

4F1

CATALOGO

TECNICO

TECHNICAL

CATALOGUE

METALFORM

versione 05/2021

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

secco

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Sistema integrato di **profili, accessori e guarnizioni** per la costruzione di **facciate continue a taglio termico** a montanti e traversi con profili aventi sezione in vista di 50 mm e profondità di 50, 80, 100, 120, 150 e 180 mm, combinabili liberamente tra loro.

I **profili costituenti montanti e traversi** sono, relativamente alla parte della sezione resistente, dello spessore di 20/10 mm e sono ottenuti tramite profilatura a freddo di nastri in **acciaio zincato, acciaio inox (AISI 304 o AISI 316L) o acciaio cor-ten**. La **particolare geometria** dei profili senza parti metalliche sporgenti verso il vano vetro e l'uso di accessori dedicati in materiale isolante, permettono di ottenere valori eccellenti di trasmittanza termica.

Il profilo pressore è fornito in acciaio zincato ed acciaio inox, è dotato di due canali porta guarnizioni ed è perforato a passo costante per l'installazione delle viti di fissaggio.

Le copertine esterne, di diversa altezza per montante e traverso e inserite a scatto, sono fornite in acciaio zincato verniciabile, acciaio inox satinato e lucido (AISI 304 o AISI 316L), acciaio COR-TEN, lega di ottone.

Il **sistema di guarnizioni interne in EPDM** è pensato per assicurare un'efficace ventilazione e lo scarico a terra dell'acqua di condensa grazie alla diversa geometria delle guarnizioni, che permette il passaggio dell'acqua da un livello all'altro semplicemente realizzando il sormonto delle guarnizioni dei traversi e dei montanti. La loro geometria è pensata per coprire totalmente la superficie del profilo lato vetro, favorendo l'isolamento termico. Sono dotate di piedi d'aggancio che permettono l'alloggiamento nei canali dei profili, garantendo il mantenimento della linearità delle guarnizioni in perimetri molto lunghi e durante le normali dilatazioni termiche della struttura nel tempo.

Le lavorazioni su profili possono essere eseguite tutte in officina. L'unione dei profili traversi ai montanti è possibile grazie ad un **sistema di giunzione con perni fissi o a scatto**, che permette l'eventuale rimozione del traverso in caso di necessità, garantendo un montaggio rapido ed efficace, senza ricorrere a ulteriori lavorazioni durante la posa.

Le **guarnizioni esterne in EPDM** hanno spessore di 3 mm e non hanno parti sporgenti rispetto alla linea dei pressori.

4F1 è stata progettata per alloggiare **vetrazioni e pannellature** aventi spessore fino a 56 mm con inserimento frontale dall'esterno, così come tutti i serramenti fissi o apribili Secco.

System of **curtain walls** integrated with **thermal break profiles, accessories and weather strips** with profiles with mullions and transoms of 50-mm visible sections and depths of 50, 80, 100, 120, 150 and 180 mm, which may be freely mixed and matched to make up different combinations.

The **profiles making up the mullions and transoms** are, in relation to the resistant part of the section, of the thickness of 20 / 10 mm and are obtained through cold profiling of strips of **galvanized steel, stainless steel (AISI 304 or AISI 316L) or cor-ten steel**. The **particular geometry** of the profiles without any metallic parts jutting out towards the area holding the glazing and the use of particular accessories in insulating materials guarantee excellent values in terms of thermal transmittance.

The profile of the external cover comes in galvanized steel and stainless steel. It is equipped with two grooves to house the weather strips and is pre-drilled at constant pitch for the installation of the anchoring screws.

The external covers come in different height between mullion and transom and they are provided in paintable galvanized steel, glossy satin-finish stainless steel (AISI 304 or AISI 316L), COR-TEN steel and brass alloy.

The **system of internal weather strips in EPDM** is designed to ensure an efficient run-off of water, guaranteeing complete ventilation of the curtain wall. The run-off system for water is based simply on the rebating of the transom weather strips in relation to the mullion weather strips. Their geometry is conceived to totally cover the surface of the profile on the side of the glass, thus promoting thermal insulation. They are equipped with hooked feet, which enable the housing of the profiles in the grooves. This type of embedding guarantees the maintaining of the linearity of the weather strips in cases of very long perimeters, and during cases of normal thermal expansion of the mullions and transoms over time.

Any working on the mullion and transom profiles can be done in the workshop. The joining of the mullions to the transoms is possible thanks to a **system of connection devices with clip-on pins** that means the transom can be removed if necessary, and which guarantees quick and easy assembly, without needing any further work during installation.

The **external weather strips in EPDM** have a thickness of 3 mm and do not have any parts jutting out in relation to the line of covers.

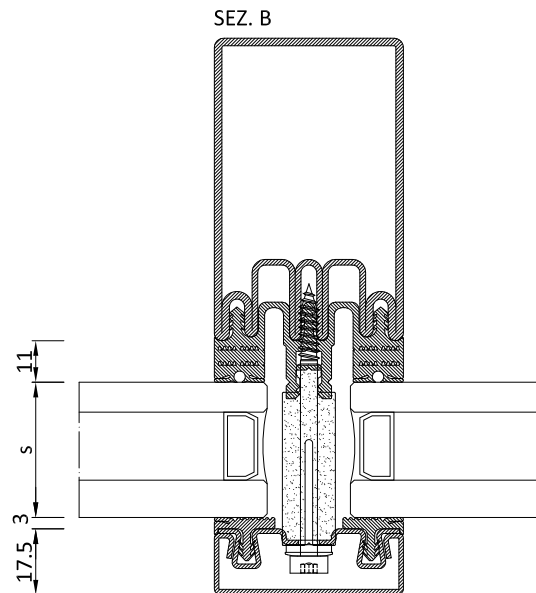
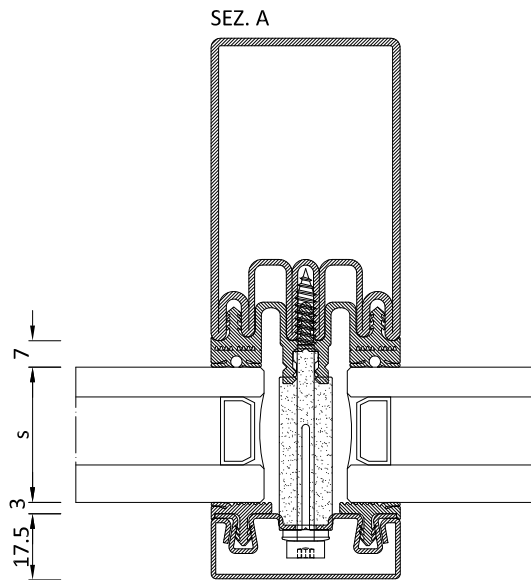
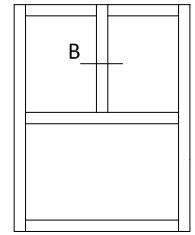
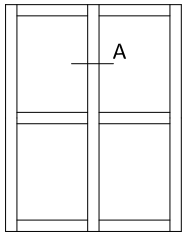
4F1 has been designed to enable **installation of glazing and panelling** up to 56 mm thickness, which can be installed frontally from the outside, as all the Secco fixes and openable frames.

PRESTAZIONI

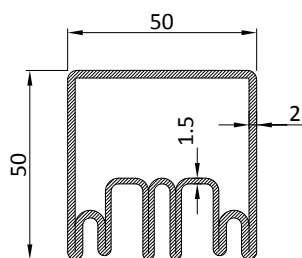
Trasmittanza termica (EN ISO 10077-2)
- Nodo tipo (PZ3610): $U_f =$ fino a 0.8 W/m²K
Permeabilità all'aria (EN 12152)
- Classe AE
Tenuta all'acqua statica (EN 12154)
- Classe RE₁₅₀₀
Tenuta all'acqua dinamica (EN 13050)
- $P_{min}=250$ Pa ; $P_{max}=750$ Pa
Resistenza al carico del vento (EN 13116)
- Carico ammesso: ± 2000 Pa
- Carico di sicurezza: ± 3000 Pa
Resistenza all'urto (EN 14019)
- Classe I5/E5
Superficie e peso massimo vetro
- 6.75 m² 550 kg

PERFORMANCES

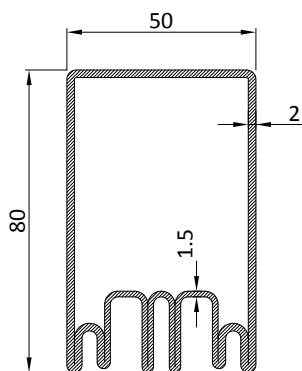
Thermal transmittance (EN ISO 10077-2)
- Typical section (PZ3610): $U_f =$ until 0.8 W/m²K
Air permeability (EN 12152)
- Class AE
Watertightness under static pressure (EN 12154)
- Class RE₁₅₀₀
Watertightness under dynamic pressure (EN 13050)
- $P_{min}=250$ Pa ; $P_{max}=750$ Pa
Resistance to wind load (EN 13116)
- Resistance to wind load: ± 2000 Pa
- Resistance to increased wind load - safety: ± 3000 Pa
Resistance against impact (EN 14019)
- Class I5/E5
Maximum glass area and weight
- 6.75 m² 550 kg



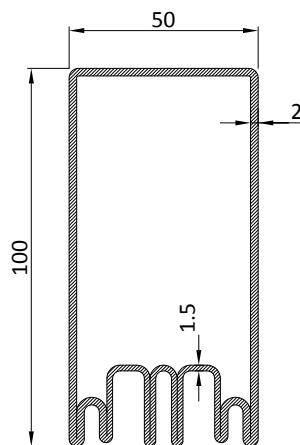
Valori trasmittanza termica Thermal transmittance							
s [mm]	U [$\frac{W}{m^2K}$]	GE3611	GE3612	U [$\frac{W}{m^2K}$]	GE3621	GE3622	GE3623
25		1.5			1.5		
26		1.5			1.4		
28		1.4			1.4		
30		1.3			1.3		
32		1.3			1.2		
34		1.2			1.2		
36		1.2			1.1		
38		1.1			1.1		
40		1.1			1.0		
42		1.0			1.0		
44		1.0			1.0		
46		1.0			1.0		
48		0.9			0.9		
50		0.9			0.9		
52		0.9			0.9		
54		0.9			0.9		
56		0.8			0.8		



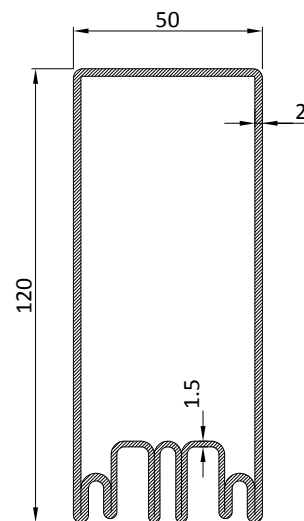
P.3605



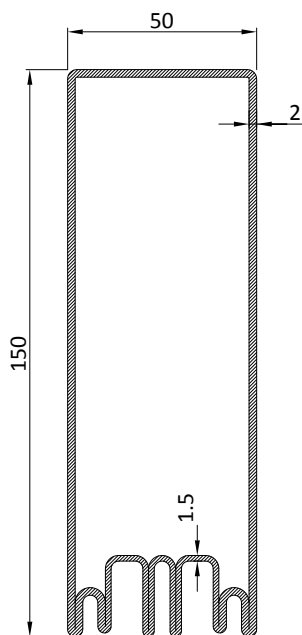
P.3608



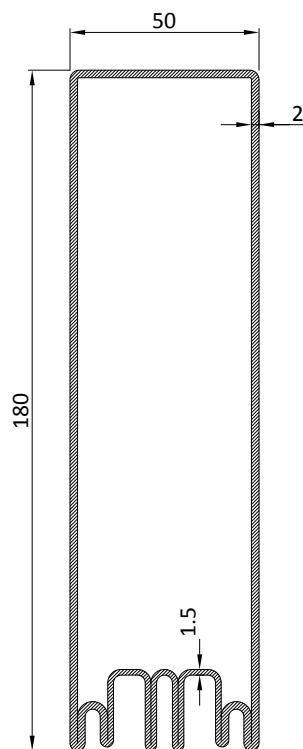
P.3610



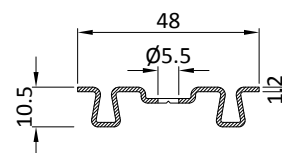
P.3612



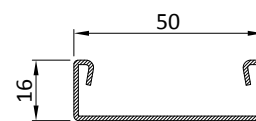
P.3615



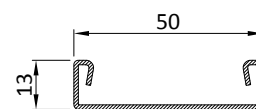
P.3618



P.3403

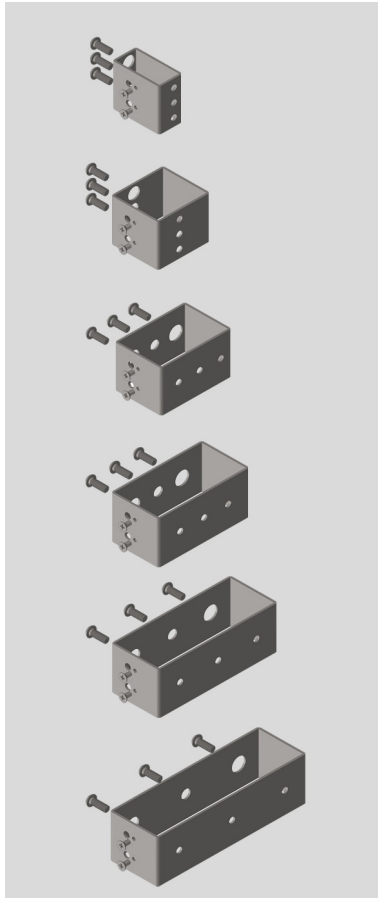


P.3406



P.3407

Profilo / Profile n°	P			A m ² /m	Jx cm ⁴	Jy cm ⁴	Wx cm ³	Wy cm ³	L		
	ZN / I	CT	OT						STD.	MIN.	MAX.
P.3605	4.70	4.70	---	0.20	16.04	18.24	5.55	7.30	6.6	3.0	8.0
P.3608	5.65	5.65	---	0.26	54.30	25.16	11.36	10.06	6.6	3.0	8.0
P.3610	6.28	6.28	---	0.30	96.51	29.77	16.14	11.91	6.6	3.0	8.0
P.3612	6.91	6.91	---	0.34	154.18	34.38	21.59	13.75	6.6	3.0	8.0
P.3615	7.85	7.85	---	0.40	273.46	41.30	30.70	16.52	6.6	3.0	8.0
P.3618	8.79	8.79	---	0.46	437.07	48.21	41.66	19.28	6.6	3.0	8.0
P.3403	0.74	---	---	---	---	---	---	---	6.6	---	---
P.3406	0.90	0.75	0.98	0.082	---	---	---	---	6.6	---	---
P.3407	0.85	0.71	0.92	0.076	---	---	---	---	6.6	---	---

**AC 36 .. I**

Cavallotti ad avvitare per
assieme traverso con
montante

*Screw-in assembling bracket
between mullion and transom*

AC3605I
traverso da 50 mm - P.3605
transom for 50 mm - P.3605

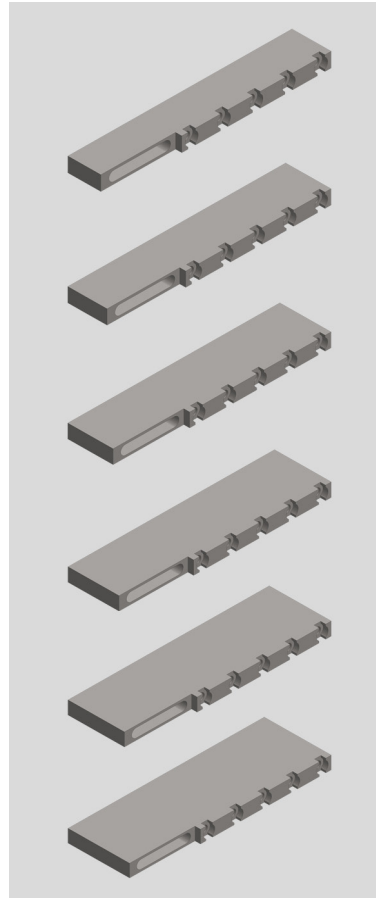
AC3608I
traverso da 80 mm - P.3608
transom for 80 mm - P.3608

AC3610I
traverso da 100 mm - P.3610
transom for 100 mm - P.3610

AC3612I
traverso da 120 mm - P.3612
transom for 120 mm - P.3612

AC3615I
traverso da 150 mm - P.3615
transom for 150 mm - P.3615

AC3618I
traverso da 180 mm - P.3618
transom for 180 mm - P.3618

**AC 36 ..**

Supporti vetro in PVC

Glazing supports in PVC

AC3620
vetri da 25 a 30 mm
glazing from 25 to 30 mm

AC3622
vetri da 31 a 36 mm
glazing from 31 to 36 mm

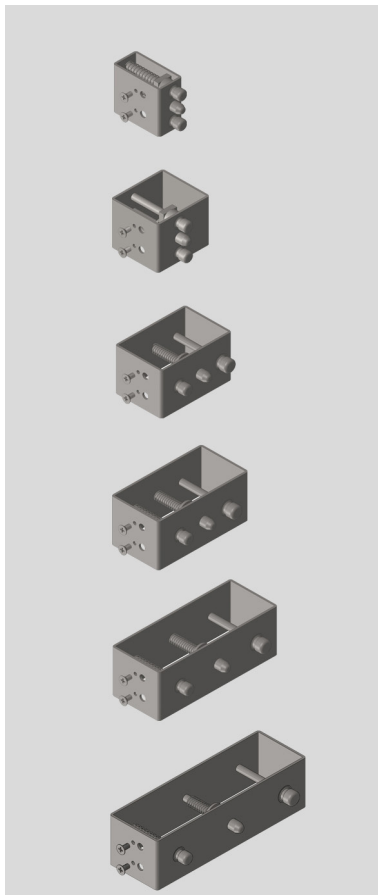
AC3624
vetri da 37 a 42 mm
glazing from 37 to 42 mm

AC3626
vetri da 43 a 48 mm
glazing from 43 to 48 mm

AC3628
vetri da 49 a 54 mm
glazing from 49 to 54 mm

AC3630
vetri da 55 a 56 mm
glazing from 55 to 56 mm

vedi tabella | see chart
3.2.2-3-4

**AC 36 .. IM**

Cavallotti a molla per
assieme traverso con
montante

*Spring assembling bracket
between mullion and transom*

AC3605IM
traverso da 50 mm - P.3605
transom for 50 mm - P.3605

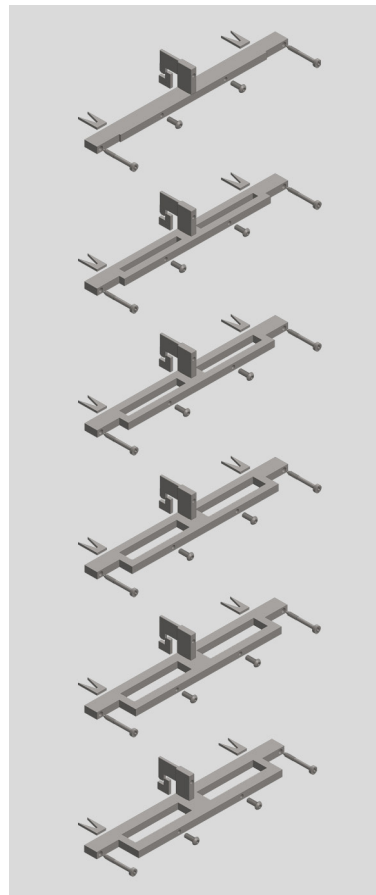
AC3608IM
traverso da 80 mm - P.3608
transom for 80 mm - P.3608

AC3610IM
traverso da 100 mm - P.3610
transom for 100 mm - P.3610

AC3612IM
traverso da 120 mm - P.3612
transom for 120 mm - P.3612

AC3615IM
traverso da 150 mm - P.3615
transom for 150 mm - P.3615

AC3618IM
traverso da 180 mm - P.3618
transom for 180 mm - P.3618

**AC 36 .. X**

Supporti vetro a "T" in acciaio
inox per vetri fino a 550 Kg

*T-shaped support in stainless
steel for glazing up to 550 kg*

AC3620X
vetri da 25 a 30 mm
glazing from 25 to 30 mm

AC3622X
vetri da 31 a 36 mm
glazing from 31 to 36 mm

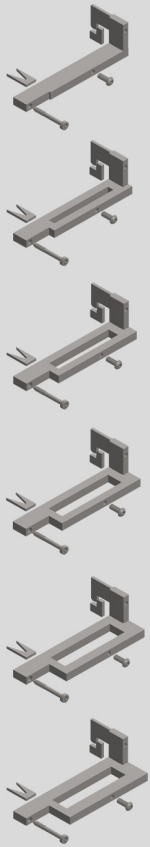
AC3624X
vetri da 37 a 42 mm
glazing from 37 to 42 mm

AC3626X
vetri da 43 a 48 mm
glazing from 43 to 48 mm

AC3628X
vetri da 49 a 54 mm
glazing from 49 to 54 mm

AC3630X
vetri da 55 a 56 mm
glazing from 55 to 56 mm

vedi tabella | see chart
3.2.2-3-4

**AC 362 . X D/S**

Supporti vetro a "L" in acciaio inox per vetri fino a 550 Kg

L-shaped support in stainless steel for glazing up to 550 kg

AC3620X D/S

vetri da 25 a 30 mm
glazing from 25 to 30 mm

AC3622X D/S

vetri da 31 a 36 mm
glazing from 31 to 36 mm

AC3624X D/S

vetri da 37 a 42 mm
glazing from 37 to 42 mm

AC3626X D/S

vetri da 43 a 48 mm
glazing from 43 to 48 mm

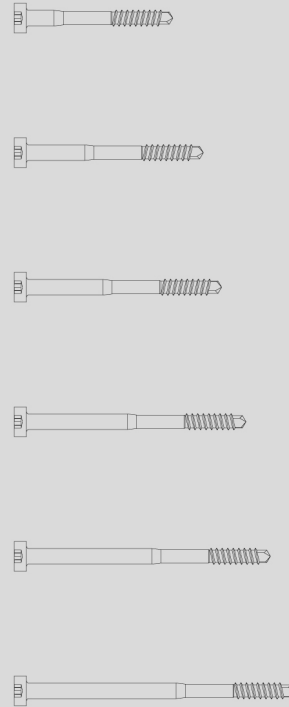
AC3628X D/S

vetri da 49 a 54 mm
glazing from 49 to 54 mm

AC3630X D/S

vetri da 55 a 56 mm
glazing from 55 to 56 mm

vedi tabella | see chart
3.2.2-3-4

**CV 36 .. I**

Vite autofilettante Ø5.5 mm in acciaio inox per fissaggio supporti vetro e profilo pressore P.3403 su montanti e traversi

Self-tapping screws of Ø5.5 mm in stainless steel for glazing supports and fixing profile P.3403 over mullion and transom

CV3648I
48 mm

CV3658I
58 mm

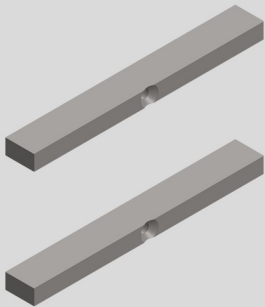
CV3664I
64 mm

CV3672I
72 mm

CV3680I
80 mm

CV3688I
88 mm

vedi tabella | see chart
3.2.7-8

**AC 3620R**

Rinforzo per incremento portata supporti vetro in PVC

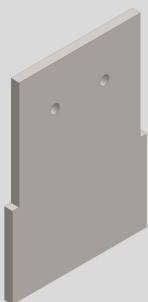
Reinforcement for incrementing load capacity of PVC glazing supports

vedi tabella | see chart
3.2.2-3-4

**CV 5403 I**

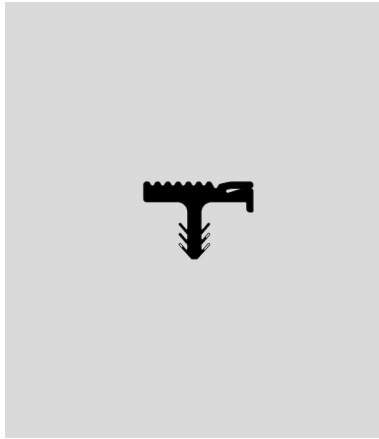
Rondella in acciaio inox/EPDM vulcanizzato per pressore P.3403

Stainless steel/vulcanised EPDM washer for fixing profile P.3403

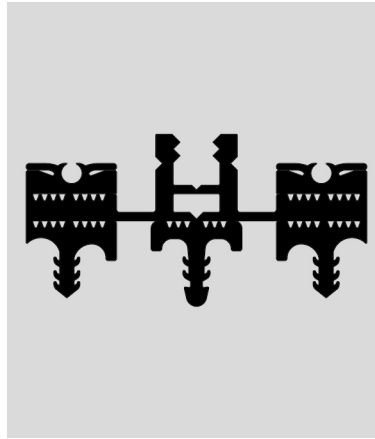
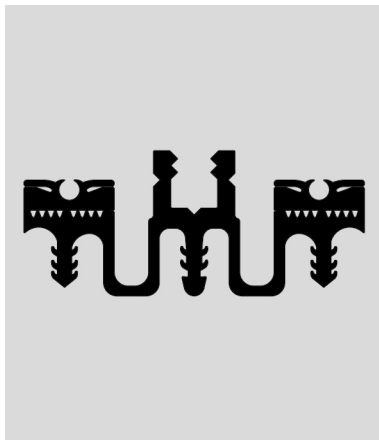
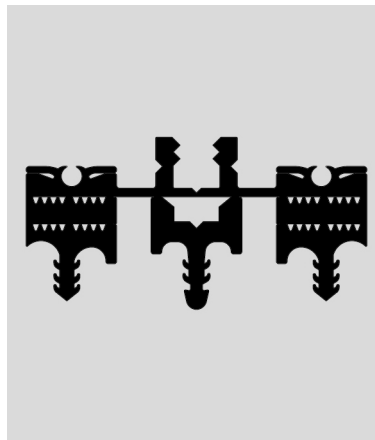
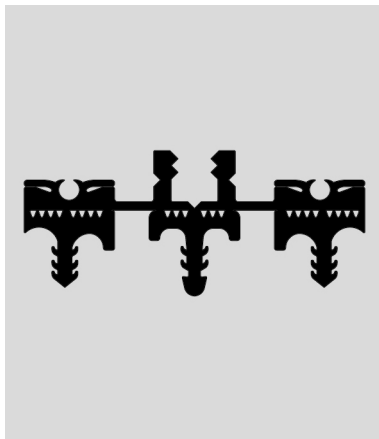
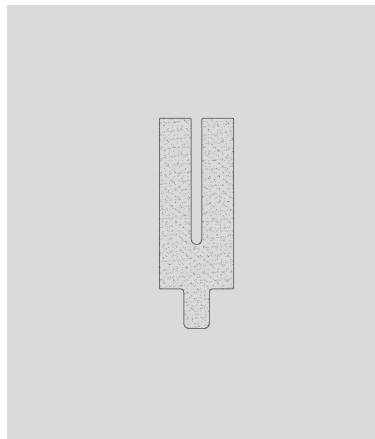
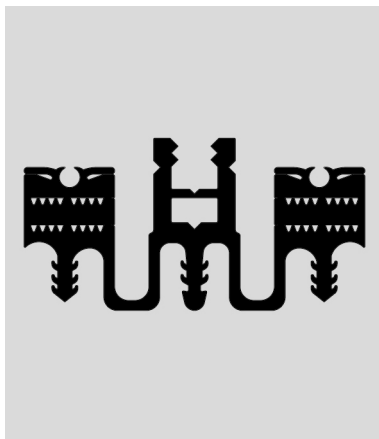
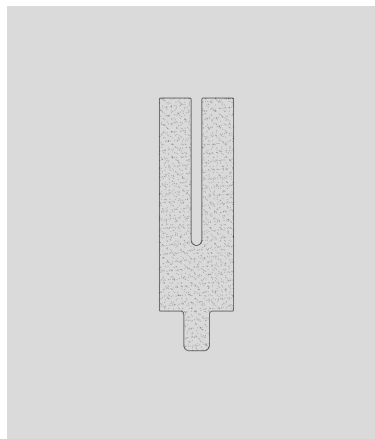
**AC 3632 I**

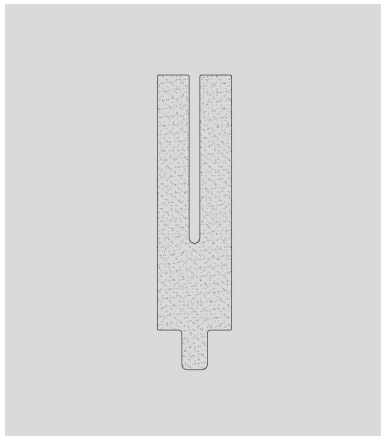
Piastra piede montante per applicazione guaina scarico acqua

Mullion bottom plate to fit drainage sheath

**GE 3602**

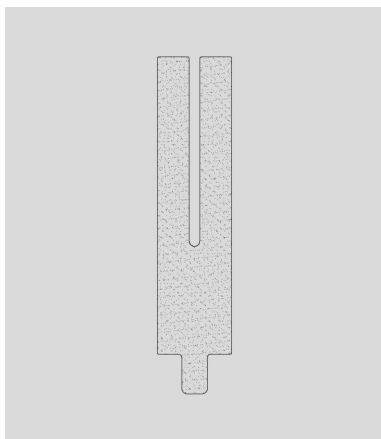
Guarnizione per pressione

Fixing profile gasket**GE 3622**Guarnizione a tre livelli per
traverso orizzontale*3-level gasket for horizontal
transom***GE 3611**Guarnizione a due livelli per
montante*2-level gasket for mullion***GE 3623**Guarnizione a tre livelli per
traverso verticale*3-level gasket for vertical
transom***GE 3612**Guarnizione a due livelli per
traverso*2-level gasket for transom***GE 3681**Schiumino estruso in
polietilene a cellule chiuse per
taglio termico
vetri da 25 a 32 mm*Extruded closed cells foam in
polyethylene for thermal break
glazing from 25 to 32 mm***GE 3621**Guarnizione a tre livelli per
montante*3-level gasket for mullion***GE 3682**Schiumino estruso in
polietilene a cellule chiuse per
taglio termico
vetri da 33 a 40 mm*Extruded closed cells foam in
polyethylene for thermal break
glazing from 33 to 40 mm*

**GE 3683**

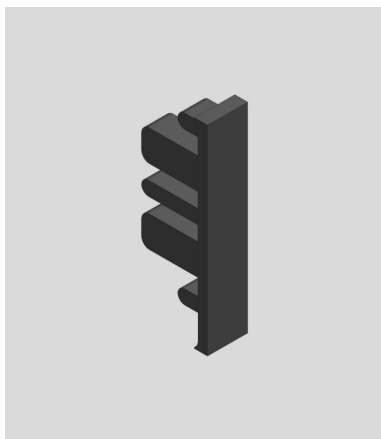
Schiumino estruso in polietilene a cellule chiuse per taglio termico vetri da 41 a 48 mm

Extruded closed cells foam in polyethylene for thermal break glazing from 41 to 48 mm

**GE 3684**

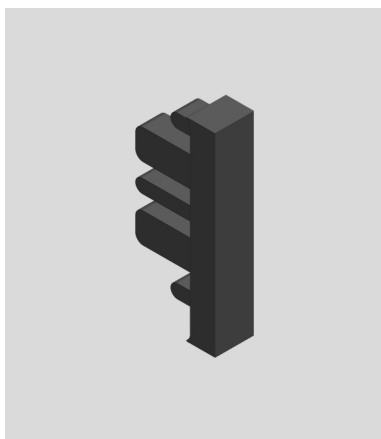
Schiumino estruso in polietilene a cellule chiuse per taglio termico vetri da 49 a 56 mm

Extruded closed cells foam in polyethylene for thermal break glazing from 49 to 56 mm

**GU 3612**

Fondogiunto per sigillatura teste trasversi con GE3612 e GE3622

Sealing cap for transom heads with GE3612 - GE3622

**GU 3623**

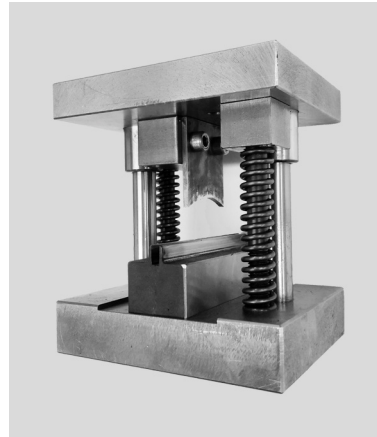
Fondogiunto per sigillatura teste trasversi con GE3623

Sealing cap for transom heads with GE3623

**AT 3601**

Maschera per esecuzione pre-fori per fissaggio fondini su montante

Pre-drilling jig for bracket assembling on mullion

**AT 3613**

Stampo per lavorazione su GE3611, GE3621 e GE3623, per applicazione supporti vetro a "T" ed "L"

Processing die for GE3611, GE3621 and GE3623 installing L/T-shaped glazing supports

**AT 3602**

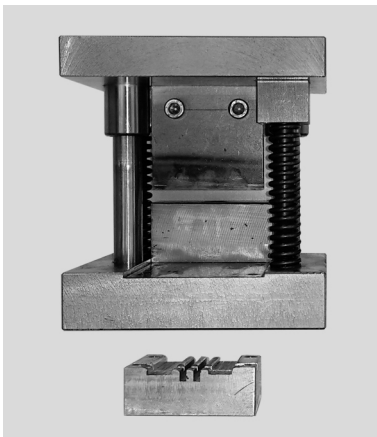
Maschera forature per installazione fondini su trasverso

Drilling jig for installing bracket assembling on transom

**AT 3614**

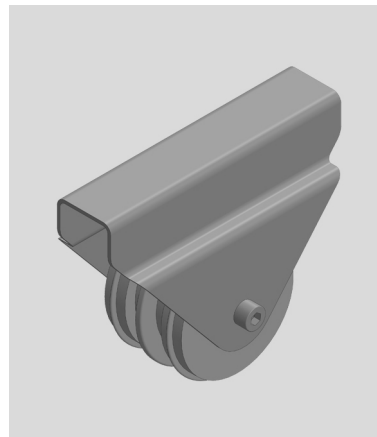
Maschera per lavorazione taglio su GE3611 e GE3622

Cutting processing jig for GE3611 and GE3622

**AT 3611**

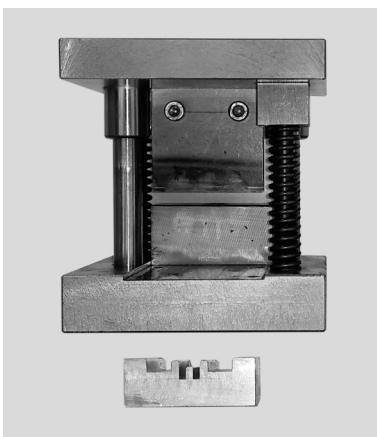
Stampo per lavorazione taglio piedini su GE3612 e GE3623

Cutting processing die for GE3612 and GE3623

**AT 3621**

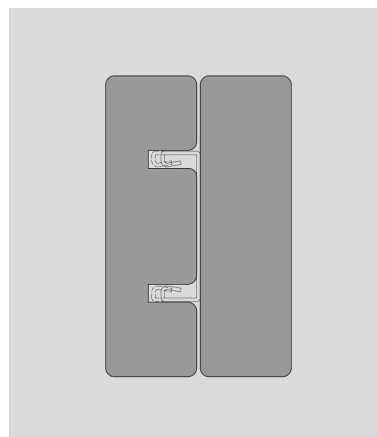
Rotella inserimento guarnizioni a 2 livelli GE3611-GE3612

Roller for 2-level gasket GE3611-GE3612

**AT 3612**

Stampo per lavorazione taglio piedini su GE3622

Cutting processing die for GE3622

**AT 5602**

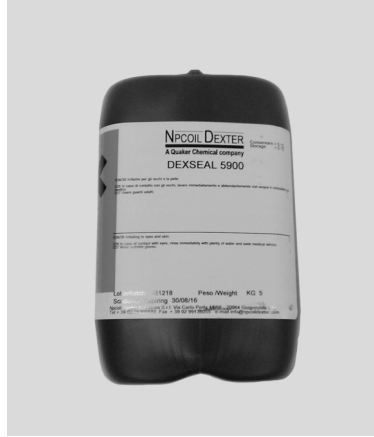
Coppia ganasce di taglio per profili P.3406 - P.3407

Cutting jaws for profiles P.3406 - P.3407

**SA 2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**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*

**SA 2002**

Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 3003**

Cera d'api per finitura corten

Beeswax for Corten finishing

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SL 0021**

Silicone nero per guarnizioni

Black silicone for gaskets

**SA 3001**

Acido per ossidazione corten

Oxidising acid for corten

Profili | Profiles• **Montanti | Mullions**

Riferirsi al dimensionamento indicato nelle tabelle a pag. 3.1.1 - 3.1.4, considerando come H montante la distanza massima tra i fissaggi sugli interpiani.

Refer to the dimensioning shows on charts 3.1.1 - 3.1.4, consider the maximum distance between interfloors fixings

In mancanza di informazioni, in generale:

If there are no informations, in general:

a. $L < 1500$ mm

- P.3612 per |for $H < 4000$ mm

- P.3618 per |for $H \geq 4000$ mm

b. $L \geq 1500$ mm

- P.3612 per |for $H < 3500$ mm

- P.3618 per |for $H \geq 3500$ mm

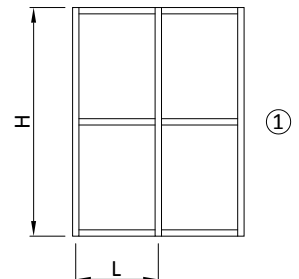
• **Traversi | Transoms**

- Utilizzare profili più piccoli o uguali ai profili montanti

Use smaller profiles or at most equal to the mullions profiles

- Solitamente i terminali inferiori e superiori della facciata sono costruiti con gli stessi profili dei montanti

Usually the bottom and top transom are the same profiles of mullions

**Guarnizioni | Weather strips**

Riferirsi alle pagine 3.3.1 e 3.3.2 | *Refer to pages 3.3.1 and 3.3.2*

a. Facciate standard montanti e traversi tipo 1 | *Standard curtain walls with mullions and transoms type 1*

- GE3611 per montanti | *GE3611 for mullion*

- GE3612 per traversi | *GE3612 for transoms*

- GU3612 n° 2 per ogni traverso | *GU3612 n° 2 for every transom*

b. Facciate con traversi verticali tipo 2 | *Curtain walls with vertical transoms type 2*

- GE3621 per montanti | *GE3621 for mullions*

- GE3622 per traversi | *GE3622 for transoms*

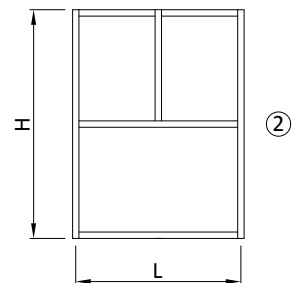
- GE3623 per traversi verticali | *GE3623 for vertical transoms*

- GU3612 n° 2 per ogni traverso orizzontale tranne che per i traversi superiori spezzati dal traverso verticale | *GU3612 n° 2 for every transom except for top transoms that are interrupted by vertical ones*

- GU3623 n° 1 per ogni traverso verticale | *GU3623 n° 1 for every vertical transom*

- GE3602 n° 2 metri per ogni metro P.3403 | *GE3602 n° 2 meters for every meter of P.3403*

- GE3681-84 stessi metri profili montanti e traversi (dimensione accessorio da valutare in base a tabella pag. 3.2.6) | *GE3681-84 same length of mullion and transom profiles (the dimension of this insulator profile has to be evaluated in reference to charts on pag. 3.2.6)*

**Accessori | Hardwares**• **Cavallotti di giunzione traverso-montante | connection devices for transom**

- n° 2 cavallotti per ogni traverso | *n° 2 devices for every transom*

Riferirsi alle indicazioni di pag 3.2.1 per il giusto abbinamento del fondino al profilo traverso | *Refer to page 3.2.1 for the combination of the right devices with the transom*

• **Supporti vetro | Glass supports**

Riferirsi alla tabella a pagina 3.2.2 | *Refer to the charts on page 3.2.2*

- n° 2 supporti per ogni vetro o pannello | *n° 2 glass supports for every glass or panel*

- Viti per supporti vetro n° 3 per supporto

In mancanza di informazioni riguardanti lo spessore del vetro scegliere un supporto per vetri di medio spessore AC3622 o AC3624 | *Without informations about the glass thickness choose a glass support for medium glass thickness i.e. AC3622 or AC3624*

Fare riferimento alle tabelle nelle pagine 3.2.2 - 3.2.4 per indicazioni sulla portata dei supporti

For informations about the carrying capacity refers to pages 3.2.2 - 3.2.4

• **Viti pressore P.3403 | Screws for P.3403**

Fare riferimento alle tabelle di pagina 3.2.8 | *Refers to the charts on page 3.2.8*

- n° 3 per ogni metro di profilo | *n° 3 screws for each meter of profile*

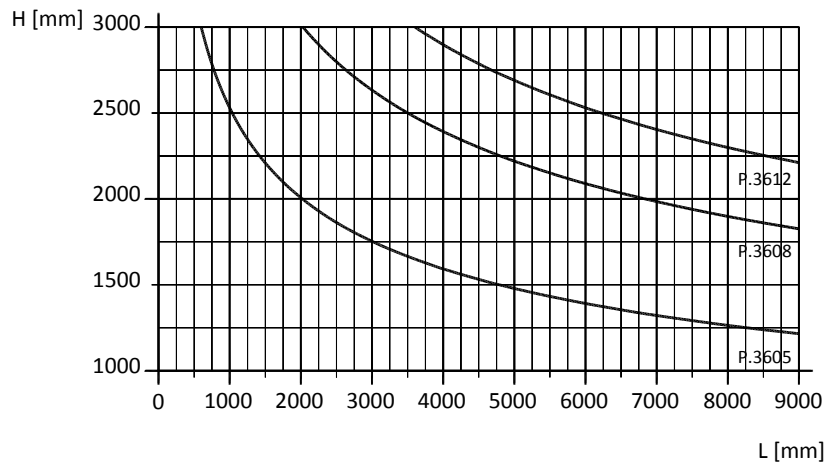
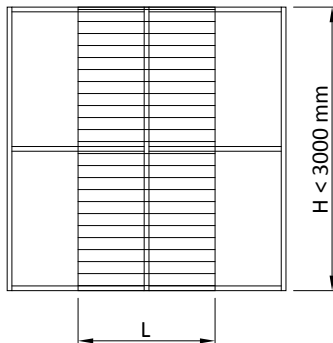
In mancanza di informazioni sullo spessore dei vetri utilizzare una vite per uno spessore vetro medio di 40 mm es. CV36721

Without any information about glass thickness use a screw for a middle glass thickness i.e. CV36721

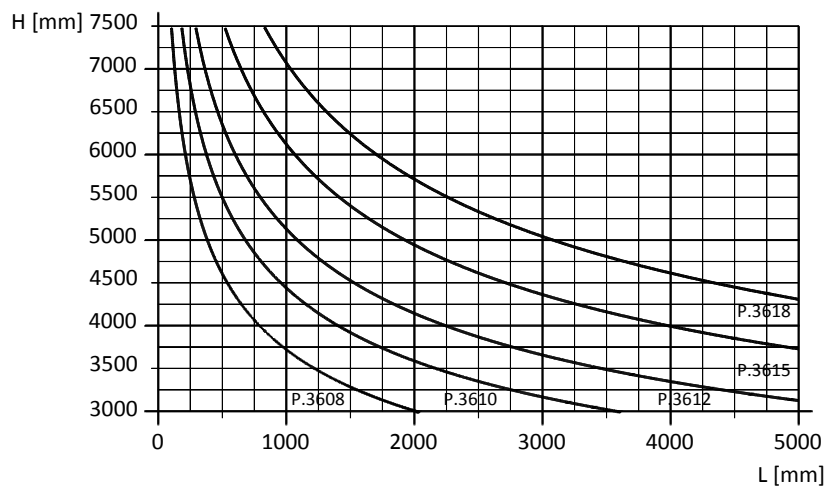
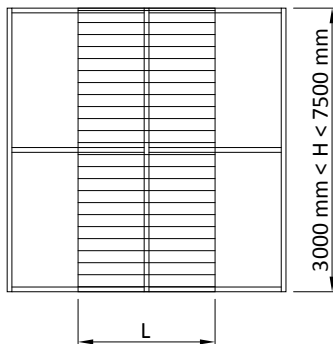
I grafici qui riportati danno un valore approssimativo dei limiti di utilizzo dei profilati. La facciata deve essere in ogni caso dimensionata dal progettista incaricato a eseguire le verifiche strutturali e di sicurezza dell'opera.

