OS2 75 L

CATALOGO TECNICO

TECHNICAL CATALOGUE

versione 07/2022

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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione in vista 62 mm (nodo laterale, nodo centrale e nodo superiore), idoneo per la realizzazione di serramenti con apertura a libro con apertura verso l'interno o verso l'esterno.

I profili in metallo componenti il sistema sono dello spessore di 15/10 mm e sono ottenuti tramite profilatura a freddo di nastri nei vari materiali previsti dal sistema.

Il taglio termico dei profili è realizzato tramite un estruso in poliammide rinforzato con fibra di vetro reso solidale alle parti in metallo esterne da una resina poliuretanica ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce la massima resistenza torsionale e flettente.

La costruzione dei telai prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto e la successiva ripresa delle superfici in vista, o l'utilizzo di un sistema misto ad assiemaggio meccanico a saldatura interna che non necessita di riprese di finitura.

Il sistema prevede al possibilità di alloggiare **vetri singoli o stratificati** (di sicurezza) a una o più camere.

Caratteristiche del sistema:
Sormonto interno ed esterno delle ante;
Sistema a 2 livelli di tenuta con guarnizione interna ed esterna di battuta per le migliori prestazioni di tenuta all'aria e all'acqua e di isolamento acustico;
Cerniere ad avvitare negli stessi materiali del profilo per porte e per finestre;
Sistema integrato per lo scarico acqua;
Kit completo per l'apertura ad anta con ferramenta a scomparsa;
Kit per l'alloggiamento di serrature completo di scatole di copertura nei diversi materiali;
Soglia inferiore con guarnizione di battuta e spazzolino.

Thermally insulated integrated system of profiles, accessories and gaskets *with visible section of 62 mm (lateral section, upper section and central section) suitable for bi-fold door, inward or outward opening.*

The metal profiles *that make up the system are 15/10 mm thick and are obtained from the cold-forming of the coils in the various materials available.*

The profile thermal break *is connected by means of a glass-fibre reinforced, extruded polyamide that becomes one with the external metal parts with the use of a high density polyurethane resin, injected at high pressure. The connection is continuous, without interruptions, guaranteeing maximum resilience to torsional and bending stress.*

The assembly of the frames *requires that the profiles be connected by welding together the sections in contact and then that the visible welds must be ground down neatly and finished, or by combining mechanical assembly and internal welding that does not require the retouching of the finish.*

The system permits to use double or triple thermal insulated glazing with ***single or stratified glass*** *(security glass).*

Features of the system:
Surmounted internal and external design of the sections ;
System with 2 barriers of tightness with internal and external rebate gasket and for the best water, wind, air tightness and acoustic performances;
High capacity to be screwed in the same material of the profile ;
Integrated system for water drain ;
Concealed hardware for side-hung windows ;
Complete kit for lock with coverings in the same material of the profile ;
Bottom threshold with rebate gasket and brush.

PRESTAZIONI

Serramenti a libro
Trasmittanza termica (EN ISO 10077-2)
- Nodo tipo: U_f =2.50 W/m^{2}K

Resistenza all'aria (DIN EN 12207)
- Fino a Classe 4

Resistenza all'acqua (DIN EN 12208)
- Fino a Classe 5A

Resistenza al vento (DIN EN 12210)
- Fino a Classe B3

PERFORMANCES

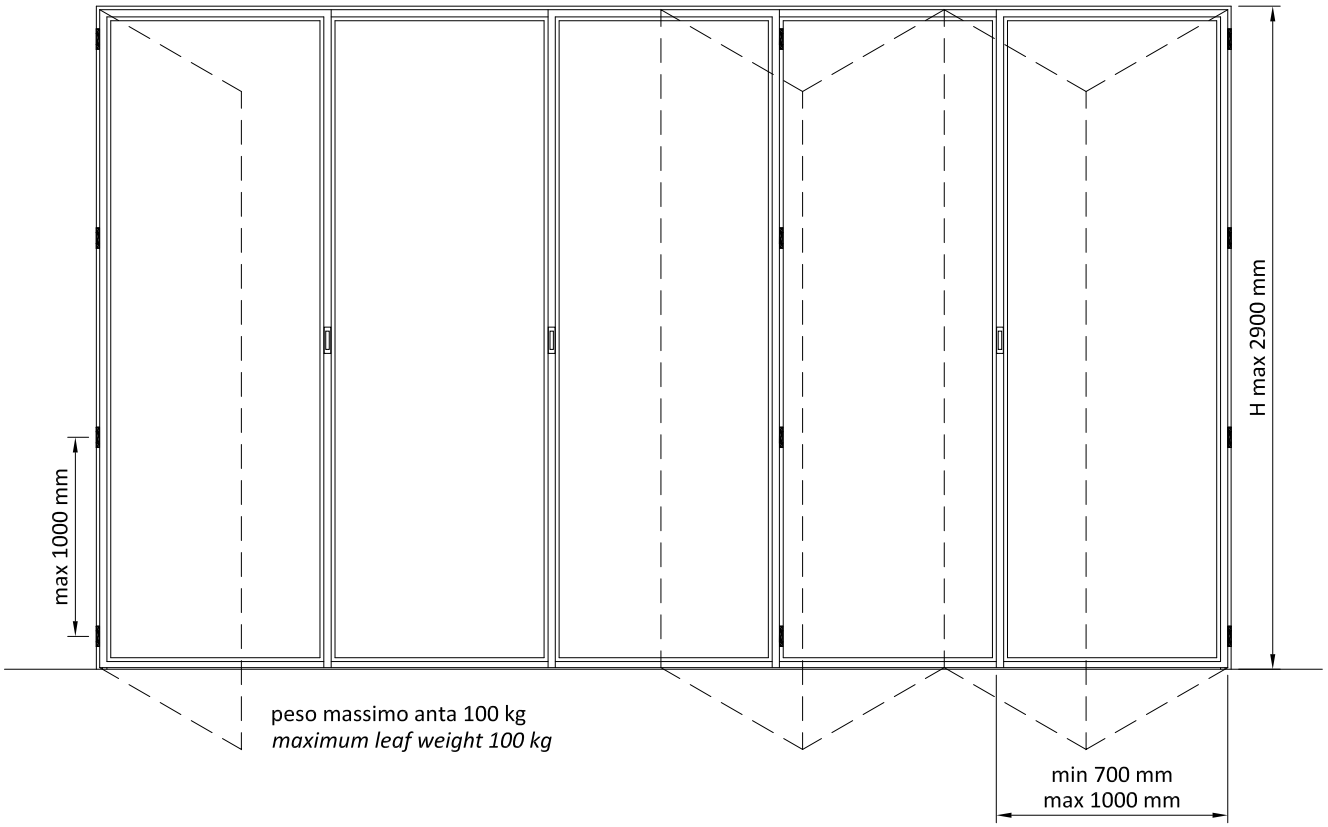
Bi-fold door
Thermal transmittance (EN ISO 10077-2)
- *Typical section: U_f =2.50 W/m^{2}K*

Air permeability (DIN EN 12207)
- *Up to Class 4*

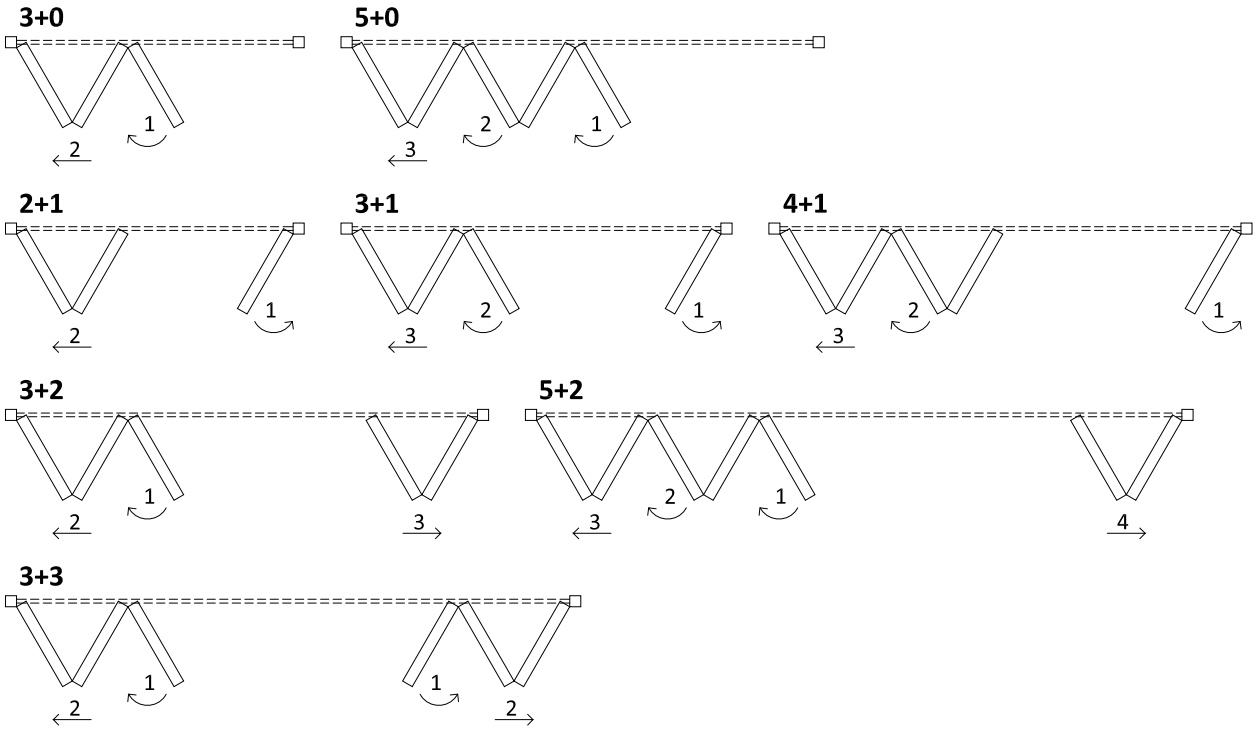
Watertightness (DIN EN 12208)
- *Up to Class 5A*

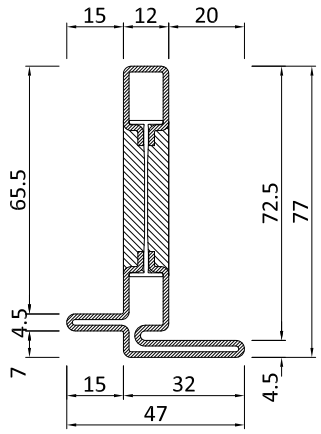
Resistance to wind load (DIN EN 12210)
- *Up to Class B3*

Limiti dimensionali - *Maximum dimension*

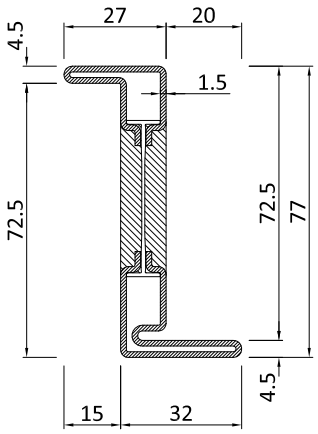


Esempi tipologie a libro realizzabili in apertura interna ed esterna
Types of bi-folding doors in inward and outward opening

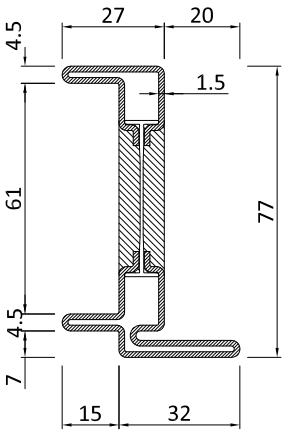




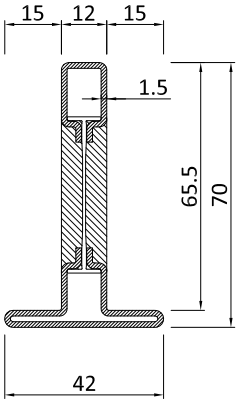
PR2962



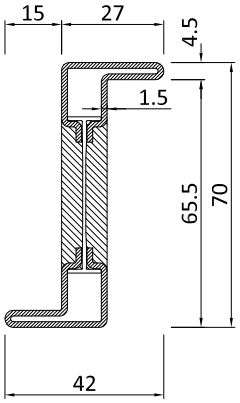
PR2963



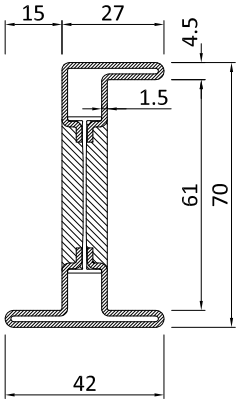
PR2965



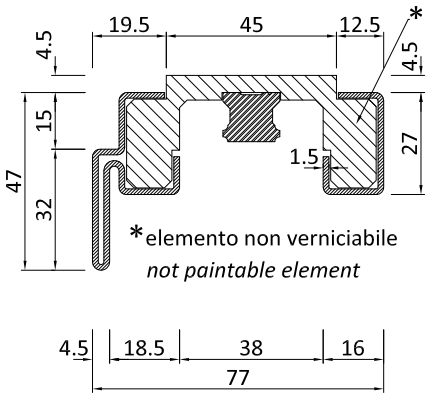
PR2972



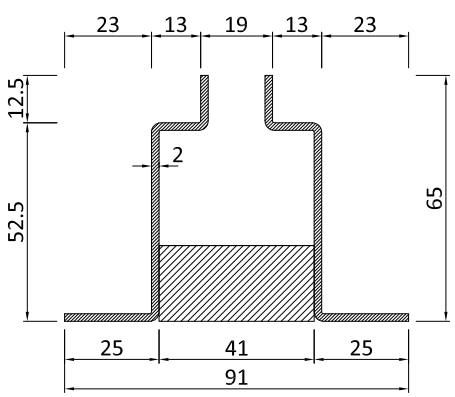
PR2973



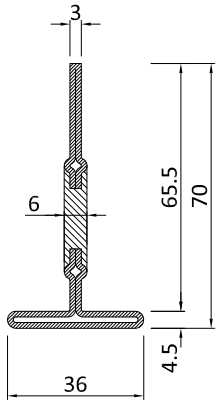
PR2974



PR2927



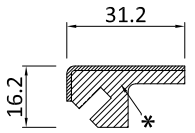
PR2928 solo in acciaio inox
stainless steel only



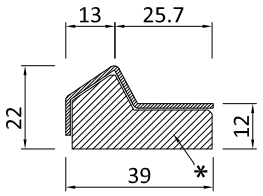
PR2964 non fornito in inox
not in stainless steel

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
PR2962	2,73	2,92	0,25	17,89	2,97	6,0
PR2963	2,80	2,99	0,25	22,53	2,79	6,0
PR2965	3,07	3,29	0,28	23,73	3,82	6,0
PR2972	2,34	2,50	0,21	14,17	2,13	6,0
PR2973	2,35	2,51	0,21	16,29	3,32	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
PR2974	2,68	2,87	0,22	18,81	2,87	6,0
PR2927	3,10	3,25	0,20			4,0
PR2928	3,85					3 - 4
PR2964	2,22	2,10	0,21	14,87	1,2	6,0

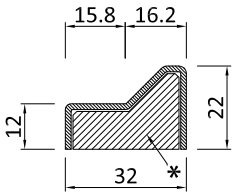


PR2929



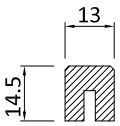
PR2938

corten non disponibile
corten steel not available

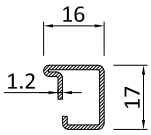


PR2939

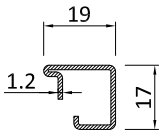
corten non disponibile
corten steel not available



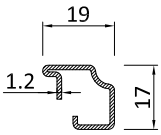
GU2926



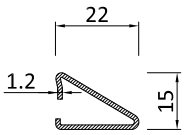
PR2606



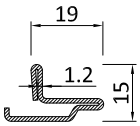
PR2607



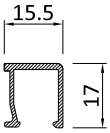
PR2627



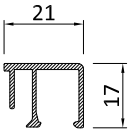
PR2629



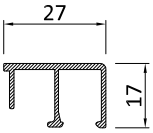
PR2638



PA2606



PA2607



PA2608

*elemento non verniciabile
not paintable element

MATERIALE | *MATERIAL*

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

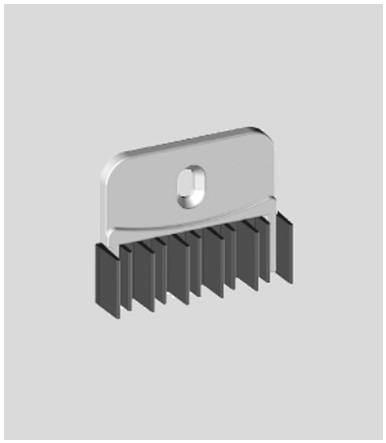
PR _ _ _ _ CZ acciaio corten grezzo | *untreated corteen steel*

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
PR2929	0,68	0,72	0,04			3 - 4
PR2938	1,18	1,22	0,05			3 - 4
PR2939	1,11	1,17	0,06			3 - 4
GU2926	0,23	PVC				3,0
PR2606	0,48	0,52				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
PR2607	0,51	0,55				6,0
PR2627	0,47	0,51				6,0
PR2629	0,49	0,53				6,0
PR2638	0,6	0,68				6,0
PA2606-7-8	0,17-0,23-0,26		Alluminio			6,0



AC1081T

Accessorio di battuta

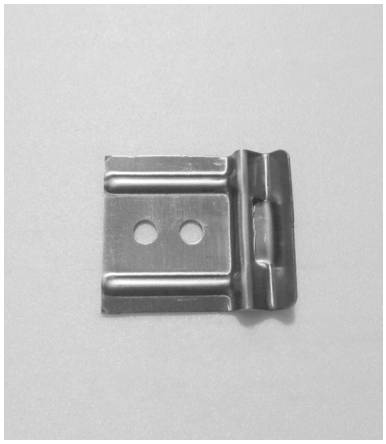
Stop accessory



AC2621L.S

Kit chiusura superiore con catenaccio L = 650 mm

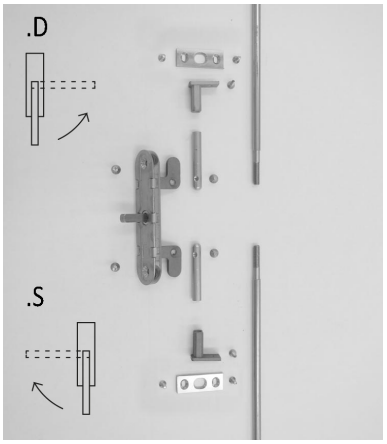
Upper closure kit with flush bolt L = 650 mm



AC2608

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

Clips for securing PR2606 - PR2607 - PR2627 PR2629 - PR2638 glazing beads



AC2624.D

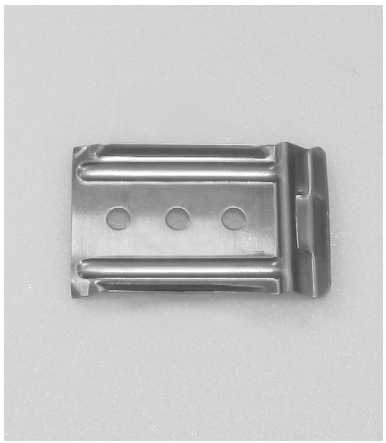
Kit cremonese dx per 1^ anta e chiusure su ante secondarie apertura interna

RH cremone bolt set for master sash and secondary shashes inward opening

AC2624.S

Kit cremonese sx per 1^ anta e chiusure su ante secondarie apertura interna

LH cremone bolt set for master sash and secondary shashes inward opening



AC2609AR

Clips per fissaggio fermavetri su profilo PR2964

Clips for securing glazing beads on PR2964 profile



AC2626R

Punto di chiusura aggiuntivo

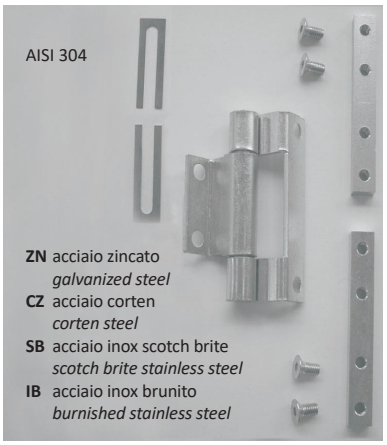
Additional locking point



AC2621L.I

Kit chiusura inferiore con catenaccio L = 450 mm

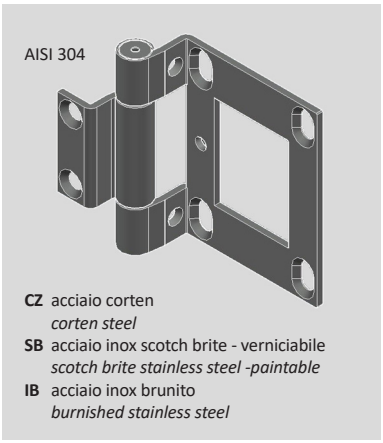
Bottom closure kit with flush bolt L = 450 mm



AC2648.xx

Cerniera a tre ali da avvitare
Peso max anta 100 kg

Three-wing screw-on hinge
Max leaf weight 100 kg

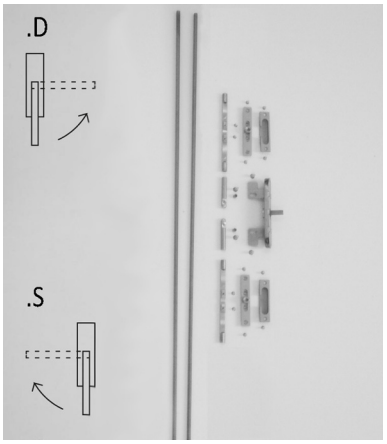


CZ acciaio corten
corten steel
SB acciaio inox scotch brite - verniciabile
scotch brite stainless steel -paintable
IB acciaio inox brunito
burnished stainless steel

AC2648L.xx

Cerniera a tre ali da avvitare in apertura esterna su impacchettamento dove interferisce con la cremonese
Peso max anta 100 kg

Three-wing screw-on hinge on folding outward opening where interference with the cremone
Max leaf weight 100 kg



AC2683.D

Kit cremonese dx per 1^ anta apertura esterna

RH cremone bolt set for master sash outward opening

AC2683.S

Kit cremonese sx per 1^ anta apertura esterna

LH cremone bolt set for master sash outward opening

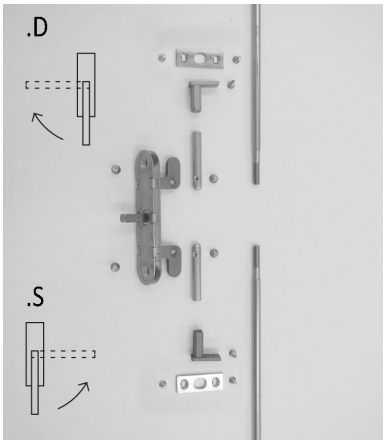


ZN acciaio zincato|*galvanized steel*
CZ acciaio corten|*corten steel*
IZ acciaio inox|*stainless steel*
BR ottone naturale|*natural brass*

AC2653.xx

Kit fondini superiori per profili PR2962 - PR2963

Upper fittings kit for profiles PR2962 - PR2963



AC2684L.D

Kit cremonese dx per maniglia ridotta ACV761

RH cremone bolt set for ACV761 reduced handle

AC2684L.S

Kit cremonese sx per maniglia ridotta ACV761

LH cremone bolt set for ACV761 reduced handle



ZN acciaio zincato|*galvanized steel*
CZ acciaio corten|*corten steel*
IZ acciaio inox|*stainless steel*
BR ottone naturale|*natural brass*

AC2656.xx

Fondino inferiore per profili
PR2962 apertura esterna
PR2963 apertura interna

Lower fitting for profiles
PR2962 outward opening
PR2963 inward opening



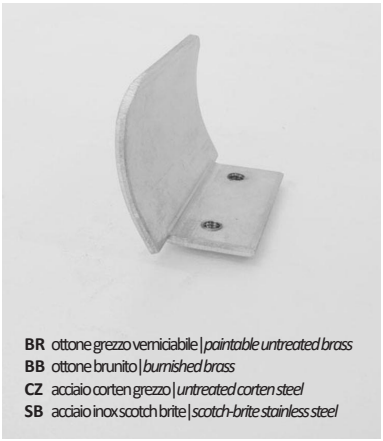
AC2693

Serratura con scrocco e catenaccio per porta

Latch and bolt lock for door

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

The door solution is allowed ONLY for single doors that must NOT be packed

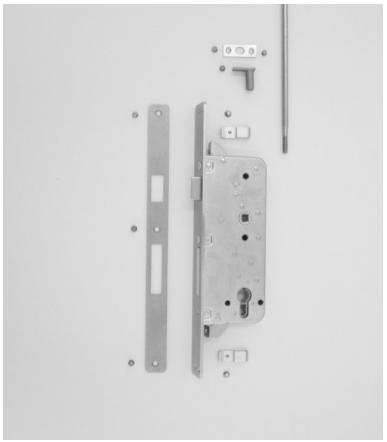


BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CZ acciaio corten grezzo|*untreated corten steel*
SB acciaio inox scotch brite|*scotch-brite stainless steel*

AC2680.xx

Maniglia di trascinamento per aperture esterne

Pulling handle for outward opening



AC2694.D

Kit serratura multipunto dx per porta

RH Multi-lock set for door

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

The door solution is allowed ONLY for single doors that must NOT be packed



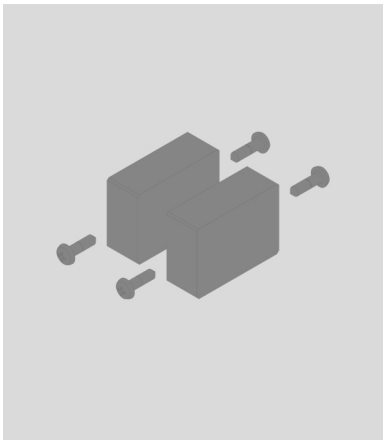
AC2694.S

Kit serratura multipunto sx per porta

LH Multi-lock set for door

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

The door solution is allowed ONLY for single doors that must NOT be packed



AC2819

Kit tappi per guida inferiore PR2928

Bottom rail cap kit for PR2928 rail



AC2695.D

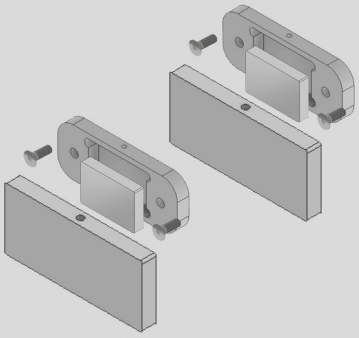
Punto di chiusura aggiuntivo dx per porta

RH additional locking point for door

AC2695.S

Punto di chiusura aggiuntivo sx per porta

LH additional locking point for door



CZ acciaio corten|*corten steel*
IZ acciaio inox|*stainless steel*
BR ottone naturale|*natural brass*

AC2825.xx

Kit magneti blocco anta libera

Magnet kit for retain free leaf

vedi pagine 4.2.3-4
see pages 4.2.3-4



ZN acciaio zincato|*galvanized steel*
CZ acciaio corten|*corten steel*
IZ acciaio inox|*stainless steel* AISI 304
BR ottone naturale|*natural brass*

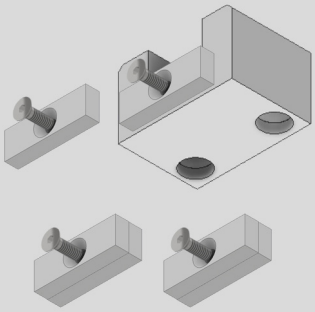
AC2696.xx

Scatola copri serratura Destra

RH lock cover box

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

The door solution is allowed ONLY for single doors that must NOT be packed



AC2826.2 /\ due ante|*two leafs*
AC2826.4 /\/\ quattro ante|*four leafs*
AC2826.6 /\/\/\ sei ante|*six leafs*

AC2826.x

Kit magneti per blocco ante impachettate

Magnet kit for folding leaf stop

vedi pagine 4.2.3-4
see pages 4.2.3-4



ZN acciaio zincato|*galvanized steel*
CZ acciaio corten|*corten steel*
IZ acciaio inox|*stainless steel* AISI 304
BR ottone naturale|*natural brass*

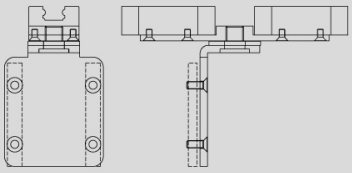
AC2697.xx

Scatola copri serratura Sinistra

LH lock cover box

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

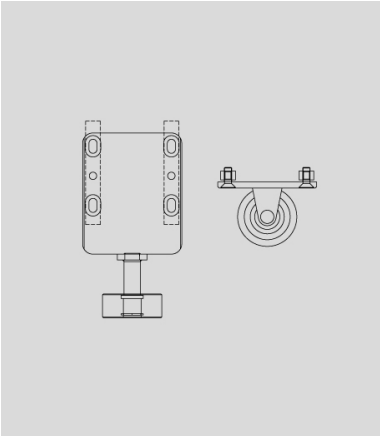
The door solution is allowed ONLY for single doors that must NOT be packed



AC2827

Carrello superiore

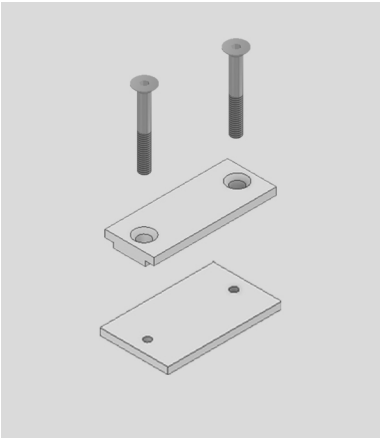
Upper roller



AC2828

Carrello inferiore

Bottom roller



AC2828.F

Fermo corsa per carrello inferiore

Travel stop for bottom roller



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

CV 1023.

Vite per boccola fermavetri in alluminio, TPS 4.2x13

Screw for alluminium glazing bead bushing, TPS 4.2x13



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

CV 1243.

Vite trilobata per boccola fermavetri in alluminio, TPS M4x8 su lato cremonese

Thread cutting machine screw for alluminium glazing bead bushing, TPS M4x8 on the cremone side

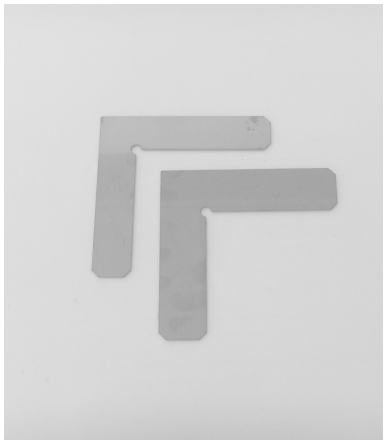


CV5012 acciaio zincato|*galvanized steel*
CV5012I acciaio inox|*stainless steel*

CV 5012.

Boccola per fermavetri in alluminio

Bushing for alluminium glazing bead



AC2803I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2963 - PR2963

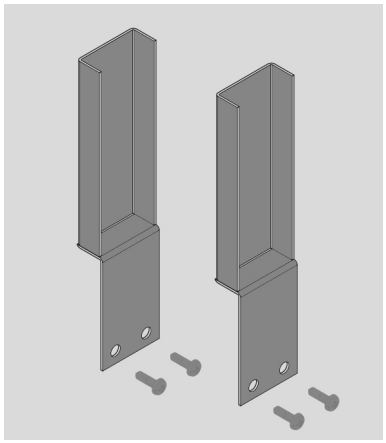


AC2865I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2965 - PR2927

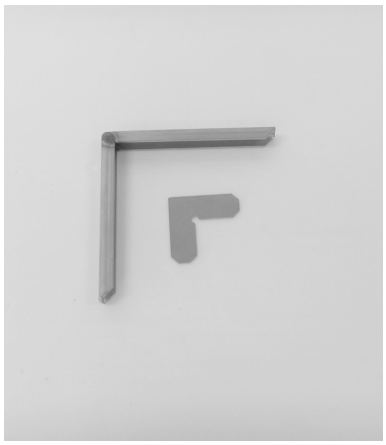


AC2818I

Kit staffe allineamento

Alignment bracket set

Profili | *Profiles*
PR2928 - PR2965



AC2832I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2962 - PR2963



AC2862I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2962 - PR2962



BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CL ottone cromo lucido|*polished and chromed brass*
OL ottone lucido|*polished brass*
SB acciaio inox scotch brite|*scotch-brite stainless steel*

ACV 751.xx

Martellina cremonese ridotta
”VITRUVIO” medium (Ø15)
T | tonda| tronca
scelta, vedi capitolo 4.2 o 5.3

Reduced cremone handle
medium ”VITRUVIO” (Ø15)
T | cut | round
choice, see chapters 4.2 or 5.3

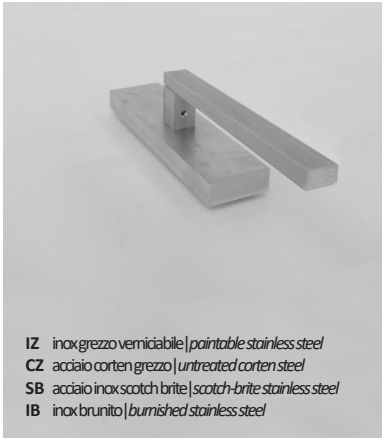


BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CL ottone cromo lucido|*polished and chromed brass*
OL ottone lucido|*polished brass*
SB acciaio inox scotch brite|*scotch-brite stainless steel*

ACV 773.xx

Martellina cremonese
”VITRUVIO” small
per finestra
L | tonda| tronca

Cremone handle
small ”VITRUVIO”
for window
L | cut | round

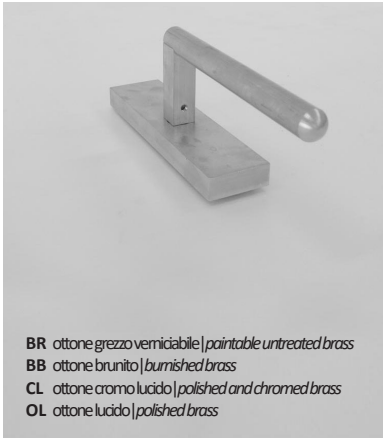


IZ inox grezzo verniciabile|*paintable stainless steel*
CZ acciaio corten grezzo|*untreated corten steel*
SB acciaio inox scotch brite|*scotch-brite stainless steel*
IB inox brunito|*burnished stainless steel*

ACV 761.xx

Martellina cremonese ribassata
”VITRUVIO” medium
L | quadra| tronca
scelta, vedi capitolo 4.2 o 5.3

Lowered cremone handle
medium ”VITRUVIO”
L | cut | square
choice, see chapters 4.2 or 5.3



BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CL ottone cromo lucido|*polished and chromed brass*
OL ottone lucido|*polished brass*

ACV 774.xx

Martellina cremonese
”VITRUVIO” small
per finestra
L | tonda| sfera

Cremone handle
small ”VITRUVIO”
for window
L | sphere | round



BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CL ottone cromo lucido|*polished and chromed brass*
OL ottone lucido|*polished brass*
SB acciaio inox scotch brite|*scotch-brite stainless steel*

ACV 771.xx

Martellina cremonese
”VITRUVIO” small
per finestra
T | tonda| tronca

Cremone handle
small ”VITRUVIO”
for window
T | cut | round

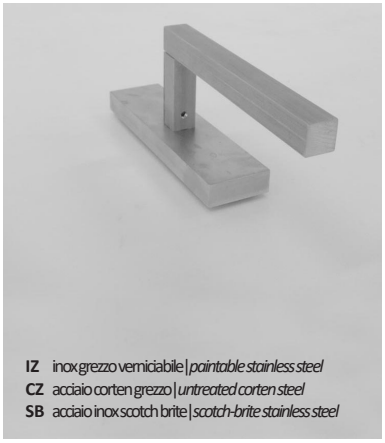


BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CL ottone cromo lucido|*polished and chromed brass*
OL ottone lucido|*polished brass*

ACV 776.xx

Martellina cremonese
”VITRUVIO”
per finestra
KIDS

Cremone handle
small ”VITRUVIO”
for window
KIDS



IZ inox grezzo verniciabile|*paintable stainless steel*
CZ acciaio corten grezzo|*untreated corten steel*
SB acciaio inox scotch brite|*scotch-brite stainless steel*

ACV 772.xx

Martellina cremonese
”VITRUVIO” small
per finestra
L | quadra | tronca

Cremone handle
small ”VITRUVIO”
for window
L | cut | square

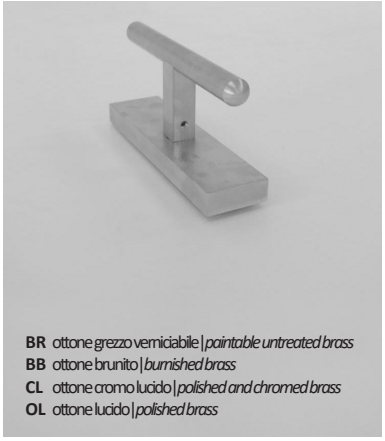


BR ottone grezzo verniciabile|*paintable untreated brass*
BB ottone brunito|*burnished brass*
CL ottone cromo lucido|*polished and chromed brass*
OL ottone lucido|*polished brass*

ACV 777.xx

Martellina cremonese
”VITRUVIO”
per finestra
OVALE

Cremone handle
small ”VITRUVIO”
for window
OVAL

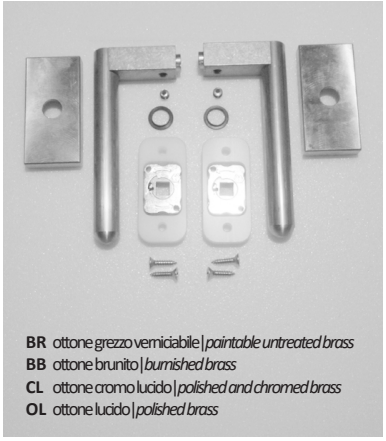


BR ottone grezzo verniciabile | *paintable untreated brass*
BB ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 779.xx

Martellina cremonese
"VITRUVIO" small
per finestra
T | tonda | sfera

Cremone handle
small "VITRUVIO"
for window
T | sphere | round



BR ottone grezzo verniciabile | *paintable untreated brass*
BB ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 954.xx

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | sfera

Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | sphere

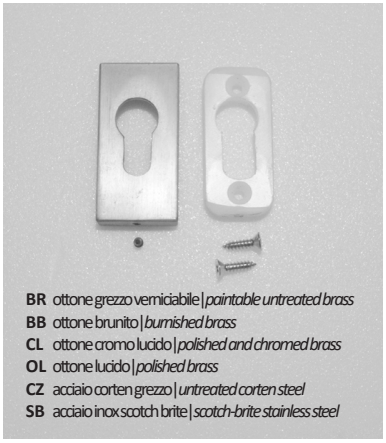
solo con ante asimmetriche
only with asymmetrical sash



ACV 065

Quadro maniglia per porta

Handle spindle bar for door

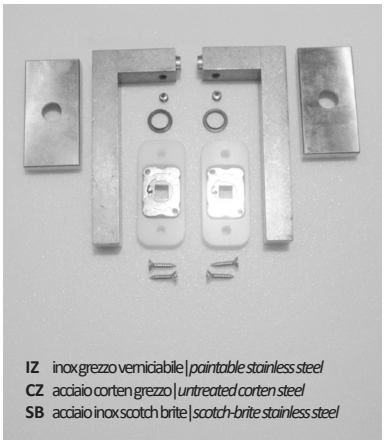


BR ottone grezzo verniciabile | *paintable untreated brass*
BB ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 964.xx

Bocchetta copri cilindro a profilo
europeo

Euro profile cylinder escutcheon
plate



IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 952.xx

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca

Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | square | cut

solo con ante asimmetriche
only with asymmetrical sash



BR ottone grezzo verniciabile | *paintable untreated brass*
BB ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 953.xx

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | tronca

Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | cut

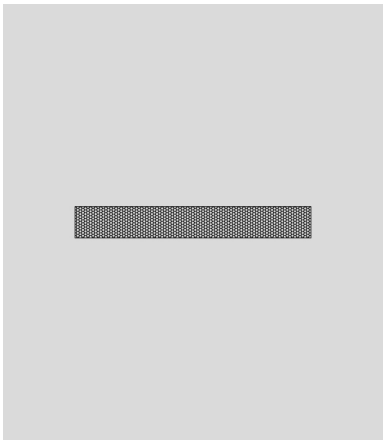
solo con ante asimmetriche
only with asymmetrical sash



GE1011

Guarnizione interna vetro
spessore 4 mm

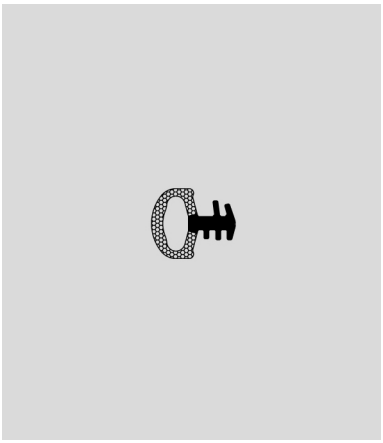
Internal weather strip for glazing bead
4 mm thick



GE2907TT

Guarnizione sotto vetro

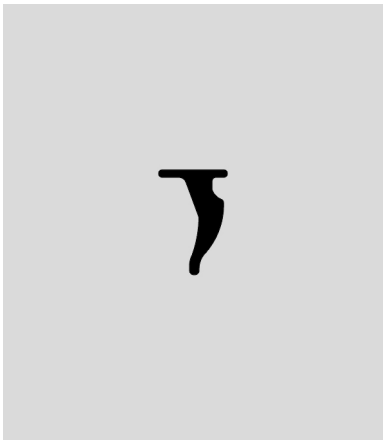
Under glass gasket



GE1001TT

Guarnizione di battuta soglia

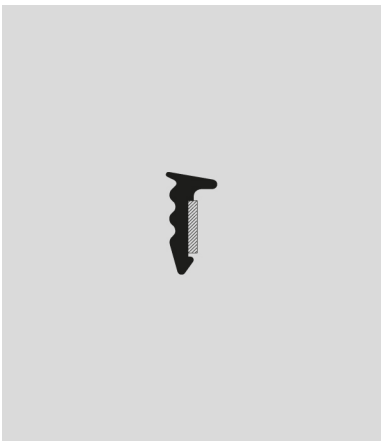
Threshold gasket



GP0095

Guarnizione interna vetro
spessore 3mm

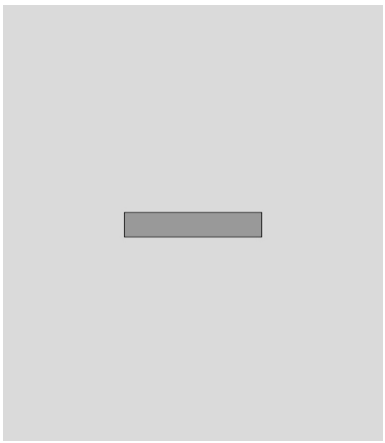
Internal weather strip for glazing bead
3 mm thick



GE2606

Guarnizione adesiva esterno vetro
vedi pg. 5.1.1

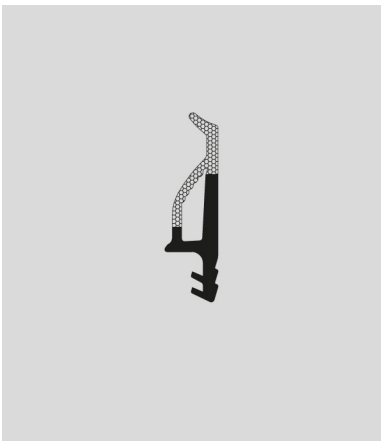
Adhesive weather strip outer window
see pg. 5.1.2



GU2036

Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

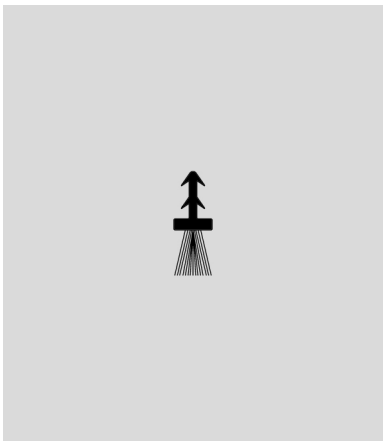
Soft adhesive shim for external window joint
12x4 mm



GE2645TT

Guarnizione di battuta
interna|esterna

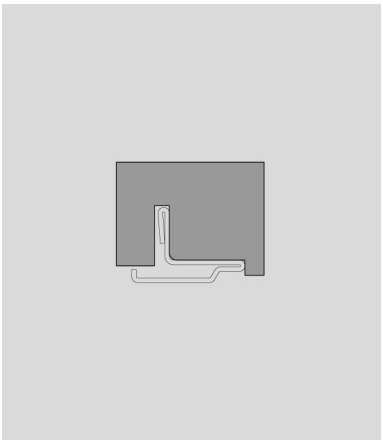
Internal/external weather strip with



GU0100

Spazzolino soglia

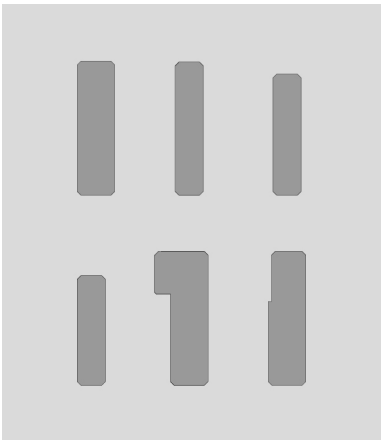
Threshold brush



AT2038

Ganasce di taglio per
PR2638

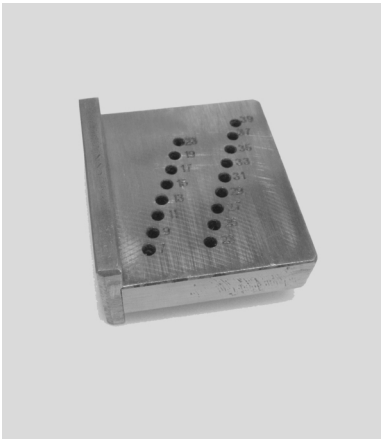
Cutting jaws for
PR2638



AT2900

Kit ganasce di taglio

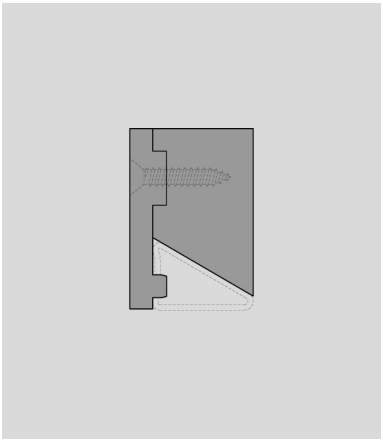
Kit of cutting jaws for profiles



AT2828

Maschera per esecuzione fori
fissaggio fermavetri

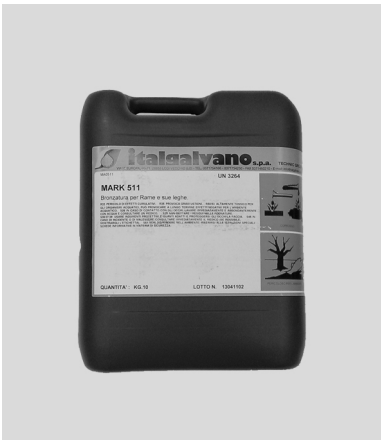
Drill jig for glazing beads
securing



AT2829

Ganasce di taglio per
fermavetro PR2629

Kit of cutting jaws
for glazin bead PR2629



SA0005.01

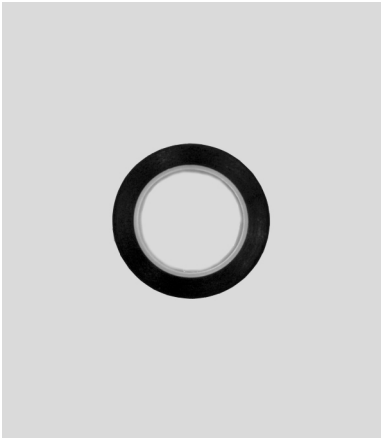
Liquido neritore per brunitura
1 Kg

Burnishing liquid
1 Kg

SA0005.10

Liquido neritore per brunitura
10 Kg

Burnishing liquid
10 Kg



SA1033

Nastro adesivo protettivo per verniciatura
33 mm

Adhesive tape for painting
33 mm

P.29xx



SA2001

Spray detergente antimpronta per superfici in acciaio inox

Anti-fingerprint detergent spray for stainless steel surfaces



SA2002

Spray solvente per rimozione collanti su superfici in acciaio inox

Solvent adhesive remover spray for stainless steel surfaces



SA2031

Liquido deumidificante vetri

Glass dehumidifying liquid



SA2032

Primer di adesione per profili verniciati

Adhesion primer for painted profiles



SA2033

Liquido di adesione per materiale plastico

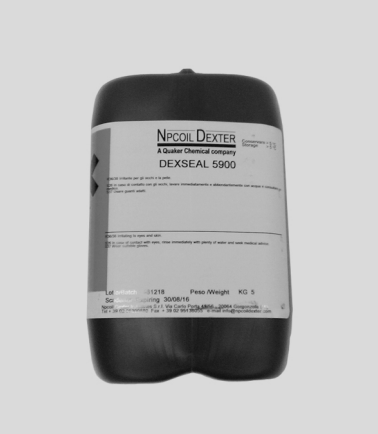
Adhesion liquid for plastic



SA3001

Acido per ossidazione corten

Oxidising acid for corten



SA3002.25

Passivante per ossidazione corten
25 Kg

Passivating agent for corten
25 Kg

SA3002.5

Passivante per ossidazione corten
5 Kg

Passivating agent for corten
5 Kg



SA3003

Cera d'api per finitura corten

Beeswax for Corten finishing



SL0019

Sigillante a freddo per giunzione angoli e traversi

Cold sealant for corner and transom joints

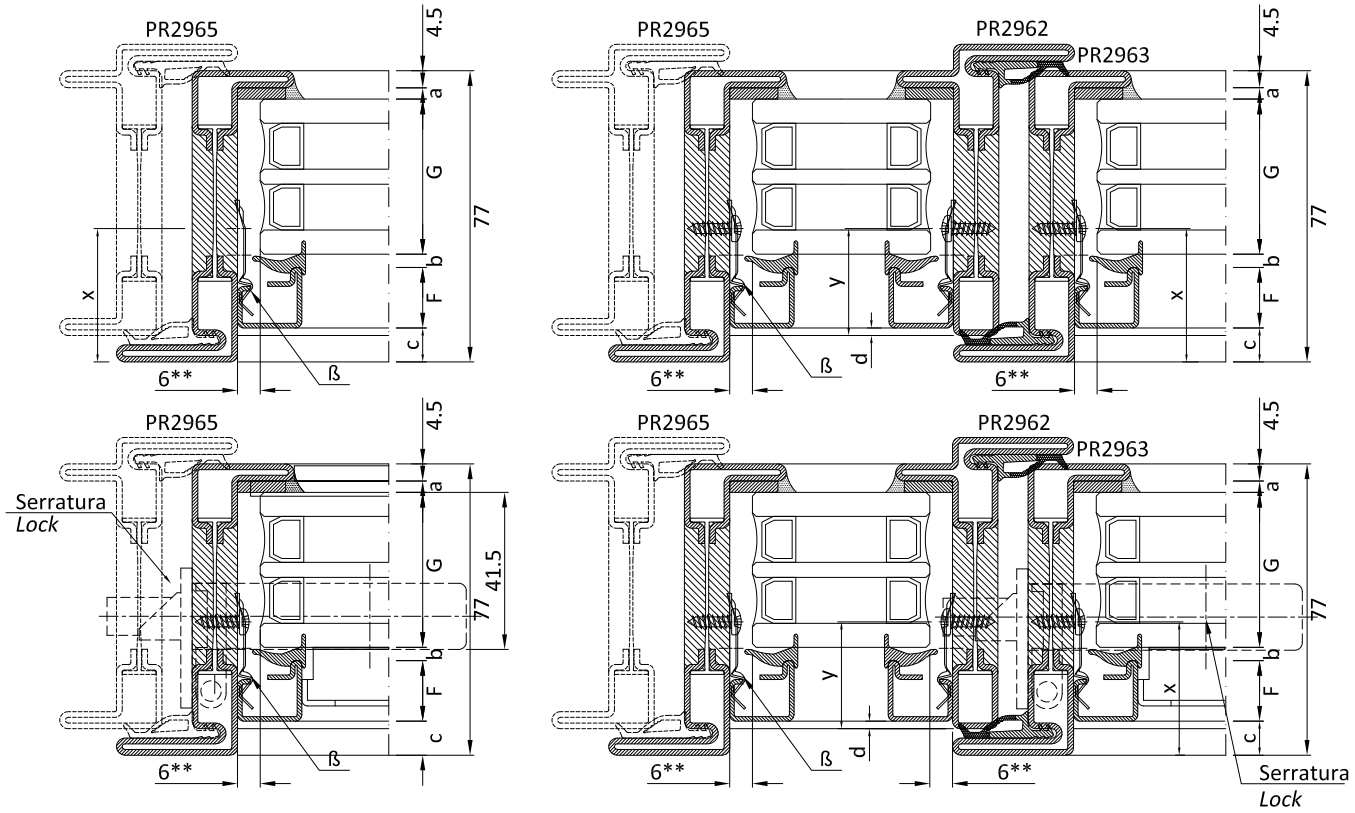
1 kg



SL0021

Silicone nero per guarnizioni

Black silicone for gaskets

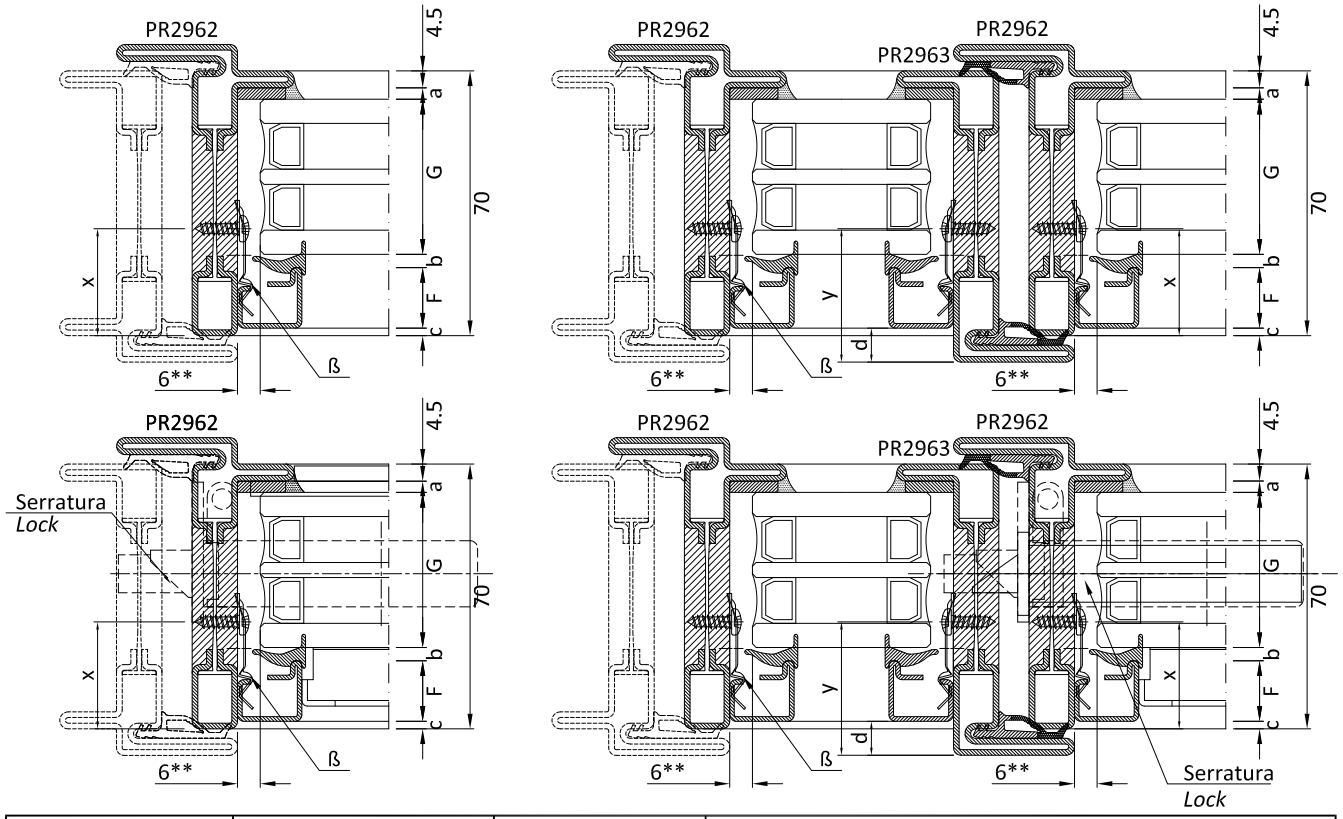


F	G	Guarnizioni - *gasket*						
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*		rientro fermavetro *glazing beads gap*		boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	y	c	d	ß
PR2606	34 - 40	3	3	42.5 - 36.5	35.5 - 29.5	16 - 10	9 - 3	AC2608
PR2607	31 - 38			42.5 - 35.5	35.5 - 28.5	16 - 9	9 - 2	AC2608
PR2627	31 - 38			42.5 - 35.5	35.5 - 28.5	16 - 9	9 - 2	AC2608
PR2629	28 - 35			53.5 - 46.5	46.5 - 39.5	16 - 9	9 - 2	AC2608
PR2638	31 - 38			50.5* - 50.5	43.5* - 43.5	16 - 9	9 - 2	AC2608

***** fissare tramite il primo foro della clip
** screw in the first hole of the clip*

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

NOTA: Con serratura AC2693 utilizzare vetri con spessore ≥ 36 mm
Con serratura AC2694 utilizzare vetri con spessore = 42-43 mm
ATTN: With lock AC2693 use glass thickness ≥ 36 mm
With lock AC2694 use glass thickness = 42-43 mm

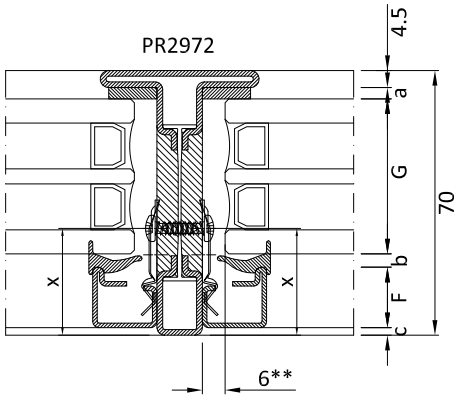


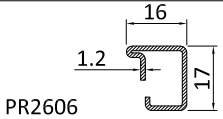
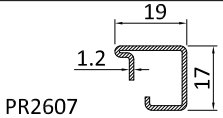
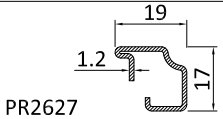
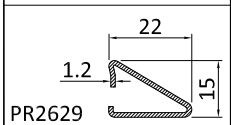
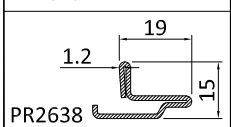
F	G	Guarnizioni - *gasket*						
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*		rientro fermavetro *glazing beads gap*		boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	y	c	d	ß
PR2606	34 - 40	3	3	35.5 - 29.5	42.5 - 36.5	9 - 3	16 - 10	AC2608
PR2607	31 - 38			35.5 - 28.5	42.5 - 35.5	9 - 2	16 - 9	AC2608
PR2627	31 - 38			35.5 - 28.5	42.5 - 35.5	9 - 2	16 - 9	AC2608
PR2629	28 - 35			39.5 - 32.5	46.5 - 39.5	9 - 2	16 - 9	AC2608
PR2638	31 - 38			43.5 - 43.5*	50.5 - 50.5*	9 - 2	16 - 9	AC2608

***** fissare tramite il primo foro della clip
** screw in the first hole of the clip*

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

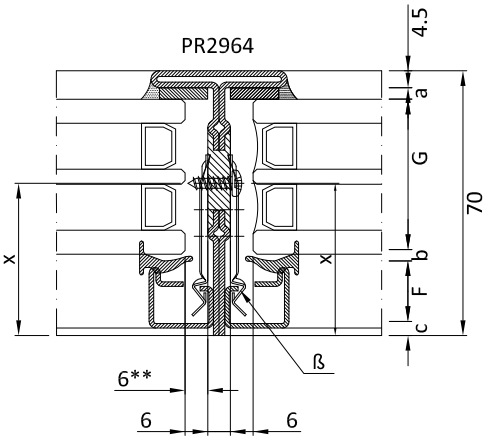
NOTA: Con serratura AC2693 utilizzare vetri con spessore ≥ 36 mm
Con serratura AC2694 utilizzare vetri con spessore ≥ 32 mm
ATTN: With lock AC2693 use glass thickness ≥ 36 mm
With lock AC2694 use glass thickness ≥ 32 mm

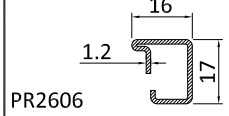
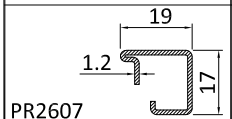
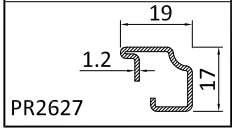


F	G	Guarnizioni - *gasket*					
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*		boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	c	d	ß
 PR2606	34 - 40	3	3	35.5 - 29.5	9 - 3	16 - 10	AC2608
 PR2607	31 - 38			35.5 - 28.5	9 - 2	16 - 9	AC2608
 PR2627	31 - 38			35.5 - 28.5	9 - 2	16 - 9	AC2608
 PR2629	28 - 35			39.5 - 32.5	9 - 2	16 - 9	AC2608
 PR2638	31 - 38			43.5 - 43.5*	9 - 2	16 - 9	AC2608

* fissare tramite il primo foro della clip
** screw in the first hole of the clip*

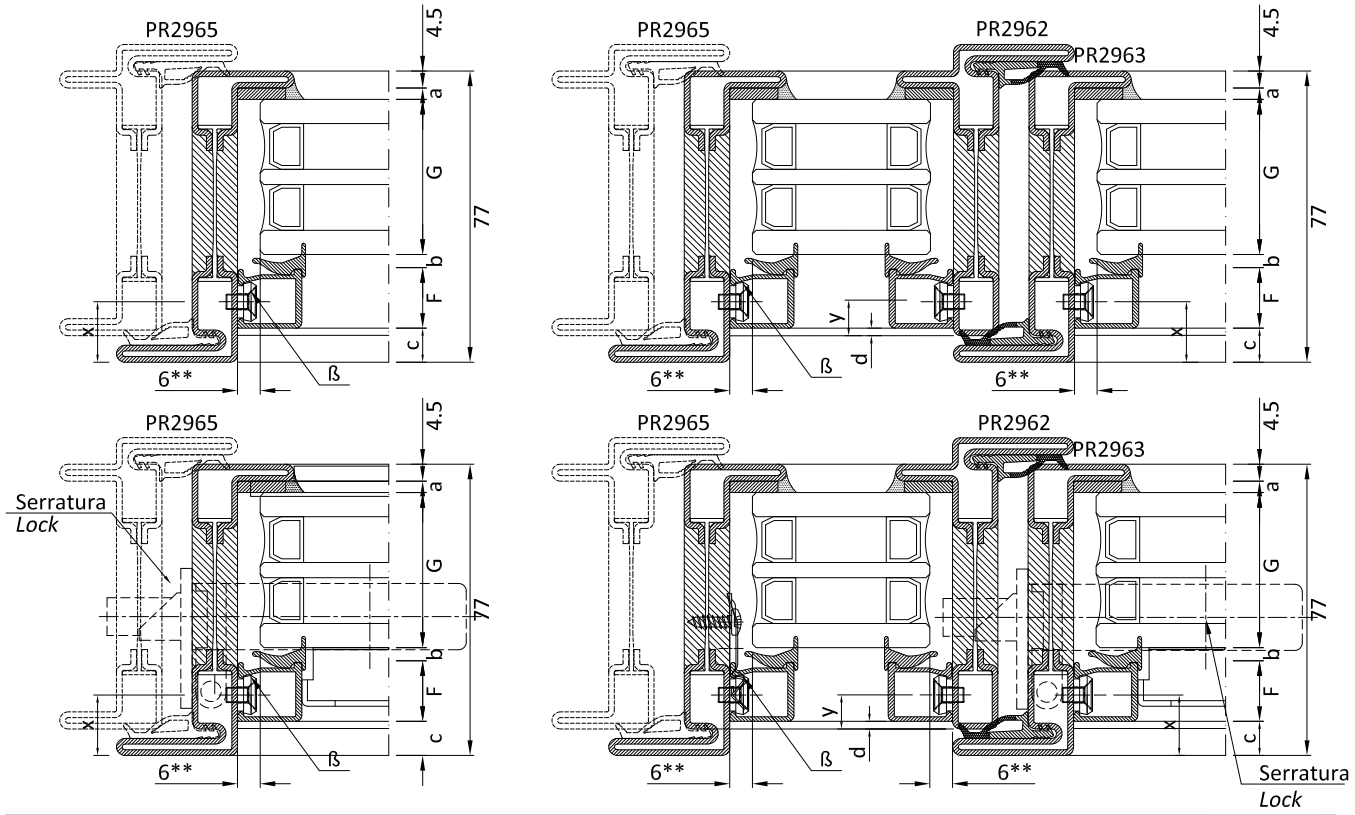
** 7 mm per PR2638
*** 7 mm for PR2638*



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*	boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	c	ß
 PR2606	34 - 40	3	3	41* - 42***	9 - 3	AC2609AR
 PR2607	31 - 38			41* - 41***	9 - 2	AC2609AR
 PR2627	31 - 38			41* - 41***	9 - 2	AC2609AR

***** fissare tramite il secondo foro della clip
** screw in the first hole of the clip*

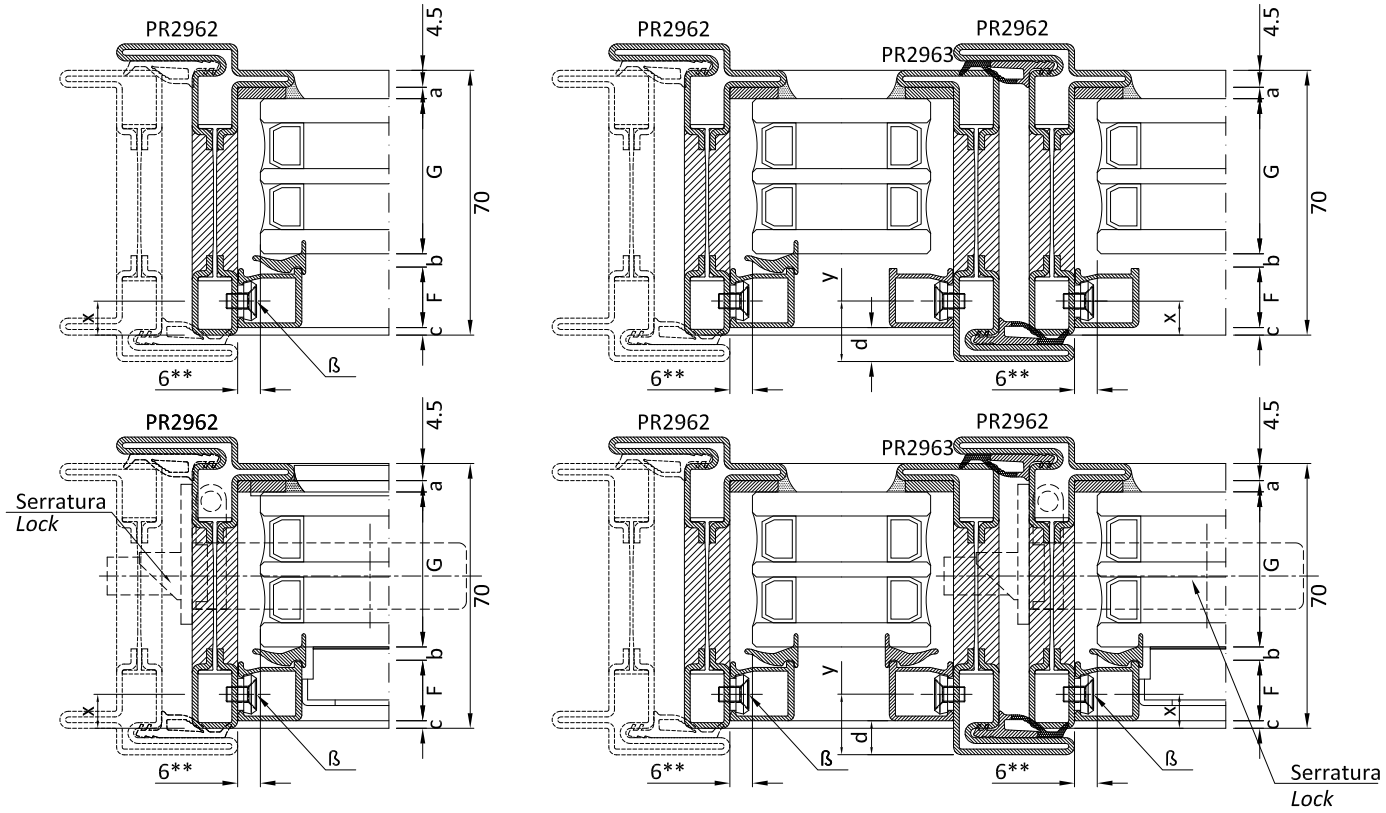
******* fissare tramite il terzo foro della clip
**** screw in the third hole of the clip*



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*		boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	y	c	d	ß
PA2606 (15.5 × 17)	39 - 40	3	3	18 - 17	11 - 10	11 - 10	4 - 3	CV1243(i) CV5012(i)
PA2607 (21 × 1.2 × 17)	34 - 36			18 - 16	11 - 9	11 - 9	4 - 2	CV1243(i) CV5012(i)
PA2608 (27 × 1.2 × 17)	28 - 30			18 - 16	11 - 9	11 - 9	4 - 2	CV1243(i) CV5012(i)

NOTA: Con serratura AC2693 utilizzare vetri con spessore ≥ 36 mm
Con serratura AC2694 utilizzare vetri con spessore ≥ 44 mm
ATTN: With lock AC2693 use glass thickness ≥ 36 mm
With lock AC2694 use glass thickness ≥ 44 mm

* Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.9.13
** Pay attention fixing the screw near cremone set - see pg. 2.9.13*

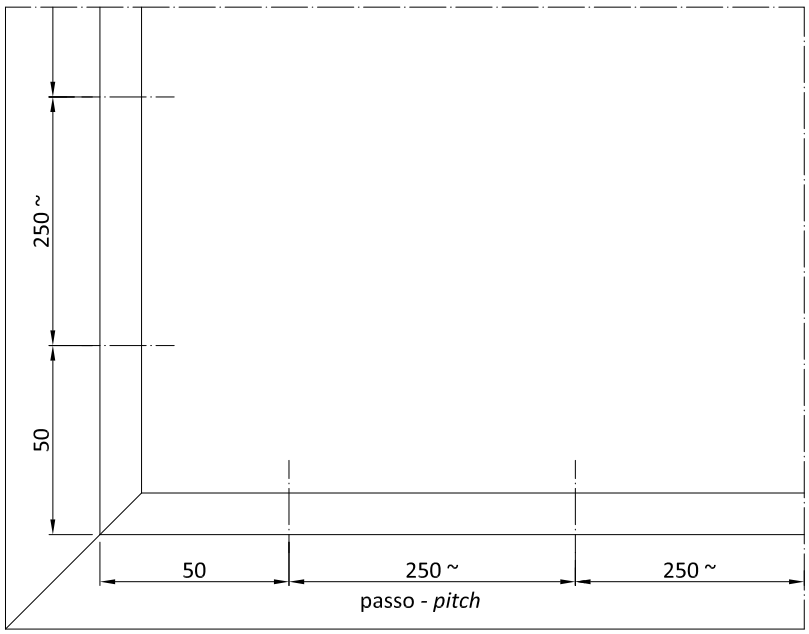


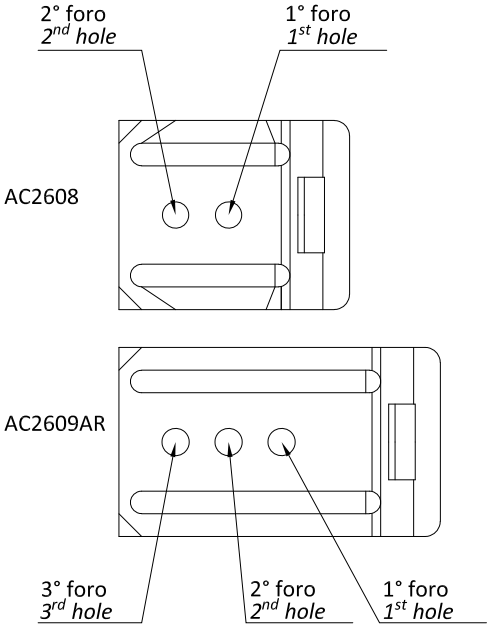
F	G	Guarnizioni - *gasket*						
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*		rientro fermavetro *glazing beads gap*		boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	y	c	d	ß
PA2606 (15.5 × 17)	39 - 40	3	3	11 - 9	18 - 16	4 - 2	11 - 9	CV1243(i) CV5012(i)
PA2607 (21 × 1.2 × 17)	34 - 36			11 - 9	18 - 16	4 - 2	11 - 9	CV1243(i) CV5012(i)
PA2608 (27 × 1.2 × 17)	28 - 30			11 - 9	18 - 16	4 - 2	11 - 9	CV1243(i) CV5012(i)

NOTA: Con serratura AC2693 utilizzare vetri con spessore ≥ 36 mm
Con serratura AC2694 utilizzare vetri con spessore ≥ 32 mm
ATTN: With lock AC2693 use glass thickness ≥ 36 mm
With lock AC2694 use glass thickness ≥ 32 mm

* Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.9.13
** Pay attention fixing the screw near cremone set - see pg. 2.9.13*

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

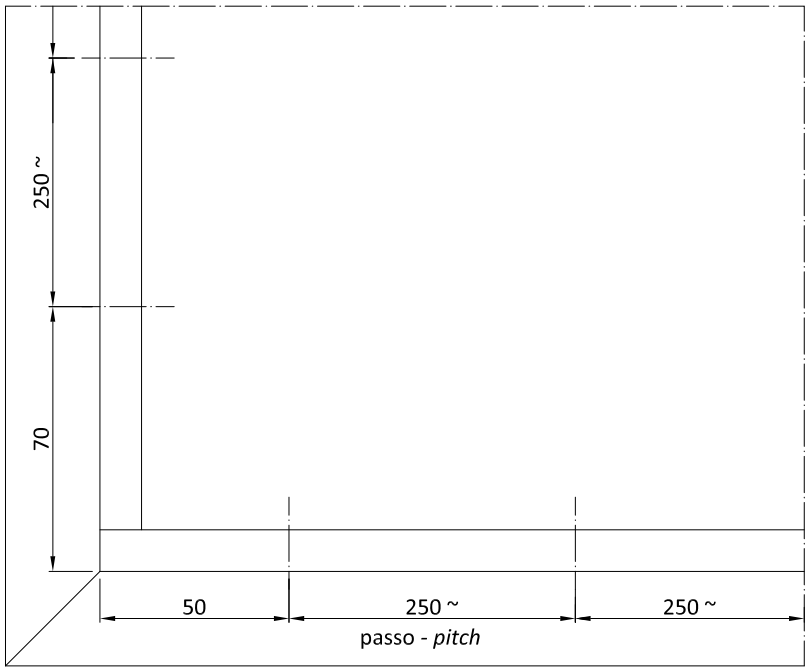




Passo clips fissaggio fermavetri
Clip pitch for glazing beads securing

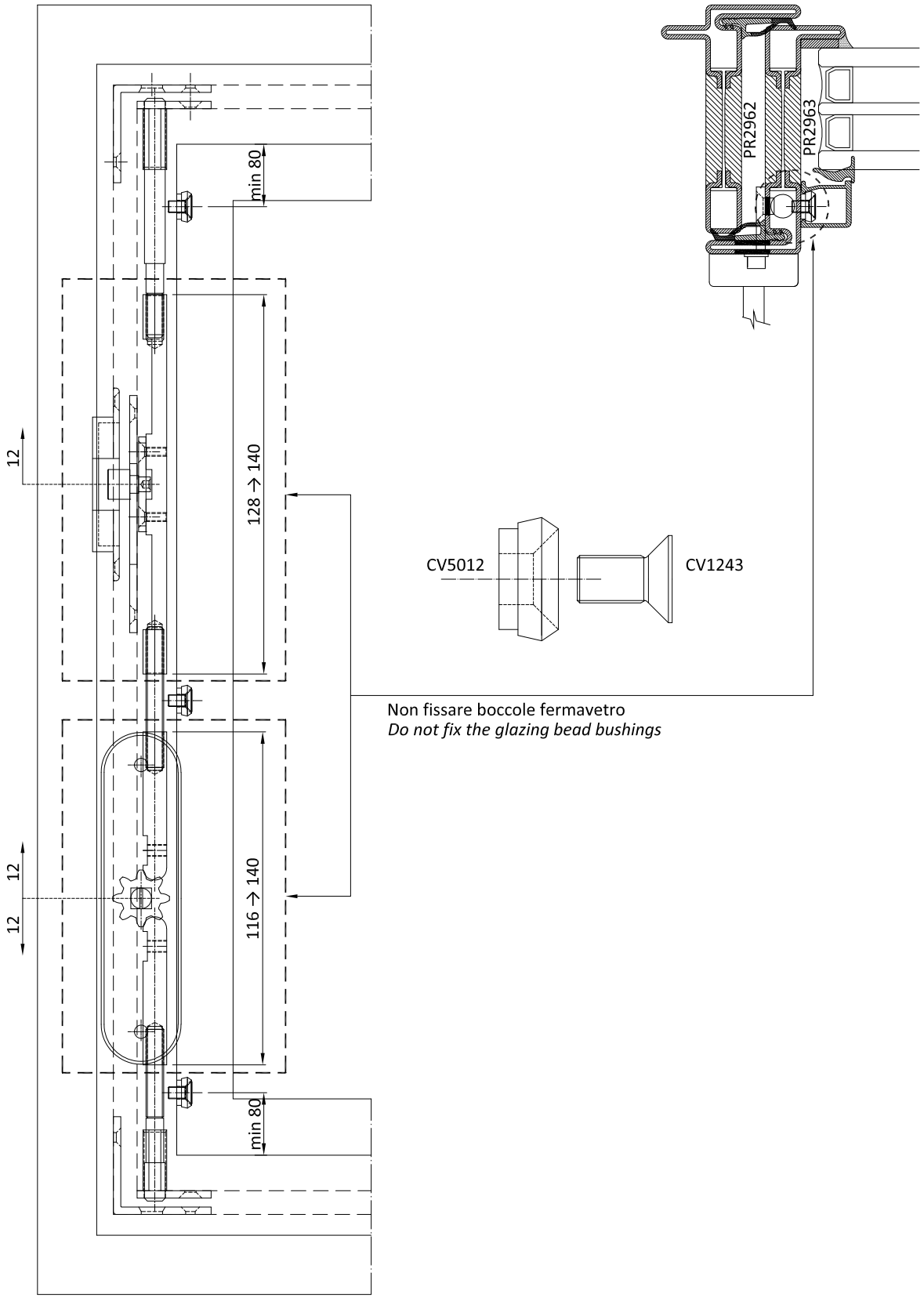
Fissaggio fermavetri PA2607 - PA2608: profili telaio vite CV1023(I) TPS 4,2 x 13 e boccola CV5012(I)
Profili anta vite CV1243(I) TPS M4 x 8 e boccola CV5012(I).

