

MB 85

CATALOGO
TECNICO
TECHNICAL
CATALOGUE

release 10/2024

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

Secco Sistemi si riserva di variare la presente documentazione senza obbligo di preavviso e raccomanda di utilizzare sempre l'ultima versione della nota tecnica scaricabile dal proprio sito www.seccosistemi.com

Secco Sistemi reserves the right to modify this documentation without prior notice and recommends always using the latest version of the technical catalogue, available for download from its website www.seccosistemi.com

1	Informazioni generali / General informations	
	Descrizione del sistema / System description	1.1.1
	Tipologie e limiti dimensionali / Typologies and dimensional limits	1.2.1 – 1.2.5
2	Componenti del sistema / System component	
	Profili / Profiles	2.1.1 – 2.1.5
	Accessori / Accessories	2.2.1 – 2.2.9
	Ferramenta / Hardware	2.3.1 – 2.3.2
	Maniglie / Handles	2.4.1 – 2.4.6
	Guarnizioni / Gaskets	2.5.1 – 2.5.2
	Attrezzature / Working tools	2.6.1 – 2.6.2
	Prodotti / Products	2.7.1 – 2.7.2
	Fermavetri / Glazing beads	2.8.1 – 2.8.6
3	Tecnica del sistema / System technique	
	Varianti del sistema / System variations	3.1.1 – 3.1.8
	Sezioni / Sections	3.2.1 – 3.2.20
	Attacchi a muro / Attachment to structure	3.3.1 – 3.3.5
4	Lavorazioni e ciclo produttivo / Processing plan	
	Ciclo produttivo porte e finestre / Door and window processing plan	4.1.1 – 4.1.2
	Distinte di taglio - Lista componenti / Cutting list - Component list	4.2.1 – 4.2.24
	Lavorazioni su barra / Bar workings	4.3.1 – 4.3.55
	Assiemaggio / Assembling	4.4.1 – 4.4.18
	Applicazione accessori / Accessory installation	4.5.1 – 4.5.31
	Lavorazione e applicazione accessori AR / Working and installation of T&T accessories ..	4.6.1 – 4.6.16
	Vetrazione / Glazing	4.7.1 – 4.7.2
5	Note generali sul processo / Processing general informations	
	Raccomandazioni per la lavorazione / Working recommendations	5.1.1 – 5.1.4
	Taglio, asolature, forature / Cutting, slots, holes	5.2.1 – 5.2.2
	Senso di apertura / Side opening	5.3.1
	Controllo qualità / Quality control activities	5.4.1
	Materiali e finiture / Material and finishing	5.5.1
	Indice analitico / Subject index	5.6.1 – 5.6.2

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 poliuretanicca 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.

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 inferiore con guarnizione a pinna

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 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.

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.

PRESTAZIONI

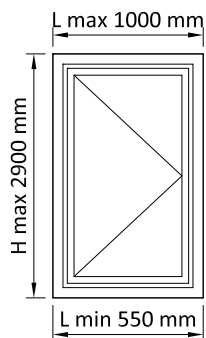
Sistema finestre

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

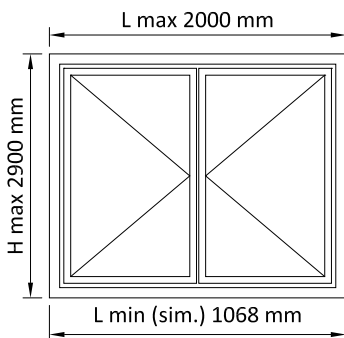
PERFORMANCES

Windows system

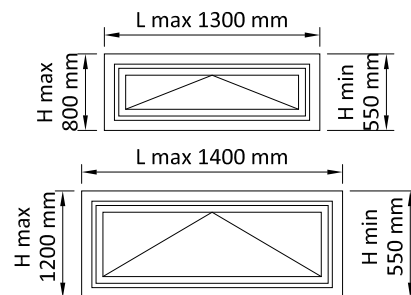
Thermal transmittance (EN ISO 10077-2)
- Typical section: $U_f = 2.50 \text{ W/m}^2\text{K}$
Acoustic performance (DIN 52210 / DIN EN ISO 717-1)
- Up to 45 dB
Air permeability (DIN EN 12207)
- Up to Class 4
Watertightness (DIN EN 12208)
- Up to Class 9A
Resistance to wind load (DIN EN 12210)
- Up to 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*

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

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

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

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

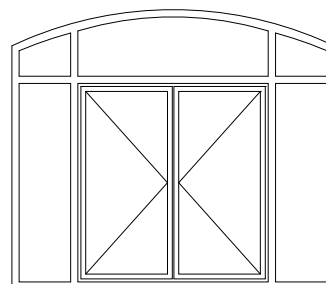
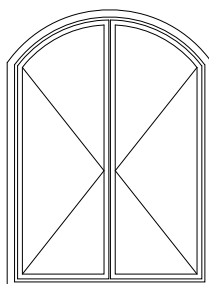
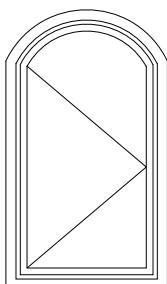
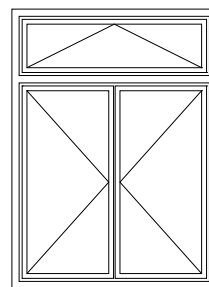
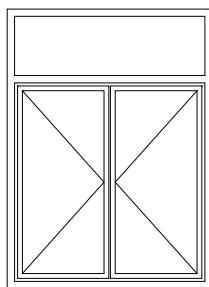
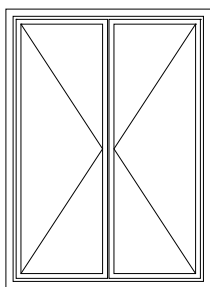
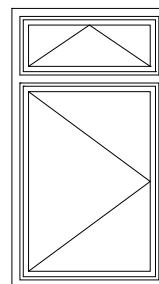
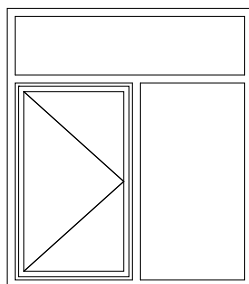
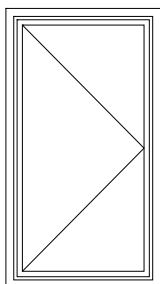
AC2648	- 50 kg
AC2649	- 40 kg
AC2631.A	- 40 kg
AC2631.B	- 40 kg
AC2632.B	- 40 kg
AG2524	- 70 kg
AG2580	- 70 kg

* cerniera aggiuntiva per H serramento > 1300 mm - vedi distinte di taglio capitolo 4.2

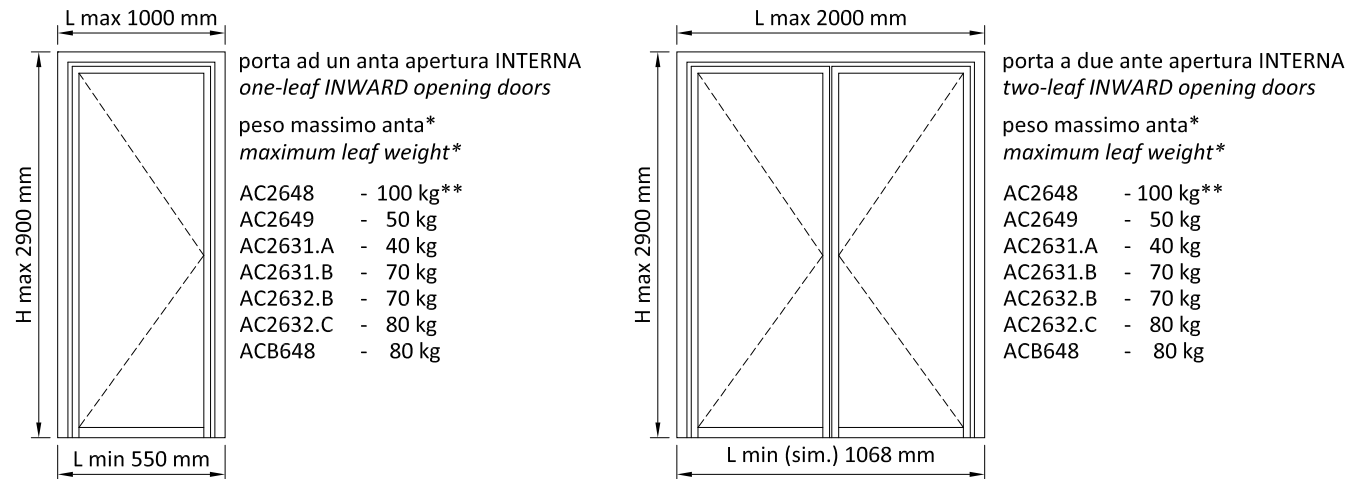
* additional hinge for windows with height > 1300 mm - see cutting list chapter 4.2

** 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*



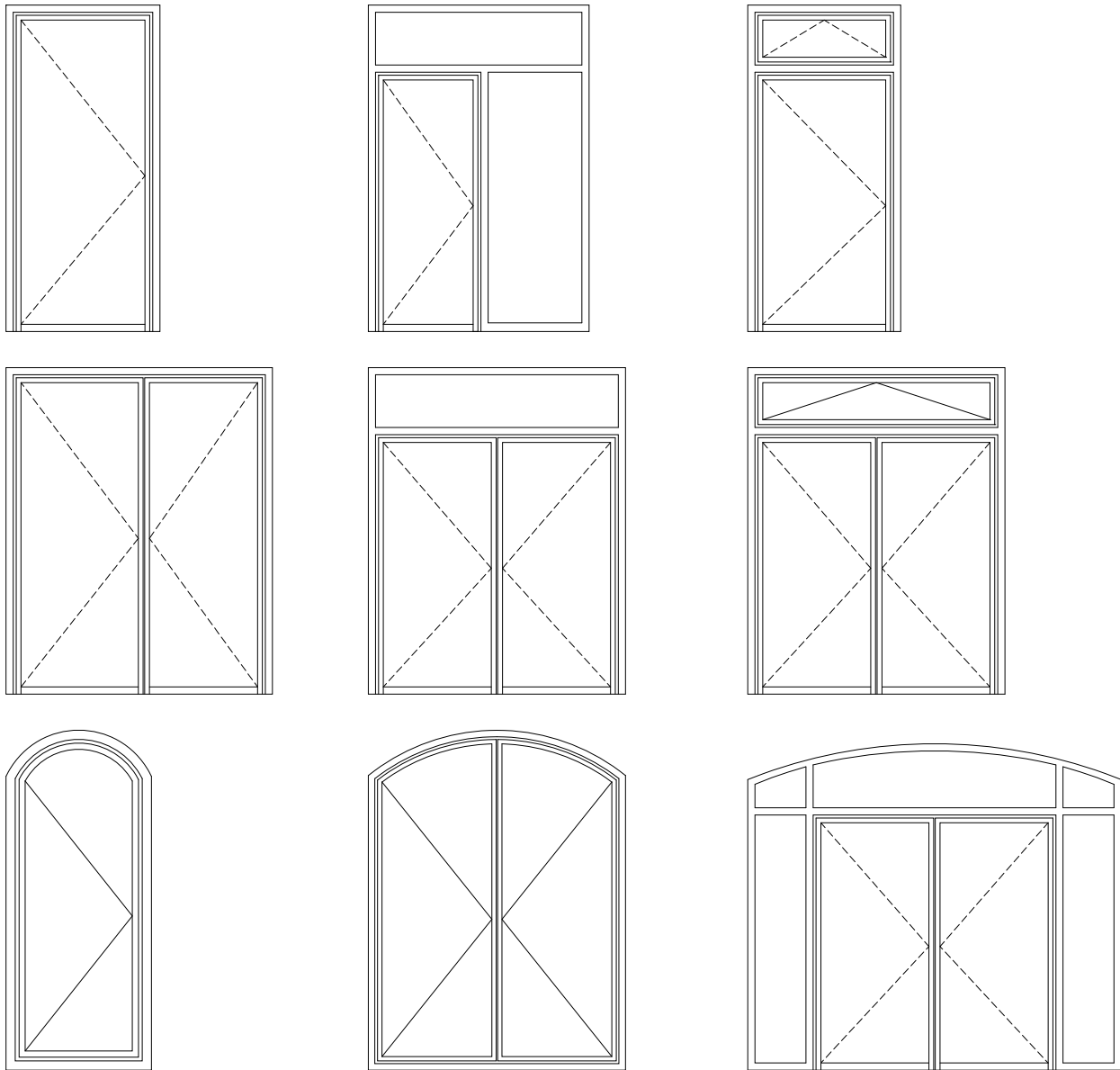
* cerniera aggiuntiva per H serramento > 2300 mm - vedi distinte di taglio capitolo 4.2

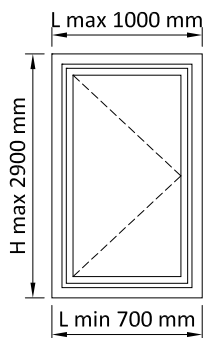
* *additional hinge for windows with height > 2300 mm - see cutting list chapter 4.2*

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

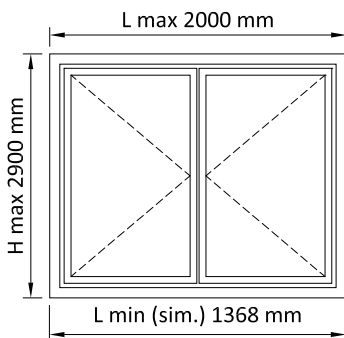
** *up to 130 kg with additional hinge (see hinge application page)*

Esempi tipologie realizzabili - *Types of door*

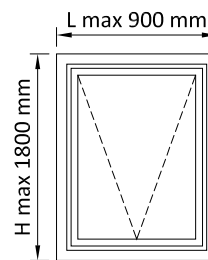


Limiti dimensionali - Maximum dimensionfinestra ad un'anta apertura ESTERNA
one-leaf OUTWARD opening windowspeso massimo anta*
maximum leaf weight*

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

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

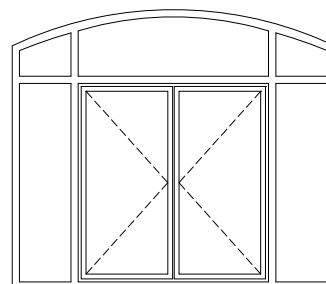
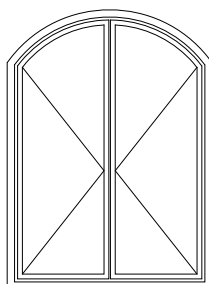
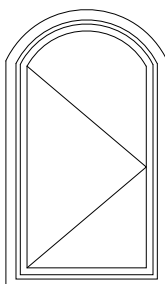
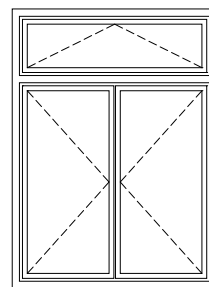
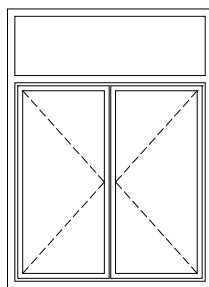
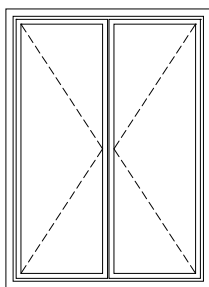
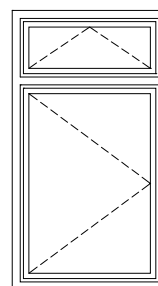
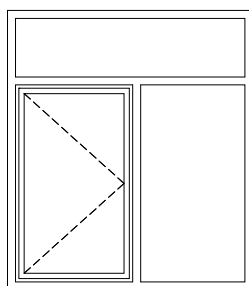
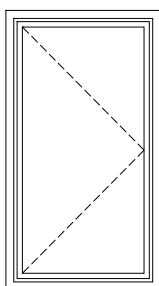
AC2631.A	- 40 kg	(H min 700)
AC2631.B	- 40 kg	(H min 700)
AC2632.B	- 40 kg	(H min 700)
AC2648	- 50 kg	(H min 700)
AC2649	- 40 kg	(H min 700)
AC2688M	- 100 kg	(H min 800)
AC2689	- 40 kg	(H min 700)

* cerniera aggiuntiva per H serramento > 1300 mm - vedi distinte di taglio capitolo 4.2

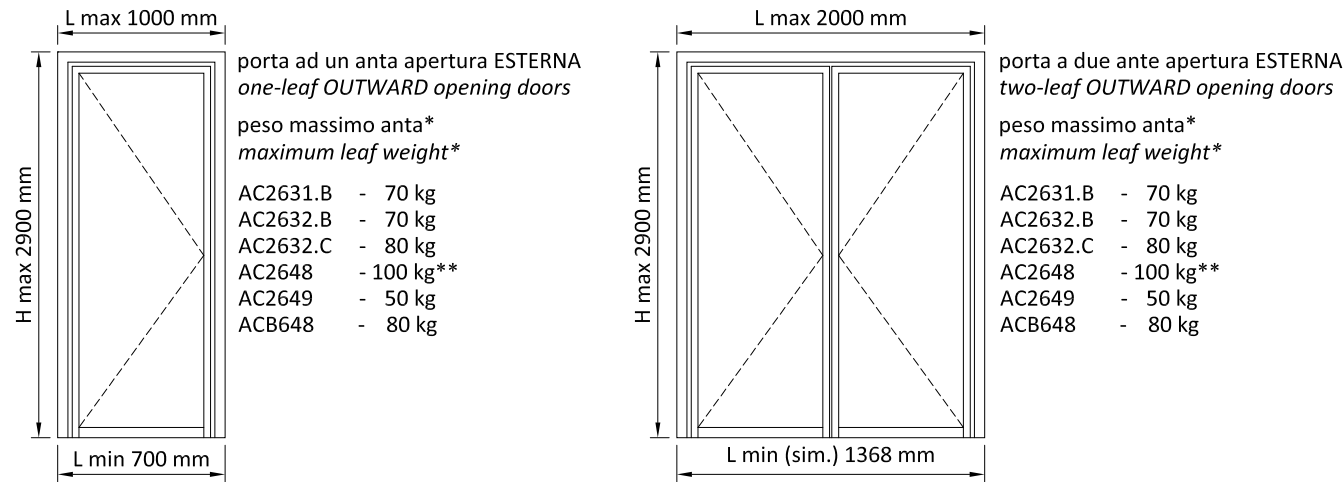
* additional hinge for windows with height > 1300 mm - see cutting list chapter 4.2

** 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*



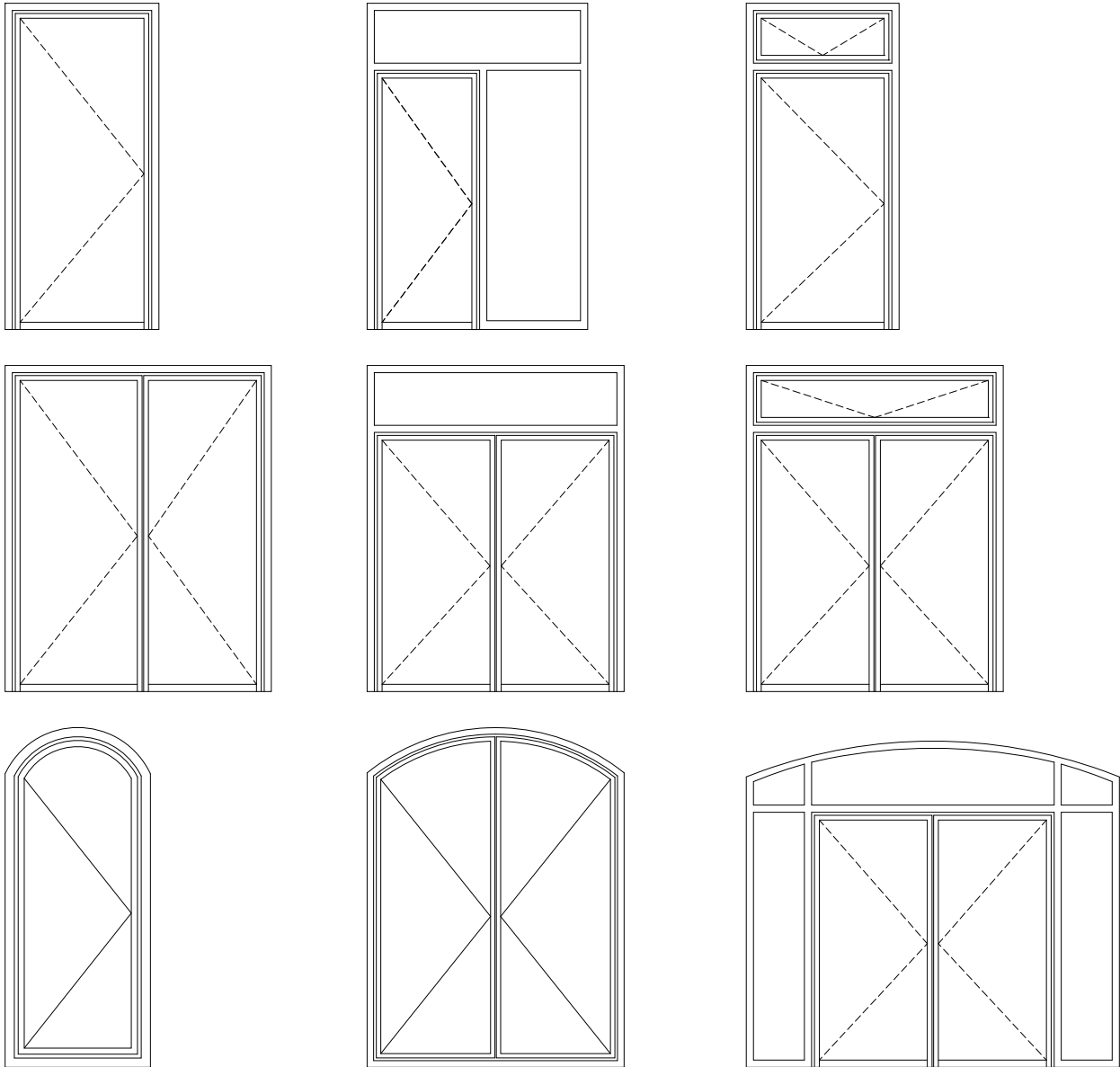
* cerniera aggiuntiva per H serramento > 2300 mm - vedi distinte di taglio capitolo 4.2

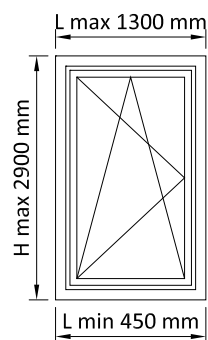
* additional hinge for windows with height > 2300 mm - see cutting list chapter 4.2

** 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*

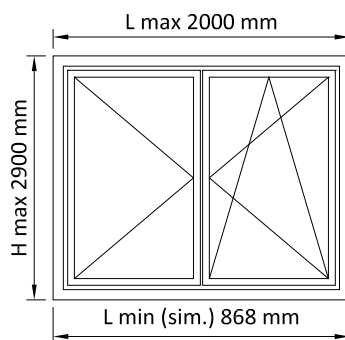


Limiti dimensionali - *Maximum dimension*

finestra ad un anta
one-leaf opening windows

peso massimo anta
maximum leaf weight

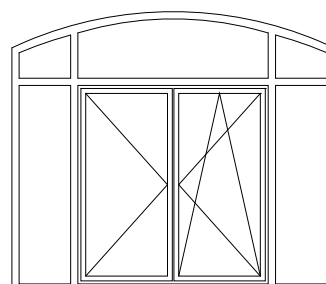
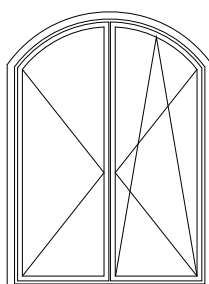
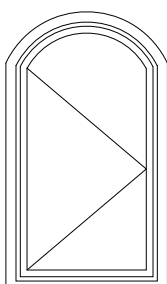
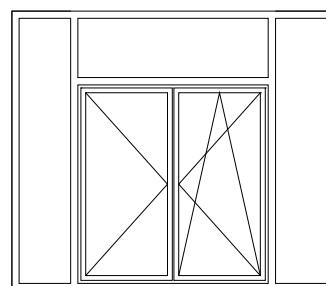
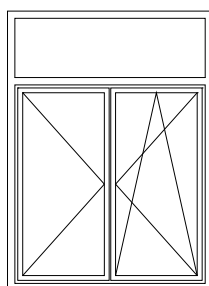
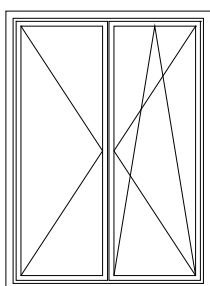
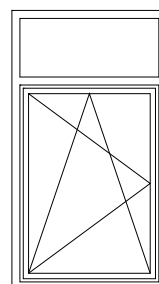
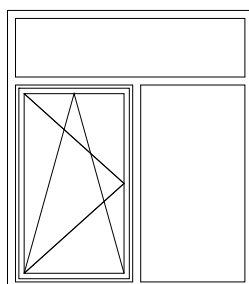
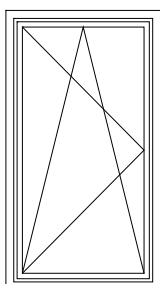
AGE581-2 - 130 kg Easy

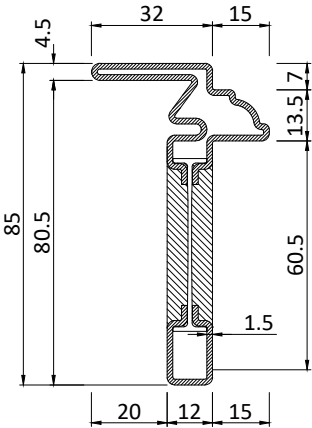


finestra a due ante
two-leaf opening windows

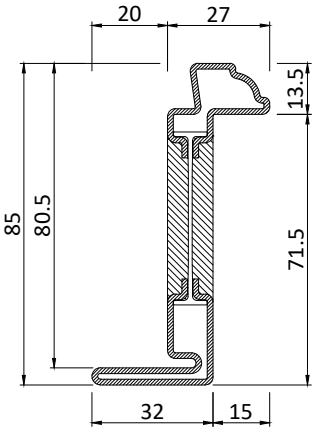
peso massimo anta
maximum leaf weight

AGE581-2-5-6 - 130 kg Easy

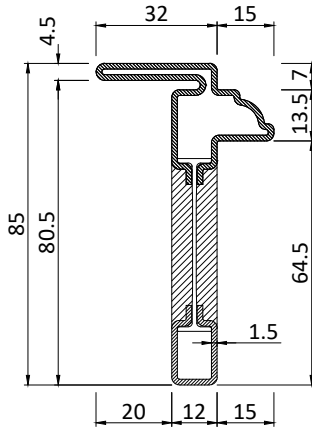
Esempi tipologie realizzabili - *Types of window*



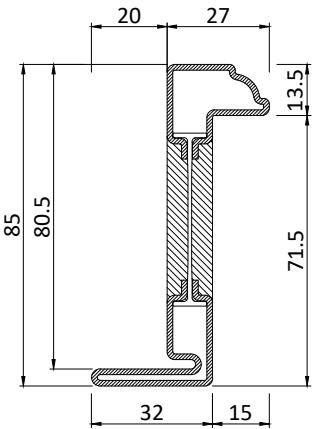
PR2942MB



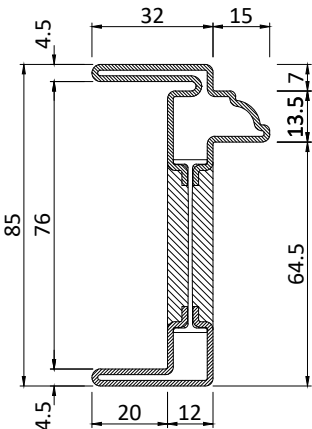
PR2943MB



PR2962MB

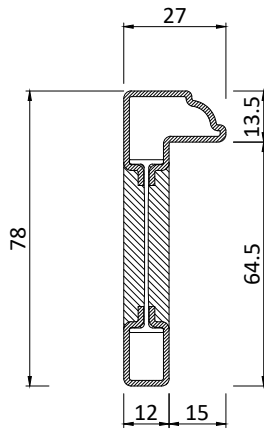


PR2963MB

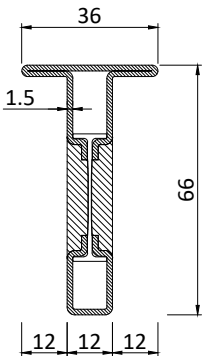


PR2968MB

applicazione esclusivamente su traverso inferiore porta apertura esterna
application exclusively on lower door transom external opening

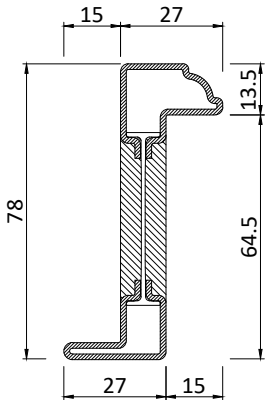


PR2971MB



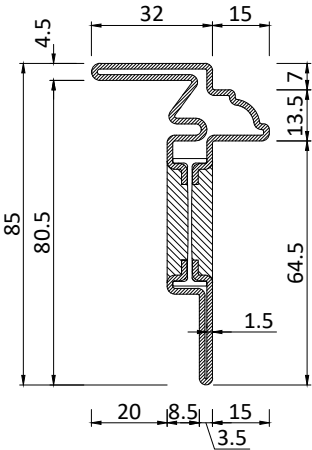
PR2972MB

solo zincato
only galvanised

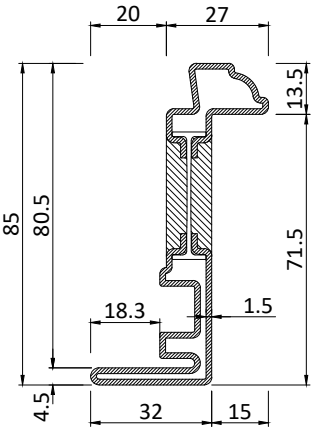


PR2973MB

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	OT						ZN	OT				
PR2942MB	3,08	3,29	0,28	21,95	3,18	6,0	PR2971MB	2,20	2,34	0,20	14,81	1,19	6,0
PR2943MB	2,98	3,19	0,27	25,63	2,92	6,0	PR2972MB	2,31	-	0,20	11,96	1,40	6,0
PR2962MB	2,97	3,17	0,27	22,31	3,19	6,0	PR2973MB	2,54	2,71	0,23	19,40	2,18	6,0
PR2963MB	2,98	3,18	0,27	26,30	2,98	6,0							
PR2968MB	3,42	3,66	0,31	30,84	4,46	3,0							

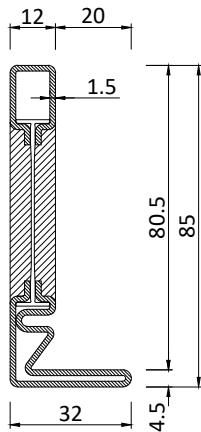


PR2542MB

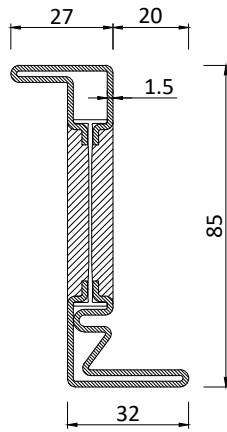


PR2543MB

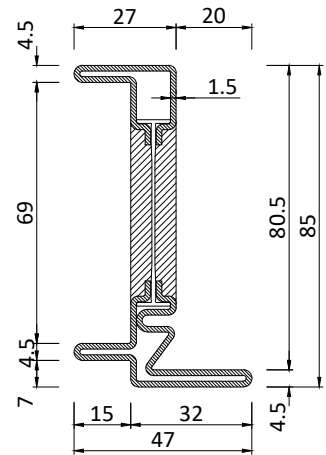
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN	OT						ZN	OT				
PR2542MB	3,21	3,45	0,28	20,78	3,20	6,0							
PR2543MB	3,36	3,61	0,29	26,26	3,08	6,0							



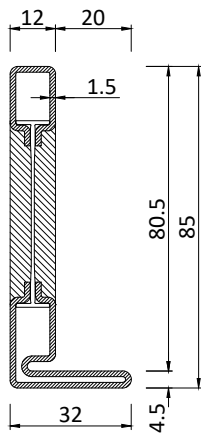
PR2901H



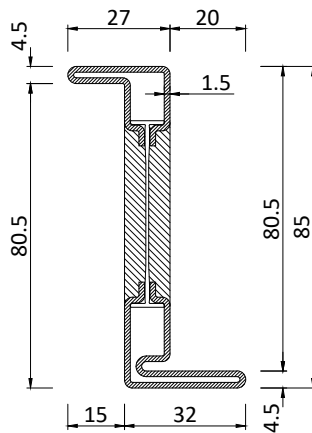
PR2903H



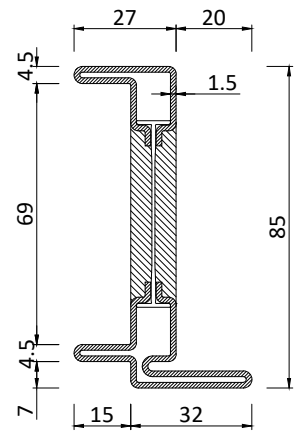
PR2915H



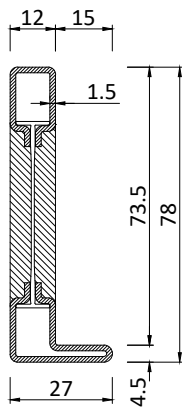
PR2961H



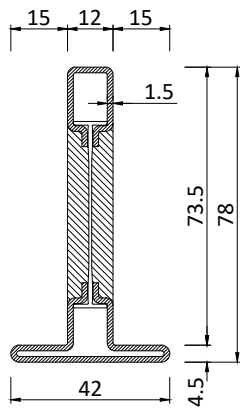
PR2963H



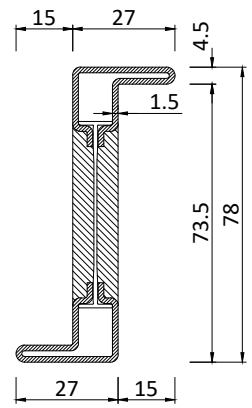
PR2965H



PR2971H



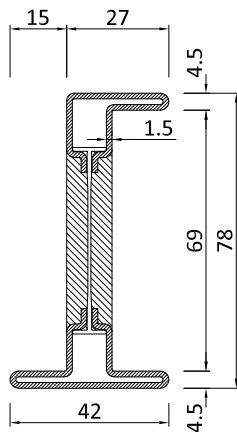
PR2972H



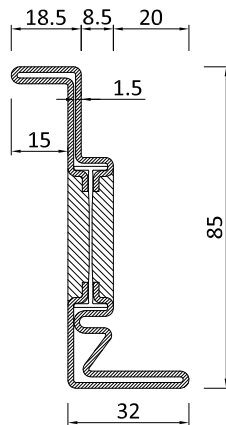
PR2973H

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN	OT				
PR2901H	2,73	2,91	0,25	21,55	1,78	6,0
PR2903H	3,07	3,28	0,28	28,22	2,80	6,0
PR2915H	3,40	3,63	0,31	29,72	3,69	6,0
PR2961H	2,62	2,79	0,25	21,69	1,74	6,0
PR2963H	2,96	3,16	0,27	28,31	2,79	6,0

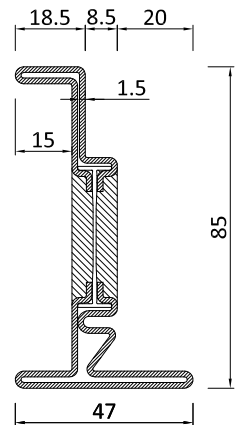
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN	OT				
PR2965H	3,28	3,51	0,30	29,85	3,82	6,0
PR2971H	2,18	2,32	0,21	16,19	1,02	6,0
PR2972H	2,52	2,68	0,23	18,33	2,12	6,0
PR2973H	2,52	2,68	0,23	20,97	3,32	6,0



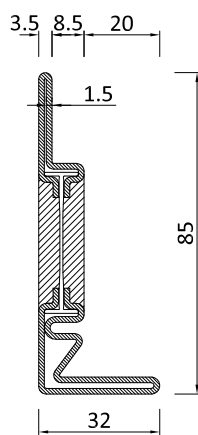
PR2974H



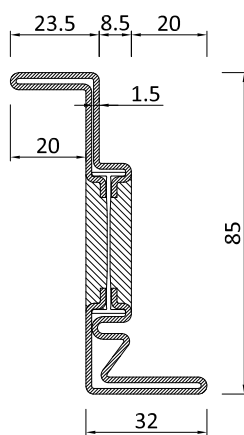
PR2503H



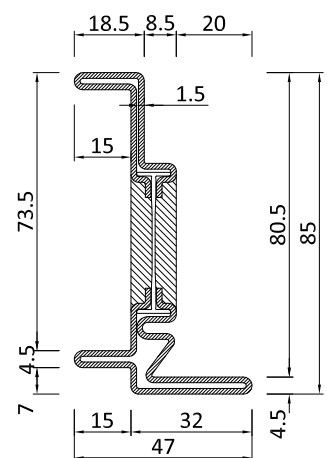
PR2505H



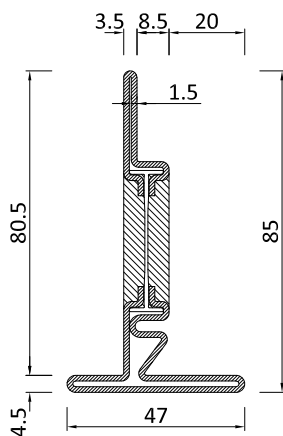
PR2511H



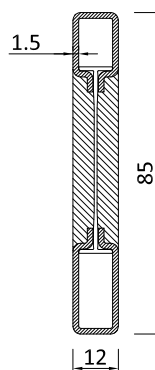
PR2513H



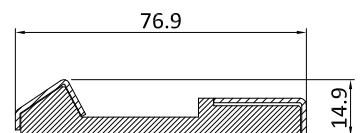
PR2515H



PR2522H



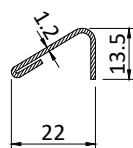
PR2931H



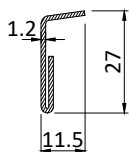
PR2630H

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN	OT				
PR2974H	2,86	3,05	0,26	24,11	2,87	6,0
PR2503H	3,21	3,44	0,28	26,79	2,77	6,0
PR2505H	3,54	3,80	0,31	29,59	3,71	6,0
PR2511H	2,87	3,08	0,25	19,88	1,93	6,0
PR2513H	3,32	3,56	0,29	28,59	3,49	6,0

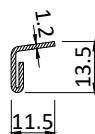
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN	OT				
PR2515H	3,53	3,79	0,31	28,28	3,61	6,0
PR2522H	3,21	3,44	0,28	21,90	2,99	6,0
PR2931H	2,01	2,13	0,19	15,92	0,36	6,0
PR2630H	1,33	1,38				3,0



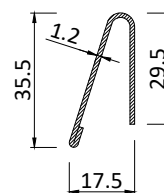
PR2620BV



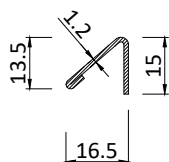
PR2818



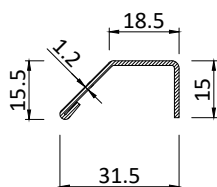
PR2819



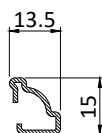
PR2660



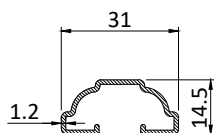
PR2670



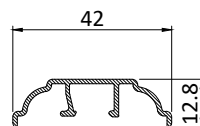
PR2671



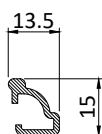
PA2028CA



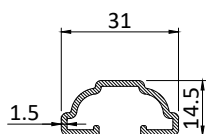
PA2030CA



PA2035CA



PRE028CA

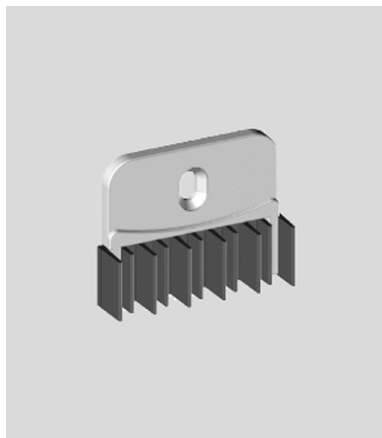


PRE030CA

MATERIALE | MATERIAL

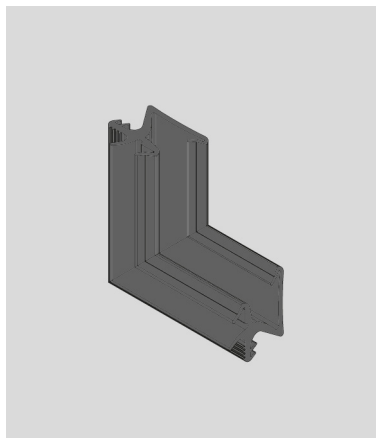
PR ____ ZN acciaio zincato | *galvanized steel*PR ____ BR ottone grezzo | *untreated brass*PA ____ alluminio | *aluminium*PRE ____ ottone grezzo | *untreated brass*

