



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

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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

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 6063 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 is performed in compliance with Technical Directives of European quality mark QUALANOD.

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.

PAINTING

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

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

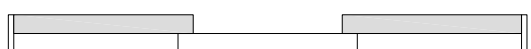
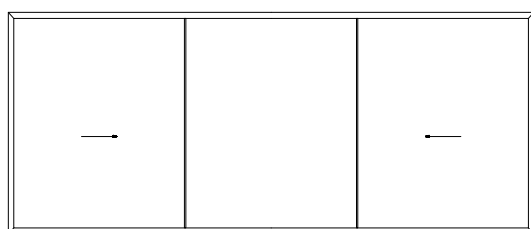
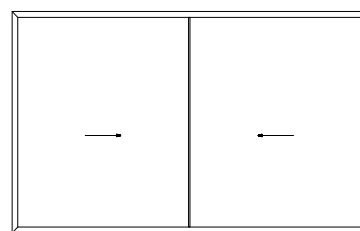
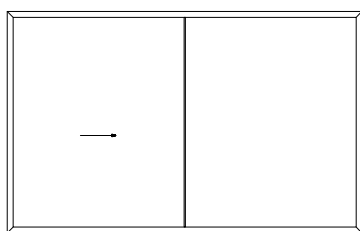
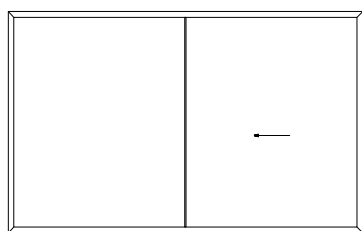
The whole sections painting cycle is carried in full compliance of quality standard QUALICOAT.

SUBLIMATION

The sublimation process allows the reproduction of the wood effect on aluminium profiles with the transfer of a special ink applying pressure and heat.

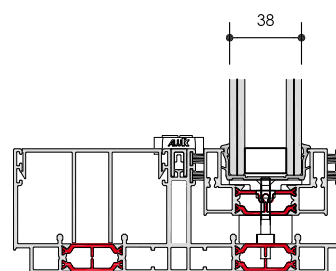
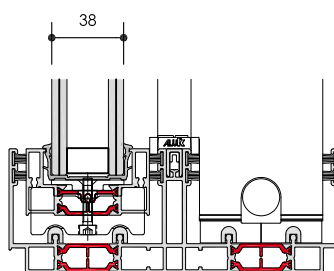
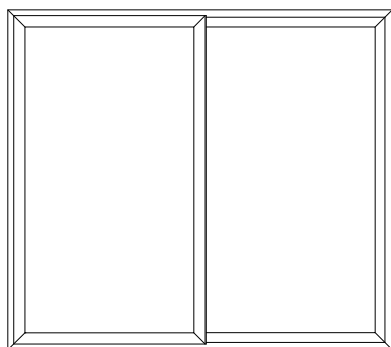
➤ CONFIGURATION

2 Track outer frame



➤ GLAZING THICKNESS RANGE

Duorail - Double glazing



Glass Range Fixed Pane = 38mm

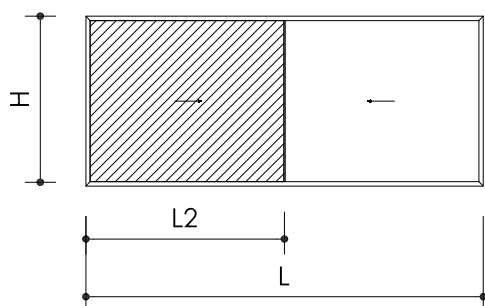
Glass Range Sliding Sash = 38mm

➤ SIZE LIMITS (2 ROLLERS)

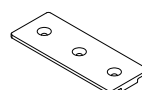
MAXIMUM SIZES

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

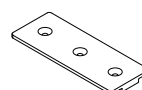
- Glass Unit: 44,2/20/44,2 (Est. 40 kg/m²) Or 55.2/18/55.2 (Est. 50 kg/m²)
- Max. panel area for 44,2/20/44,2 = (H x L2) = 7.5m²
- Max. panel area for 55.2/18/55.2 = (H x L2) = 6.0m²



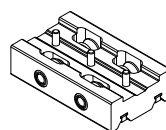
Max. Load per Panel
2 Rollers Per Sash = 300 Kg



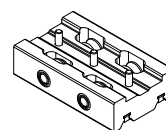
V62000



V62000



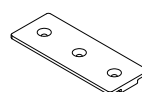
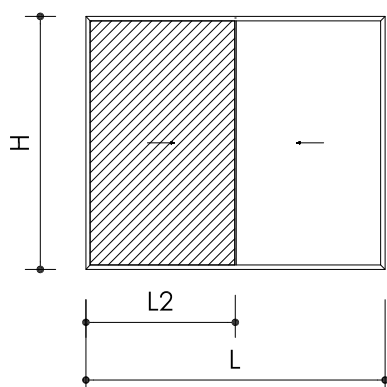
H00200



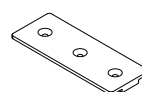
H00200

OR

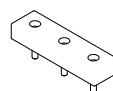
2 - 4 Fixed Blocks Per Fixed Sash = Max.
Weight < 600Kg



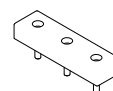
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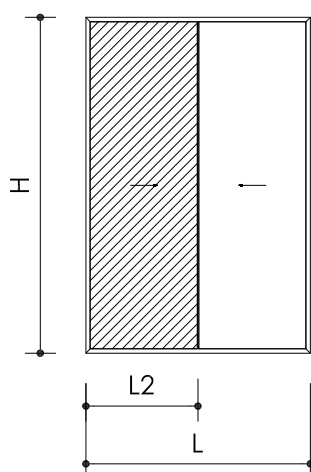
V62000



V50001



V50001



IMPORTANT:

Panel height can not exceed:

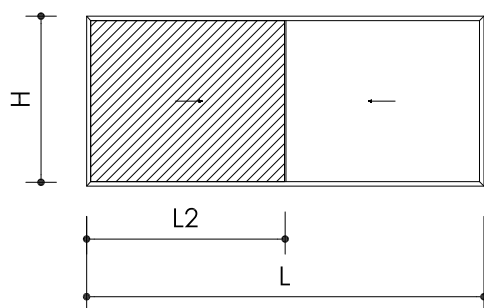
$$H/L2 < 2.5$$

➤ SIZE LIMITS (4 ROLLERS)

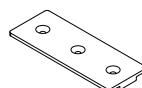
MAXIMUM SIZES

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

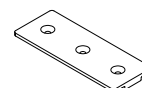
- Glass Unit: 44,2/20/44,2 (Est. 40 kg/m²) Or 55.2/18/55.2 (Est. 50 kg/m²)
- Max. panel area for 44,2/20/44,2 = (H x L2) = 10.0m² 
- Max. panel area for 55.2/18/55.2 = (H x L2) = 8.0m²



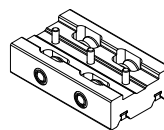
Max. Load per Panel
4 Rollers Per Sash = 400 Kg



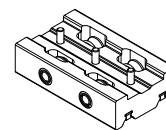
V62000



V62000



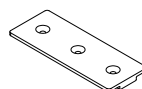
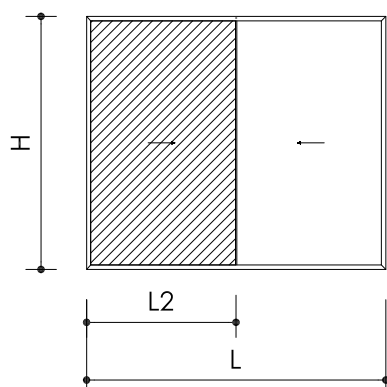
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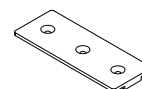
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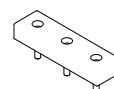
2 - 4 Fixed Blocks Per Fixed Sash = Max.
Weight < 600Kg



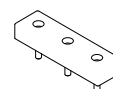
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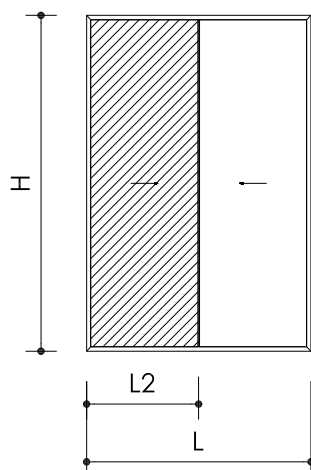
V62000



V50001



V50001



IMPORTANT:

Panel height can not exceed:

$$H/L2 < 2.5$$

➤ CLEAR OPENING SIZES

Clear opening sizes can be calculated using the following formulae:

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

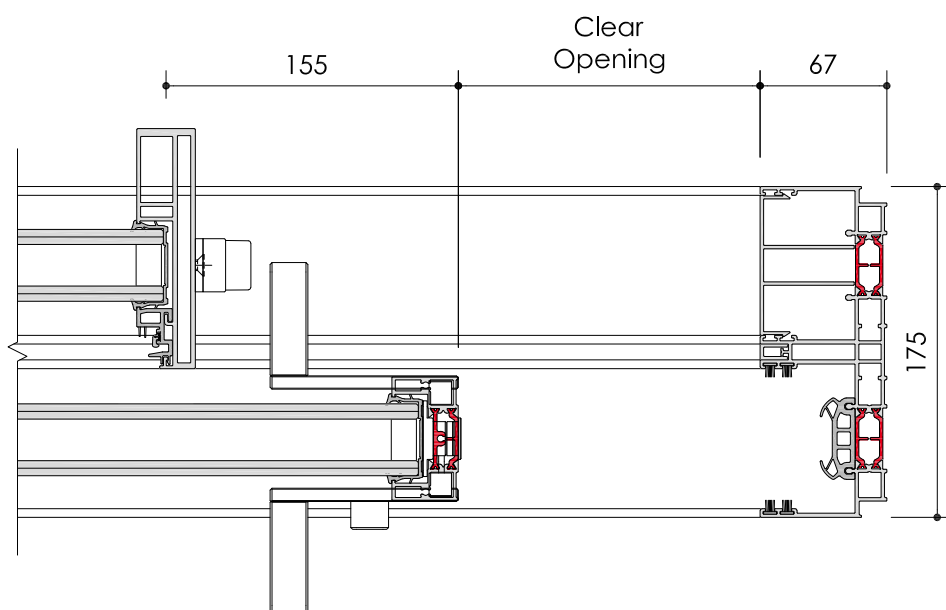
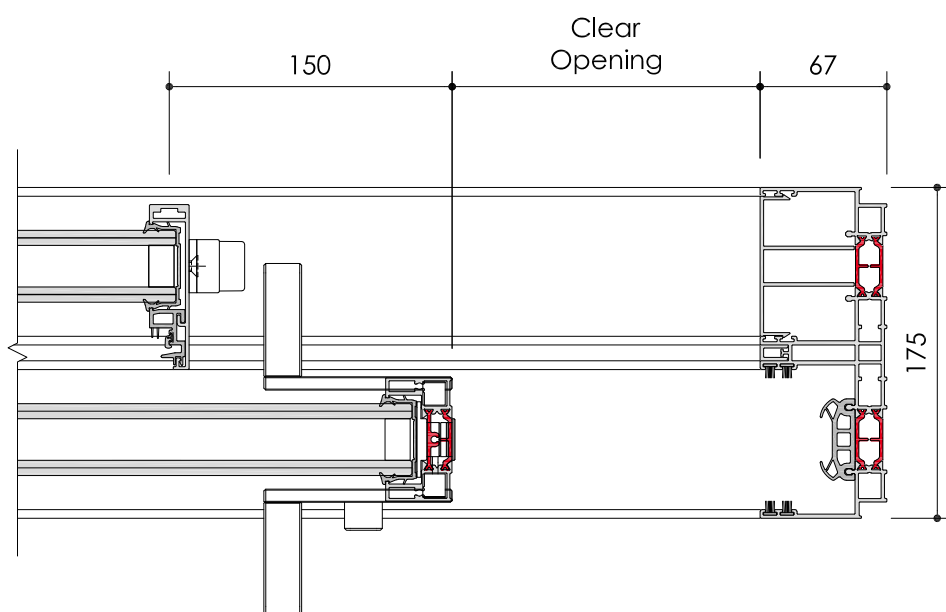
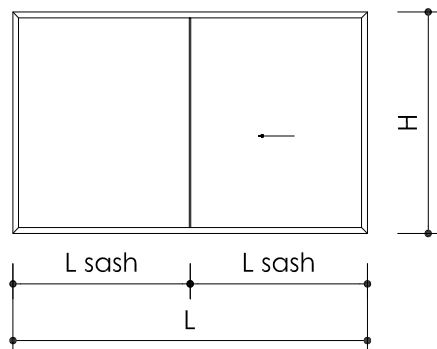
E.G.

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:

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

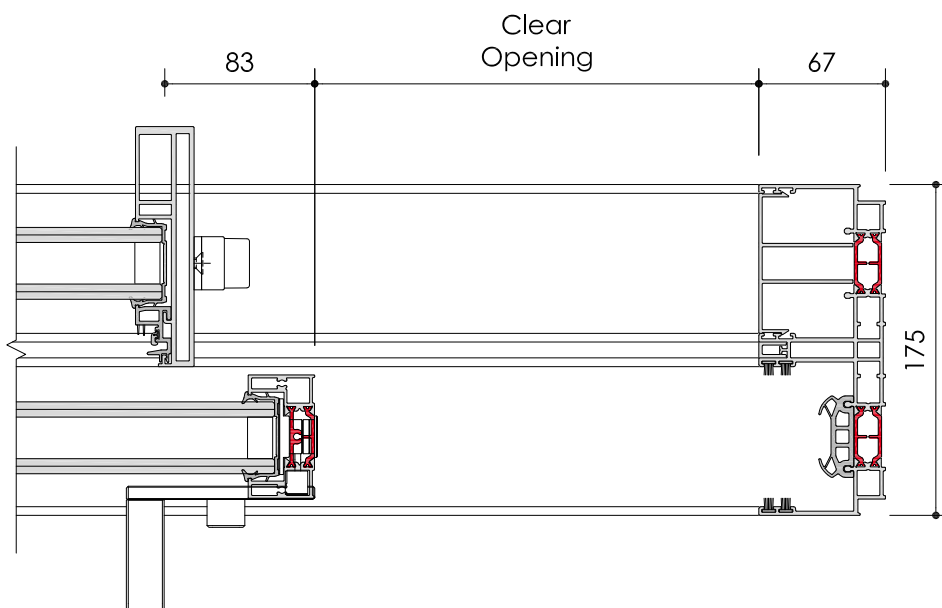
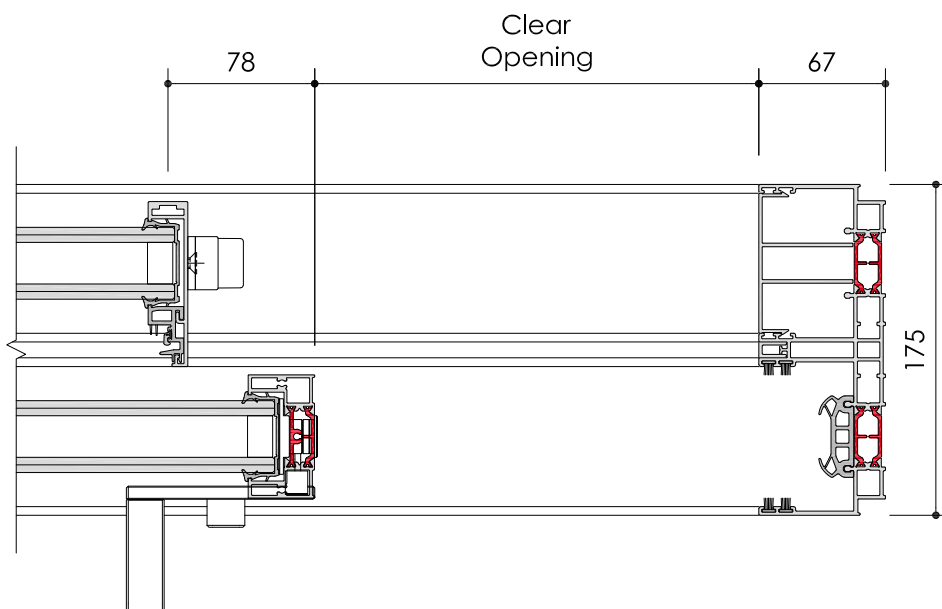
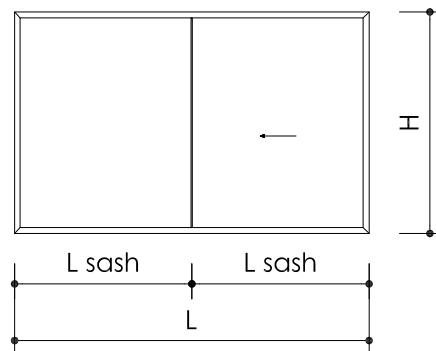
E.G.

Panel Length = 4000mm

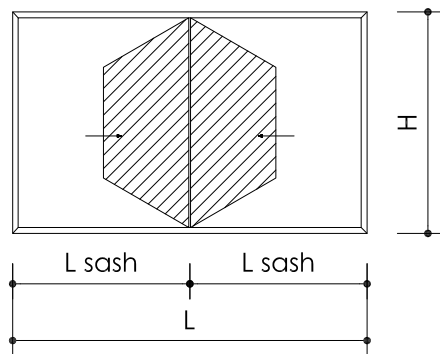
No. Of Panels = 2

Therefore:

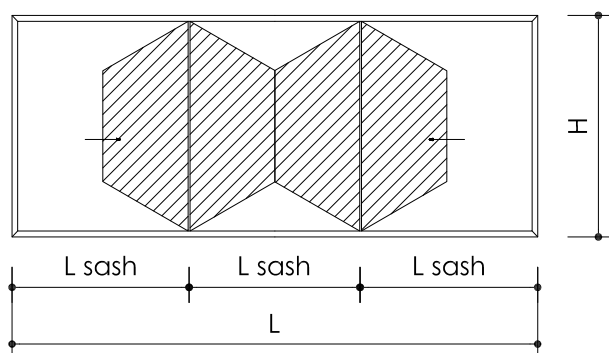
$$\begin{aligned} \text{CLEAR OPENING} &= 4000/2 - (67 + 78) \\ &= 2000 - 145 \\ &= 1855 \text{ mm} \end{aligned}$$



➤ WIND LOADING



OX & XX Configurations



XOX Configuration

The following tables contain the maximum loadings in relation to the door span for interlocking profiles. The tables are representative for uses with standard size vents and frames. 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 27.44cm⁴ N00120	 lxx 77.50cm⁴ N00121	 lxx 151.17cm⁴ N00124	 lxx 276.17cm⁴ N00124 (Steel Reinforced 5 x 100)
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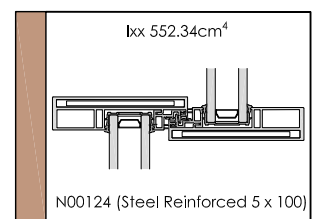
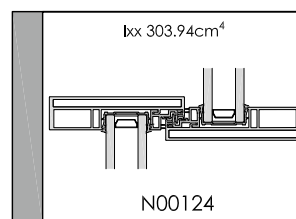
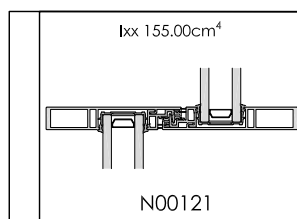
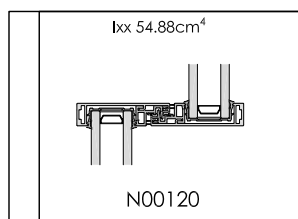
WIND LOADING CHART (400 Pa)

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	12.0	12.6	13.1	13.7	14.3	14.9	15.4	16.0	16.6	17.1	17.7	18.3	
2.10	12.5	12.9	13.3	13.5	13.7	13.9	13.9	14.6	15.2	15.9	16.5	17.2	17.9	18.5	19.2	19.8	20.5	21.2	
2.20	14.7	15.2	15.7	16.0	16.3	16.6	16.7	16.7	17.5	18.3	19.0	19.8	20.5	21.3	22.1	22.8	23.6	24.3	
2.30	17.4	18.1	18.7	19.2	19.7	20.0	20.2	20.4	20.4	21.3	22.2	23.1	24.0	24.9	25.8	26.7	27.5	28.4	
2.40	21.0	21.9	22.6	23.3	23.9	24.4	24.8	25.1	25.2	25.3	26.3	27.4	28.4	29.5	30.5	31.6	32.7	33.7	
2.50	25.0	26.1	27.1	28.0	28.8	29.5	30.0	30.4	30.8	30.9	31.0	32.2	33.5	34.7	36.0	37.2	38.4	39.7	
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	39.2	40.6	42.1	43.5	45.0	46.4	
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	47.2	48.9	50.6	52.3	54.0	
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	56.6	58.5	60.5	62.4	
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	67.4	69.6	71.9	
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	79.7	82.3	
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	93.8	
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	16.0	16.8	17.5	18.3	19.0	19.8	20.6	21.3	22.1	22.9	23.6	24.4		
2.10	16.7	17.2	17.7	18.1	18.3	18.5	18.5	19.4	20.3	21.2	22.1	22.9	23.8	24.7	25.6	26.5	27.3	28.2		
2.20	19.6	20.3	20.9	21.4	21.8	22.1	22.3	22.3	23.3	24.3	25.4	26.4	27.4	28.4	29.4	30.4	31.4	32.5		
2.30	22.7	23.6	24.4	25.1	25.7	26.1	26.4	26.6	26.7	27.8	29.0	30.1	31.3	32.4	33.6	34.8	35.9	37.1		
2.40	26.2	27.3	28.3	29.2	29.9	30.5	31.0	31.3	31.5	31.6	32.9	34.2	35.5	36.9	38.2	39.5	40.8	42.1		
2.50	30.0	31.4	32.6	33.6	34.6	35.4	36.0	36.5	36.9	37.1	37.2	38.7	40.2	41.7	43.2	44.6	46.1	47.6		
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	45.2	46.9	48.5	50.2	51.9	53.6		
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	52.5	54.4	56.2	58.1	60.0		
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	60.6	62.7	64.8	66.9		
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	69.7	72.0	74.3		
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	79.7	82.3		
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	93.8		
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	24.0	25.1	26.3	27.4	28.6	29.7	30.9	32.0	33.1	34.3	35.4	36.6	
2.10	25.0	25.8	26.5	27.1	27.5	27.7	27.8	29.1	30.4	31.8	33.1	34.4	35.7	37.0	38.4	39.7	41.0	42.3	
2.20	29.3	30.4	31.3	32.1	32.7	33.1	33.4	33.5	35.0	36.5	38.0	39.5	41.1	42.6	44.1	45.6	47.2	48.7	
2.30	34.1	35.4	36.6	37.6	38.5	39.1	39.6	39.9	40.0	41.7	43.5	45.2	46.9	48.7	50.4	52.1	53.9	55.6	
2.40	39.3	41.0	42.5	43.7	44.9	45.8	46.5	47.0	47.3	47.4	49.4	51.3	53.3	55.3	57.3	59.2	61.2	63.2	
2.50	45.1	47.0	48.8	50.4	51.8	53.0	54.0	54.8	55.4	55.7	55.8	58.0	60.3	62.5	64.7	67.0	69.2	71.4	
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	67.8	70.3	72.8	75.3	77.8	80.3	
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	78.7	81.5	84.4	87.2	90.0	
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	90.9	94.1	97.2	100.4	
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	104.5	108.0	111.5	
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	119.6	123.4	
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	136.2	
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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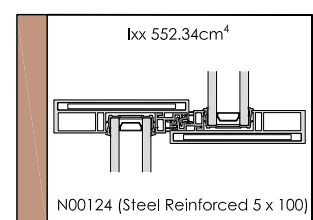
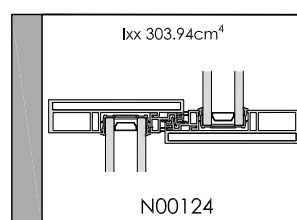
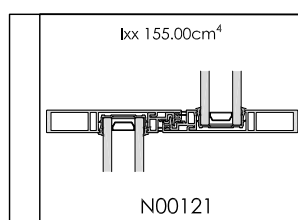
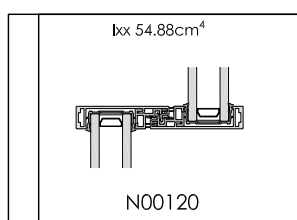
WIND LOADING CHART (800 Pa)

Deflection H/150		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	24.0	25.1	26.3	27.4	28.6	29.7	30.9	32.0	33.1	34.3	35.4	36.6
2.10		25.0	25.8	26.5	27.1	27.5	27.7	27.8	29.1	30.4	31.8	33.1	34.4	35.7	37.0	38.4	39.7	41.0	42.3
2.20		29.3	30.4	31.3	32.1	32.7	33.1	33.4	33.5	35.0	36.5	38.0	39.5	41.1	42.6	44.1	45.6	47.2	48.7
2.30		34.9	36.2	37.4	38.5	39.3	40.0	40.5	40.8	40.9	42.6	44.4	46.2	48.0	49.7	51.5	53.3	55.1	56.9
2.40		42.0	43.7	45.3	46.7	47.8	48.8	49.6	50.1	50.4	50.6	52.7	54.8	56.9	59.0	61.1	63.2	65.3	67.4
2.50		50.1	52.3	54.3	56.0	57.6	58.9	60.0	60.9	61.5	61.9	62.0	64.5	67.0	69.4	71.9	74.4	76.9	79.4
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	78.3	81.2	84.1	87.0	89.9	92.8
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	94.5	97.9	101.2	104.6	108.0
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	113.2	117.1	121.0	124.9
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	134.7	139.2	143.7
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	159.4	164.6
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	187.6
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		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		28.1	29.0	29.6	30.1	30.4	30.5	32.0	33.5	35.0	36.6	38.1	39.6	41.1	42.7	44.2	45.7	47.2	48.8
2.10		33.3	34.5	35.4	36.1	36.6	36.9	37.0	38.8	40.6	42.3	44.1	45.9	47.6	49.4	51.2	52.9	54.7	56.4
2.20		39.1	40.5	41.8	42.8	43.6	44.2	44.5	44.6	46.6	48.7	50.7	52.7	54.8	56.8	58.8	60.8	62.9	64.9
2.30		45.5	47.3	48.8	50.2	51.3	52.2	52.8	53.2	53.3	55.6	57.9	60.3	62.6	64.9	67.2	69.5	71.8	74.2
2.40		52.4	54.6	56.6	58.3	59.8	61.0	62.0	62.6	63.1	63.2	65.8	68.5	71.1	73.7	76.4	79.0	81.6	84.3
2.50		60.1	62.7	65.1	67.2	69.1	70.7	72.0	73.1	73.8	74.3	74.4	77.4	80.4	83.3	86.3	89.3	92.3	95.2
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	90.4	93.7	97.1	100.4	103.8	107.1
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	105.0	108.7	112.5	116.2	120.0
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	121.3	125.4	129.6	133.8
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	139.4	144.0	148.7
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	159.4	164.6
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	187.6
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		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	48.0	50.3	52.6	54.9	57.1	59.4	61.7	64.0	66.3	68.6	70.9	73.1
2.10		50.0	51.7	53.1	54.2	54.9	55.4	55.6	58.2	60.9	63.5	66.2	68.8	71.4	74.1	76.7	79.4	82.0	84.7
2.20		58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	70.0	73.0	76.1	79.1	82.1	85.2	88.2	91.3	94.3	97.4
2.30		68.2	70.9	73.3	75.3	77.0	78.3	79.2	79.8	80.0	83.4	86.9	90.4	93.9	97.3	100.8	104.3	107.8	111.2
2.40		78.7	82.0	84.9	87.5	89.7	91.5	92.9	94.0	94.6	94.8	98.7	102.7	106.6	110.6	114.5	118.5	122.4	126.4
2.50		90.1	94.1	97.7	100.9	103.7	106.1	108.1	109.6	110.7	111.4	111.6	116.1	120.5	125.0	129.5	133.9	138.4	142.9
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	135.6	140.6	145.6	150.7	155.7	160.7
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	157.5	163.1	168.7	174.3	180.0
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	181.9	188.2	194.4	200.7
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	209.0	216.0	223.0
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	239.1	246.9
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	272.4
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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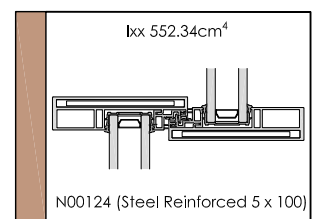
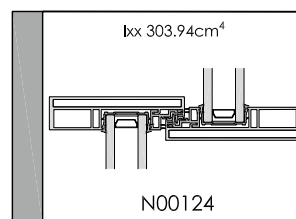
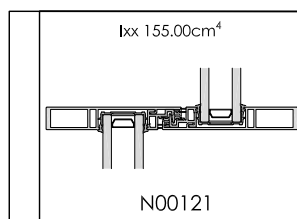
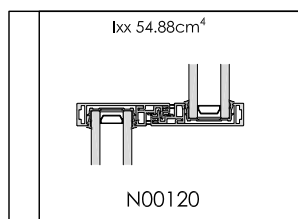
WIND LOADING CHART (1200 Pa)

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	36.0	37.7	39.4	41.1	42.9	44.6	46.3	48.0	49.7	51.4	53.1	54.9	
2.10	37.5	38.8	39.8	40.6	41.2	41.6	41.7	43.7	45.6	47.6	49.6	51.6	53.6	55.6	57.6	59.5	61.5	63.5	
2.20	44.0	45.6	47.0	48.1	49.0	49.7	50.1	50.2	52.5	54.8	57.0	59.3	61.6	63.9	66.2	68.5	70.7	73.0	
2.30	52.3	54.4	56.2	57.7	59.0	60.0	60.7	61.2	61.3	64.0	66.6	69.3	72.0	74.6	77.3	80.0	82.6	85.3	
2.40	62.9	65.6	67.9	70.0	71.8	73.2	74.4	75.2	75.7	75.8	79.0	82.2	85.3	88.5	91.6	94.8	98.0	101.1	
2.50	75.1	78.4	81.4	84.1	86.4	88.4	90.0	91.3	92.3	92.8	93.0	96.7	100.4	104.2	107.9	111.6	115.3	119.0	
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	117.5	121.9	126.2	130.6	134.9	139.3	
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	141.7	146.8	151.8	156.9	162.0	
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	169.8	175.6	181.5	187.3	
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	202.1	208.8	215.6	
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	239.1	246.9	
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	281.5	
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	48.0	50.3	52.6	54.9	57.1	59.4	61.7	64.0	66.3	68.6	70.9	73.1	
2.10	50.0	51.7	53.1	54.2	54.9	55.4	55.6	58.2	60.9	63.5	66.2	68.8	71.4	74.1	76.7	79.4	82.0	84.7	
2.20	58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	70.0	73.0	76.1	79.1	82.1	85.2	88.2	91.3	94.3	97.4	
2.30	68.2	70.9	73.3	75.3	77.0	78.3	79.2	79.8	80.0	83.4	86.9	90.4	93.9	97.3	100.8	104.3	107.8	111.2	
2.40	78.7	82.0	84.9	87.5	89.7	91.5	92.9	94.0	94.6	94.8	98.7	102.7	106.6	110.6	114.5	118.5	122.4	126.4	
2.50	90.1	94.1	97.7	100.9	103.7	106.1	108.1	109.6	110.7	111.4	111.6	116.1	120.5	125.0	129.5	133.9	138.4	142.9	
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	135.6	140.6	145.6	150.7	155.7	160.7	
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	157.5	163.1	168.7	174.3	180.0	
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	181.9	188.2	194.4	200.7	
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	209.0	216.0	223.0	
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	239.1	246.9	
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	281.5	
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	72.0	75.4	78.9	82.3	85.7	89.1	92.6	96.0	99.4	102.9	106.3	109.7	
2.10	75.0	77.5	79.6	81.2	82.4	83.1	83.3	87.3	91.3	95.3	99.2	103.2	107.2	111.1	115.1	119.1	123.0	127.0	
2.20	88.0	91.2	94.0	96.3	98.1	99.4	100.1	100.4	105.0	109.5	114.1	118.6	123.2	127.8	132.3	136.9	141.5	146.0	
2.30	102.3	106.3	109.9	112.9	115.4	117.4	118.8	119.6	119.9	125.1	130.4	135.6	140.8	146.0	151.2	156.4	161.6	166.9	
2.40	118.0	123.0	127.4	131.2	134.6	137.3	139.4	141.0	141.9	142.2	148.1	154.0	160.0	165.9	171.8	177.7	183.7	189.6	
2.50	135.2	141.1	146.5	151.3	155.5	159.1	162.1	164.4	166.1	167.1	167.4	174.1	180.8	187.5	194.2	200.9	207.6	214.3	
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	203.4	210.9	218.4	226.0	233.5	241.0	
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	236.2	244.6	253.1	261.5	269.9	
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	272.8	282.2	291.6	301.1	
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	313.6	324.0	334.5	
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	358.7	370.3	
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	408.6	
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



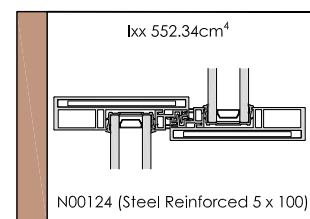
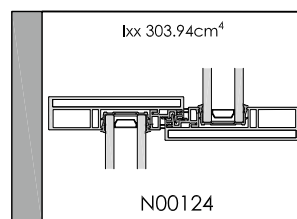
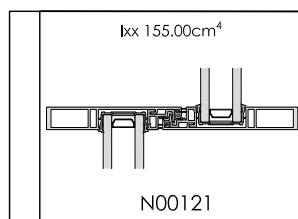
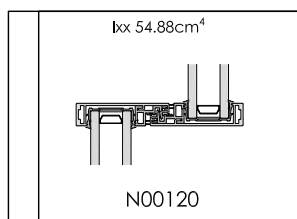
WIND LOADING CHART (1600 Pa)

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	48.0	50.3	52.6	54.9	57.1	59.4	61.7	64.0	66.3	68.6	70.9	73.1	
2.10	50.0	51.7	53.1	54.2	54.9	55.4	55.6	58.2	60.9	63.5	66.2	68.8	71.4	74.1	76.7	79.4	82.0	84.7	
2.20	58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	70.0	73.0	76.1	79.1	82.1	85.2	88.2	91.3	94.3	97.4	
2.30	69.7	72.5	74.9	77.0	78.7	80.0	81.0	81.5	81.7	85.3	88.8	92.4	95.9	99.5	103.1	106.6	110.2	113.7	
2.40	83.9	87.4	90.6	93.3	95.7	97.6	99.1	100.2	100.9	101.1	105.3	109.5	113.8	118.0	122.2	126.4	130.6	134.8	
2.50	100.1	104.5	108.5	112.1	115.2	117.9	120.1	121.8	123.0	123.8	124.0	129.0	133.9	138.9	143.8	148.8	153.8	158.7	
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	156.7	162.5	168.3	174.1	179.9	185.7	
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	189.0	195.7	202.5	209.2	216.0	
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	226.3	234.2	242.0	249.8	
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	269.4	278.4	287.4	
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	318.9	329.1	
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	375.3	
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	64.0	67.0	70.1	73.1	76.2	79.2	82.3	85.3	88.4	91.4	94.5	97.5	
2.10	66.7	68.9	70.8	72.2	73.2	73.9	74.1	77.6	81.1	84.7	88.2	91.7	95.3	98.8	102.3	105.8	109.4	112.9	
2.20	78.2	81.1	83.5	85.6	87.2	88.3	89.0	89.2	93.3	97.4	101.4	105.5	109.5	113.6	117.6	121.7	125.7	129.8	
2.30	90.9	94.5	97.7	100.4	102.6	104.3	105.6	106.4	106.6	111.2	115.9	120.5	125.1	129.8	134.4	139.1	143.7	148.3	
2.40	104.9	109.3	113.2	116.7	119.6	122.0	123.9	125.3	126.1	126.4	131.7	136.9	142.2	147.5	152.7	158.0	163.3	168.5	
2.50	120.1	125.4	130.2	134.5	138.2	141.4	144.1	146.1	147.6	148.5	148.8	154.8	160.7	166.7	172.6	178.6	184.5	190.5	
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	180.8	187.5	194.2	200.9	207.6	214.3	
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	210.0	217.5	224.9	232.4	239.9	
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	242.5	250.9	259.2	267.6	
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	278.7	288.0	297.3	
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	318.9	329.1	
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	375.3	
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	96.0	100.6	105.1	109.7	114.3	118.9	123.4	128.0	132.6	137.1	141.7	146.3	
2.10	100.0	103.4	106.1	108.3	109.9	110.8	111.1	116.4	121.7	127.0	132.3	137.6	142.9	148.2	153.5	158.8	164.1	169.3	
2.20	117.3	121.6	125.3	128.4	130.8	132.5	133.5	133.9	139.9	146.0	152.1	158.2	164.3	170.4	176.5	182.5	188.6	194.7	
2.30	136.4	141.8	146.5	150.6	153.9	156.5	158.4	159.5	159.9	166.9	173.8	180.8	187.7	194.7	201.6	208.6	215.5	222.5	
2.40	157.3	163.9	169.8	175.0	179.4	183.0	185.9	187.9	189.2	189.6	197.5	205.4	213.3	221.2	229.1	237.0	244.9	252.8	
2.50	180.2	188.1	195.3	201.7	207.4	212.2	216.1	219.2	221.4	222.8	223.2	232.1	241.1	250.0	258.9	267.9	276.8	285.7	
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	271.2	281.2	291.3	301.3	311.3	321.4	
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	314.9	326.2	337.4	348.7	359.9	
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	363.8	376.3	388.9	401.4	
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	418.1	432.0	446.0	
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	478.3	493.7	
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	544.7	
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



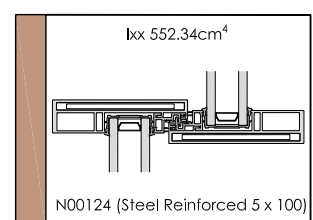
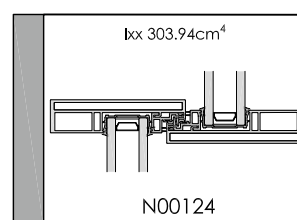
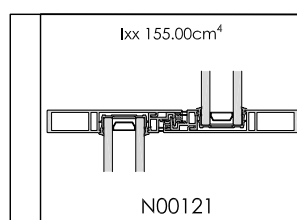
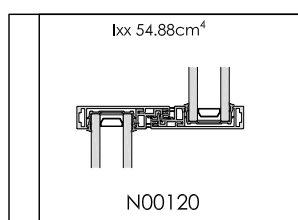
WIND LOADING CHART (2000 Pa)

Deflection H/150		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	52.7	54.3	55.5	56.4	57.0	57.1	60.0	62.9	65.7	68.6	71.4	74.3	77.1	80.0	82.9	85.7	88.6	91.4	
2.10	62.5	64.6	66.3	67.7	68.7	69.3	69.5	72.8	76.1	79.4	82.7	86.0	89.3	92.6	95.9	99.2	102.5	105.8	
2.20	73.3	76.0	78.3	80.2	81.7	82.8	83.4	83.7	87.5	91.3	95.1	98.9	102.7	106.5	110.3	114.1	117.9	121.7	
2.30	87.1	90.6	93.6	96.2	98.3	100.0	101.2	101.9	102.2	106.6	111.0	115.5	119.9	124.4	128.8	133.3	137.7	142.1	
2.40	104.9	109.3	113.2	116.7	119.6	122.0	123.9	125.3	126.1	126.4	131.7	136.9	142.2	147.5	152.7	158.0	163.3	168.5	
2.50	125.1	130.7	135.6	140.1	144.0	147.3	150.1	152.2	153.8	154.7	155.0	161.2	167.4	173.6	179.8	186.0	192.2	198.4	
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	195.8	203.1	210.4	217.6	224.9	232.1	
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	236.2	244.6	253.1	261.5	269.9	
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	282.9	292.7	302.4	312.2	
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	336.8	348.0	359.3	
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	398.6	411.4	
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	469.1	
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	

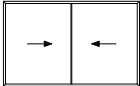
Deflection H/200		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	70.3	72.4	74.1	75.2	76.0	76.2	80.0	83.8	87.6	91.4	95.2	99.0	102.9	106.7	110.5	114.3	118.1	121.9	
2.10	83.3	86.1	88.4	90.3	91.6	92.3	92.6	97.0	101.4	105.8	110.3	114.7	119.1	123.5	127.9	132.3	136.7	141.1	
2.20	97.8	101.4	104.4	107.0	109.0	110.4	111.3	111.6	116.6	121.7	126.8	131.8	136.9	142.0	147.0	152.1	157.2	162.3	
2.30	113.7	118.2	122.1	125.5	128.3	130.4	132.0	132.9	133.3	139.1	144.8	150.6	156.4	162.2	168.0	173.8	179.6	185.4	
2.40	131.1	136.6	141.5	145.8	149.5	152.5	154.9	156.6	157.6	158.0	164.6	171.2	177.7	184.3	190.9	197.5	204.1	210.7	
2.50	150.2	156.8	162.8	168.1	172.8	176.8	180.1	182.7	184.5	185.6	186.0	193.5	200.9	208.3	215.8	223.2	230.7	238.1	
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	226.0	234.3	242.7	251.1	259.5	267.8	
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	262.4	271.8	281.2	290.6	299.9	
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	303.1	313.6	324.1	334.5	
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	348.4	360.0	371.6	
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	398.6	411.4	
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	469.1	
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	

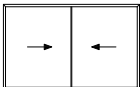
Deflection H/300		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	105.5	108.6	111.1	112.9	113.9	114.3	120.0	125.7	131.4	137.1	142.9	148.6	154.3	160.0	165.7	171.4	177.1	182.9	
2.10	125.0	129.2	132.7	135.4	137.3	138.5	138.9	145.5	152.1	158.8	165.4	172.0	178.6	185.2	191.8	198.5	205.1	211.7	
2.20	146.7	152.0	156.7	160.5	163.5	165.6	166.9	167.3	174.9	182.5	190.1	197.7	205.4	213.0	220.6	228.2	235.8	243.4	
2.30	170.5	177.2	183.2	188.2	192.4	195.7	198.0	199.4	199.9	208.6	217.3	226.0	234.6	243.3	252.0	260.7	269.4	278.1	
2.40	196.7	204.9	212.3	218.7	224.3	228.8	232.4	234.9	236.5	237.0	246.9	256.7	266.6	276.5	286.4	296.2	306.1	316.0	
2.50	225.3	235.2	244.2	252.2	259.2	265.2	270.1	274.0	276.8	278.5	279.0	290.2	301.3	312.5	323.7	334.8	346.0	357.1	
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	339.0	351.5	364.1	376.6	389.2	401.7	
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	393.7	407.7	421.8	435.8	449.9	
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	454.7	470.4	486.1	501.8	
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	522.6	540.0	557.5	
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	597.9	617.1	
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	680.9	
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	

KEY



➤ 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 N.
 L4120 H2640 mm	4	8A (450Pa)	C3 (1200Pa)	1	BSI 8635380 28.11.2016

OPERATION AND STRENGTH CHARACTERISTICS					
MOCK UP	RESISTANCE TO REPEATED OPENING & CLOSING EN 1191 EN12400	VERTICAL LOAD EN 947 EN 1192	STATIC TORSION EN 948 EN 1192	SOFT & HEAVY IMPACT EN 949 EN 1192	LAB & TEST REPORT N.
 L2346 H2546 mm	3 (20000 cycles)	-	-	-	BSI Pending —,—.2017

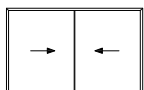
This is only a summary of test reports for information purposes only.
For complete information, please refer to the full test report which is available upon request.

➤ TEST PERFORMANCE

THERMAL TRANSMITTANCE

TIPOLOGY	THERMAL TRANSMITTANCE Uf	LAB & TEST REPORT N.
Sliding door	EN ISO 10077-2	IRcCOS 1994-CPR-1460 23.01.2017
Sliding door	EN ISO 10077-2	IRcCOS 1994-CPR-1475 13.02.2017

THERMAL TRANSMITTANCE (U_w)

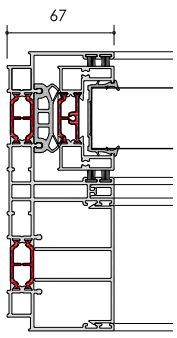
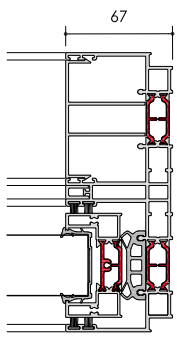
 L4000 H2500 mm	DOUBLE GLAZING $\psi = 0.06 \text{ W/mK}$ $U_g = 1.0 \text{ W/m}^2\text{K}$	$U_w = 1.3 \text{ W/m}^2\text{K}$
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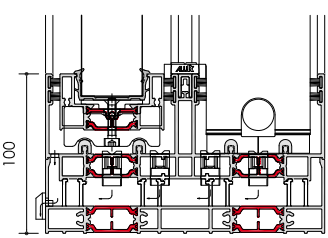
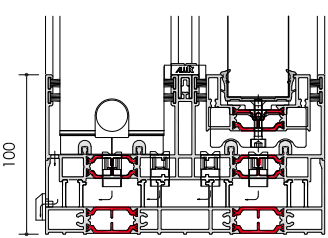
This is only a summary of test reports for information purposes only.
For complete information, please refer to the full test report which is available upon request.

➤ THERMAL TRANSMITTANCE (U_f)

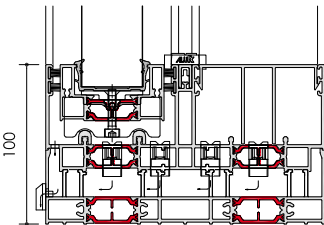
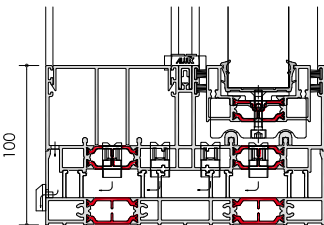
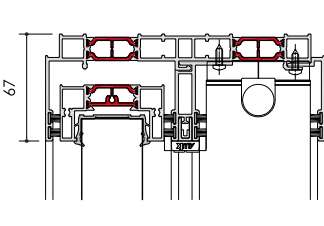
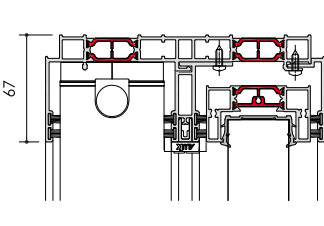
Thermal transmittance (U_f) of the nodes calculated according to EN ISO 10077-2.

