

BV 75

CATALOGO TECNICO TECHNICAL CATALOGUE

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

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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione in vista 47 mm (nodo laterale) e 62 mm (nodo centrale), idoneo per la realizzazione di porte e finestre a 2 ante, rettangolari, sagomate o curve con o senza fissi laterali e superiori, con apertura verso l'interno, ad anta semplice, anta ribalta o vasistas, o con apertura verso l'esterno ad anta semplice o a sporgere.

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 poliuretana 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 la 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 3 livelli di tenuta con guarnizione di giunto aperto e 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 completo di accessori 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;

Paraspifferi inferiori con guarnizione a pinna, e soglia inferiore per sistema porte.

Thermally insulated integrated system of profiles, accessories and gaskets with visible section of 47 mm (lateral section) and 62 mm (central section) suitable for rectangular, trapezoidal, arched shaped double leafed doors and windows for door and window with or without fixed side light; inward opening, casement or tilt and turn or bottom hung, and outward opening, casement or top hung.

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 3 barriers of tightness with central gasket and 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 complete of accessories for water drain ;

Concealed hardware for side-hung windows ;

Complete kit for lock with coverings in the same material of the profile ;

Special drop down seal with fin and threshold for door system.

PRESTAZIONI

Sistema finestre

Trasmittanza termica (EN ISO 10077-2)

- Nodo tipo: $U_f = 2.50 \text{ W/m}^2\text{K}$

Isolamento acustico (DIN 52210 / DIN EN ISO 717-1)

- Fino a 45 dB

Resistenza all'aria (DIN EN 12207)

- Fino a Classe 4

Resistenza all'acqua (DIN EN 12208)

- Fino a Classe 9A

Resistenza al vento (DIN EN 12210)

- Fino a Classe C5

Prova di durata a cicli di apertura (DIN EN 1197-12400)

- Fino a Classe 2 - 10.000 cicli

PERFORMANCES

Windows system

Thermal transmittance (EN ISO 10077-2)

- Typical section: $U_f = 2.50 \text{ W/m}^2\text{K}$

Acoustic performance (DIN 52210 / DIN EN ISO 717-1)

- Up to 45 dB

Air permeability (DIN EN 12207)

- Up to Class 4

Watertightness (DIN EN 12208)

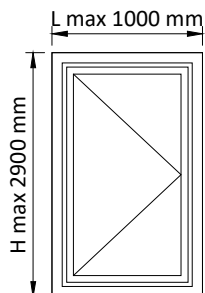
- Up to Class 9A

Resistance to wind load (DIN EN 12210)

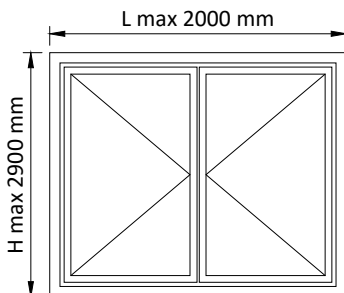
- Up to Class C5

Resistance to repeated opening and closing (DIN EN 1197-12400)

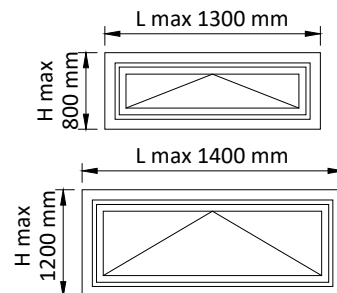
- Up to Class 2 - 10 000 opening and closing

Limiti dimensionali - Maximum dimensionfinestra ad un anta apertura INTERNA
one-leaf INWARD opening windowspeso massimo anta*
maximum leaf weight*

AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg
AC2648	- 100 kg**
ACB648	- 80 kg
AC2649	- 50 kg

finestra a due ante apertura INTERNA
two-leaf INWARD opening windowspeso massimo anta*
maximum leaf weight*

AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg
AC2648	- 100 kg**
ACB648	- 80 kg
AC2649	- 50 kg

finestra vasistas apertura INTERNA
bottom-hung windowpeso massimo anta*
maximum leaf weight*

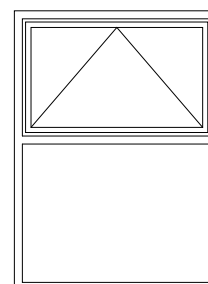
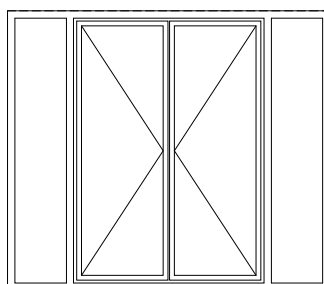
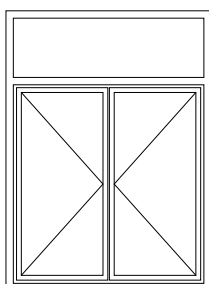
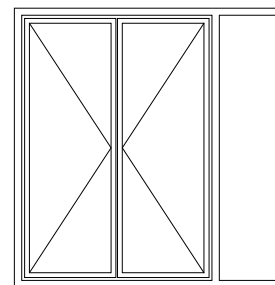
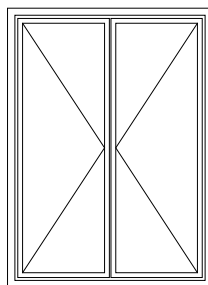
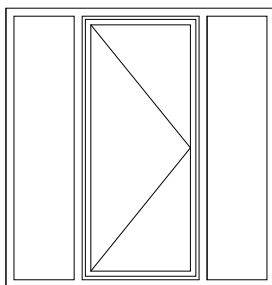
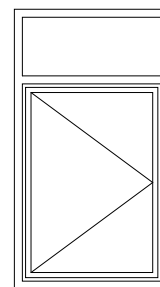
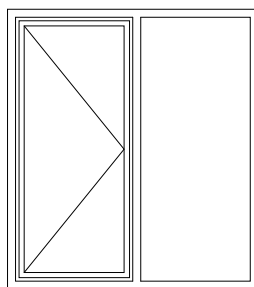
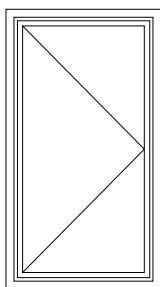
AC2631/A	- 40 kg
AC2631/B	- 40 kg
AC2632/B	- 40 kg
AG2524	- 70 kg
AG2580	- 70 kg

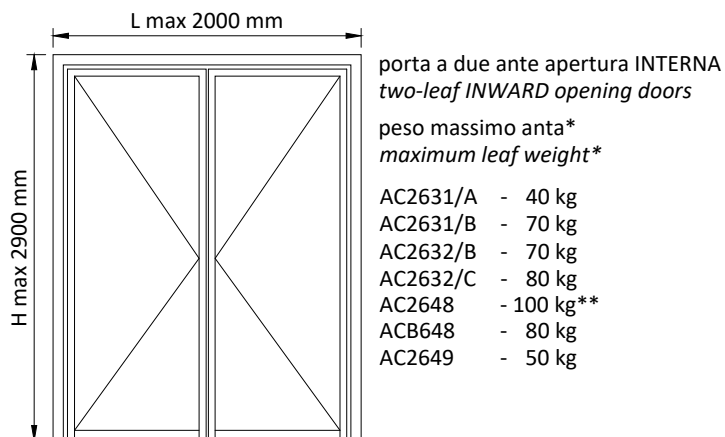
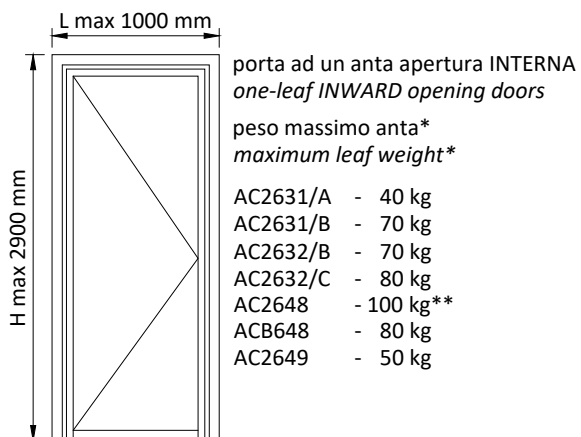
* cerniera aggiuntiva per H serramento > 1300 mm

* additional hinge for windows with height > 1300 mm

** fino a 130 kg con cerniera aggiuntiva superiore (vedi pag. applicazione cerniera)

** up to 130 kg with additional hinge (see hinge application page)

Esempi tipologie realizzabili - Types of windows

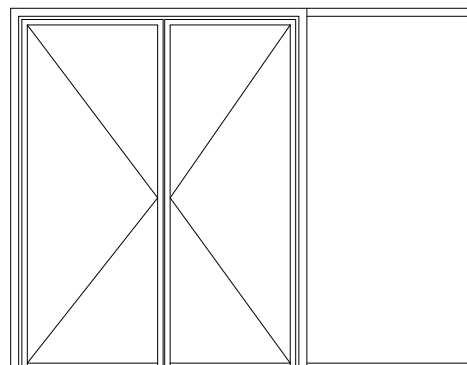
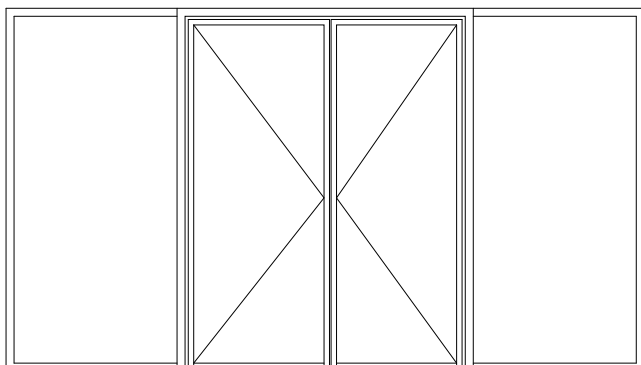
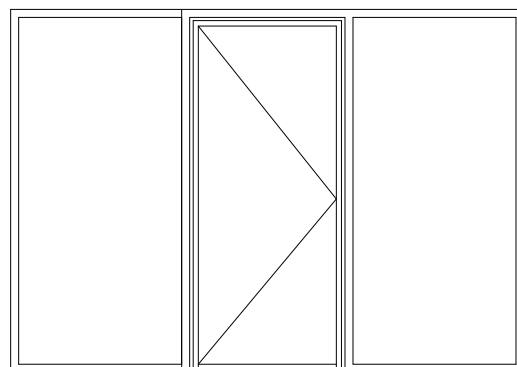
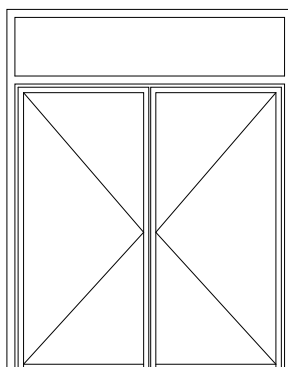
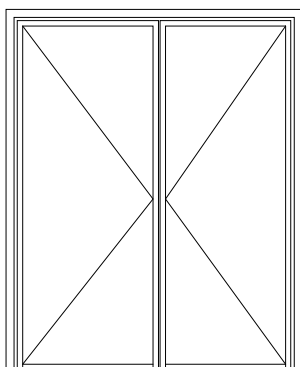
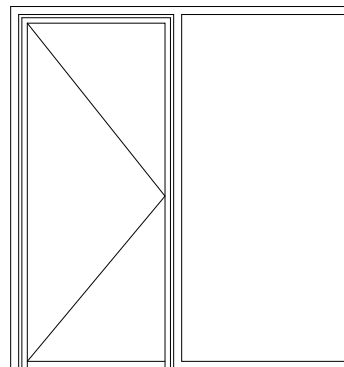
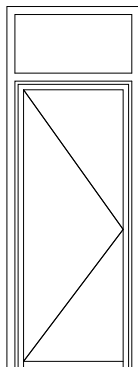
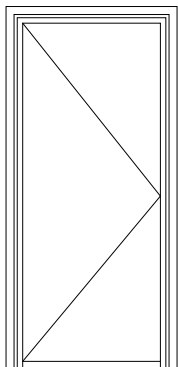
Limiti dimensionali - Maximum dimension

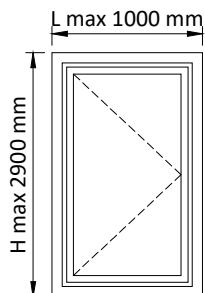
* cerniera aggiuntiva per H serramento > 2300 mm

* *additional hinge for windows with height > 2300 mm*

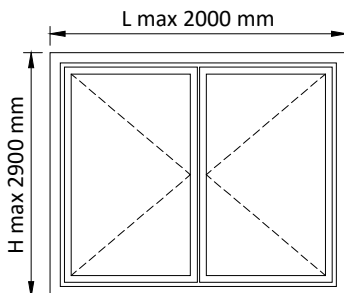
** fino a 130 kg con cerniera aggiuntiva superiore (vedi pag. applicazione cerniera)

** *up to 130 kg with additional hinge (see hinge application page)*

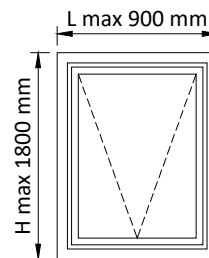
Esempi tipologie realizzabili - Types of door

Limiti dimensionali - Maximum dimensionfinestra ad un anta apertura ESTERNA
one-leaf OUTWARD opening windowspeso massimo anta*
maximum leaf weight*

AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg
AC2648	- 100 kg**
ACB648	- 80 kg
AC2649	- 50 kg

finestra a due ante apertura ESTERNA
two-leaf OUTWARD opening windowspeso massimo anta*
maximum leaf weight*

AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg
AC2648	- 100 kg**
ACB648	- 80 kg
AC2649	- 50 kg

finestra a sporgere apertura ESTERNA
awning windowpeso massimo anta*
maximum leaf weight*

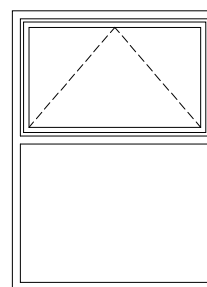
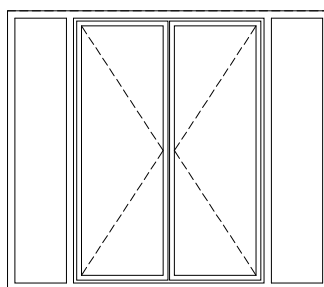
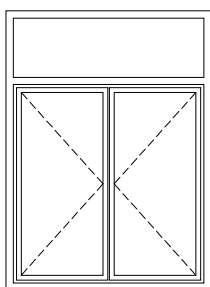
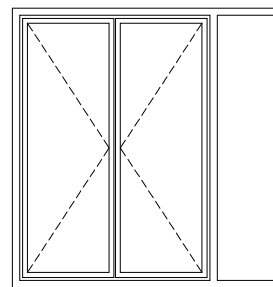
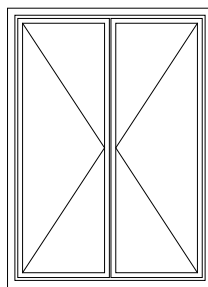
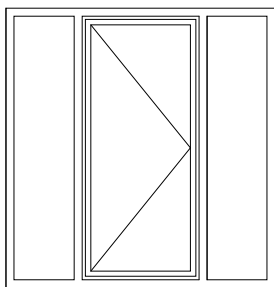
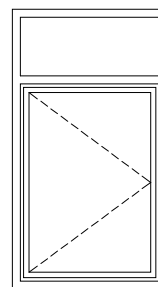
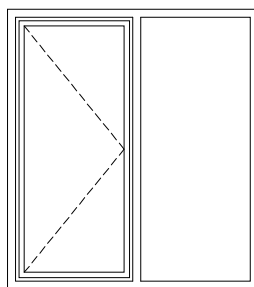
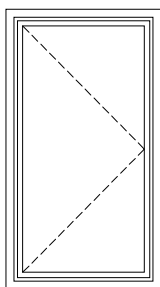
AC2631/A	- 40 kg
AC2631/B	- 40 kg
AC2632/B	- 40 kg
AC2648	- 40 kg
AC2649	- 40 kg
AC2688	- 100 kg
AC2689	- 40 kg

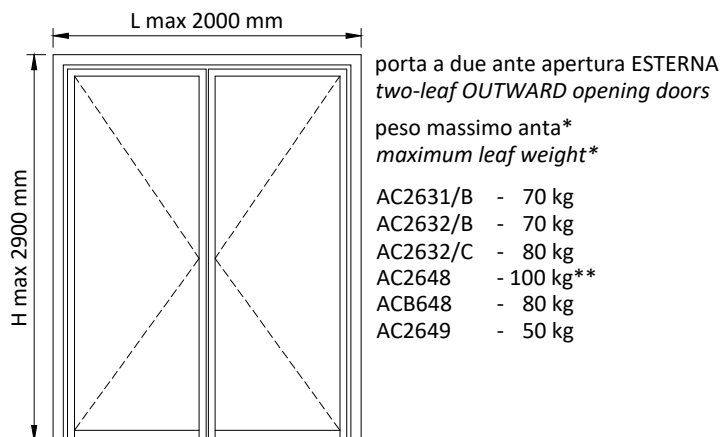
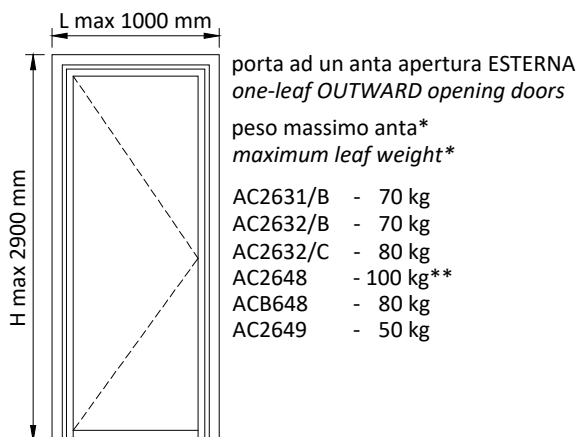
* cerniera aggiuntiva per H serramento > 1300 mm

* additional hinge for windows with height > 1300 mm

** fino a 130 kg con cerniera aggiuntiva superiore (vedi pag. applicazione cerniera)

** up to 130 kg with additional hinge (see hinge application page)

Esempi tipologie realizzabili - Types of windows

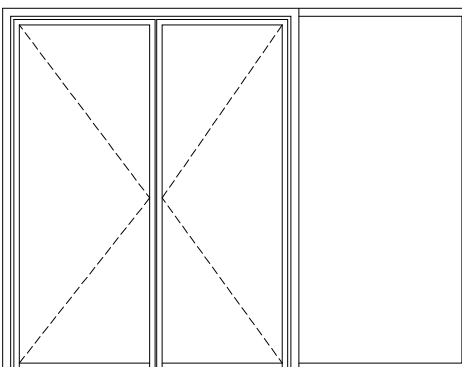
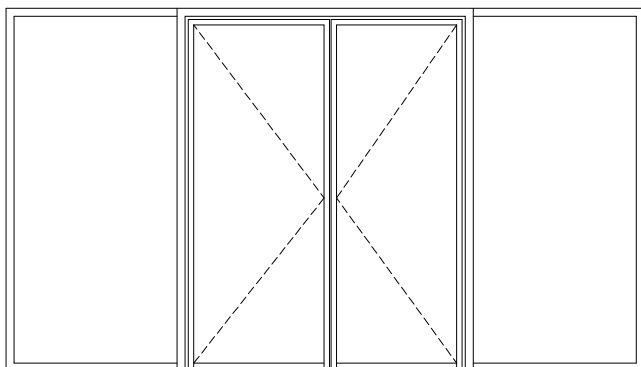
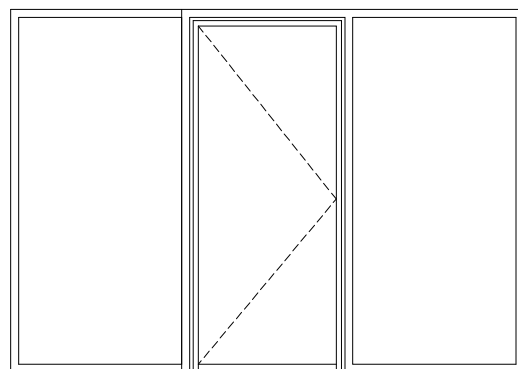
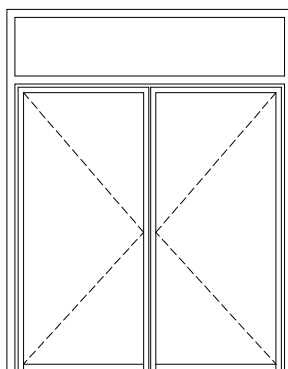
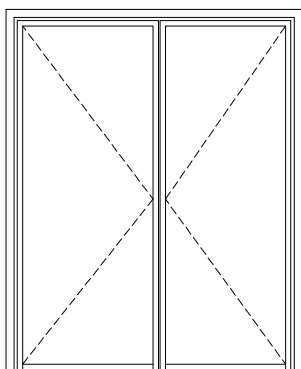
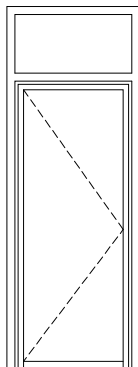
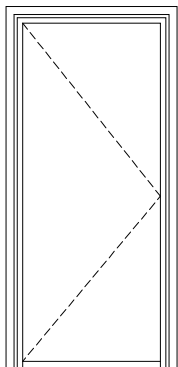
Limiti dimensionali - Maximum dimension

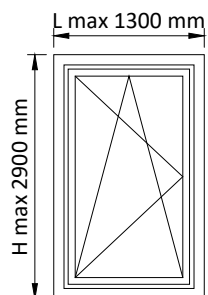
* cerniera aggiuntiva per H serramento > 2300 mm

* *additional hinge for windows with height > 2300 mm*

** fino a 130 kg con cerniera aggiuntiva superiore (vedi pag. applicazione cerniera)

** *up to 130 kg with additional hinge (see hinge application page)*

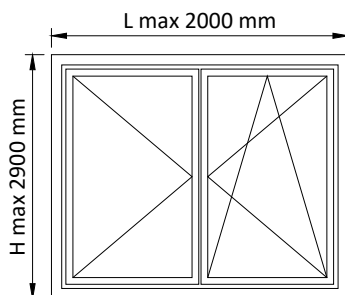
Esempi tipologie realizzabili - Types of door

Limiti dimensionali - Maximum dimension

finestra ad un anta
one-leaf opening windows

peso massimo anta
maximum leaf weight

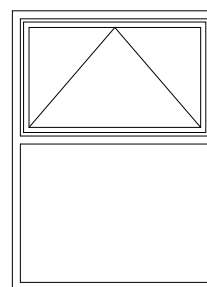
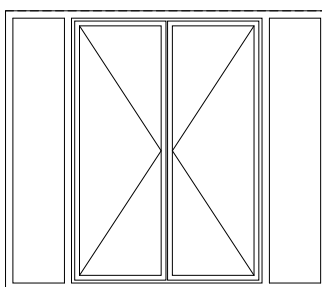
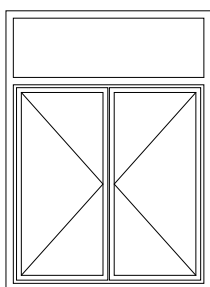
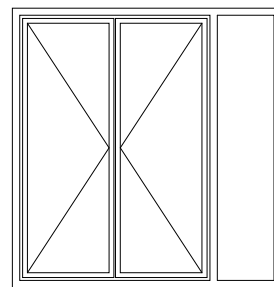
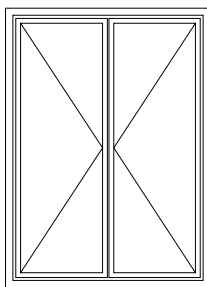
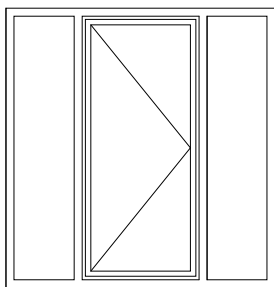
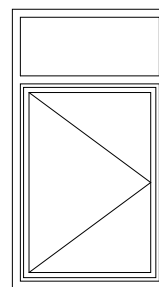
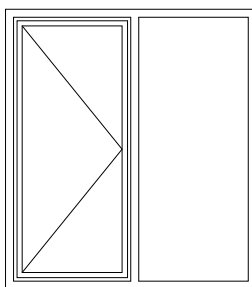
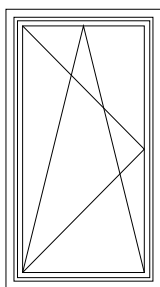
AGE581-2 - 130 kg Easy

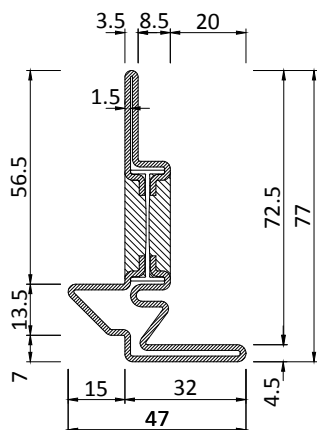


finestra a due ante
two-leaf opening windows

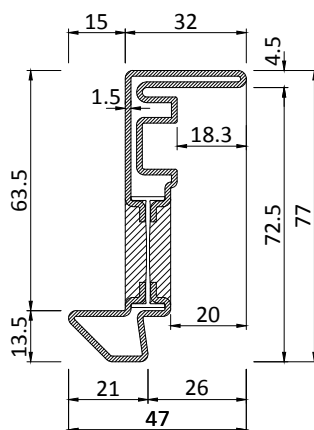
peso massimo anta
maximum leaf weight

AGE581-2-5-6 - 130 kg Easy

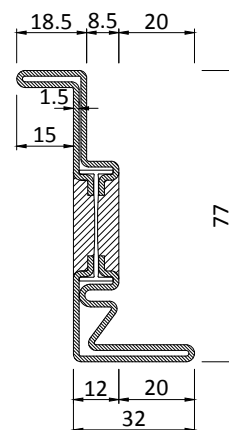
Esempi tipologie realizzabili - Types of window



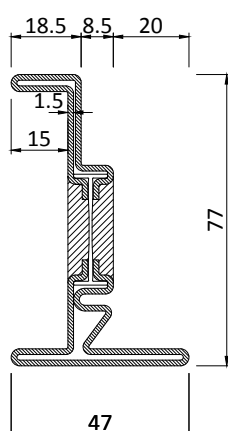
PR2542BV



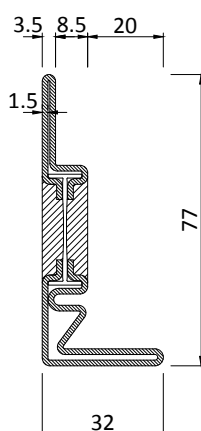
PR2543BV



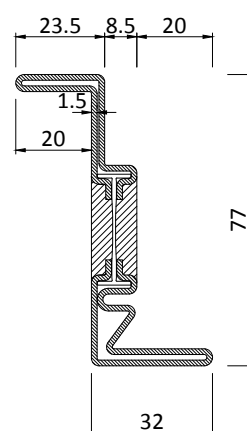
PR2503



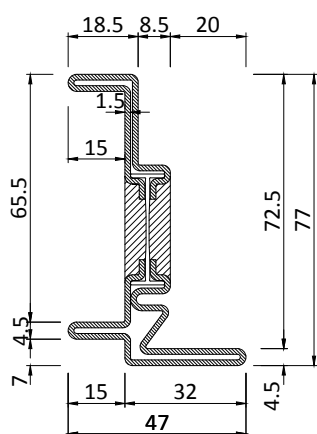
PR2505



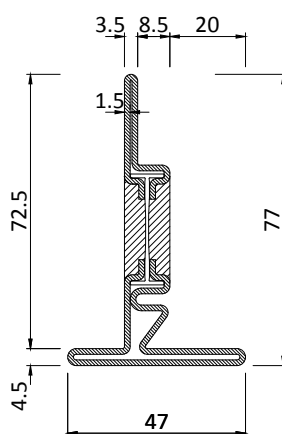
PR2511



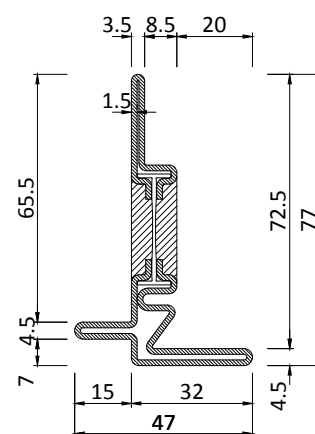
PR2513



PR2515



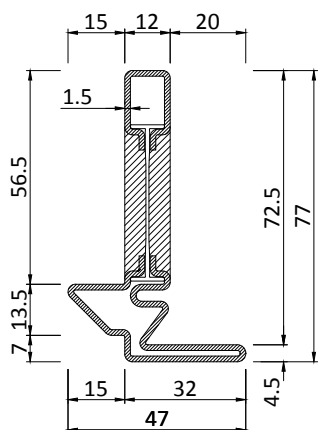
PR2522



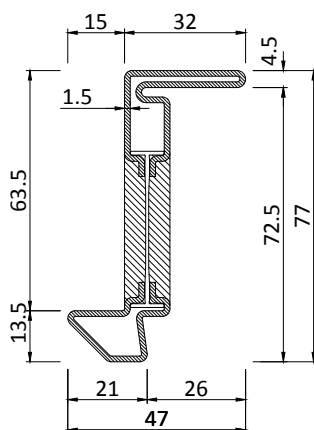
PR2542

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2542BV	3,03	3,26	0,24	15,91	3,08	6,0
PR2543BV	3,18	3,41	0,25	20,38	2,97	6,0
PR2503	2,98	3,20	0,26	21,06	2,77	6,0
PR2505	3,30	3,55	0,29	23,36	3,71	6,0
PR2511	2,66	2,86	0,23	15,34	1,94	6,0

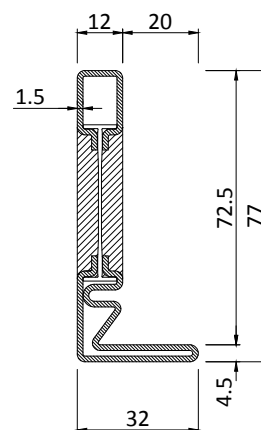
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2513	3,10	3,33	0,26	23,03	3,49	6,0
PR2515	3,26	3,51	0,29	22,20	3,61	6,0
PR2522	2,98	3,21	0,26	17,00	3,00	6,0
PR2542	2,94	3,17	0,26	16,03	2,91	6,0



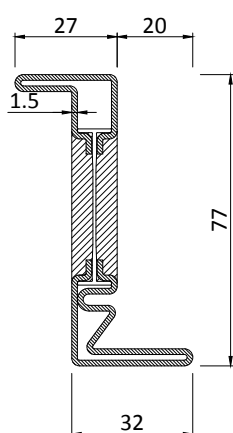
PR2942BV



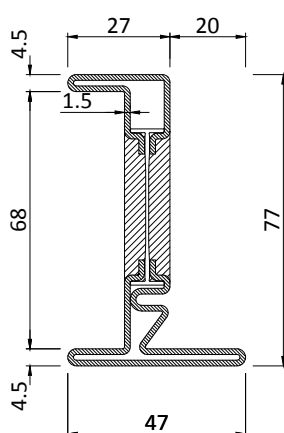
PR2943BV



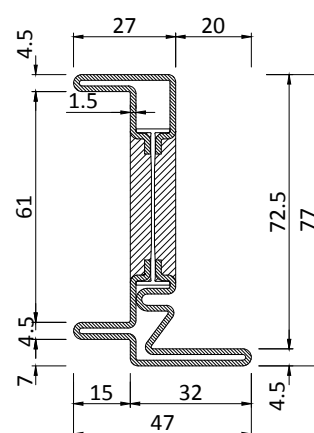
PR2901



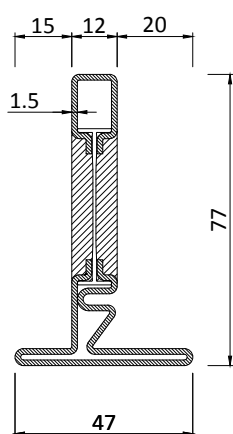
PR2903



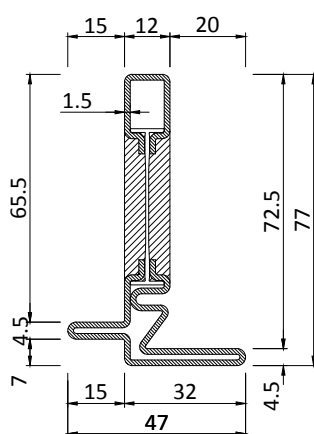
PR2905



PR2915



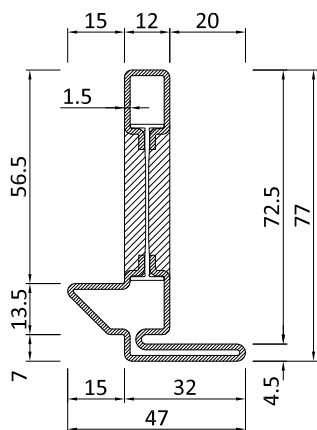
PR2922



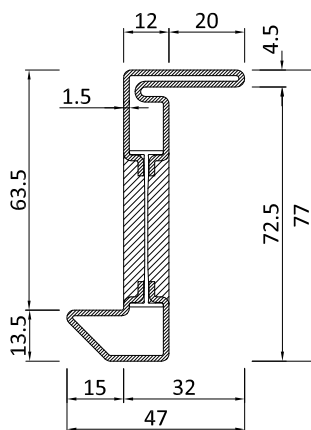
PR2942

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2942BV	2,90	3,10	0,24	17,24	3,05	6,0
PR2943BV	2,80	3,00	0,23	19,73	2,81	6,0
PR2901	2,53	2,70	0,23	17,03	1,78	6,0
PR2903	2,87	3,07	0,25	22,40	2,80	6,0

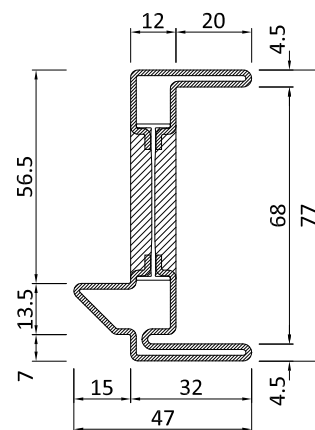
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2905	3,19	3,42	0,29	24,76	3,80	6,0
PR2915	3,15	3,38	0,29	23,60	3,70	6,0
PR2922	2,85	3,05	0,26	18,70	2,97	6,0
PR2942	2,81	3,01	0,26	17,75	2,87	6,0



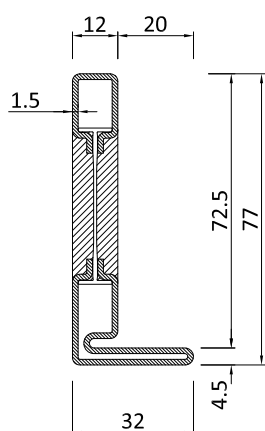
PR2962BV



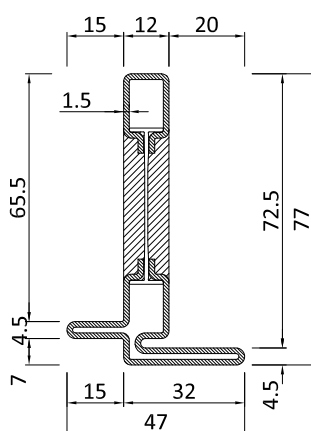
PR2963BV



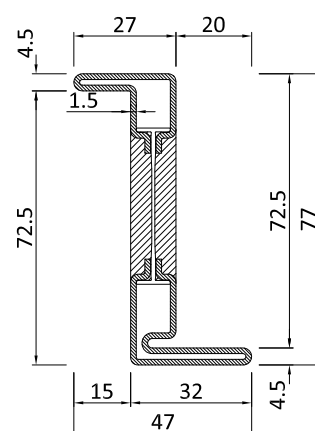
PR2968BV



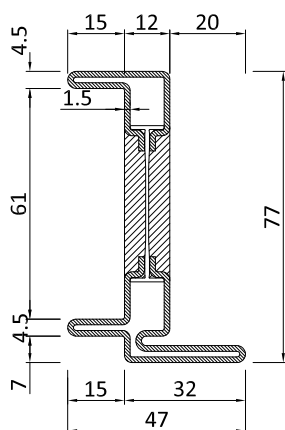
PR2961



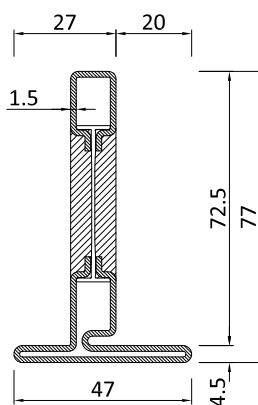
PR2962



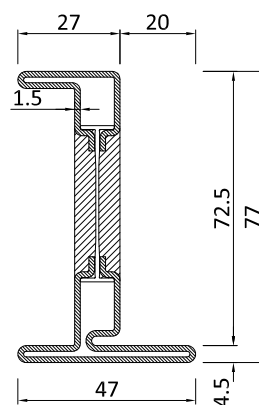
PR2963



PR2965

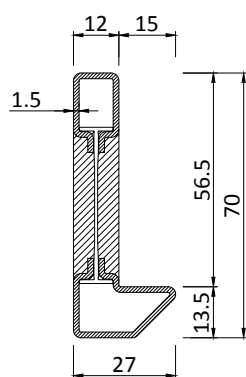


PR2982

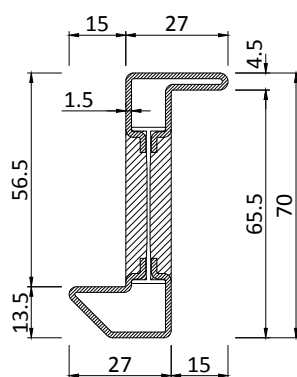


PR2985

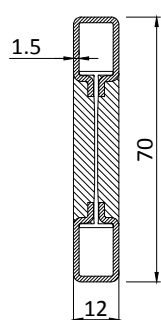
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
PR2962BV	2,78	2,97	0,24	17,36	3,05	6,0	PR2963	2,80	2,99	0,25	22,53	2,79	6,0
PR2963BV	2,80	2,99	0,24	20,35	2,87	6,0	PR2965	3,07	3,29	0,28	23,73	3,82	6,0
PR2968BV	3,24	3,48	0,37	24,42	4,30	3,0	PR2982	2,78	2,97	0,25	18,82	2,98	6,0
PR2961	2,46	2,62	0,22	17,17	1,74	6,0	PR2985	3,12	3,34	0,28	24,91	4,42	6,0
PR2962	2,73	2,92	0,25	17,89	2,97	6,0							



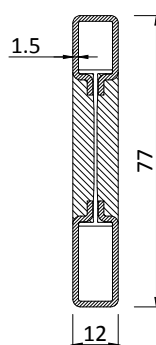
PR2971BV



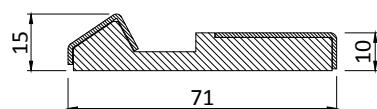
PR2973BV



PR2930

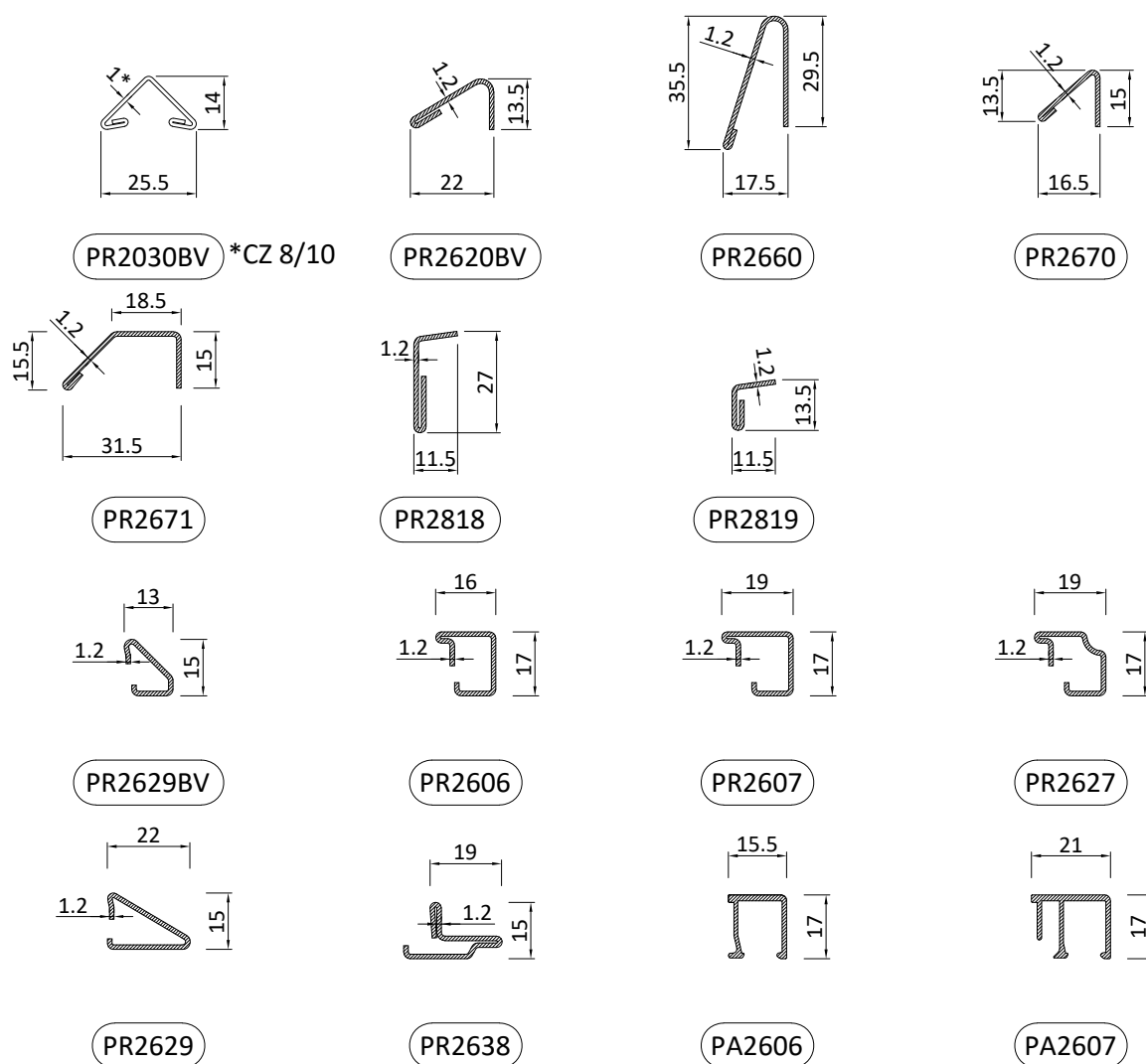


PR2931



PR1130

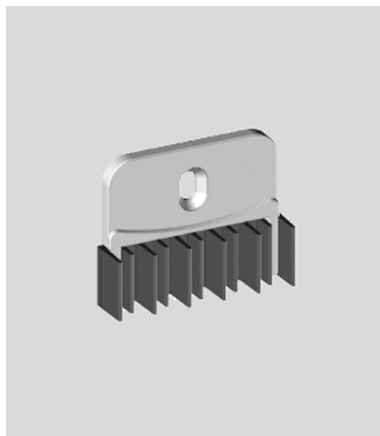
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
PR2971BV	2,02	2,45	0,18	11,15	1,09	6,0							
PR2973BV	2,36	2,52	0,21	14,62	2,07	6,0							
PR2930	1,67	1,77	0,16	9,70	0,31	6,0							
PR2931	1,84	1,95	0,17	12,37	0,36	6,0							
PR1130	1,64	1,71	0,16			3,0							



MATERIALE | MATERIAL

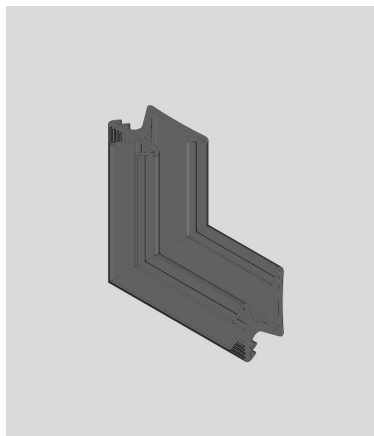
- PR ---- ZN acciaio zincato | *galvanized steel*
- PR ---- CZ acciaio corten grezzo | *untreated corten steel*
- PR ---- SB acciaio inox scotch brite | *stainless steel scotch brite*
- PR ---- BR ottone grezzo | *untreated brass*

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / 1 - CT	OT						ZN / 1 - CT	OT				
PR2030BV	0,46	0,52				4,0	PR2606	0,48	0,52				6,0
PR2620BV	0,24	0,27				4,0	PR2607	0,51	0,55				6,0
PR2660	0,73	0,79				4,0	PR2627	0,47	0,51				6,0
PR2670	0,40	0,43				4,0	PR2629	0,49	0,53				6,0
PR2671	0,50	0,59				4,0	PR2638	0,60	0,68				6,0
PR2818	0,48	0,52				4,0	PA2606	0,17	Alluminio				6,0
PR2819	0,28	0,31				6,0	PA2607	0,23	Alluminio				6,0
PR2629BV	0,34	0,37				6,0							

**AC1081T**

Accessorio di battuta su profilo
soglia PR1130

*Stop accessory on PR1130
threshold profile*

**AC2617NG**

Guarnizione d'angolo
vulcanizzata per GE 2603

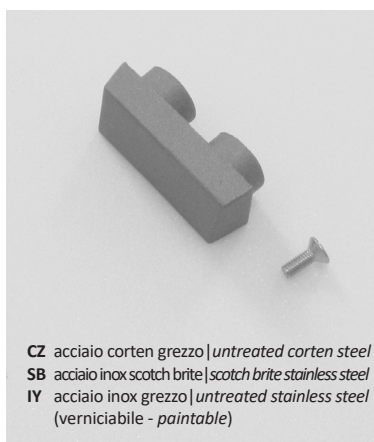
*Vulcanised corner gasket
for GE 2603*

**AC2514.xx**

Kit fondini per profili
PR2542BV - PR2543BV

*Fittings kit for profiles
PR2542BV - PR2543BV*

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

**AC2618.xx**

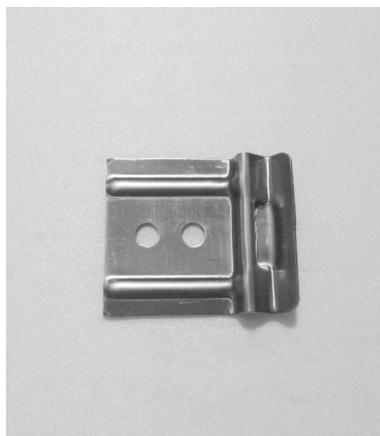
Scarico acqua per aperture
interne in metallo

Metal drip for inward openings

AC2618.NE

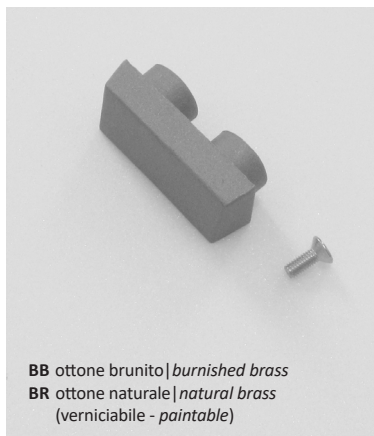
Scarico acqua per aperture
interne in plastica nera
Non verniciabile

*Black plastic drip for inward
openings
Non paintable*

**AC2608**

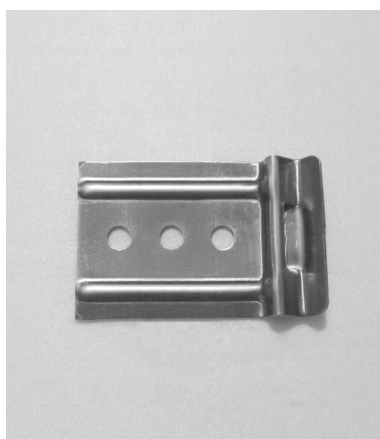
Clips per fissaggio fermavetri
PR2606 - PR2607 - PR2627
PR2629 - PR2638 - PR2629BV

*Clips for securing
PR2606 - PR2607 - PR2627
PR2629 - PR2638 - PR2629BV
glazing beads*

**ACB219.xx**

Scarico acqua per aperture
interne in ottone

Brass drip for inward openings

**AC2608AR**

Clips per fissaggio fermavetri
PR2606 - PR2607 - PR2627
PR2629 - PR2629BV
su profilo PR2522 - PR2542BV -
PR2543BV

*Clips for securing
PR2606 - PR2607 - PR2627
PR2629 - PR2629BV
glazing beads
on PR2522 - PR2542BV -
PR2543BV profiles*

**AC2621G.x**

Catenaccio 2^ anta per
porte/finestre

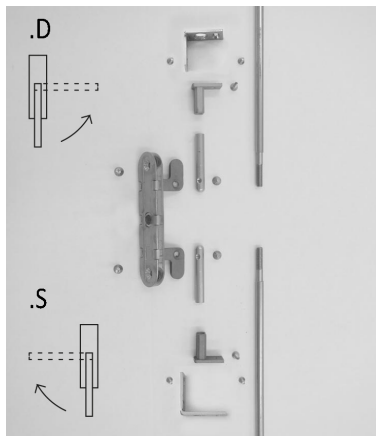
*Second leaf flush bolt for
doors/windows*

A 140 mm
B 220 mm
X 450 mm
C 650 mm
D 850 mm

**AC2622**

Fermo a scatto chiusura 2^a anta per finestra

Snapper for 2nd window leaf

**AC2625E.D**

Kit cremone dx per finestre ad un anta

Gratz con maniglia removibile
RH cremone bolt set for single leaf windows

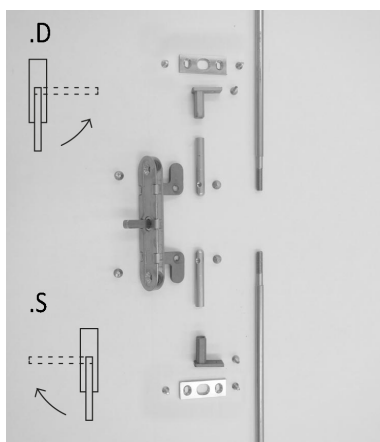
Gratz mechanism with removable handle

AC2625E.S

Kit cremone sx per finestre ad un anta

Gratz con maniglia removibile
LH cremone bolt set for single leaf windows

Gratz mechanism with removable handle

**AC2624.D**

Kit cremone dx per finestre a due ante

RH cremone bolt set for double leaf windows

AC2624.S

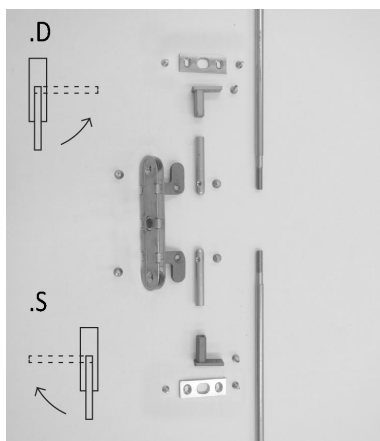
Kit cremone sx per finestre a due ante

LH cremone bolt set for double leaf windows

**AC2626R**

Punto di chiusura aggiuntivo per finestra

Additional locking point for windows

**AC2624E.D**

Kit cremone dx per finestre a due ante

Gratz con maniglia removibile
RH cremone bolt set for double leaf windows

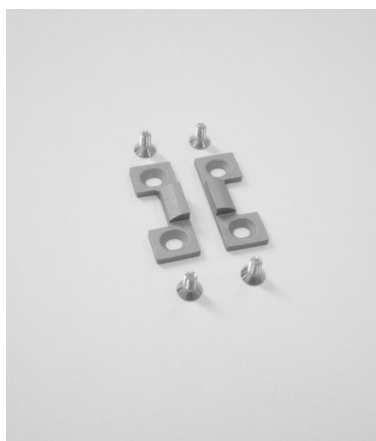
Gratz mechanism with removable handle

AC2624E.S

Kit cremone sx per finestre a due ante

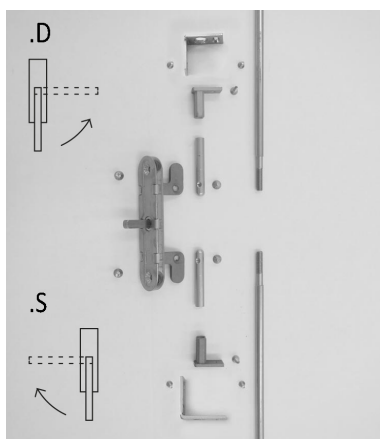
Gratz con maniglia removibile
LH cremone bolt set for double leaf windows

Gratz mechanism with removable handle

**AC2627**

Chiusura mediana lato cerniere

Hinge-side middle closing

**AC2625.D**

Kit cremone dx per finestre ad un anta

RH cremone bolt set for single leaf windows

AC2625.S

Kit cremone sx per finestre ad un anta

LH cremone bolt set for single leaf windows

**AC2631.A**

Cerniera a due ali in acciaio zincato a saldare | Ø 10
Peso max anta 40 kg

Weld-on hinge in galvanised steel | Ø 10
Max leaf weight 40 kg

**AC2631.B**

Cerniera a due ali in acciaio
zincato a saldare | Ø 13
Peso max anta 70 kg

*Weld-on hinge in galvanised
steel | Ø 13
Max leaf weight 70 kg*

**AC2640.xx**

Cricchetto per vasistas

*Finger catch for bottom-hung
windows*

**AC2632.B**

Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 13
Peso max anta 70 kg

*Adjustable weld-on hinge
in galvanised steel | Ø 13
Max leaf weight 70 kg*

**AC2641**

Braccetti per vasistas
Peso max anta 40 Kg

*Stays for bottom-hung windows
Max leaf weight 40 kg*

**AC2632.C**

Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 16
Peso max anta 80 kg

*Adjustable weld-on hinge
in galvanised steel | Ø 16
Max leaf weight 80 kg*

**AC2648.xx**

Cerniera a tre ali da avvitare
su PR2943BV (apertura interna)
su PR2962BV (apertura esterna)
Peso max anta 100 kg

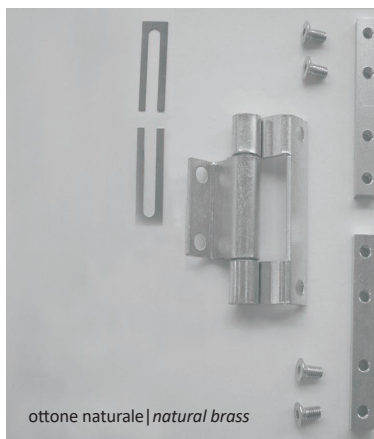
*Three-wing screw-on hinge
on PR2943BV (inward opening)
on PR2962BV (outward opening)
Max leaf weight 100 kg*

**AC2636.x**

Guarnizione automatica di
tenuta sotto porta

Automatic bottom seal

AC2636.Z lunghezza/length 315 - 430 mm
AC2636.A lunghezza/length 380 - 530 mm
AC2636.B lunghezza/length 480 - 630 mm
AC2636.C lunghezza/length 580 - 730 mm
AC2636.D lunghezza/length 680 - 830 mm
AC2636.E lunghezza/length 780 - 930 mm
AC2636.F lunghezza/length 880 - 1030 mm
AC2636.G lunghezza/length 980 - 1130 mm
AC2636.H lunghezza/length 1080 - 1230 mm

**ACB 648.BR**

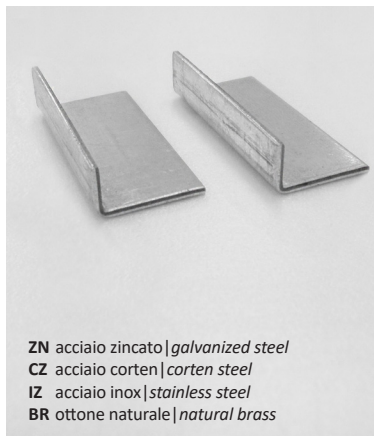
Cerniera in ottone a tre ali da
avvitare
su PR2943BV (apertura interna)
su PR2962BV (apertura esterna)
Peso max anta 80 kg

*Three-wing screw-on brass
hinge
on PR2943BV (inward opening)
on PR2962BV (outward opening)
Max leaf weight 80 kg*

**AC2648R**

Rinforzo cerniera AC2648,
ACB648 e AC2649 su profilo
PR2962BV

*Reinforcement for hinge
AC2648, ACB648 and AC2649 on
PR2962BV profile*

**AC2653.xx**

Kit fondini per profili
PR2962BV - PR2963BV

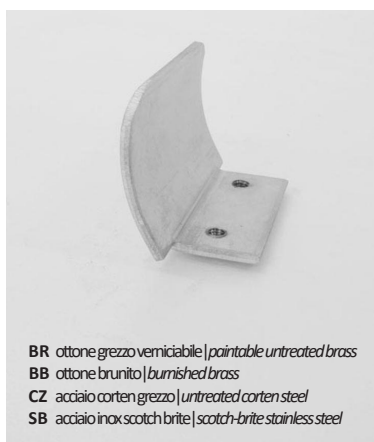
*Fittings kit for profiles
PR2962BV - PR2963BV*

**AC2649.xx.ISED**

Cerniera a due ali da avvitare
Sx su PR2943BV (apertura interna)
Dx su PR2962BV (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
LH on PR2943BV (inward opening)
RH on PR2962BV (outward opening)
Max leaf weight 50 kg*

Scelta verso cerniera pg. 5.3.1
Side hinge choice pg. 5.3.1

**AC2680.xx**

Maniglia di trascinamento
per aperture esterne

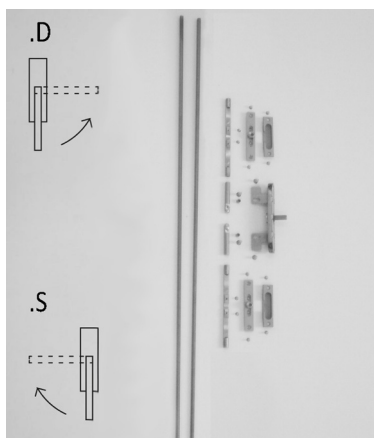
*Pulling handle for outward
opening*

**AC2649.xx.IDES**

Cerniera a due ali da avvitare
Dx su PR2943BV (apertura interna)
Sx su PR2962BV (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
RH on PR2943BV (inward opening)
LH on PR2962BV (outward opening)
Max leaf weight 50 kg*

Scelta verso cerniera pg. 5.3.1
Side hinge choice pg. 5.3.1

**AC2683.D**

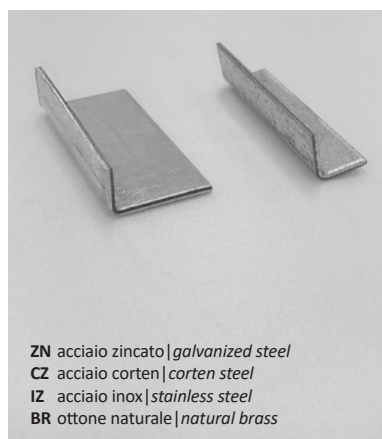
Kit cremonese dx per finestre
ad un anta - apertura esterna

*RH cremonese bolt set for single leaf
windows - outward opening*

AC2683.S

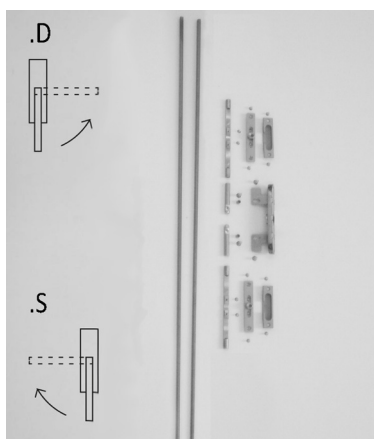
Kit cremonese sx per finestre
ad un anta - apertura esterna

*LH cremonese bolt set for single leaf
windows - outward opening*

**AC2652.xx**

Kit fondini per profili
PR2942BVBV - PR2943BV

*Fittings kit for profiles
PR2942BV - PR2943BV*

**AC2683E.D**

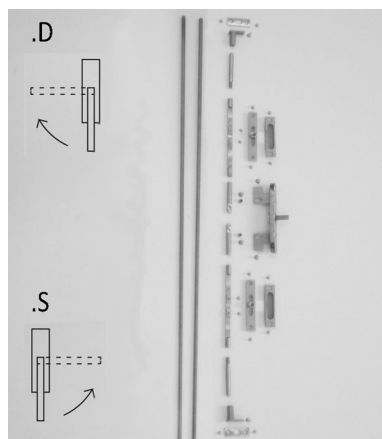
Kit cremonese dx per finestre
ad un anta - apertura esterna
Gratz con maniglia removibile

*RH cremonese bolt set for single leaf
windows - outward opening
Gratz mechanism with removable handle*

AC2683E.S

Kit cremonese sx per finestre
ad un anta - apertura esterna
Gratz con maniglia removibile

*LH cremonese bolt set for single leaf
windows - outward opening
Gratz mechanism with removable handle*

**AC2684.D**

Kit cremonese dx per finestre
a due ante - apertura esterna

*RH cremone bolt set for double
leaf windows - outward opening*

AC2684.S

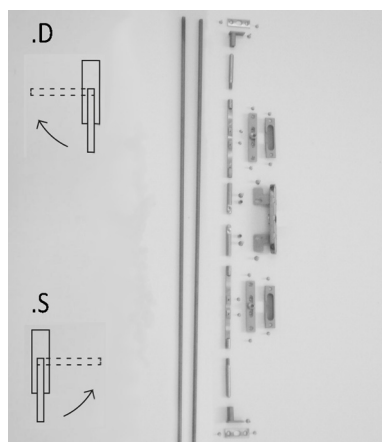
Kit cremonese sx per finestre
a due ante - apertura esterna

*LH cremone bolt set for double leaf
windows - outward opening*

**AC2687**

Braccetto limitatore di apertura
esterna finestra con blocco

*Casement stay
outward opening*

**AC2684E.D**

Kit cremonese dx per finestre
a due ante - apertura esterna
Gratz con maniglia removibile
*RH cremone bolt set for double
leaf windows - outward opening
Gratz mechanism with removable handle*

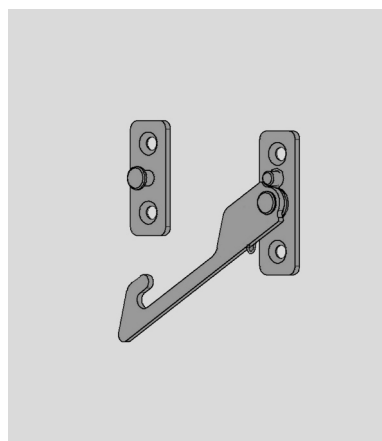
AC2684E.S

Kit cremonese sx per finestre
a due ante - apertura esterna
Gratz con maniglia removibile
*LH cremone bolt set for double leaf
windows - outward opening
Gratz mechanism with removable handle*

**AC2688**

Coppia compassi
apertura a sporgere
Peso massimo anta 100 kg

*Pair of side arms for
awning opening
Max leaf weight 100 kg*

**AC2685.D**

Limitatore di apertura per aereazione
APR interna dx | APR esterna sx

*Window ventilation restrictor
RH inward oPR | LH outward oPR*

AC2685.S

Limitatore di apertura per aereazione
APR interna sx | APR esterna dx

*Window ventilation restrictor
LH inward oPR | RH outward oPR*

**AC2689**

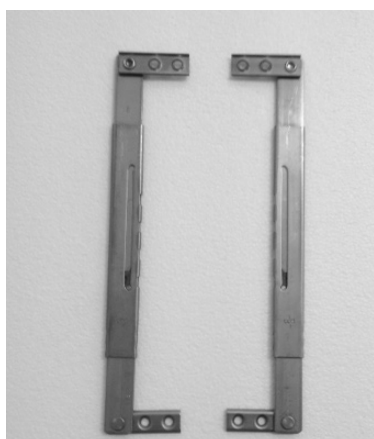
Coppia compassi
apertura a sporgere
Peso massimo anta 40 kg

*Pair of side arms for
awning opening
Max leaf weight 40 kg*

**AC2686**

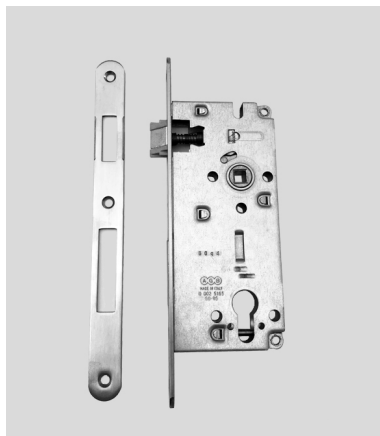
Braccetto limitatore di apertura
frizionato

Window restrictor

**AC2690**

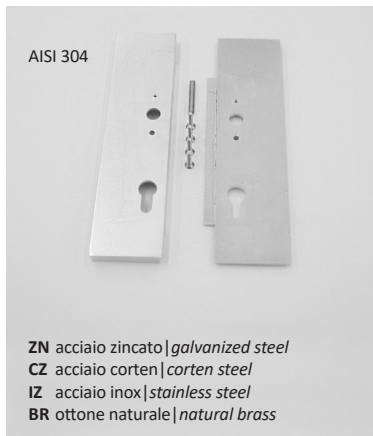
Braccetti limitatori
apertura a sporgere

*Casement stays for
awning opening*

**AC2693**

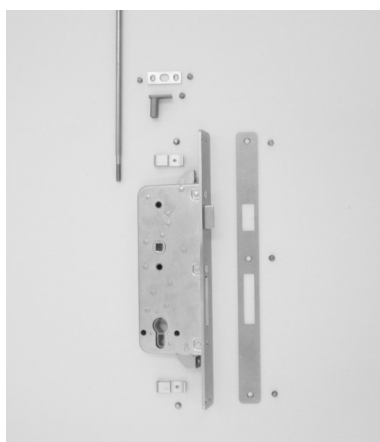
Serratura con scrocco e
catenaccio

Latch and bolt lock

**AC2697.xx**

Scatola copri serratura
Sinistra
per fermavetro
PR2606-PR2607-PR2627
PA2660-PA2670

LH lock cover box
for glazing bead
PR2606-PR2607-PR2627
PA2660-PA2670

**AC2694.D**

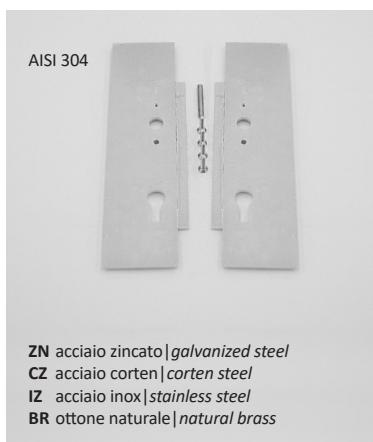
Kit serratura multipunto dx
per porta

RH Multi-lock set for door

AC2694.S

Kit serratura multipunto sx
per porta

LH Multi-lock set for door

**AC2696BV.xx**

Scatola copri serratura
Destra/Sinistra
per fermavetro
PR2629BV

RH/LH lock cover box
for glazing bead
PR2629BV

**AC2695.D**

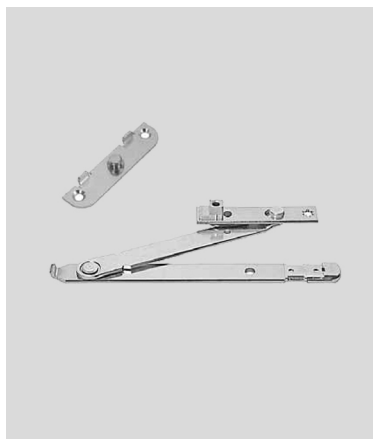
Punto di chiusura aggiuntivo
dx per porta

RH additional locking point for door

AC2695.S

Punto di chiusura aggiuntivo
sx per porta

LH additional locking point for door

**AG1386**

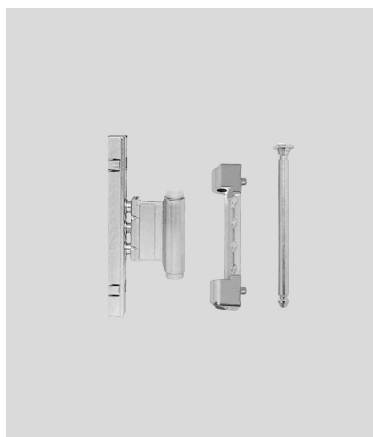
Limitatore di apertura frizionato
per meccanismi A/R a scomparsa
Solo per meccanismi EASY

*Friction stay for tilt-turn
mechanism, concealed hinges
Only for EASY mechanism*

**AC2696.xx**

Scatola copri serratura
Destra
per fermavetro
PR2606-PR2607-PR2627
PA2660-PA2670

RH lock cover box
for glazing bead
PR2606-PR2607-PR2627
PA2660-PA2670

**AG2524**

Cerniera a tre ali ad avvitare per
vasistas con profilo PR2543BV
Peso max anta 70 kg

*Screw-on hinge for bottom-hung
window with PR2543BV profile
Max leaf weight 70 kg*

Solo con profilo telaio PR2513
Only with frame profile PR2513

**AG1224C.xx**

Kit copertine in plastica per
cerniere AG2524

Plastic cover for hinges AG2524

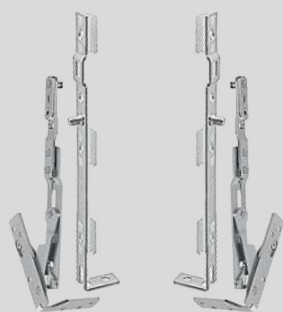
AG1224C.AG argento | *matt silver*
AG1224C.MC marrone | *brown*
AG1224C.BC bronzato chiaro | *light bronze plated*
AG1224C.BO ottonato opaco | *matt brass plated*
AG1224C.OL ottonato lucido | *brass plated*
AG1224C.IS inox | *stainless steel*
AG1224C.NI nichelato | *nickel*
AG1224C.WB bianco RAL 9001 | *white RAL 9001*
AG1224C.WC bianco RAL 9010 | *white RAL 9010*

**CV1242**

Vite trilobata
TPS M4x6

*Thread cutting machine screw
TPS M4x6*

CV1242 acciaio zincato | *galvanized steel*
CV1242I acciaio inox | *stainless steel*

**AG2580**

Coppia di cerniere a scomparsa
per vasitas su profilo PR2543BV
Peso max anta 70 kg

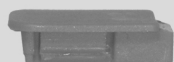
*Pair of concealed hinges for
bottom hung window
on PR2543BV profile
Max leaf weight 70 kg*

**CV1243**

Vite trilobata
TPS M4x8

*Thread cutting machine screw
TPS M4x8*

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

**AG6530**

Limitatore di corsa per
meccanismi A/R

*Opening limiter on tilt&turn
mechanism*

**CV1244**

Vite trilobata
TPS M4x12

*Thread cutting machine screw
TPS M4x12*

CV1244 acciaio zincato | *galvanized steel*
CV1244I acciaio inox | *stainless steel*

**CV1023**

Vite per boccia fermavetri
in alluminio, TPS 4.2x13

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

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

**CV1271**

Vite trilobata
TPS M4x16

*Thread cutting machine screw
TPS M4x16*

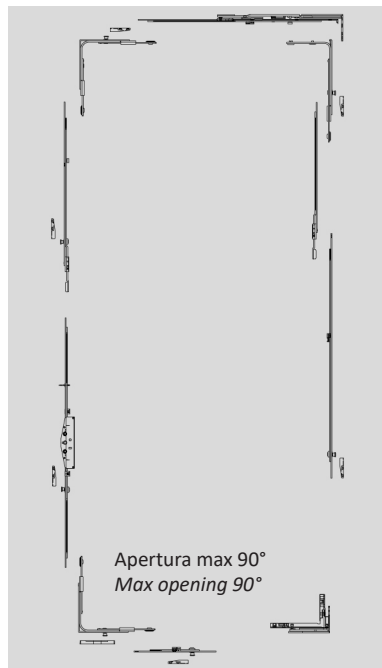
CV1271 acciaio zincato | *galvanized steel*
CV1271I acciaio inox | *stainless steel*

**CV5012**

Boccola per fermavetri in
alluminio

*Bushing for aluminium
glazing bead*

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

**AGE581.xx**

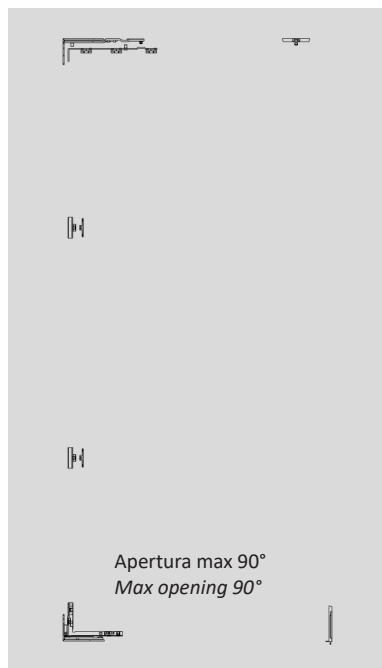
Meccanismo A/R prima anta Dx cerniere a scomparsa

*First leaf RH tilt-turn mechanism with concealed hinges***EASY****AGE582.xx**

Meccanismo A/R prima anta Sx cerniere a scomparsa

*First leaf LH tilt-turn mechanism with concealed hinges***EASY**

		altezza - height								
		670 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	F4	G4	H4	I4

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 130 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AGE585.xx**

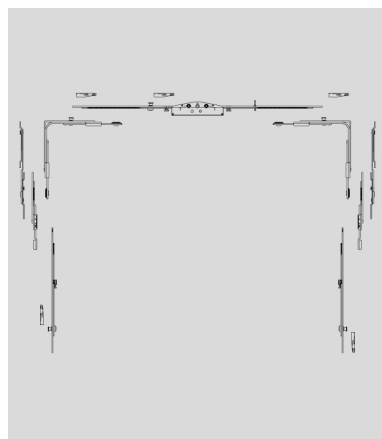
Meccanismo A/R seconda anta Dx cerniere a scomparsa

*Second leaf RH tilt-turn mechanism with concealed hinges***EASY****AGE586.xx**

Meccanismo A/R seconda anta Sx cerniere a scomparsa

*Second leaf LH tilt-turn mechanism with concealed hinges***EASY**

		altezza - height								
		670 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	F4	G4	H4	I4

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 130 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AG2574.xx**

Meccanismo vasistas con cremonese su traverso superiore

*Bottom hung window with cremonese bolt set on the top-rail***EASY**

		altezza - height			
		430 660	661 860	861 1200	1201 1400
larghezza width	670-860	A2	B2	C2	D2
	861-1200	A3	B3	C3	D3

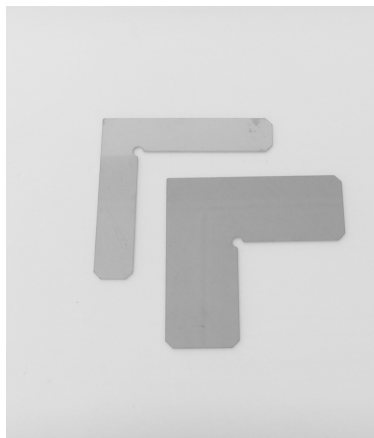
Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 70-100 kg*

**AC2801I**

Kit squadrette allineamento

Alignment bracket set

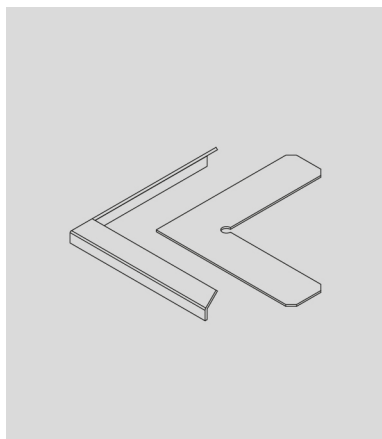
Profili | Profiles
 PR2901 | PR2901 - PR2922
 PR2901 - PR2903 | PR2901 - PR2905
 PR2903 - PR2922 | PR2901 - PR2942
 PR2903 - PR2942 | PR2905 - PR2942
 PR2942 | PR2915 - P2942
 PR2961 | PR2961 - PR2963
 PR2962 - PR2963 telaio | frame

**AC2805I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2905
 PR2985

**AC2803BVR**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2542BV
 PR2542BV - PR2543BV

**AC2805IR**

Kit squadrette allineamento

Alignment bracket set

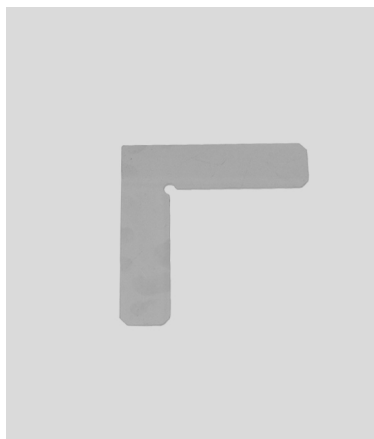
Profili | Profiles
 PR2505

**AC2803I**

Kit squadrette allineamento

Alignment bracket set

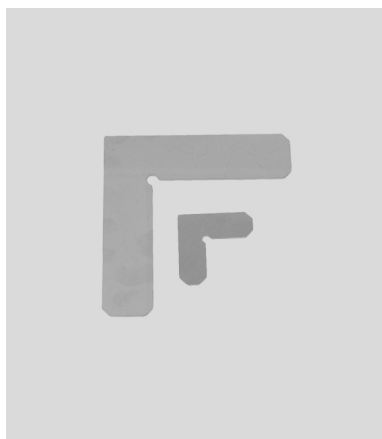
Profili | Profiles
 PR2903
 PR2915
 PR2963
 PR2965 - PR2963

**AC2811IR**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2511

**AC2803IR**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2503 | PR2513 | PR2542

**AC2815IR**

Kit squadrette allineamento

Alignment bracket set

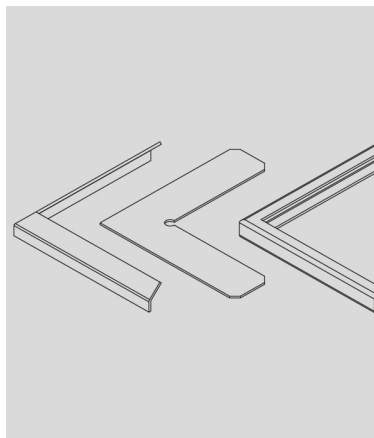
Profili | Profiles
 PR2515

**AC2822I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2922
 PR2905 - PR2922
 PR2982
 PR2985 - PR2982

**AC2843BVR**

Kit squadrette allineamento

Alignment bracket set

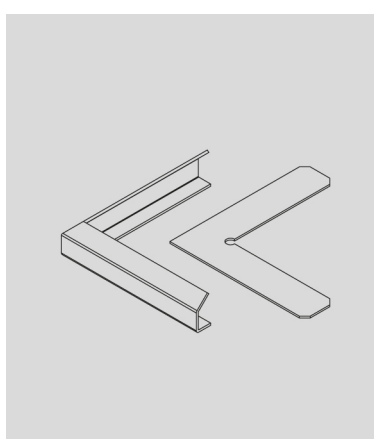
Profili | Profiles
 PR2543BV

**AC2822IR**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2522

**AC2853BV**

Kit squadrette allineamento

Alignment bracket set

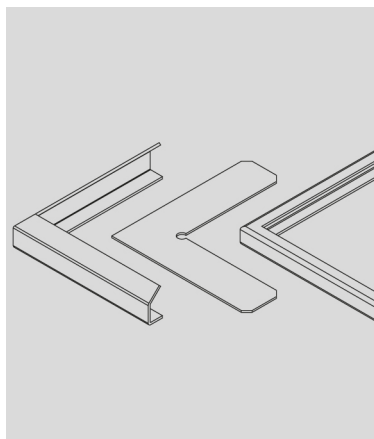
Profili | Profiles
 PR2973BV

**AC2832I**

Kit squadrette allineamento

Alignment bracket set

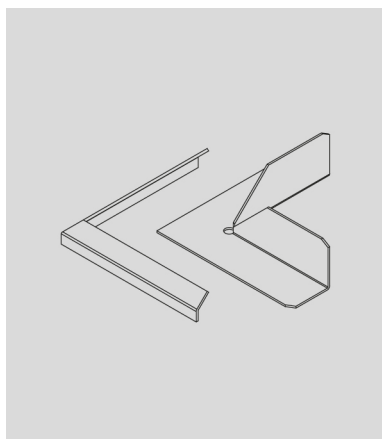
Profili | Profiles
 PR2932 - PR2933
 PR2942 - PR2943
 PR2962 - P2963

**AC2862BV**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2962BV
 PR2962BV - PR2963BV

**AC2843BV**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2943BV
 PR2942BV - PR2943BV

**AC2862I**

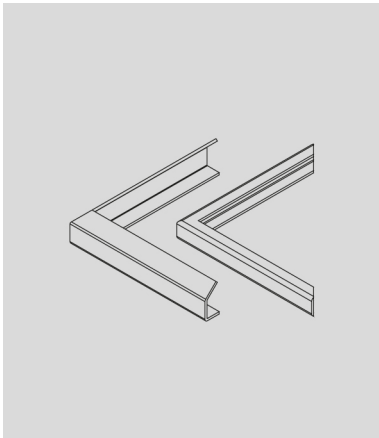
Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 PR2962

**AC2865I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
PR2965**AC2871BV**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
PR2971BV

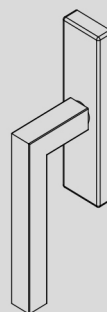


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV673.xx

Copertina per gratz con maniglia
 removibile su kit
 AC2624E | AC2625E
 AC2683E | AC2684E

*Cover for gratz mechanism
 on kit
 AC2624E | AC2625E
 AC2683E | AC2684E*

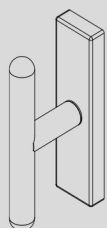


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV872.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
 L | quadra | tronca

*Cremone handle
 medium "VITRUVIO"
 for window
 L | square | cut*

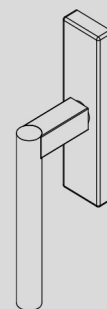


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV776.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
 KIDS

*Cremone handle
 "VITRUVIO" medium
 for window
 KIDS*

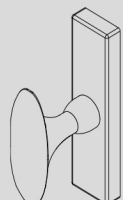


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV873.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
 L | tonda | tronca

*Cremone handle
 medium "VITRUVIO"
 for window
 L | round | cut*

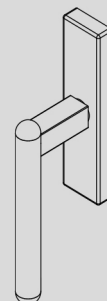


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass

ACV777.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
OVALE

*Cremone handle
 small "VITRUVIO"
 for window
 OVAL*

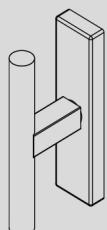


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV874S.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
 L | tonda | sfera

*Cremone handle
 medium "VITRUVIO"
 for window
 L | round | sphere*

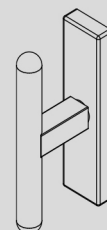


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV871.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
 T | tonda | tronca

*Cremone handle
 medium "VITRUVIO"
 for window
 T | round | cut*



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
 IX acciaio inox brunito | burnished stainless steel

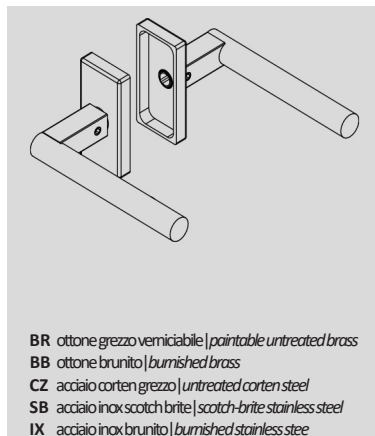
ACV879.xx

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

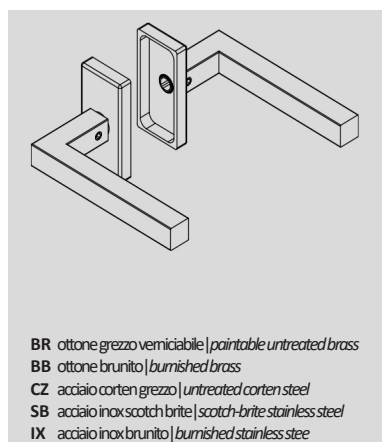
*Cremone handle
 medium "VITRUVIO"
 for window
 T | round | sphere*

**AC2775/1**

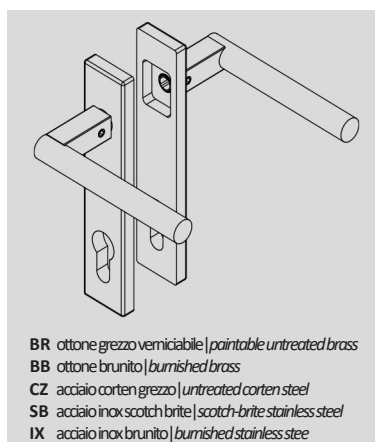
Quadro maniglia

Handle spindle bar**ACV953.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | cut*

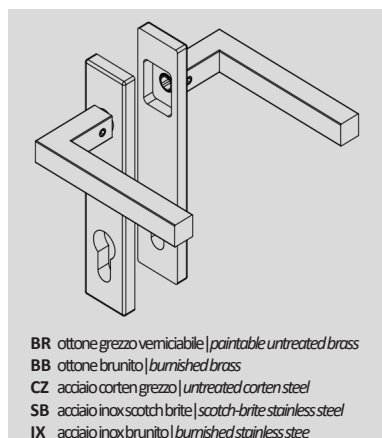
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**ACV952.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | square | cut*

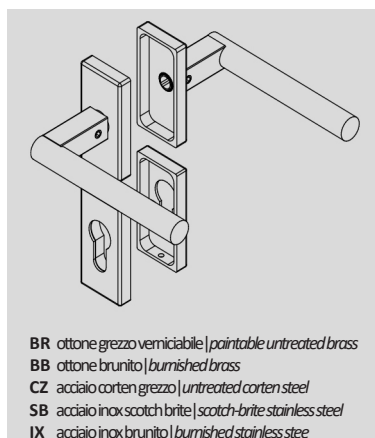
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**ACV953B.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta con copri cilindro
integrato e interasse maniglia
85 mm
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
escutcheon with integrated
cylinder cover and 85 mm
handle spacing
L | round | cut*

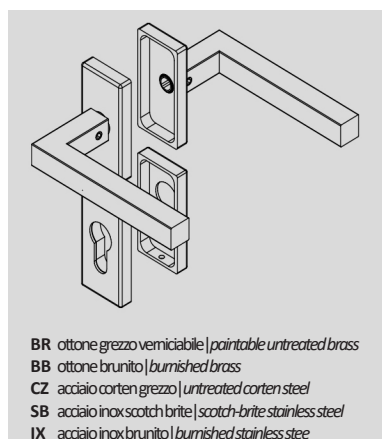
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**ACV952B.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta con copri cilindro
integrato e interasse maniglia
85 mm
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
escutcheon with integrated
cylinder cover and 85 mm
handle spacing
L | square | cut*

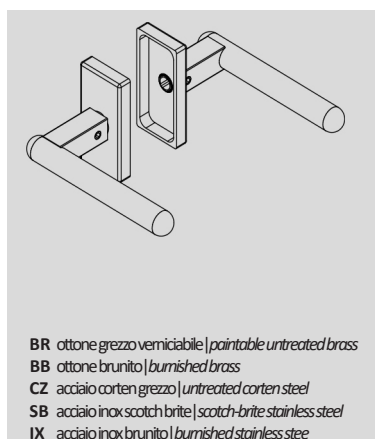
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**ACV953C.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
con copri cilindro
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
with cylinder cover
L | round | cut*

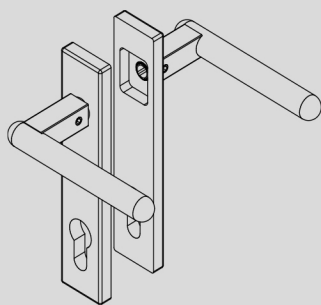
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**ACV952C.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
con copri cilindro
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
with cylinder cover
L | square | cut*

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
 IX acciaio inox brunito | burnished stainless steel

**ACV954S.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | sfera*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | sphere*

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
 IX acciaio inox brunito | burnished stainless steel

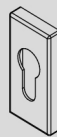


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV954SB.xx

Coppia maniglie per porta
 "VITRUVIO" medium
 bocchetta con copri cilindro
 integrato e interasse maniglia
 85 mm
 L | tonda | sfera

*Double door handlesets
 "VITRUVIO" medium
 escutcheon with integrated
 cylinder cover and 85 mm
 handle spacing
 L | round | sphere*

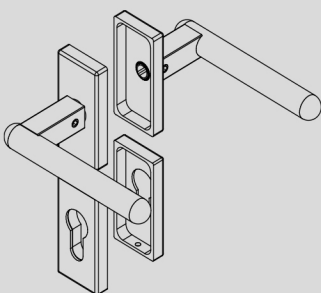


ACV964.xx

Bocchetta copri cilindro a profilo
 europeo

*Euro profile cylinder escutcheon
 plate*

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
 IX acciaio inox brunito | burnished stainless steel

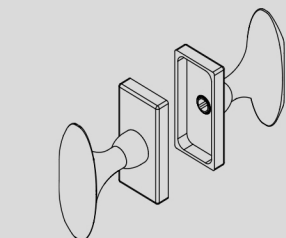


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV954SC.xx

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

*Double door handlesets
 "VITRUVIO" medium
 rectangular escutcheon
 with cylinder cover
 L | round | sphere*

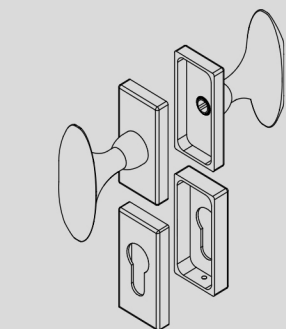


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass

ACV955.xx

Coppia maniglie per porta
 "VITRUVIO"
 bocchetta rettangolare
 OVALE

*Double door handlesets
 "VITRUVIO"
 rectangular escutcheon
 OVAL*



BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass

ACV955C.xx

Coppia maniglie per porta
 "VITRUVIO"
 bocchetta rettangolare
 con copri cilindro
 OVALE

*Double door handlesets
 "VITRUVIO"
 rectangular escutcheon
 with cylinder cover
 OVAL*

**GE1001TT**

Guarnizione di battuta su soglia
per porte

Gasket for treshold on doors

**GE2606**

Guarnizione adesiva esterno
vetro
vedi pg. 5.1.1

*Adhesive weather strip outer
window
see pg. 5.1.2*

**GE1011**

Guarnizione interna vetro
spessore 4 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GE2645TT**

Guarnizione di battuta
interna | esterna

*Internal/external weather
strip*

**GE2543TT**

Guarnizione di battuta
interna

Internal weather strip

**GE2907TT**

Guarnizione sotto vetro

Under glass gasket

**GE2603**

Guarnizione per giunto aperto
Apertura interna

*Weather strip for open joint
Inward opening*

**GP0095**

Guarnizione interna vetro
spessore 3mm

*Internal weather strip for
glazing bead
3 mm thick*

**GU2030E**

Profilo in PVC con biadesivo per
fissaggio dividivetro
PR2030BV

*PVC profile with double-sided
tape for fixing glass divider on
PR2030BV*

**GU2036**

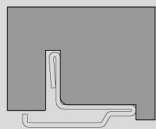
Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

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

**GU2634**

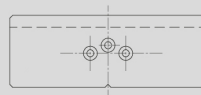
Estruso rigido in PVC per soglia
porte PR1130

*Rigid extruded PVC section for
PR1130 threshold*

**AT2038**

Ganasce di taglio per
PR2638

*Cutting jaws for
PR2638*

**AT2818**

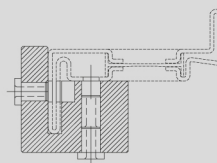
Maschera per esecuzione fori
per applicazione scarico acqua
AC2618 - AC2618NE

*Drill jig for AC2618 - AC2618NE
water drip installation*

**AT2629**

Maschera per esecuzione
fori fissaggio cerniere
AC2649

*Drill jig for
AC2649 hinges*

**AT2825**

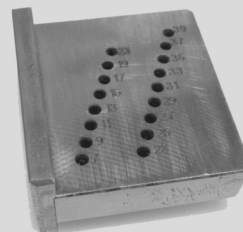
Maschera per applicazione
cremonese AC2624-AC2625
Profilo PR2943BV
e aperture esterne

*Jig for AC2624-AC2625
cremone bolt installation
PR2943BV profile
and outward opening*

**AT2900**

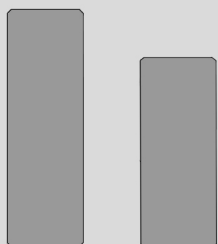
Kit ganasce di taglio sistema
OS2 75

*Kit of cutting jaws for profiles
OS2 75*

**AT2828**

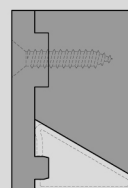
Maschera per esecuzione fori
fissaggio fermavetri

*Drill jig for glazing beads
securing*

**AT2900BV**

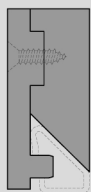
Kit aggiuntivo ganasce di taglio
sistema OS2 75 BV

*Additional kit of cutting jaws for
profiles OS2 75 BV*

**AT2829**

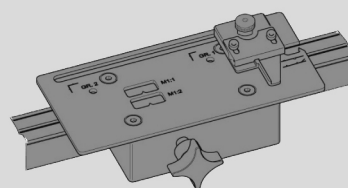
Ganasce di taglio per
fermavetro PR2629

*Kit of cutting jaws
for glazin bead PR2629*

**AT2829BV**

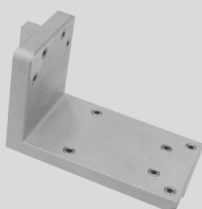
Ganasce di taglio per
fermavetro PR2629BV

*Kit of cutting jaws
for glazing bead PR2629BV*

**ATG313**

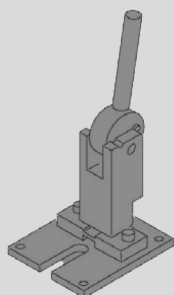
Asta millimetrata per trancia
oleopneumatica

*Rod divided into millimetres for
oil-pneumatic punching machine*

**ATG281**

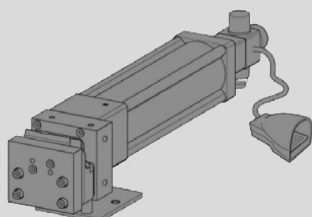
Kit dime per esecuzione fori
montaggio A/R cerniere a
scomparsa

*Template kit for drilling holes
for tilt-turn kit with concealed
hinges*

**ATG311**

Trancia manuale

Manual punching machine

**ATG312**

Trancia oleopneumatica

*Oil-pneumatic punching
machine*

**SA0005.01**

Liquido neritore per brunitura
1 Kg

*Burnishing liquid
1 Kg*

SA0005.10

Liquido neritore per brunitura
10 Kg

*Burnishing liquid
10 Kg*

**SA2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**SA0070.10**

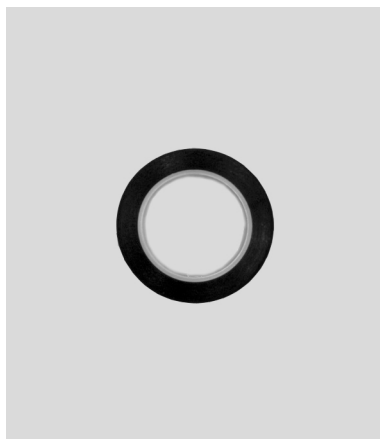
Brunitore per acciaio inox
1 l

*Burnisher for stainless steel
1 l*

**SA2002**

Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA1024**

Nastro adesivo protettivo per
verniciatura
24 mm

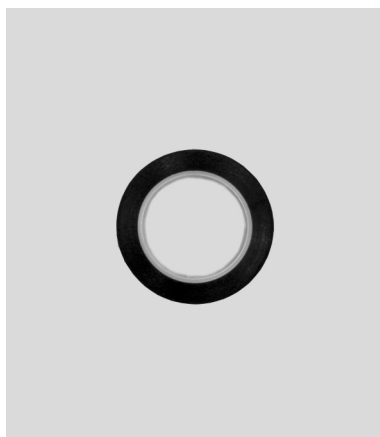
*Adhesive tape for painting
24 mm*

PR25xx

**SA2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA1033**

Nastro adesivo protettivo per
verniciatura
33 mm

*Adhesive tape for painting
33 mm*

PR29xx

**SA2032**

Primer di adesione per profili
verniciati

*Adhesion primer for painted
profiles*

**SA2033**

Liquido di adesione per
materiale plastico

Adhesion liquid for plastic

**SA3004**

Cera d'api liquida per finitura
brunita di ottone e acciaio inox
5 l

*Liquid beeswax for burnished
brass and stainless steel
finishing
5 l*

**SA3001**

Acido per ossidazione corten

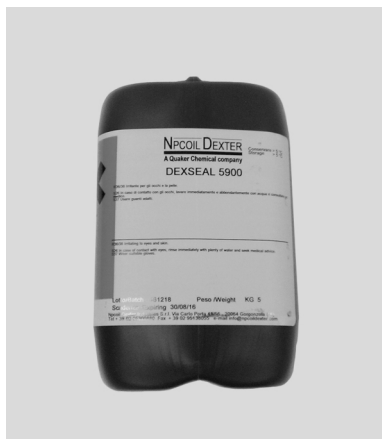
Oxidising acid for corten

**SL0019**

Sigillante a freddo per giunzione
angoli e trasversi

*Cold sealant for corner and
transom joints*

1 kg

**SA3002.05**

Passivante per ossidazione corten
5 kg

*Passivating agent for corten
5 kg*

SA3002.25

Passivante per ossidazione corten
25 kg

*Passivating agent for corten
25 kg*

**SL0021**

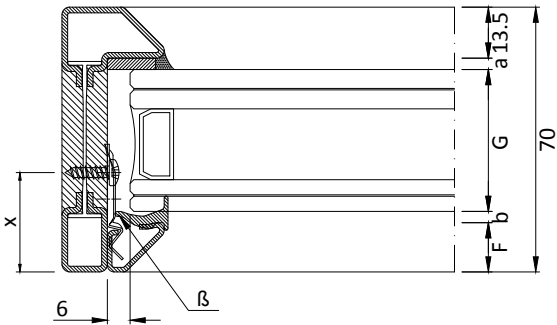
Silicone nero per guarnizioni

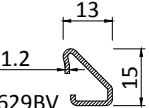
Black silicone for gaskets

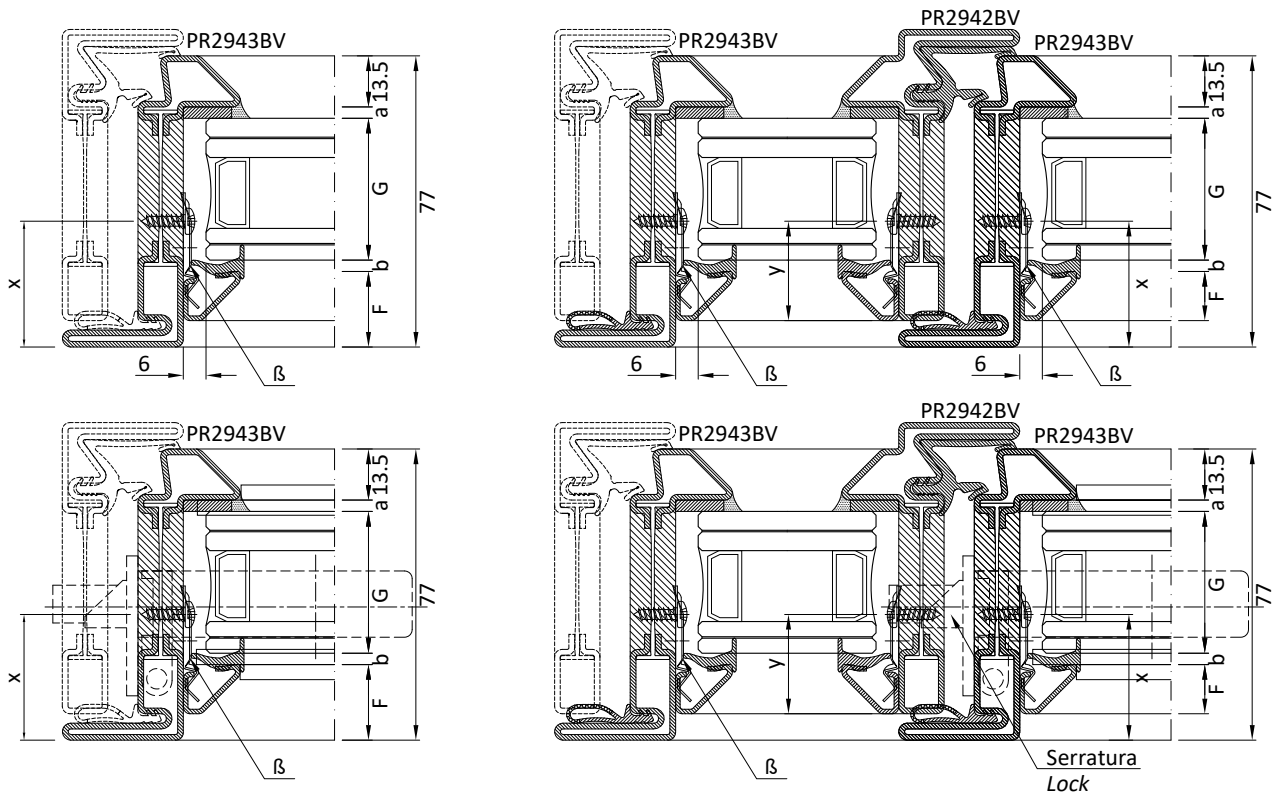
**SA3003**

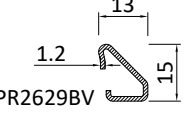
Cera d'api per finitura corten

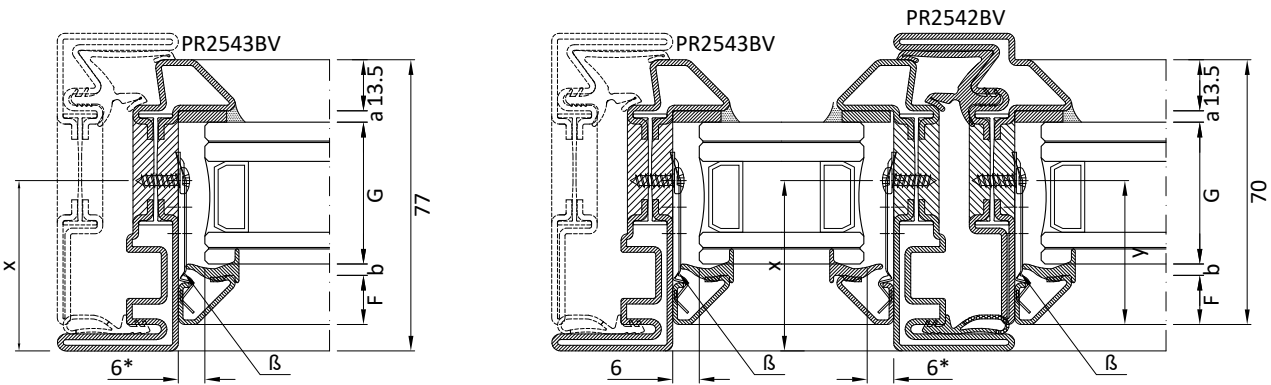
Beeswax for Corten finishing



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	clips fissaggio fermavetro glazing beads securing clips
codice code	mm			x	
	Fisso 70 Fix 70	a	b	Fisso 70 Fix 70	β
 PR2629BV	37	3	3	26	AC2608

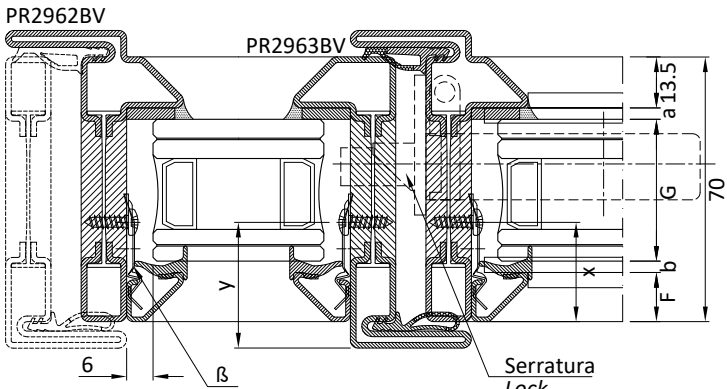
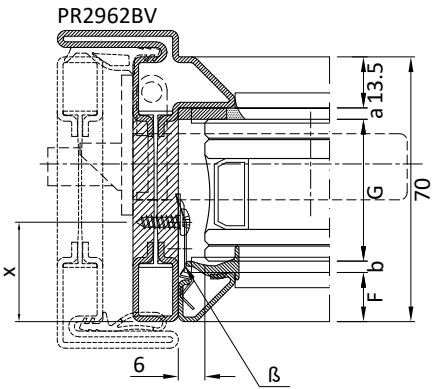
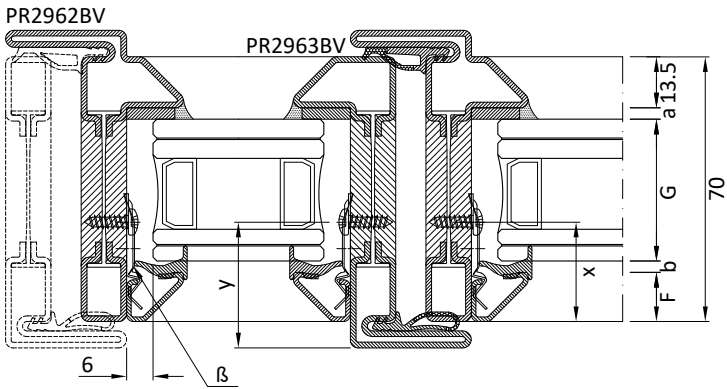
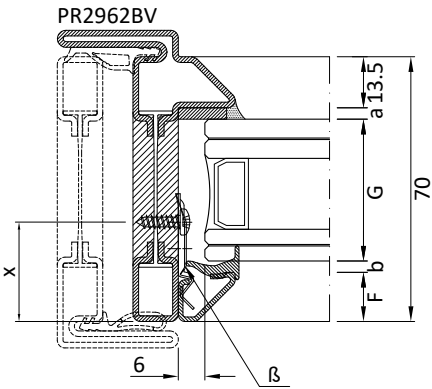


