OS2 75 AS

CATALOGO TECNICO TECHNICAL CATALOGUE

versione 12/2021

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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'istallazione 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 permeabiltiy, 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/m^{2}K

Resistenza all'aria (UNI EN 12207)
- fino a classe 4

Resistenza all'acqua (UNI EN 12208)
- fino a classe 9A

Resistenza al vento (UNI EN 12210)
- fino a classe B3

Forze di azionamento (UNI EN 12046/1)
- Classe 1 < 100 N

PERFORMANCE
Thermal transmittance (UNI EN 14351/1)
- *Uw up to 1,4 W/m^{2}K*

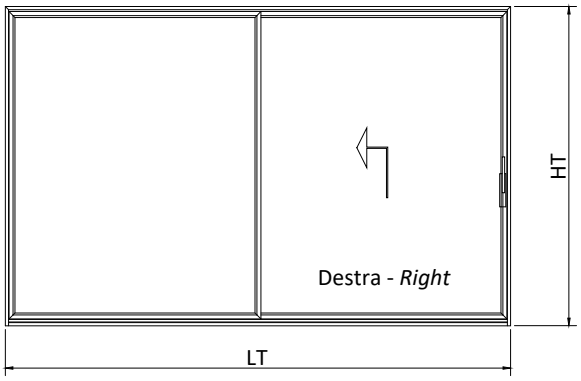
Air permeability (UNI EN 12207)
- *up to class 4*

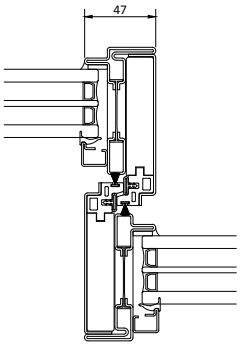
Watertightness (UNI EN 12208)
- *up to class 9A*

Resistance to wind load (UNI EN 12210)
- *up to class B3*

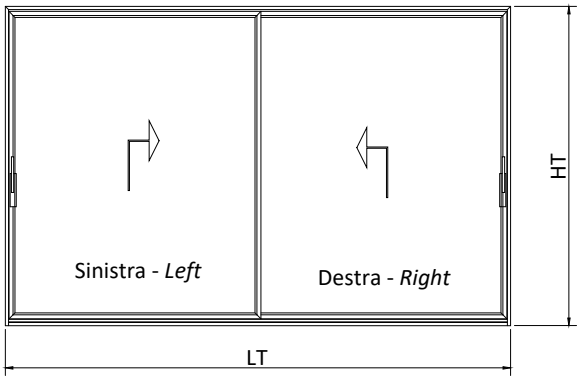
Operating forces (UNI EN 12046/1)
- *Class 1 < 100 N*

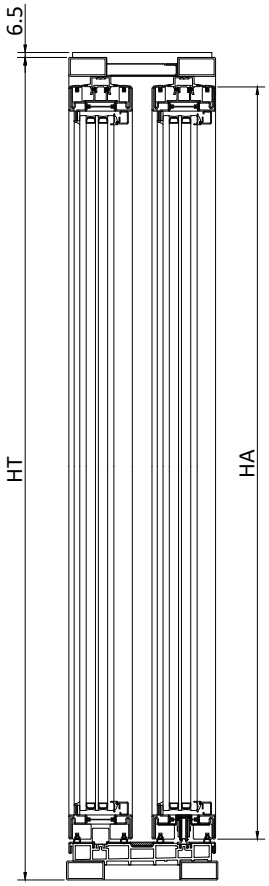
Schema | *Type* A 1 anta scorrevole ed 1 anta fissa
1 sliding and 1 fixed sash





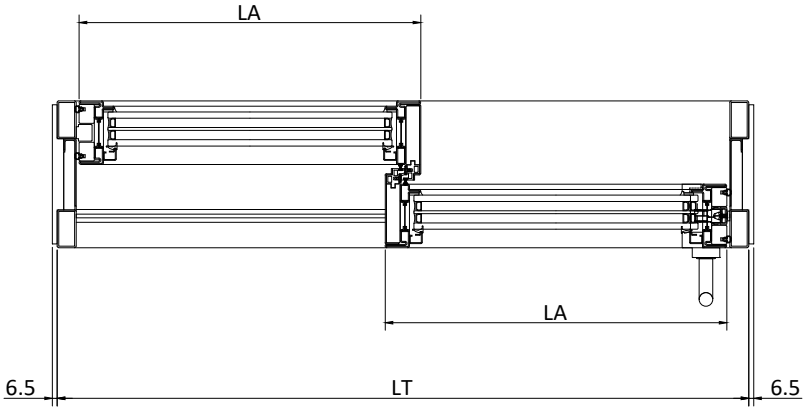
Schema | *Type* B 2 ante scorrevoli
2 sliding sashes



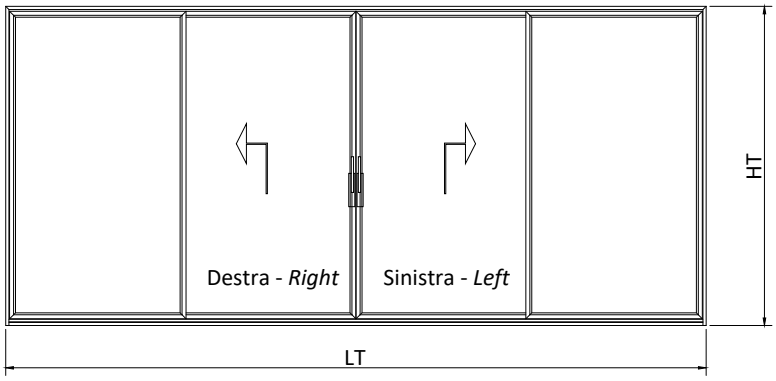


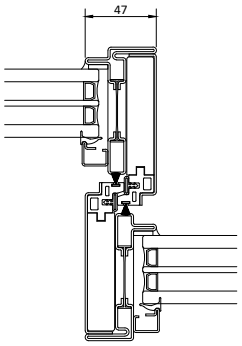
Limiti dimensionali | *Dimensional limits* (mm)

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	

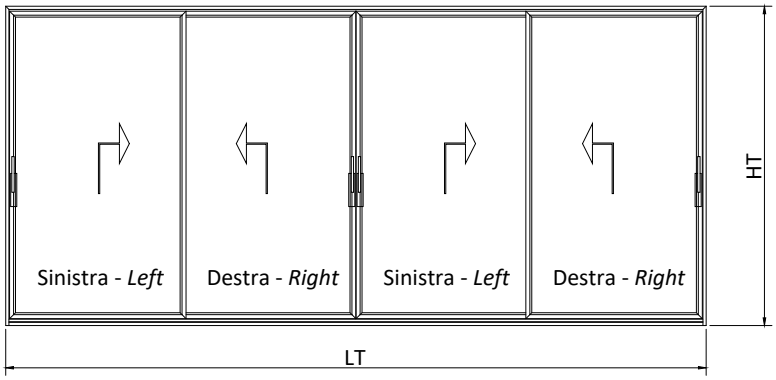


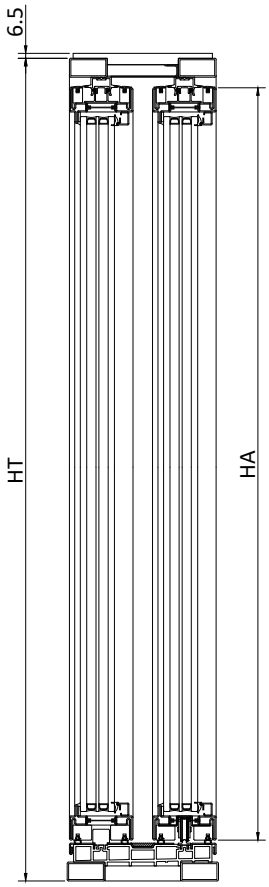
Schema | *Type* E 2 ante scorrevoli e 2 ante fisse
2 sliding and 2 fixed sashes





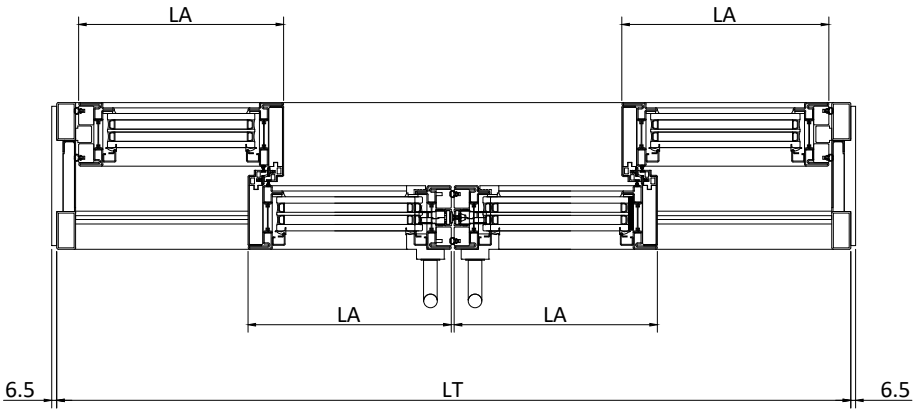
Schema | *Type* F 4 ante scorrevoli
4 sliding sashes

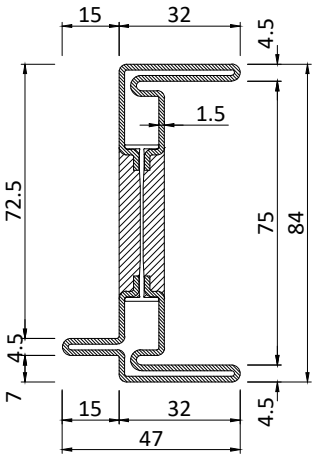




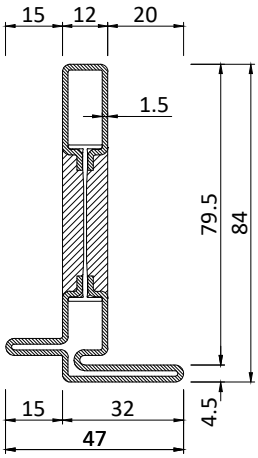
Limiti dimensionali | *Dimensional limits* (mm)

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	

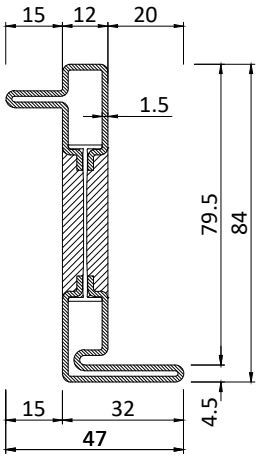




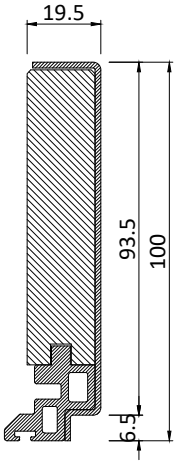
PR2975



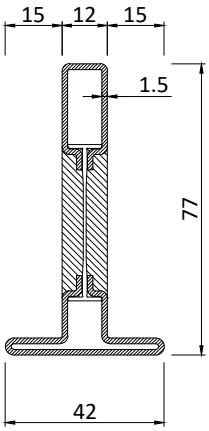
PR2988



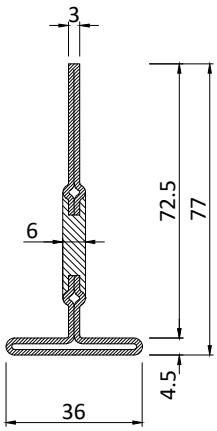
PR2989



PR2946



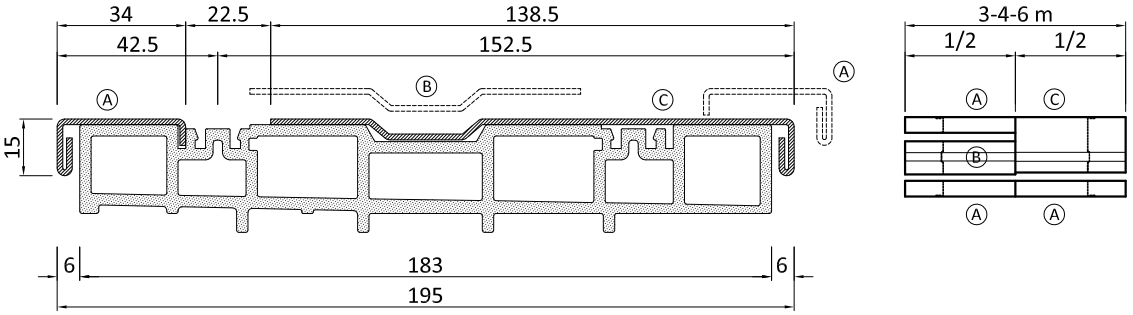
PR2952



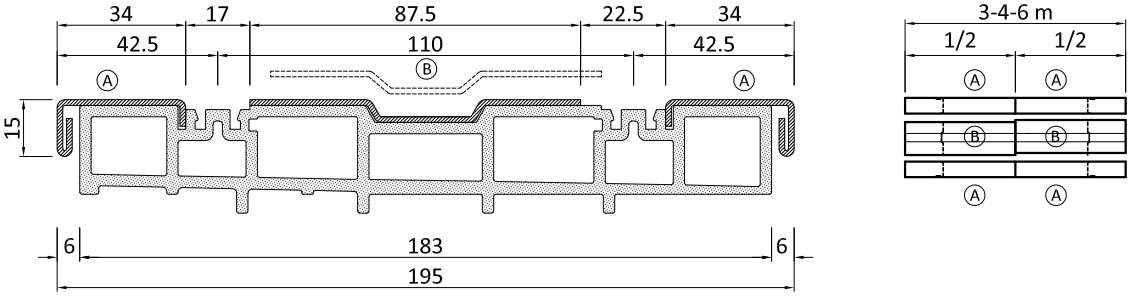
PR2954 Non fornito in acciaio inox
Not in stailess steel

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2975	3,52	3,77	0,32	32,75	4,36	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

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2954	2,33	2,55	0,22	19,90	1,20	6,0

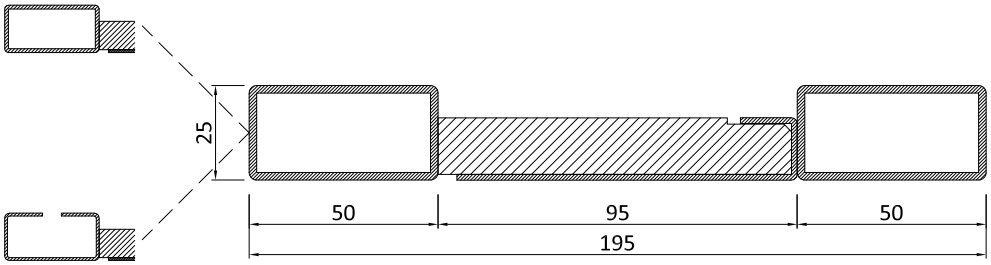


PR2983



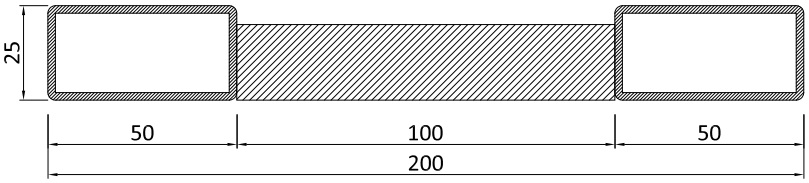
PR2984

acciaio zincato
galvanized steel



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

PR2986

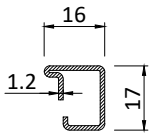


PR1195

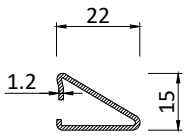
disponibile in acciaio zincato o acciaio inox
available in galvanized steel or stainless steel

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2983	4,25	4,47	0,53			3 - 4 - 6
PR2984	4,25	4,47	0,46			3 - 4 - 6
PR2986	7,30	7,65	0,45			3 - 4
PR1195	6,60		0,30			3 - 4 - 6

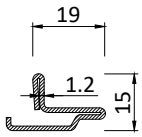
Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m



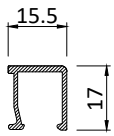
PR2606



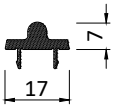
PR2629



PR2638

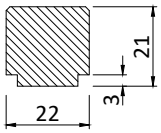


PA2606

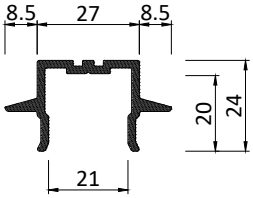


PA1194

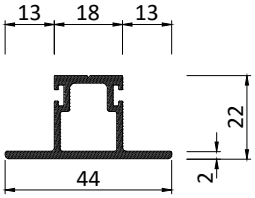
PA1194.NE



GU2905



GU2955



GU2956

MATERIALE | *MATERIAL*

PR _ _ _ _ ZN acciaio zincato | *galvanized steel*

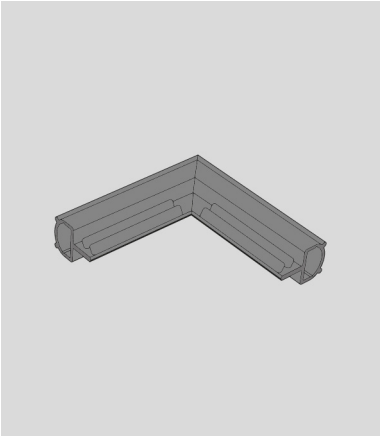
PR _ _ _ _ CZ acciaio corten grezzo | *untreated corteen steel*

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

PR _ _ _ _ BR ottone grezzo | untreated brass

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2606	0,48	0,52				6
PR2629	0,49	0,53				6
PR2638	0,60	0,68				6
PR2606	0,17	alluminio|aluminium				6

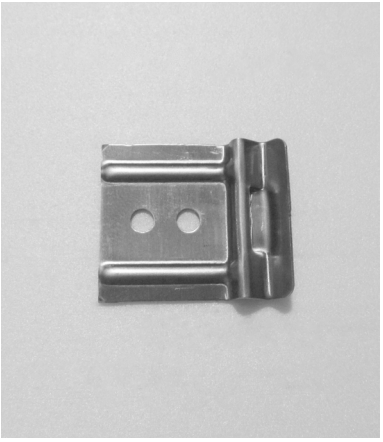
Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PA1194	0,20	alluminio argento|aluminium silver				6
PA1194.NE	0,20	alluminio nero|aluminium black				6
GU2905	0,30	PVC				3,0
GU2955	0,26	poliammide|polyamide				3 - 4 - 6
GU2956	0,23	poliammide|polyamide				3 - 4 - 6



AC 1305G

Guarnizione d'angolo vulcanizzata per GE1305S

Vulcanised corner weather strip for GE1305S



AC 2608

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

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

AC 2609

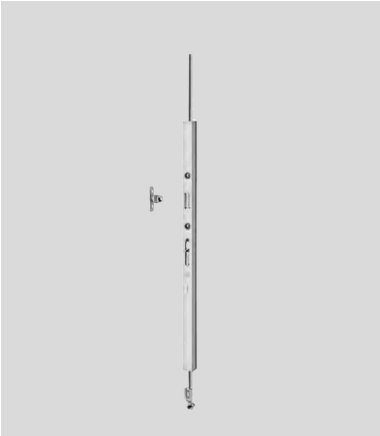
Clips per fissaggio fermavetri PR2606 - PR2607 - PR2627 su profilo PR2954

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

AC 2993 P

Accessorio assiemaggio telaio PR2986

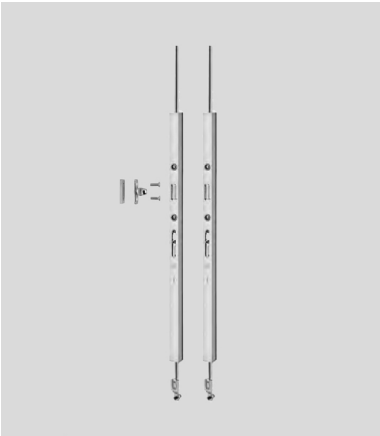
Frame assembling accessory PR2986



AG 2989.AB

Kit prolunga aggiuntiva cremonese

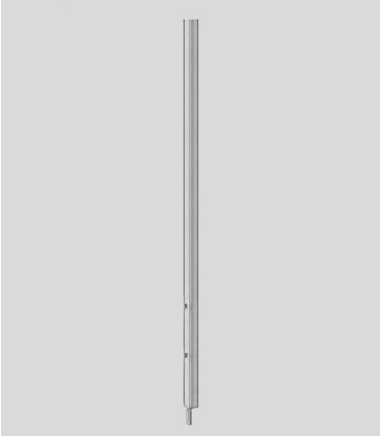
Additional extension kit for cremone bolt set



AG 2989.EF

Kit prolunga aggiuntiva cremonese per soluzione coassiale

Additional extension kit for cremone bolt set on coaxial leaf solution



AG 2989 C

Profilo di copertura aggiuntivo cremonese
H 1000 mm

Additional covering profile for cremone bolt
H 1000 mm

AG 2992.AB

Rostro aggiuntio

Additional hook bolt

AG 2992.EF

Rostro aggiuntio per
soluzione coassiale

Additional hook bolt on coaxial leaf solution

CV1243 acciaio zincato|*galvanized steel*
CV1243I acciaio inox|*stainless steel*

CV 1243.

Vite trilobata
TPS M4x8

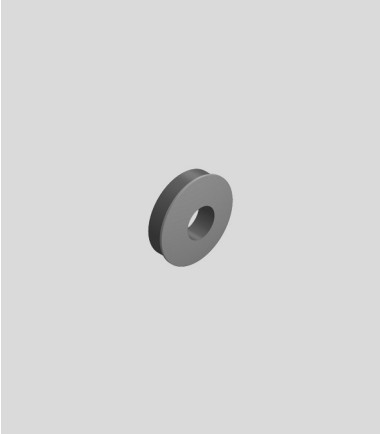
Thread cutting machine screw
TPS M4x8

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

CV 5012.

Boccola per fermavetro in
alluminio
PA2606

Bushing for alluminium
glazing bead
PA2606



CV 5403 I

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

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

Tabella determinazione range dimensione ante per ordine kit movimentazione e tenuta

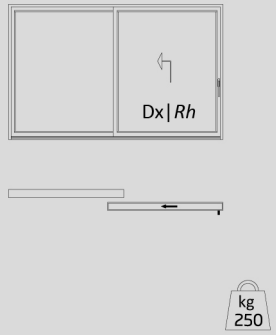
Table for sash range for the order of the handling and sealing kit

250 kg

altezza - *height*

	XX	**1135 1750**	**1751 2100**	**2101 2350**	**2351 2700**	**2701 2908**
larghezza *width*	**850 - 1560**	A1	B1	C1	D1	E1
H maniglia - *handle*		396	996	996	996	996

Schema| *Type* A



AG2986A.xx

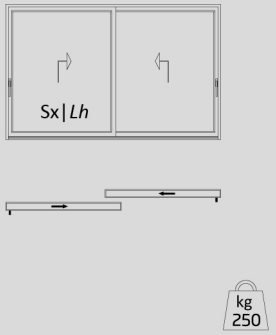
Kit movimentazione e tenuta 1 anta apribile - anta dx

portata fino a 250 kg

1 leaf handling and sealing kit - RH

load up to 250 kg

Schema| *Type* B



AG2987B.xx

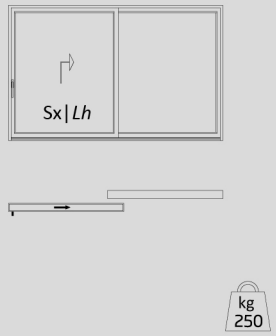
Kit movimentazione e tenuta 2 ante apribili - 1^ anta sx

portata fino a 250 kg

2 leaf handling and sealing kit - LH master

load up to 250 kg

Schema| *Type* A



AG2987A.xx

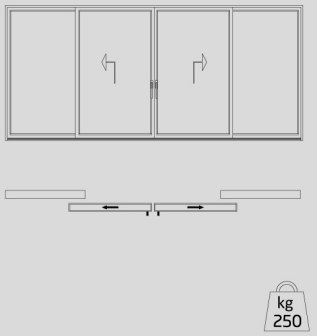
Kit movimentazione e tenuta 1 anta apribile - anta sx

portata fino a 250 kg

1 leaf handling and sealing kit - LH

load up to 250 kg

Schema| *Type* E



AG2986E.xx

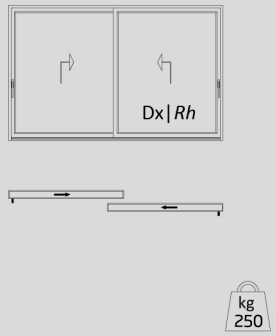
Kit movimentazione e tenuta 2 ante apribili

portata fino a 250 kg

2 leaf handling and sealing kit

load up to 250 kg

Schema| *Type* B



AG2986B.xx

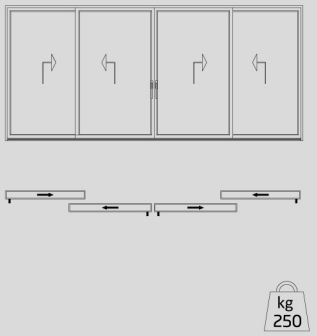
Kit movimentazione e tenuta 2 ante apribili - 1^ anta dx

portata fino a 250 kg

2 leaf handling and sealing kit - RH master

load up to 250 kg

Schema| *Type* F



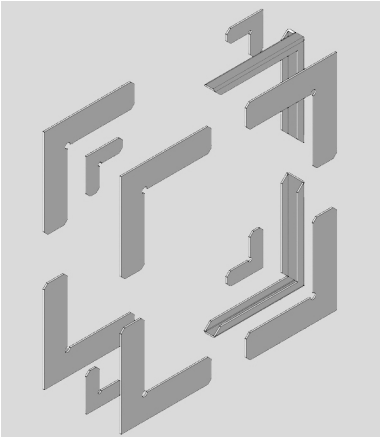
AG2986F.xx

Kit movimentazione e tenuta 4 ante apribili

portata fino a 250 kg

4 leaf handling and sealing kit

load up to 250 kg



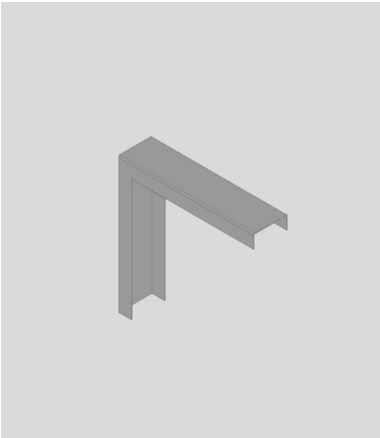
AC 290ANT

Kit squadrette di giunzione angoli per anta apribile o fissa

Acciaio inox

Corner joint kit for openable or fixed sash

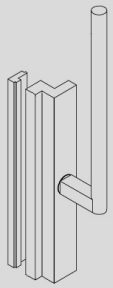
Stainless steel



AC 290TES

Squadretta di giunzione angolo telaio esterno
PR2986
Acciaio inox

Corner joint for external frame
PR2986
Stainless steel

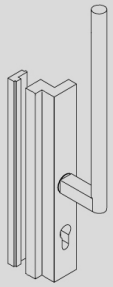


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV096.xx

Maniglione singolo con scatola copri serratura per fermavetro PR2606
PA2606

Single handle with box lock cover for glazing beads
PR2606
PA2606

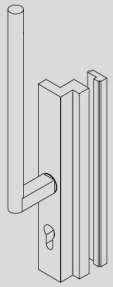


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV096Y.xx.D

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

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

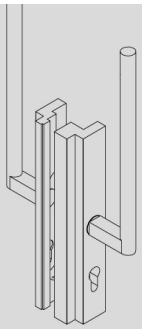


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV096Y.xx.S

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

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

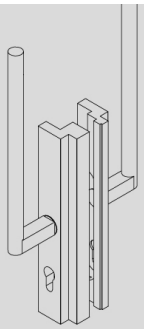


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV196Y.xx.D

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

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

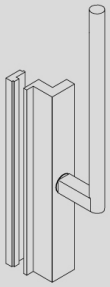


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV196Y.xx.S

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

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

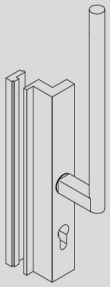


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV097.xx

Maniglione singolo con scatola copri serratura per fermavetro PR2629-2638

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

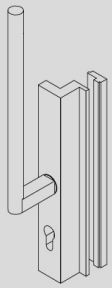


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV097Y.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

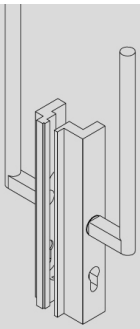


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV097Y.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

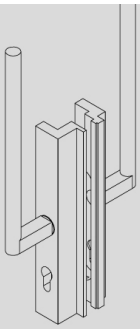


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV197Y.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

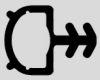


ZN acciaio zincato|*galvanized steel*
SB acciaio inox|*stainless steel*
CZ acciaio corten|*corten steel*
BR ottone|*brass*

ACV197Y.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 1305S

Guarnizione laterale e inferiore ante

Sash uproghts an bottom rail gasket

GE 2905S

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

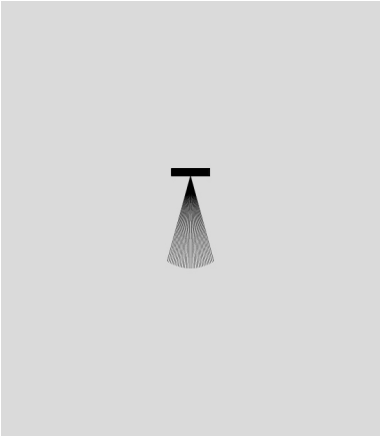
Guarnizione adesiva esterno vetro
vedi pg. 5.1.1

Adhesive weather strip outer window
see pg. 5.1.2

GU 1147

Spazzolino per guida superiore H=5 mm

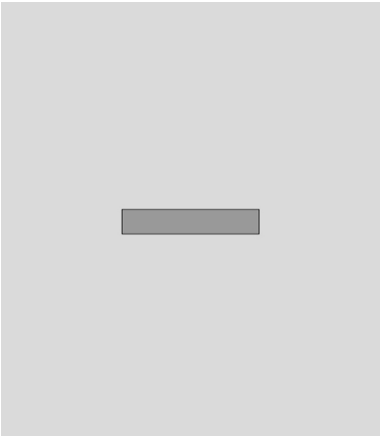
Brush on upper sliding track
H=5 mm



GU 1387

Spazzolino per labirinto
H=13 mm

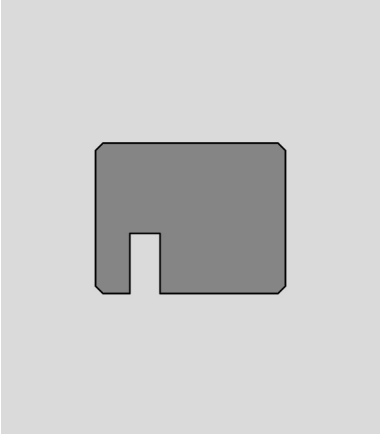
Brush for labyrinth joint
H=13 mm



GU 2036

Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

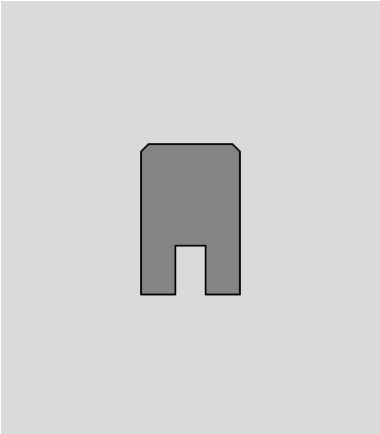
Soft adhesive shim for
external window joint
12x4 mm



GU 2975L

Profilo plastico porta
guarnizione perimetrale

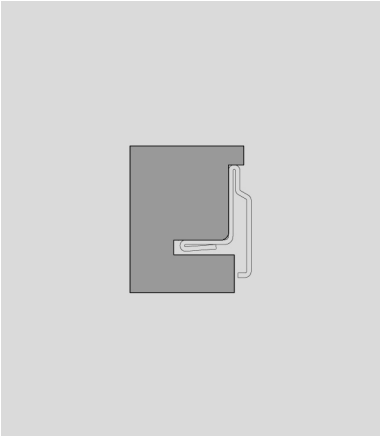
Plastic door profile
perimeter gasket



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

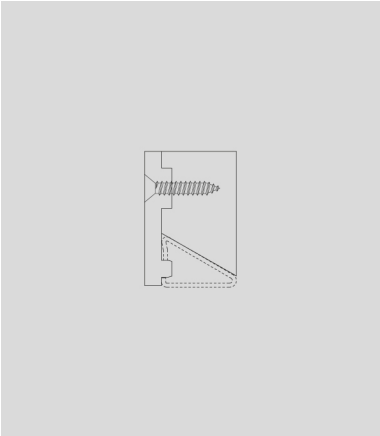
Kit ganasce di taglio

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

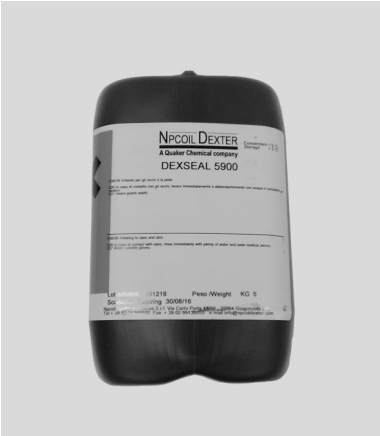
Spray solvente per rimozione collanti su superfici in acciaio inox

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

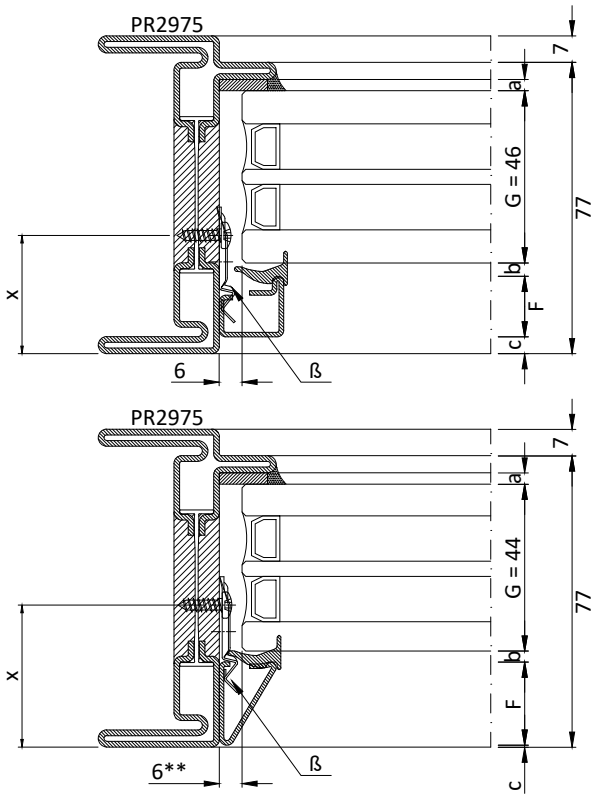
Cold sealant for corner and transom joints

1 kg

SL 0021

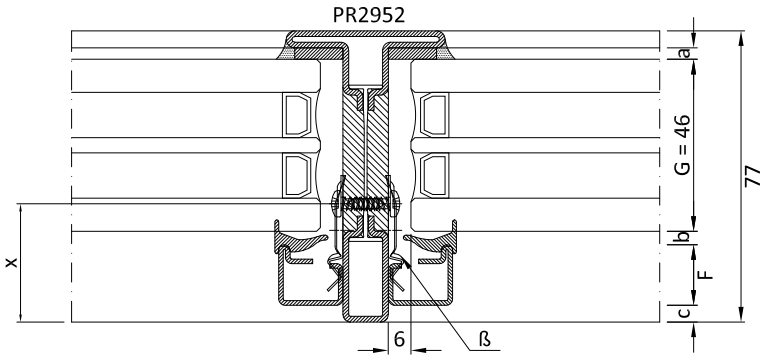
Silicone nero per guarnizioni

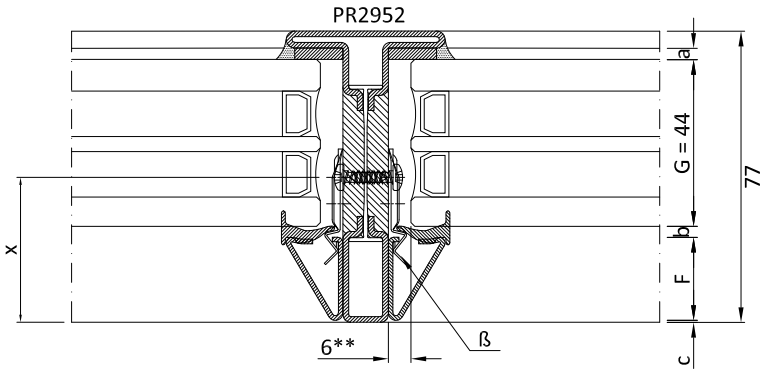
Black silicone for gaskets



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	ß
16, 1.2, 17 PR2606	46	3	3	30.5	5	AC2608
22, 1.2, 15 PR2629	44			37.5	0	AC2608
19, 1.2, 15 PR2638	44			44.5	3	AC2608

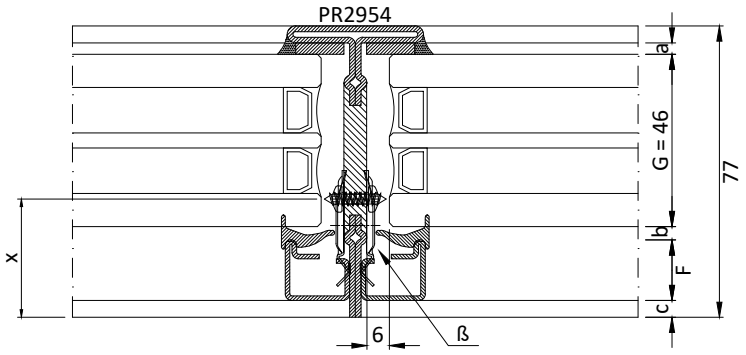
** 7 mm per PR2638
** *7 mm for PR2638*

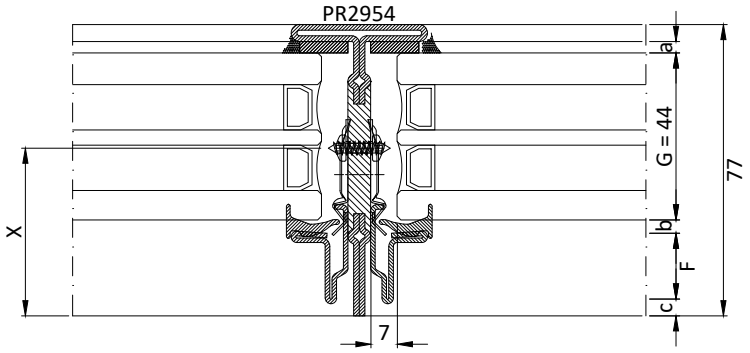


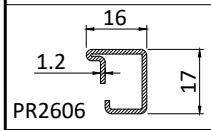
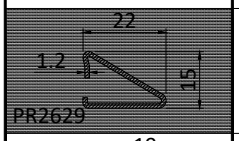
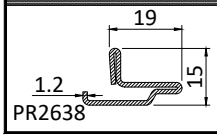


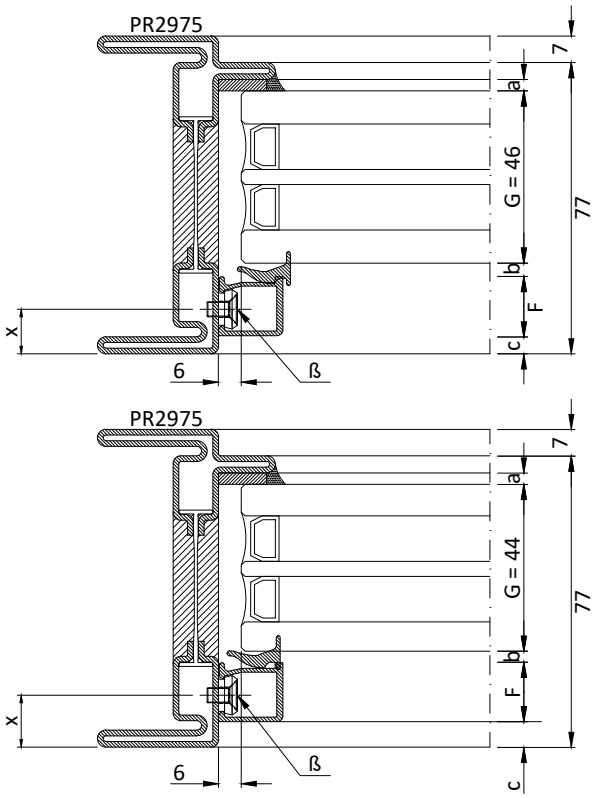
F	G	Guarnizioni - *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
16, 1.2, 17 PR2606	46	3	3	30.5	5	AC2608
22, 1.2, 15 PR2629	44			37.5	0	AC2608
19, 1.2, 15 PR2638	44			44.5	3	AC2608

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



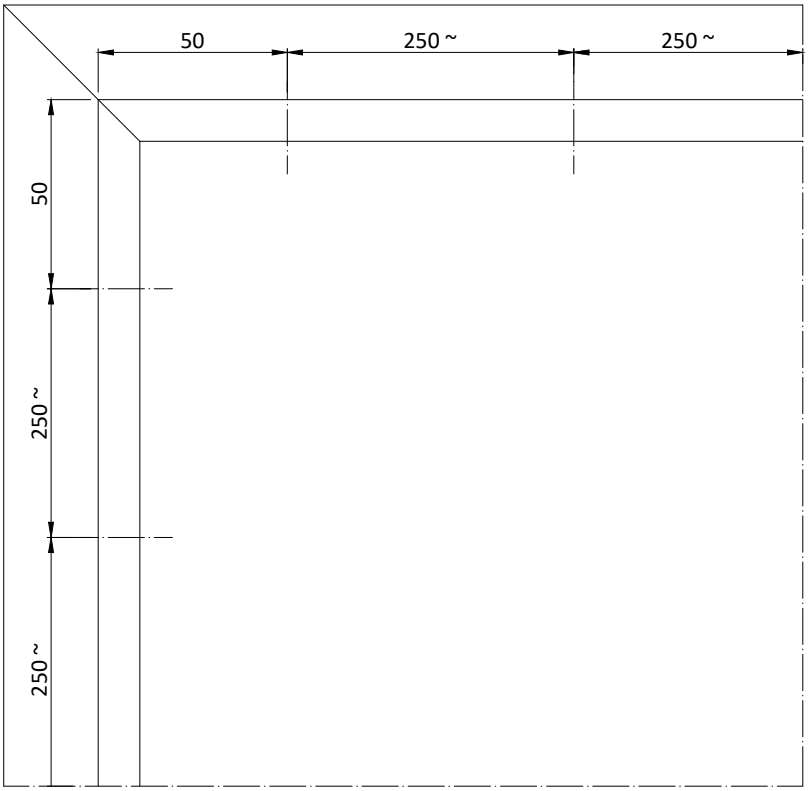


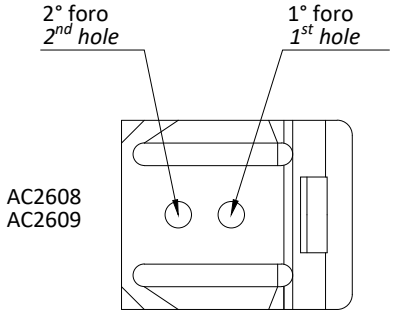
F	G	Guarnizioni - *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice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

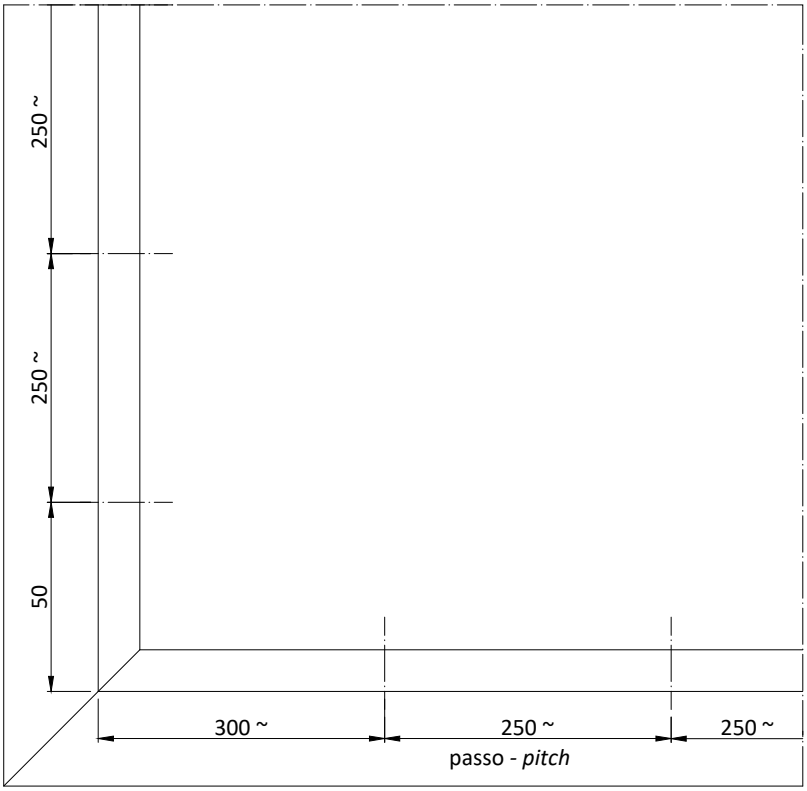


F	G	Guarnizioni - *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
15.5 17 PA2606	46	3	3	12	5	CV1243(I) CV5012(I)

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

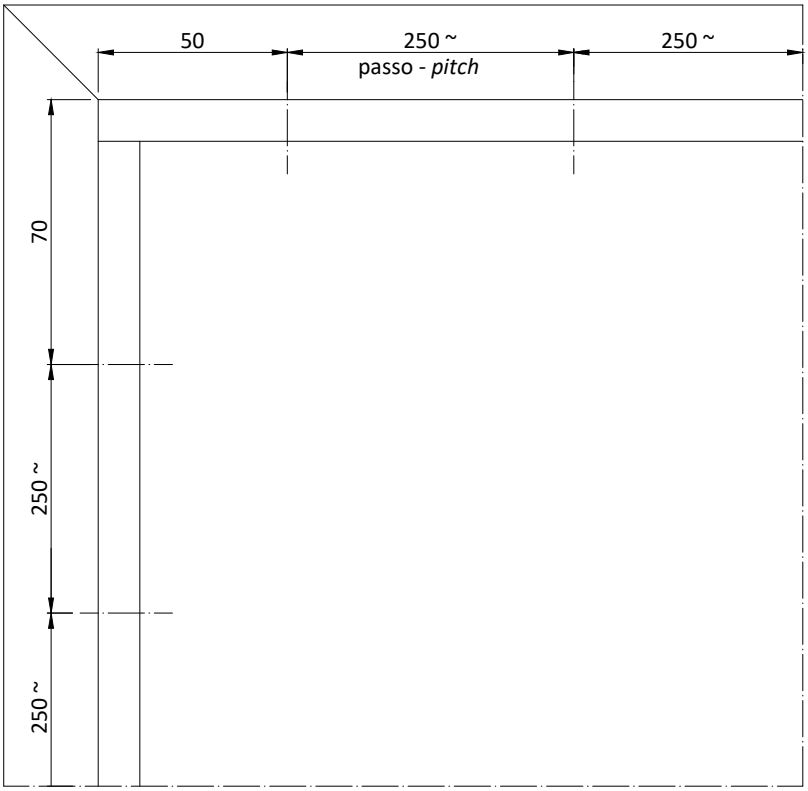


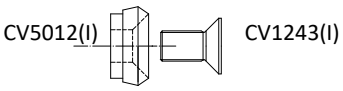


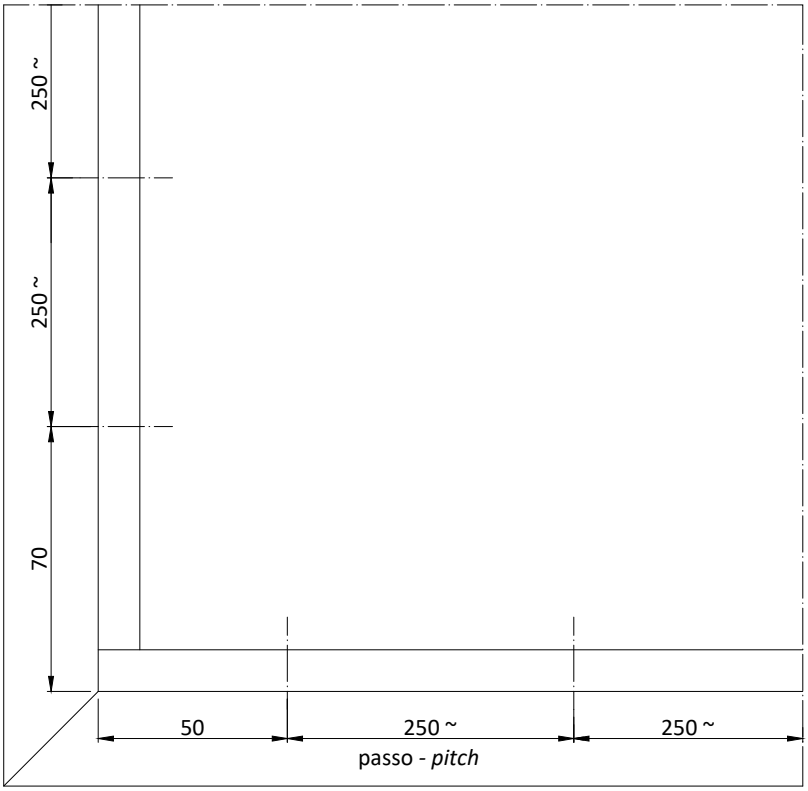


Passo clips fissaggio fermavetri
Clip pitch for glazing beads securing

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

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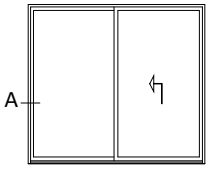

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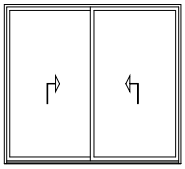

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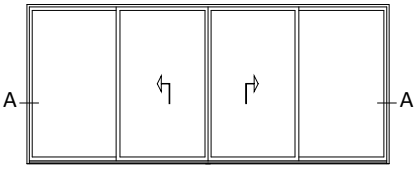

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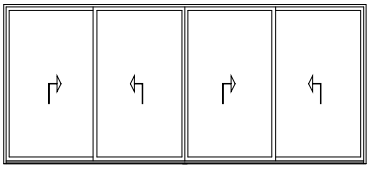

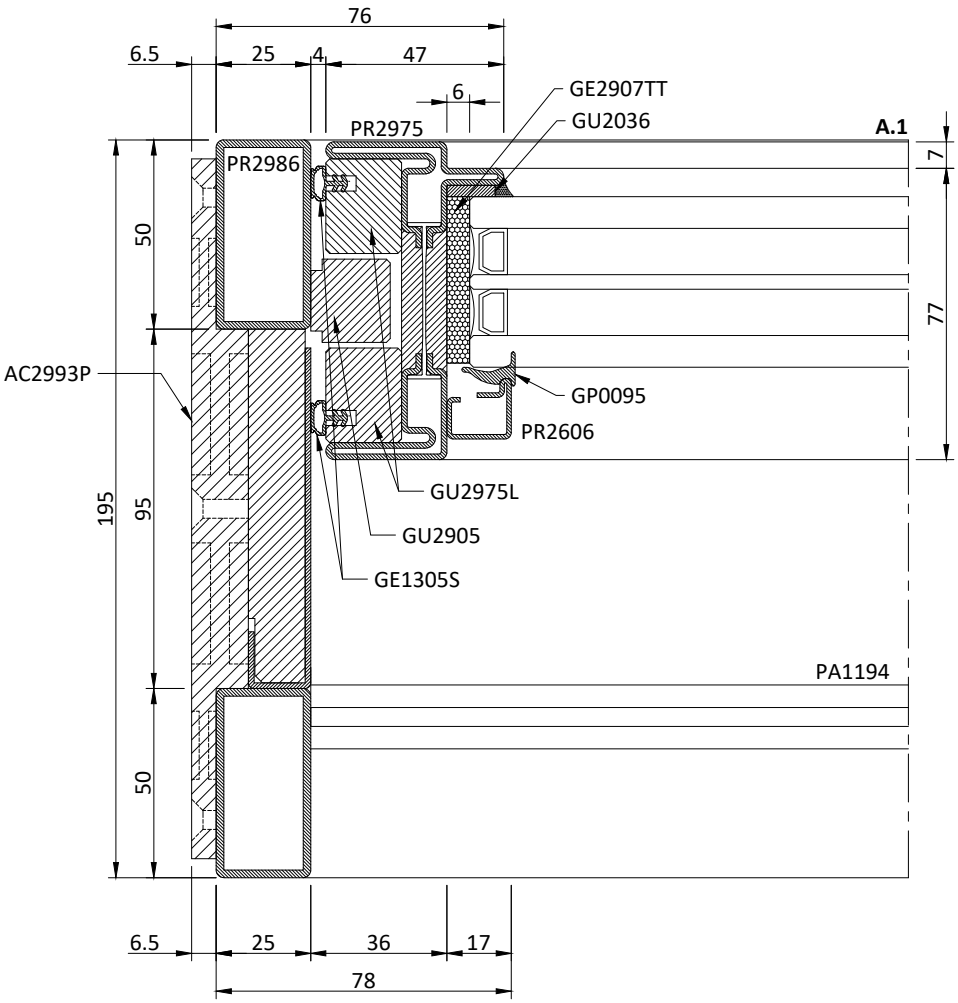

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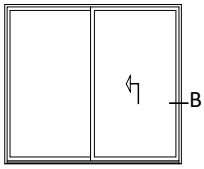

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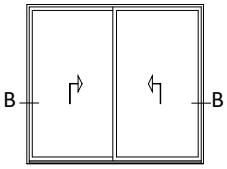

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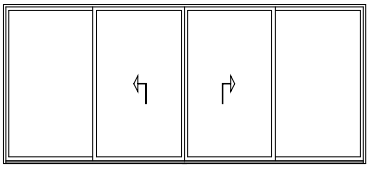

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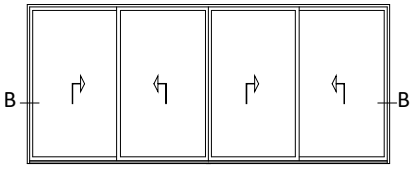

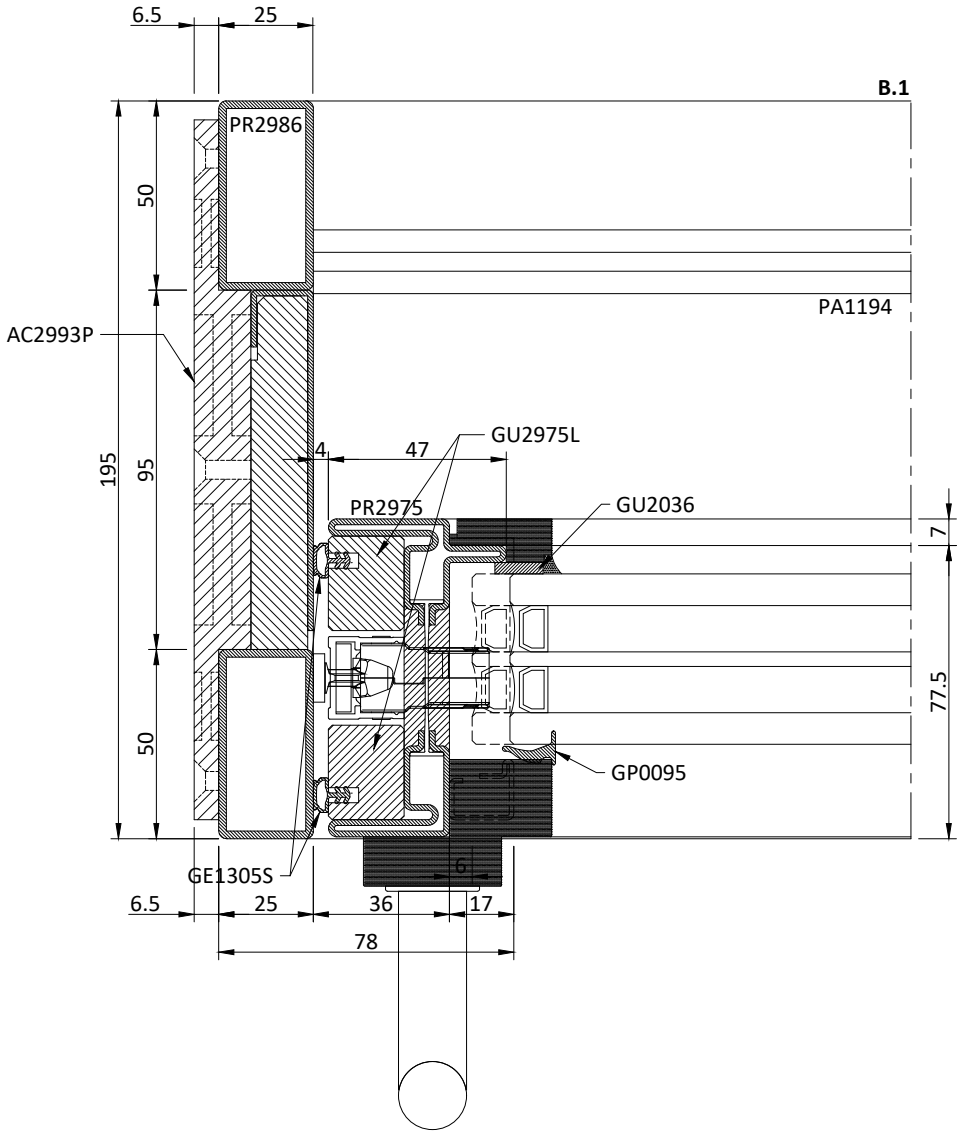

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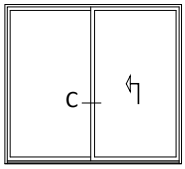

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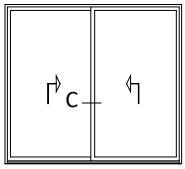

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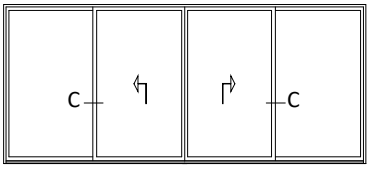

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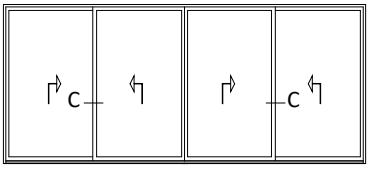

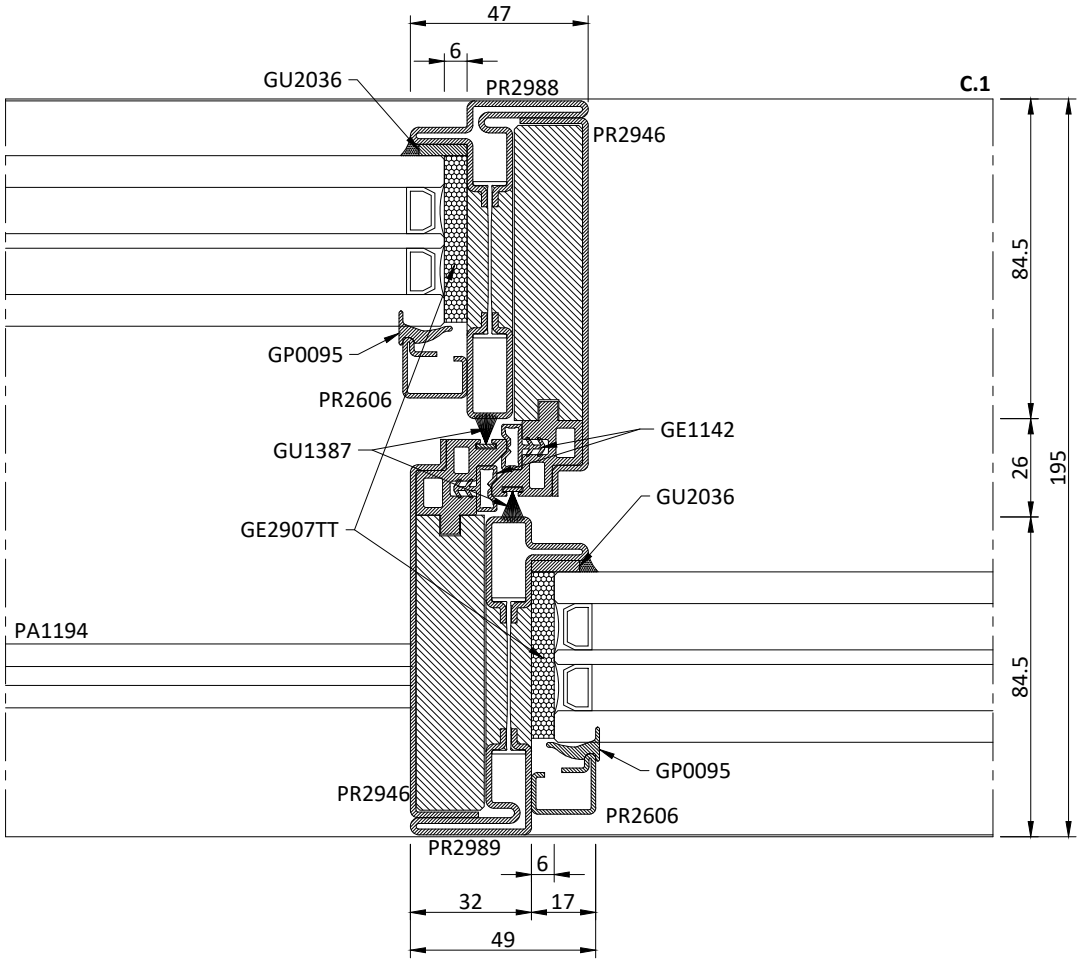

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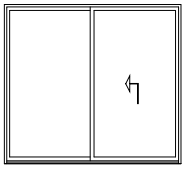

