

OS2 75 AS

CATALOGO
TECNICO
TECHNICAL
CATALOGUE

METALFORM
versione 02/2020

The logo for Secco, featuring the word "secco" in white lowercase letters on a red trapezoidal background.

secco

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OS2 75 AS è un sistema integrato di accessori, guarnizioni e profilati a **taglio termico** aventi profondità di 84 mm e sezione in vista di 47 mm. Il sistema consente di realizzare serramenti alzanti scorrevoli da una a quattro ante, apribili e/o fisse. Il peso massimo delle singole ante è di 250 kg e il sistema installa vetri a doppia camera da 43/45 mm di spessore.

Le prestazioni di tenuta al passaggio di aria e acqua e di isolamento acustico sono ottenute grazie alla compressione dei giunti di tenuta durante la chiusura delle ante. Tali giunti sono progettati con doppia guarnizione di tenuta sui quattro lati, un dedicato profilo soglia per il drenaggio dell'acqua e speciali tamponi in gomma e neoprene posizionati alle estremità verticali del giunto centrale.

Ogni tipologia è provvista di apposita accessoristica di movimentazione e chiusura a scomparsa ed integrata al sistema con chiusure multiple: tutte le soluzioni possono essere motorizzate tramite l'installazione dei gruppi motore, dedicati e a scomparsa, che ne consentono l'alzata e lo scorrimento.

Le prestazioni del sistema a taglio termico **OS2 75 AS** sono state testate, nelle configurazioni più estreme di peso e dimensione, dai migliori Laboratori di certificazione Europei secondo le norme di riferimento EN 14351-1.

OS2 75 AS is an integrated system of accessories, gaskets and **thermally broken** cold-rolled profiles with a nominal depth of 84 mm and visible section of 47 mm. The system allows the manufacture of lift-and-slide doors with up to four sashes openable and/or fixed. The maximum weight per sash is 250 kg, and the system can be fitted with a TGU of 43/45 mm thick.

High performance of the system in terms of air permeability, watertightness and sound reduction is achieved thanks to the compression provided by the sealing joints in closing position. These joints are designed with double sealing gaskets along all four sides, a dedicated threshold profile for water drainage and special rubber and neoprene pads positioned at the top of the central joint.

Each typology comes with a dedicated set of accessories for concealed handling and multi-locking system: all configurations can be automated by means of dedicated and concealed motor units, which allow the lifting and sliding of the system.

The performances of the thermally broken system **OS2 75 AS** have been tested in the most extreme configurations of weight and size from the best European certification laboratories according to the reference standards EN 14351-1.

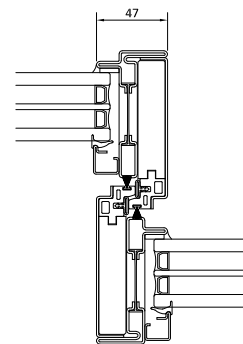
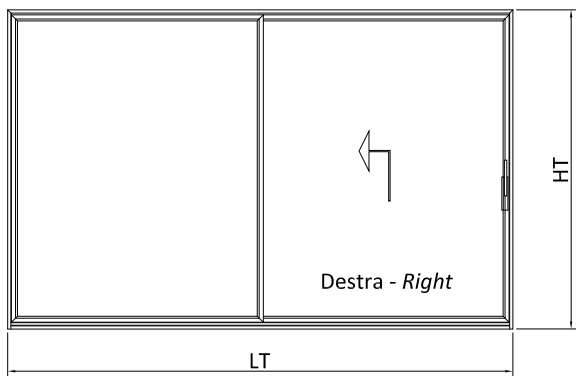
PRESTAZIONI

Trasmittanza termica (UNI EN 14351/1)
- Uw fino a 1,4 W/m²K
Resistenza all'aria (UNI EN 12207)
- fino a classe 4
Resistenza all'acqua (UNI EN 12208)
- fino a classe 5A
Resistenza al vento (UNI EN 12210)
- fino a classe C3
Forze di azionamento (UNI EN 12046/1)
- Classe 1 < 100 N

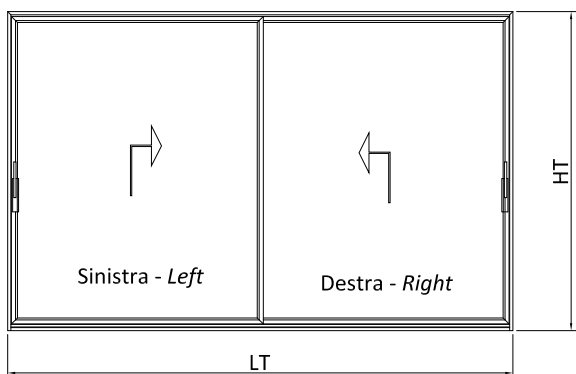
PERFORMANCE

Thermal transmittance (UNI EN 14351/1)
- Uw up to 1,4 W/m²K
Air permeability (UNI EN 12207)
- up to class 4
Watertightness (UNI EN 12208)
- up to class 5A
Resistance to wind load (UNI EN 12210)
- up to class C3
Operating forces (UNI EN 12046/1)
- Class 1 < 100 N

Schema | Type A 1 anta scorrevole ed 1 anta fissa
1 sliding and 1 fixed sash

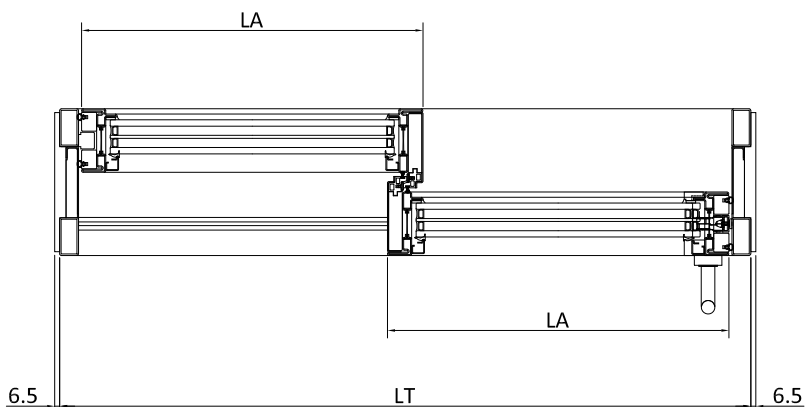
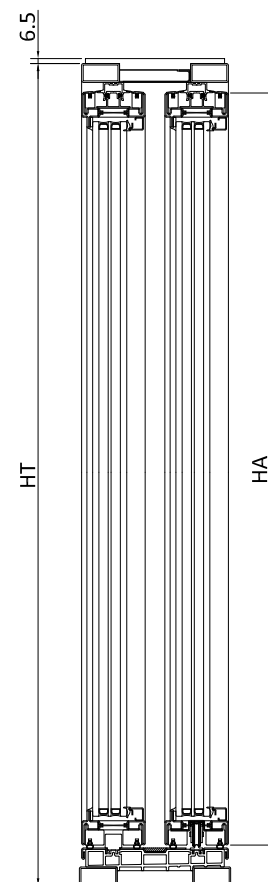


Schema | Type B 2 ante scorrevoli
2 sliding sashes

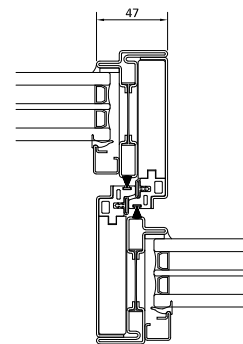
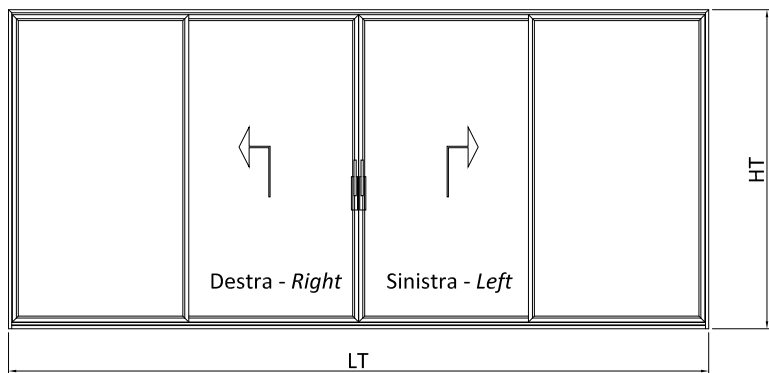


Limiti dimensionali | Dimensional limits (mm)

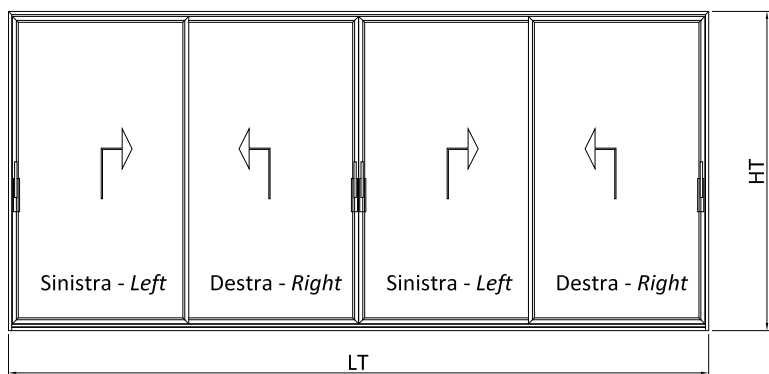
Telaio Frame	LT	1711 - 3131	LT
	HT	1227 - 3000	HT
Anta Sash	LA	850 - 1560	LT/2-5.5
	HA	1135 - 2908	HT - 93
Peso Weight	250 kg		



Schema | Type E 2 ante scorrevoli e 2 ante fisse
2 sliding and 2 fixed sashes

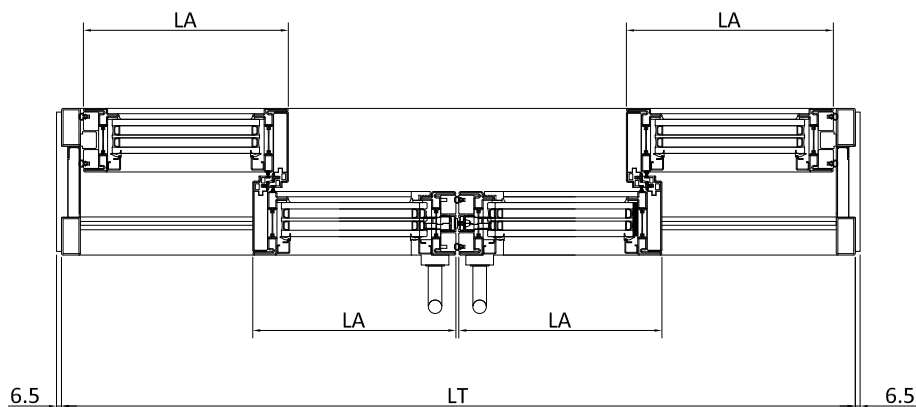
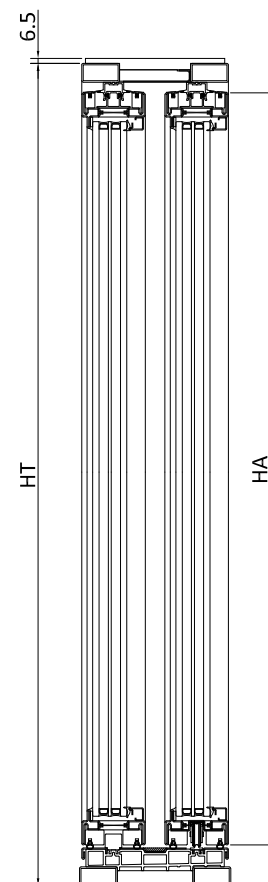


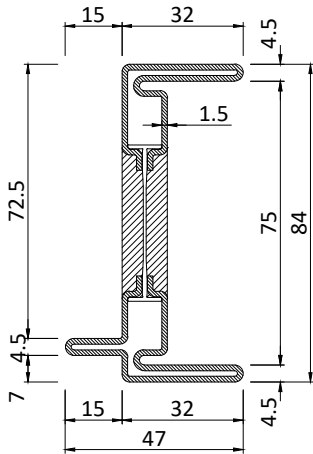
Schema | Type F 4 ante scorrevoli
4 sliding sashes



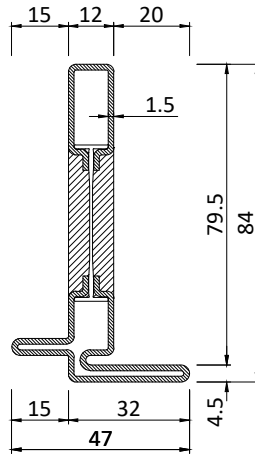
Limiti dimensionali | Dimensional limits (mm)

Telaio Frame	LT	3368 - 6208	LT
	HT	1227 - 3000	HT
Anta Sash	LA	850 - 1560	LT/2-5.5
	HA	1135 - 2908	HT - 93
Peso Weight	250 kg		

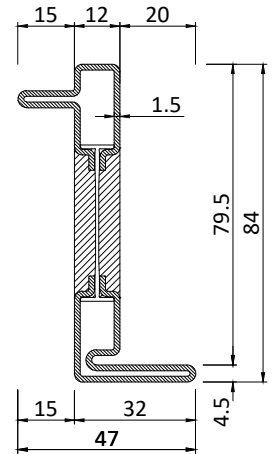




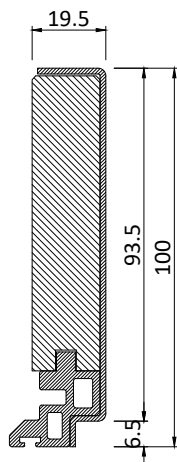
PR2975



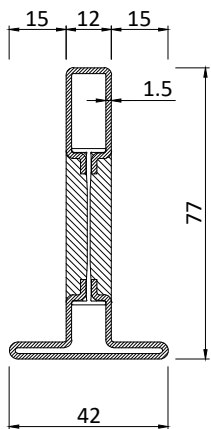
PR2988



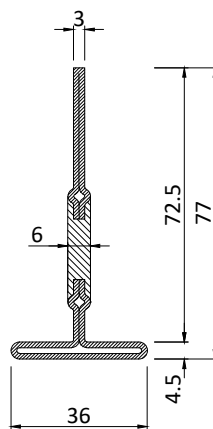
PR2989



PR2946



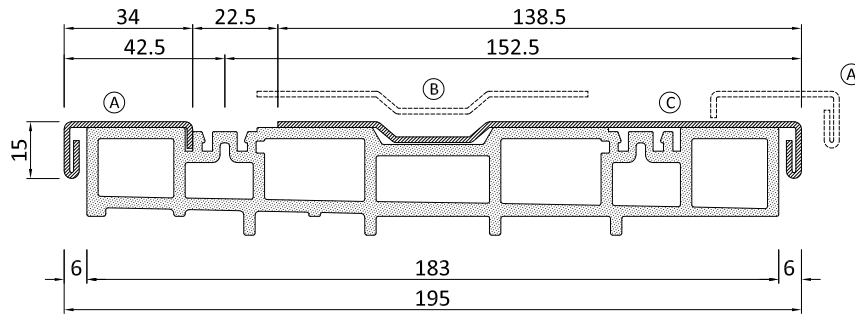
PR2952



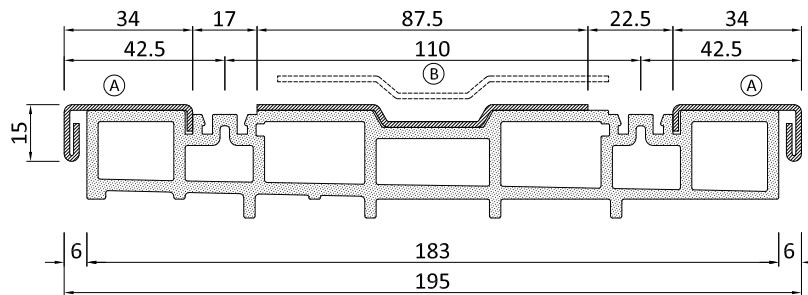
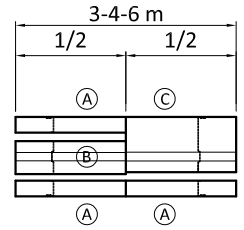
PR2954

Non fornito in acciaio inox
Not in stainless steel

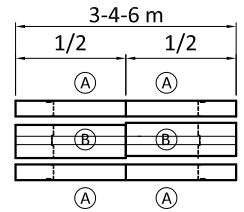
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
PR2975	3,52	3,77	0,32	32,75	4,36	6,0	PR2954	2,33	2,55	0,22	19,90	1,20	6,0
PR2988	2,96	3,17	0,27	22,62	3,03	6,0							
PR2989	2,95	3,15	0,27	25,66	2,85	3 - 4							
PR2946	3,25	3,40	0,13			3 - 4							
PR2952	2,51	2,68	0,23	18,14	2,18	6,0							



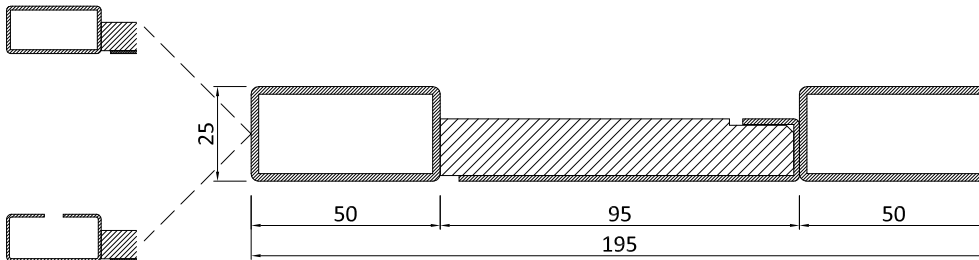
PR2983



PR2984

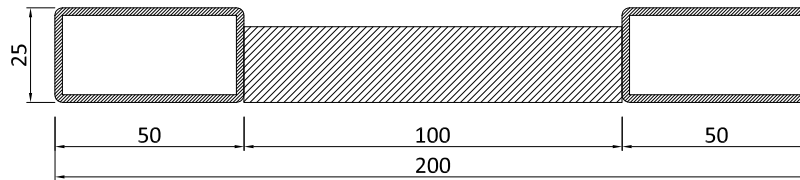


acciaio zincato
galvanized steel



PR2986

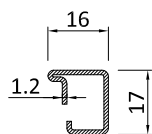
acciaio inox-corten-ottone
stainless steel-corten-brass



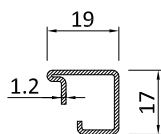
PR1195

disponibile in acciaio zincato o
acciaio inox
available in galvanized steel or
stainless steel

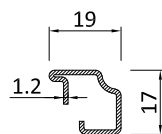
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
PR2983	7,30	7,65	0,25			3 - 4 - 6							
PR2984	4,70	5,10	0,25			3 - 4 - 6							
PR2986	7,30	7,65	0,45			3 - 4							
PR1195	6,60					3 - 4 - 6							



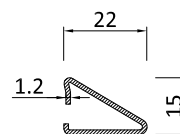
PR2606



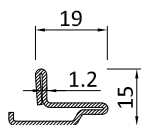
PR2607



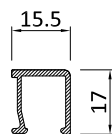
PR2627



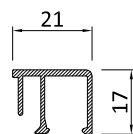
PR2629



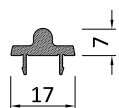
PR2638



PA2606

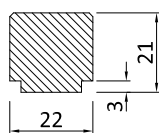


PA2607

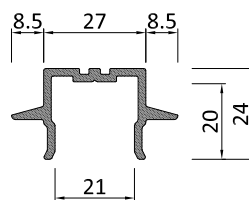


PA1194

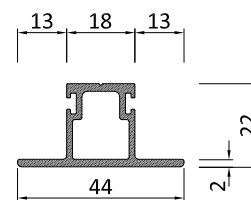
PA1194.NE



GU2905



GU2955

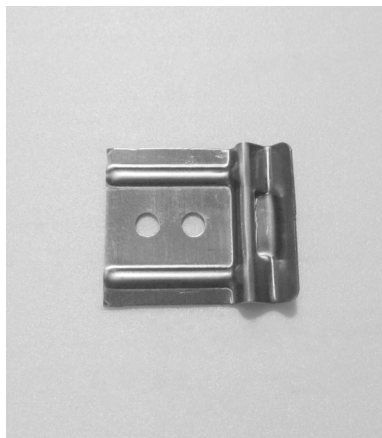


GU2956

MATERIALE | MATERIAL

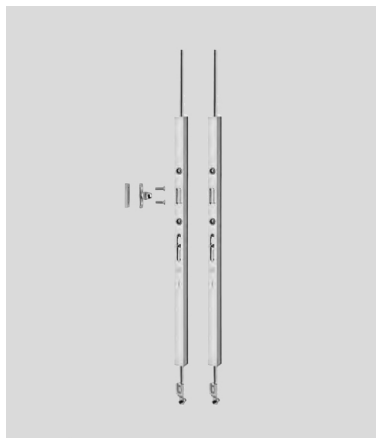
PR ____ ZN acciaio zincato | *galvanized steel*PR ____ CZ acciaio corten grezzo | *untreated corten steel*PR ____ SB acciaio inox scotch brite | *stainless steel scotch brite*PR ____ BR ottone grezzo | *untreated brass*

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
PR2606	0,48	0,52				6,0	PA1194	0,20		alluminio argento aluminium silver			6,0
PR2607	0,51	0,55				6,0	PA1194.NE	0,20		alluminio nero aluminium black			6,0
PR2627	0,47	0,51				6,0	GU2905	0,30		PVC			3,0
PR2629	0,49	0,53				6,0	GU2955	0,26		poliammide polyamide			3 - 4 - 6
PR2638	0,60	0,68				6,0	GU2956	0,23		poliammide polyamide			3 - 4 - 6
PA2606	0,17		alluminio aluminium			6,0							
PA2607	0,23		alluminio aluminium			6,0							

**AC 2608**

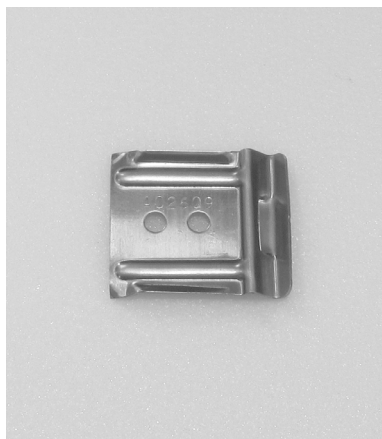
Clips per fissaggio fermavetri
PR2606 - PR2607 - PR2627 -
PR2629 - PR2638

*Clips for glazing bead
PR2606 - PR2607 - PR2627 -
PR2629 - PR2638*

**AG 2989.EF**

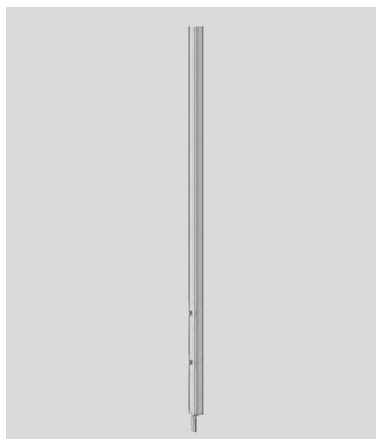
Kit prolunga aggiuntiva
cremonese per soluzione
coassiale

*Additional extension kit for
cremone bolt set on coaxial leaf
solution*

**AC 2609**

Clips per fissaggio fermavetri
PR2606 - PR2607 - PR2627
su profilo PR2954

*Clips for glazing bead
PR2606 - PR2607 - PR2627
on PR2954 profile*

**AG 2989 C**

Profilo di copertura aggiuntivo
cremonese
H 1000 mm

*Additional covering profile for
cremone bolt
H 1000 mm*

**AC 2993 P**

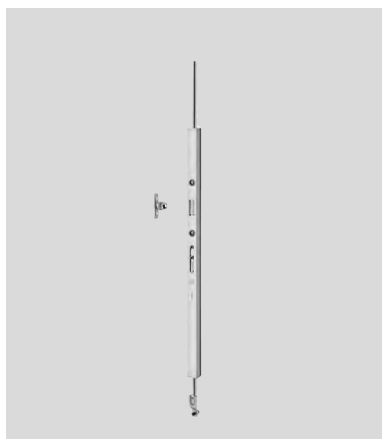
Accessorio assiempaggio telaio
PR2986

*Frame assembling accessory
PR2986*

**AG 2992.AB**

Rostro aggiuntivo

Additional hook bolt

**AG 2989.AB**

Kit prolunga aggiuntiva
cremonese

*Additional extension kit for
cremone bolt set*

**AG 2992.EF**

Rostro aggiuntivo per
soluzione coassiale

*Additional hook bolt on coaxial
leaf solution*



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

CV 1023.

Vite per boccia fermavetro
in alluminio, TPS 4.2x13

*Screw for aluminium glazing
bead bushing, TPS 4.2x13*

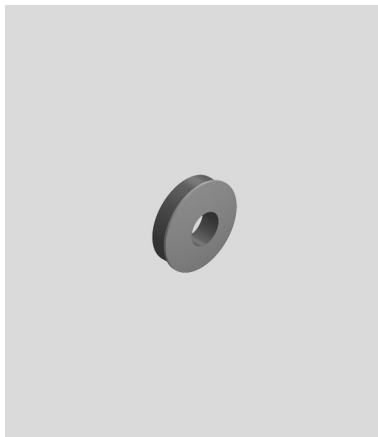


CV5012 acciaio zincato | galvanized steel
CV5012I acciaio inox | stainless steel

CV 5012.

Boccia per fermavetro in
alluminio
PA2606

*Bushing for aluminium
glazing bead
PA2606*



CV 5403 I

Rondella in acciaio inox/EPDM
vulcanizzato per viti di
assieme telaio inferiore
PR2983 - PR2984 con PR1195

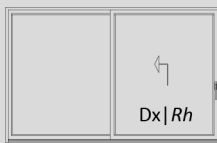
*Stainless steel/vulcanised EPDM
washer for assembly screws on
bottom-rail profil
PR2983 - PR2984 with PR1195*

Tabella determinazione range dimensione ante per ordine kit movimentazione e tenuta

Table for sash range for the order of the handling and sealing kit

		altezza - height				
		1135	1751	2101	2351	2701
		1750	2100	2350	2700	2908
larghezza width	XX	A1	B1	C1	D1	E1
	850 - 1560					

Schema | Type A



AG 2986A.xx

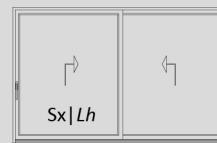
Kit movimentazione e tenuta
1 anta apribile - anta dx

portata fino a 250 kg

1 leaf handling and sealing
kit - RH

load up to 250 kg

Schema | Type B



AG 2987B.xx

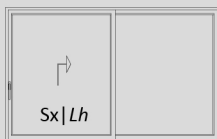
Kit movimentazione e tenuta 2
ante apribili - 1^ anta sx

portata fino a 250 kg

2 leaf handling and sealing
kit - LH master

load up to 250 kg

Schema | Type A



AG 2987A.xx

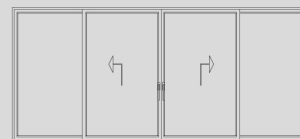
Kit movimentazione e tenuta
1 anta apribile - anta sx

portata fino a 250 kg

1 leaf handling and sealing
kit - LH

load up to 250 kg

Schema | Type E



AG 2986E.xx

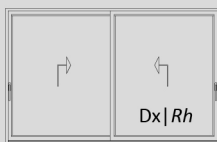
Kit movimentazione e tenuta 2
ante apribili

portata fino a 250 kg

2 leaf handling and sealing kit

load up to 250 kg

Schema | Type B



AG 2986B.xx

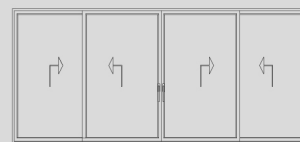
Kit movimentazione e tenuta 2
ante apribili - 1^ anta dx

portata fino a 250 kg

2 leaf handling and sealing
kit - RH master

load up to 250 kg

Schema | Type F



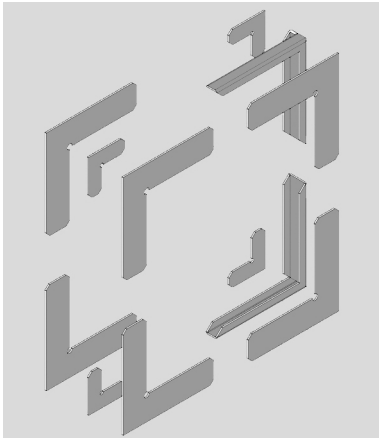
AG 2986F.xx

Kit movimentazione e tenuta 4
ante apribili

portata fino a 250 kg

4 leaf handling and sealing kit

load up to 250 kg



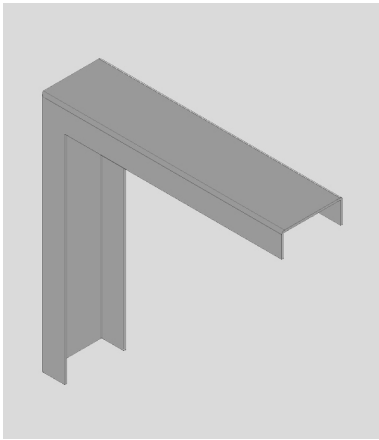
AC 290ANT

Kit squadrette di giunzione angoli
per anta apribile o fissa

Acciaio inox

*Corner joint kit for openable or
fixed sash*

Stainless steel



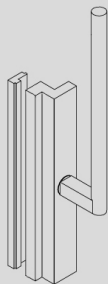
AC 290TES

Squadrette di giunzione
angolo telaio esterno
PR2986

Acciaio inox

*Corner joint for external frame
PR2986*

Stainless steel

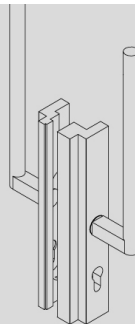


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 096.xx

Maniglione singolo con scatola
copri serratura per
fermavetro PR2606-2607-2627
PA2606-2607

*Single handle with box lock
cover for glazing beads
PR2606-2607-2627
PA2606-2607*

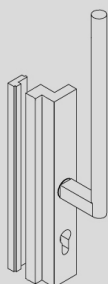


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 196Y.xx.S

Maniglione doppio con scatola
copri serratura destra e foro
chiave europea per
fermavetro PR2606-2607-2627
PA2606-2607

*Double handle with right box
lock cover and european key
hole for glazing beads
PR2606-2607-2627
PA2606-2607*

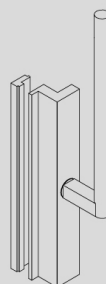


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 096Y.xx.D

Maniglione singolo con scatola
copri serratura destra e foro
chiave europea per
fermavetro PR2606-2607-2627
PA2606-2607

*Single handle with right box lock
cover and european key hole for
glazing beads
PR2606-2607-2627
PA2606-2607*

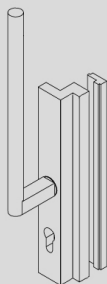


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 097.xx

Maniglione singolo con scatola
copri serratura per
fermavetro PR2629-2638

*Single handle with box lock
cover for glazing beads
PR2629-2638*

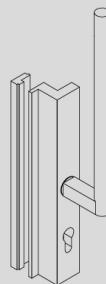


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 096Y.xx.S

Maniglione singolo con scatola
copri serratura sinistra e foro
chiave europea per
fermavetro PR2606-2607-2627
PA2606-2607

*Single handle with left box lock
cover and european key hole for
glazing beads
PR2606-2607-2627
PA2606-2607*

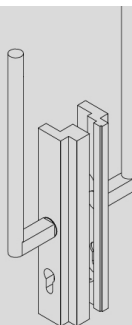


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 097Y.xx.D

Maniglione singolo con scatola
copri serratura destra e foro
chiave europea per
fermavetro PR2629-2638

*Single handle with right box lock
cover and european key hole for
glazing beads
PR2629-2638*

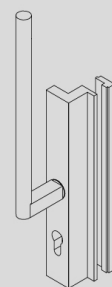


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 196Y.xx.D

Maniglione doppio con scatola
copri serratura destra e foro
chiave europea per
fermavetro PR2606-2607-2627
PA2606-2607

*Double handle with right box
lock cover and european key
hole for glazing beads
PR2606-2607-2627
PA2606-2607*

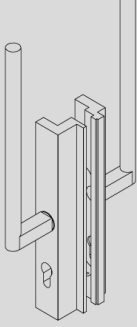


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 097Y.xx.S

Maniglione singolo con scatola
copri serratura sinistra e foro
chiave europea per
fermavetro PR2629-2638

*Single handle with left box lock
cover and european key hole for
glazing beads
PR2629-2638*

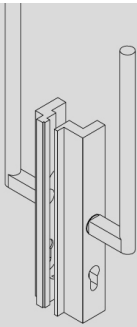


ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 197Y.xx.D

Maniglione doppio con scatola
copri serratura destra e foro
chiave europea per
fermavetro PR2629-2638

*Double handle with right box
lock cover and european key
hole for glazing beads
PR2629-2638*



ZN acciaio zincato | *galvanized steel*
SB acciaio inox | *stainless steel*
CZ acciaio corten | *corten steel*
BR ottone | *brass*

ACV 197Y.xx.S

Maniglione doppio con scatola
copri serratura destra e foro
chiave europea per
fermavetro PR2629-2638

*Double handle with right box
lock cover and european key
hole for glazing beads
PR2629-2638*

**GE 1001 ES**

Guarnizione laterale e inferiore ante

Sash uproghts an bottom rail gasket

**GE 2905**

Guarnizione superiore ante

Top-rail gasket

**GE 1011**

Guarnizione interna fermavetro spessore 3-4 mm

Internal gasket on 3-4 mm thick glazing bead

**GE 2907TT**

Guarnizione sotto vetro

Under glass gasket

**GE 1142**

Guarnizione di tenuta labirinto

Labyrinth sealing gasket

**GP 0095**

Guarnizione interna fermavetro spessore 3 mm

Internal glass gasket 3 mm thick

**GE 2606**

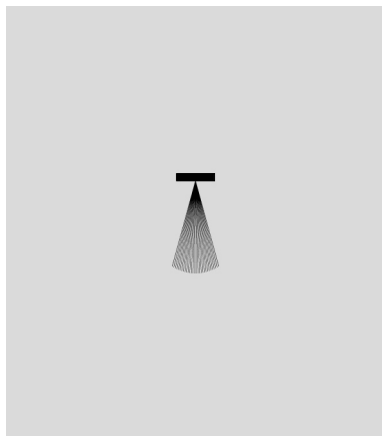
Guarnizione adesiva esterno vetro vedi pg. 5.1.1

Adhesive weather strip outer window see pg. 5.1.2

**GU 1147**

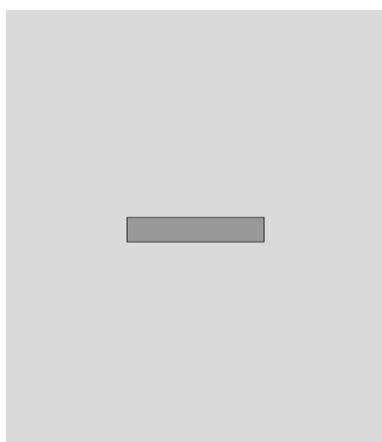
Spazzolino per guida superiore H=5 mm

Brush on upper sliding track H=5 mm

**GU 1387**

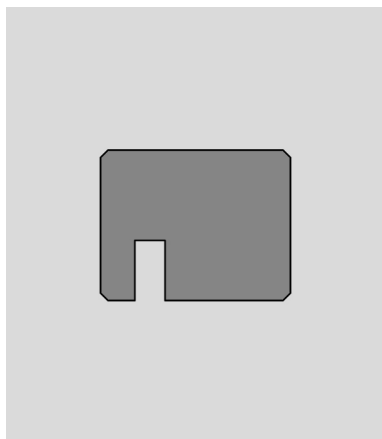
Spazzolino per labirinto
H=13 mm

*Brush for labyrinth joint
H=13 mm*

**GU 2036**

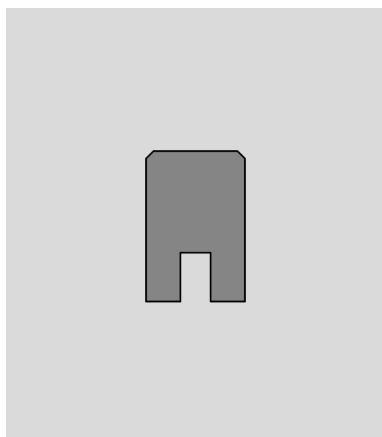
Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

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

**GU 2975L**

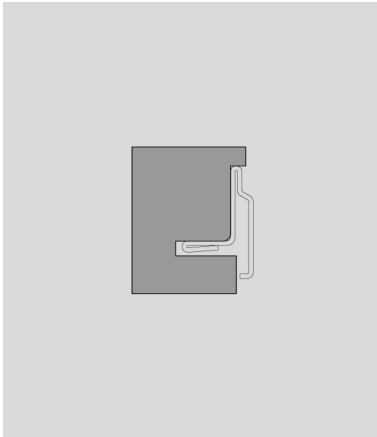
Profilo plastico porta
guarnizione perimetrale

*Plastic door profile
perimeter gasket*

**GU 2975S**

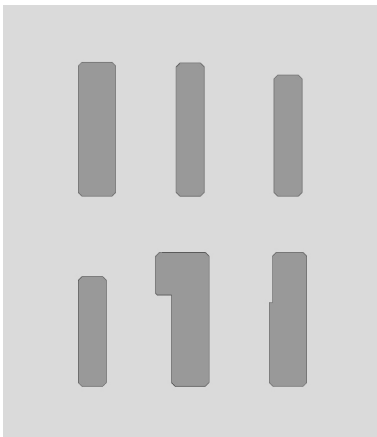
Profilo plastico porta
guarnizione superiore

*Plastic door profile
upper gasket*

**AT 2038**

Ganasce di taglio per
PR2638

*Cutting jaws for
PR2638*

**AT 2900**

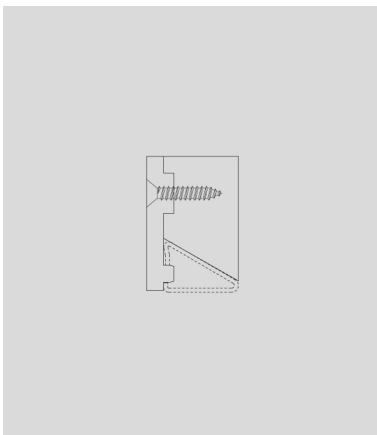
Kit ganasce di taglio

Kit of cutting jaws for profiles

**AT 2828**

Maschera per esecuzione fori
fissaggio fermavetri

*Drill jig for glazing beads
securing*

**AT 2829**

Ganasce di taglio per
fermavetro PR2629

*Kit of cutting jaws
for glazin bead PR2629*

**SA 005/01**

Liquido neritore per brunitura
1 Kg

Burnishing liquid
1 Kg

SA 005/10

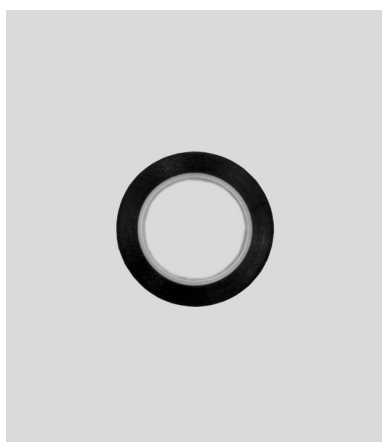
Liquido neritore per brunitura
10 Kg

Burnishing liquid
10 Kg

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA 1033**

Nastro adesivo protettivo per
verniciatura
33 mm

Adhesive tape for painting
33 mm

**SA 2032**

Primer di adesione per profili
verniciati

*Adhesion primer for painted
profiles*

**SA 2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**SA 2033**

Liquido di adesione per
materiale plastico

Adhesion liquid for plastic

**SA 2002**

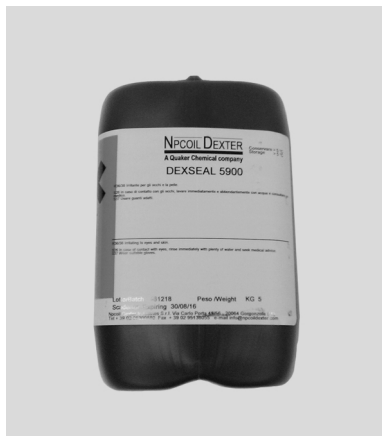
Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 3001**

Acido per ossidazione corten

Oxidising acid for corten

**SA 3002**

Passivante per ossidazione corten
25 Kg

*Passivating agent for corten
25 Kg*

SA 3002/5

Passivante per ossidazione corten
5 Kg

*Passivating agent for corten
5 Kg*

**SL 0022**

Adesivo cianoacrilico per
tamponi in neoprene

*Cyanoacrylic adhesive for
neoprene pads*

**SA 3003**

Cera d'api per finitura corten

Beeswax for Corten finishing

**SL 0019**

Sigillante a freddo per giunzione
angoli e traversi

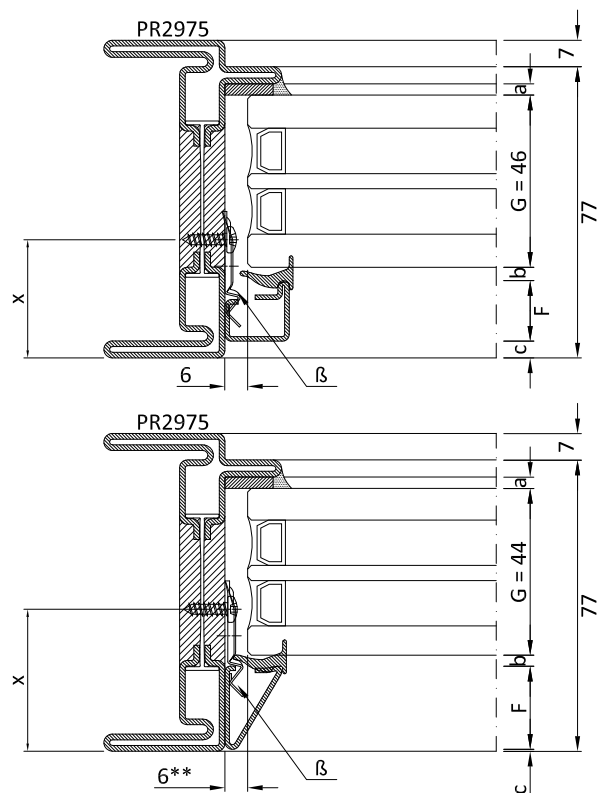
*Cold sealant for corner and
transom joints*

1 kg

**SL 0021**

Silicone nero per guarnizioni

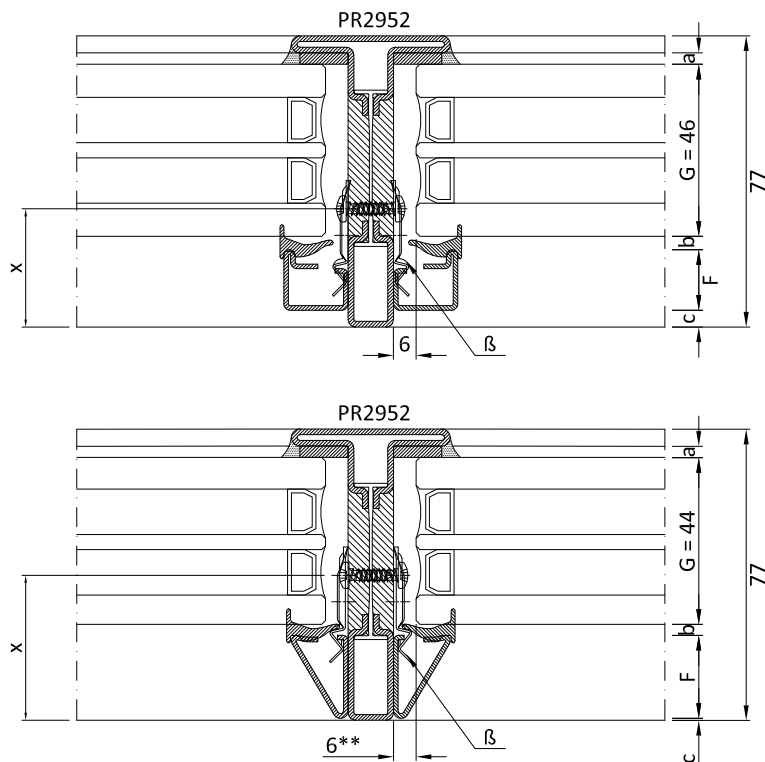
Black silicone for gaskets



F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	c	β
PR2606 	46	3	3	30.5	5	AC2608
PR2607 	46			30.5	2	AC2608
PR2627 	46			30.5	2	AC2608
PR2629 	44			37.5	0	AC2608
PR2638 	44			44.5	3	AC2608

** 7 mm per PR2638

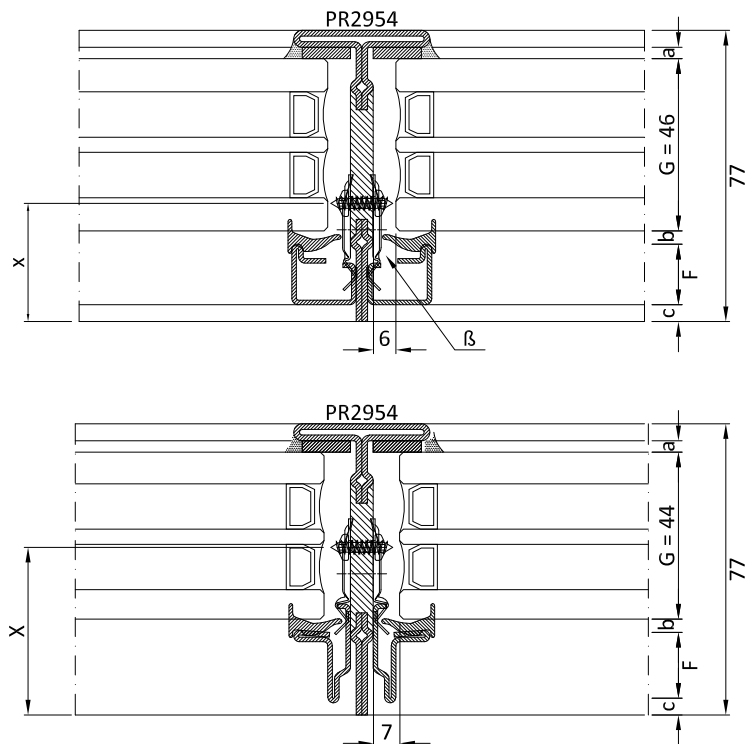
** 7 mm for PR2638



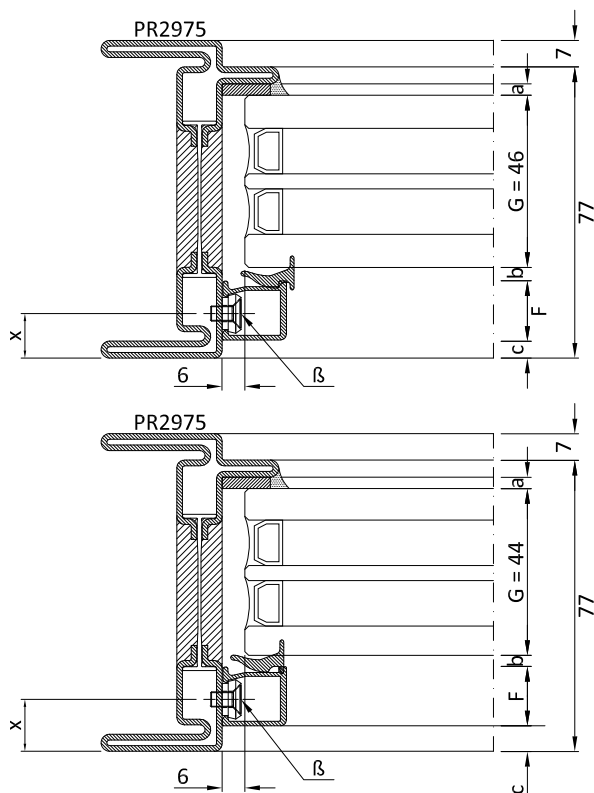
F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips
		GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm			
codice code	mm	a	b	x	c	β
PR2606 	46	3	3	30.5	5	AC2608
PR2607 	46			30.5	2	AC2608
PR2627 	46			30.5	2	AC2608
PR2629 	44			37.5	0	AC2608
PR2638 	44			44.5	3	AC2608

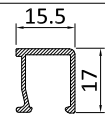
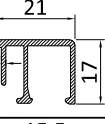
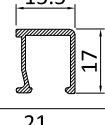
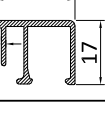
** 7 mm per PR2638

** 7 mm for PR2638

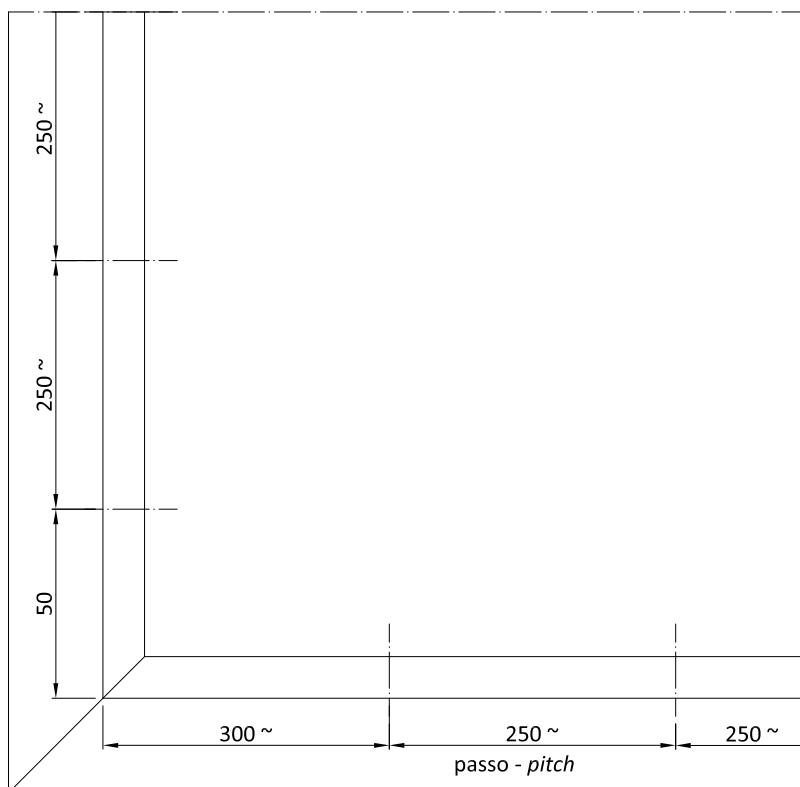
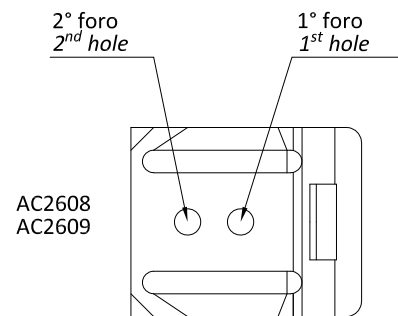
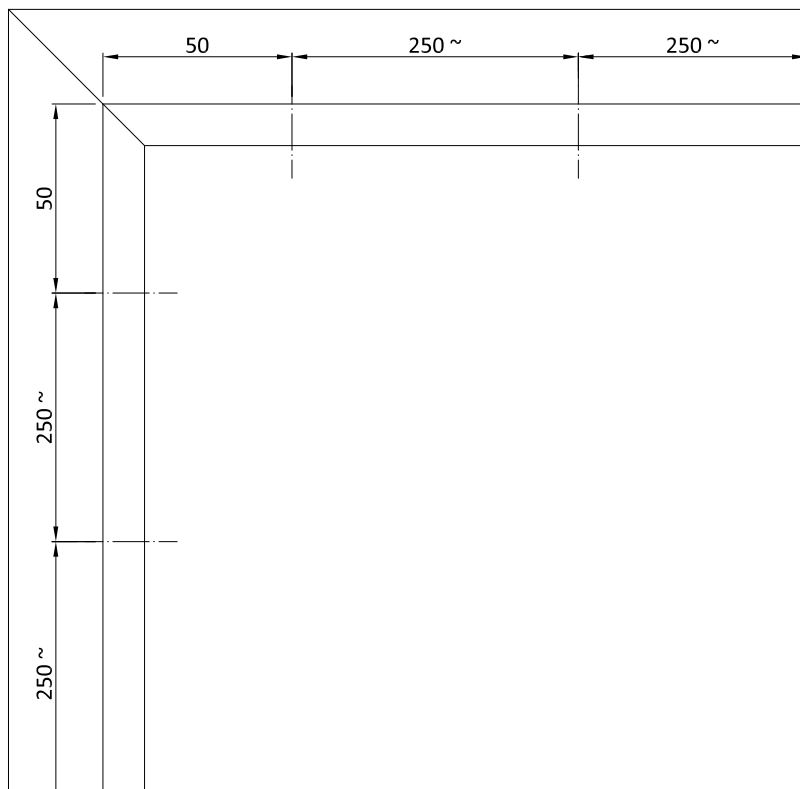


F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	c	β
 PR2606	46			31	5	AC2609
 PR2607	46	3	3	31	2	AC2609
 PR2627	46			31	2	AC2609
 PR2629	Non utilizzabile su PR2954 Cannot be used on PR2954					
 PR2638	44	3	3	44	3	AC2608 AC2609



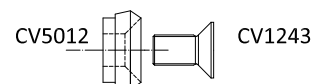
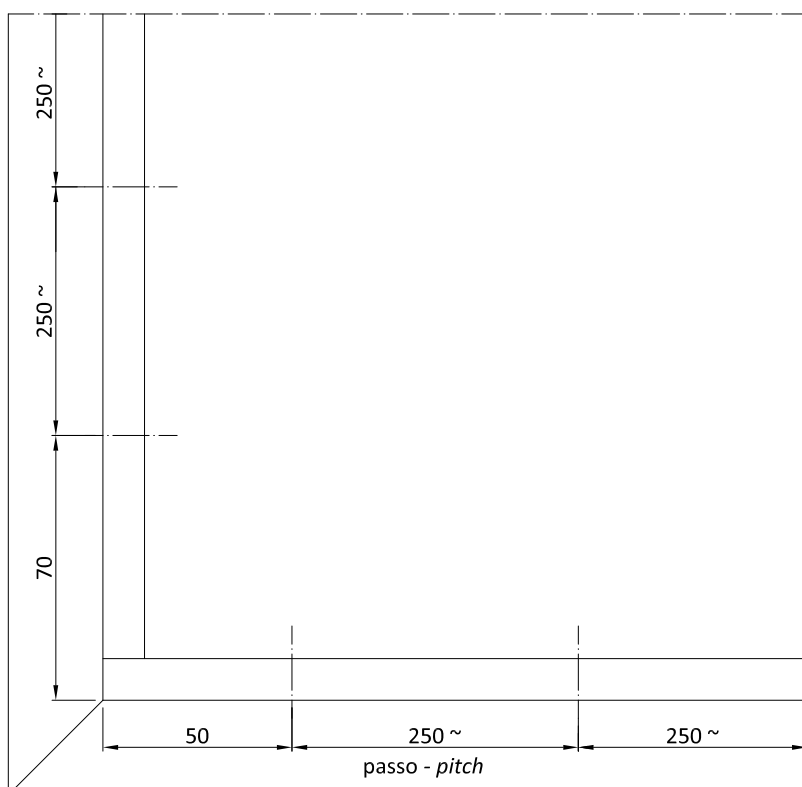
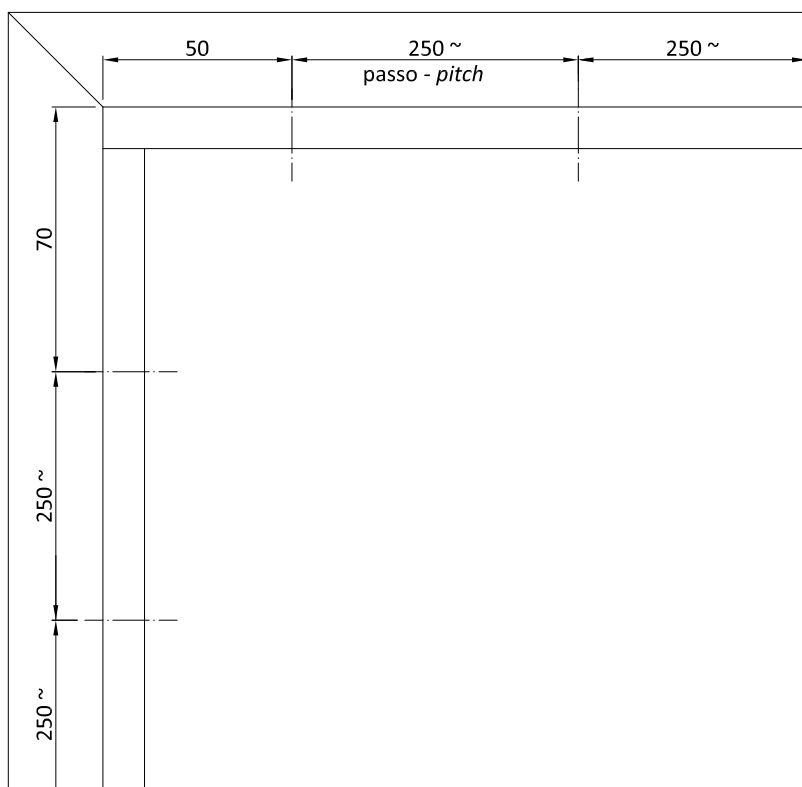
F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips
		GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm			
fermavetro glazing beads	spessore vetro glass thickness					
codice code	mm	a	b	x	c	β
PA2606 	46	3	3	12	5	CV1243(I) CV5012(I)
PA2607 	46			7	0	CV1243(I) CV5012(I)
PA2606 	44	3	3	13.5	7	CV1243(I) CV5012(I)
PA2607 	44			8	1	CV1243(I) CV5012(I)