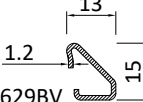
F		Guarnizioni - gasket				
fermavetro glazing beads	glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis		clips fissaggio fermavetro glazing beads securing clips
		a	b	x	y	β
 PR2629BV	37	3	3	33	26	AC2608

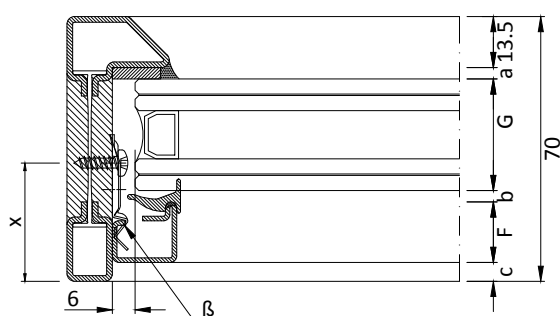


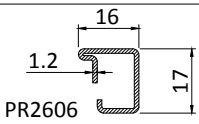
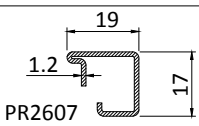
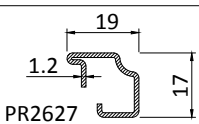
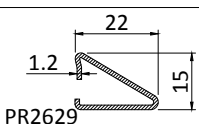
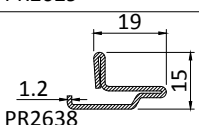
F		Guarnizioni - gasket				
fermavetro glazing beads	glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	clips fissaggio fermavetro glazing beads securing clips	
codice code	mm	a	b	x	y	β
 PR2629BV	37	3	3	45	38	AC2608AR

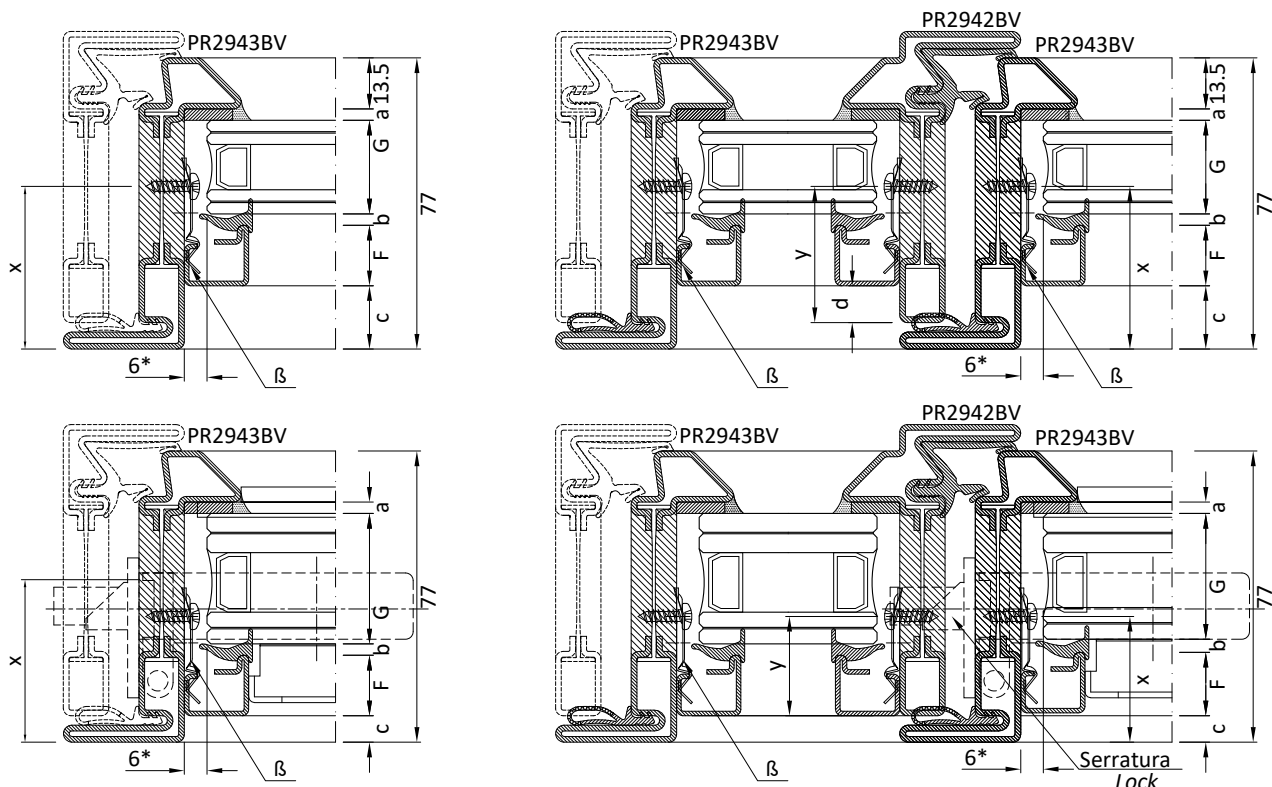
* 7 mm lato cremonese
* 7 mm cremone side

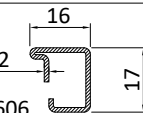
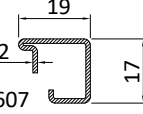
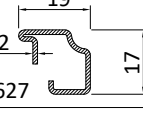
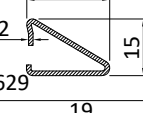
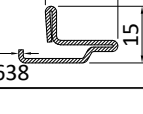


F		Guarnizioni - gasket				
fermavetro glazing beads	glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis		clips fissaggio fermavetro glazing beads securing clips
		a	b	x	y	β
 PR2629BV	37	3	3	26	33	AC2608



F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips
codice code		a	b	x	c	β
 PR2606	26 - 34	3	3	36 - 28	8 - 0	AC2608
 PR2607	26 - 31			32 - 26	6 - 0	AC2608
 PR2627	26 - 31			32 - 26	6 - 0	AC2608
 PR2629	26 - 28			41 - 38	3 - 0	AC2608
 PR2638	26 - 31			48 - 43	5 - 0	AC2608

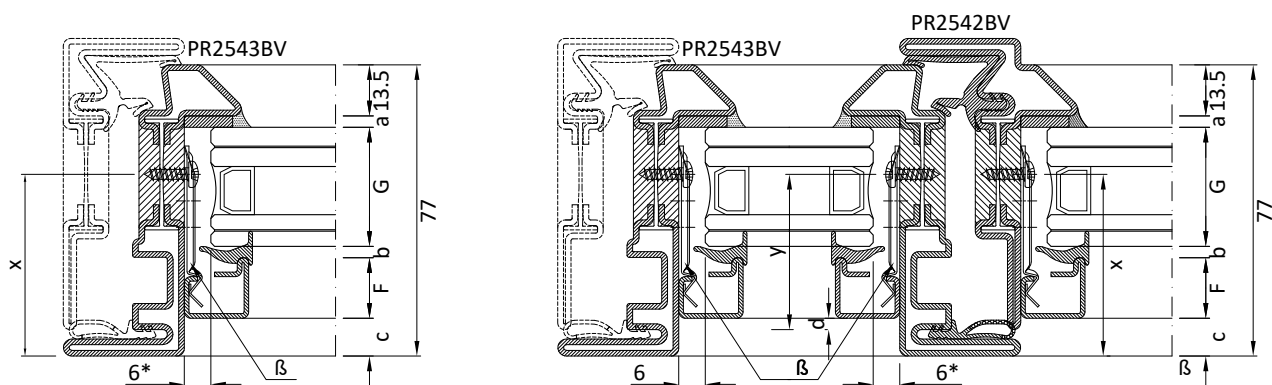


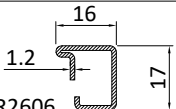
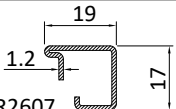
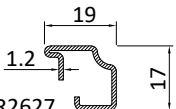
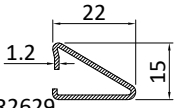
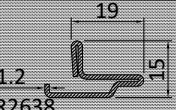
F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice code		a	b	x	y	c	d	β
PR2606 	26 - 34	3	3	43 - 35	36 - 28	15 - 7	8 - 0	AC2608
PR2607 	26 - 31			39 - 33	32 - 26	13 - 7	6 - 0	AC2608
PR2627 	26 - 31			39 - 33	32 - 26	13 - 7	6 - 0	AC2608
PR2629 	26 - 28			48 - 45	41 - 38	10 - 7	3 - 0	AC2608
PR2638 	26 - 31			55 - 50	48 - 43	12 - 7	5 - 0	AC2608

* 7 mm per PR2638

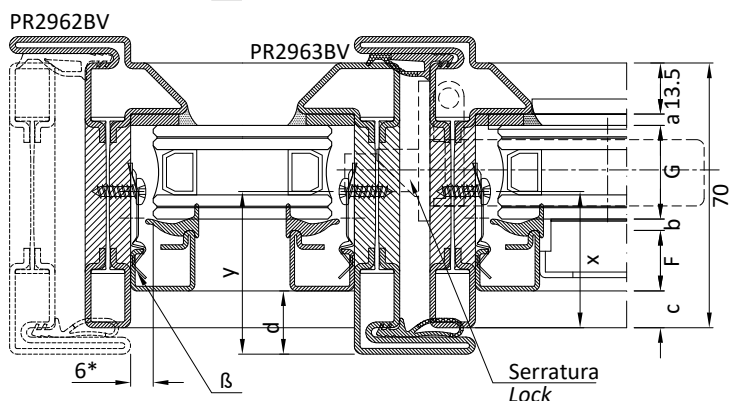
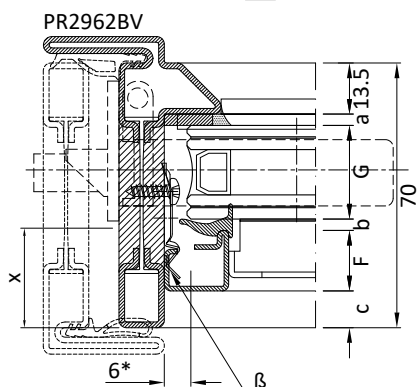
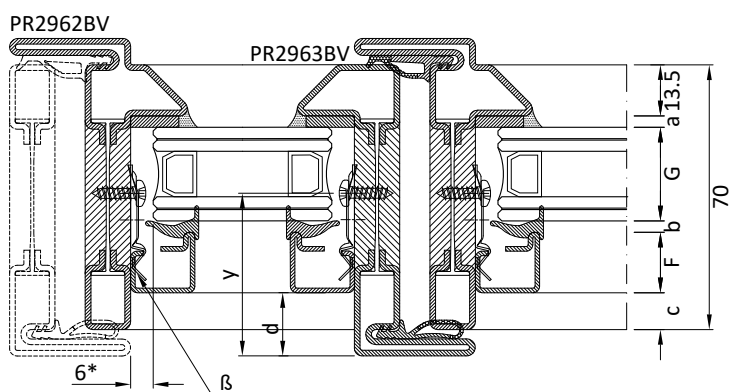
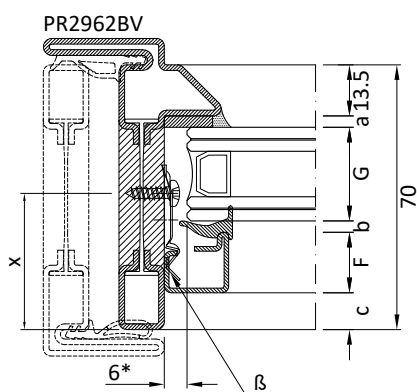
* 7 mm for PR2638

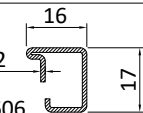
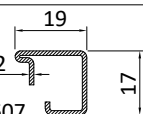
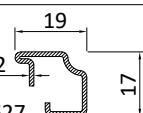
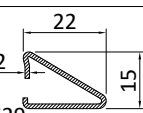
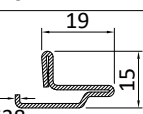
NOTA: Con serratura AC2693 utilizzare vetri con spessore 27 mm - NOTE: With lock AC2693 use glass thickness 27 mm
 Con serratura AC2694 utilizzare vetri con spessore 35 mm With lock AC2694 use glass thickness 35 mm



F	G	Guarnizioni - <i>gasket</i>						
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>	GU2036 3 mm  + sigillatura + <i>seal</i>	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro <i>glazing beads securing axis</i>		rientro fermavetro <i>glazing beads gap</i>		clips fissaggio fermavetro <i>glazing beads securing clips</i>
codice <i>code</i>		a	b	x	y	c	d	β
 PR2606	29 - 34	3	3	40 - 35	33 - 28	12 - 7	5 - 0	AC2608AR
 PR2607	26 - 31			39 - 33	32 - 26	13 - 7	6 - 0	AC2608AR
 PR2627	26 - 31			39 - 33	32 - 26	13 - 7	6 - 0	AC2608AR
 PR2629	26 - 28			48 - 45	41 - 38	10 - 7	3 - 0	AC2608
 PR2638	Non utilizzabile con profilo PR2543BV - PR2542BV <i>Not usable with profile profil PR2543BV - PR2542BV</i>							

* 7 mm lato cremonese
* 7 mm cremone side

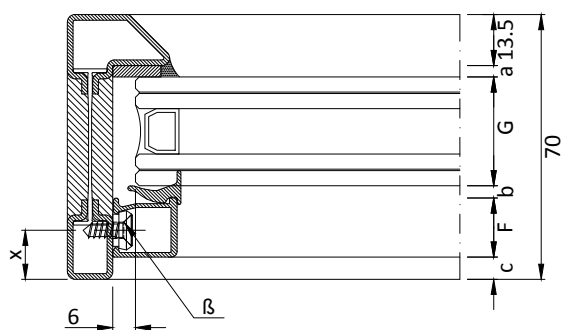


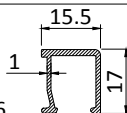
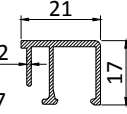
F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips		
codice code		a	b	x	y	c	d	β
PR2606 	29 - 34	3	3	33 - 28	40 - 35	5 - 0	12 - 7	AC2608
PR2607 	26 - 31			32 - 26	39 - 33	6 - 0	13 - 7	AC2608
PR2627 	26 - 31			32 - 26	39 - 33	6 - 0	13 - 7	AC2608
PR2629 	26 - 28			41 - 38	48 - 45	3 - 0	10 - 7	AC2608
PR2638 	26 - 31			48 - 43	55 - 50	5 - 0	12 - 7	AC2608

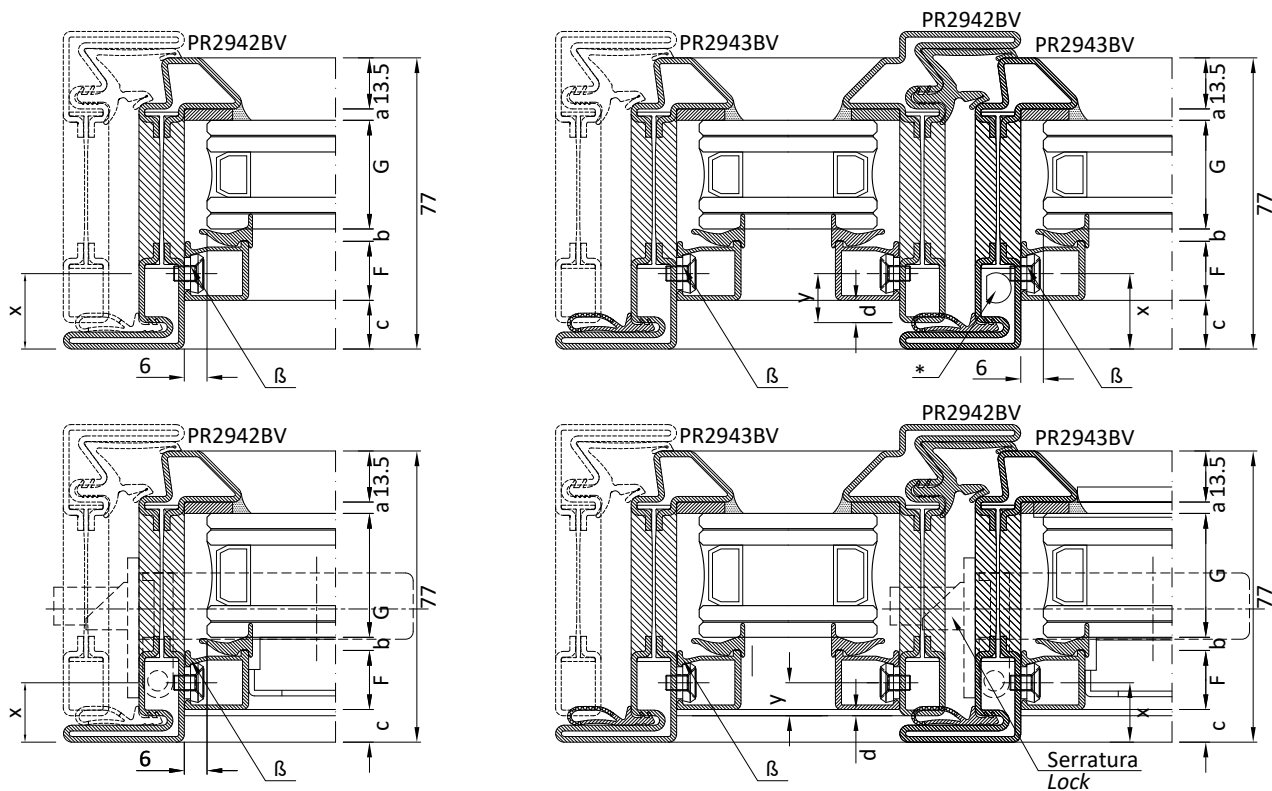
* 7 mm per PR2638

* 7 mm for PR2638

NOTA: Con serratura AC2693 utilizzare vetri con spessore 27 mm - NOTE: With lock AC2693 use glass thickness 27 mm
 Con serratura AC2694 utilizzare vetri con spessore 35 mm With lock AC2694 use glass thickness 35 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	clips fissaggio fermavetro glazing beads securing clips
codice code	mm Fisso 70 Fix 70	a	b	x	c	β
PR2606 	29 - 35	3	3	13 - 7	6 - 0	CV1023(i) CV5012(i)
PR2607 	25 - 30			12 - 7	5 - 0	CV1023(i) CV5012(i)



F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	y	c	d	β
PR2606 	29 · 35	3	3	20 · 14	13 · 7	13 · 7	6 · 0	CV1023(i) CV5012(i)
PR2607 	25 · 30			19 · 14	12 · 7	12 · 7	5 · 0	CV1023(i) CV5012(i)

NOTA: Con serratura AC2693 utilizzare vetri con spessore 27 mm

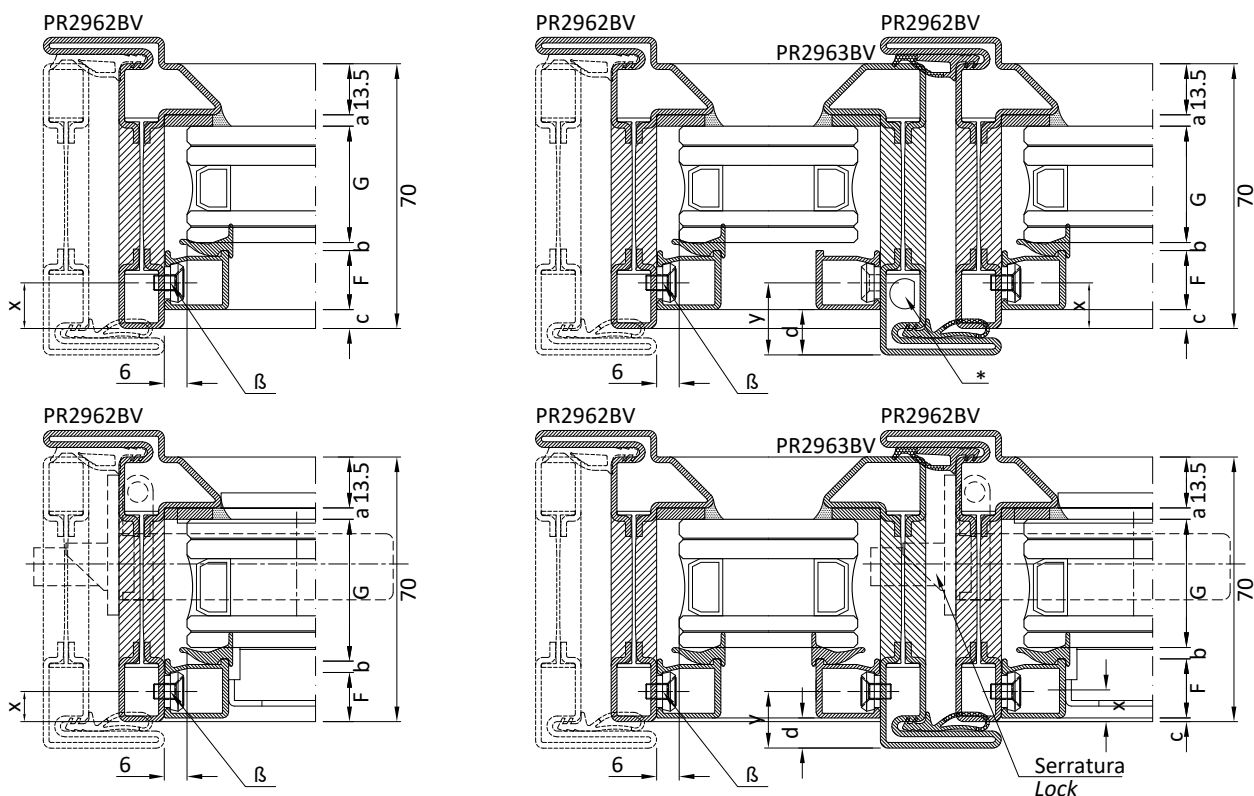
Con serratura AC2694 utilizzare vetri con spessore 35 mm

ATTN: With lock AC2693 use glass thickness 27 mm

With lock AC2694 use glass thickness 35 mm

* Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.9.14

* Pay attention fixing the screw near cremone set - see pg. 2.9.14



F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	y	c	d	β
PR2606 	29 - 35	3	3	13 - 7	20 - 14	6 - 0	13 - 7	CV1023(i) CV5012(i)
PR2607 	25 - 30			12 - 7	19 - 14	5 - 0	12 - 7	CV1023(i) CV5012(i)

NOTA: Con serratura AC2693 utilizzare vetri con spessore 27 mm

Con serratura AC2694 utilizzare vetri con spessore 23 mm

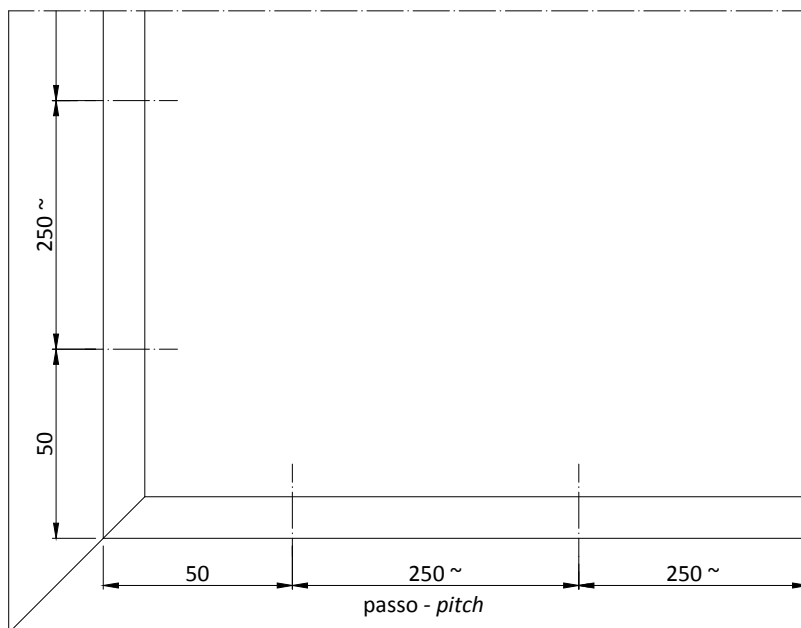
ATTN: With lock AC2693 use glass thickness 27 mm

With lock AC2694 use glass thickness 23 mm

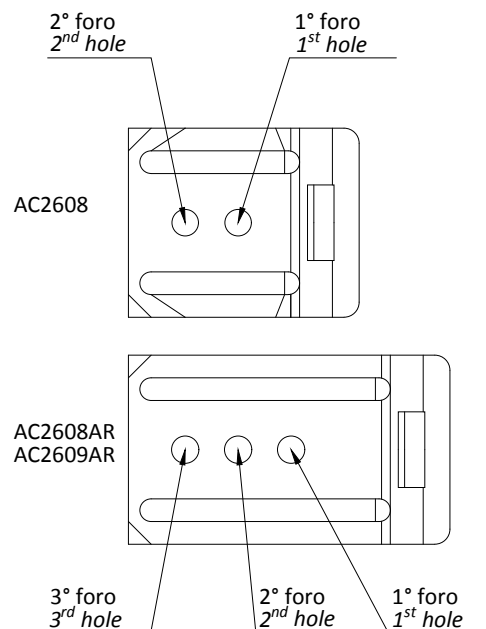
* Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.9.14

* Pay attention fixing the screw near cremone set - see pg. 2.9.14

Fissaggio fermavetri PR2629BV - PR2606 - PR2607 - PR2627 - PR2629 - PR2638: clip AC2608/AC2608AR con vite TC 3.5x9.5 (non fornite)
 Glazing beads fixing PR2629BV - PR2606 - PR2607 - PR2627 - PR2629 - PR2638: clip AC2608 /AC2608AR with screw TC 3.5x9.5 (not included)

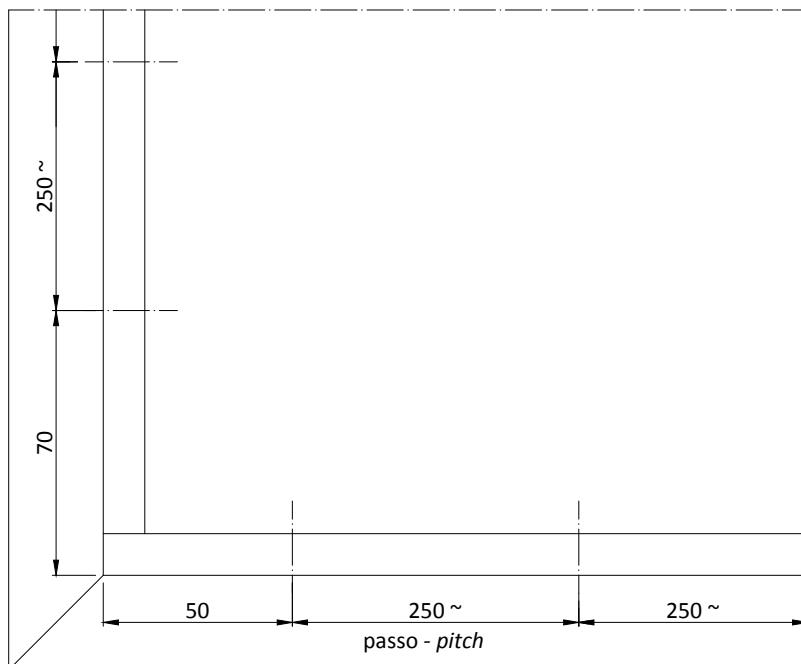


Passo clips fissaggio fermavetri
 Clip pitch for glazing beads securing



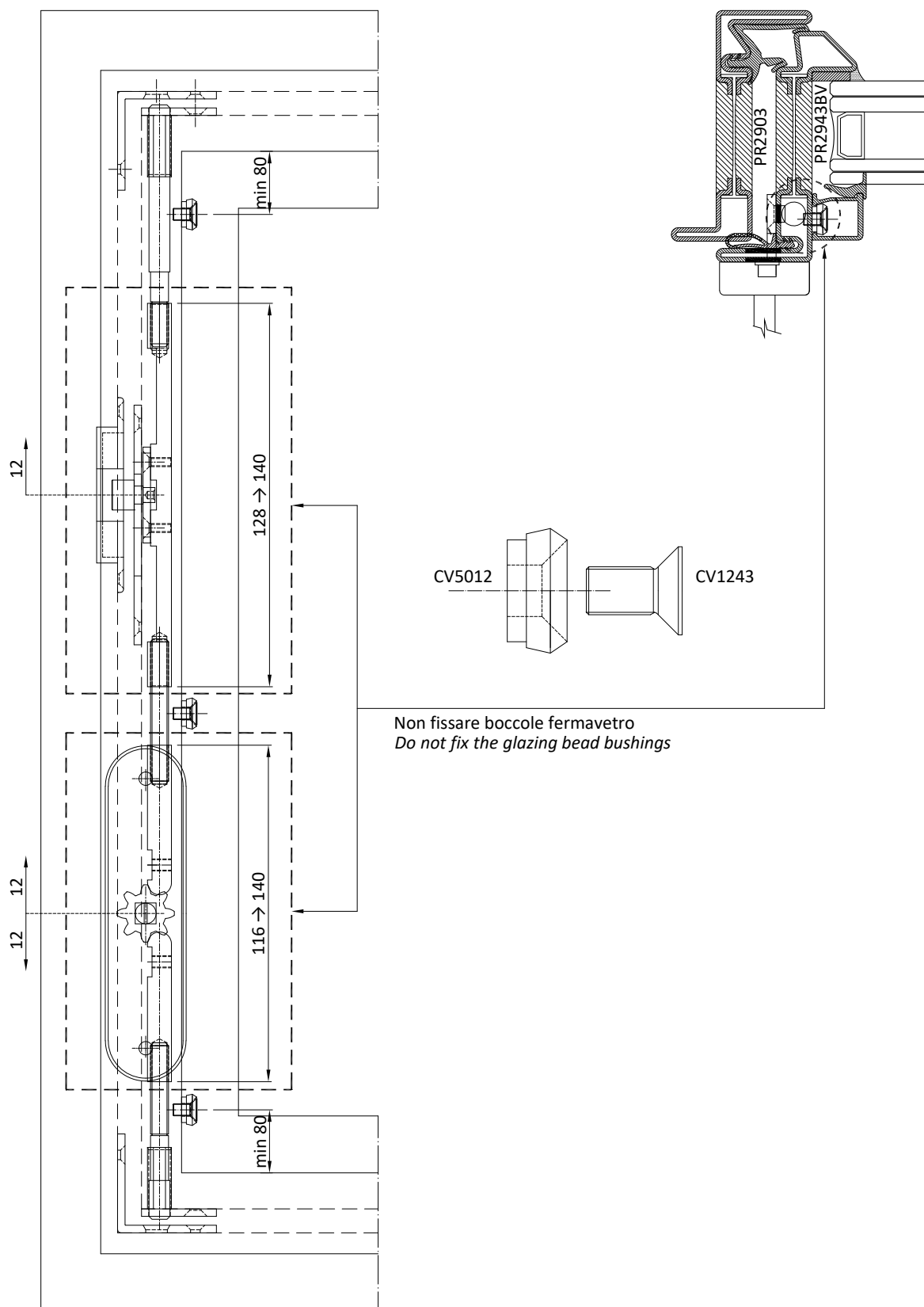
Fissaggio fermavetri PA2606 - PA2607: profili telaio vite CV1023(I) TPS 4,2 x 13 e boccola CV5012(I)
 Profili anta vite CV1243(I) TPS M4 x 8 e boccola CV5012(I).

Glazing bead fixing PA2606 - PA2607: 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).

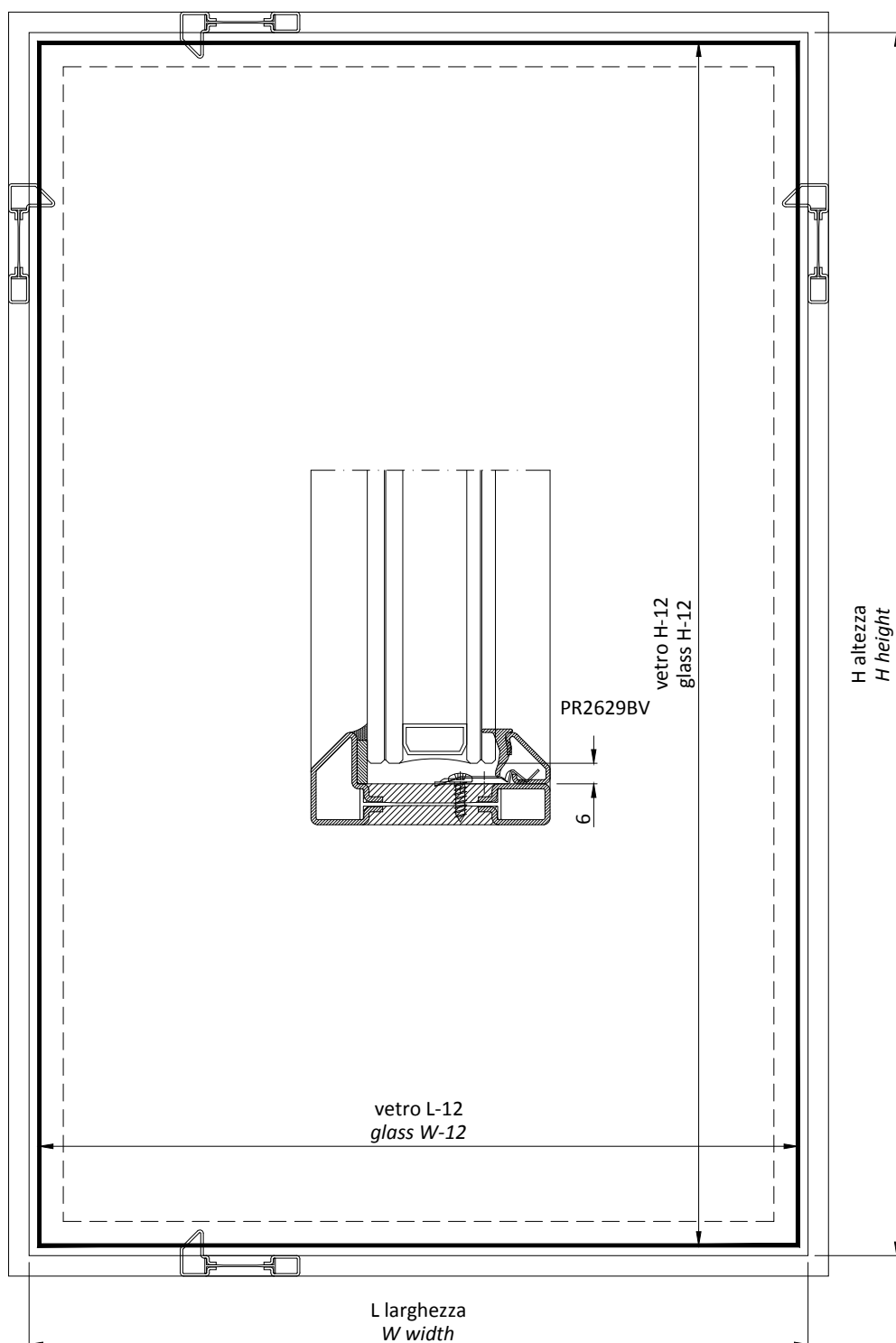
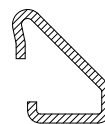


Passo vite e boccola fissaggio fermavetri
 Screw and bushing pitch for glazing beads fixing

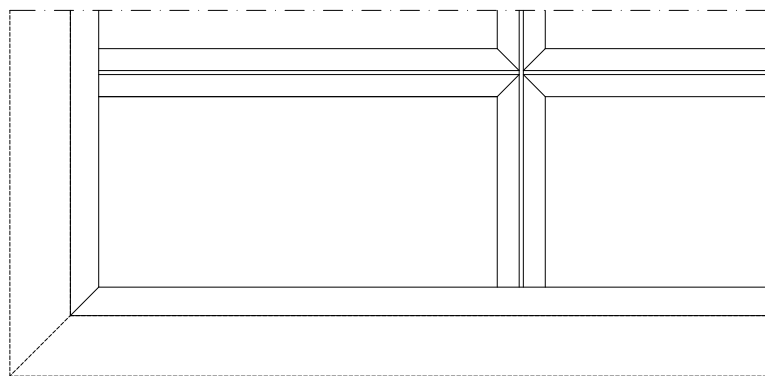
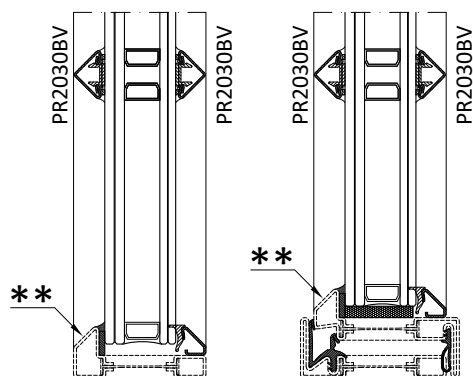
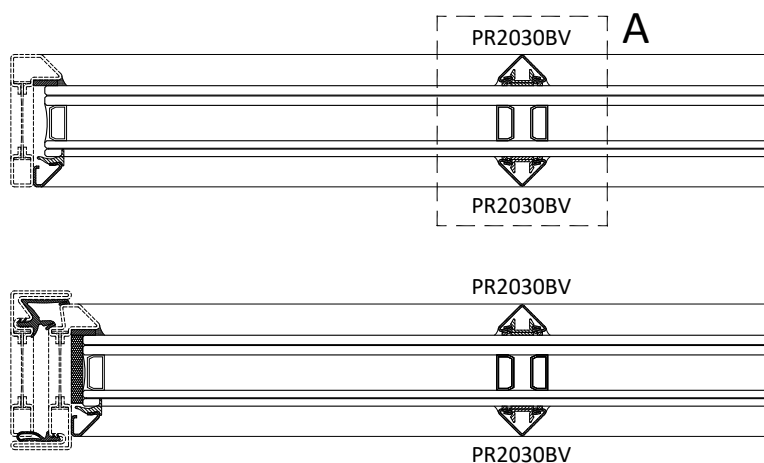
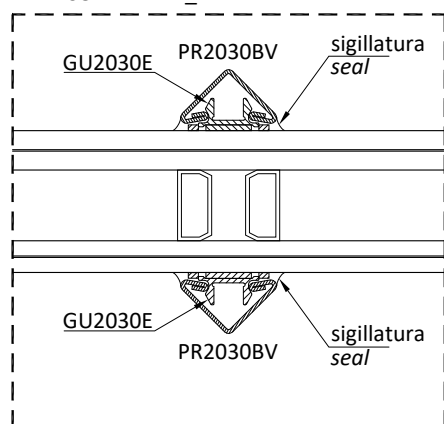
Boccole fissaggio fermavetri in alluminio
Bushing fixing for aluminium glazing beads



PR2629BV

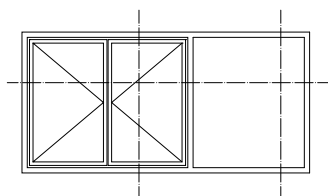


PARTICOLARE "A" _ DETAIL "A"



Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
 Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
 For ONLY horizontal or ONLY vertical glazing beads use GU2031
 For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

** Saldare o sigillare
 Weld or seal



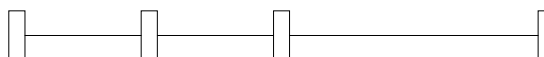
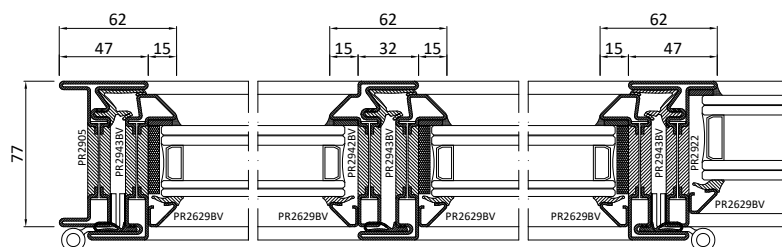
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa in luce

Type
double leaf window with fixed light
inward opening
laying middle wall



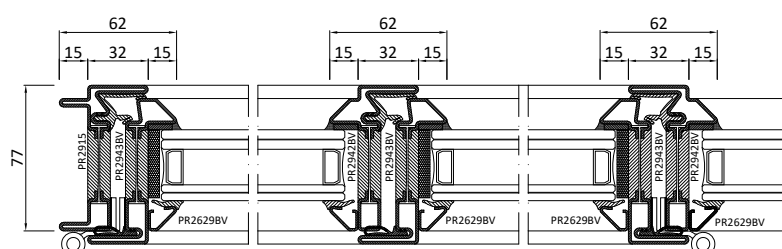
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

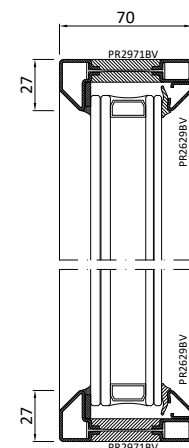
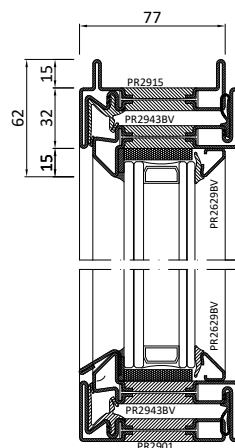
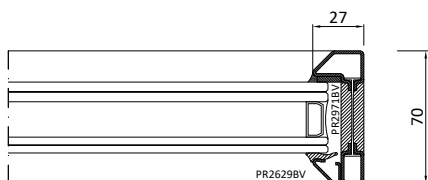
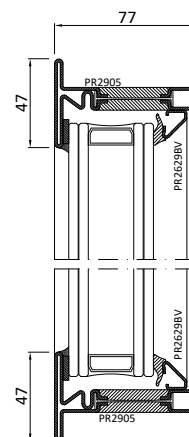
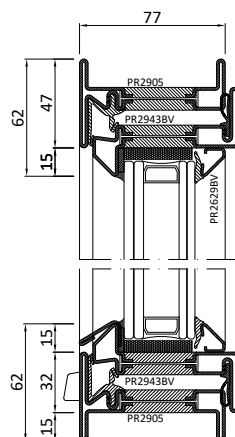
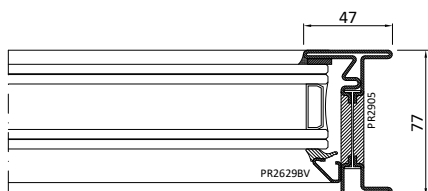
System 1
minimised sections
non-flush glasses
visible openings on the facade

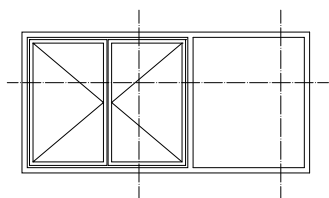


Sistema 2
sezioni congruenti
vetri complanari
aperture in evidenza nel prospetto

System 2
congruent sections
flush glasses
visible openings on the facade







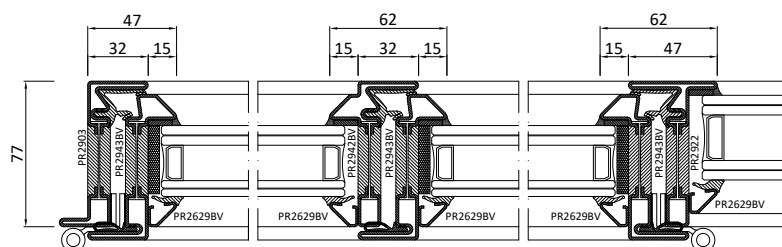
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa interno muro

Type
double leaf window with fixed light
inward opening
laying internal wall



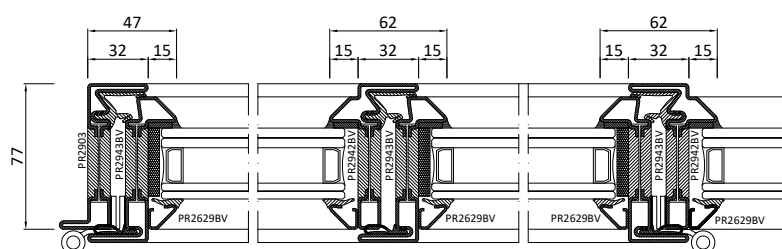
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

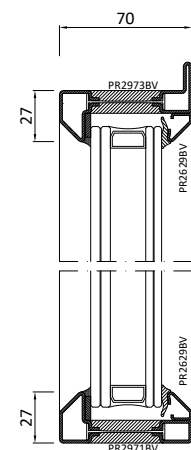
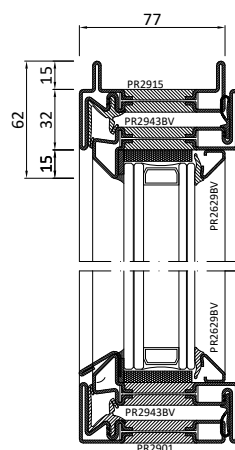
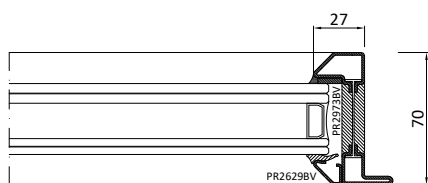
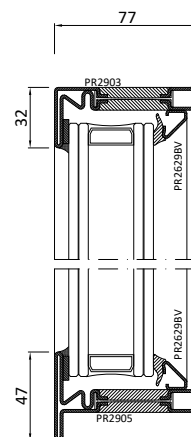
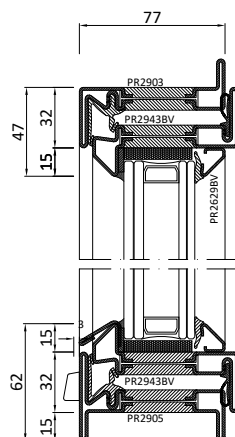
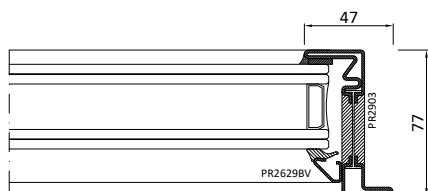
System 1
minimised sections
non-flush glasses
visible openings on the facade

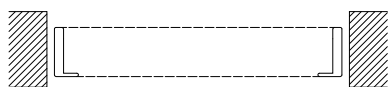
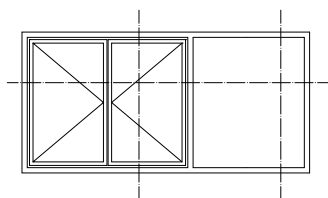


Sistema 2
sezioni congruenti
vetri complanari
aperture in evidenza nel prospetto

System 2
congruent sections
flush glasses
visible openings on the facade

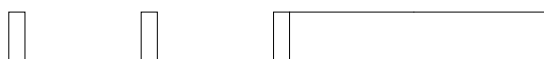






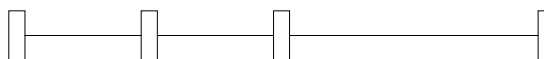
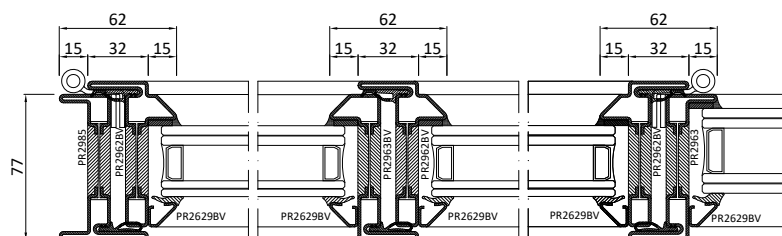
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa in luce

Type
double leaf window with fixed light
outward opening
laying middle wall



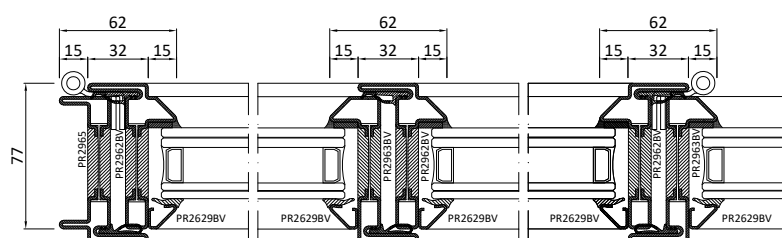
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

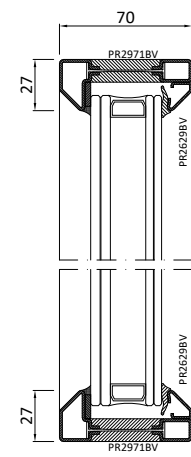
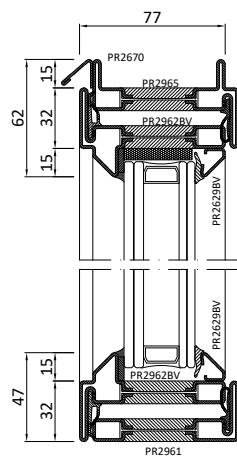
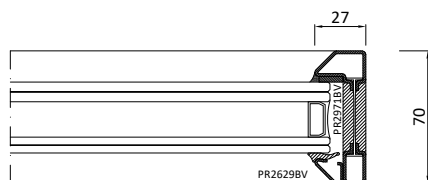
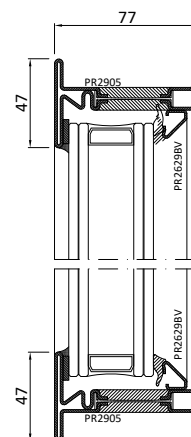
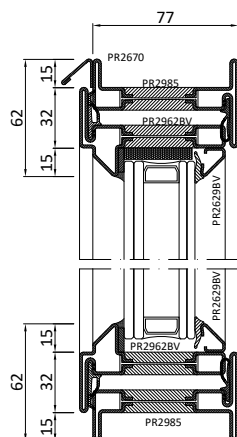
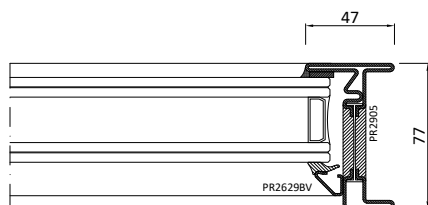
System 1
minimised sections
non-flush glasses
visible openings on the facade

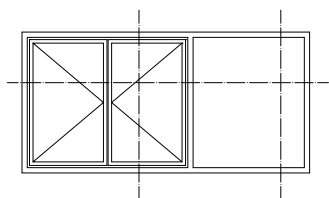


Sistema 2
sezioni congruenti
vetri complanari
aperture in evidenza nel prospetto

System 2
congruent sections
flush glasses
visible openings on the facade







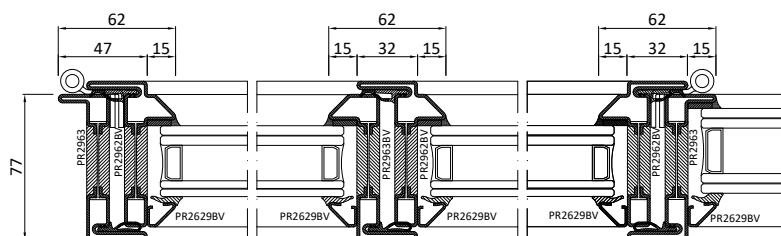
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa esterno muro

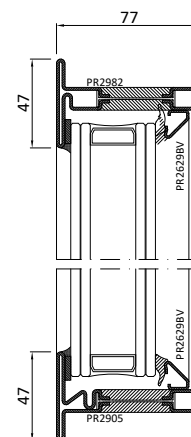
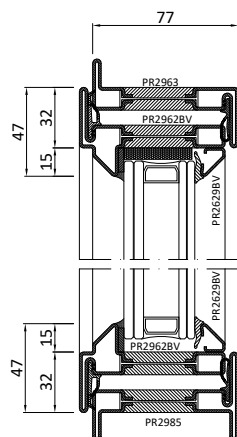
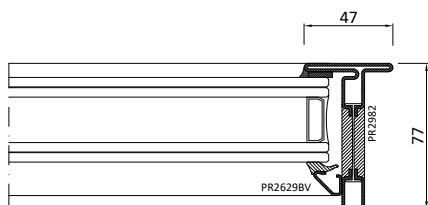
Type
double leaf window with fixed light
external opening
laying external wall

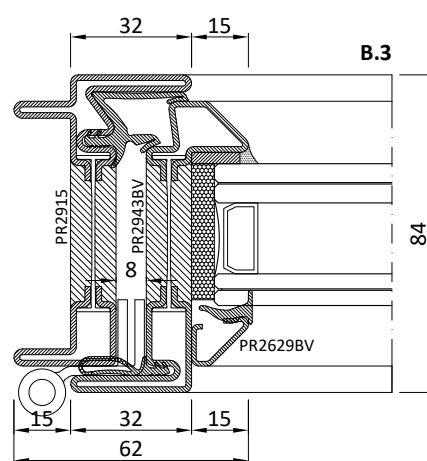
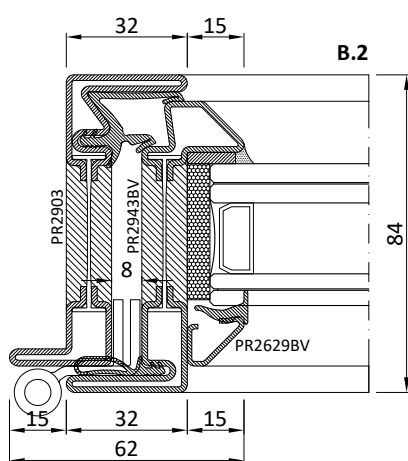
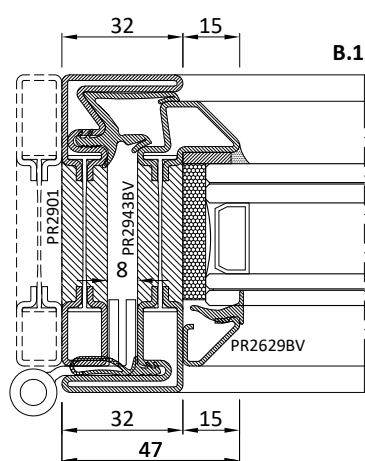
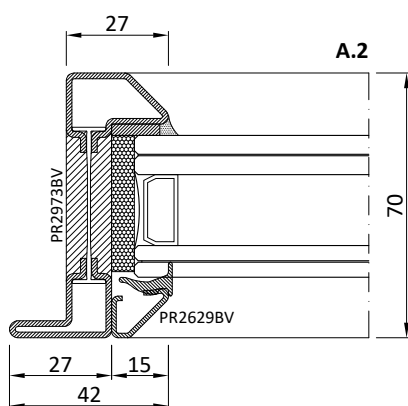
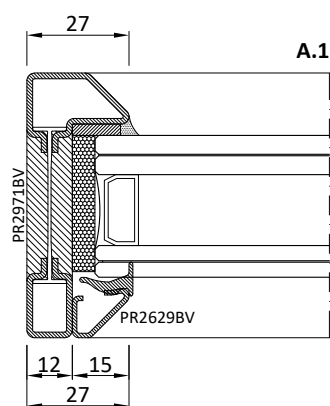
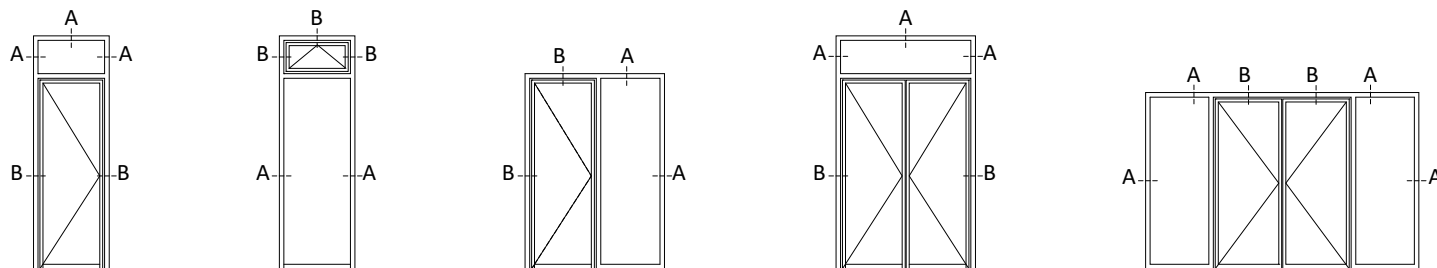
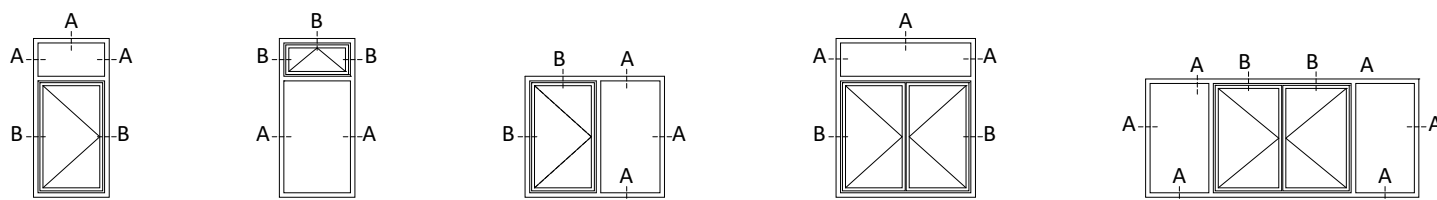


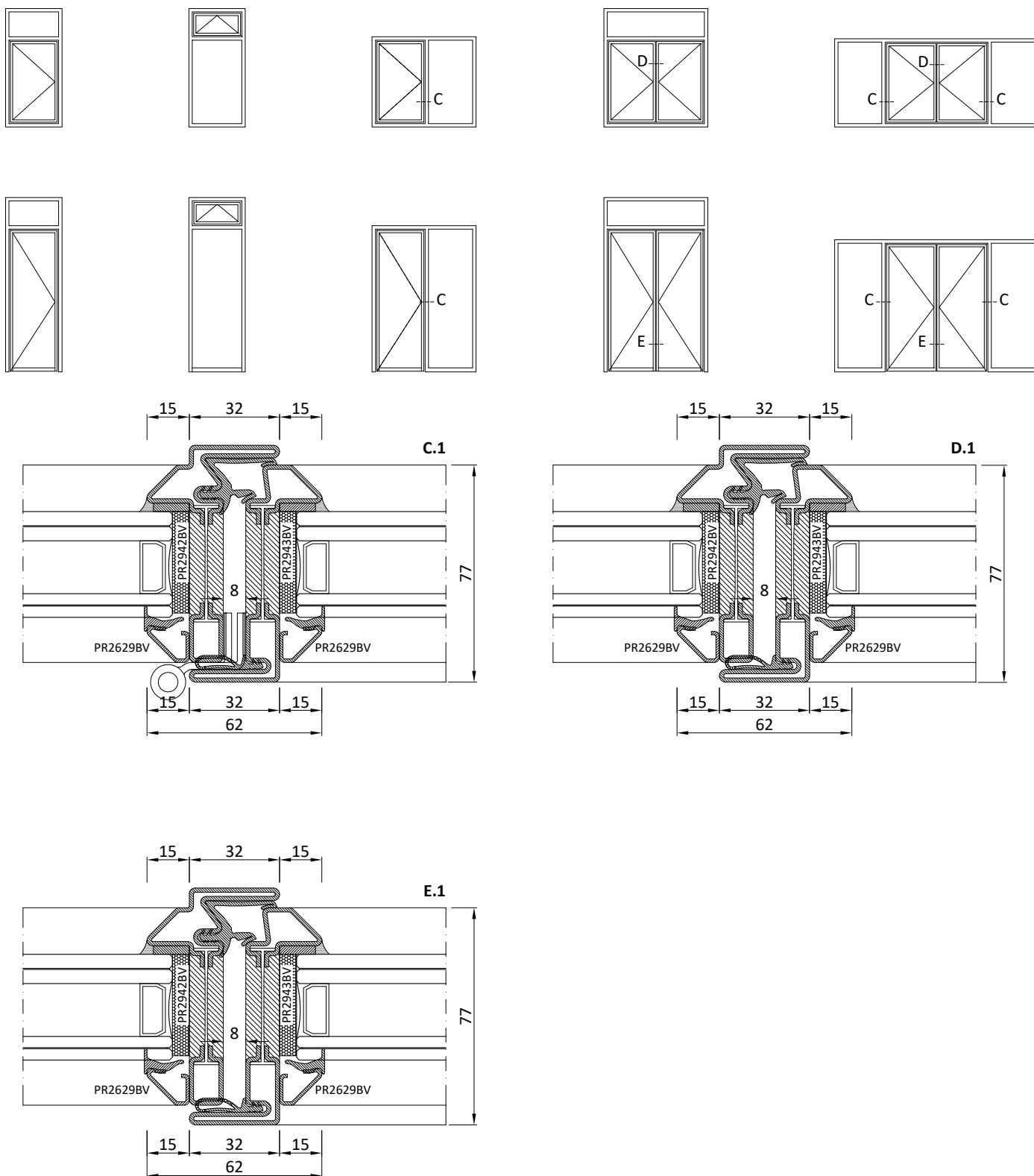
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

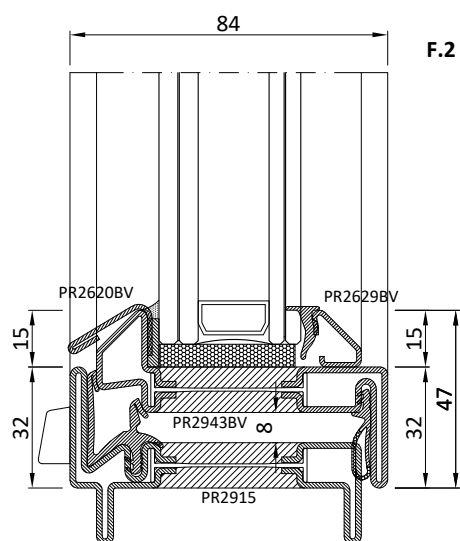
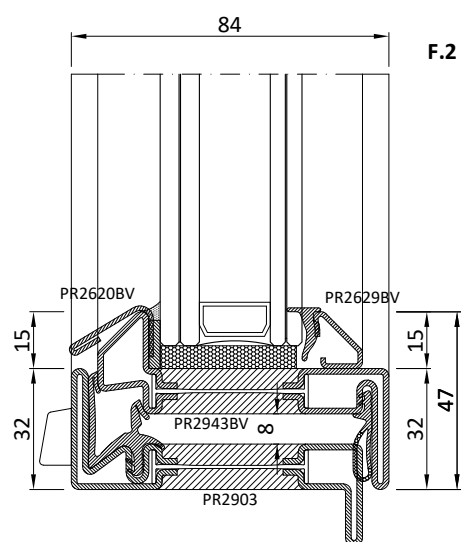
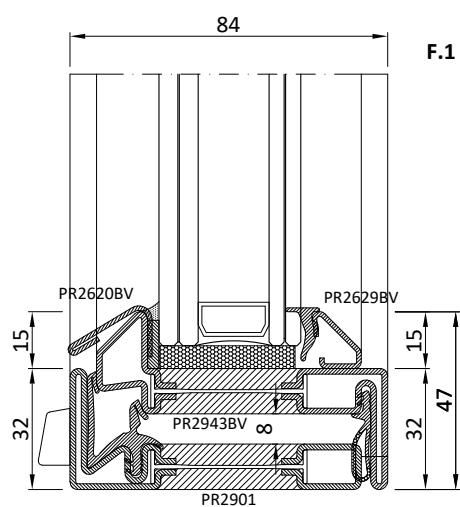
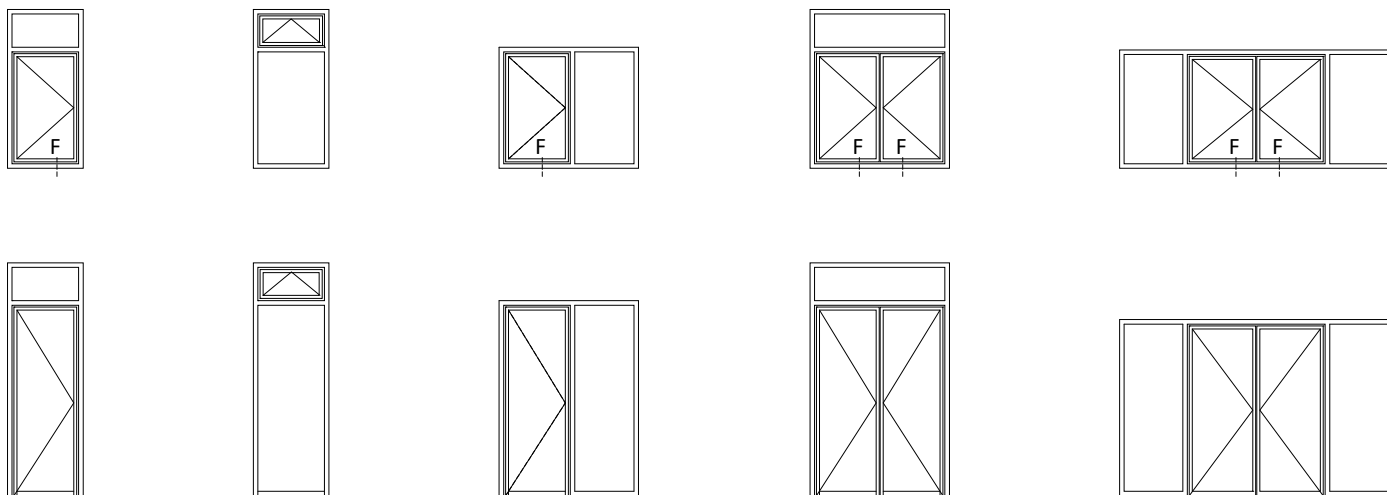
System 1
minimised sections
non-flush glasses
visible openings on the facade

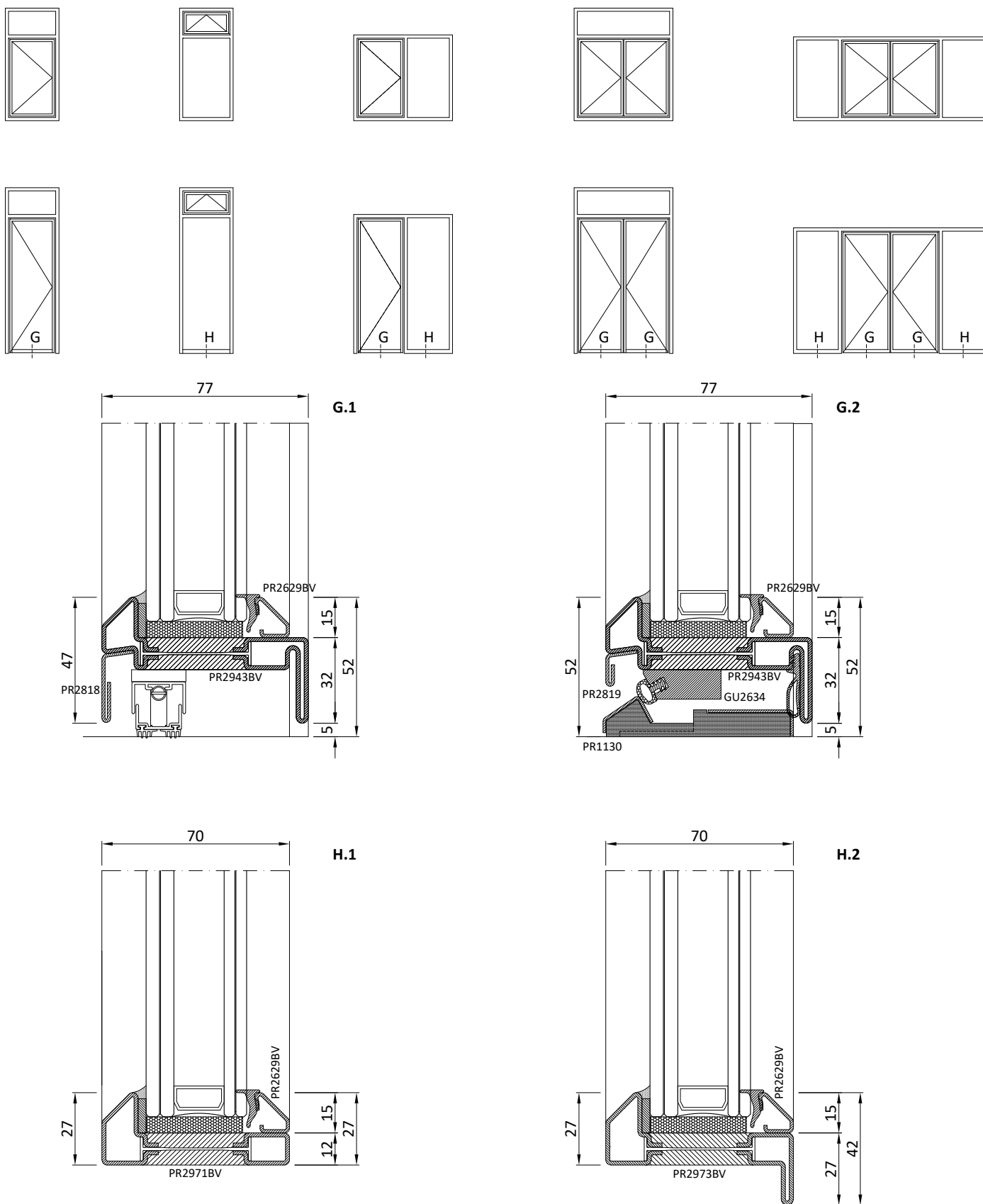


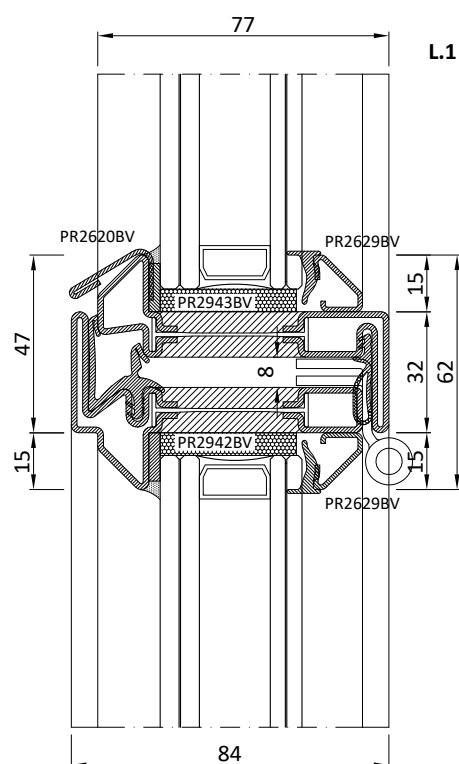
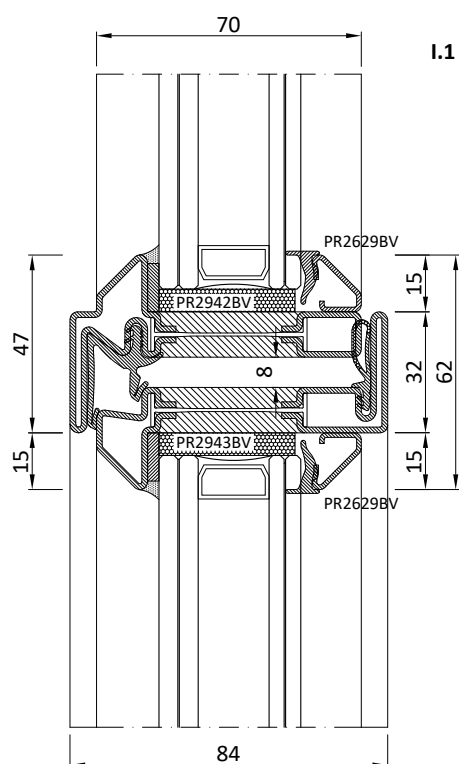
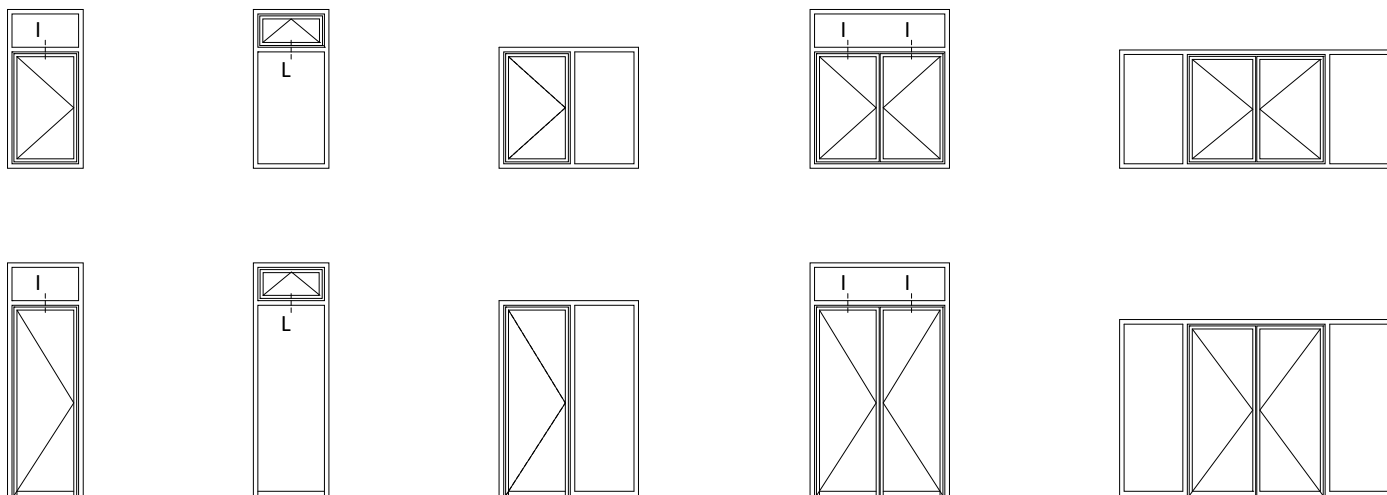


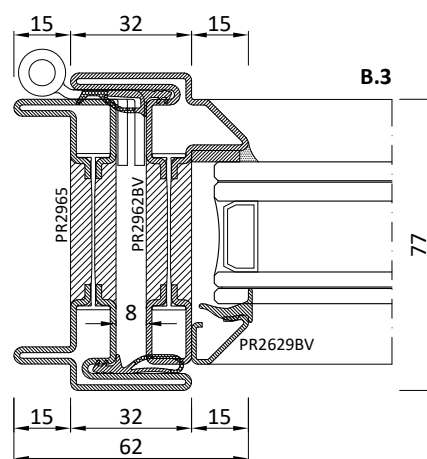
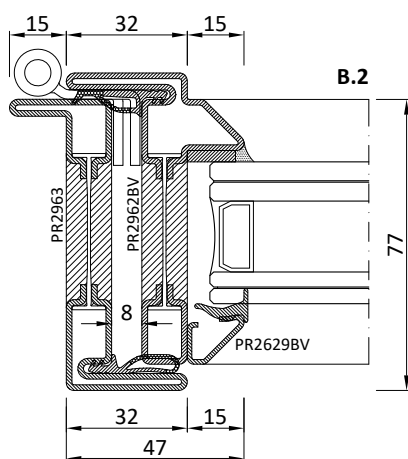
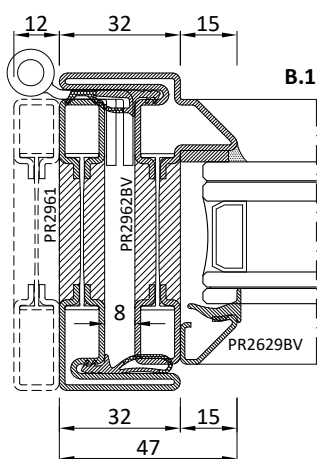
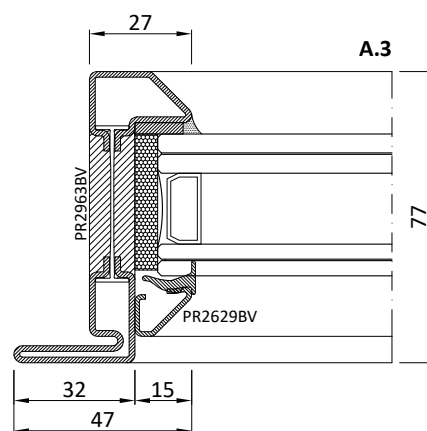
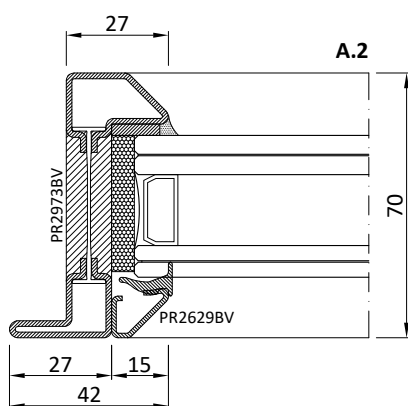
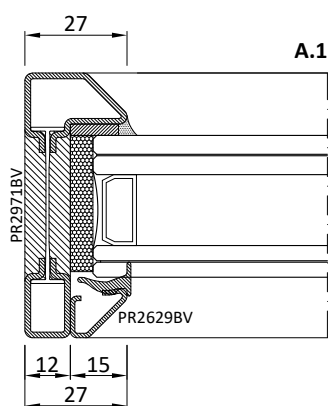
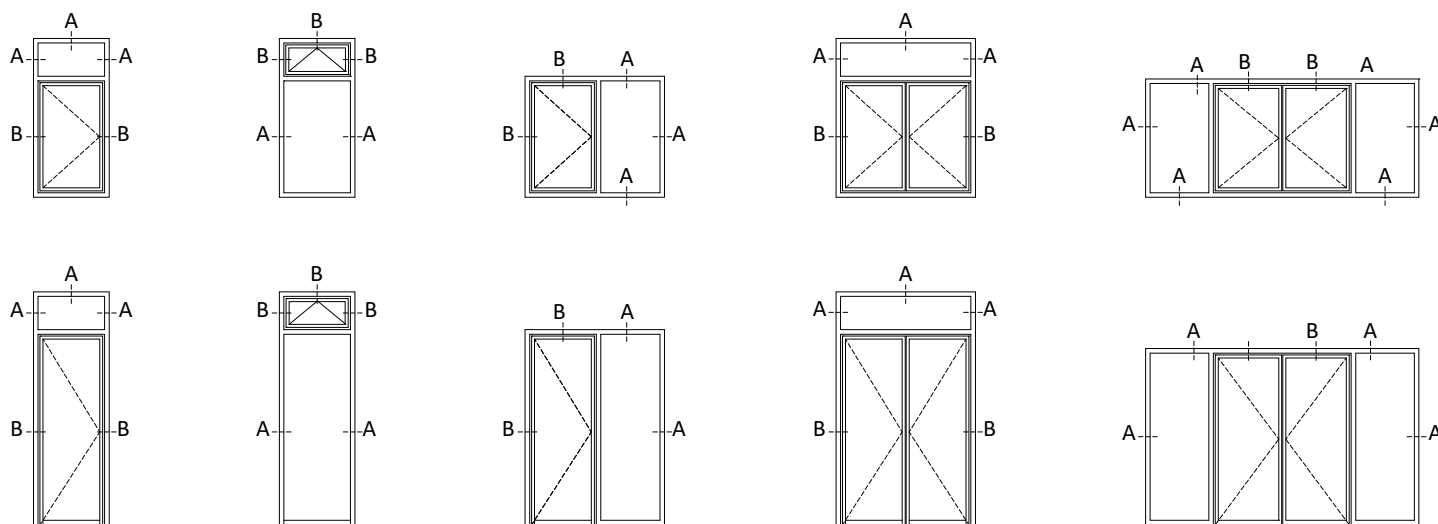


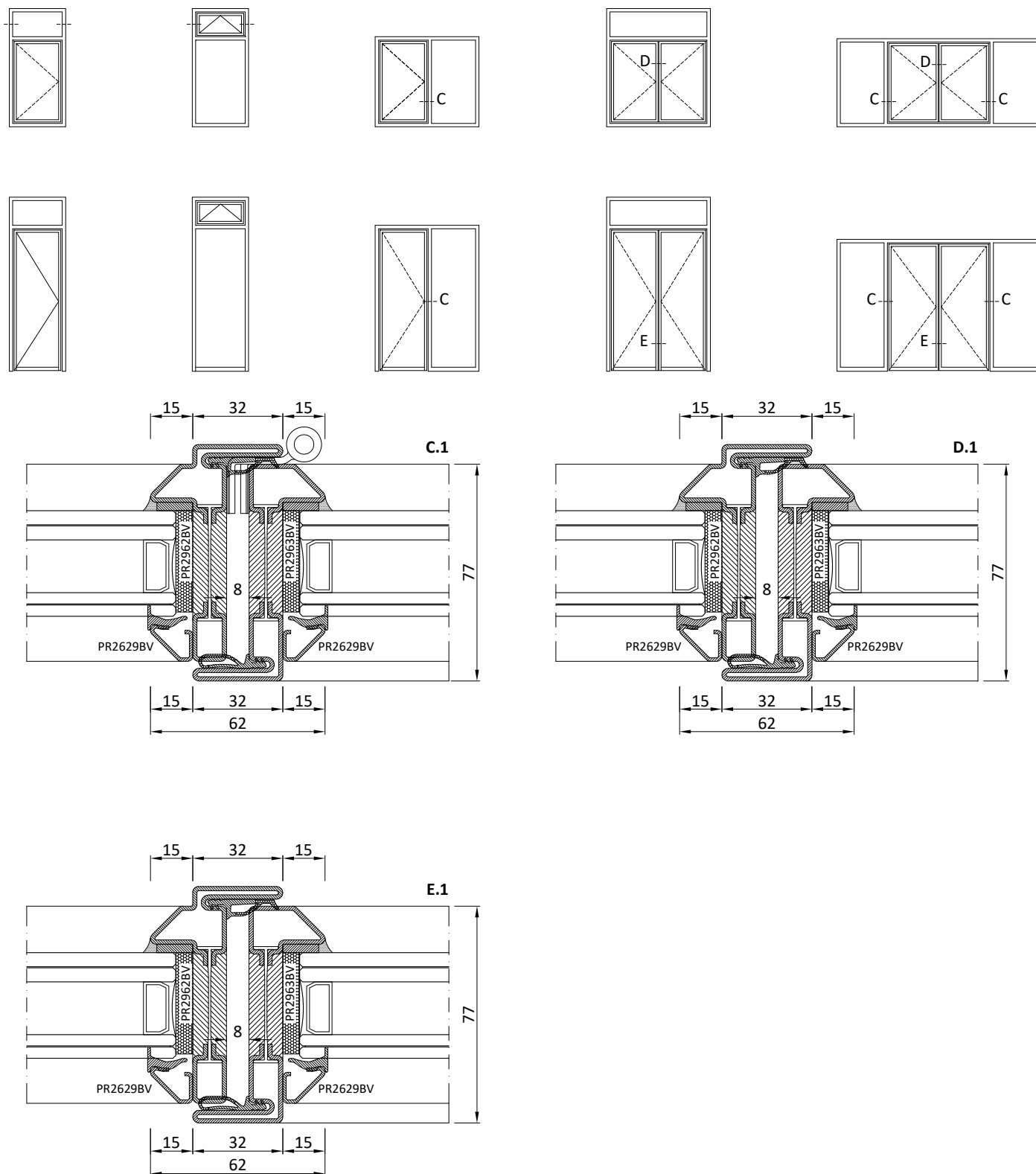


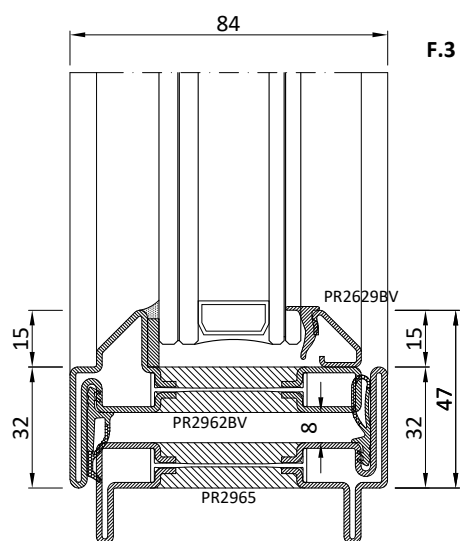
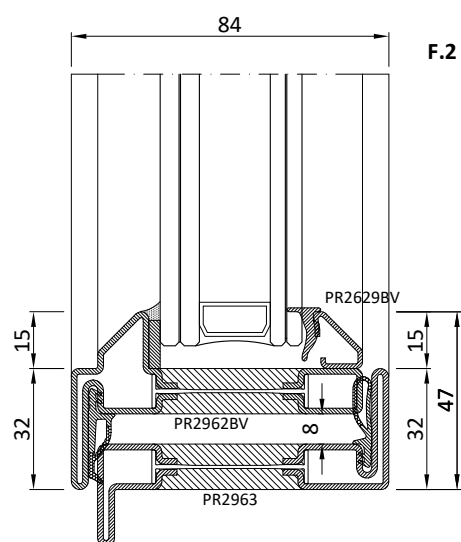
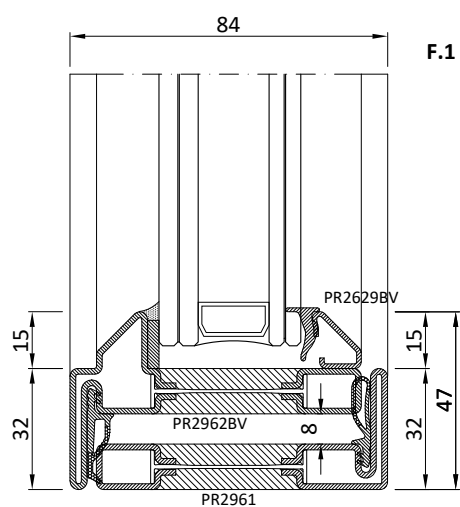
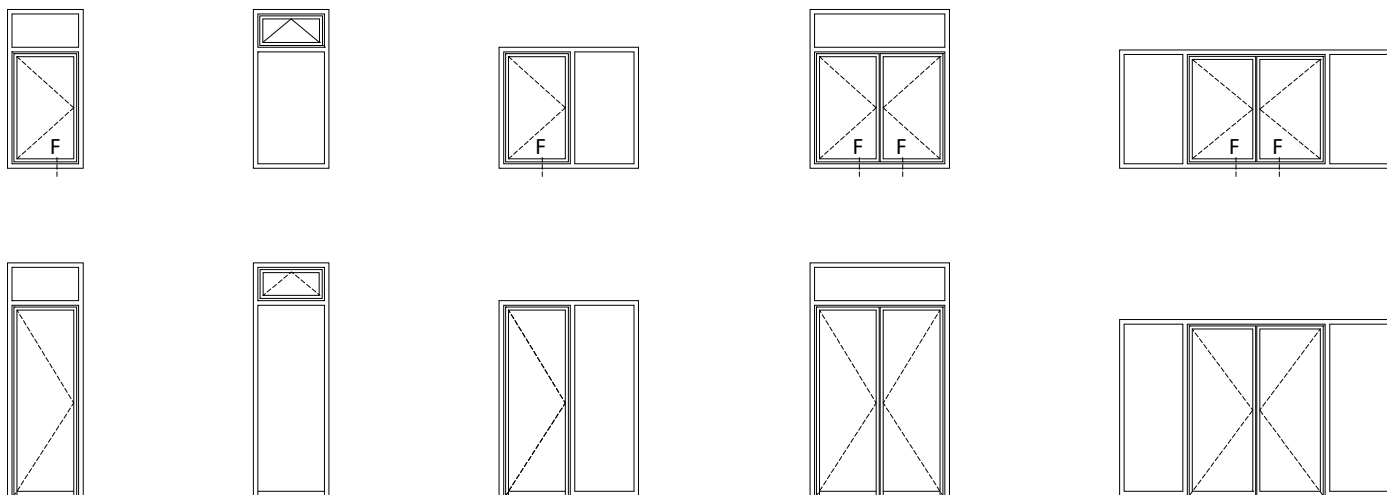


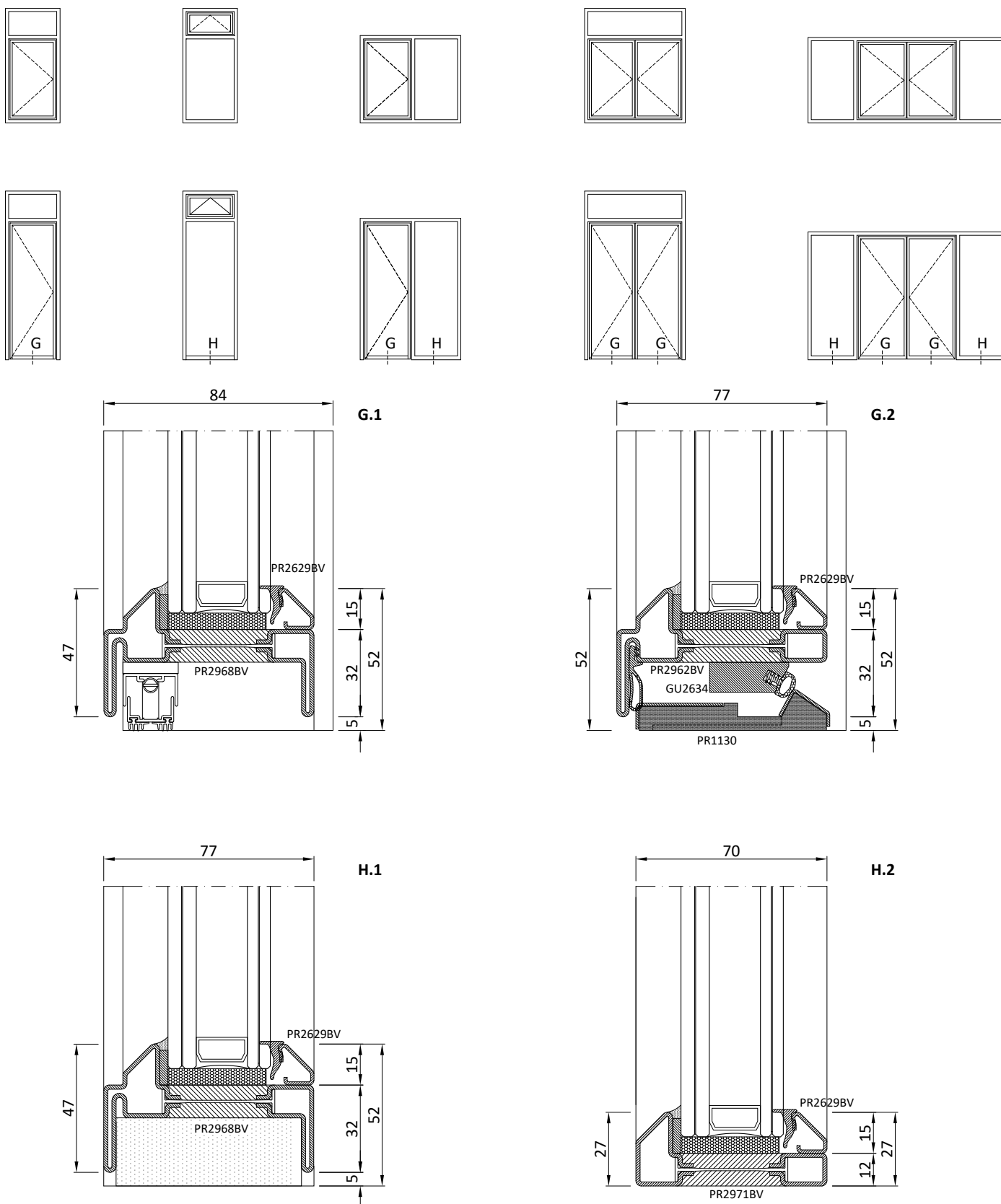


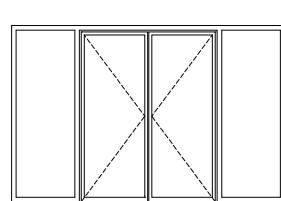
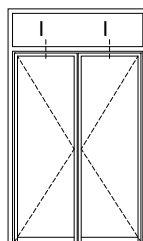
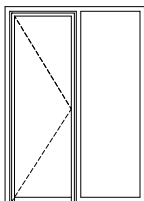
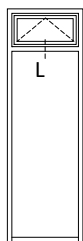
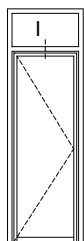
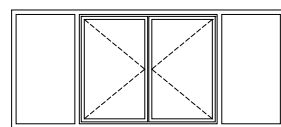
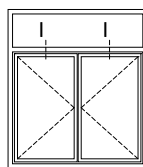
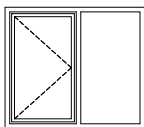
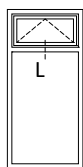
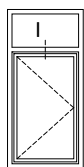




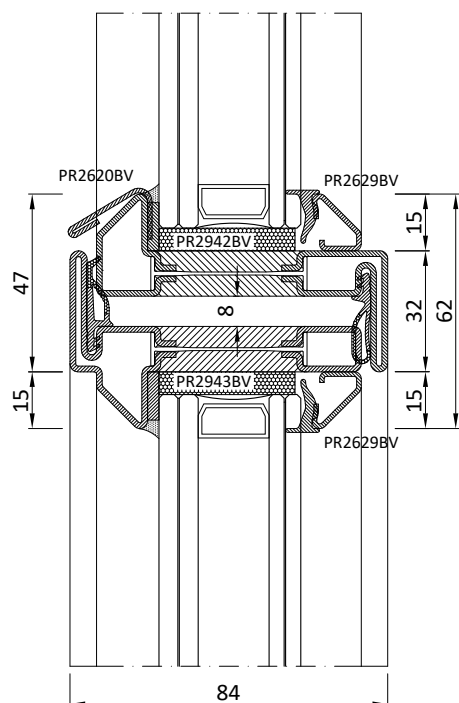




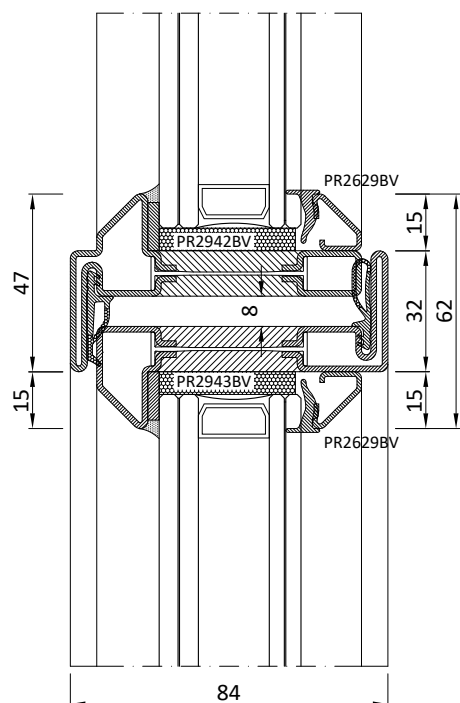


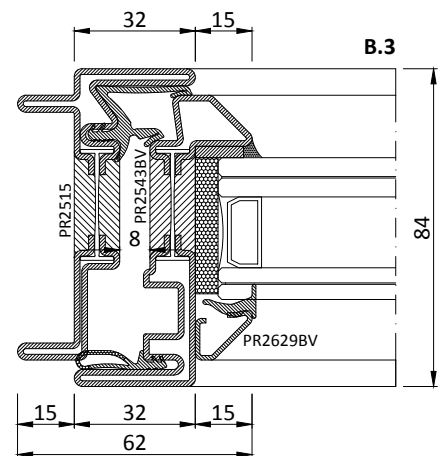
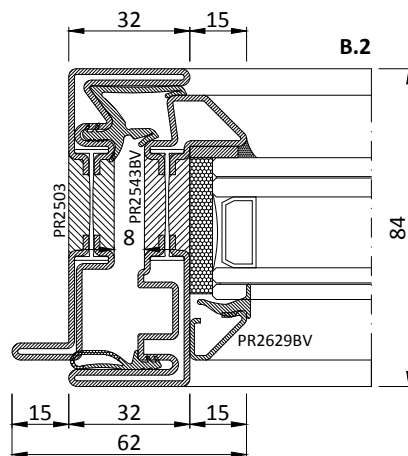
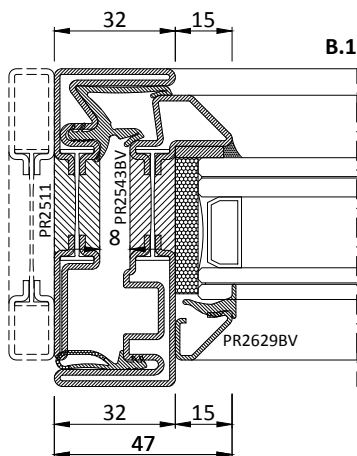
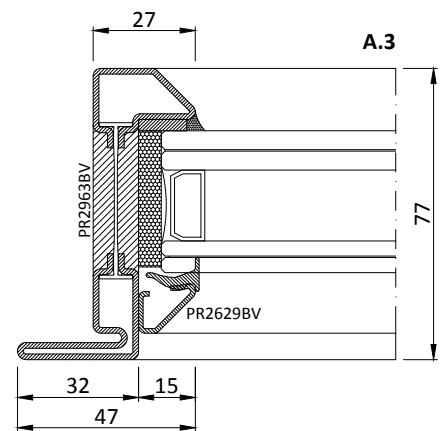
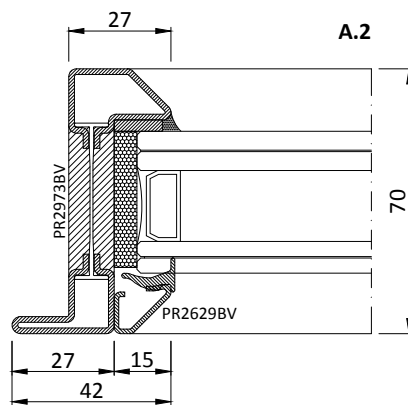
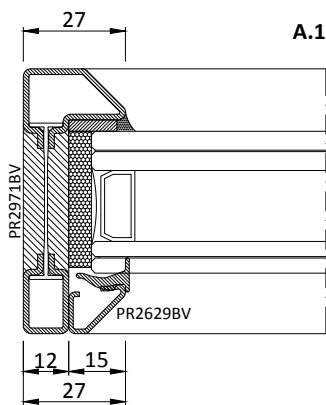
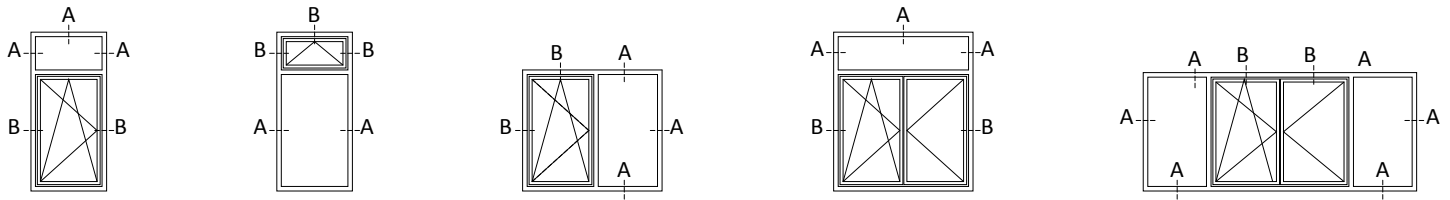


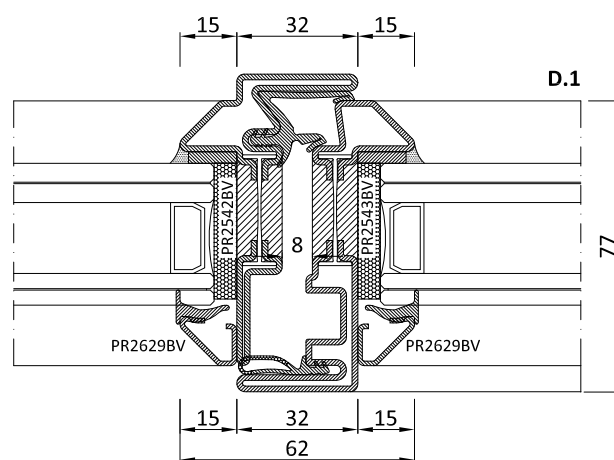
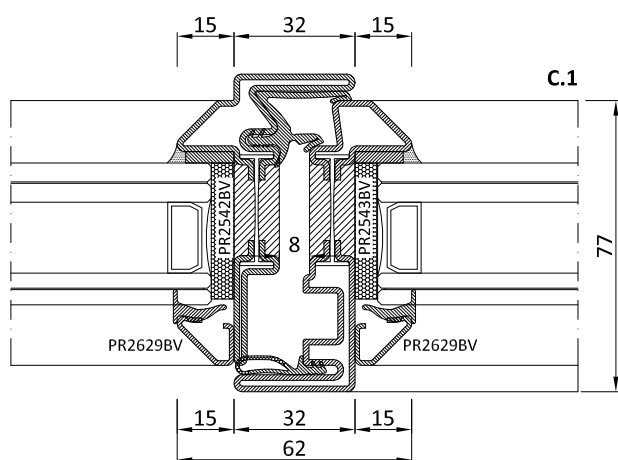
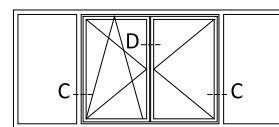
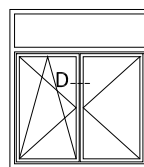
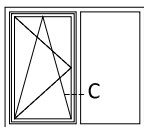
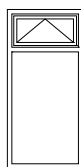
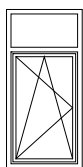
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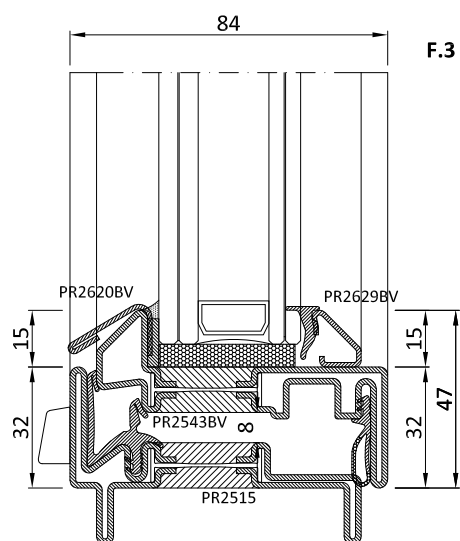
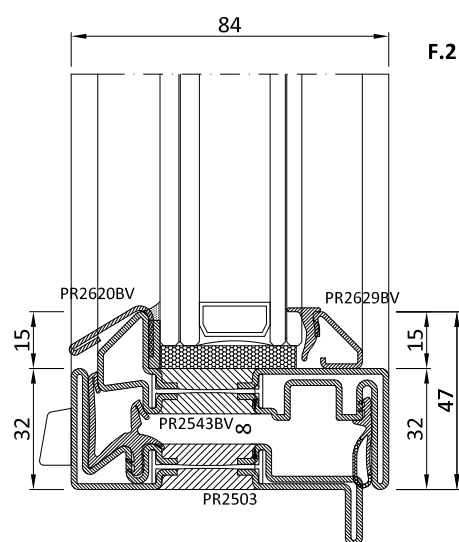
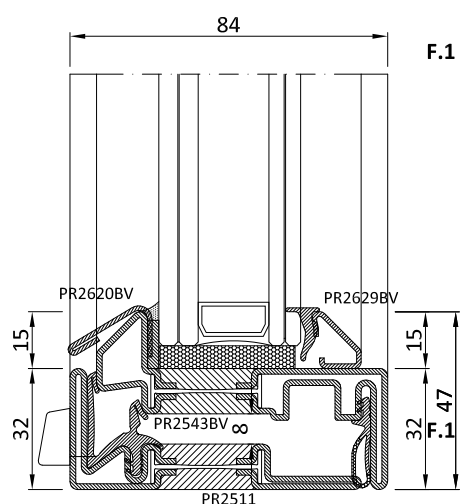
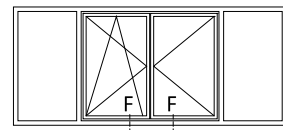
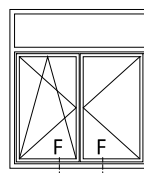
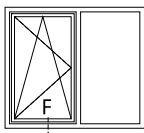
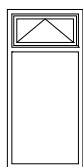
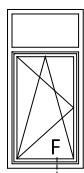