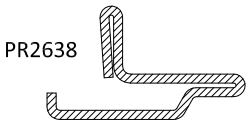
Glazing bead fixing PA2607 - PA2608: frame profile screw CV1023(I) TPS 4,2 x 13 and bushing CV5012(I)
Leaf profile screw CV1243(I) TPS M4 x 8 M4 x 8 and bushing CV5012(I).

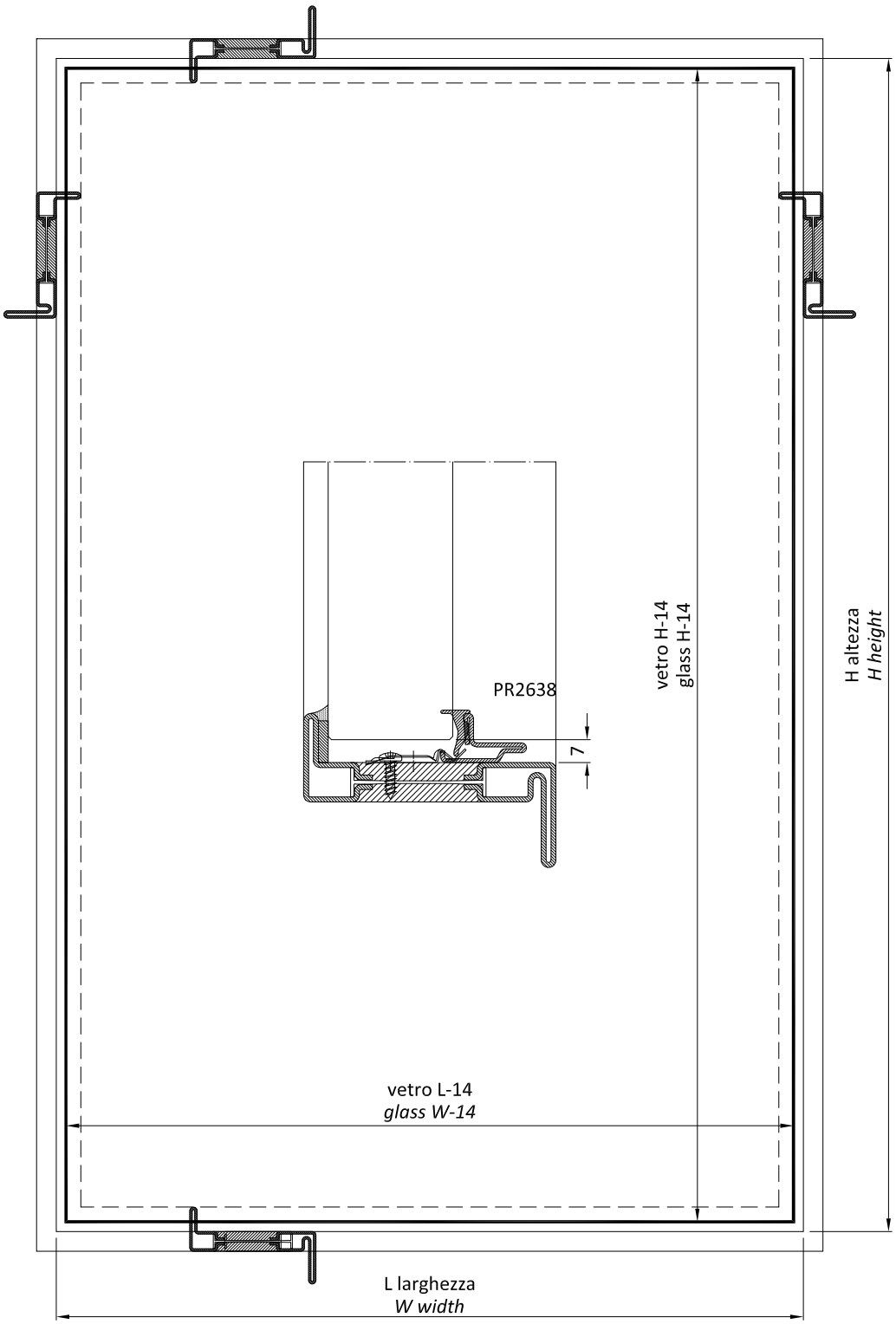


Passo vite e boccola fissaggio fermavetri
Screw and bushing pitch for glazing beads fixing

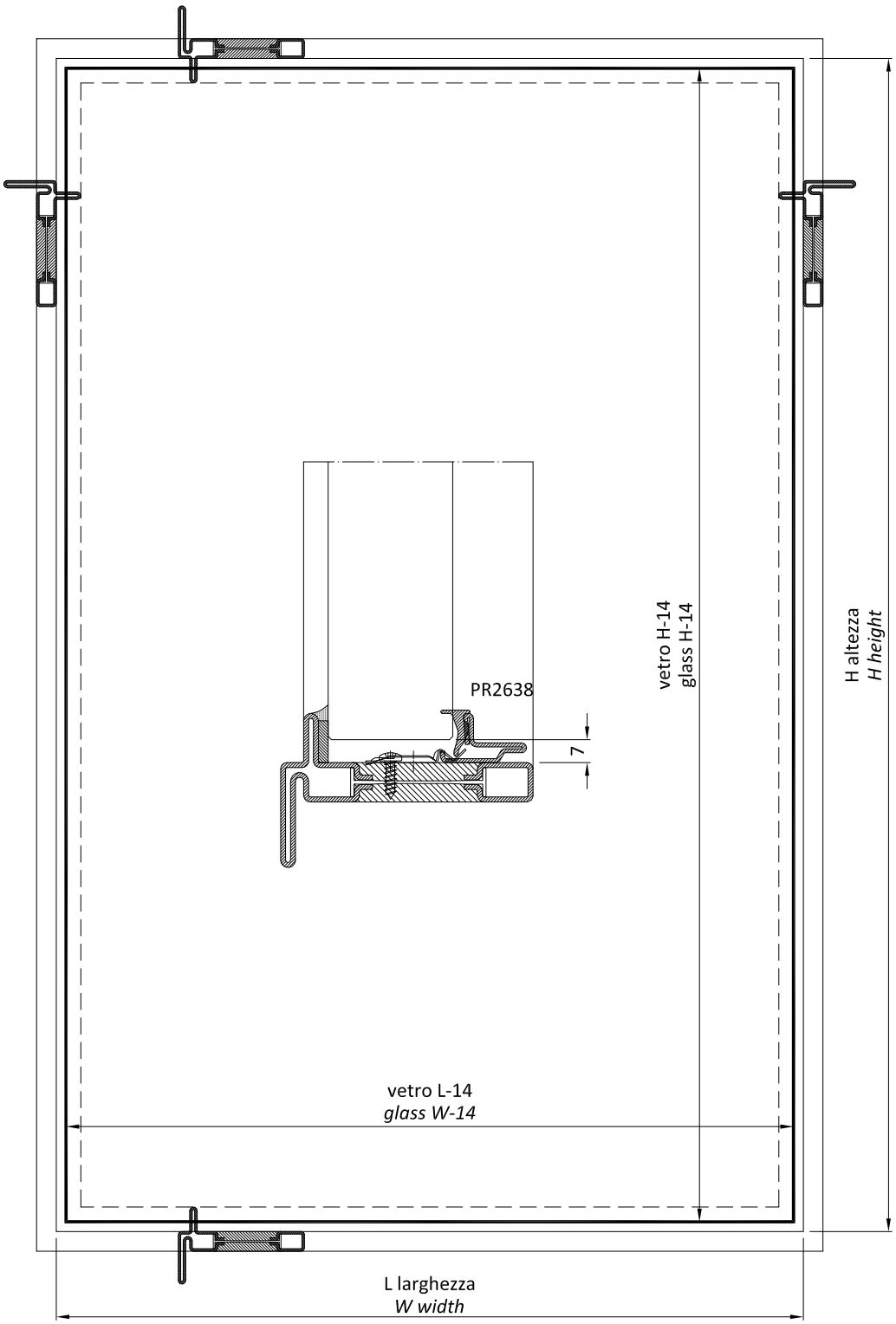
Boccole fissaggio fermavetri in alluminio
Bushing fixing for alluminium glazing beads

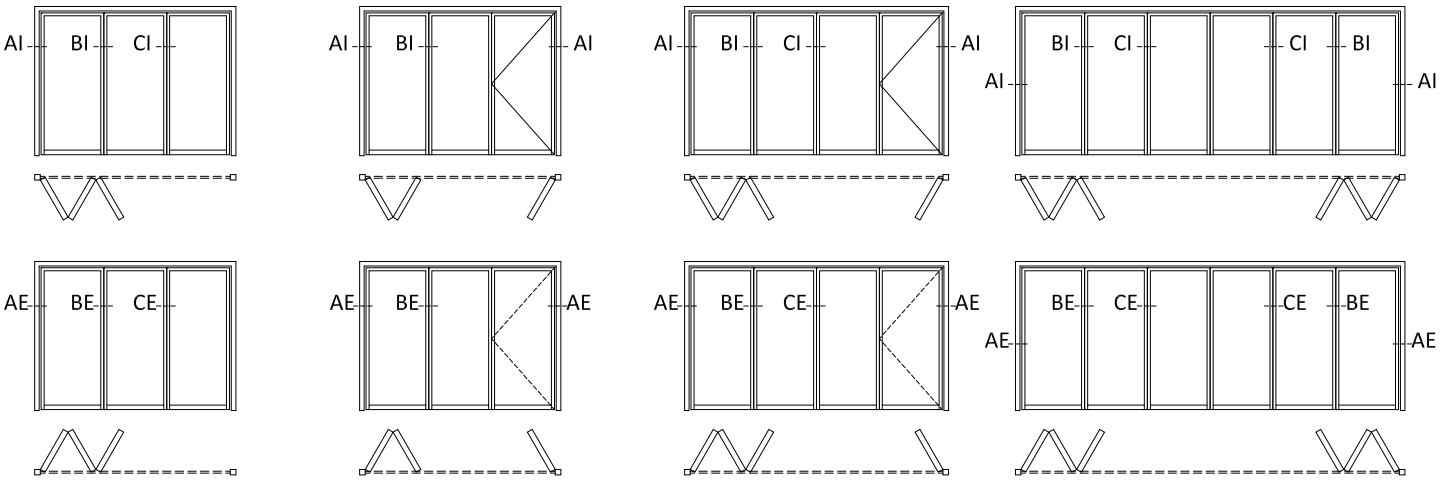


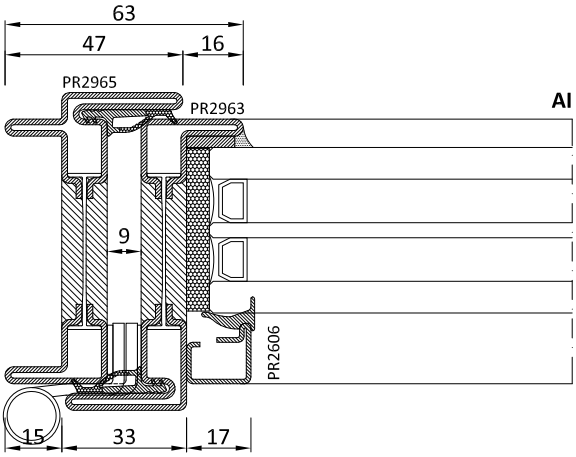

PR2638

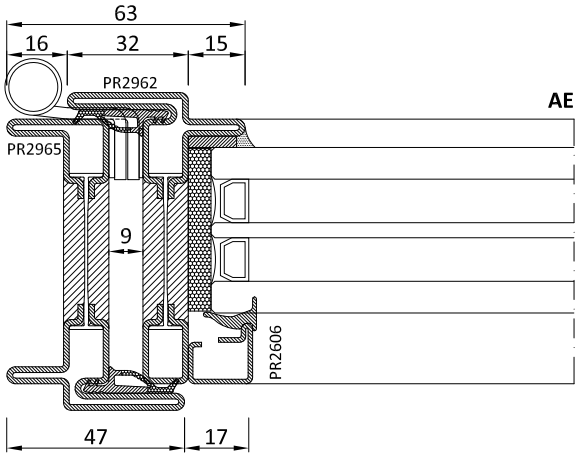

PR2638
7
vetro H-14
glass H-14
H altezza
H height
vetro L-14
glass W-14
L larghezza
W width

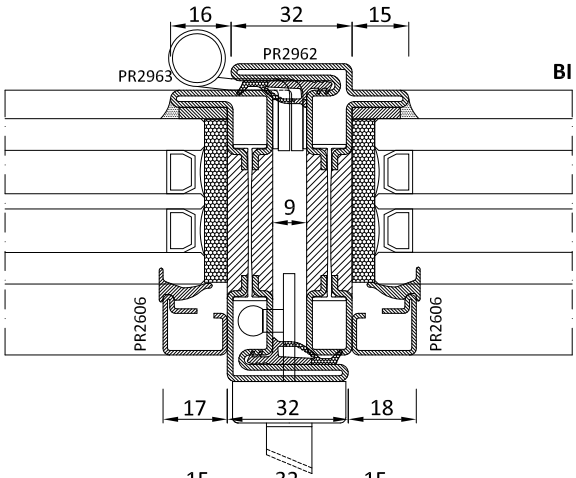
PR2638

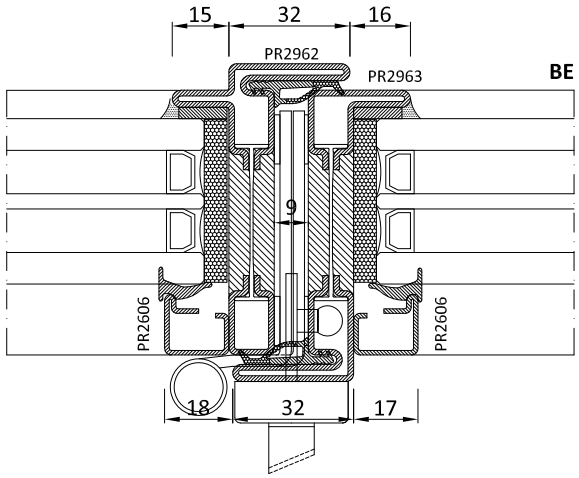

PR2638
7
vetro H-14
glass H-14
H altezza
H height
vetro L-14
glass W-14
L larghezza
W width

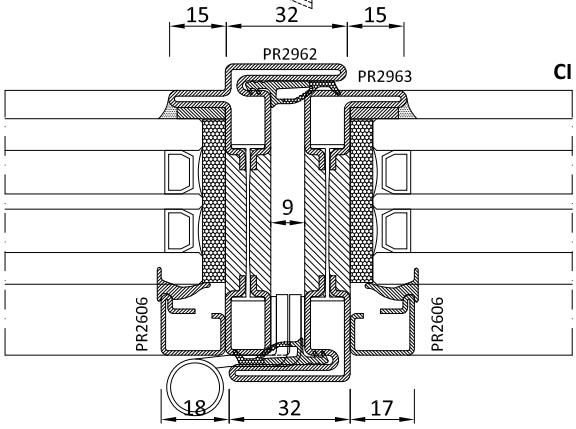

AI
BI
CI
AE
BE
CE

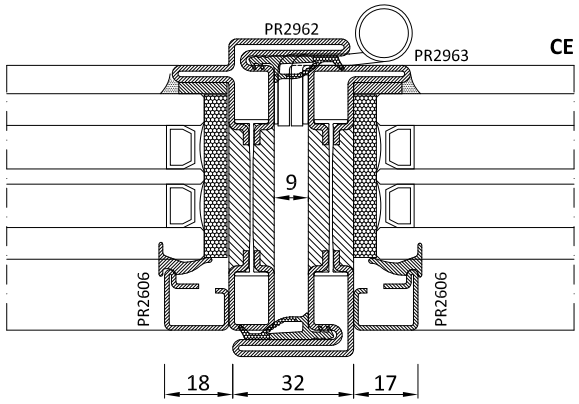

63
47
16
PR2965
PR2963
AI
9
PR2606
15
33
17

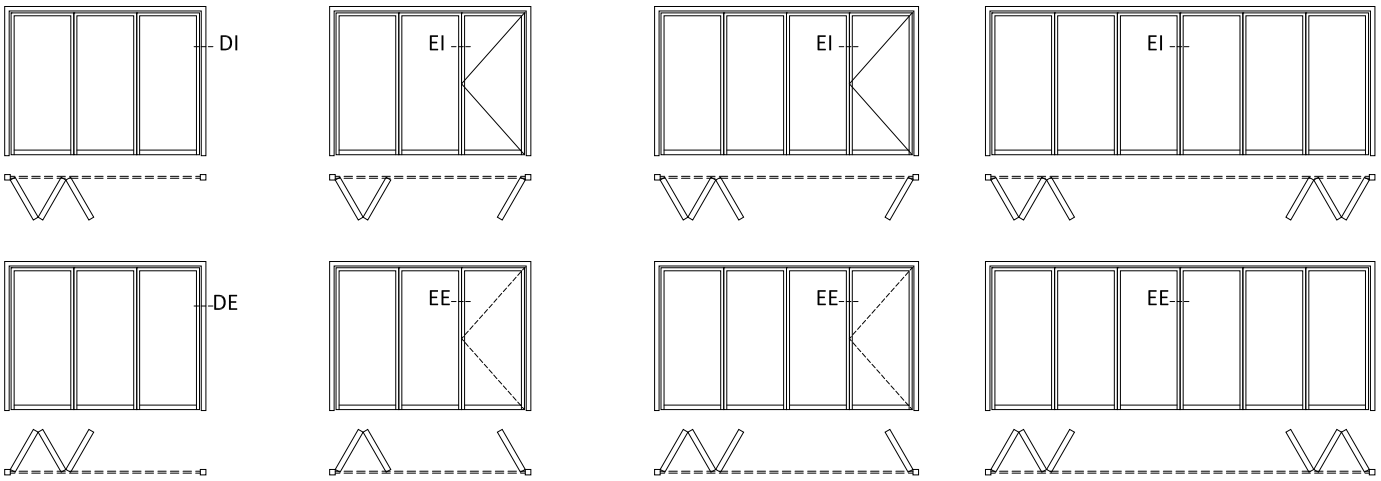

63
16
32
15
PR2962
AE
PR2965
9
PR2606
47
17

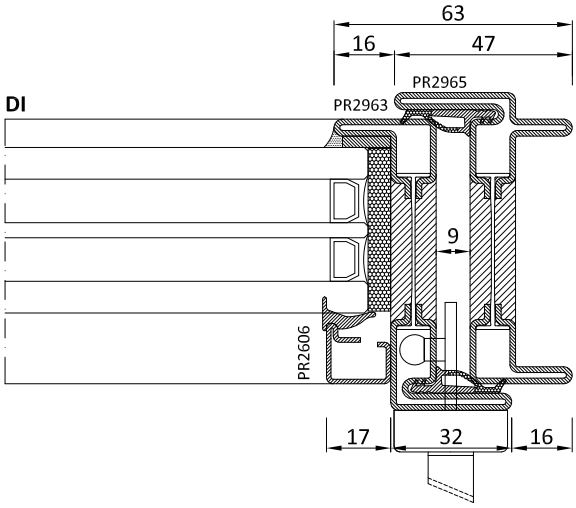

16
32
15
PR2962
PR2963
BI
9
PR2606
PR2606
17
32
18

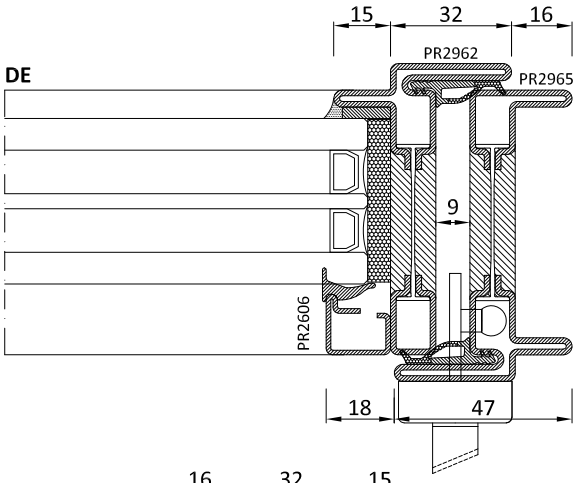

15
32
16
PR2962
PR2963
BE
9
PR2606
PR2606
18
32
17

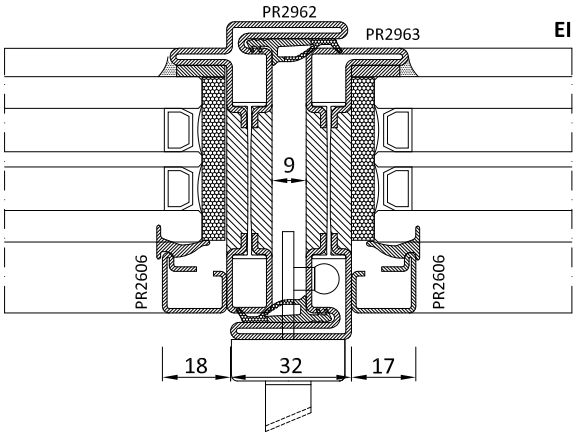

15
32
15
PR2962
PR2963
CI
9
PR2606
PR2606
18
32
17

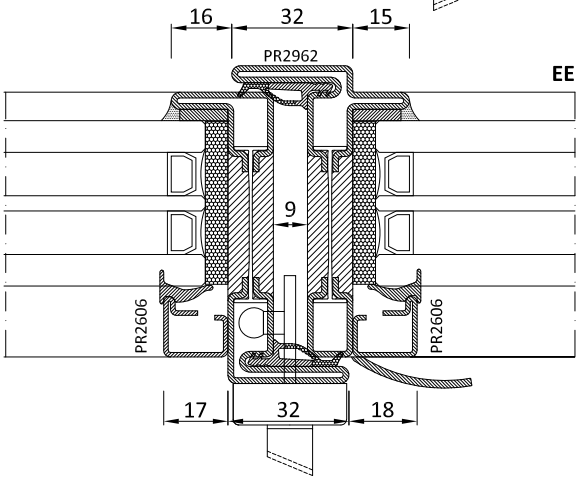

PR2962
PR2963
CE
9
PR2606
PR2606
18
32
17

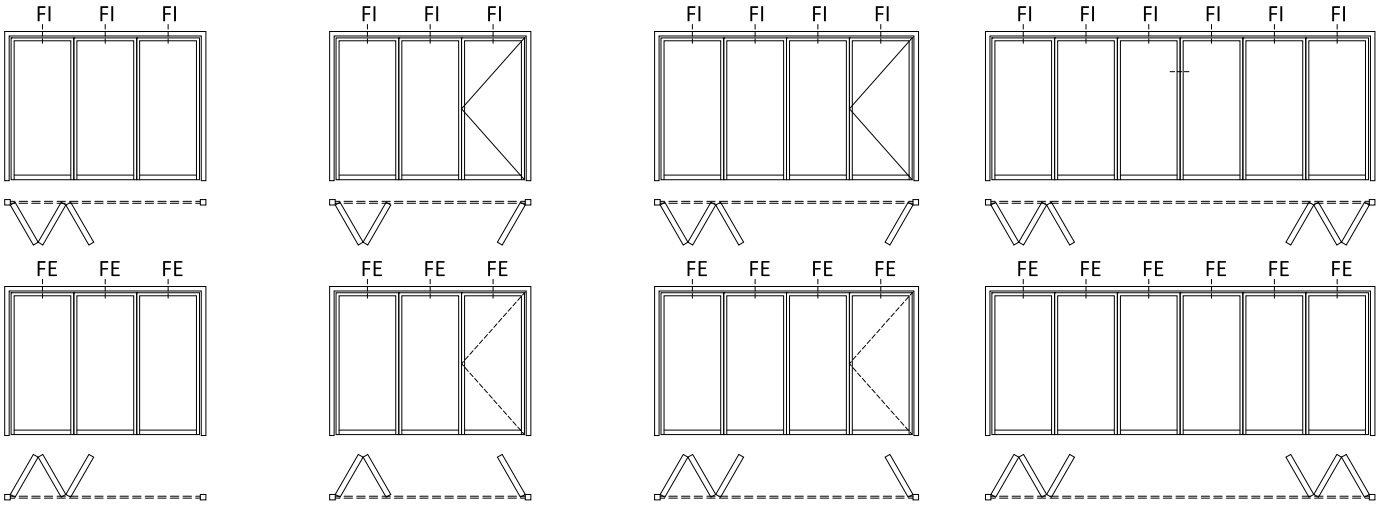

DI
EI
EI
EI
DE
EE
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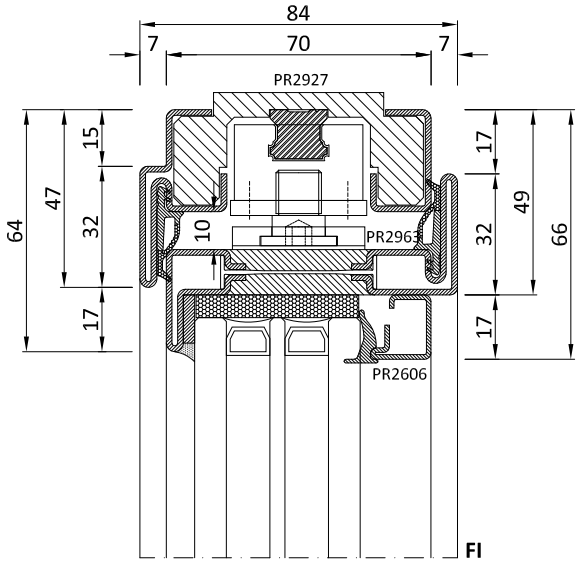

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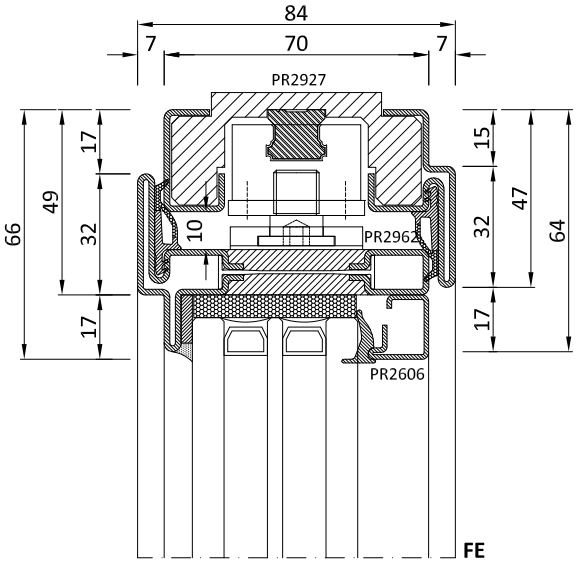

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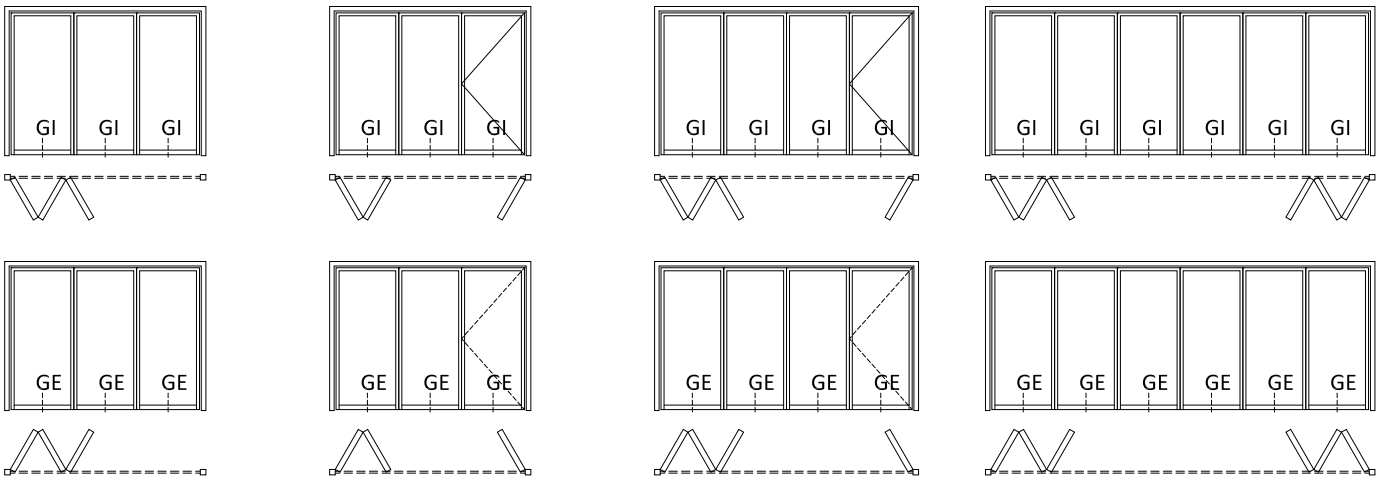

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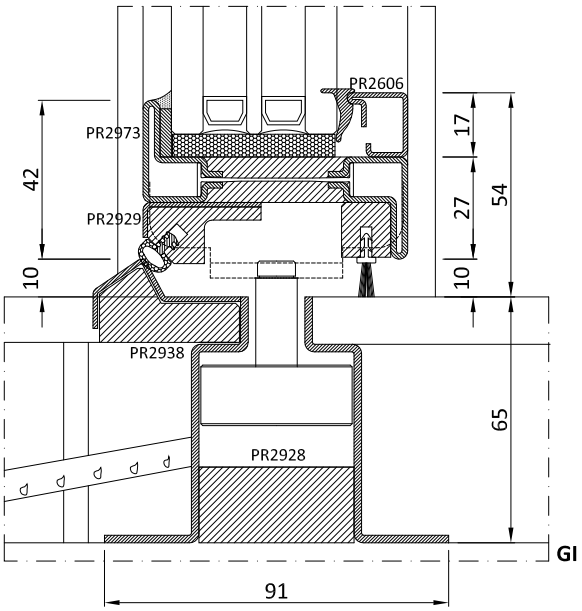

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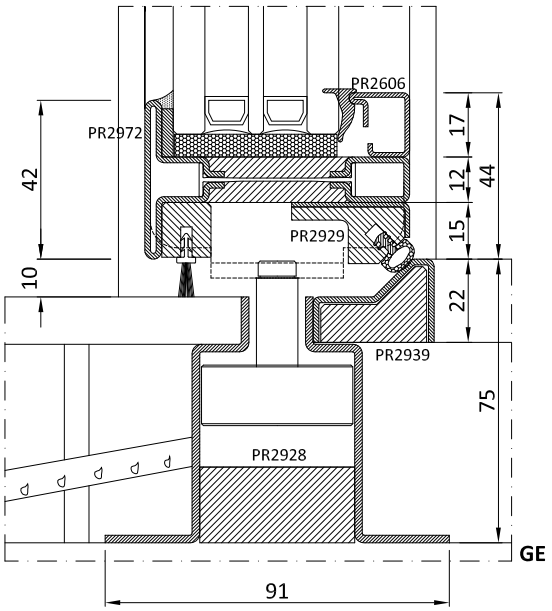

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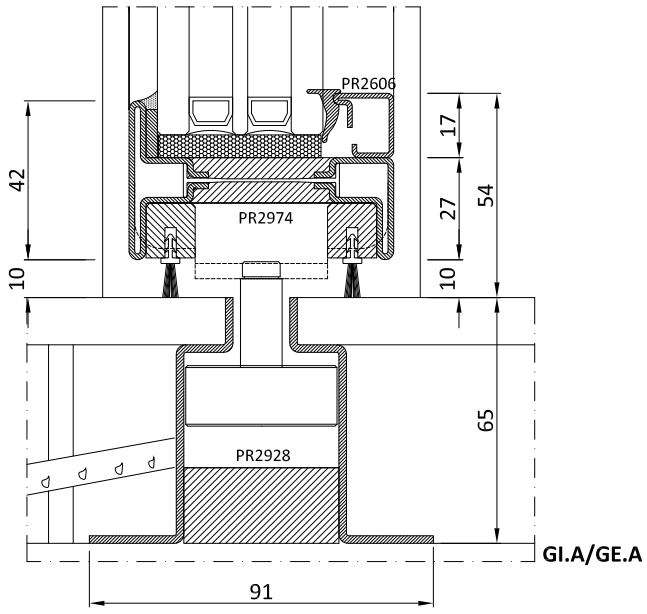

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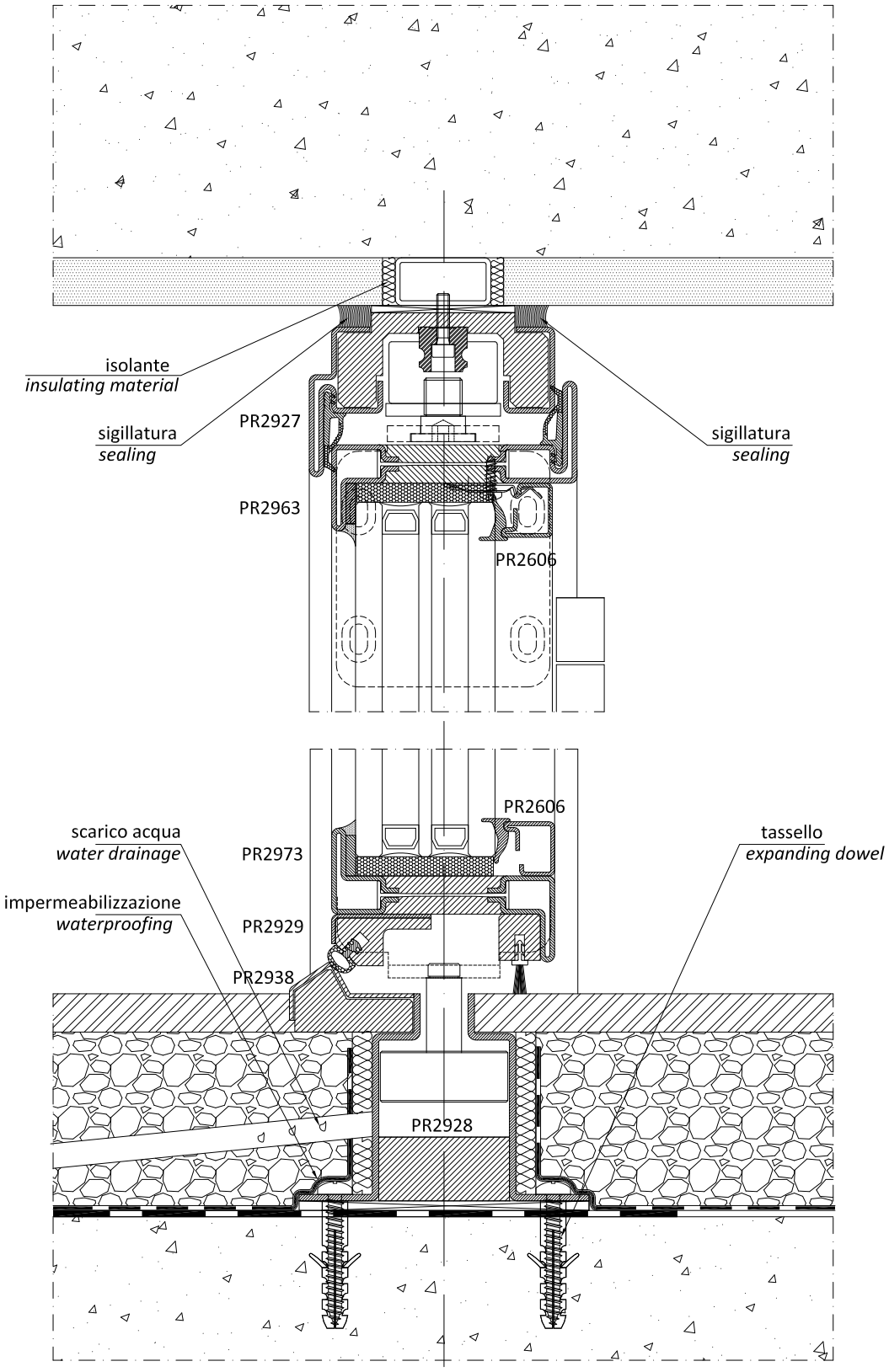

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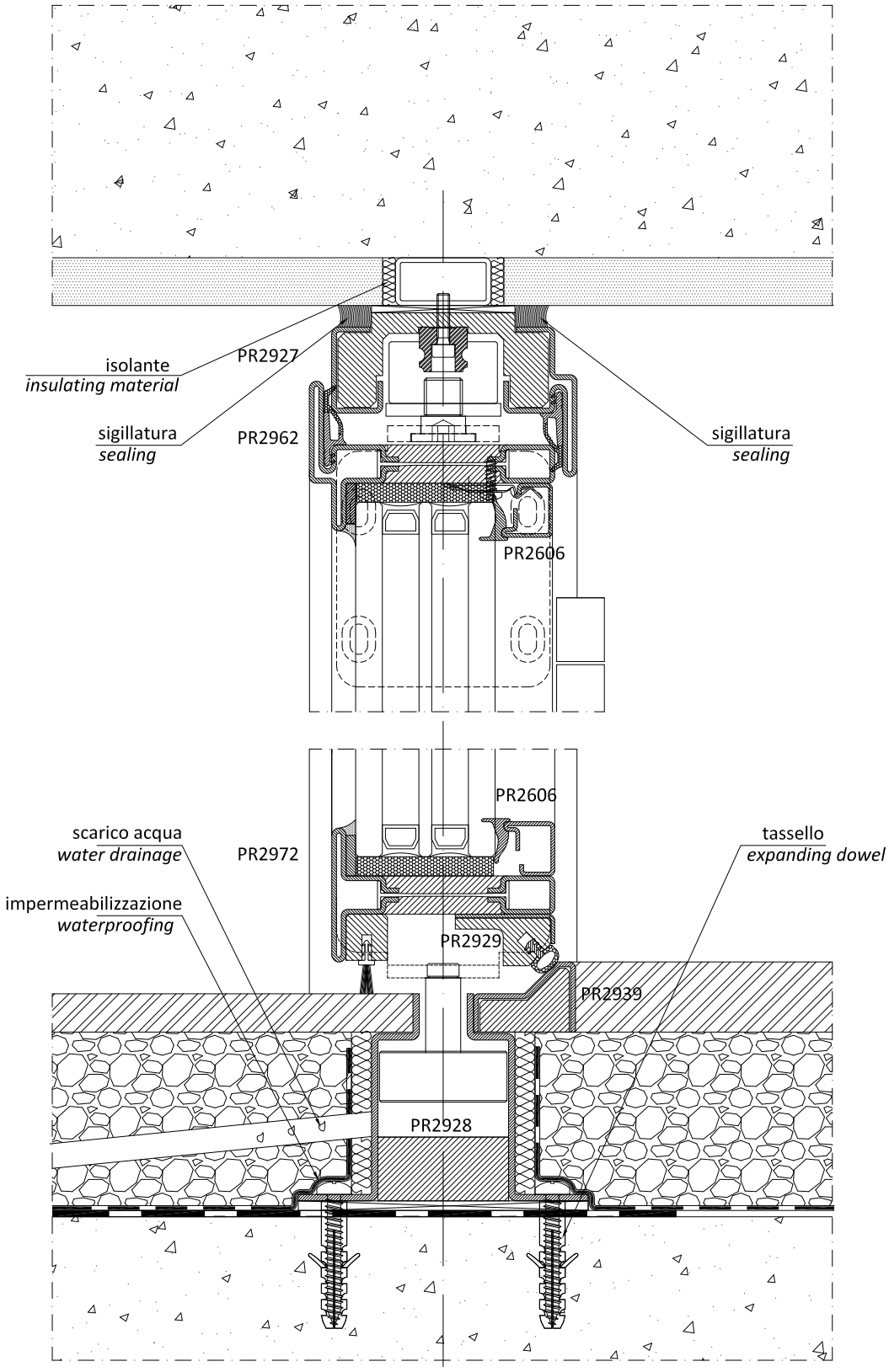

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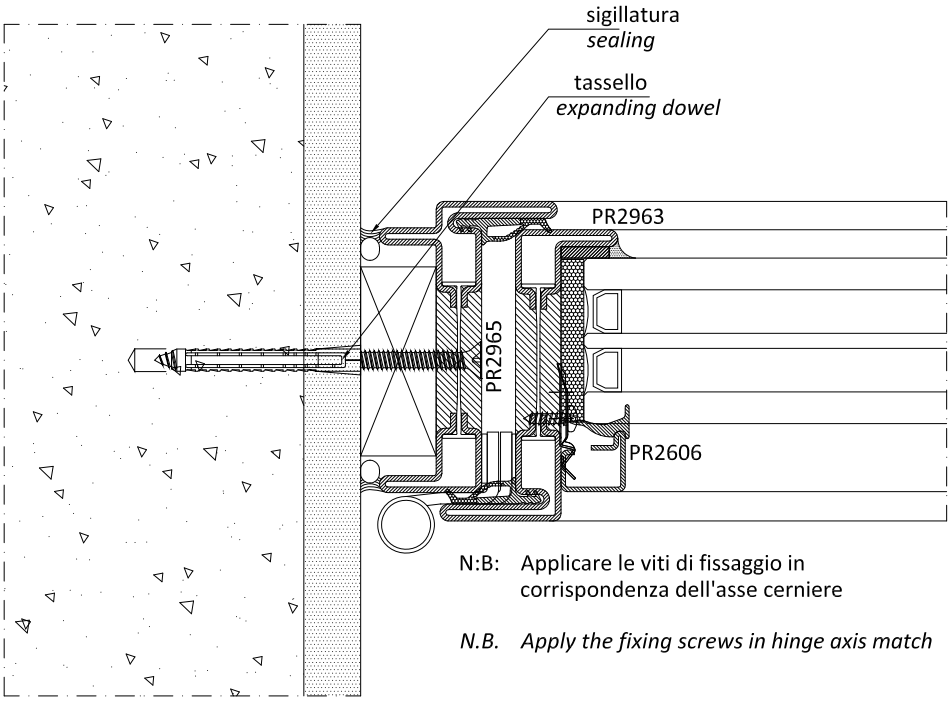

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PR2973
PR2929
PR2938
PR2928
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10
17
27
54
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65
91
GI


PR2606
PR2972
PR2929
PR2939
PR2928
42
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PR2606
PR2974
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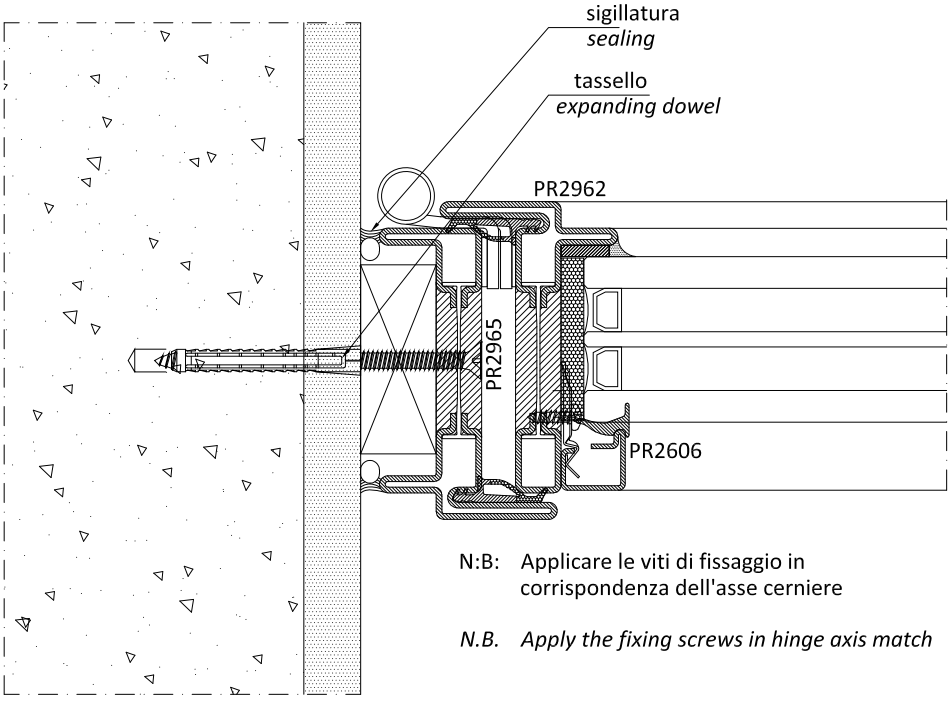

isolante
insulating material
sigillatura
sealing
PR2927
sigillatura
sealing
PR2963
PR2606
PR2606
scarico acqua
water drainage
PR2973
tassello
expanding dowel
impermeabilizzazione
waterproofing
PR2929
PR2938
PR2928


isolante
insulating material
PR2927
sigillatura
sealing
PR2962
sigillatura
sealing
PR2606
PR2606
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water drainage
PR2972
tassello
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PR2929
PR2939
PR2928



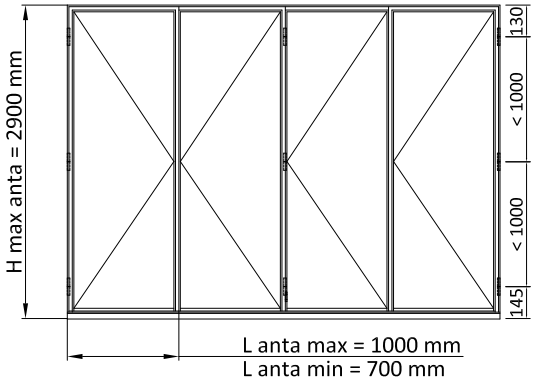
N:B: Applicare le viti di fissaggio in corrispondenza dell'asse cerniere

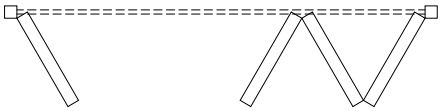
N.B. Apply the fixing screws in hinge axis match



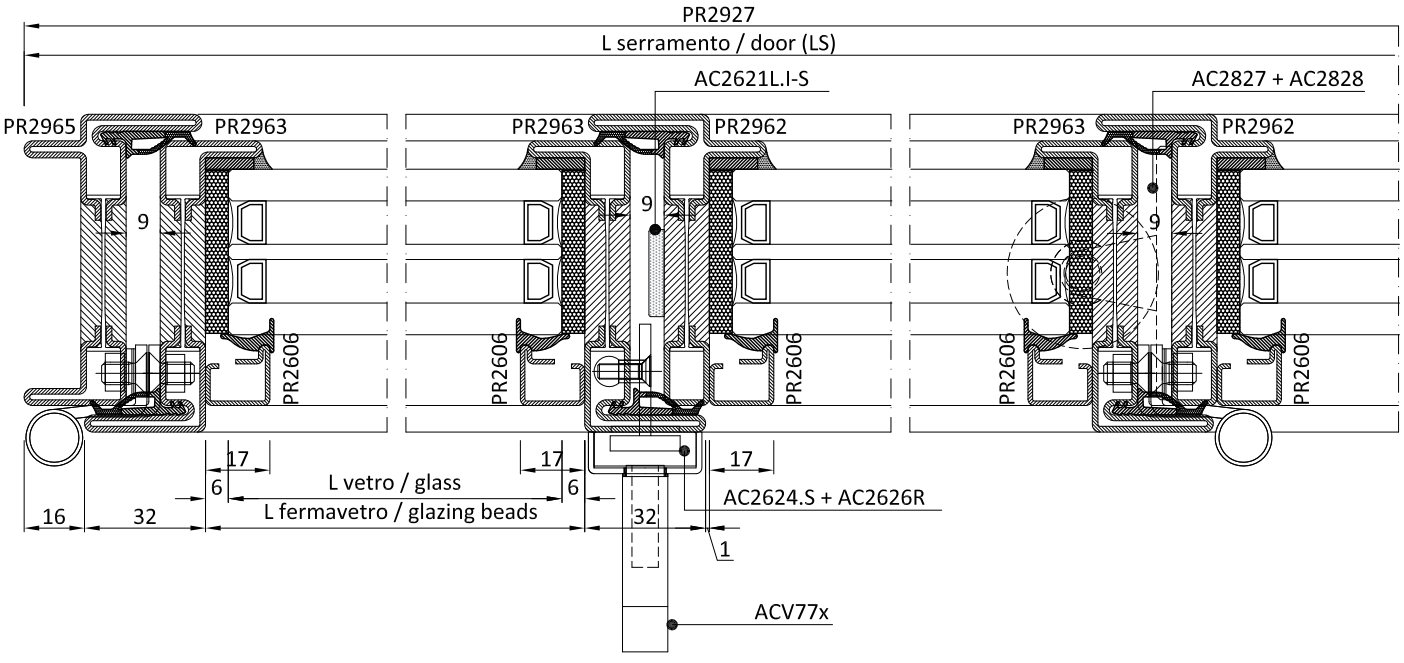
N:B: Applicare le viti di fissaggio in corrispondenza dell'asse cerniere

N.B. Apply the fixing screws in hinge axis match





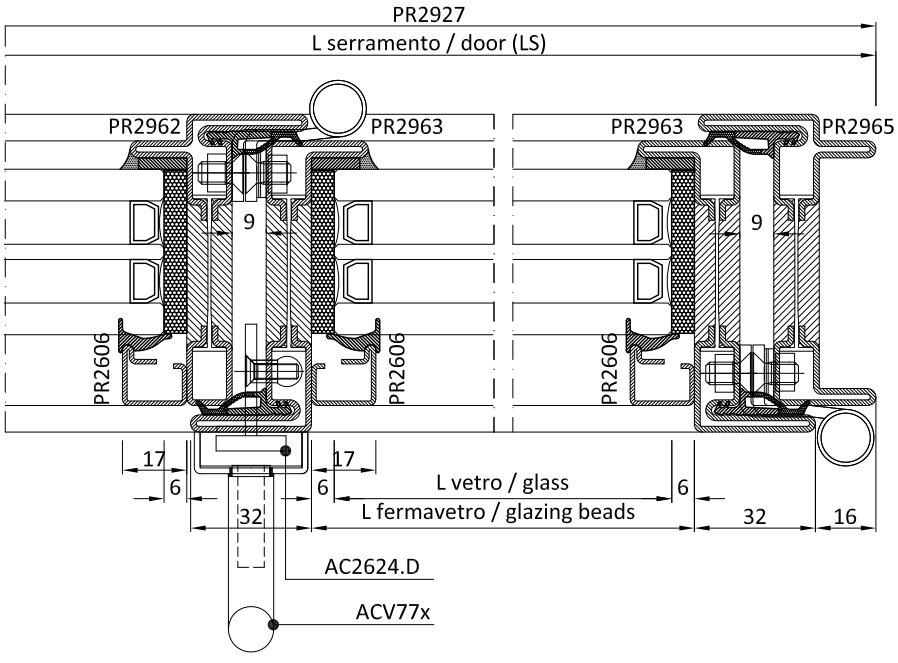
	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	45°	90°
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	90°	45°
PR2927a	Profilo Guida superiore	*Upper rail profile*	1	LS + 9	45°	45°
PR2927b	Guida superiore	*Upper rail*	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	*Bottom rail profile*	1	LS	90°	90°
PR2938	Profilo Battuta inferiore	*Lower fitting for profiles*	1	LS-54	90°	90°
	Anta	***Leaf***				
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	3	H-31.5	45°	90°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	2	H-31.5	90°	45°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	4	(LS+61)/4	45°	45°
PR2962	Profilo a "T" anta	*"T" profile leaf*	1	H-31.5	45°	90°
PR2962	Profilo a "T" anta	*"T" profile leaf*	2	H-31.5	90°	45°
PR2973	Profilo Zoccolo	*Socle profile*	4	(LS-195)/4	90°	90°
PR2929	Profilo Finitura Inferiore	*Bottom finishing profile*	4	(LS-99)/4	90°	90°
GU2926	Profilo porta spazzolino inferiore	*Lower brush profile*	4	(LS-99)/4	90°	90°
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	8	(LS-195)/4	45°	45°
PR2606	Profilo fermavetro	*Glazing bead profile*	8	H-90.5	45°	45°
	Vetri	***Glass unit***				
-	Vetrocamera	*Insulated glass*	4	(LS-243)/4 x HS-102		

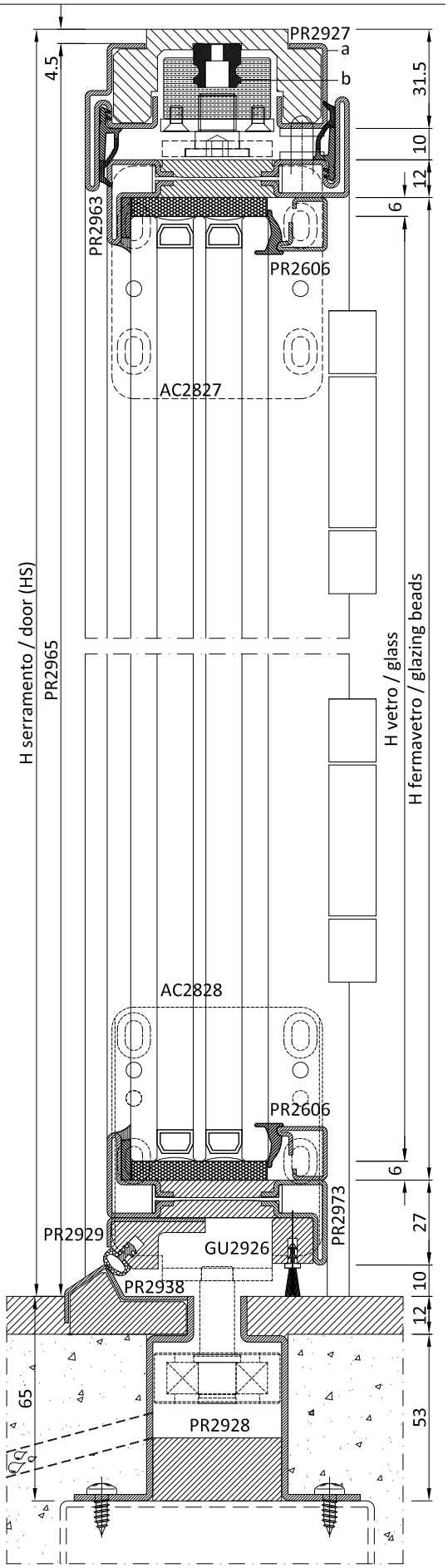


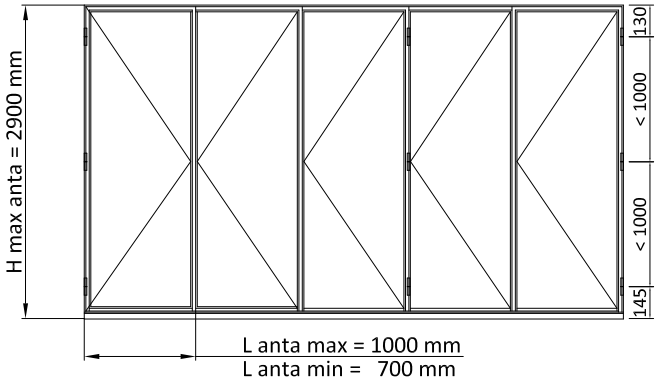
* solo con profili ottone
only with brass profiles

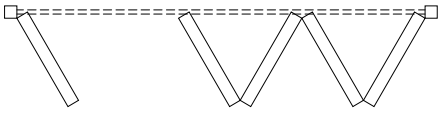
	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	Var.
AC2626R	Kit chiusura aggiuntiva	*Additional locking point*	Var.
AC2621L.I	Catenaccio 2^ anta (H 450)	*Second leaf bolt*	1
AC2621L.S	Catenaccio 2^ anta (H 650)	*Second leaf bolt*	1
AC2653.xx	Fondino per 2^ anta	*Botton plate for second leaf*	3
AC2656.xx	Fondino inferiore	*Lower fitting for profiles*	3
AC2818I	Staffa inf. aggancio telaio	*Bottom bracket*	1
AC2819	Kit tappo chiusura guida	*Rail closure cap*	1
AC1081T	Accessorio di battuta	*Stop Accessory*	5
AC2624.D	Kit cremonese	*Cremone bolt set*	1
AC2624.S	Kit cremonese	*Cremone bolt set*	1
AC2827	Carrello guida superiore	*Upper roller*	1
AC2828	Carrello guida inferiore	*Bottom roller*	1
AC2648.xx	Cerniere	*Hinges*	Var.
AC2825.xx	Kit magneti anta libera	*Magnet kit for free leaf*	1
AC2826.2	Kit magneti per blocco ante	*Magnet kit for leaf stop*	1
AC2828.F	Fermo corsa carrello inferiore	*Travel stop for bottom roller*	1
ACV77-.xx	Maniglia "Vitruvio"	*"Vitruvio" handle*	2
AC2803I*	Kit squadrette per PR2963	*Corner brackets kit for PR2963*	5
AC2832I*	Kit squadrette per PR2962-63	*Corner brackets kit for PR2962-63*	3

	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1001TT	Guarnizione di battuta soglia	*Treshold rebating gasket*	1	1xLS
GE2645TT	Guarnizione esterna di battuta	*Rebating gasket*	2	1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	*Gasket to put under the glass*	1	2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4xHS
GU0100	Guarnizione esterna	*Esternal weather strip*	1	1xLS

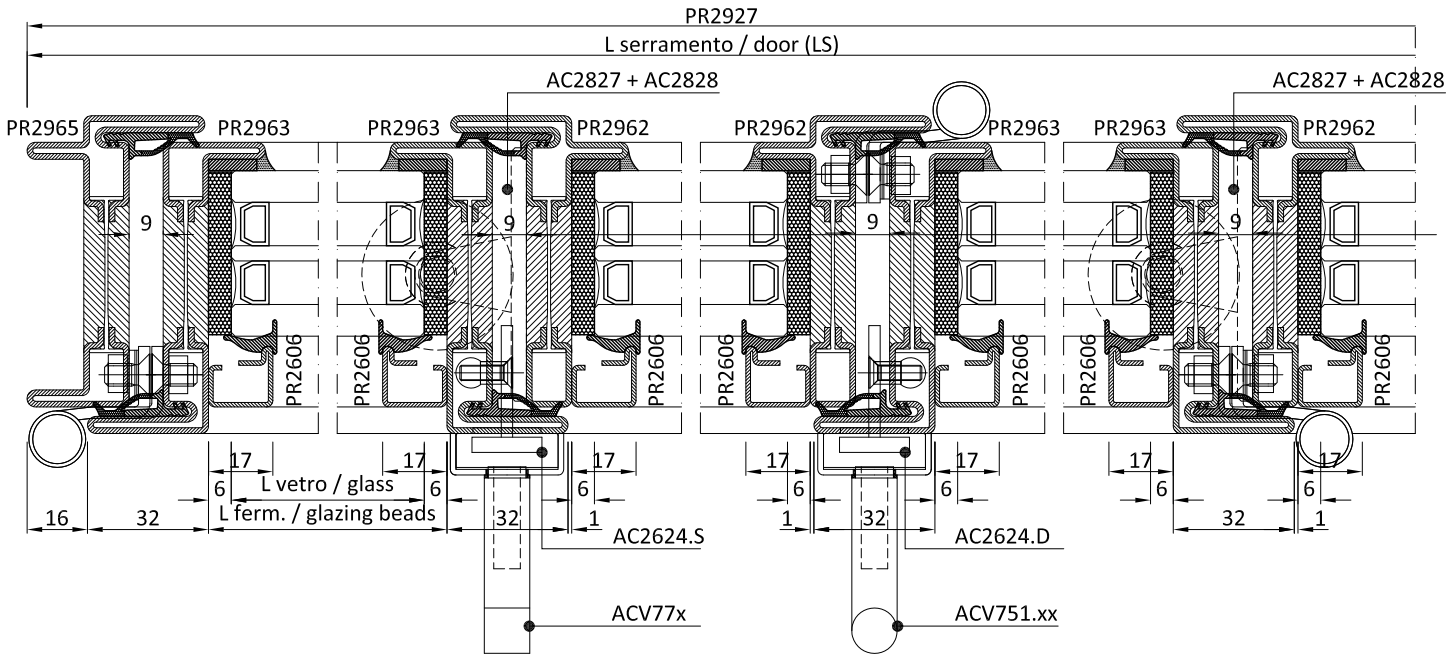








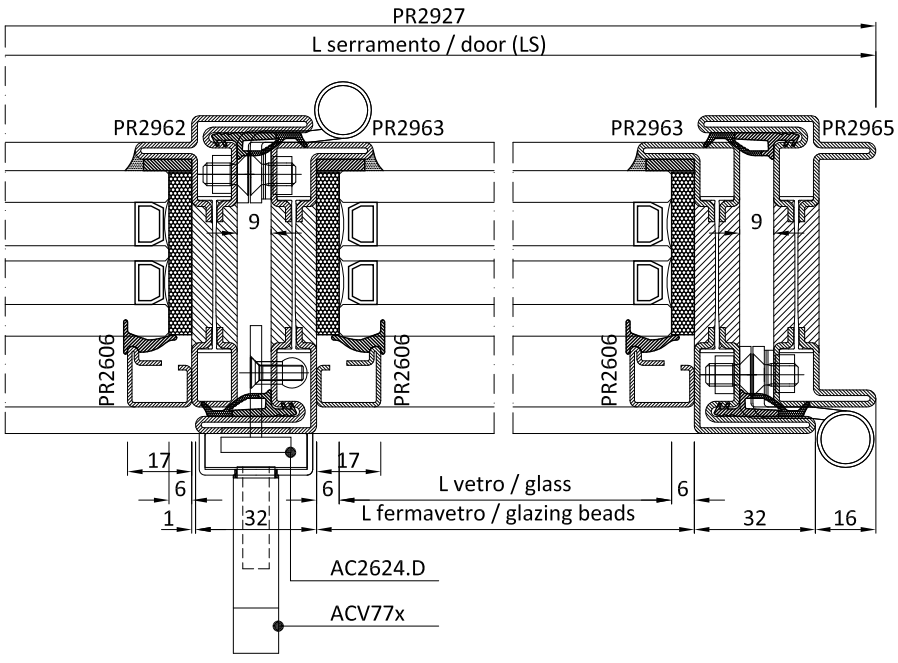
	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	45°	90°
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	90°	45°
PR2927a	Profilo Guida superiore	*Upper rail profile*	1	LS + 9	45°	45°
PR2927b	Guida superiore	*Upper rail*	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	*Bottom rail profile*	1	LS	90°	90°
PR2938	Profilo Battuta inferiore	*Bottom profile*	1	LS-54	90°	90°
	Anta	***Leaf***				
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	3	H-31.5	45°	90°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	3	H-31.5	90°	45°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	5	(LS+92)/5	45°	45°
PR2962	Profilo a "T" anta	*"T" profile leaf*	2	H-31.5	45°	90°
PR2962	Profilo a "T" anta	*"T" profile leaf*	2	H-31.5	90°	45°
PR2973	Profilo Zoccolo	*Socle profile*	5	(LS-228)/5	90°	90°
PR2929	Profilo Finitura Inferiore	*Bottom finishing profile*	5	(LS-108)/5	90°	90°
GU2926	Profilo porta spazzolino inferiore	*Lower brush profile*	5	(LS-108)/5	90°	90°
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	10	(LS-228)/5	45°	45°
PR2606	Profilo fermavetro	*Glazing bead profile*	10	H-90.5	45°	45°
	Vetri	***Glass unit***				
-	Vetrocamera	*Insulated glass*	5	(LS-288)/5 x HS-102		

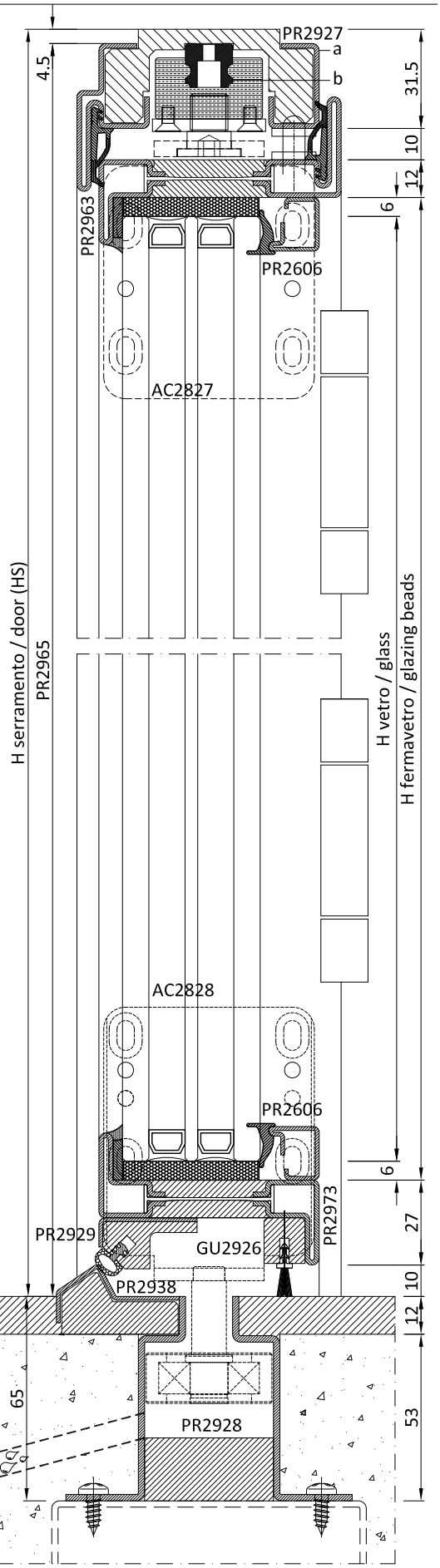


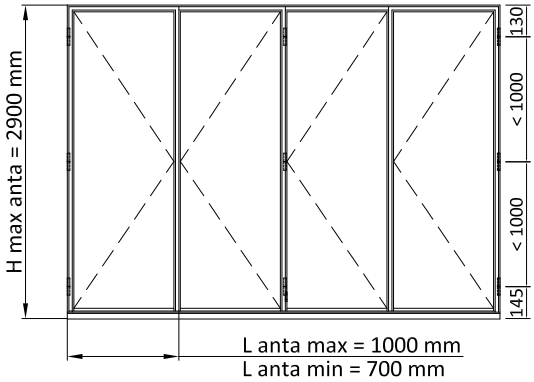
* solo con profili ottone
only with brass profiles

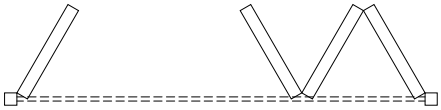
	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	Var.
AC2626R	Kit chiusura aggiuntiva	*Additional locking point*	Var.
AC2653.xx	Fondino per 2^ anta	*Botton plate for second leaf*	4
AC2656.xx	Fondino inferiore	*Lower fitting for profiles*	4
AC2818I	Staffa inf. aggancio telaio	*Bottom bracket*	1
AC2819	Kit tappo chiusura guida	*Rail closure cap*	1
AC1081T	Accessorio di battuta	*Stop Accessory*	6
AC2624.D	Kit cremonese	*Cremone bolt set*	2
AC2624.S	Kit cremonese	*Cremone bolt set*	1
AC2827	Carrello guida superiore	*Upper roller*	2
AC2828	Carrello guida inferiore	*Bottom roller*	2
AC2648.xx	Cerniere	*Hinges*	Var.
AC2826.4	Kit magneti per blocco ante	*Magnet kit for leaf stop*	1
AC2828.F	Fermo corsa carrello inferiore	*Travel stop for bottom roller*	1
ACV751.xx	Maniglia "Vitruvio" ridotta	*Reduced "Vitruvio" handle*	1
ACV77-.xx	Maniglia "Vitruvio"	*"Vitruvio" handle*	2
AC2803I*	Kit squadrette per PR2963	*Corner brackets kit for PR2963*	6
AC2832I*	Kit squadrette per PR2962-63	*Corner brackets kit for PR2962-63*	4

	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1001TT	Guarnizione di battuta soglia	*Treshold rebating gasket*	1	1xLS
GE2645TT	Guarnizione esterna di battuta	*Rebating gasket*	2	1xLS+6xHS
GE2907TT	Guarnizione sotto vetro	*Gasket to put under the glass*	2	1xLS+5xHS
GU2036	Piattina adesiva fondo giunto	*Adhesive shim for joint*	2	1xLS+5xHS
GP0095	Guarnizione interna vetro	*Internal weather strip*	2	1xLS+5xHS
GU0100	Spazzolino soglia	*Threshold brush*	1	1xLS

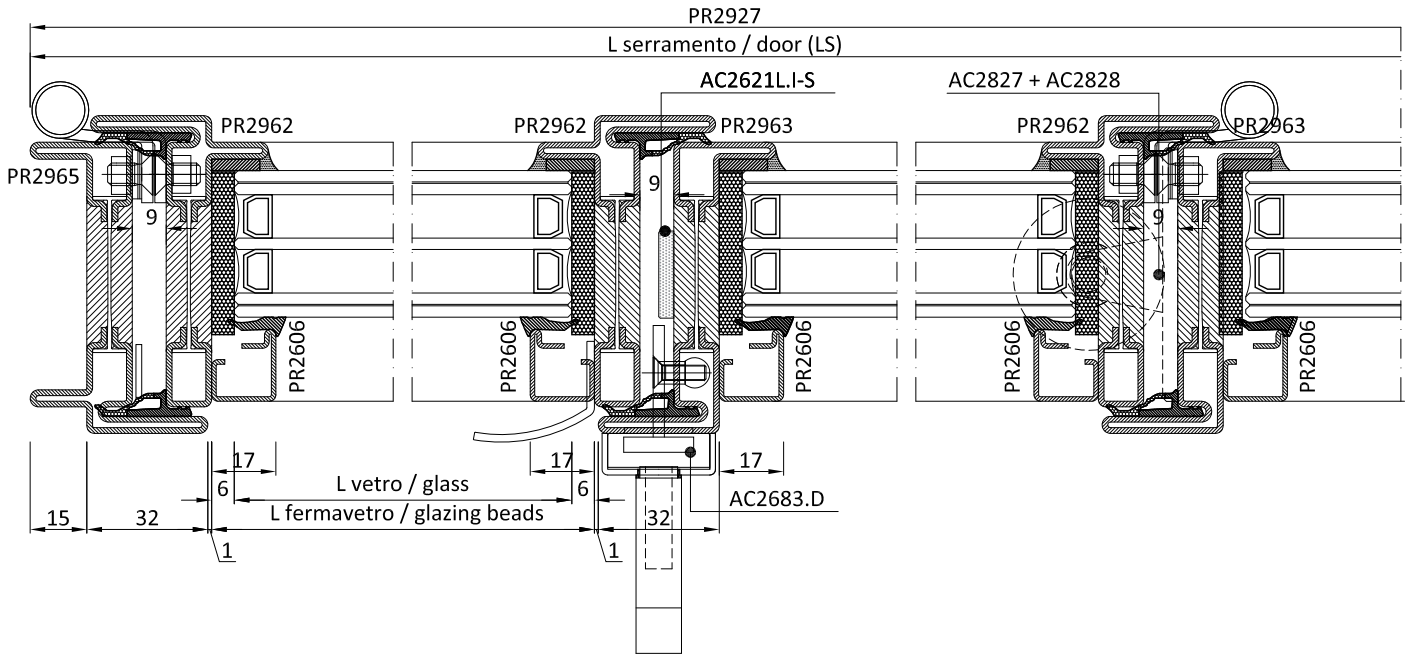








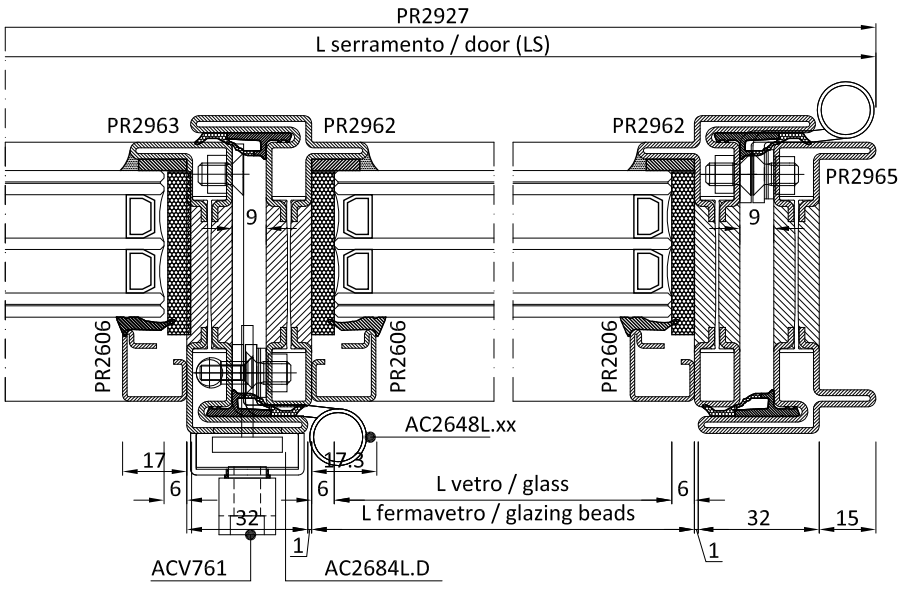
	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	45°	90°
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	90°	45°
PR2927a	Profilo Guida superiore	*Upper rail profile*	1	LS + 9	45°	45°
PR2927b	Guida Superiore	*Upper rail*	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	*Bottom rail profile*	1	LS	90°	90°
PR2939	Profilo Battuta inferiore	*Lower fitting for profiles*	1	LS-54	90°	90°
	Anta	***Leaf***				
PR2962	Profilo a "T" anta	*"T" profile leaf*	3	HS-31.5	45°	90°
PR2962	Profilo a "T" anta	*"T" profile leaf*	2	HS-31.5	90°	45°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-31.5	45°	90°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-31.5	90°	45°
PR2962	Profilo a "T" anta	*"T" profile leaf*	4	(LS+61)/4	45°	45°
PR2972	Profilo Zoccolo	*Socle profile*	4	(LS-195)/4	90°	90°
PR2929	Profilo Finitura Inferiore	*Bottom finishing profile*	4	(LS-99)/4	90°	90°
GU2926	Profilo porta spazzolino inferiore	*Lower brush profile*	4	(LS-99)/4	90°	90°
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	8	(LS-195)/4	45°	45°
PR2606	Profilo fermavetro	*Glazing bead profile*	8	HS-90.5	45°	45°
	Vetri	***Glass unit***				
-	Vetrocamera	*Insulated glass*	4	(LS-243)/4 x HS-102		