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				
PR2620BV	0,24	0,27				4,0							
PR2818	0,48	0,52				4,0	PA2028CA	All.	0,13				6,0
PR2819	0,28	0,31				4,0	PA2030CA	All.	0,22				6,0
PR2660	0,73	0,79				4,0	PA2035CA	All.	0,25				6,0
PR2670	0,40	0,43				4,0	PRE028CA		0,40				6,0
PR2671	0,50	0,59				4,0	PRE030CA		0,70				6,0

**AC1081T**

Accessorio di battuta su profilo
soglia PA2630H

*Stop accessory on PA2630H
threshold profile*

**AC2617NG**

Guarnizione d'angolo
vulcanizzata per GE2603

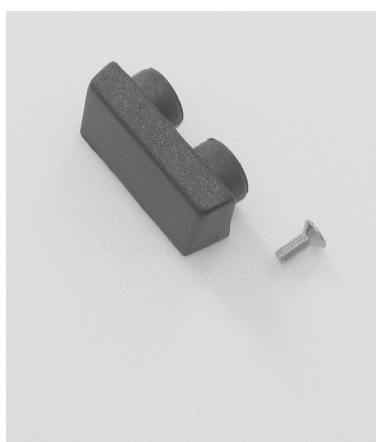
*Vulcanised corner gasket
for GE2603*

**AC2514.xx**

Kit fondini per profili
PR2542MB - PR2543MB

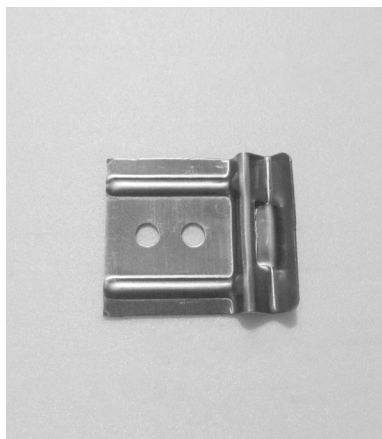
*Fittings kit for profiles
PR2542MB - PR2543MB*

ZN acciaio zincato | *galvanized steel*
BR ottone naturale | *natural brass*

**AC2618.NE**

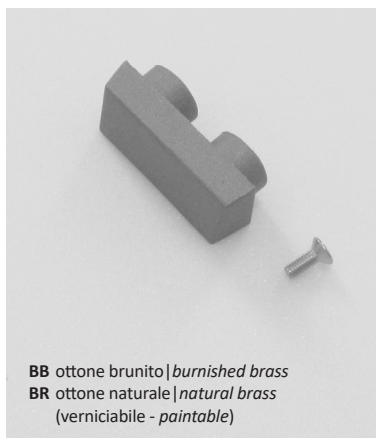
Scarico acqua per aperture
interne in plastica nera
Non verniciabile

*Black plastic drip for inward
openings
Non paintable*

**AC2608**

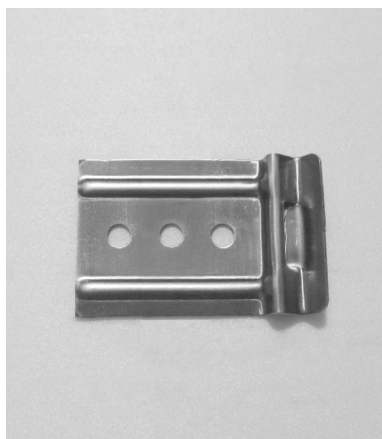
Clips per fissaggio fermavetri
PA2028CA - PRE028CA

*Clips for securing
PA2028CA - PRE028CA
glazing beads*

**ACB219.xx**

Scarico acqua per aperture
interne in ottone

Brass drip for inward openings

**AC2608AR**

Clips per fissaggio fermavetri
PA2028CA - PRE028CA
su profilo PR2542MB -
PR2543MB

*Clips for securing
PA2028CA - PRE028CA glazing
beads
on PR2542MB - PR2543MB profile*

**AC2621G.A**

Catenaccio 2^ anta per
porte/finestre
L = 140 mm

*Second leaf flush bolt for
doors/windows
L = 140 mm*

**AC2621G.B**

Catenaccio 2^ anta per
porte/finestre
L = 220 mm

*Second leaf flush bolt for
doors/windows
L = 220 mm*

**AC2621SG.X**

Catenaccio inferiore 2^ anta per
porte/finestre su soglia
L = 450 mm

*Lower second leaf flush bolt for
doors/windows on threshold
L = 450 mm*

**AC2621G.X**

Catenaccio 2^ anta per
porte/finestre
L = 450 mm

*Second leaf flush bolt for
doors/windows
L = 450 mm*

**AC2622**

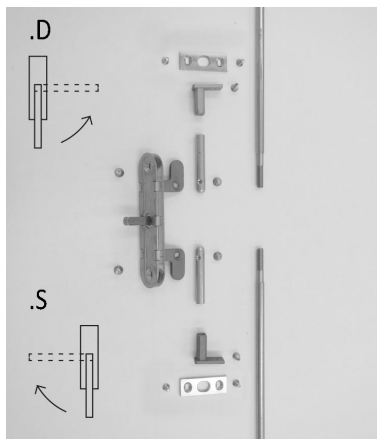
Fermo a scatto chiusura 2^ anta
per finestra

Snapper for 2nd window leaf

**AC2621G.C**

Catenaccio 2^ anta per
porte/finestre
L = 650 mm

*Second leaf flush bolt for
doors/windows
L = 650 mm*

**AC2624.D**

Kit cremone dx per finestre
a due ante

*RH cremone bolt set for double
leaf windows*

AC2624.S

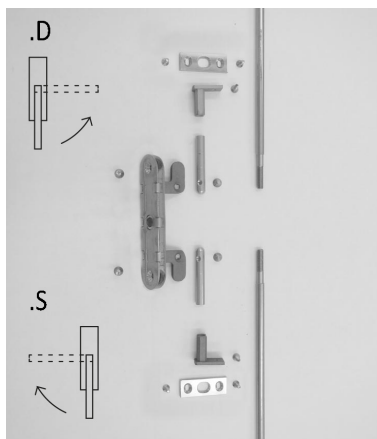
Kit cremone sx per finestre
a due ante

*LH cremone bolt set for double leaf
windows*

**AC2621G.D**

Catenaccio 2^ anta per
porte/finestre
L = 850 mm

*Second leaf flush bolt for
doors/windows
L = 850 mm*

**AC2624E.D**

Kit cremone dx per finestre
a due ante

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

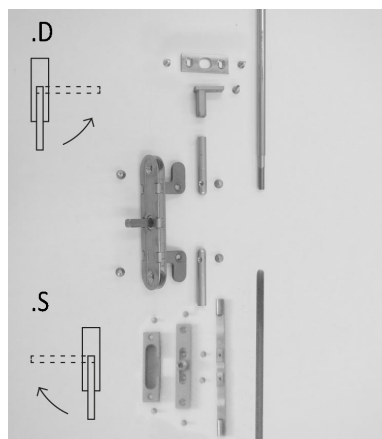
Gratz mechanism with removable handle

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

**AC2624SG.D**

Kit cremonese dx per finestre
a due ante su soglia - ap. interna

*RH cremonese bolt set for double
leaf windows on threshold - inward
opening*

AC2624SG.S

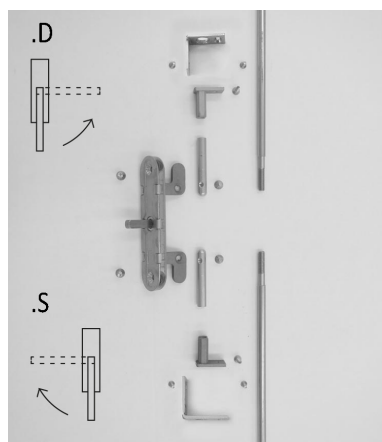
Kit cremonese sx per finestre
a due ante su soglia - ap. interna

*LH cremonese bolt set for double
leaf windows on threshold- inward
opening*

**AC2626R**

Punto di chiusura aggiuntivo
per finestra

*Additional locking point
for windows*

**AC2625.D**

Kit cremonese dx per finestre
ad un anta | PR2943MB

*RH cremonese bolt set for single leaf
windows | PR2943MB*

AC2625.S

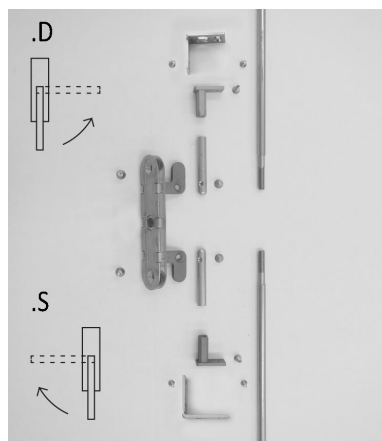
Kit cremonese sx per finestre
ad un anta | PR2943MB

*LH cremonese bolt set for single leaf
windows | PR2943MB*

**AC2627**

Chiusura mediana lato cerniere

Hinge-side middle closing

**AC2625E.D**

Kit cremonese dx per finestre
ad un anta | PR2943MB
Gratz con maniglia removibile
*RH cremonese bolt set for single leaf
windows | PR2943MB
Gratz mechanism with removable handle*

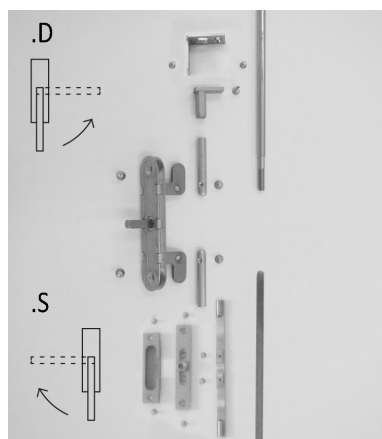
AC2625E.S

Kit cremonese sx per finestre
ad un anta | PR2943MB
Gratz con maniglia removibile
*LH cremonese bolt set for single leaf
windows | PR2943MB
Gratz mechanism with removable handle*

**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*

**AC2625SG.D**

Kit cremonese dx per finestre
ad un anta su soglia | PR2843

*RH cremonese bolt set for single leaf
windows on threshold | PR2843*

AC2625SG.S

Kit cremonese sx per finestre
ad un anta su soglia | PR2843

*LH cremonese bolt set for single leaf
windows on threshold | PR2843*

**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*

**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 PR2943MB (apertura interna)
su PR2962MB (apertura esterna)
Peso max anta 100 kg

*Three-wing screw-on hinge
on PR2943MB (inward opening)
on PR2962MB (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

**AC2648Y.xx**

Cerniera a tre ali da avvitare
su PR2943MB (apertura interna)
su PR2962MB (apertura esterna)
Peso max anta 100 kg

*Three-wing screw-on hinge
on PR2943MB (inward opening)
on PR2962MB (outward opening)
Max leaf weight 100 kg*

**AC2640.xx**

Cricchetto per vasistas

*Finger catch for bottom-hung
windows*

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

**AC2648R**

Rinforzo cerniera AC2648,
ACB648 e AC2649 su profilo
PR2962MB

*Reinforcement for hinge
AC2648, ACB648 and AC2649 on
PR2962MB profile*

**ACB648.BR**

Cerniera in ottone a tre ali da avvitare
su PR2943MB (apertura interna)
su PR2962MB (apertura esterna)
Peso max anta 80 kg

*Three-wing screw-on brass hinge
on PR2943MB (inward opening)
on PR2962MB (outward opening)
Max leaf weight 80 kg*

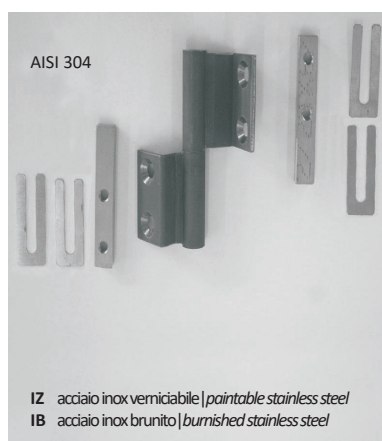
ottone naturale | natural brass

**AC2653.xx**

Kit fondini per profili
PR2962MB - PR2963MB

*Fittings kit for profiles
PR2962MB - PR2963MB*

ZN acciaio zincato | galvanized steel
BR ottone naturale | natural brass



AISI 304

AC2649.xx.ISED

Cerniera a due ali da avvitare
Sx su PR2943MB (apertura interna)
Dx su PR2962MB (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
LH on PR2943MB (inward opening)
RH on PR2962MB (outward opening)
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
IB acciaio inox brunito | burnished stainless steel

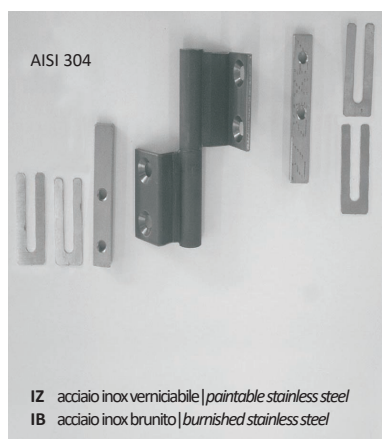
Scelta verso cerniera pg. 5.3.1
Side hinge choice pg. 5.3.1

**AC2654.xx**

Fondini per profili
PR2942MB

*Fittings for profiles
PR2942MB*

ZN acciaio zincato | galvanized steel
BR ottone naturale | natural brass



AISI 304

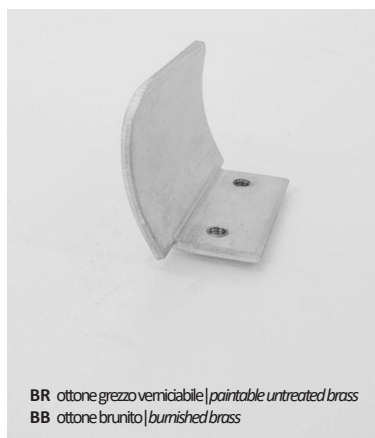
AC2649.xx.IDES

Cerniera a due ali da avvitare
Dx su PR2943MB (apertura interna) Sx su PR2962MB (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
RH on PR2943MB (inward opening)
LH on PR2962MB (outward opening)
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
IB acciaio inox brunito | burnished stainless steel

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

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

**AC2652.xx**

Kit fondini per profili
PR2942MB - PR2943MB

*Fittings kit for profiles
PR2942MB - PR2943MB*

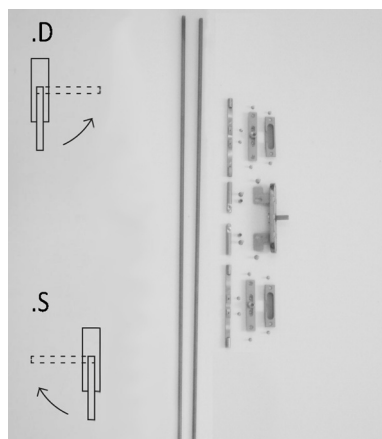
ZN acciaio zincato | galvanized steel
BR ottone naturale | natural brass

**AC2680E.xx**

Maniglia di trascinamento
per aperture esterne
con profilo PR2562MB

Pulling handle for outward opening with PR2562MB profile

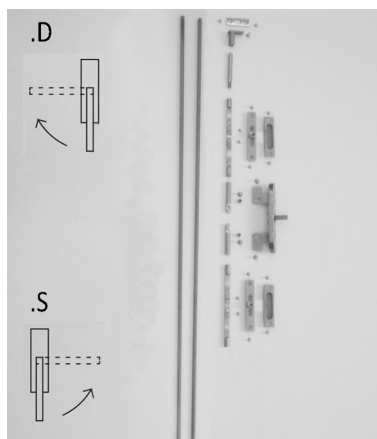
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass

**AC2683.D**

Kit cremonese dx per finestre
ad un anta e su soglia
apertura esterna
*RH cremonese bolt set for single leaf
windows and on threshold
outward opening*

AC2683.S

Kit cremonese sx per finestre
ad un anta e su soglia
apertura esterna
*LH cremonese bolt set for single
leaf windows and on threshold
outward opening*

**AC2684SG.D**

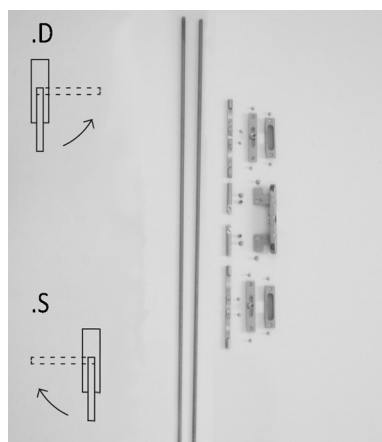
Kit cremonese dx per finestre
a due ante su soglia - ap. esterna

*RH cremonese bolt set for double
leaf windows on threshold -
outward opening*

AC2684SG.S

Kit cremonese sx per finestre
a due ante su soglia - ap. esterna

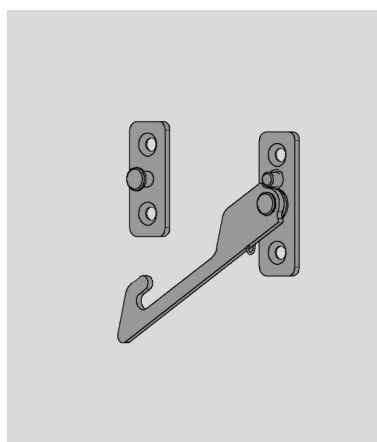
*LH cremonese bolt set for double leaf
windows on threshold - outward
opening*

**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*

**AC2685.D**

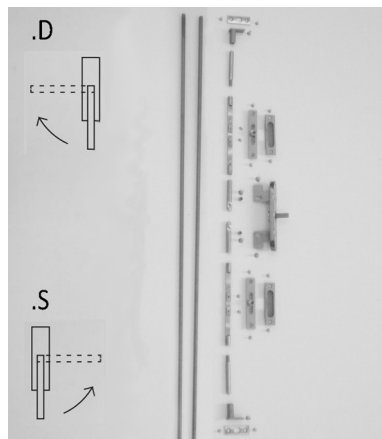
Limitatore di apertura per aereazione
APR interna dx | APR esterna sx

*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*

**AC2684.D**

Kit cremonese dx per finestre
a due ante - apertura esterna

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

AC2684.S

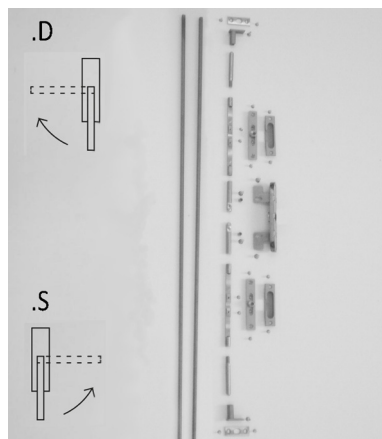
Kit cremonese sx per finestre
a due ante - apertura esterna

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

**AC2686**

Braccetto limitatore di apertura
frizionato

Window restrictor

**AC2684E.D**

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

**AC2687**

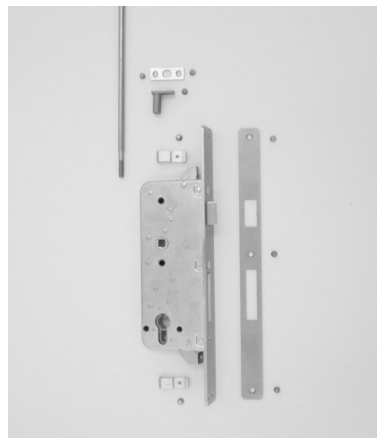
Braccetto limitatore di apertura
esterna finestra con blocco

*Casement stay
outward opening*

**AC2688**

Coppia compassi
apertura a sporgere
Peso massimo anta 100 kg

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

**AC2694.D**

Kit serratura multipunto dx
per porta

RH Multi-lock set for door

AC2694.S

Kit serratura multipunto sx
per porta

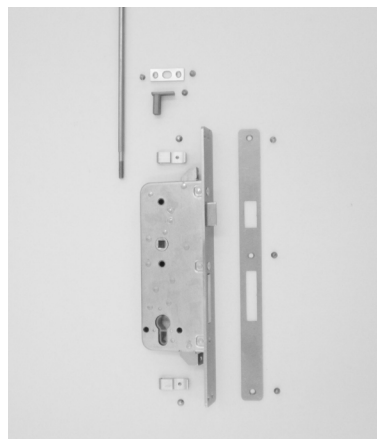
LH Multi-lock set for door

Vedi pg. 4.5.25 per la scelta
For the choice see pg. 4.5.25

**AC2689**

Coppia compassi
apertura a sporgere
Peso massimo anta 40 kg

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

**AC2694R.D**

Kit serratura a rullo multipunto
dx per porta

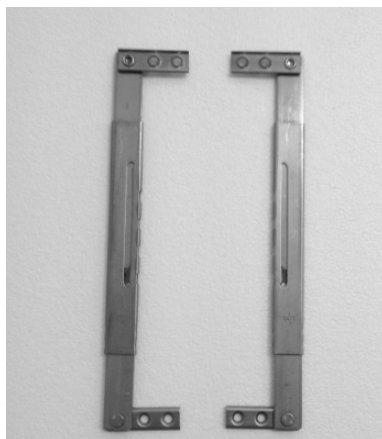
*RH multipoint roller lock kit for
door*

AC2694R.S

Kit serratura a rullo multipunto
sx per porta

*LH multipoint roller lock kit for
door*

Vedi pg. 4.5.24 per la scelta
For the choice see pg. 4.5.24

**AC2690**

Braccetti limitatori
apertura a sporgere

*Casement stays for
awning opening*

**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

Vedi pg. 4.5.26 per la scelta
For the choice see pg. 4.5.26

**AC2693**

Serratura con scrocco e
catenaccio

Latch and bolt lock

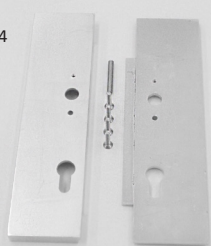
**AC2696.xx**

Scatola copri serratura
Destra

RH lock cover box

Vedi pg. 5.3.1 per la scelta
For the choice see pg. 5.3.1

AISI 304



ZN acciaio zincato | *galvanized steel*
BR ottone naturale | *natural brass*

AC2697.xx

Scatola copri serratura
Sinistra

LH lock cover box

Vedi pg. 5.3.1 per la scelta
For the choice see pg. 5.3.1

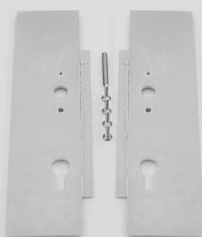
**AG1224C.xx**

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*
AG1224C.GR grigio | *grey*

AISI 304



ZN acciaio zincato | *galvanized steel*
BR ottone naturale | *natural brass*

AC2696BV.xx

Scatola copri serratura
Destra/Sinistra
per fermavetro
PA2028CA

*RH/LH lock cover box
 for glazing bead
 PA2028CA*

**AG2580**

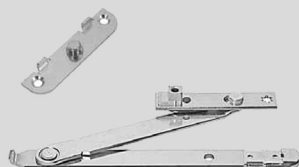
Coppia di cerniere a scomparsa
per vasistas su profilo PR2543MB
Peso max anta 70 kg

*Pair of concealed hinges for
 bottom hung window
 on PR2543MB profile
 Max leaf weight 70 kg*

AG1386

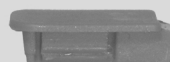
Limitatore di apertura frizionato
per meccanismi A/R a scomparsa
Solo per meccanismi EASY

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

**AG6530**

Limitatore di corsa per
meccanismi A/R

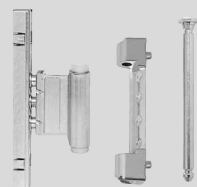
*Opening limiter on tilt&turn
 mechanism*

**AG2524**

Cerniera a tre ali ad avvitare per
vasistas con profilo PR2543MB
Peso max anta 70 kg

*Screw-on hinge for bottom-hung
 window with PR2543MB profile
 Max leaf weight 70 kg*

Solo con profilo telaio PR2513H
Only with frame profile
PR2513H

**CV1023**

Vite per boccola 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*

**CV1242**

Vite trilobata
TPS M4x6

*Thread cutting machine screw
TPS M4x6*

**CV1271**

Vite trilobata
TPS M4x16

*Thread cutting machine screw
TPS M4x16*

**CV1243**

Vite trilobata
TPS M4x8

*Thread cutting machine screw
TPS M4x8*

**CV5012**

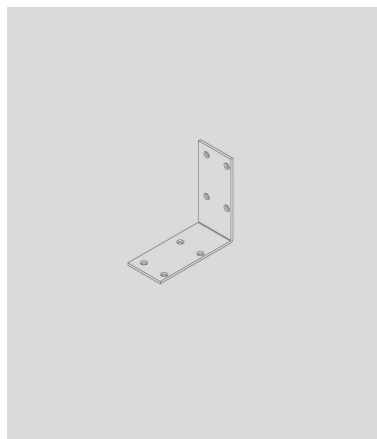
Boccola per fermavetri in
alluminio

*Bushing for aluminium
glazing bead*

**CV1244**

Vite trilobata
TPS M4x10

*Thread cutting machine screw
TPS M4x10*

**AC2986R-CA**

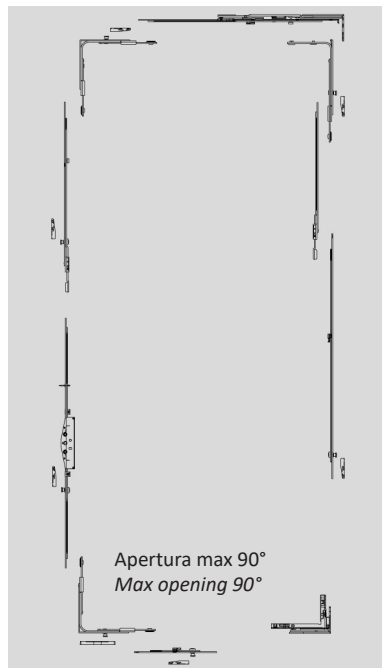
Squadretta interna assiemaggio
anta MB 85

*MB 85 internal door assembly
square*

**CV1245**

Vite trilobata
TPS M4x12

*Thread cutting machine screw
TPS M4x12*

**AGE581.xx**

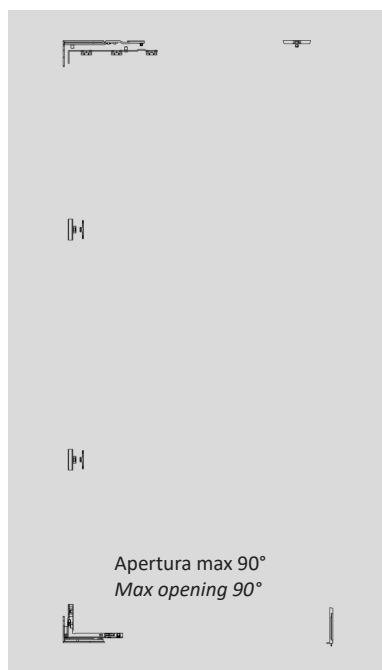
Meccanismo A/R prima anta Dx cerniere a scomparsa

*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

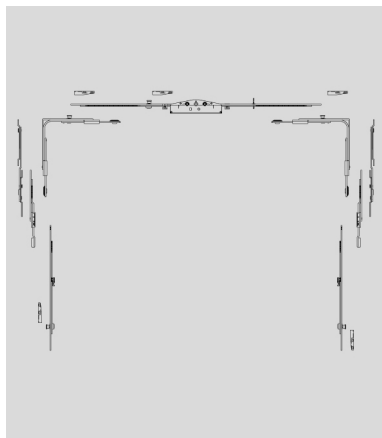
*Second leaf RH tilt-turn mechanism with concealed hinges***EASY****AGE586.xx**

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***AG 2580**Coppia di cerniere a scomparsa
per vasistas su profilo PR2543CA
Peso max anta 70 kg*Pair of concealed hinges for
bottom hung window
on PR2543CA profile
Max leaf weight 70 kg*

**AG2574.xx**

Meccanismo vasistas con cremonese su traverso superiore

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

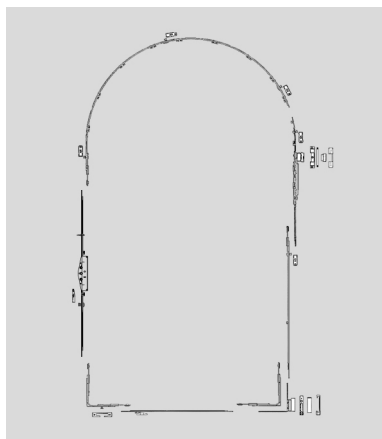
EASY

altezza - height

	430	661	861
	660	860	1200
larghezza width	670-860	A2	B2
	861-1200	A3	B3
	1201-1400	A4	B4

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 70-100 kg*

**AG2578**

Meccanismo A/R curvo ad una o due ante con cerniere a vista
(specificare all'ordine misure cava ferramenta e mano di apertura)

*Tilt-turn mechanism with visible hinges for arched windows
(Specify hardware slot size and the opening)*

EASY

Solo con profilo telaio PR2513H

Only with frame profile PR2513H

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 80 kg*

Larghezza massima | *Maximum width: 1200 mm*

Altezza massima arco reale | *Maximum height arch: 1900 mm*

Altezza massima arco ribassato | *Maximum height segmental arch: 2400 mm*

**AG1278C.xx**

Kit copertine destre in plastica
per kit A/R AG2578

*Plastic right-cover kit for
tilt&turn for kit AG2578*

AG1279C.xx

Kit copertine sinistre in plastica
per kit A/R AG2578

*Plastic left-cover kit for tilt&turn
for kit AG2578*



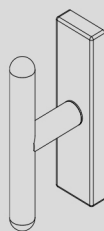
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV673.xx

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

*Cover for gratz mechanism
 on kit*

AC2624E | AC2625E
 AC2683E | AC2684E

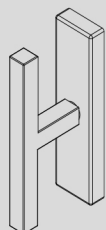


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV776.xx

Martellina cremonese
 "VITRUVIO" medium
 per finestra
 KIDS

*Cremona handle
 "VITRUVIO" medium
 for window
 KIDS*

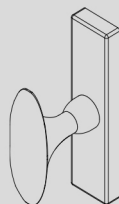


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV770.xx

Martellina cremonese
 "VITRUVIO" small
 per finestra
 T | quadra | tronca

*Cremona handle
 small "VITRUVIO"
 for window
 T | square | cut*

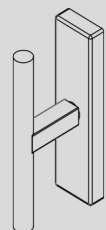


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass

ACV777.xx

Martellina cremonese
 "VITRUVIO"
 per finestra
OVALE

*Cremona handle
 small "VITRUVIO"
 for window
 OVAL*

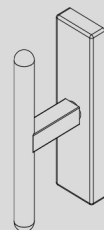


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV771.xx

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

*Cremona handle
 small "VITRUVIO"
 for window
 T | round | cut*

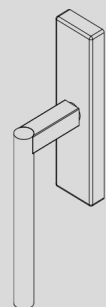


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV779.xx

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

*Cremona handle
 small "VITRUVIO"
 for window
 T | round | sphere*

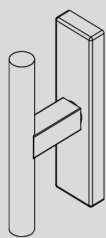


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV773.xx

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

*Cremona handle
 small "VITRUVIO"
 for window
 L | round | cut*

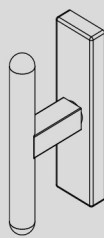


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV871.xx

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

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

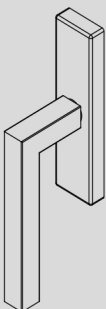


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV879.xx

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

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

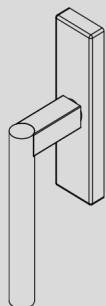


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

ACV872.xx

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

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

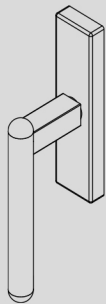


BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

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
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

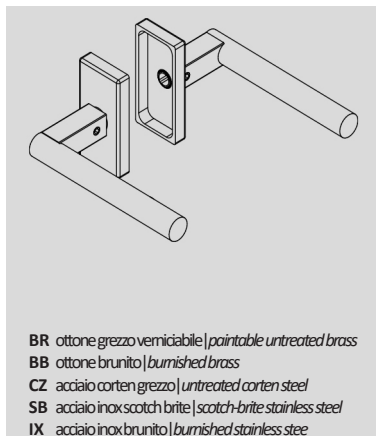
ACV874S.xx

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

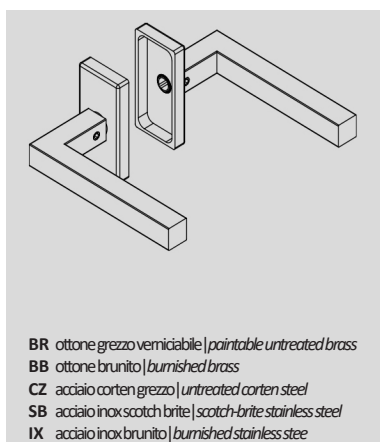
*Cremone handle
 medium "VITRUVIO"
 for window
 L | round | sphere*

**AC2775/1**

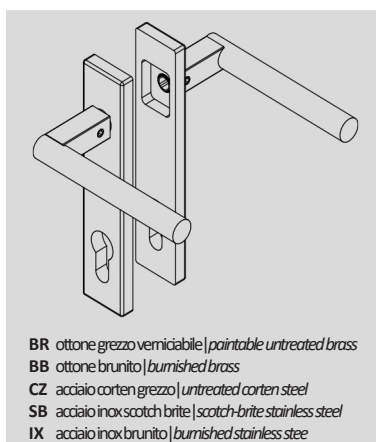
Quadro maniglia

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*

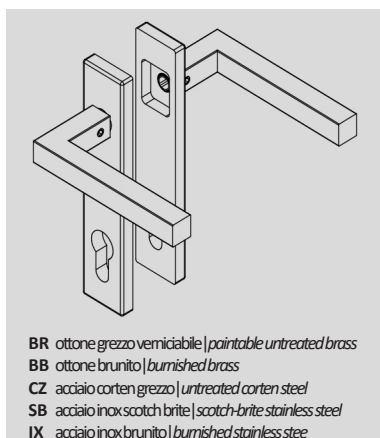
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

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

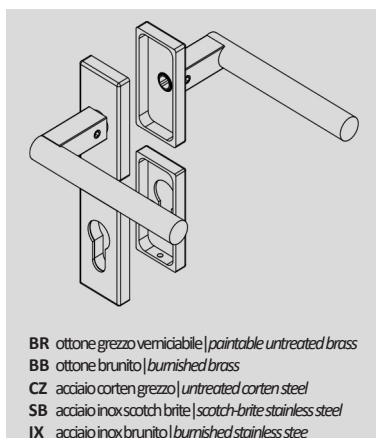
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**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*

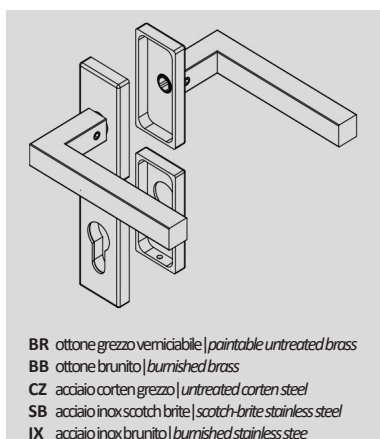
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**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*

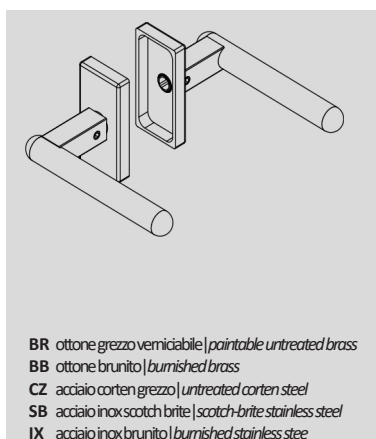
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**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*

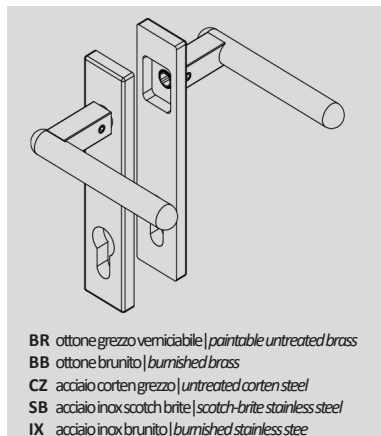
BR ottone grezzo verniciabile | paintable untreated brass
 BB ottone brunito | burnished brass
 CZ acciaio corten grezzo | untreated corten steel
 SB acciaio inox scotch brite | scotch-brite stainless steel
 IX acciaio inox brunito | burnished stainless steel

**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

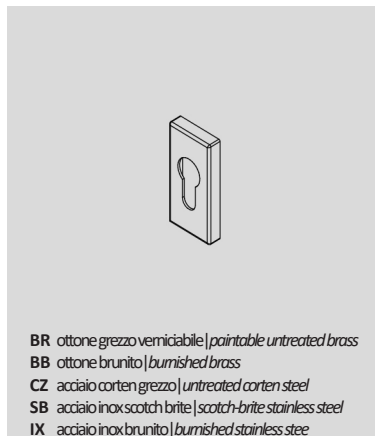
**ACV954S.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | sfera*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | sphere*

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

**ACV954SB.xx**

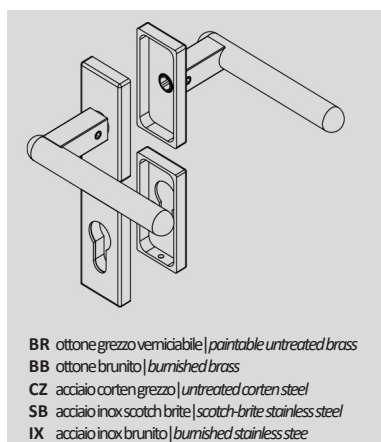
Coppia maniglie per porta
 "VITRUVIO" medium
 bocchetta con copri cilindro
 integrato e interasse maniglia
 85 mm
 L | tonda | sfera

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

**ACV964.xx**

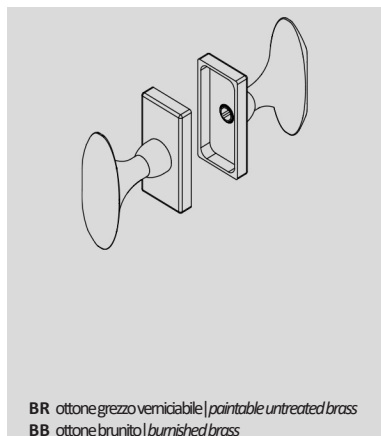
Bocchetta copri cilindro a profilo
 europeo

*Euro profile cylinder escutcheon
 plate*

**ACV954SC.xx**

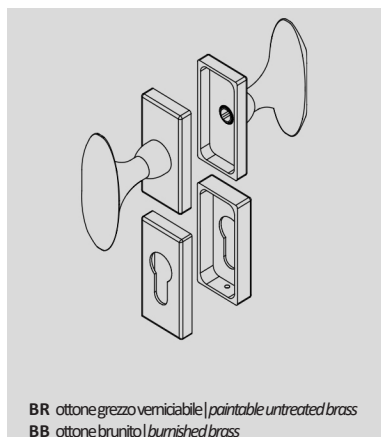
Coppia maniglie per porta
 "VITRUVIO" medium
 bocchetta rettangolare
 con copri cilindro
 L | tonda | sfera

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

**ACV955.xx**

Coppia maniglie per porta
 "VITRUVIO"
 bocchetta rettangolare
 OVALE

*Double door handlesets
 "VITRUVIO"
 rectangular escutcheon
 OVAL*

**ACV955C.xx**

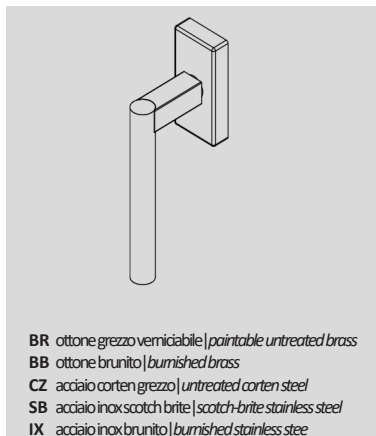
Coppia maniglie per porta
 "VITRUVIO"
 bocchetta rettangolare
 con copri cilindro
 OVALE