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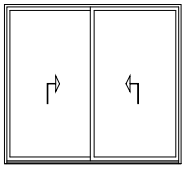

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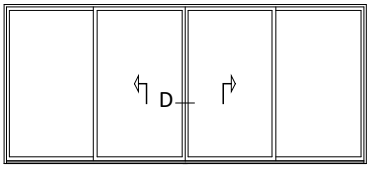

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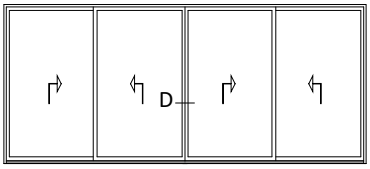

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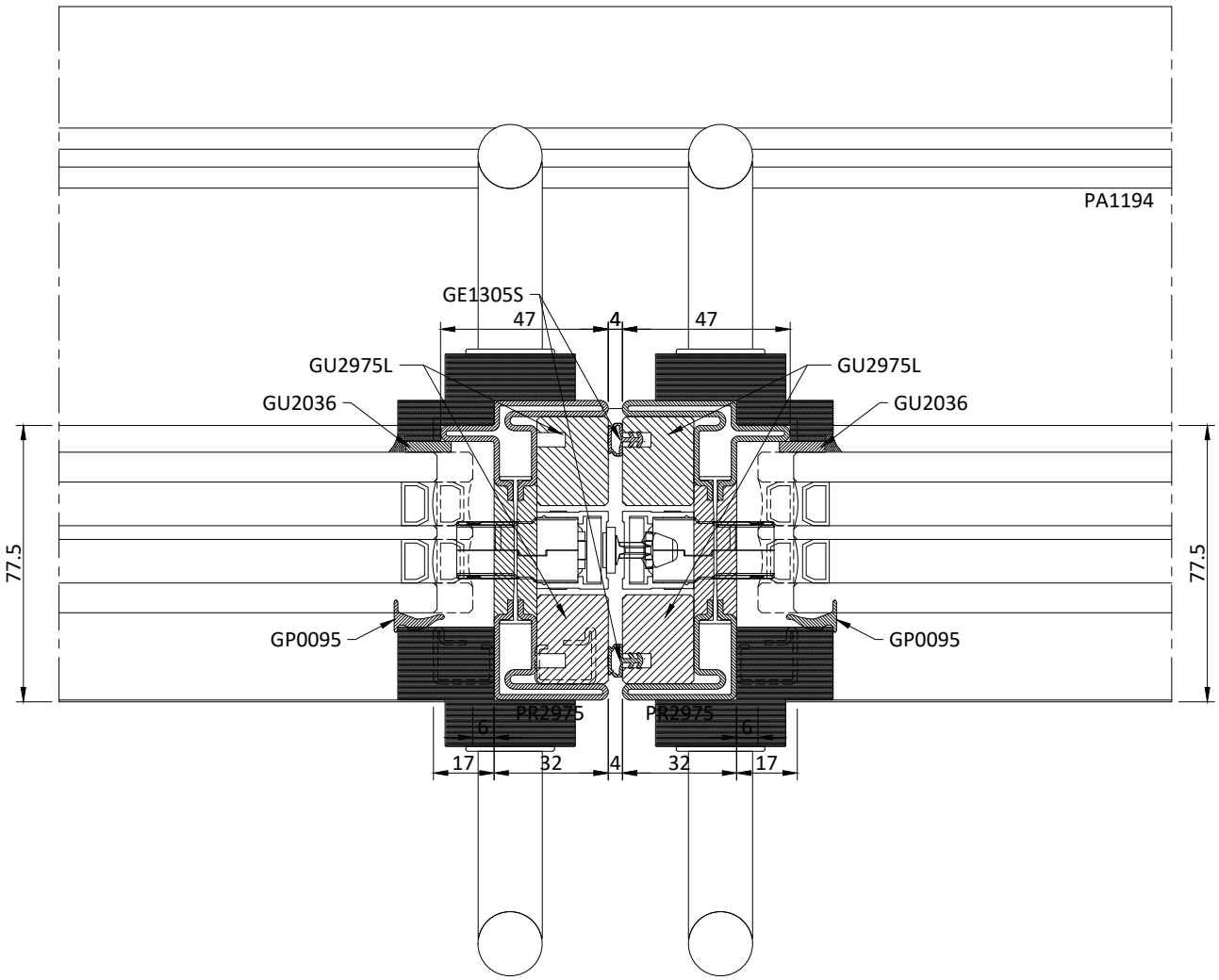

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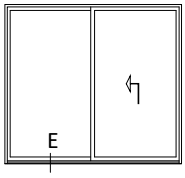

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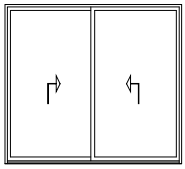

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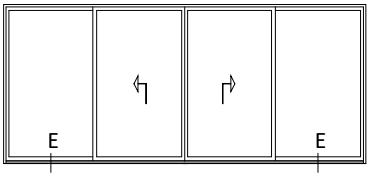

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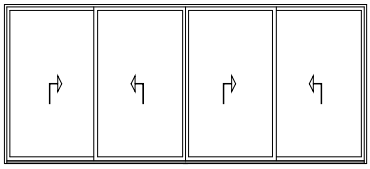

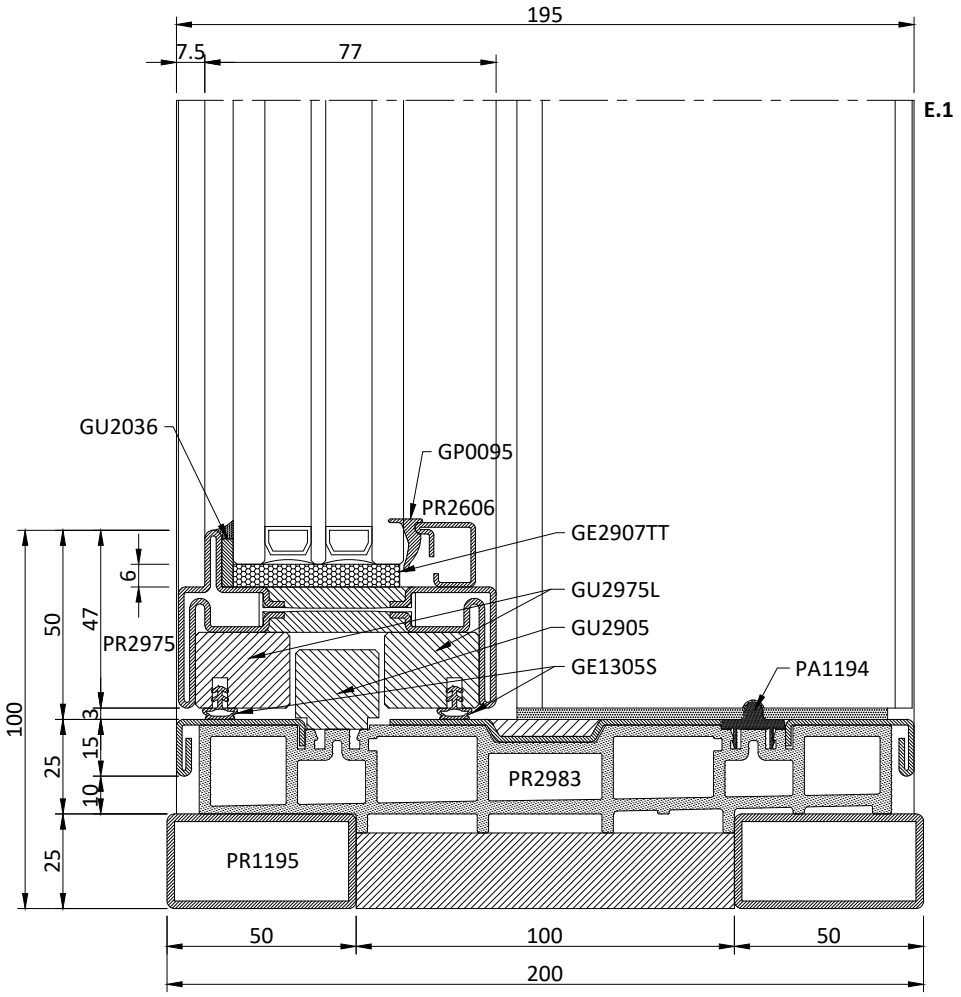

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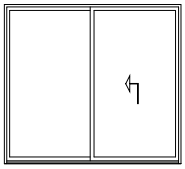

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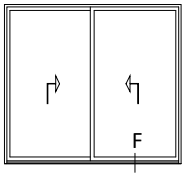

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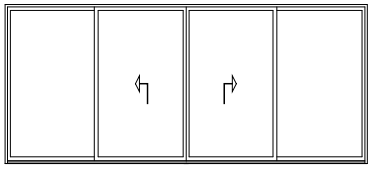

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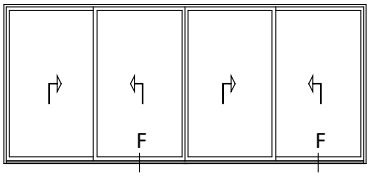

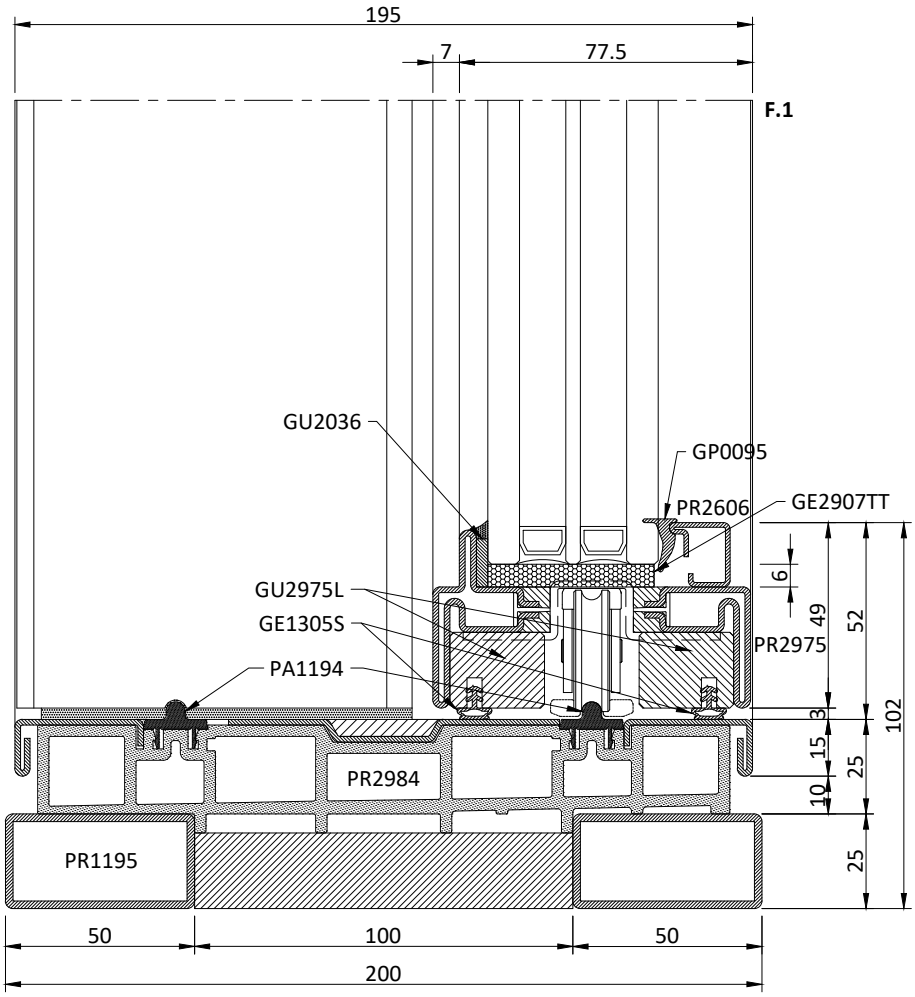

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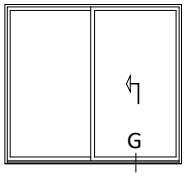

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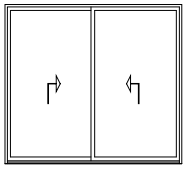

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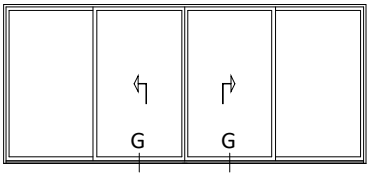

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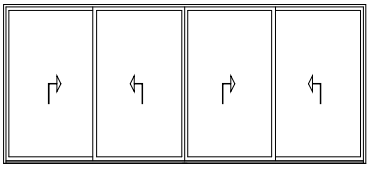

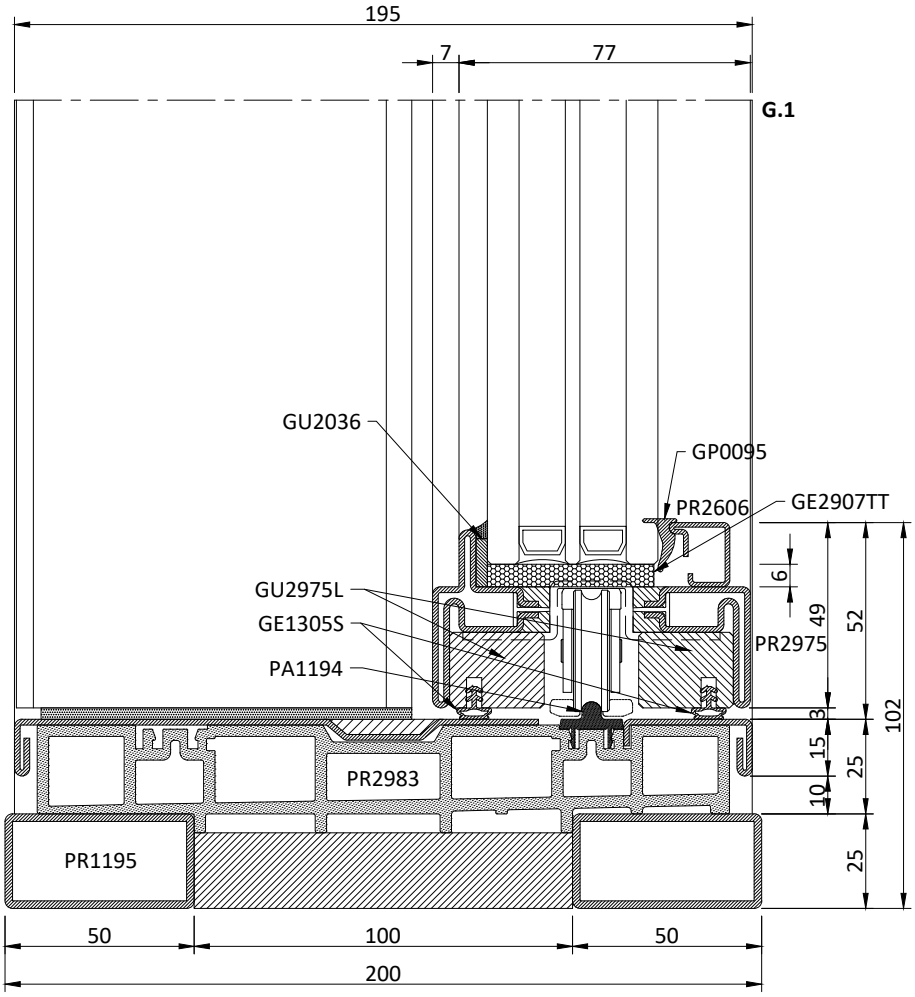

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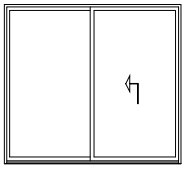

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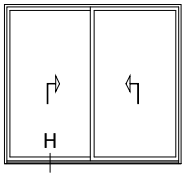

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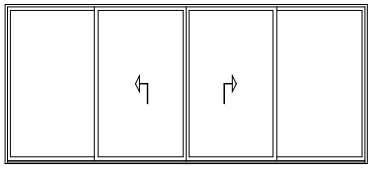

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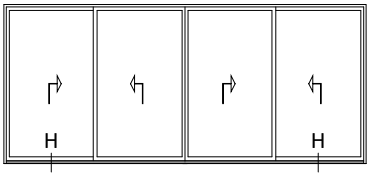

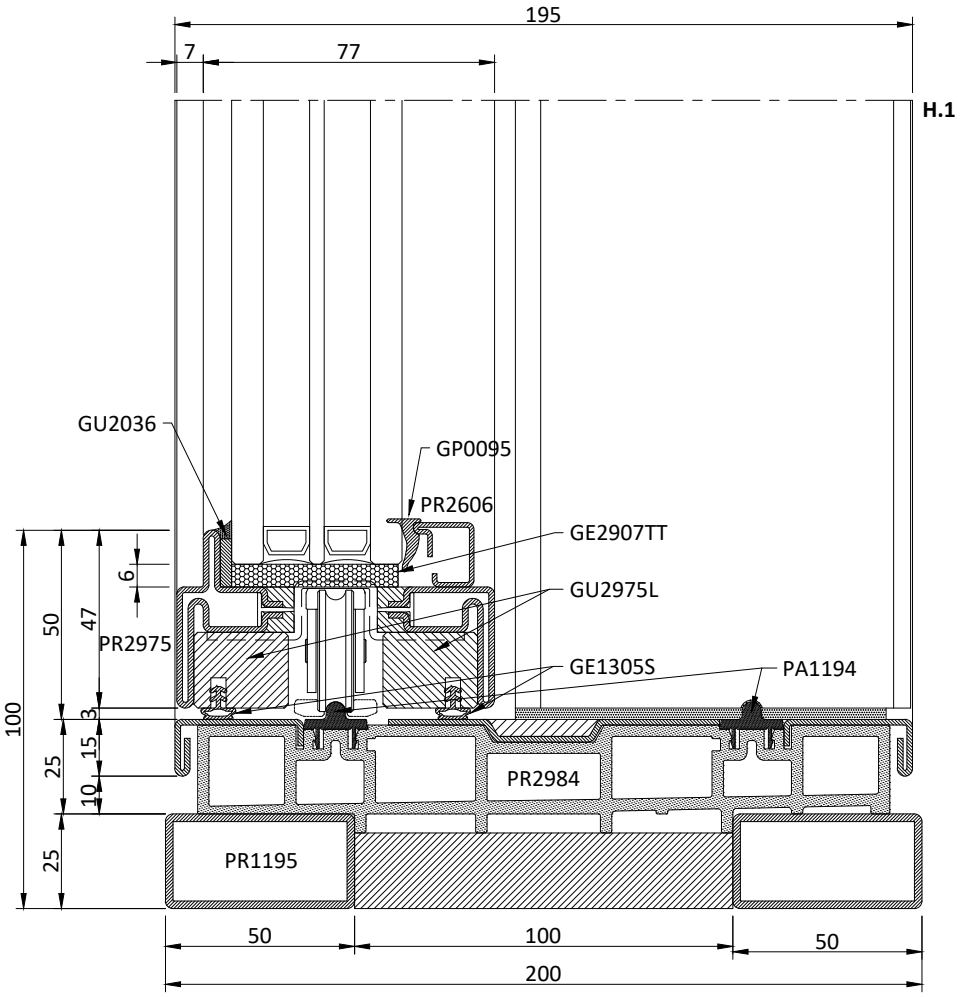

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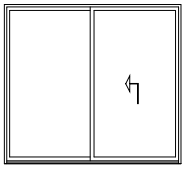

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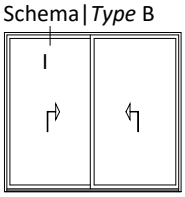

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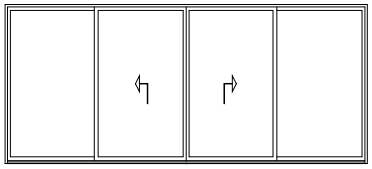

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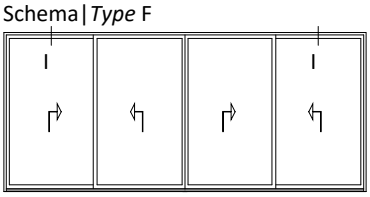

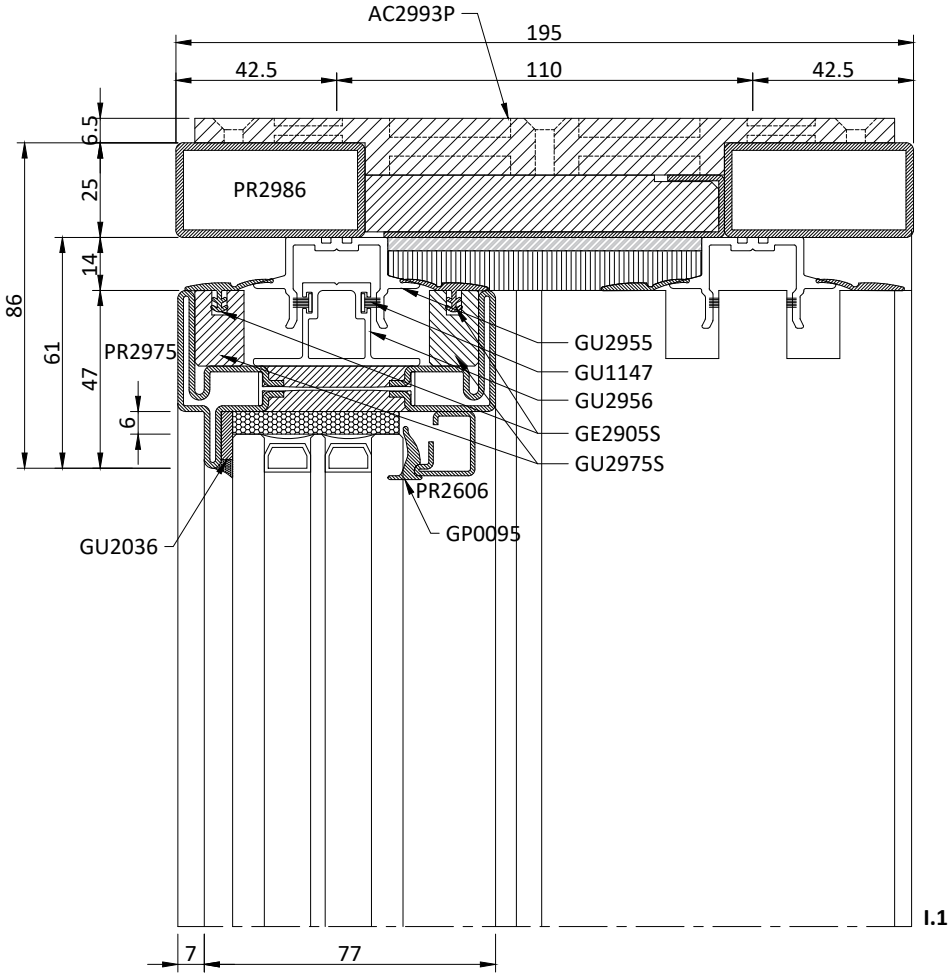

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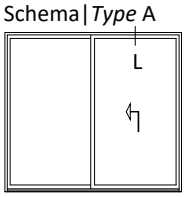

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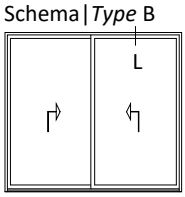

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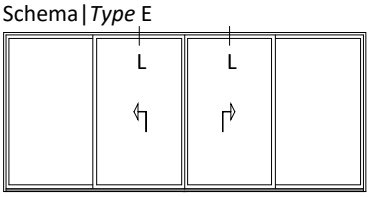

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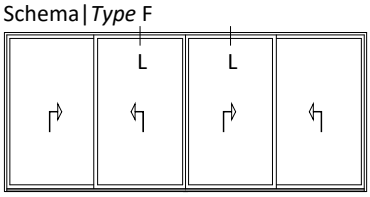

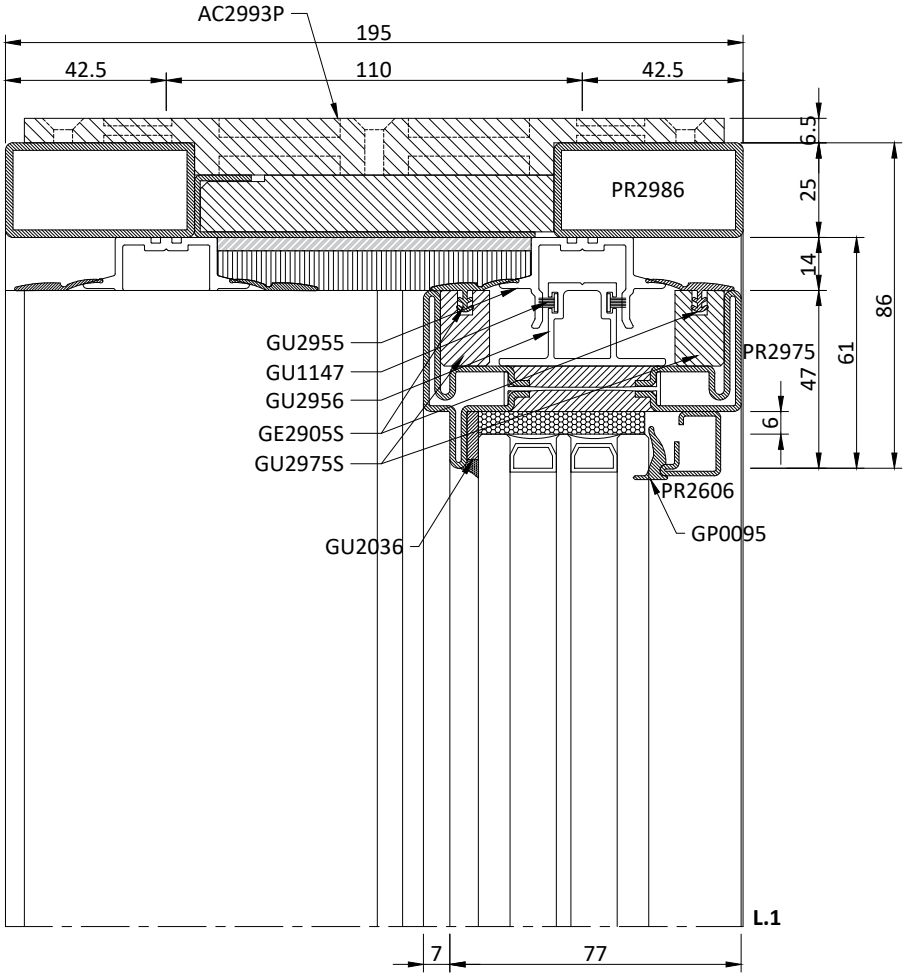

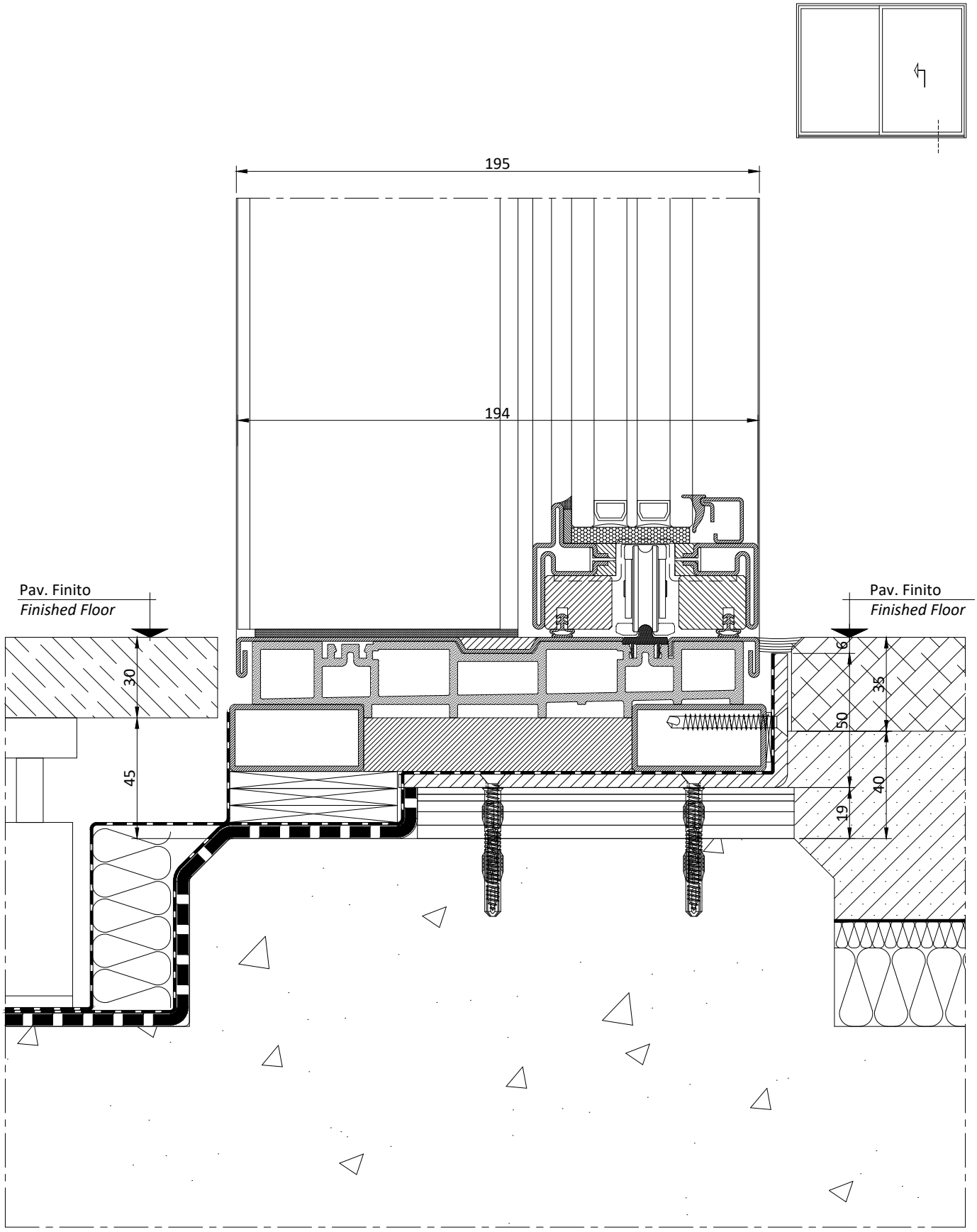
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Pav. Finito
Finished Floor
Pav. Finito
Finished Floor
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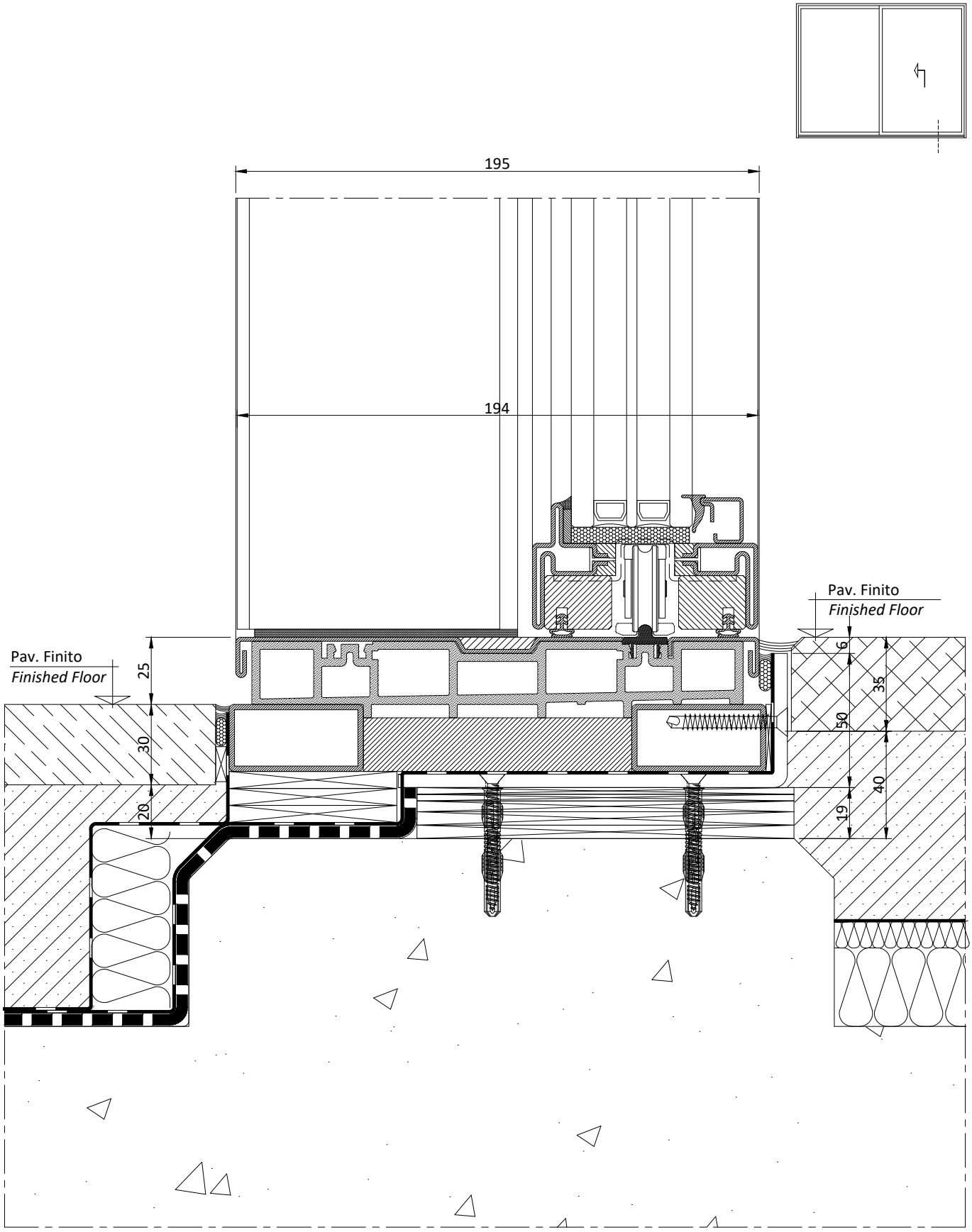
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Pav. Finito
Finished Floor
Pav. Finito
Finished Floor
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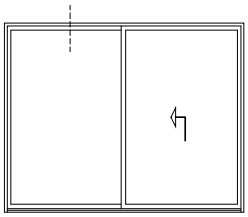

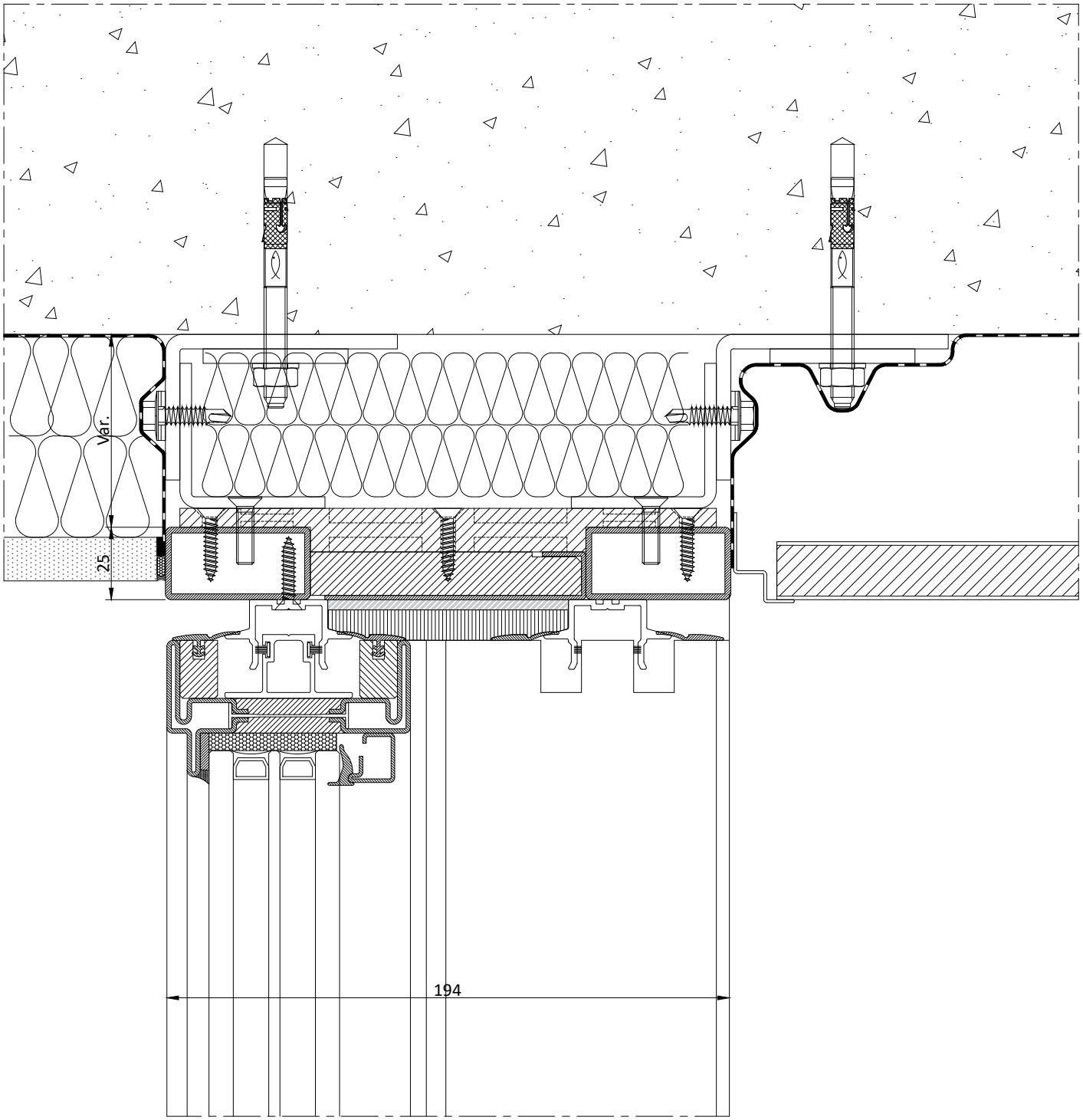
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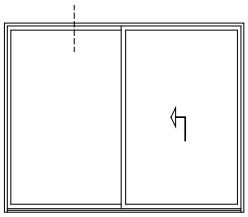

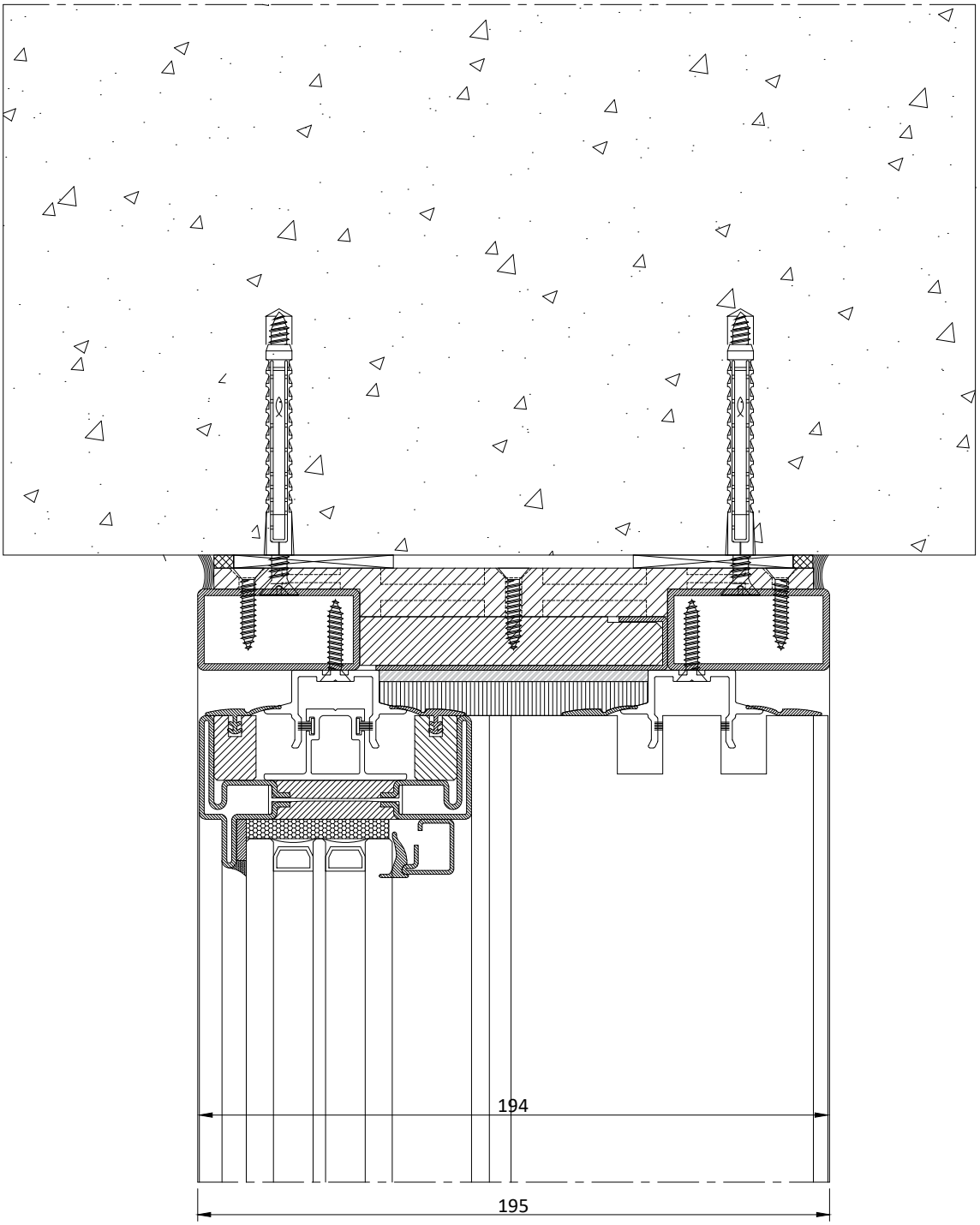
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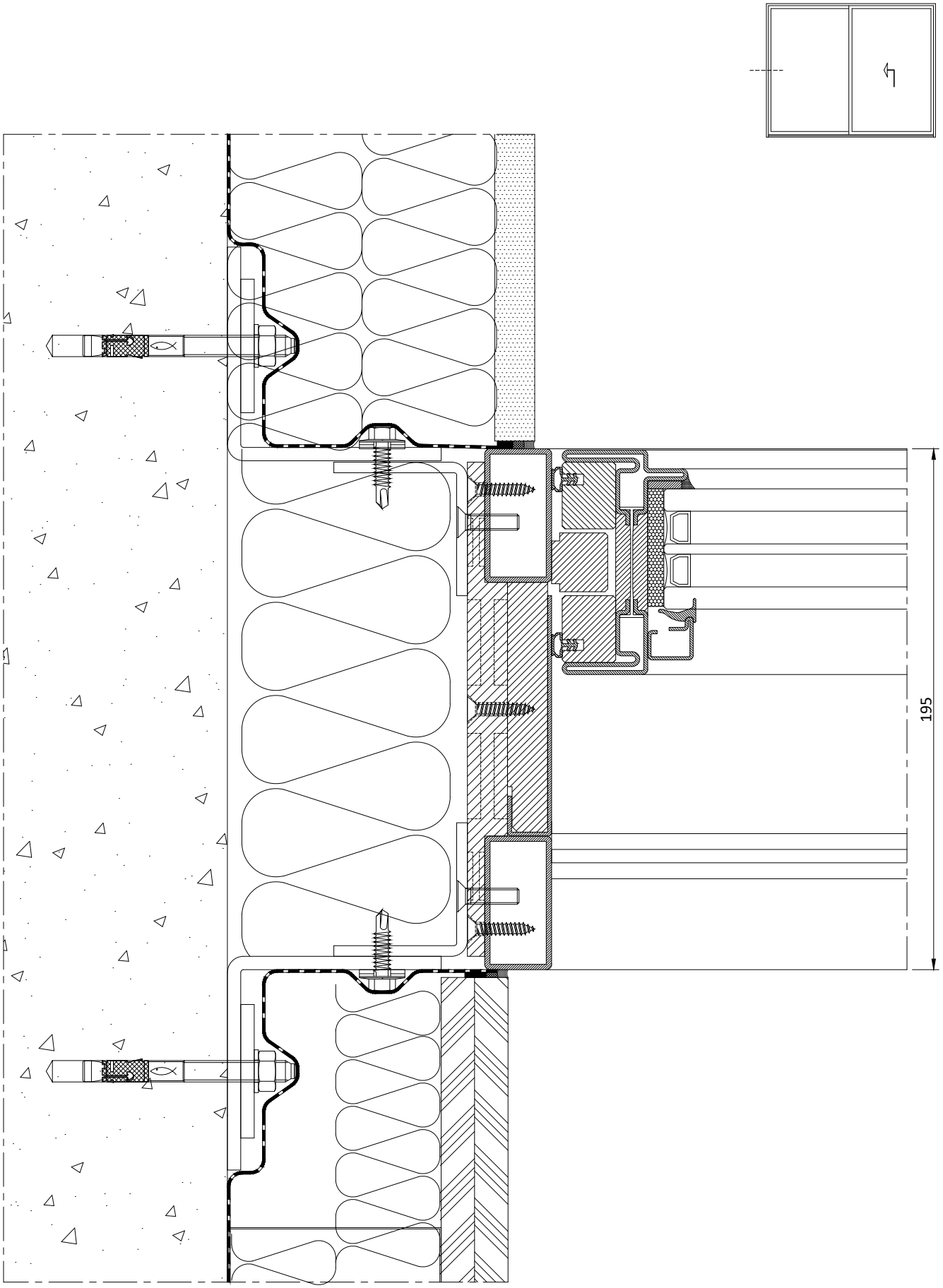
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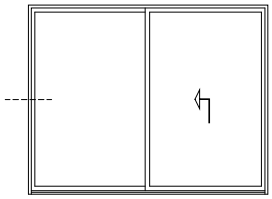

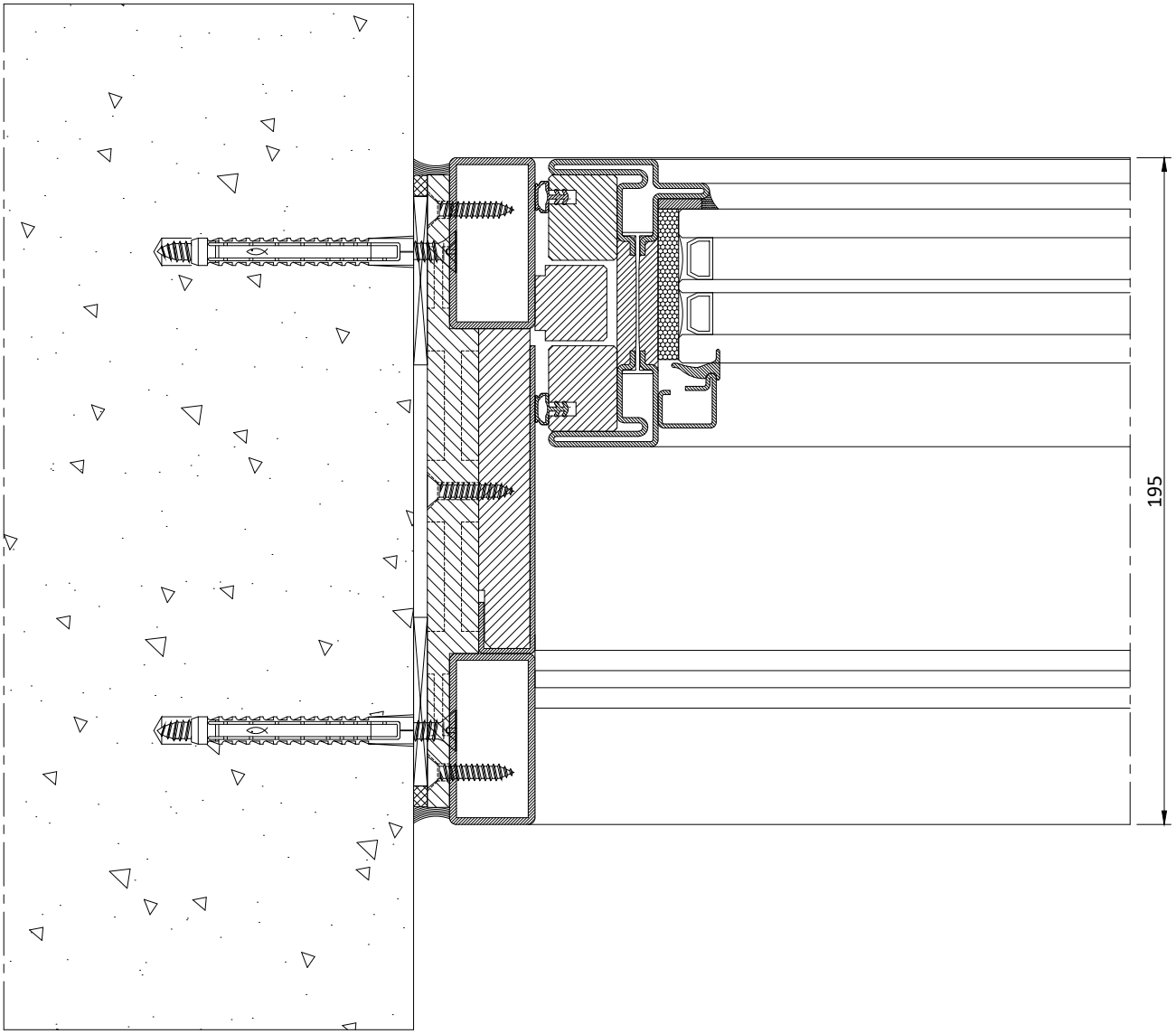
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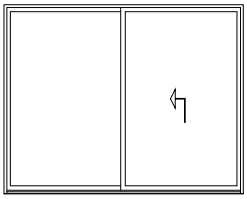
Distinta di taglio e lista componenti | *Cutting list and components list*

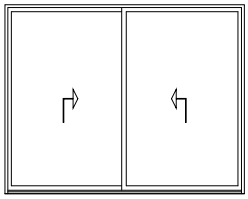
Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.
E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti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

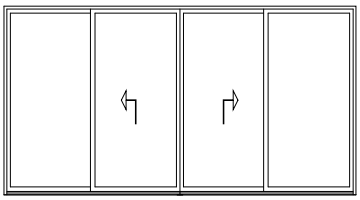
Schema | *Type* A



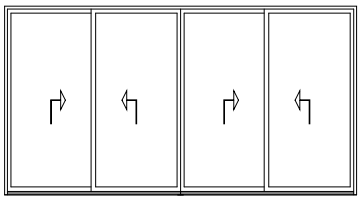
Schema | *Type* B

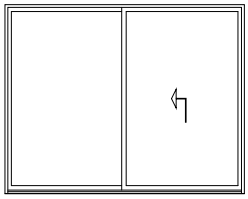


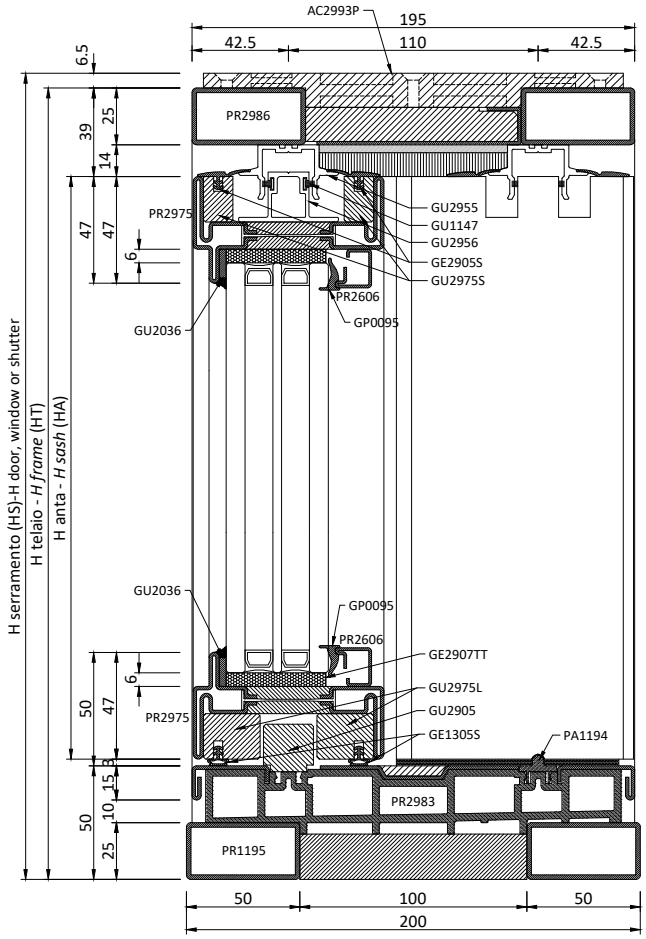
Schema | *Type* E



Schema | *Type* F



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42.5
PR2986
PR2975
GU2955
GU1147
GU2956
GE2905S
GU2975S
PR2606
GP0095
GU2036
GE2907TT
GU2975L
GU2905
GE1305S
PA1194
PR2983
PR1195
H serramento (HS)-H door, window or shutter
H telaio - *H frame* (HT)
H anta - *H sash* (HA)
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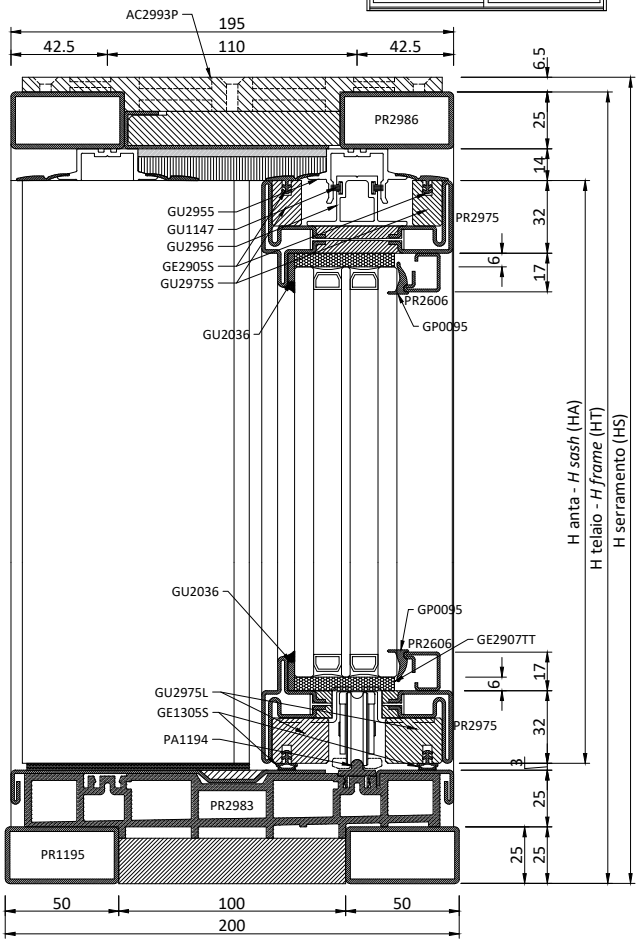
100
200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GE2907TT
GU2975L
GE1305S
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PR1195
H anta - *H sash* (HA)
H telaio - *H frame* (HT)
H serramento (HS)
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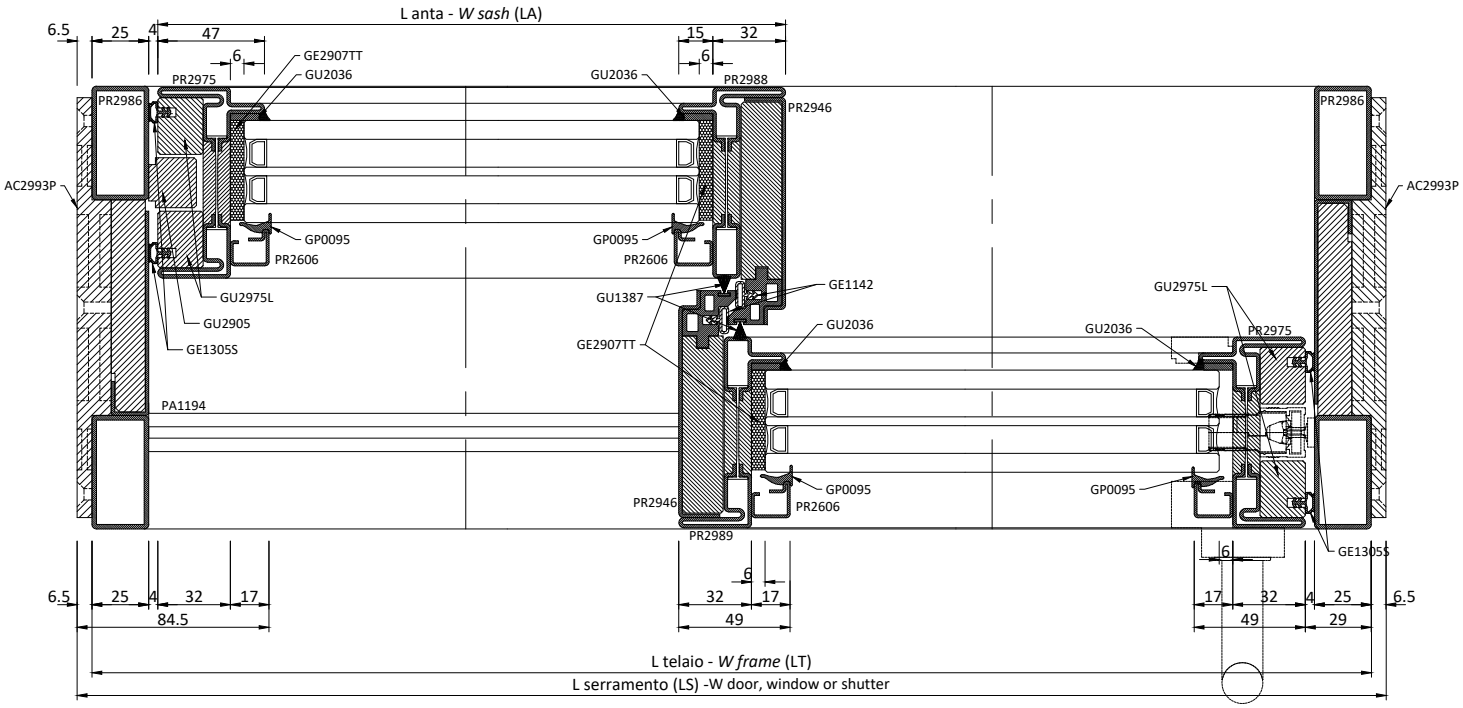
L anta - *W sash* (LA)
GE2907TT
GU2036
PR2975
PR2986
PR2988
PR2946
AC2993P
GP0095
PR2606
GU2975L
GU2905
GE1305S
GU1387
GE1142
PA1194
PR2989
GE1305S
84.5
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49
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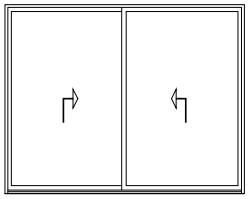
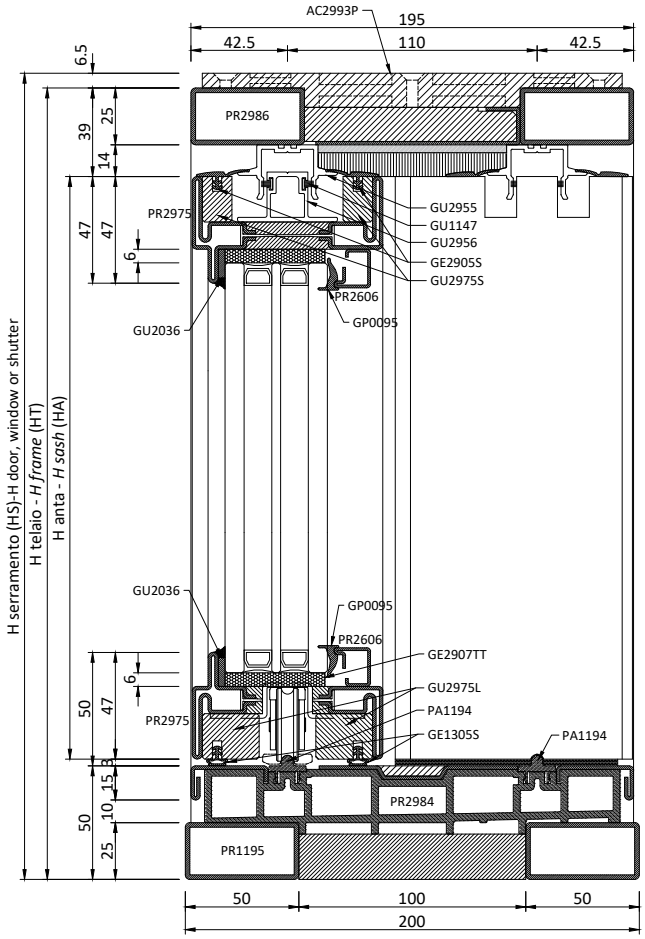
L telaio - *W frame* (LT)
L serramento (LS) -W door, window or shutter