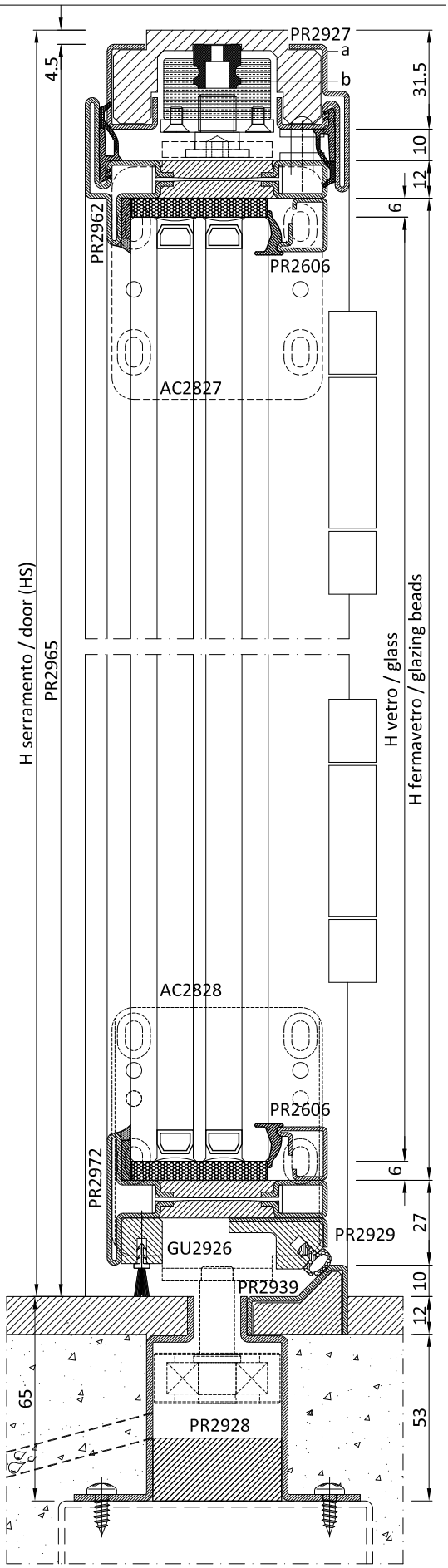


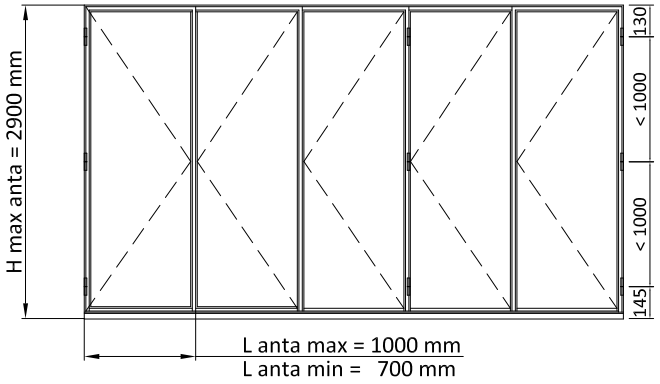
* solo con profili ottone
only with brass profiles

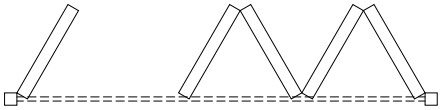
	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	Var.
AC2626R	Kit chiusura aggiuntiva	*Additional locking point*	Var.
AC2621L.I	Catenaccio 2^ anta (H 450)	*Second leaf bolt*	1
AC2621L.S	Catenaccio 2^ anta (H 650)	*Second leaf bolt*	1
AC2653.xx	Fondino per 2^ anta	*Botton plate for second leaf*	3
AC2656.xx	Fondino inferiore	*Lower fitting for profiles*	3
AC2818I	Staffa inf. aggancio telaio	*Bottom bracket*	1
AC2819	Kit tappo chiusura guida	*Rail closure cap*	1
AC1081T	Accessorio di battuta	*Stop Accessory*	5
AC2683.D/S	Kit cremonese	*Cremone bolt set*	1
AC2684L.D/S	Kit cremonese	*Cremone bolt set*	1
AC2827	Carrello guida superiore	*Upper roller*	1
AC2828	Carrello guida inferiore	*Bottom roller*	1
AC2648.xx	Cerniere	*Hinges*	Var.
AC2648L.xx	Cerniere	*Hinges*	Var.
AC2825.xx	Kit magneti anta libera	*Magnet kit for free leaf*	1
AC2826.2	Kit magneti per blocco ante	*Magnet kit for leaf stop*	1
AC2828.F	Fermo corsa carrello inferiore	*Travel stop for bottom roller*	1
AC2680.xx	Maniglia di trascinamento	*Pulling handle*	1
ACV751.xx	Maniglia "Vitruvio"	*"Vitruvio" handle*	1
ACV761.xx	Maniglia "Vitruvio" ridotta	*Reduced "Vitruvio" handle*	1
AC2862I*	Kit squadrette per PR2962	*Corner brackets kit for PR2962*	5
AC2832I*	Kit squadrette per PR2962-63	*Corner brackets kit for PR2962-63*	3

	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1001TT	Guarnizione di battuta soglia	*Treshold rebating gasket*	1	1xLS
GE2645TT	Guarnizione esterna di battuta	*Rebating gasket*	2	1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	*Gasket to put under the glass*	1	2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4xHS
GU0100	Guarnizione esterna	*Esternal weather strip*	1	1xLS

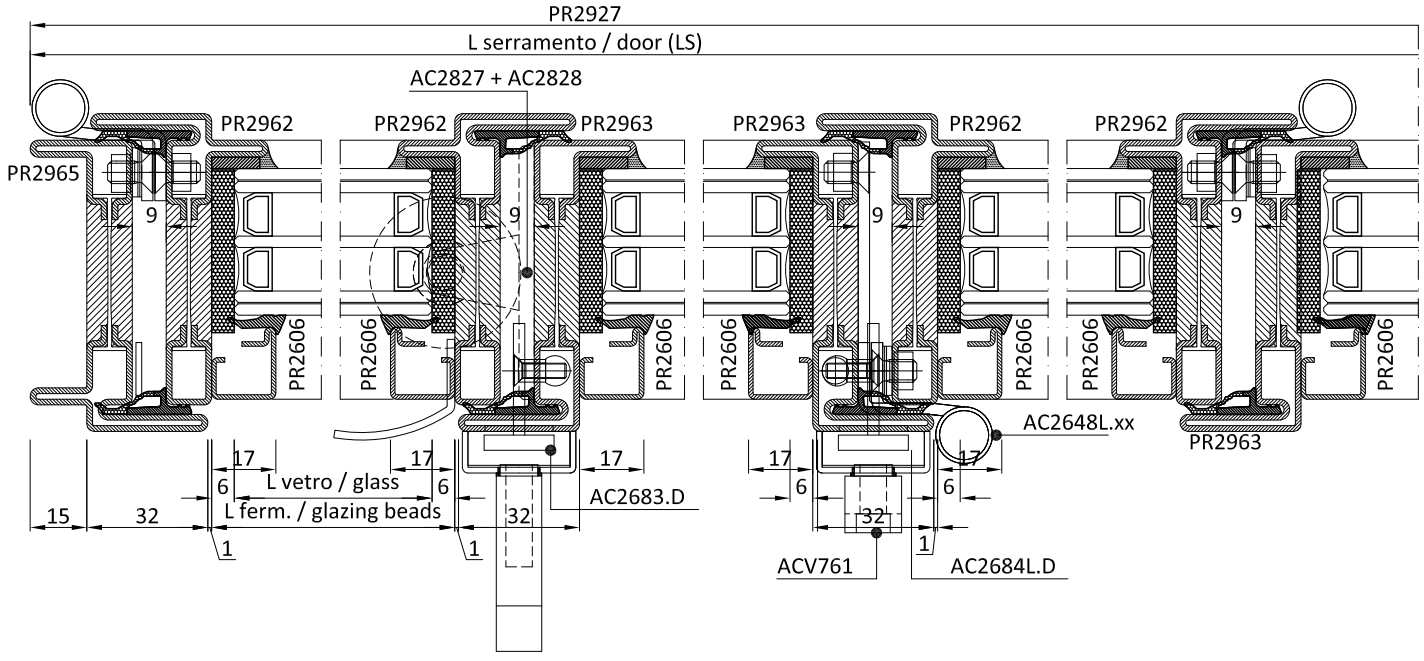








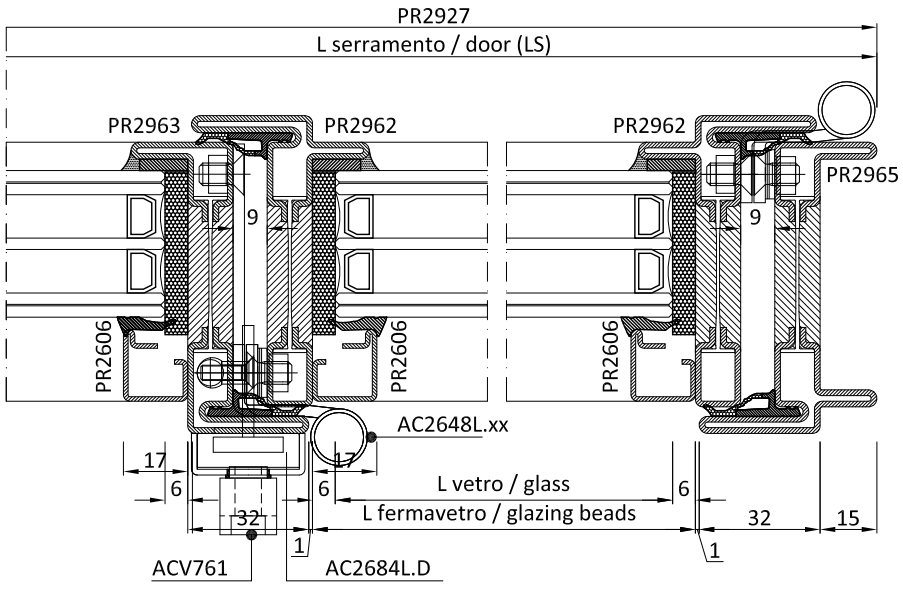
	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	45°	90°
PR2965	Profilo Zoccolo	*Socle profile*	1	HS-4.5	90°	45°
PR2927a	Profilo Guida superiore	*Upper rail profile*	1	LS + 9	45°	45°
PR2927b	Guida Superiore	*Upper rail*	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	*Bottom rail profile*	1	LS	90°	90°
PR2939	Profilo Battuta inferiore	*Lower fitting for profiles*	1	LS-54	90°	90°
	Anta	***Leaf***				
PR2962	Profilo a "T" anta	*"T" profile leaf*	3	HS-31.5	45°	90°
PR2962	Profilo a "T" anta	*"T" profile leaf*	3	HS-31.5	90°	45°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-31.5	45°	90°
PR2963	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-31.5	90°	45°
PR2962	Profilo a "T" anta	*"T" profile leaf*	5	(LS+92)/5	45°	45°
PR2972	Profilo Zoccolo	*Socle profile*	5	(LS-228)/5	90°	90°
PR2929	Profilo Finitura Inferiore	*Bottom finishing profile*	5	(LS-108)/5	90°	90°
GU2926	Profilo porta spazzolino inferiore	*Lower brush profile*	5	(LS-108)/5	90°	90°
	Fermavetri	***Glazing beads***				
PR2606	Profilo fermavetro	*Glazing bead profile*	10	(LS-228)/5	45°	45°
PR2606	Profilo fermavetro	*Glazing bead profile*	10	HS-90.5	45°	45°
	Vetri	***Glass unit***				
-	Vetrocamera	*Insulated glass*	5	(LS-288)/5 x HS-102		

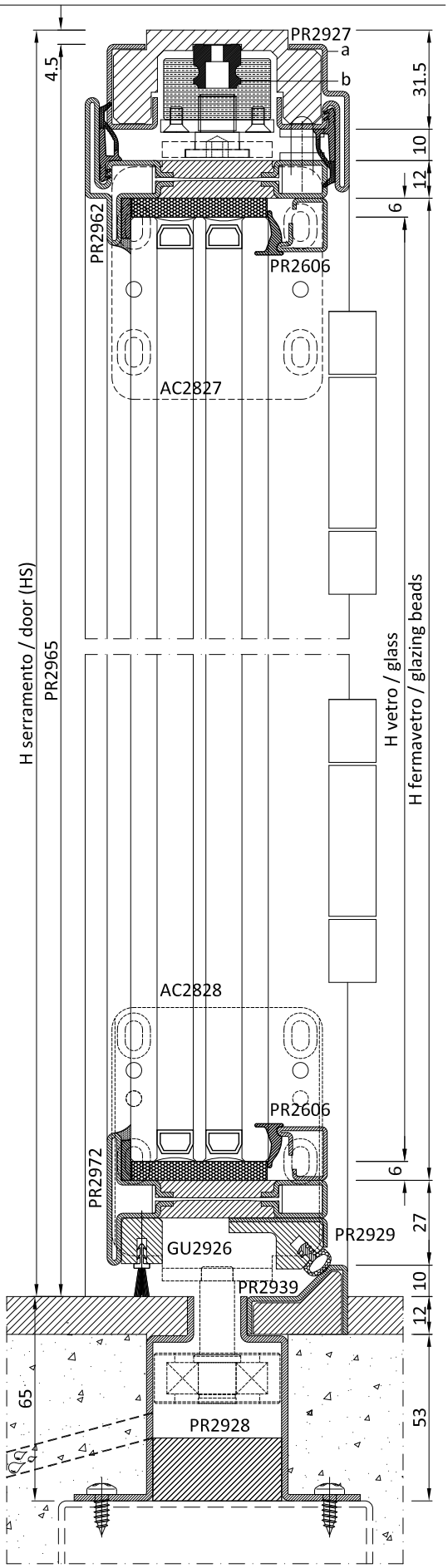


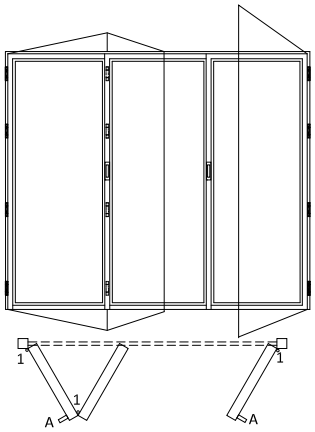
* solo con profili ottone
only with brass profiles

	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	Var.
AC2626R	Kit chiusura aggiuntiva	*Additional locking point*	Var.
AC2653.xx	Fondino per 2^ anta	*Botton plate for second leaf*	4
AC2656.xx	Fondino inferiore	*Lower fitting for profiles*	4
AC2818I	Staffa inf. aggancio telaio	*Bottom bracket*	1
AC2819	Kit tappo chiusura guida	*Rail closure cap*	1
AC1081T	Accessorio di battuta	*Stop Accessory*	6
AC2684L.D/S	Kit cremonese	*Cremone bolt set*	2
AC2683.D/S	Kit cremonese	*Cremone bolt set*	1
AC2827	Carrello guida superiore	*Upper roller*	2
AC2828	Carrello guida inferiore	*Bottom roller*	2
AC2648.xx	Cerniere	*Hinges*	Var.
AC2648L.xx	Cerniere	*Hinges*	Var.
AC2826.4	Kit magneti per blocco ante	*Magnet kit for leaf stop*	1
AC2828.F	Fermo corsa carrello inferiore	*Travel stop for bottom roller*	1
AC2680.xx	Maniglia di trascinamento	*Pulling handle*	1
ACV751.xx	Maniglia "Vitruvio" ridotta	*Reduced "Vitruvio" handle*	1
ACV761.xx	Maniglia "Vitruvio"	*"Vitruvio" handle*	2
AC2862I*	Kit squadrette per PR2962	*Corner brackets kit for PR2962*	6
AC2832I*	Kit squadrette per PR2962-63	*Corner brackets kit for PR2962-63*	4

	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1001TT	Guarnizione di battuta soglia	*Treshold rebating gasket*	1	1xLS
GE2645TT	Guarnizione esterna di battuta	*Rebating gasket*	2	1xLS+6xHS
GE2907TT	Guarnizione sotto vetro	*Gasket to put under the glass*	2	1xLS+5xHS
GU2036	Piattina adesiva fondo giunto	*Adhesive shim for joint*	2	1xLS+5xHS
GP0095	Guarnizione interna vetro	*Internal weather strip*	2	1xLS+5xHS
GU0100	Spazzolino soglia	*Threshold brush*	1	1xLS

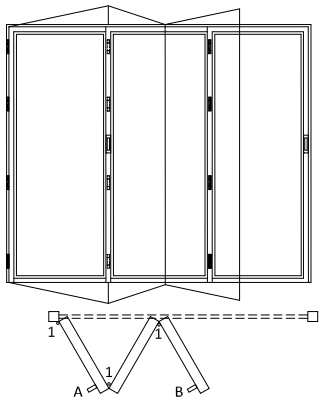






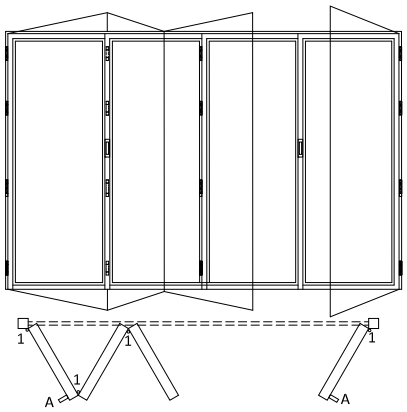
APERTURA INTERNA 2+1
INWARD OPENING 2+1

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2624.D	Kit cremonese Dx chiusura *Cremone bolt set Rh*	1 pz.	4.3.12 4.5.1-2
AC2624.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	1 pz.	4.3.12 4.5.1-2
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	2 pz.	4.5.29



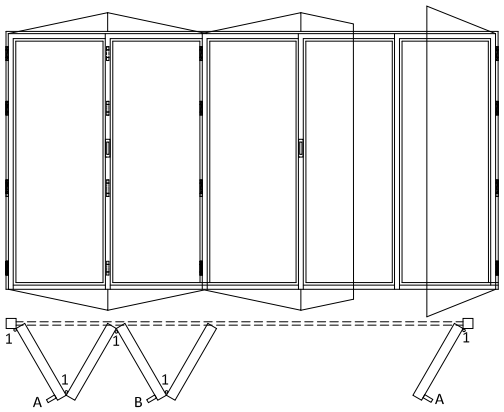
APERTURA INTERNA 3+0
INWARD OPENING 3+0

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2624.S	Kit cremonese Dx chiusura *Cremone bolt set Rh*	2 pz.	4.3.12 4.5.1-2
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.29
ACV751.xx (B)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.27



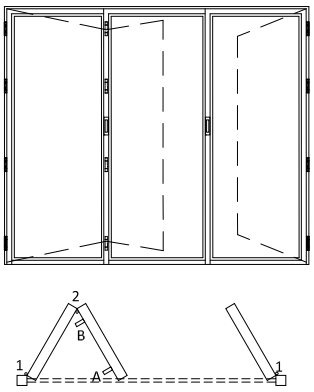
APERTURA INTERNA 3+1
INWARD OPENING 3+1

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2624.D	Kit cremonese Dx chiusura *Cremone bolt set Rh*	1 pz.	4.3.12 4.5.1-2
AC2624.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	1 pz.	4.3.12 4.5.1-2
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	2 pz.	4.5.29
AC2621L.I	Catenaccio Inferiore *Bottom flush bolt*	1 pz.	4.3.22-23
AC2621L.S	Catenaccio Superiore *Upper flush bolt*	1 pz.	4.3.24-25



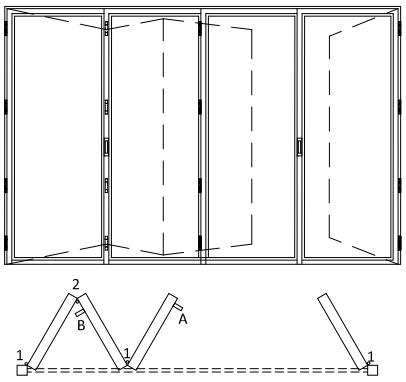
APERTURA INTERNA 4+1
INWARD OPENING 4+1

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2624.D	Kit cremonese Dx chiusura *Cremone bolt set Rh*	1 pz.	4.3.12 4.5.1-2
AC2624.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	2 pz.	4.3.12 4.5.1-2
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	2 pz.	4.5.29
ACV751.xx (B)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.27



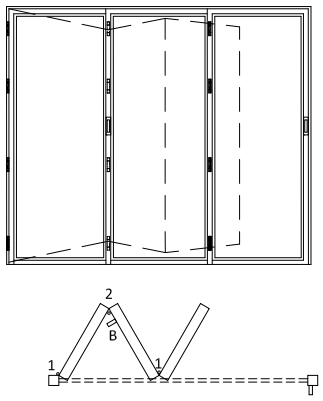
APERTURA ESTERNA 2+1
OUTWARD OPENING 2+1

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2683.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	1 pz.	4.3.13 4.5.3-4
AC2684L.S	Kit cremonese Sx man. ridotta *Cremone bolt set Lh red. hand.*	1 pz.	4.3.14 4.5.5-6
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
AC2648L.xx (2)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.17
ACV751.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.27
ACV761.xx (B)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.28
AC2680.xx	Maniglia di trascinamento *Pulling handle*	1 pz.	4.5.8



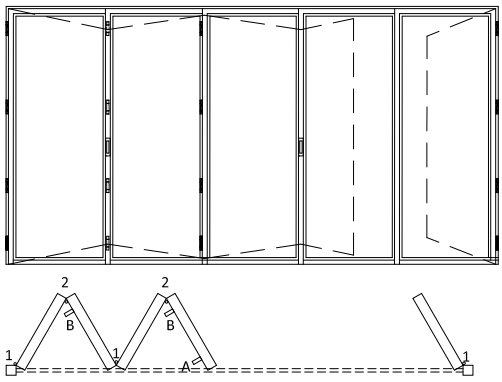
APERTURA ESTERNA 3+1
OUTNWARD OPENING 3+1

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2683.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	1 pz.	4.3.13 4.5.3-4
AC2684L.S	Kit cremonese Sx man. ridotta *Cremone bolt set Lh red. hand.*	1 pz.	4.3.14 4.5.5-6
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
AC2648L.xx (2)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.17
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.29
ACV761.xx (B)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.28
AC2680.xx	Maniglia di trascinamento *Pulling handle*	1 pz.	4.5.8



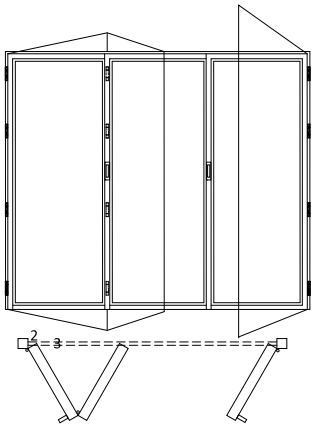
APERTURA ESTERNA 3+0
OUTNWARD OPENING 3+0

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2683.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	1 pz.	4.3.13 4.5.3-4
AC2684L.S	Kit cremonese Sx man. ridotta *Cremone bolt set Lh red. hand.*	1 pz.	4.3.14 4.5.5-6
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
AC2648L.xx (2)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.17
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.29
ACV761.xx (B)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.28
AC2680.xx	Maniglia di trascinamento *Pulling handle*	1 pz.	4.5.8



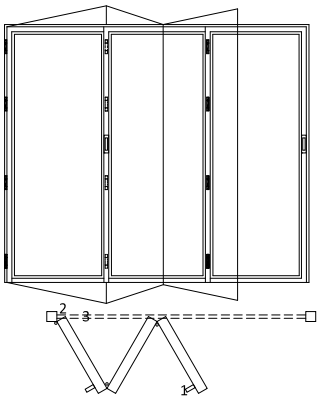
APERTURA ESTERNA 4+1
OUTNWARD OPENING 4+1

Art. *Code*	Descrizione *Description*	Q.tà	Pag.
AC2683.S	Kit cremonese Sx chiusura *Cremone bolt set Lh*	1 pz.	4.3.13 4.5.3-4
AC2684L.S	Kit cremonese Sx man. ridotta *Cremone bolt set Lh red. hand.*	2 pz.	4.3.14 4.5.5-6
AC2626R	Punto di chiusura aggiuntivo *Additional locking point*	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.16
AC2648L.xx (2)	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	Var.	4.3.17
ACV77_.xx (A)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	1 pz.	4.5.29
ACV761.xx (B)	Martellina cremonese "Vitruvio" *Cremone Handle "Vitruvio"*	2 pz.	4.5.28
AC2680.xx	Maniglia di trascinamento *Pulling handle*	1 pz.	4.5.8



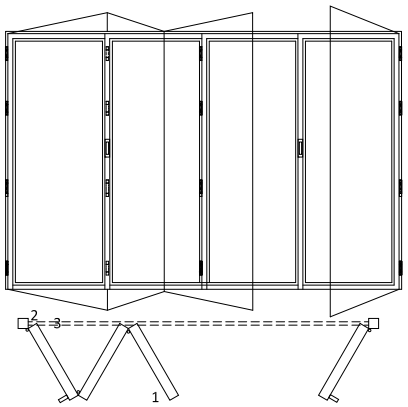
APERTURA INTERNA 2+1
INWARD OPENING 2+1

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2826.2 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.29
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31



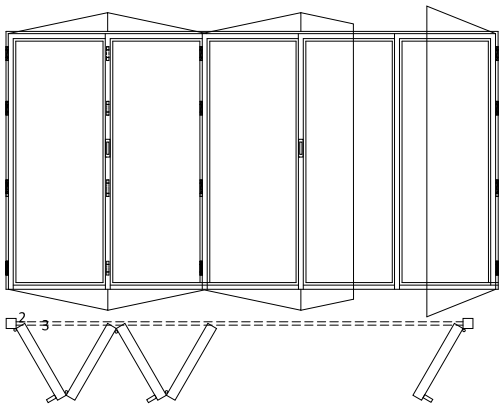
APERTURA INTERNA 3+0
INWARD OPENING 3+0

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2825.xx (1)	Kit magneti carrelli blocco anta libera *Magnet kit for retain free leaf*	1 pz.	4.5.30
AC2826.2 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.29
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31



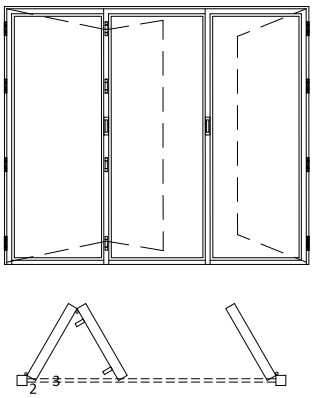
APERTURA INTERNA 3+1
INWARD OPENING 3+1

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2825.xx (1)	Kit magneti carrelli blocco anta libera *Magnet kit for retain free leaf*	1 pz.	4.5.30
AC2826.2 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.29
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31



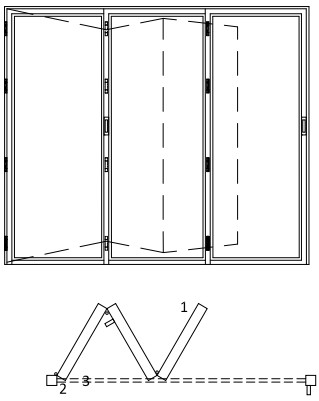
APERTURA INTERNA 4+1
INWARD OPENING 4+1

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2826.4 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.28
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31



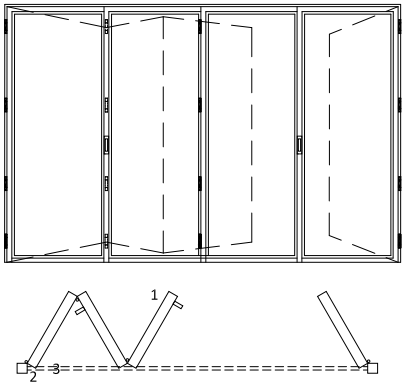
APERTURA ESTERNA 2+1
OUTWARD OPENING 2+1

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2826.2 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.29
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31



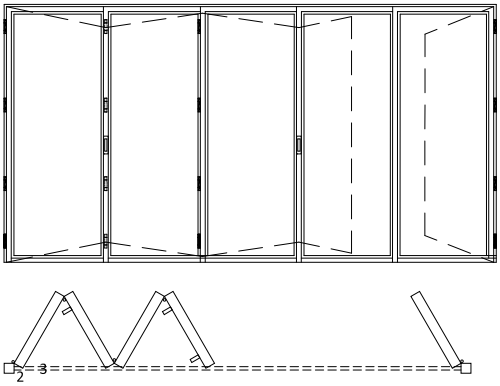
APERTURA ESTERNA 3+0
OUTNWARD OPENING 3+0

Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2825.xx (1)	Kit magneti carrelli blocco anta libera *Magnet kit for retain free leaf*	1 pz.	4.5.30
AC2826.2 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.29
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31



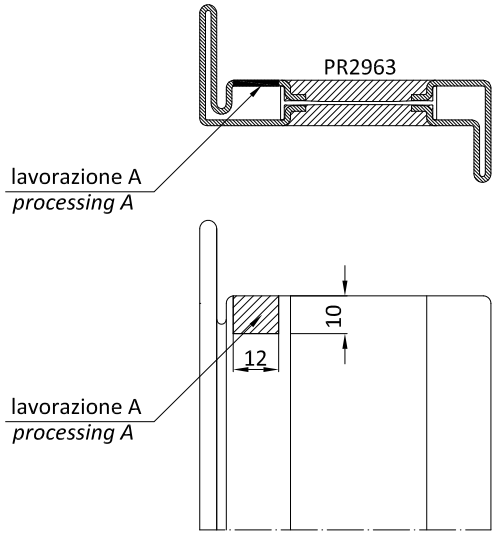
APERTURA ESTERNA 3+1
OUTNWARD OPENING 3+1

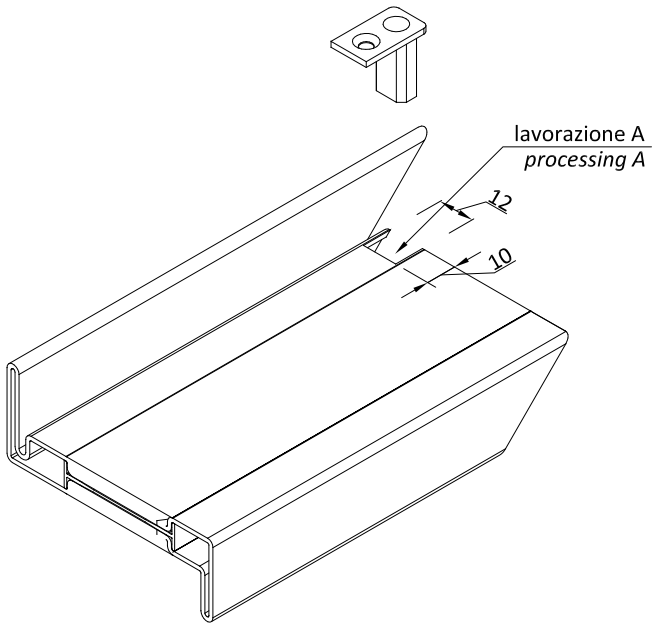
Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2825.xx (1)	Kit magneti carrelli blocco anta libera *Magnet kit for retain free leaf*	1 pz.	4.5.30
AC2826.2 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.29
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31

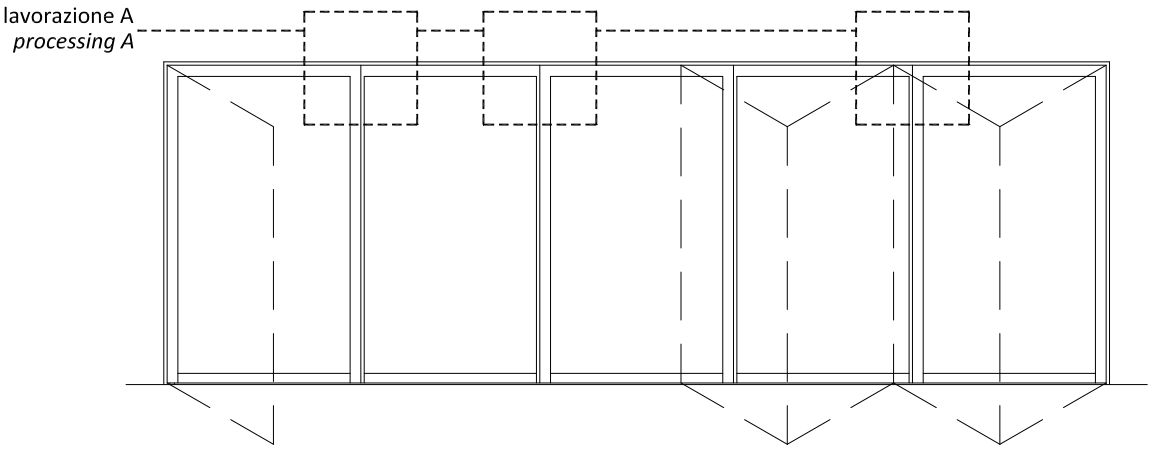


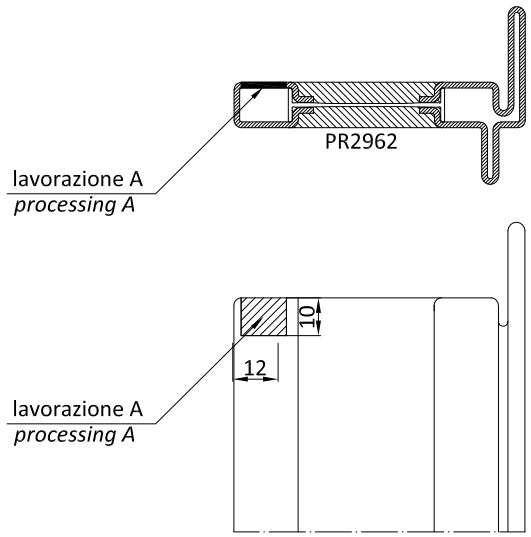
APERTURA ESTERNA 4+1
OUTNWARD OPENING 4+1

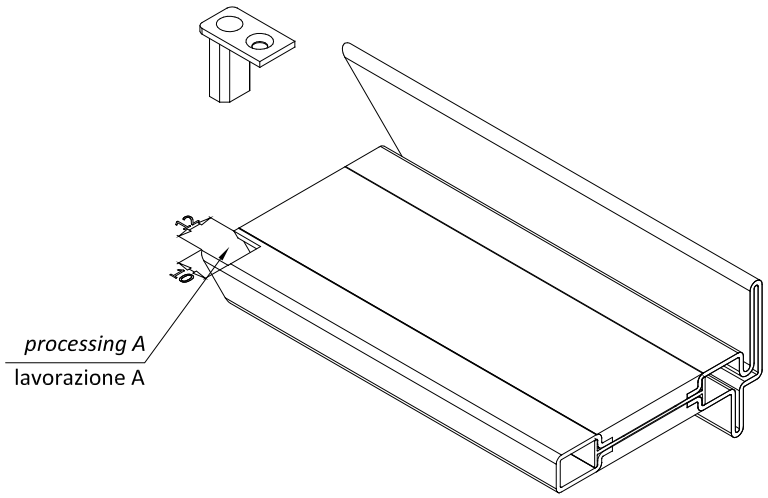
Art. Code	Descrizione *Description*	Q.tà	Pag.
AC2826.4 (2)	Kit magneti per blocco ante impacchettate *Magnet kit upper for folding leaf stop*	1 pz.	4.5.28
AC2828.F (3)	Fermo corsa per carrello inferiore *Travel stop for bottom roller*	1 pz.	4.5.31

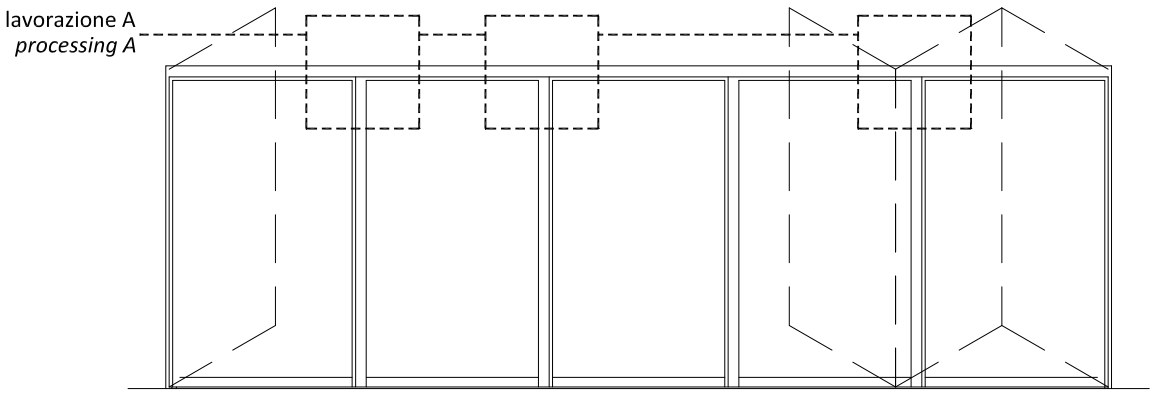

PR2963
lavorazione A
processing A
10
12
lavorazione A
processing A

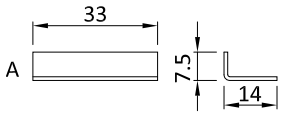

lavorazione A
processing A
12
10

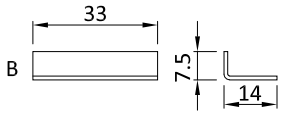

lavorazione A
processing A

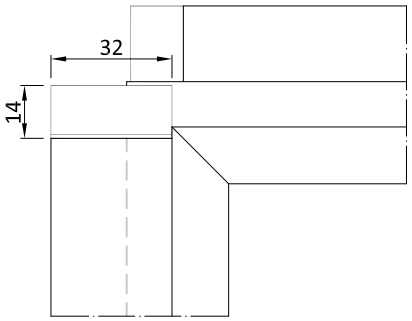

PR2962
lavorazione A
processing A
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lavorazione A
processing A

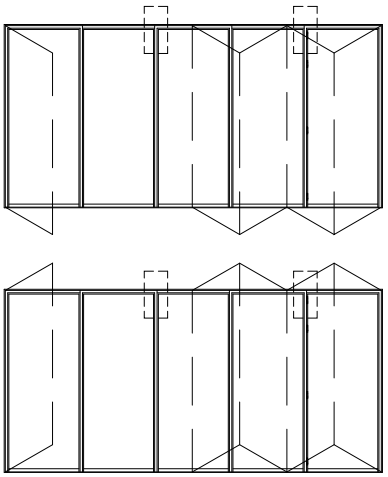

2
10
processing A
lavorazione A

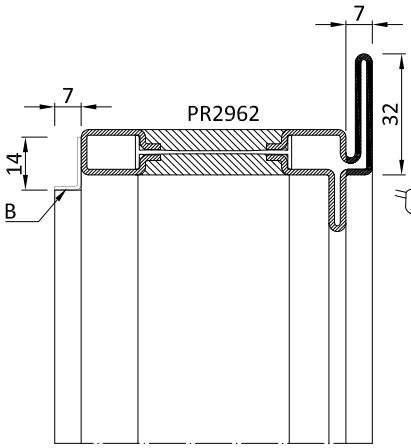

lavorazione A
processing A

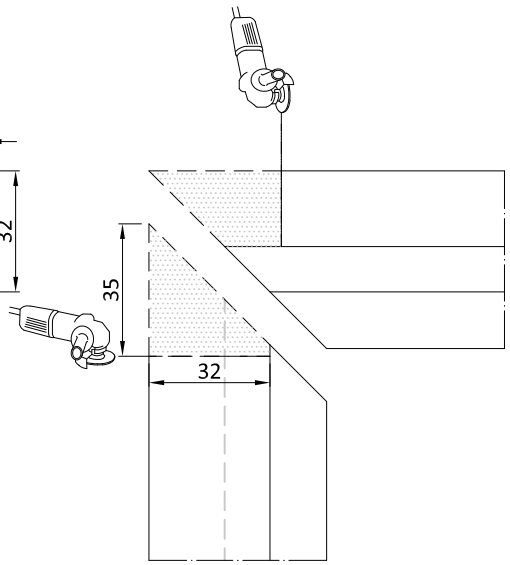


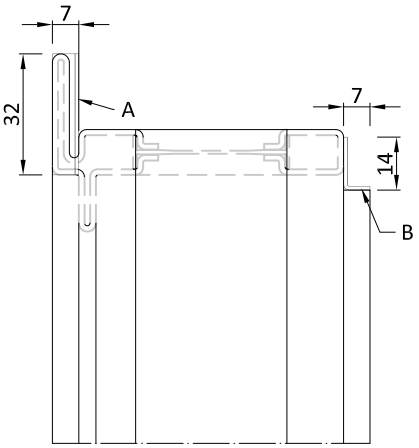


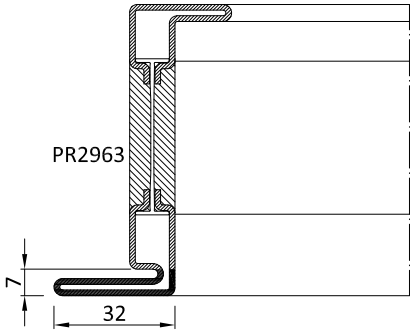


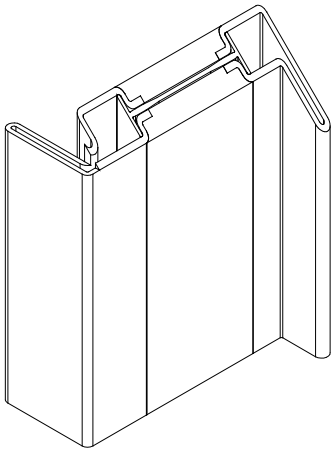


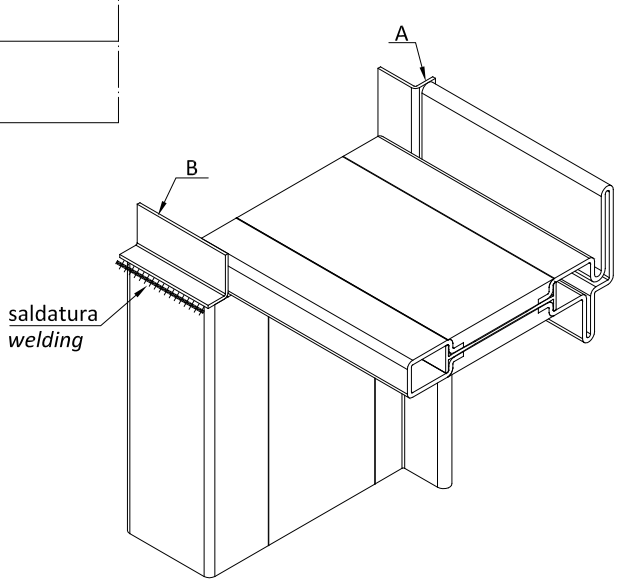




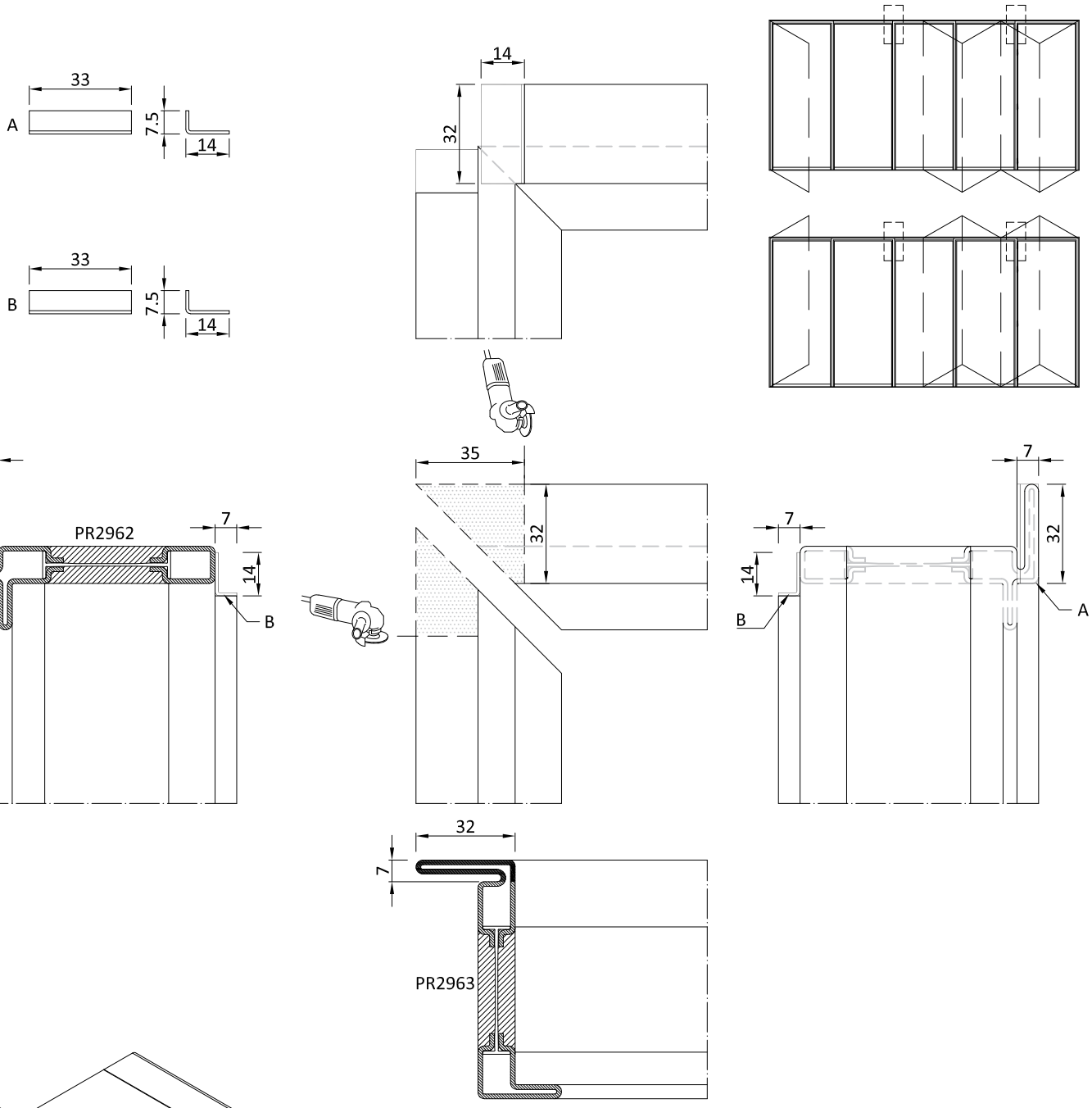




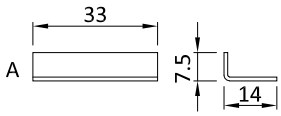


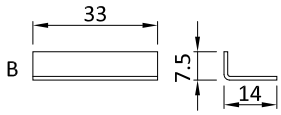


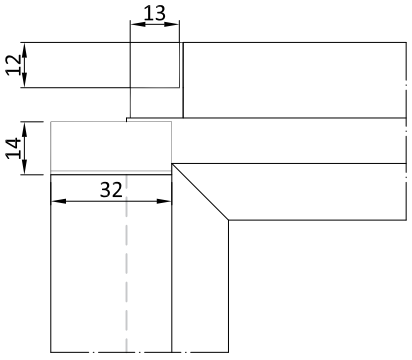
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

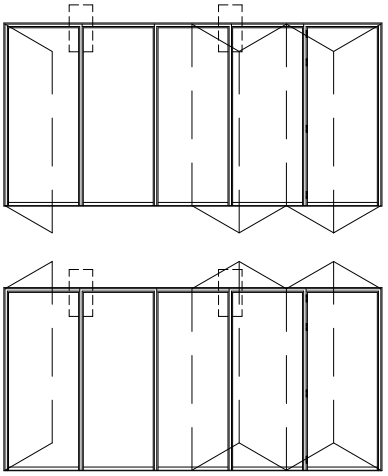


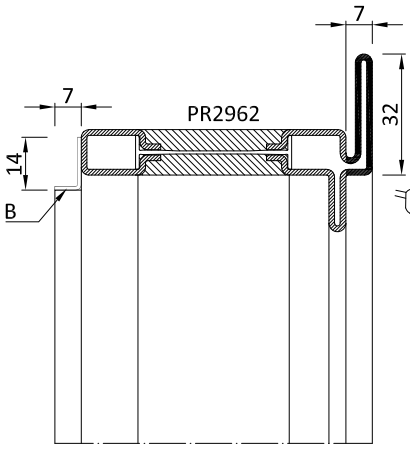
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

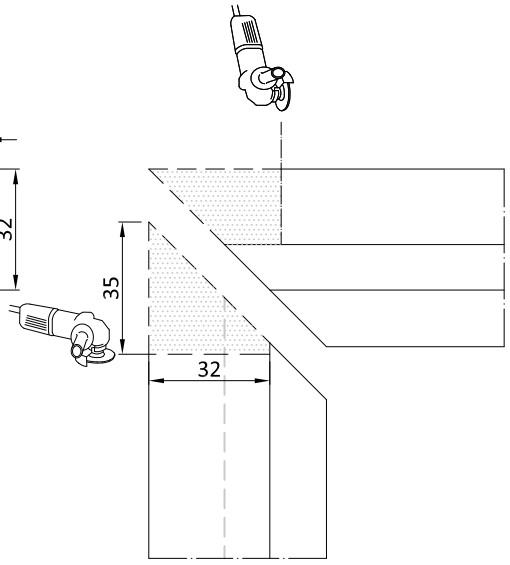


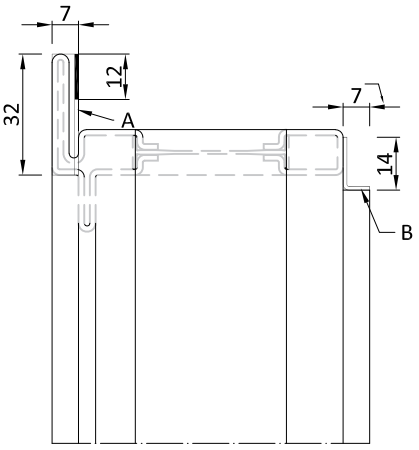




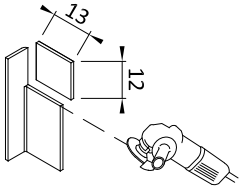


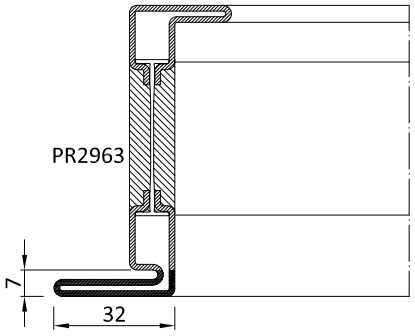


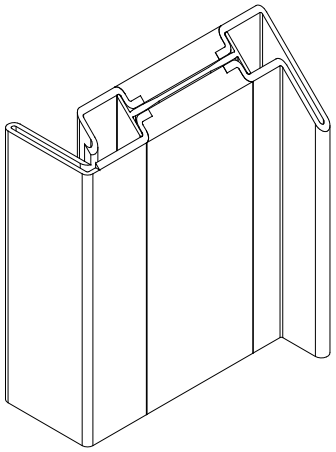


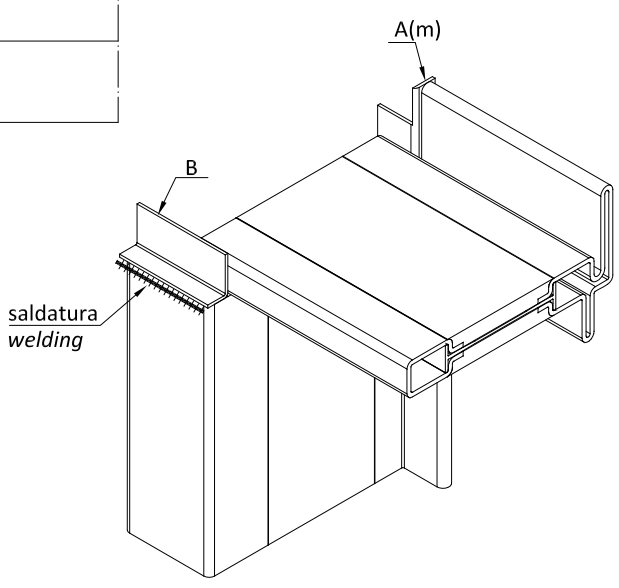


Nota: fondino di tipo A modificato A(m)
Note: the fitting tipe A edited A(m)

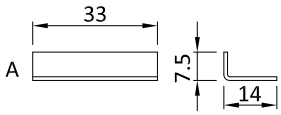


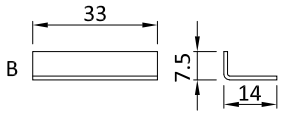


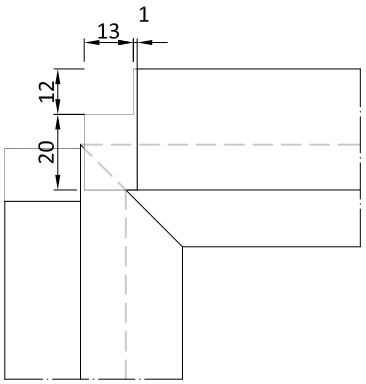


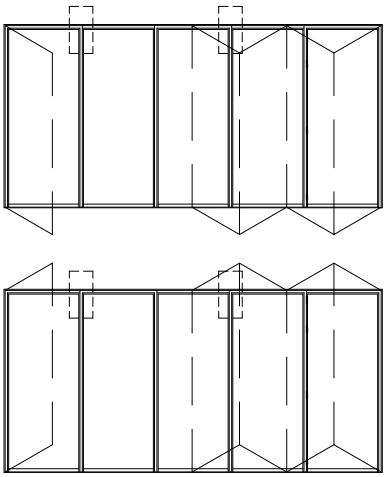


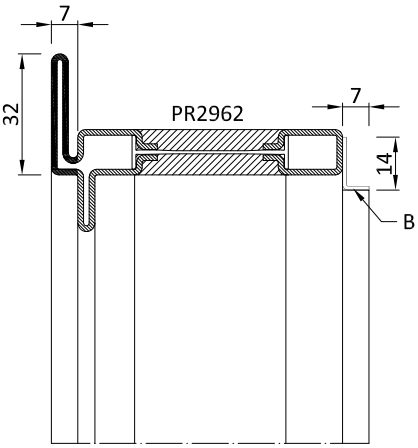
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

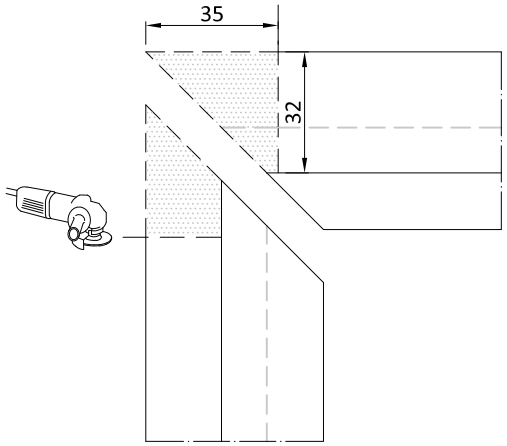


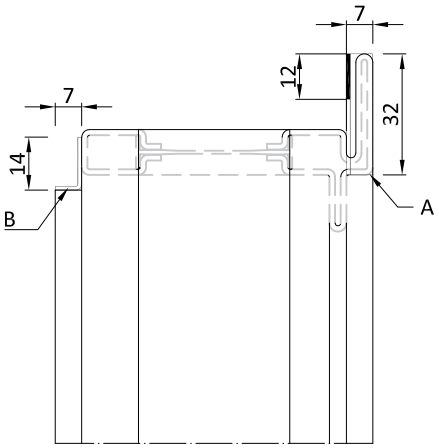




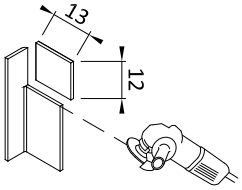


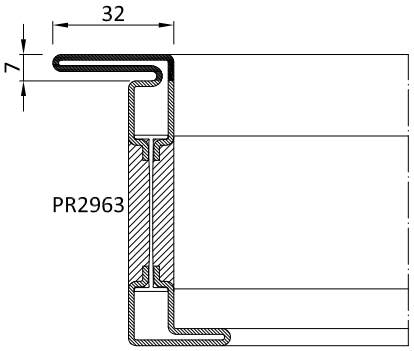


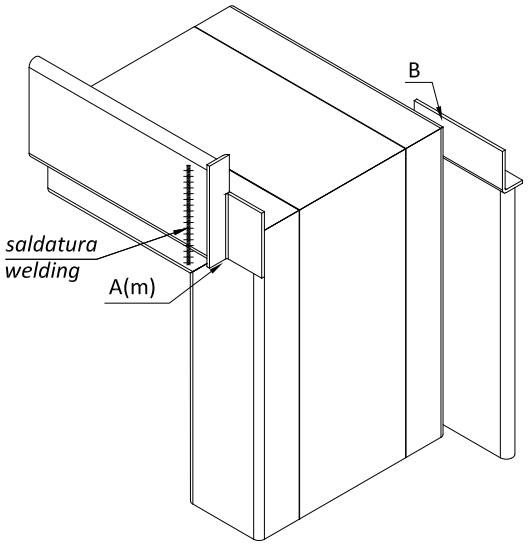


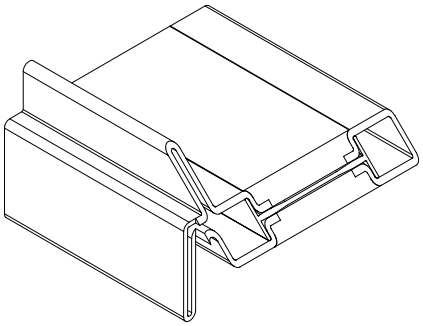


Nota: fondino di tipo A modificato A(m)
Note: the fitting tipe A edited A(m)

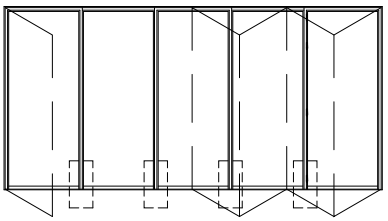


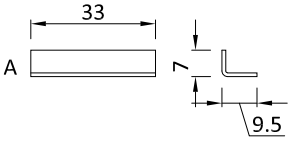


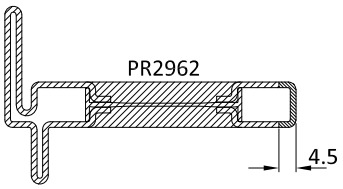


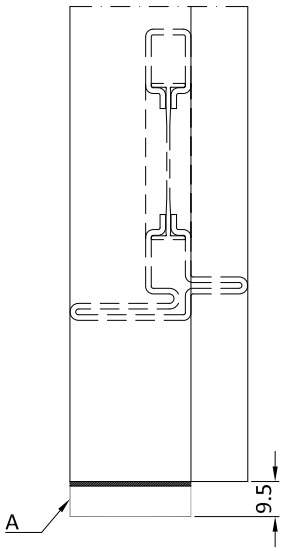


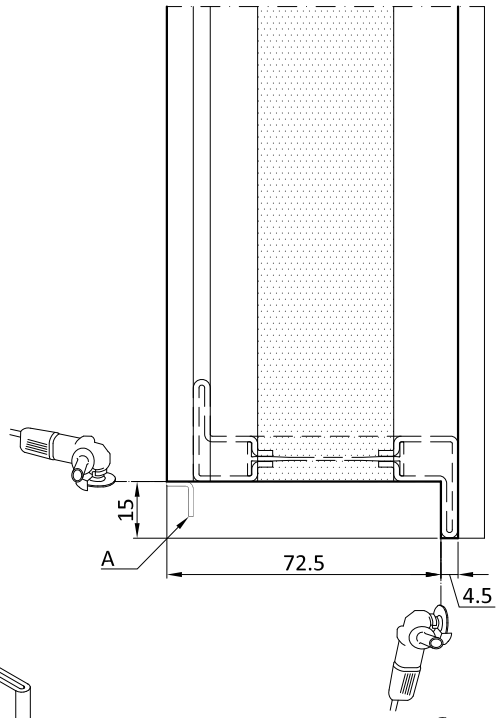
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

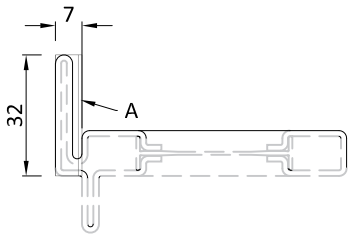


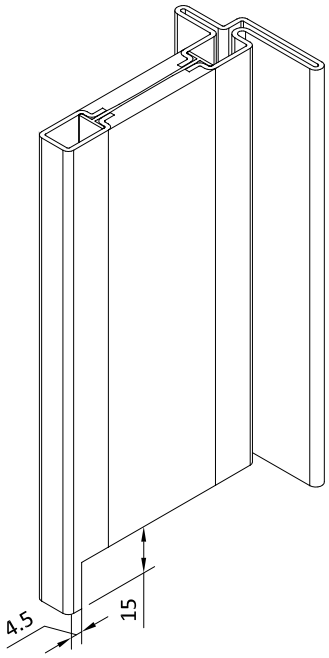


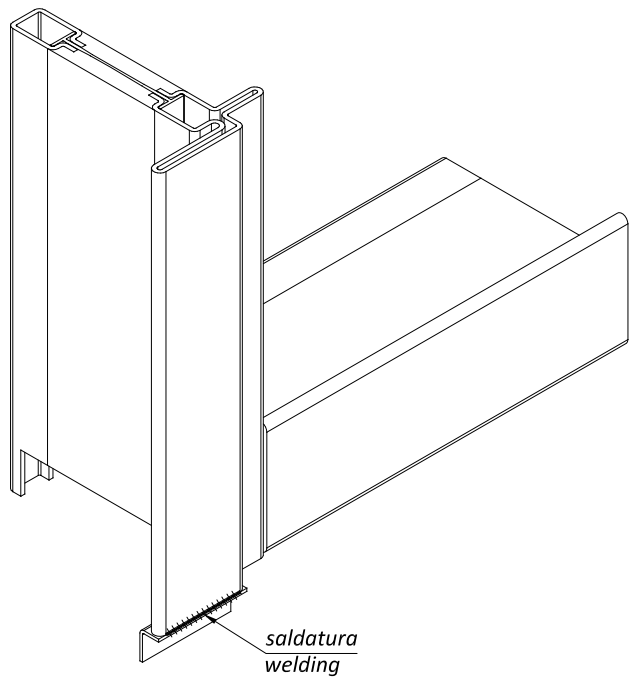




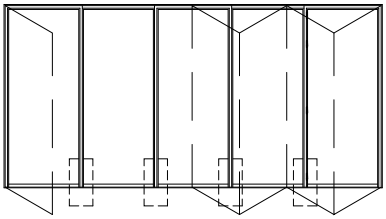


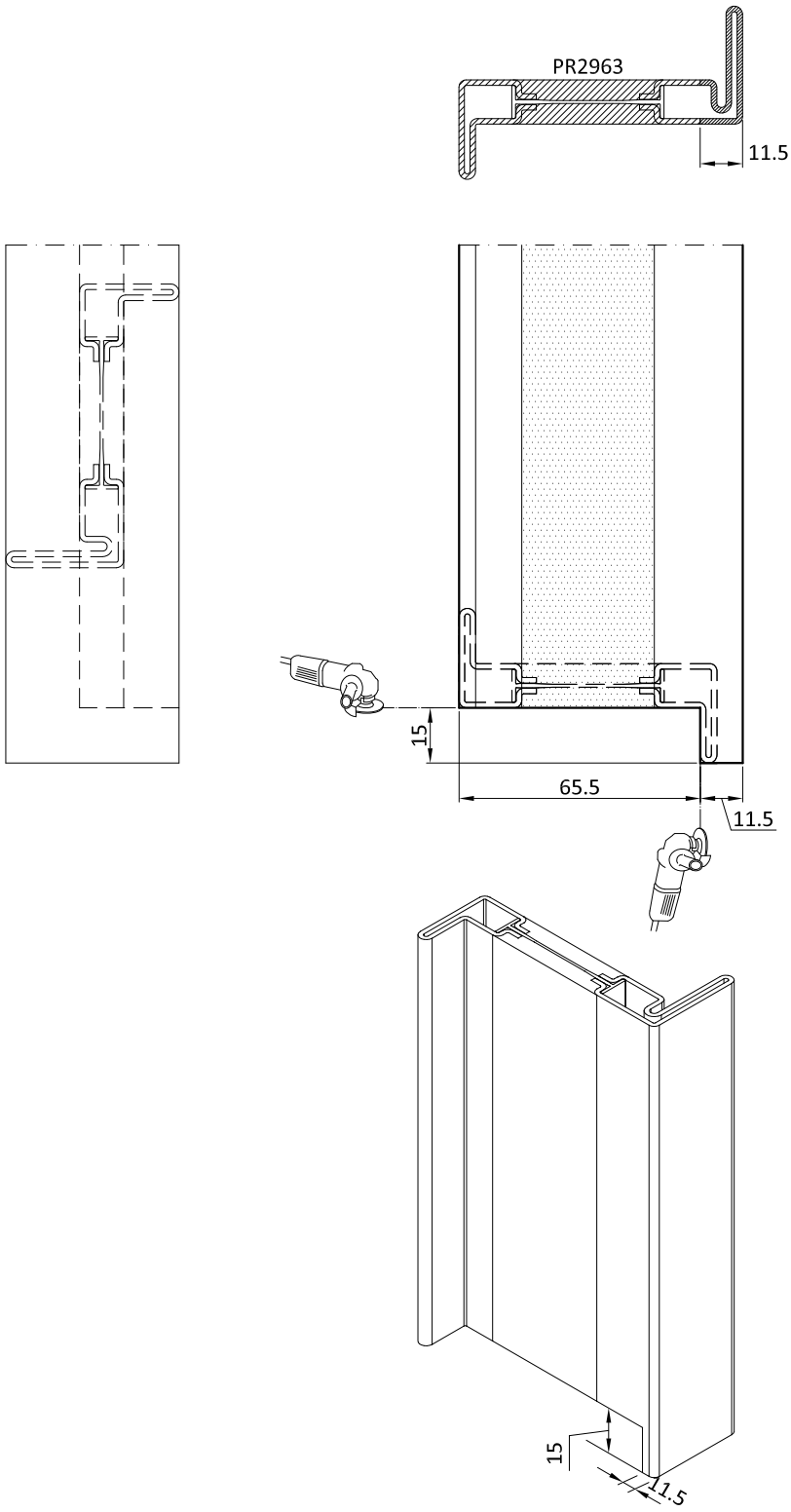




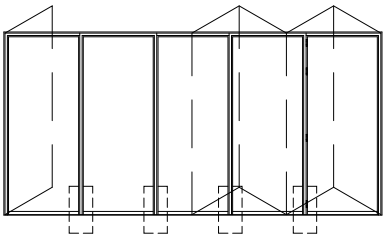


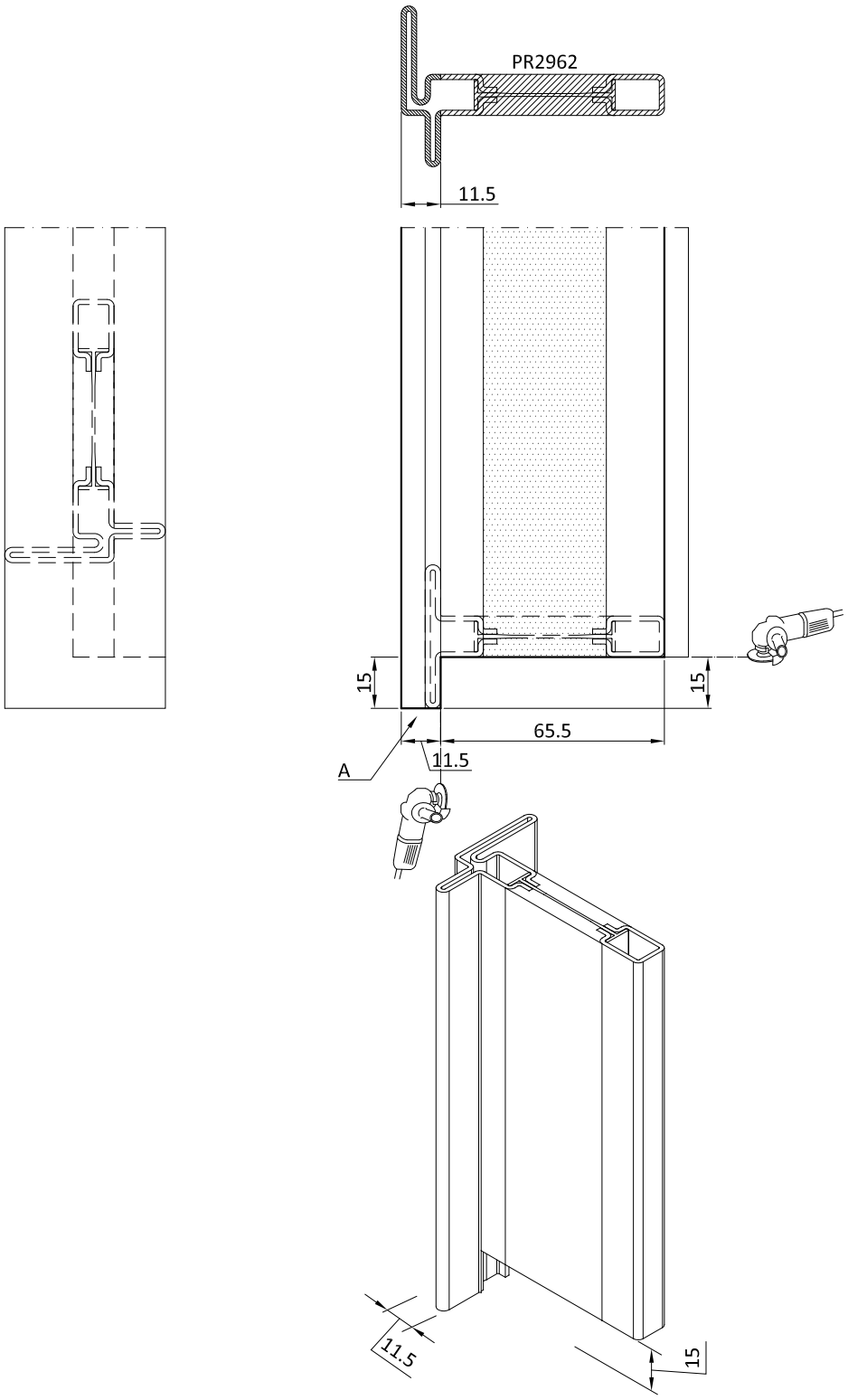
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*



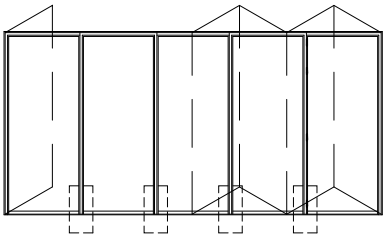


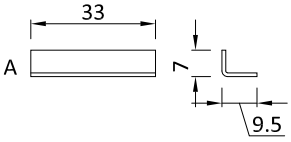
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

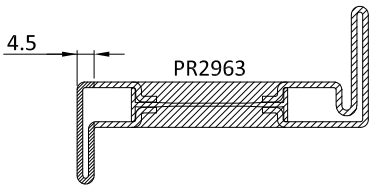


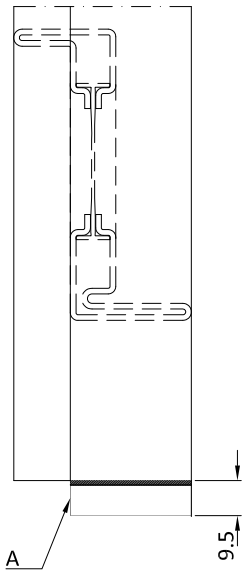


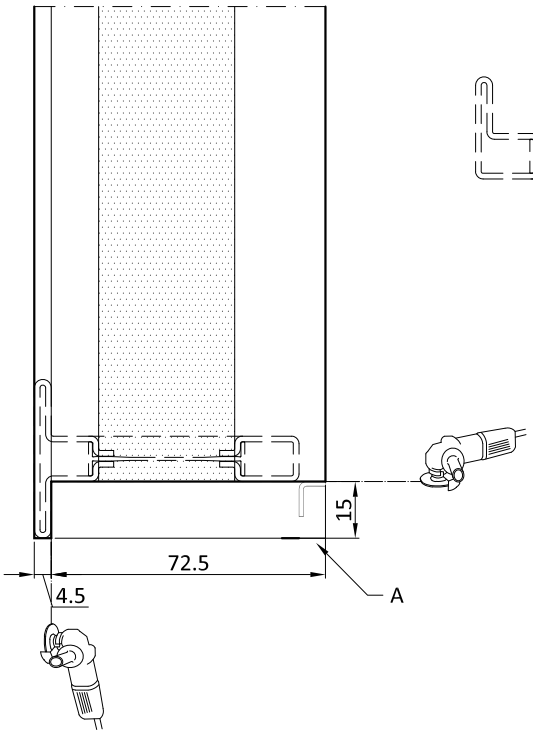
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

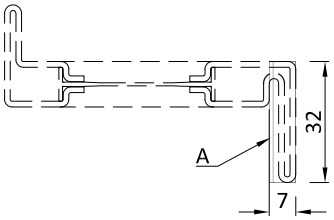


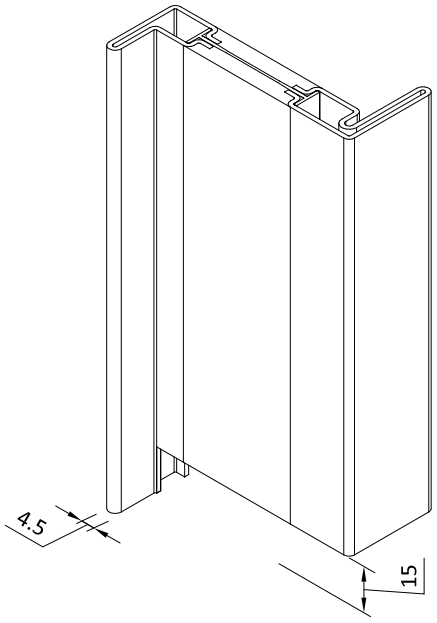


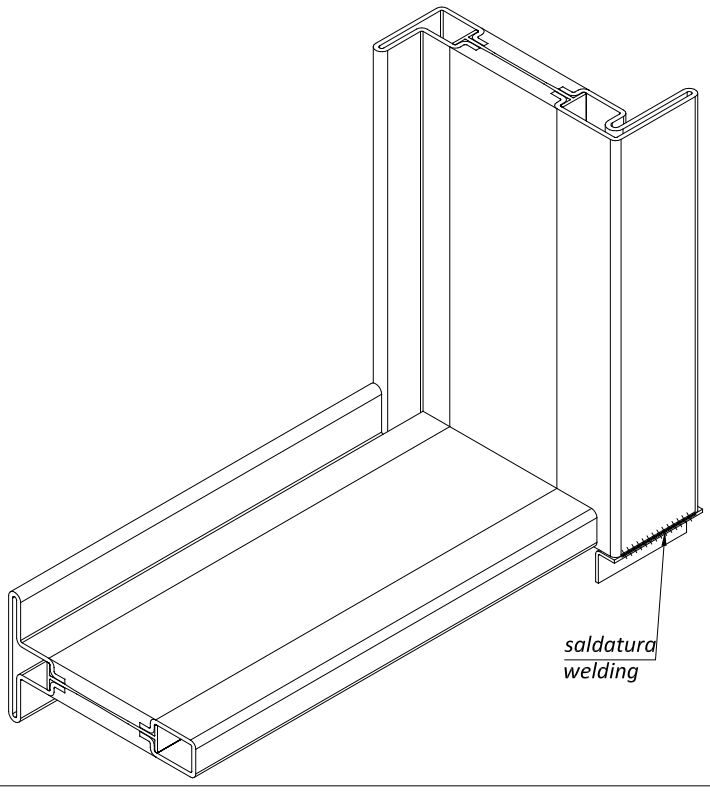




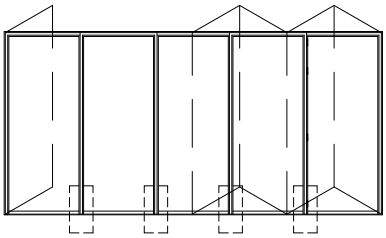


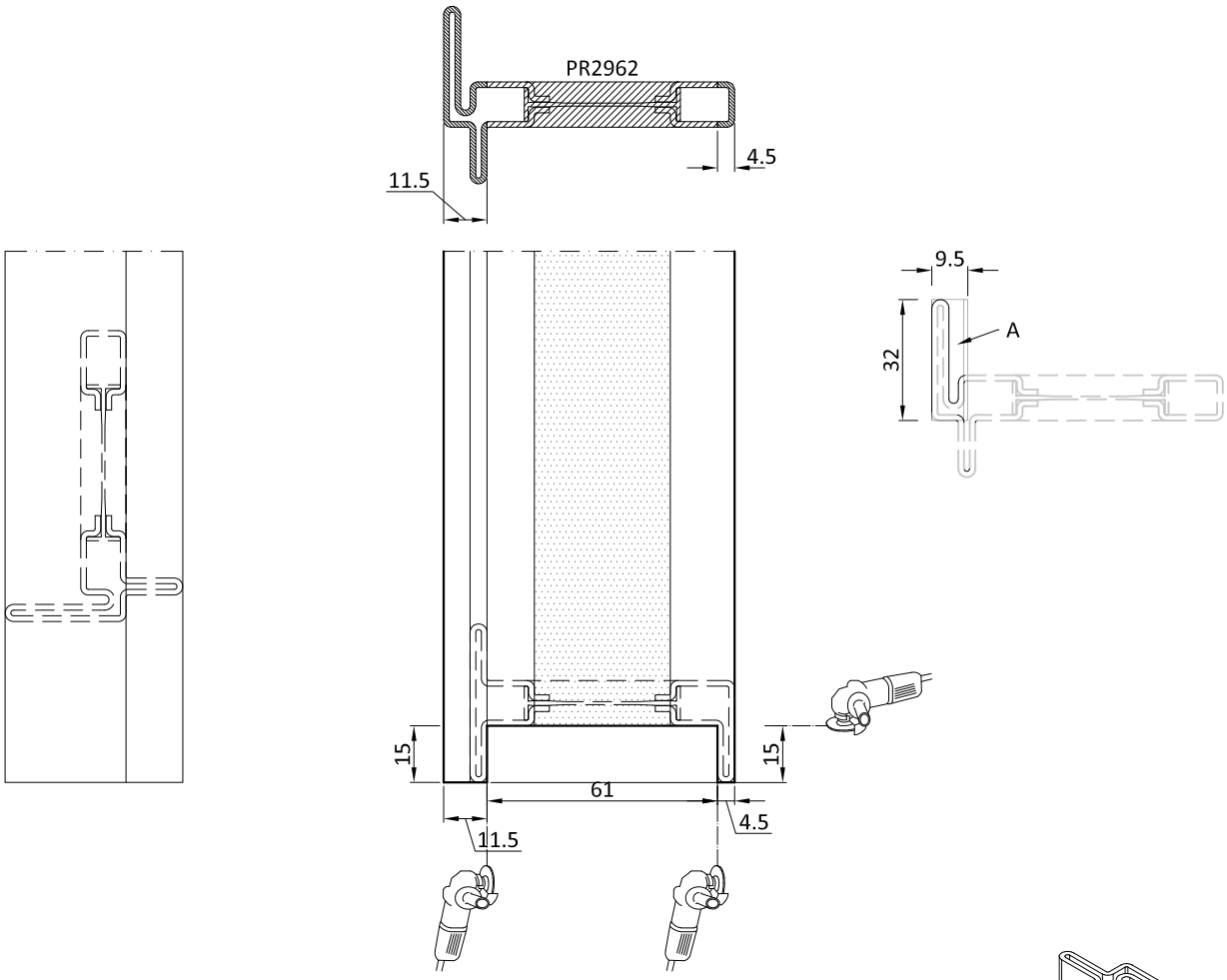


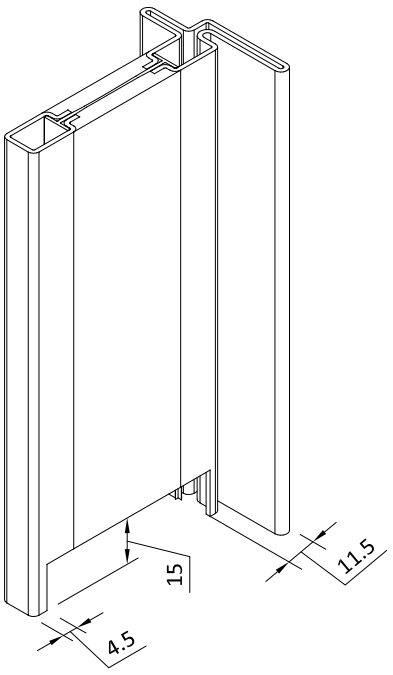




Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*



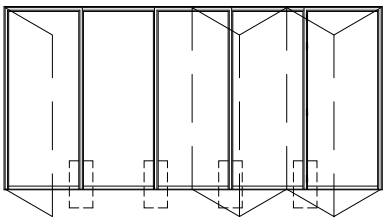


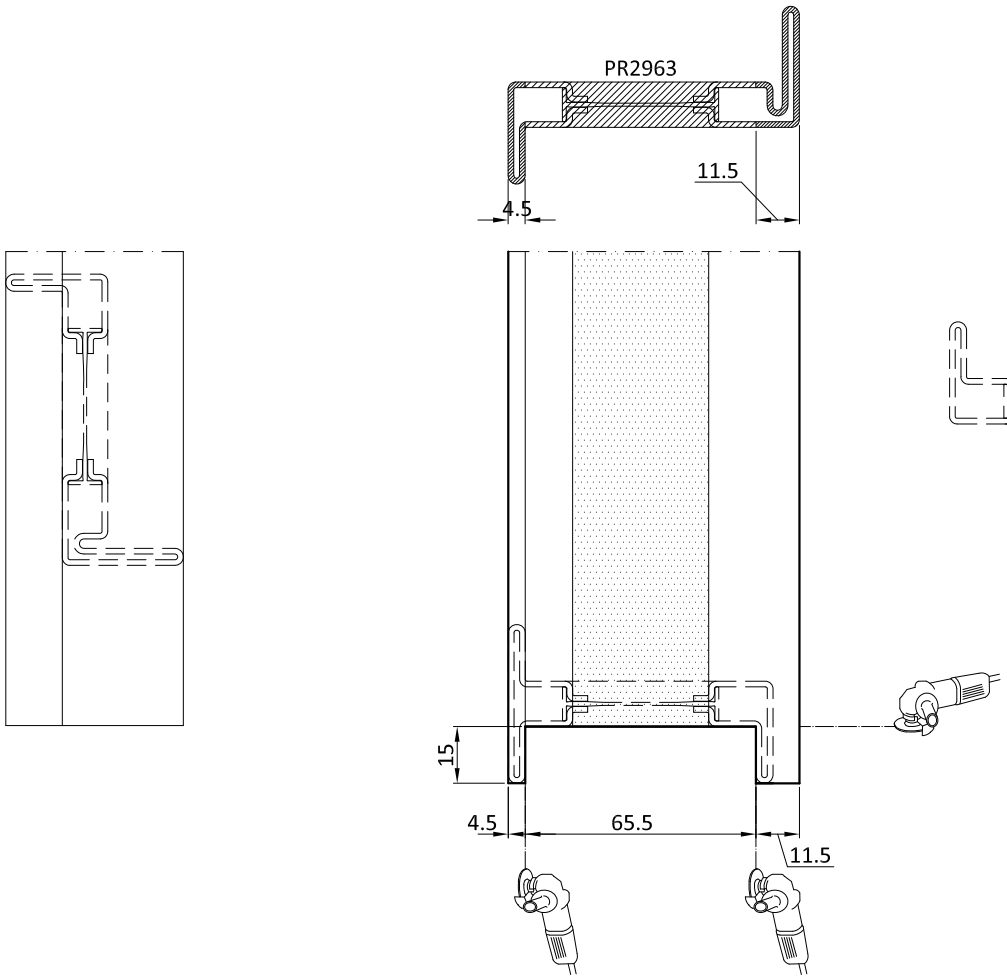


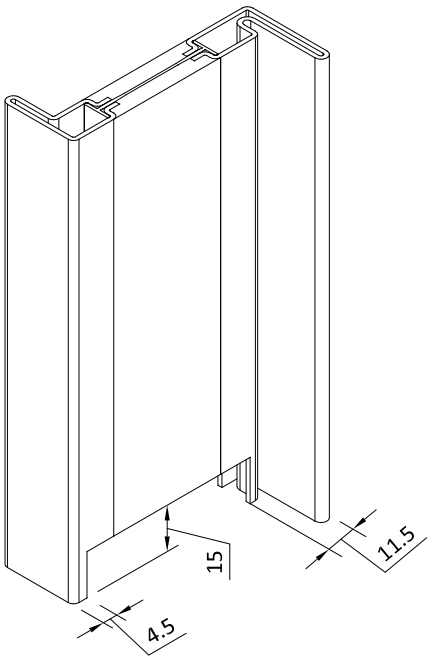
Lavorazione valida sia per le aperture interne che per le aperture esterne
Processing valid for both inword and outward openings

Il particolare "A" va saldato al PR2962 solamente nelle aperture interne
Part "A" must be welded to PR2962 only in the inward openings.

Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*



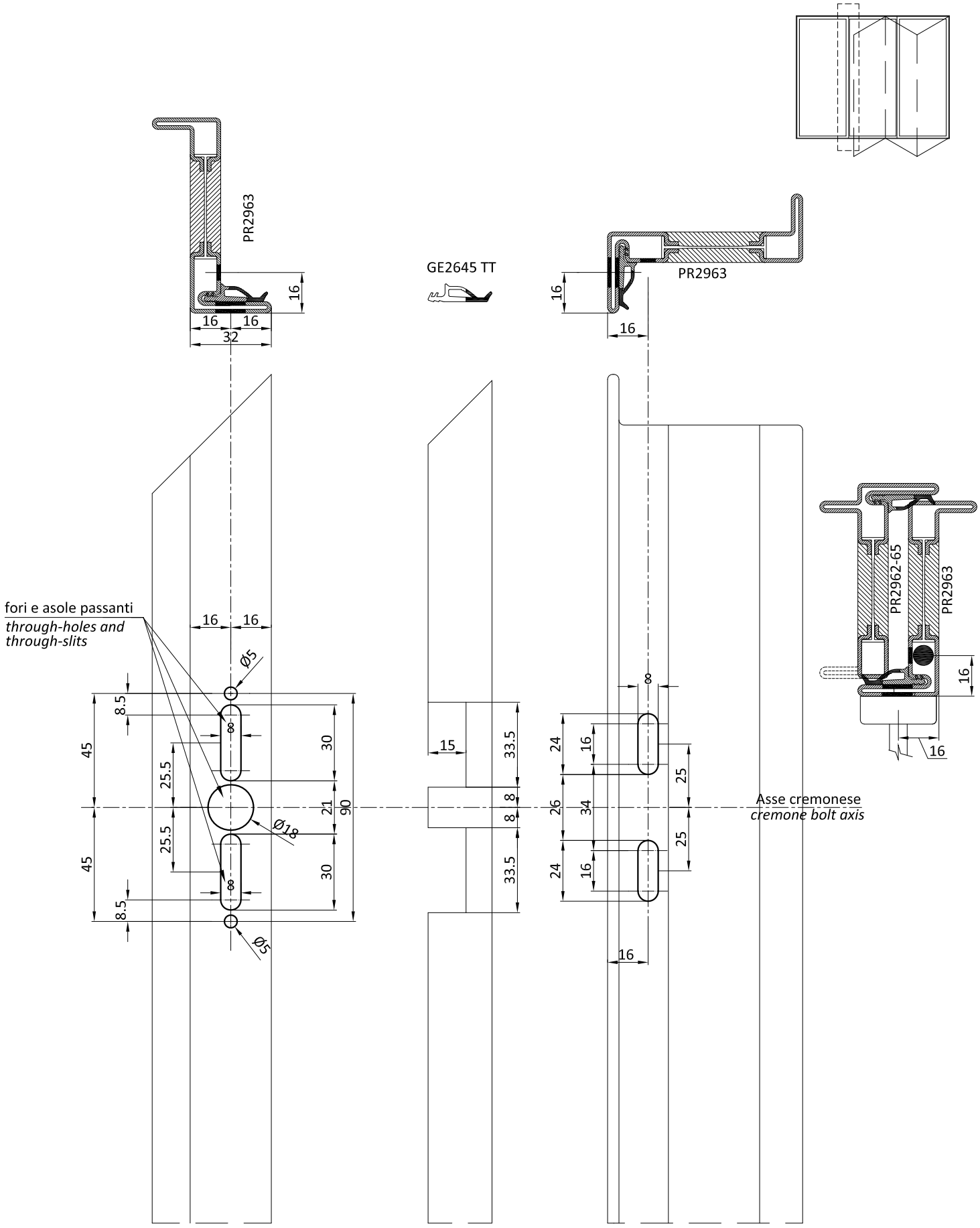


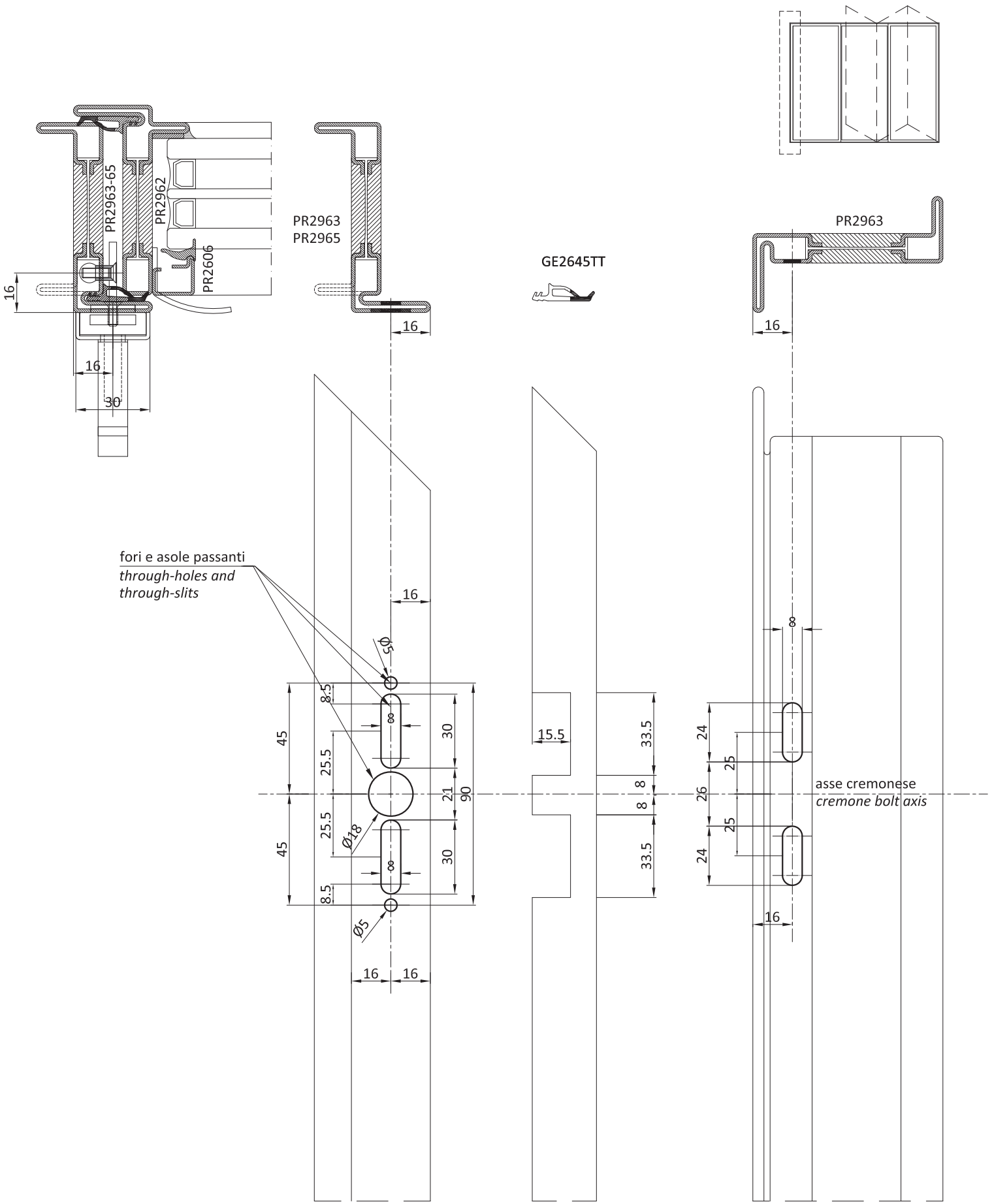


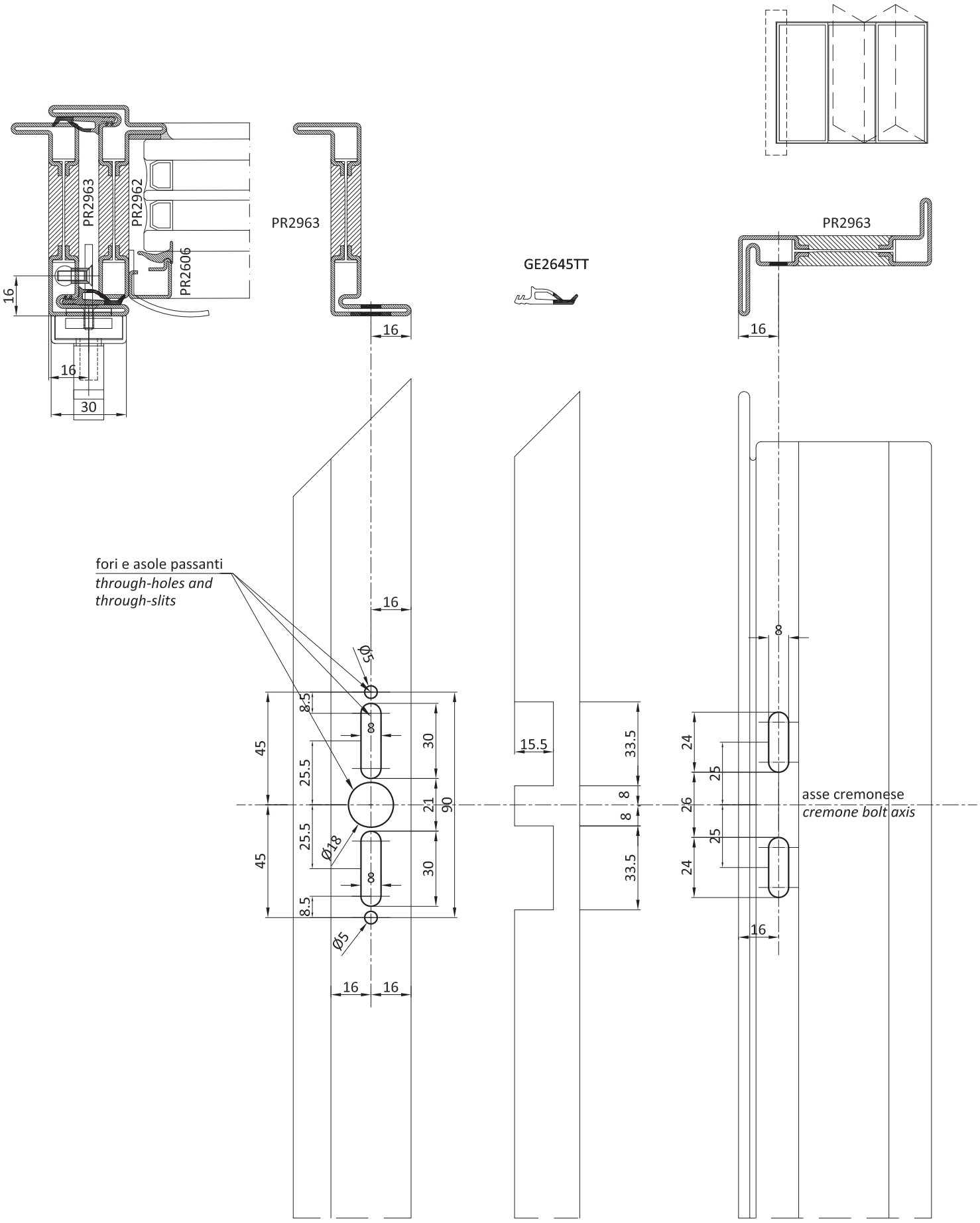
Lavorazione valida sia per le aperture interne che per le aperture esterne
Processing valid for both inword and outward openings

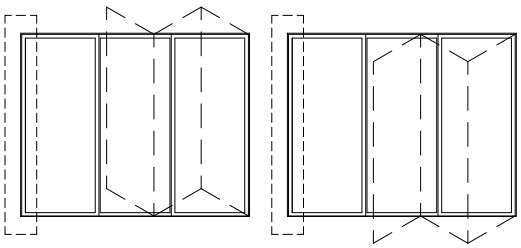
Il particolare "A" va saldato al PR2963 solamente nelle aperture interne
Part "A" must be welded to PR2963 only in the inward openings.

Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

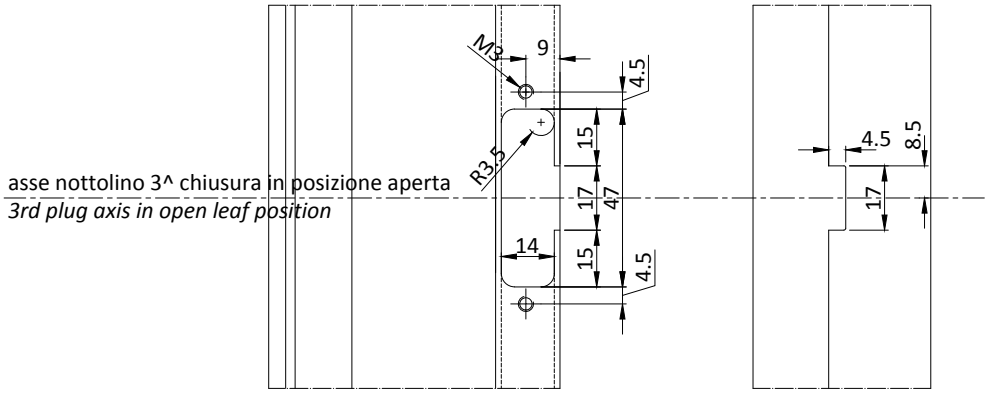

PR2963
16
16
16
32
GE2645 TT
PR2963
16
16
PR2962-65
PR2963
16
16
fori e asole passanti
through-holes and through-slits
16
16
Ø5
8.5
45
25.5
25.5
45
8.5
30
21
90
30
Ø18
Ø5
15
33.5
8
8
33.5
8
24
16
26
34
24
16
25
25
16
Asse cremonese
cremone bolt axis


PR2963-65
PR2962
PR2606
16
16
30
PR2963
PR2965
16
GE2645TT
PR2963
16
fori e asole passanti
through-holes and
through-slits
16
5Φ
8.5
45
25.5
30
21
90
25.5
Ø18
30
45
8.5
Ø5
16
16
15.5
33.5
8
8
33.5
8
24
25
26
25
24
asse cremonese
cremone bolt axis
16

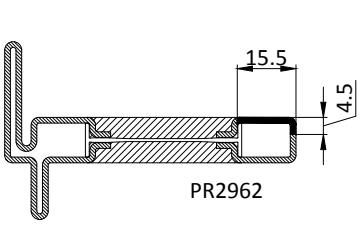

PR2963
PR2962
PR2606
16
16
30
PR2963
16
GE2645TT
PR2963
16
fori e asole passanti
through-holes and through-slits
16
5Φ
8.5
8
30
45
25.5
21
90
25.5
Ø18
45
30
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asse cremonese
cremone bolt axis
16

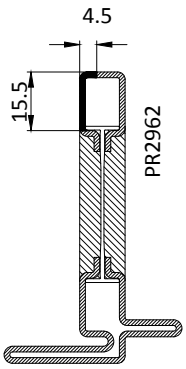


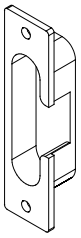
lavorazione applicazione incontro
Processing for the installation of the strike plate



AC2626R Incontro 3^ chiusura
3rd lock strike plate



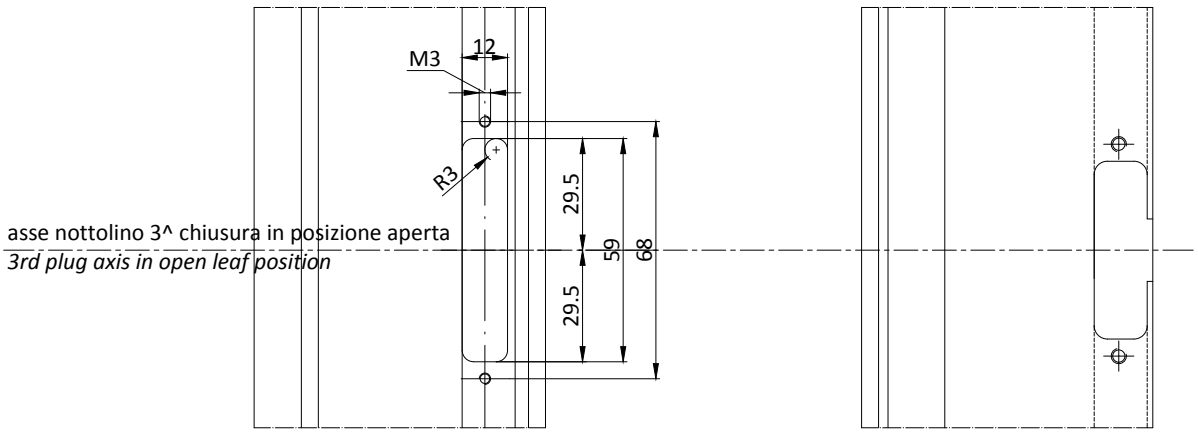


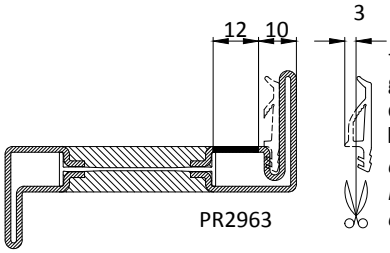


N.B.: Distanza massima tra i punti di chiusura 1000 mm

N.B.: Distance between the closing points max. 1000 mm

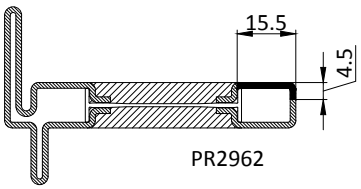
lavorazione applicazione nottolino
processing for plug installation

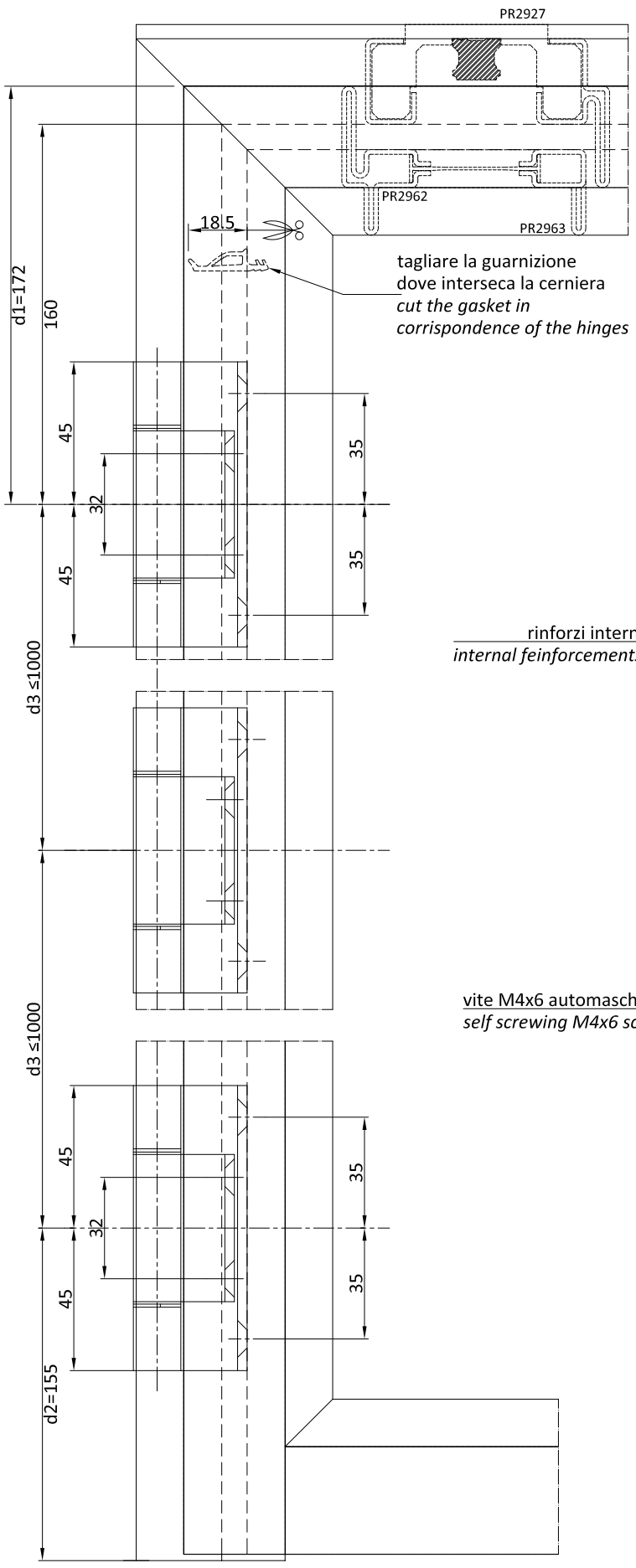


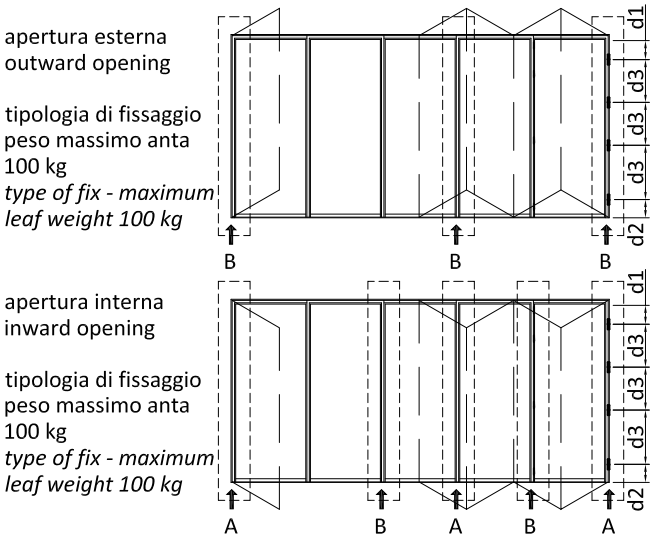


3

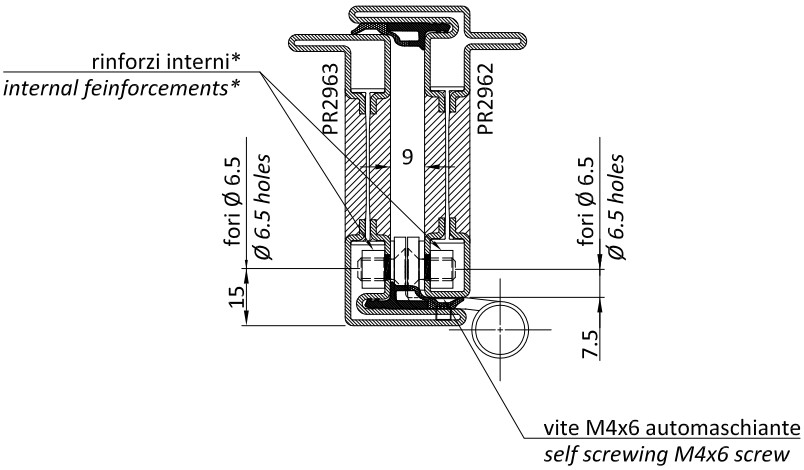
tagliare la guarnizione dove interseca la chiusura
cut the gasket in corrispondence of closure

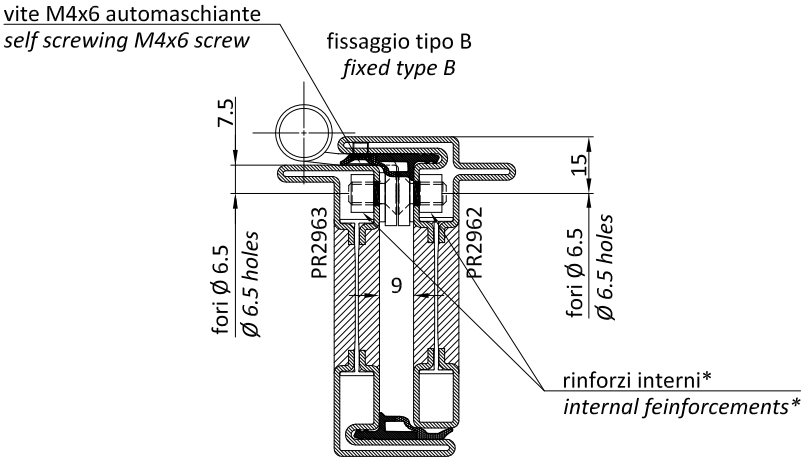






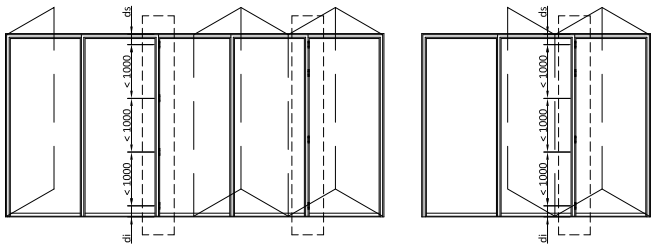
fissaggio tipo A
fixed type A

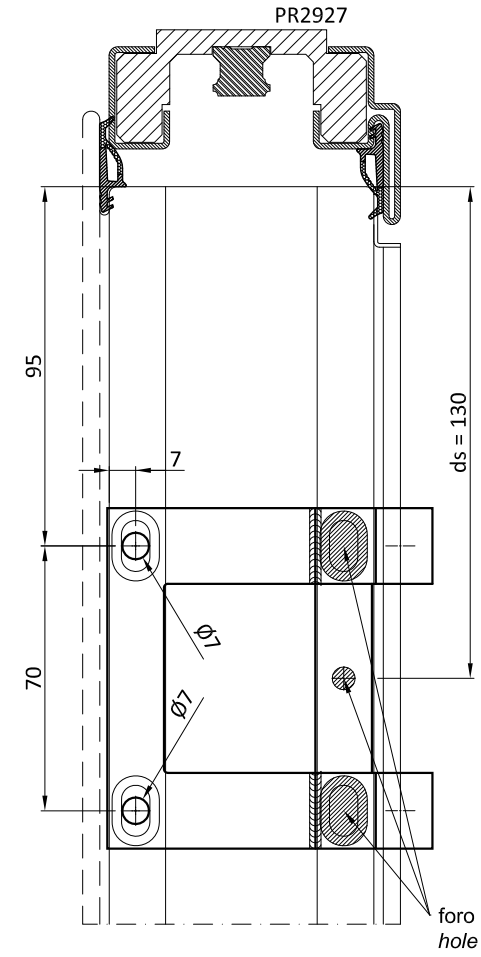


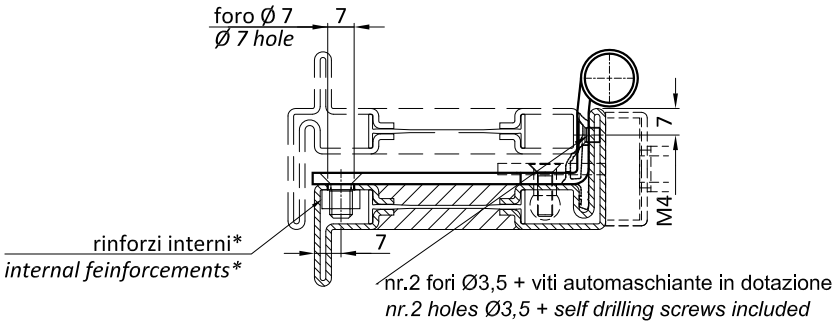


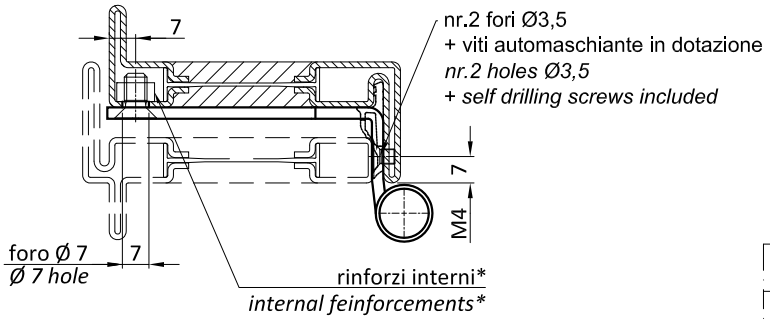
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

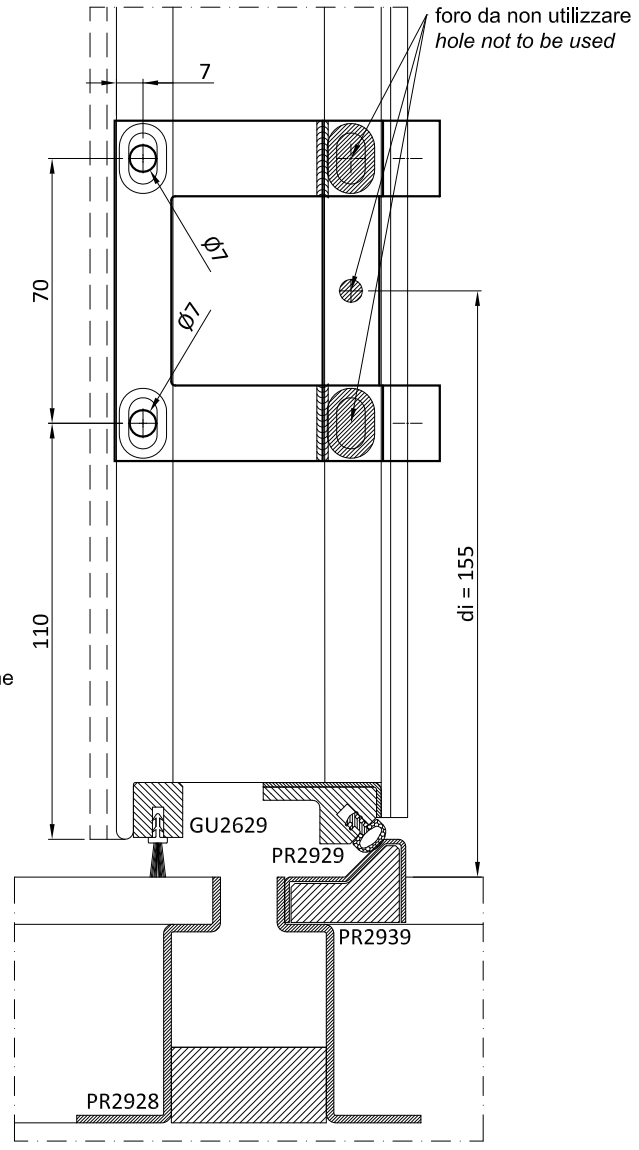
apertura ESTERNA
OUTWARD opening





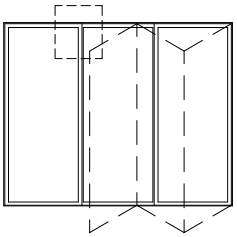




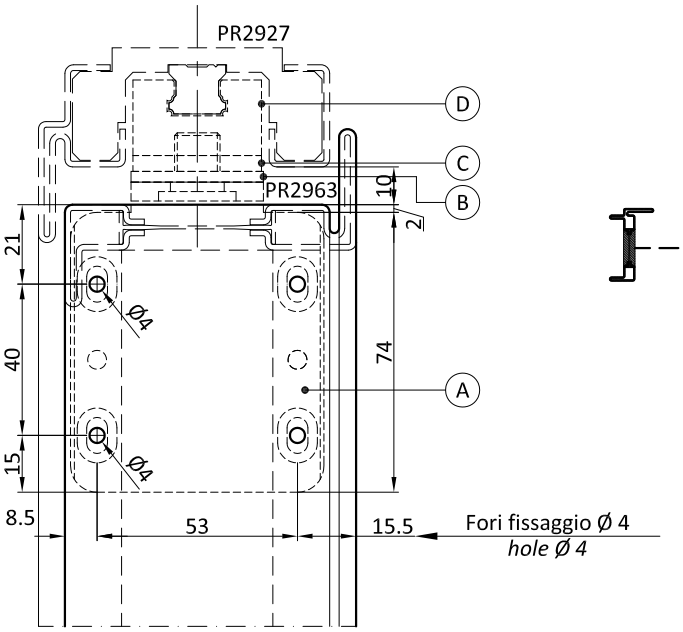


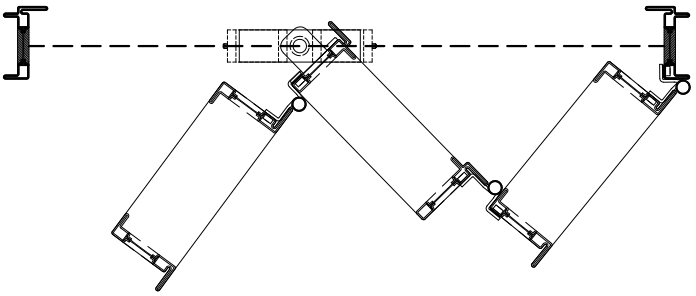
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

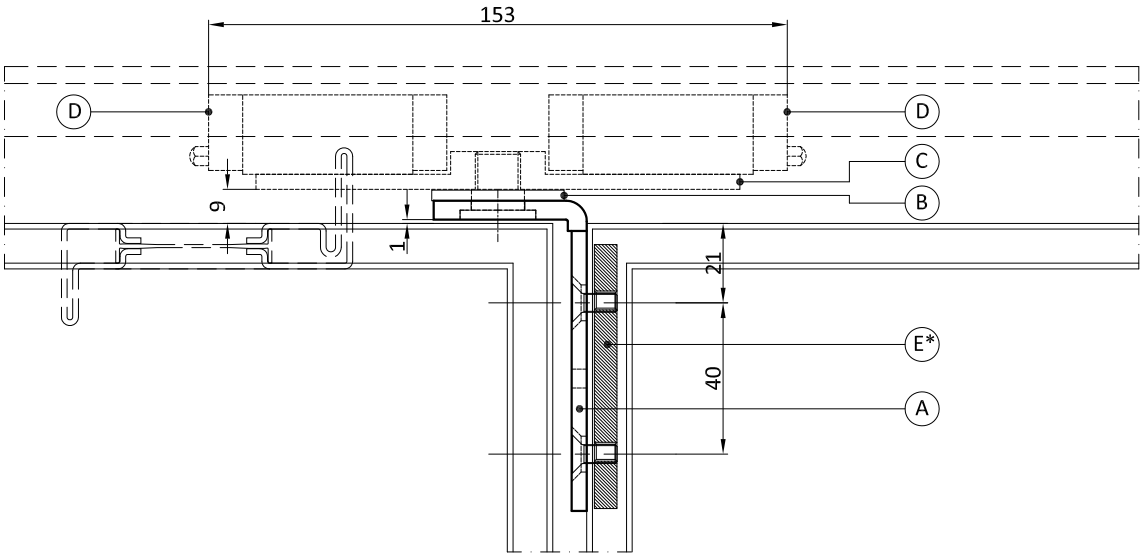
apertura INTERNA
INWARD opening

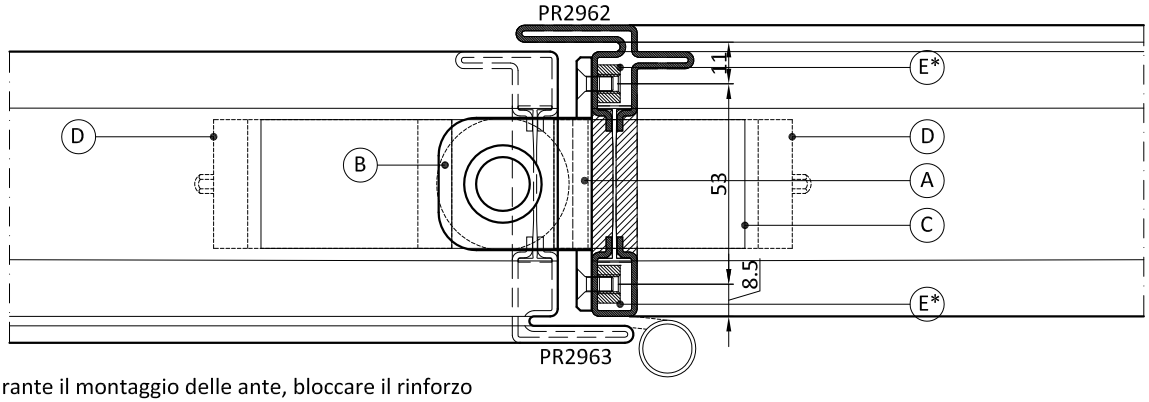


A - Staffa angolare | *Corner bracket*
B - Rondella ottone | *Brass washer*
C - Piastra collegamento carelli | *Connection plate for roller*
D - Carrelli | *Rollers*
E - Rinforzo* | *Reinforcement**

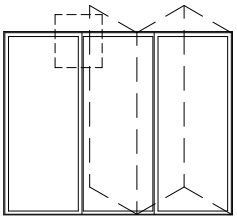






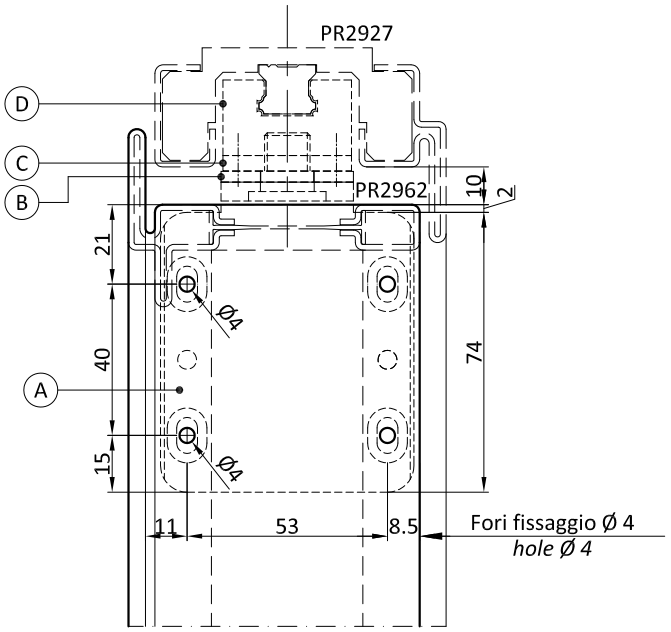


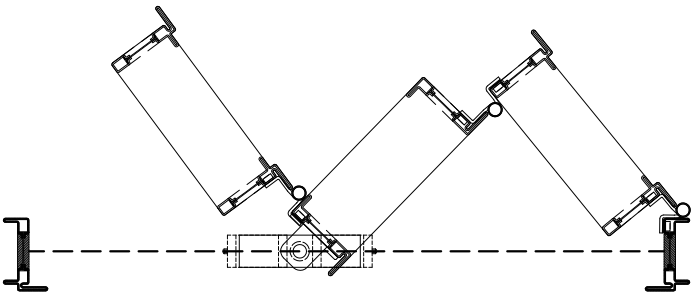
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

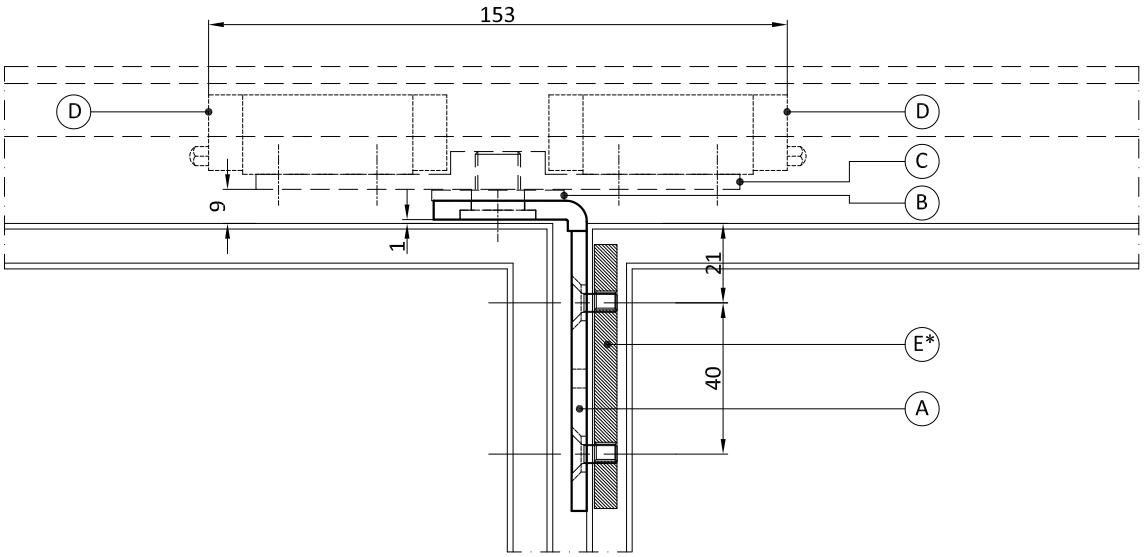


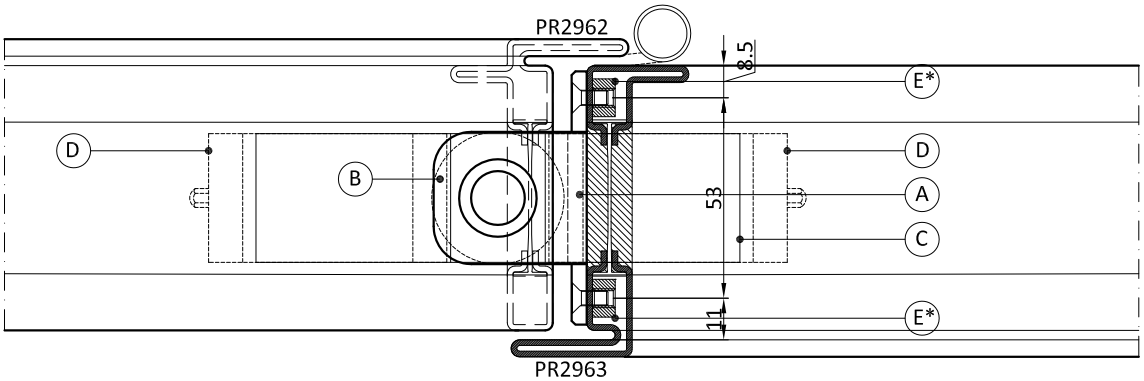
apertura ESTERNA
OUTWARD opening

A - Staffa angolare | *Corner bracket*
B - Rondella ottone | *Brass washer*
C - Piastra collegamento carelli | *Connection plate for roller*
D - Carrelli | *Rollers*
E - Rinforzo* | *Reinforcement**



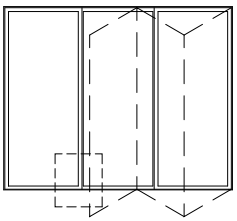




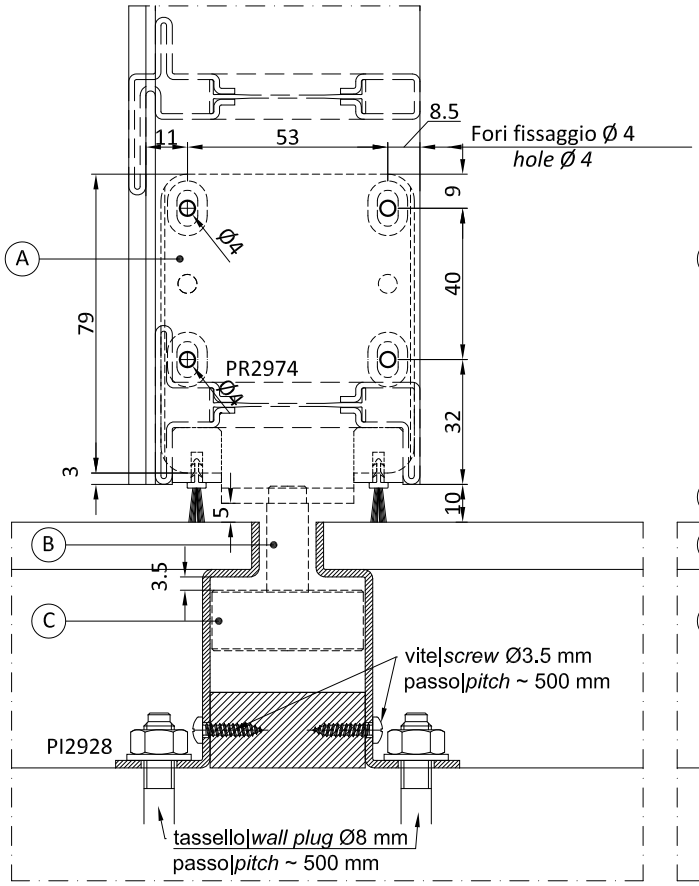


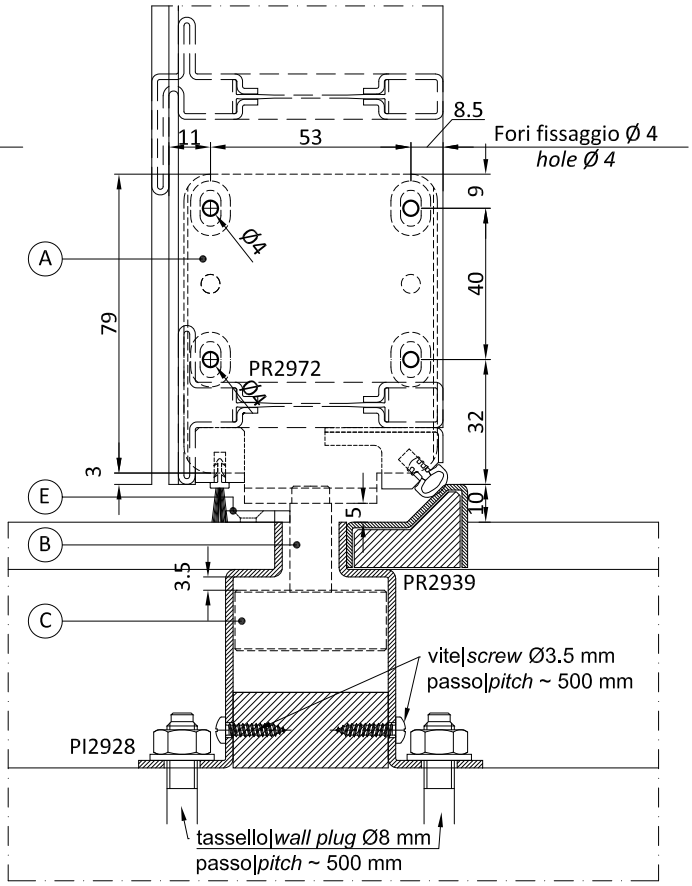
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

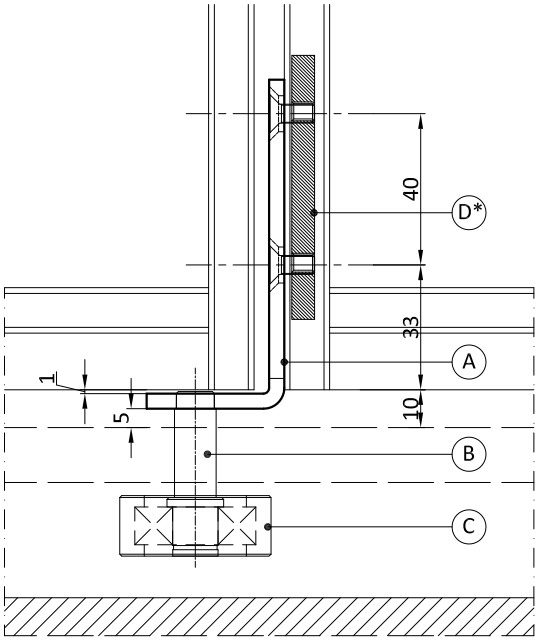
apertura INTERNA
INWARD opening

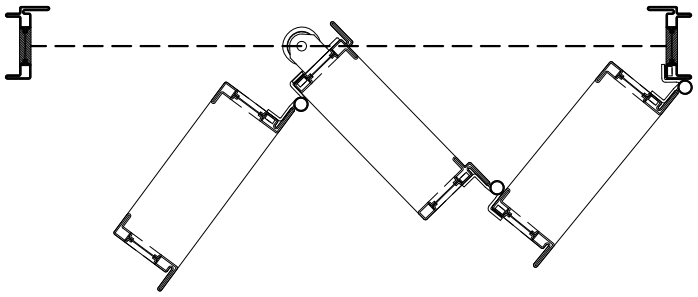


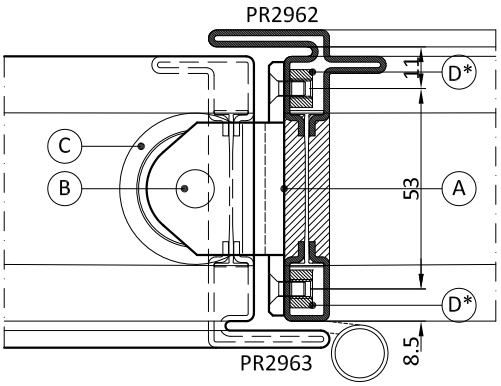
A - Staffa angolare | *Corner bracket*
B - Perno | *Pivot*
C - Cuscinetto a sfera | *Ball bearing*
D - Rinforzo* | *Reinforcement**
E - Incontro carrello inferiore | *Strike plate bottom roller*







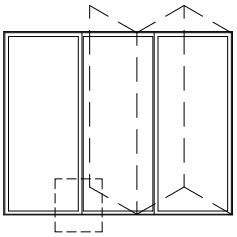




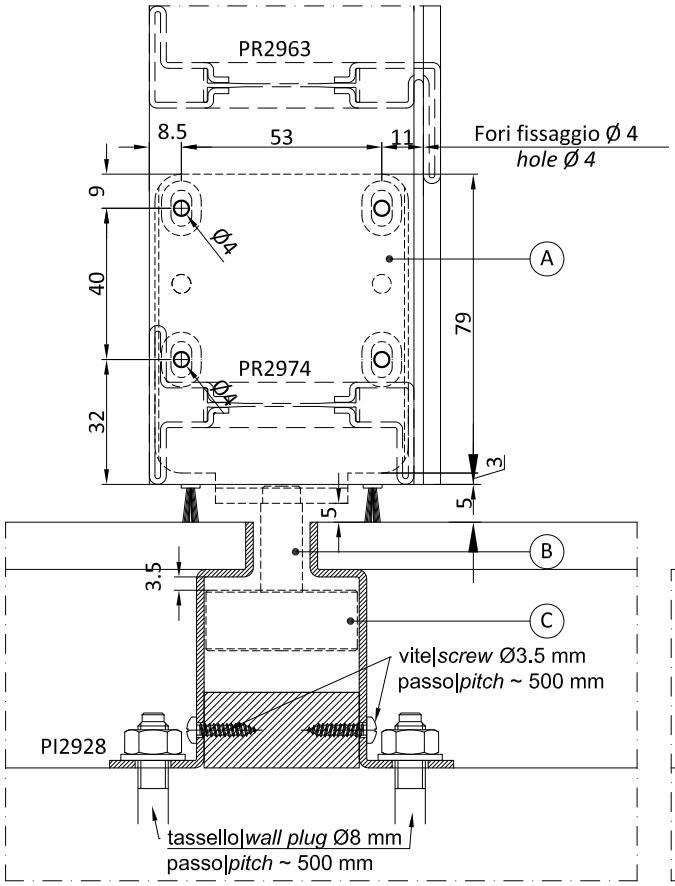
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

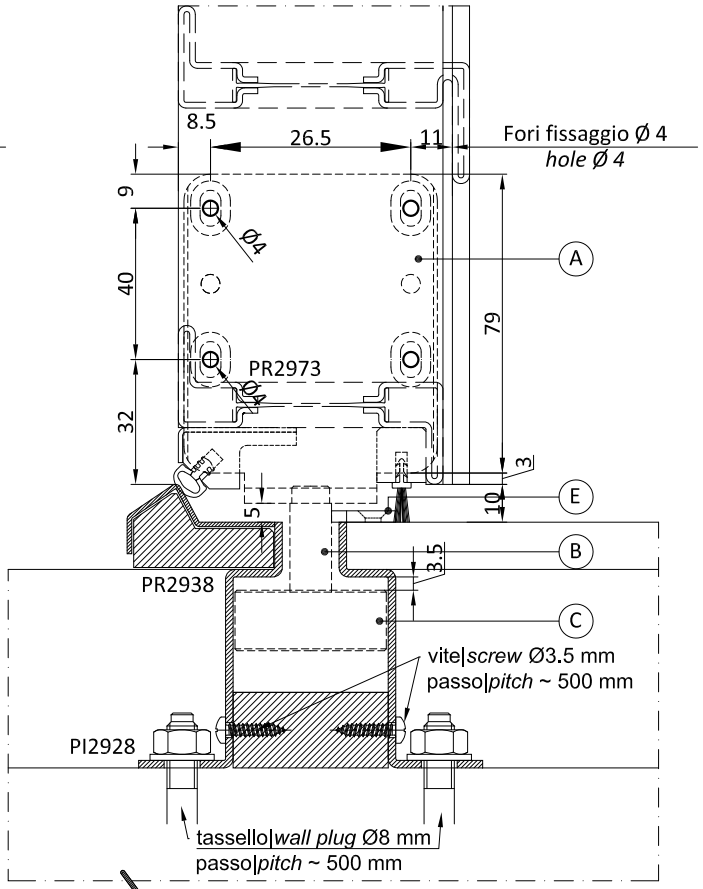
viti e tasselli non inclusi | *screws and wall plugs not supplied*

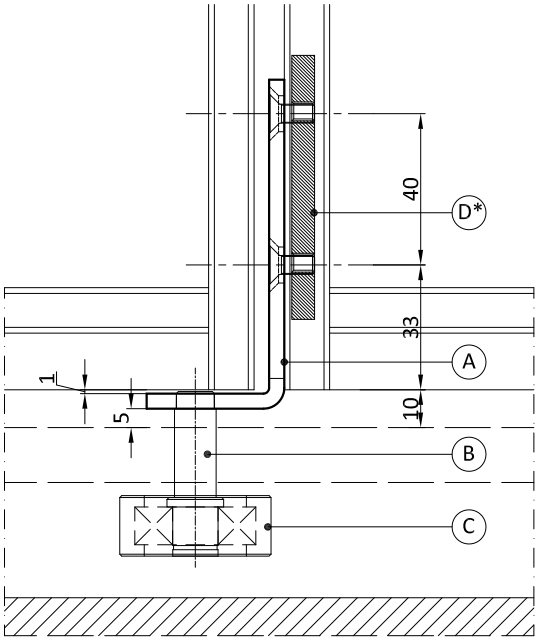
apertura ESTERNA
OUTWARD opening

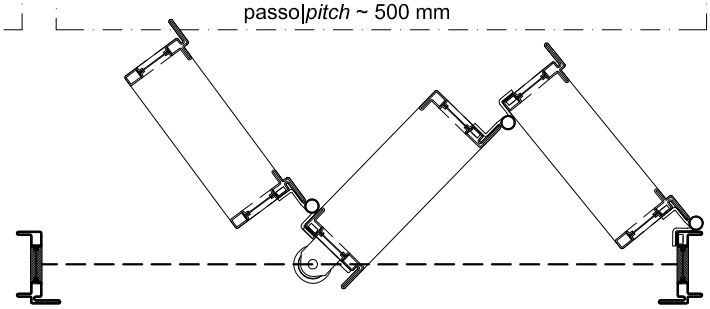


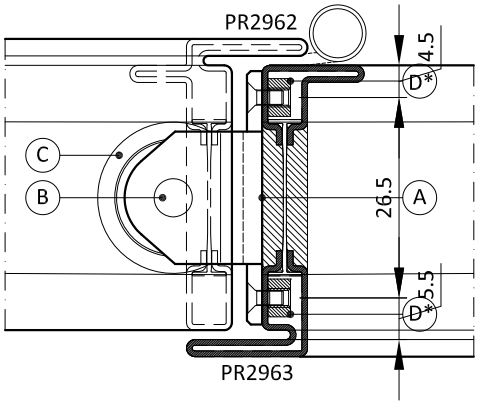
A - Staffa angolare | *Corner bracket*
B - Perno | *Pivot*
C - Cuscinetto a sfera | *Ball bearing*
D - Rinforzo* | *Reinforcement**
E - Incontro carrello inferiore | *Strike plate bottom roller*







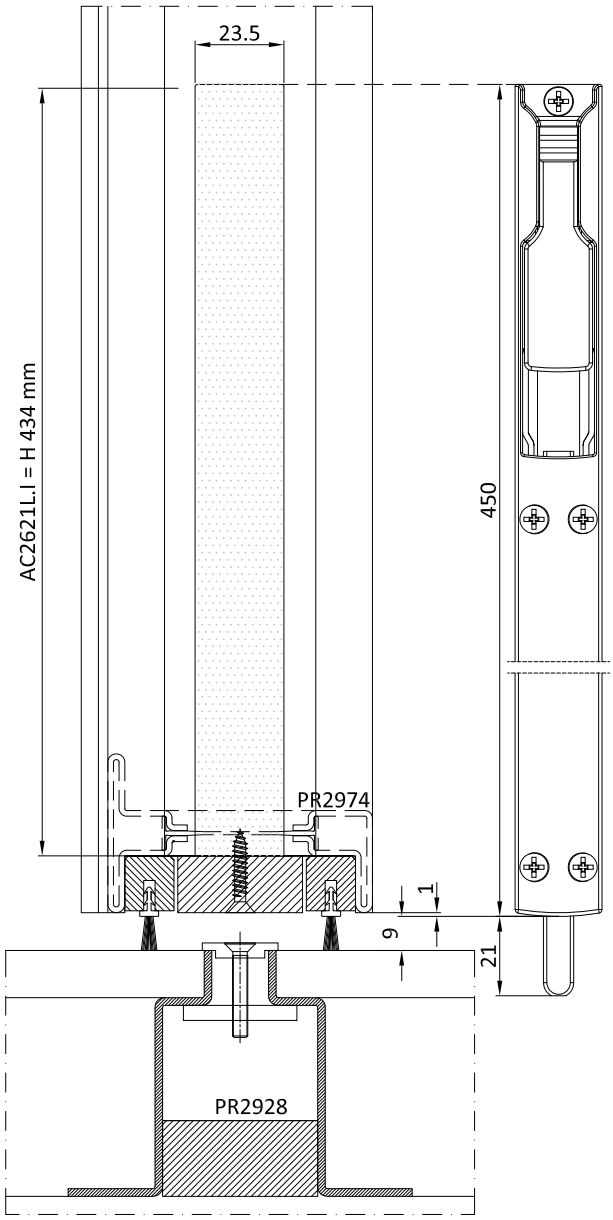


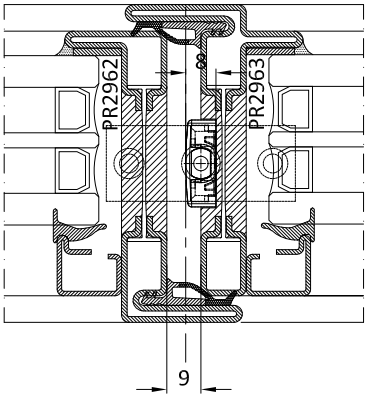


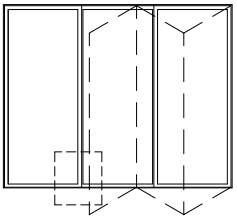
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

viti e tasselli non inclusi | *screws and wall plugs not supplied*

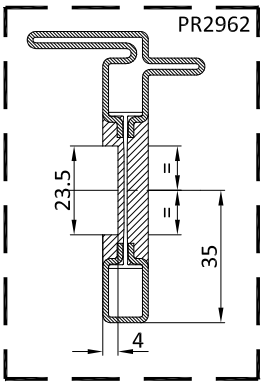
apertura INTERNA
INWARD opening

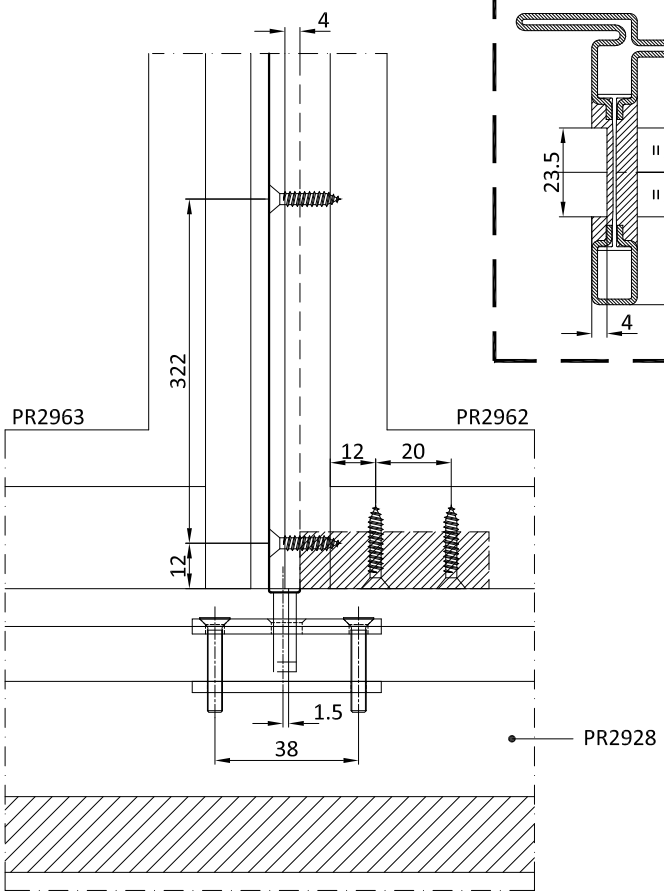


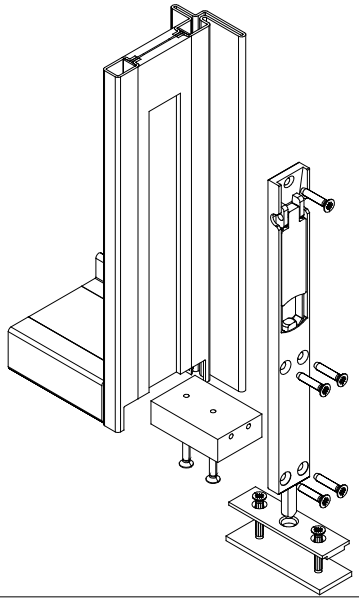




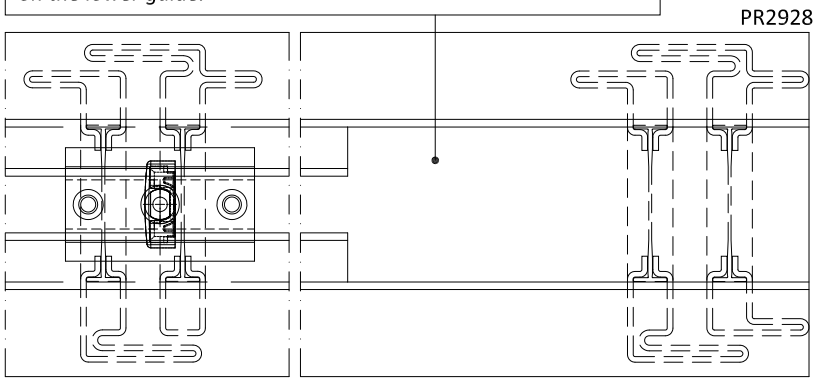
Applicazione valida anche con profilo zoccolo PR2973
Application valid with PR2973 bottom profile



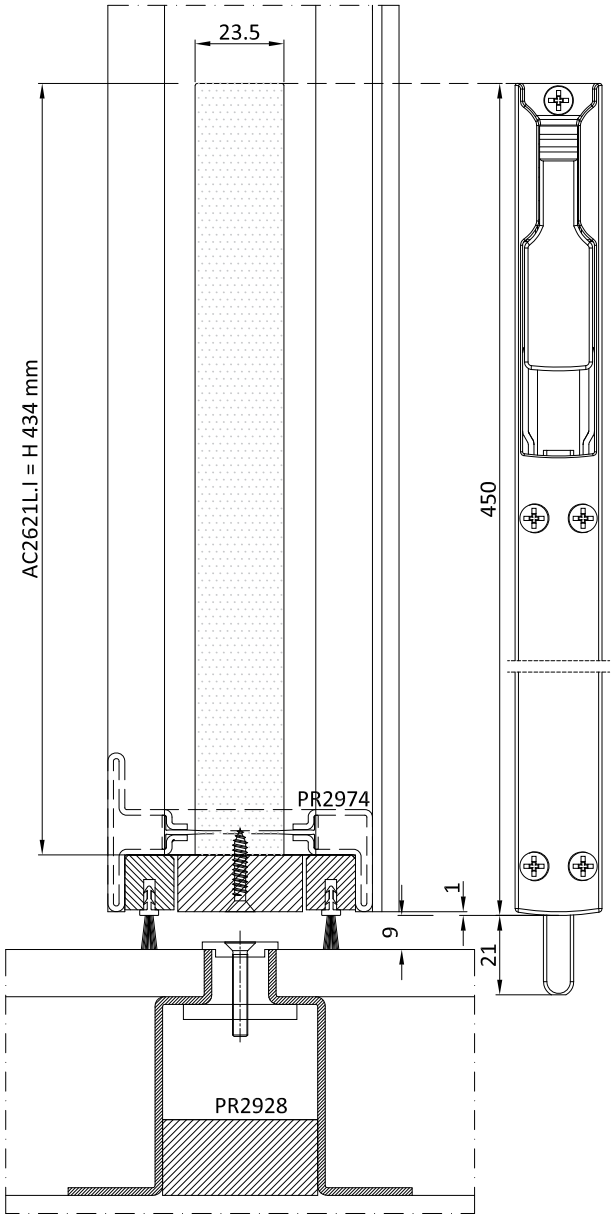


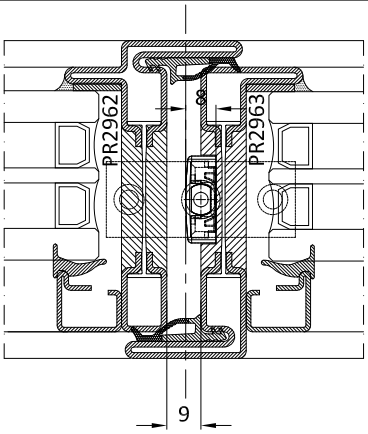


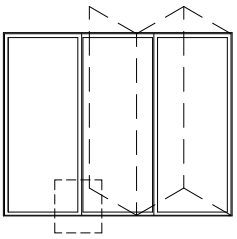
Pre-assemblare l'incontro, inserirlo dallo scasso guida necessario ai carrelli inferiori, farlo scorrere nella corretta posizione prima di inserire ante e carrelli.
Pre-assemble the strike plate before fitting the sashes and rollers, insert and slide it into position from the slot for the bottom rollers on the lower guide.



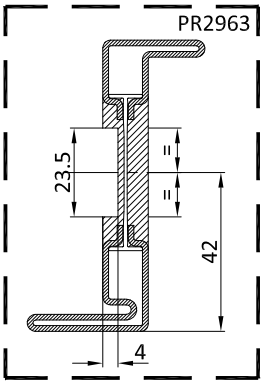
apertura ESTERNA
OUTWARD opening

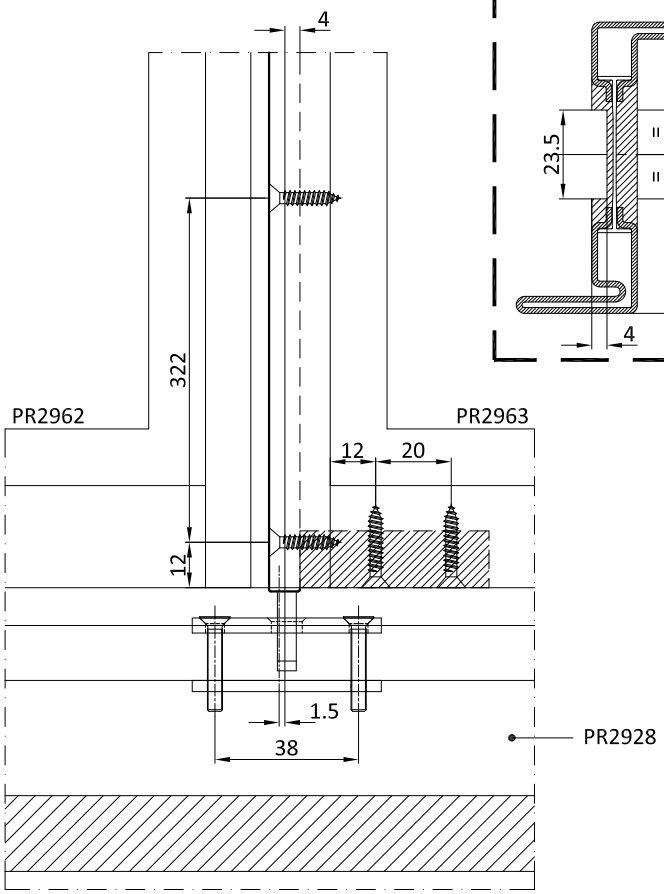


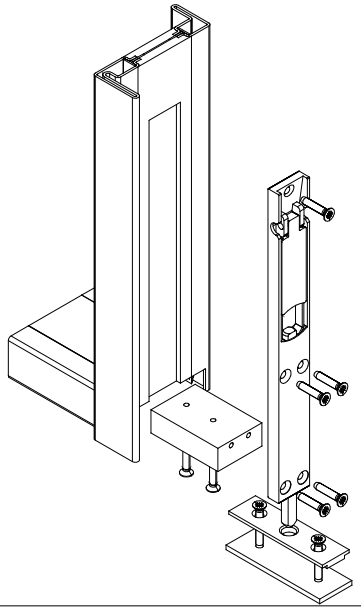




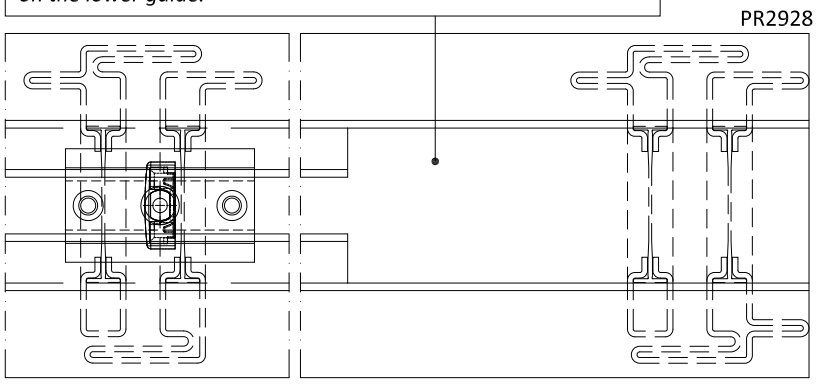
Applicazione valida anche con profilo zoccolo PR2972
Application valid with PR2972 bottom profile



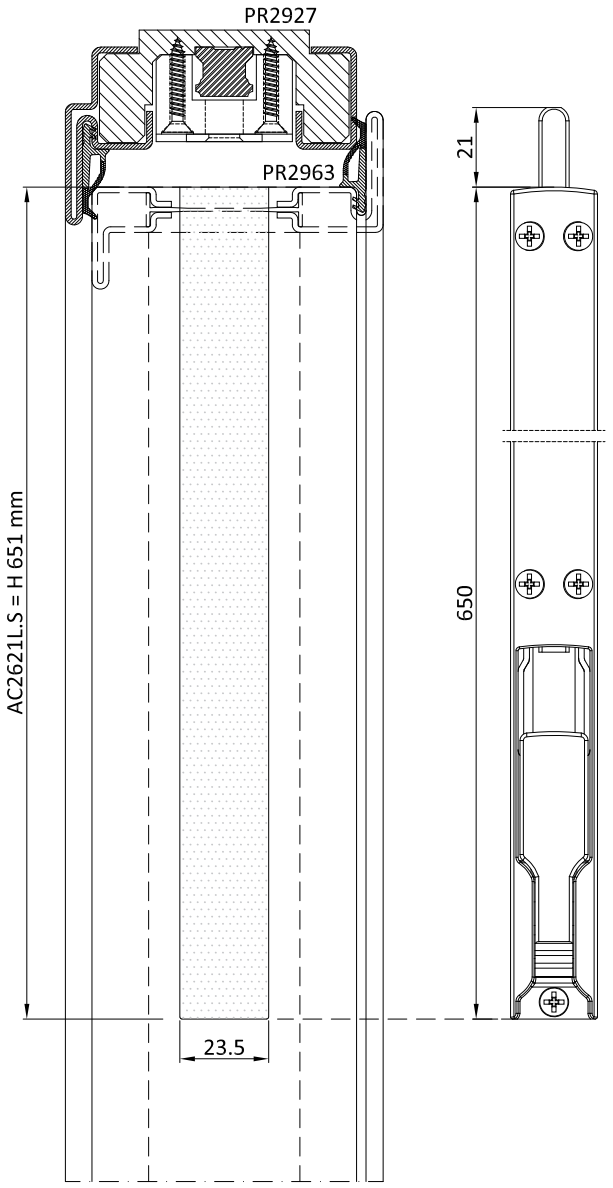


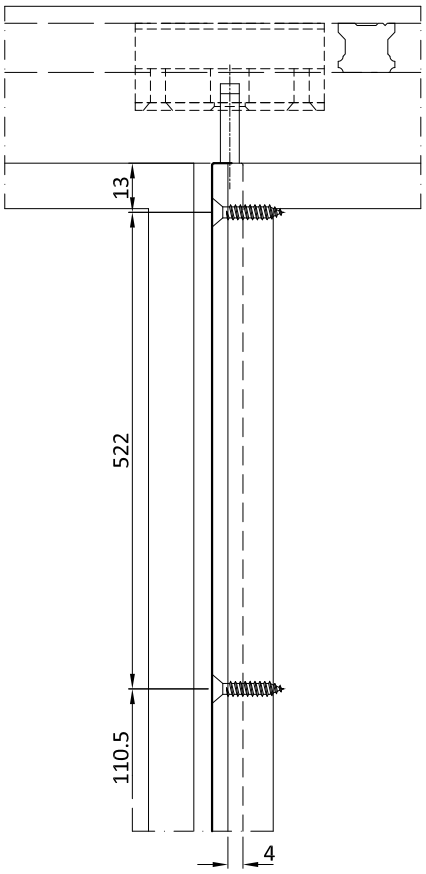


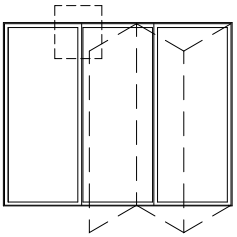
Pre-assemblare l'incontro, inserirlo dallo scasso guida necessario ai carrelli inferiori, farlo scorrere nella corretta posizione prima di inserire ante e carrelli.
Pre-assemble the strike plate before fitting the sashes and rollers, insert and slide it into position from the slot for the bottom rollers on the lower guide.