Fissaggio fermavetri PR2606-PR2607-PR2627-PR2629-PR2638: clip AC2608/AC2609 con vite TC 3.5 x 9.5 (non fornite)
 Glazing beads fixing PR2606-PR2607-PR2627-PR2629-PR2638: clip AC2608 /AC2609 with screw TC 3.5 x 9.5 (not included)



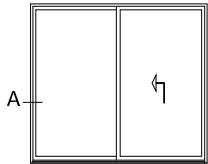
Passo clips fissaggio fermavetri
 Clip pitch for glazing beads securing

Fissaggio fermavetri PA2606-PA2607: vite CV1023(I) TPS 4,2 x 13 e boccola CV5012(I)
 Glazing bead fixing PA2606-PA2607: screw CV1023(I) TPS 4,2 x 13 and bushing CV5012(I)

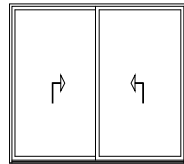


Passo vite e boccola fissaggio fermavetri
 Screw and bushing pitch for glazing beads fixing

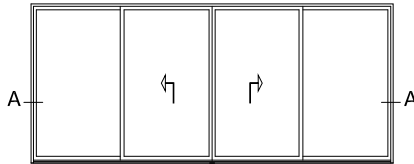
Schema | Type A



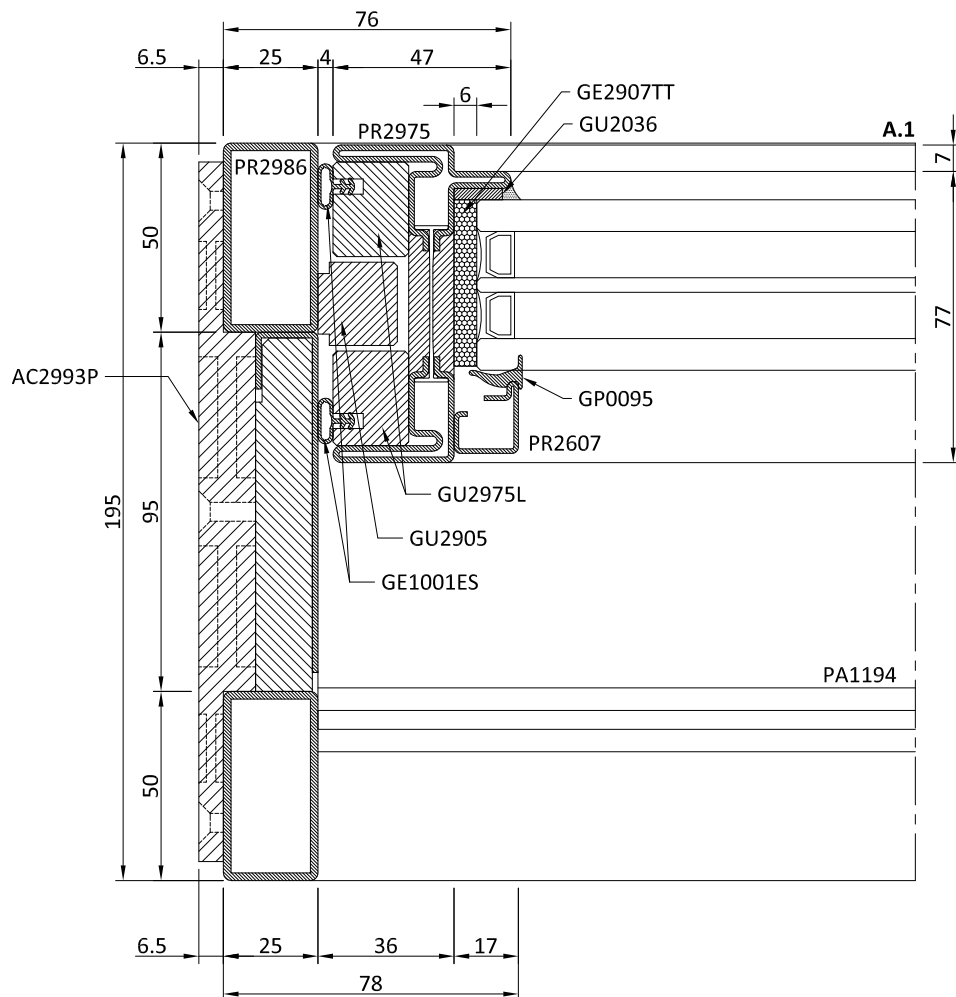
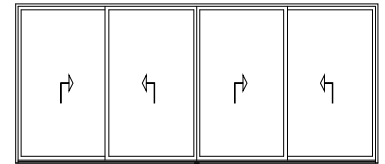
Schema | Type B



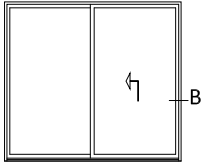
Schema | Type E



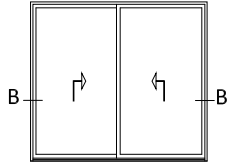
Schema | Type F



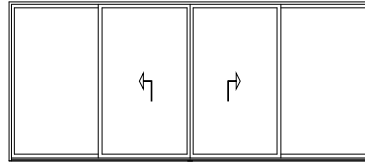
Schema | Type A



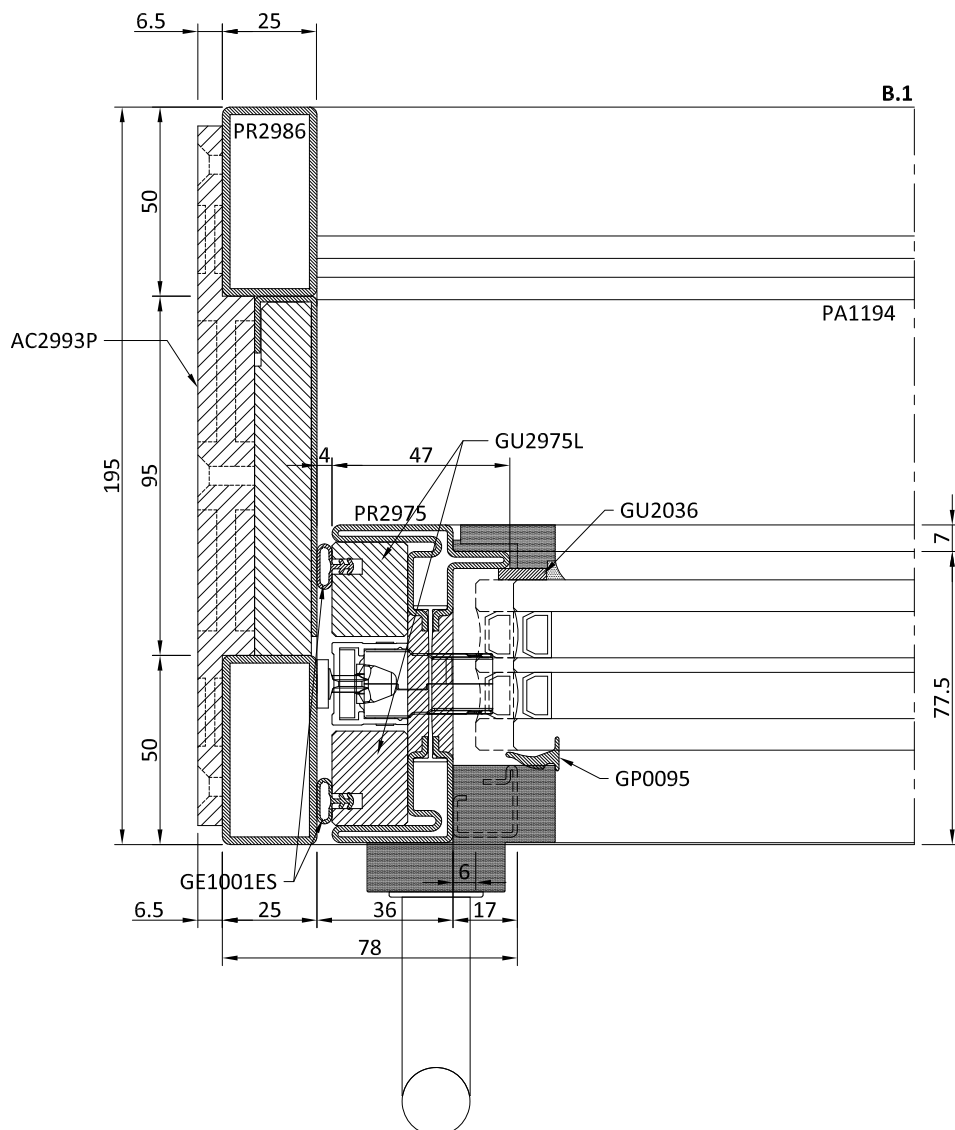
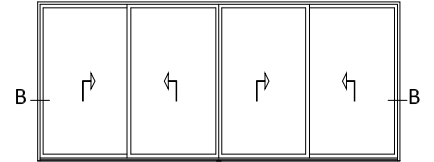
Schema | Type B



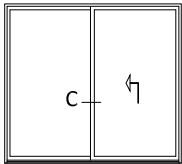
Schema | Type E



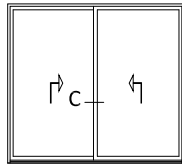
Schema | Type F



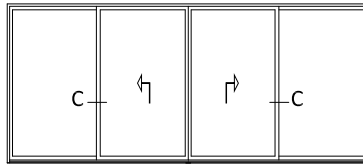
Schema | Type A



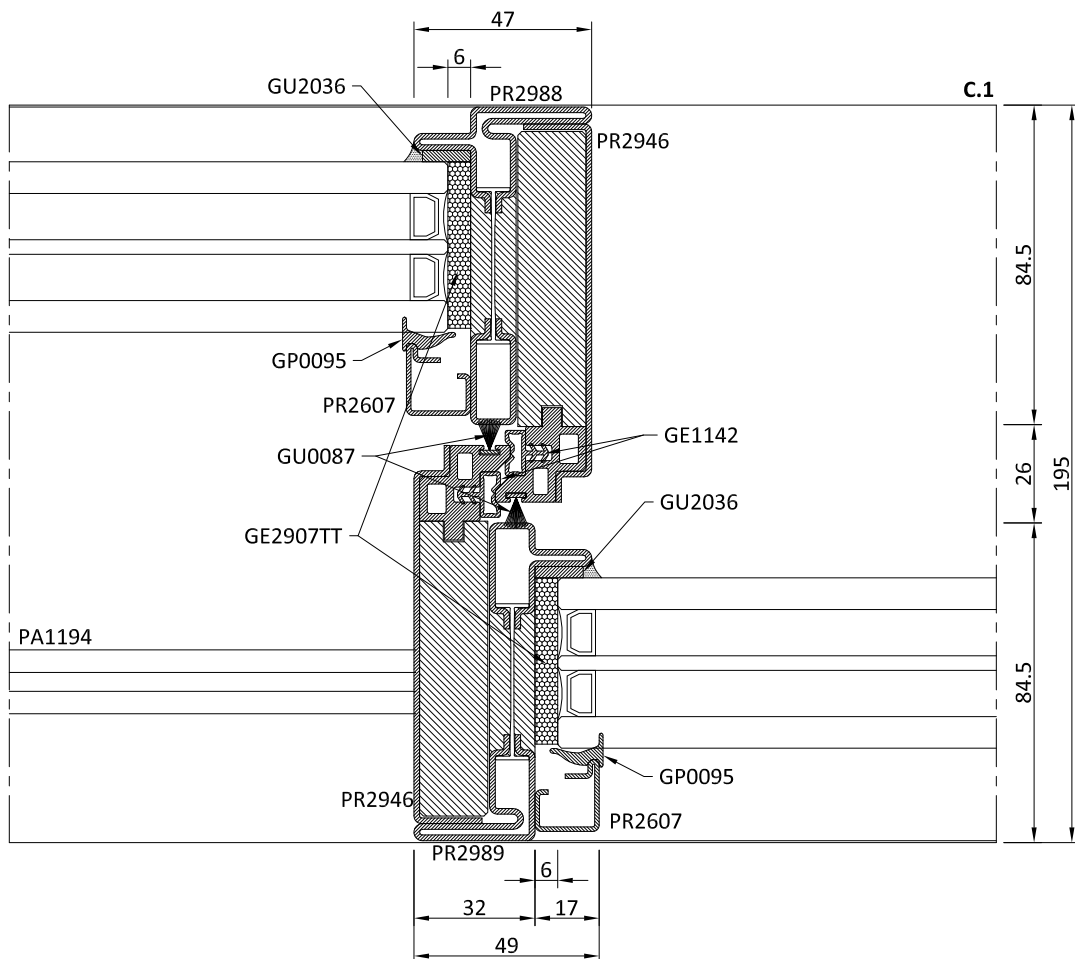
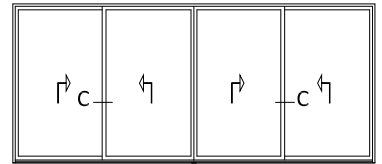
Schema | Type B



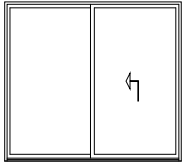
Schema | Type E



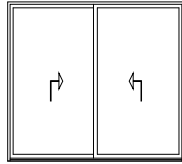
Schema | Type F



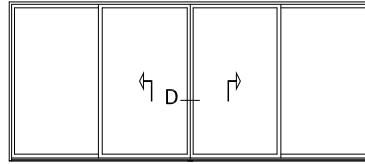
Schema | Type A



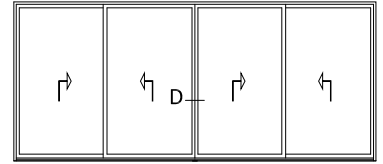
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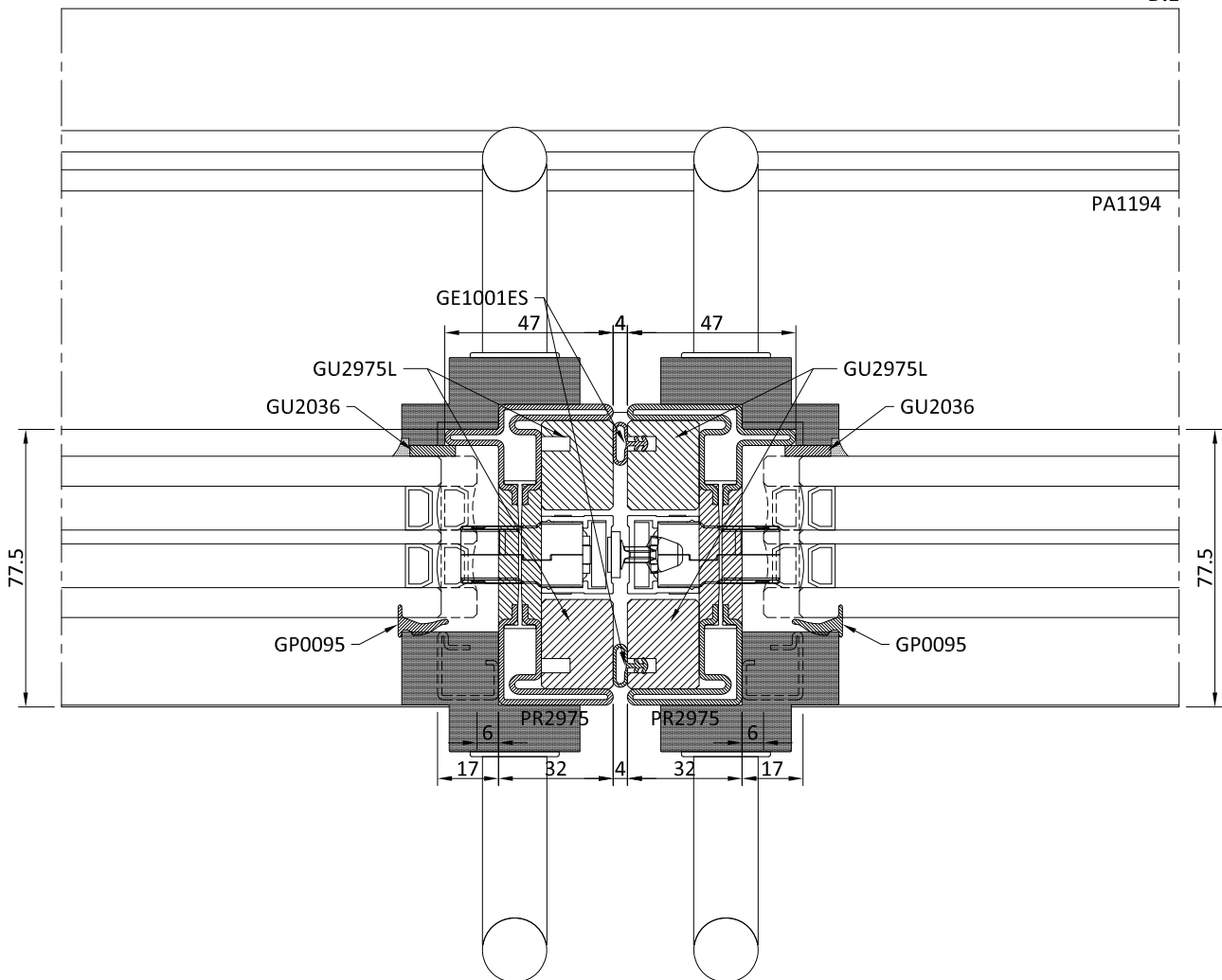
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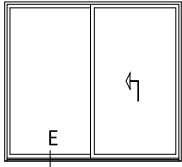
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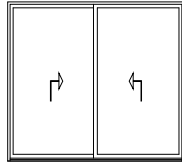
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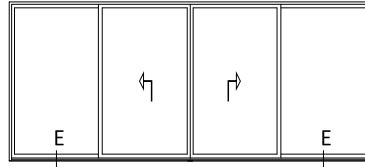
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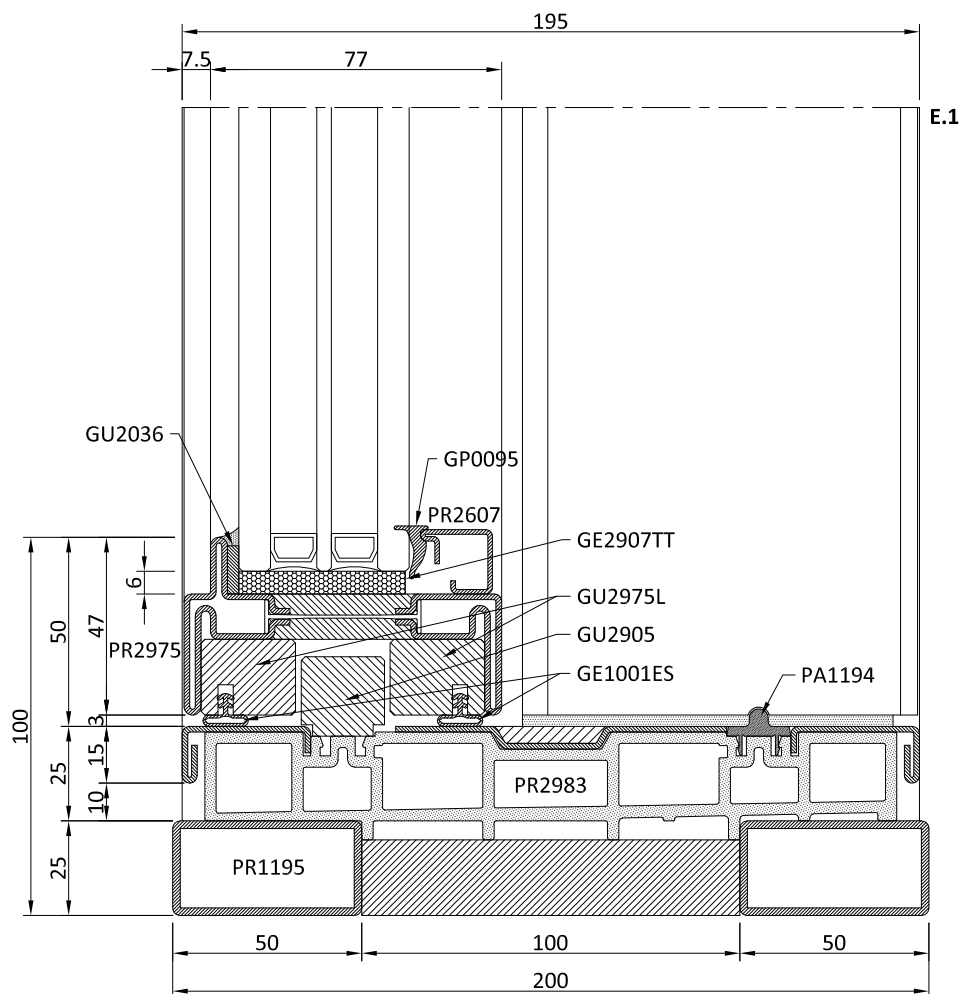
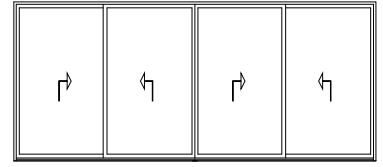
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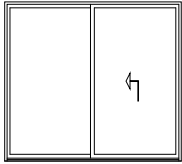
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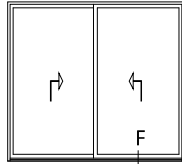
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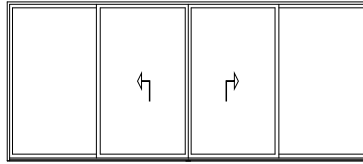
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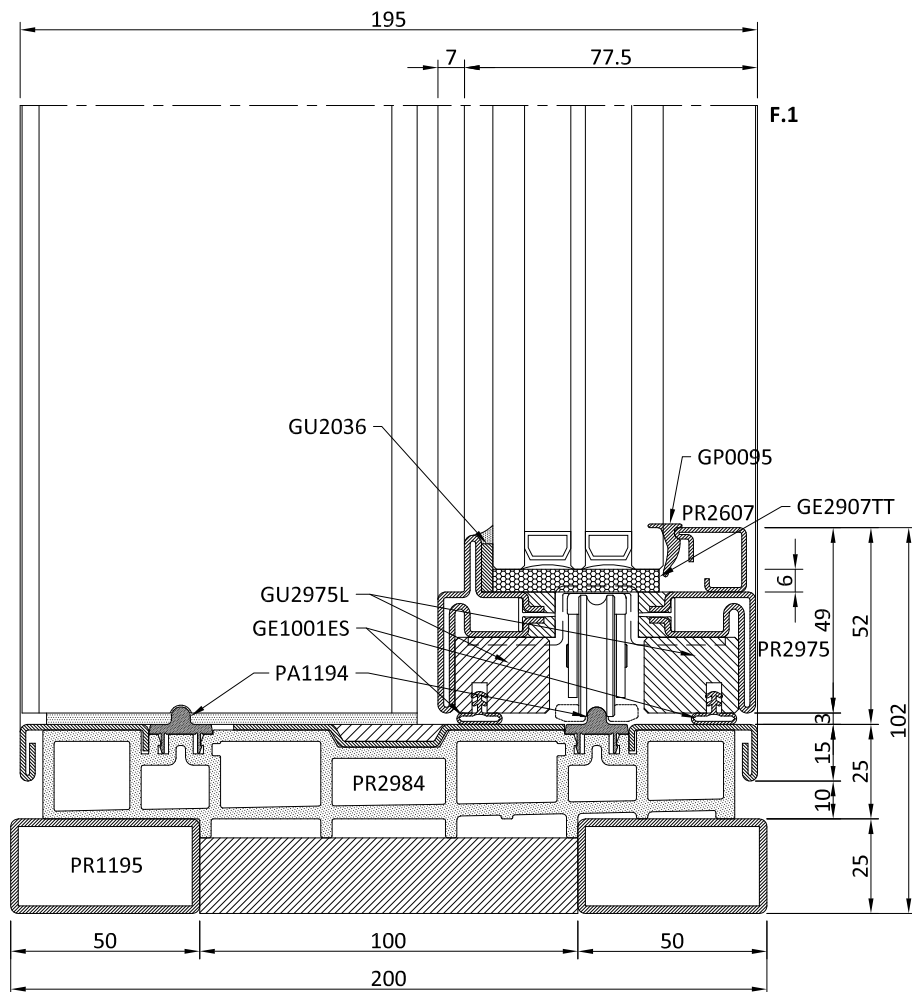
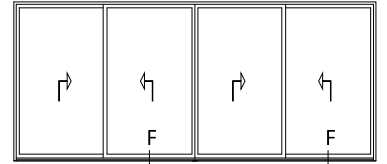
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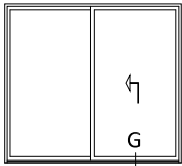
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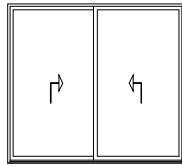
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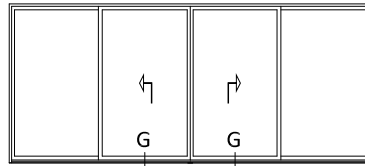
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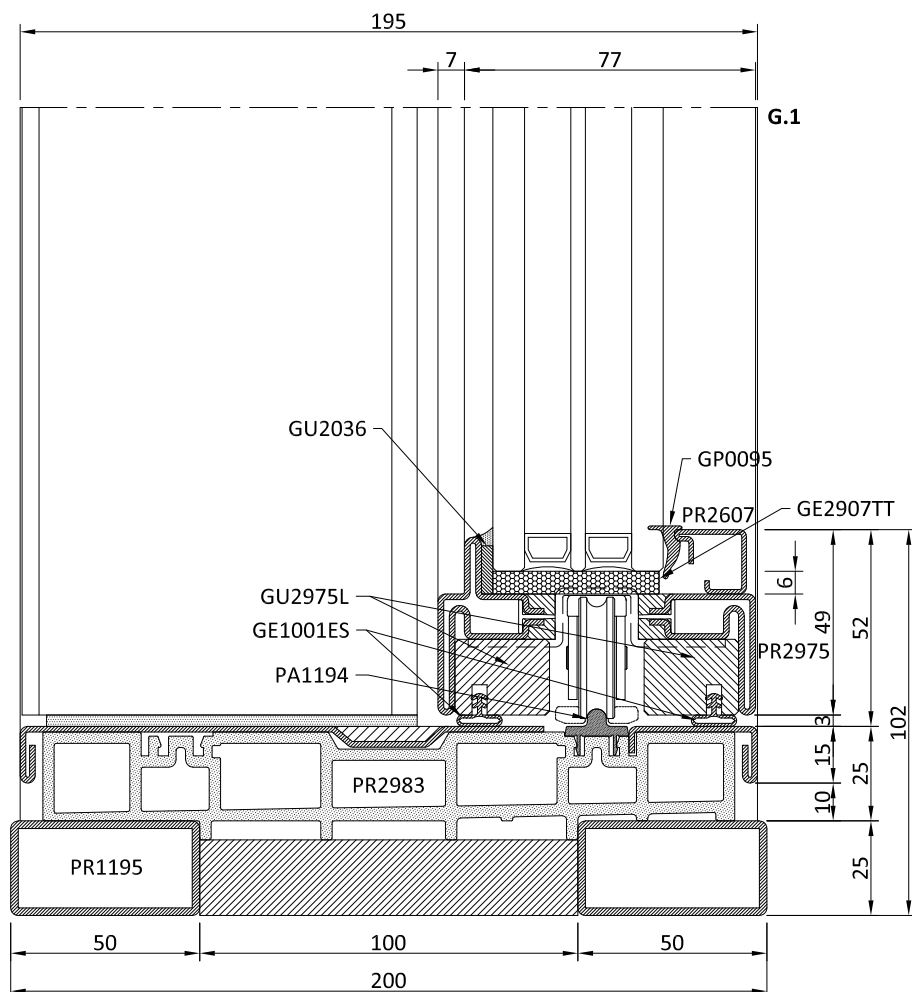
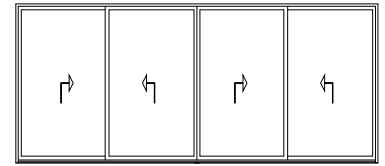
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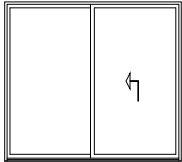
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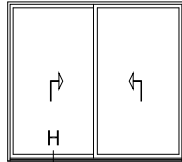
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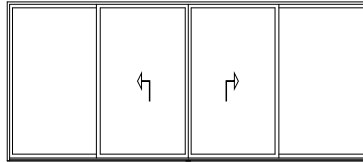
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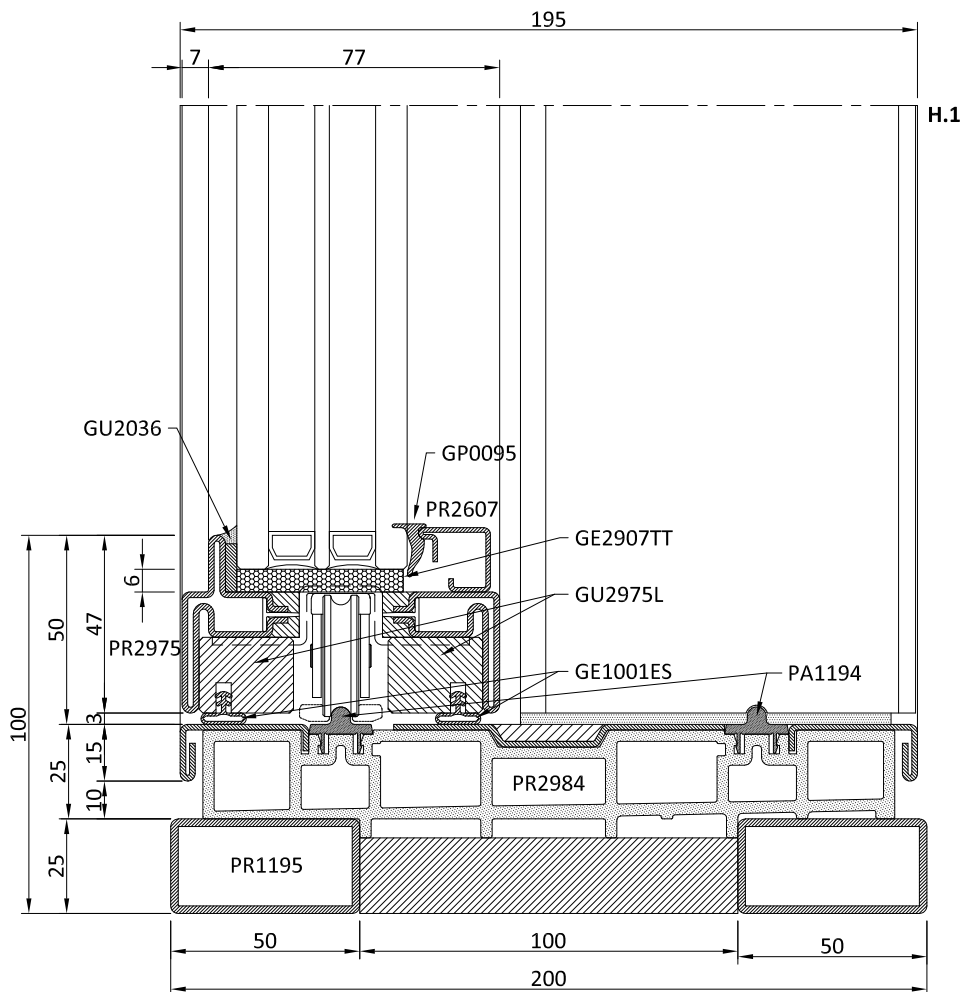
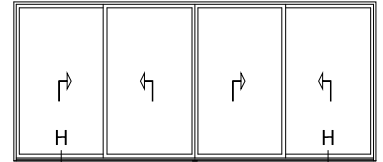
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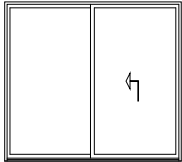
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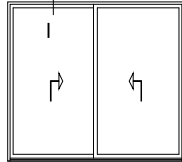
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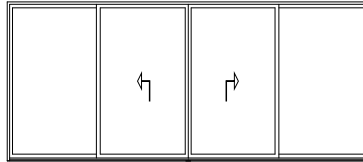
Schema | Type A



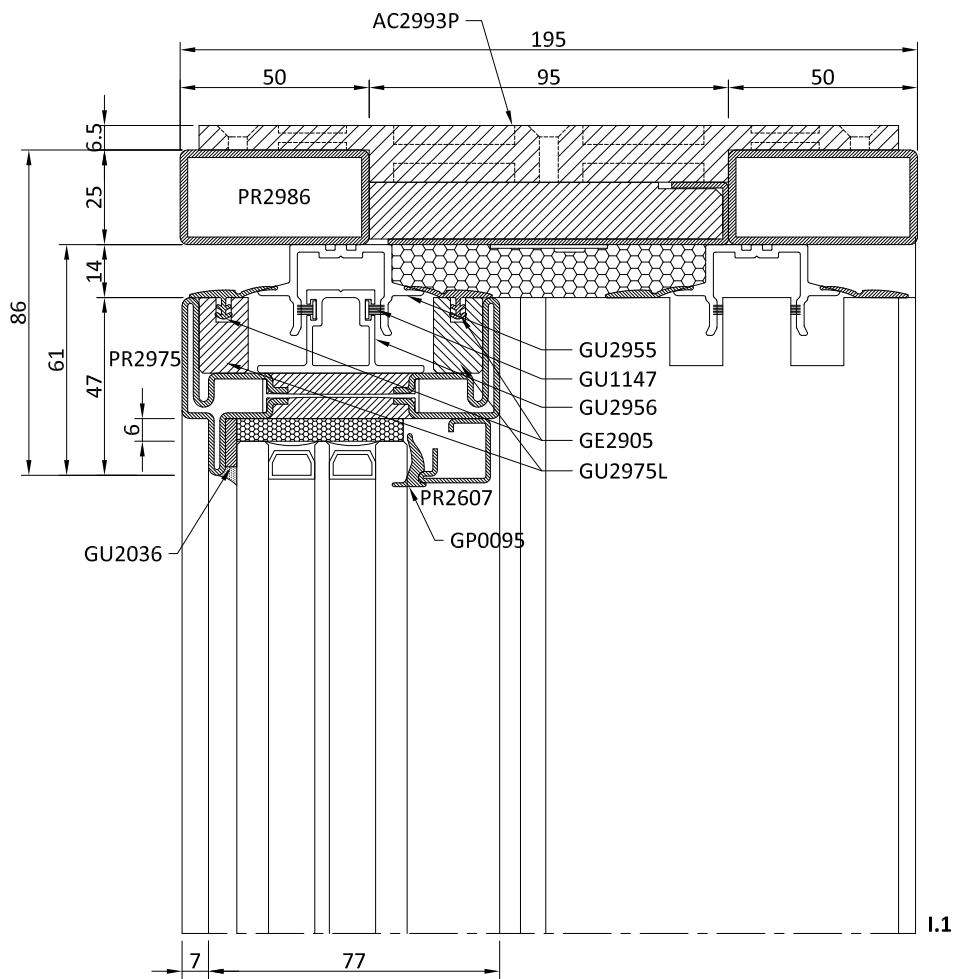
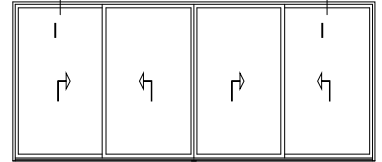
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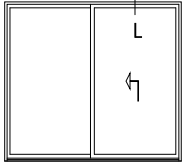
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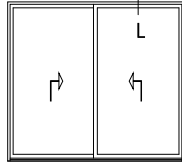
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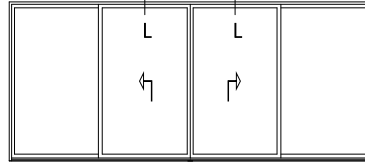
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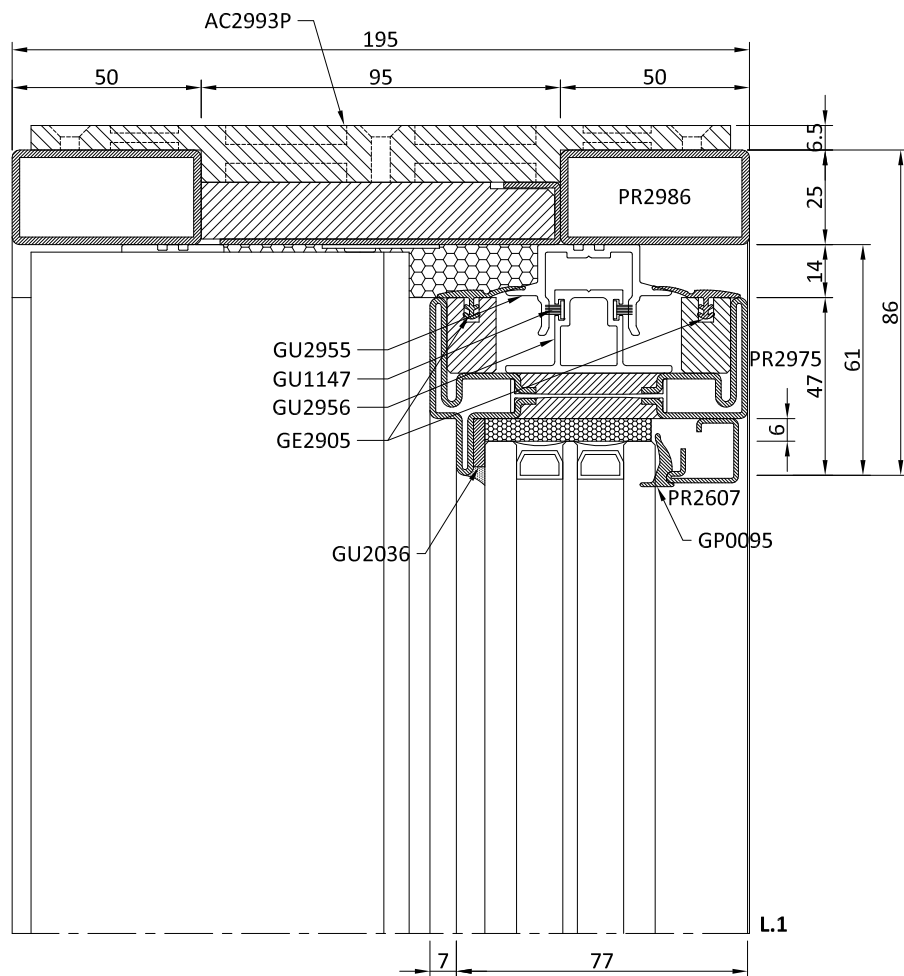
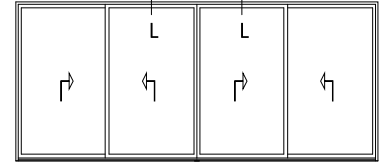
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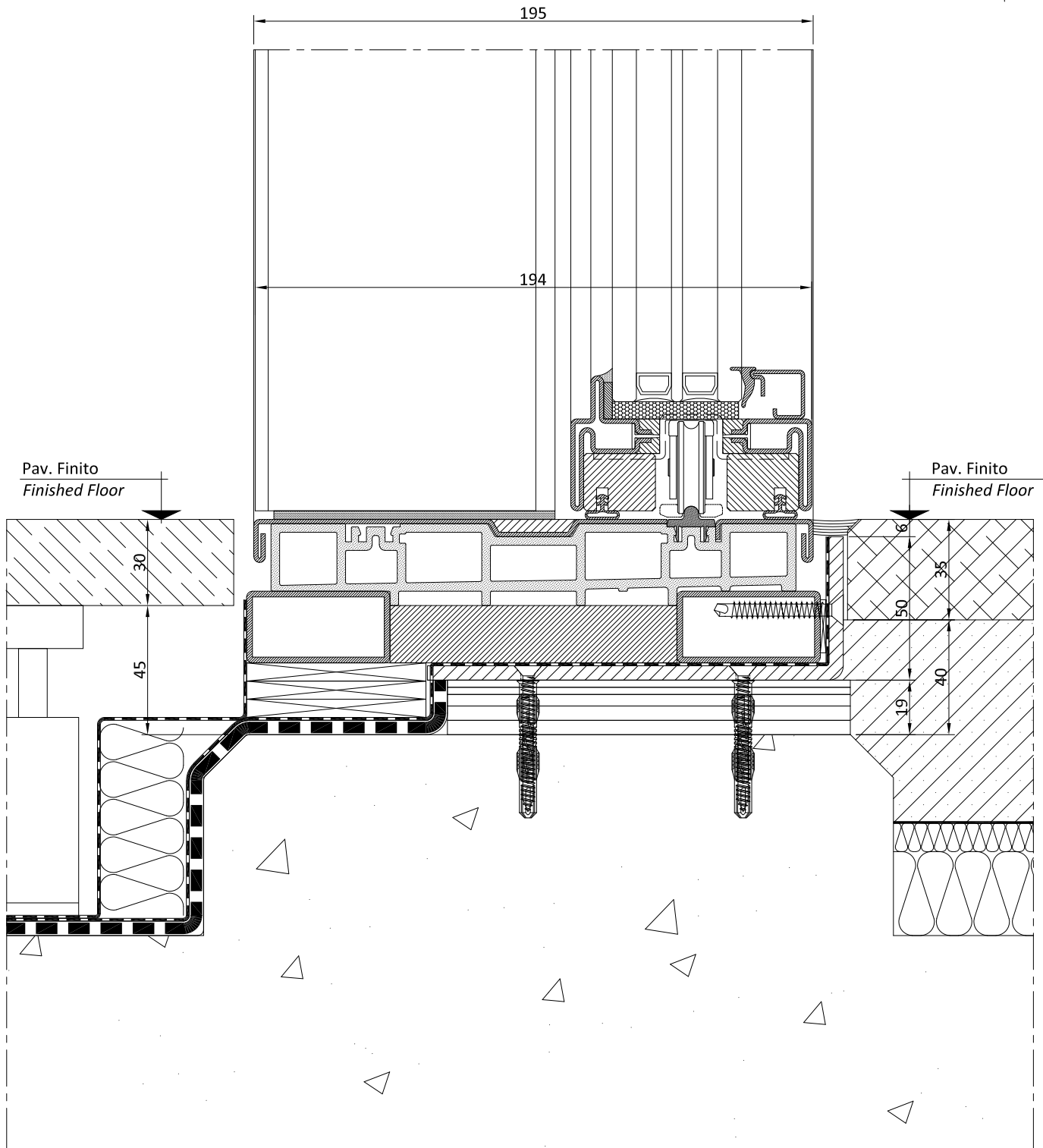
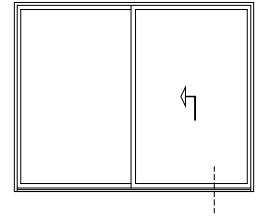


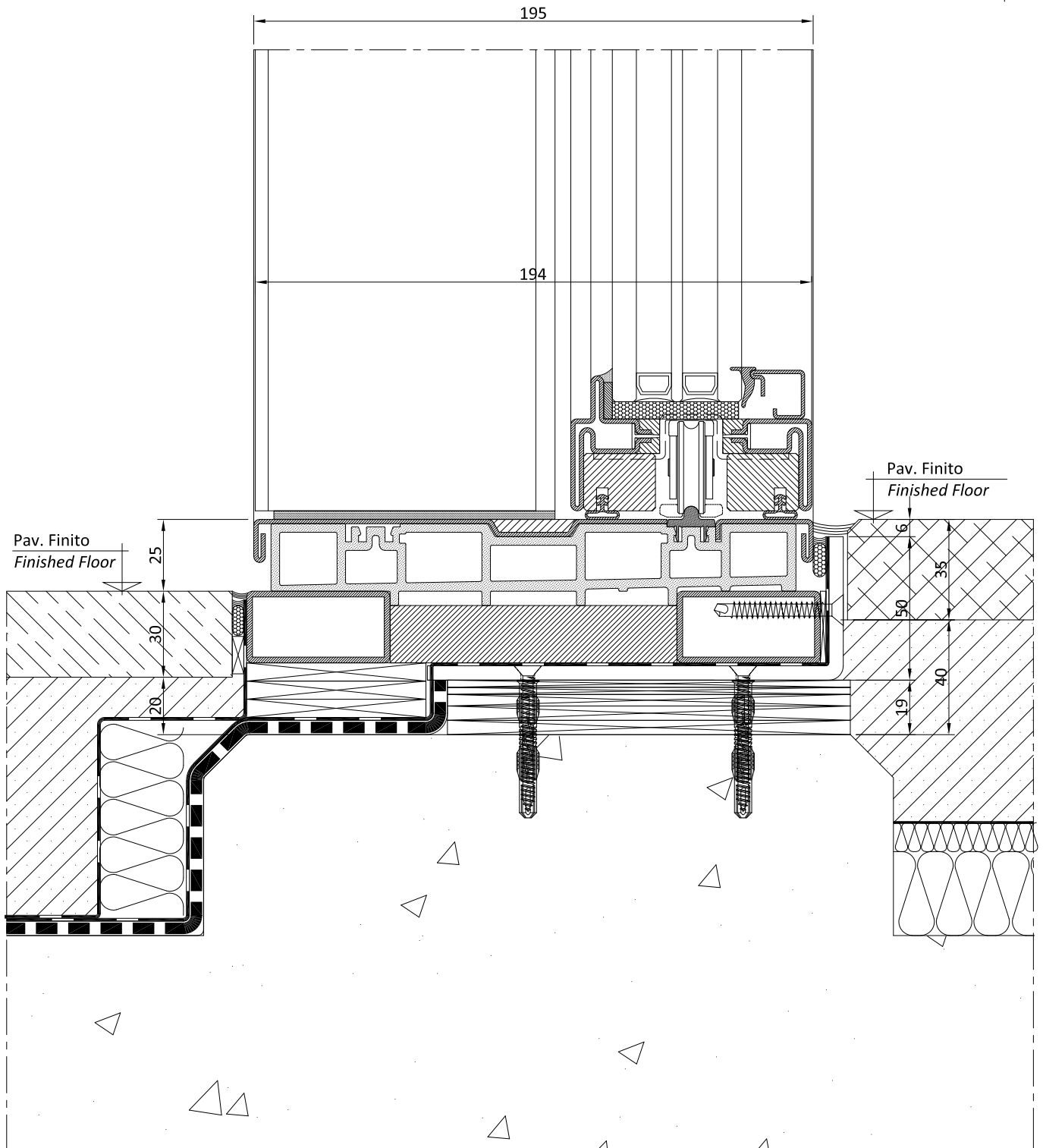
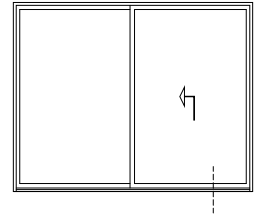
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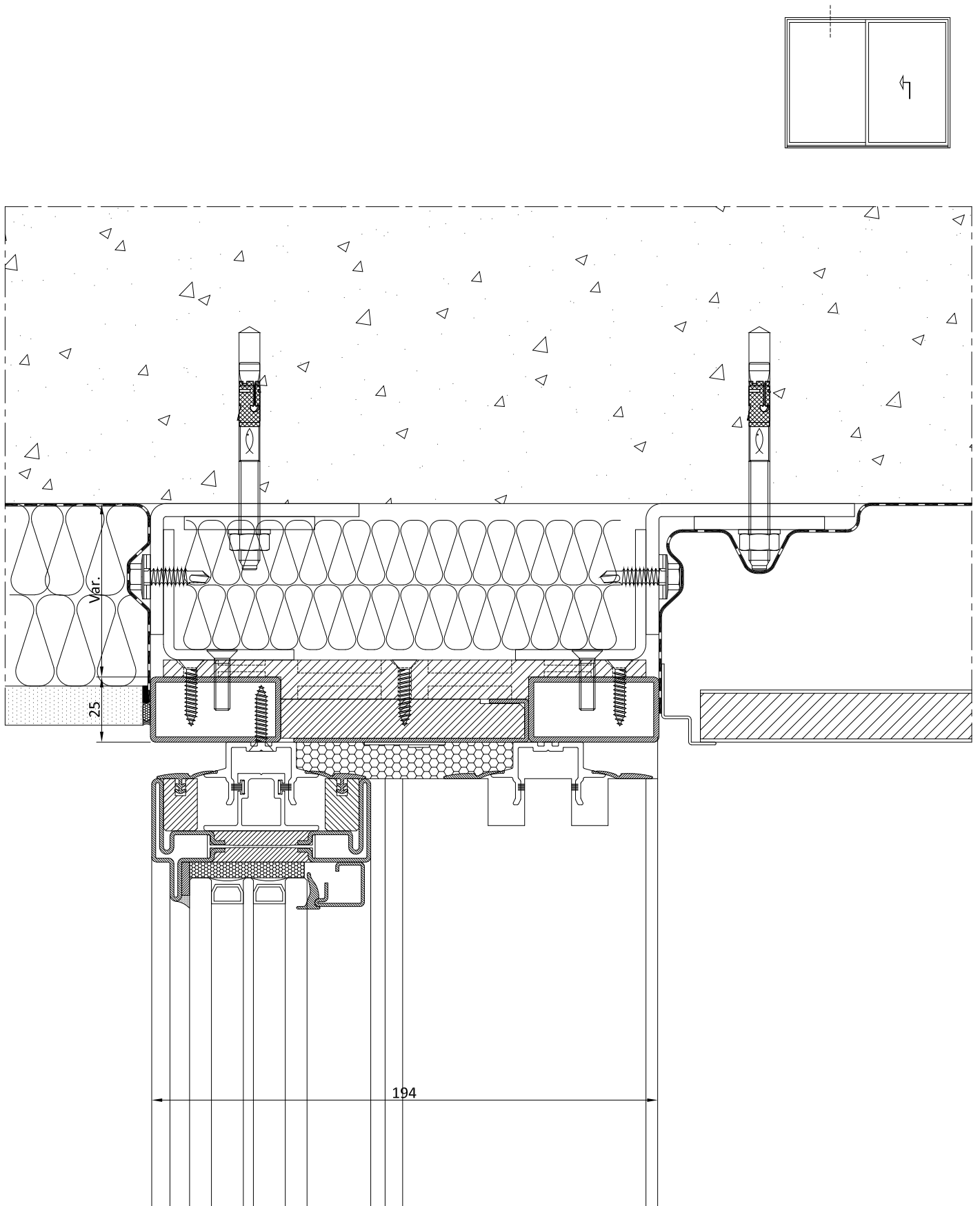


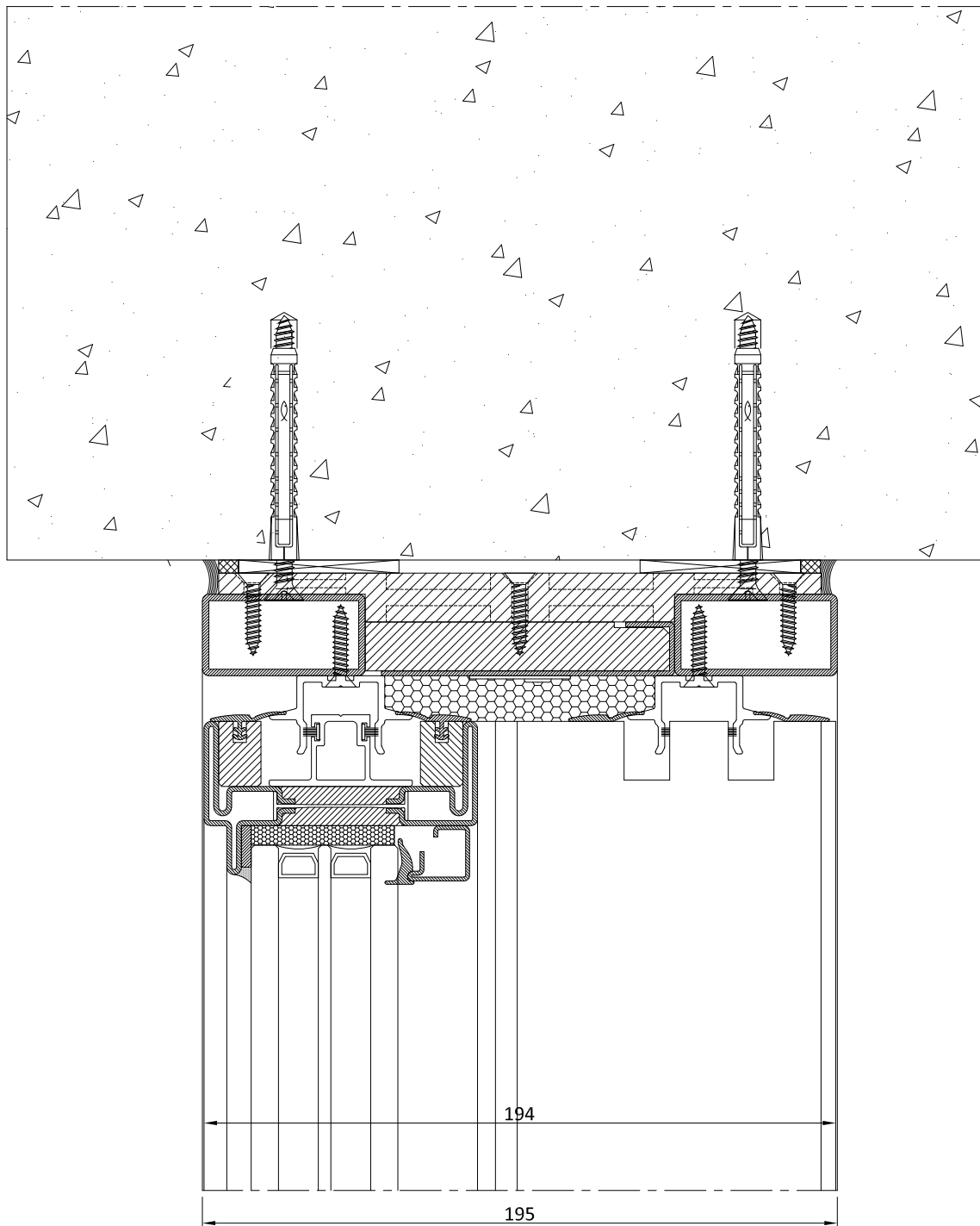
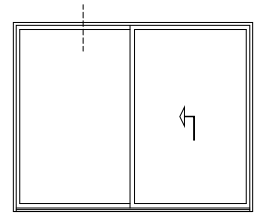
Schema | Type F

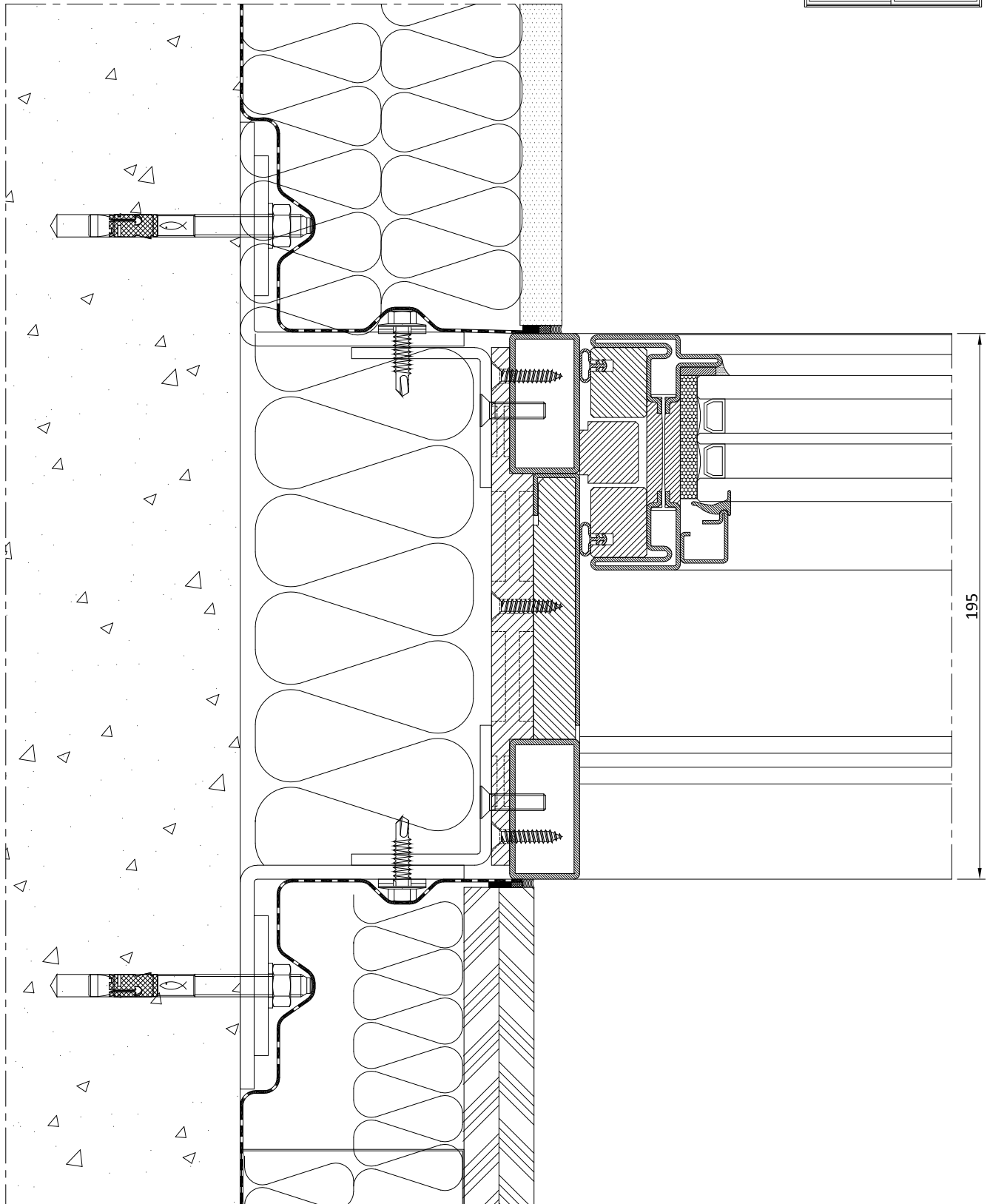
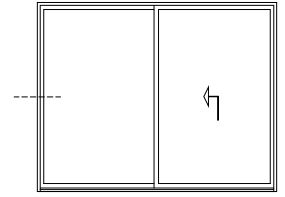


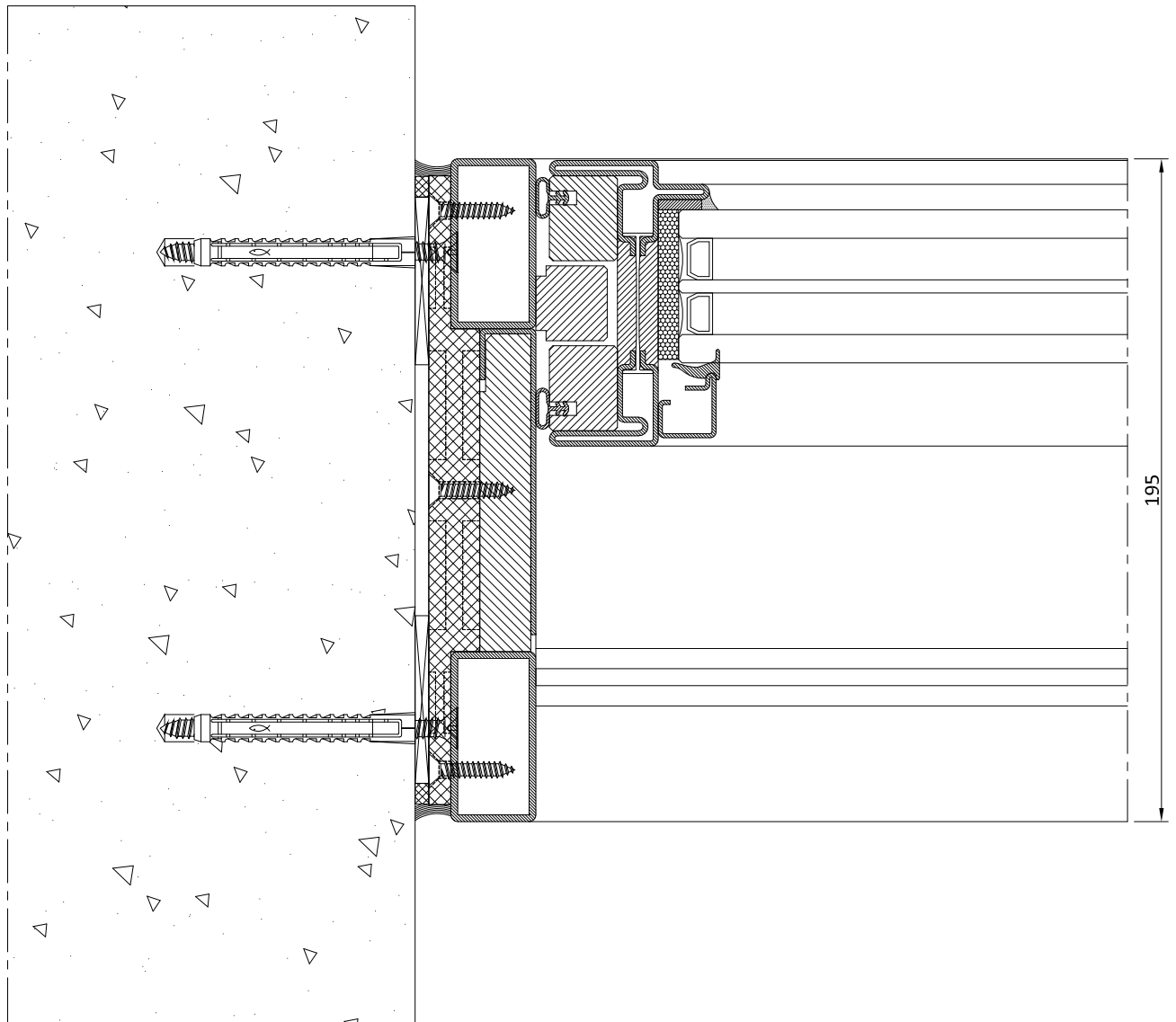
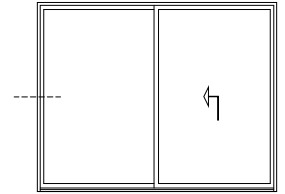










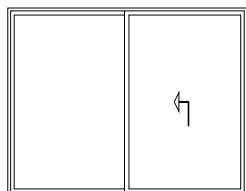


Distinta di taglio e lista componenti | Cutting list and components list

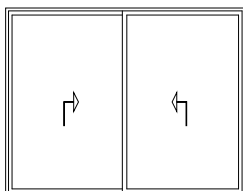
Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo. E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window. The window manufacturers' specialized technicians will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.