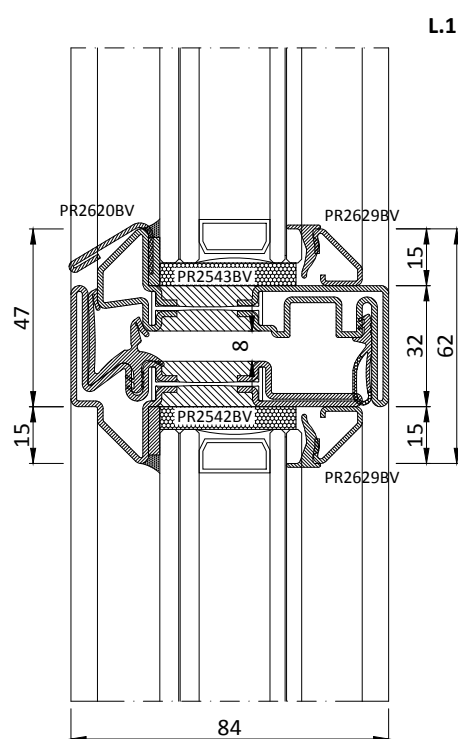
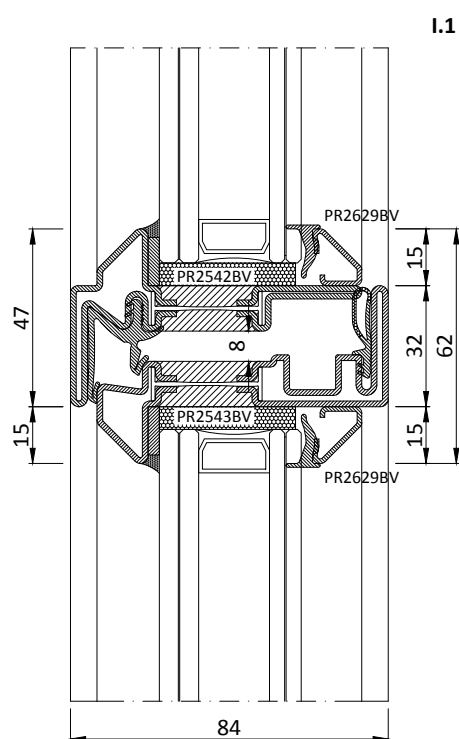
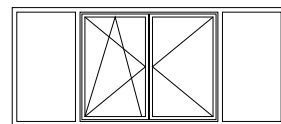
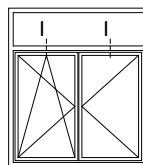
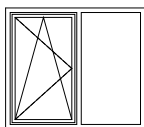
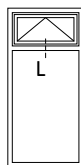
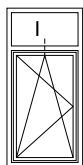
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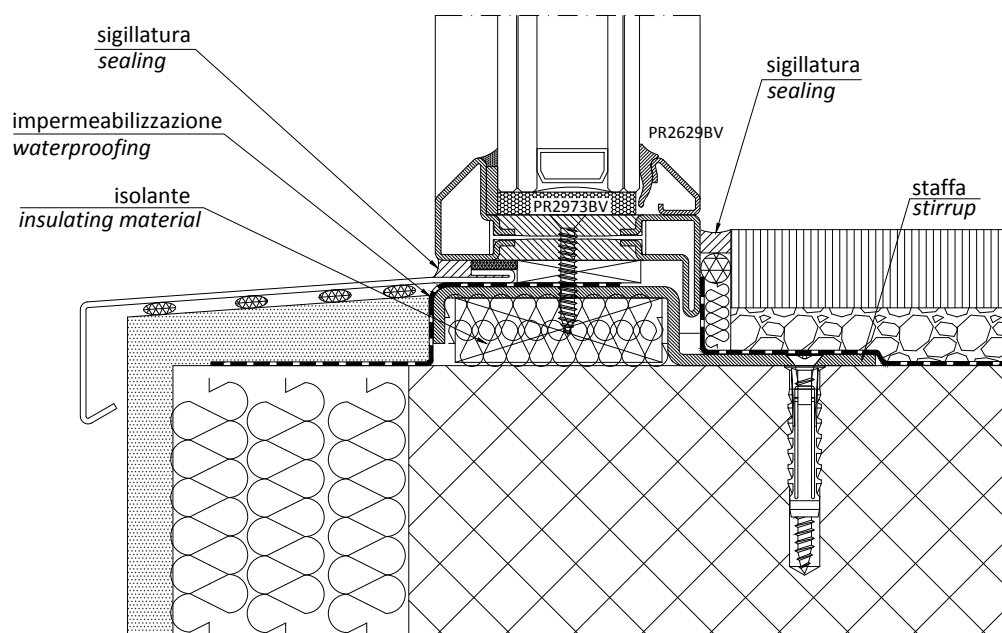
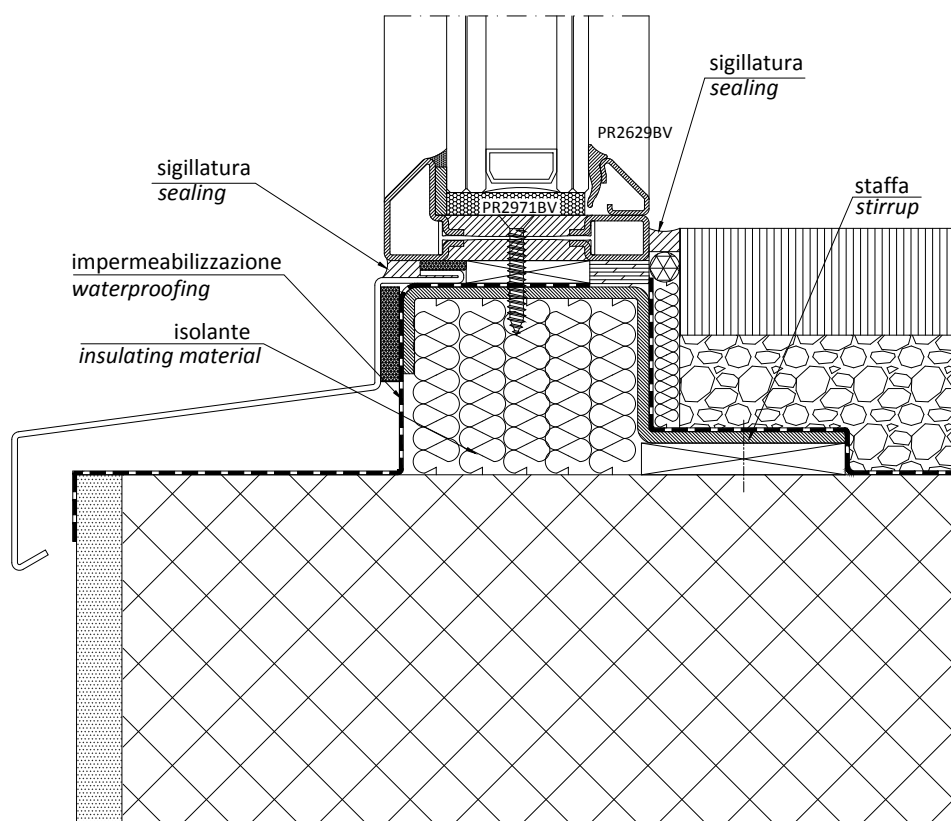


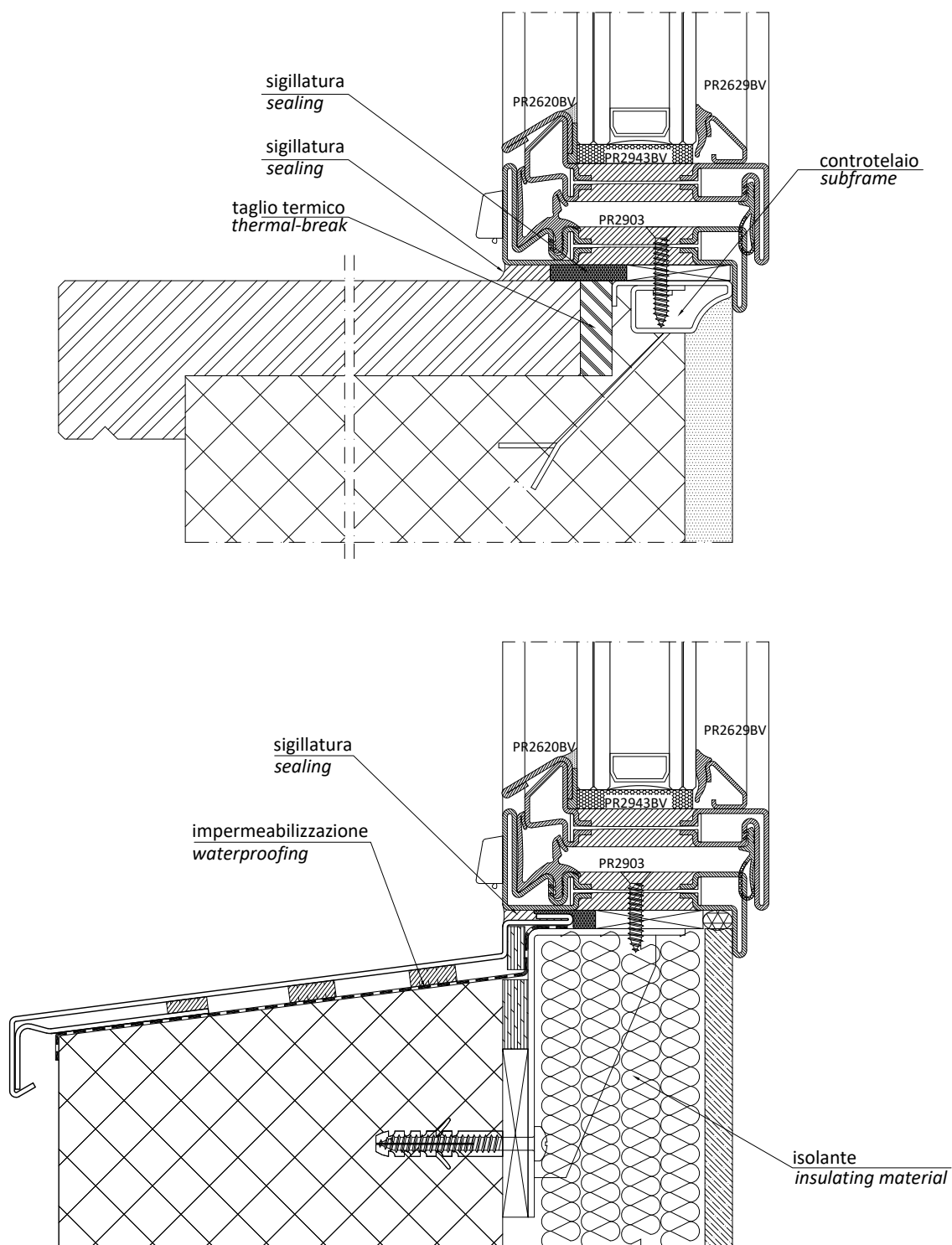


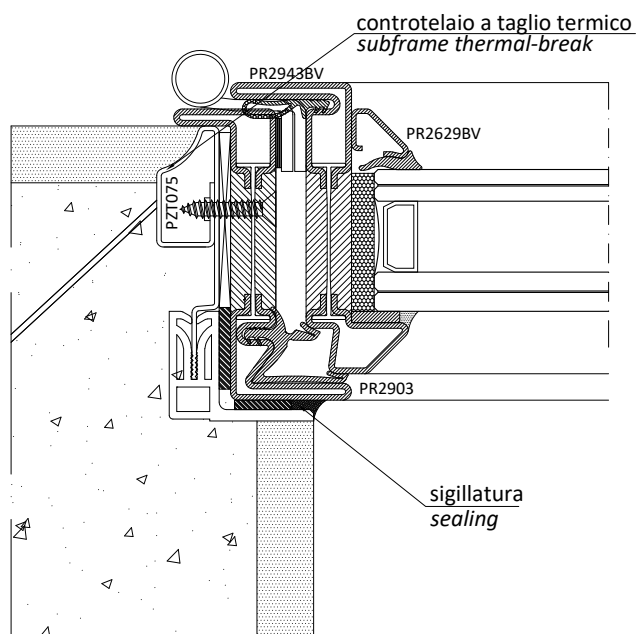
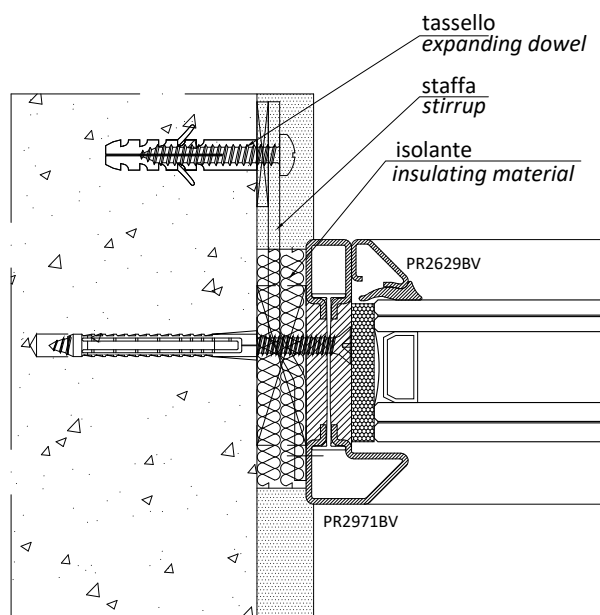
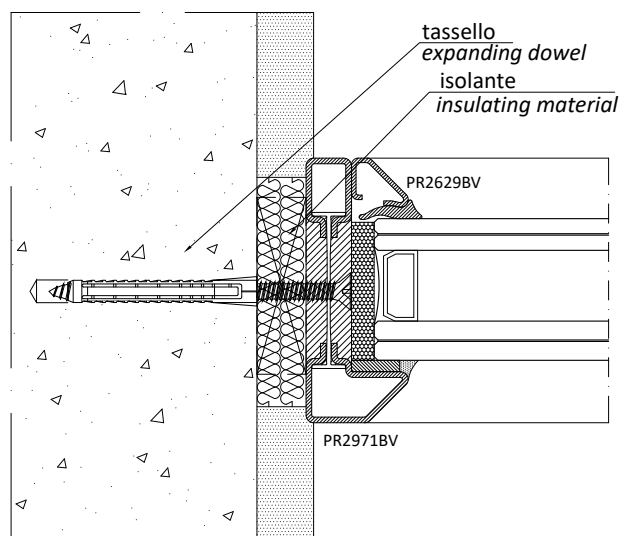


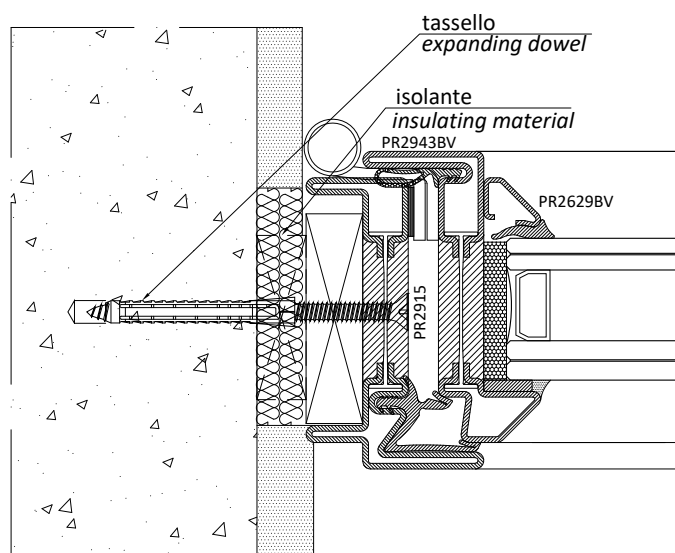




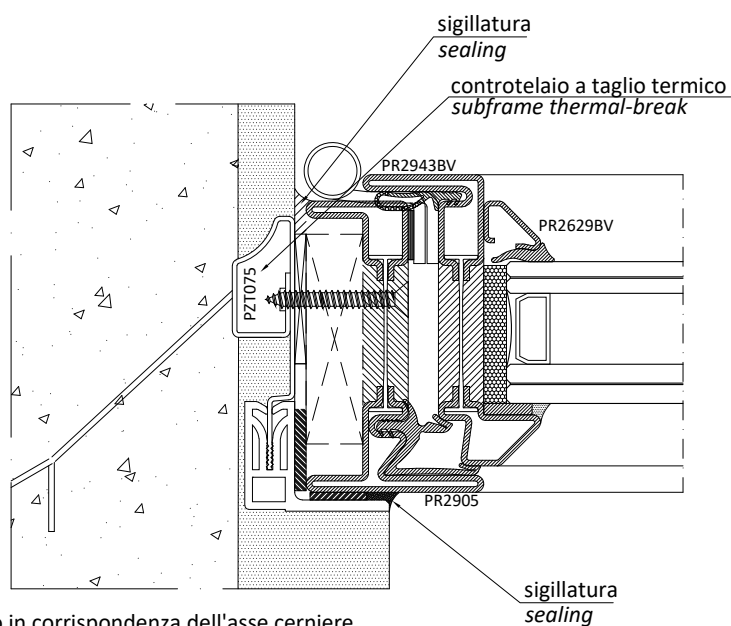
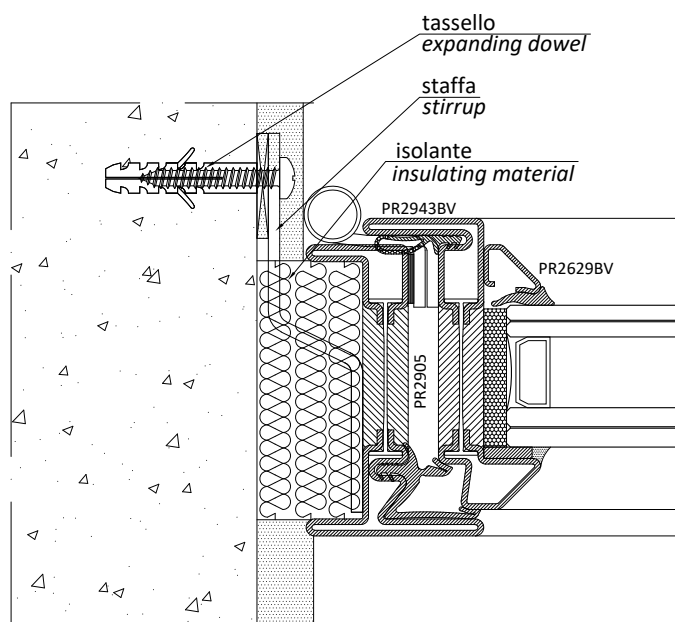




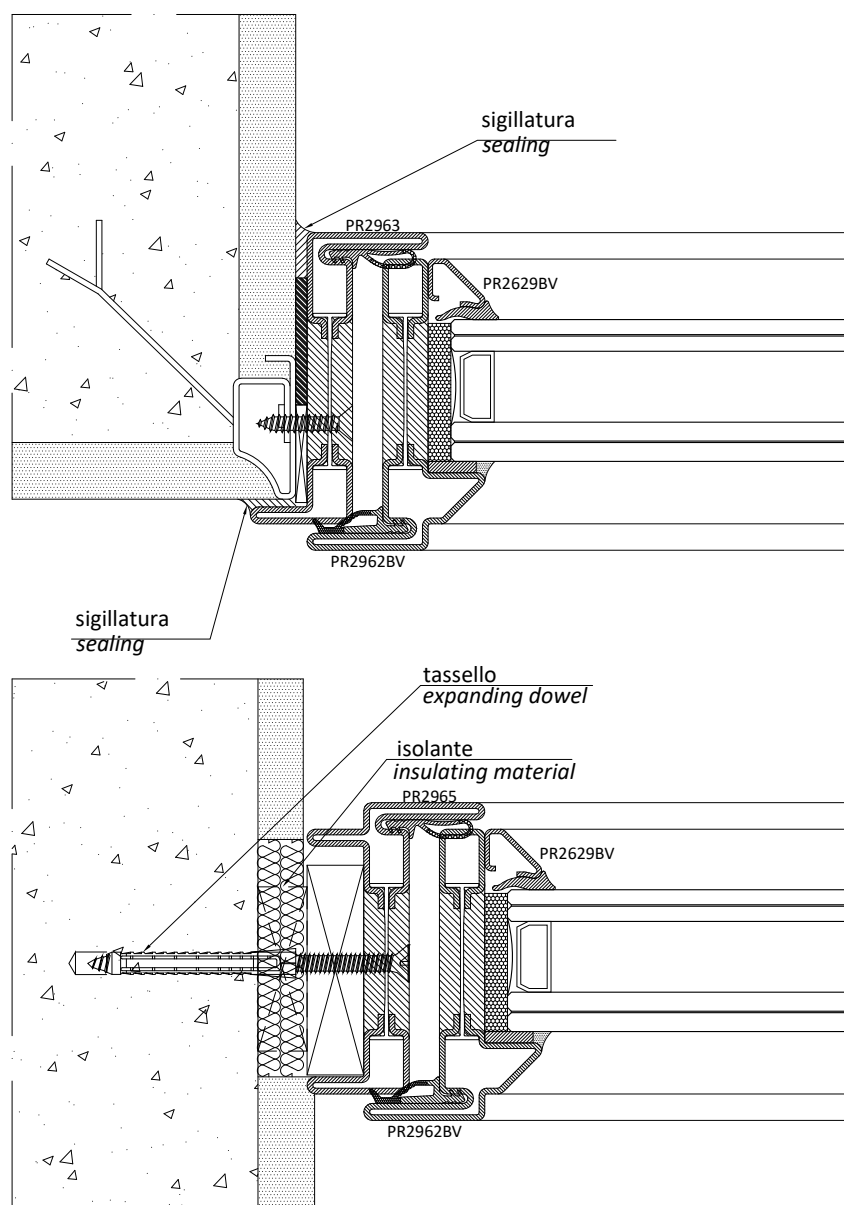




Applicare viti di
fissaggio profilo a
muro in
corrispondenza
dell'asse cerniere



Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
Fixing screws in correspondence of hinge axis



Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
 Fixing screws in correspondence of hinge axis

Lavorazioni su barra / Section working

Taglio / Cut	5.1.1-2 5.2.1-2
Fori per cerniere ad avvitare / Screw-on hinges holes	4.3.24-27
Fori e asole per cremonese / Cremonese bolt holes and slots	4.3.14-19
Fori e asole per chiusura supplementare / Additional locking points slots and holes	4.3.20-23
Fori per scarico acqua / Water drip holes	4.3.9
Taglio punta per inversione battuta / Secondary leaf top central joint working	4.3.3-8
Fori inserimento rinforzi cerniere / Hinge reinforcement holes	4.3.1-2
Fresatura per catenacci 2° anta / Secondary leaf flush bolt milling	4.3.37-38
Fori limitatori apertura per apertura ad anta / Casement restrictor stays holes	4.3.28-33
Fresature per compassi e limitatori sporgere / Stay arm and restrictor stays for awning windows milling	4.3.34-36
Lavorazione gocciolatoio / Water drip section workink	4.3.11-13
Fori fissaggio a muro / Wall mounting holes	3.3.1-5

Assiemaggio / AssemblyCostruzione telai / Frame assembly

Saldatura / Welding	4.4.1-4
Inserimento squadrette (profili ottone) / Brackets insertion (brass section)	4.4.3
Sigillatura interna della giunzione (profili ottone) / Internal joint sealing (brass sections)	4.4.1

Applicazione accessori / Accessories installation

Saldatura cerniere a saldare / Screw-on hinges holes	4.4.5-6
Fori snapper 2° anta / Secondary leaf snapper holes	4.5.4
Fori cricchetto e braccetti vasistas / Finger catch and stay arms for bottom hung window holes	4.5.14
Fori chiusure mediane a scomparsa / Concealed hinge side middle closing holes	4.5.12
Fori maniglia trascinalimento seconda anta / Pulling handle secondary leaf holes	4.5.15
Fori limitatori apertura per apertura ad anta / Restrictor stays holes	4.3.28-33
Fori per compassi e limitatori sporgere / Stay arm and restrictor stays for awning windows holes	4.3.34-36

Preparazione per verniciatura e ossidazione / Preparation for the powder coating - burnishing

Fori su telaio per scarichi liquidi pretrattamento / Holes on frame for the drainage of pretreatment liquid	5.1.4
Pulitura della superficie (ottone) / Cleaning of the surface	5.1.4

Montaggio accessori / Accessories installation

Applicazione e sigillatura guarnizioni giunto aperto / Sealing of central gasket	4.5.1-2
Applicazione scarichi acqua / Water drip installation	4.5.1
Montaggio cerniere / compassi / vasistas etc. / Hinges and arms installation (side hung, bottom-hung, awning)	4.5.12-23
Montaggio cremonese e incontri / Cremonese bolt installion	4.5.3-11
Montaggio guarnizioni di battuta / Gasket installation	...
Sigillatura angolo nel TT / Corner joint sealing	4.5.1

Vetrazione / Glazing

Applicazione clips fermavetro / Glazing bead clips installation	2.9.1-15
Applicazione vetro (spessoramento) / Glazing installation (setting blocks)	4.7.1-2

Lavorazioni su barra / Bar workings

Taglio / Cut	5.1.1-2 5.2.1-2
Fori per cerniere ad avvitare / Screw-on hinges holes	4.3.24-27
Fori e asole per serratura e incontri / Lock and strike slots and holes	4.3.41-44
Fori e asole per chiusura supplementare / Additional locking points slots and holes	4.3.45-46
Taglio punta per inversione battuta / Secondary leaf top central joint working	4.3.3-8
Fori inserimento rinforzi cerniere / Hinge reinforcement holes	4.3.1-2
Fresatura per catenacci 2° anta / Secondary leaf flush bolt milling	4.3.37-38
Fori fissaggio a muro / Wall mounting holes	3.3.1-5

Assiemaggio / Assembly

<u>Costruzione telai / Frame assembly</u>	
Saldatura / Welding	4.4.1-4
Inserimento squadrette (profili ottone) / Brackets insertion (brass section)	4.4.3
Sigillatura interna della giunzione (profili ottone) / Internal corner joint sealing (brass sections)	4.4.1
<u>Applicazione accessori / Accessories installation</u>	
Saldatura cerniere a saldare / Weld-on hinges welding	4.4.5-6
Lavorazione per paraspiro automatico / Automatic door bottom seal working	4.3.39-40

Preparazione per verniciatura e ossidazione / Preparation for the powder coating – burnishing

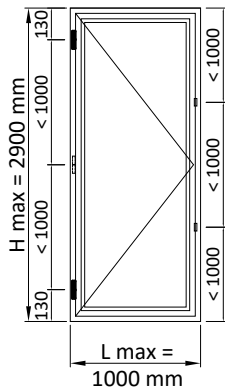
Fori su telaio per scarichi liquidi pretrattamento / Holes on frame for the drainage of pretreatment liquid	5.1.4
Pulitura della superficie (ottone) / Cleaning of the surface	5.1.4

Montaggio accessori / Accessories installation

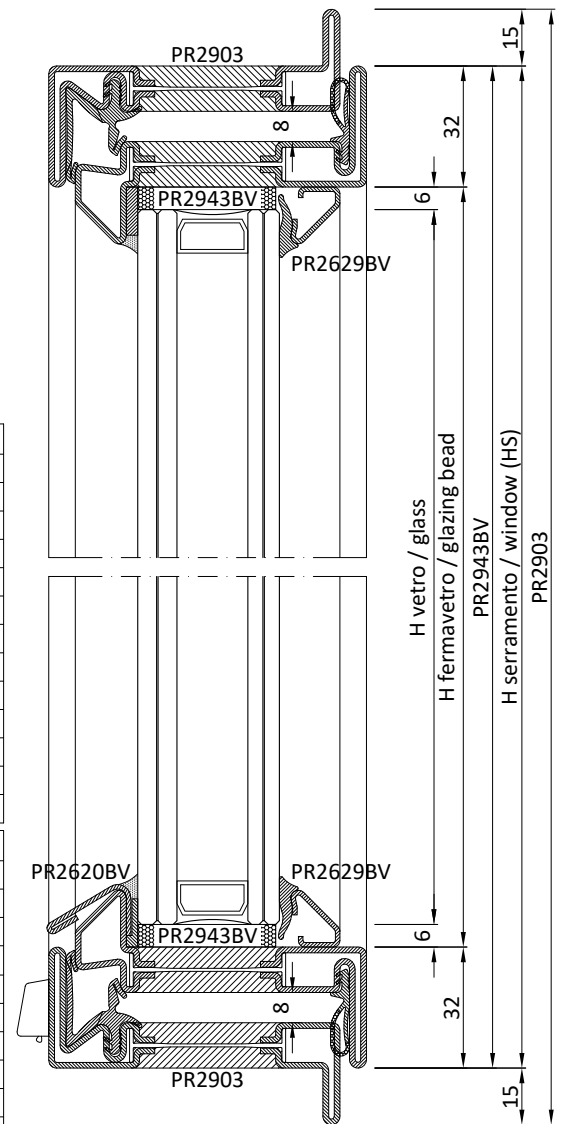
Montaggio cerniere / Hinges installation	4.3.24-27
Montaggio serratura e incontri / Lock and strikes installation	4.5.16-20
Applicazione paraspiro automatico / Automatic door bottom seal installation	4.3.39-40
Montaggio catenaccio / Flush bolt installation	4.3.37-38
Montaggio guarnizioni di battuta / Gasket installation	...
Sigillatura angolo nel TT / Corner joint sealing	4.5.1

Vetrazione / Glazing

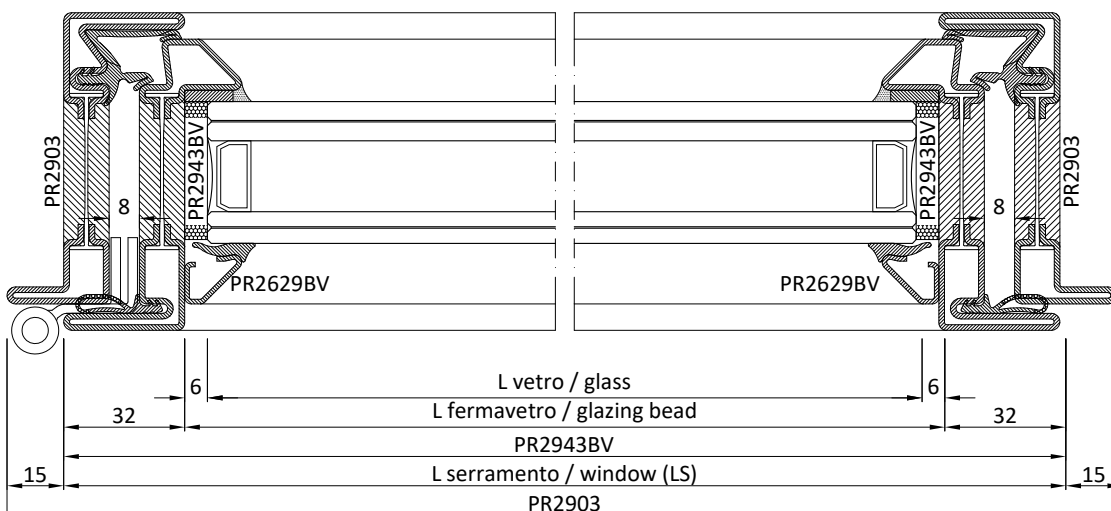
Applicazione clips fermavetro / Glazing bead clips installation	2.9.1-15
Applicazione vetro (spessoramento) / Glazing installation (setting blocks)	4.7.1-2

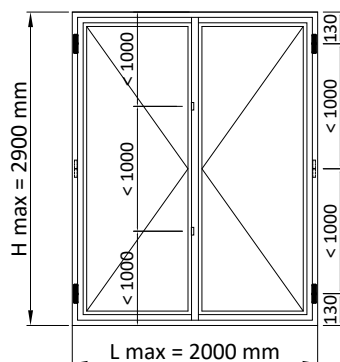


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
PR2903	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta			Leaf			
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri			Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC2618.xx	Scarico acqua	Water drip	Var.			
AC2625D/S	Kit cremonese	Cremone bolt set	1			
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.			
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.			
AC	Cerniere	Hinges	Var.			
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per PR2903	Corner brackets kit for PR2903	4			
AC2843BV*	Kit squadrette per PR2943BV	Corner brackets kit for PR2943	4			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2543TT	Guarnizione interna di battuta	Rebating gasket	1	2xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS		
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

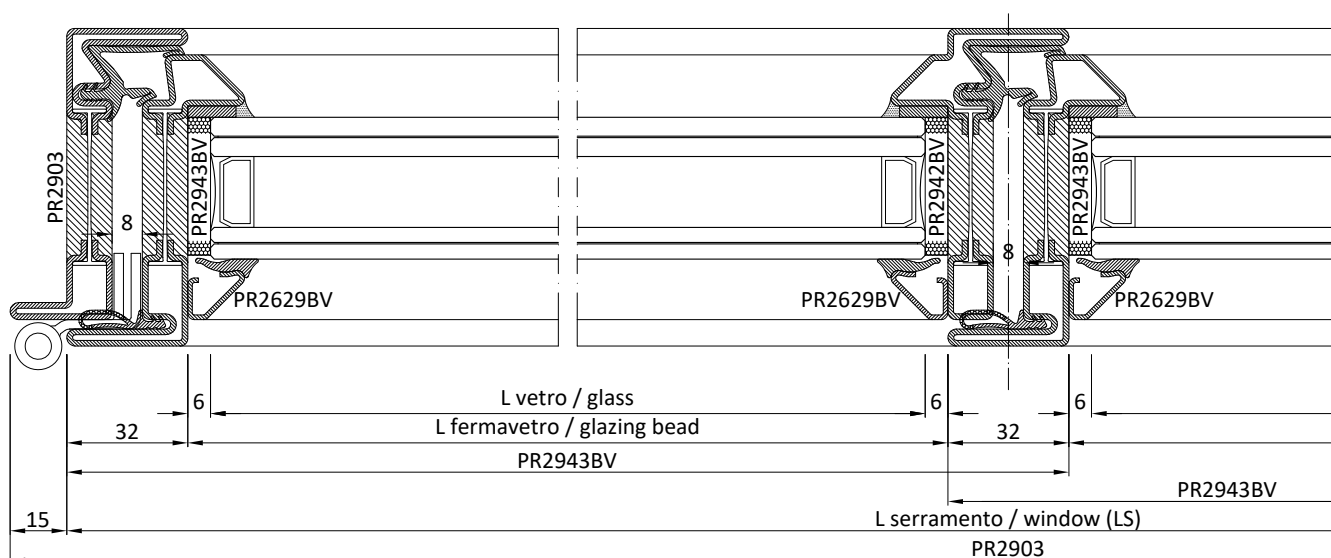


* solo con profili ottone
only with brass profiles





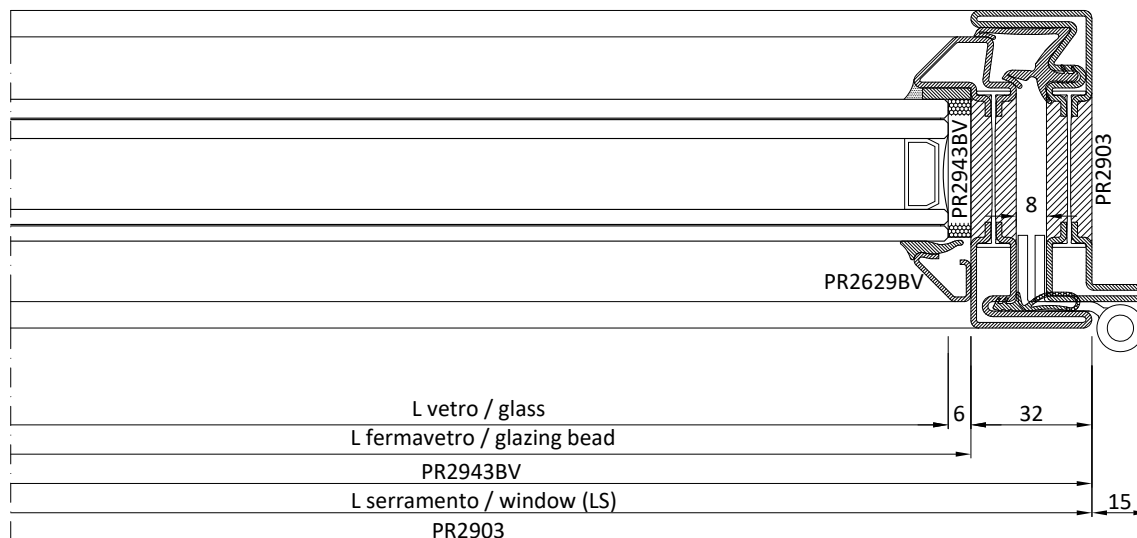
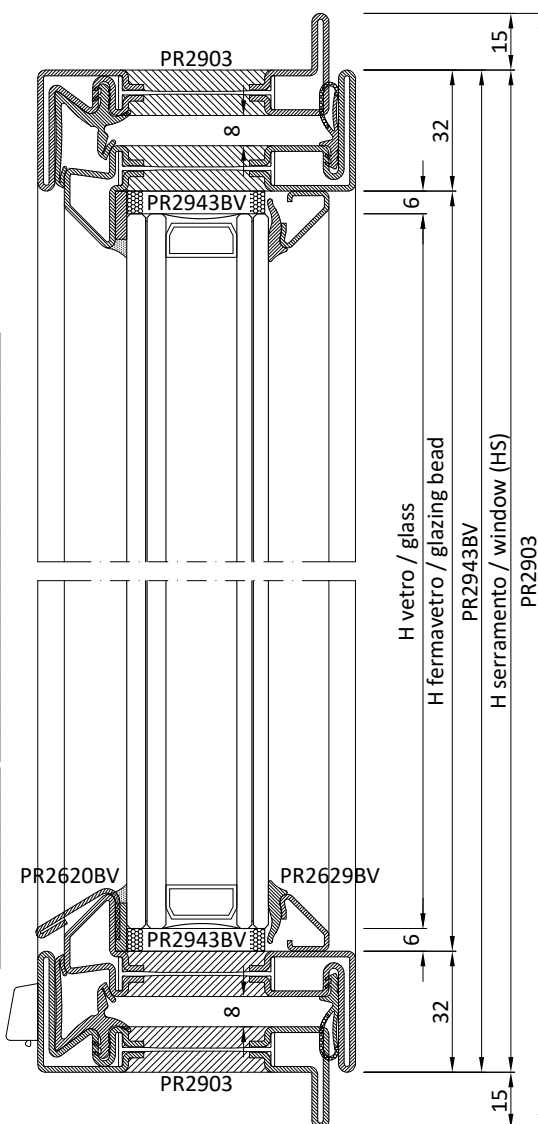
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2903	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45° 45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45° 45°
Anta		Leaf			
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45° 45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	3	HS	45° 45°
PR2942BV	Profilo a "T" anta	"T" profile leaf	1	HS	45° 45°
PR2620BV	Profilo battiacqua	Water drip profile	2	LS/2-53	90° 90°
Fermavetri		Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

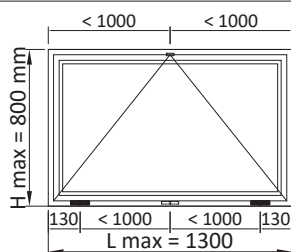


ACCESSORI		HARDWARE
Cod.	Descrizione	Description
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket
AC2618.xx	Scarico acqua	Water drip
AC2622	Fermo a scatto per 2 ^a anta	Snapper for second leaf window
AC2624D/S	Kit cremonese	Cremona bolt set
AC2626R	Kit per terza chiusura	Three-point lock system kit
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing
AC2652	Fondino per 2 ^a anta	Bottom plate for second leaf
AC	Cerniere	Hinges
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle
AC28031*	Kit squadrette per PR2903	Corner brackets kit for PR2903
AC2843BV*	Kit squadrette per PR2943BV-42BV	Corner brackets kit for PR2943BV-42BV
AC2843BV*	Kit squadrette per PR2943BV	Corner brackets kit for P.2943

GUARNIZIONI		GASKETS
Cod.	Descrizione	Description
GE2543TT	Guarnizione interna di battuta	Rebating gasket
GE2603	Guarnizione giunto aperto	Weather strip for open joint
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint
GP0095	Guarnizione interna vetro	Internal weather strip

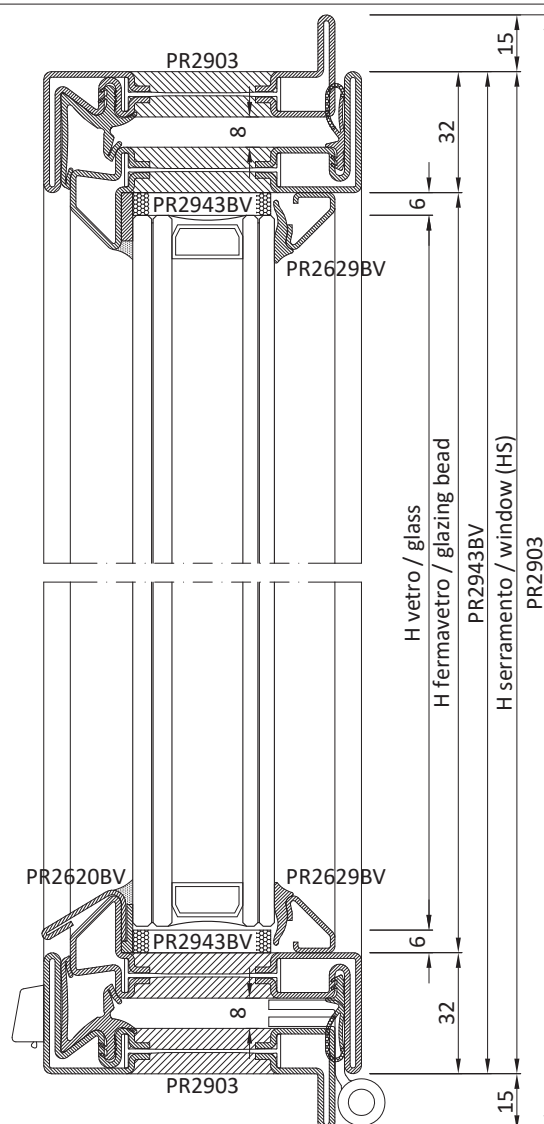
* solo con profili ottone
only with brass profiles





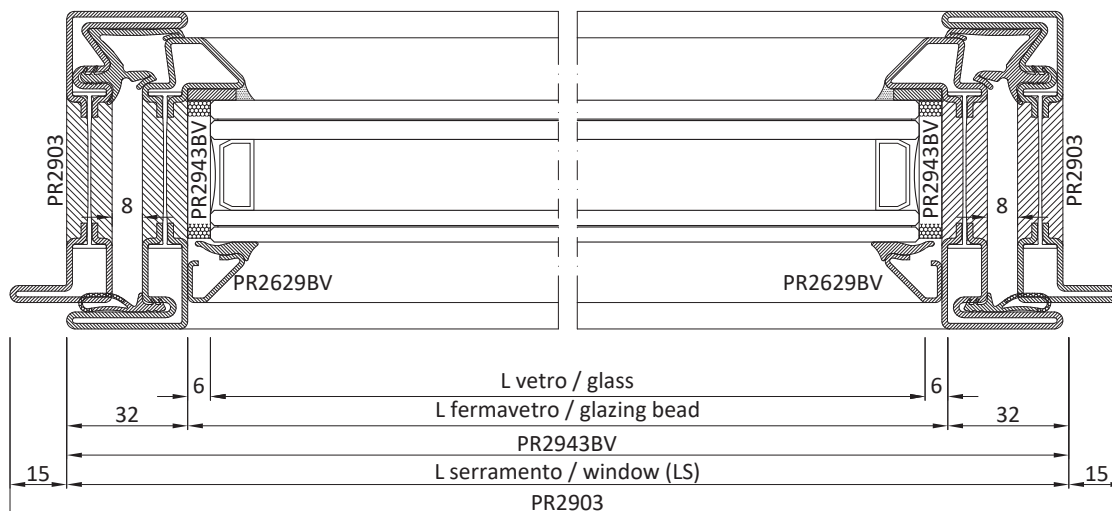
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri		Glazing beads				
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		

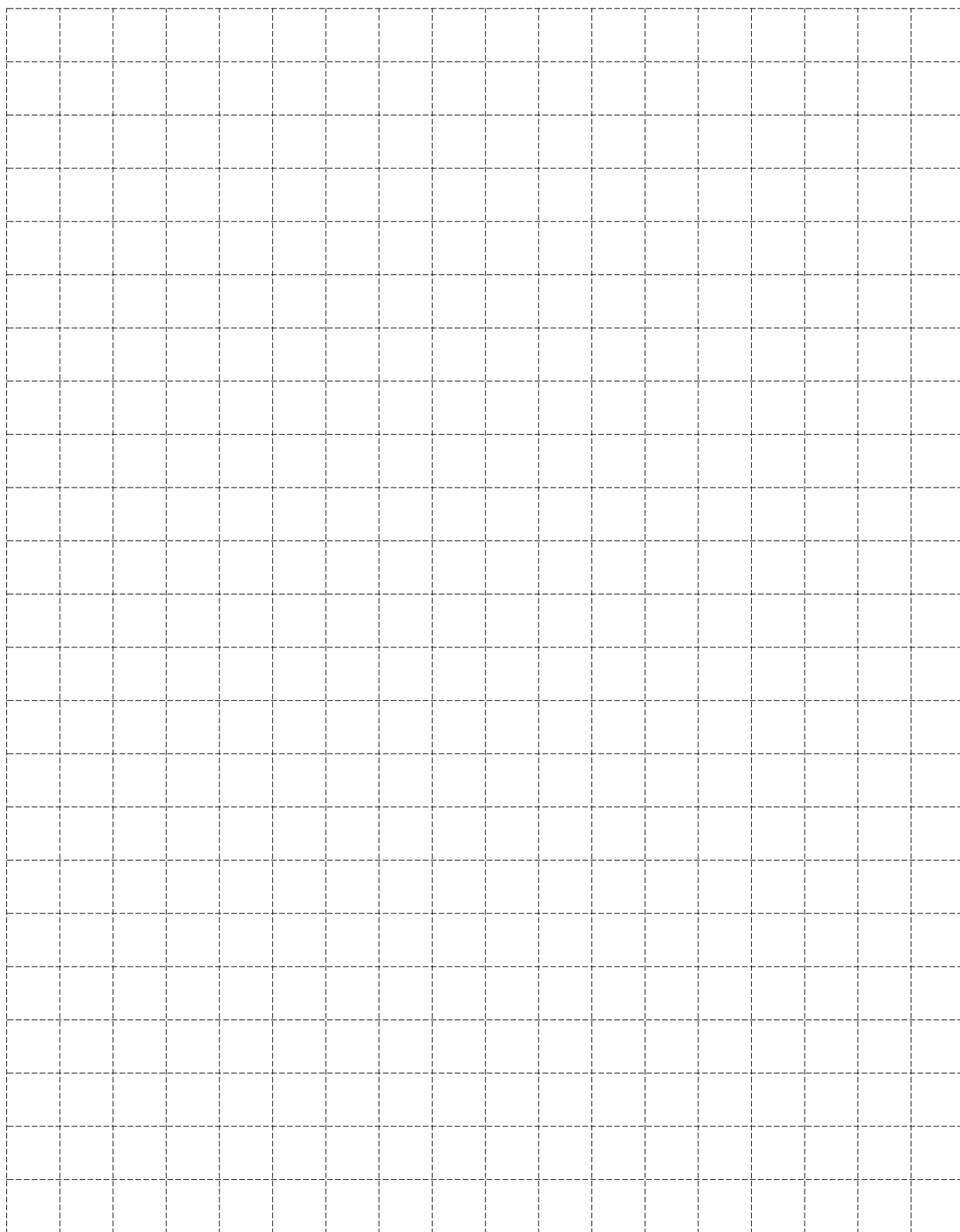
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4
AC2618.xx	Scarico acqua	Water drip	Var.
AC2640..	Cricchetto per vasistas	Finger catch for bottom-hung windows	1
AC2641	Braccetti per vasistas	Stays for bottom-hung windows	1
AC	Cerniere	Hinges	Var.
AC2803I*	Kit squadrette per PR2903	Corner brackets kit for PR2903	4
AC2843BV*	Kit squadrette per PR2943BV	Corner brackets kit for PR2943	4

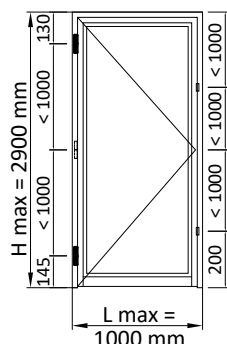


GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n°Dim.
GE2543TT	Guarnizione interna di battuta	Rebating gasket	1 2xLS+2xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1 2xLS+2xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS

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only with brass profiles



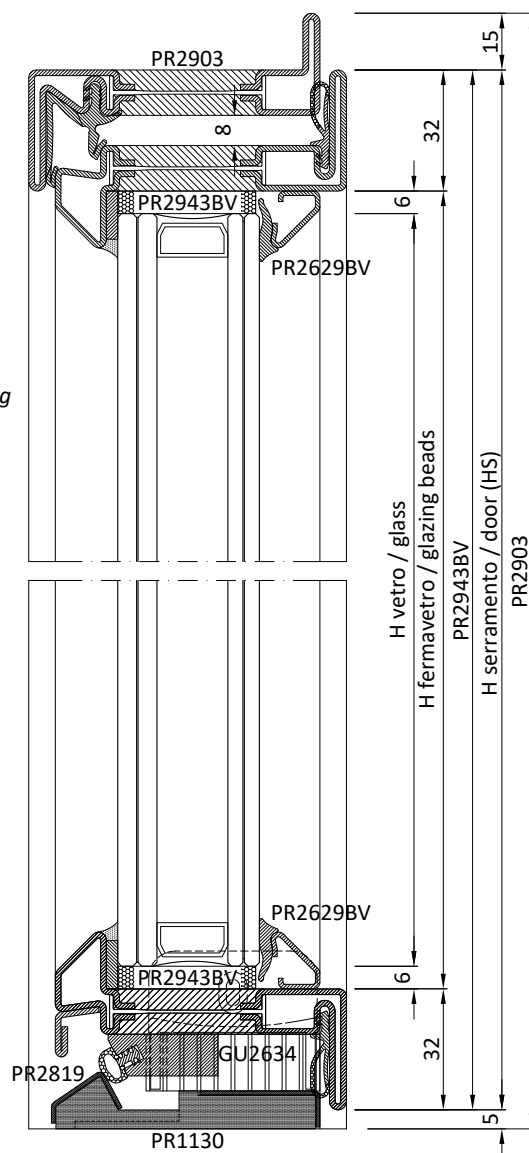




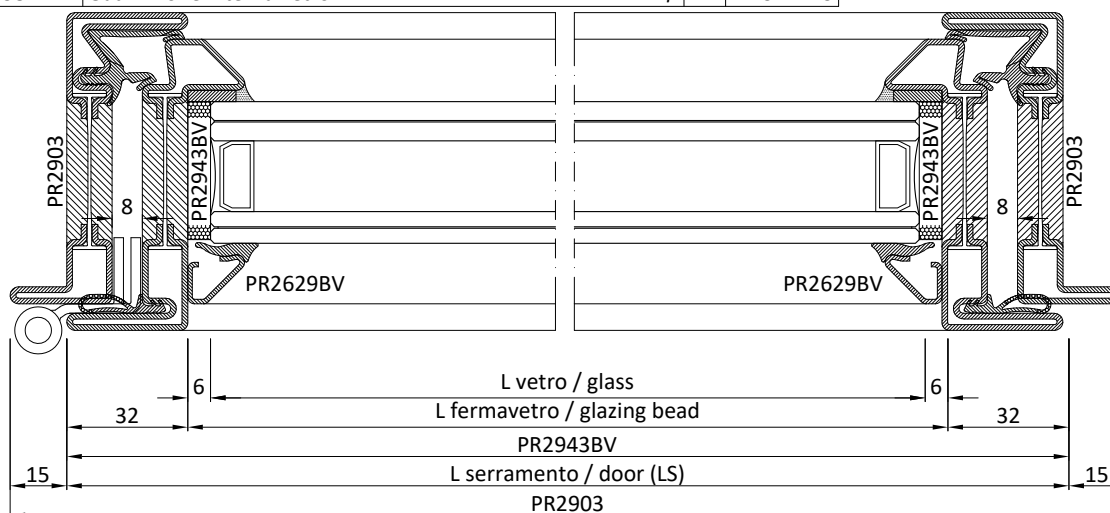
PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR1130	Profilo soglia	Threshold	1	LS-24	90°	90°
GU2634	Estruso in PVC	Rigid extruded PVC	1	LS-40	90°	90°
Anta		Leaf				
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	HS-5	45°	45°
PR2819	Profilo gocciolatoio	Closing profile	1	LS-52	90°	90°
Fermavetri		Glazing beads				
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-81		

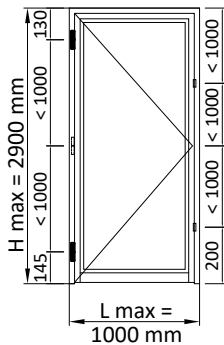
ACCESSORI		HARDWARE
Cod.	Descrizione	Description
AC2608	Clips fissaggio fermavetri	<i>Clips to secure glazing beads</i>
AC2617NG	Guarnizione d'angolo	<i>Vulcanised corner gasket</i>
AC1081T	Accessorio di battuta	<i>Stop accessory</i>
AC	Serratura	<i>Lock</i>
AC2695D/S	Punto di chiusura agg. (con AC2694)	<i>Additional closing</i>
AC2696BV	Scatola copri serratura	<i>Lock cover box</i>
AC	Cerniere	<i>Hinges</i>
ACV95..	Maniglia "Vitruvio"	<i>"Vitruvio" handle</i>
AC28031*	Kit squadrette per PR2903	<i>Corner brackets kit for PR2903</i>
AC2843BV*	Kit squadrette per PR2943BV	<i>Corner brackets kit for PR2943BV</i>

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione interna di battuta	<i>Rebating gasket</i>	1 1xLS+2xHS
GE1001TT	Guarnizione esterna di battuta	<i>Rebating gasket</i>	1 1xLS
GE2603	Guarnizione giunto aperto	<i>Weather strip for open joint</i>	1 1xLS+2xHS
GE2907TT	Guarnizione sotto vetro	<i>Gasket to put under the glass</i>	1 2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	<i>Adhesive shim for joint</i>	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	<i>Internal weather strip</i>	1 2xLS+2xHS



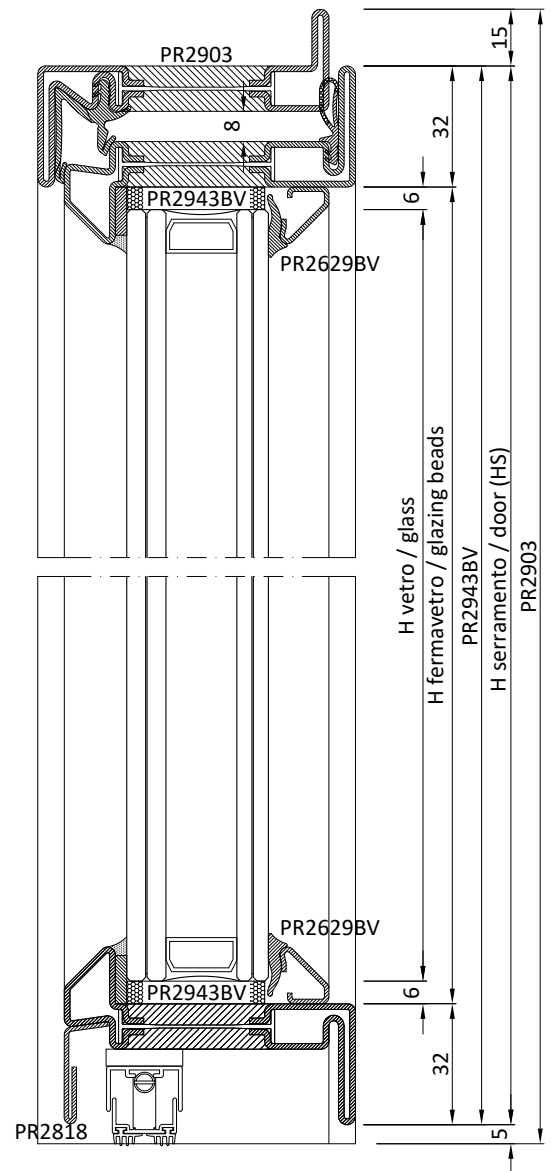
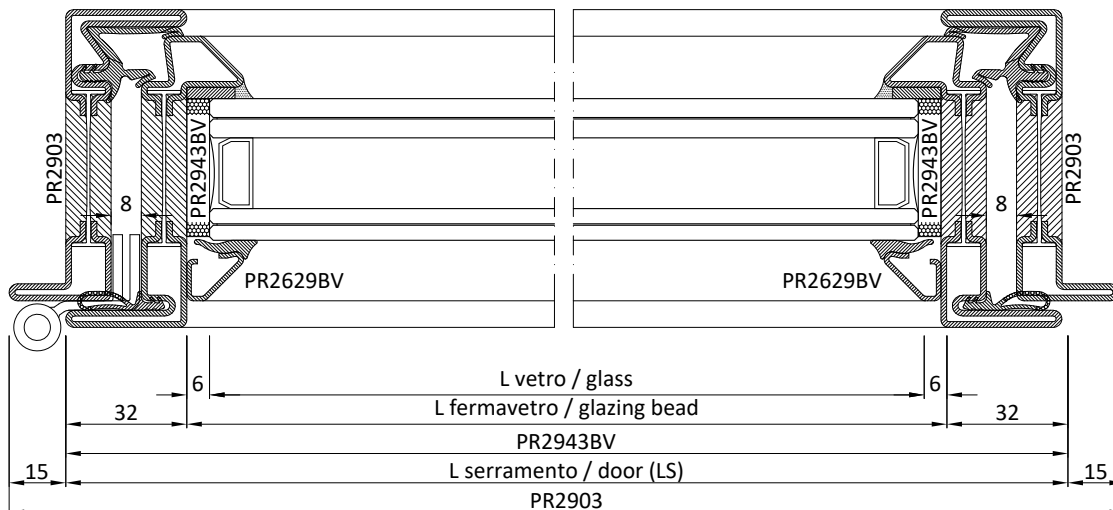
* solo con profili ottone
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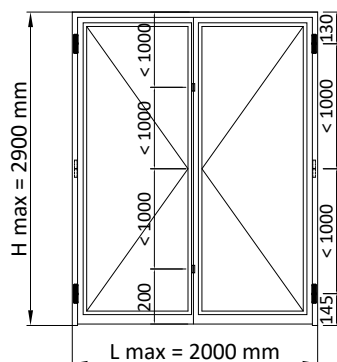




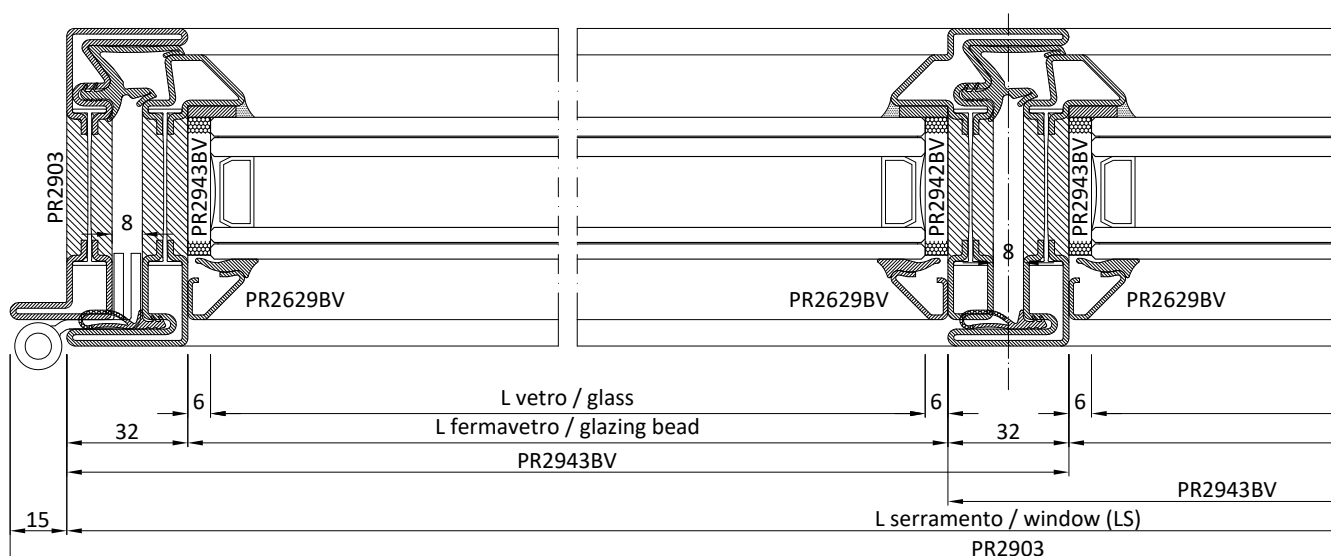
PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta			Leaf			
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	2	HS-5	45°	45°
PR2818	Profilo gocciolatoio	Water drip profile	1	LS-52	90°	90°
Fermavetri			Glazing beads			
PR2926BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2626BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-78 x HS-78		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	2			
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	1			
AC	Serratura	Lock	1			
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.			
AC2696BV	Scatola copri serratura	Lock cover box	1			
AC	Cerniere	Hinges	Var.			
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per PR2903	Corner brackets kit for PR2903	2			
AC2843BV*	Kit squadrette per PR2943BV	Corner brackets kit for PR2943BV	4			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2543TT	Guarnizione interna di battuta	Rebating gasket	1	1xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	1xLS+2xHS		
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

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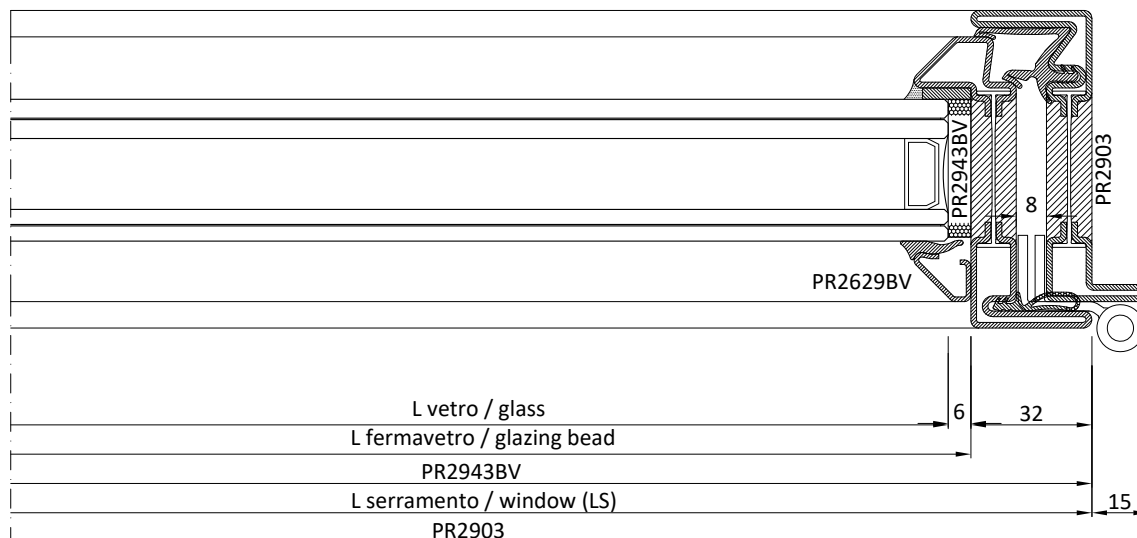
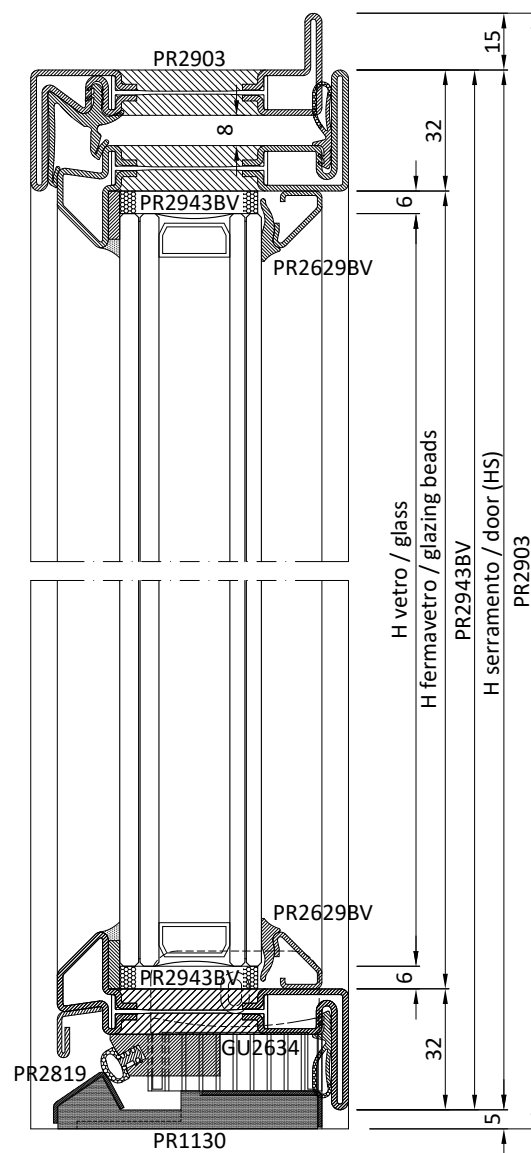
Cod.	PROFILI Descrizione	PROFILES Description	n°Dim.	Taglio Cutting
	Telaio	Frame		
PR2903	Profilo a "Z" telaio	"Z" profile frame	1 LS+30	45° 45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1 HS+15	45° 90°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1 HS+15	90° 45°
PR1130	Profilo soglia per porta	Profile for door threshold	1 LS-24	90° 90°
GU2634	Profilo porta guarnizione di battuta	Rebate gasket profile	1 (LS-48)/2	90° 90°
GU2634	Profilo porta guarnizione di battuta	Rebate gasket profile	1 ((LS-48)/2)+5	90° 90°
	Anta	Leaf		
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	4 LS/2+16	45° 45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	3 HS-5	45° 45°
PR2942BV	Profilo a "T" anta	"T" profile leaf	1 HS-5	45° 45°
PR2819	Profilo gocciolatoio	Water drip profile	2 LS/2-35	90° 90°
	Fermavetri	Glazing beads		
PR2629BV	Profilo fermavetro	Glazing bead profile	4 LS/2-48	45° 45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4 HS-69	45° 45°
	Vetri	Glass unit		
-	Vetrocamera	Insulated glass	2 LS/2-60 x HS-81	

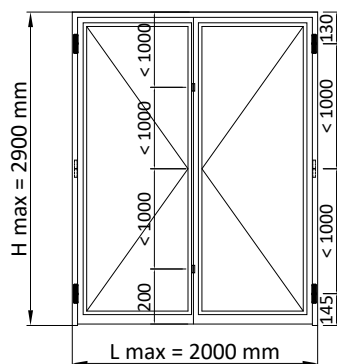


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	2
AC2621G.-	Catenaccio 2^ anta	Second leaf bolt	2
AC1081T	Accessorio di battuta	Stop accessory	2
AC2652	Fondino per 2^ anta	Botton plate for second leaf	2
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696BV	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per PR2903	Corner brackets kit for PR2903	2
AC2843BV*	Kit squadrette per PR2943BV-42BV	Corner brackets kit for PR2943BV-32BV	2
AC2843BV*	Kit squadrette per PR2943BV	Corner brackets kit for PR2943BV	6

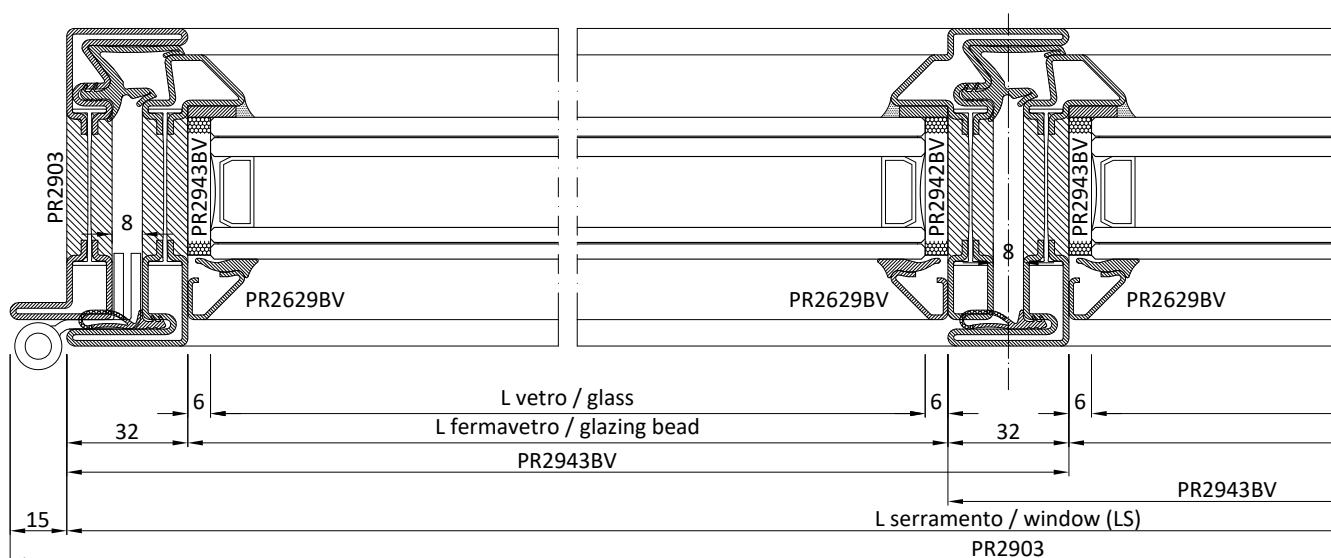
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione interna di battuta	Rebating gasket	1	1xLS+3xHS
GE1001TT	Guarnizione di battuta	Rebating gasket	1	1xLS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put 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

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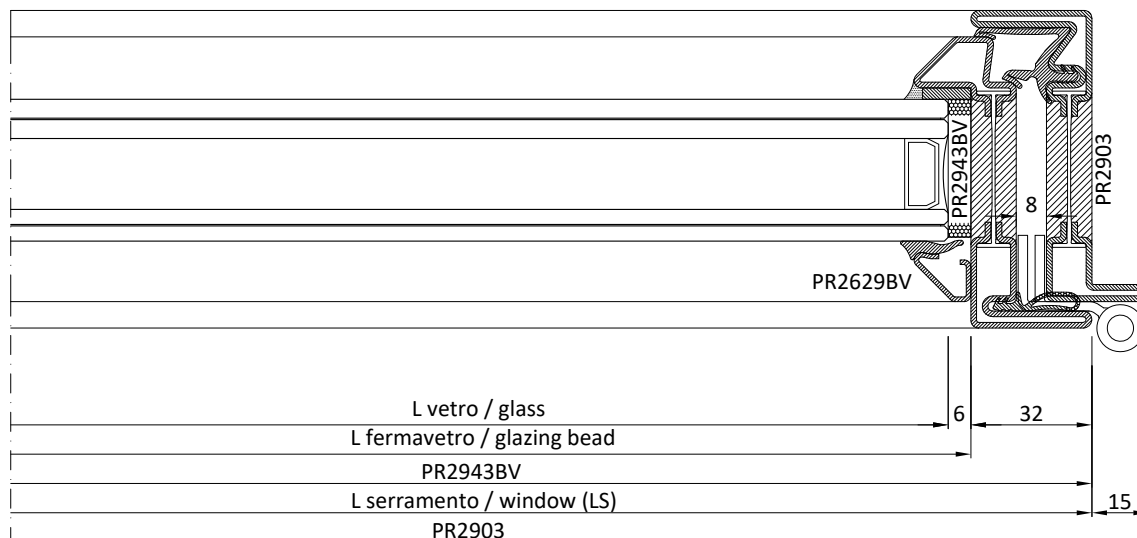
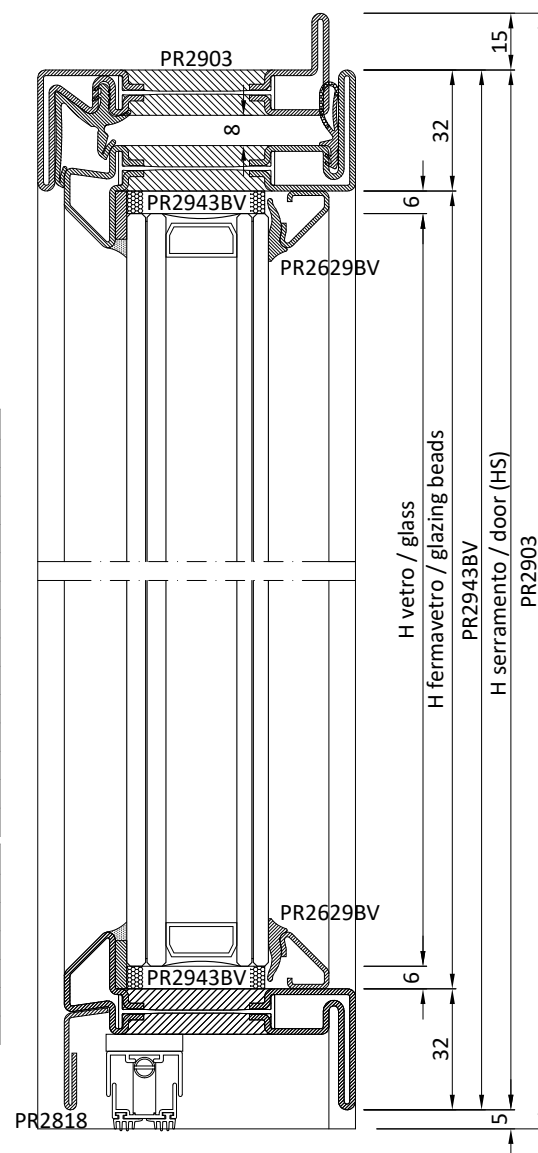
Cod.	PROFILI Descrizione	PROFILES Description	n°	Dim.	Taglio	Cutting
	Telaio	Frame				
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
	Anta	Leaf				
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45°	45°
PR2943BV	Profilo a "Z" anta	"Z" profile leaf	3	HS-5	45°	45°
PR2942BV	Profilo a "T" anta	"T" profile leaf	1	HS-5	45°	45°
PR2818	Profilo gocciolatoio	Water drip profile	2	LS/2-36	90°	90°
	Fermavetri	Glazing beads				
PR2629BV	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
	Vetri	Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81		

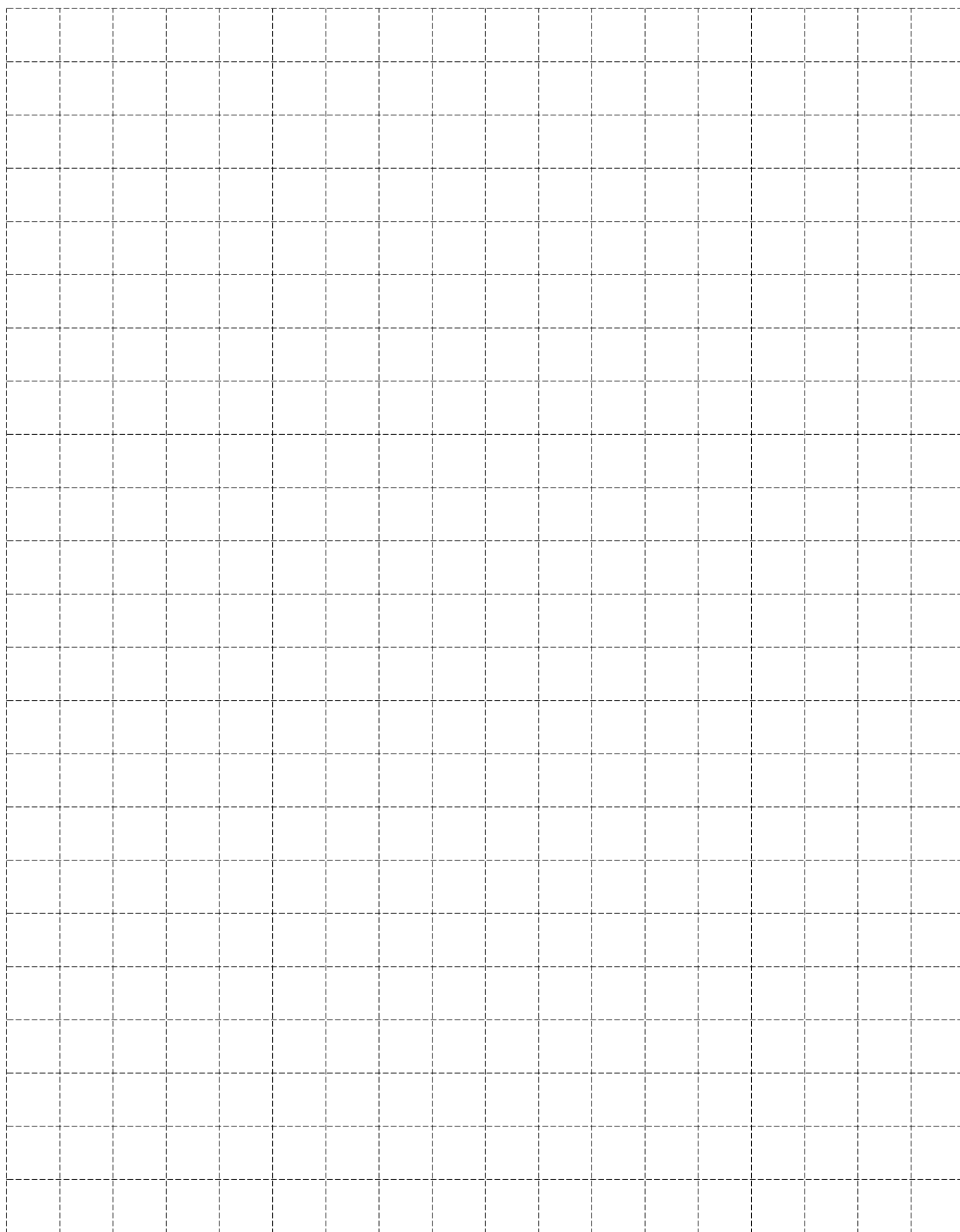


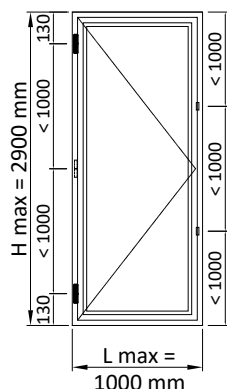
ACCESSORI		HARDWARE
Cod.	Descrizione	Description
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket
AC2621G.-	Catenaccio 2^ anta	Second leaf bolt
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket
AC2652	Fondino per 2^ anta	Bottom plate for second leaf
AC	Serratura	Lock
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing
AC2696BV	Scatola copri serratura	Lock cover box
AC	Cerniere	Hinges
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle
AC2803I*	Kit squadrette per PR2903	Corner brackets kit for PR2903
AC2843BV*	Kit squadrette per PR2943BV-42BV	Corner brackets kit for PR2943BV-32BV
AC2843BV*	Kit squadrette per PR2943BV	Corner brackets kit for PR2943BV

GUARNIZIONI		GASKETS
Cod.	Descrizione	Description
GE2543TT	Guarnizione esterna di battuta	Rebating gasket
GE2603	Guarnizione giunto aperto	Weather strip for open joint
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint
GP0095	Guarnizione interna vetro	Internal weather strip

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only with brass profiles



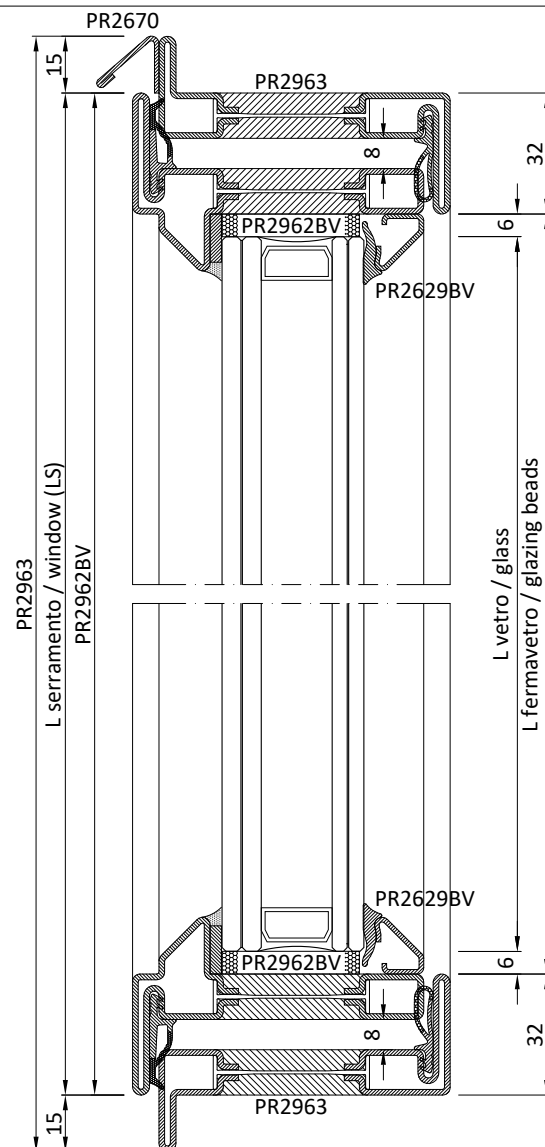




PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2963	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta		Leaf				
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	LS	45°	45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	HS	45°	45°
Fermavetri		Glazing beads				
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		

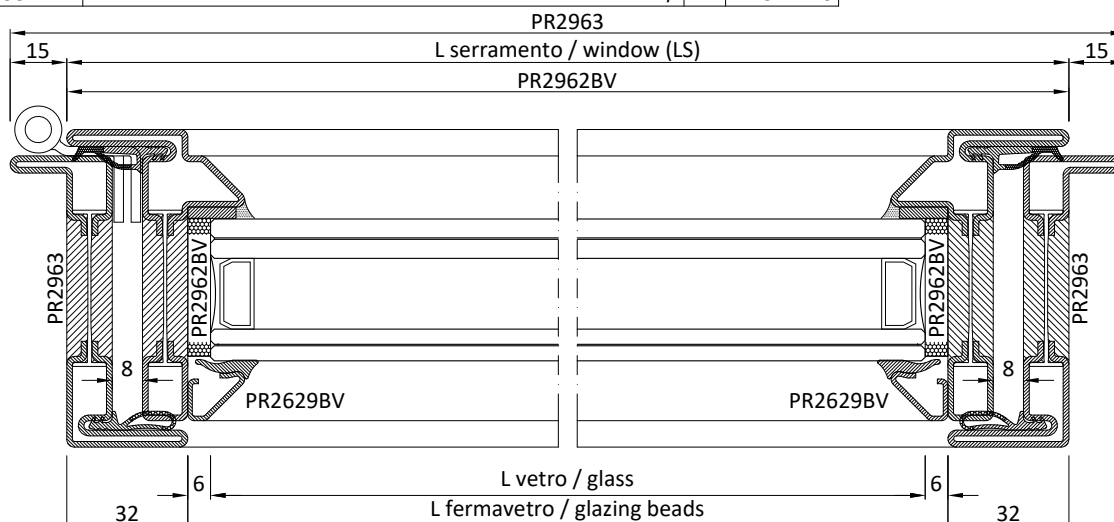
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2680 ..	Maniglia di trascinamento	Dragging leaf handle	1
AC2683D/S	Kit cremonese	Cremona bolt set	1
AC2687	Braccetti limitatori	Casement stays	Opz.
AC	Cerniere	Hinges	Var.
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per PR2963	Corner brackets kit for P.2963	4
AC2862BV*	Kit squadrette per PR2962BV	Corner brackets kit for PR2962BV	4
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

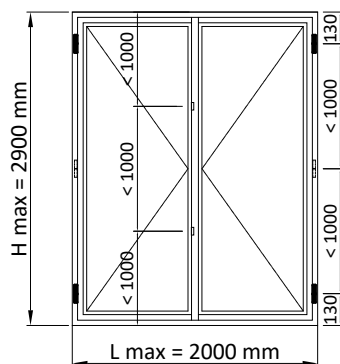
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n°Dim.
GE2543TT	Guarnizione interna di battuta	Rebating gasket	2 2xLS+2xHS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 2xLS+2xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS



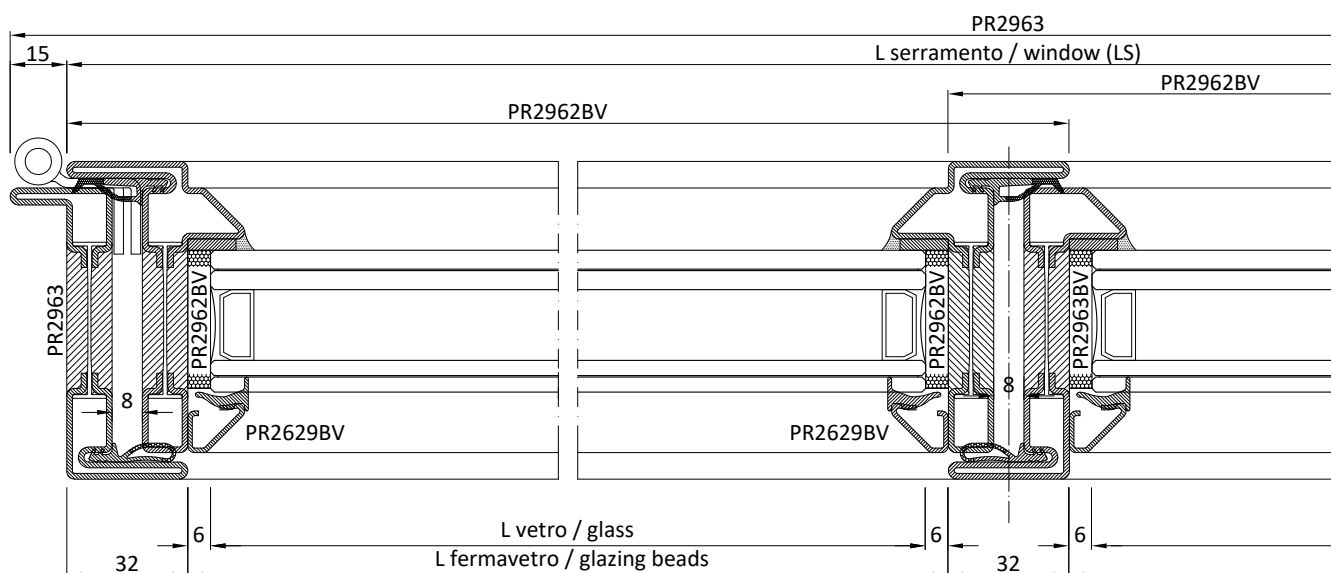
* solo con profili ottone
only with brass profiles

** 1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949





PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2963	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45° 45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45° 45°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90° 90°
Anta		Leaf			
PR2962BV	Profilo a "T" anta	"T" profile leaf	4	LS/2+16	45° 45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	3	HS	45° 45°
PR2963BV	Profilo a "Z" anta	"Z" profile leaf	1	HS	45° 45°
Fermavetri		Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

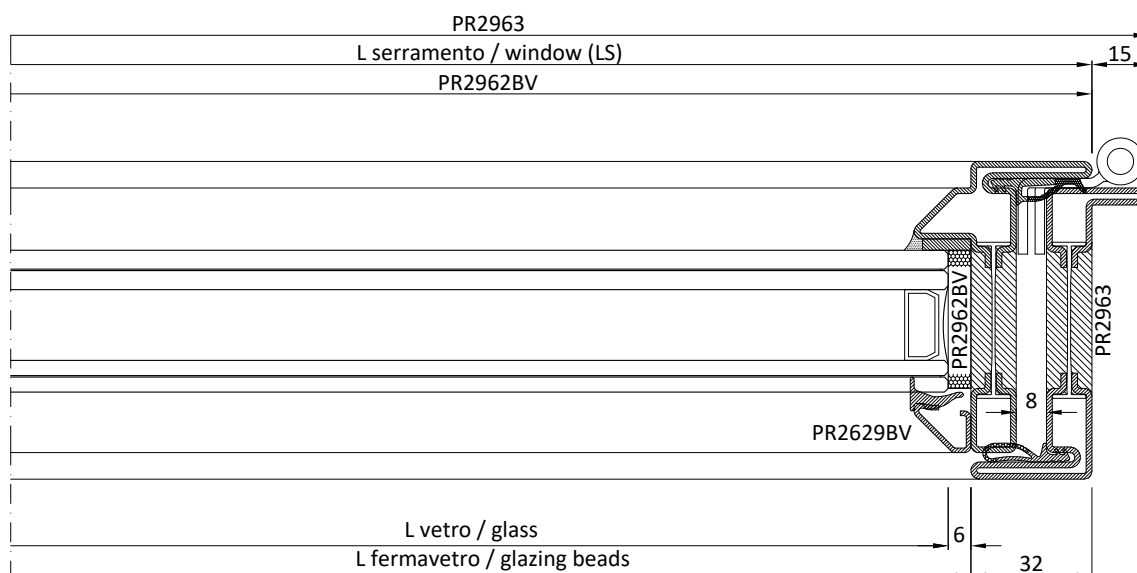
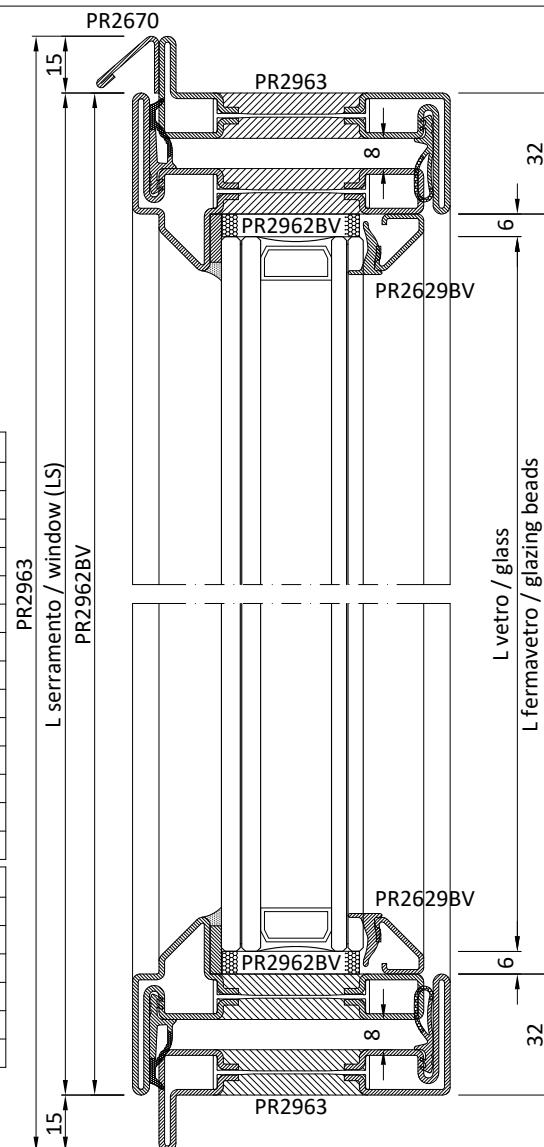


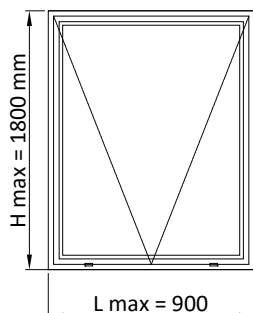
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2653	Fondino per 2^ anta	Botton plate for second leaf	2
AC2680	Maniglia di trascinamento	Dragging leaf handle	1
AC2684D/S	Kit cremonese	Cremona bolt set	1
AC2687	Braccetti limitatori	Casement stays	Opz.
AC	Cerniere	Hinges	Var.
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC28031*	Kit squadrette per PR2963	Corner brackets kit for PR2963	4
AC2843BV*	Kit squadrette per PR2962BV-63BV	Comer brackets kit for PR2962BV-63BV	2
AC2862BV*	Kit squadrette per PR2962BV	Corner brackets kit for PR2962BV	6
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione interna di battuta	Rebating gasket	2	2xLS+3xHS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	2xLS+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

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**1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949

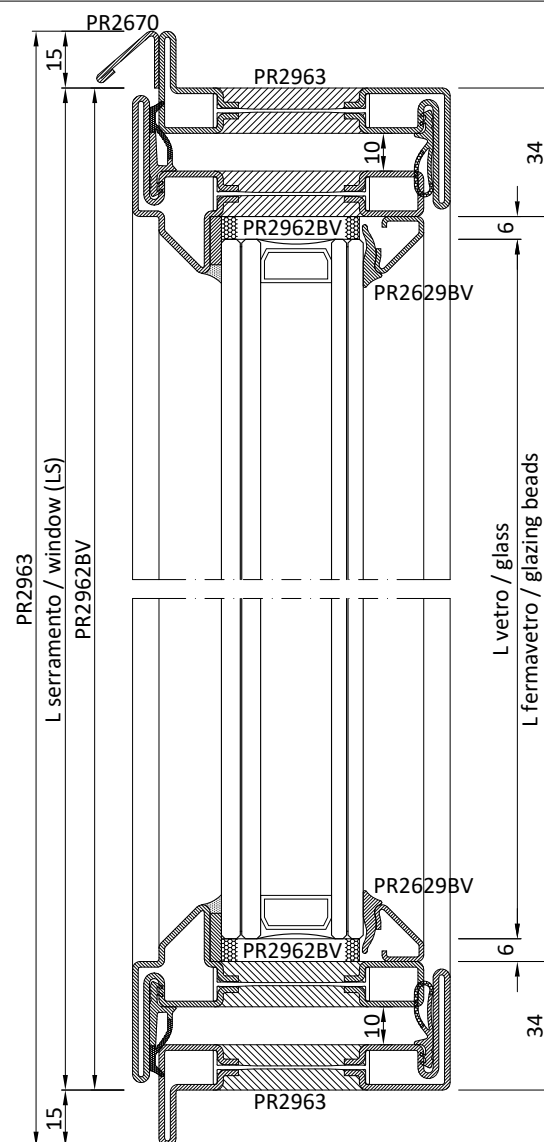




PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2963	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta		Leaf				
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	LS-4	45°	45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	HS-4	45°	45°
Fermavetri		Glazing beads				
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-68	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-68	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-80 x HS-80		

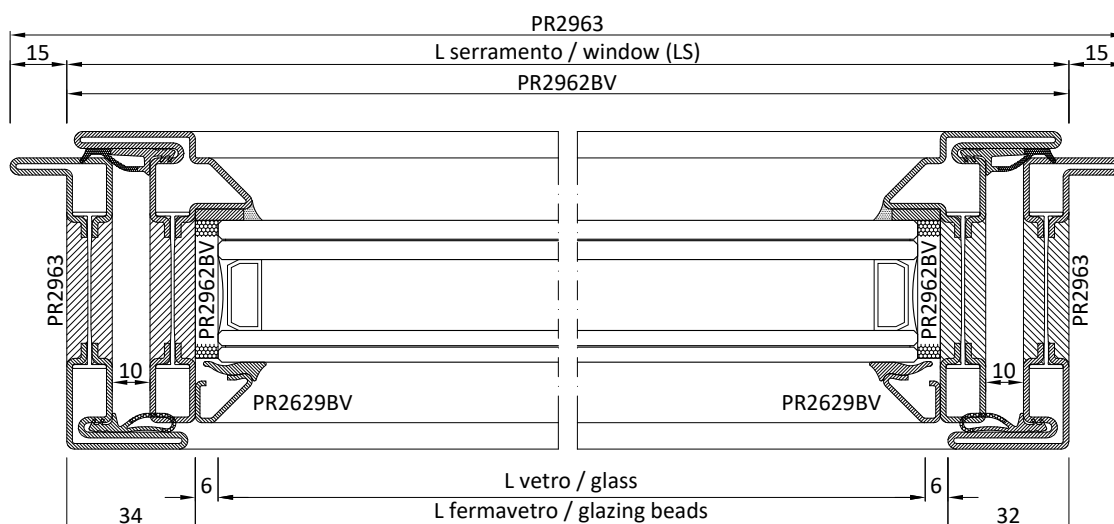
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2680 ..	Maniglia di trascinamento	Dragging leaf handle	1
AC2683D/S	Kit cremonese	Cremone bolt set	1
AC	Coppia compassi	Pair of side arm	1
AC	Cerniere (solo con AC2690)	Hinges (only with AC2690)	Opz.
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC28031*	Kit squadrette per PR2963	Corner brackets kit for PR2963	4
AC2862BV*	Kit squadrette per PR2962BV	Corner brackets kit for PR2962BV	4
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

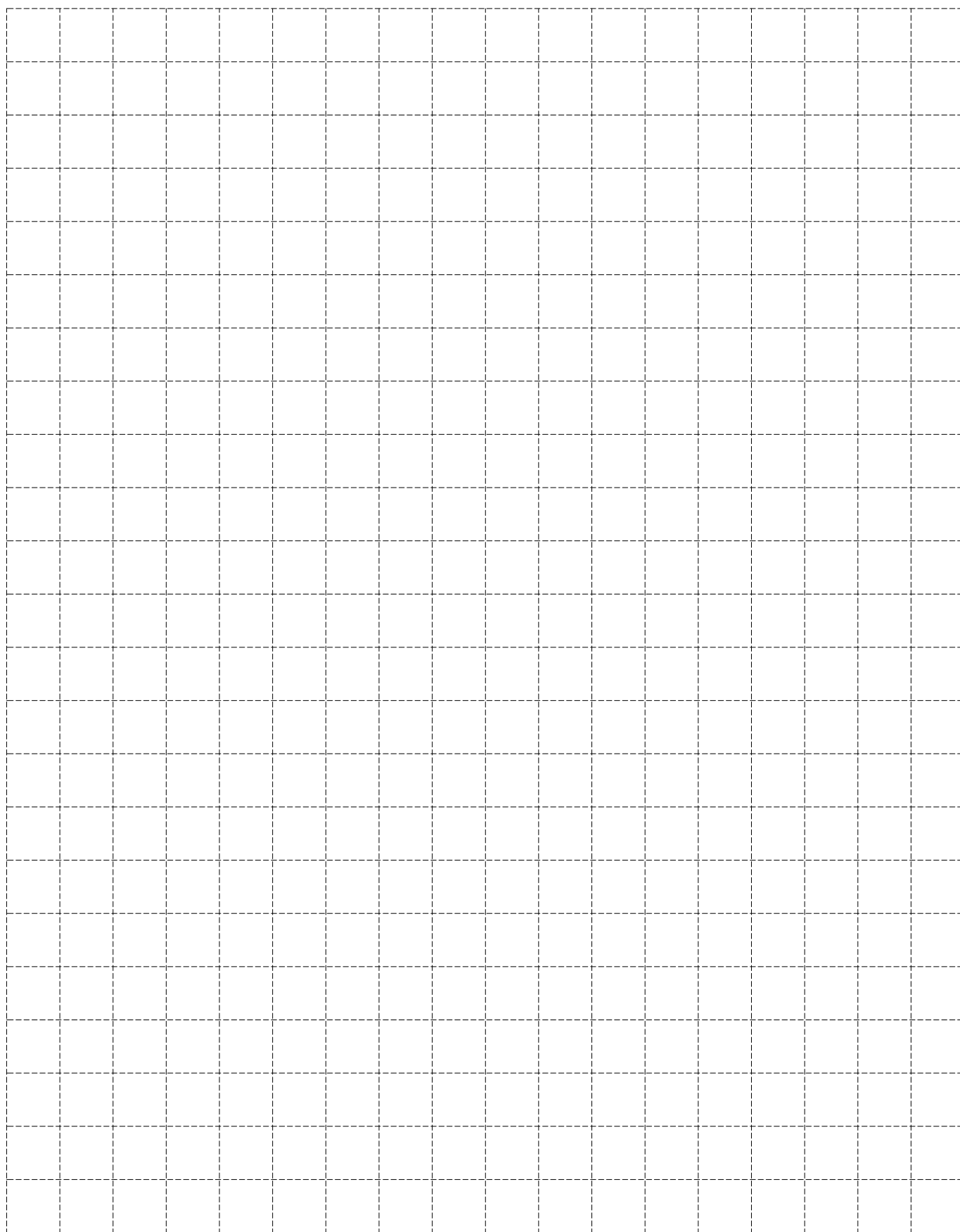
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n°Dim.
GE2543TT	Guarnizione interna di battuta	Rebating gasket	2 2xLS+2xHS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 2xLS+2xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS

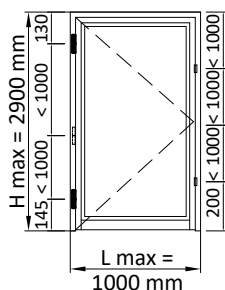


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** 1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949



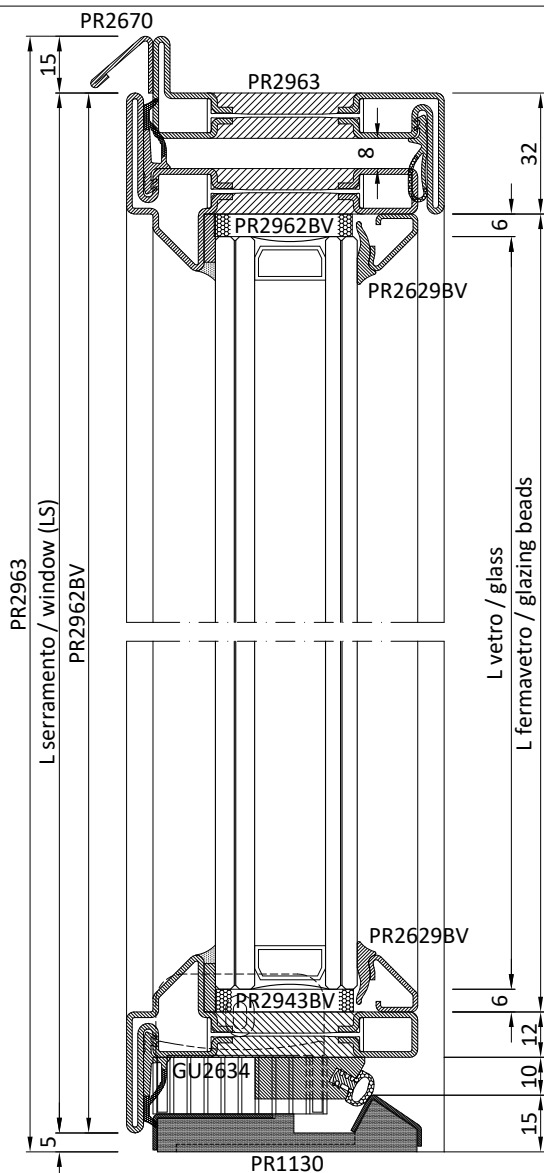




PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio						
Frame						
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
PR1130	Profilo soglia	Threshold	1	LS-24	90°	90°
GU2634	Estruso in PVC	Rigid extruded PVC	1	LS-40	90°	90°
Anta						
Leaf						
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	LS	45°	45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	HS-5	45°	45°
Fermavetri						
Glazing beads						
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2926BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri						
Glass unit						
-	Vetrocamera	Insulated glass	1	LS-76 x HS-81		

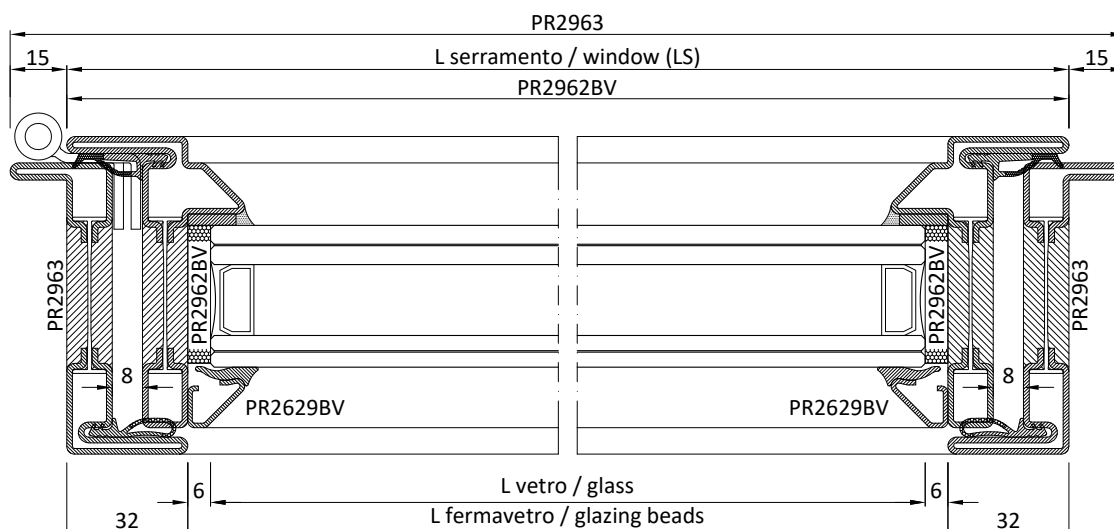
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC1081T	Accessorio di battuta	Stop accessory	2
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696BV	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per PR2963	Corner brackets kit for PR2963	2
AC2862BV*	Kit squadrette per PR2962BV	Corner brackets kit for PR2962BV	4
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

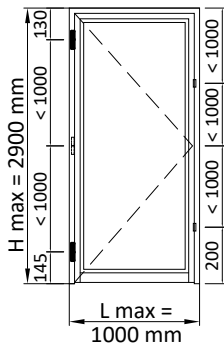
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione di battuta soglie	Rebating gasket	1 1xLS
GE2543TT	Guarnizione interna di battuta	Rebating gasket	2 1xLS+2xHS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 2xLS+2xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS



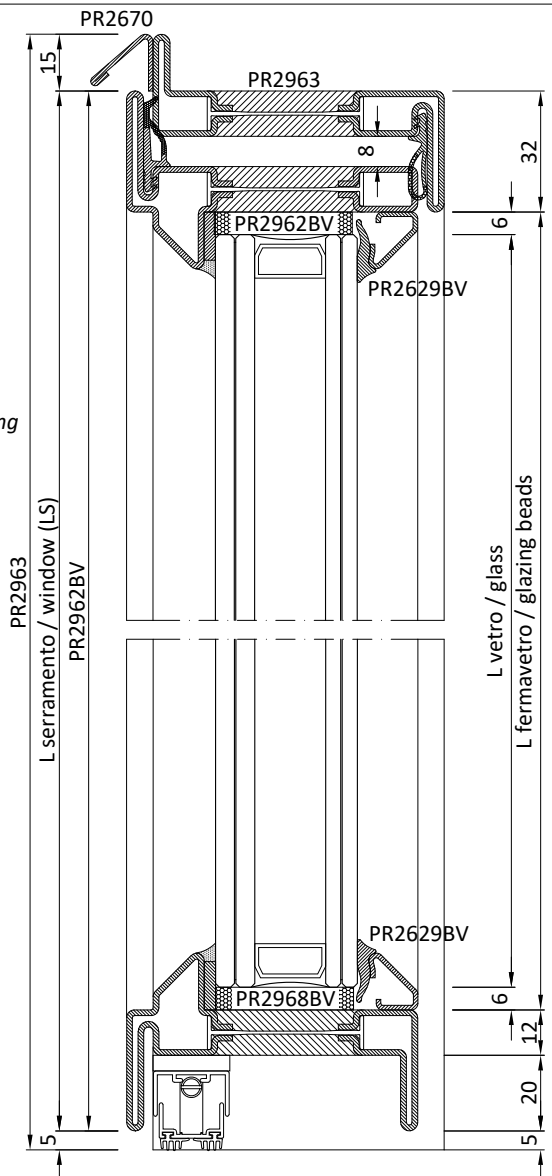
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** 1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949