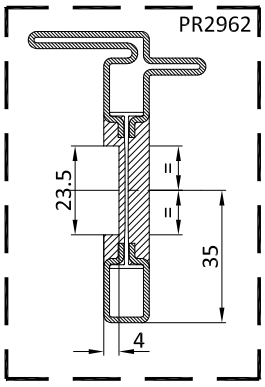


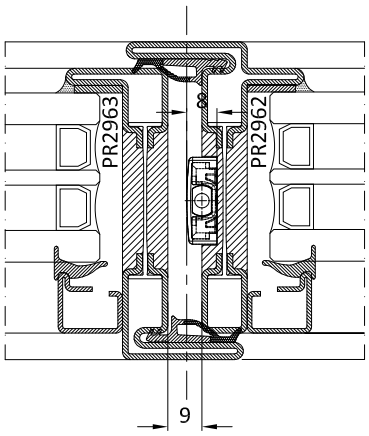
apertura INTERNA
INWARD opening

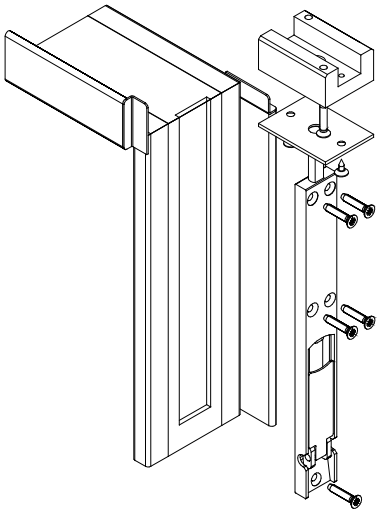


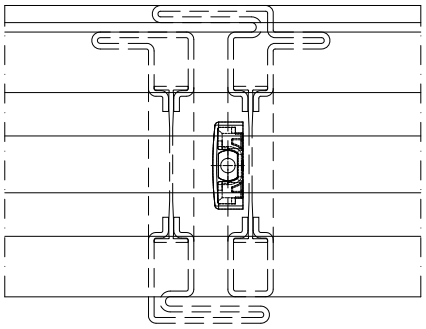




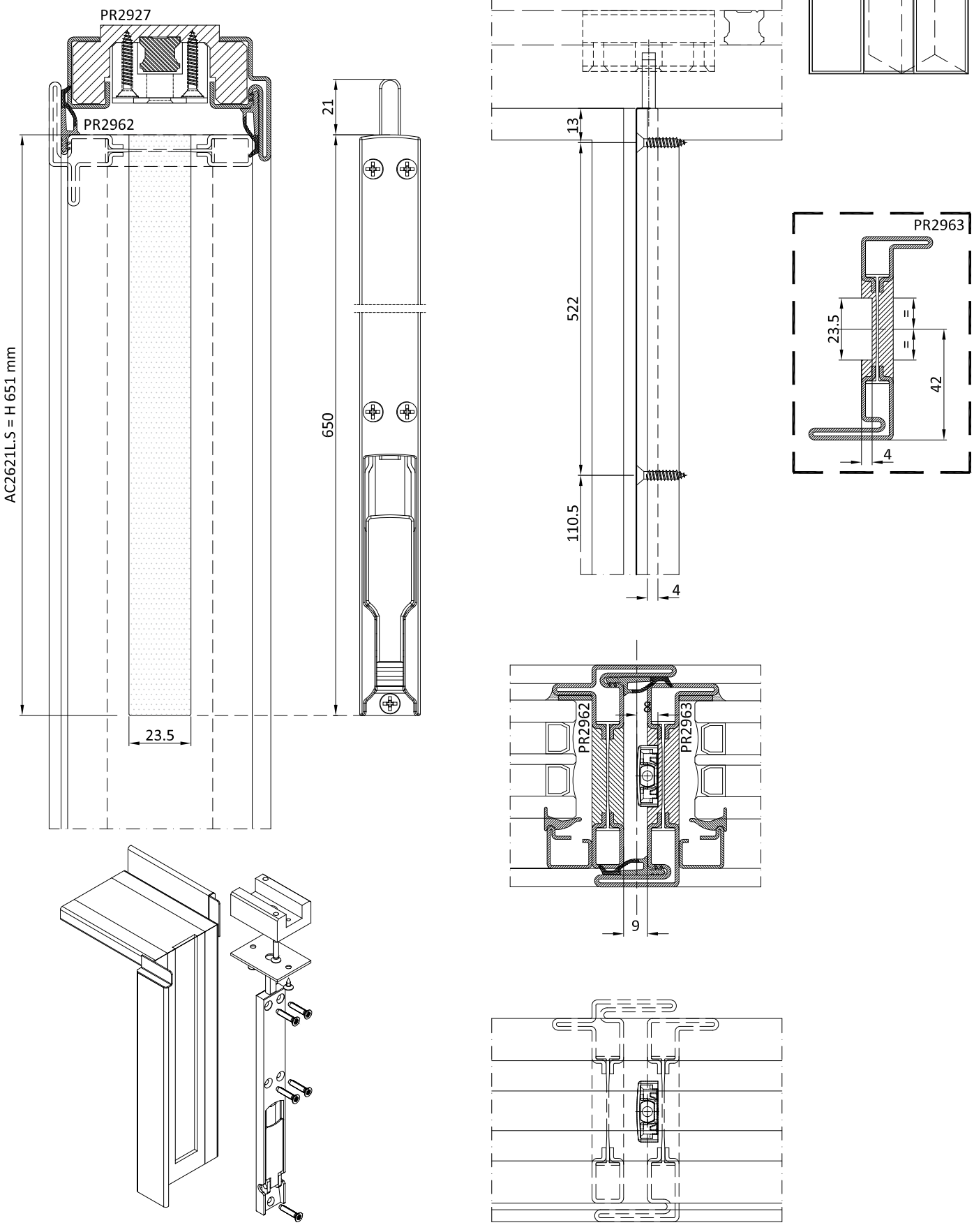


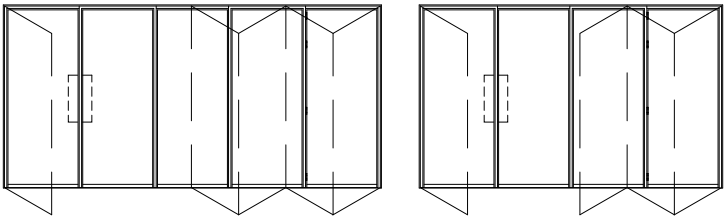


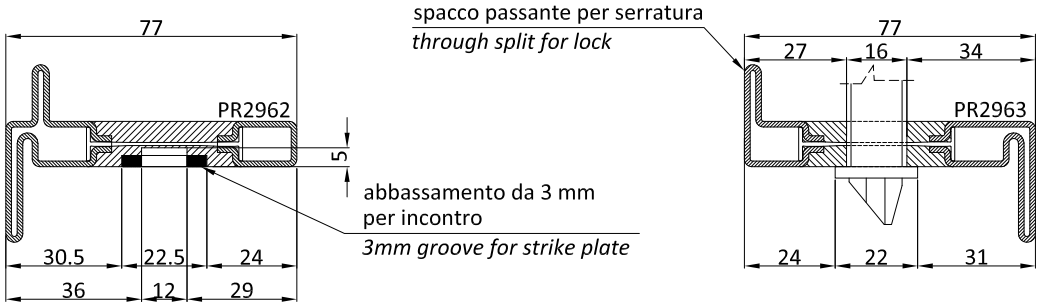


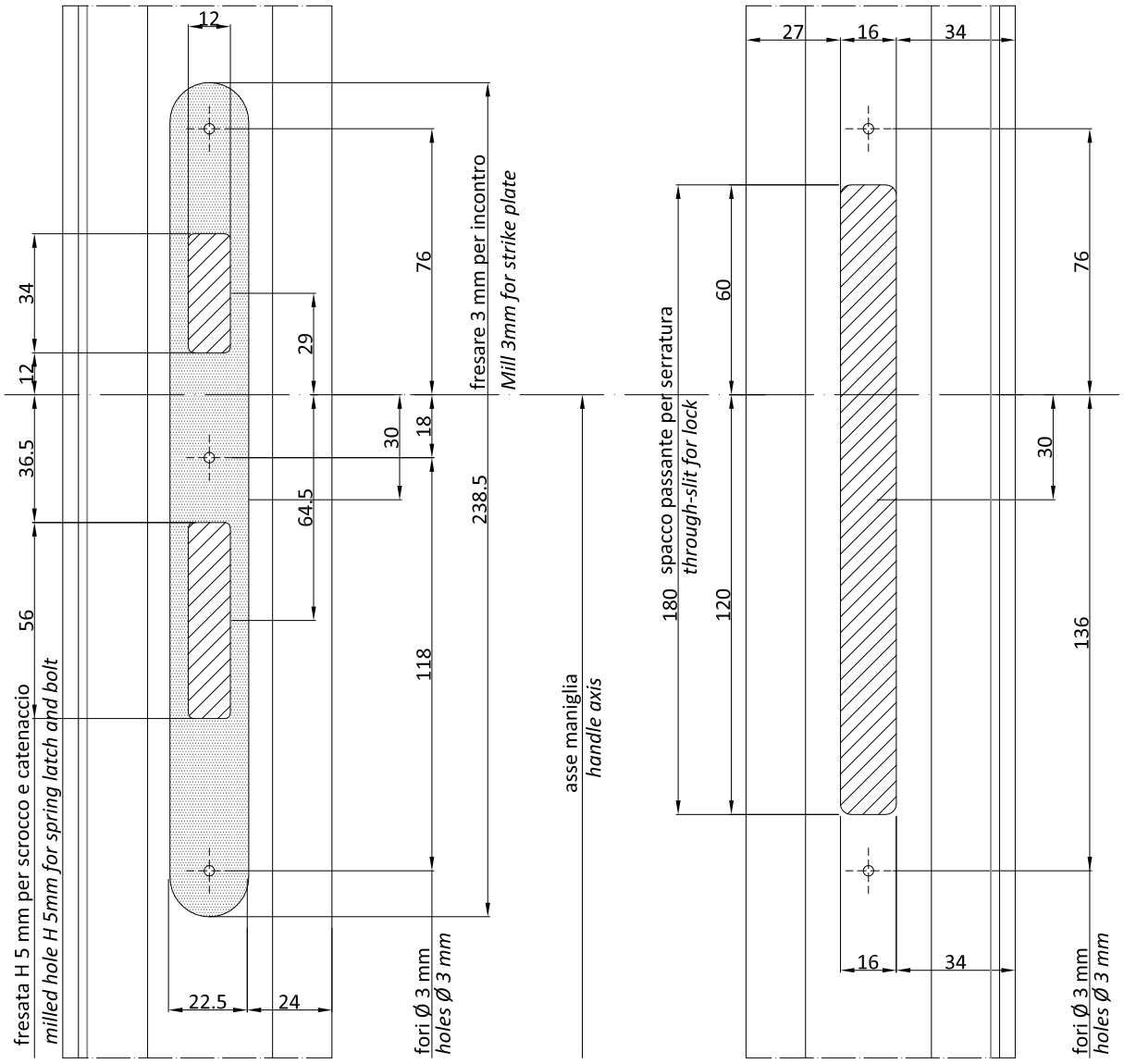


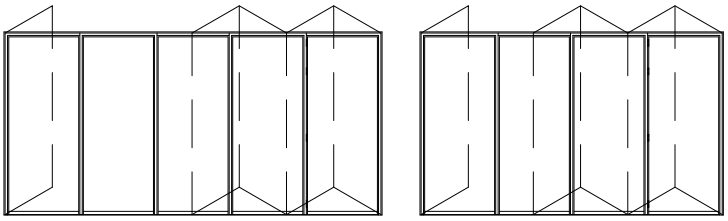
apertura ESTERNA
OUTWARD opening

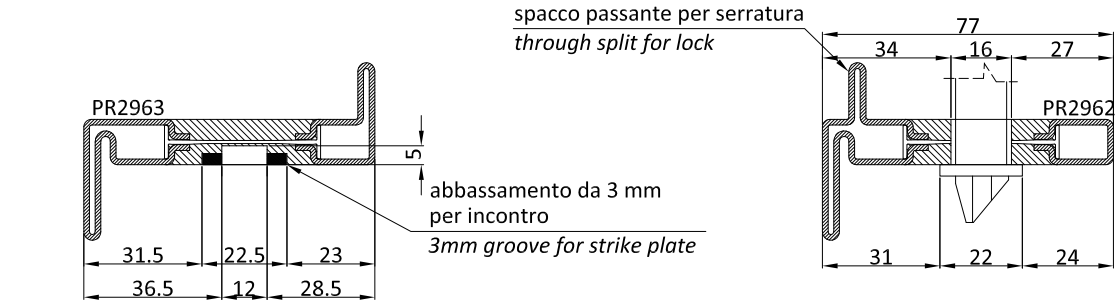


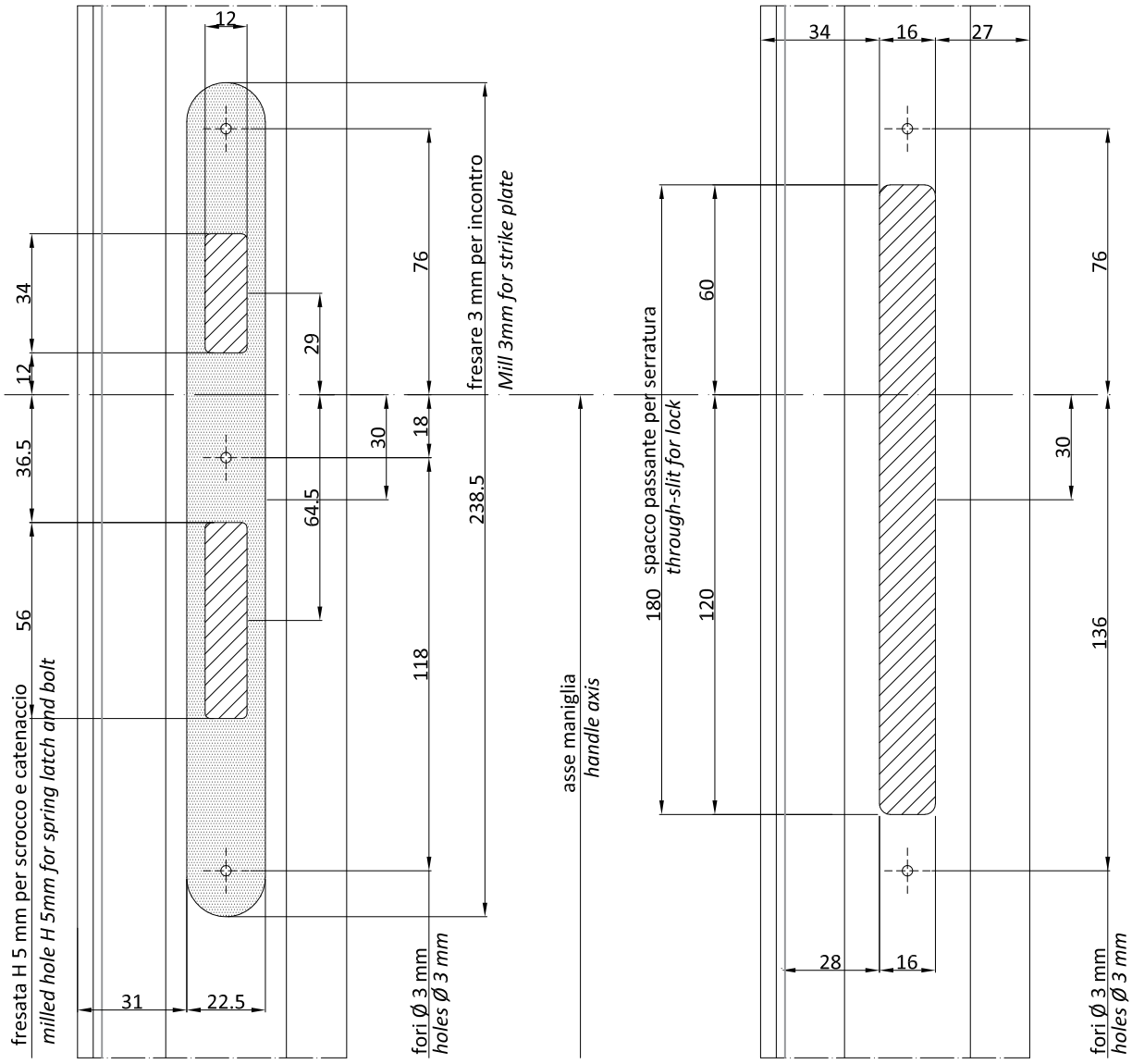


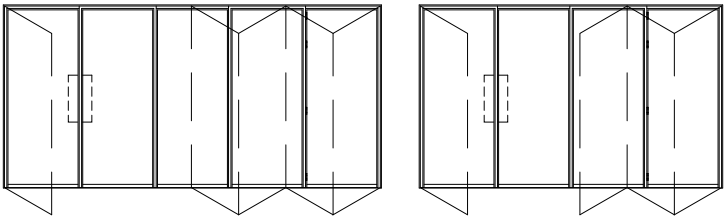

77
PR2962
5
abbassamento da 3 mm
per incontro
3mm groove for strike plate
30.5
22.5
24
36
12
29
spacco passante per serratura
through split for lock
77
27
16
34
PR2963
24
22
31

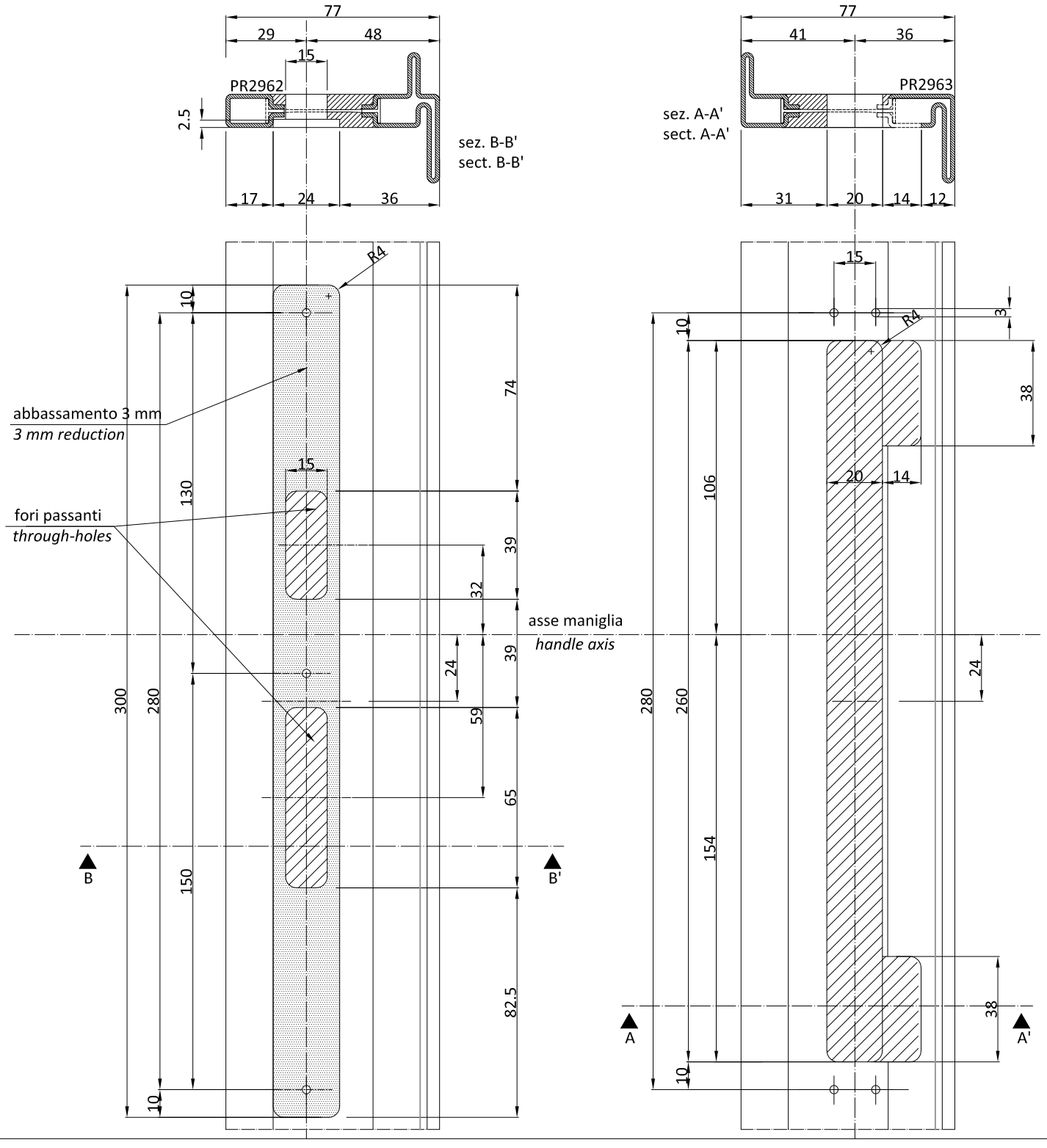

12
34
12
36.5
56
fresata H 5 mm per scrocco e catenaccio
milled hole H 5mm for spring latch and bolt
29
76
fresare 3 mm per incontro
Mill 3mm for strike plate
30
18
64.5
238.5
118
asse maniglia
handle axis
22.5
24
fori Ø 3 mm
holes Ø 3 mm
27
16
34
60
180
spacco passante per serratura
through-slit for lock
120
76
30
136
16
34
fori Ø 3 mm
holes Ø 3 mm

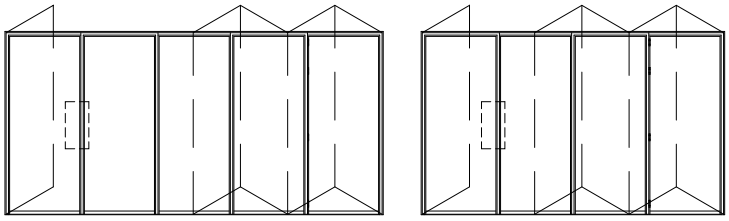


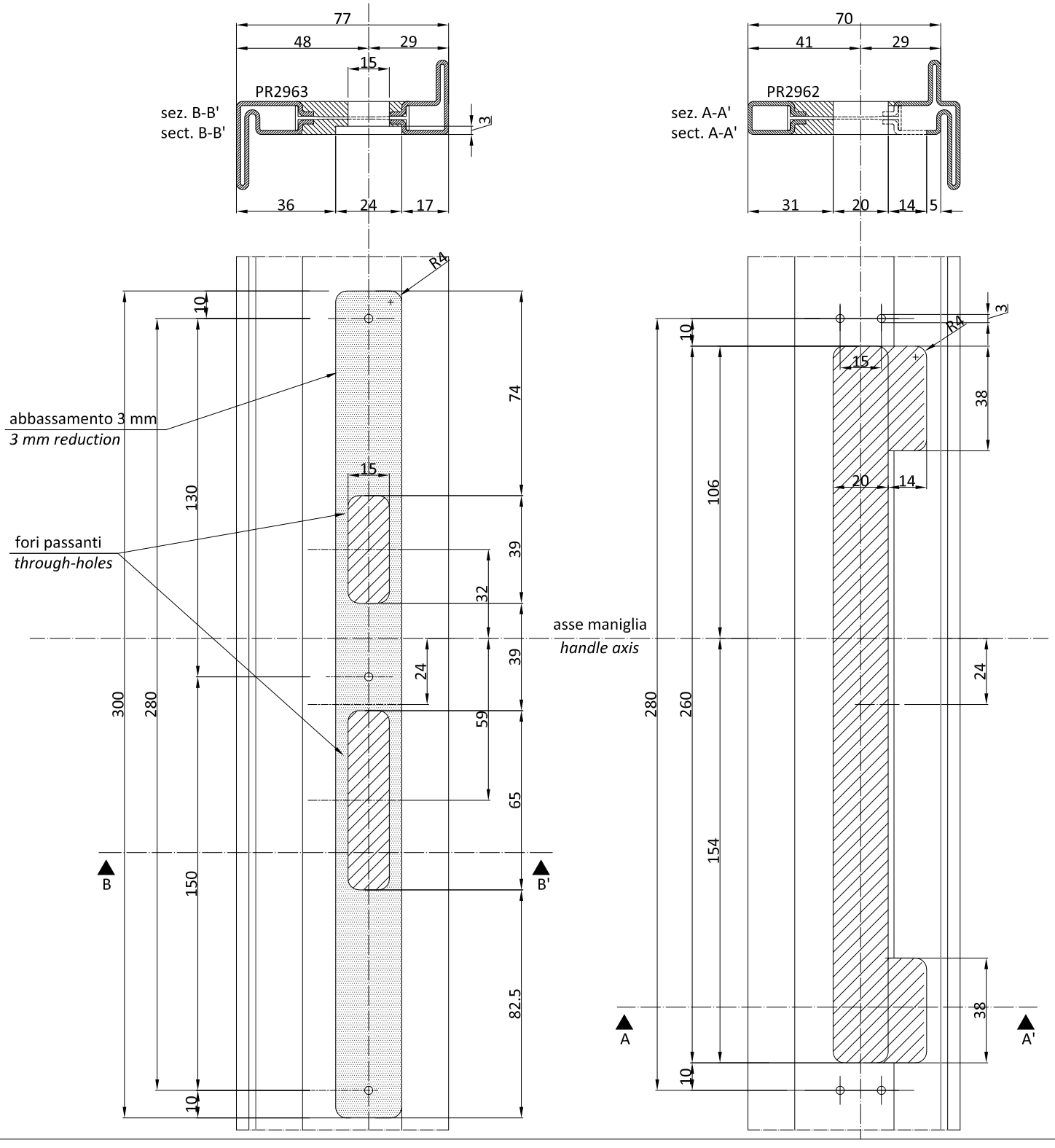

spacco passante per serratura
through split for lock
77
34
16
27
PR2963
PR2962
5
abbassamento da 3 mm
per incontro
3mm groove for strike plate
31.5
22.5
23
36.5
12
28.5
31
22
24


12
34
16
27
34
12
36.5
56
29
76
fresare 3 mm per incontro
Mill 3mm for strike plate
30
18
64.5
238.5
118
fresata H 5 mm per scrocco e catenaccio
milled hole H 5mm for spring latch and bolt
asse maniglia
handle axis
180
spacco passante per serratura
through-slit for lock
60
120
76
30
136
31
22.5
28
16
fori Ø 3 mm
holes Ø 3 mm

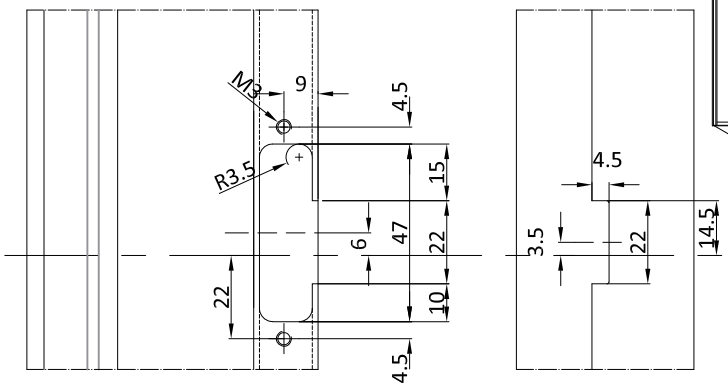


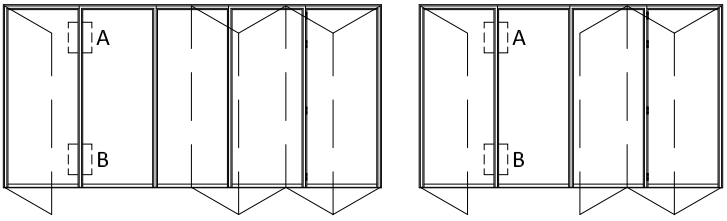

77
29
48
15
PR2962
2.5
sez. B-B'
sect. B-B'
17
24
36
77
41
36
PR2963
sez. A-A'
sect. A-A'
31
20
14
12
R4
10
74
abbassamento 3 mm
3 mm reduction
15
130
fori passanti
through-holes
39
32
asse maniglia
handle axis
24
39
300
280
59
65
B
B'
150
82.5
10
15
3
R4
38
106
20
14
280
260
24
154
A
A'
38
10



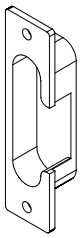

77
48
29
15
PR2963
sez. B-B'
sect. B-B'
3
36
24
17
70
41
29
PR2962
sez. A-A'
sect. A-A'
31
20
14
5
R4
10
abbassamento 3 mm
3 mm reduction
fori passanti
through-holes
130
74
39
32
24
59
65
300
280
150
82.5
B
B'
asse maniglia
handle axis
106
154
260
38
A
A'

lavorazione applicazione incontro
processing strike plate installation

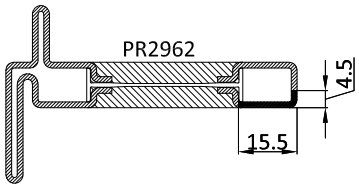


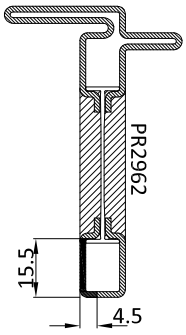


asse nottolino 3^ chiusura in posizione aperta
latch axis for the 3rd lock in open position

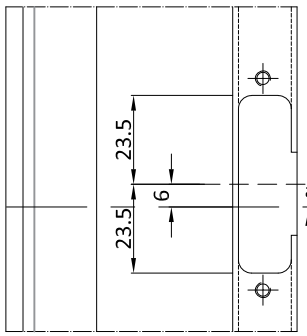


Incontro 3^ chiusura
3rd lock strike plate

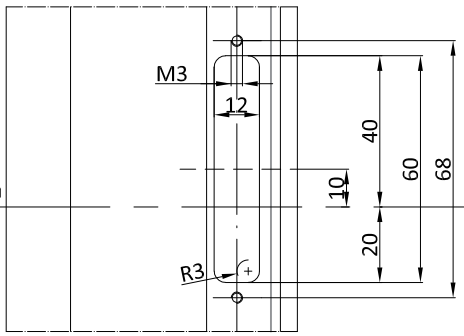




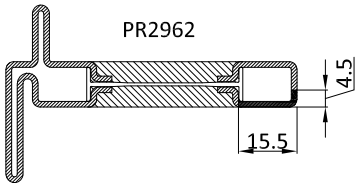
lavorazione applicazione nottolino
processing for the assembling of the 3rd lock

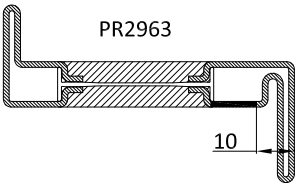


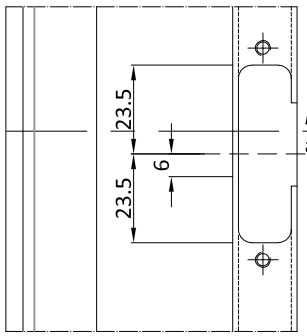
asse nottolino 3^ chiusura in posizione aperta
latch axis for the 3rd lock in open position



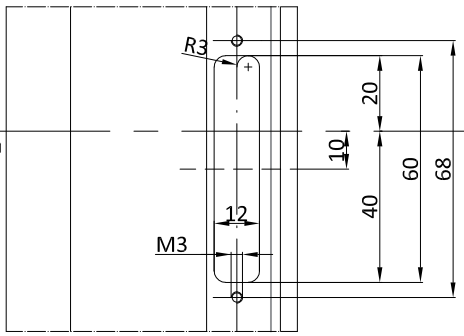
lavorazione superiore A
upper processing A







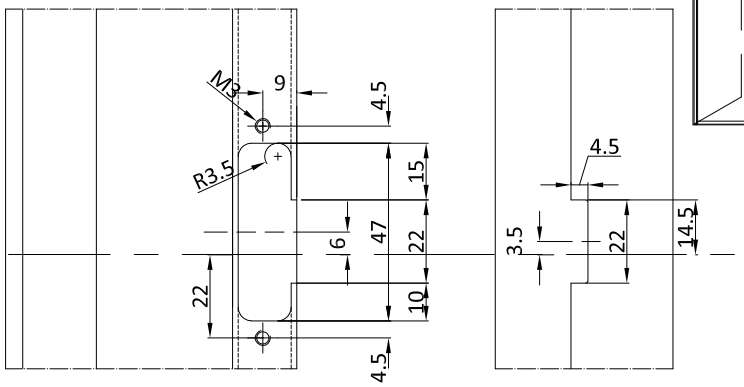
latch axis for the 3rd lock in open position
asse nottolino 3^ chiusura in posizione aperta

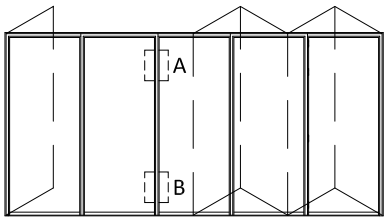


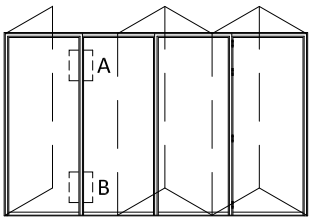
lavorazione inferiore B
lower processing B

lavorazione superiore-inferiore specchiata orizzontalmente
upper working-bottom working horizontally mirrored

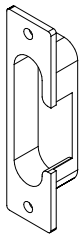
lavorazione applicazione incontro
processing strike plate installation



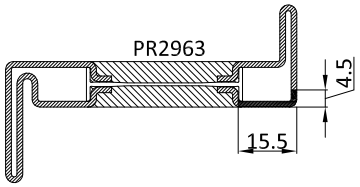


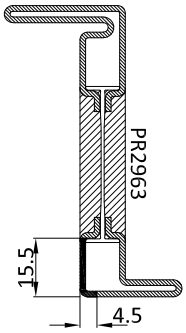


asse nottolino 3^ chiusura in posizione aperta
latch axis for the 3rd lock in open position

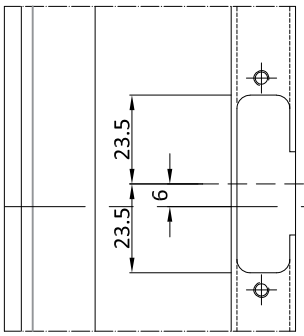


Incontro 3^ chiusura
3rd lock strike plate

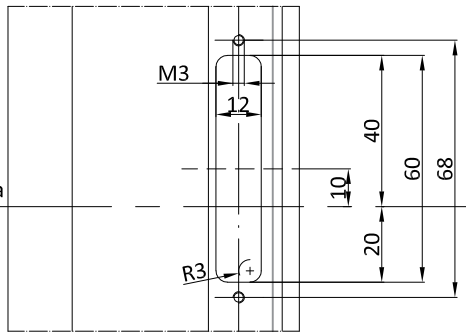




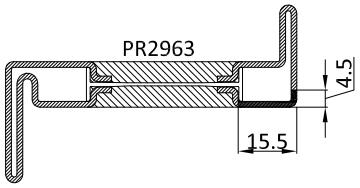
lavorazione applicazione nottolino
processing for the assembling of the 3rd lock

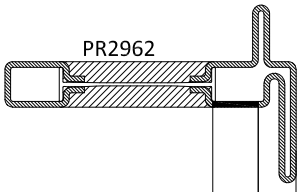


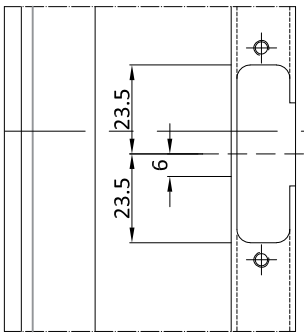
asse nottolino 3^ chiusura in posizione aperta
latch axis for the 3rd lock in open position



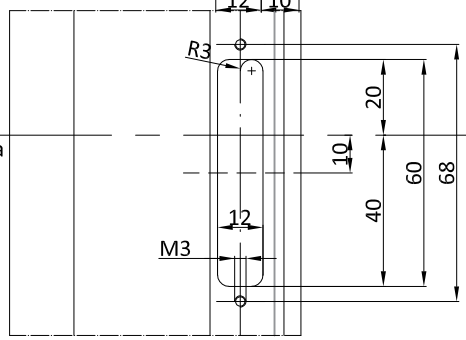
lavorazione superiore A
upper processing A





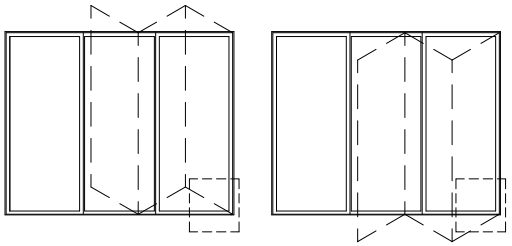


latch axis for the 3rd lock in open position
asse nottolino 3^ chiusura in posizione aperta

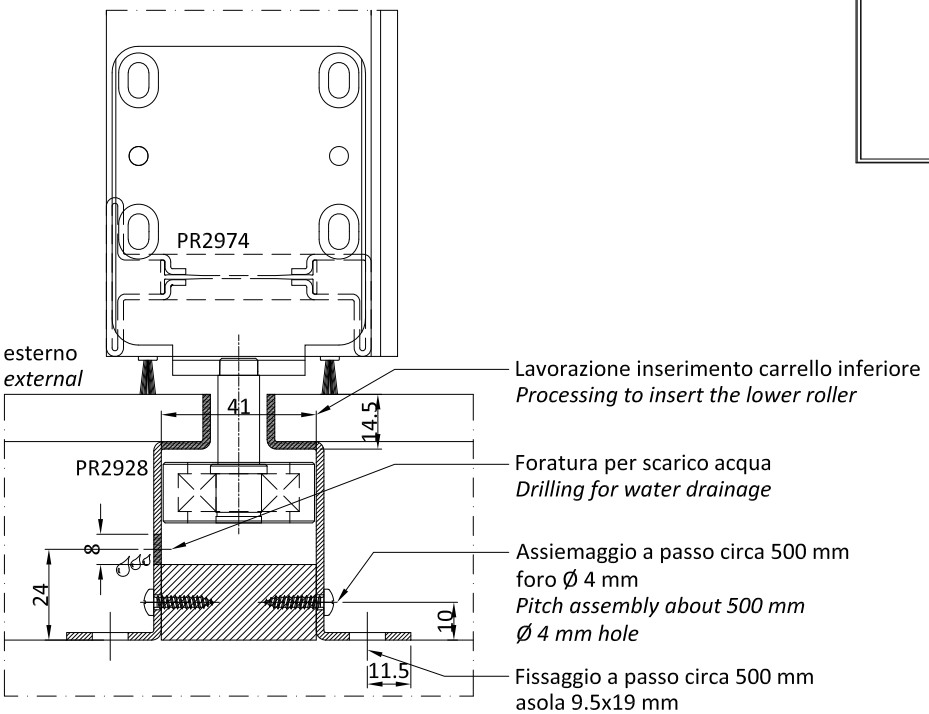


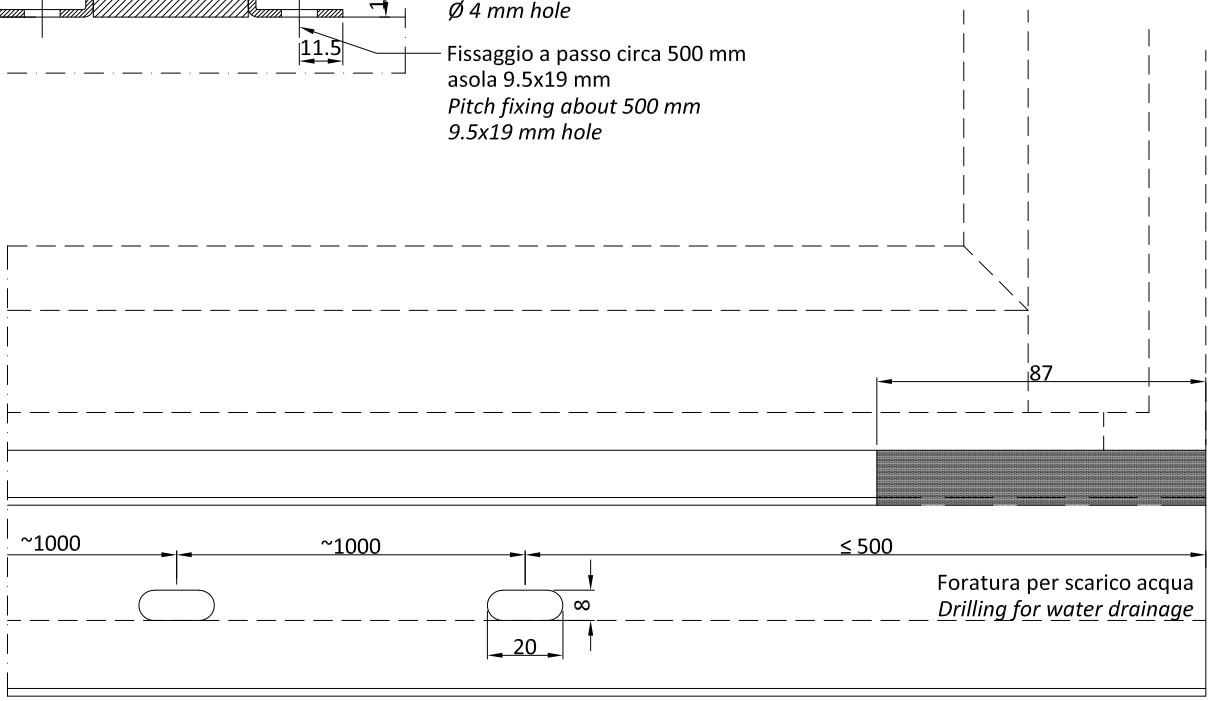
lavorazione inferiore B
lower processing B

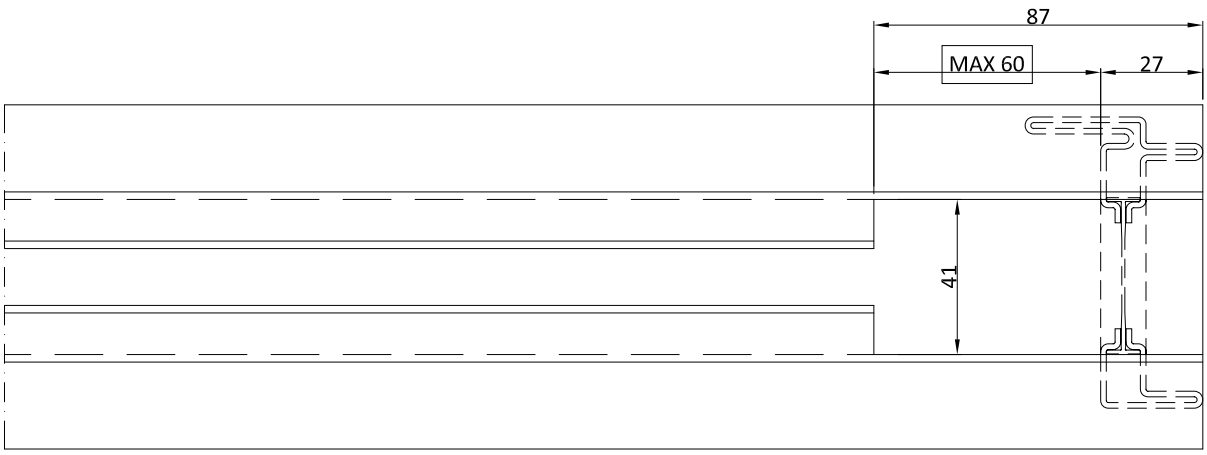
lavorazione superiore; inferiore specchiata orizzontalmente
upper working; bottom working horizontally mirrored

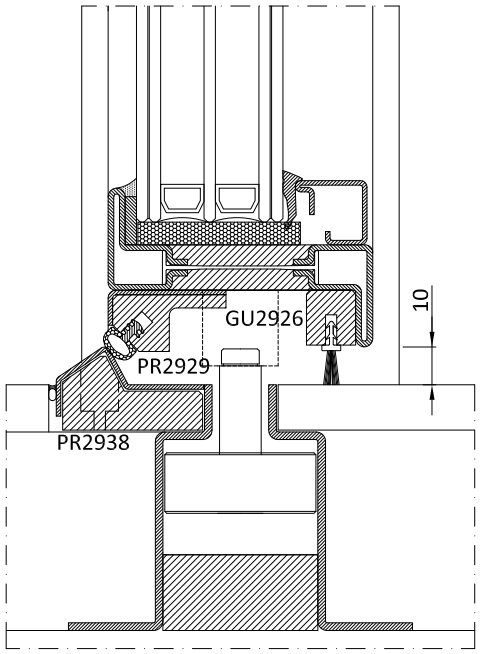


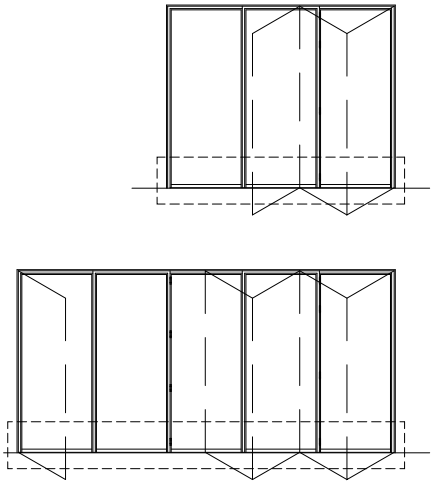
Applicazione tipo, valida per aperture interne e aperture esterne
Example application, for internal and external openings

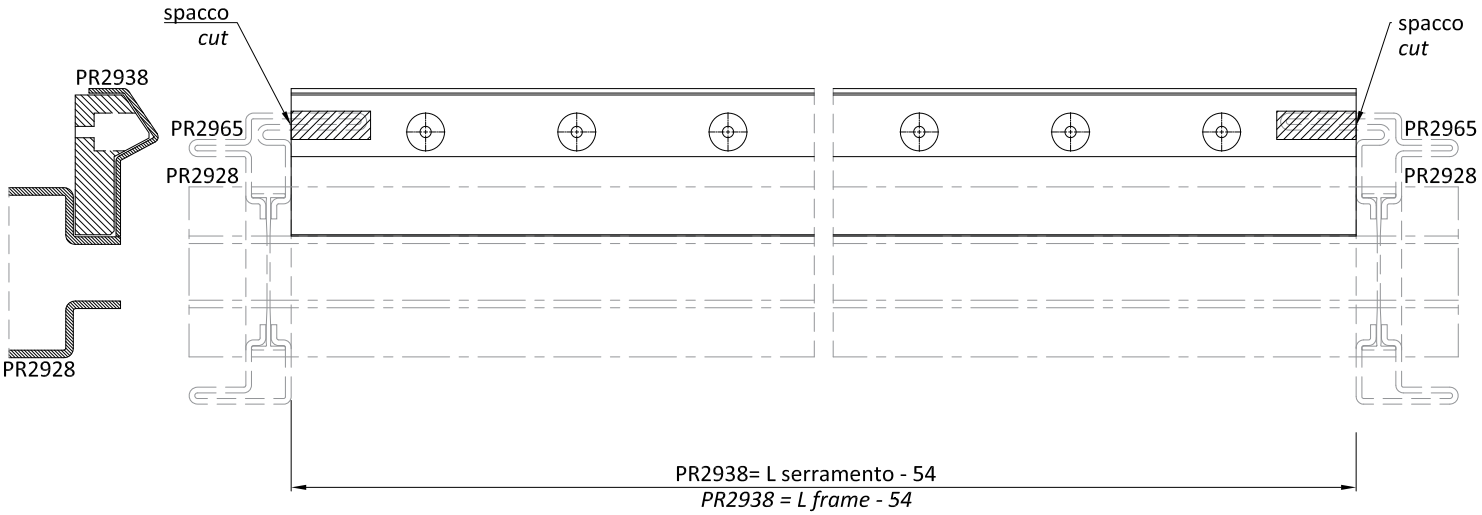


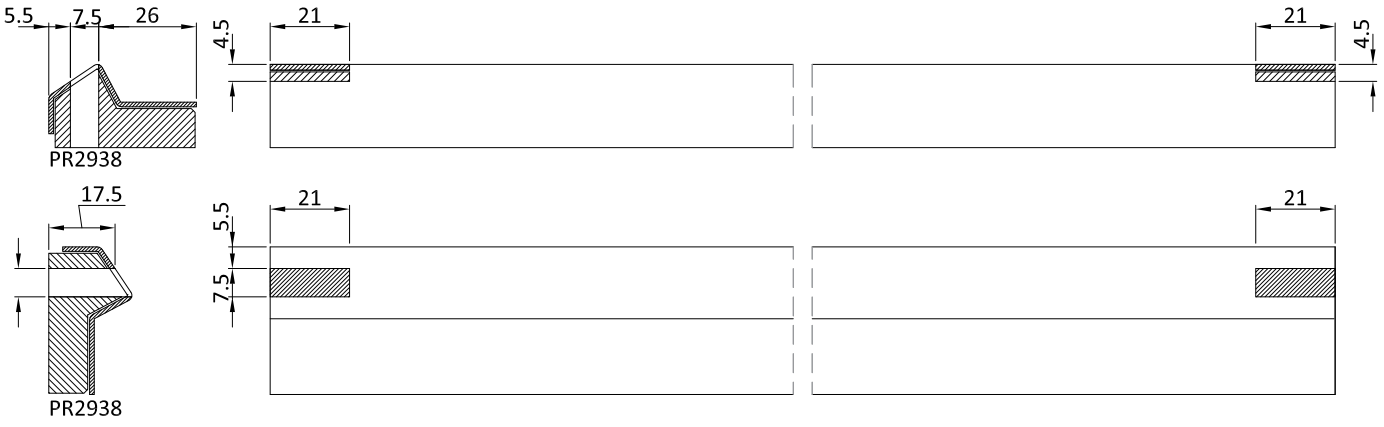


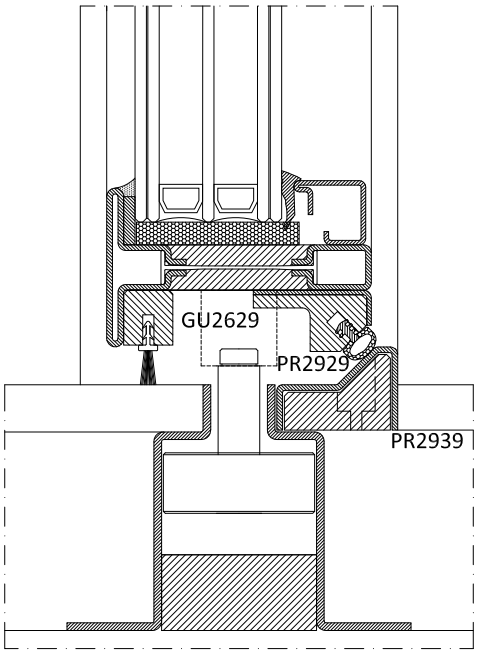


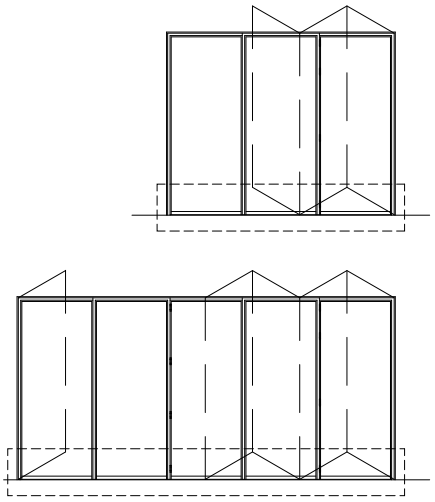

10
GU2926
PR2929
PR2938

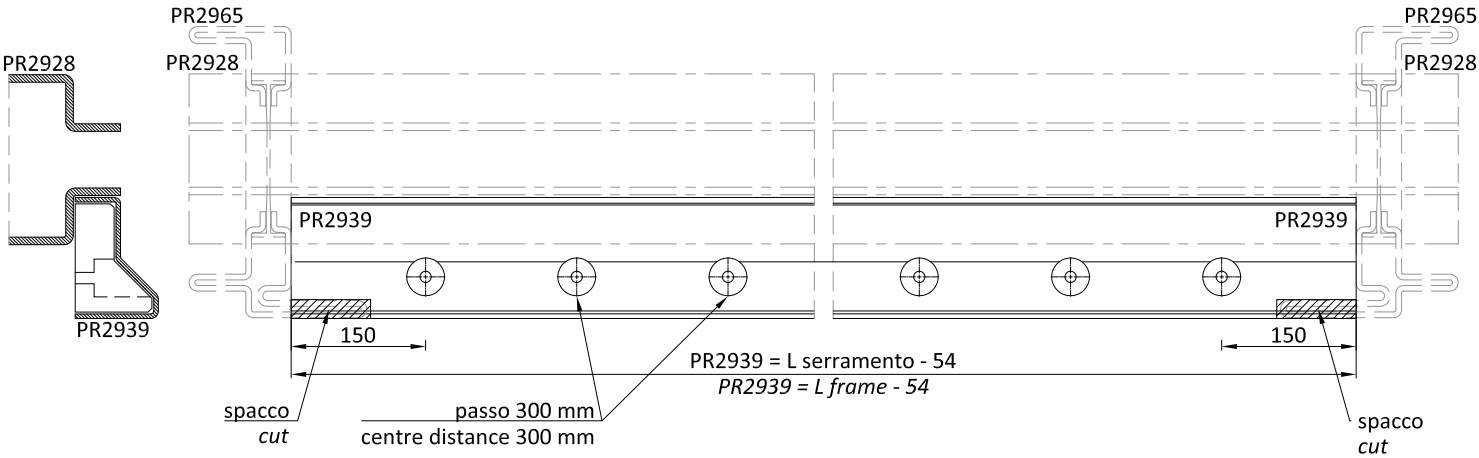


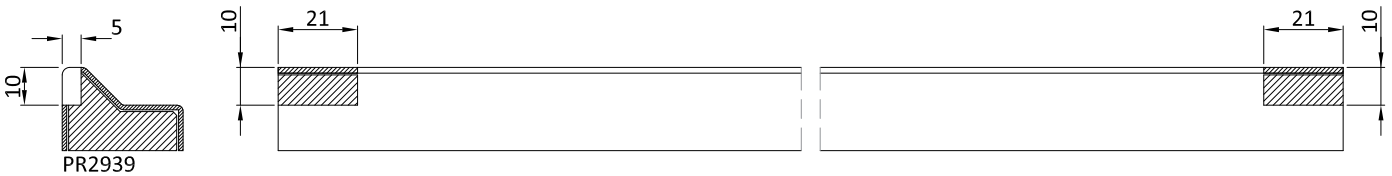

spacco
cut
spacco
cut
PR2938
PR2965
PR2928
PR2965
PR2928
PR2928
PR2938= L serramento - 54
PR2938 = L frame - 54

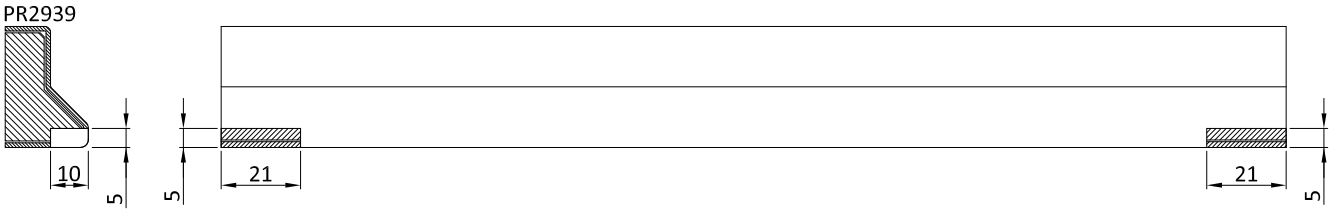

5.5
7.5
26
4.5
21
21
4.5
PR2938
17.5
21
21
5.5
7.5
7.5
PR2938

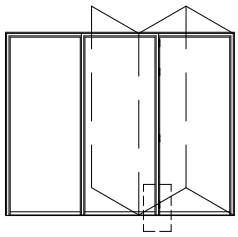

GU2629
PR2929
PR2939

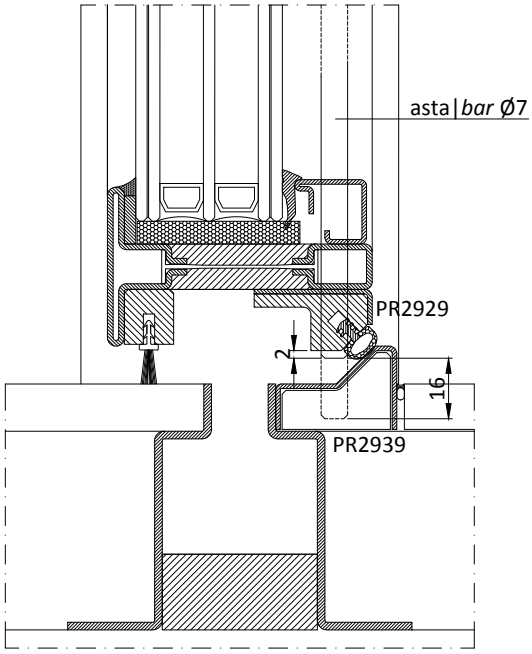


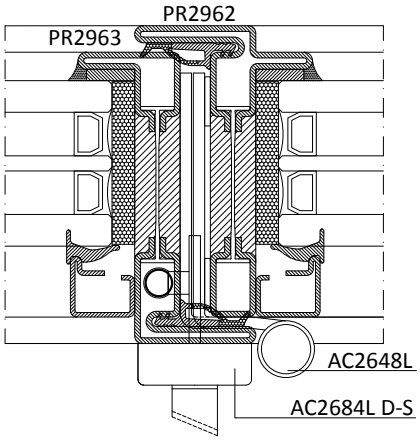

PR2965
PR2928
PR2928
PR2965
PR2928
PR2939
PR2939
PR2939
150
150
PR2939 = L serramento - 54
PR2939 = L frame - 54
spacco
cut
passo 300 mm
centre distance 300 mm
spacco
cut

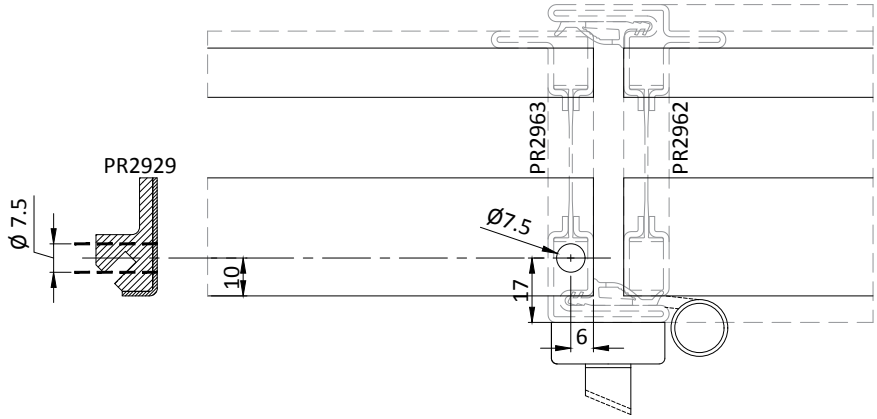

5
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PR2939
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21
21
10


PR2939
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5
5
21
21
5

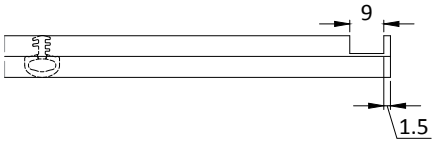




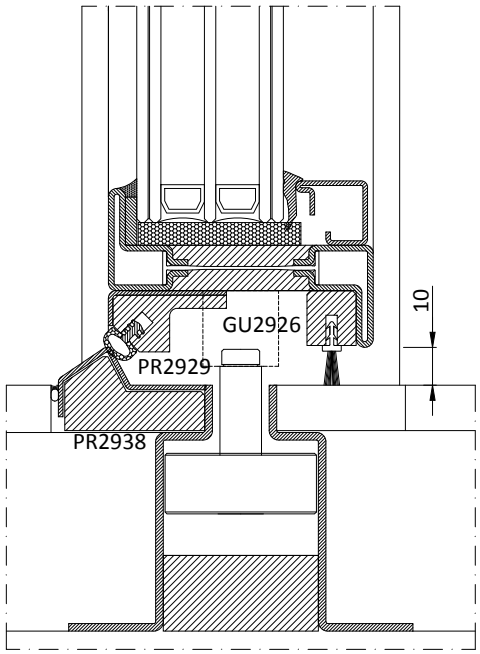


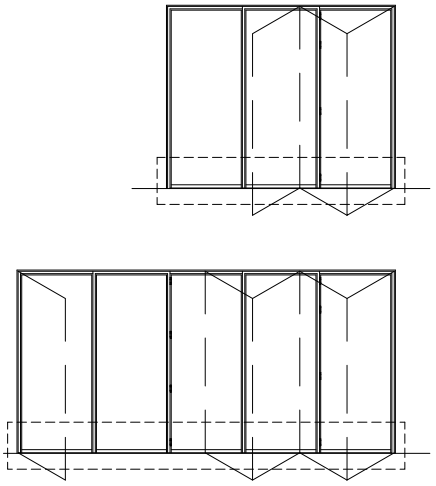


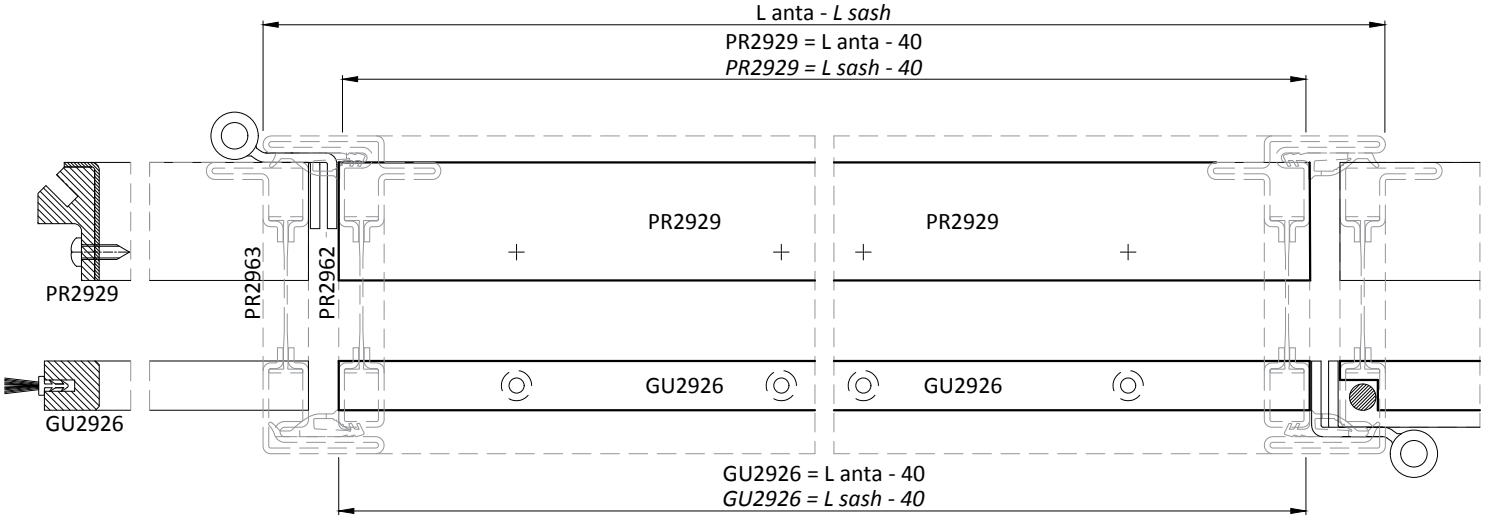


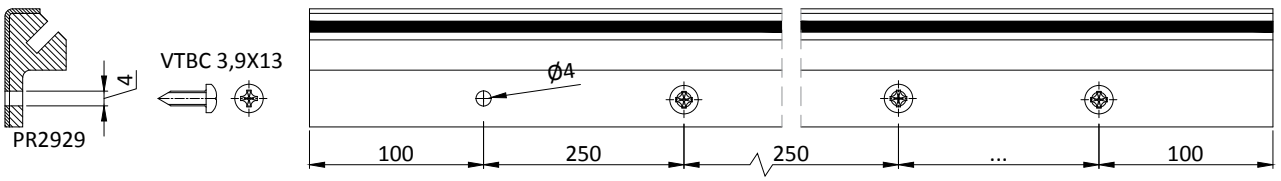


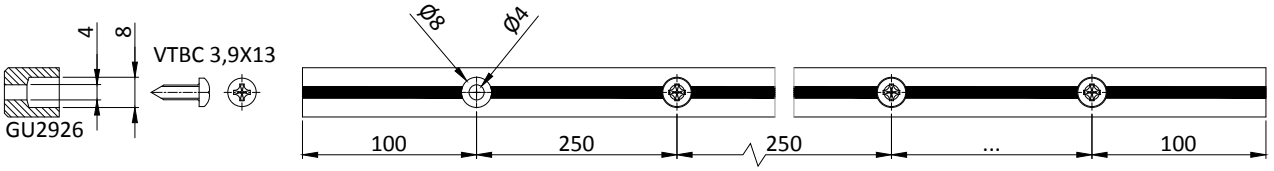
in prossimità del taglio incollare la guarnizione
near the cut, glue the gasket



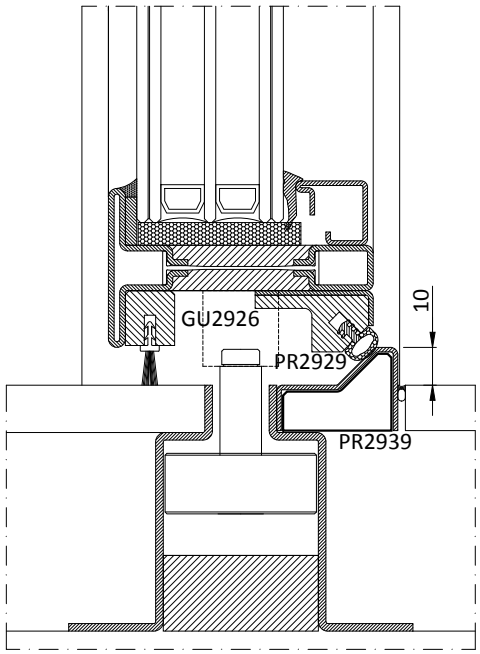


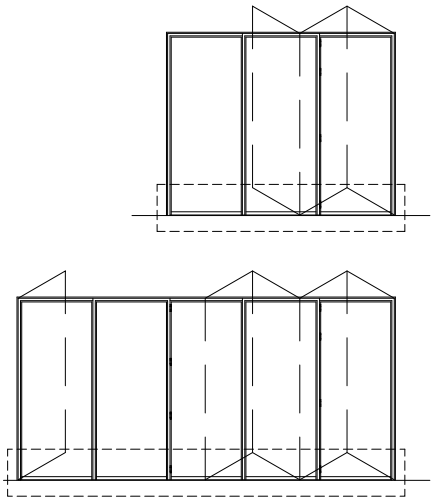


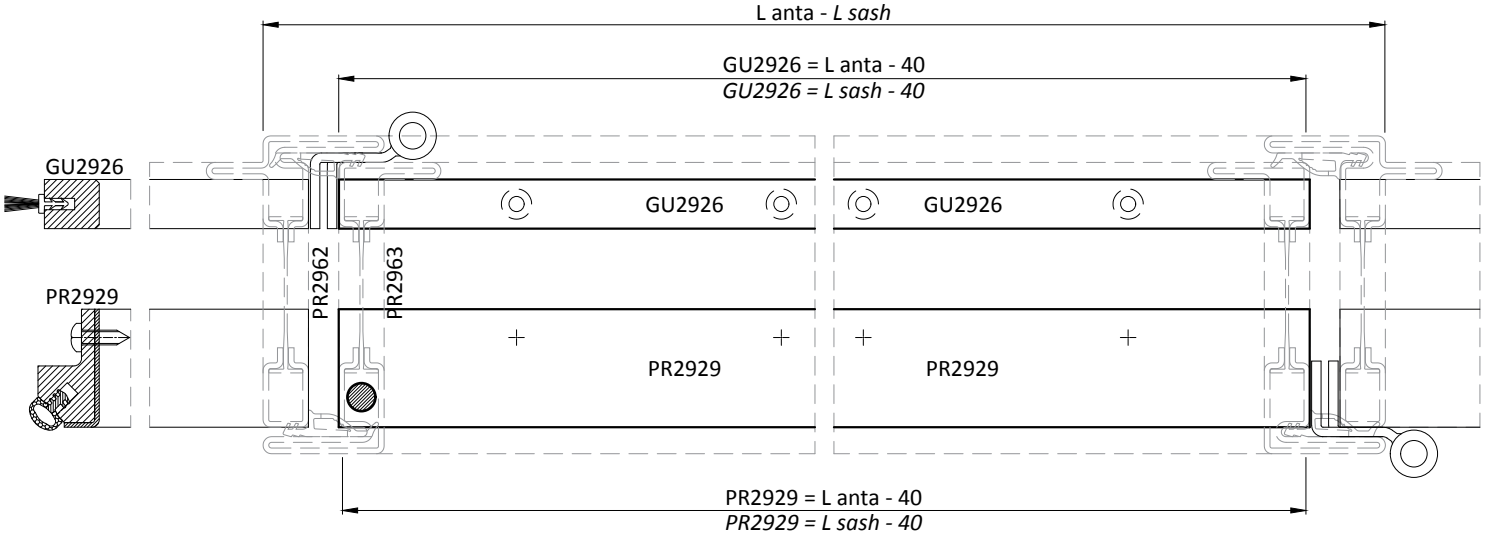


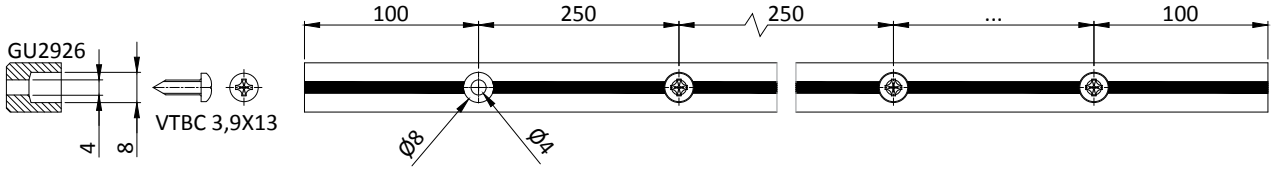


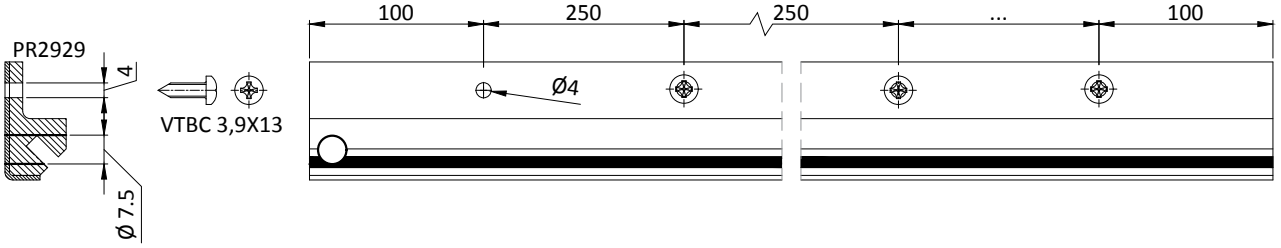
viti non comprese - *screws not supplied*