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

**AC2556**

Meccanismo DK esterno per maniglie "Vitruvio"

External tilt and turn mechanism for "Vitruvio" handles

**ACV973.xx**

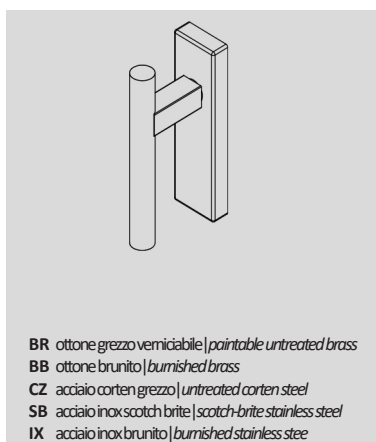
Maniglia per DK finestra "VITRUVIO" medium
L | tonda | tronca

*DK window handle "VITRUVIO" medium
L | round | cut*

**ACR055**

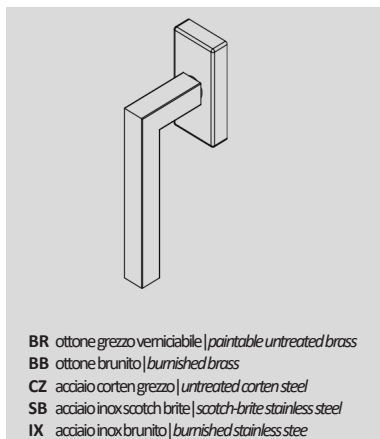
Quadro riduzione per martellina DK commerciale

Spindle reducer for commercial DK handle

**ACV973H.xx**

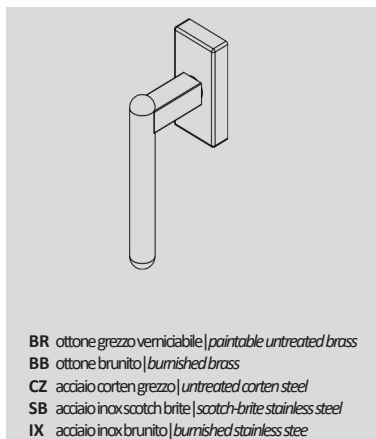
Maniglia per DK finestra "VITRUVIO" medium
H | tonda | tronca

*DK window handle "VITRUVIO" medium
H | round | cut*

**ACV972.xx**

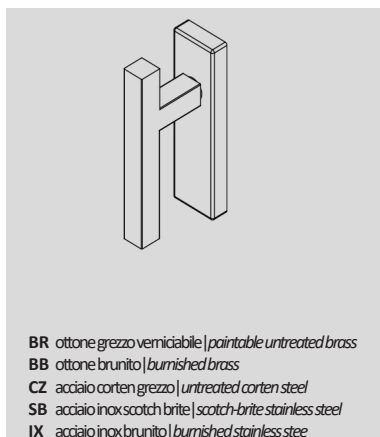
Maniglia per DK finestra "VITRUVIO" medium
L | quadra | tronca

*DK window handle "VITRUVIO" medium
L | square | cut*

**ACV974S.xx**

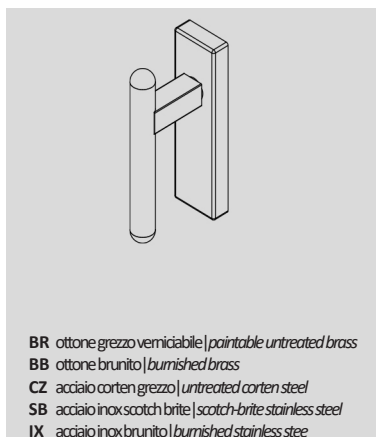
Maniglia per DK finestra "VITRUVIO" medium
L | tonda | sfera

*DK window handle "VITRUVIO" medium
L | round | sphere*

**ACV972H.xx**

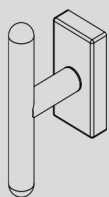
Maniglia per DK finestra "VITRUVIO" medium
H | quadra | tronca

*DK window handle "VITRUVIO" medium
H | square | cut*

**ACV974SH.xx**

Maniglia per DK finestra "VITRUVIO" medium
H | tonda | sfera

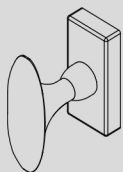
*DK window handle "VITRUVIO" medium
H | round | sphere*

**ACV976.xx**

Maniglia per DK finestra
"VITRUVIO" medium
KIDS

*DK window handle
"VITRUVIO" medium
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*

**ACV977.xx**

Maniglia per DK finestra
"VITRUVIO"
OVALE

*DK window handle
"VITRUVIO"
OVAL*

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

**GE 1001TT**

Guarnizione di battuta su soglia
per porte

Gasket for treshold on doors

**GE2645TT**

Guarnizione di battuta
interna | esterna su profili
PR2543MB | PR2943MB
PR2963MB | PR2962MB

*Internal/external weather
strip with
PR2543MB | PR2943MB
PR2963MB | PR2962MB
profiles*

**GE1011**

Guarnizione interna vetro
spessore 4 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GE2907TT**

Guarnizione sotto vetro

Under glass gasket

**GE2543TT**

Guarnizione di battuta
interna su profili
PR2543MB

*Internal weather strip
on profiles
PR2543MB*

**GP0095**

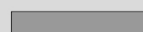
Guarnizione interna vetro
spessore 3mm

*Internal weather strip for
glazing bead
3 mm thick*

**GE2603**

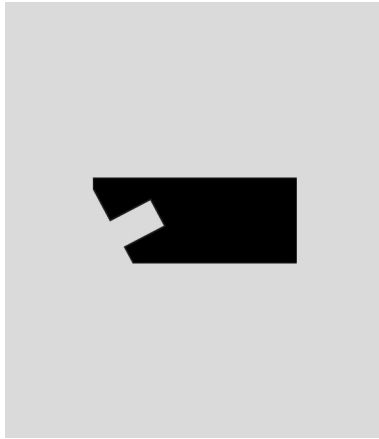
Guarnizione per giunto aperto
Apertura interna

*Weather strip for open joint
Inward opening*

**GU2036**

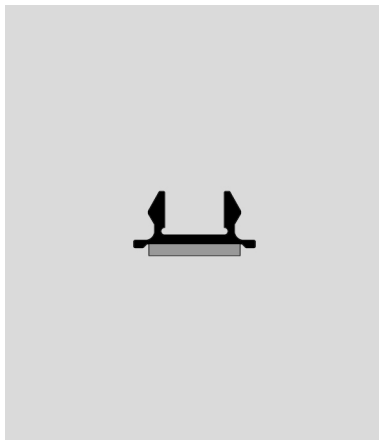
Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

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

**GU 2634**

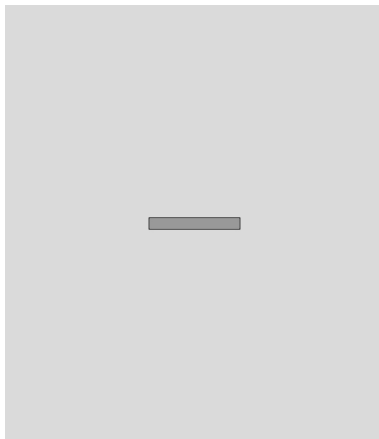
Estruso rigido in PVC per soglia
porte PR2630H

*Rigid extruded PVC section for
PR2630H threshold*

**GU2030E**

Profilo in PVC con biadesivo per
fissaggio dividivetro
PR2030BV

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

**GU2031**

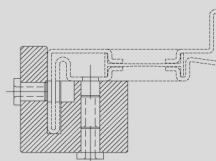
Biadesivo per dividivetro
12x1.5 mm

*Bi-adhesive tape for glass
divider
12x1.5 mm*

**AT2629**

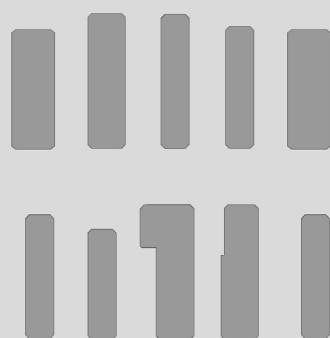
Maschera per esecuzione
fori fissaggio cerniere
AC2629-AC2630
AC2649-AC2650

*Drill jig for
AC2629-AC2630 hinges
AC2649-AC2650 hinges*

**AT2825**

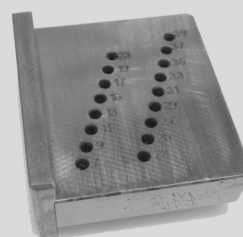
Maschera per applicazione
cremonese AC2624-AC2625
Profilo PR2943H
e aperture esterne

*Jig for AC2624-AC2625
cremonese bolt installation
PR2943H profile
and outward opening*

**AT2900MB**

Kit ganasce di taglio sistema
MB 85

*Kit of cutting jaws for profiles
MB 85*

**AT2828**

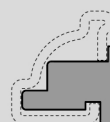
Maschera per esecuzione fori
fissaggio fermavetri

*Drill jig for glazing beads
securing*

**AT2900H**

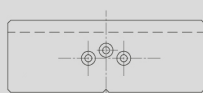
Kit ganasce di taglio

Kit of cutting jaws for profiles

**ATE 028CA**

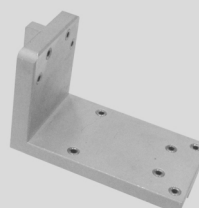
Ganasce di taglio per
PA2028CA

*Cutting jaws for
PA2028CA*

**AT2818**

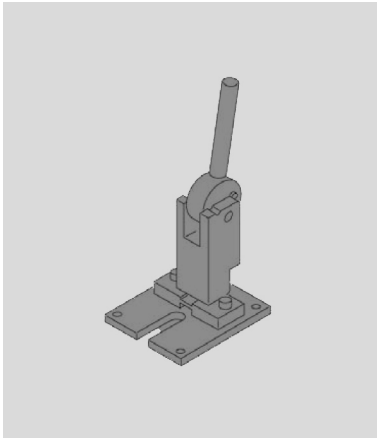
Maschera per esecuzione fori
per applicazione scarico acqua
AC2618 - AC2618NE

*Drill jig for AC2618 - AC2618NE
water drip installation*

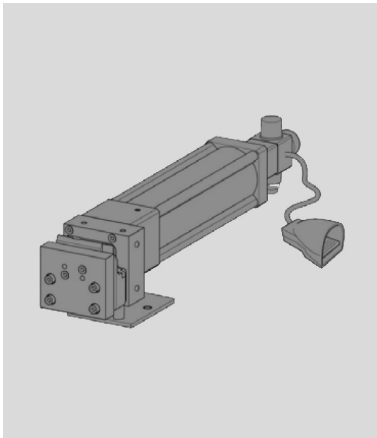
**ATG281**

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

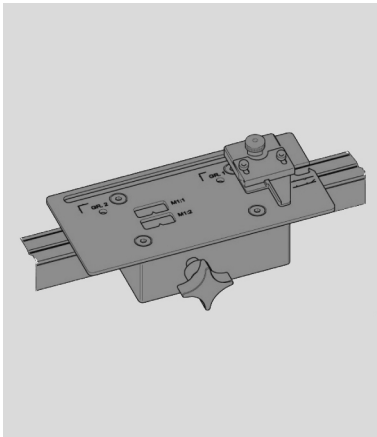
*Template kit for drilling holes
for tilt-turn kit with concealed
hinges*

**ATG311**

Trancia manuale

Manual punching machine**ATG312**

Trancia oleopneumatica

Oil-pneumatic punching machine**ATG313**

Asta millimetrata per trancia oleopneumatica

Rod divided into millimetres for oil-pneumatic punching machine**AT030CA**

Fresa per profilo PA2030CA - PA2034CA

*Milling cutter for profiles
PA2030CA - PA2034CA*

**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**

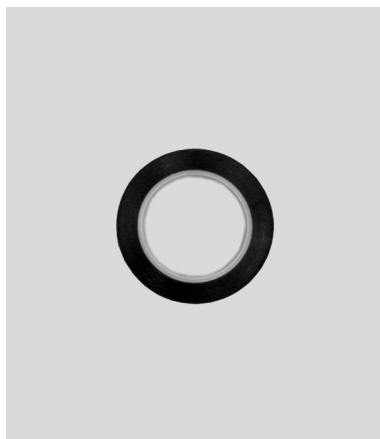
Brunitore per acciaio inox
1 l

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

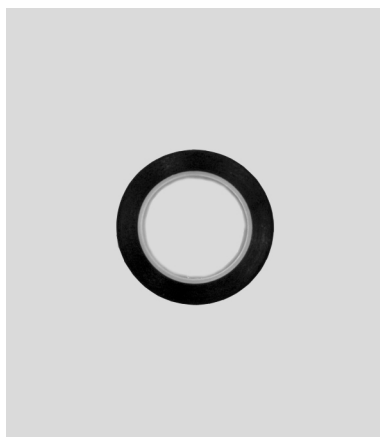
Adhesive tape for painting
24 mm

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**

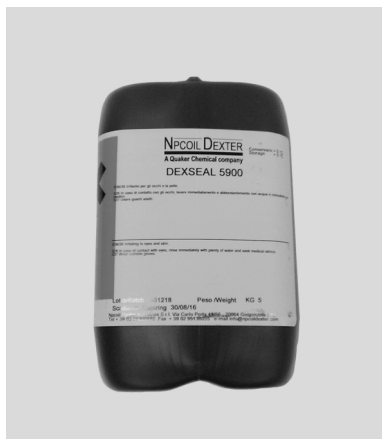
Acido per ossidazione corten
1 l

Oxidising acid for corten
1 l

**SL0019**

Sigillante a freddo per giunzione
angoli e trasversi
1 kg

*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**

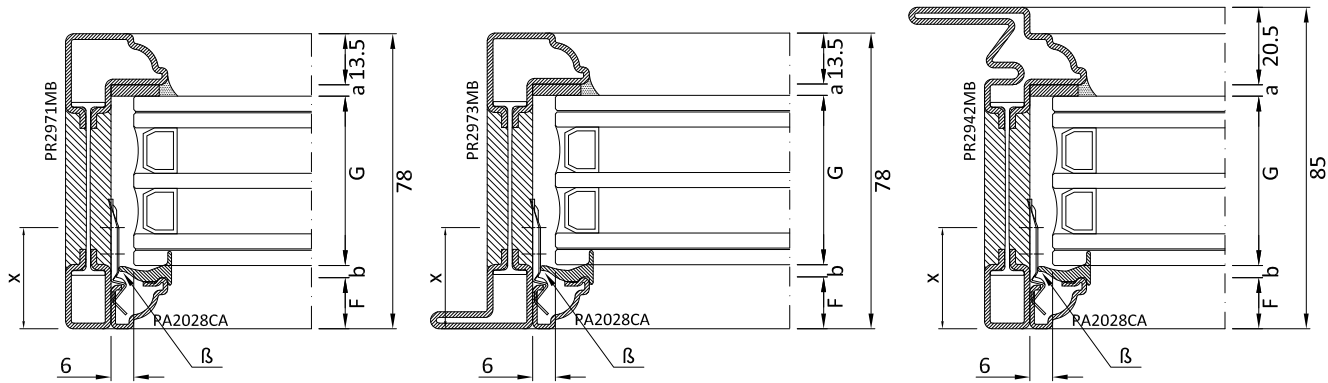
Silicone nero per guarnizioni

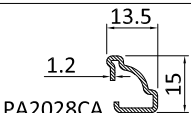
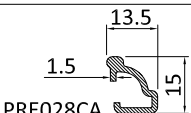
Black silicone for gaskets

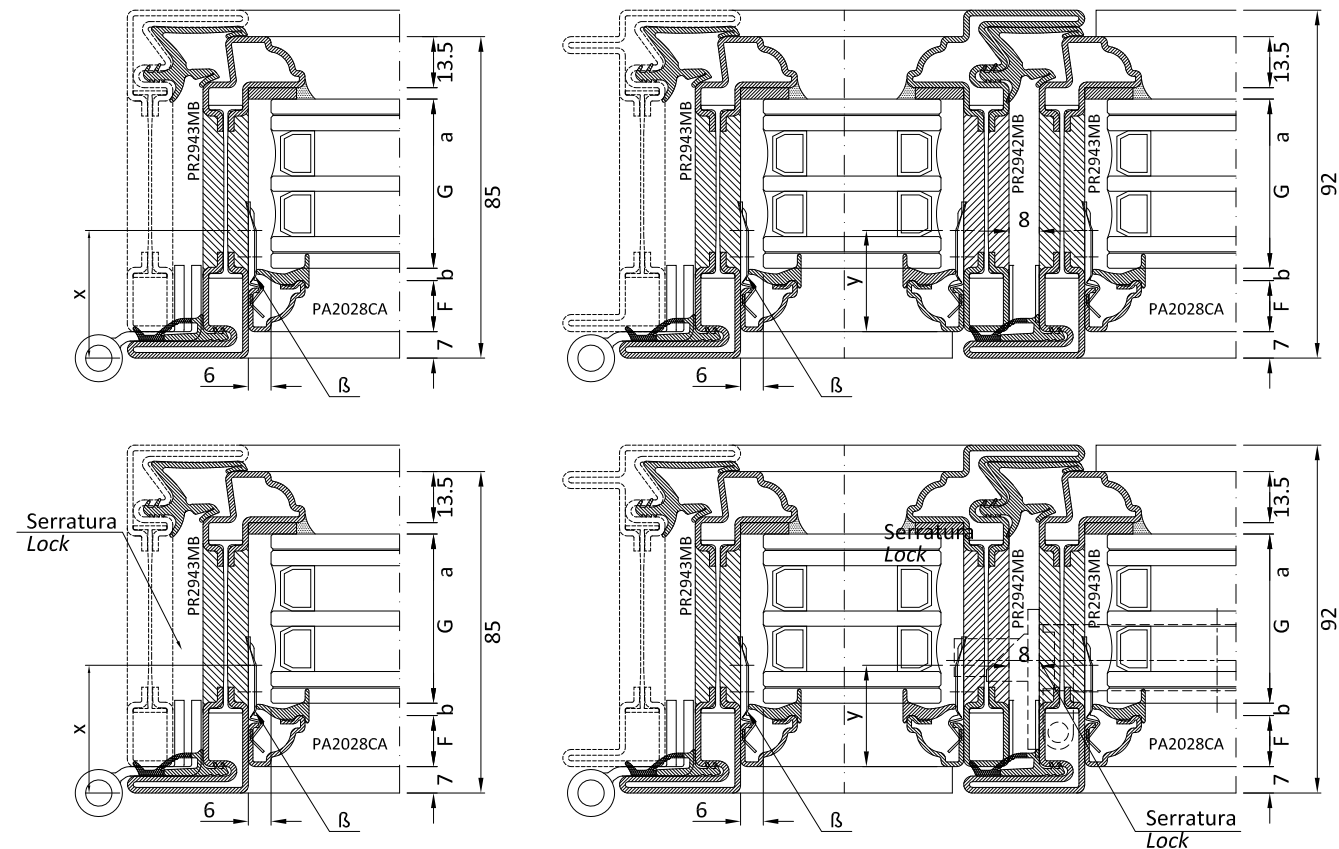
**SA3003**

Cera d'api per finitura corten
5 kg

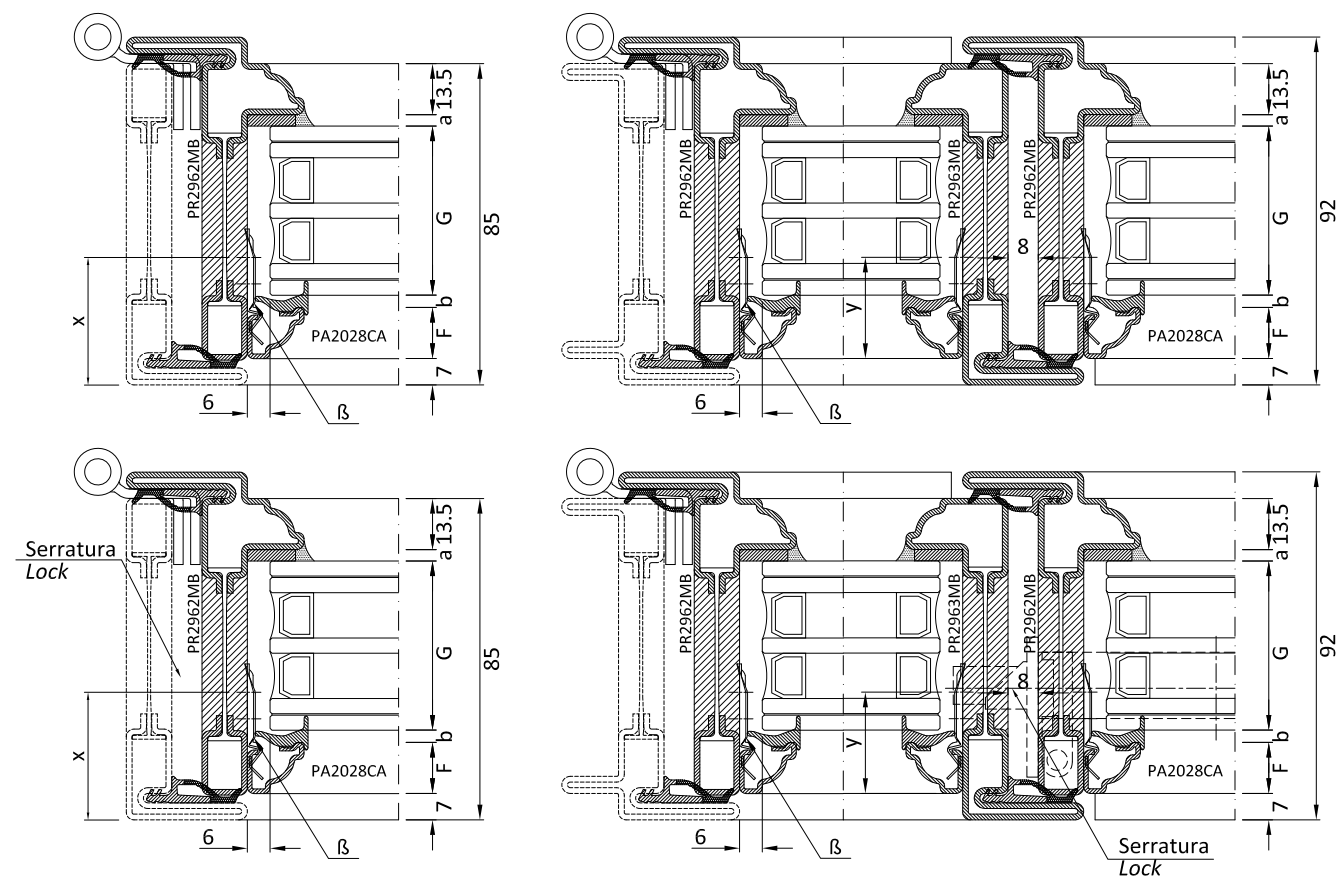
Beeswax for Corten finishing
5 kg

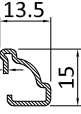
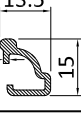


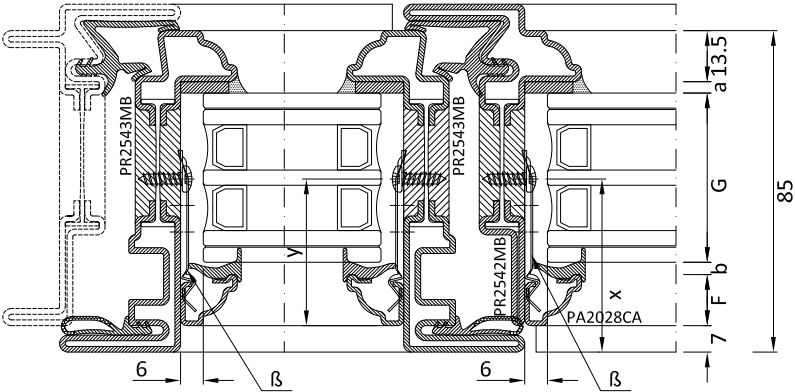
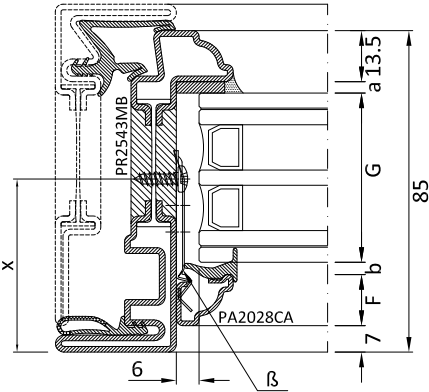
F	G	Guarnizioni - gasket			
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	clips fissaggio fermavetro glazing beads securing clips
codice code	mm			x	
	Fisso 78/85 Fix 78/85	a	b	Fisso 81 Fix 81	β
 PA2028CA	44	3	4	27	AC2608
 PRE028CA	44	3	4	27	AC2608

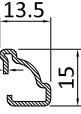


F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	y	β
1.2 PA2028CA 13.5 15	44	3	4	34	27	AC2608
1.5 PRE028CA 13.5 15	44	3	4	34	27	AC2608

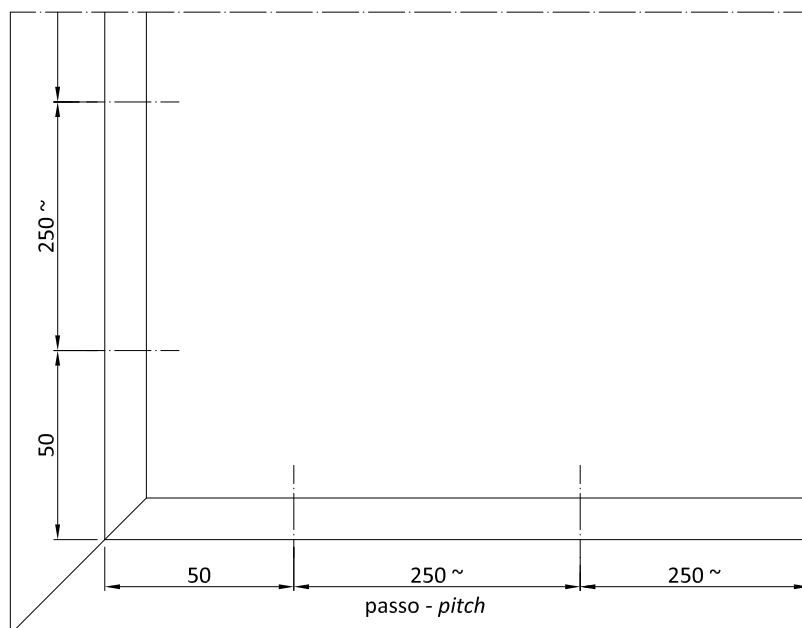


F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis		clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	y	β
 PA2028CA	44	3	4	34	27	AC2608
 PRE028CA	44	3	4	34	27	AC2608

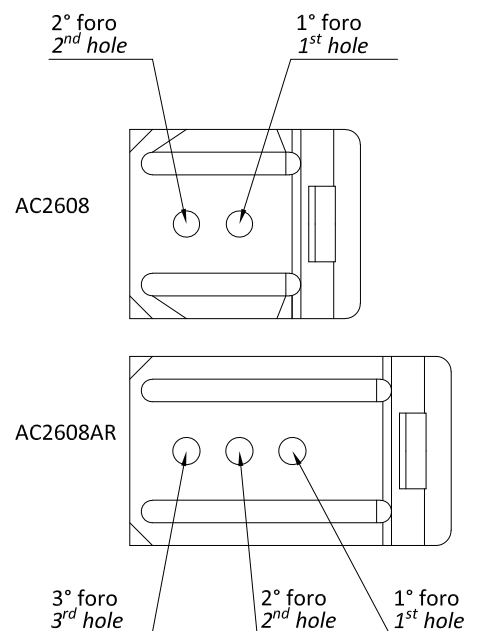


F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis		clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	y	β
 PA2028CA	44	3	4	46	39	AC2608AR
 PRE028CA	44	3	4	46	39	AC2608AR

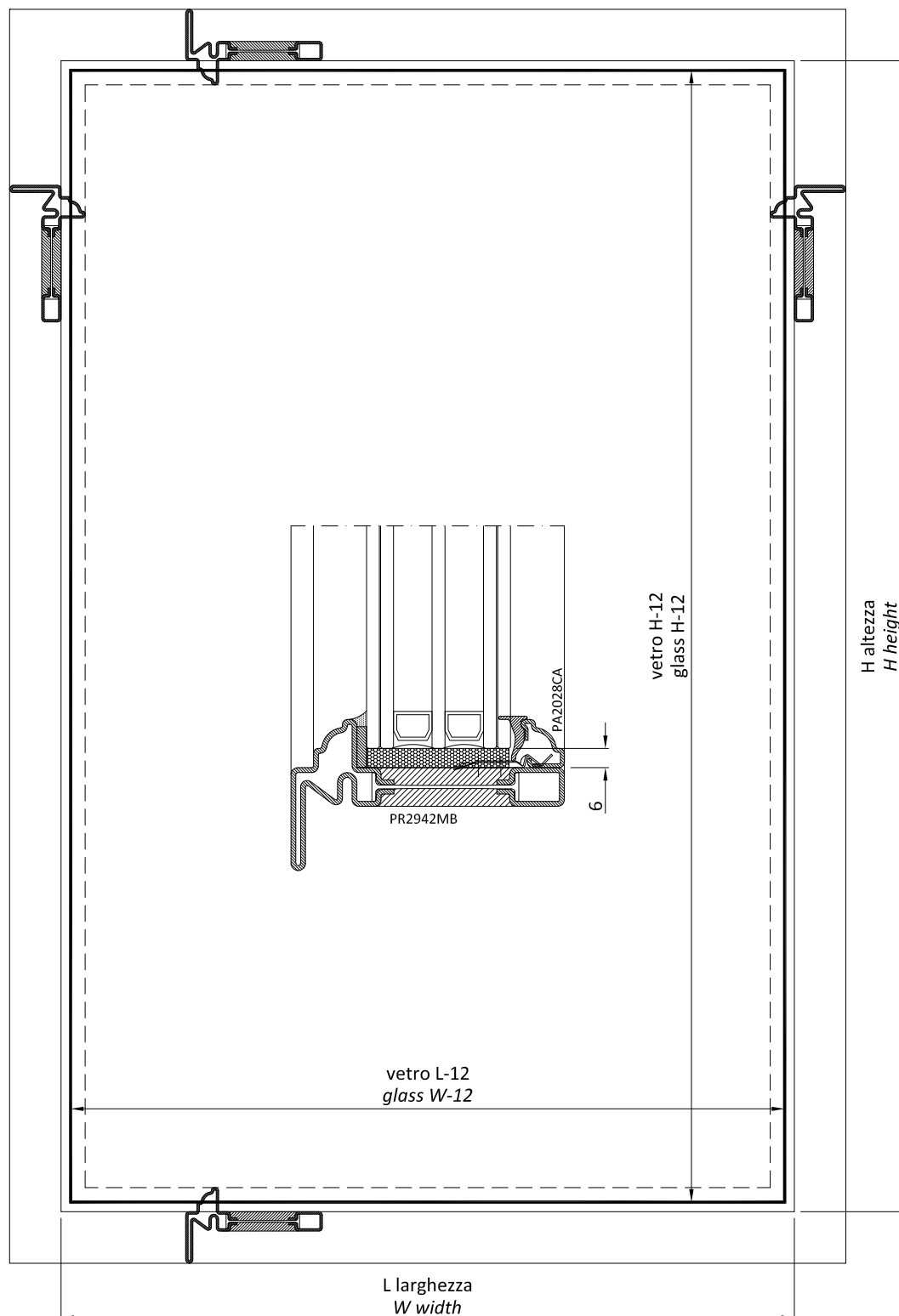
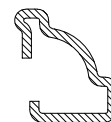
Fissaggio fermavetri PA2028CA: clip AC2608/AC2608AR con vite TC 3.5x9.5 (non fornite)
 Glazing beads fixing PA2028CA: clip AC2608/AC2608AR with screw TC 3.5x9.5 (not included)

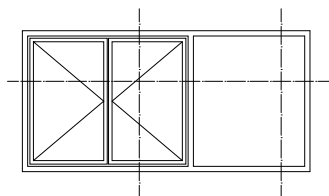


Passo clips fissaggio fermavetri
 Clip pitch for glazing beads securing



PR2028CA





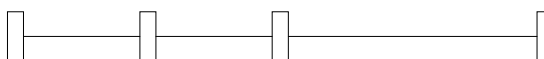
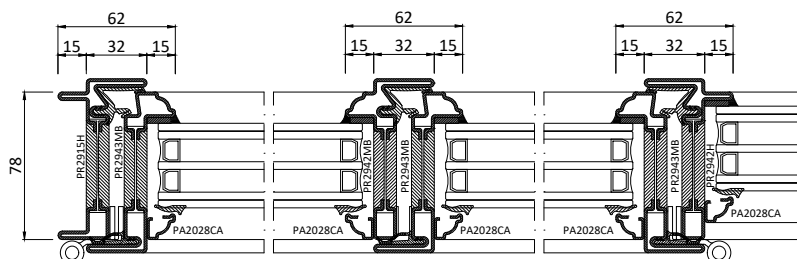
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa in luce

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



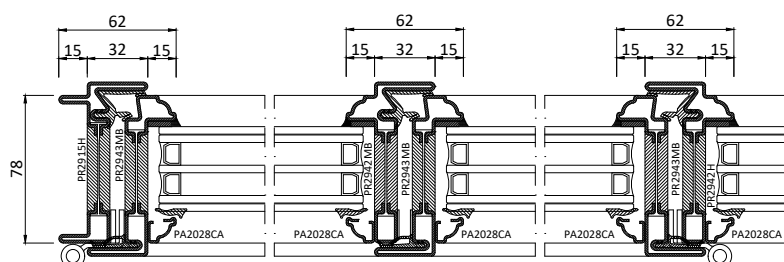
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

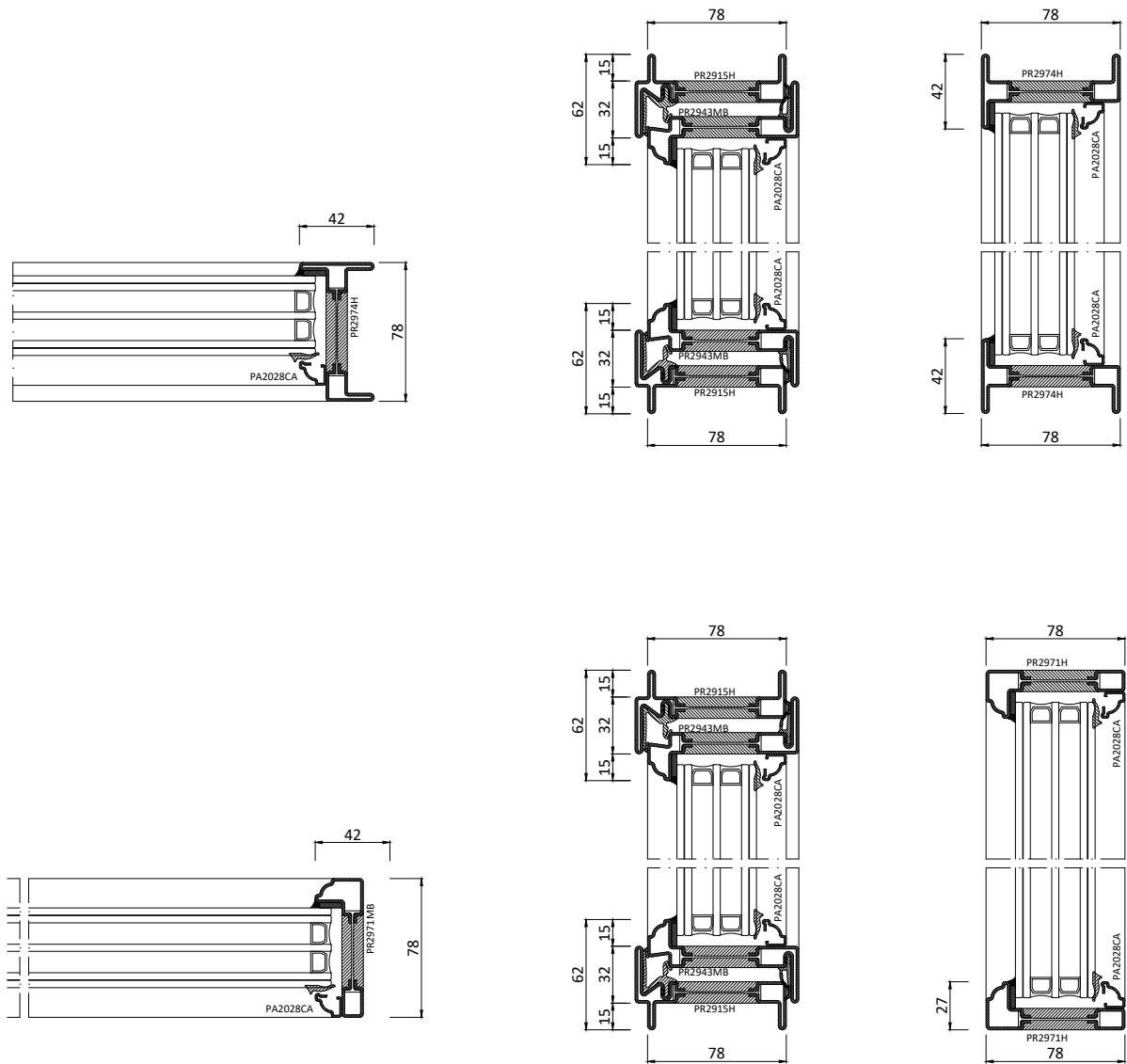
System 1
minimised sections
non-flush glasses
visible openings on the facade

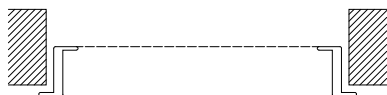
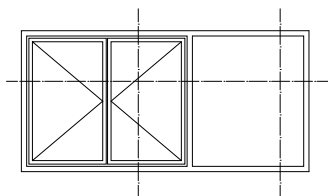


Sistema 2
sezioni congruenti
vetri complanari
aperture in evidenza nel prospetto

System 2
congruent sections
flush glasses
visible openings on the facade







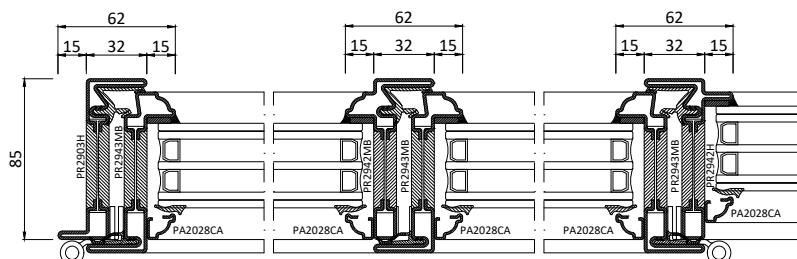
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa interno muro

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



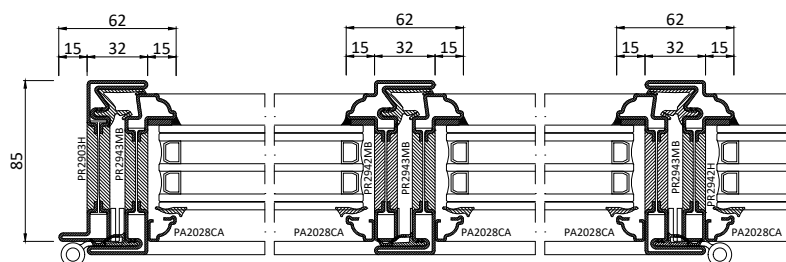
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