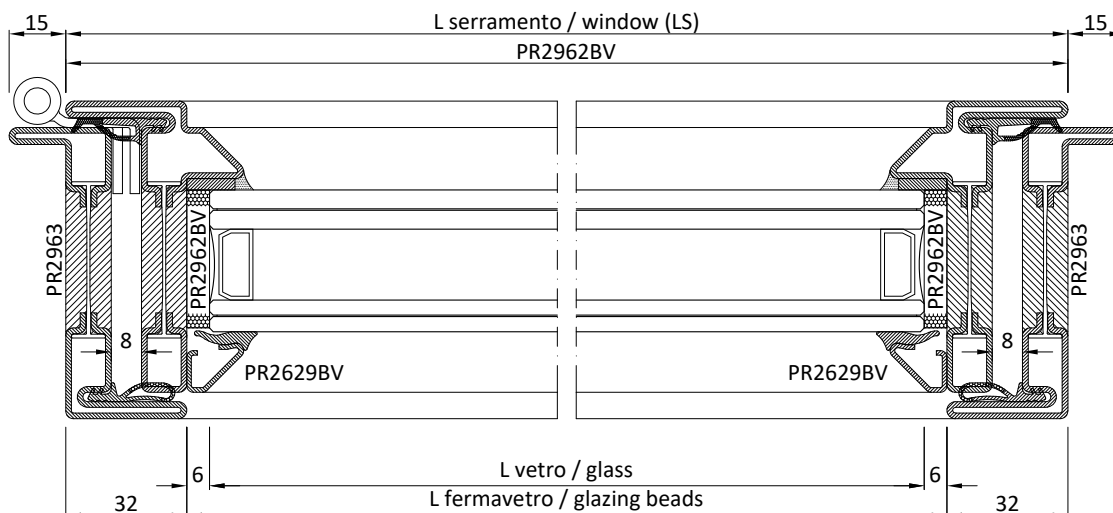


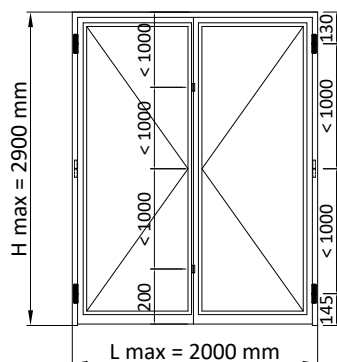
PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta			Leaf			
PR2962BV	Profilo a "T" anta	"T" profile leaf	1	LS	45°	45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	HS-5	45°	45°
PR2968BV	Profilo zoccolo	Zocle profile leaf	1	LS	45°	45°
Fermavetri			Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2926BV	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-81		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	1			
AC	Serratura	Lock	1			
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.			
AC2696BV	Scatola copri serratura	Lock cover box	1			
AC	Cerniere	Hinges	Var.			
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per PR2963	Corner brackets kit for PR2963	2			
AC2862BV*	Kit squadrette per PR2962BV	Corner brackets kit for PR2962BV	4			
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2543TT	Guarnizione interna di battuta	Rebating gasket	2	1xLS+2xHS		
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	1xLS+2xHS		
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		



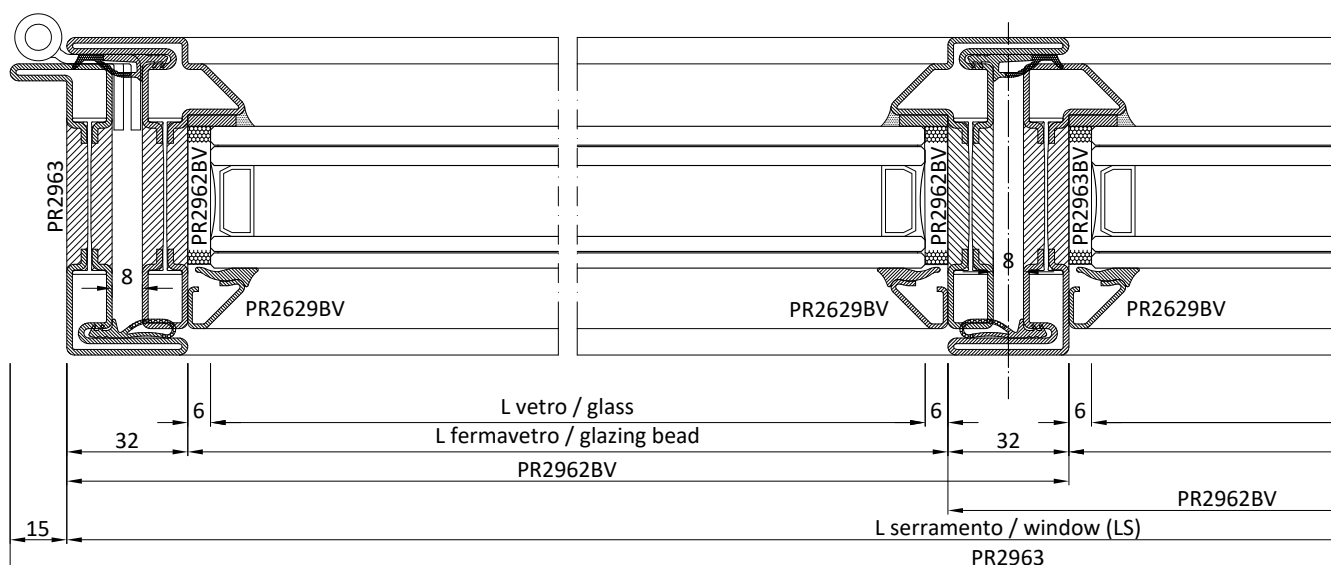
* solo con profili ottone
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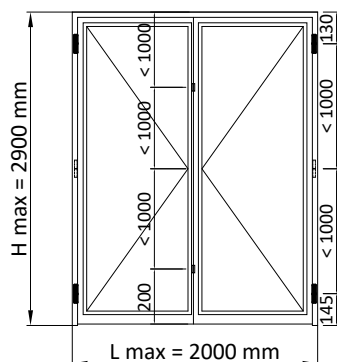
**1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949



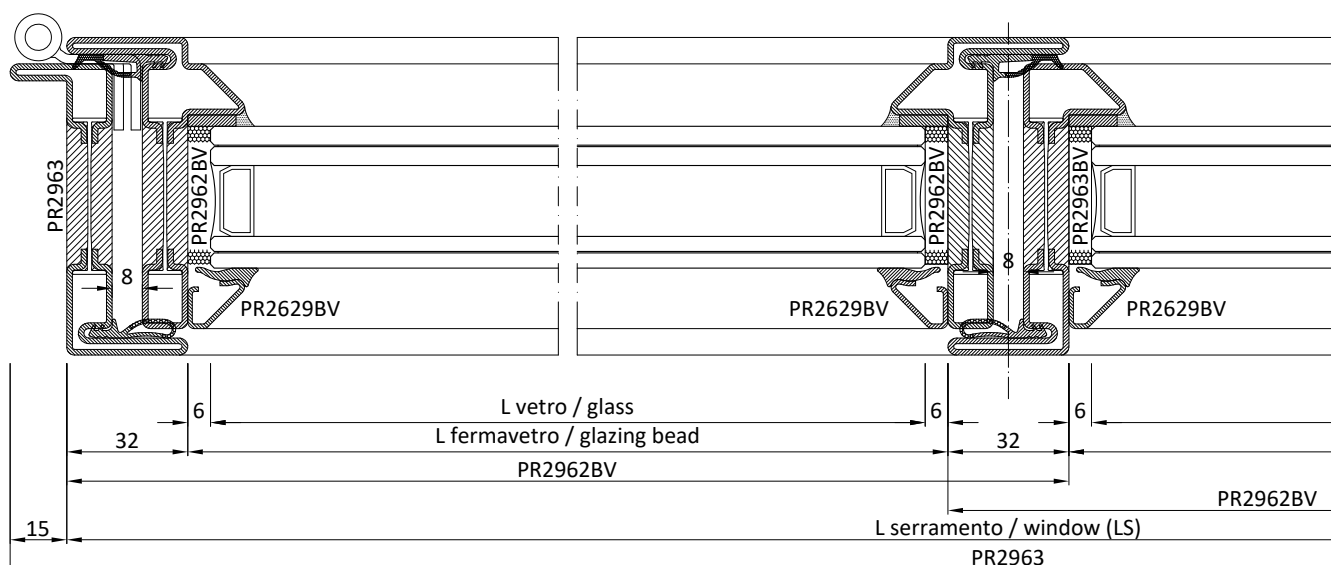


Cod.	PROFILI Descrizione	PROFILES Description	n°Dim.	Taglio	Cutting
	Telaio	Frame			
PR2963	Profilo a "Z" telaio	"Z" profile frame	1 LS+30	45°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1 HS+15	45°	90°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1 HS+15	90°	45°
PR2670	Profilo Gocciolatoio	Water drip profile	1 LS+30	90°	90°
PR1130	Profilo soglia per porta	Profile for door threshold	1 LS-24	90°	90°
GU2634	Profilo porta guarnizione di battuta	Rebate gasket profile	1 (LS-48)/2	90°	90°
GU2634	Profilo porta guarnizione di battuta	Rebate gasket profile	1 ((LS-48)/2)+5	90°	90°
	Anta	Leaf			
PR2962BV	Profilo a "T" anta	"T" profile leaf	4 LS/2+16	45°	45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	3 HS-5	45°	45°
PR2963BV	Profilo a "Z" anta	"Z" profile leaf	1 HS-5	45°	45°
	Fermavetri	Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	4 LS/2-48	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4 HS-69	45°	45°
	Vetri	Glass unit			
-	Vetrocamera	Insulated glass	2 LS/2-60 x HS-81		





	PROFILI	PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
	Telaio	Frame				
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2963	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR2670	Profilo Gocciaio	Watre drip profile	1	LS+30	90°	90°
	Anta	Leaf				
PR2962BV	Profilo a "T" anta	"T" profile leaf	2	LS/2+16	45°	45°
PR2962BV	Profilo a "T" anta	"T" profile leaf	3	HS-5	45°	45°
PR2963BV	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45°	45°
PR2968BV	Profilo Zoccolo	Zocle profile leaf	2	LS/2+16	45°	45°
	Fermavetri	Glazing beads				
PR2629BV	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
	Vetri	Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81		

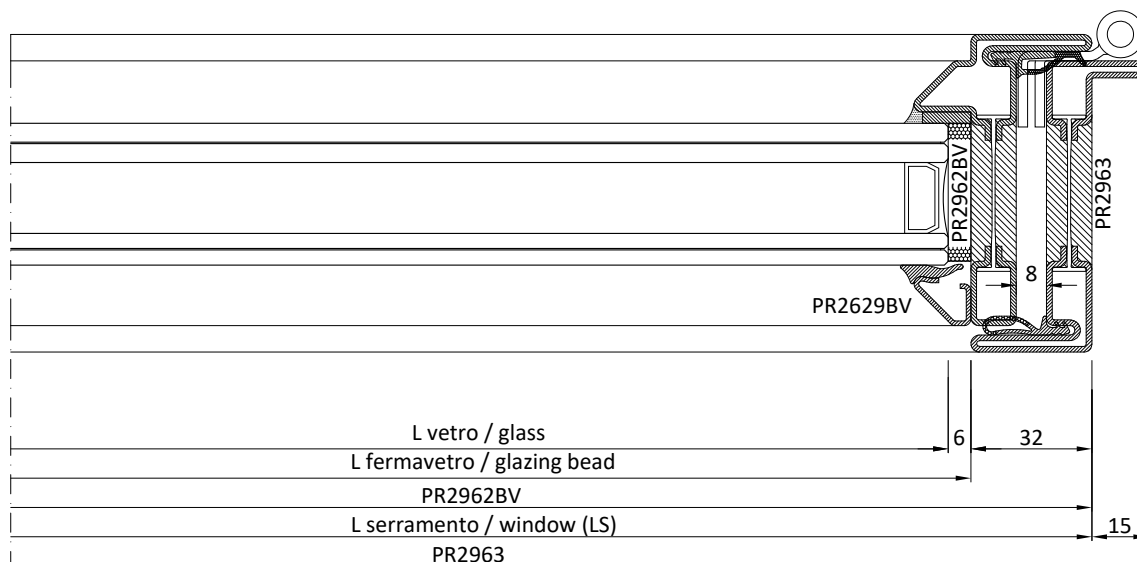
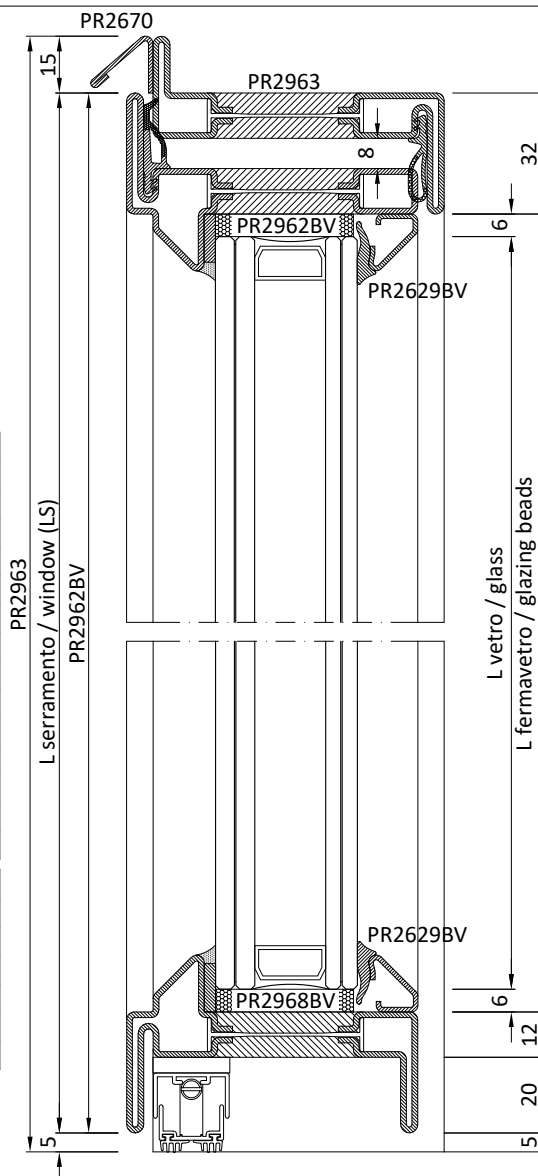


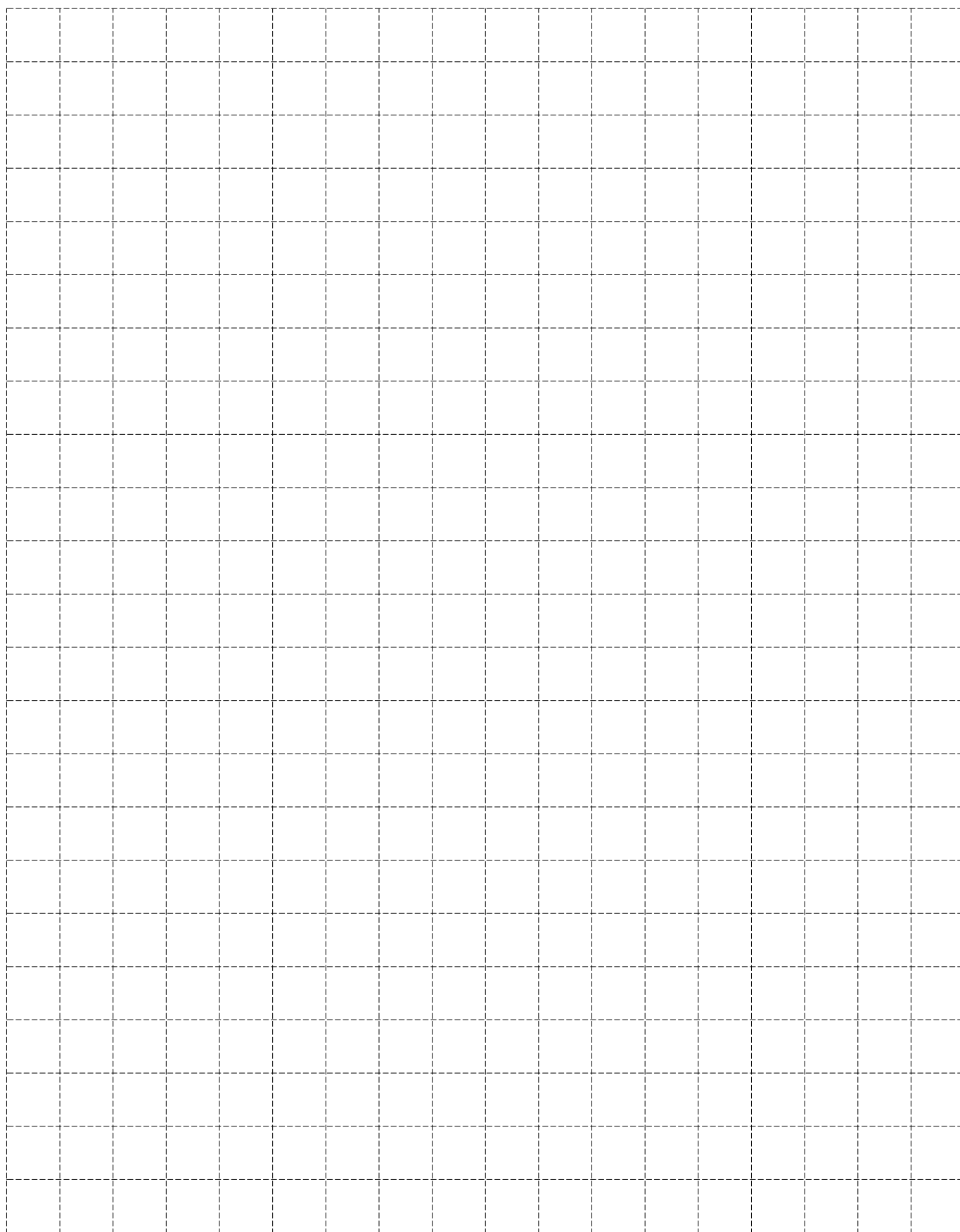
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2621G.-	Catenaccio 2^ anta	Second leaf bolt	2
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2
AC2653	Fondino per 2^ anta	Bottom plate for second leaf	2
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696BV	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC28031*	Kit squadrette per PR2903	Corner brackets kit for PR2903	2
AC2843BV*	Kit squadrette per PR2962BV-63BV	Corner brackets kit for PR2943BV-32BV	2
AC2862BV*	Kit squadrette per PR2962BV	Corner brackets kit for PR2943BV	6
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

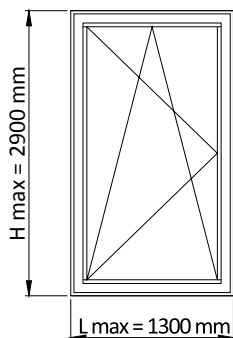
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione interna di battuta	Rebating gasket	1 1xLS+3xHS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1 1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+4xHS

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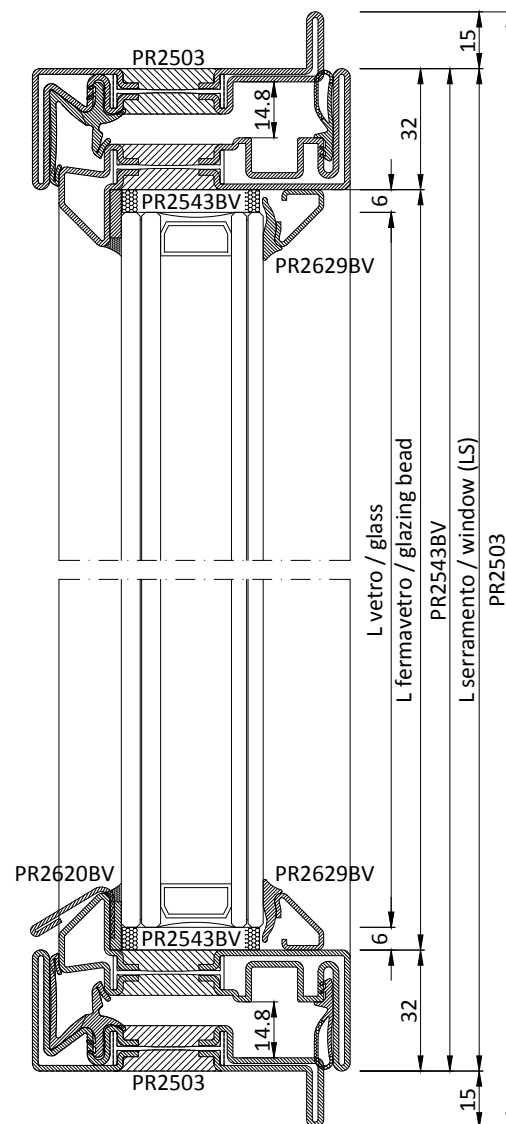
** 1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949



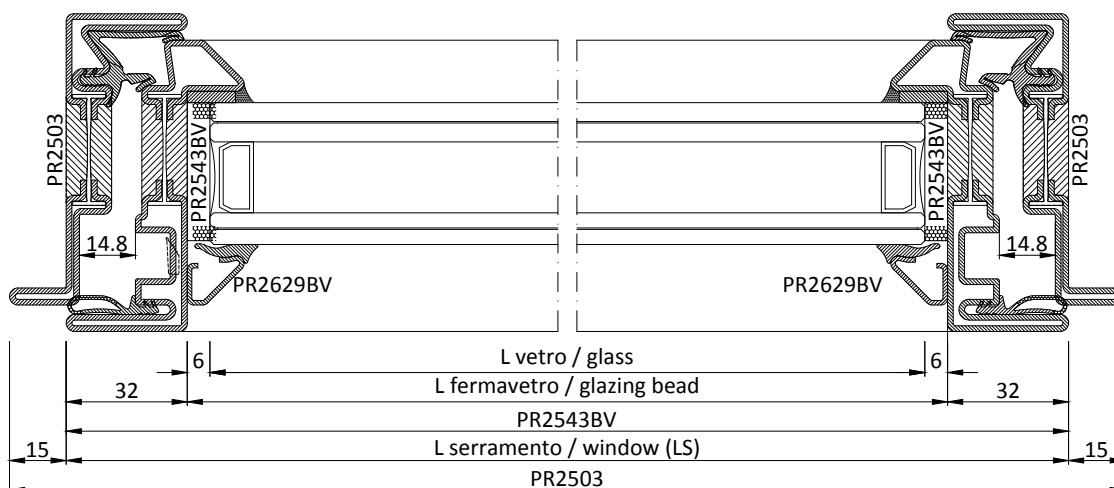


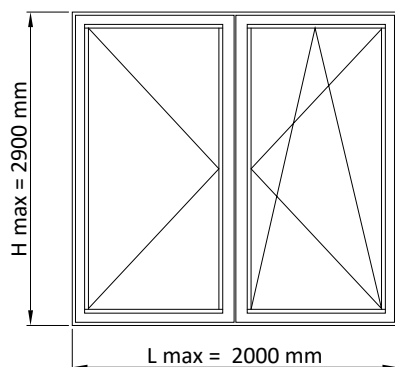


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting	
Telaio			Frame			
PR2503	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2503	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta			Leaf			
PR2543BV	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2543BV	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri			Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2803IR*	Kit squadrette per PR2503	Corner joint kit for PR2503	4			
AC2843BVR*	Kit squadrette per PR2543BV	Corner joint kit for PR2543BV	4			
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC2618.xx	Scarico acqua	Water drip	Var.			
AGE581/2..	Meccanismo Anta Ribalta	Tilt and Turn mechanism	1			
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2556	Meccanismo DK	External tilt & turn mechanism	1			
AC2608AR	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
CV1242	Viti fissaggio ferramenta	Hardware fixing screws	12			
CV1243	Viti fissaggio ferramenta	Hardware fixing screws	Var.			
CV1244	Viti fissaggio ferramenta	Hardware fixing screws	2			
CV1271	Viti fissaggio ferramenta	Hardware fixing screws	Var.			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS		
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

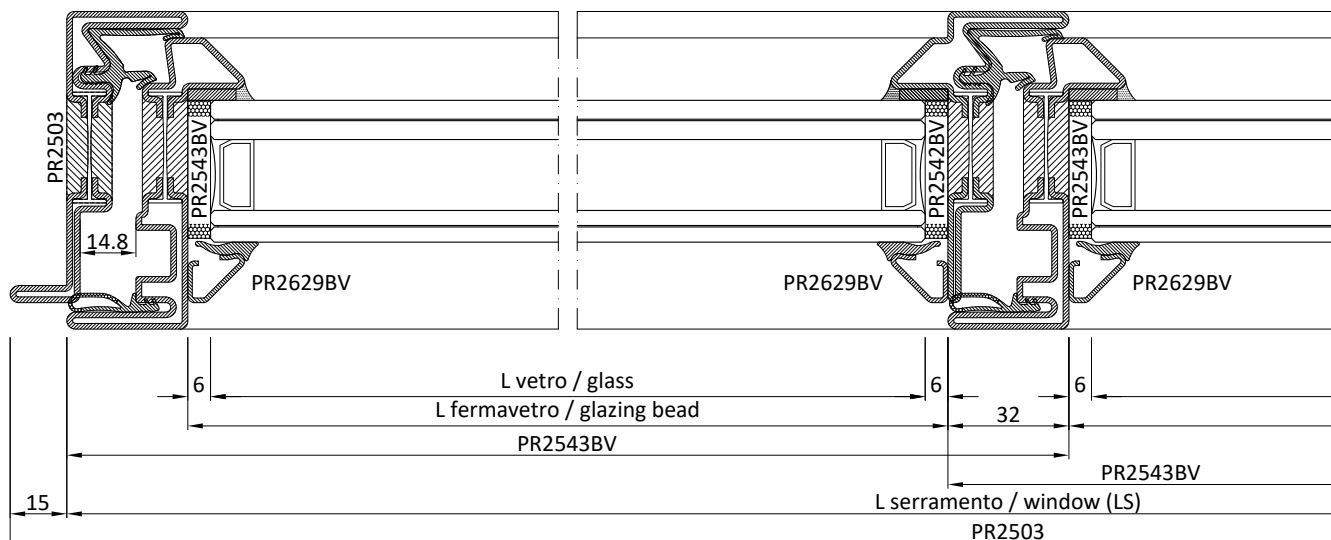


* solo con profili ottone
only with brass profiles





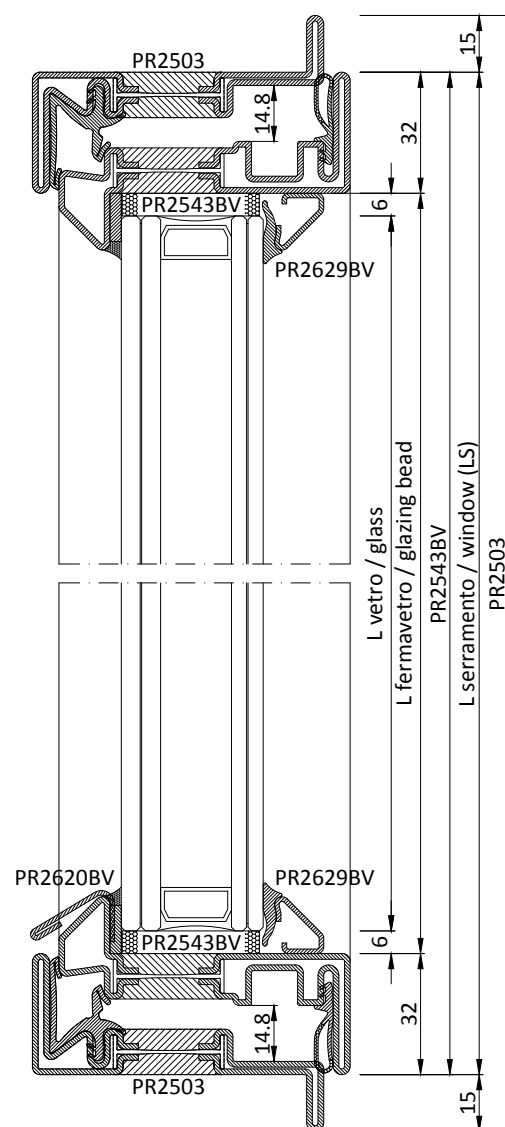
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2503	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45° 45°
PR2503	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45° 45°
Anta		Leaf			
PR2543BV	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45° 45°
PR2543BV	Profilo a "Z" anta	"Z" profile leaf	3	HS	45° 45°
PR2542BV	Profilo a "T" anta	"T" profile leaf	1	HS	45° 45°
PR2620BV	Profilo battiacqua	Water drip profile	2	LS/2-53	90° 90°
Fermavetri		Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2629BV	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

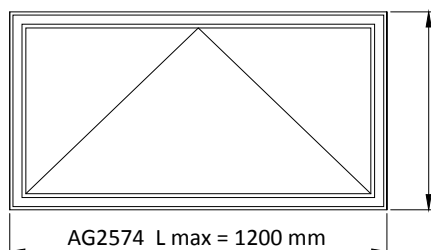


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2803IR*	Kit sq. per PR2503	Joint kit for PR2503	4
AC2843BVR*	Kit squadrette per PR2543BV	Corner joint kit for PR2543BV	6
AC2803BVR*	Kit squadrette per PR2543/42BV	Corner joint kit for PR2543/42BV	2
AC2514	Kit inversione battuta 2^ anta	2nd leaf reverse closure kit	1
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4
AC2618.xx	Scarico acqua	Water drip	Var.
AGE581/2..	Meccanismo Anta Ribalta	Tilt and Turn mechanism	1
AGE585/6..	Meccanismo Anta Ribalta 2^ anta	2nd leaf tilt/turn mechanism	1
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2556	Meccanismo DK	External tilt & turn mechanism	1
AC2608AR	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
CV1242	Viti fissaggio ferramenta	Hardware fixing screws	22
CV1243	Viti fissaggio ferramenta	Hardware fixing screws	Var.
CV1244	Viti fissaggio ferramenta	Hardware fixing screws	2
CV1271	Viti fissaggio ferramenta	Hardware fixing screws	Var.

GUARNIZIONI		JOINTS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+3xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1 2xLS+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

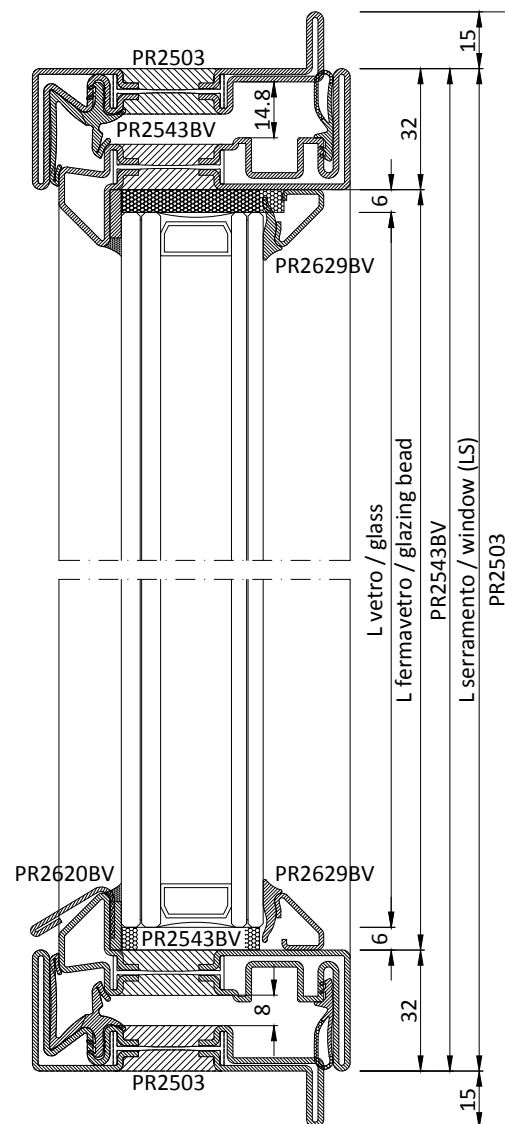
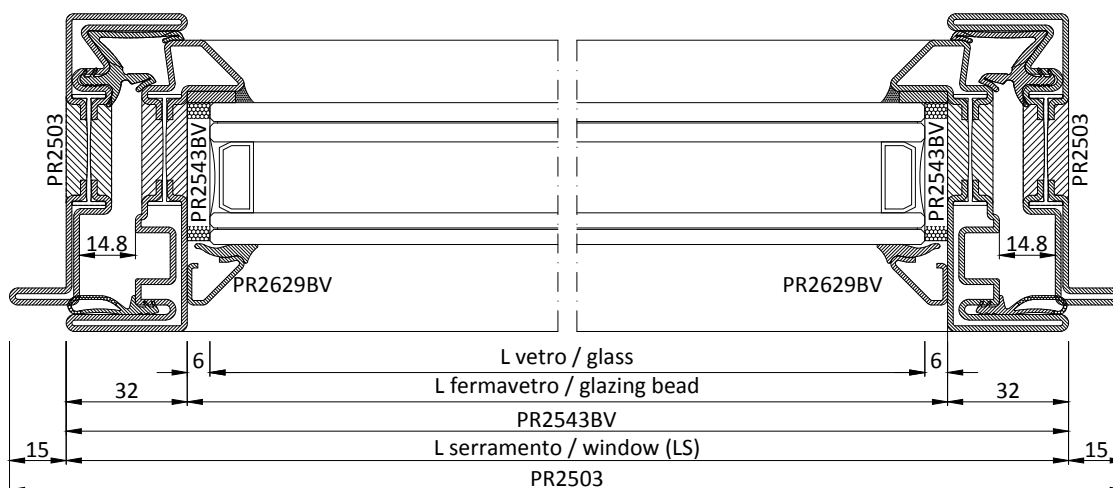
** solo con profili ottone
only with brass profiles

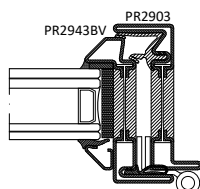
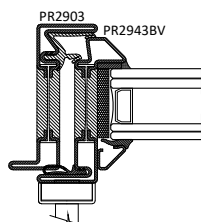
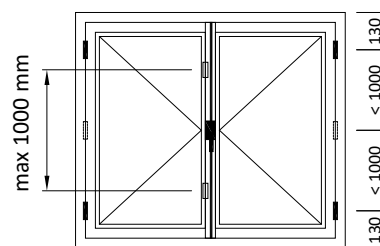
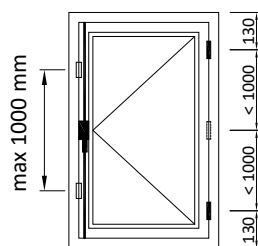




AG2574 H max = 1400 mm

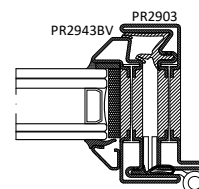
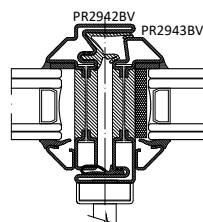
PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
PR2503	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2503	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta			Leaf			
PR2543BV	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2543BV	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri			Glazing beads			
PR2629BV	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2629BV	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2803IR*	Kit squadrette per PR2503	Corner joint kit for PR2503	4			
AC2843BVR*	Kit squadrette per PR2543BV	Corner joint kit for PR2543BV	4			
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC2618.xx	Scarico acqua	Water drip	Var.			
AG2574..	Meccanismo Anta	Mechanism	1			
AG2580	Cerniere a scomparsa	Concealed hinges	1			
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2556	Meccanismo DK	External tilt & turn mechanism	1			
AC2608AR	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
CV1242	Viti fissaggio ferramenta	Hardware fixing screws	12			
CV1243	Viti fissaggio ferramenta	Hardware fixing screws	Var.			
CV1271	Viti fissaggio ferramenta	Hardware fixing screws	Var.			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS		
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

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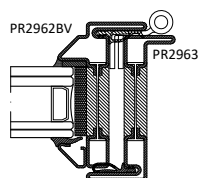
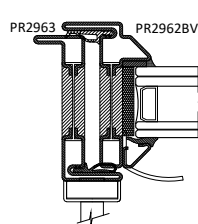
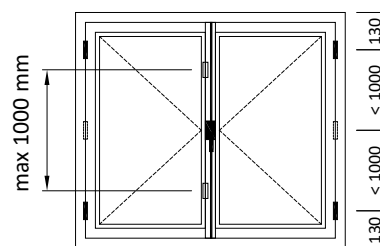
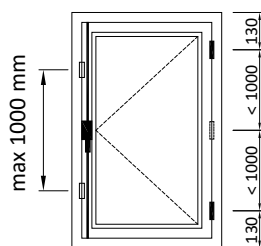
APERTURA INTERNA AD UN ANTA PROFILO PR2943BV
ONE-LEAF INWARD OPENING PR2943BV PROFILE

Art.	Code	Descrizione Description	Pag.
AC2625 D/S		Kit cremonese chiusura finestra ad un anta <i>Cremone bolt set for one-leaf window</i>	4.3.15 4.5.5 6
AC2648 ACB648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.24
AC2649		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.26 27
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.20 4.5.11



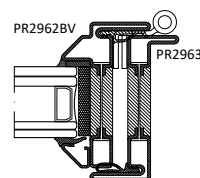
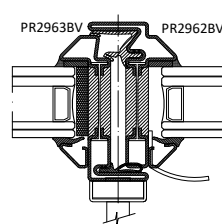
APERTURA INTERNA A DUE ANTE PROFILO PR2943BV
TWO-LEAF INWARD OPENING PR2943BV PROFILE

Art.	Code	Descrizione Description	Pag.
AC2624 D/S		Kit cremonese chiusura finestra a due ante <i>Cremone bolt set for two-leaf window</i>	4.3.14 4.5.3 4
AC2622		Snapper chiusura 2^ anta <i>Snapper for 2nd leaf</i>	4.5.4
AC2648 ACB648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.24
AC2649		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.26 27
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.20 4.5.11



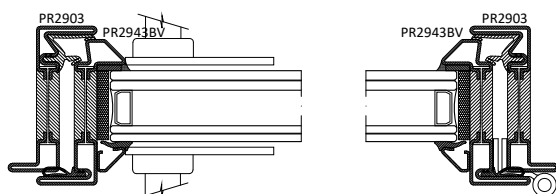
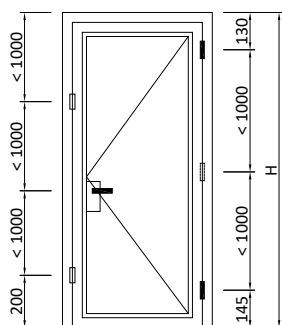
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ONE-LEAF OUTWARD OPENING PR2962BV PROFILE

Art.	Code	Descrizione Description	Pag.
AC2683 D/S		Kit cremonese chiusura finestra ad un anta <i>Cremone bolt set for one-leaf window</i>	4.3.16 17 4.5.7 8
AC2680		Maniglia trascinamento anta <i>Pulling handle</i>	4.5.15
AC2648 ACB648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.25
AC2649		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.27
AC2631 A/B		Cerniere a saldare <i>Cerniere a saldare</i>	4.4.6
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.22 4.5.11



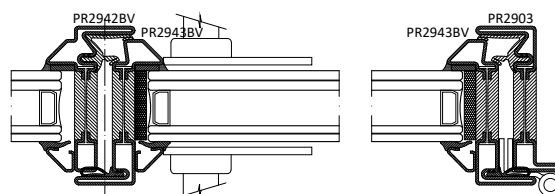
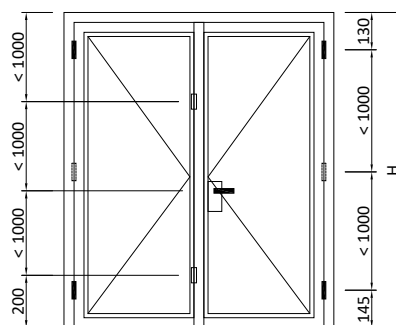
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TWO-LEAF OUTWARD OPENING PR2962BV PROFILE

Art.	Code	Descrizione Description	Pag.
AC2684 D/S		Kit cremonese chiusura finestra a due ante <i>Cremone bolt set for two-leaf window</i>	4.3.18 19 4.5.9 10
AC2680		Maniglia trascinamento anta <i>Pulling handle</i>	4.5.15
AC2648 ACB648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.25
AC2649		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.27
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.23 4.5.11



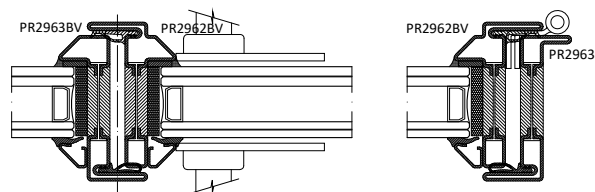
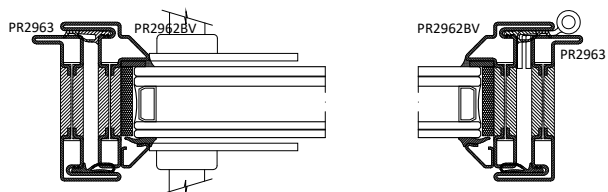
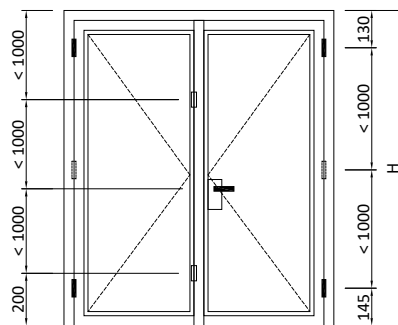
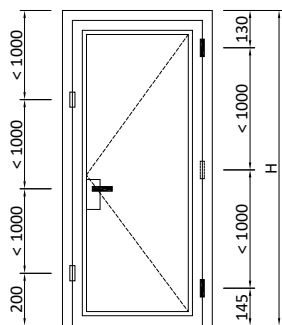
APERTURA INTERNA AD UN ANTA PROFILO PR2943BV
ONE-LEAF INWARD OPENING PR2943BV PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio Lock with spring latch and bolt	4.3.41
AC2694 D/S		Kit serratura a multipunto Multi-lock kit	4.3.43 4.5.16 17
AC2695 D/S		Punto di chiusura aggiuntivo Additional lock	4.3.45 4.5.18
AC2696BV		Scatola copri serratura Lock cover box	4.5.20
AC2648 ACB648		Cerniere a tre ali ad avvitare Three-wing screw-in hinge	4.3.24
AC2649		Cerniere a due ali ad avvitare Two-wing screw-in hinge	4.3.26 27
AC2631/B		Cerniere a saldare Welding hinge	4.4.5
AC2632B/C		Cerniere a saldare Welding hinge	4.4.5



APERTURA INTERNA A DUE ANTE PROFILO PR2943BV
TWO-LEAF INWARD OPENING PR2943BV PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio Lock with spring latch and bolt	4.3.41
AC2694 D/S		Kit serratura a multipunto Multi-lock kit	4.3.43 4.5.16 17
AC2695 D/S		Punto di chiusura aggiuntivo Additional lock	4.3.45 4.5.18
AC2696BV		Scatola copri serratura Lock cover box	4.5.20
AC2621G A/B/X/C/D		Catenaccio seconda anta Second leaf bolt	4.3.37
AC2648 ACB648		Cerniere a tre ali ad avvitare Three-wing screw-in hinge	4.3.24
AC2649		Cerniere a due ali ad avvitare Two-wing screw-in hinge	4.3.26 27
AC2631/B		Cerniere a saldare Welding hinge	4.4.5
AC2632B/C		Cerniere a saldare Welding hinge	4.4.5

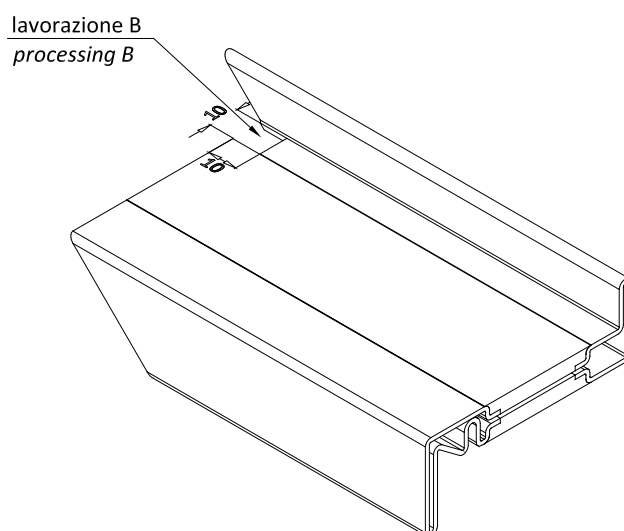
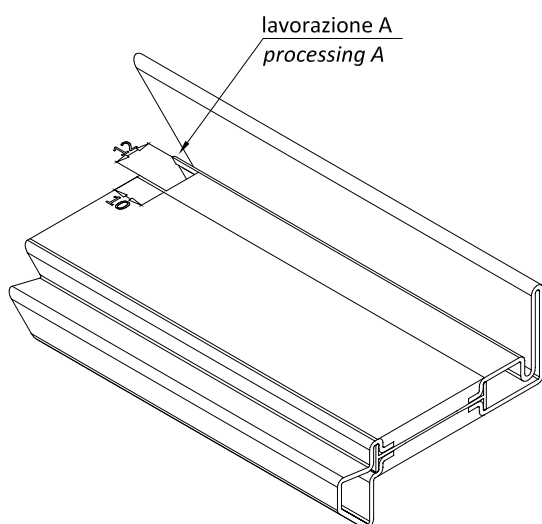
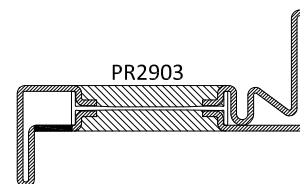
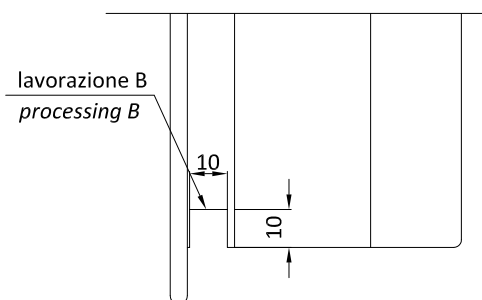
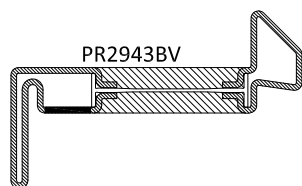
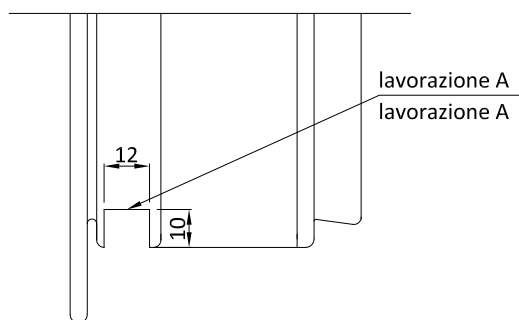


APERTURA ESTERNA AD UN ANTA PROFILO PR2962BV
ONE-LEAF OUTWARD OPENING PR2962BV PROFILE

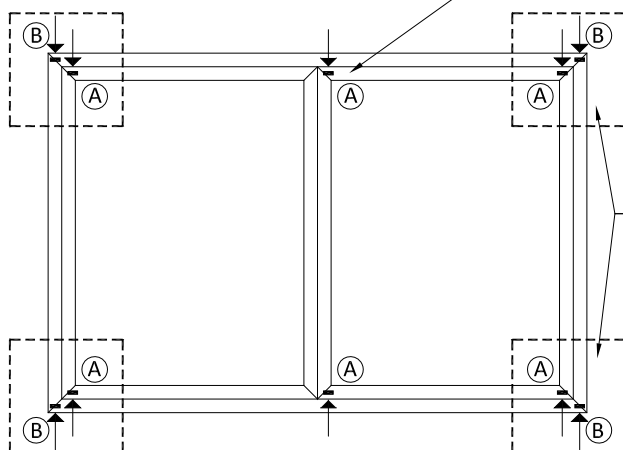
Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio Lock with spring latch and bolt	4.3.42
AC2694 D/S		Kit serratura a multipunto Multi-lock kit	4.3.44 4.5.16 17
AC2695 D/S		Punto di chiusura aggiuntivo Additional lock	4.3.46 4.5.18
AC2696BV		Scatola copri serratura Lock cover box	4.5.20
AC2648 ACB648		Cerniere a tre ali ad avvitare Three-wing screw-in hinge	4.3.25
AC2649		Cerniere a due ali ad avvitare Two-wing screw-in hinge	4.3.27
AC2631/B		Cerniere a saldare Welding hinge	4.4.6
AC2632B/C		Cerniere a saldare Welding hinge	4.4.6

APERTURA ESTERNA A DUE ANTE PROFILO PR2962BV
TWO-LEAF OUTWARD OPENING PR2962BV PROFILE

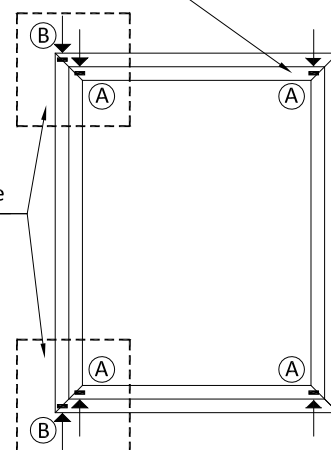
Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio Lock with spring latch and bolt	4.3.42
AC2694 D/S		Kit serratura a multipunto Multi-lock kit	4.3.44 4.5.16 17
AC2695 D/S		Punto di chiusura aggiuntivo Additional lock	4.3.46 4.5.18
AC2696BV		Scatola copri serratura Lock cover box	4.5.20
AC2621G A/B/X/C/D		Catenaccio seconda anta Second leaf bolt	4.3.38
AC2648 ACB648		Cerniere a tre ali ad avvitare Three-wing screw-in hinge	4.3.25
AC2649		Cerniere a due ali ad avvitare Two-wing screw-in hinge	4.3.27
AC2631/B		Cerniere a saldare Welding hinge	4.4.6
AC2632B/C		Cerniere a saldare Welding hinge	4.4.6

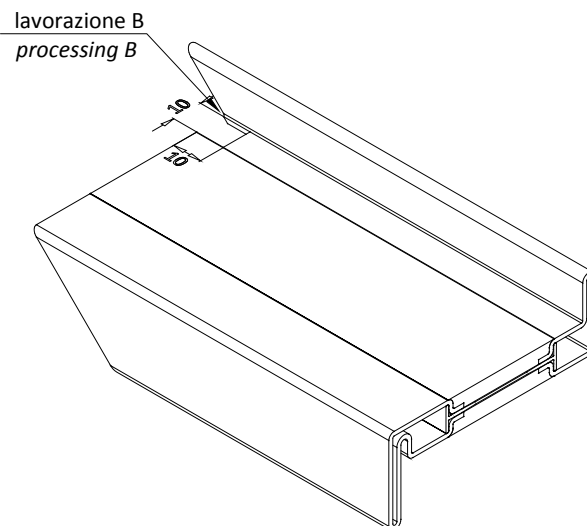
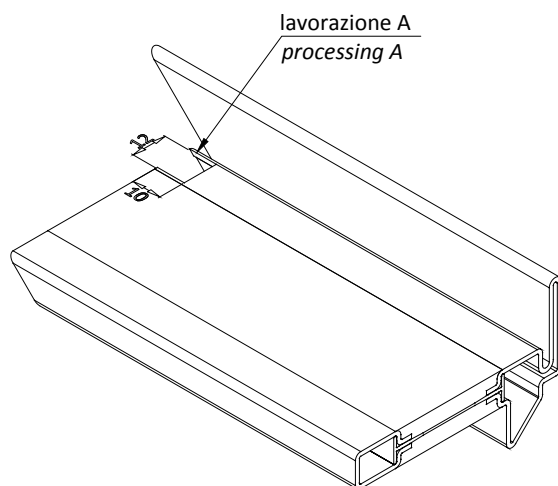
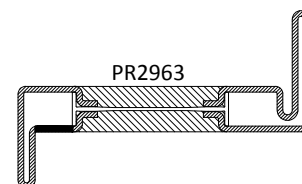
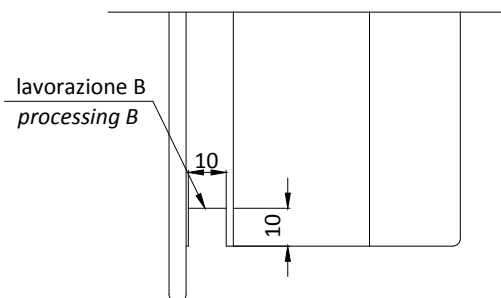
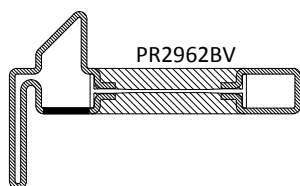
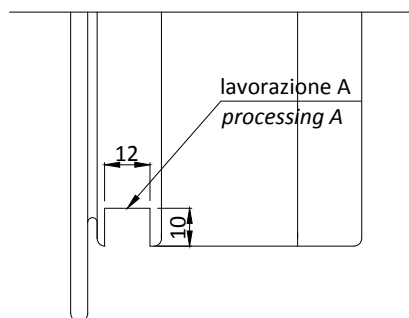


lavorazione per inserimento aste cremonese
processing for inserting cremone bolt rod

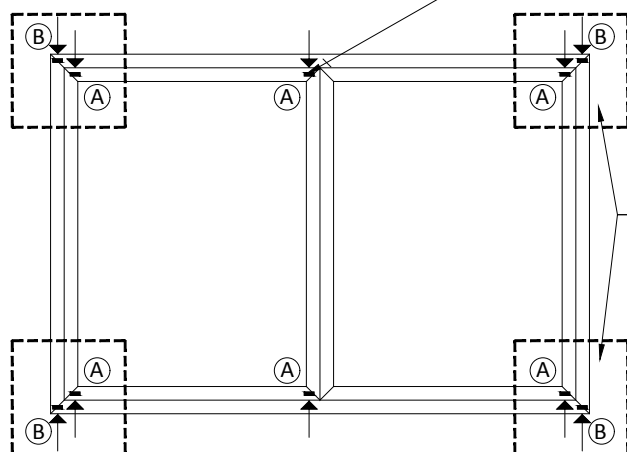


lavorazione per inserimento rinforzo cerniere
processing for inserting hinge strengtheners

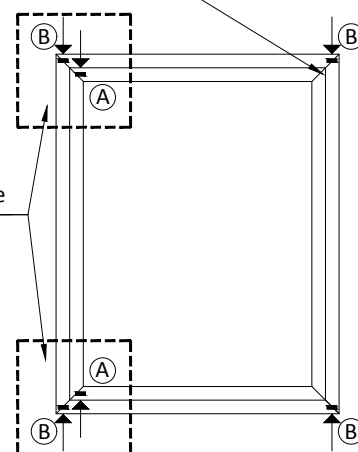


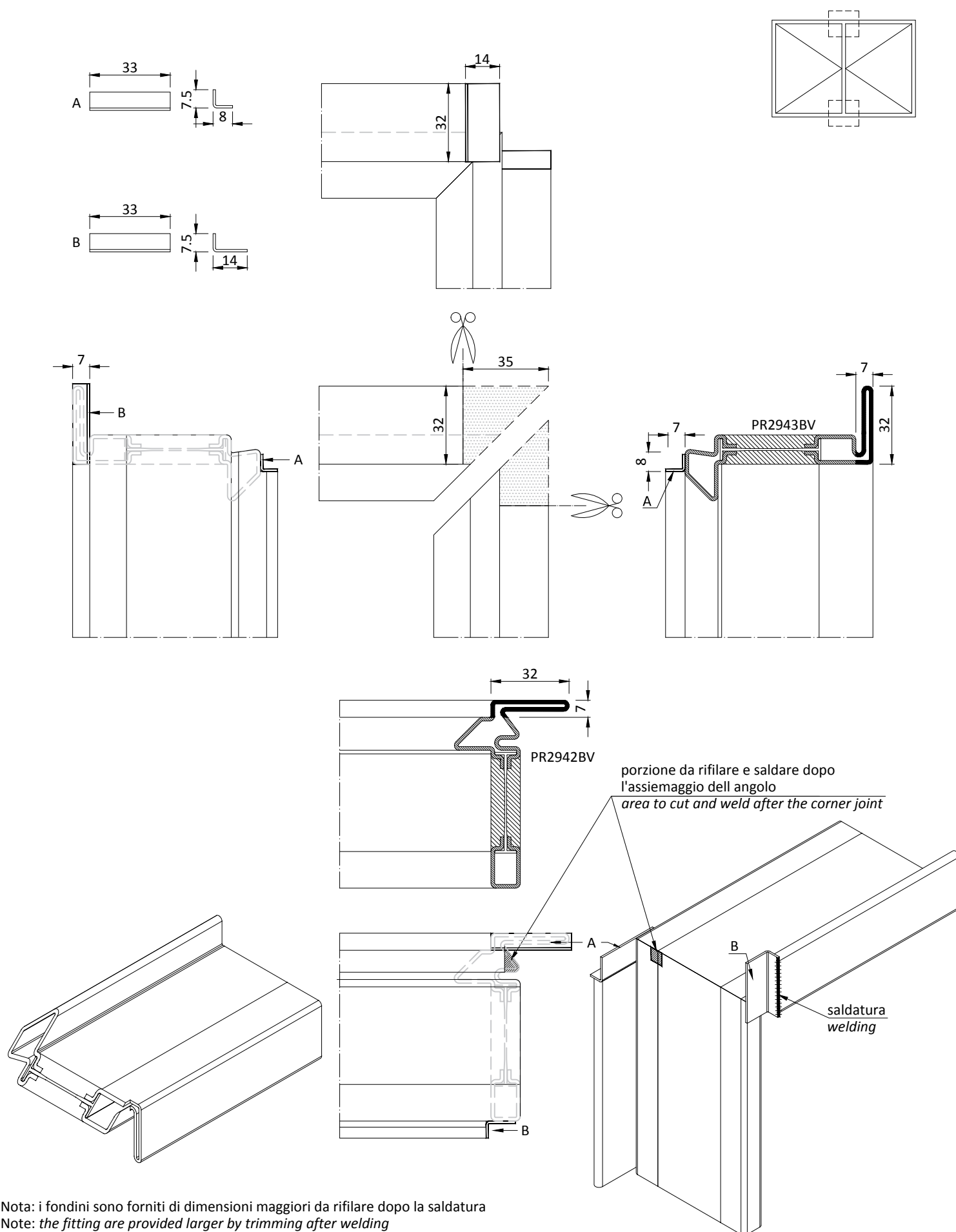


lavorazione per inserimento aste cremone
processing for inserting cremone bolt rod

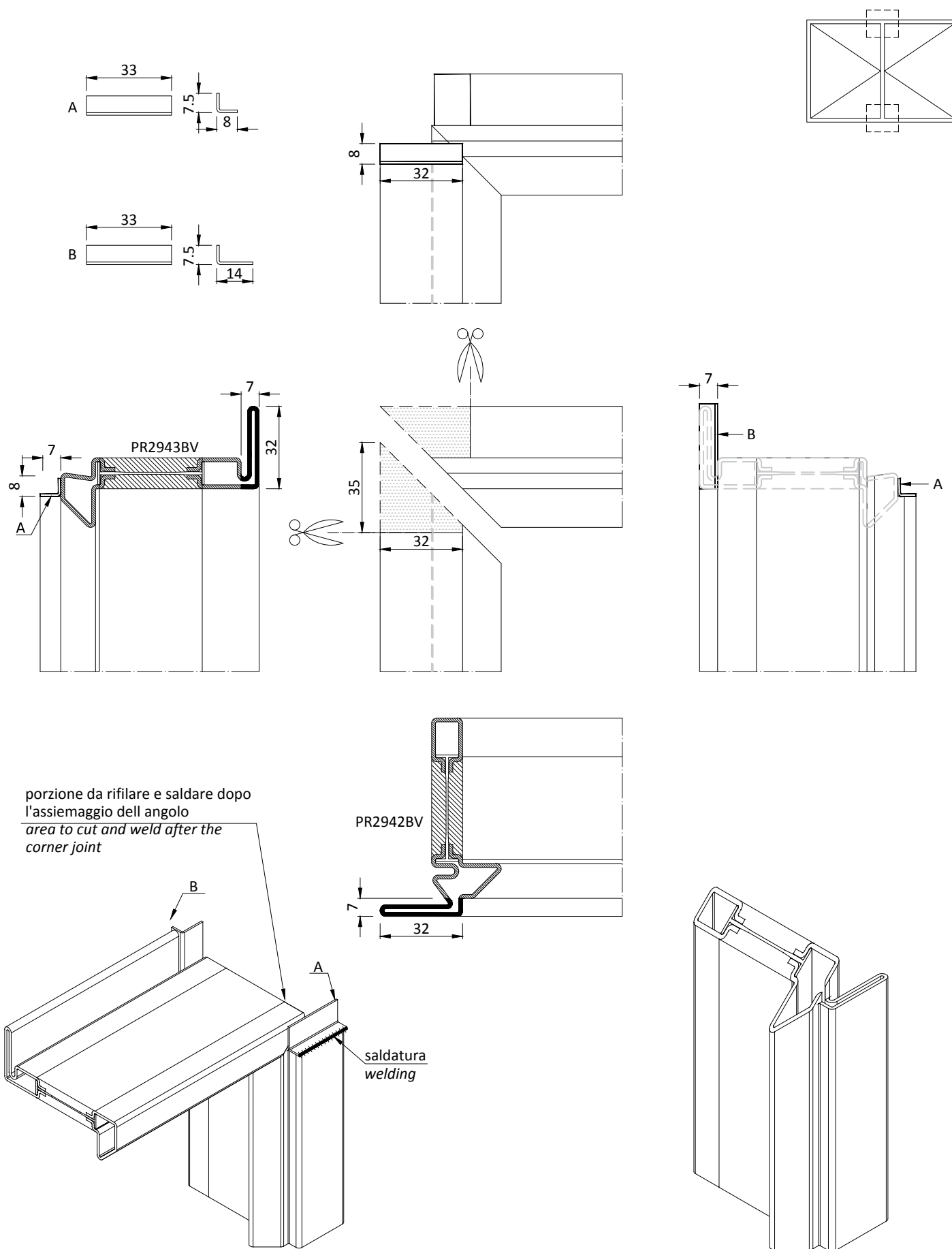


lavorazione per inserimento rinforzo cerniere
processing for inserting hinge strengtheners

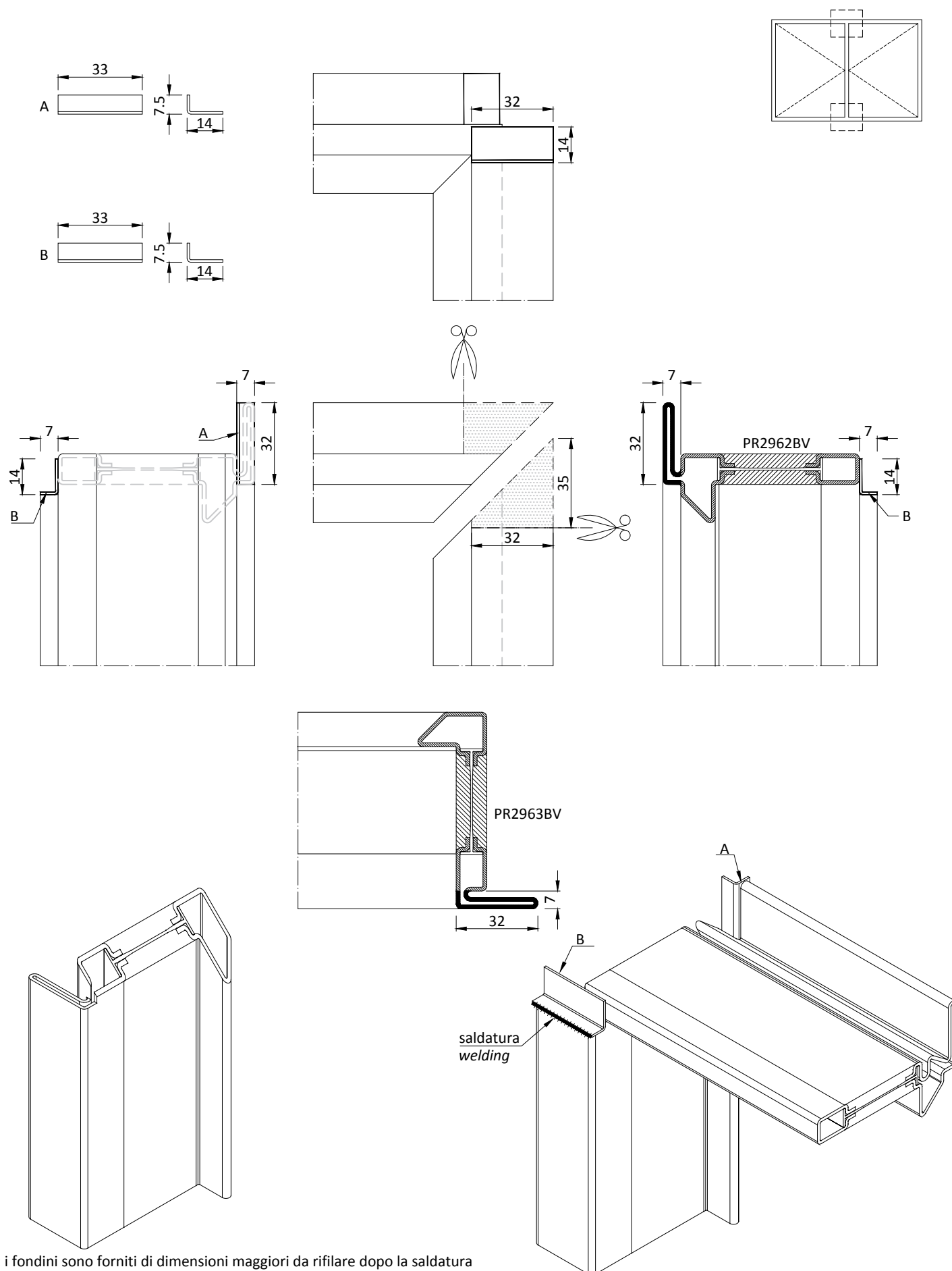


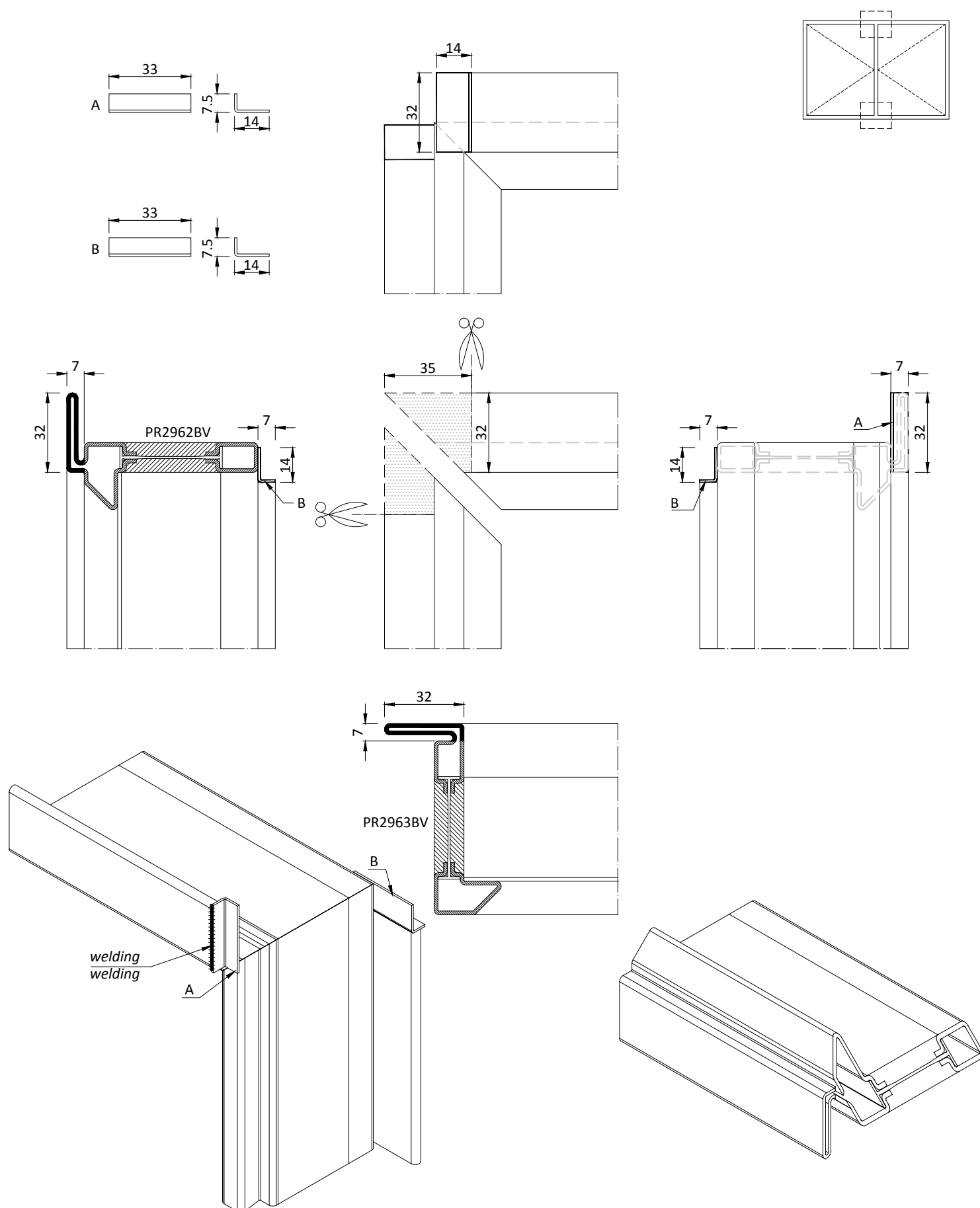


Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding

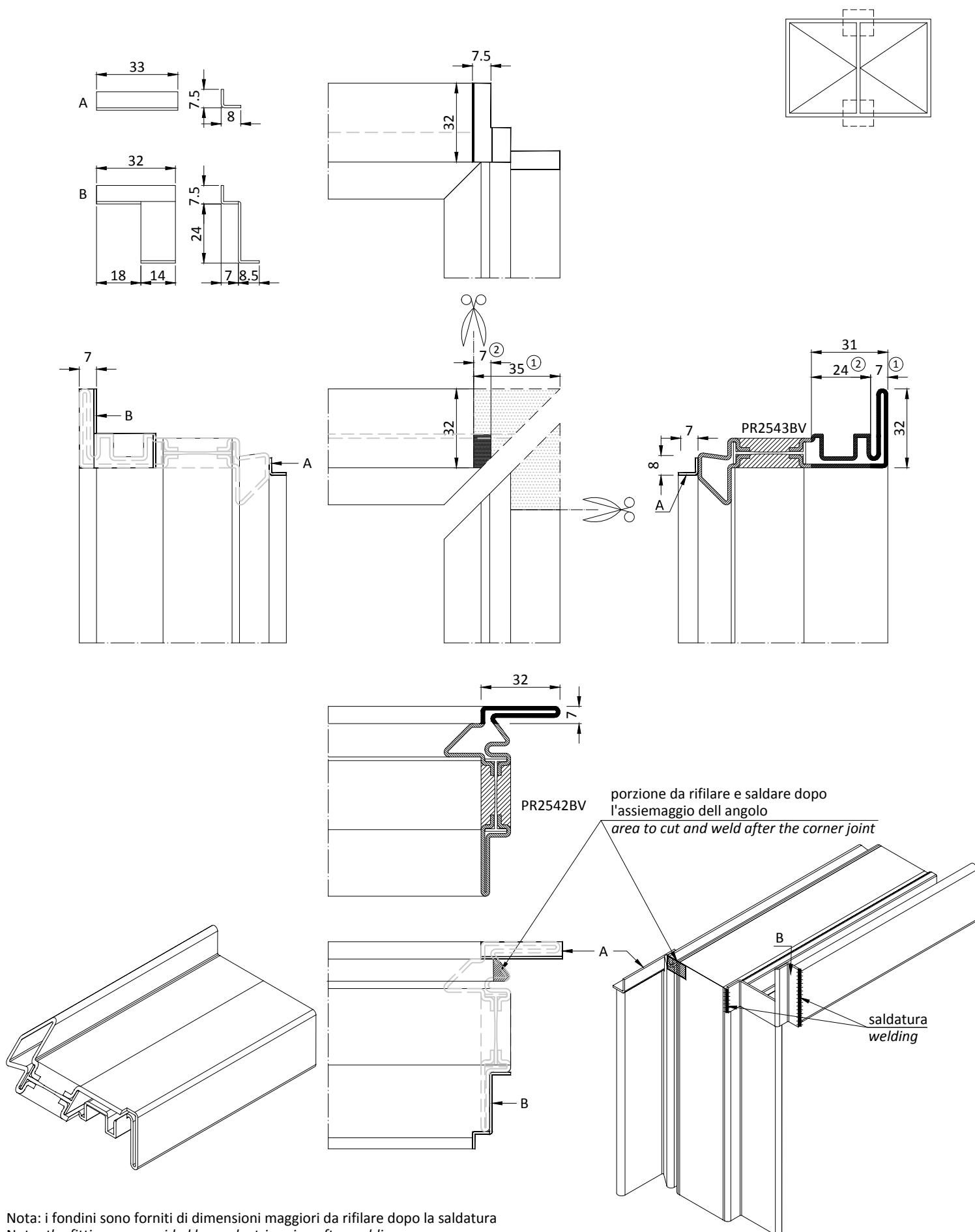


Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding

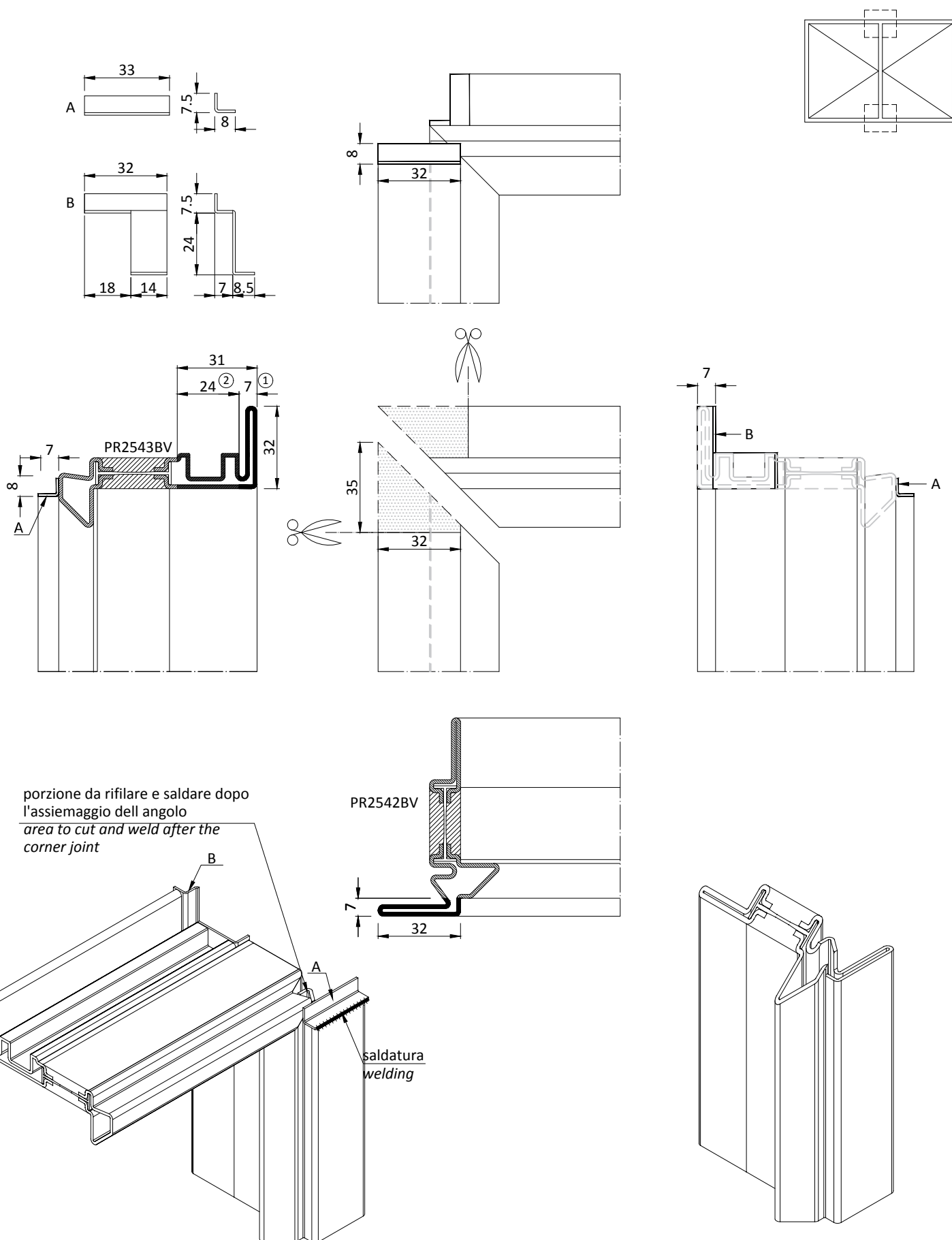




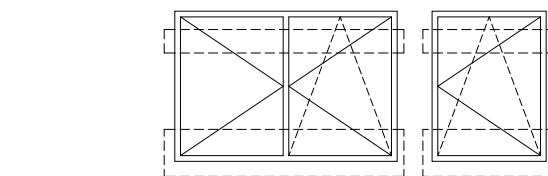
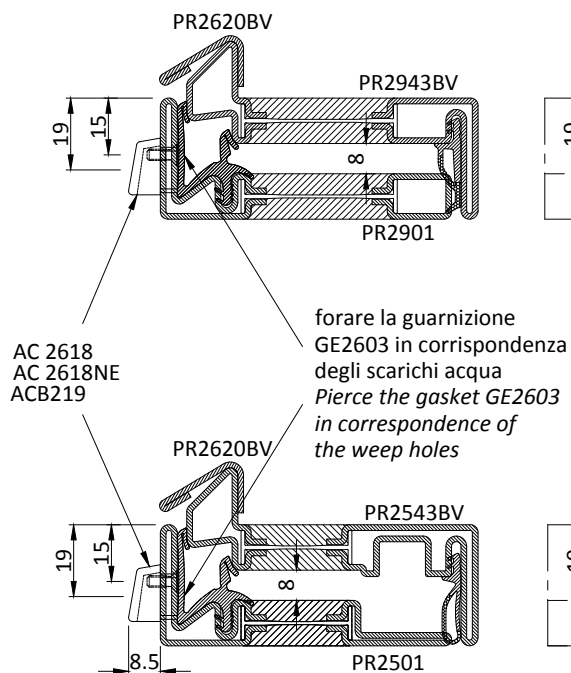
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



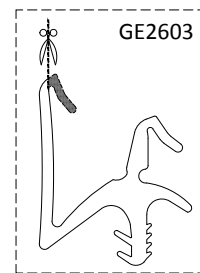
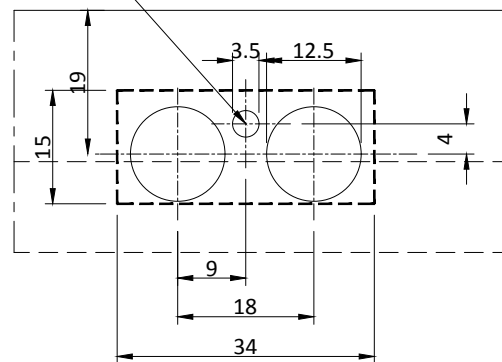
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



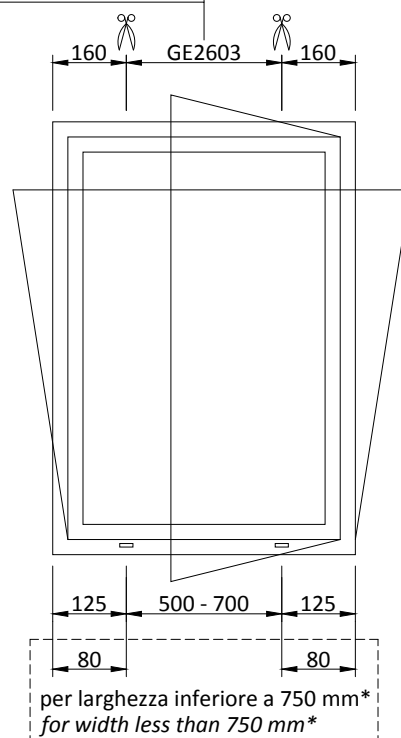
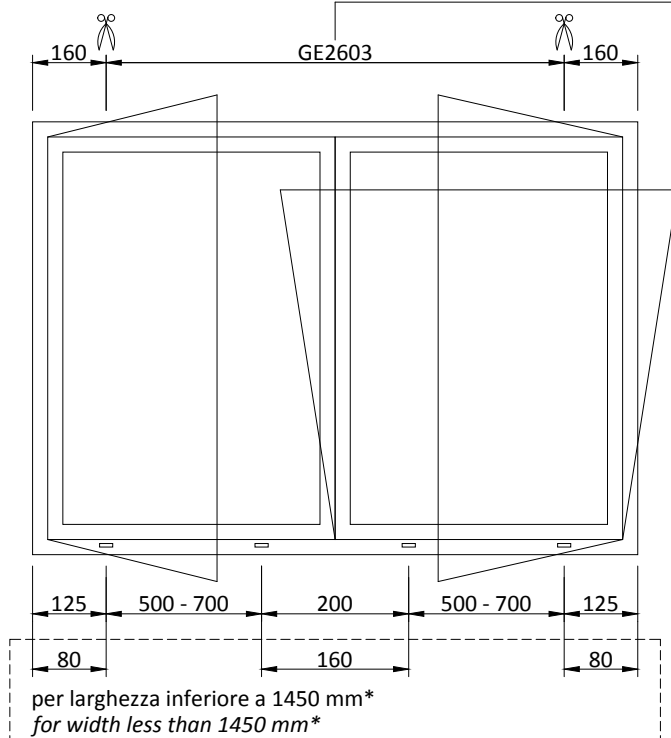
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



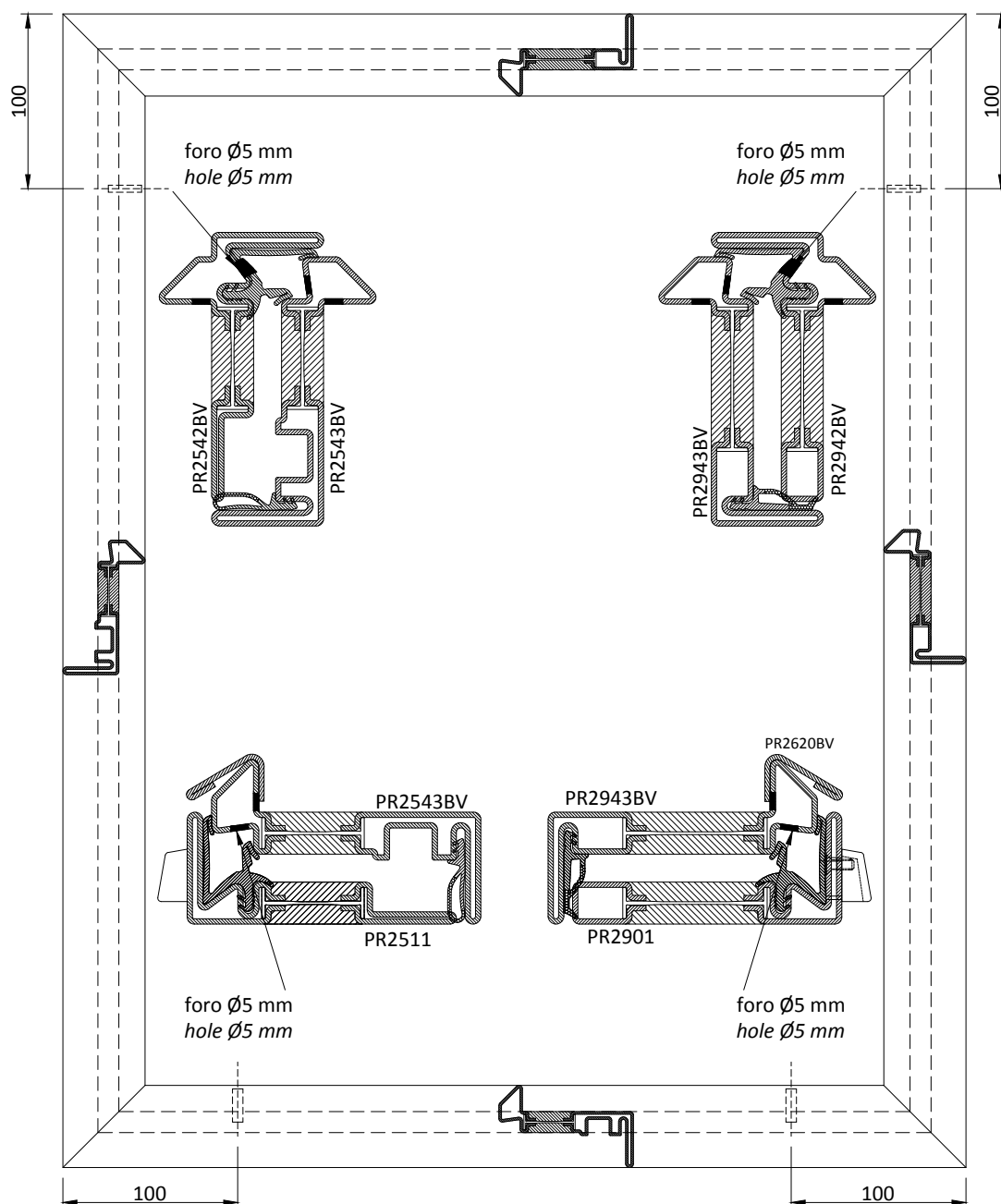
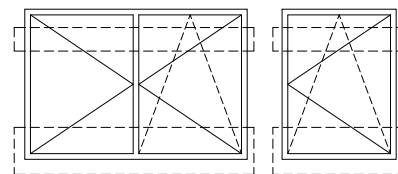
svasato
countersunk



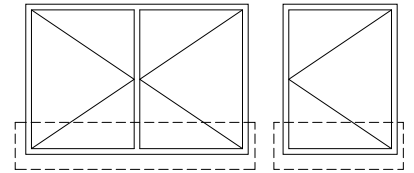
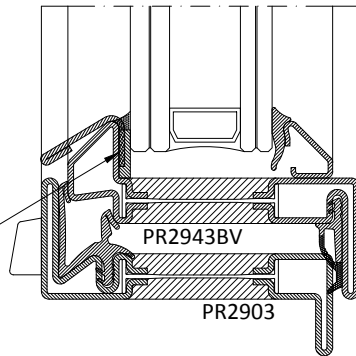
Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm



* tagliare l'angolo vulcanizzato AC2617NG per 30 mm
* cut the vulcanised corner gasket AC2617NG to 30 mm

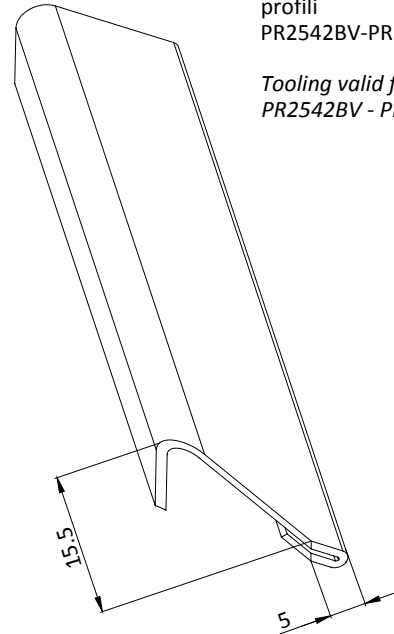


sigillare per tutta la lunghezza.
seal along the entire length.

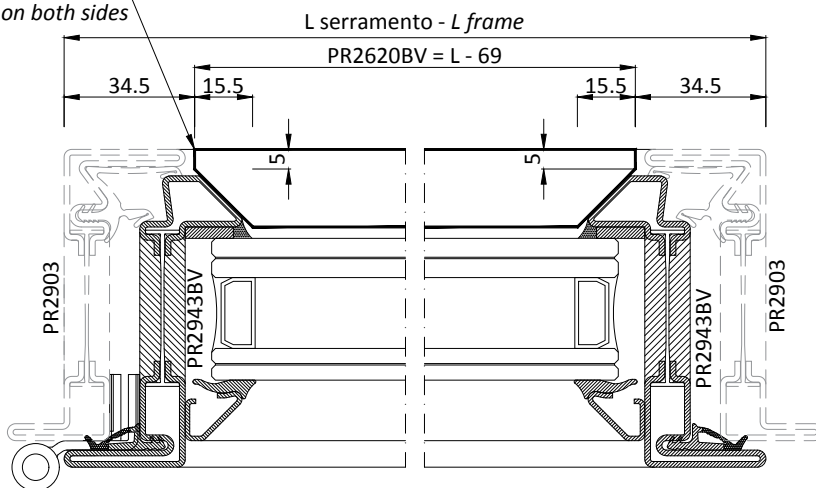


Lavorazione valida per
profili
PR2542BV-PR2543BV

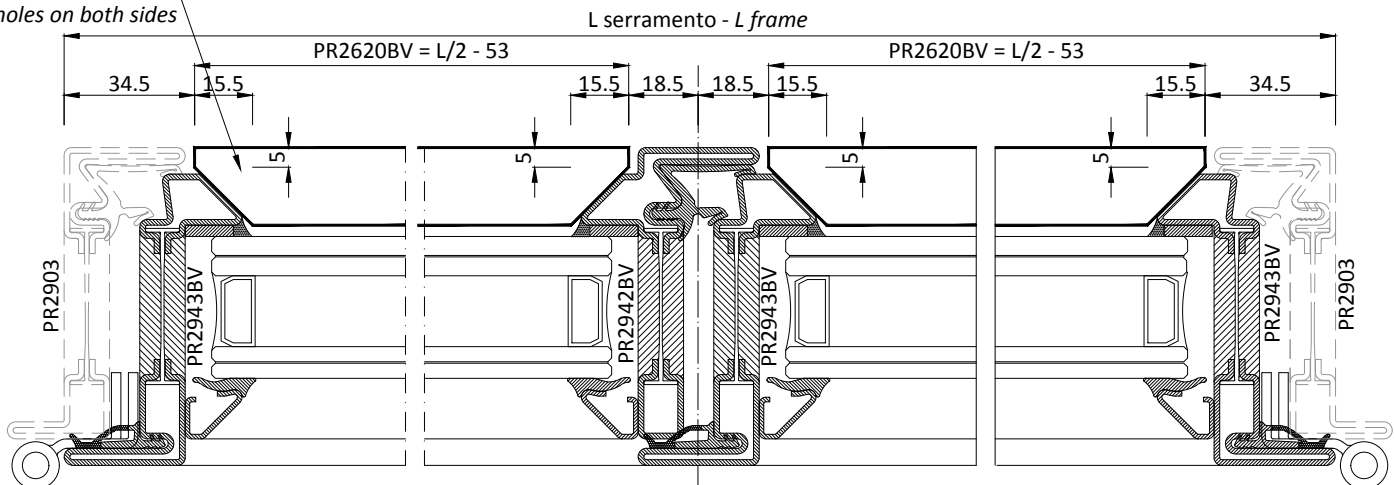
Tooling valid for profiles
PR2542BV - PR2543BV

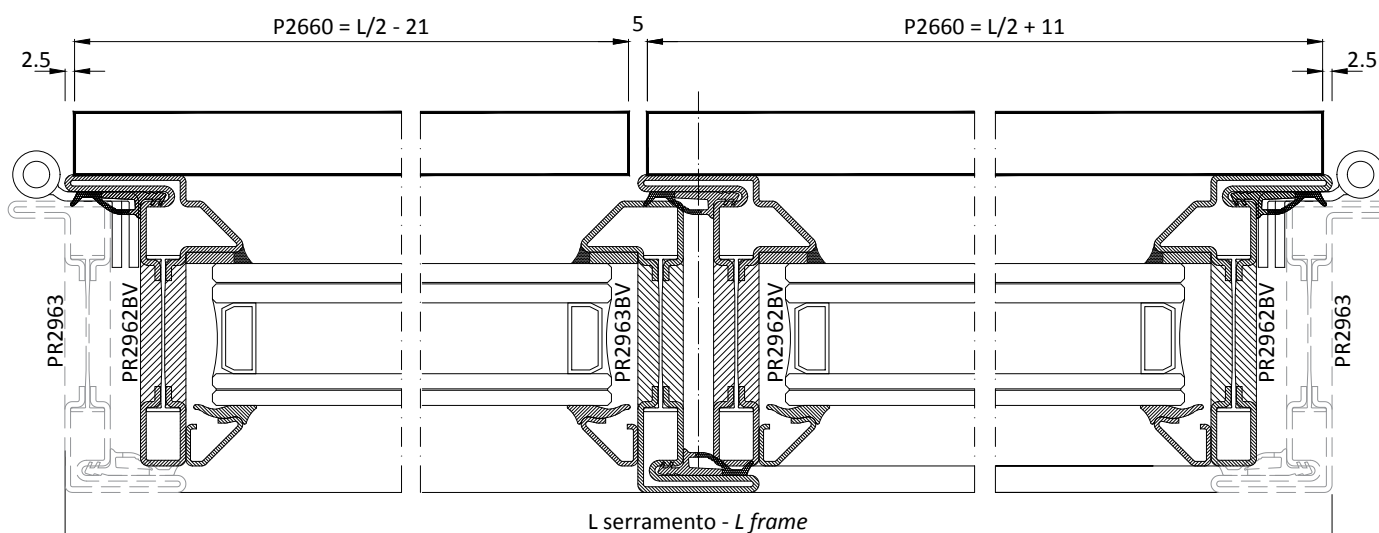
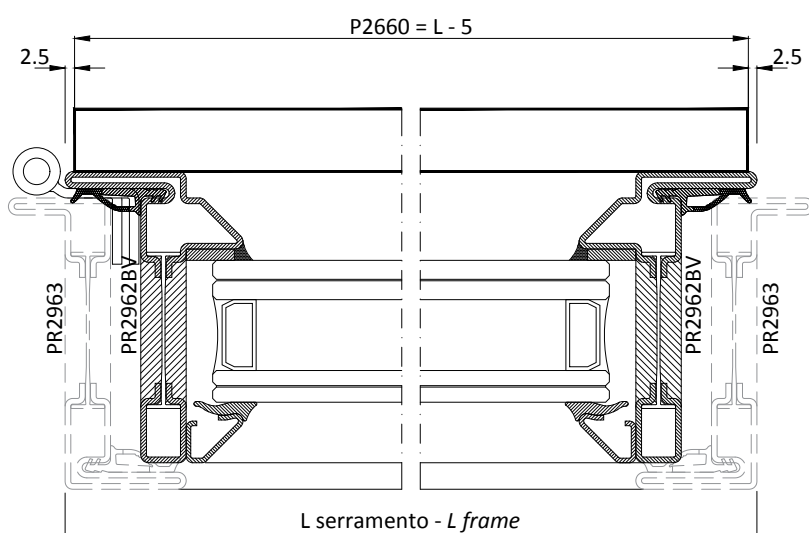
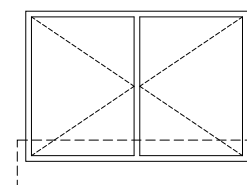
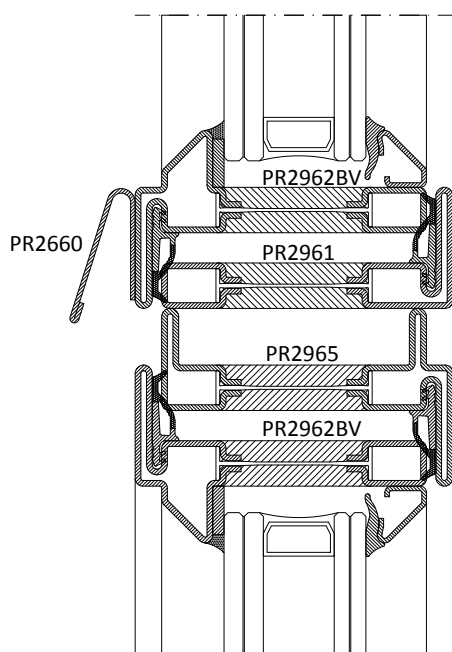


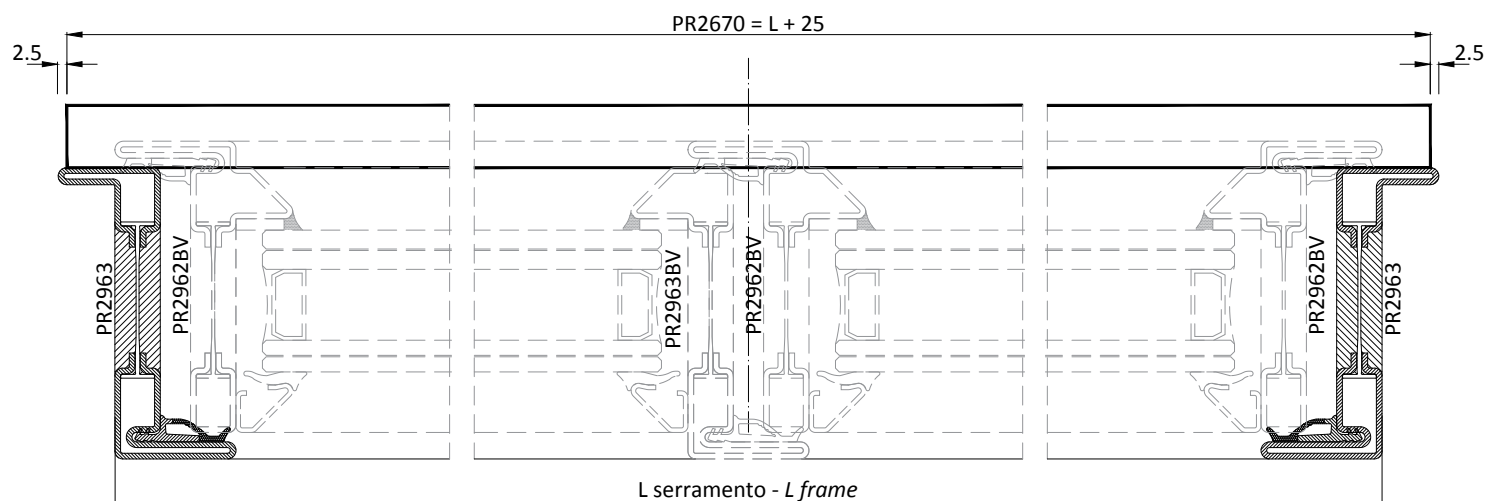
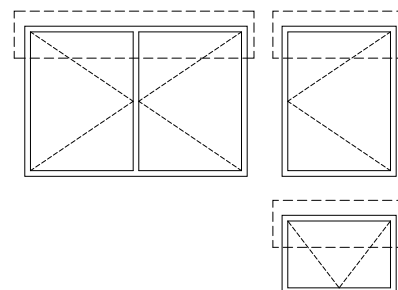
spacco ambo i lati
holes on both sides

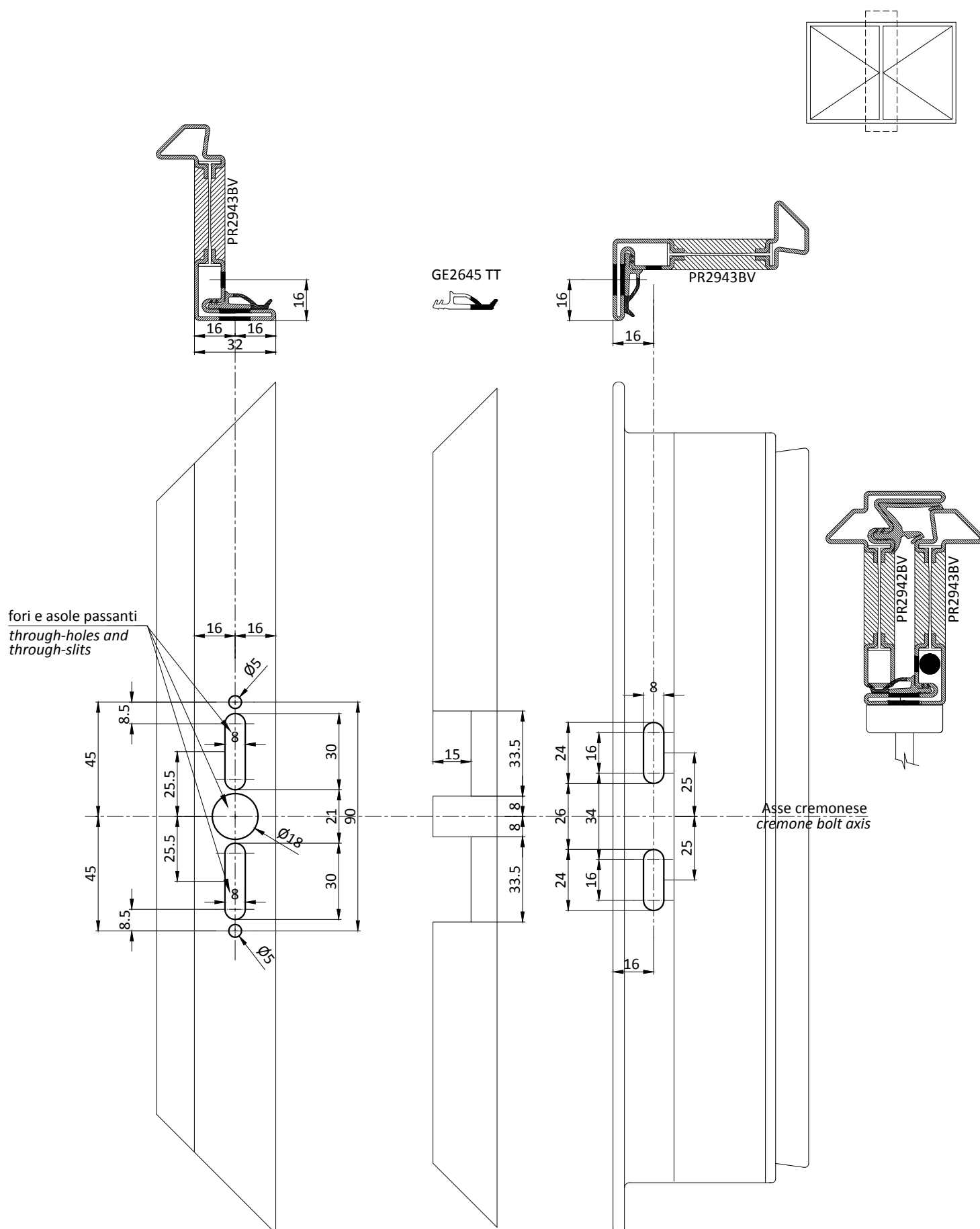


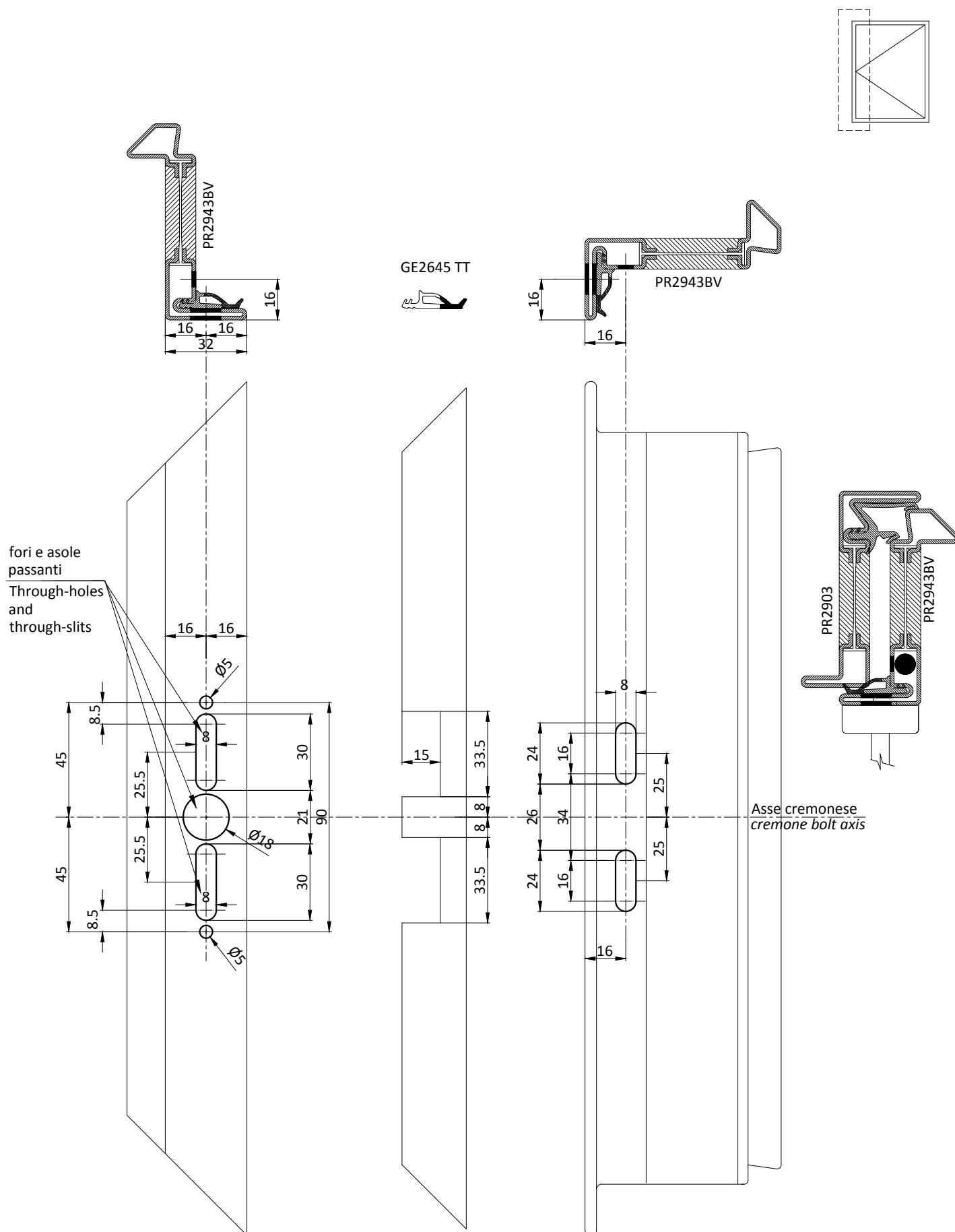
spacco ambo i lati
holes on both sides

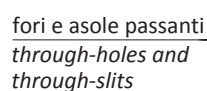


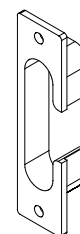
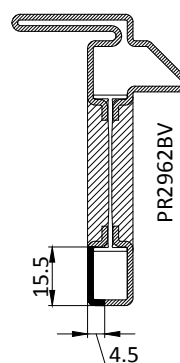
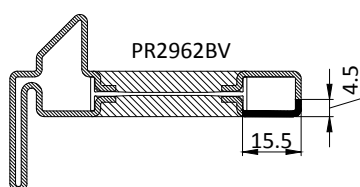
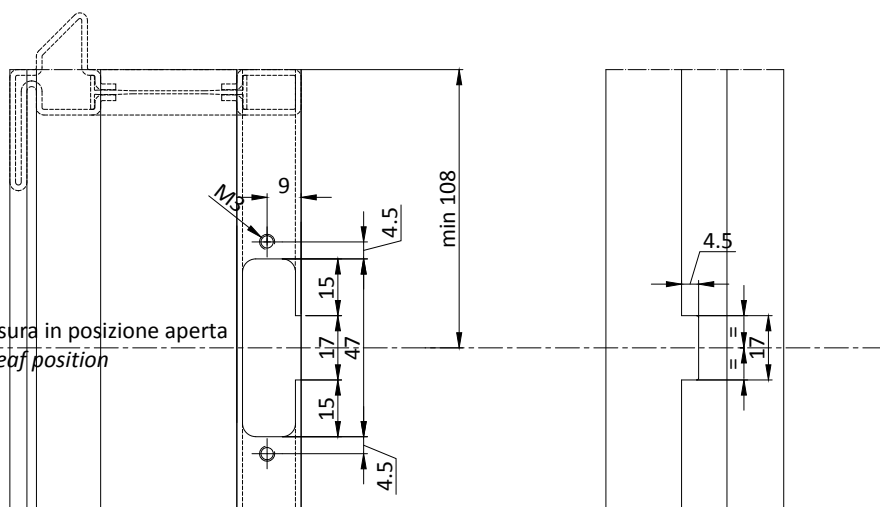
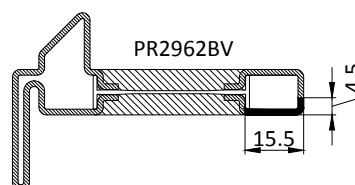
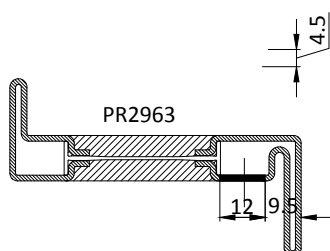
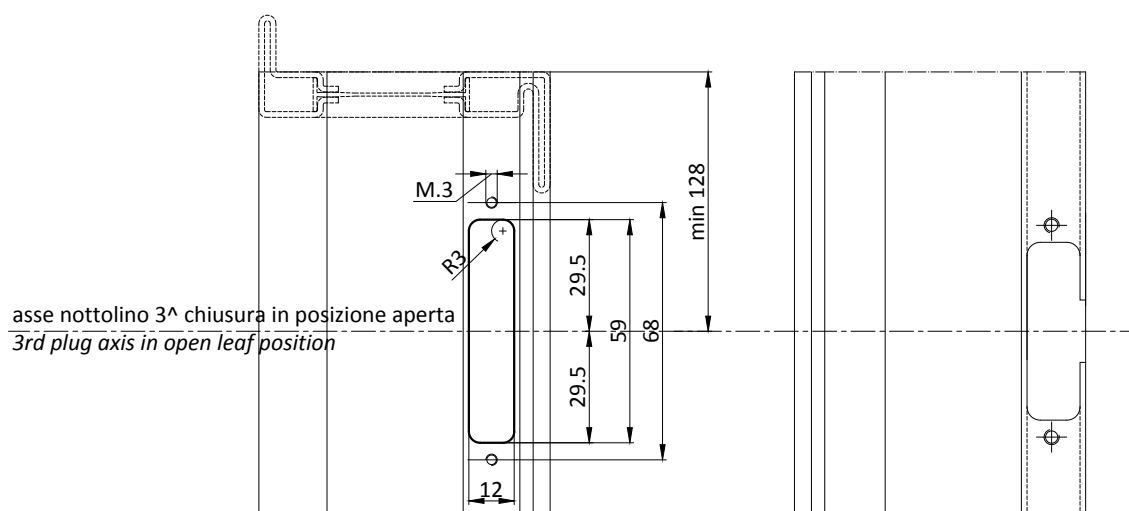