The graphs below gives an approximate value about the application limits of the profiles. However curtain wall must be custom sized by the person responsible for the structural and asfety measures

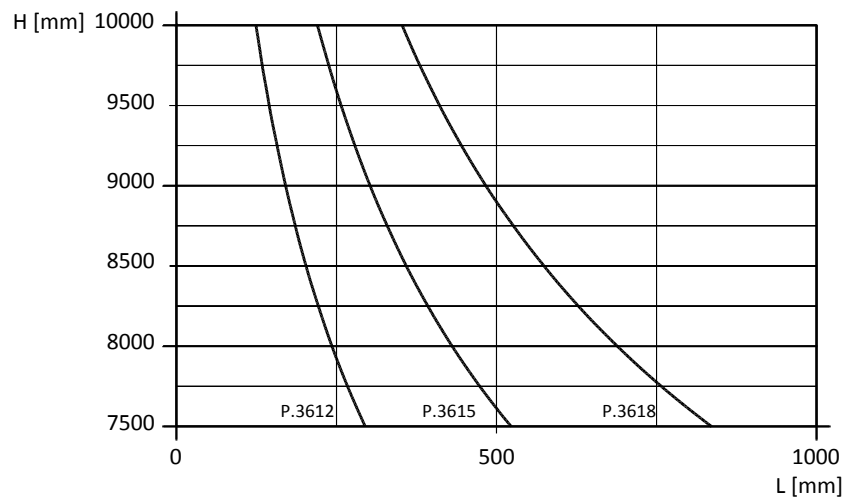
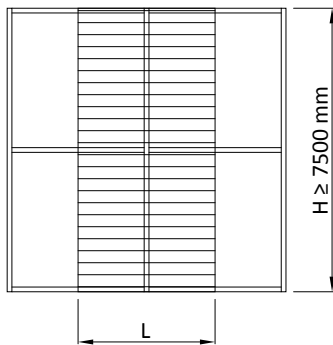
$$f_{max} = \frac{H}{200}$$



$$f_{max} = 5 \text{ mm} + \frac{H}{300}$$



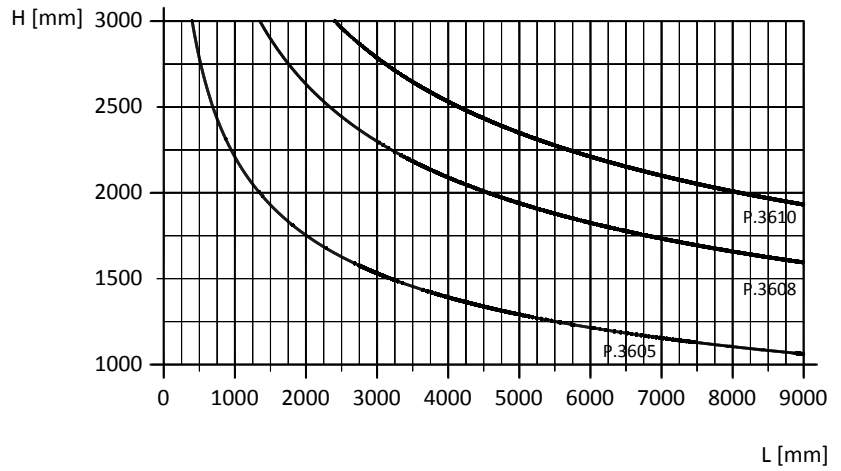
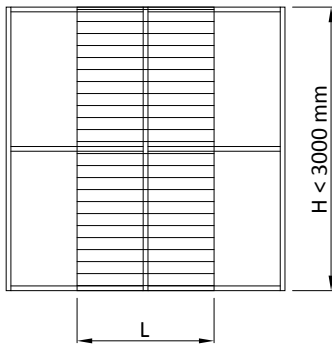
$$f_{max} = \frac{H}{250}$$



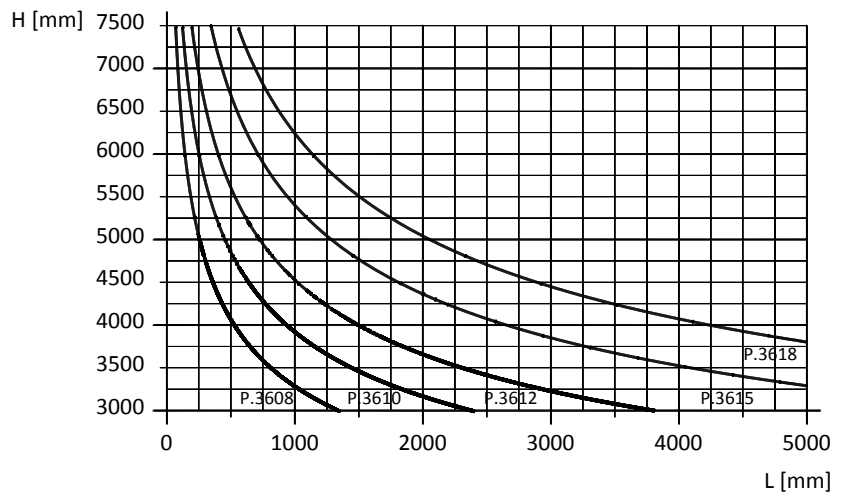
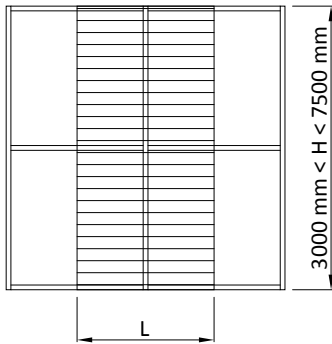
NB: passo griglia 250 mm
NOTE: grid step 250 mm



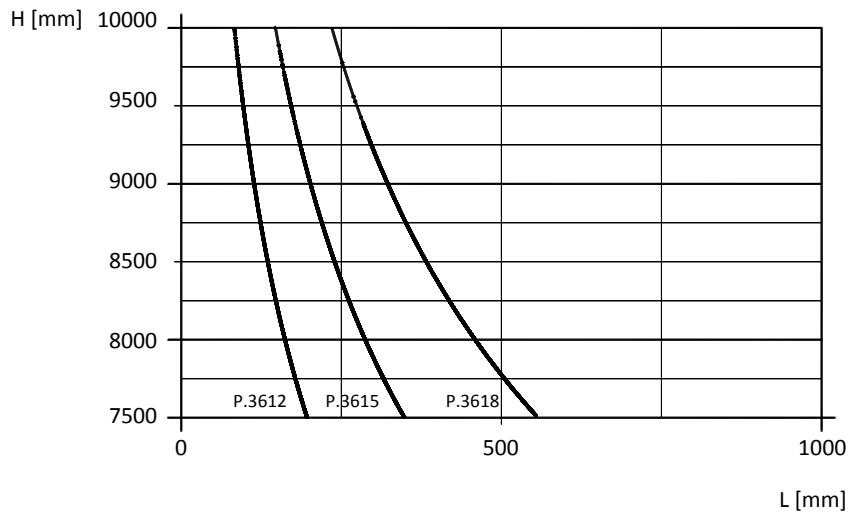
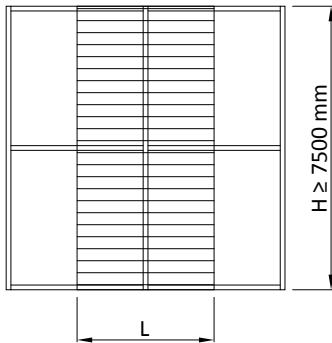
$$f_{max} = \frac{H}{200}$$



$$f_{max} = 5 \text{ mm} + \frac{H}{300}$$



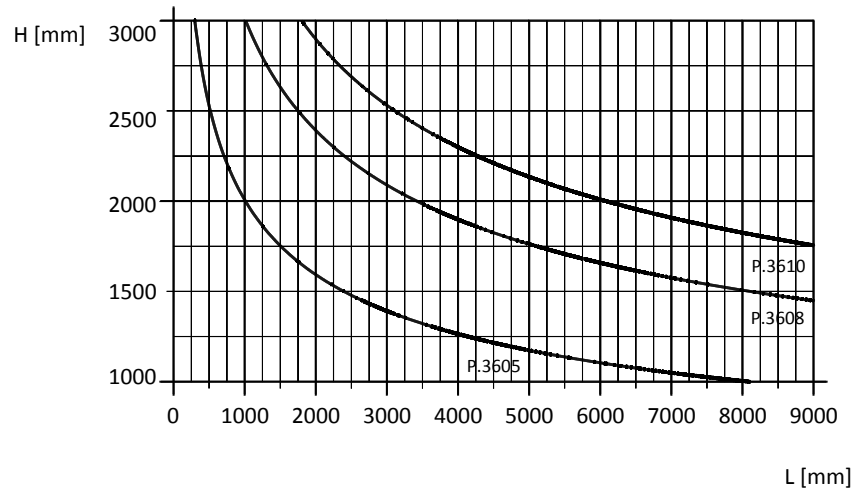
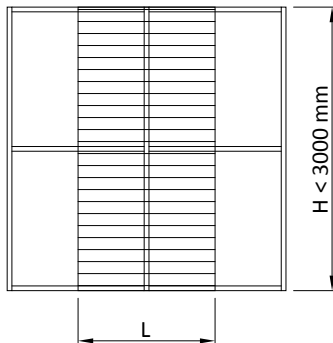
$$f_{max} = \frac{H}{250}$$



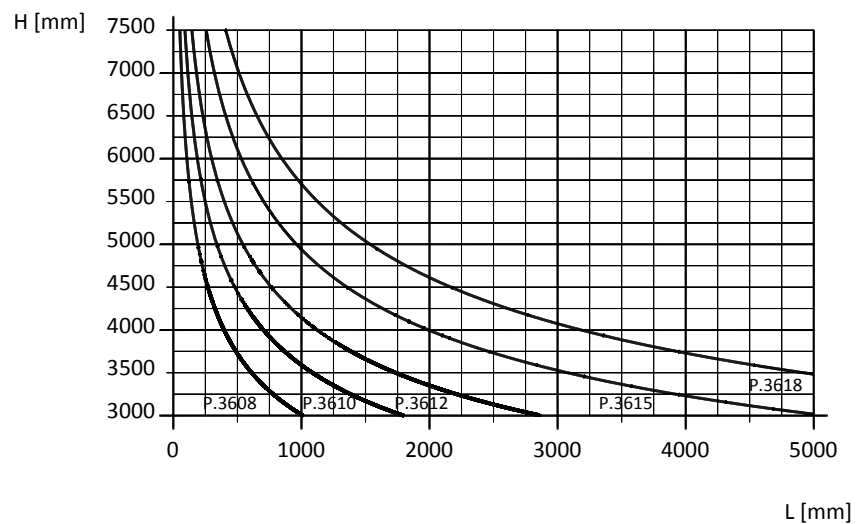
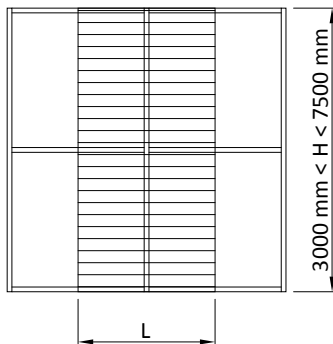
NB: passo griglia 250 mm
NOTE: gird step 250 mm



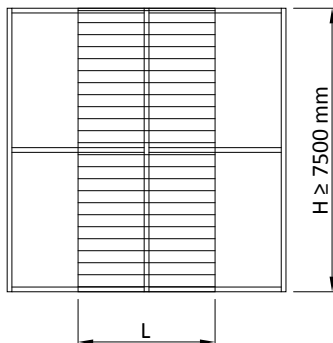
$$f_{max} = \frac{H}{200}$$



$$f_{max} = 5 \text{ mm} + \frac{H}{300}$$



$$f_{max} = \frac{H}{250}$$



Per un carico di progetto di 1600 Pa o superiore non è possibile realizzare specchiature più alte di 7500 mm, senza rinforzare i profili
 For a 1600 Pa wind load or more it is not possible to realize curtain walls with $H > 7500 \text{ mm}$, without a reinforcement in the profiles

NB: passo griglia 250 mm
 NOTE: grid step 250 mm



Esempio: | *Example:*

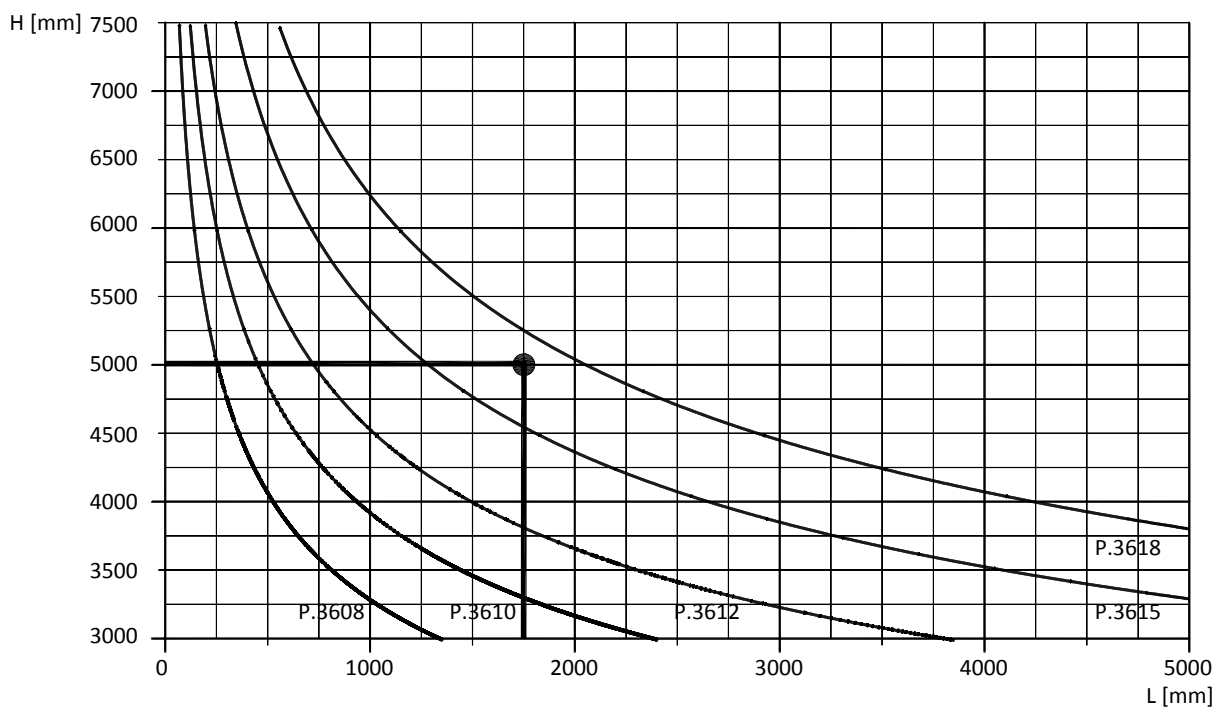
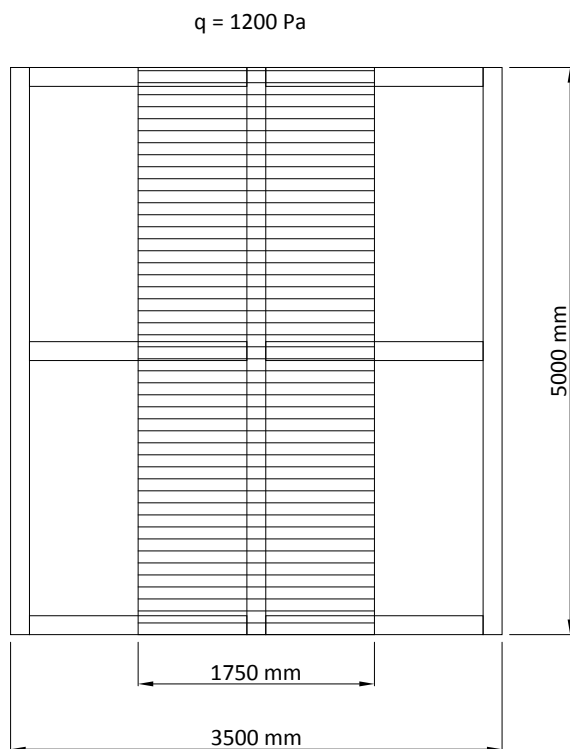
Facciata 3500 mm x 5000 mm | *Curtain wall 3500 mm x 5000 mm*

Carico del vento $q = 1200$ Pa | *Wind load $q = 1200$ Pa*

Larghezza di interesse per la spinta del vento $L_q = 1750$ mm | *Wind load Width $L_q = 1750$ mm*

Range di flessione massima ammissibile $f \leq H/300 + 5$ mm | *Maximum flexion range allowed $f \leq H/300 + 5$ mm*

Profilo montante utilizzabile: P.3618 | *Profile to use: P.3618*



NB: passo griglia 250 mm

NOTE: gird step 250 mm

Nel grafico che segue si vuole dare una guida per poter scegliere i profili traversi sottoposti a carico verticale. E' necessario valutare la combinazione del peso proprio sommato al peso portato, in modo da utilizzare il profilo traverso più opportuno all'applicazione richiesta.

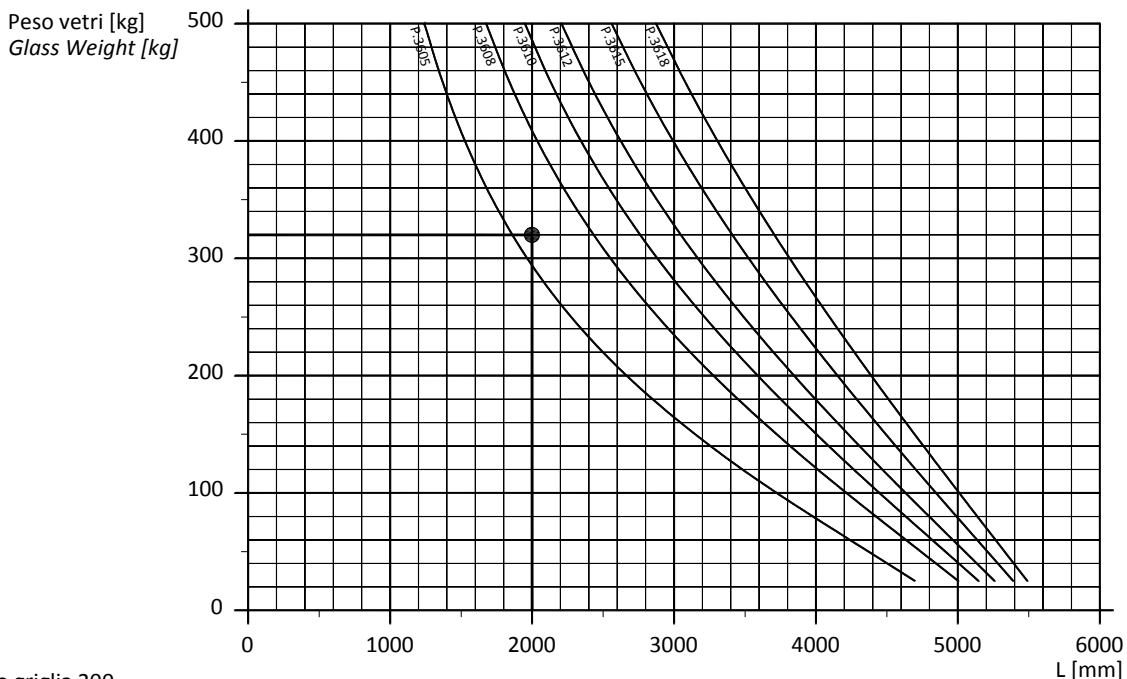
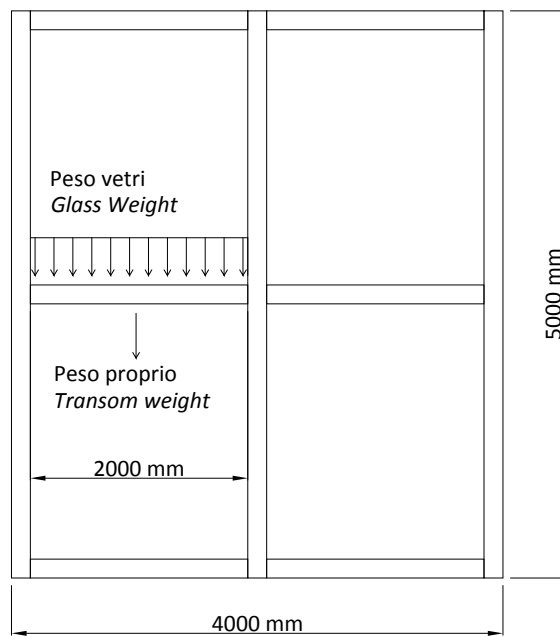
Secondo norma la flessione del traverso non deve superare $\frac{1}{500}$ mm della sua lunghezza.

In the graph below there is a guideline for choosing the profiles subjected to vertical load. It is necessary to evaluate the combination of the transom weight and the glass weight, in order to use the best profile as function of the application.

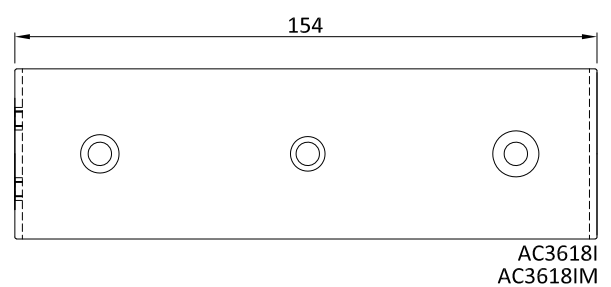
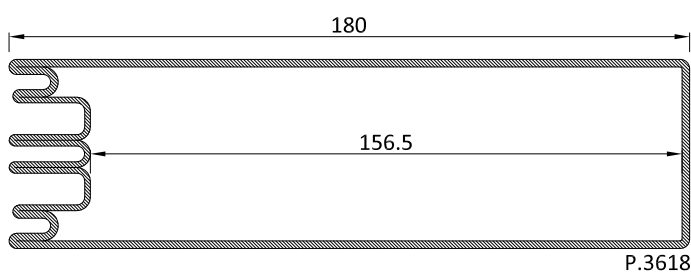
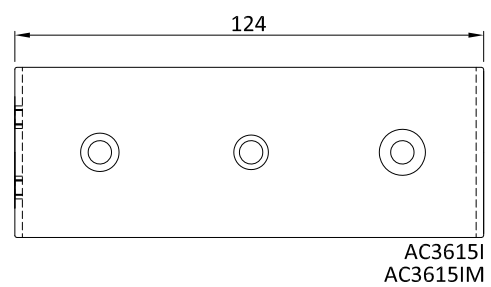
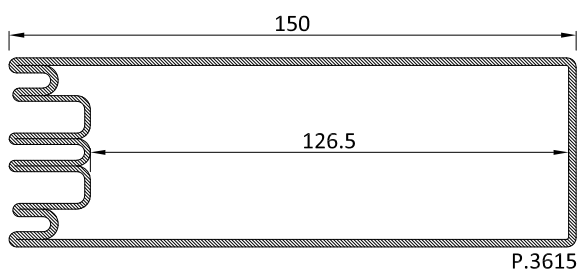
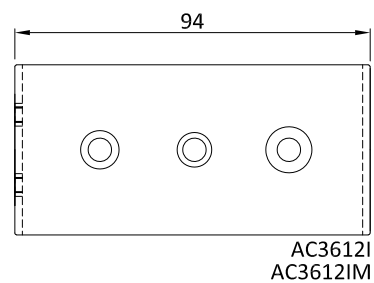
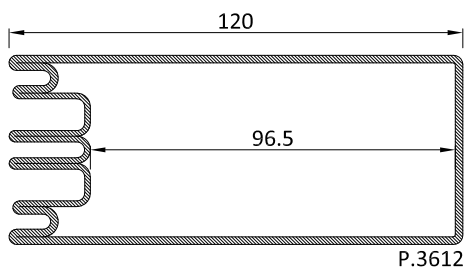
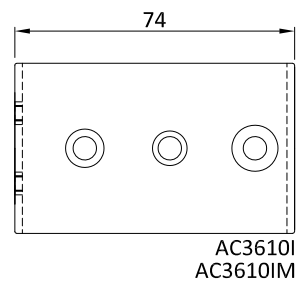
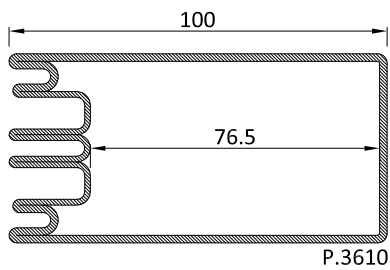
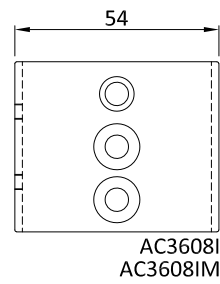
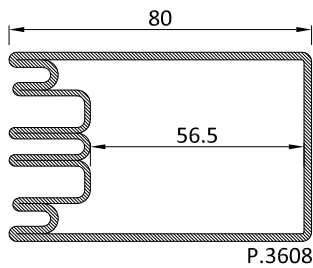
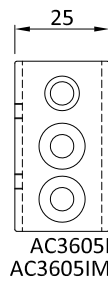
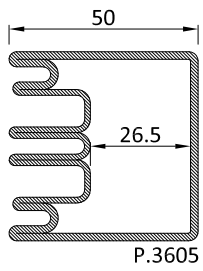
Maximun flexion allowed to the transom must be under $\frac{1}{500}$ mm of its lenght.

Esempio:
L traverso = 2000 mm
Peso vetro = 320 kg
Profilo più piccolo utilizzabile = P.3608

Example:
L transom = 2000 mm
Glass Weight = 320 kg
Smaller profile to use = P.3608



NB: passo griglia 200
NOTE: grid step 200



Nel grafico che segue viene data un'indicazione della portata massima ammessa dai supporti vetro, in relazione allo spessore del vetro scelto.
In the graph below there is an indication about the carrying capacity of the glass supports, as function as glass thickness

Per scegliere la più adeguata tipologia di applicazione di supporto vetro, incrociare il valore di spessore vetro di progetto, con il suo peso.
Interpolate the value of the glass thickness with its weight to choose the best kind of glass support, as function as the application they are subjected.

Esempio:

Vetrocamera 5+5.1/16/4+4.1 = 35 mm ca.

Dimensioni 1500 mm x 2800 mm

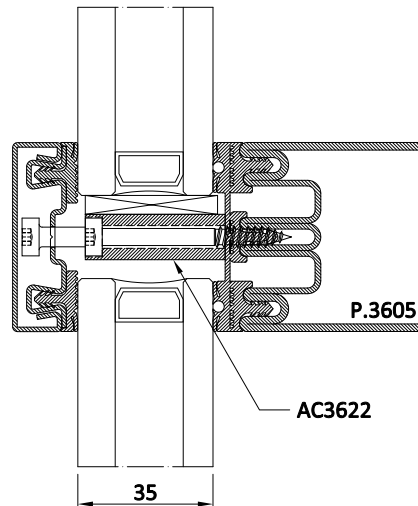
Peso 190 kg ca.

Example:

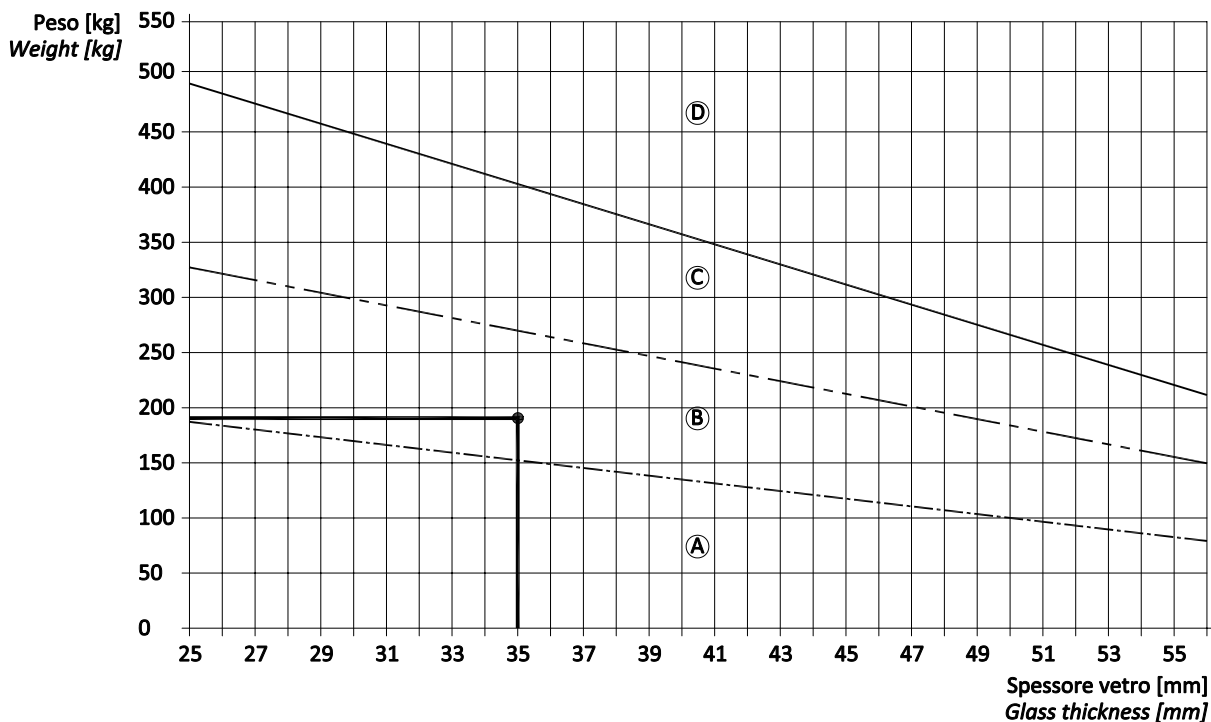
Glazing: 5+5.1/16/4+4.1 = 35 mm

Dimensions: 1500 x 2800 mm

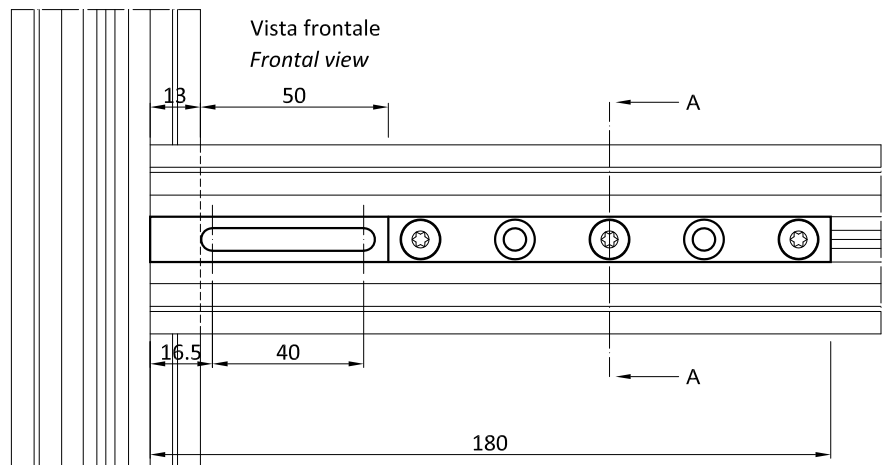
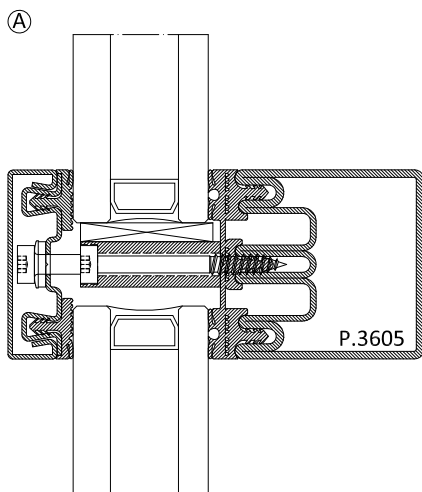
Weight: 190 kg ca.



- (A) - - - - - 3 viti | 3 screws
 (B) - · - - - - 3 viti e 2 rinforzi | 3 screws and 2 reinforcement
 (C) ——— 3 viti e 2 rinforzi saldati | 3 screws and 2 welded reinforcement
 (D) Supporti vetro serie AC36..X - AC36..X D/S | Glass supports AC36..X - AC36..X D/S series

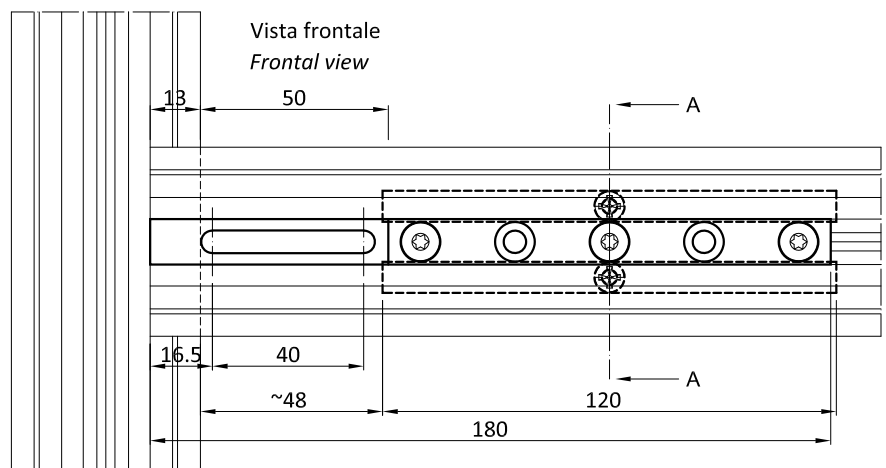
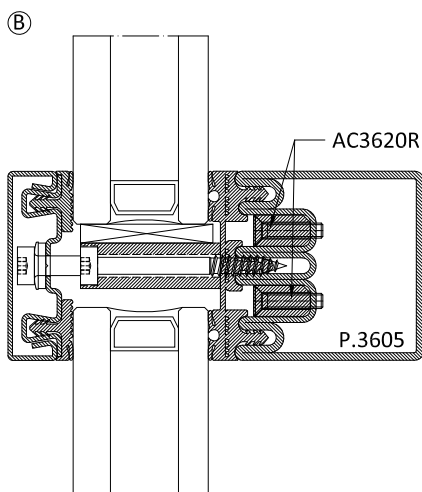


NB.: Flessione massima considerata del supporto vetro = 3 mm
 NOTE: Max. flexion considered of the glass support = 3 mm



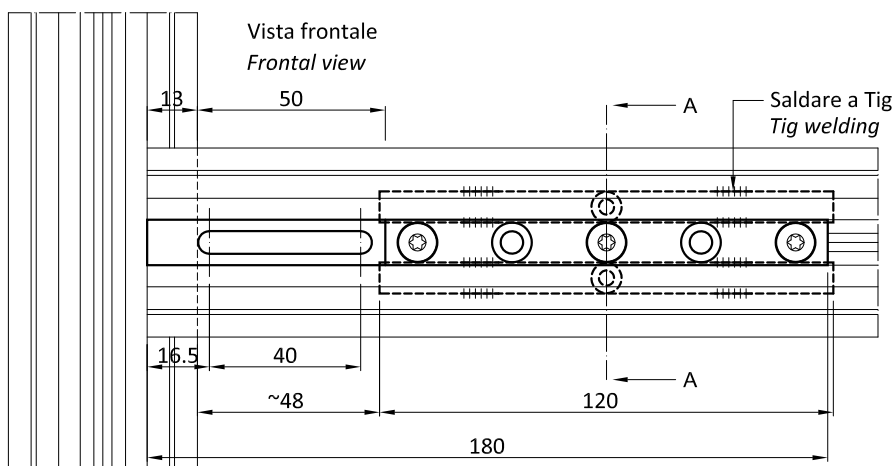
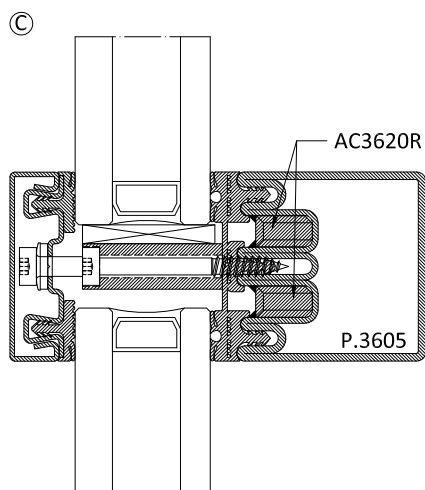
Spessore vetro Glass thickness	Max. peso vetro Max. glass weight
fino a 25 mm	200 kg
da 25 a 35 mm	150 kg
da 35 a 45 mm	120 kg
da 45 a 56 mm	90 kg

Portata supporto vetro con 3 viti
Glass support carrying capacity with 3 screws



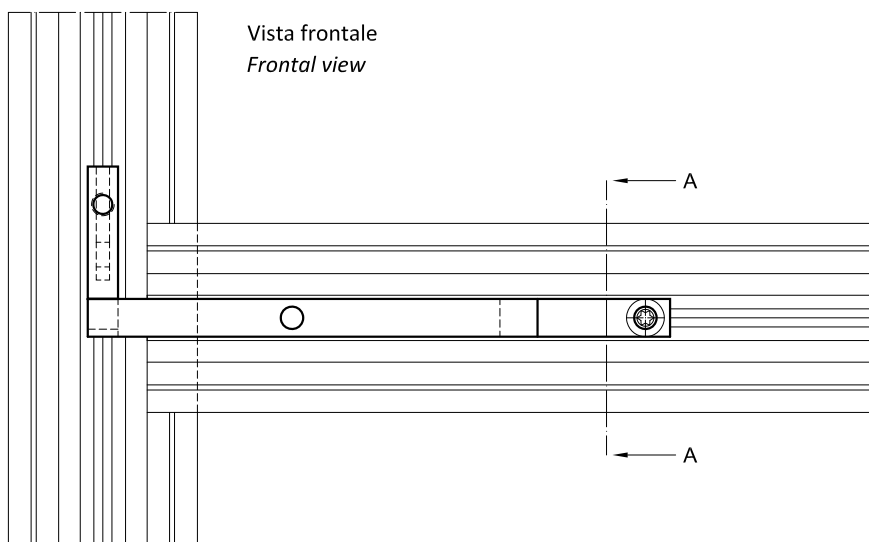
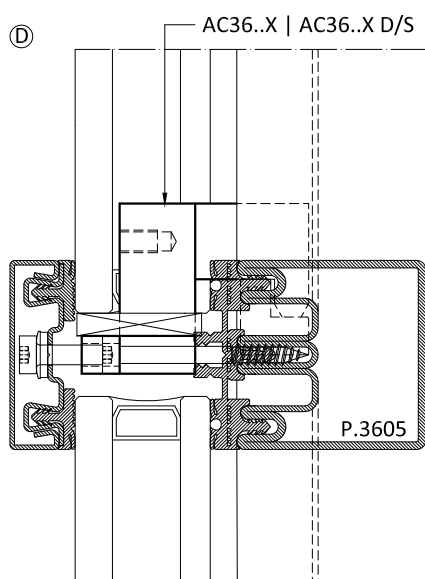
Spessore vetro Glass thickness	Max. peso vetro Max. glass weight
fino a 25 mm	320 kg
da 25 a 35 mm	280 kg
da 35 a 45 mm	200 kg
da 45 a 56 mm	150 kg

Portata supporto vetro con 3 viti e 2 rinforzi AC3620R
Glass support carrying capacity with 3 screws and two reinforcements



Spessore vetro Glass thickness	Max. peso vetro Max. glass weight
fino a 25 mm	500 kg
da 25 a 35 mm	400 kg
da 35 a 45 mm	300 kg
da 45 a 56 mm	220 kg

Portata supporto vetro con 3 viti e 2 rinforzi AC3620R saldati
Glass support carrying capacity with 3 screws and one reinforcement
joined by welding on profile

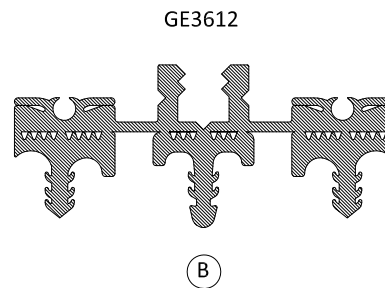
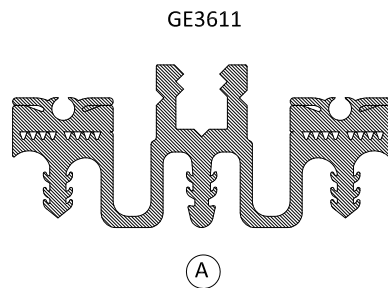
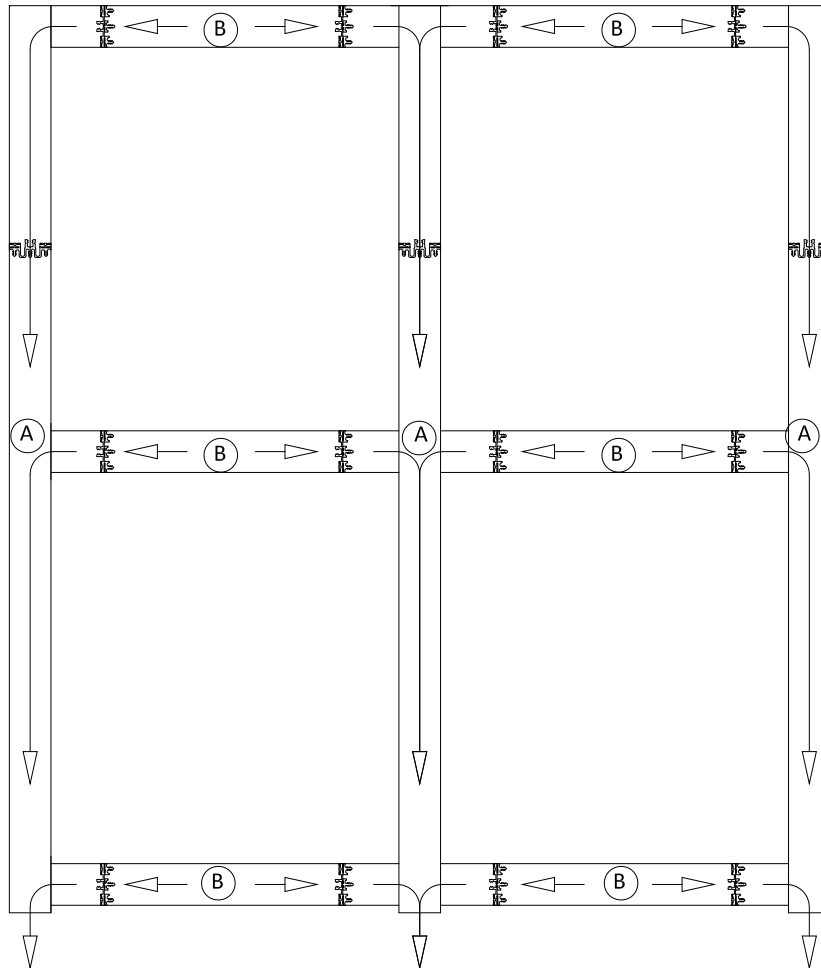


Spessore vetro Glass thickness	Max. peso vetro Max. glass weight
fino a 25 mm	550 kg
da 25 a 35 mm	
da 35 a 45 mm	
da 45 a 56 mm	

Portata supporto vetro serie X: fino a 550 kg
Carrying capacity of X series glass supports : 550 kg

1 Soluzioni standard
Standard solutions

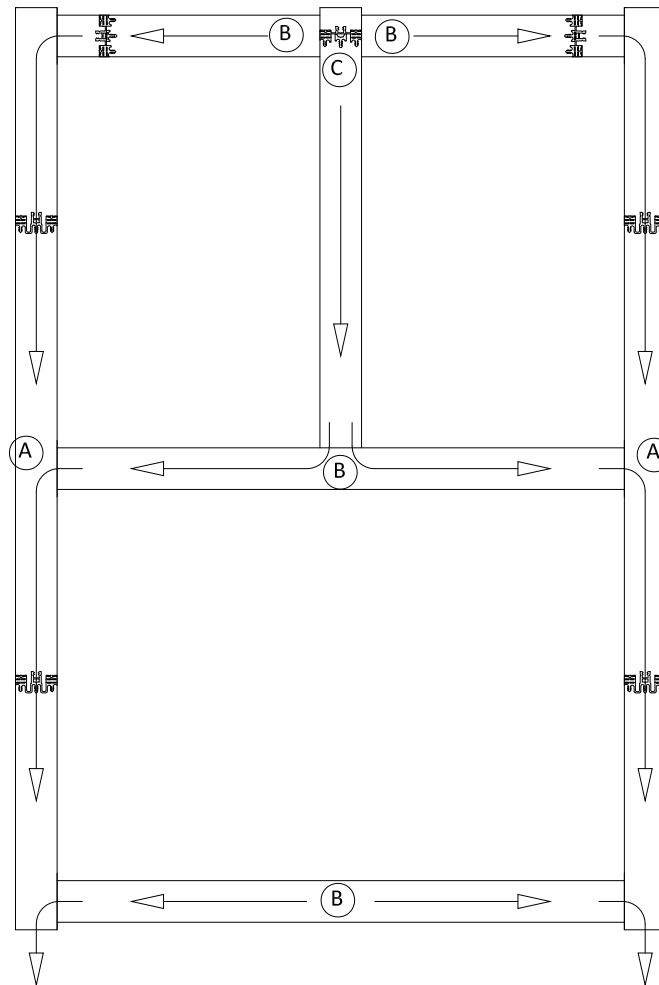
←
Deflusso acqua
Water flow



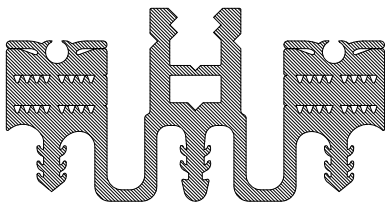
2

Soluzioni con traverso verticale
Vertical transon solutions

←
Deflusso acqua
Water flow

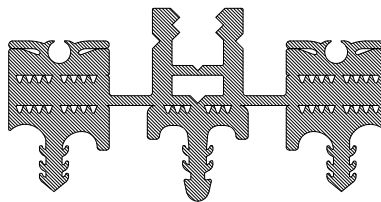


GE3621



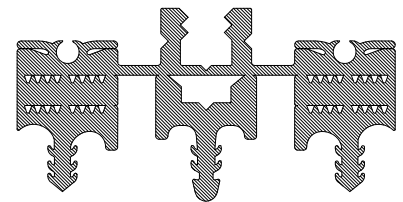
A

GE3622

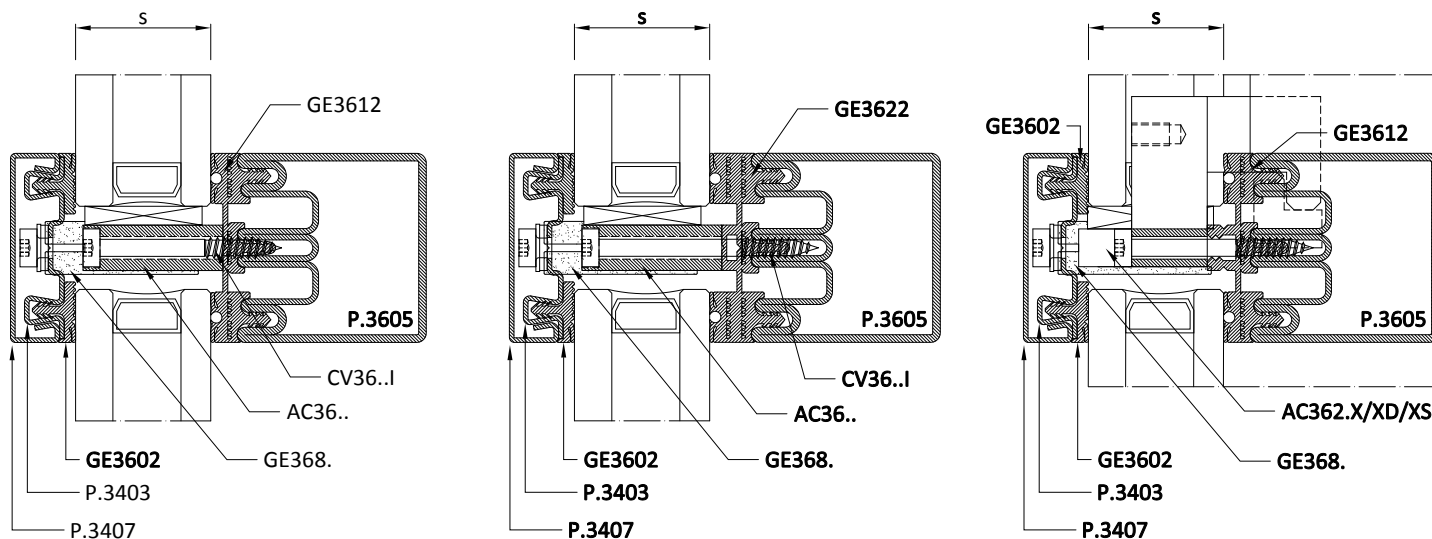


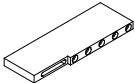
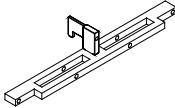
B