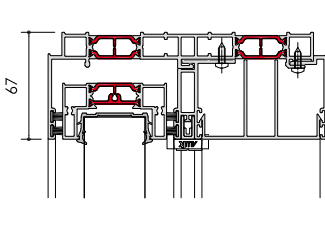
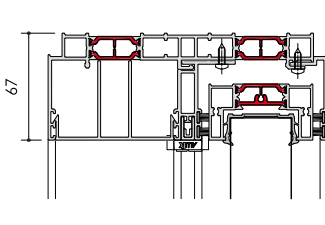
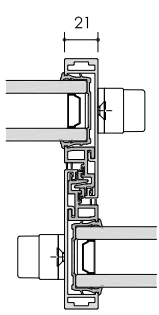
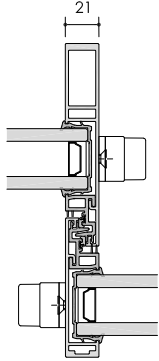
Profile Materials	Conductivity λ W/(m.K)	Emissivity ε
Aluminum alloy oxidized / painted	160	0.9
Aluminum alloy mill finish	160	0.3
Polyamide	0.3	-
EPDM	0.25	-
Mohair sweep	0.14	-
PVC Flexible	0.14	-
PVC Rigid	0.17	-
Polyurethane solid	0.21	-
Polyurethane foam	0.05	-

	U_f [W/(m².K)]	
	$\varepsilon = 0.3$	$\varepsilon = 0.9$
	2.7	2.7
U00020 U00100 N00651		
	2.5	2.6
U00020 U00100 N00651		

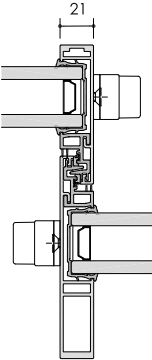
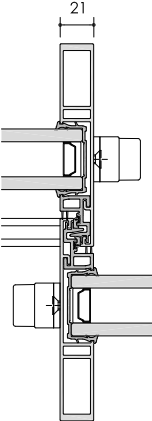
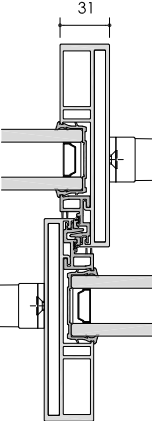
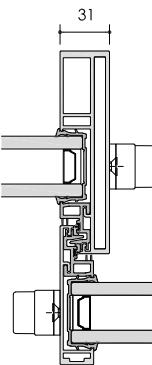
	U_f [W/(m².K)]	
	$\varepsilon = 0.3$	$\varepsilon = 0.9$
	2.9	3.0
U00020 U00100 U00630		
	2.9	3.0
U00020 U00100 U00630		

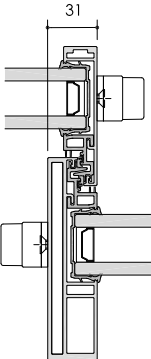
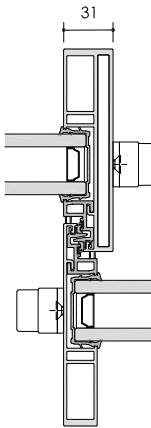
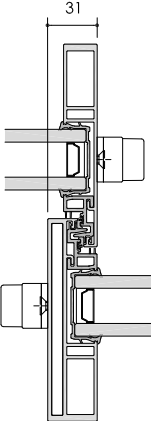
► THERMAL TRANSMITTANCE (U_f)

	U_f [W/(m ² .K)]	
	$\varepsilon = 0.3$	$\varepsilon = 0.9$
	3.1	3.2
	U00020 U00100 U00630 N00651	
	2.8	2.9
	U00020 U00100 U00630 N00651	
	2.9	2.9
	U00021 U00100 N00652 N00653	
	2.9	2.9
	U00021 U00100 N00652 N00653	

	U_f [W/(m ² .K)]	
	$\varepsilon = 0.3$	$\varepsilon = 0.9$
	3.1	3.1
	U00021 U00100 N00651 N00652 N00653	
	2.9	2.9
	U00021 U00100 N00651 N00652 N00653	
	-	11.6
	N00120 N00120	
	-	11.7
	N00120 N00121	

➤ THERMAL TRANSMITTANCE (U_f)

	U_f [W/(m².K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	-	12.6
	N00120 N00121	
	-	12.8
	N00121 N00121	
	-	9.5
	N00124 N00124	
	-	8.4
	N00120 N00124	

	U_f [W/(m².K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	-	9.2
	N00124 N00120	
	-	9.1
	N00121 N00124	
	-	9.3
	N00124 N00121	

» WARRANTIES & LEGAL RESTRICTION

WARRANTIES

AluK S.A. (hereinafter "AluK") warrants that its systems meet the required technical characteristics.

Additional warranties may apply under certain conditions.

LEGAL RESTRICTION

All drawings and information in this technical manual are indicative and cannot engage our responsibility.

The AluK policy of continuous improvement determines the right to make the modifications without prior warning.

AluK cannot be held responsible for possible misprints or other technical errors in this manual. This technical manual cannot lead to any legal action whatsoever.

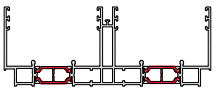
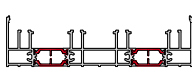
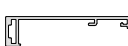
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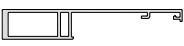
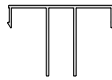


SECTION 2 PROFILE INDEX

PROFILE

	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	U00020	2 Track Outer Frame (Cill & Jamb)	6.8	361.61	47.37	5.01
	U00021	2 Track Outer Frame (Head)	6.8	251.18	17.11	5.02
	U00100	Double Glazed Sash	6.8	25.10	4.57	5.03
	U00630	2 Track Sub Cill	6.8	388.28	15.31	5.04
	N00120	21mm Interlock Profile	6.8	27.44	1.22	5.05

► PROFILE

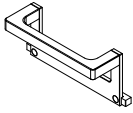
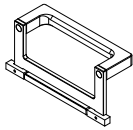
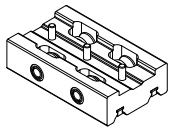
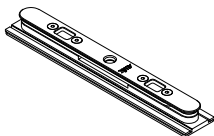
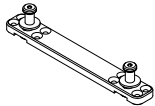
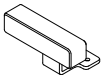
	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	N00121	21mm Reinforced Interlock Profile	6.8	77.50	3.13	5.05
	N00124	31mm Reinforced Interlock Profile	6.8	151.17	8.01	5.05
	N00632 ANOD.	Aluminium Track (Ø10mm)	6.0	-	-	5.07
	N00651	Outer Frame Cover Profile	6.8	-	-	5.06
	N00652	Internal Rebate (Outer Frame Head)	6.8	-	-	5.07

PROFILE

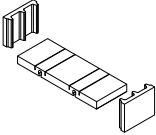
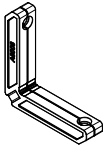
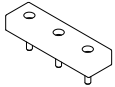
	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	N00653	Central Rebate (Outer Frame Head)	6.8	-	-	5.07
	N00654* * Only for Aluk.FRA P8005	Connector Clip	6.5	-	-	5.07

SECTION 3
ACCESSORY INDEX

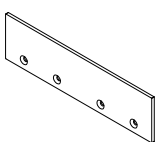
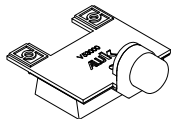
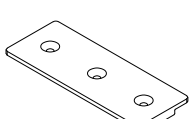
HARDWARE & ACCESSORY

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

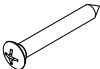
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V20000	Interlock Foam Plug	Grey	2
	V42000 * * Only for Aluk.FRA 27500	Mechanical cleat (13mm)	-	8
	V50001	Fixed sash support blocks (Including 6off M5 x 22 Cap Head Screws)	Black	2
	V51001 * * Only for Aluk.ITA 709616	Ø10.5mm Hole Plug	Black	100
	V51002 * * Only for Aluk.ITA 709617	Ø10.5mm Hole Plug	White	100
	V51003 * * Only for Aluk.ITA 712007	Water Drain Cap With Valve	Black	20

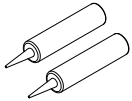
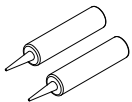
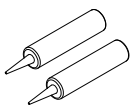
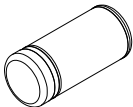
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V51004 * * Only for Aluk.ITA 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
	V58000	Interlock end cap	Black	2
	V62000	Roller glazing packer	-	1

➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V70000 * Only for Aluk.FRA 86720	Mechanical cleat screw	-	50
	V70001	Ø4.2 x 30mm pozi CSK polyamide screw	-	1000
	V70002 * * Only for Aluk.GBR XS006	Ø4.2 x 16mm pozi CSK s/tap ss screw	-	100
	V70004	Ø3.5 x 13mm pozi pan s/tap ss screw	-	100
	V70005	Ø4.2 x 13mm pozi pan self drill screw	-	100

➤ HARDWARE & ACCESSORY

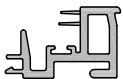
IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	T50000	Small Joint Sealant, 290ml (Black) (1 Box)	Black	12
	T50001	Small Joint Sealant, 290ml (White) (1 Box)	White	12
	T50002	Small Joint Sealant, 290ml (RAL 7016) (1 Box)	Grey	12
	T50003	Aluk Sealant Wipes (1 Box)	-	6



SECTION 4 GASKET & PLASTIC PROFILE



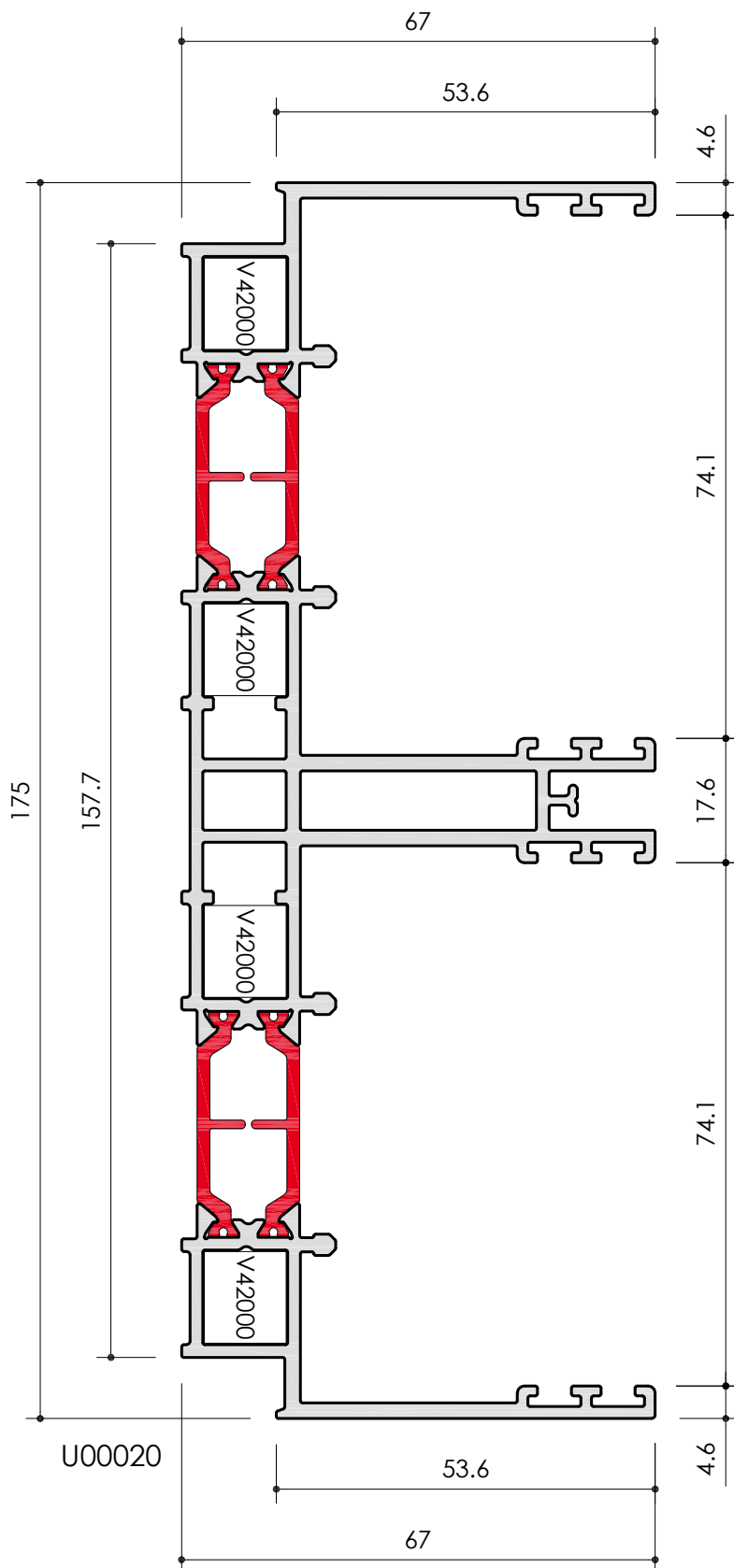
GASKET & PLASTIC PROFILE

SECTION	CODE	DESCRIPTION	MATERIAL	L [m]
	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
	V10000 * * Only for Aluk.GBR XA621	Sliding Seal / Fin pile 6.9mm x 6mm [Black] 6.9mm x 6mm	Woolpile	350

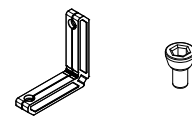


SECTION 5 PROFILE SECTION

PROFILE SECTION



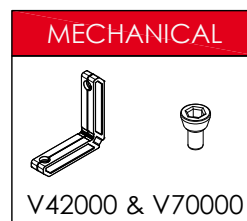
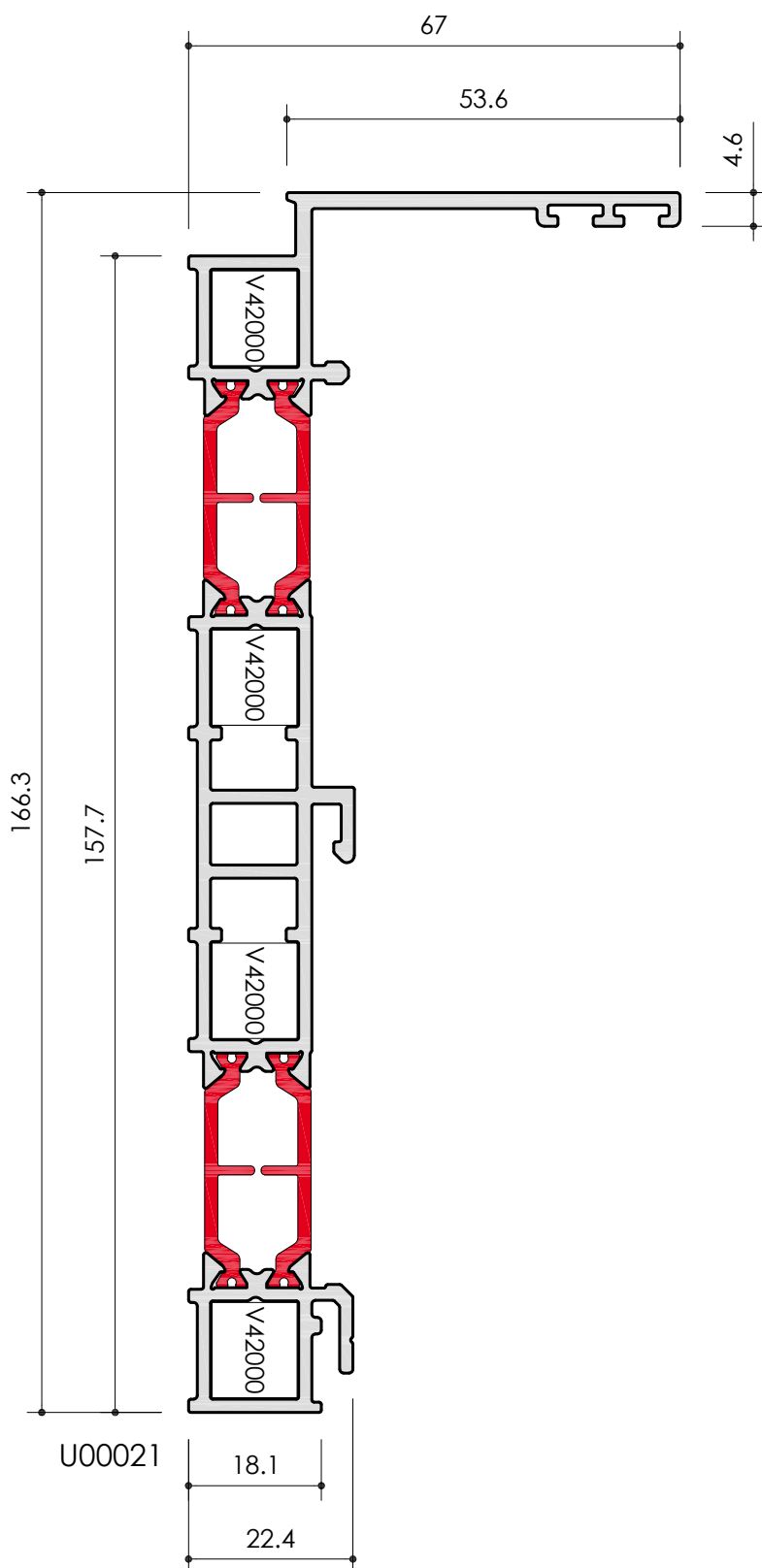
MECHANICAL



V42000 & V70000

Scale 1 : 1

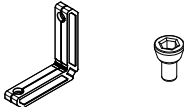
➤ PROFILE SECTION



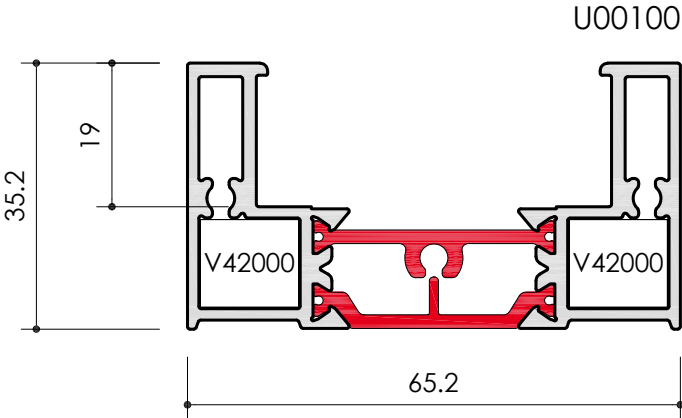
Scale 1 : 1

➤ PROFILE SECTION

MECHANICAL

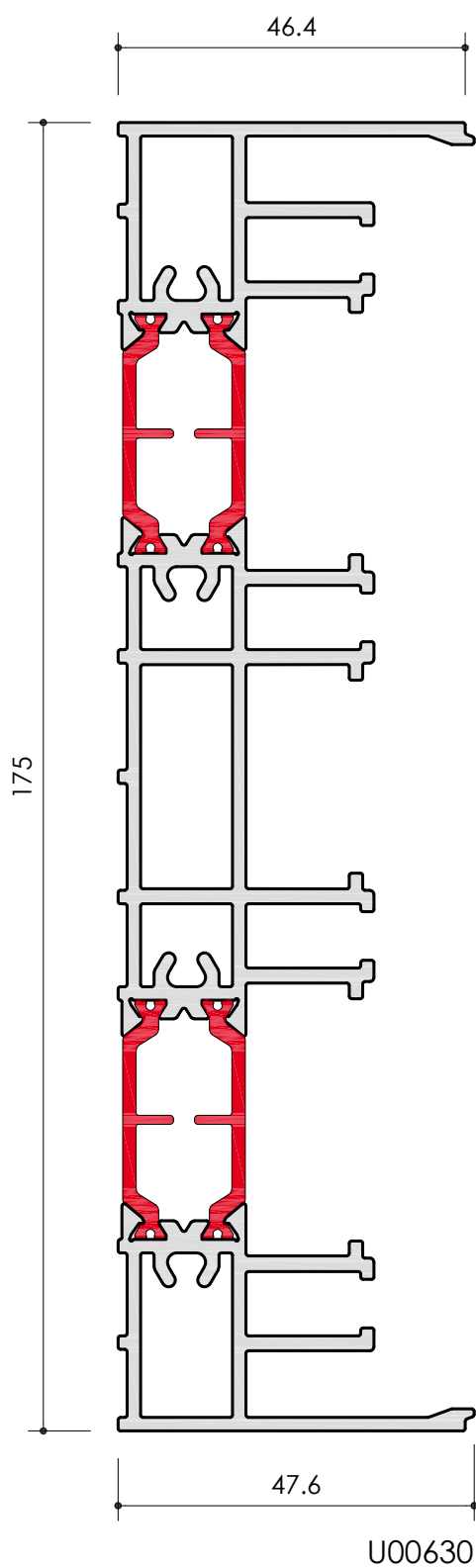


V42000 & V70000



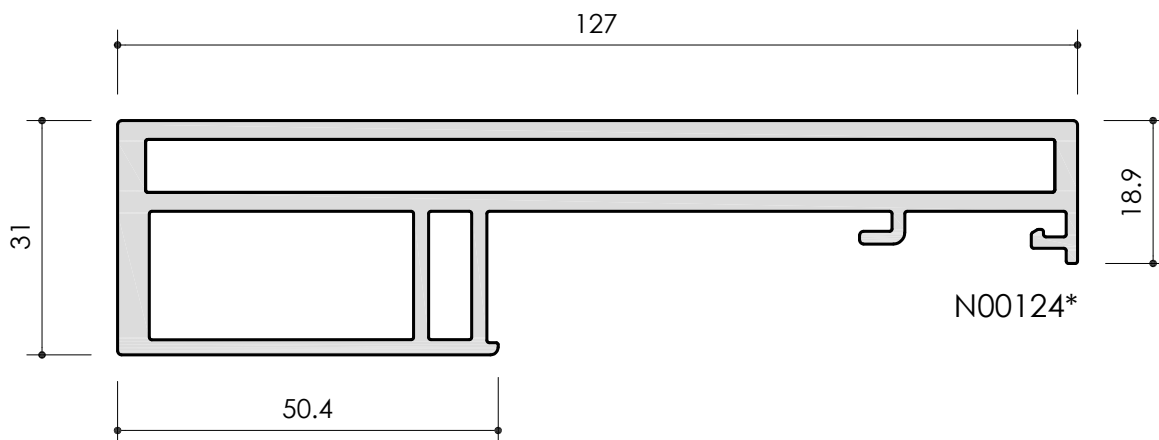
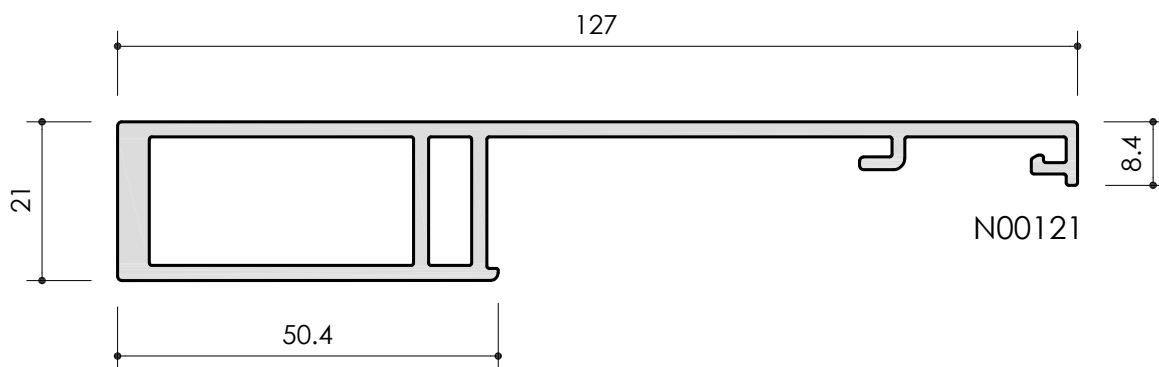
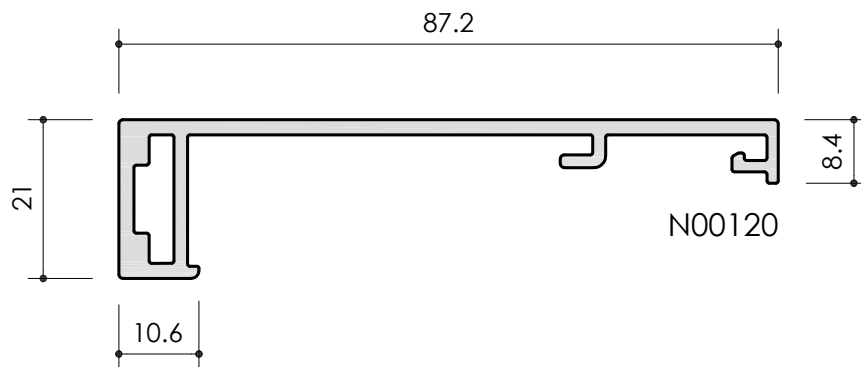
Scale 1 : 1

➤ PROFILE SECTION



Scale 1 : 1

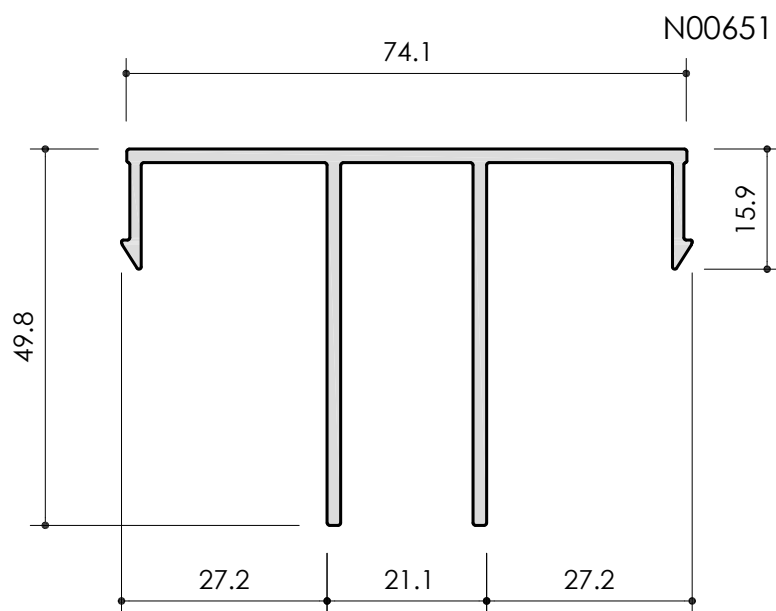
➤ PROFILE SECTION



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

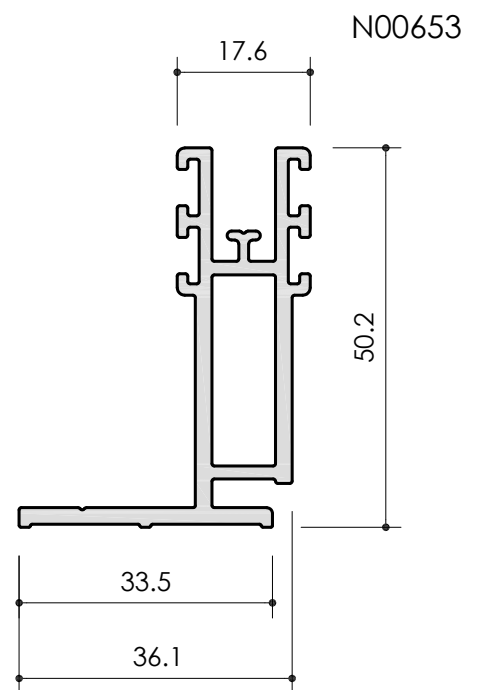
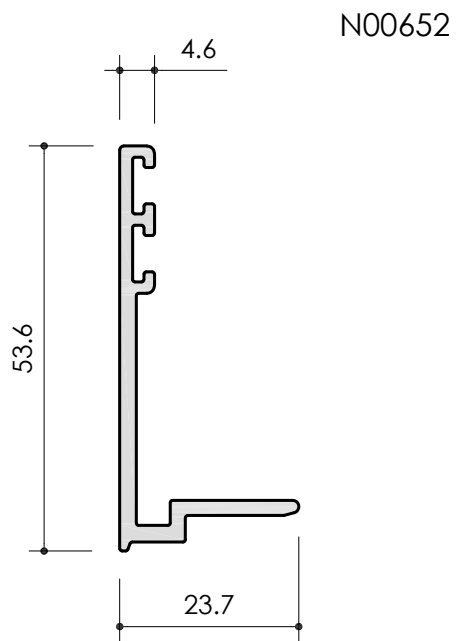
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► PROFILE SECTION

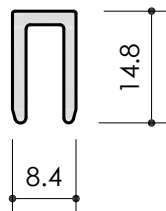


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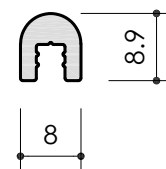
PROFILE SECTION



N00654



N00632

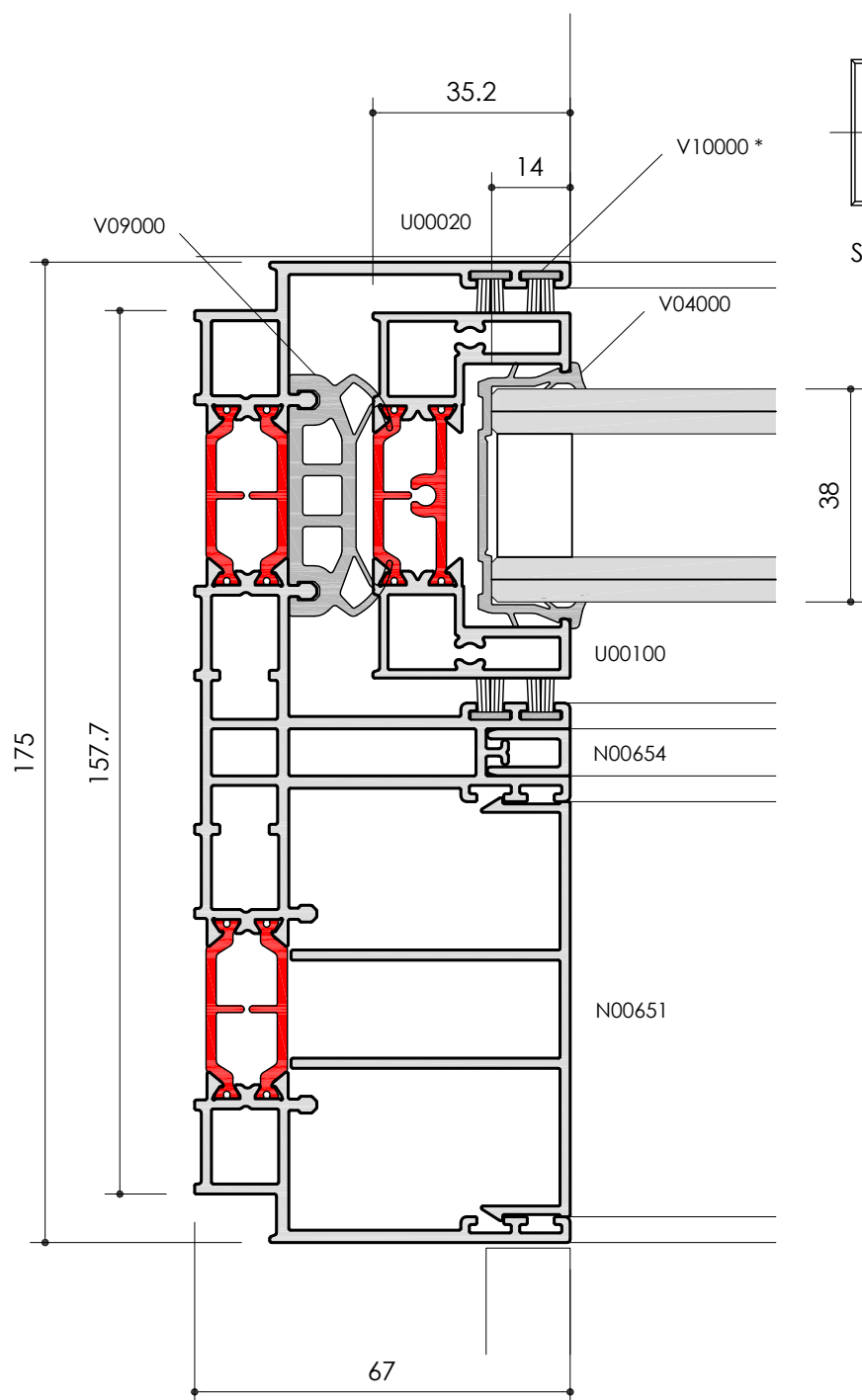


Scale 1 : 1

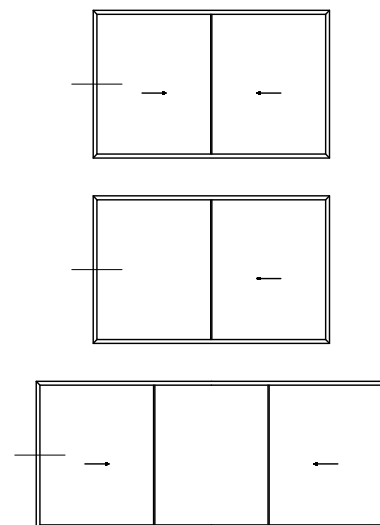


SECTION 6 TYPICAL DETAIL

TYPICAL DETAIL



JAMB SECTIONS



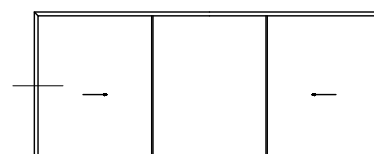
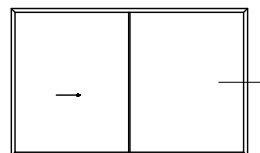
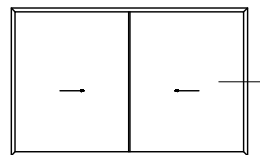
Scale 1 : 1.3

* V10000 = Only for Aluk.GBR: XA621

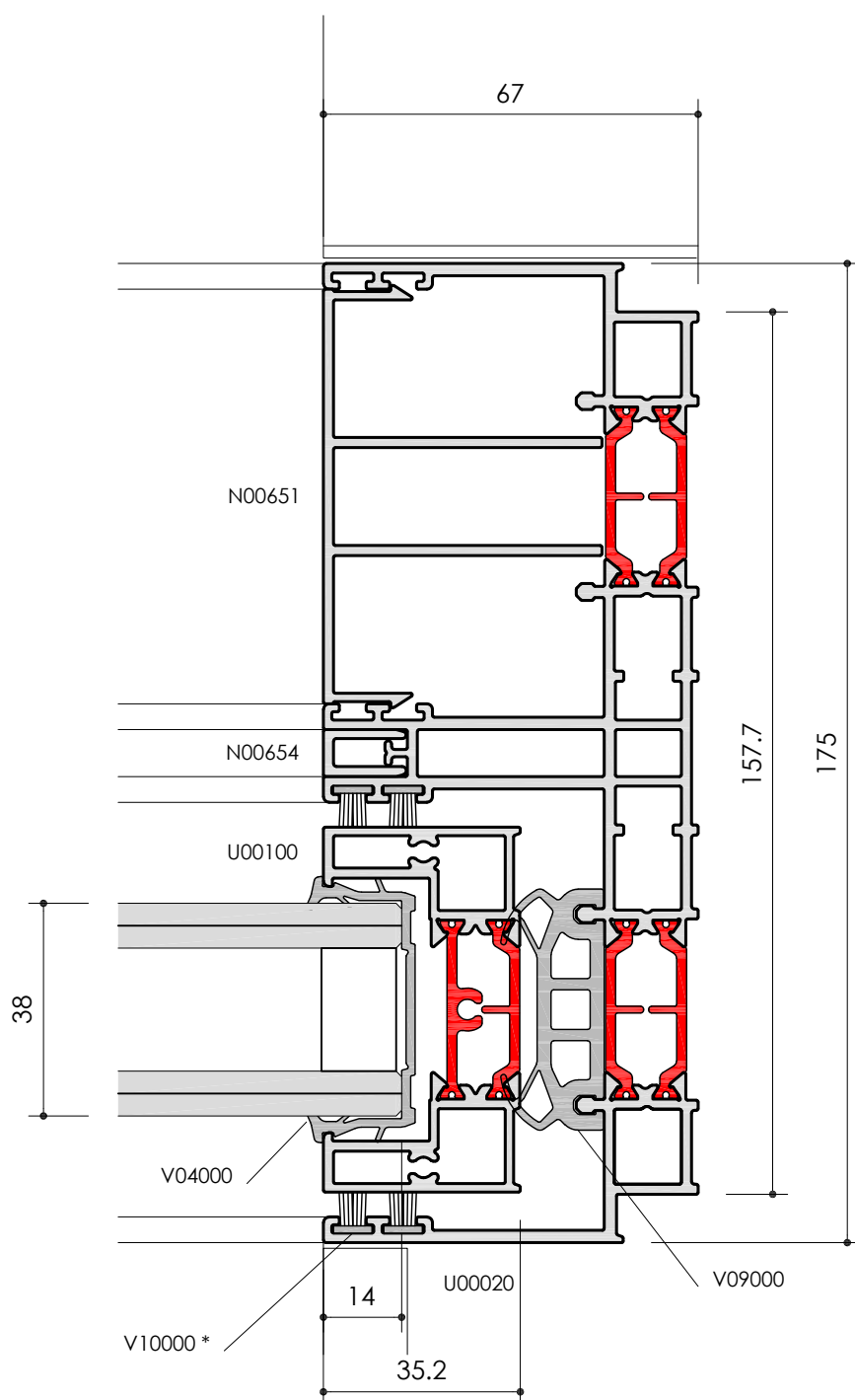
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

JAMB SECTIONS



Scale 1 : 1.3

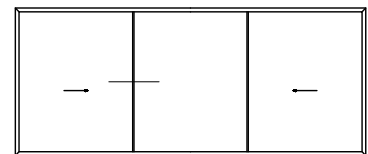
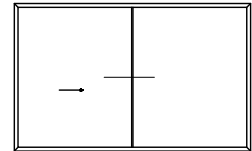
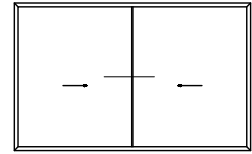


* V10000 = Only for Aluk.GBR: XA621

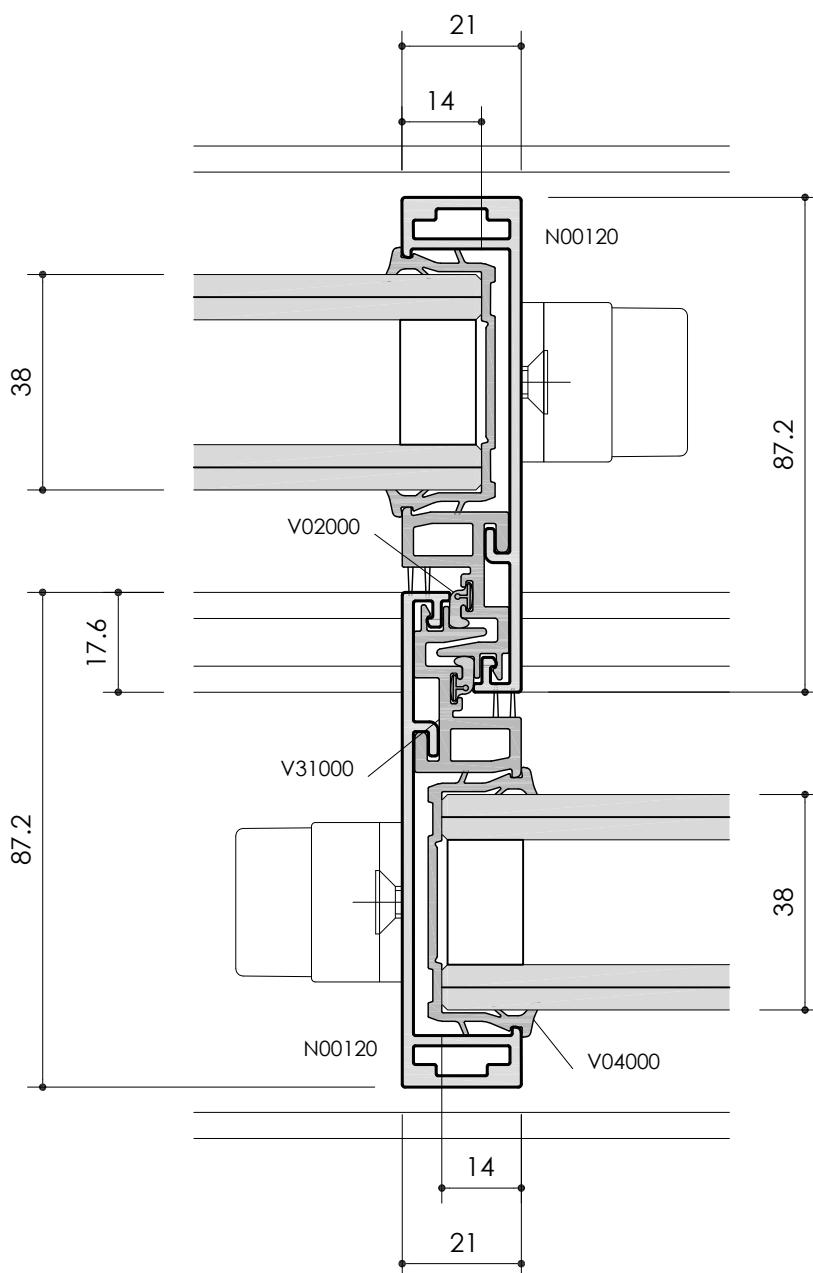
N.B. Gasket & Glazing Configurations are shown in section 7