	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio/*Cutting*	
	Telaio	***Frame***				
PR2986	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
PR1195	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
PR2983	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/2-53	90	90
	Telaio base - copertina centrale (Part. C)	*Lower frame - central cover (Detail C)*	1	(LT-50)/2	90	90
	Telaio base - copertina esterna (Part. A)	*Lower frame - external cover (Detail A)*	1	(LT-50)/2	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-50)/2)+21	90	90
GU2956	Pattino di scorrimento anta mobile e fissa	*Runner for sliding and fixed sash*	2	((LT-58)/2)+18,5	90	90
PA1194	Profilo guida inferiore	*Lower profile*	1	LT-50	90	90
	Anta	***Sash***				
PR2975	Profilo zoccolo	*Bottom rail profile*	4	((LT-58)/2)+23,5	45	45
	Profilo zoccolo	*Bottom rail profile*	2	HT-92	45	45
PR2988	Profilo a "T"	*"T" profile*	1	HT-92	45	45
PR2989	Profilo a "Z"	*"Z" profile*	1	HT-92	45	45
PR2946	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
GU2975L	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	4	HT-92	45	45
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	2	((LT-58)/2)+3,5	45	90
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	2	((LT-58)/2)+3,5	90	45
GU2975S	Profilo plastico porta guarnizione superiore	*Plastic door profile upper gasket*	4	((LT-58)/2)+3,5	90	45
GU2905	Estruso di compensazione	*Compensation extrusion*	1	HT-115	90	90
	Estruso di compensazione	*Compensation extrusion*	1	(LT/2)-68,5	90	90
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	4	((LT-58)/2)-40,5	45	45
	Profilo fermavetro	*Glazing bead profile*	4	HT-156	45	45
	Vetri	***Glass unit***				
	Vetrocamera	*Double glazing*	2	((LT-58)/2)-40,5x(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.xx	Kit alzante scorrevole	*Lift and slide kit*	1			
ACV___	Maniglione	*Large handle*	1			
AC2993P	Accessorio assiemaggio telaio	*Frame assemblage accessory*	var.			
AC1305G	Angolo vulcanizzato per GE1305S	*Vulcanised corner gasket for GE1106S*	4			
AC290TES	Squadretta di unione per telaio PR2986	*Corner joint for frame PR2986*	4			
CV5403I	Rondella in acciaio inox/epdm	*Stainless steel/vulcanaised 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		
GE2905S	Guarnizione superiore ante	*Gasket for upper sash*	2	LT		
GE1305S	Guarnizione perimetrale ante	*Gasket for side sash*	2	2xLT/2+2xHT		
GE1142	Guarnizione labirinto centrale	*Gasket for central labyrinth*	2	HT		
GU1387	Spazzolino verticale labirinto	*Vertical labyrinth brush + adhesive*	1	HT		
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 contractionsof the material over time*						

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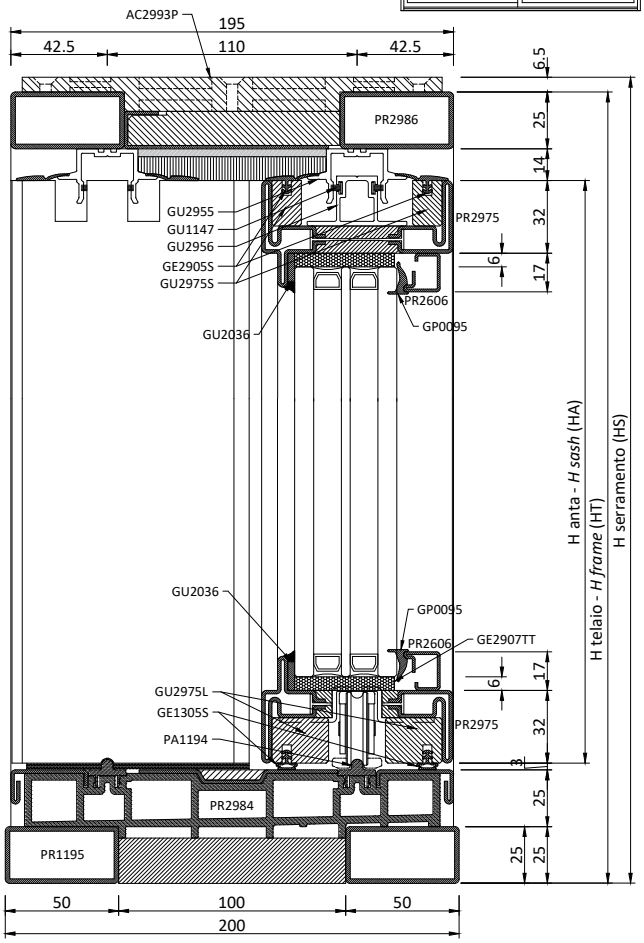
PR2606
GP0095
GU2036
GE2907TT
GU2975L
PA1194
GE1305S
PR2984
PR1195
H serramento (HS)-H door, window or shutter
H telaio - *H frame* (HT)
H anta - *H sash* (HA)
50
100
200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PR2986
PR2975
GU2955
GU1147
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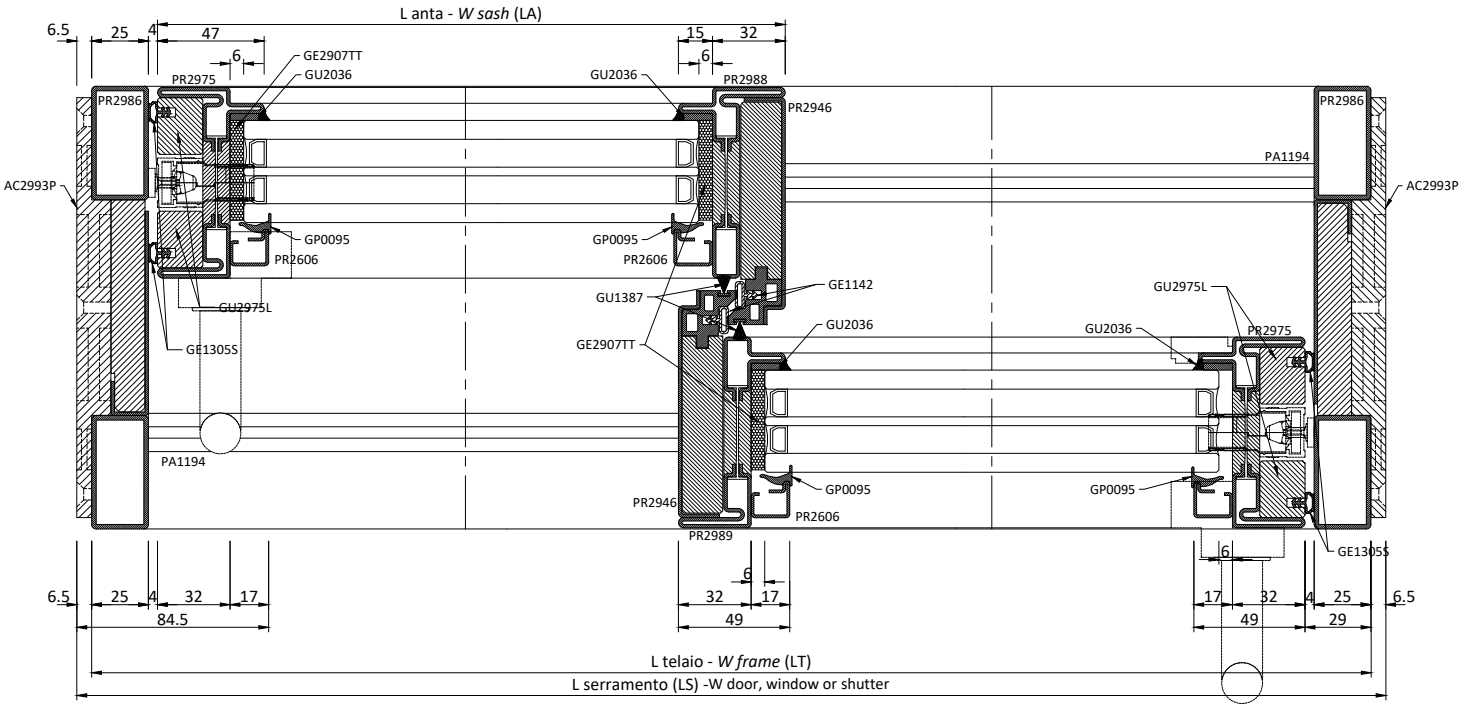
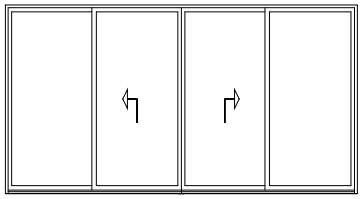
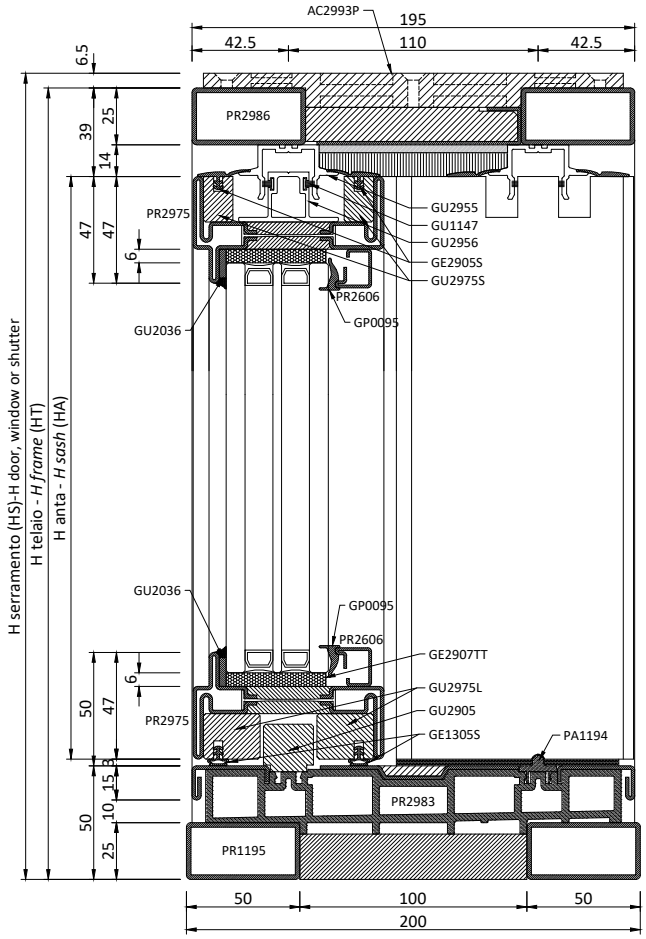
GE2905S
GU2975S
PR2606
GP0095
GU2036
GE2907TT
GU2975L
GE1305S
PA1194
PR2984
PR1195
H anta - *H sash* (HA)
H telaio - *H frame* (HT)
H serramento (HS)
50
100
200


L anta - *W sash* (LA)
PR2986
PR2975
GE2907TT
GU2036
PR2988
PR2946
AC2993P
GP0095
PR2606
GU2975L
GE1305S
PA1194
GU1387
GE1142
PR2989
GU2975L
PR2975
GE1305S
L telaio - *W frame* (LT)
L serramento (LS) -W door, window or shutter
84.5
49
29

	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio/*Cutting*	
	Telaio	***Frame***				
PR2986	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
PR1195	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
PR2984	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/2-53	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	((LT-58)/2)+18,5	90	90
PA1194	Profilo guida inferiore	*Lower profile*	2	LT-50	90	90
	Anta	***Sash***				
PR2975	Profilo zoccolo	*Bottom rail profile*	4	((LT-58)/2)+23,5	45	45
	Profilo zoccolo	*Bottom rail profile*	2	HT-92	45	45
PR2988	Profilo a "T"	*"T" profile*	1	HT-92	45	45
PR2989	Profilo a "Z"	*"Z" profile*	1	HT-92	45	45
PR2946	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*	4	HT-92	45	45
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	2	((LT-58)/2)+3,5	45	90
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	2	((LT-58)/2)+3,5	90	45
GU2975S	Profilo plastico porta guarnizione superiore	*Plastic door profile upper gasket*	4	((LT-58)/2)+3,5	90	45
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	4	((LT-58)/2)-40,5	45	45
	Profilo fermavetro	*Glazing bead profile*	4	HT-156	45	45
	Vetri	***Glass unit***				
	Vetrocamera	*Double glazing*	2	((LT-58)/2)-40,5x(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.xx	Kit alzante scorrevole	*Lift and slide kit*	2			
ACV___	Maniglione	*Large handle*	2			
AC2993P	Accessorio assiemaggio telaio	*Frame assemblage accessory*	var.			
AC1305G	Angolo vulcanizzato per GE1305S	*Vulcanised corner gasket for GE1106S*	4			
AC290TES	Squadretta di unione per telaio PR2986	*Corner joint for frame PR2986*	4			
CV5403I	Rondella in acciaio inox/epdm	*Stainless steel/vulcanaised 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		
GE2905S	Guarnizione superiore ante	*Gasket for upper sash*	2	LT		
GE1305S	Guarnizione perimetrale ante	*Gasket for side sash*	2	2xLT/2+2xHT		
GE1142	Guarnizione labirinto centrale	*Gasket for central labyrinth*	2	HT		
GU1387	Spazzolino verticale labirinto	*Vertical labyrinth brush + adhesive*	1	HT		
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 contractionsof the material over time*						

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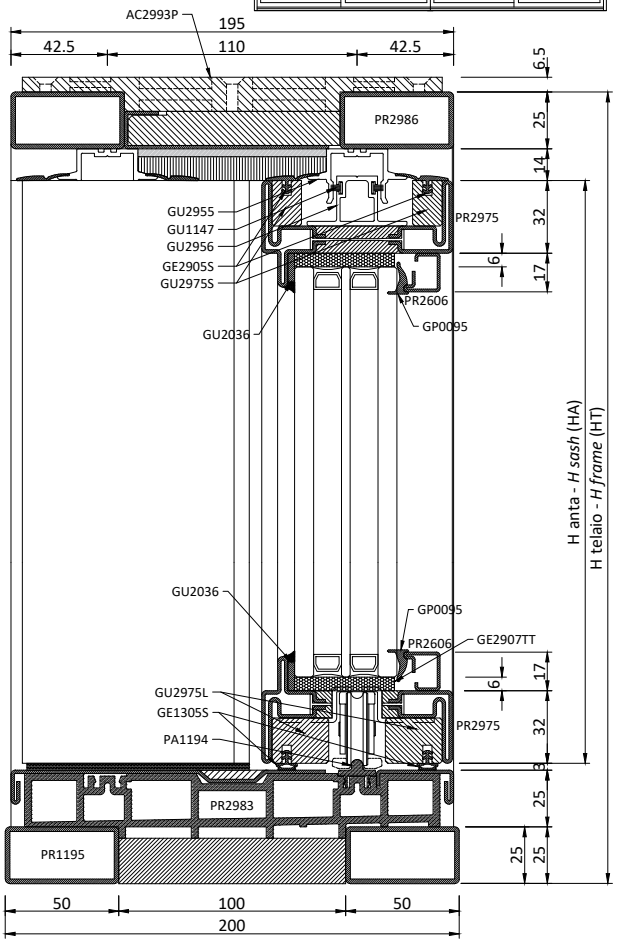
195
42.5
110
42.5
PR2986
PR2975
GU2955
GU1147
GU2956
GE2905S
GU2975S
PR2606
GP0095
GU2036
GE2907TT
GU2975L
GU2905
GE1305S
PA1194
PR2983
PR1195
H serramento (HS)-H door, window or shutter
H telaio - *H frame* (HT)
H anta - *H sash* (HA)
50
100
200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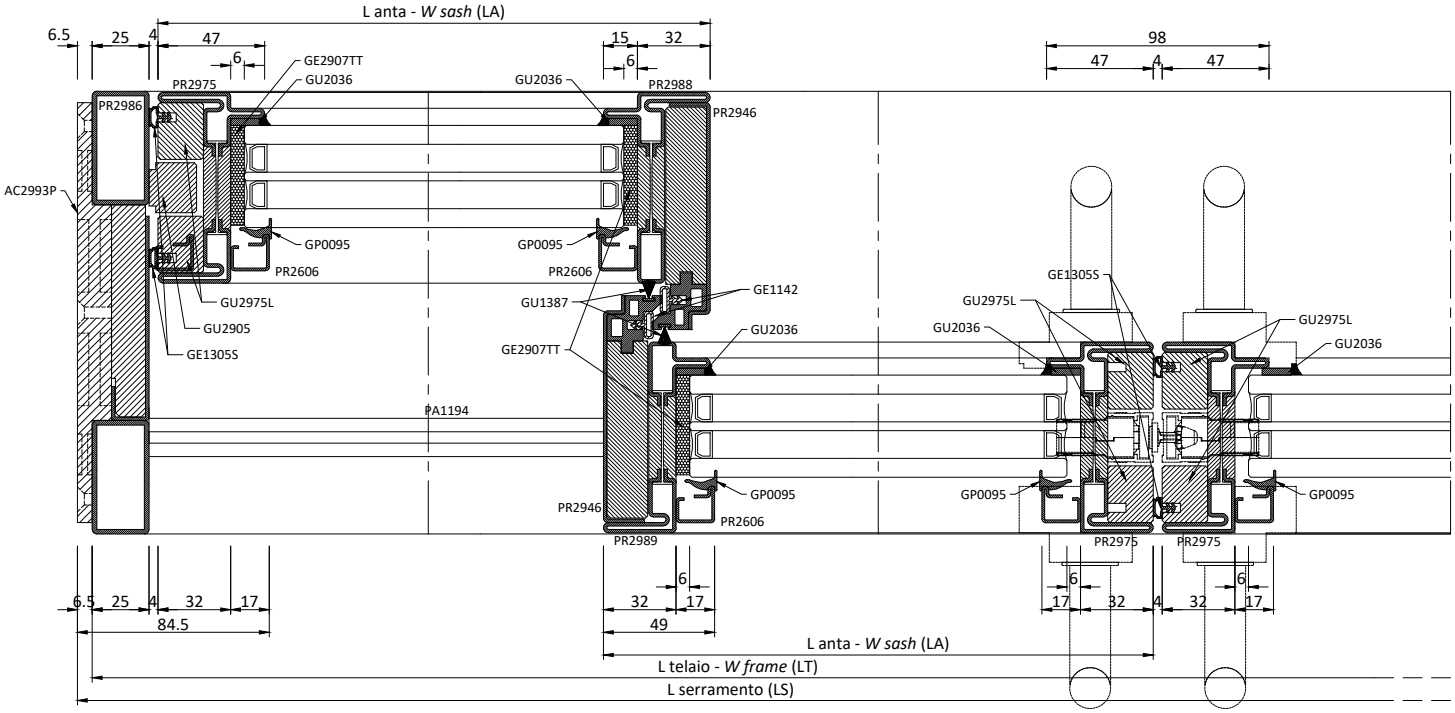
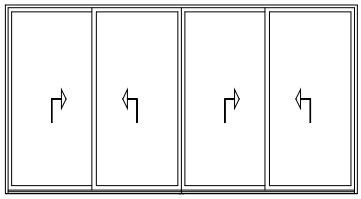
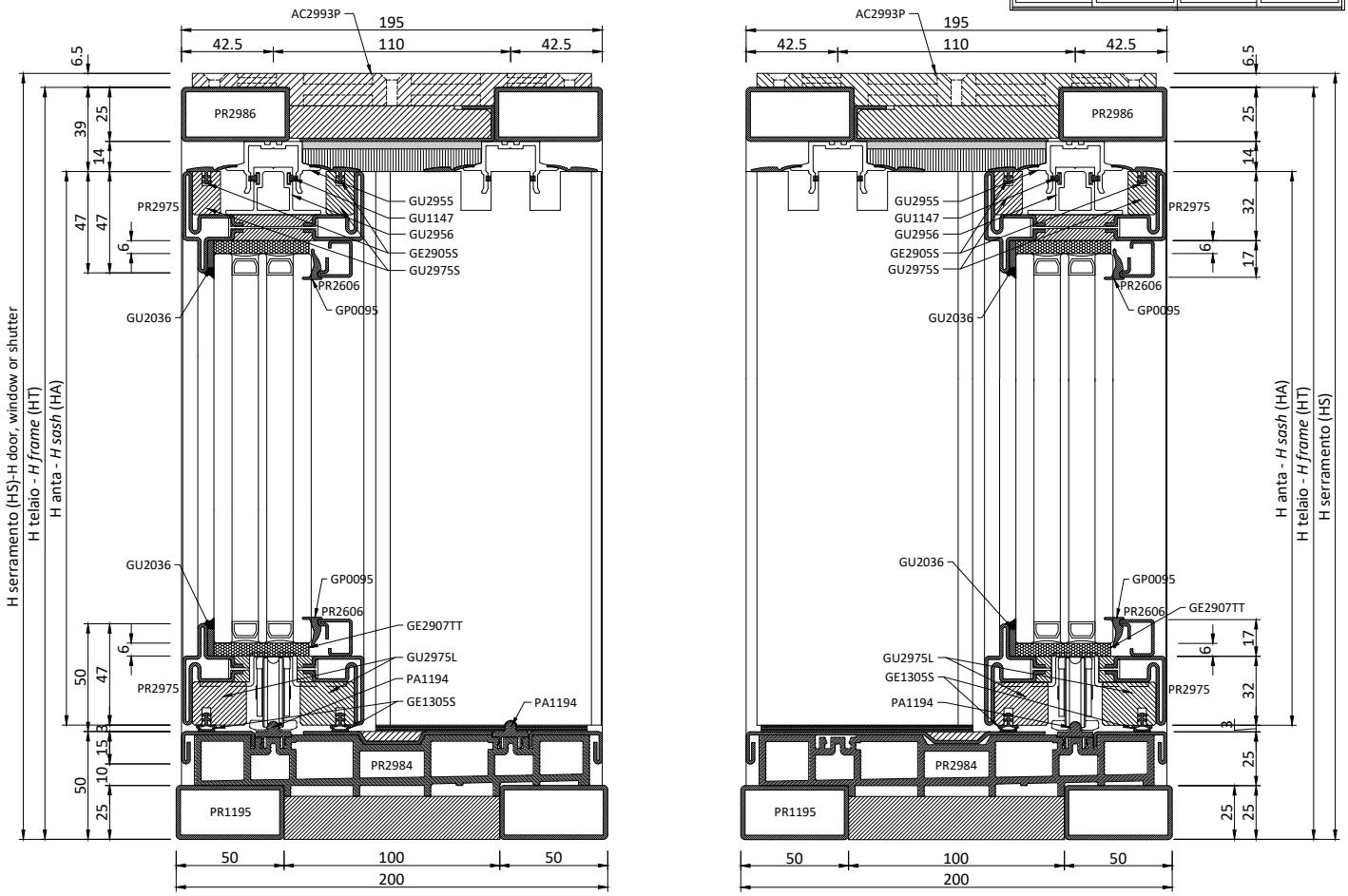
GU2956
GE2905S
GU2975S
PR2975
PR2606
GP0095
GU2036
GE2907TT
GU2975L
GE1305S
PA1194
PR2983
PR1195
H anta - *H sash* (HA)
H telaio - *H frame* (HT)
50
100
200


L anta - *W sash* (LA)
GE2907TT
GU2036
PR2975
PR2986
PR2988
PR2946
AC2993P
GP0095
PR2606
GU2975L
GU2905
GE1305S
GU1387
GE1142
PA1194
PR2989
98
47
4
47
GE1305S
GU2975L
GU2036
84.5
49
L anta - *W sash* (LA)
L telaio - *W frame* (LT)
L serramento (LS)

	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio/*Cutting*	
	Telaio	***Frame***				
PR2986	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*	1	(LT-344)/2+145	90	90
	Estruso centrale di unione	*Central extrusion junction*	2	(LT-344)/4+99,5	90	90
	Estruso centrale di unione	*Central extrusion junction*	2	HT-25	90	90
	Profilo centrale a "C"	*"C" profile*	1	(LT-344)/2+140	90	90
	Profilo centrale a "C"	*"C" profile*	2	(LT-344)/4+97	90	90
	Profilo centrale a "C"	*"C" profile*	2	HT-25	90	90
PR1195	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
PR2983	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-344)/4+46,5	90	90
	Telaio base - copertina centrale (Part. A)	*Lower frame - central cover (Detail C)*	2	(LT-344)/4+74,5	90	90
	Telaio base - copertina esterna (Part. C)	*Lower frame - external cover (Detail A)*	1	(LT-344)/2+145	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-344)/4+96	90	90
GU2956	Pattino di scorrimento anta mobile e fissa	*Runner for sliding and fixed sash*	4	(LT-344)/4+89	90	90
PA1194	Profilo guida inferiore	*Lower profile*	1	LT-50	90	90
	Anta	***Sash***				
PR2975	Profilo zoccolo	*Bottom rail profile*	8	(LT-344)/4+94	45	45
	Profilo zoccolo	*Bottom rail profile*	4	HT-92	45	45
PR2988	Profilo a "T"	*"T" profile*	2	HT-92	45	45
PR2989	Profilo a "Z"	*"Z" profile*	2	HT-92	45	45
PR2946	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*	2	HT-92	45	45
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	6	HT-92	45	45
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	4	(LT-344)/4+74	45	90
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	4	(LT-344)/4+74	90	45
GU2975S	Profilo plastico porta guarnizione superiore	*Plastic door profile upper gasket*	8	(LT-344)/4+74	90	45
GU2905	Estruso di compensazione	*Compensation extrusion*	2	HT-115	90	90
	Estruso di compensazione	*Compensation extrusion*	2	(LT-344)/4+31	90	90
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	8	(LT-344)/4+30	45	45
	Profilo fermavetro	*Glazing bead profile*	8	HT-156	45	45
	Vetri	***Glass unit***				
	Vetrocamera	*Double glazing*	4	(LT-344)/4+18x(HT-168)		
	ACCESSORI	***HARDWARE***				
Cod.	Descrizione	*Description*	n°	Note/*Notes*		
AC290ANT	Kit squadrette di giunzione ante	*Corner joint kit Sashes*	4			
AG2992.EF	Rostro aggiuntivo	*Additional hook bolt*	opz.			
AG2986E.xx	Kit alzante scorrevole	*Lift and slide kit*	1			
ACV___	Maniglione	*Large handle*	2			
AC2993P	Accessorio assiemaggio telaio	*Frame assemblage accessory*	var.			
AC1305G	Angolo vulcanizzato per GE1305S	*Vulcanised corner gasket for GE1106S*	8			
AC290TES	Squadretta di unione per telaio PR2986	*Corner joint for frame PR2986*	4			
CV5403I	Rondella in acciaio inox/epdm	*Stainless steel/vulcanaised 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		
GE2905S	Guarnizione superiore ante	*Gasket for upper sash*	8	LT/4		
GE1305S	Guarnizione perimetrale ante	*Gasket for side sash*	2	2xLT/2+6xHT		
GE1142	Guarnizione labirinto centrale	*Gasket for central labyrinth*	4	HT		
GU1387	Spazzolino verticale labirinto	*Vertical labyrinth brush + adhesive*	4	HA		
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 contractionsof the material over time*						




AC2993P
195
42.5
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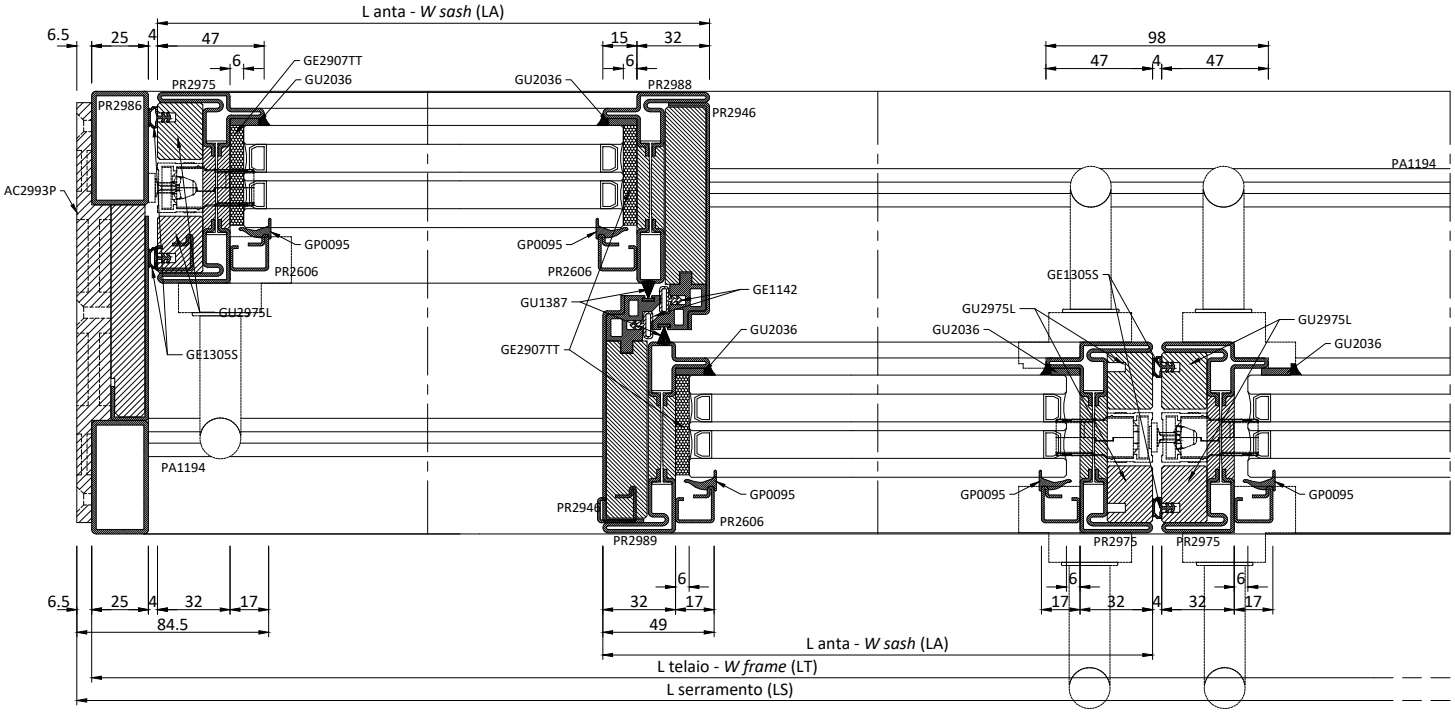
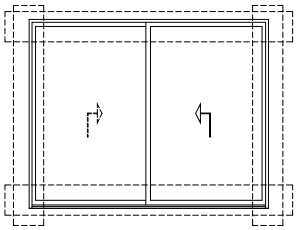
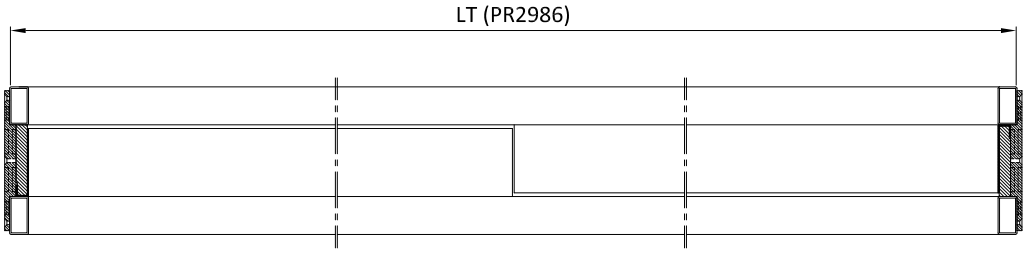
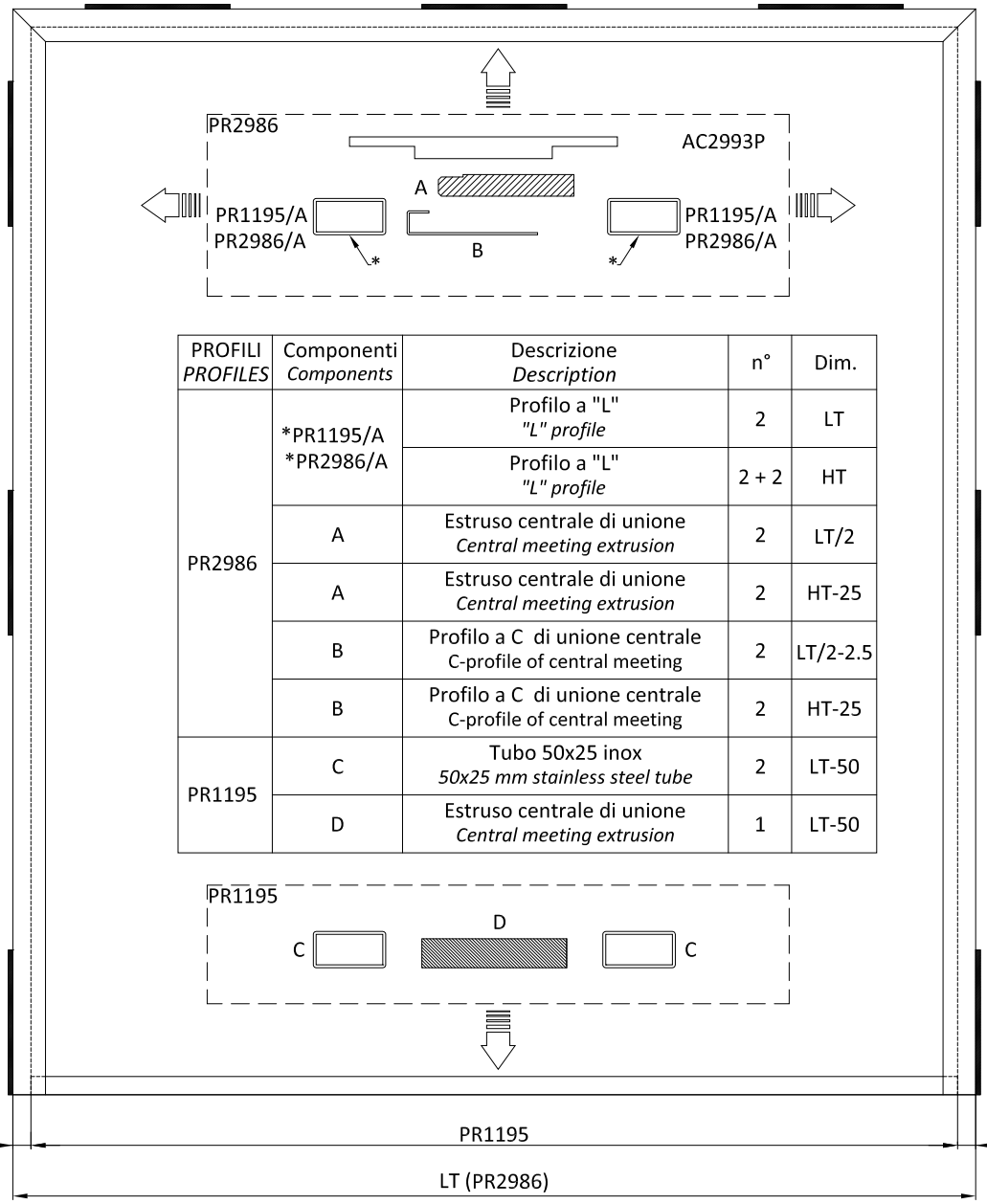
PR2986
PR2975
GU2955
GU1147
GU2956
GE2905S
GU2975S
PR2606
GP0095
GU2036
GE2907TT
GU2975L
PA1194
GE1305S
PR2984
PR1195
H serramento (HS)-H door, window or shutter
H telaio - *H frame* (HT)
H anta - *H sash* (HA)
H serramento (HS)
50
100
200

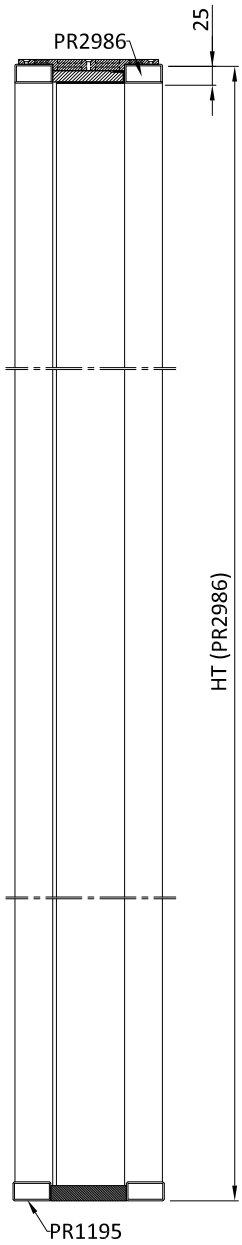

L anta - *W sash* (LA)
L telaio - *W frame* (LT)
L serramento (LS)
AC2993P
PR2986
PR2975
GE2907TT
GU2036
PR2988
PR2946
PA1194
GP0095
PR2606
GU2975L
GE1305S
GU1387
GE1142
PR2989
84.5
49
98

	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio/*Cutting*	
	Telaio	***Frame***				
PR2986	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*	1	(LT-344)/2+145	90	90
	Estruso centrale di unione	*Central extrusion junction*	2	(LT-344)/4+99,5	90	90
	Estruso centrale di unione	*Central extrusion junction*	2	HT-25	90	90
	Profilo centrale a "C"	*"C" profile*	1	(LT-344)/2+140	90	90
	Profilo centrale a "C"	*"C" profile*	2	(LT-344)/4+97	90	90
	Profilo centrale a "C"	*"C" profile*	2	HT-25	90	90
PR1195	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
PR2984	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)*	1	(LT-344)/2+89	90	90
	Telaio base - copertina esterna (Part. B)	*Lower frame - external cover (Detail B)*	2	(LT-344)/4+46,5	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 ante	*Upper rail of sliding sash*	2	LT-50	90	90
GU2956	Pattino di scorrimento ante	*Runner for sliding and fixed sash*	4	(LT-344)/4+89	90	90
PA1194	Profilo guida inferiore	*Lower profile*	2	LT-50	90	90
	Anta	***Sash***				
PR2975	Profilo zoccolo	*Bottom rail profile*	8	(LT-344)/4+94	45	45
	Profilo zoccolo	*Bottom rail profile*	4	HT-92	45	45
PR2988	Profilo a "T"	*"T" profile*	2	HT-92	45	45
PR2989	Profilo a "Z"	*"Z" profile*	2	HT-92	45	45
PR2946	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*	2	HT-92	45	45
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	6	HT-92	45	45
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	4	(LT-344)/4+74	45	90
	Profilo plastico porta guarnizione perimetrale	*Plastic door profile perimeter gasket*	4	(LT-344)/4+74	90	45
GU2975S	Profilo plastico porta guarnizione superiore	*Plastic door profile upper gasket*	8	(LT-344)/4+74	90	45
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	8	(LT-344)/4+30	45	45
	Profilo fermavetro	*Glazing bead profile*	8	HT-156	45	45
	Vetri	***Glass unit***				
	Vetrocamera	*Double glazing*	4	(LT-344)/4+18x(HT-168)		
	ACCESSORI	***HARDWARE***				
Cod.	Descrizione	*Description*	n°	Note/*Notes*		
AC290ANT	Kit squadrette di giunzione ante	*Corner joint kit Sashes*	4			
AG2992.EF	Rostro aggiuntivo	*Additional hook bolt*	opz.			
AG2986F.xx	Kit alzante scorrevole	*Lift and slide kit*	1			
ACV___	Maniglione	*Large handle*	4			
AC2993P	Accessorio assiemaggio telaio	*Frame assemblage accessory*	var.			
AC1305G	Angolo vulcanizzato per GE1305S	*Vulcanised corner gasket for GE1106S*	8			
AC290TES	Squadretta di unione per telaio PR2986	*Corner joint for frame PR2986*	4			
CV5403I	Rondella in acciaio inox/epdm	*Stainless steel/vulcanaised 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		
GE2905S	Guarnizione superiore ante	*Gasket for upper sash*	8	LT/4		
GE1305S	Guarnizione perimetrale ante	*Gasket for side sash*	2	2xLT/2+6xHT		
GE1142	Guarnizione labirinto centrale	*Gasket for central labyrinth*	4	HT		
GU1387	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 contractionsof the material over time*						



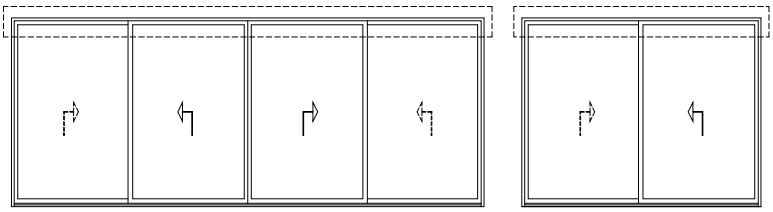




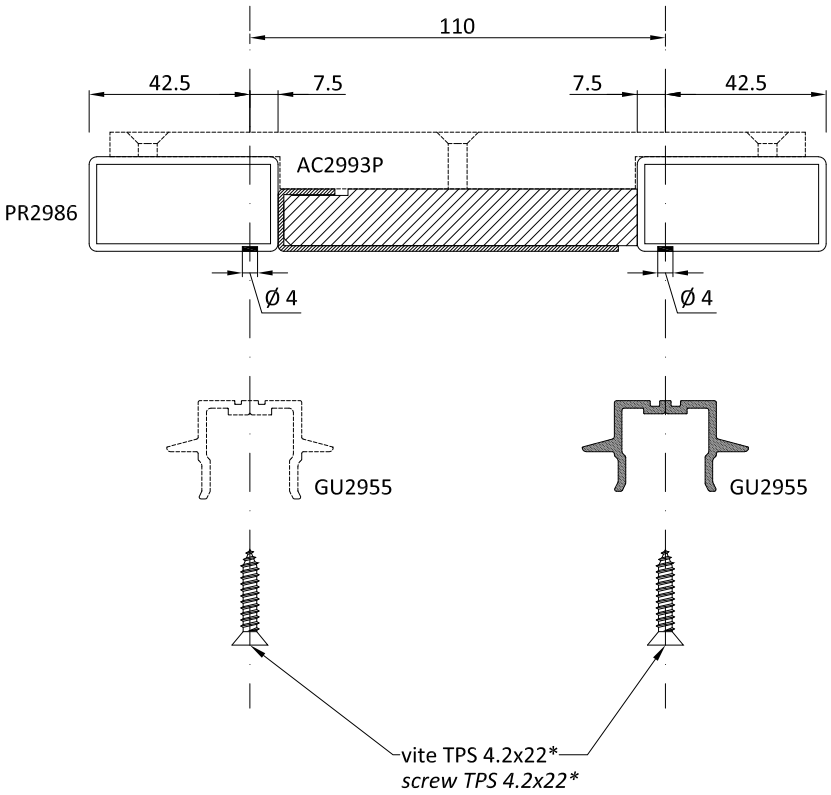


PROFILI *PROFILES*	Componenti *Components*	Descrizione *Description*	n°	Dim.
PR2986	*PR1195/A *PR2986/A	Profilo a "L" *"L" profile*	2	LT
		Profilo a "L" *"L" profile*	2 + 2	HT
	A	Estruso centrale di unione *Central meeting extrusion*	2	LT/2
	A	Estruso centrale di unione *Central meeting extrusion*	2	HT-25
	B	Profilo a C di unione centrale C-profile of central meeting	2	LT/2-2.5
	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'assiemaggio per il fissaggio della guida GU2955
** ATTENTION perforate the profile before assembling to attach the* GU2955 *rail*

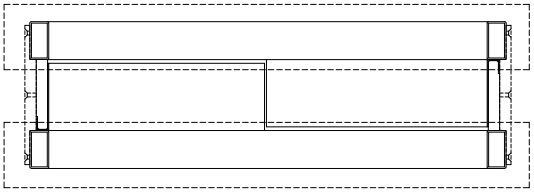


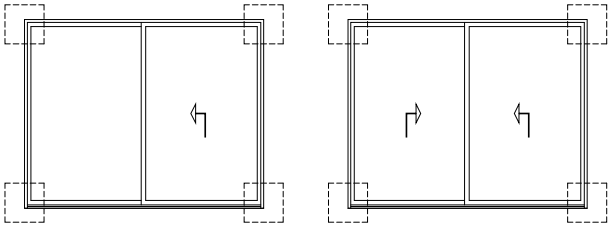
Prima di assemblare il telaio esterno forare Ø 4 mm il profilo superiore per fissaggio guida GU2955
Before assembling the frame make a Ø 4 mm hole in the upper profile to atach the GU2955 rail

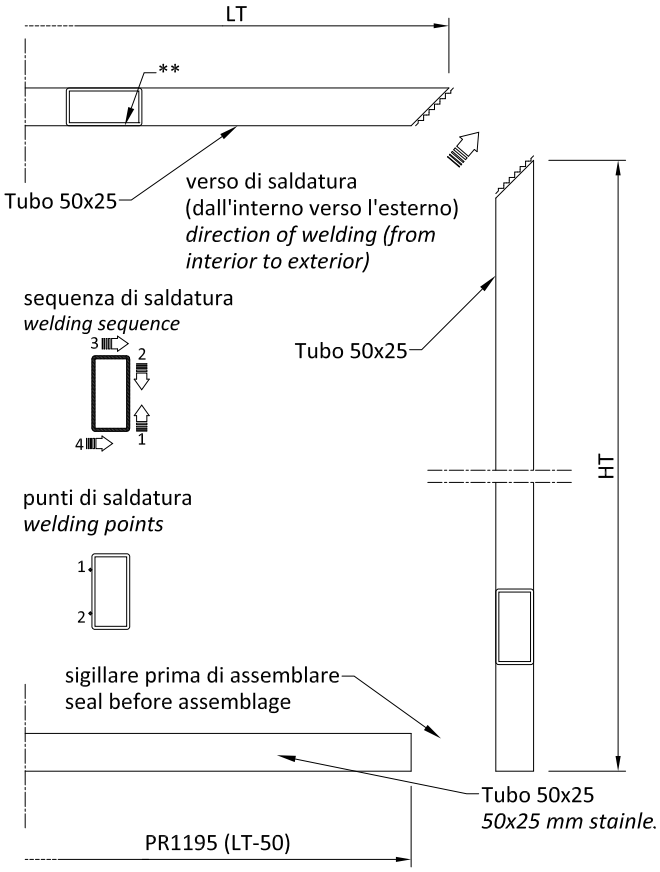


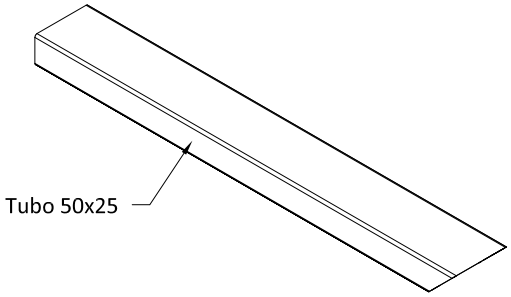
Il passo di foratura viene definito nelle singole schede di applicazione guida GU2955 delle specifiche tipologie realizzabili
The spacing of the drilled holes is described in the individual rail GU2955 application sheets for the specific typologies possible

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

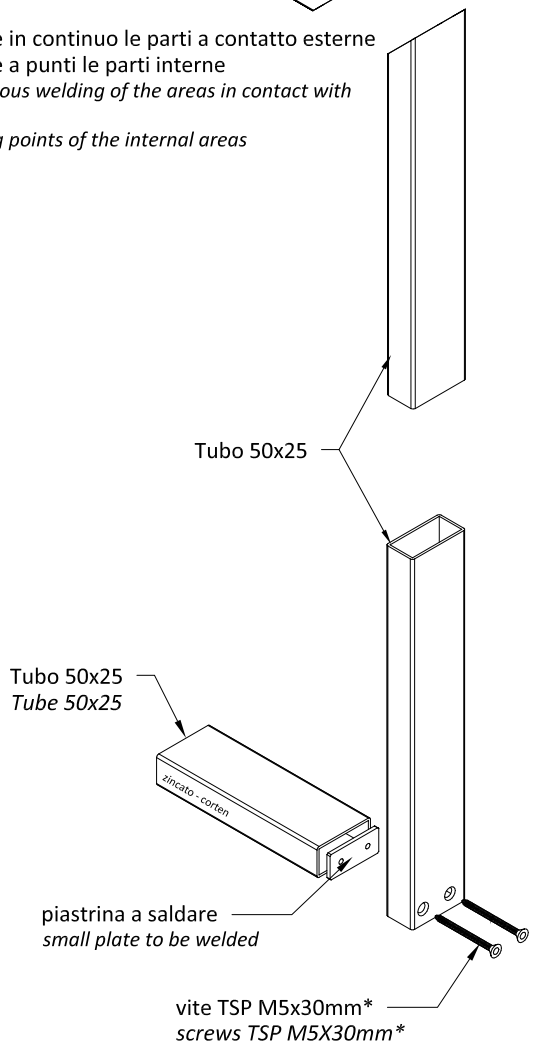


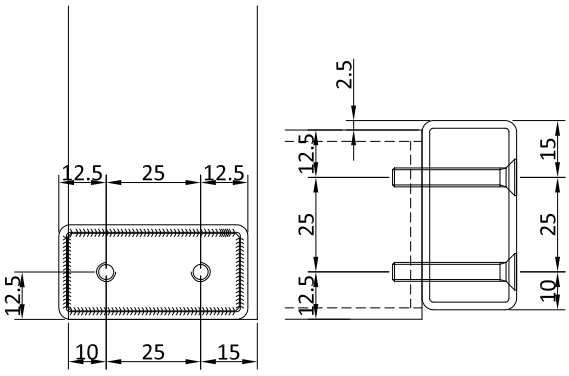




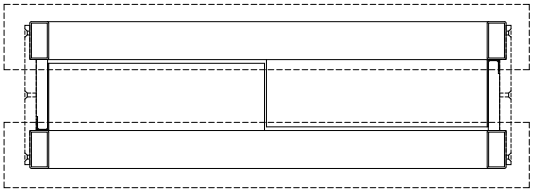


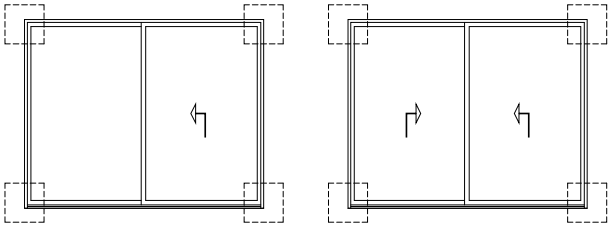
- saldare in continuo le parti a contatto esterne
- saldare a punti le parti interne
- *continuous welding of the areas in contact with exterior*
- *welding points of the internal areas*

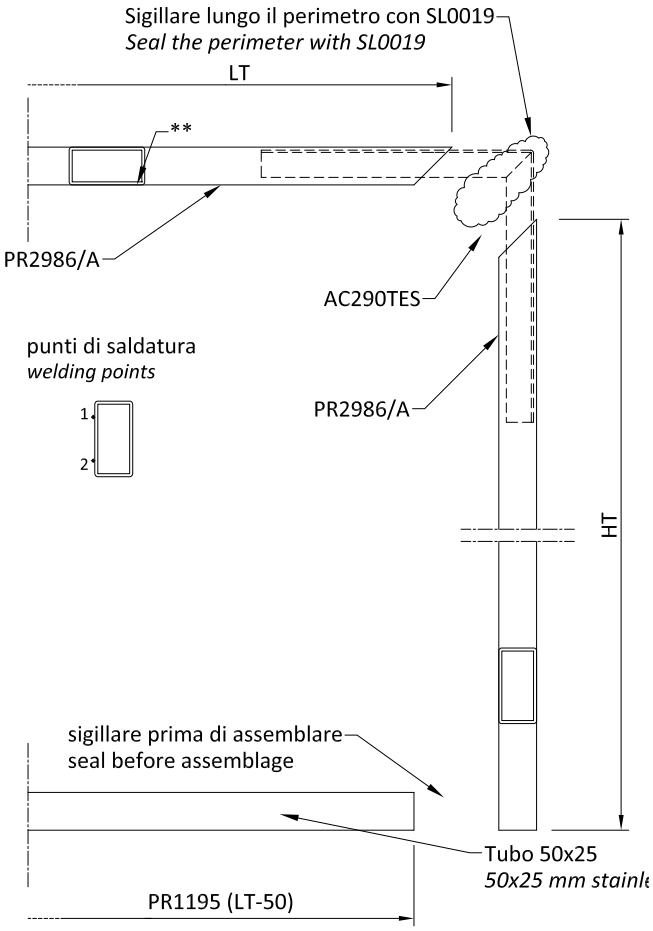


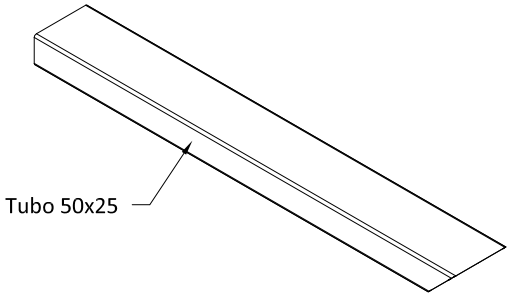


* viti TPS M5x30 non comprese|*screws TPS M5x30 not included*
**ATTENZIONE forare il profilo prima dell'assiemaggio per il fissaggio della guida GU2955
***ATTENTION perforate the profile before assembling to attach the GU2955 rail*

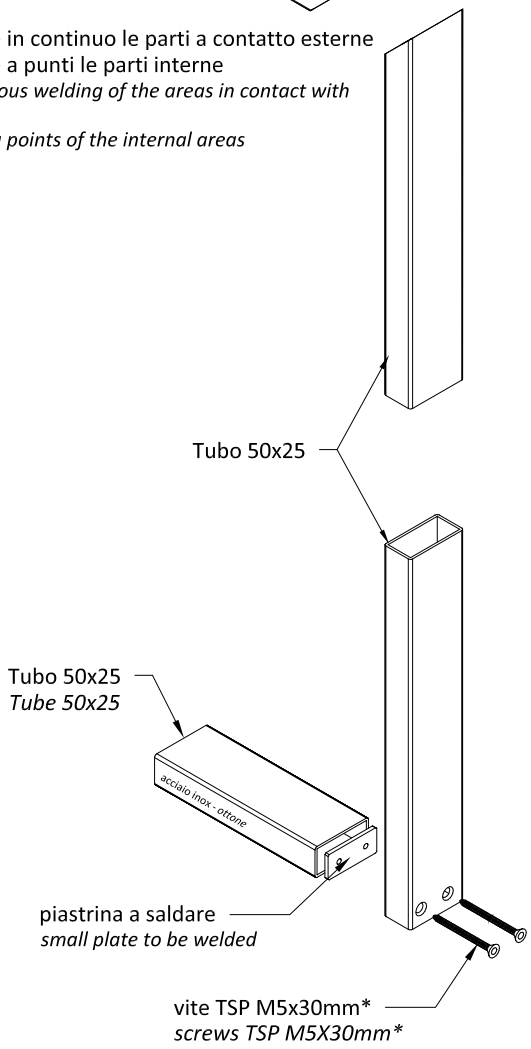


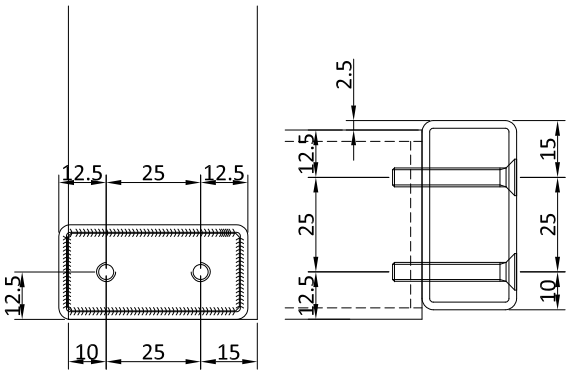




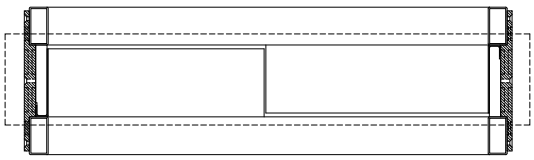


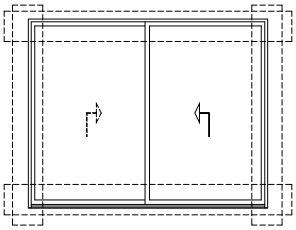
- saldare in continuo le parti a contatto esterne
- saldare a punti le parti interne
- *continuous welding of the areas in contact with exterior*
- *welding points of the internal areas*

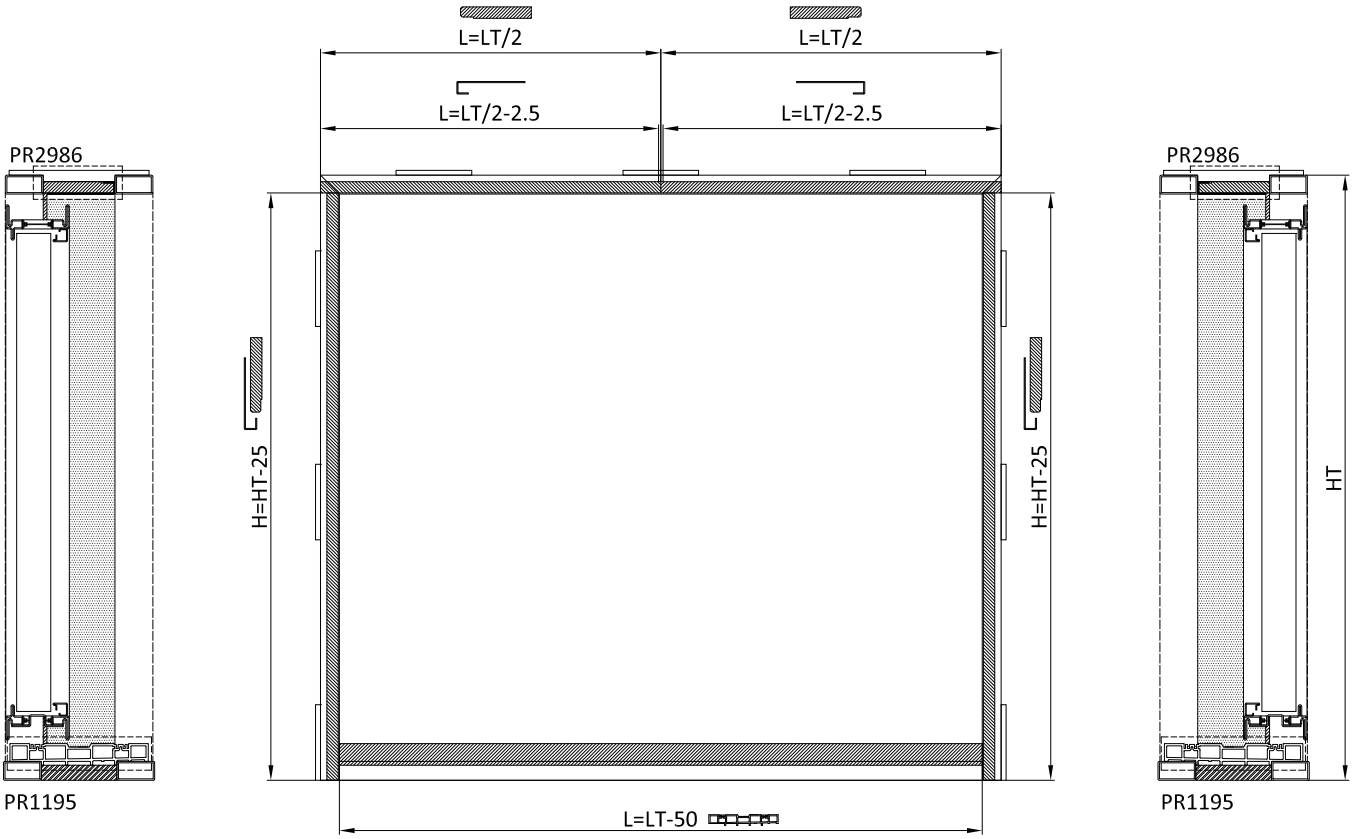




* viti TPS M5x30 non comprese|*screws TPS M5x30 not supplied*
**ATTENZIONE forare il profilo prima dell'assiemaggio per il fissaggio della guida GU2955
***ATTENTION perforate the profile before assembling to attach the GU2955 rail*