GE3623





C

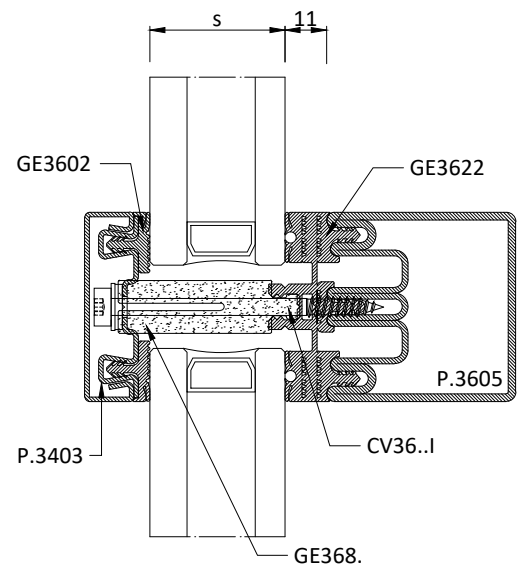
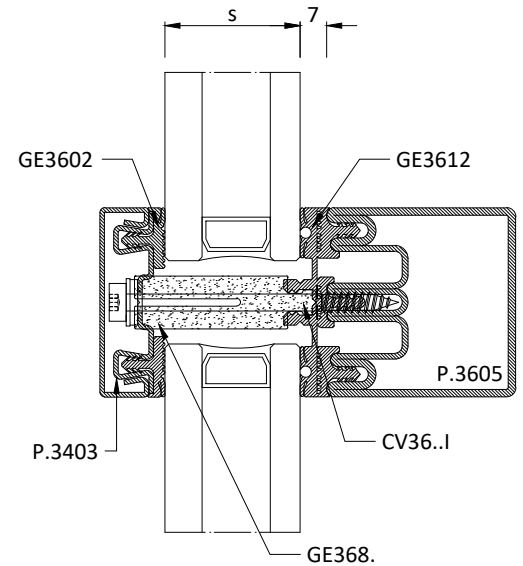


s [mm]					
	Cod.	Viti con - Screws with GE3612	Viti con - Screws with GE3622	Cod.	Cod.
25	AC3620	CV3648I	CV3648I	AC3620X/XD/XS	GE3681
26					
27					
28					
29					
30	AC3622	CV3648I	CV3658I	AC3622X/XD/XS	GE3682
31					
32					
33					
34					
35					
36	AC3624	CV3658I	CV3664I	AC3624X/XD/XS	GE3683
37					
38					
39					
40					
41					
42	AC3626	CV3664I	CV3664I	AC3626X/XD/XS	GE3684
43					
44					
45					
46					
47					
48	AC3628	CV3672I	CV3672I	AC3628X/XD/XS	GE3684
49					
50					
51					
52					
53					
54	AC3630	CV3680I	CV3680I	AC3630X/XD/XS	GE3684
55					
56					

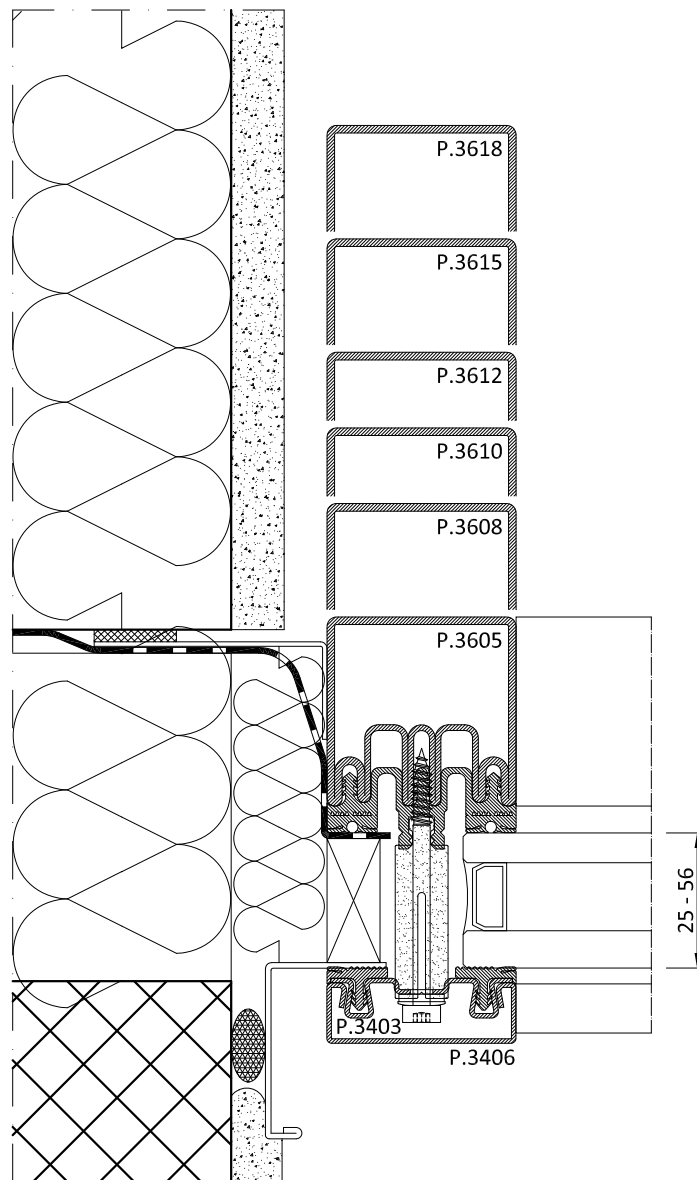
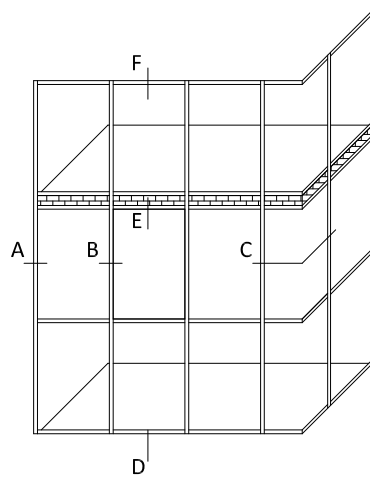
In questa tabella vengono indicate le viti da utilizzare per il fissaggio del profilo pressore, in base allo spessore del vetro scelto e allo spessore della guarnizione prevista

In this table there are indications about screws usage for the external fixing profile, according to glass thickness and weather strip thickness

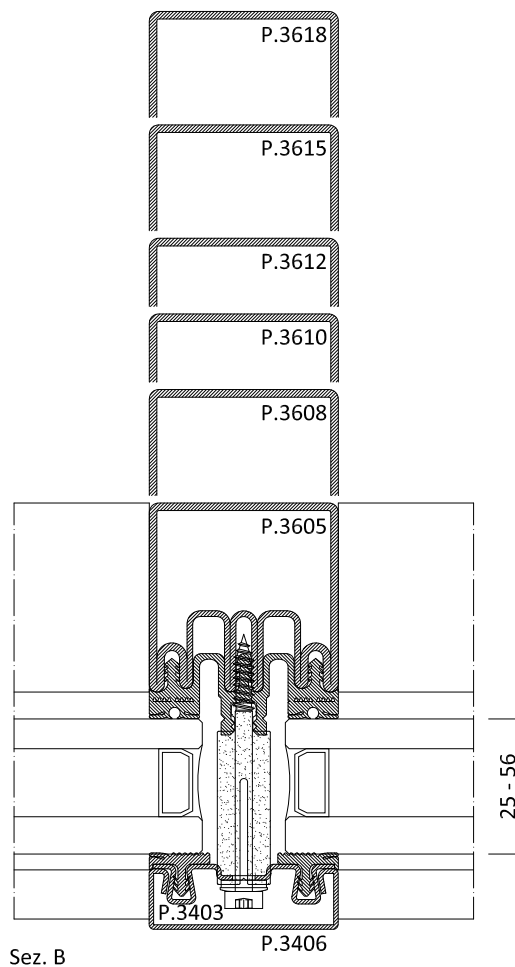
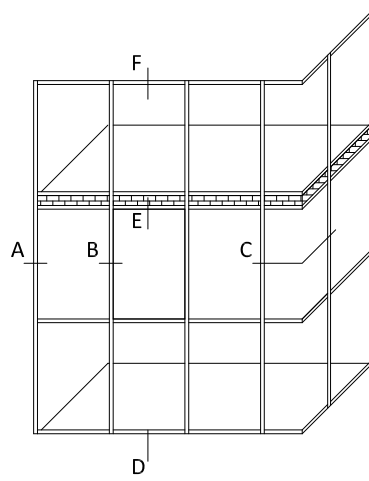
s [mm]	Viti con - Screws with GE3611 - GE3612		s [mm]	Viti con - Screws with GE3621 - GE3622 - GE3623	
25	CV3658I		25	CV3664I	CV5403I
26			26		CV5403I
27			27		
28			28		
29	CV3664I	CV5403I	29	CV3672I	
30		CV5403I	30		
31			31		CV5403I
32			32		CV5403I
33			33	CV5403I	
34			34	CV5403I	
35	CV3672I	CV5403I	35	CV3672I	
36		CV5403I	36		
37		CV5403I	37		
38		CV5403I	38		
39			39	CV3680I	CV5403I
40			40		CV5403I
41			41		CV5403I
42			42		CV5403I
43	CV3680I	CV5403I	43	CV3680I	
44		CV5403I	44		
45		CV5403I	45		
46		CV5403I	46		
47			47	CV3688I	CV5403I
48			48		CV5403I
49			49		CV5403I
50			50		CV5403I
51	CV3688I	CV5403I	51	CV3688I	
52		CV5403I	52		
53		CV5403I	53		
54		CV5403I	54		
55			55		
56			56		

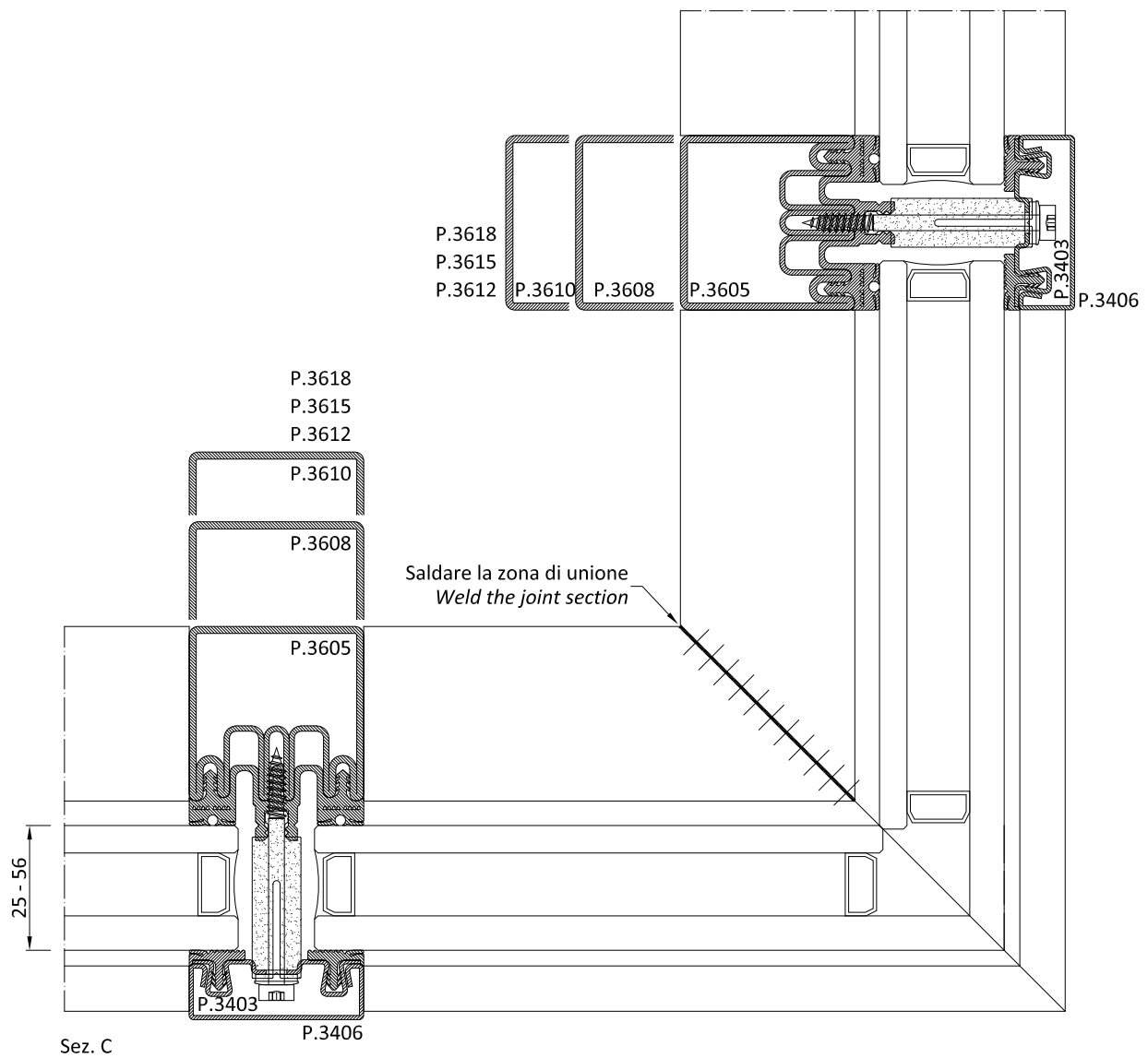
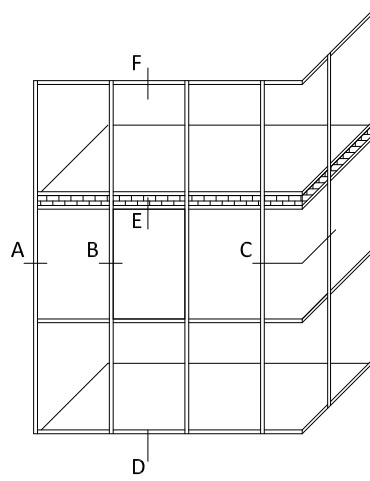


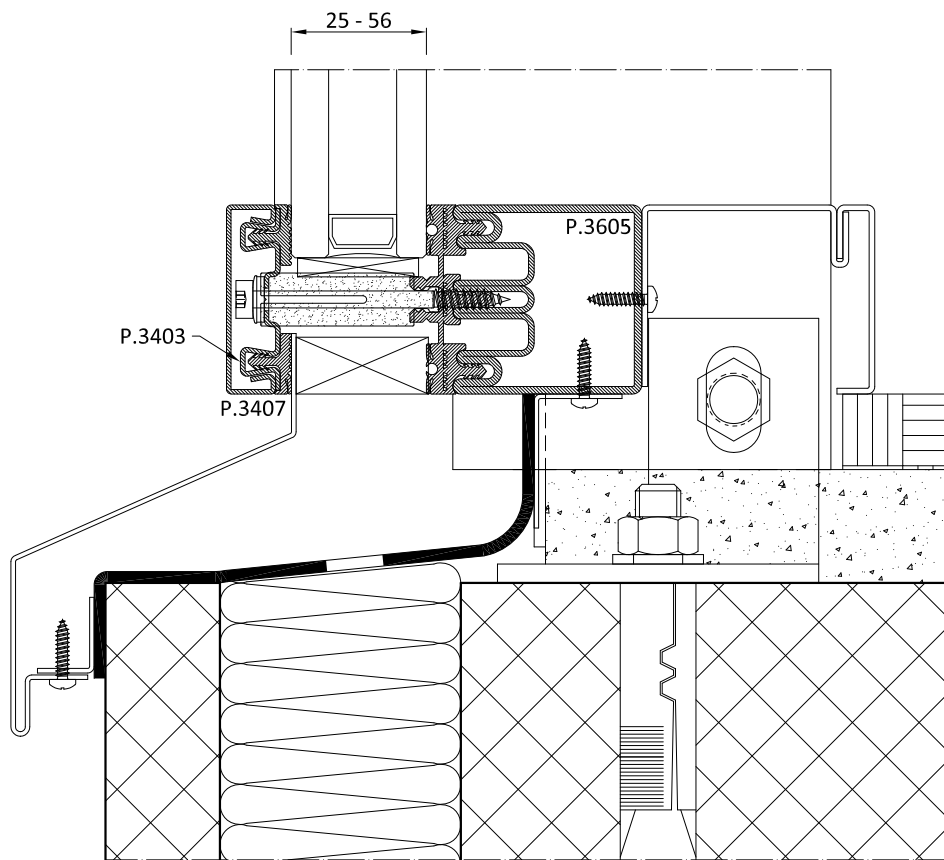
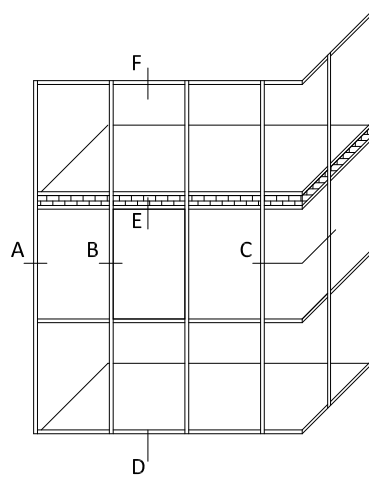
NB.: Coppia max. serraggio viti 5 Nm
NOTE.: Max. torque of tightening 5 Nm



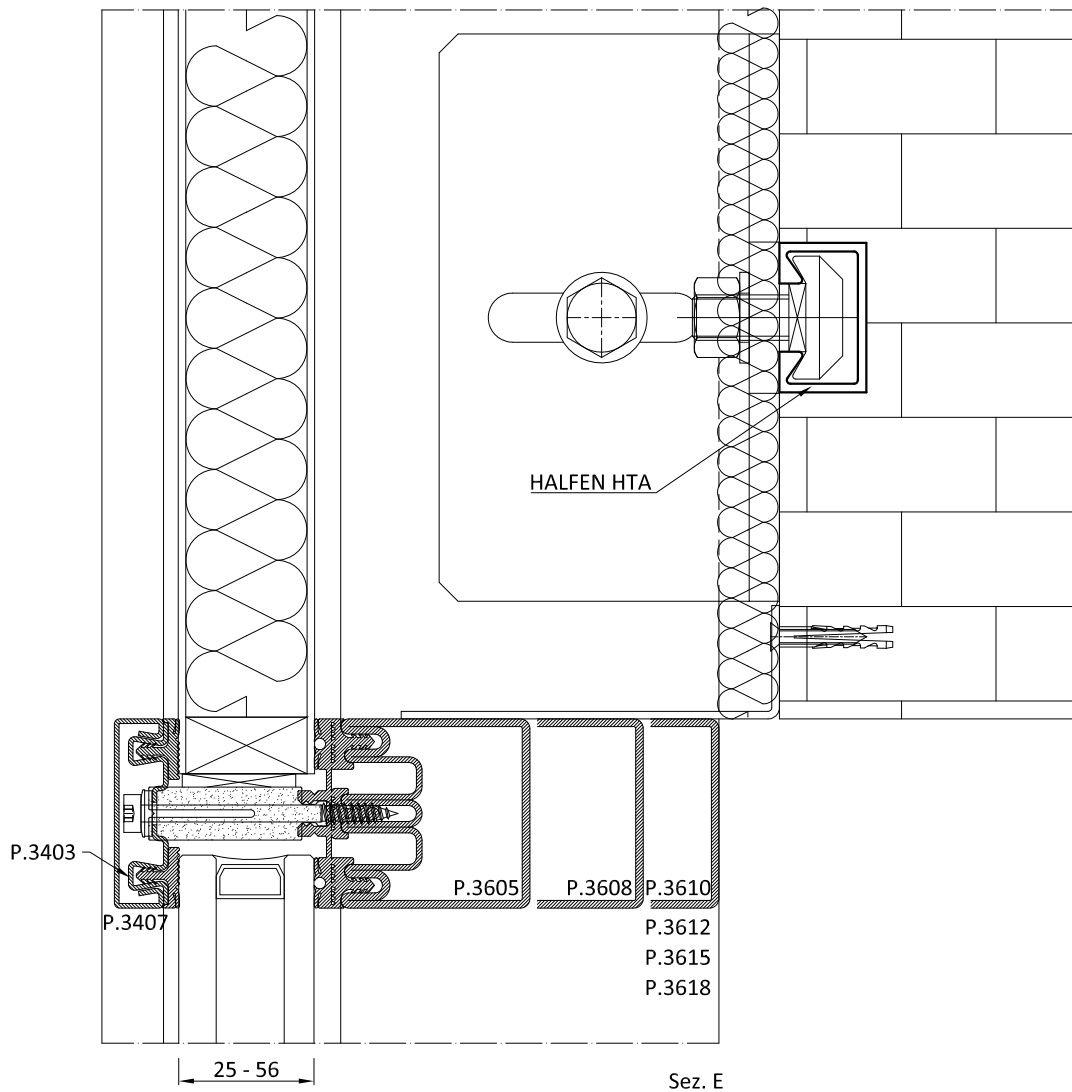
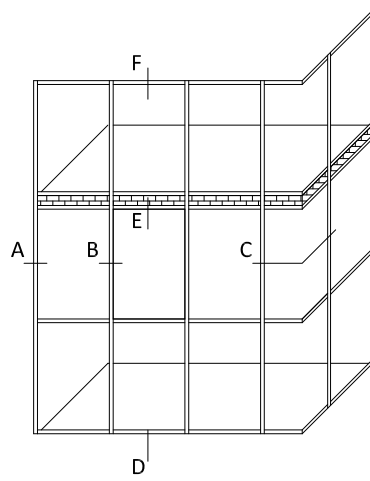
Sez. A

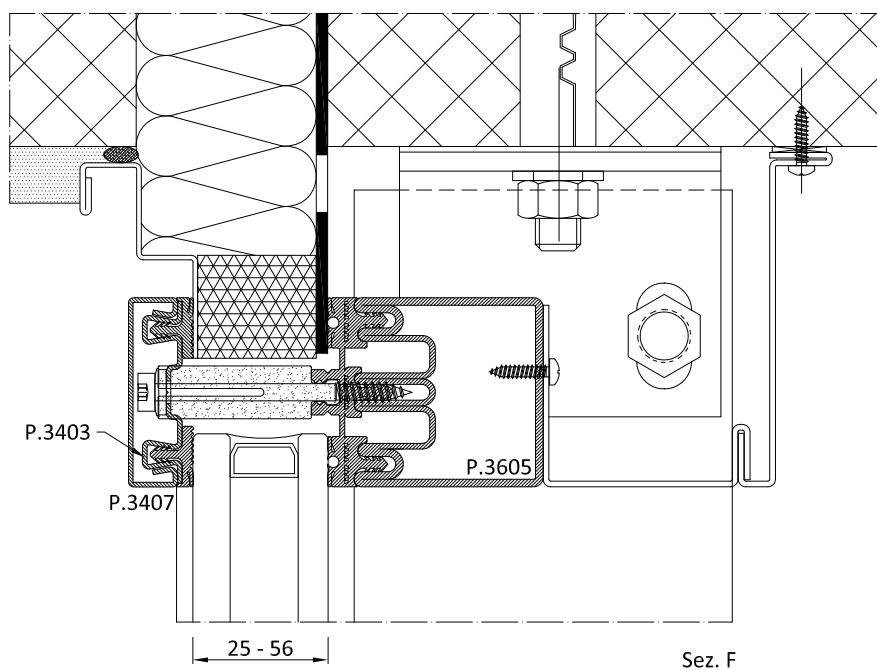
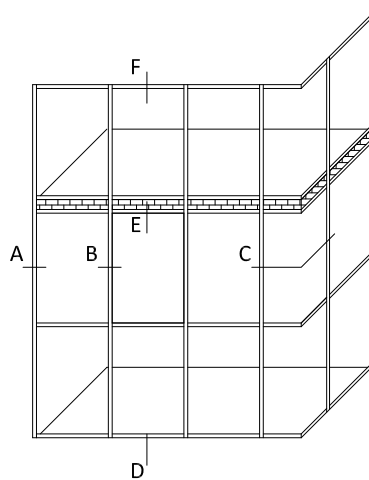


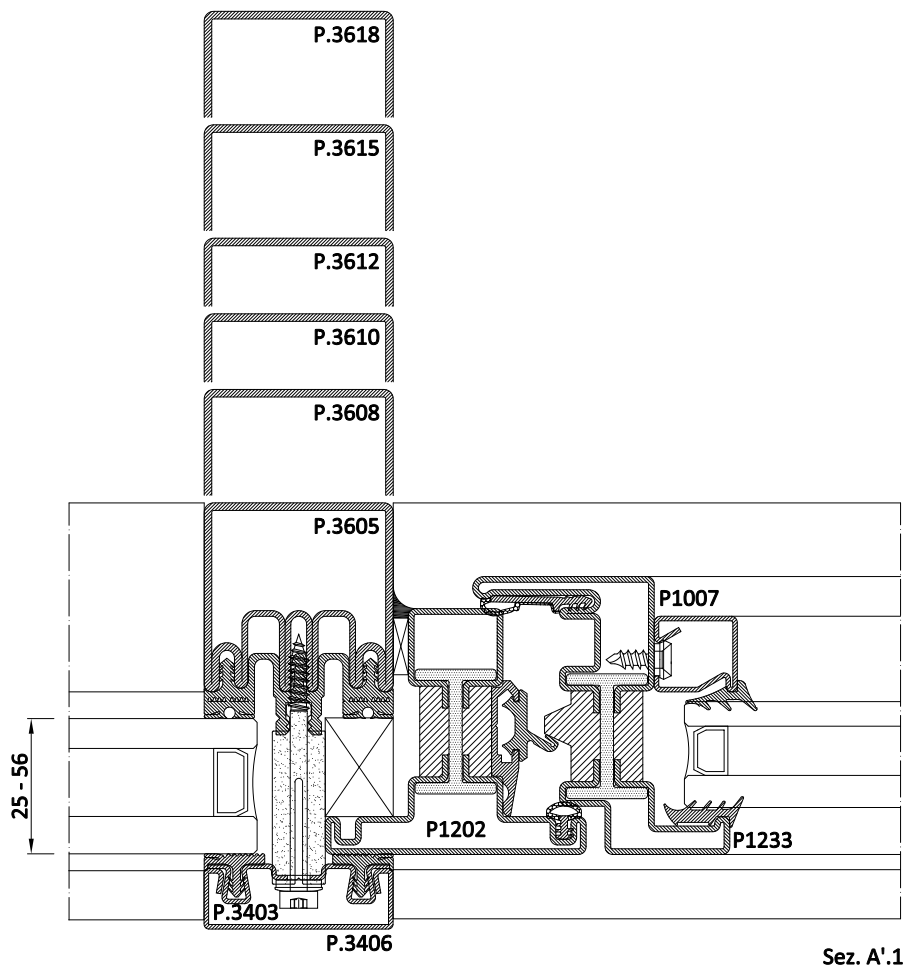
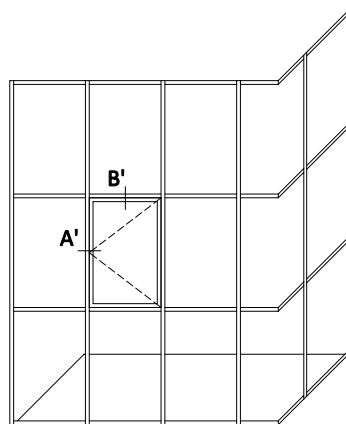


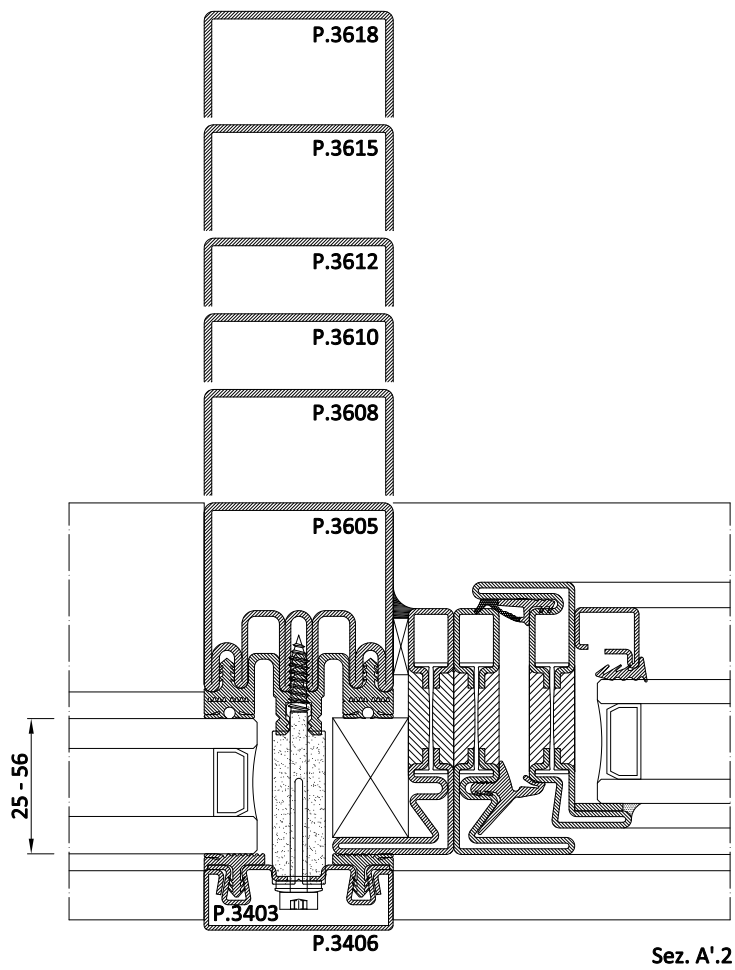
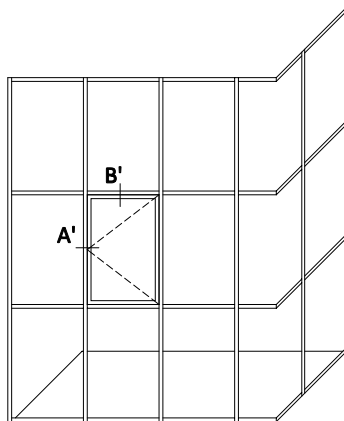


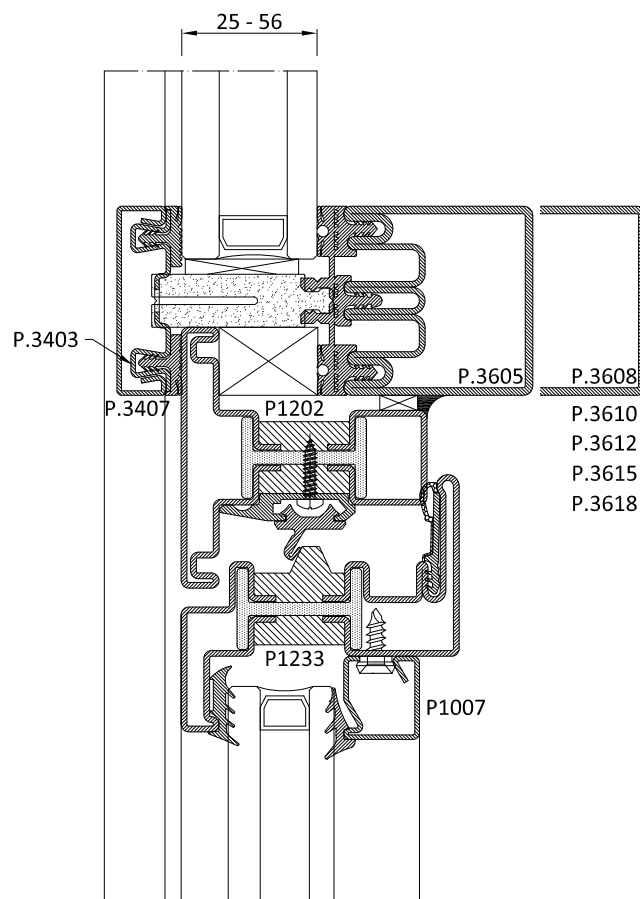
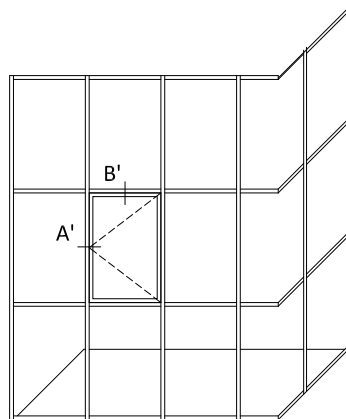
Sez. D



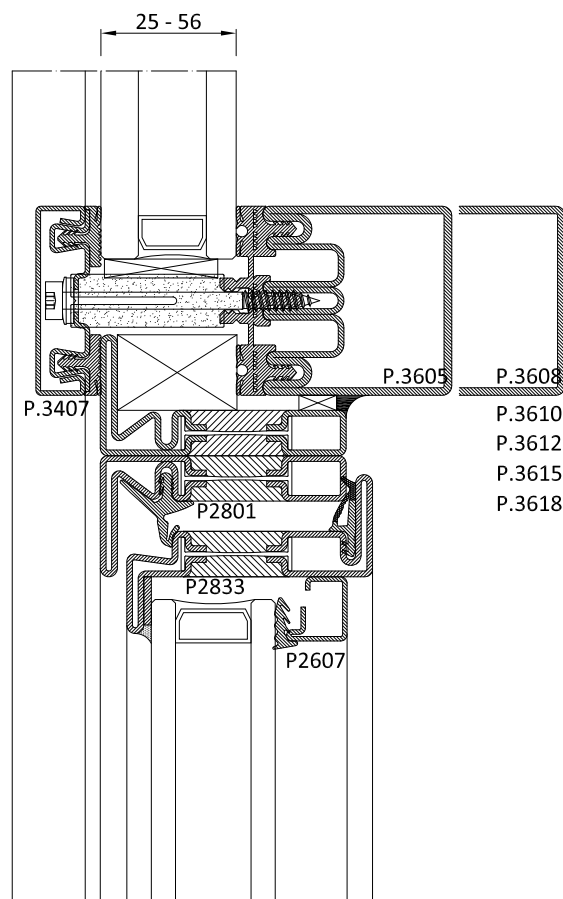
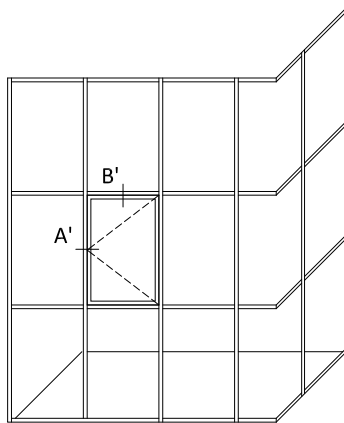




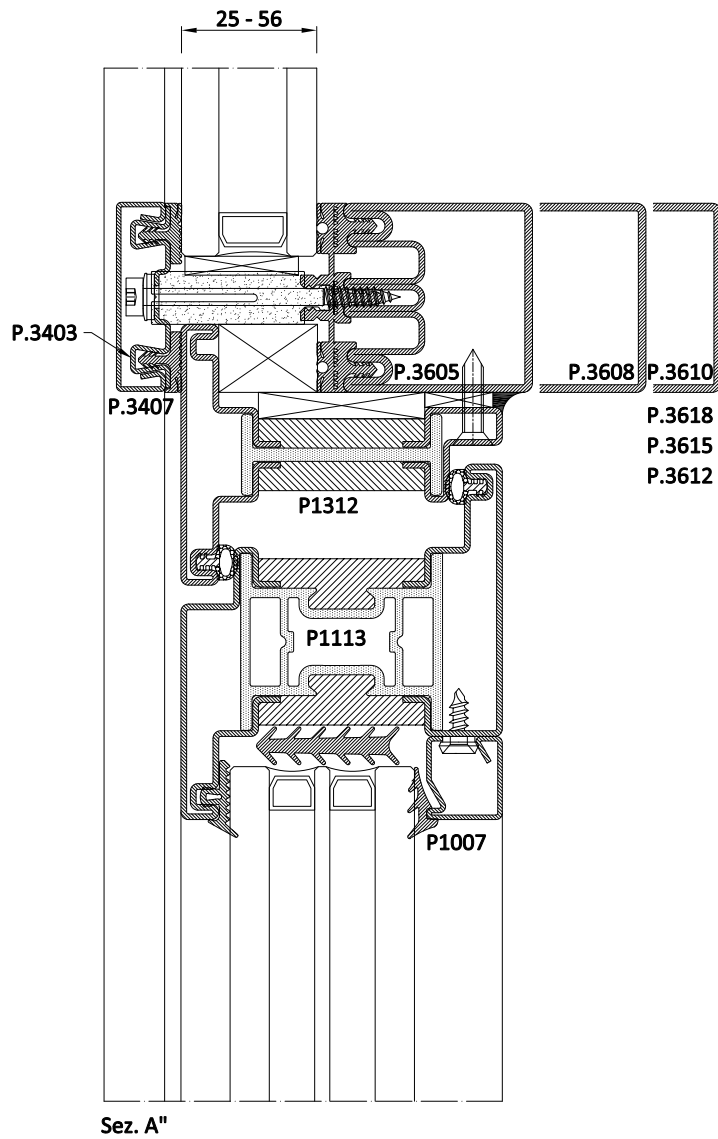
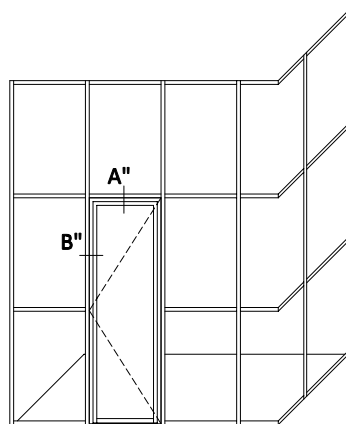


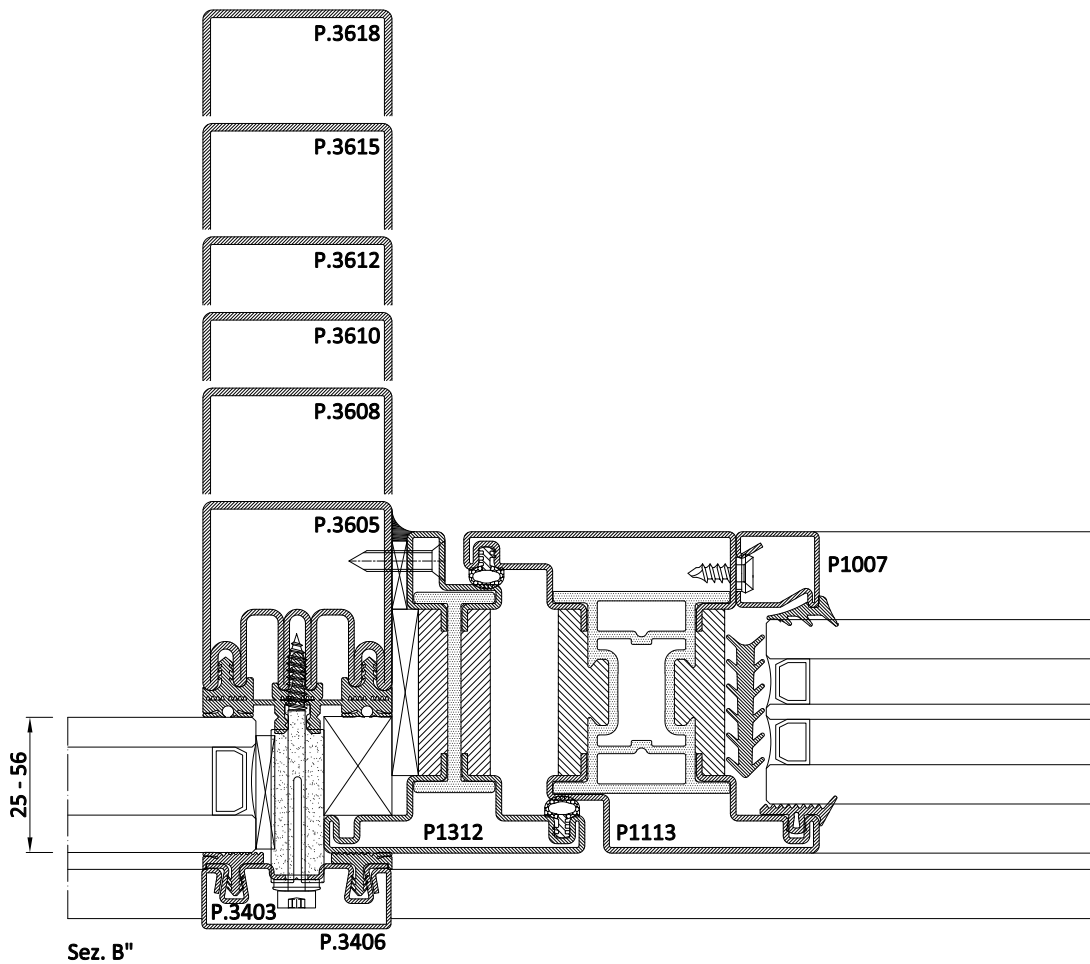
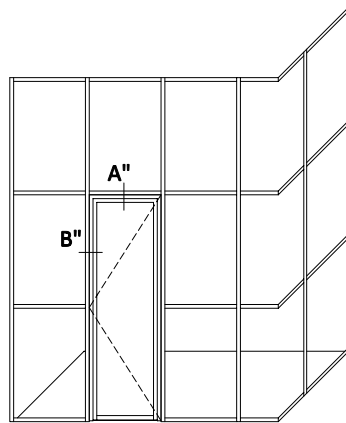


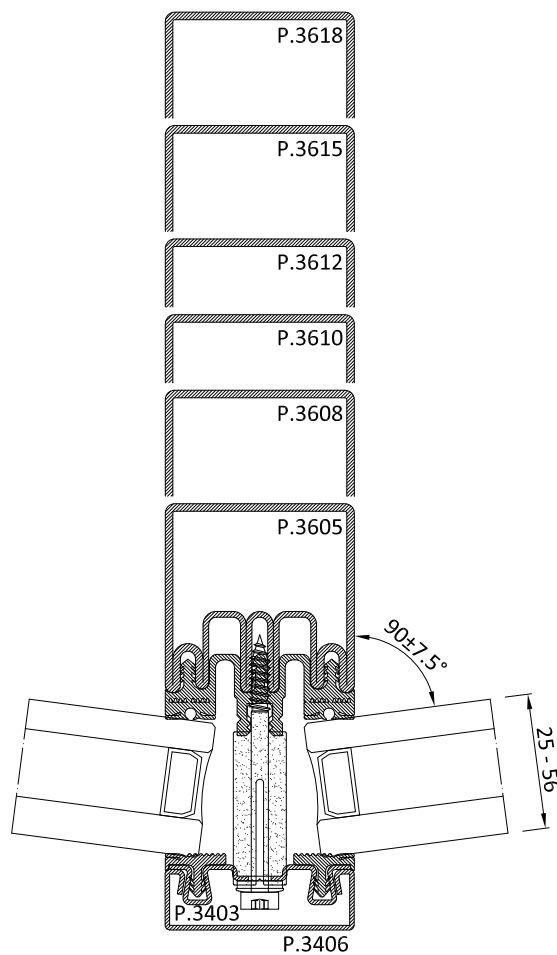
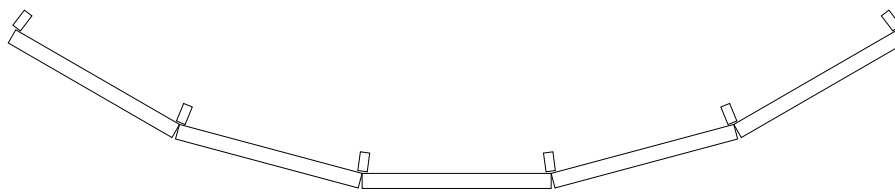
Sez. B'.1