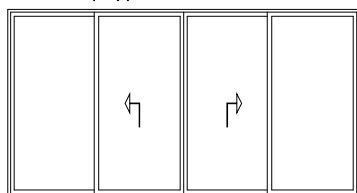
Schema | Type A



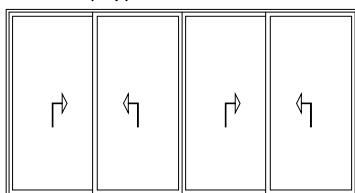
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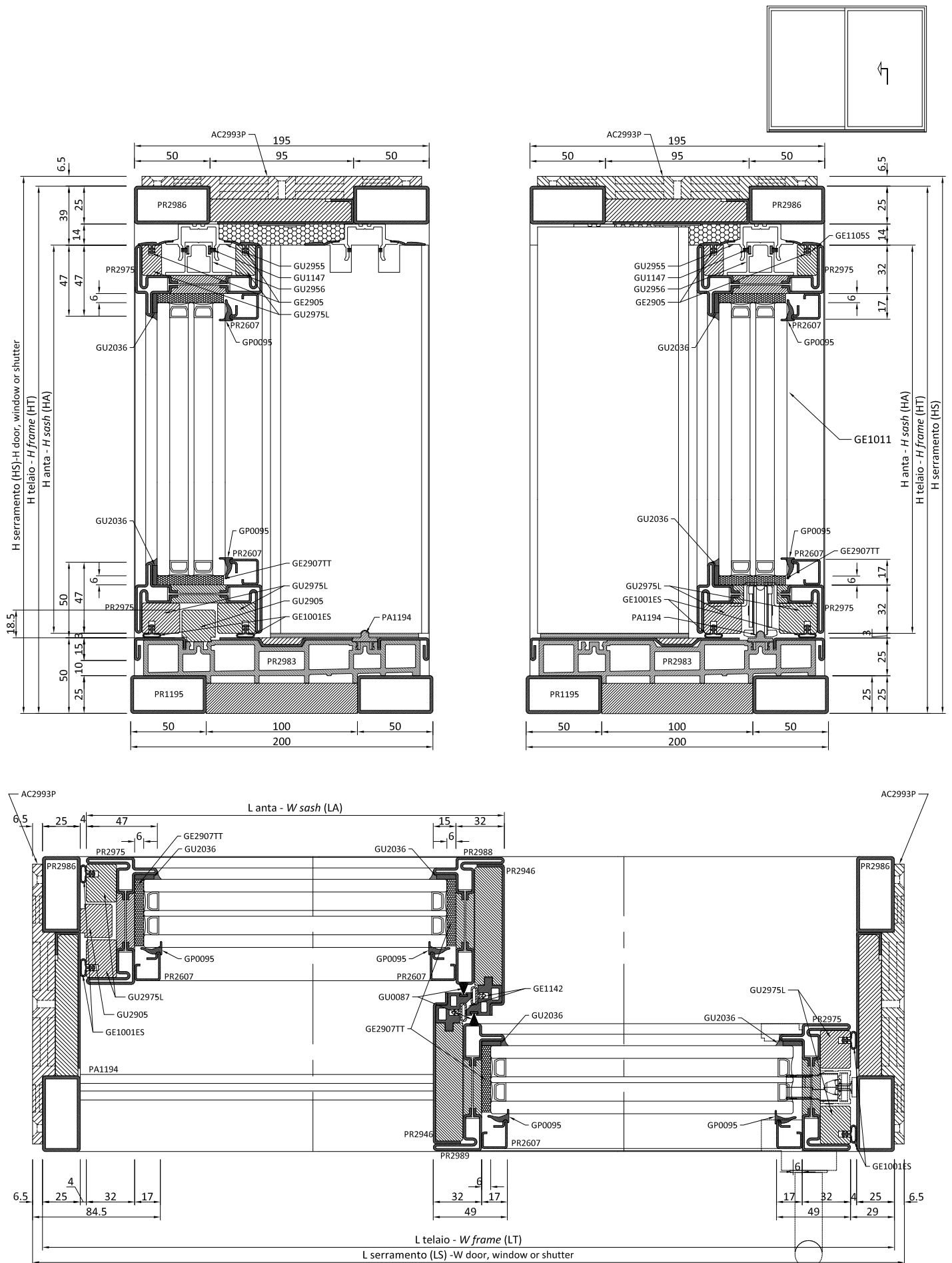


Schema | Type E



Schema | Type F





PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio/Cutting	
Telaio		Frame				
PR.2986	Profilo 50x25	Profile 50x25	2	LT	45	45
	Profilo 50x25	Profile 50x25	2	HT	45	90
	Profilo 50x25	Profile 50x25	2	HT	90	45
	Estruso centrale di unione	Central extrusion junction	2	LT/2	90	90
	Estruso centrale di unione	Central extrusion junction	2	HT-25	90	90
	Profilo centrale a "C"	"C" profile	2	LT/2-2,5	90	90
	Profilo centrale a "C"	"C" profile	2	HT-25	90	90
PR.1195	Tubo 50x25 mm inox	50x25 mm stainless steel tube	2	LT-50	90	90
	Estruso centrale di unione	Central extrusion junction	1	LT-50	90	90
PR.2983	Telaio base - copertina interna (Part. A)	Lower frame - internal cover (Detail A)	1	LT-50	90	90
	Telaio base - copertina esterna (Part. B)	Lower frame - external cover (Detail B)	1	LT/2-17	90	90
	Telaio base - copertina centrale (Part. C)	Lower frame - central cover (Detail C)	1	LT/2-25	90	90
	Telaio base - copertina esterna (Part. A)	Lower frame - external cover (Detail A)	1	LT/2-25	90	90
	Telaio base - profilo poliammide di supporto guide	Lower frame - polyamide profile of rails	1	LT-50	90	90
Guide		Rail				
GU2955	Profilo guida superiore anta mobile	Upper rail of sliding sash	1	LT-50	90	90
	Profilo guida superiore anta fissa	Upper rail of fixed sash	1	LT/2-2	90	90
GU2956	Pattino di scorrimento anta mobile e fissa	Runner for sliding and fixed sash	2	LA-5	90	90
PA1194	Profilo guida inferiore	Lower profile	1	LT-50	90	90
Anta		Sash				
PR.2975	Profilo zoccolo	Bottom rail profile	4	LT/2-5,5	45	45
	Profilo zoccolo	Bottom rail profile	2	HT-92	45	45
PR.2988	Profilo a "T"	"T" profile	1	HT-92	45	45
PR.2989	Profilo a "Z"	"Z" profile	1	HT-92	45	45
PR.2946	Profilo labirinto centrale - anta mobile (Part. 1)	Central labyrinth profile - sliding sash (Detail 1)	1	HT-92	90	90
	Profilo labirinto centrale - anta mobile (Part. 2)	Central labyrinth profile - sliding sash (Detail 2)	1	HT-132	90	90
	Profilo labirinto centrale - anta fissa (Part. 1)	Central labyrinth profile - fixed sash (Detail 1)	1	HT-80	90	90
	Profilo labirinto centrale - anta fissa (Part. 2)	Central labyrinth profile - fixed sash (Detail 2)	1	HT-120	90	90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	2	LT/2-25,5	45	90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	2	LT/2-25,5	90	45
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	2	HT-92	45	45
GU2975S	Profilo plastico porta guarnizione superiore	Plastic door profile upper gasket	4	LT/2-25,5	45	90
Fermavetri		Glazing beads				
PR.2607	Profilo fermavetro	Glazing bead profile	4	LT/2-69,5	90	90
	Profilo fermavetro	Glazing bead profile	4	HT-156	90	90
Vetri		Glass unit				
	Vetrocamera	Double glazing	2	(LT/2-81,5)x(HT-168)		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°	Note/Notes		
AC290ANT	Kit squadrette di giunzione Ante	Corner joint kit Sashes	2			
AG2992.AB	Rostro aggiuntivo	Additional hook bolt	opz.			
AG2986 7A	Kit alzante scorrevole	Lift and slide kit	1			
AG2989.AB	Prolunga superiore cremonese	Upper Cremonese extension	1	x HA > 2635 mm		
AG2989C	Profilo di copertura Aggiuntivo	Additional covering profile	1	x HA > 2635 mm		
ACV	Maniglione	Large handle	1			
AC2993P	Accessorio assiemaggio telaio	Frame assemblage accessory	var.			
AC1001G	Angolo vulcanizzato per GE1001S	Vulcanised corner gasket for GE1106S	4			
AC290TES	Squadretta di unione per telaio PR.2986	Corner joint for frame PR.2986	4			
CV5403I	Rondella in acciaio inox/Epdm	Stainless steel/vulcanised Epdm washer	var.			
AC2608	Clips Fissaggio Fermavetri	Clips for glazing bead	var.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GU2036	Piattina adesiva morbida esterno vetro	Soft adhesive shim for external window	1	2xLT+4xHT		
GU2907TT	Guarnizione sotto vetro	Under glass gasket	1	2xLT+4xHT		
GPO095	Guarnizione interna vetro	Internal glass gasket	1	2xLT+4xHT		
GE2905	Guarnizione superiore ante	Gasket for upper sash	2	LT		
GE1001ES	Guarnizione perimetrale ante	Gasket for side sash	2	2xLT/2+2xHT		
GE1142	Guarnizione labirinto centrale	Gasket for central labyrinth	2	HT		
GU0087	Spazzolino verticale labirinto	Vertical labyrinth brush + adhesive	1	HT		
GU2905	Estruso di compensazione	Compensation extrusion	1	LT/2-50		
	Estruso di compensazione	Compensation extrusion	1	HT-105		
GU1147	Spazzolino tenuta superiore anta mobile	Upper sealing brush for sliding sash	4	LT/2		

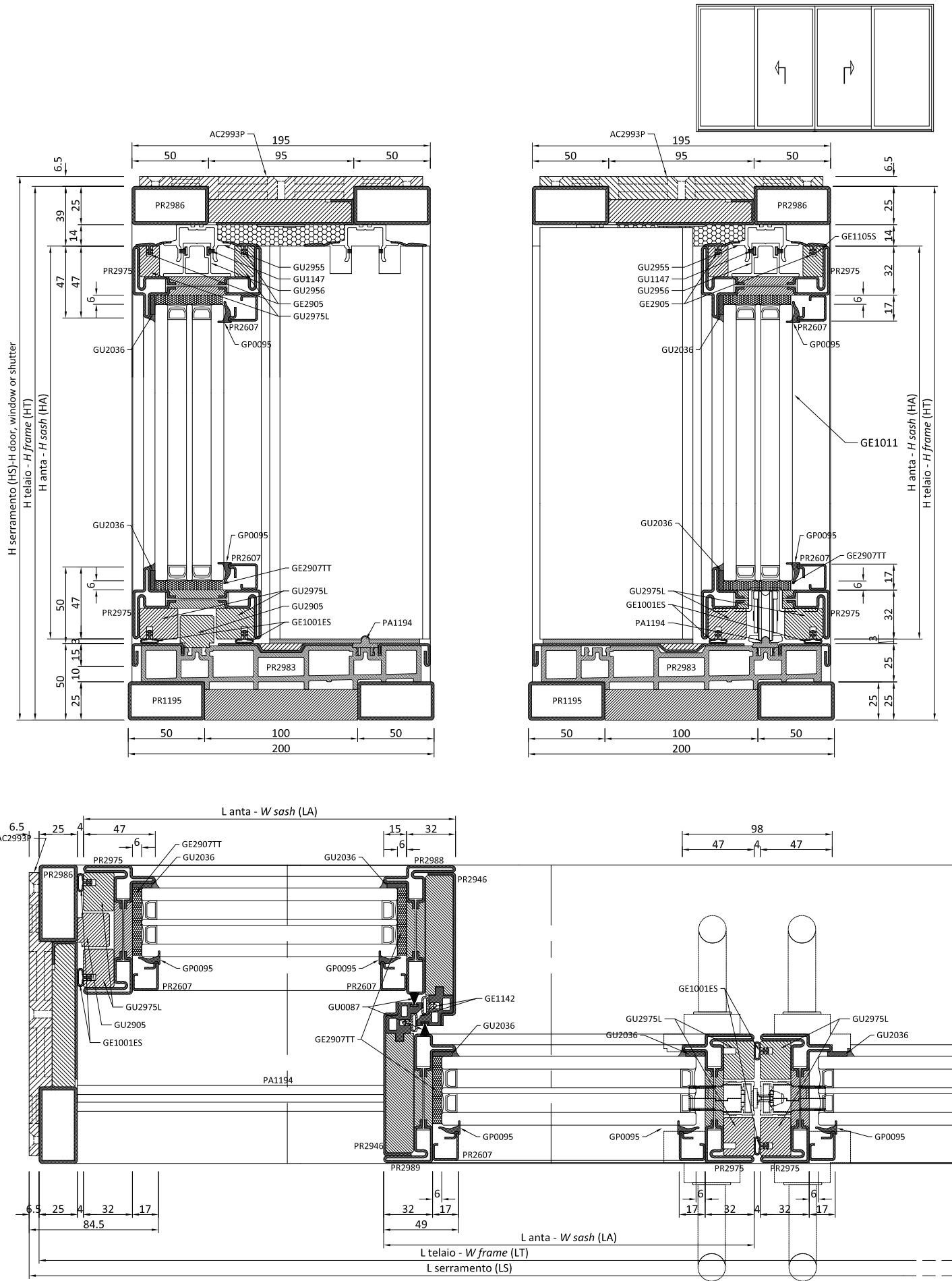
* le dimensioni delle guarnizioni sono indicative e devono essere aumentate del 10% per adattamenti e ritiri del materiale nel tempo

* the gasket dimensions are indicative and have to be increased by 10% owing to adaptation and contractions of the material over time

PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio/Cutting	
Telaio		Frame				
PR.2986	Profilo 50x25	Profile 50x25	2	LT	45	45
	Profilo 50x25	Profile 50x25	2	HT	45	90
	Profilo 50x25	Profile 50x25	2	HT	90	45
	Estruso centrale di unione	Central extrusion junction	2	LT/2	90	90
	Estruso centrale di unione	Central extrusion junction	2	HT-25	90	90
	Profilo centrale a "C"	"C" profile	2	LT/2-2,5	90	90
	Profilo centrale a "C"	"C" profile	2	HT-25	90	90
P.1195	Tubo 50x25 mm inox	50x25 mm stainless steel tube	2	LT-50	90	90
	Estruso centrale di unione	Central extrusion junction	1	LT-50	90	90
PR.2983	Telaio base - copertina interna/esterna (Part. A)	Lower frame - internal/external cover (Detail A)	2	LT-50	90	90
	Telaio base - copertina centrale (Part. B)	Lower frame - central cover (Detail B)	2	LT/2-17	90	90
	Telaio base - profilo poliammide di supporto guide	Lower frame - polyamide profile of rails	1	LT-50	90	90
Guide		Rail				
GU2955	Profilo guida superiore	Upper rail of sliding sash	2	LT-50	90	90
GU1146	Pattino di scorrimento anta mobile e fissa	Runner for sliding and fixed sash	2	LA-5	90	90
PA1194	Profilo guida inferiore	Lower profile	2	LT-50	90	90
Anta		Sash				
PR.2975	Profilo zoccolo	Bottom rail profile	2	LT/2-5,5	45	45
	Profilo zoccolo	Bottom rail profile	2	HT-92	45	45
PR.2988	Profilo a "T"	"T" profile	1	HT-92	45	45
PR.2989	Profilo a "Z"	"Z" profile	1	HT-92	45	45
PR.2946	Profilo labirinto centrale (Part. 1)	Central labyrinth profile (Detail 1)	2	HT-92	90	90
	Profilo labirinto centrale (Part. 2)	Corner labyrinth profile (Detail 2)	2	HT-132	90	90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	2	LT/2-25,5	45	90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	2	LT/2-25,5	90	45
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	4	HT-92	45	45
GU2975S	Profilo plastico porta guarnizione superiore	Plastic door profile upper gasket	4	LT/2-25,5	45	90
Fermavetri		Glazing beads				
PR.2607	Profilo fermavetro	Glazing bead profile	4	LT/2-69,5	45	45
	Profilo fermavetro	Glazing bead profile	4	HT-156	45	45
Vetri		Glass unit				
	Vetrocamera	Double glazing	2	(LT/2-81,5)x(HT-168)		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°	Note/Notes		
AC290ANT	Kit squadrette di giunzione Ante	Corner joint kit Sashes	2			
AG2992.AB	Rostro aggiuntivo	Additional hook bolt	opz.			
AG2986 7B	Kit alzante scorrevole	Lift and slide kit	2			
AG2989.AB	Prolunga superiore cremonese	Upper Cremonese extension	2	x HA > 2635 mm		
AG2989C	Profilo di copertura Aggiuntivo	Additional covering profile	2	x HA > 2635 mm		
ACV ___	Maniglione	Large handle	2			
AC2993P	Accessorio assiemaggio telaio	Frame assemblage accessory	var.			
AC1001G	Angolo vulcanizzato per GE1001S	Vulcanised corner gasket for GE1106S	4			
AC290TES	Squadretta di unione per telaio PR.2986	Corner joint for frame PR.2986	4			
CV5403I	Rondella in acciaio inox/Epdm	Stainless steel/vulcanised Epdm washer	var.			
AC2608	Clips Fissaggio Fermavetri	Clips for glazing bead	var.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GU2036	Piattina adesiva morbida esterno vetro	Soft adhesive shim for external window	1	2xLT+4xHT		
GU2907TT	Guarnizione sotto vetro	Under glass gasket	1	2xLT+4xHT		
GP0095	Guarnizione interna vetro	Internal glass gasket	1	2xLT+4xHT		
GE2905	Guarnizione superiore ante	Gasket for upper sash	2	LT		
GE1001ES	Guarnizione perimetrale ante	Gasket for side sash	2	2xLT/2+2xHT		
GE1142	Guarnizione labirinto centrale	Gasket for central labyrinth	2	HT		
GU0087	Spazzolino verticale labirinto	Vertical labyrinth brush + adhesive	1	HT		
GU2905	Estruso di compensazione	Compensation extrusion	1	LT/-50		
	Estruso di compensazione	Compensation extrusion	1	HT-105		
GU1147	Spazzolino tenuta superiore anta mobile	Upper sealing brush for sliding sash	4	LT/2		

* le dimensioni delle guarnizioni sono indicative e devono essere aumentate del 10% per adattamenti e ritiri del materiale nel tempo

* the gasket dimensions are indicative and have to be increased by 10% owing to adaptation and contraction of the material over time

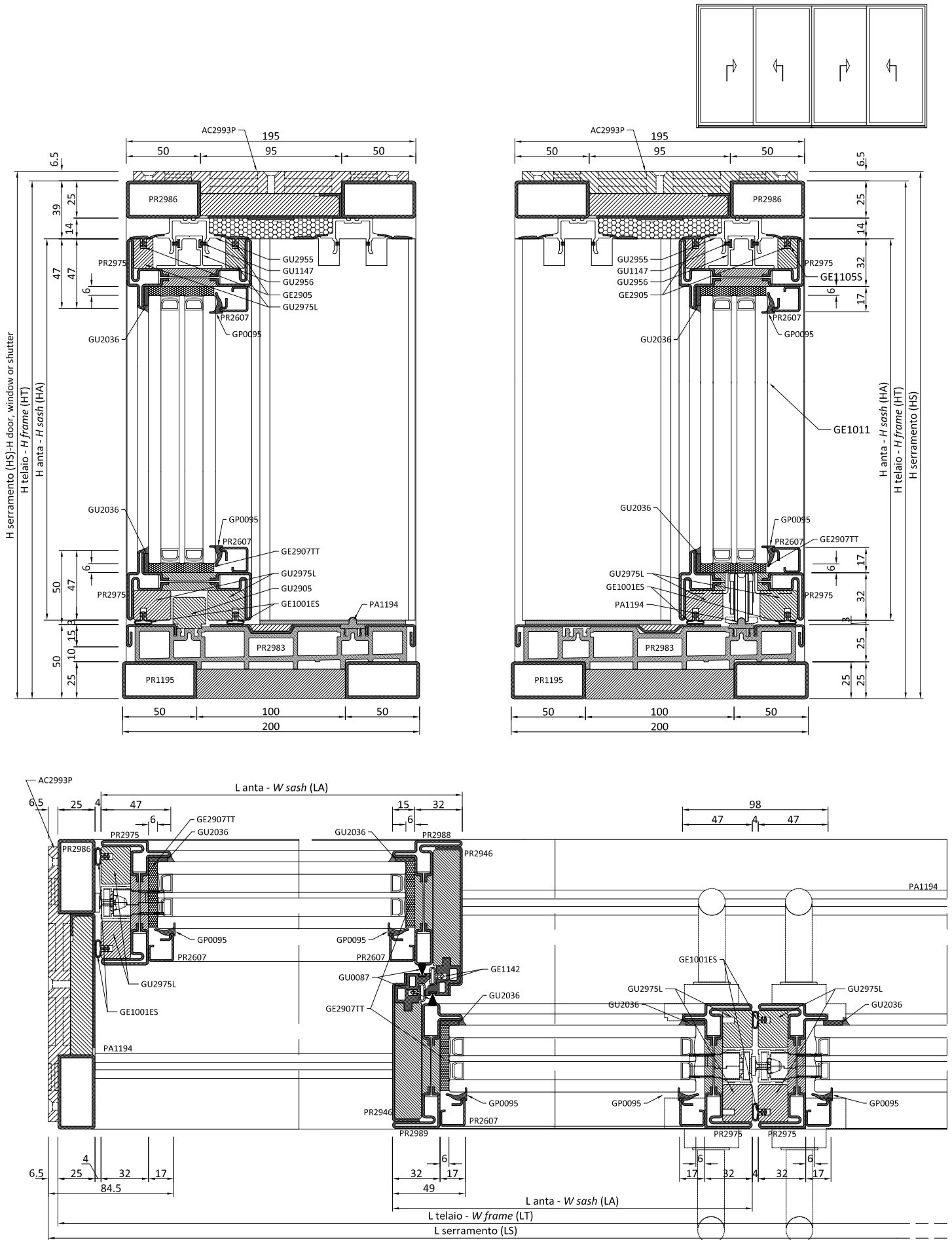


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio/Cutting	
Telaio		Frame				
PR.2986	Profilo 50x25	Profile 50x25	2	LT	45	45
	Profilo 50x25	Profile 50x25	2	HT	45	90
	Profilo 50x25	Profile 50x25	2	HT	90	45
	Estruso centrale di unione	Central extrusion junction	2	LT/4+13	90	90
	Estruso centrale di unione	Central extrusion junction	1	LT/2-27	90	90
	Estruso centrale di unione	Central extrusion junction	2	HT-25	90	90
	Profilo centrale a "C"	"C" profile	2	LT/4-14	90	90
	Profilo centrale a "C"	"C" profile	1	LT/2-32	90	90
PR.1195	Profilo centrale a "C"	"C" profile	2	HT-25	90	90
	Tubo 50x25 mm inox	50x25 mm stainless steel tube	2	LT-50	90	90
PR.2983	Estruso centrale di unione	Central extrusion junction	1	LT-50	90	90
	Telaio base - copertina interna (Part. A)	Lower frame - internal cover (Detail A)	1	LT-50	90	90
	Telaio base - copertina esterna (Part. B)	Lower frame - external cover (Detail B)	2	LT/4-28,5	90	90
	Telaio base - copertina centrale (Part. C)	Lower frame - central cover (Detail C)	1	LT/2-27	90	90
	Telaio base - copertina esterna (Part. A)	Lower frame - external cover (Detail A)	2	LT/4-11,5	90	90
	Telaio base - profilo poliammide di supporto guide	Lower frame - polyamide profile of rails	1	LT-50	90	90
Guide		Rail				
GU2955	Profilo guida superiore anta mobile	Upper rail of sliding sash	1	LT-50	90	90
	Profilo guida superiore anta fissa	Upper rail of fixed sash	2	LT/4+10	90	90
GU2956	Pattino di scorrimento anta mobile e fissa	Runner for sliding and fixed sash	4	LT/4+3	90	90
PA1194	Profilo guida inferiore	Lower profile	1	LT-50	90	90
Anta		Sash				
PR.2975	Profilo zoccolo	Bottom rail profile	8	LT/4+8	45	45
	Profilo zoccolo	Bottom rail profile	4	HT-92	45	45
PR.2988	Profilo a "T"	"T" profile	2	HT-92	45	45
PR.2989	Profilo a "Z"	"Z" profile	2	HT-92	45	45
PR.2946	Profilo labirinto centrale - anta mobile (Part. 1)	Central labyrinth profile - sliding sash (Detail 1)	2	HT-92	90	90
	Profilo labirinto centrale - anta mobile (Part. 2)	Central labyrinth profile - sliding sash (Detail 2)	2	HT-132	90	90
	Profilo labirinto centrale - anta fissa (Part. 1)	Central labyrinth profile - fixed sash (Detail 1)	2	HT-80	90	90
	Profilo labirinto centrale - anta fissa (Part. 2)	Central labyrinth profile - fixed sash (Detail 2)	2	HT-120	90	90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	4	LT/4-12	45	90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	4	LT/4-12	90	45
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	8	HT-92	45	45
GU2975S	Profilo plastico porta guarnizione superiore	Plastic door profile upper gasket	8	LT/4-12	45	90
Fermavetri		Glazing beads				
PR.2607	Profilo fermavetro	Glazing bead profile	8	LT/4-56	90	90
	Profilo fermavetro	Glazing bead profile	8	HT-156	90	90
Vetri		Glass unit				
	Vetrocamera	Double glazing	4	(LT/4-68)x(HT-168)		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°	Note/Notes		
AC290ANT	Kit squadrette di giunzione Ante	Corner joint kit Sashes	4			
AG2992.AB	Rostro aggiuntivo	Additional hook bolt	opz.			
AG2986E	Kit alzante scorrevole	Lift and slide kit	2			
AG2989.EF	Prolunga superiore cremonese	Upper Cremonese extension	1	x HA > 2635 mm		
AG2989C	Profilo di copertura Aggiuntivo	Additional covering profile	2	x HA > 2635 mm		
ACV___	Maniglione	Large handle	2			
AC2993P	Accessorio assiemaggio telaio	Frame assemblage accessory	var.			
AC1001G	Angolo vulcanizzato per GE1001S	Vulcanised corner gasket for GE11065	8			
AC290TES	Squadretta di unione per telaio PR.2986	Corner joint for frame PR.2986	4			
CV5403I	Rondella in acciaio inox/Epdm	Stainless steel/vulcanised Epdm washer	var.			
AC2608	Clips Fissaggio Fermavetri	Clips for glazing bead	var.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GU2036	Piattina adesiva morbida esterno vetro	Soft adhesive shim for external window	1	2xLT+8xHT		
GU2907TT	Guarnizione sotto vetro	Under glass gasket	1	2xLT+8xHT		
GP0095	Guarnizione interna vetro	Internal glass gasket	1	2xLT+8xHT		
GE2905	Guarnizione superiore ante	Gasket for upper sash	8	LT/4		
GE1001ES	Guarnizione perimetrale ante	Gasket for side sash	2	2xLT/2+6xHT		
GE1142	Guarnizione labirinto centrale	Gasket for central labyrinth	4	HT		
GU0087	Spazzolino verticale labirinto	Vertical labyrinth brush + adhesive	4	HA		
GU2905	Estruso di compensazione	Compensation extrusion	2	LT/4-35		
	Estruso di compensazione	Compensation extrusion	2	HT-105		
GU1147	Spazzolino tenuta superiore anta mobile	Upper sealing brush for sliding sash	8	LT/4+8		

* Le dimensioni delle guarnizioni sono indicative e devono essere aumentate del 10% per adattamenti e ritiri del materiale nel tempo

* the gasket dimensions are indicative and have to be increased by 10% owing to adaptation and contractions of the material over time

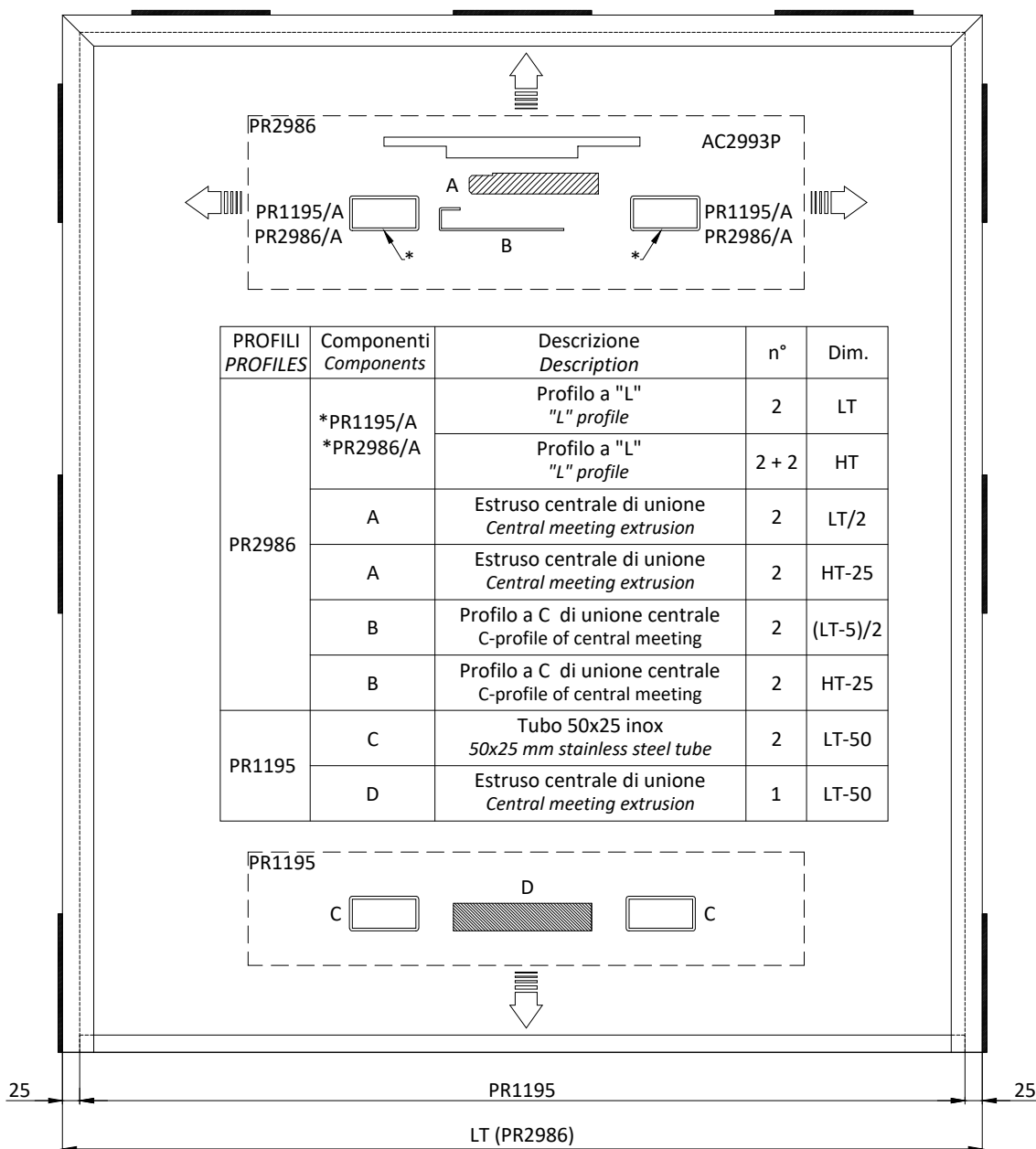
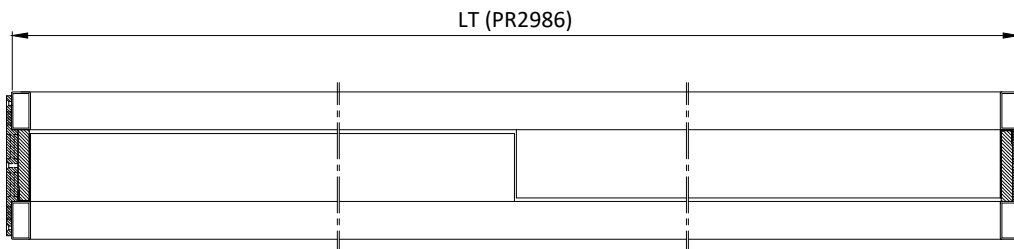
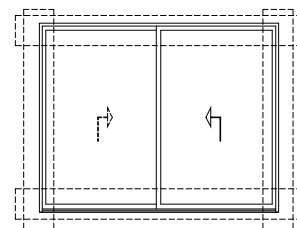




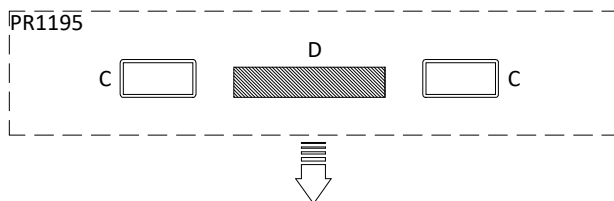
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio/Cutting
Telaio		Frame			
PR.2986	Profilo 50x25	Profile 50x25	2	LT	45 45
	Profilo 50x25	Profile 50x25	2	HT	45 90
	Profilo 50x25	Profile 50x25	2	HT	90 45
	Estruso centrale di unione	Central extrusion junction	2	LT/4+13	90 90
	Estruso centrale di unione	Central extrusion junction	1	LT/2-27	90 90
	Estruso centrale di unione	Central extrusion junction	2	HT-25	90 90
	Profilo centrale a "C"	"C" profile	2	LT/4-14	90 90
	Profilo centrale a "C"	"C" profile	1	LT/2-32	90 90
PR.1195	Tubo 50x25 mm inox	50x25 mm stainless steel tube	2	LT-50	90 90
	Estruso centrale di unione	Central extrusion junction	1	LT-50	90 90
PR.2983	Telaio base - copertina interna (Part. A)	Lower frame - internal cover (Detail A)	2	LT-50	90 90
	Telaio base - copertina esterna (Part. B)	Lower frame - external cover (Detail B)	2	LT/4-28,5	90 90
	Telaio base - copertina centrale (Part. C)	Lower frame - central cover (Detail C)	1	LT/2-61	90 90
	Telaio base - profilo poliammide di supporto guide	Lower frame - polyamide profile of rails	1	LT-50	90 90
Guide		Rail			
GU2955	Profilo guida superiore ante	Upper rail of sliding sash	2	LT-50	90 90
GU2956	Pattino di scorrimento ante	Runner for sliding and fixed sash	4	LT/4+3	90 90
PA1194	Profilo guida inferiore	Lower profile	2	LT-50	90 90
Anta		Sash			
PR.2975	Profilo zoccolo	Bottom rail profile	8	LT/4+8	45 45
	Profilo zoccolo	Bottom rail profile	4	HT-92	45 45
PR.2988	Profilo a "T"	"T" profile	2	HT-92	45 45
PR.2989	Profilo a "Z"	"Z" profile	2	HT-92	45 45
PR.2946	Profilo labirinto centrale - anta mobile (Part. 1)	Central labyrinth profile - sliding sash (Detail 1)	4	HT-92	90 90
	Profilo labirinto centrale - anta mobile (Part. 2)	Central labyrinth profile - sliding sash (Detail 2)	4	HT-132	90 90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	4	LT/4-12	45 90
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	4	LT/4-12	90 45
GU2975L	Profilo plastico porta guarnizione perimetrale	Plastic door profile perimeter gasket	8	HT-92	45 45
GU2975S	Profilo plastico porta guarnizione superiore	Plastic door profile upper gasket	8	LT/4-12	45 90
Fermavetri		Glazing beads			
PR.2607	Profilo fermavetro	Glazing bead profile	8	LT/4-56	90 90
	Profilo fermavetro	Glazing bead profile	8	HT-156	90 90
Vetri		Glass unit			
	Vetrocamera	Double glazing	4	(LT/4-68)x(HT-168)	
ACCESSORI		HARDWARE			
Cod.	Descrizione	Description	n°	Note/Notes	
AC290ANT	Kit squadrette di giunzione Ante	Corner joint kit Sashes	4		
AG2992.AB	Rostro aggiuntivo	Additional hook bolt	opz.		
AG2986F	Kit alzante scorrevole	Lift and slide kit	2		
AG2989.AB	Prolunga superiore cremonese	Upper Cremonese extension	1	x HA > 2635 mm	
AG2989.EF	Prolunga superiore cremonese	Upper Cremonese extension	1	x HA > 2635 mm	
AG2989C	Profilo di copertura Aggiuntivo	Additional covering profile	4	x HA > 2635 mm	
ACV	Maniglione	Large handle	4		
AC2993P	Accessorio assiemaggio telaio	Frame assemblage accessory	var.		
AC1001G	Angolo vulcanizzato per GE1001S	Vulcanised corner gasket for GE1001S	8		
AC290TES	Squadretta di unione per telaio PR.2986	Corner joint for frame PR.2986	4		
CV5403I	Rondella in acciaio inox/Epdm	Stainless steel/vulcanised Epdm washer	var.		
AC2608	Clips Fissaggio Fermavetri	Clips for glazing bead	var.		
GUARNIZIONI		GASKETS			
Cod.	Descrizione	Description	n°	Dim.	
GU2036	Piattina adesiva morbida esterno vetro	Soft adhesive shim for external window	1	2xLT+8xHT	
GU2907TT	Guarnizione sotto vetro	Under glass gasket	1	2xLT+8xHT	
GP0095	Guarnizione interna vetro	Internal glass gasket	1	2xLT+8xHT	
GE2905	Guarnizione superiore ante	Gasket for upper sash	8	LT/4	
GE1001ES	Guarnizione perimetrale ante	Gasket for side sash	2	2xLT/2+6xHT	
GE1142	Guarnizione labirinto centrale	Gasket for central labyrinth	4	HT	
GU0087	Spazzolino verticale labirinto	Vertical labyrinth brush + adhesive	4	HT	
GU1147	Spazzolino tenuta superiore anta mobile	Upper sealing brush for sliding sash	8	LT/4+8	

* le dimensioni delle guarnizioni sono indicative e devono essere aumentate del 10% per adattamenti e ritiri del materiale nel tempo

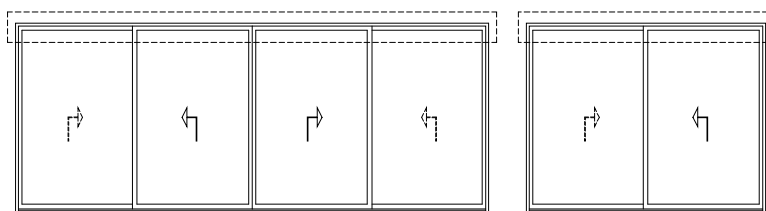
* the gasket dimensions are indicative and have to be increased by 10% owing to adaptation and contraction of the material over time



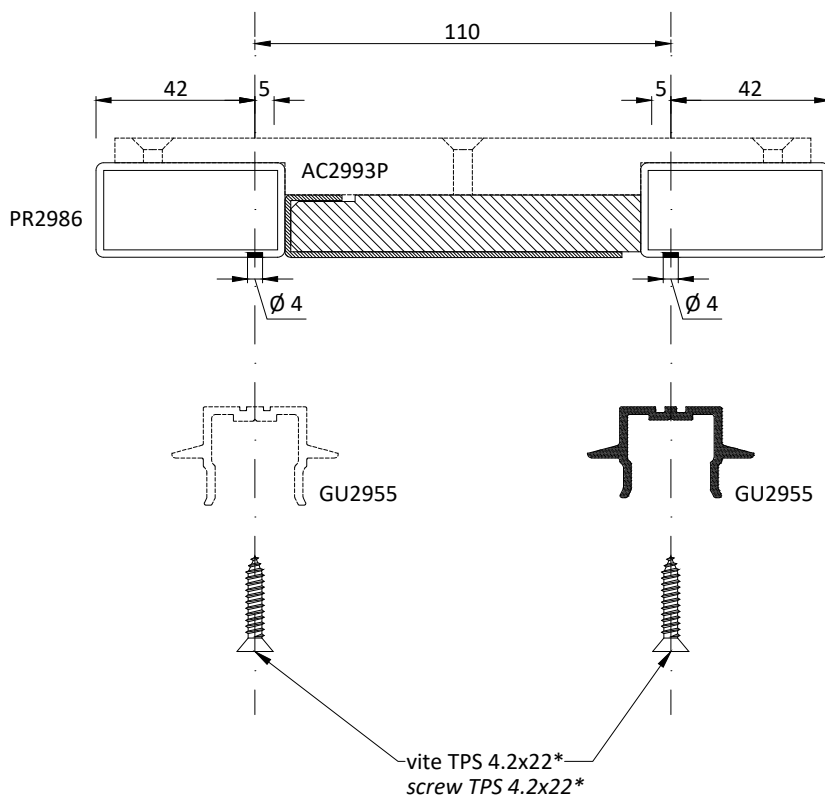
PROFILI PROFILES	Componenti Components	Descrizione Description	n°	Dim.
PR2986	*PR1195/A	Profilo a "L"	2	LT
	*PR2986/A	"L" profile		
		Profilo a "L"	2 + 2	HT
		"L" profile		
	A	Estruso centrale di unione Central meeting extrusion	2	LT/2
	A	Estruso centrale di unione Central meeting extrusion	2	HT-25
PR1195	B	Profilo a C di unione centrale C-profile of central meeting	2	(LT-5)/2
	B	Profilo a C di unione centrale C-profile of central meeting	2	HT-25
PR1195	C	Tubo 50x25 inox 50x25 mm stainless steel tube	2	LT-50
	D	Estruso centrale di unione Central meeting extrusion	1	LT-50



* ATTENZIONE forare il profilo prima dell'assieme per il fissaggio della guida GU2955
* ATTENTION perforate the profile before assembling to attach the GU2955 rail

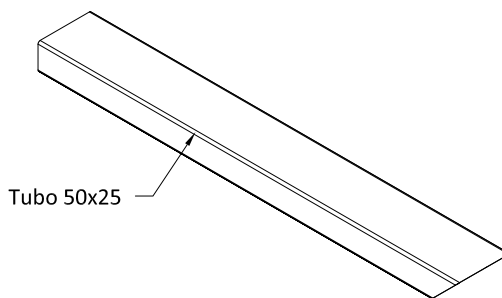
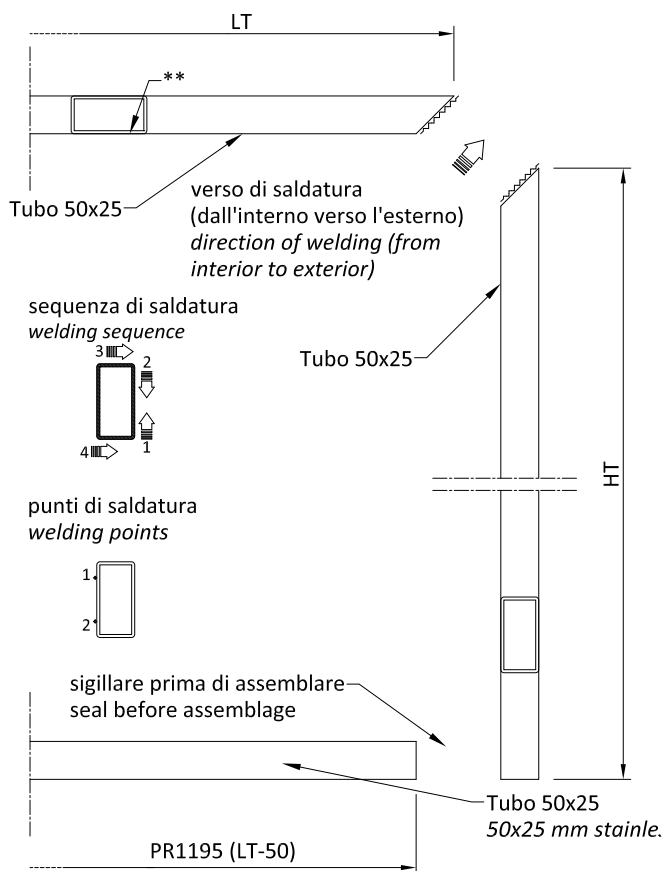
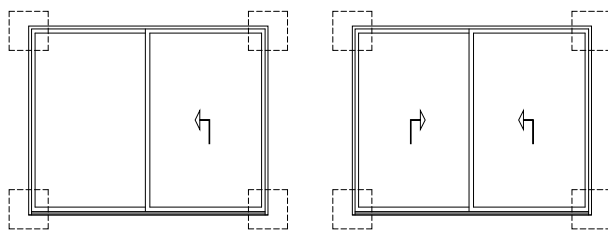
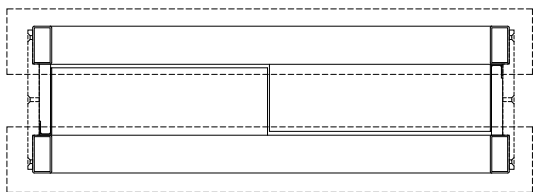


Prima di assemblare il telaio esterno forare $\varnothing 4$ mm il profilo superiore per fissaggio guida GU2955
Before assembling the frame make a $\varnothing 4$ mm hole in the upper profile to attach the GU2955 rail

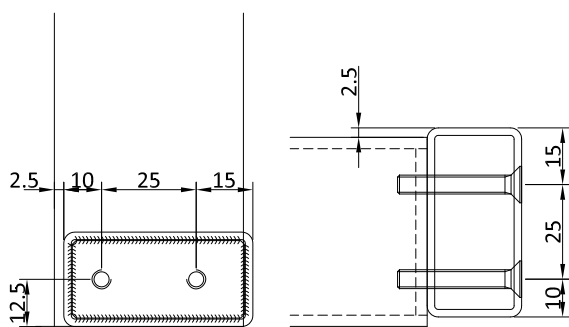
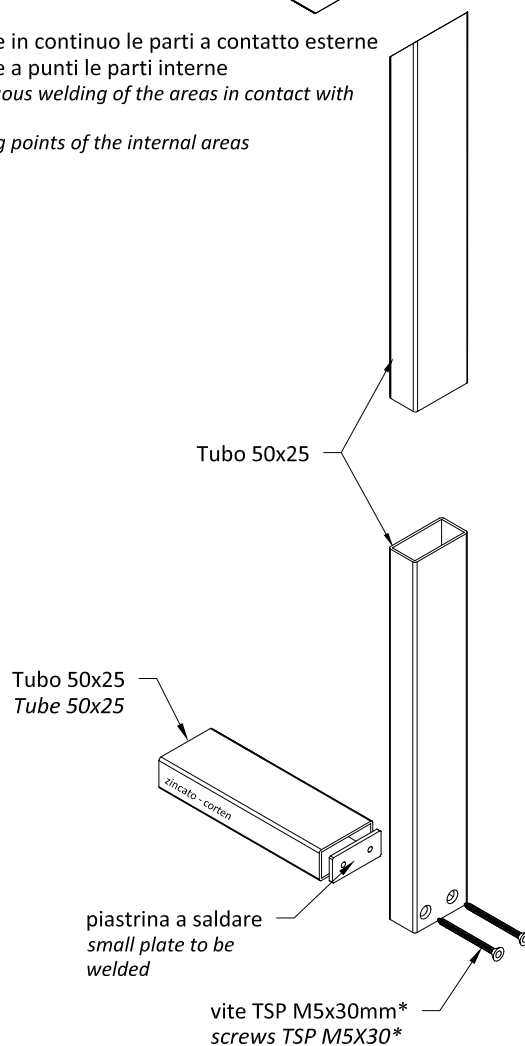


Il passo di foratura viene definito nelle singole schede di applicazione guida GU2955 delle specifiche tipologie realizzabili
The spacing of the drilled holes is described in the individual rail GU2955 application sheets for the specific typologies possible