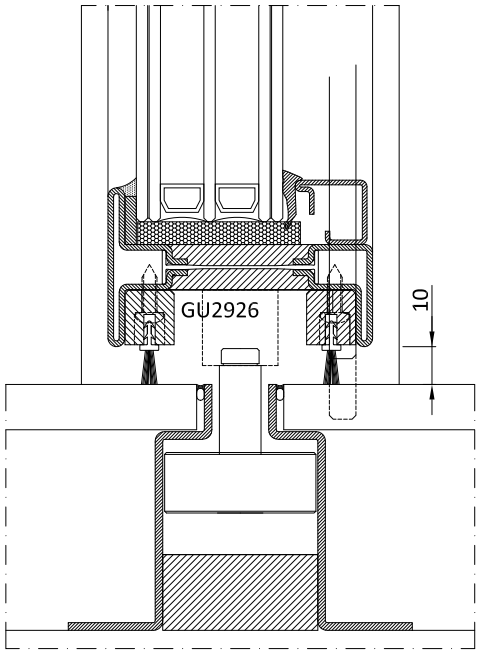


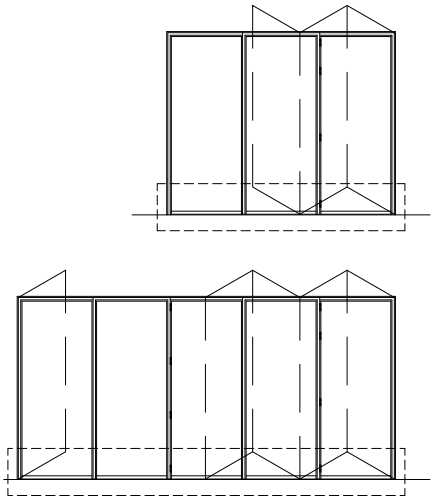


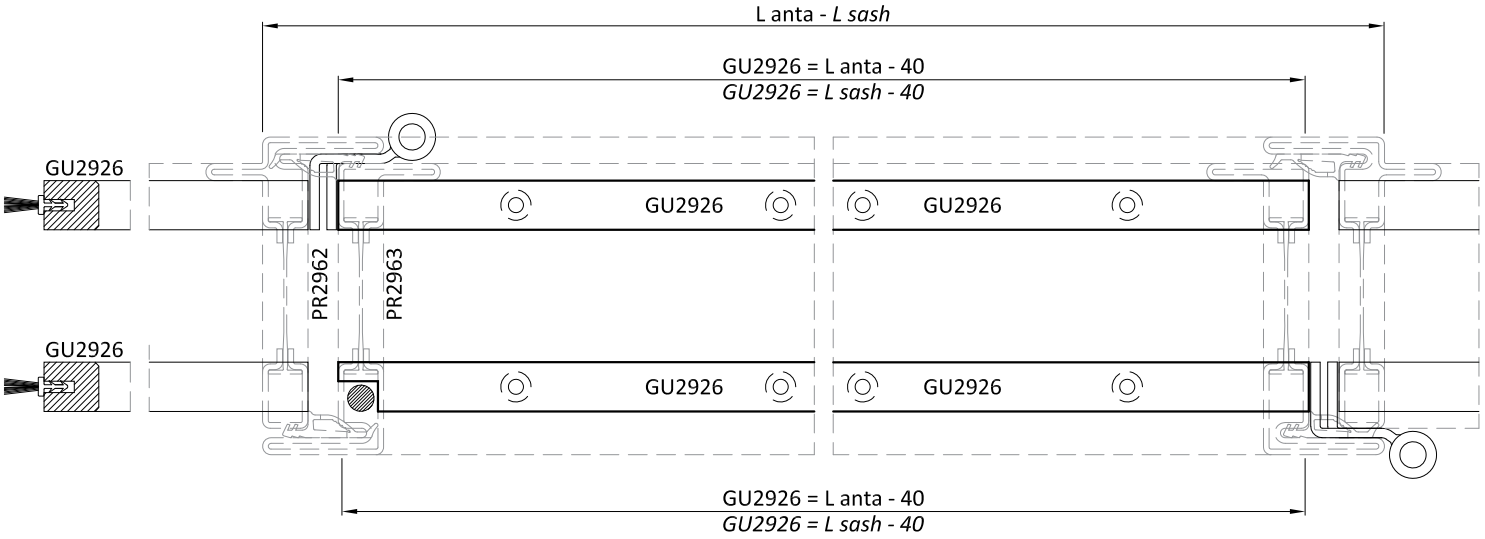


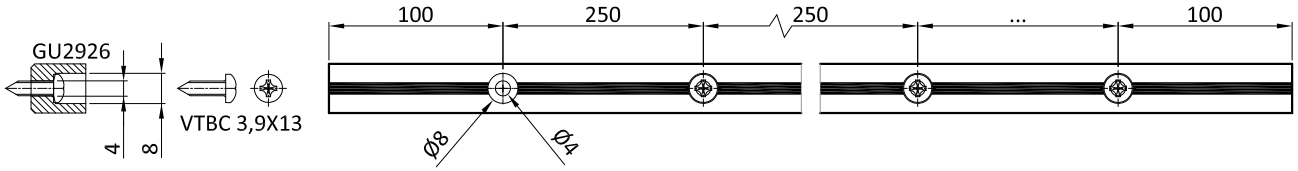


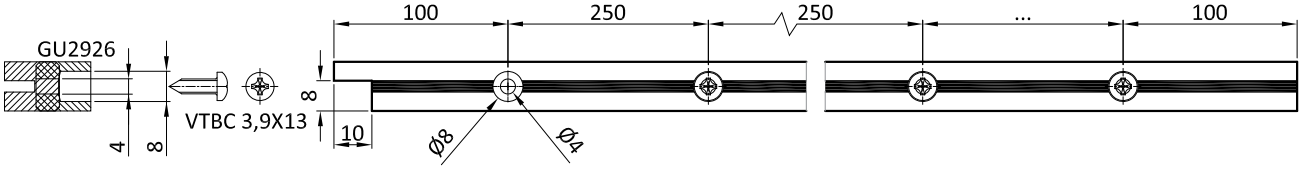
viti non comprese - *screws not supplied*



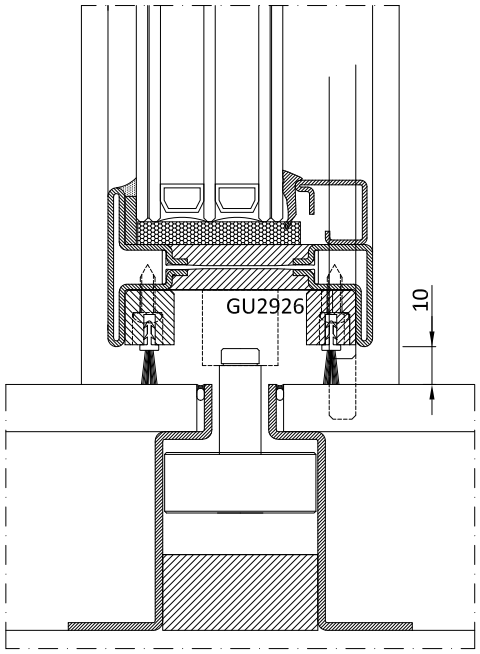


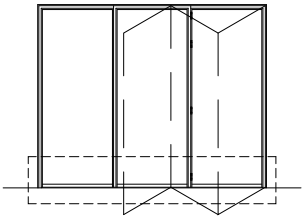


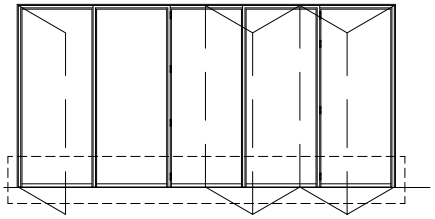


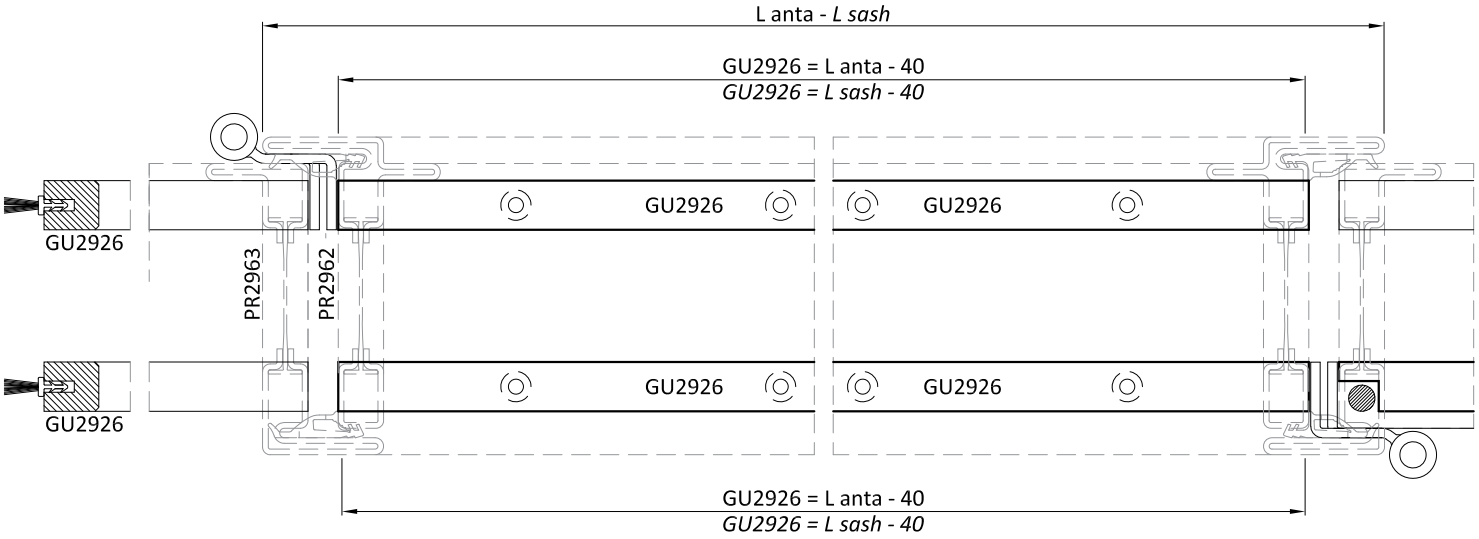


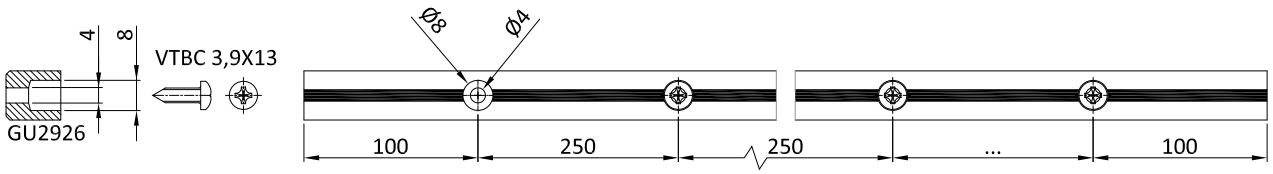
viti non comprese - *screws not supplied*

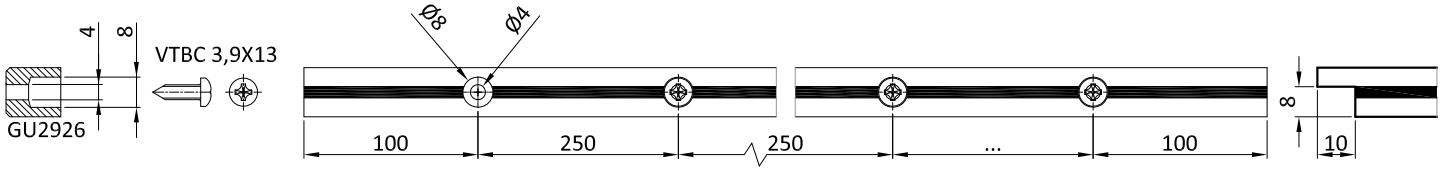




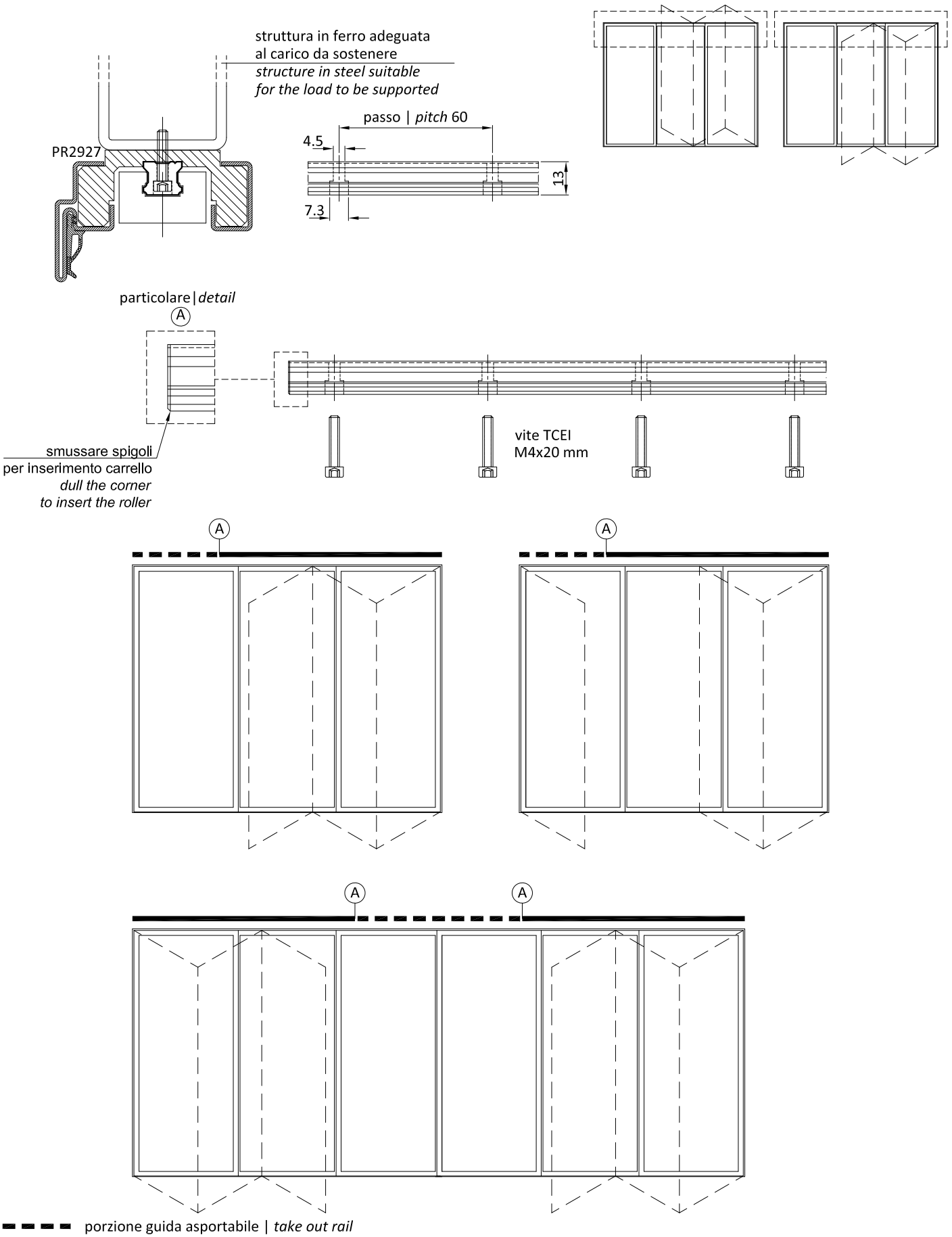




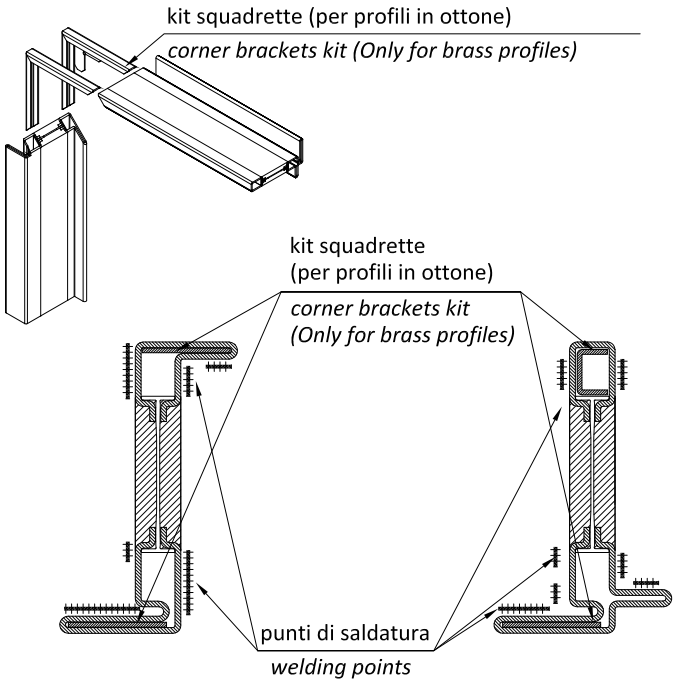


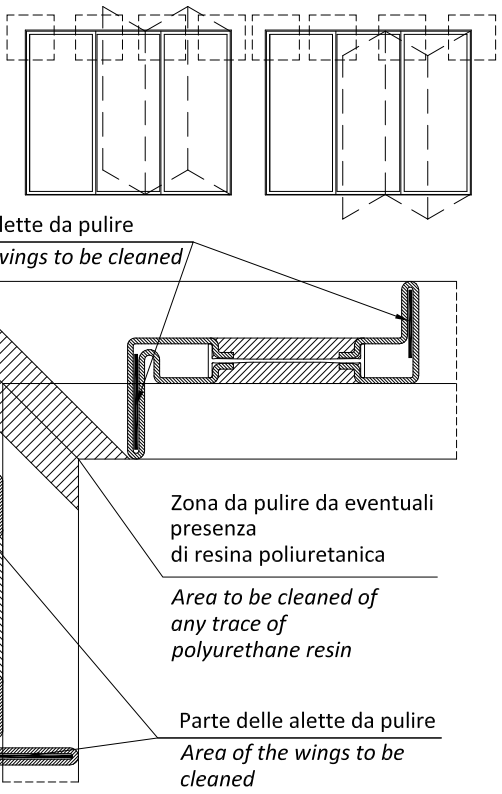


viti non comprese - *screws not supplied*



TCEI M4x20 mm
viti non comprese - *screws not supplied*





Ottone
Utilizzare le squadrette di allineamento, sigillare tutte le superfici di contatto tra i profili che non vanno saldate. Saldare a TIG a punti le zone indicate.

Brass
Use corner brackets, seal all surfaces in touch with profiles that are not to be seam-welded. Spot weld (TIG) the marked areas.

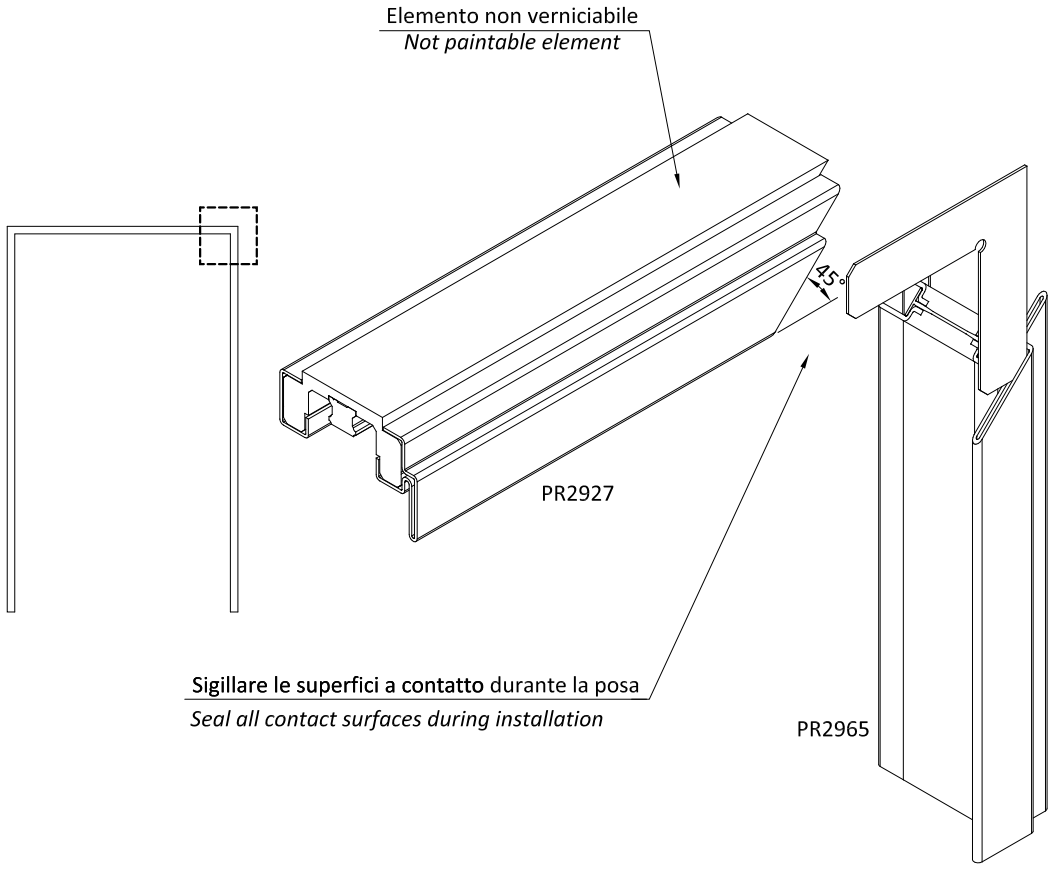
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld all contact surfaces.

N.B. Prima di saldare l'angolo del profilo eliminare l'eventuale resina poliuretanica presente all'interno dell'aletta scaldando leggermente il profilo stesso per circa 20 mm. in modo da sciogliere la resina ed eliminare le impurità presenti.

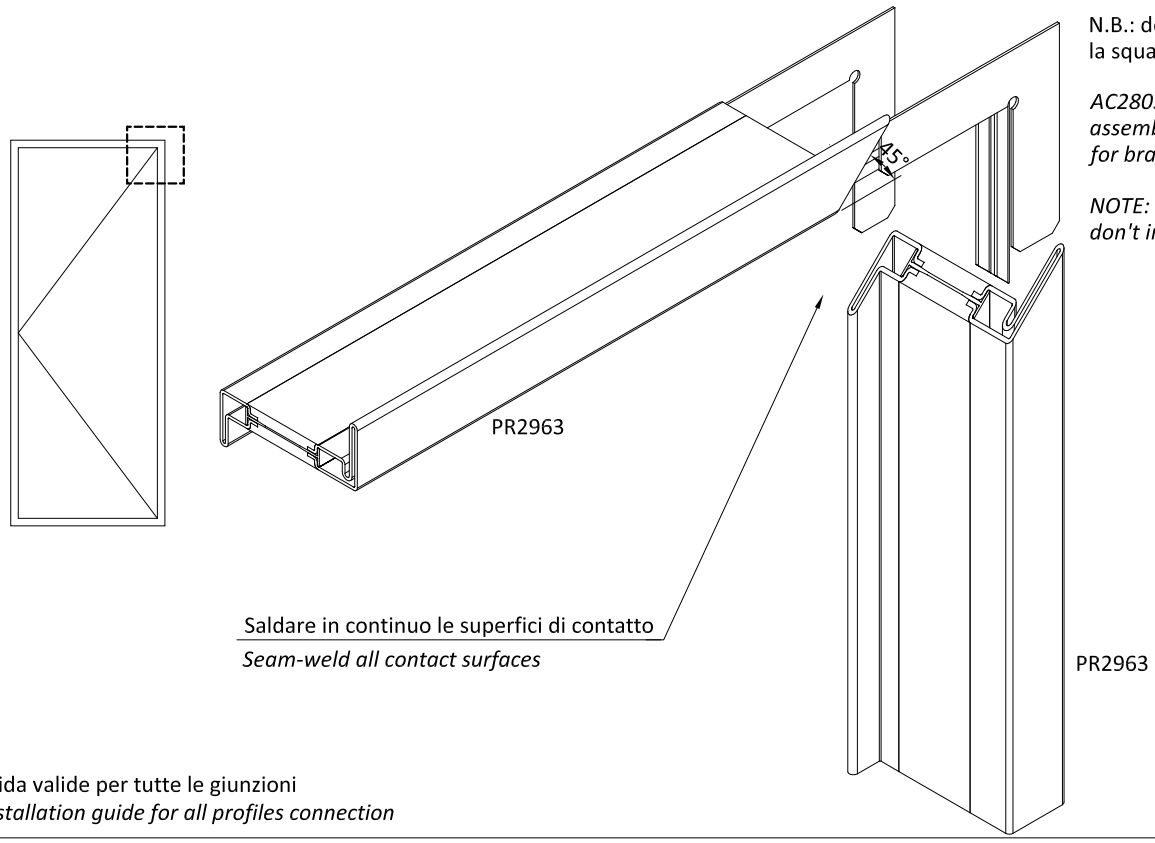
ATTN. Before welding the corner please remove any trace of polyurethane resin in the internal side of casin, heating the profile for ca. 20 mm to melt the resin and removein this way all other impurities.

Profilo *Profile*	Kit squadrette *Corner brackets set*
Codice *Code*	Codice *Code*
PR2963-PR2963	AC 2803I
PR2962-PR2963	AC 2832I
PR2962-PR2962	AC 2862I
PR2965-PR2927	AC 2865I



AC2865I squadretta di assiemaggio

AC2865I assembling corner brackets



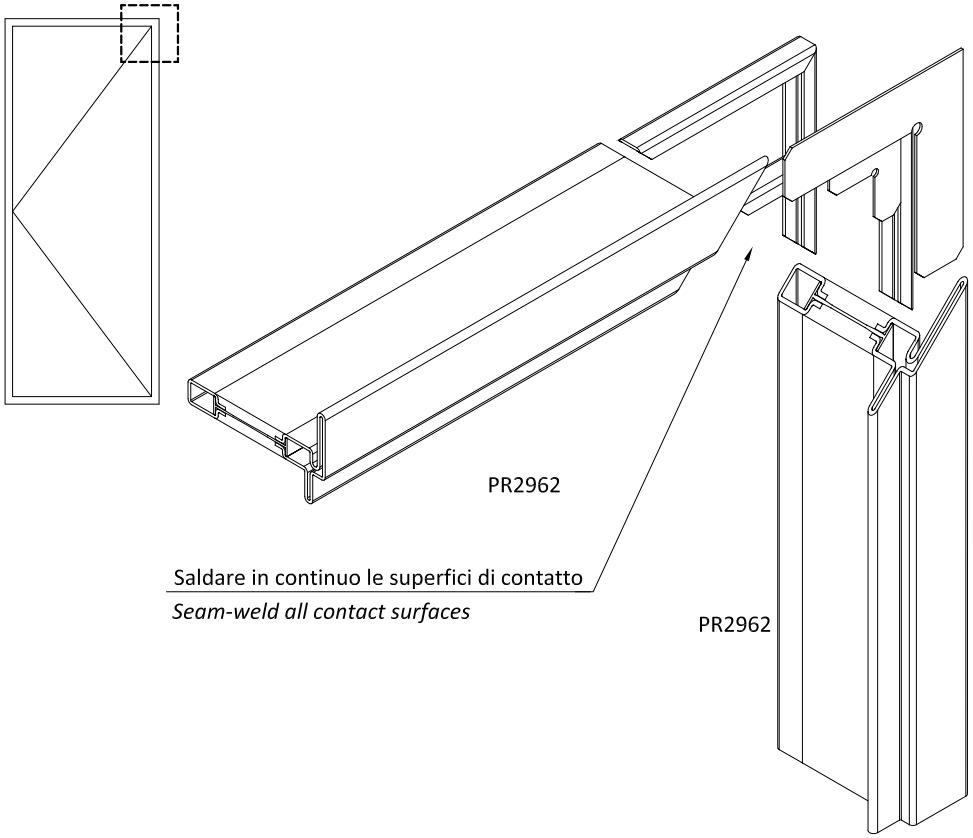
AC2803I
squadretta di assiemaggio
per profili in ottone

N.B.: dove c'è l'asta non inserire la squadretta

AC2803I
assembling corner brackets
for brass profiles

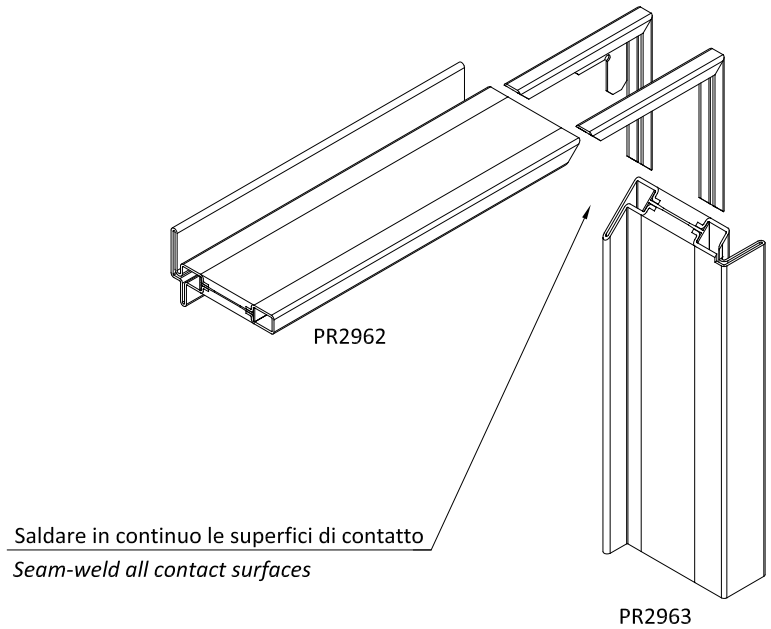
NOTE: Where there is the rod, don't insert corner brackets

Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection



AC2862I squadretta di assiemaggio per profili in ottone

AC2862I assembling corner brackets for brass profiles



AC2832I
squadretta di assiemaggio per profili in ottone

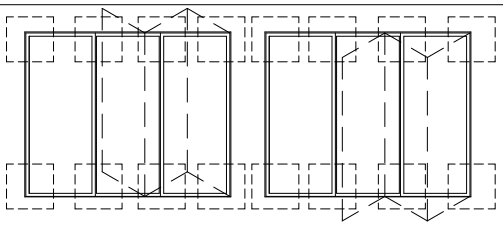
N.B.: dove c'è l'asta non inserire la squadretta

AC2832I
assembling corner brackets for brass profiles

NOTE: Where there is the rod, don't insert corner brackets

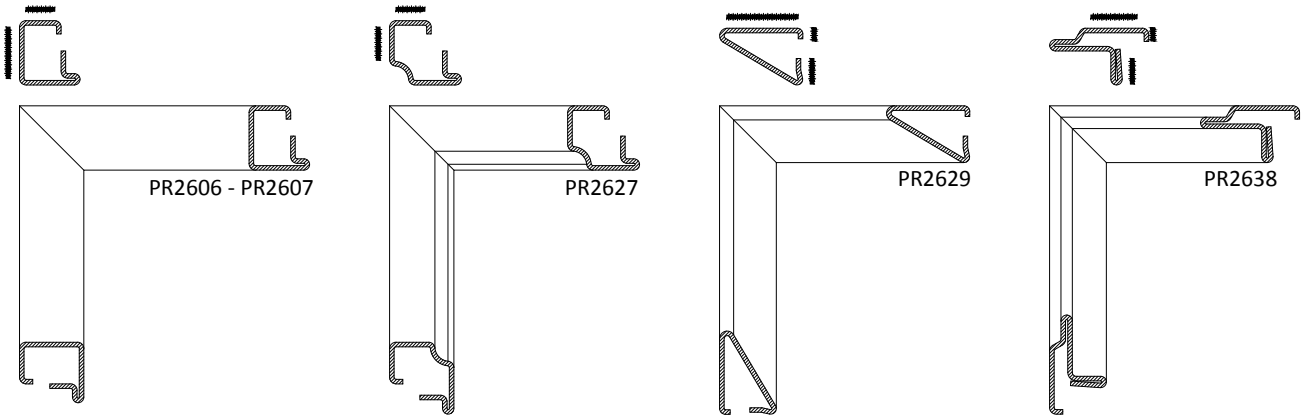
Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection

Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.



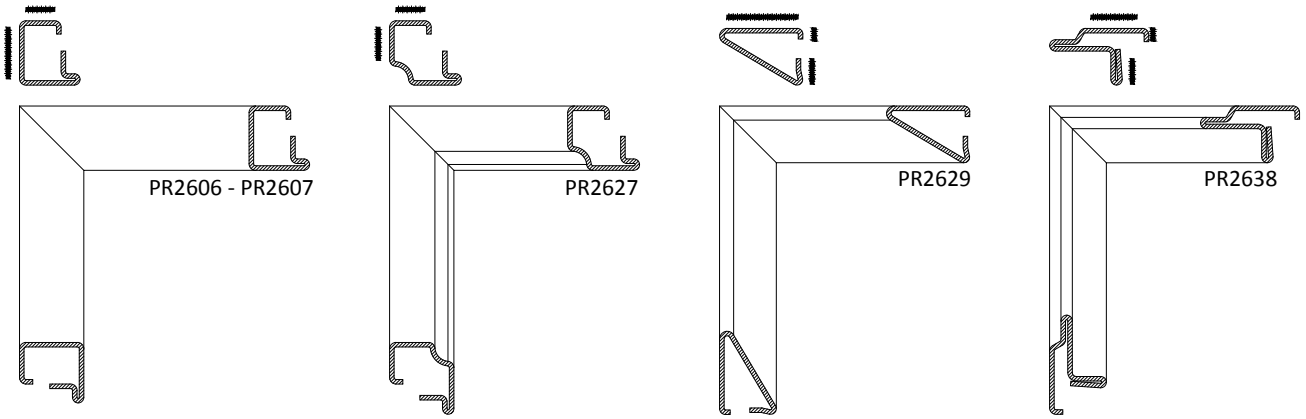
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

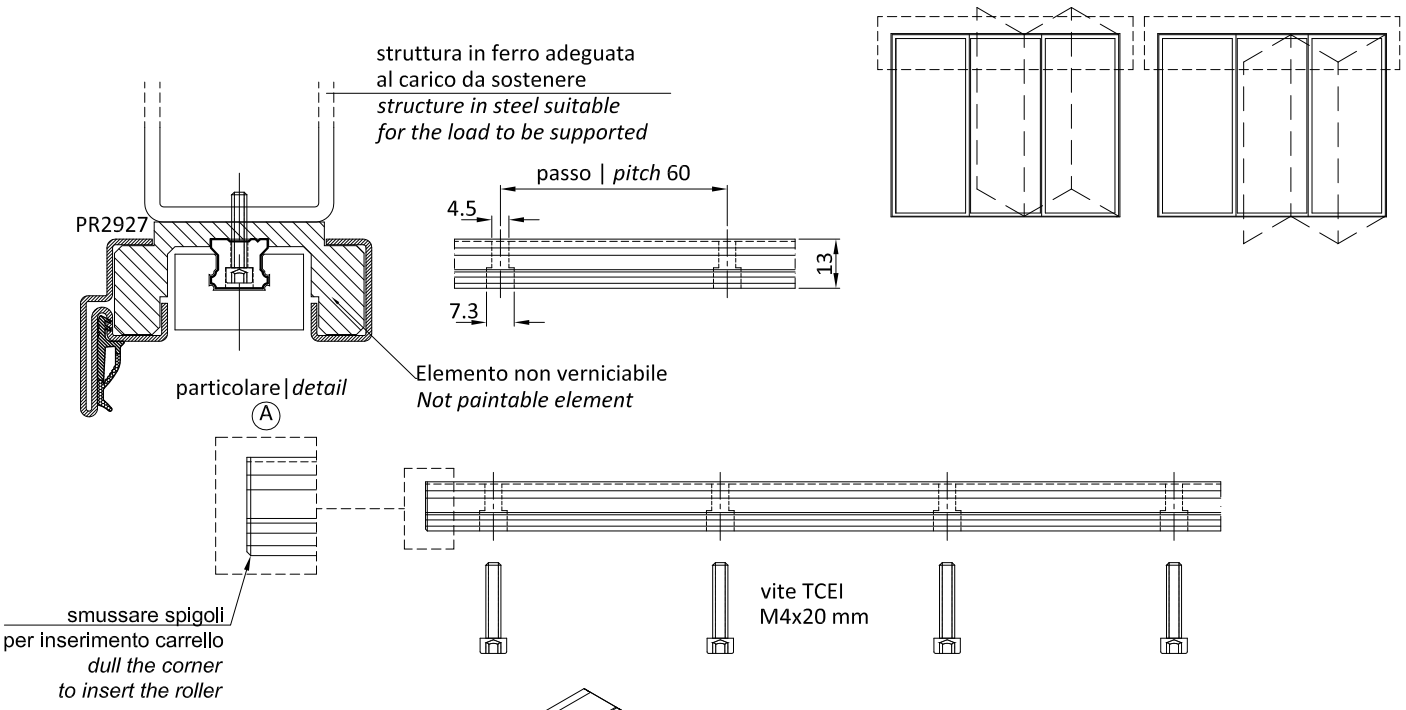
Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld the shown areas

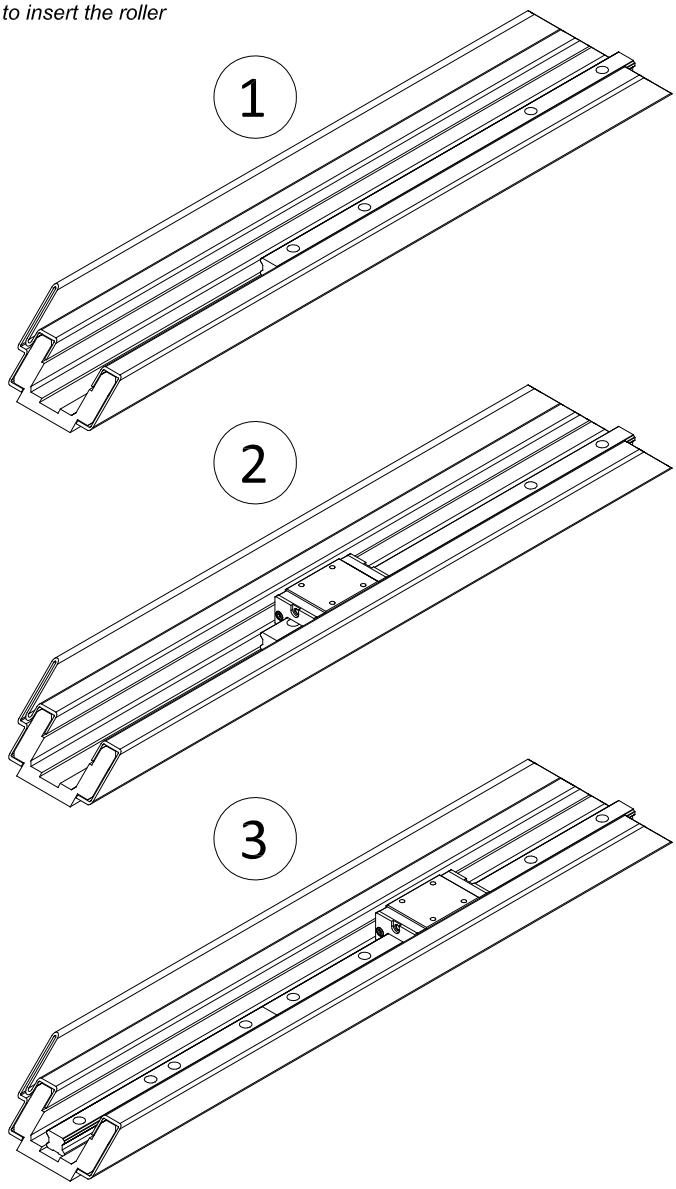


Ottone
Saldare a TIG a punti le zone indicate.

Brass
Spot weld (TIG) the marked areas.







1. Applicare la prima parte della guida al telaio
2. Inserire singolarmente tutti i carrelli nella guida superiore
3. Attenzione: rimuovere la linguetta di contenimento delle sfere progressivamente all'inserimento de carrello nella guida
4. Applicare la parte asportabile della guida superiore
5. Installare le staffe ai carrelli
6. Collegare le cerniere dell'anta e solo successivamente fissare l'anta alla staffa dei carrelli

1. *Apply the first part of the top raile to the frame*
2. *Insert all upper roller individually into the top rail*
3. *Attention: remove the ball retaining tab as the carriage is inserted into the guide*
4. *Attach the removable part of the top rail*
5. *Install the brackets on the trolleys*
6. *Connect the sash hinges and only then attach the sash to the trolley brackets*

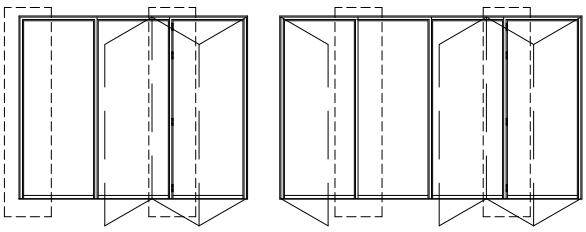
LUBRIFICAZIONE

- La lubrificazione e pulizia della guida superiore avviene attraverso il passaggio dei carrelli AC2827.
- Per ambienti particolarmente aggressivi, mantenere monitorato lo stato di lubrificazione/pulizia della guida e trattare superficialmente con olio lubrificante idrorepellente (tipo “WD-40”) secondo necessità per impedire l'insorgere di fenomeni ossidativi.
- Al fine di mantenere invariata l'integrità estetica della guida in corrispondenza dei tratti non interessati al passaggio dei carrelli, prevedere lubrificazione aggiuntiva con olio lubrificante idrorepellente (tipo “WD-40”).

LUBRICATION

- *The lubrication and cleaning of the upper guide takes place through the passage of the carriages AC2827.*
- *For particularly aggressive environments, keep the lubrication/cleaning status of the guide monitored and treat the surface with water-repellent lubricating oil (type "WD-40") as needed to prevent oxidative phenomena.*
- *In order to maintain unchanged the aesthetic integrity of the guide at the sections not affected by the passage of the rollers, provide additional lubrication with water-repellent lubricating oil (type "WD-40").*

viti non comprese - *screws not supplied*



1) Avvitare le aste di chiusura agli accessori di collegamento.

2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.

3) Inserire e fissare il GRATZ all'anta.

4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.

5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.

6) Fissare gli incontri al telaio.

1) Screw the closing rods to the connection fittings.

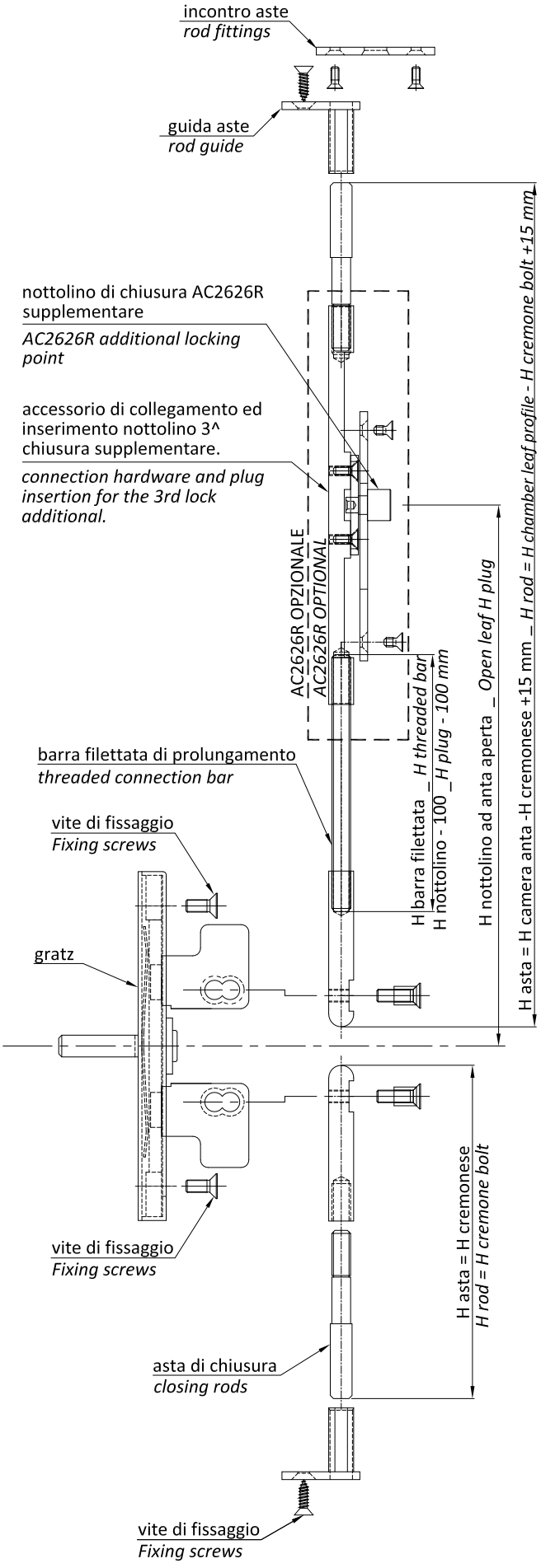
2) Insert the rods into the slits on the leaf corners.

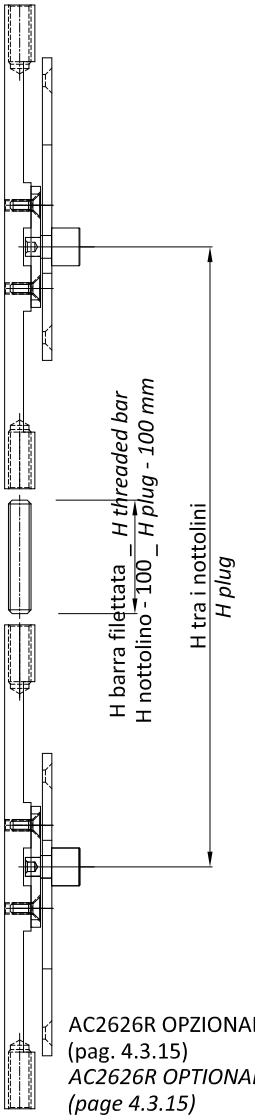
3) Insert the "GRATZ" mechanism into the leaf and secure.

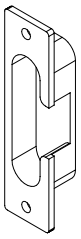
4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.

5) Insert the rod guides into the slits and fix them to the leaf.

6) Secure the fittings to the frame.



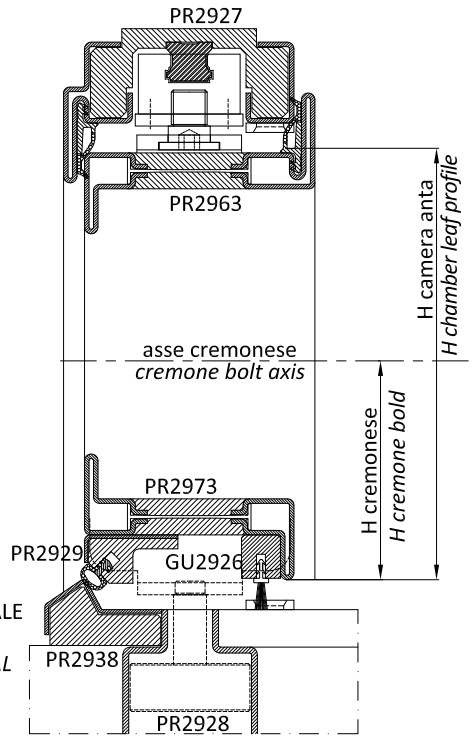


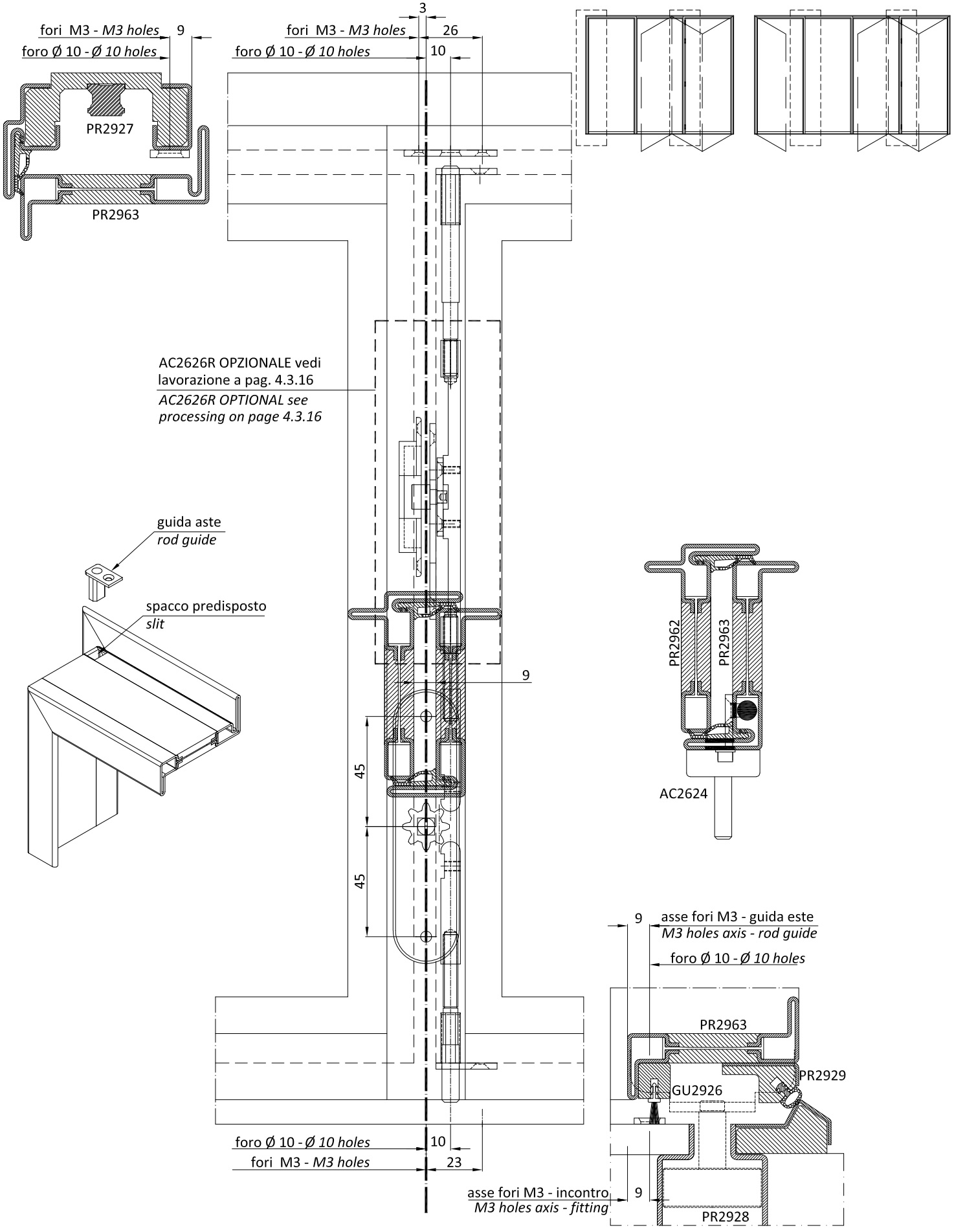


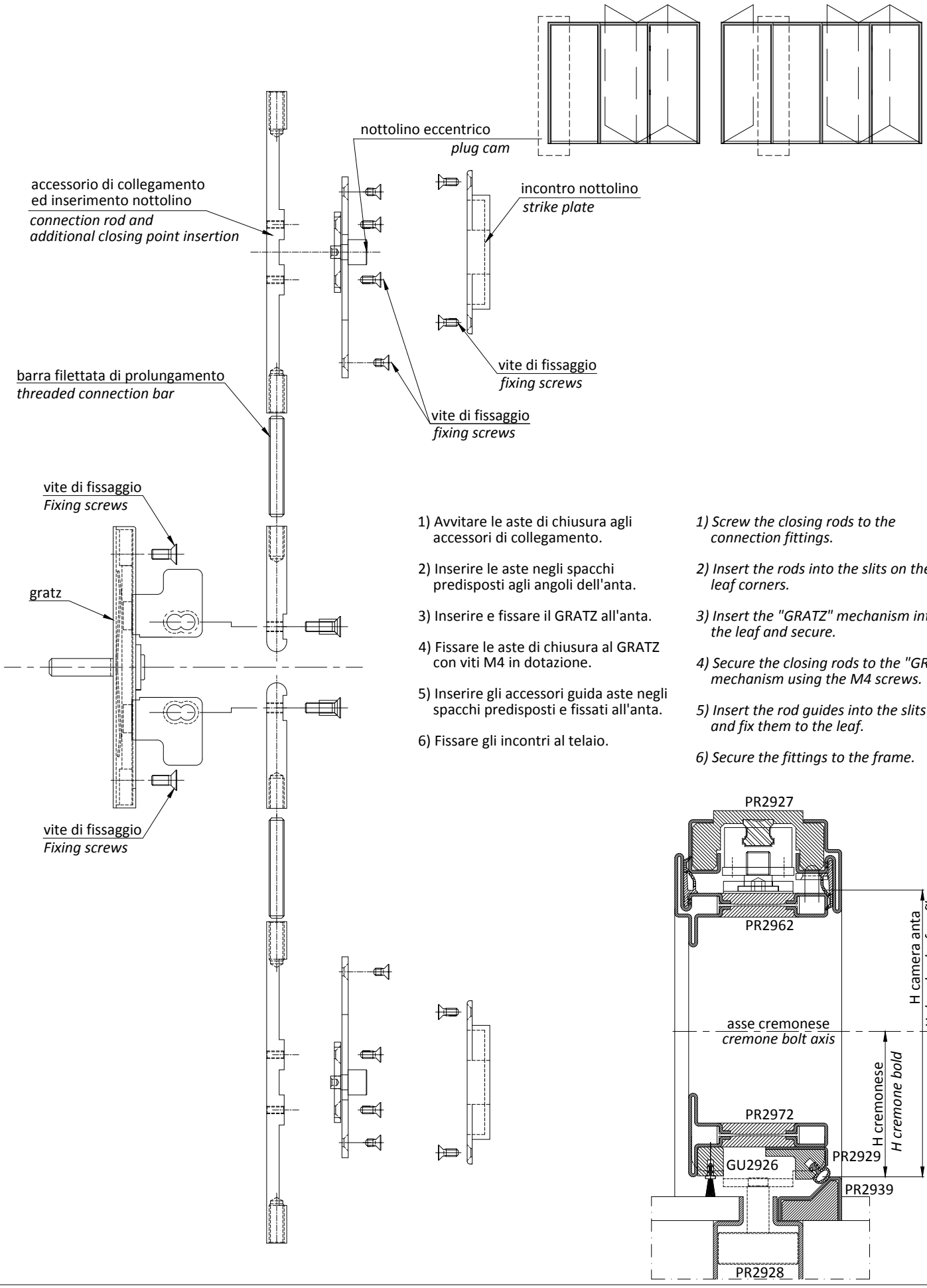
AC2626R incontro 3^ chiusura OPZIONALE
AC2626R 3rd lock strike plate OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.

Attn. Consider one locking point every 1000 mm max.




fori M3 - M3 holes
9
foro Ø 10 - Ø 10 holes
PR2927
PR2963
3
fori M3 - M3 holes
26
foro Ø 10 - Ø 10 holes
10
AC2626R OPZIONALE vedi lavorazione a pag. 4.3.16
AC2626R OPTIONAL see processing on page 4.3.16
guida aste
rod guide
spacco predisposto
slit
9
45
45
PR2962
PR2963
AC2624
9
asse fori M3 - guida este
M3 holes axis - rod guide
foro Ø 10 - Ø 10 holes
PR2963
PR2929
GU2926
foro Ø 10 - Ø 10 holes
10
fori M3 - M3 holes
23
asse fori M3 - incontro
M3 holes axis - fitting
9
PR2928



1) Avvitare le aste di chiusura agli accessori di collegamento.

2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.

3) Inserire e fissare il GRATZ all'anta.

4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.

5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.

6) Fissare gli incontri al telaio.

1) Screw the closing rods to the connection fittings.

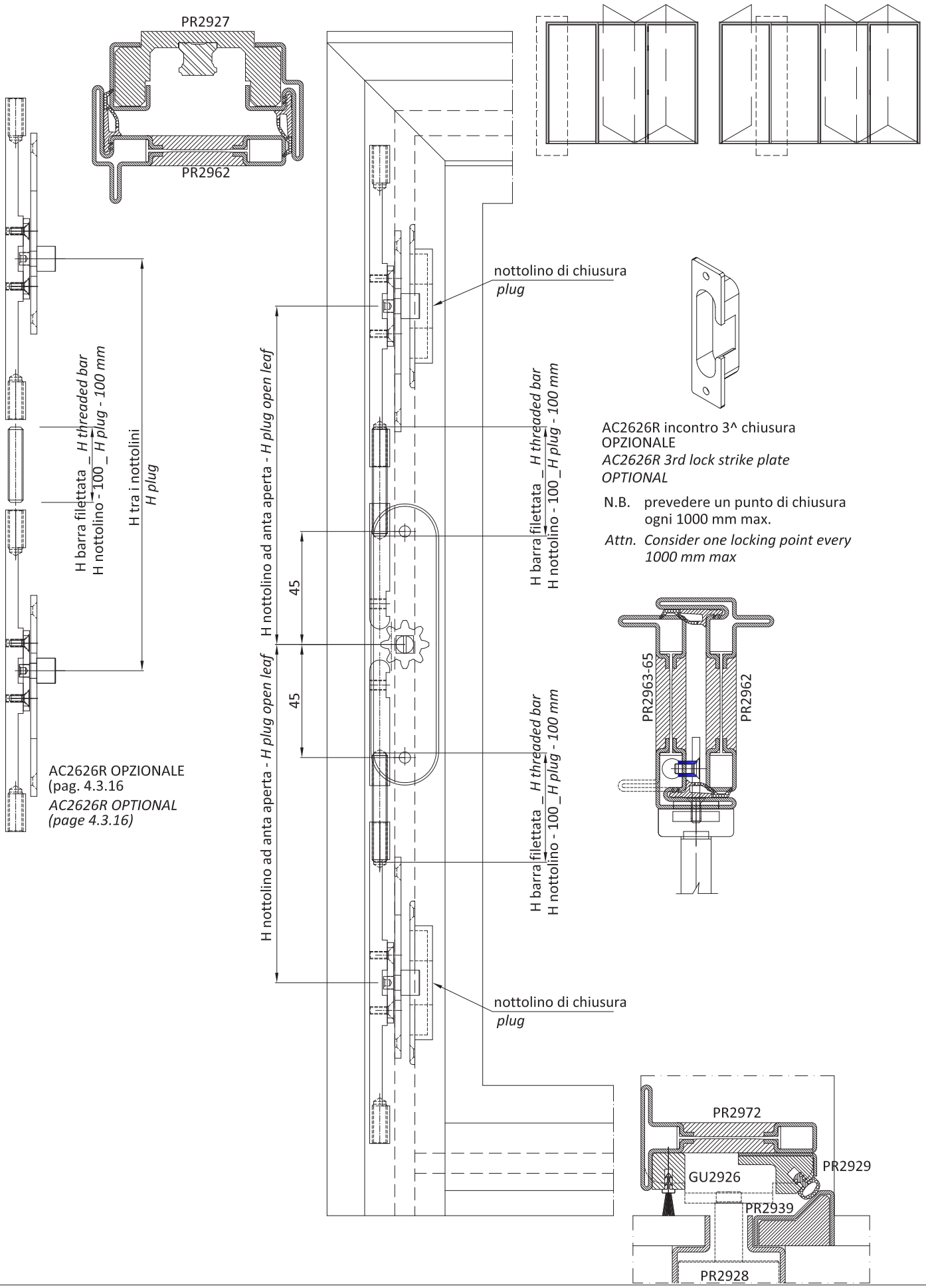
2) Insert the rods into the slits on the leaf corners.

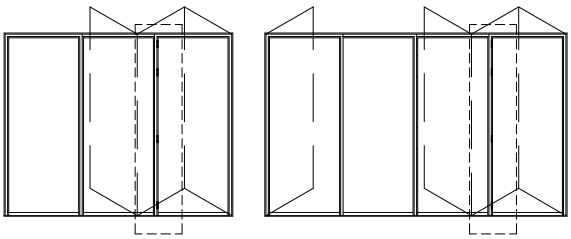
3) Insert the "GRATZ" mechanism into the leaf and secure.

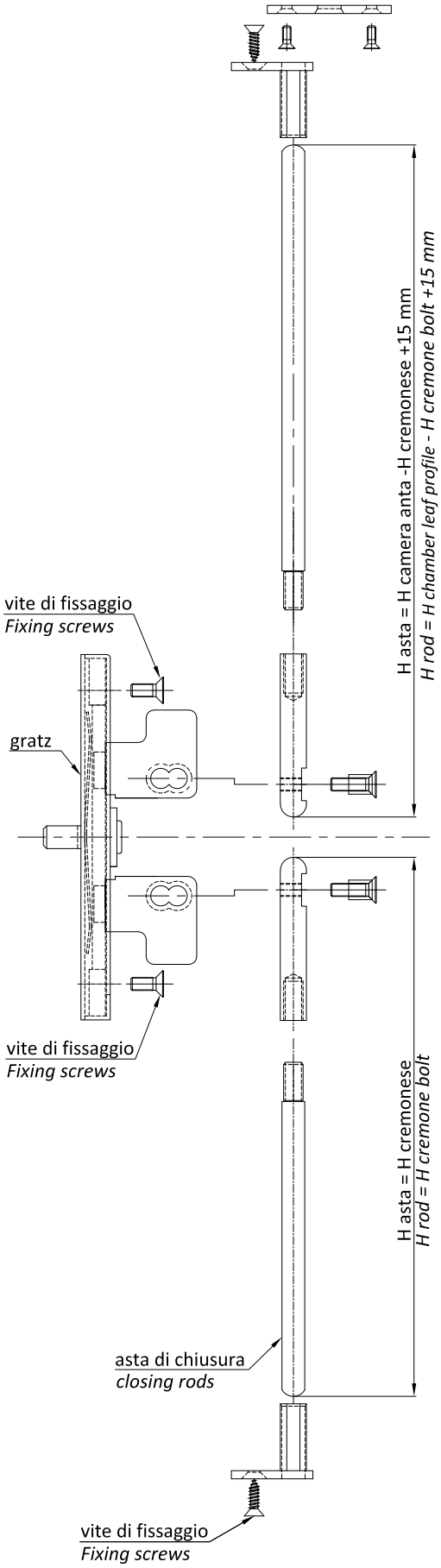
4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.

5) Insert the rod guides into the slits and fix them to the leaf.

6) Secure the fittings to the frame.


PR2927
PR2962
H barra filettata _ H threaded bar
H nottolino - 100 _ H plug - 100 mm
H tra i nottolini
H plug
AC2626R OPZIONALE
(pag. 4.3.16
AC2626R OPTIONAL
(page 4.3.16)
nottolino di chiusura
plug
H nottolino ad anta aperta - H plug open leaf
45
45
H nottolino ad anta aperta - H plug open leaf
H barra filettata _ H threaded bar
H nottolino - 100 _ H plug - 100 mm
H barra filettata _ H threaded bar
H nottolino - 100 _ H plug - 100 mm
nottolino di chiusura
plug
AC2626R incontro 3^ chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL
N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max
PR2963-65
PR2962
PR2972
PR2929
GU2926
PR2939
PR2928





1) Avvitare le aste di chiusura agli accessori di collegamento

2) Inserire le aste negli spacchi predisposti agli angoli dell'anta

3) Inserire e fissare il GRATZ all'anta

4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione

5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

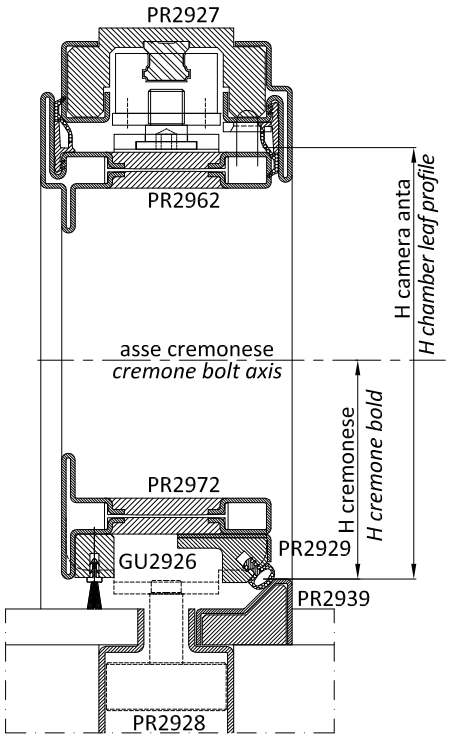
2) Insert the rods into the slits on the leaf corners

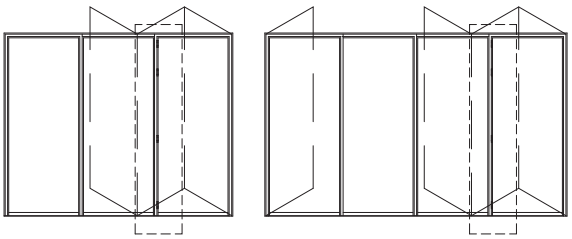
3) Insert the "GRATZ" mechanism into the leaf and secure

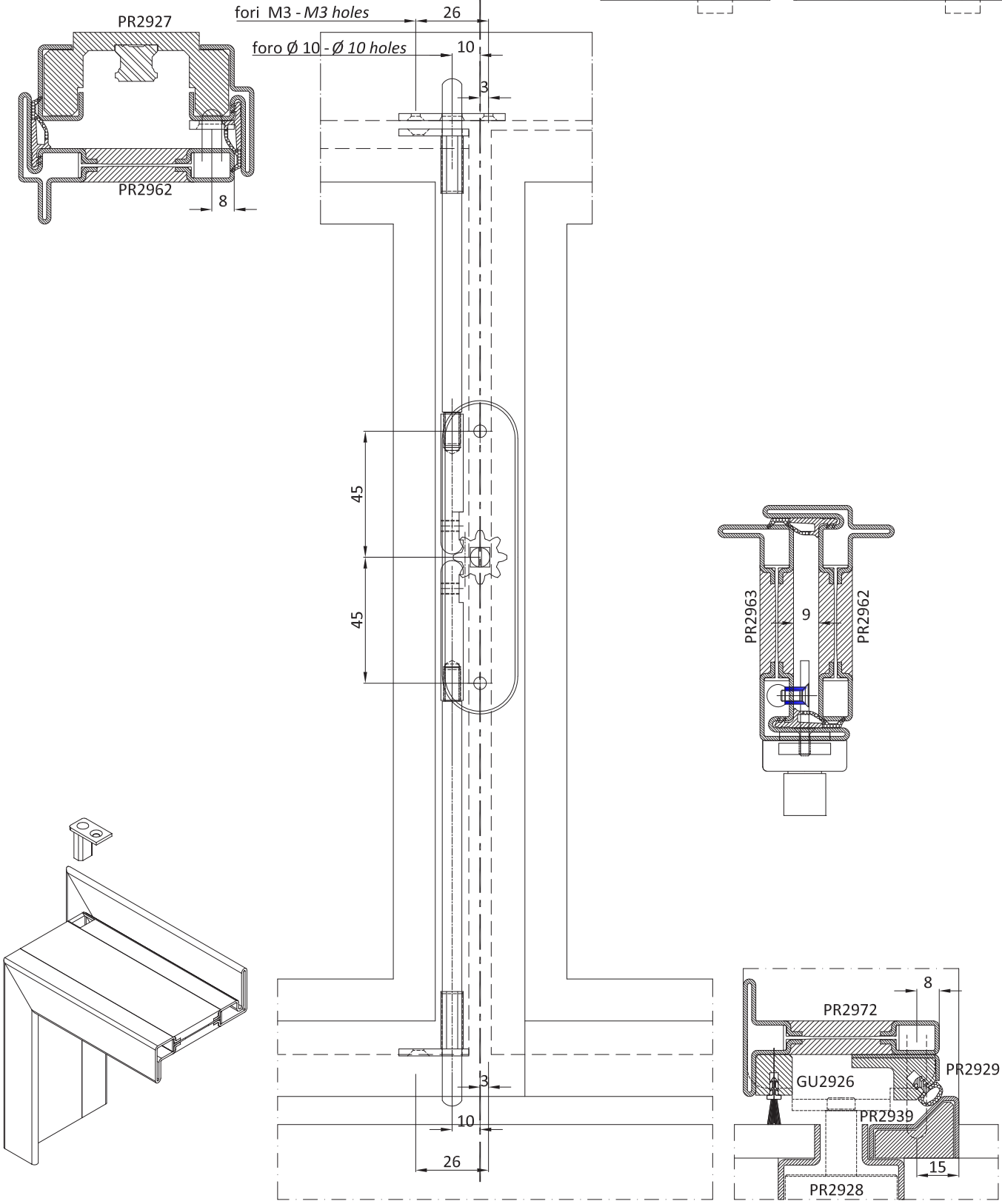
4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws

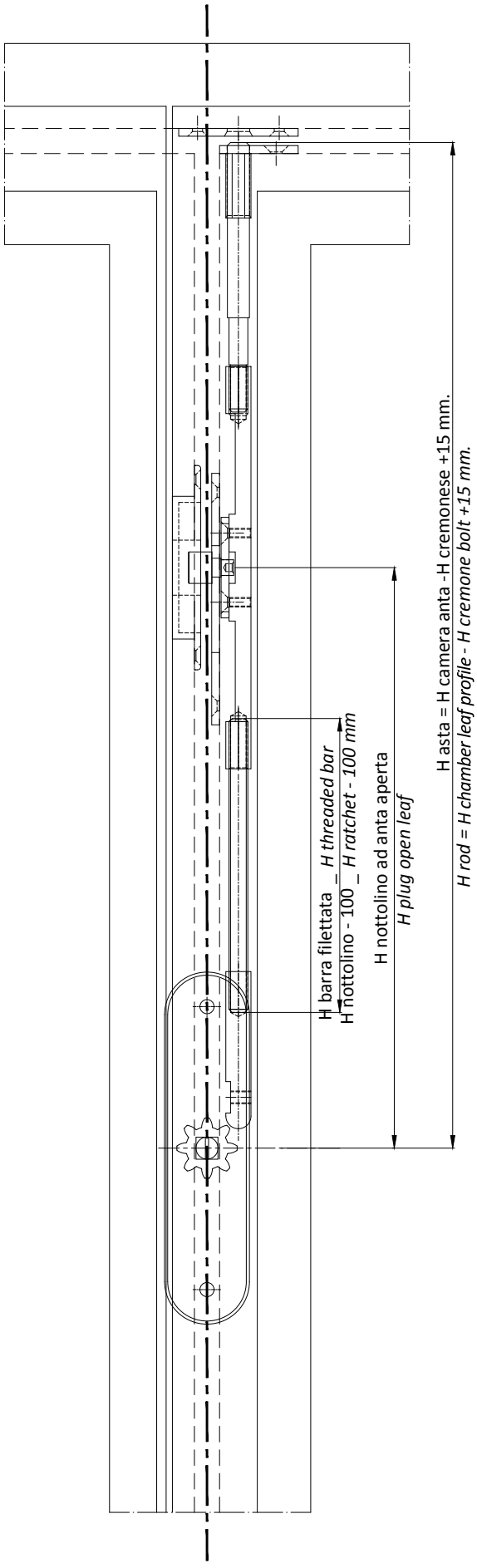
5) Insert the rod guides into the slits and fix them to the leaf

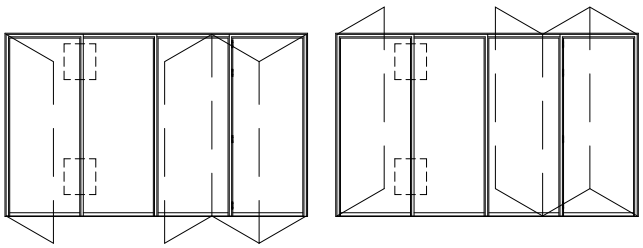
6) Secure the fittings to the frame





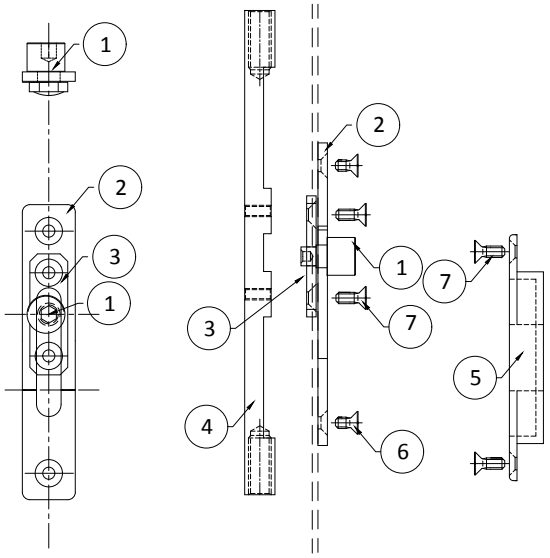

PR2927
PR2962
8
fori M3 - *M3 holes*
26
foro Ø 10 - *Ø 10 holes*
10
3
45
45
PR2963
9
PR2962
3
10
26
8
PR2972
PR2929
GU2926
PR2939
15
PR2928

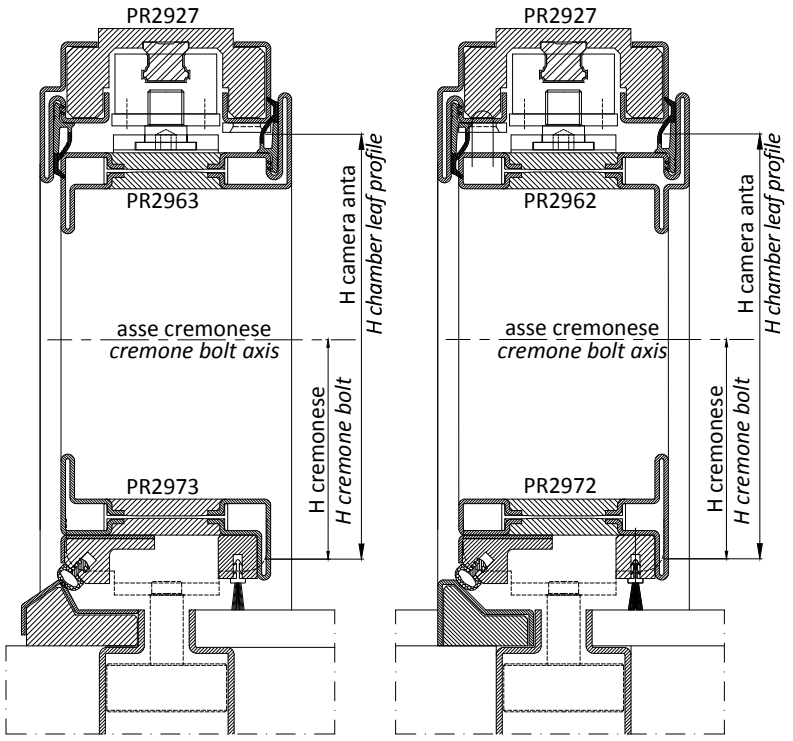


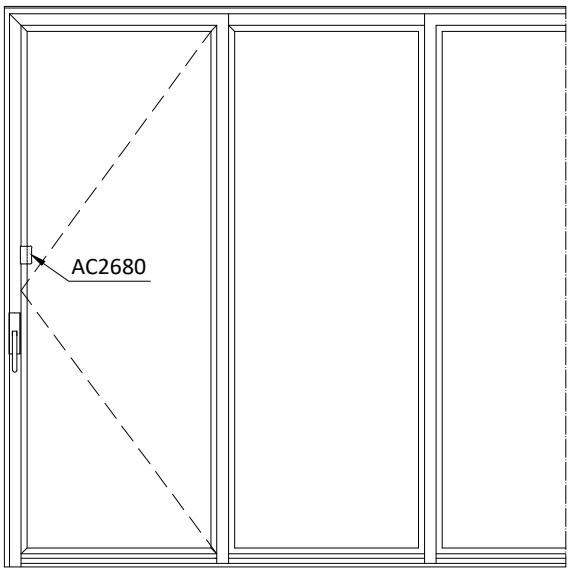


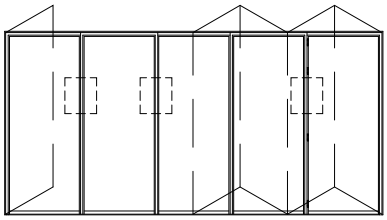
1) Rullino eccentrico
2) Piastra di fissaggio
3) Piastra di collegamento
4) Accessorio aggancio aste
5) Incontro 3^ chiusura
6) viti M3x6 mm
7) viti M3x8 mm

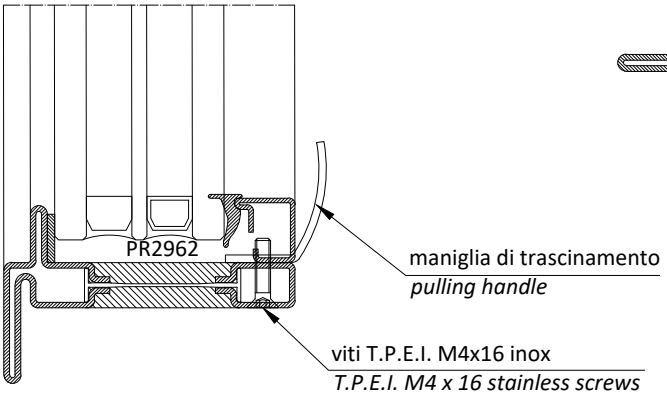
1) Barrel cam
2) Installation plate
3) Connecting plate
4) Rod docking accessory
5) 3rd lock strike plate
6) screws M3x6 mm
7) screws M3x8 mm