> TYPICAL DETAIL

INTERLOCK SECTIONS

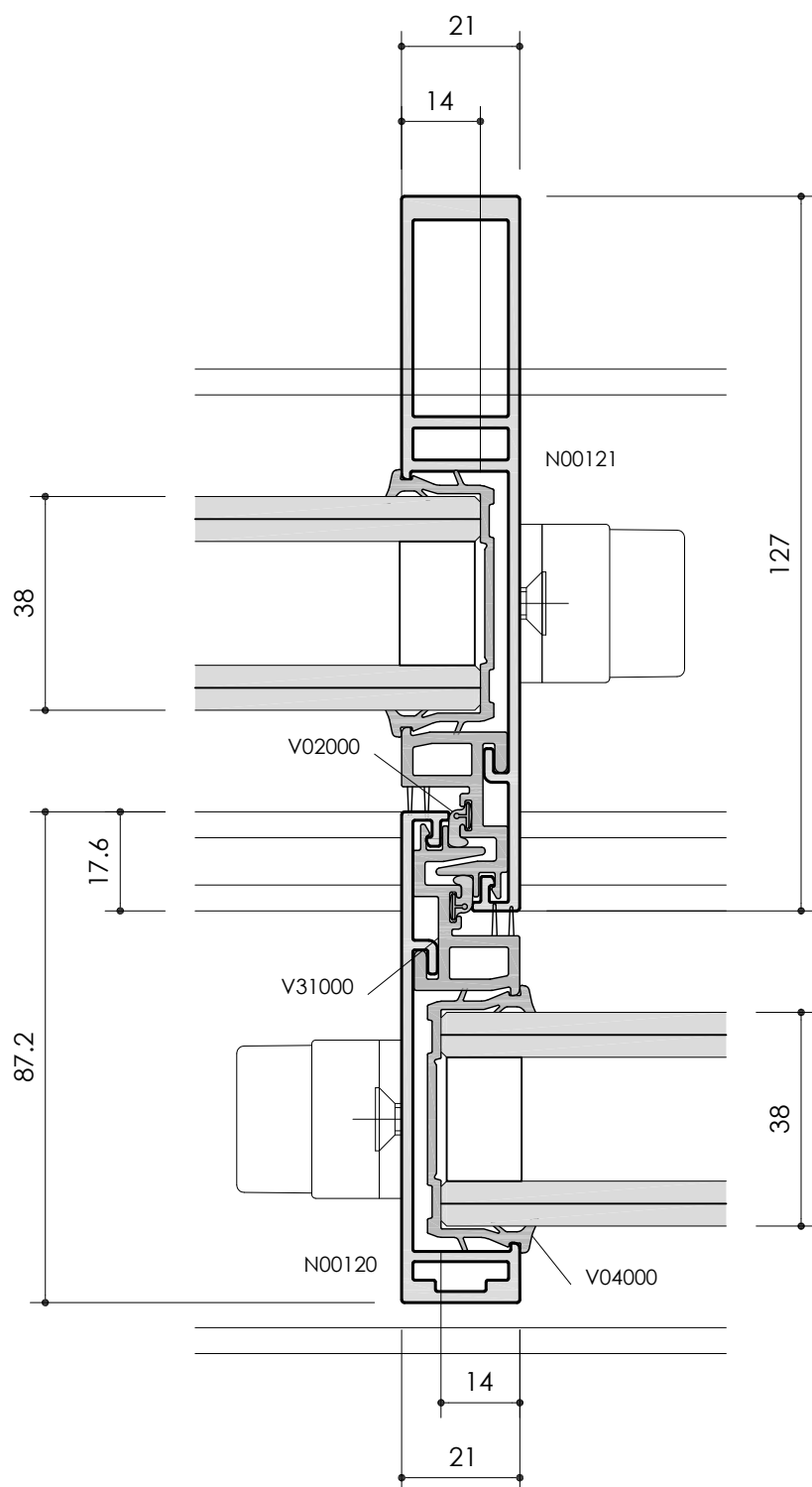


Scale 1 : 1.3

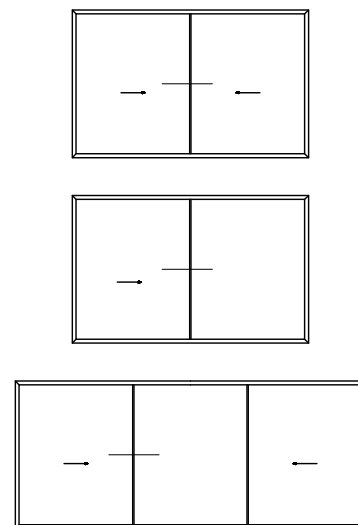


N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



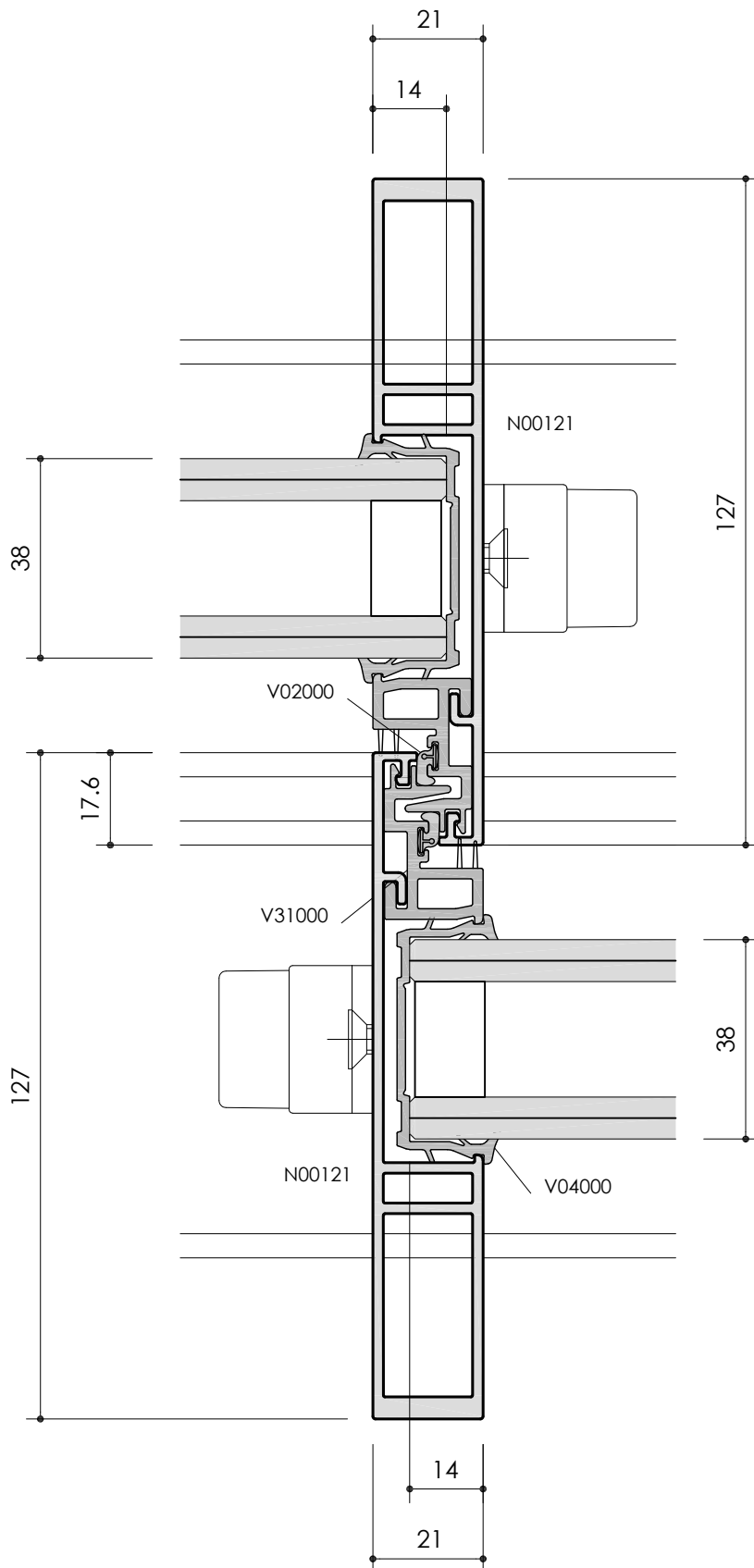
INTERLOCK SECTIONS



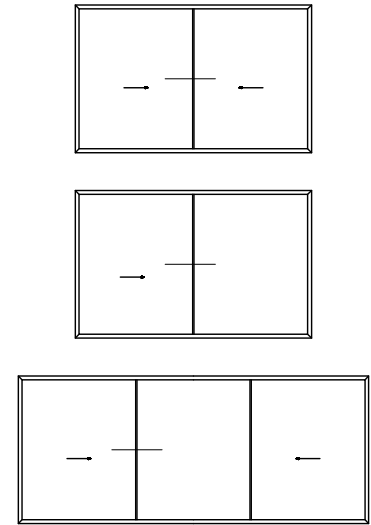
Scale 1 : 1.3

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

> TYPICAL DETAIL



INTERLOCK SECTIONS

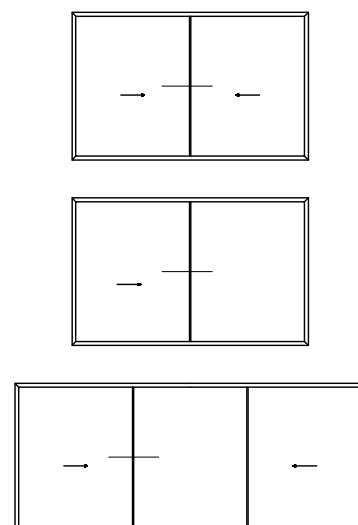
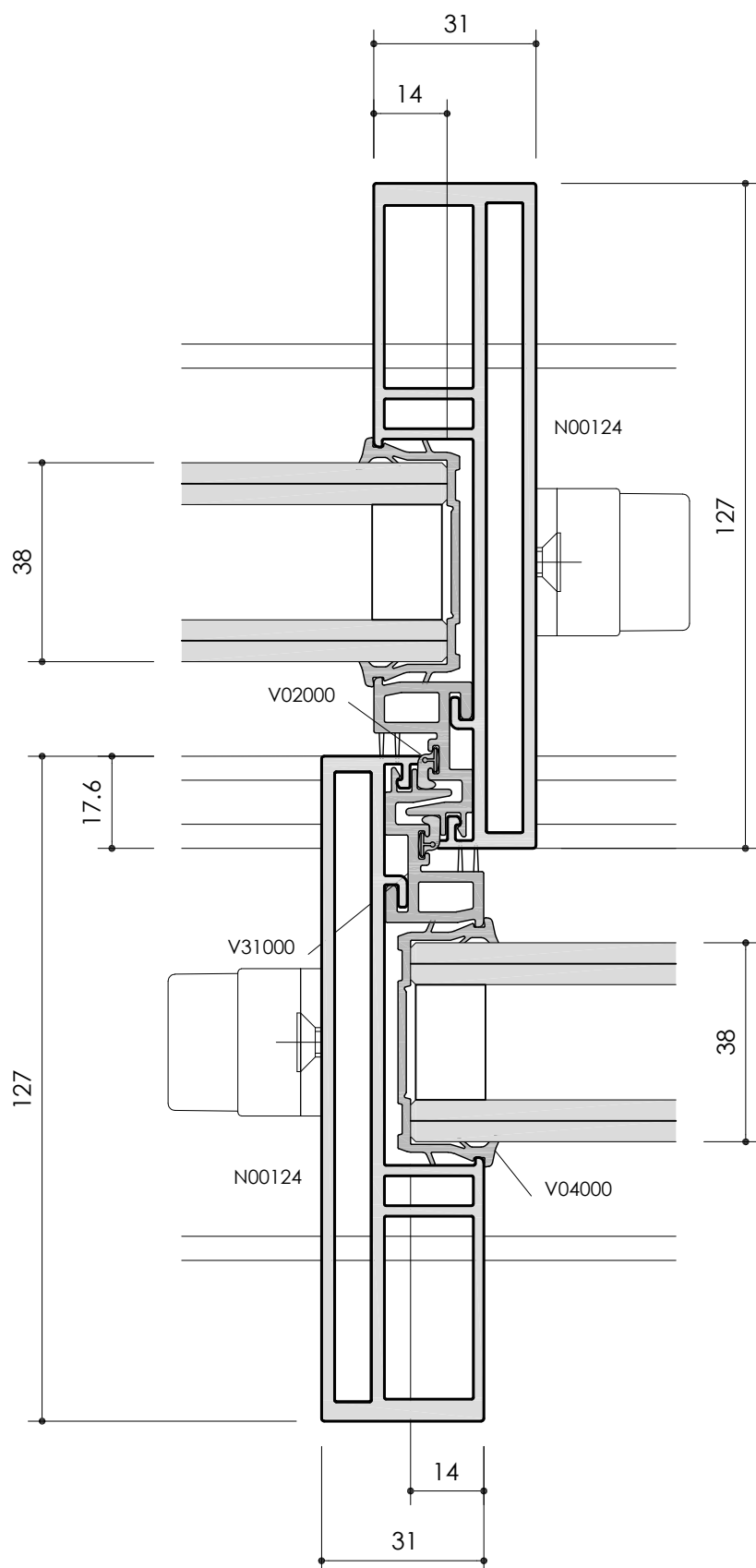


Scale 1 : 1.3

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

▶ TYPICAL DETAIL

INTERLOCK SECTIONS



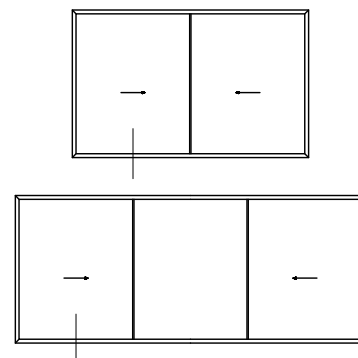
Scale 1 : 1.3

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

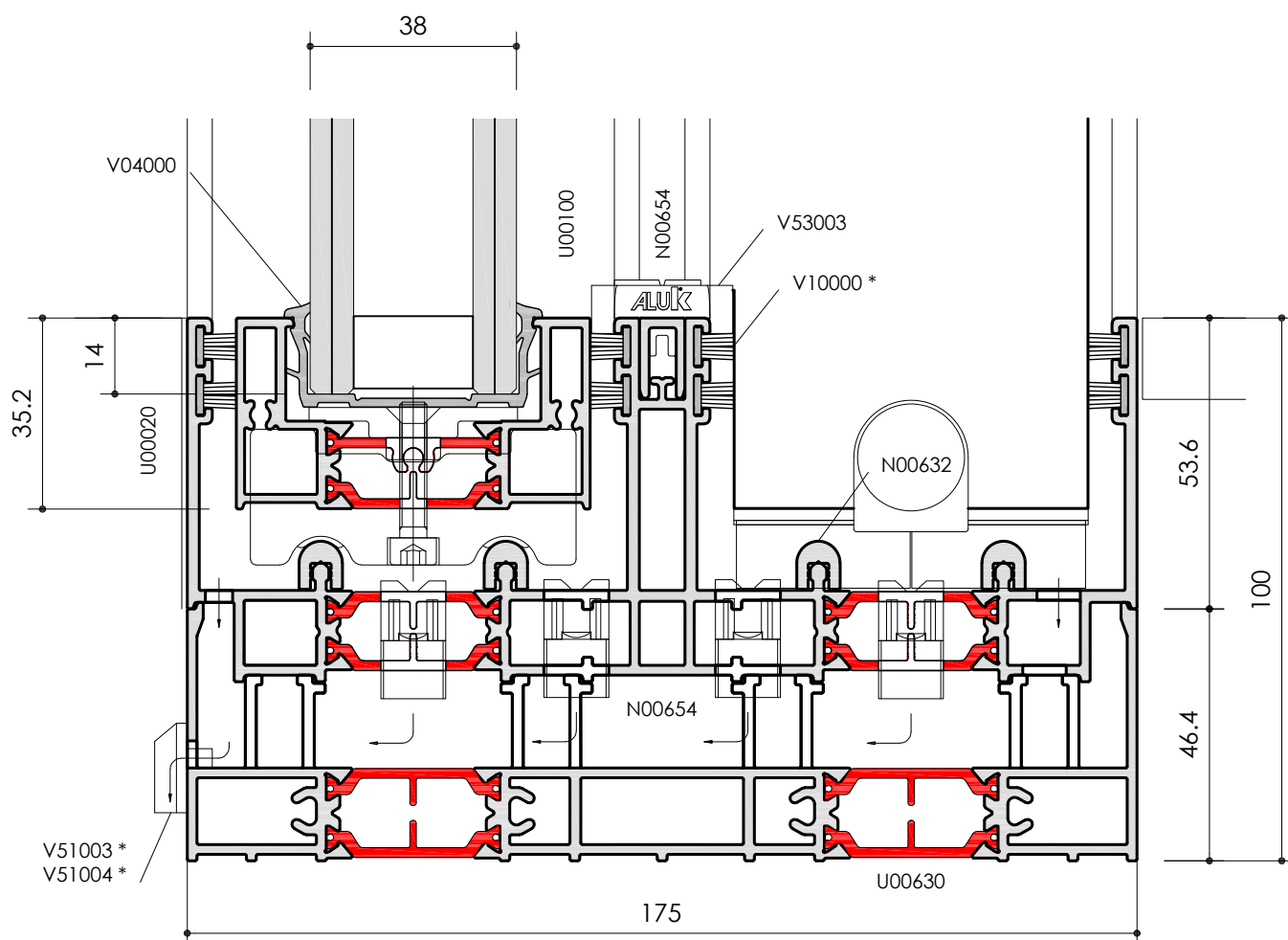
N.B. Additional inserts / reinforcement not supplied by Aluk

> 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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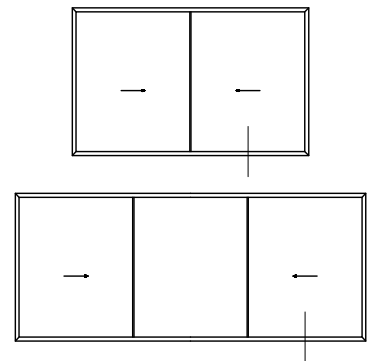
INFINIUM

6.07

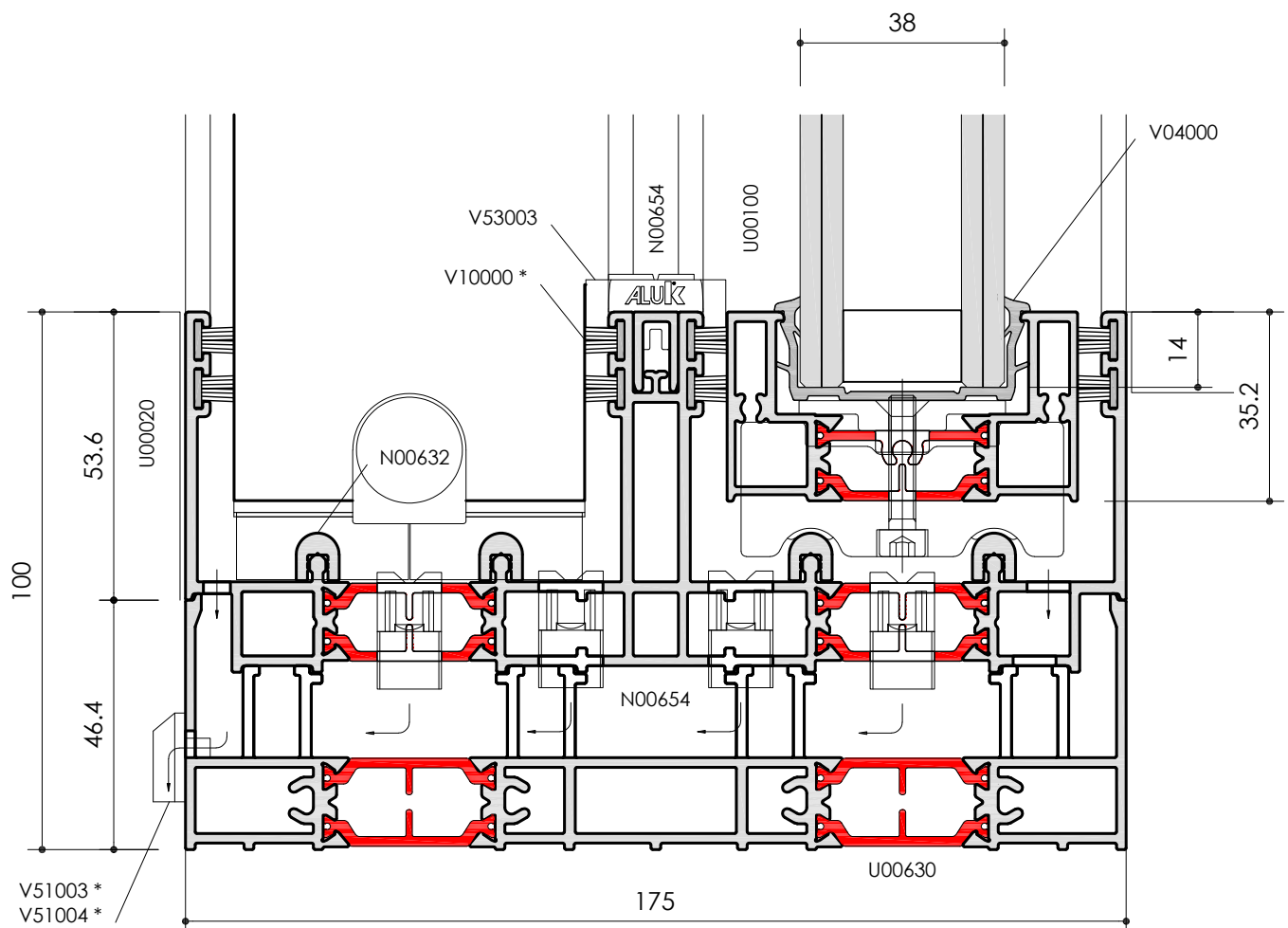
30.01.2017

► TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

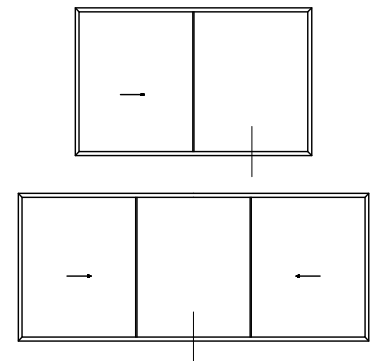
* V51003 = Only for Aluk.ITA: 712007

* V10000 = Only for Aluk.GBR: XA621

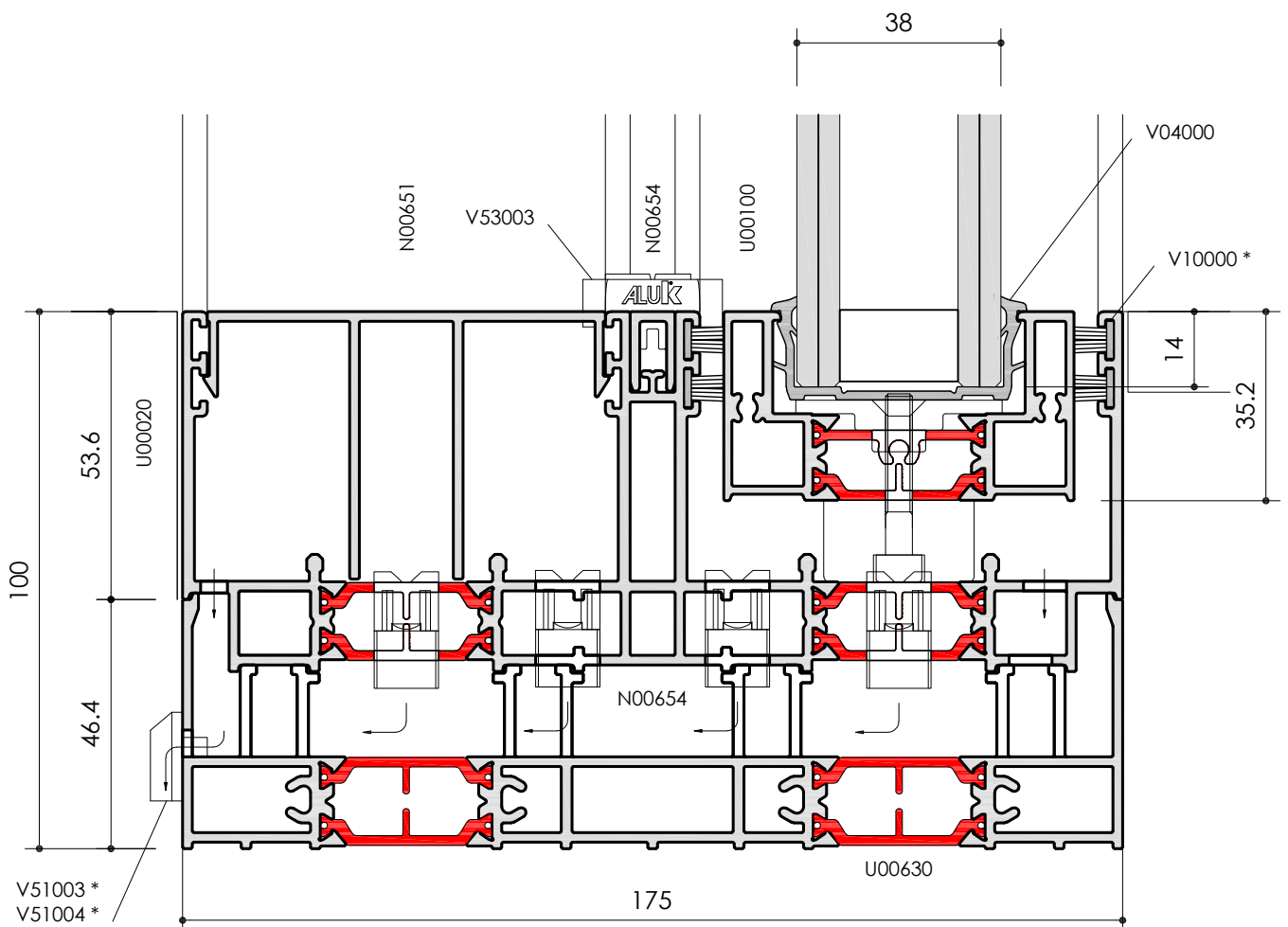
N.B. Gasket & Glazing Configurations are shown in section 7

➤ 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

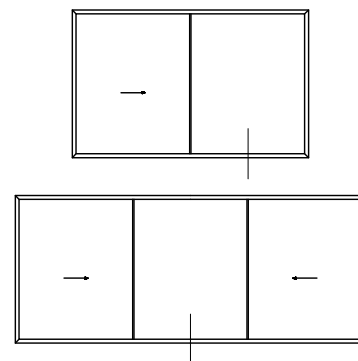
ALUK

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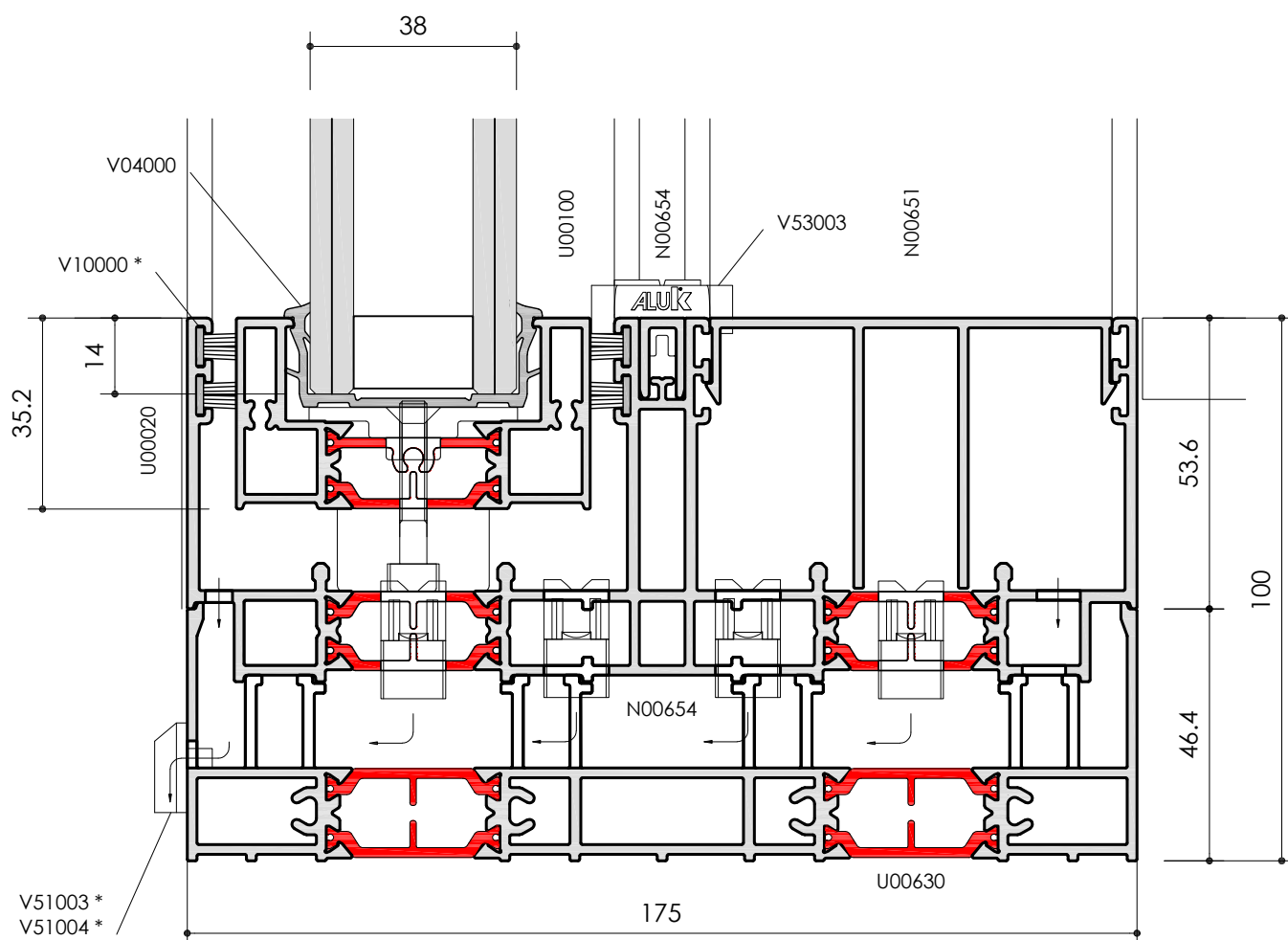
INFINIUM 6.09 30.01.2017

► TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

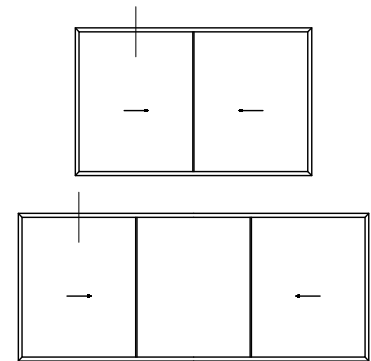
* V51003 = Only for Aluk.ITA: 712007

* V10000 = Only for Aluk.GBR: XA621

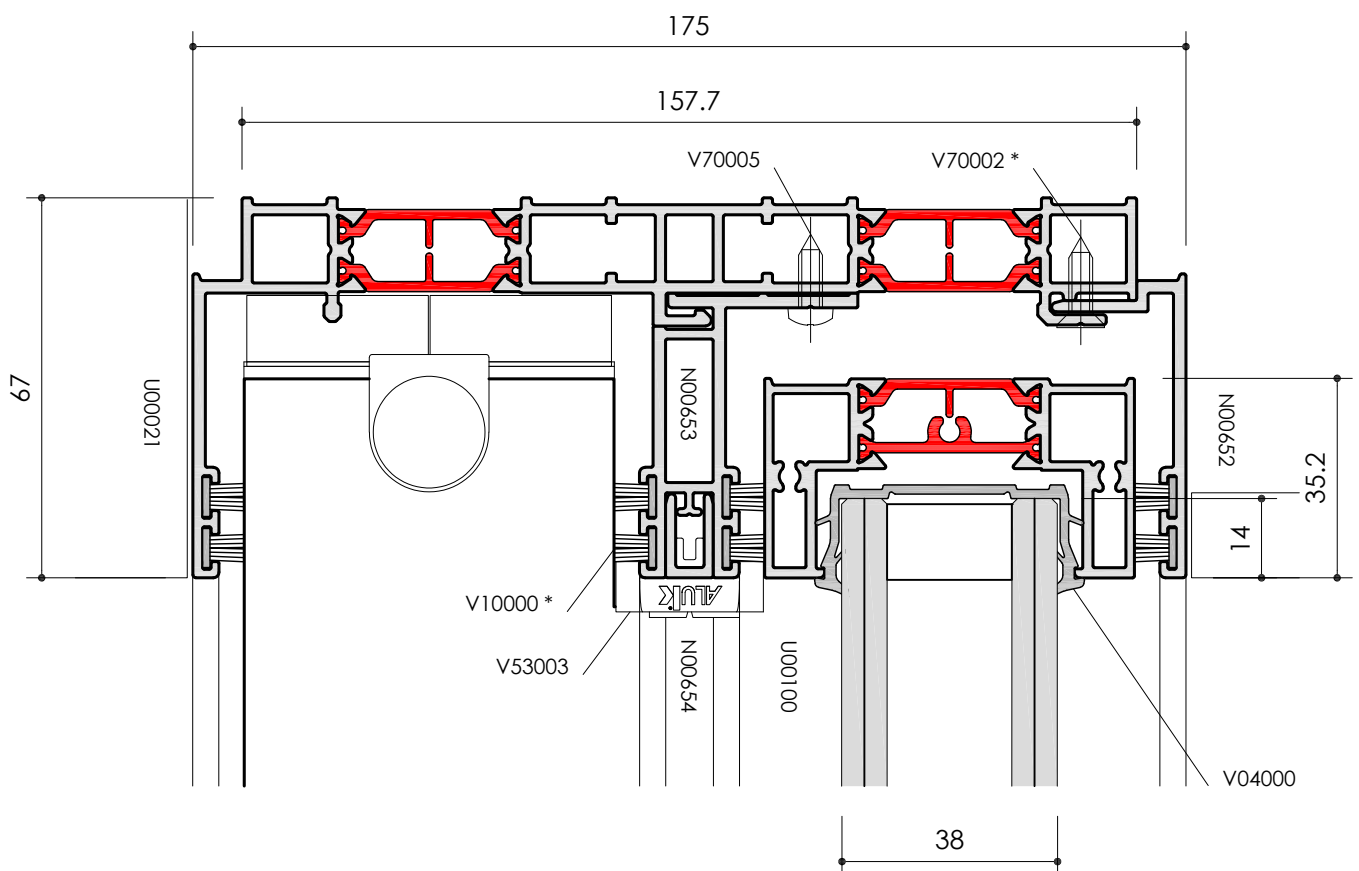
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



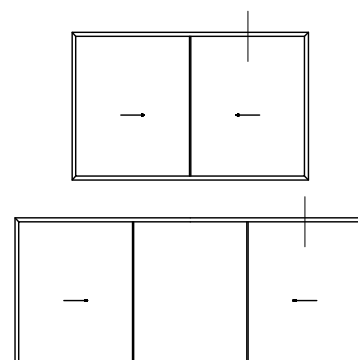
* V10000 = Only for Aluk.GBR: XA621

*V70002 = Only for Aluk.GBR: XS1006

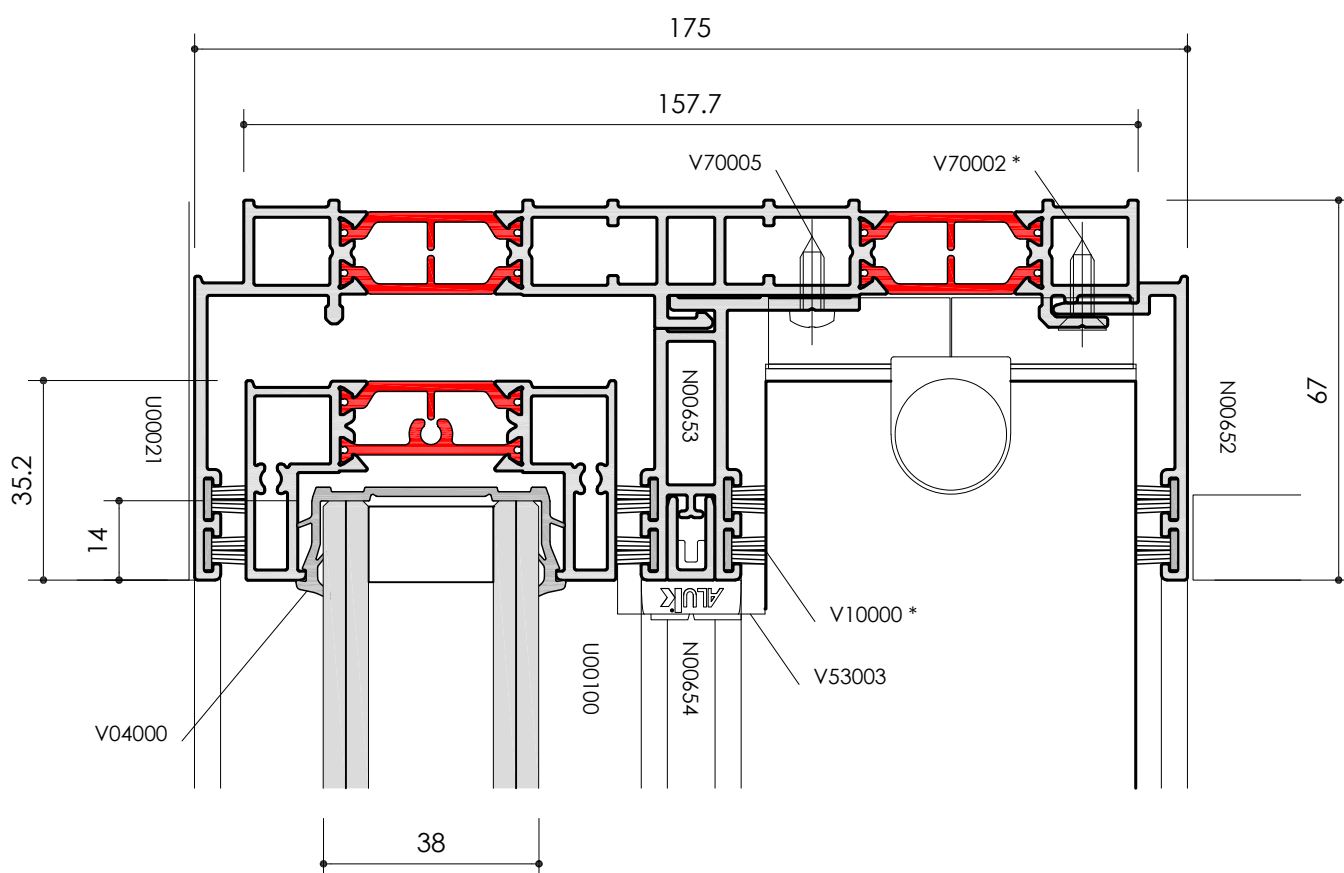
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



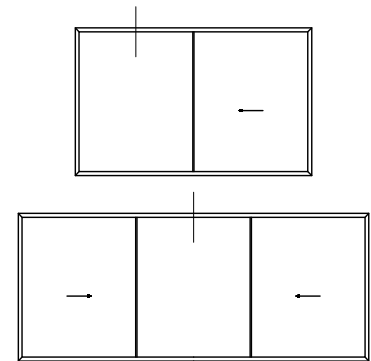
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

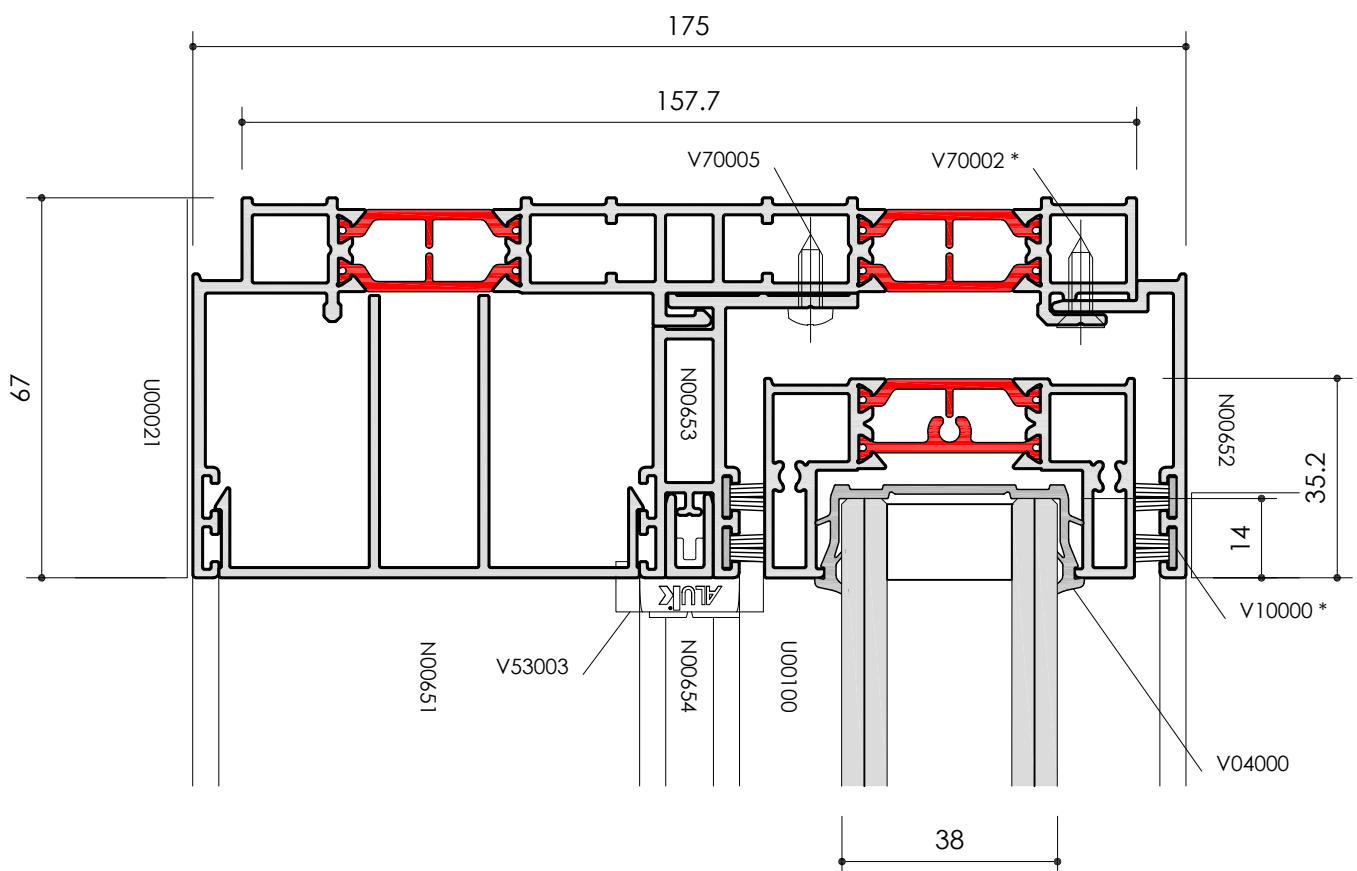
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



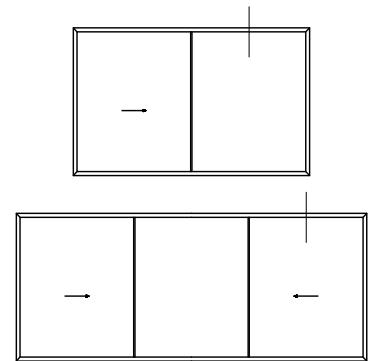
* V10000 = Only for Aluk.GBR: XA621

*V70002 = Only for Aluk.GBR: XS1006

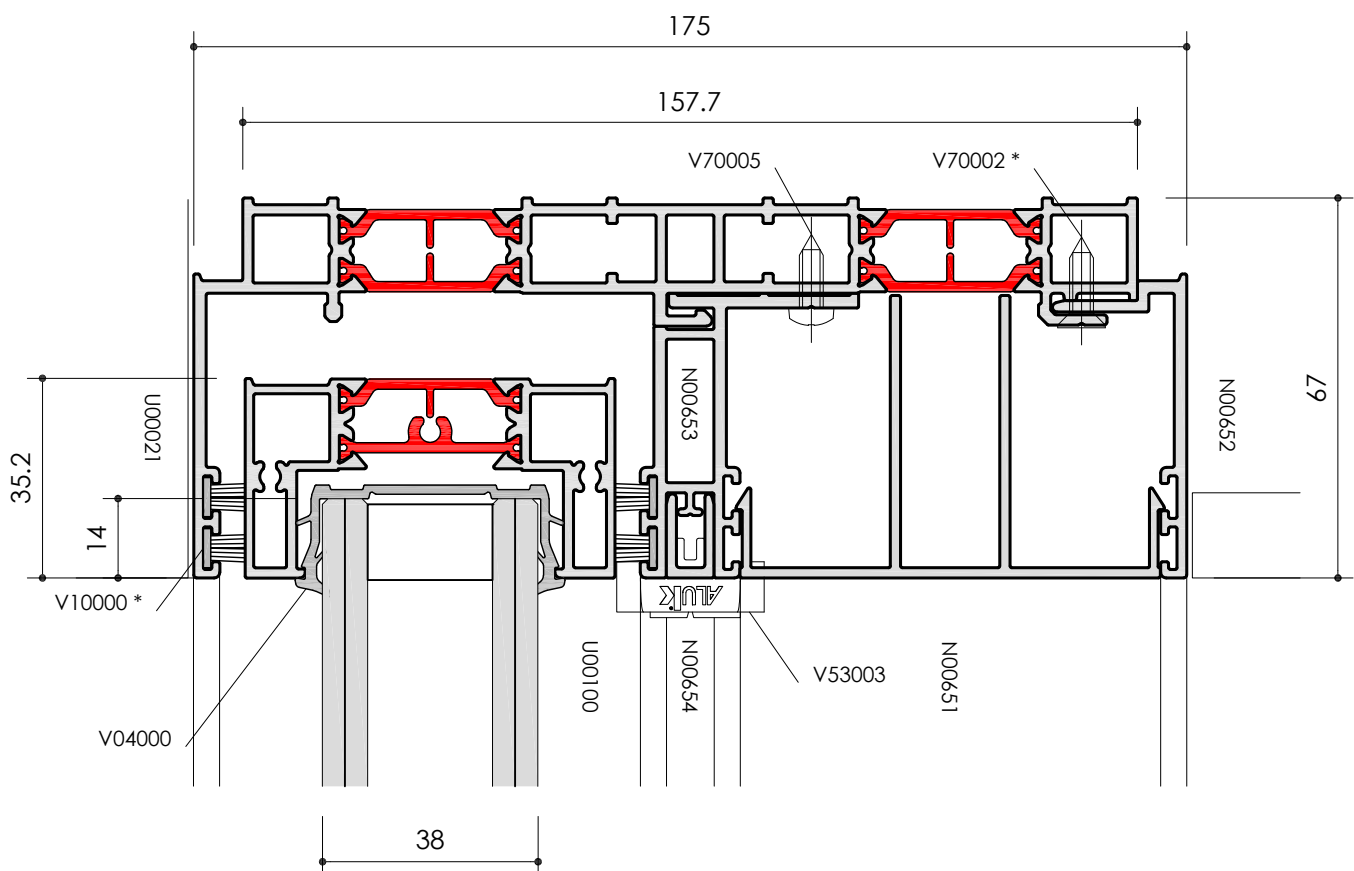
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



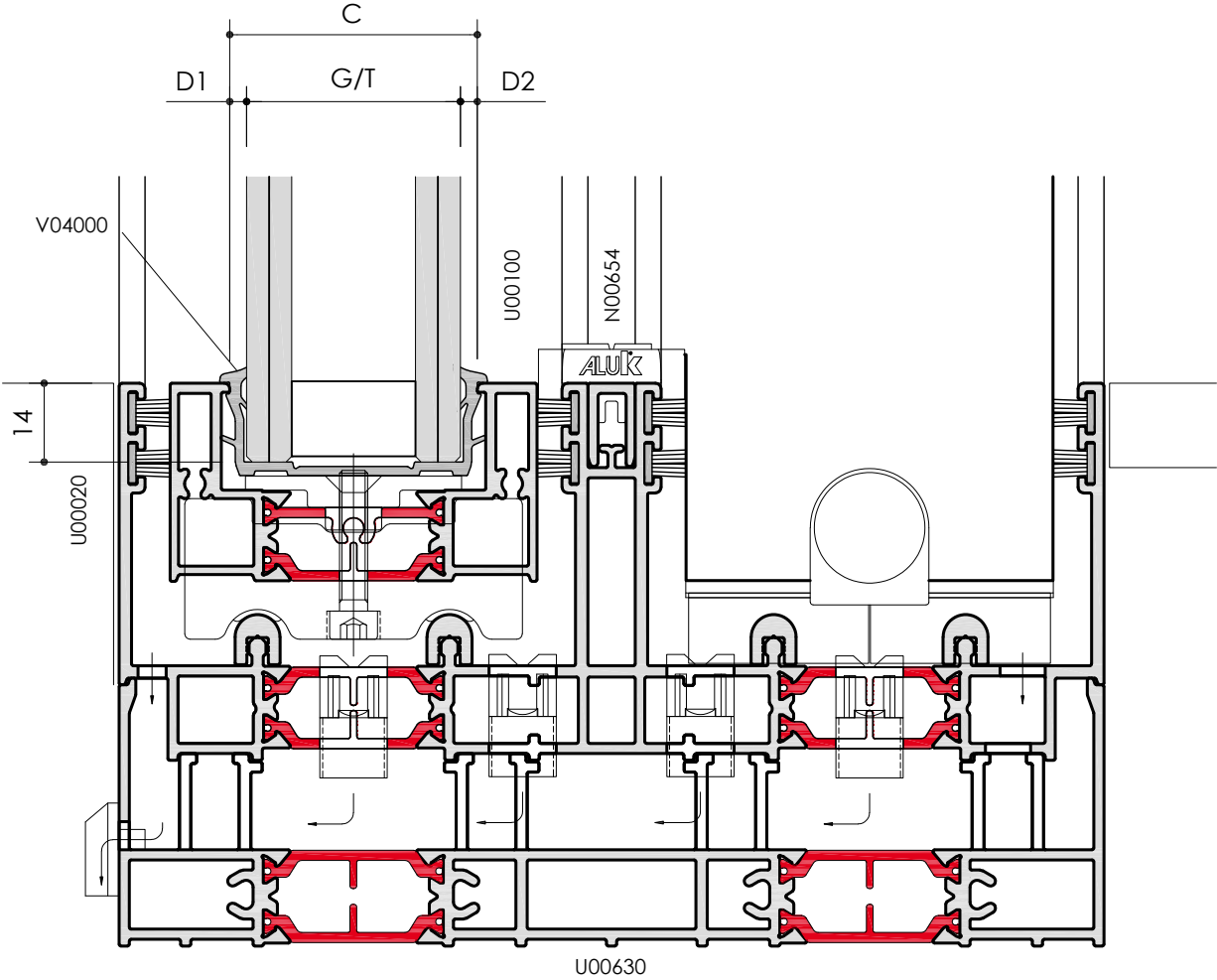
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