* viti TPS 4.2x22 non comprese
 * screws TPS 4.2x22 not supplied



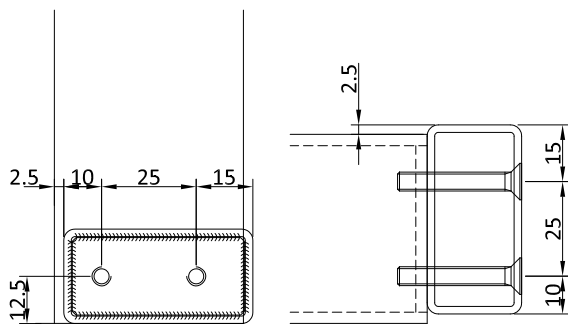
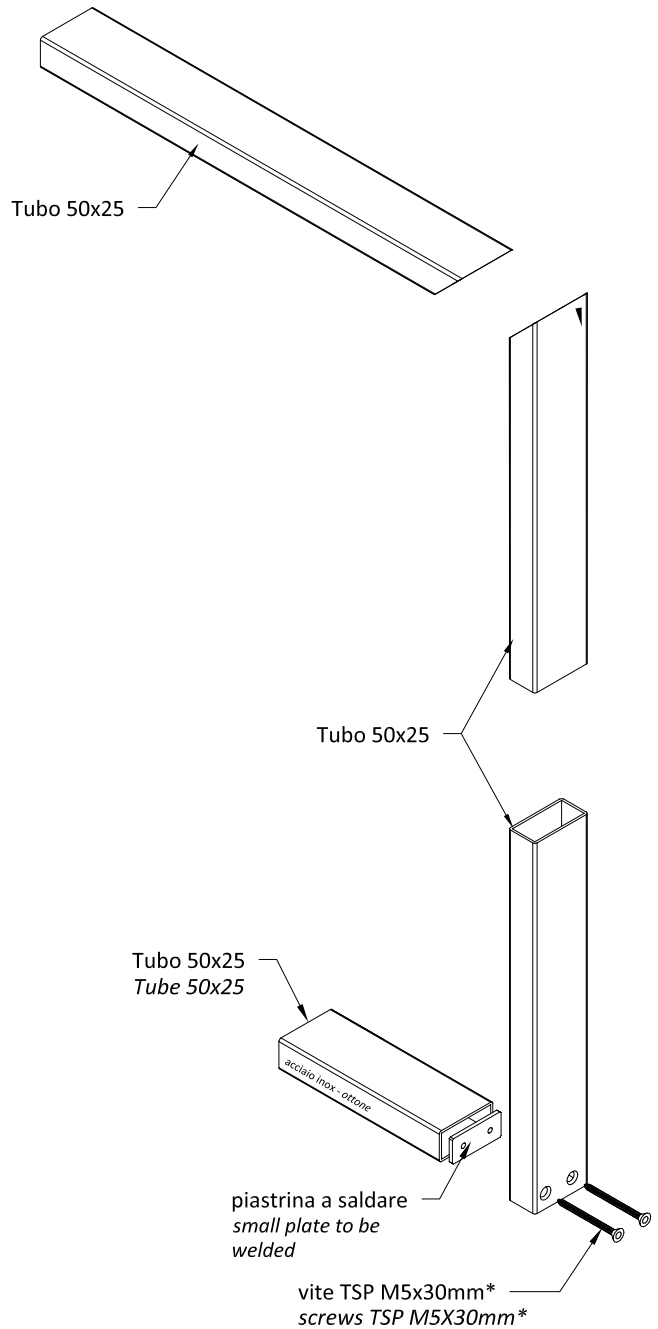
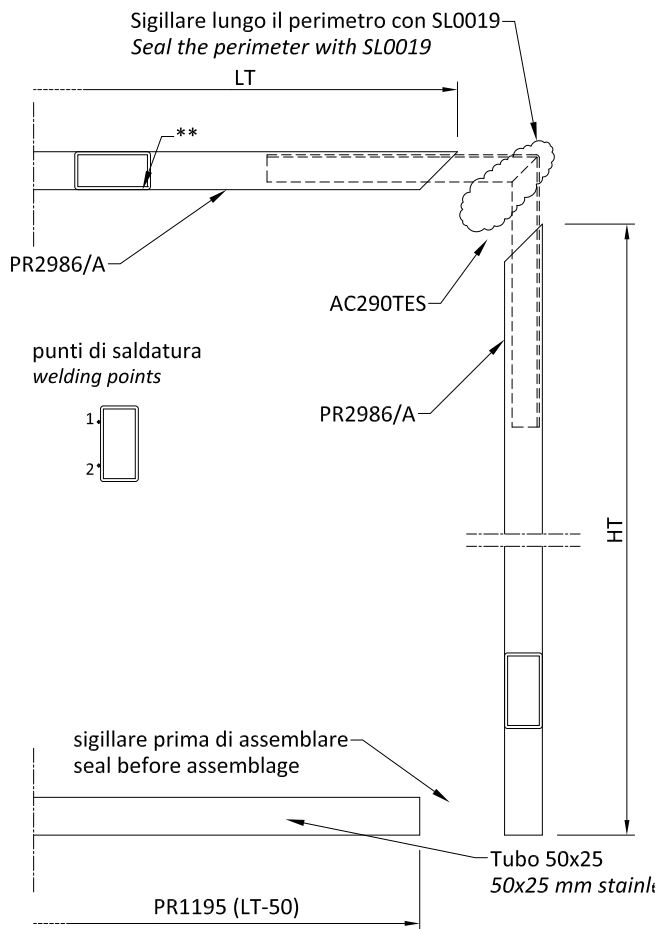
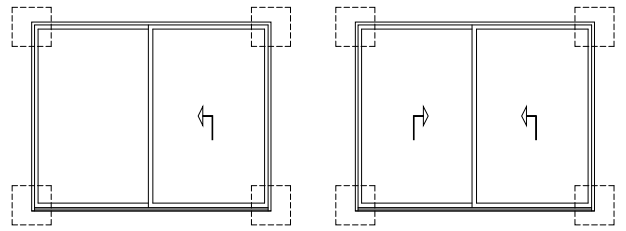
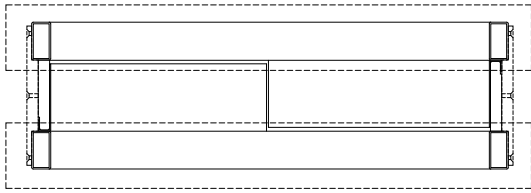
- saldare in continuo le parti a contatto esterne
- saldare a punti le parti interne
- continuous welding of the areas in contact with exterior
- welding points of the internal areas



* viti TPS M5x30 non comprese | screws TPS M5x30 not included

**ATTENZIONE forare il profilo prima dell'assemblaggio per il fissaggio della guida GU2955

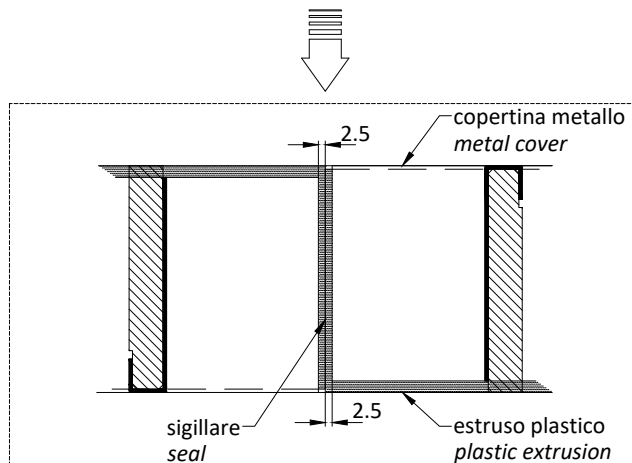
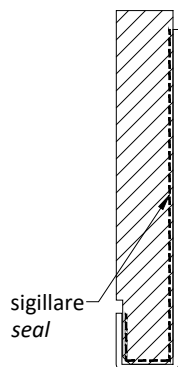
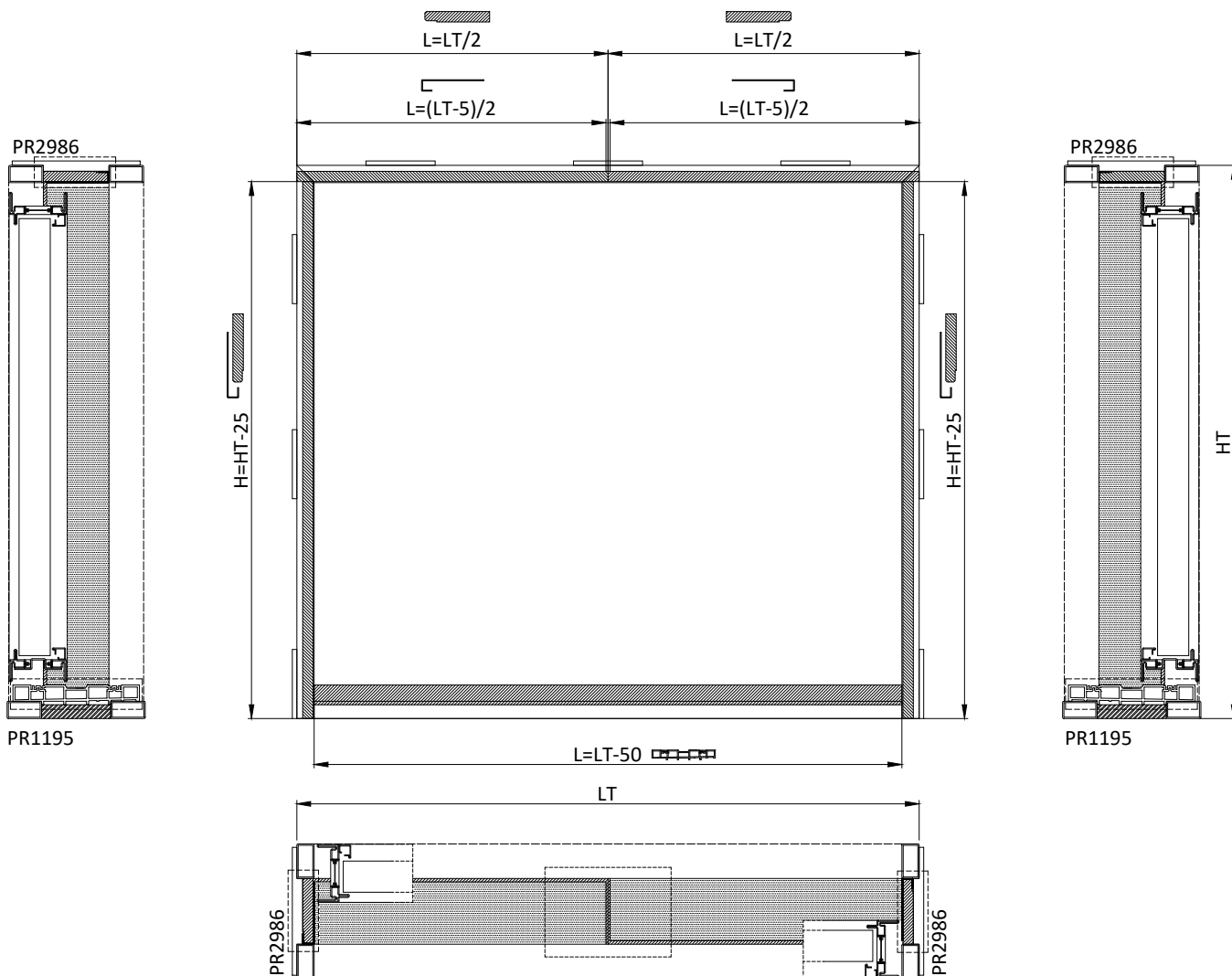
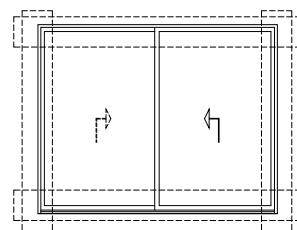
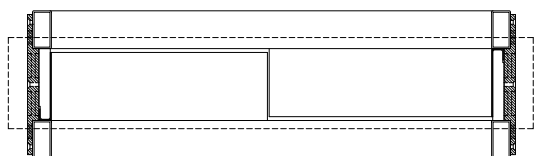
**ATTENTION perforate the profile before assembling to attach the GU2955 rail

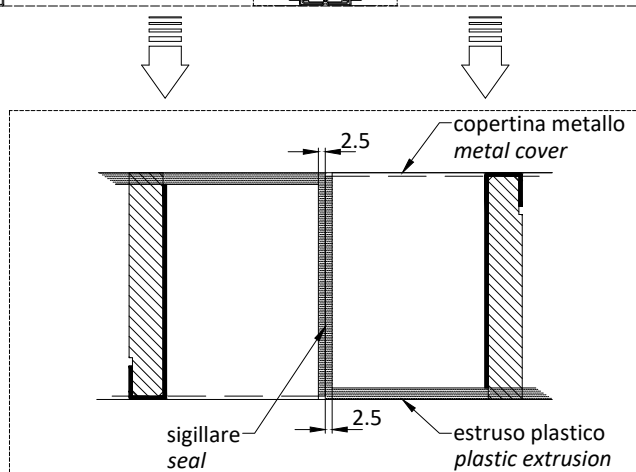
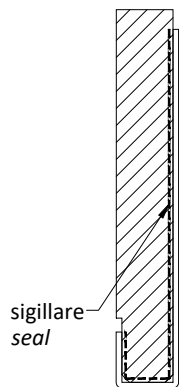
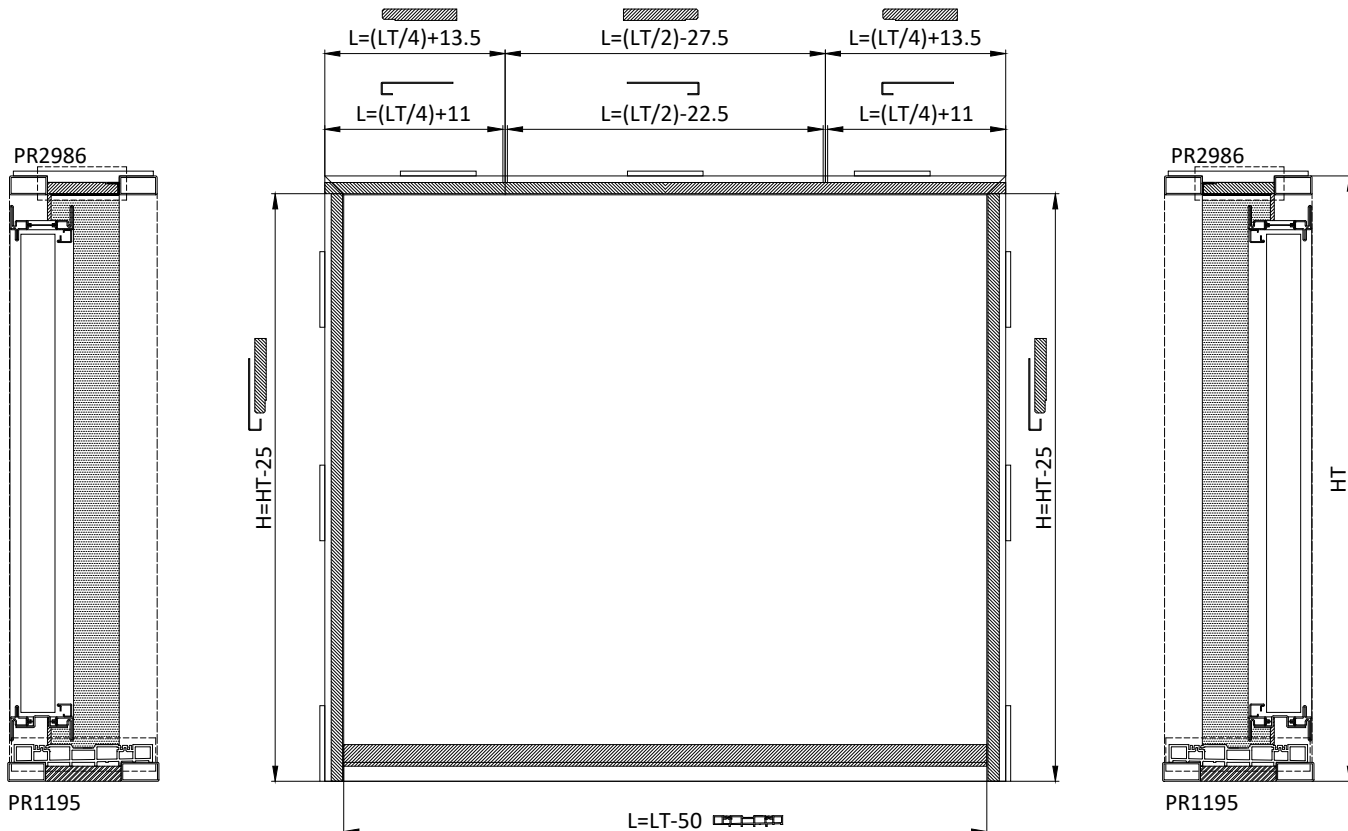
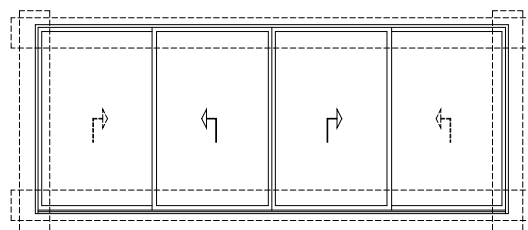
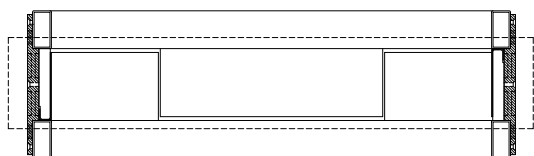


* viti TPS M5x30 non comprese | screws TPS M5x30 not supplied

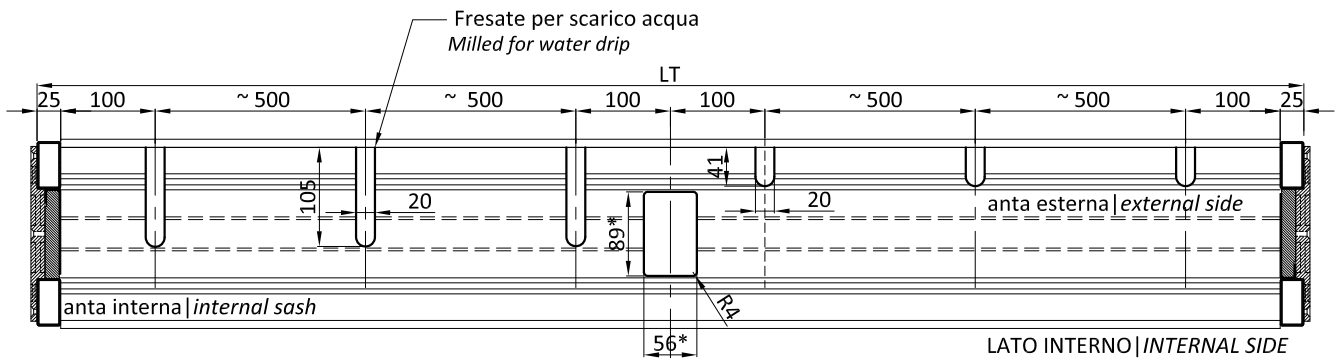
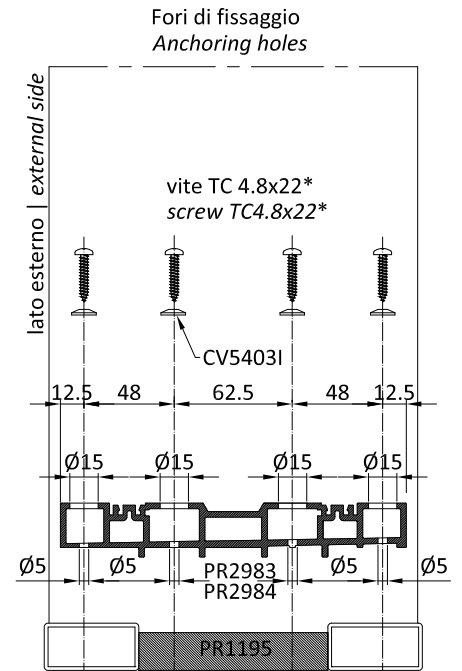
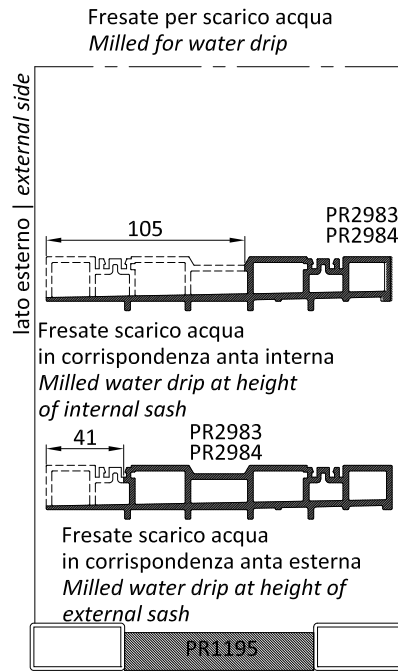
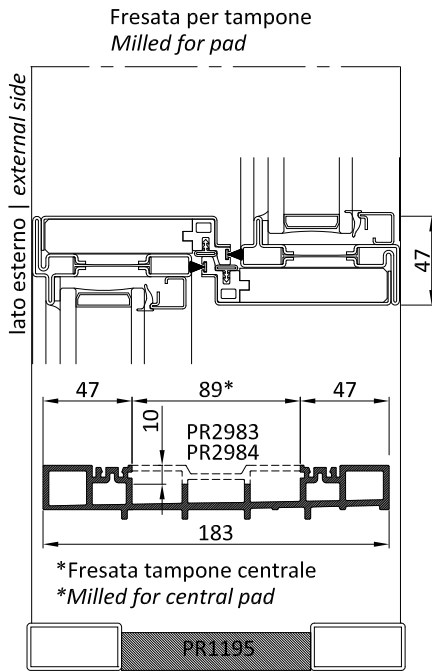
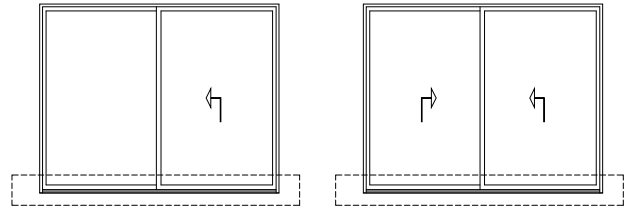
**ATTENZIONE forare il profilo prima dell'assemblaggio per il fissaggio della guida GU2955

**ATTENTION perforate the profile before assembling to attach the GU2955 rail

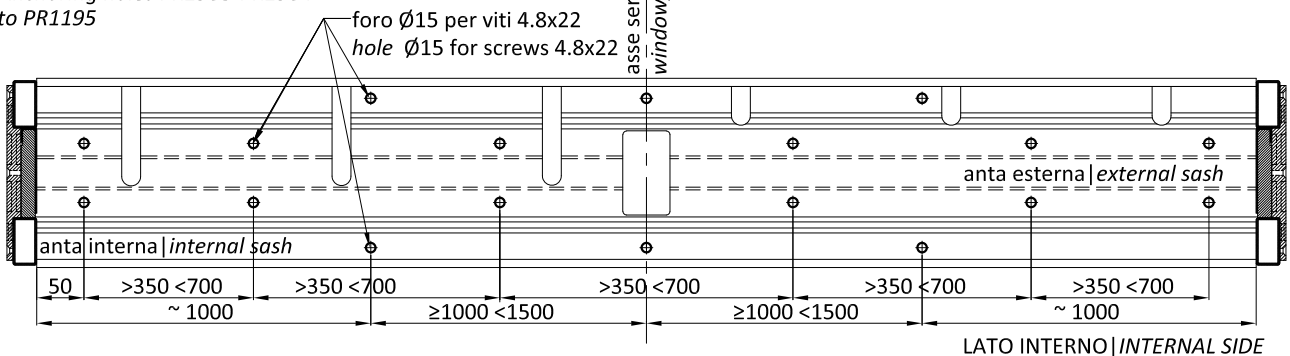




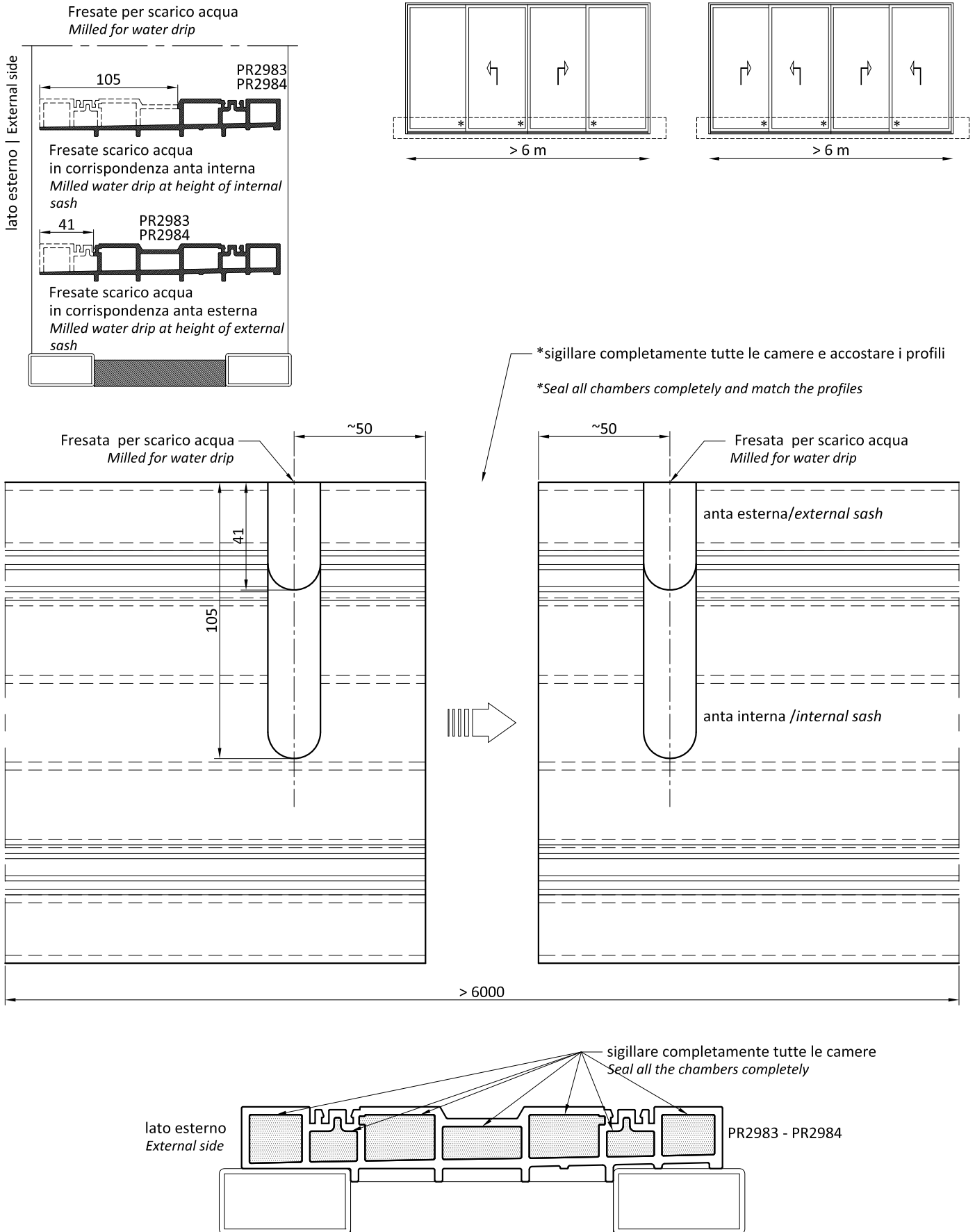
***DA VERIFICARE CON LE DIMENSIONI DELL'ACCESSORIO CONSEGNA TO**
***TO VERIFY WITH DIMENSIONS OF THE DELIVERED ACCESSORY**



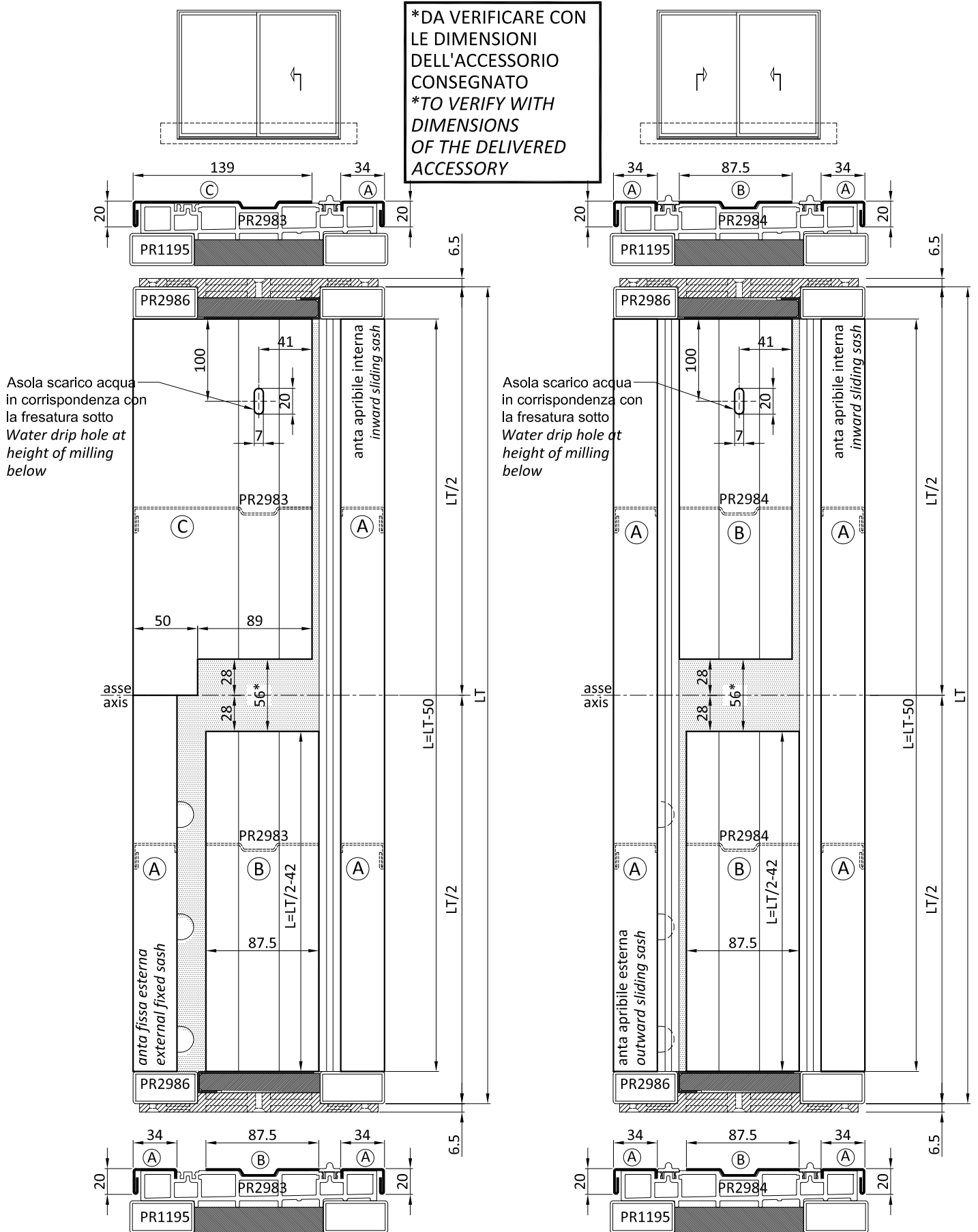
Fori di fissaggio PR2983-PR2984 al PR1195
Anchoring holes PR2983-PR2984 to PR1195



* viti TPS-TC 4.8 x 22 non comprese
*screws TPS-TC 4.8x22 not supplied

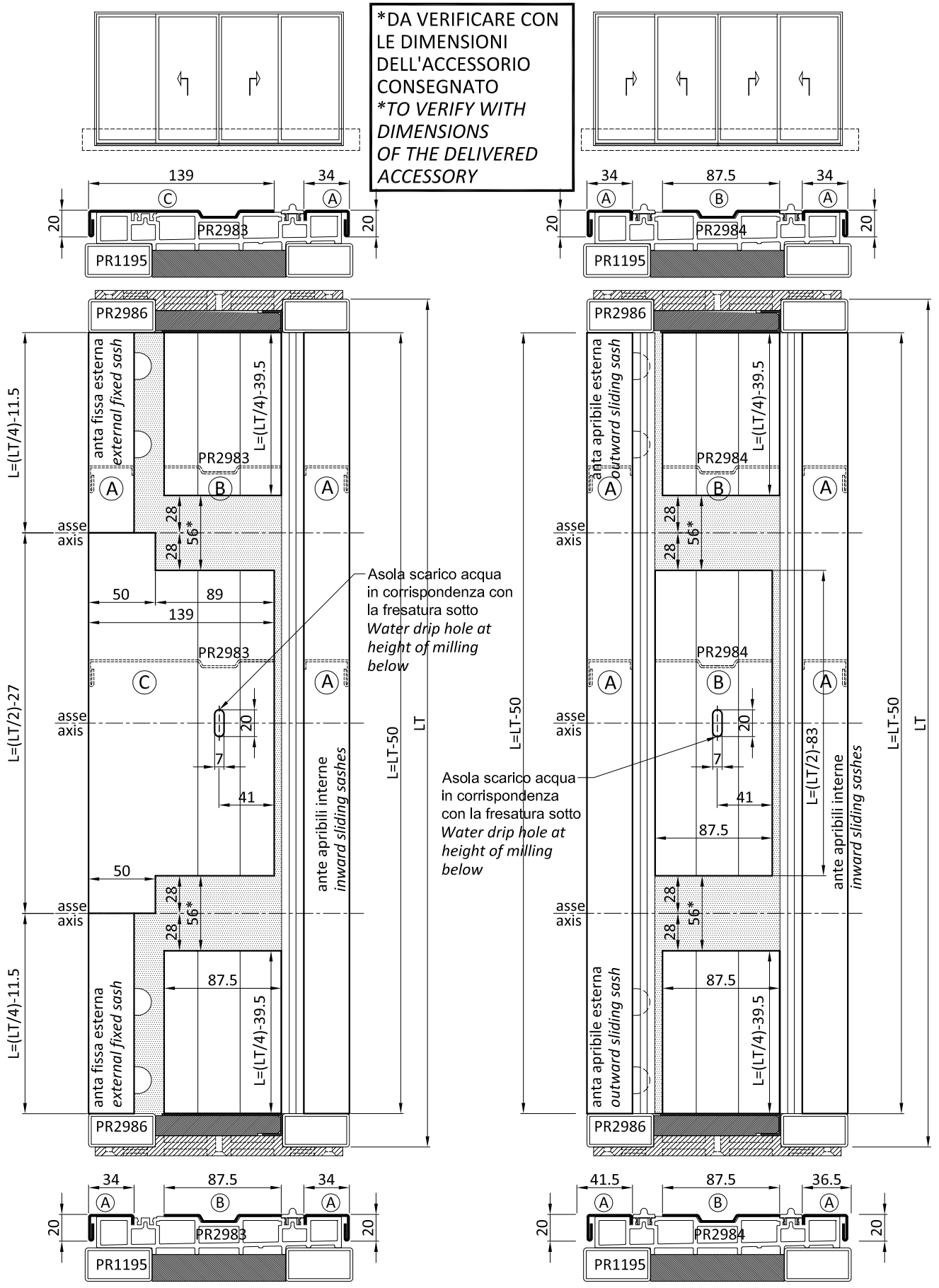


* VIETATA la giunzione in asse del labirinto dove viene eseguita la fresatura per il tampone ed in asse centrale del serramento dove si incontrano le due ante interne ed è realizzato lo scarico acqua centrale
*FORBIDDEN the junction on the axis of the labyrinth where milling is carried out for the pad and on the central axis of the door/window where the two internal sashes meet and the main water drip is located



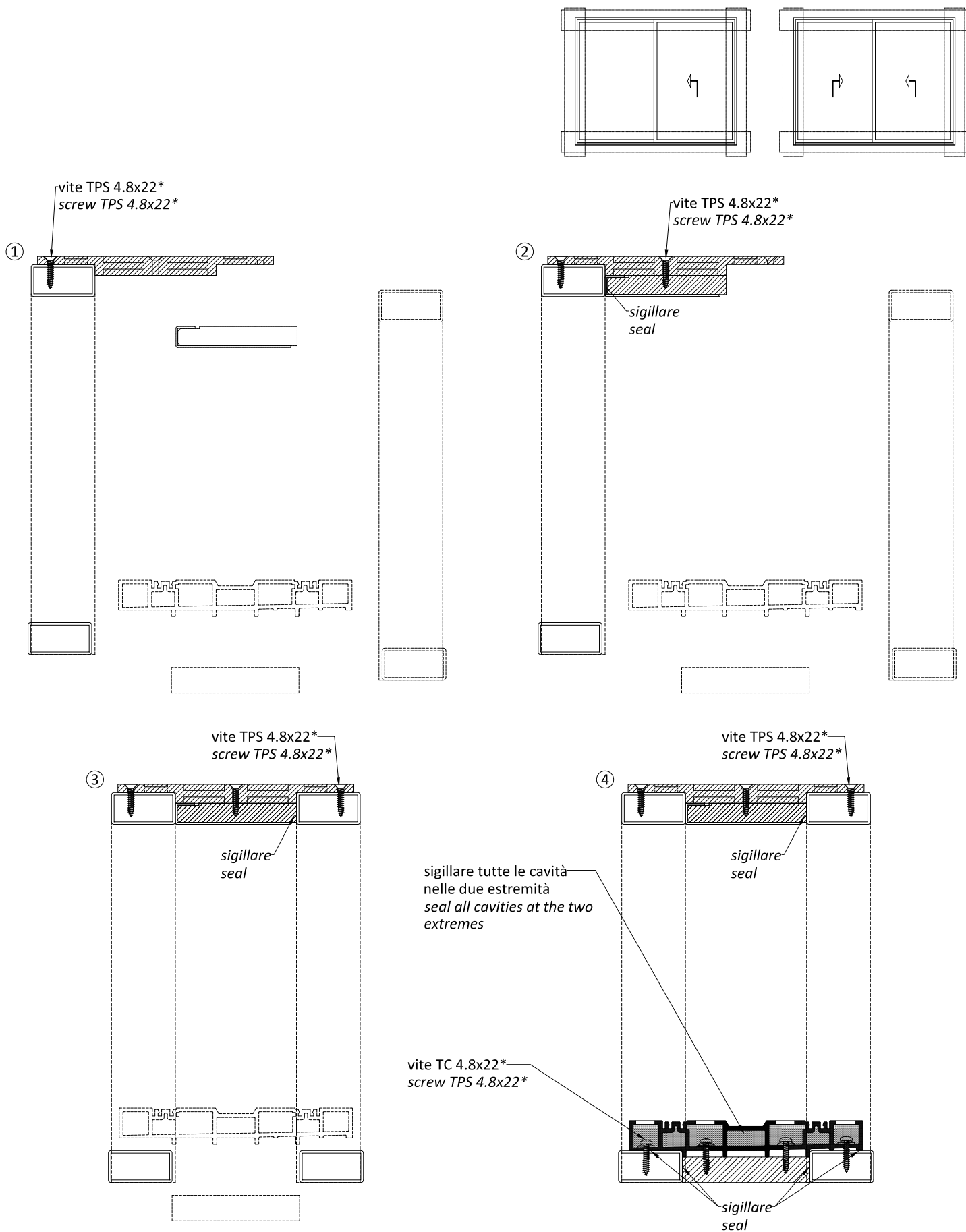
Le copertine in metallo devono essere fissate al profilo estruso PR2983-PR2984 mediante incollaggio con silicone
 The metal covers have to be attached to the extrusion profile PR2983-PR2984 with silicon
 La copertina A interna va posizionata dopo il fissaggio del serramento a terra
 Internal cover A must be put in place once the window/door has been attached on the ground



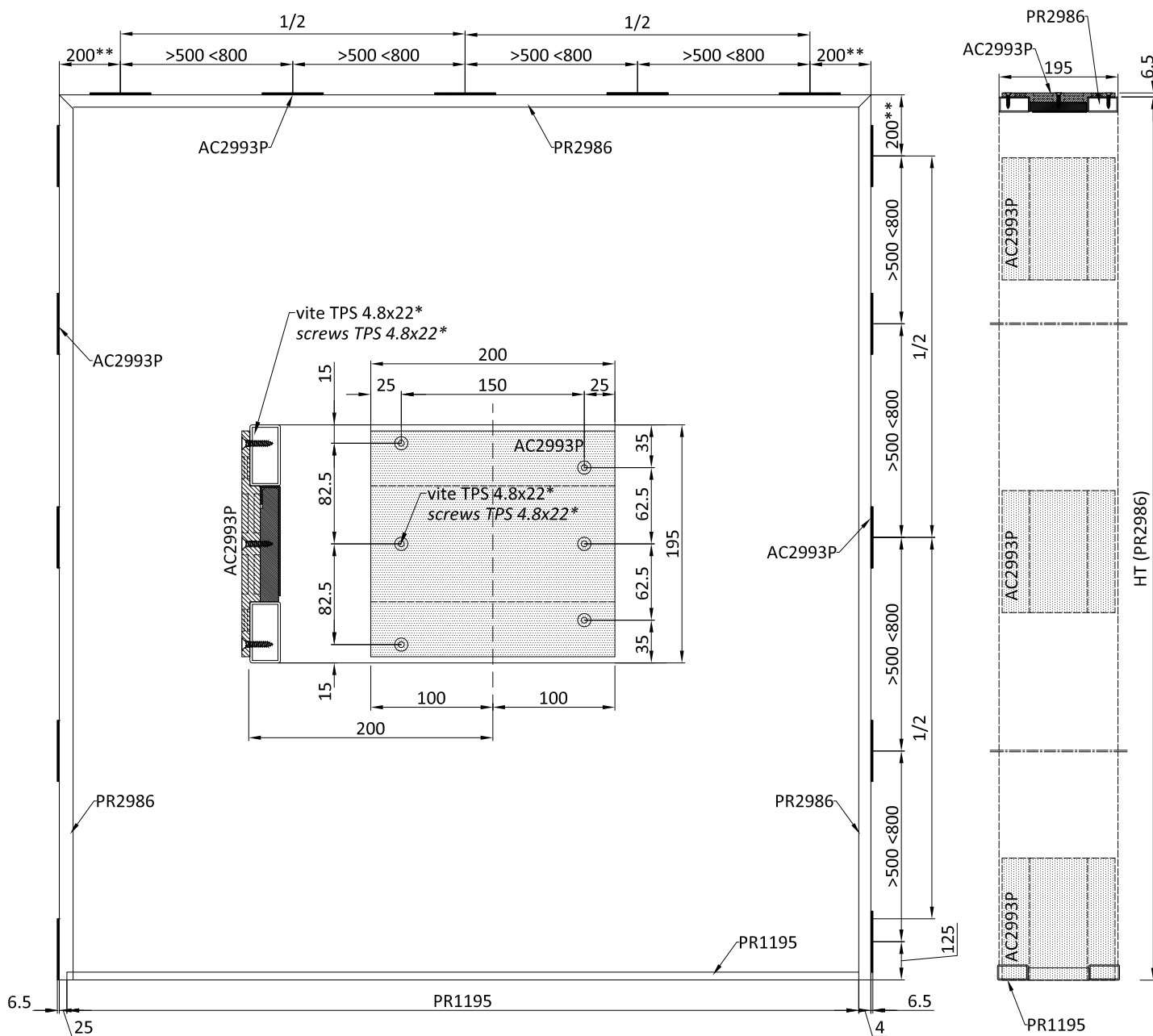
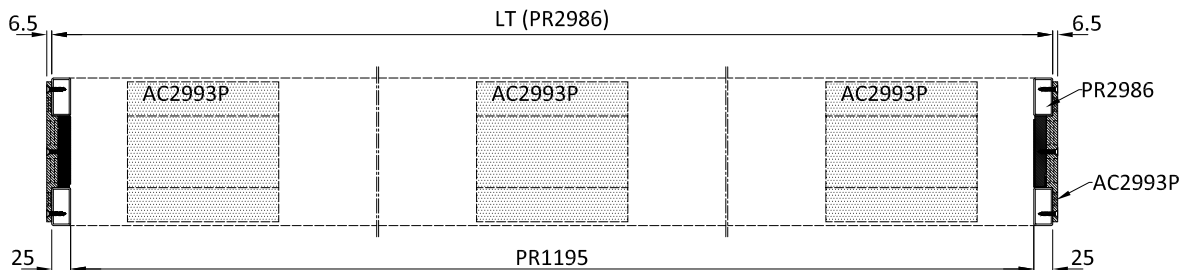
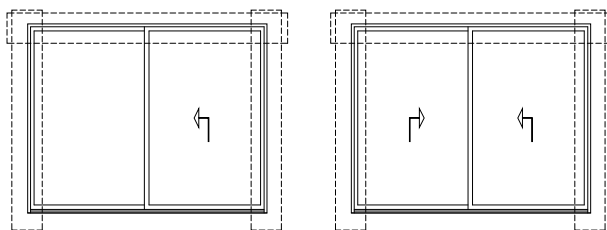


Le copertine in metallo devono essere fissate al profilo estruso PR2983-PR2984 mediante incollaggio con silicone
 The metal covers have to be attached to the extrusion profile PR2983-PR2984 with silicon
 La copertina A interna va posizionata dopo il fissaggio del serramento a terra
 Internal cover A must be put in place once the window/door has been attached on the ground



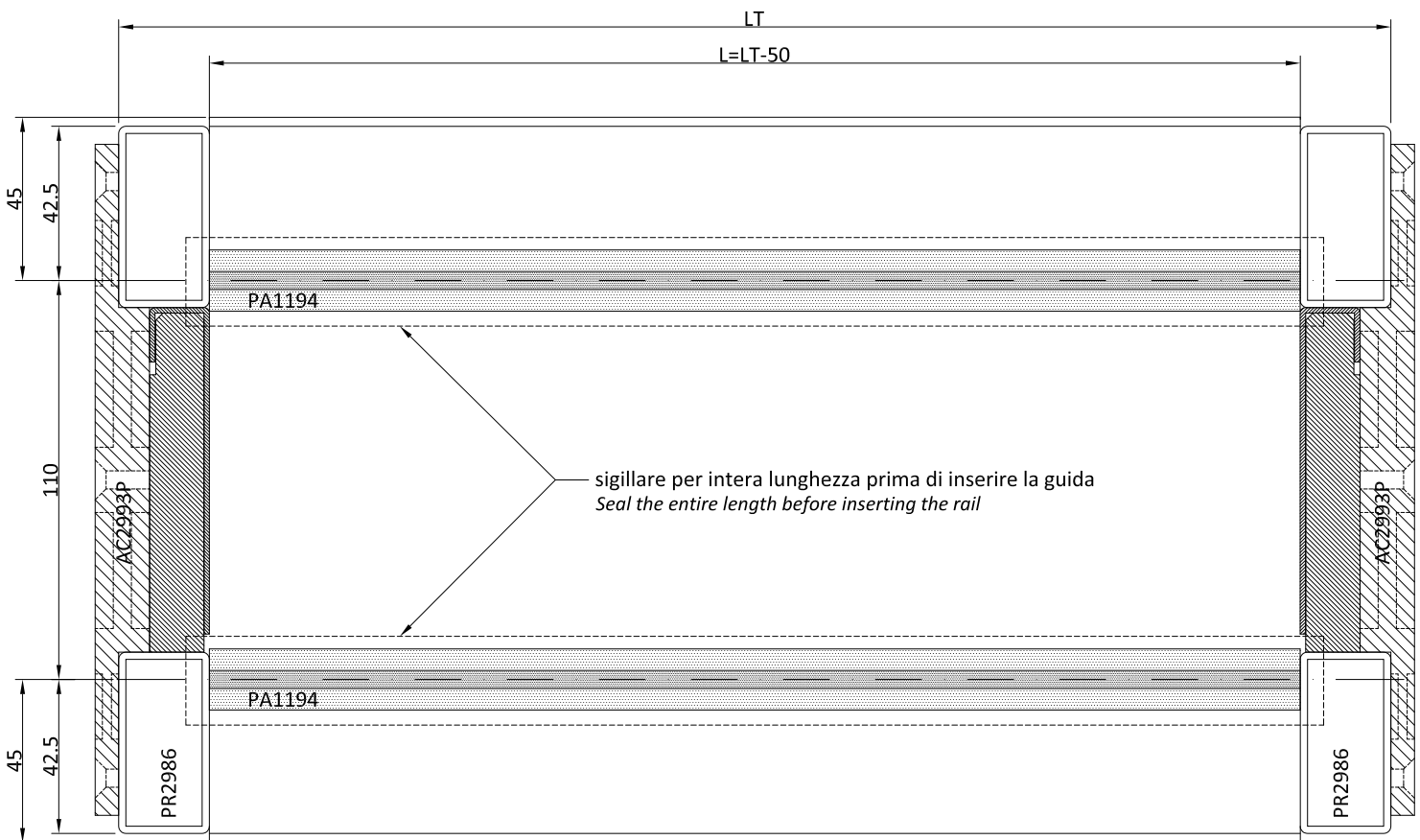
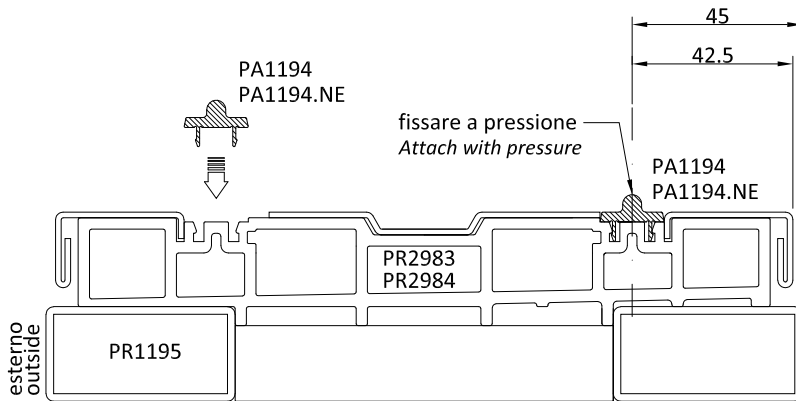
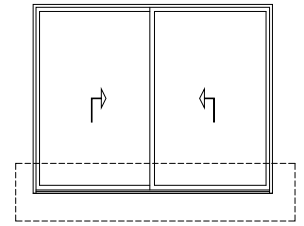


* viti TPS-TC 4.8x22 non comprese
 * screws TPS-TC 4.8x22 not supplied

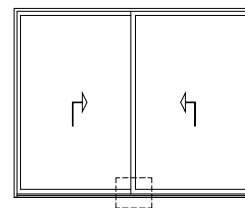
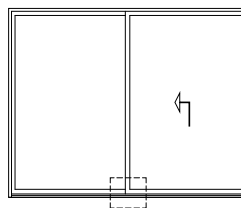


* vite TPS-TC 4.8x22 non comprese | screws TPS-TC 4.8x22 not supplied
**con squadretta AC290TES | with bracket AC290TES - 200→300 mm

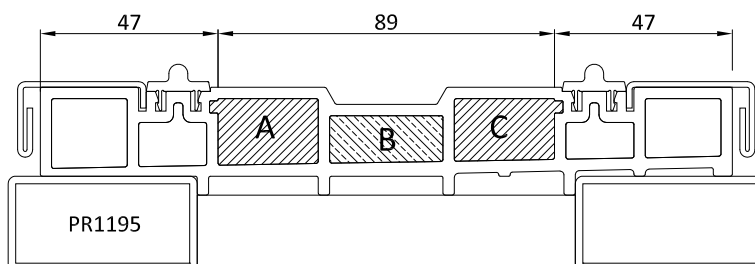
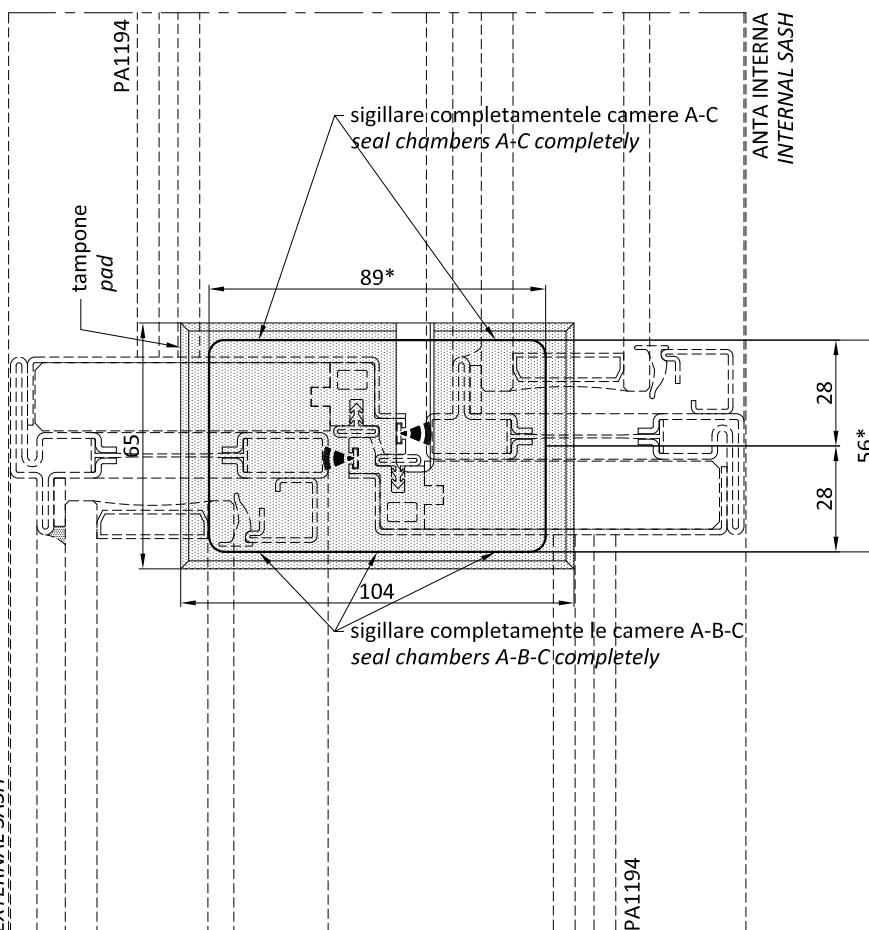
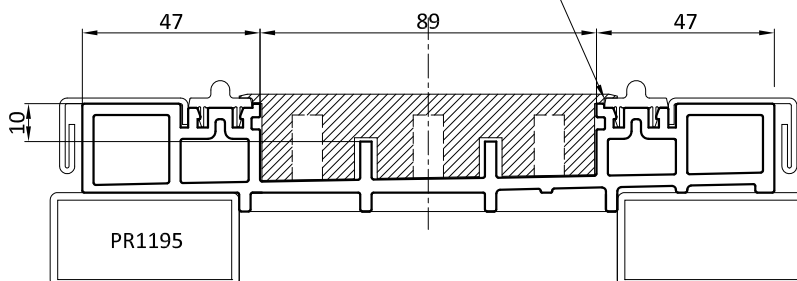
lavorazione valida anche per guida singola
 processing also valid for individual rail