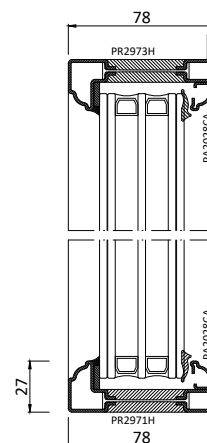
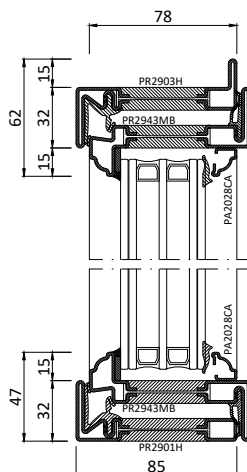
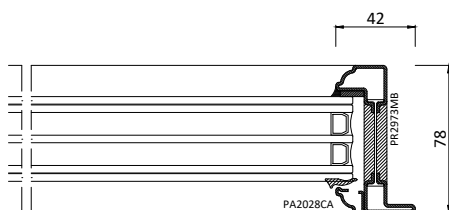
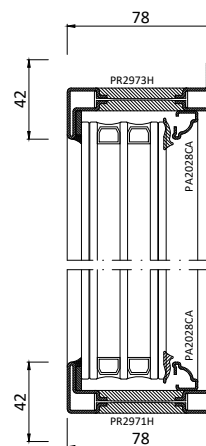
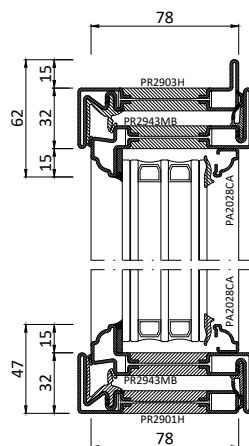
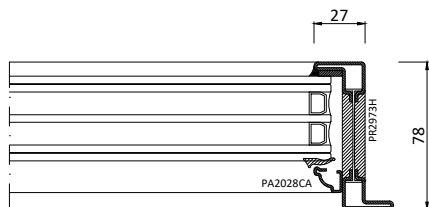
System 1
minimised sections
non-flush glasses
visible openings on the facade

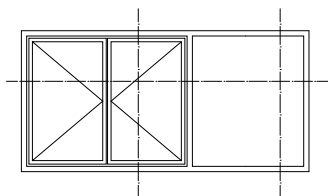


Sistema 2
sezioni congruenti
vetri complanari
aperture in evidenza nel prospetto

System 2
congruent sections
flush glasses
visible openings on the facade







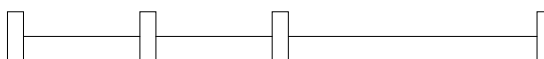
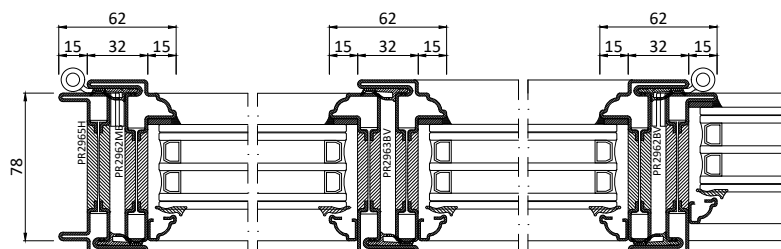
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa in luce

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



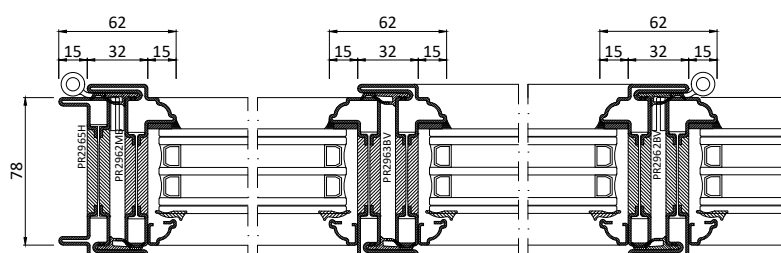
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

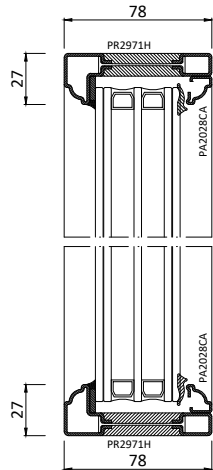
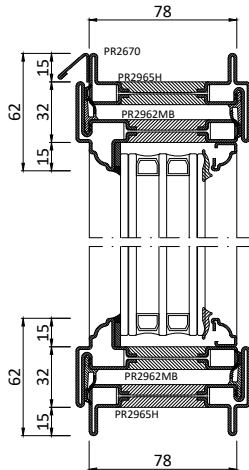
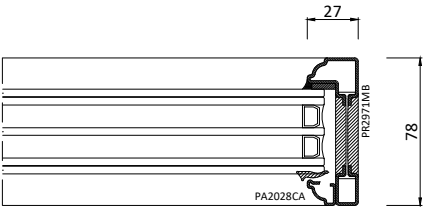
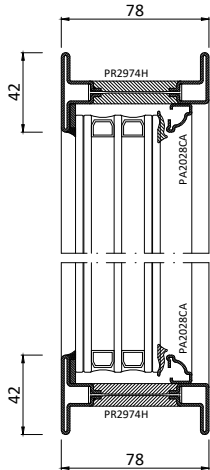
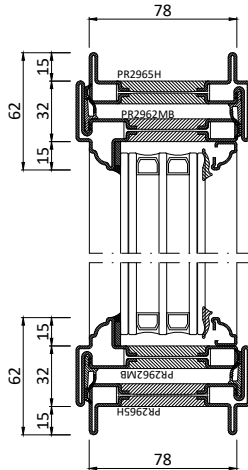
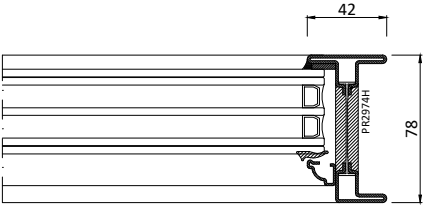
System 1
minimised sections
non-flush glasses
visible openings on the facade

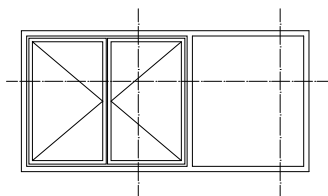


Sistema 2
sezioni congruenti
vetri complanari
aperture in evidenza nel prospetto

System 2
congruent sections
flush glasses
visible openings on the facade







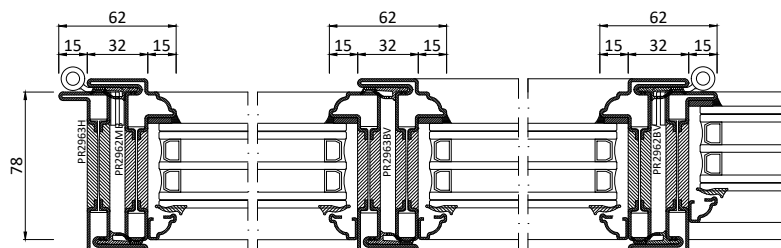
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa esterno muro

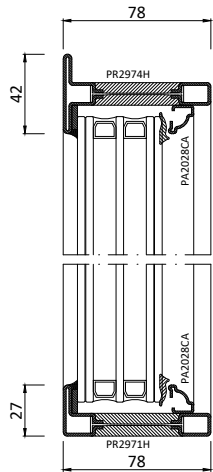
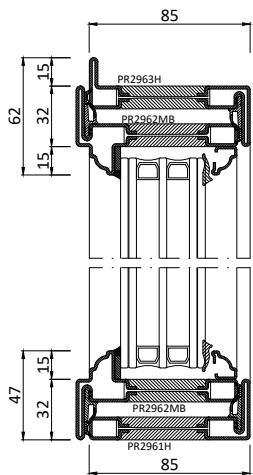
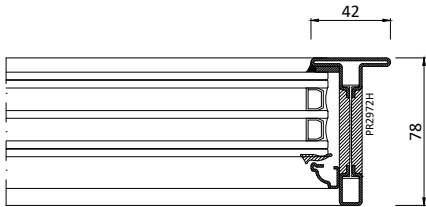
Type
double leaf window with fixed light
external opening
laying external wall

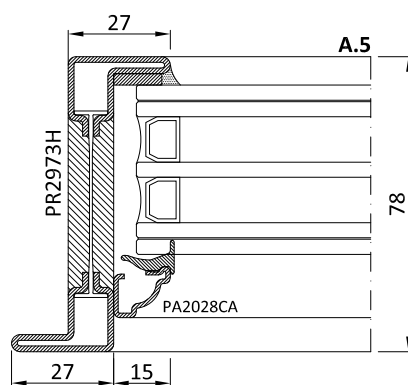
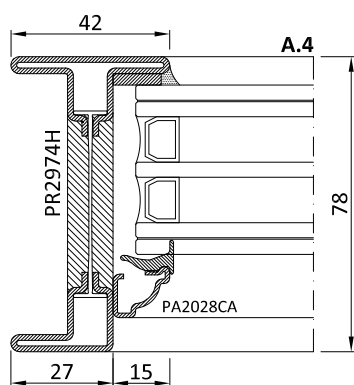
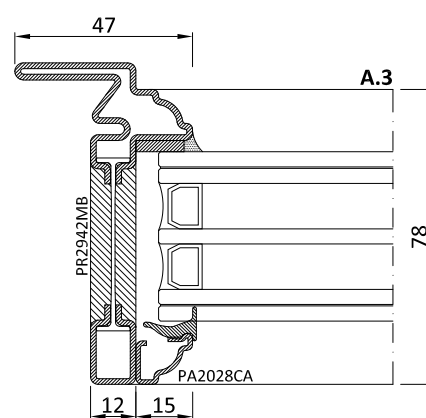
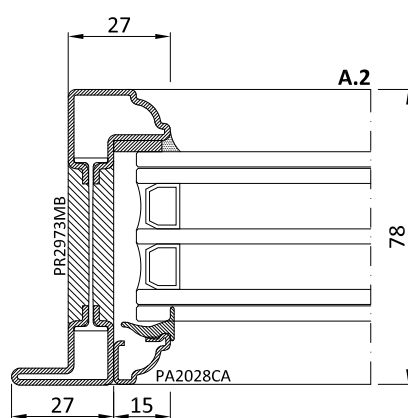
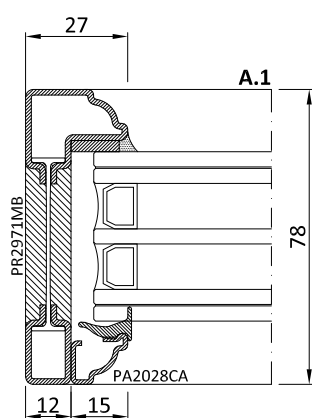
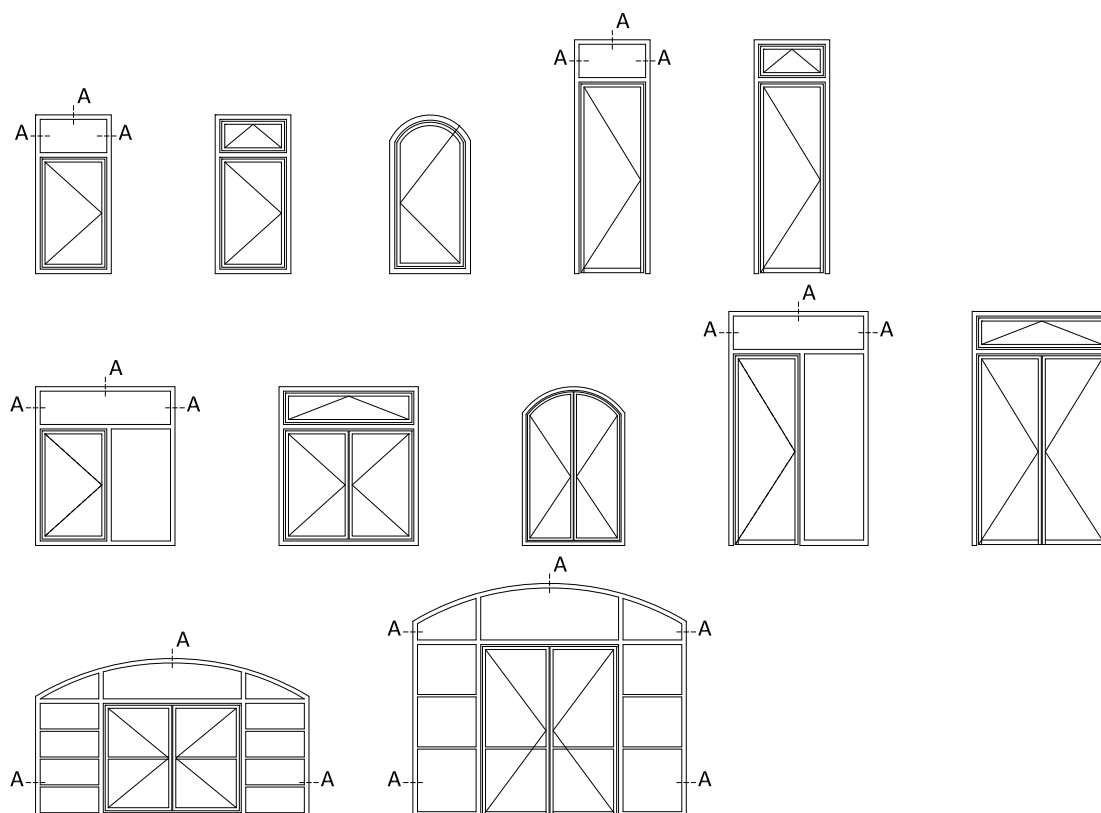


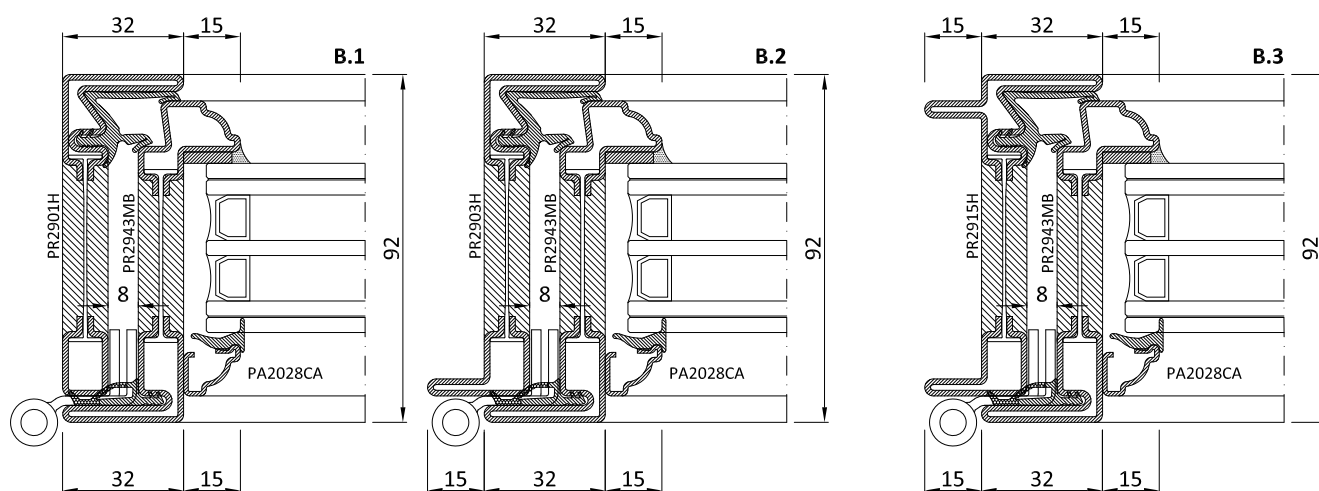
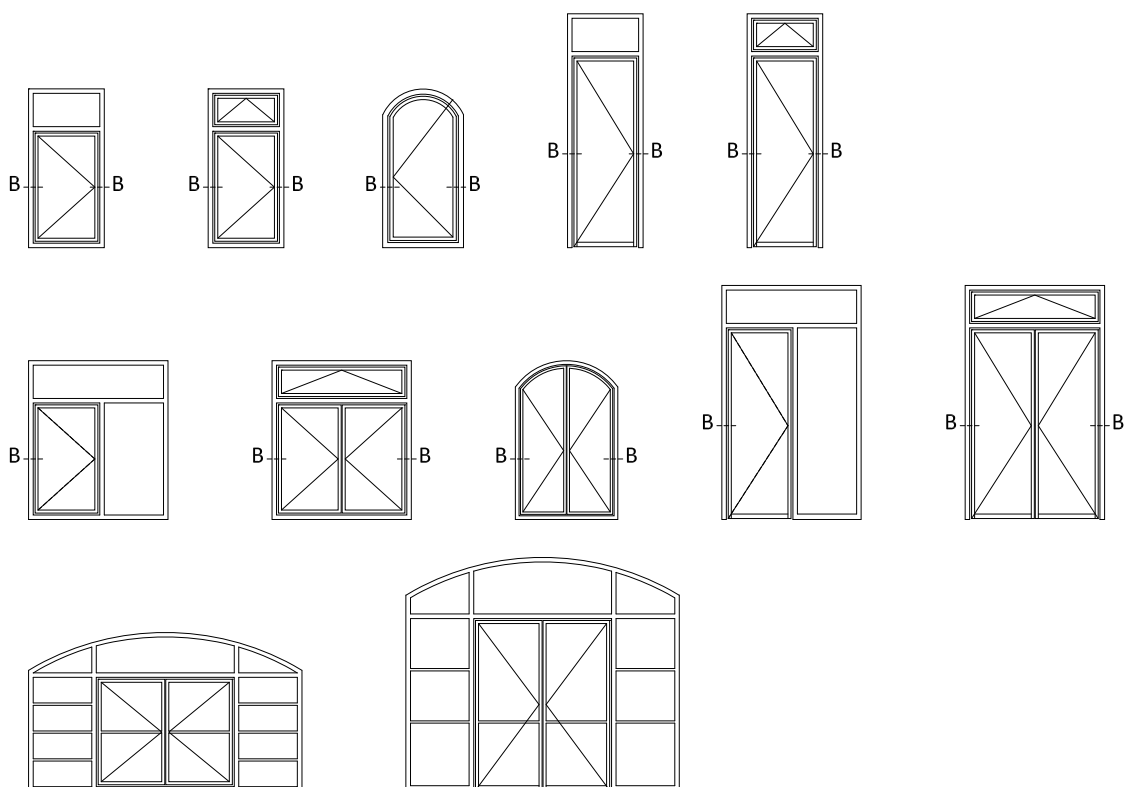
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

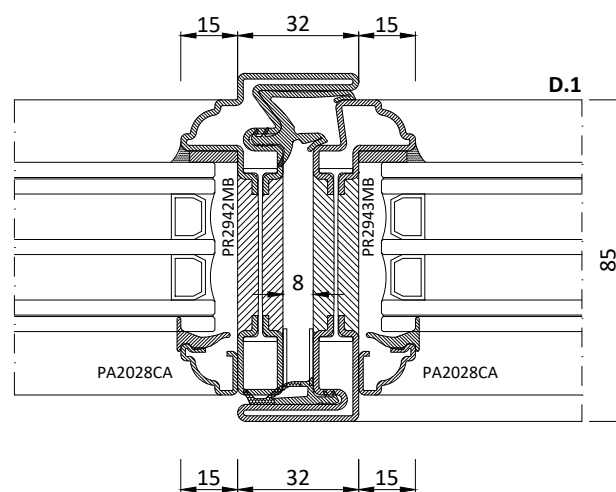
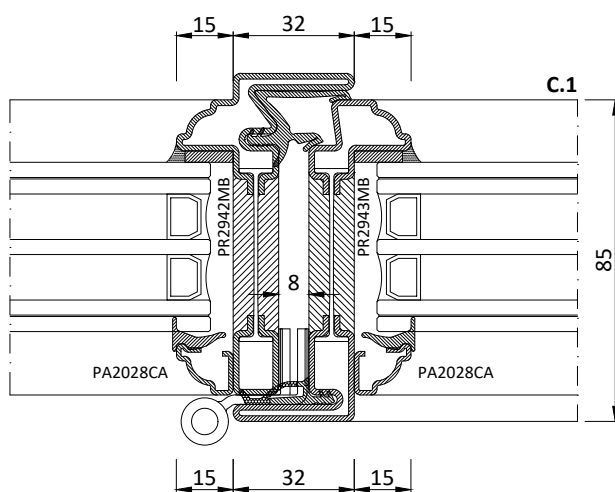
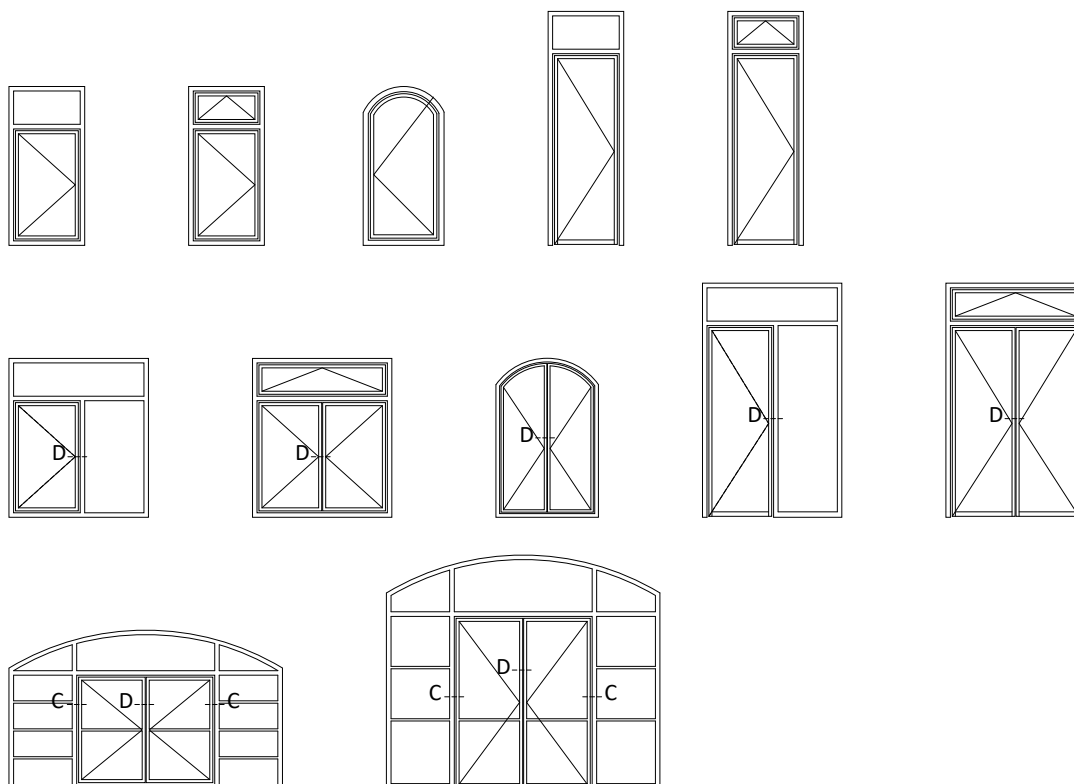
System 1
minimised sections
non-flush glasses
visible openings on the facade

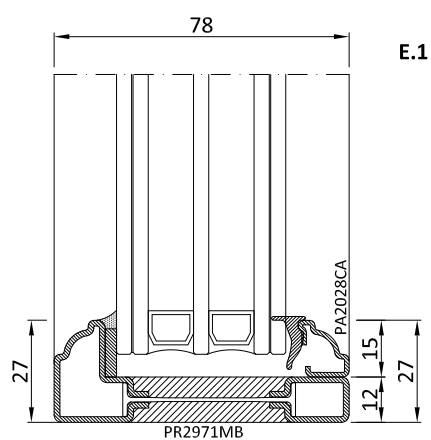
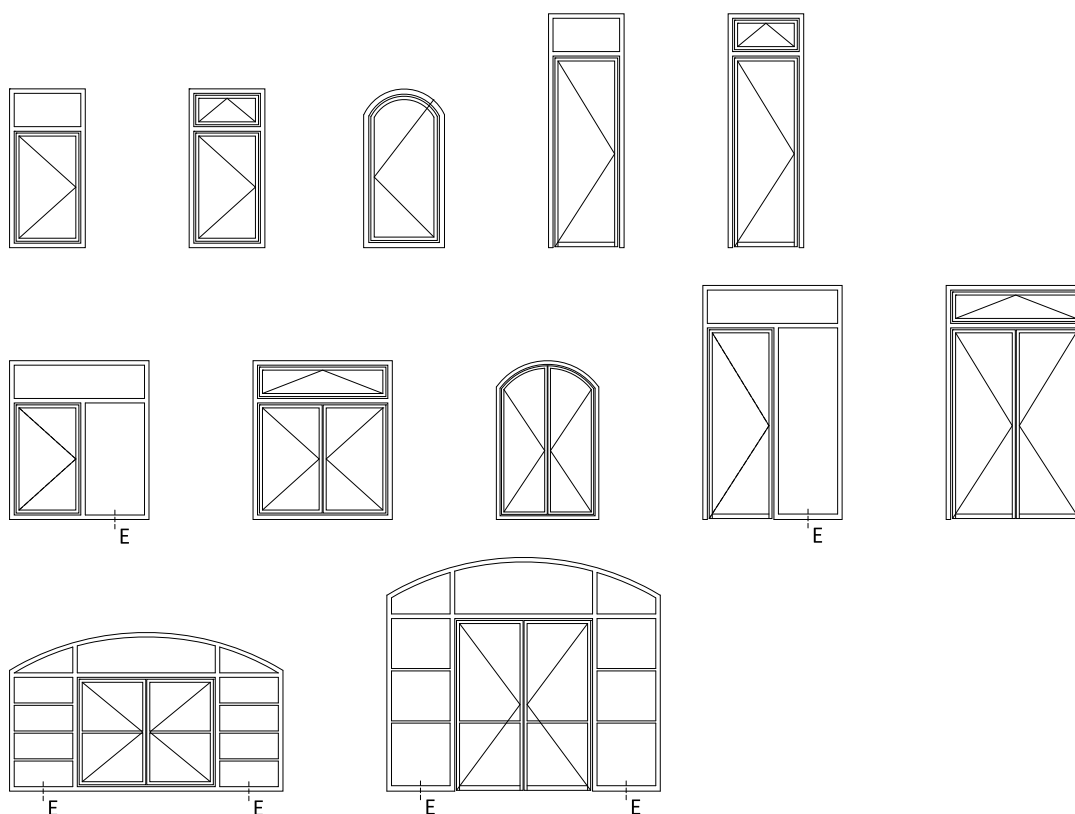




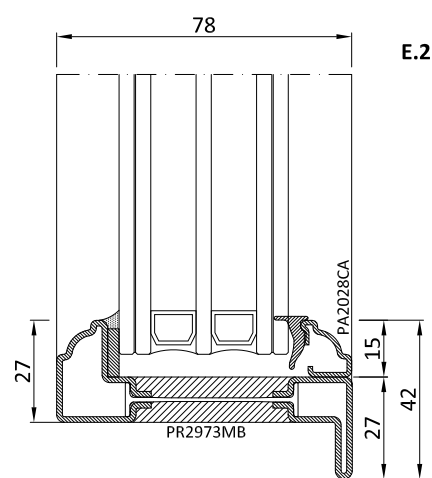




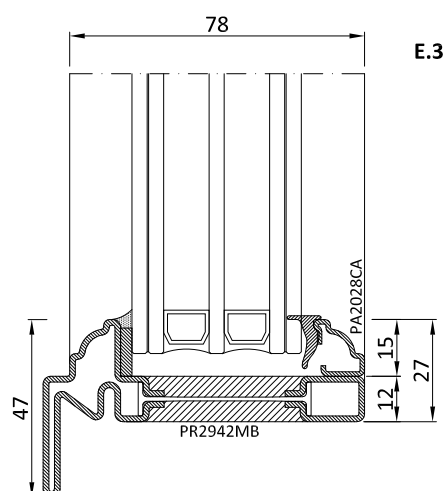




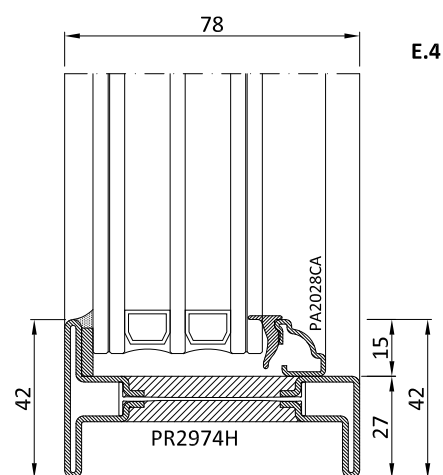
E.1



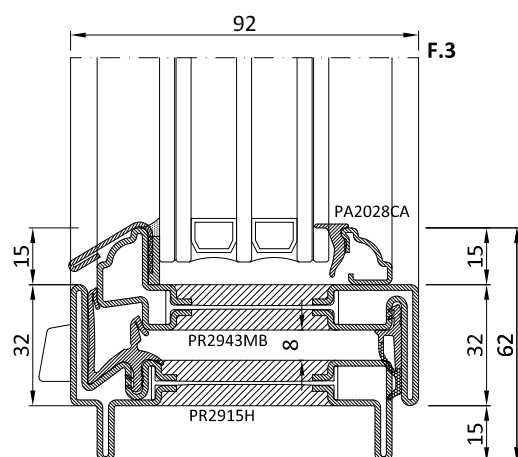
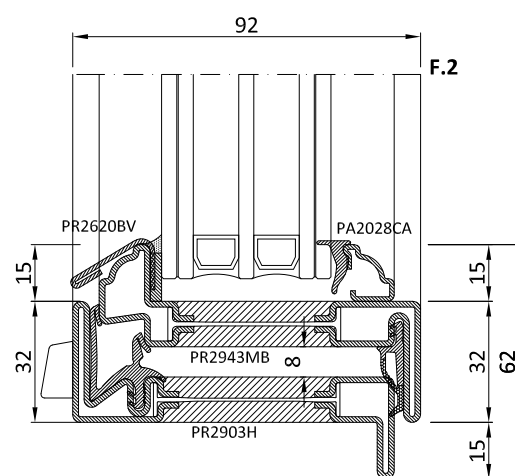
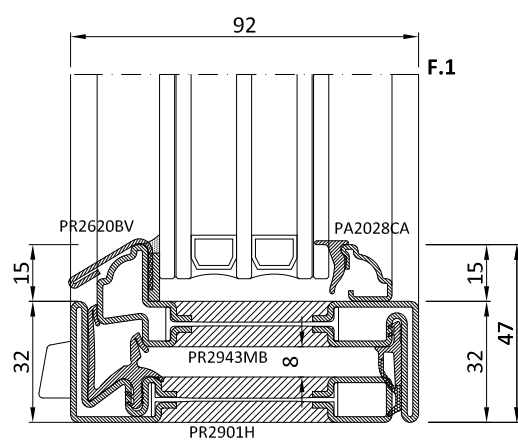
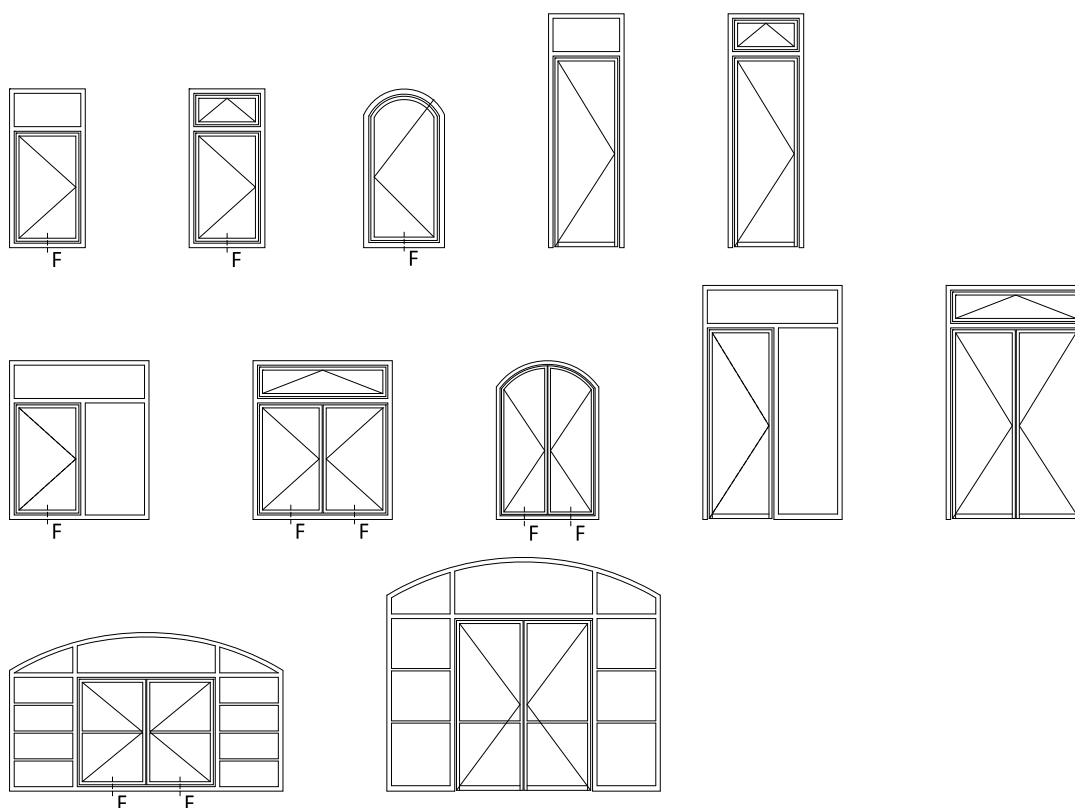
E.2

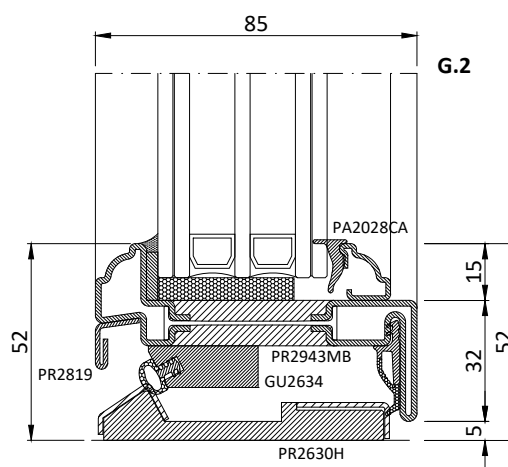
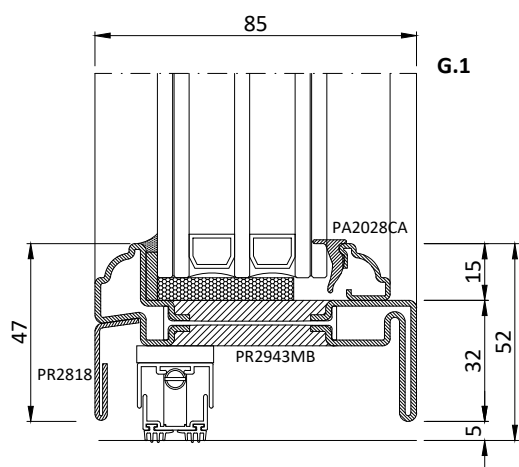
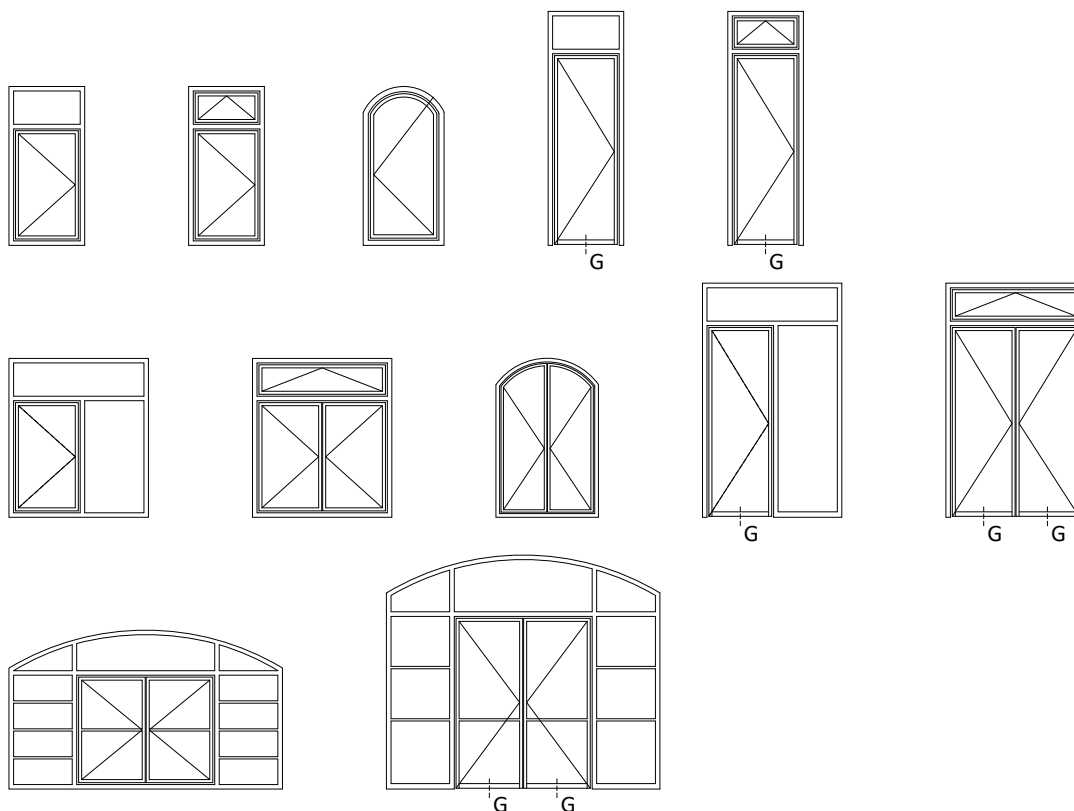


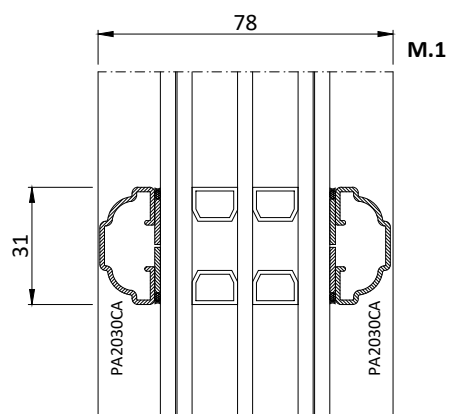
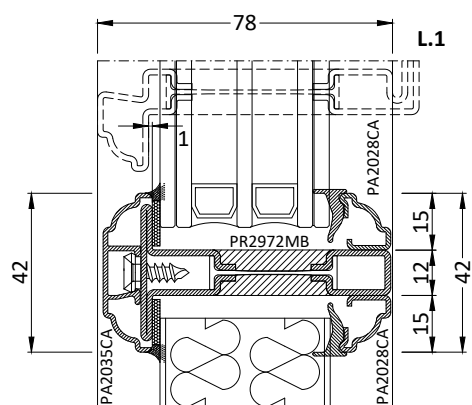
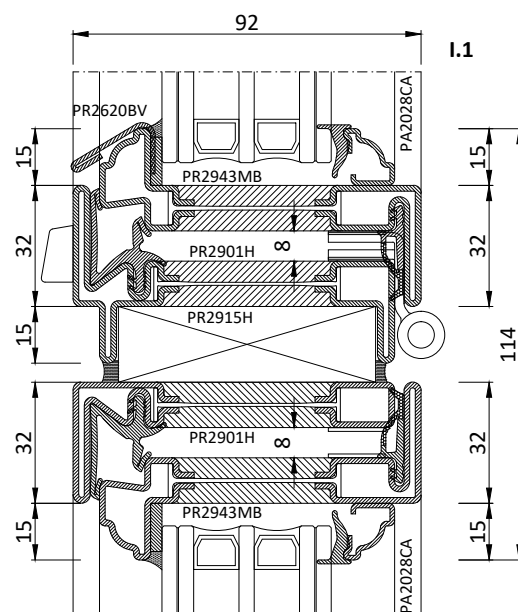
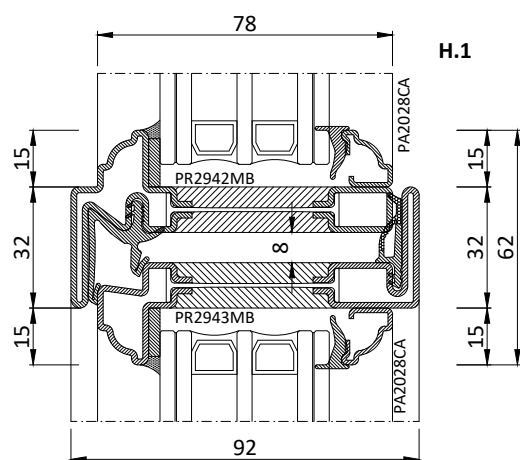
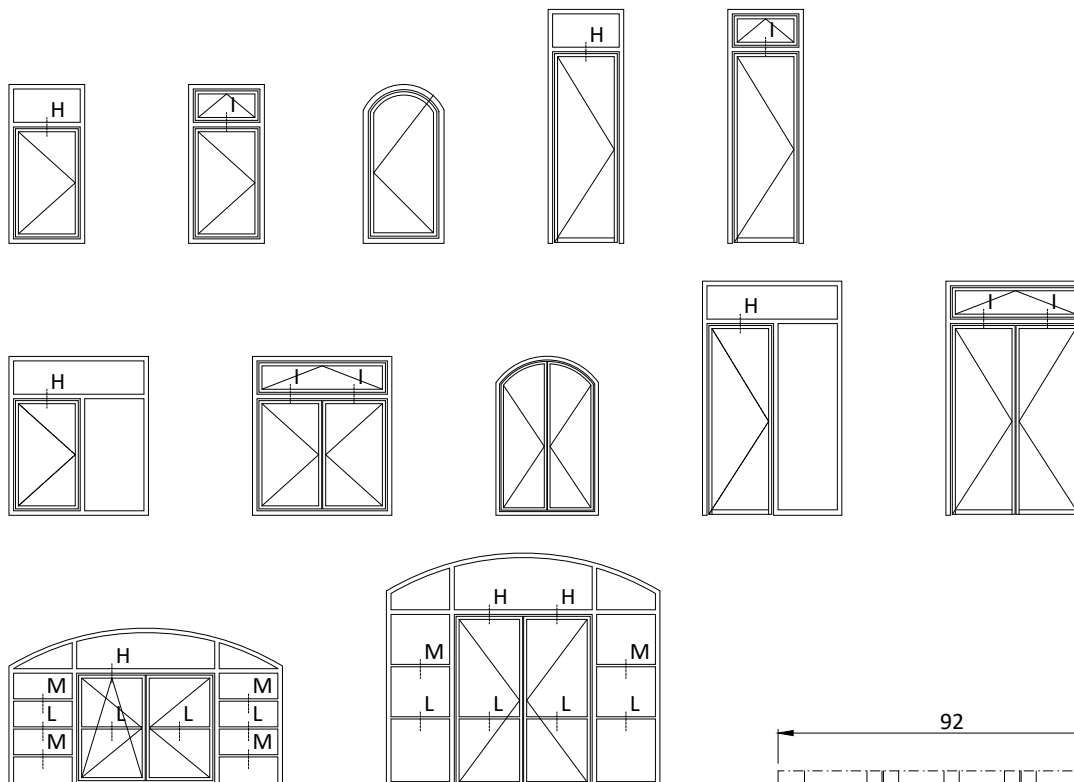
E.3