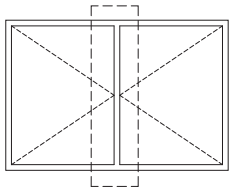








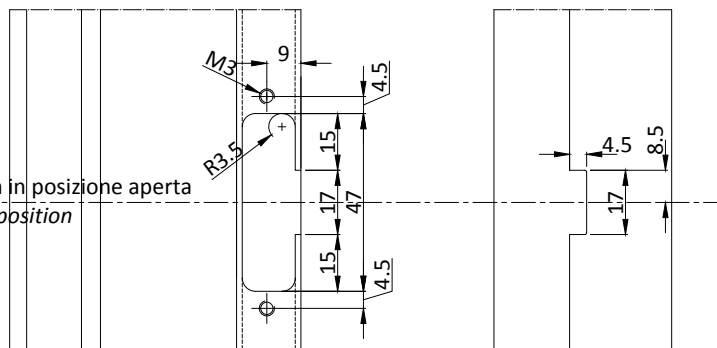
lavorazione applicazione incontro
Processing for strike plate installationasse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf positionIncontro 3^a chiusura
3rd lock strike platelavorazione applicazione nottolino
Processing for plug installationasse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position





lavorazione applicazione incontro
Processing for the installation of the strike plate

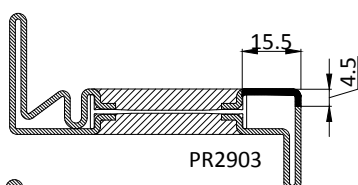
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



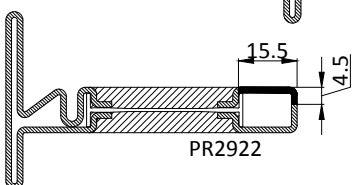
Incontro 3^a chiusura
3rd lock strike plate

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

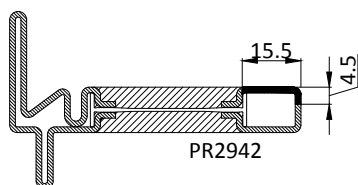
N.B.: Distance between the closing
points max. 1000 mm



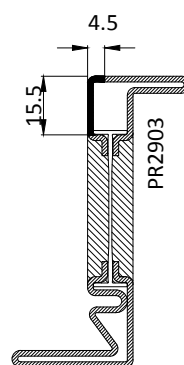
PR2903



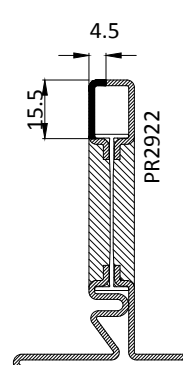
PR2922



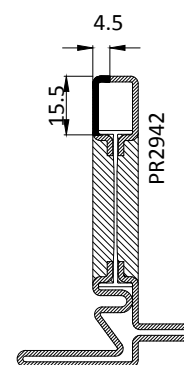
PR2942



PR2903



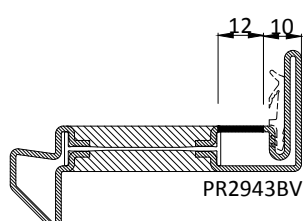
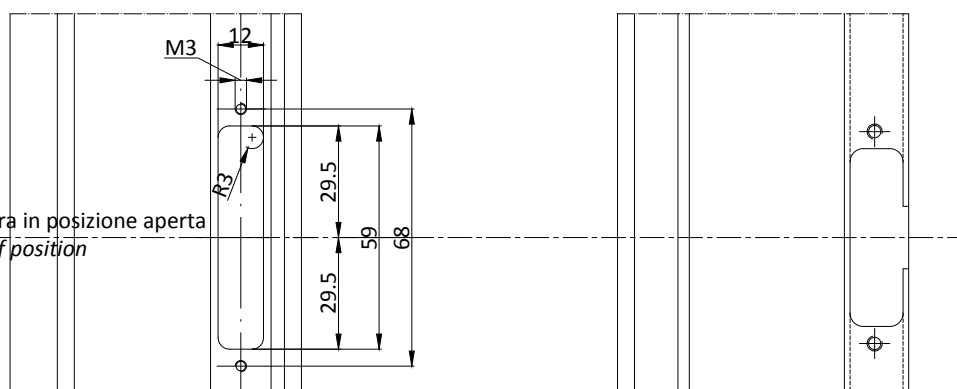
PR2922



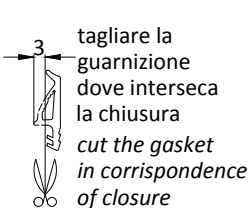
PR2942

lavorazione applicazione nottolino
Processing for plug installation

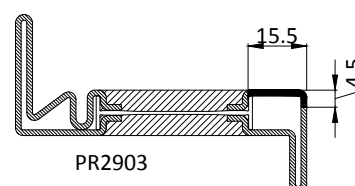
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



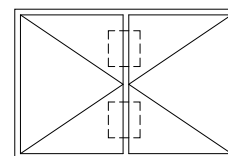
PR2943BV



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

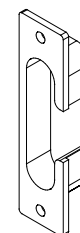
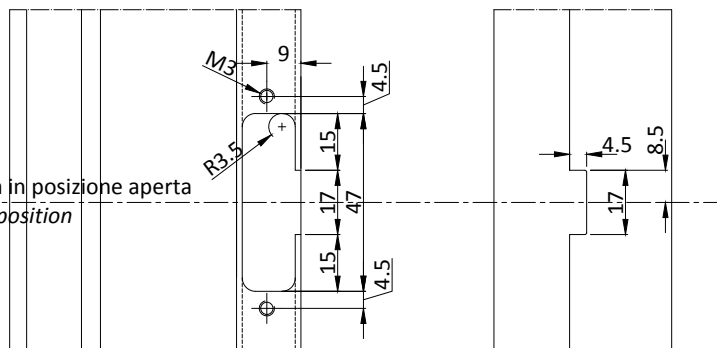


PR2903



lavorazione applicazione incontro
Processing for the installation of the strike plate

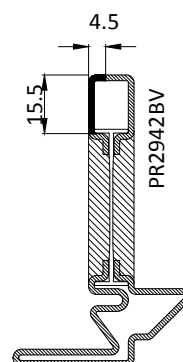
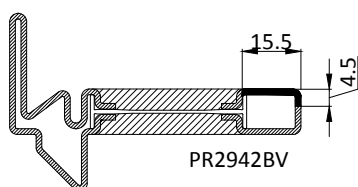
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



Incontro 3^a chiusura
3rd lock strike plate

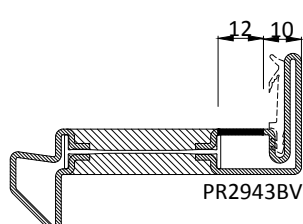
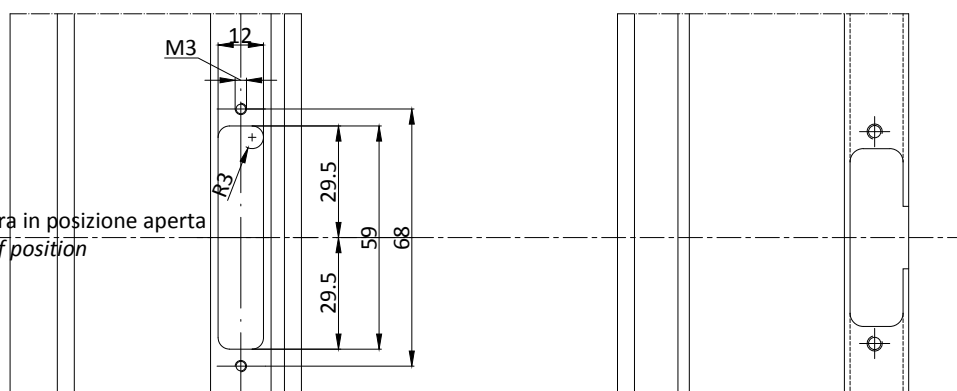
N.B.: Distanza massima tra i punti
di chiusura 1000 mm

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

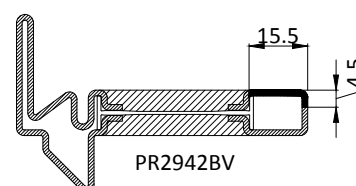


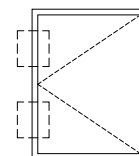
lavorazione applicazione nottolino
Processing for plug installation

asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



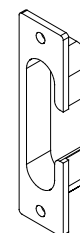
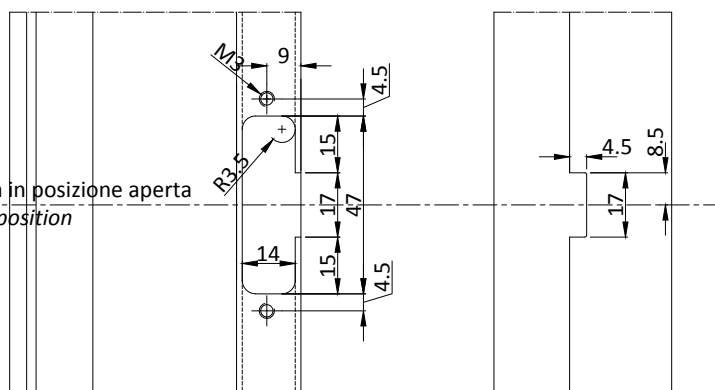
tagliare la
guarnizione
dove interseca
la chiusura
cut the gasket
in correspondence
of closure





lavorazione applicazione incontro
Processing for the installation of the strike plate

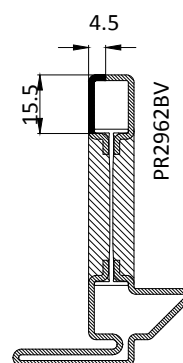
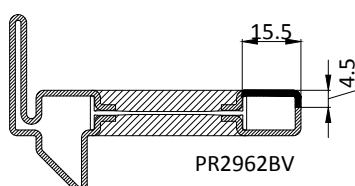
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



Incontro 3^a chiusura
3rd lock strike plate

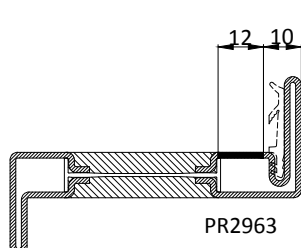
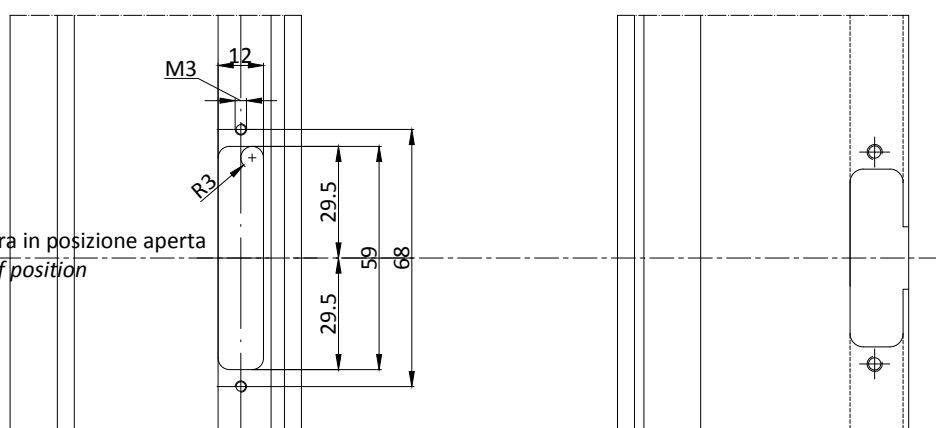
N.B.: Distanza massima tra i punti
di chiusura 1000 mm

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

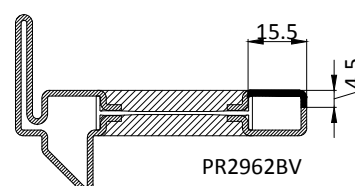


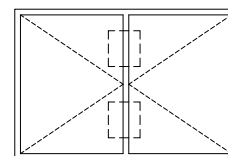
lavorazione applicazione nottolino
Processing for plug installation

asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



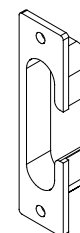
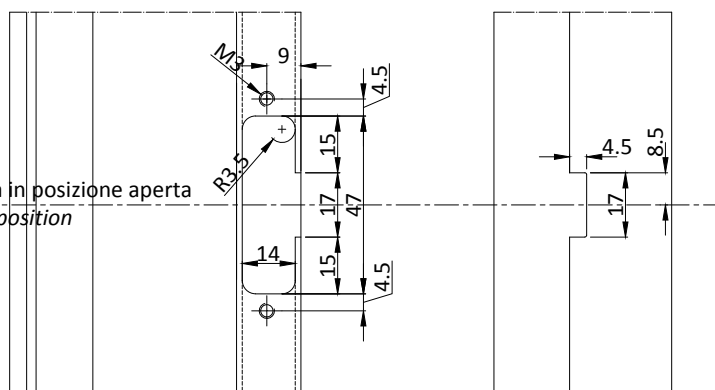
tagliare la
guarnizione
dove interseca
la chiusura
cut the gasket
in correspondence
of closure





lavorazione applicazione incontro
Processing for the installation of the strike plate

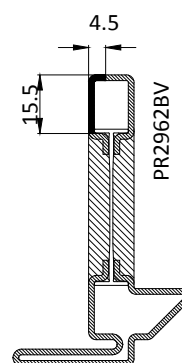
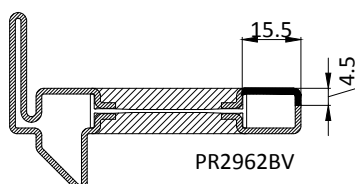
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



Incontro 3^a chiusura
3rd lock strike plate

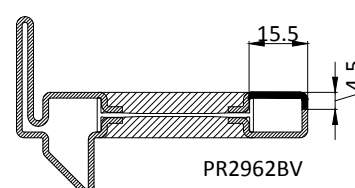
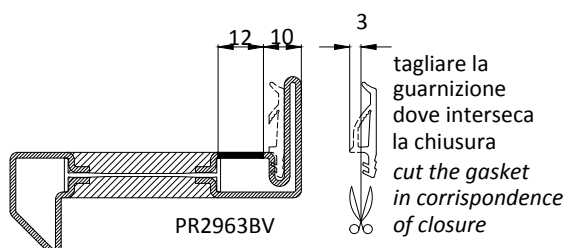
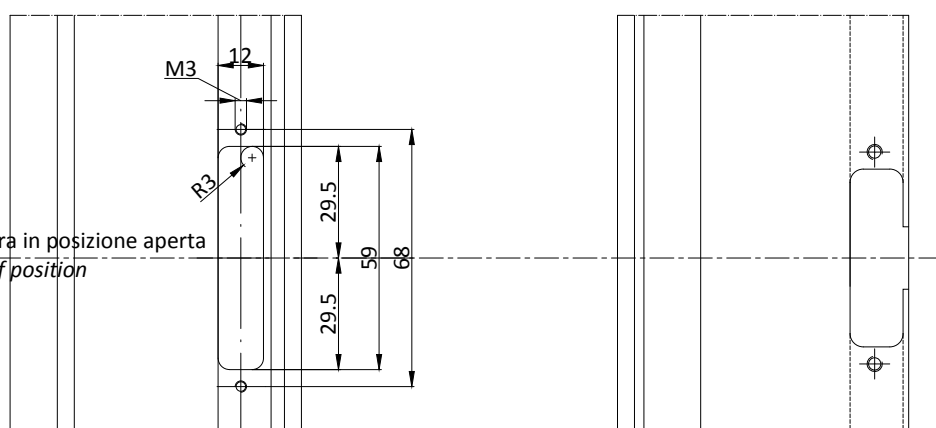
N.B.: Distanza massima tra i punti
di chiusura 1000 mm

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

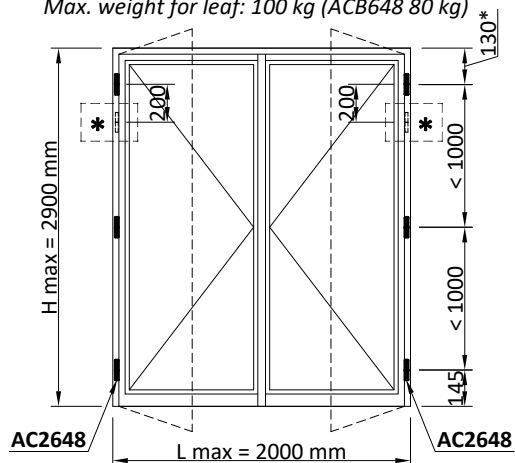


lavorazione applicazione nottolino
Processing for plug installation

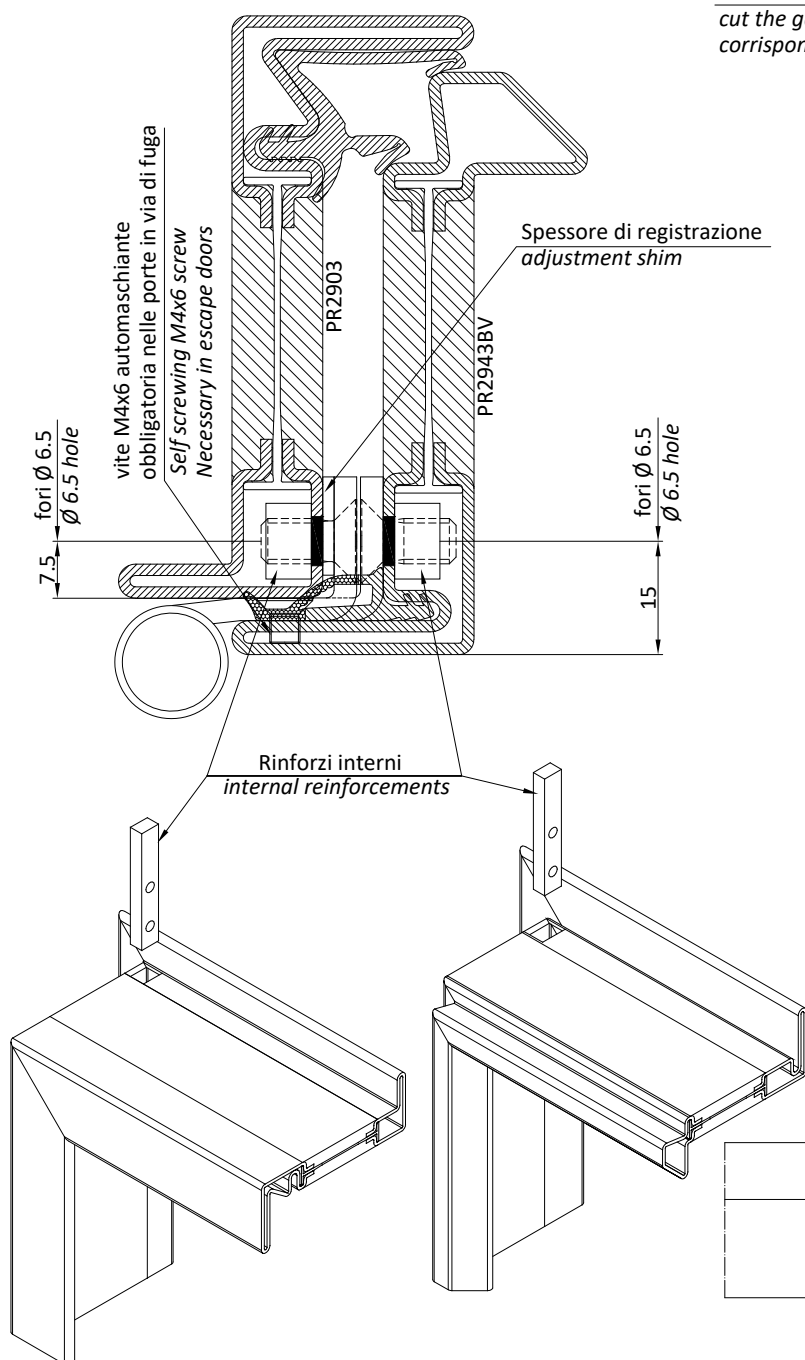
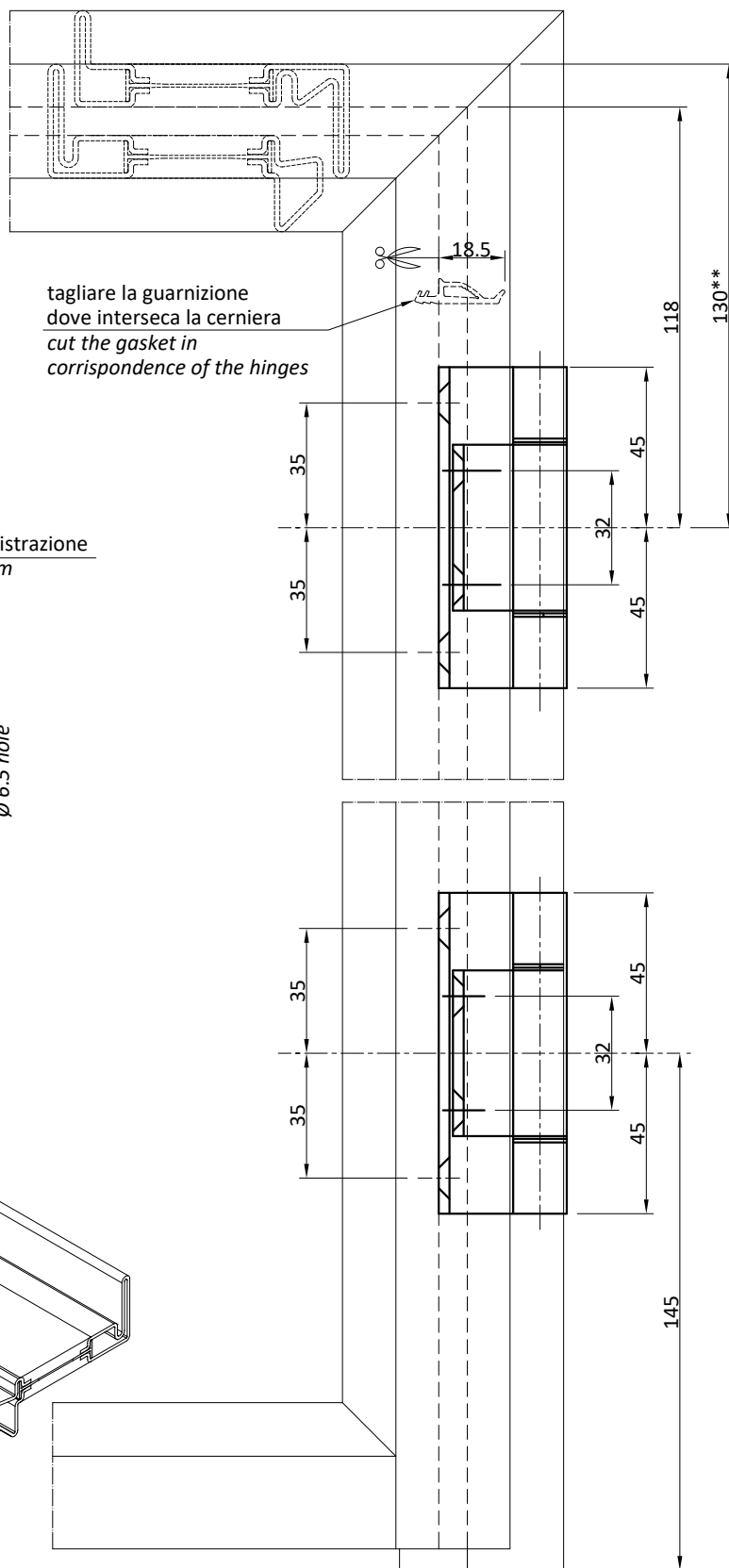
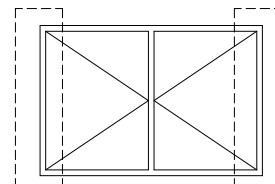
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



Peso max. per anta 100 kg (ACB648 80 kg)
Max. weight for leaf: 100 kg (ACB648 80 kg)



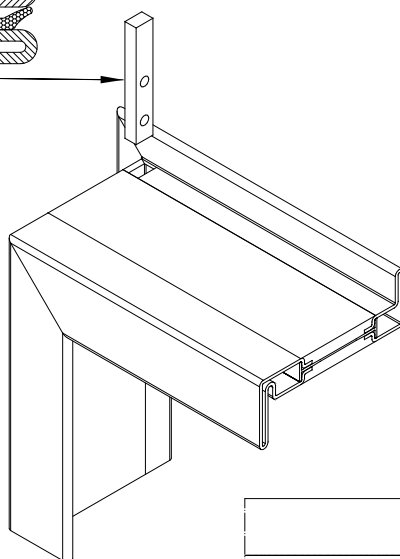
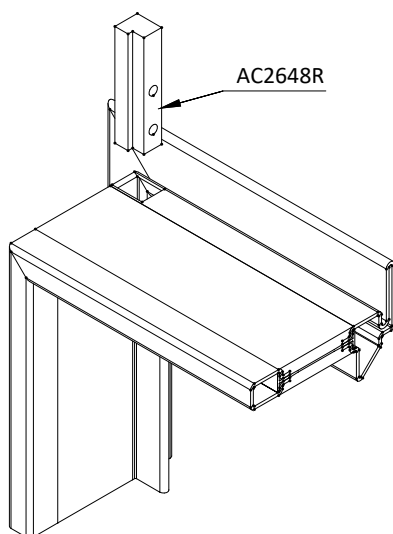
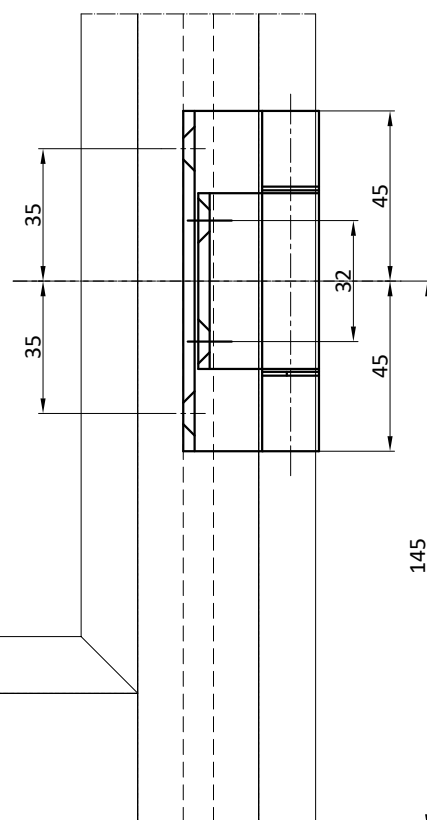
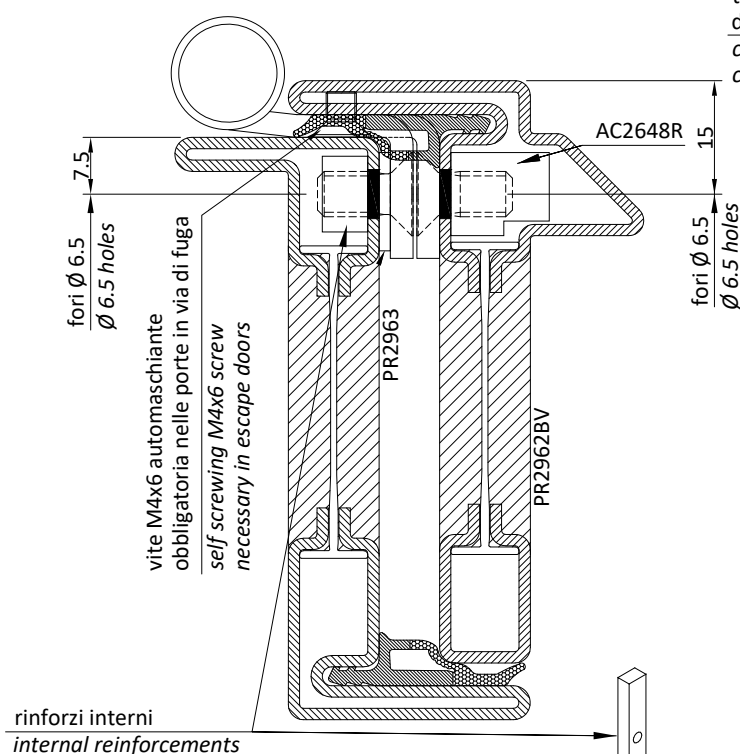
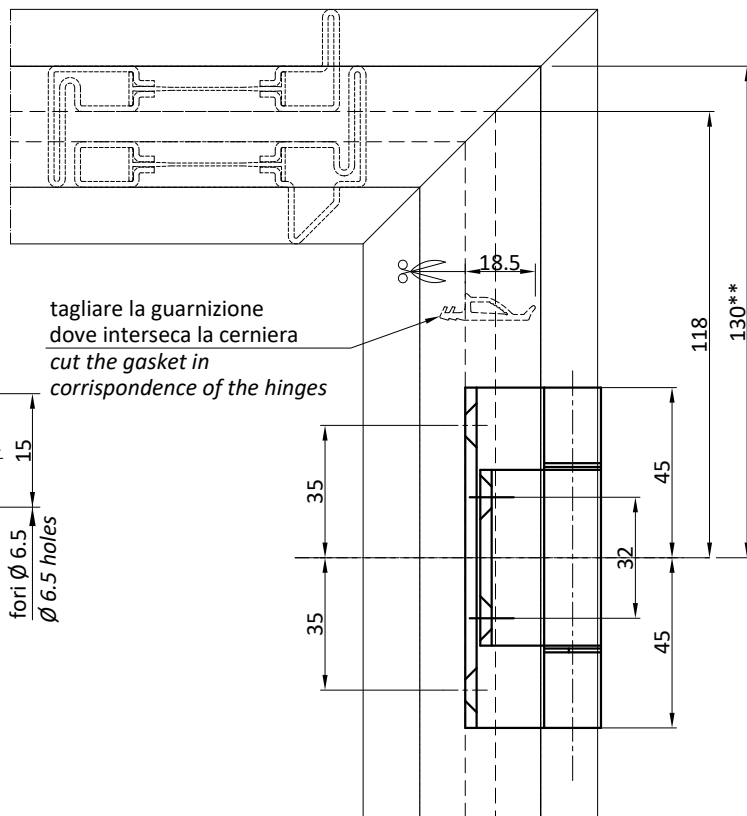
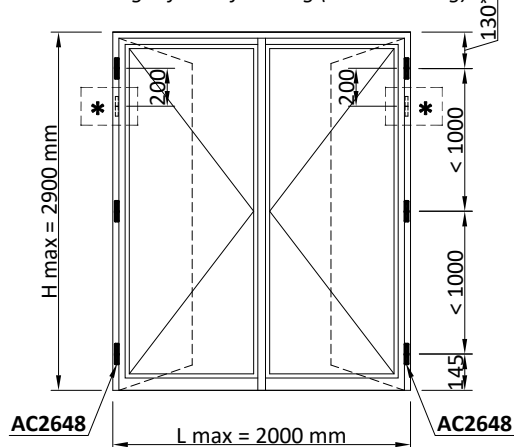
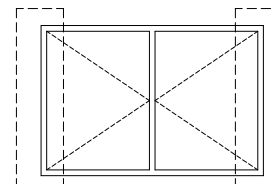
*AC2648:
Cerniera aggiuntiva per peso anta
>100kg - peso max 130 kg
Additional hinge for weight of leaf
>100 kg - max 130 kg



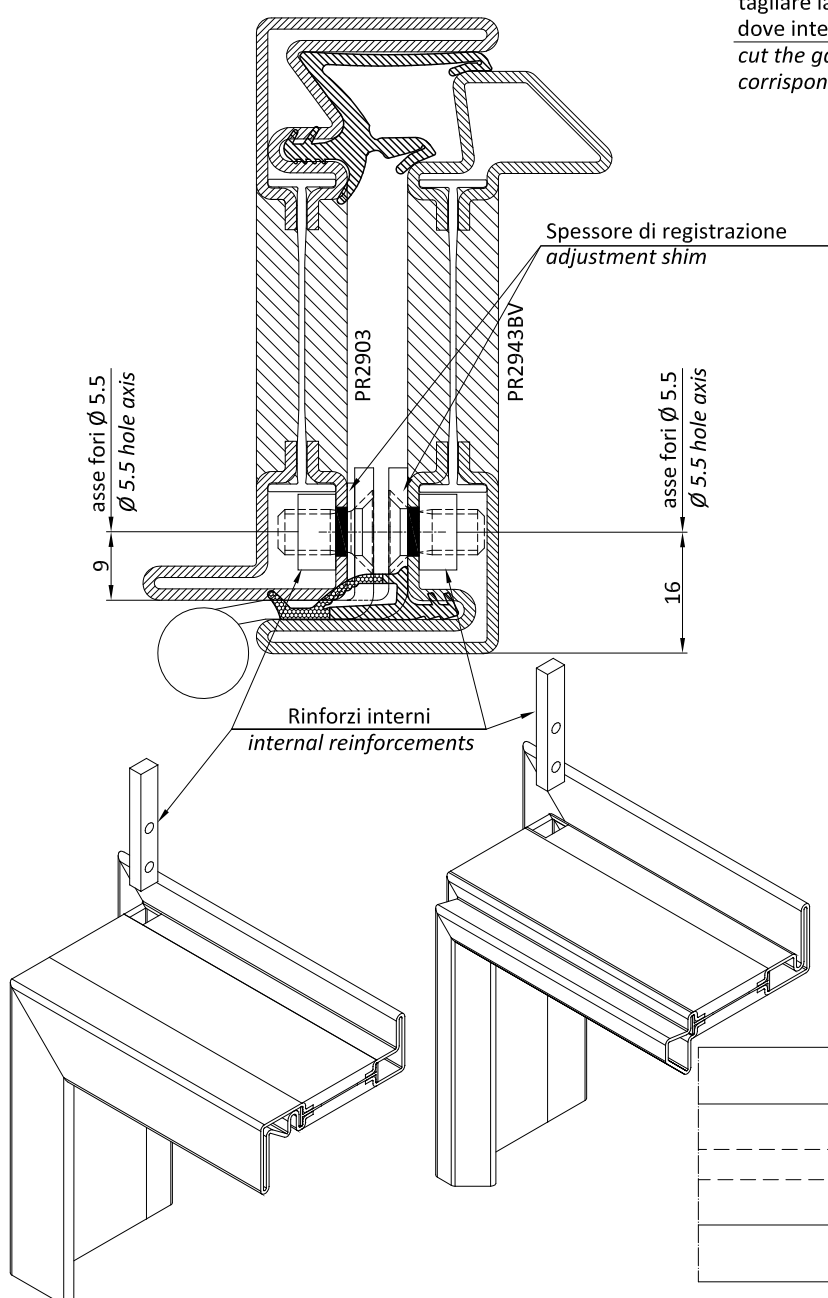
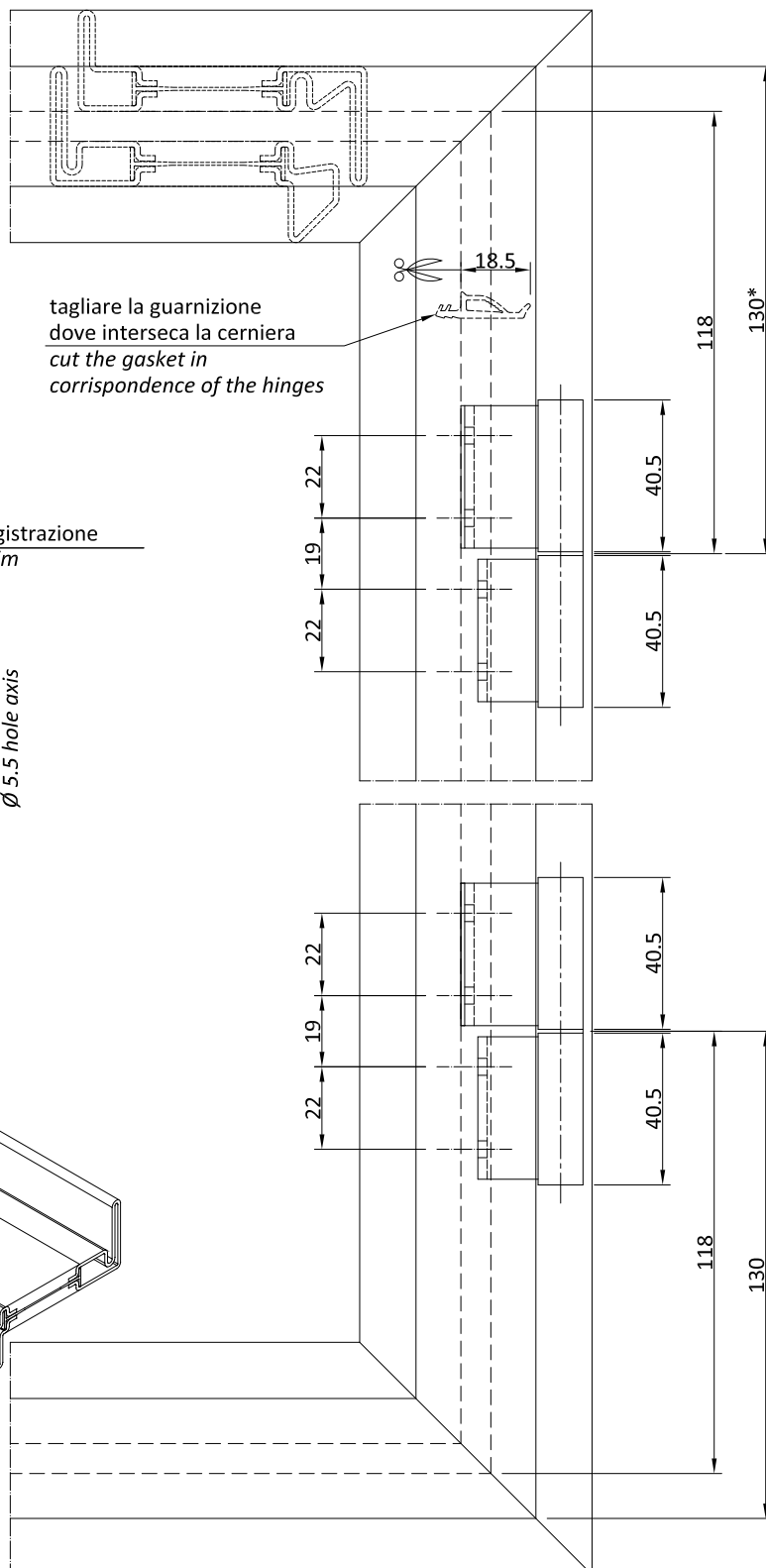
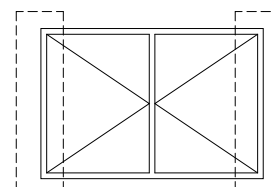
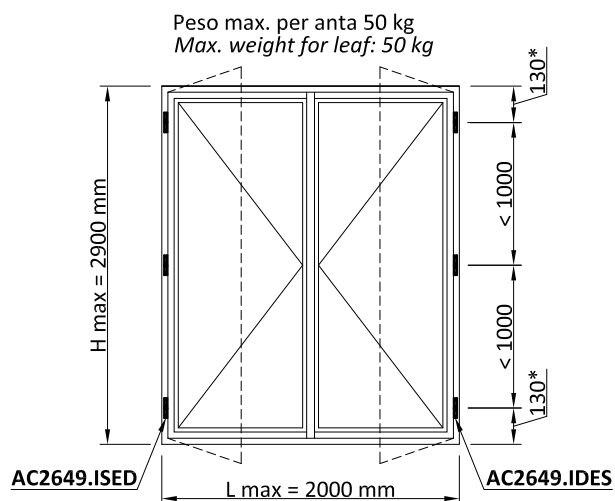
**150 mm ottone | brass

Peso max. per anta 100 kg (ACB648 80 kg)
Max. weight for leaf: 100 kg (ACB648 80 kg)

*AC2648:
Cerniera aggiuntiva per peso anta
>100kg - peso max 130 kg
Additional hinge for weight of leaf
>100 kg - max 130 kg



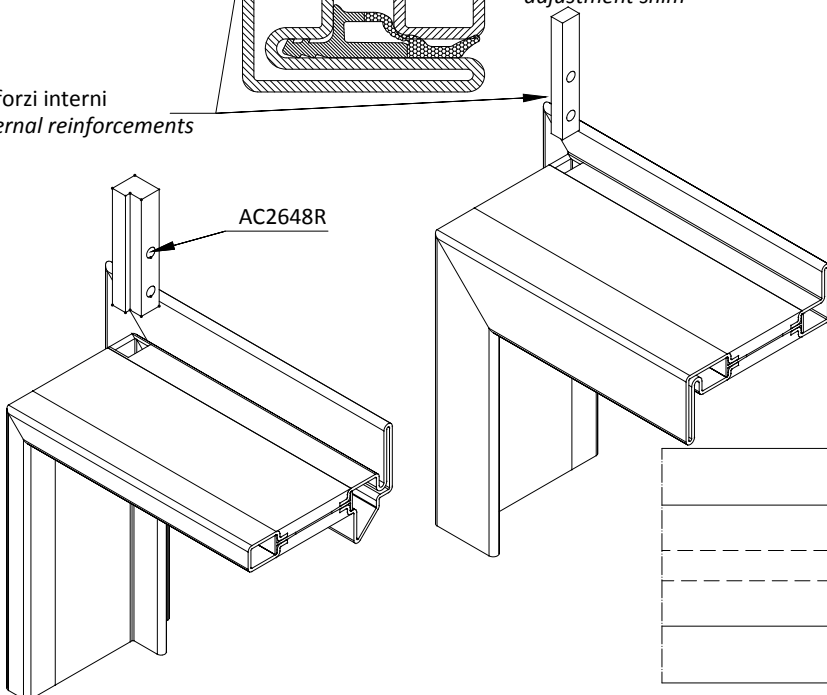
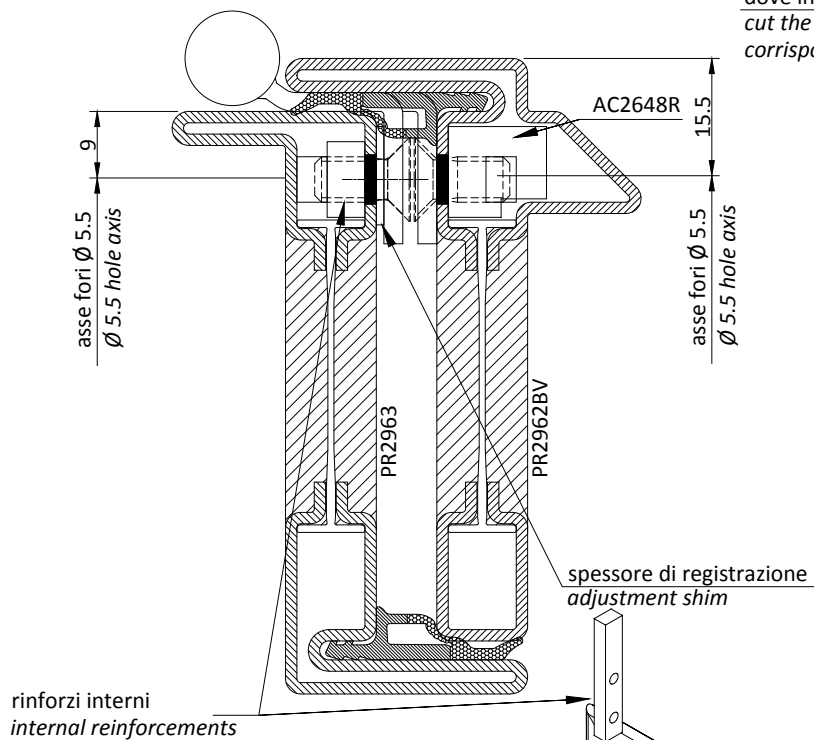
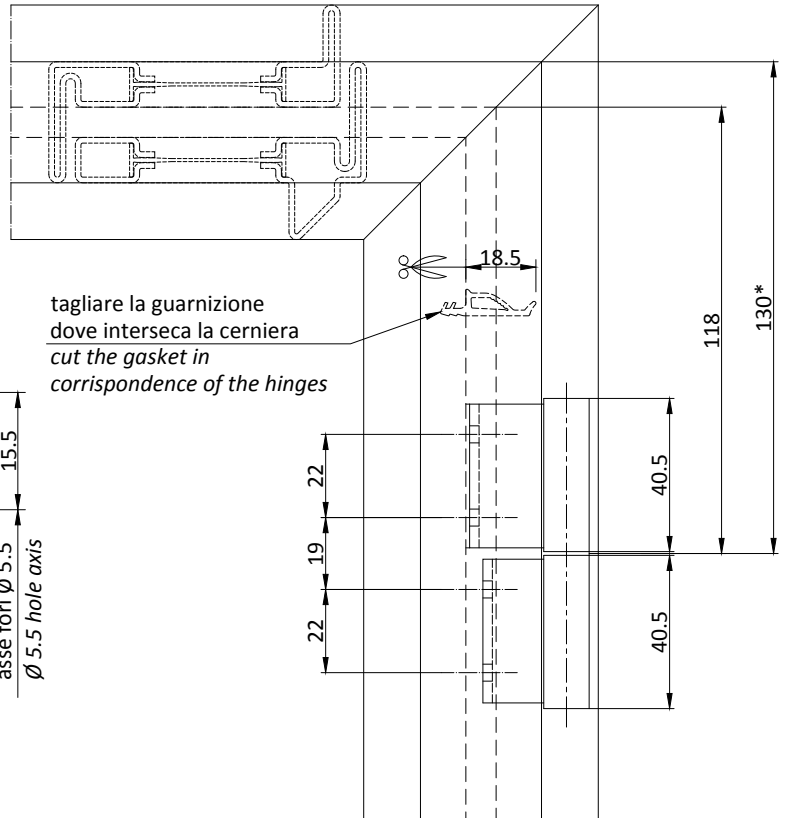
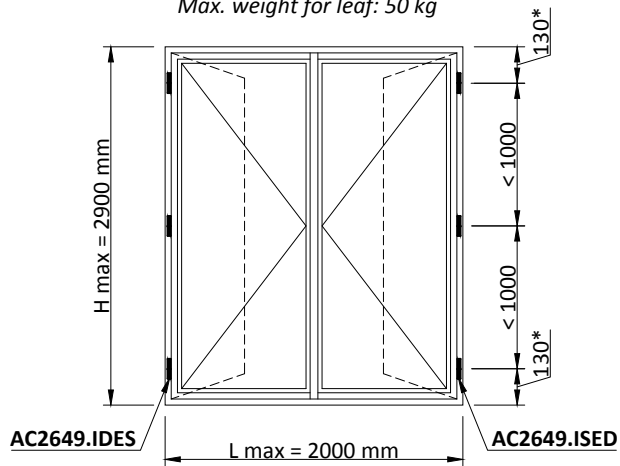
**150 mm ottone | brass



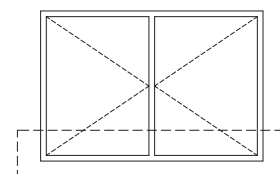
Per l'applicazione delle cerniere AC2649.ISED - AC2649.IDES utilizzare maschera AT2629
For the installation of hinges AC2649.ISED - AC2649.IDES please use the jig AT2629

*150 mm ottone | brass

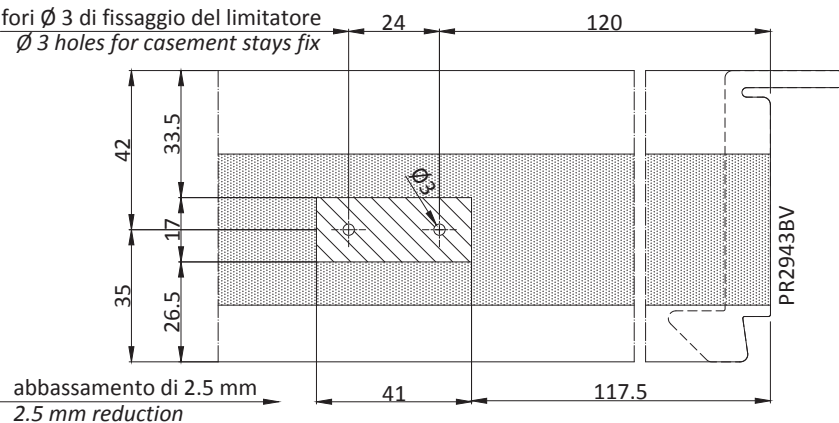
Peso max. per anta 50 kg
Max. weight for leaf: 50 kg



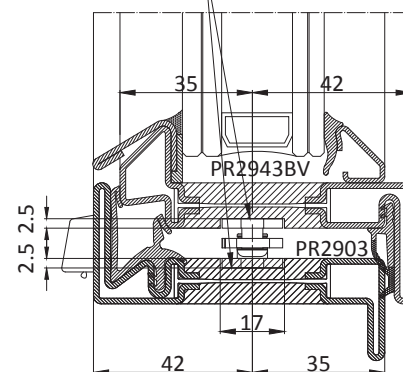
*150 mm ottone|*brass*



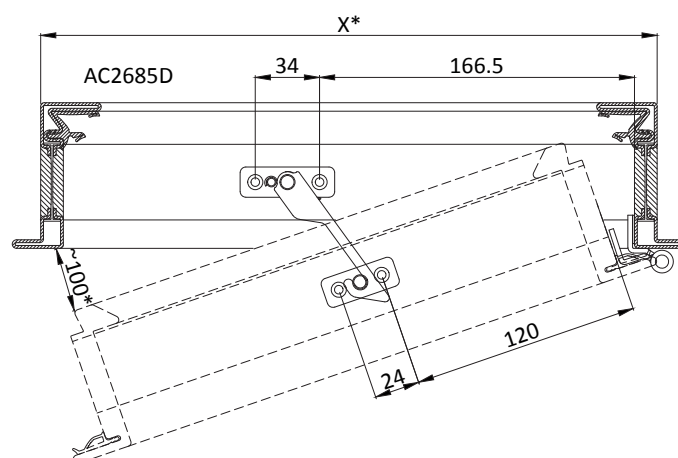
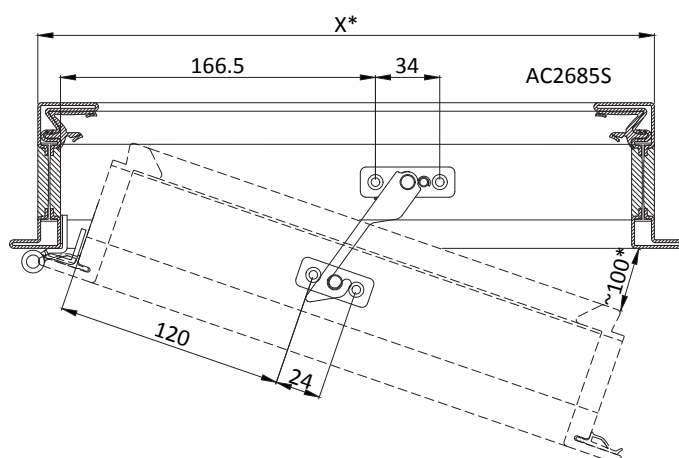
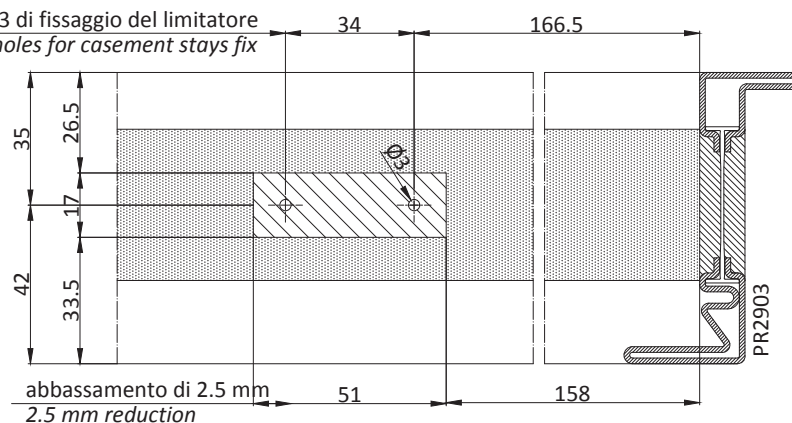
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fix



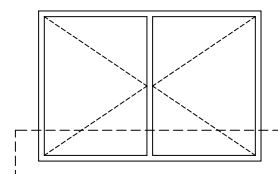
abbassamento di 2.5 mm
2.5 mm reduction



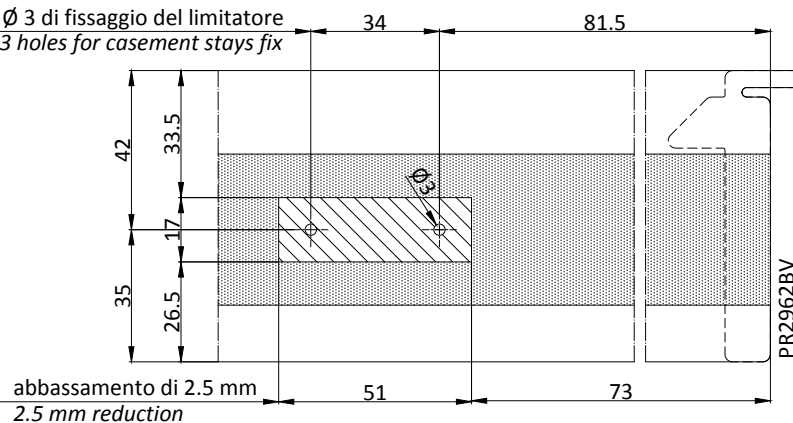
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fix



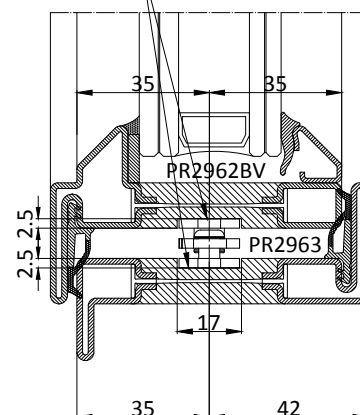
* simulazione di applicazione su larghezza telaio (X) 500 mm e apertura massima ~100 mm
* fitting simulation for frame width (X) 500mm and maximum opening ~100 mm



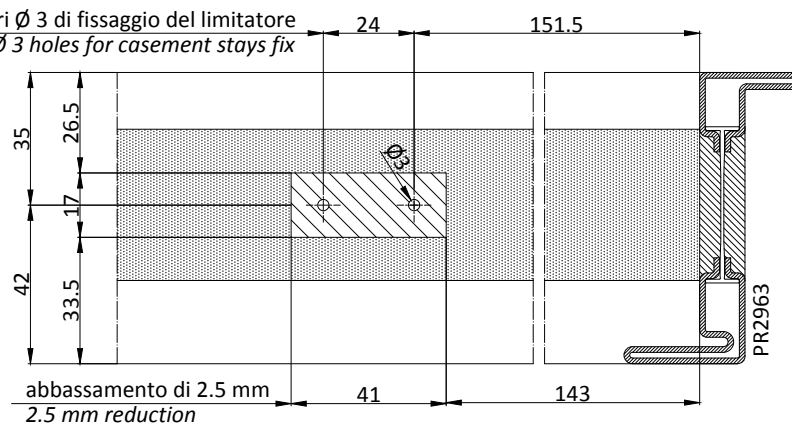
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fix



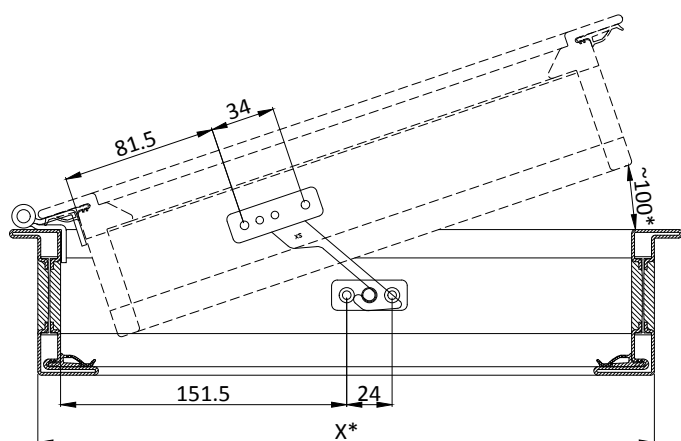
abbassamento di 2.5 mm
2.5 mm reduction



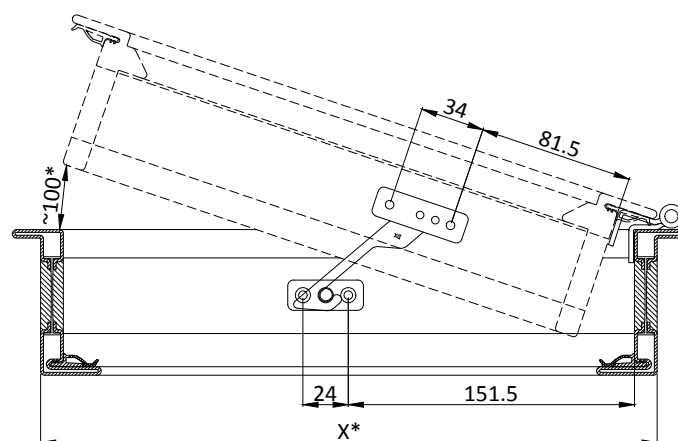
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fix



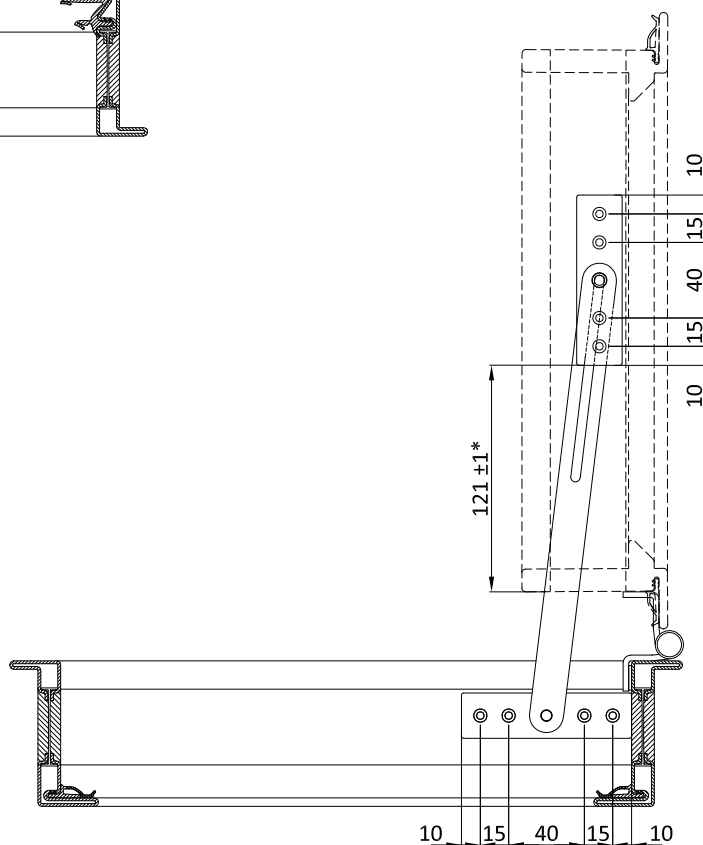
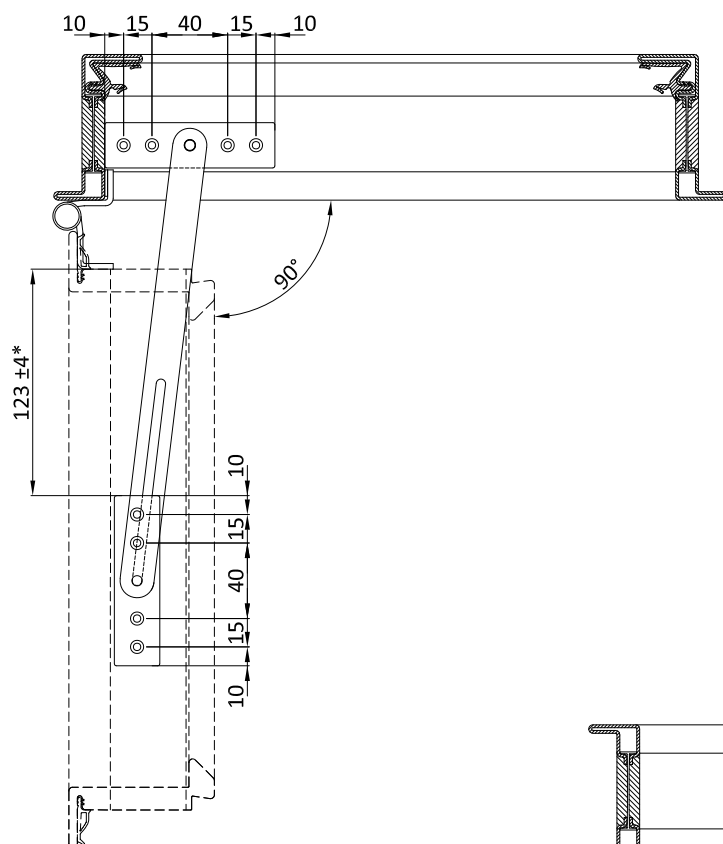
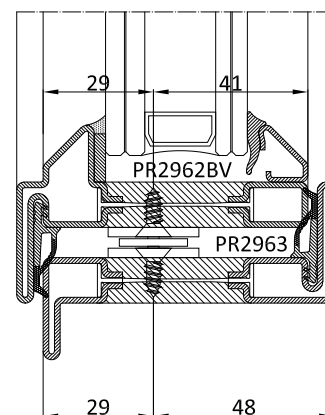
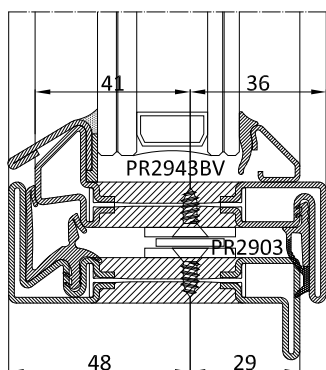
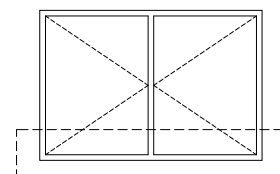
AC2685S



AC2685D

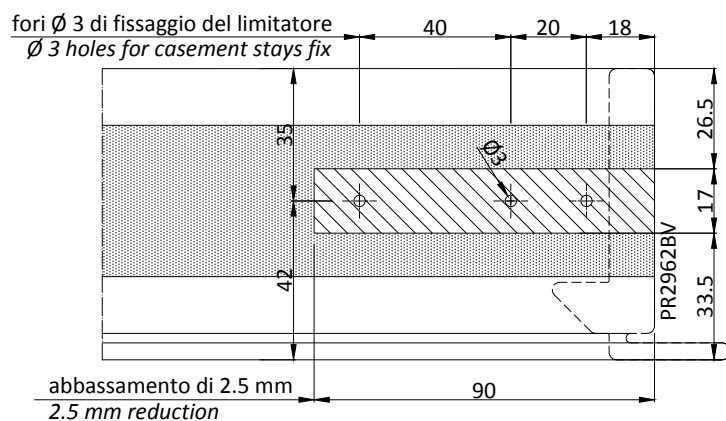
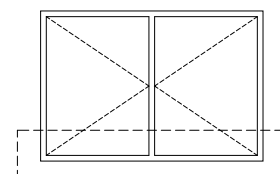


* simulazione di applicazione su larghezza telaio (X) 500 mm e apertura massima ~100 mm
* fitting simulation for frame width (X) 500mm and maximum opening ~100 mm

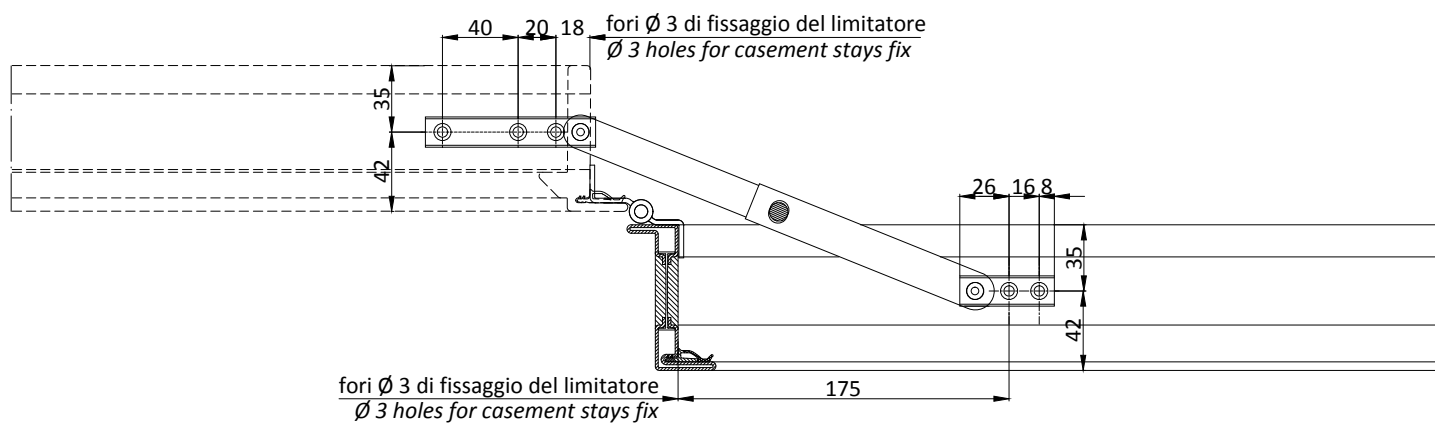
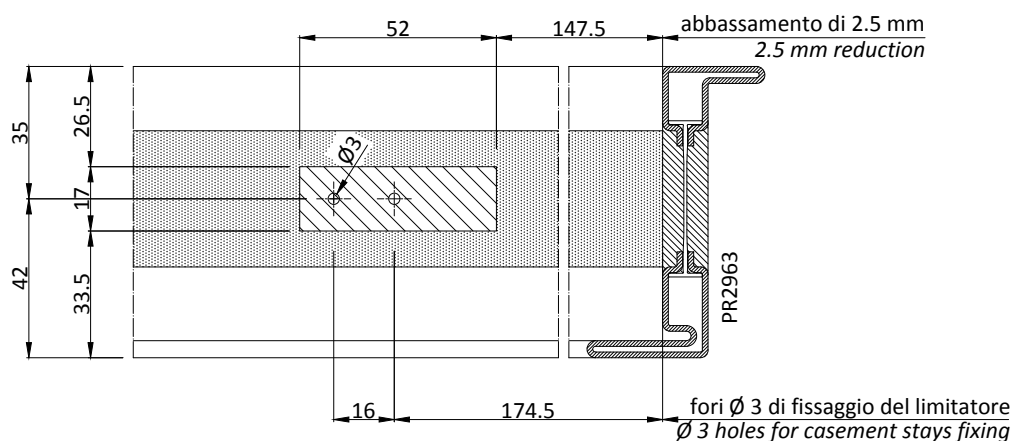
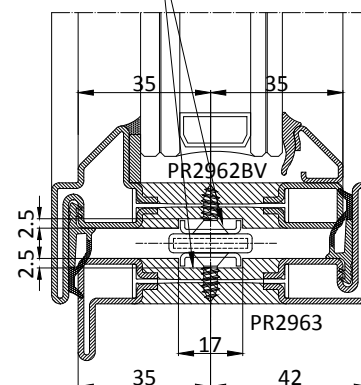


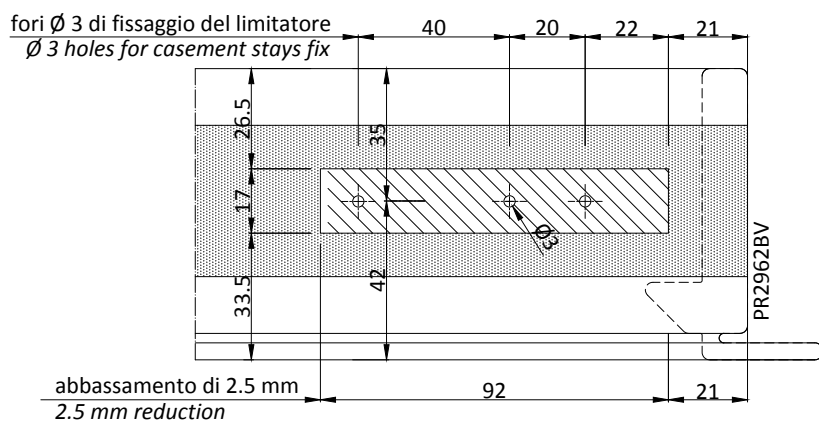
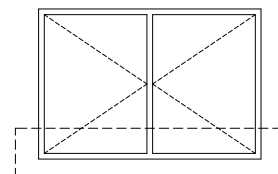
* dimensione variabile a seconda del profilo e delle cerniere utilizzate. Si consiglia il posizionamento sull'anta in opera.

* variable dimension according to the selected profile and hinges. To be positioned with the leaf in place.

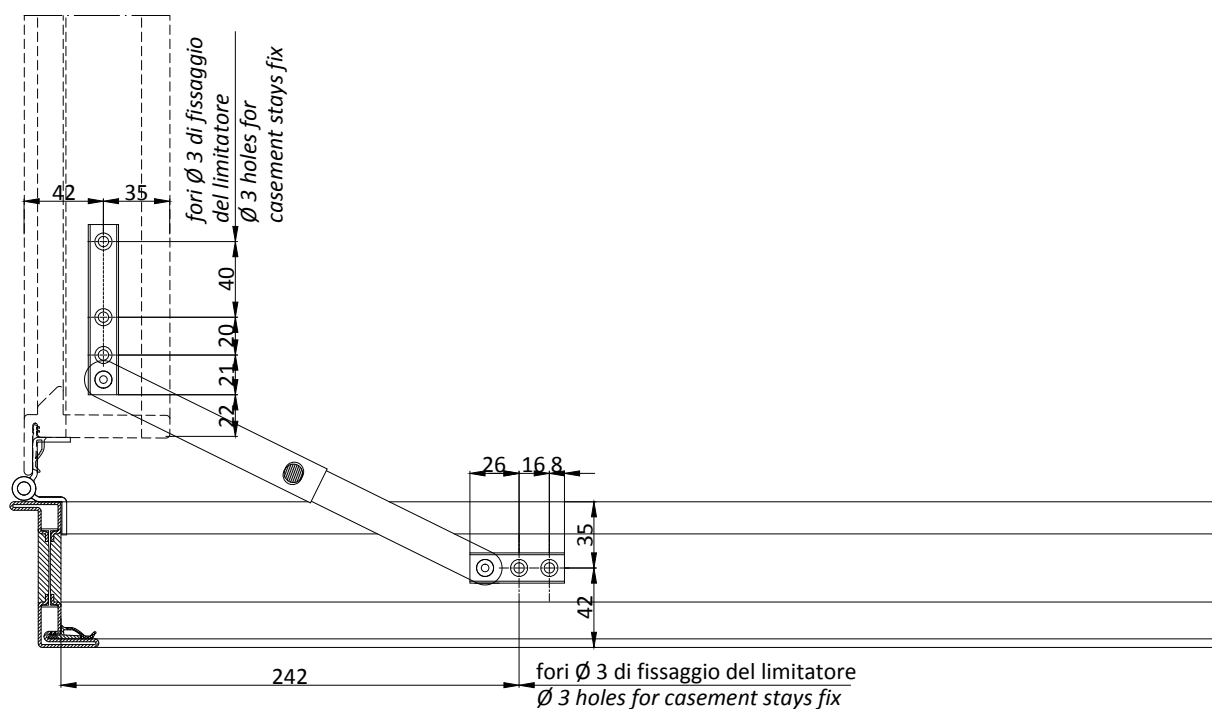
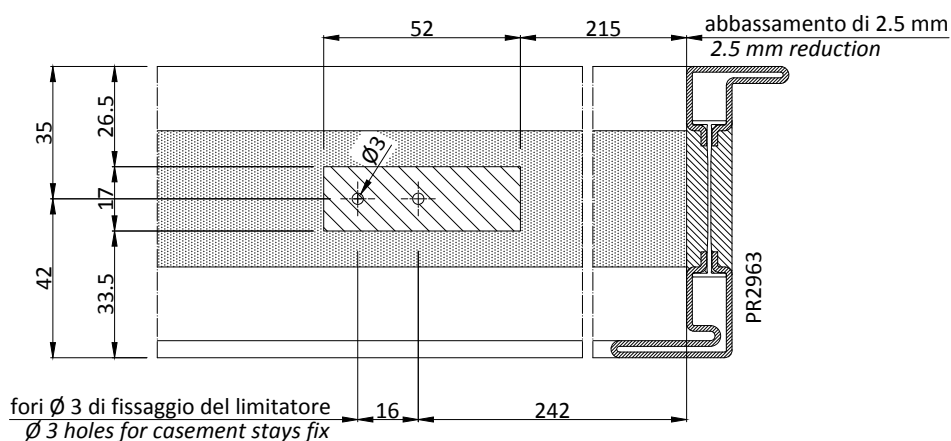
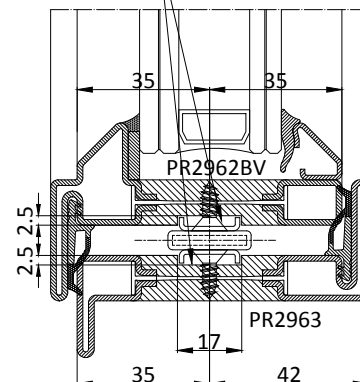


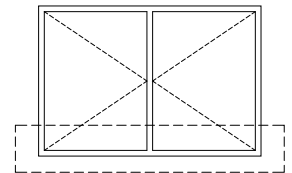
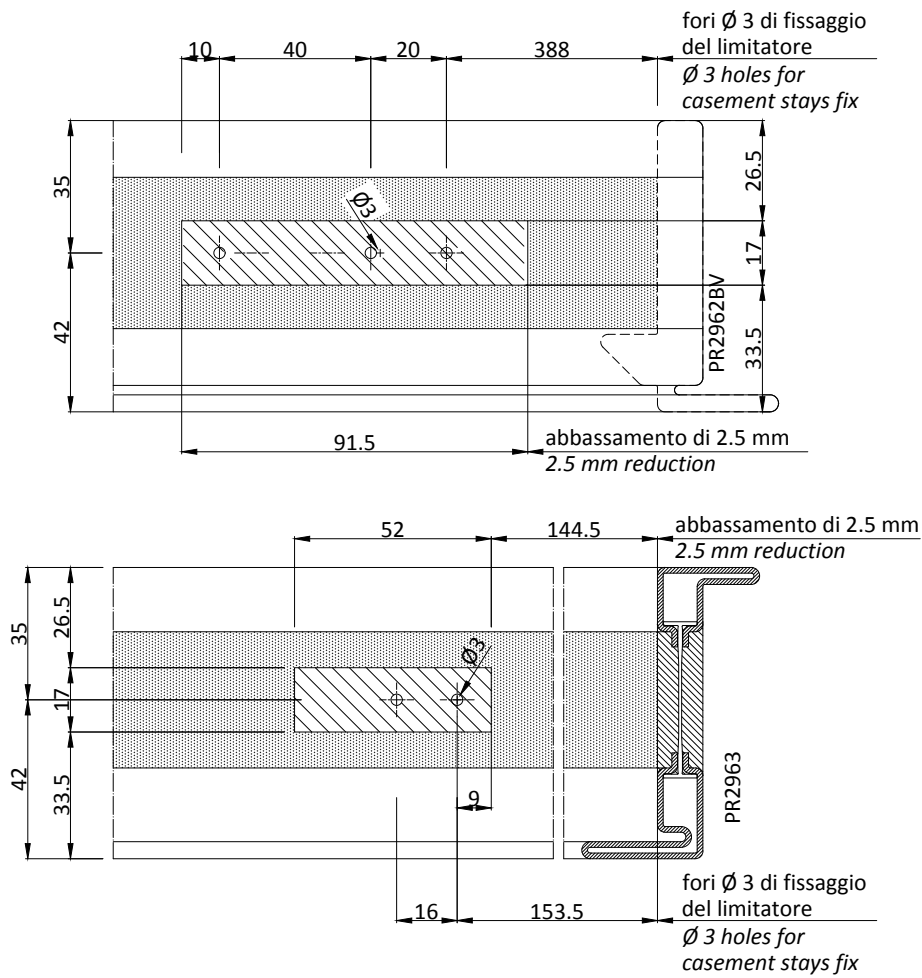
abbassamento di 2.5 mm
2.5 mm reduction



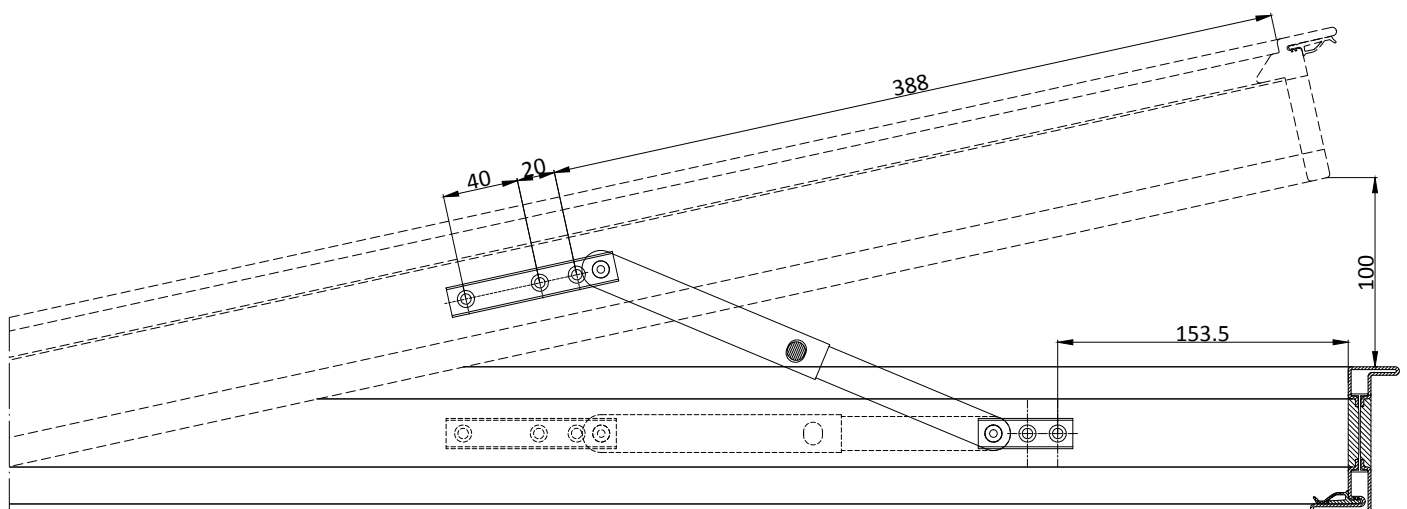
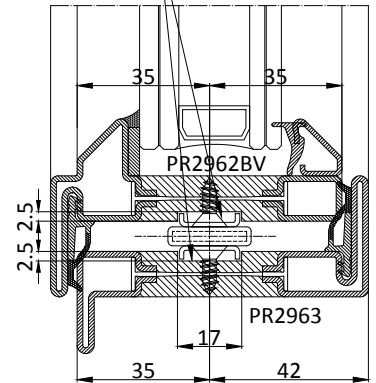


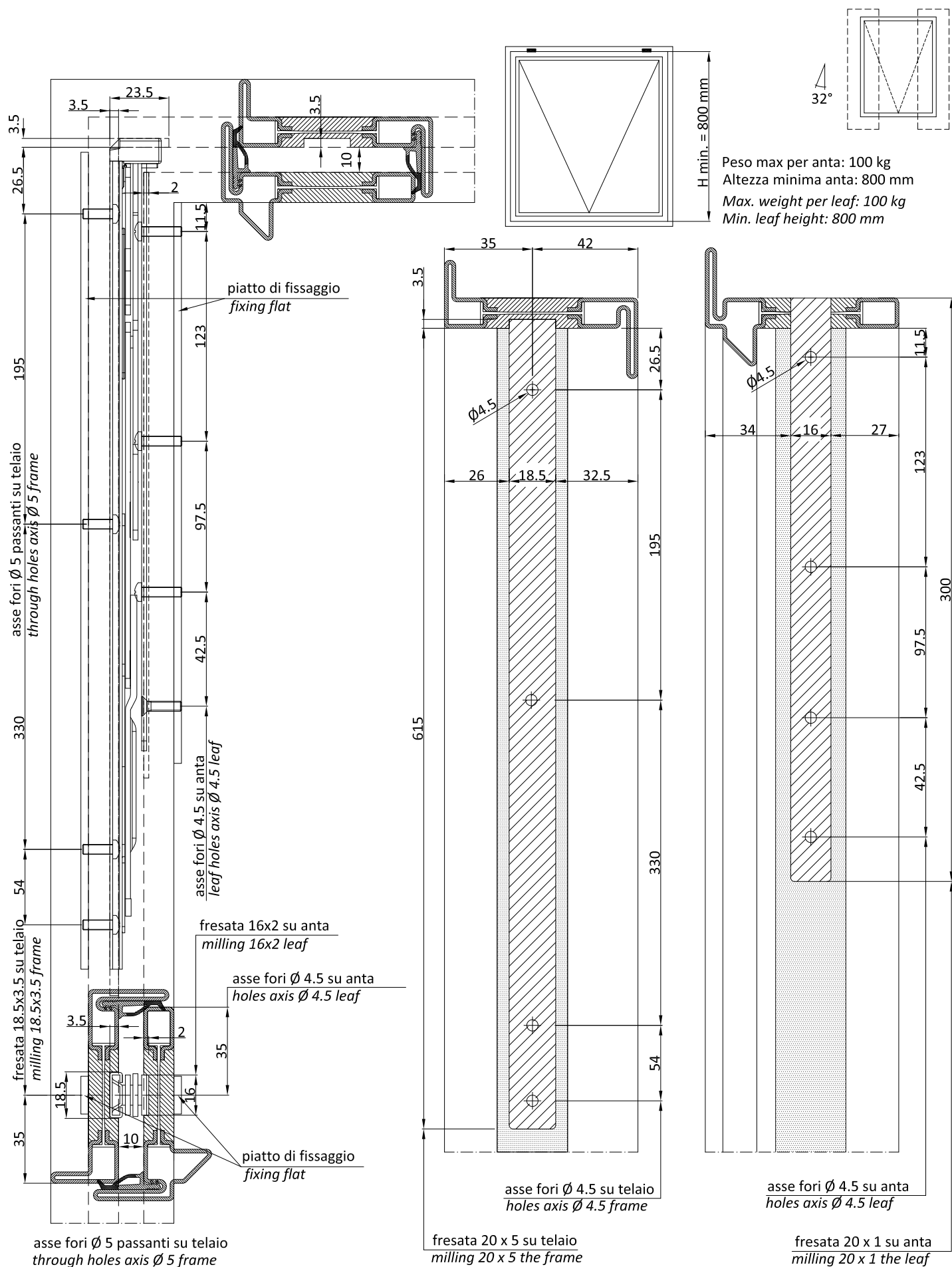
abbassamento di 2.5 mm
2.5 mm reduction

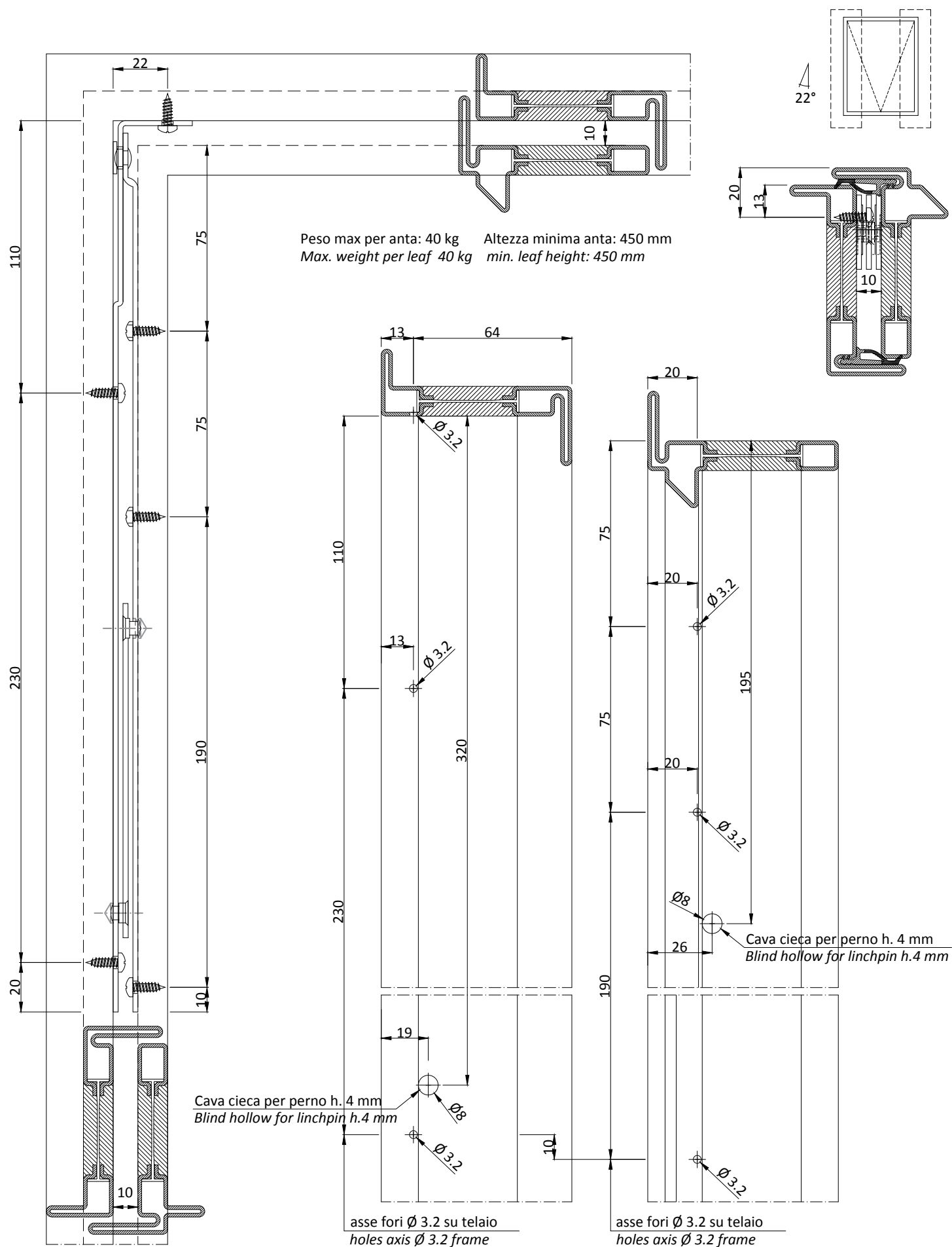


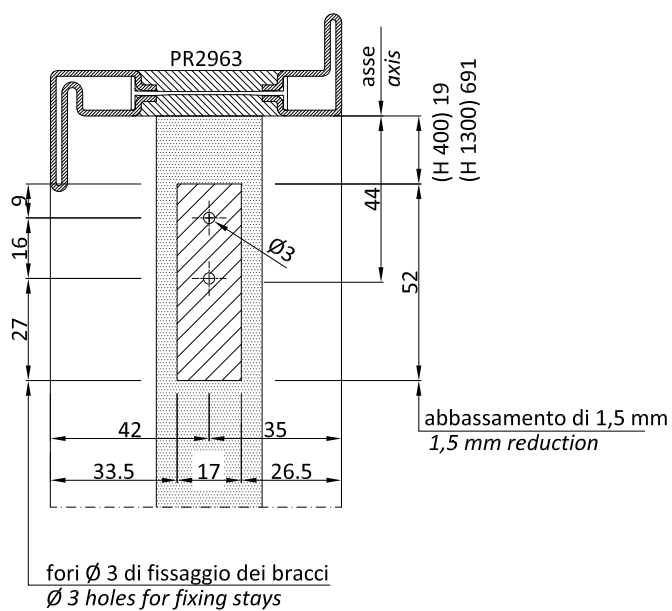


abbassamento di 2.5 mm
2.5 mm reduction

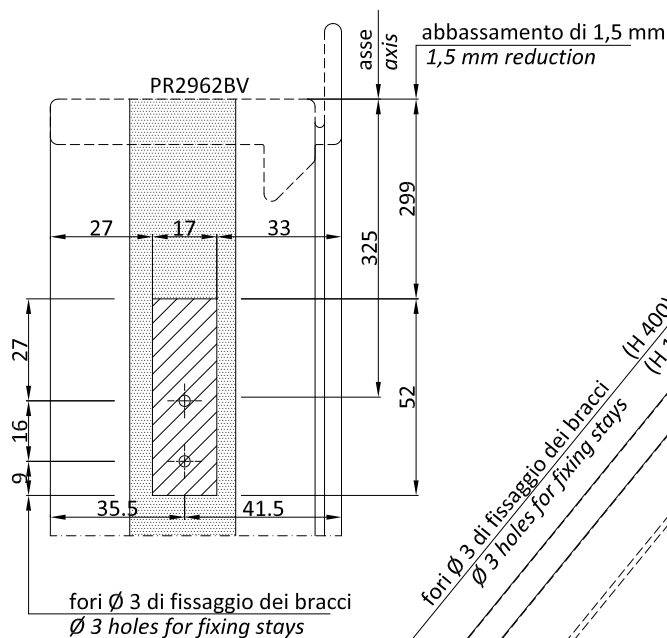
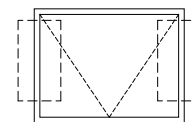
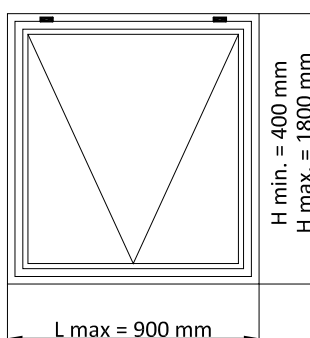






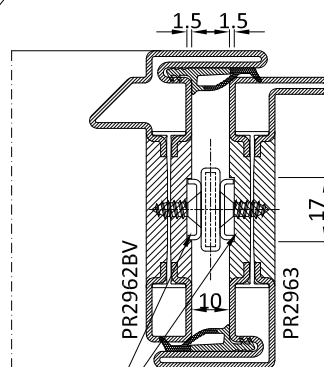
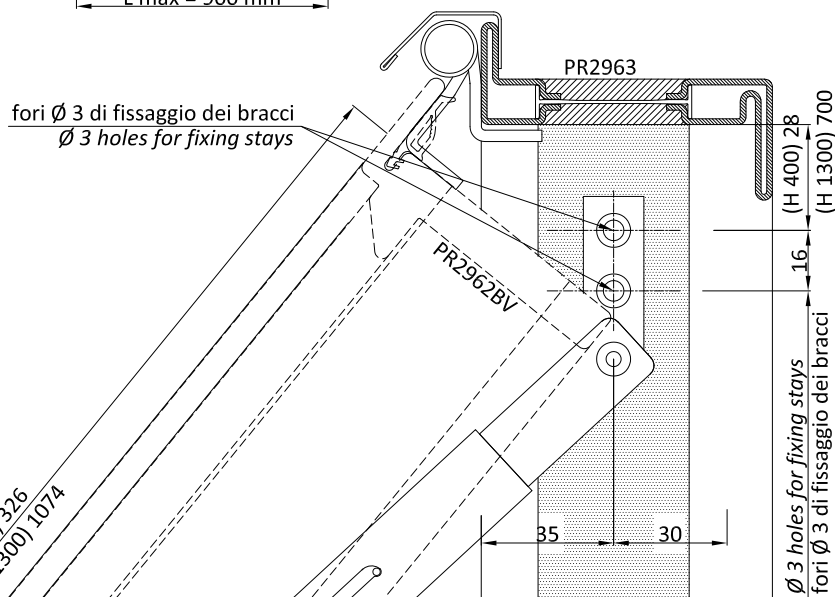
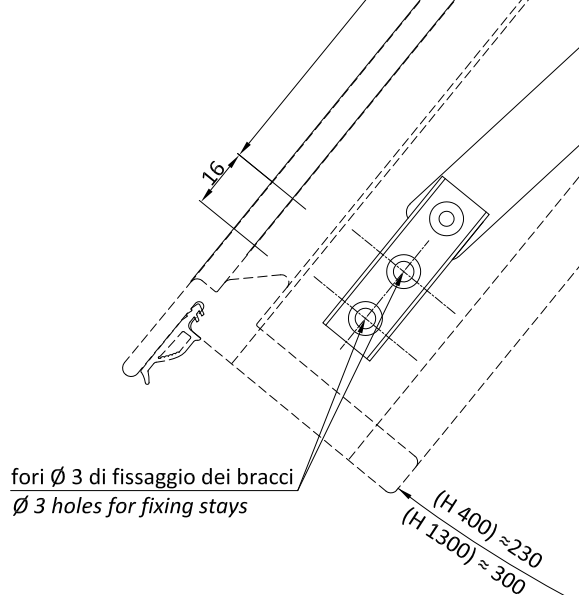


peso max. per anta: 60 Kg
max. leaf weight: 60 Kg

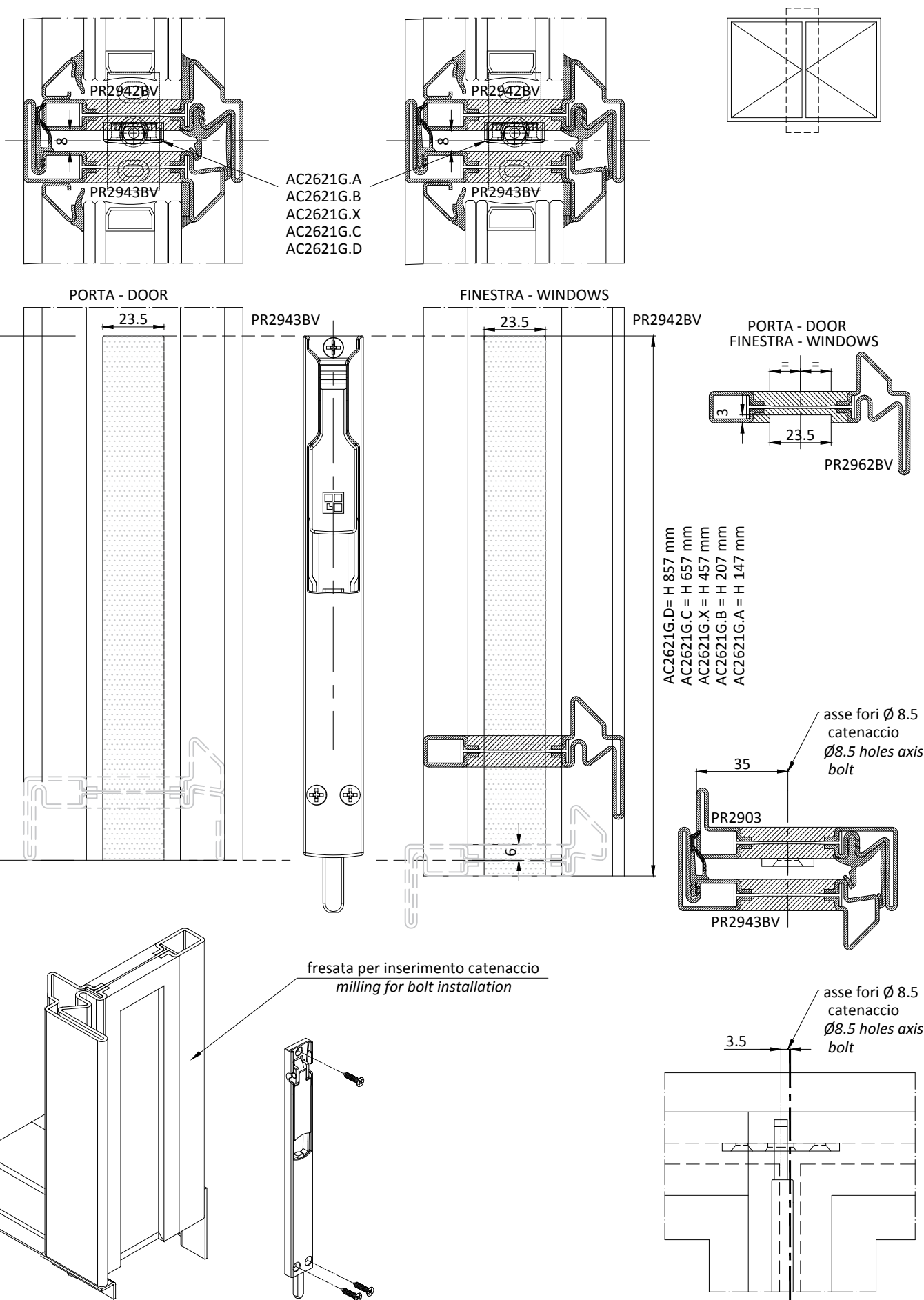


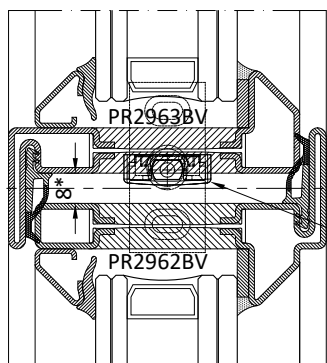
fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays

(H 400) 326
(H 1300) 1074

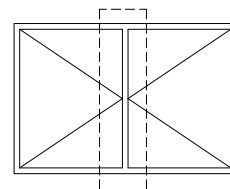
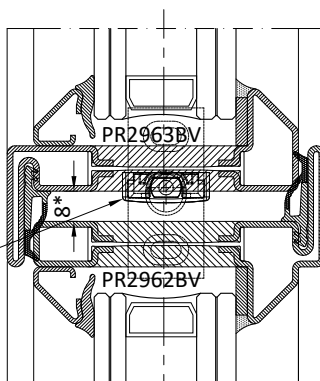


abbassamento di 1,5 mm
1,5 mm reduction





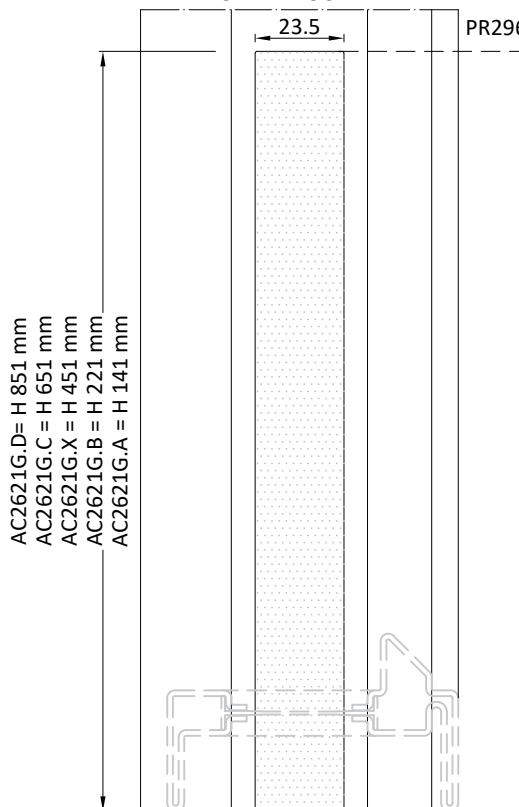
AC2621G.A
AC2621G.B
AC2621G.X
AC2621G.C
AC2621G.D



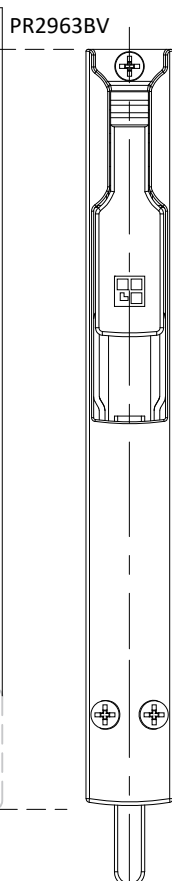
*dimensione anta | sash size <600 mm
fresare 8 mm e prevedere delle piastre di
rinforzo per il fissaggio (non in dotazione);
aumentare l'aria del nodo centrale di 1 mm
mill 8 mm and provide reinforcement plates
for fixing (not supplied); increase the air of
the central section of 1 mm