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

SECTION 7
GLAZING DETAIL

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



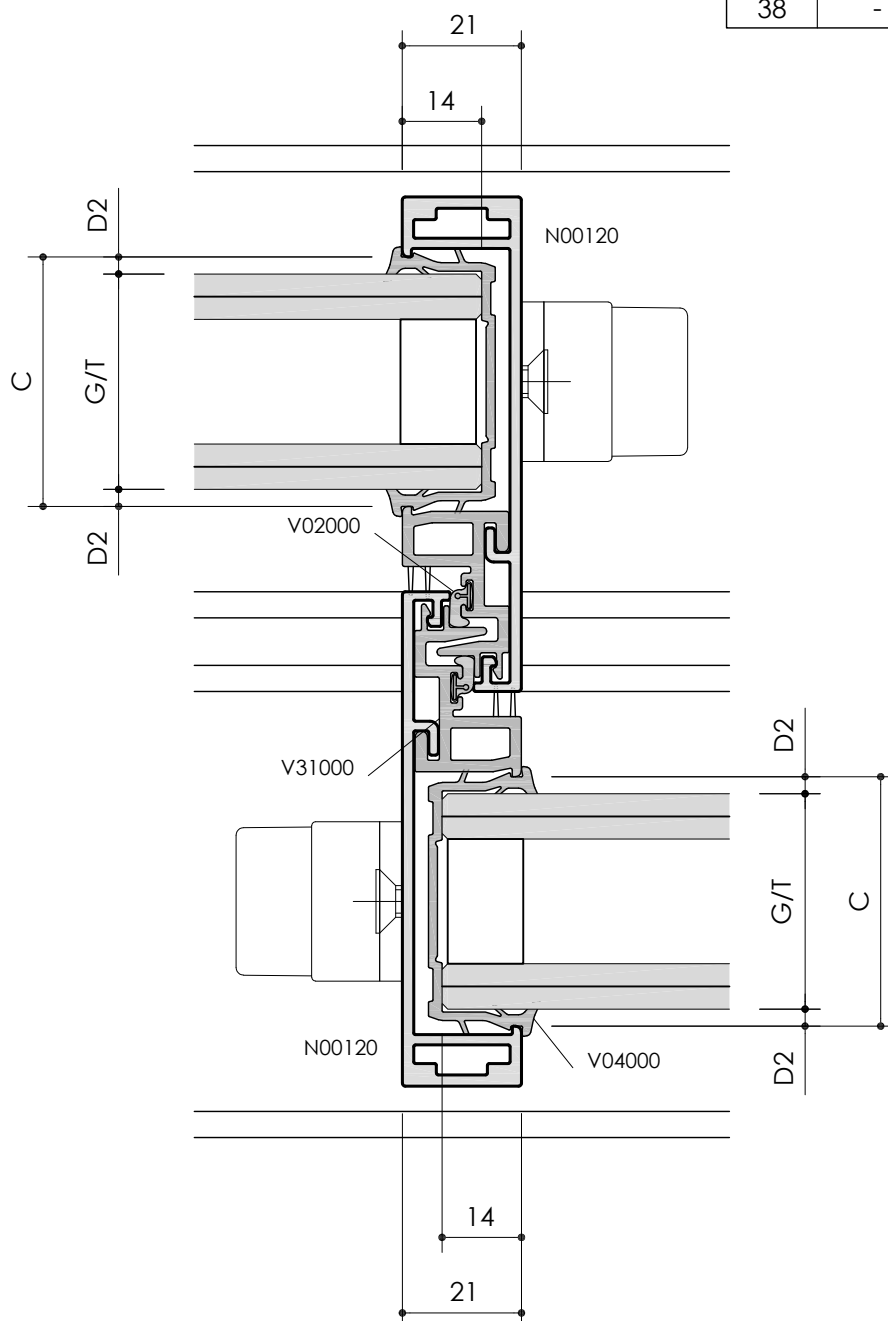
U-GASKET	WEDGE
V04000	-
	
38mm	-

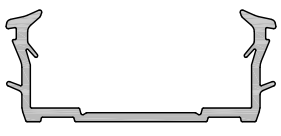
Applicable Profile(s):
U00100

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



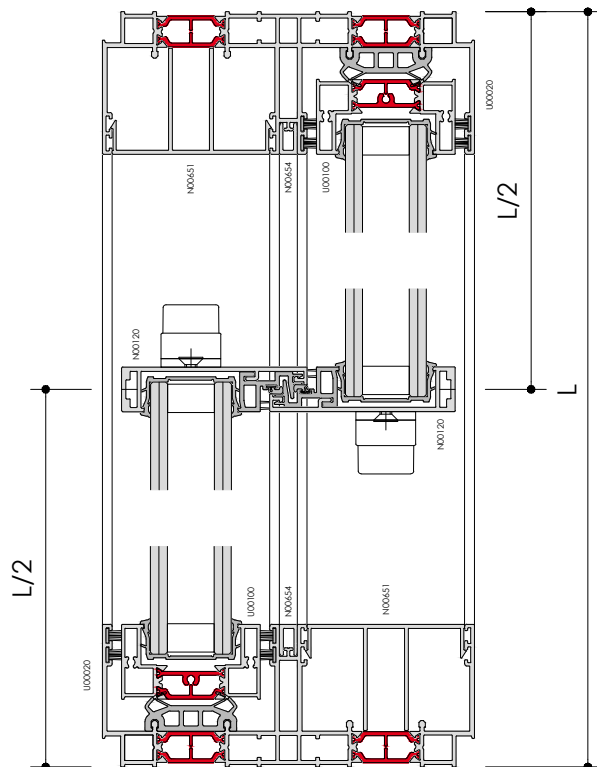
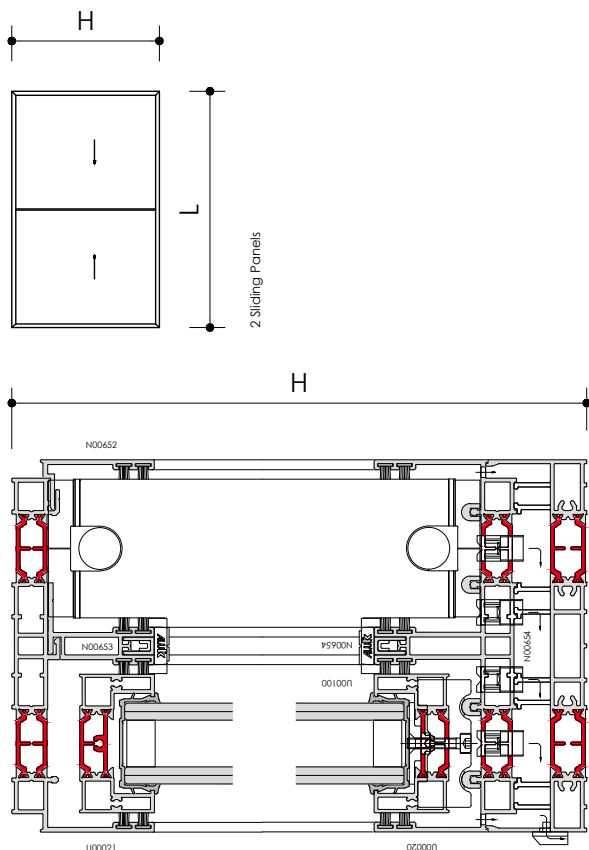
U-GASKET	WEDGE
V04000	-
	-
38mm	-

Applicable Profile(s):
N00120, N00121 & N00124

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

SECTION 8
CUTTING LIST

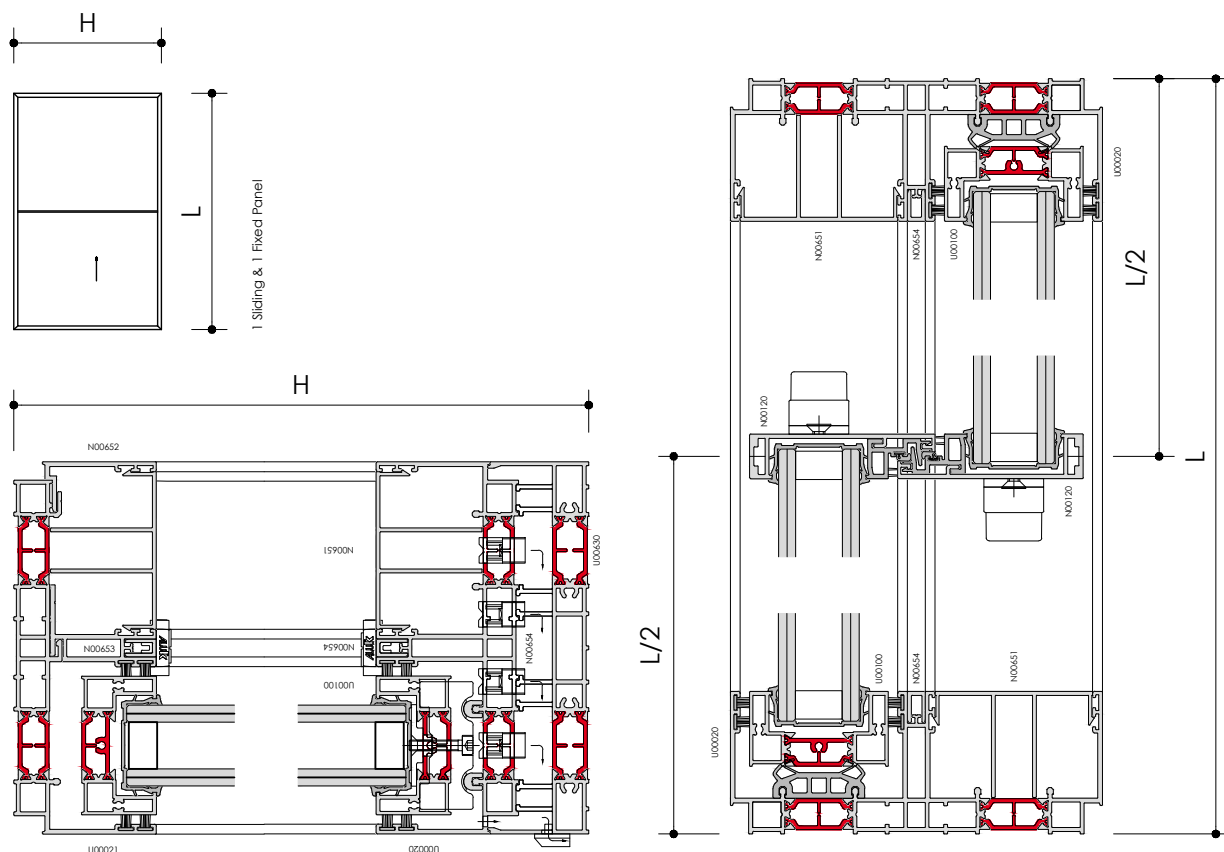
CUTTING LIST



PROFILE	NO.	SIZE	ANGLE
U00020	2	L	45°-45°
U00020	2	H - 33	45°-45°
U00021	2	L	45°-45°
U00630	1	L	90°-90°
N00632	4	L - 44	90°-90°
N00651	2	H - 74.2	90°-90°
N00652	1	L - 26.8	45°-45°
N00653	1	L - 33.6	45°-45°
N00654	4	[L - 155]/2	90°-90°
U00100	2	H - 167	90°-90°
U00100	2	H - 96.6	45°-45°
U00100	2	L/2 - 23.3	45°-90°
U00120	2	H - 96.6	90°-90°
ACCESSORIES			
V20000	4	Interlock Foam Plug	QUANTITY
V42000 *	24	Mechanical Cleat (13mm)	4
V53003	4	Interlock Seal (EPDM)	24
V55000	2	Sub Cill End Caps	4
V58000	4	Interlock End Cap	2
V62000	4	Roller Glazing Packer	4
V70000 *	48	Mechanical Cleat Screw	4
V70001	4	Ø4.2 x 30mm Pozl Pan Polyamide Screw	4
V70002 *	8	Ø4.2 x 16mm Pozl CSK S/Top SS 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	-
T50000/1/2	-	Small Joint Sealant/Adhesive	-
T50003	-	Aluk Sealant Wipes	-
GASKET / PLASTIC PROFILE			
V02000	2H	Co-Extruded Bubble Seal (Q-Lon)	SIZE
V04000	2L + 4H	38mm Double Glazed U Gasket	2H
V09000	2H	Outer Frame Bumper Seal	2H
V10000 *	16L + 8H	Outer Frame Sliding Seal/Fin Pile 6.9mmx 6mm	16L + 8H
V31000	2	21mm PVC Interlock Profile	H - 96.6
HARDWARE			
H00100	2	Lateral Locking Handle	QUANTITY
H00101	2	Lateral Pull Handle	2
H00200	4	Roller Wheels	4
H00400	2	Lateral Lock	2
H00401	2	Lateral Lock Adjustable Keep	2
H00404	2	Lateral Lock Lever	2
GLASS			
Glass unit 38mm	2	L/2 - 49.5	HEIGHT
			H - 139

* 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.GBR: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720
 * V70002 = Only for Aluk.GBR: XS006

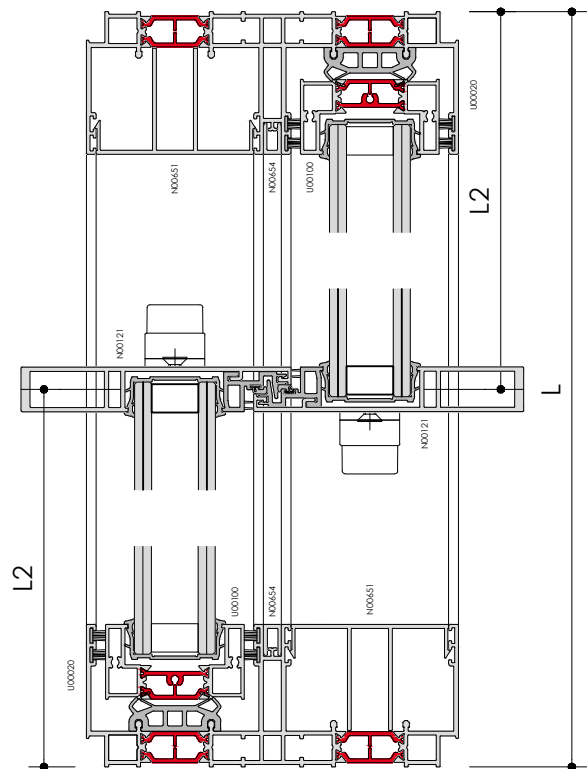
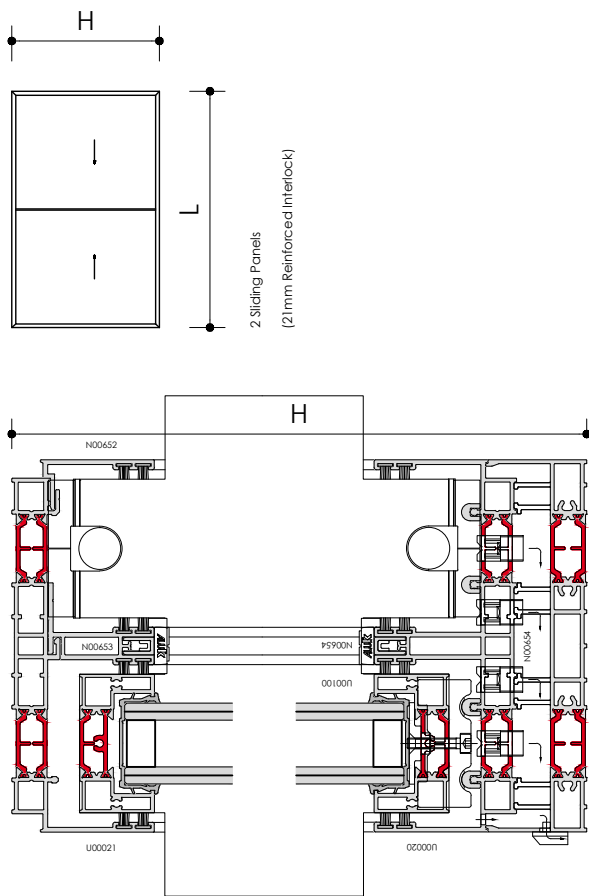
CUTTING LIST



PROFILE	NO.	SIZE	ANGLE
U00020	2	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	4	QUANTITY	
V42000 *	24	QUANTITY	
V50001	2	QUANTITY	
V53003	2	QUANTITY	
V55000	2	QUANTITY	
V58000	4	QUANTITY	
V62000	4	QUANTITY	
V70000 *	48	QUANTITY	
V70001	4	QUANTITY	
V70002 *	8	QUANTITY	
V51001 *	-	QUANTITY	
V51003 *	-	QUANTITY	
V51004 *	-	QUANTITY	
V51005 *	-	QUANTITY	
T50000/1/2	-	QUANTITY	
T50003	-	QUANTITY	
GASKET / PLASTIC PROFILE			
V02000	2H	SIZE	
V04000	2L + 4H	SIZE	
V09000	2H	SIZE	
V10000 *	16L + 8H	SIZE	
V31000	H - 96.6	SIZE	90°-90°
HARDWARE			
H00100	1	QUANTITY	
H00101	1	QUANTITY	
H00200	2	QUANTITY	
H00400	1	QUANTITY	
H00401	1	QUANTITY	
H00404	1	QUANTITY	
GLASS			
Glass unit 38mm	2	WIDTH	HEIGHT
		L/2 - 49.5	H - 139

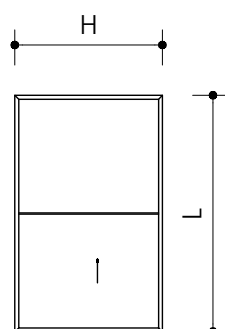
* V10000 = Only for Aluk.GBR: XA621
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.ITA: 709616
 * V51002 = Only for Aluk.ITA: 709617
 * V51003 = Only for Aluk.GBR: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720
 * V70002 = Only for Aluk.GBR: X5006

CUTTING LIST

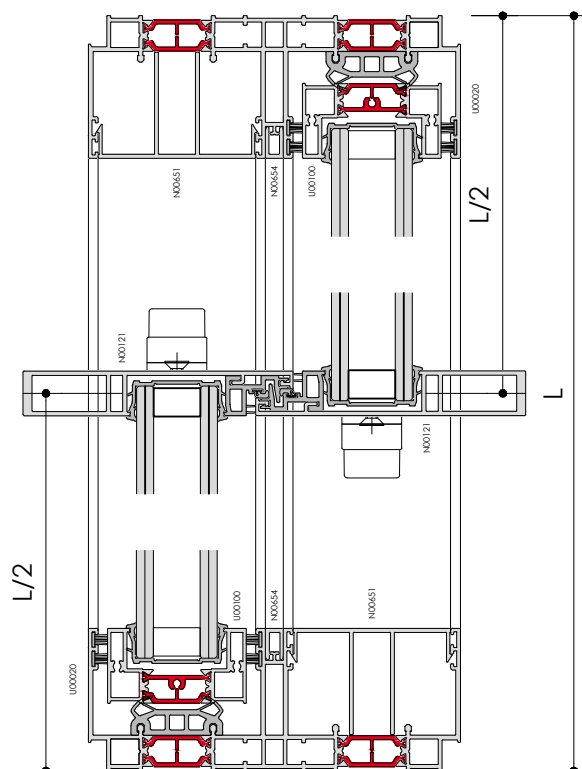
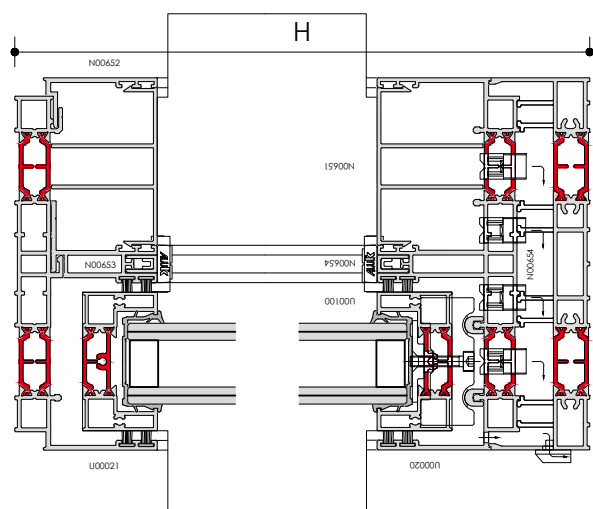


PROFILE	NO.	SIZE	ANGLE
U00020	2	L	45°-45°
U00020	2	H - 33	45°-45°
U00021	2	L	45°-45°
U00630	1	L	90°-90°
U00632	4	L - 44	90°-90°
N00651	2	H - 74.2	90°-90°
N00652	1	L - 26.8	45°-45°
N00653	1	L - 33.6	45°-45°
N00654	4	(L - 155)/2	90°-90°
U00100	2	H - 167	90°-90°
U00100	2	H - 96.6	45°-45°
U00100	2	L/2 - 23.3	45°-90°
U00121	2	L/2 - 23.3	45°-90°
N00121	2	H - 96.6	90°-90°
ACCESSORIES			
V20000	4	Interlock Foam Plug	QUANTITY
V42000 *	4	Mechanical Cleat (13mm)	4
V53003	4	Interlock Seal (EPDM)	24
V55000	2	Sub Cill End Caps	4
V58000	4	Interlock End Cap	2
V62000	4	Roller Glazing Packer	4
V70000 *	48	Mechanical Cleat Screw	4
V70001	4	Ø4.2 x 30mm Pozl Pan Polyamide Screw	4
V70002 *	8	Ø4.2 x 16mm Pozl CSK S/Top SS 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	-
T50000/1/2	-	Small Joint Sealant/Adhesive	-
T50003	-	Aluk Sealant Wipes	-
GASKET / PLASTIC PROFILE			
V02000	2H	Co-Extruded Bubble Seal (G-Lon)	SIZE
V04000	2L + 4H	38mm Double Glazed U Gasket	2H
V09000	2H	Outer Frame Bumper Seal	2H
V10000 *	16L + 8H	Outer Frame Sliding Seal/Fin Pile 6.9mmx 6mm	16L + 8H
V31000	2	21mm PVC Interlock Profile	H - 96.6
HARDWARE			
H00100	2	Lateral Locking Handle	QUANTITY
H00101	2	Lateral Pull Handle	2
H00200	4	Roller Wheels	4
H00400	2	Lateral Lock	2
H00401	2	Lateral Lock Adjustable Keep	2
H00404	2	Lateral Lock Lever	2
GLASS			
Glass unit 38mm	2	L/2 - 49.5	HEIGHT
			H - 139

* V10000 = 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.GBR: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720
 * V70002 = Only for Aluk.GBR: XS006



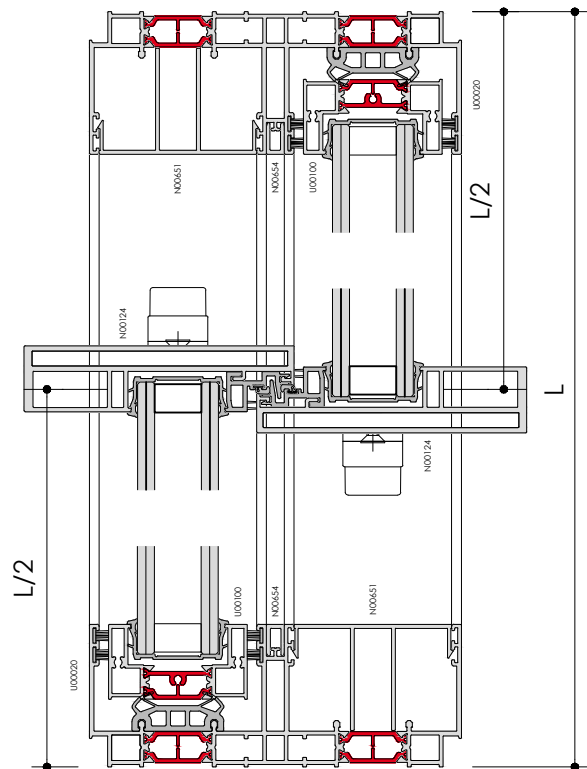
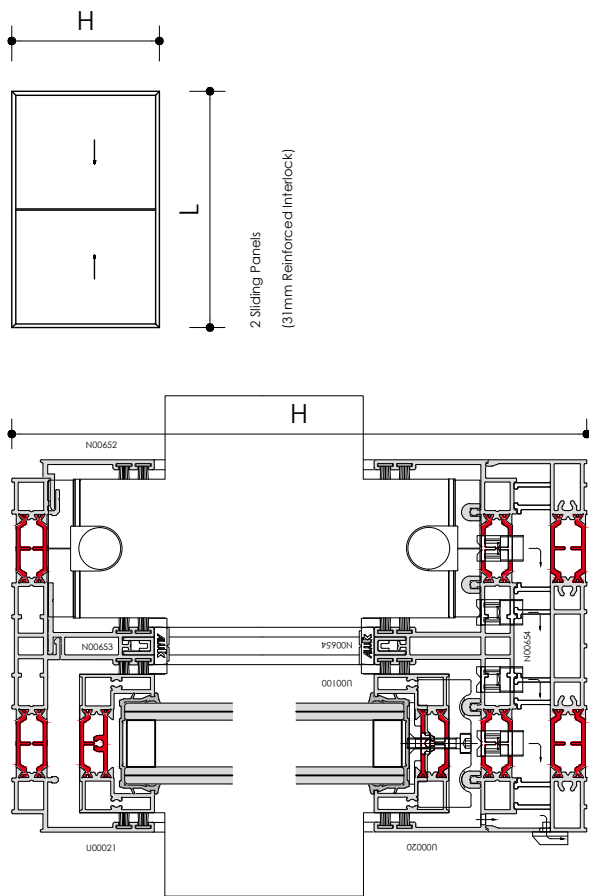
Sliding & 1 Fixed Panel
21mm Reinforced Interlock)



PROFILE		NO.	SIZE	ANGLE
U00020	2 Track Outer Frame	2	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	
N00051	Outer Frame Cover Profile	2	H - 74.2	90°-90°
N00052	Outer Frame Cover Profile	2	(L - 155)/2	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/2 - 79.5	90°-90°
N00054	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°
N00121	21mm Reinforced Interlock Profile	2	H - 96.6	90°-90°
ACCESSORIES		QUANTITY		
V20000	Interlock Foam Plug	4		
V42000 *	Mechanical Cleat (13mm)			24
V50001	Fixed Sash Support Blocks			2
V53003	Interlock Seal (EPDM)			2
V55000	Sub Cill End Caps			2
V58000	Interlock End Cap			2
V62000	Roller Glazing Packer			4
V70000 *	Mechanical Cleat Screw			48
V70001	Ø4.2 x 30mm Pozl Pan Polyamide Screw			4
V70002 *	Ø4.2 x 16mm Pozl CSK S/1ap SS Screw			8
V10001 *	Ø10.5mm Hole Plug			-
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	Auk Sealant Wipes			-
GASKET / PLASTIC PROFILE		NO.	SIZE	
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°
HARDWARE		QUANTITY		
H00100	Lateral Locking Handle			1
H00101	Lateral Pull Handle			1
H00200	Roller Wheels			2
H00400	Lateral Lock			1
H00401	Lateral Lock Adjustable Keep			1
H00404	Lateral Lock Lever			1
GLASS UNIT 36mm		NO.	WIDTH	HEIGHT
		2	L/2 - 49.5	H - 139

- * 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
- * V70002 = Only for Aluk.FRA: XS006

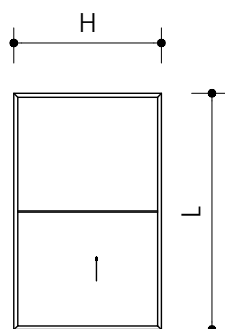
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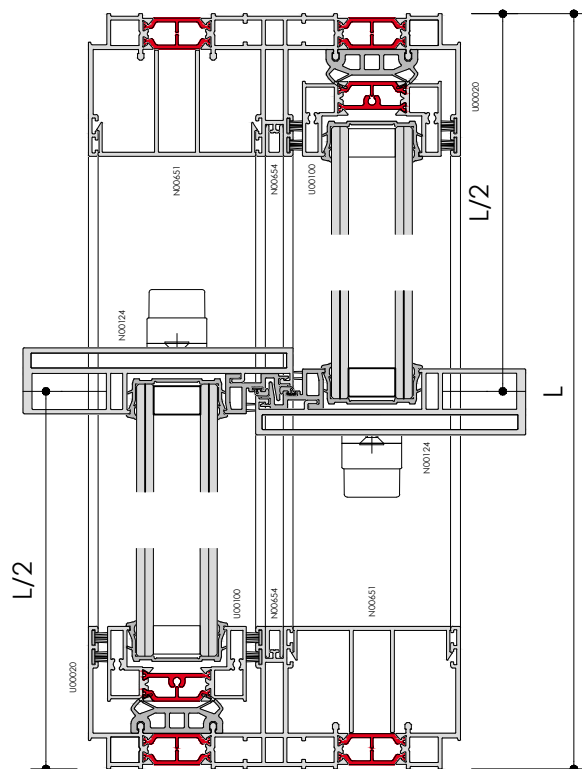
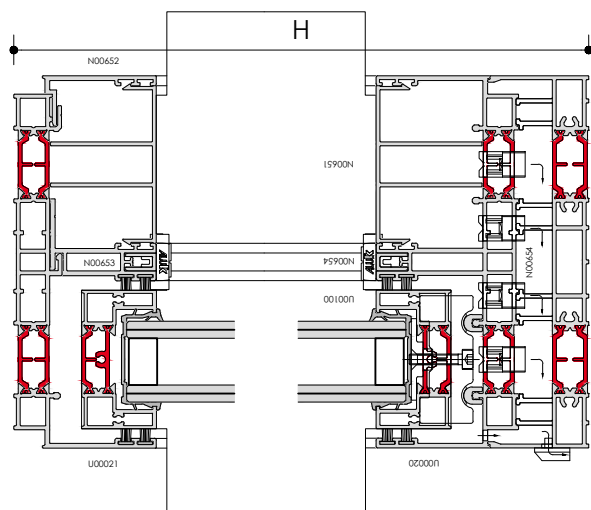
PROFILE	NO.	SIZE	ANGLE
U00020	2	L	45°-45°
U00020	2	H - 33	45°-45°
U00021	2	L	45°-45°
U00630	1	L	90°-90°
U00632	4	L - 44	90°-90°
N00651	2	H - 74.2	90°-90°
N00652	1	L - 26.8	45°-45°
N00653	1	L - 33.6	45°-45°
N00654	4	(L - 155)/2	90°-90°
U00100	2	H - 167	90°-90°
U00100	2	H - 96.6	45°-45°
U00100	2	L/2 - 23.3	45°-90°
U00124	2	L/2 - 23.3	45°-90°
N00124	2	H - 96.6	90°-90°
ACCESSORIES			
V20000	4	Interlock Foam Plug	4
V42000 *	24	Mechanical Cleat (13mm)	24
V53003	4	Interlock Seal (EPDM)	4
V55000	2	Sub Cill End Caps	2
V58000	4	Interlock End Cap	4
V62000	4	Roller Glazing Packer	4
V70000 *	48	Mechanical Cleat Screw	48
V70001	4	Ø4.2 x 30mm Pozl Pan Polyamide Screw	4
V70002 *	8	Ø4.2 x 16mm Pozl CSK S/Top SS 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	-
T50000/1/2	-	Small Joint Sealant/Adhesive	-
T50003	-	Aluk Sealant Wipes	-
GASKET / PLASTIC PROFILE			
V02000	2H	Co-Extruded Bubble Seal (Q-Lon)	2H
V04000	2L + 4H	38mm Double Glazed U Gasket	2L + 4H
V09000	2H	Outer Frame Bumper Seal	2H
V10000 *	16L + 8H	Outer Frame Sliding Seal/Fin Pile 6.9mmx 6mm	16L + 8H
V31000	2	21mm PVC Interlock Profile	H - 96.6
HARDWARE			
H00100	2	Lateral Locking Handle	2
H00101	2	Lateral Pull Handle	2
H00200	4	Roller Wheels	4
H00400	2	Lateral Lock	2
H00401	2	Lateral Lock Adjustable Keep	2
H00404	2	Lateral Lock Lever	2
GLASS			
Glass unit 38mm	2	L/2 - 49.5	H - 139

* 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.GBR: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720
 * V70002 = Only for Aluk.GBR: XS006

CUTTING LIST



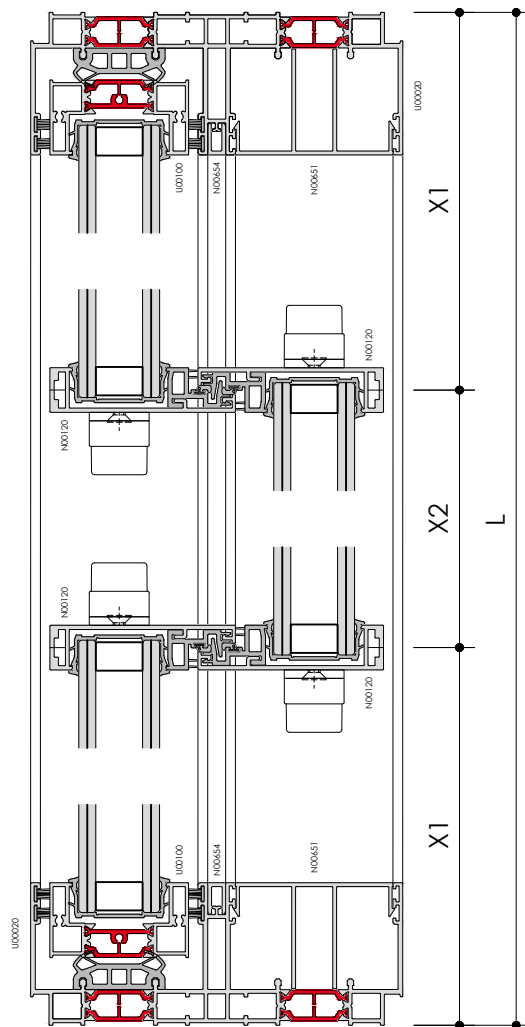
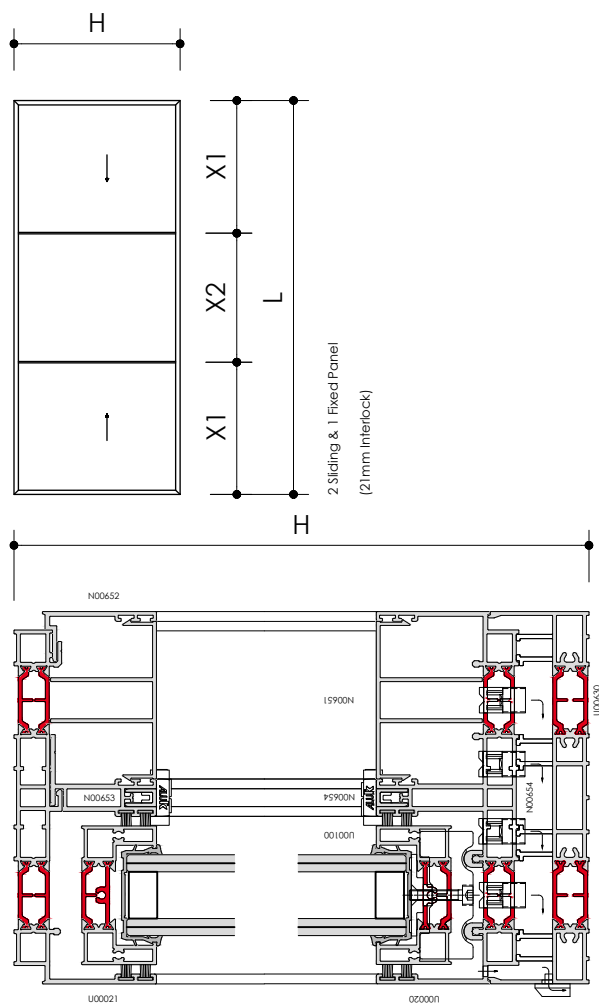
1 Sliding & 1 Fixed Panel
(3 mm Reinforced Interlock)



PROFILE	NO.	SIZE	ANGLE
U00020	2	L	45°-45°
U00020	2	H - 33	45°-45°
U00021	2	L	45°-45°
U00021	2	H - 33	45°-45°
U00630	1	L	90°-90°
U00632	2	L - 44	90°-90°
N00651	2	H - 74.2	90°-90°
N00651	2	L/2 - 82.5	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°-45°
U00100	2	L/2 - 23.3	45°-45°
N00124	2	H - 96.6	90°-90°
ACCESSORIES			
V20000	4	Interlock Foam Plug	QUANTITY
V42000 *	24	Mechanical Cleat (13mm)	24
V50001	2	Fixed Sash Support Blocks	2
V53003	2	Interlock Seal (EPDM)	2
V55000	2	Sub Cill End Caps	2
V58000	2	Interlock End Cap	2
V62000	4	Roller Glazing Packer	4
V70000 *	48	Mechanical Cleat Screw	48
V70001	4	Ø4.2 x 30mm Pozz Pan Polyamide Screw	4
V70002 *	8	Ø4.2 x 16mm Pozz CSK S/Top SS Screw	8
V51001 *	-	Ø10.5mm Hole Plug	-
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	2H	Co-Extruded Bubble Seal (Q-Lon)	SIZE
V04000	2L + 4H	38mm Double Glazed U Gasket	2L + 4H
V09000	2H	Outer Frame Bumper Seal	2H
V10000 *	16L + 8H	Outer Frame Sliding Seal/Fin Pile 6.9mm x 6mm	16L + 8H
V31000	2	21mm PVC Interlock Profile	H - 96.6 90°-90°
HARDWARE			
H00100	1	Lateral Locking Handle	QUANTITY
H00101	1	Lateral Pull Handle	1
H00200	2	Roller Wheels	2
H00400	1	Lateral Lock	1
H00401	1	Lateral Lock Adjustable Keep	1
H00404	1	Lateral Lock Lever	1
GLASS			
Glass unit 38mm	2	L/2 - 49.5	HEIGHT
			H - 139

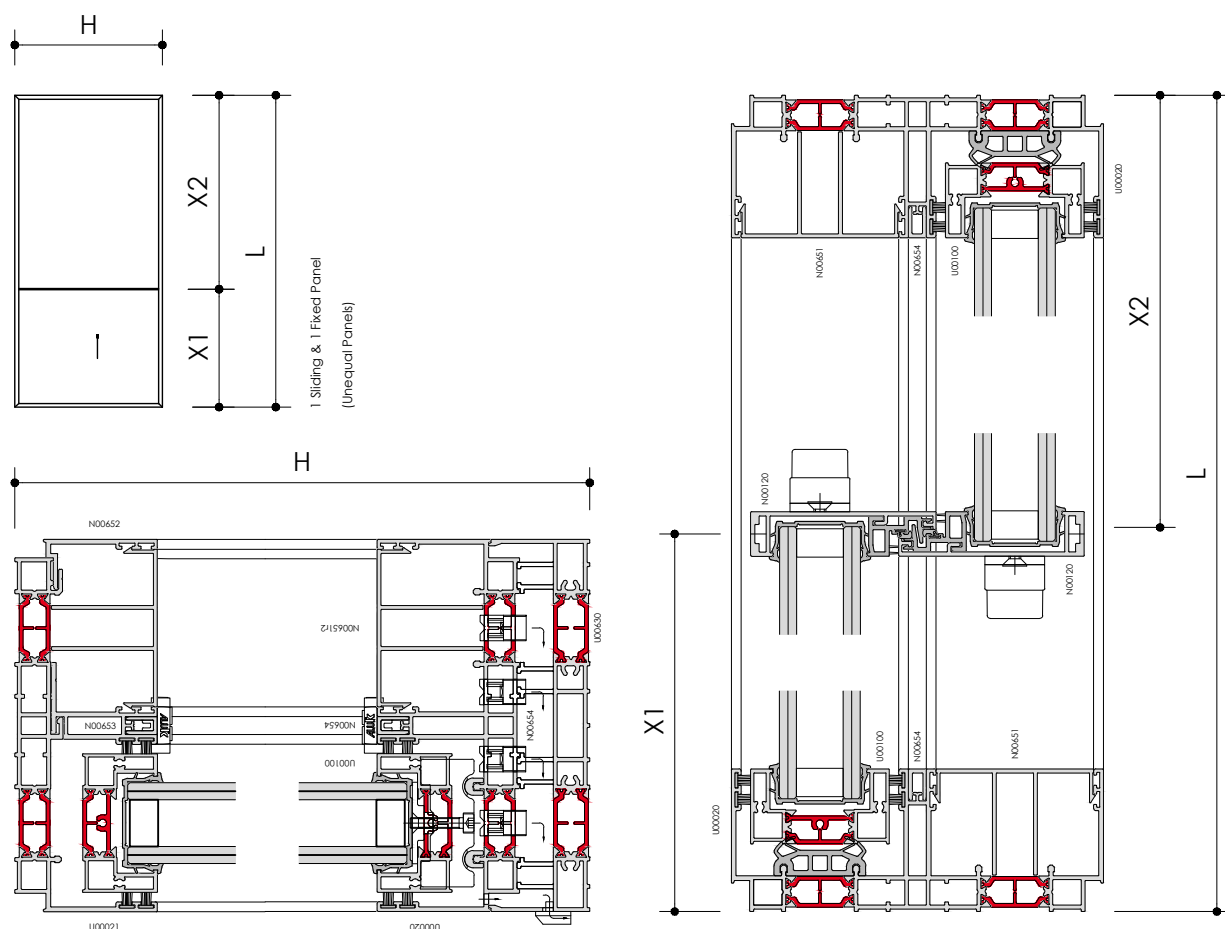
* V10000 = Only for Aluk.GBR: XA621
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.ITA: 709616
 * V51002 = Only for Aluk.ITA: 709617
 * V51003 = Only for Aluk.GBR: 712007
 * V51004 = Only for Aluk.FRA: 27500
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720
 * V70002 = Only for Aluk.GBR: XS006

CUTTING LIST



PROFILE	NO.	SIZE	ANGLE
U00020	2	L	45°-45°
U00020	2	H - 33	45°-45°
U00021	1	L	45°-45°
U00630	1	L	90°-90°
N00632	4	L - 44	90°-90°
N00651	2	H - 74.2	90°-90°
N00652	1	L - 26.8	45°-45°
N00653	1	L - 33.6	45°-45°
N00654	6	(L - 176)/3	90°-90°
N00654	2	H - 167	90°-90°
U00100	2	H - 96.6	45°-45°
U00100	2	(L - 134)/3 + 43.7	45°-90°
U00100	2	(L - 134)/3 - 43.7	45°-90°
U00100	2	(L - 134)/3 + 17	90°-90°
N00121	4	H - 96.6	90°-90°
ACCESSORIES			QUANTITY
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	2	
V58000	Interlock End Cap	8	
V62000	Roller Glazing Packer	6	
V70000 *	Mechanical Cleat Screw	48	
V70001	Ø4.2 x 30mm Pozz Pan Polyamide Screw	8	
V70002 *	Ø4.2 x 16mm Pozz CSK S/Top SS 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	-	
T50000/1/2	Small Joint Sealant/Adhesive	-	
T50003	Aluk Sealant Wipes	-	
GASKET / PLASTIC PROFILE			SIZE
V02000	Co-Extruded Bubble Seal (Q-Lon)	2H	
V04000	38mm Double Glazed U Gasket	2L + 6H	
V09000	Outer Frame Bumper Seal	2H	
V10000 *	Outer Frame Sliding Seal/Fin Pile 6.9mmx 6mm	1L + 8H	
V31000	21mm PVC Interlock Profile	H - 96.6	90°-90°
HARDWARE			QUANTITY
H00100	Lateral Locking Handle	2	
H00101	Lateral Pull Handle	2	
H00200	Roller Wheels	4	
H00400	Lateral Lock	2	
H00401	Lateral Lock Adjustable Keep	2	
H00404	Lateral Lock Lever	2	
GLASS			WIDTH
Glass unit 38mm	2	L2 - 49.5	H - 139
Glass unit 38mm	1	L3 + 7	H - 139

* 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
 * V70002 = Only for Aluk.GBR: X5006



PROFILE	NO.	SIZE	ANGLE
U00020	2	L	45°-45°
2 Track Outer Frame			
U00020	2	H - 33	45°-45°
2 Track Outer Frame			
U00021	1	L	45°-45°
2 Track Outer Frame (Head)			
U00030	1	L	90°-90°
Drainage Sub Cill			
N00632	2	L - 44	90°-90°
Aluminium Track			
N00651	2	H - 74.2	90°-90°
Outer Frame Cover Profile			
N00651	2	X1 - 77.5	90°-90°
Outer Frame Cover Profile (X1)			
N00652	1	L - 26.8	45°-45°
Internal Rebate			
N00653	1	L - 33.6	45°-45°
Central Rebate			
N00654	2	X1 - 77.5	90°-90°
Connector Clip			
N00654	2	X2 - 77.5	90°-90°
Connector Clip			
N00654	2	H - 167	90°-90°
Connector Clip			
U00100	2	H - 96.6	45°-45°
Double Glazed Sash			
U00100	2	X1 - 23.3	45°-90°
Double Glazed Sash (X1)			
U00100	2	X2 - 23.3	45°-90°
Double Glazed Sash (X2)			
N00120	2	H - 96.6	90°-90°
21mm Interlock Profile			
ACCESSORIES			QUANTITY
V20000	Interlock Foam Plug		
V42000 *	Mechanical Cleat (13mm)		
V50001	Fixed Sash Support Blocks		24
V53003	Interlock Seal (EPDM)		2
V55000	Sub Cill End Caps		2
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
V70002 *	Ø4.2 x 16mm Pozl CSK S/Top SS Screw		8
V51001 *	Ø10.5mm Hole Plug		-
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		-
G50003	Aluk Sealant Wipes		-
TASKSET / PLASTIC PROFILE		NO.	SIZE
V02000	Co-Extruded Bubble Seal (Q-Lon)		
V04000			2H
V09000	Outer Frame Bumper Seal		2L + 4H
V10000 *	Outer Frame Sliding Seal/Fin Pile 6.9mmx 6mm		2H
V31000	21mm PVC Interlock Profile	2	16L + 8H
HARDWARE			QUANTITY
H00100	Lateral Locking Handle		
H00101	Lateral Pull Handle		1
H00200	Bottom Adjustable Glazed U Gasket		1
H00400	Lateral Lock		2
H00401	Lateral Lock Adjustable Keep		1
H00404	Lateral Lock Lever		1
GLASS		NO.	WIDTH
Glass unit 38mm		2	X1 Or X2 - 49.5
			HEIGHT
			H - 139

- * 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
- * V70002 = Only for Aluk.FRA: XS006

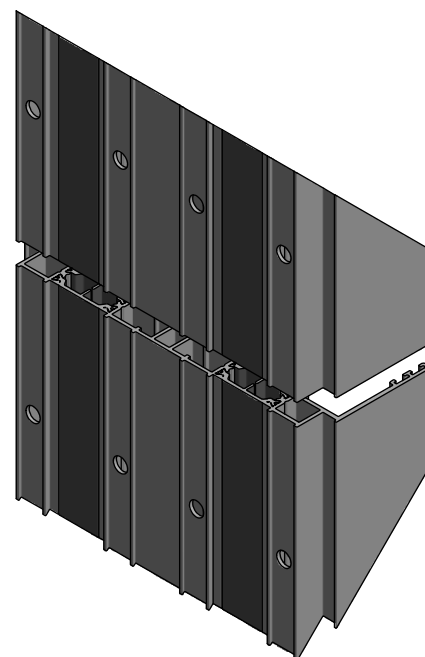
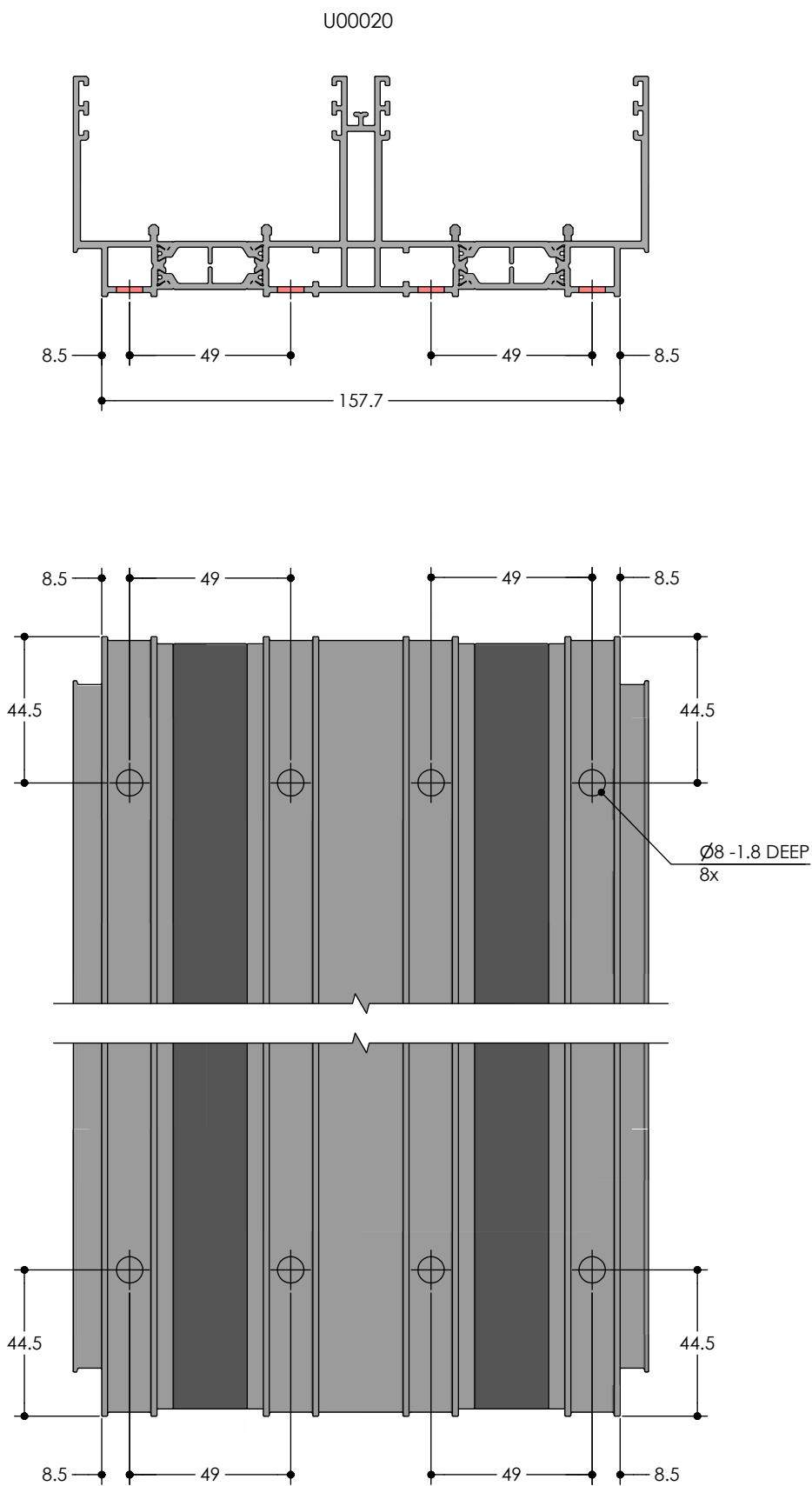