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L=LT/2-2.5
L=LT/2-2.5
PR2986
PR2986
H=HT-25
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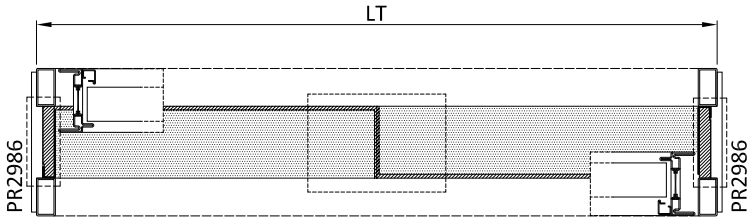
HT
PR1195
PR1195
L=LT-50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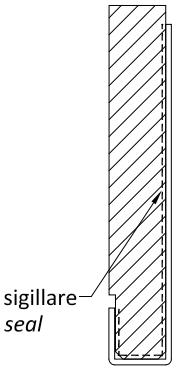
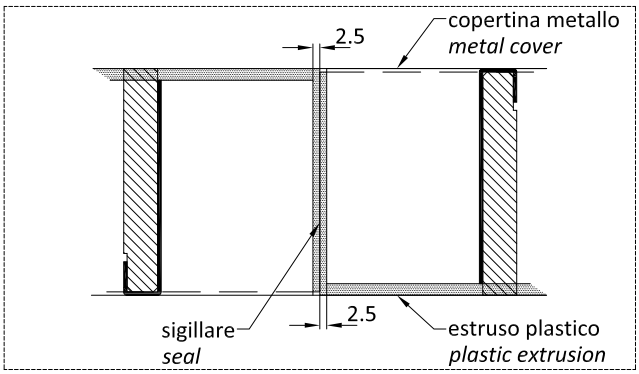
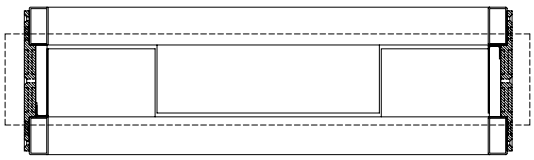
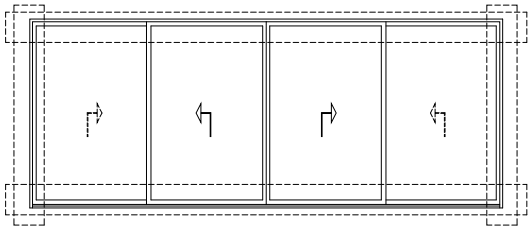
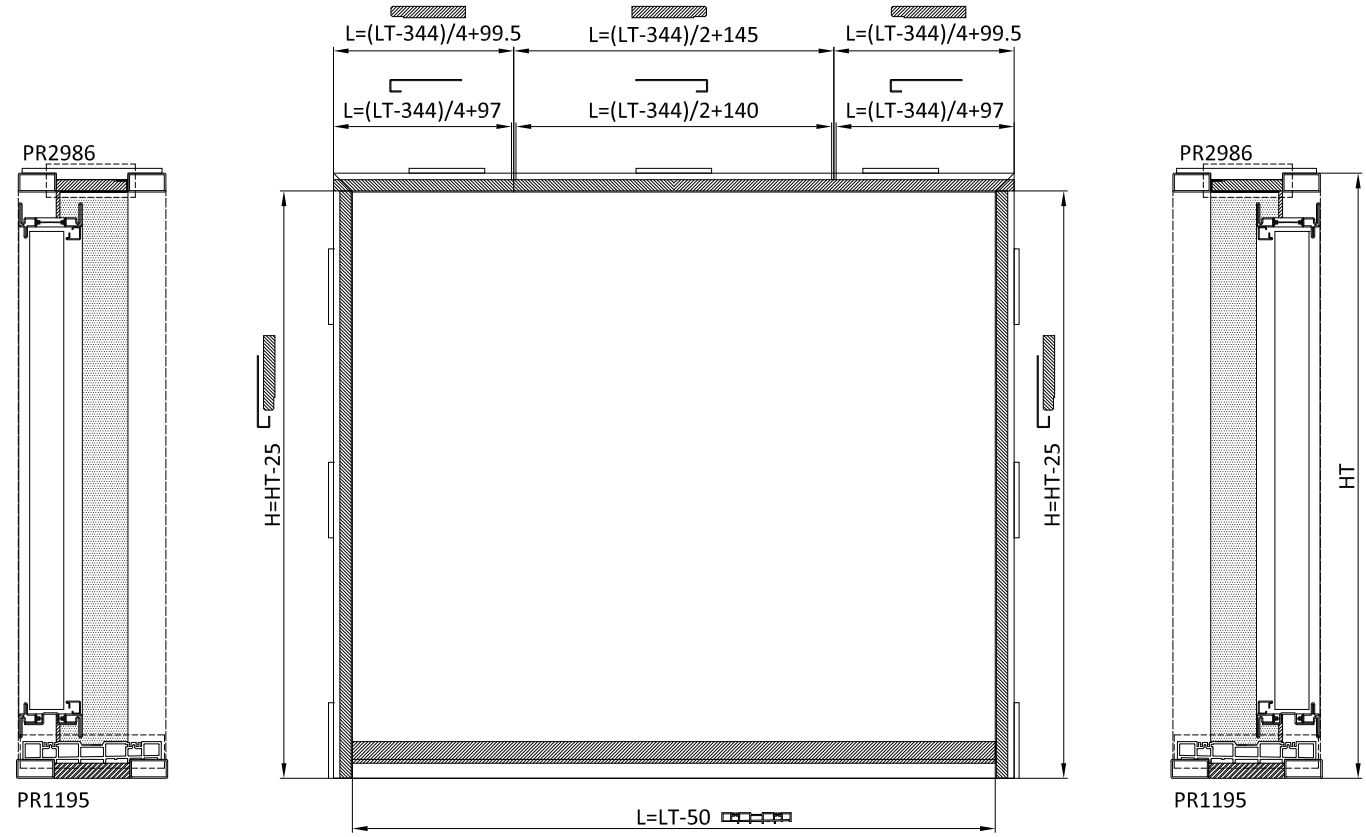
PR2986
PR2986


sigillare
seal


2.5
copertina metallo
metal cover
sigillare
seal
2.5
estruso plastico
plastic extrusion



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L=(LT-344)/4+97
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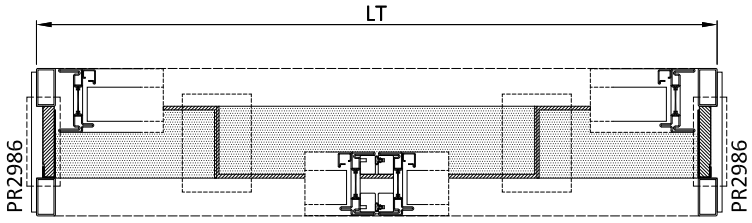
PR2986
PR2986
H=HT-25
H=HT-25
HT
PR1195
PR1195
L=LT-50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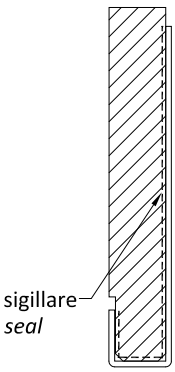
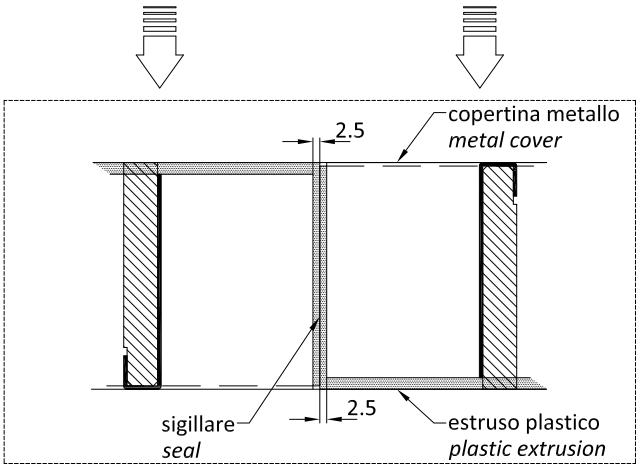
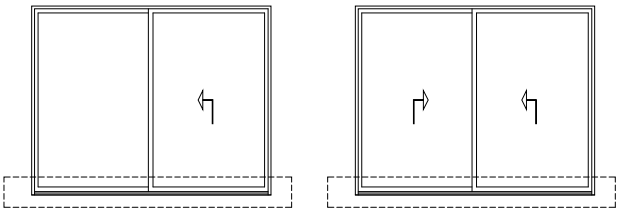
PR2986
PR2986

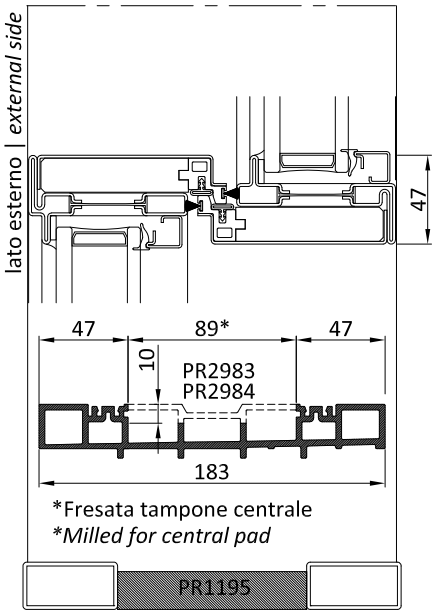

sigillare
seal


2.5
copertina metallo
metal cover
sigillare
seal
2.5
estruso plastico
plastic extrusion

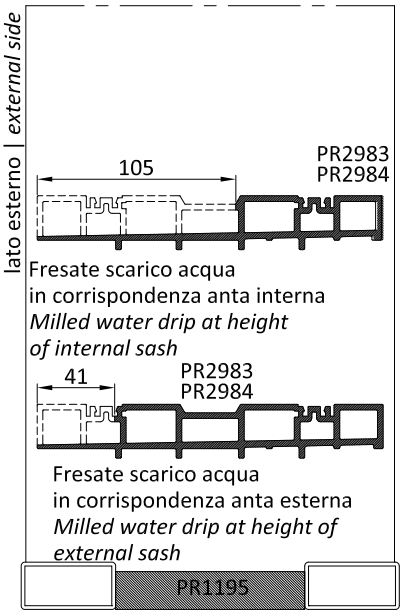
*DA VERIFICARE CON LE DIMENSIONI DELL'ACCESSORIO CONSEGNATO
**TO VERIFY WITH DIMENSIONS OF THE DELIVERED ACCESSORY*



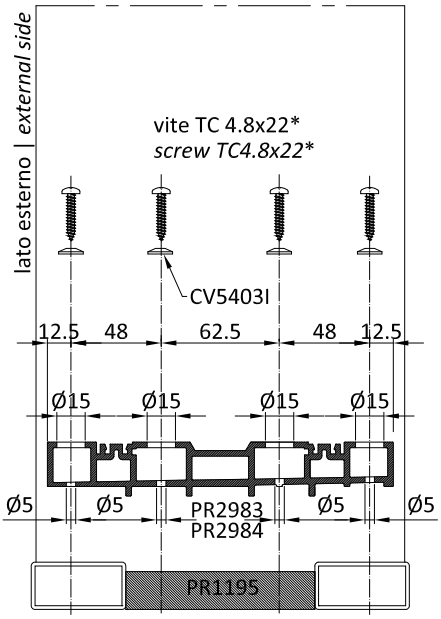
Fresata per tampone
Milled for pad

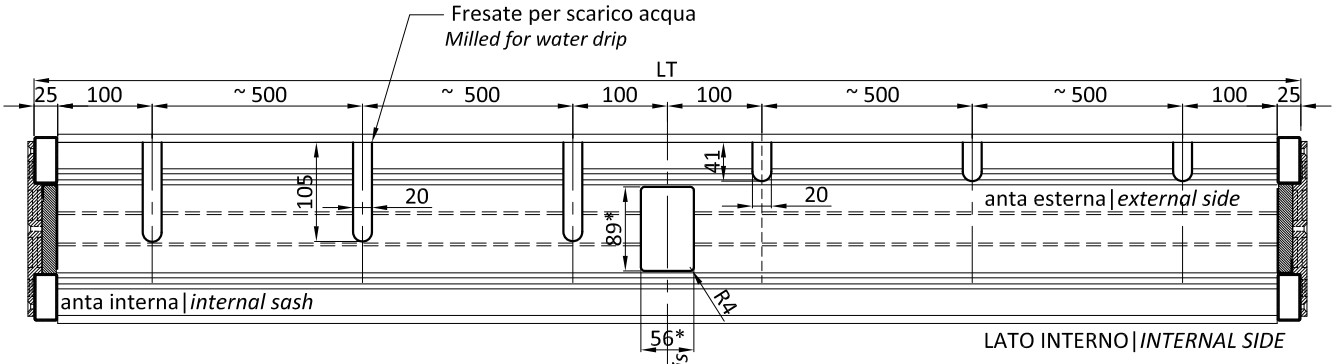


Fresate per scarico acqua
Milled for water drip

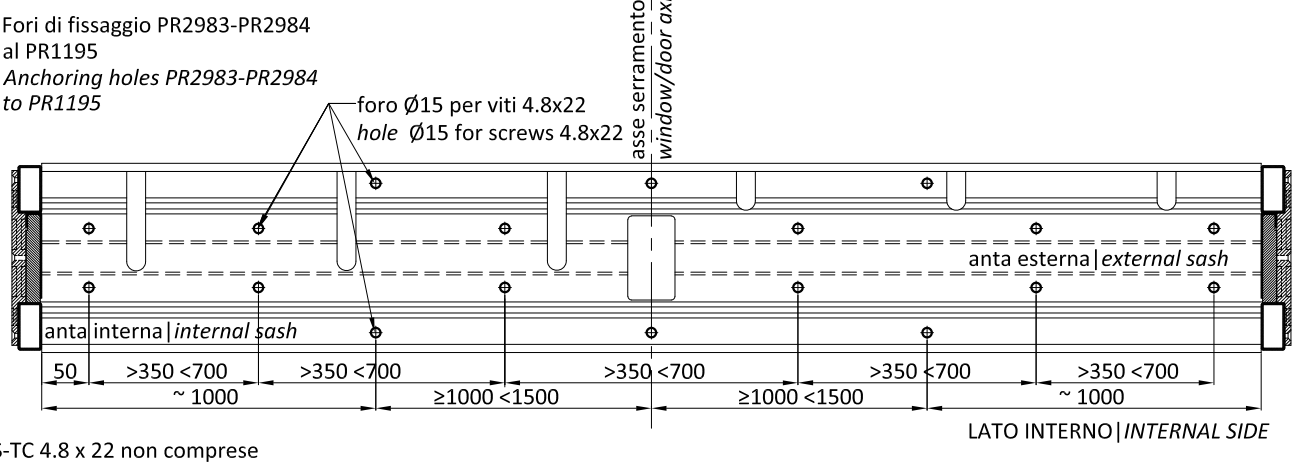


Fori di fissaggio
Anchoring holes



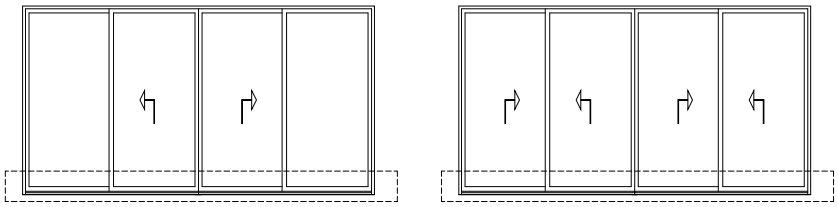


Fori di fissaggio PR2983-PR2984
al PR1195
Anchoring holes PR2983-PR2984
to PR1195

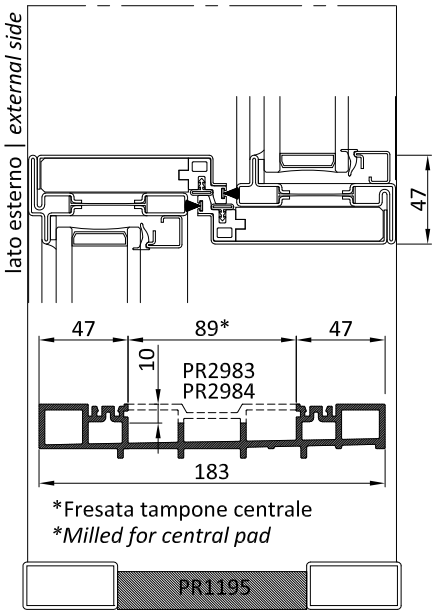


* viti TPS-TC 4.8 x 22 non comprese
*screws TPS-TC 4.8x22 not supplied

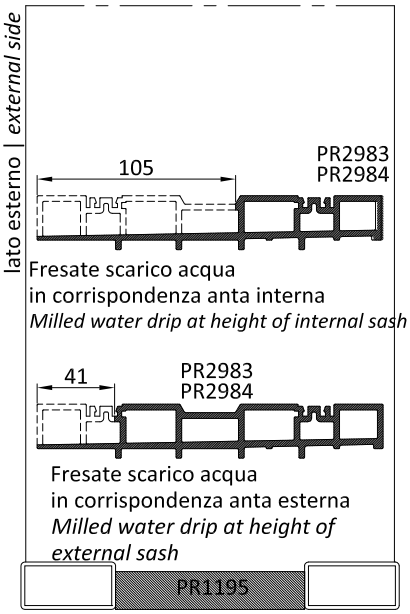
*DA VERIFICARE CON LE DIMENSIONI DELL'ACCESSORIO CONSEGNATO
**TO VERIFY WITH DIMENSIONS OF THE DELIVERED ACCESSORY*



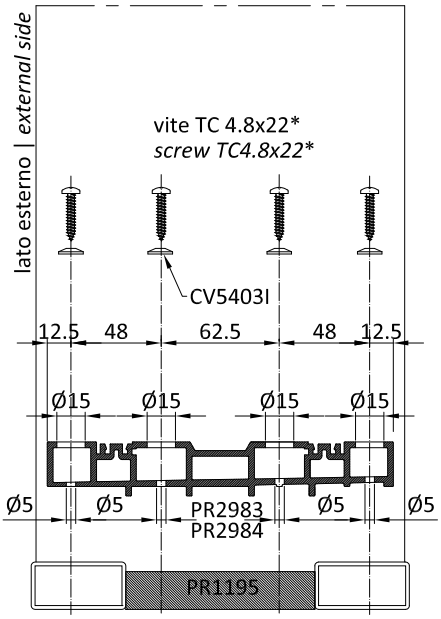
Fresata per tampone
Milled for pad

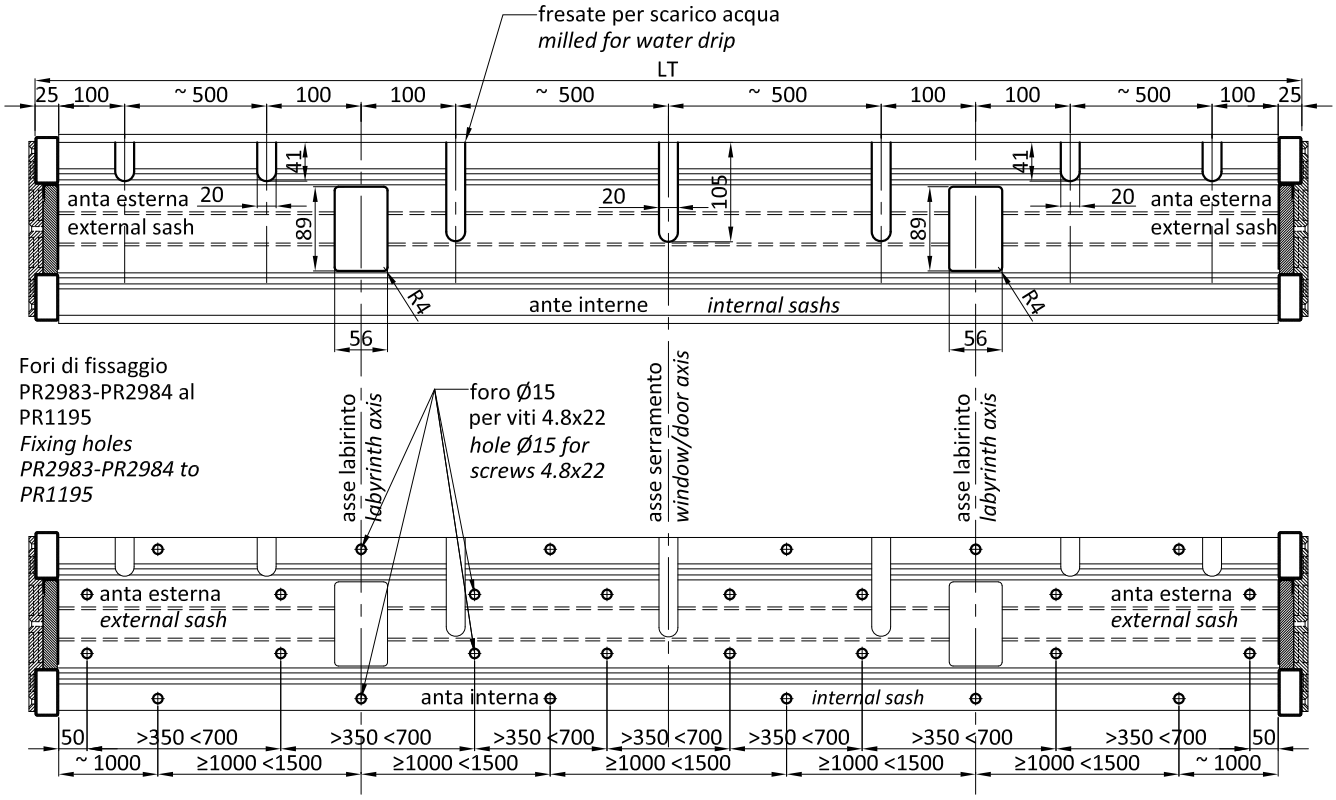


Fresate per scarico acqua
Milled for water drip

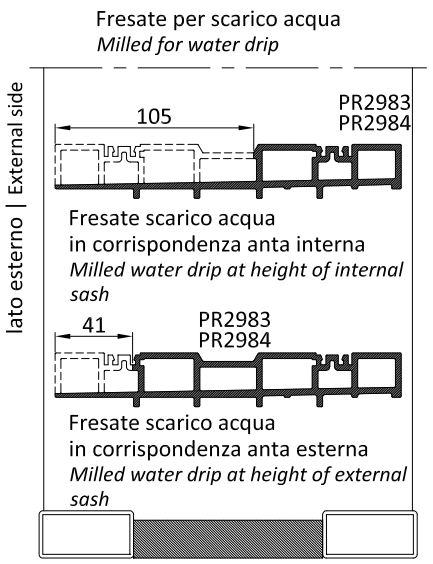


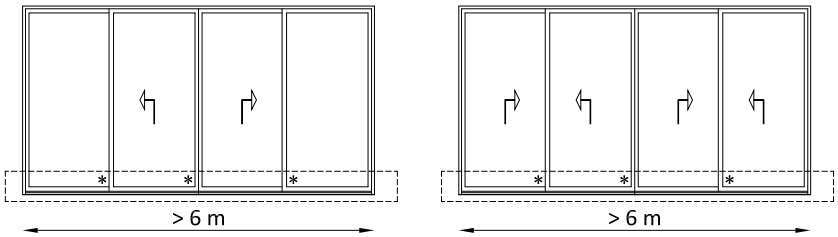
Fori di fissaggio
Anchoring holes

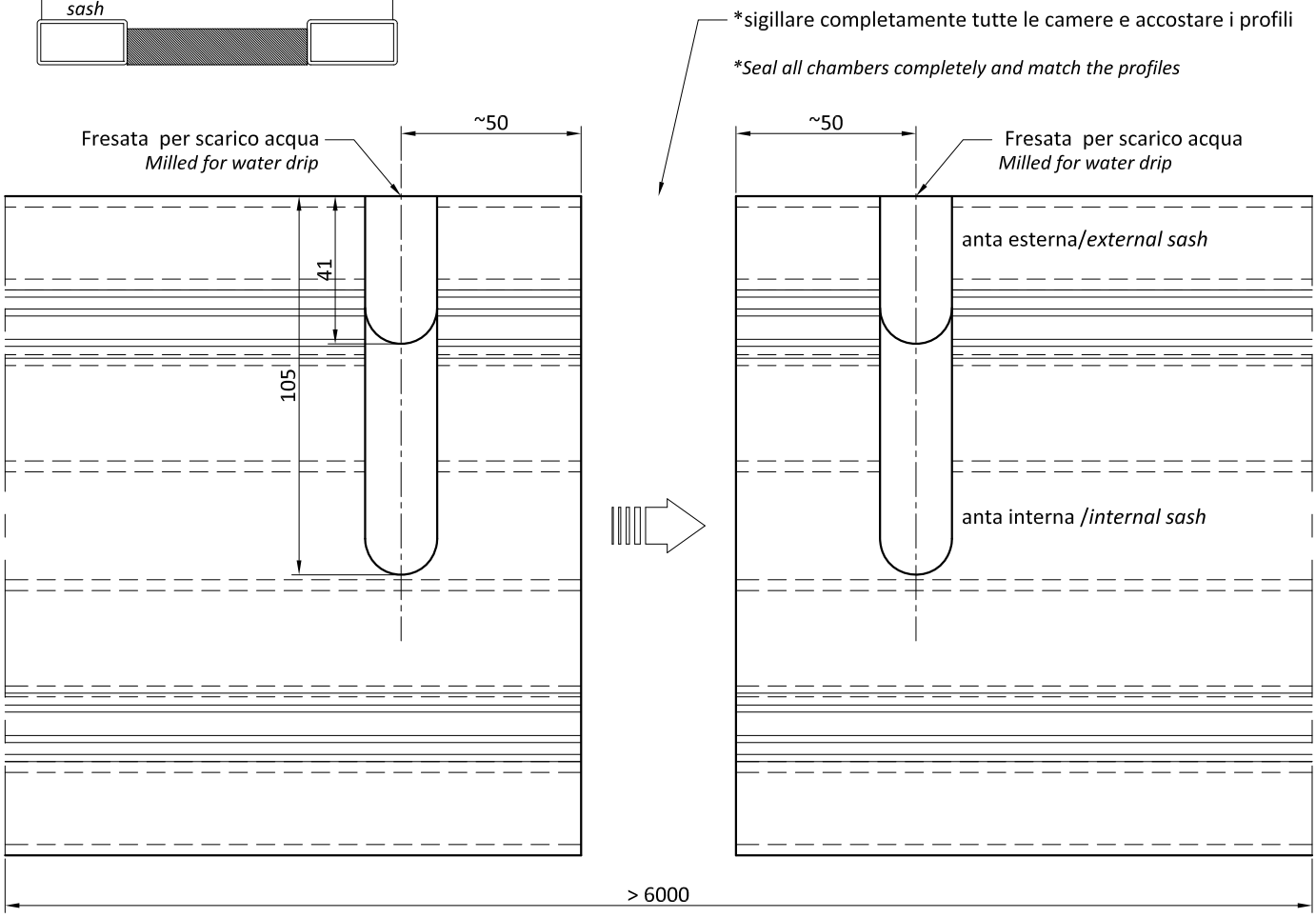


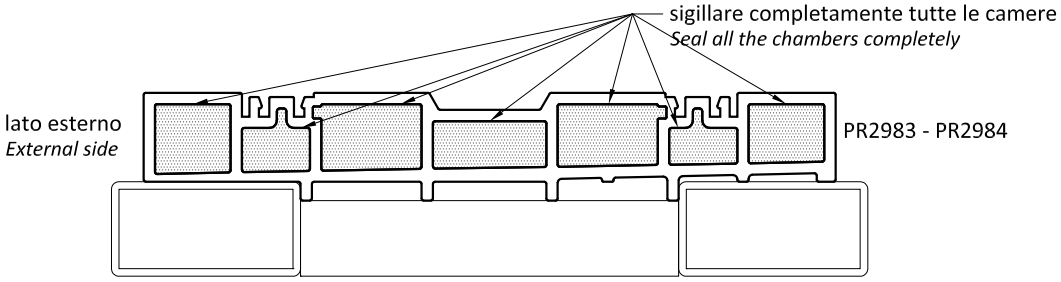


* viti TPS-TC 4.8x22 non comprese
** screws TPS-TC 4.8x22 not supplied*



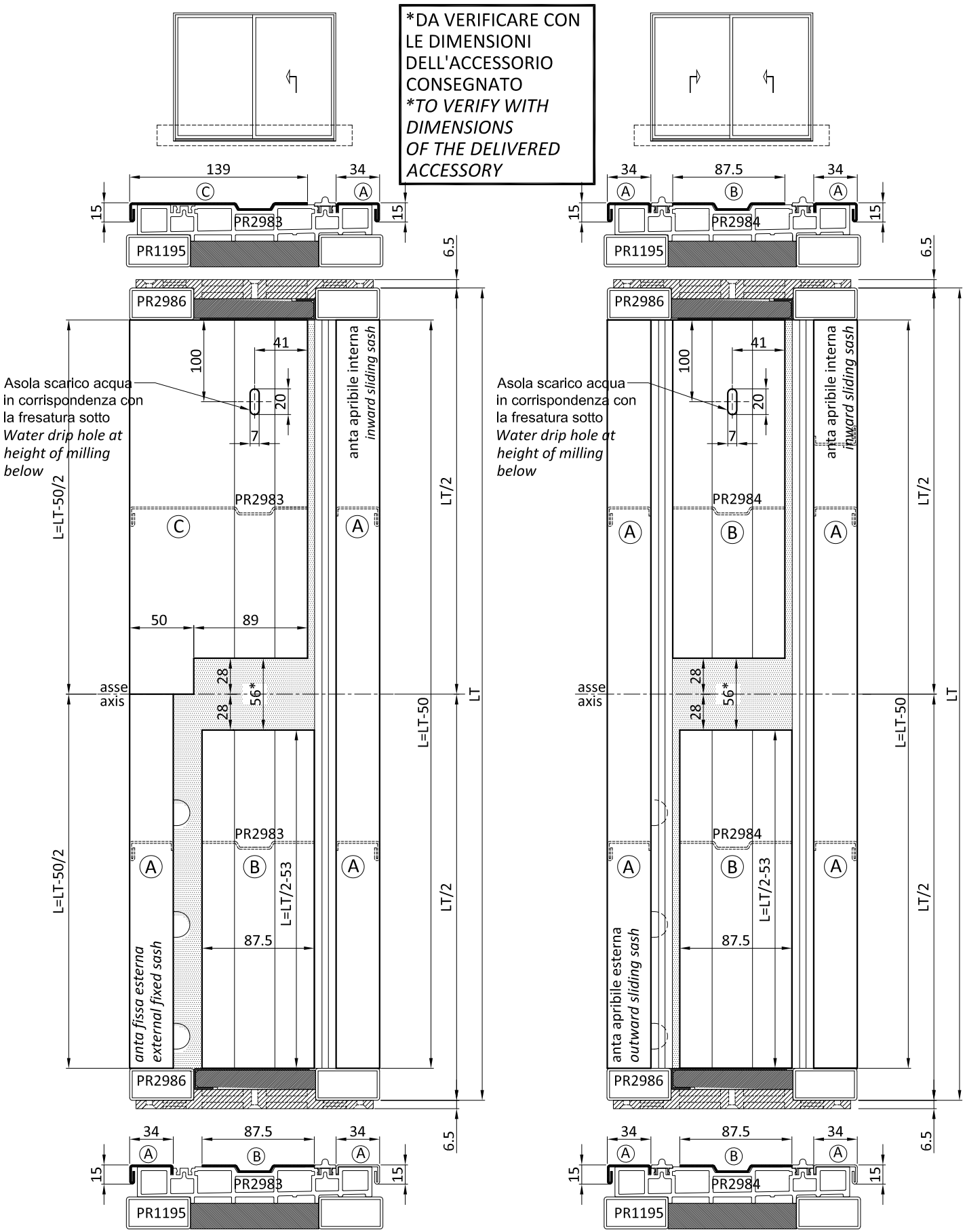




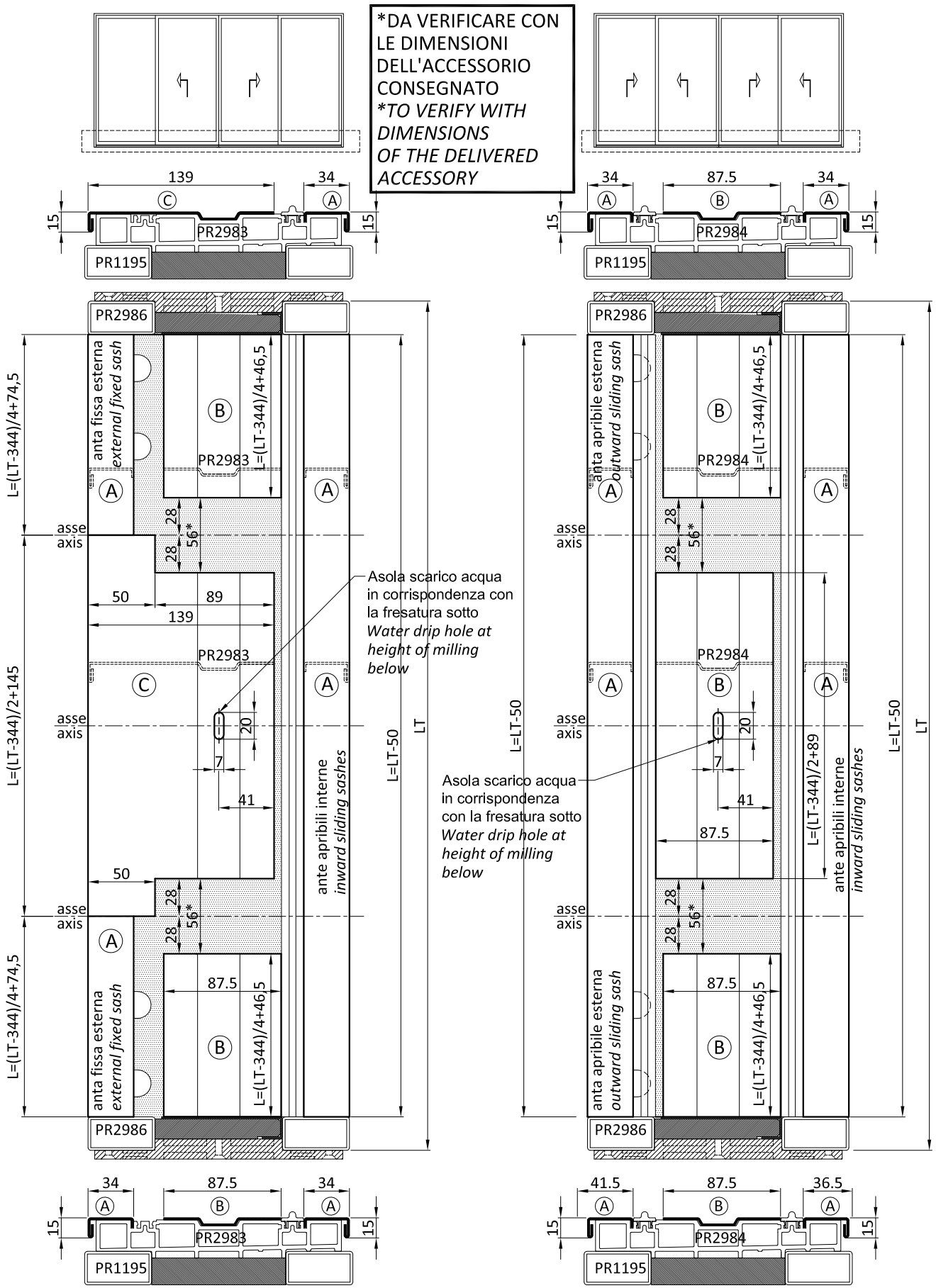


* VIETATA la giunzione in asse del labirinto dove viene eseguita la fresatura per il tampone ed in asse centrale del serramento dove si incontrano le due ante interne ed è realizzato lo scarico acqua centrale

**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
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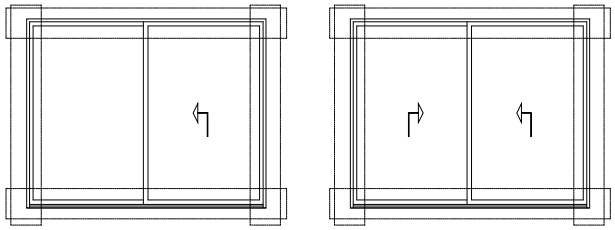
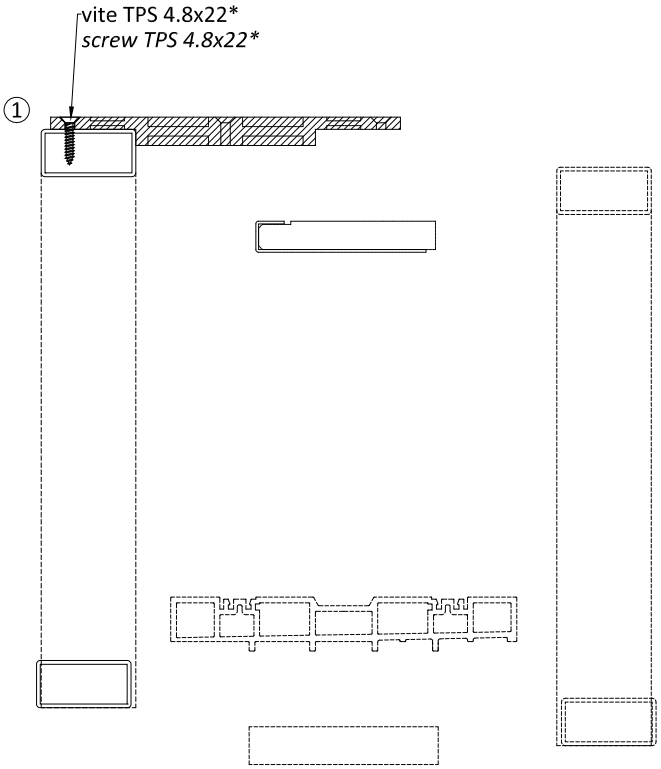
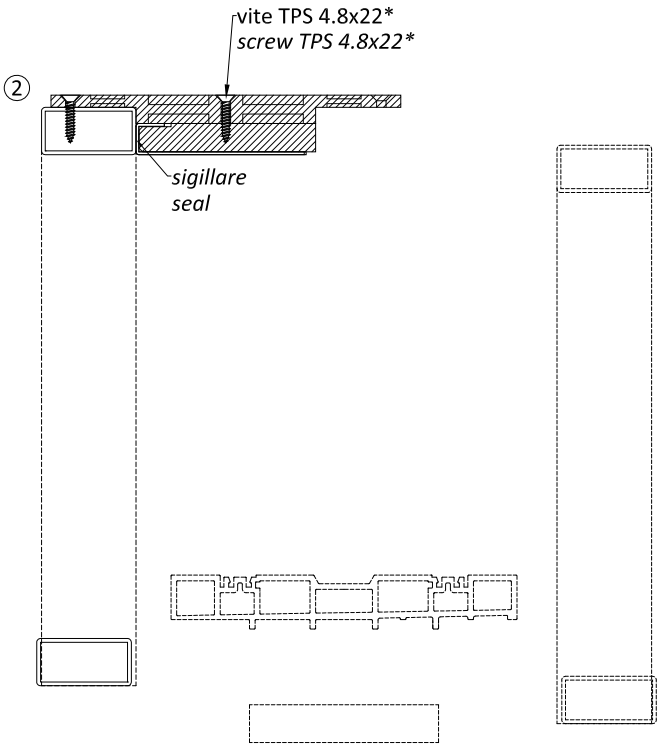
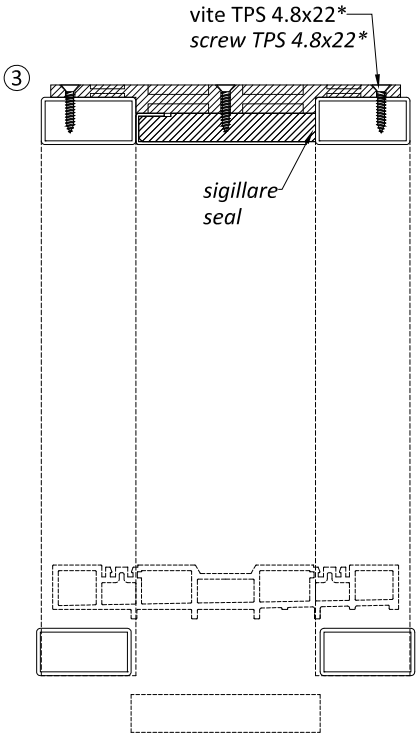
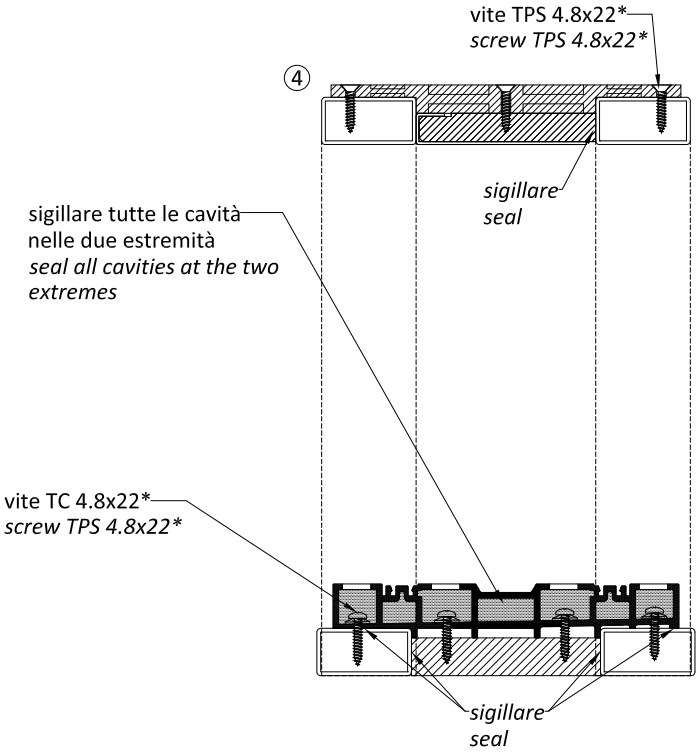
Internal cover A must be put in place once the window/door has been attached on the ground



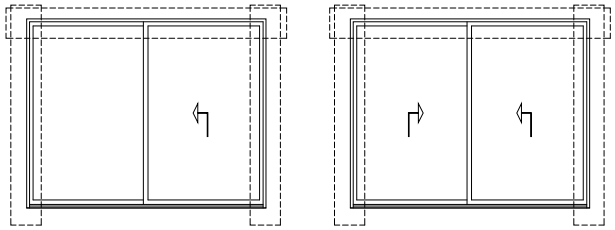


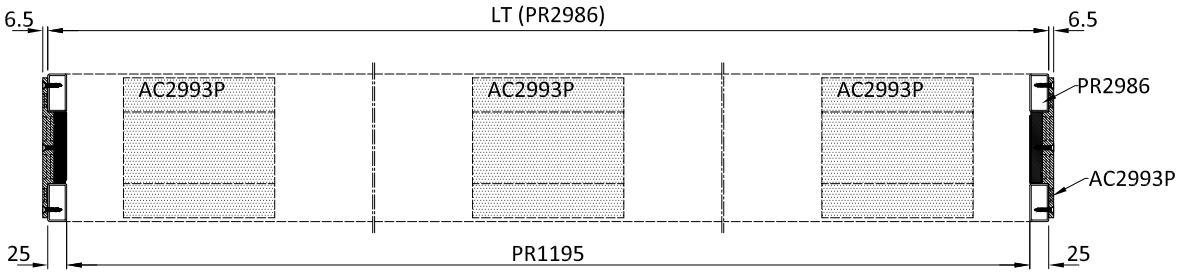


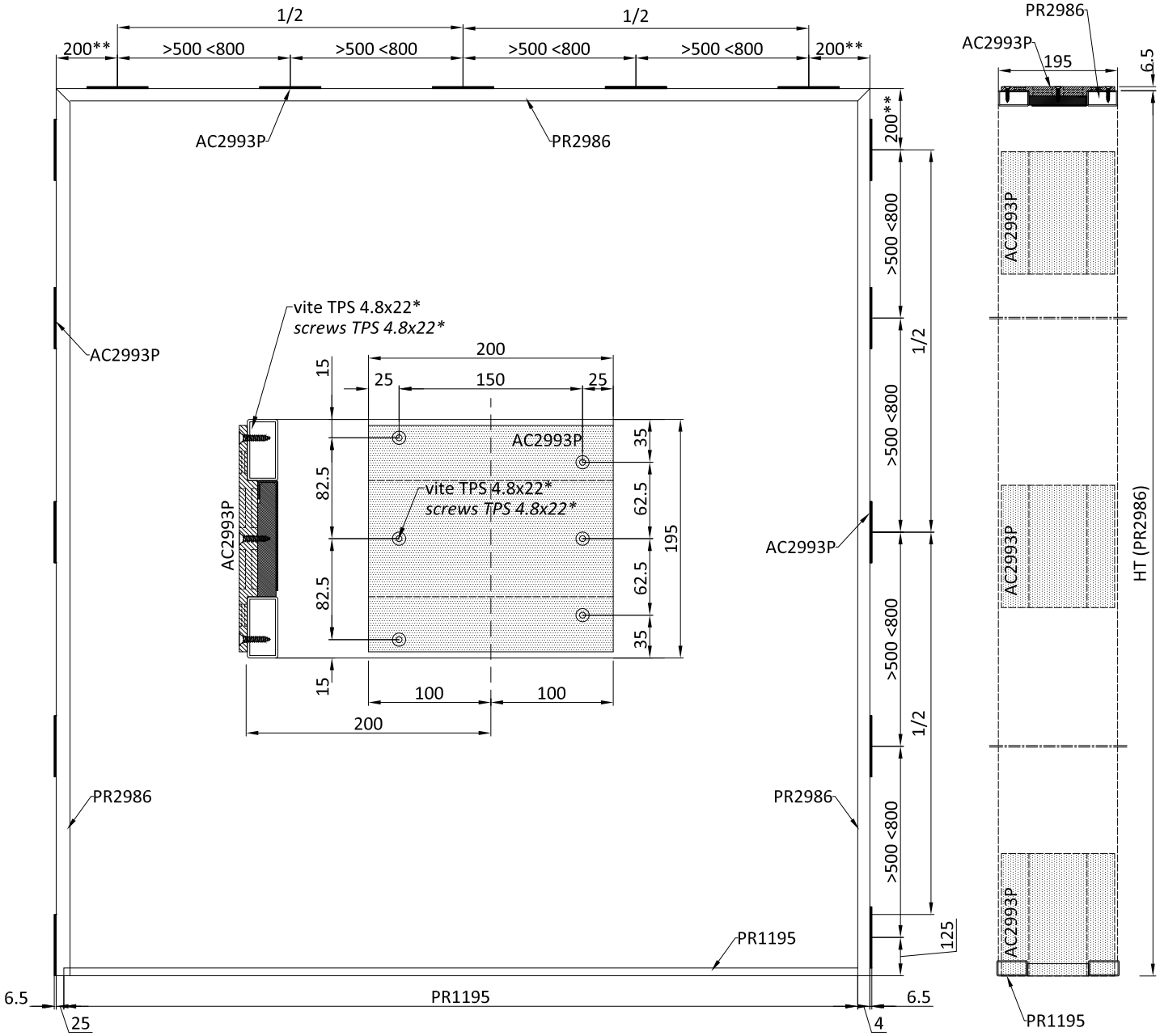




* viti TPS-TC 4.8x22 non comprese
* *screws TPS-TC 4.8x22 not supplied*

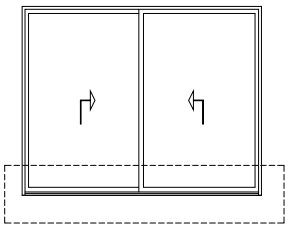


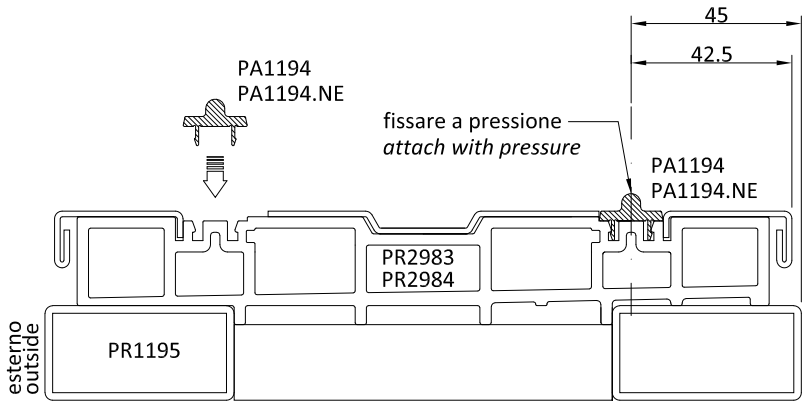


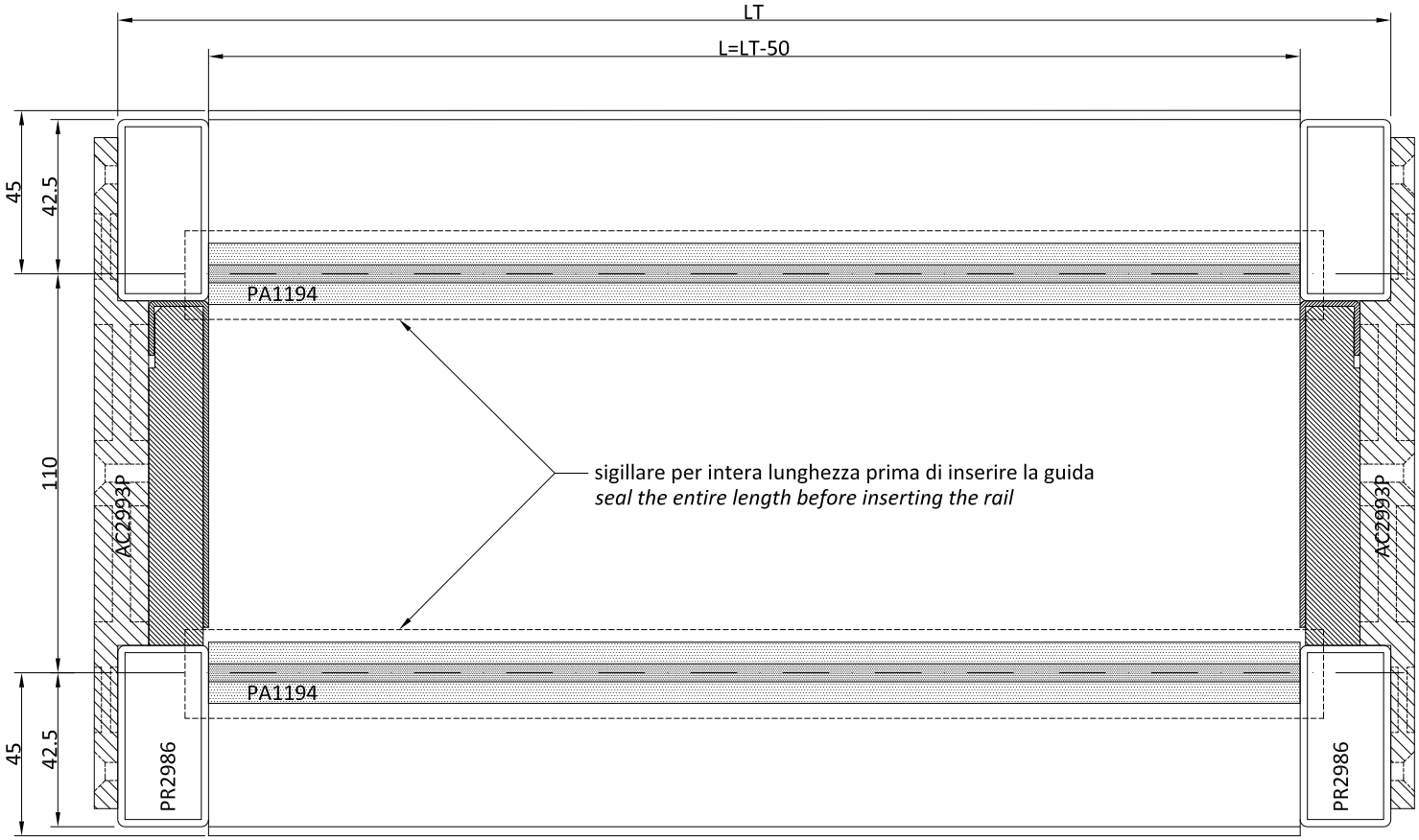


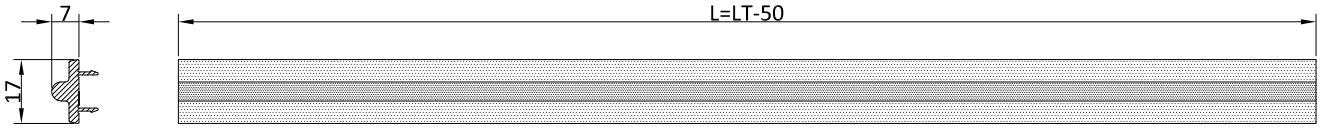
* viti TPS-TC 4.8x22 non comprese|*screws TPS-TC 4.8x22 not supplied*
**con squadretta AC290TES|*with bracket AC290TES* - 200→300 mm

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

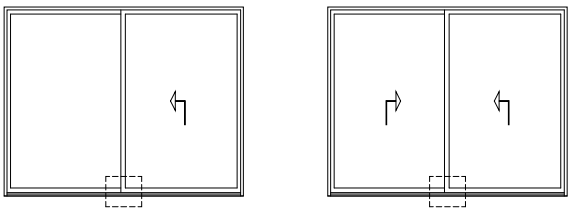


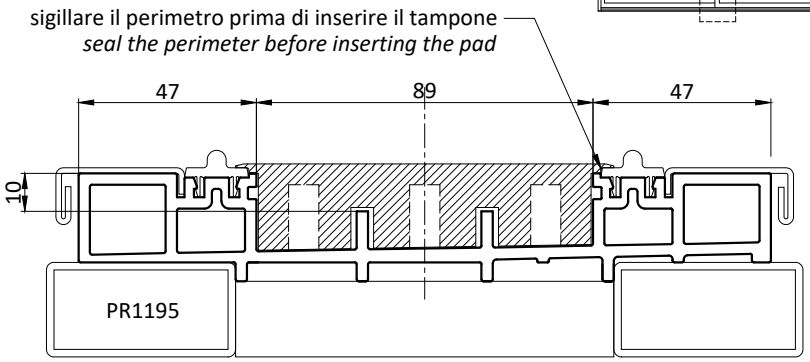


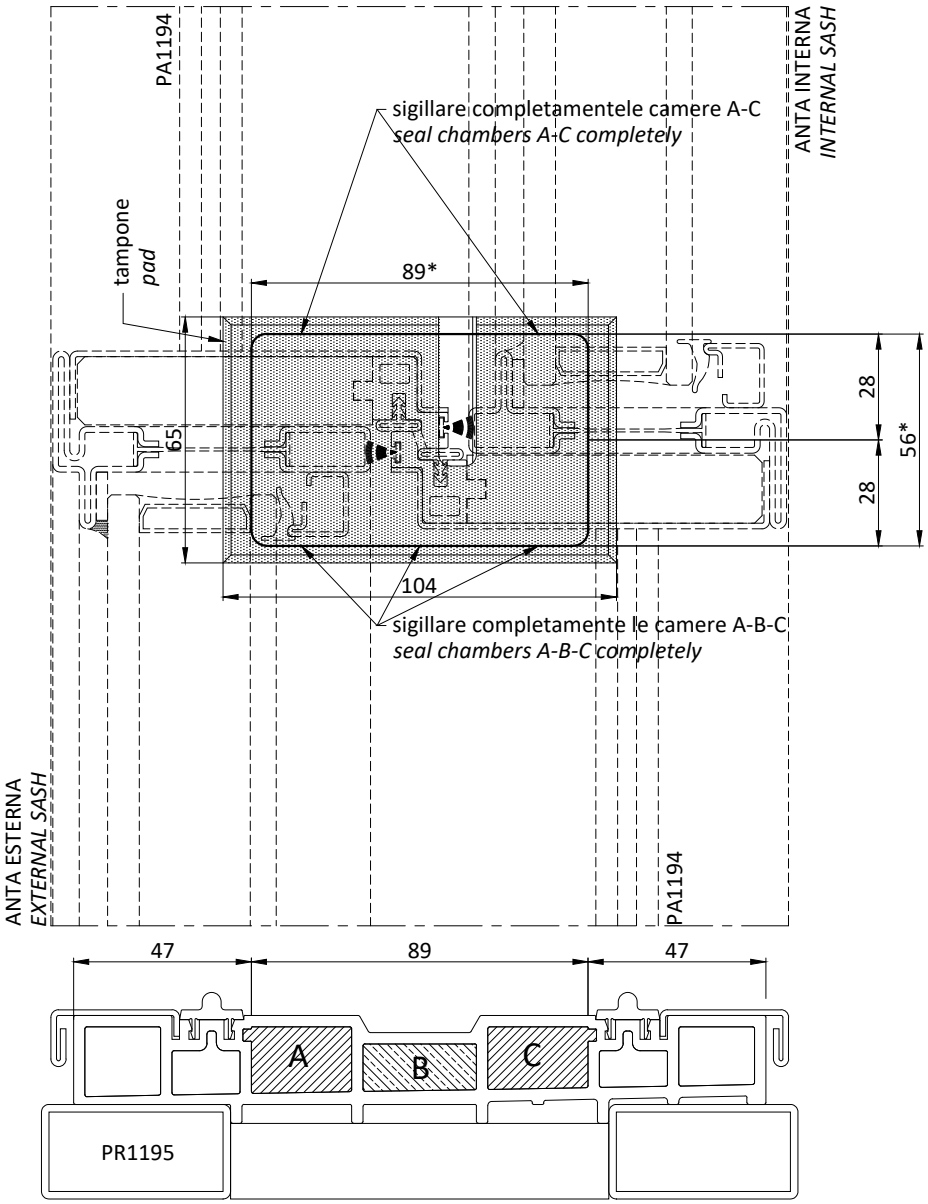


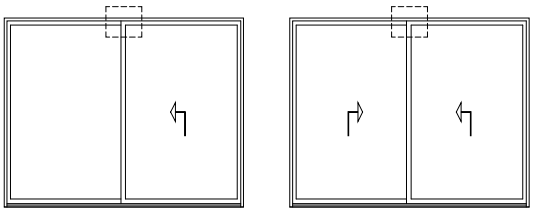


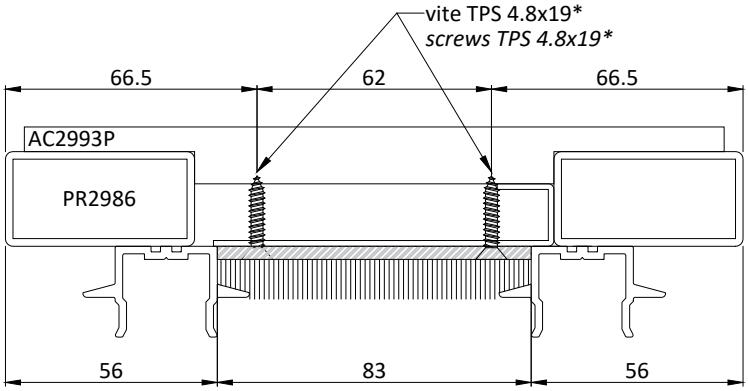
*DA VERIFICARE CON LE DIMENSIONI DELL'ACCESSORIO CONSEGNATO
**TO VERIFY WITH DIMENSIONS OF THE DELIVERED ACCESSORY*