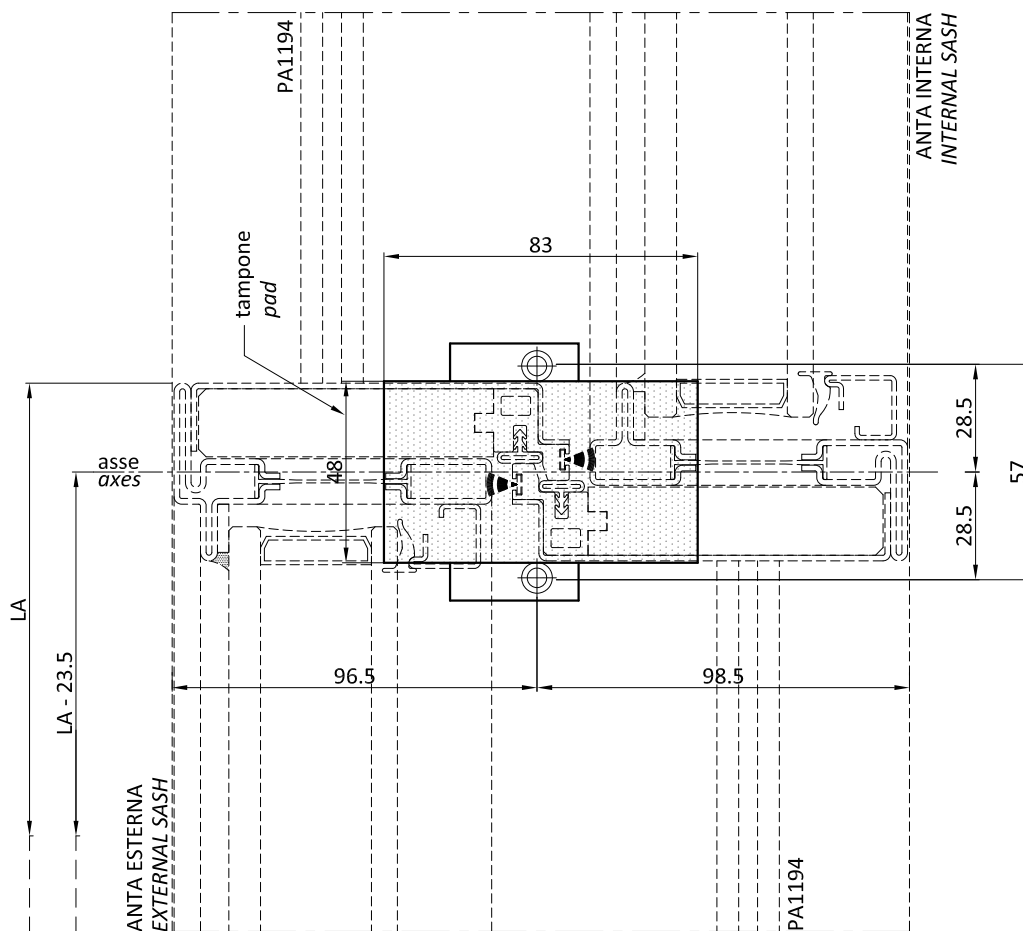
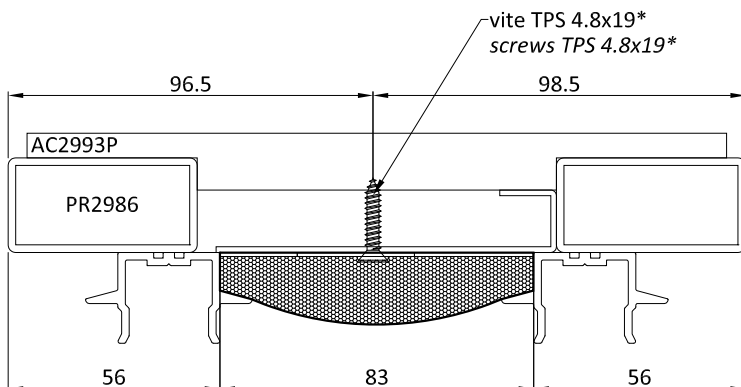
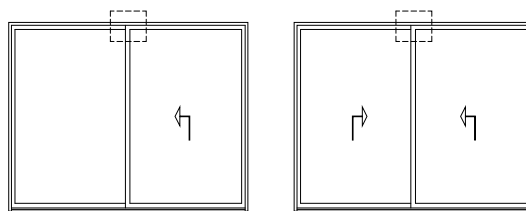


***DA VERIFICARE CON LE DIMENSIONI DELL'ACCESSORIO CONSEGNA TO**
***TO VERIFY WITH DIMENSIONS OF THE DELIVERED ACCESSORY**



sigillare il perimetro prima di inserire il tampone
 seal the perimeter before inserting the pad





NOTE:

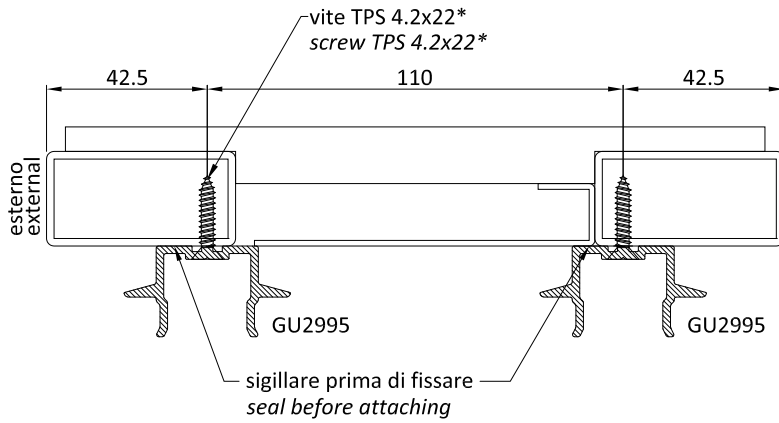
- Inserire e fissare la prima guida con la rispettiva anta
- Inserire e fissare il tampono
- Inserire e fissare la seconda guida con la rispettiva anta

NOTE:

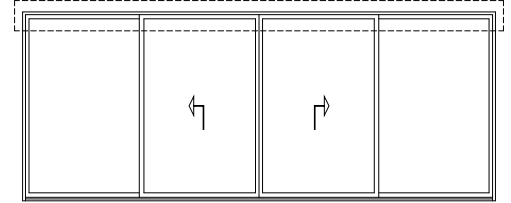
- Insert and attach the first rail with respective sash*
- Insert and attach the pad*
- Insert and attach the second rail with respective sash*

* viti TPS 4.2 x 19 non comprese
 * screws TPS 4.2 x 19 not supplied

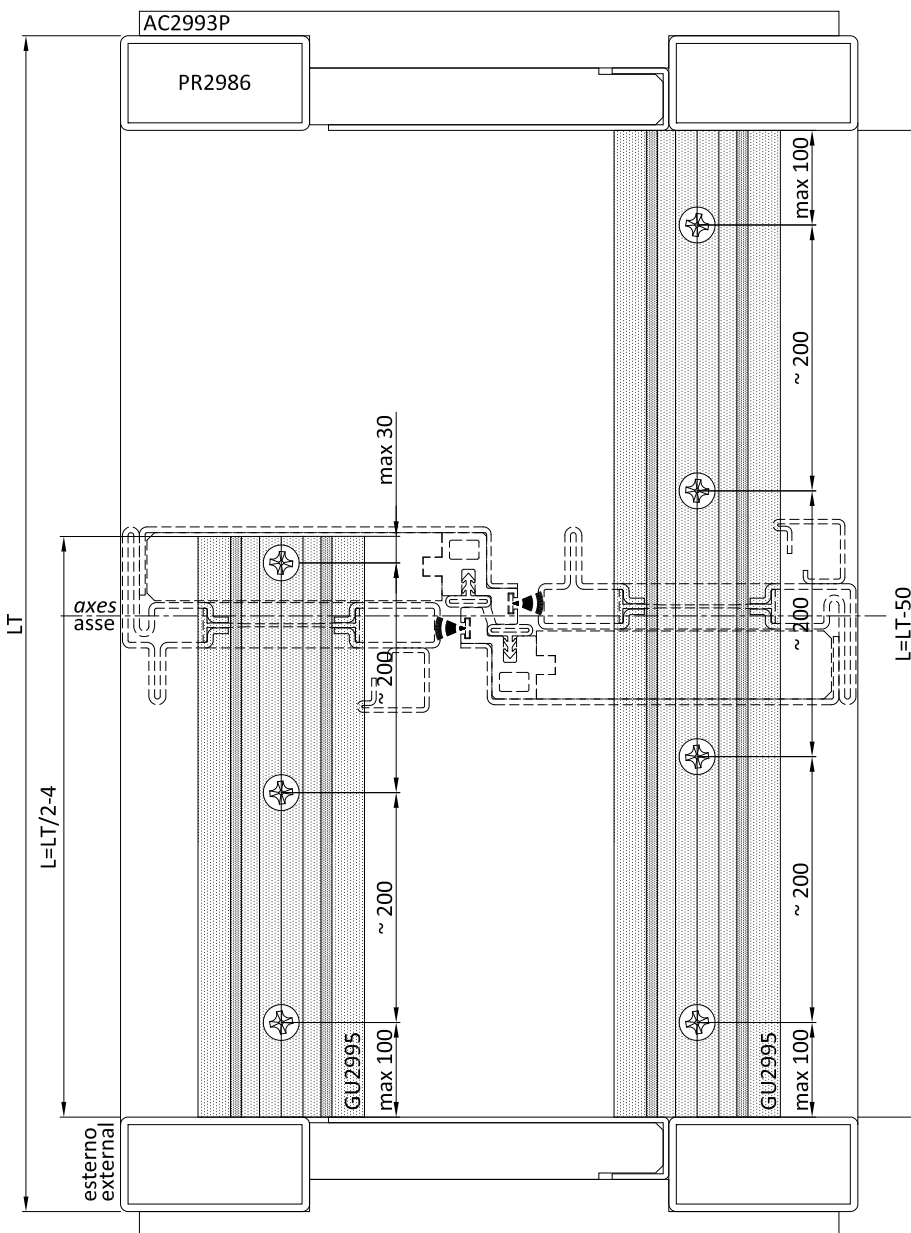




Schema | Type A



Schema | Type E

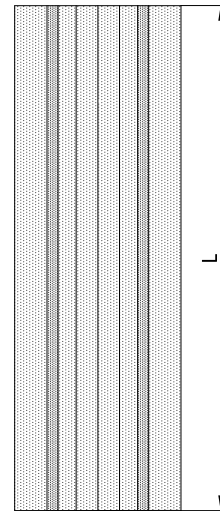
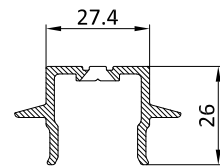


NOTE :

- Preforare il telaio PR2986 prima dell'assemblaggio
- Montare la guida assieme alla posa dell'anta

NOTE:

- Perforate frame PR2986 before assemblage
- Mount the rail when attaching the sash

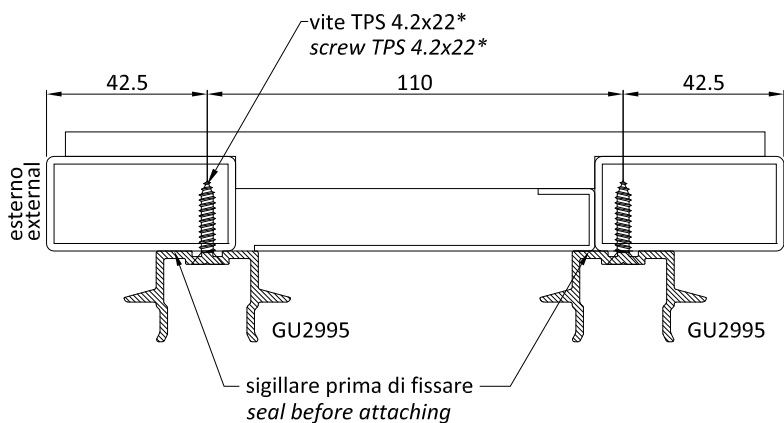


GU2995

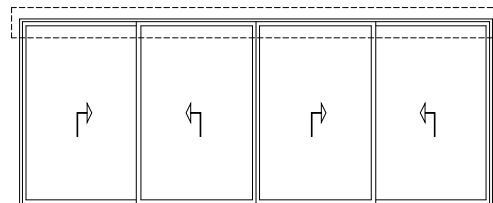
Schema A ed E
lunghezza guida GU2995 interna
 $L=LT-50$
lunghezza guida GU2995 esterna
 $L=LT/2-4$ (2 pz.)

Type A and E
length internal rail GU2995
 $L=LT-50$
length external rail GU2995
 $L=LT/2-4$ (2 pc.)

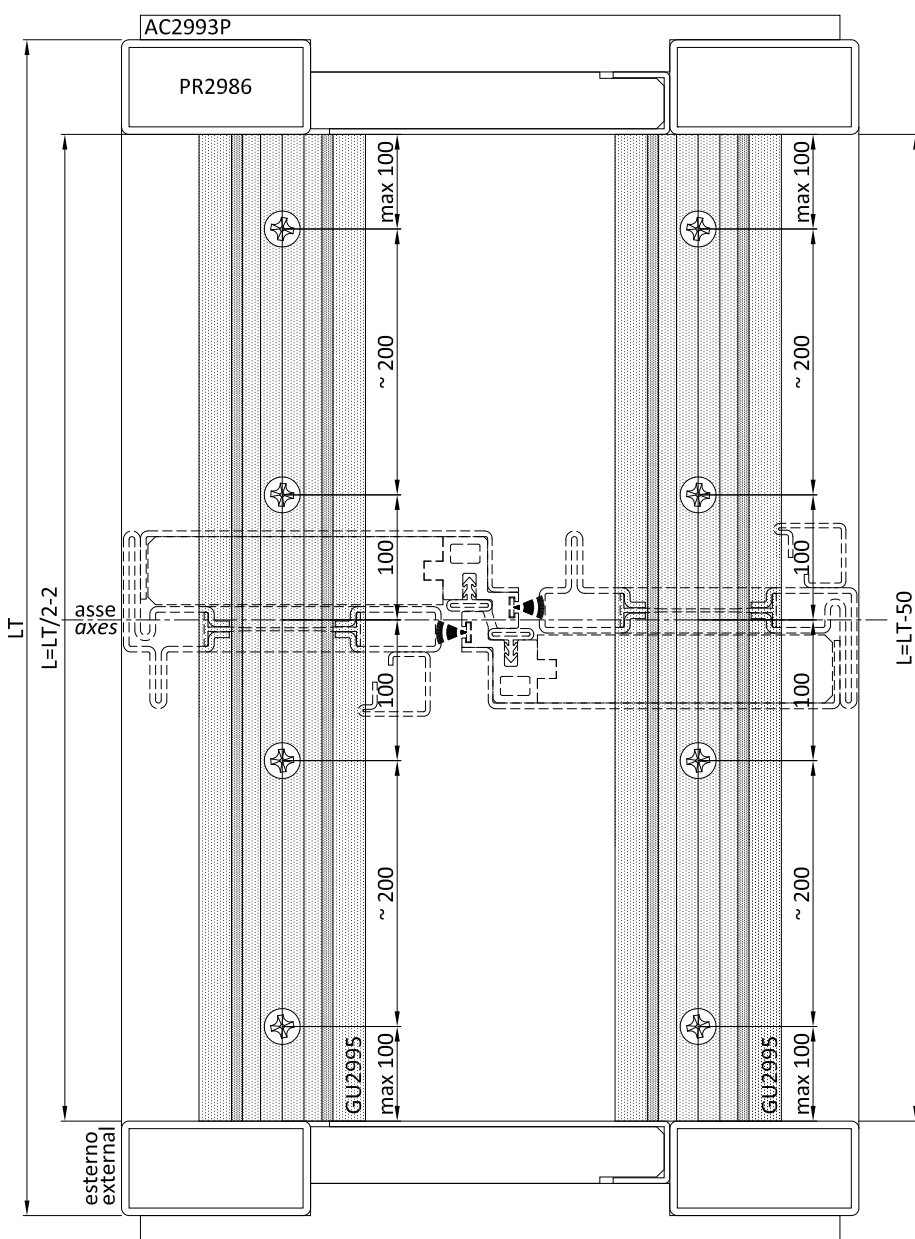
* viti TPS 4.2x22 non comprese
* screws TPS 4.2x22 not supplied



Schema | Type B



Schema | Type F

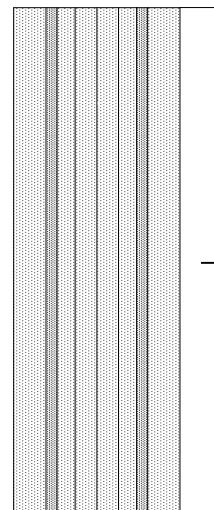
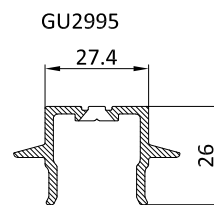


NOTE :

- Preforare il telaio PR2986 prima dell'assemblaggio
- Montare la guida assieme alla posa dell'anta

NOTE:

- Perforate frame PR2986 before assemblage
- Mount the rail when attaching the sash

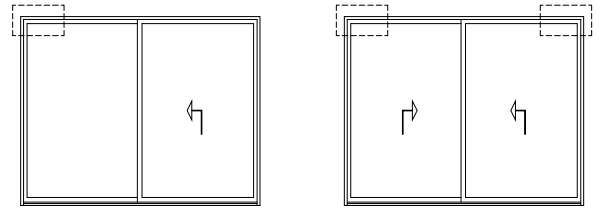
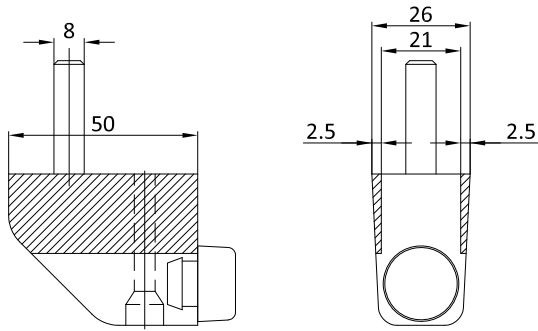


GU2995

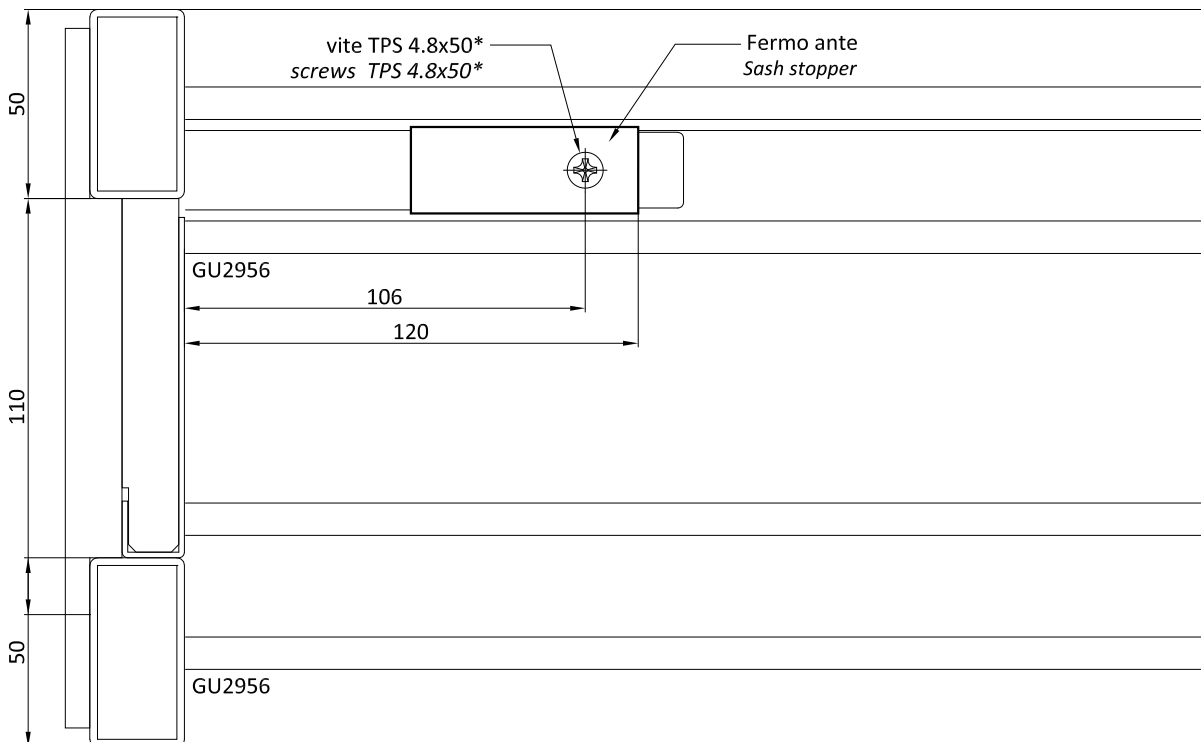
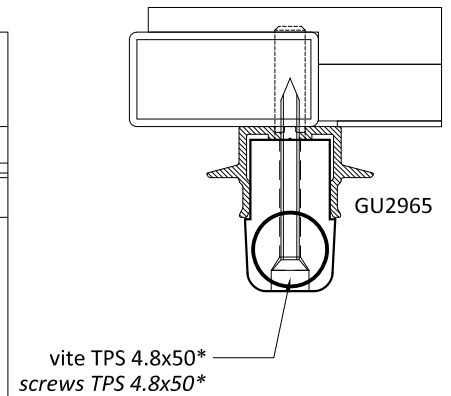
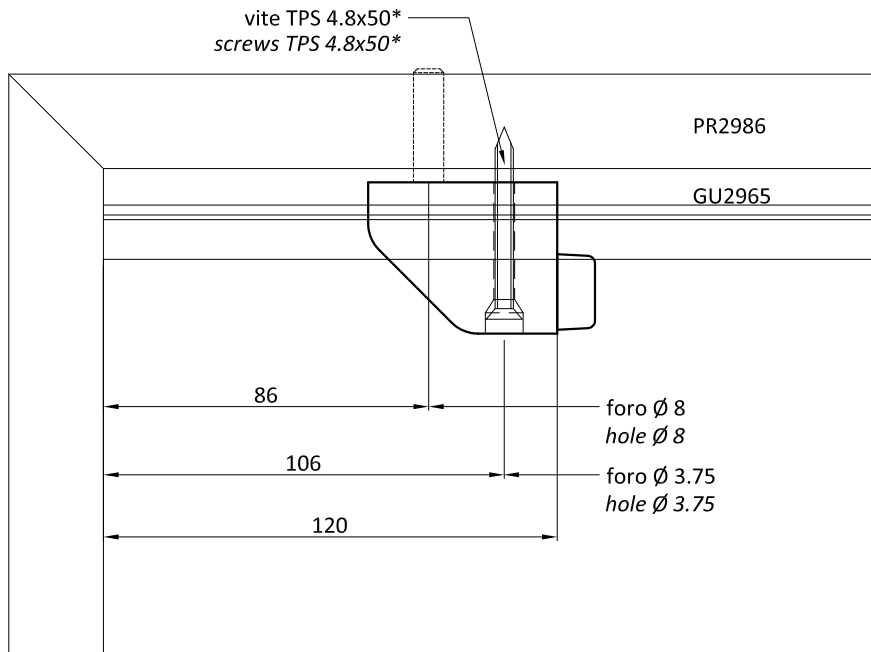
Schema B ed F
lunghezza guida GU2995 interna ed esterna
L=LT-50

Type B and F
length internal and external rail GU2995
L=LT-50

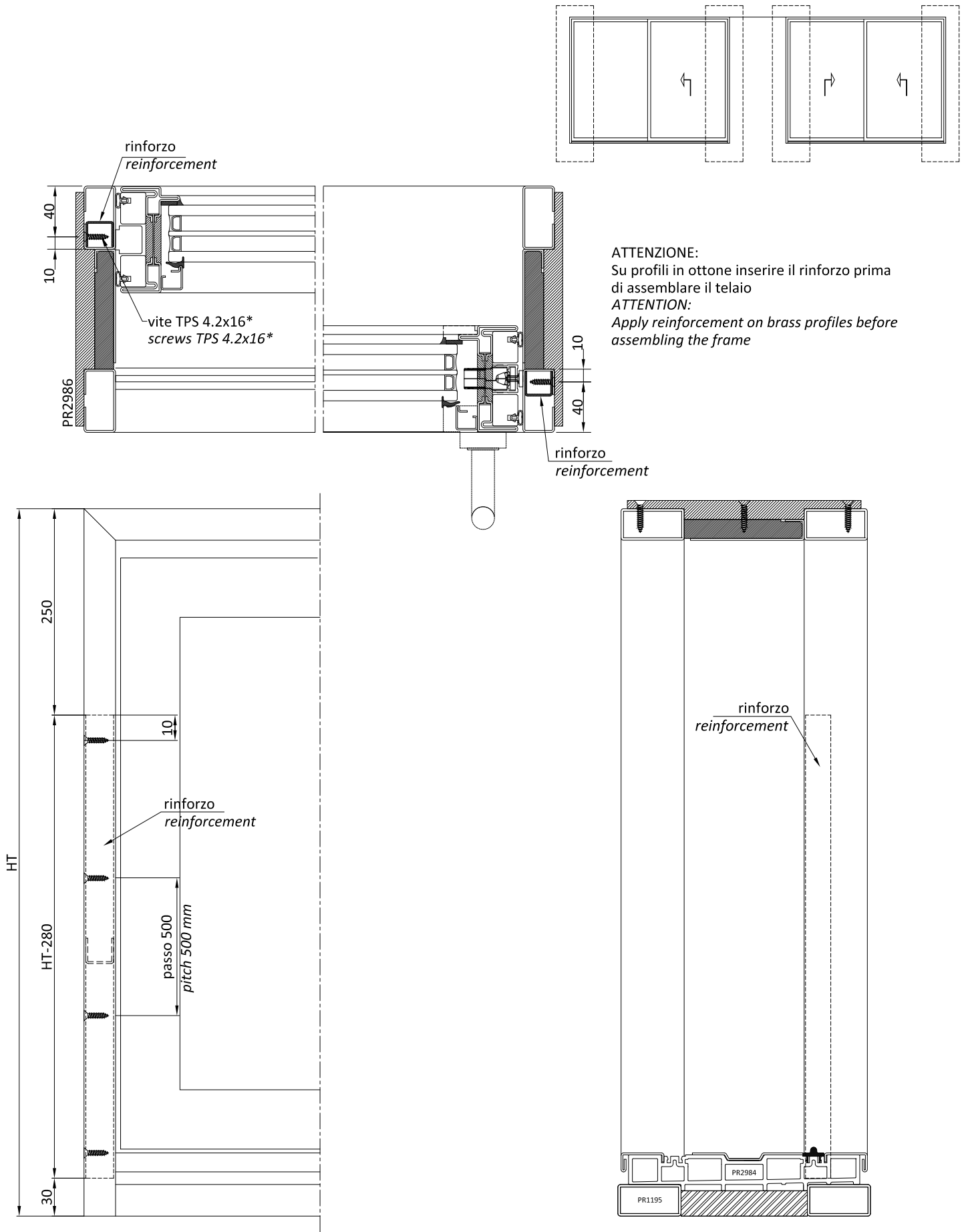
* viti TPS 4.2x22 non comprese
* screws TPS 4.2x22 not supplied



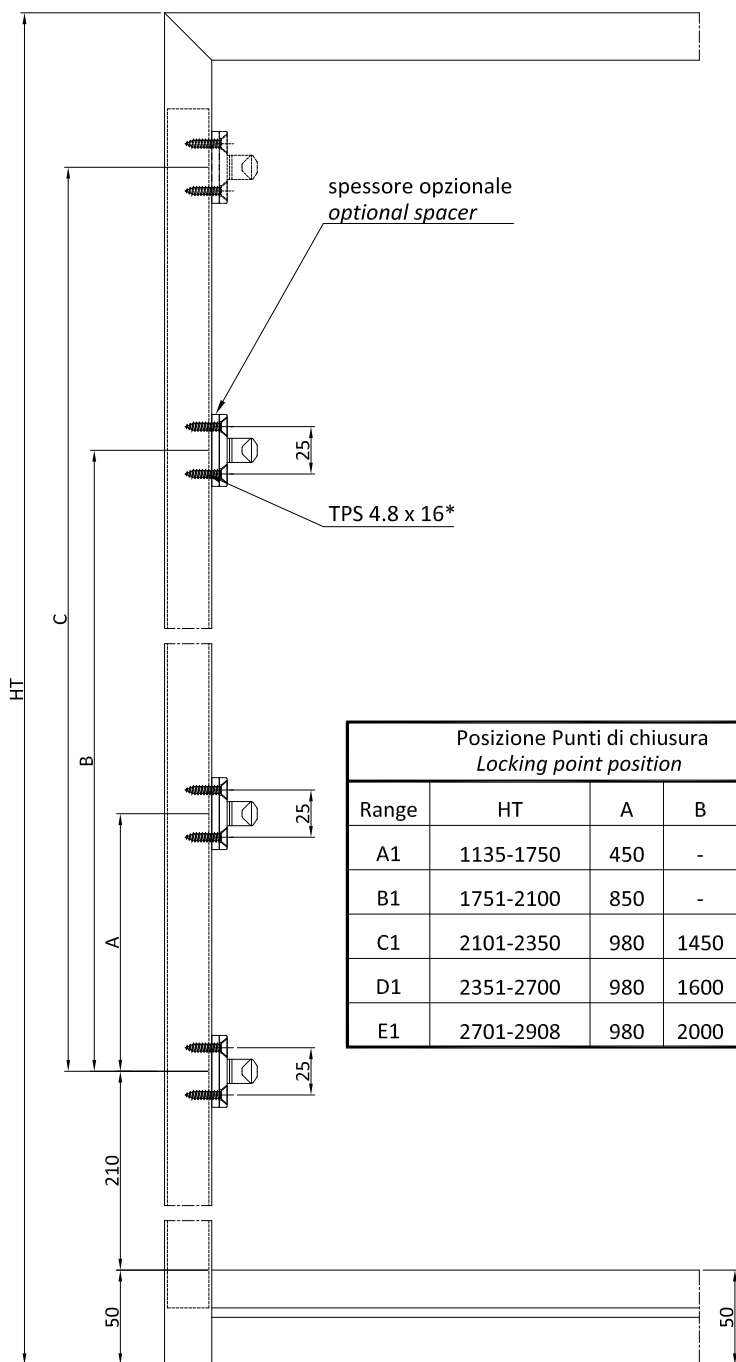
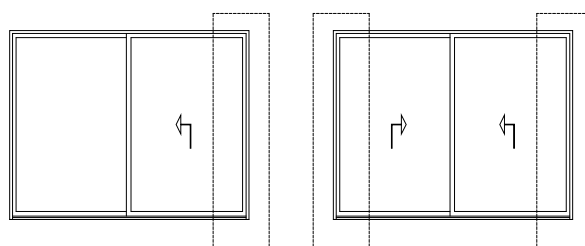
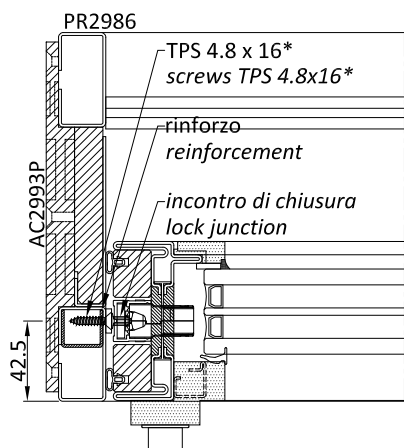
*lavorazione valida anche per guida singola
 processing also valid for individual rail*



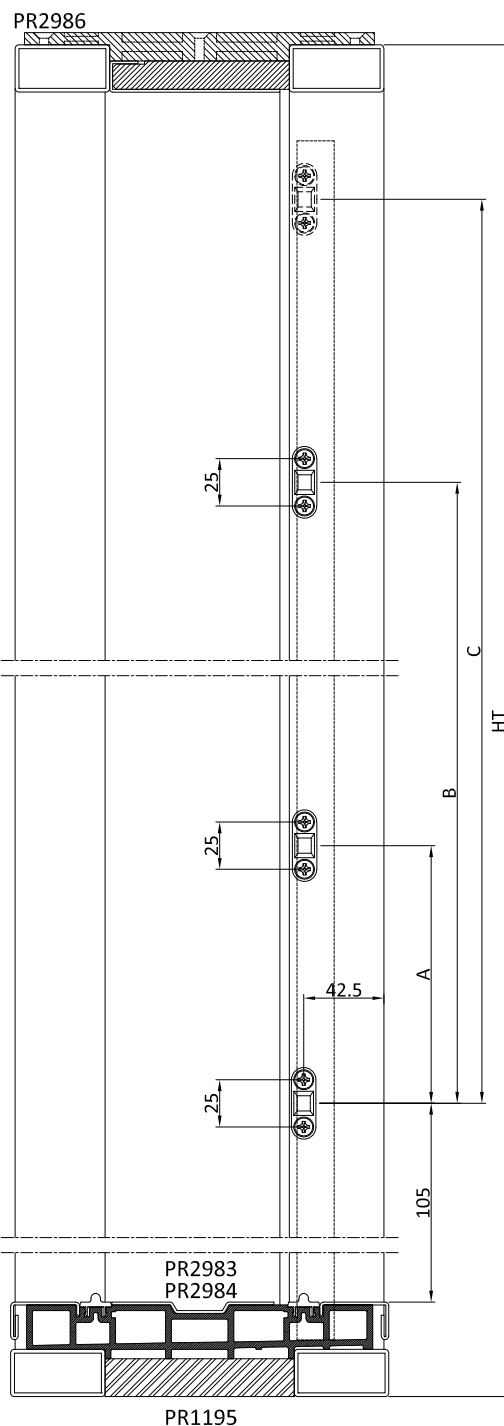
* viti TPS 4.8x50 non comprese
 * screws TPS 4.8x50 not supplied



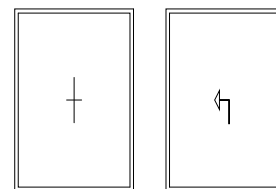
* viti TPS 4.2x16 non comprese
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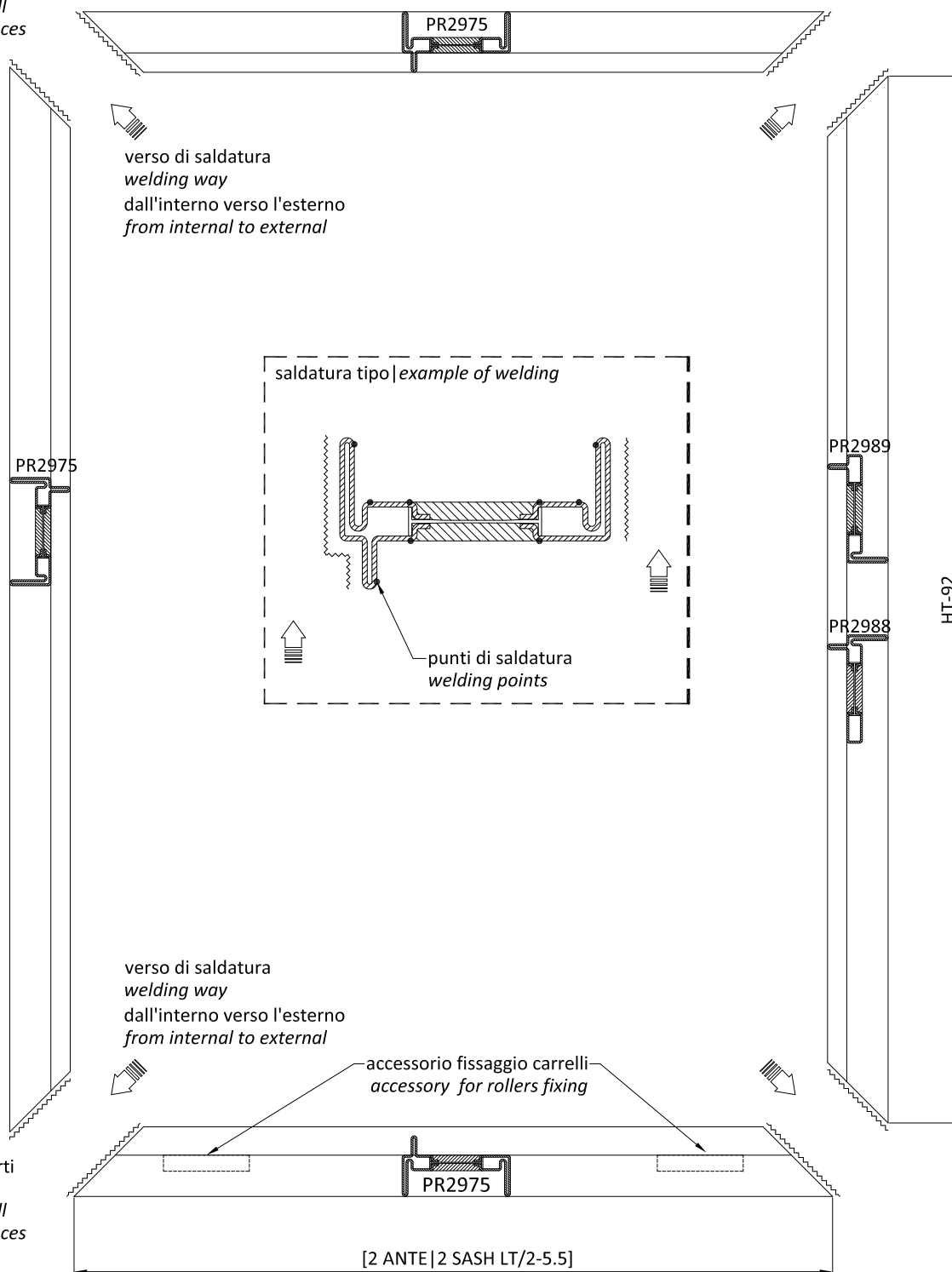
Posizione Punti di chiusura Locking point position				
Range	HT	A	B	C
A1	1135-1750	450	-	-
B1	1751-2100	850	-	-
C1	2101-2350	980	1450	-
D1	2351-2700	980	1600	-
E1	2701-2908	980	2000	VAR.



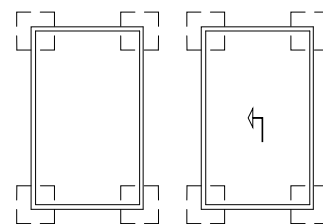
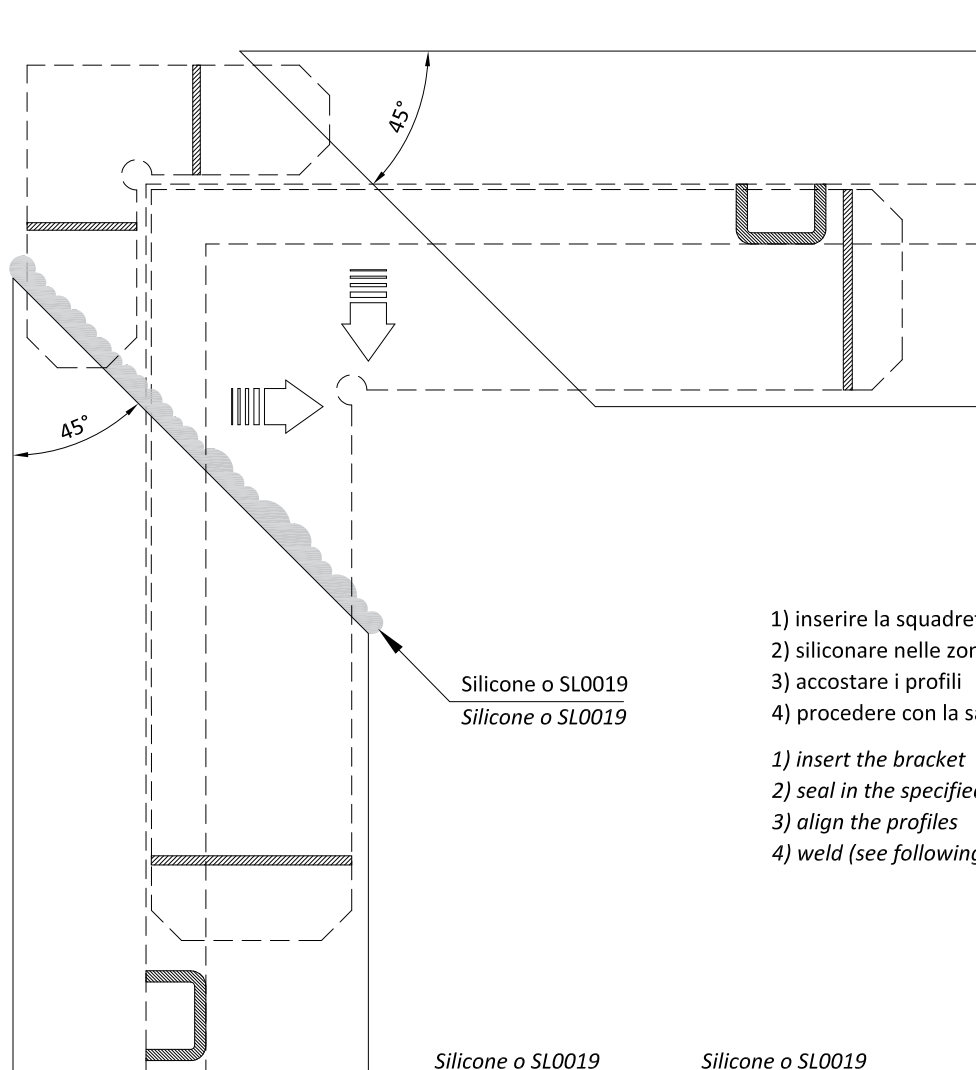
* viti TPS 4.8x16 non comprese
* screws TPS 4.8x16 not supplied



saldare le parti
a contatto
seam-weld all
contact surfaces

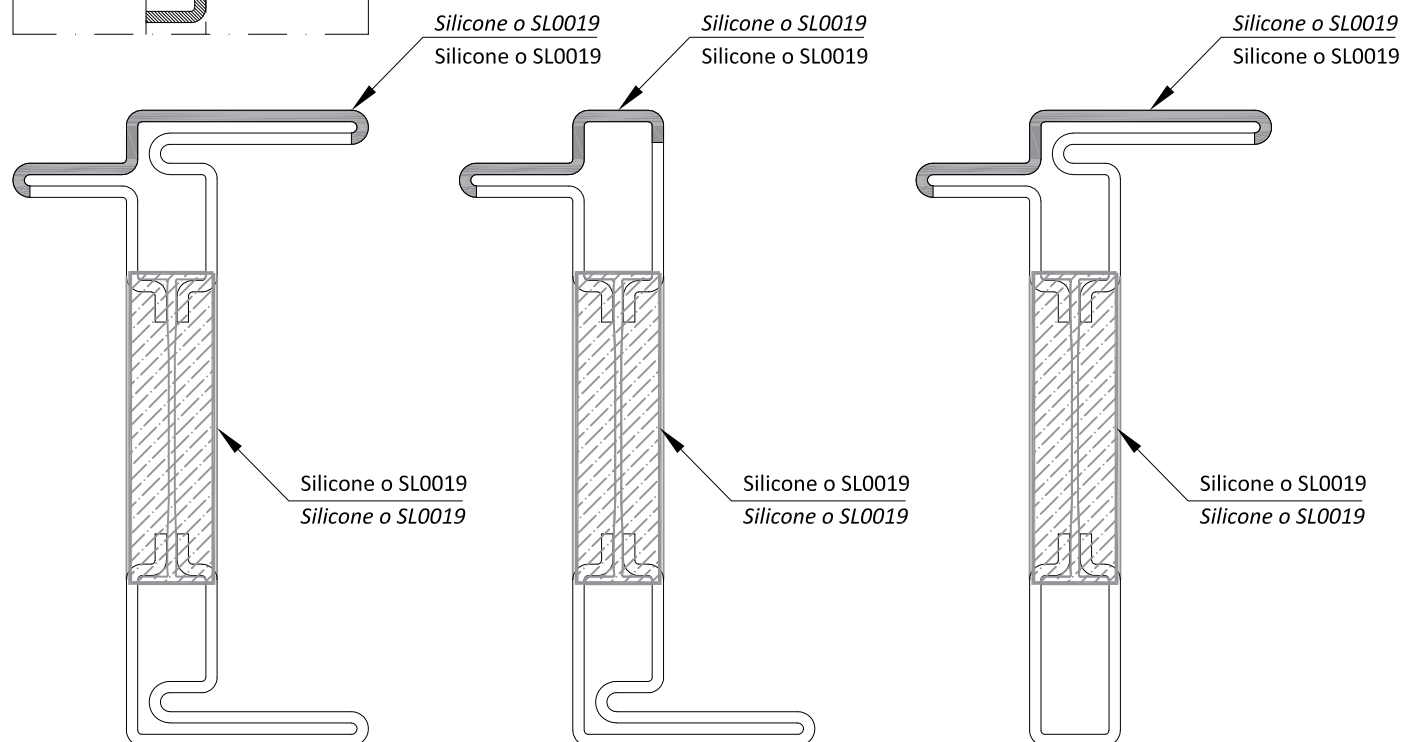


saldare le parti
a contatto
seam-weld all
contact surfaces



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

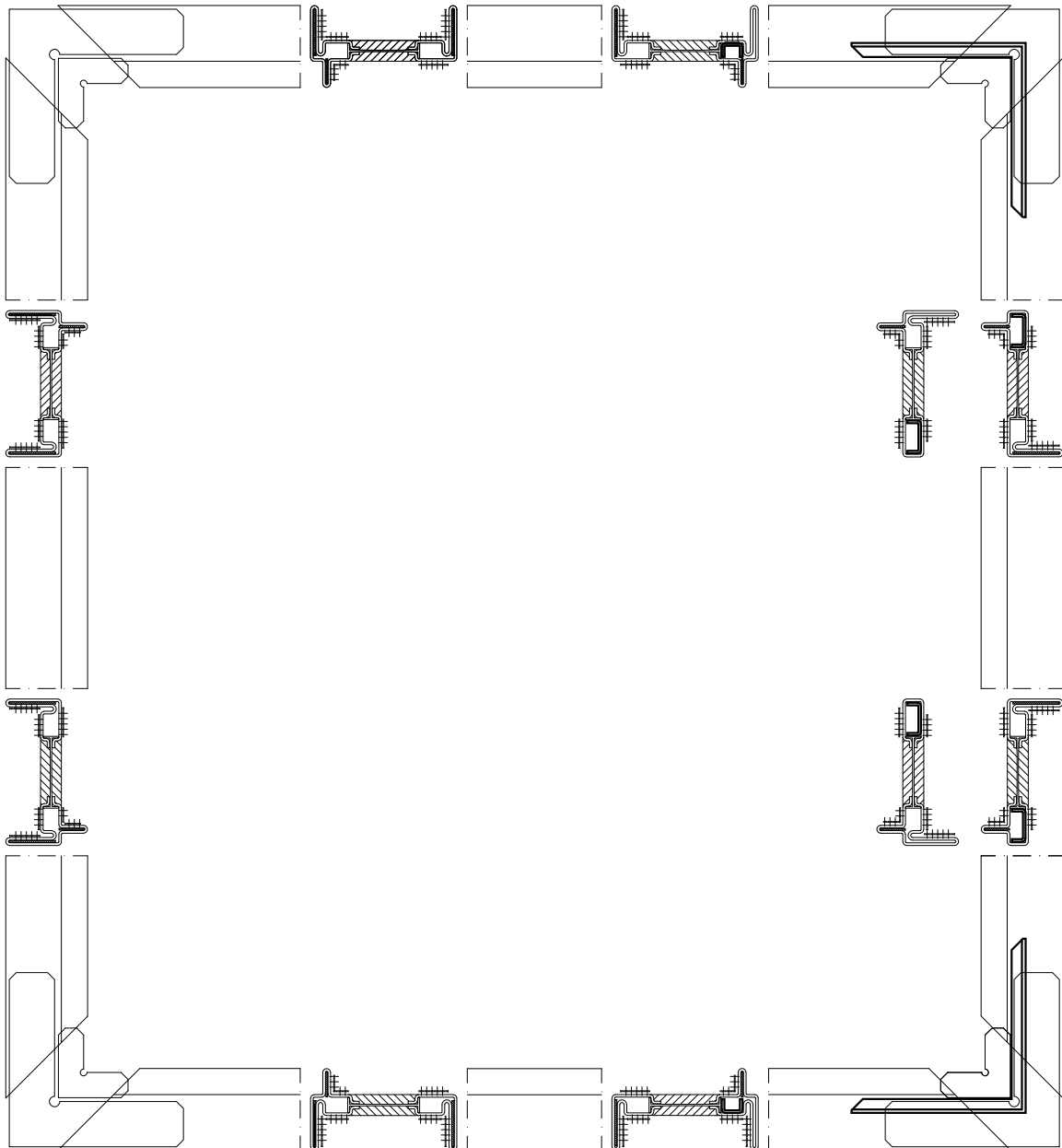
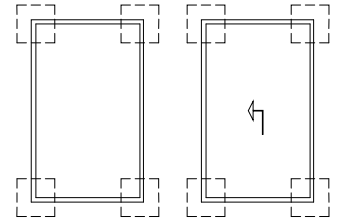
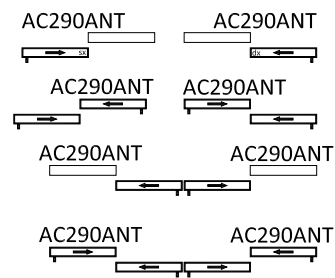
- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)

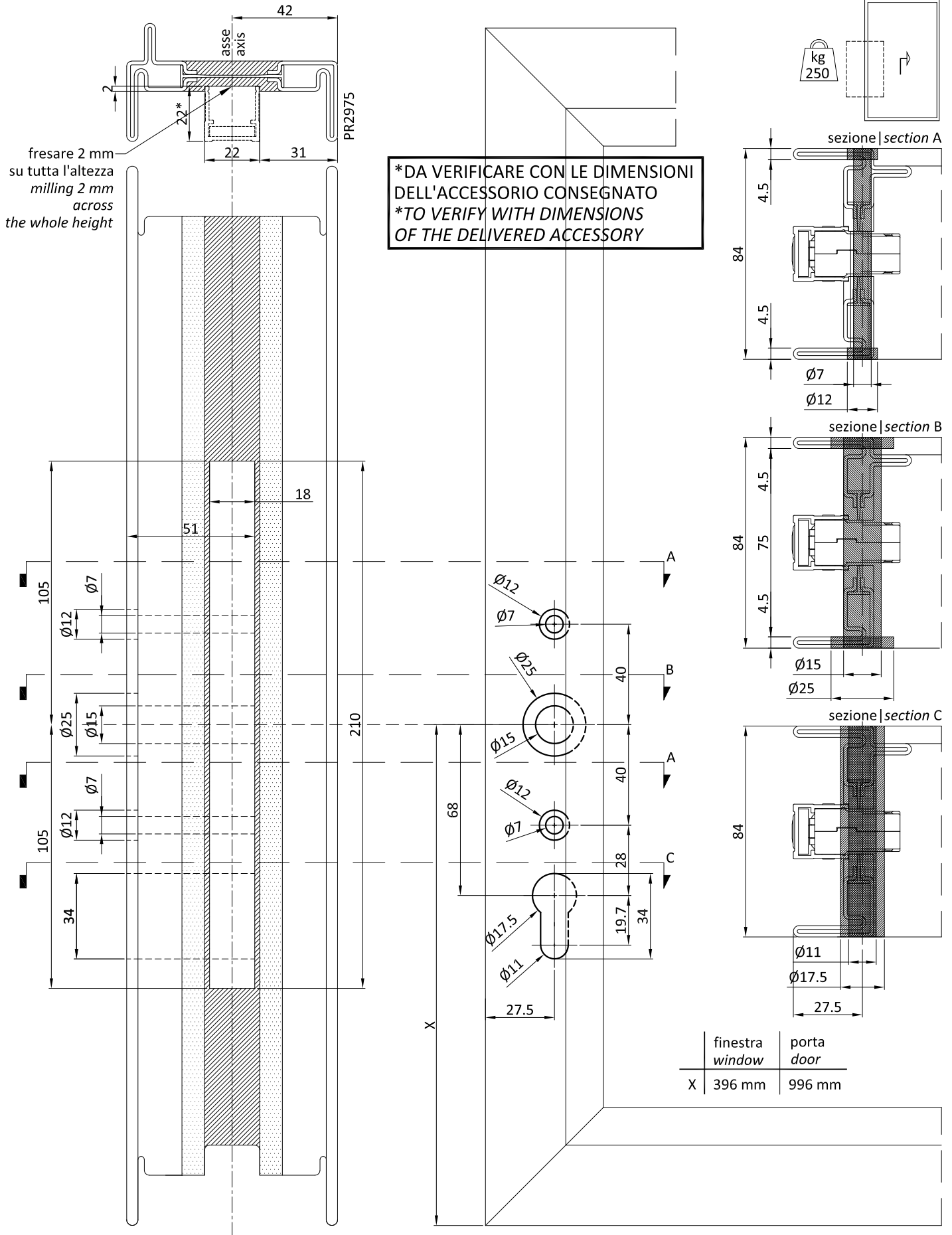


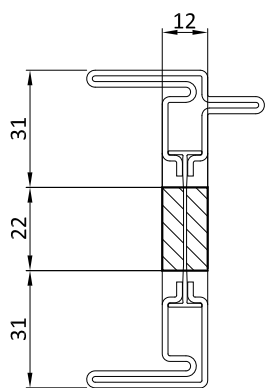
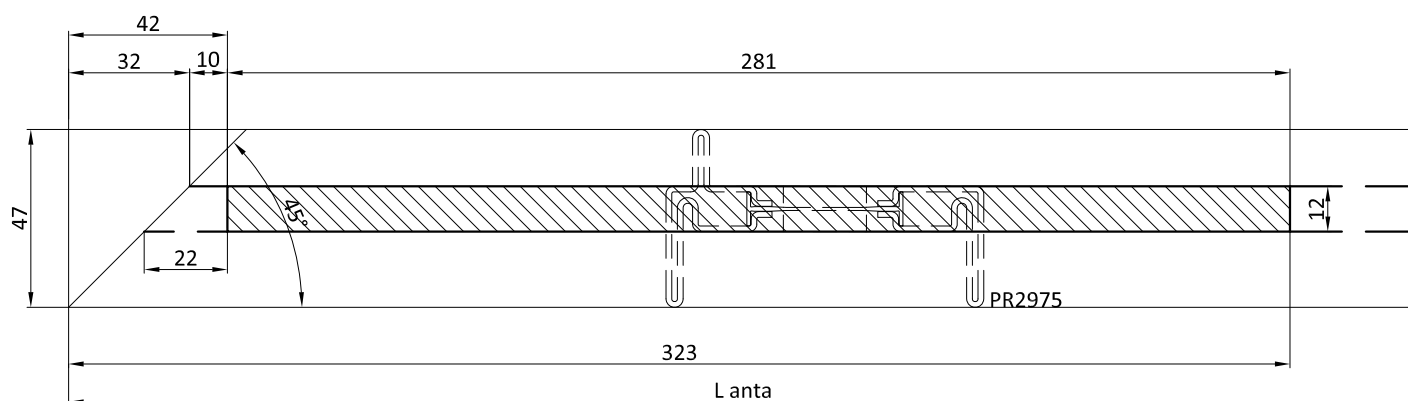
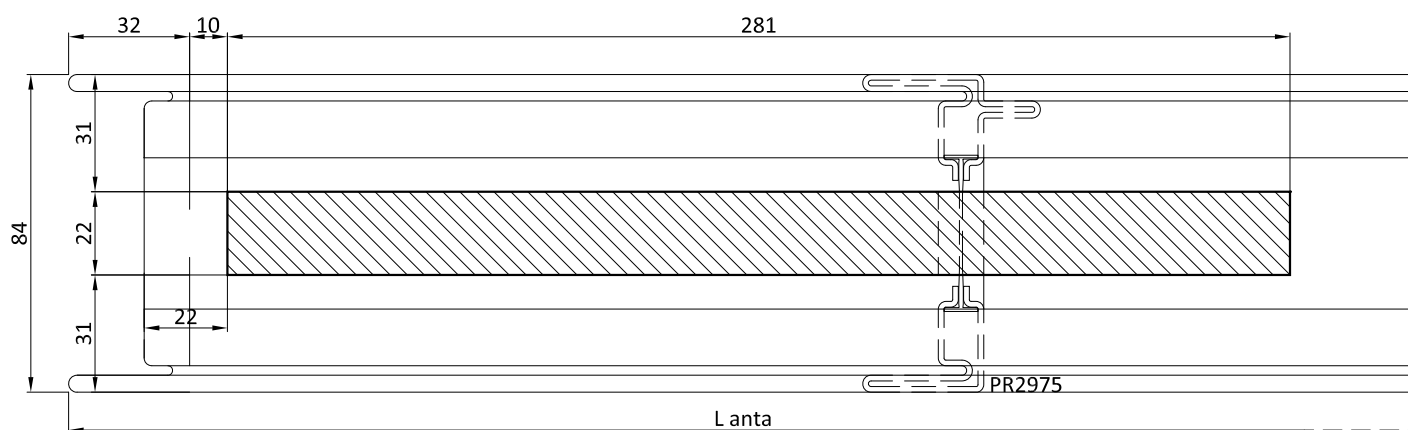
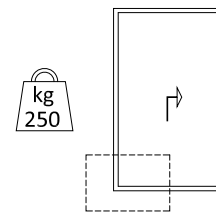
■ Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
■ Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)

Saldare a TIG con materiale di riporto nelle zone indicate con ++++++
TIG welding with filler material in the areas indicated with ++++++

Sigillare tutte le superfici di contatto esterne con silicone o SL0019
Seal all the external contact surfaces with silicone or SL0019