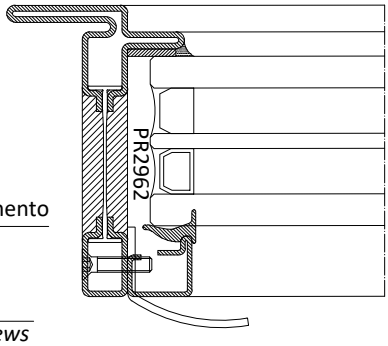


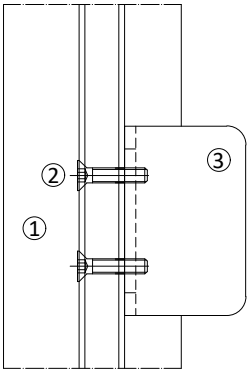




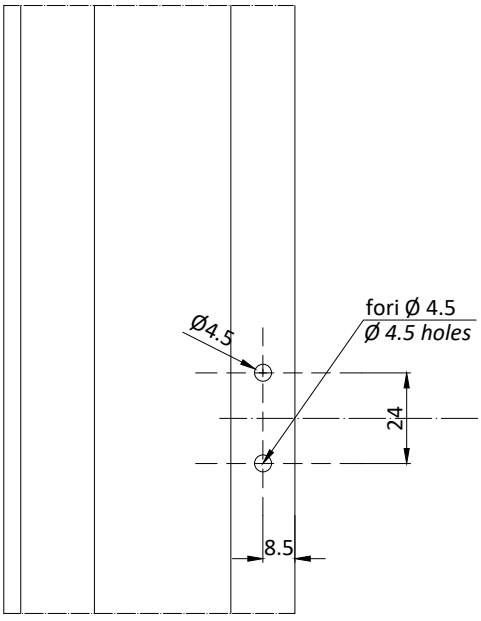




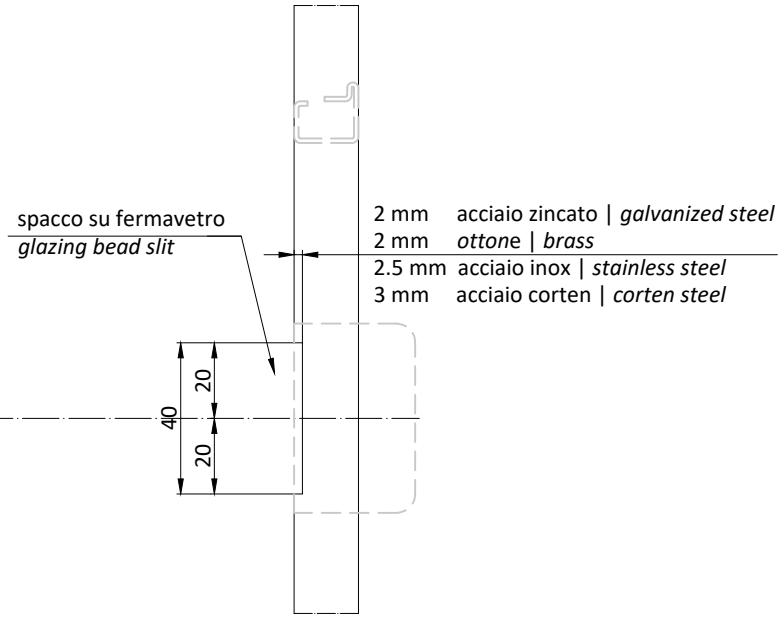




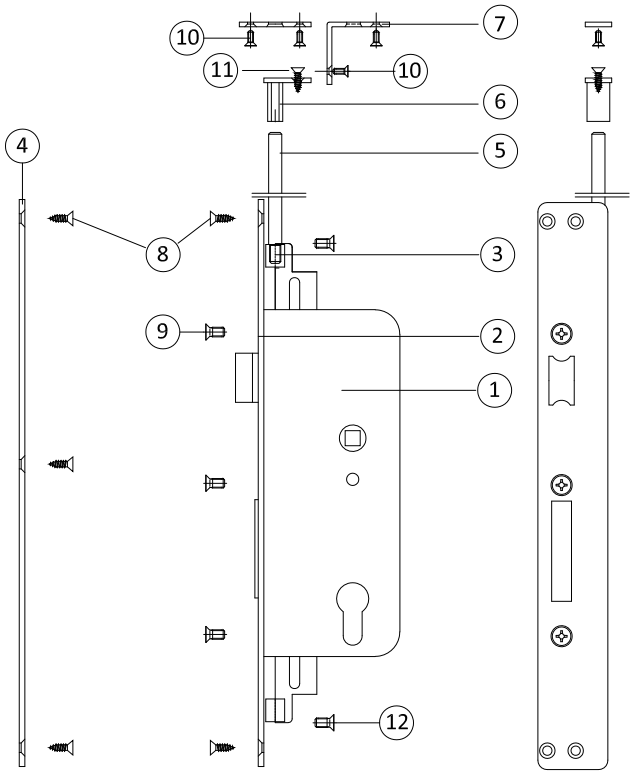
1 Maniglia di trascinamento| *pulling handle*
2 Viti TSPEI M4x16 | *TSPEI M4 x 16 stainless screws*
3 T Profilo anta | *T leaf profile*

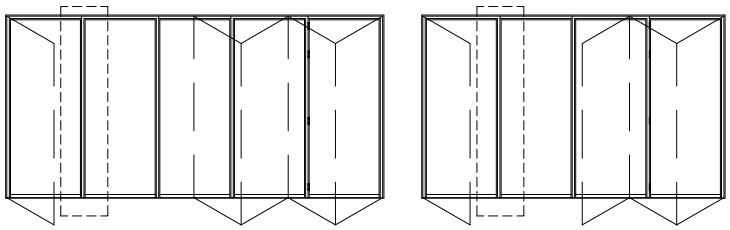


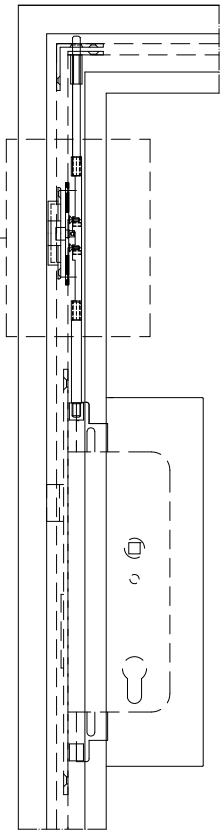
lavorazione su profilo
profile processing



lavorazione su fermavetro
profile processing







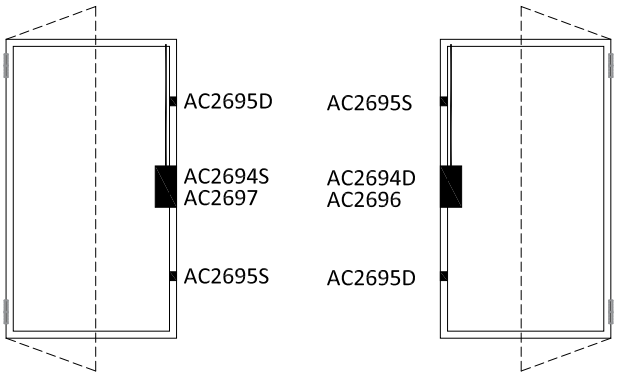
AC2695 OPZIONALE
vedi lavorazione a pag. 4.3.30

AC2695 OPTIONAL
see processing on page 4.3.30

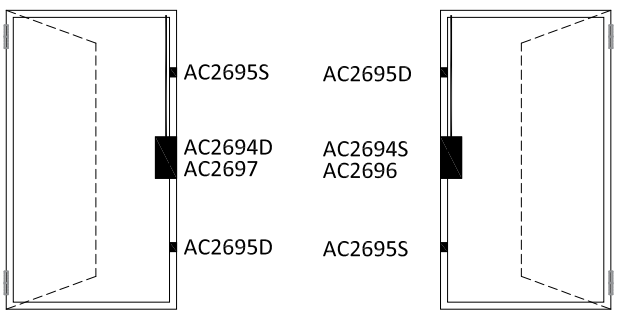
1) Serratura
2) Frontalino (Dx o Sx)
3) Riduttore di collegamento
4) Incontro per serratura
5) Aste inox
6) Guida aste superiore
7) Incontro aste per porte a due ante
7 bis) Incontro aste per porte ad un anta
8) Viti autof. Inox A2 T.P.T.C. 3,9x13
9) Viti Inox T.P.T.C. m5x10
10) Viti Inox T.P.E.I. 3x8
11) Viti autof. Inox T.P.T.C. 3,5x13
12) Viti Inox T.S.P.E.I. M4x8

1) Lock
2) Faceplate right/left
3) Connecting adaptor
4) Strike plate for lock
5) Stainless rods
6) Upper rods guide
7) Rod fittings for two-leaf doors
7 bis) Rod fittings for one-leaf doors
8) A2 T.P.T.C. 3.9x13 self-drilling stainless screws
9) T.P.T.C. m5x10 stainless screws
10) T.P.E.I. 3x8 stainless screws
11) T.P.T.C. 3.9 x 13 self-drilling stainless screws
12) T.S.P.E.I. M4 x 8 stainless screws

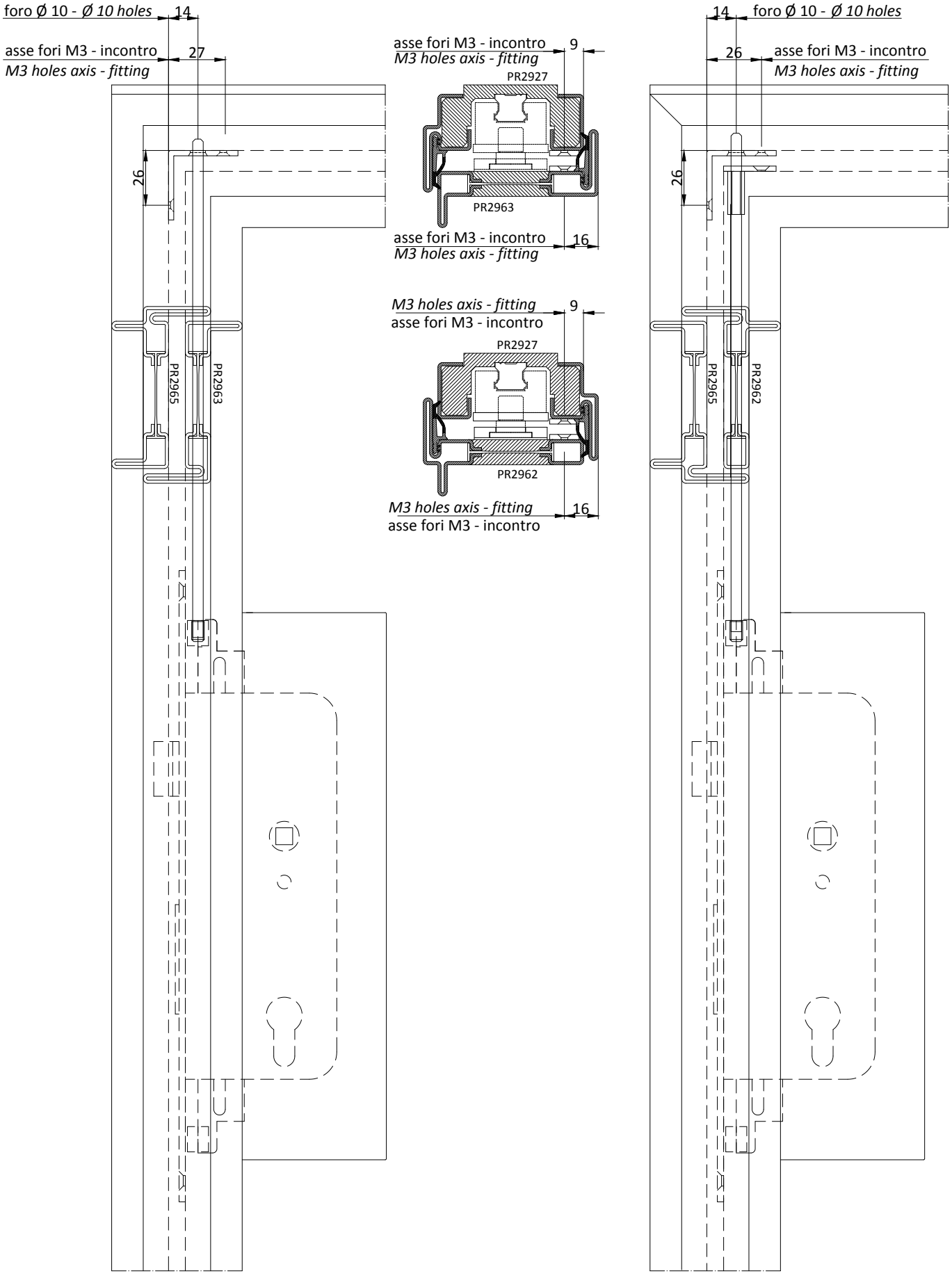
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

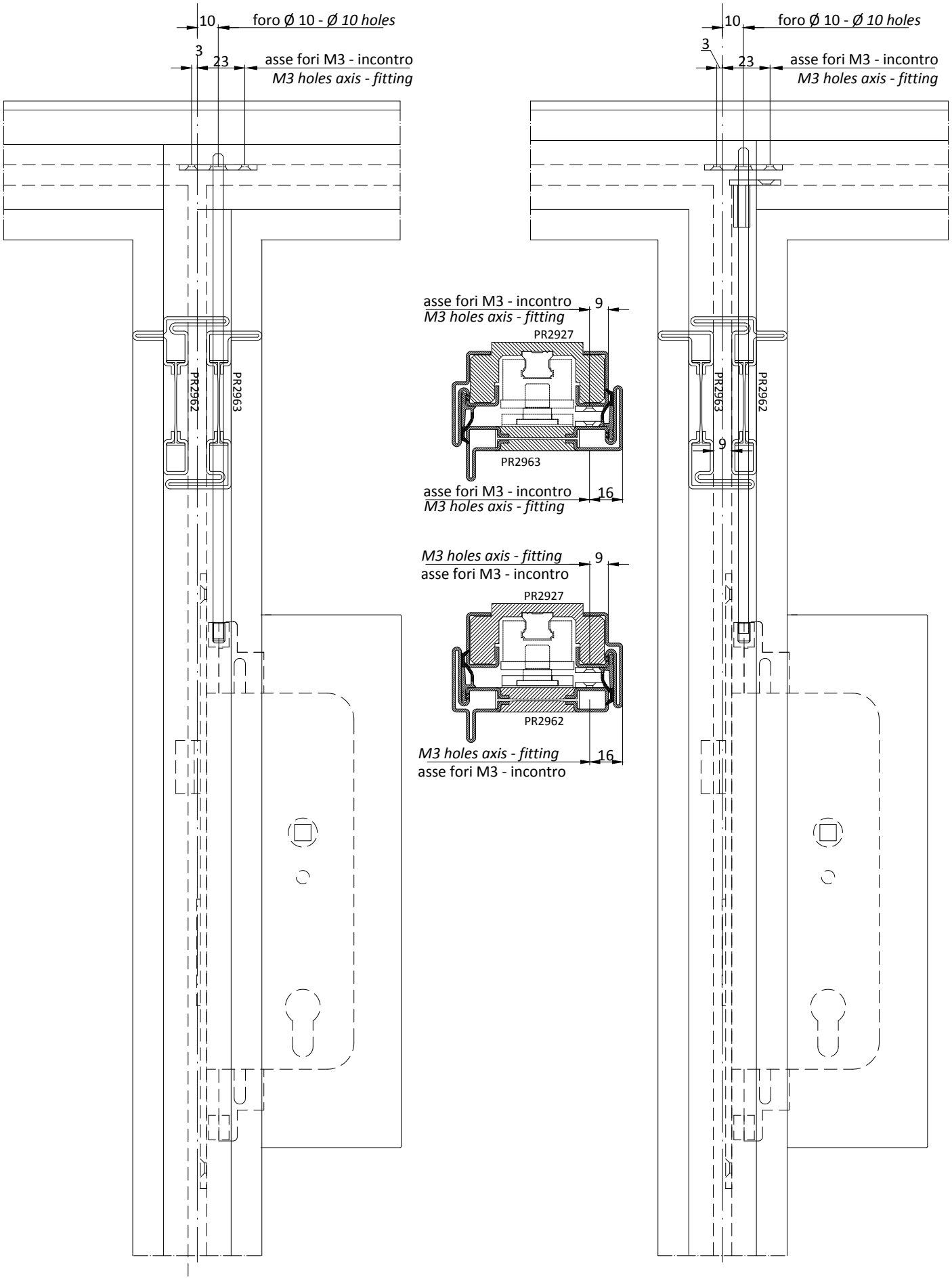


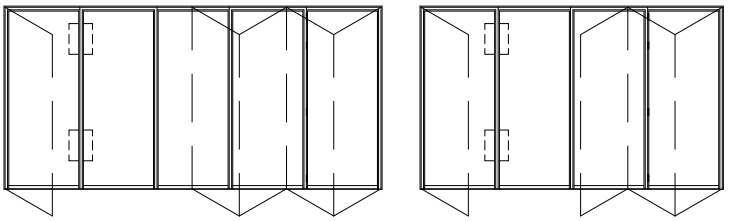
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

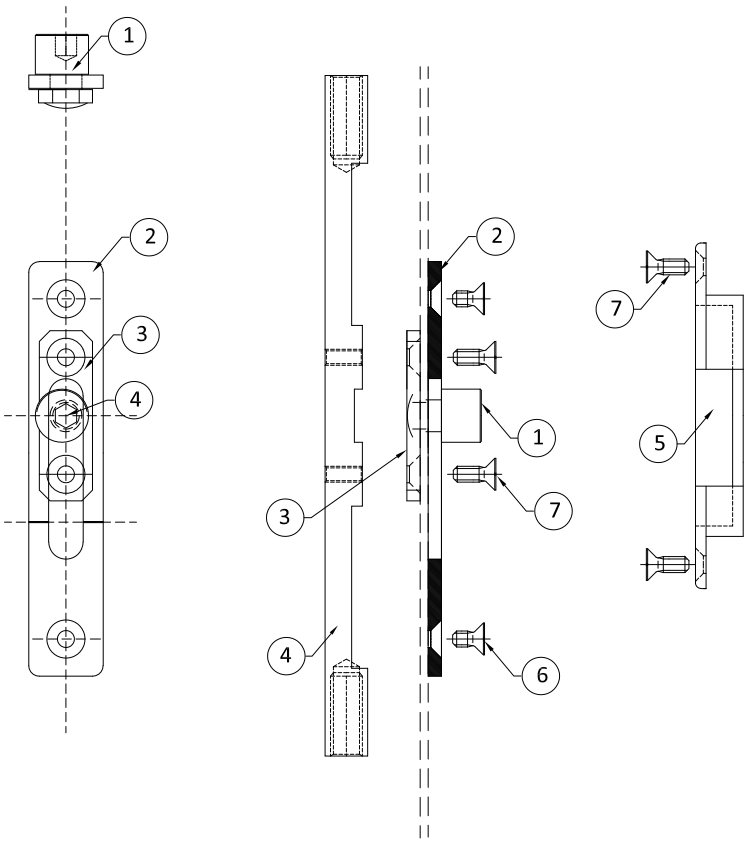

foro Ø 10 - *Ø 10 holes*
14
asse fori M3 - incontro
M3 holes axis - fitting
27
26
PR2965
PR2963
asse fori M3 - incontro
M3 holes axis - fitting
9
PR2927
PR2963
asse fori M3 - incontro
M3 holes axis - fitting
16
M3 holes axis - fitting
asse fori M3 - incontro
9
PR2927
PR2962
M3 holes axis - fitting
asse fori M3 - incontro
16
14
foro Ø 10 - *Ø 10 holes*
26
asse fori M3 - incontro
M3 holes axis - fitting
26
PR2965
PR2962


10
foro Ø 10 - *Ø 10 holes*
3
23
asse fori M3 - incontro
M3 holes axis - fitting
PR2962
PR2963
asse fori M3 - incontro
M3 holes axis - fitting
9
PR2927
PR2963
asse fori M3 - incontro
M3 holes axis - fitting
16
M3 holes axis - fitting
asse fori M3 - incontro
9
PR2927
PR2962
M3 holes axis - fitting
asse fori M3 - incontro
16
10
foro Ø 10 - *Ø 10 holes*
3
23
asse fori M3 - incontro
M3 holes axis - fitting
PR2963
PR2962
9

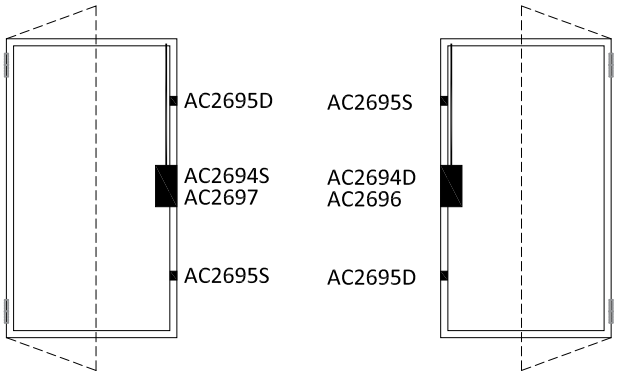


1) Rullino eccentrico
2) Piastra di fissaggio
3) Piastra di collegamento
4) Accessorio aggancio aste
5) Incontro 3^ chiusura
6) viti M3 x 6
7) viti M3 x 8

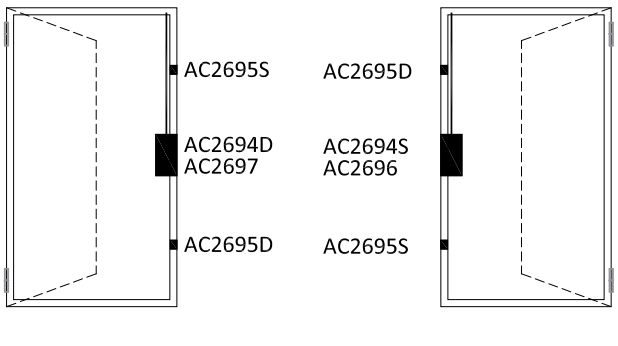
1) Barrel cam
2) Installation plate
3) Connecting plate
4) Rod docking accessory
5) 3rd lock strike plate
6) screws M3 x 6
7) screws M3 x 8



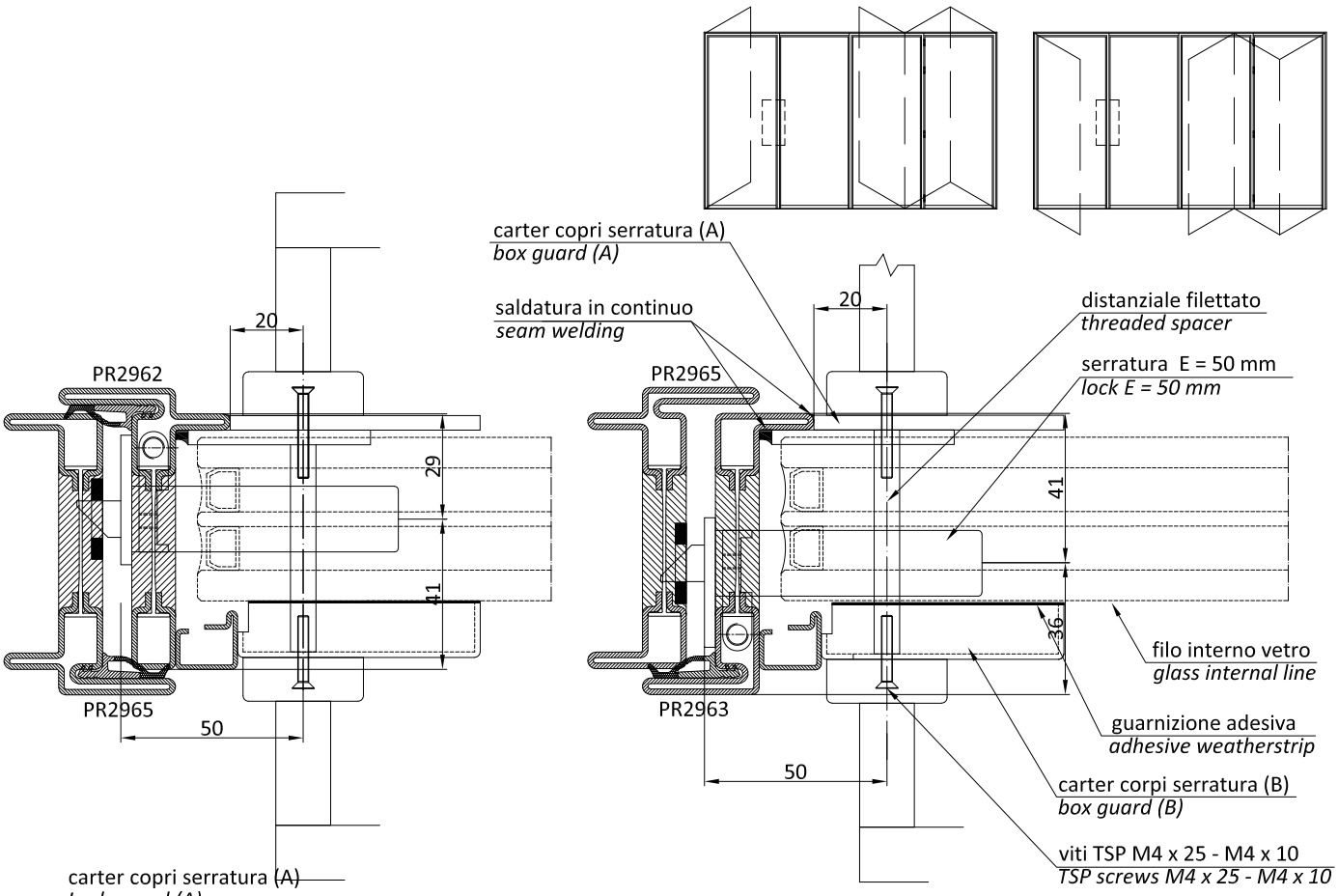
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

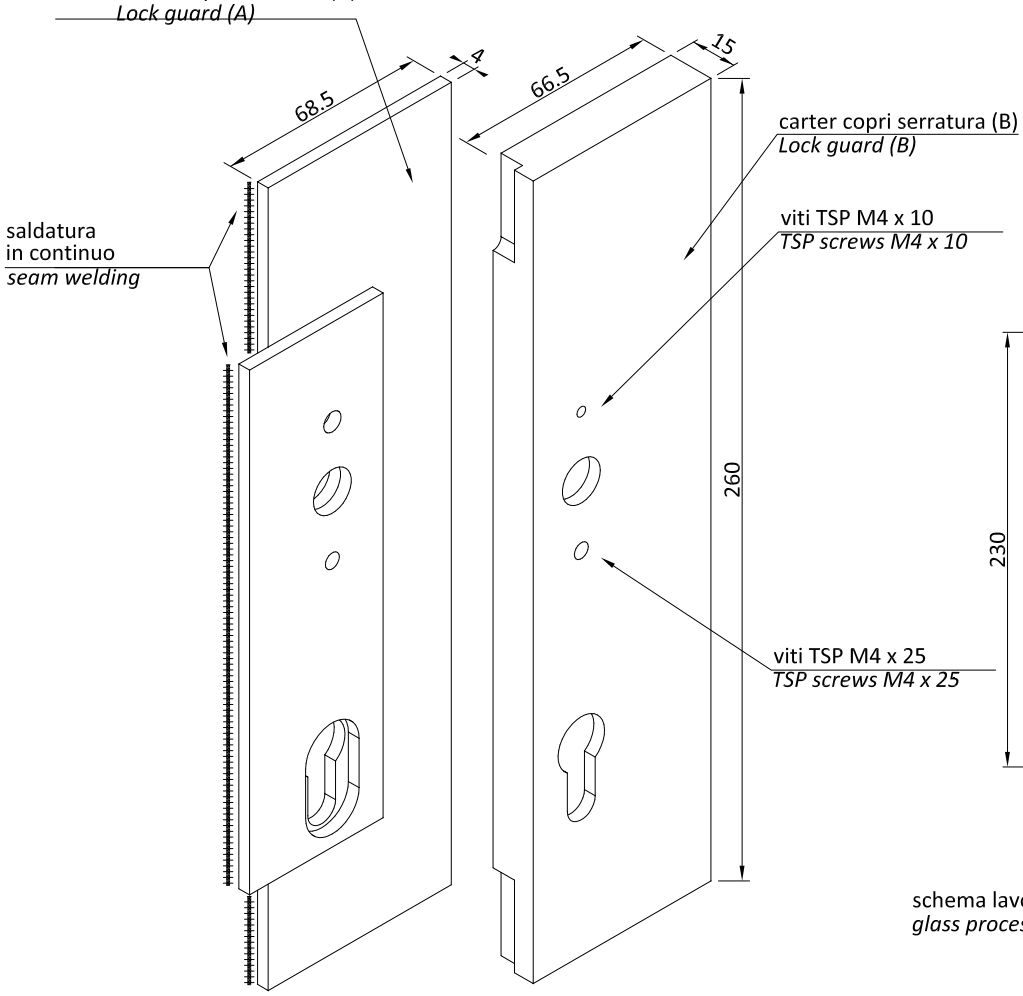


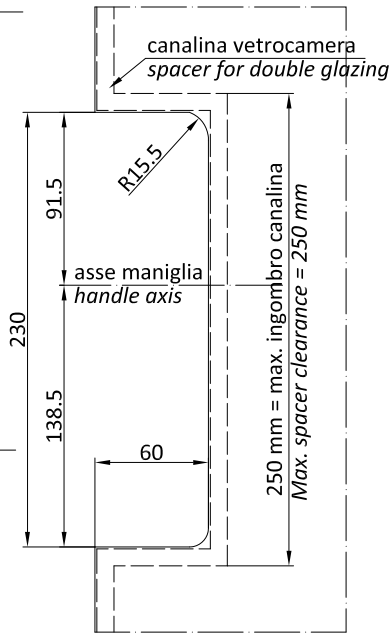
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



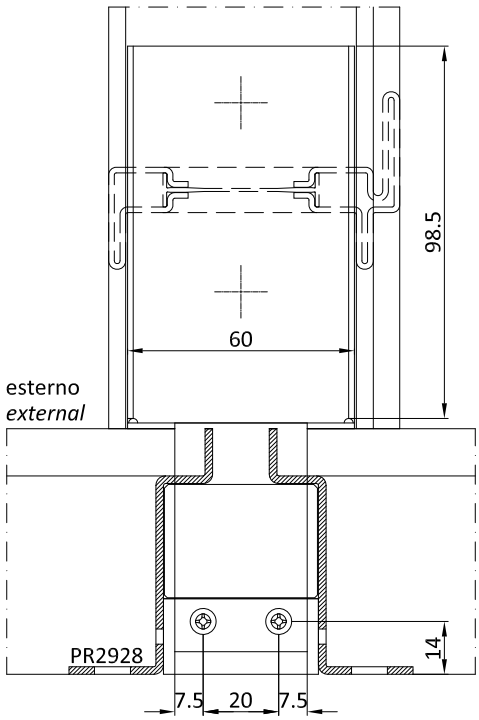
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

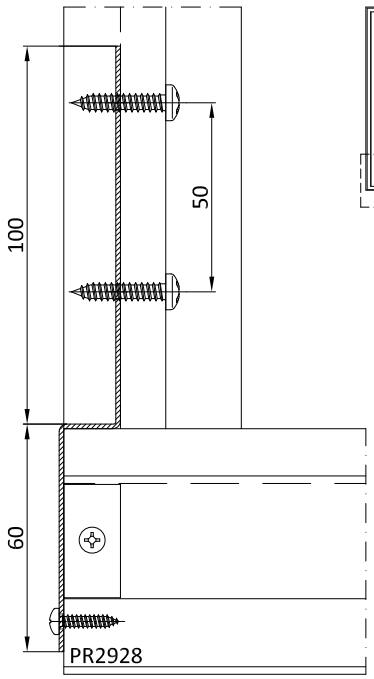


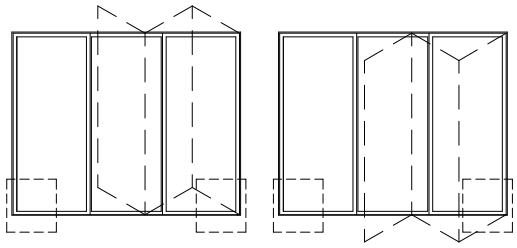




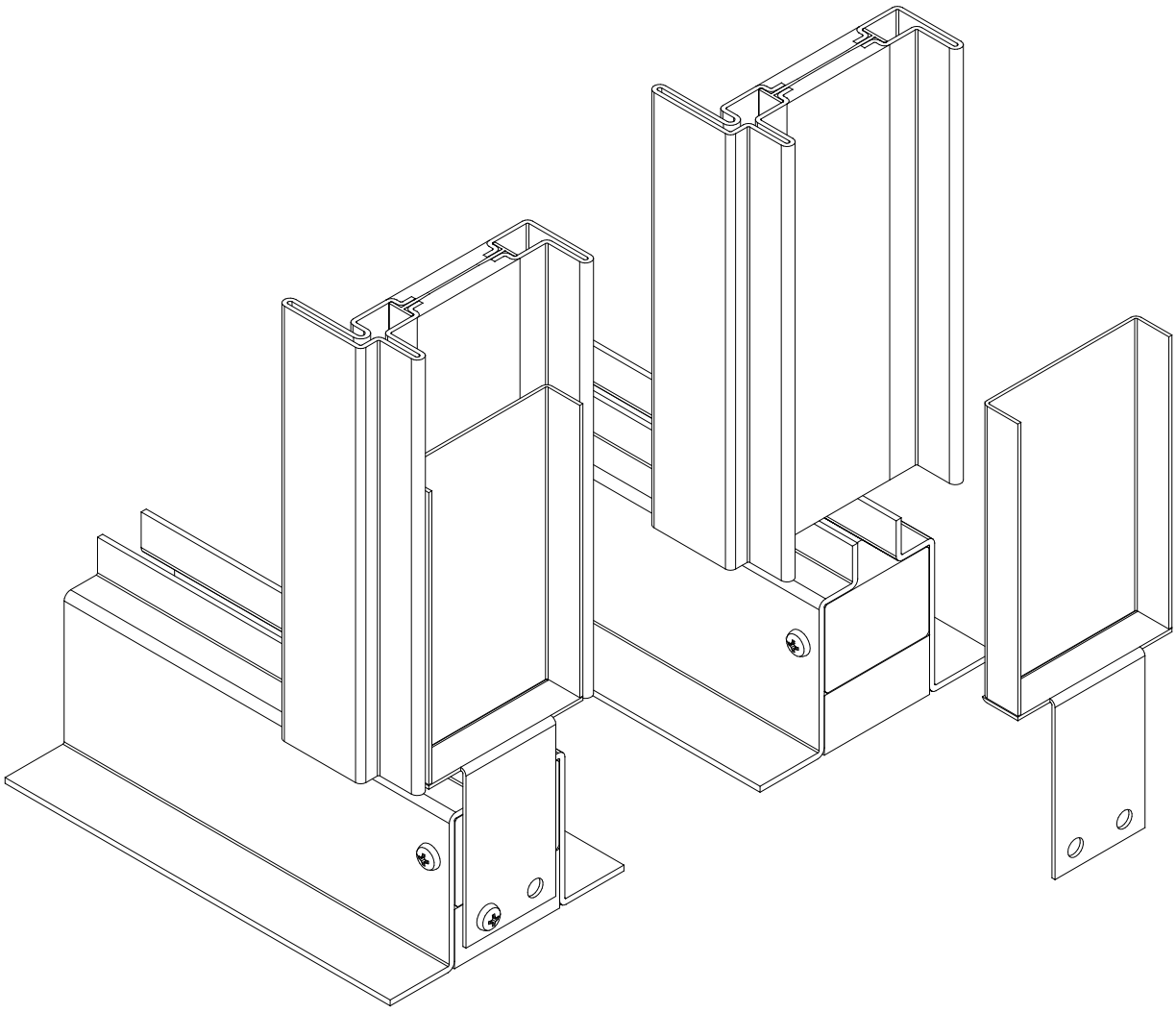
schema lavorazione vetro per inserimento serratura
glass processing scheme for lock insertion



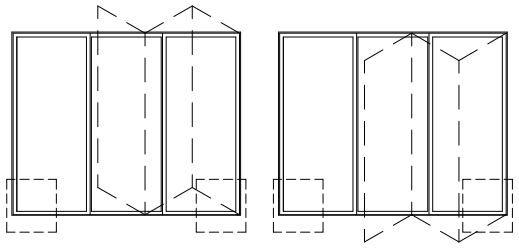




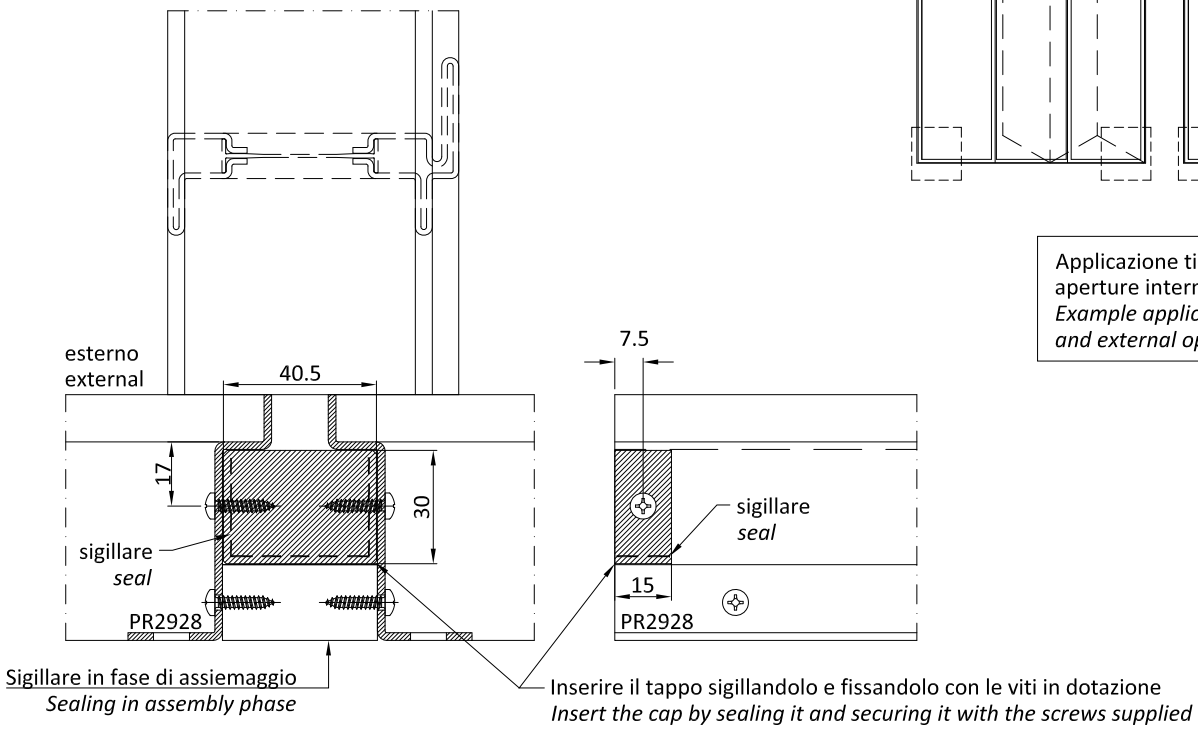
Applicazione tipo, valida per aperture interne e aperture esterne
Example application, for internal and external openings

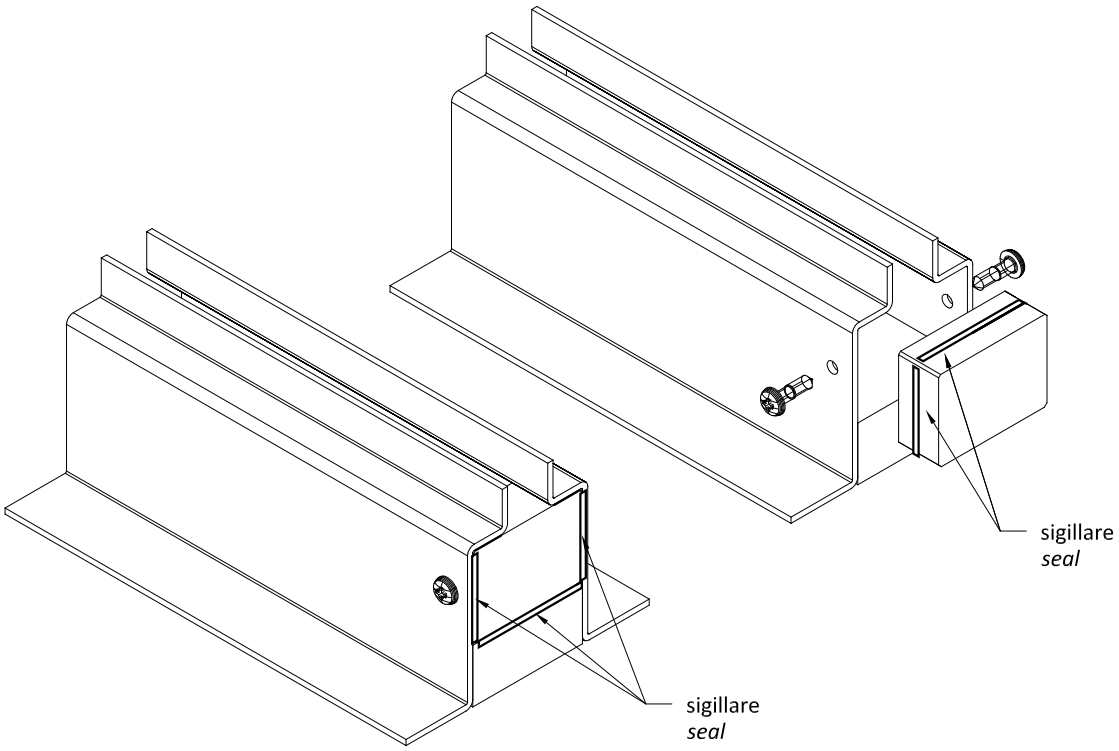


viti non comprese - *screws not supplied*

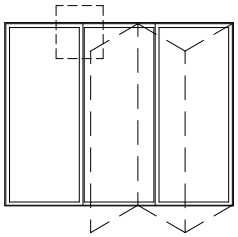


Applicazione tipo, valida per aperture interne e aperture esterne
Example application, for internal and external openings

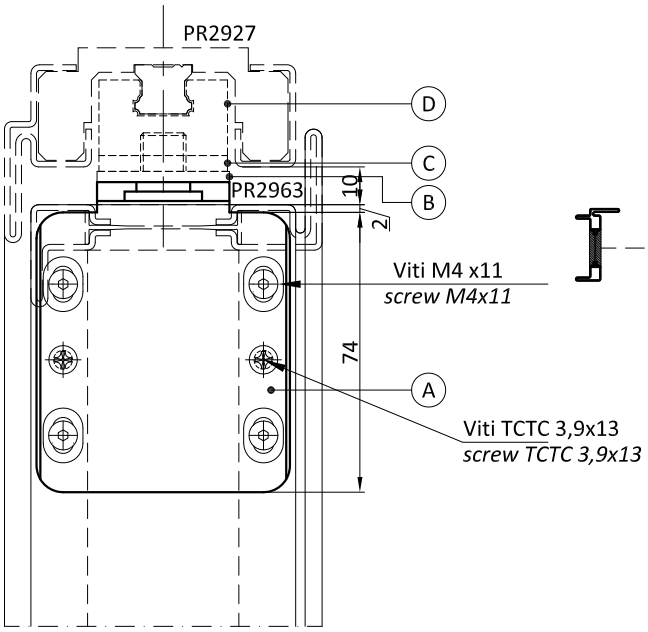


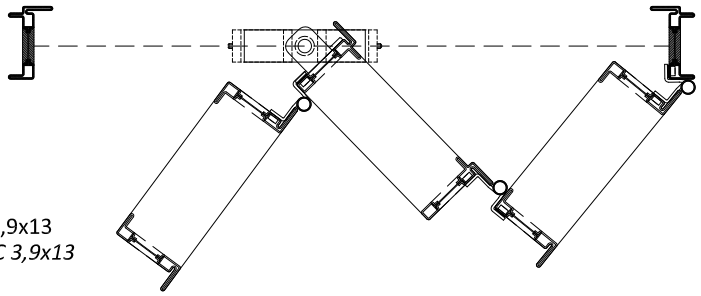


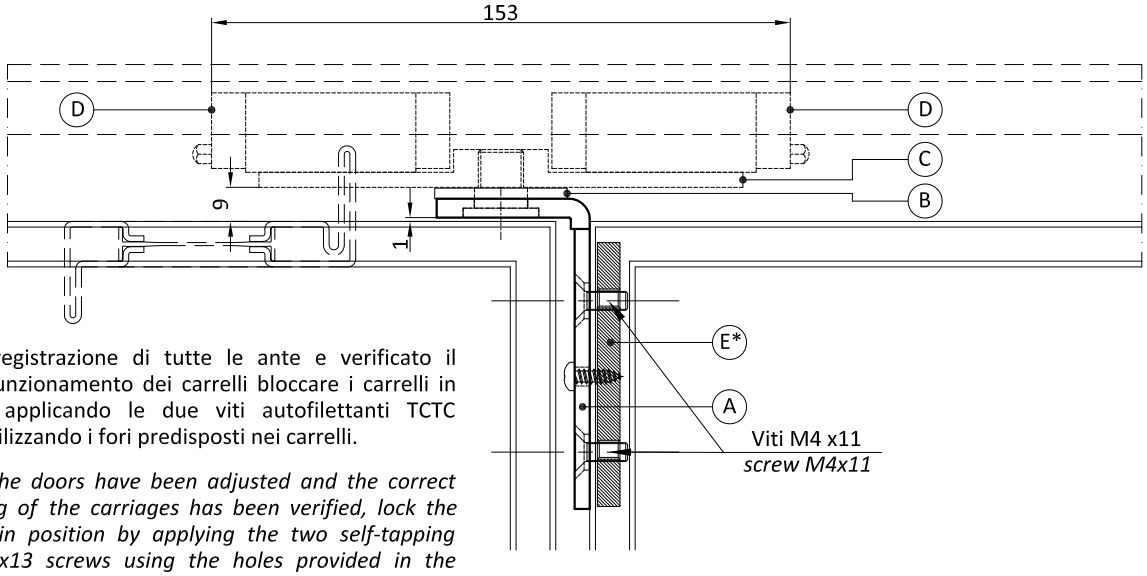
apertura INTERNA
INWARD opening



A - Staffa angolare | *Corner bracket*
B - Rondella ottone | *Brass washer*
C - Piastra collegamento carelli | *Connection plate for roller*
D - Carrelli | *Rollers*
E - Rinforzo* | *Reinforcement**

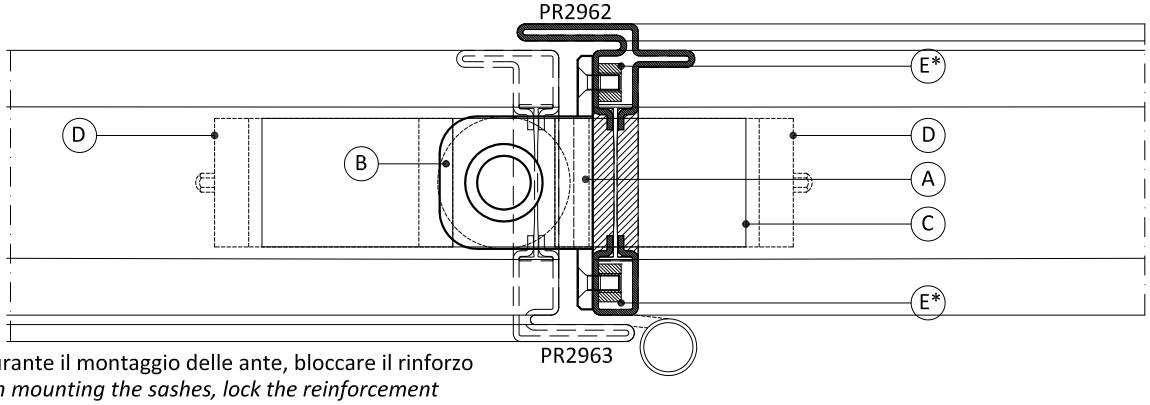




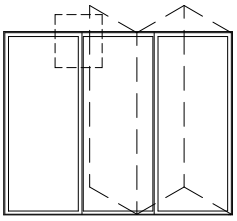


Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9xx13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9xx13 screws using the holes provided in the carriages.

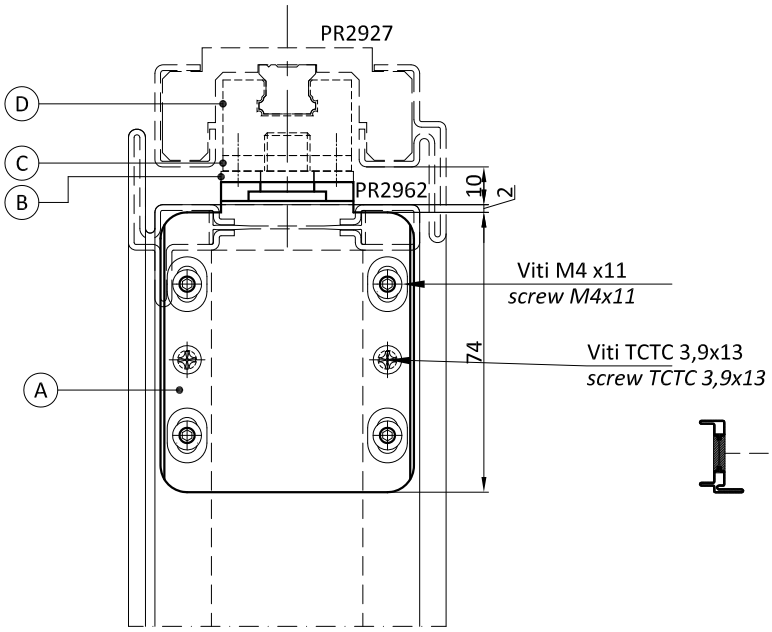


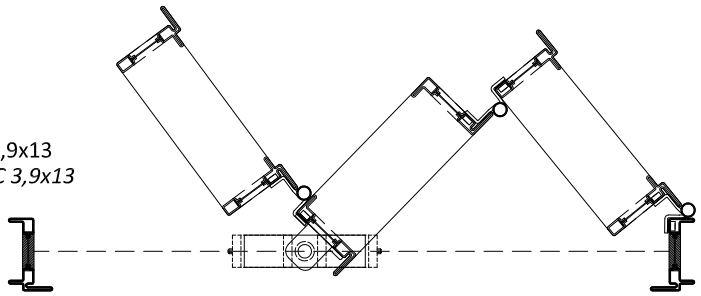
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

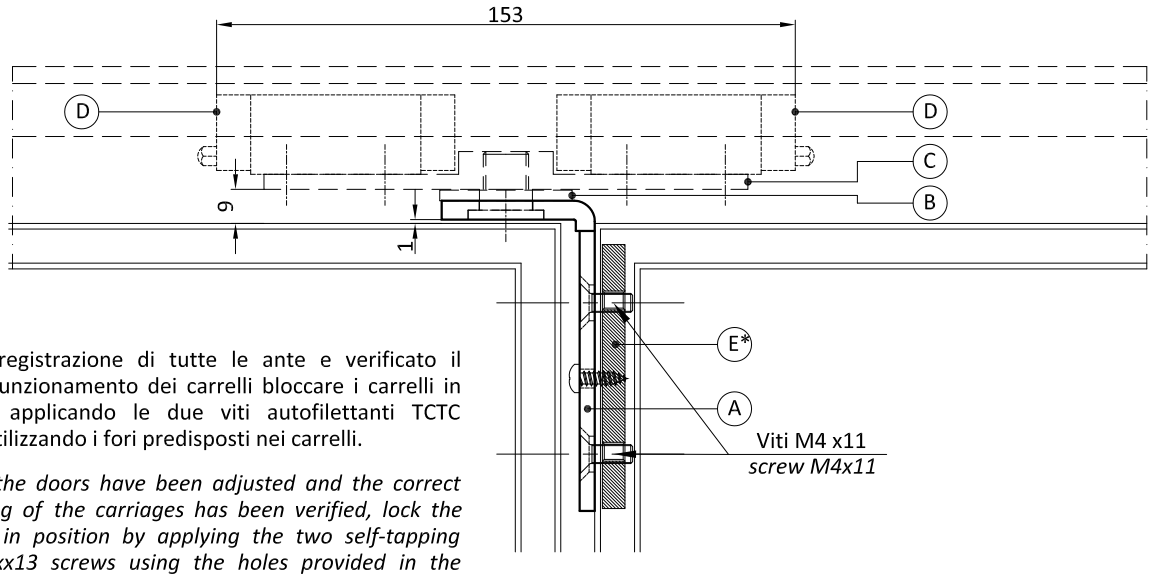


apertura ESTERNA
OUTWARD opening

A - Staffa angolare | *Corner bracket*
B - Rondella ottone | *Brass washer*
C - Piastra collegamento carelli | *Connection plate for roller*
D - Carrelli | *Rollers*
E - Rinforzo* | *Reinforcement**

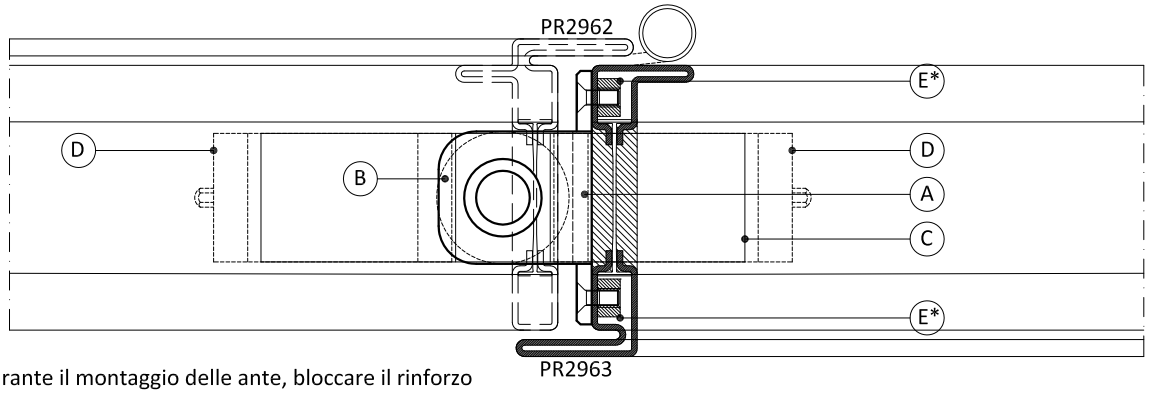






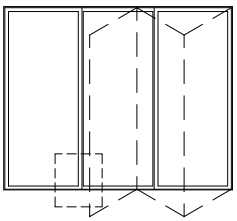
Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9xx13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9xx13 screws using the holes provided in the carriages.

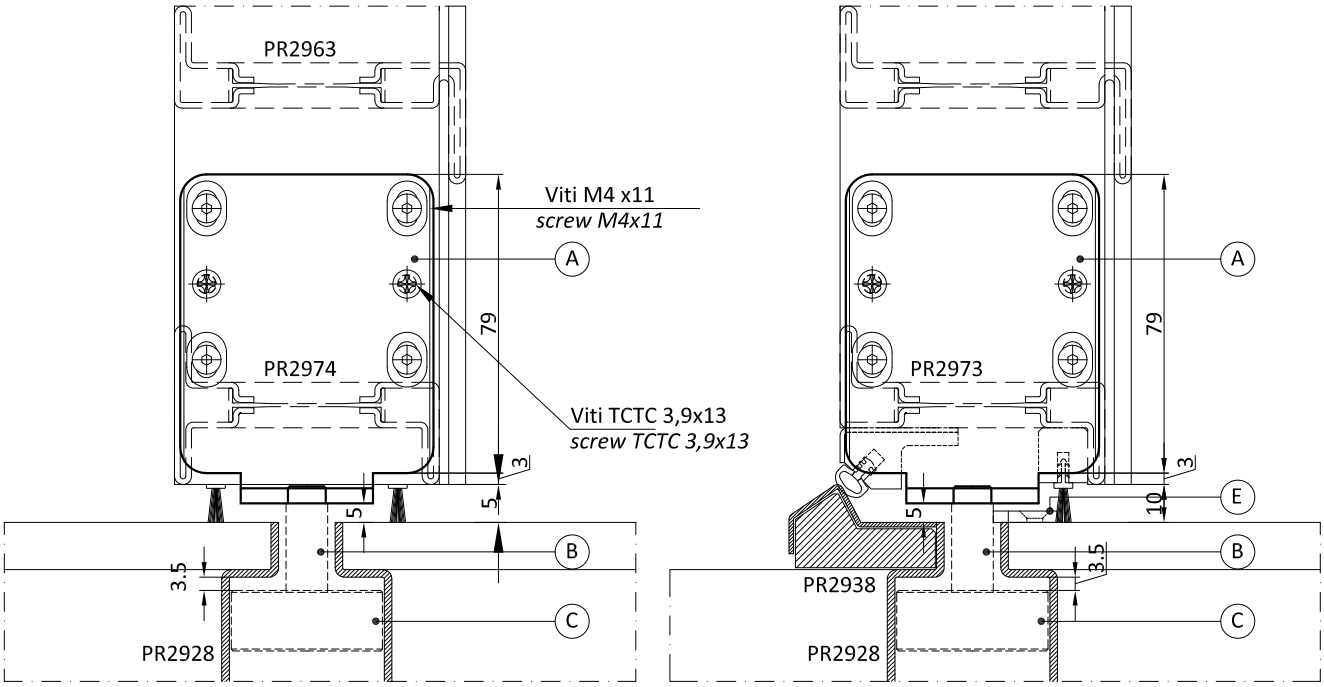


* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

apertura INTERNA
INWARD opening

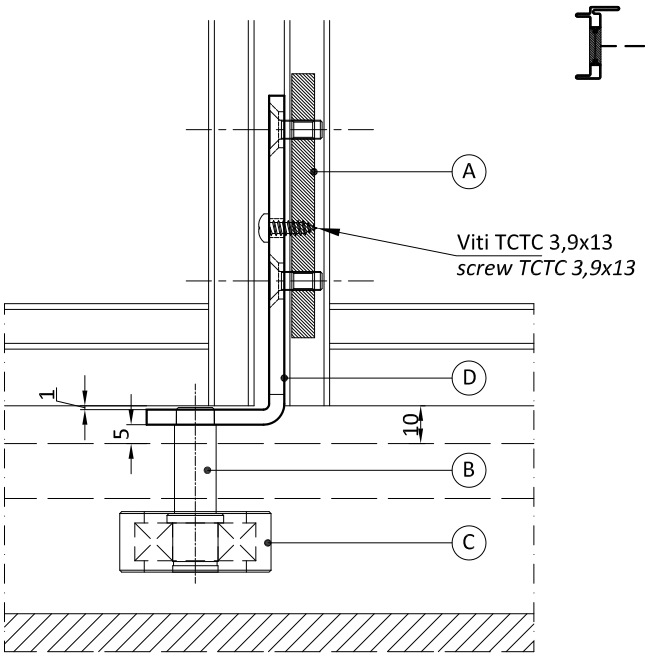


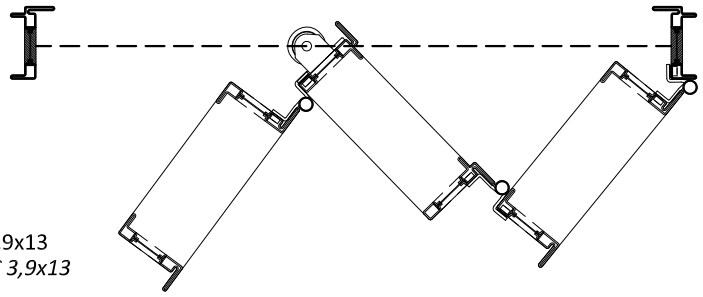
A - Staffa angolare | *Corner bracket*
B - Perno | *Pivot*
C - Cuscinetto a sfera | *Ball bearing*
D - Rinforzo | *Reinforcement*
E - Incontro carrello inferiore | *Strike plate bottom roller*

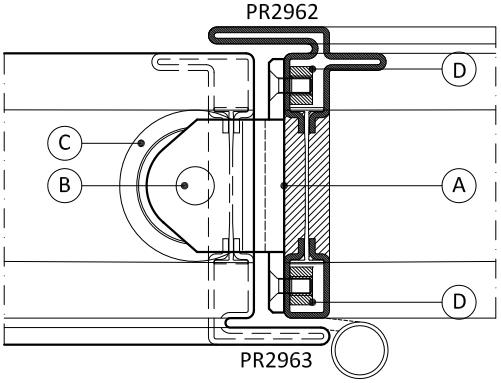


Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9xx13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9xx13 screws using the holes provided in the carriages.



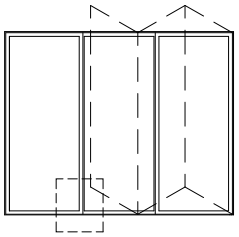




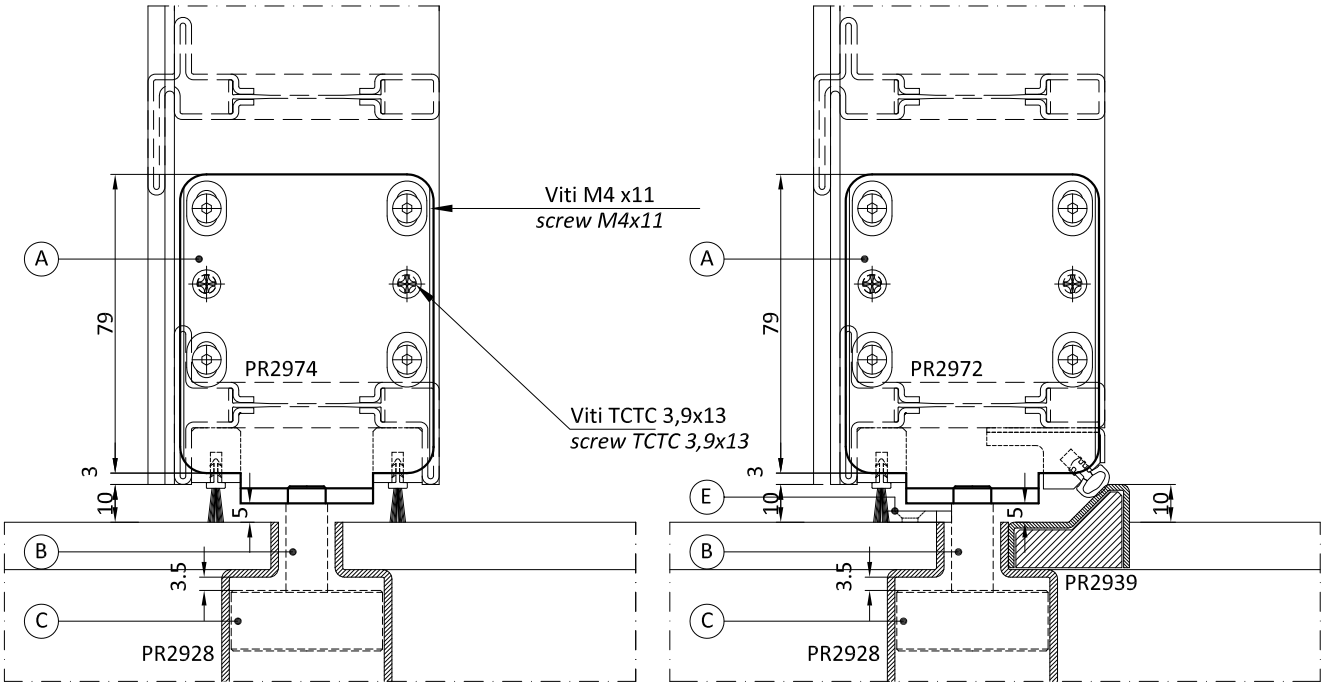
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

viti e tasselli non inclusi | *screws and wall plugs not supplied*

apertura ESTERNA
OUTWARD opening

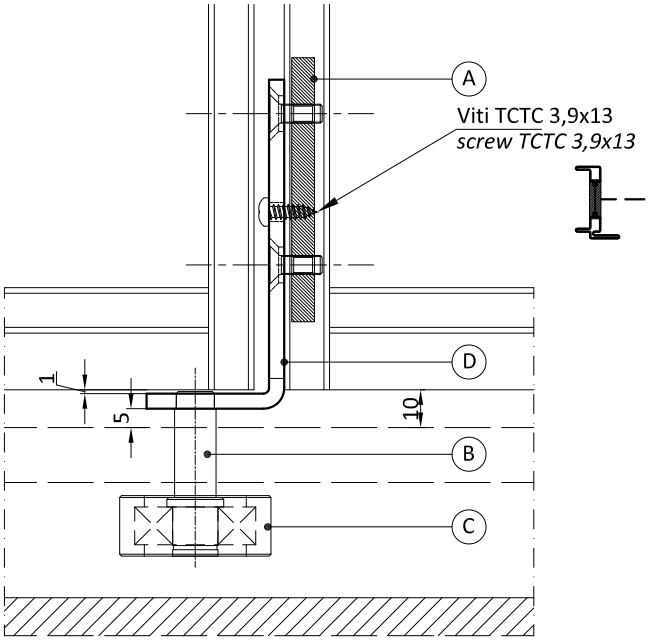


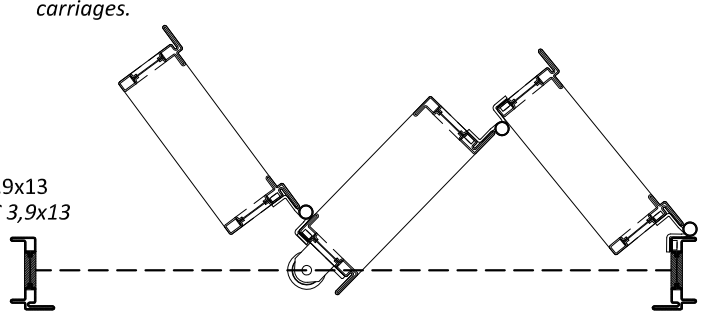
A - Staffa angolare | *Corner bracket*
B - Perno | *Pivot*
C - Cuscinetto a sfera | *Ball bearing*
D - Rinforzo | *Reinforcement*
E - Incontro carrello inferiore| *Strike plate bottom roller*

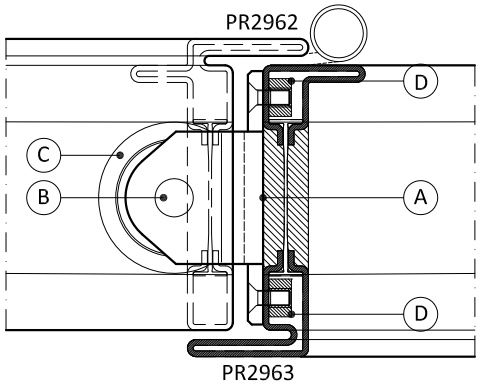


Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9xx13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9xx13 screws using the holes provided in the carriages.



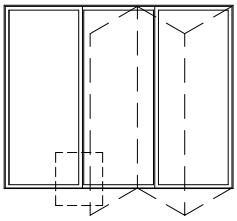


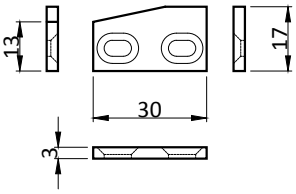


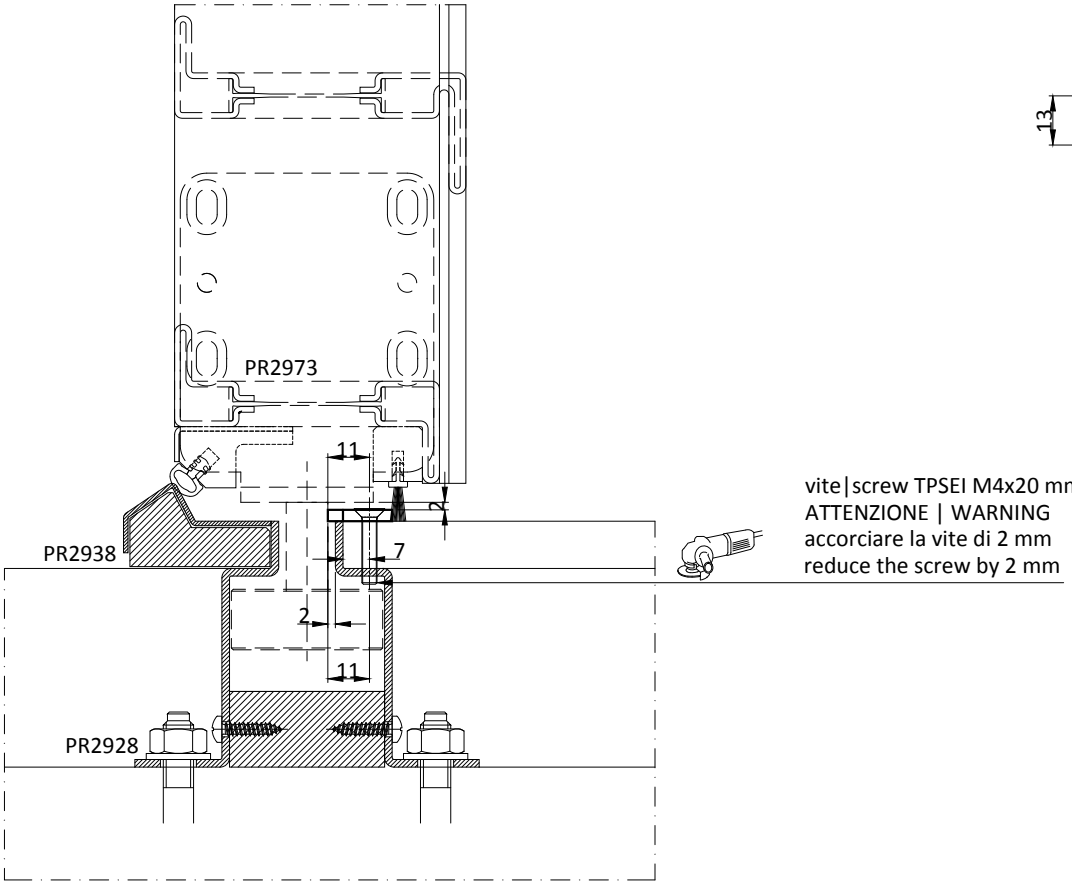
* ATTENZIONE durante il montaggio delle ante, bloccare il rinforzo
** WARNING when mounting the sashes, lock the reinforcement*

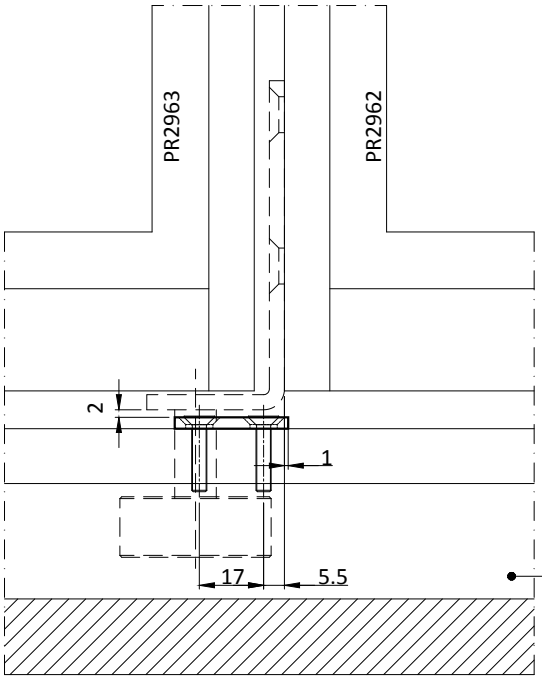
viti e tasselli non inclusi | *screws and wall plugs not supplied*

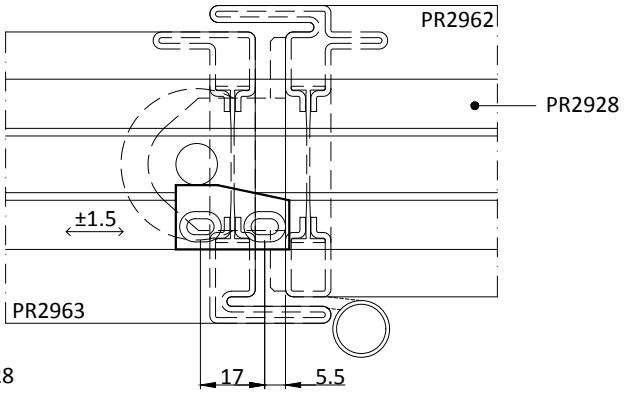
apertura INTERNA
INWARD opening



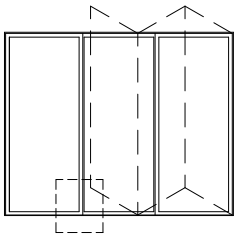


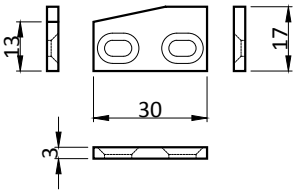


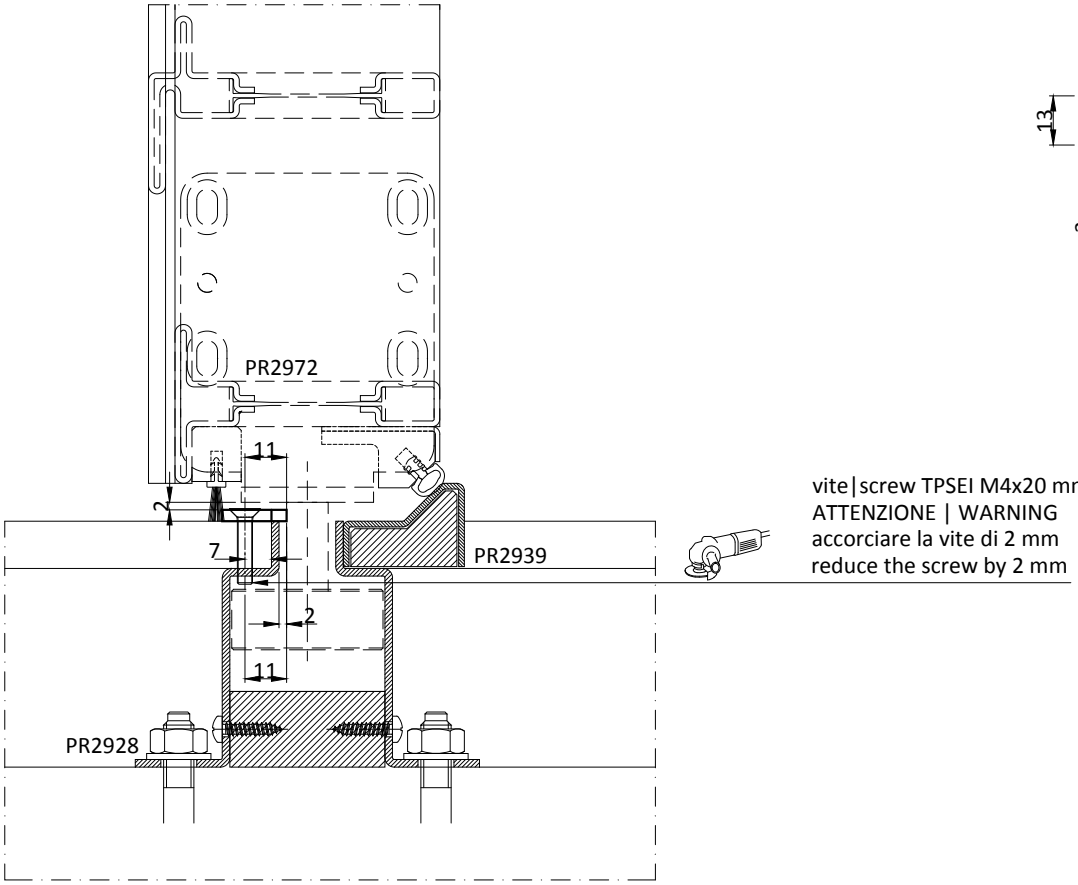


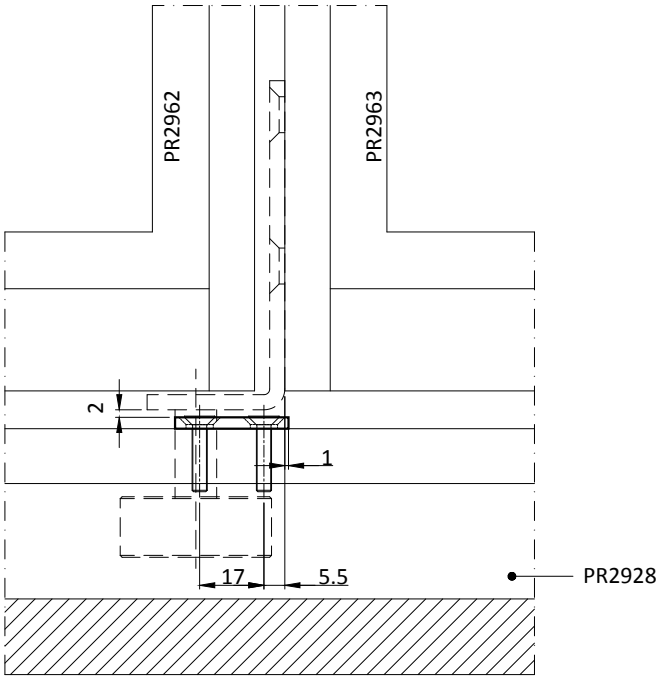


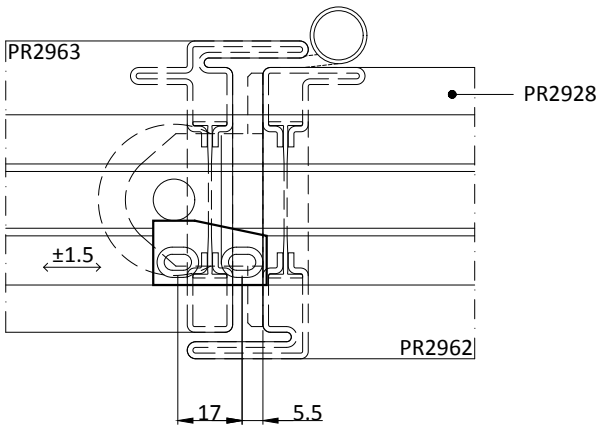
apertura ESTERNA
OUTWARD opening

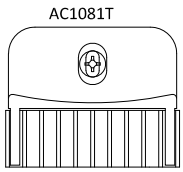


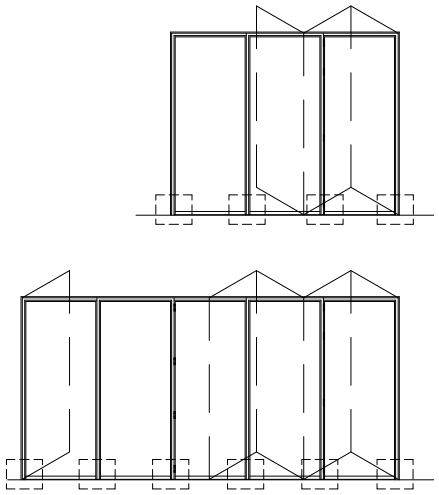




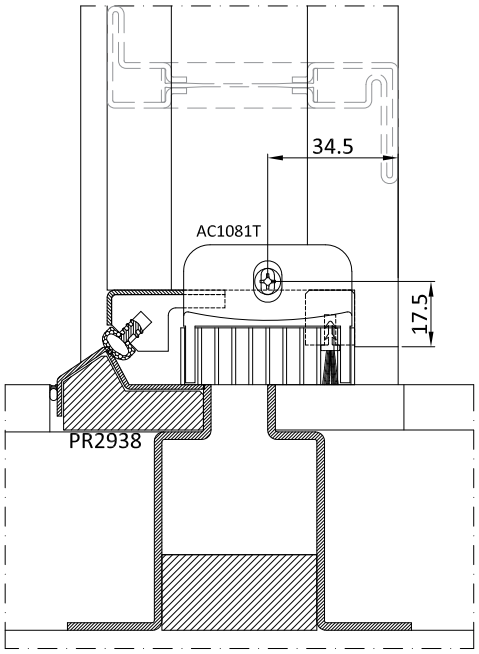




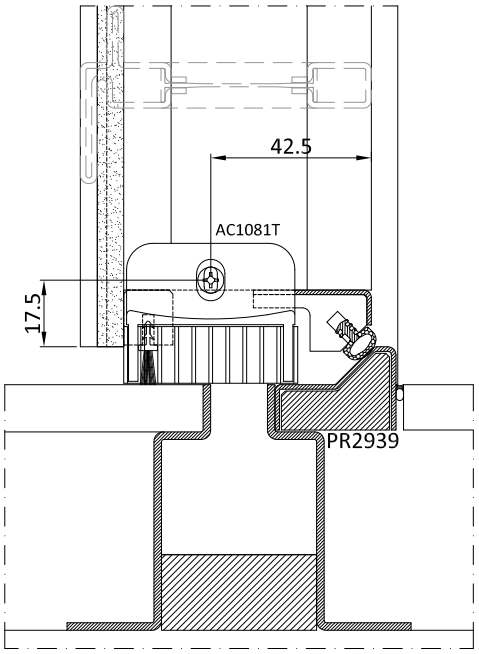


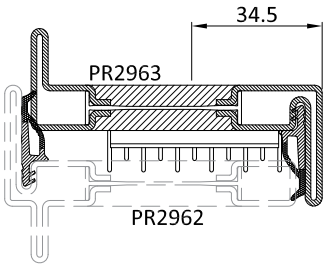


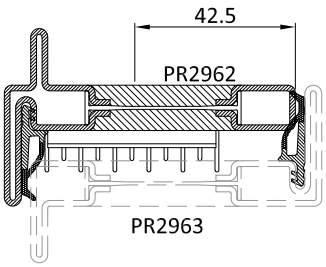
apertura INTERNA
INWARD opening



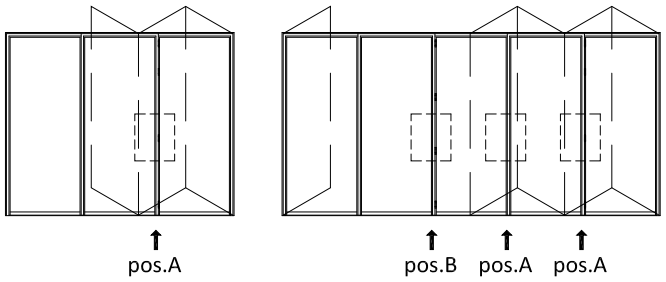
apertura ESTERNA
OUTWARD opening



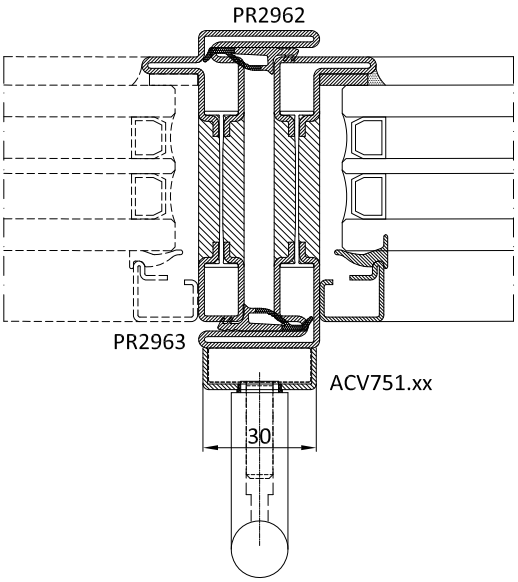


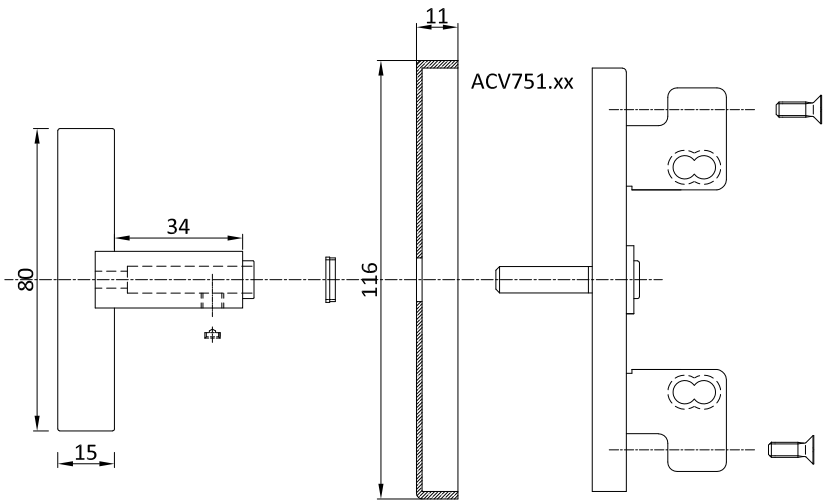


viti non comprese - *screws not supplied*

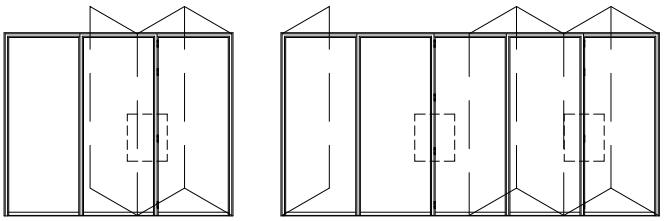


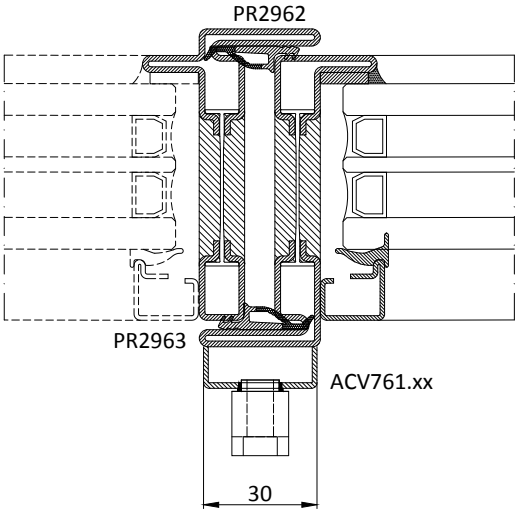
ACV751.xx
pos.A obbligatoria|obligatory
pos.B opzionale|optional