SECTION 9 MACHINING

MACHINING

» INLINE SLIDING DOOR

➤ U00020 - MECHANICAL CLEAT



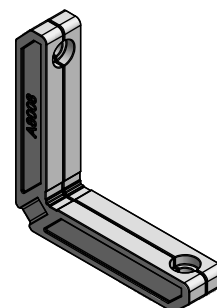
* ALUK FR CODE: 27500

** ALUK FR CODE: 86720

Use cleat and screw ref:

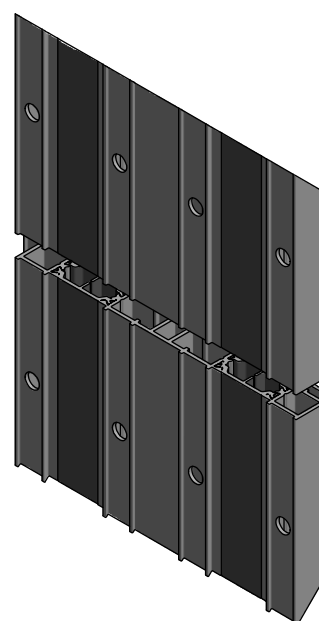
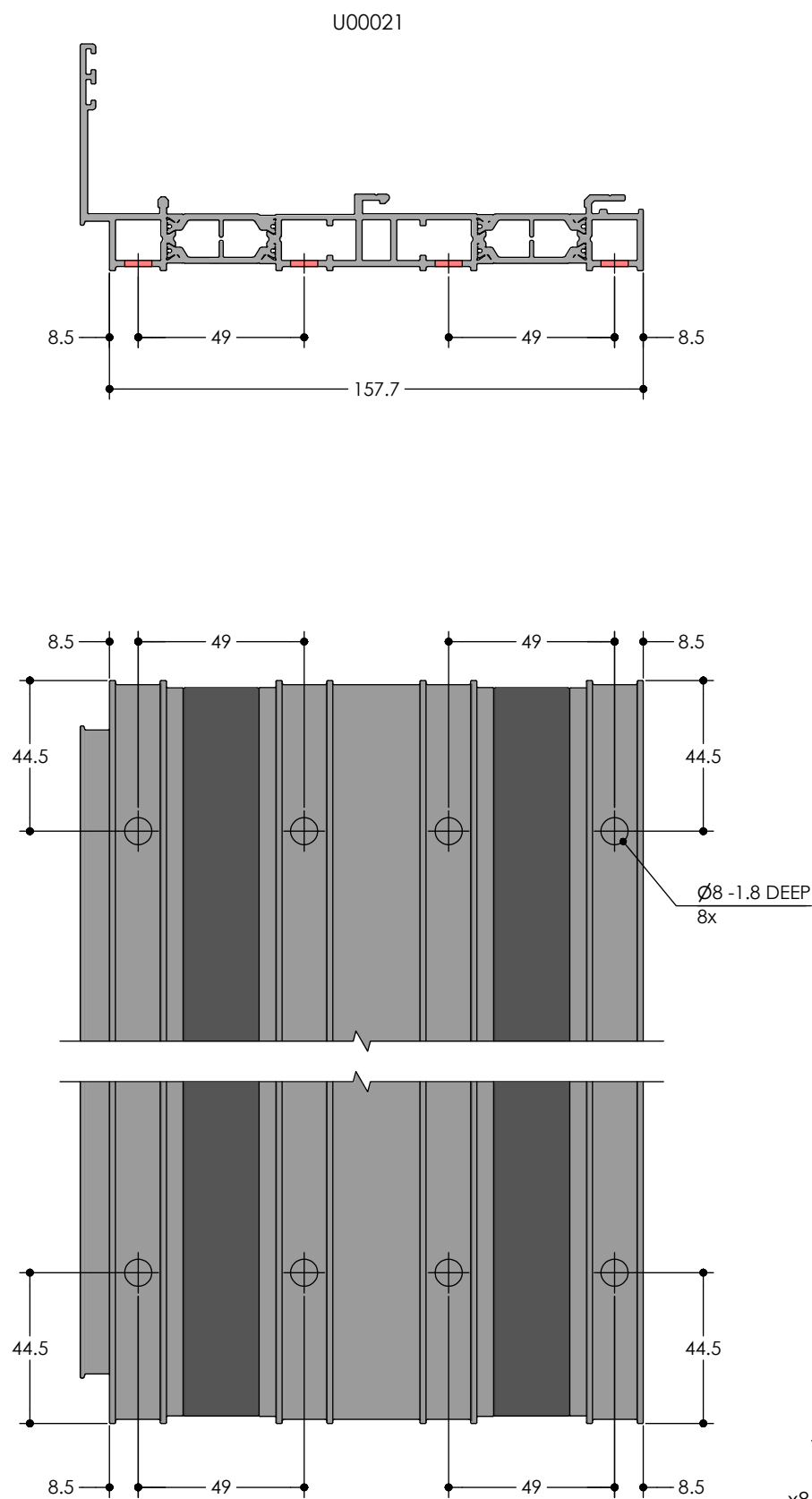


V70000**
x8 Per Corner



V42000*
x4 Per Corner

➤ U00021 - MECHANICAL CLEAT

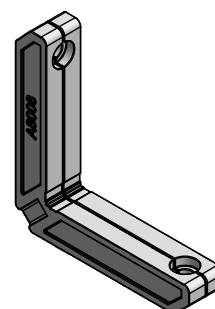


* ALUK FR CODE: 27500
** ALUK FR CODE: 86720

Use cleat and screw ref:

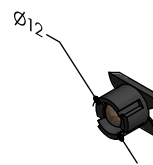
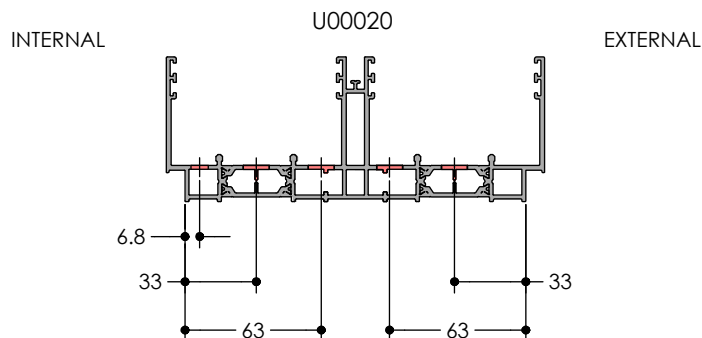


V70000**
x8 Per Corner



V42000*
x4 Per Corner

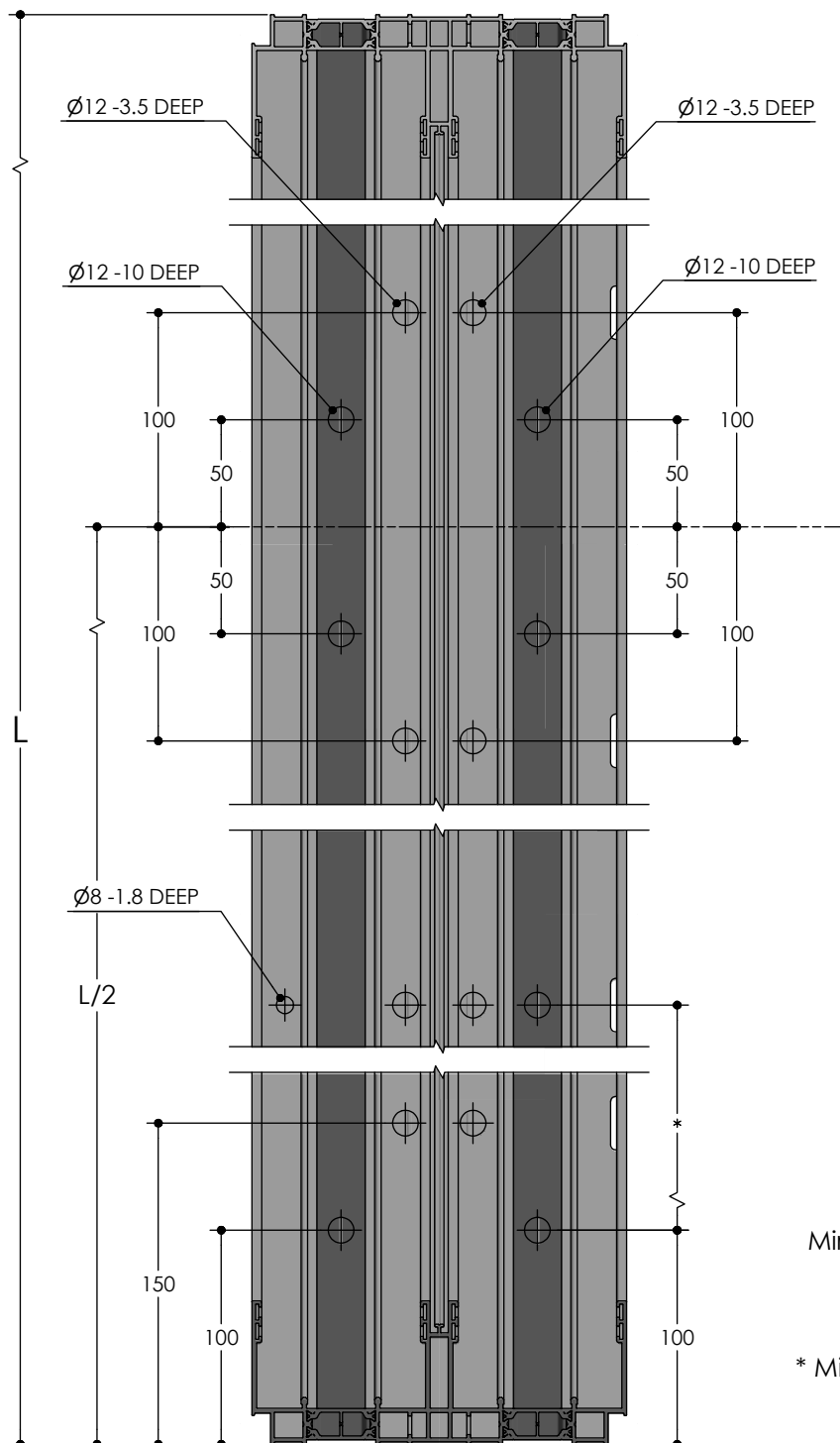
U00020 - DRAINAGE



V51005*

Drainage Valve

* ALUK GBR CODE: A-00-225

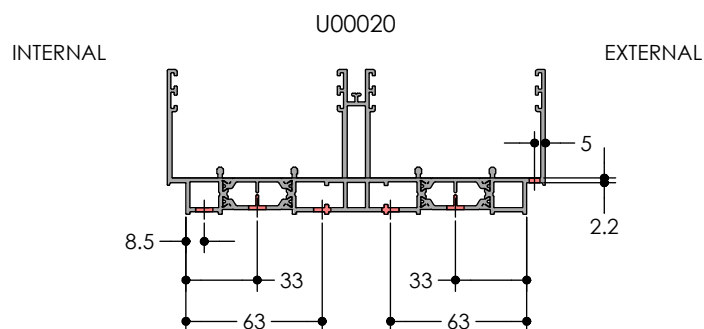


IMPORTANT:

Mirror all drainage holes around centre line / mid-point of each interlock.

* Mid point between the end and centre line of the outer frame profile.

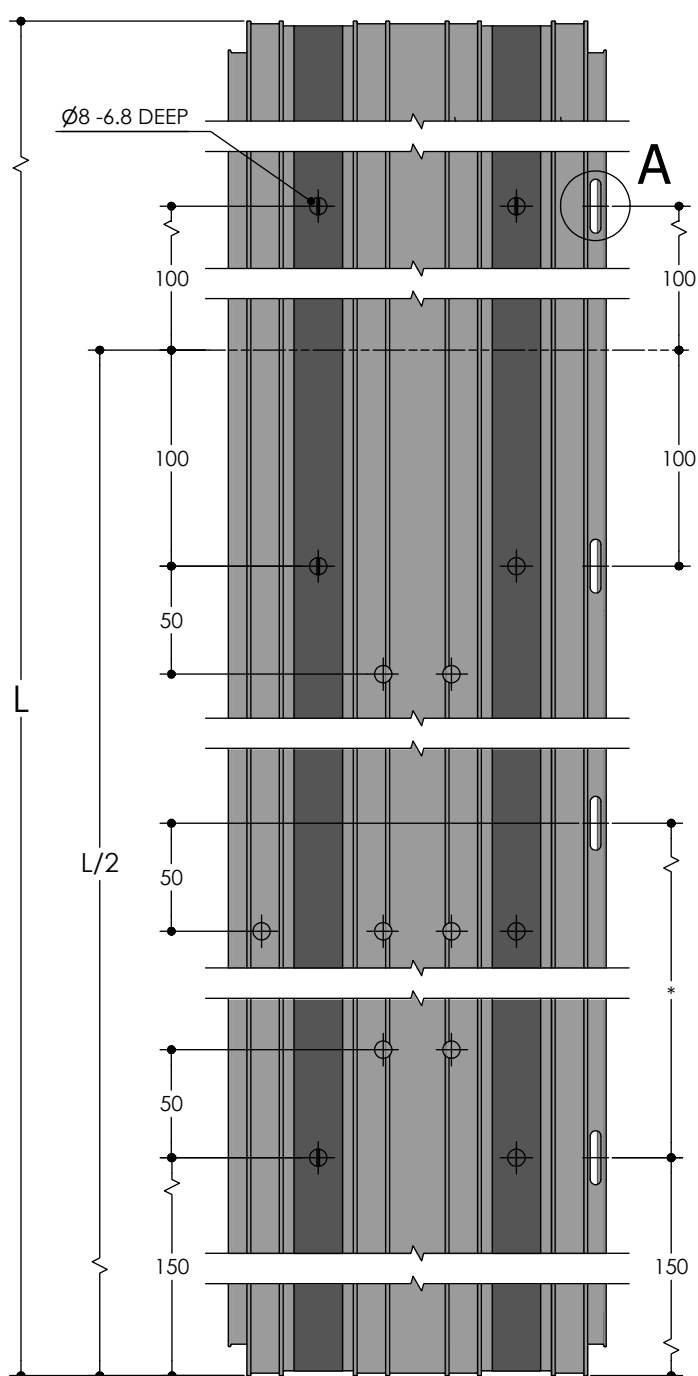
➤ U00020 - DRAINAGE CONT.



IMPORTANT:

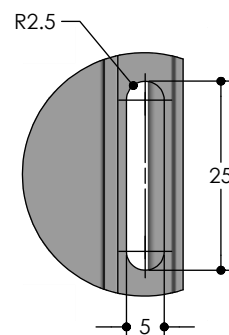
Ø8 holes offset by 50mm from top
Ø12mm holes.

Mirror all drainage holes around
centre line /
mid-point of each interlock.



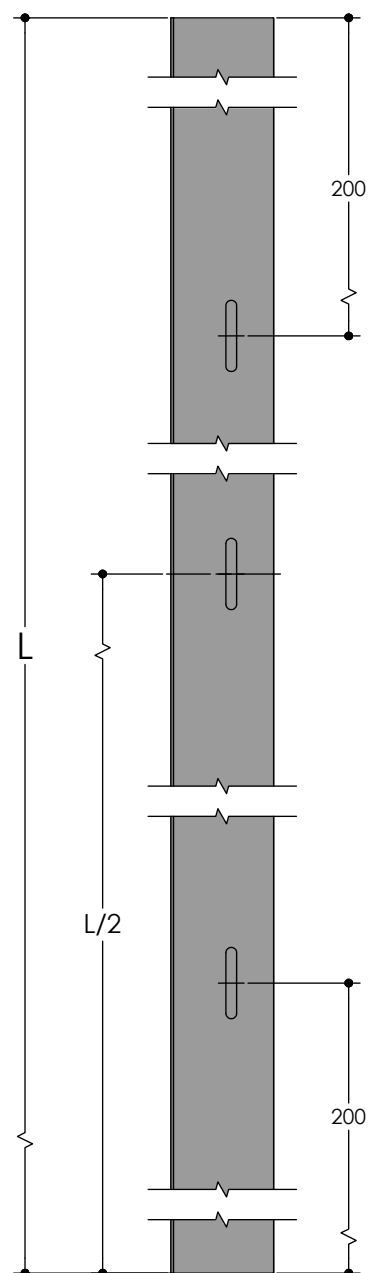
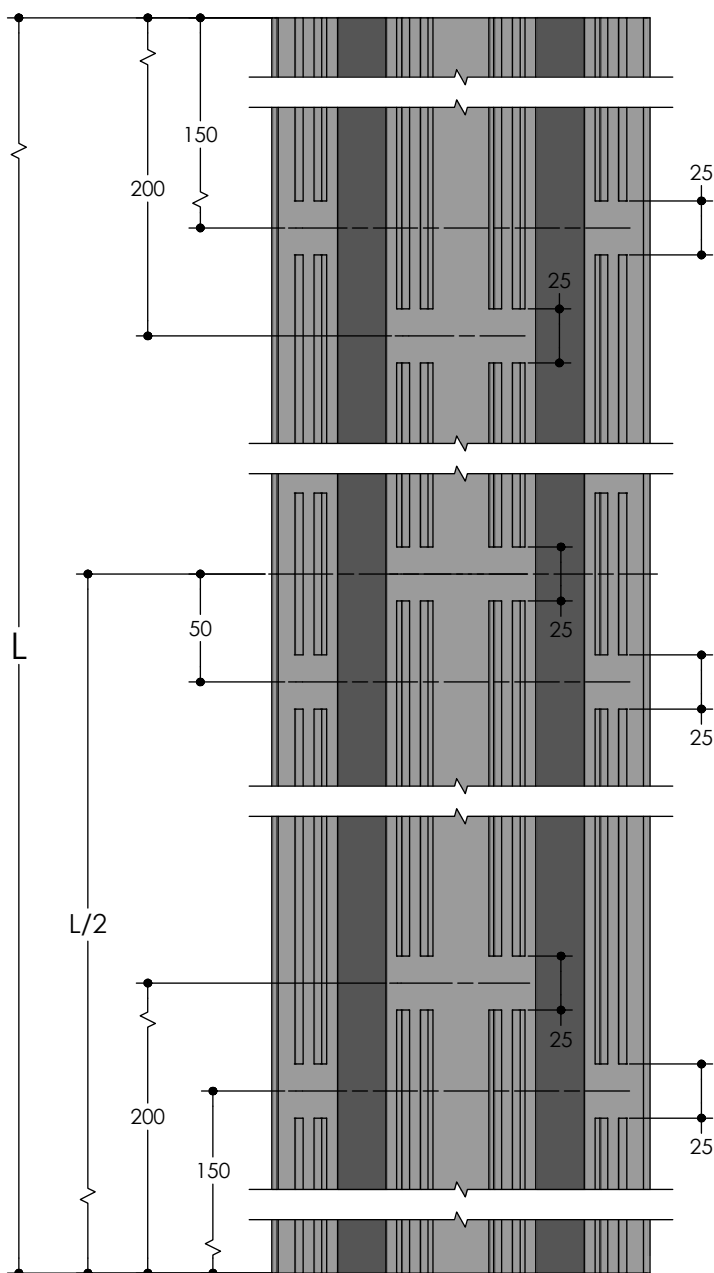
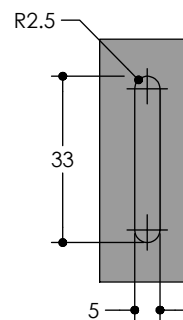
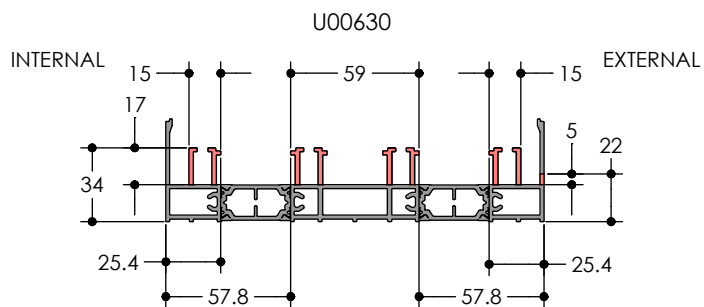
A

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



▶ U00630 - DRAINAGE

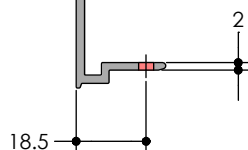
Slot depth 1.8mm through 1 wall.



NOTE: Mirror all drainage holes around centre line / mid-point of each interlock.

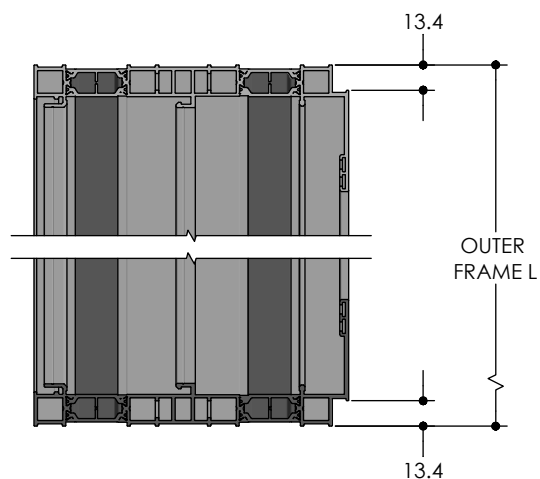
➤ N00652 - INTERNAL REBATE

N00652

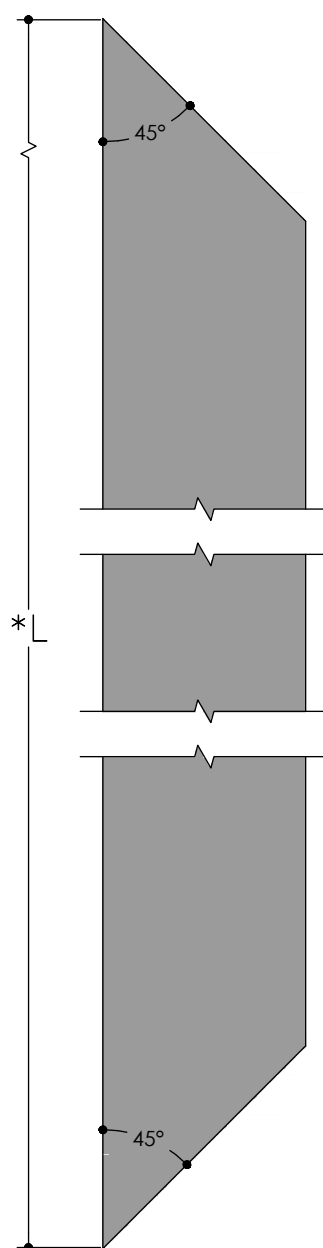
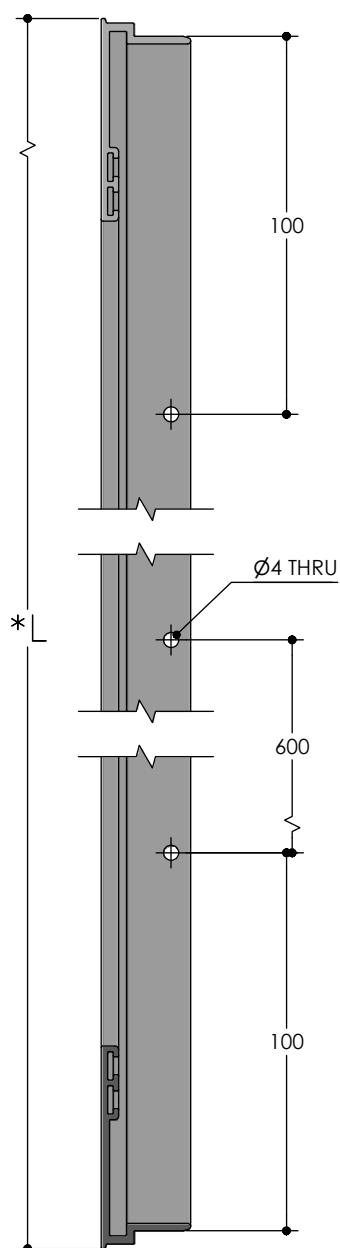


IMPORTANT:

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

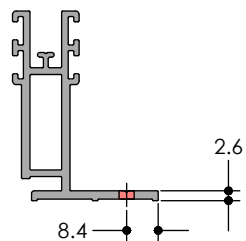


*L = OUTER FRAME L - 26.8



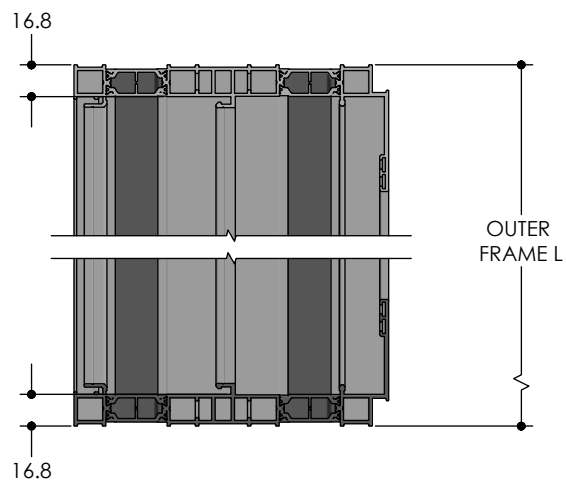
➤ N00653 - CENTRAL REBATE

N00653

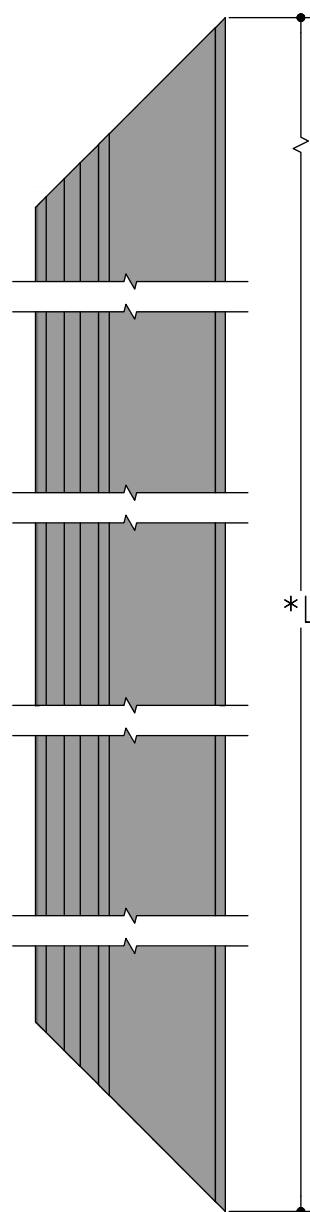
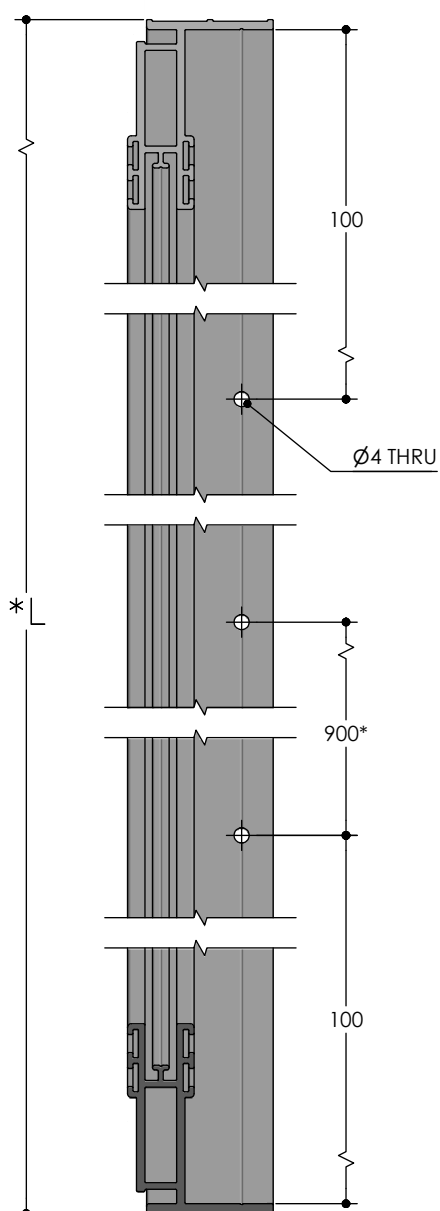


IMPORTANT:

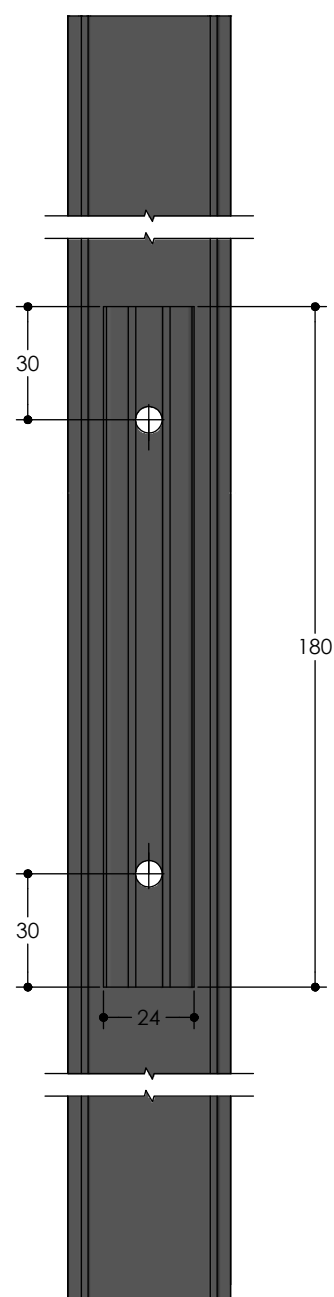
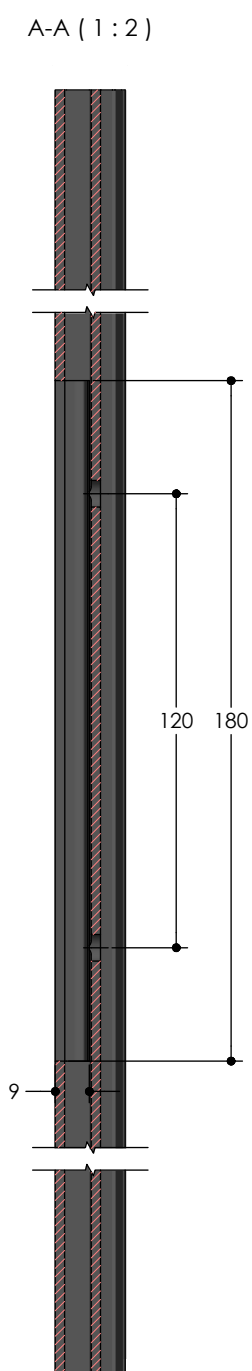
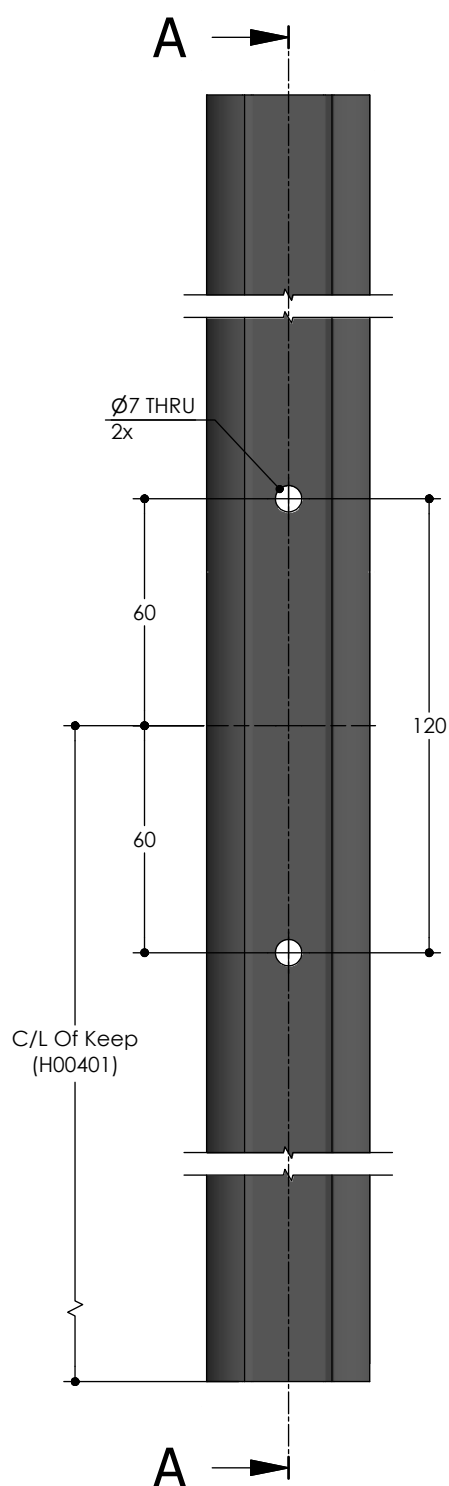
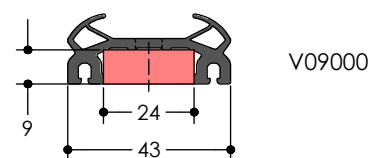
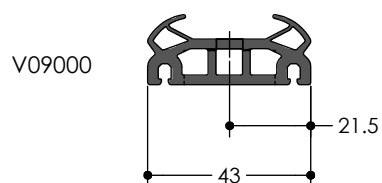
Continue Ø3mm holes at 900mm centres along full length of N00653



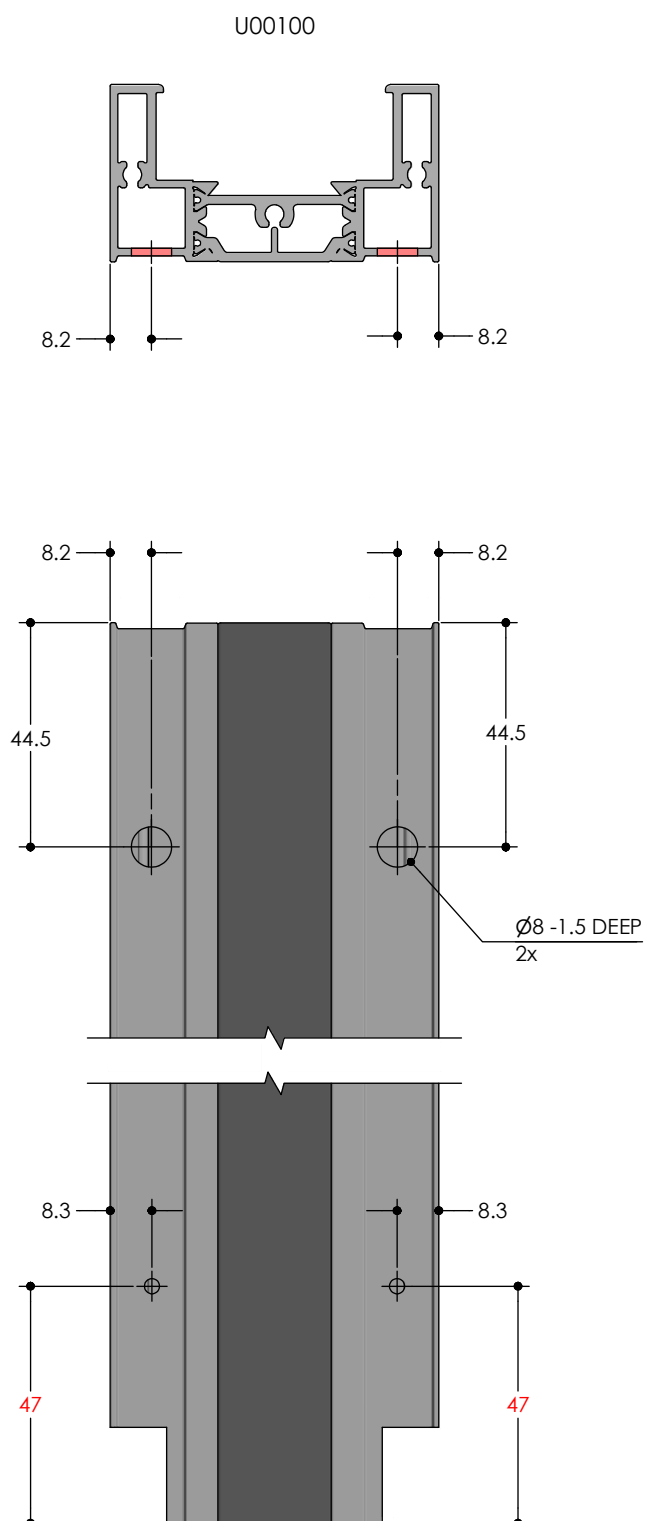
$$*L = \text{OUTER FRAME L} - 33.6$$



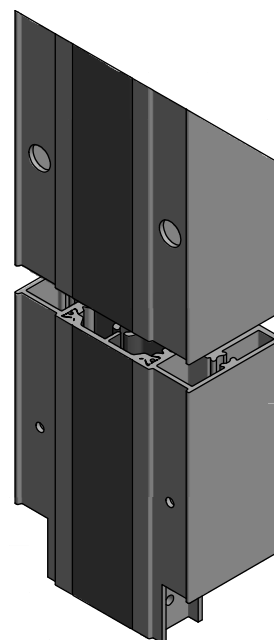
➤ V09000 - KEEP CUT OUT



➤ U00100 - HEAD/CILL CLEAT MACHINING



When using N00124 interlock
dimension equals 57mm.

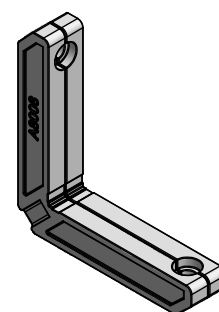


* ALUK FR CODE: 27500
** ALUK FR CODE: 86720

Use cleat and screw ref:

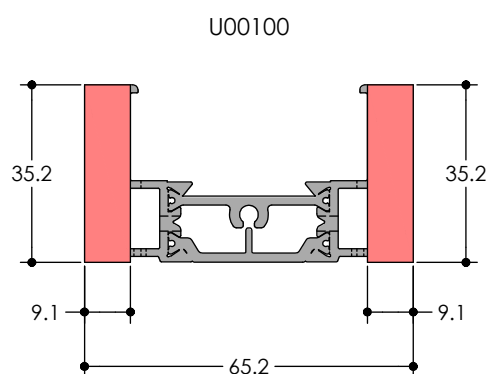


V70000*
x8 Per Corner



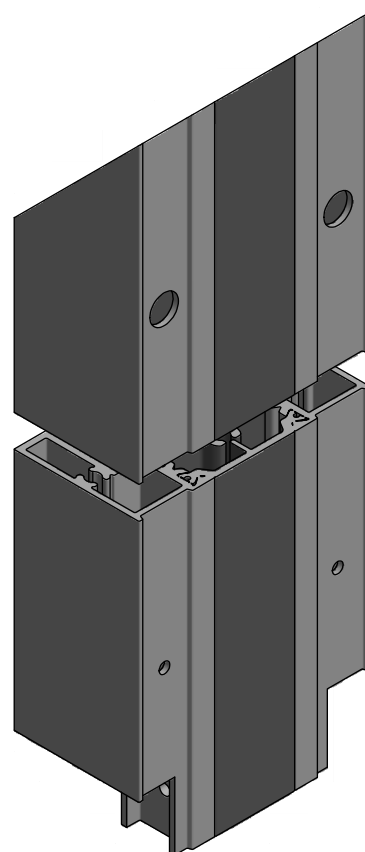
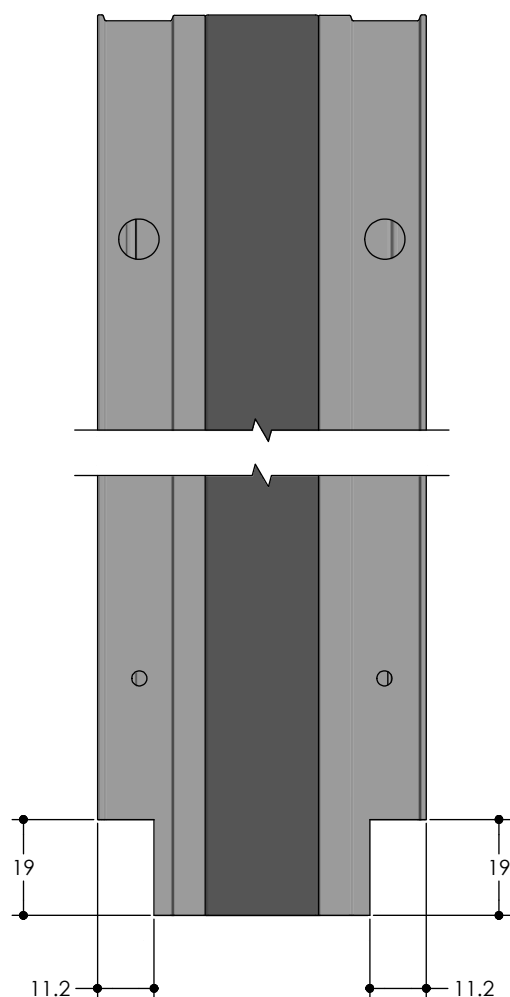
V42000*
x4 Per Corner

➤ U00100 - HEAD/CILL END MILLING

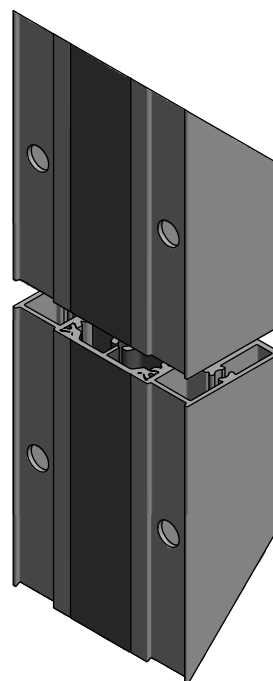
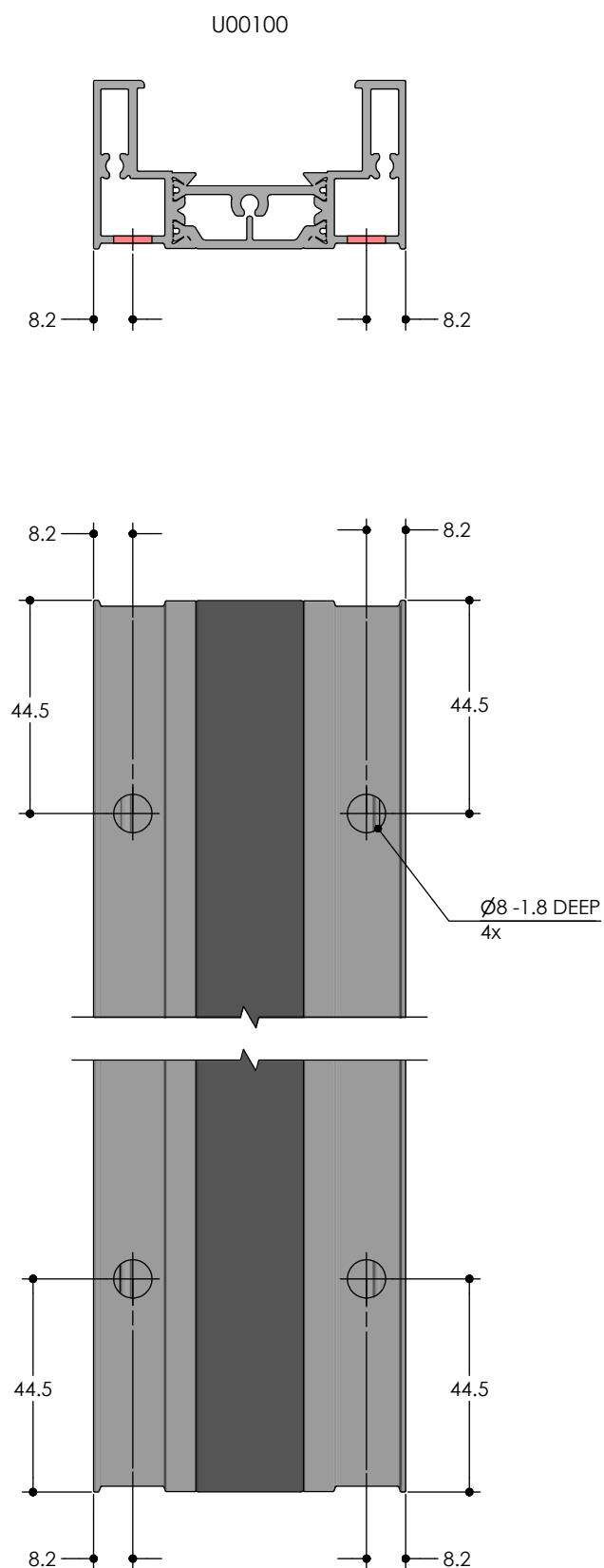


NOTE:

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



➤ U00100 - JAMB CLEAT MACHINING

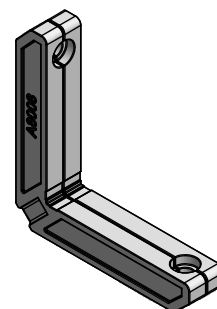


* ALUK FR CODE: 27500
** ALUK FR CODE: 86720

Use cleat and screw ref:



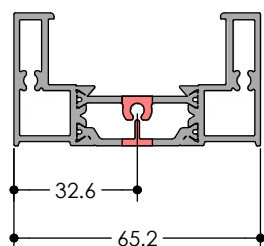
V70000**
x8 Per Corner



V42000*
x4 Per Corner

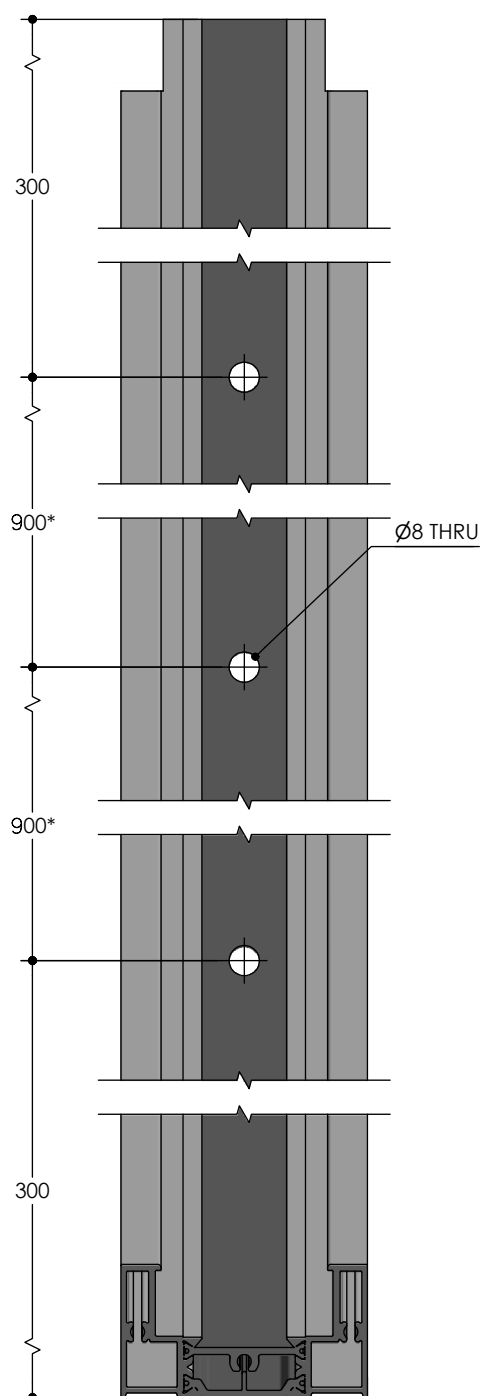
➤ U00100 - DRAINAGE HOLES

U00100

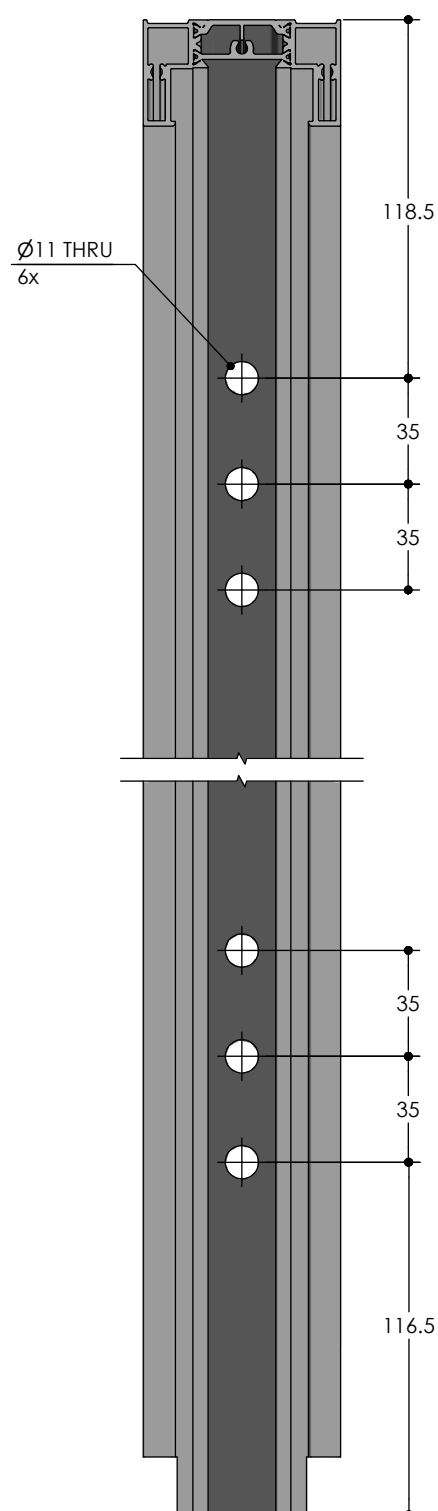
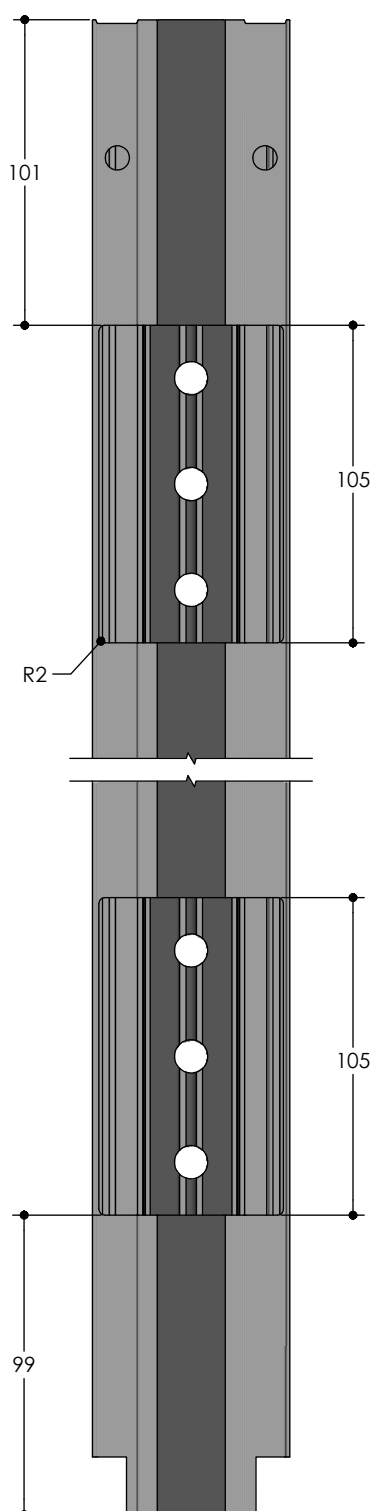
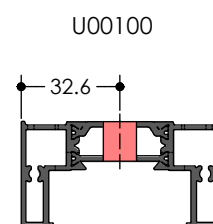
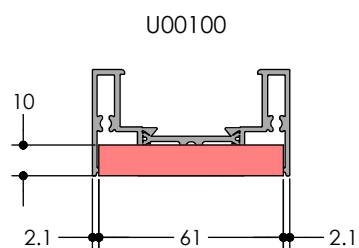


NOTE:

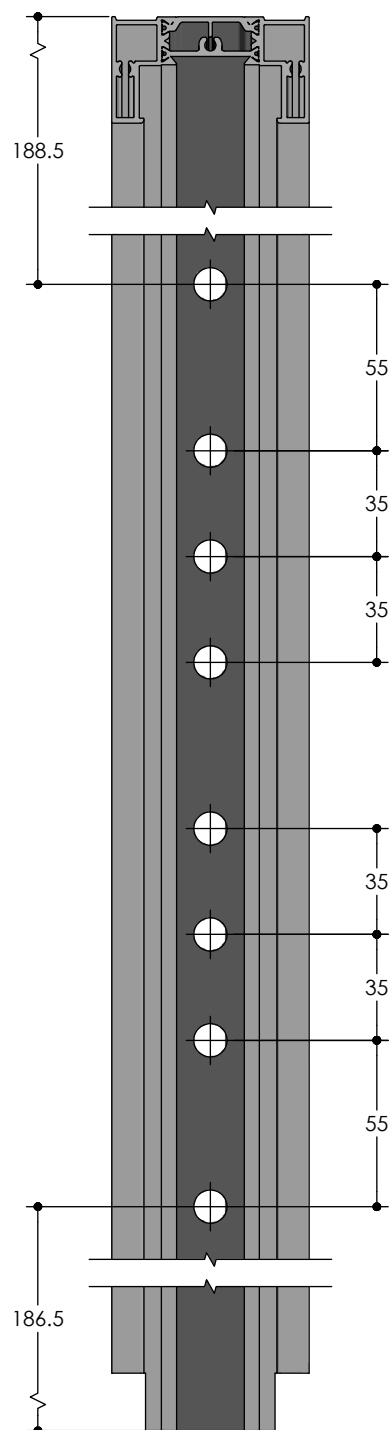
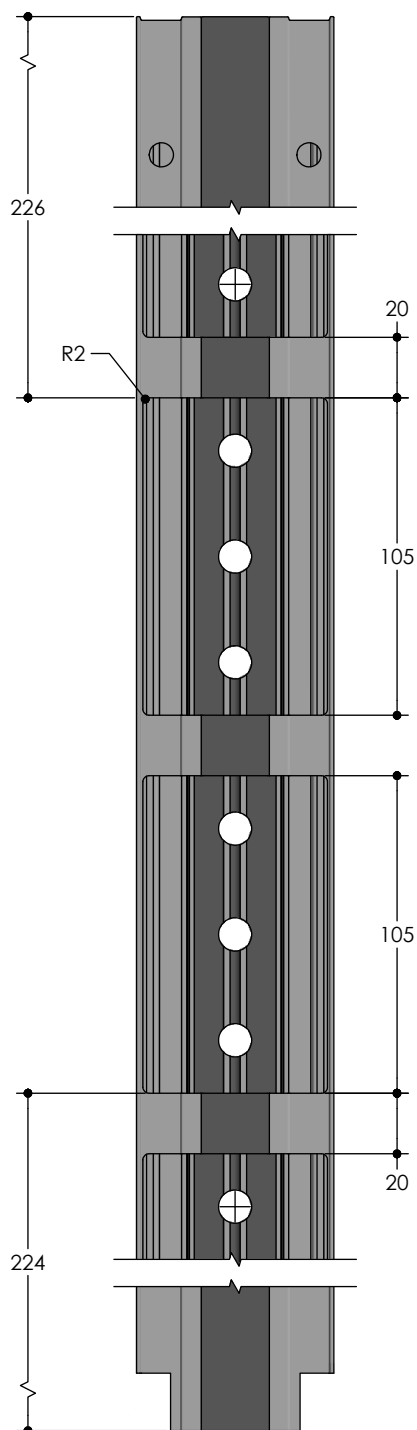
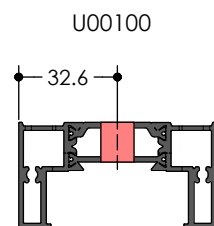
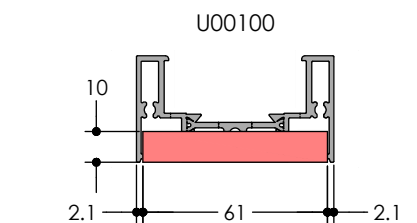
Continue @ 900mm
centres on bottom
profile only.



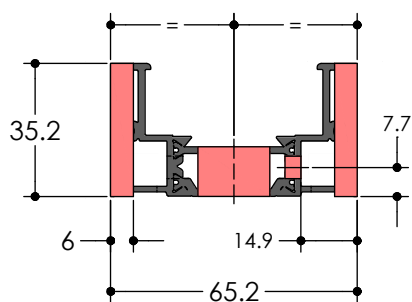
➤ U00100 - 2 ROLLERS (H00200 & V62000)



➤ U00100 - 4 ROLLERS (H00200 & V62000)

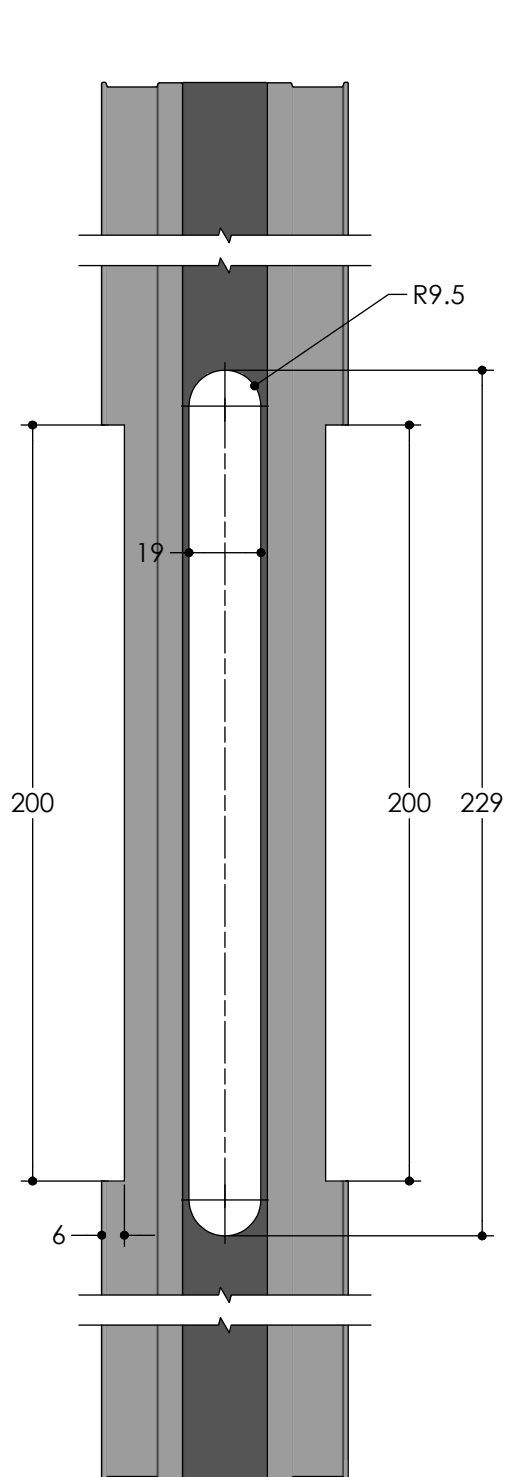


➤ U00100 - LOCK & HANDLE MACHINING

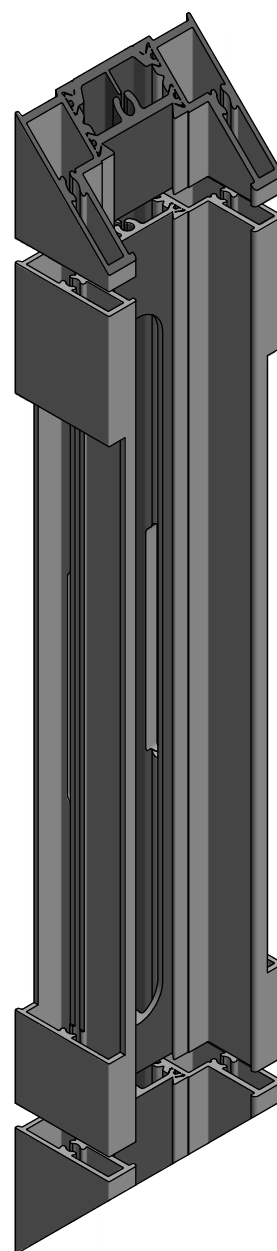
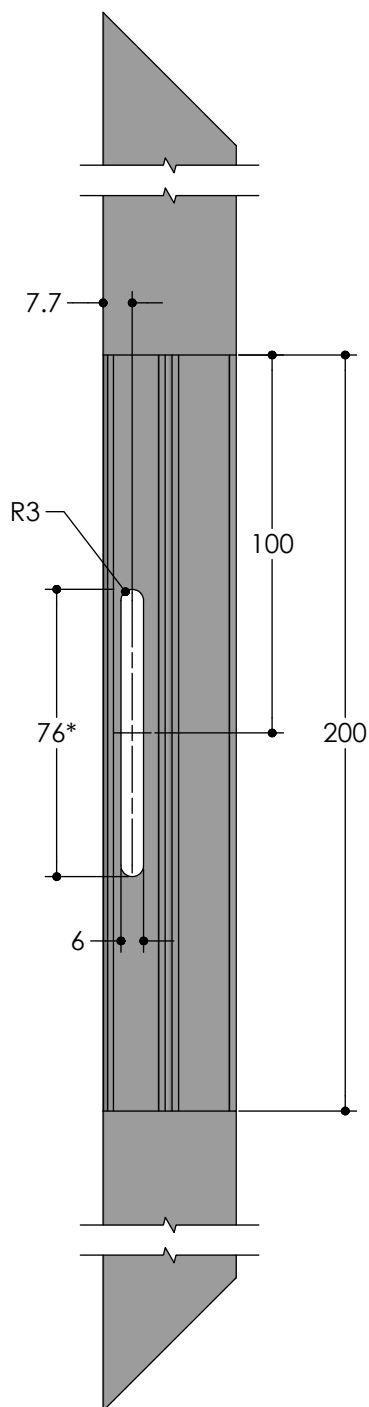


NOTE:

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



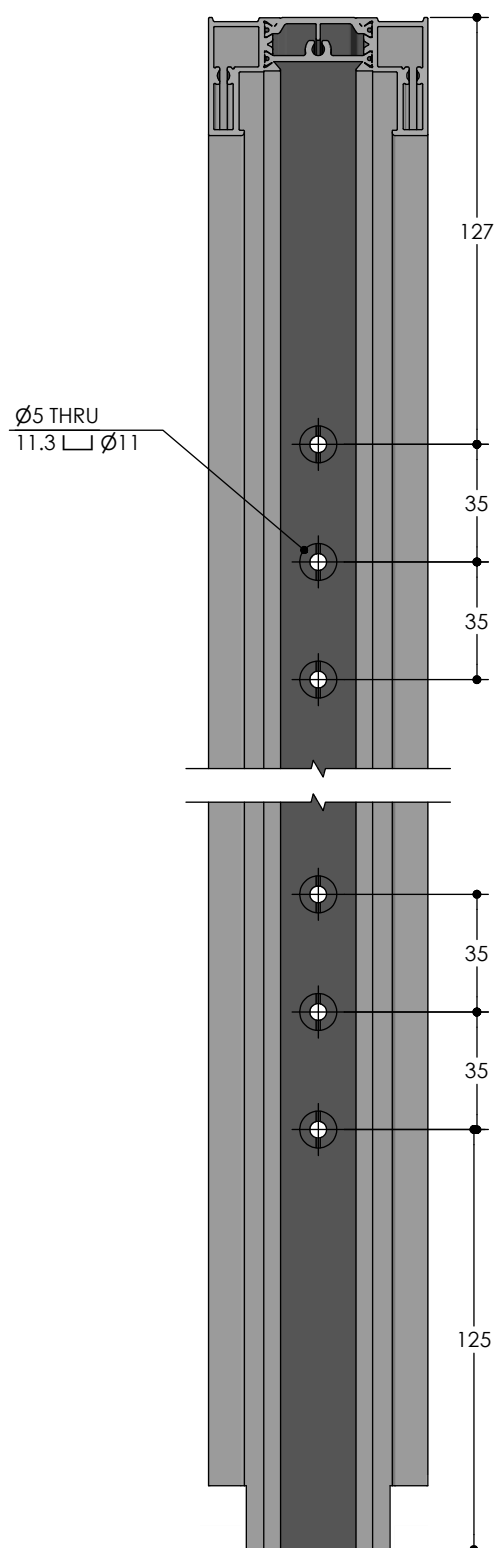
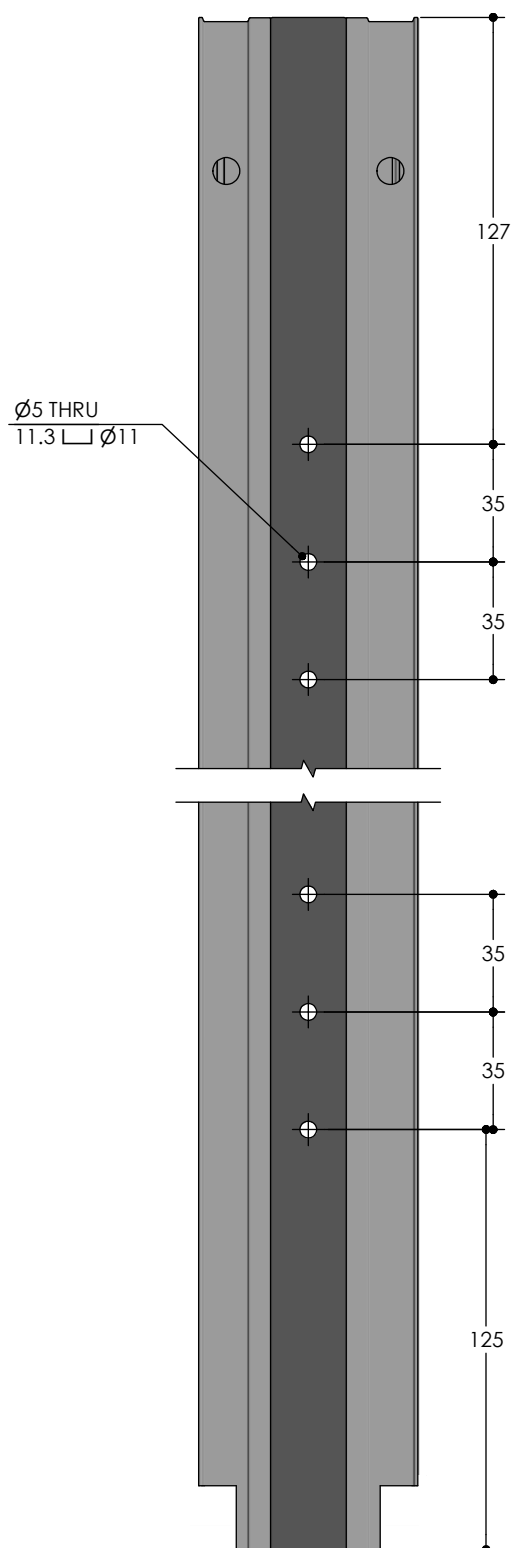
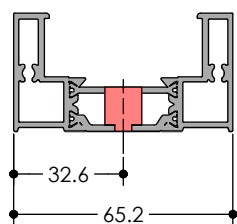
INTERNAL SIDE



* Slot depth 4.2mm

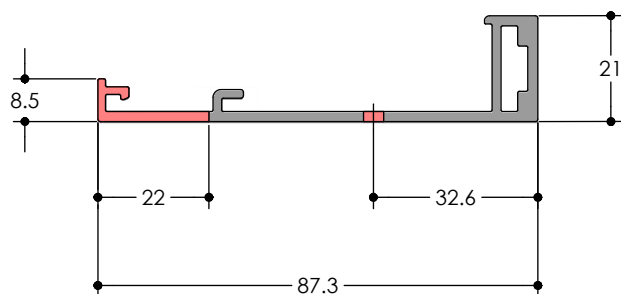
➤ U00100 - FIXED PANEL SUPPORT BLOCKS

U00020



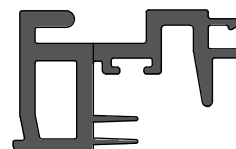
➤ N00120 - STANDARD INTERLOCK

N00120

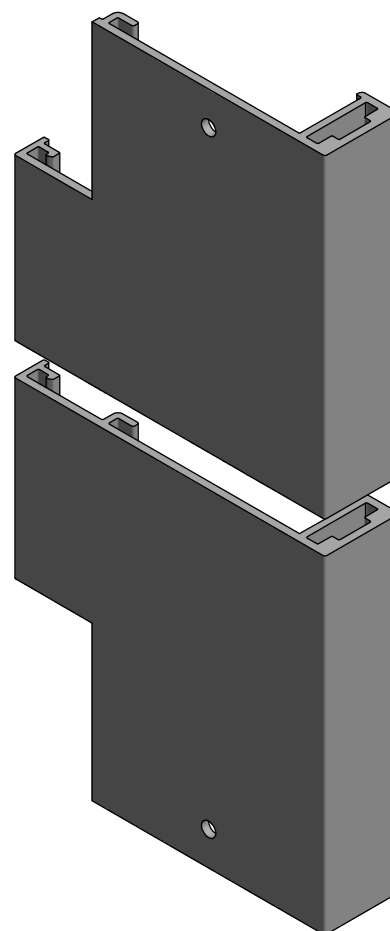
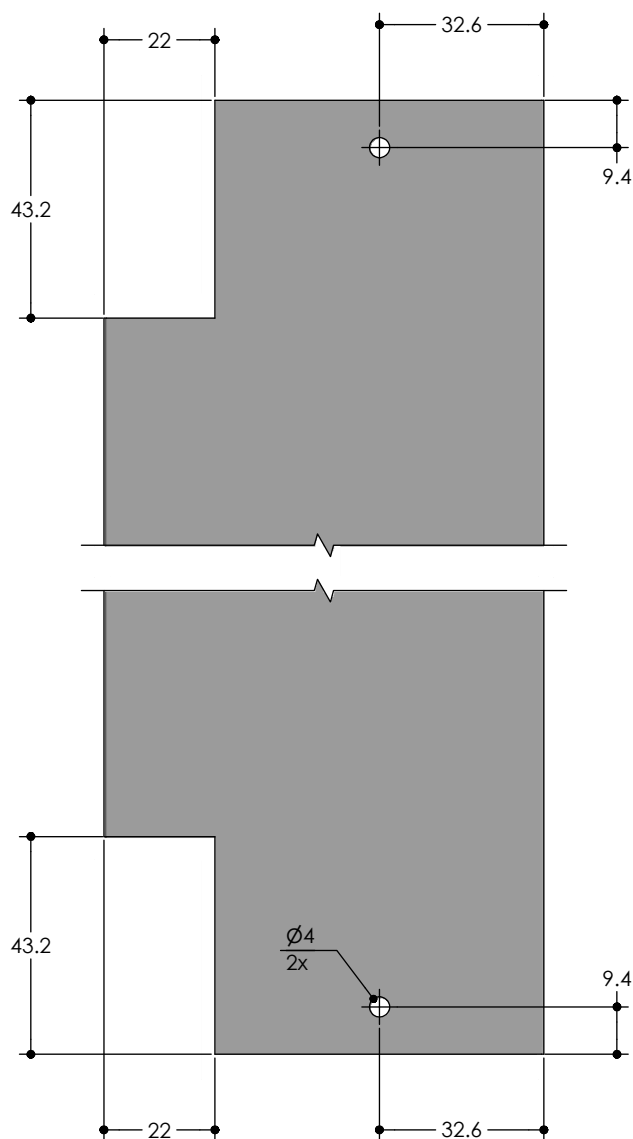


NOTE:

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

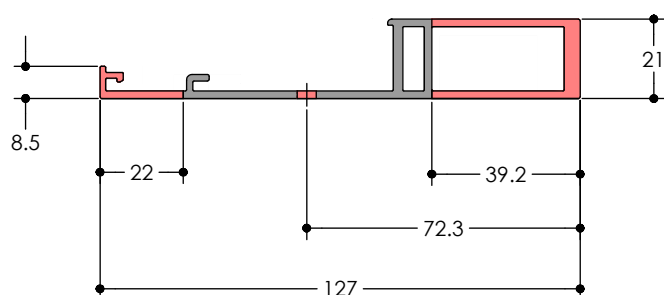


V31000



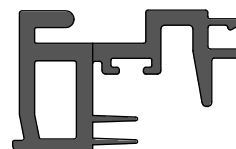
➤ N00121 - REINFORCED INTERLOCK

N00121

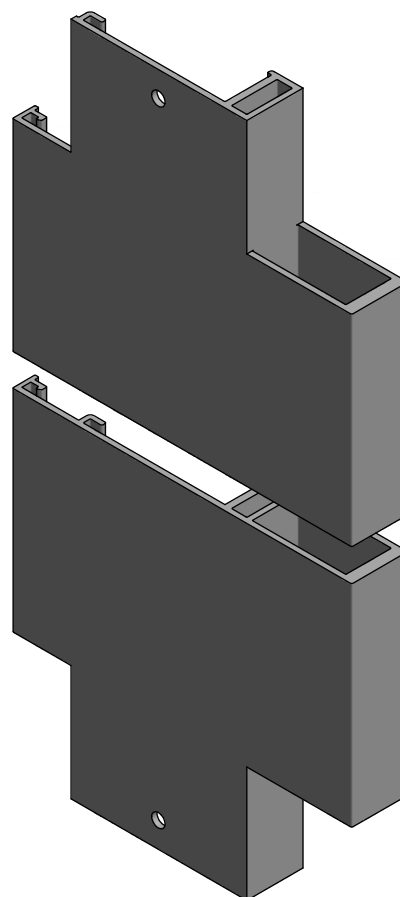
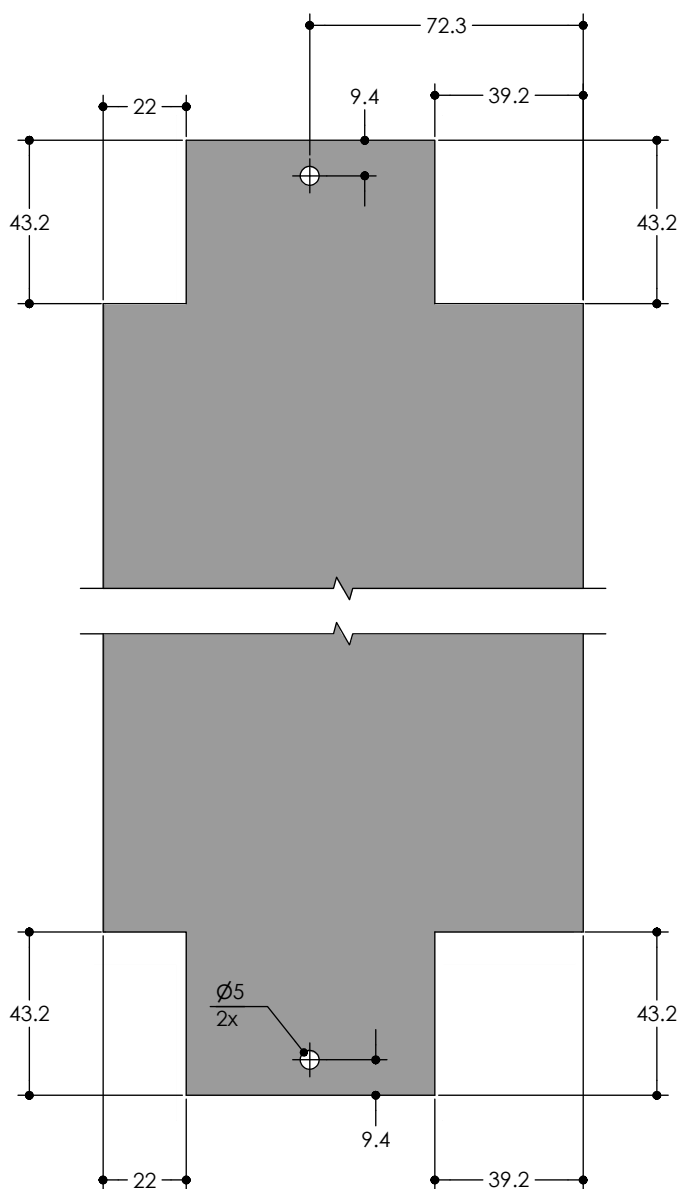


NOTE:

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

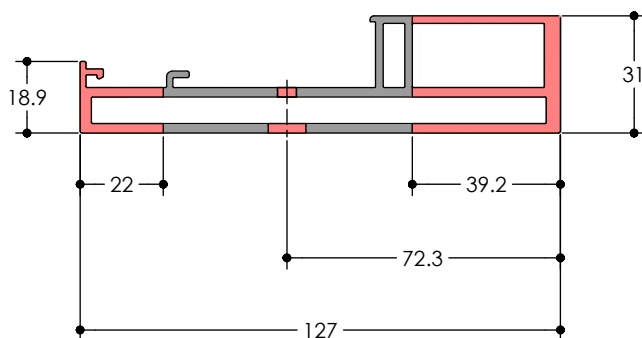


V31000



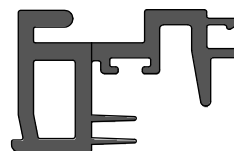
➤ N00124 - REINFORCED INTERLOCK

N00124

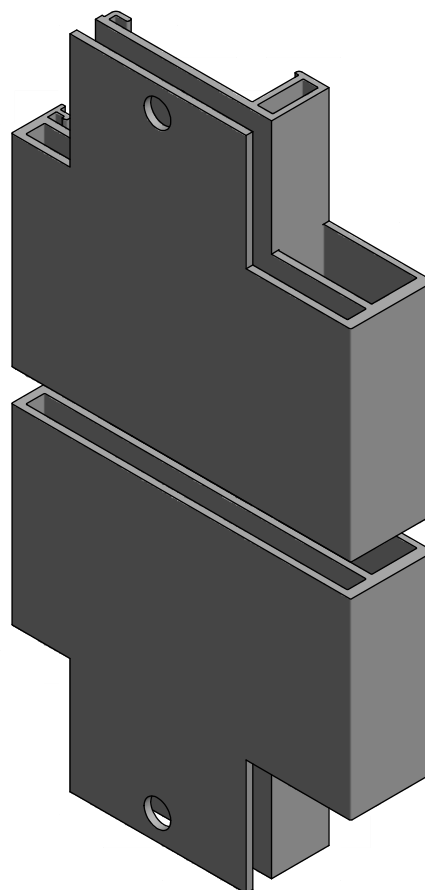
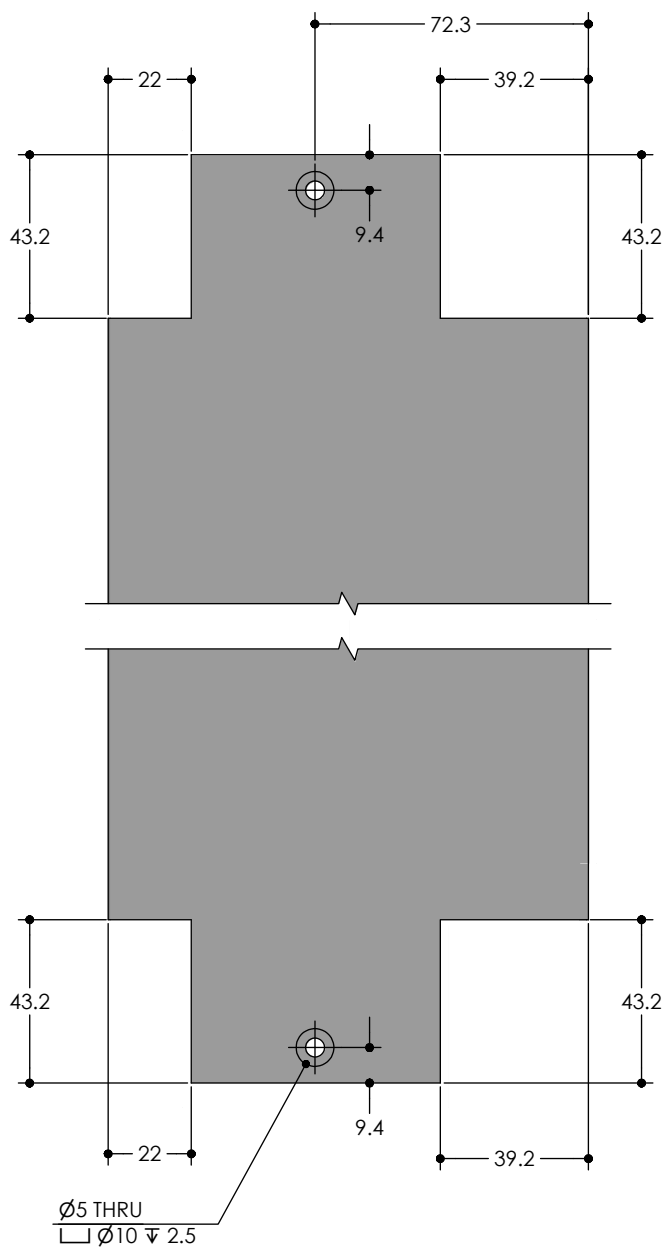


NOTE:

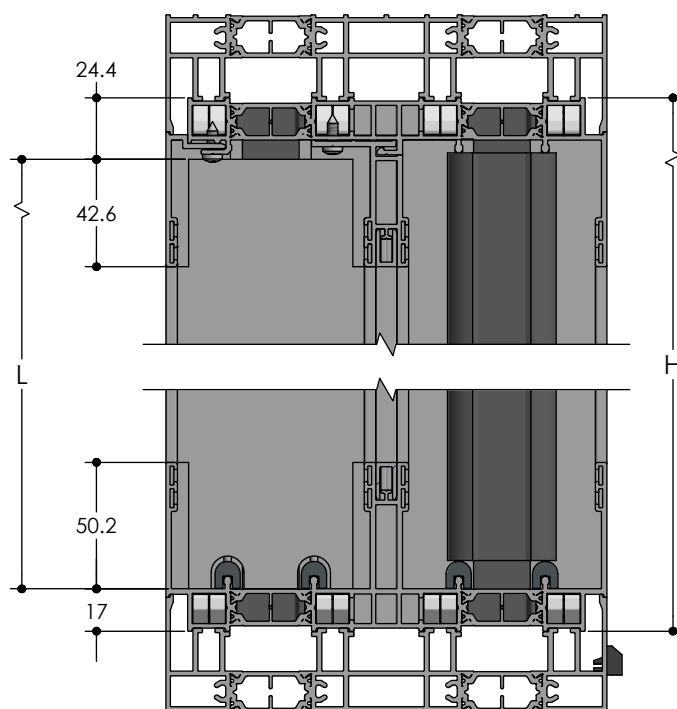
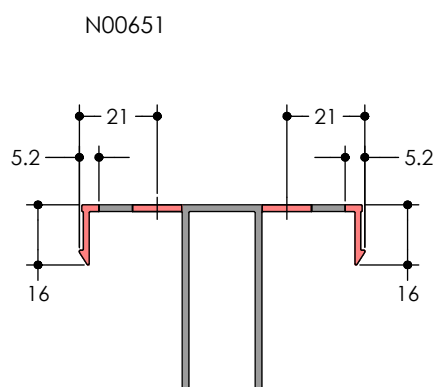
Insert V31000 (PVC Interlock) into N00120 before machining together.



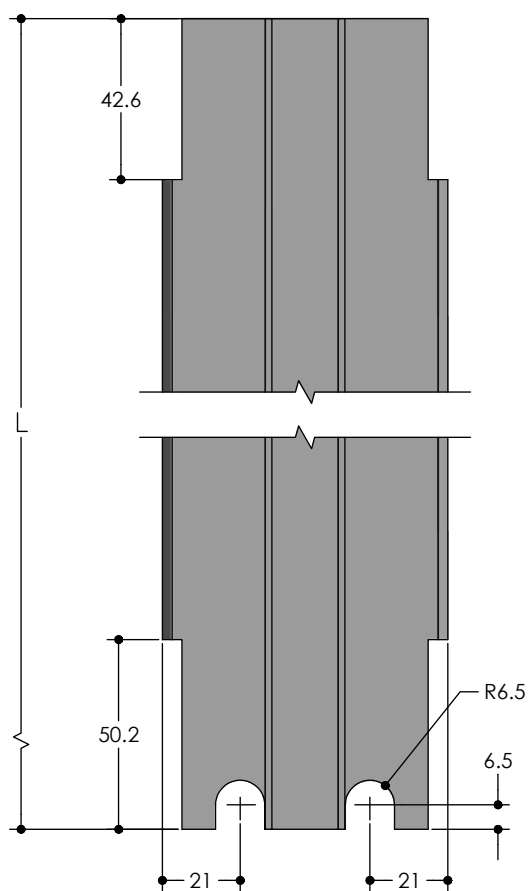
V31000



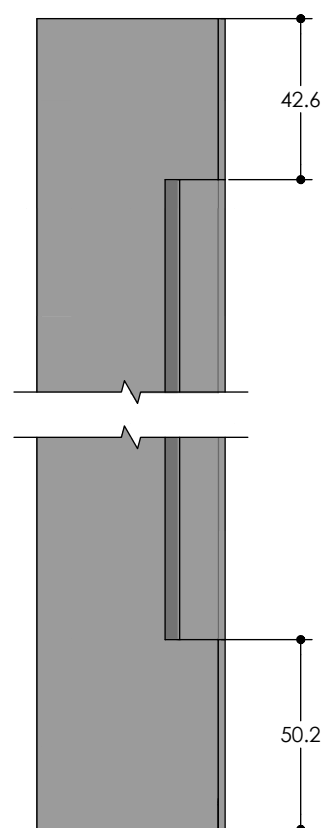
➤ N00651 - JAMB COVER PLATE



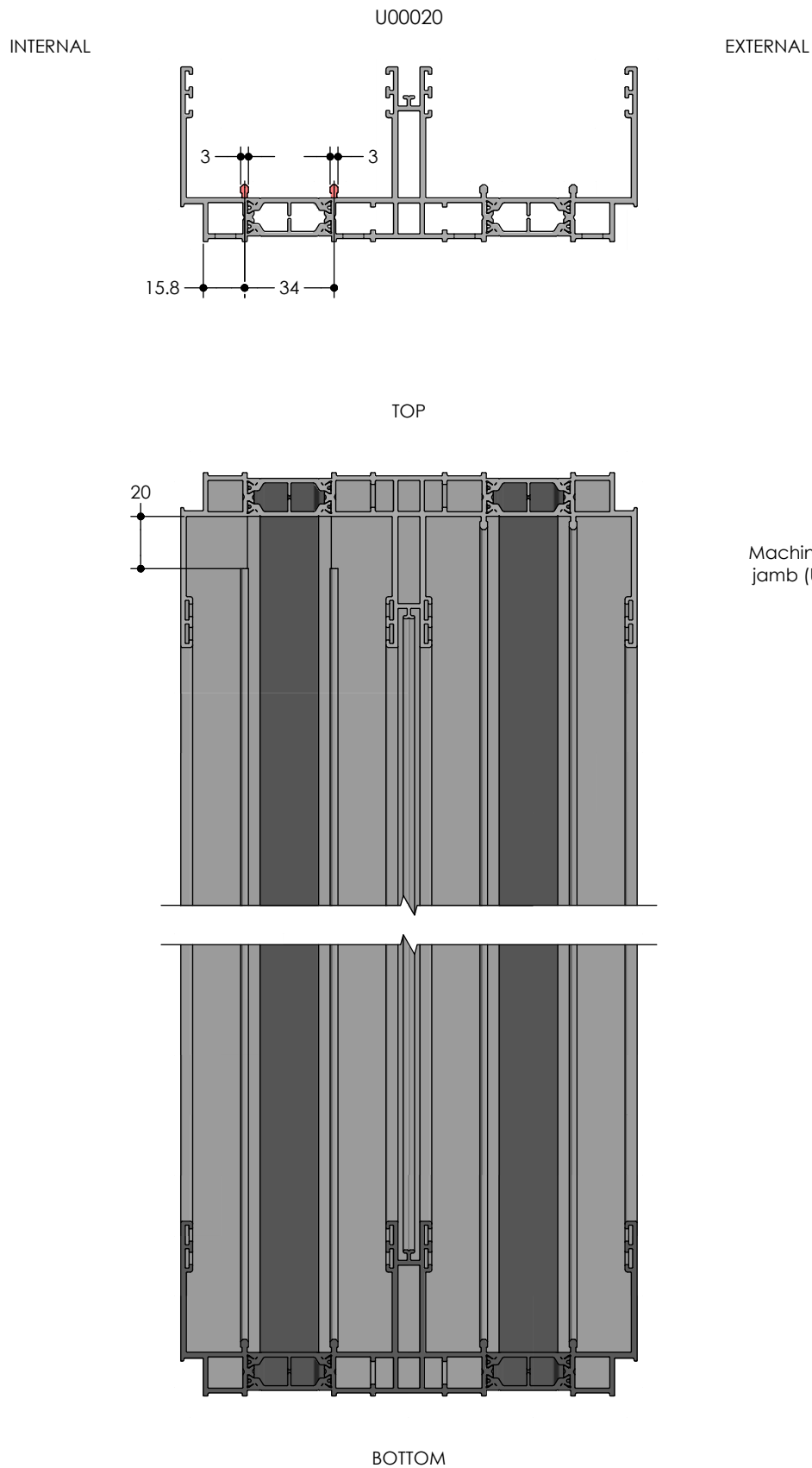
TOP



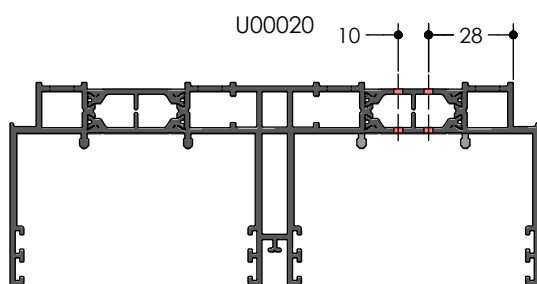
BOTTOM



➤ U00020 - N00652 & N00653 CLEARANCE

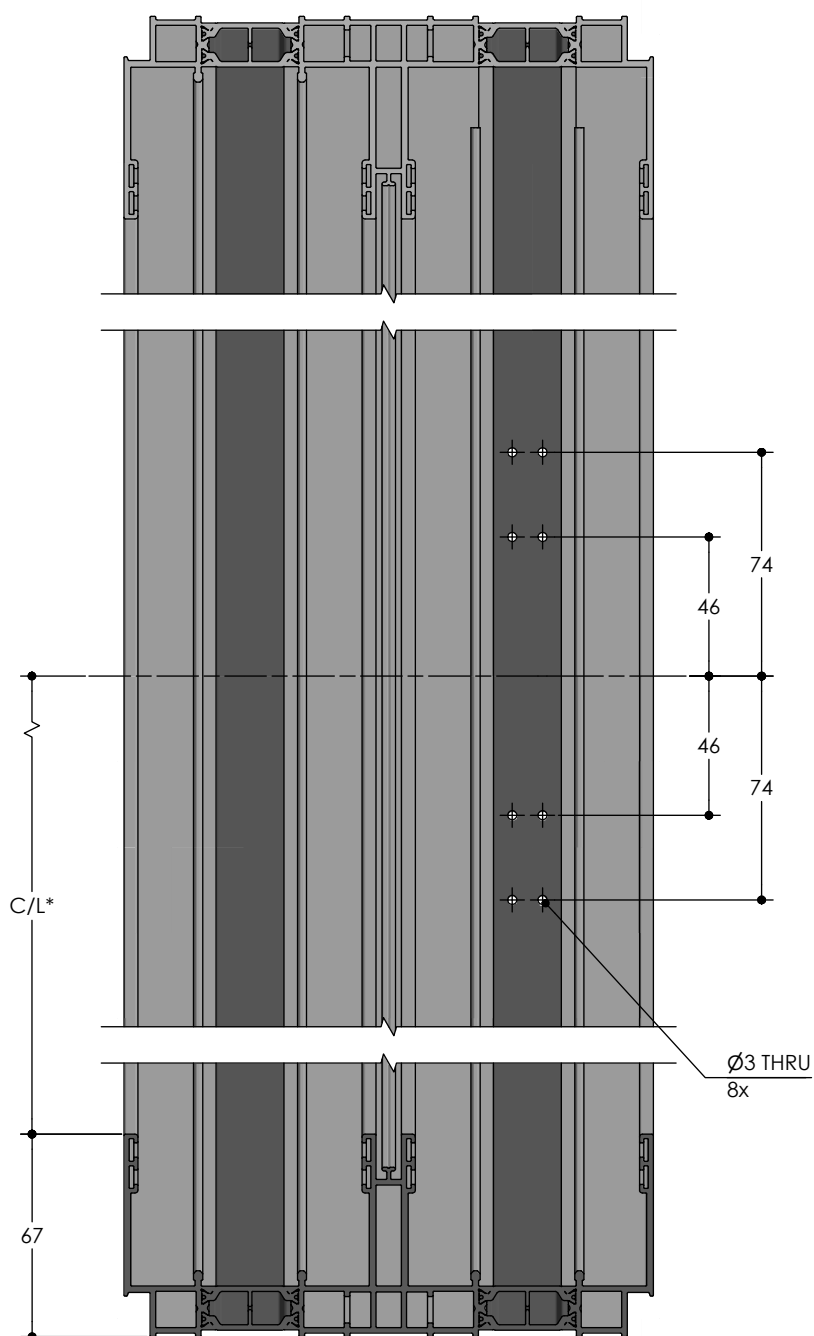


➤ U00020 - KEEP FIXING POSITIONS (H00401)

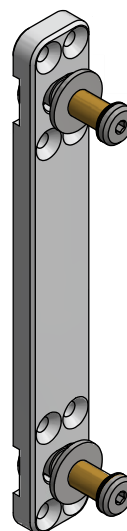


NOTE:

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



H00401



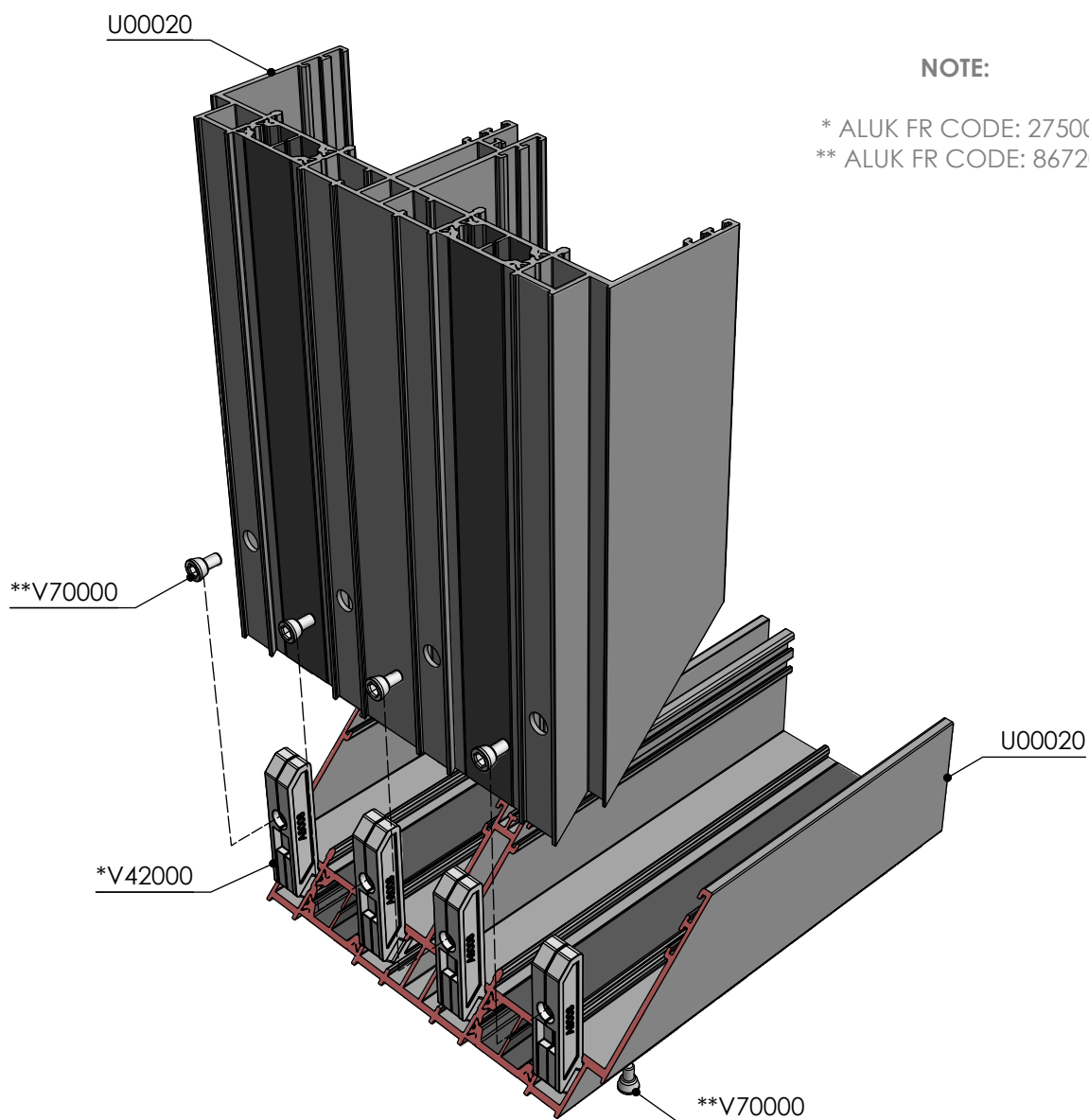
SECTION 10
ASSEMBLY

ASSEMBLY

» INFINIUM ASSEMBLY

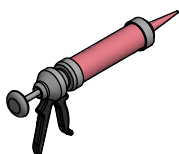
➤ U00020 - CORNER JOINT

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



Apply Sealant!