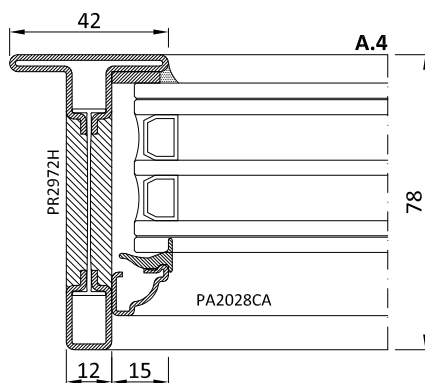
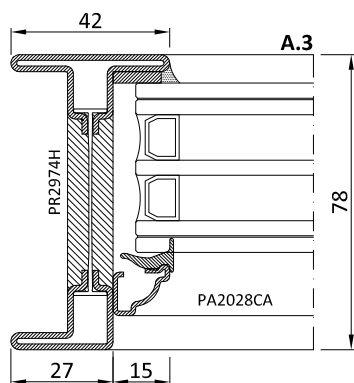
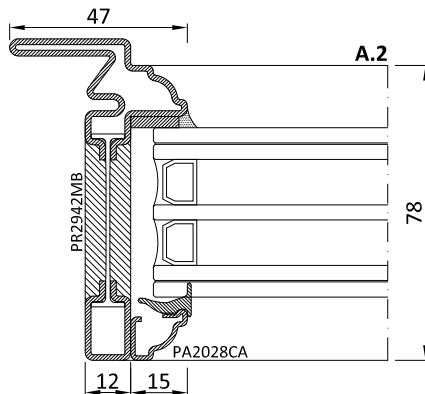
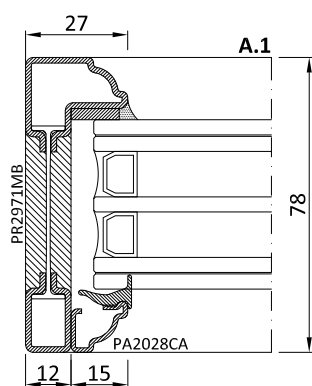
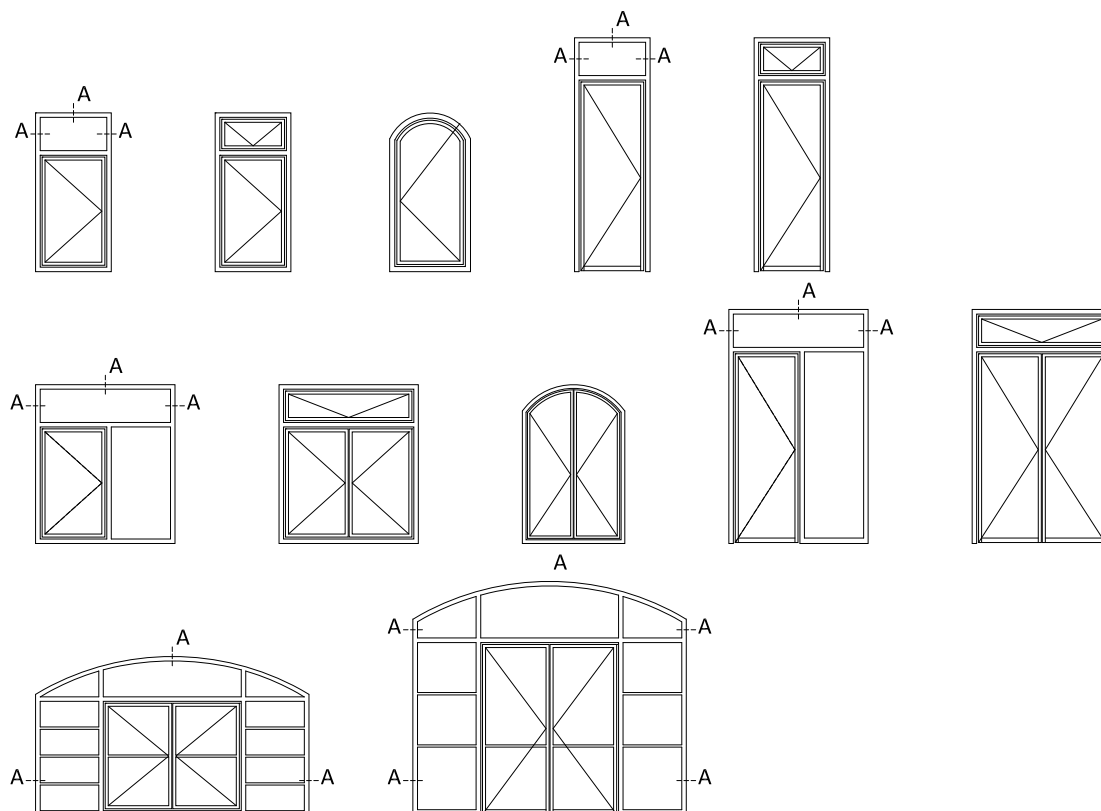


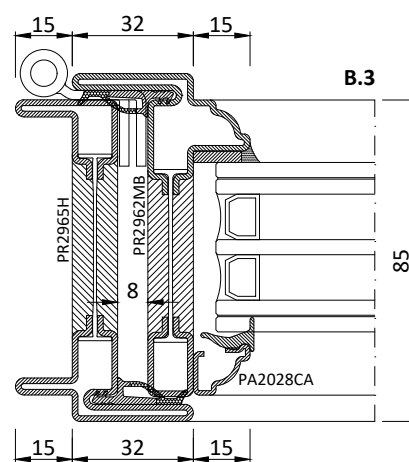
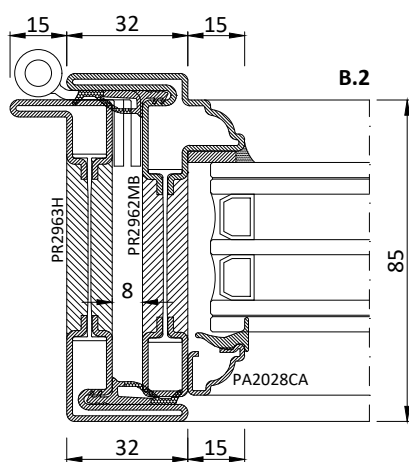
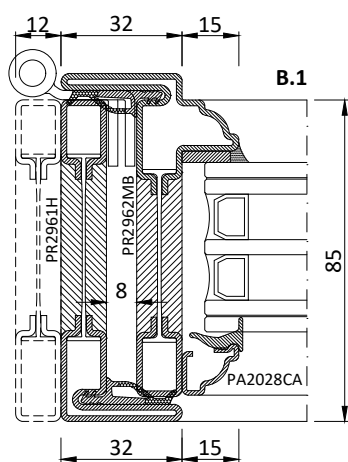
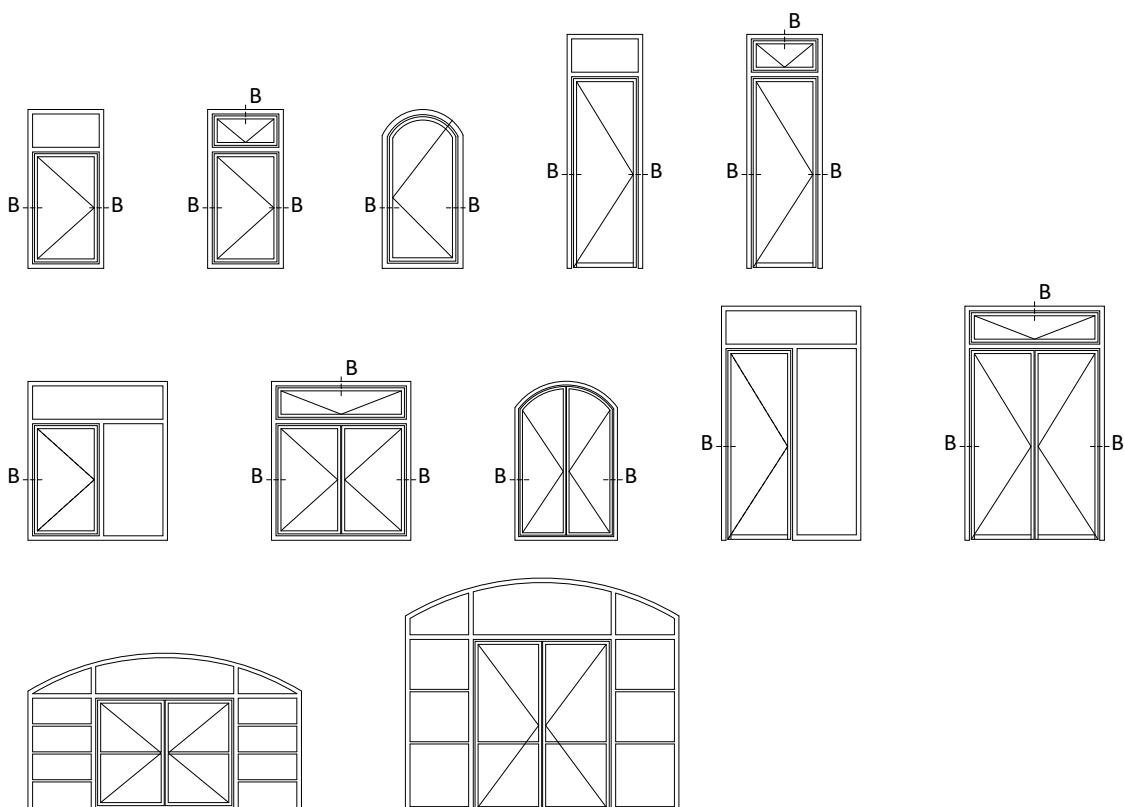
E.4

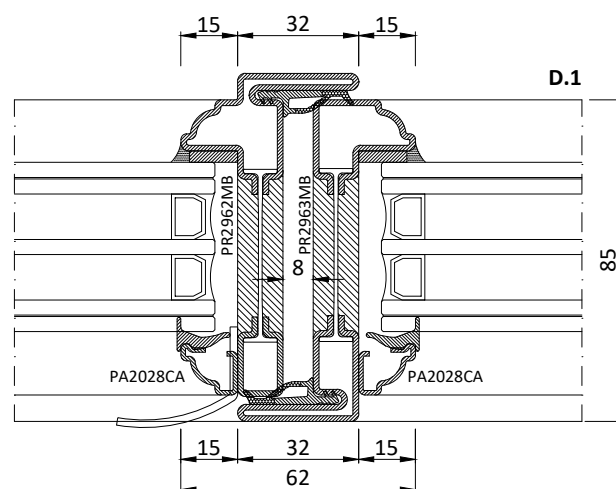
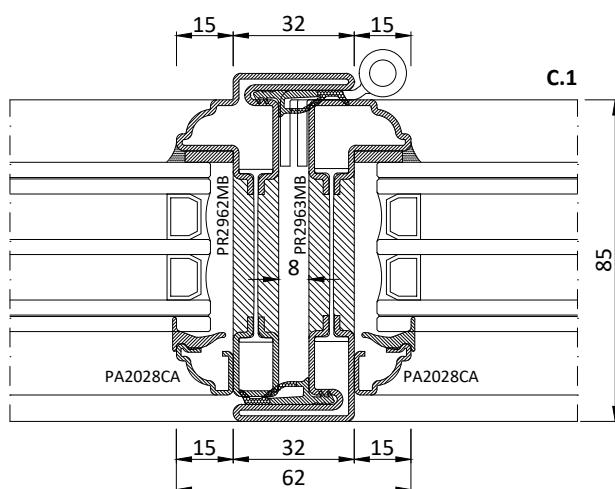
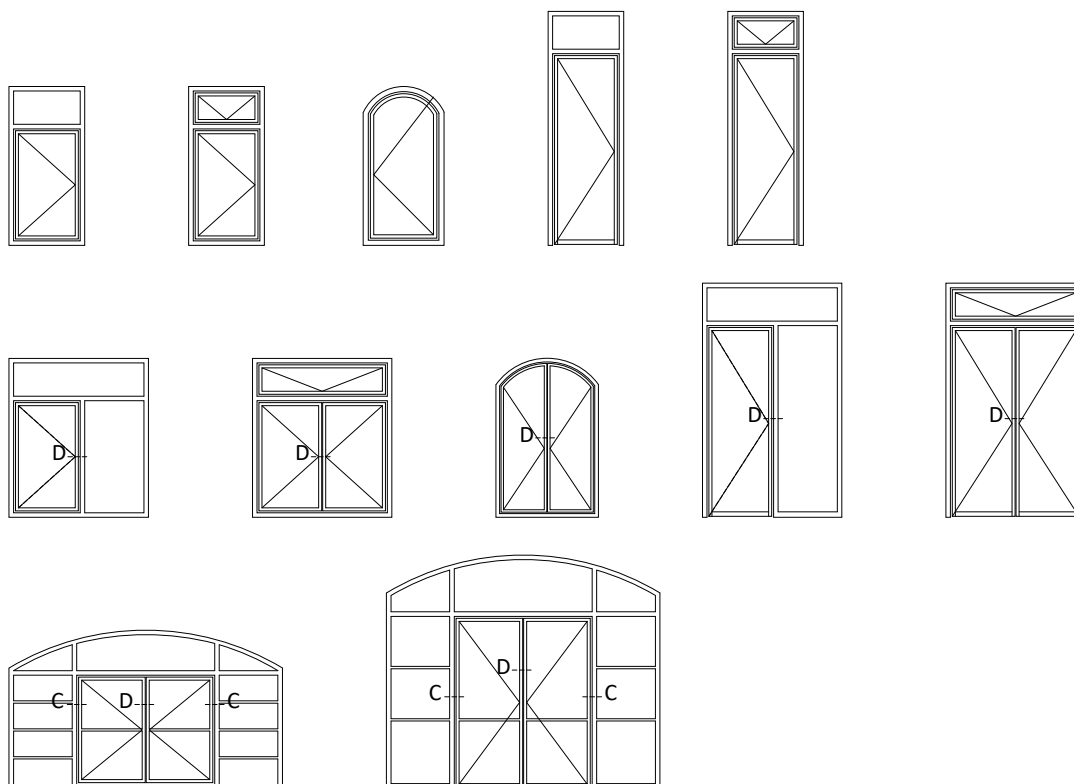


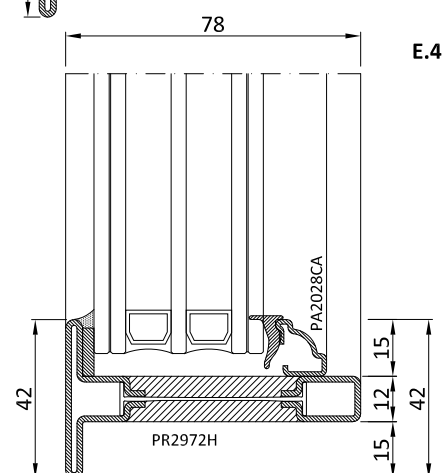
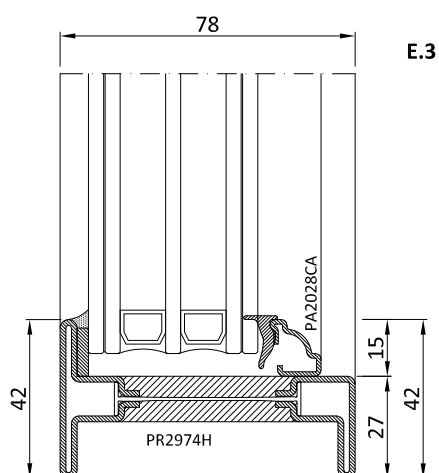
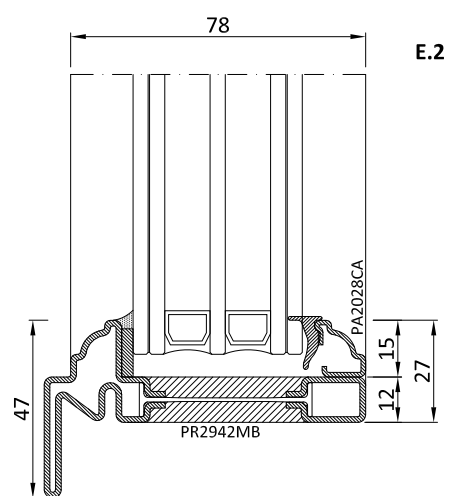
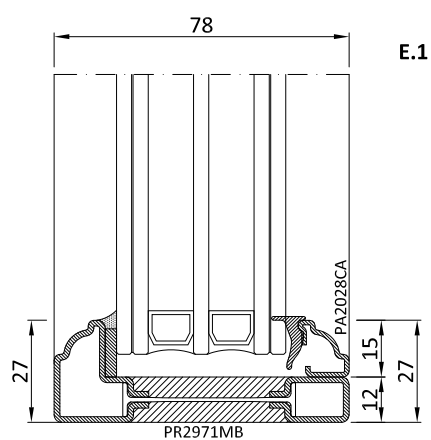
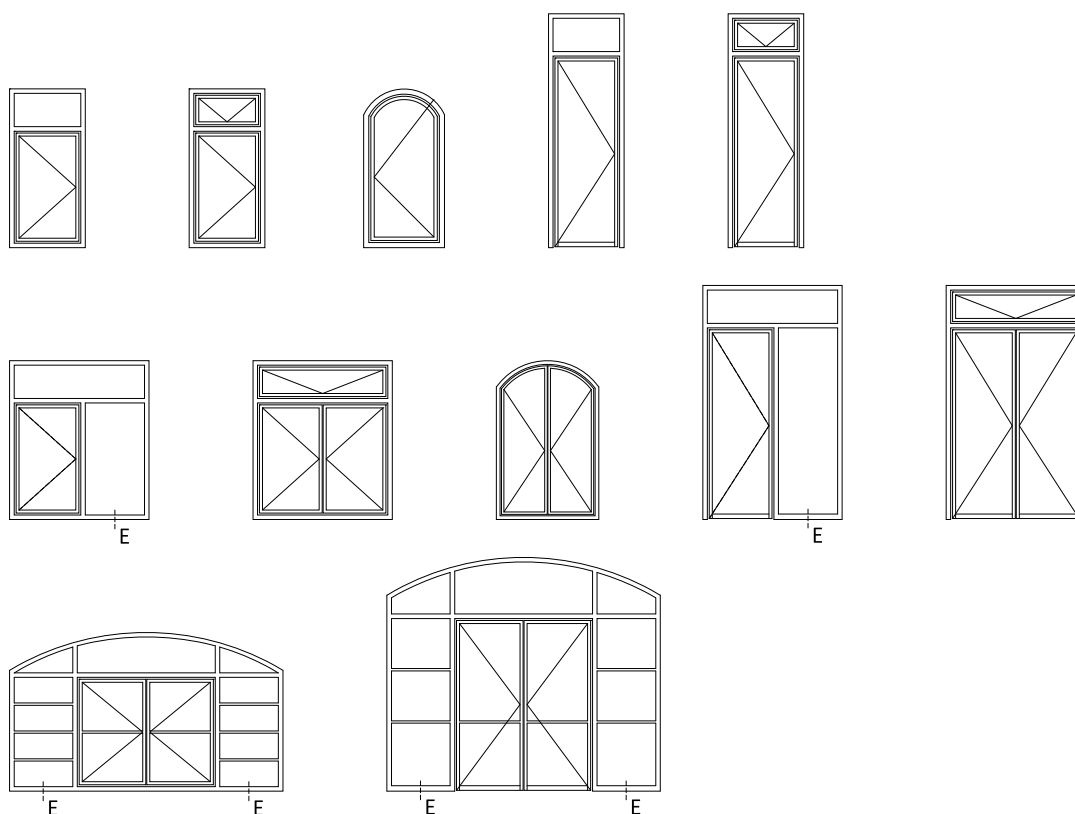


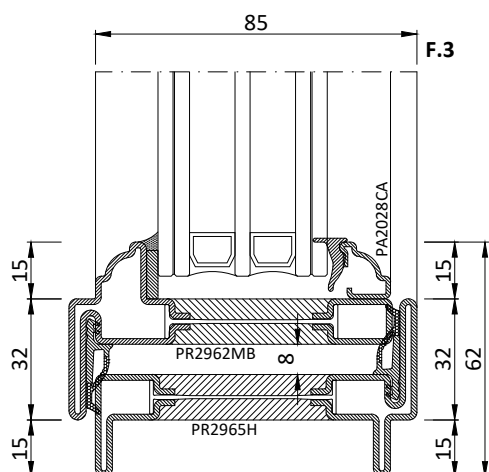
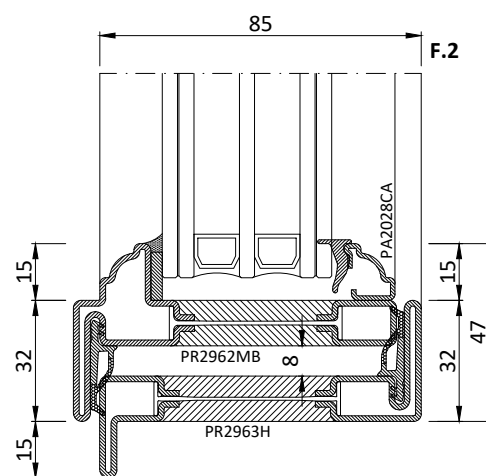
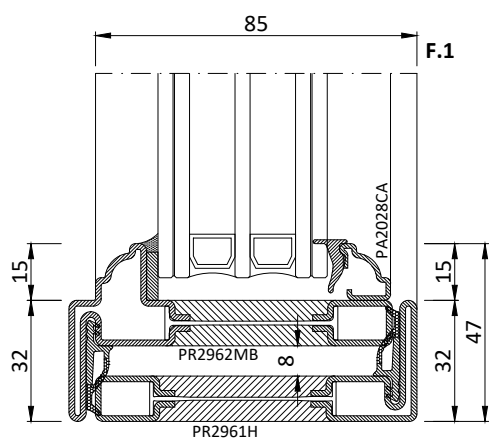
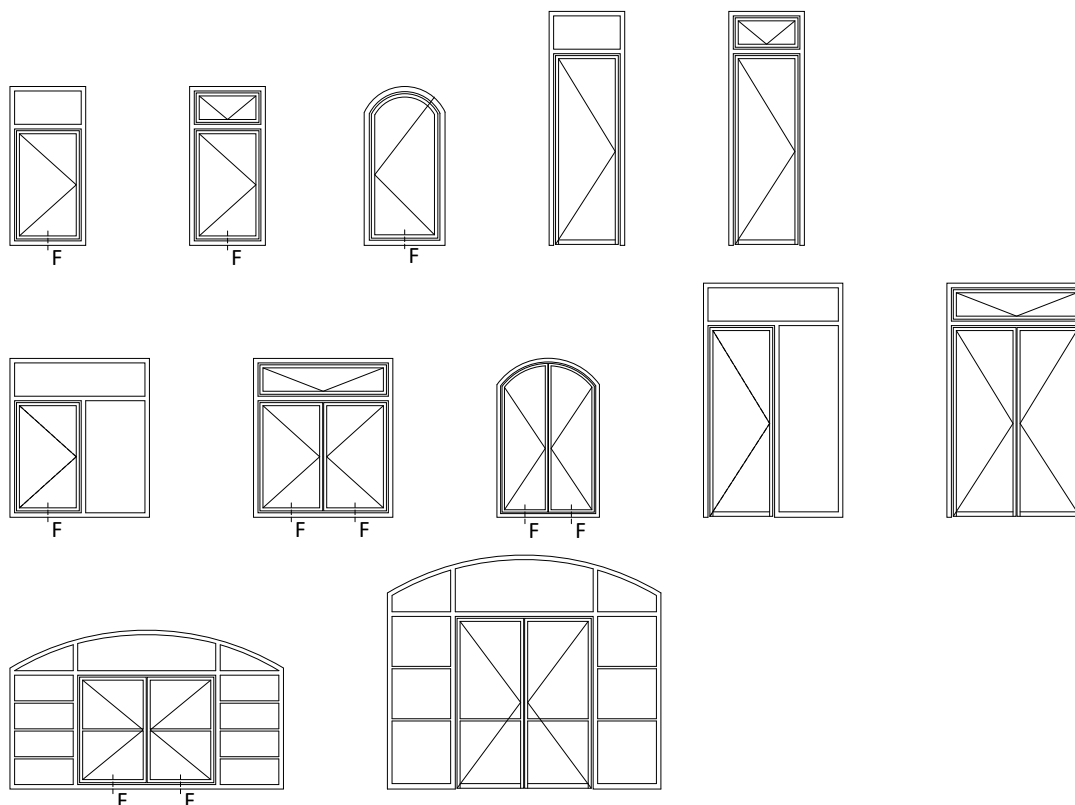


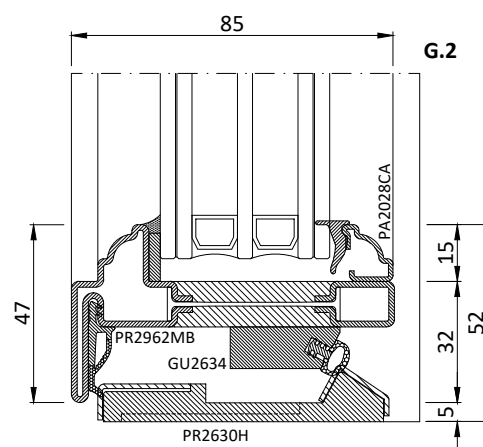
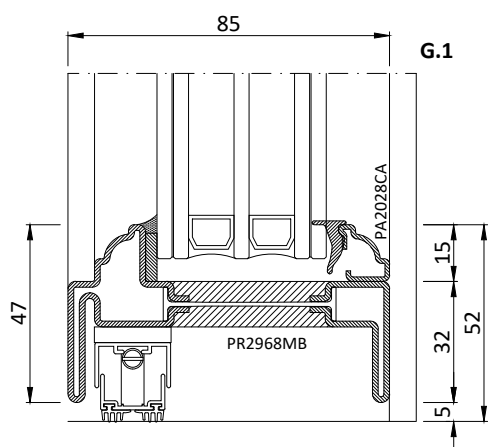
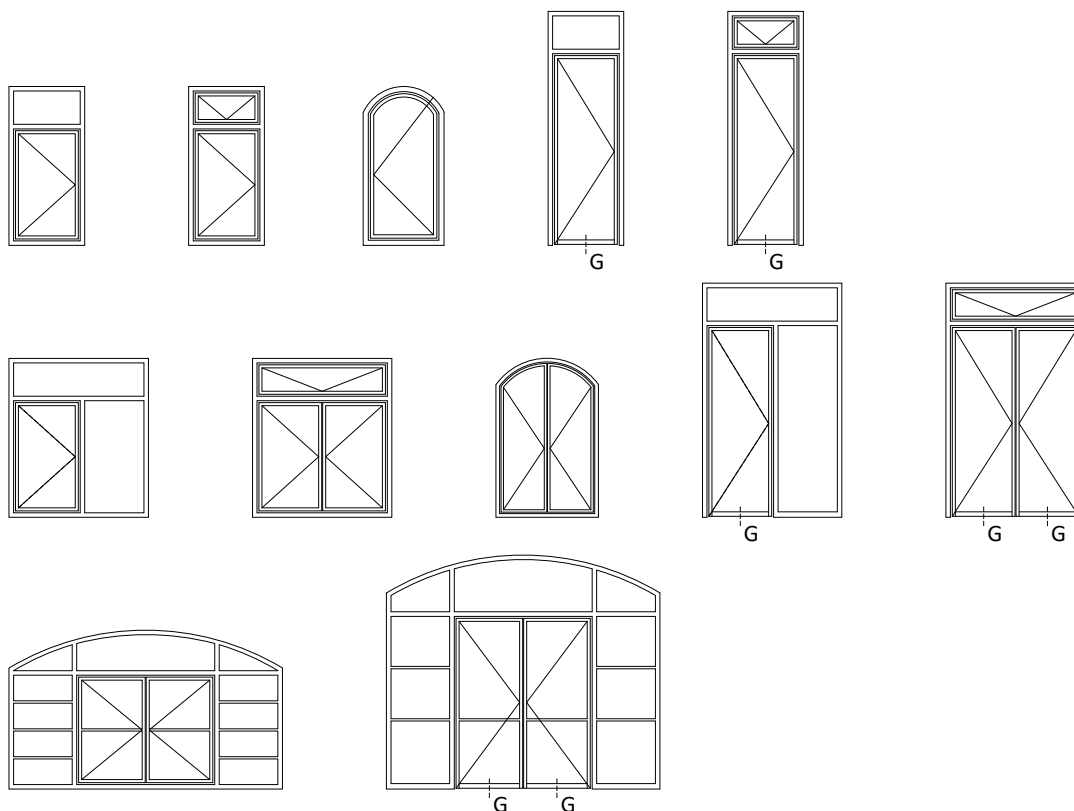


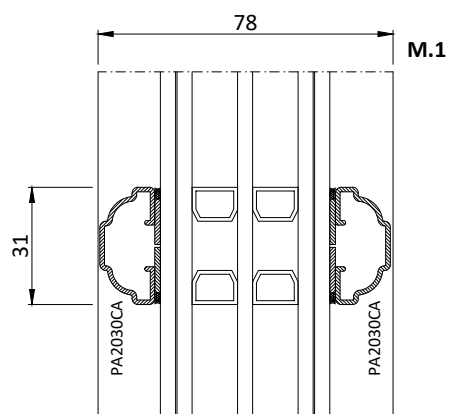
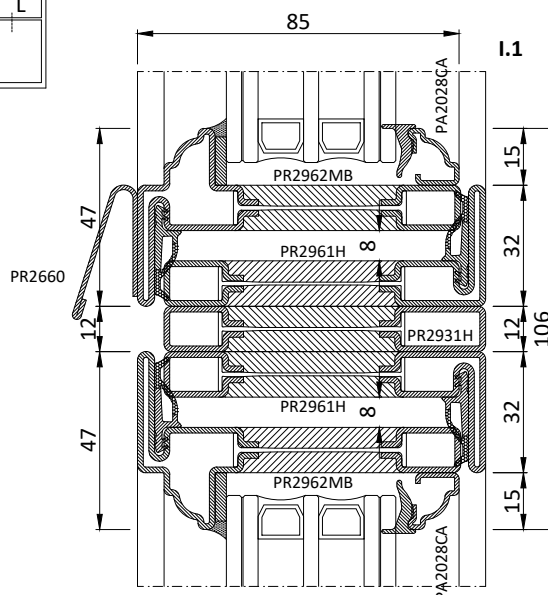
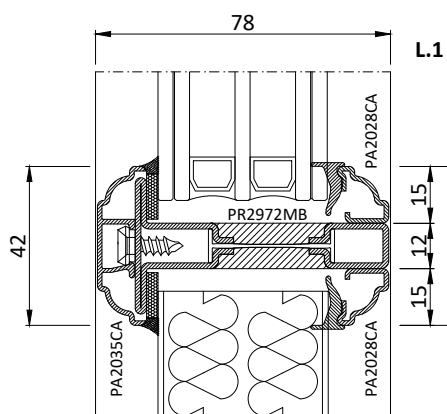
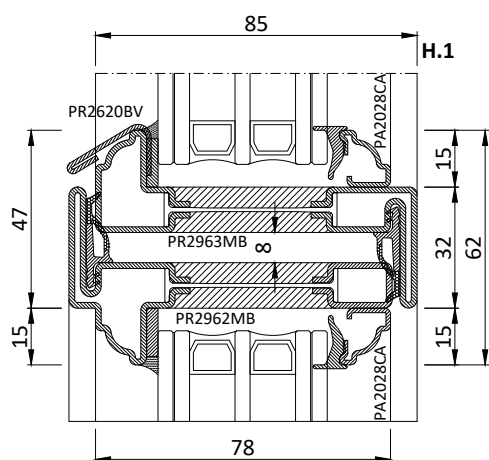
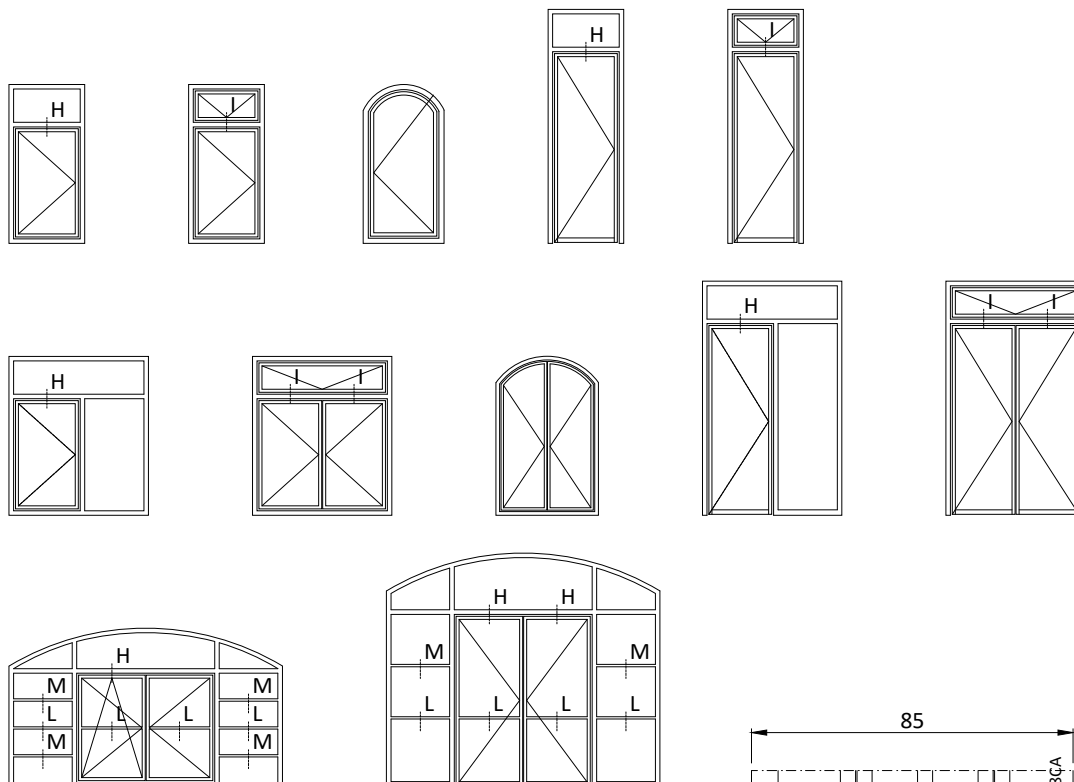


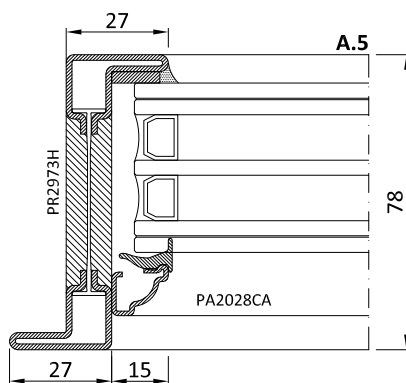
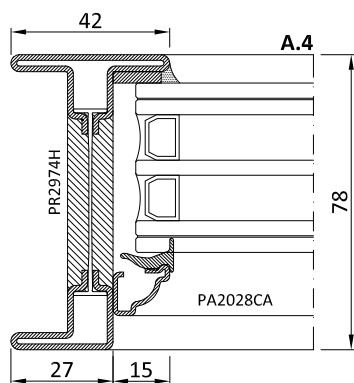
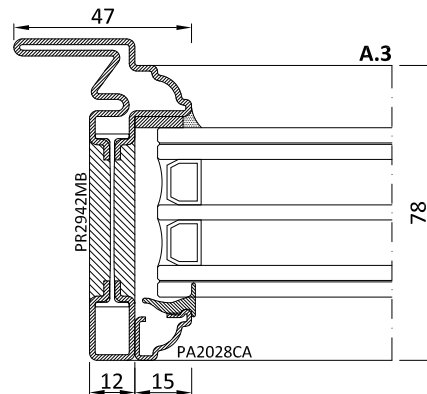
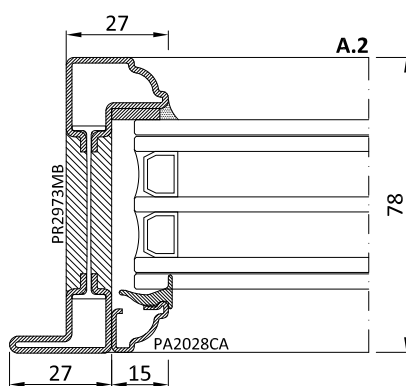
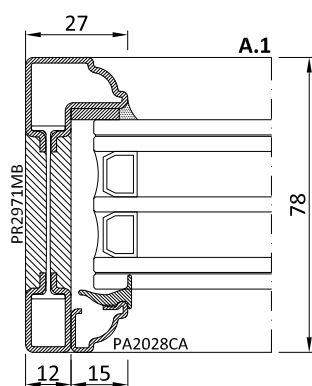
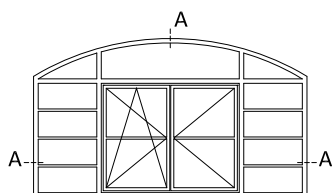
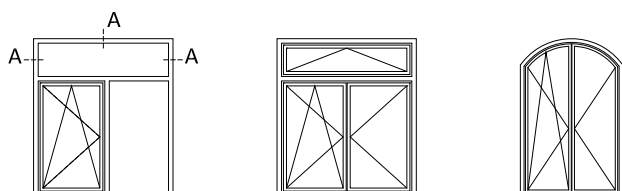
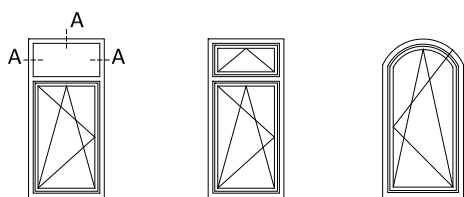