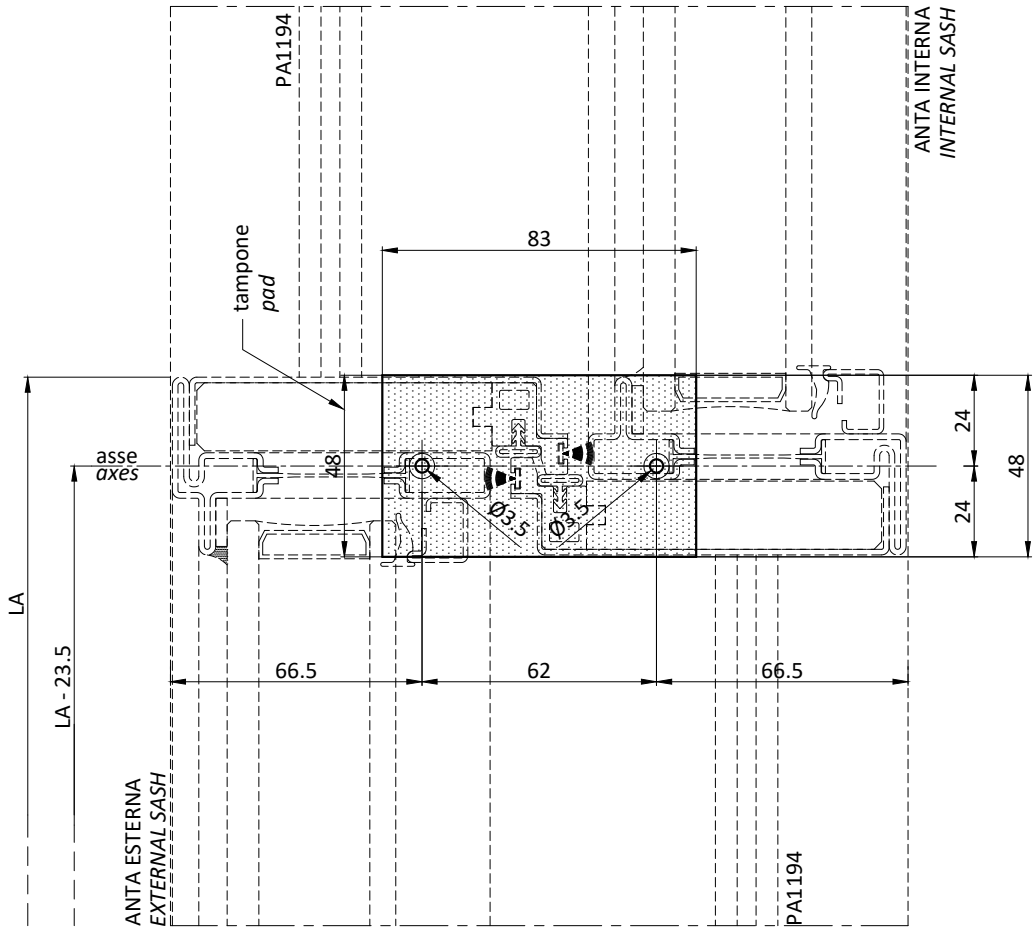








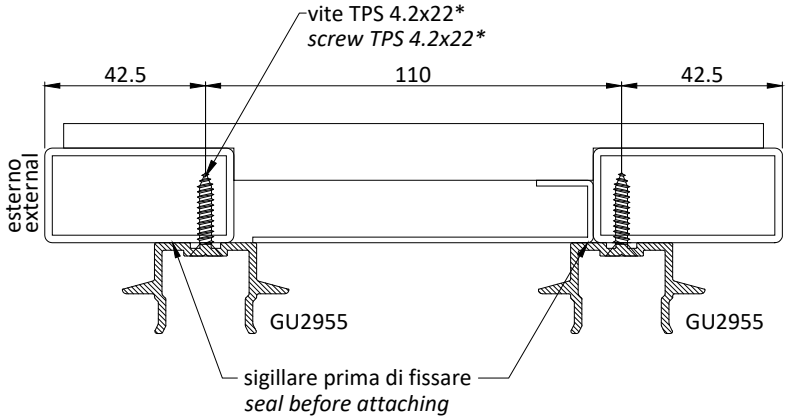


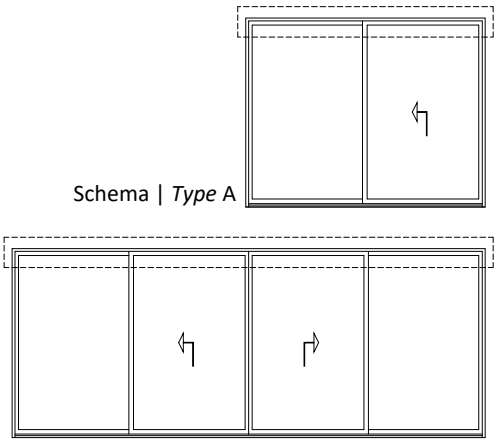


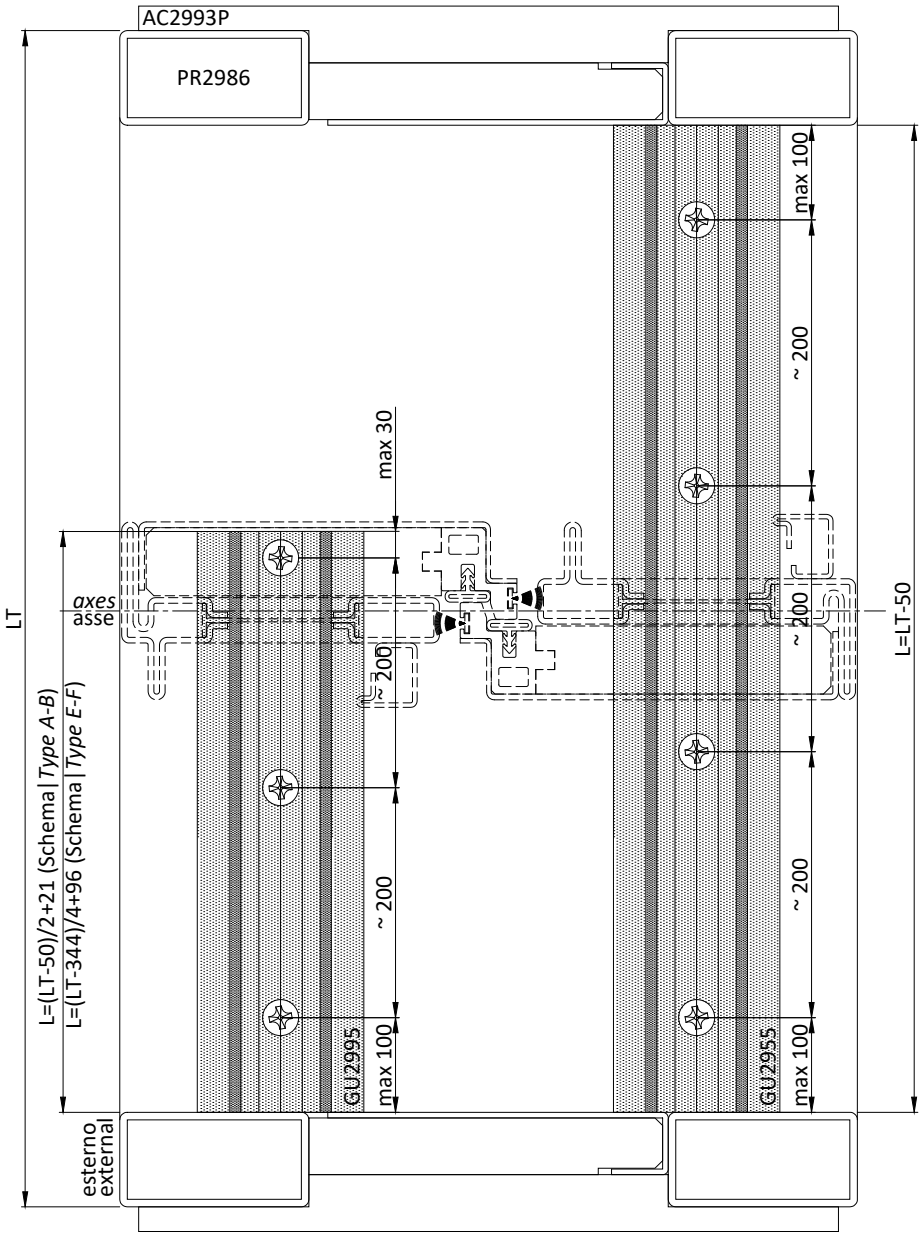
* viti TPS 4.2 x 19 non comprese
** screws TPS 4.2 x 19 not supplied*

NOTE:
- Inserire e fissare la prima guida con la rispettiva anta
- Inserire e fissare il tampone
- 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

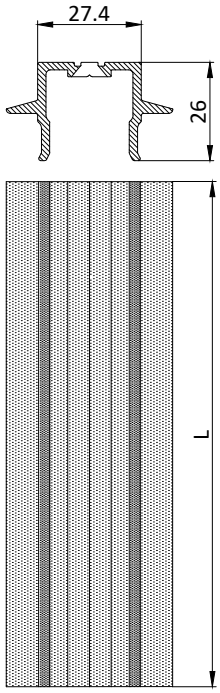






NOTE :
- Preforare il telaio PR2986 prima dell'assemblaggio
- Montare la guida assieme alla posa dell'anta

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

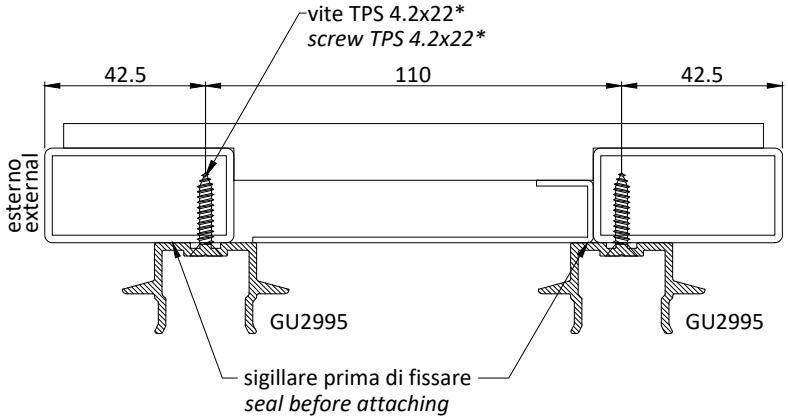


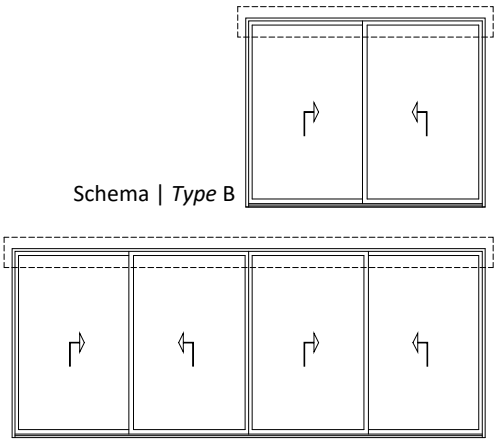
GU2955

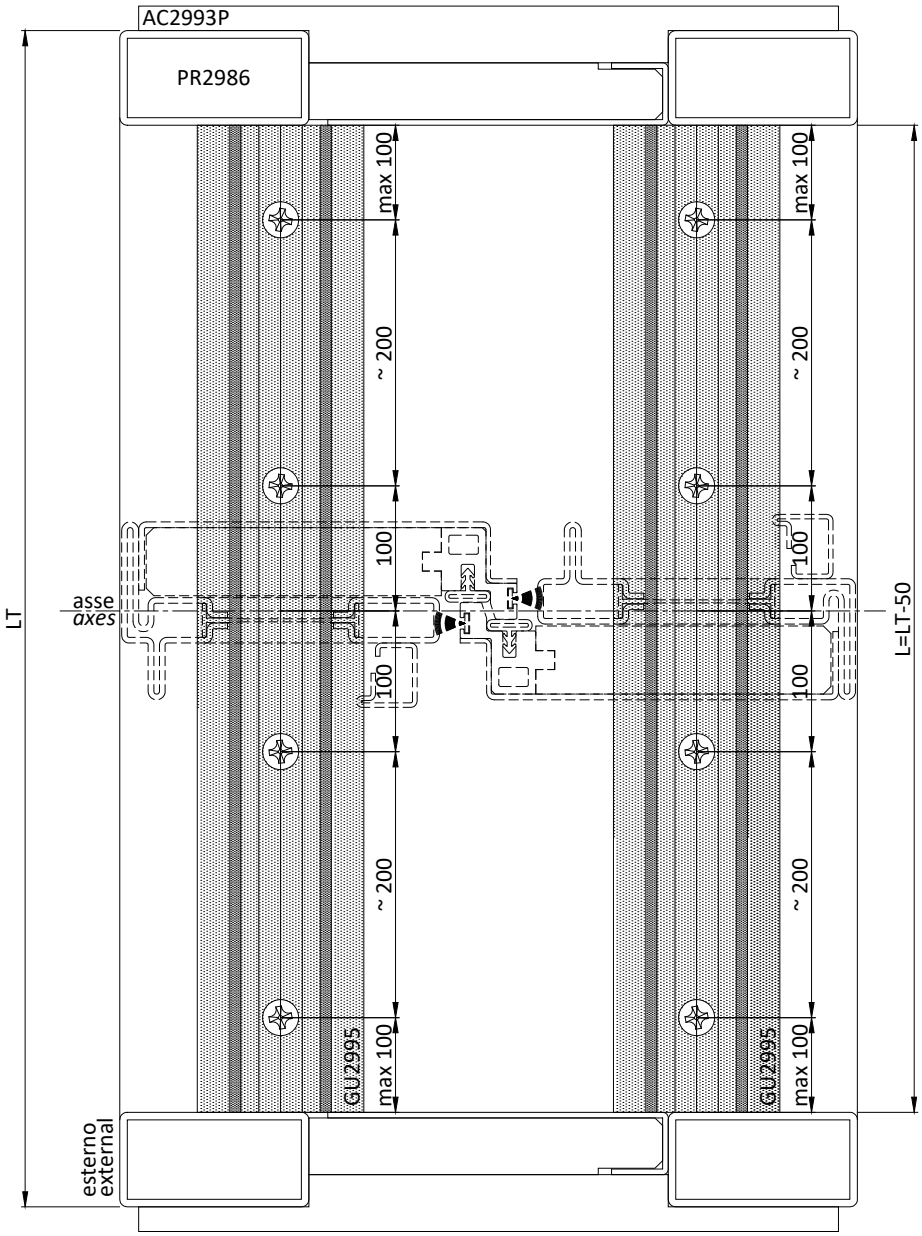
Schema A ed E
lunghezza guida GU2955 interna
L=LT-50
lunghezza guida GU2955 esterna
L=LT/2-4 (2 pz.)

Type A and E
lenght internal rail GU2955
L=LT-50
lenght external rail GU2955
L=LT/2-4 (2 pc.)

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



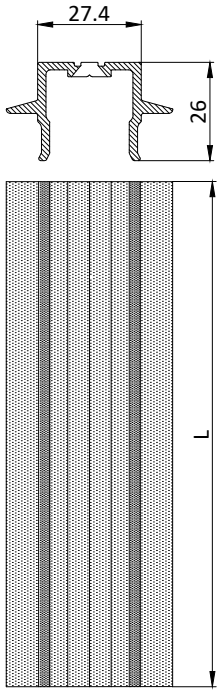




NOTE :
- Preforare il telaio PR2986 prima dell'assemblaggio
- Montare la guida assieme alla posa dell'anta

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

GU2995

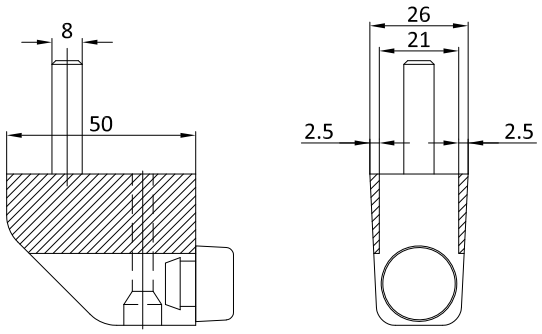


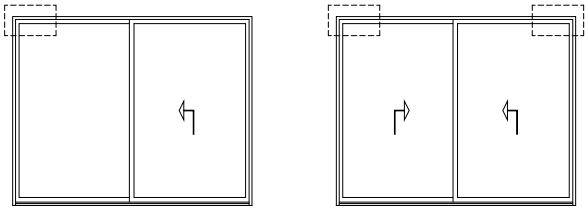
GU2955

Schema B ed F
lunghezza guida GU2955 interna ed esterna
L=LT-50

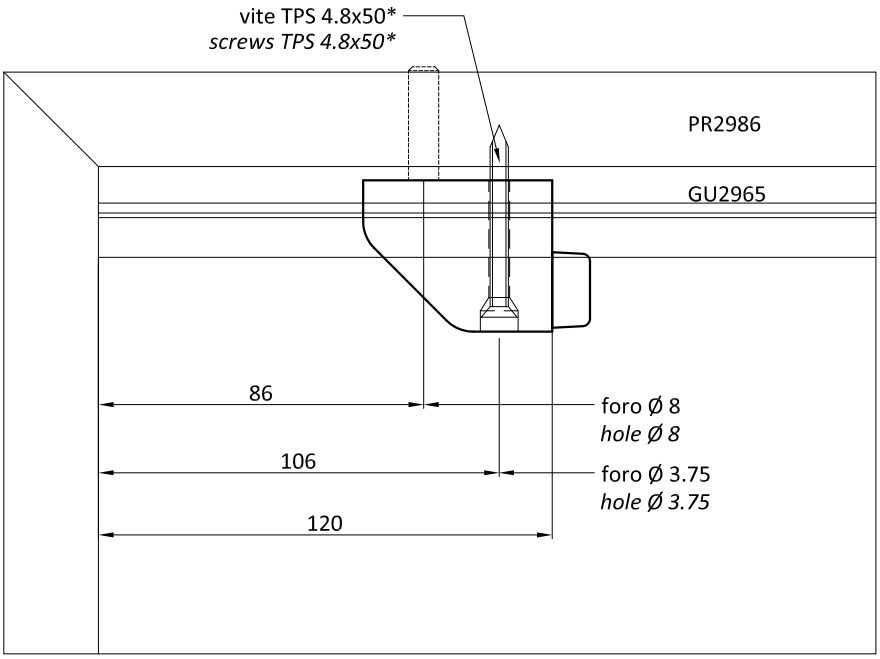
Type B and F
lenght internal and external rail GU2955
L=LT-50

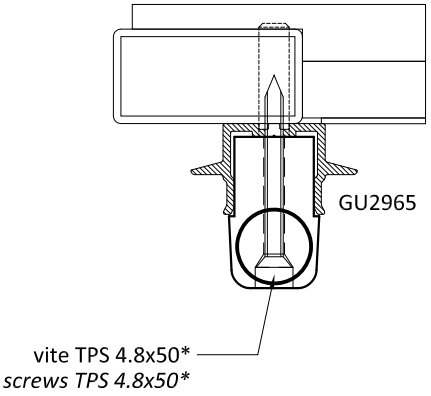
* viti TPS 4.2x22 non comprese
** screws TPS 4.2x22 not supplied*

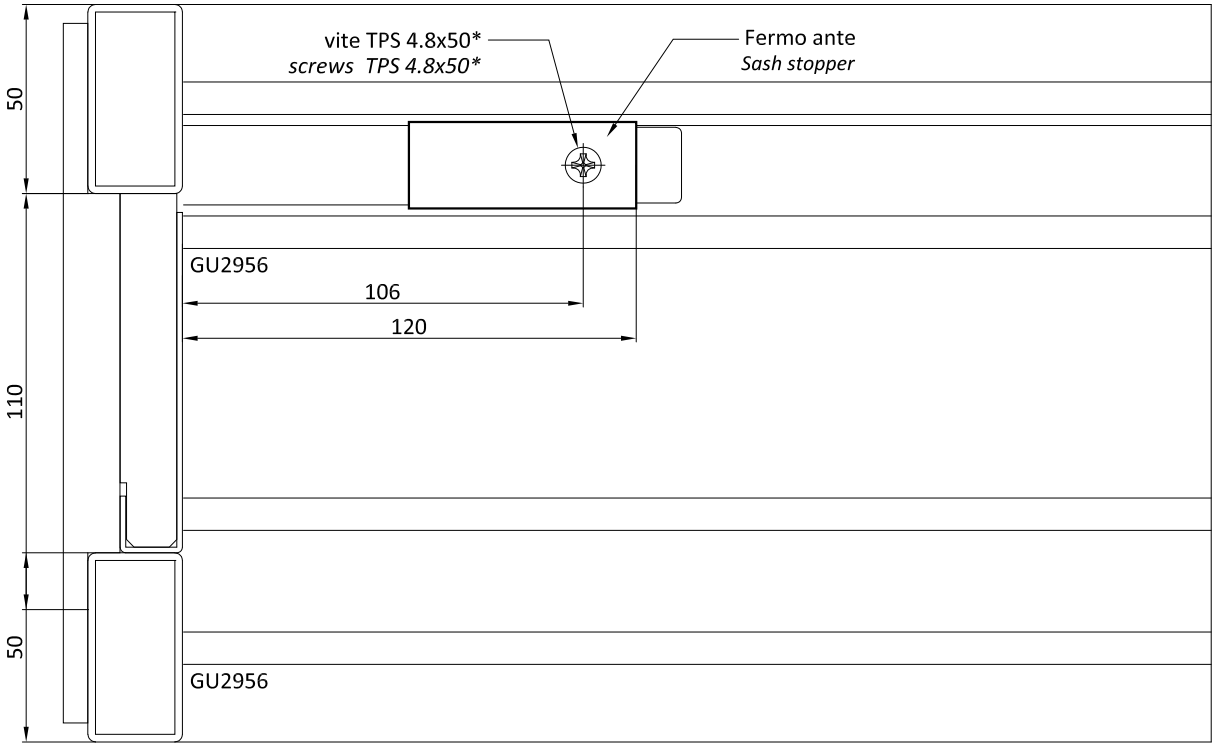




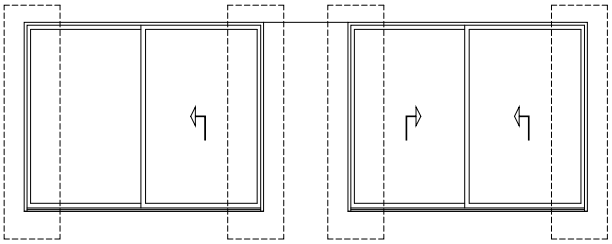
lavorazione valida anche per guida singola
processing also valid for individual rail

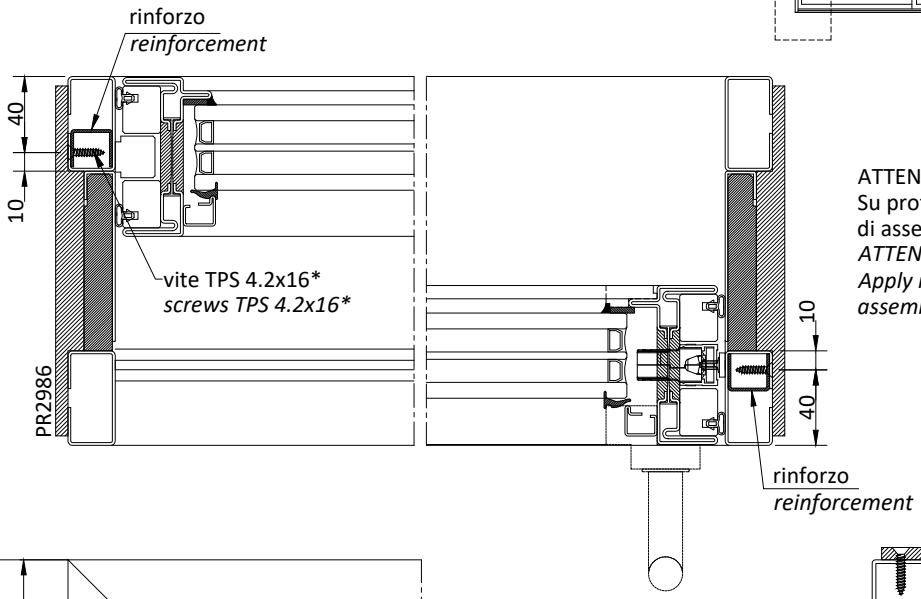




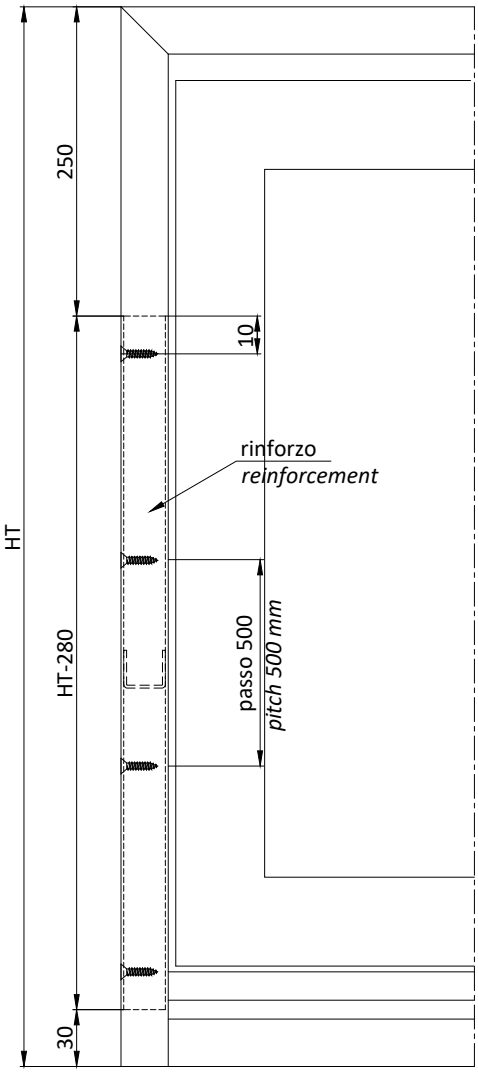


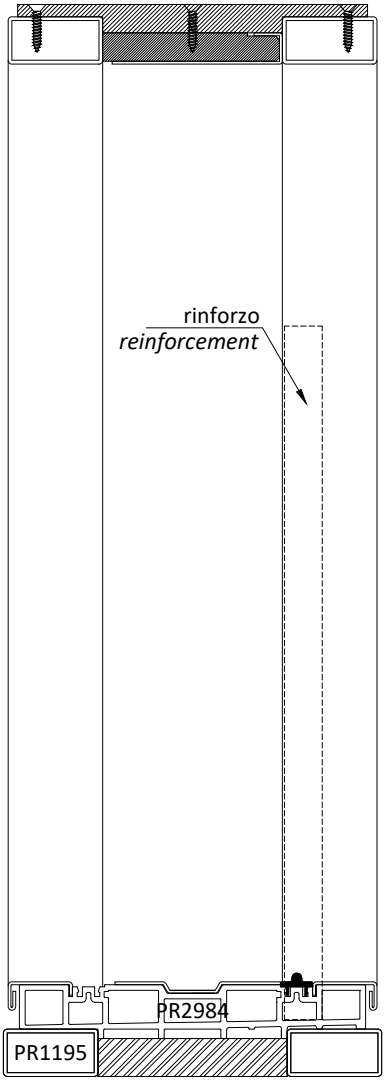
* viti TPS 4.8x50 non comprese
* *screws TPS 4.8x50 not supplied*



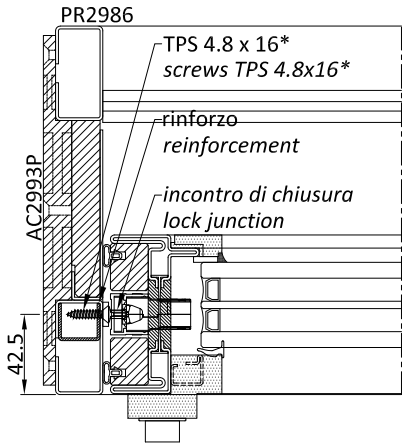


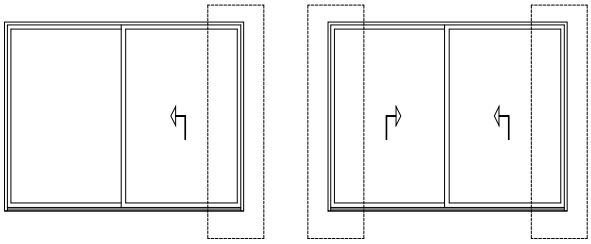
ATTENZIONE:
Su profili in ottone inserire il rinforzo prima di assemblare il telaio
ATTENTION:
Apply reinforcement on brass profiles before assembling the frame

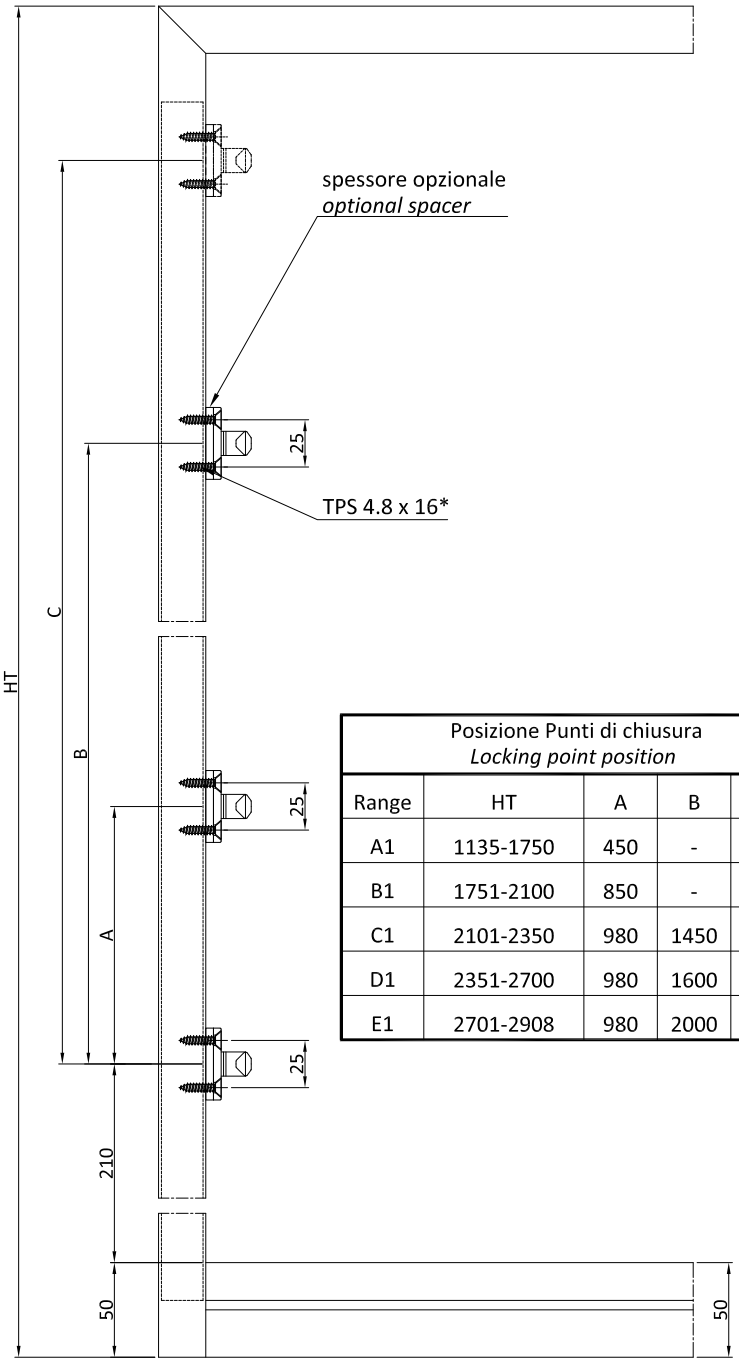




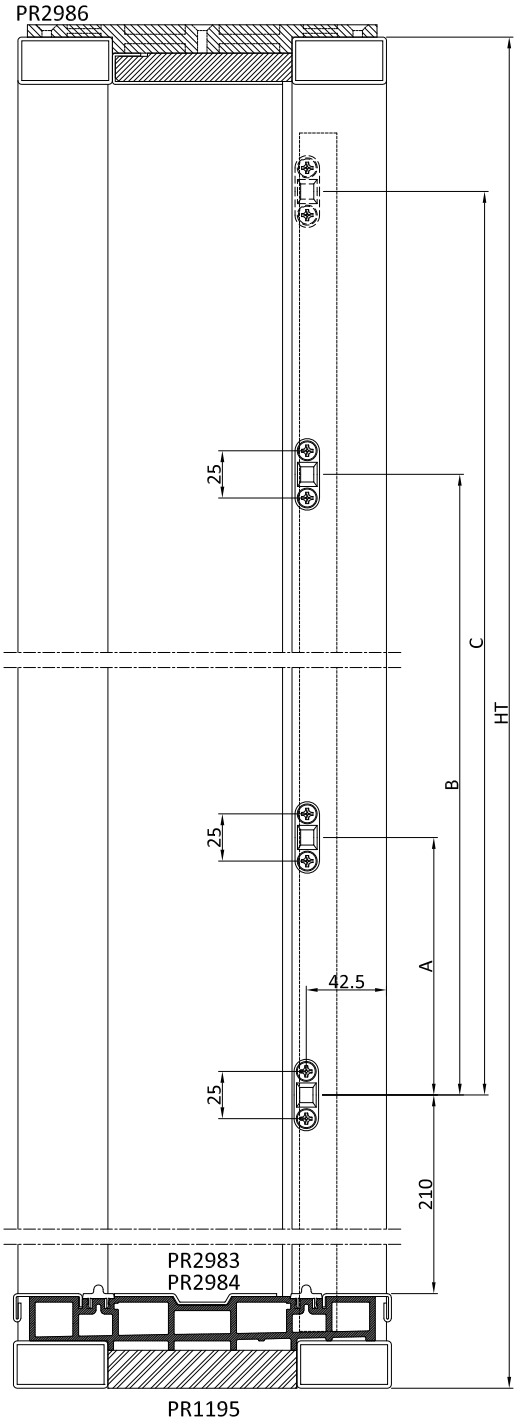
* viti TPS 4.2x16 non comprese
*screws TPS 4.2x16 not supplied



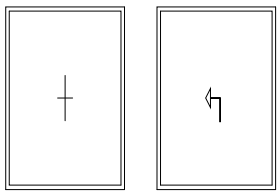


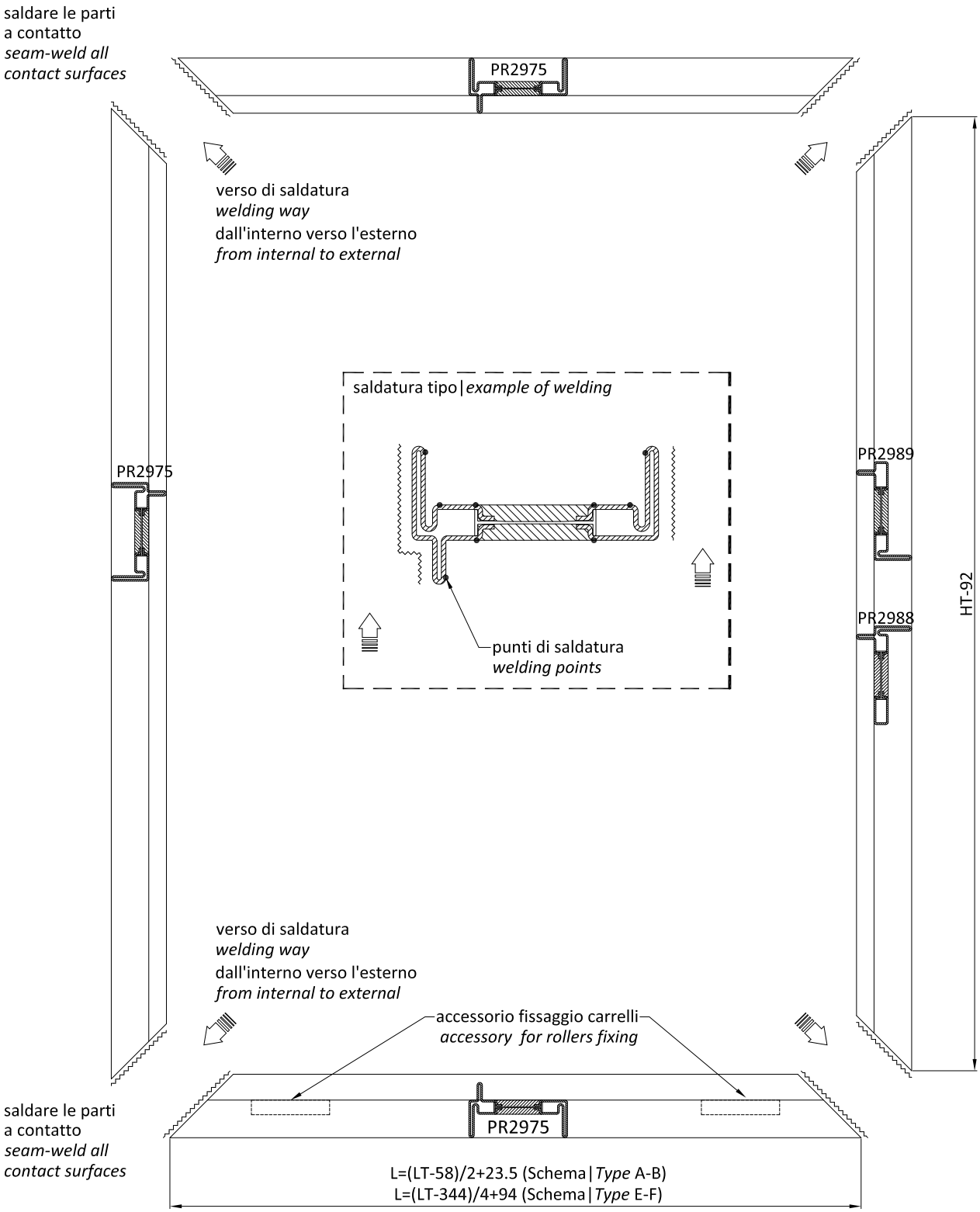


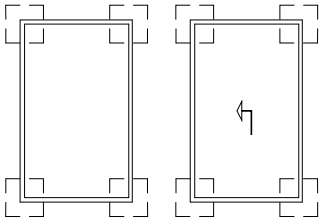
Posizione Punti di chiusura *Locking point position*				
Range	HT	A	B	C
A1	1135-1750	450	-	-
B1	1751-2100	850	-	-
C1	2101-2350	980	1450	-
D1	2351-2700	980	1600	-
E1	2701-2908	980	2000	VAR.

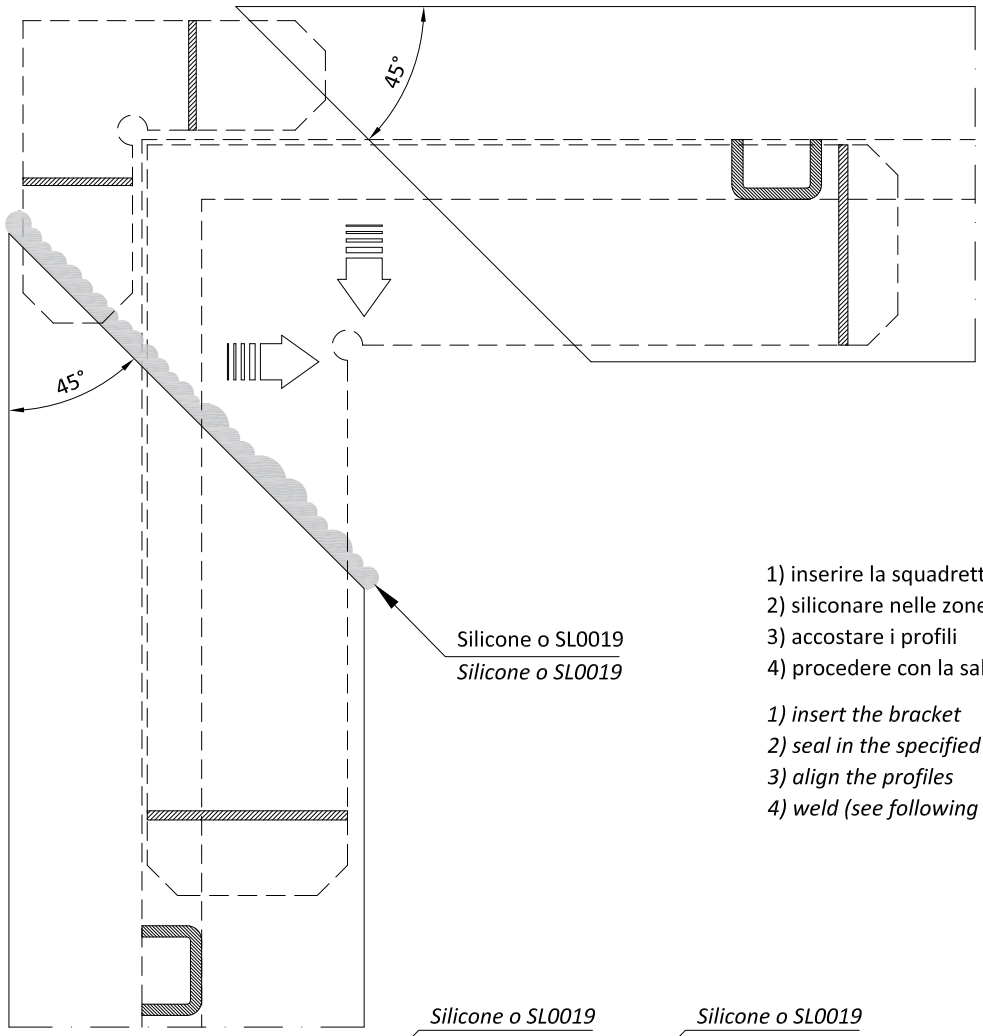


* viti TPS 4.8x16 non comprese
* *screws TPS 4.8x16 not supplied*



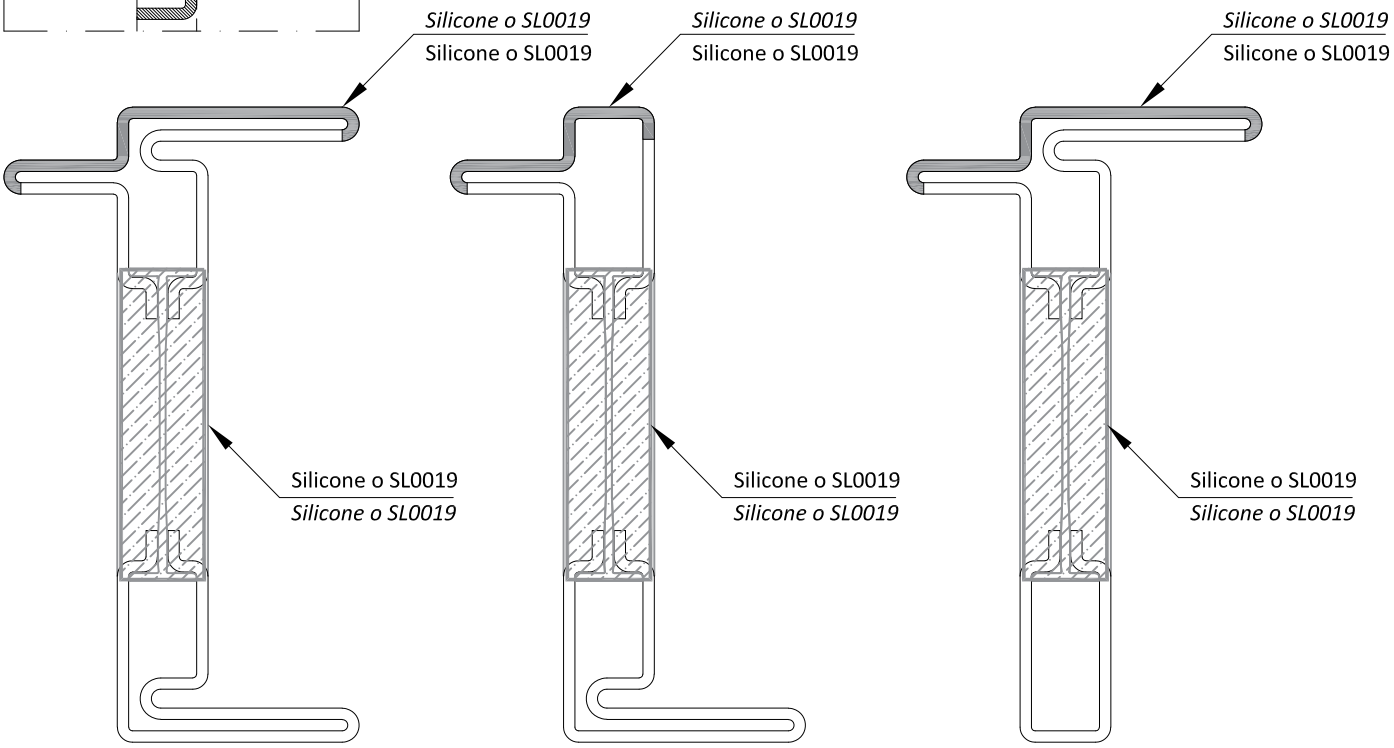

saldare le parti
a contatto
seam-weld all
contact surfaces
PR2975
verso di saldatura
welding way
dall'interno verso l'esterno
from internal to external
saldatura tipo|*example of welding*
PR2975
PR2989
PR2988
HT-92
punti di saldatura
welding points
verso di saldatura
welding way
dall'interno verso l'esterno
from internal to external
accessorio fissaggio carrelli
accessory for rollers fixing
saldare le parti
a contatto
seam-weld all
contact surfaces
PR2975
L=(LT-58)/2+23.5 (Schema|*Type* A-B)
L=(LT-344)/4+94 (Schema|*Type* E-F)





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

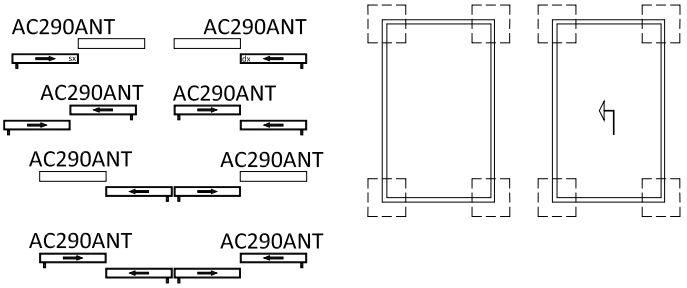
1) insert the bracket
2) seal in the specified areas
3) align the profiles
4) weld (see following pages)

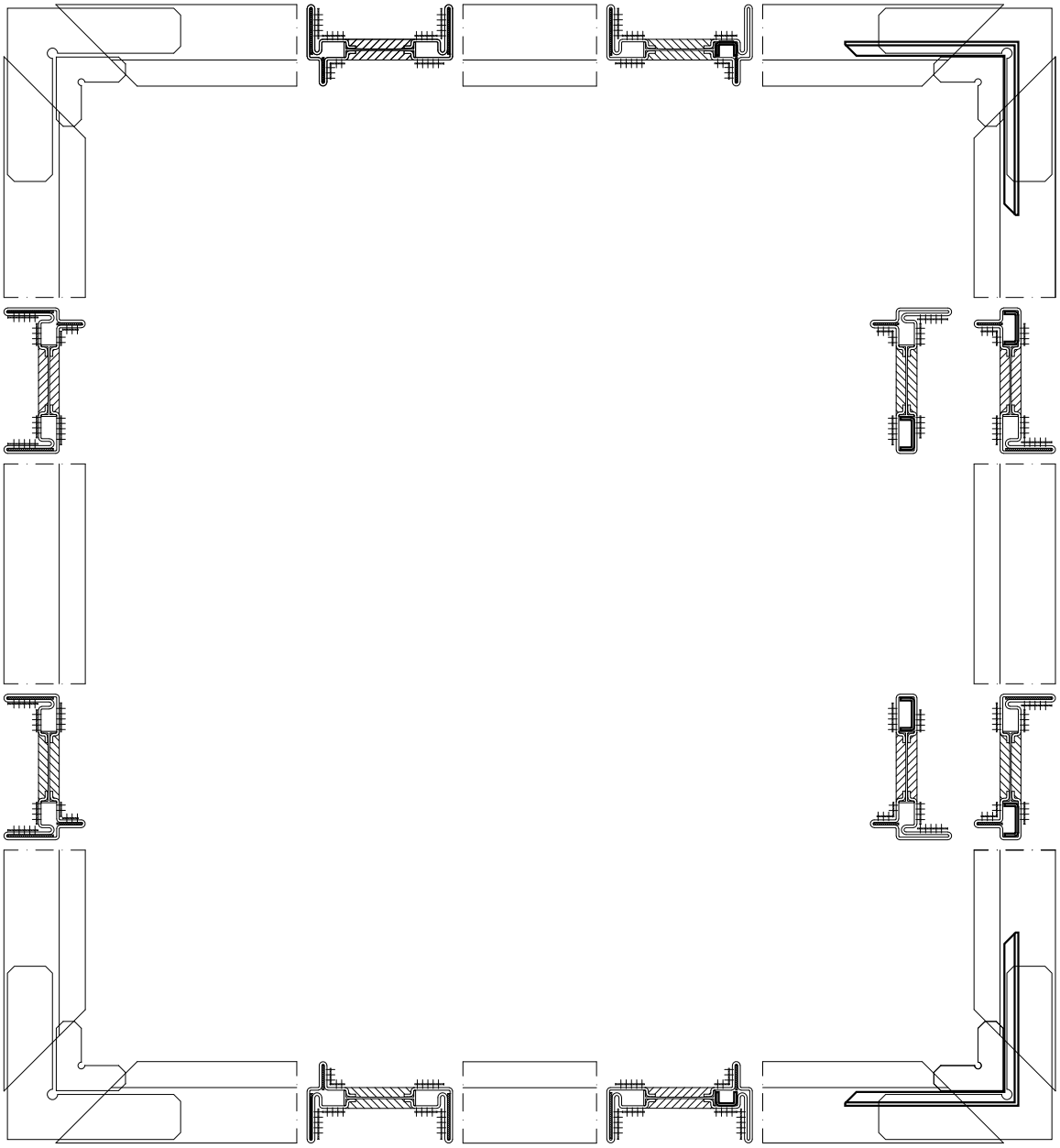


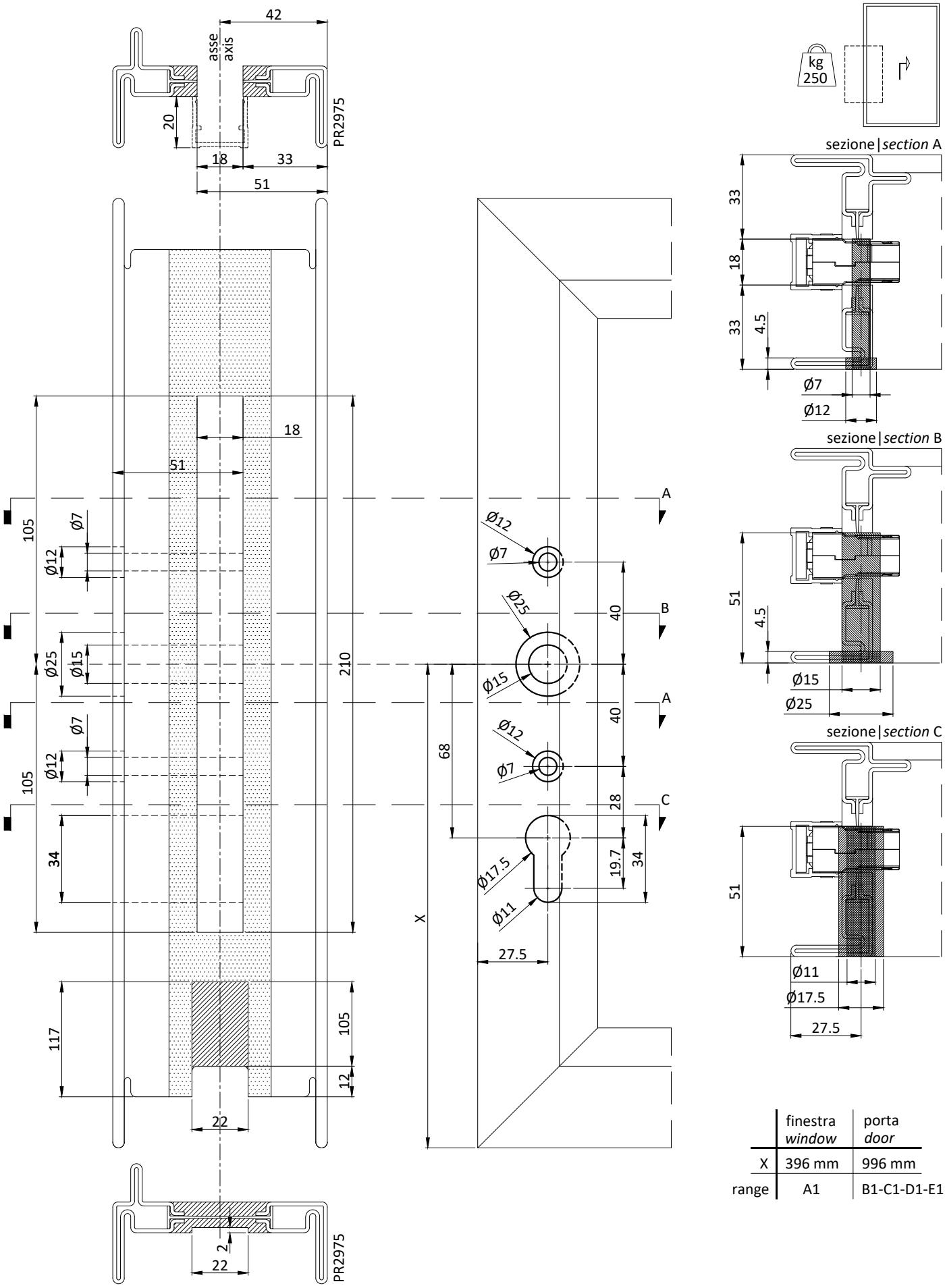
Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)

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

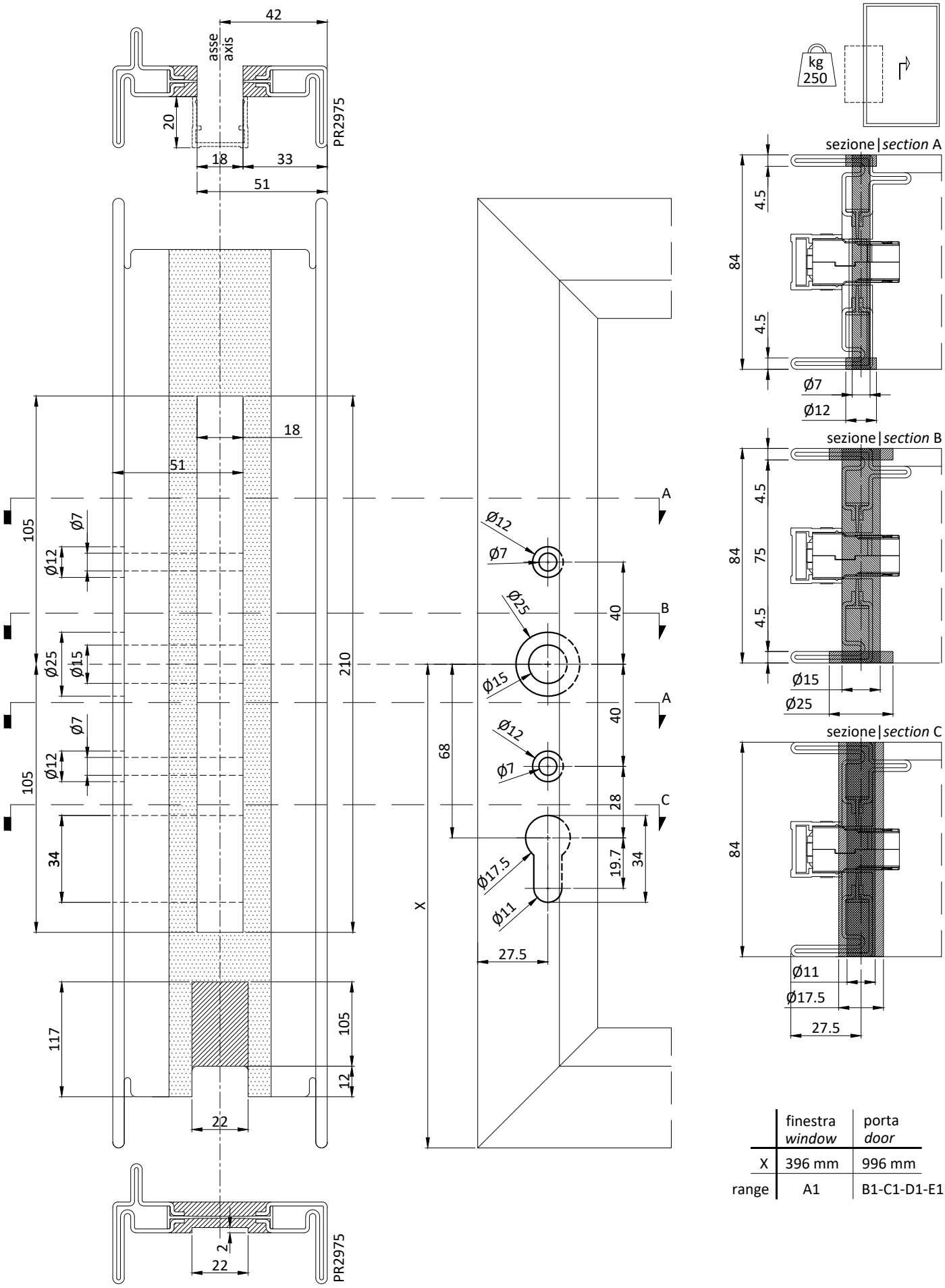
Sigillare tutte le superfici di contatto esterne con silicone o SL0019
Seal all the external contact surfaces with silicone our SL0019



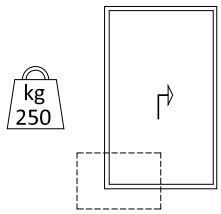


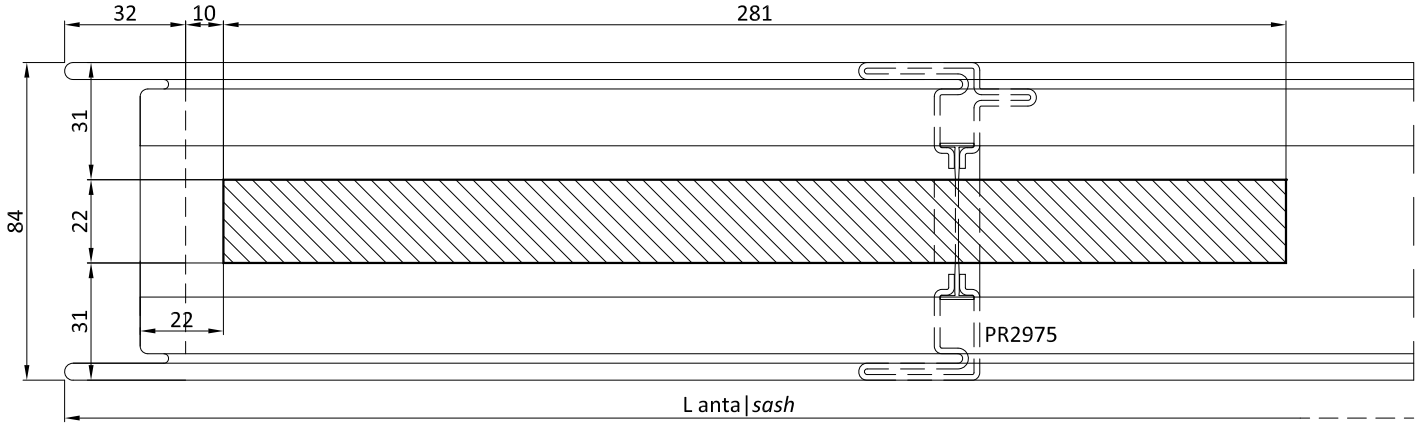


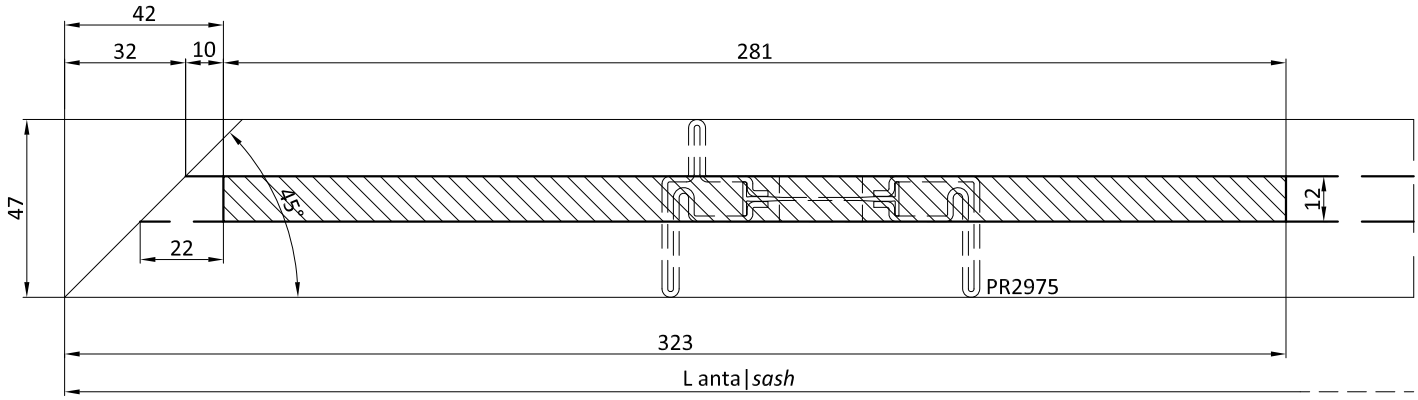
	finestra *window*	porta *door*
X	396 mm	996 mm
range	A1	B1-C1-D1-E1