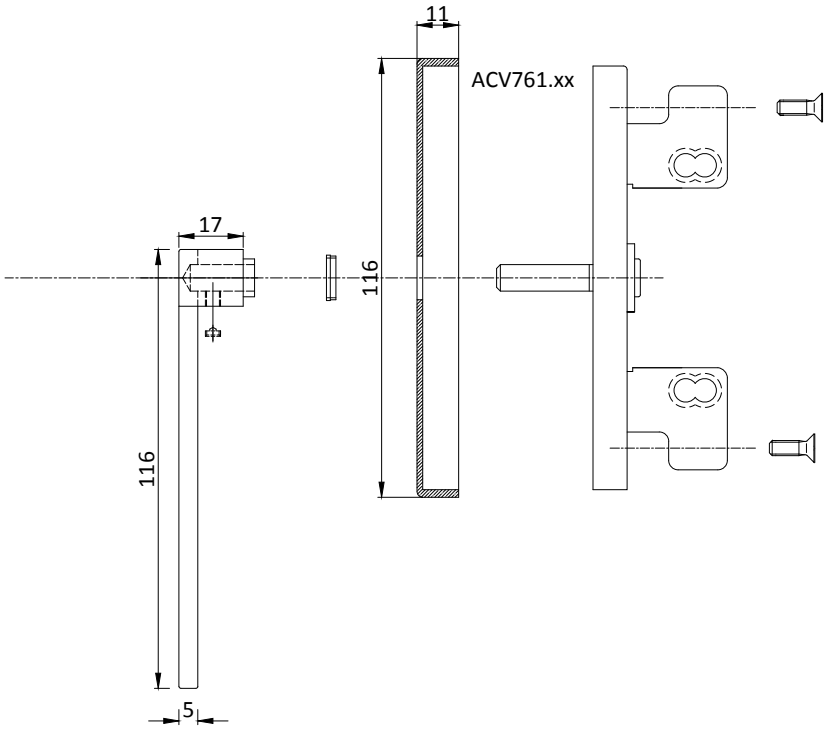




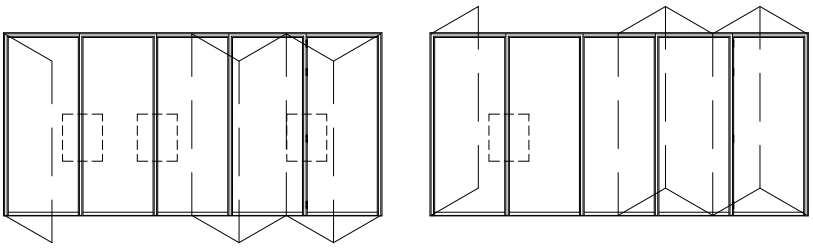
Martellina cremonese ridotta su impacchettamento Apertura Interna 3+0;4+1 e similari, apertura esterna 2+1 e similari
Reduce cemone handle on opening folding inward 3+0; 4+1 and similar, ouward 2+1 an similar

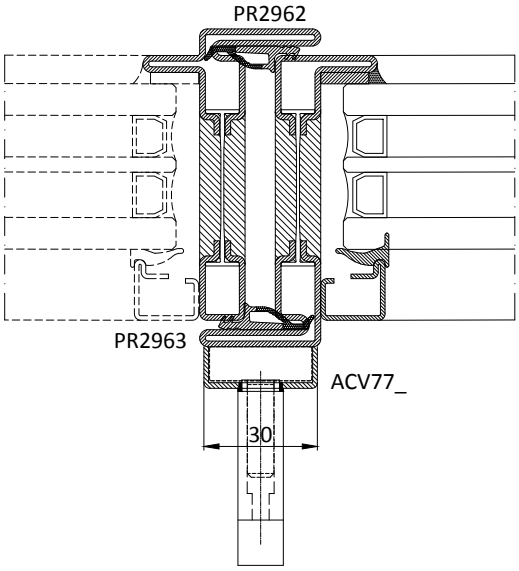


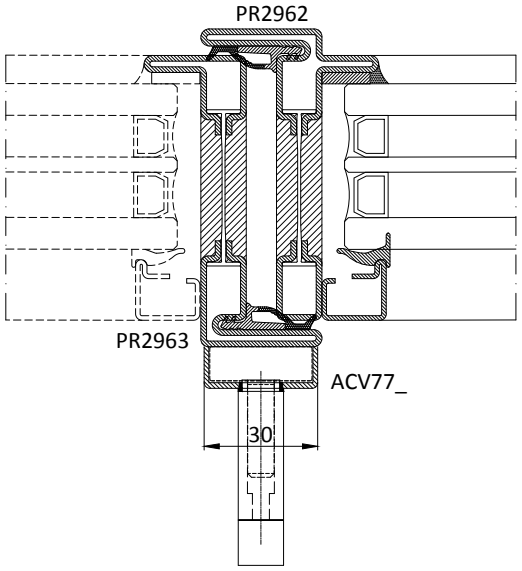


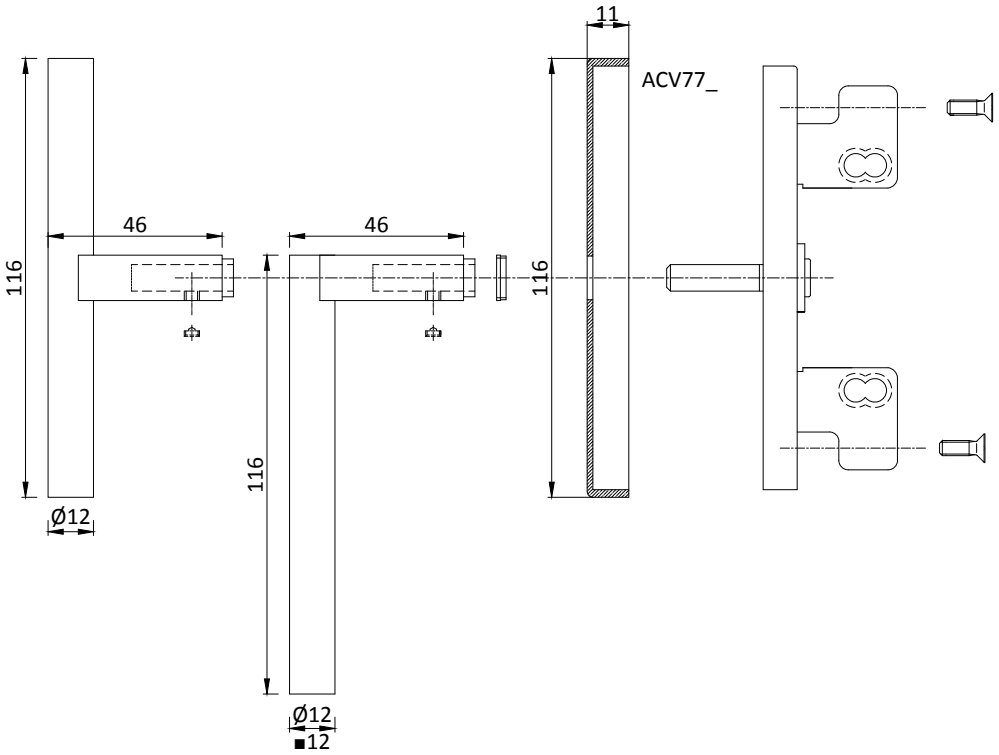


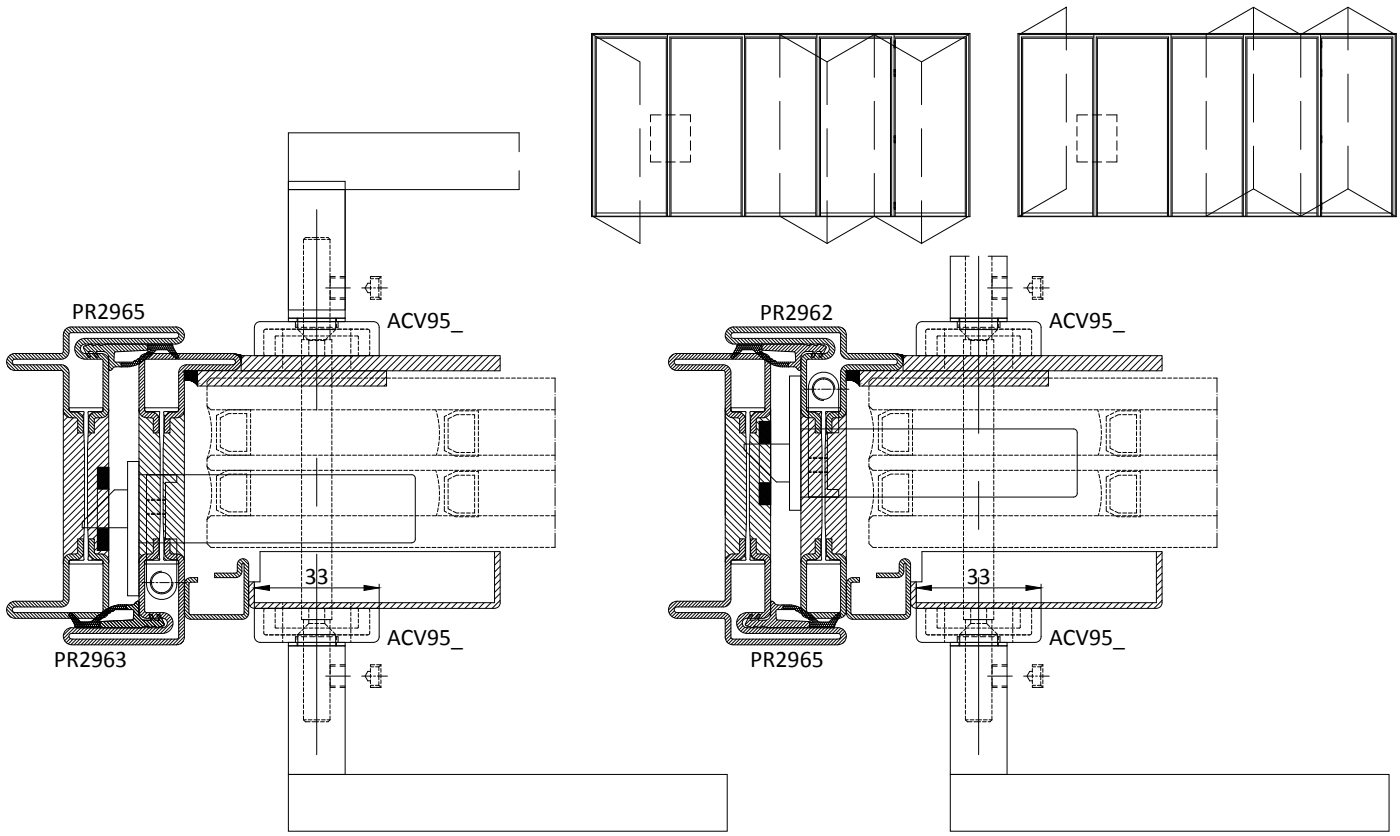
Martellina cremonese ridotta su impacchettamento apertura esterna
Reduce cemone handle on opening folding ouward

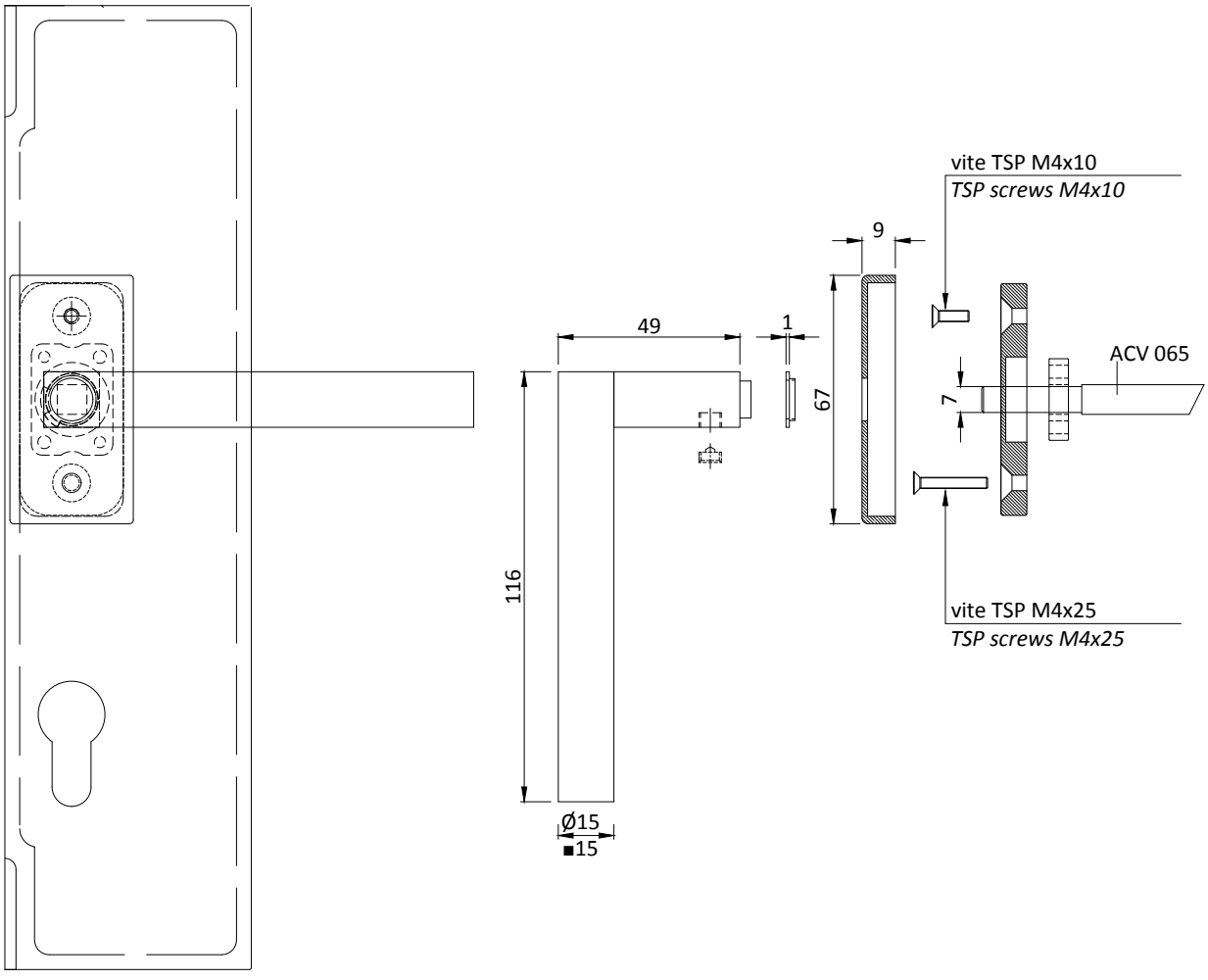


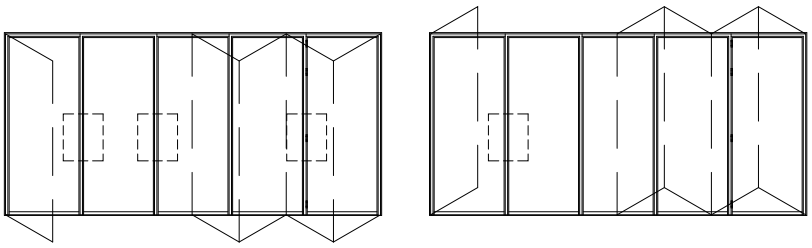

PR2962
PR2963
ACV77_
30

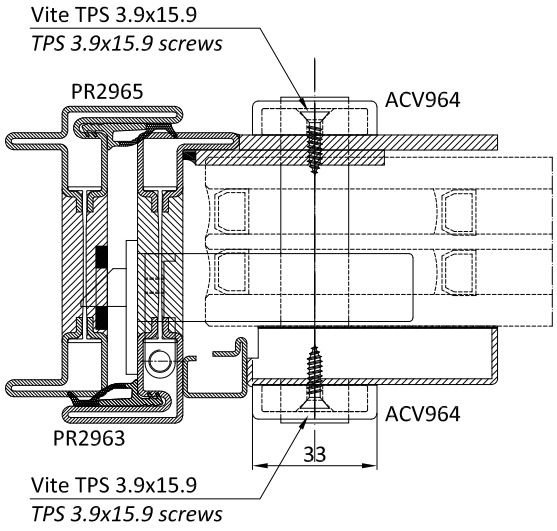

PR2962
PR2963
ACV77_
30

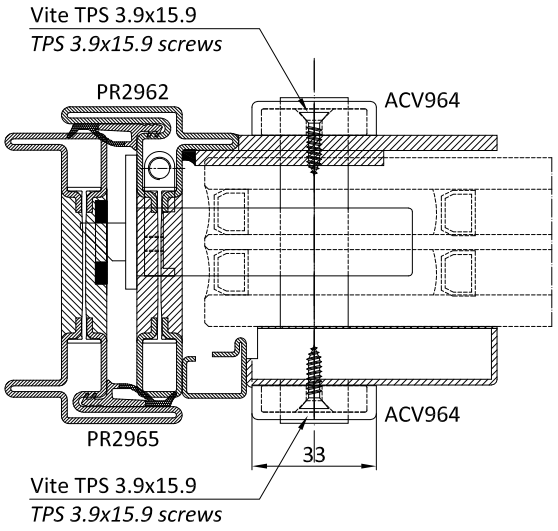

11
ACV77_
46
46
116
116
116
Ø12
Ø12
■12

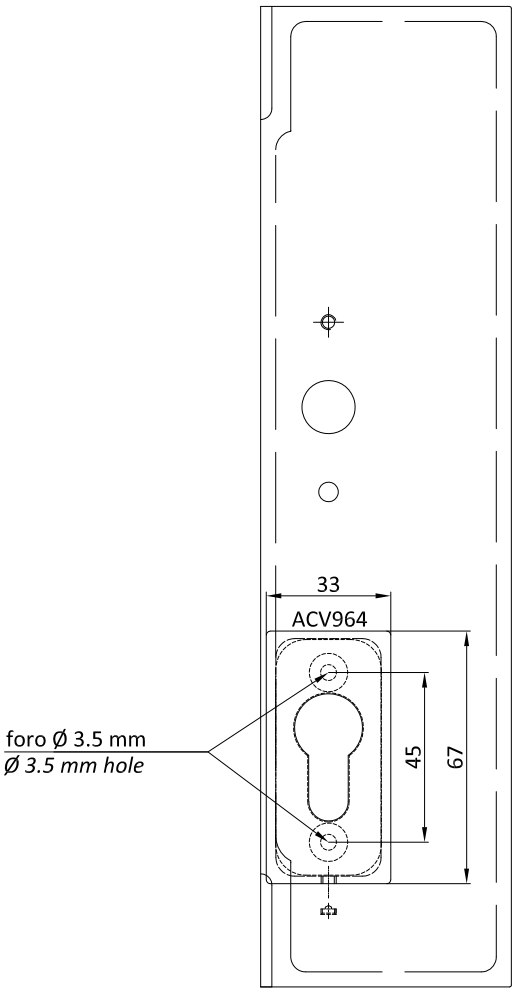

PR2965
ACV95_
33
ACV95_
PR2963
PR2962
ACV95_
33
ACV95_
PR2965

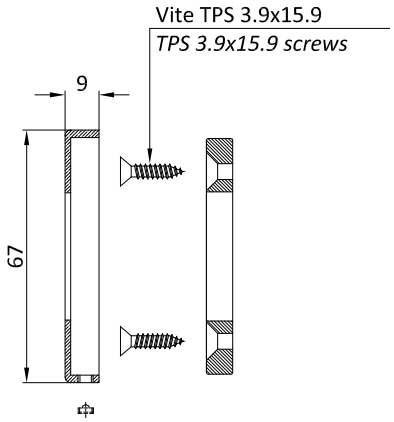

vite TSP M4x10
TSP screws M4x10
9
49
1
67
7
ACV 065
116
vite TSP M4x25
TSP screws M4x25
Ø15
■15

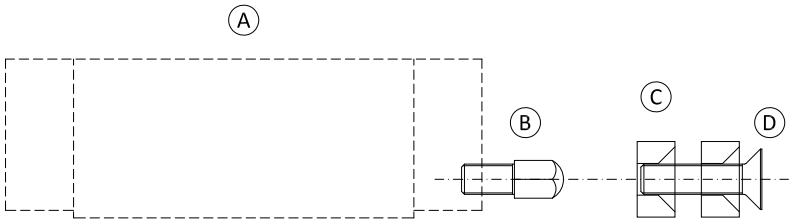


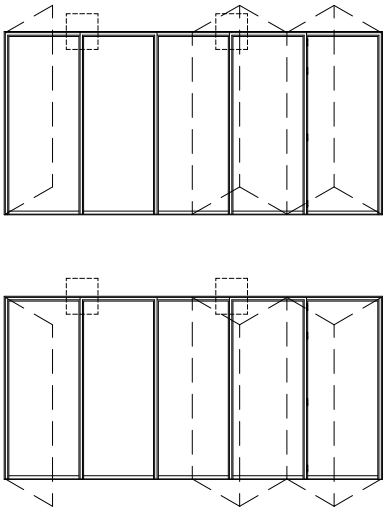

Vite TPS 3.9x15.9
TPS 3.9x15.9 screws
PR2965
ACV964
ACV964
PR2963
33
Vite TPS 3.9x15.9
TPS 3.9x15.9 screws


Vite TPS 3.9x15.9
TPS 3.9x15.9 screws
PR2962
ACV964
ACV964
PR2965
33
Vite TPS 3.9x15.9
TPS 3.9x15.9 screws


33
ACV964
foro Ø 3.5 mm
Ø 3.5 mm hole
45
67


Vite TPS 3.9x15.9
TPS 3.9x15.9 screws
9
67

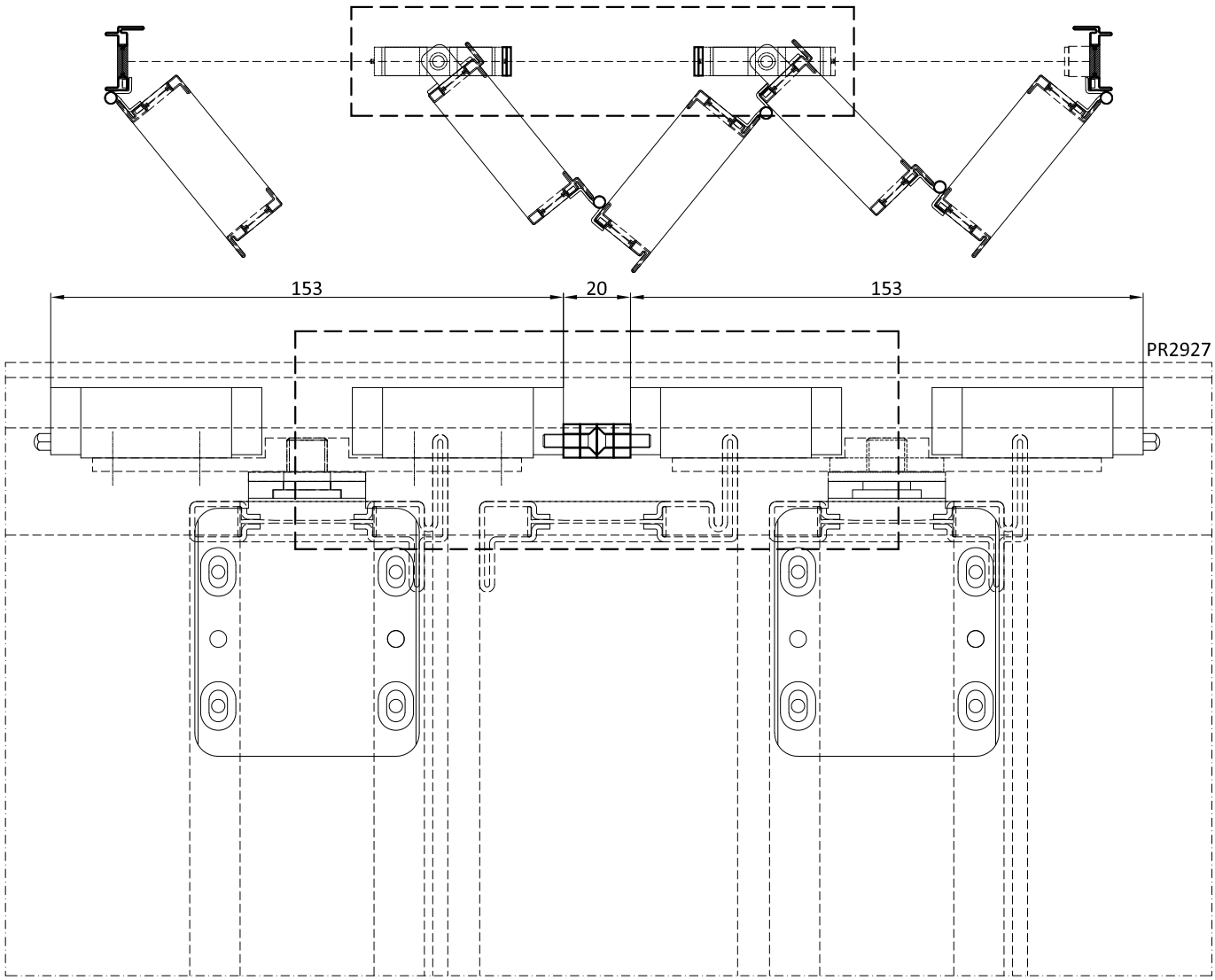


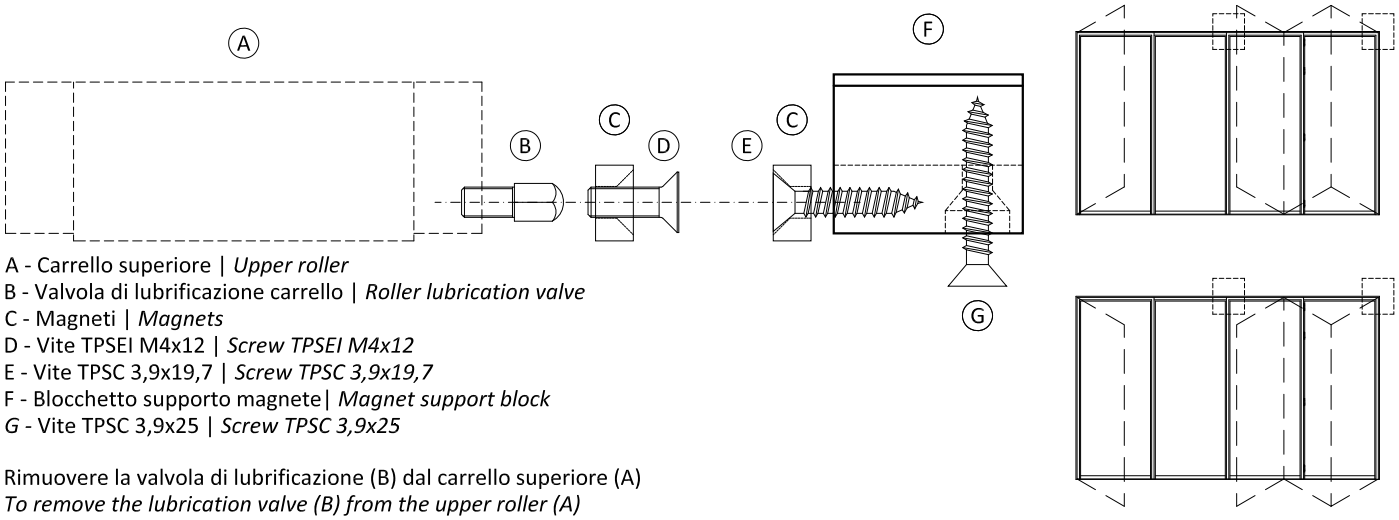


A - Carrello superiore | *Upper roller*
B - Valvola di lubrificazione carrello | *Roller lubrication valve*
C - Magneti | *Magnets*
D - Vite TPSEI M4x16 | *Screw TPSEI M4x16*

Rimuovere la valvola di lubrificazione (B) dal carrello superiore (A)
To remove the lubrication valve (B) from the upper roller (A)

Avvitare i 2 magneti (C) tramite la vite M4x16 (D)
To scew the two magnets (C) with the screw M4x16 (D)





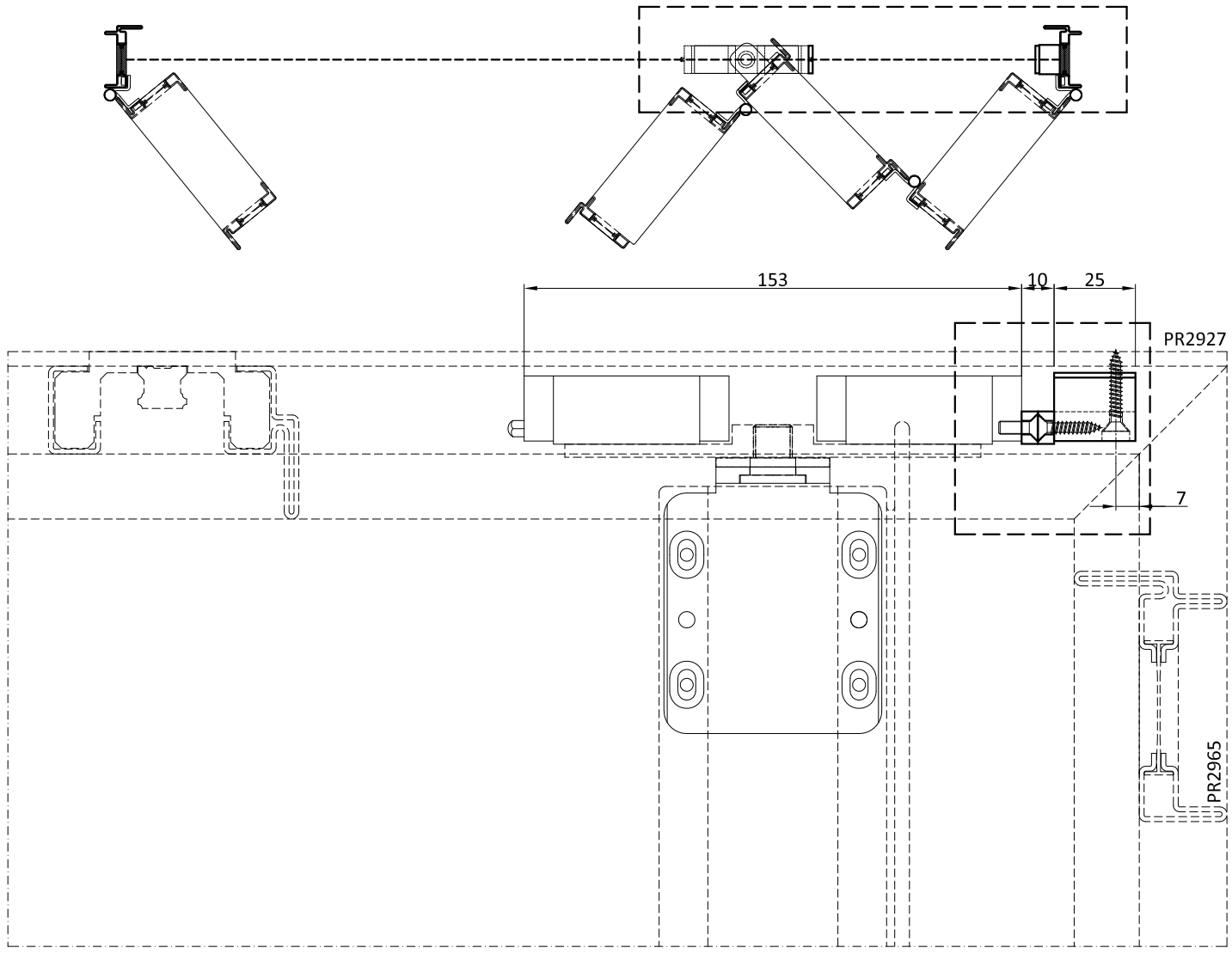
A - Carrello superiore | *Upper roller*
B - Valvola di lubrificazione carrello | *Roller lubrication valve*
C - Magneti | *Magnets*
D - Vite TPSEI M4x12 | *Screw TPSEI M4x12*
E - Vite TPSC 3,9x19,7 | *Screw TPSC 3,9x19,7*
F - Blocchetto supporto magnete| *Magnet support block*
G - Vite TPSC 3,9x25 | *Screw TPSC 3,9x25*

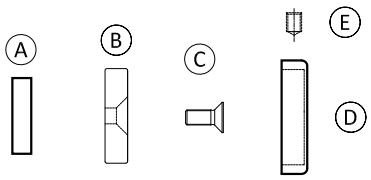
Rimuovere la valvola di lubrificazione (B) dal carrello superiore (A)
To remove the lubrication valve (B) from the upper roller (A)

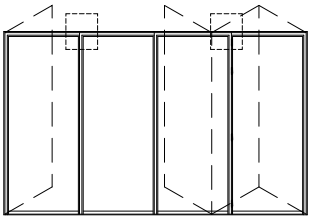
Avvitare il magnete (C) tramite la vite M4x12 (D) al carrello superiore (A)
To screw the magnet (C) with the screw M4x12 (D) to the upper roller (A)

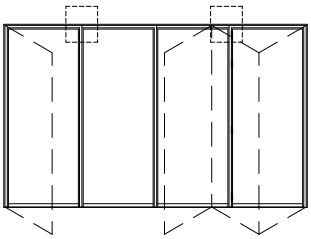
Avvitare il magnete (C) tramite la vite TPSC 3,9x19,7 (E) al blocchetto supporto magnete (F)
To screw the magnet (C) with the screw TPSC 3,9x19,7 *(E) to the magnet support block (F)*

Fissare il blocchetto (F) alla guida superiore tramite la vite TPSC 3,9x25 (G)
To fix the support block (F) to the upper guide with the screw TPSC 3,9x25 (G)







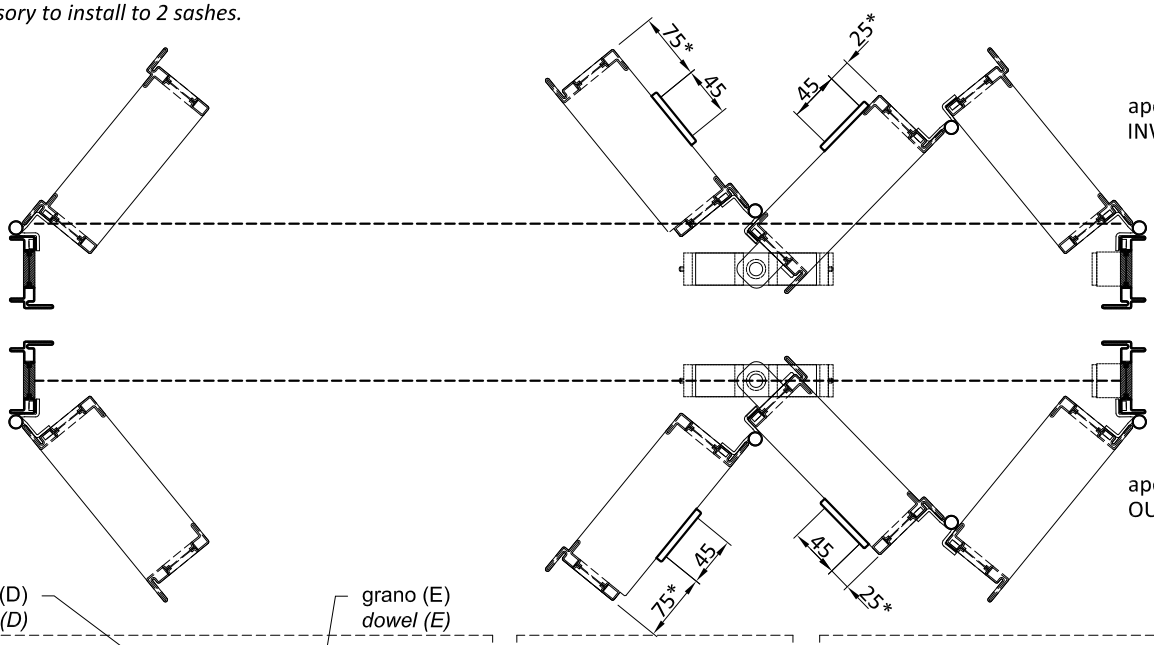


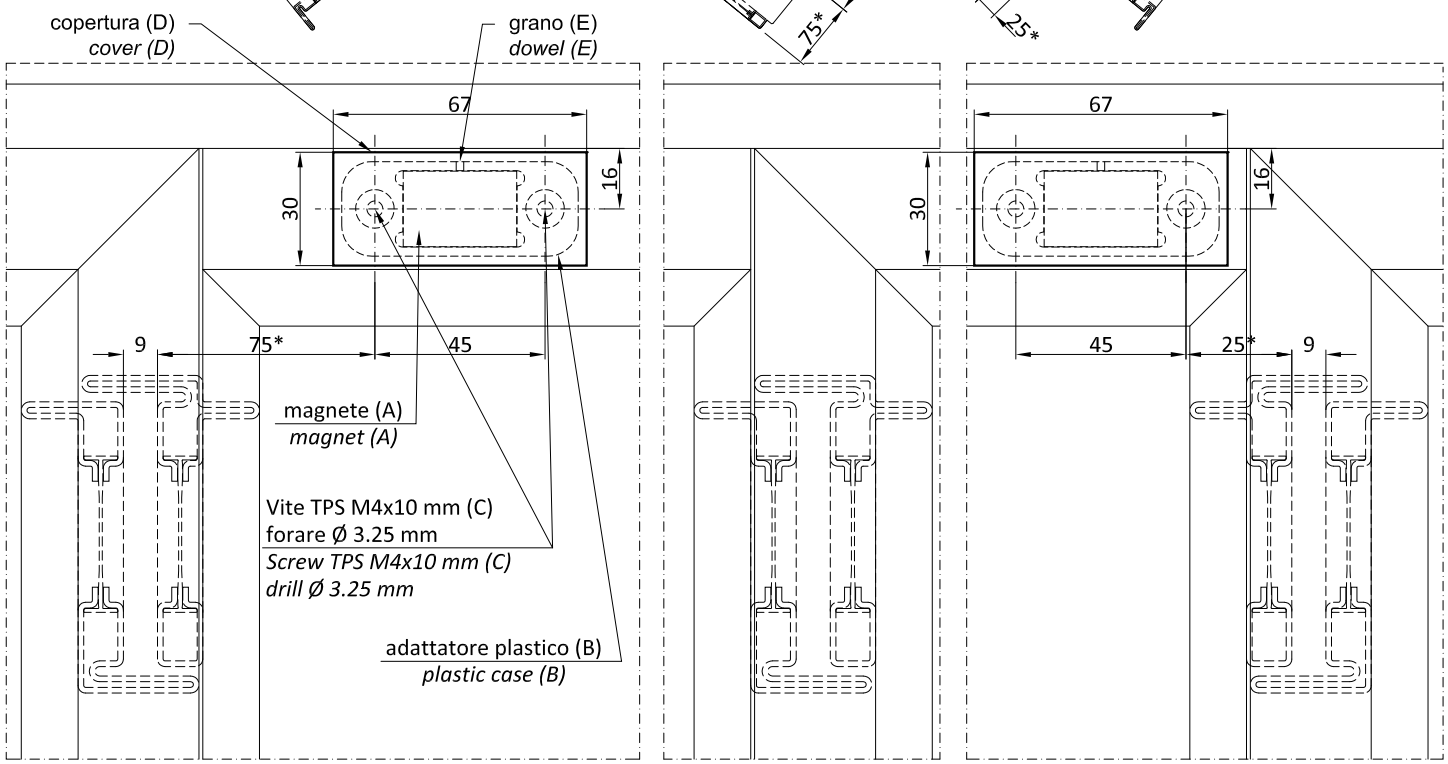
A - Magnete | *Magnet*
B - Adattatore plastico | *Plastic case*
C - Vite TPS M4x10 mm | *Screw TPS M4x10 mm*
D - Copertura porta magnete | *Magnet cover*
E - Grano A2 M4x6 mm | *Dowel A2 M4x6*

Inserire il magnete (A) all'adattatore plastico (B) e fissare all'ante tramite le viti 3,9x12,7 (C)
To put the magnet (A) to the plastic case (B) and to fix to the sash with screw 3,9x12,7 (C)

Posizionare la copertura porta magnete (D) e fissarla all'adattatore plastico (B) tramite il grano M4x6 (E)
To fit in the magnet cover (D) and to fix it (B) with the dowel M4x6 (E) to the plastic case (B)

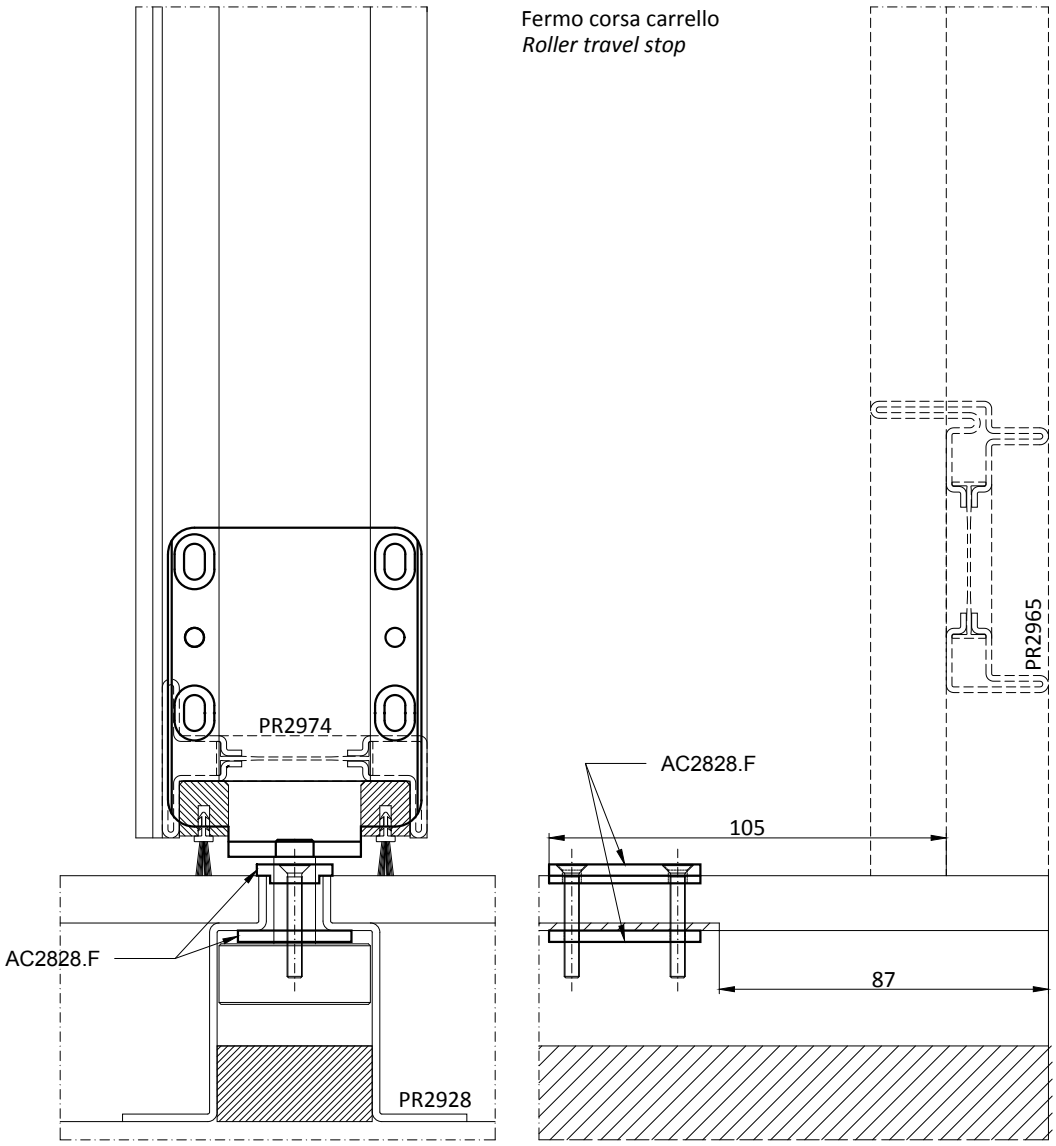
N.b.: accessorio da installare su 2 ante.
Note: accessory to install to 2 sashes.

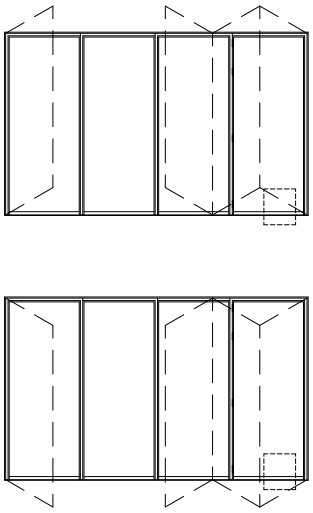




* posizionamento teorico; si consiglia di fissare uno dei due magneti e tracciare il posizionamento del secondo
** theoretical positioning; it is advisable to fix one of the two magnets and trace the positioning of the second one*

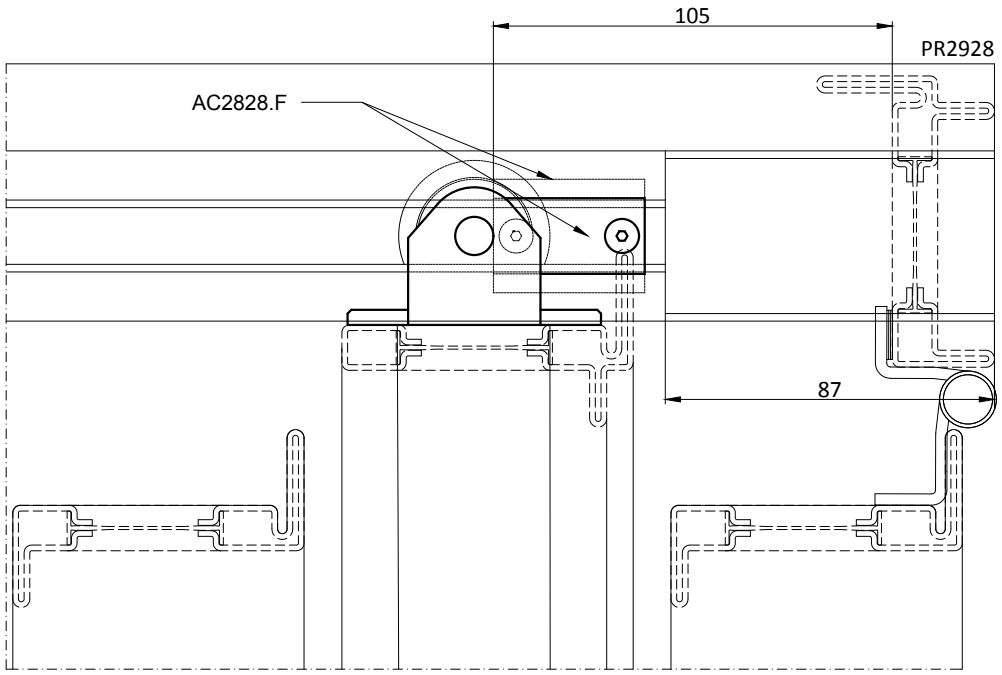
Fermo corsa carrello
Roller travel stop

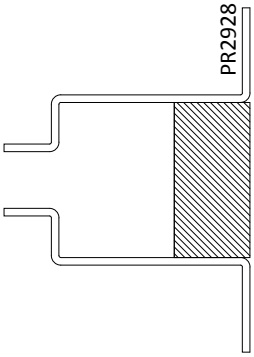


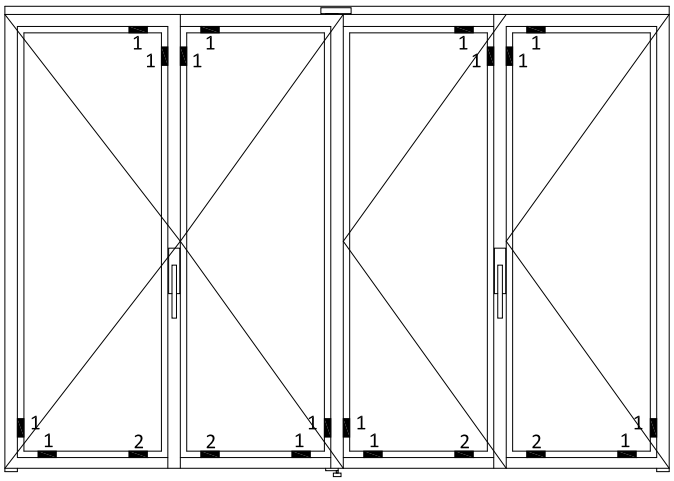


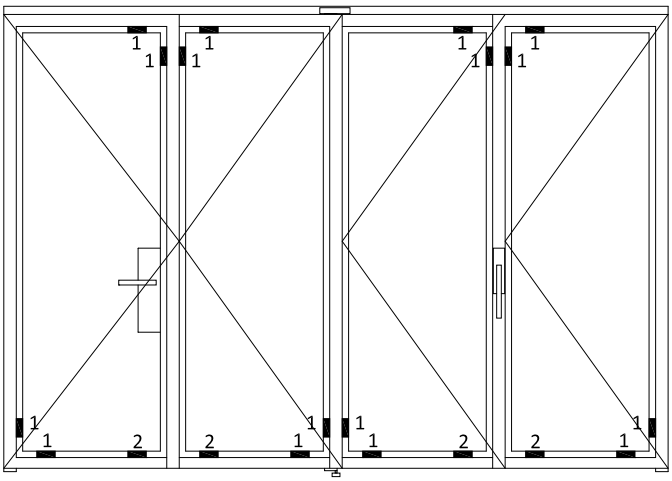
Applicazione valida anche con profilo zoccolo PR2972 e PR2973

Application valid with PR2972 and PR2973 bottom profile



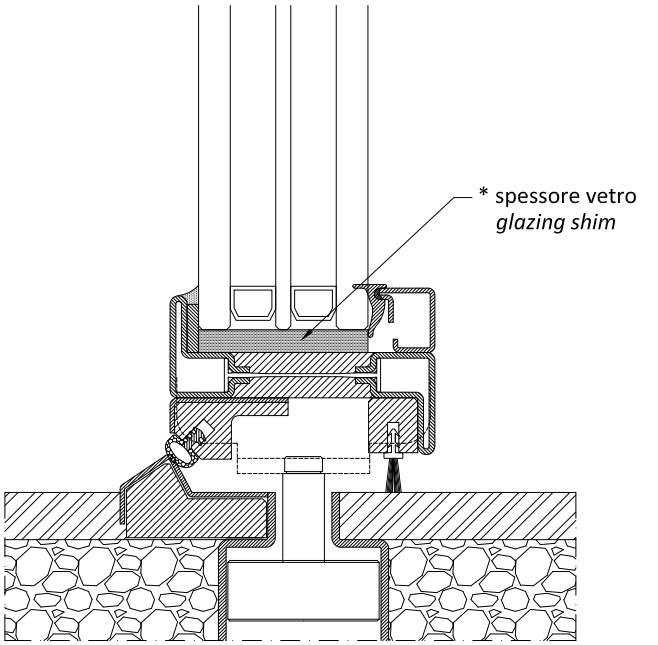


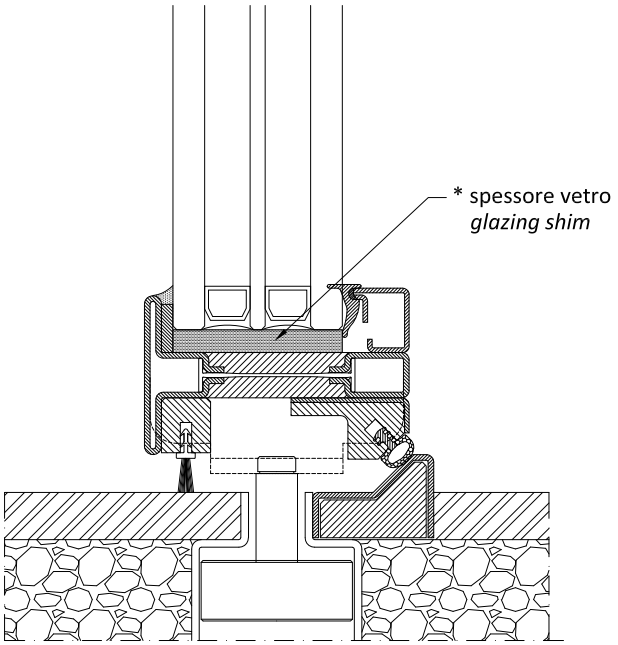




1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*





Note / *Note*

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- *The shims width is the same or bigger (+2 mm) than the installed glas spacer.*

- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti la migrazione.
- *The shims position has to be provided by using an appropriate material which avoids any movements.*

* spessori vetro non inclusi - *glazing shims not included*

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 L è composto da una serie di profili dalle ridottissime dimensioni e prevede un accoppiamento dei telai esterni con le ante apribili con distanza di 8 mm in verticale e 10 mm in orizzontale. 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 e la tolleranza per il sormonto degli stessi compresa tra +0/+0.5 mm.

Taglio/Lavorazioni
I profili OS2 75 L in acciaio, 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 utilizzate per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2900) 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 L 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 L 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 (SA1033). 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 o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione e all'esterno, l'utilizzo di siliconatura o inserimento della guarnizione adesiva GE2606 (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m^2 di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

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 fughe e del sormonto tra ante apribili e telai fissi, il regolare posizionamento delle guarnizioni e delle sigillature, il drenaggio del giunto aperto 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 L is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm in vertical side and 10 mm in horizontal side. To ensure the correct use of hardware and gaskets the processing must be performed with great care and precision. It is advised to keep the tolerance between +0/-1 mm for opening elements and between +0/+0.5 mm for their overlapping area.

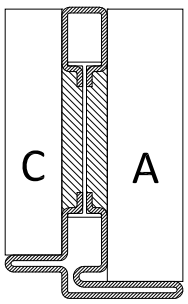
Cut / Processing
OS2 75 L profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. OS2 75 L profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2900) 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°. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

Welding
OS2 75 L 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 DPIs provided and in areas with sufficient ventilation and with fumes 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 a later painting without any visible imperfections (pores and ripples).
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised

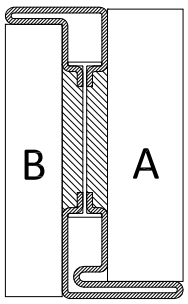
Painting/Burnishing
OS2 75 L profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1033). Holes must be drilled (as per instructions) in the frames 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 cooling.
It is advised to follow pre-treatment and painting cycles as outlined in Secco Sistemi documentation.

Glass application
Glass needs to be secured internally and externally. Internally, glass beads must be used together with clips or bushings and then secured by pressure with the appropriate gasket. Externally, glass must be secured by applying silicone or adhesive gasket GE2606 (the latter is recommended when leaves dimensions are bigger than 1 square metre in order to guarantee a higher rigidity of the glass). In order to ensure the correct behaviour of the system, it is recommended to verify the proper pressurization of the internal glass bead gaskets and that the external silicone perimeter is completely free of imperfections.

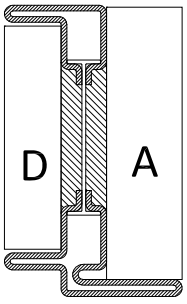
Set up
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, you should verify the proper behaviour of the window/door (easiness of opening/closing, stability of the open leaf, etc.), 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.



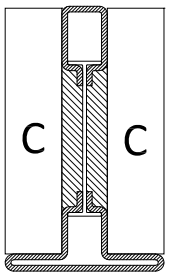
PR2962



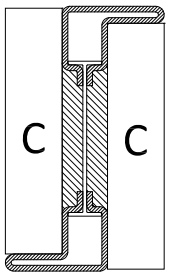
PR2963



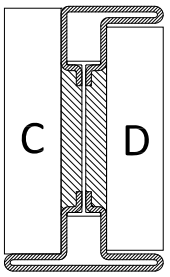
PR2965



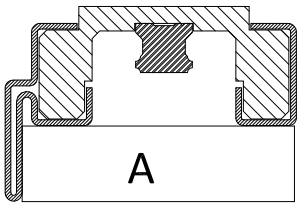
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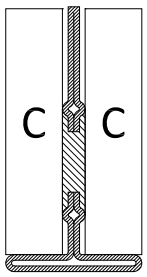
PR2973



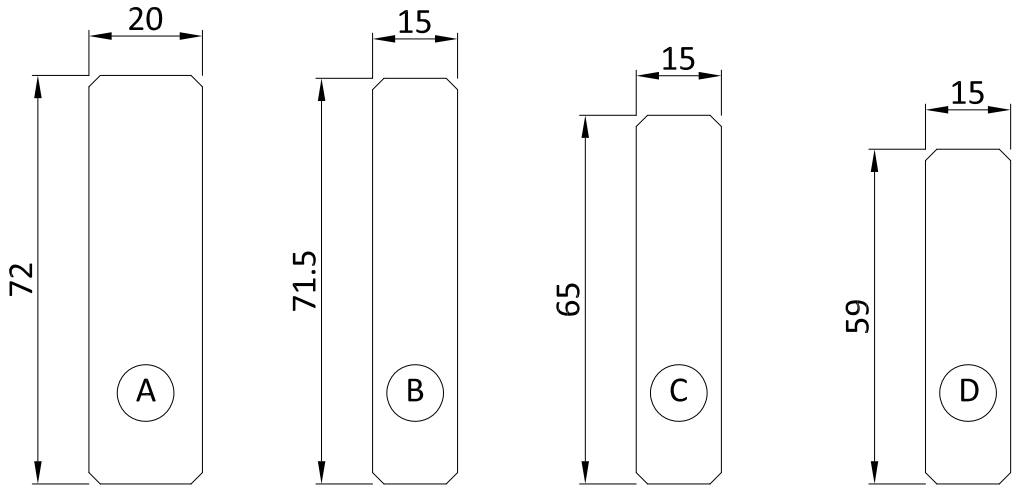
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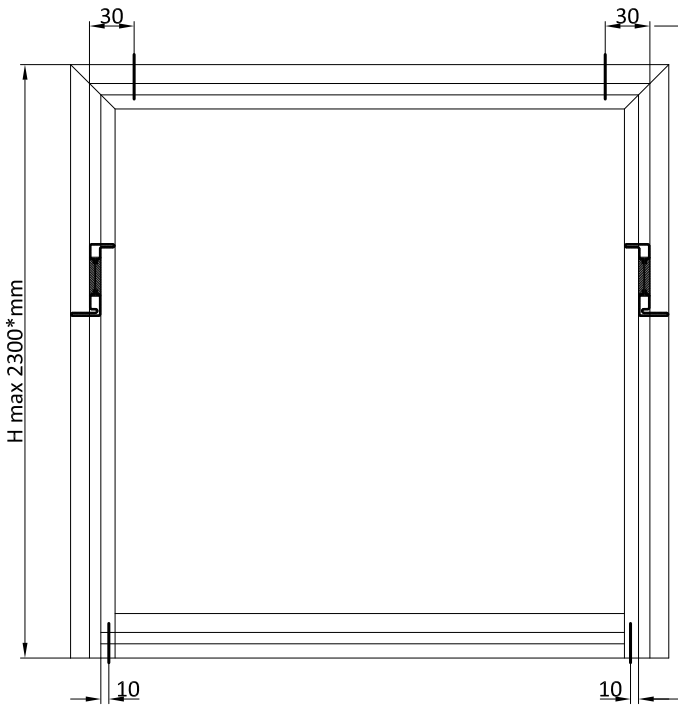


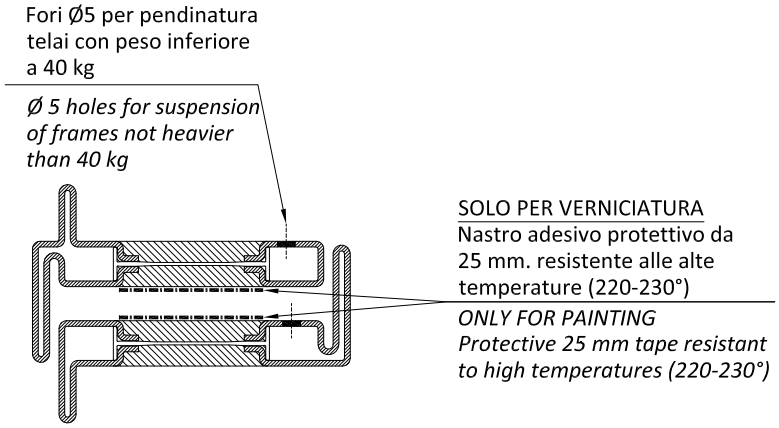
PR2927

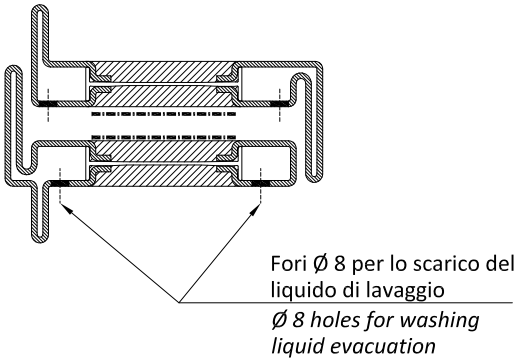


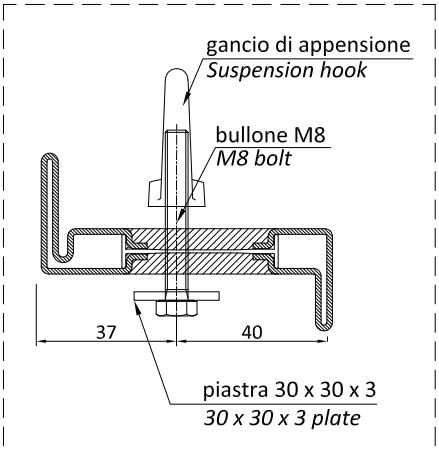
PR2964











Schema appensione per telai con peso superiore a 40 kg

Suspension chart for frames heavier than 40 kg

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

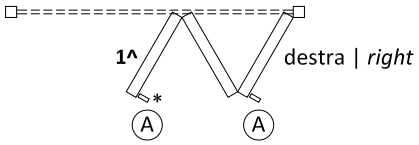
- Use a HSS drill. The diameter of the drill is indicated in the technical note;
- Thread the hole with self-threading zinc-plated screws with the same diameter as the stainless steel screw provided with the kit;
- Position and secure the item with the stainless steel screws provided.

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.

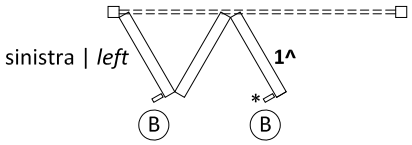
apertura INTERNA
INWARD opening

3+0



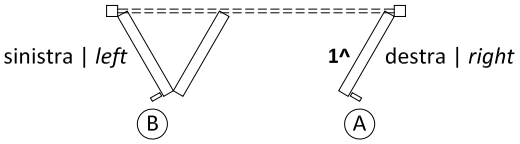
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	2	Kit cremonese | *Cremone bolt*

3+0



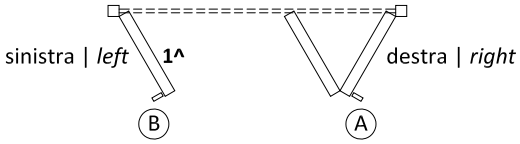
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.S	2	Kit cremonese | *Cremone bolt*

2+1



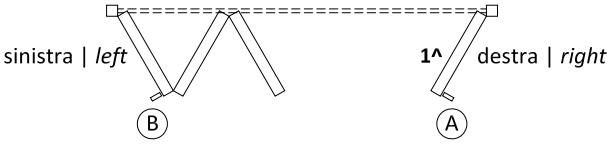
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	1	Kit cremonese | *Cremone bolt*
B	AC 2624.S	1	Kit cremonese | *Cremone bolt*

2+1



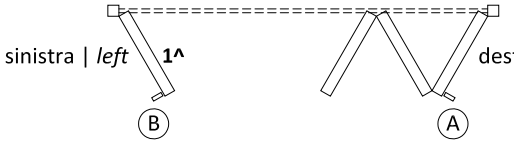
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	1	Kit cremonese | *Cremone bolt*
B	AC 2624.S	1	Kit cremonese | *Cremone bolt*

3+1



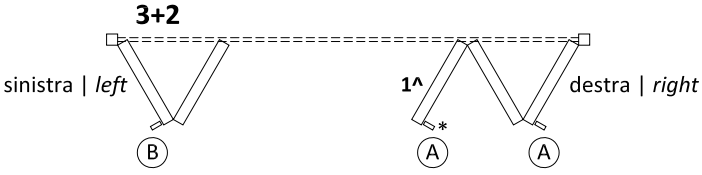
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	1	Kit cremonese | *Cremone bolt*
B	AC 2624.S	1	Kit cremonese | *Cremone bolt*

3+1



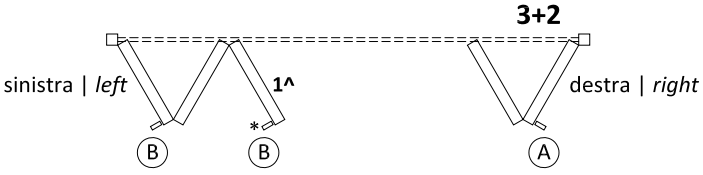
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	1	Kit cremonese | *Cremone bolt*
B	AC 2624.S	1	Kit cremonese | *Cremone bolt*

3+2



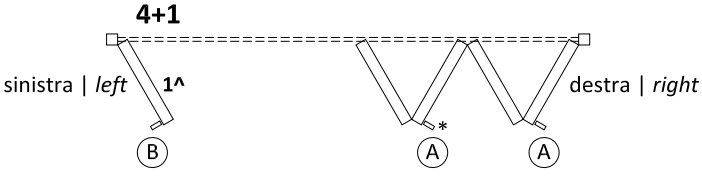
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	2	Kit cremonese | *Cremone bolt*
B	AC 2624.S	1	Kit cremonese | *Cremone bolt*

3+2



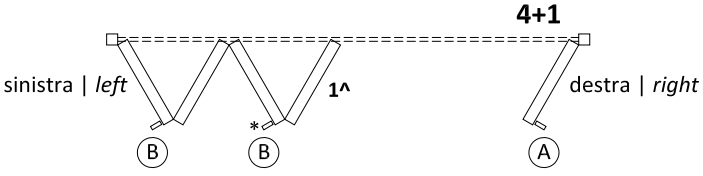
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	1	Kit cremonese | *Cremone bolt*
B	AC 2624.S	2	Kit cremonese | *Cremone bolt*

4+1



	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	2	Kit cremonese | *Cremone bolt*
B	AC 2624.S	1	Kit cremonese | *Cremone bolt*

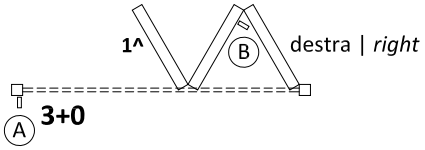
4+1



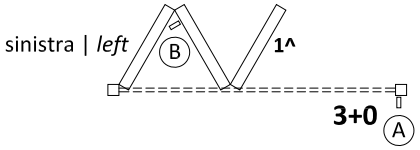
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2624.D	1	Kit cremonese | *Cremone bolt*
B	AC 2624.S	2	Kit cremonese | *Cremone bolt*

* si rende necessario l'utilizzo della maniglia ACV751 | *is necessary to use the handle ACV751*

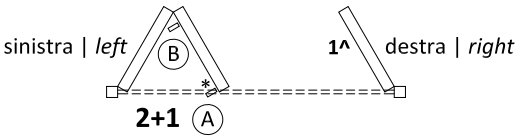
apertura ESTERNA
OUTWARD opening



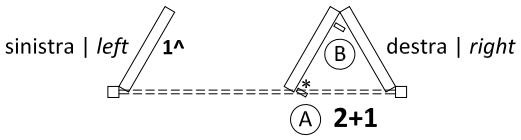
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.D	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.D	1	Kit cremonese | *Cremone bolt*



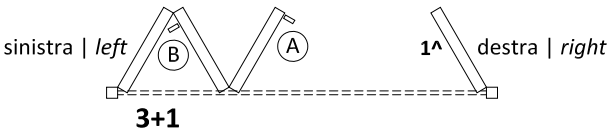
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.S	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.S	1	Kit cremonese | *Cremone bolt*



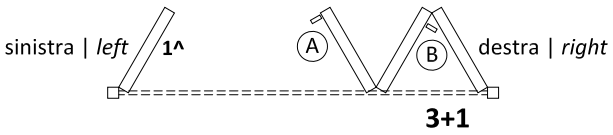
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.S	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.S	1	Kit cremonese | *Cremone bolt*



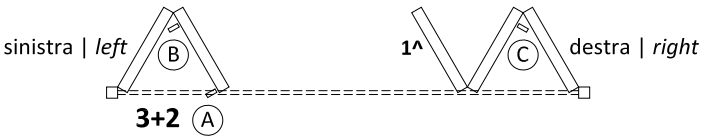
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.D	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.D	1	Kit cremonese | *Cremone bolt*



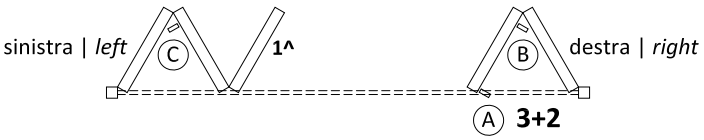
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.S	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.S	1	Kit cremonese | *Cremone bolt*



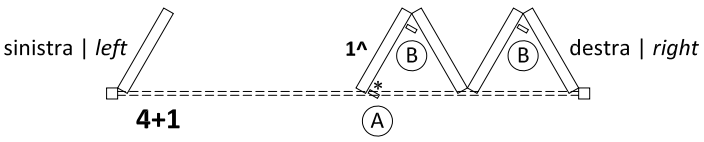
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.D	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.D	1	Kit cremonese | *Cremone bolt*



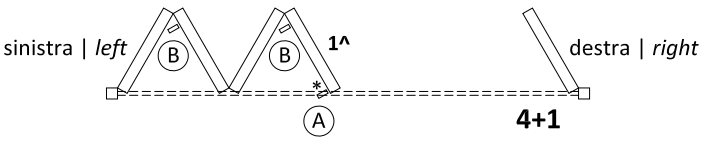
	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.S	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.S	1	Kit cremonese | *Cremone bolt*
C	AC 2684L.D	1	Kit cremonese | *Cremone bolt*



	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.D	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.D	1	Kit cremonese | *Cremone bolt*
C	AC 2684L.S	1	Kit cremonese | *Cremone bolt*



	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.D	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.D	2	Kit cremonese | *Cremone bolt*



	Codice | *Code*	nr.	Descrizione | *Description*
A	AC 2683.S	1	Kit cremonese | *Cremone bolt*
B	AC 2684L.S	2	Kit cremonese | *Cremone bolt*

* si rende necessario l'utilizzo della maniglia ACV751 | *is necessary to use the handle ACV751*
NOTE il kit AC2684L.D-S richiede la maniglia ACV761 | *kit AC2684L.D-S requires handle ACV761*

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
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
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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