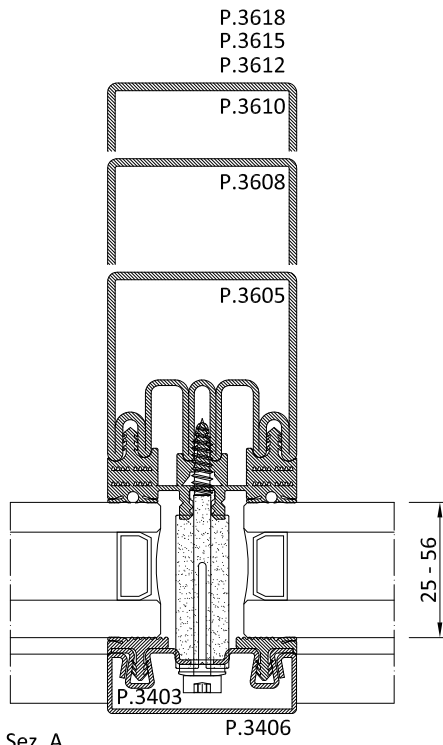
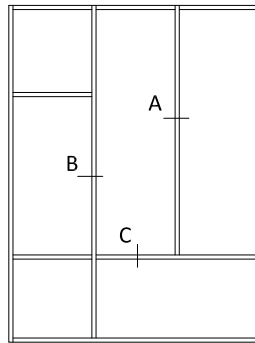


Sez. B'.2

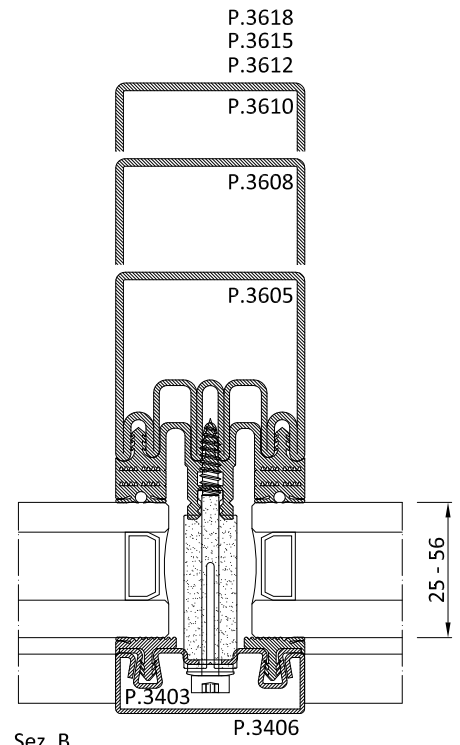




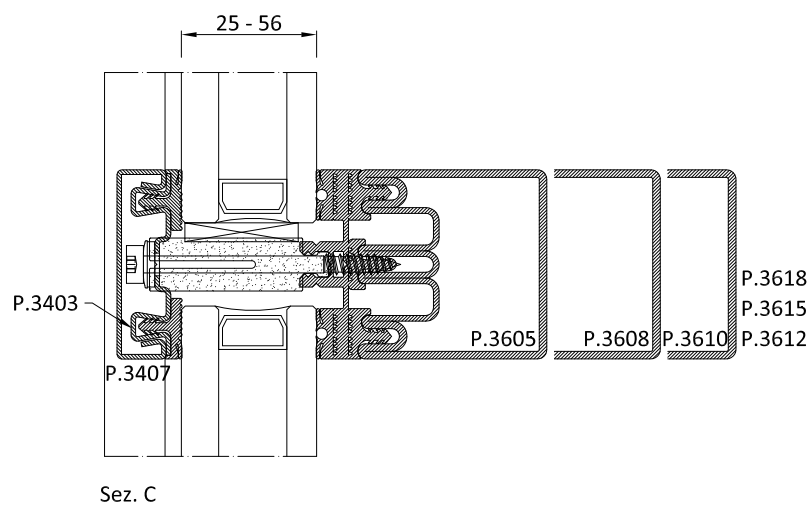




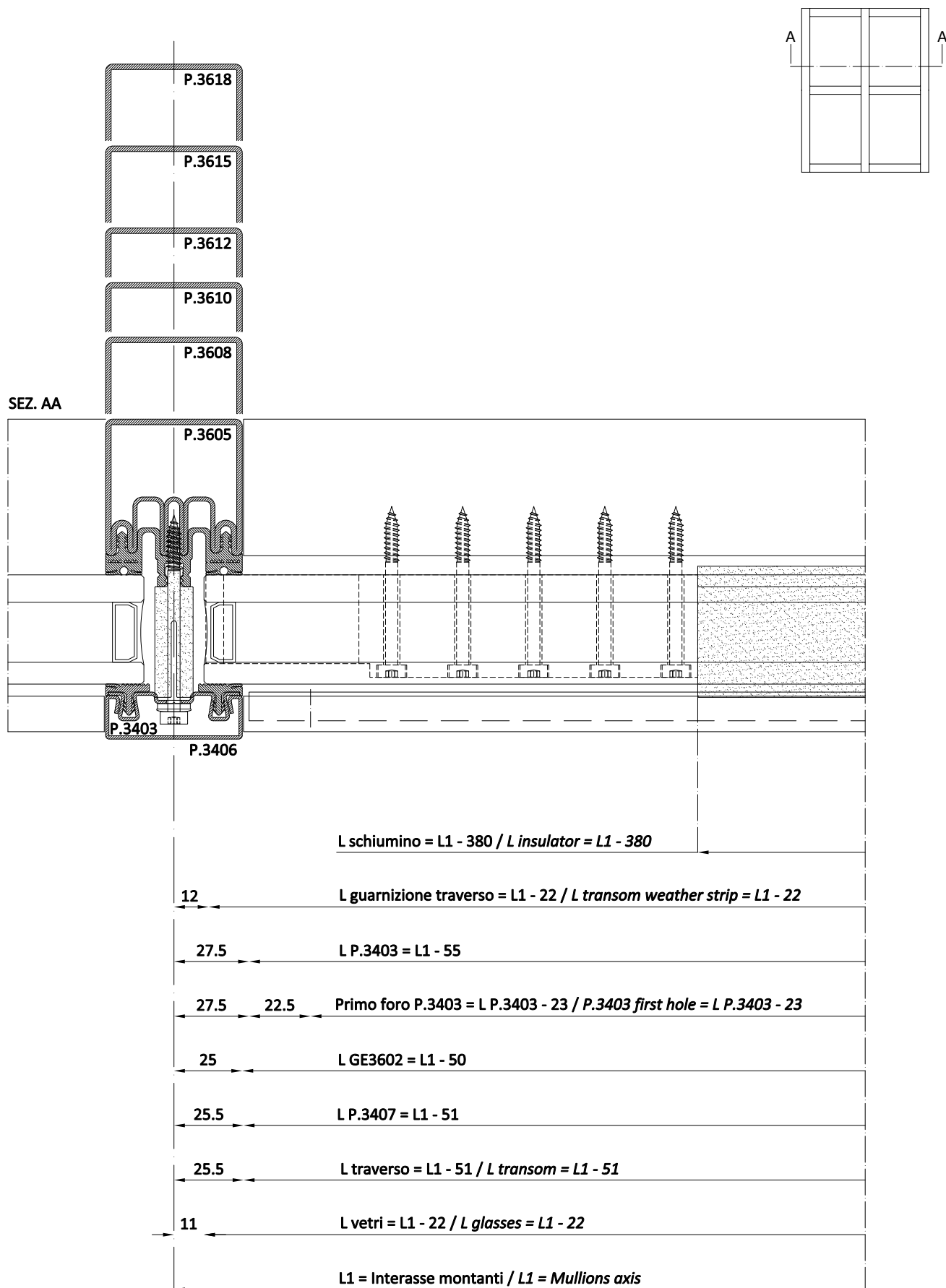
Sez. A

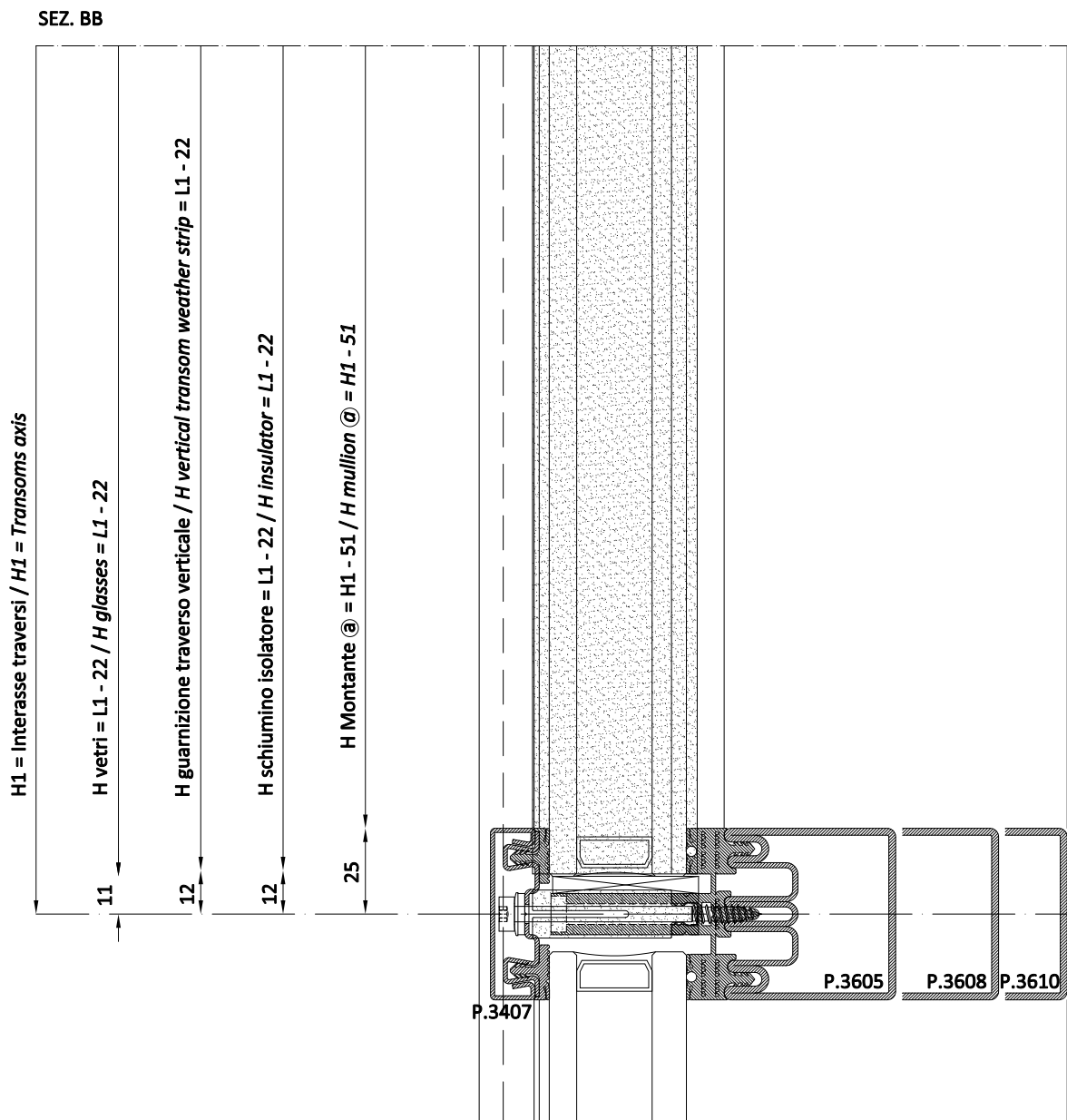
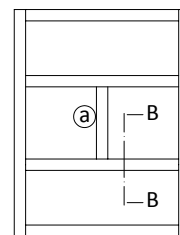


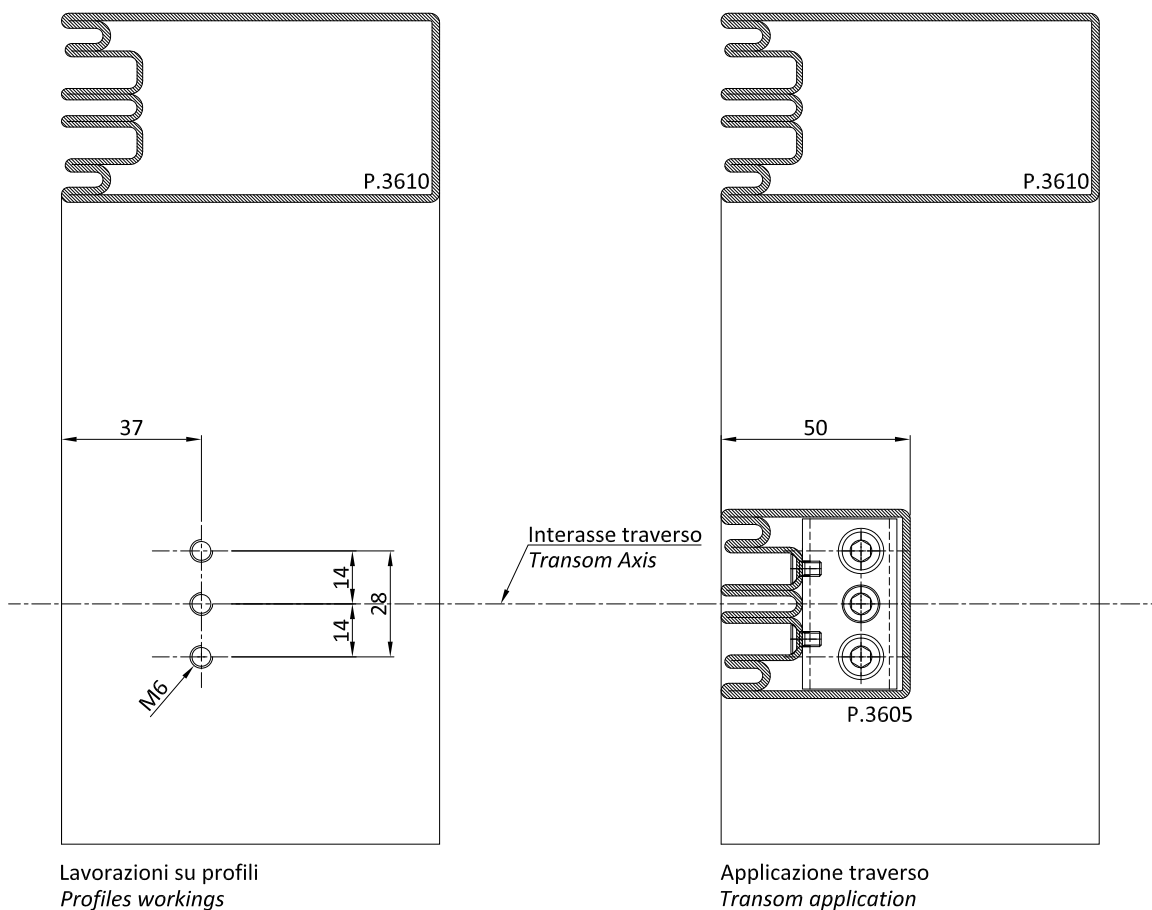
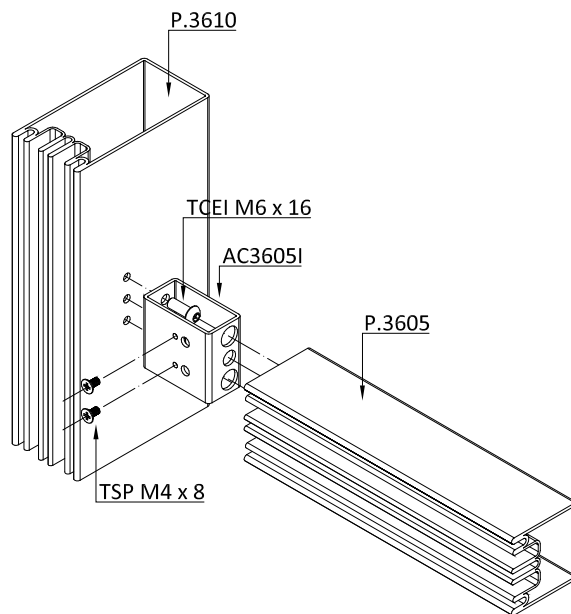
Sez. B



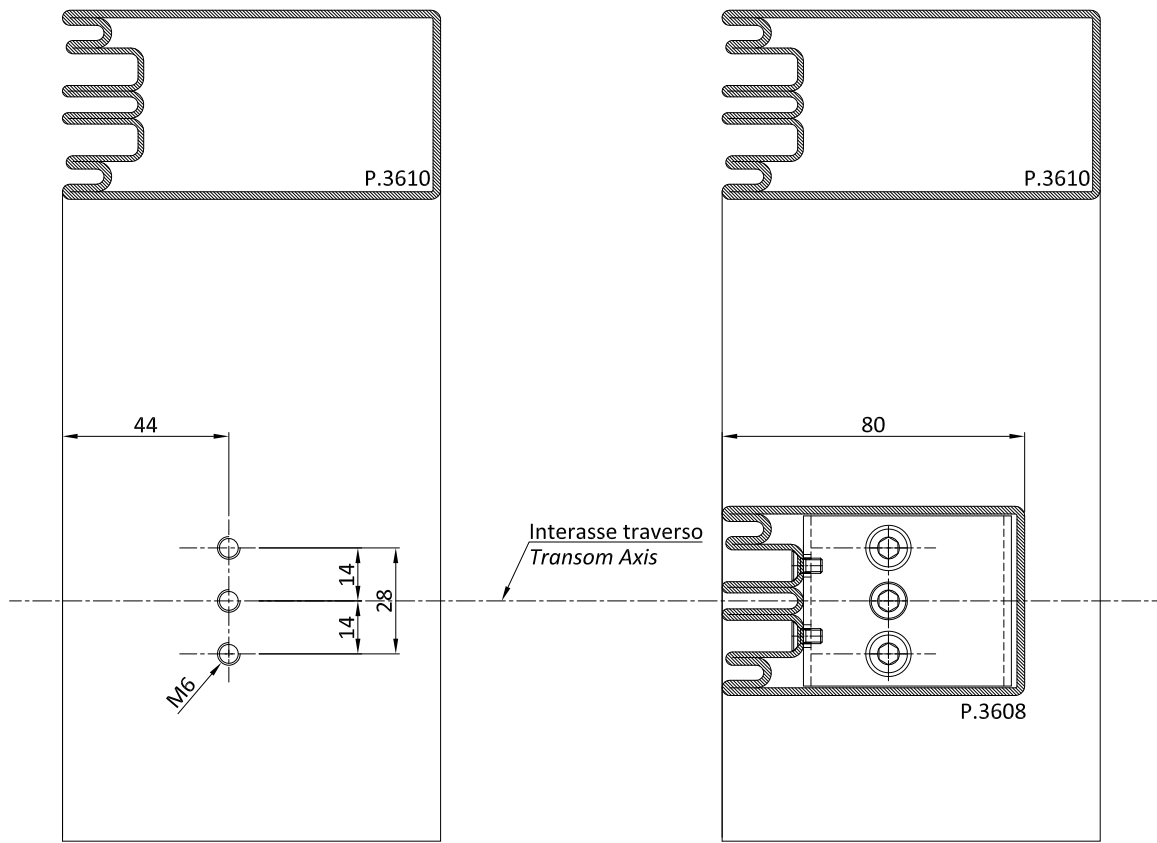
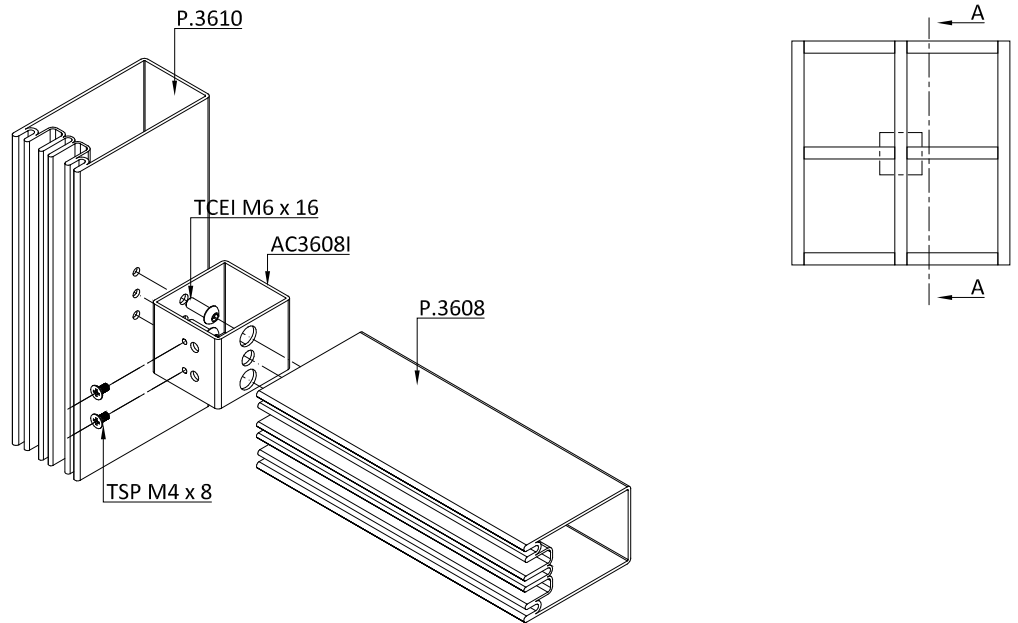
Sez. C







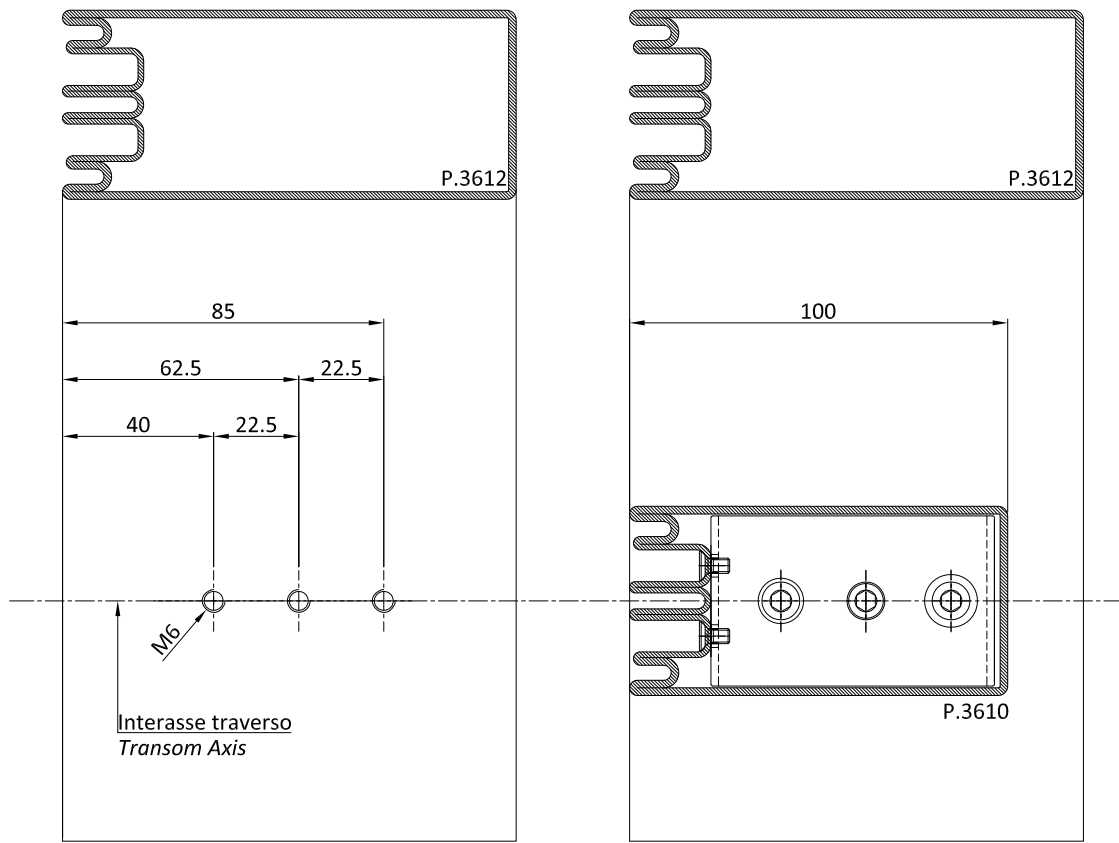
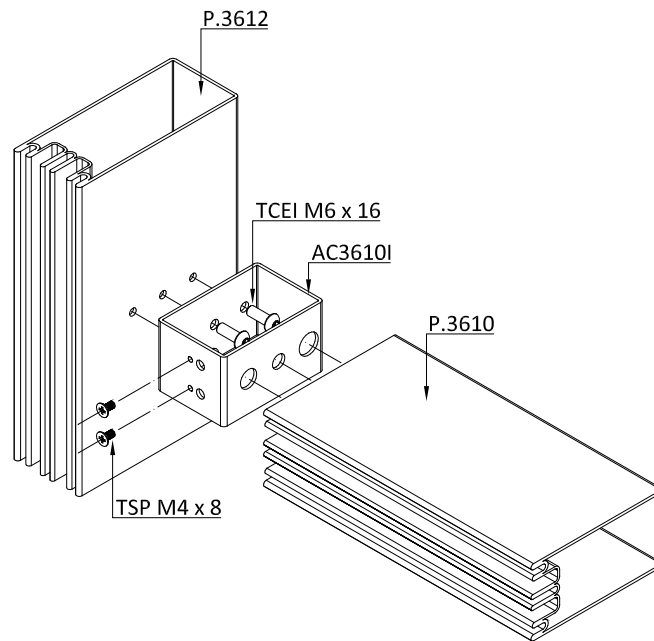
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



Lavorazioni su profili
Profiles workings

Applicazione trasverso
Transom application

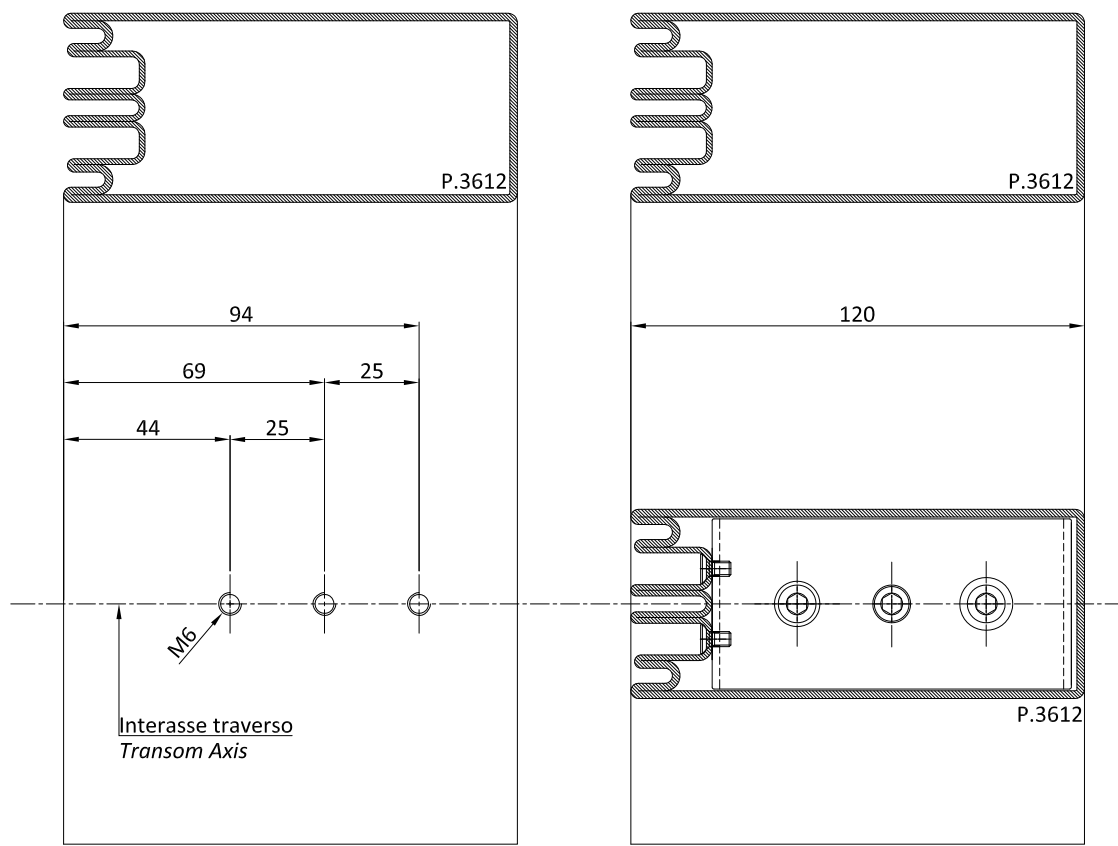
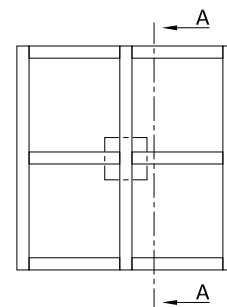
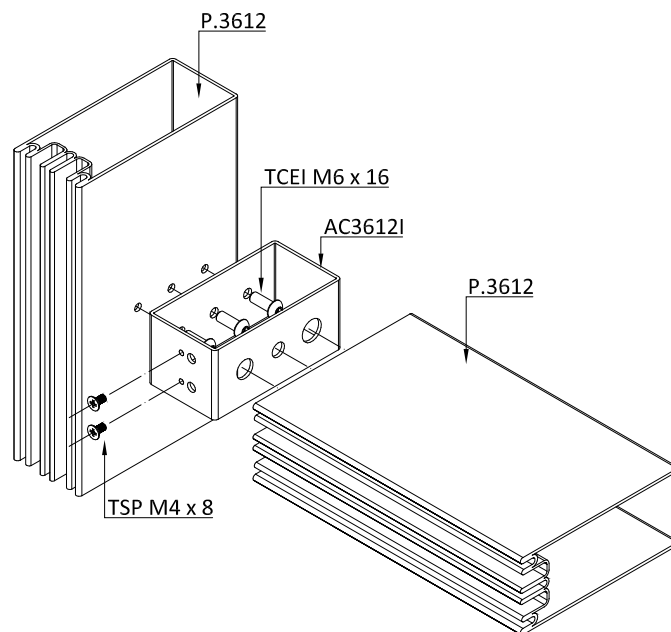
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



Lavorazioni su profili
Profiles workings

Applicazione traverso
Transom application

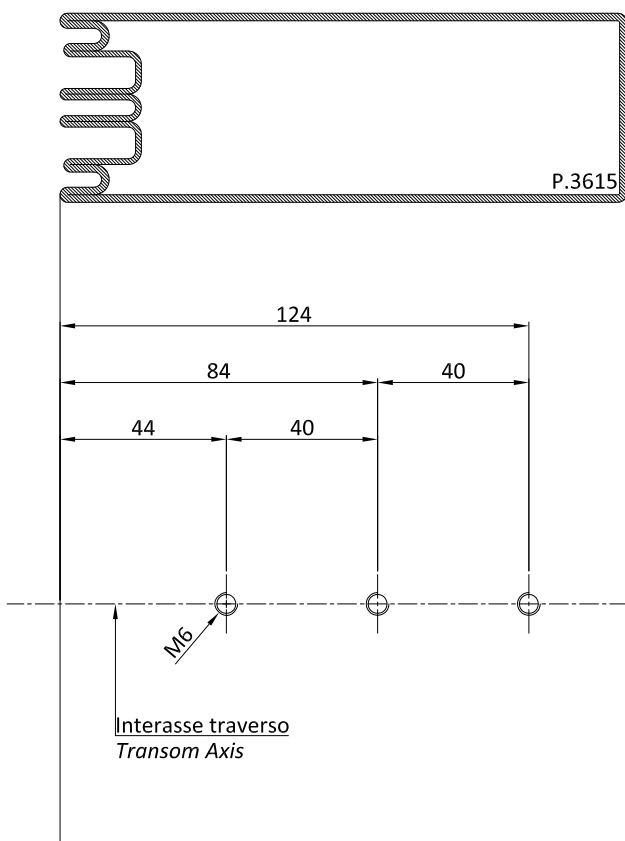
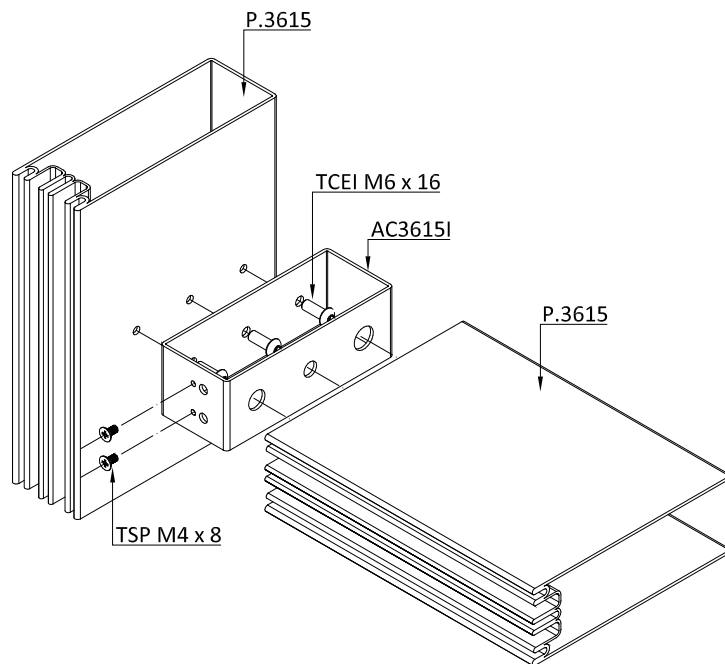
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



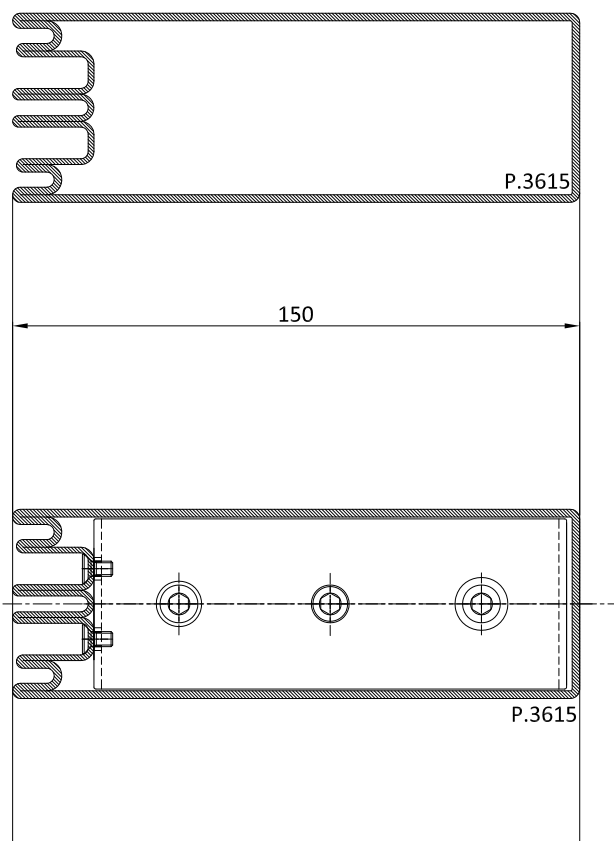
Lavorazioni su profili
Profiles workings

Applicazione trasverso
Transom application

N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles

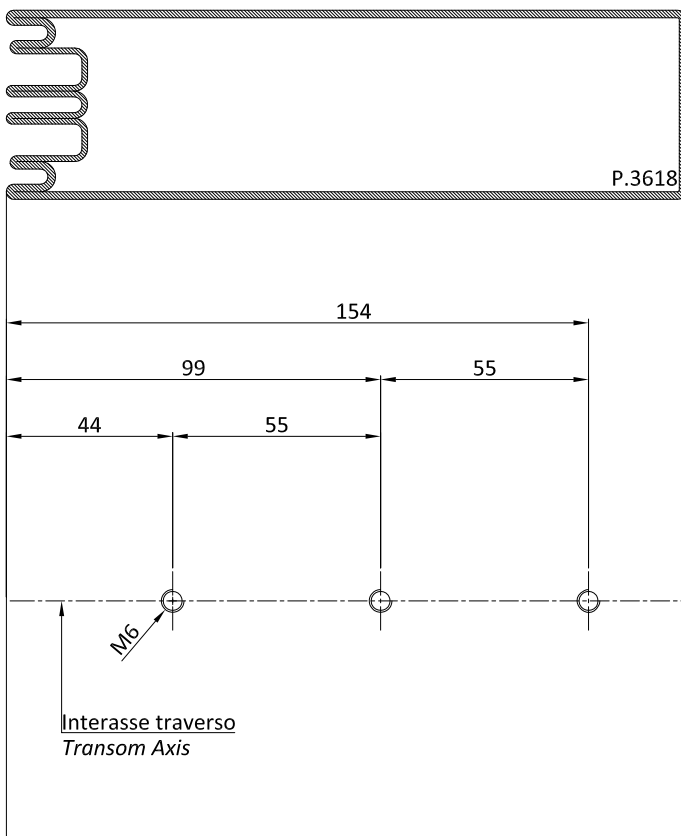
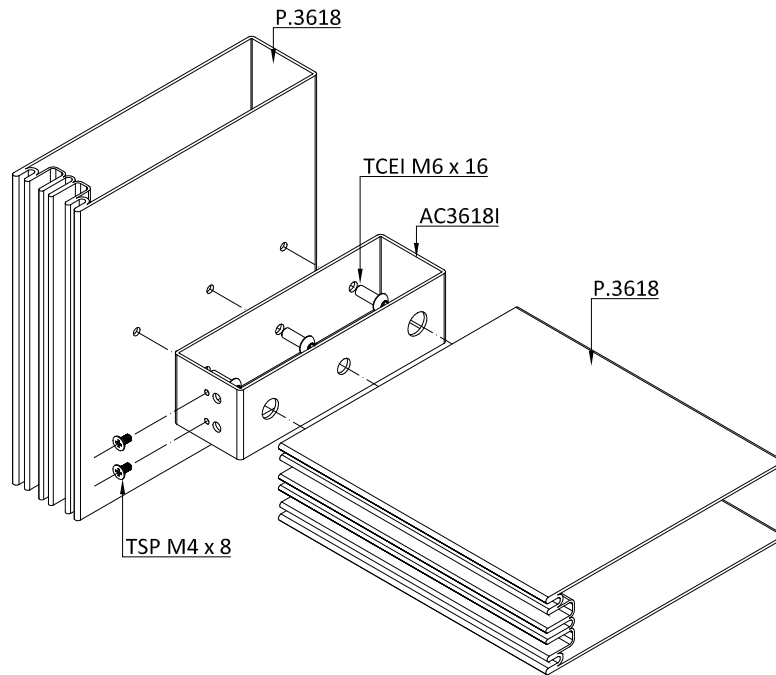


Lavorazioni su profili
Profiles workings

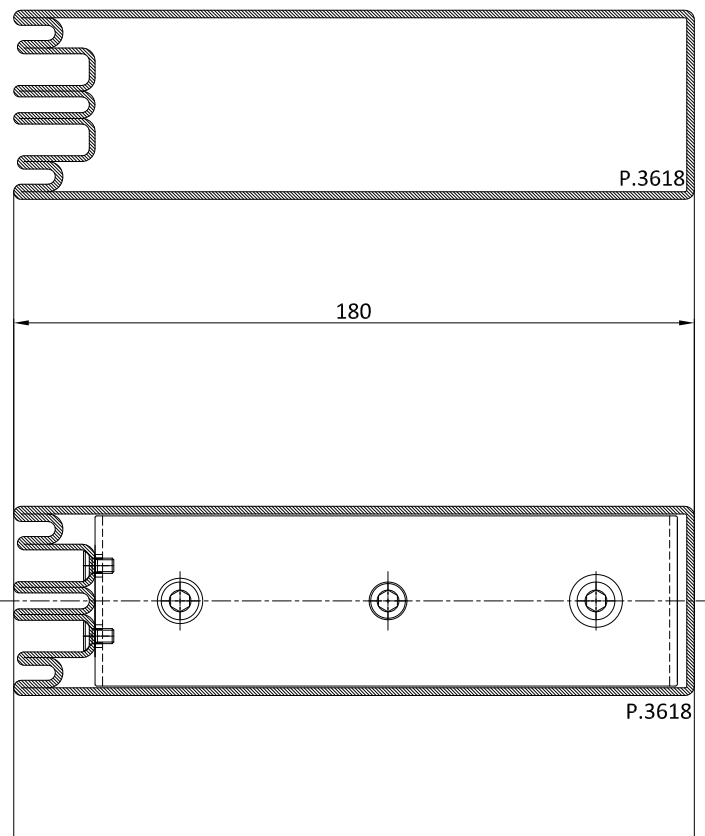


Applicazione trasverso
Transom application

N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles

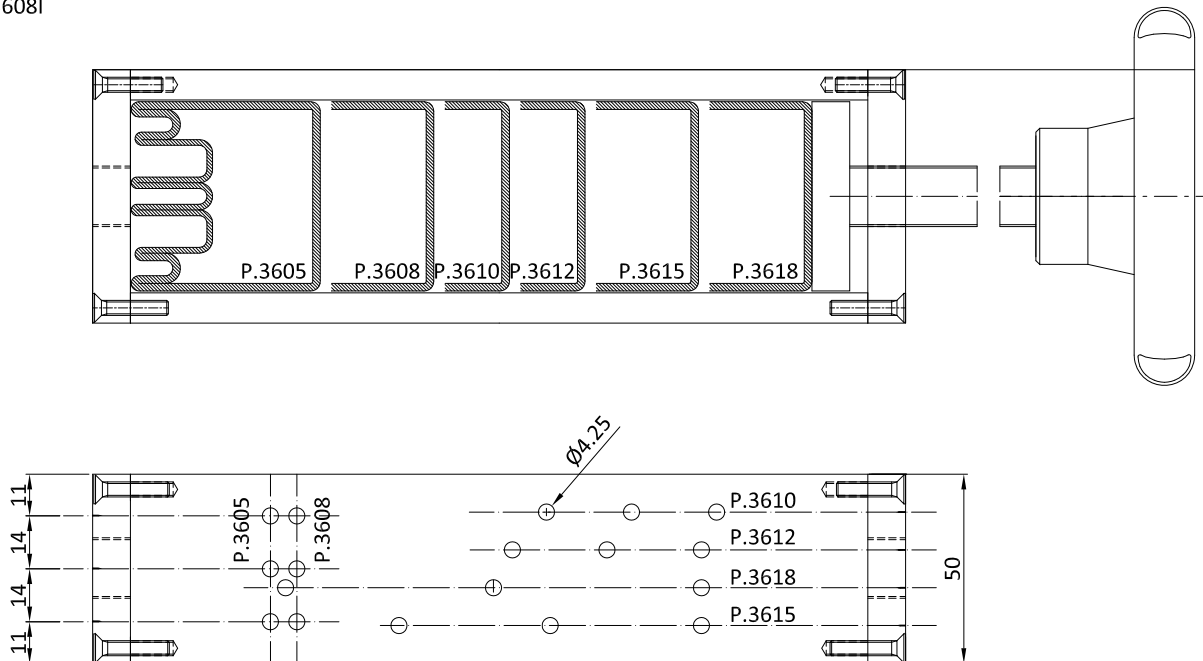


Lavorazioni su profili
Profiles workings

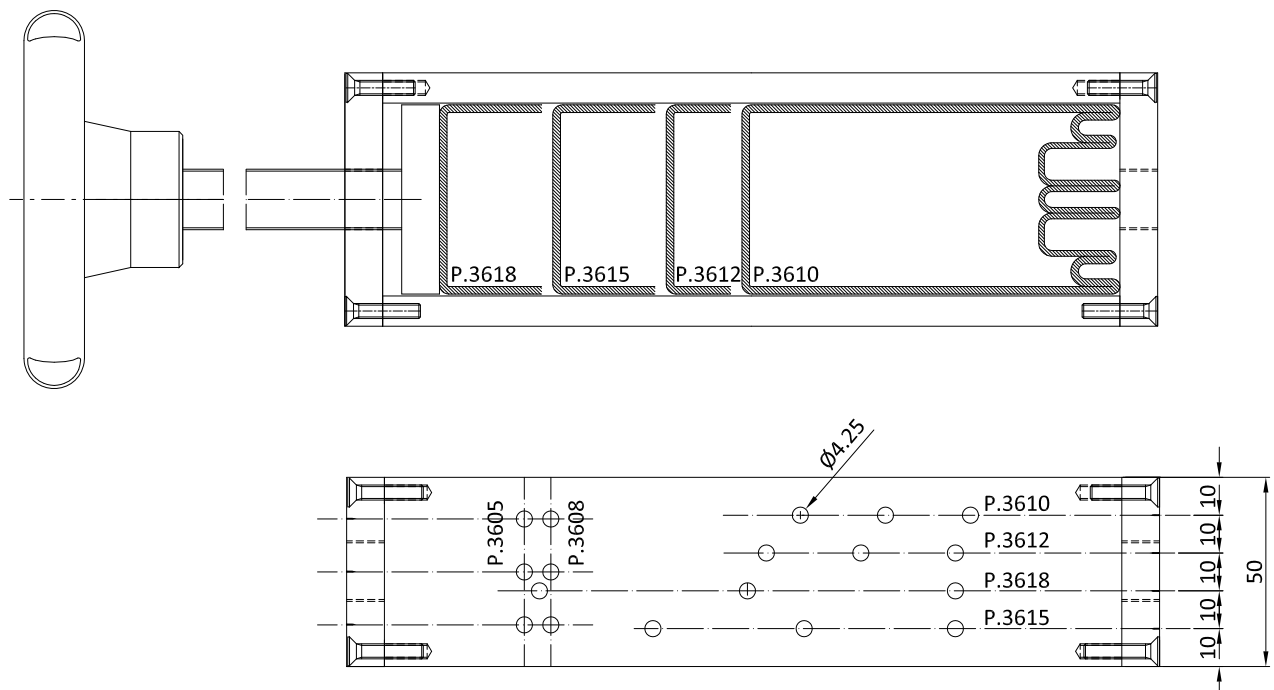


Applicazione traverso
Transom application

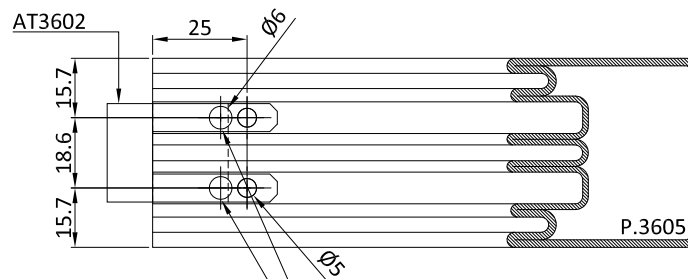
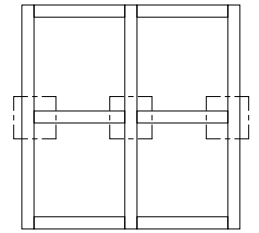
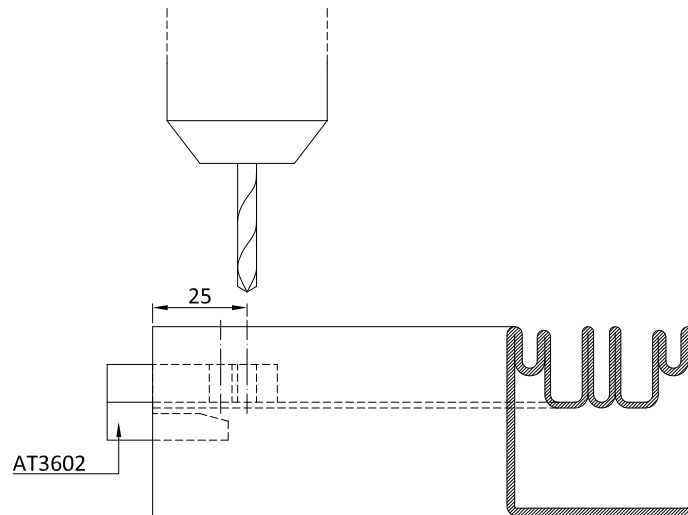
Orientamento maschera di foratura per / Orientation of drilling jig for
AC3605I
AC3608I