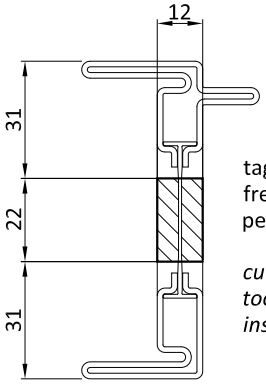


	finestra *window*	porta *door*
X	396 mm	996 mm
range	A1	B1-C1-D1-E1



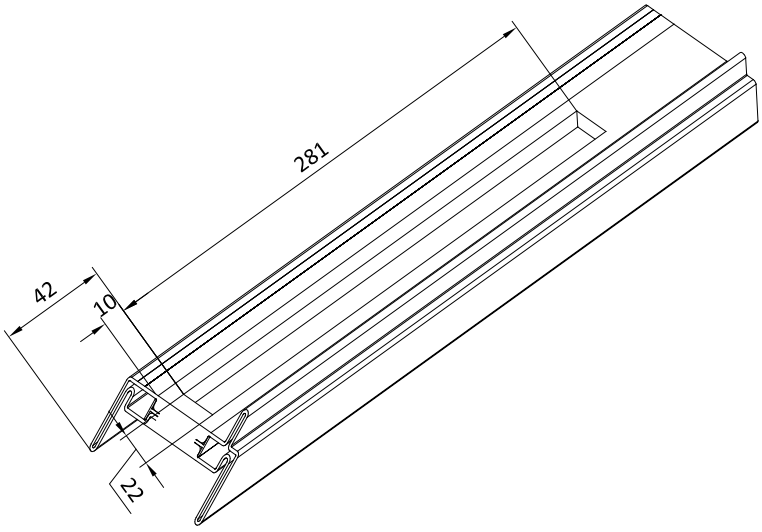


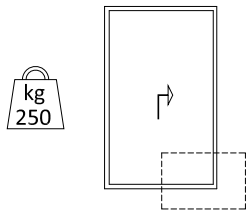


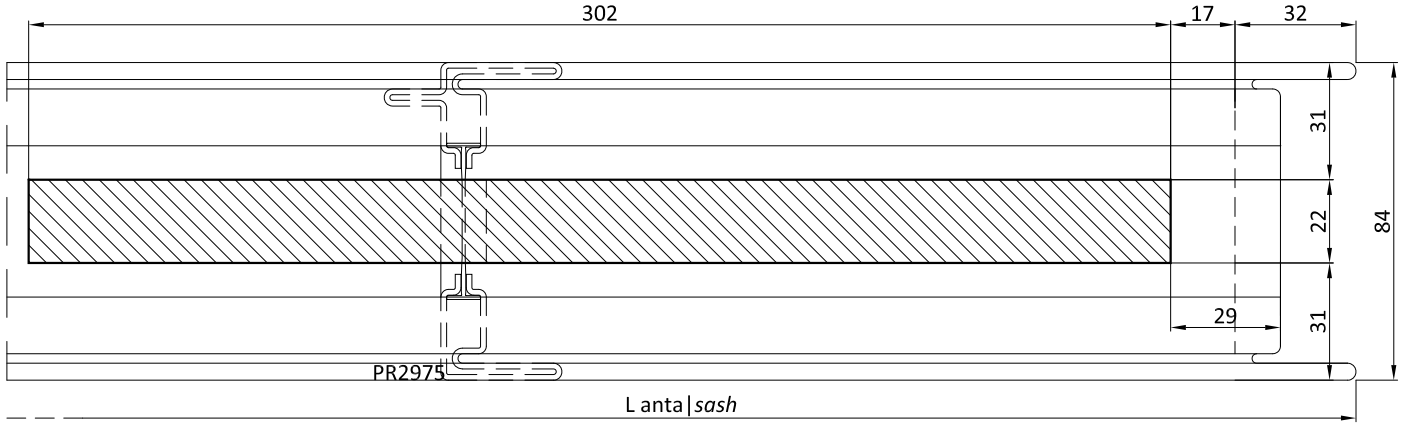


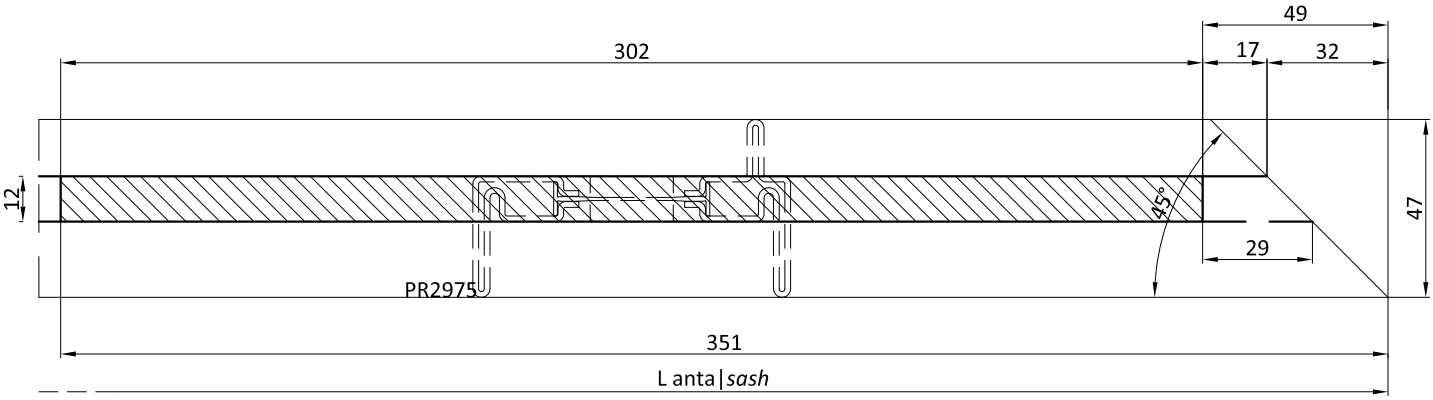
tagliare a misura il profilo PR2975 e fresare come da disegno il poliuretano per l'alloggio carrelli

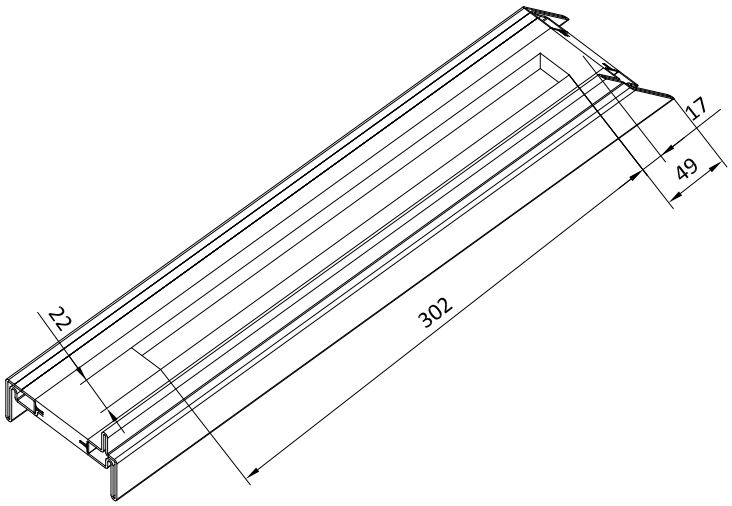
cutting to size the profile PR2975 and tooling the polyurethane for the trolley installation as drawing indication





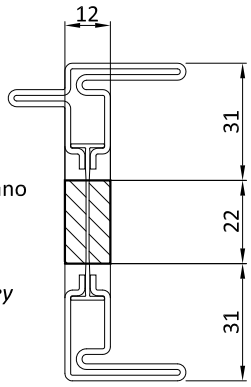


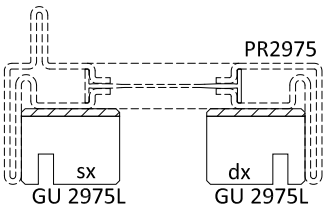


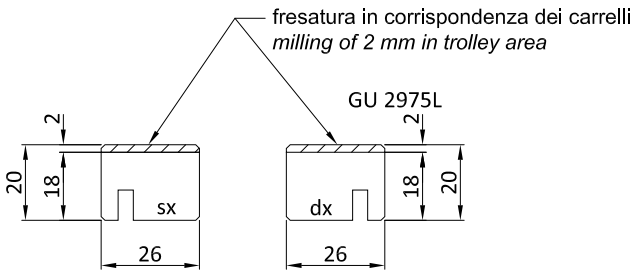


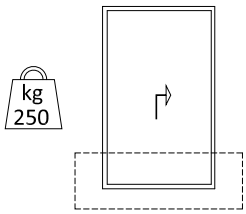
tagliare a misura il profilo PR2975
e fresare come da disegno il poliuretano
per l'alloggio carrelli

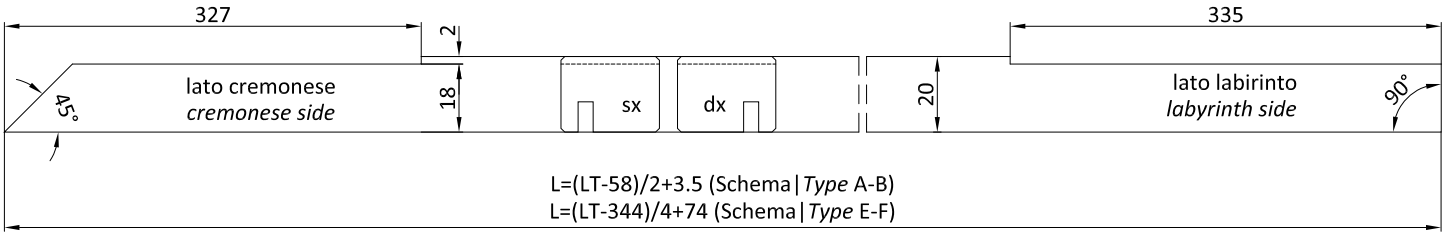
cutting to size the profile PR2975 and
tooling the polyurethane for the trolley
installation as drawing indication

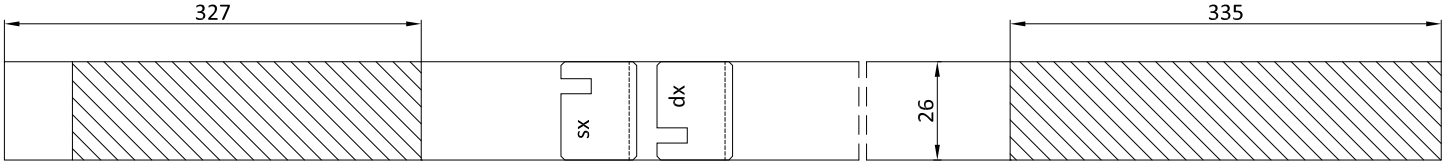


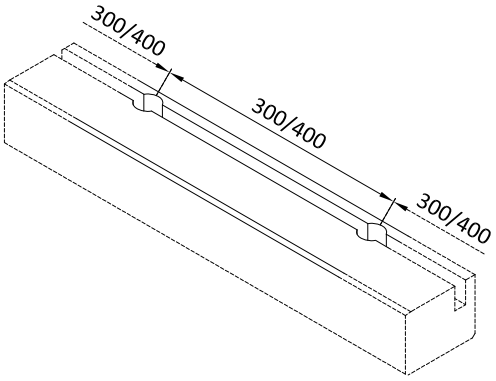


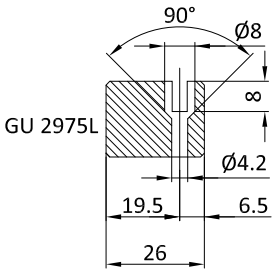






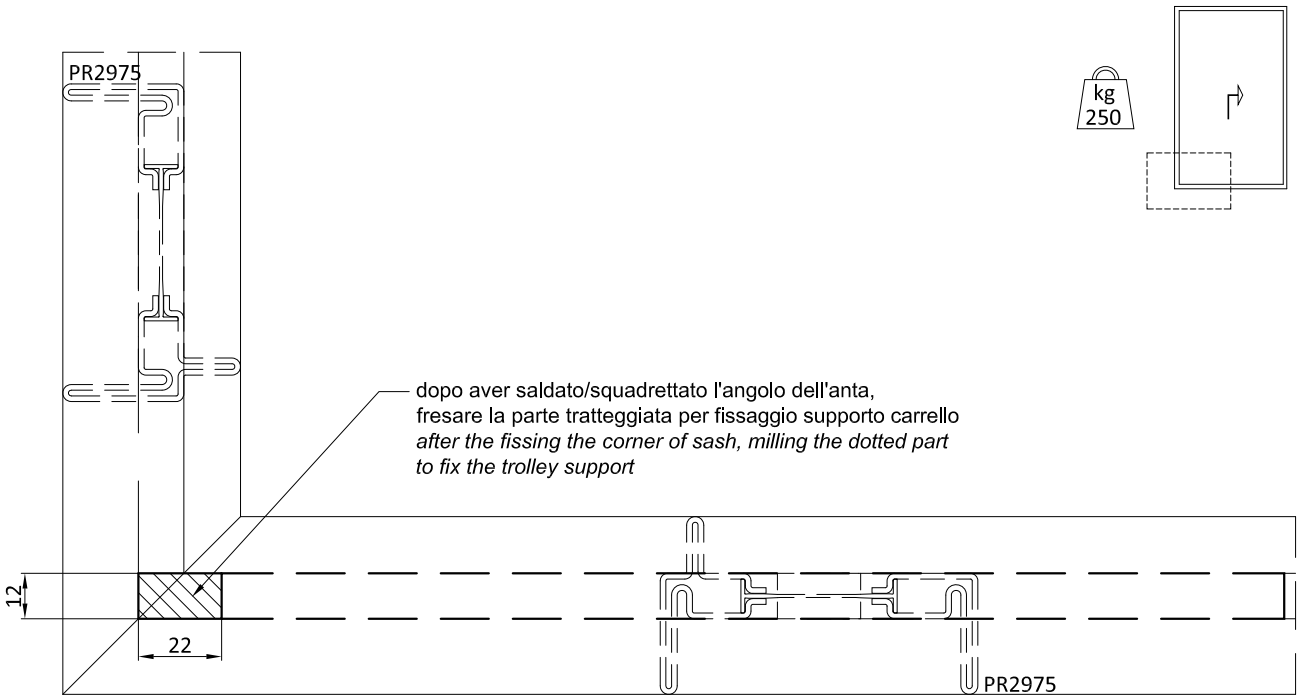


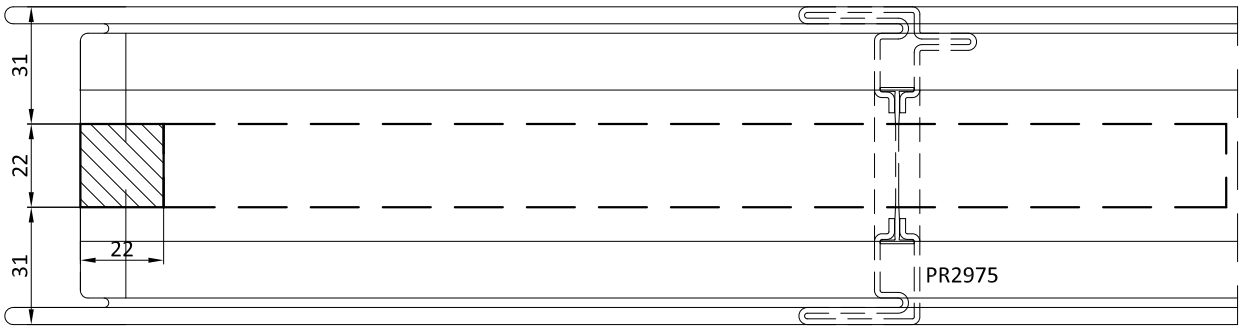


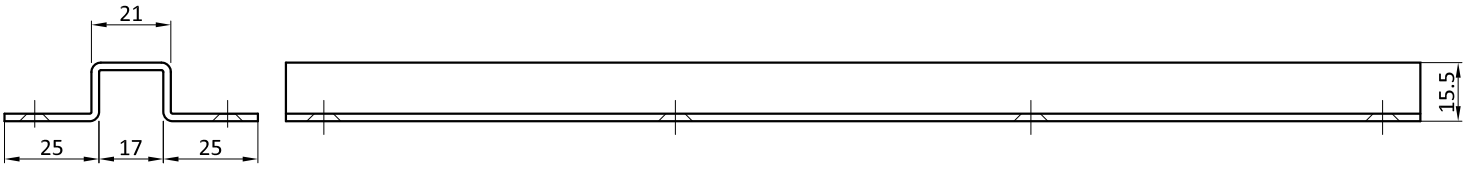


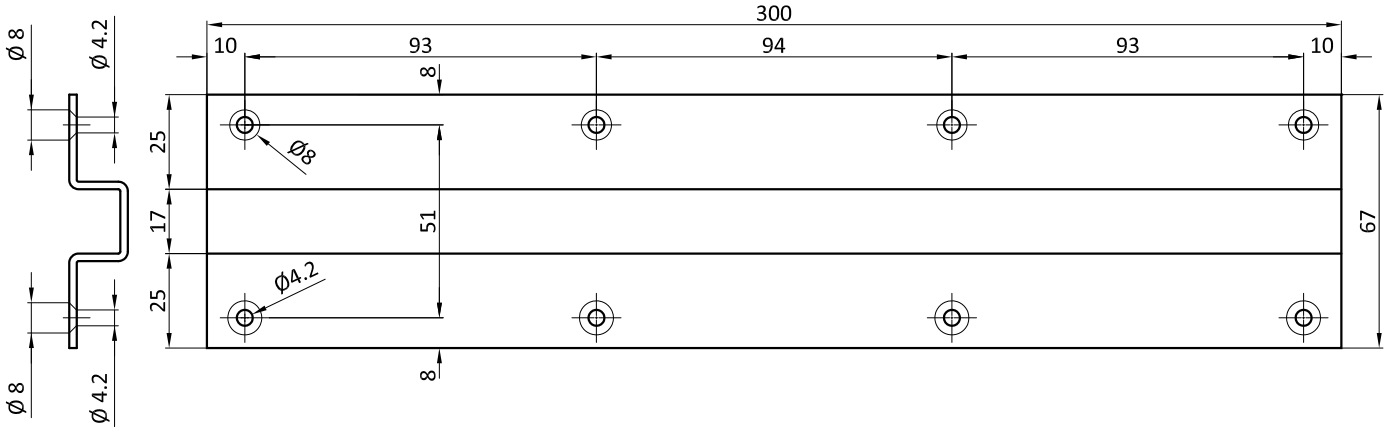
forare Ø4.2 passante
forare Ø8 per 8 mm
svasare per vite M4

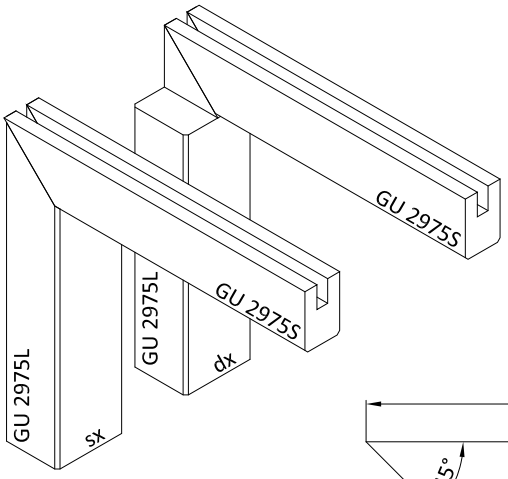
drill Ø4.2 through hole
drill Ø8 for 8 mm
countersink for M4 screw

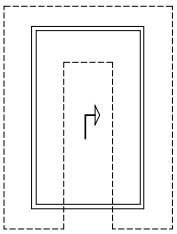

PR2975
kg
250
dopo aver saldato/squadrettato l'angolo dell'anta,
fresare la parte tratteggiata per fissaggio supporto carrello
after the fissing the corner of sash, milling the dotted part
to fix the trolley support
12
22
PR2975

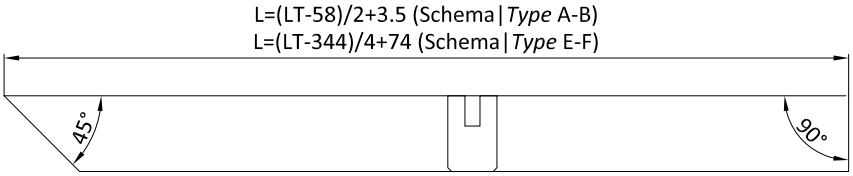

31
22
31
22
PR2975


21
25
17
25
15.5


300
10
93
94
93
10
8
Ø 8
Ø 4.2
25
17
25
Ø8
51
Ø4.2
67
8
Ø 8
Ø 4.2


GU 2975S
GU 2975S
GU 2975L
GU 2975L
dx
sx

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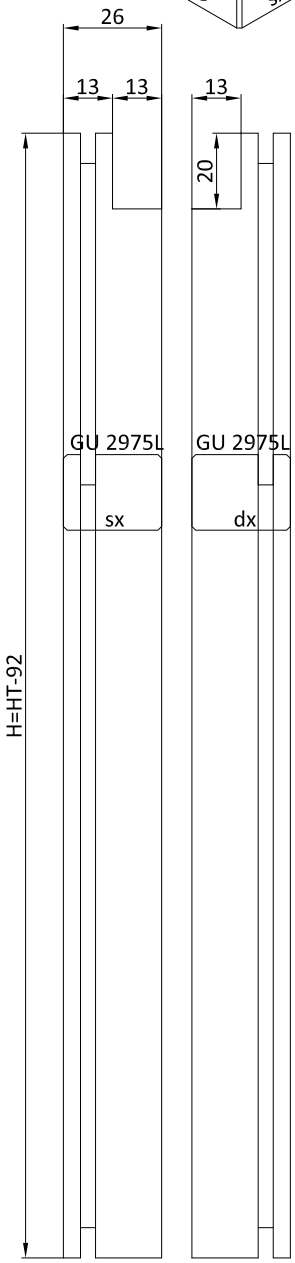
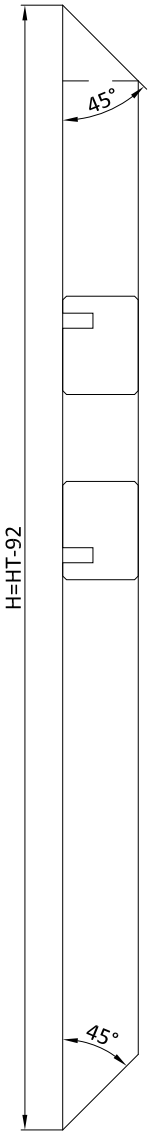
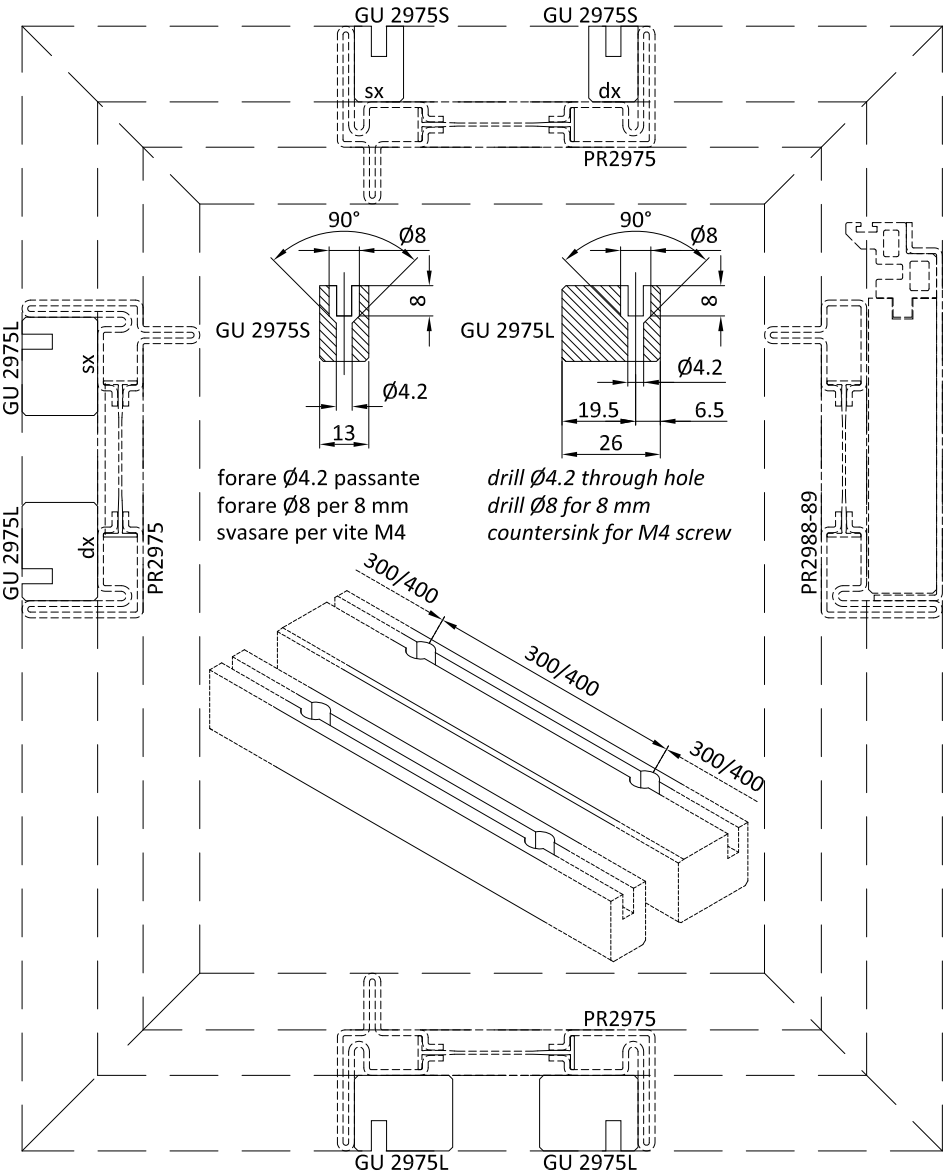
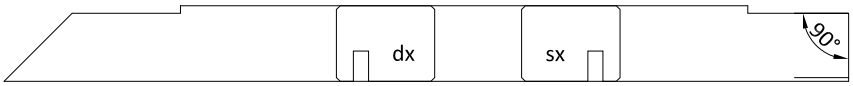
L=(LT-344)/4+74 (Schema|*Type* E-F)
45°
90°

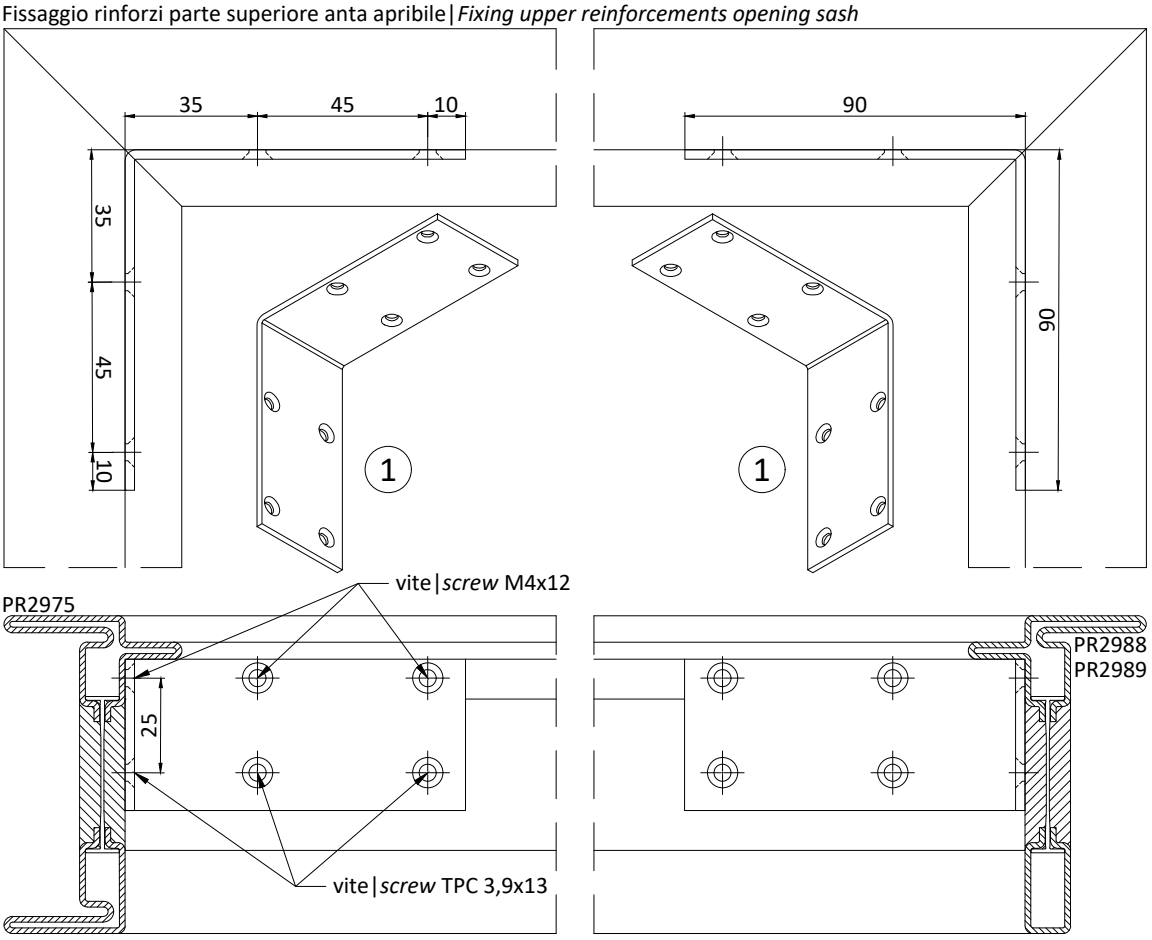

26
13
13
13
20
GU 2975L
GU 2975L
sx
dx
H=HT-92

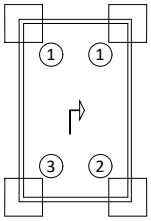

45°
H=HT-92
45°


GU 2975S
GU 2975S
sx
dx
PR2975
90°
Ø8
8
GU 2975S
Ø4.2
13
90°
Ø8
8
GU 2975L
Ø4.2
19.5
6.5
26
forare Ø4.2 passante
forare Ø8 per 8 mm
svasare per vite M4
drill Ø4.2 through hole
drill Ø8 for 8 mm
countersink for M4 screw
GU 2975L
sx
GU 2975L
dx
PR2975
PR2988-89
300/400
300/400
300/400
PR2975
GU 2975L
GU 2975L


dx
sx
90°

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

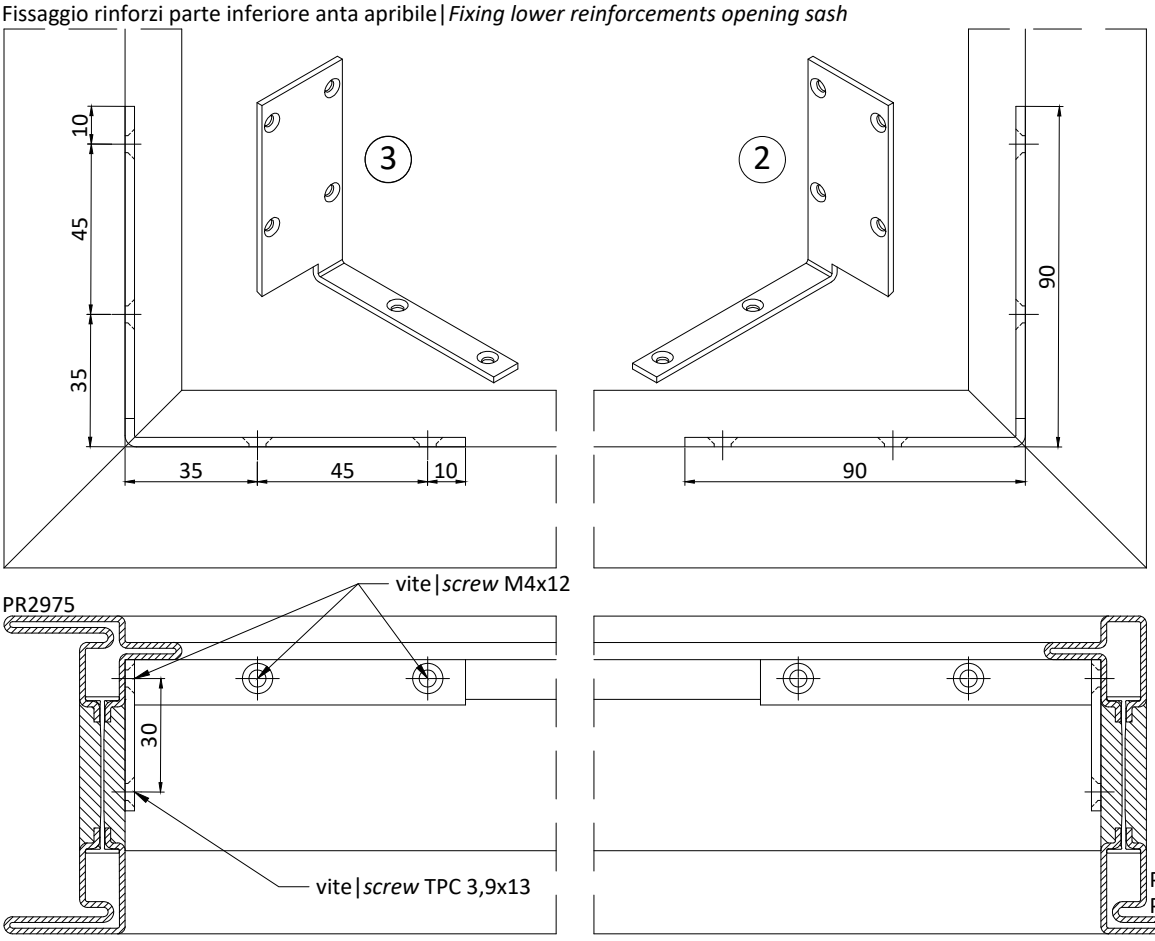
To install reinforcement after the assembly of the sashs.

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

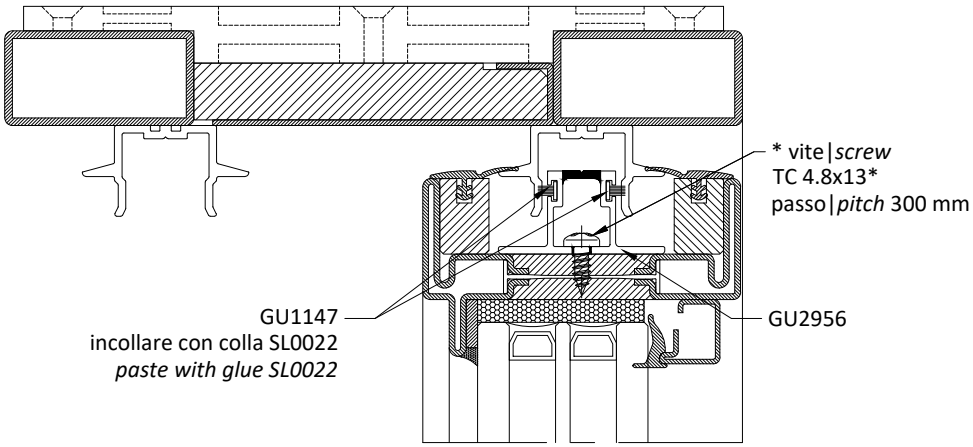
Reinforcement type 2 - 1 piece
Fix the angle in the inner right corner of the sash on the lower part.

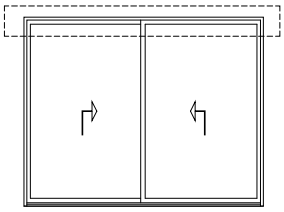
Reinforcement type 2 - 1 piece
Fix the angle in the inner left corner of the sash on the lower part

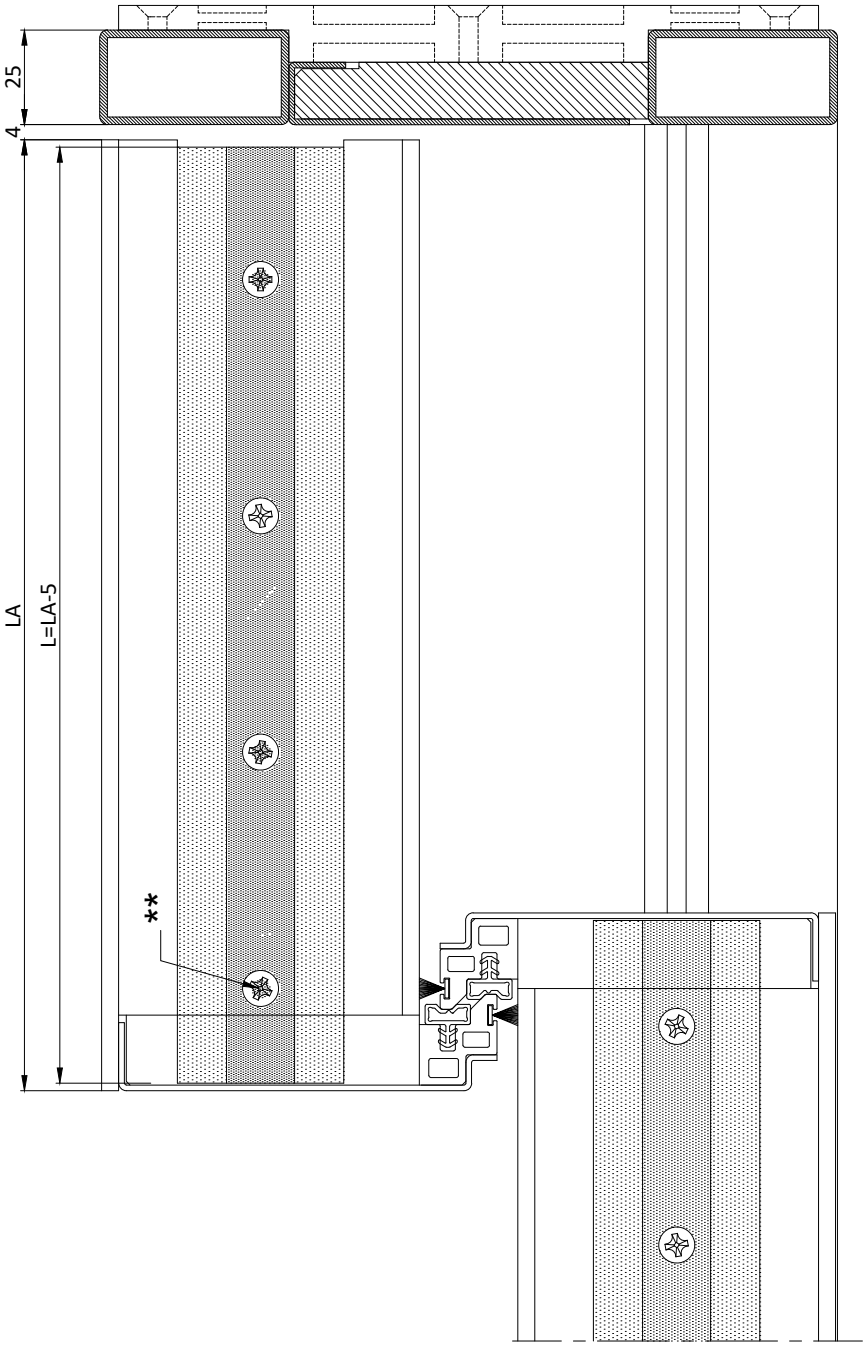
Fissaggio rinforzi parte inferiore anta apribile|*Fixing lower reinforcements opening sash*

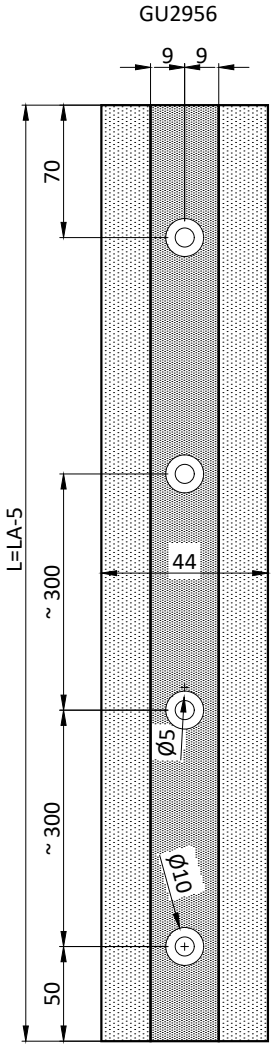


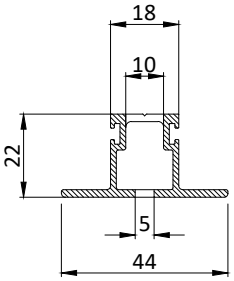
* viti non comprese
** screws not supplied*



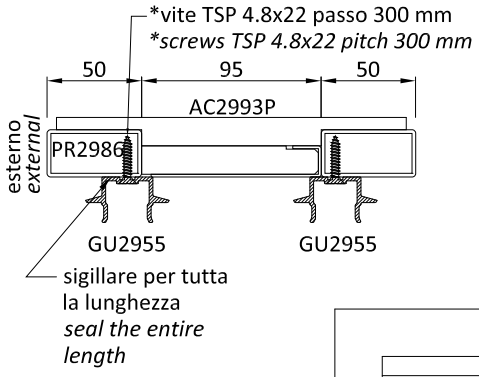


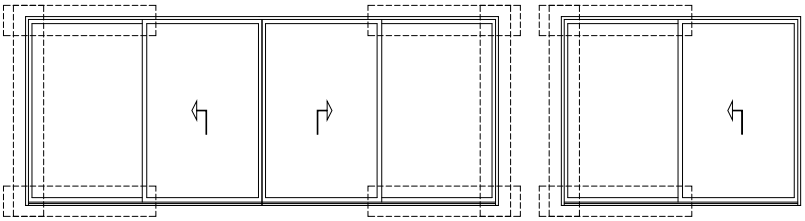


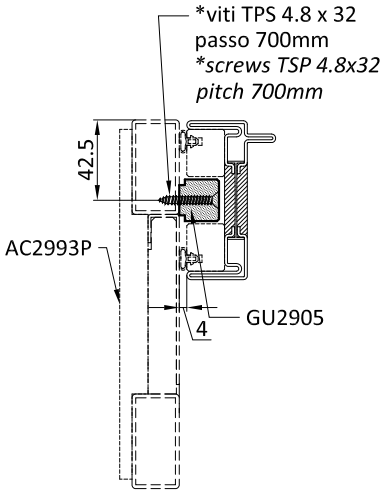


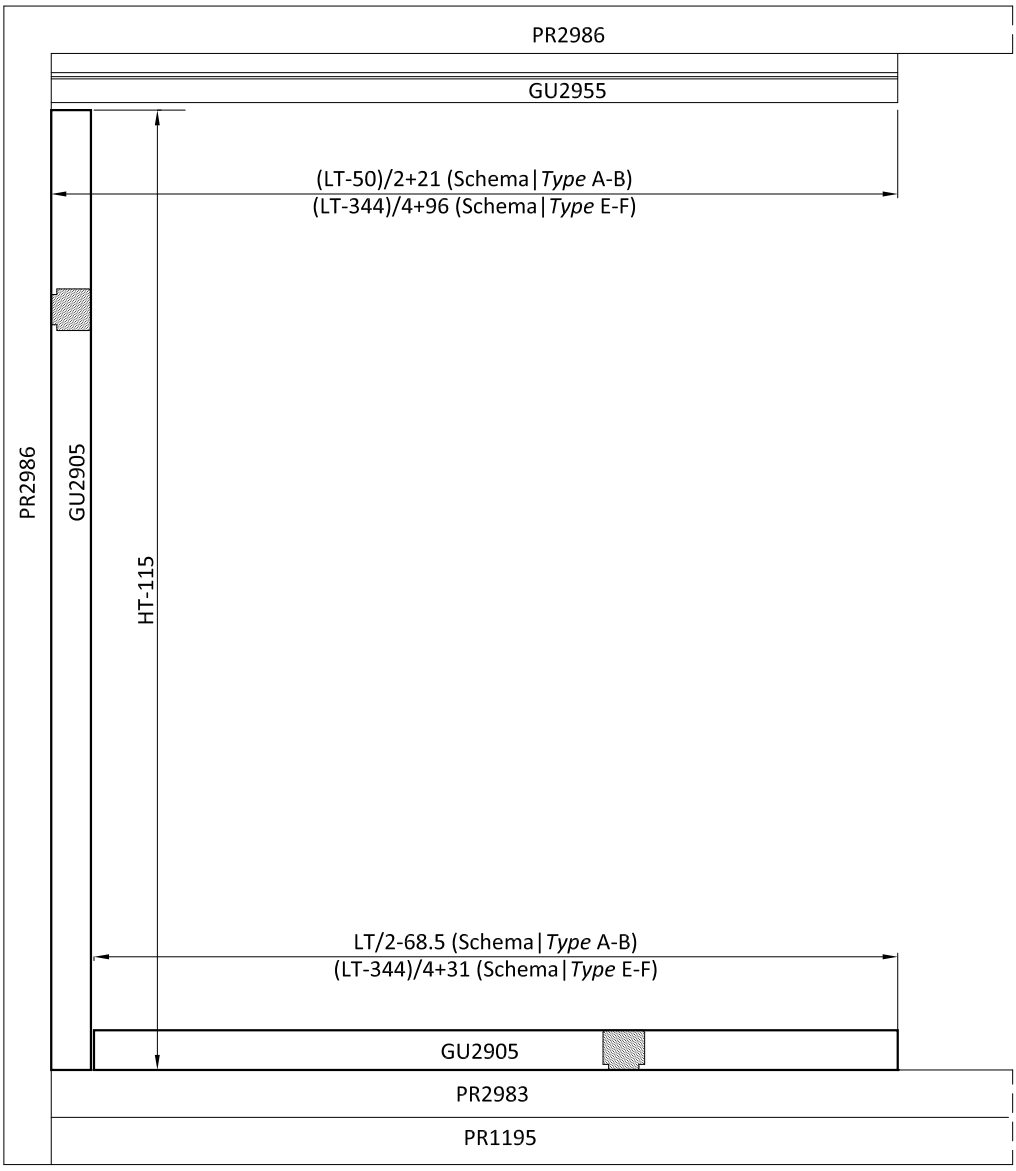


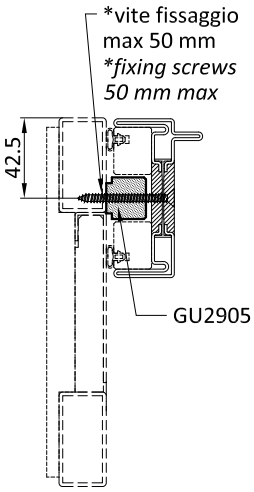
* viti TC 4.8x13 non comprese|*screws* TC 4.8x13 *not supplied*

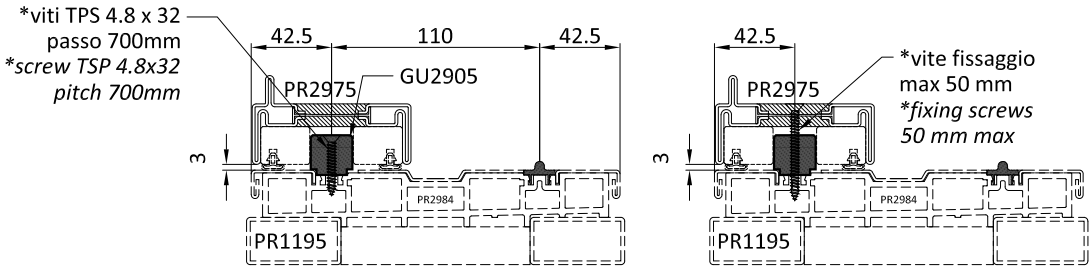




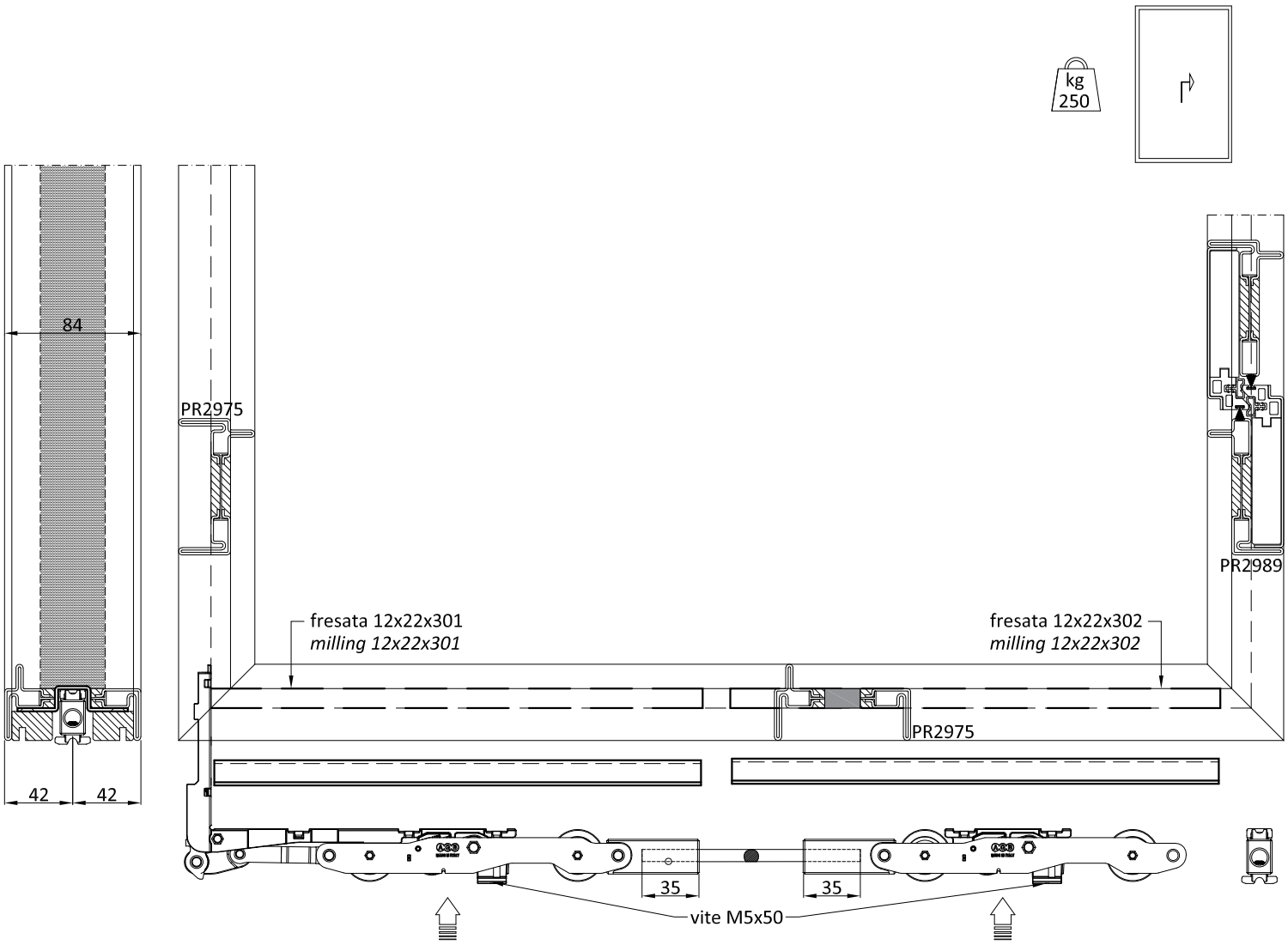


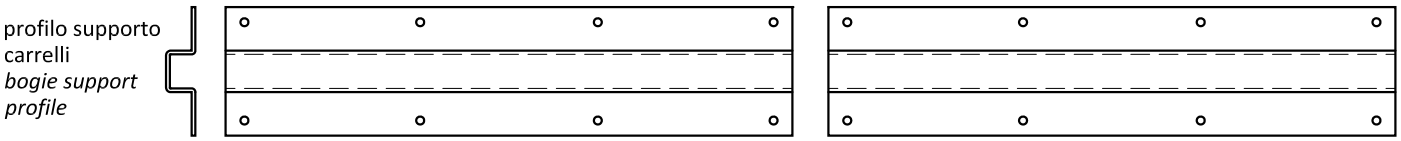


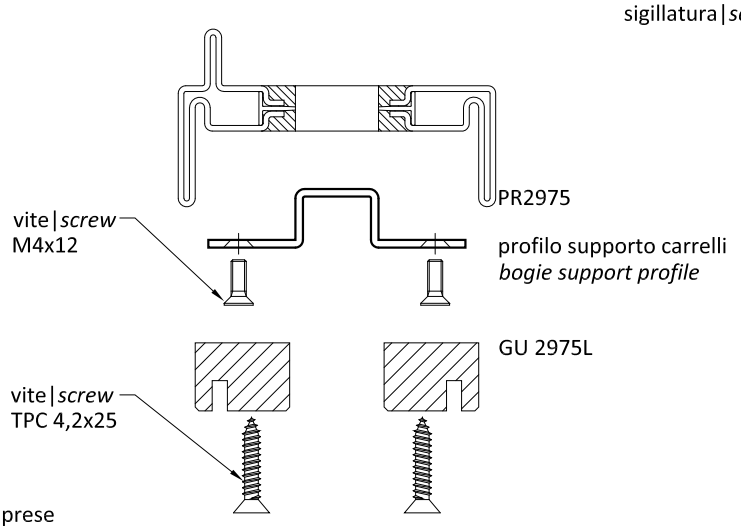


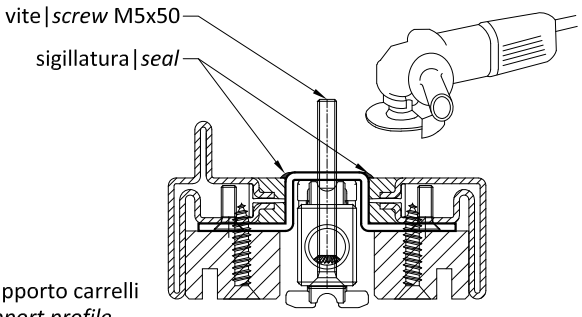


*viti non comprese
*screws not supplied









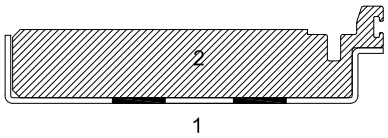
Sequenza installazione|*Installing sequence*:

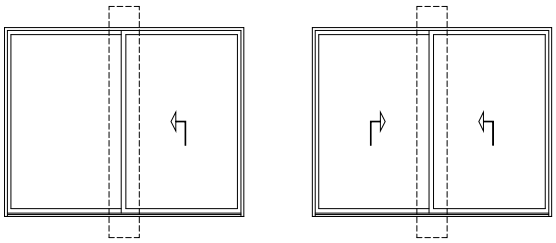
1-Fissare il profilo di supporto carrelli al profilo PR2975
Fix the bogie support profile to PR2975
2-Sigillare il profilo di supporto su tutto il perimetro
Seal the gap between PR2975 and support profile
3-Fissare il carrello al profilo di supporto
Fix bogie on the support profile
4-Tagliare la vite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

* viti non comprese
** screws not supplied*

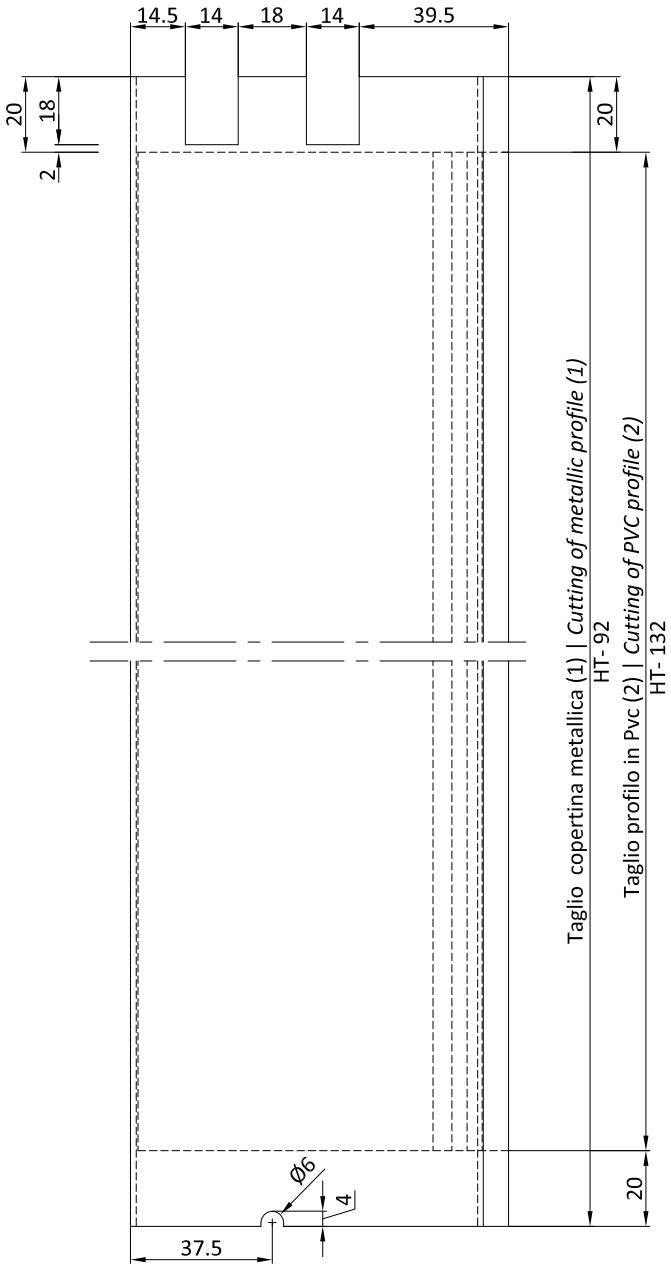
1) Profilo metallico | *Metallic profile*

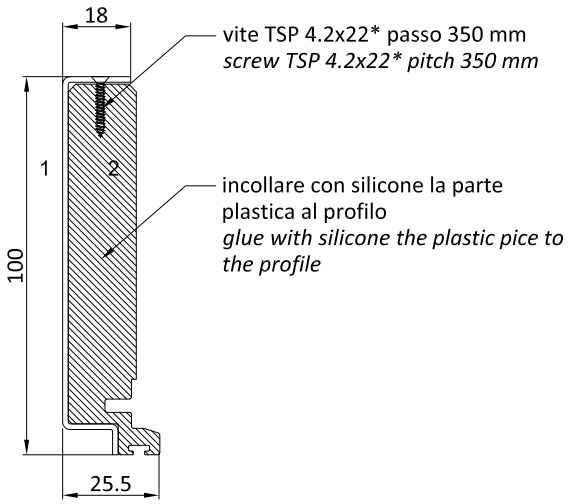
2) Estruso in PVC rigido | *Extruded PVC profile*