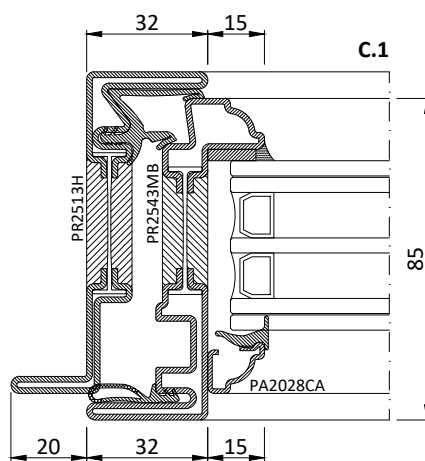
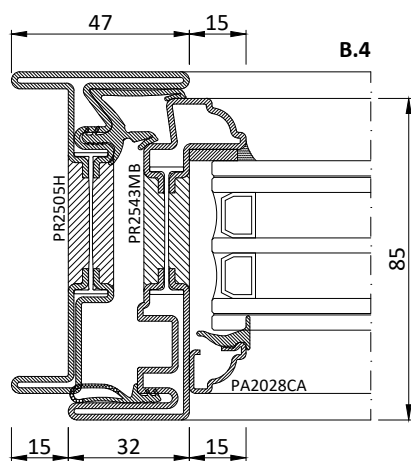
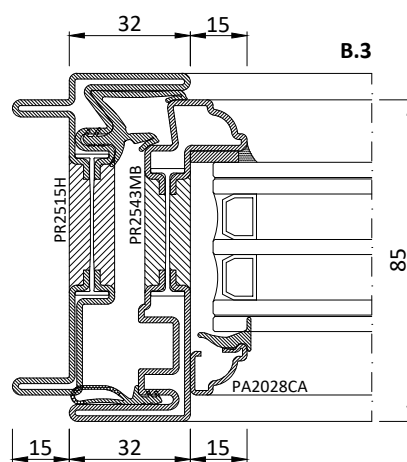
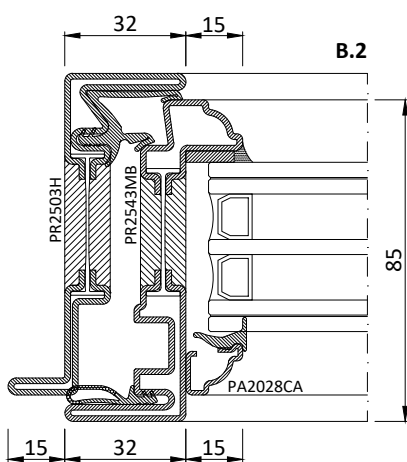
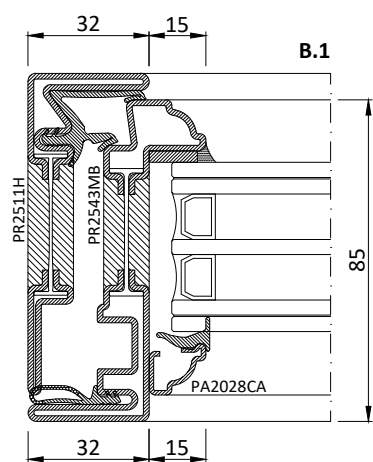
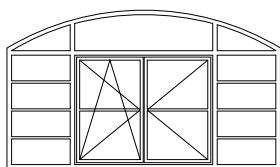
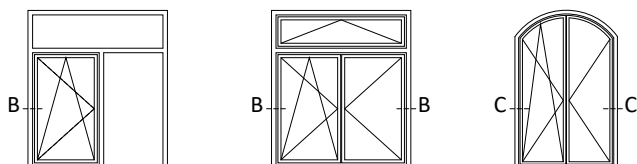
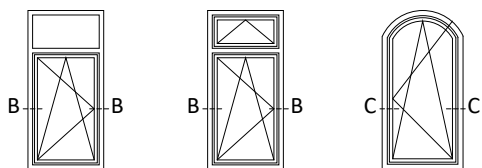


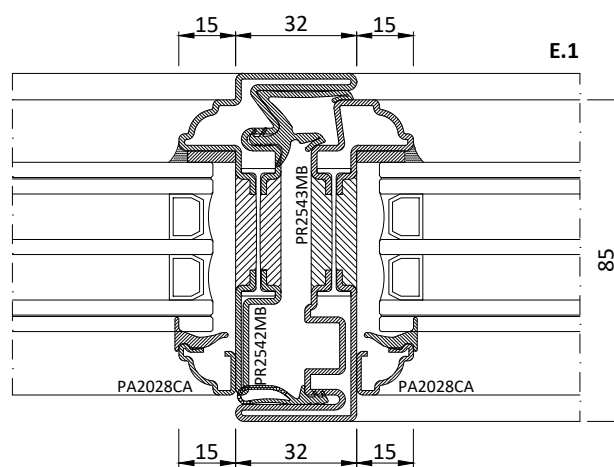
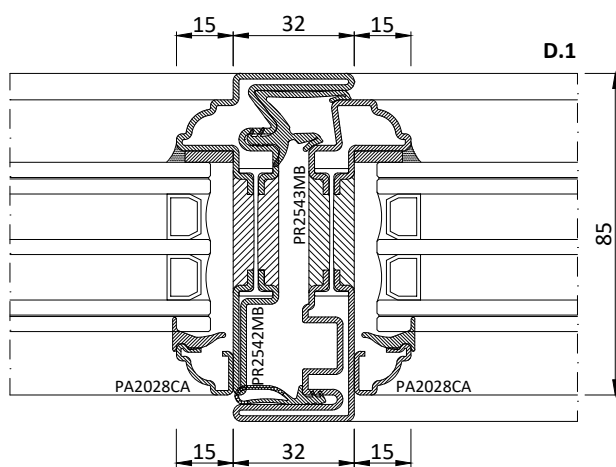
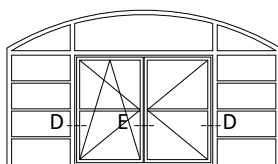
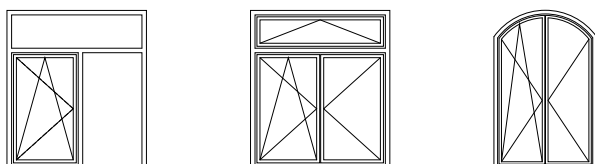
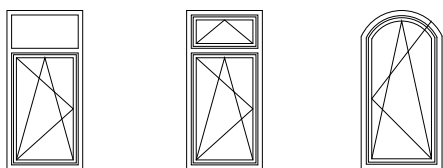


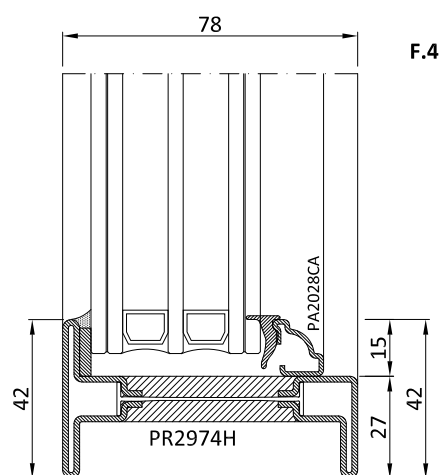
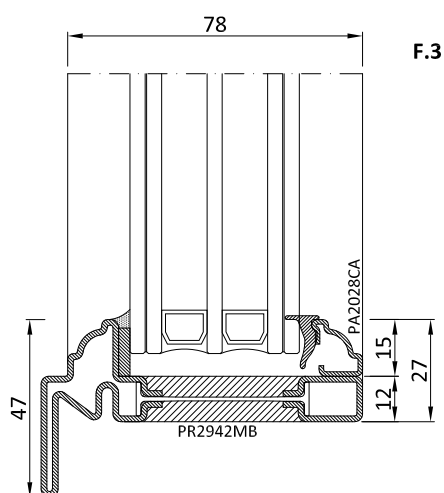
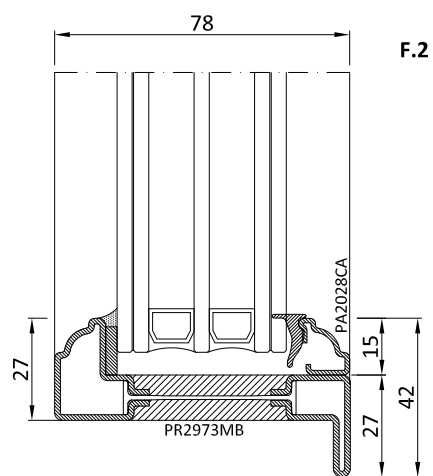
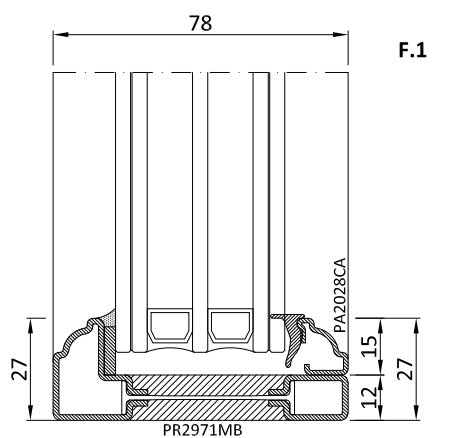
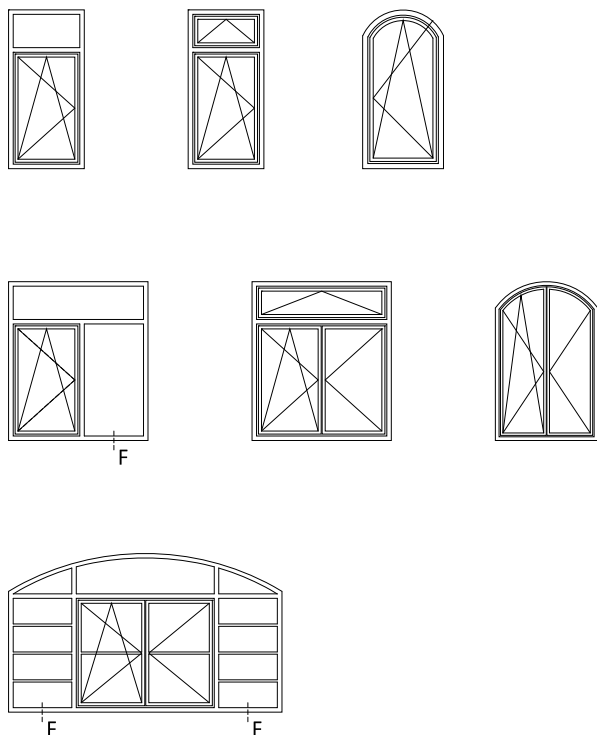


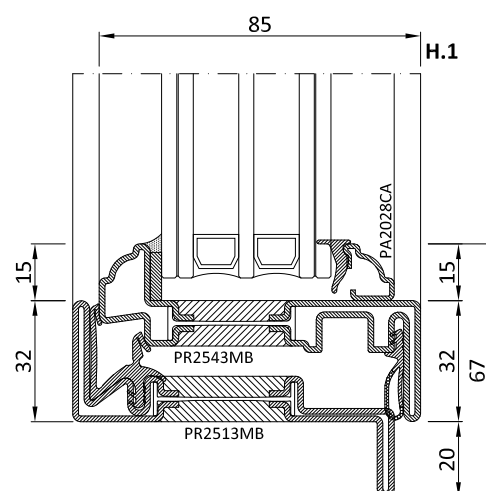
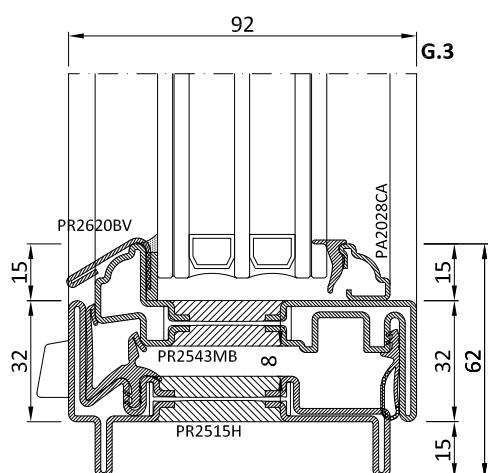
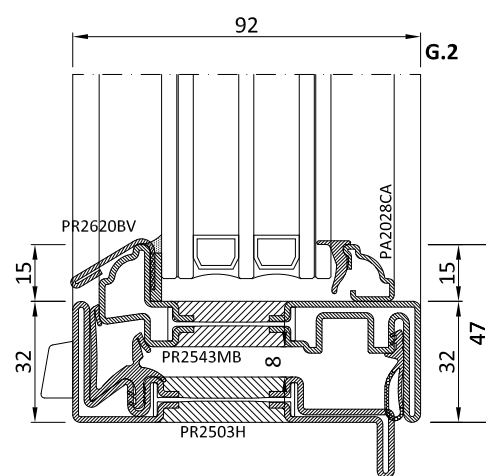
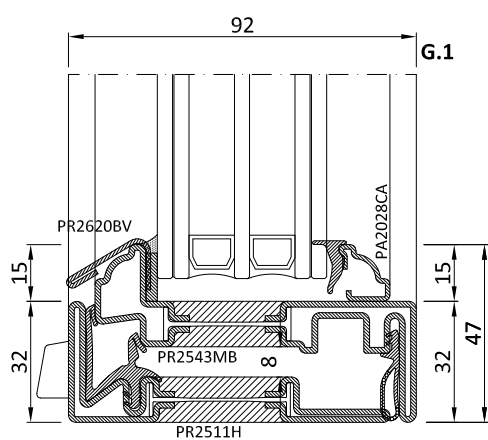
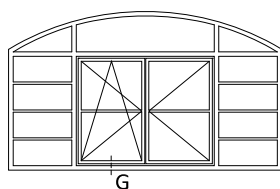
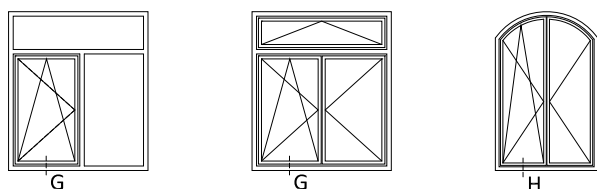
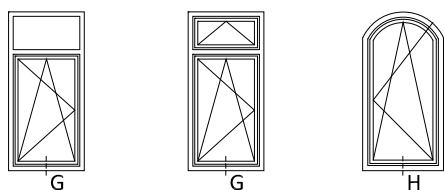


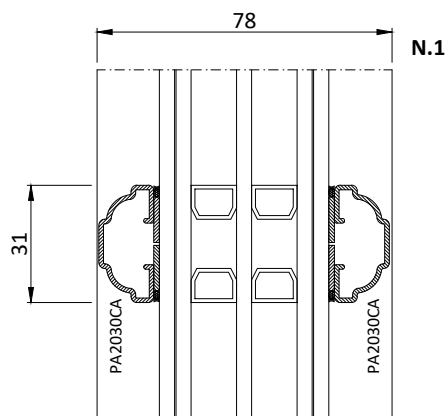
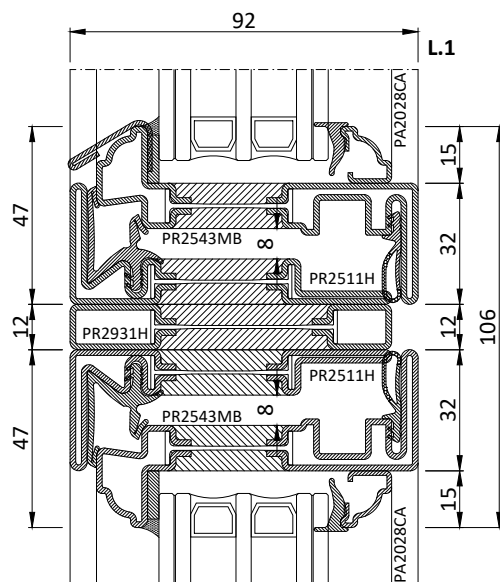
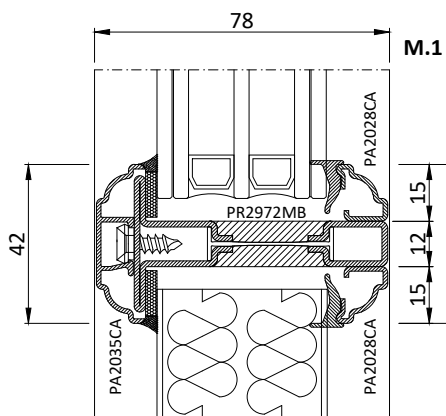
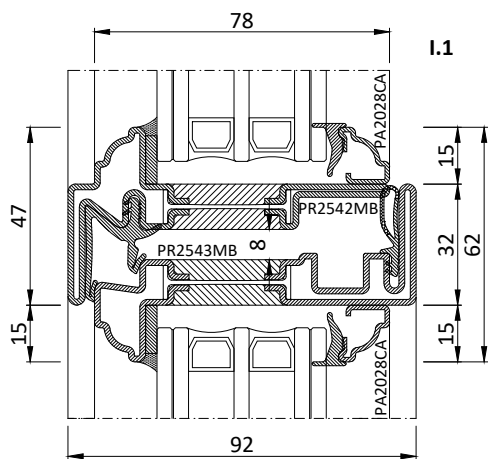
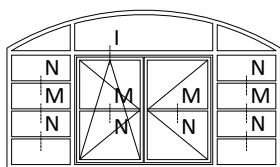
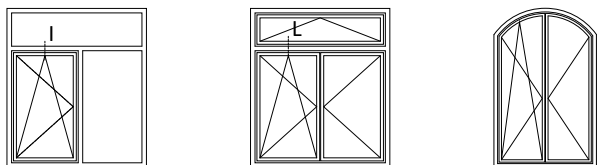
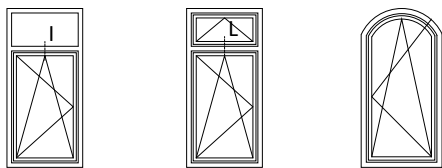


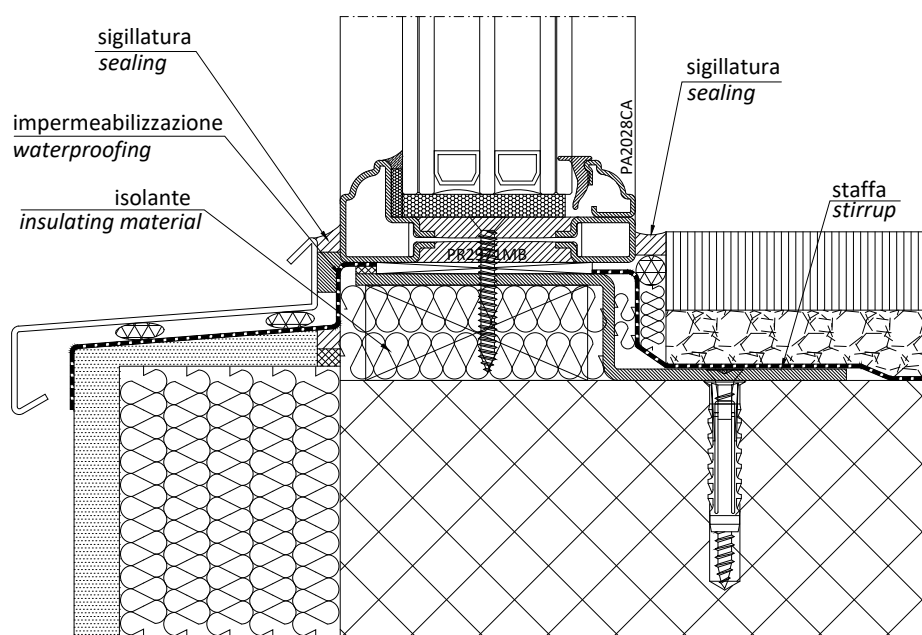
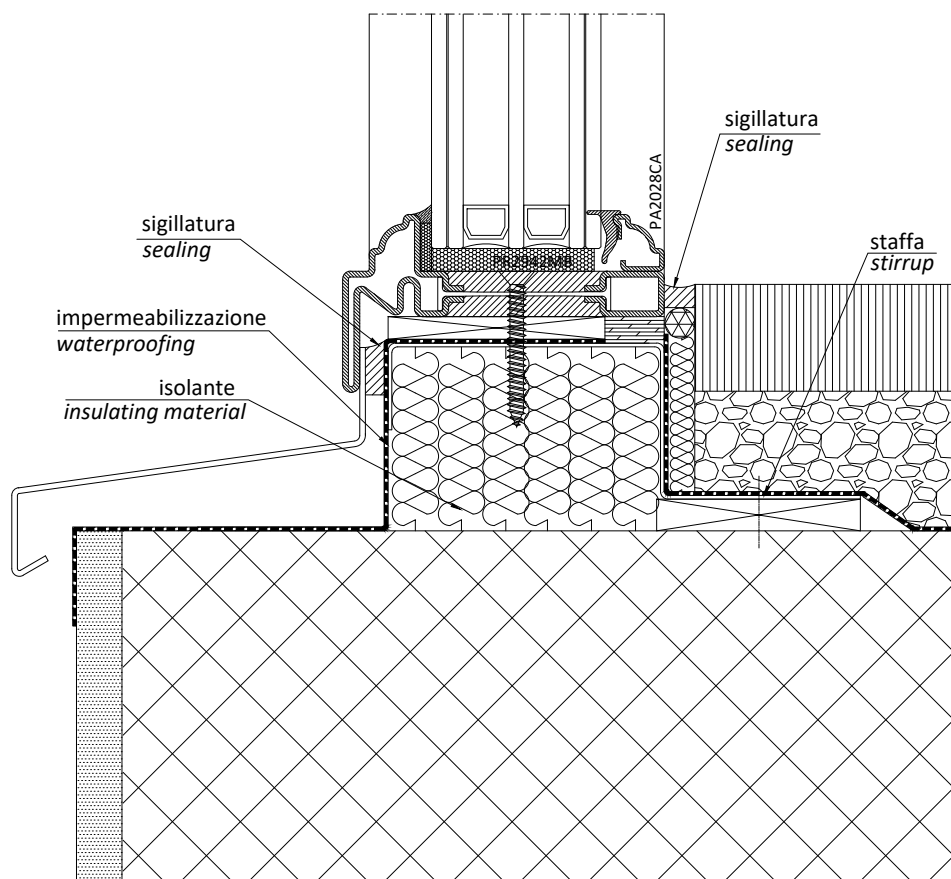


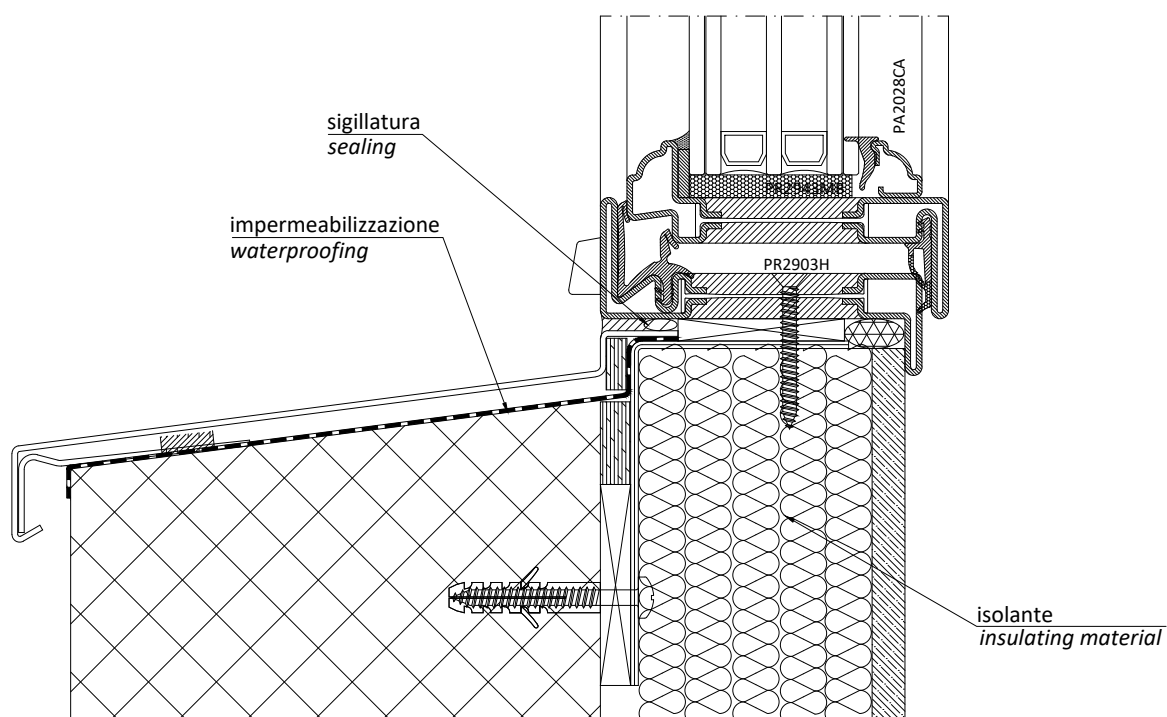
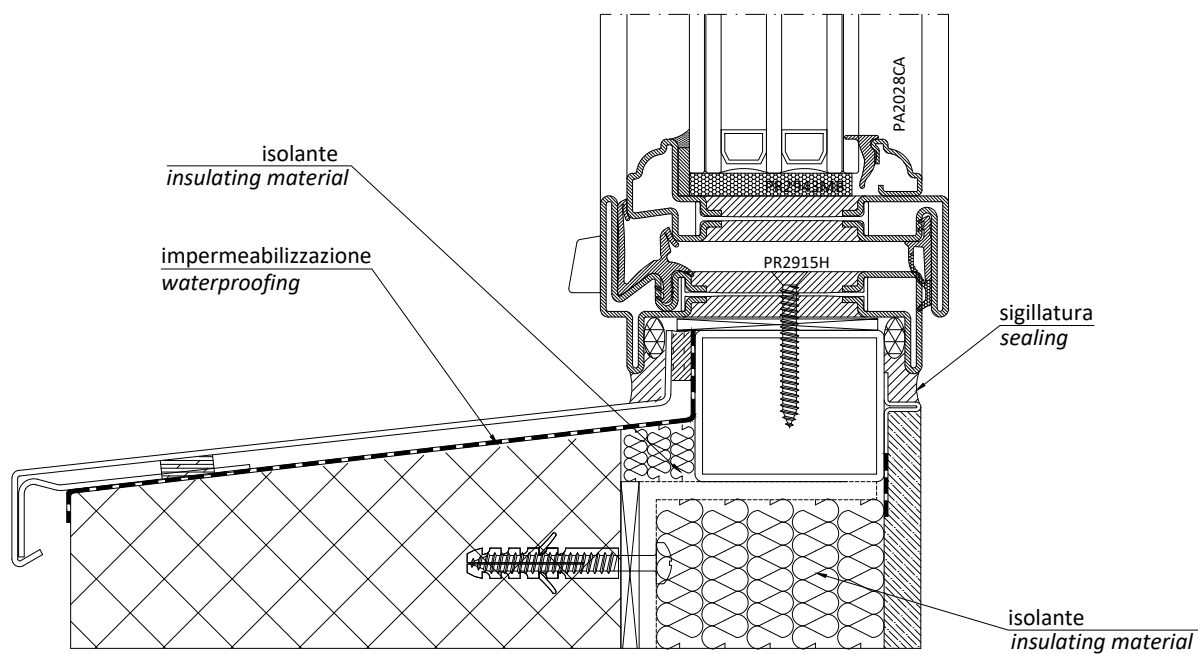


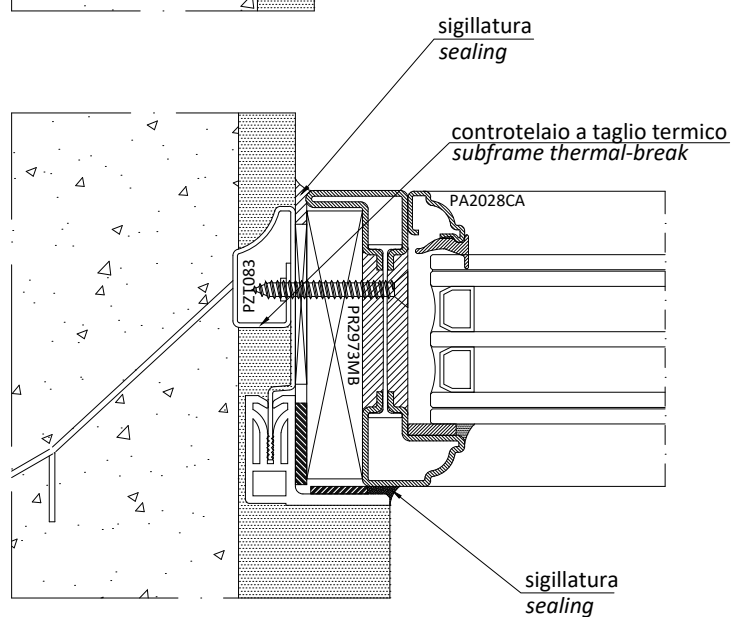
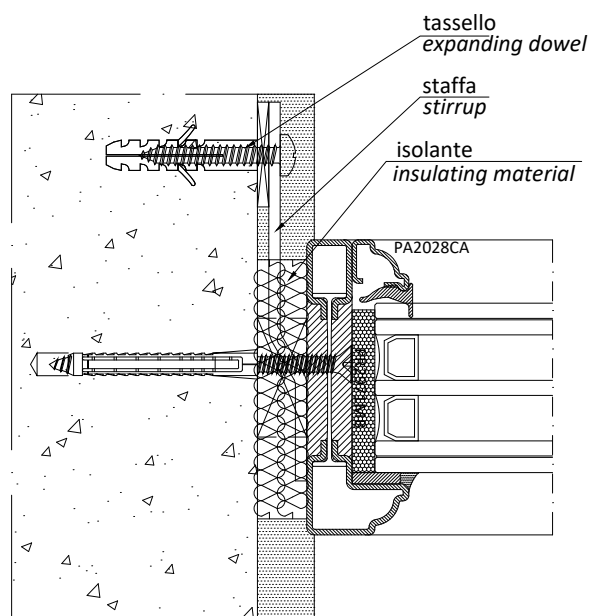
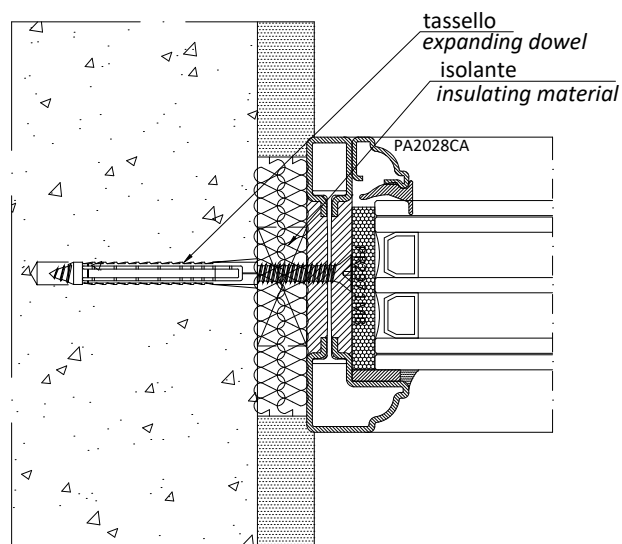


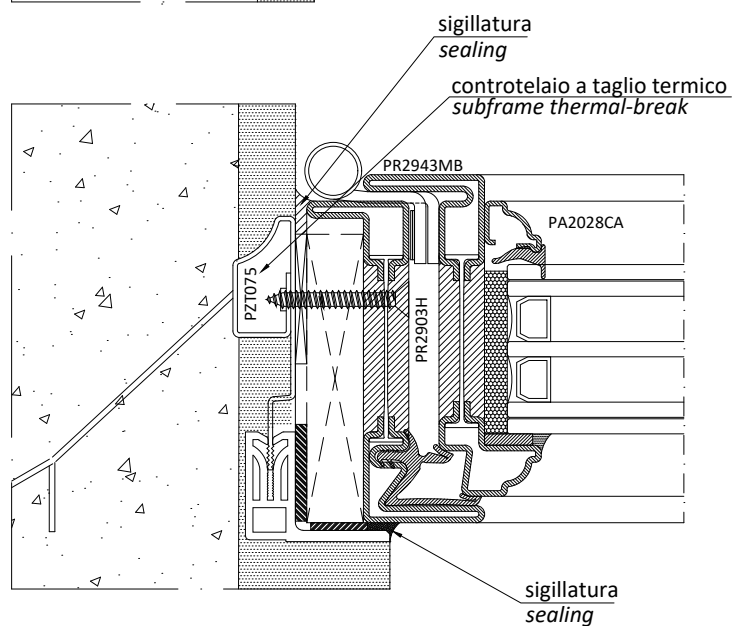
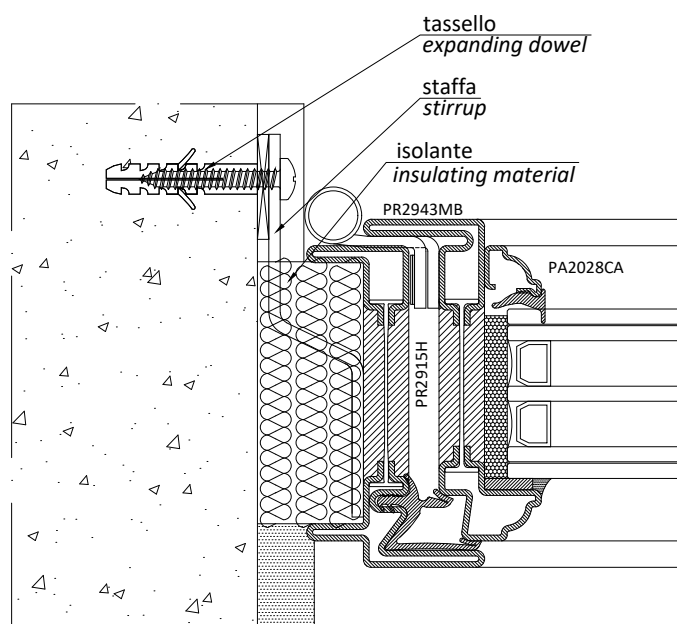
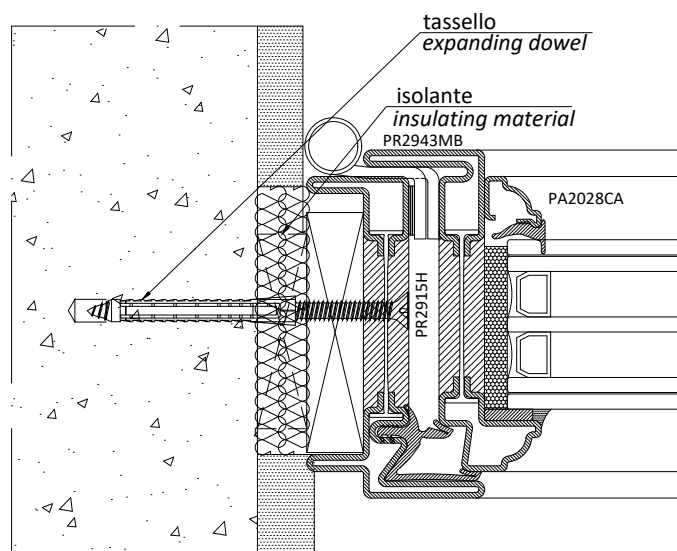




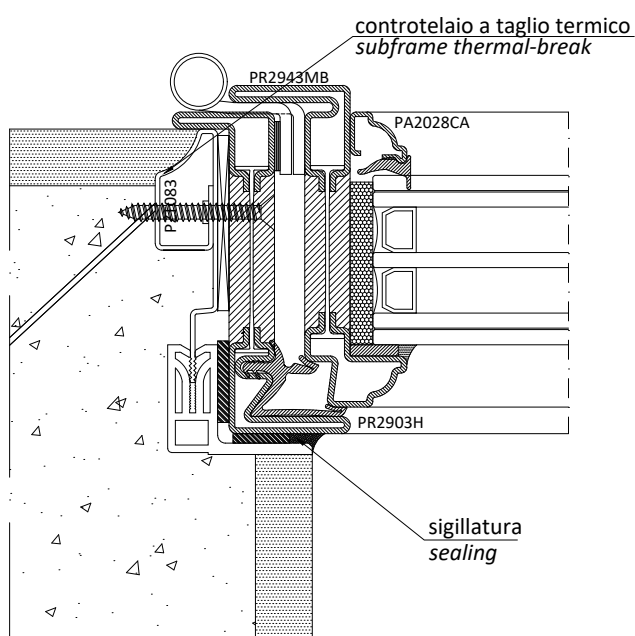
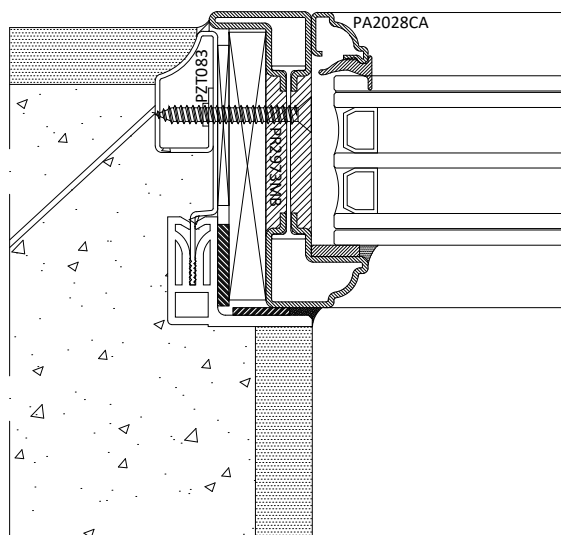








Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
 Fixing screws in correspondence of hinge axis



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	4.3.20-21
Fori e asole per chiusura supplementare / Additional locking points slots and holes	4.3.22-23
Fori per scarico acqua / Water drip holes	4.3.11
Taglio punta per inversione battuta / Secondary leaf top central joint working	4.3.3-10
Fori inserimento rinforzi cerniere / Hinge reinforcement holes	4.3.1-2
Fresatura per catenacci 2° anta / Secondary leaf flush bolt milling	4.3.37-40
Fori limitatori apertura per apertura ad anta / Casement restrictor stays holes	4.3.30-33
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
Fori fissaggio a muro / Wall mounting holes	3.3.1-4

Assiemaggio / AssemblyCostruzione telai / Frame assembly

Assiemaggio traverso – fissaggio squadrette / Assembly of the transom – fixing of the brackets	4.4.1-12
Assiemaggio dividivetro / Assembly of glass divider	4.4.13-14
Saldatura / Welding	4.4.15
Sigillatura interna della giunzione (profili ottone) / Internal joint sealing (brass sections)	4.5.1

Applicazione accessori / Accessories installation

Saldatura cerniere a saldare / Screw-on hinges holes	4.4.17
Fori snapper 2° anta / Secondary leaf snapper holes	4.5.4-6
Fori cerniera a scomparsa vasistas / Concealed hinges for bottom- hung window holes	4.6.14
Fori cricchetto e braccetti vasistas / Finger catch and stay arms for bottom hung window holes	4.5.22
Fori chiusure mediane a scomparsa / Concealed hinge side middle closing holes	4.5.20
Fori maniglia trascinalento seconda anta / Pulling handle secondary leaf holes	4.5.23-24
Fori limitatori apertura per apertura ad anta / Restrictor stays holes	4.5.28-33
Fori per compassi e limitatori sporgere / Stay arm and restrictor stays for awning windows holes	4.5.34-36

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 (brass)	5.1.4

Montaggio accessori / Accessories installation

Applicazione e sigillatura guarnizioni giunto aperto / Sealing of central gasket	4.5.1
Applicazione scarichi acqua / Water drip installation	4.5.1
Montaggio cerniere / compassi / vasistas etc. / Hinges and arms installation (side hung, bottom-hung, awning)	4.5.21-22
Montaggio cremonese e incontri / Cremonese bolt installion	4.5.3-19
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	2.8.1-6
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
Soglie e lavorazioni per fissaggi e scarichi acqua / Thresholds and workings for fixings and water drains	4.3.49-55
Taglio punta per inversione battuta / Secondary leaf top central joint working	4.3.3-10
Fori inserimento rinforzi cerniere / Hinge reinforcement holes	4.3.1-2
Fresatura per catenacci 2° anta / Secondary leaf flush bolt milling	4.2.37-40
Fori fissaggio a muro / Wall mounting holes	3.3.4

Assiemaggio / AssemblyCostruzione telai / Frame assembly

Saldatura / Welding	4.4.15
Sigillatura interna della giunzione (profili ottone) / Internal corner joint sealing (brass sections)	4.5.1

Applicazione accessori / Accessories installation

Saldatura cerniere a saldare / Weld-on hinges welding	4.4.18
Lavorazione per paraspiro automatico / Automatic door bottom seal working	4.3.41-42

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

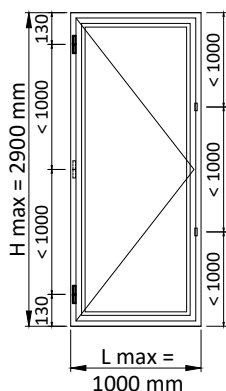
Fori su telaio per scarichi liquidi pretrattamento / Holes on frame for the drainage of pretreatment liquid	5.1.4
Pulitura della superficie (ottone) / Cleaning of the surface (brass)	5.1.4