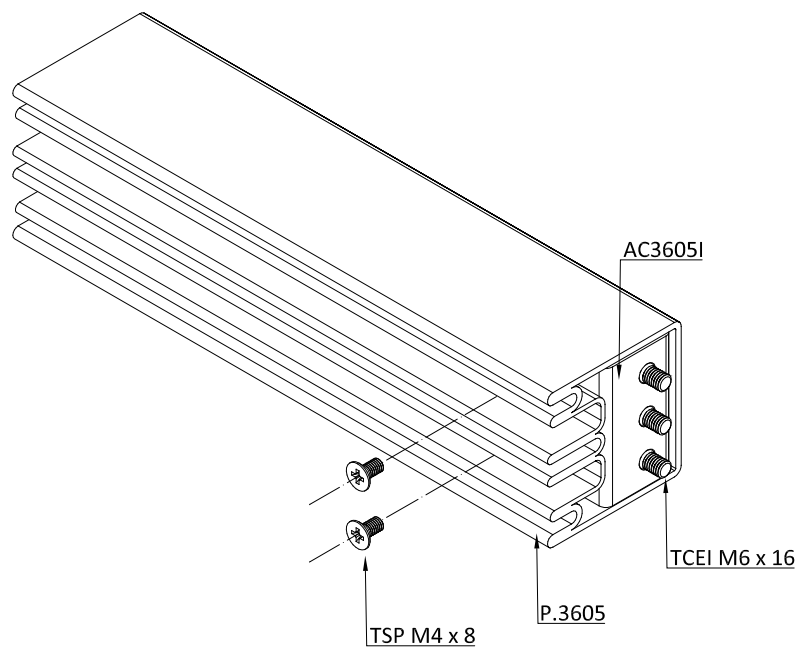
Orientamento maschera di foratura per / Orientation of drilling jig for
AC3610I
AC3612I
AC3615I
AC3618I



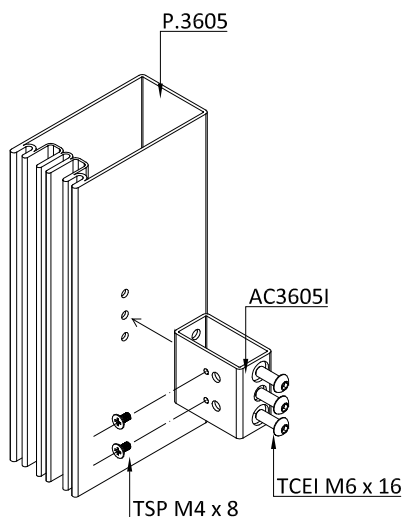
N.B.: In mancanza di un centro di lavoro è consigliabile utilizzare la maschera AT3601 per forare i montanti
NOTE: It is recommended to use AT3601 jig in absence of a machining center



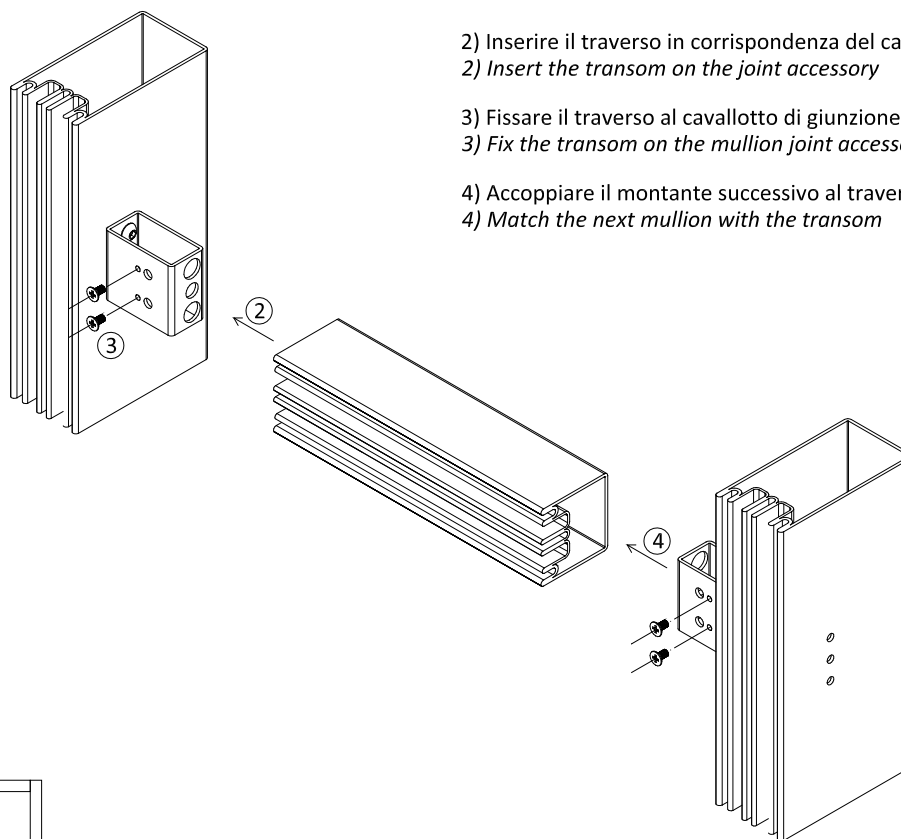
Fori per estrazione cavallotti a molla
(non necessari per cavallotti ad avvitare)
Holes for removing the connecton device
(not necessary for connection devices with springs)



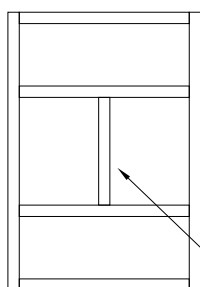
N.B.: Lavorazioni analoghe su tutti i profili traverso
NOTE: Same working on other transom profiles



- 1) Fissare il fondino al montante utilizzando le apposite viti TCEI M6 x 16 *
- 1) Fix the joint accessory on the side of the mullion with TCEI M6 x 16 screws *

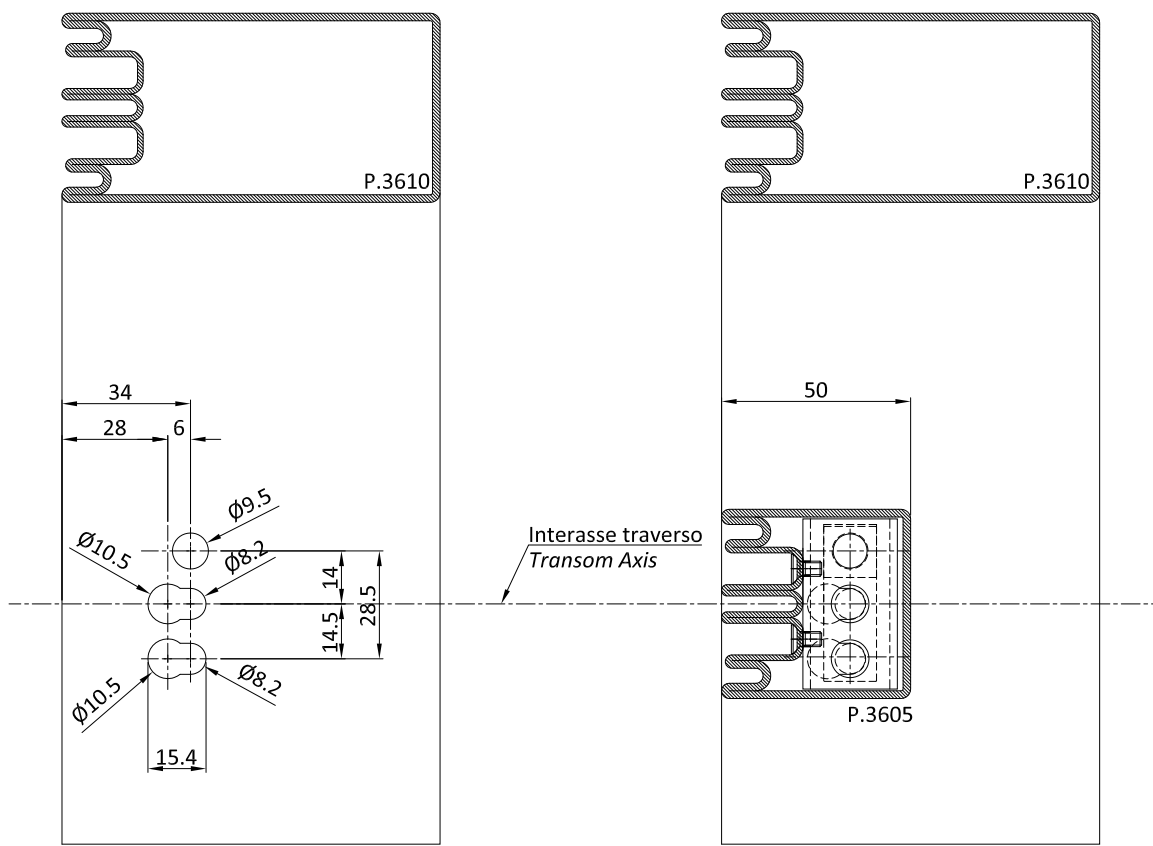
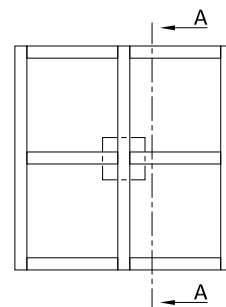
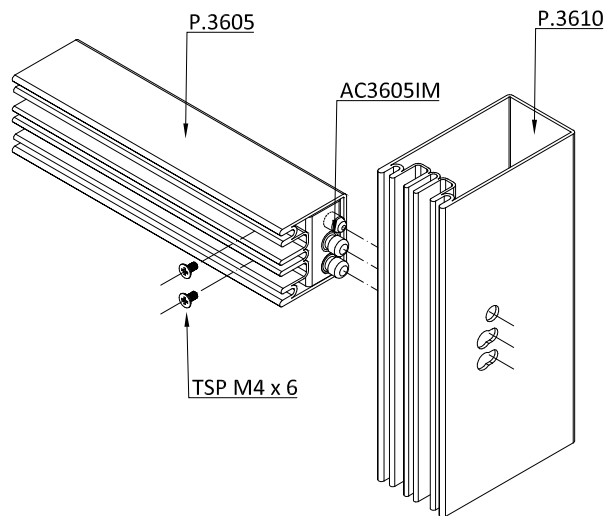


- 2) Inserire il traverso in corrispondenza del cavalletto
- 2) Insert the transom on the joint accessory
- 3) Fissare il traverso al cavalletto di giunzione tramite le viti TSP M4 x 8
- 3) Fix the transom on the mullion joint accessory with TSP M4 x 8 screws
- 4) Accoppiare il montante successivo al traverso
- 4) Match the next mullion with the transom



NB.: Traversi verticali devono essere preassemblati a quelli orizzontali in officina.
Note: Vertical transoms should be assembled with the horizontal transoms in the workshop.

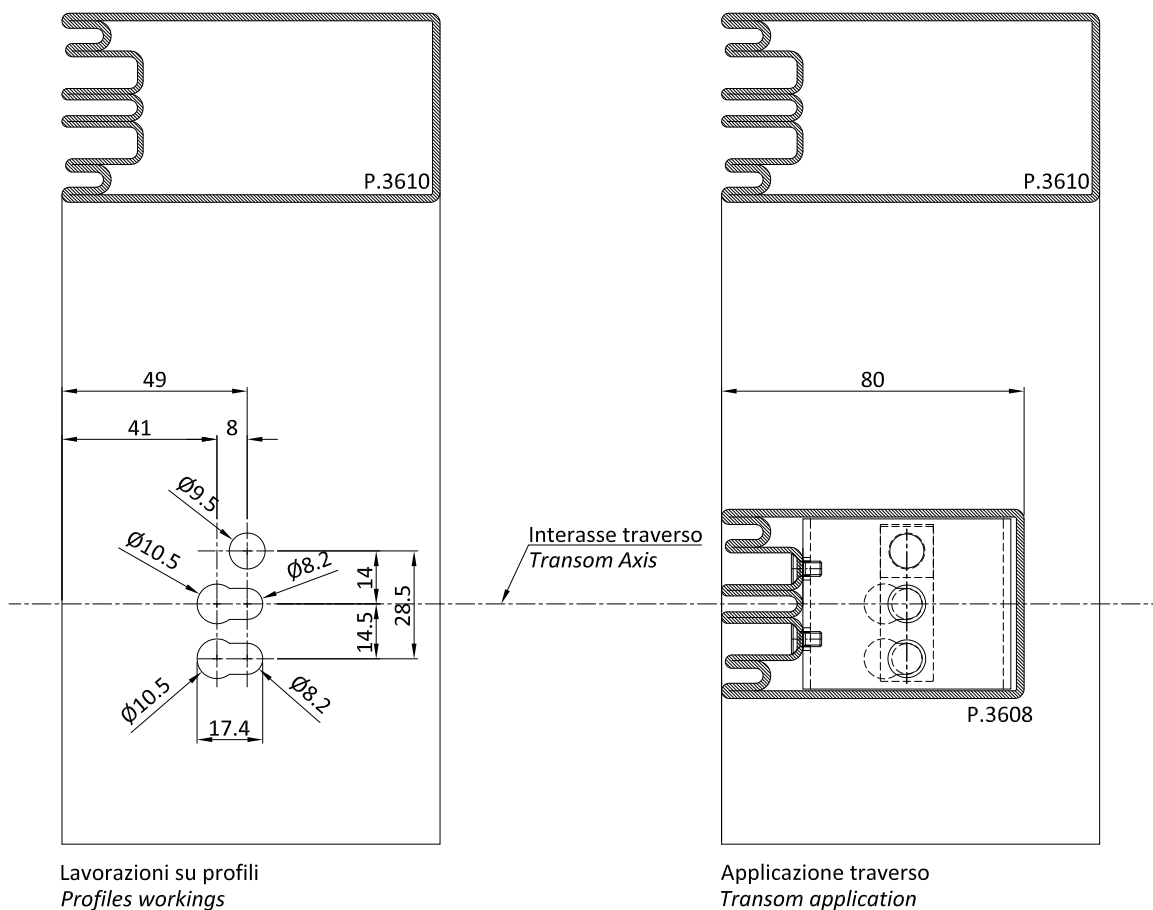
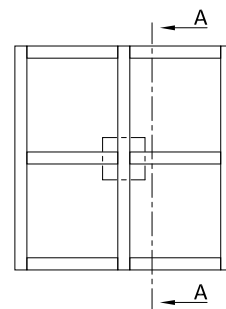
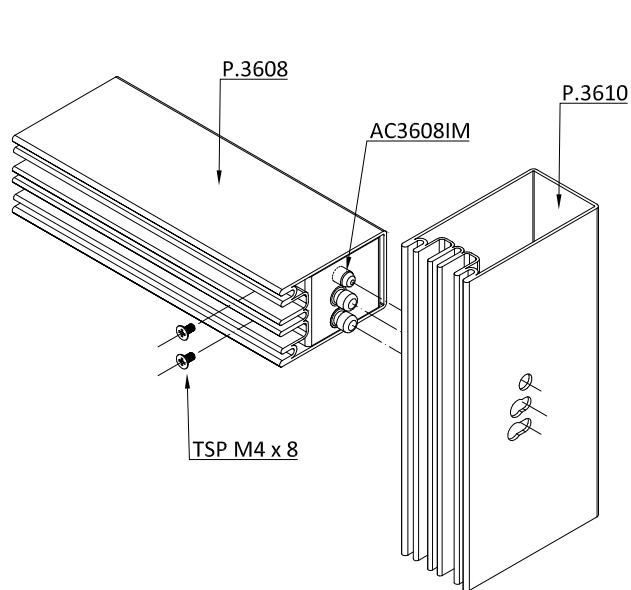
* fase 1 da eseguire in officina
* phase 1 to be performed in the workshop



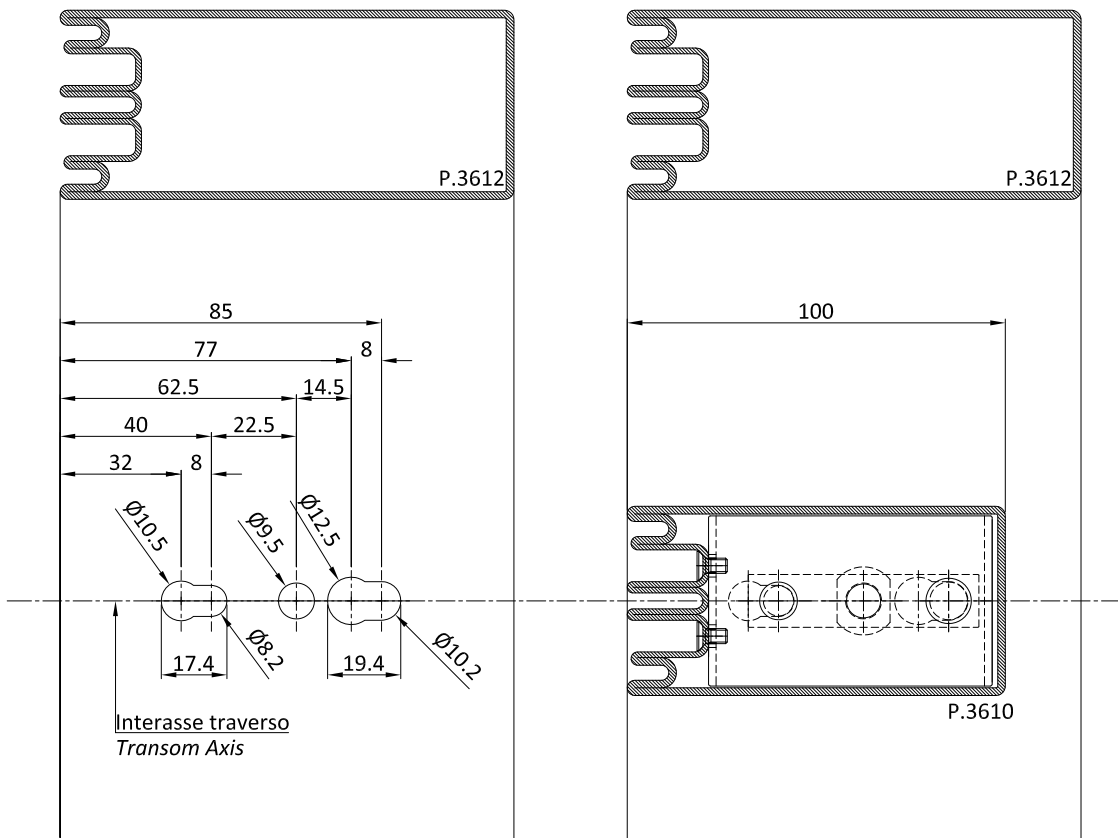
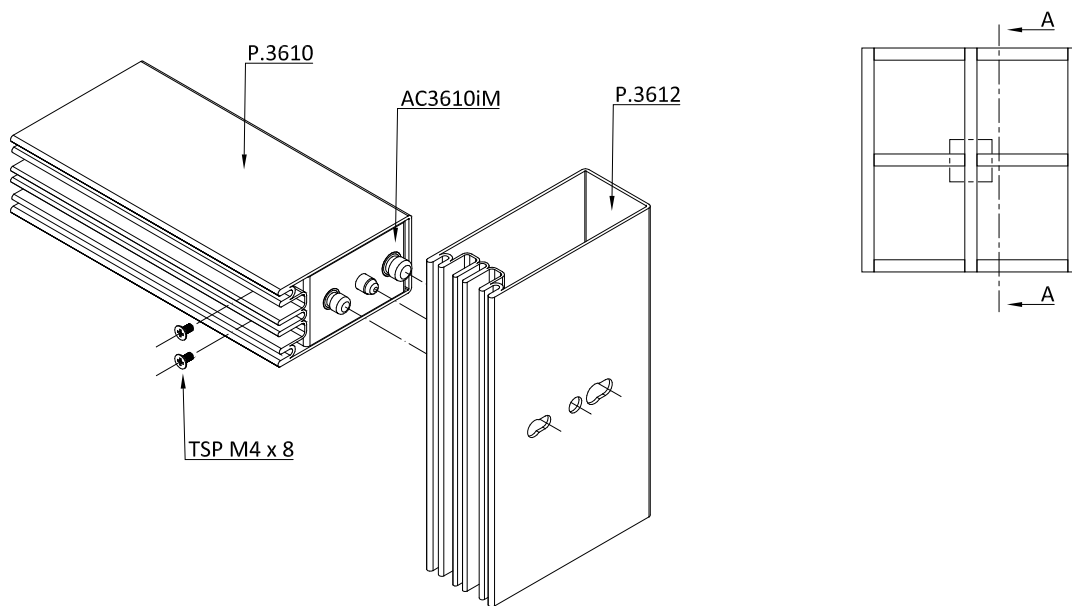
Lavorazioni su profili
Profiles workings

Applicazione trasverso
Transom application

N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



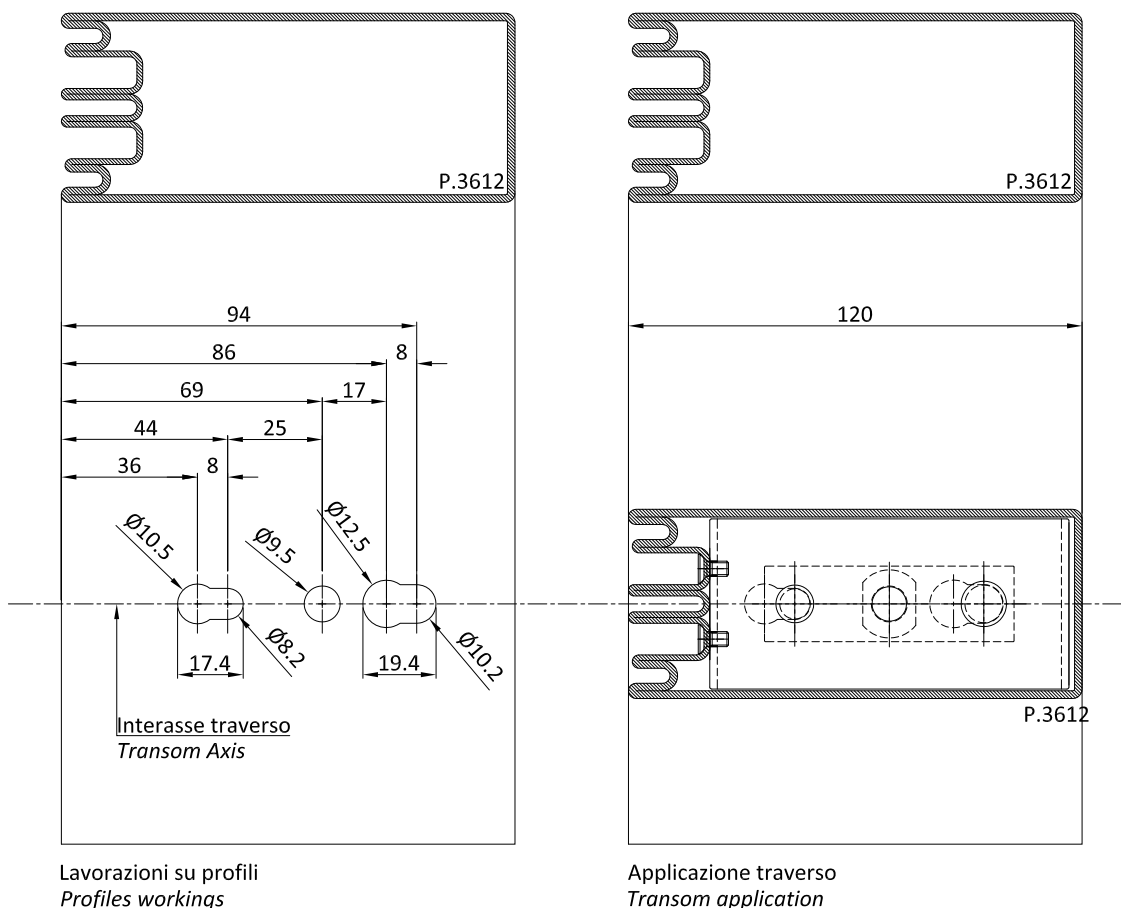
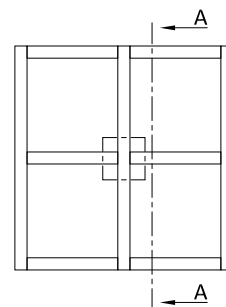
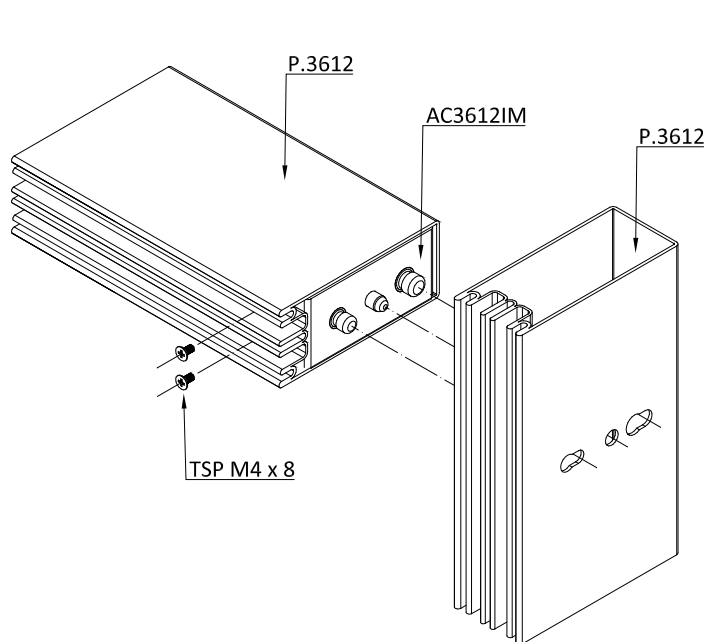
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



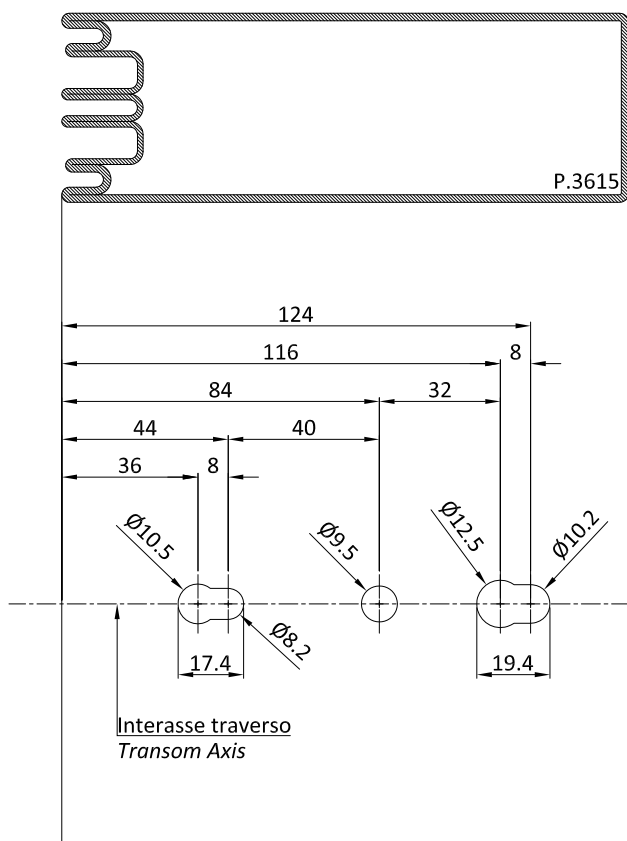
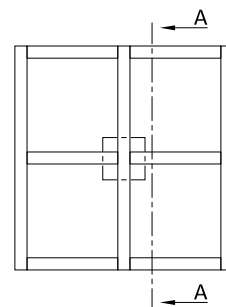
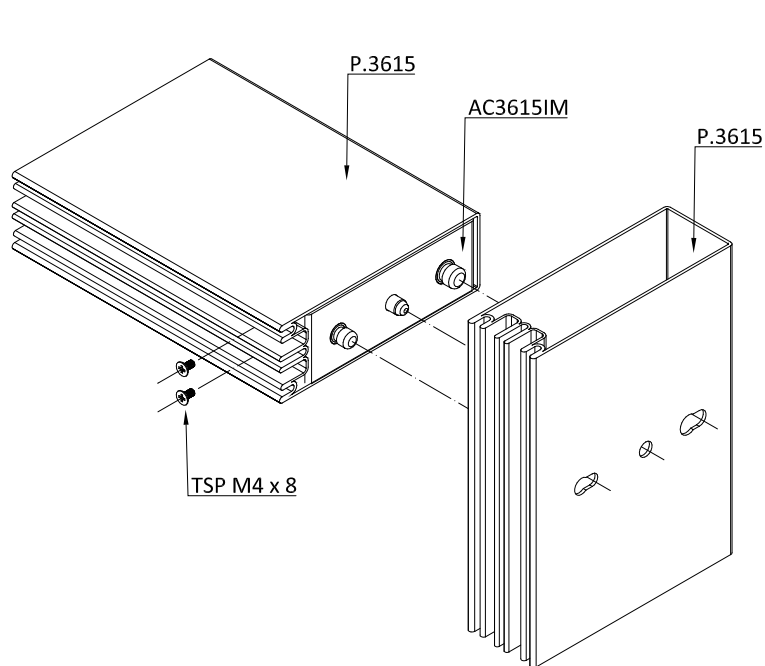
Lavorazioni su profili
Profiles workings

Applicazione traverso
Transom application

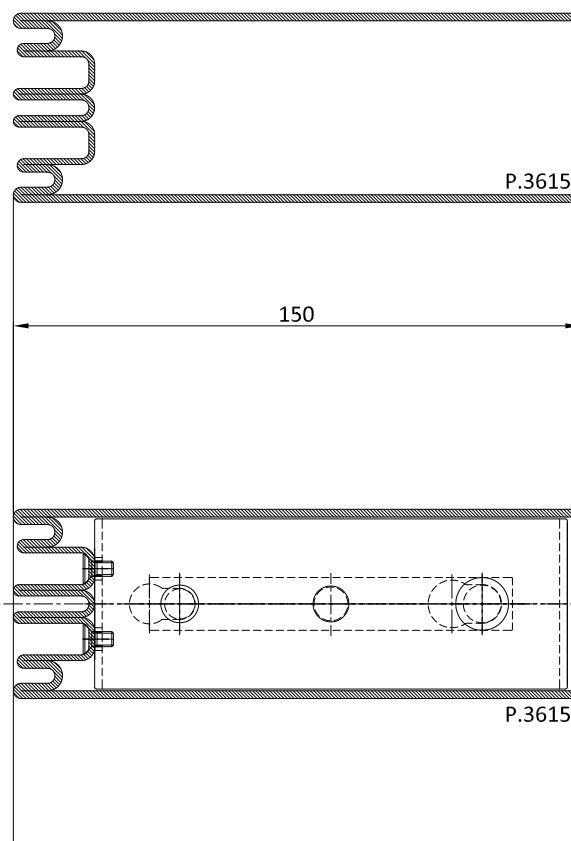
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles

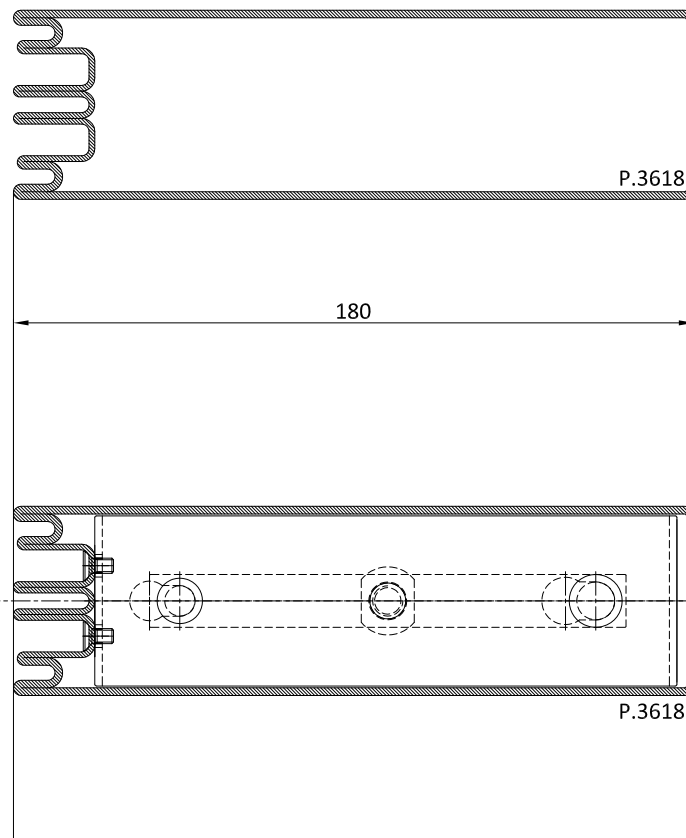
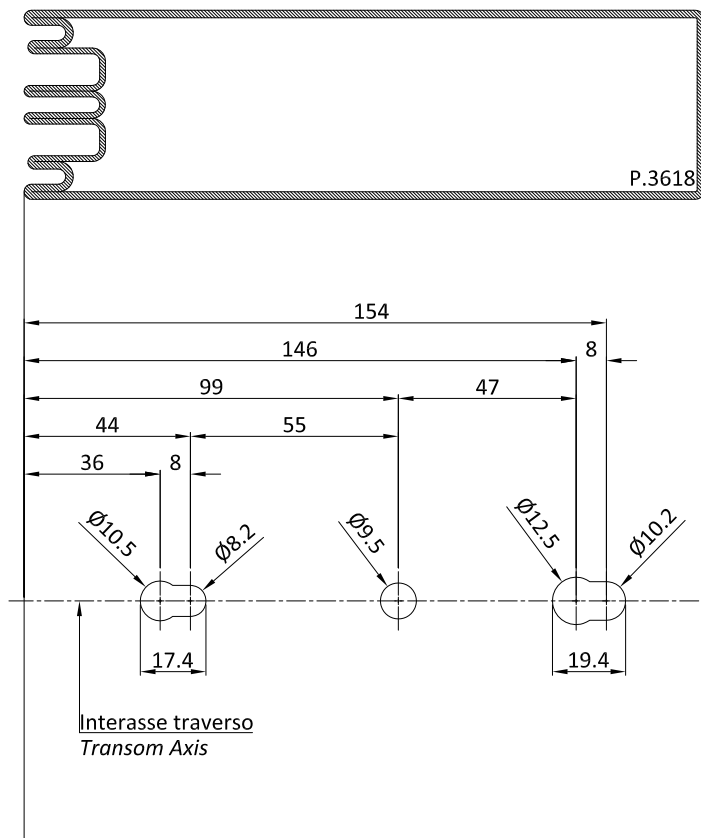
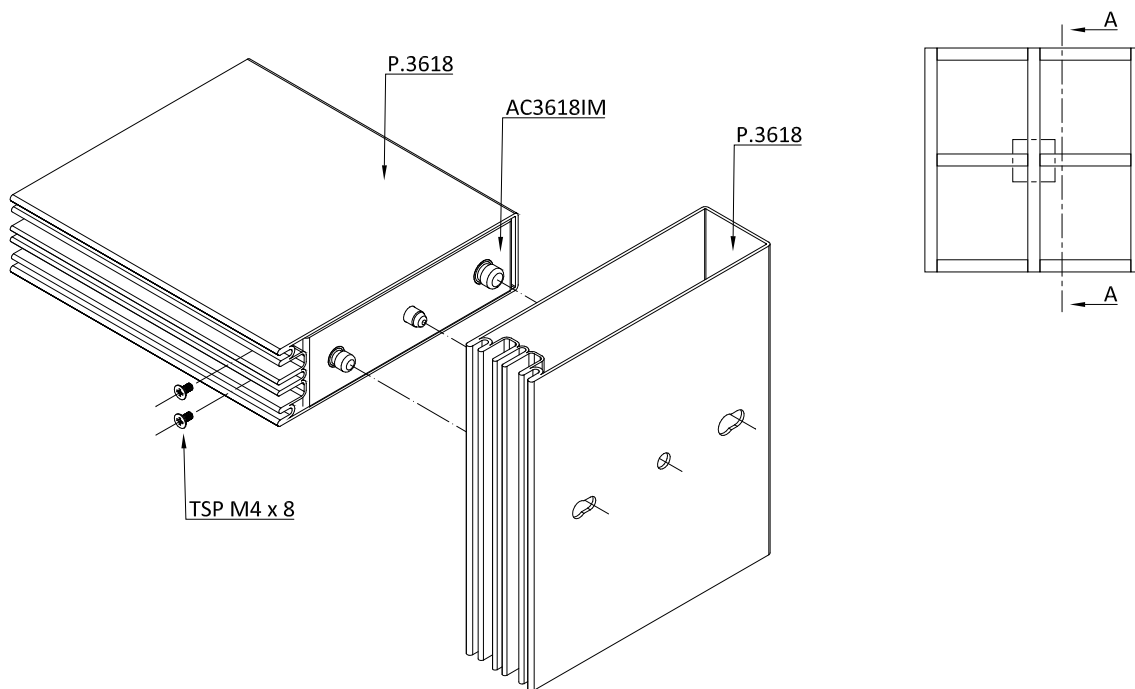


Lavorazioni su profili
Profiles workings



Applicazione traverso
Transom application

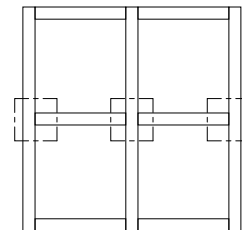
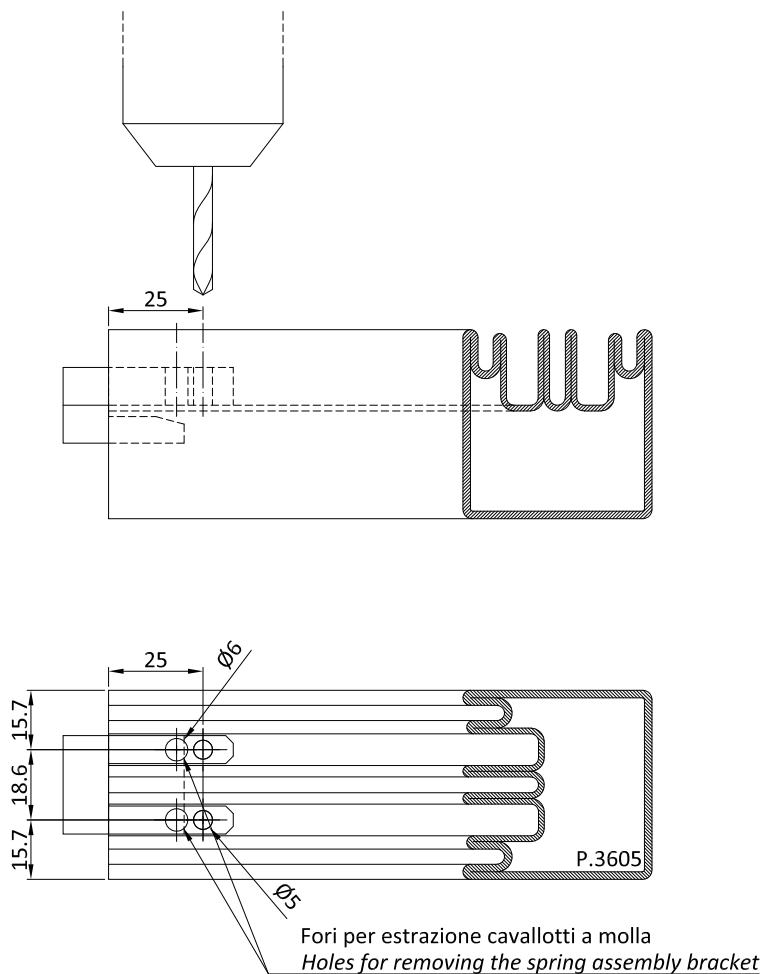
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



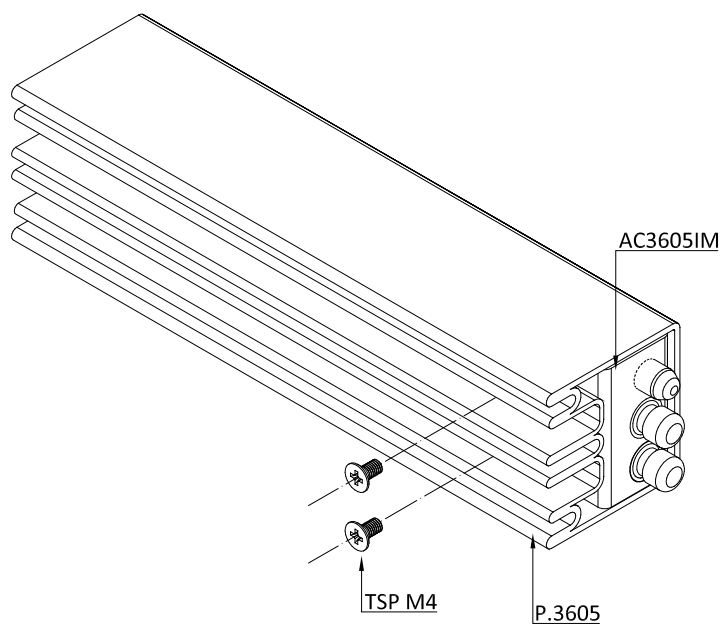
Lavorazioni su profili
Profiles workings

Applicazione trasverso
Transom application

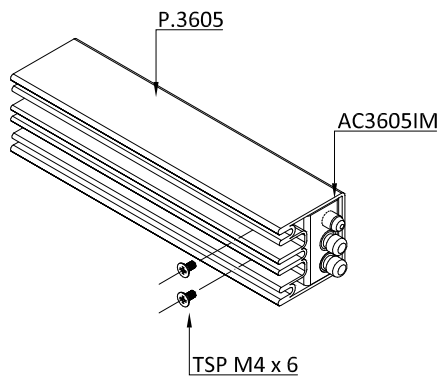
N.B.: Lavorazioni analoghe sugli altri profili montante
NOTE: Same working on other mullion profiles



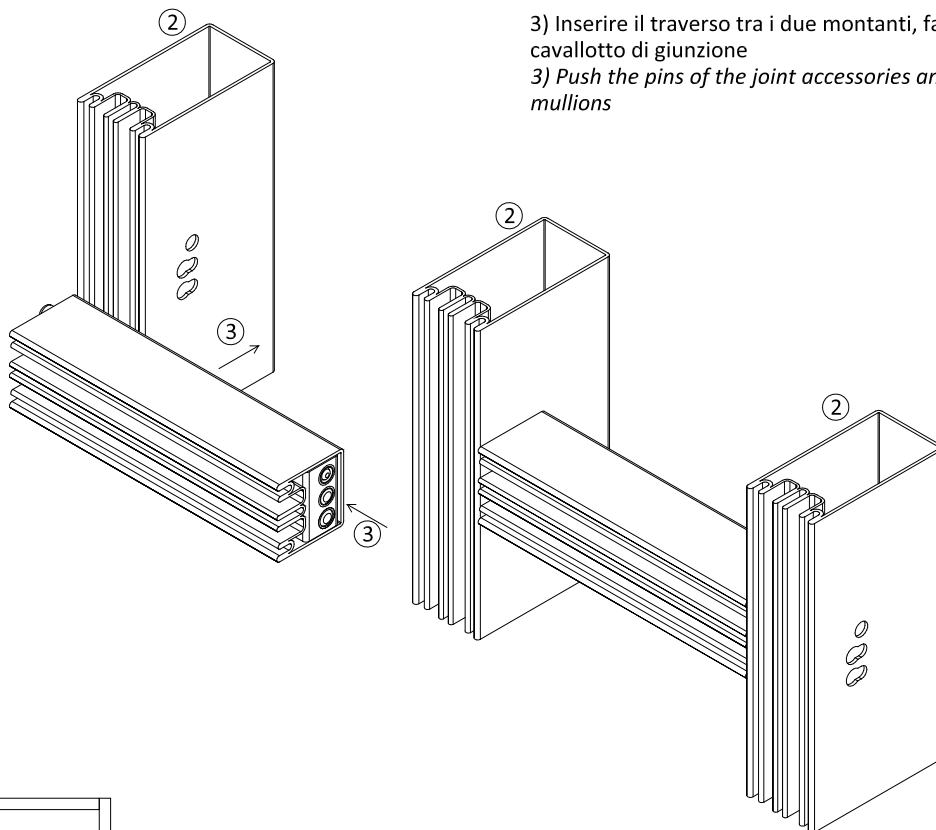
N.B.: Ai fini dellestrazione del traverso è sufficiente eseguire solo una delle due forature con $\varnothing 6$
NOTE: For extraction of the transom it is enough to execute only one of the two holes with $\varnothing 6$



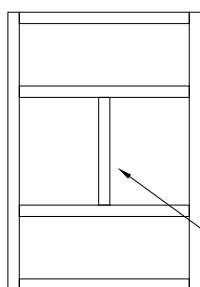
N.B.: Lavorazioni analoghe sugli altri profili traverso
NOTE: Same working on other transom profiles



- 1) Fissare il fondino al traverso utilizzando le apposite viti TSP M4 x 8 *
- 1) Fix the mullion joint accessory in the transom with TCEI M6 x 16 screws *



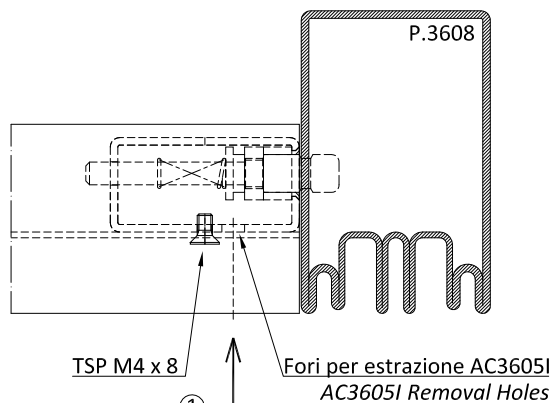
- 2) Posare priMa i montanti e fissarli a muro con le apposite staffe
- 2) Pose first the mullions and fix them on the wall by the brackets
- 3) Inserire il traverso tra i due montanti, facendo retrarre i perni del cavallotto di giunzione
- 3) Push the pins of the joint accessories and insert the transom between two mullions



NB.: Traversi verticali vanno montati in modo analogo ai traversi orizzontali
Note: Vertical transoms could be mounted in the same way of the horizontal transoms

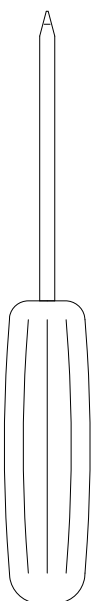
* fase 1 da eseguire in officina

* phase 1 to be performed in the workshop

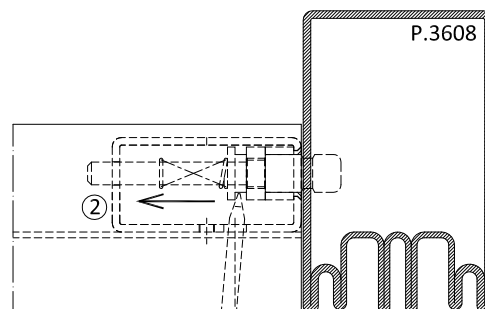


①

TSP M4 x 8

Fiori per estrazione AC3605I
AC3605I Removal Holes

1) Rimuovere le viti di fissaggio TSP M4 x 8. Inserire un cacciavite a taglio con diametro $\varnothing < 5$ mm in uno degli appositi fori per l'estrazione
1) Remove the the TSP M4 x 8 screws. Insert a slot screwdriver with diameter $\varnothing < 5$ mm in one of the removal holes

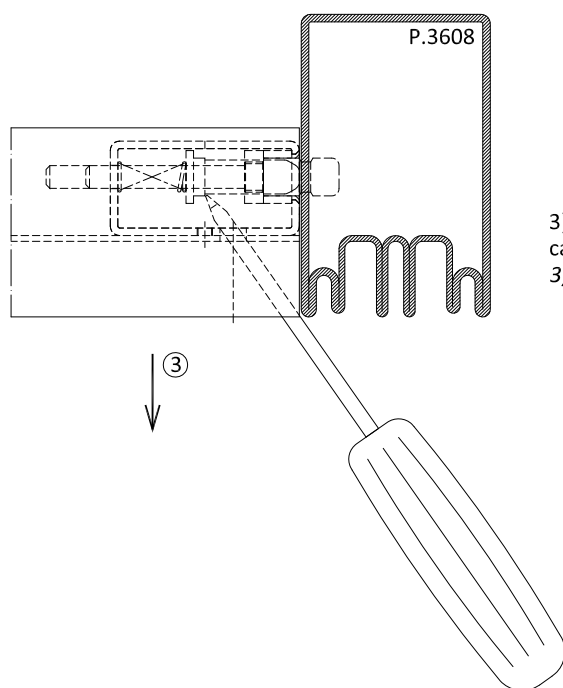


②



2) Ritirare in direzione opposta al montante il perno centrale tramite la piastrina di aggancio, per circa 10 mm

2) Push inward the central pin for about 10 mm.