PORTA - DOOR

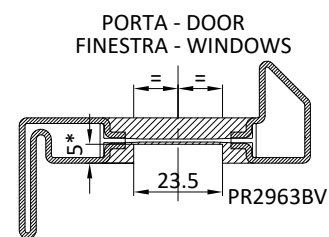
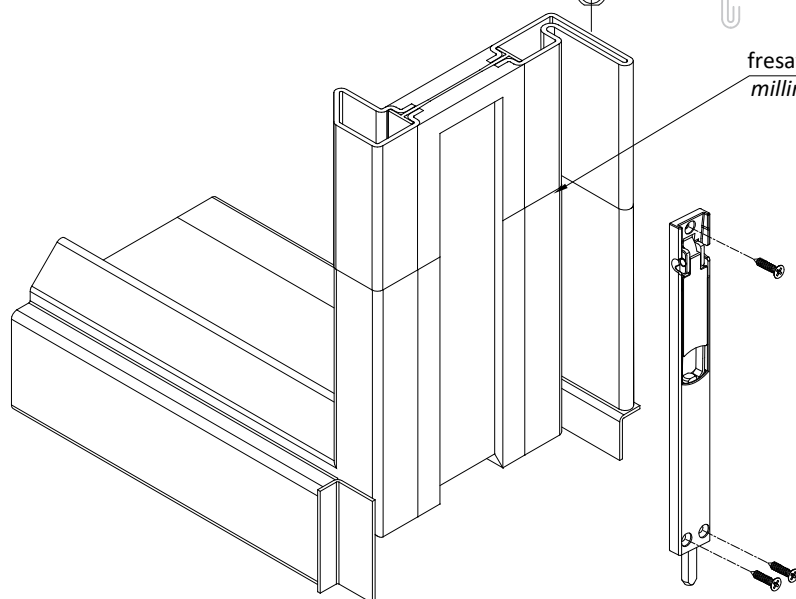
FINESTRA - WINDOWS



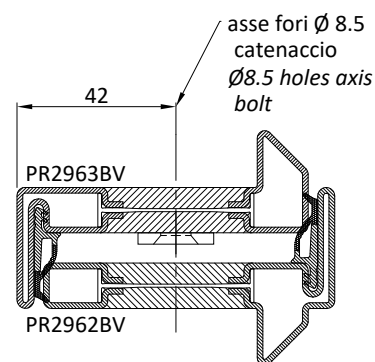
AC2621G.D = H 851 mm
AC2621G.C = H 651 mm
AC2621G.X = H 451 mm
AC2621G.B = H 221 mm
AC2621G.A = H 141 mm



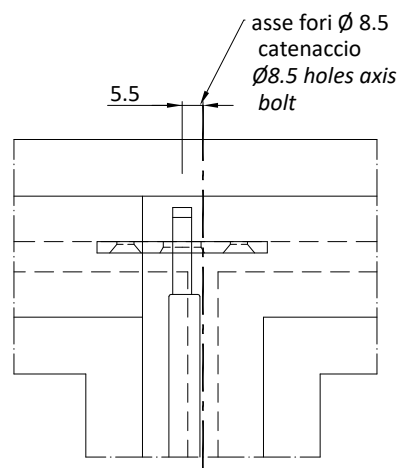
AC2621G.D = H 857 mm
AC2621G.C = H 657 mm
AC2621G.X = H 457 mm
AC2621G.B = H 207 mm
AC2621G.A = H 147 mm

PORTA - DOOR
FINESTRA - WINDOWS

fresata per inserimento catenaccio
milling for bolt installation

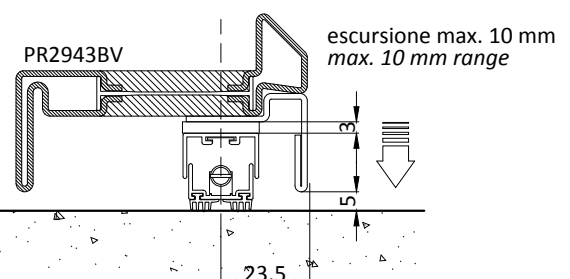
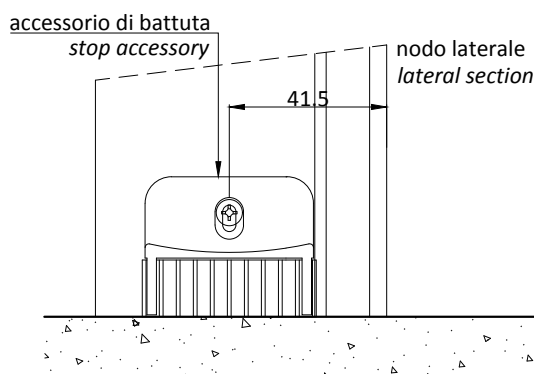
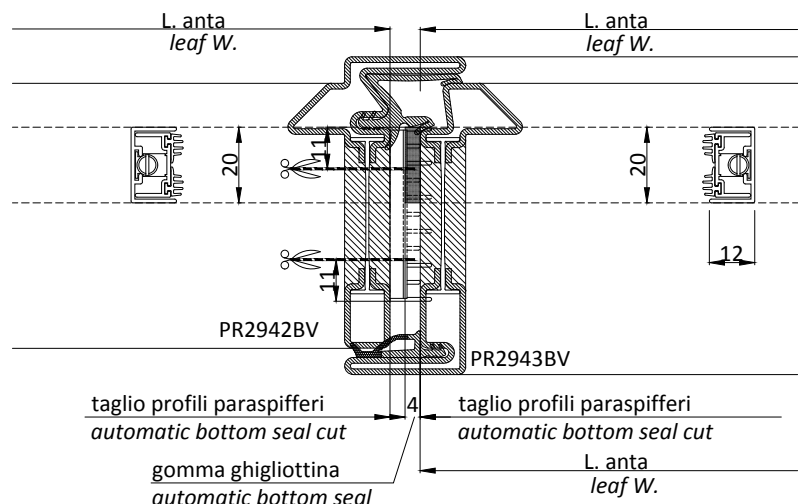
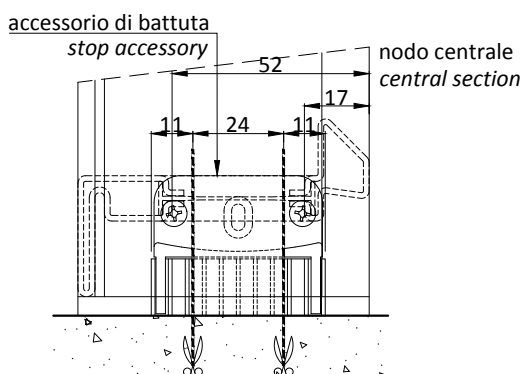
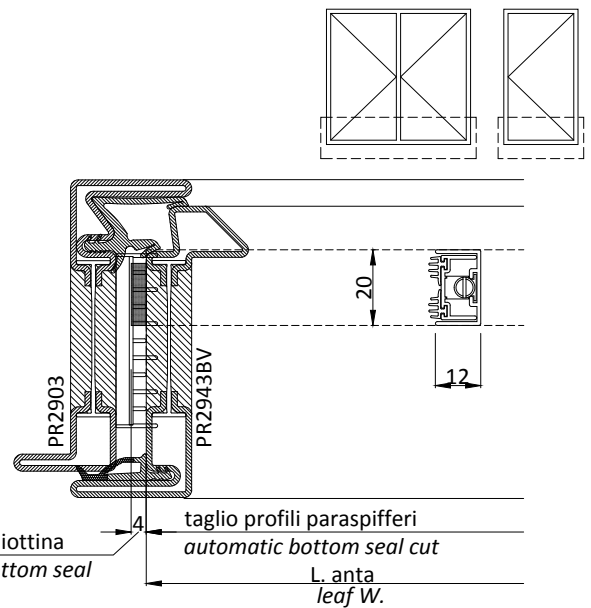
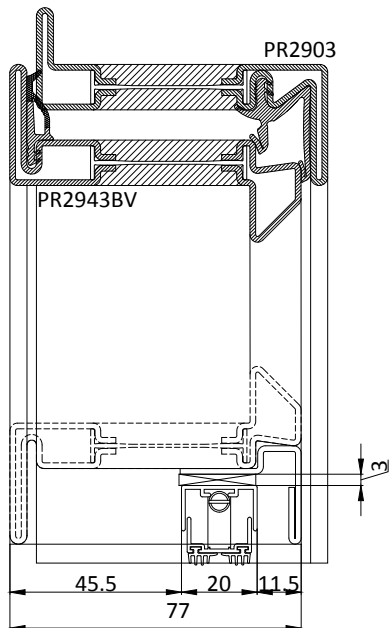


asse fori Ø 8.5
catenaccio
Ø8.5 holes axis
bolt

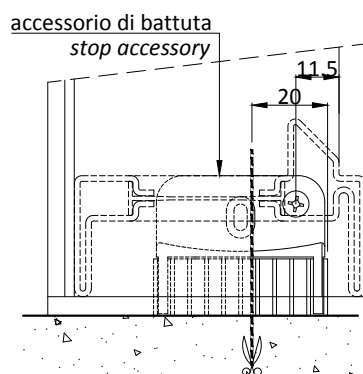
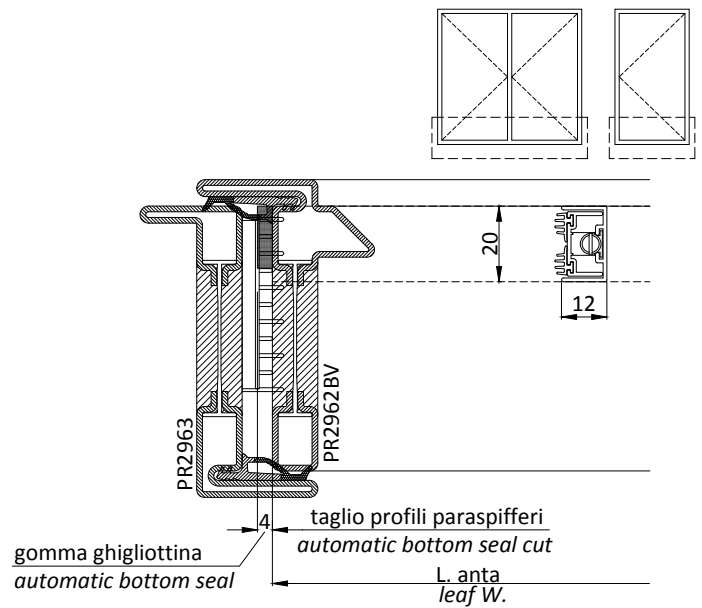
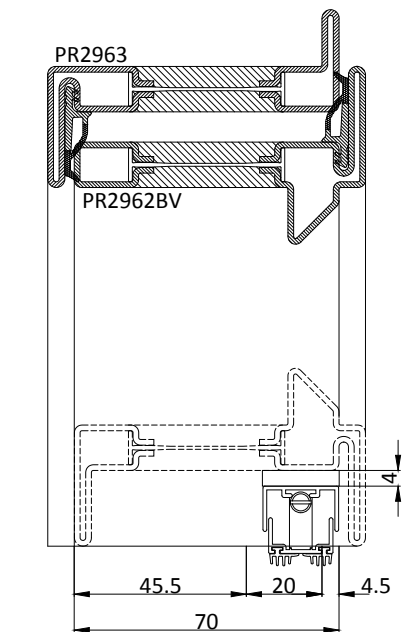


asse fori Ø 8.5
catenaccio
Ø8.5 holes axis
bolt

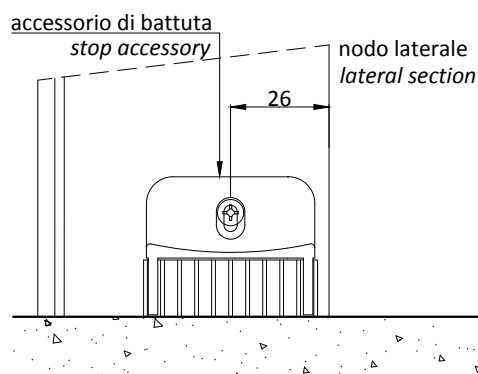
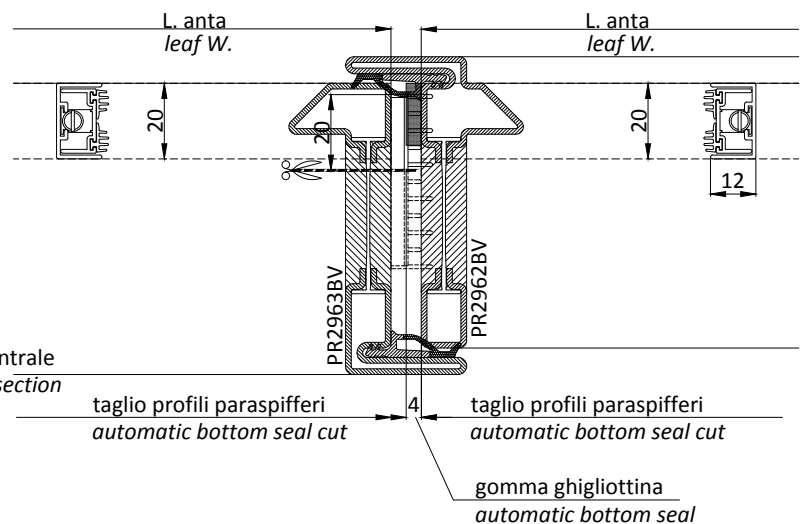
Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2636/Z	280 - 430 mm	299 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	930 - 1030 mm	864 - 1014 mm
AC2636/G	980 - 1130 mm	964 - 1164 mm
AC2636/H	1080 - 1230 mm	1114 - 1314 mm



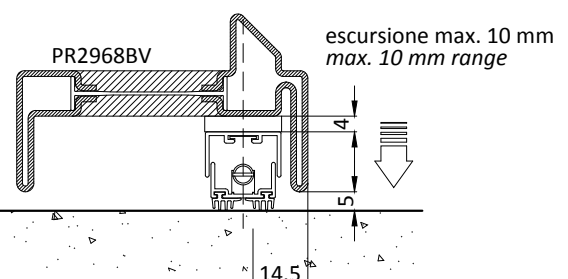
Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2636/Z	280 - 430 mm	299 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	930 - 1030 mm	864 - 1014 mm
AC2636/G	980 - 1130 mm	964 - 1164 mm
AC2636/H	1080 - 1230 mm	1114 - 1314 mm

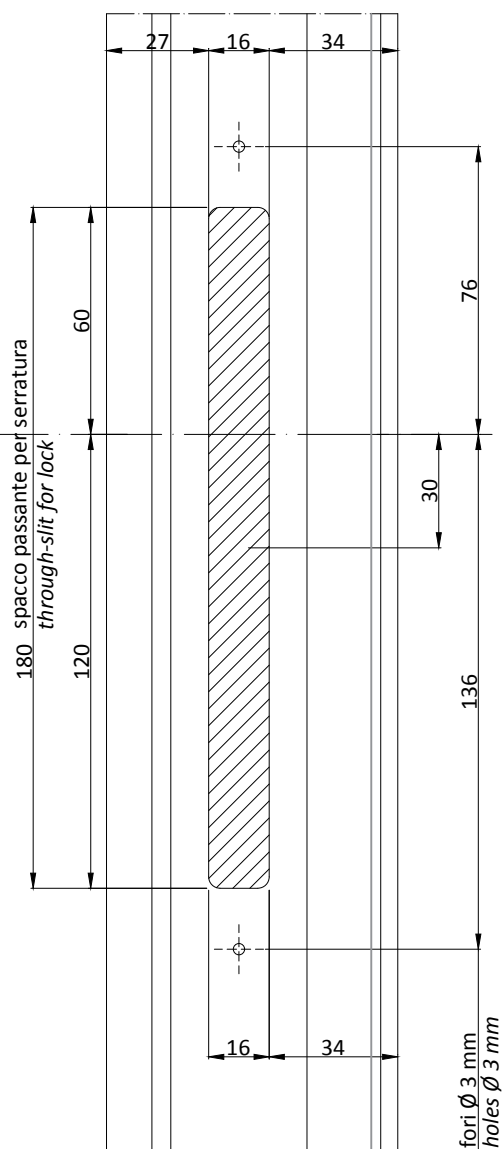
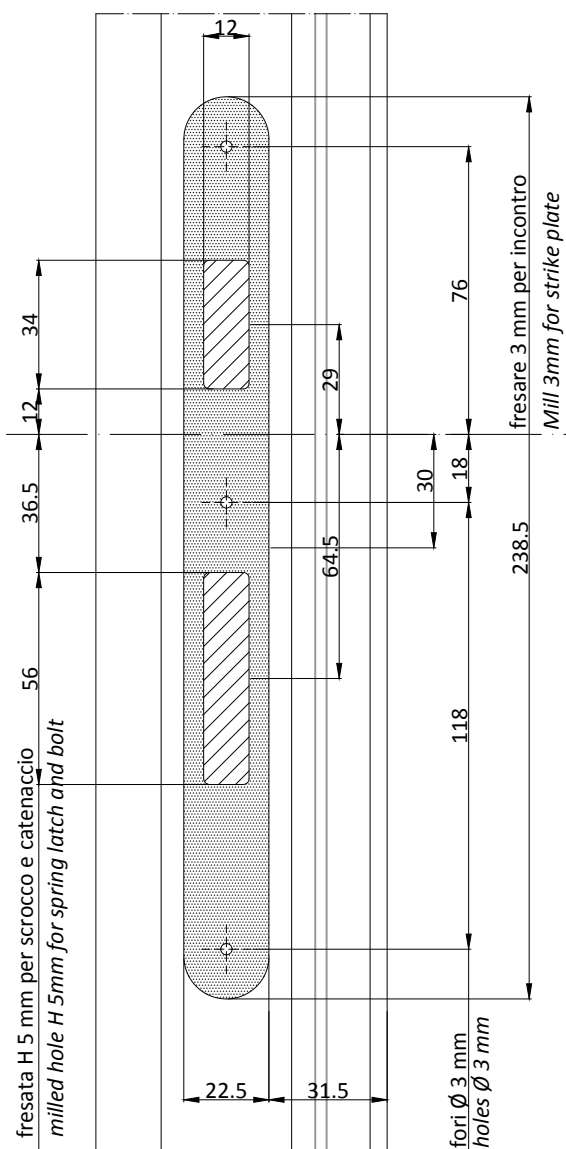
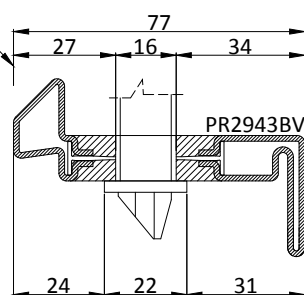
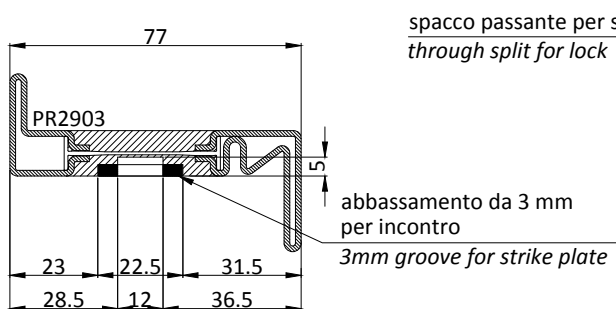
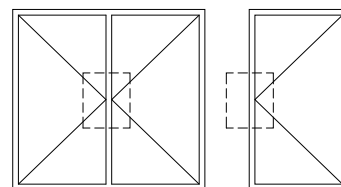
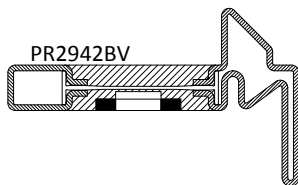


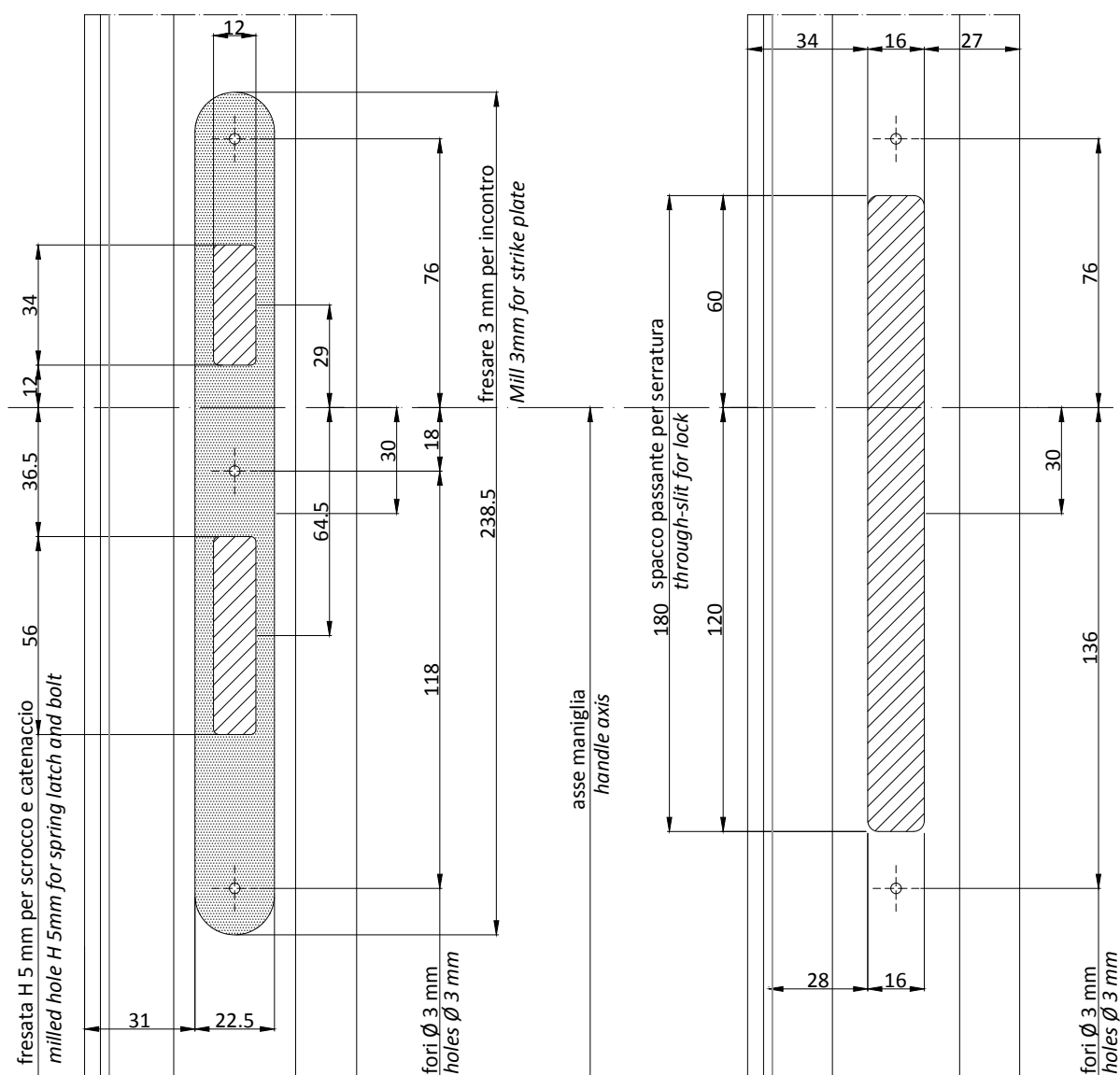
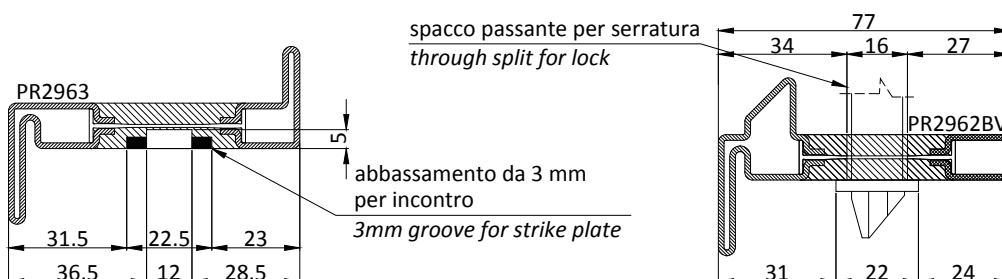
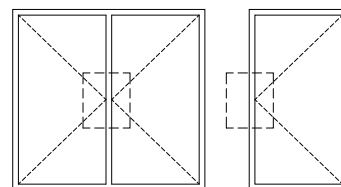
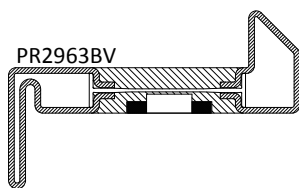
nodo centrale
central section

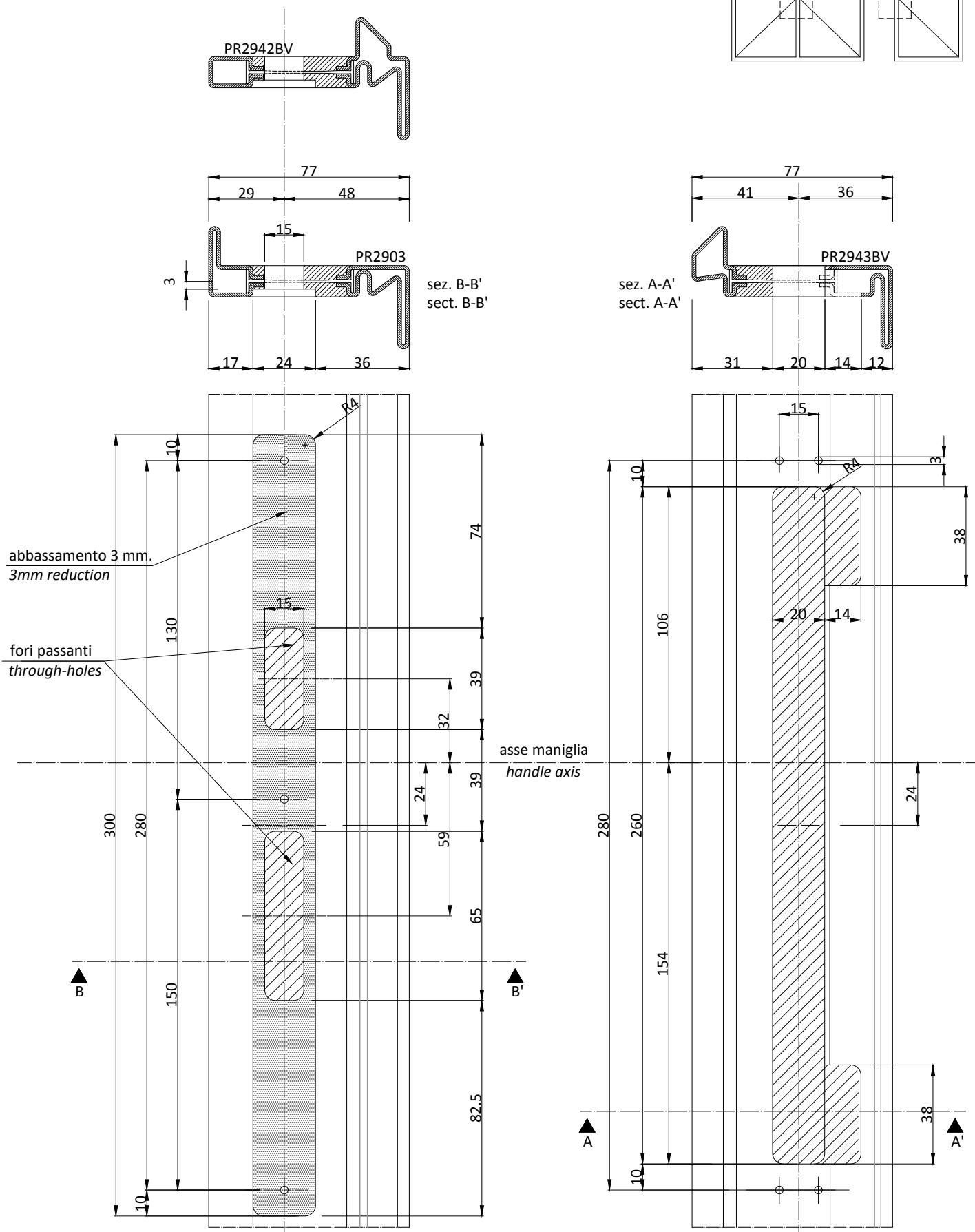


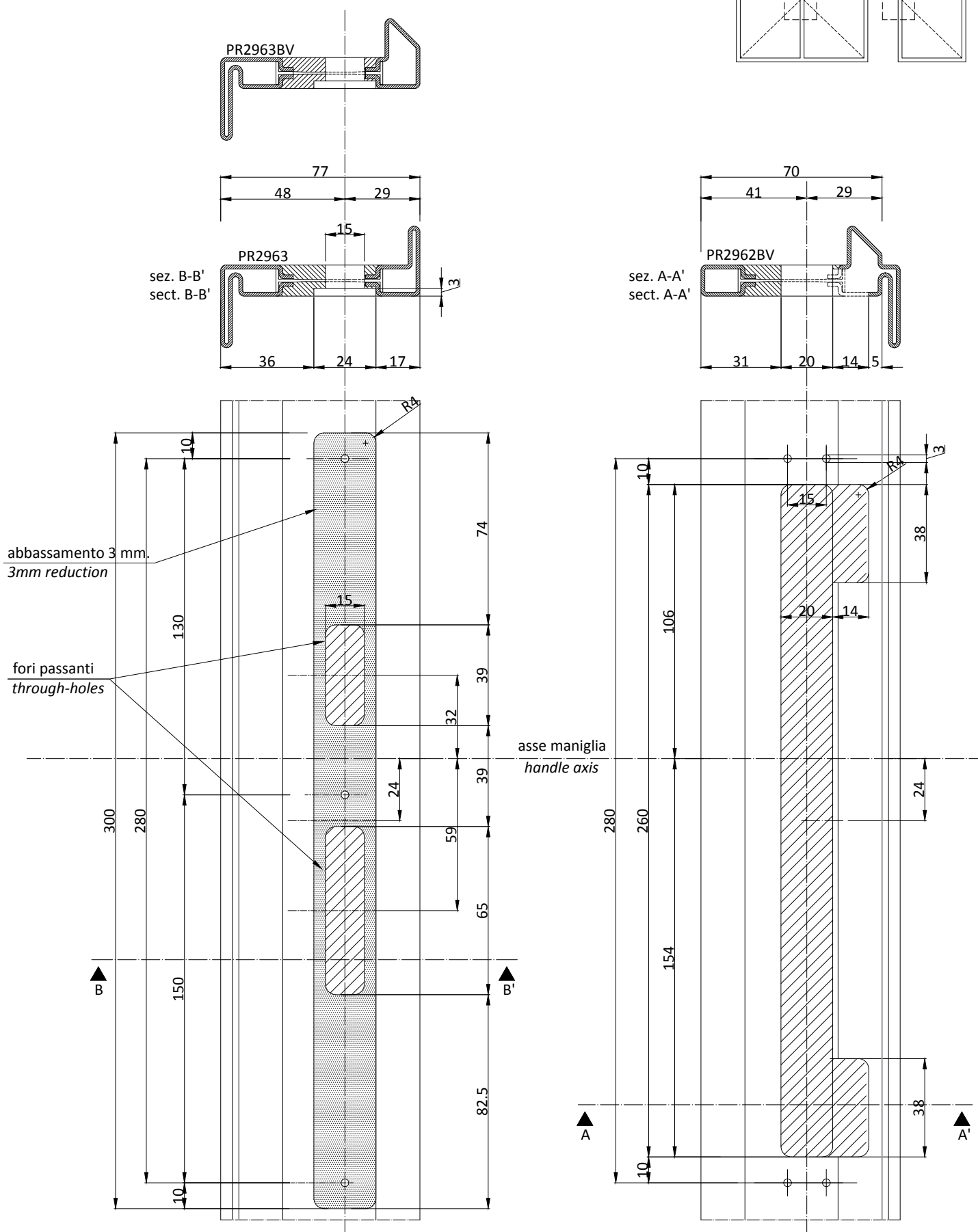
nodo laterale
lateral section





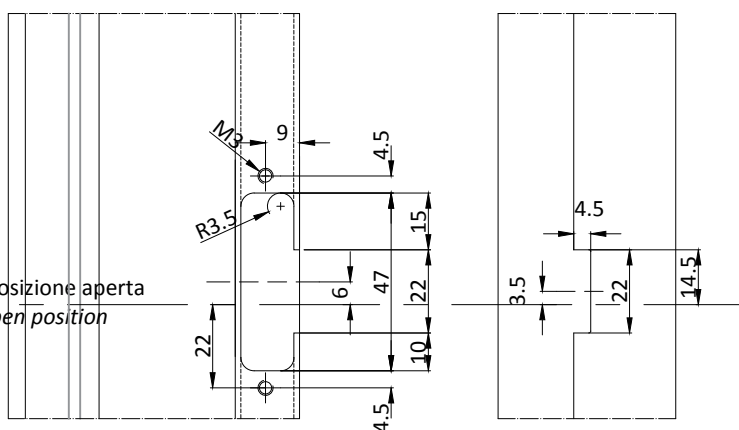




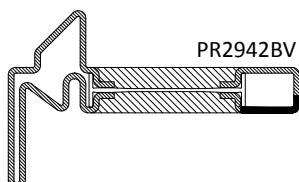
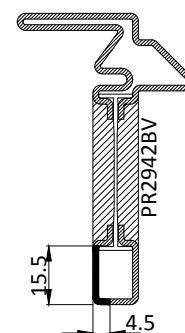
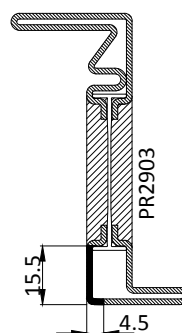
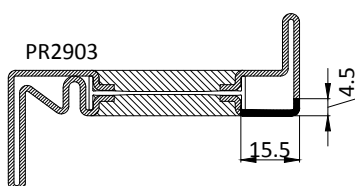


lavorazione applicazione incontro
Processing strike plate installation

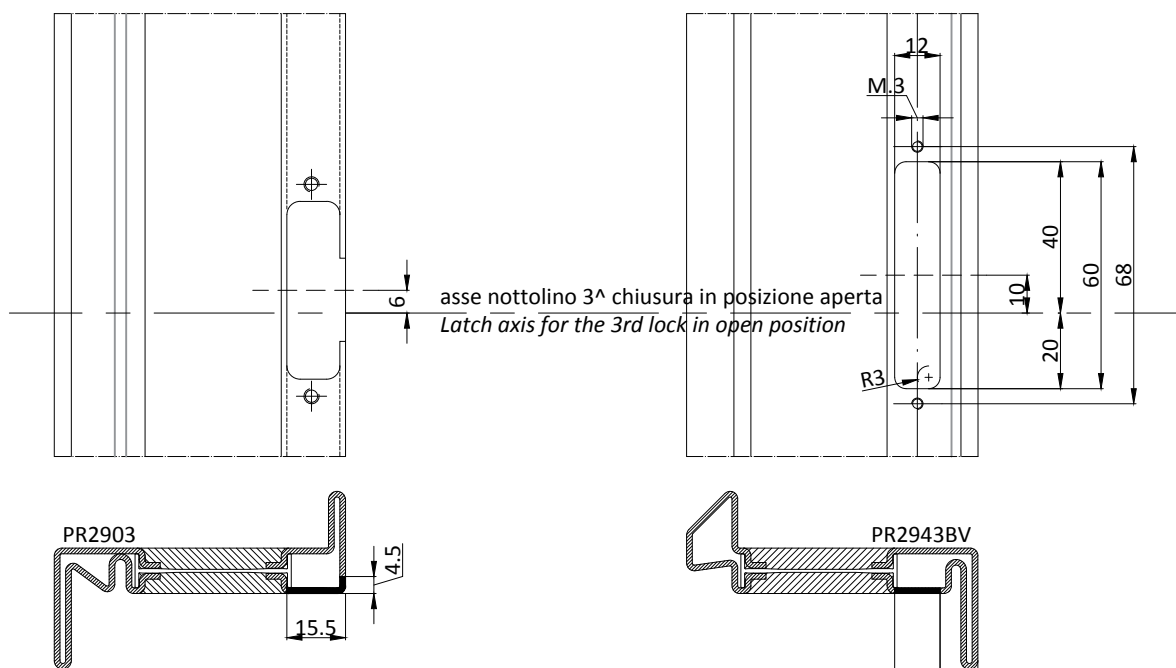
asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



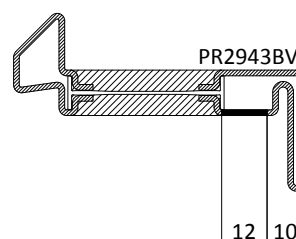
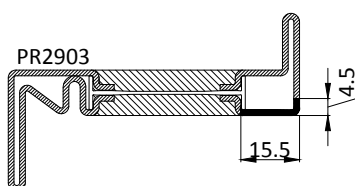
Incontro 3^a chiusura
3rd lock strike plate



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



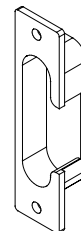
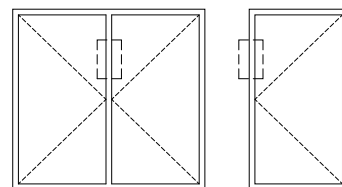
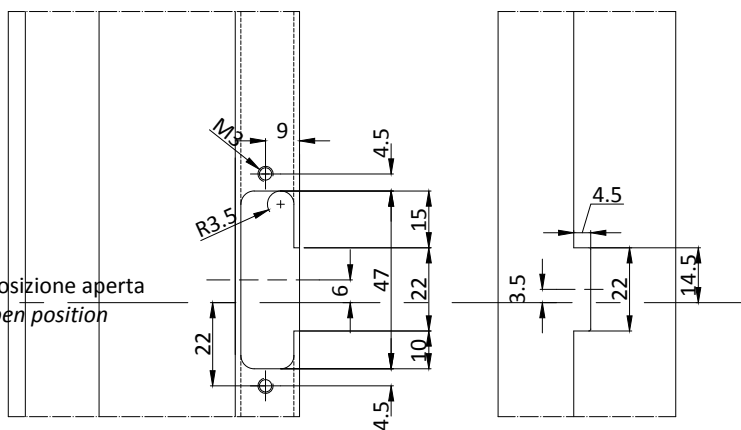
asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



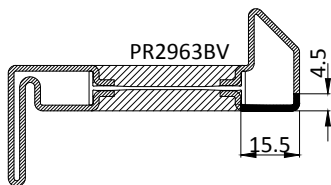
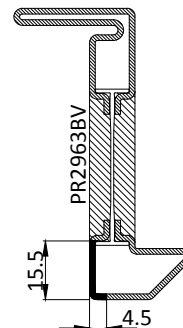
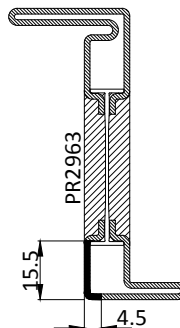
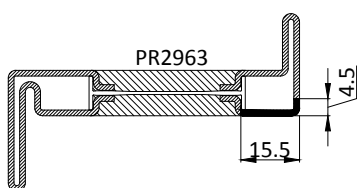
lavorazione superiore-inferiore specchiata orizzontalmente
upper working-bottom working horizontally mirrored

lavorazione applicazione incontro
Processing strike plate installation

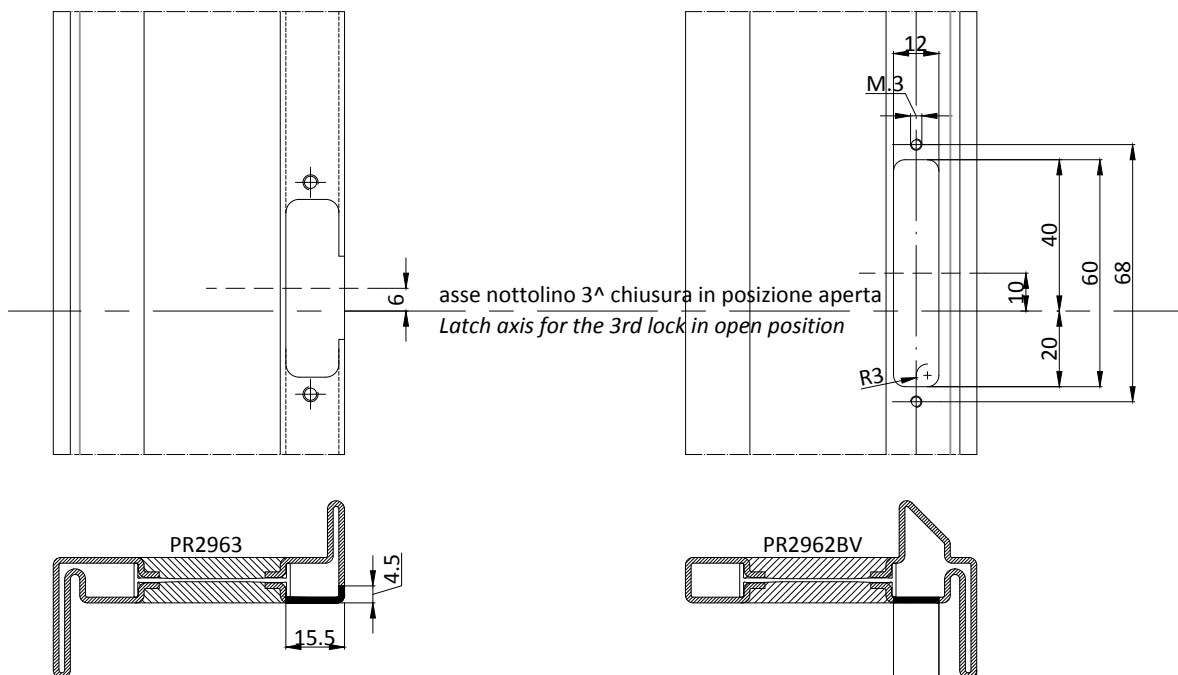
asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



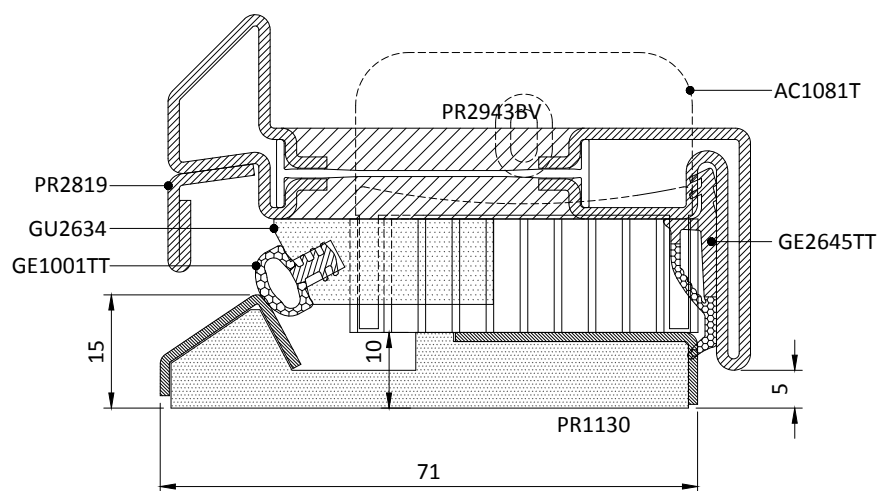
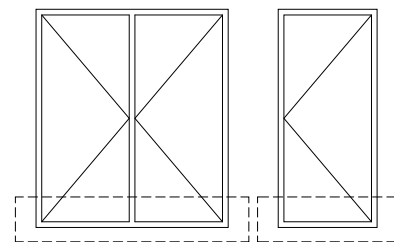
Incontro 3^a chiusura
3rd lock strike plate

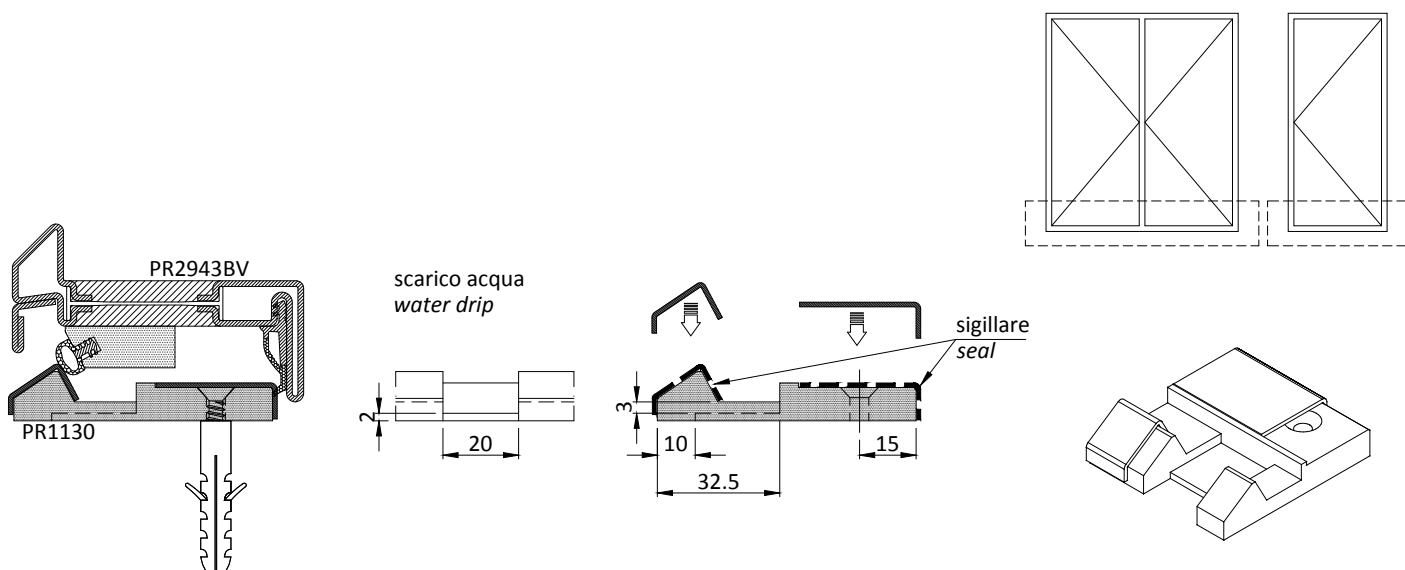


lavorazione applicazione nottolino
Processing for the assembling of the 3rd lock

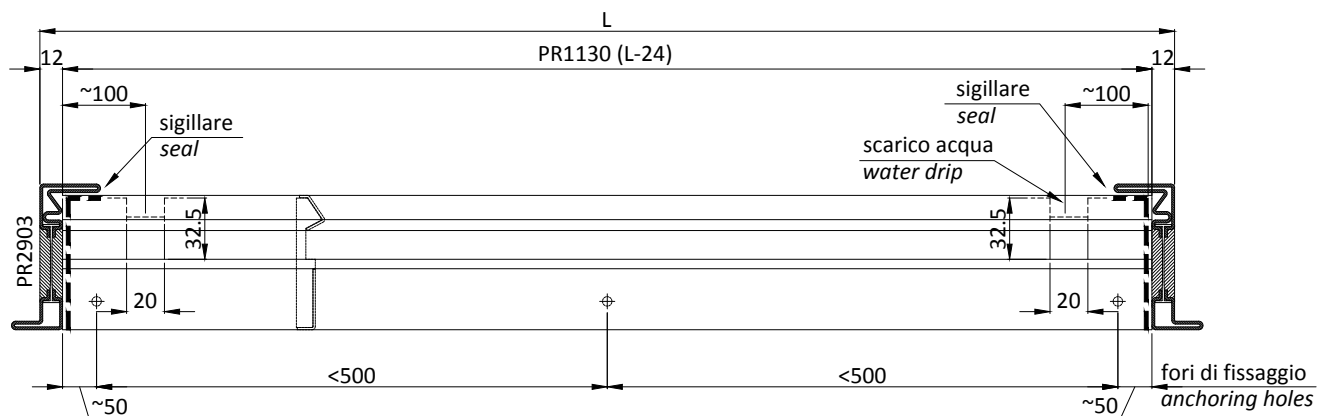


lavorazione superiore; inferiore specchiata orizzontalmente
Upper working; bottom working horizontally mirrored

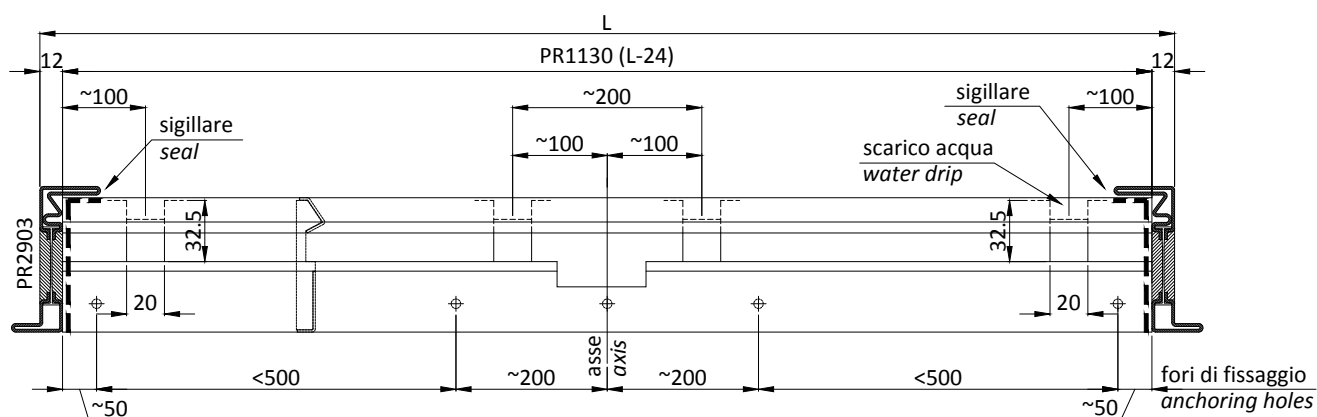


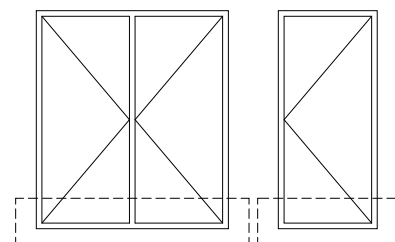
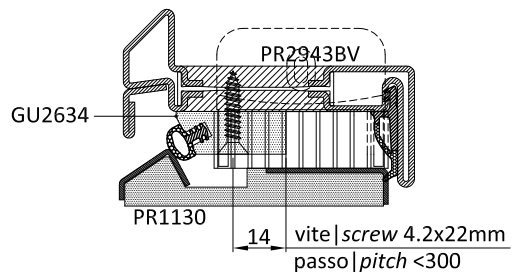


Lavorazione per porta ad 1 anta | Processing for single leaf door

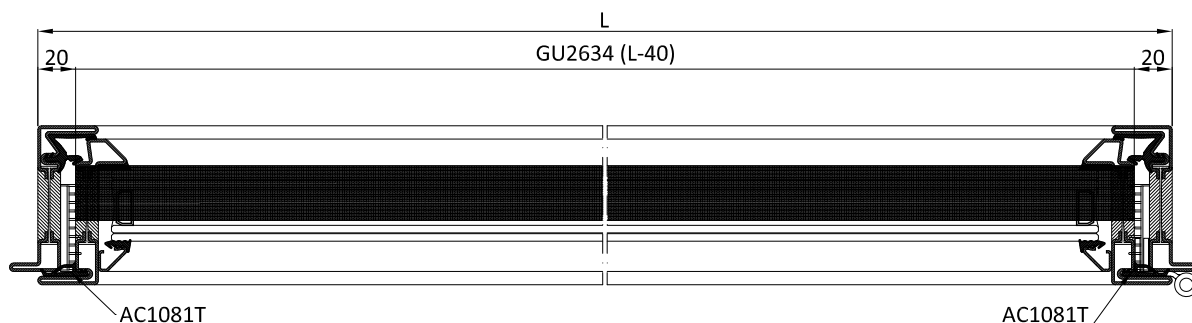


Lavorazione per porta a 2 ante | Processing for double leaf door

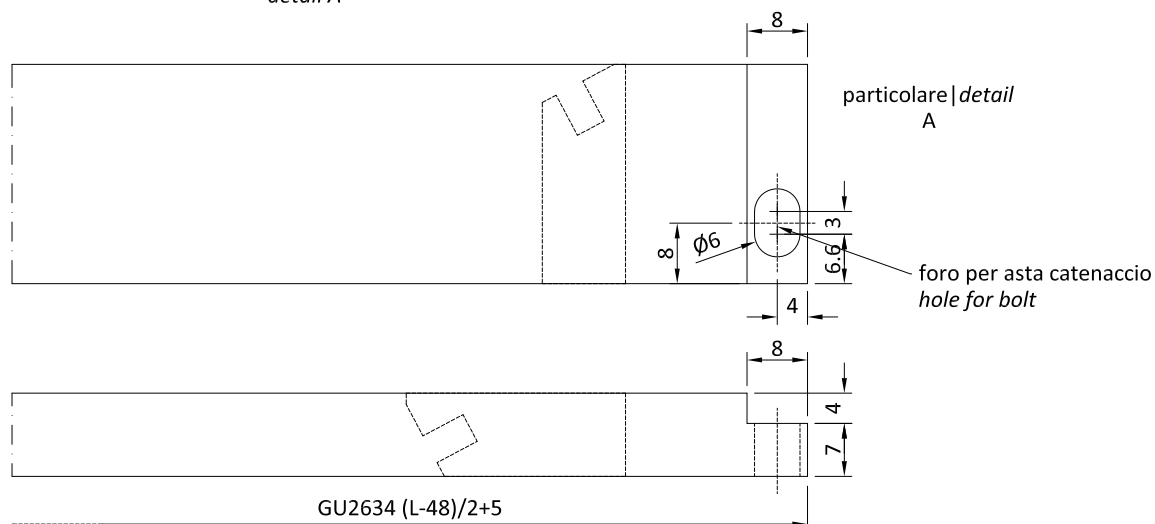
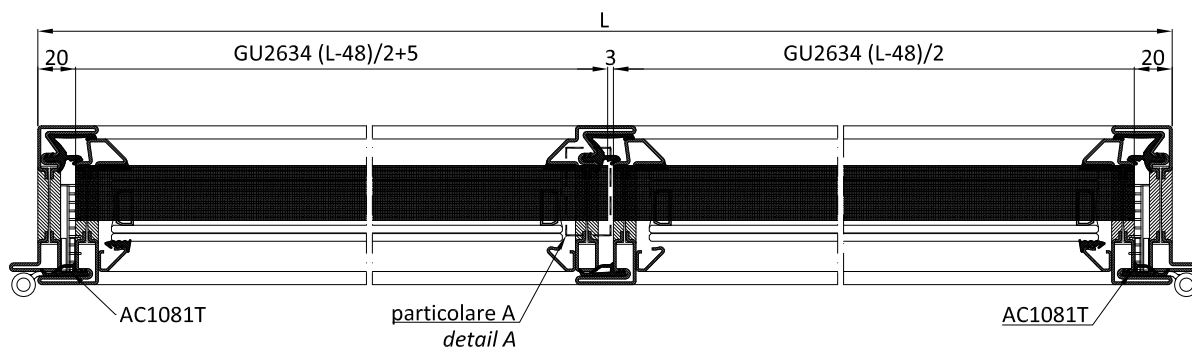


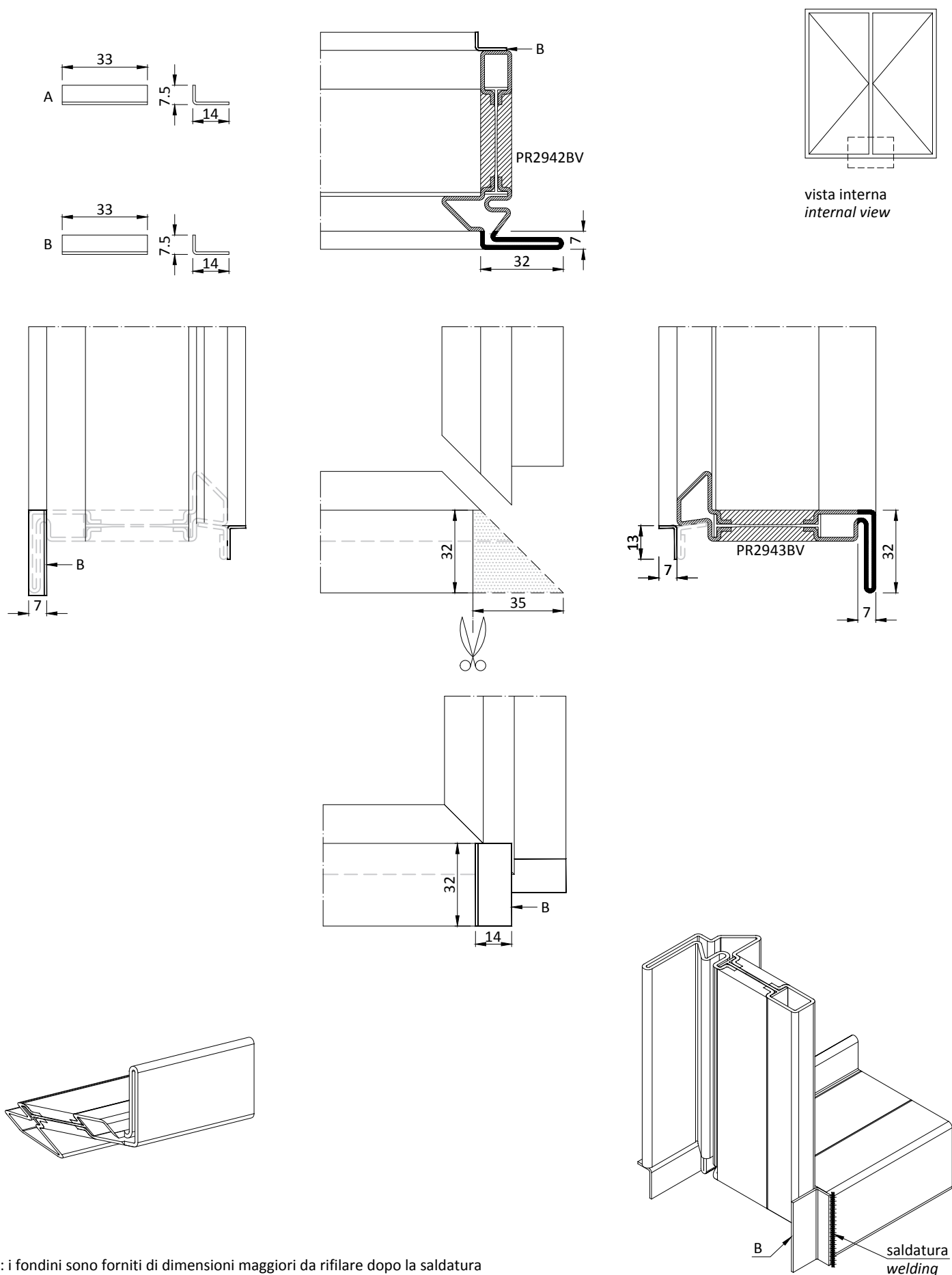


Lavorazione per porta ad 1 anta | Processing for single leaf door

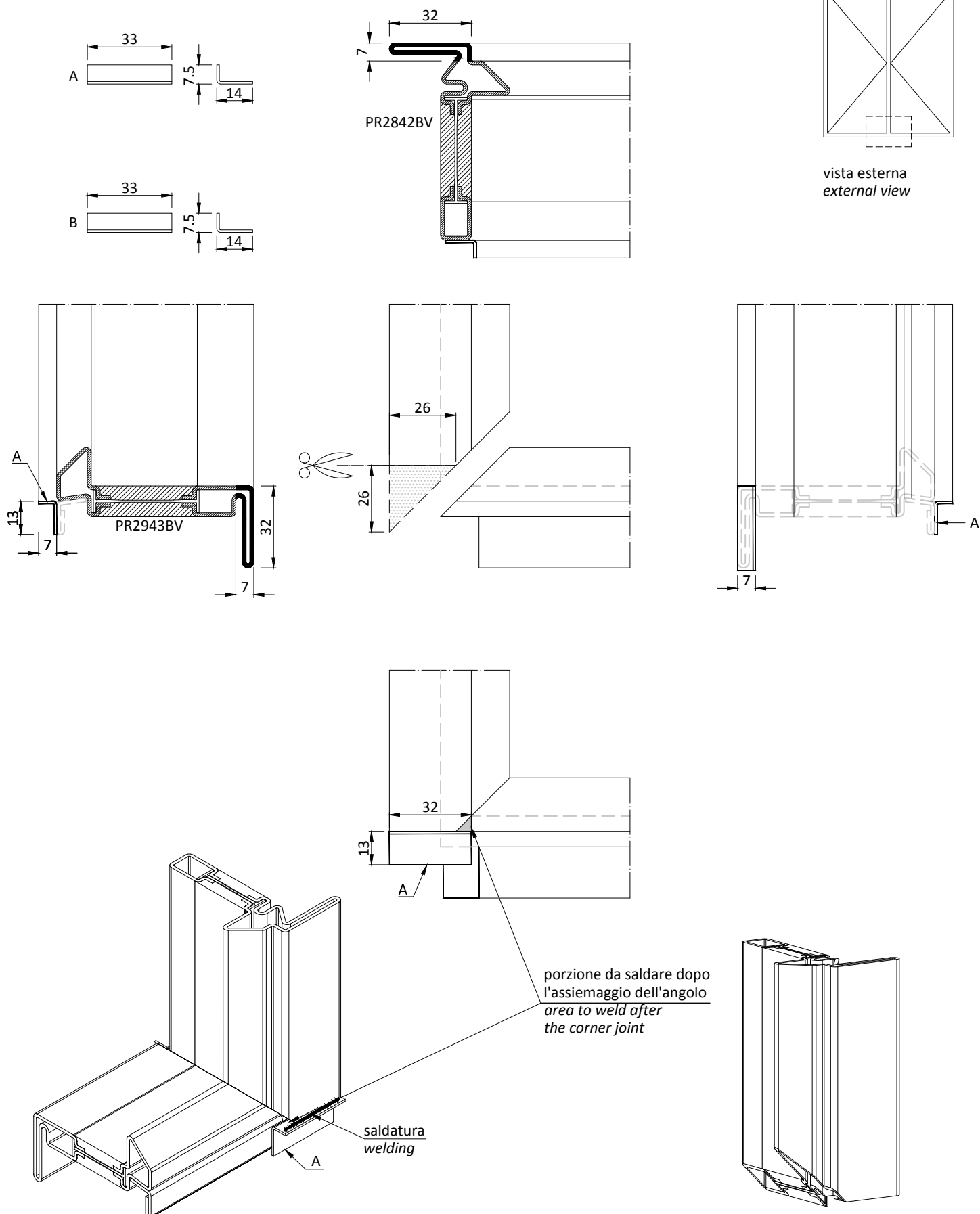


Lavorazione per porta a 2 ante | Processing for double leaf door

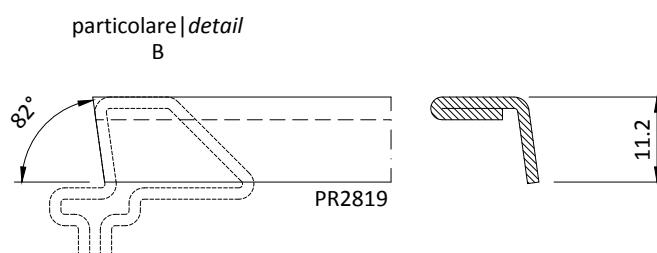
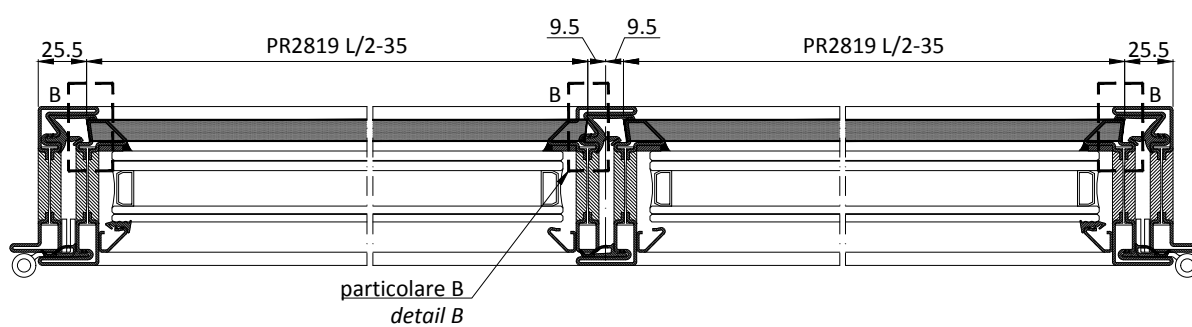
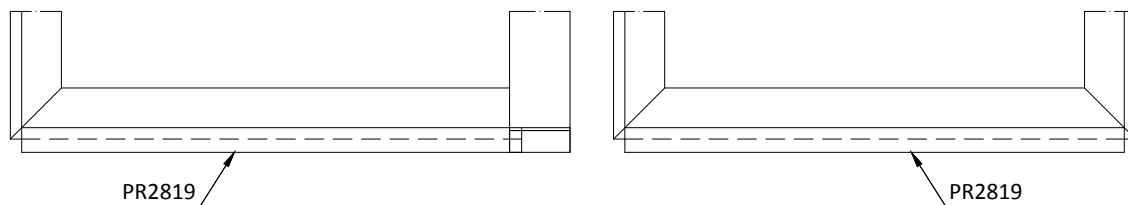
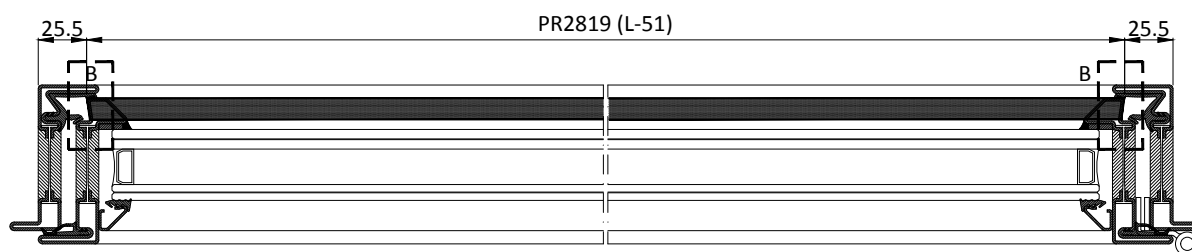
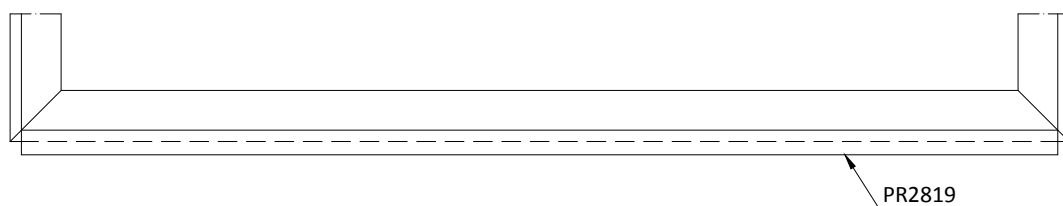
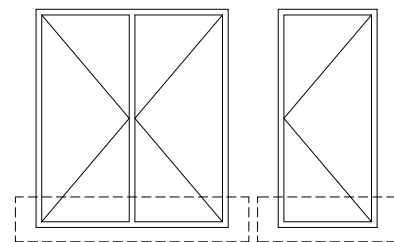
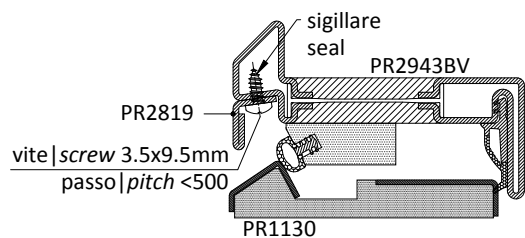


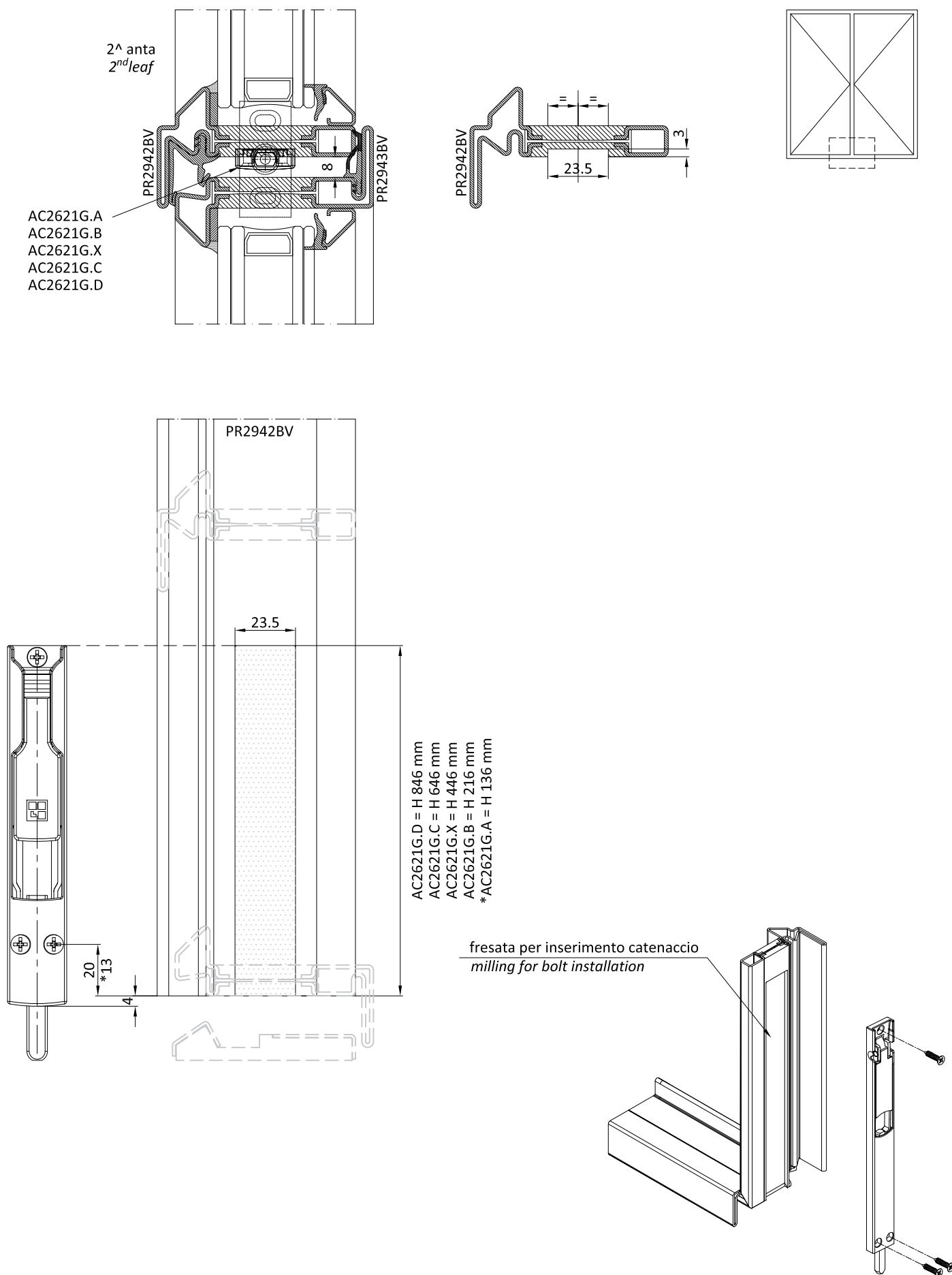


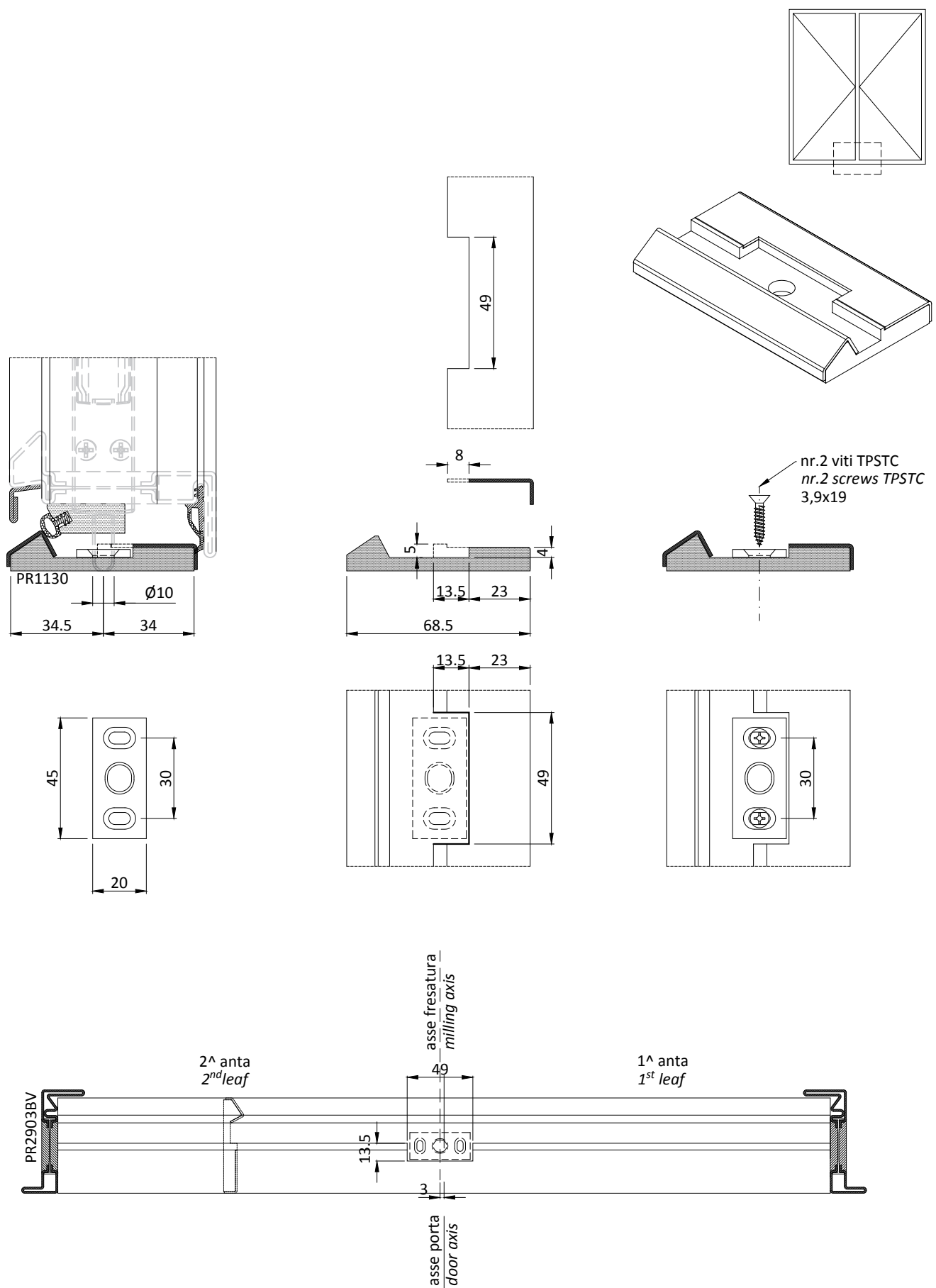
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding

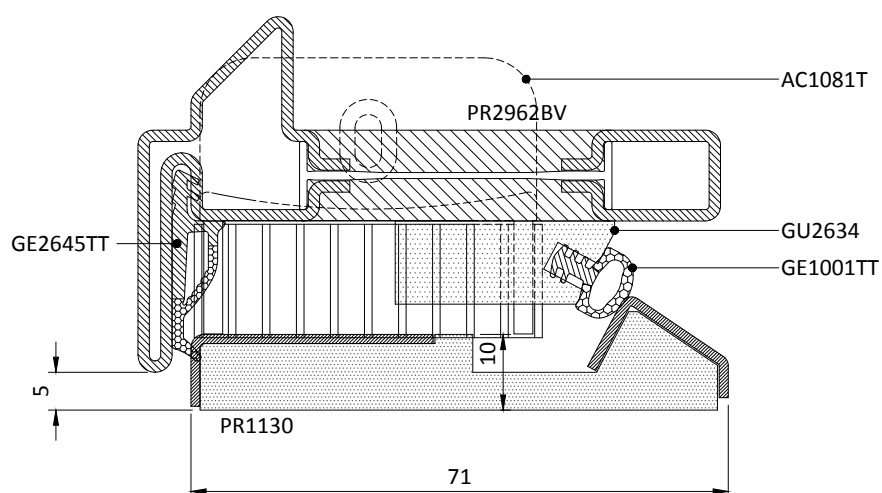
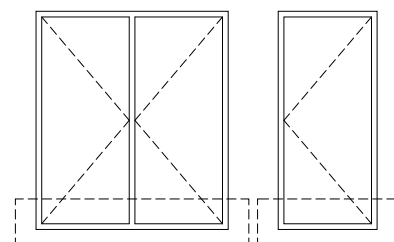


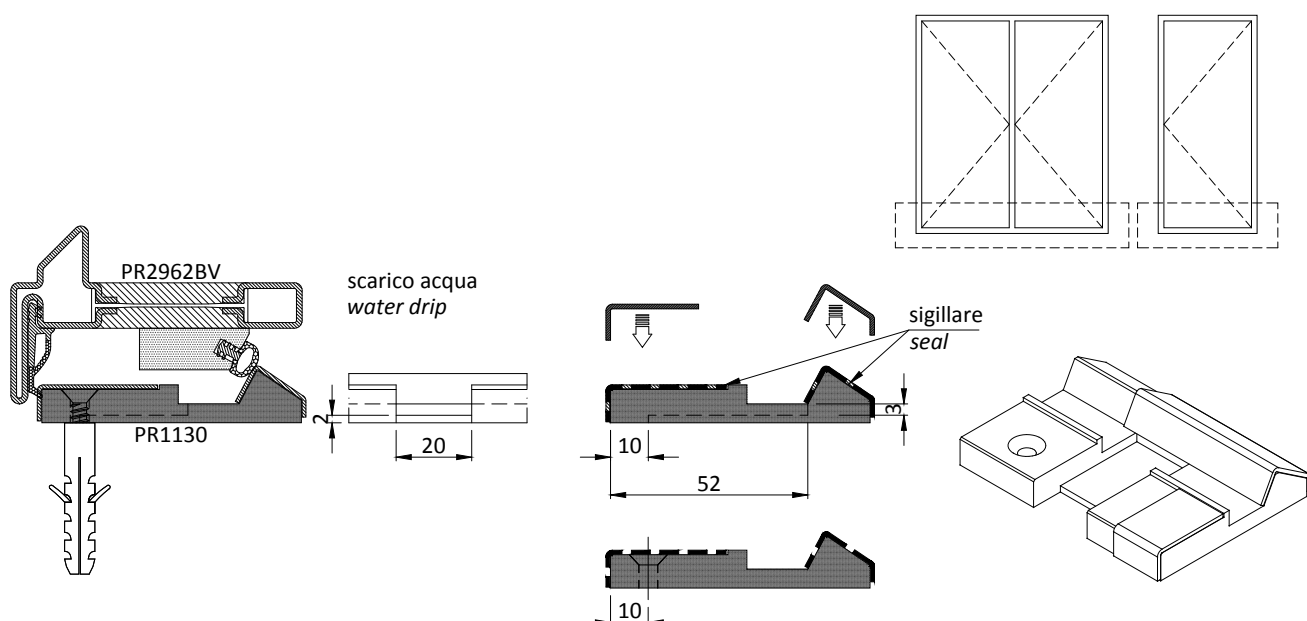
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



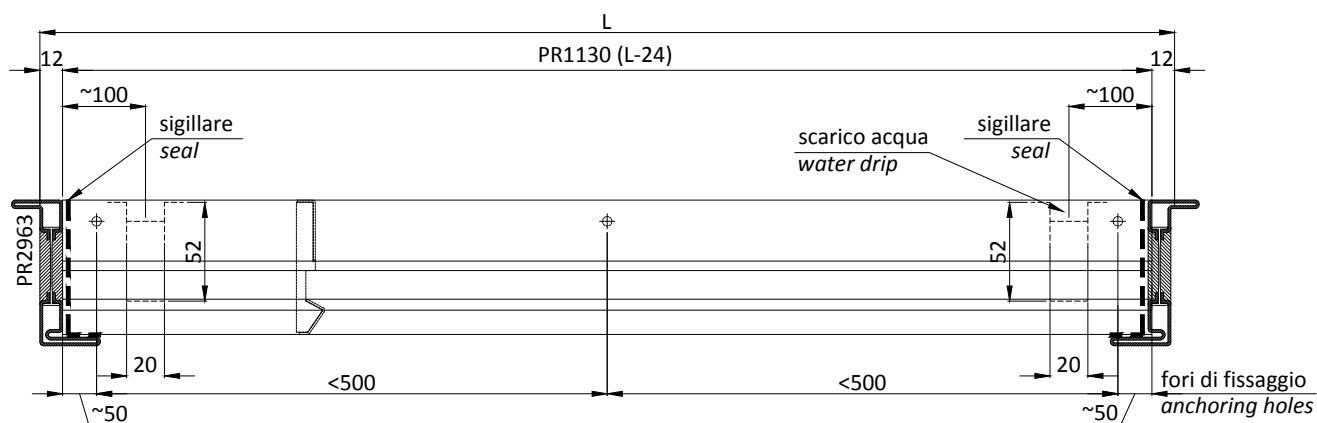




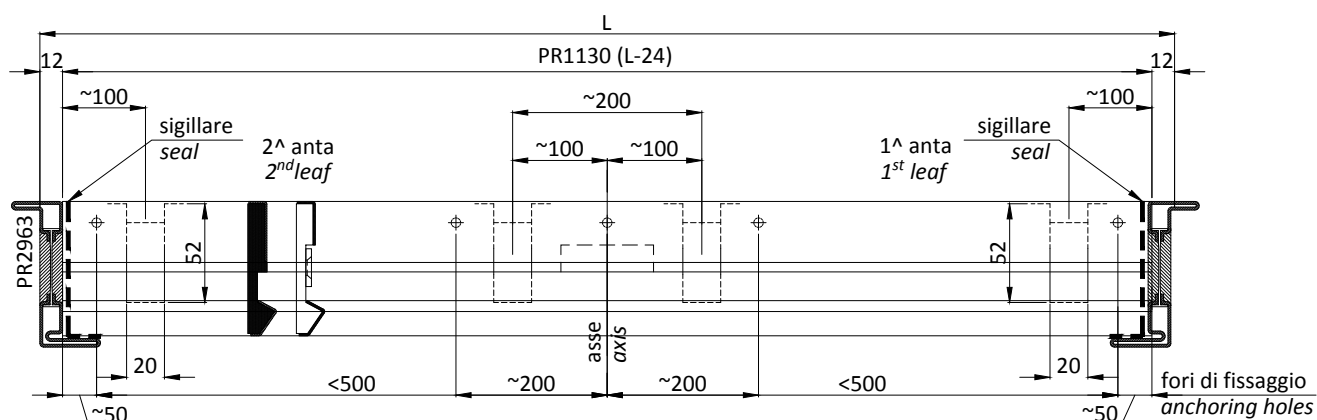


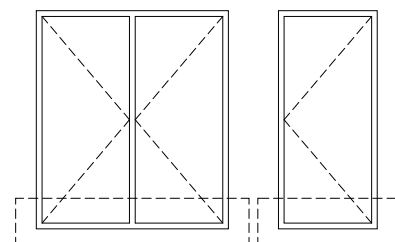
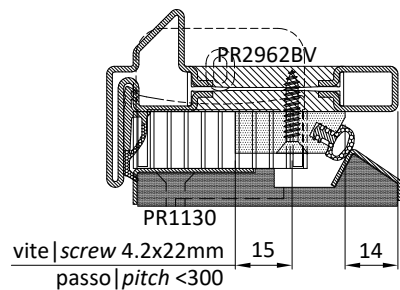


Lavorazione per porta ad 1 anta | Processing for single leaf door

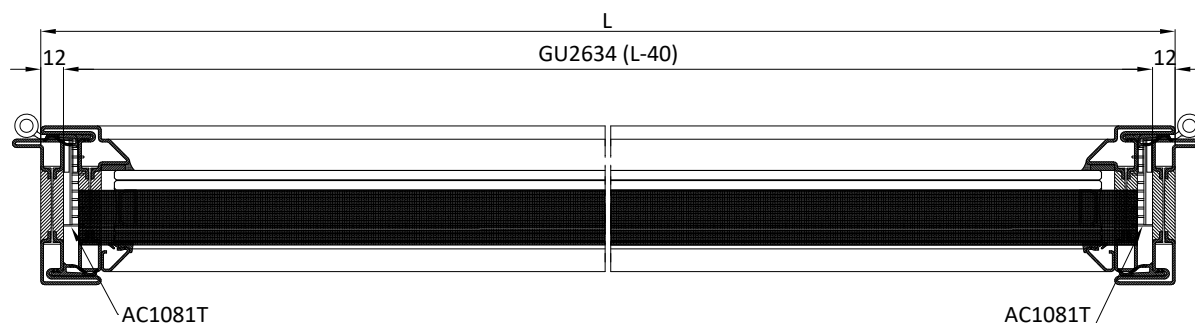


Lavorazione per porta a 2 ante | Processing for double leaf door

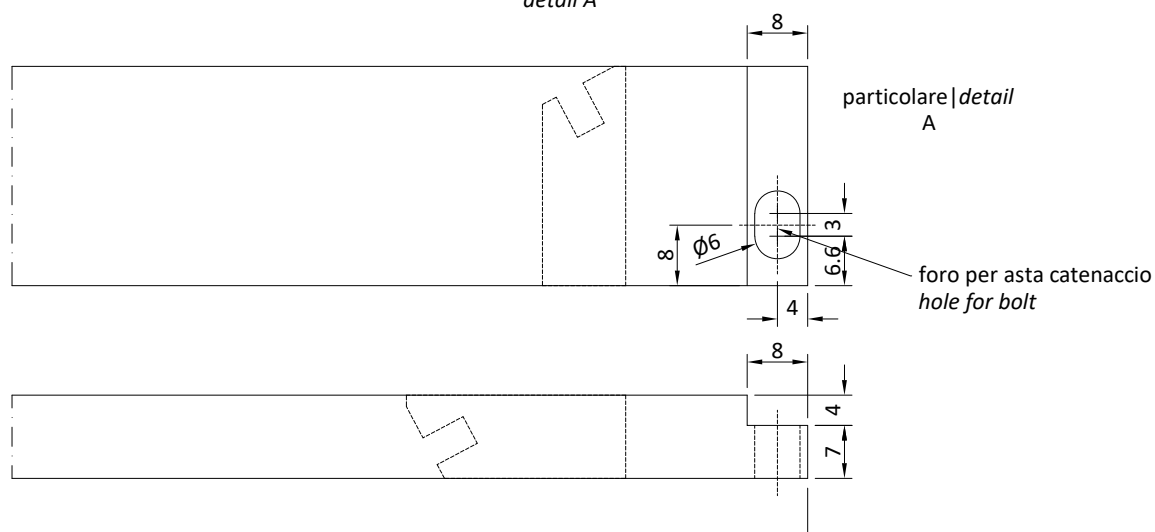
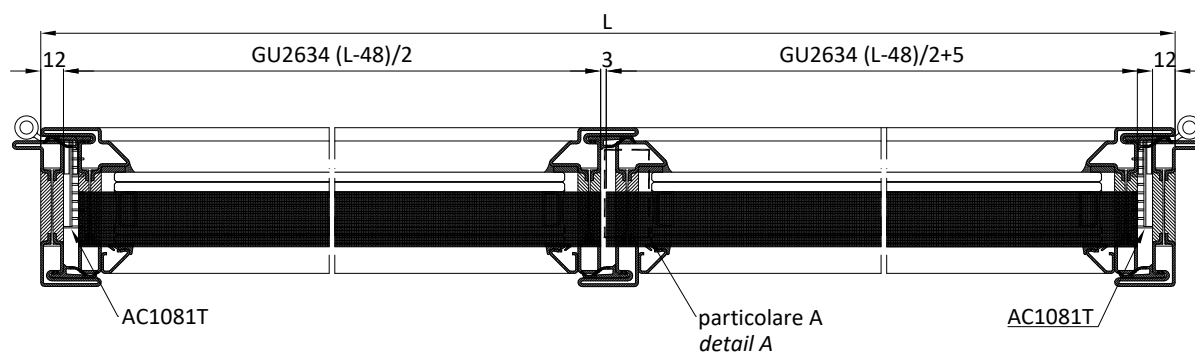


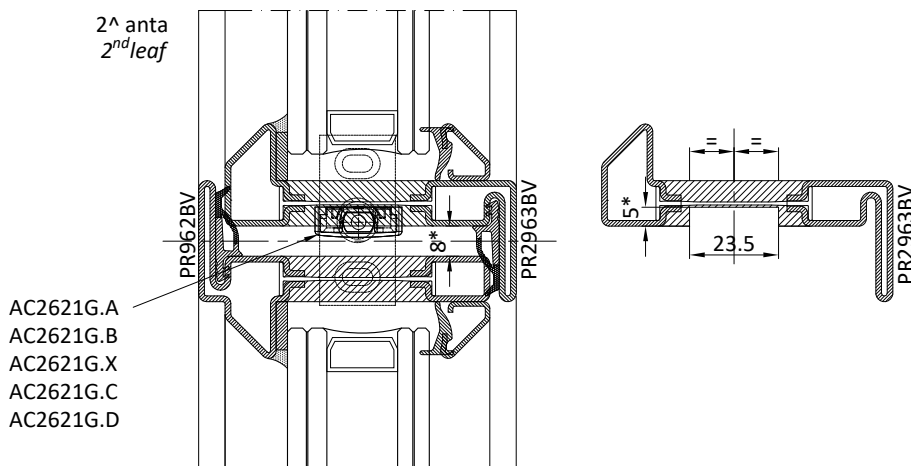


Lavorazione per porta ad 1 anta | Processing for single leaf door

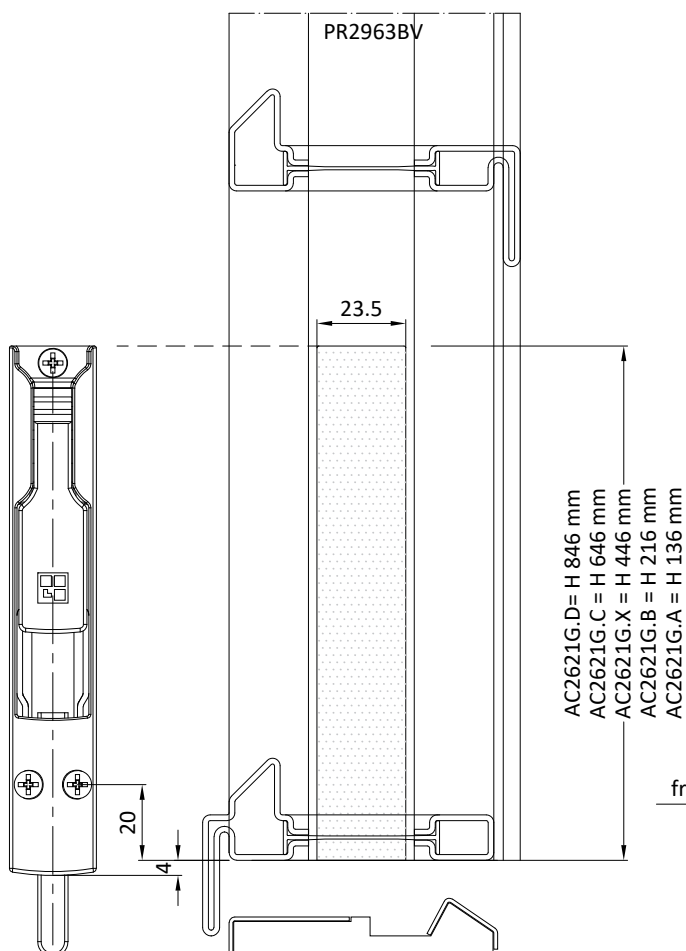


Lavorazione per porta a 2 ante | Processing for double leaf door

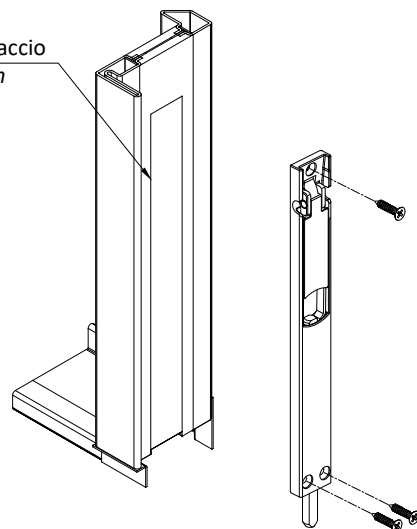


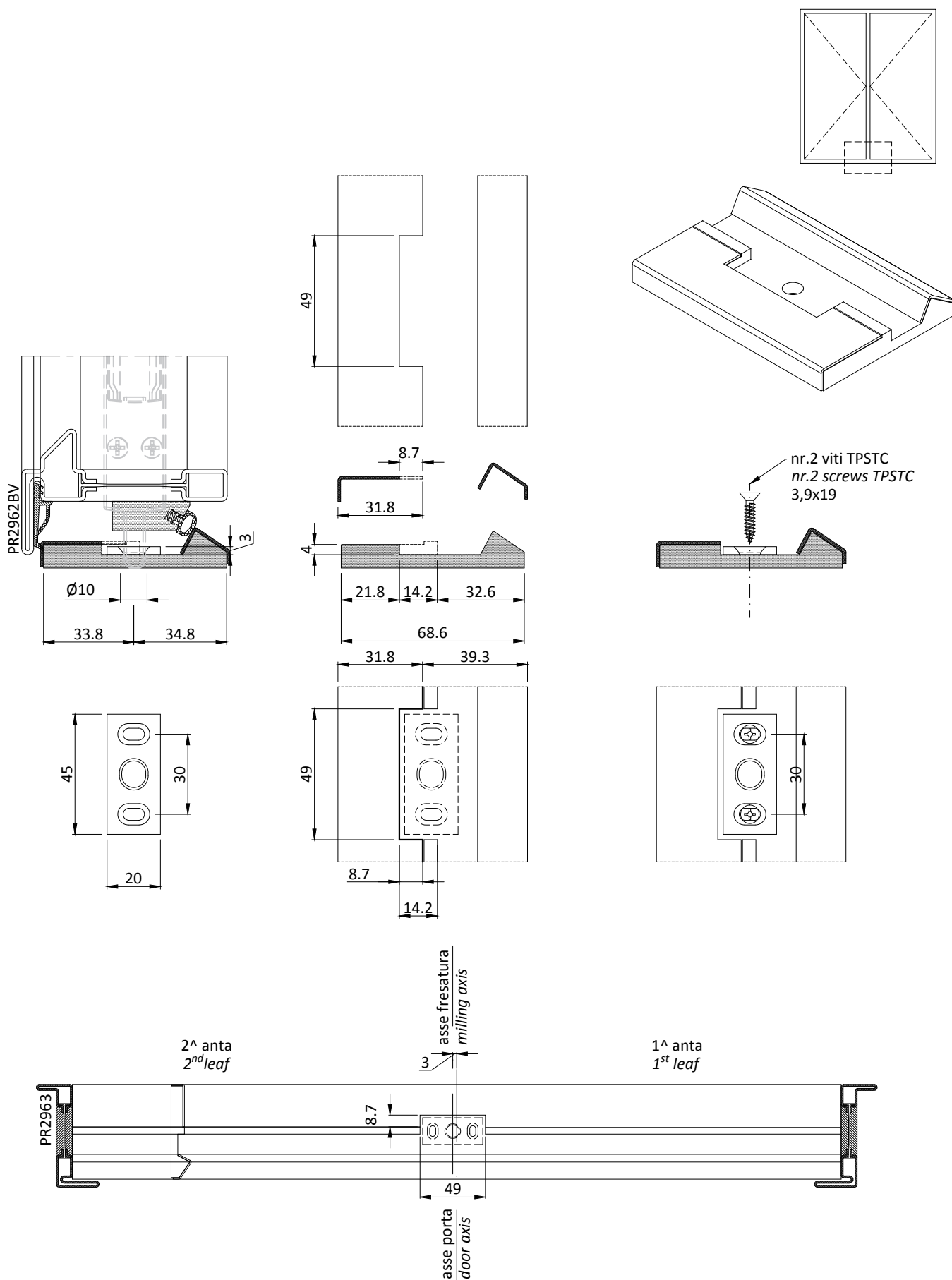


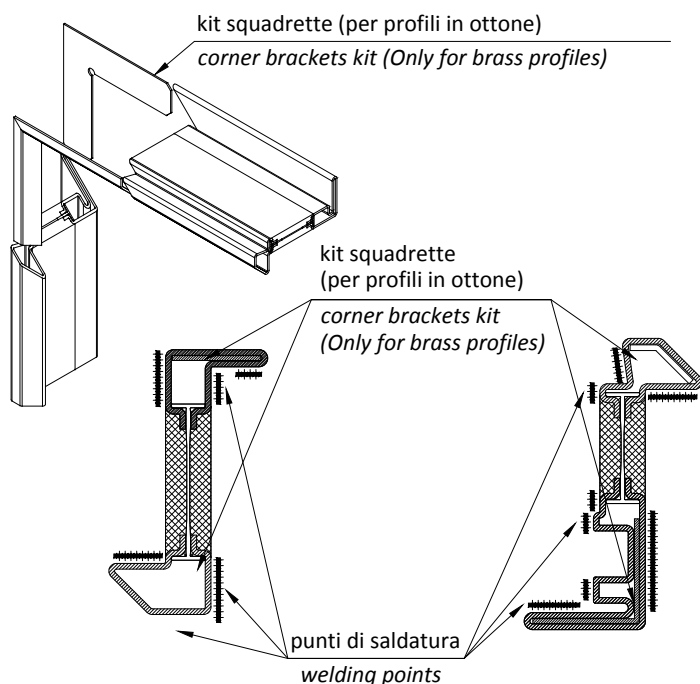
*dimensione anta | sash size <600 mm
fresare 8 mm e prevedere delle piastre di
rinforzo per il fissaggio (non in dotazione);
aumentare l'aria del nodo centrale di 1 mm
mill 8 mm and provide reinforcement plates
for fixing (not supplied); increase the air of
the central section of 1 mm



fresata per inserimento catenaccio
milling for bolt installation





**Ottone**

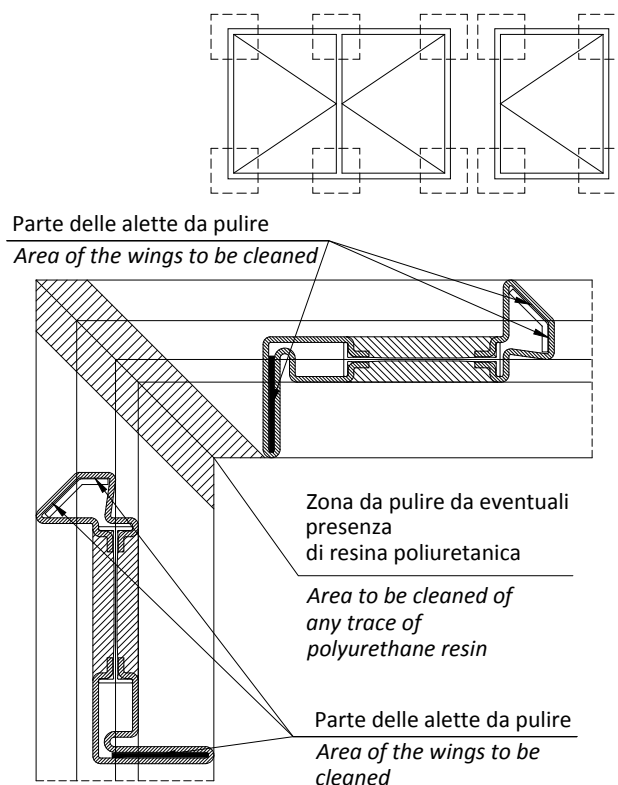
Utilizzare le squadrette di allineamento, sigillare tutte le superfici di contatto tra i profili che non vanno saldate. Saldare a TIG a punti le zone indicate.

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.



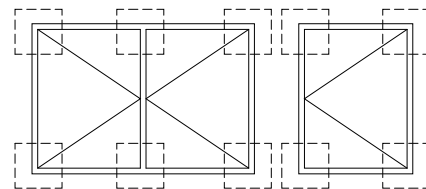
N.B. Prima di saldare l'angolo del profilo eliminare l'eventuale resina poliuretanica presente all'interno dell'aletta scaldando leggermente il profilo stesso per circa 20 mm. in modo da sciogliere la resina ed eliminare le impurità presenti.

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 remove in this way all other impurities.

Profilo Profile	Kit squadrette Corner brackets set
Codice Code	Codice Code
PR2901-PR2901	AC 2801I
PR2903-PR2903	AC 2803I
PR2905-PR2905	AC 2805I
PR2901-PR2905	AC 2801I
PR2901-PR2922	AC 2801I
PR2903-PR2905	AC 2803I
PR2903-PR2922	AC 2801I
PR2905-PR2922	AC 2822I
PR2915-PR2915	AC 2803I
PR2922-PR2922	AC 2822I
PR2942-PR2942	AC 2801I
PR2942-PR2943	AC 2832I
PR2901-PR2942	AC 2801I
PR2903-PR2942	AC 2801I
PR2905-PR2942	AC 2801I
PR2915-PR2942	AC 2801I

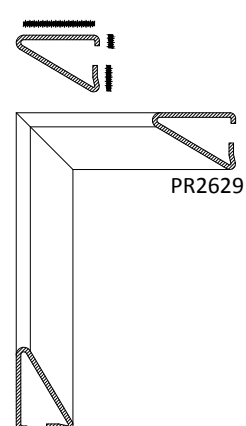
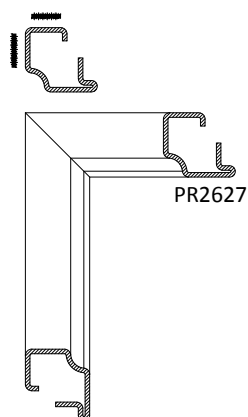
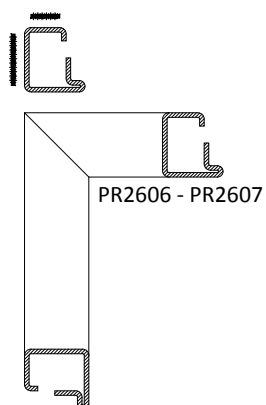
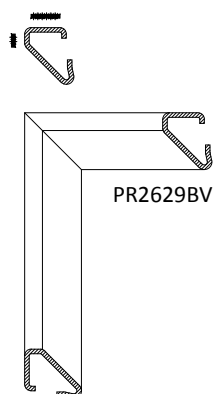
Profilo Profile	Kit squadrette Corner brackets set
Codice Code	Codice Code
PR2961-PR2961	AC 2801I
PR2962-PR2962	AC 2862I
PR2963-PR2963	AC 2803I
PR2965-PR2965	AC 2865I
PR2962-PR2963	AC 2801I-telaio frame
PR2965-PR2963	AC 2803I
PR2503-PR2503	AC 2803IR
PR2982-PR2982	AC 2822I
PR2985-PR2985	AC 2805I
PR2513-PR2513	AC 2803IR
PR2505-PR2505	AC 2805IR
PR2511-PR2511	AC 2811IR
PR2515-PR2515	AC 2815IR
PR2522-PR2522	AC 2822IR
PR2542-PR2542	AC 2803IR

Profilo Profile	Kit squadrette Corner brackets set
Codice Code	Codice Code
PR2542BV-PR2542BV	AC2803BVR
PR2543BV-PR2543BV	AC2843BVR
PR2542BV-PR2543BV	AC2803BVR
PR2943BV-PR2943BV	AC2843BV
PR2942BV-PR2943BV	AC2843BV
PR2962BV-PR2962BV	AC2862BV
PR2963BV-PR2963BV	AC2803BV
PR2962BV-PR2963BV	AC2862BV
PR2971BV-PR2971BV	AC2871BV
PR2973BV-PR2973BV	AC2853BV
PR2971BV-PR2973BV	AC2871BV



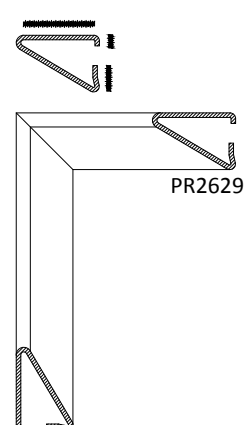
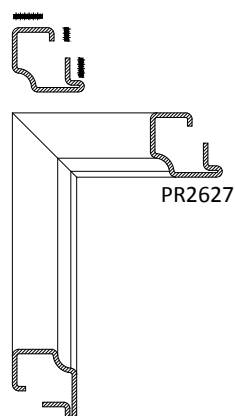
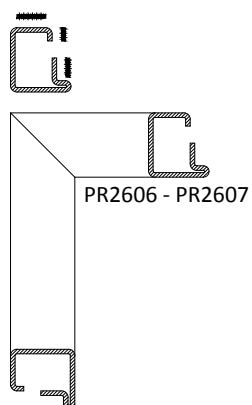
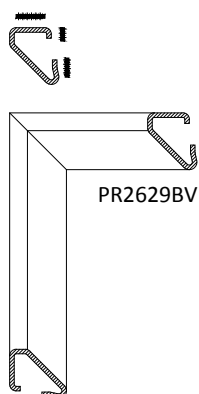
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

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



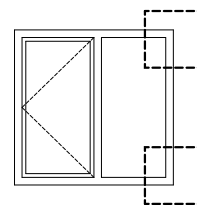
Ottone
Saldare a TIG a punti le zone indicate.