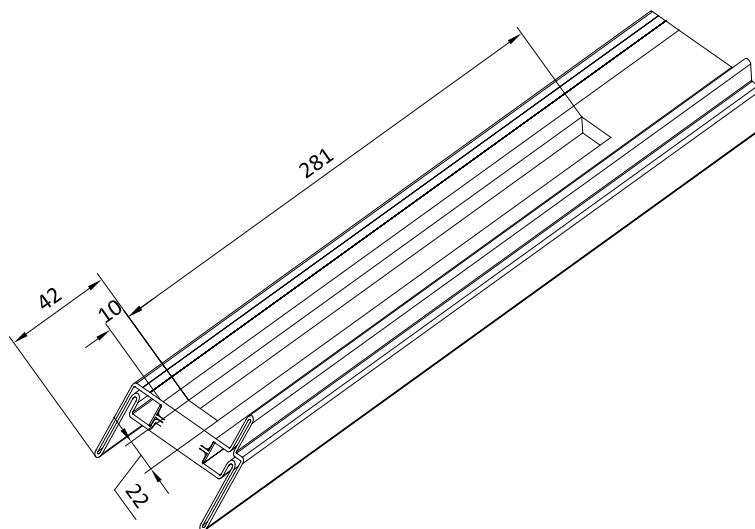


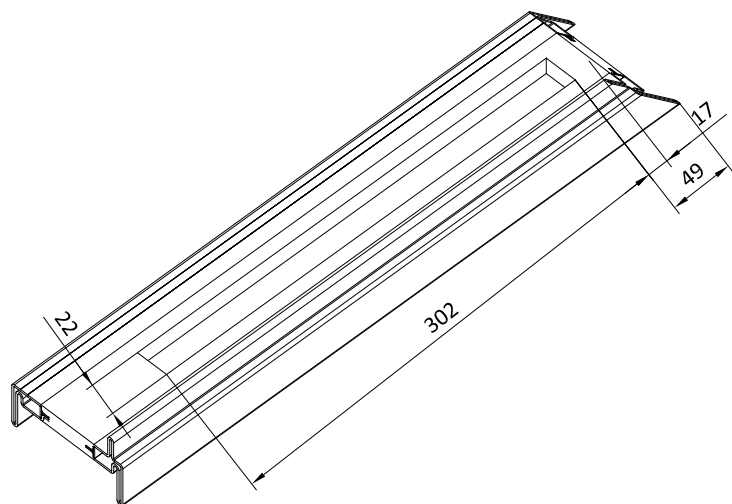
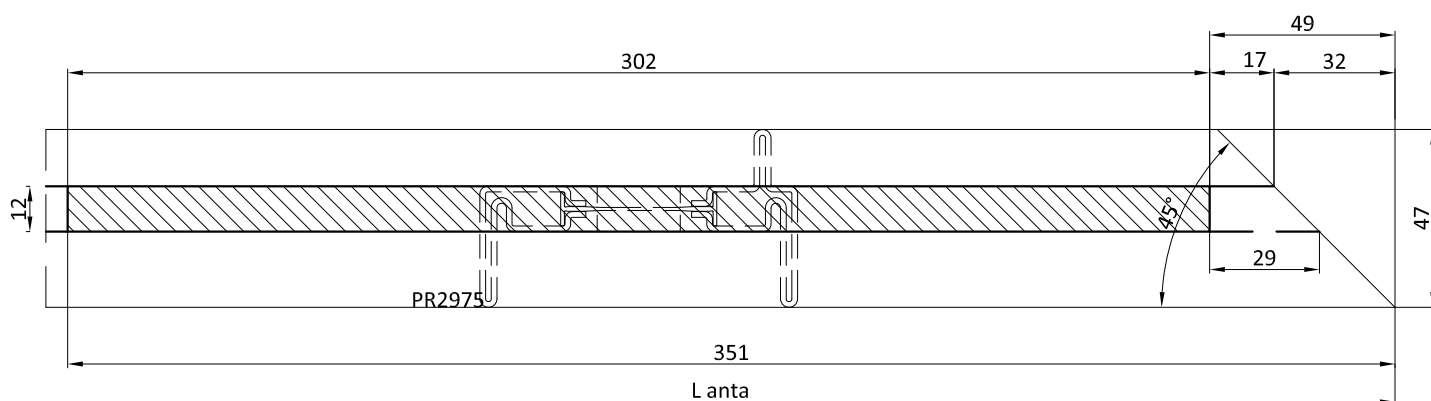
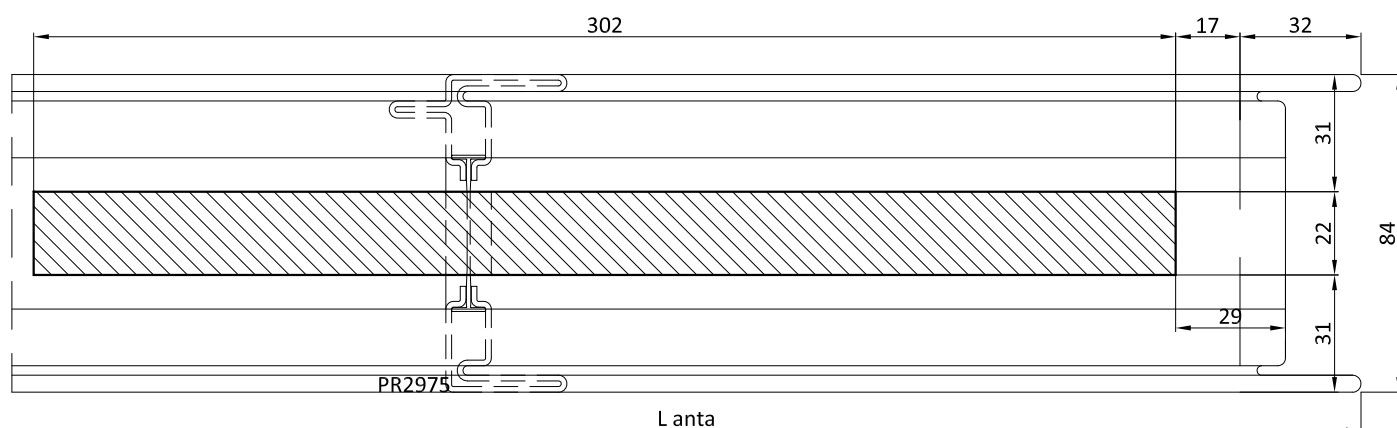
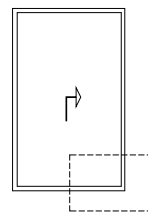




Tagliare a misura
il profilo PR2975
fresare come da disegno
il poliuretano
per l'alloggio carrelli

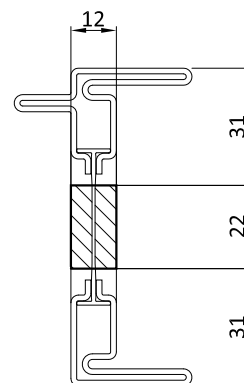
*Cutting to size
the profile PR2975 and tooling
the polyurethane for the trolley
installation as
drawing indication*

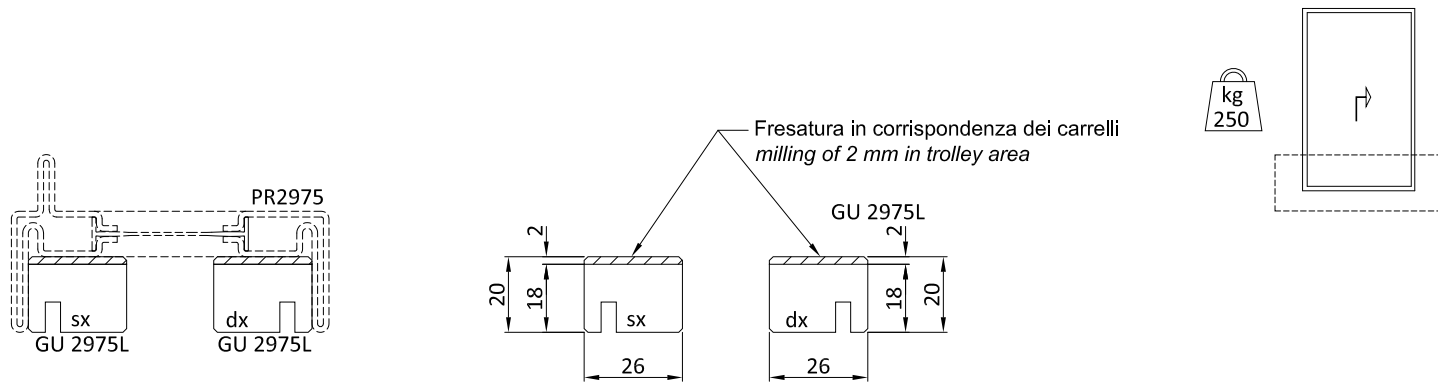




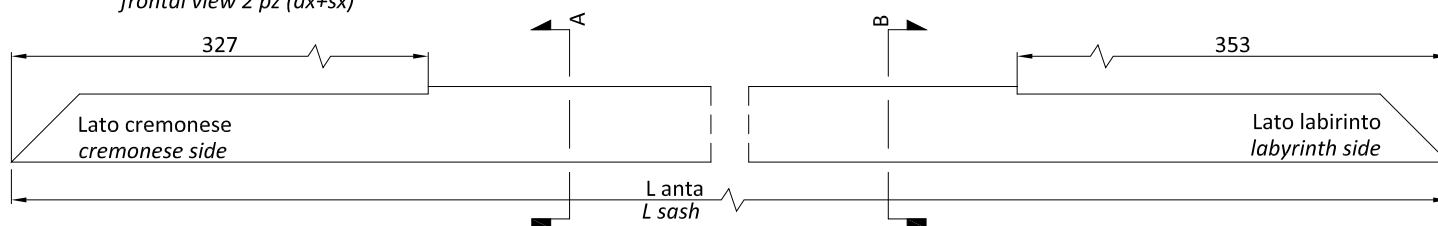
Tagliare a misura
il profilo PR2975
fresare come da disegno
il poliuretano
per l'alloggio carrelli

*Cutting to size
the profile PR2975 and tooling
the polyurethane for the trolley
installation as
drawing indication*

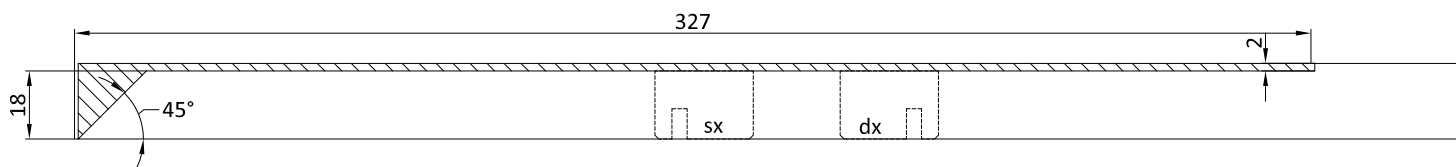
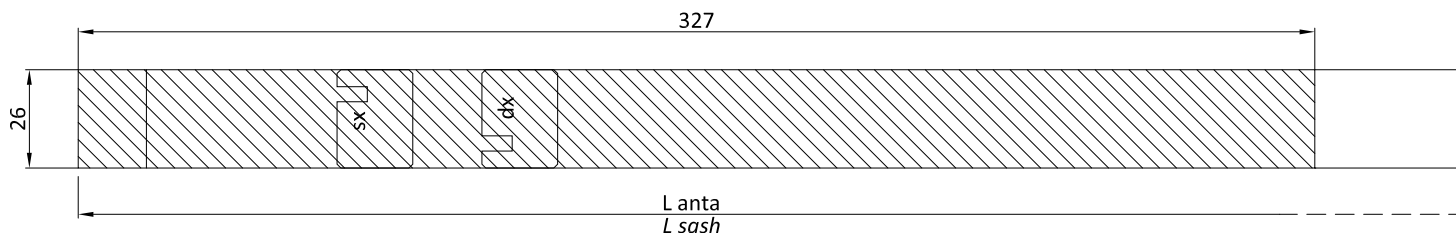




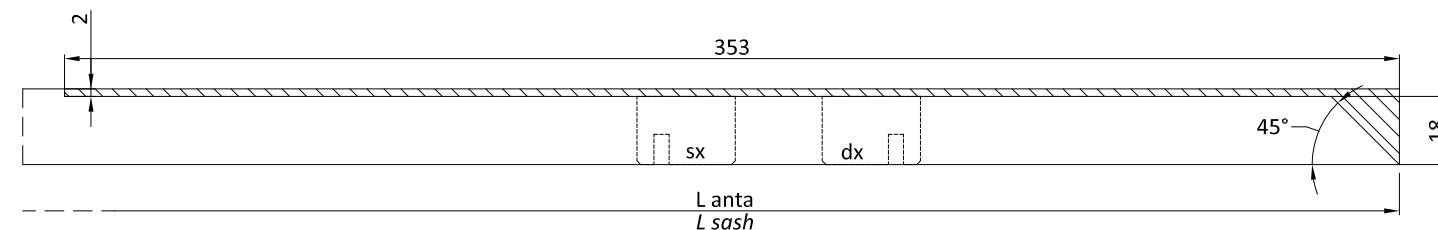
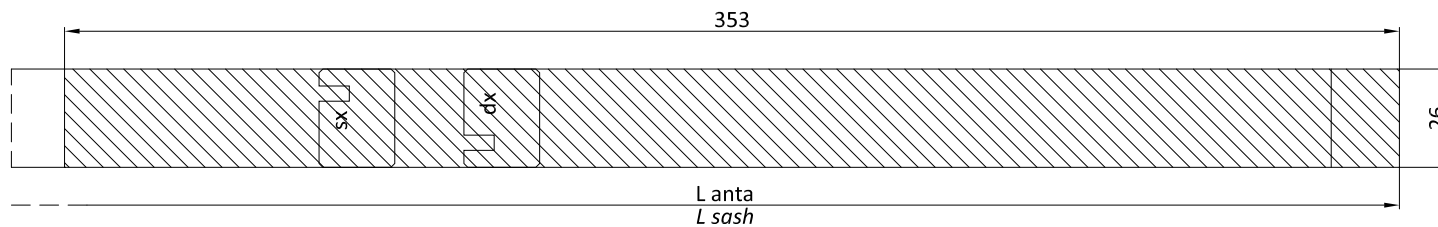
GU 2975L - Vista complessiva nr.2 pezzi (dx+sx)
frontal view 2 pz (dx+sx)

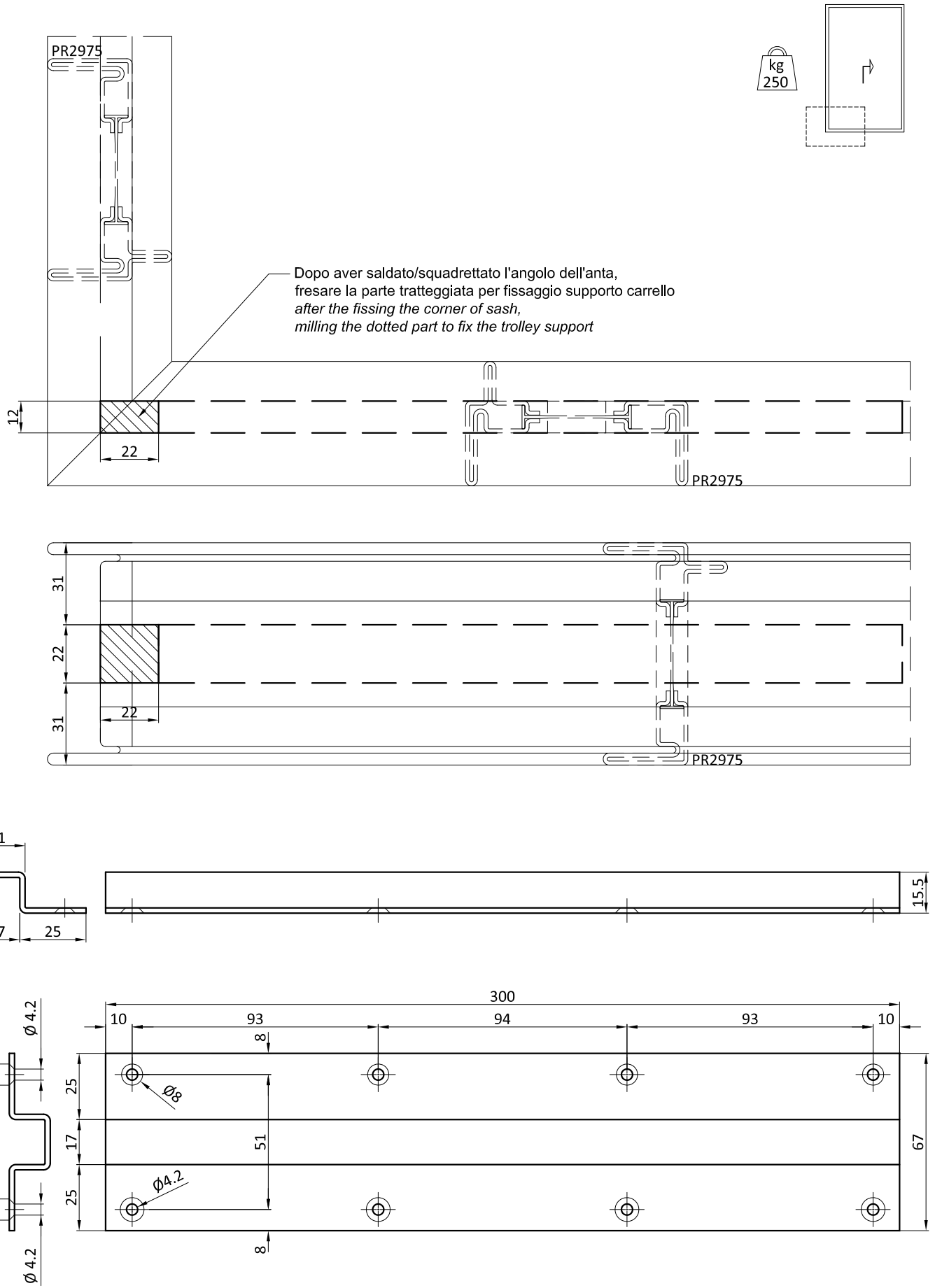


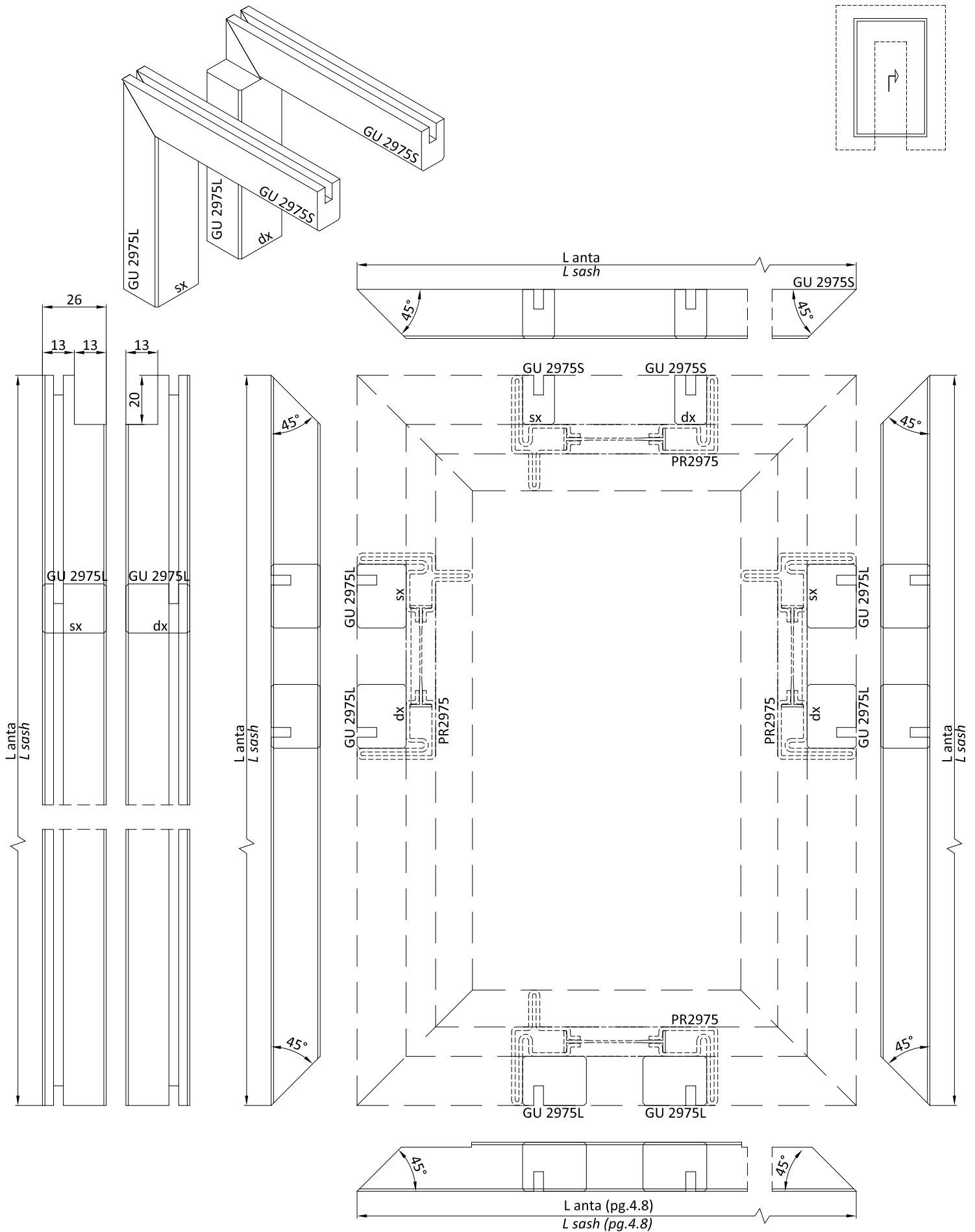
sezione A
section A



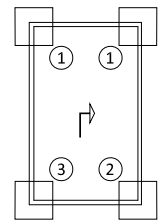
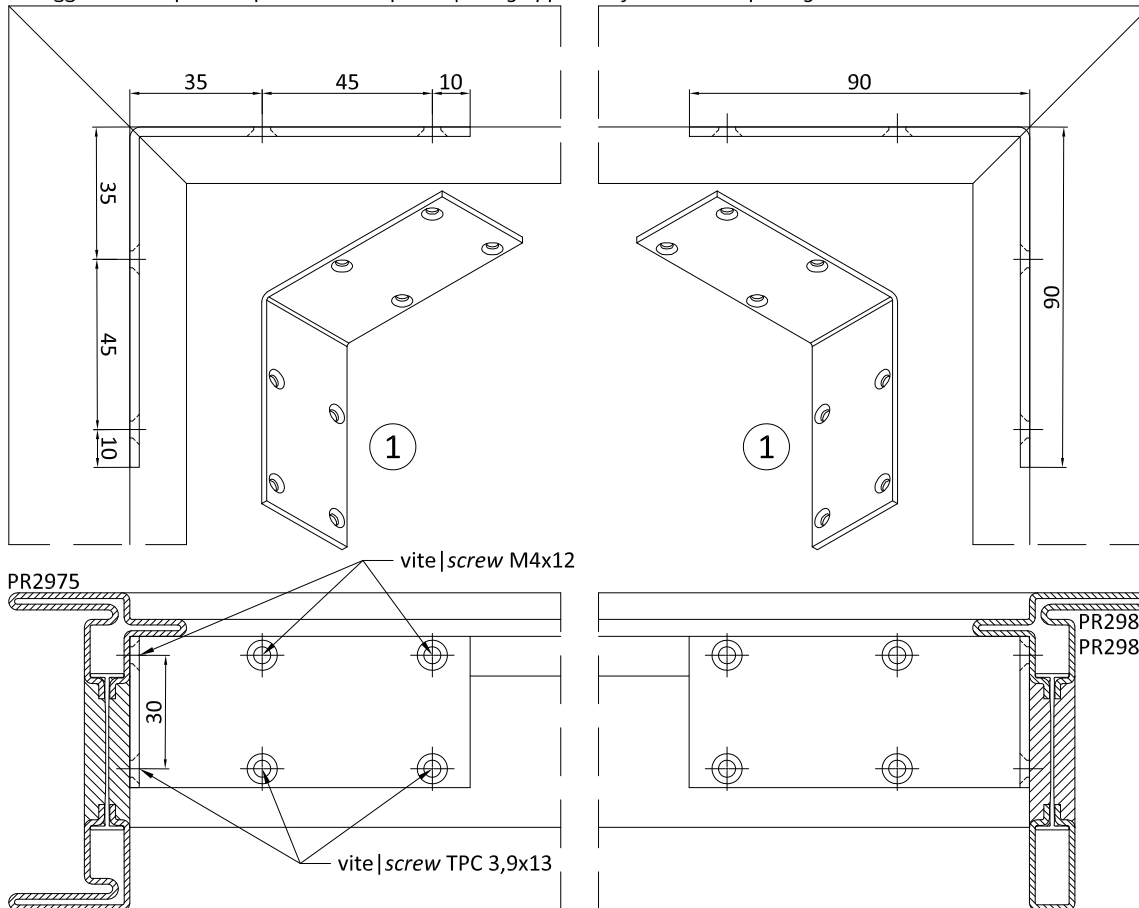
sezione B
section B







Fissaggio rinforzi parte superiore anta apribile | Fixing upper reinforcements opening sash



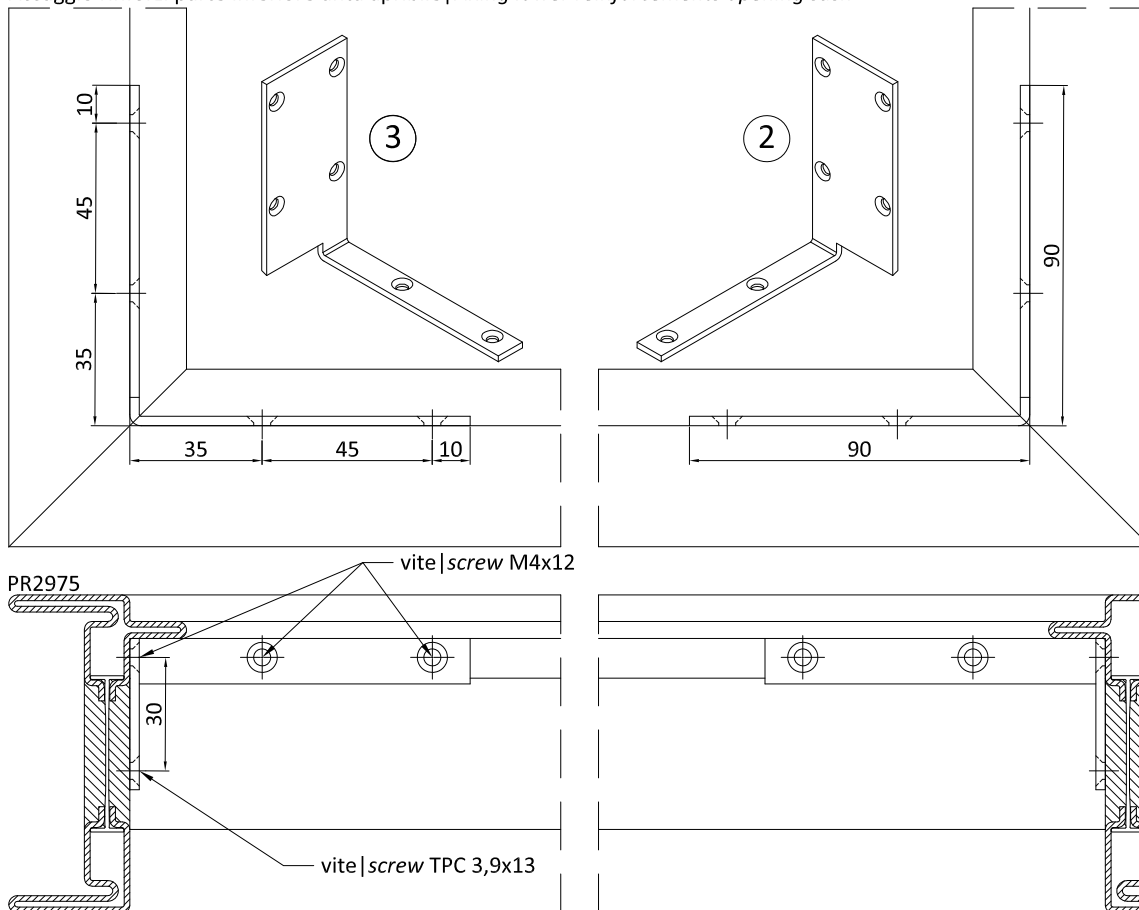
Installare i rinforzi dopo l'assemblaggio delle ante.

Rinforzo tipo 1 - 2 pezzi
Fissare gli angolari negli angoli interni dell'anta sulla parte superiore

Rinforzo tipo 2 - 1 pezzo
Fissare l'angolare nell'angolo interno destro dell'anta sulla parte inferiore

Rinforzo tipo 3 - 1 pezzo
Fissare l'angolare nell'angolo interno sinistro dell'anta sulla parte inferiore

Fissaggio rinforzi parte inferiore anta apribile | Fixing lower reinforcements opening sash



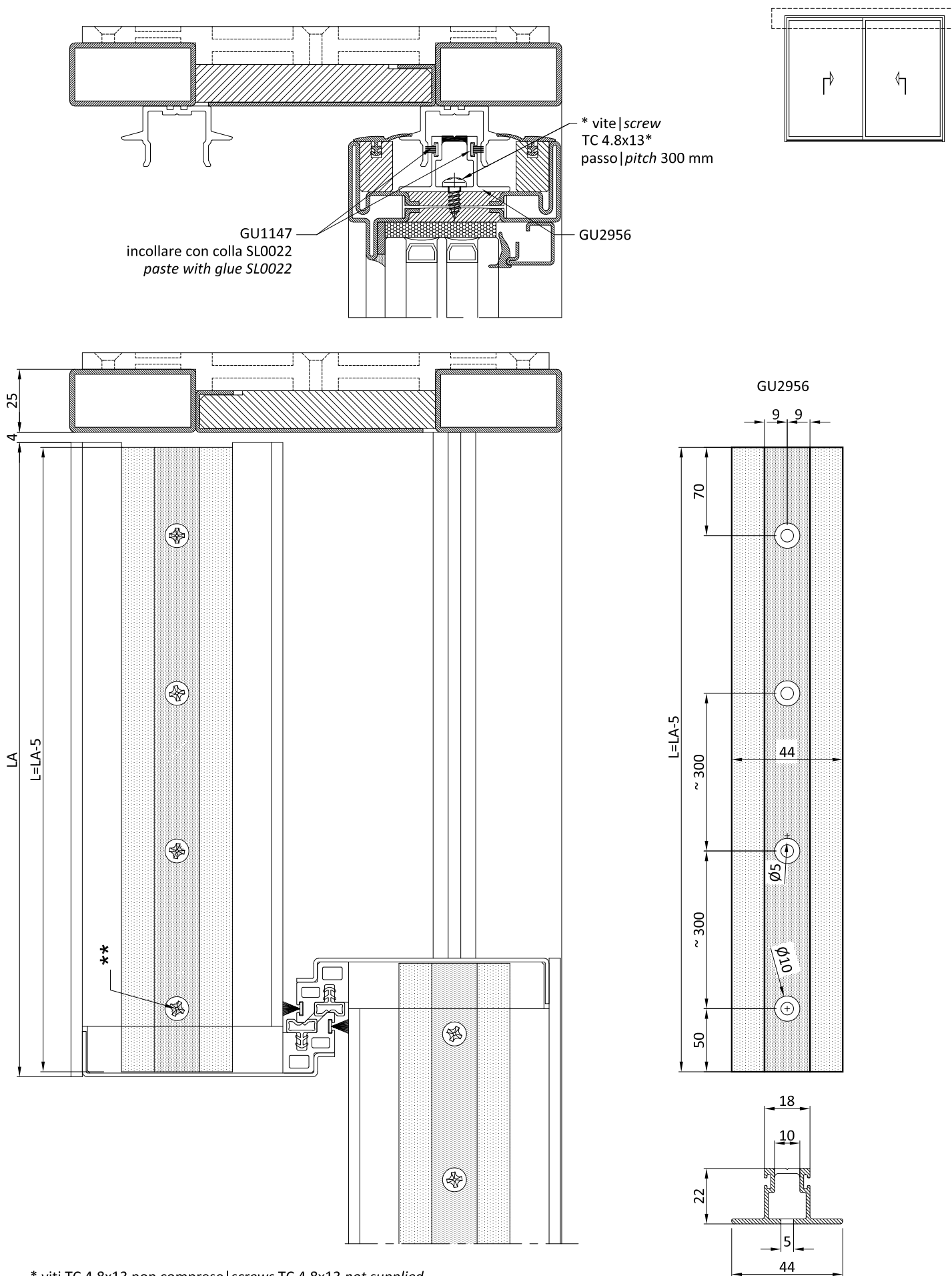
To install reinforcement after the assembly of the sashes.

Reinforcement type 1 - 2 pieces
Fix the corner pieces in the inner corners of the sash on the top

Reinforcement type 2 - 1 piece
Fix the angle in the inner right corner of the sash on the lower part.

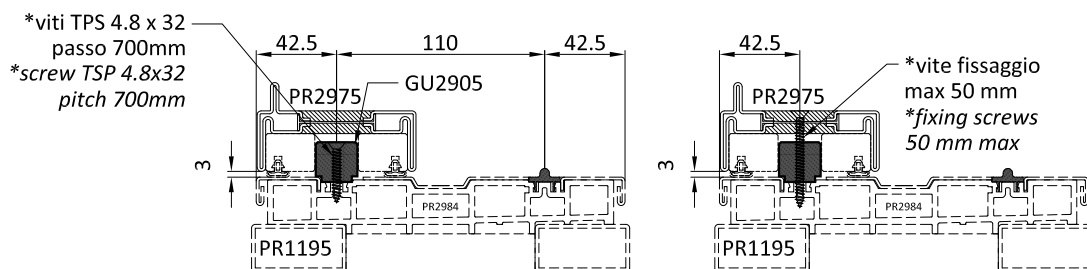
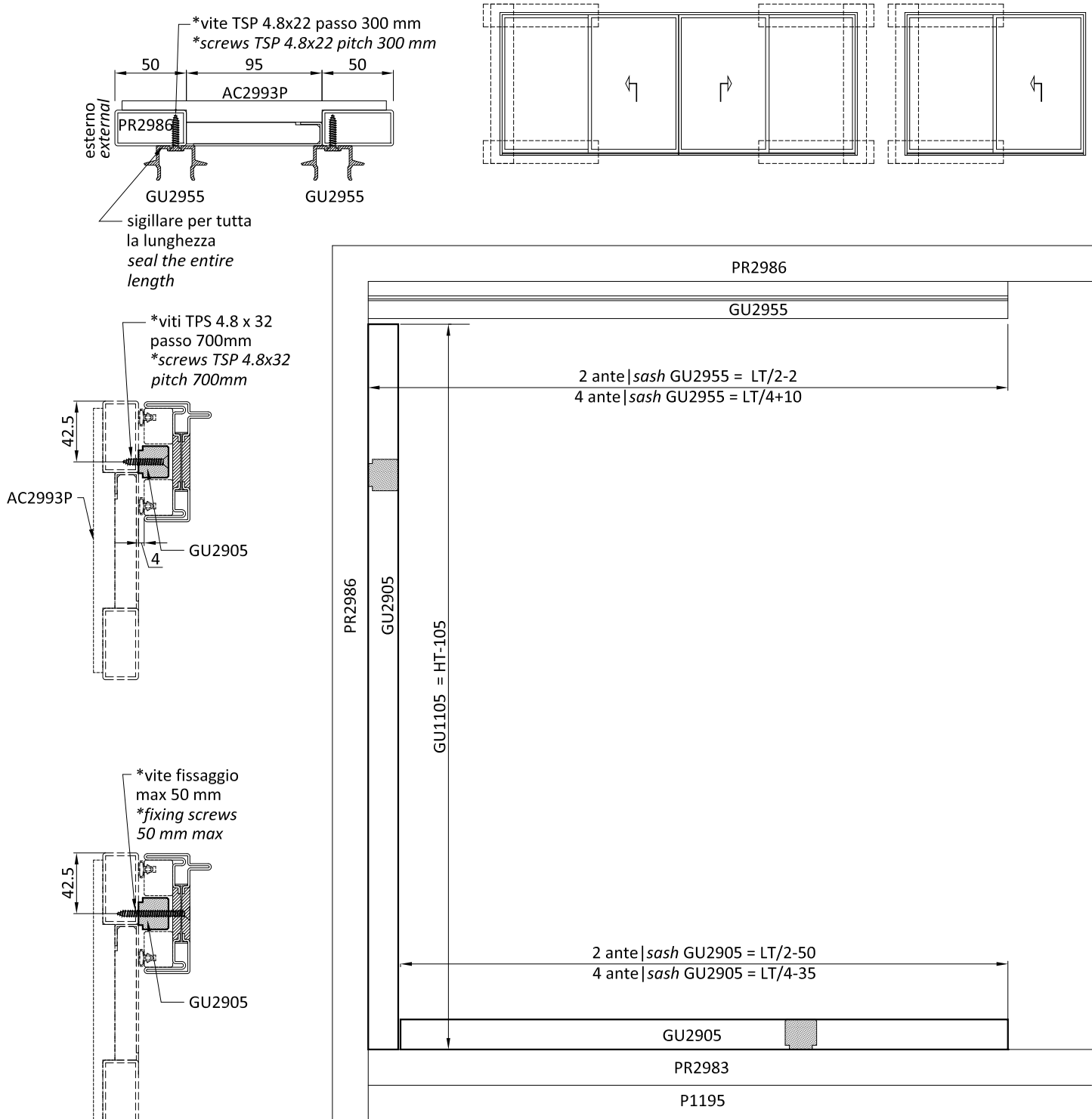
Reinforcement type 2 - 1 piece
Fix the angle in the inner left corner of the sash on the lower part

PR2989
PR2988 * viti non comprese
* screws not supplied

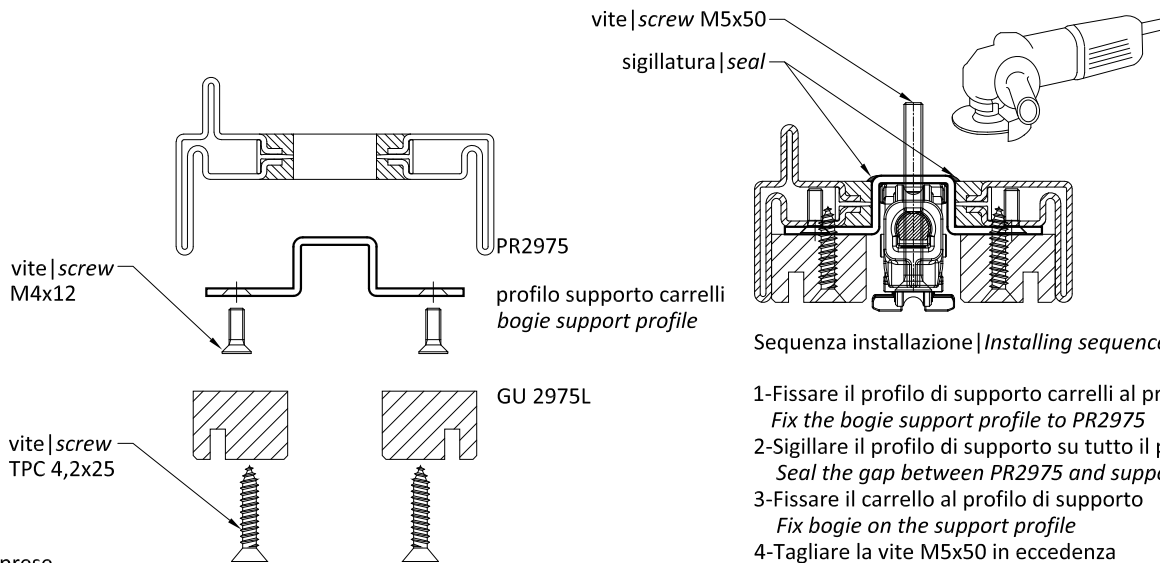
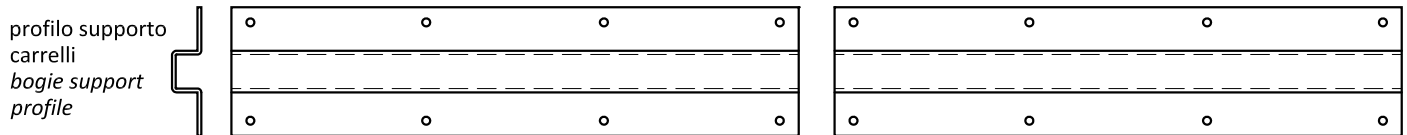
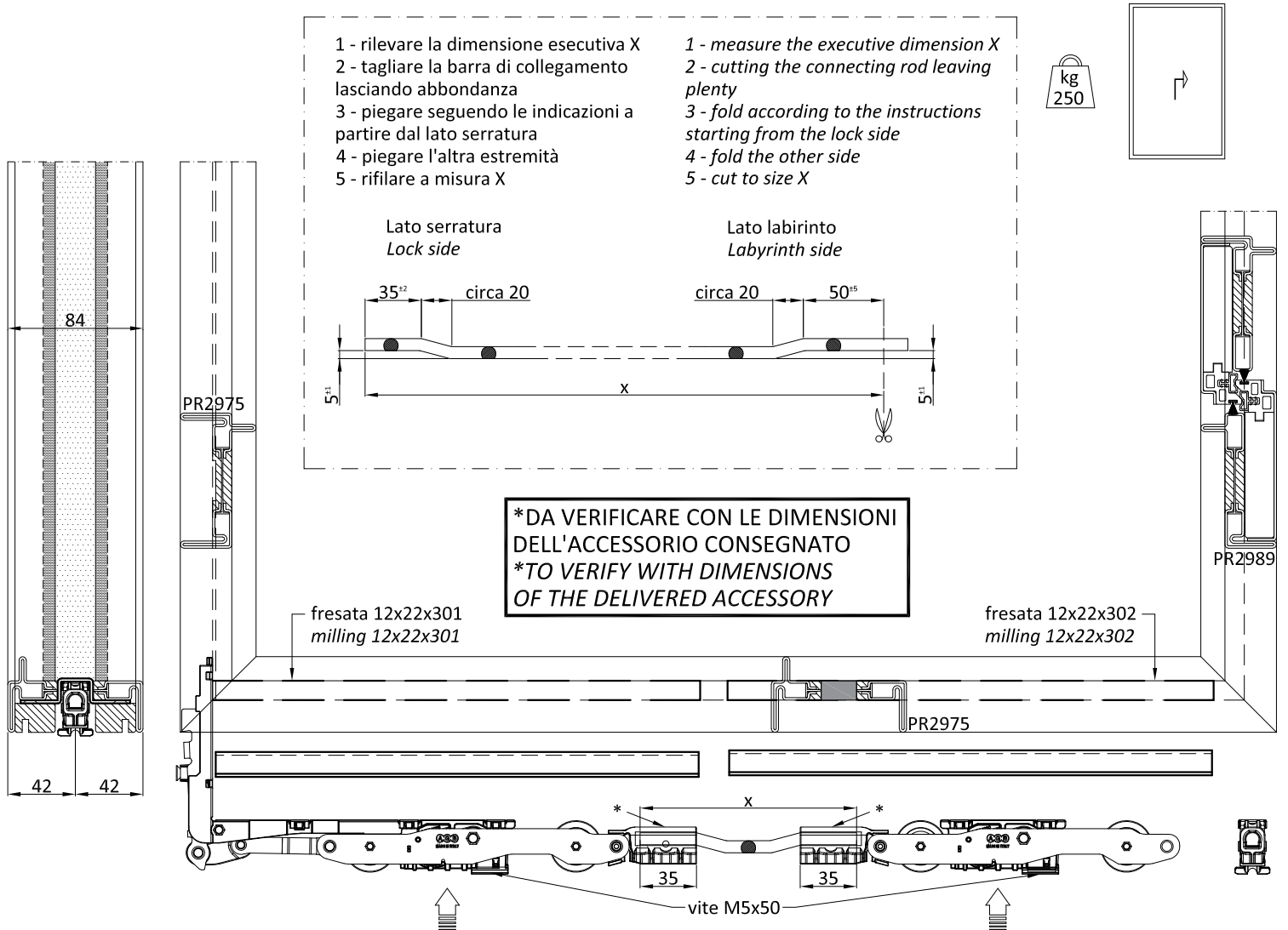


* viti TC 4.8x13 non comprese | screws TC 4.8x13 not supplied





*viti non comprese
 *screws not supplied

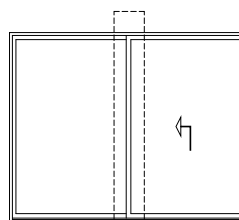
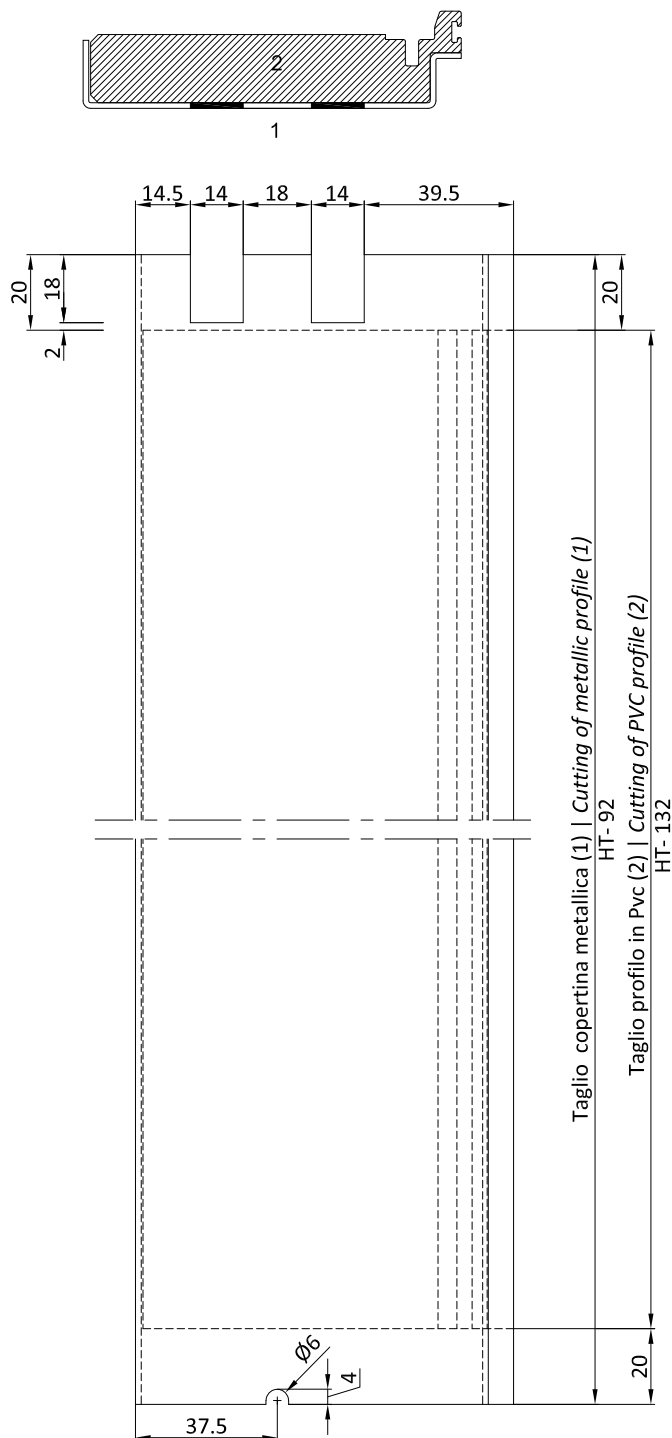


- Sequenza installazione | Installing sequence:
- 1-Fissare il profilo di supporto carrelli al profilo PR2975
Fix the bogie support profile to PR2975
 - 2-Sigillare il profilo di supporto su tutto il perimetro
Seal the gap between PR2975 and support profile
 - 3-Fissare il carrello al profilo di supporto
Fix bogie on the support profile
 - 4-Tagliare la vite M5x50 in eccedenza
Cut screw M5x50 over the profile

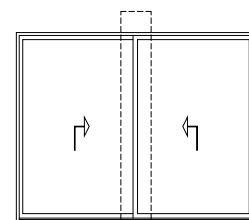
* viti non comprese
* screws not supplied

1) Profilo metallico | *Metallic profile*

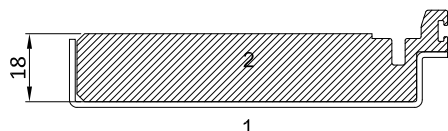
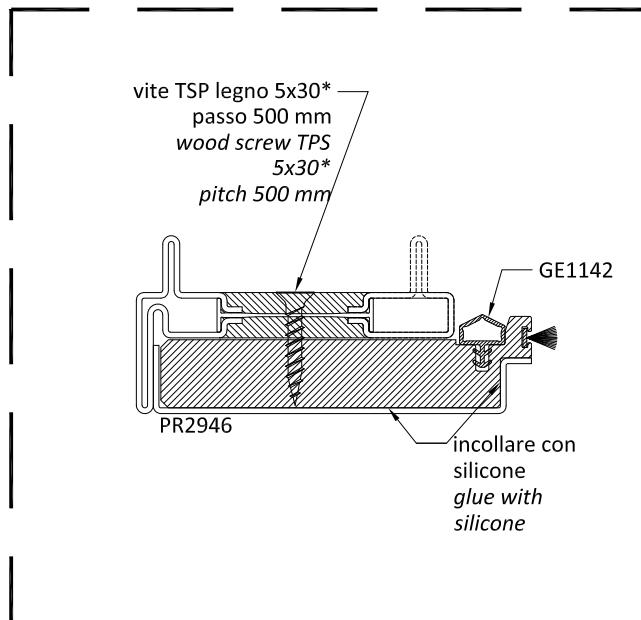
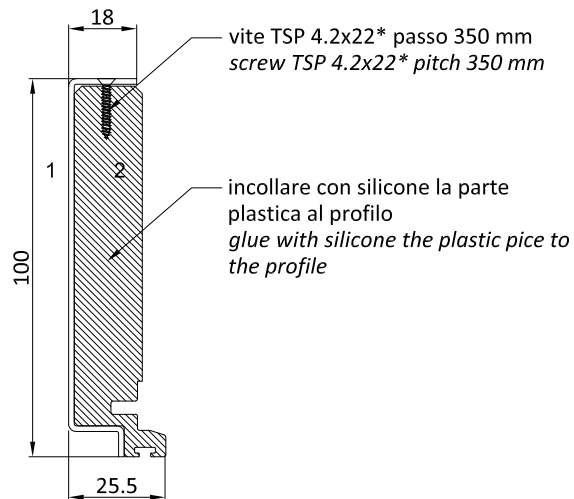
2) Estruso in PVC rigido | *Extruded PVC profile*



Schema | Type A

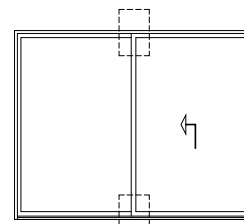
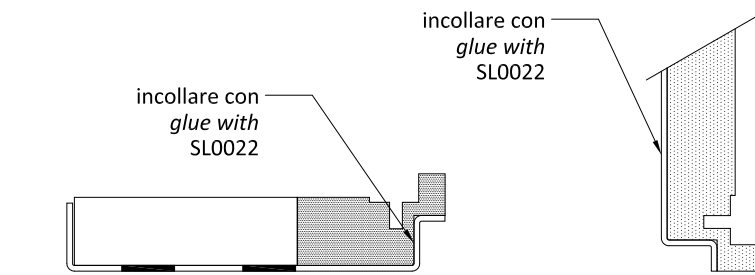


Schema | Type B

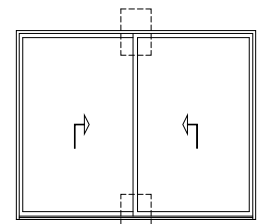


* viti TPS 4.2 x 22 e TC legno 6x35 non comprese

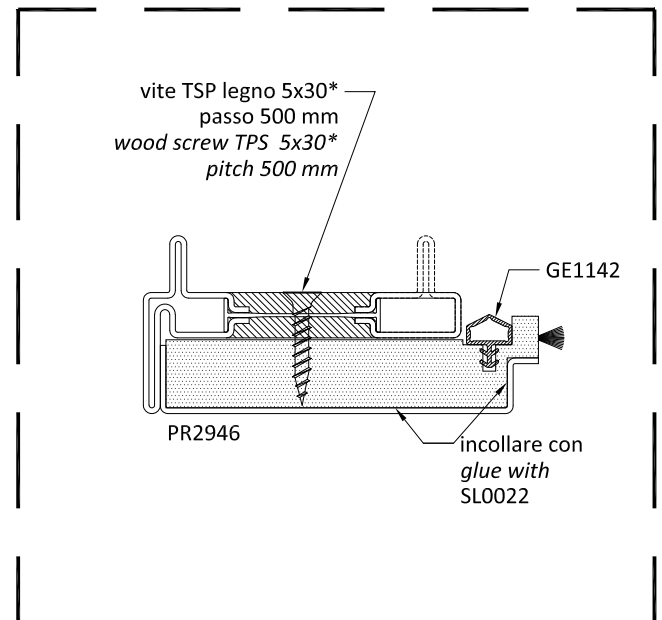
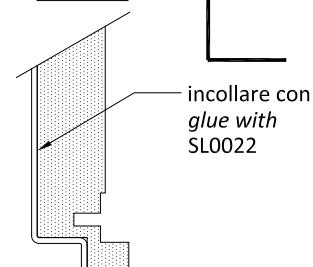
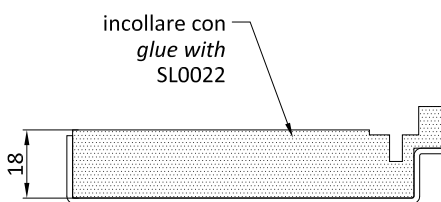
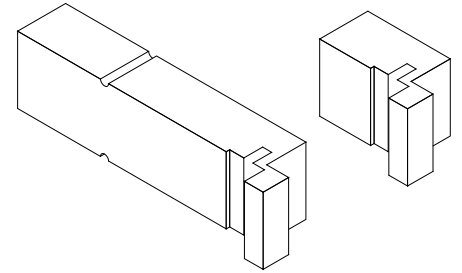
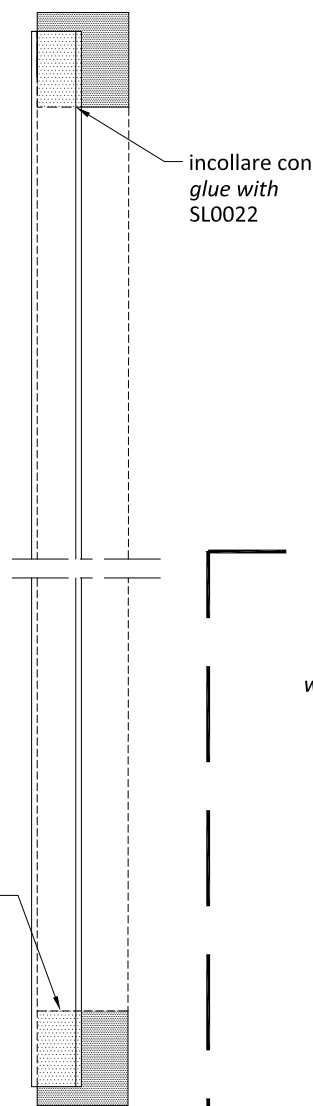
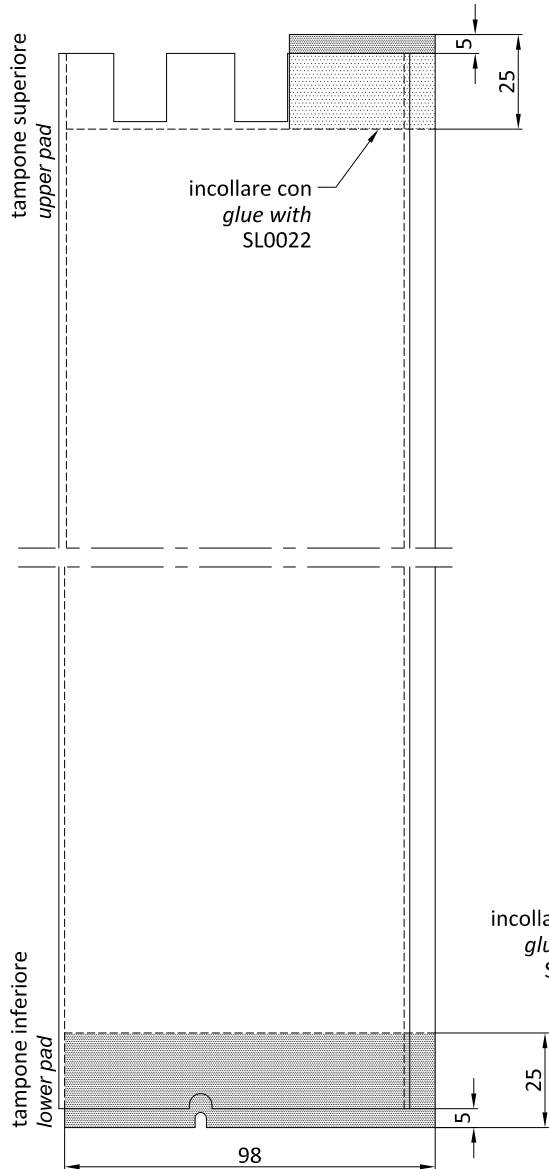
* TPS 4.2 screws x 22 and wood screws TC 6x35 not supplied