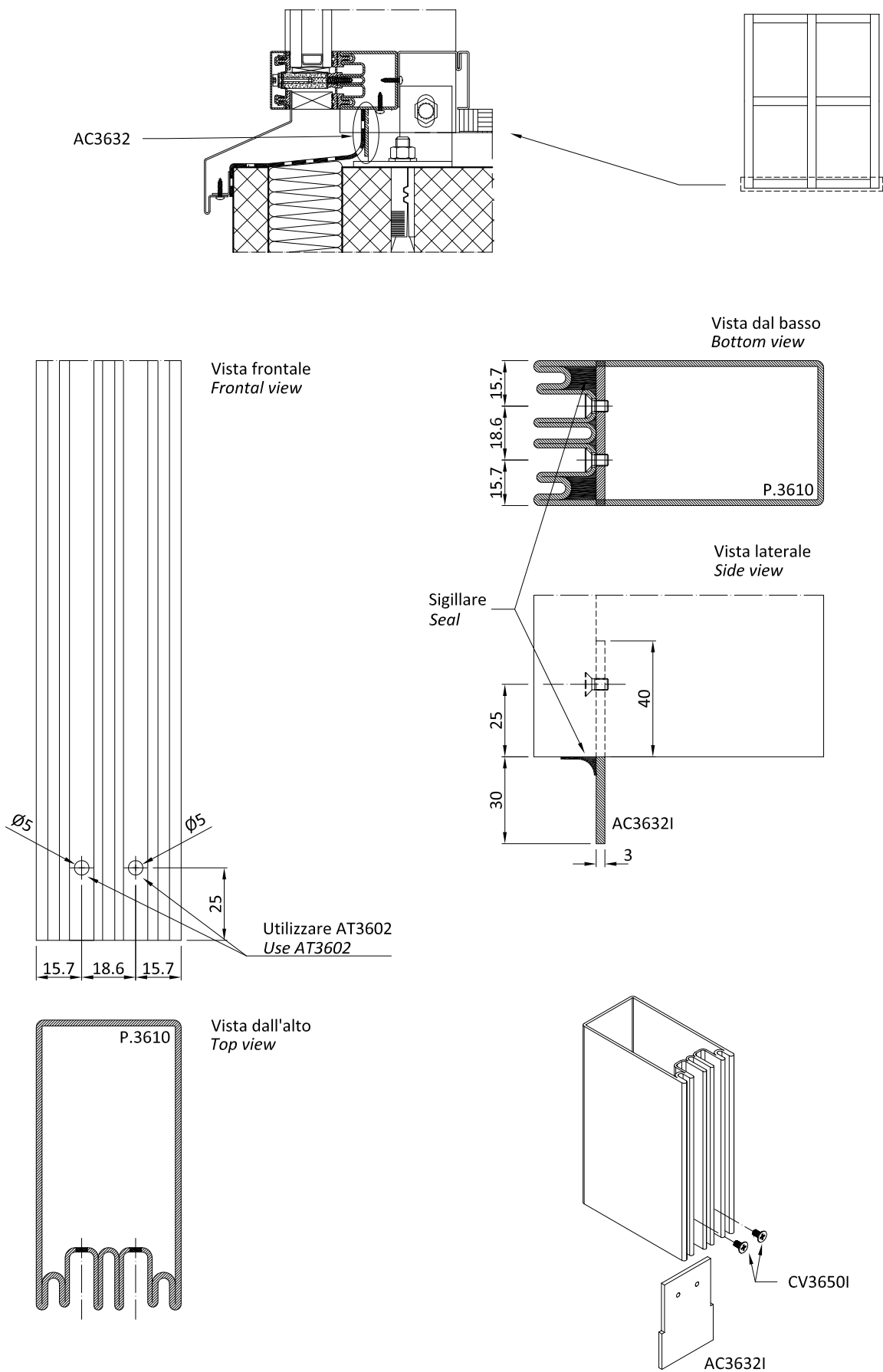


③

3) Sfilare il traverso mantenendo represso il perno centrale del cavalletto di giunzione

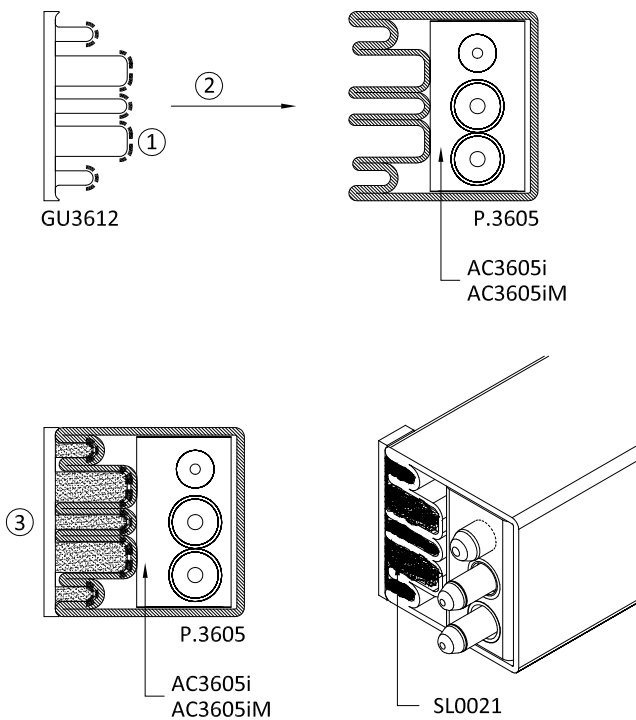
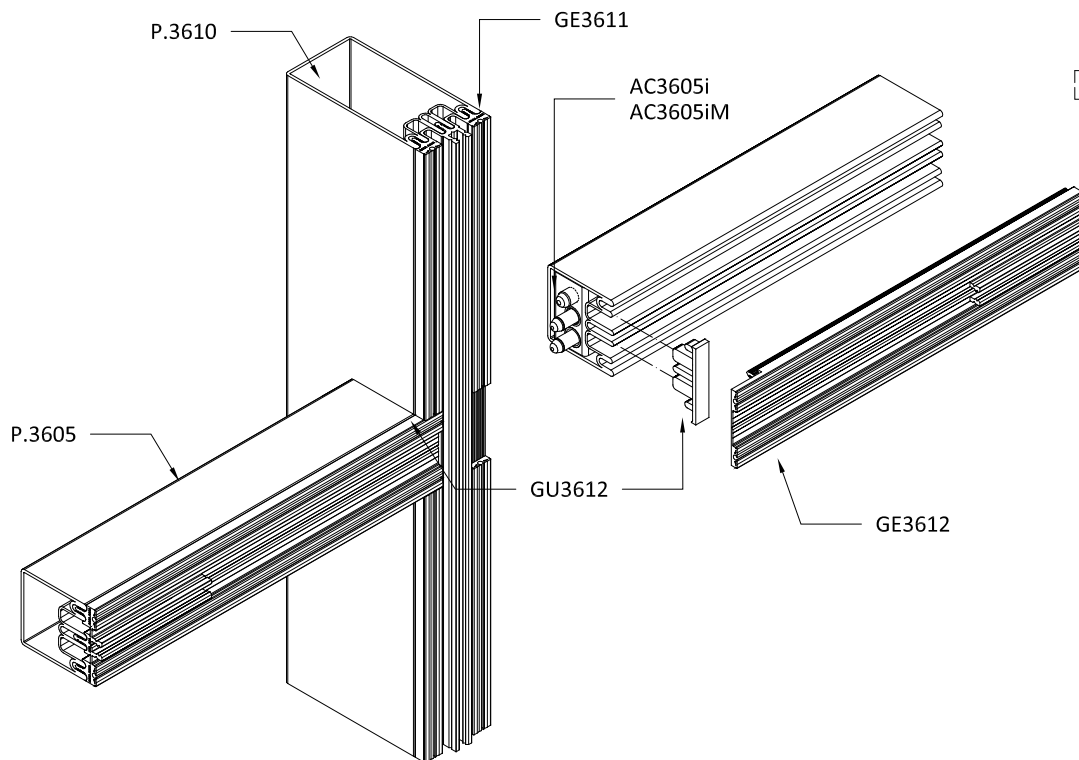
3) Remove the transom keeping retracted the central pin of the joint accessory

NB.: Operazione analoga per tutte le tipologie di cavalletto
NOTE.: This process is the same for every kind of joint accessory



NB: AC3632I permette l'incollatura della guaina per lo scarico acqua ai piedi del montante. Soluzioni alternative devono essere studiate in fase progettuale

NOTE: AC3632I allows to joint the sheath for discharging water in the bottom of the mullion. Alternative solutions must be studied at the design stage



1) Applicare silicone SL0021 sui piedi d'aggancio dell'accessorio GU3612

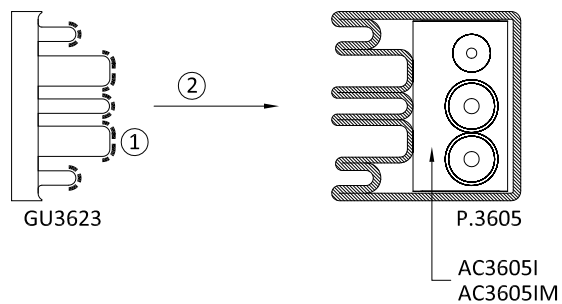
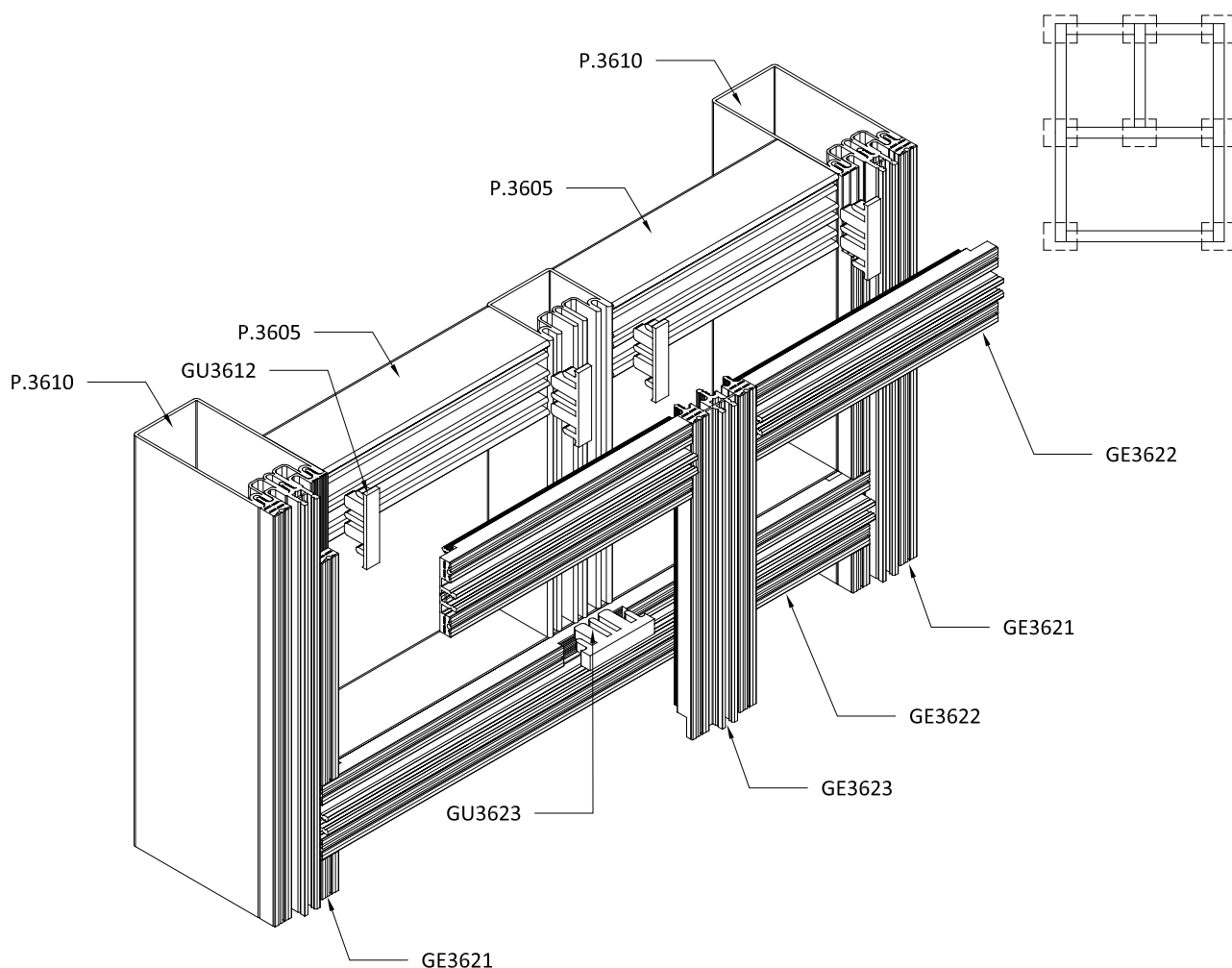
2) Inserire GU3612 in corrispondenza delle teste del profilo trasverso

3) Sigillare con SL0021 la testa del trasverso, in modo da impedire l'uscita di eventuale acqua presente nei canali

1) Apply SL0021 on the bottom of GU3612 as indicated

2) Insert GU3612 into the heads of the transom profile

3) Seal with SL0021 the heads of the transom in order to prevent the exit of any water in the grooves



1) Applicare silicone SL0021 sui piedi d'aggancio dell'accessorio GU3623

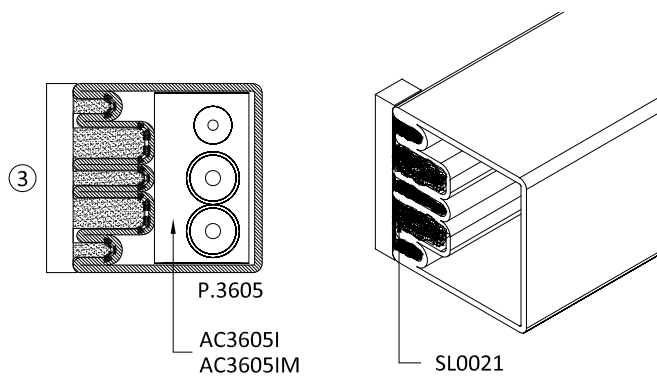
2) Inserire GU3623 in corrispondenza delle teste del profilo trasverso

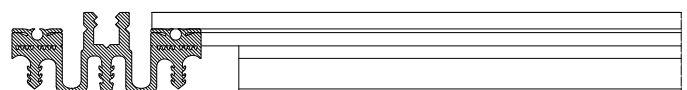
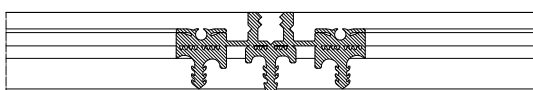
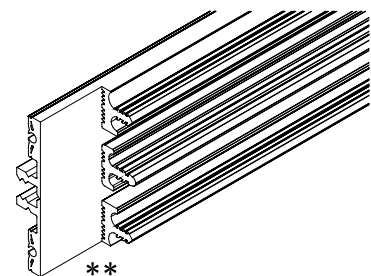
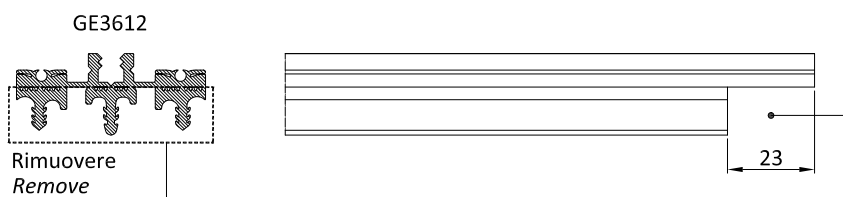
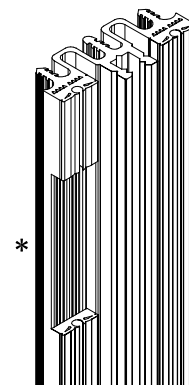
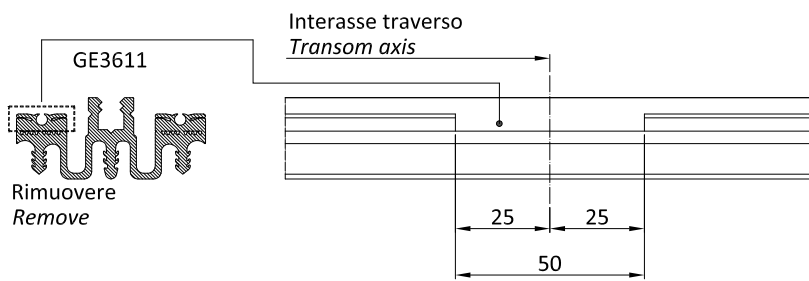
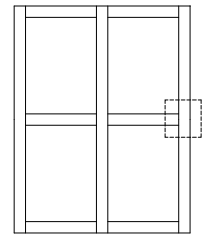
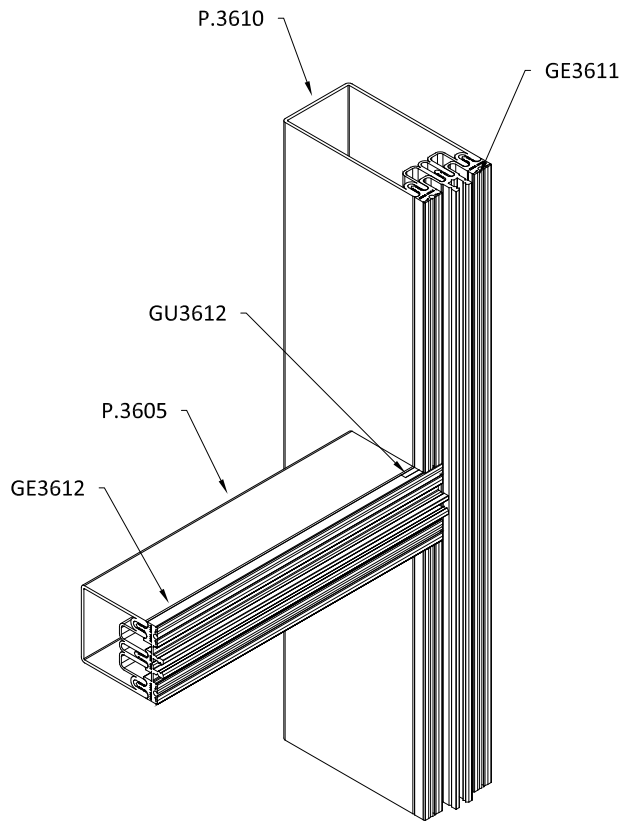
3) Sigillare con SL0021 la testa del trasverso, in modo da impedire l'uscita di eventuale acqua presente nei canali

1) Apply SL0021 on the bottom of GU3623 as indicated

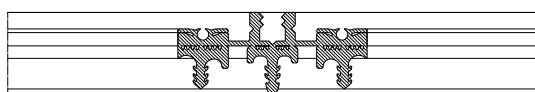
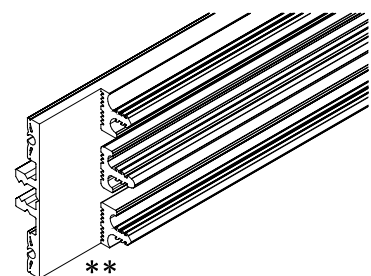
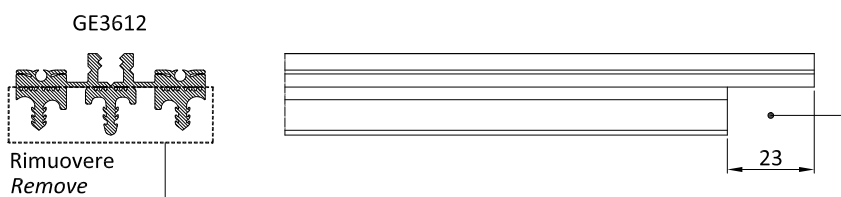
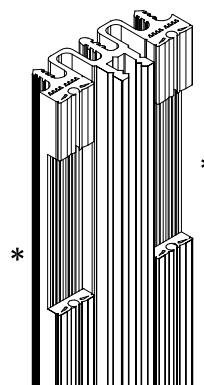
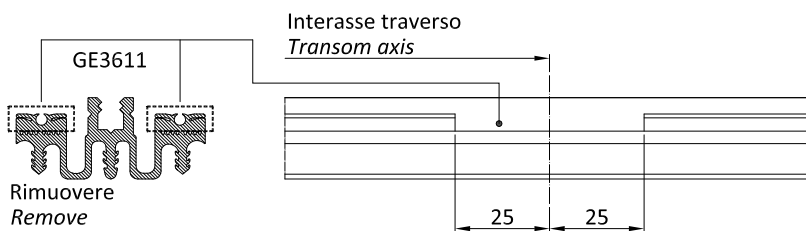
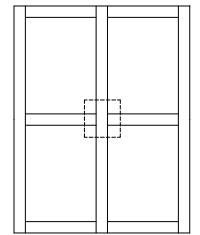
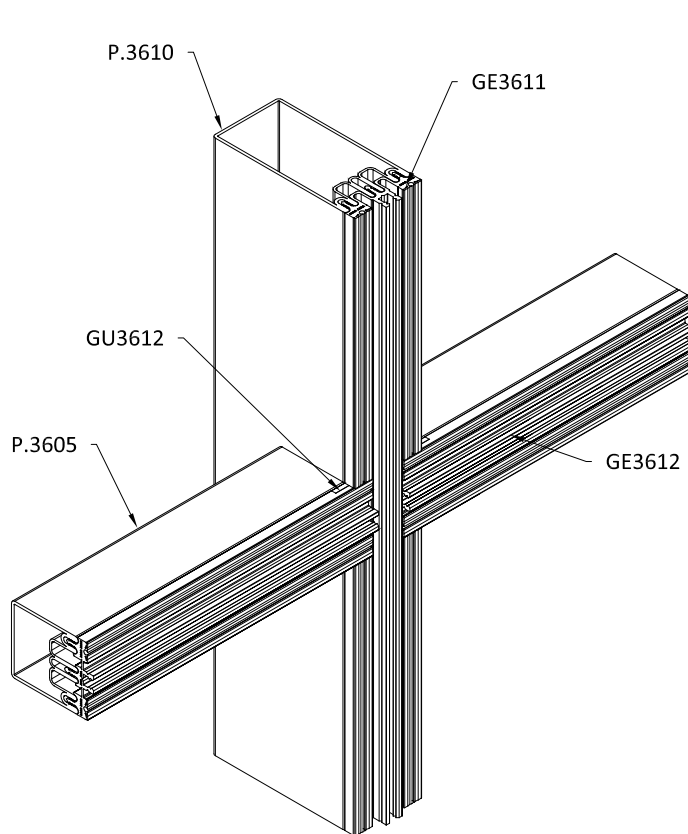
2) Insert GU3623 into the heads of the transom profile

3) Seal with SL0021 the heads of the transom in order to prevent the exit of any water in the grooves

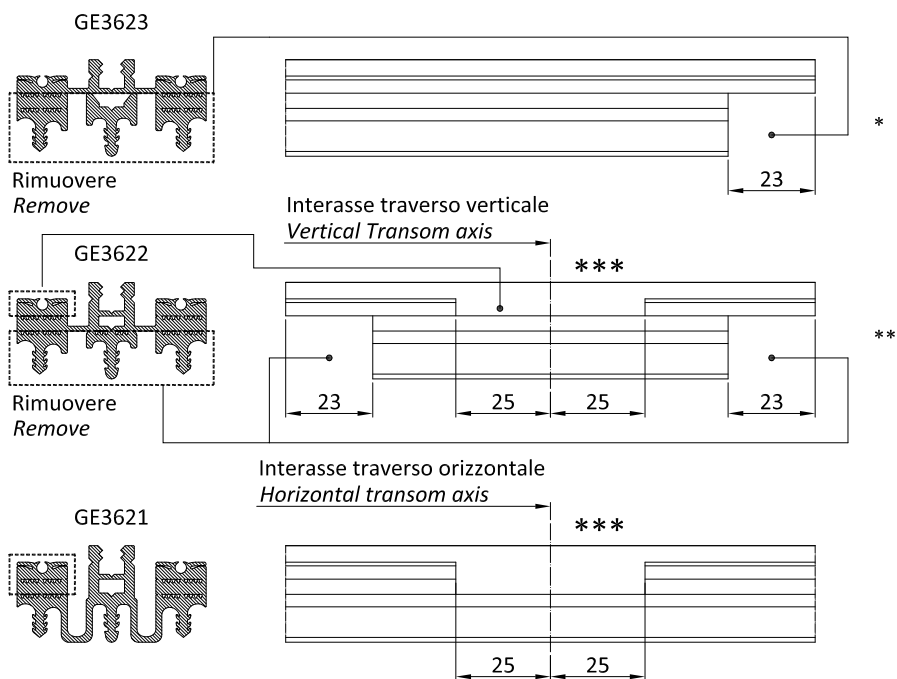
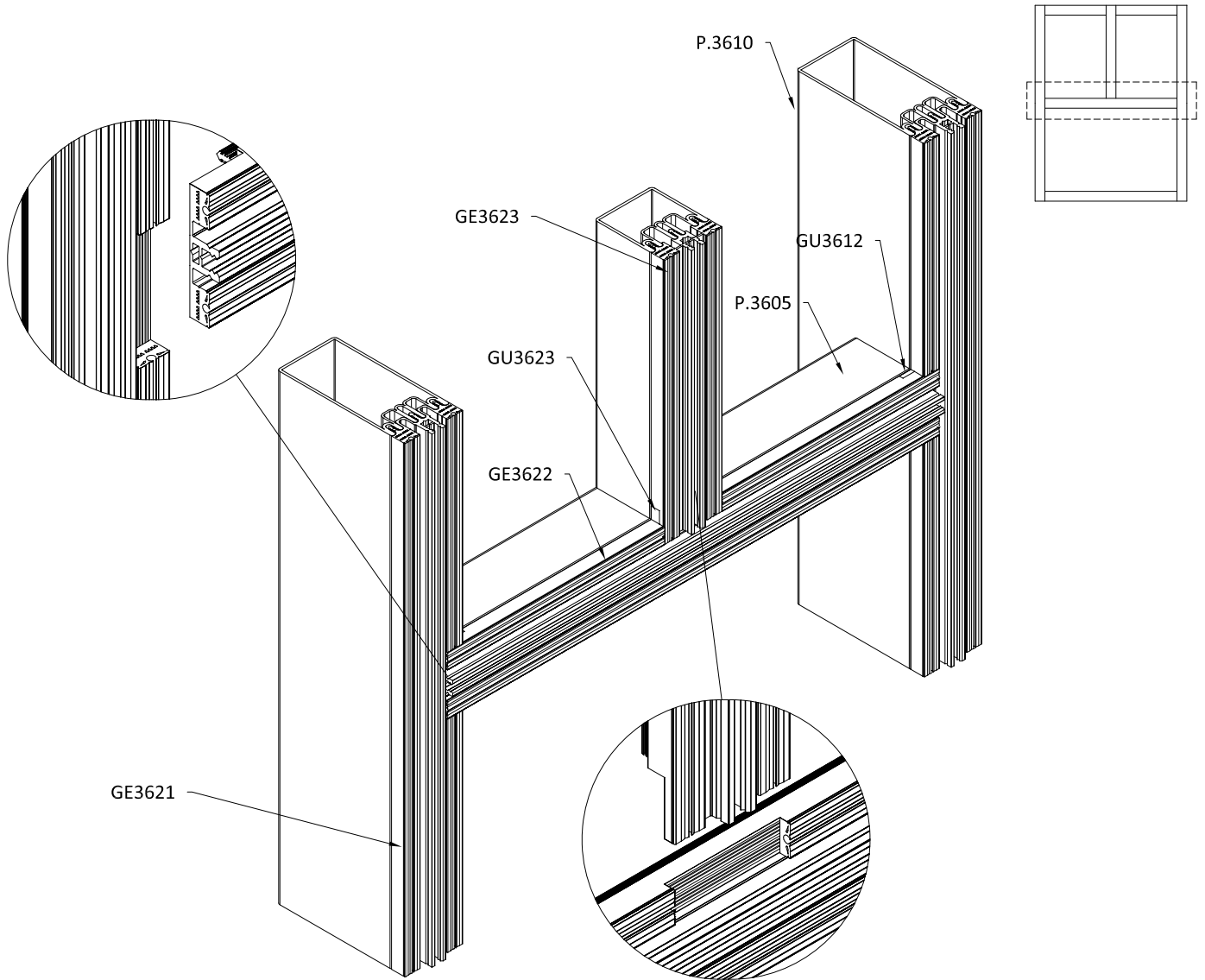




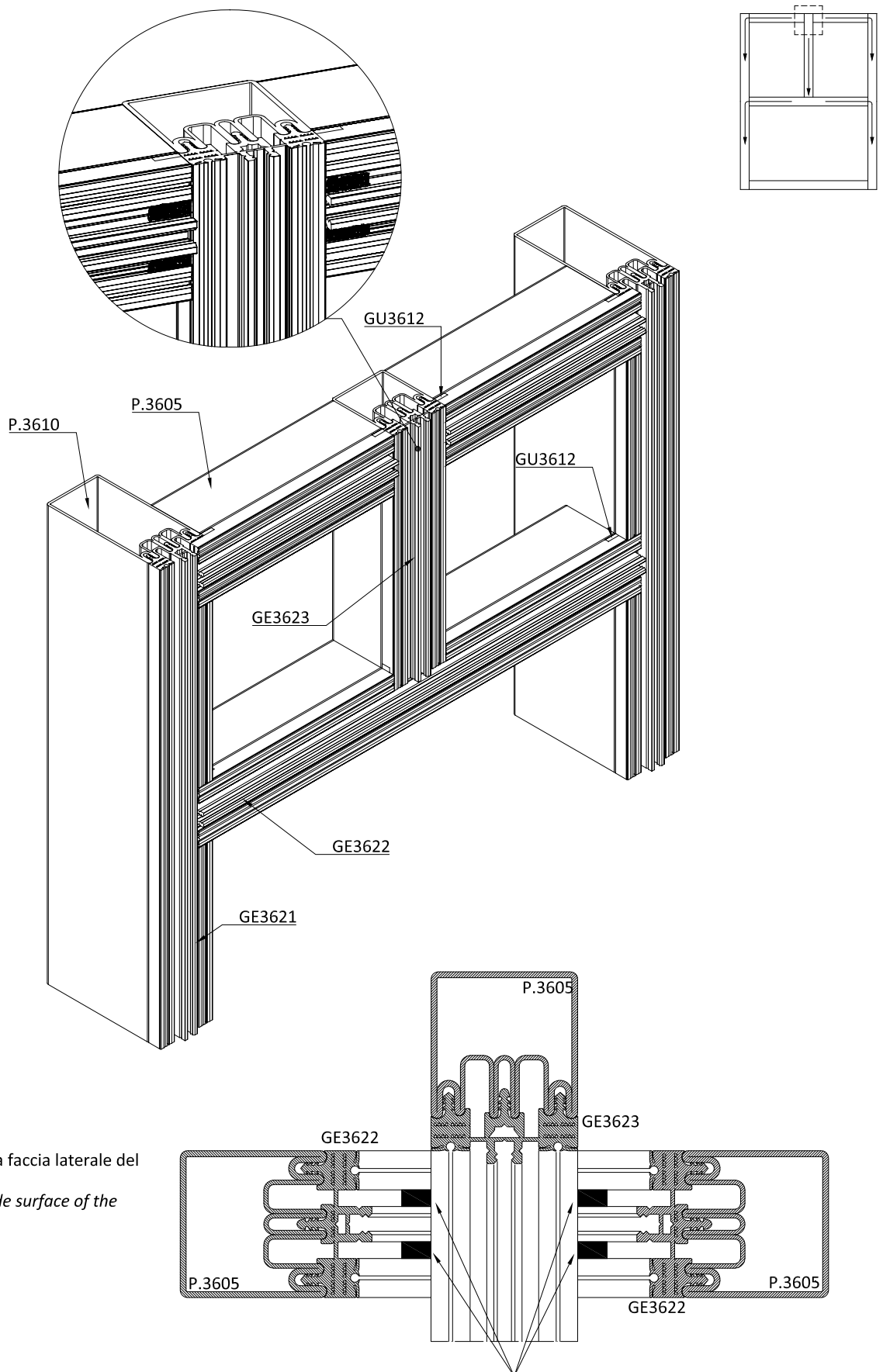
- * utilizzare AT3614
- ** utilizzare AT3611
- * use AT3614
- ** use AT3611



- * utilizzare AT3614
- ** utilizzare AT3611
- * use AT3614
- ** use AT3611

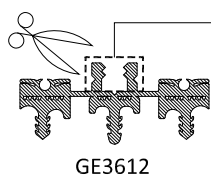
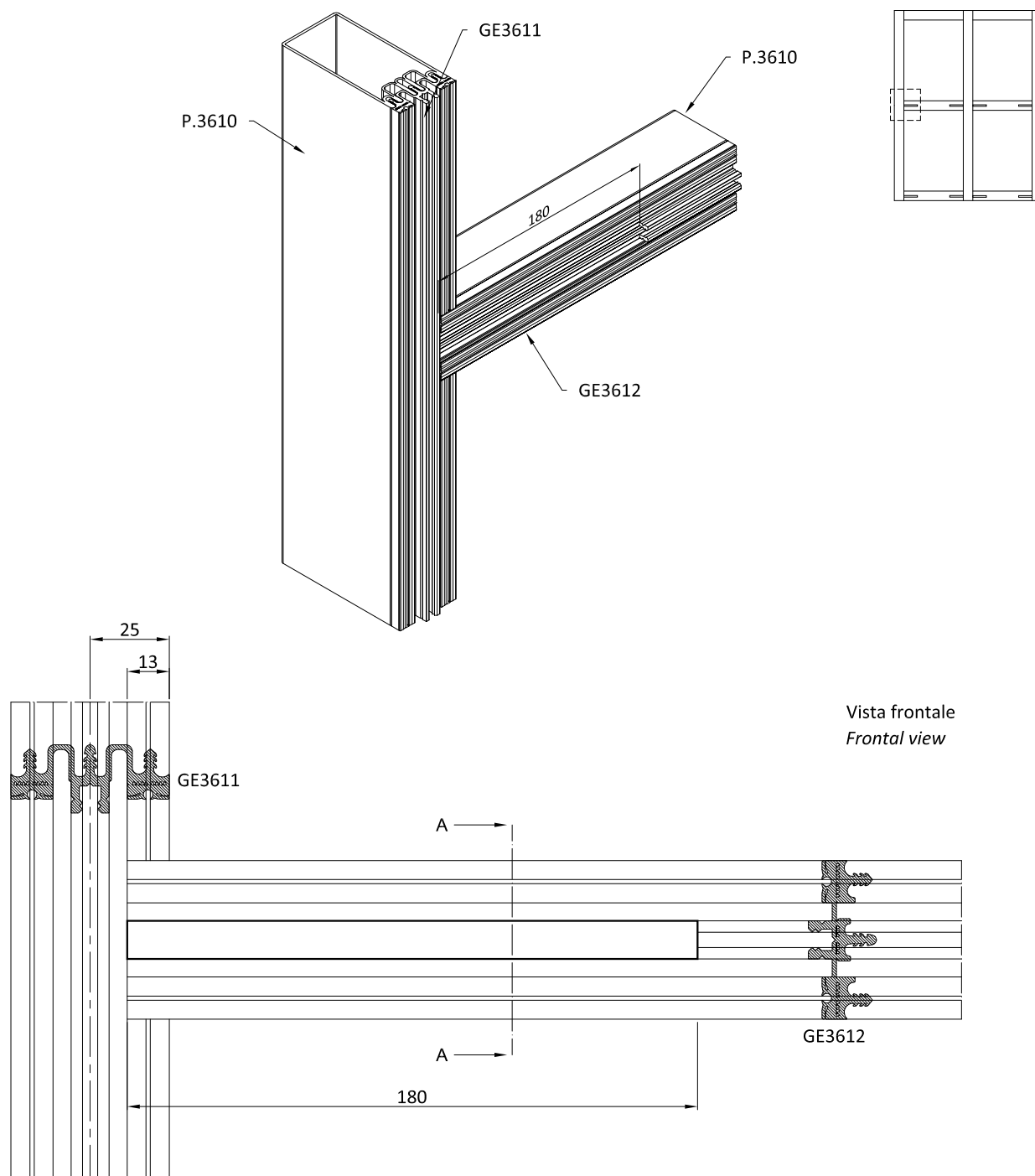


- * utilizzare AT3611
- ** utilizzare AT3612
- *** utilizzare AT3614
- * use AT3611
- ** use AT3612
- *** use AT3614



Tagliare GE3622 a filo della faccia laterale del
traverse verticale.
*Cut GE3622 close to the side surface of the
vertical transom profile*

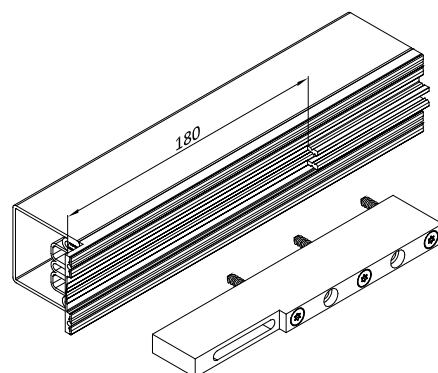
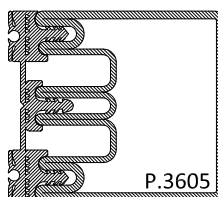
Sigillare con SL0021 la zona di scolo acqua della GE3622,
in corrispondenza della testa della guarnizione
*Seal with SL0021 the water flow zone of GE3622,
close to the head of the weather strip*



AC3622

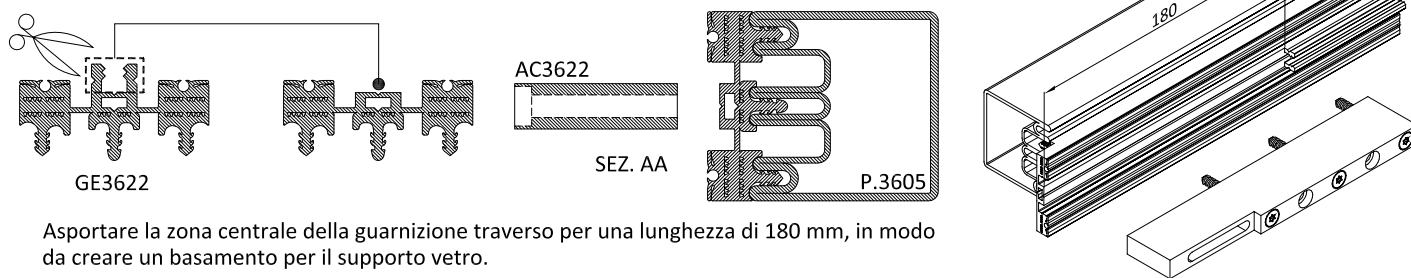
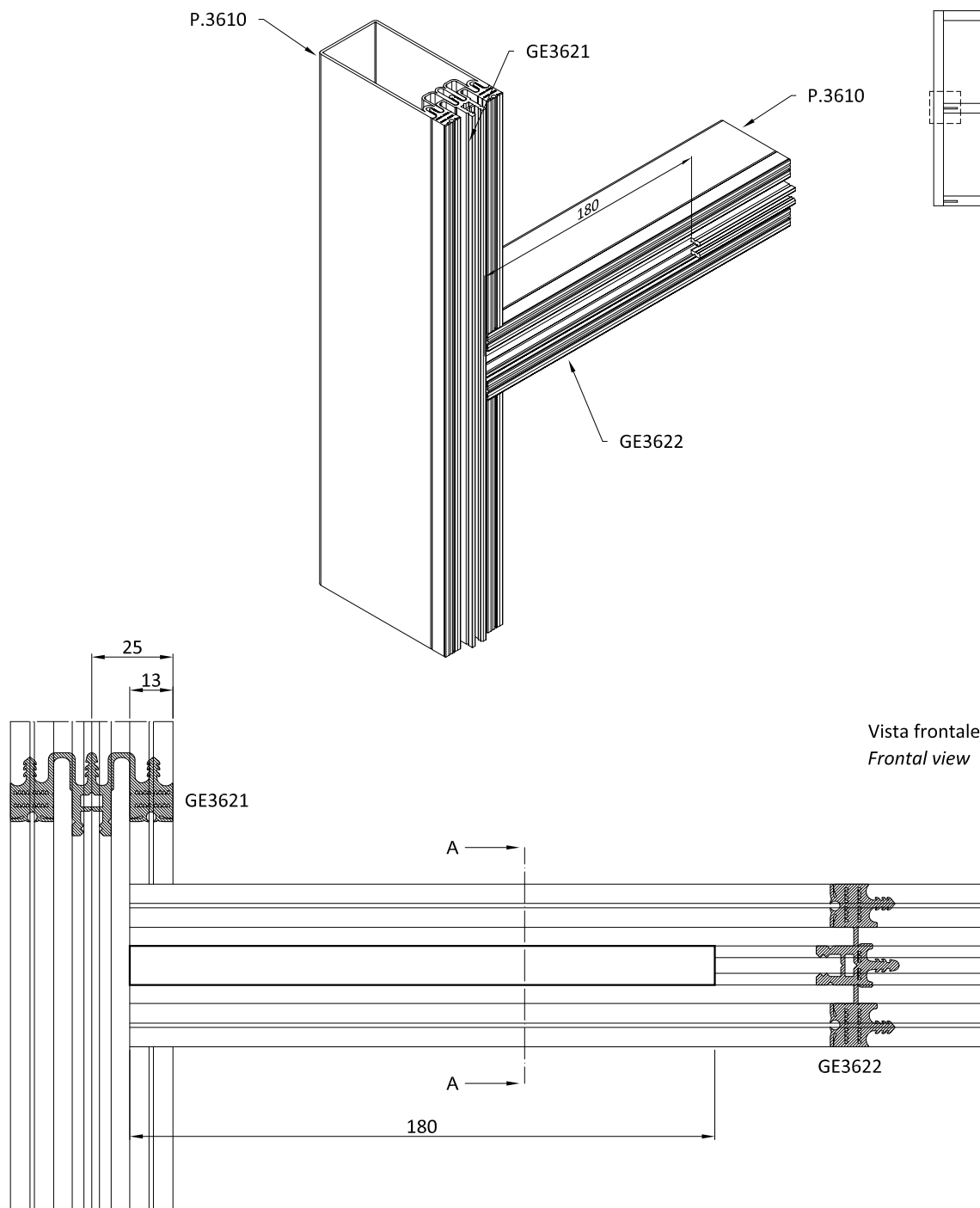


SEZ. AA



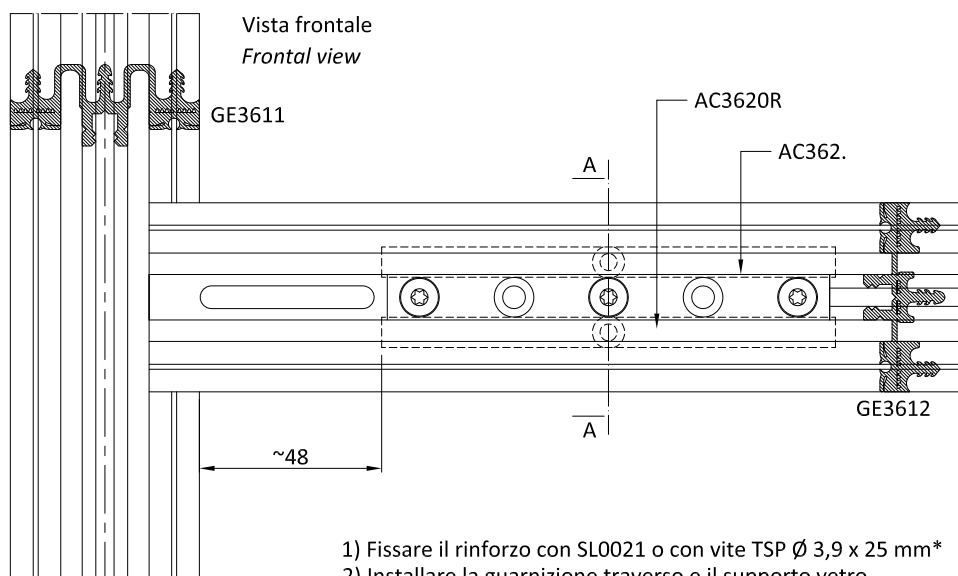
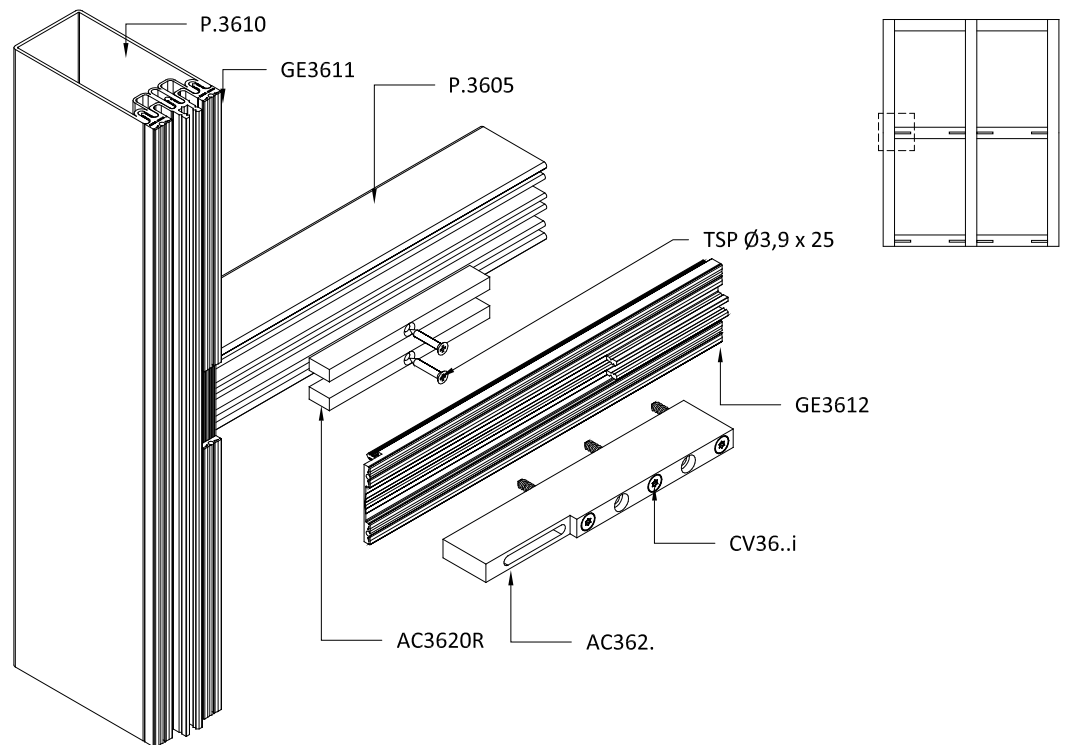
Asportare la zona centrale della guarnizione traverso per una lunghezza di 180 mm, in modo da creare un basamento di appoggio per il supporto vetro.