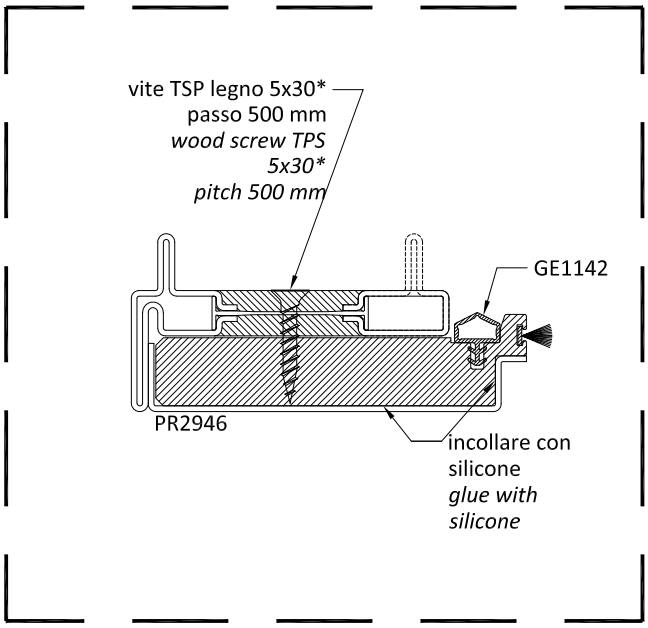


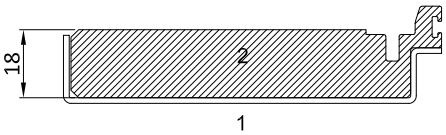


Schema | *Type* A Schema | *Type* B

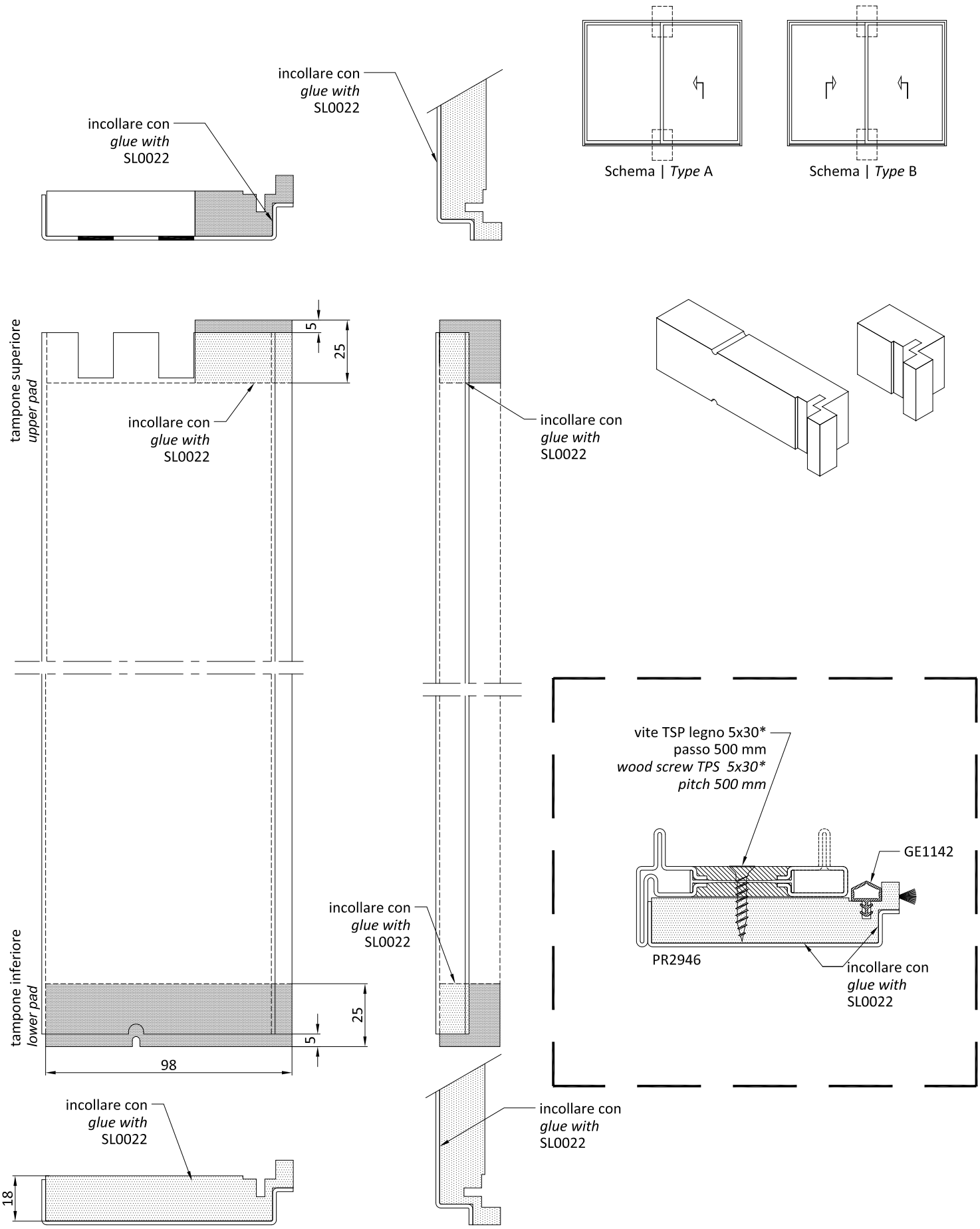






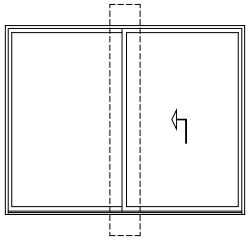


* viti TPS 4.2 x 22 e TC legno 6x35 non comprese
* *TPS 4.2 screws x 22 and wood screws TC 6x35 not supplied*

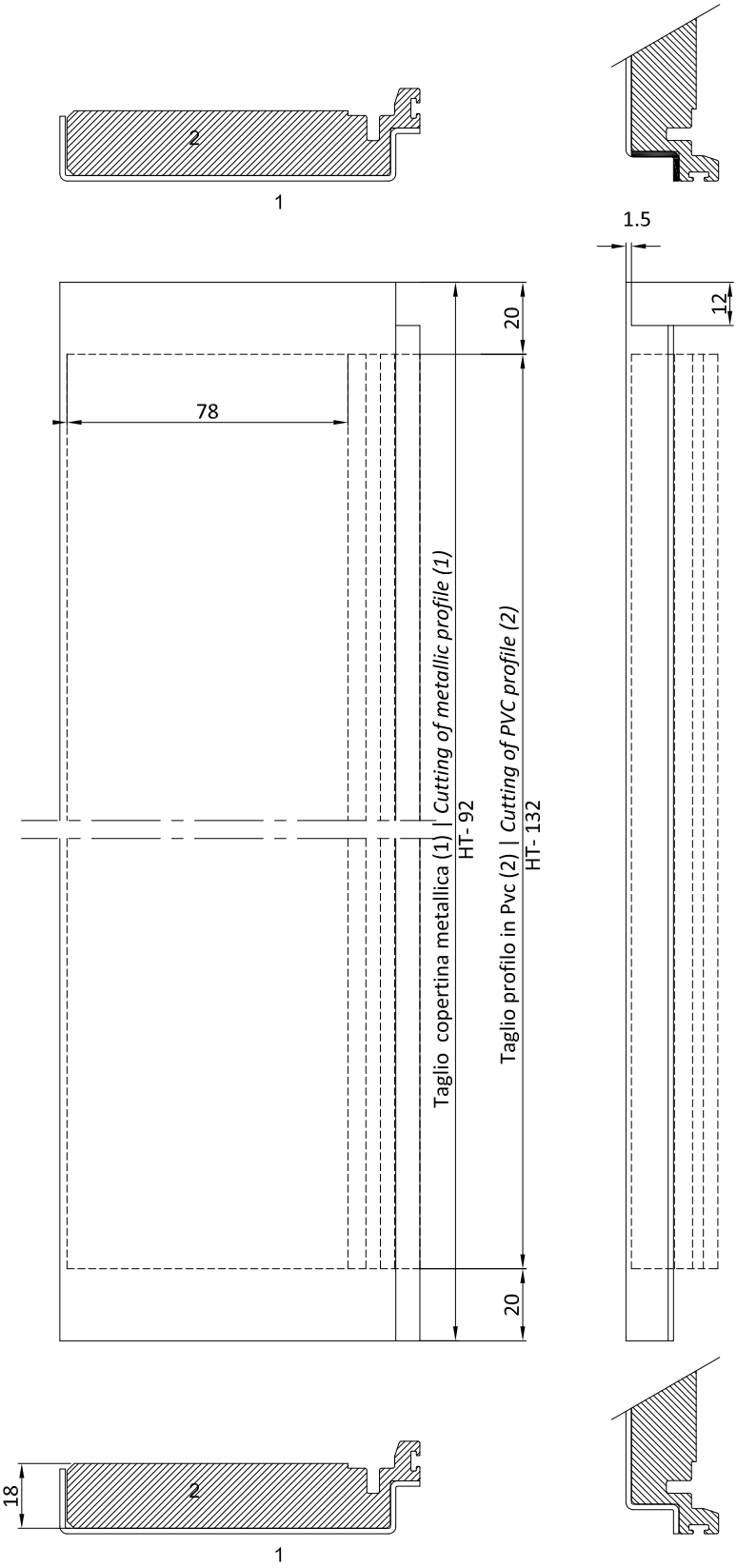

incollare con
glue with
SL0022
incollare con
glue with
SL0022
Schema | *Type* A
Schema | *Type* B
tampone superiore
upper pad
5
25
incollare con
glue with
SL0022
incollare con
glue with
SL0022
vite TSP legno 5x30*
passo 500 mm
*wood screw TPS 5x30**
pitch 500 mm
GE1142
PR2946
incollare con
glue with
SL0022
incollare con
glue with
SL0022
tampone inferiore
lower pad
25
5
98
incollare con
glue with
SL0022
incollare con
glue with
SL0022
18

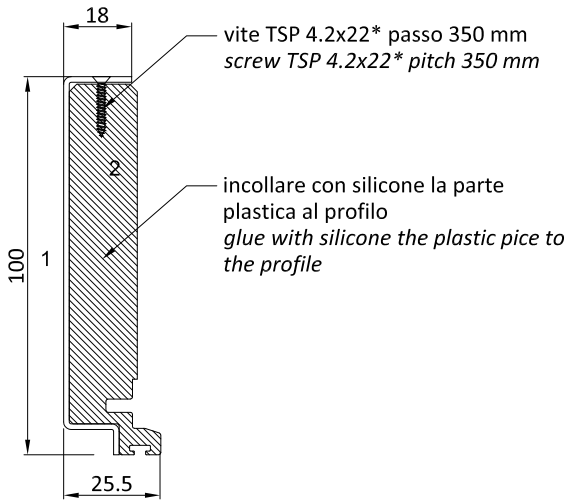
1) Profilo metallico | *Metallic profile*

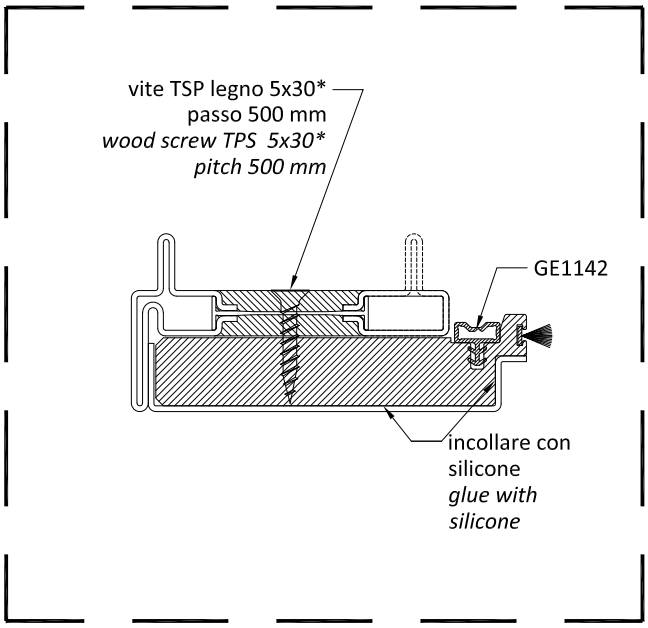
2) Estruso in PVC rigido | *Extruded PVC profile*



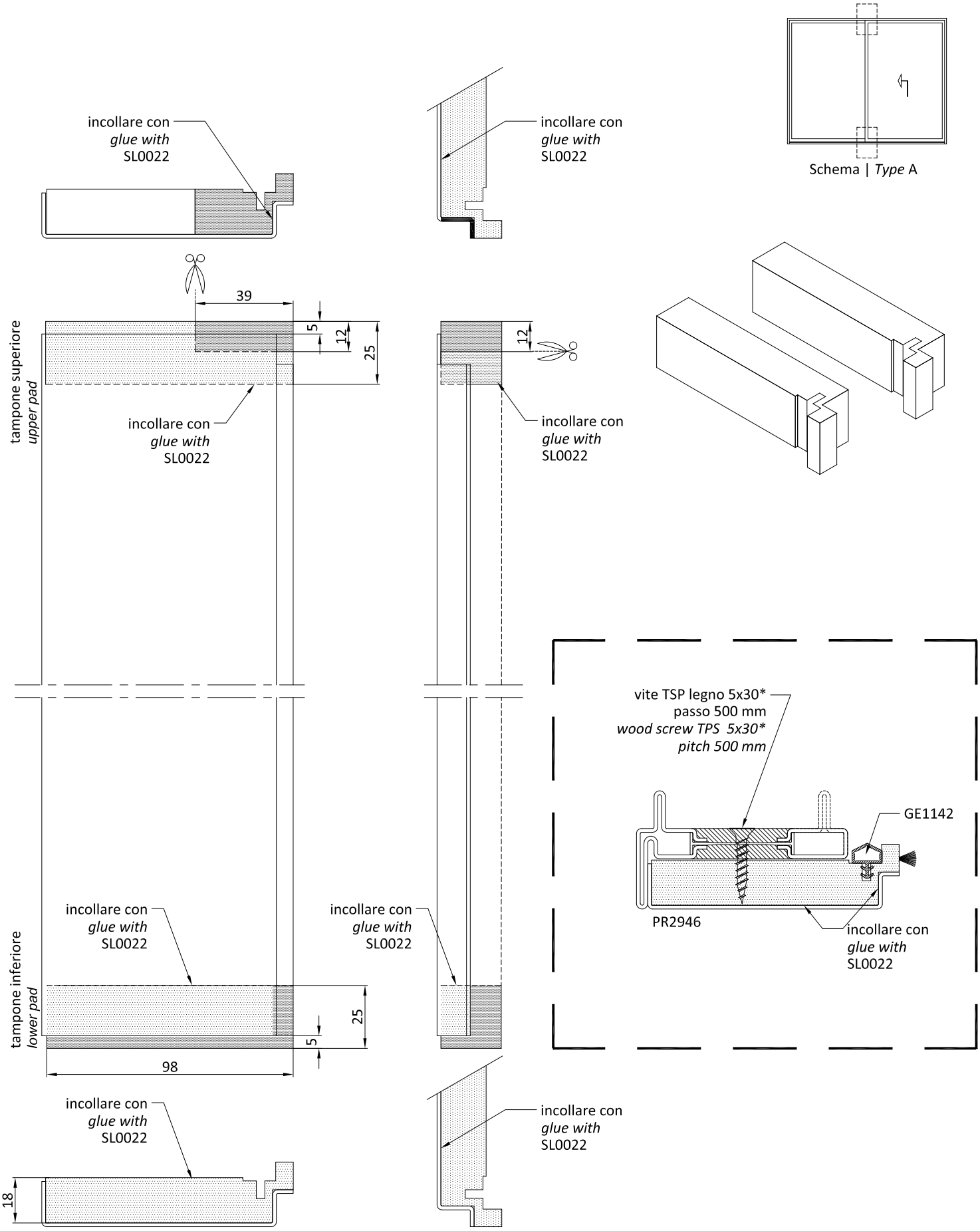
Schema | *Type* A



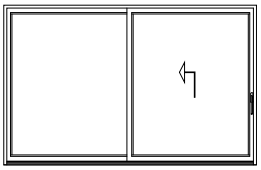


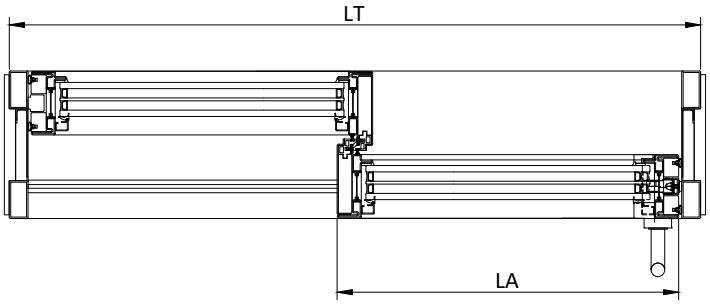


* viti TPS 4.2 x 22 e TC legno 6x35 non comprese
* *TPS 4.2 screws x 22 and wood screws TC 6x35 not supplied*


incollare con
glue with
SL0022
incollare con
glue with
SL0022
Schema | *Type* A
39
5
12
25
12
tampone superiore
upper pad
incollare con
glue with
SL0022
incollare con
glue with
SL0022
vite TSP legno 5x30*
passo 500 mm
*wood screw TPS 5x30**
pitch 500 mm
GE1142
PR2946
incollare con
glue with
SL0022
incollare con
glue with
SL0022
incollare con
glue with
SL0022
tampone inferiore
lower pad
25
5
98
incollare con
glue with
SL0022
incollare con
glue with
SL0022
18

Schema | *Type* A



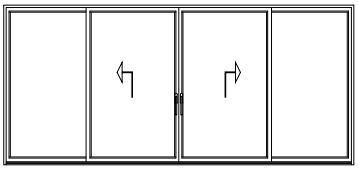


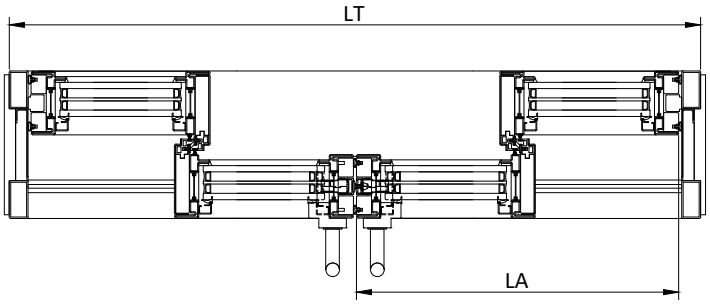
Dimensione anta (A)
Sash dimension (A)

LA = LT/2- 6

HA = HT - 92

Schema | *Type* E

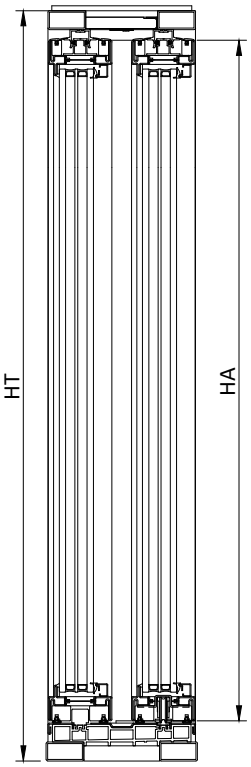




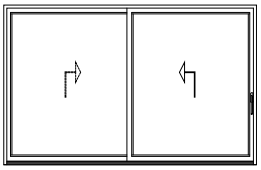
Dimensione anta (A)
Sash dimension (A)

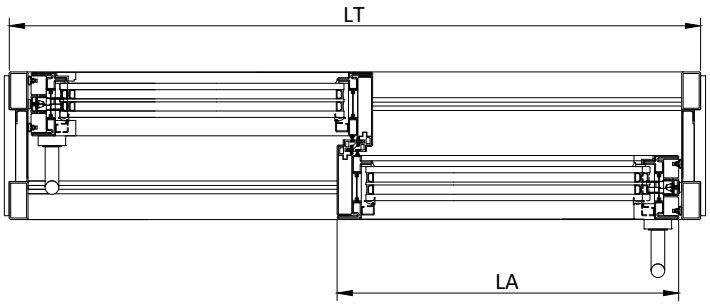
LA = LT/4+8

HA = HT - 92



Schema | *Type* B



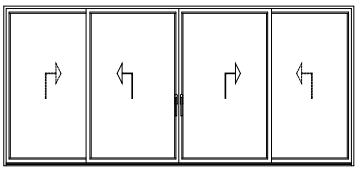


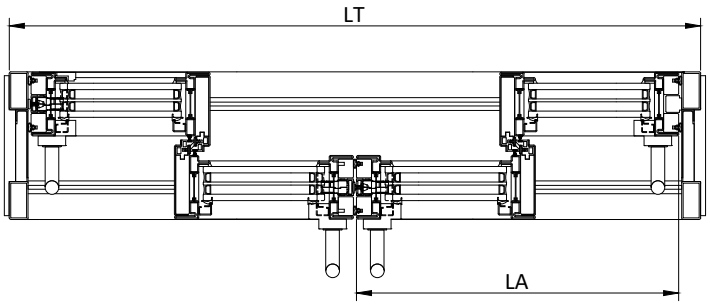
Dimensione anta (A)
Sash dimension (A)

LA = LT/2- 6

HA = HT - 92

Schema | *Type* F

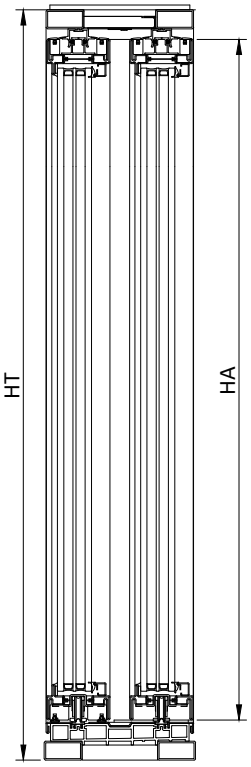




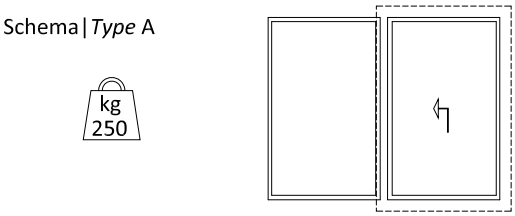
Dimensione anta (A)
Sash dimension (A)

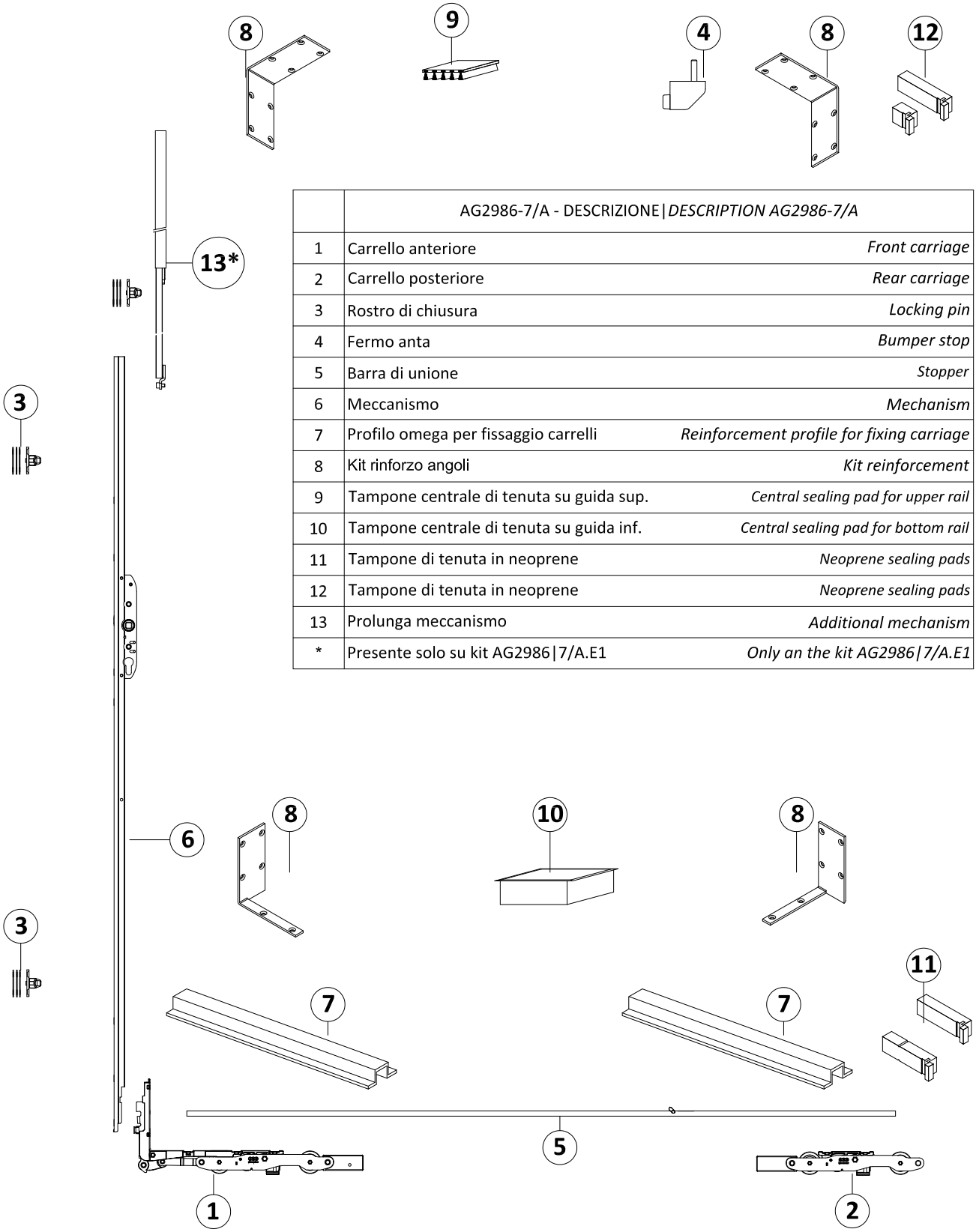
LA = LT/4+8

HA = HT - 92



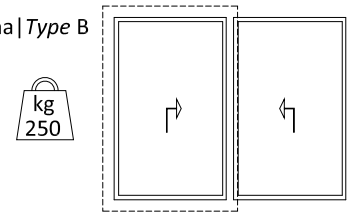
Schema|*Type* A

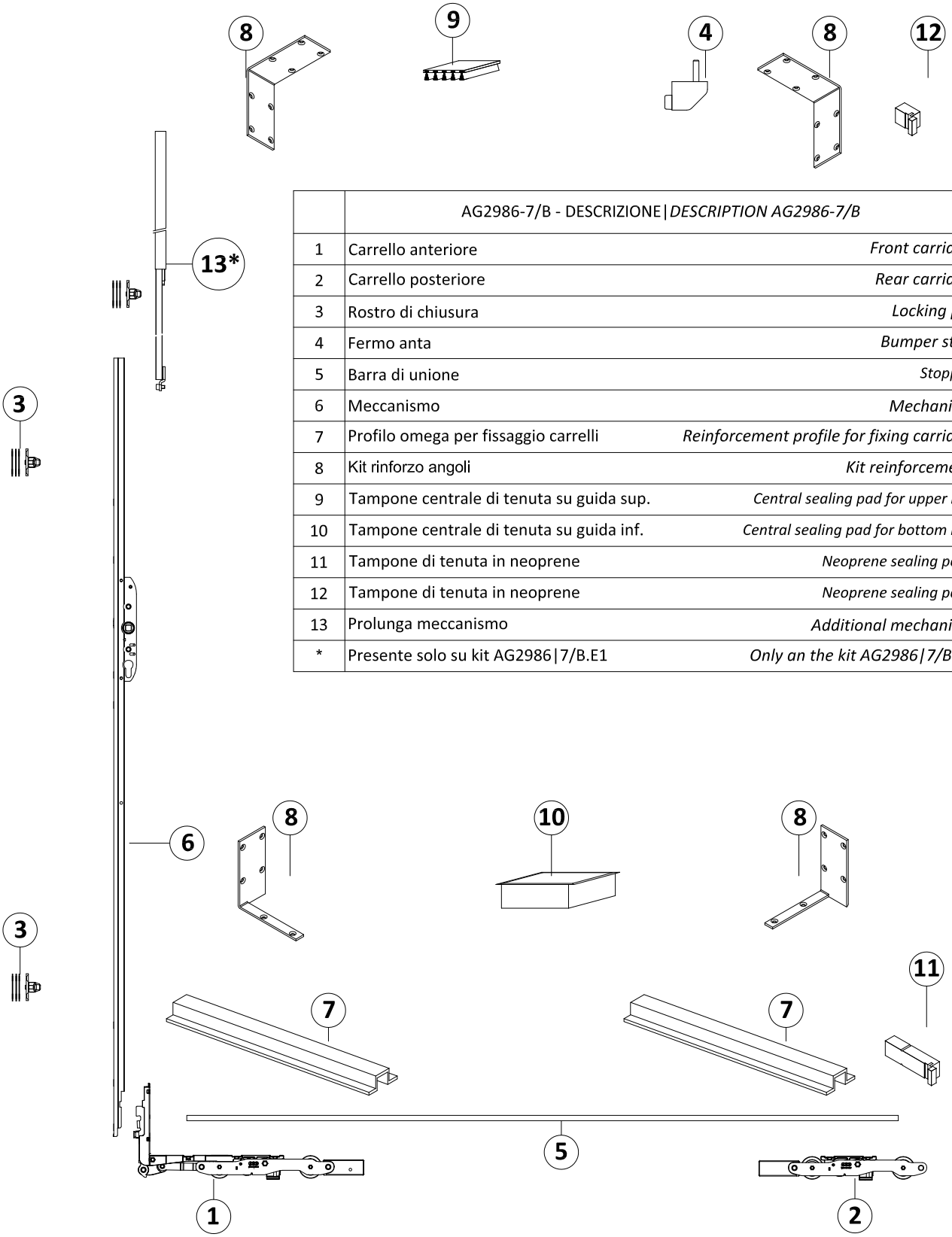




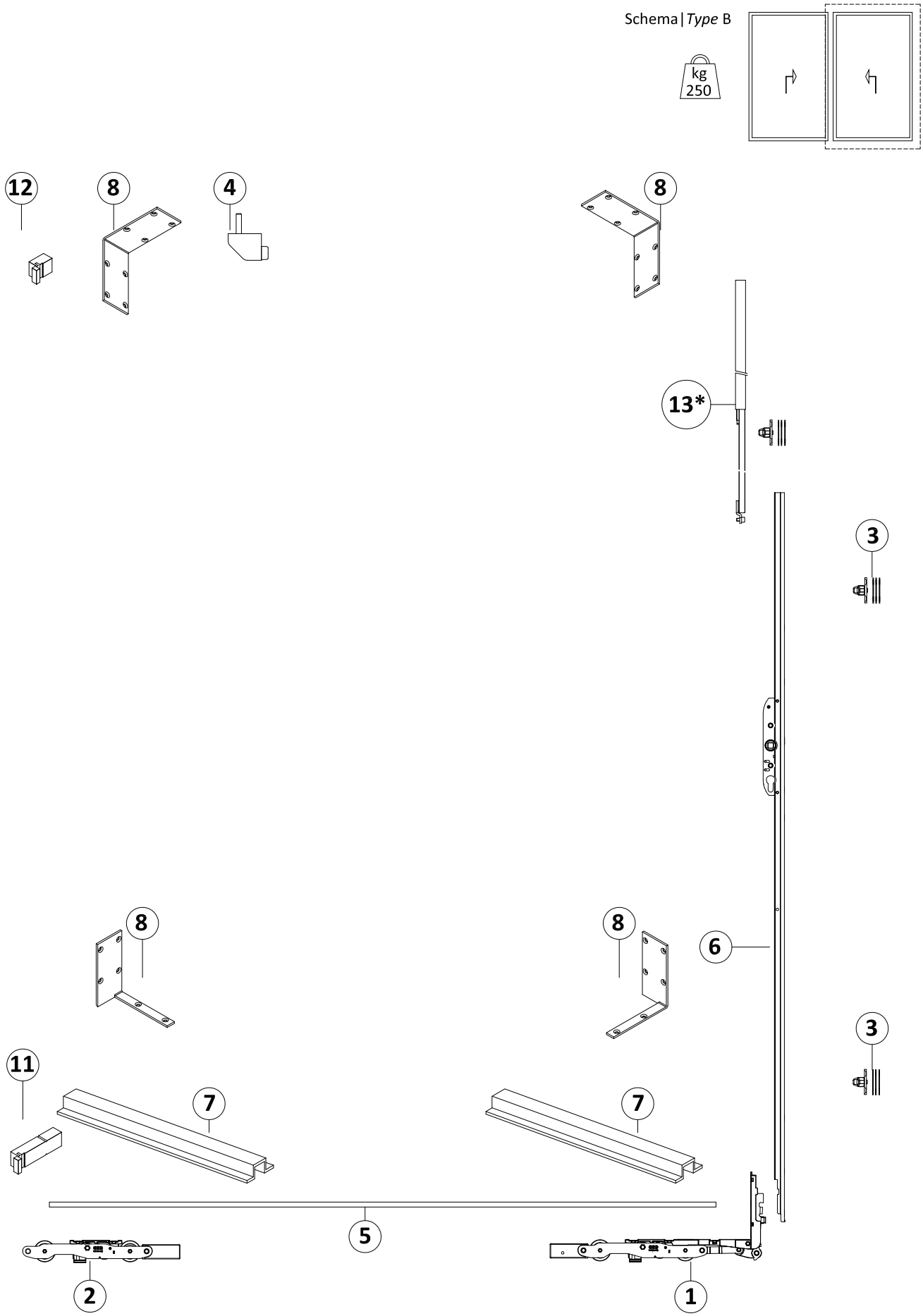
	AG2986-7/A - DESCRIZIONE|*DESCRIPTION AG2986-7/A*	
1	Carrello anteriore	*Front carriage*
2	Carrello posteriore	*Rear carriage*
3	Rostro di chiusura	*Locking pin*
4	Fermo anta	*Bumper stop*
5	Barra di unione	*Stopper*
6	Meccanismo	*Mechanism*
7	Profilo omega per fissaggio carrelli	*Reinforcement profile 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 an the kit AG2986|7/A.E1*

Schema|*Type* B

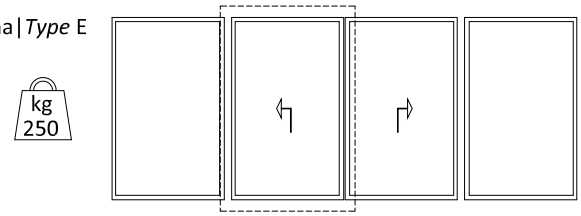


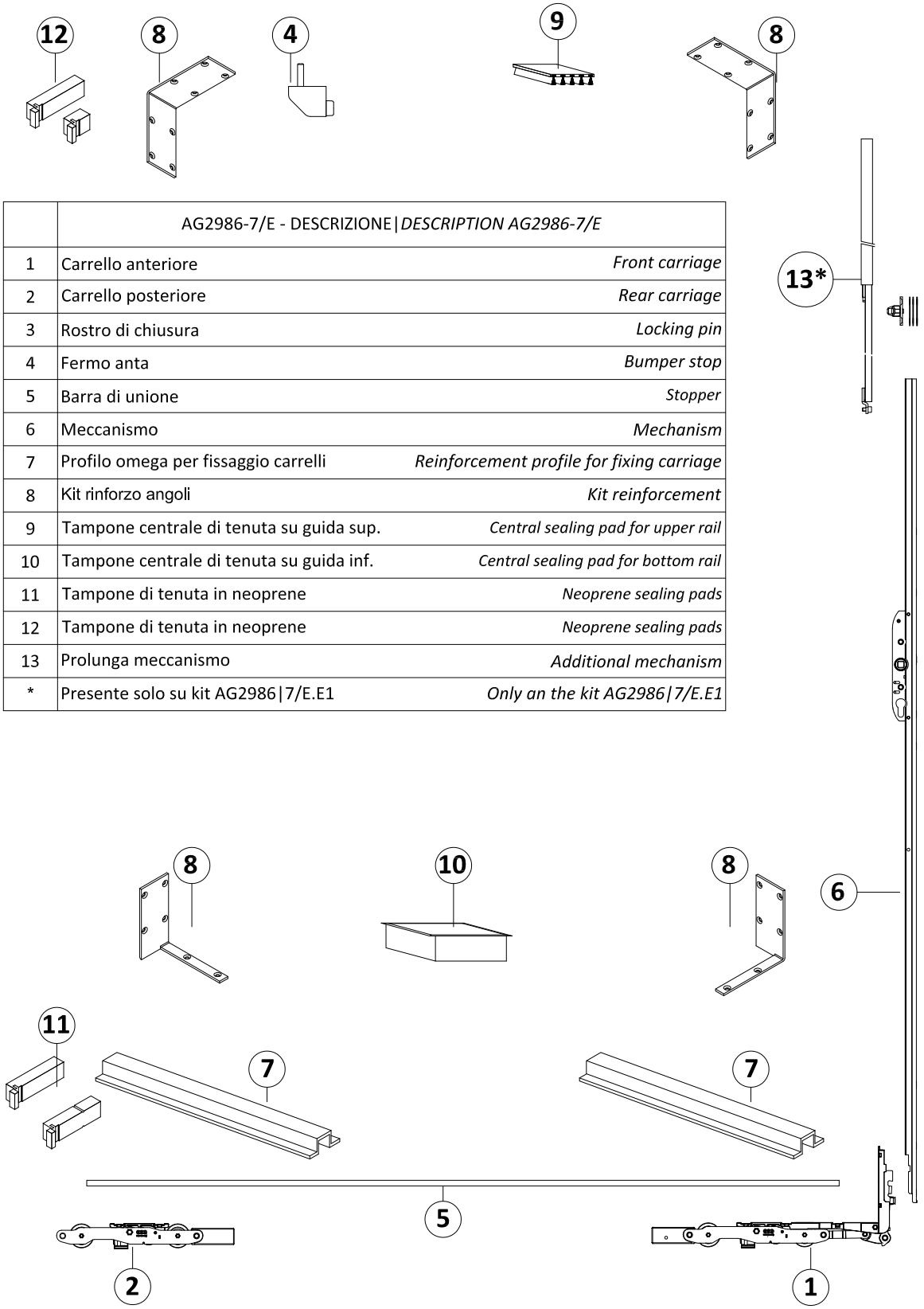


	AG2986-7/B - DESCRIZIONE|*DESCRIPTION AG2986-7/B*	
1	Carrello anteriore	*Front carriage*
2	Carrello posteriore	*Rear carriage*
3	Rostro di chiusura	*Locking pin*
4	Fermo anta	*Bumper stop*
5	Barra di unione	*Stopper*
6	Meccanismo	*Mechanism*
7	Profilo omega per fissaggio carrelli	*Reinforcement profile 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 an the kit AG2986|7/B.E1*


Schema | *Type* B
kg
250
12
8
4
8
13*
3
8
8
6
3
11
7
7
5
2
1

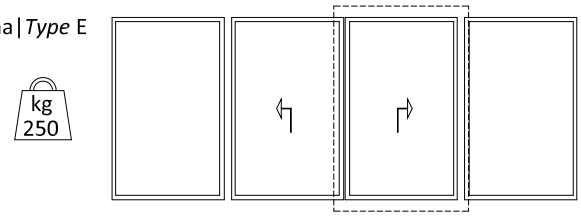
Schema|*Type* E

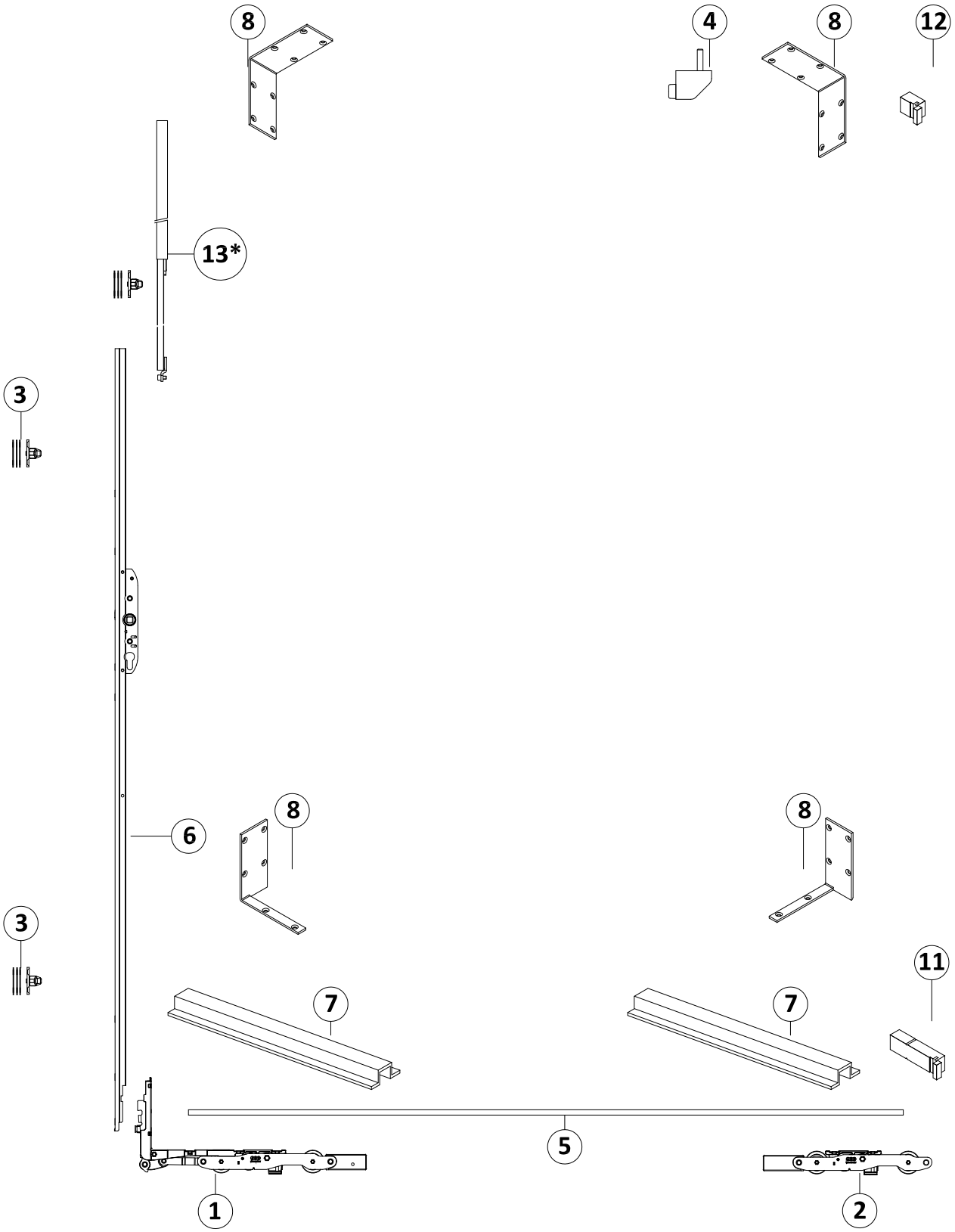




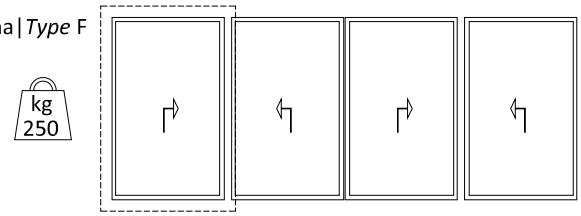
	AG2986-7/E - DESCRIZIONE|*DESCRIPTION AG2986-7/E*	
1	Carrello anteriore	*Front carriage*
2	Carrello posteriore	*Rear carriage*
3	Rostro di chiusura	*Locking pin*
4	Fermo anta	*Bumper stop*
5	Barra di unione	*Stopper*
6	Meccanismo	*Mechanism*
7	Profilo omega per fissaggio carrelli	*Reinforcement profile 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/E.E1	*Only an the kit AG2986|7/E.E1*

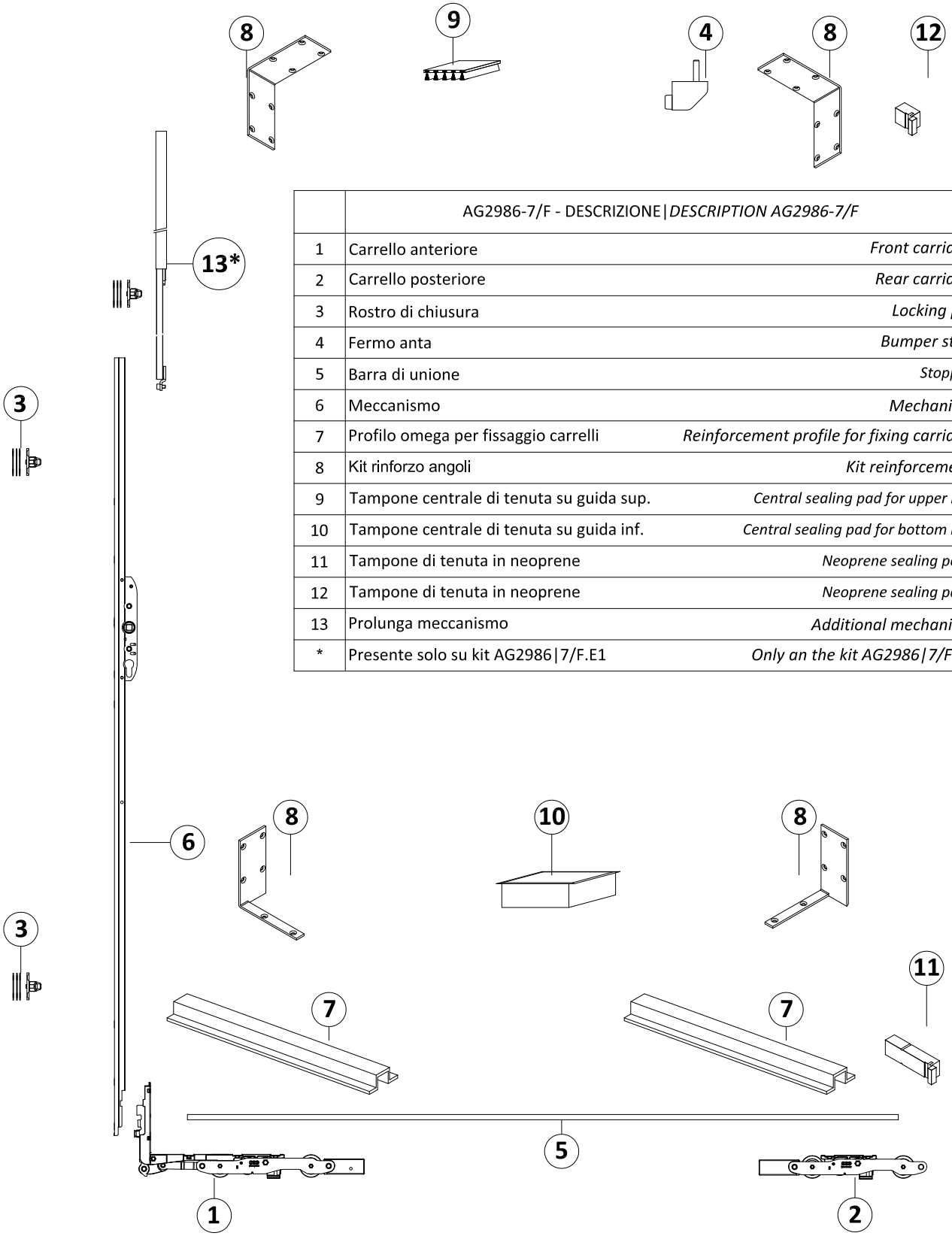
Schema | *Type* E





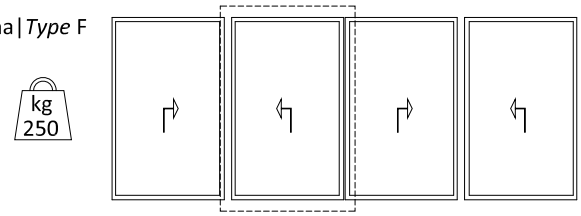
Schema|*Type* F

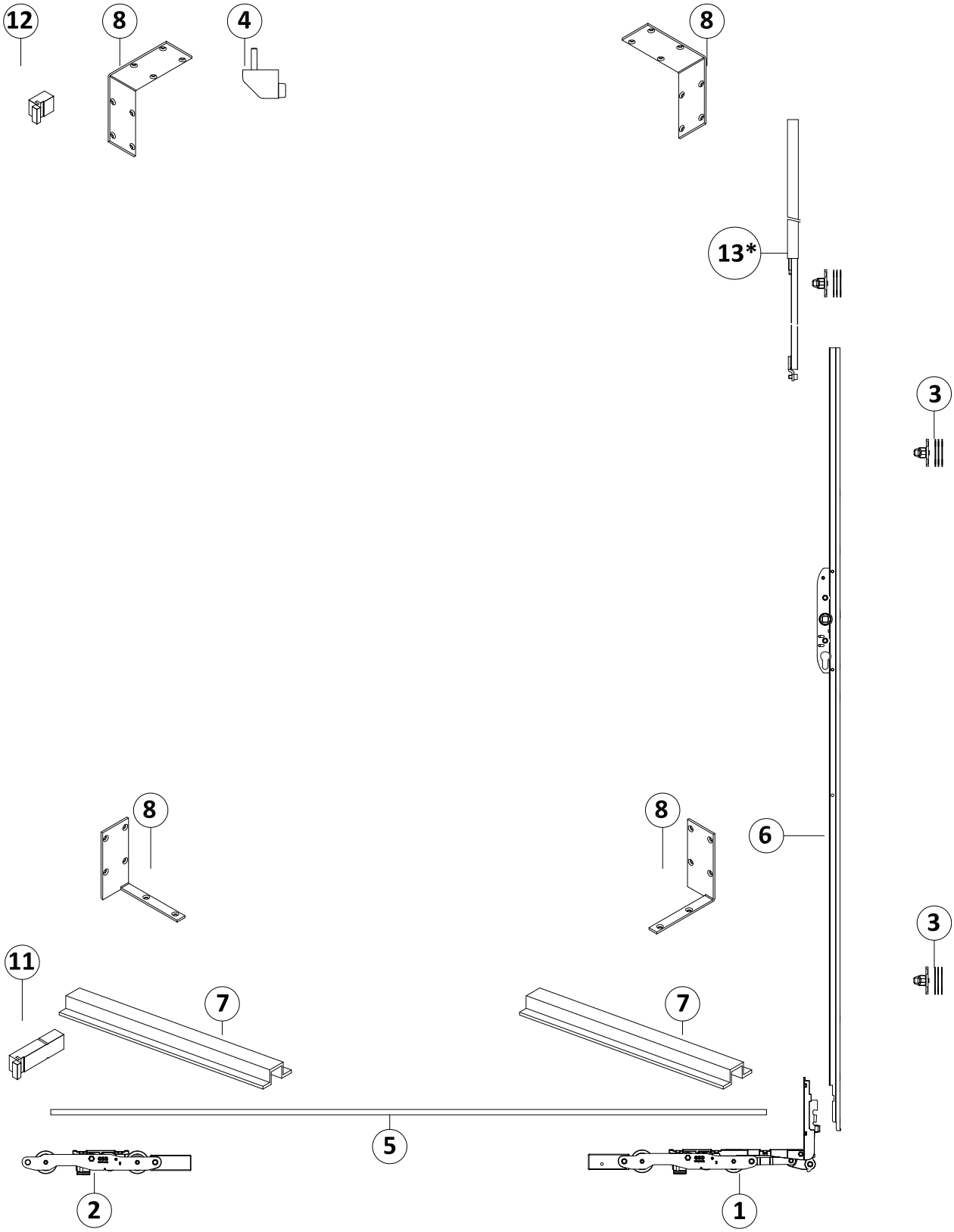




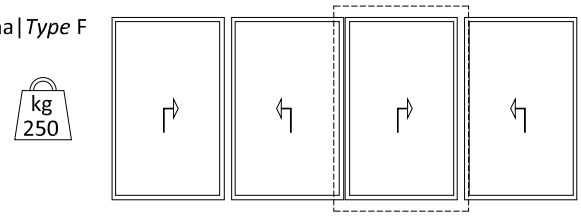
	AG2986-7/F - DESCRIZIONE|*DESCRIPTION AG2986-7/F*	
1	Carrello anteriore	*Front carriage*
2	Carrello posteriore	*Rear carriage*
3	Rostro di chiusura	*Locking pin*
4	Fermo anta	*Bumper stop*
5	Barra di unione	*Stopper*
6	Meccanismo	*Mechanism*
7	Profilo omega per fissaggio carrelli	*Reinforcement profile 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 an the kit AG2986|7/F.E1*

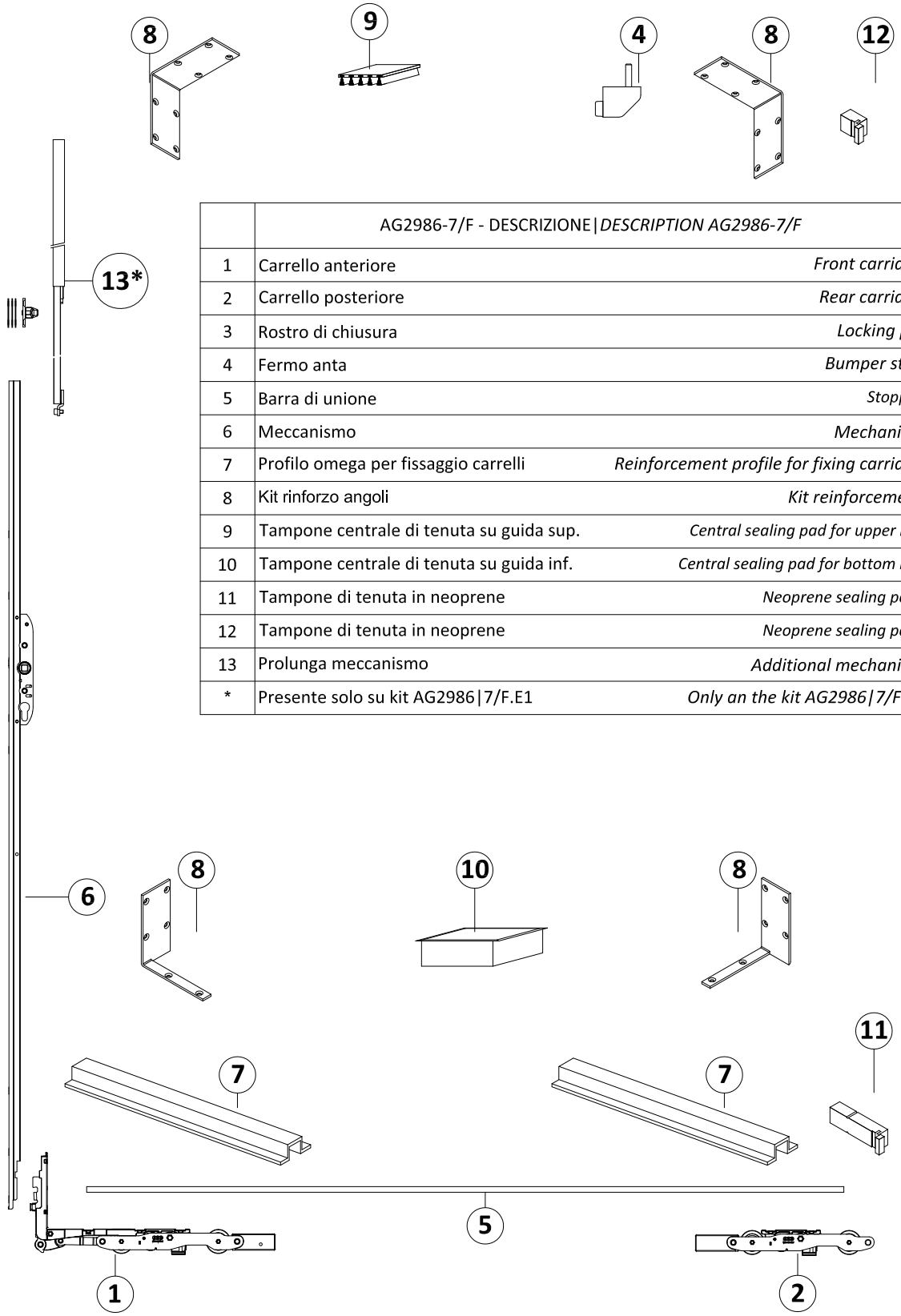
Schema | *Type* F





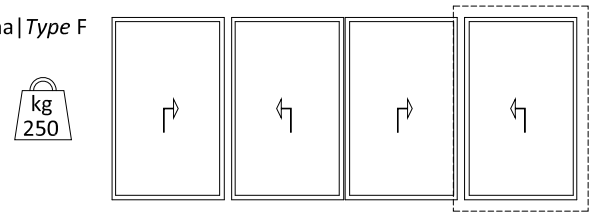
Schema|*Type* F

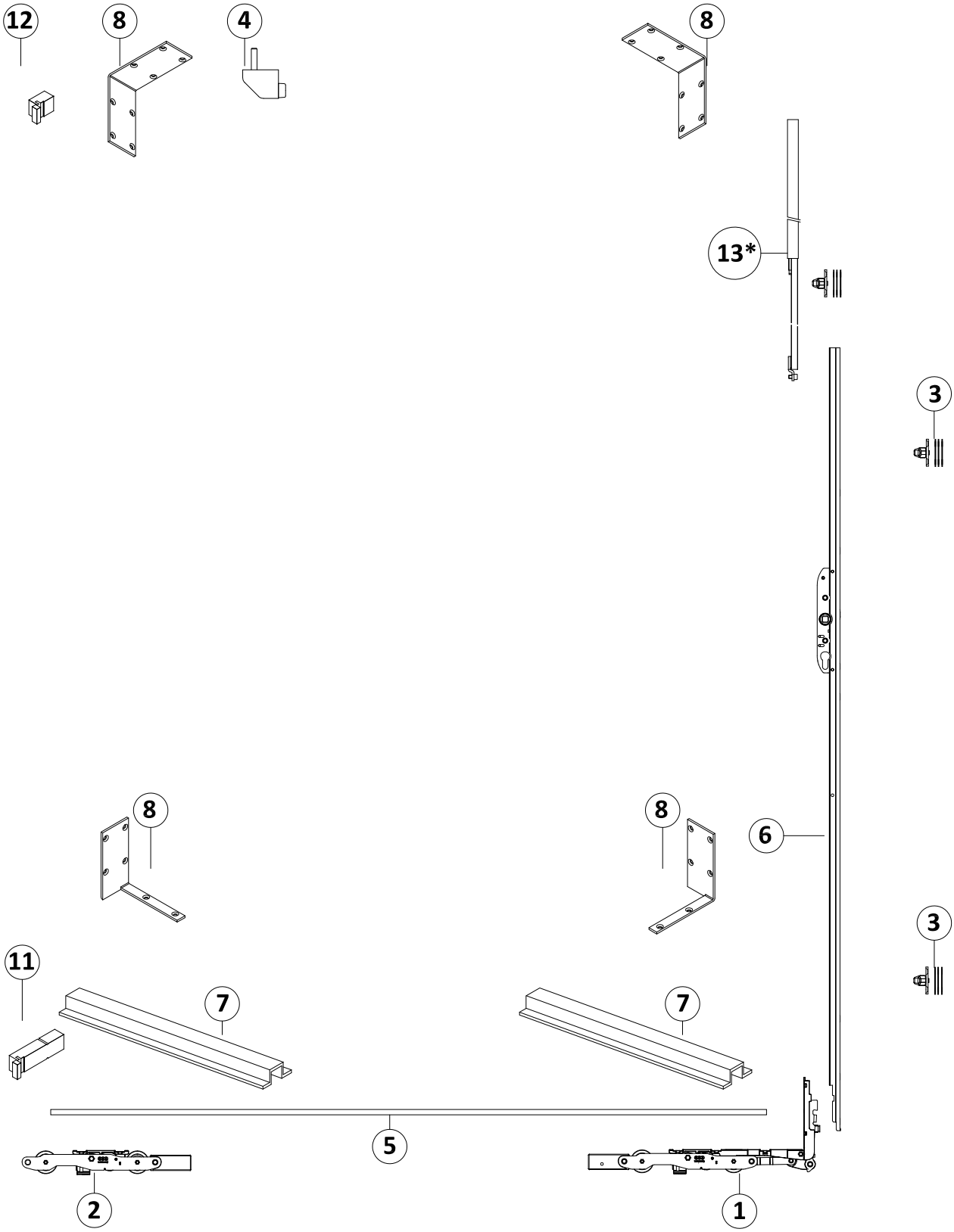




	AG2986-7/F - DESCRIZIONE|*DESCRIPTION AG2986-7/F*	
1	Carrello anteriore	*Front carriage*
2	Carrello posteriore	*Rear carriage*
3	Rostro di chiusura	*Locking pin*
4	Fermo anta	*Bumper stop*
5	Barra di unione	*Stopper*
6	Meccanismo	*Mechanism*
7	Profilo omega per fissaggio carrelli	*Reinforcement profile 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 an the kit AG2986|7/F.E1*