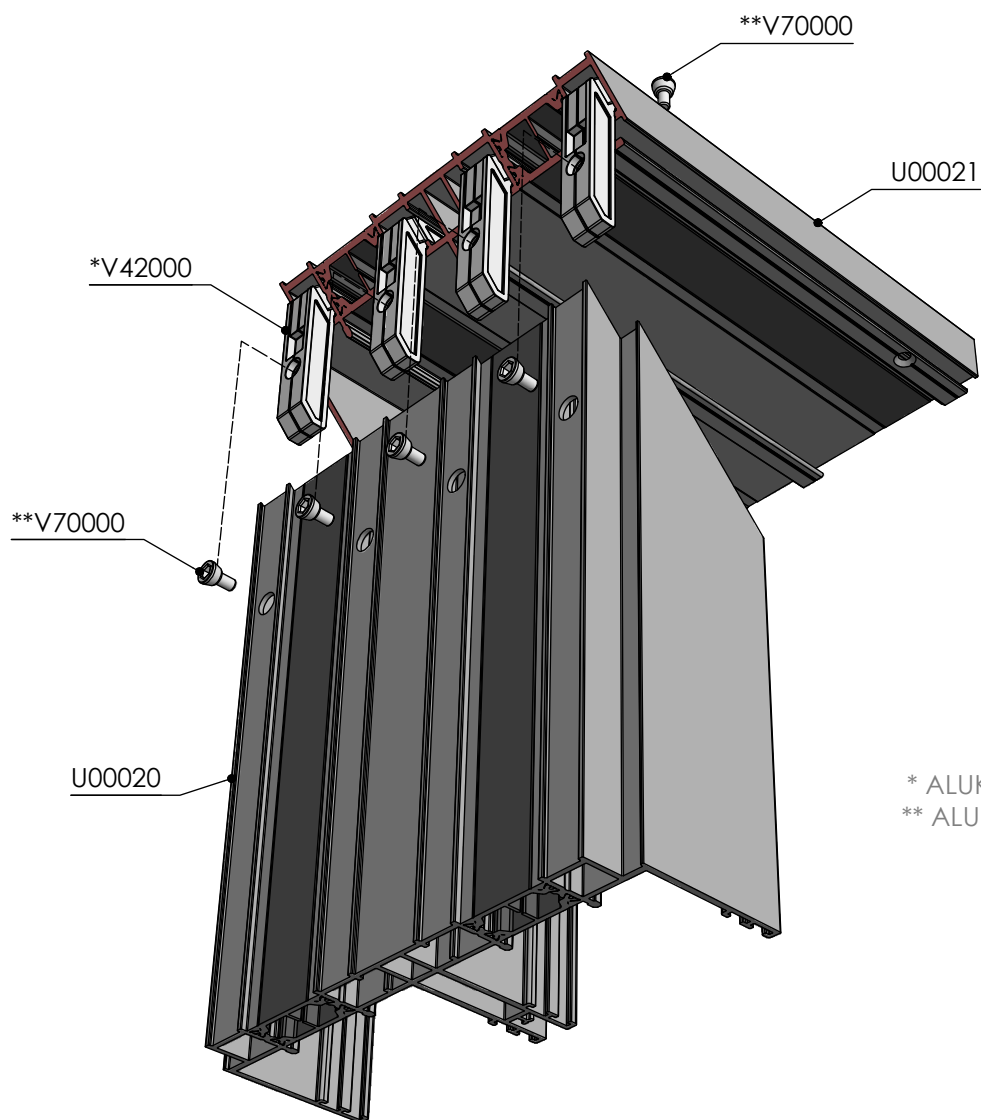
T50000 - T50002



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

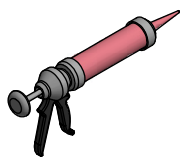
➤ U00020 & U00021 - CORNER JOINT

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



NOTE:

* ALUK FR CODE: 27500
 ** ALUK FR CODE: 86720



Apply Sealant!

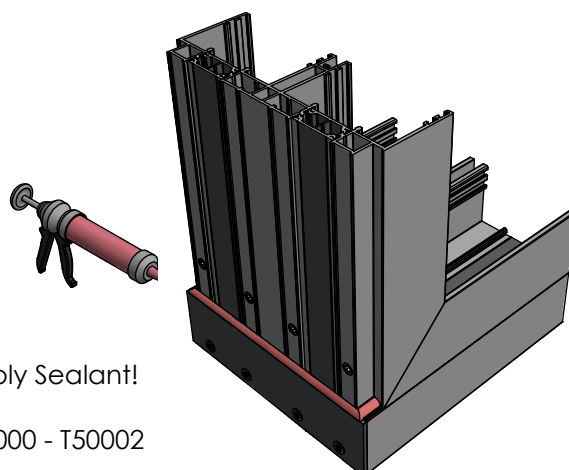
T50000 - T50002

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

➤ U00630 - SUB CILL ASSEMBLY

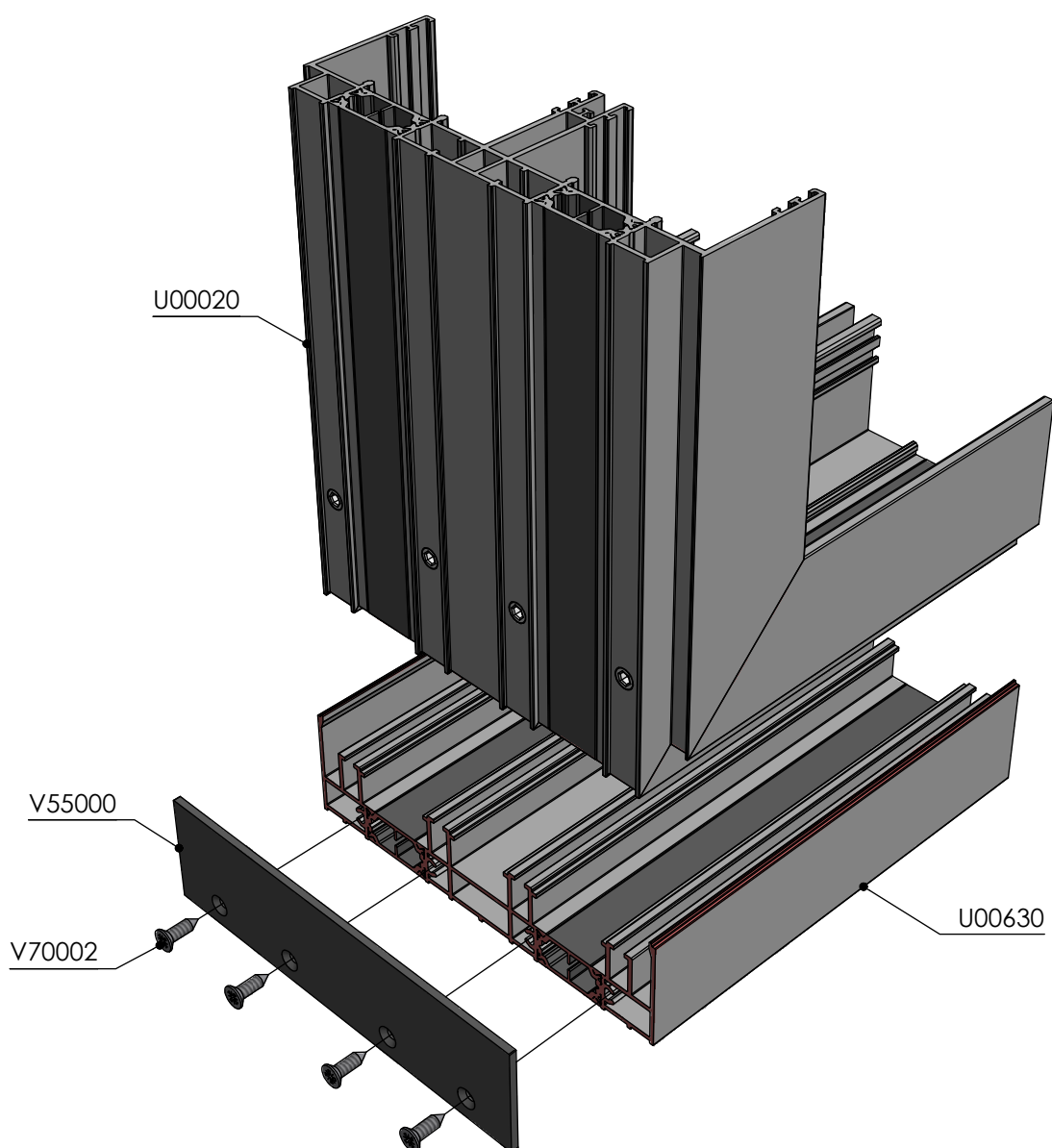
NOTE:

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



Apply Sealant!

T50000 - T50002

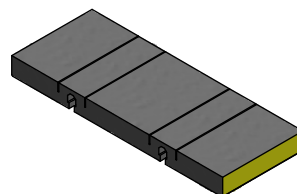
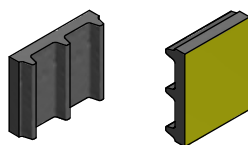


Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ V20000 - INTERLOCK FOAM SEAL

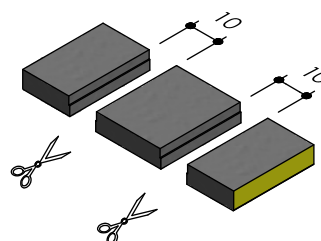
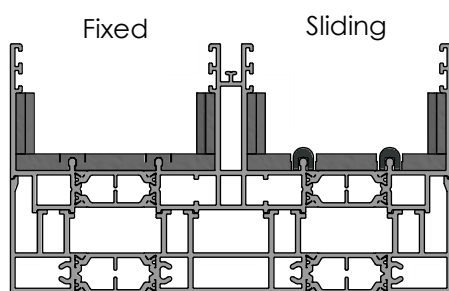
V20000 (Part 2)

Sliding/Fixed



V20000 (Part 1)

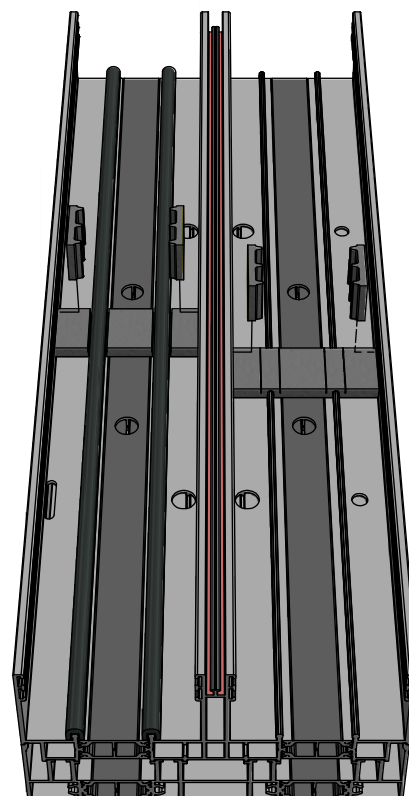
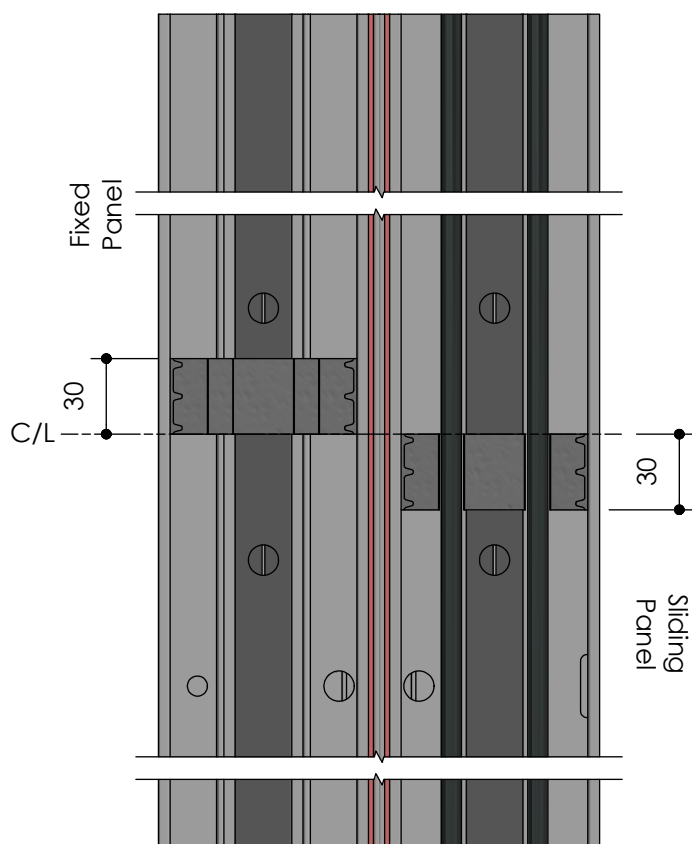
Fixed



V20000 (Part 1)

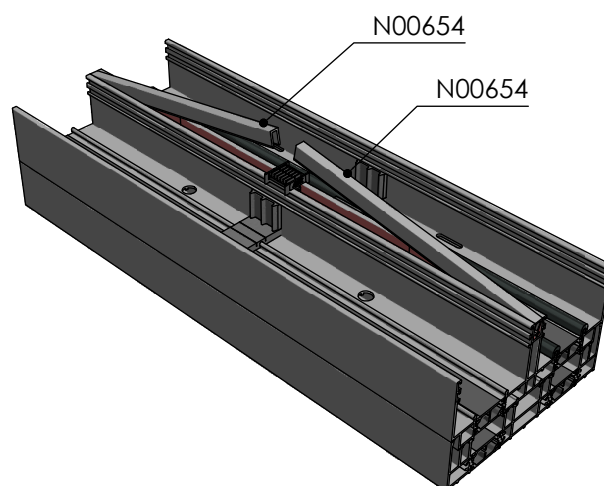
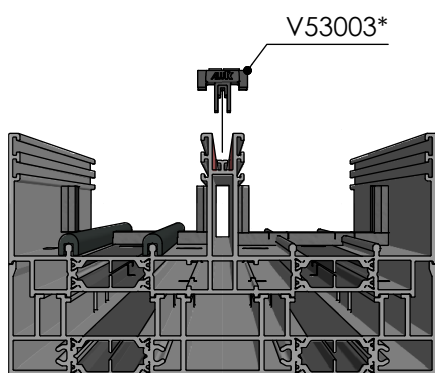
Sliding

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.

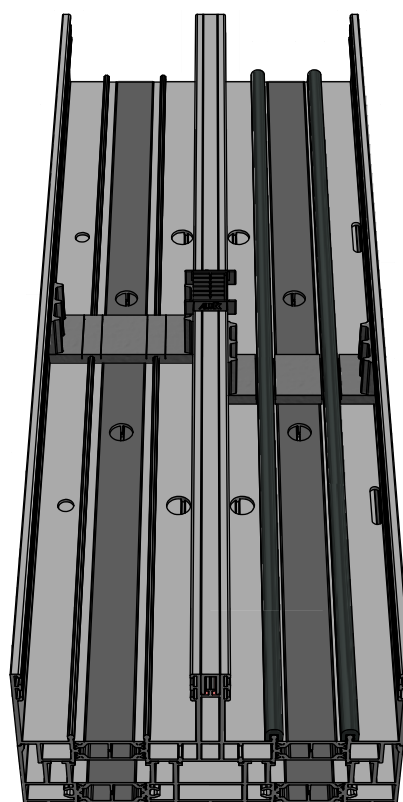
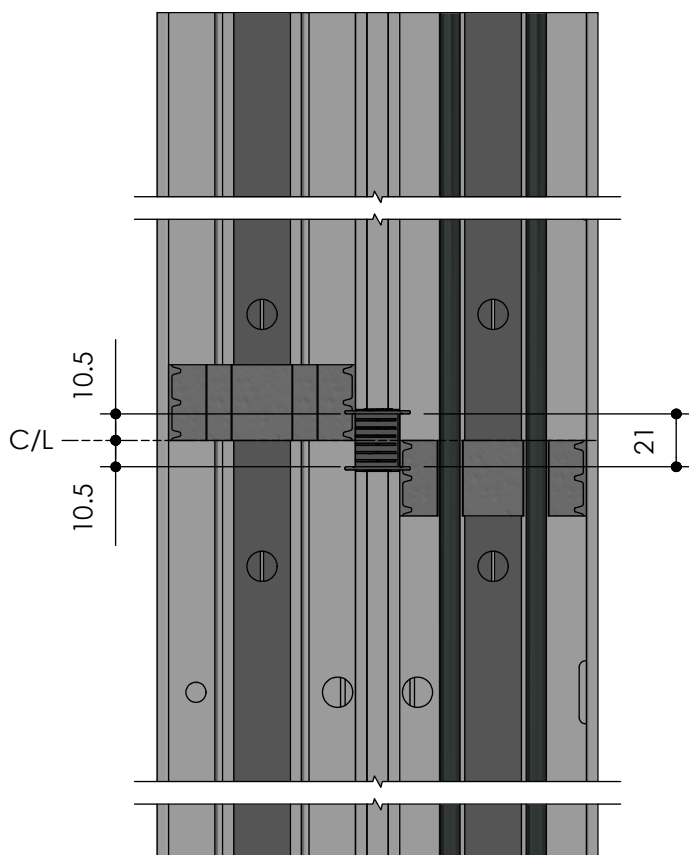
➤ U00020 - V53003 EPDM INTERLOCK SEAL



Apply Sealant!

T50000 - T50002

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



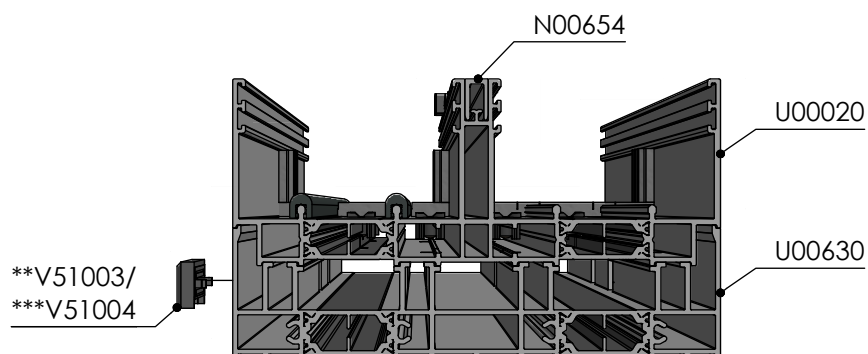
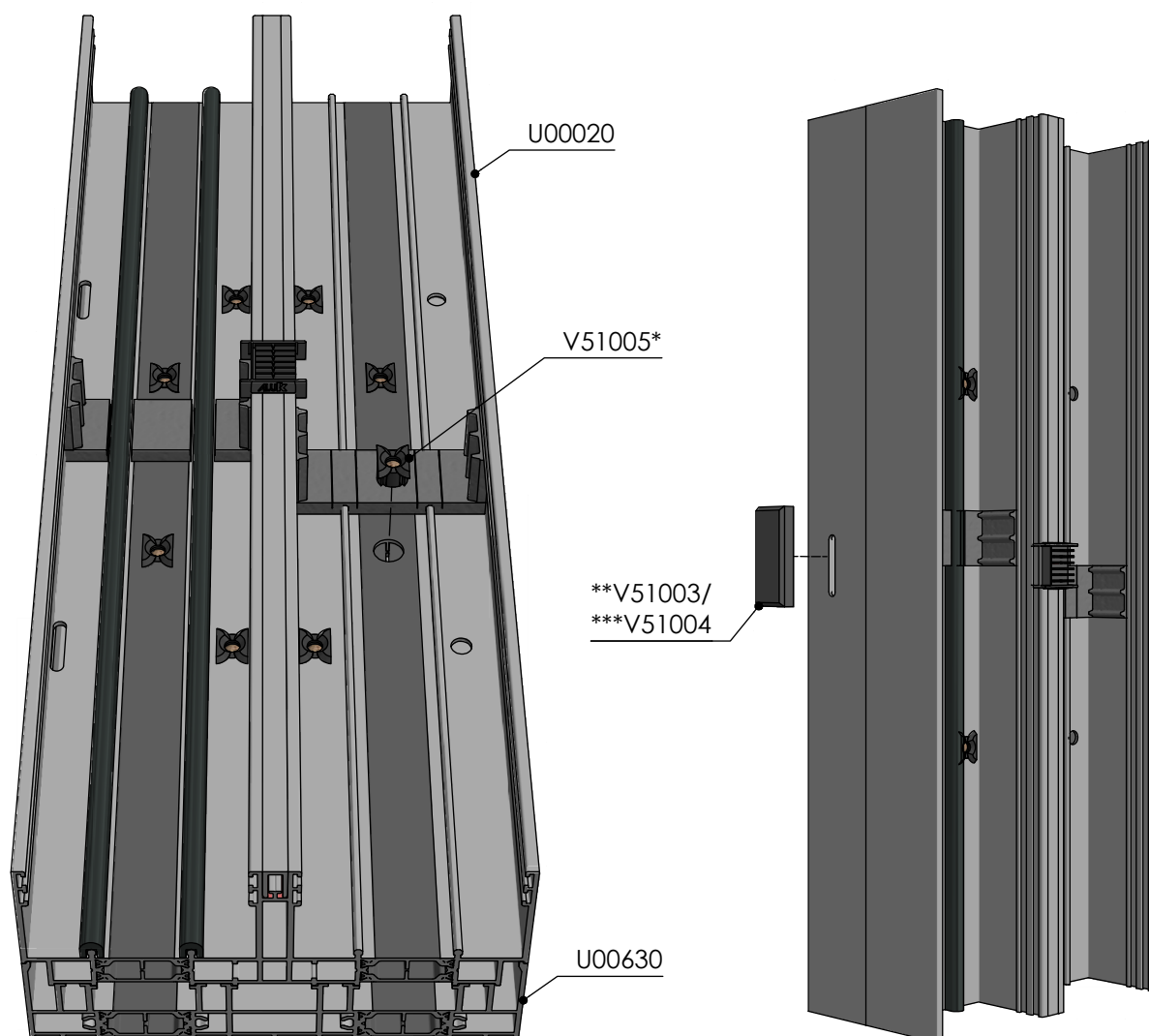
Apply small joint sealant along U-channel before assembling N00654.
Once fixed wipe away any excess sealant using T50003.

➤ U00020 & U00630 - DRAINAGE VALVES

* ALUK GBR CODE: A-00-225

** ALUK ITA CODE: 712007

*** ALUK ITA CODE: 712008



NOTE:

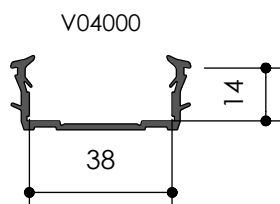
Makesure all drainage valves (V51003, V51004 & V51005) are fitted in appropriate holes/slots.

➤ V04000 - GLAZING GASKET

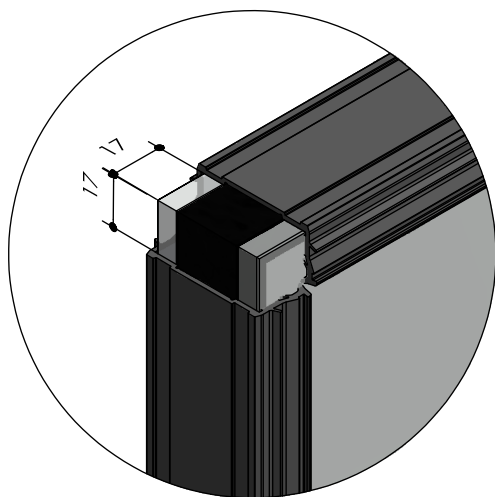
IMPORTANT:

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.

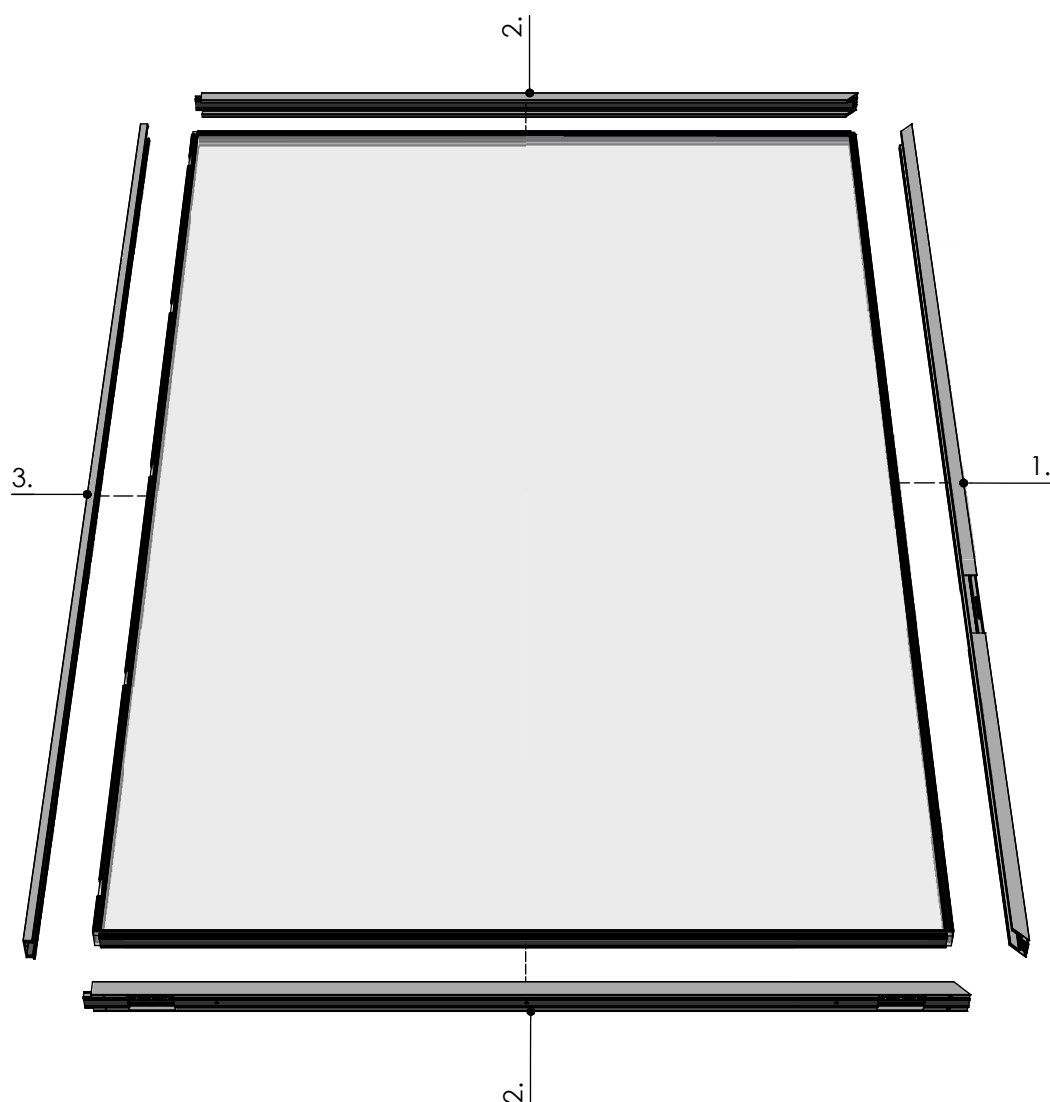


* Cut and join V0400 at the top of the unit using cyanoacrylate glue before assembling the profile.
Failure to join the gasket correctly may cause water ingress or the gasket to move when assembled.

➤ SASH ASSEMBLY METHOD

Installation Proceedure:

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

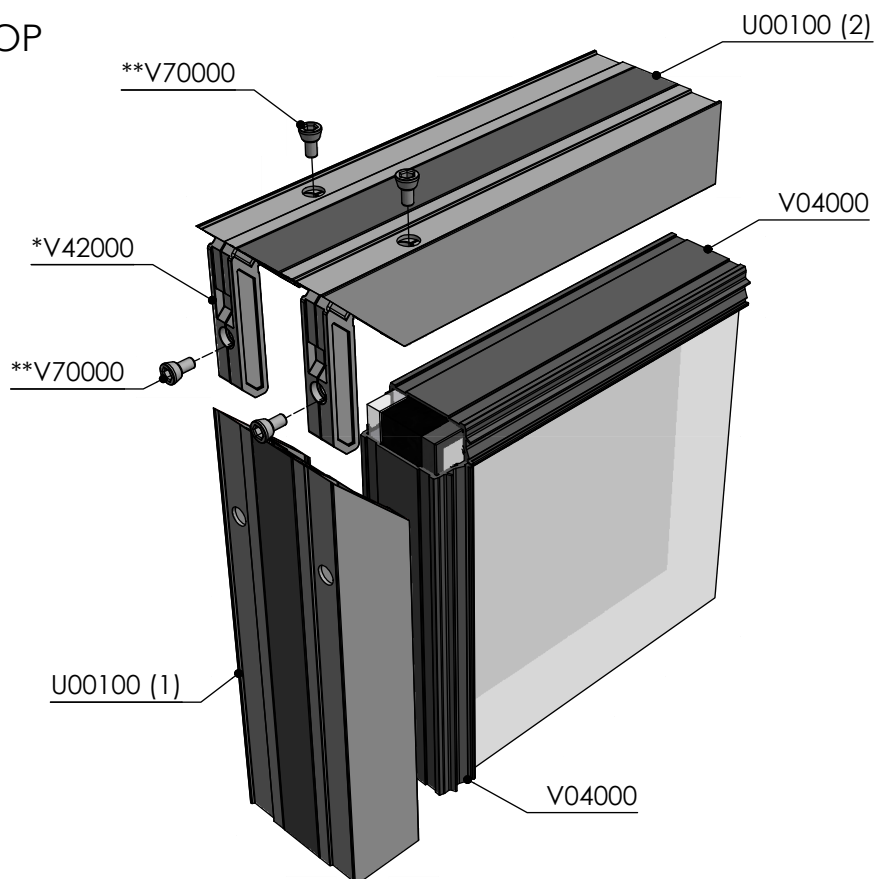


IMPORTANT:

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

➤ U00100 - CORNER ASSEMBLY

TOP

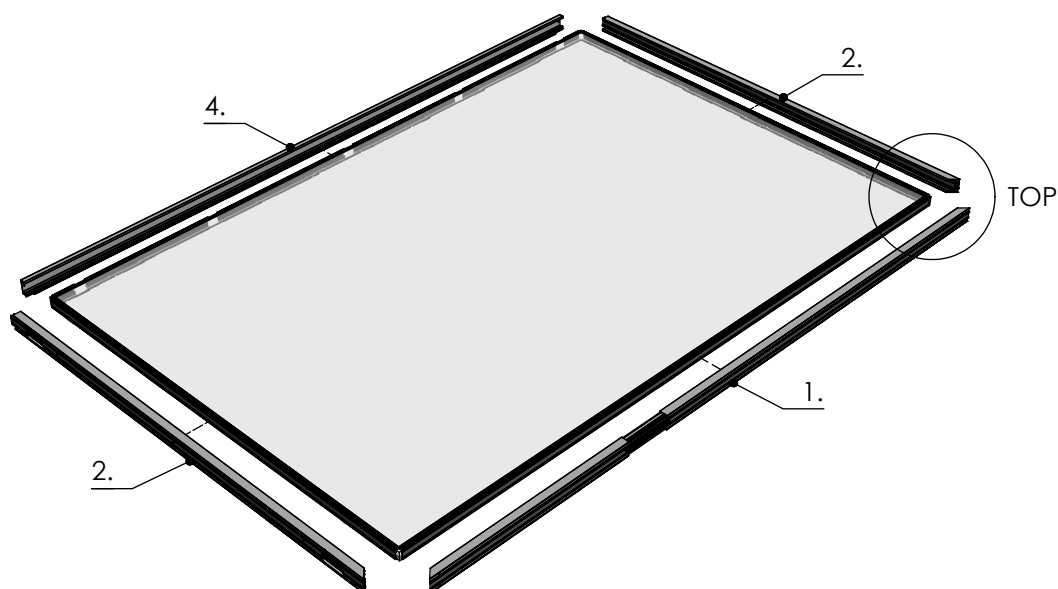


* ALUK FR CODE: 27500
** ALUK FR CODE: 86720



Apply Sealant!

T50000 - T50002



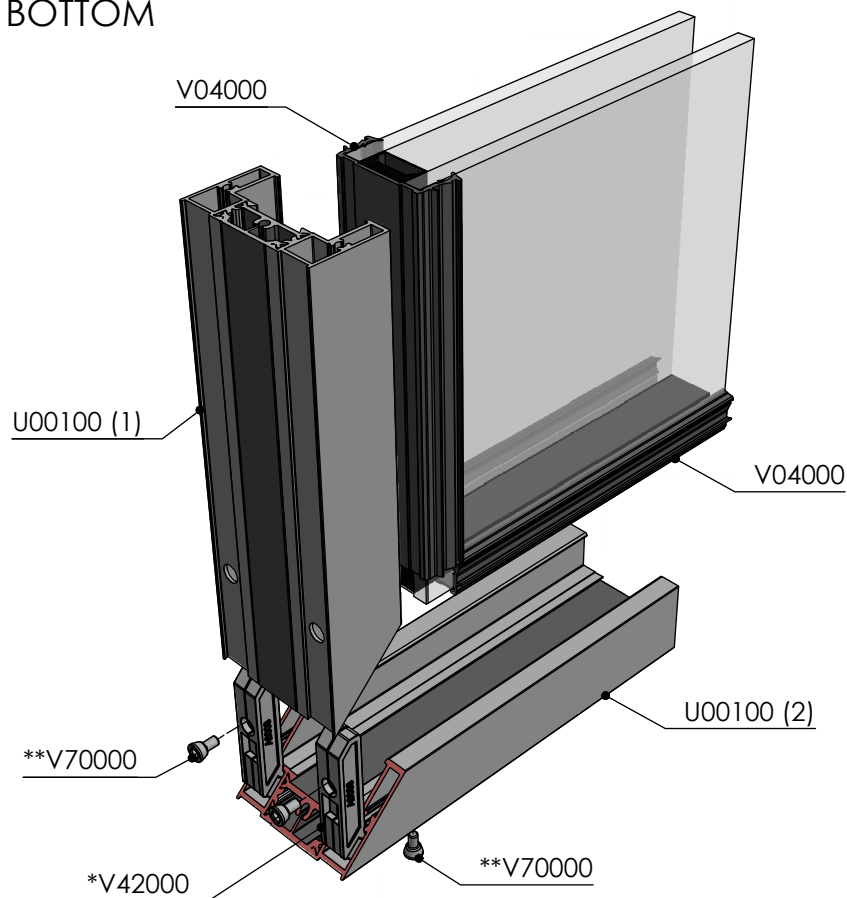
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100 - CORNER ASSEMBLY

BOTTOM

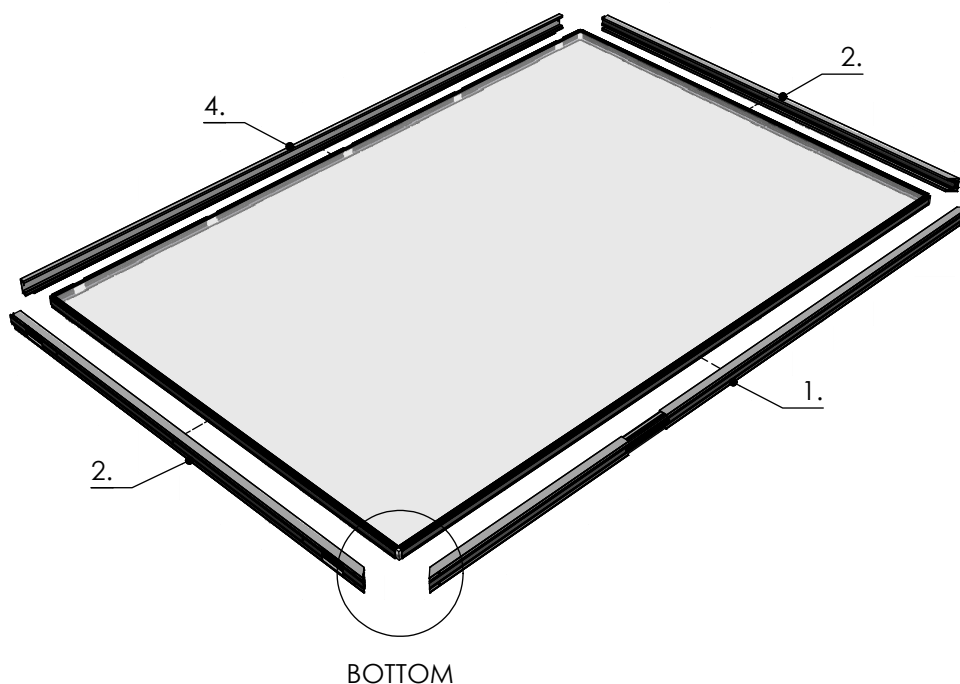
* ALUK FR CODE: 27500

** ALUK FR CODE: 86720



Apply Sealant!

T50000 - T50002



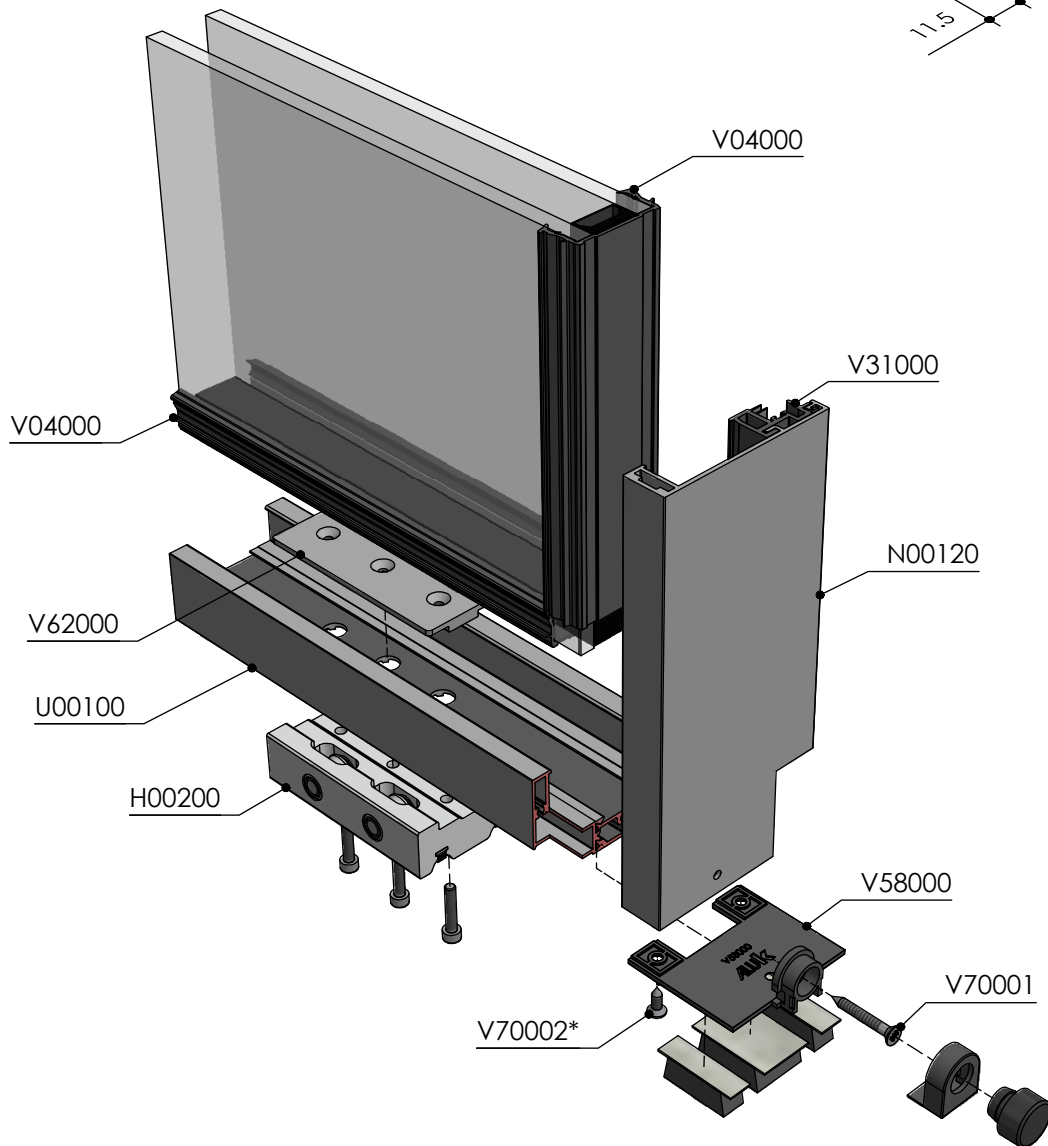
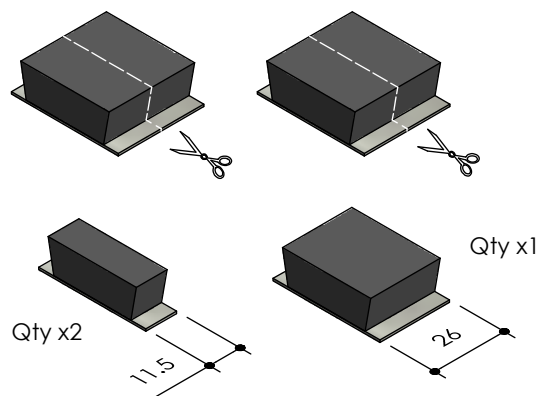
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ 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 V5800



Apply Sealant!