Brass
Spot weld (TIG) the marked areas.



AC2871BV squadretta di assiemaggio
per profili in ottone

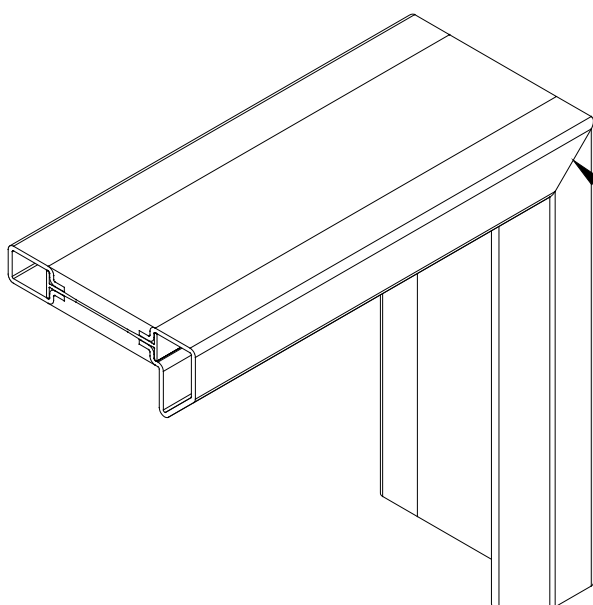
AC2871BV assembling corner brackets
for brass profiles



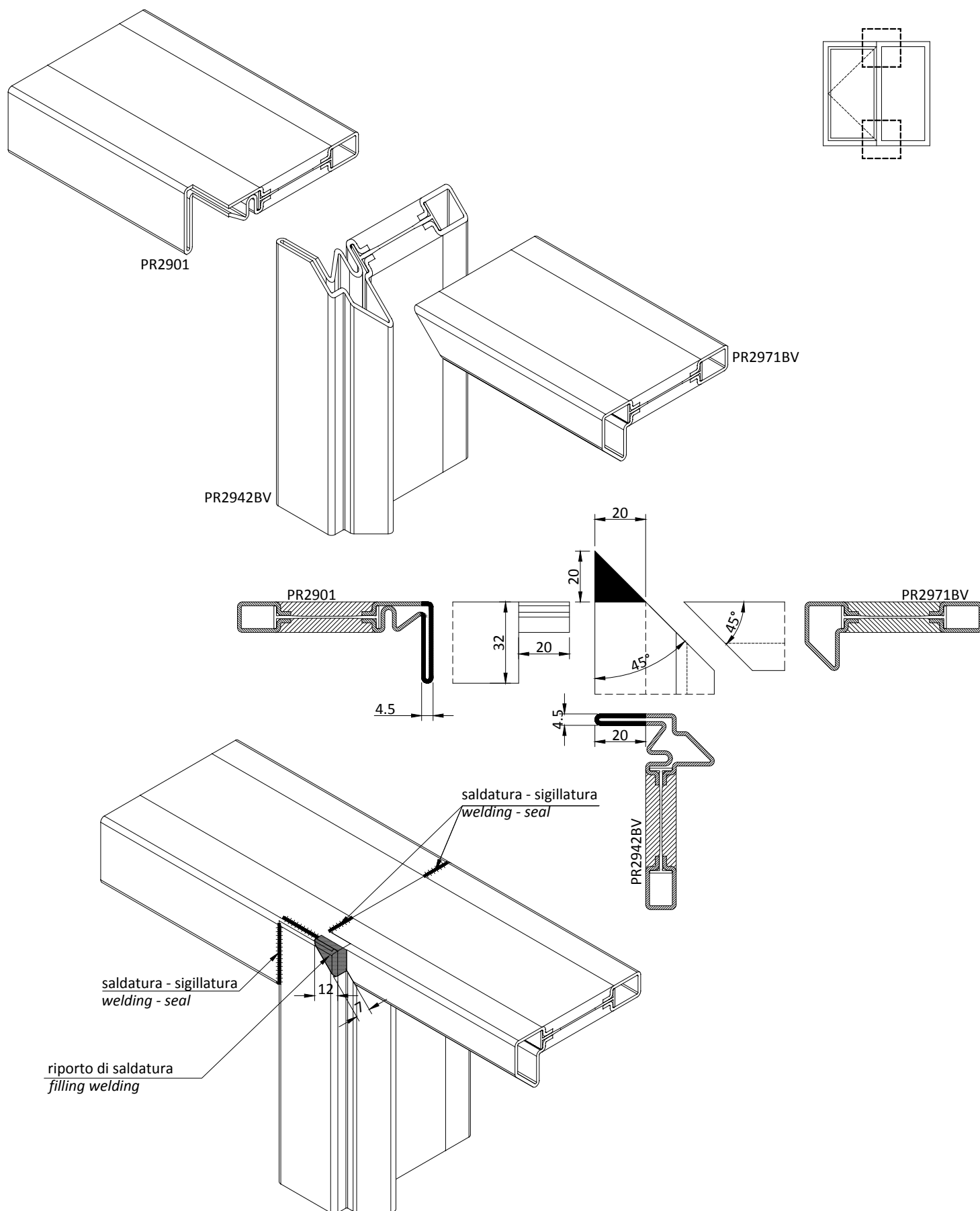
PR2971BV

PR2971BV

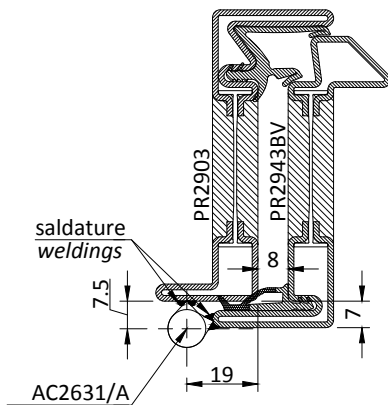
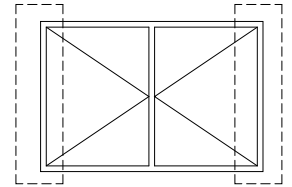
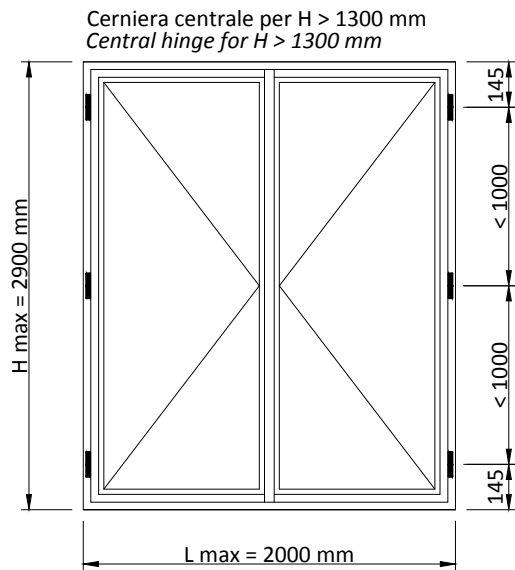
Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.



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



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



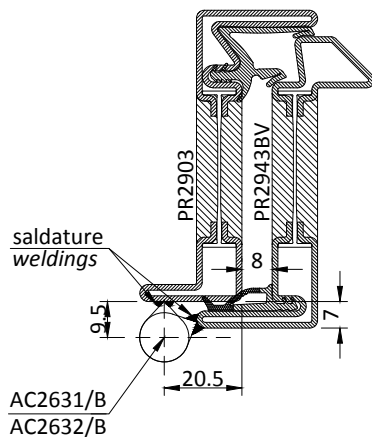
schema di fissaggio
AC2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

installation chart

AC2631/A non-adjustable

Ø 10 Hinge

Max leaf weight 40 kg



schema di fissaggio
AC2631/B non registrabile
AC2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

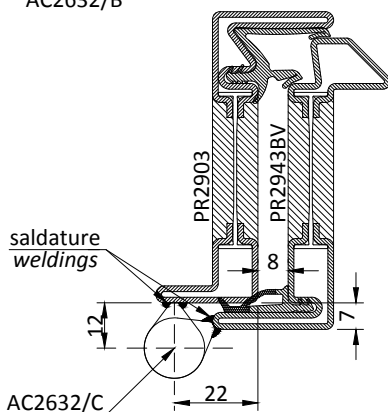
installation chart

AC2631/B non-adjustable

AC2632/B adjustable in height

Ø 13 Hinge

Max leaf weight 70 kg



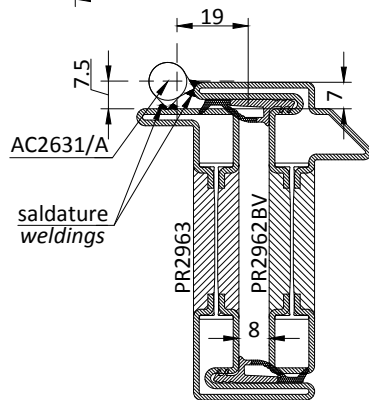
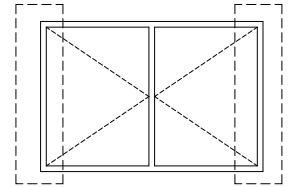
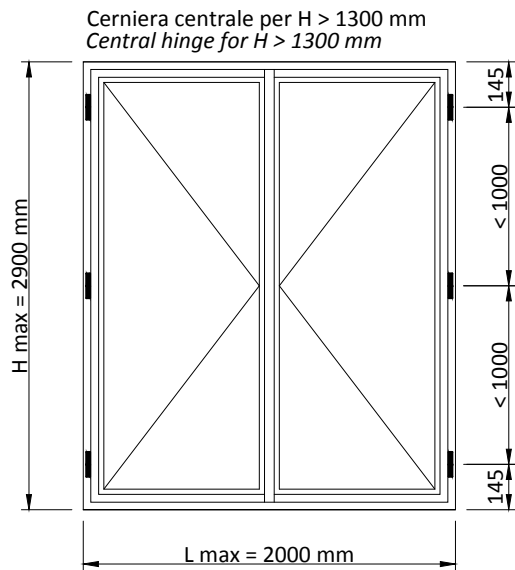
schema di fissaggio
AC2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

installation chart

AC2632/C adjustable in height

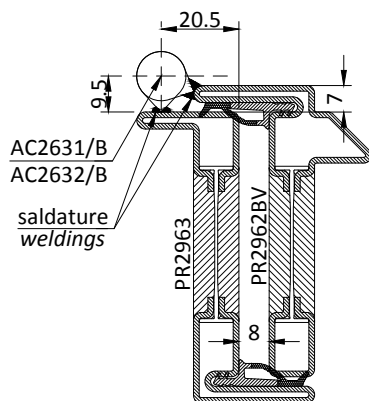
Ø 16 hinge

Max leaf weight 80 kg



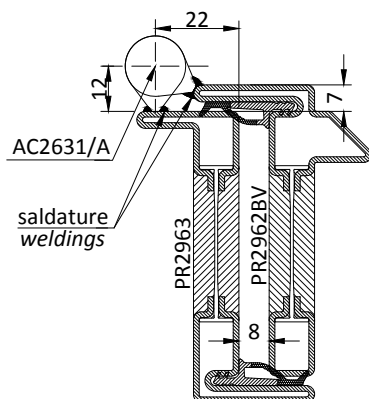
schema di fissaggio
AC2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

installation chart
AC2631/A non-adjustable
Ø 10 Hinge
Max leaf weight 40 kg



schema di fissaggio
AC2631/B non registrabile
AC2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

installation chart
AC2631/B non-adjustable
AC2632/B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg

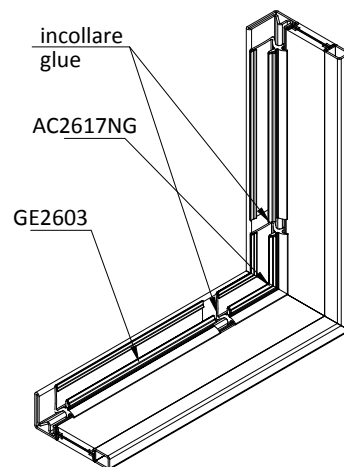
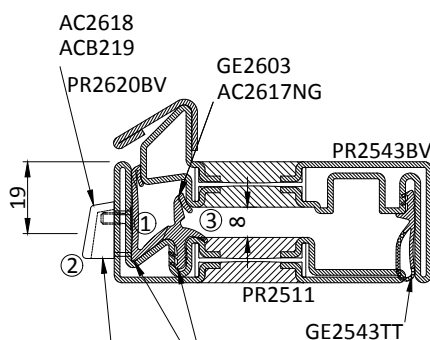
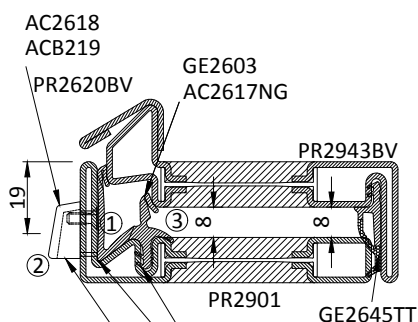
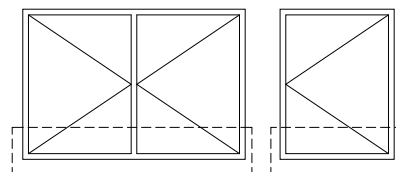


schema di fissaggio
AC2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

installation chart
AC2632/C adjustable in height
Ø 16 hinge
Max leaf weight 80 kg

- 1) Eseguire i fori come da disegno (lavorazione effettuabile con maschera AT2618).
- 2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione Inox A2.
- 3) Posizionare la guarnizione di giunto centrale e gli angoli vulcanizzati, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica.
- 4) Sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.

- 1) Drill the holes as shown in the diagram (using jig AT2618).
- 2) Position the water drain, seal and secure with the supplied A2 stainless screw.
- 3) Position the central weather strip and vulcanised corner, glue the corners to the weather strip using cyanoacrylate glue
- 4) seal the entire lower base of the frame and vertically for 150 mm

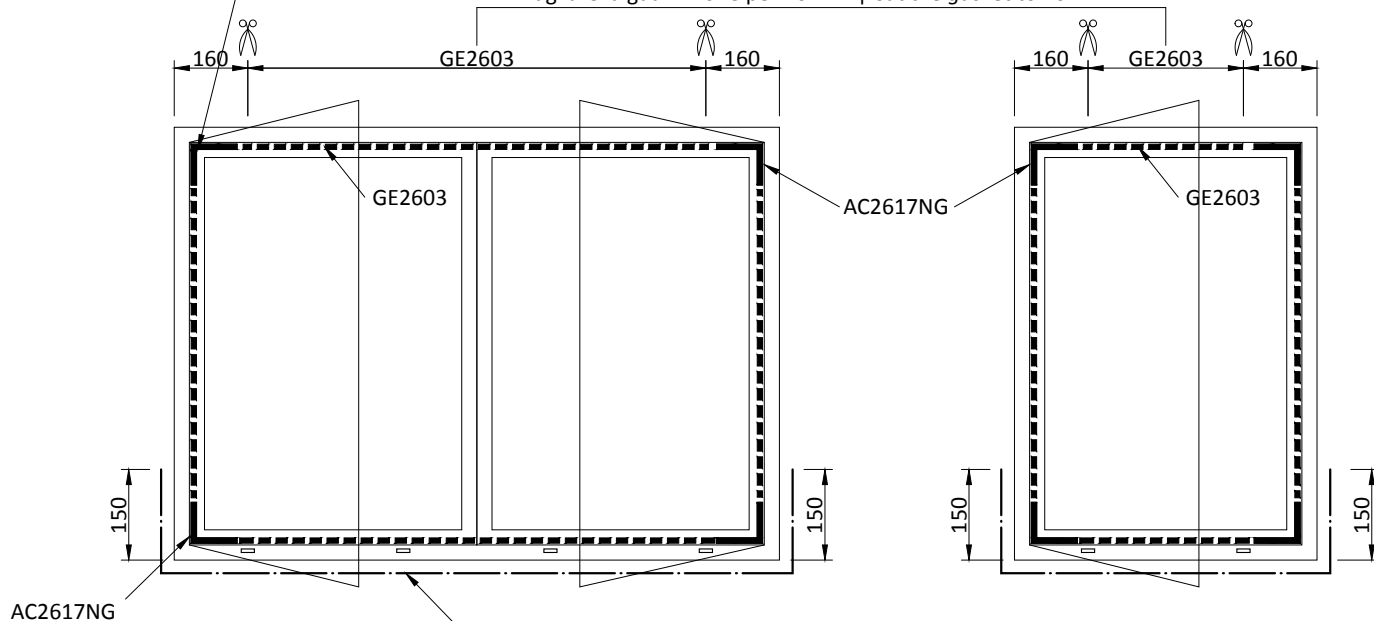


sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
seal the entire base of the frame and vertically for 150 mm

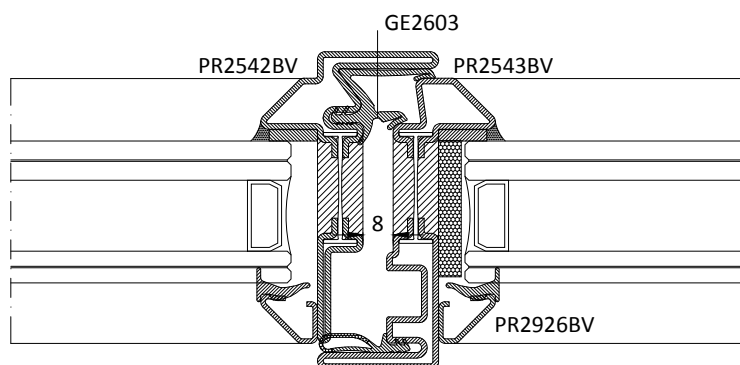
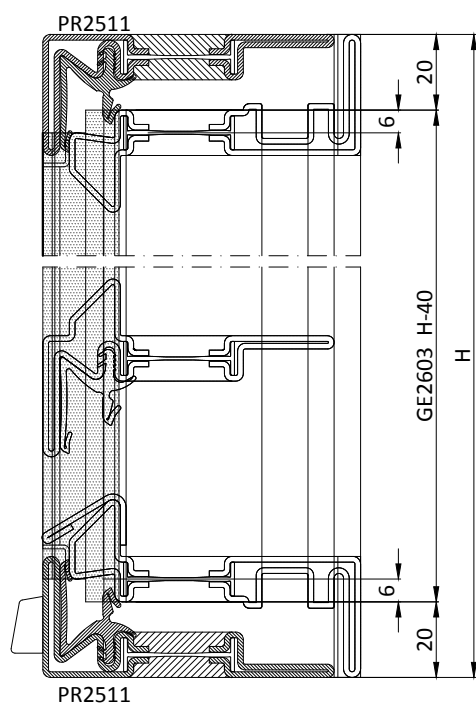
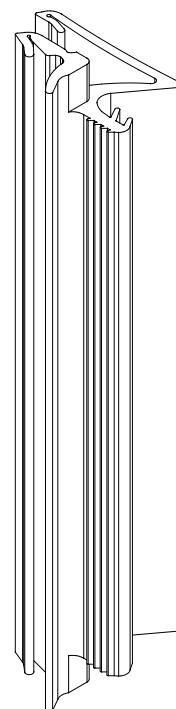
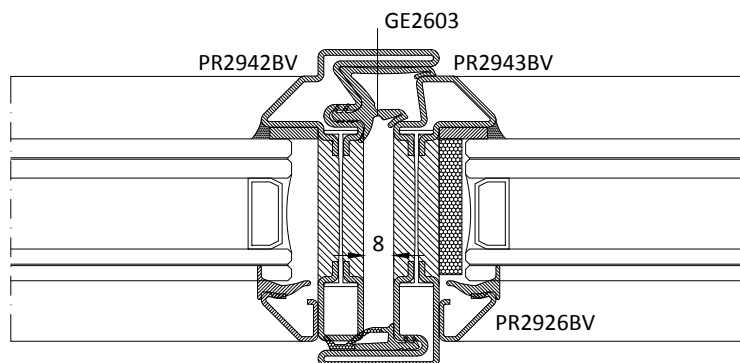
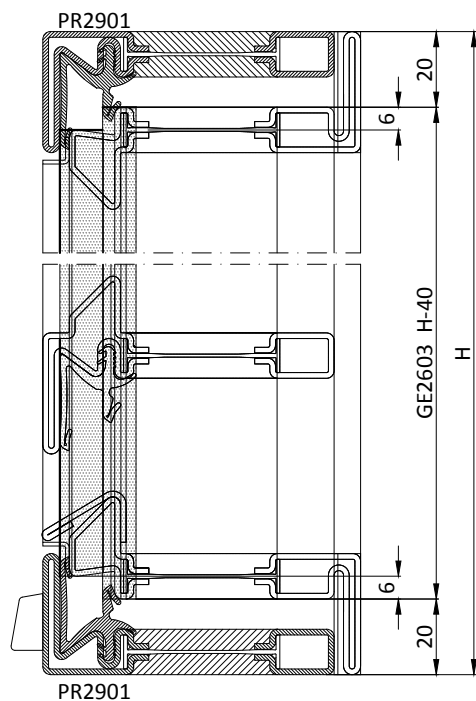
sigillare il perimetro dello scarico acqua
seal the perimeter of the water drip

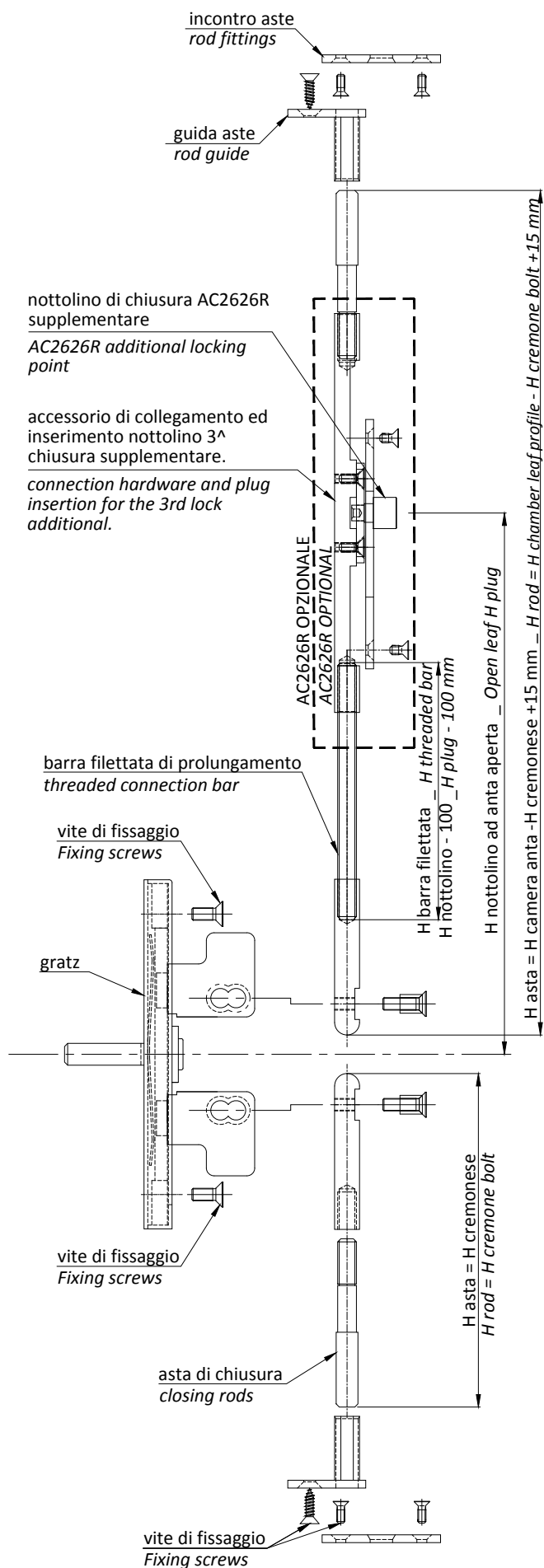
incollare gli angoli vulcanizzati AC2617 alla guarnizione con colla cianoacrilica
glue the AC2617 vulcanised corner to the gasket using cyanoacrylate glue

Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm



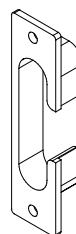
- ④ sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
- ④ seal the entire base of the frame and vertically for 150 mm





- 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.

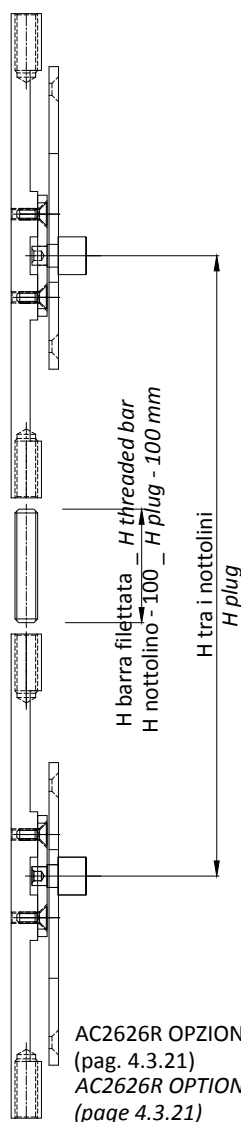
- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.



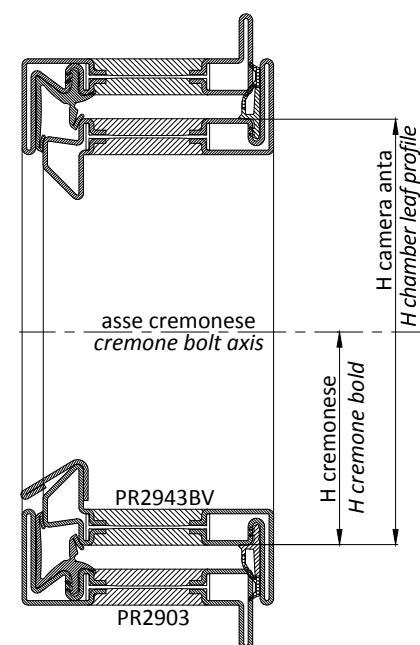
AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

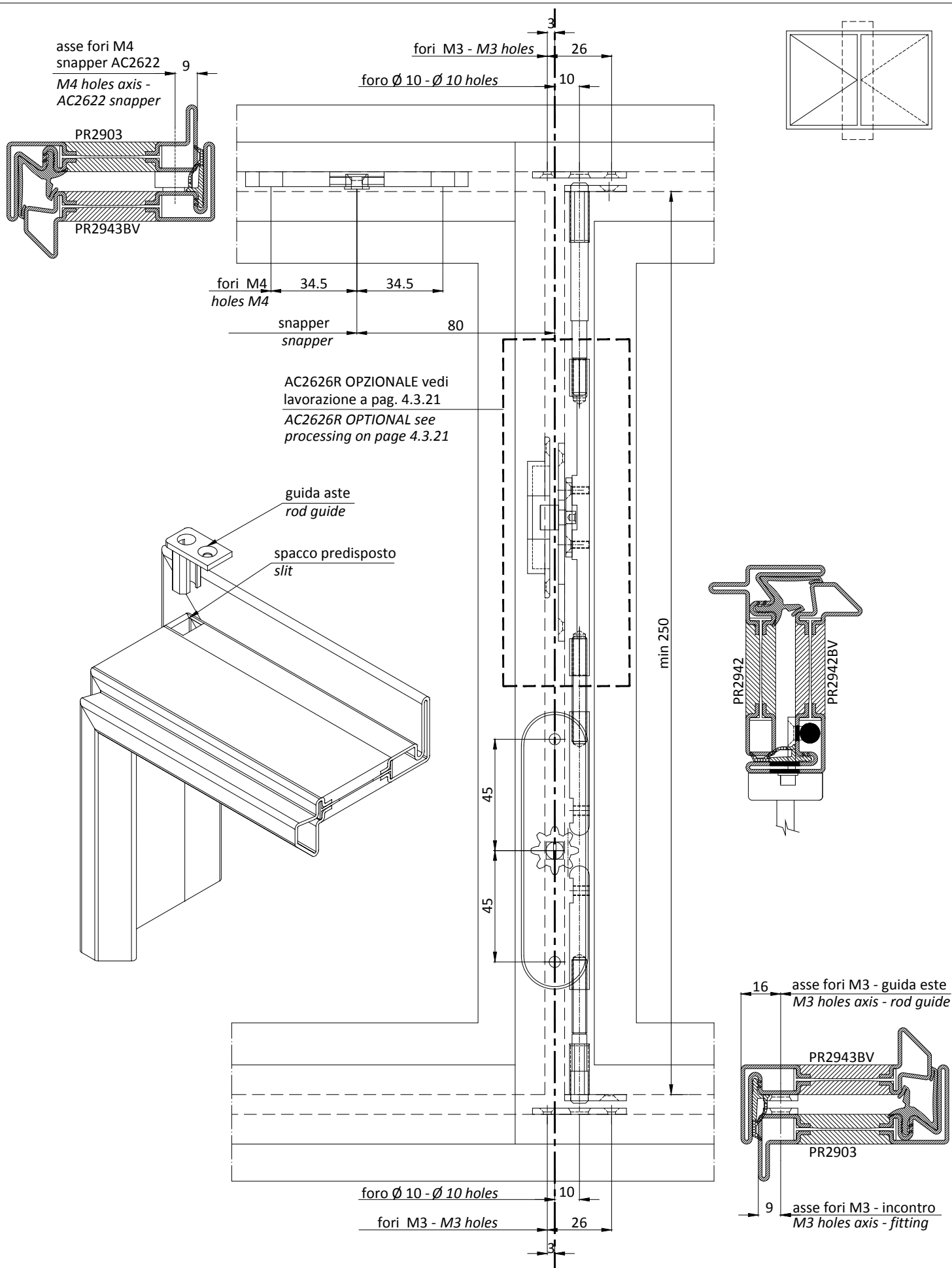
N.B. prevedere un punto di chiusura ogni 1000 mm max.

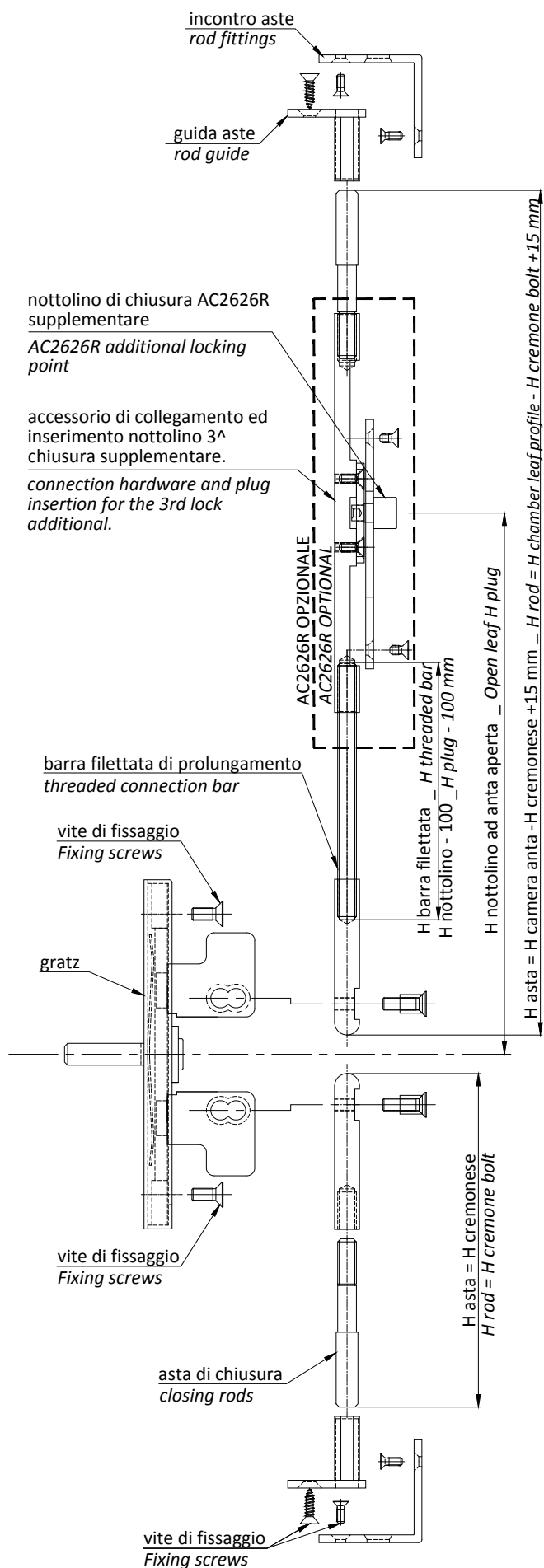
Attn. Consider one locking point every 1000 mm max.



AC2626R OPZIONALE
(pag. 4.3.21)
AC2626R OPTIONAL
(page 4.3.21)

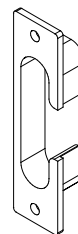






- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.
- 6) Fissare gli incontri al telaio.

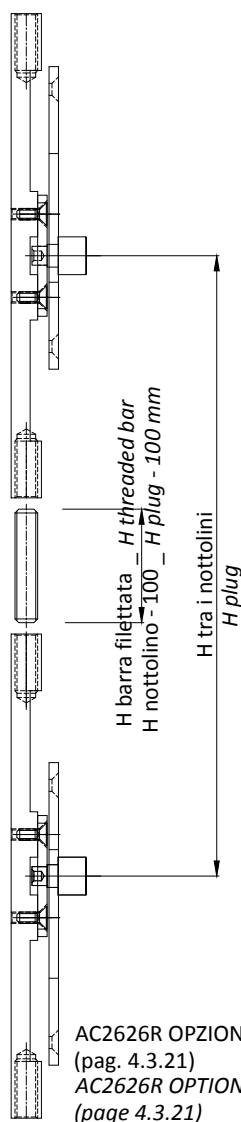
- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.



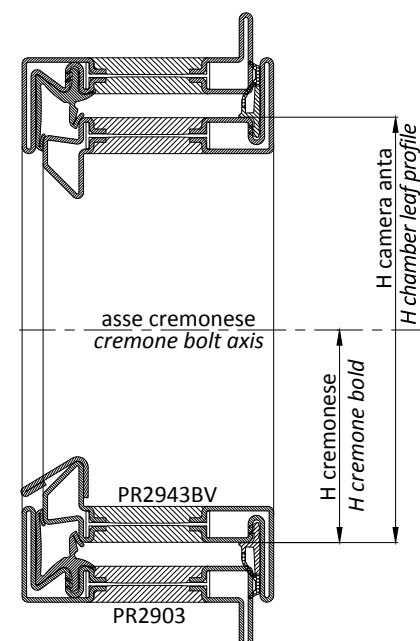
AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

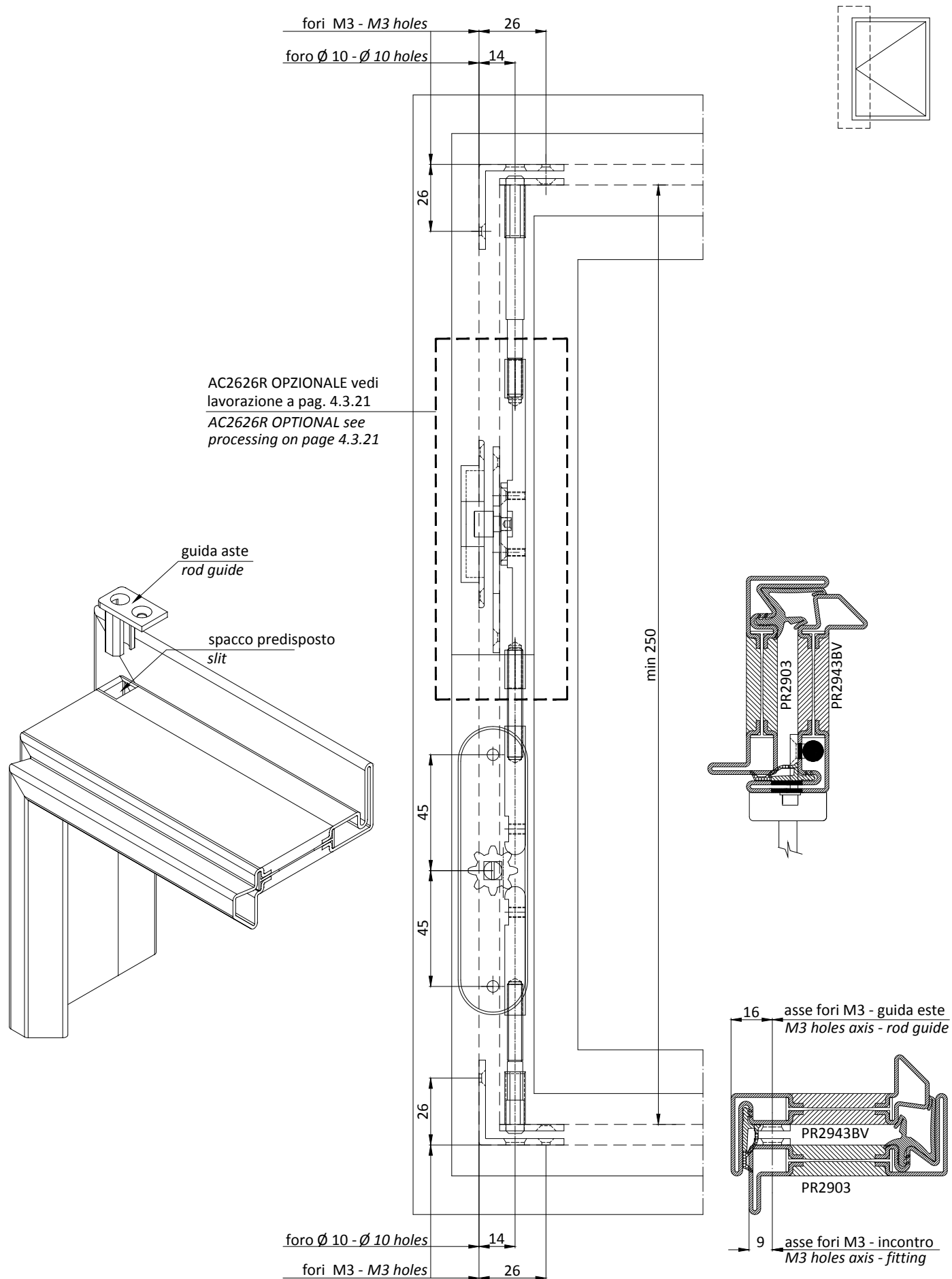
N.B. prevedere un punto di chiusura ogni 1000 mm max.

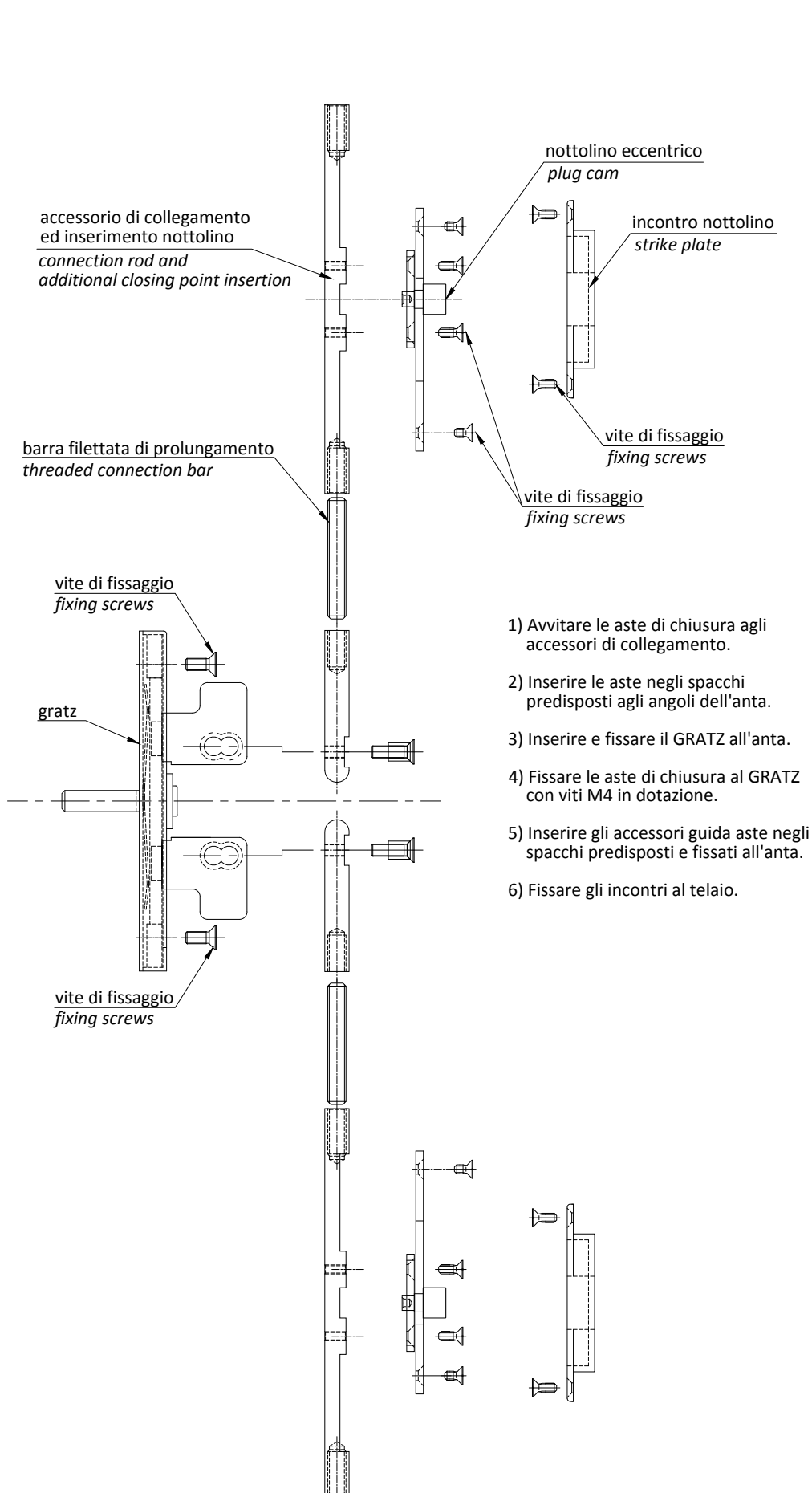
Attn. Consider one locking point every 1000 mm max.



AC2626R OPZIONALE
(pag. 4.3.21)
AC2626R OPTIONAL
(page 4.3.21)

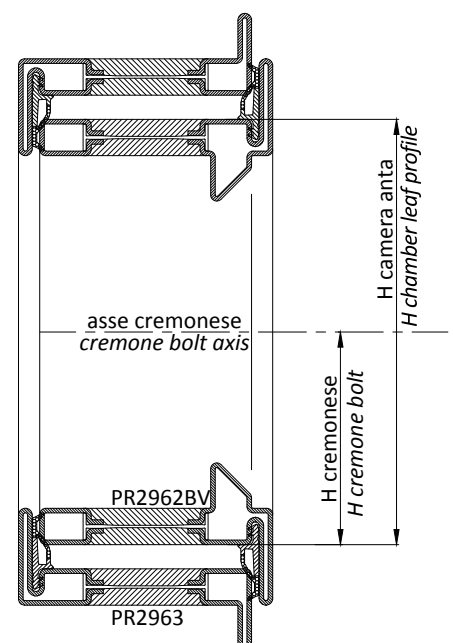


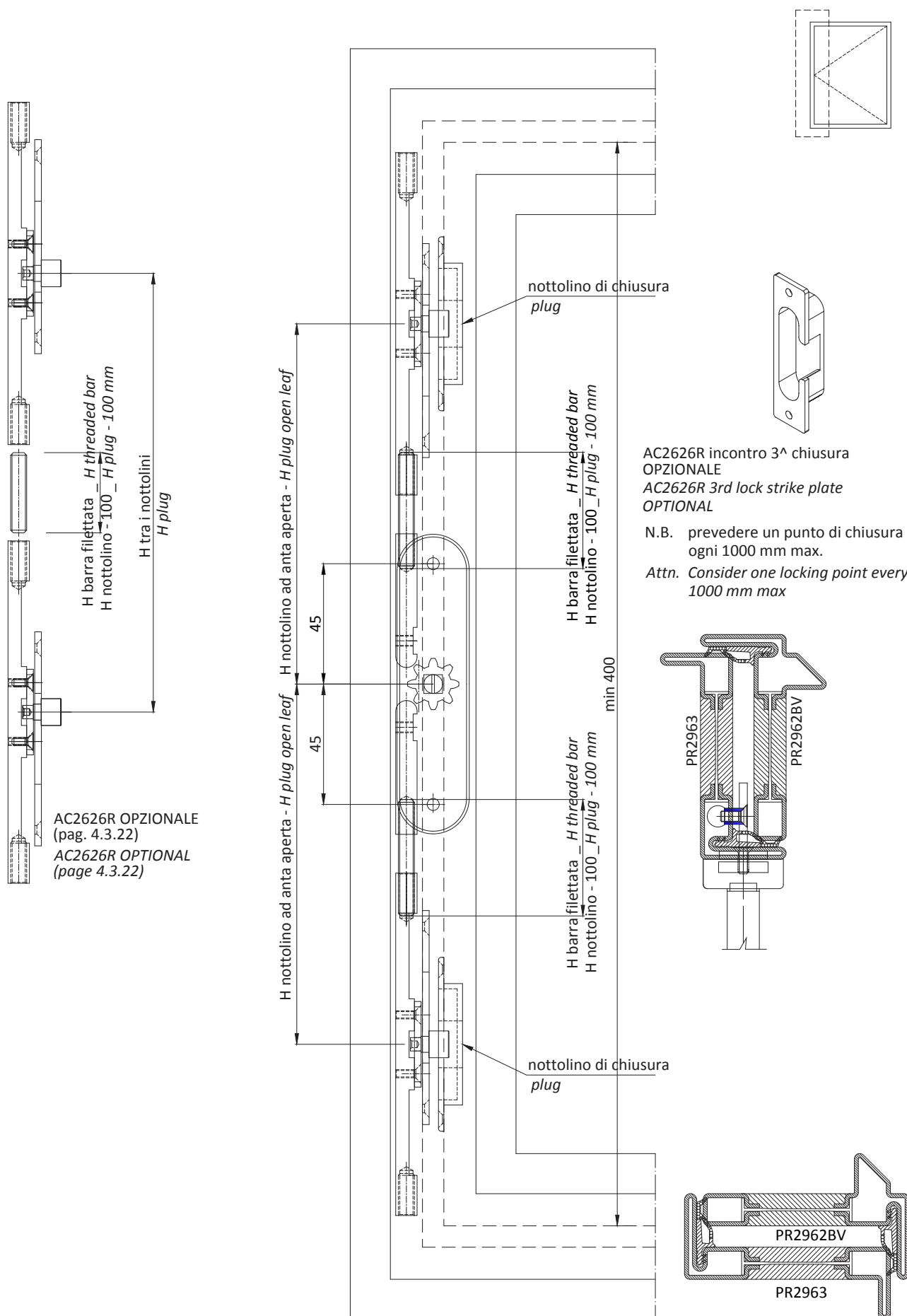


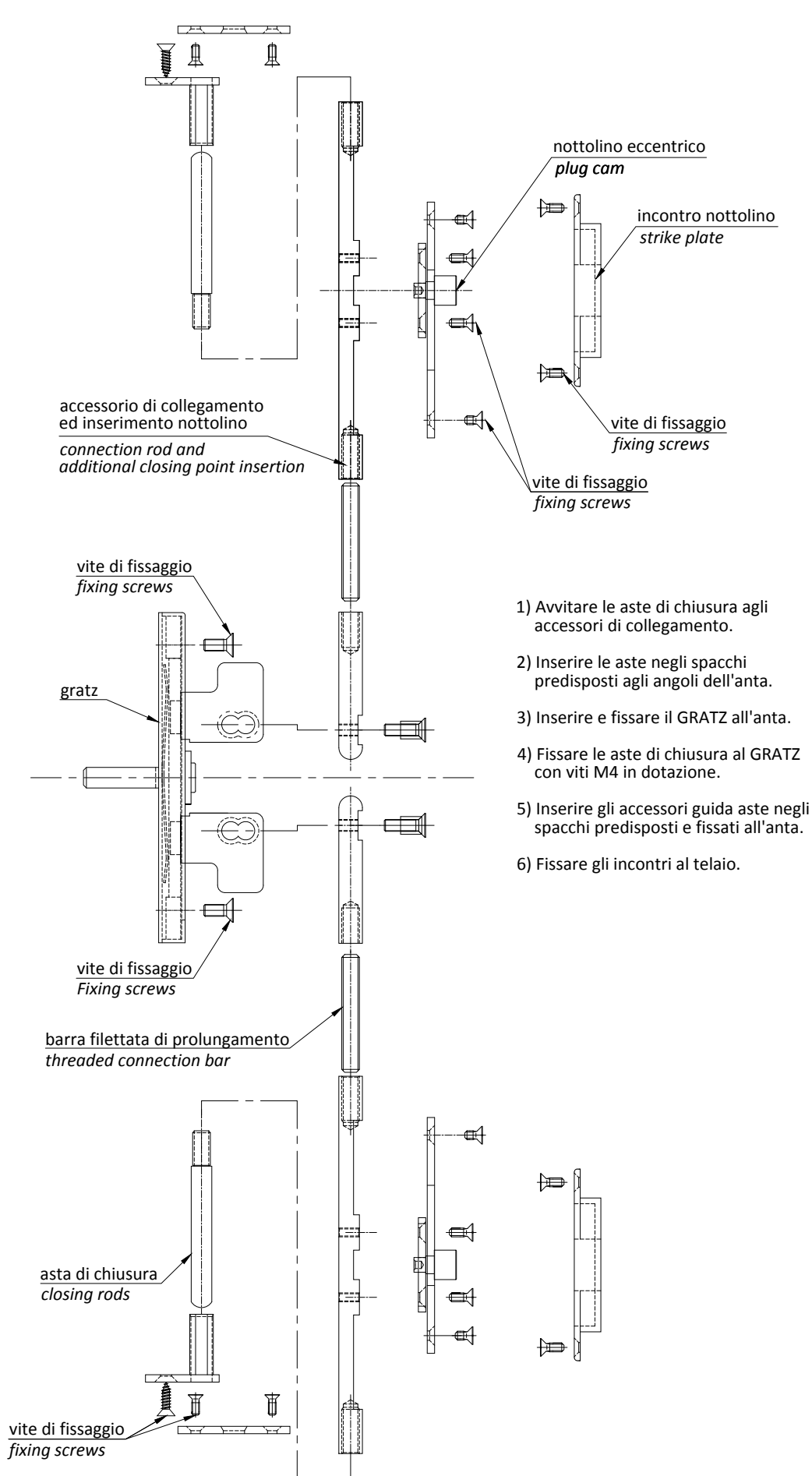


- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.
- 6) Fissare gli incontri al telaio.

- 1) Screw the closing rods to the connection fittings.
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- 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.

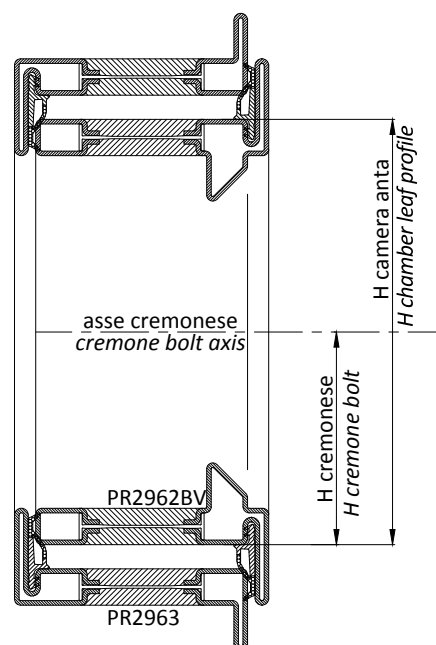


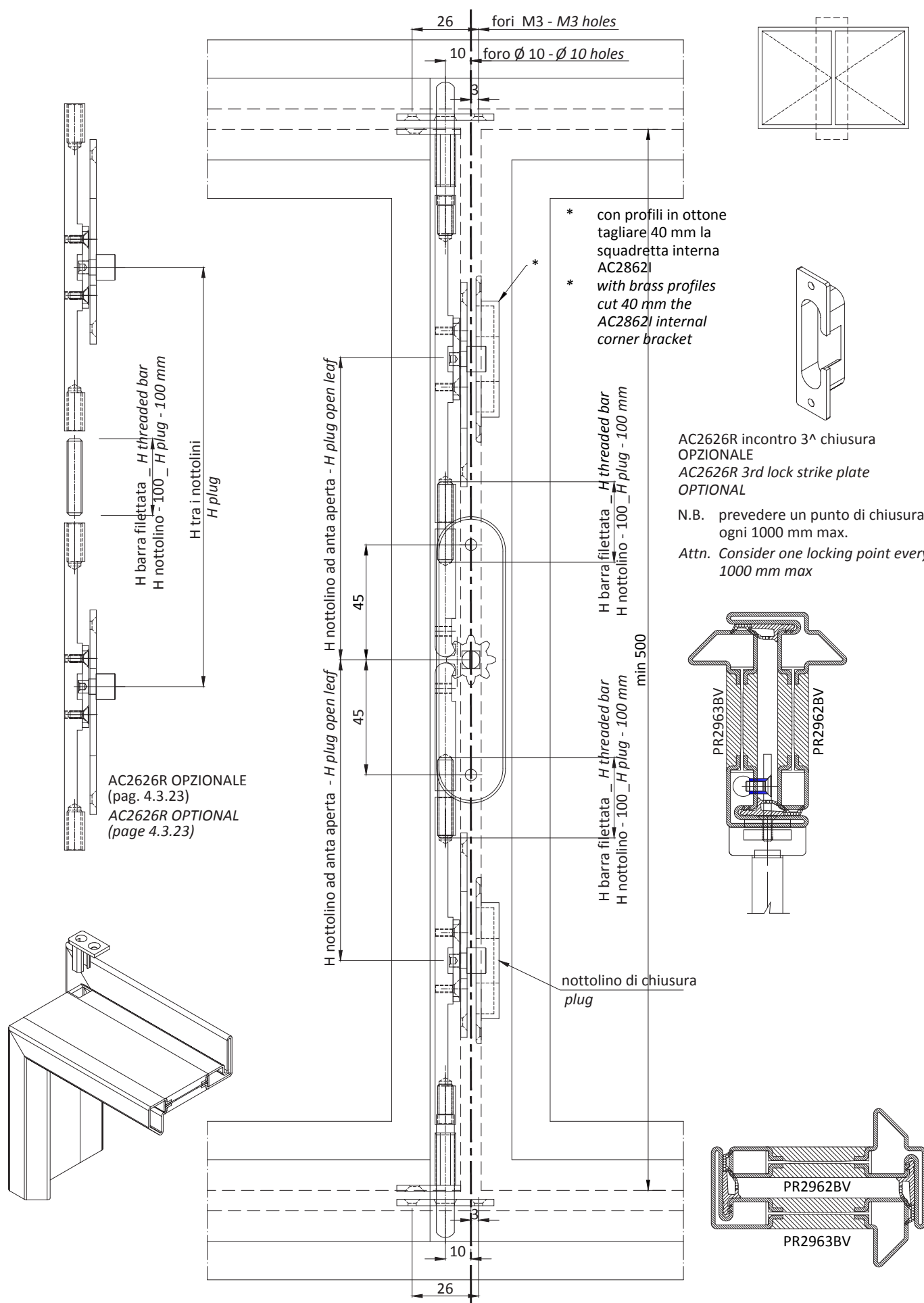


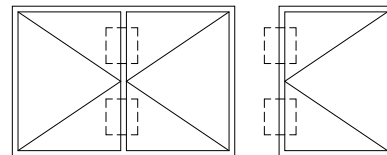
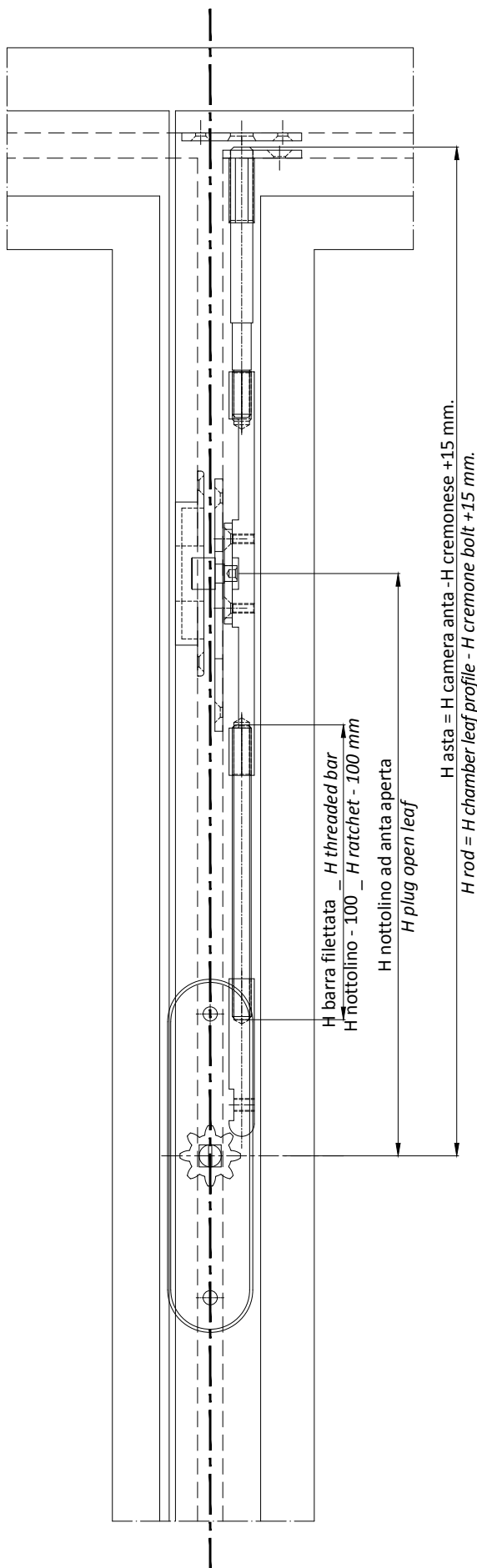


- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.
- 6) Fissare gli incontri al telaio.

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- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.

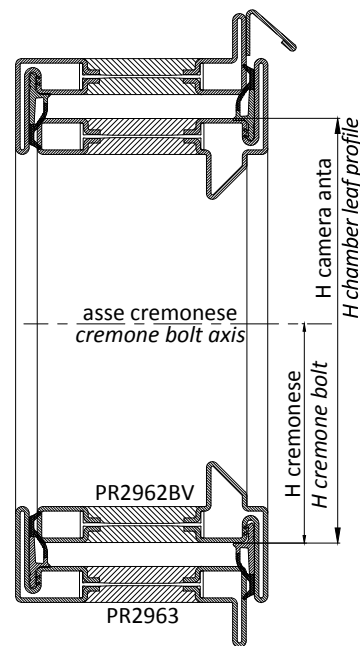
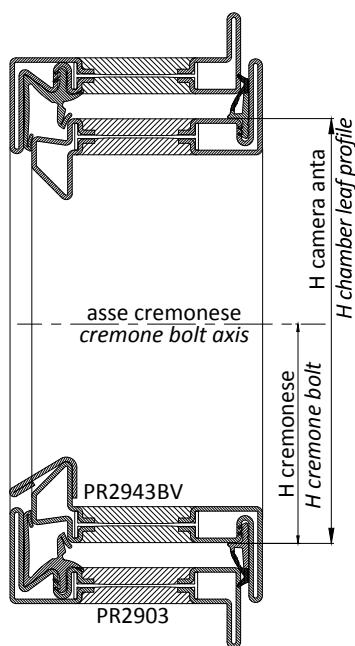
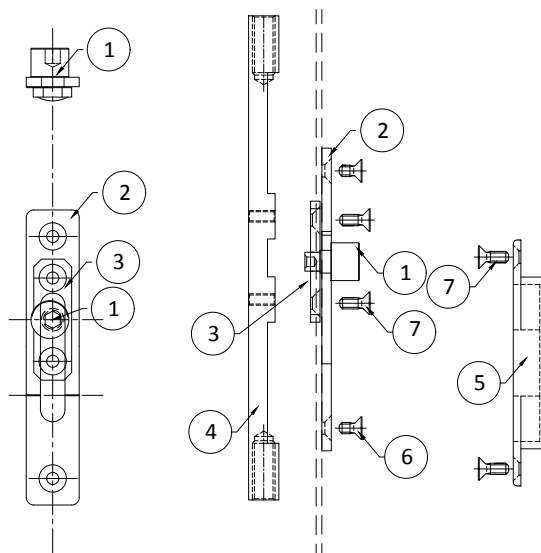


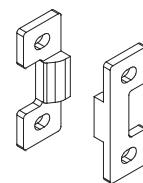
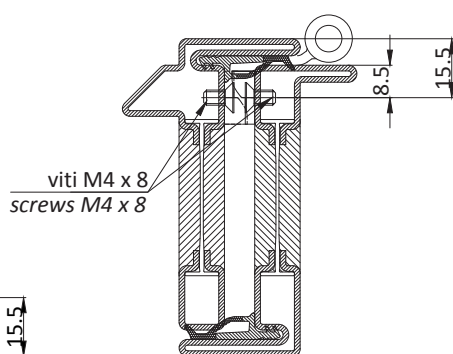
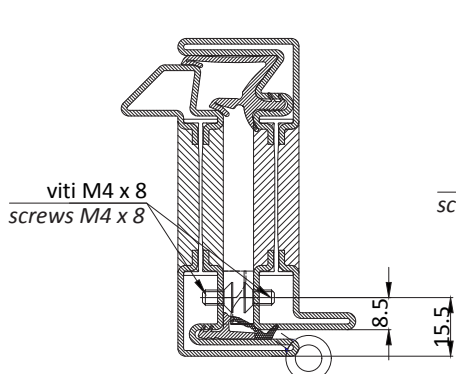
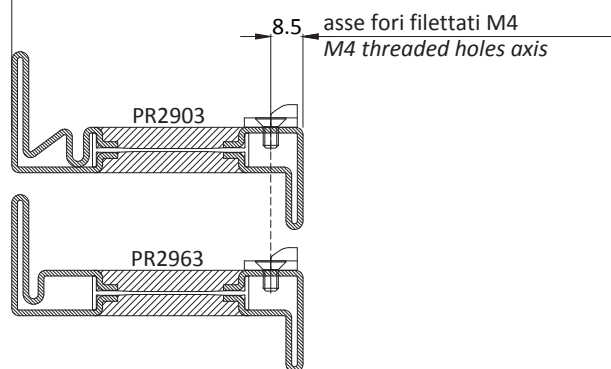
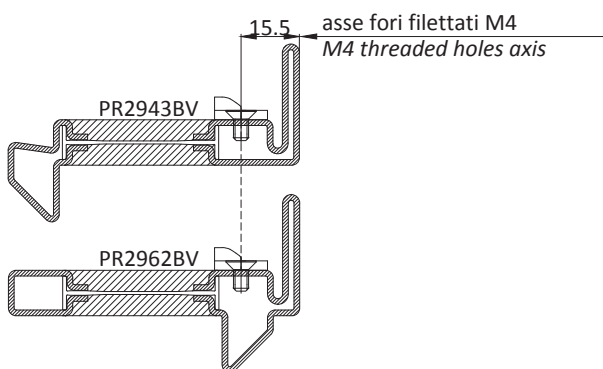
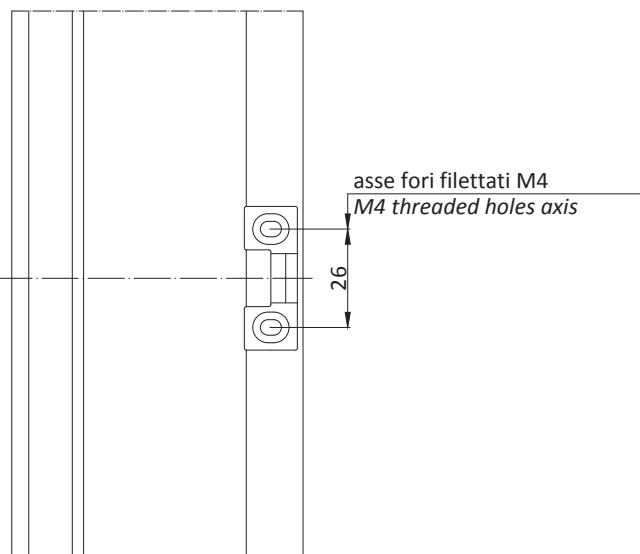
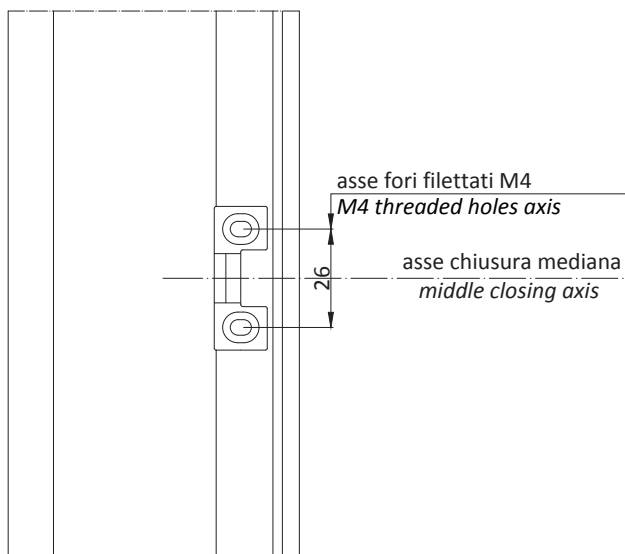
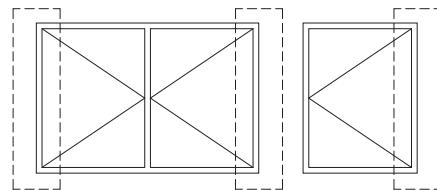
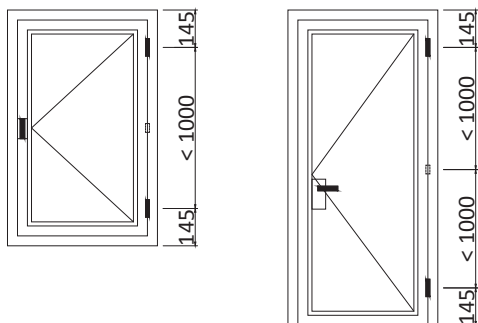




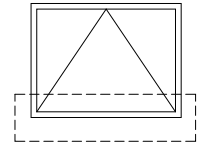
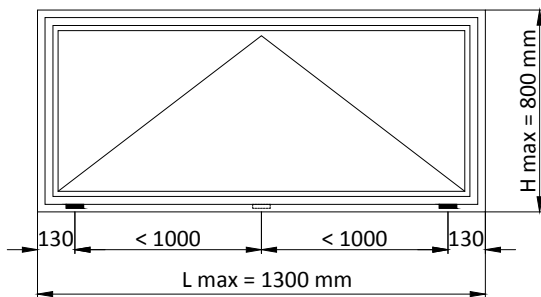
- 1) Rullino eccentrico.
- 2) Piastra di fissaggio.
- 3) Piastra di collegamento.
- 4) Accessorio aggancio aste.
- 5) Incontro 3^a chiusura.
- 6) viti M3 x 6.
- 7) viti M3 x 8.

- 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.



chiusura mediana
Middle closing

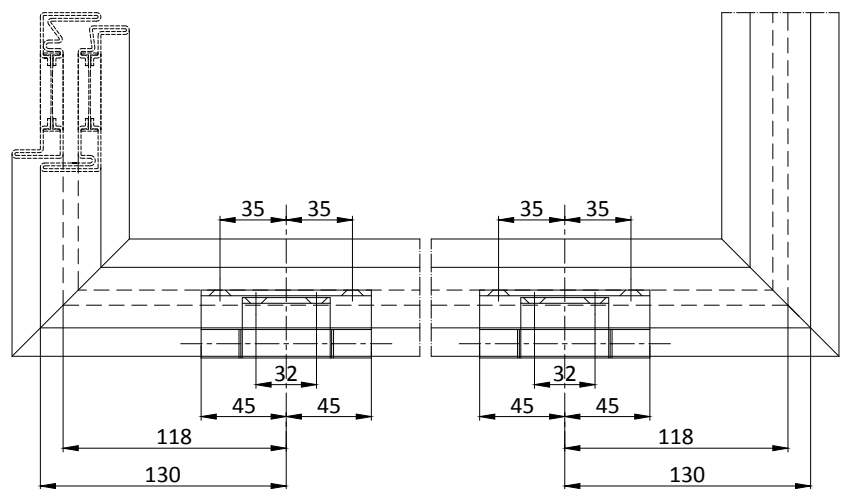
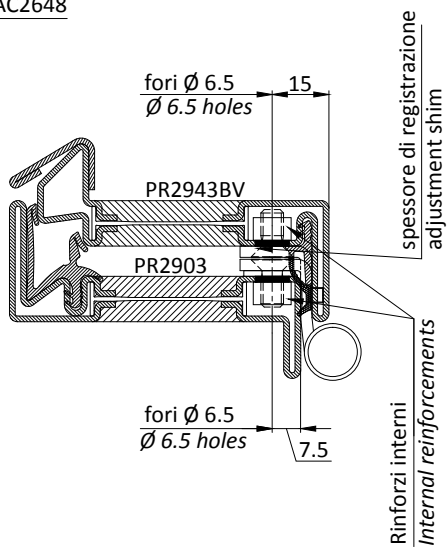
peso max. per anta: 40 kg
max. leaf weight: 40 kg



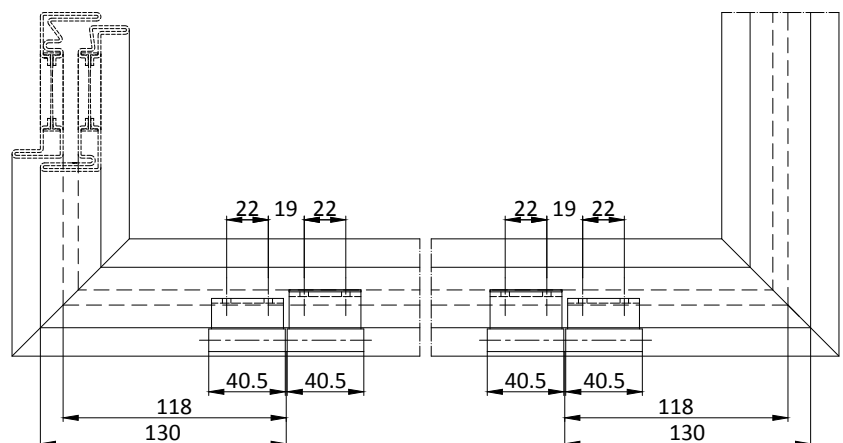
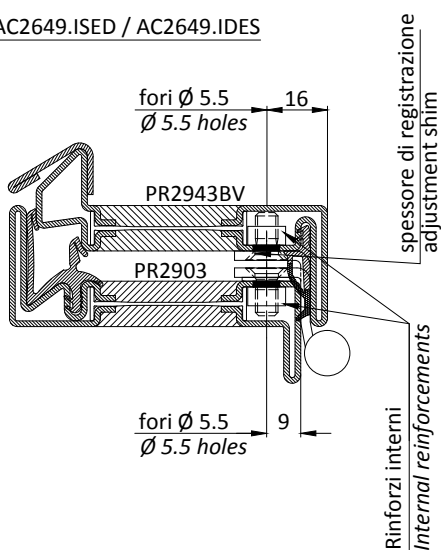
NOTA: Con cerniere AC2648, AC2649.ISED e AC2649.IDES
installare braccetti limitatori AC2641

ATTN: With hinges AC2648, AC2649.ISED and AC2649.IDES
please install the restrictor stay AC2641

AC2648



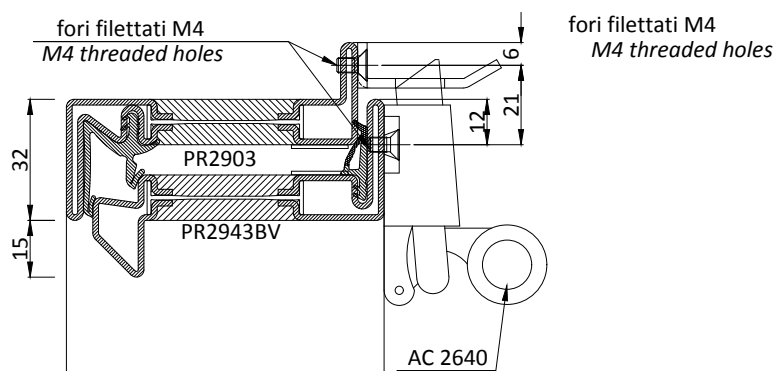
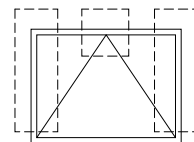
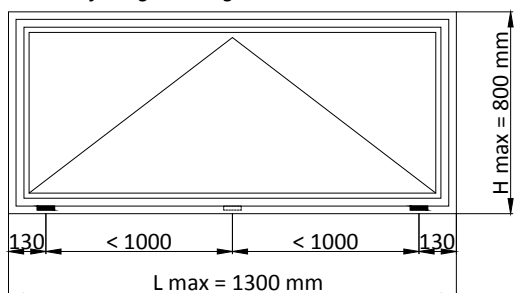
AC2649.ISED / AC2649.IDES



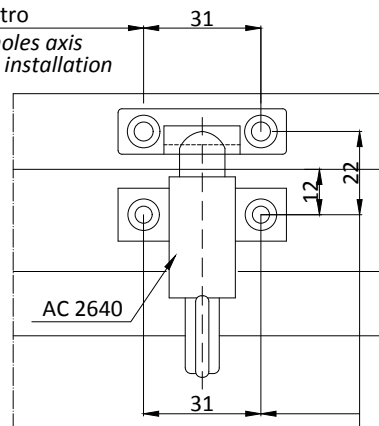
N.B.: Per vasistas installare una cerniera destra AC2649.IDES
e una cerniera sinistra AC2649.ISED

NOTE : For top hung windows please install one right hinge AC2649.IDES
and one left hinge AC2646.ISED

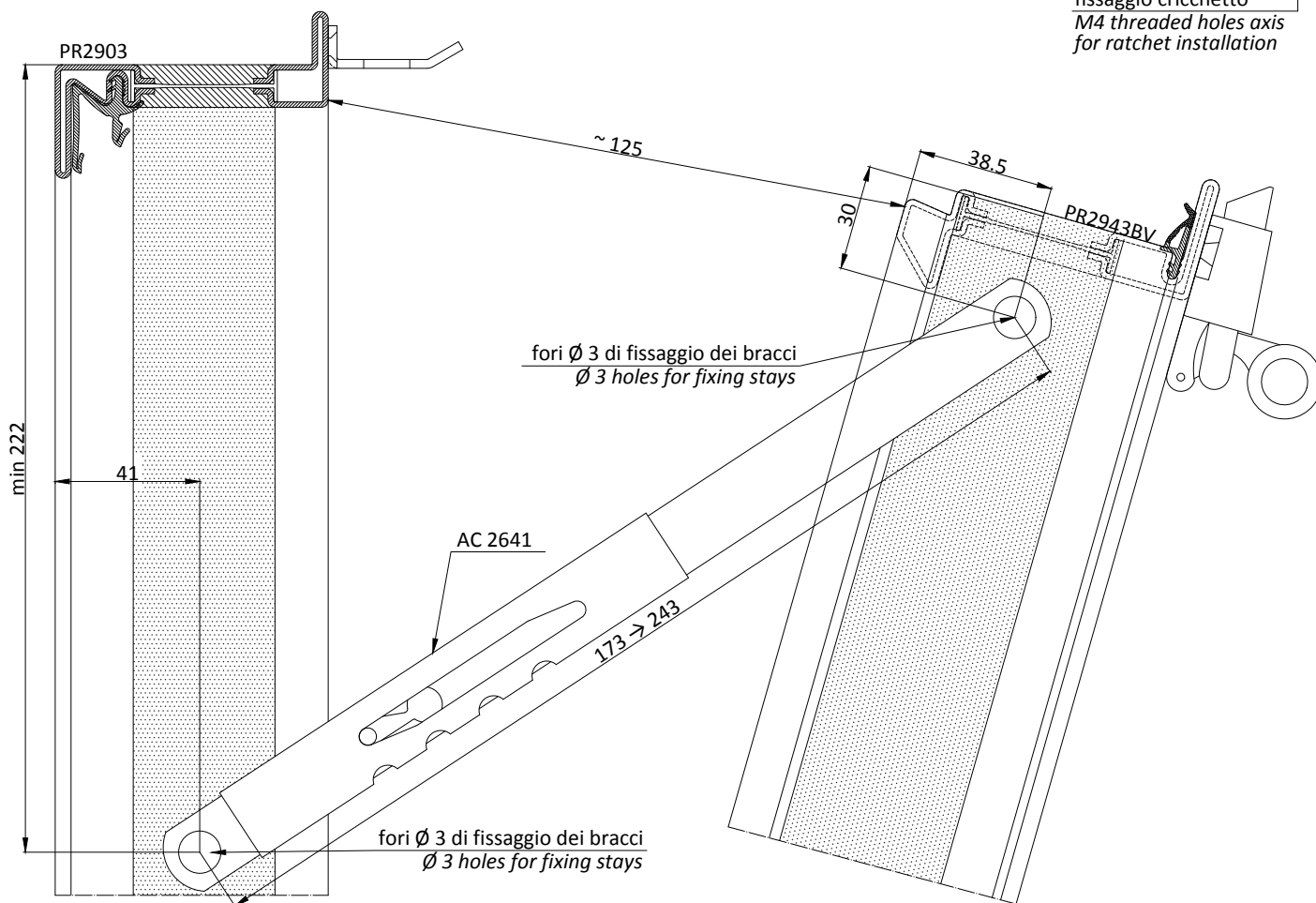
peso max. per anta: 40 kg
max. leaf weight: 40 kg

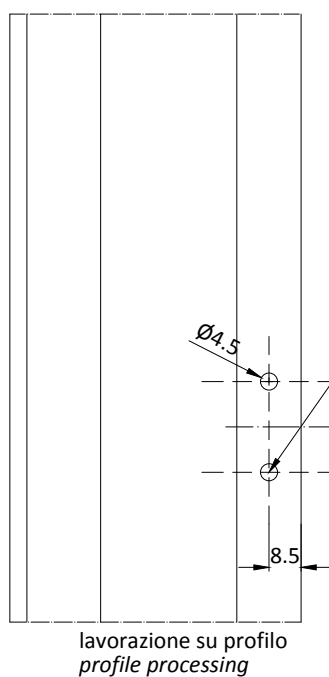
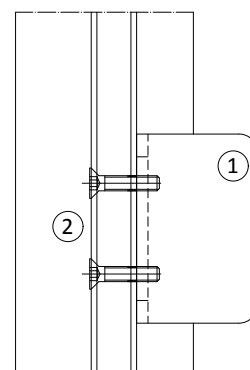
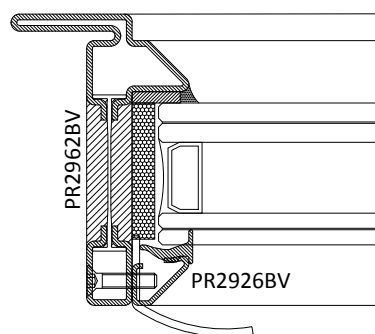
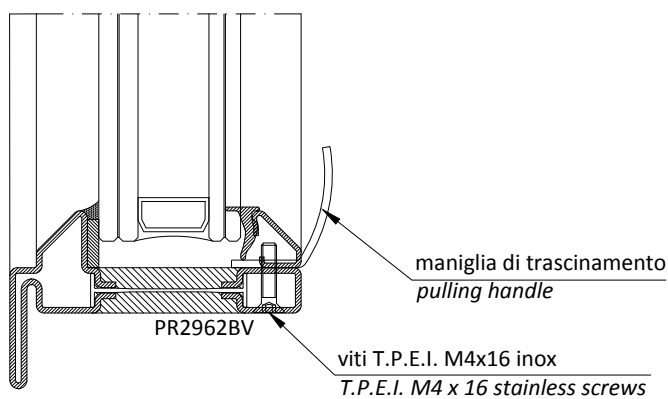
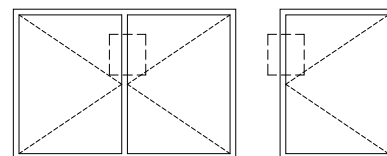
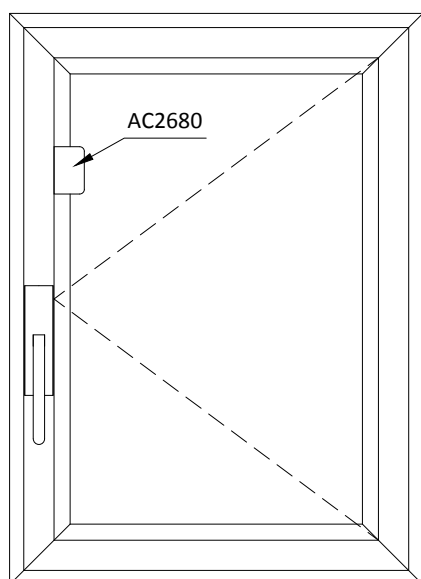


fori filettati M4
fissaggio incontro
M4 threaded holes axis
for strike plate installation

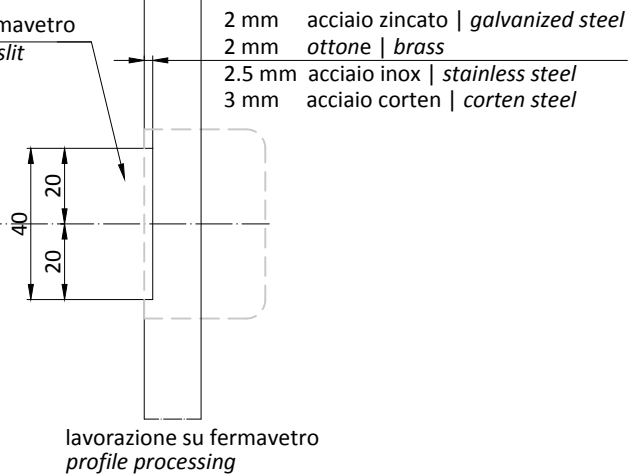


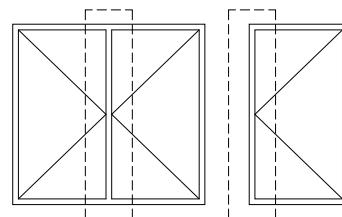
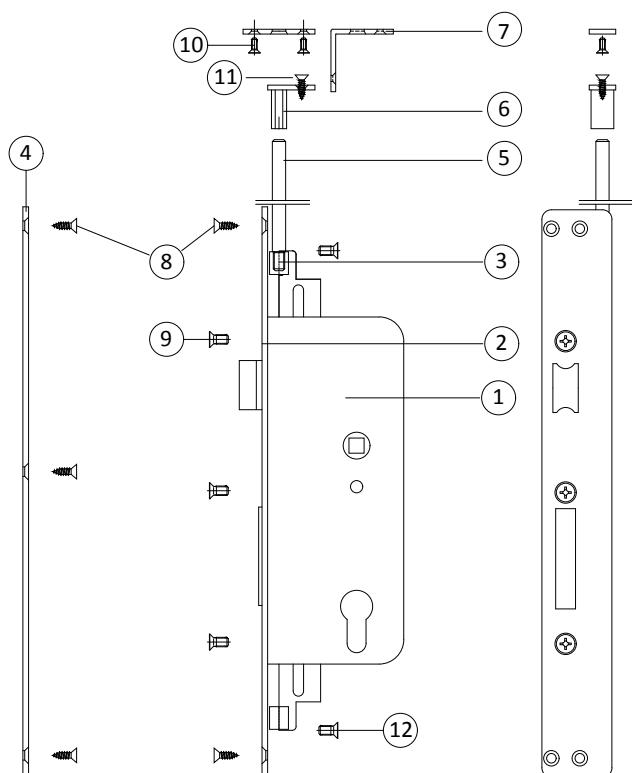
fori filettati M4
fissaggio cricchetto
M4 threaded holes axis
for ratchet installation



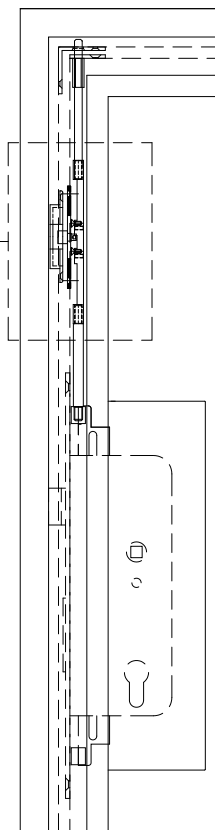


spacco su fermavetro
glazing bead slit





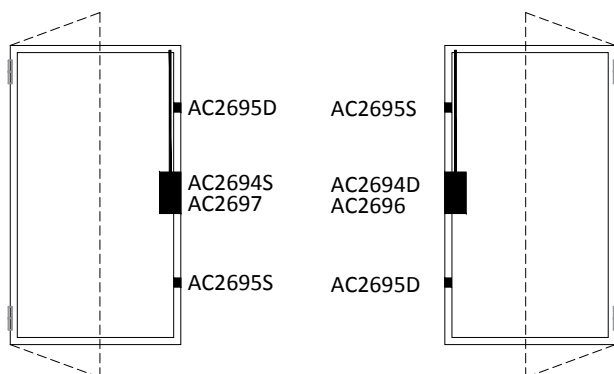
AC2695 OPZIONALE
vedi lavorazione a pag. 4.3.60-61 | 4.5.27
AC2695 OPTIONAL
see processing on page 4.3.60-61 | 4.5.27



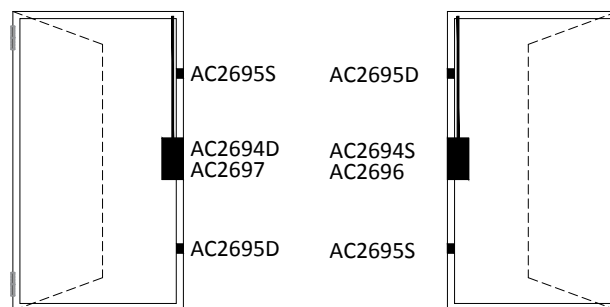
- 1) Serratura
- 2) Frontalino (Dx o Sx)
- 3) Riduttore di collegamento
- 4) Incontro per serratura
- 5) Aste inox
- 6) Guida aste superiore
- 7) Incontro aste per porte a due ante
- 7 bis) Incontro aste per porte ad un anta
- 8) Viti autof. Inox A2 T.P.T.C. 3,9x13
- 9) Viti Inox T.P.T.C. m5x10
- 10)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

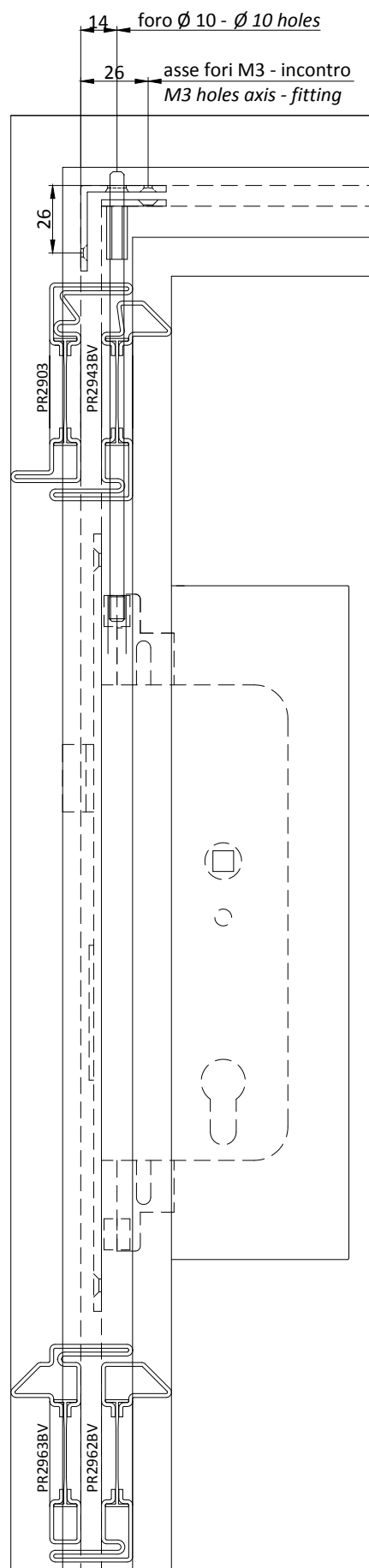
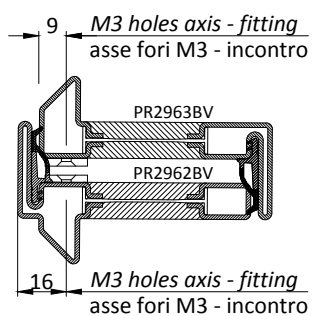
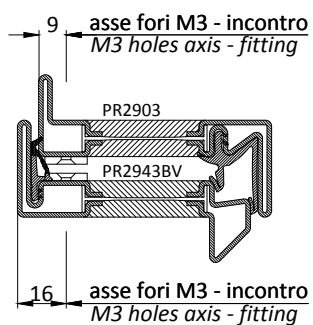
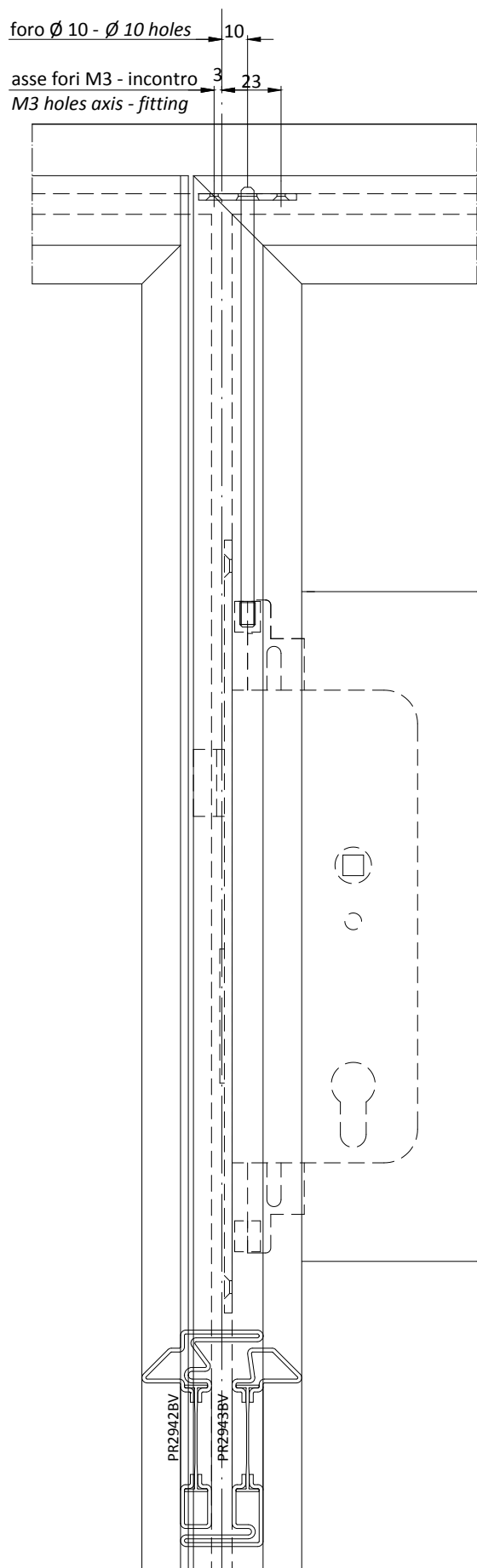
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE CHART FOR THE USE OF LOCKS AND THIRD LOCKS



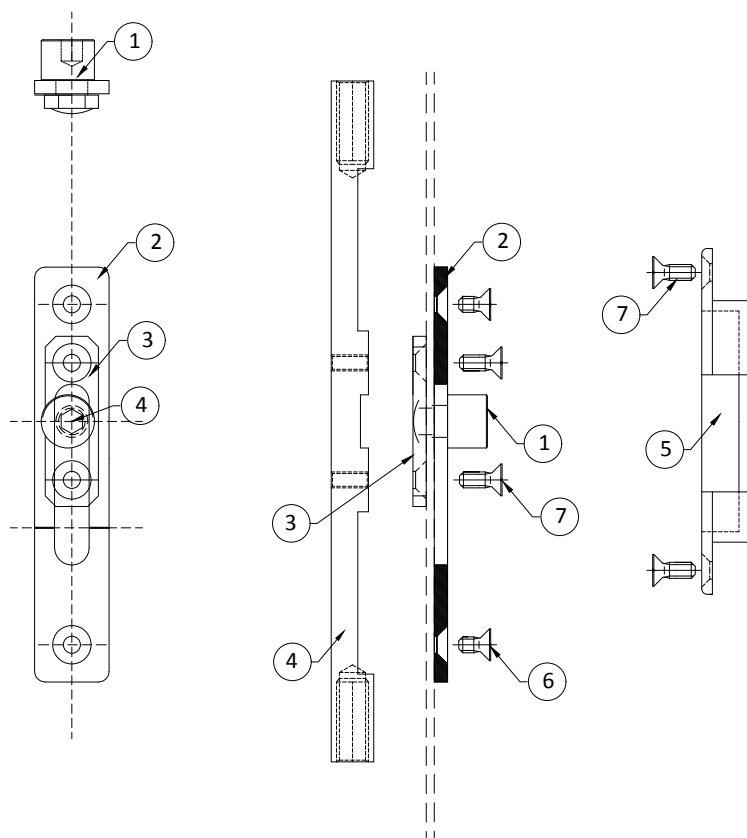
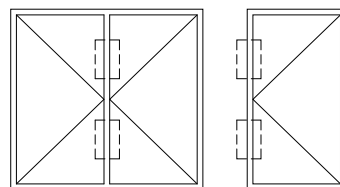
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



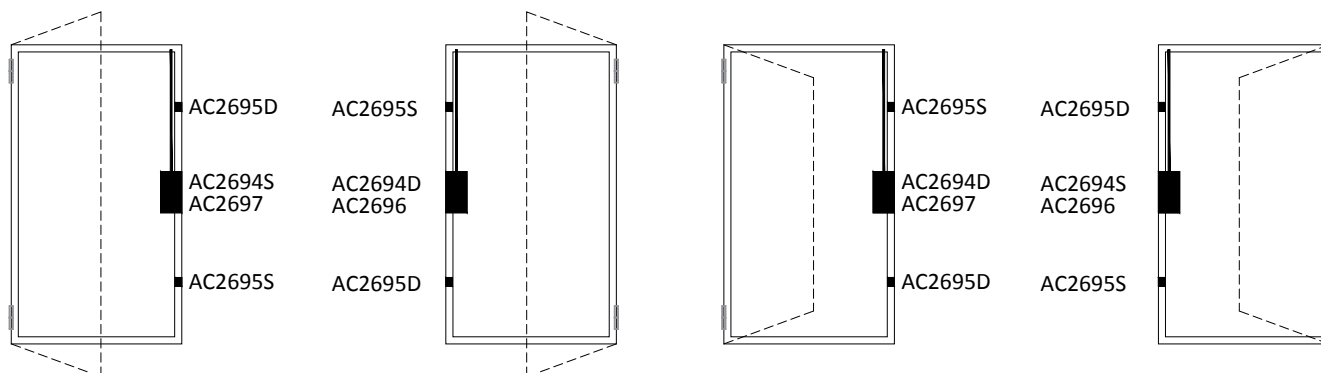
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



- | | |
|-------------------------------------|--------------------------|
| 1) Rullino eccentrico | 1) Barrel cam |
| 2) Piastra di fissaggio | 2) Installation plate |
| 3) Piastra di collegamento | 3) Connecting plate |
| 4) Accessorio aggancio aste | 4) Rod docking accessory |
| 5) Incontro 3 ^a chiusura | 5) 3rd lock strike plate |
| 6) viti M3 x 6 | 6) screws M3 x 6 |
| 7) viti M3 x 8 | 7) screws M3 x 8 |

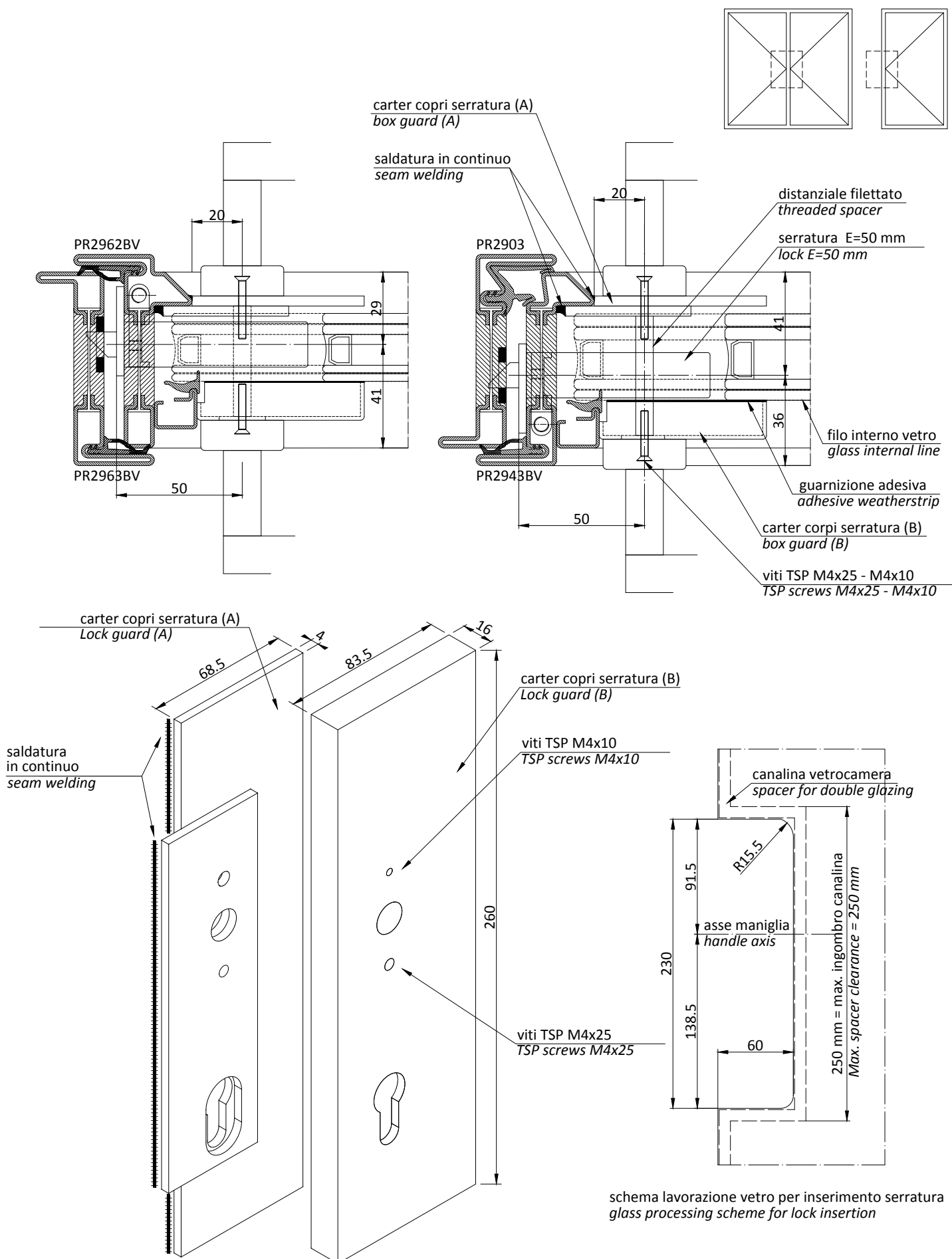


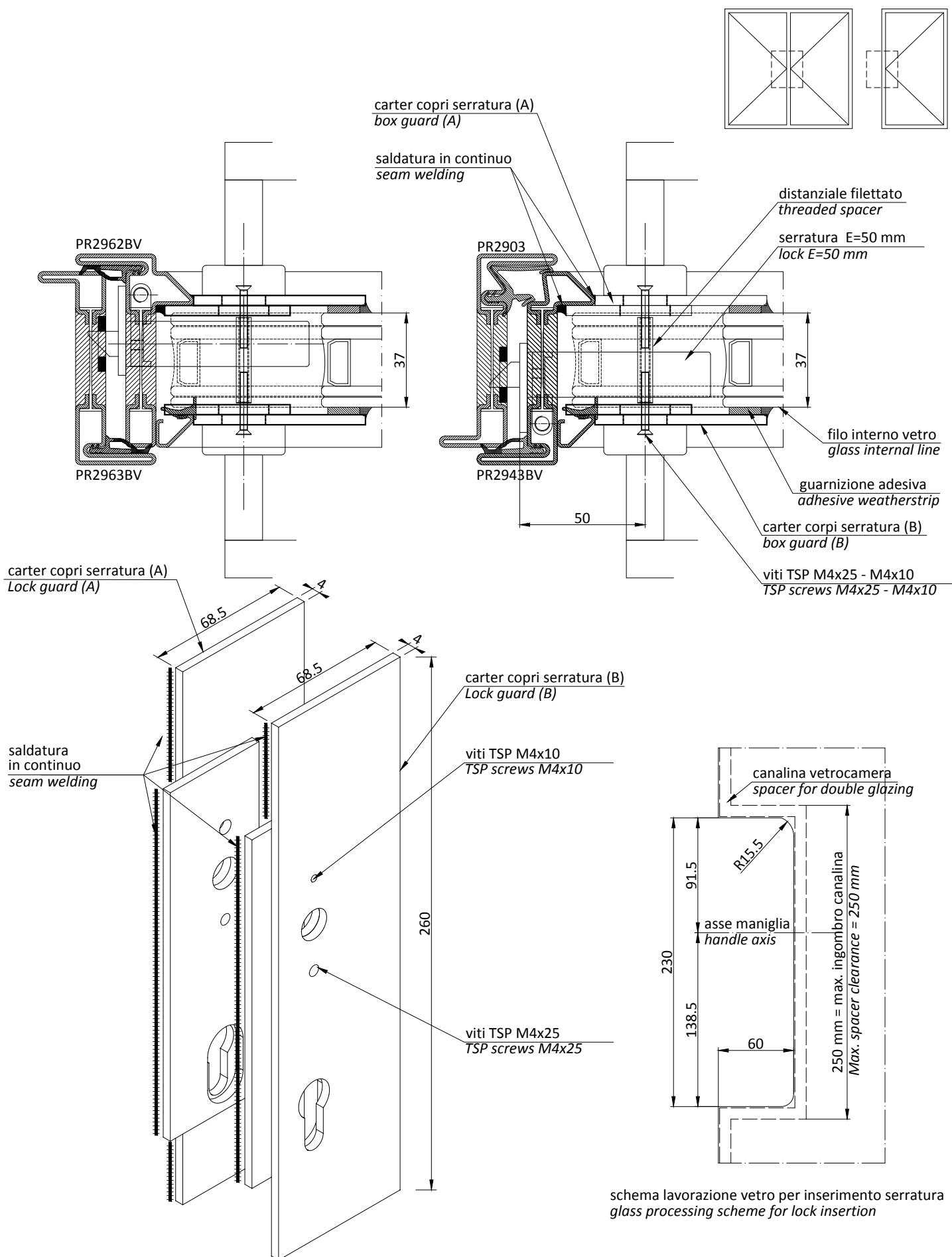
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

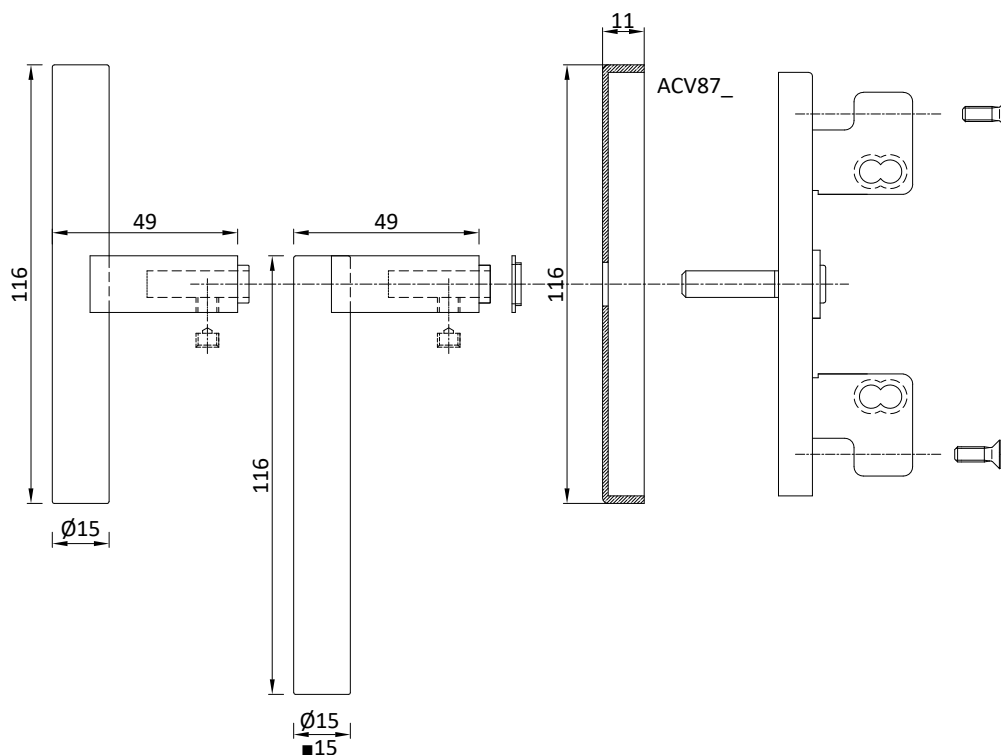
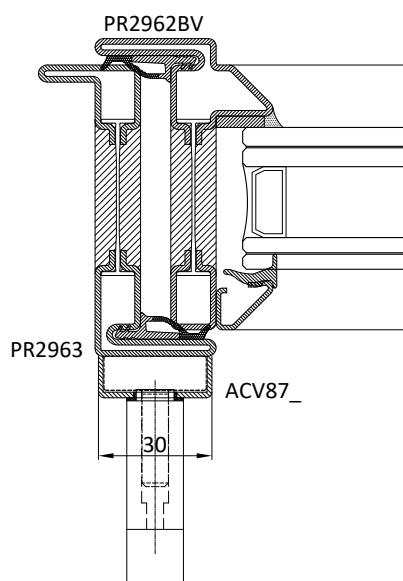
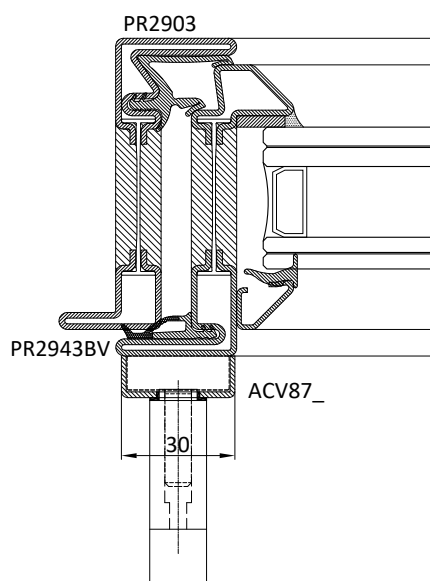
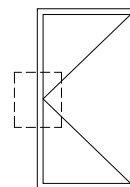