Remove the central zone of the weather strip, for a length of 180 mm in order to create a base for the glass support

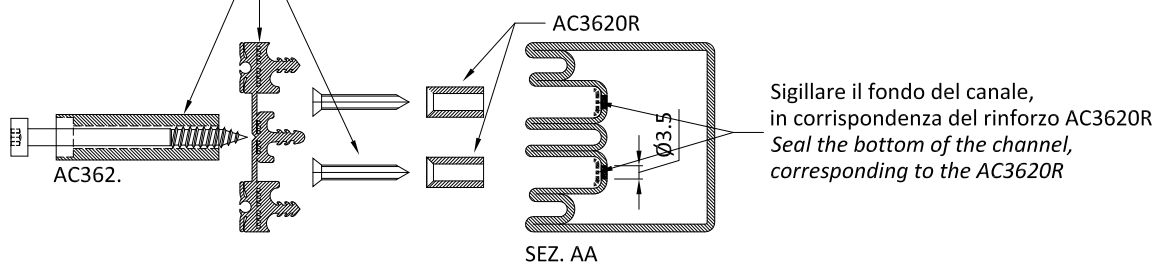


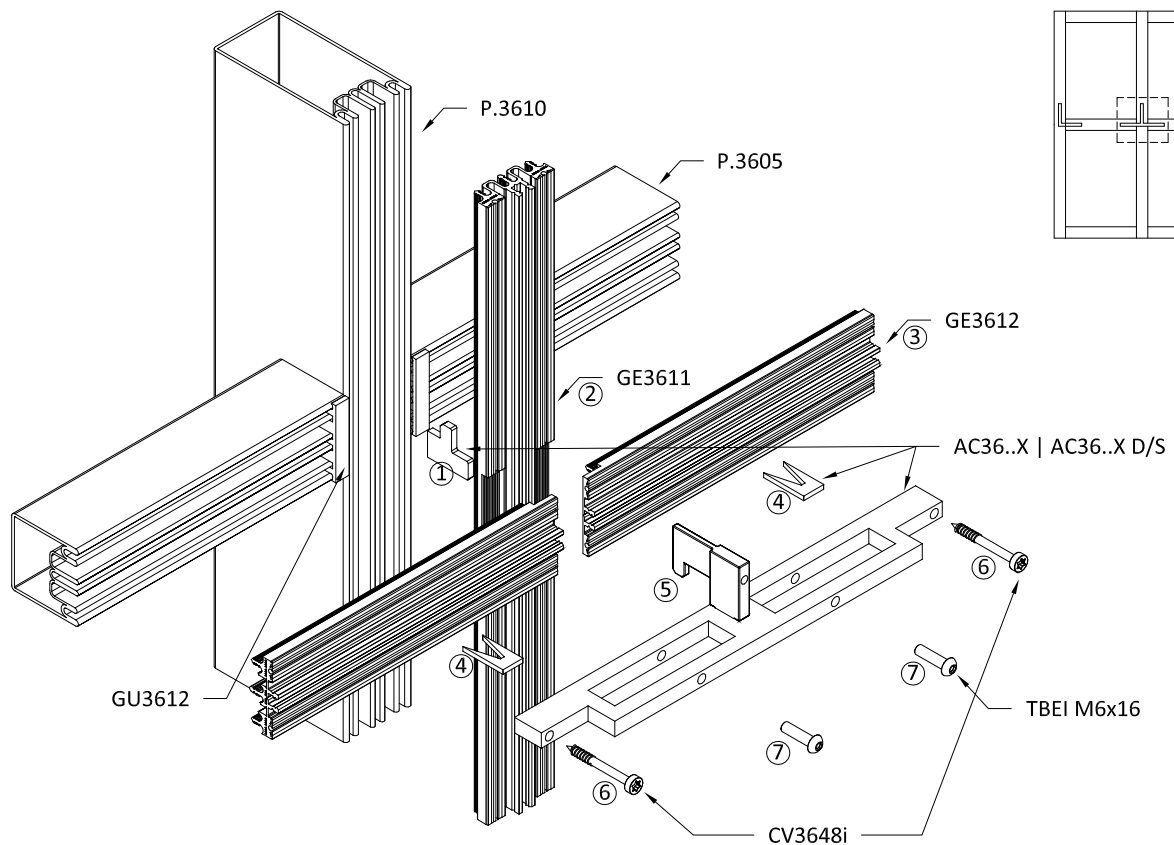
Asportare la zona centrale della guarnizione traverso per una lunghezza di 180 mm, in modo da creare un basamento per il supporto vetro.

Remove the central zone of the weather strip, for a length of 180 mm in order to create a base for the glass support



- 1) Fissare il rinforzo con SL0021 o con vite TSP \varnothing 3,9 x 25 mm*
- 2) Installare la guarnizione trasverso e il supporto vetro
- 1) Fix the reinforcement accessory with SL0021 or FH \varnothing 3,9 x 25 mm screw*
- 2) Install the transom weather strip and the glass support





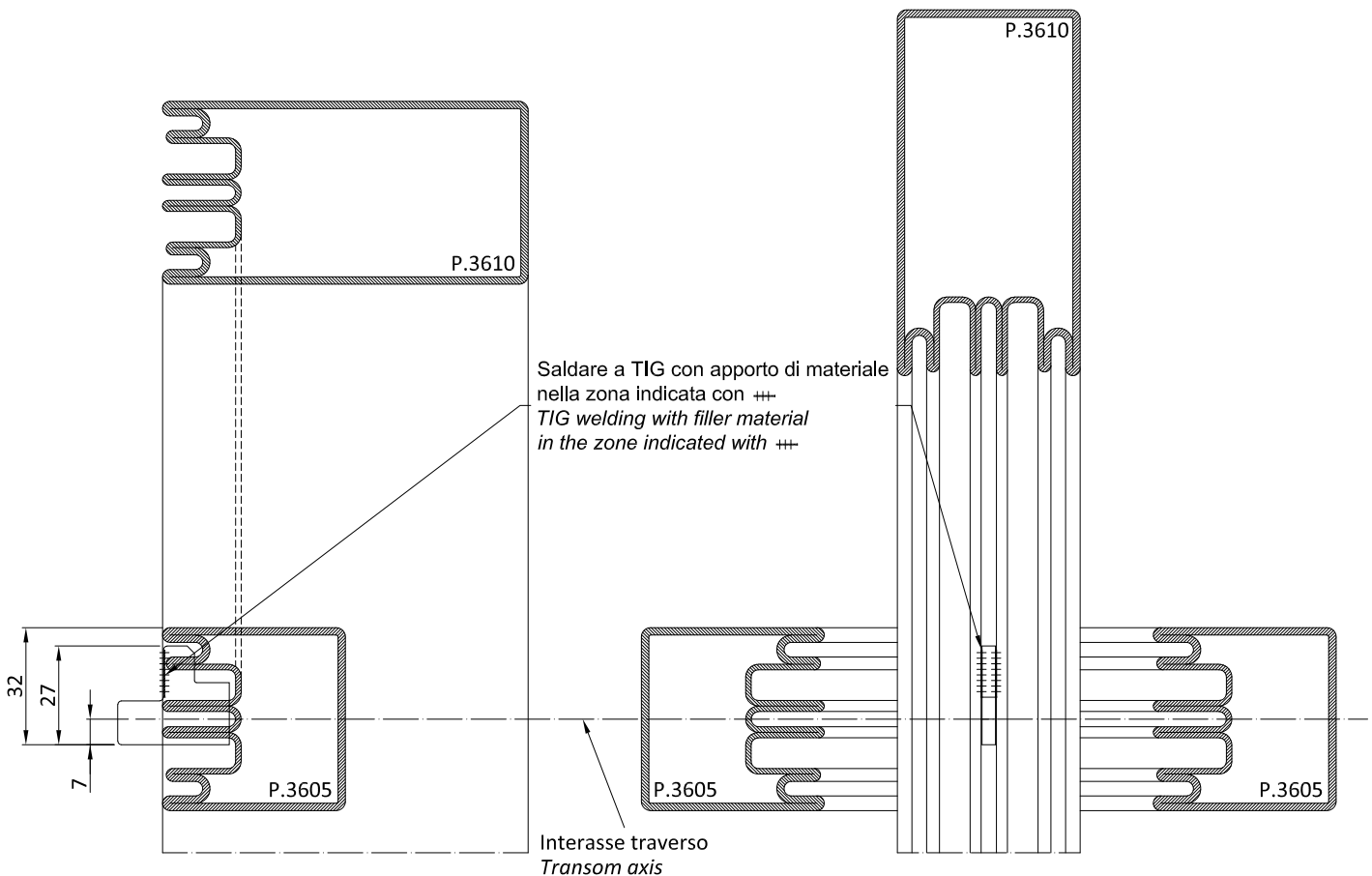
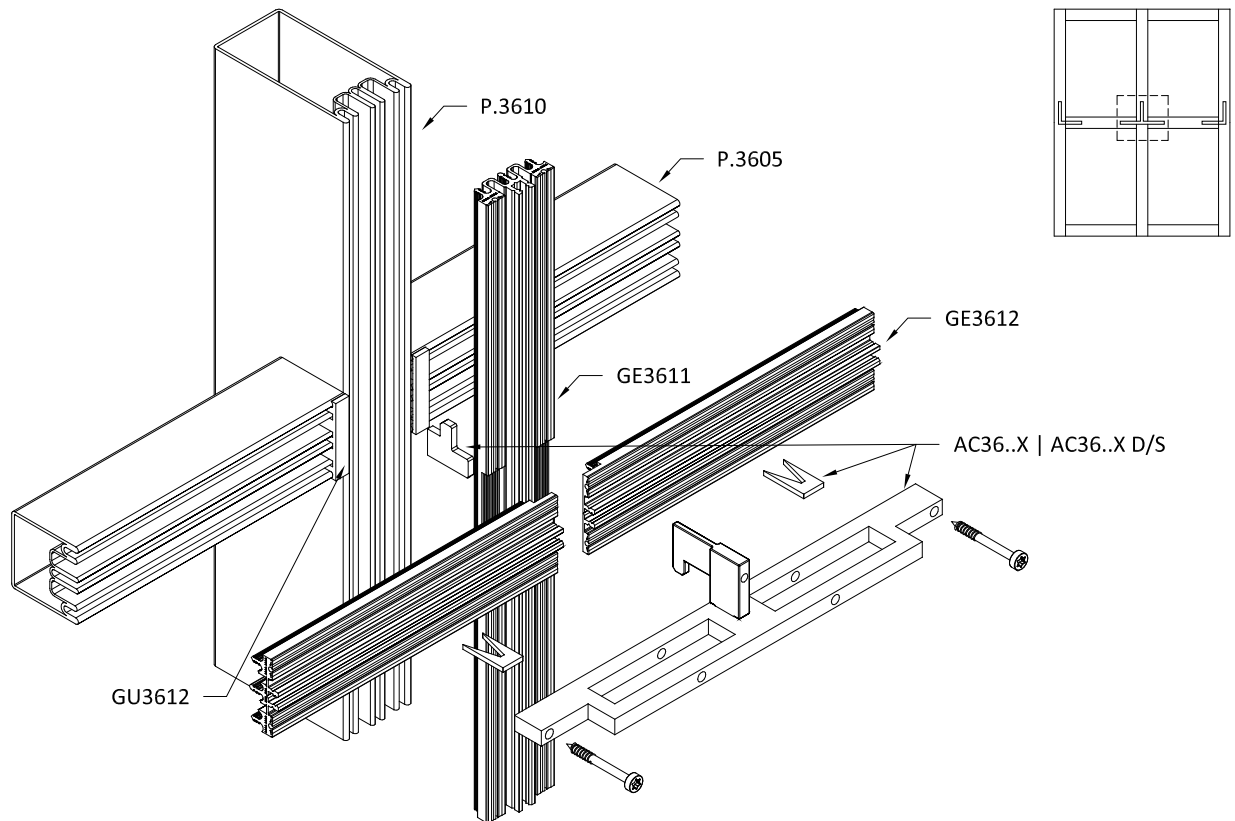
Sequenza di Montaggio

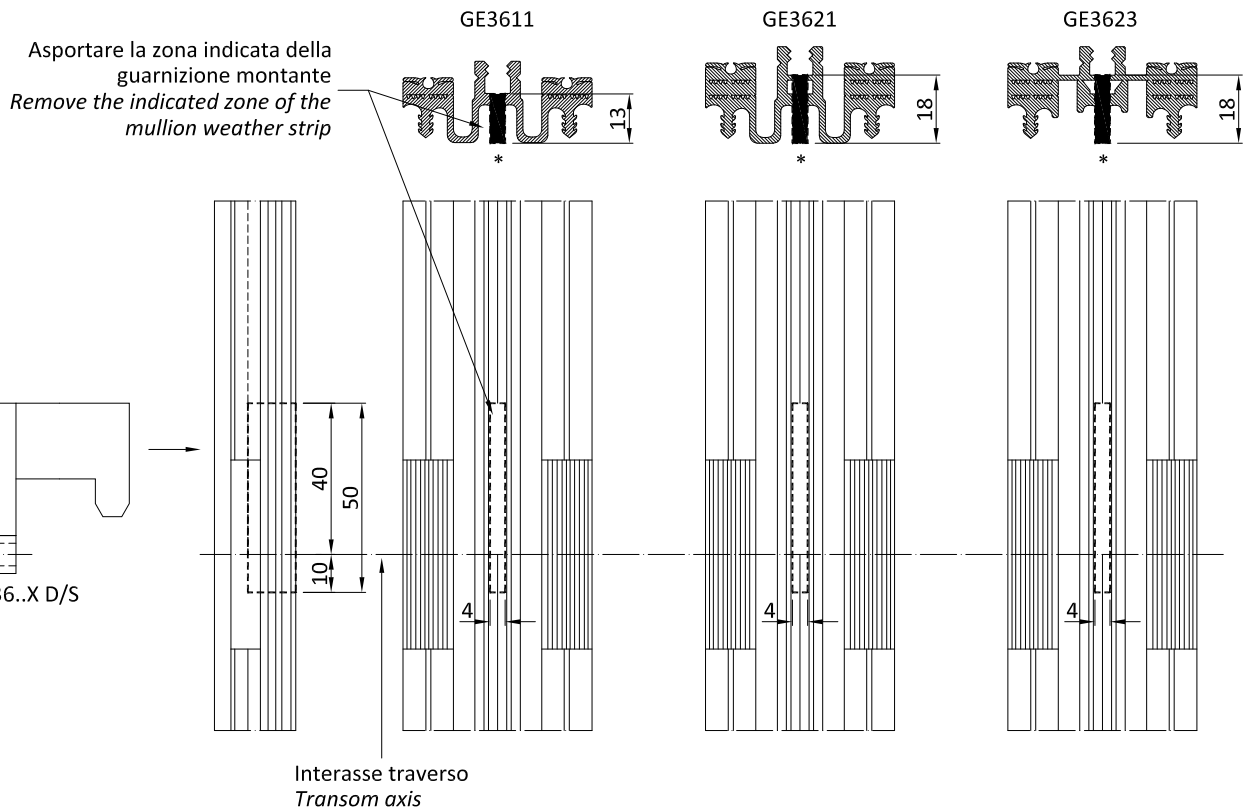
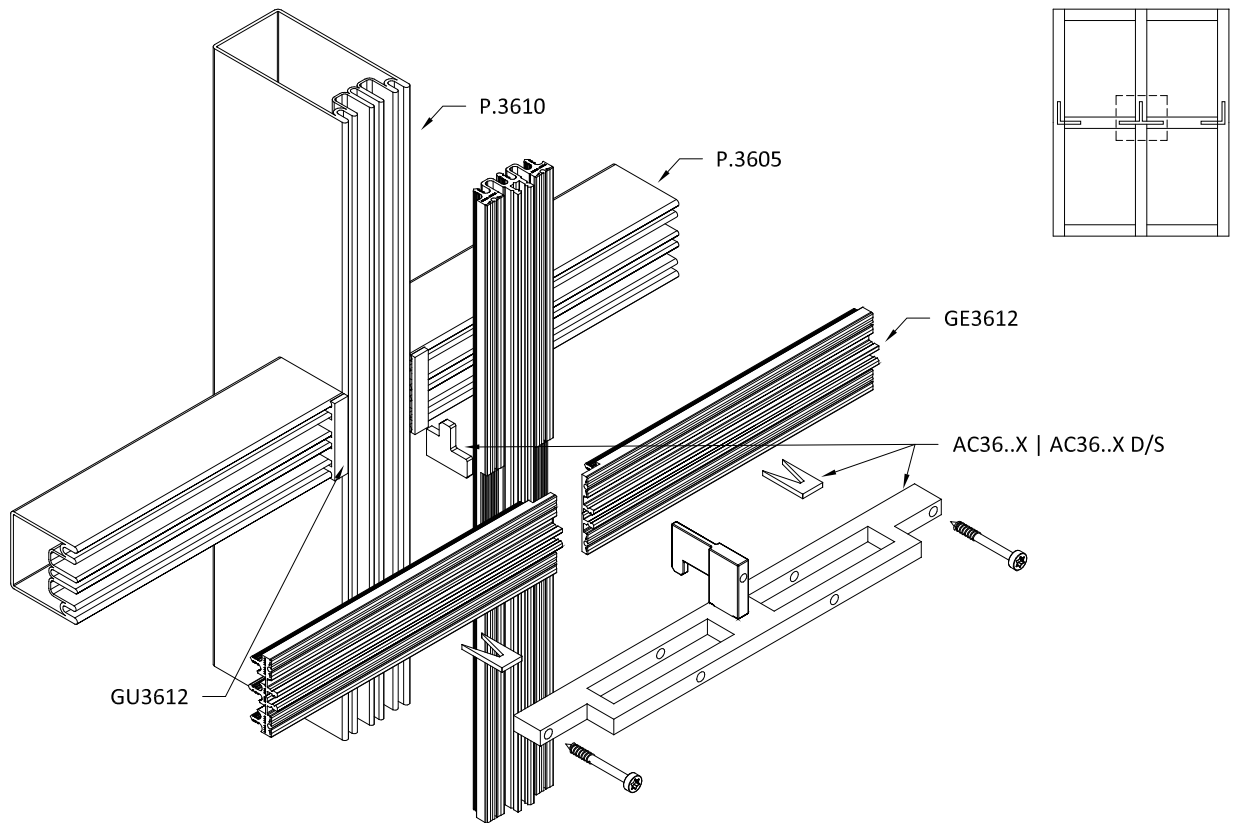
In officina / In workshop:

- ① Saldare a Tig nella posizione indicata l'accessorio con geometria a L nel canale centrale del profilo montante
Weld by Tig the L shape accessory in the central channel of the mullion profile in the indicated position
- ② Installare la guarnizione montante dopo aver creato una feritoia nella zona indicata
Install the mullions' weather strip after making a vent on the indicated area
- ③ Installare la guarnizione trasverso
Install the transom's weather strip
- ④ Inserire con l'aiuto di un martello le apposite piastre a forchetta nel canale centrale del trasverso
Insert with an hammer the fork shaped plates in the central channel of the transom

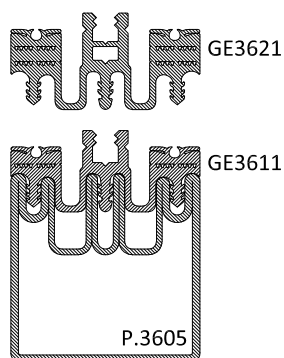
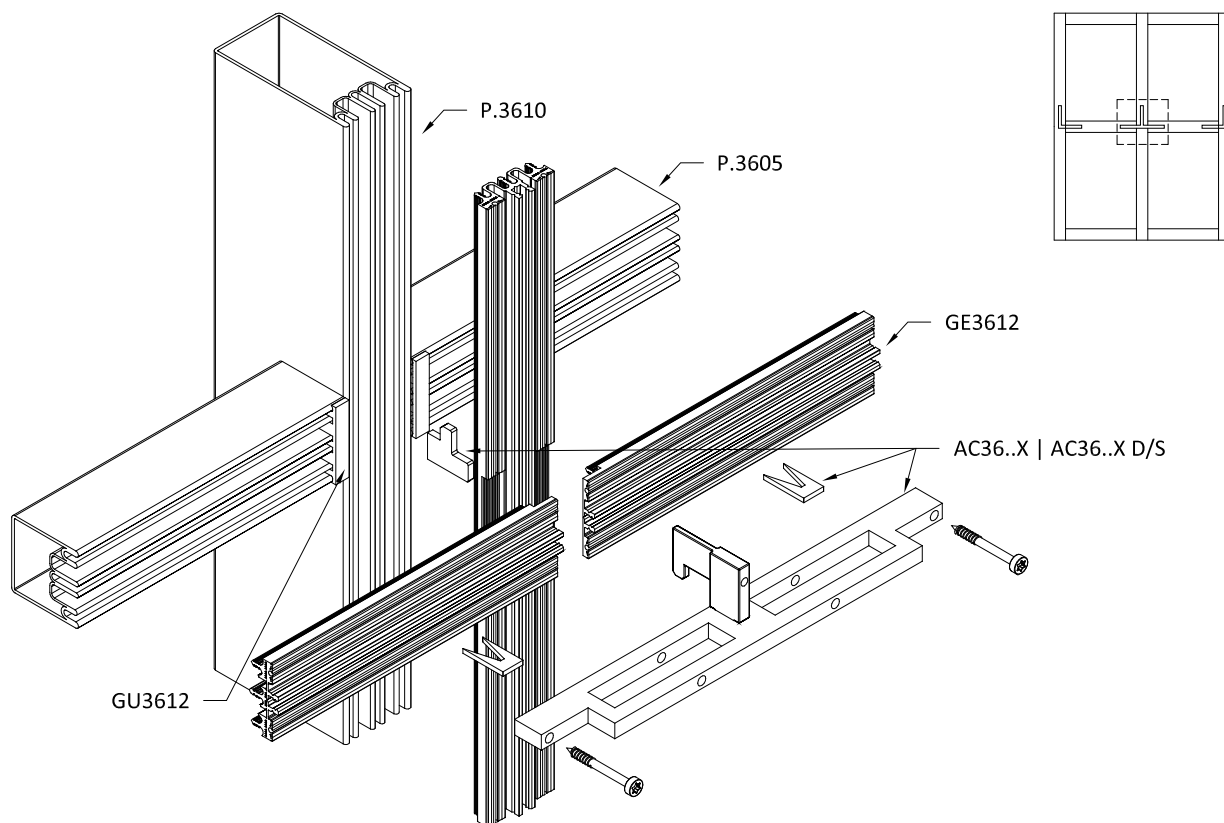
In cantiere / In the dockyard:

- ⑤ Agganciare il supporto vetro alla piastra saldata nel canale centrale del montante
Hook the glass support with the welded plate located in the central channel of the mullion
- ⑥ Fissare il supporto vetro al trasverso tramite le apposite viti nel kit
Fix the glass support on the transom by the screws in the kit
- ⑦ Utilizzare le viti TBEI M6 x 16 per fissare le teste dei pressori del trasverso al supporto vetro (pag. 5.3.2)
Use the button head M6 x 16 screws to fix the heads of the P.3403 transom profile on the glass support (page 5.3.2)

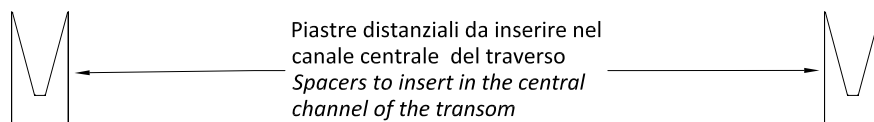
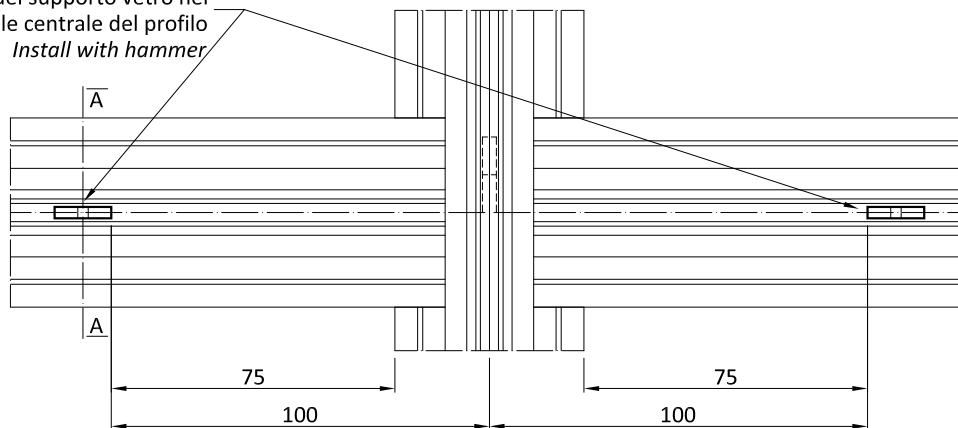
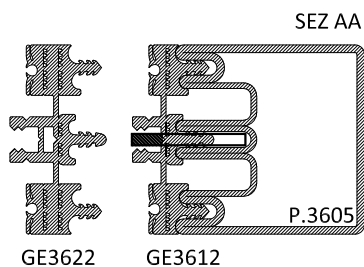


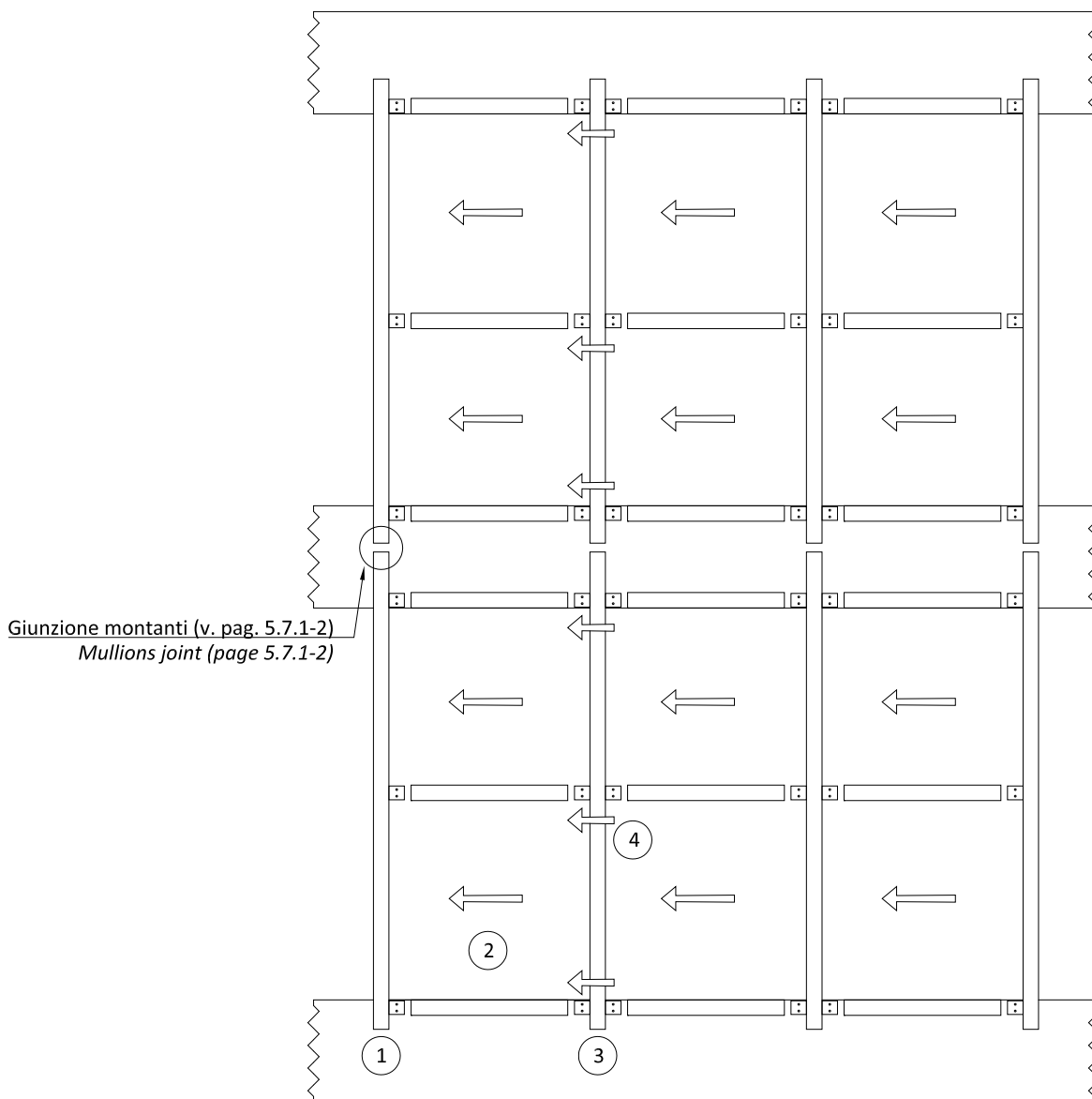


* utilizzare AT3613
** use AT3613



Installare tramite martello l'accessorio per battuta del supporto vetro nel canale centrale del profilo
Install with hammer





Sistema con traversi a montaggio sequenziale

Sistema di montaggio previsto per fondini ad avvitare serie AC36..i pre-installati sui montanti

- ① Installare la prima fila di montanti tramite le apposite staffe di fissaggio *
 - ② Inserire e fissare la testa dei traversi nel fondino pre-installato sul montante con le apposite viti
 - ③ Installare la fila successiva di montanti tramite le apposite staffe di fissaggio *
 - ④ Accostare i montanti ai traversi, inserendo i fondini dentro alle teste dei traversi e fissarli con le apposite viti.
- Ripetere l'operazione per tutti i moduli successivi di montanti e traversi

Sequential assembly system

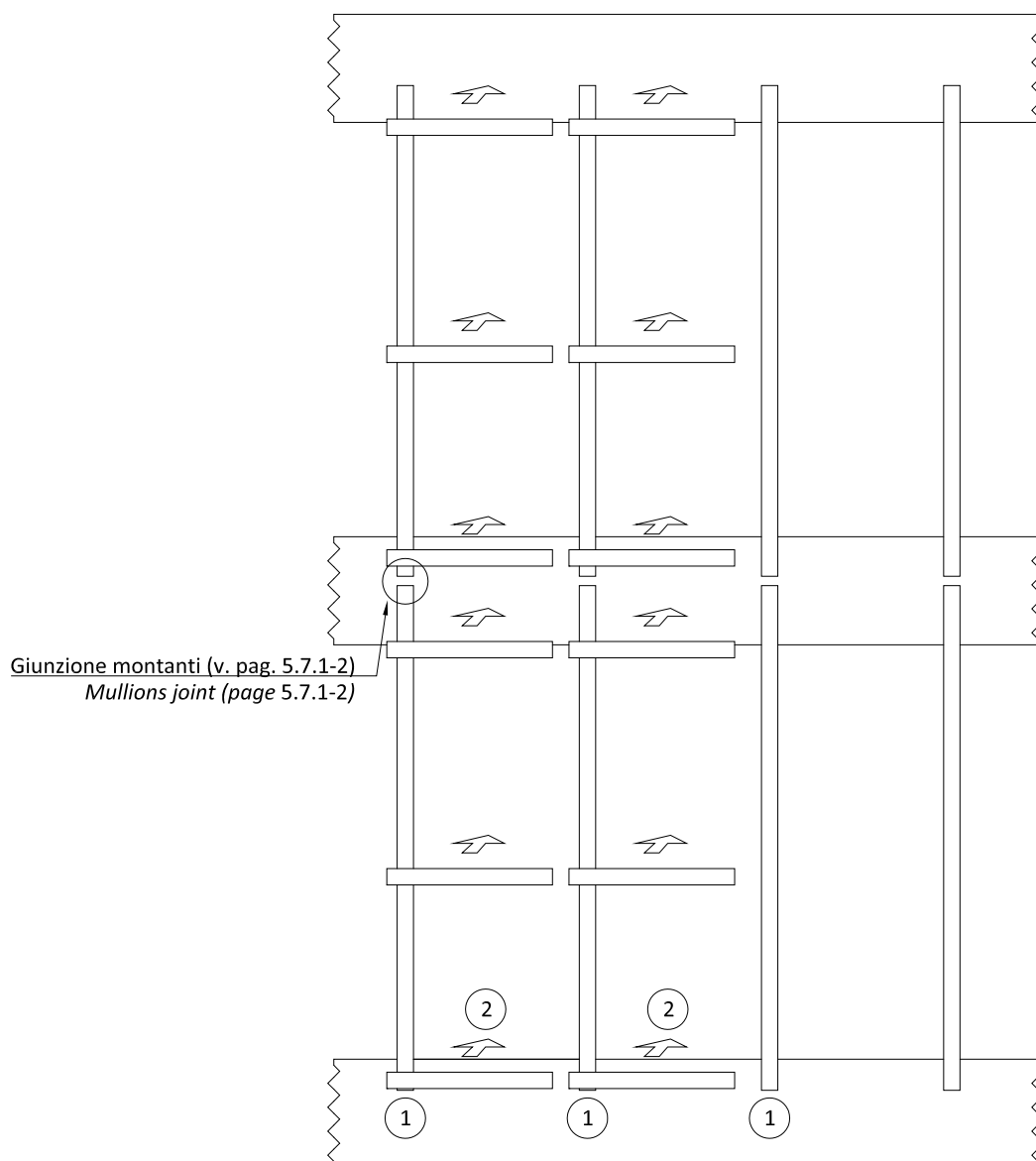
Refer to this assembly method when using screwed connection devices AC36..i series pre-installed on mullions

- ① Install the first line of mullions by the fixing brackets *
- ② Insert and fix with the screws the head of the transoms in the pre-installed joint accessory
- ③ Install the next line of mullions by the fixing brackets *
- ④ Accost the mullions to the transom, plug the connection devices into the head of the transom and fix it with the screws.