Montaggio accessori / Accessories installation

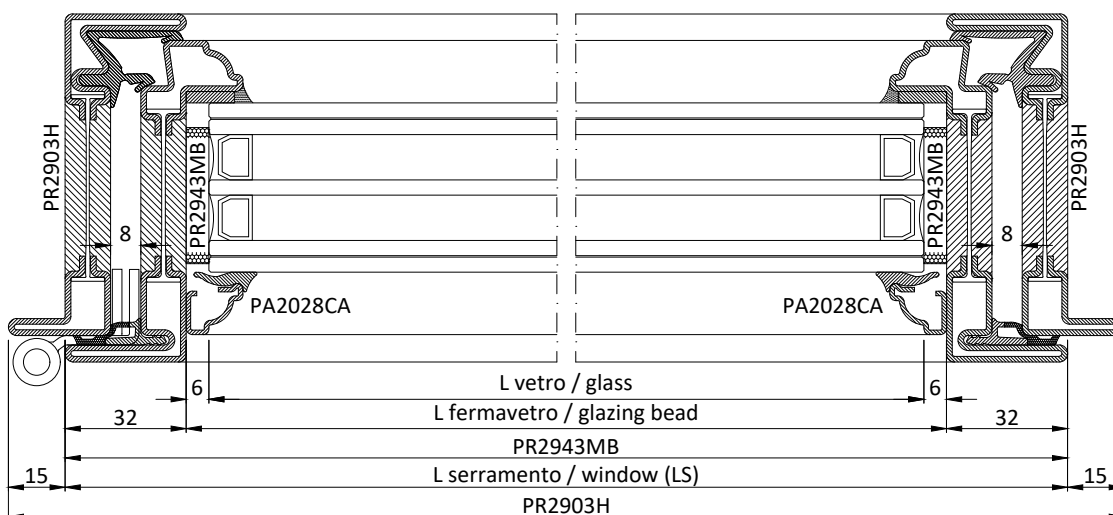
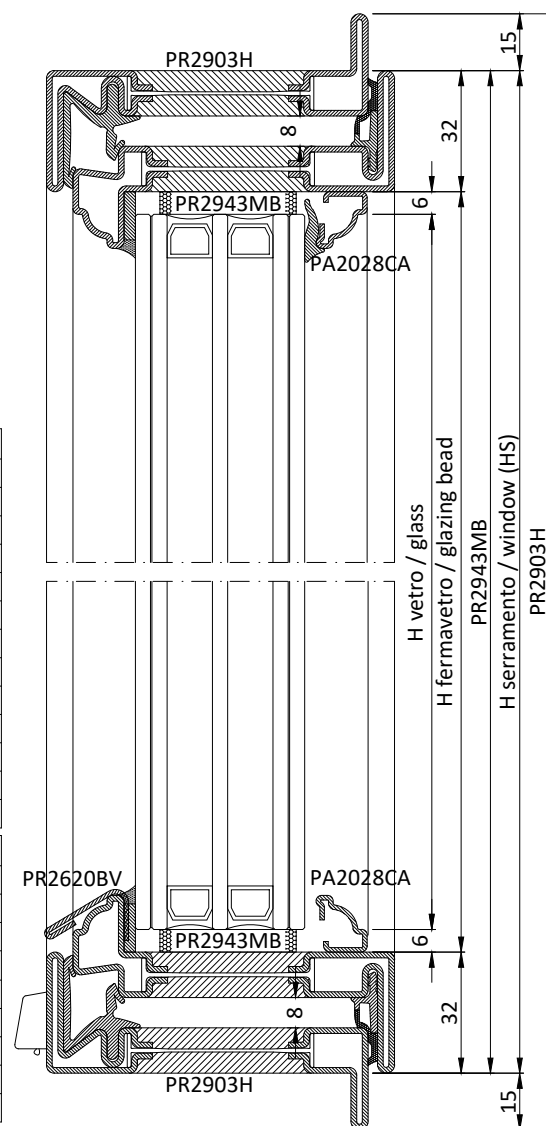
Montaggio cerniere / Hinges installation	4.5.32-41
Montaggio serratura e incontri / Lock and strikes installation	4.5.-27
Applicazione paraspiro automatico / Automatic door bottom seal installation	4.3.41-42
Montaggio catenaccio / Flush bolt installation	4.3.37-40
Montaggio guarnizioni di battuta / Gasket installation	...
Sigillatura angolo nel TT / Corner joint sealing	4.5.1

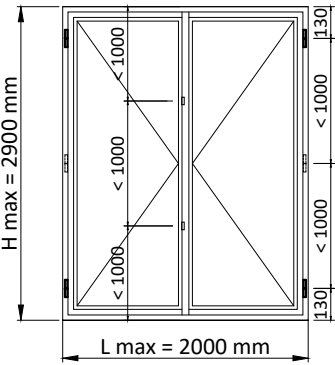
Vetrazione / Glazing

Applicazione clips fermavetro / Glazing bead clips installation	2.8.1-6
Applicazione vetro (spessoramento) / Glazing installation (setting blocks)	4.7.1-2

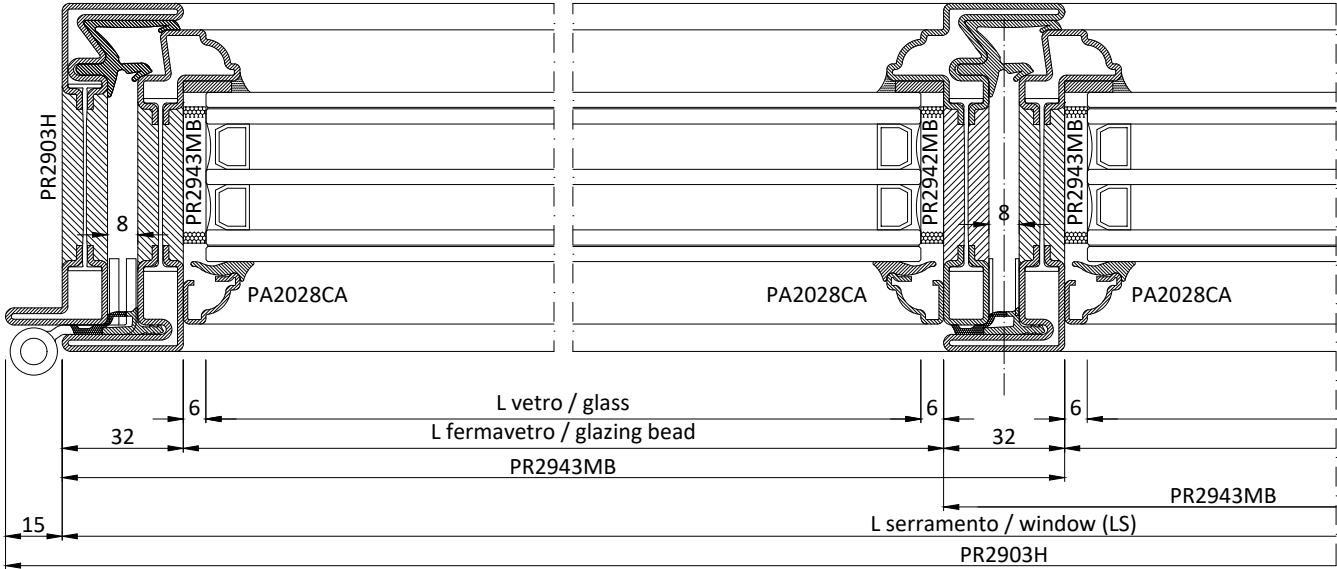


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri		Glazing beads				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	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.			
ACV87..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	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		



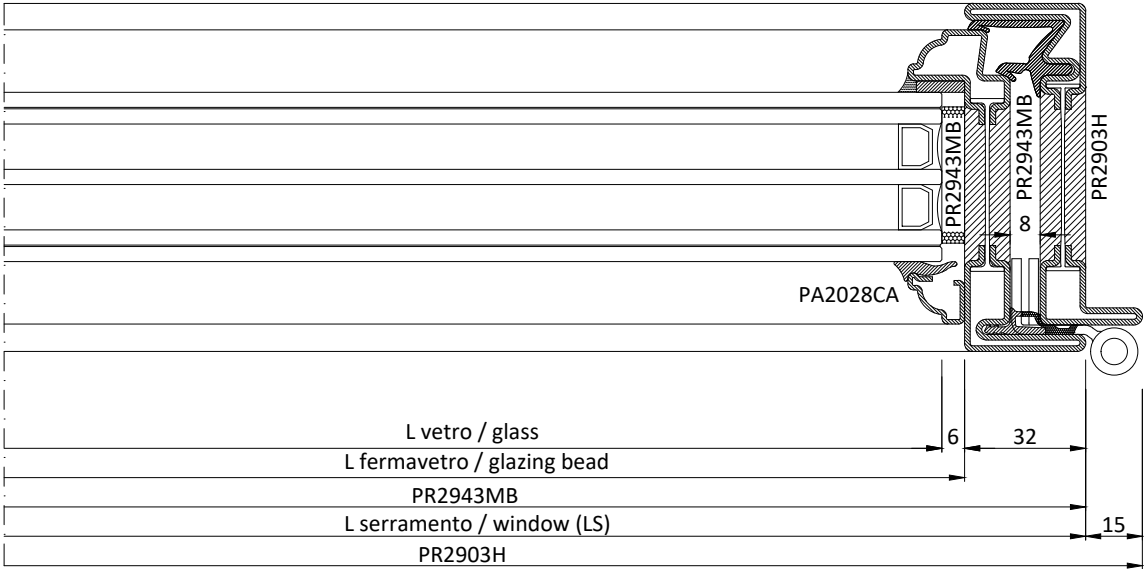
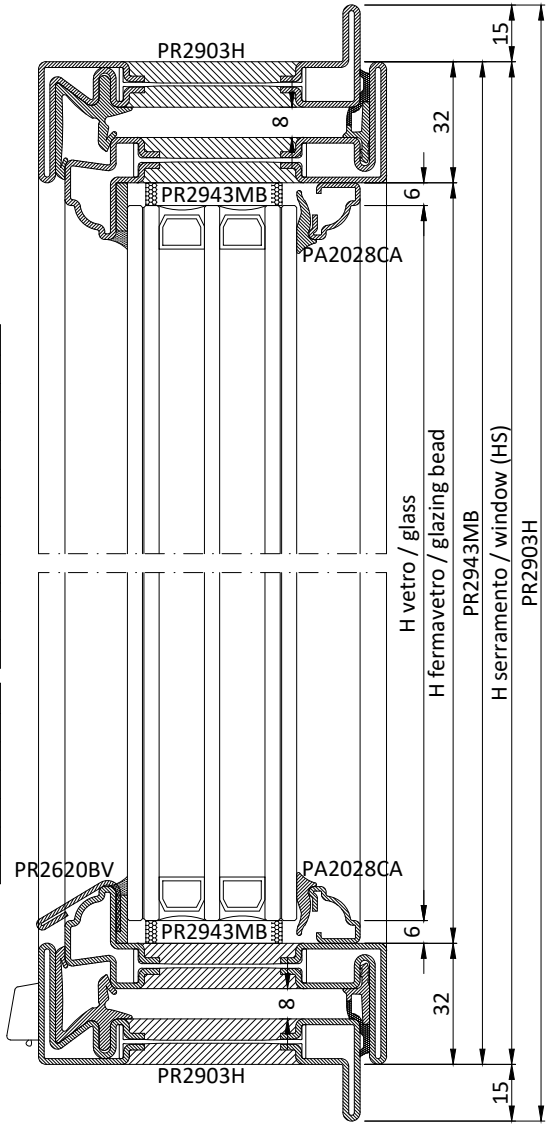


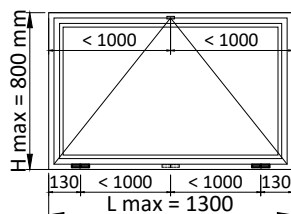
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45°	45°
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	3	HS	45°	45°
PR2942MB	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				
PA2028CA	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	4	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76		



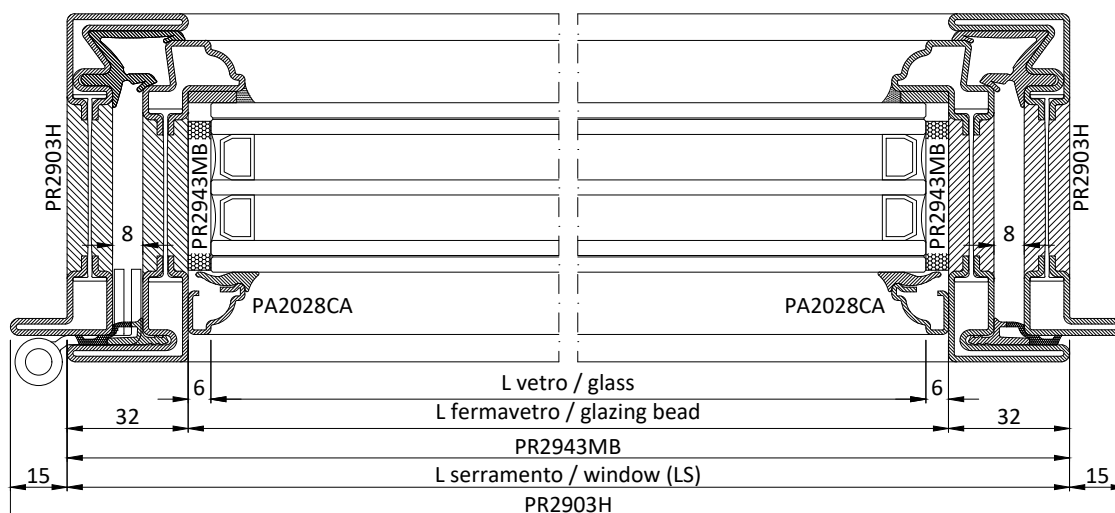
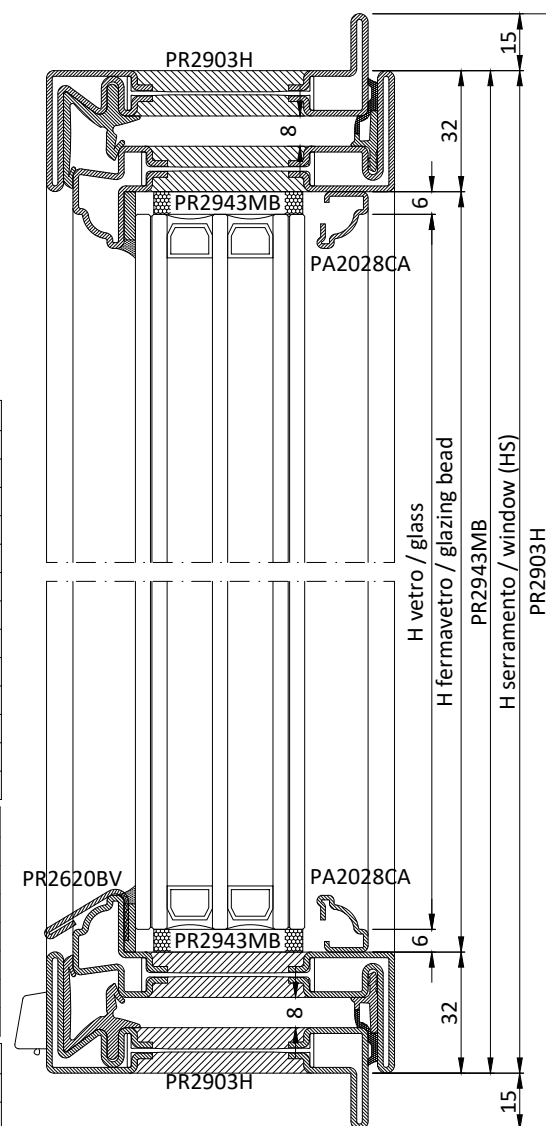
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4
AC2618.xx	Scarico acqua	Water drip	Var.
AC2622	Fermo a scatto per 2 ^a anta	Snapper for second leaf window	1
AC2624D/S	Kit cremonese	Cremona bolt set	1
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2652	Fondino per 2 ^a anta	Bottom plate for second leaf	2
AC	Cerniere	Hinges	Var.
ACV87..	Maniglia "Vitruvio"	"Vitruvio" handle	1

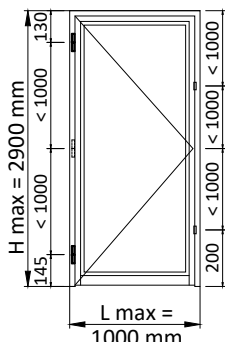
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n°
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1
GP0095	Guarnizione interna vetro	Internal weather strip	1





PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943MB	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				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	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.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	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		

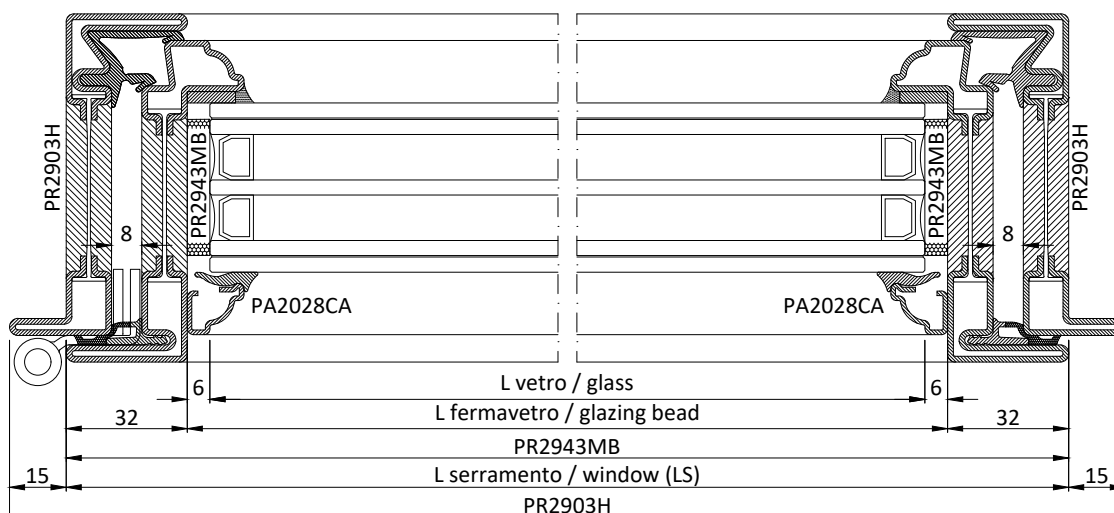
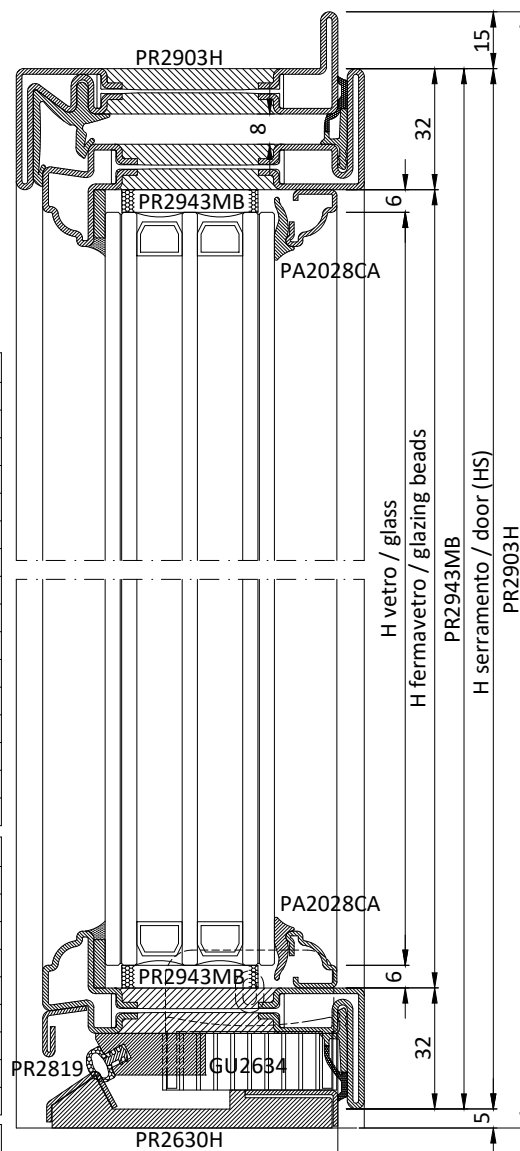


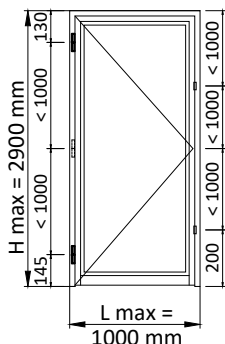


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR2630H	Profilo soglia	Threshold	1	LS-24	90°	90°
GU2634	Estruso in PVC	Rigid extruded PVC	1	LS-40	90°	90°
Anta		Leaf				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943MB	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				
PR2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2028CA	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-81		

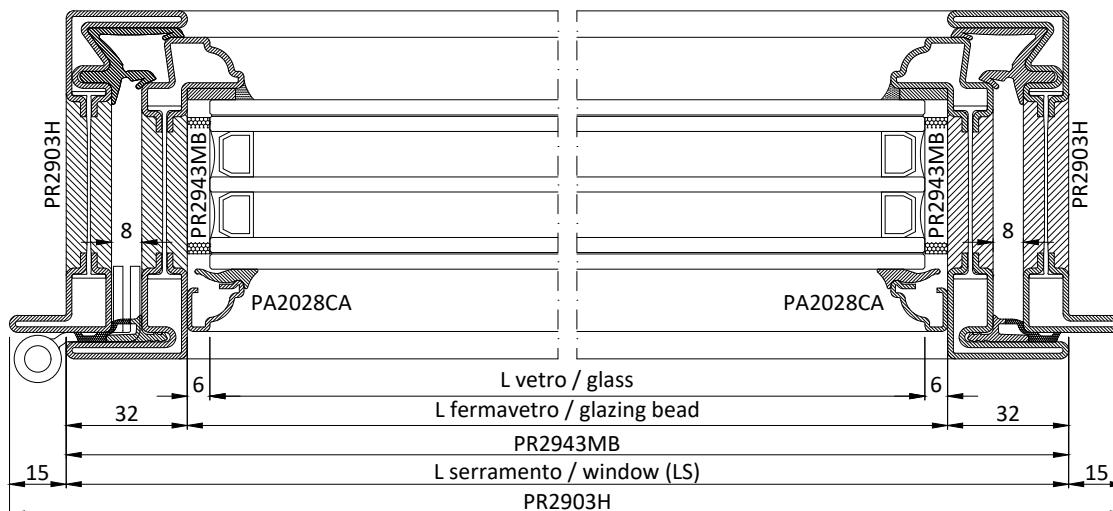
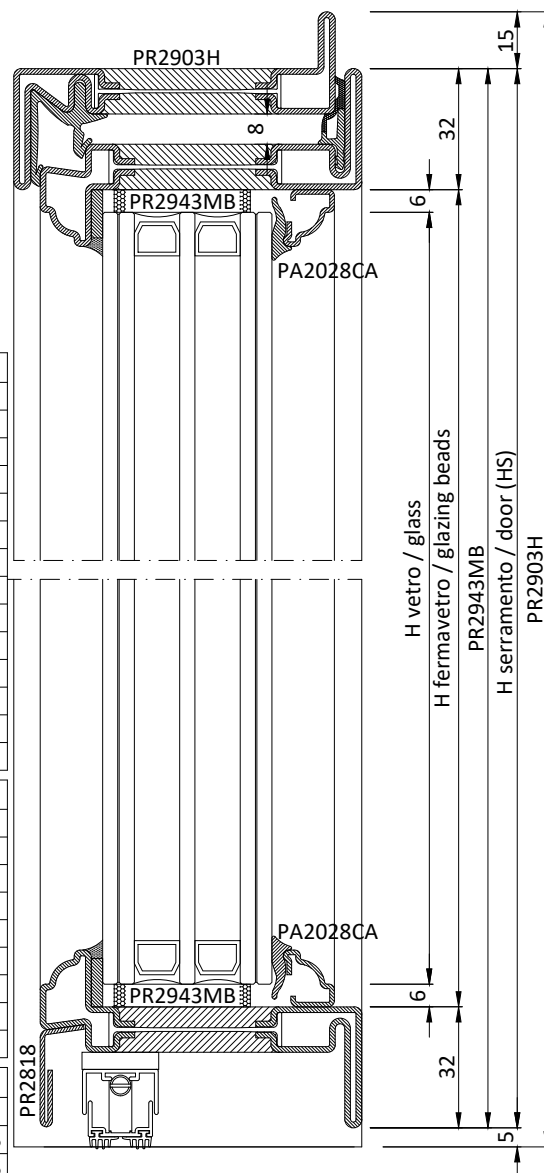
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	2
AC1081T	Accessorio di battuta	Stop accessory	2
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696BV	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1

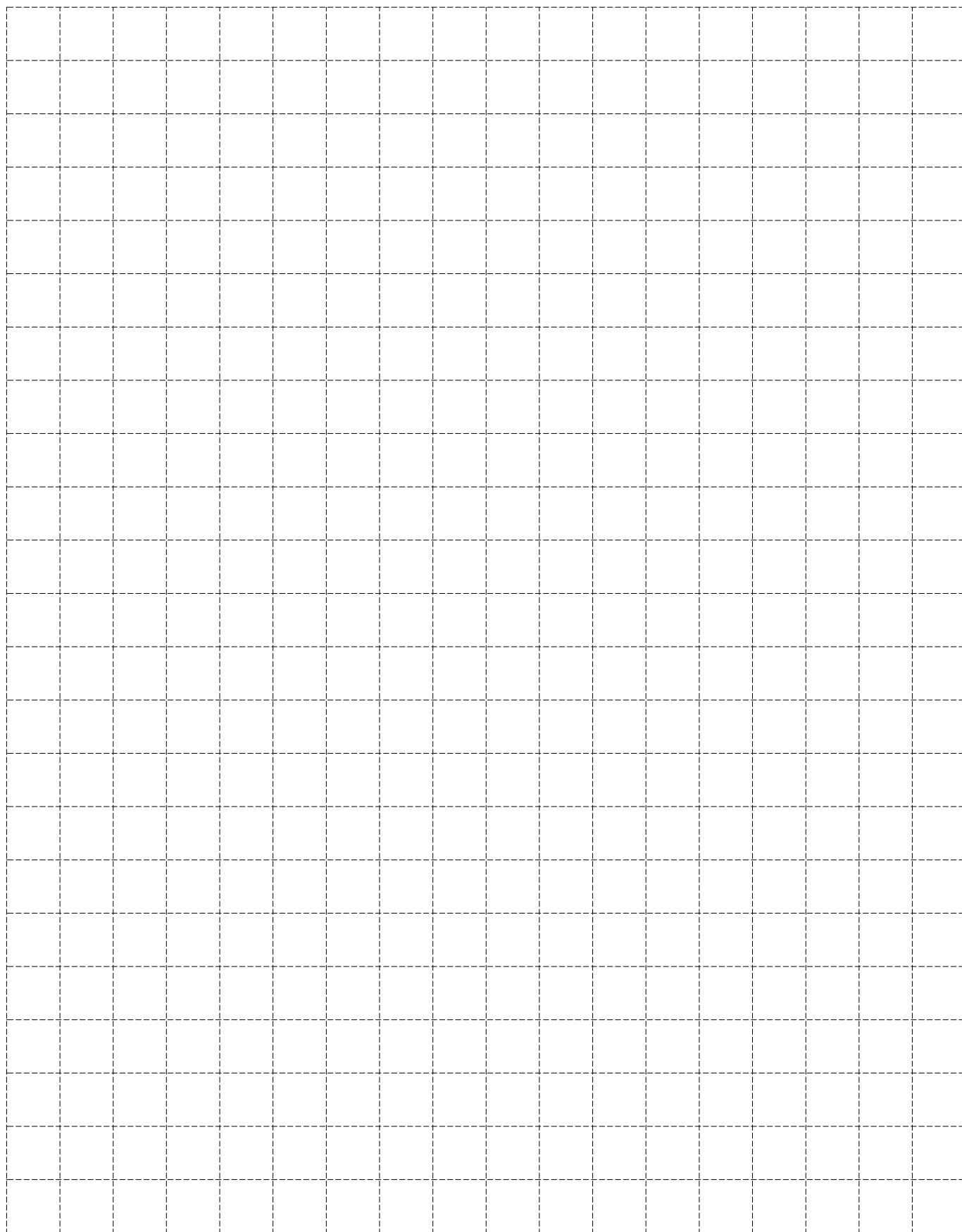
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1 1xLS+2xHS
GE1001TT	Guarnizione esterna di battuta	Rebating gasket	1 1xLS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1 1xLS+2xHS
GE2907TT	Guarnizione sotto vetro	Gasket 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

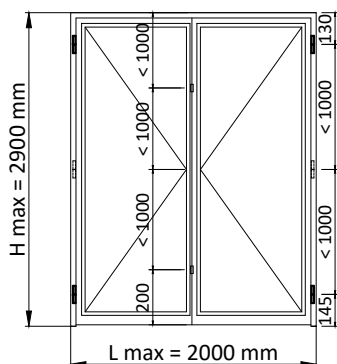




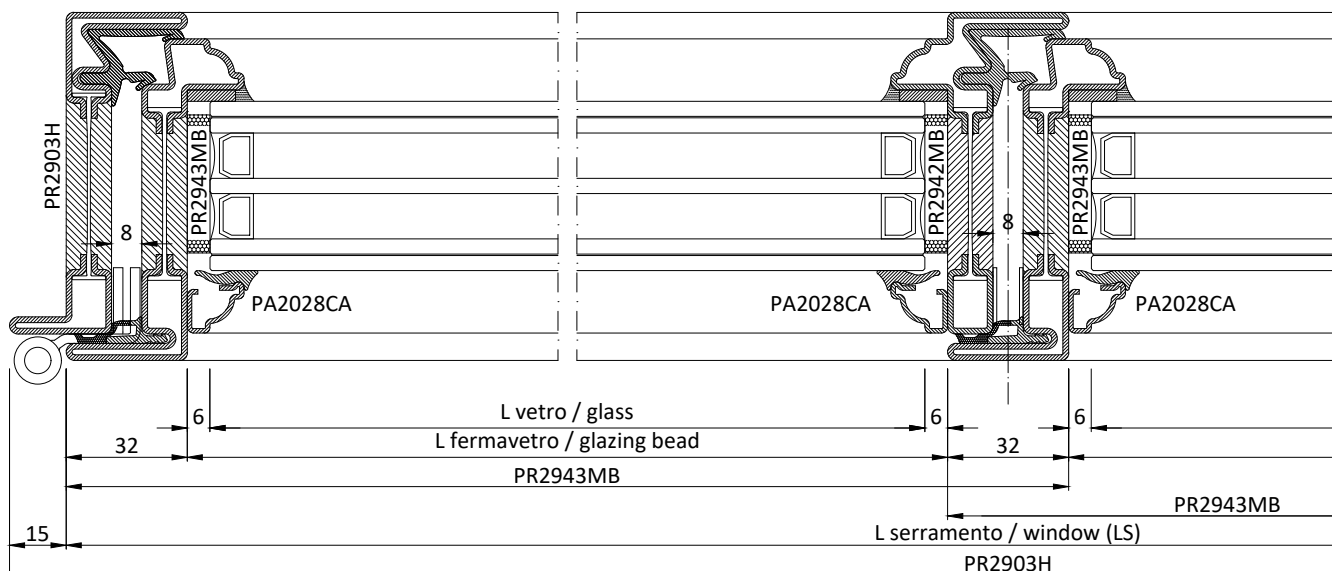
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2943MB	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				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	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.			
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			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	Guarnizione esterna 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		





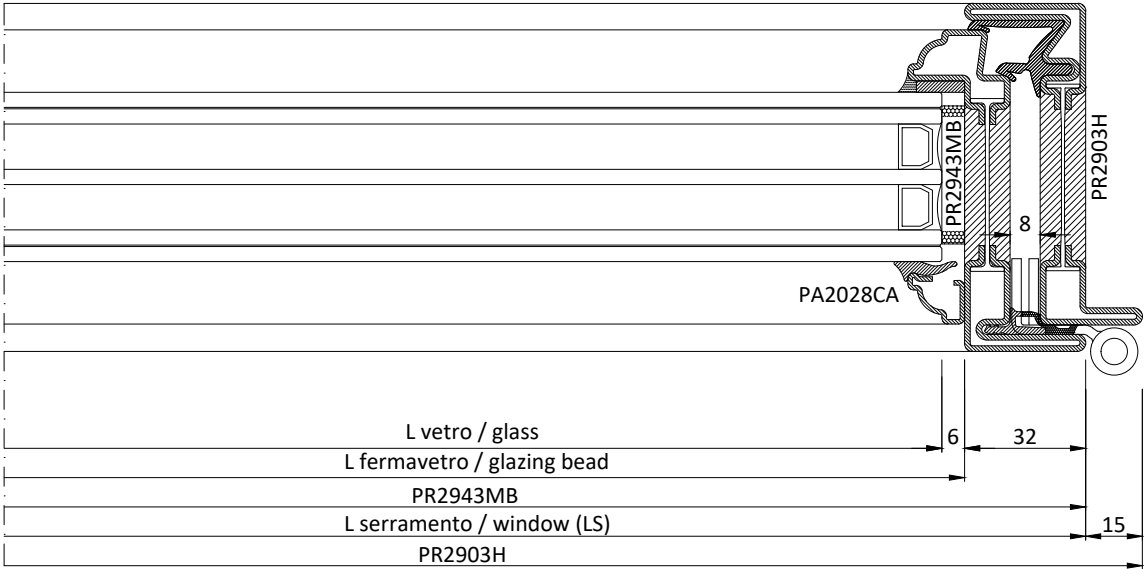
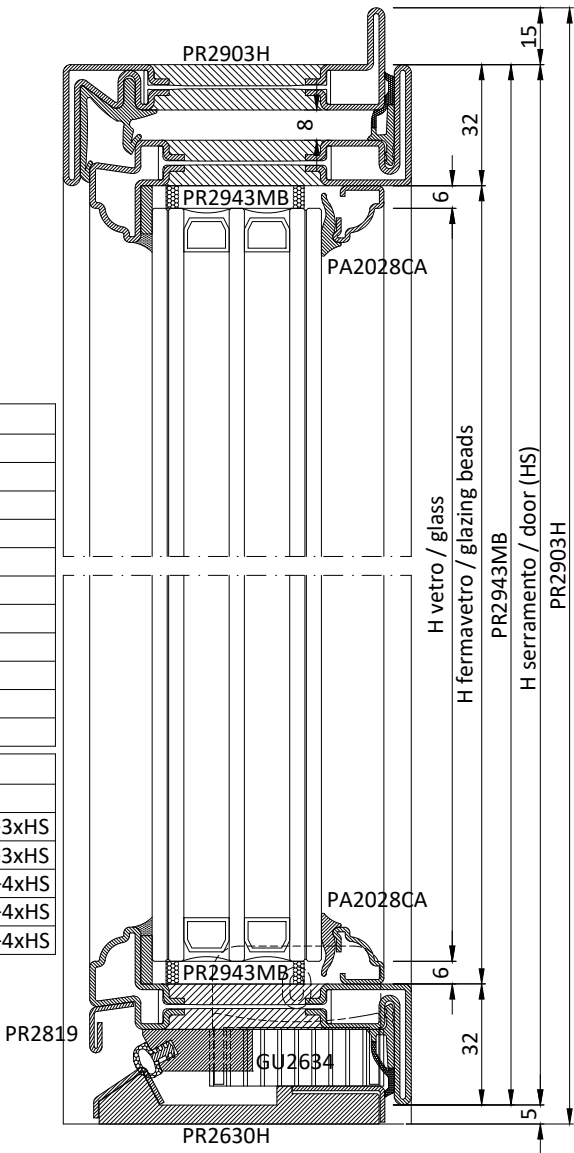


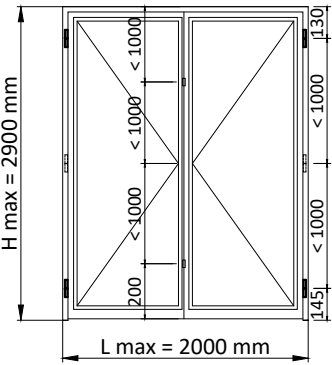
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
GU2634	Profilo porta 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				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45°	45°
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	3	HS-5	45°	45°
PR2942MB	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				
PA2028CA	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81		



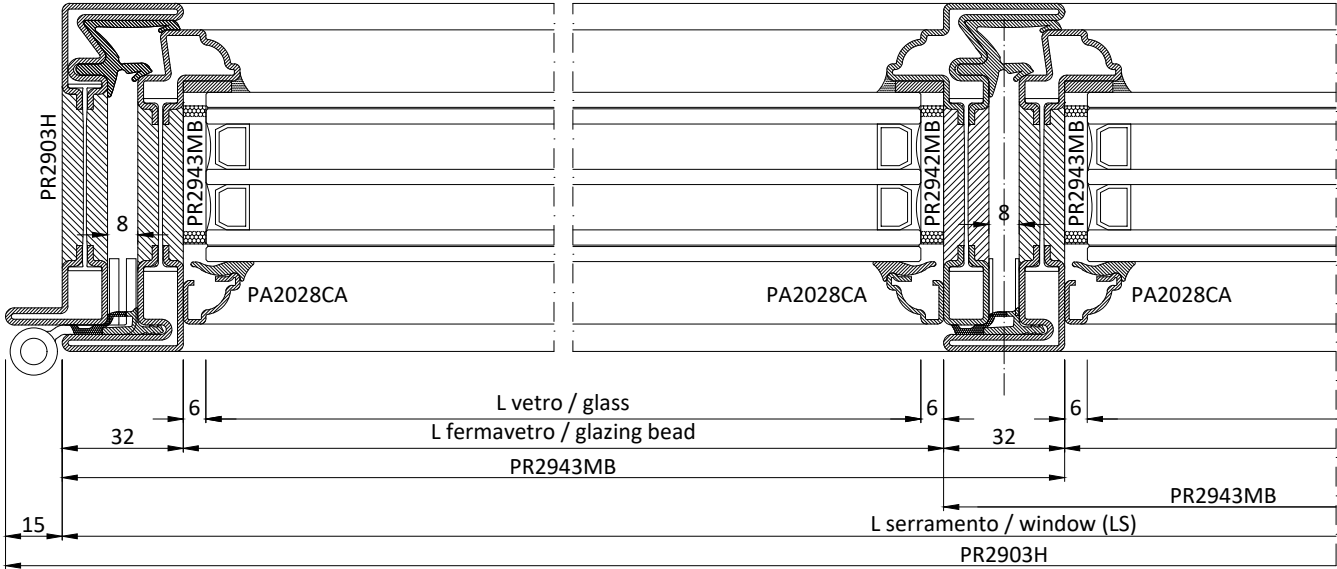
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	2
AC2621G.-	Catenaccio 2^ anta	Second leaf bolt	2
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2
AC2652	Fondino 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

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	1xLS+3xHS
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