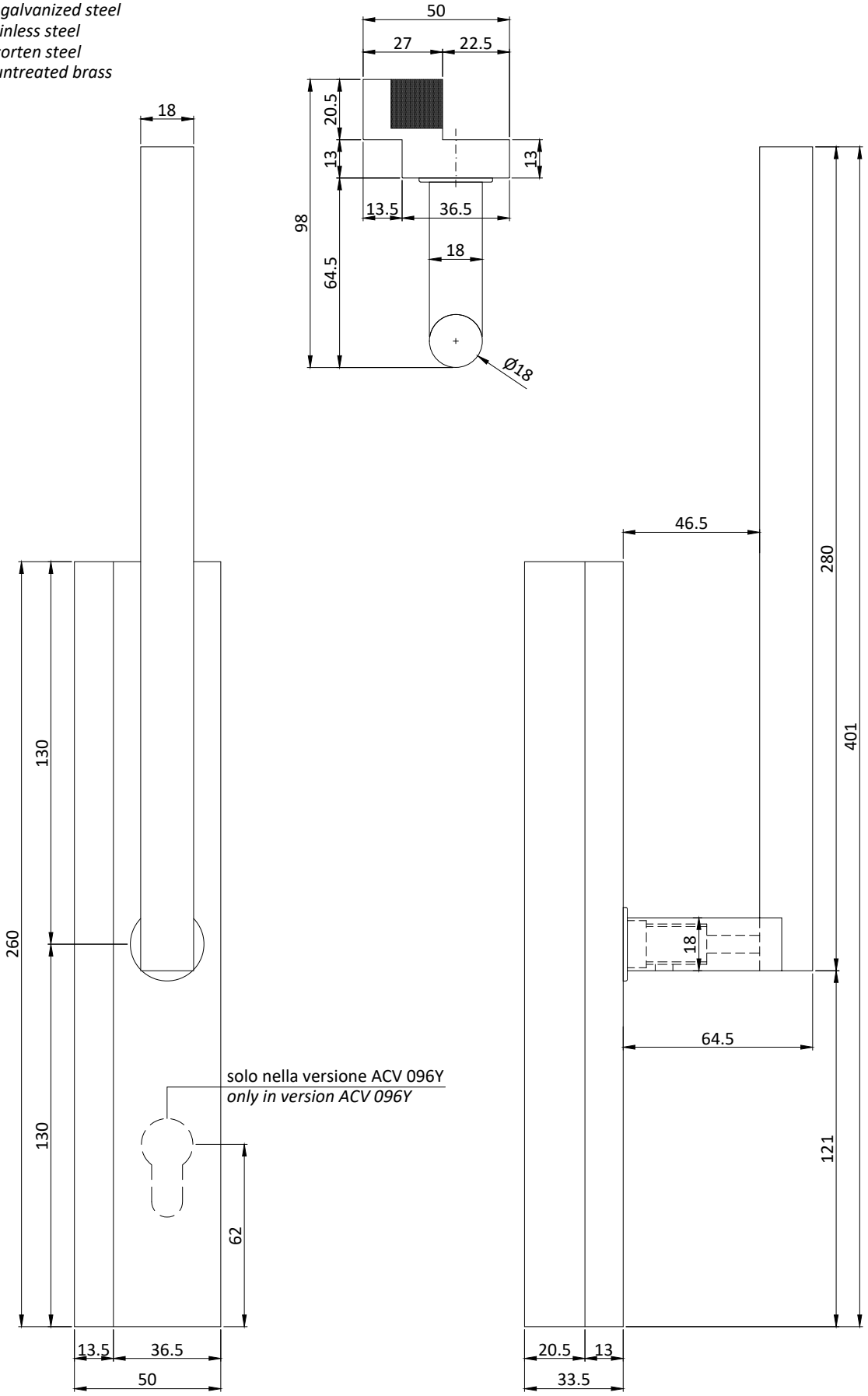
Schema | *Type* F





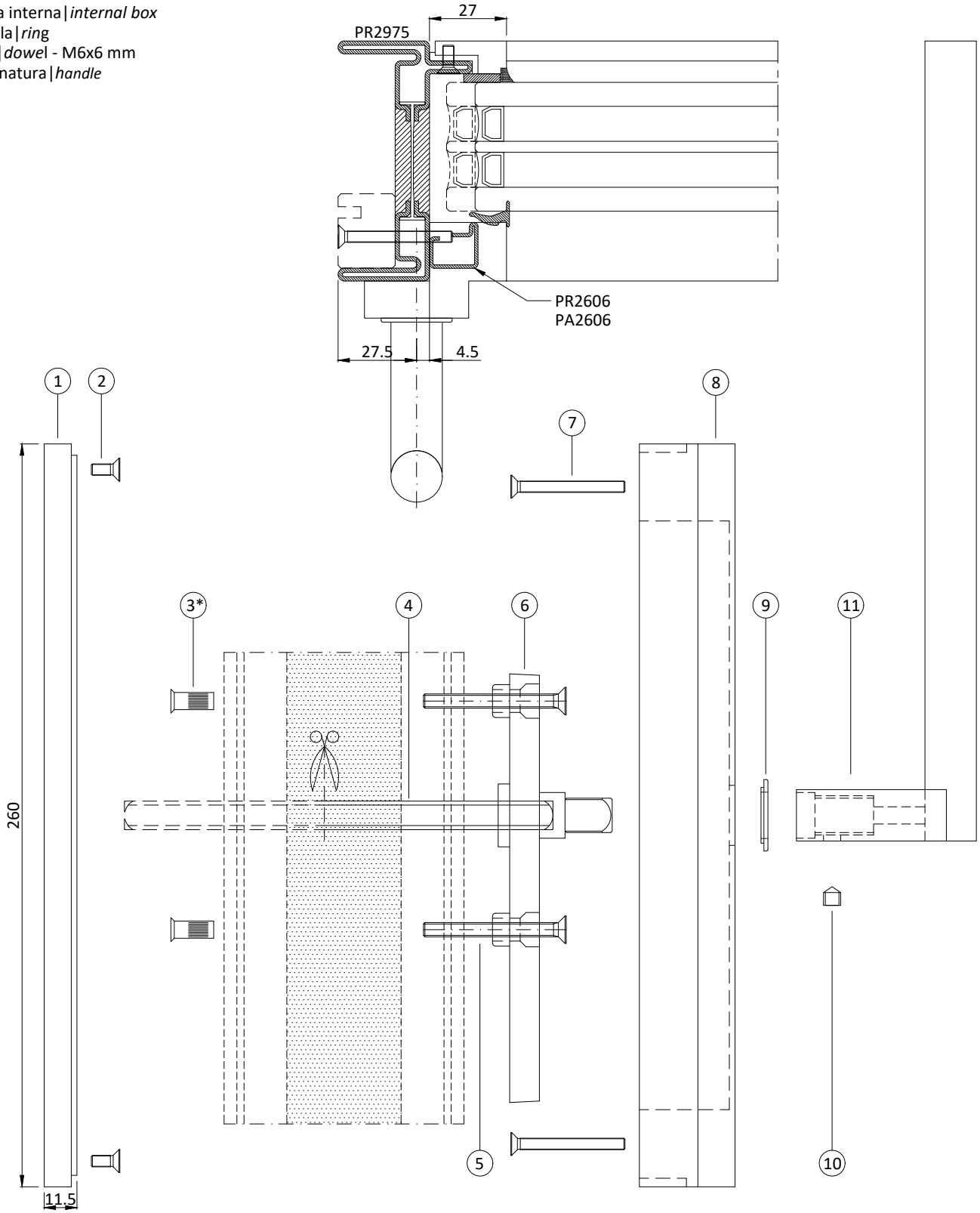
ACV 096 - ACV 096 Y finiture|*finishing*

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



ACV096 - ACV096Y componenti|*components*

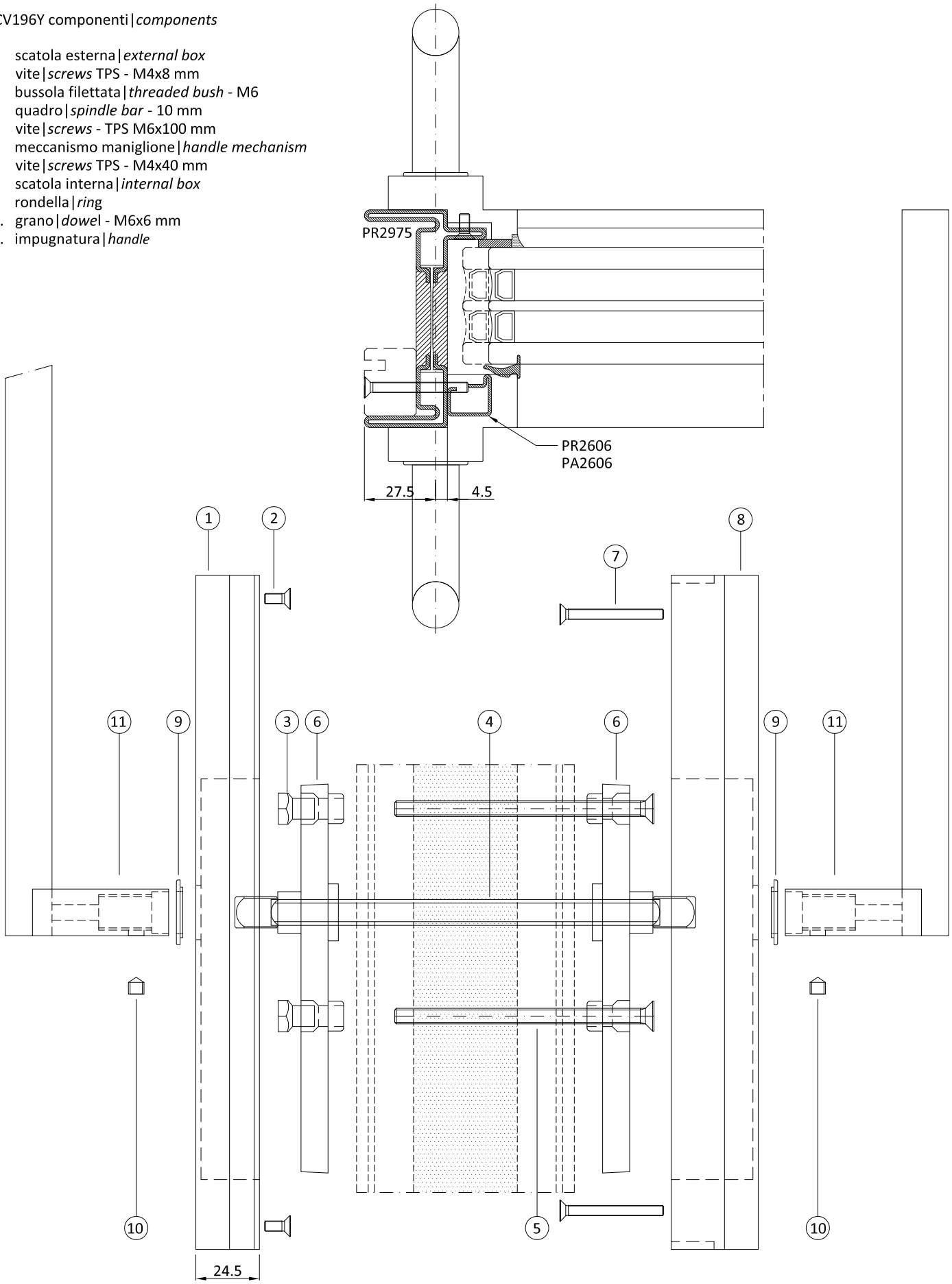
1. piatto esterno|*external plate*
2. vite|*screws* TPS - M4x8 mm
3. rivetto filettato|*threaded rivet* - M5
4. quadro|*spindle bar* - 10 mm
5. vite|*screws* - TPS M5x50 mm
6. meccanismo maniglione|*handle mechanism*
7. vite|*screws* TPS - M4x40 mm
8. scatola interna|*internal box*
9. rondella|*ring*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



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

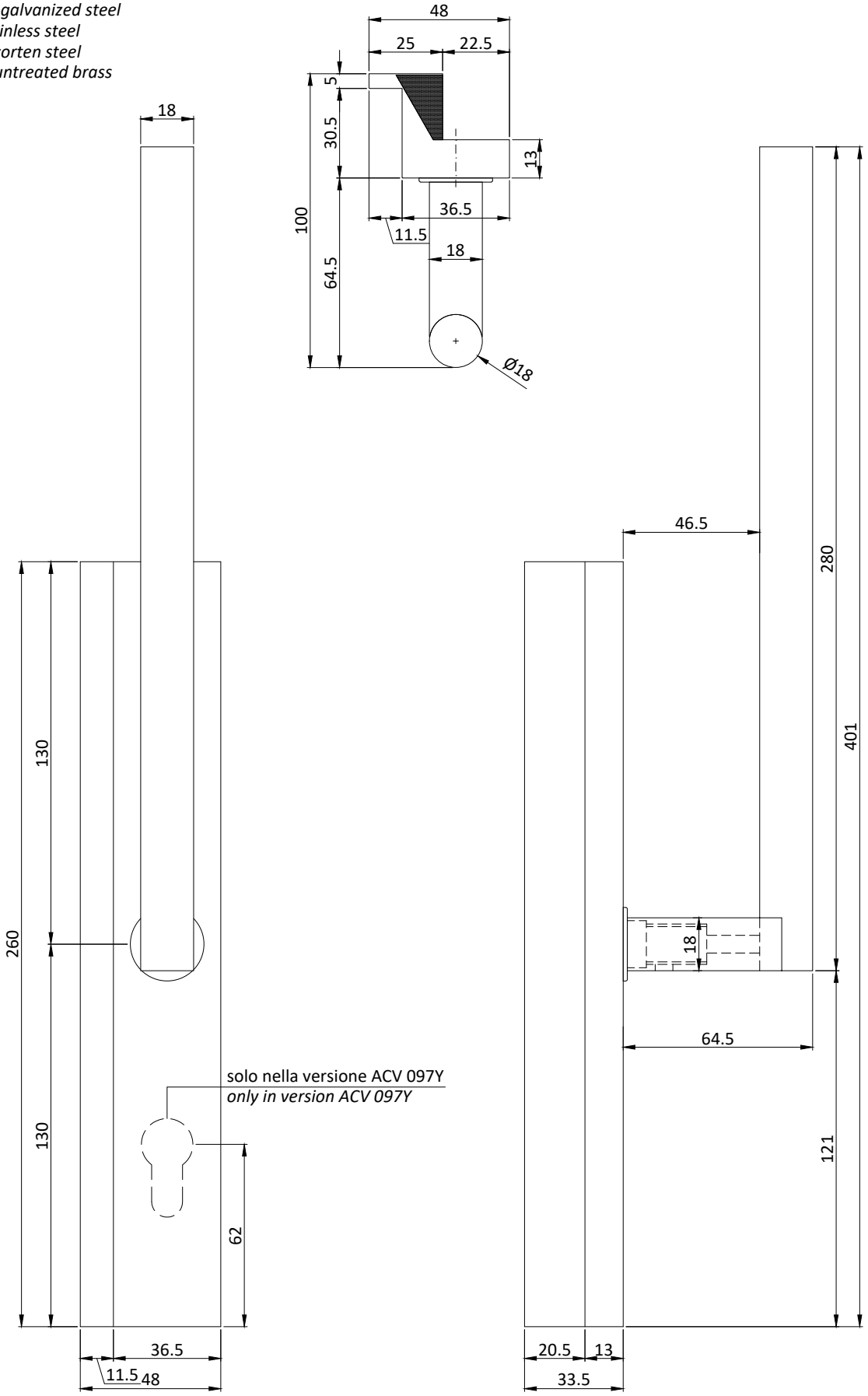
ACV196Y componenti|*components*

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*



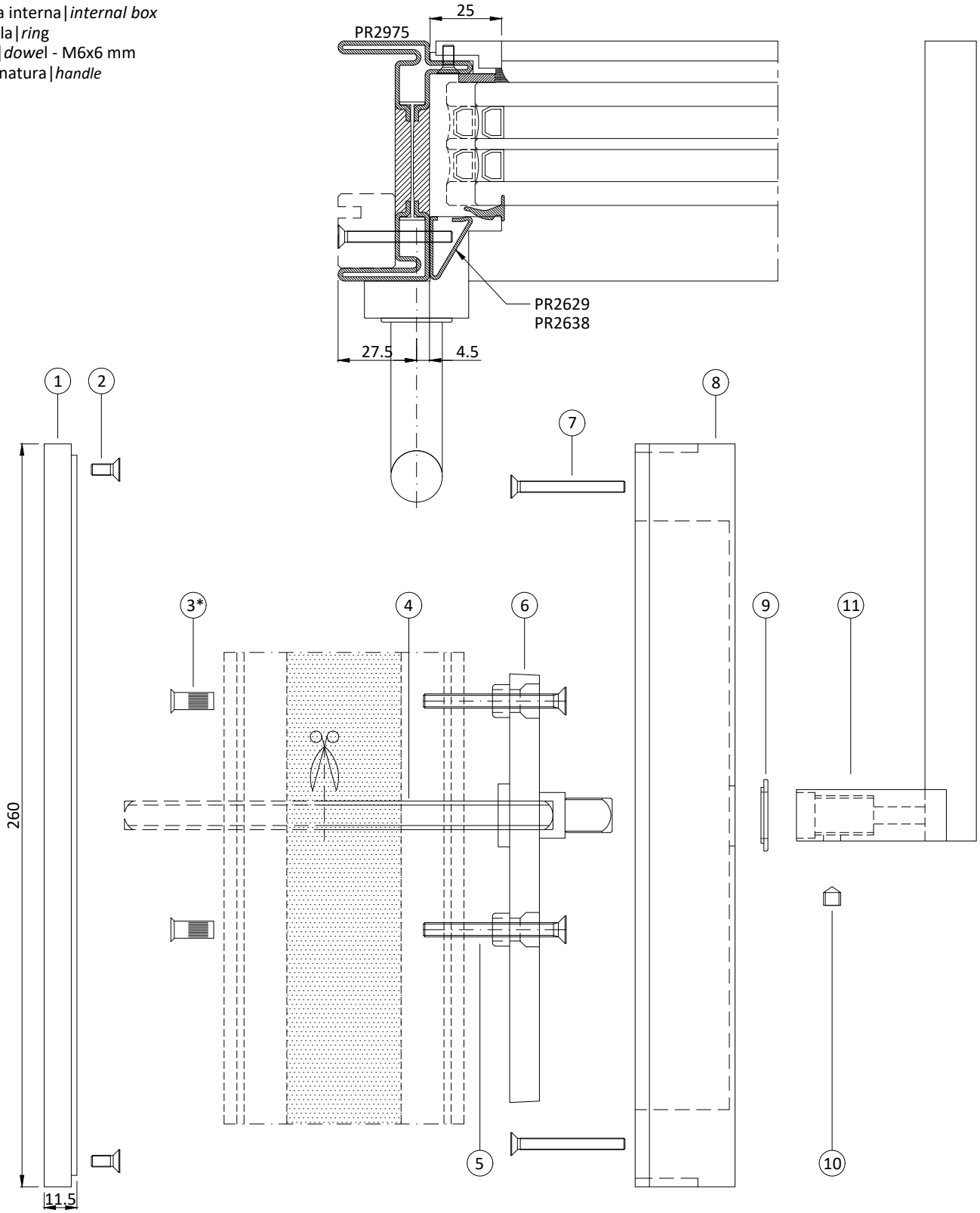
ACV 097 - ACV 097 Y finiture|*finishing*

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



ACV097 - ACV097Y componenti|*components*

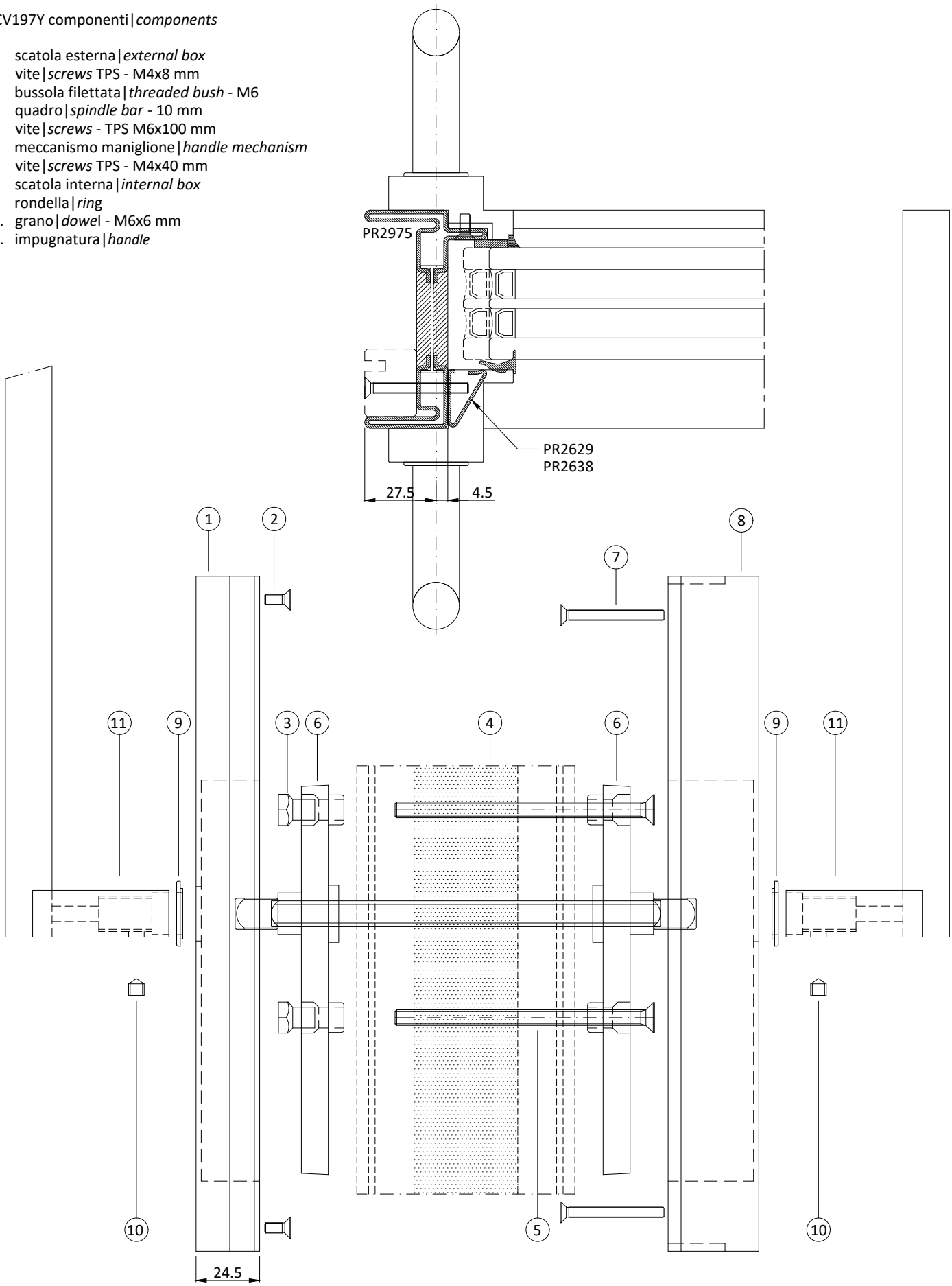
1. piatto esterno|*external plate*
2. vite|*screws* TPS - M4x8 mm
3. rivetto filettato|*threaded rivet* - M5
4. quadro|*spindle bar* - 10 mm
5. vite|*screws* - TPS M5x50 mm
6. meccanismo maniglione|*handle mechanism*
7. vite|*screws* TPS - M4x40 mm
8. scatola interna|*internal box*
9. rondella|*ring*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



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

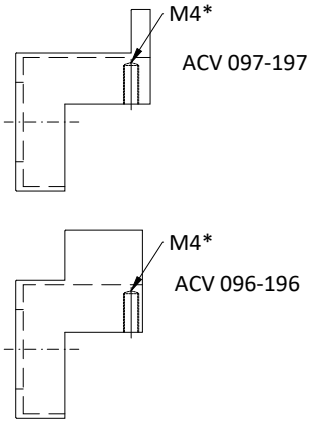
ACV197Y componenti|*components*

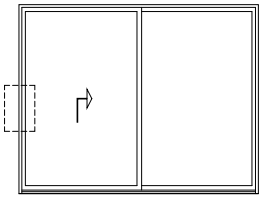
1. scatola esterna|*external box*
2. vite|*screws* TPS - M4x8 mm
3. bussola filettata|*threaded bush* - M6
4. quadro|*spindle bar* - 10 mm
5. vite|*screws* - TPS M6x100 mm
6. meccanismo maniglione|*handle mechanism*
7. vite|*screws* TPS - M4x40 mm
8. scatola interna|*internal box*
9. rondella|*ring*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

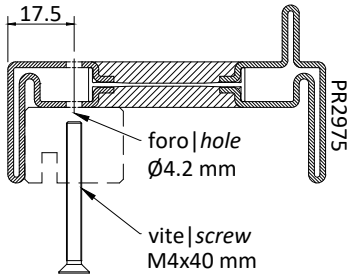


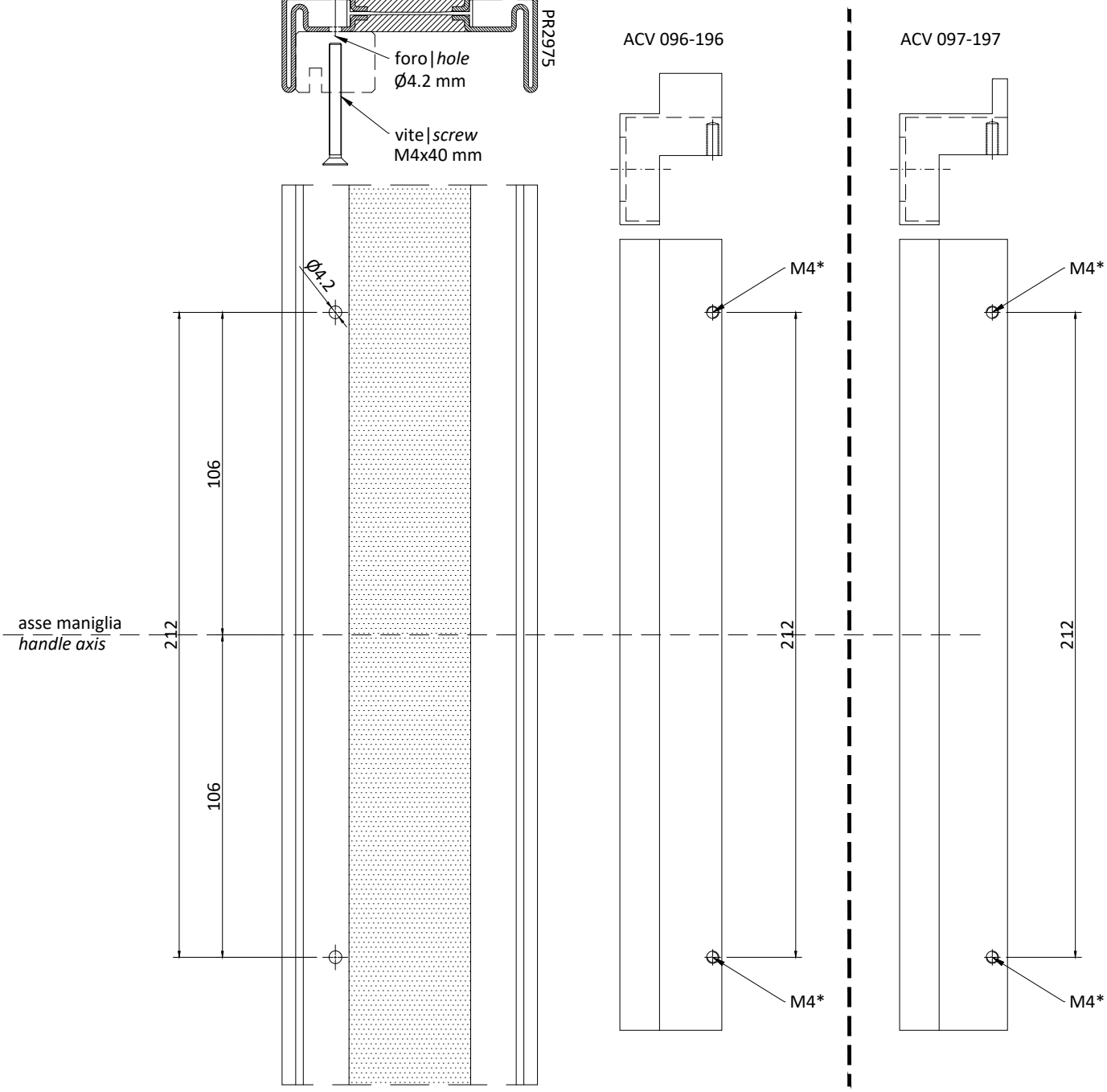
1 - forare Ø4.2 mm il profilo PR2975
2 - allineare correttamente la scatola interna
3 - tracciare i fori del profilo PR2975 sulla scatola interna
4 - forare M4, prestando attenzione a non forare passante

1 - drill Ø4.2 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





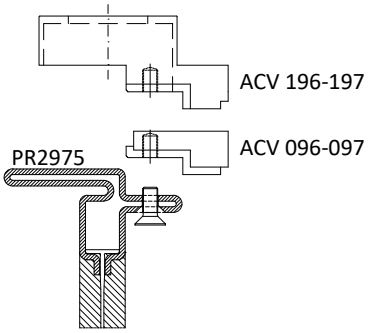


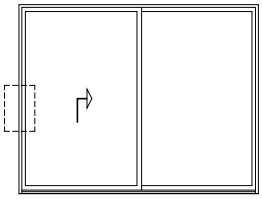


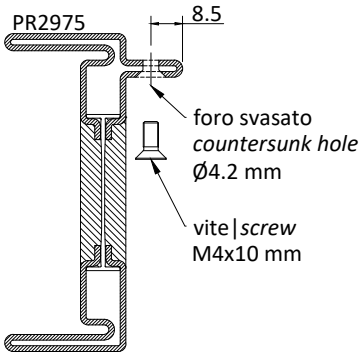
* prestare particolare attenzione ai punti 3-4
* *pay more attention to points 3-4*

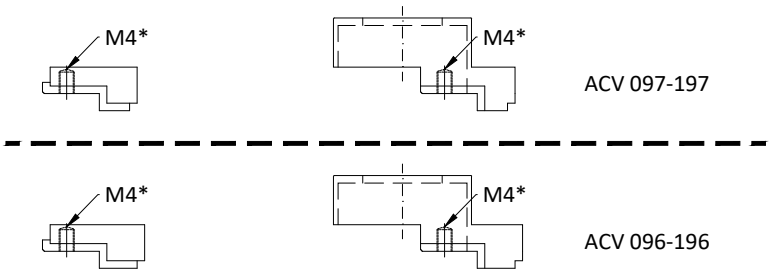
1 - forare Ø4.2 mm il profilo PR2975
2 - allineare correttamente il piatto/scatola esterna
3 - tracciare i fori del profilo PR2975 su piatto/scatola esterna
4 - forare M4, prestando attenzione a non forare passante

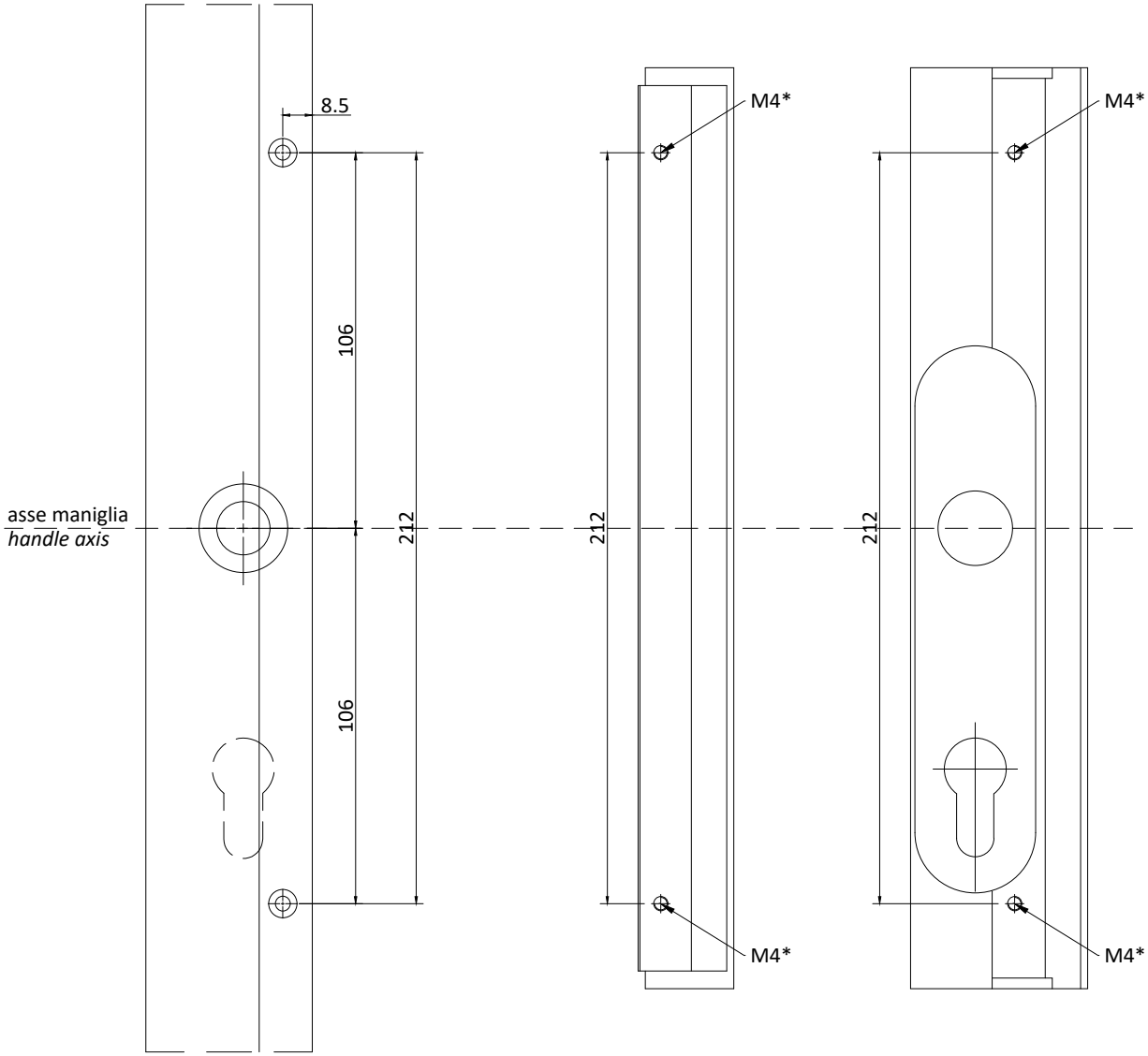
1 - drill Ø4.2 mm the profile PR2975
2 - Align the outer plate/box correctly
3 - mark the holes of the profile PR2975 on the external plate/box
4 - Drill M4, be careful not to drill through it



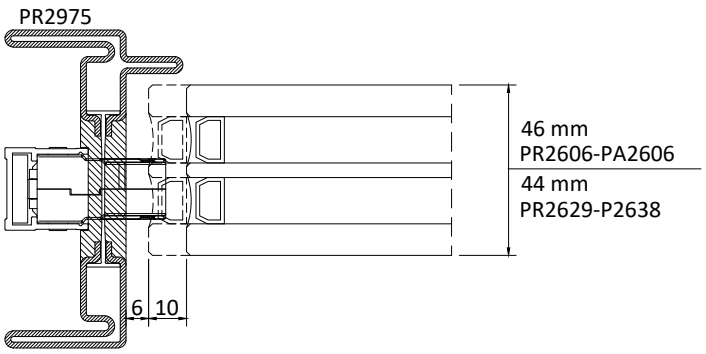


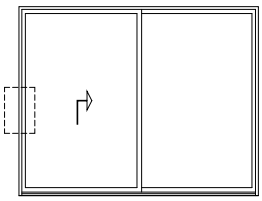


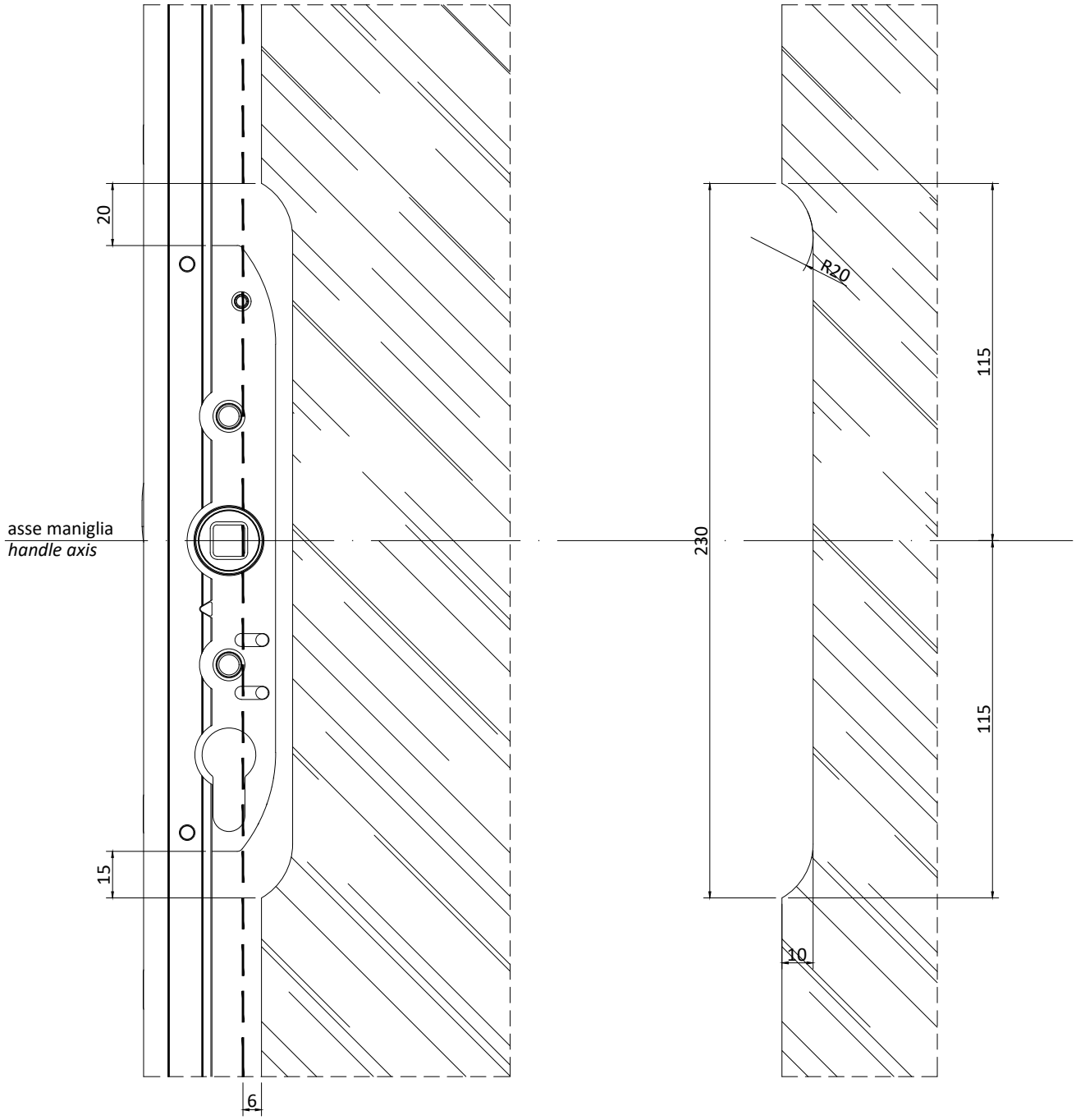




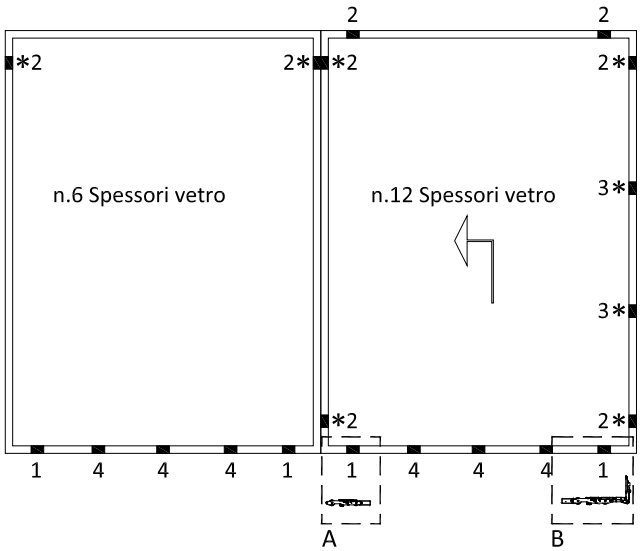
* prestare particolare attenzione ai punti 3-4
* *pay more attention to points 3-4*


PR2975
46 mm
PR2606-PA2606
44 mm
PR2629-P2638
6
10

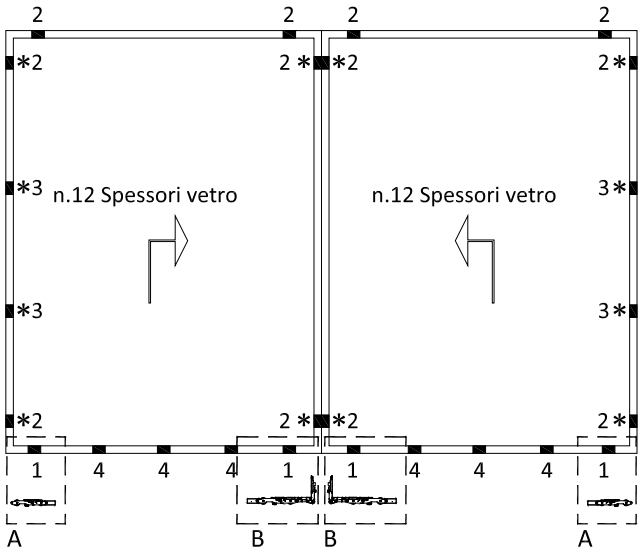



20
asse maniglia
handle axis
15
6
R20
115
230
115
10

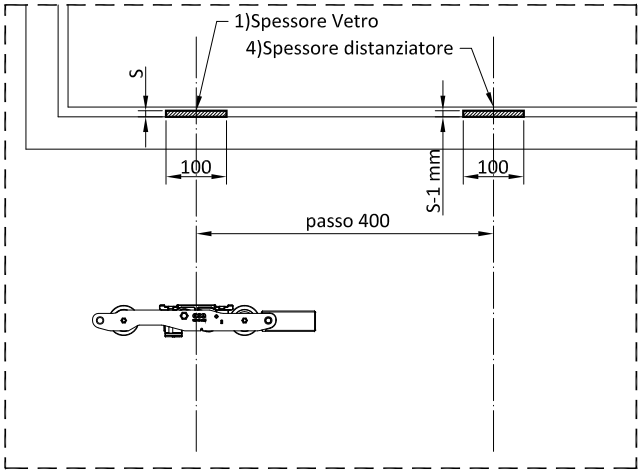
1 ANTA SCORREVOLE ED 1 ANTA FISSA
1 SLIDING AND 1 FIXED SASH



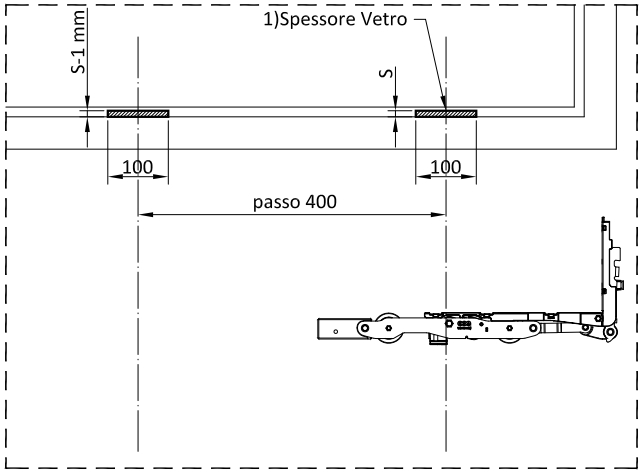
2 ANTE SCORREVOLI
2 SLIDING SASHES

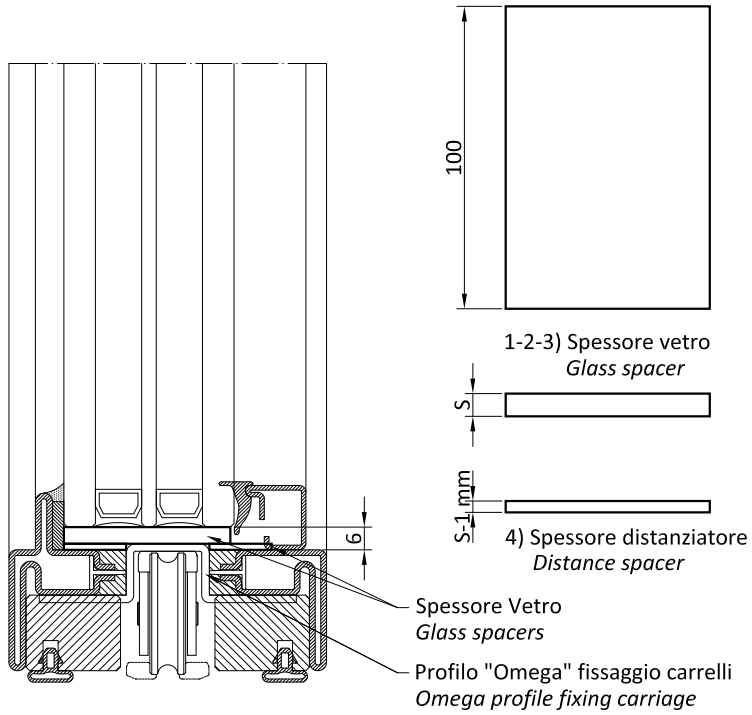


PARTICOLARE "A"
PARTICULAR "A"



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'istallazione 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 del 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.

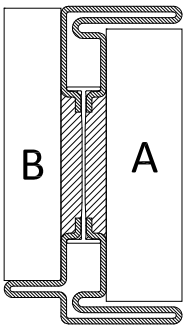
Cut / Processing
OS2 75 AS profiles in galvanized steel, stainless steel and corten steel can be cut with normal saws, like those used for steel pipes. OS2 75 AS profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws advised 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).

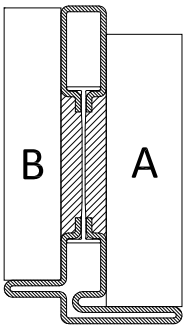
Painting/Burnishing
OS2 75 AS profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate 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.

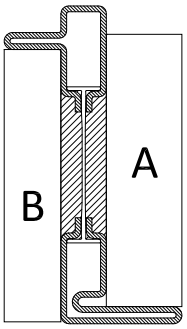
Installation
Proper installation must guarantee that the performances declared in the EC marking and verified in the lab will remain constant. It is advised to arrange a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to install. 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.



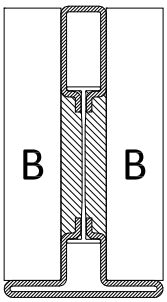
PR2975



PR2988



PR2989



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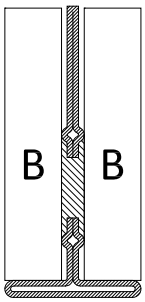

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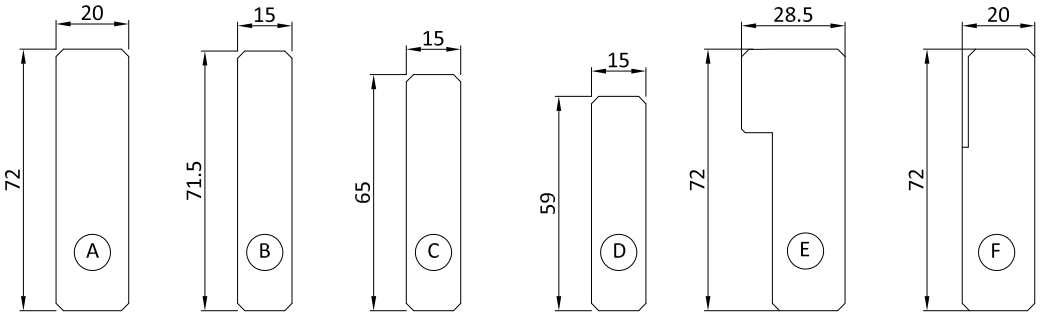
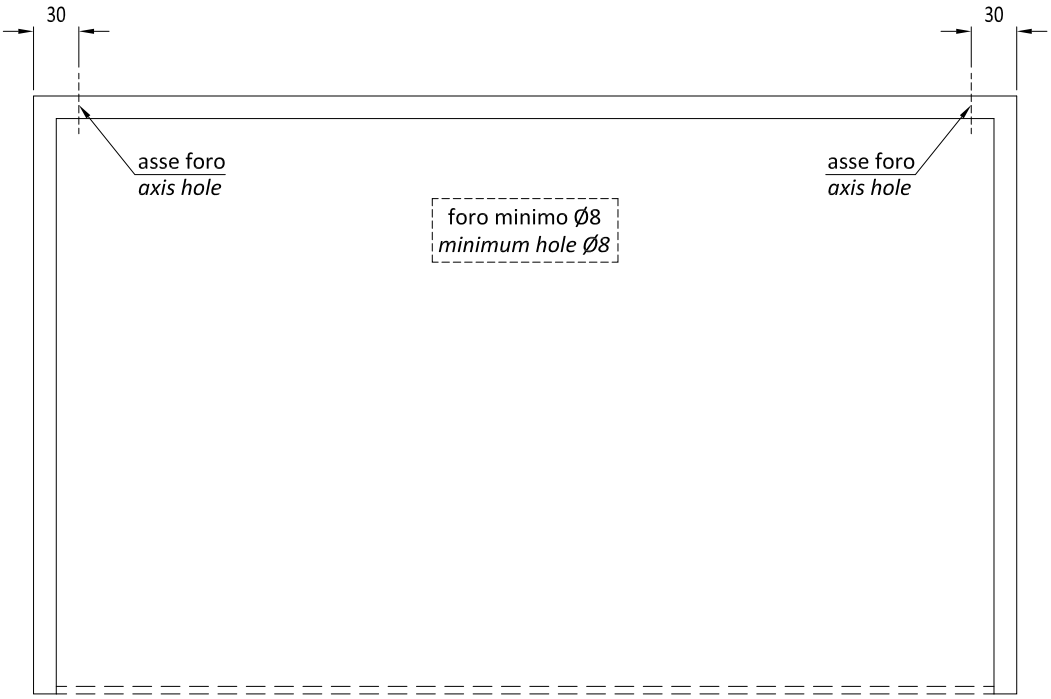
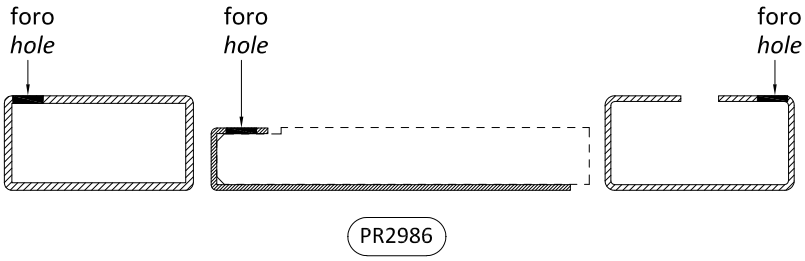


telaio | *frame*

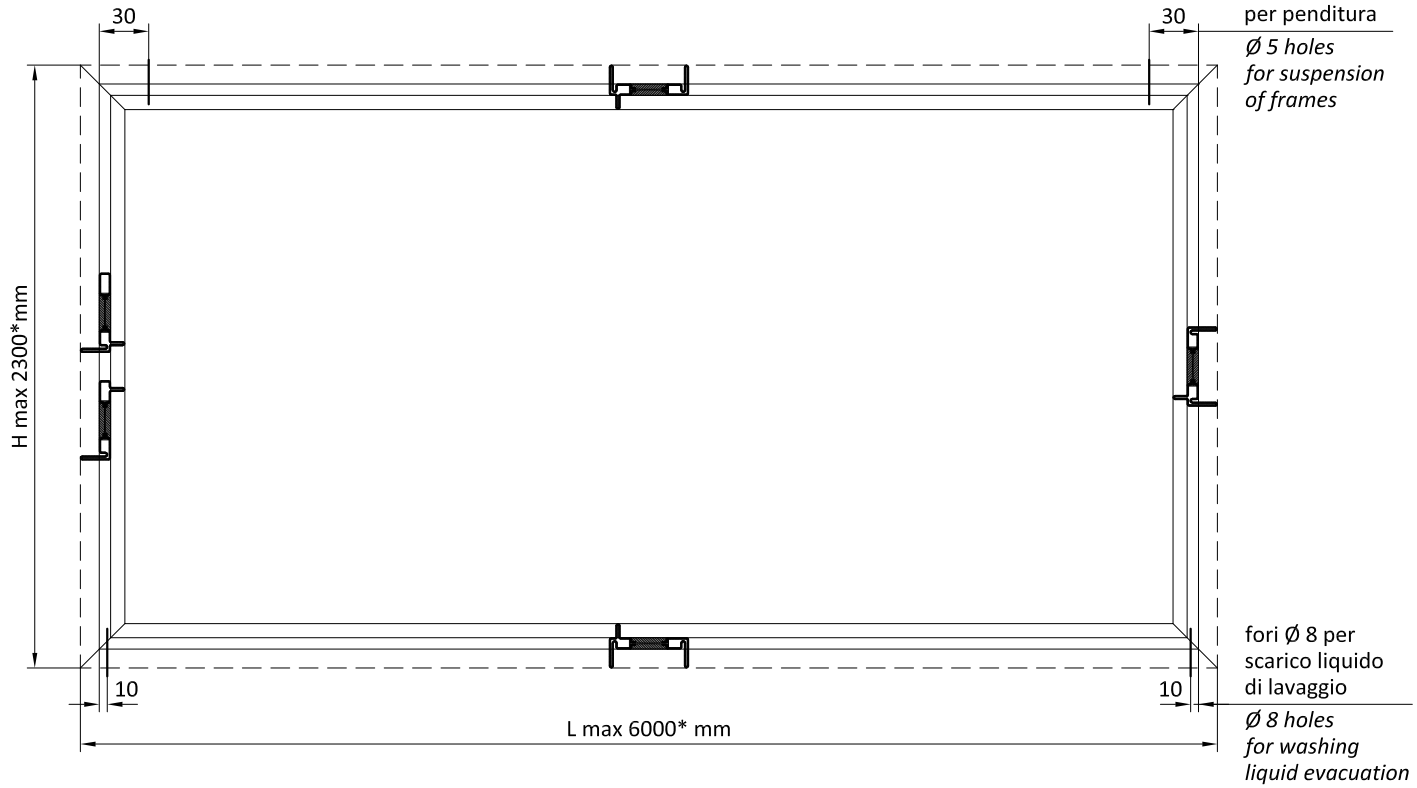


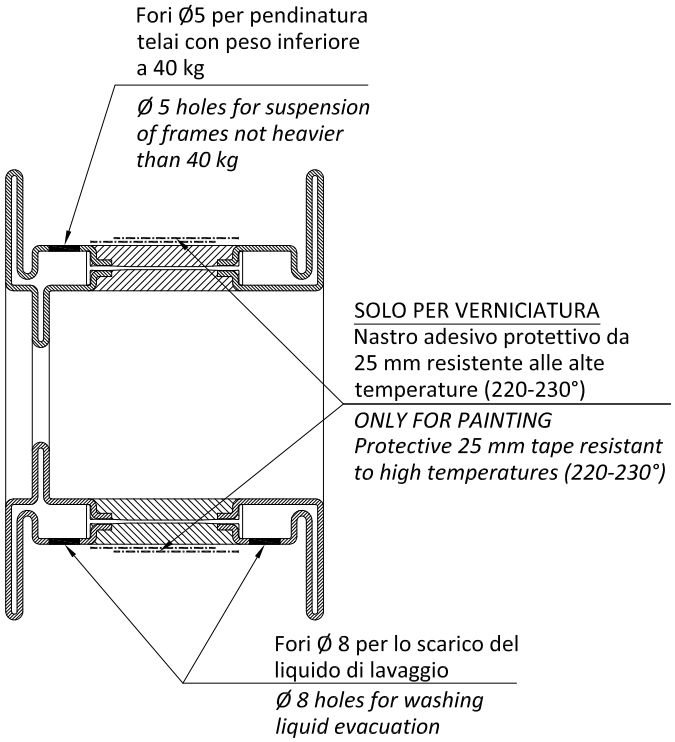
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto

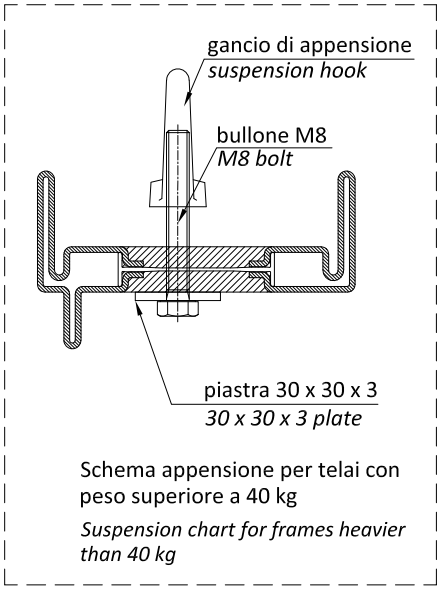
N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

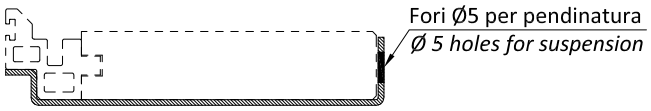


anta | *sash*









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*

Troncatrice

caratteristiche 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);
- Capacita 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.

Pantografo

caratteristiche 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.

Forature

montaggio 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.

Cutter

Minimum 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.

Phantograph

Minimum 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.

Drilling

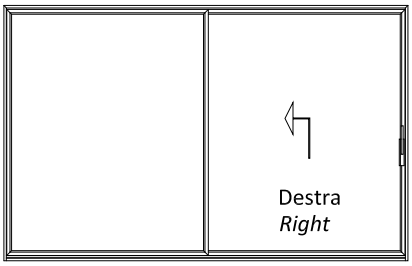
How to mount closing and moving components on a stainless steel profile

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

Milling slots and loops in the profiles

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

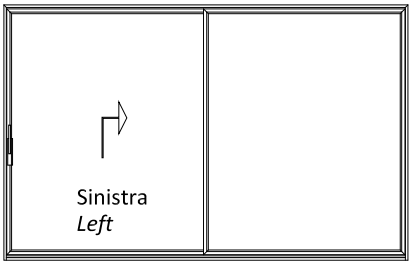
Schema | *Type* A 1 anta scorrevole ed 1 anta fissa
1 sliding and 1 fixed sash



vista interna | *inside view*

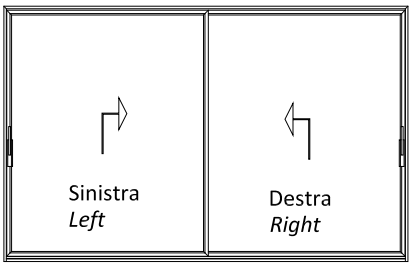
Codice	*Code*	Descrizione	*Description*
AG 2986A		Kit movimentazione e tenuta 1 anta apribile *1 leaf handling and sealing kit*	
ACV 096 - 097		Maniglione singolo *Single handle*	
ACV 096Y.D - 097Y.D		Maniglione singolo con cilindro *Single handle with hole cilinder*	
ACV 196Y.D - 197Y.D		Maniglione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

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



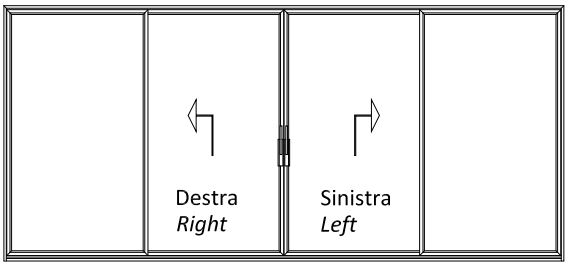
Codice	*Code*	Descrizione	*Description*
AG 2987A		Kit movimentazione e tenuta 1 anta apribile *1 leaf handling and sealing kit*	
ACV 096 - 097		Maniglione singolo *Single handle*	
ACV 096Y.S - 097Y.S		Maniglione singolo con cilindro *Single handle with hole cilinder*	
ACV 196Y.S - 197Y.S		Maniglione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

Schema | *Type* B 2 ante scorrevoli
2 sliding sashes



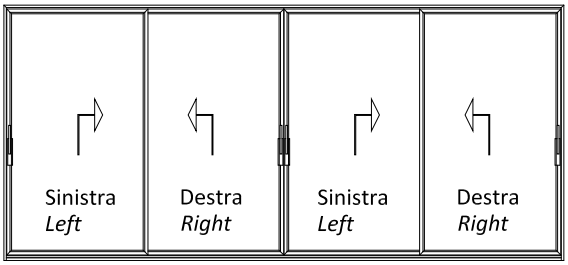
Codice	*Code*	Descrizione	*Description*
AG 2986B - AG 2987B		Kit movimentazione e tenuta 2 ante apribili *2 leaf handling and sealing kit*	
ACV 096 - 097		Maniglione singolo *Single handle*	
ACV 096Y.D-S - 097Y.D-S		Maniglione singolo con cilindro *Single handle with hole cilinder*	
ACV 196Y.D-S - 197Y.D-S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

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

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

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

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

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

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 Scoth 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/m^2 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 in made through several processes: degreasing, pickling an washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat in 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 relieveing and then mirror-like polished.

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