Repeat for all subsequent modules

* utilizzare staffe di fissaggio che permettano la traslazione orizzontale del montante di almeno 60 mm
(esempio p. 5.7.1)

* use fixing brackets that allow to move mullions of at least 60 mm horizontally
(example p. 5.7.1)



Sistema con traversi a montaggio frontale

Sistema di montaggio previsto per fondini a molla serie AC36..iM pre-installati su traversi

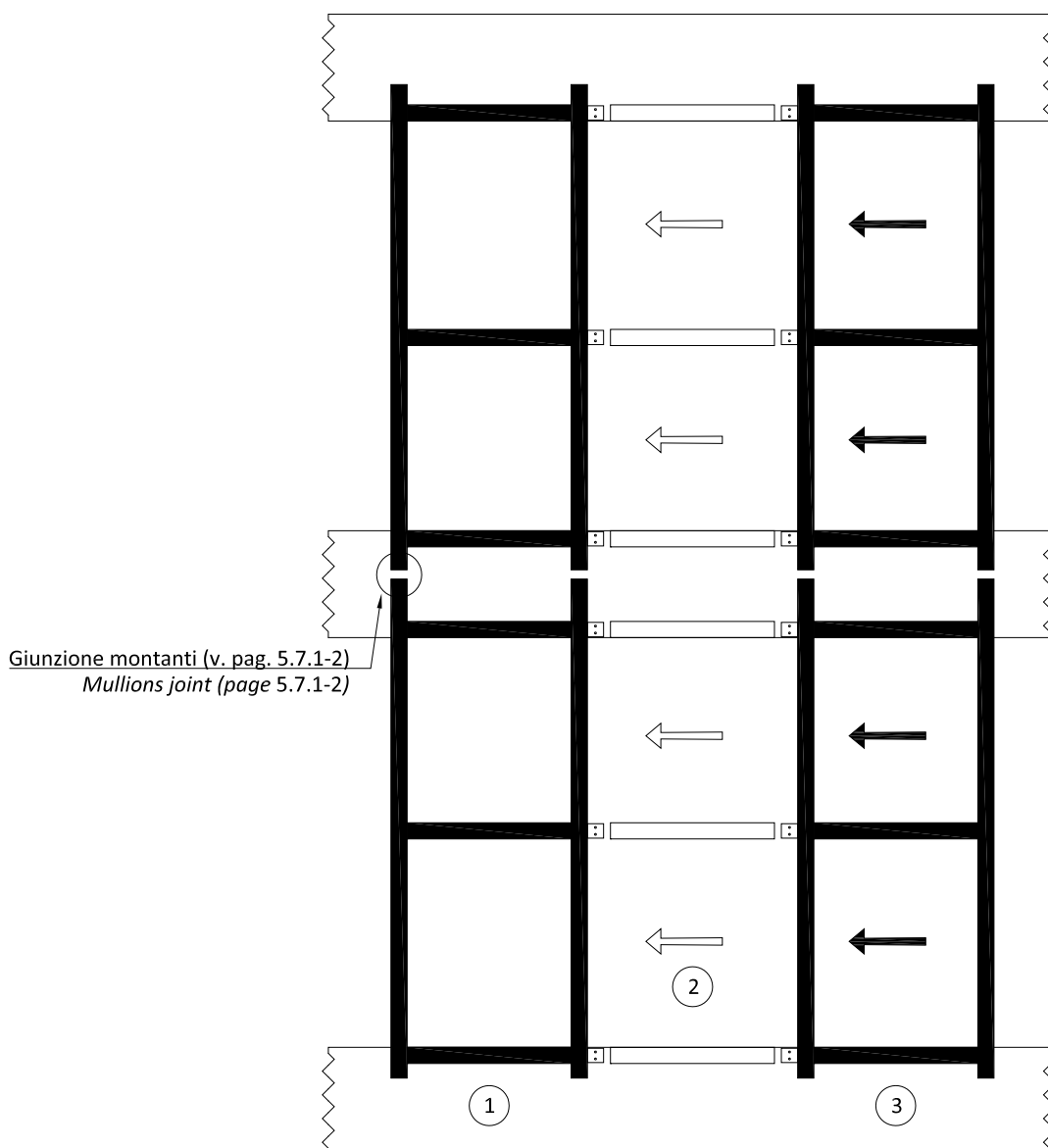
- ① Fissare i montanti ai solai mediante l'utilizzo di apposite staffe *
 - ② Installare i traversi tra i montanti tramite i fondini a molla pre-installati nei traversi
- Ripetere l'operazione per tutti i moduli successivi

Frontal transom assembly system

Refer to this assembly method when using spring connection devices AC36..iM series pre-installed on transoms

- ① Fix mullions on the floors by the fixing brackets *
 - ② Install the transoms between mullions by the springs connection device
- Repeat for all subsequent modules

* esempio p. 5.7.2
* example p. 5.7.2



Sistema con moduli pre-assemblati e trasversi a montaggio sequenziale

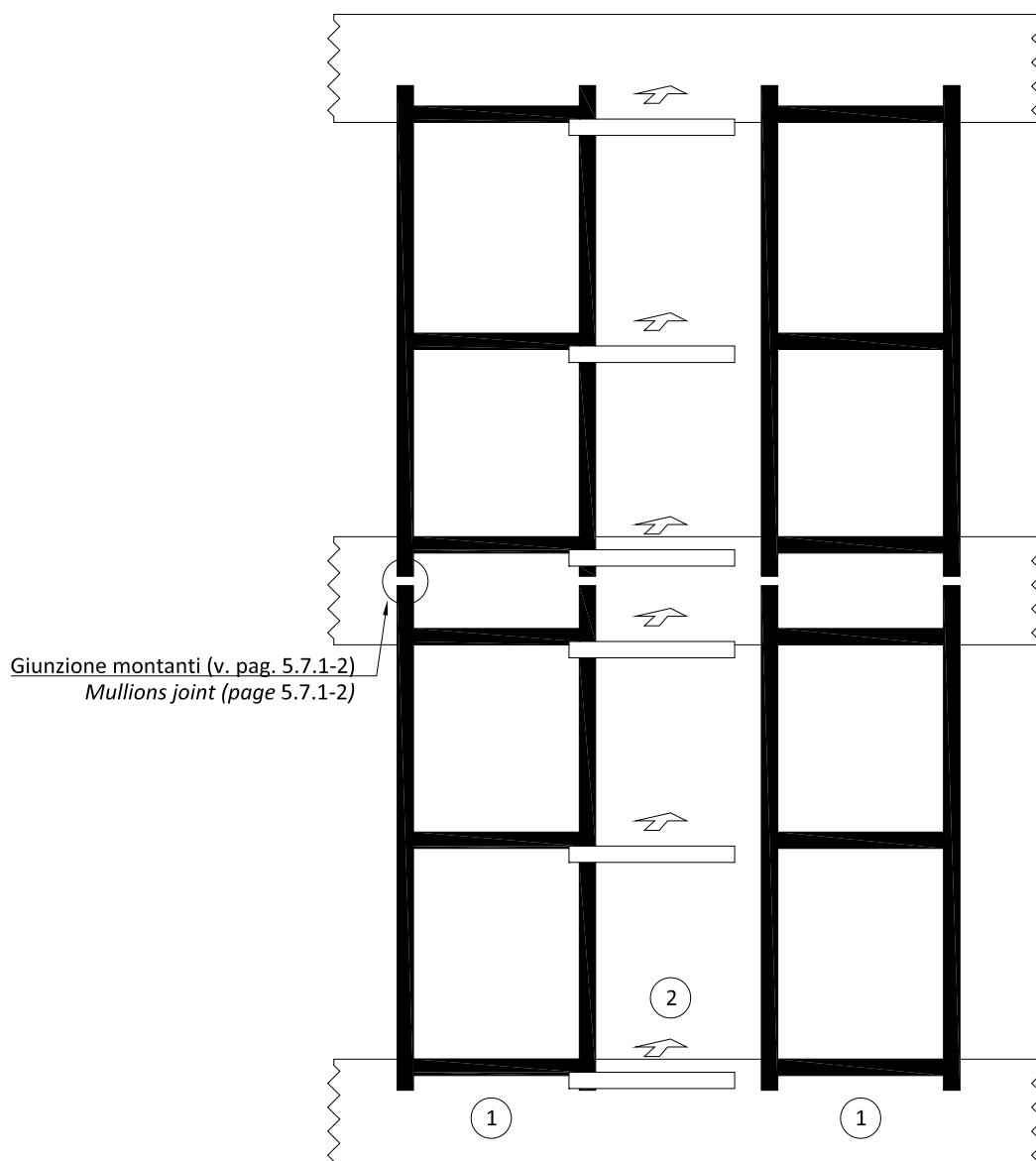
- ① Fissare un modulo ai solai mediante l'utilizzo di apposite staffe *
 - ② Inserire e fissare con le apposite viti la testa dei trasversi nel fondino pre-installato sul montante
 - ③ Installare il modulo successivo tramite le apposite staffe di fissaggio*, inserendo i fondini nelle teste dei trasversi
- Ripetere l'operazione per tutti i moduli successivi

Pre-assembled modules system with sequential transom assembly

- ① Install the first pre-assembled module by the fixing brackets *
 - ② Insert the head of the transoms in the connection device
 - ③ Install the next pre-assembled module the fixing brackets, * pluggin the connection devices into the head of the transom
- Repeat for all subsequent modules

* utilizzare staffe di fissaggio che permettano la traslazione orizzontale del montante di almeno 60 mm (esempio p. 5.7.1)

* use fixing brackets that allow to move mullions of at least 60 mm horizontally (example p. 5.7.1)



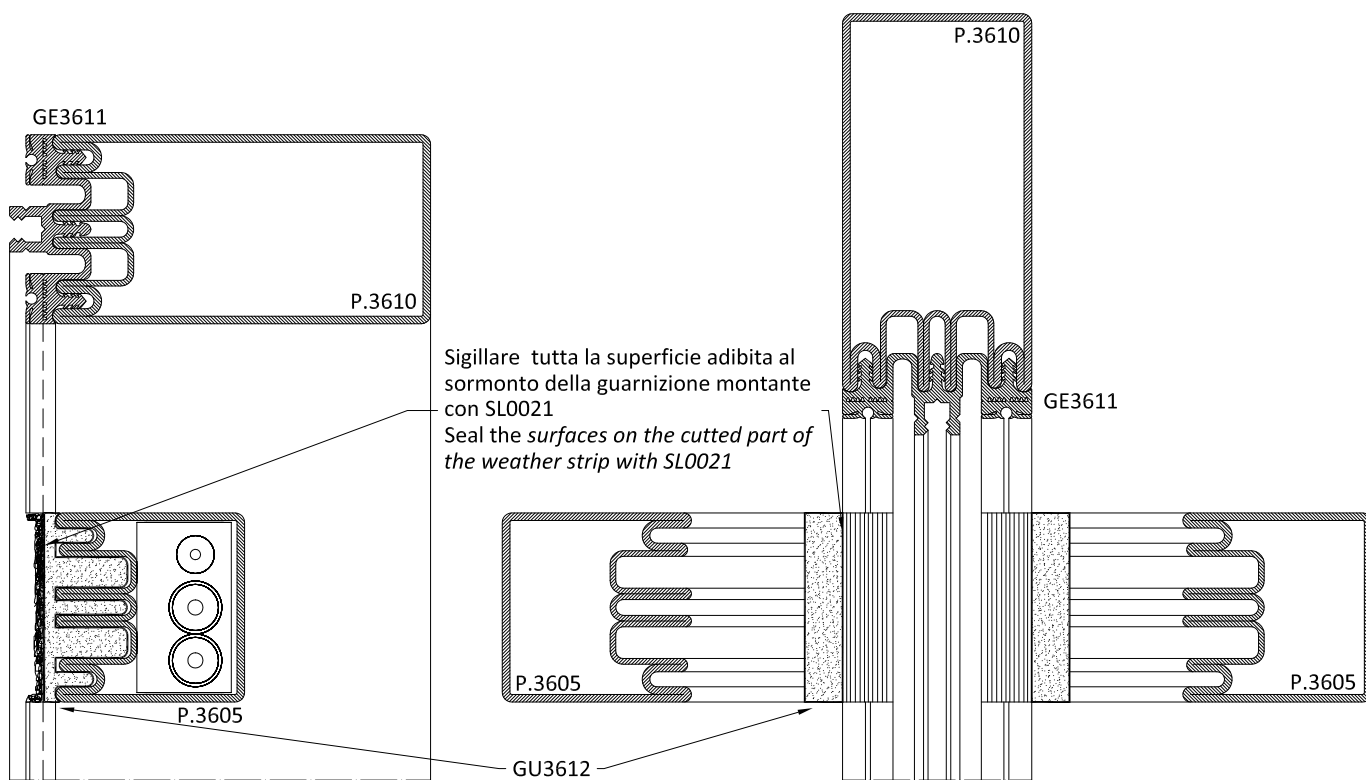
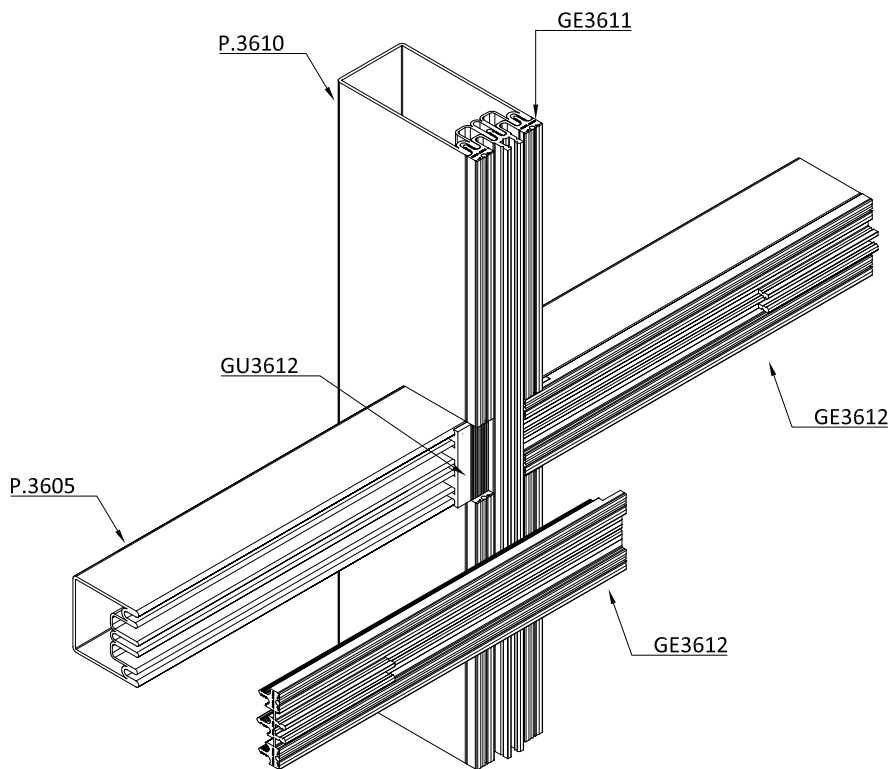
Sistema con moduli pre-assemblati e traversi a montaggio frontale

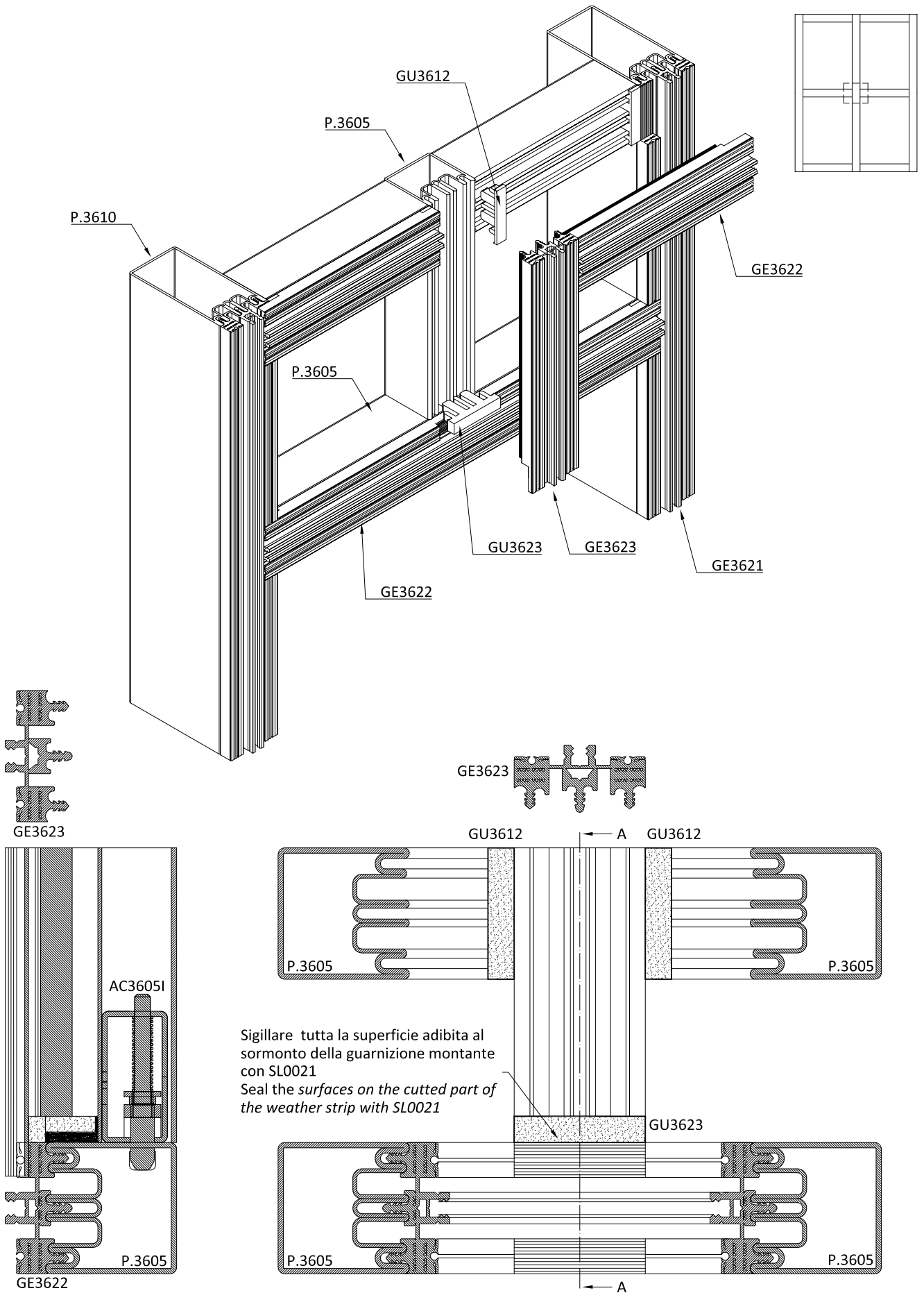
- ① Fissare due moduli ai solai mediante l'utilizzo di apposite staffe *
- ② Installare i traversi tra i montanti tramite i fondini a molla pre-installati nei traversi
Ripetere l'operazione per tutti i moduli successivi

Pre-assembled modules system with frontal transom assembly

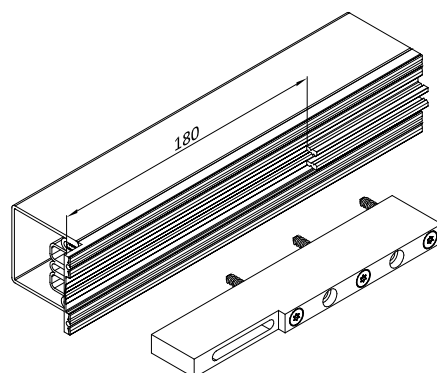
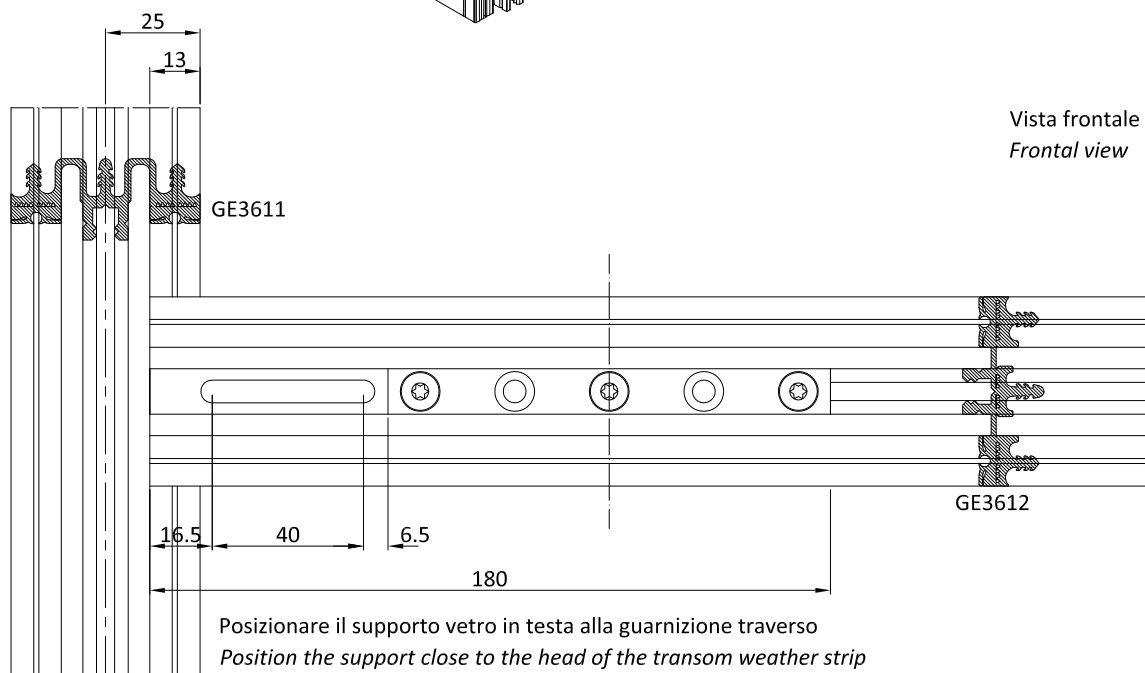
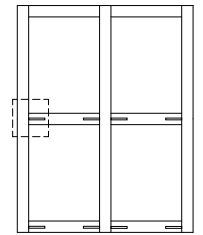
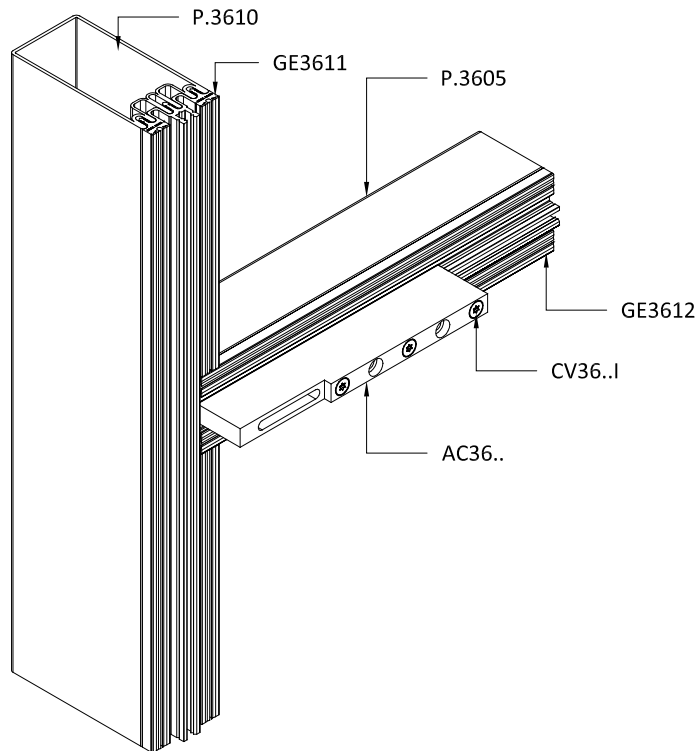
- ① Fix mullions on the floors by the fixing brackets *
- ② Install the transoms between mullions by the springs connection device
Repeat for all subsequent modules

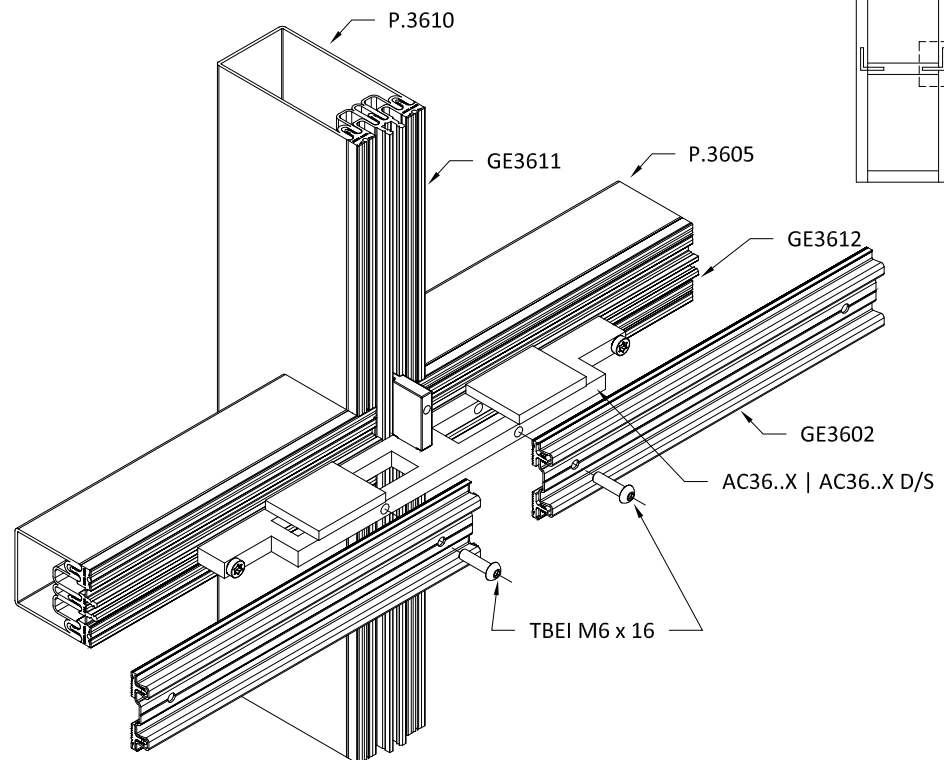
* esempio p. 5.7.2
* example p. 5.7.2



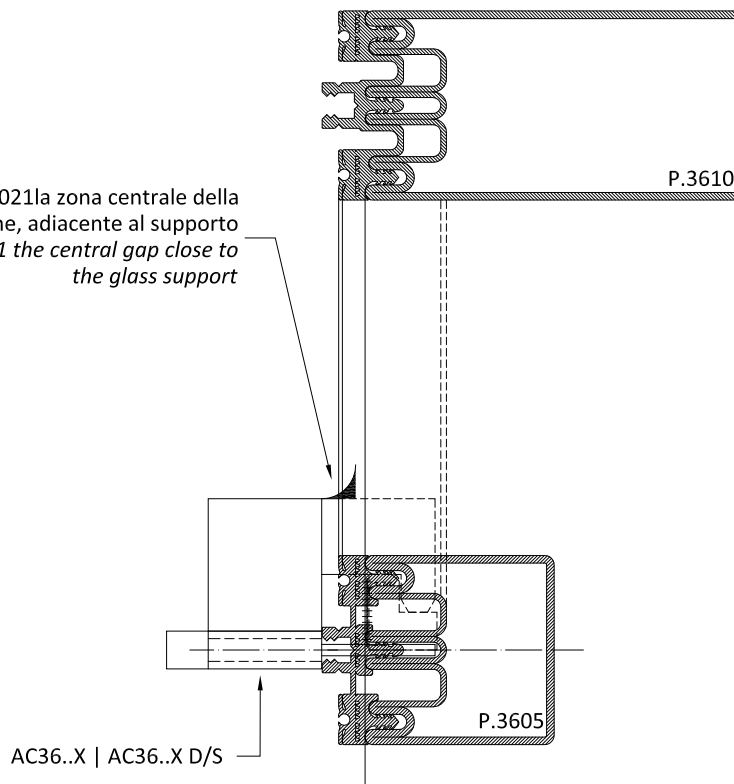


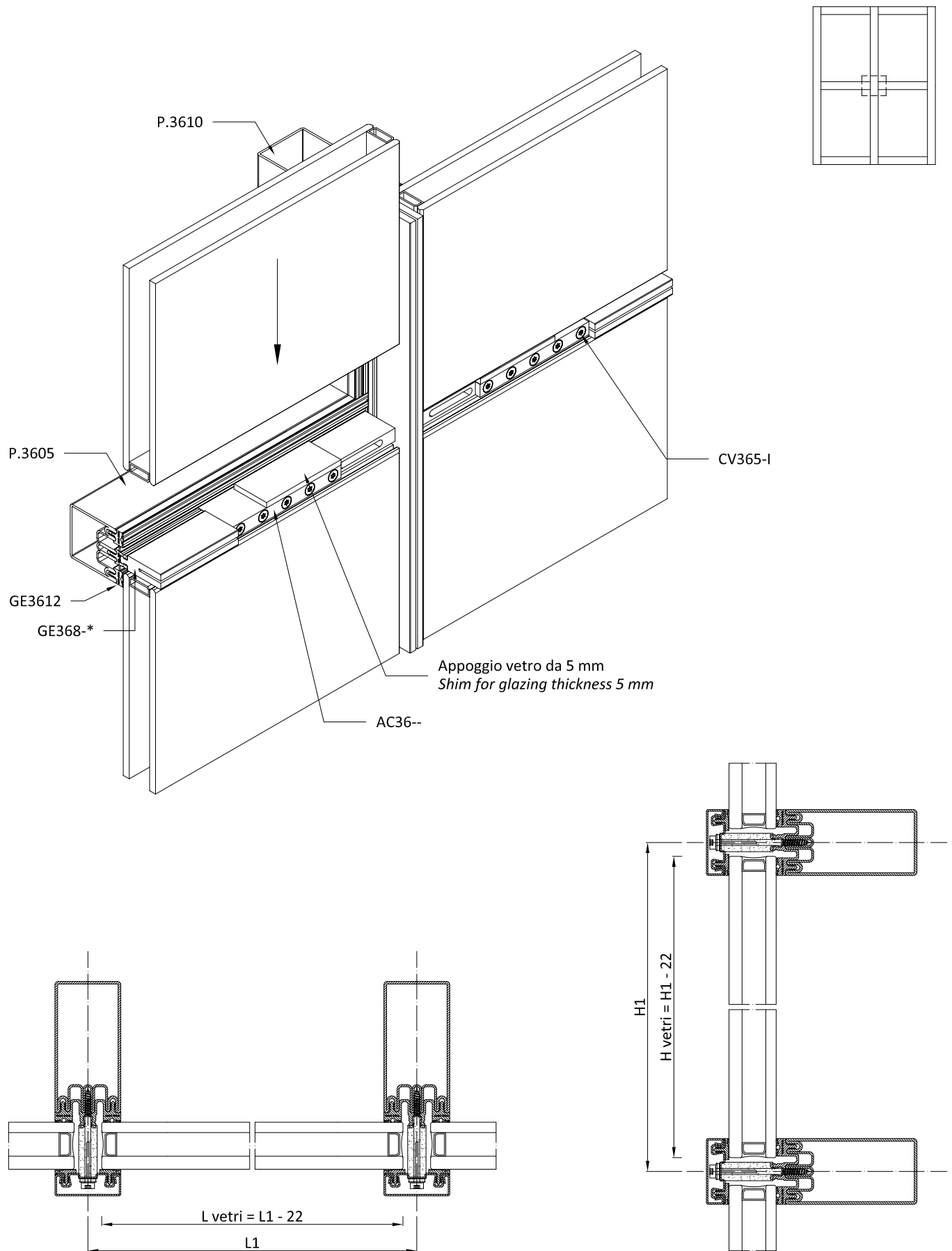
Sigillare tutta la superficie adibita al sormonto della guarnizione montante con SL0021
Seal the surfaces on the cutted part of the weather strip with SL0021



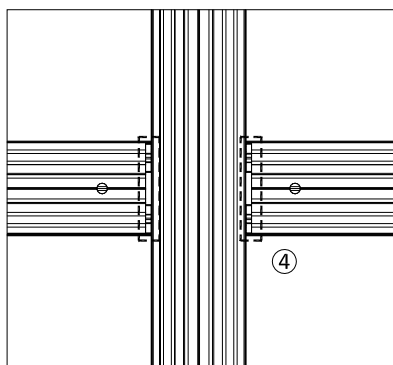
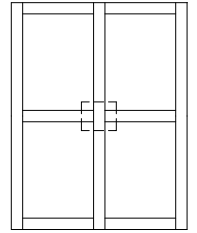
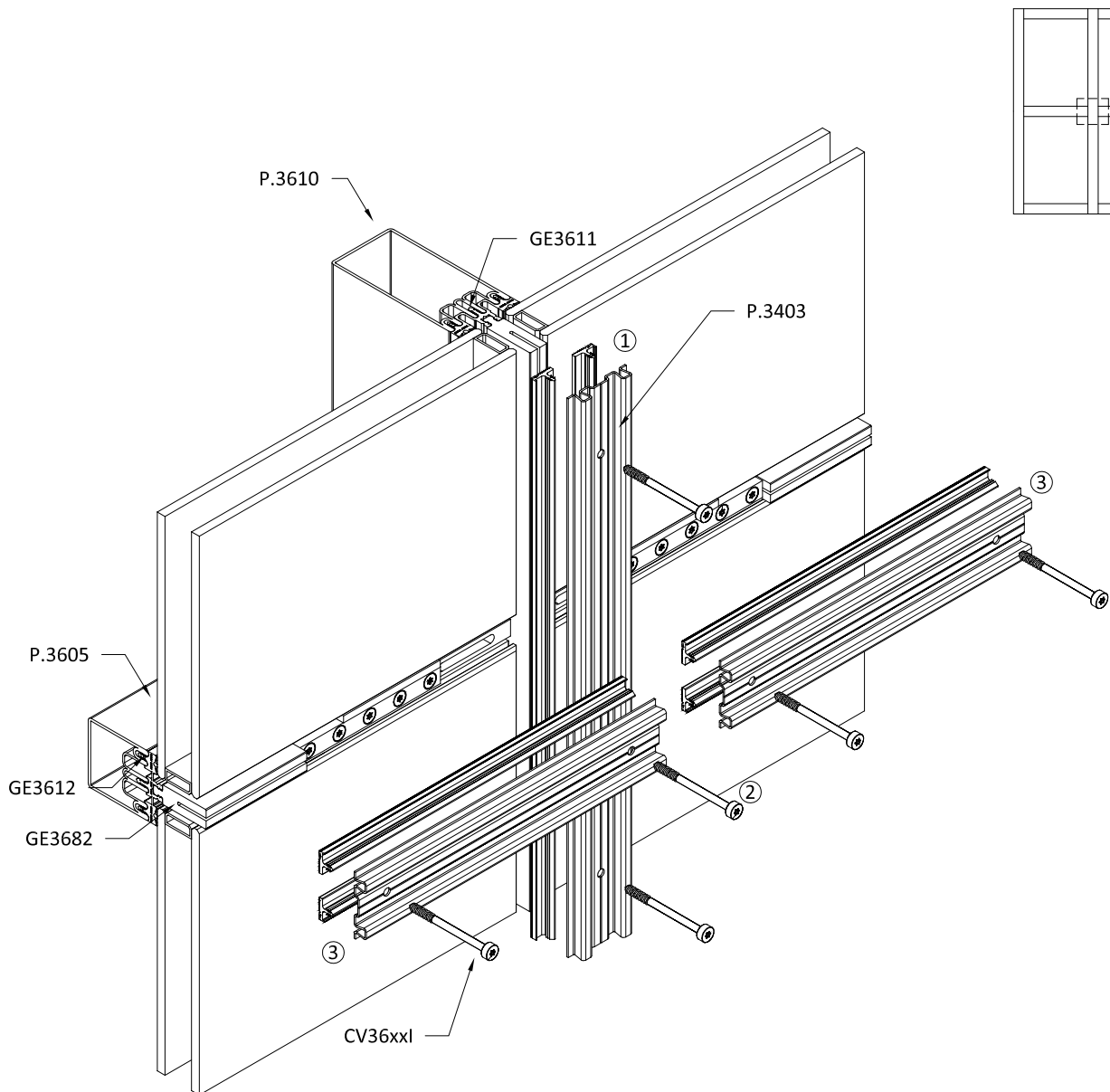


Sigillare con SL0021 la zona centrale della guarnizione, adiacente al supporto
Seal with SL0021 the central gap close to the glass support





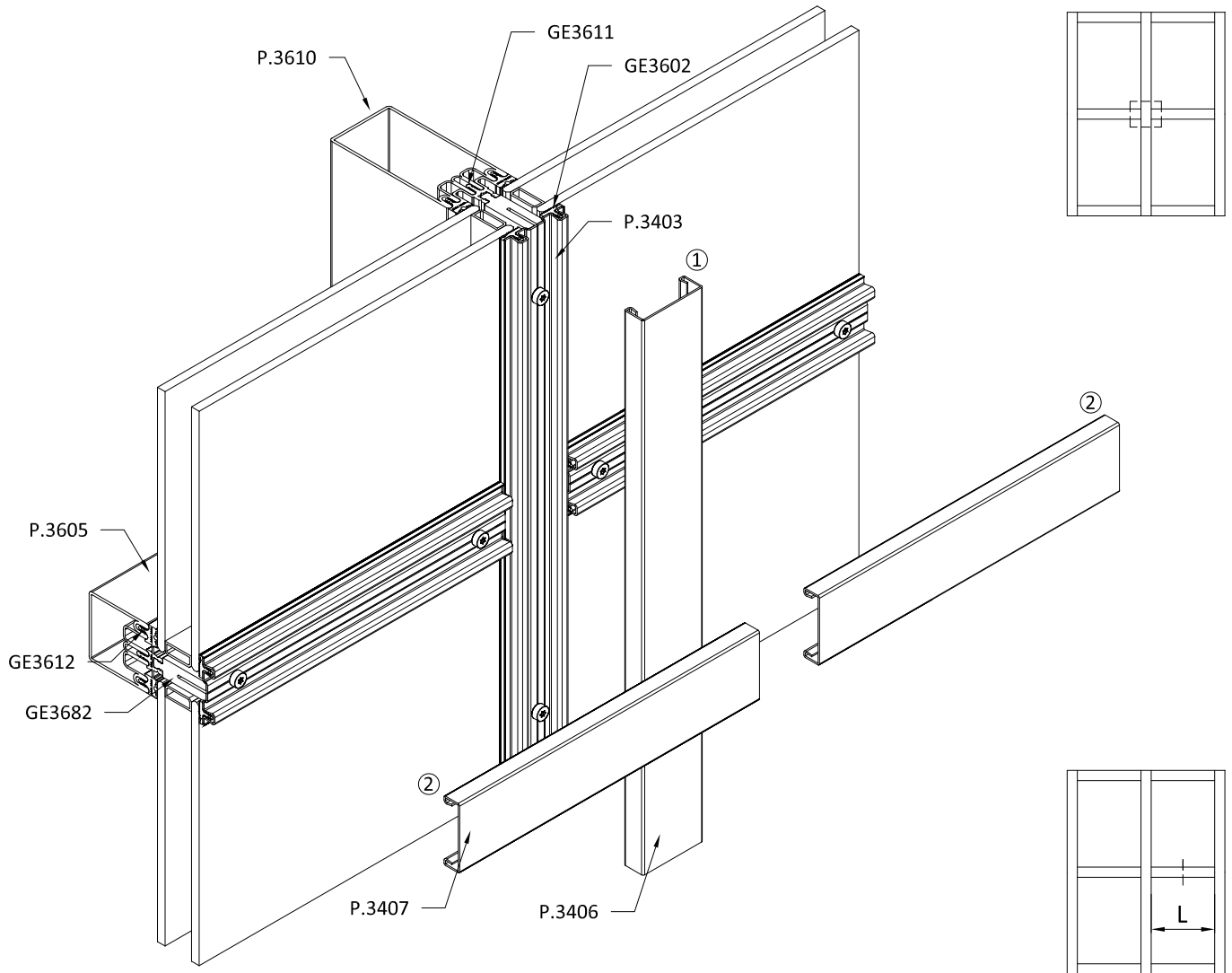
* Installare il profilo isolatore prima dei vetri
* install the insulator profile before the glasses



- 1) Inserimento guarnizioni GE3602 nel pressore del montante e del traverso
1) Insert weather strips into the mullion and transom pressure
- 2) Tramite le apposite viti CV36xxl fissare il pressore del montante*
2) Fix the mullion pressure with CV36xxl screws*
- 3) Tramite le apposite viti CV36xxl fissare il pressore traverso*
3) Fix the transom pressure with CV36xxl screws
- 4) Sigillare la zona di incrocio tra P.3403 orizzontale e P.3403 verticale
4) Seal the gap between the horizontal P.3403 profile and vertical P.3403 profile

* N.B.: Coppia max. serraggio 5 Nm

* NOTE: Max fixing torque 5 Nm

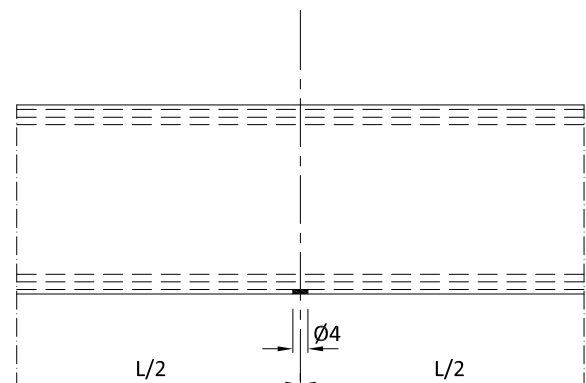
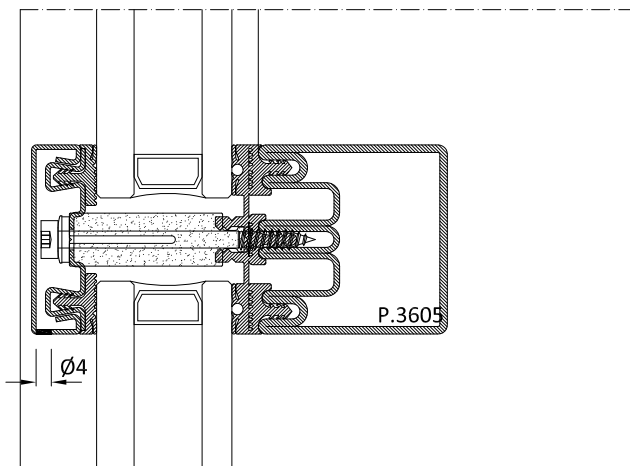


- 1) Montare prima le copertine dei montanti P.3406
- 1) *P.3406 profiles must be mounted first on mullions*

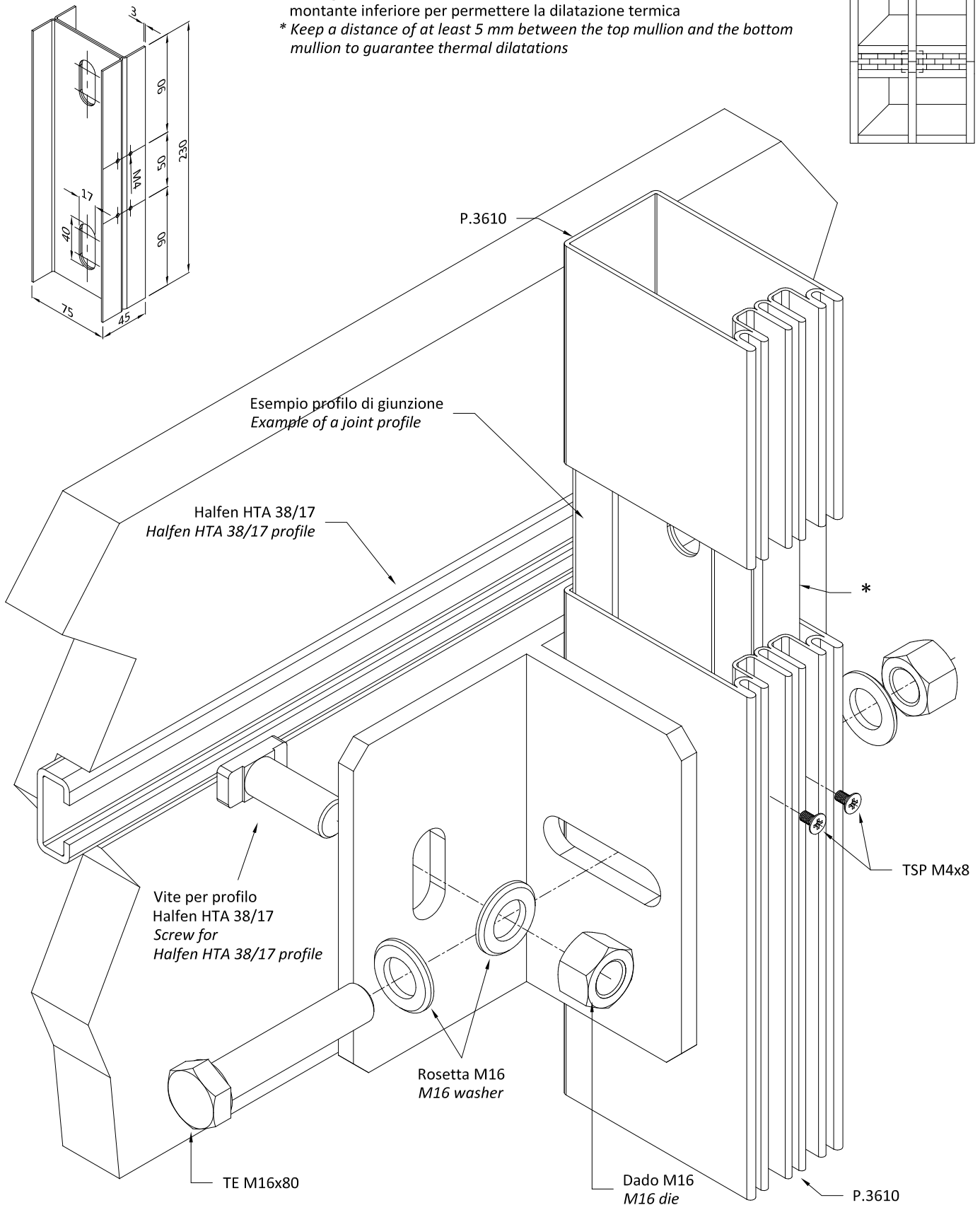
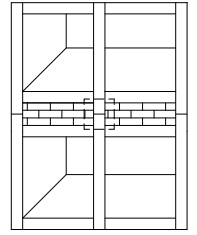
- 2) Montare le copertine dei traverzi P.3407
- 2) *Mount P.3407 on transoms*

NB.: Se il traverso supera i 2000 mm in lunghezza forare con punta $\varnothing 4$ la faccia inferiore del profilo P.3407 come indicato in figura, in modo da impedire accumuli di acqua.

NOTE.: If the transom is longer than 2000 mm, make a hole on the lower surface of the P.3407 profile as represented in the picture, to avoid water stagnation.



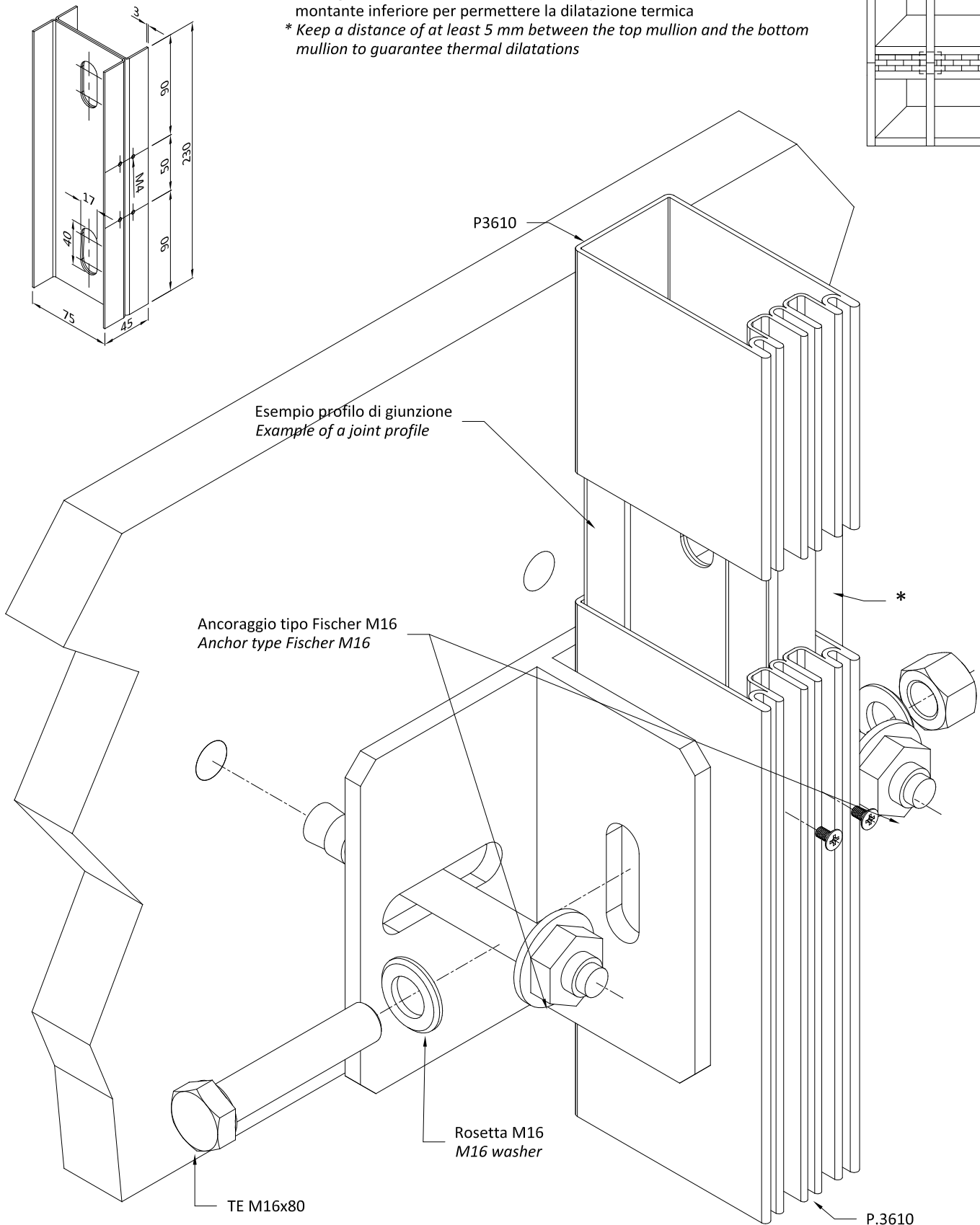
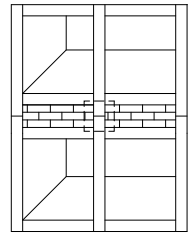
- * Nella giunzione distanziare il montante superiore di almeno 5 mm dal montante inferiore per permettere la dilatazione termica
* Keep a distance of at least 5 mm between the top mullion and the bottom mullion to guarantee thermal dilatations



N.B.: Staffe di fissaggio, halfen e canotti di giunzione non di fornitura Secco.
Devono essere valutati in base ad accurate verifiche strutturali

NOTE: Fixing brackets, halfen and mullion joint accessories are not provided by Secco.
They must be chosen after a thorough structural analysis

- * Nella giunzione distanziare il montante superiore di almeno 5 mm dal montante inferiore per permettere la dilatazione termica
* Keep a distance of at least 5 mm between the top mullion and the bottom mullion to guarantee thermal dilatations



N.B.: Staffe di fissaggio halfen e canotti di giunzione non di fornitura Secco.
Devono essere valutati in base ad accurate verifiche strutturali

NOTE: Fixing brackets, halfen and mullion joint accessories are not provided by Secco.
They must be chosen after a thorough structural analysis

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)

AISI 304 (X5 CrNi 18-10)

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.

Finitura lucida: ottenuta su nastro AISI 304.

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 Stroncoat® finitura skinpassata

Caratteristiche fisiche

Fe P02 ZM 100 (copertura di zinco-magnesio pari a 100gr/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, 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)

AISI 304 (X5 CrNi 18-10)

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.

Polished finish: obtained on AISI 304.

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 Stroncoat®, skinpassed finishing.

Physical features

Fe P02 ZM 100 (with zinc-magnesium coating of 100 gr/m² on both faces)

Norms of reference

UNI EN 10142/3/7; EURONORM 143

Pre-painted surface treatment

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

COPPER ALLOY OT67**Materials**

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

Physical features

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

Norms of reference

EN 1652:1999

Surface treatment

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

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

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