Schema | Type A

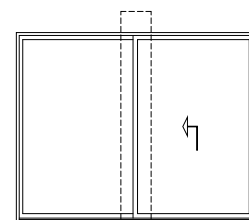


Schema | Type B

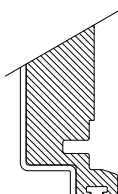
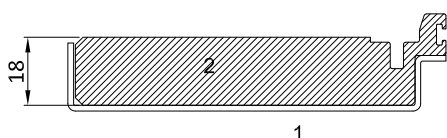
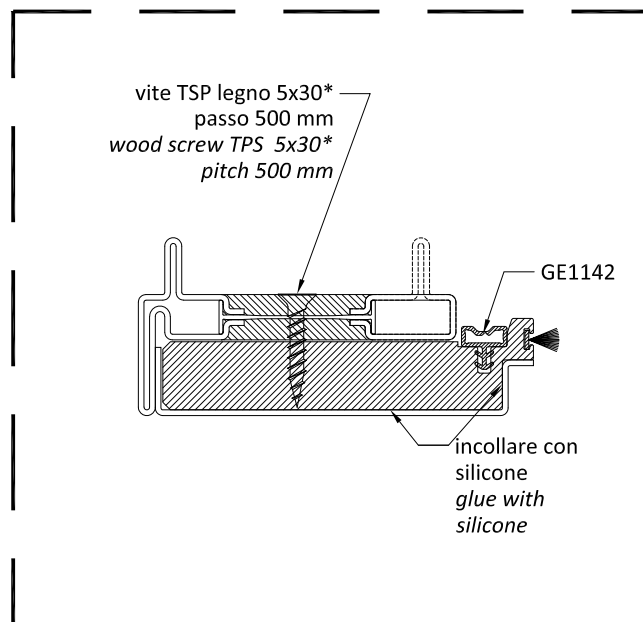
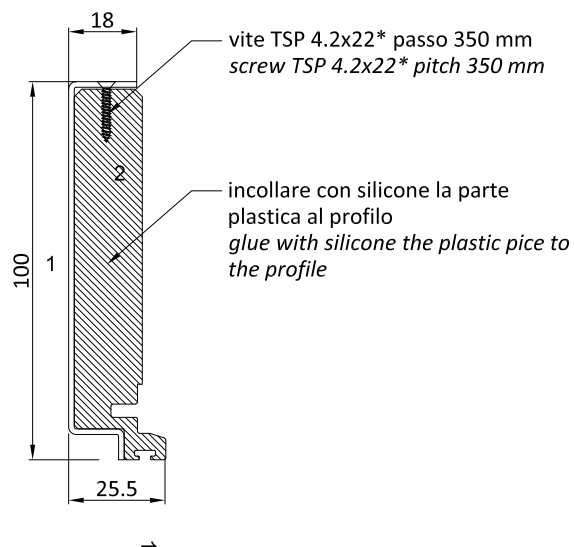
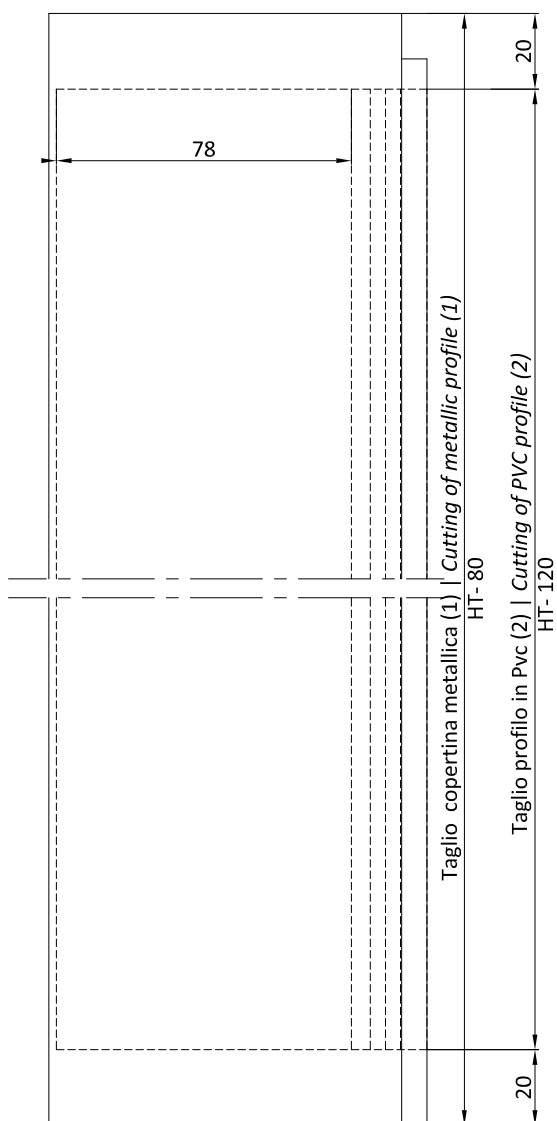
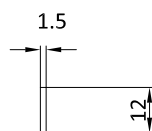
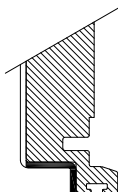
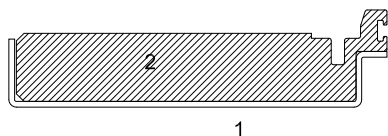


1) Profilo metallico | *Metallic profile*

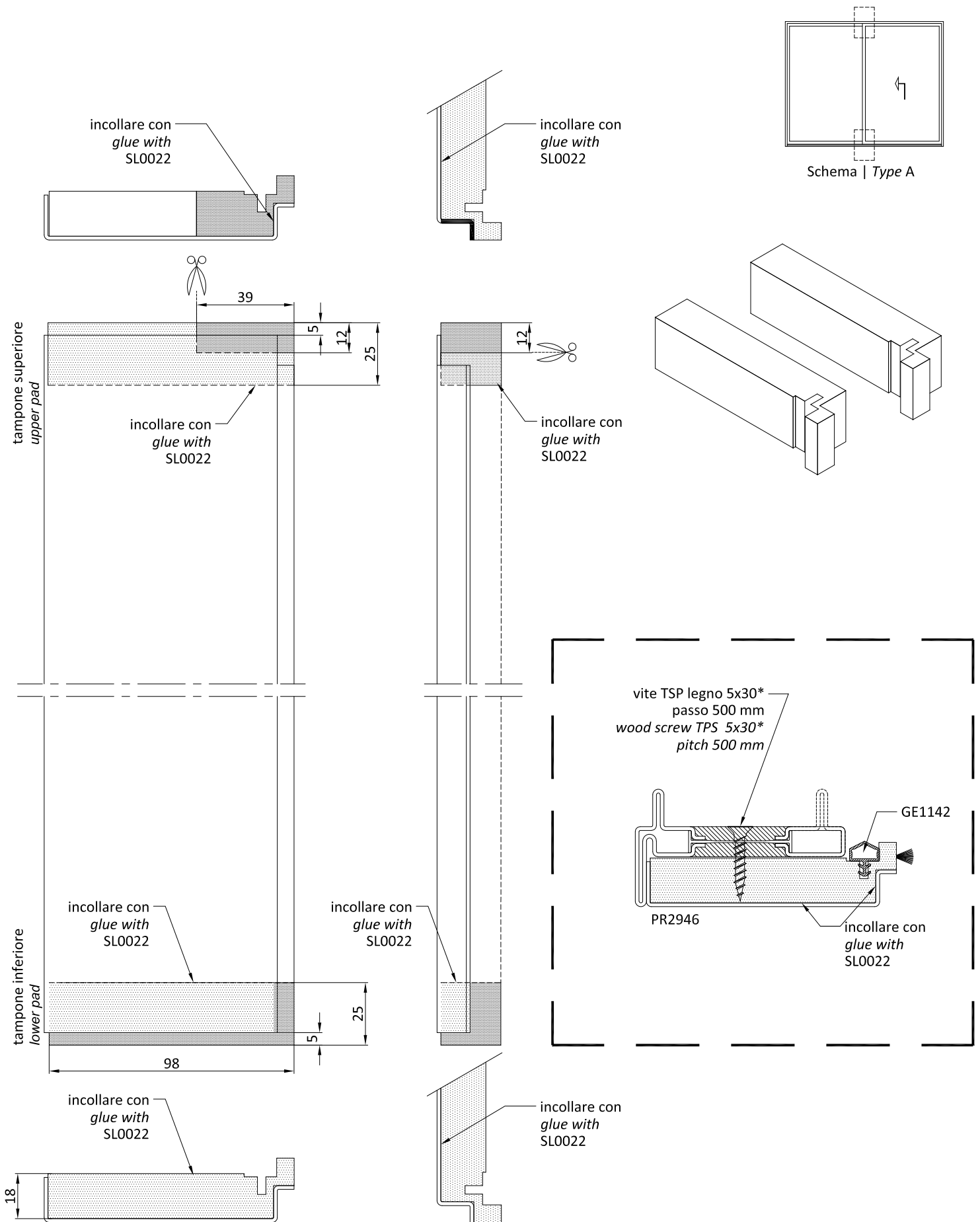
2) Estruso in PVC rigido | *Extruded PVC profile*



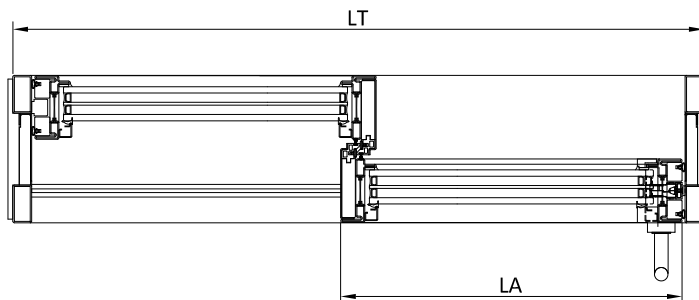
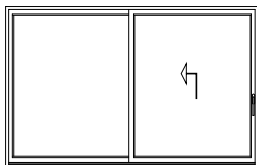
Schema | Type A



* viti TPS 4.2 x 22 e TC legno 6x35 non comprese
* TPS 4.2 screws x 22 and wood screws TC 6x35 not supplied



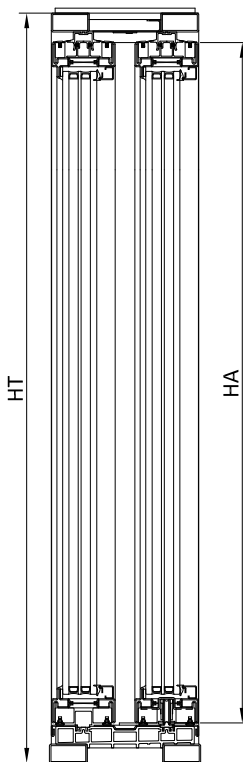
Schema | Type A



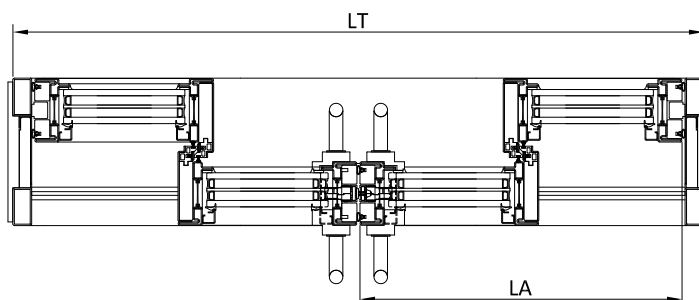
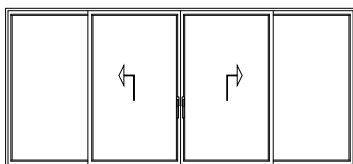
Dimensione anta (A)
Sash dimension (A)

$$LA = LT/2 - 6$$

$$HA = HT - 92$$



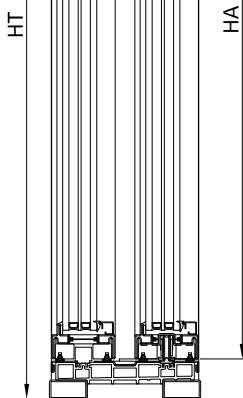
Schema | Type E



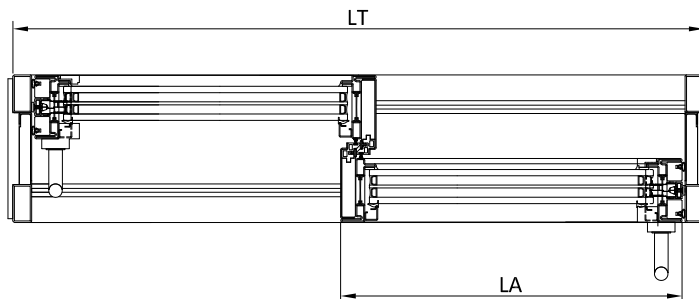
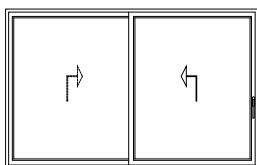
Dimensione anta (A)
Sash dimension (A)

$$LA = LT/4 + 8$$

$$HA = HT - 92$$



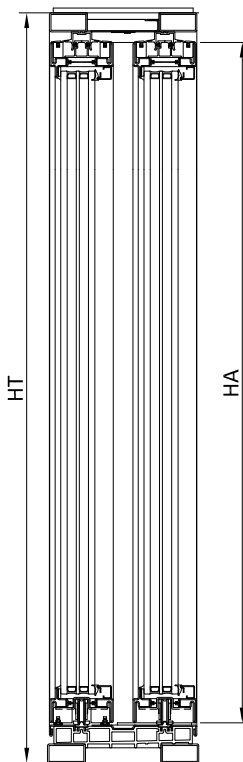
Schema | Type B



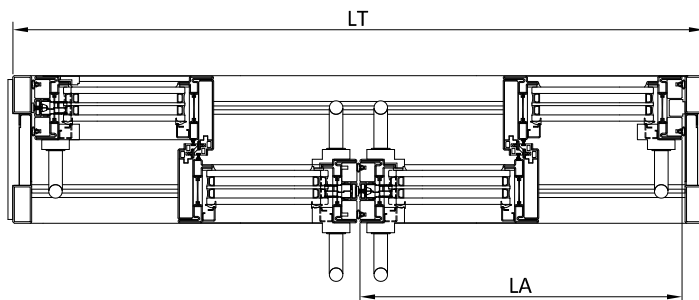
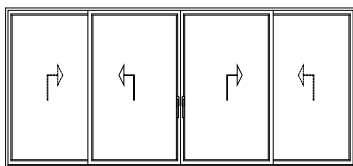
Dimensione anta (A)
Sash dimension (A)

$$LA = LT/2 - 6$$

$$HA = HT - 92$$



Schema | Type F

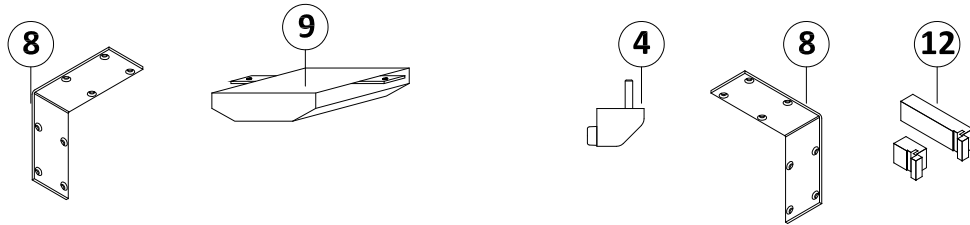
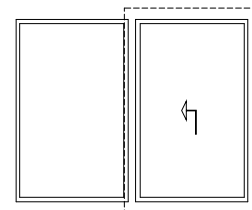


Dimensione anta (A)
Sash dimension (A)

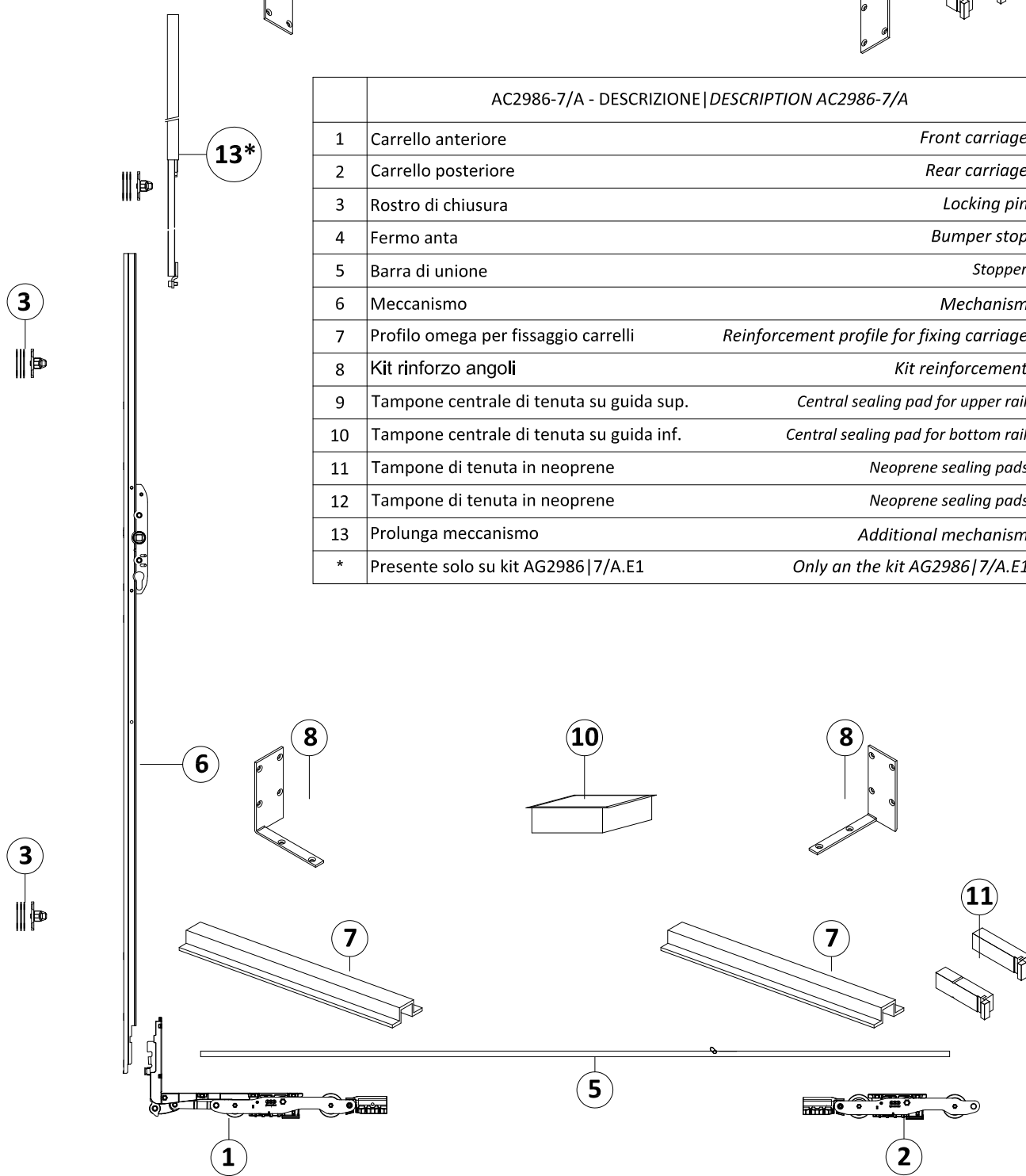
$$LA = LT/4 + 8$$

$$HA = HT - 92$$

Schema | Type A

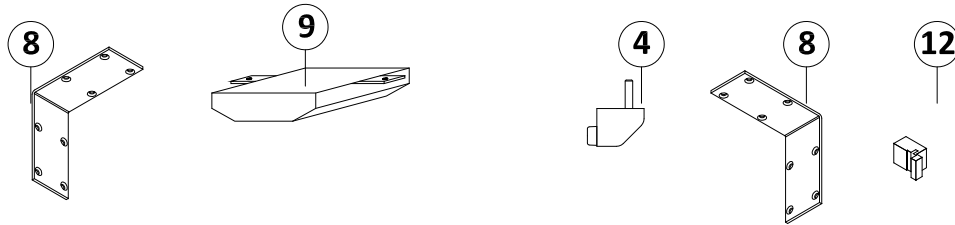
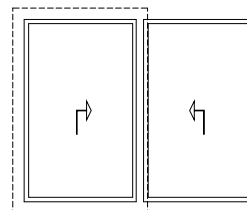


AC2986-7/A - DESCRIZIONE DESCRIPTION AC2986-7/A		
1	Carrello anteriore	Front carriage
2	Carrello posteriore	Rear carriage
3	Rostro di chiusura	Locking pin
4	Fermo anta	Bumper stop
5	Barra di unione	Stopper
6	Meccanismo	Mechanism
7	Profilo omega per fissaggio carrelli	Reinforcement profile for fixing carriage
8	Kit rinforzo angoli	Kit reinforcement
9	Tampone centrale di tenuta su guida sup.	Central sealing pad for upper rail
10	Tampone centrale di tenuta su guida inf.	Central sealing pad for bottom rail
11	Tampone di tenuta in neoprene	Neoprene sealing pads
12	Tampone di tenuta in neoprene	Neoprene sealing pads
13	Prolunga meccanismo	Additional mechanism
*	Presente solo su kit AG2986 7/A.E1	Only on the kit AG2986 7/A.E1

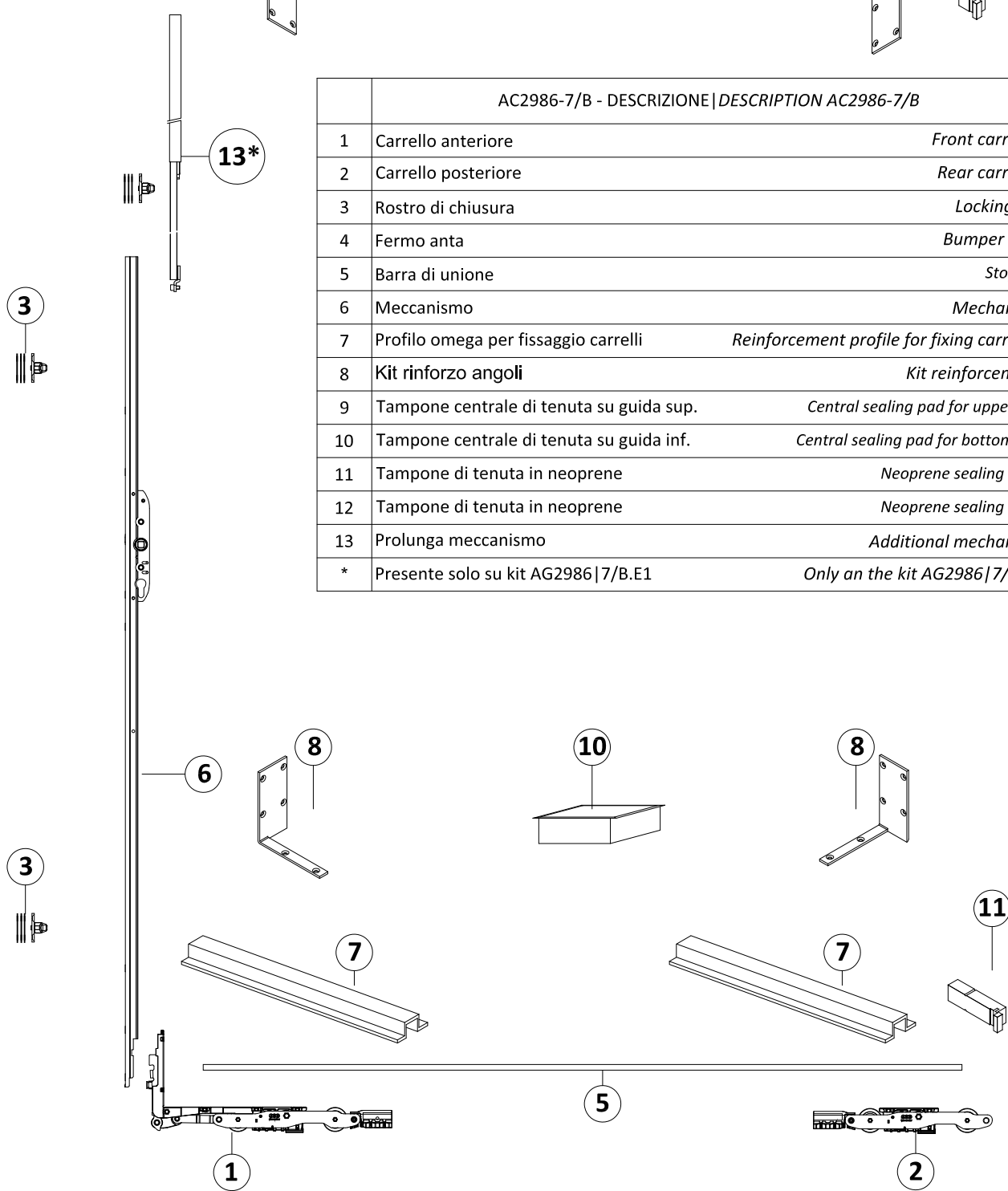


Schema | Type B

kg
250

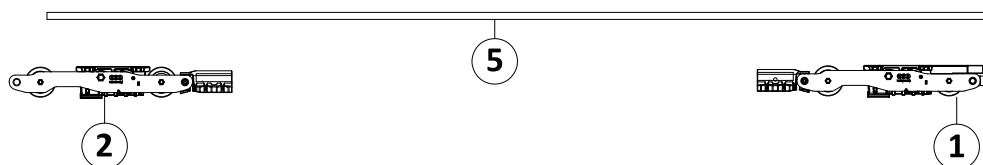
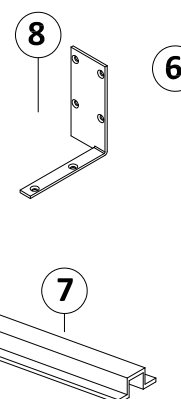
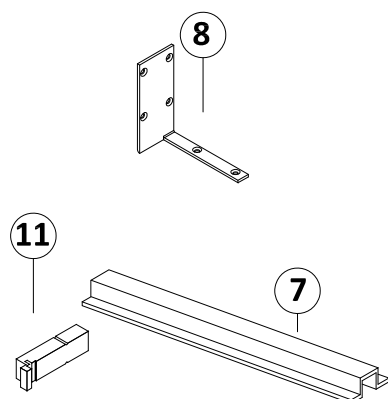
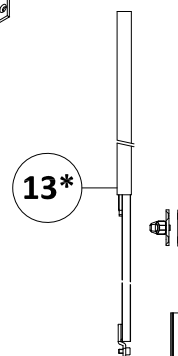
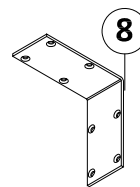
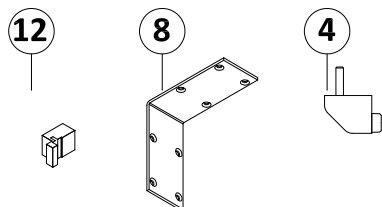
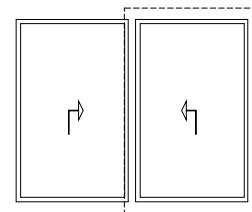


AC2986-7/B - DESCRIZIONE DESCRIPTION AC2986-7/B		
1	Carrello anteriore	Front carriage
2	Carrello posteriore	Rear carriage
3	Rostro di chiusura	Locking pin
4	Fermo anta	Bumper stop
5	Barra di unione	Stopper
6	Meccanismo	Mechanism
7	Profilo omega per fissaggio carrelli	Reinforcement profile for fixing carriage
8	Kit rinforzo angoli	Kit reinforcement
9	Tampone centrale di tenuta su guida sup.	Central sealing pad for upper rail
10	Tampone centrale di tenuta su guida inf.	Central sealing pad for bottom rail
11	Tampone di tenuta in neoprene	Neoprene sealing pads
12	Tampone di tenuta in neoprene	Neoprene sealing pads
13	Prolunga meccanismo	Additional mechanism
*	Presente solo su kit AG2986 7/B.E1	Only on the kit AG2986 7/B.E1

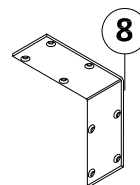
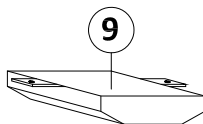
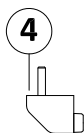
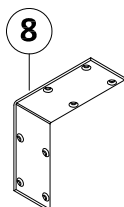
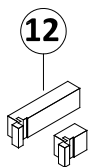
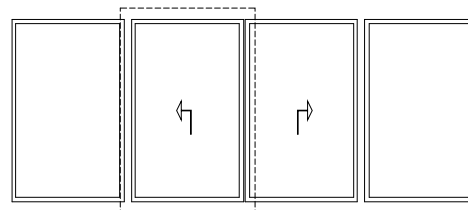


Schema | Type B

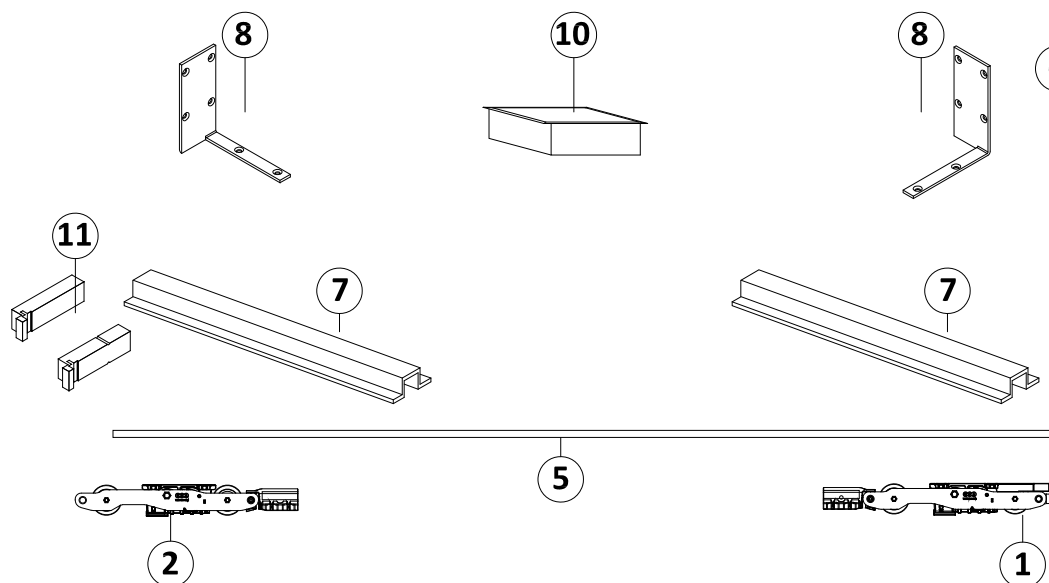
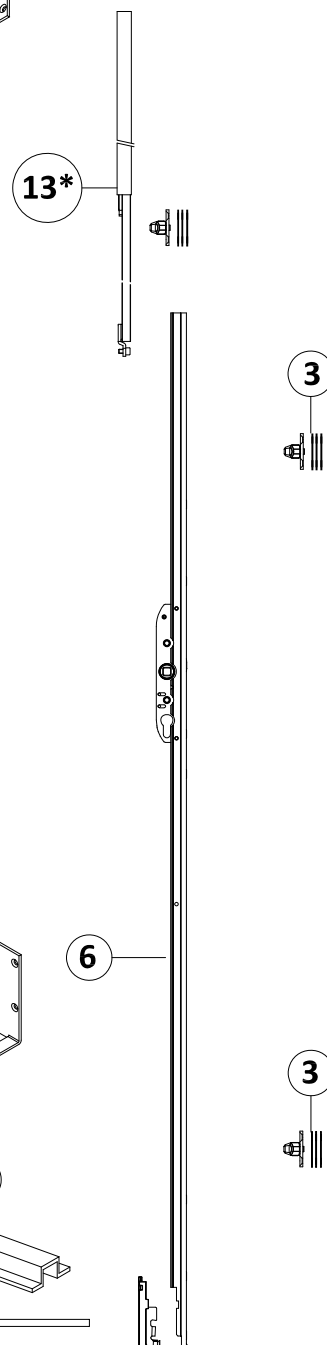
kg
250



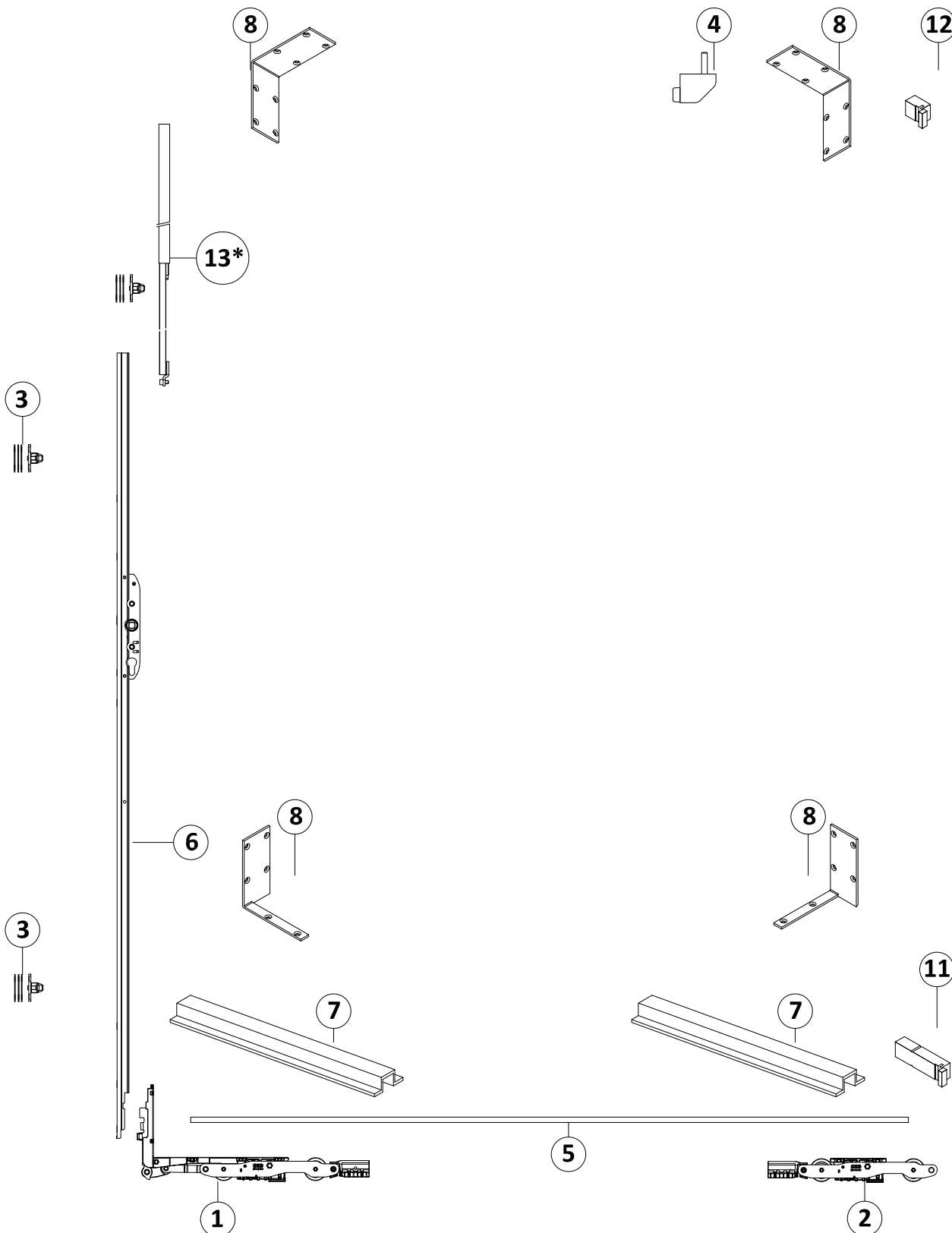
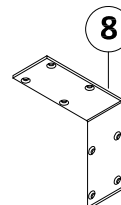
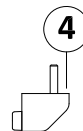
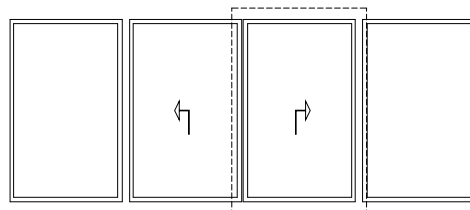
Schema | Type E



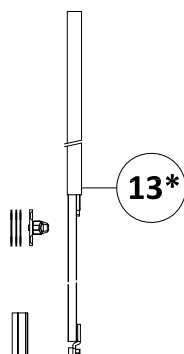
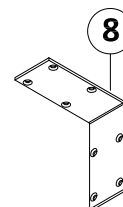
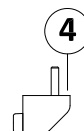
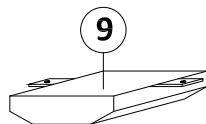
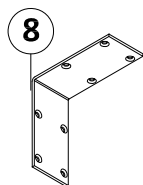
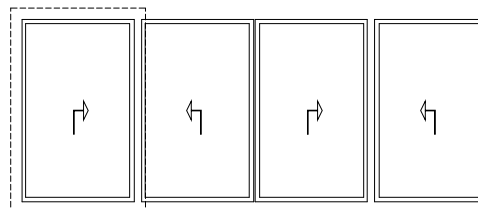
	AC2986-7/E - DESCRIZIONE DESCRIPTION AC2986-7/E
1	Carrello anteriore <i>Front carriage</i>
2	Carrello posteriore <i>Rear carriage</i>
3	Rostro di chiusura <i>Locking pin</i>
4	Fermo anta <i>Bumper stop</i>
5	Barra di unione <i>Stopper</i>
6	Meccanismo <i>Mechanism</i>
7	Profilo omega per fissaggio carrelli <i>Reinforcement profile for fixing carriage</i>
8	Kit rinforzo angoli <i>Kit reinforcement</i>
9	Tampone centrale di tenuta su guida sup. <i>Central sealing pad for upper rail</i>
10	Tampone centrale di tenuta su guida inf. <i>Central sealing pad for bottom rail</i>
11	Tampone di tenuta in neoprene <i>Neoprene sealing pads</i>
12	Tampone di tenuta in neoprene <i>Neoprene sealing pads</i>
13	Prolunga meccanismo <i>Additional mechanism</i>
*	Presente solo su kit AG2986 7/E.E1 <i>Only on the kit AG2986 7/E.E1</i>



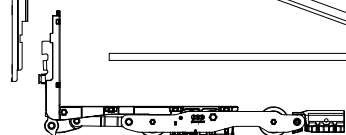
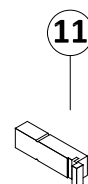
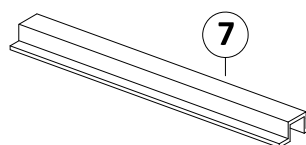
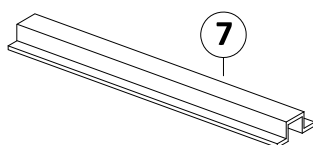
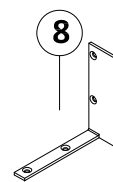
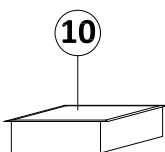
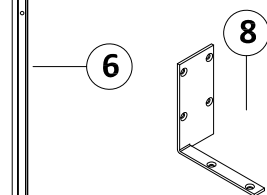
Schema | Type E



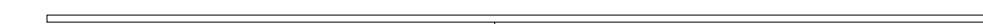
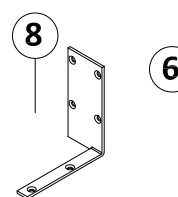
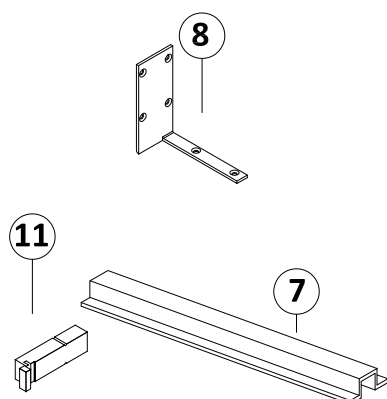
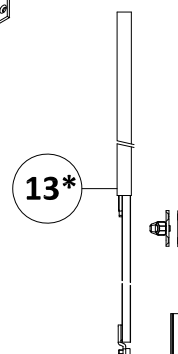
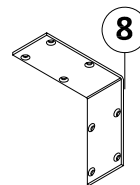
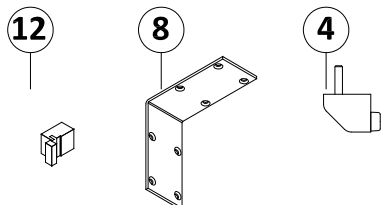
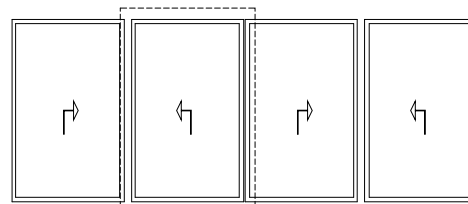
Schema | Type F



AC2986-7/F - DESCRIZIONE DESCRIPTION AC2986-7/F		
1	Carrello anteriore	Front carriage
2	Carrello posteriore	Rear carriage
3	Rostro di chiusura	Locking pin
4	Fermo anta	Bumper stop
5	Barra di unione	Stopper
6	Meccanismo	Mechanism
7	Profilo omega per fissaggio carrelli	Reinforcement profile for fixing carriage
8	Kit rinforzo angoli	Kit reinforcement
9	Tampone centrale di tenuta su guida sup.	Central sealing pad for upper rail
10	Tampone centrale di tenuta su guida inf.	Central sealing pad for bottom rail
11	Tampone di tenuta in neoprene	Neoprene sealing pads
12	Tampone di tenuta in neoprene	Neoprene sealing pads
13	Prolunga meccanismo	Additional mechanism
*	Presente solo su kit AG2986 7/F.E1	Only on the kit AG2986 7/F.E1

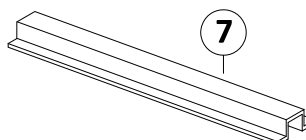


Schema | Type F



2

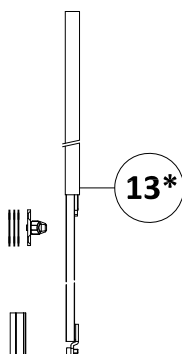
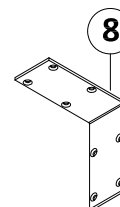
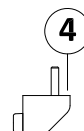
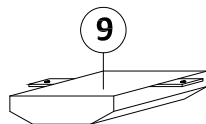
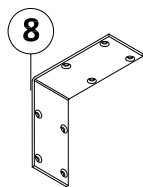
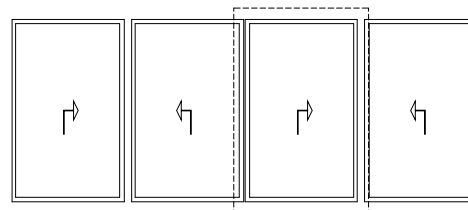
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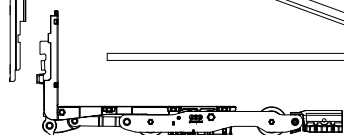
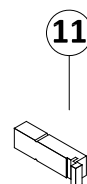
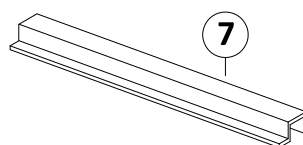
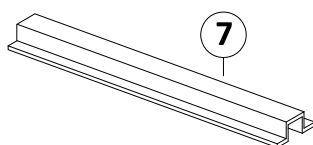
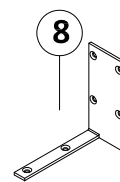
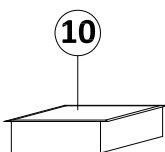
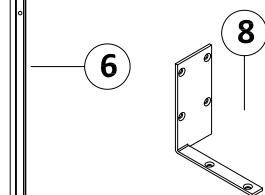
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1

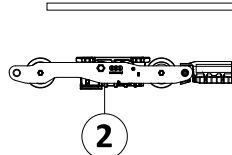
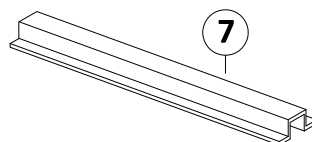
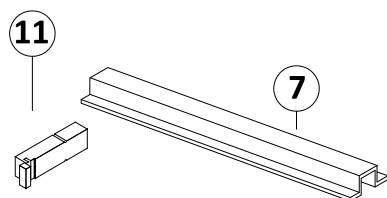
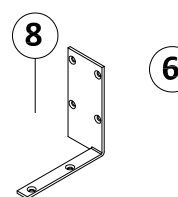
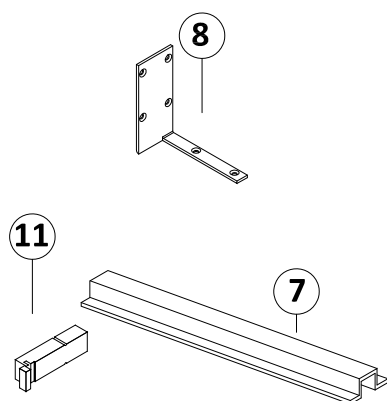
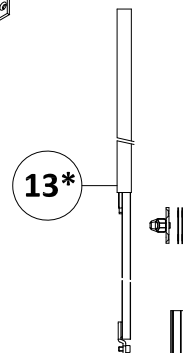
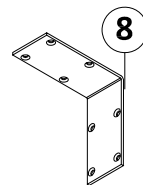
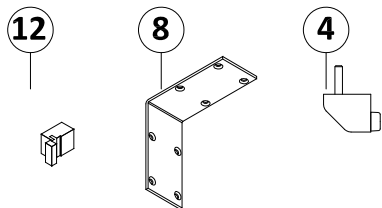
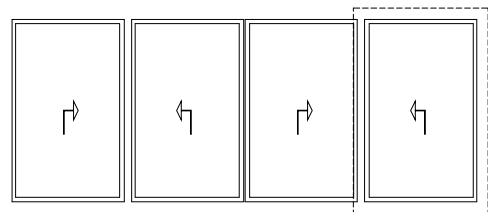
Schema | Type F



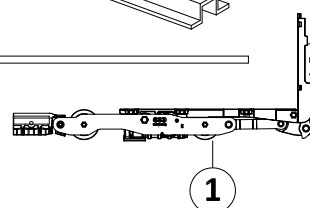
AC2986-7/F - DESCRIZIONE DESCRIPTION AC2986-7/F	
1	Carrello anteriore <i>Front carriage</i>
2	Carrello posteriore <i>Rear carriage</i>
3	Rostro di chiusura <i>Locking pin</i>
4	Fermo anta <i>Bumper stop</i>
5	Barra di unione <i>Stopper</i>
6	Meccanismo <i>Mechanism</i>
7	Profilo omega per fissaggio carrelli <i>Reinforcement profile for fixing carriage</i>
8	Kit rinforzo angoli <i>Kit reinforcement</i>
9	Tampone centrale di tenuta su guida sup. <i>Central sealing pad for upper rail</i>
10	Tampone centrale di tenuta su guida inf. <i>Central sealing pad for bottom rail</i>
11	Tampone di tenuta in neoprene <i>Neoprene sealing pads</i>
12	Tampone di tenuta in neoprene <i>Neoprene sealing pads</i>
13	Prolunga meccanismo <i>Additional mechanism</i>
*	Presente solo su kit AG2986 7/F.E1 <i>Only on the kit AG2986 7/F.E1</i>



Schema | Type F



5



1

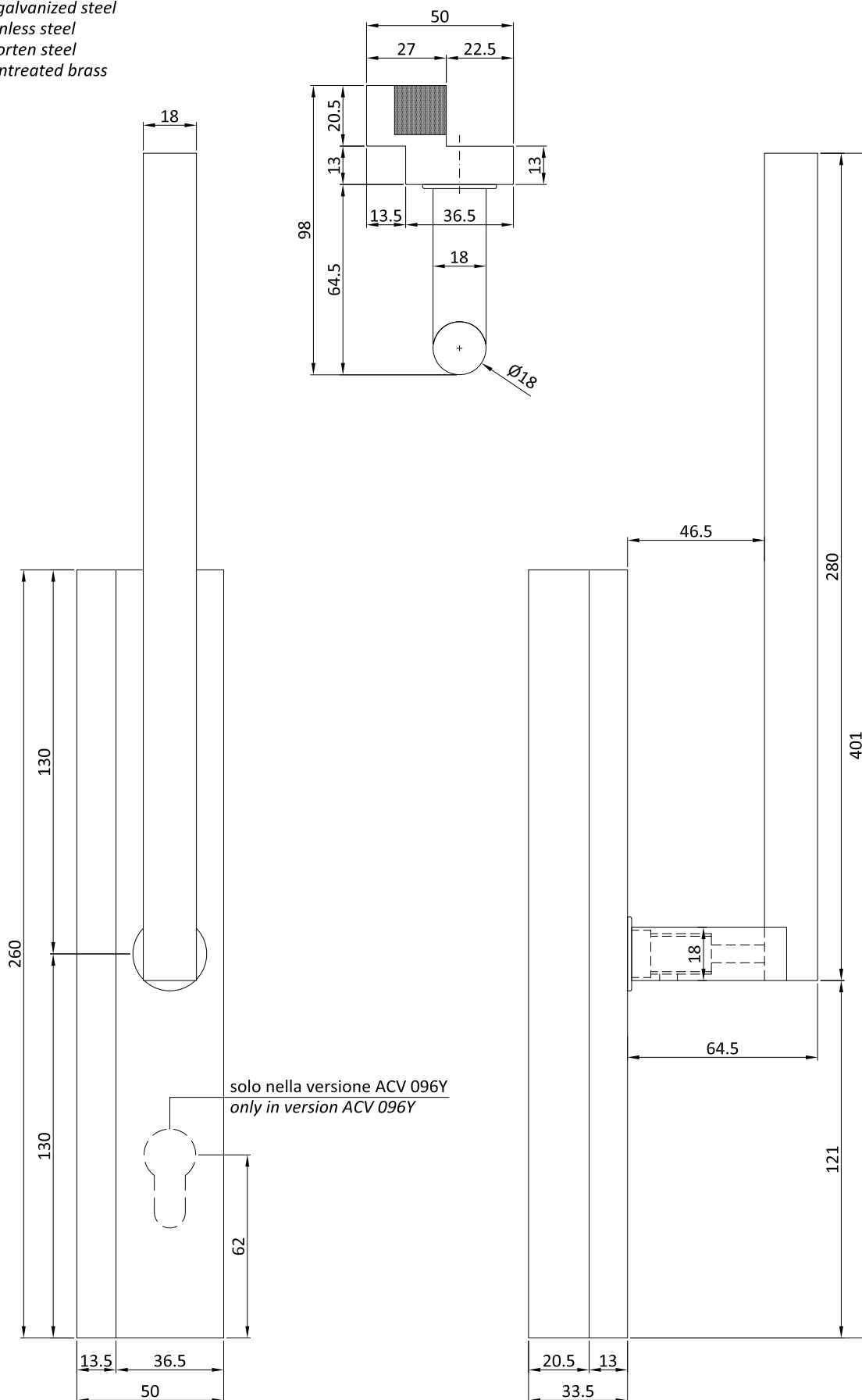
ACV 096 - ACV 096 Y finiture | finishing

ZN acciaio zincato | galvanized steel

SB acciaio inox | stainless steel

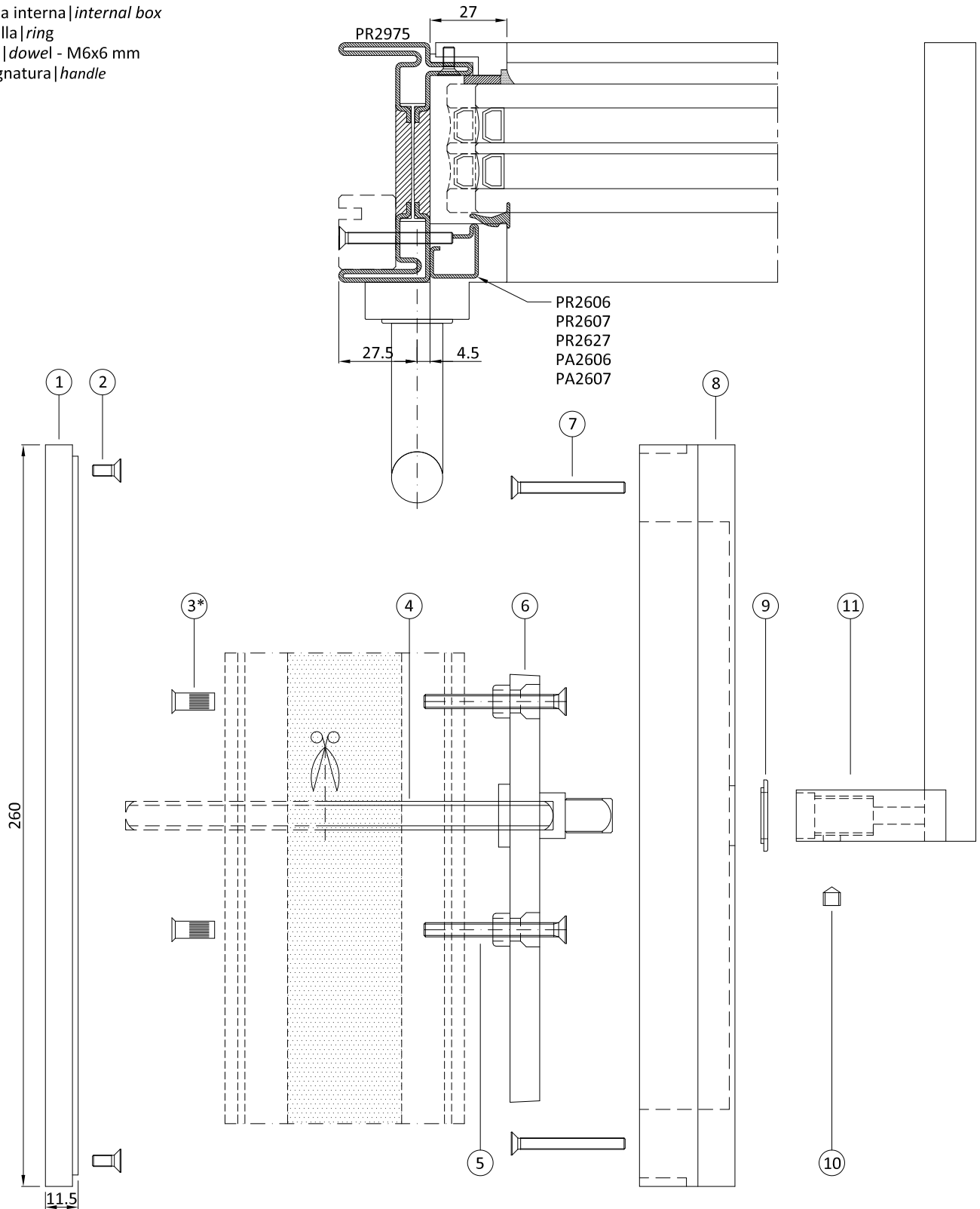
CZ acciaio corten | corten steel

BR ottone grezzo | untreated brass



ACV096 - ACV096Y componenti | components

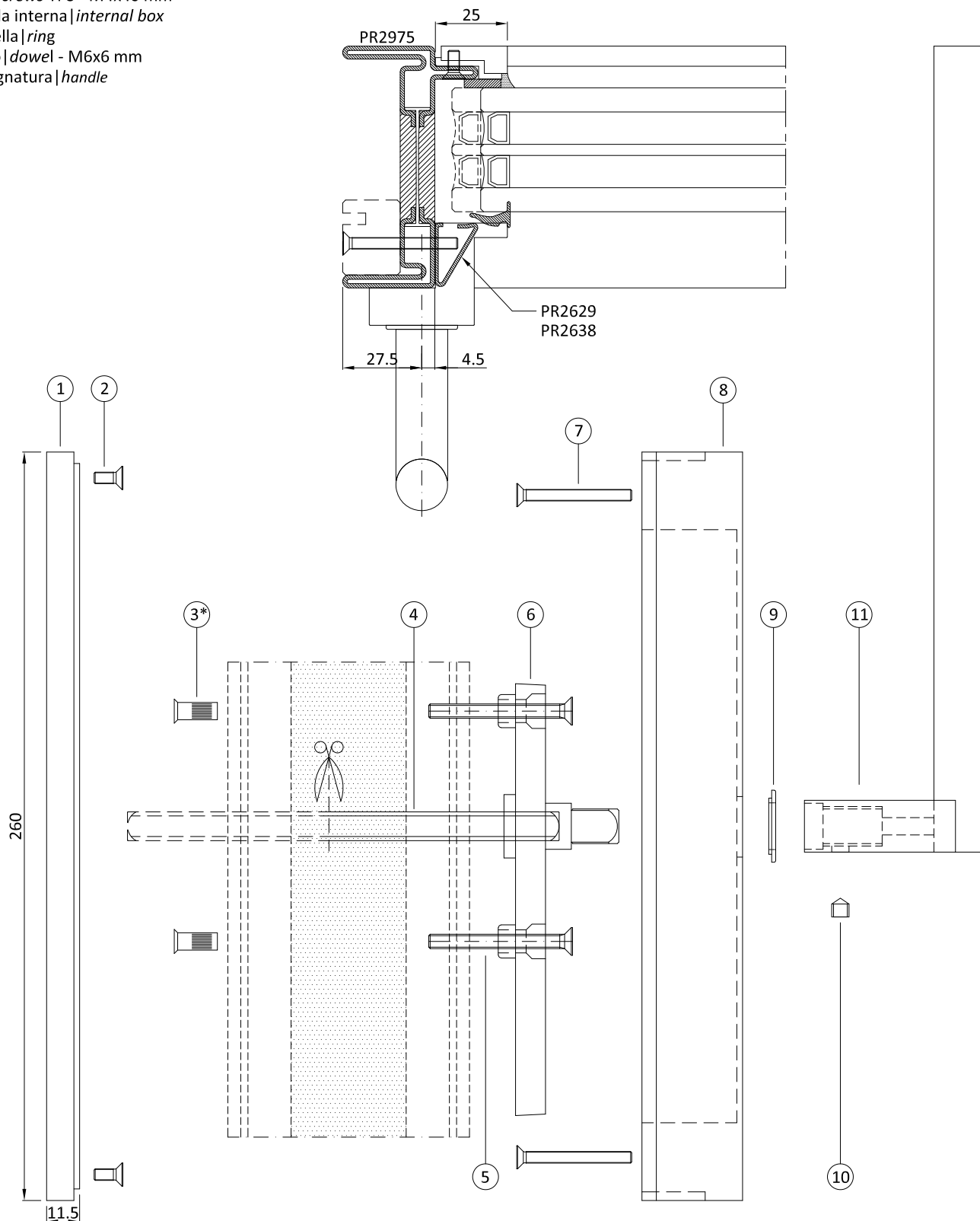
1. piatto esterno | external plate
2. vite | screws TPS - M4x8 mm
3. rivetto filettato | threaded rivet - M5
4. quadro | spindle bar - 10 mm
5. vite | screws - TPS M5x50 mm
6. meccanismo maniglione | handle mechanism
7. vite | screws TPS - M4x40 mm
8. scatola interna | internal box
9. rondella | ring
10. grano | dowel - M6x6 mm
11. impugnatura | handle