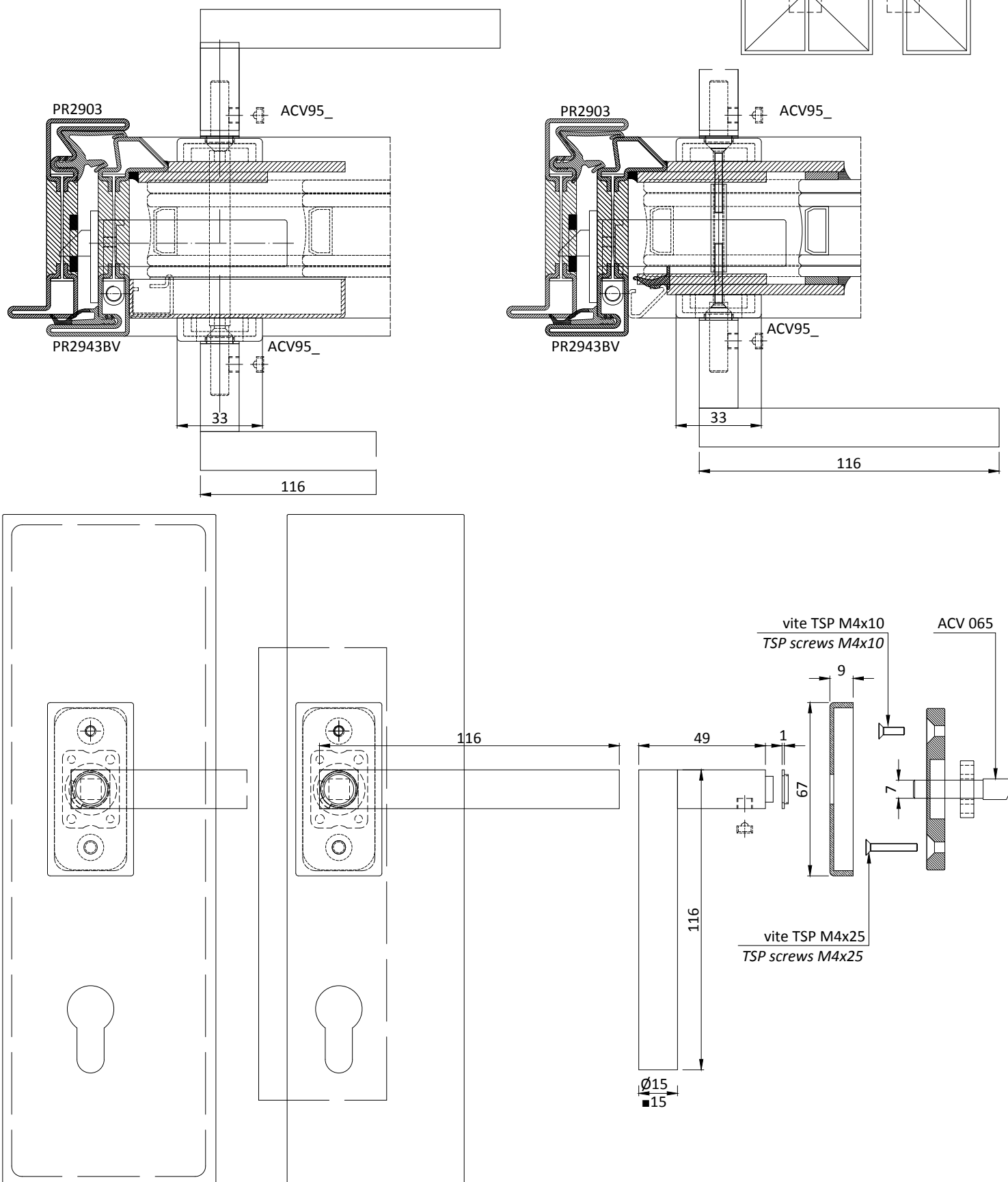
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

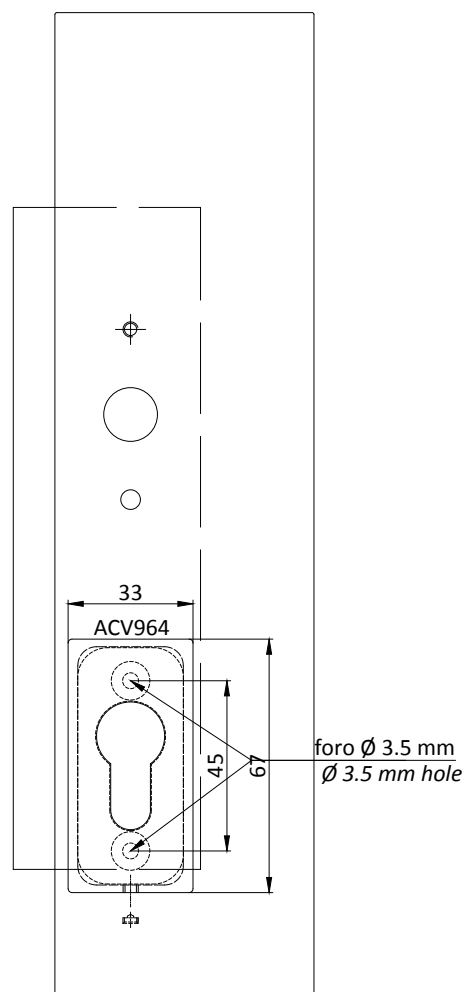
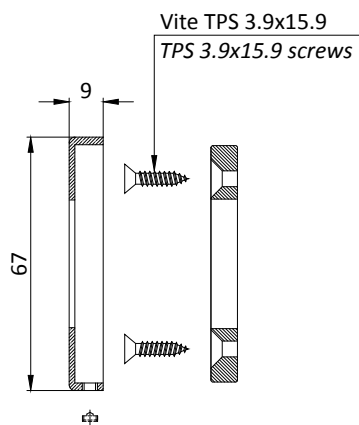
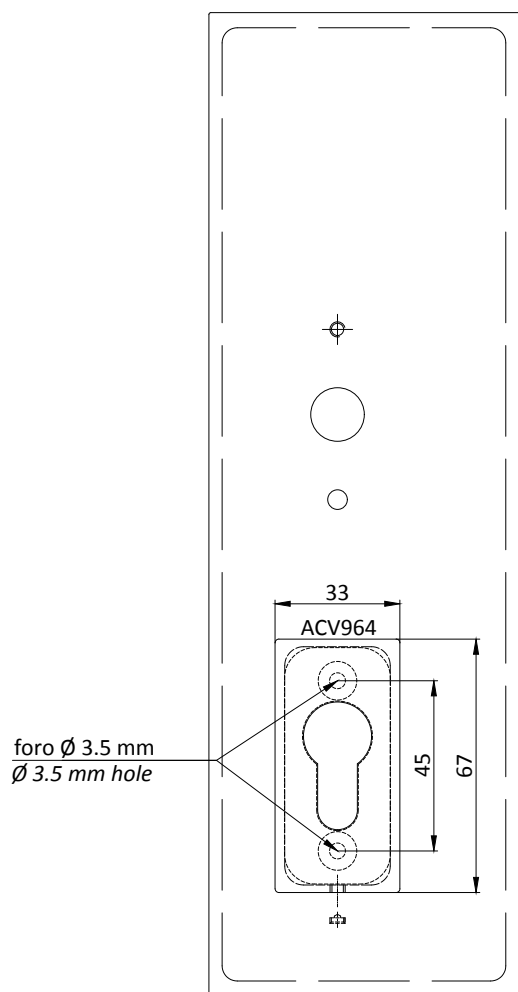
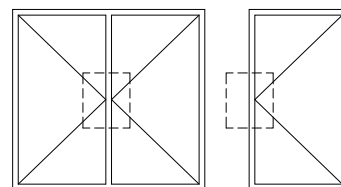
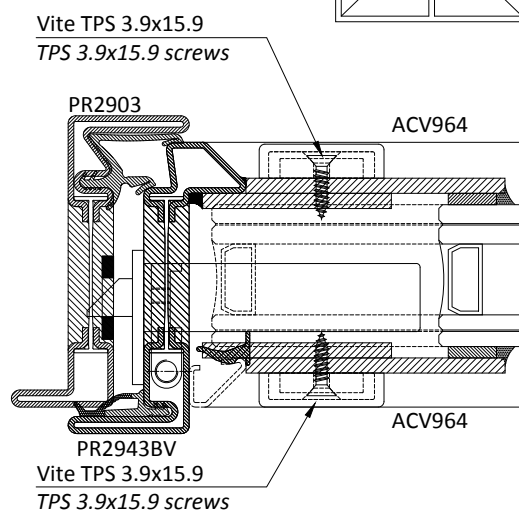
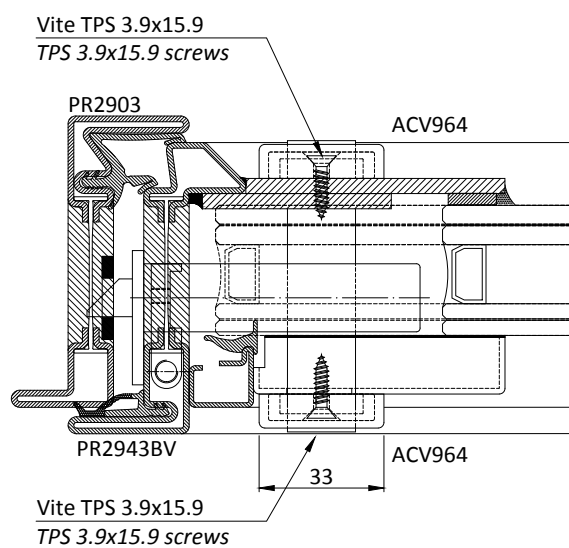






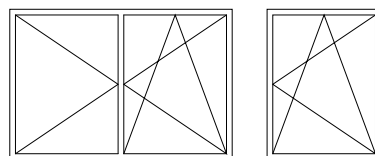


Soluzione valida anche per apertura esterna
Solution also valid for external opening

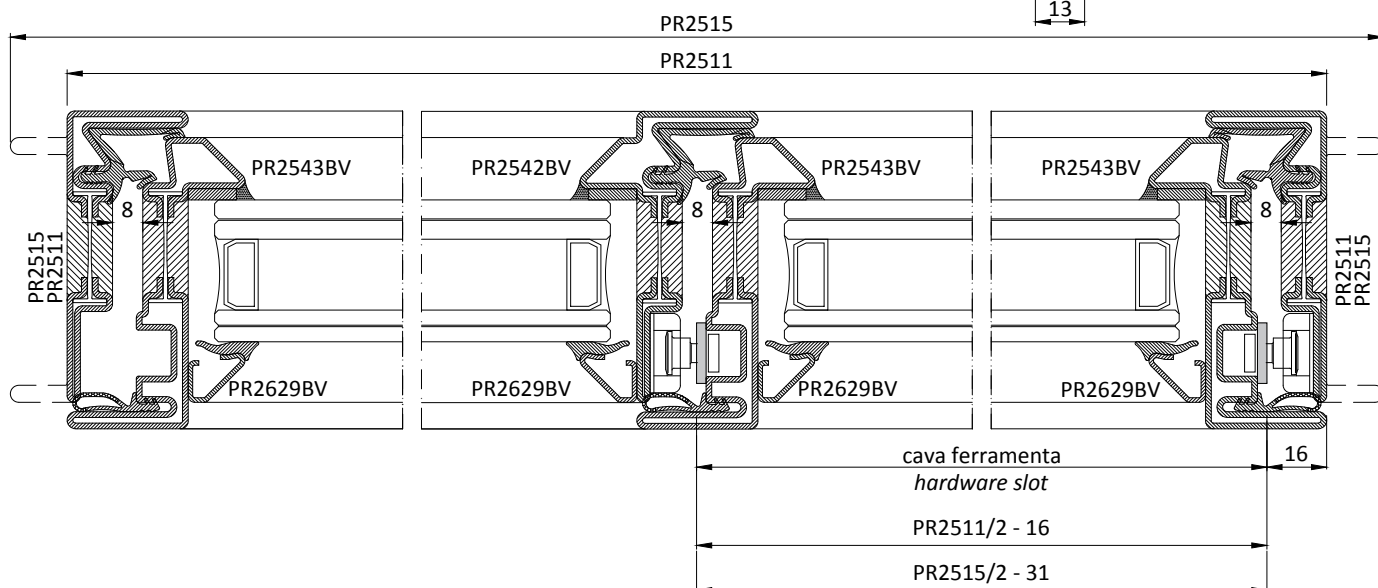
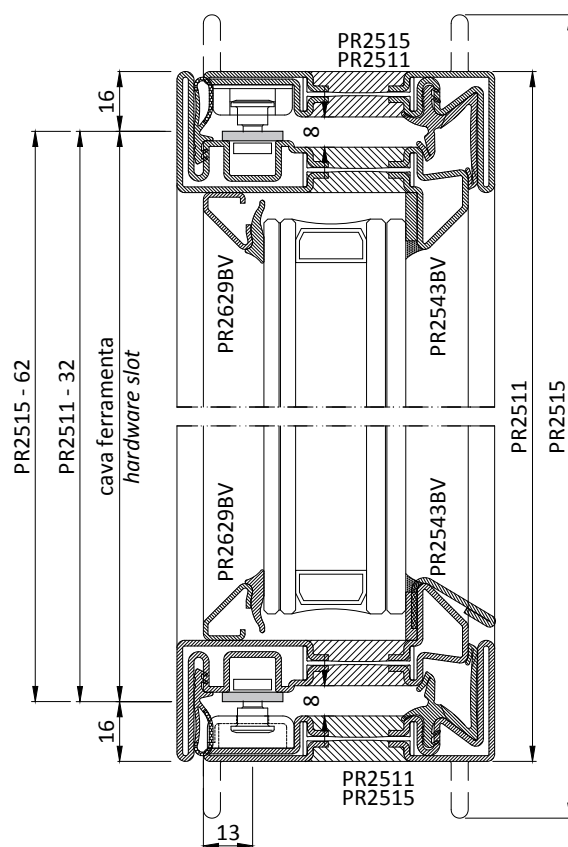
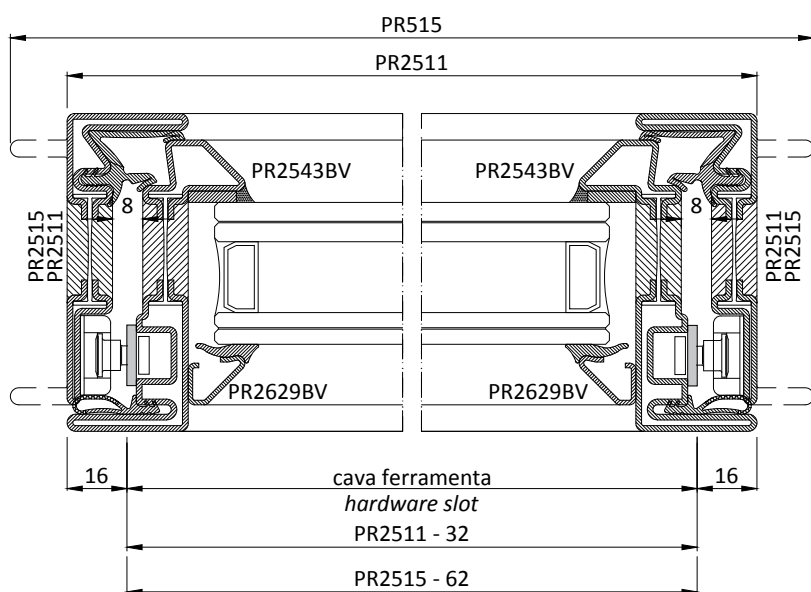


Soluzione valida anche per apertura esterna
Solution also valid for external opening

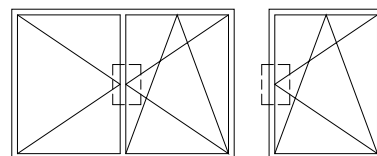
AGE581-2-5-6 130 kg Easy



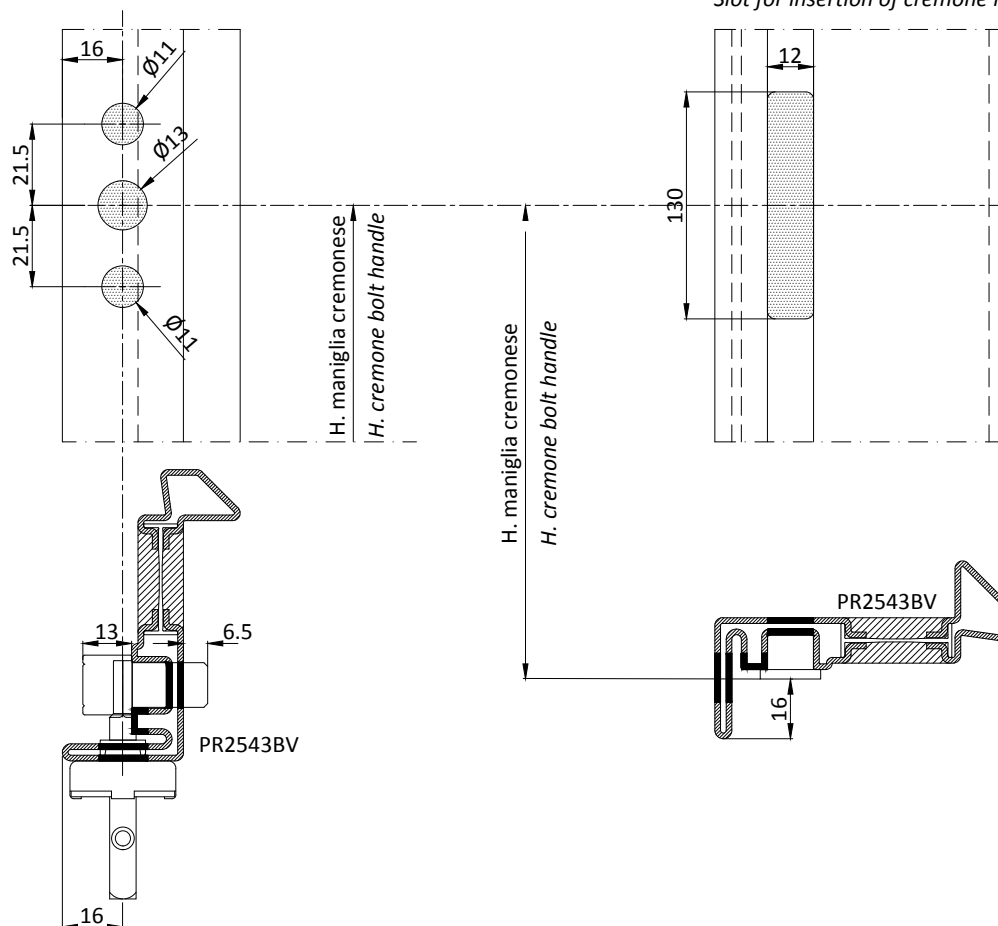
		H altezza - height											
Easy		670 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400	2401 2600	2601 2800	2801 3000
L larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1	J1	K1	L1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2	J2	K2	L2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3	J3	K3	L3
	1201-1400	-	-	-	D4	E4	-	-	-	-	-	-	-



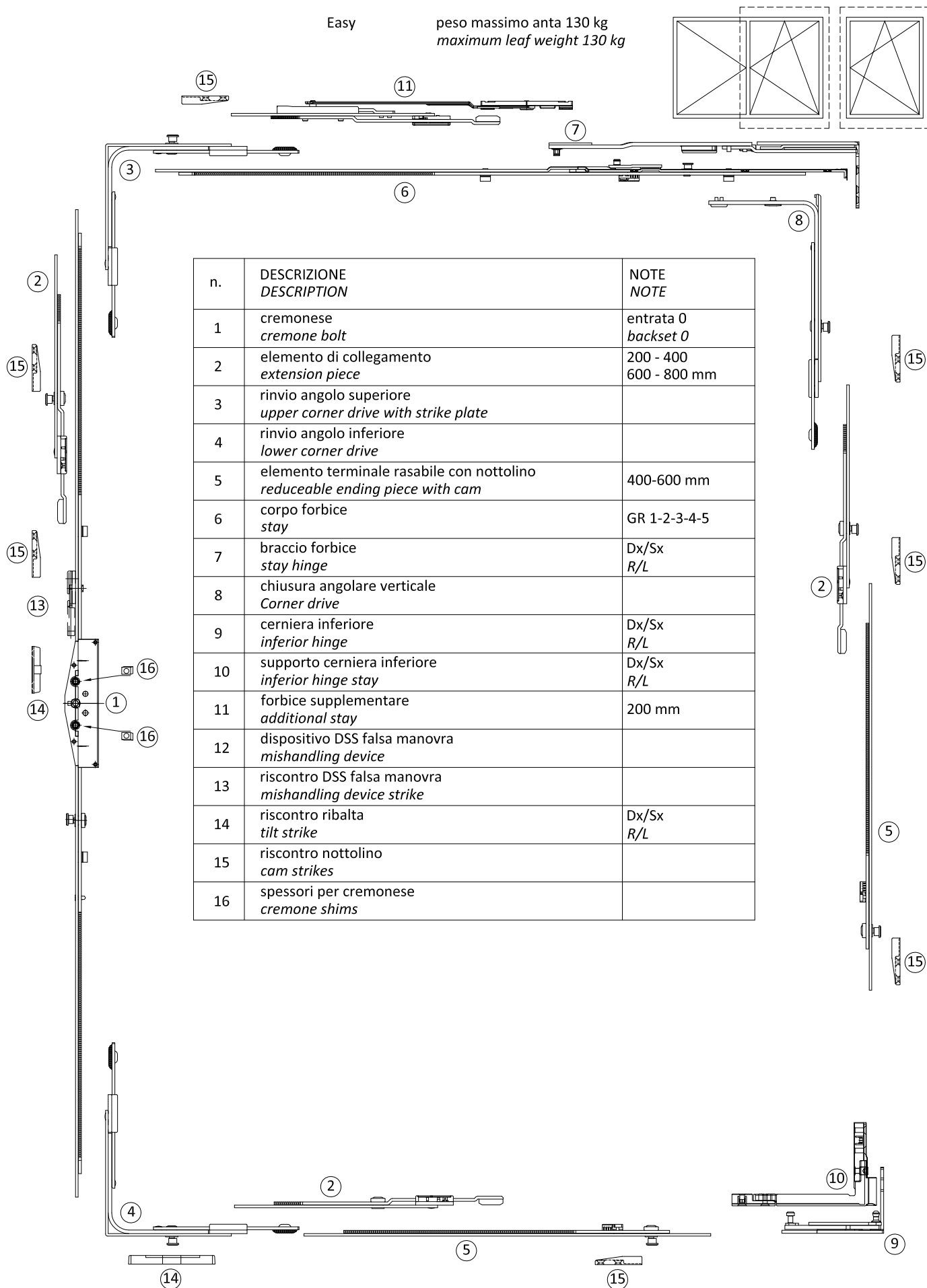
Fori per inserimento quadro comando
e fissaggio maniglia / movimento DK
holes for inserting control panel and
anchoring of handle / TT (tilt and turn)
movement



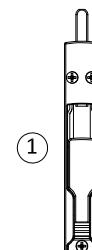
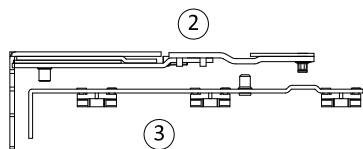
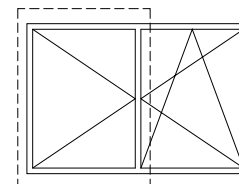
Asola per inserimento meccanismo cremonese
Slot for insertion of cremone mechanism



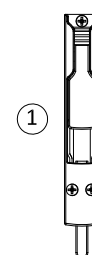
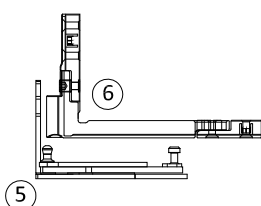
ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	H cava ferramenta - H hardware slot Easy - RC2	H maniglia cremonese H cremone bolt handle
Finestre Windows	370 → 520	H/2
	521 → 670	H/2
	671 → 860	H/2
	861 → 1000	H/2
	1001 → 1200	500
	1201 → 1400	500
	1401 → 1600	500
	1601 → 1800	500
Porte - finestre French Windows	1801 → 2000	1050
	2001 → 2200	1050
	2201 → 2400	1050
	2401 → 2600	1050
	2601 → 2800	1050
	2801 → 3000	1050

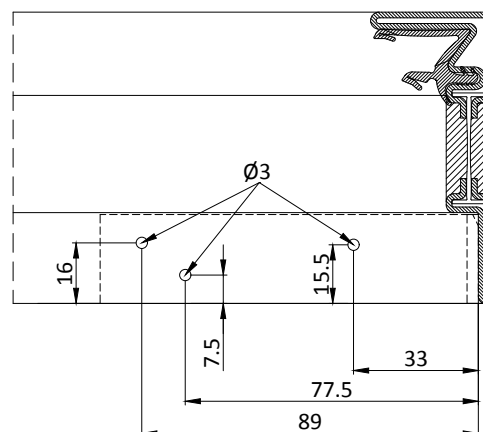
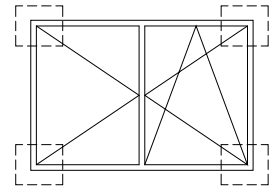
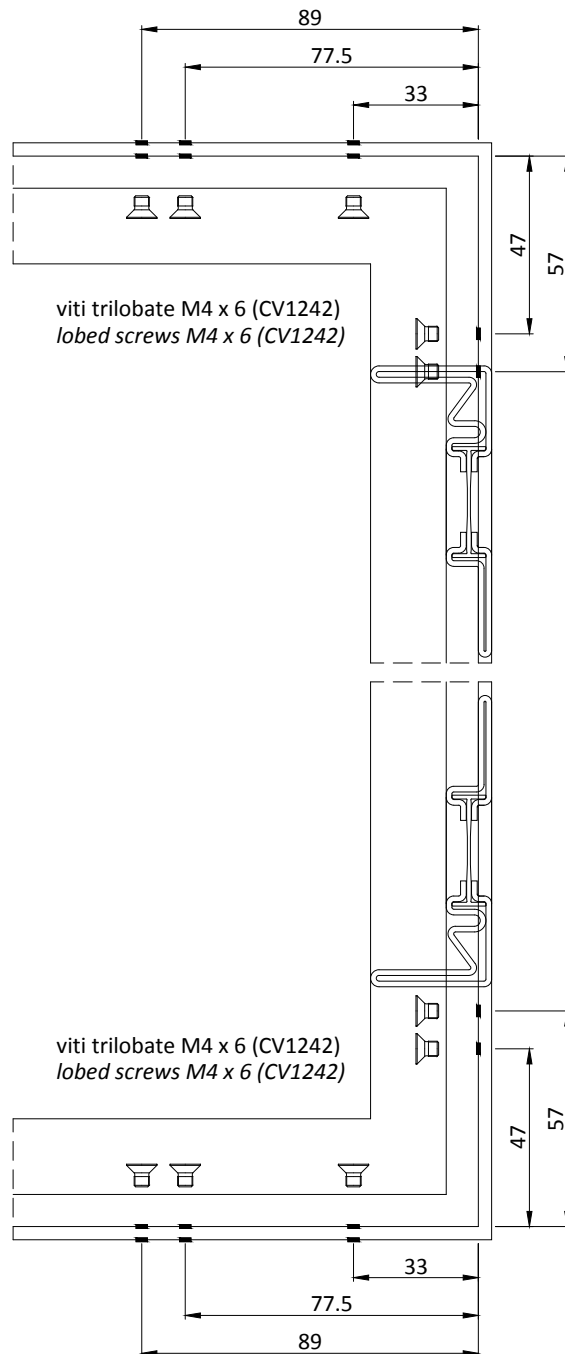
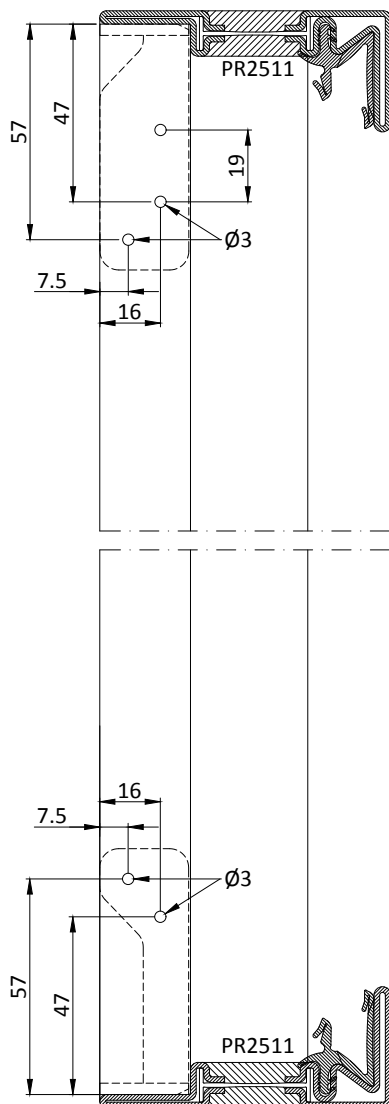


Easy

peso massimo anta 130 kg
maximum leaf weight 130 kg

n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	catenaccio seconda anta second leaf flush bolt	140-220-650-850 mm
2	cerniera superiore upper hinge	Dx/Sx R/L
3	supporto cerniera superiore upper hinge stay	Dx/Sx R/L
4	chiusura mediana lato cerniere hinge-side middle closing	
5	cerniera inferiore inferior hinge	Dx/Sx R/L
6	supporto cerniera inferiore inferior hinge stay	Dx/Sx R/L

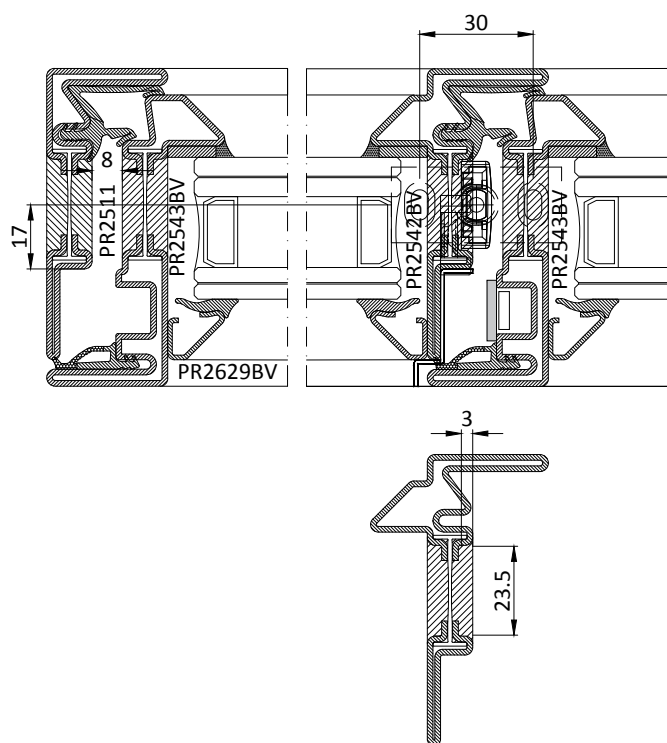




Fori eseguibili con maschera ATG281
Holes to be done with ATG281

CATENACCIO SUPERIORE - UPPER FLUSH BOLT

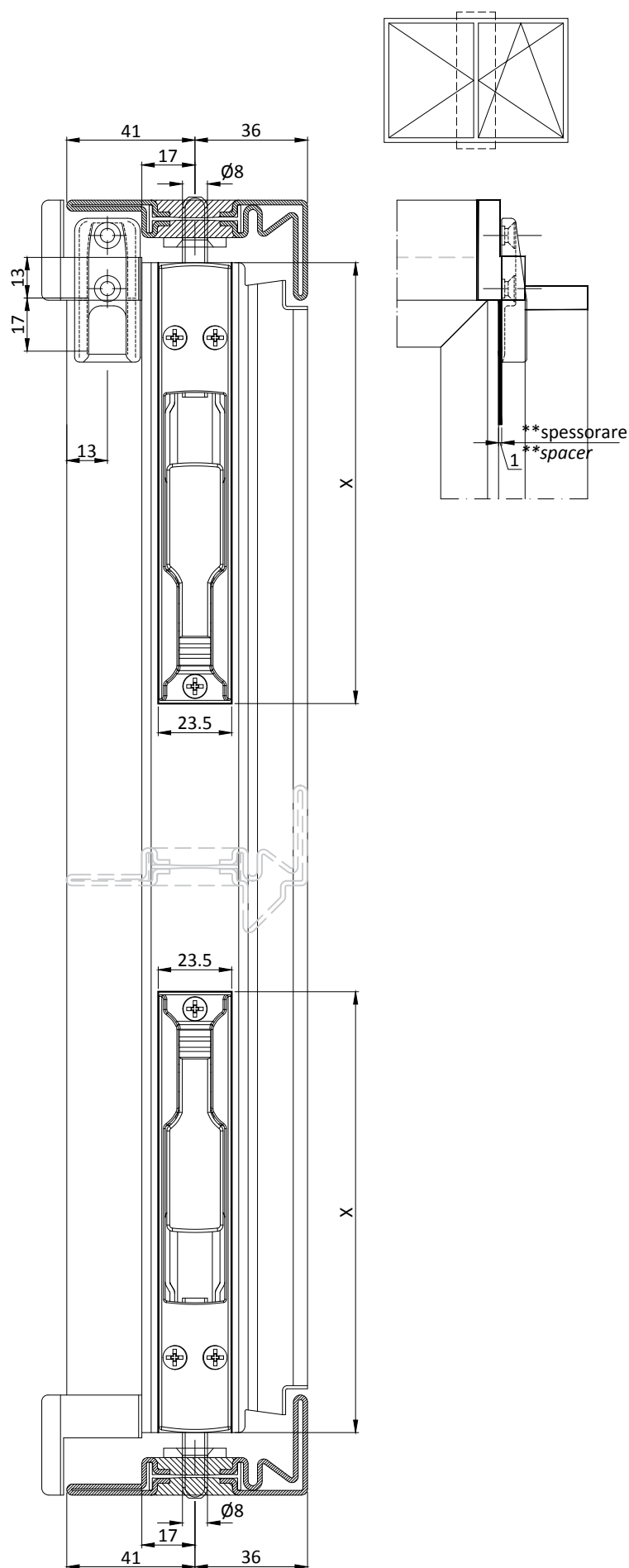
		H altezza - height					
X		480 670	671 860	861 1200	1201 1600	1601 2400	2401 3000
L	345-440	/	141	221	451	651	851
larghezza width	441-1400	141	141	221	451	651	851

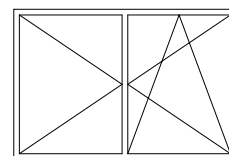


CATENACCIO INFERIORE - LOWER FLUSH BOLT

		H altezza - height			
X		480 670	671 860	861 1800	1801 3000
L	345-440	/	141	221	451
larghezza width	441-1400	141	141	221	451

- * chiusura superiore con fermo a scatto
- ** spessore non fornito
- * upper closure with snapper
- ** spacer not supplied

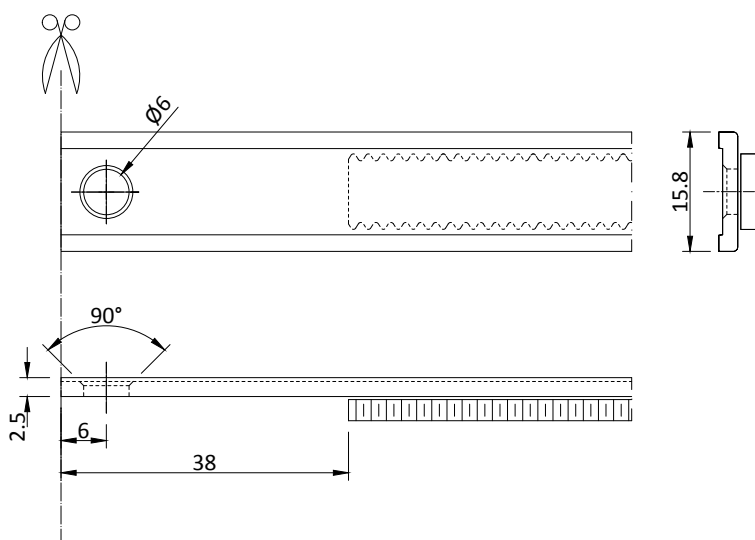




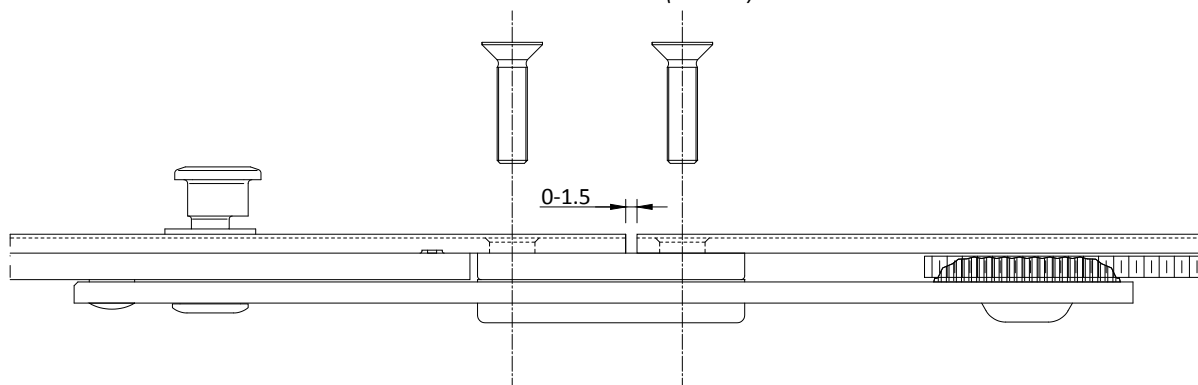
Lavorazione da eseguire sui componenti rasabili della ferramenta
Working on the cuttable pieces of the hardware

- 1 - Eseguire taglio della ferramenta sfalsato
- 2 - Eseguire foro e svasatura

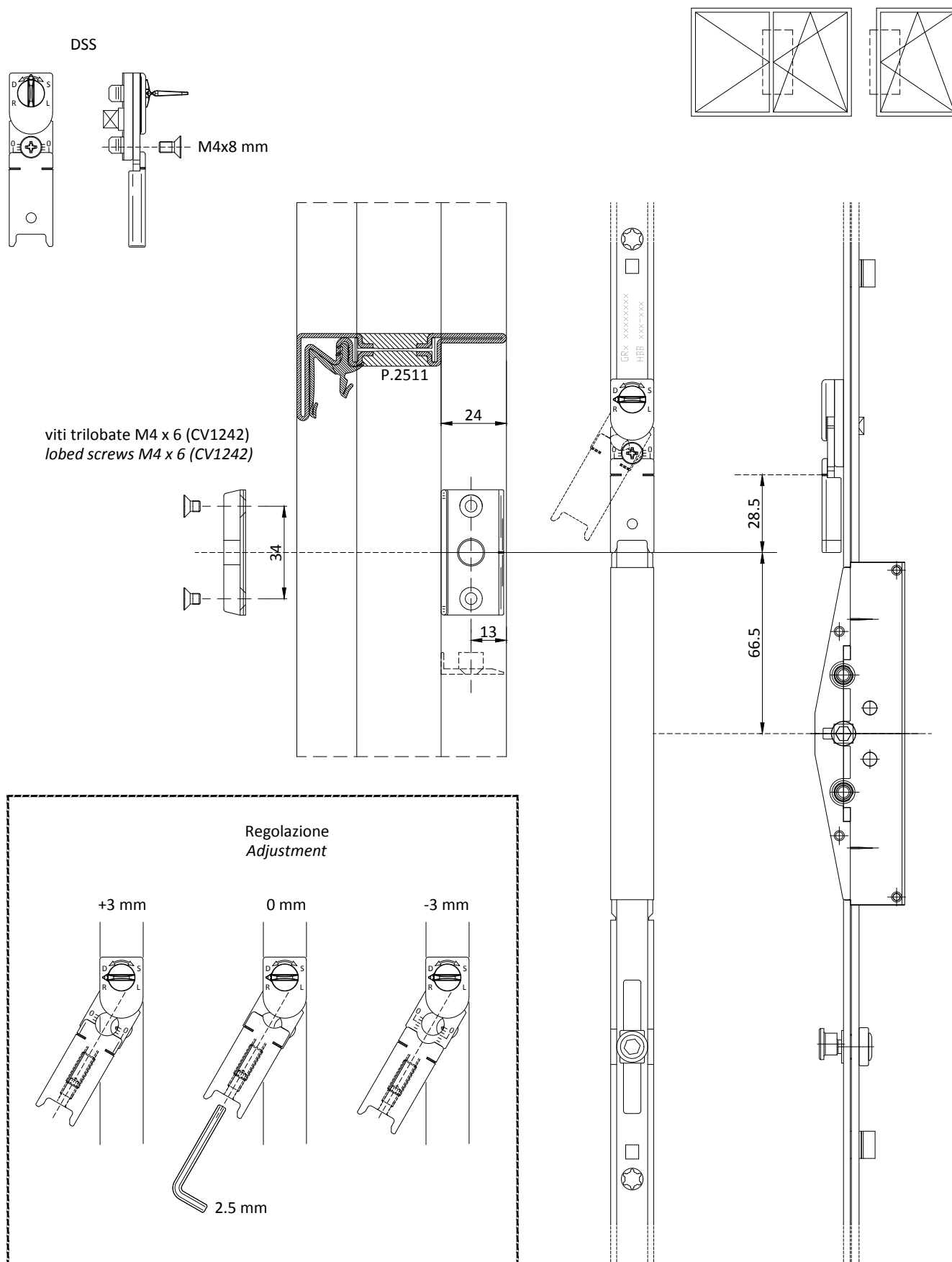
- 1 - Cutting of the hardware
- 2 - Hole drilling and countersink



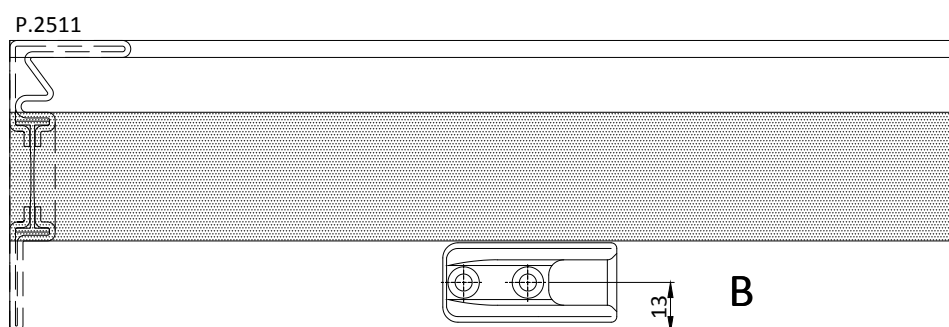
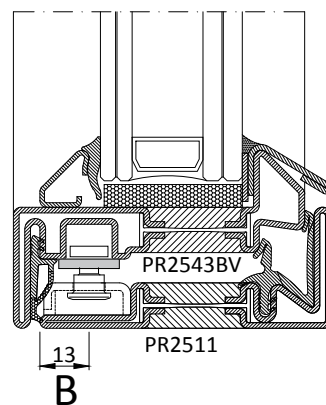
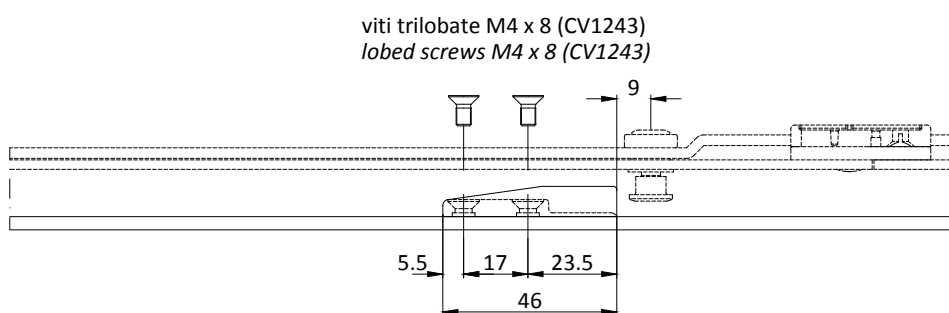
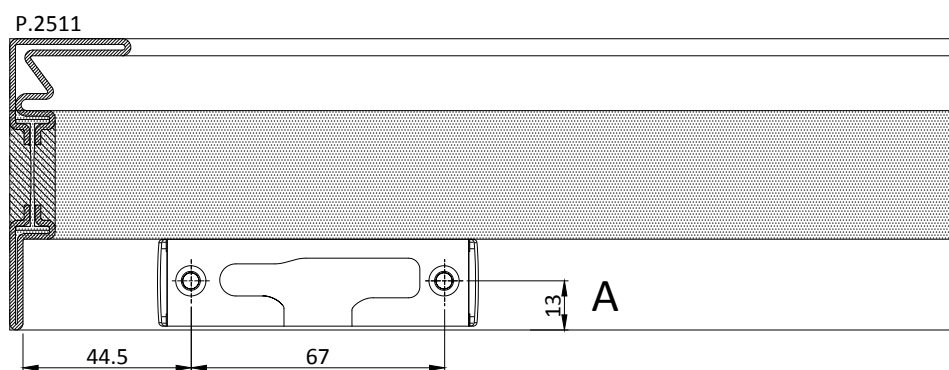
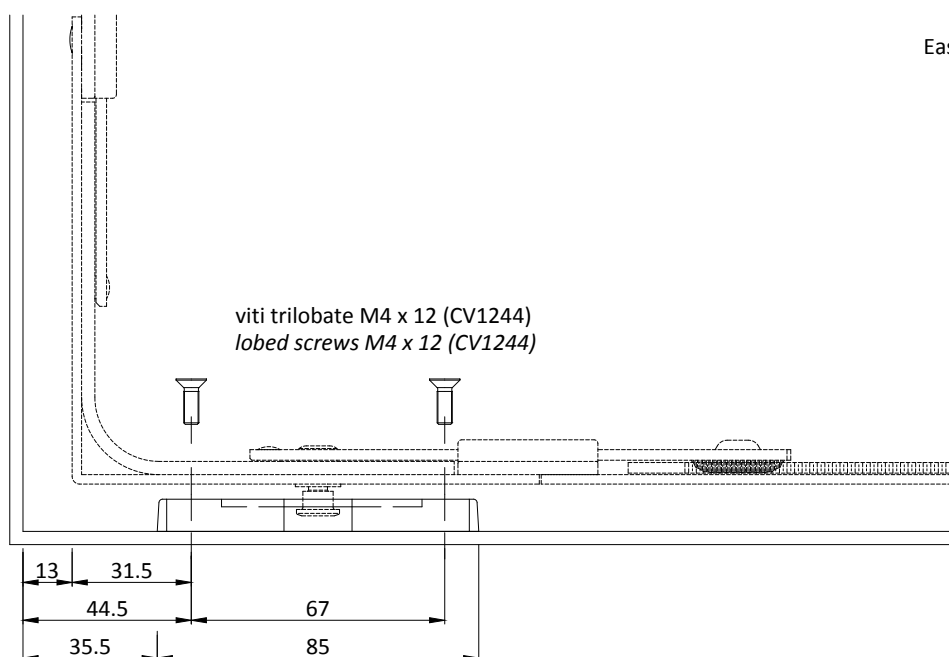
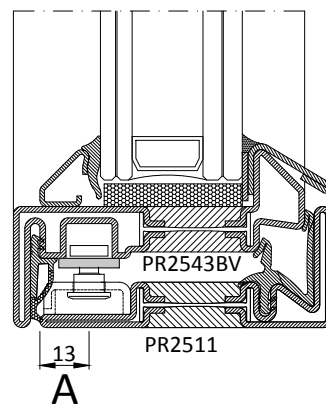
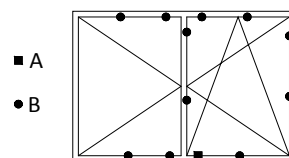
viti trilobate M4 x 16 (CV1271)
lobed screws M4 x 16 (CV1271)



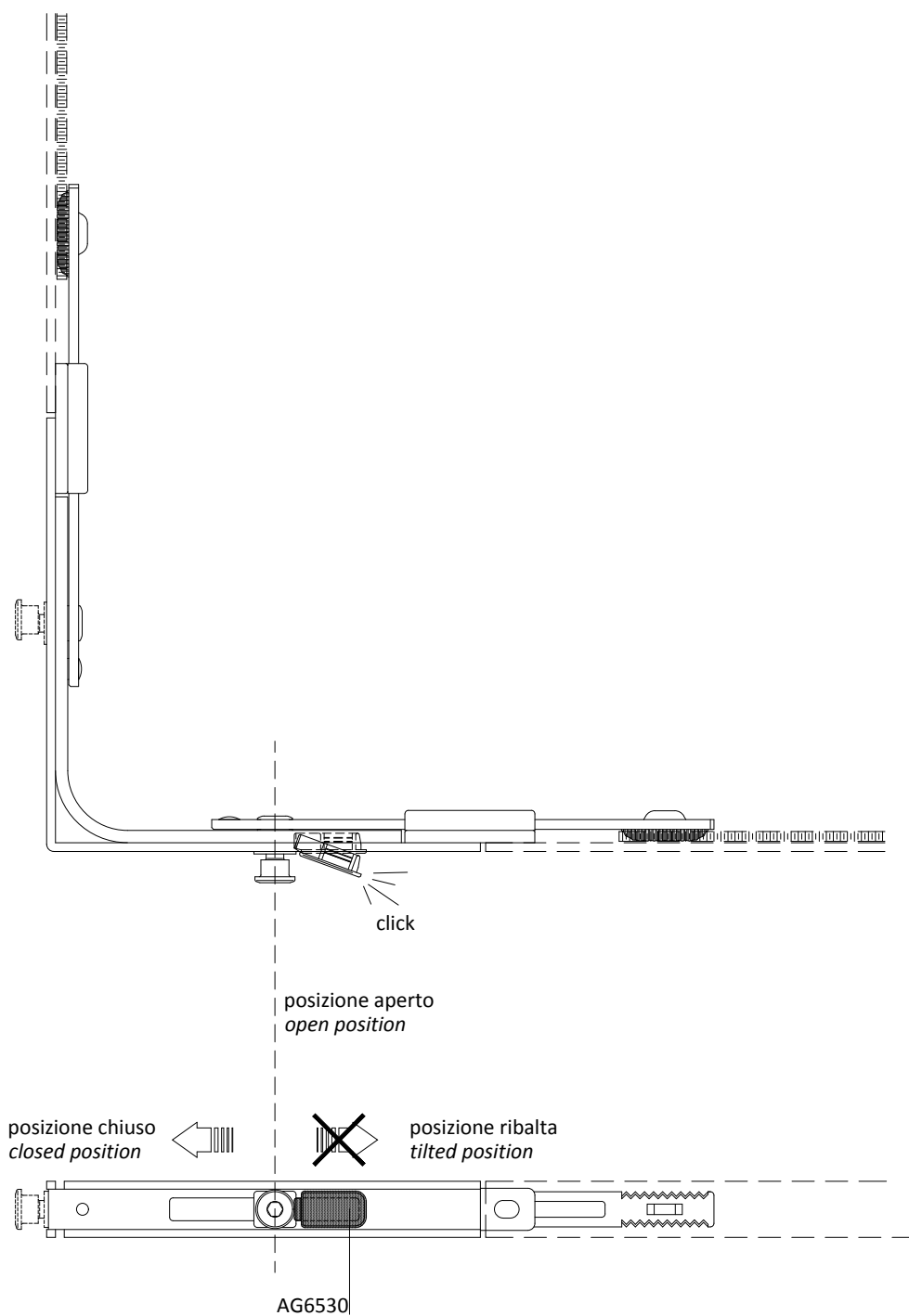
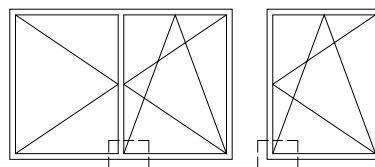
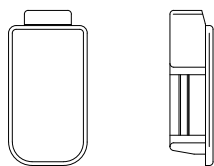
Lavorazione eseguibile con trancia ATG 311 o ATG 312
Tooling possible with punching machine ATG 311 or ATG 312



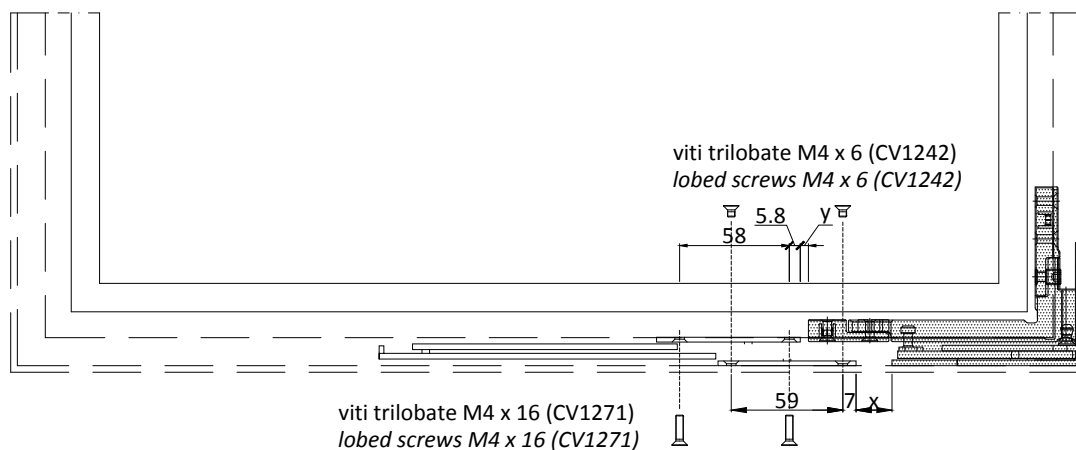
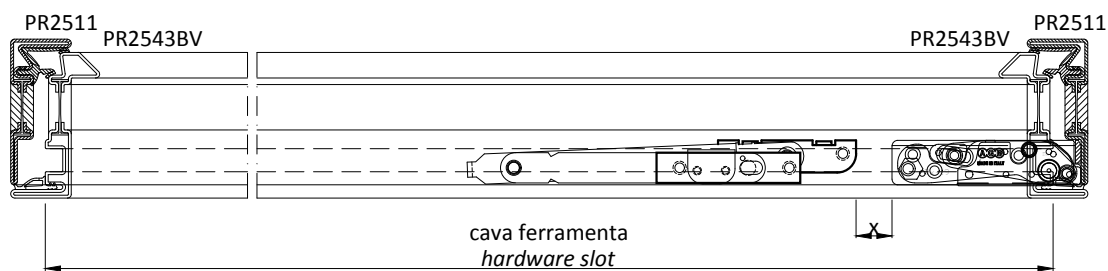
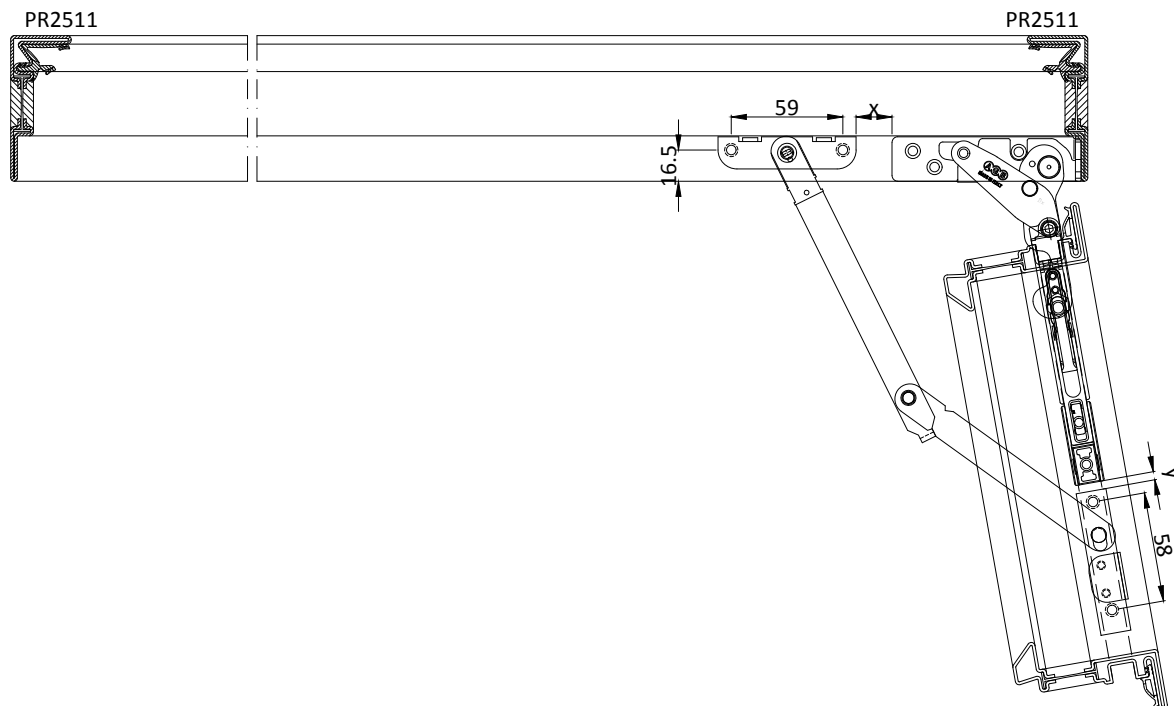
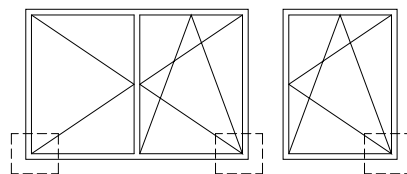
Easy

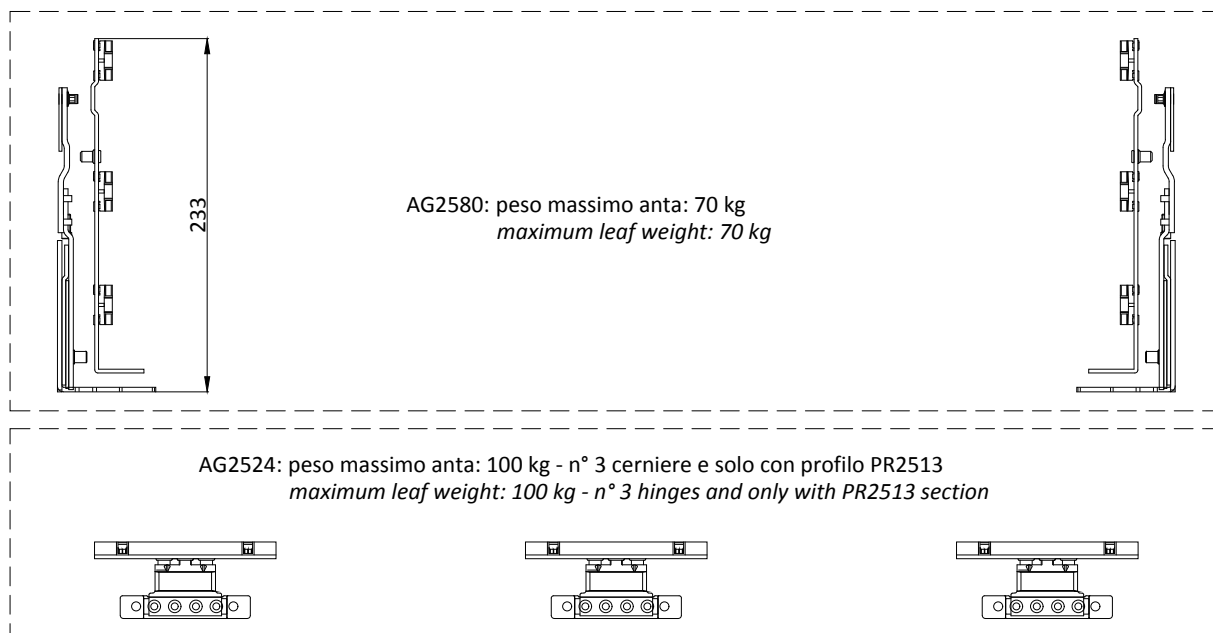
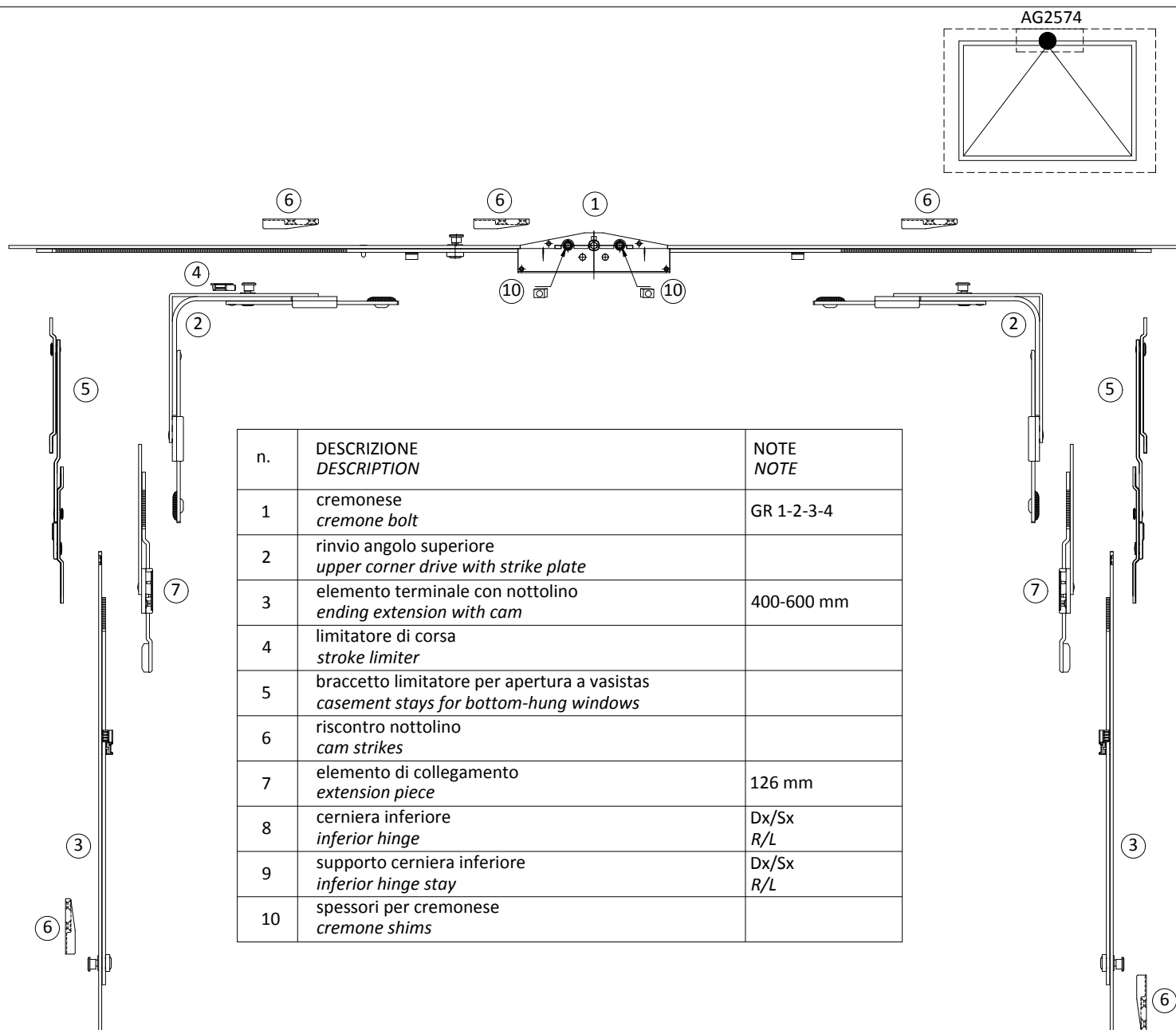


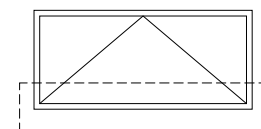
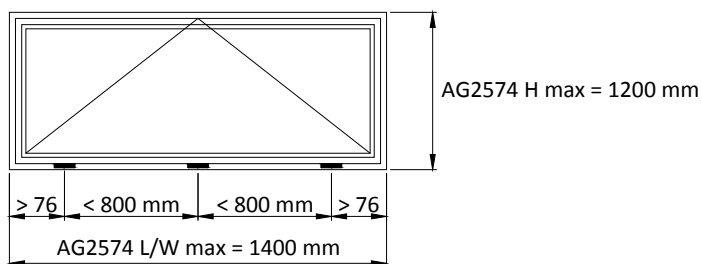
AG6530



α	x [mm]	y [mm]	min. cava ferramenta hardware slot min. [mm]
90°	31	16.3	450
100°	19	4.3	450



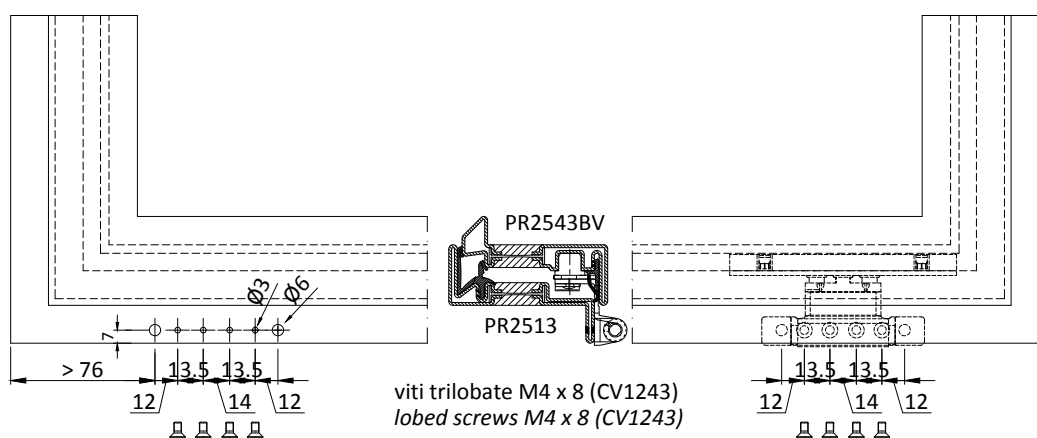
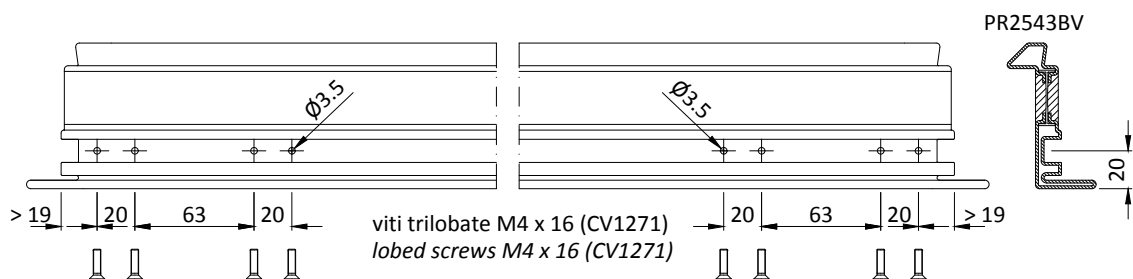
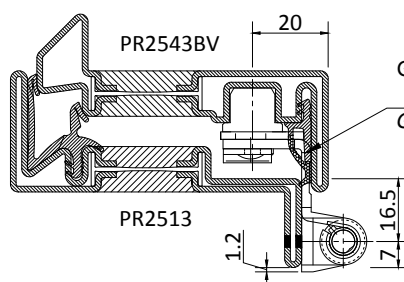


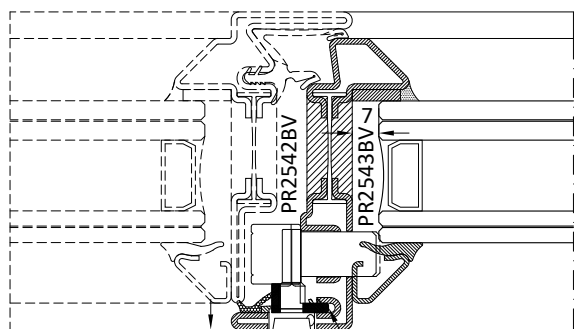
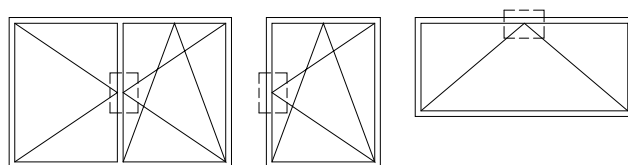
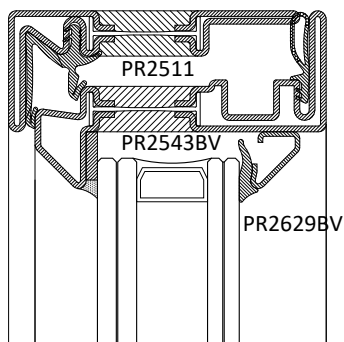


solo con profilo PR2513
only with PR2513 section

2 cerniere
peso massimo anta 70 kg
3 cerniere
peso massimo anta 100 kg

2 hinges
maximum leaf weight 70 kg
3 hinges
maximum leaf weight 100 kg



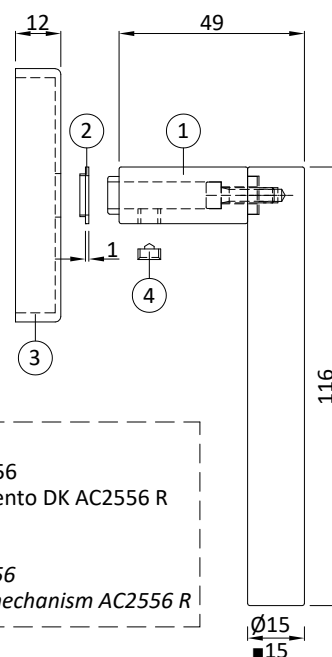
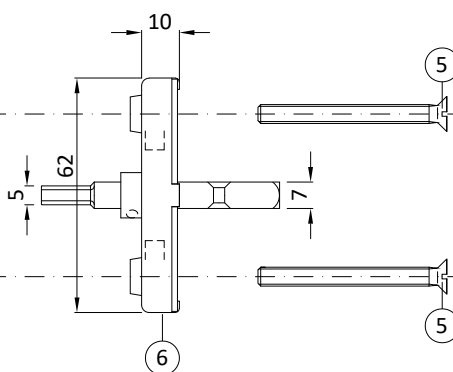
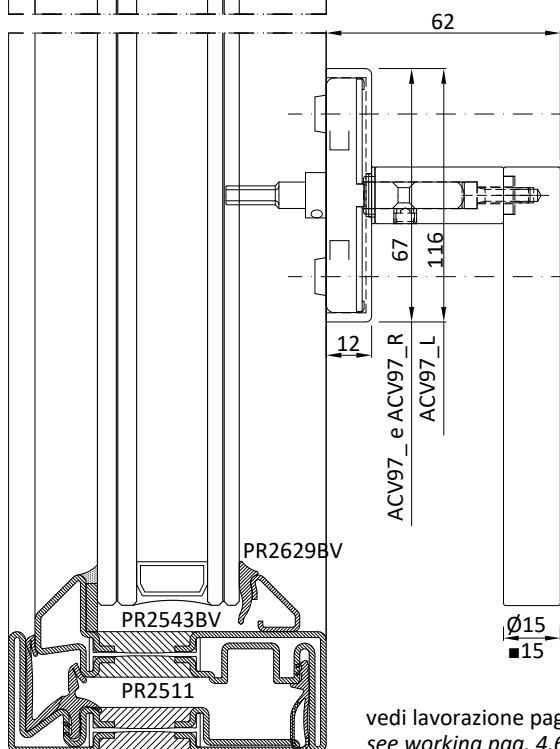
AC2556
AC2556Rspessore viti cremonese
cremone screws shim

ACV97- :

- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Vite TP M5x50 (non fornite)
- 6) Movimento DK

ACV97- :

- 1) Handle grip
- 2) Ring
- 3) Rose
- 4) Dowel M6x6
- 5) Flat head screws M5x50 (not supplied)
- 6) Tilt-turn movement



ATTENZIONE

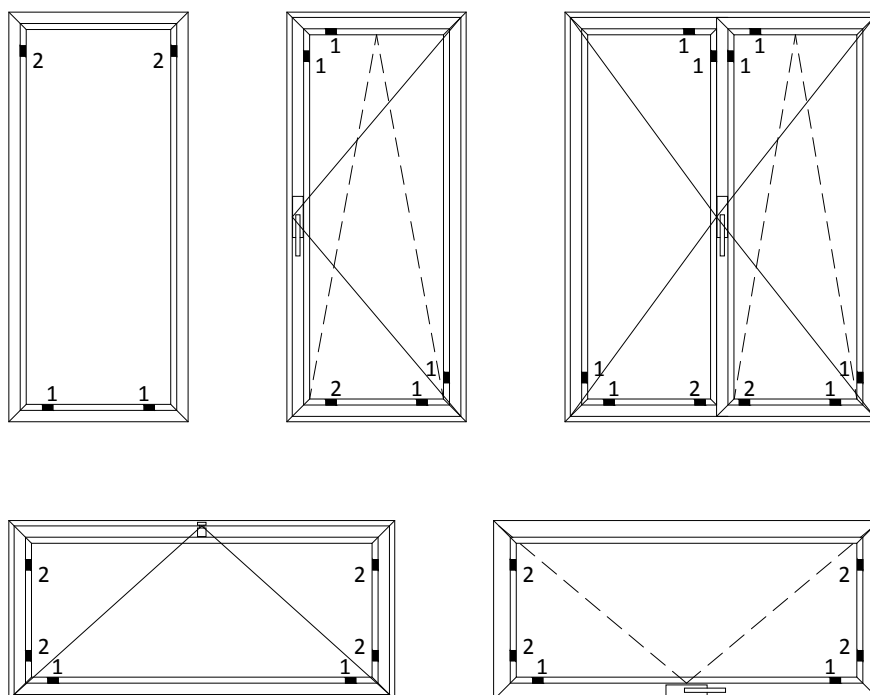
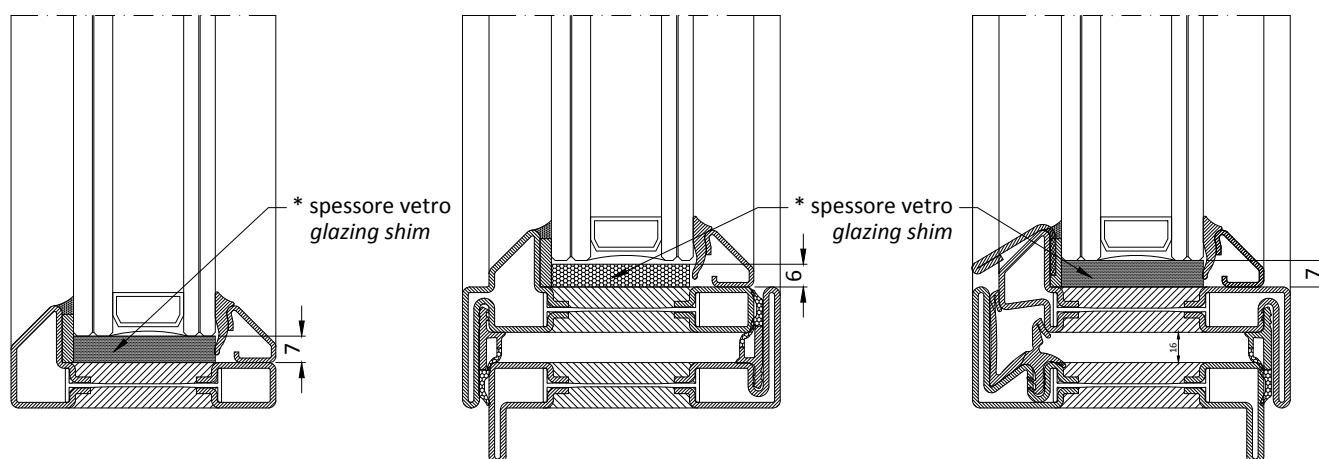
Con maniglie ACV97_ movimento DK AC2556
Con maniglie ACV97_R e ACV97_L movimento DK AC2556 R

ATTENTION

With handles ACV97_ DK mechanism AC2556
With handles ACV97_R and ACV97_L DK mechanism AC2556 R

vedi lavorazione pag 4.6.2
see working pag. 4.6.2

Finestra | Window

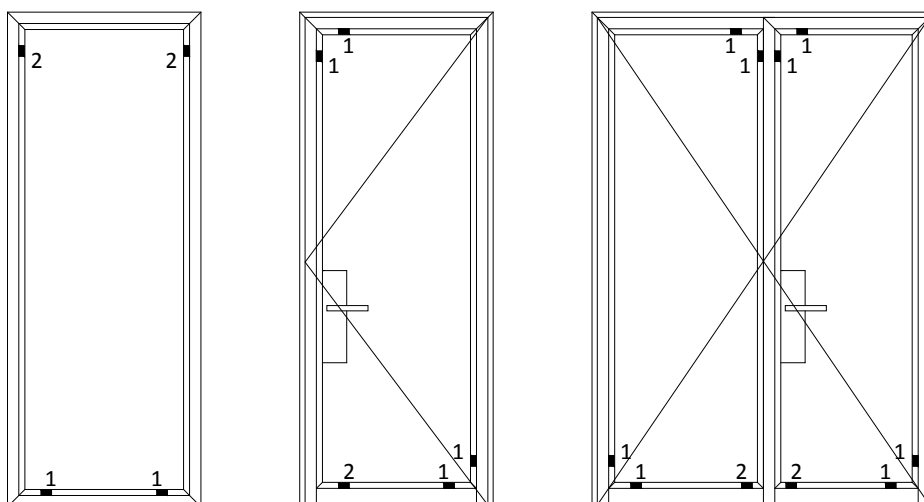
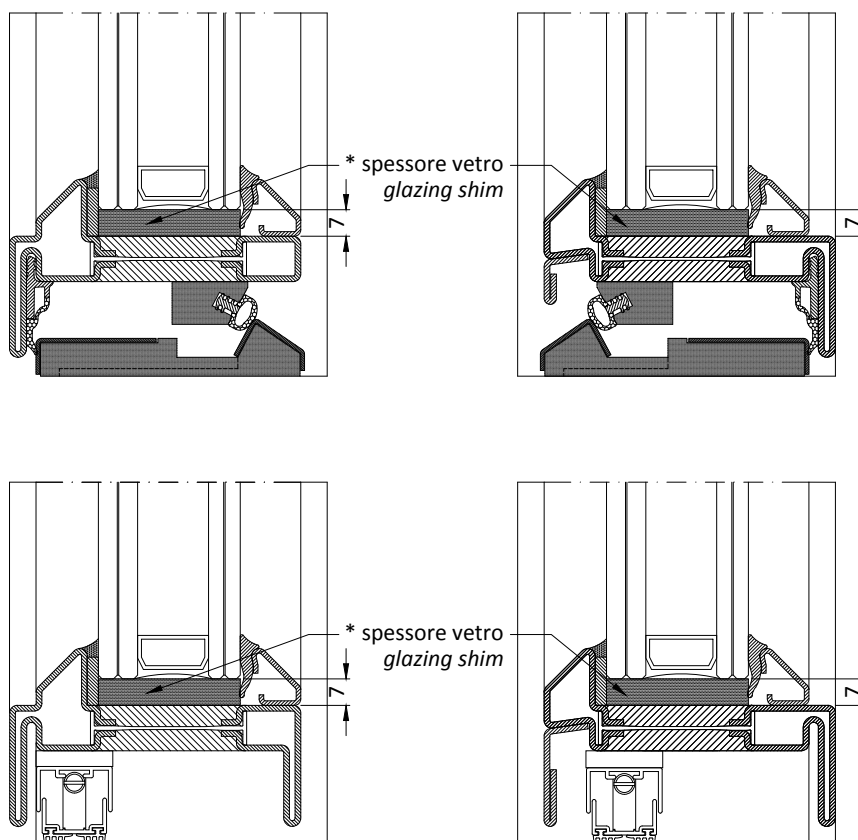
1) spessore portante | *carry shim*2) spessore distanziatore | *compensation shim*

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 glass 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*

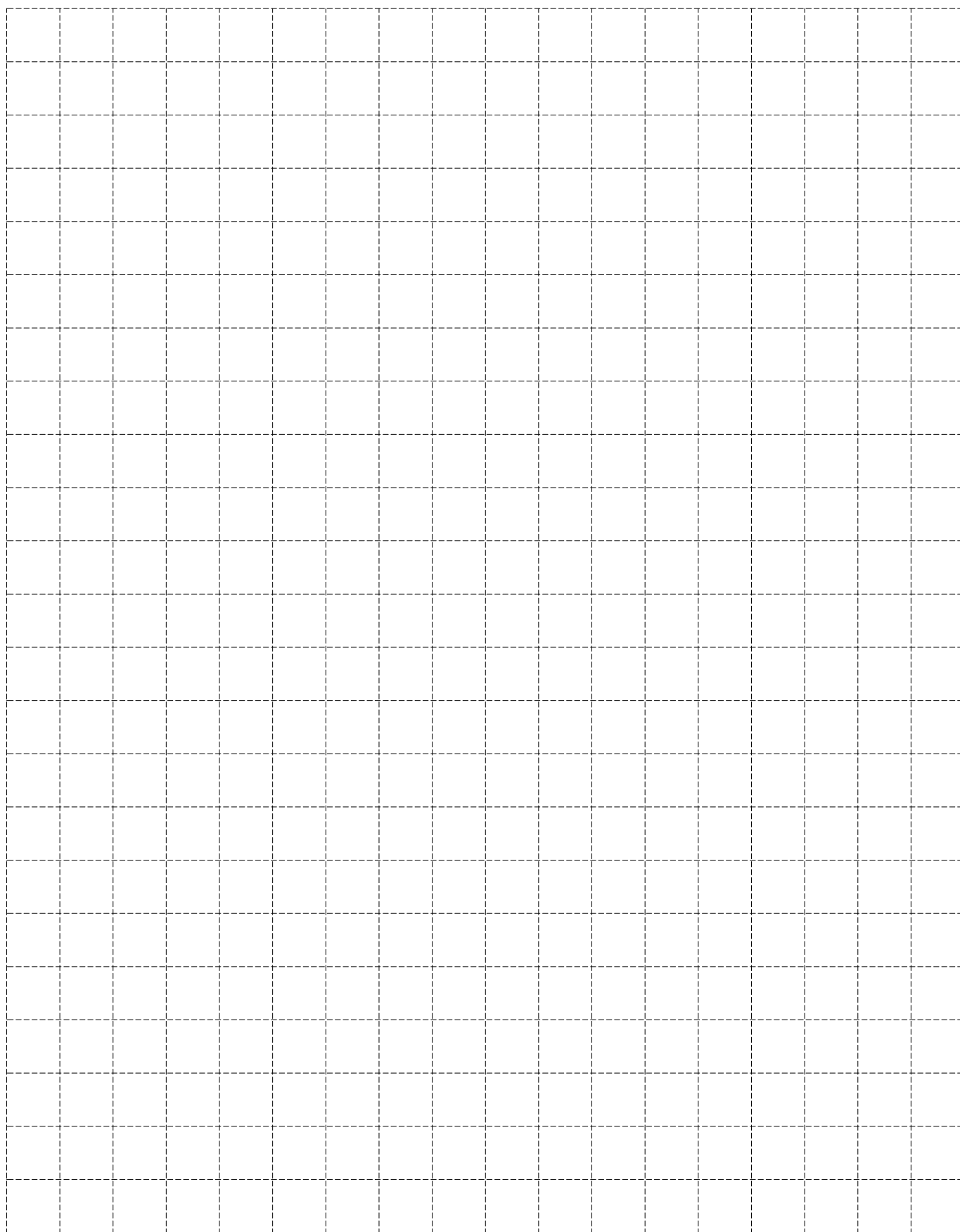
Porta | Door

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 ideali 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

BV 75 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. 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 BV 75 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+AT2900BV) 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 BV 75 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 BV 75 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 (SA1024/33). 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 m² 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 contro telaio/muratura esistente e alle dimensioni degli elementi da installare. Al termine dell'installazione si verifici 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 telaio 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

BV 75 is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm. 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

BV 75 profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. BV 75 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+AT2900BV) 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 $-1^\circ/+1^\circ$. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

Welding

BV 75 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 DPLs 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

BV 75 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024/33). 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

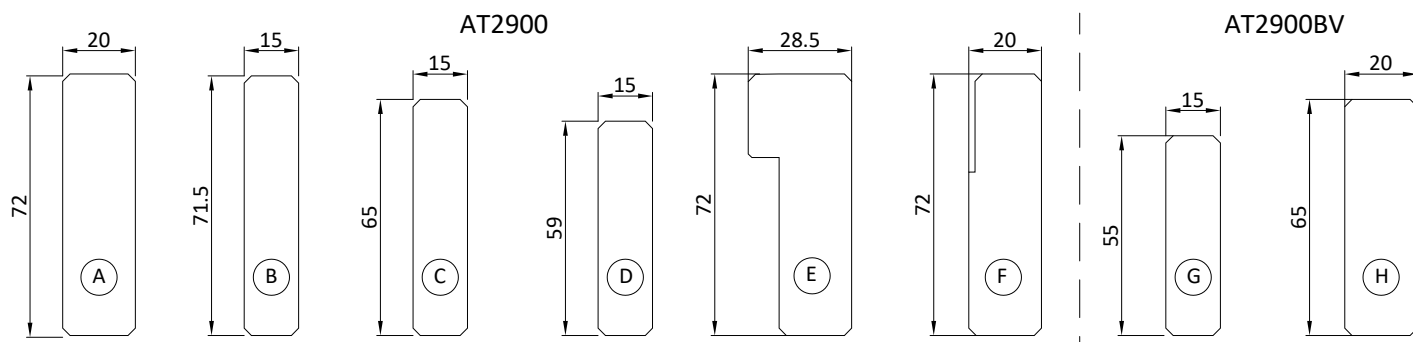
The glazing unit is secured by means of glazing beads which must be fixed by pressure with the dedicated clips or bushings to then fit the appropriate gasket.

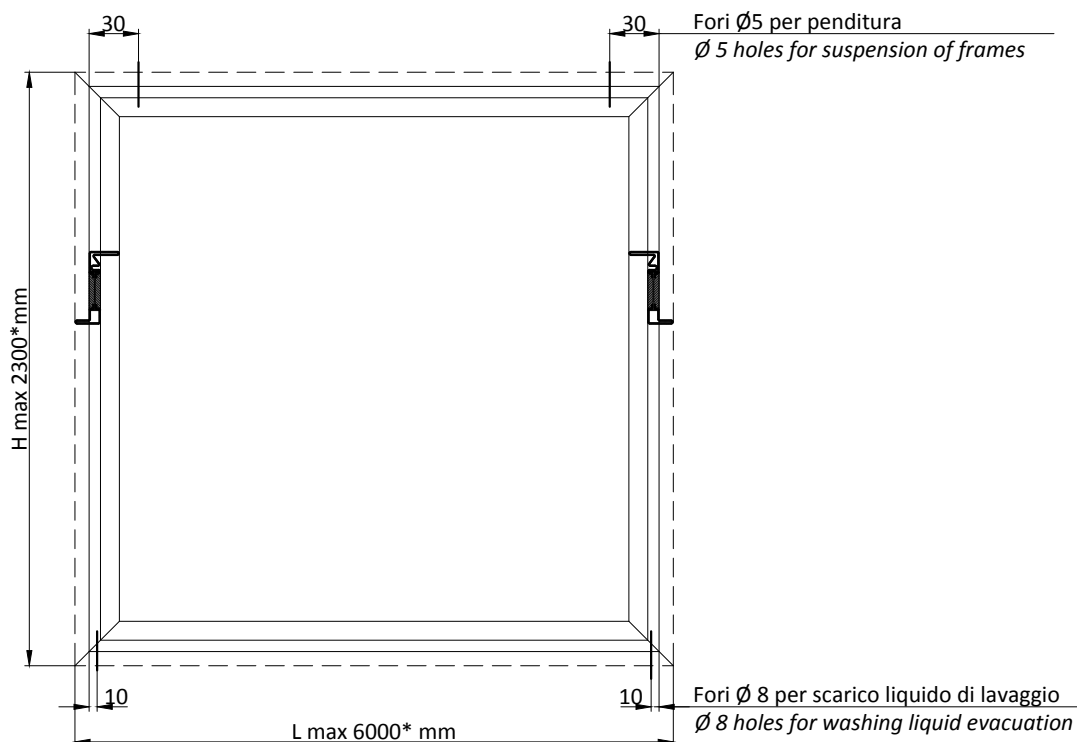
Externally, the glazing unit must be sealed with GE2606 or by applying silicone on the whole perimeter (the latter is recommended when the glazed surface is greater than 1 sqm in order to guarantee a higher rigidity of the glazing unit).

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

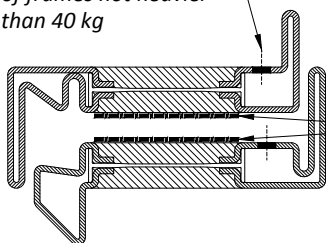
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, 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.



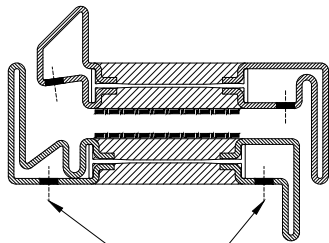


Fori Ø5 per pendinatura
telai con peso inferiore
a 40 kg

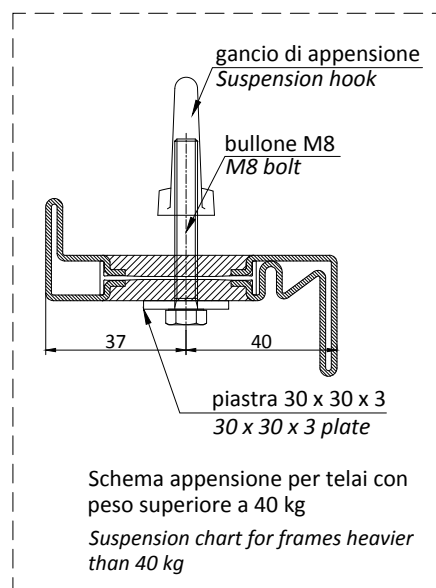
Ø 5 holes for suspension
of frames not heavier
than 40 kg



SOLO PER VERNICIATURA
Nastro adesivo protettivo da
25 mm. resistente alle alte
temperature (220-230°)
ONLY FOR PAINTING
Protective 25 mm tape resistant
to high temperatures (220-230°)



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



SOLO PER BRUNITURA

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

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

ONLY FOR BURNISHING

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

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

* Dimensioni massime disponibili nell'impianto di Secco Sistemi
Maximum available size in the Secco Sistemi plant

Troncatricecaratteristiche minime della macchina

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

caratteristiche della lama

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

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

Pantografocaratteristiche minime della macchina

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

caratteristiche minime delle frese

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

Foraturemontaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

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

fresatura di cave e asole sui profili inox

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

CutterMinimum requirements for the use of the machine

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

Blade specifications

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

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

PhantographMinimum requirements for the use of the machine

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

Minimum requirements for the use of a milling machine

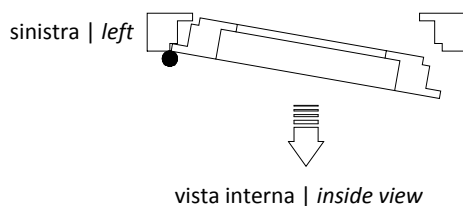
- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

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

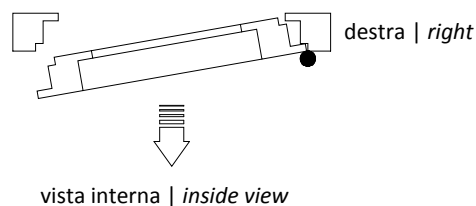
- Use a HSS drill. The diameter of the drill is indicated in the technical note;
- Thread the hole with self-threading zinc-plated screws with the same diameter as the stainless steel screw provided with the kit;
- Position and secure the item with the stainless steel screws provided.

Milling slots and loops in the profiles

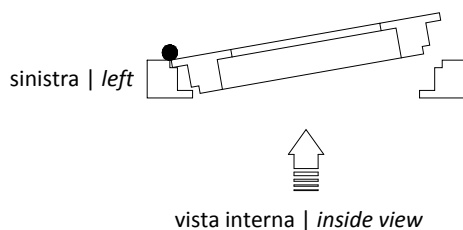
- Use machines designed for steel processing (pantographs or milling machines);
- Max rpm setting (3000 rpm);
- Use milling machines with a diameter no bigger than 8 mm and with 4 HSS steel blades;
- Exceed with lubrication, mainly on the machine;
- Processed slowly until the milling is as clean as possible;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

APERTURA INTERNA | INWARD OPENING

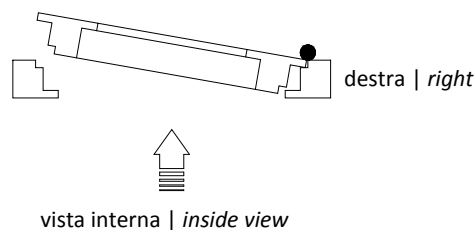
Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2624S	PR2943BV-PR2642BV
AC2625S	PR2943BV
Cerniere Hinges	
AC2649ISED	PR2943BV
Serratura multipunto Multi-lock set	
AC2694S	PR2943BV



Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2624D	PR2943BV-PR2642BV
AC2625D	PR2943BV
Cerniere Hinges	
AC2649IDES	PR2943BV
Serratura multipunto Multi-lock set	
AC2694D	PR2943BV

APERTURA ESTERNA | OUTWARD OPENING

Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2683S	PR2962BV
AC2684S	PR2962BV-PR2963BV
Cerniere Hinges	
AC2649IDES	PR2962BV
Serratura multipunto Multi-lock set	
AC2694D	PR2962BV



Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2683 D	PR2962BV
AC2684 D	PR2962BV-PR2963BV
Cerniere Hinges	
AC2649ISED	PR2962BV
Serratura multipunto Multi-lock set	
AC2694S	PR2962BV

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°

3. Lavorazioni su barra / Section processing

Finestra / Window	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648/ACB648 sez 4.3.24		AC2648/ACB648 sez 4.3.25	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649 sez 4.3.26		AC2649 sez 4.3.27	
Fori e asole per cremonese anta singola <i>Single leaf windows espagnolette holes</i>	AC2625 sez 4.3.15		AC2683 sez 4.3.16-17	
Fori e asole per cremonese anta doppia <i>Double leaf windows espagnolette holes</i>	AC2624 sez 4.3.14		AC2684 sez 4.3.18-19	
Fori e asole per chiusura supplementare <i>Additional locking points slots and holes</i>	AC2626R sez 4.3.20-21		AC2626R sez 4.3.22-23	
Fori per scarico acqua <i>Water drip holes</i>	AC2618.XX sez 4.3.9	ACB219 sez 4.3.9		
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2652 sez 4.3.3-4	AC2514 sez 4.3.7-8	AC2653 sez 4.3.5-6	
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2621A/B/X/C/D sez 4.3.37		AC2621A/B/X/C/D sez 4.3.38	
Fori limitatori apertura per apertura ad anta <i>Restrictor stays holes</i>			AC2687 sez 4.3.31-33	
Fresature per compassi sporgere <i>Stay arm for awning windows milling</i>			AC2688 sez 4.3.34	
Fresature per limitatori sporgere <i>Stay arm for awning windows milling</i>	-	-	AC2690 sez 4.3.36	
Lavorazione gocciolatoio <i>Water drip section workink</i>	PR2620BV sez 4.3.16			
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.3.1-4		sez 3.3.5	

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648/ACB648 sez 4.3.24		AC2648/ACB648 sez 4.3.25	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649 sez 4.3.26		AC2649 sez 4.3.27	
Fori e asole per serratura e incontri <i>Lock and strike slots and holes</i>	AC2693 sez 4.3.41	AC2694 sez 4.3.43	AC2693 sez 4.3.42	AC2694 sez 4.3.44
Fori e asole per chiusura supplementare <i>Additional locking points slots and holes</i>	AC2695 sez 4.3.45		AC2695 sez 4.3.46	
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2652 sez 4.3.3-4		AC2653 sez 4.3.5-6	
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2621A/B/X/C/D sez 4.3.37		AC2621A/B/X/C/D sez 4.3.38	
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.3.1-4		sez 3.3.5	

4. Assiemaggio / Assembly

Finestra / Window	Aperture interne / Inward opening		Aperture esterne / Outward opening	
<u>Costruzione telai</u>				
Inserimento squadrette (profili ottone) – Saldatura / Brackets insertion (brass section) - Welding	AC28xx sez 4.4.1-4		AC28xx sez 4.4.1-4	
Sigillatura interna della giunzione (ottone) Internal joint sealing (brass sections)	AC28xx sez 4.4.1-4		AC28xx sez 4.4.1-4	
Taglio punta per inversione battuta Secondary leaf top central joint working	AC2652 sez 4.3.3-4	AC2514 sez 4.3.7-8	AC2653 sez 4.3.5-6	
<u>Applicazione accessori</u>				
Fori inserimento rinforzi cerniere Hinge reinforcement holes	- sez 4.3.1		- sez 4.3.2	
Fori per cerniere a tre ali Three-wing hinge holes	AC2648/ACB648 sez 4.3.24		AC2648/ACB648 sez 4.3.25	
Foratura per cerniera a due ali Two-wing hinge holes	AC2649 sez 4.3.26		AC2649 sez 4.3.27	
Saldatura cerniere a saldare Hinge welding	AC2631/32 sez 4.4.5		AC2631/32 sez 4.4.6	
Fori snapper 2° anta Secondary leaf snapper holes	AC2622 sez 4.5.4			
Fori cricchetto e braccetti vasistas Finger catch and stay arms for bottom hung window holes	AC2640/41 sez 4.5.14			
Fori chiusure mediane a scomparsa Concealed medians closures holes	AC2627 sez 4.5.12			
Fori maniglia trascinalimento seconda anta Fixed handle for secondary leaf holes			AC2680 sez 4.5.15	
Fori limitatori apertura per apertura ad anta Restrictor stays holes			AC2687 sez 4.3.31-33	
Fori compassi sporgere Stay arm for awning windows holes			AC2688 sez 4.3.34	AC2689 sez 4.3.35
Fori limitatori sporgere Stay arm for awning windows holes	-	-	AC2690 sez 4.3.36	

Porta / Door	Aperture interne / Inward opening	Aperture esterne / Outward opening
<u>Costruzione telai / Frame assembly</u>		
Inserimento squadrette (profili ottone) – Saldatura / Brackets insertion (brass section) - Welding	AC28xx sez 4.4.1-3	AC28xx sez 4.4.1-3
Sigillatura interna della giunzione (ottone) Internal joint sealing (brass sections)	AC28xx sez 4.4.1-3	AC28xx sez 4.4.1-3
Taglio punta per inversione battuta Secondary leaf top central joint working	AC2652 sez 4.3.3-4	AC2653 sez 4.3.5-6
<u>Applicazione accessori / Accessories installation</u>		
Fori inserimento rinforzi cerniere Hinge reinforcement holes	- sez 4.3.1	- sez 4.3.2

Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648/ACB648 sez 4.3.24	AC2648/ACB648 sez 4.3.25
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649 sez 4.3.26	AC2649 sez 4.3.27
Saldatura cerniere a saldare <i>Hinge welding</i>	AC2631/32 sez 4.4.5	AC2631/32 sez 4.4.6
Lavorazione per paraspiro automatico <i>Automatic door bottom seal installation holes</i>	AC2636 sez 4.3.39	AC2636 sez 4.3.40

5. Preparazione per verniciatura - brunitura / *Preparation for the powder coating - burnishing*
 - a. Fori su telaio per scarichi liquidi pretrattamento
Holes on frame for the drainage of pretreatment liquid sez 5.1.4
 - b. Marcatura e imballo telai esterni e ante
External frames and leafs branding and packing -
 - c. Marcatura e imballo telai fermavetro
Glazingbeads frames branding and packing -
 - d. Marcatura e imballo profili complementari
Additional profiles branding and packing -
 - e. Imballo scarichi acqua e cerniere
Accessories (water drip, hinges) branding and packing -
6. Applicazione accessori e sigillatura / *Hardware and accessories installation and sealing*
 - a. Porta / *Door*
 - I. Montaggio cerniere / *Hinges installation* sez 4.3.24-27 | 4.4.5-6
 - II. Montaggio serratura e incontri / *Lock and strikes installation* sez 4.5.16-18
 - III. Applicazione paraspiro automatico /
Automatic door bottom seal installation holes sez 4.3.39-40
 - IV. Montaggio catenaccio / *Flush bolt installation* sez. 4.3.37-38
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
 - VI. Sigillatura angolo nel TT / *Corner joint sealing*
 - b. Finestra e fissi
 - I. Applicazione e sigillatura guarnizioni giunto aperto /
Sealing of central gasket sez 4.5.1
 - II. Applicazione scarichi acqua / *water drip installation* sez 4.5.1
 - III. Montaggio cerniere / compassi / vasistas etc /
Hinges and arms installation (side hung, bottom hung, awning, etc) sez 4.5.12-15
 - IV. Montaggio cremonese e incontri / *Espagnolette installion* sez 4.5.3-11
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
 - VI. Sigillatura angolo nel TT / *Corner joint sealing*
7. Vetrazione / *Glazing*
 - a. Applicazione clips fermavetro / *glazing bead clips installation* sez 2.9.1-15
 - b. Applicazione guarnizione esterna / *External glazing gasket installation*
 - c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* sez 4.7.1-2
 - d. Inserimento fermavetri / *Glazing beads application*
 - e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
 - f. Verifica corretta compressione guarnizione /
Control of the right compression of the gasket
8. Controlli su prodotto finito / *Control on finished element*
 - a. Verifica distanza tra anta e telaio /
Control of gap between leaf and frame +0 +0.5 mm

- | | |
|--|--|
| b. Verifica sormonto anta su telaio / <i>Control of leaf surmount</i> | +0 +1 mm |
| c. Verifica sigillature per scarico acqua /
<i>Control of central gasket sealing</i> | test con acqua su giunto
<i>test with water</i> |
| d. Verifica funzionamento cremonese/maniglia serratura
<i>Control of hardware functioning</i> | |
| e. Verifica finitura superficiale / <i>Control of surface finishing</i> | |
9. Controlli dopo la posa / *Controls after installation*
- | | |
|---|--|
| a. Verifica corretta installazione telai: squadra, piombo, misure /
<i>Control of alignment and plumbing of frame and leaf</i> | |
| b. Verifica distanza tra anta e telaio /
<i>Control of gap between leaf and frame</i> | +0 +0.5 mm |
| c. Verifica sormonto anta su telaio / <i>Control of leaf surmount</i> | +0, +1 mm |
| d. Verifica sigillature per scarico acqua /
<i>Control of central gasket sealing</i> | test con acqua su giunto
<i>test with water</i> |
| e. Verifica funzionamento cremonese/maniglia serratura
<i>Control of hardware functioning</i> | |
| f. Verifica finitura superficiale / <i>Control of surface finishing</i> | |

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

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

Caratteristiche fisiche

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

Norme di riferimento

EN 10088-2; EU 114

Trattamenti superficiali

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

ACCIAIO COR-TEN**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

EN 10149

Trattamenti superficiali

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

ACCIAIO ZINCATO VERNICIATO**Descrizione**

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

Designazione acciaio

DX51D Z200 / ZM120

Norme di riferimento

UNI EN 10346; UNI EN 10143/7

Verniciatura

La verniciatura dei telai viene eseguita a polveri con ciclo di cottura in forno a 180°C o a liquido con ciclo eseguito a bassa temperatura 60-80°C. Il processo di verniciatura deve essere conforme allo standard Qualisteelcoat con classificazione da C2 a C5 in funzione del sito di installazione del manufatto

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.

PAINTED GALVANIZED STEEL**Description**

Profiles obtained from hot-dip galvanized steel sheet, Sendzimir system, skin-passed finish

Steel designation

DX51D Z200 / ZM120

Reference standards

UNI EN 10346; UNI EN 10143/7

Painting

The painting of the frames is carried out with powder painting with a baking cycle in an oven at 180°C or with liquid painting with a cycle carried out at a low temperature of 60-80°C. The painting process must comply with the Qualisteelcoat standard with classification from C2 to C5 depending on the installation site of the product.

COPPER ALLOY OT67**Materials**

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

Physical features

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

Norms of reference

EN 1652:1999

Surface treatment

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

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

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