T50000 - T50002

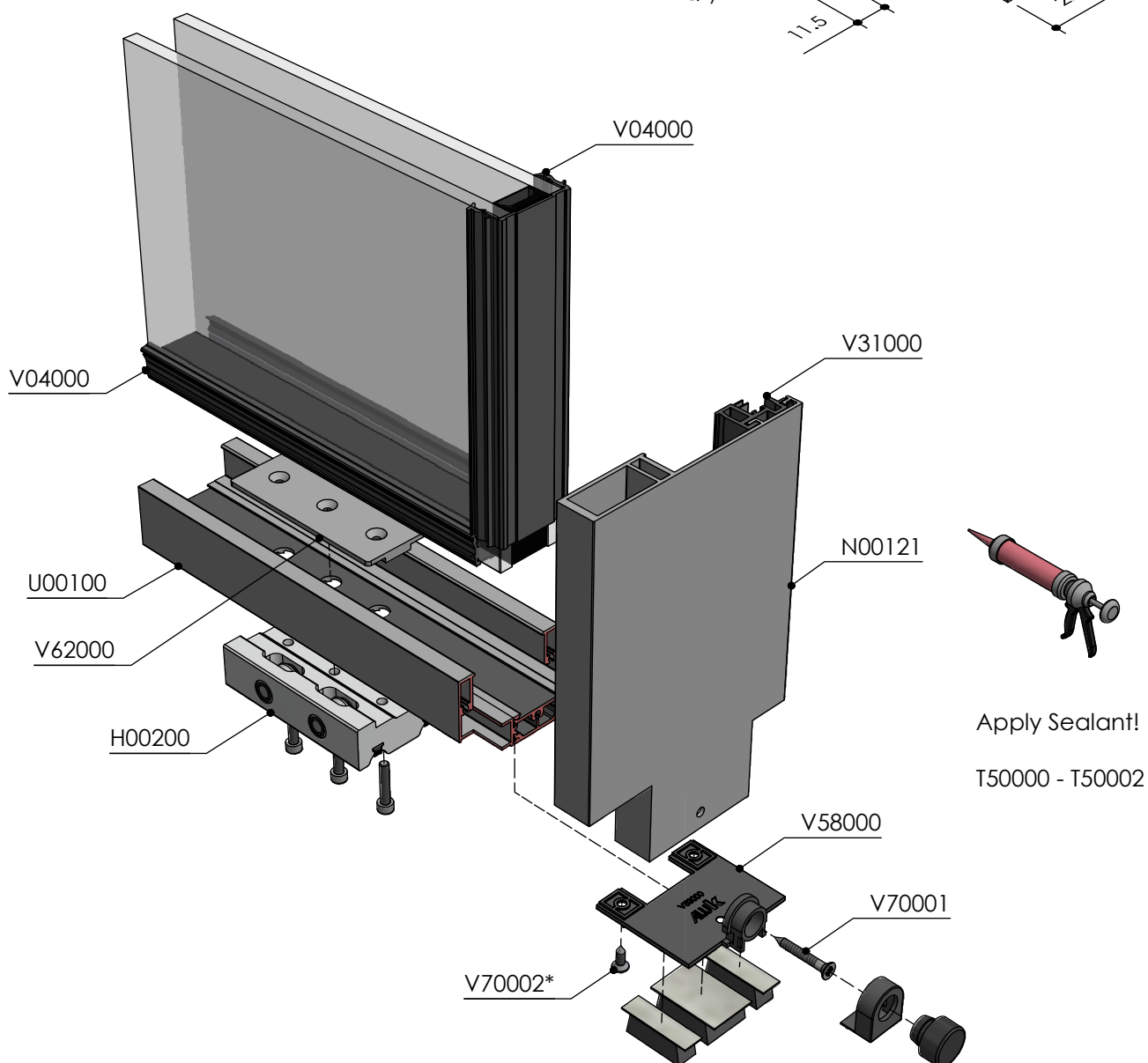
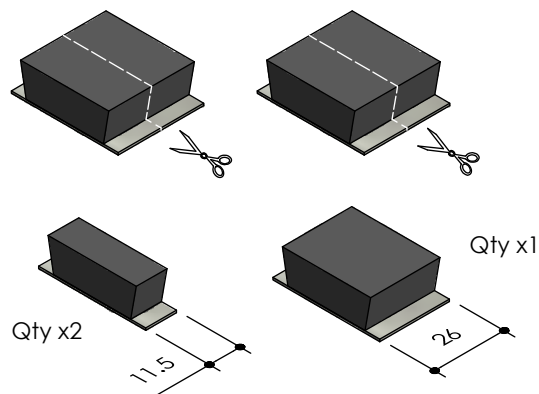
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00121 - SASH & INTERLOCK ASSEMBLY

* ALUK GBR CODE: XS006

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

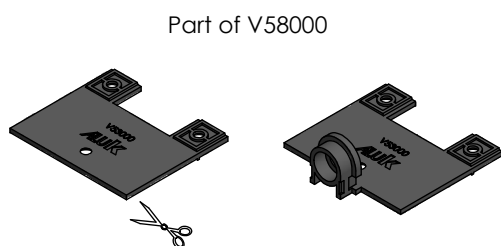
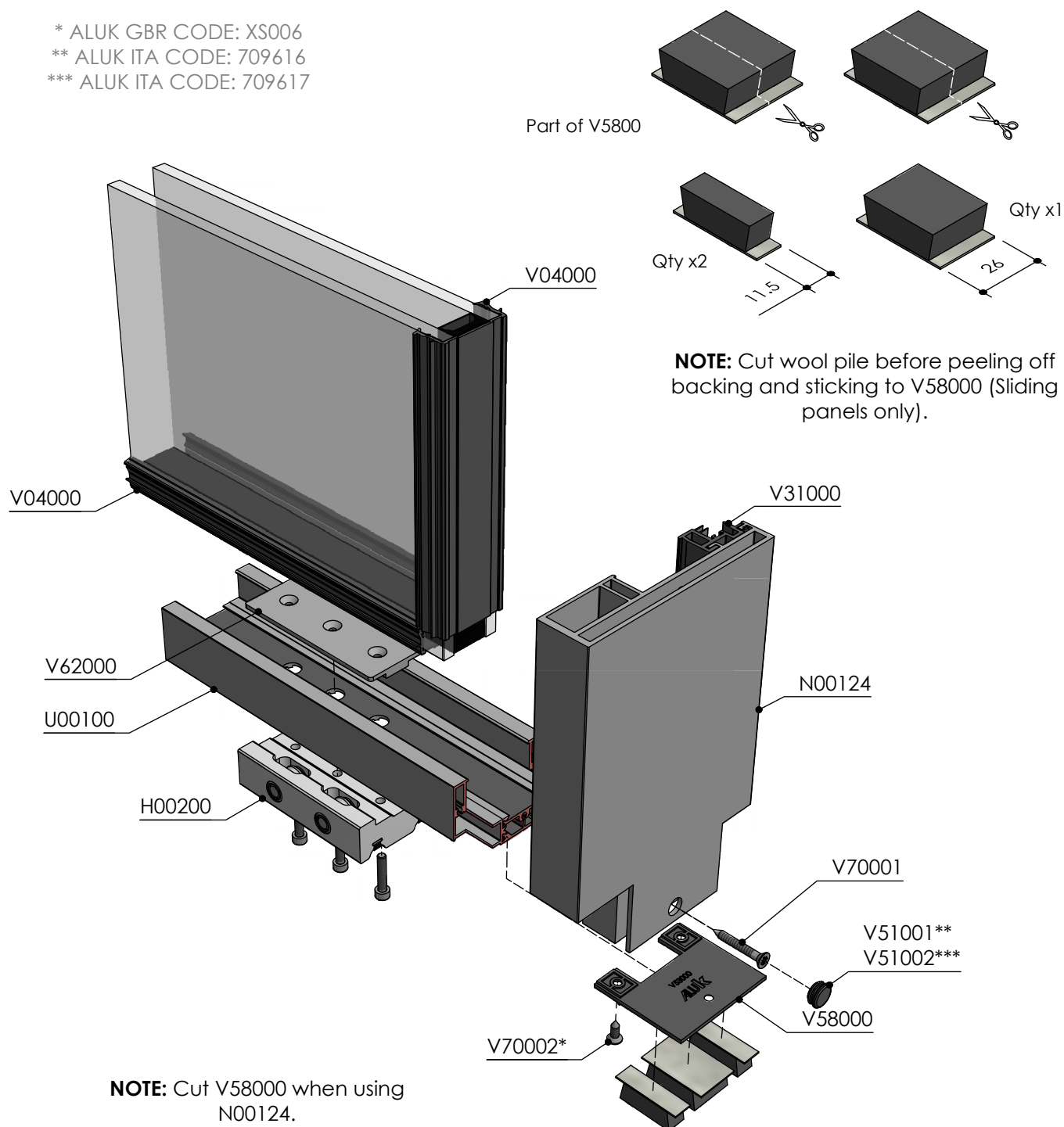
Part of V5800



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

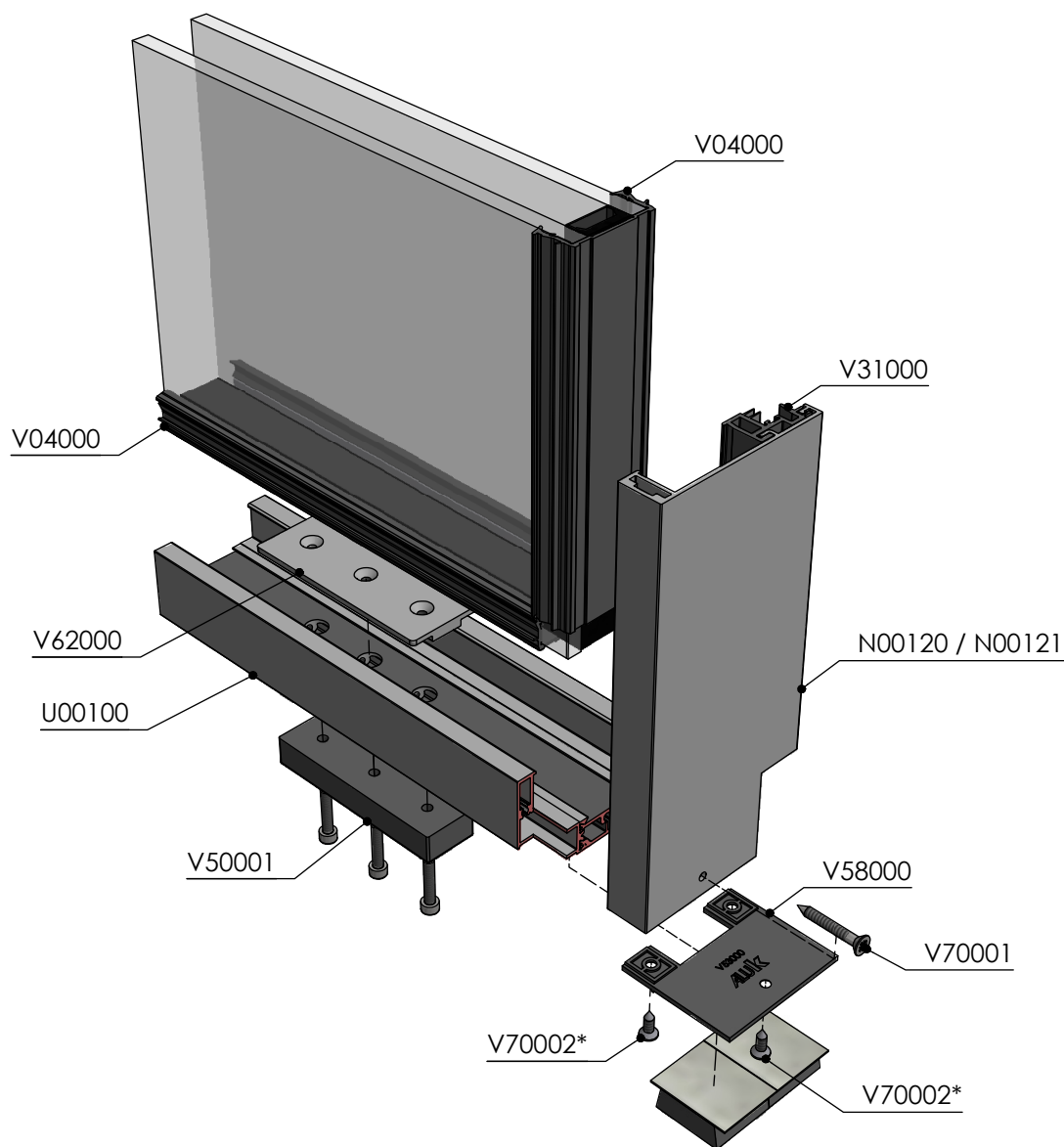
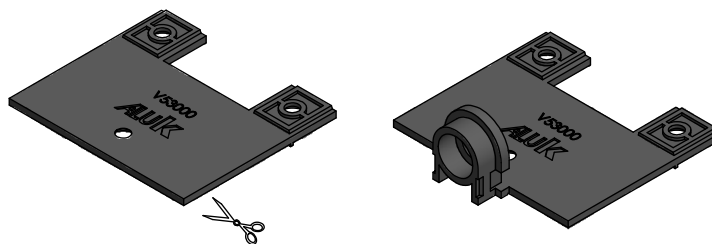
Apply small joint sealant on all corner surfaces before assembling the frame.
 Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00120 - FIXED SASH & INTERLOCK ASSEMBLY

* ALUK GBR CODE: XS006

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

Part of V58000



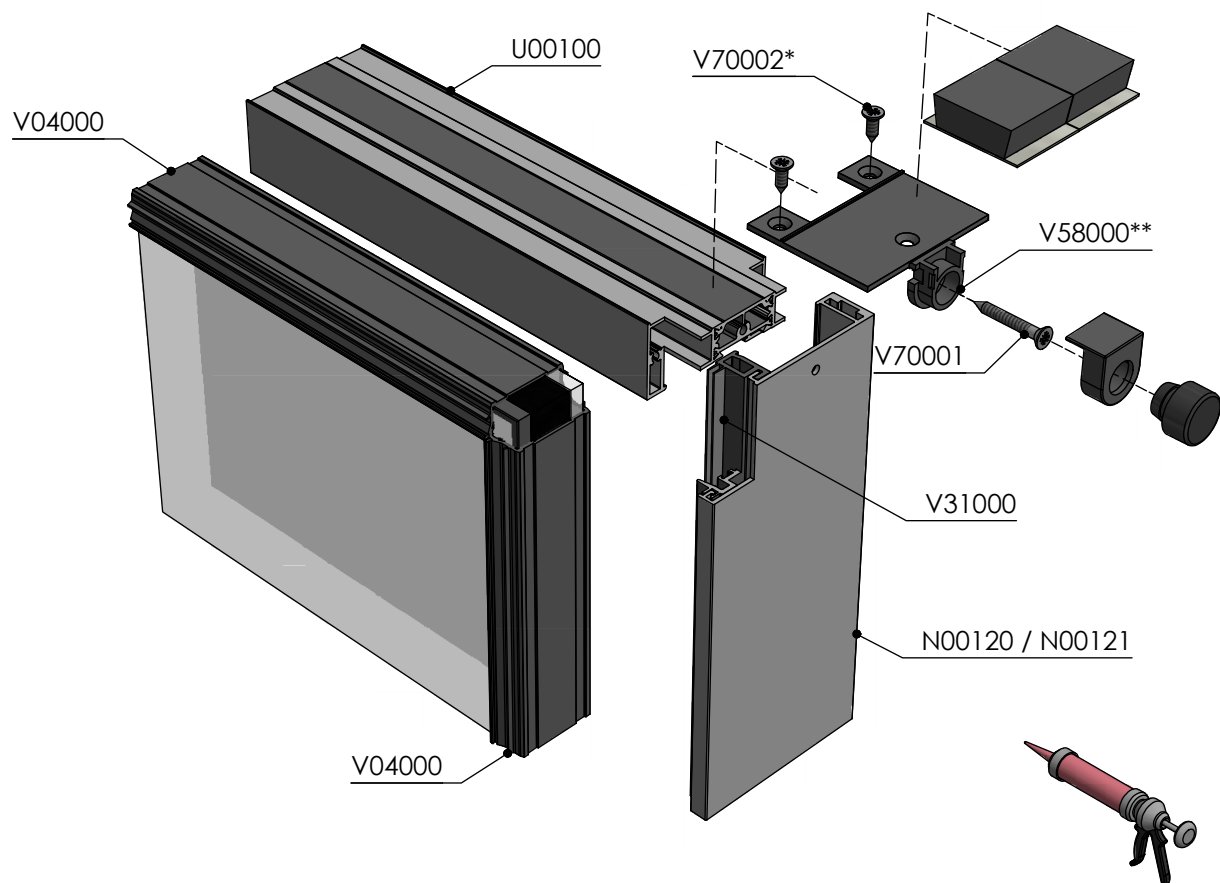
Apply Sealant!

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

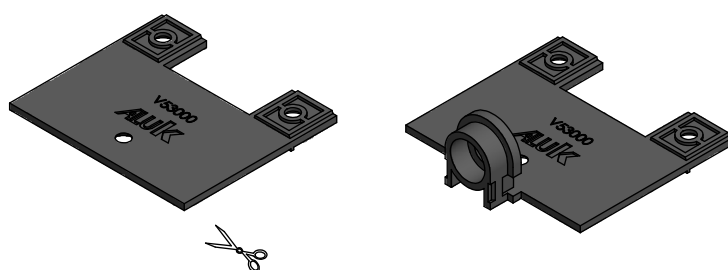
* ALUK GBR CODE: XS006



Part of V58000

Apply Sealant!

T50000 - T50002



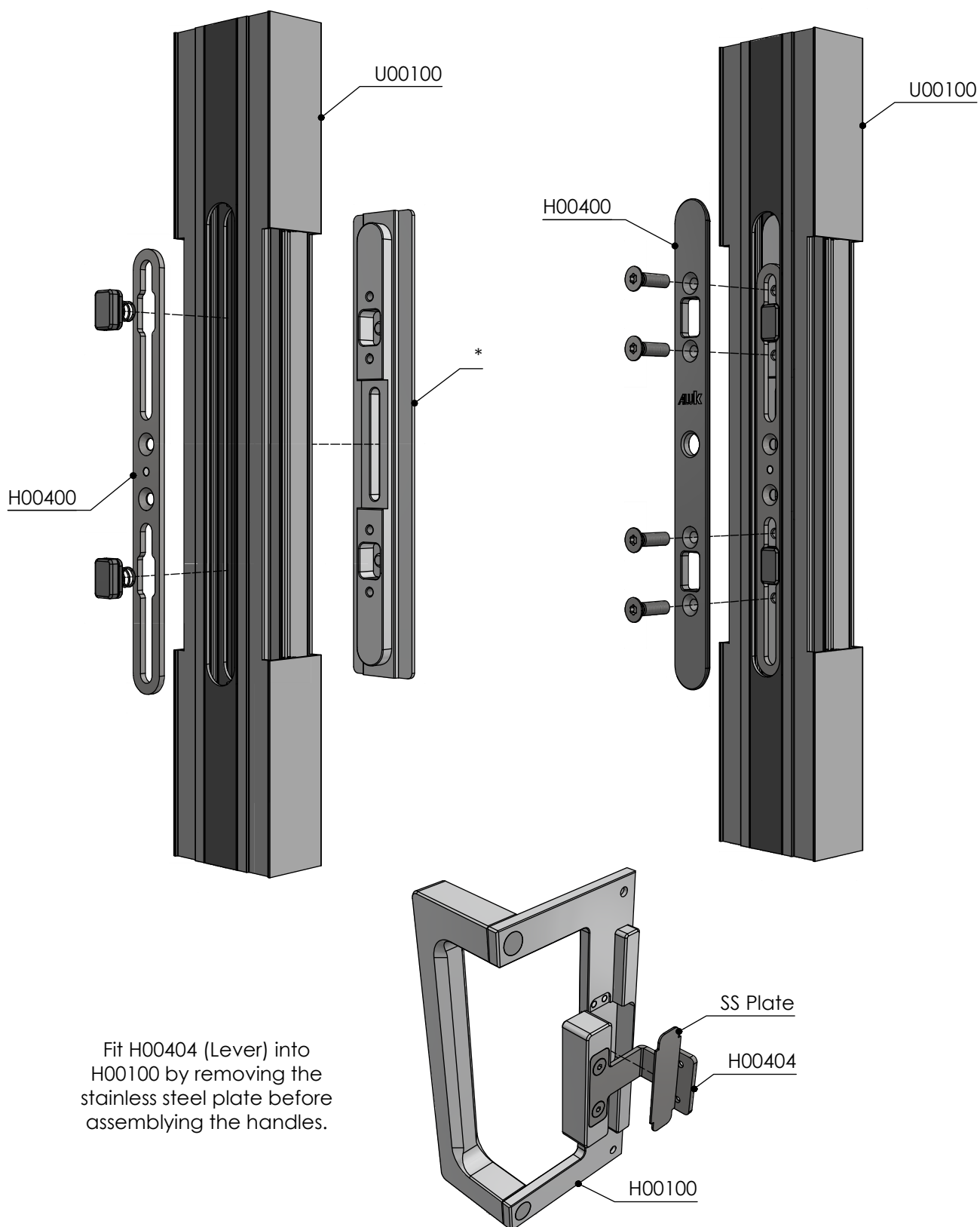
**Cut V58000 to avoid N00651
when installed (Fixed panels
only).

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

➤ U00100, H00400 - LOCK & LEVER ASSEMBLY

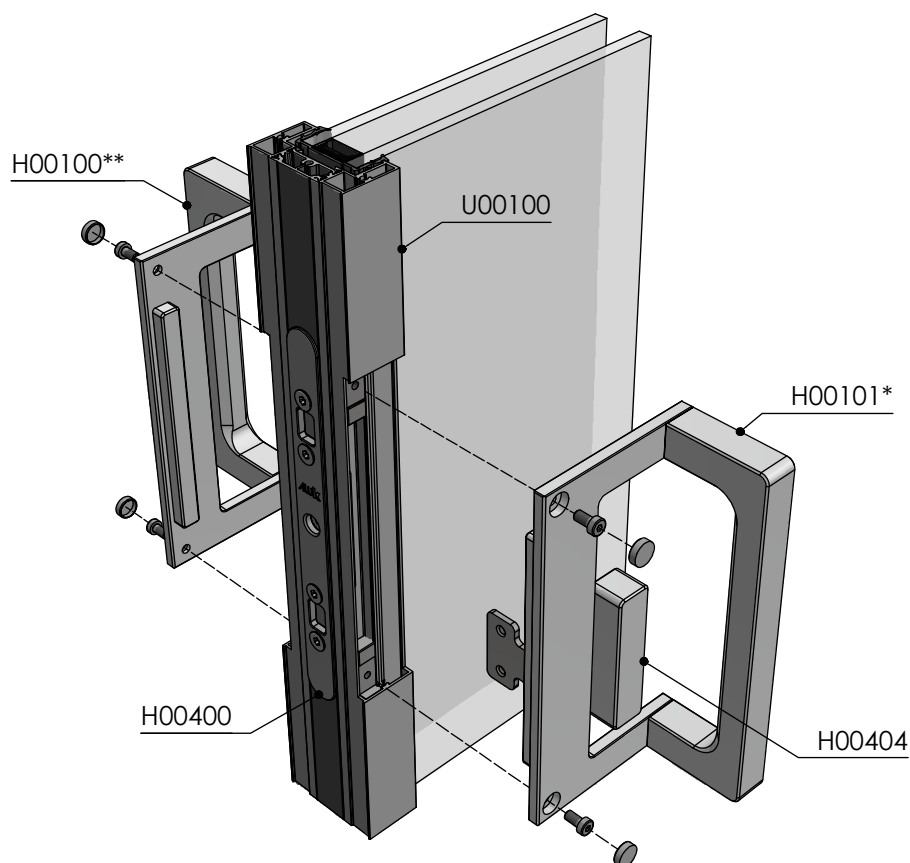
***IMPORTANT:**

H00400 backing plate must be fitted before glazing.



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

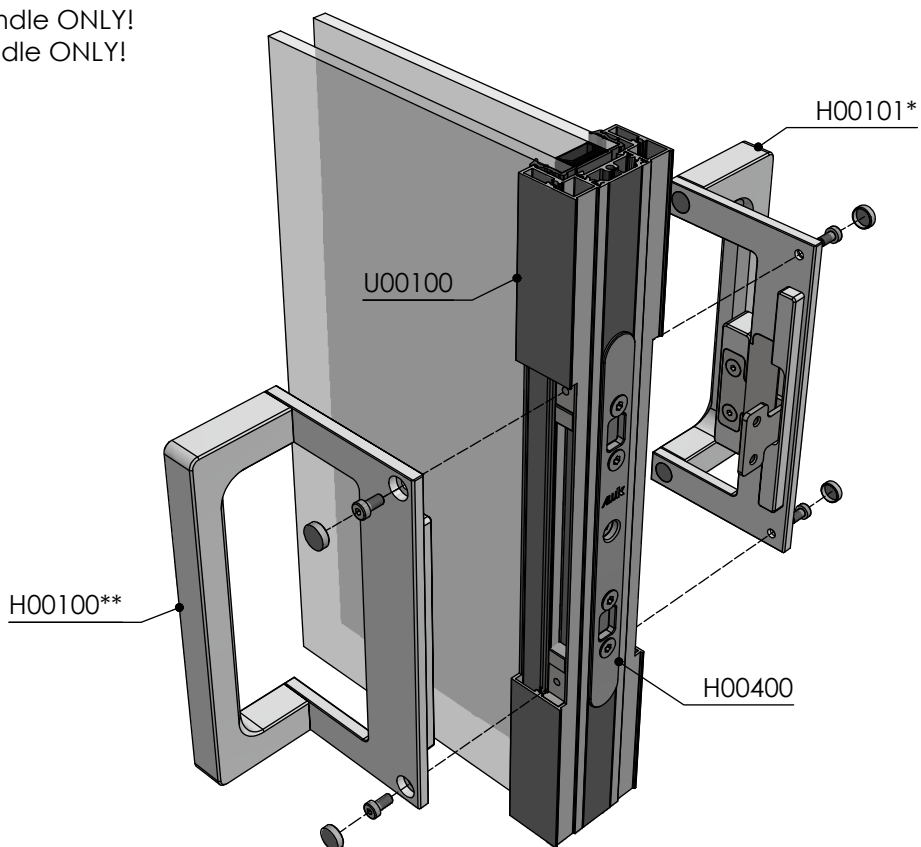
➤ U00100, H00100, H00101 - HANDLE ASSEMBLY



NOTE:

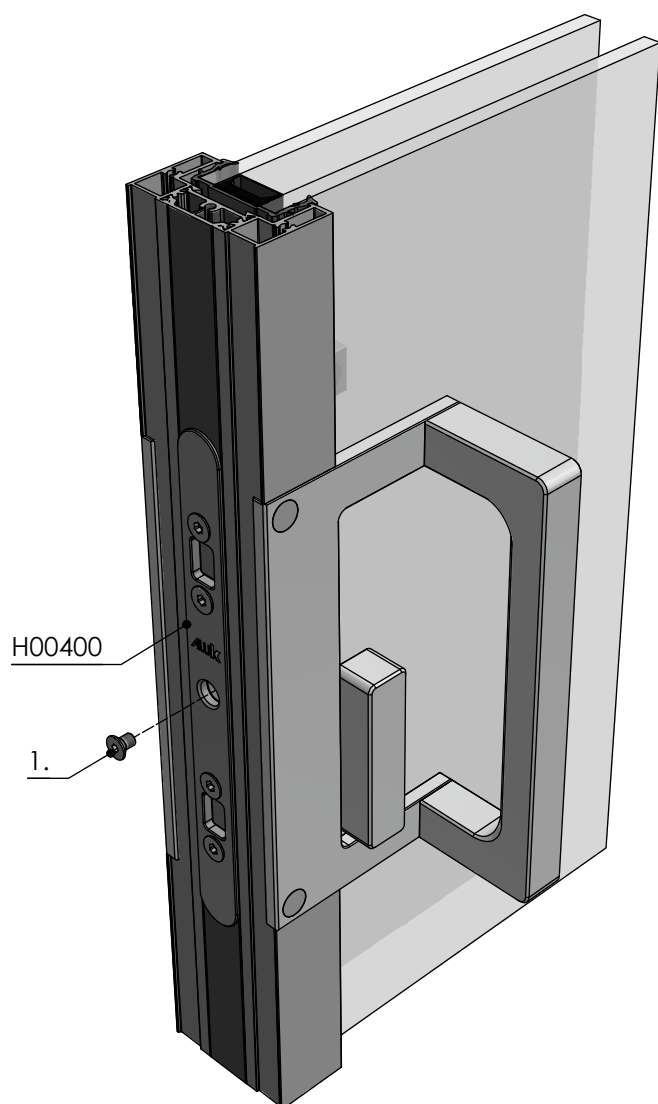
** External Handle ONLY!

* Internal Handle ONLY!

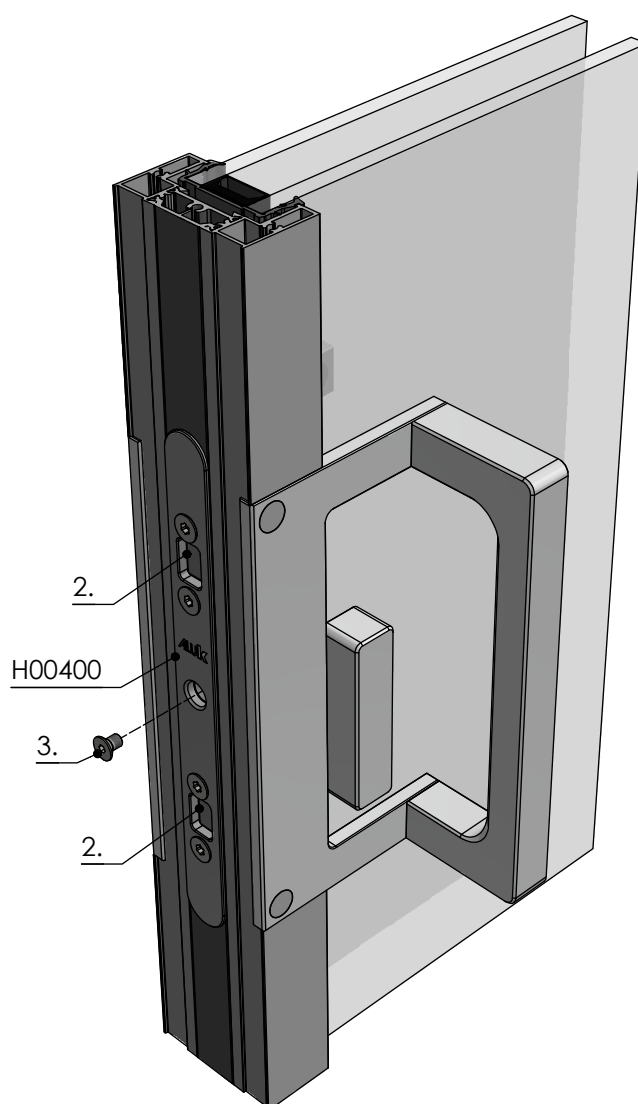


H00100 & H00101 can be fitted after glazing to avoid damage during transport.

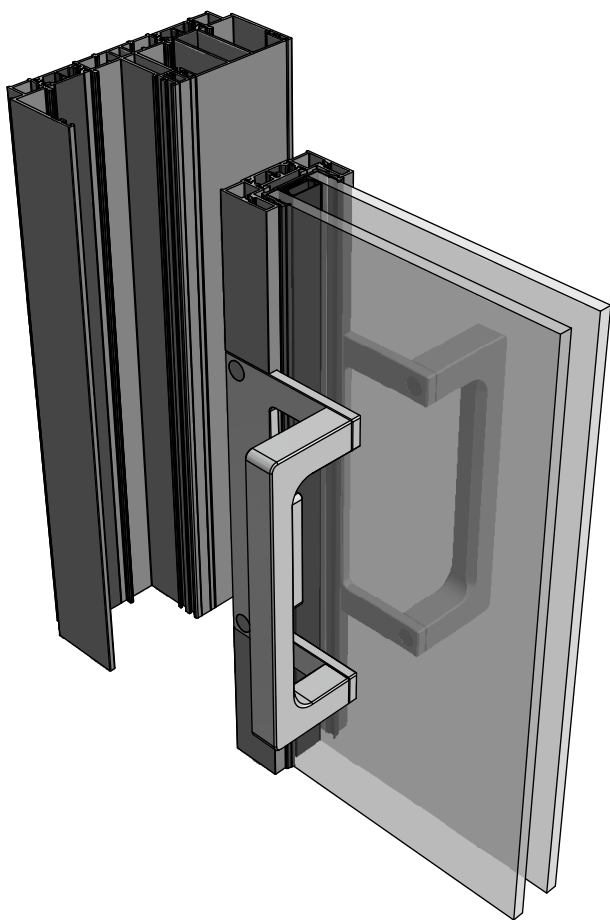
➤ H00400 & H00404 - FINAL FIXING



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.



➤ U0020, U00100, H00401 - KEEP ALIGNMENT

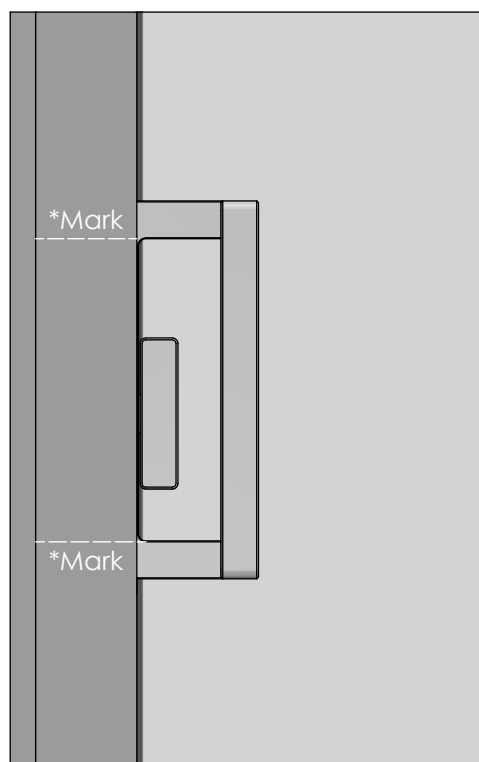
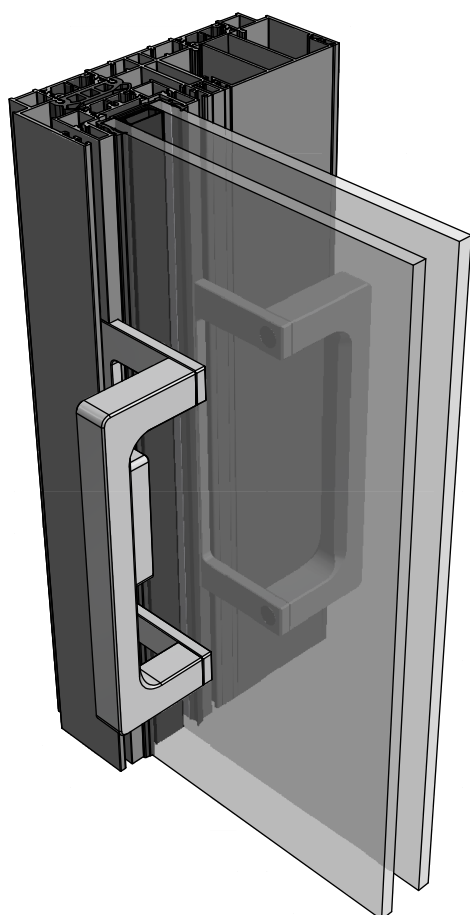


Note:

Slide door shut.

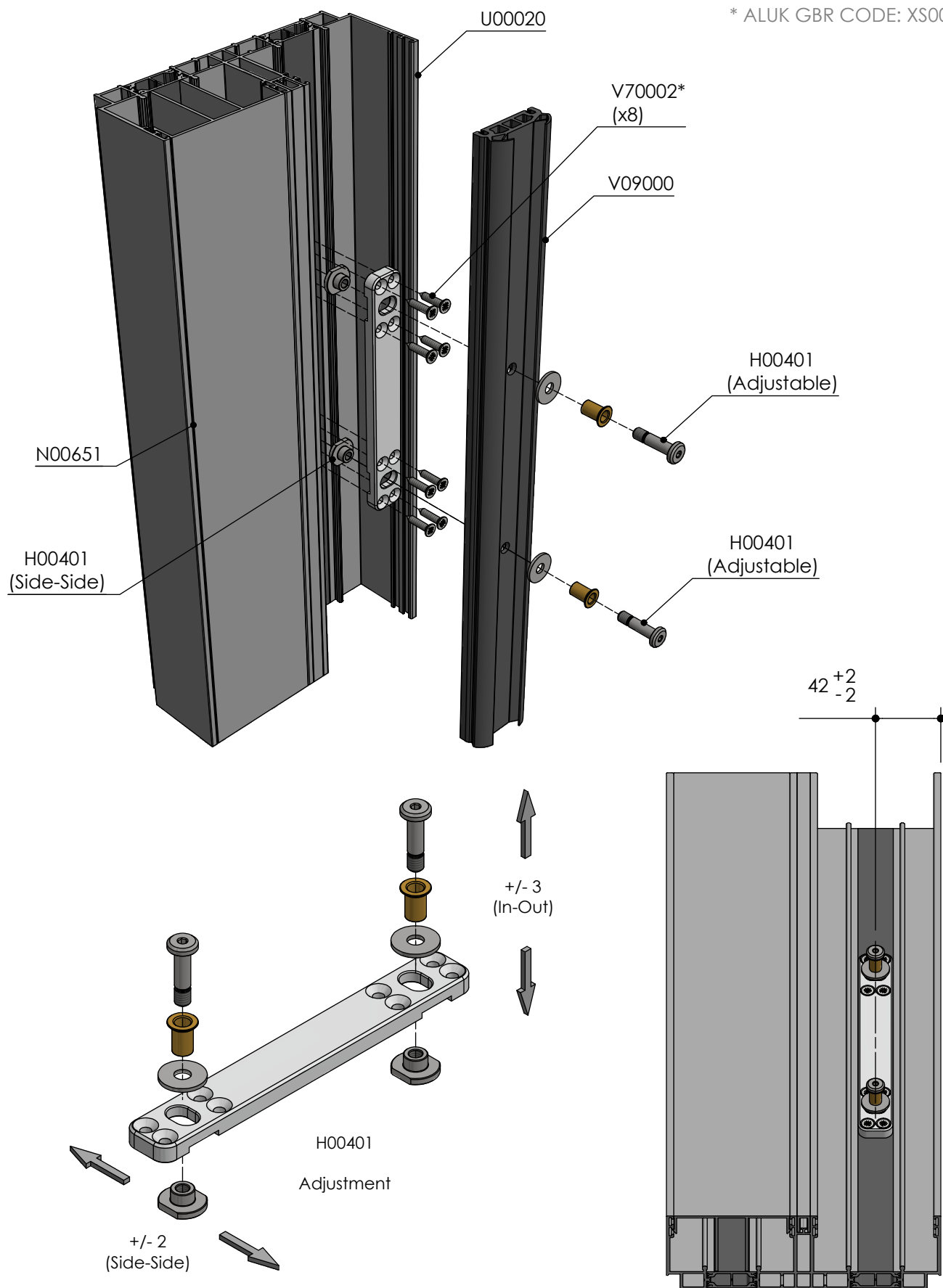
* Mark a pencil line from the internal side of the handle grip.

Use marks to align top and bottom of H00401 Keep.



➤ U00020, H00401 - KEEP ASSEMBLY

* ALUK GBR CODE: XS006

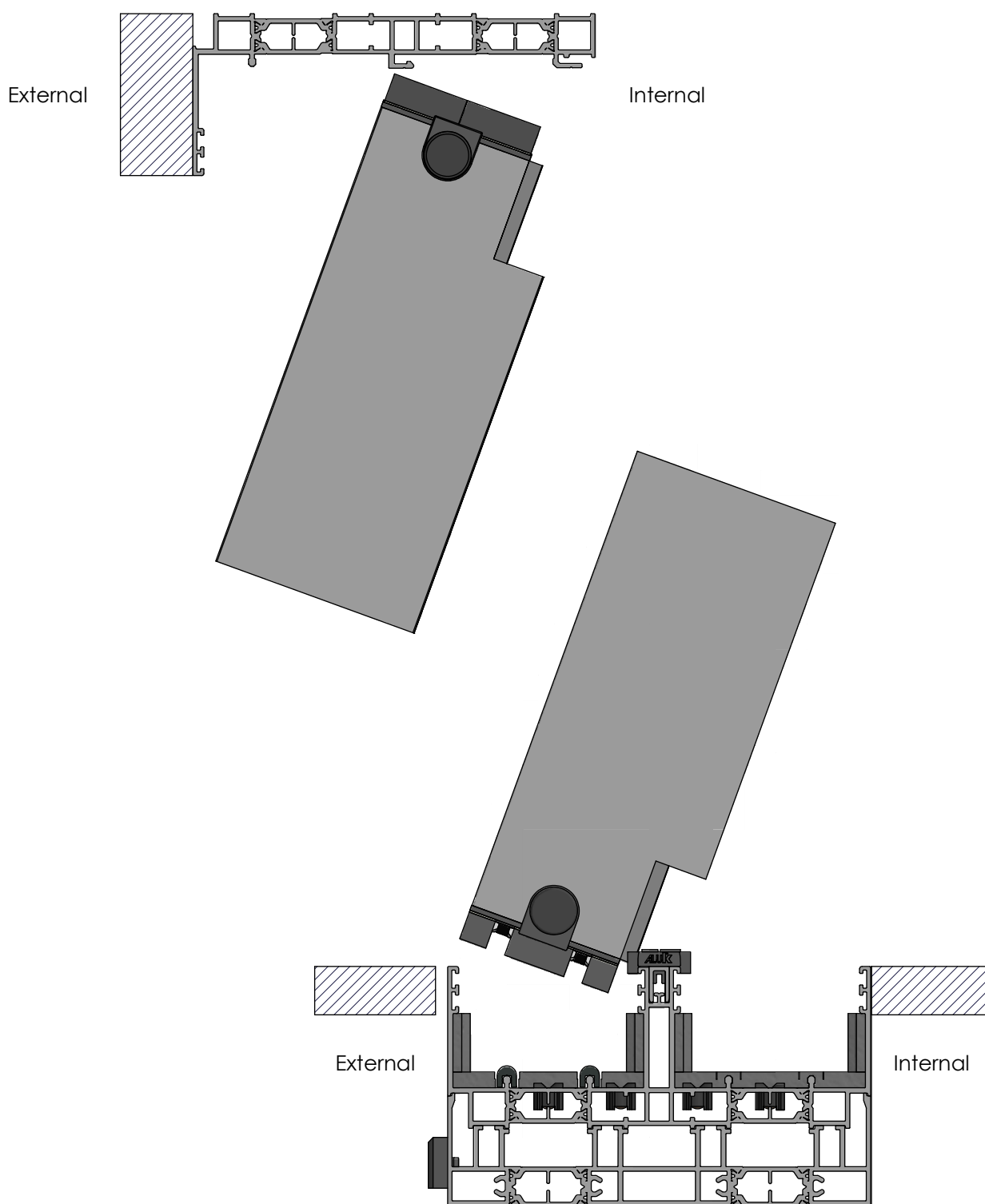


▶ PANEL INSTALLATION

Panel Installation:

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

1. & 2.

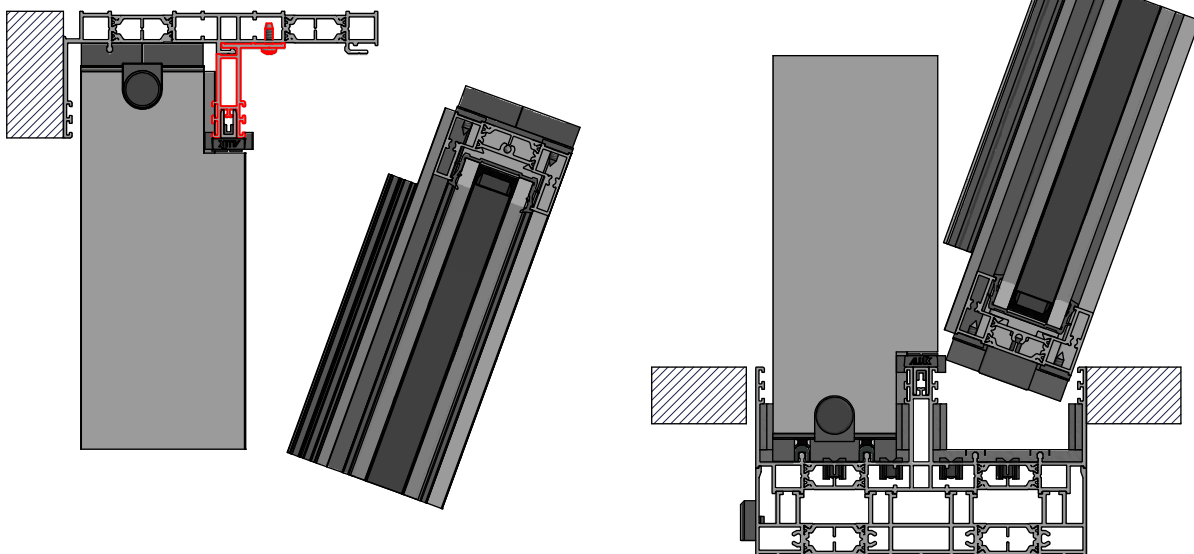


➤ PANEL INSTALLATION CONT.

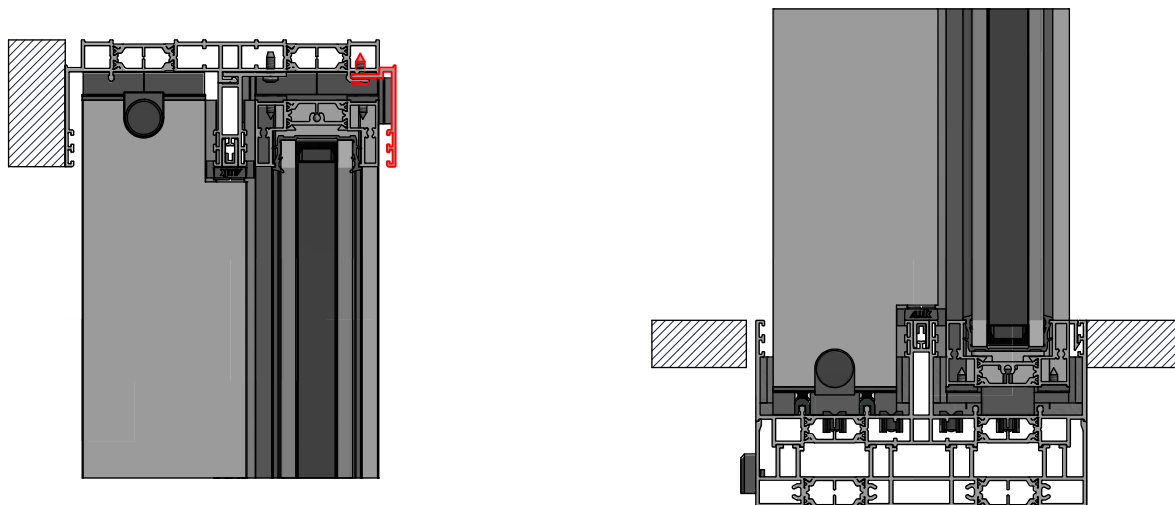
Panel Installation continued:

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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