* rivetto da applicare alla serratura
* rivet to be applied to the lock

ACV097 - ACV097Y componenti | components

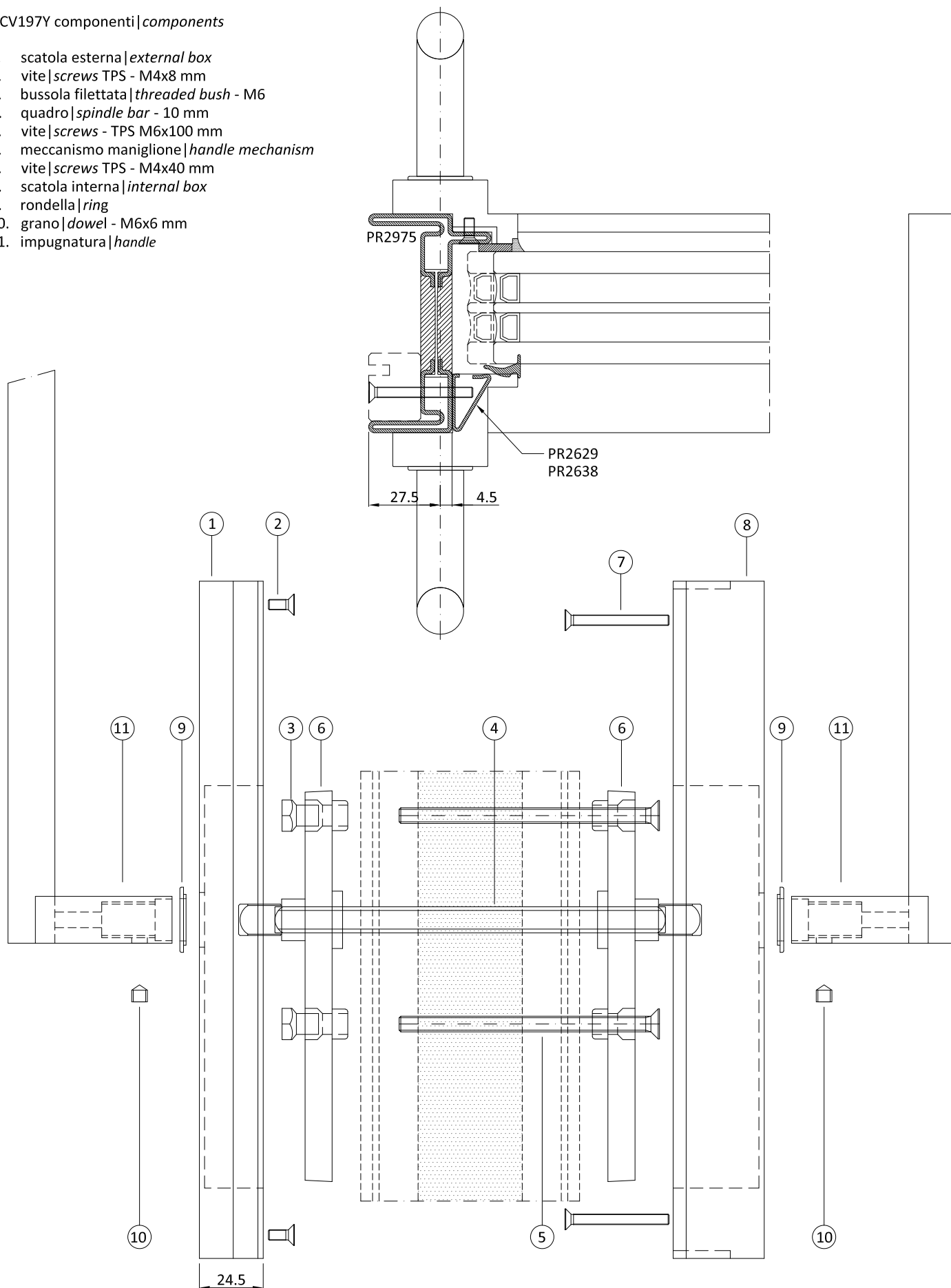
1. piatto esterno | external plate
2. vite | screws TPS - M4x8 mm
3. rivetto filettato | threaded rivet - M5
4. quadro | spindle bar - 10 mm
5. vite | screws - TPS M5x50 mm
6. meccanismo maniglione | handle mechanism
7. vite | screws TPS - M4x40 mm
8. scatola interna | internal box
9. rondella | ring
10. grano | dowel - M6x6 mm
11. impugnatura | handle



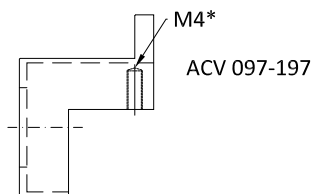
* rivetto da applicare alla serratura
* rivet to be applied to the lock

ACV197Y componenti | components

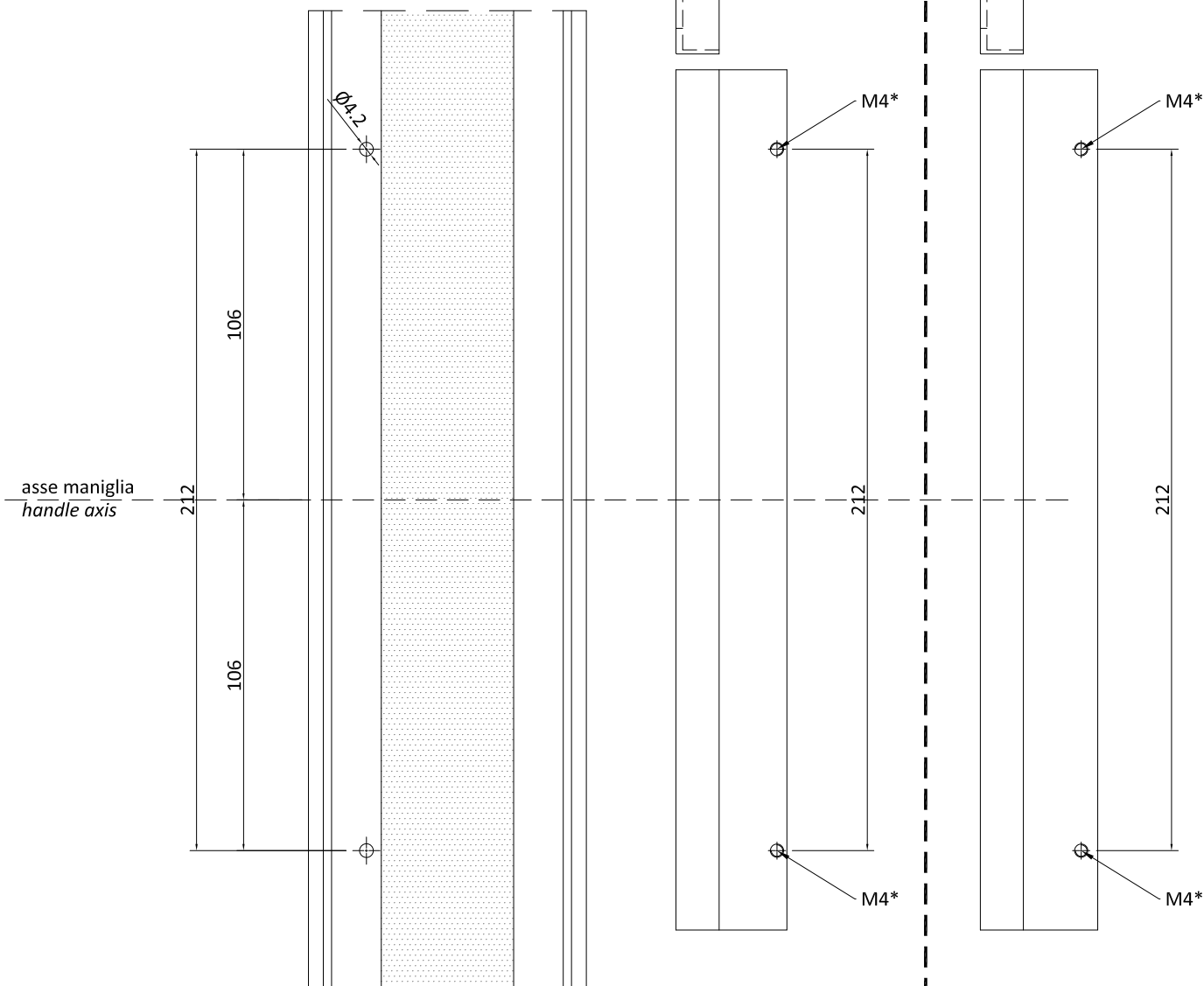
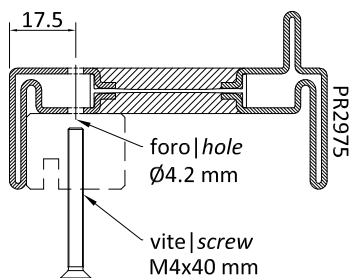
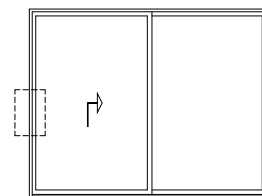
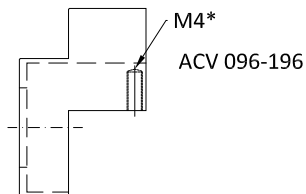
1. scatola esterna | external box
2. vite | screws TPS - M4x8 mm
3. bussola filettata | threaded bush - M6
4. quadro | spindle bar - 10 mm
5. vite | screws - TPS M6x100 mm
6. meccanismo maniglione | handle mechanism
7. vite | screws TPS - M4x40 mm
8. scatola interna | internal box
9. rondella | ring
10. grano | dowel - M6x6 mm
11. impugnatura | handle



- 1 - forare $\varnothing 4.2$ mm il profilo PR2975
- 2 - allineare correttamente la scatola interna
- 3 - tracciare i fori del profilo PR2975 sulla scatola interna
- 4 - forare M4, prestando attenzione a non forare passante



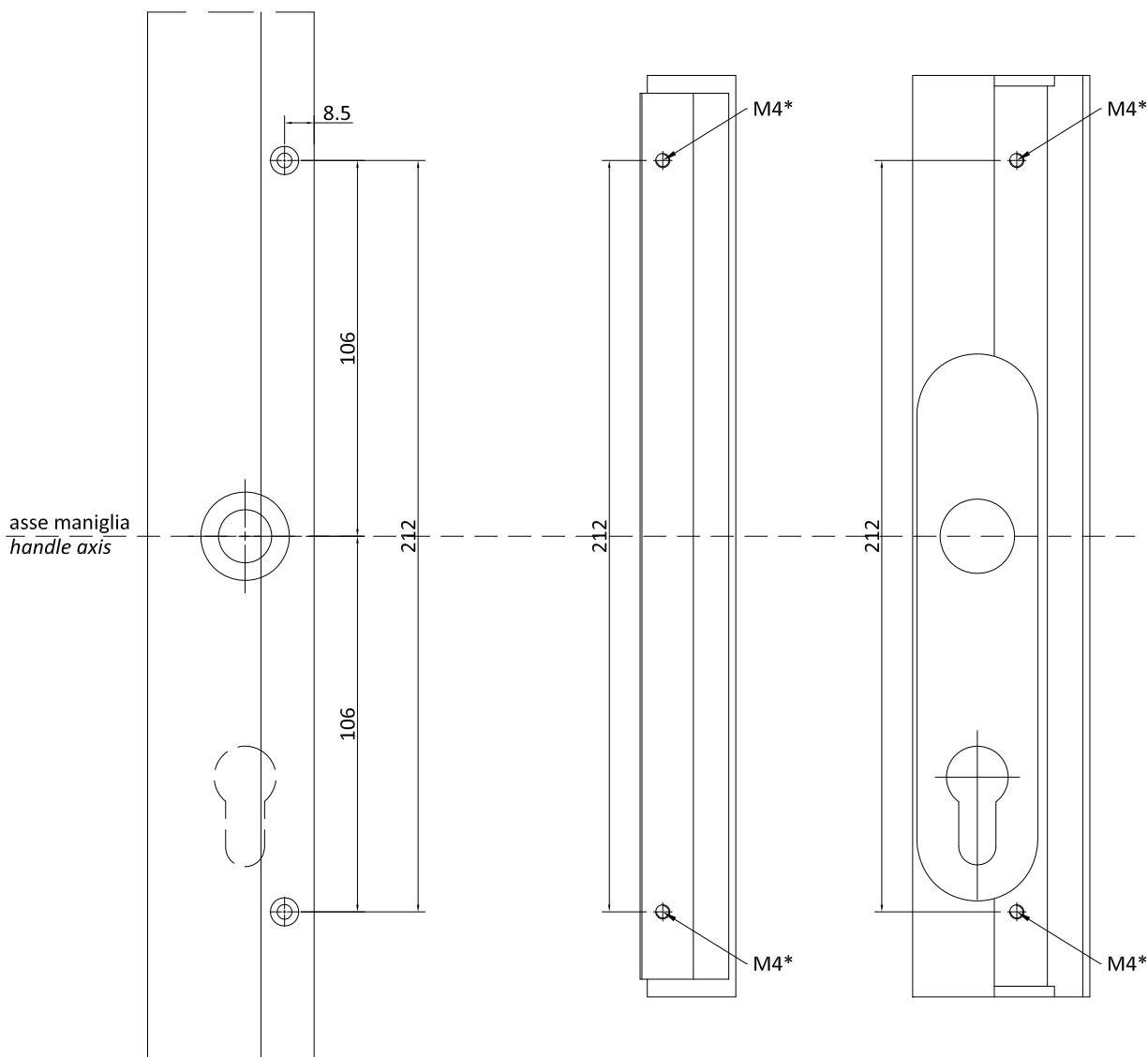
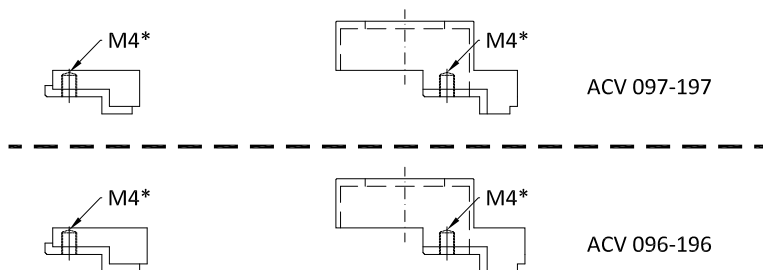
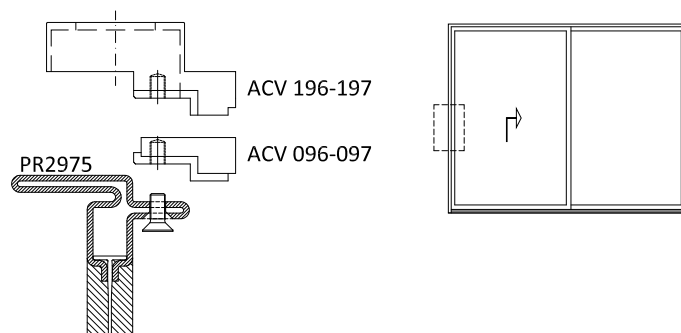
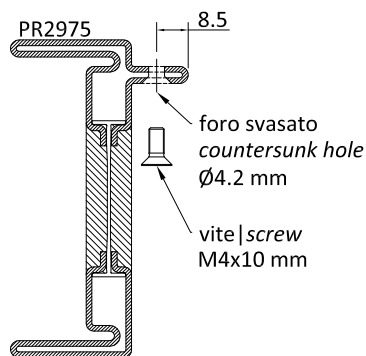
- 1 - drill $\varnothing 4.2$ mm the profile PR2975
- 2 - Align the inner box correctly
- 3 - mark the holes of the profile PR2975 on the inner box
- 4 - Drill M4, be careful not to drill through it



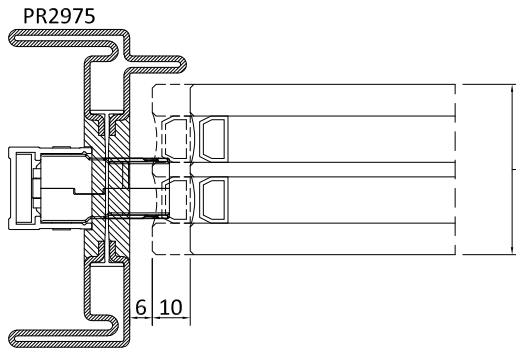
* prestare particolare attenzione ai punti 3-4
* pay more attention to points 3-4

- 1 - forare $\varnothing 4.2$ mm il profilo PR2975
- 2 - allineare correttamente il piatto/scatola esterna
- 3 - tracciare i fori del profilo PR2975 su piatto/scatola esterna
- 4 - forare M4, prestando attenzione a non forare passante

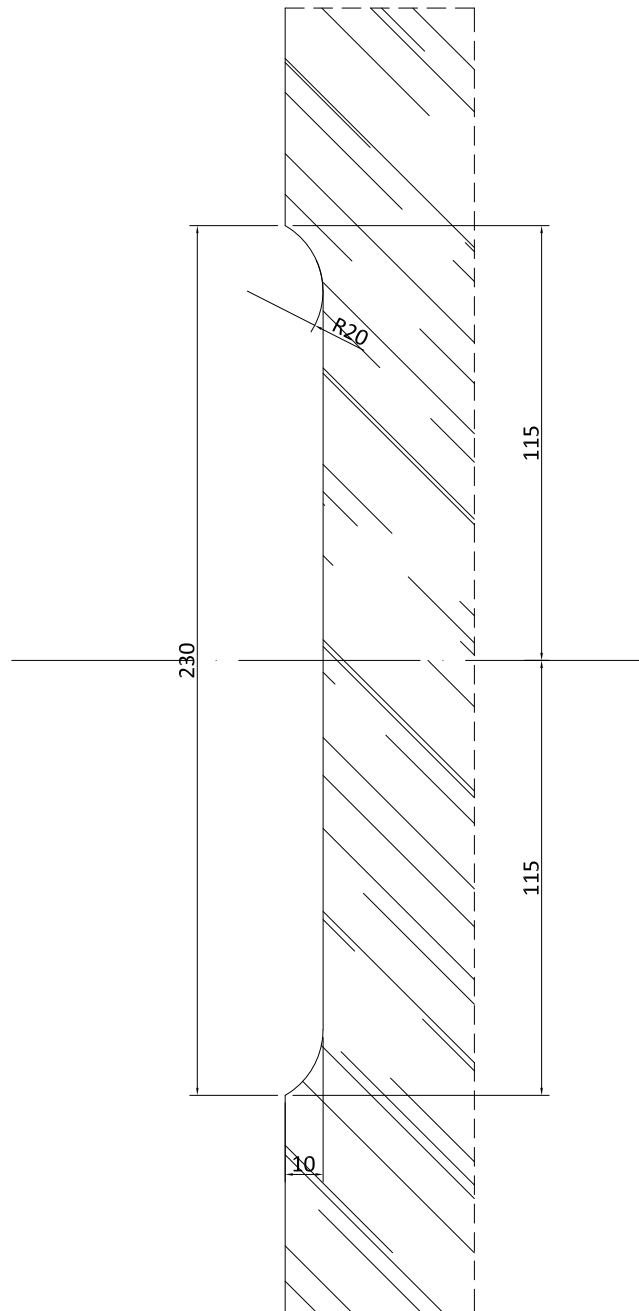
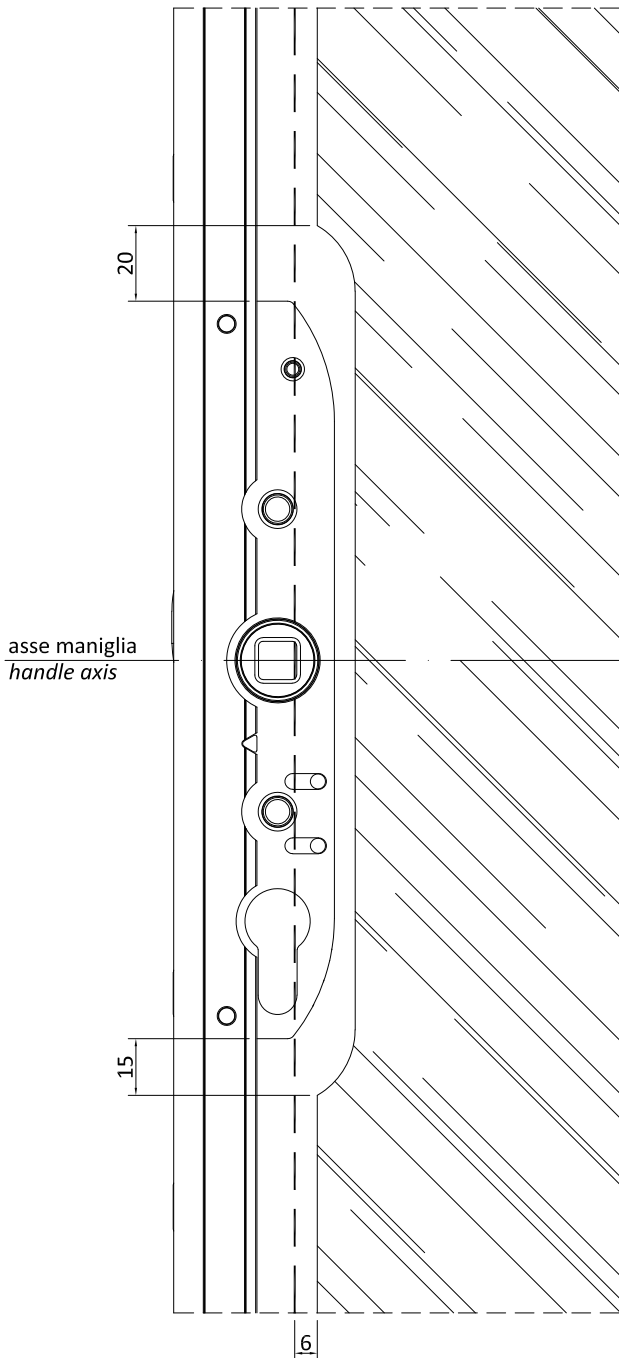
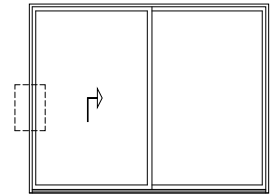
- 1 - drill $\varnothing 4.2$ mm the profile PR2975
- 2 - Align the outer plate/box correctly
- 3 - mark the holes of the profile PR2975 on the external plate/box
- 4 - Drill M4, be careful not to drill through it



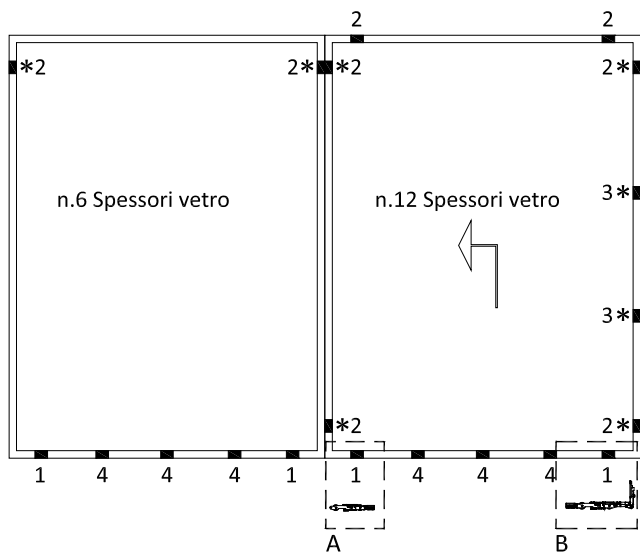
* prestare particolare attenzione ai punti 3-4
* pay more attention to points 3-4



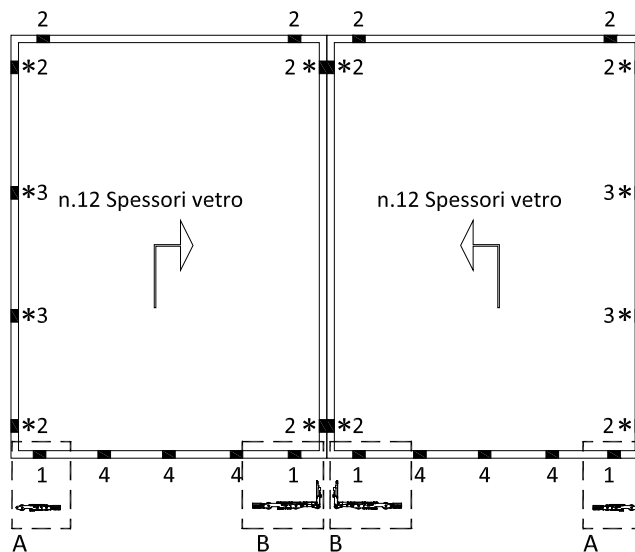
46 mm
PR2606-PR2607-PR2627-PA2607-PA2608
44 mm
PR2629-P2638



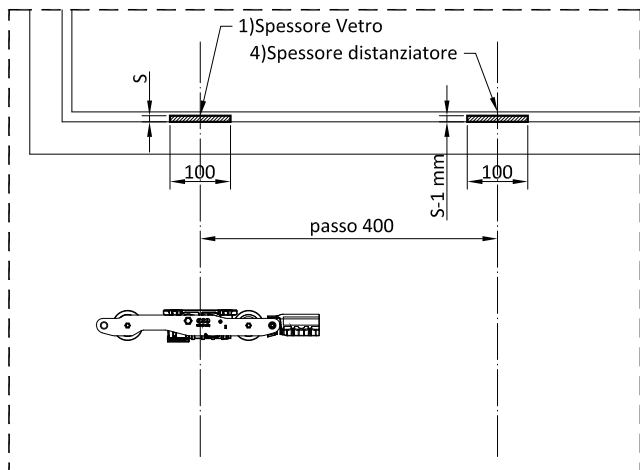
1 ANTA SCORREVOLE ED 1 ANTA FISSA
1 SLIDING AND 1 FIXED SASH



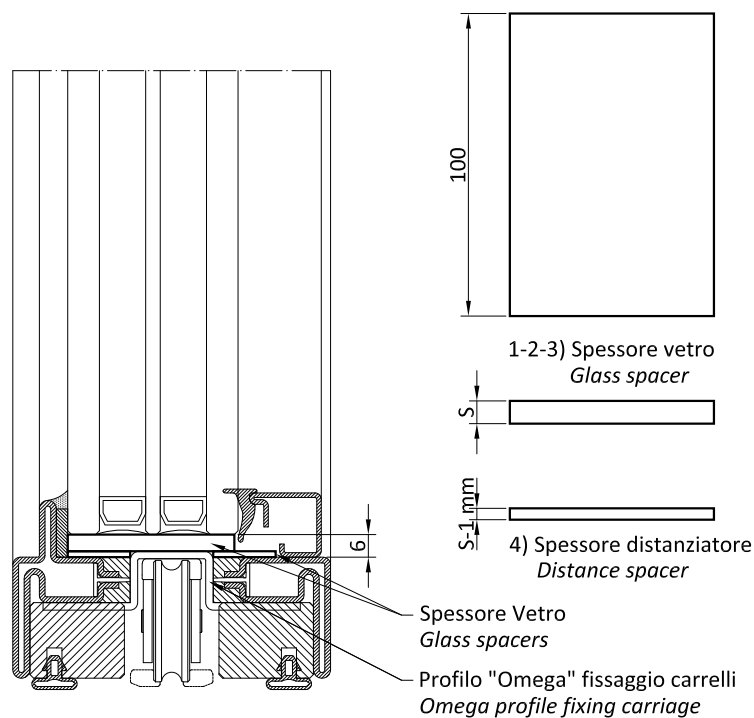
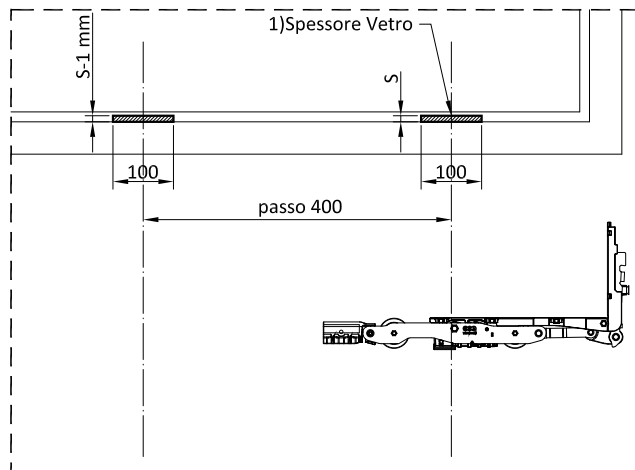
2 ANTE SCORREVOLI
2 SLIDING SASHES



PARTICOLARE "A"
PARTICULAR "A"



PARTICOLARE "B"
PARTICULAR "B"



- 1) Spessore portante (allineato ai carrelli dove presenti)
- 2) Spessore distanziatore
- 3) Spessore distanziatore per punti di chiusura
- 4) Spessore distanziatore

- 1) Load-bearing spacer (aligned with carriages if present)
- 2) Distance spacer
- 3) Distance spacer for locking points
- 4) Distance spacer

* Verticalmente fissare spessore vetro con Silicone

* Attach glass spacer vertically with Seal

Generalità

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

Tolleranze

OS2 75 AS prevede l'accoppiamento tra i telai esterni e le ante apribili con distanza di 4 mm nei giunti laterali e di 3 e 14 mm nei giunti inferiore e superiore. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-1 mm.

Taglio/Lavorazioni

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

Saldatura

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

Verniciatura/Brunitura

I profili OS2 75 AS sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. La zona a taglio termico in poliuretano non è in grado di accogliere con sufficiente adesione le polveri poliesteri e perciò si consiglia di ricoprire tali zone, nelle sole parti destinate ad essere in vista, con apposite pellicole adesive idonee al passaggio in forno. I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento. Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrazione

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

Installazione

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

General information

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

Tolerance

OS2 75 AS is made by coupling external frames with the opening leaves with a distance of 4 mm in lateral joint and 3 mm or 14 mm in the lower and upper joint. To ensure the correct functioning of hardware and gaskets, tooling must be performed with great care and precision. It is advised to keep the tolerance between +0/-1 mm for opening elements.

Cut / Processing

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

Welding

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

Painting/Burnishing

OS2 75 AS profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024 and SA1033). Holes must be drilled in the frames (as per instructions in these technical specifications) before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooled.

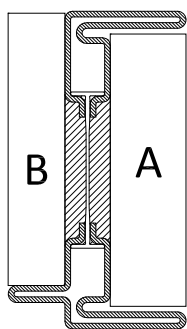
It is advised to follow pre-treatment and painting cycles as outlined in the Secco Sistemi documentation.

Glass application

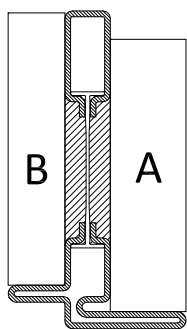
Glass needs to be secured internally and externally. Internally, glazing beads must be used together with clips then secured by pressure with the appropriate gasket; externally a continuous perimetrical gasket should be applied, jointed and sealed in a top corner or a butyl seal and a thread of silicone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

Installation

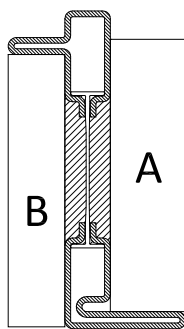
Proper installation must guarantee that the performances declared in the EC marking and verified in the lab will remain constant. It is advised to arrange a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to install. Once installation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



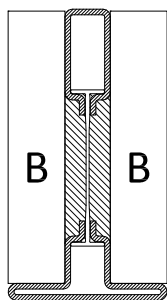
PR2975



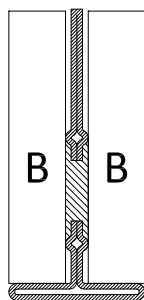
PR2988



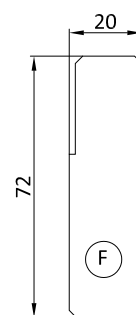
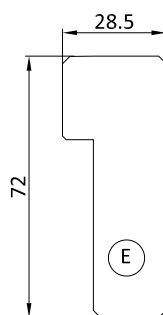
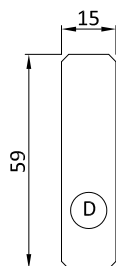
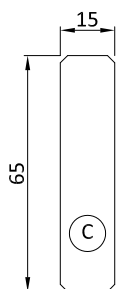
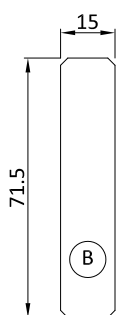
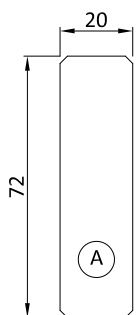
PR2989

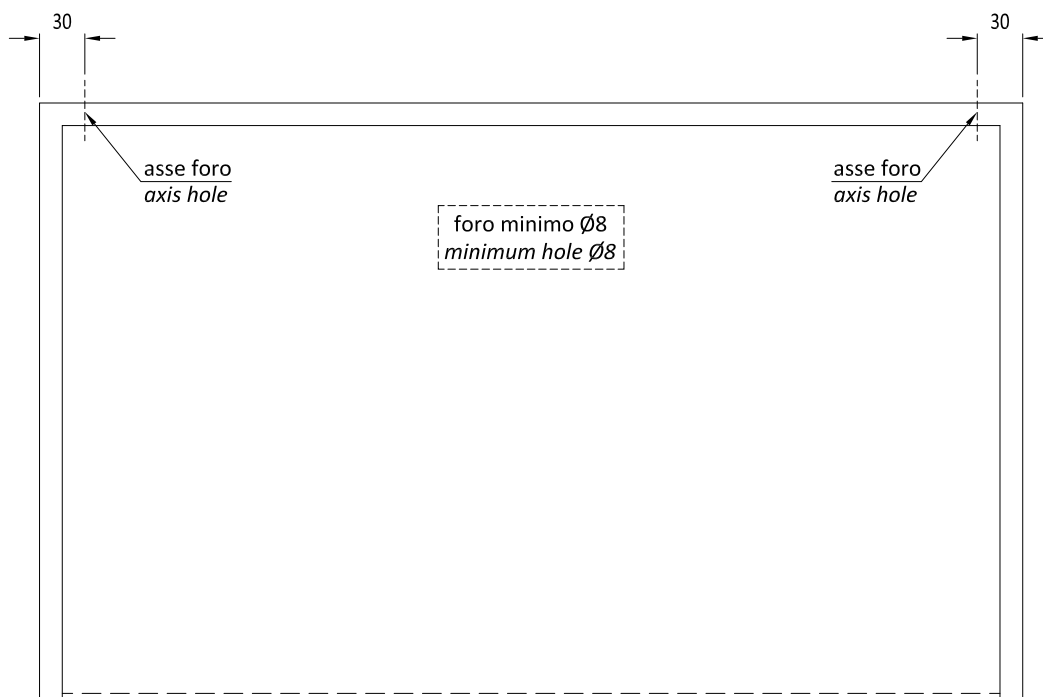


PR2952



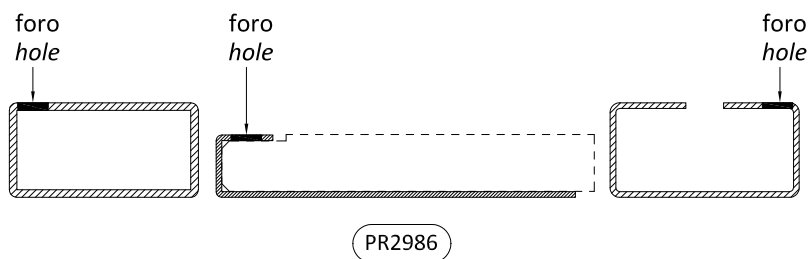
PR2954



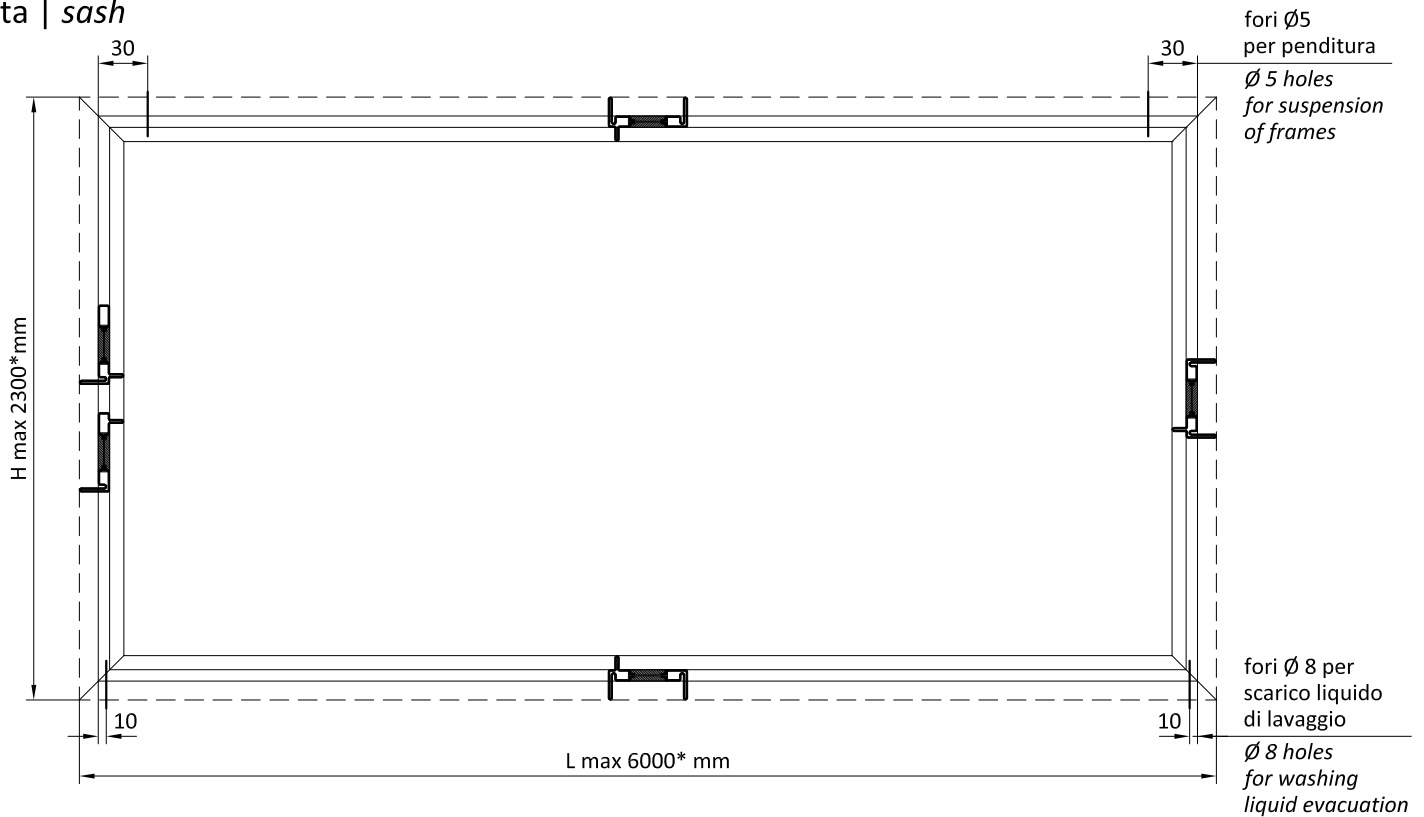
telaio | *frame*

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

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

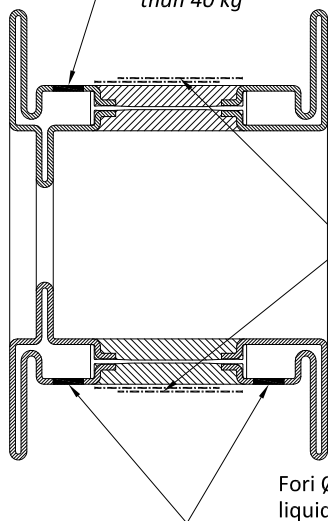


anta | sash



Fori Ø5 per pendinatura
telai con peso inferiore
a 40 kg

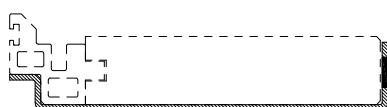
Ø 5 holes for suspension
of frames not heavier
than 40 kg



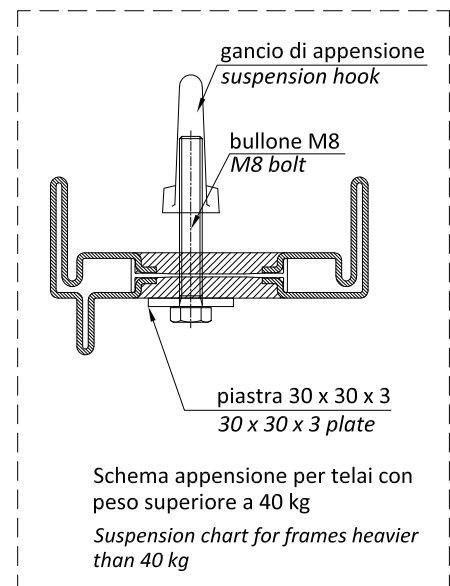
SOLO PER VERNICIATURA
Nastro adesivo protettivo da
25 mm resistente alle alte
temperature (220-230°)

ONLY FOR PAINTING
Protective 25 mm tape resistant
to high temperatures (220-230°)

Fori Ø8 per lo scarico del
liquido di lavaggio
Ø 8 holes for washing
liquid evacuation



Fori Ø5 per pendinatura
Ø 5 holes for suspension

**SOLO PER BRUNITURA**

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

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

ONLY FOR BURNISHING

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

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

* Dimensioni massime disponibili nell'impianto di Secco Sistemi

* Maximum available size in the Secco Sistemi plant

Troncatricecaratteristiche minime della macchina

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

caratteristiche della lama

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

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

Pantografocaratteristiche minime della macchina

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

caratteristiche minime delle frese

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

Foraturemontaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

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

fresatura di cave e asole sui profili inox

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

CutterMinimum requirements for the use of the machine

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

Blade specifications

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

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

PhantographMinimum requirements for the use of the machine

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

Minimum requirements for the use of a milling machine

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

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

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

Milling slots and loops in the profiles

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

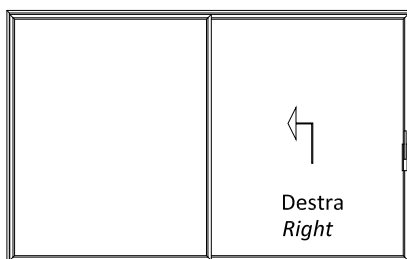
1. Controllo materiale in arrivo / *Incoming equipment Control*

Verifica visiva dell'intergrità delle barre con attenzione a: / *Profiles wholeness visual control paying attention to:*

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

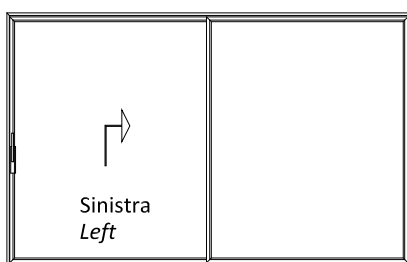
2. Taglio barre e controllo barre / *Cut and Control of profiles*

- Misura lunghezza / *Length measurement* ±0.5 mm
- Verifica 45° / *45° Control* ± 1°
- Verifica 90° / *90° Control* ± 1°

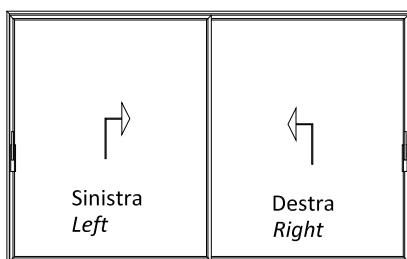
Schema | Type A 1 anta scorrevole ed 1 anta fissa
1 sliding and 1 fixed sash

vista interna | inside view

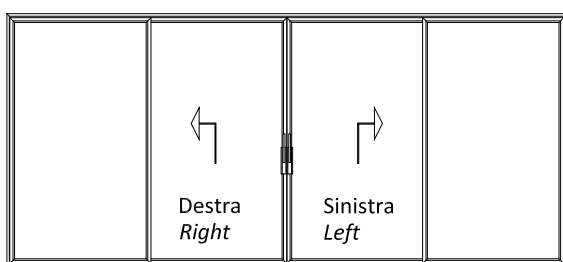
Codice Code	Descrizione Description
AG 2986A	Kit movimentazione e tenuta 1 anta apribile 1 leaf handling and sealing kit
ACV 096 - 097	Maniglione singolo Single handle
ACV 096Y.D - 097Y.D	Maniglione singolo con cilindro Single handle with hole cilinder
ACV 196Y.D - 197Y.D	Maniglione doppio con cilindro Double handle with hole cilinder

Schema | Type A 1 anta scorrevole ed 1 anta fissa
1 sliding and 1 fixed sash

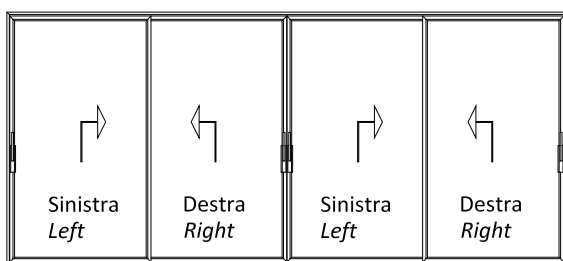
Codice Code	Descrizione Description
AG 2987A	Kit movimentazione e tenuta 1 anta apribile 1 leaf handling and sealing kit
ACV 096 - 097	Maniglione singolo Single handle
ACV 096Y.S - 097Y.S	Maniglione singolo con cilindro Single handle with hole cilinder
ACV 196Y.S - 197Y.S	Maniglione doppio con cilindro Double handle with hole cilinder

Schema | Type B 2 ante scorrevoli
2 sliding sashes

Codice Code	Descrizione Description
AG 2986B - AG 2987B	Kit movimentazione e tenuta 2 ante apribili 2 leaf handling and sealing kit
ACV 096 - 097	Maniglione singolo Single handle
ACV 096Y.D-S - 097Y.D-S	Maniglione singolo con cilindro Single handle with hole cilinder
ACV 196Y.D-S - 197Y.D-S	Maniglione doppio con cilindro Double handle with hole cilinder

Schema | Type E 2 ante scorrevoli e 2 ante fisse
2 sliding and 2 fixed sashes

Codice Code	Descrizione Description
AG 2986E	Kit movimentazione e tenuta 2 ante apribili 2 leaf handling and sealing kit
ACV 096 - 097	Maniglione singolo Single handle
ACV 096Y.D-S - 097Y.D-S	Maniglione singolo con cilindro Single handle with hole cilinder
ACV 196Y.D-S - 197Y.D-S	Maniglione doppio con cilindro Double handle with hole cilinder

Schema | Type F 4 ante scorrevoli
4 sliding sashes

Codice Code	Descrizione Description
AG 2986F	Kit movimentazione e tenuta 4 ante apribili 4 leaf handling and sealing kit
ACV 096 - 097	Maniglione singolo Single handle
ACV 096Y.D-S - 097Y.D-S	Maniglione singolo con cilindro Single handle with hole cilinder
ACV 196Y.D-S - 197Y.D-S	Maniglione doppio con cilindro Double handle with hole cilinder

3. Lavorazioni su barra / *Section processing*

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648 sez 4.3.7		AC2648 sez 4.2.9	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649/50 sez 4.2.6		AC2649/50 sez 4.2.8	
Fori e asole per serratura e incontri <i>Lock and strike slots and holes</i>	AC2493 sez 4.2.15	AC2494 sez 4.2.16	AC2493 sez 4.2.15	AC2494 sez 4.2.17
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2653 sez 4.2.3-4		AC2653 sez 4.2.3-4	
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2440 sez 4.2.11-12	AC2621GB/GC sez 4.2.10	AC2440 sez 4.2.11-12	AC2621GB/GC sez 4.2.10
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.2.1-2		sez 3.2.1-2	

4. Assiemaggio / *Assembly*

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
<u>Costruzione telai / <i>Frame assembly</i></u>				
Saldatura / <i>Welding</i>	- sez 4.3.1-3		- sez 4.3.1-3	
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2653 sez 4.2.3-4		AC2653 sez 4.2.3-4	
<u>Applicazione accessori / <i>Accessories installation</i></u>				
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648 sez 4.3.7		AC2648 sez 4.2.9	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649/50 sez 4.2.6		AC2649/50 sez 4.2.8	
Saldatura cerniere a saldare <i>Hinge welding</i>	AC2631/32 sez 4.3.5		AC2631/32 sez 4.3.6	
Lavorazione per paraspiffero automatico <i>Automatic door bottom seal installation holes</i>	AC2436 sez 4.2.13		AC2436 sez 4.2.14	

5. Preparazione per verniciatura / *Preparation for the powder coating*

- a. Fori su telaio per scarichi liquidi pretrattamento
Holes on frame for the drainage of pretreatment liquid sez 5.1.4
- b. Marcatura e imballo telai esterni e ante
External frames and leafs branding and packing -
- c. Marcatura e imballo telai fermavetro
Glazingbeads frames branding and packing -
- d. Marcatura e imballo profili complementari
Additional profiles branding and packing -
- e. Imballo scarichi acqua e cerniere
Accessories (water drip, hinges) branding and packing -

6. Applicazione accessori / *Hardware and accessories installation*
Porta / *Door*
- I. Montaggio cerniere / *Hinges installation* sez 4.2.6-9
 - II. Montaggio serratura e incontri / *Lock and strikes installation* sez 4.2.15-17
 - III. Applicazione paraspiffero automatico /
Automatic door bottom seal installation holes sez 4.2.13-14
 - IV. Montaggio catenaccio / *Flush bolt installation* sez. 4.2.10-11
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
7. Vetrazione / *Glazing*
- a. Applicazione clips fermavetro / *glazing bead clips installation* sez 2.6.1-7
 - b. Applicazione guarnizione esterna / *External glazing gasket installation*
 - c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* sez 4.5.1
 - d. Inserimento fermavetri / *Glazing beads application*
 - e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
 - f. Verifica corretta compressione guarnizione / *Control of the right compression of the gasket*
8. Controlli su prodotto finito / *Control on finished element*
- a. Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
 - c. Verifica funzionamento maniglia serratura / *Control of hardware functioning*
 - d. Verifica finitura superficiale / *Control of surface finishing*
9. Controlli dopo la posa / *Controls after installation*
- a. Verifica corretta installazione telai: squadra, piombo, misure /
Control of alignment and plumbing of frame and leaf
Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
Verifica funzionamento maniglia serratura / *Control of hardware functioning*
 - c. Verifica finitura superficiale / *Control of surface finishing*

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

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

Caratteristiche fisiche

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

Norme di riferimento

EN 10088-2; EU 114

Trattamenti superficiali

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

ACCIAIO COR-TEN**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

EN 10149

Trattamenti superficiali

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

ACCIAIO ZINCATO VERNICIATO**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

UNI EN 10142/3/7; EURONORM 143

Trattamenti superficiali per la verniciatura

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

LEGA DI RAME OT67**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

EN 1652:1999

Trattamenti superficiali

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

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

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

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

Physical features

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

Norms of reference

EN 10088-2; EU 114

Surface treatment

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

CORTEN STEEL**Materials**

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

Physical features

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

Norms of reference

EN 10149

Surface treatment

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

GALVANIZED AND PAINTED STEEL**Materials**

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

Physical features

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

Norms of reference

UNI EN 10142/3/7; EURONORM 143

Pre-painted surface treatment

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

COPPER ALLOY OT67**Materials**

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

Physical features

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

Norms of reference

EN 1652:1999

Surface treatment

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

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

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AG2987A	4.3.4-5 – 4.3.14 – 4.3.20
AG2986B	4.3.4-5 – 4.3.14 – 4.3.21-22
AG2987B	4.3.4-5 – 4.3.14 – 4.3.21-22
AG2986E	4.3.4-5 – 4.3.14 – 4.3.23-24
AG2986F	4.3.4-5 – 4.3.14 – 4.3.25-28
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CV1243	2.9.4 – 2.9.6
CV1243I	2.9.4 – 2.9.6
CV5012	2.9.4 – 2.9.6
CV5012I	2.9.4 – 2.9.6
CV5403I	4.2.7-8
GU2905	4.3.13
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GU2975L	4.3.8 – 4.3.10
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METALFORM

MASTERS OF METAL

UNITED KINGDOM

METALFORM

NORWAYMETAL LTD

53 Chelsea Manor Street

London, SW3 5RZ

SALES@METALFORM.UK

+44 20 81298814

GERMANY

METALFORM GMBH

Carl-Zeiss-Ring 15A

85737 Ismaning

SALES@METALFORMGROUP.DE

+49 17663630406

NORWAY

METALFORM AS

Brochmannsveien 2

1950 Rømskog

SALG@METALFORM.NO

+47 401 62 446

METALFORMGROUP

SALES@METALFORMGROUP.COM