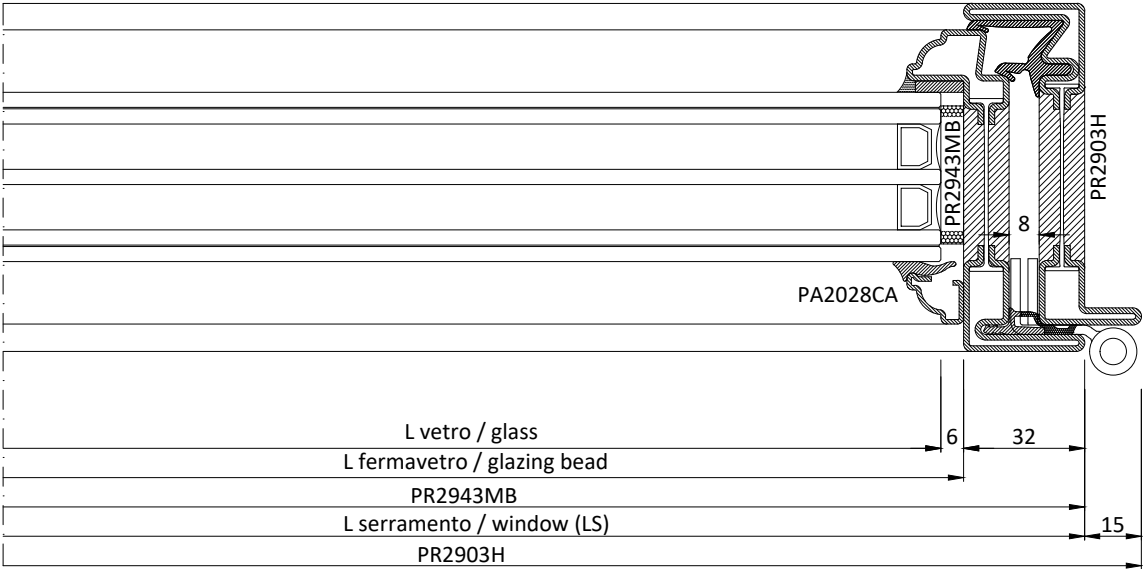
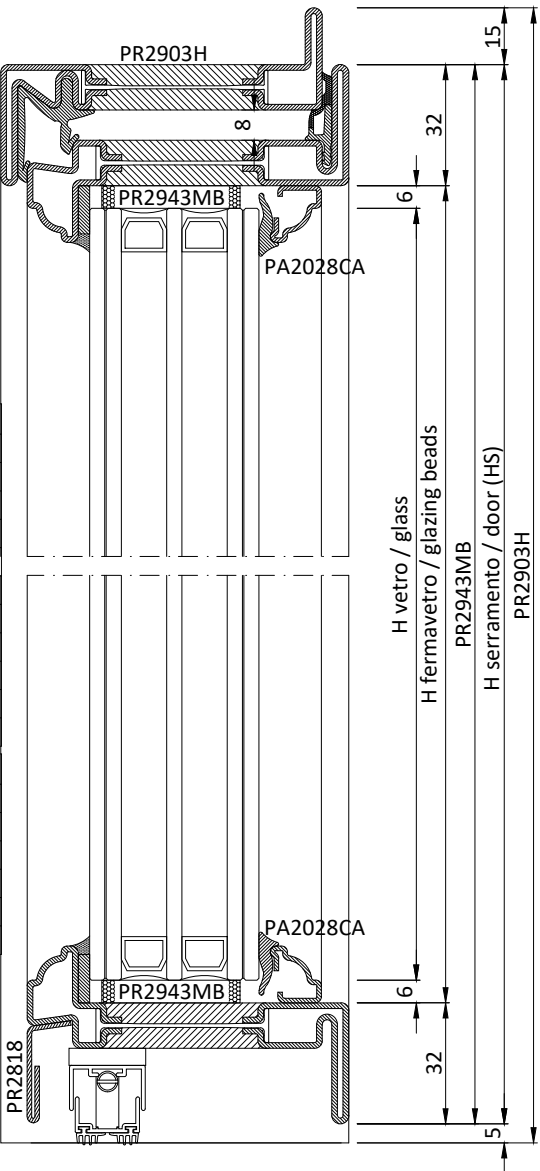


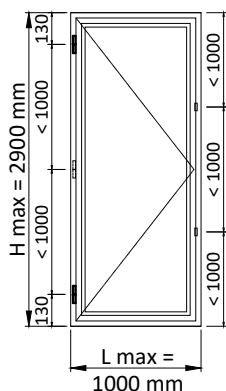


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2903H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45°	45°
PR2943MB	Profilo a "Z" anta	"Z" profile leaf	3	HS-5	45°	45°
PR2942MB	Profilo a "T" anta	"T" profile leaf	1	HS-5	45°	45°
PR2818	Profilo gocciolatoio	Water drip profile	2	LS/2-35	90°	90°
Fermavetri		Glazing beads				
PR2028CA	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PR2028CA	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	
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2	
AC2652	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	
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	1xLS+3xHS
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

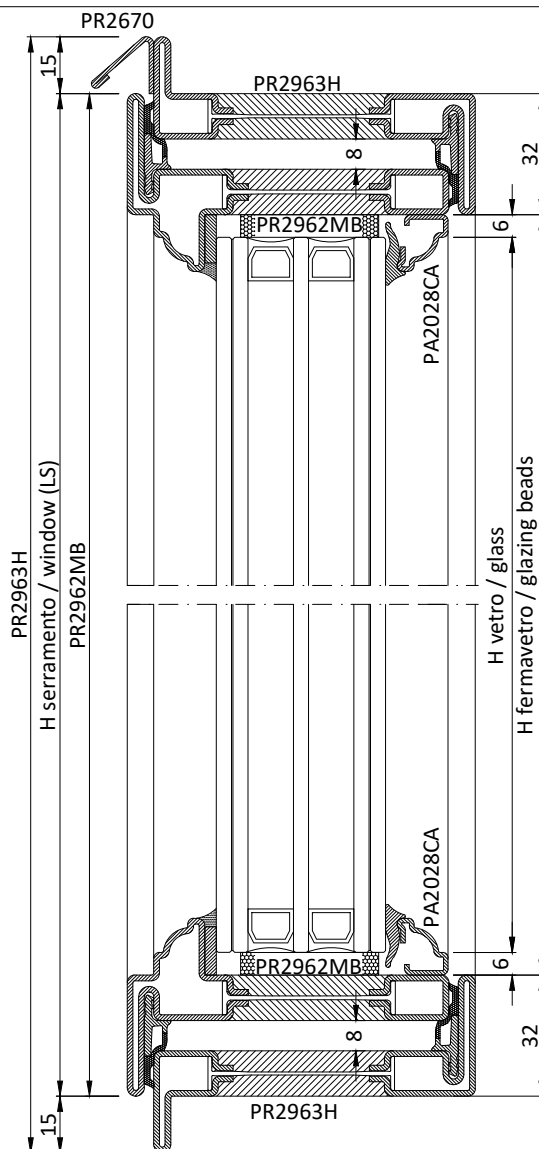




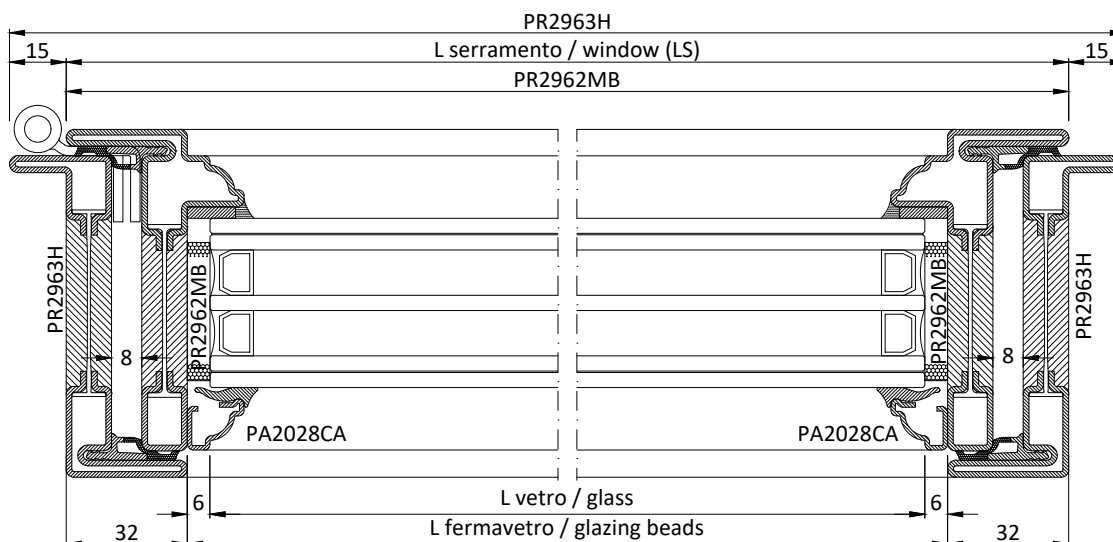
PROFILI			PROFILES			
Cod.	Descrizione	Description	n° Dim.		Taglio	Cutting
Telaio		Frame				
PR2963H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta		Leaf				
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	LS	45°	45°
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	HS	45°	45°
Fermavetri		Glazing beads				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		

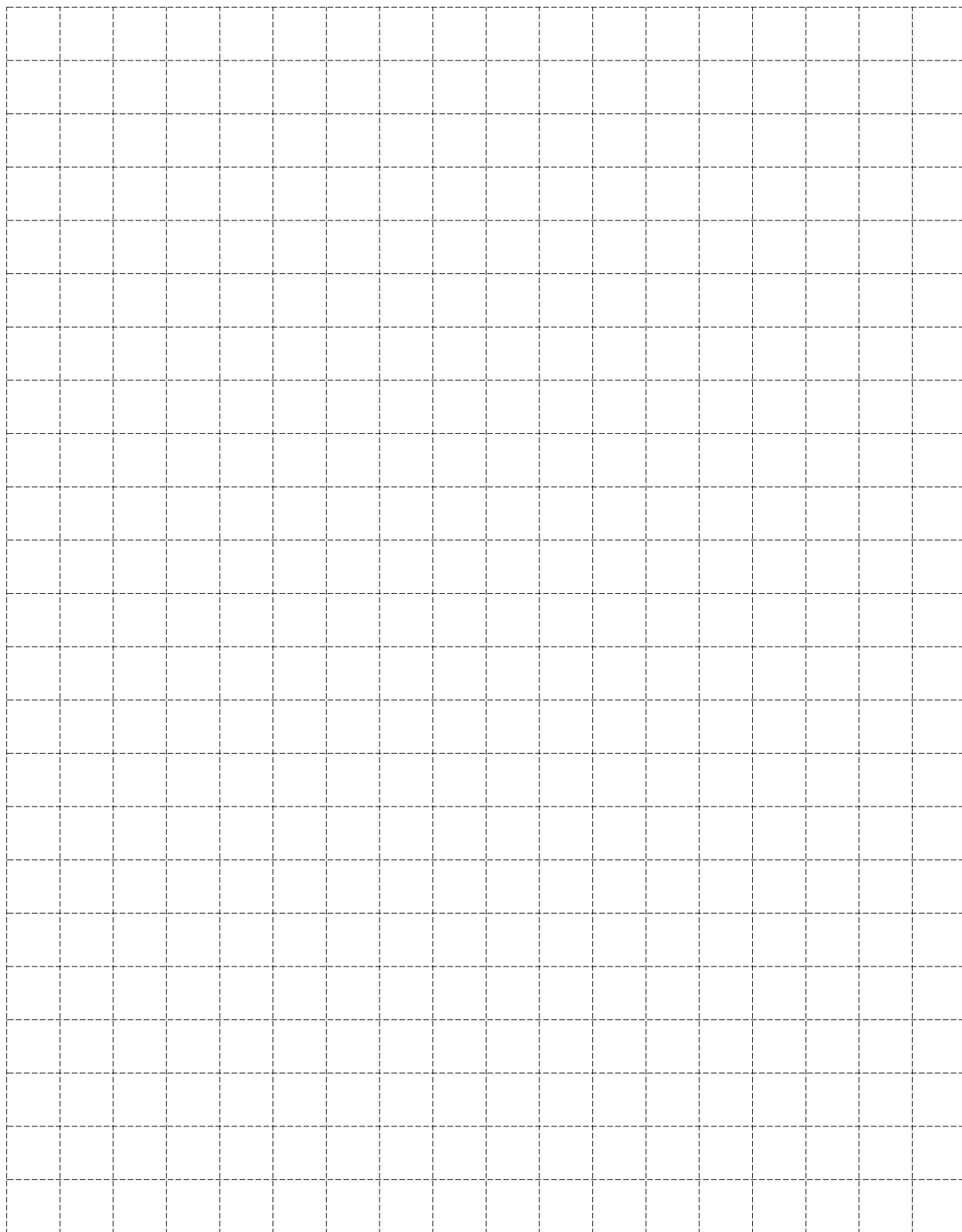
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2680 ..	Maniglia di trascimento	Dragging leaf handle	1
AC2683D/S	Kit cremonese	Cremone bolt set	1
AC2687	Braccetti limitatori	Casement stays	Opz.
AC	Cerniere	Hinges	Var.
ACV87..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

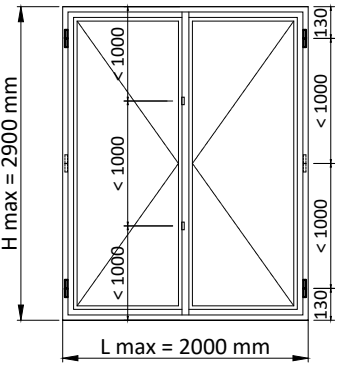
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 4xLS+4xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna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



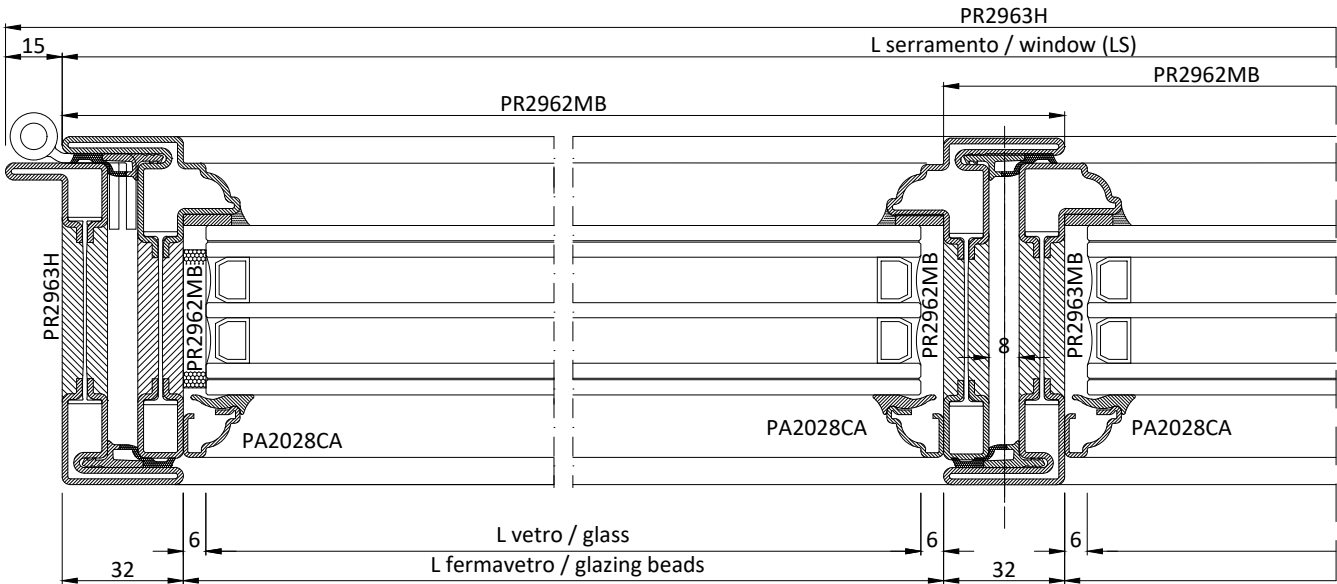
** 1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949







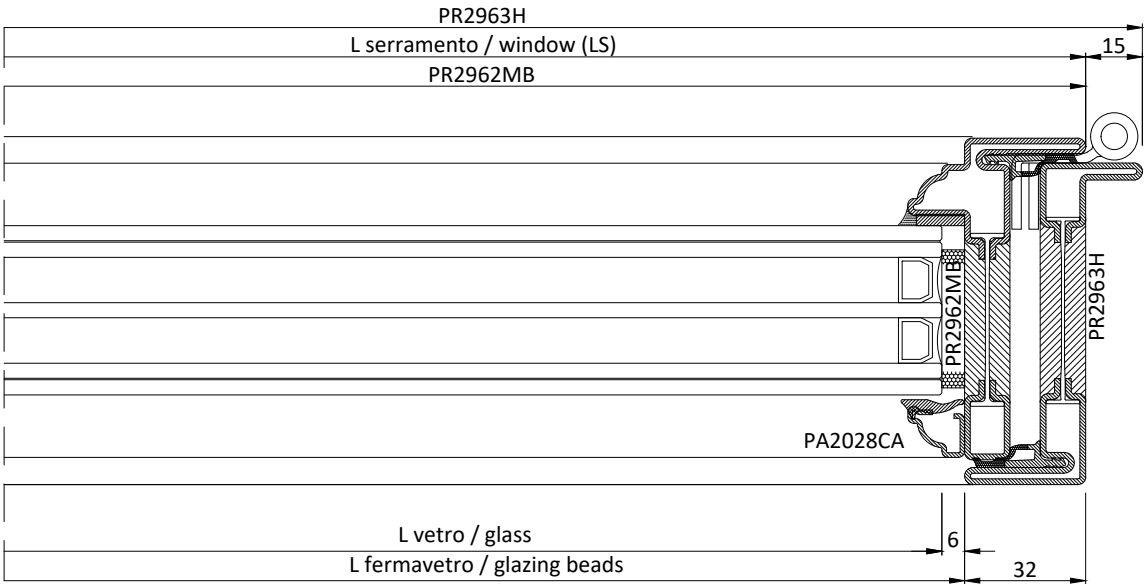
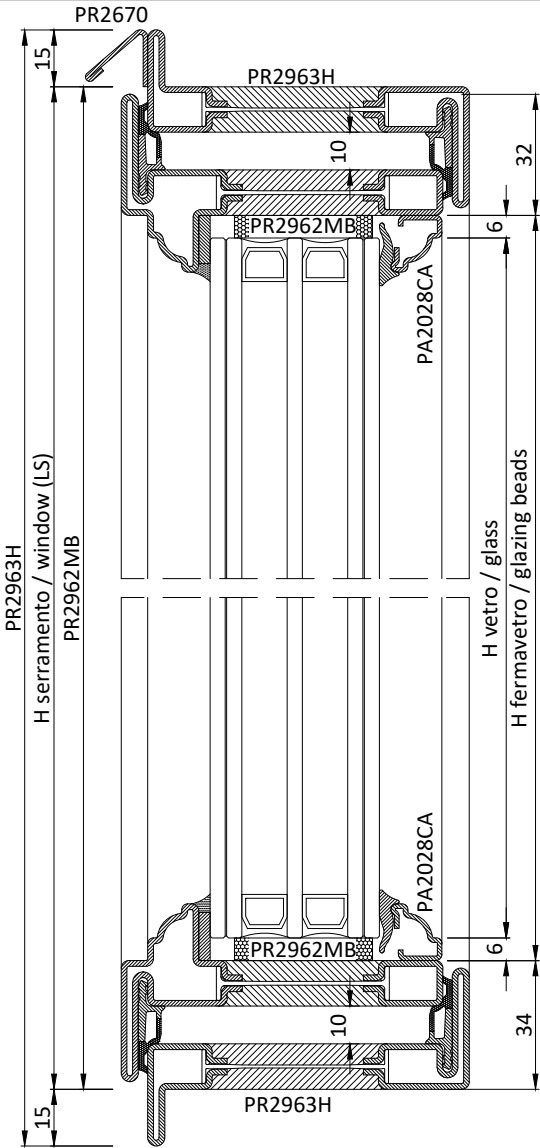
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2963H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta		Leaf				
PR2962MB	Profilo a "T" anta	"T" profile leaf	4	LS/2+16	45°	45°
PR2962MB	Profilo a "T" anta	"T" profile leaf	3	HS	45°	45°
PR2963MB	Profilo a "Z" anta	"Z" profile leaf	1	HS	45°	45°
Fermavetri		Glazing beads				
PA2028CA	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	4	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76		

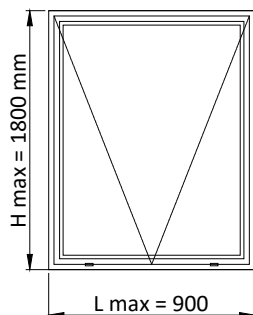


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2653	Fondino per 2^ anta	Bottom plate for second 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.
ACV87..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

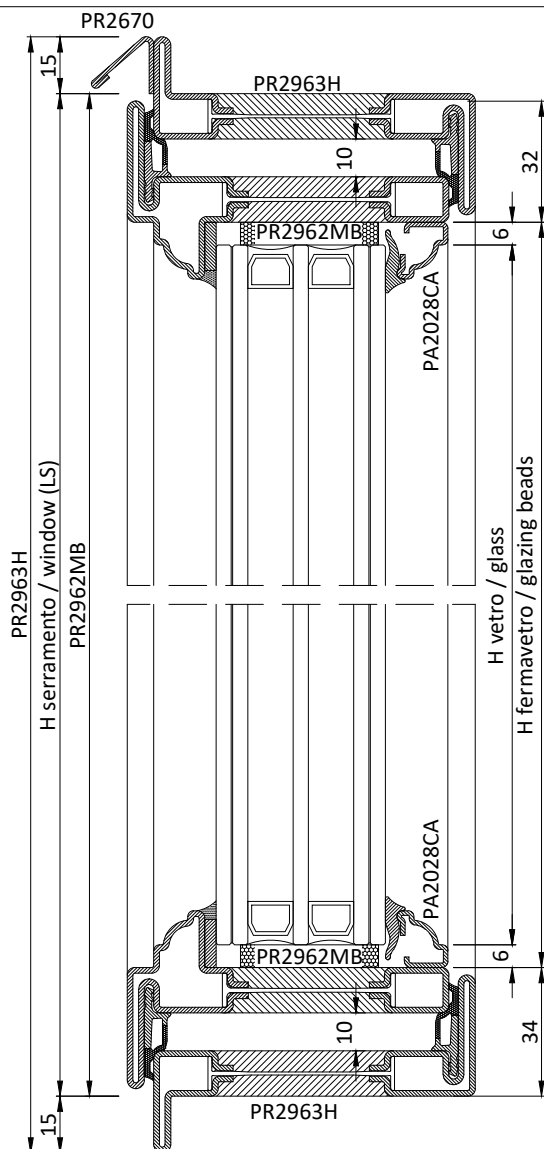
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	2xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna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

**1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hingeAC2648/ACB648/AC2949

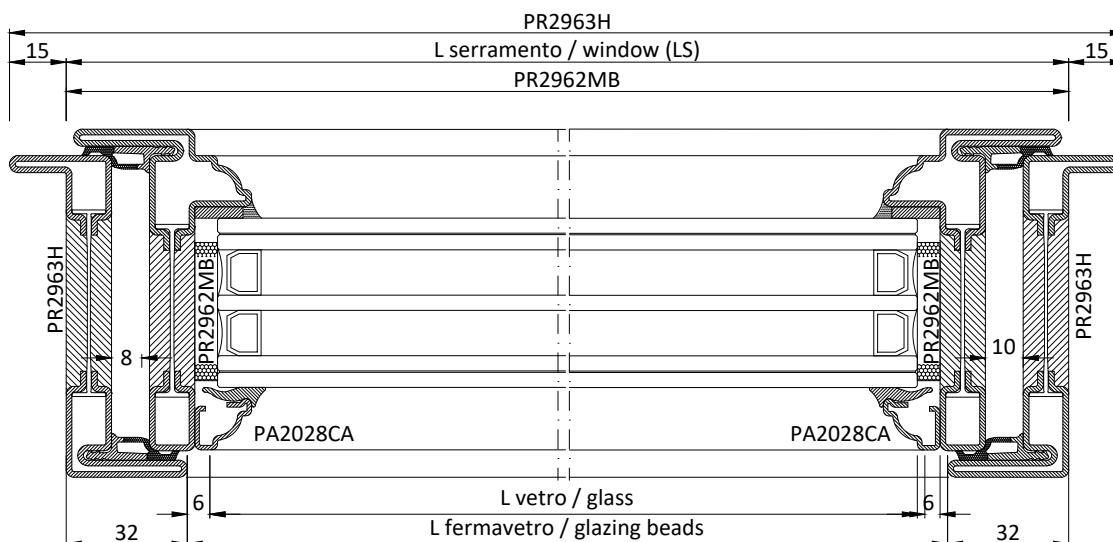


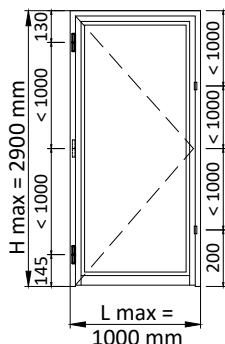


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2963H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta		Leaf				
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	LS-4	45°	45°
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	HS-4	45°	45°
Fermavetri		Glazing beads				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-68	45°	45°
PA2028CA	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	Cremona bolt set	1			
AC	Coppia compassi	Pair of side arm	1			
AC	Cerniere (solo con AC2690)	Hinges (only with AC2690)	Opz.			
ACV87..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
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		



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

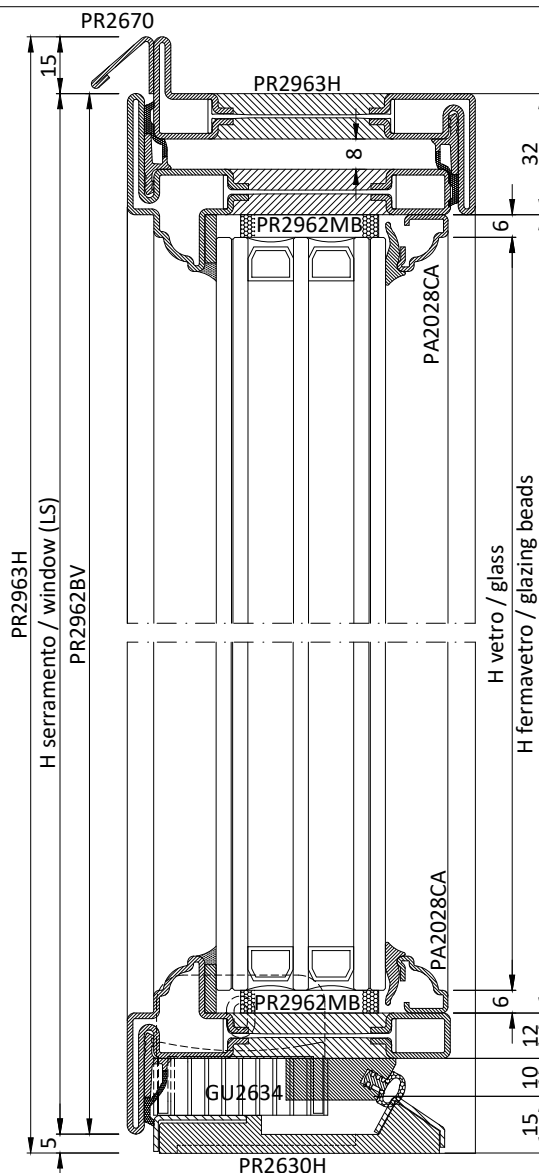




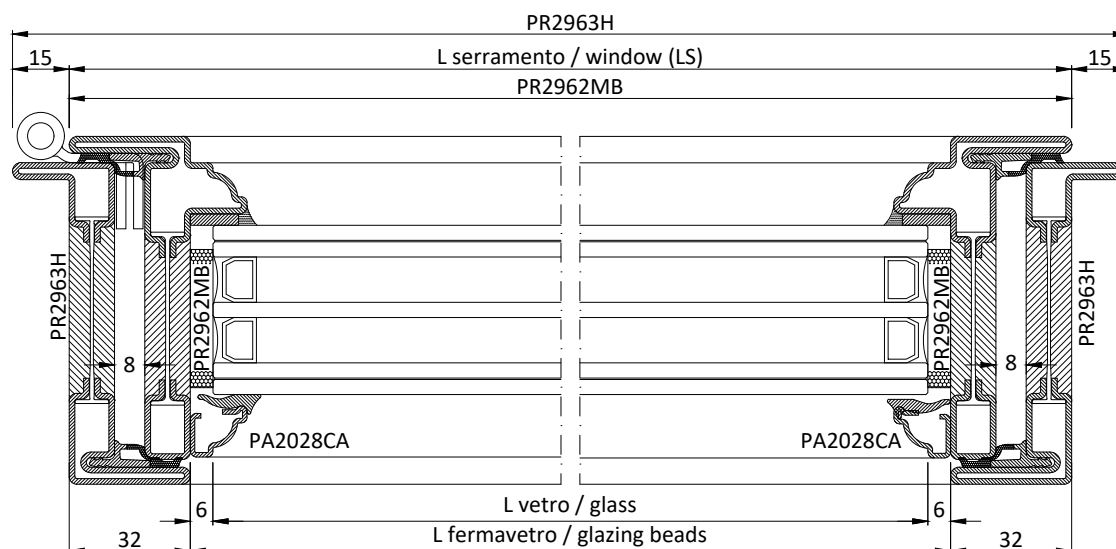
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
PROFILATI		PROFILES				
Telaio		Frame				
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
PR2630H	Profilo soglia	Threshold	1	LS-24	90°	90°
GU2634	Estruso in PVC	Rigid extruded PVC	1	LS-40	90°	90°
Anta		Leaf				
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	LS	45°	45°
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	HS-5	45°	45°
Fermavetri		Glazing beads				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-81		

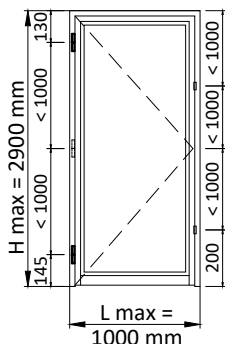
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC1081T	Accessorio di battuta	Stop accessory	2
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696BV	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
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
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



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

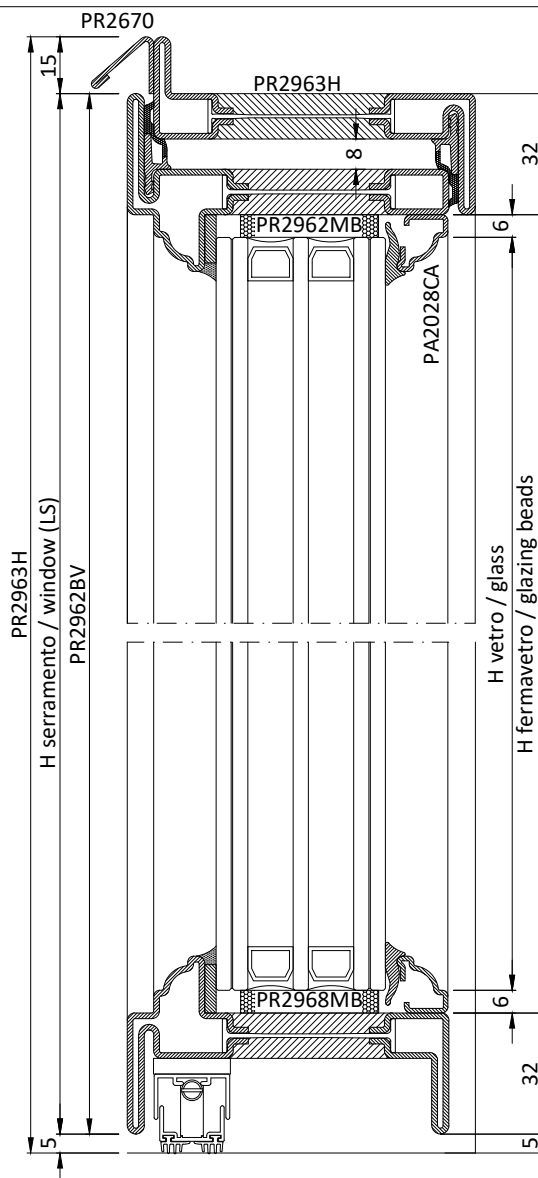




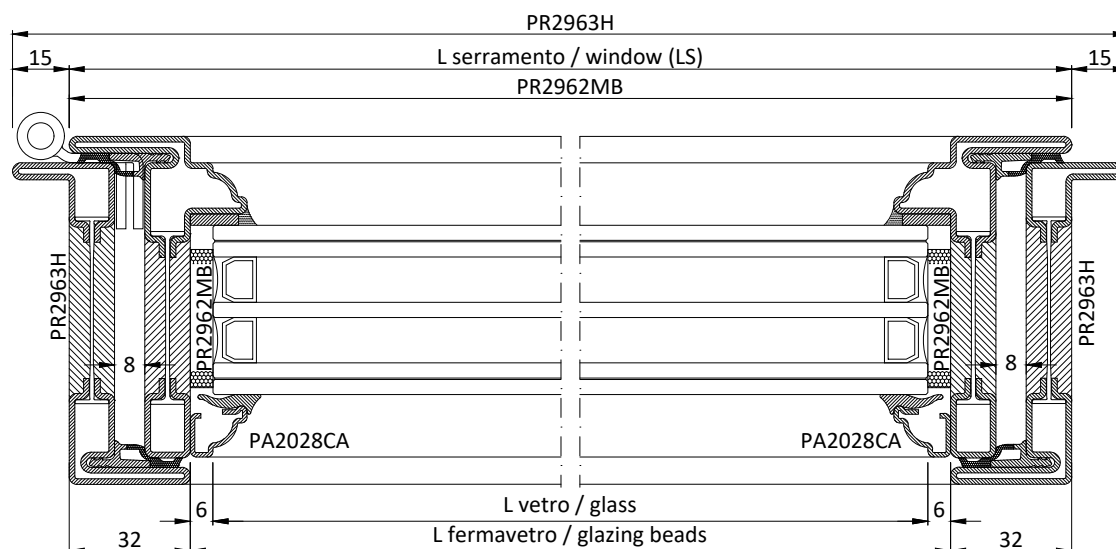
	PROFILI	PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
	Telaio	Frame				
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
	Anta	Leaf				
PR2962MB	Profilo a "T" anta	"T" profile leaf	1	LS	45°	45°
PR2962MB	Profilo a "T" anta	"T" profile leaf	2	HS-5	45°	45°
PR2968MB	Profilo zoccolo	Zocle profile leaf	1	LS	45°	45°
	Fermavetri	Glazing beads				
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
	Vetri	Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-81		

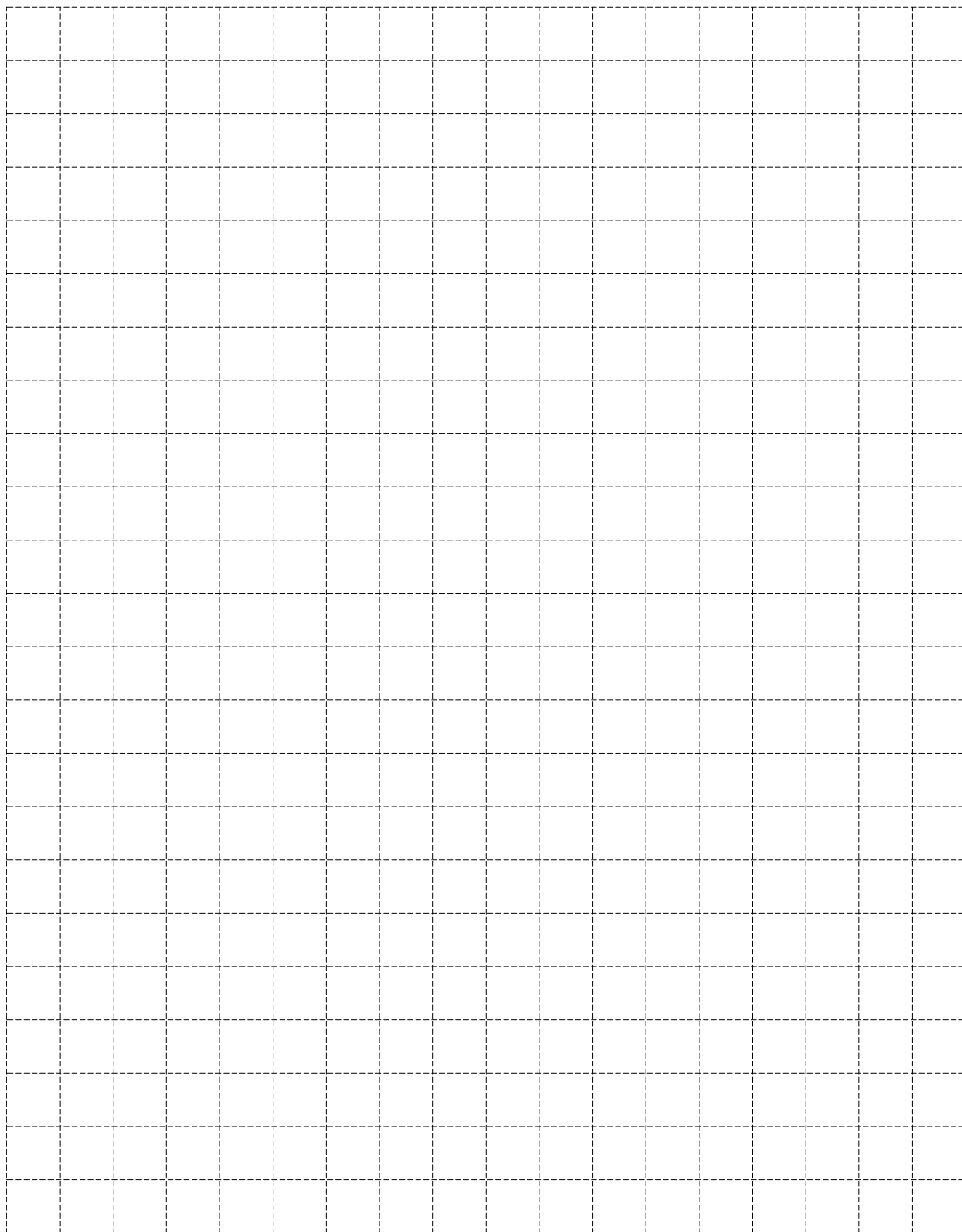
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	<i>Clips to secure glazing beads</i>	Var.
AC2636/.	Guarnizione automatica	<i>Automatic underdoor seal gasket</i>	1
AC	Serratura	<i>Lock</i>	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	<i>Additional closing</i>	Opz.
AC2696BV	Scatola copri serratura	<i>Lock cover box</i>	1
AC	Cerniere	<i>Hinges</i>	Var.
ACV95..	Maniglia "Vitruvio"	<i>"Vitruvio" handle</i>	1
AC2648R**	Rinforzo cerniera per PR2962BV	<i>Reinforcement for PR2962BV</i>	Var.

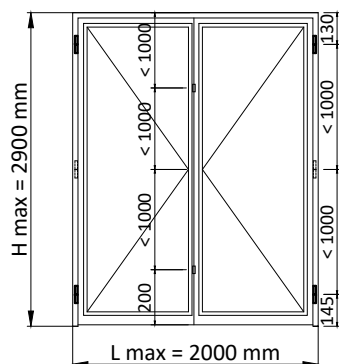
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	1xLS+2xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+2xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS
GP0095	Guarnizione interna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



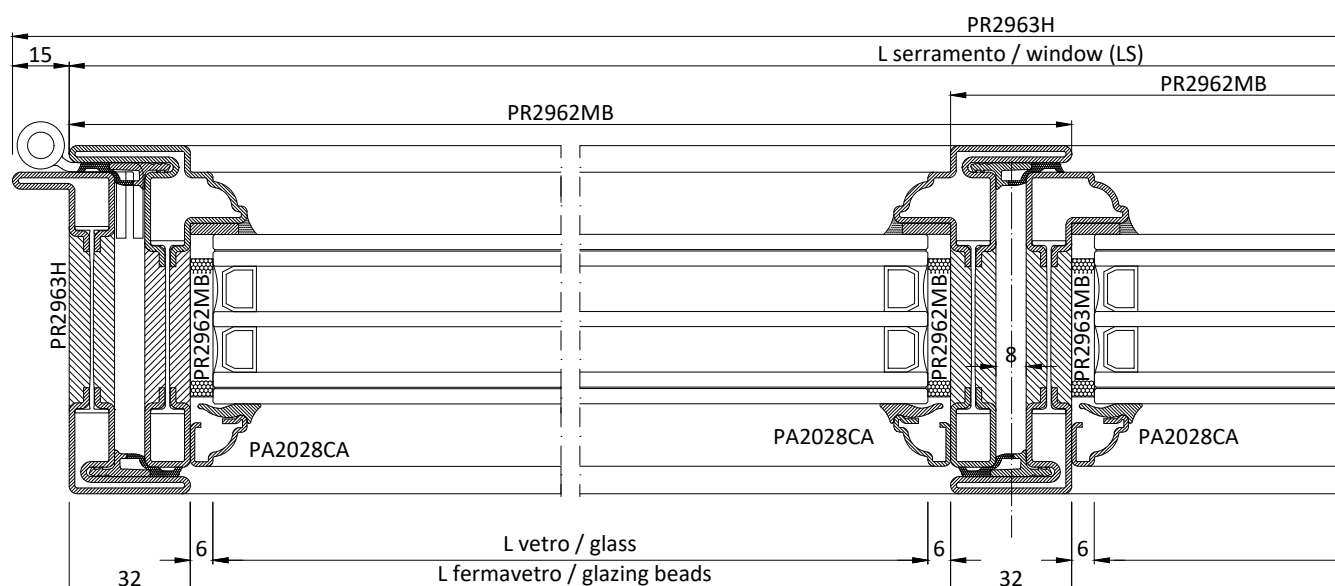
****1 rinforzo per cerniera AC2648/ACB648/AC2949**
1 reinforcement for hinge AC2648/ACB648/AC2949





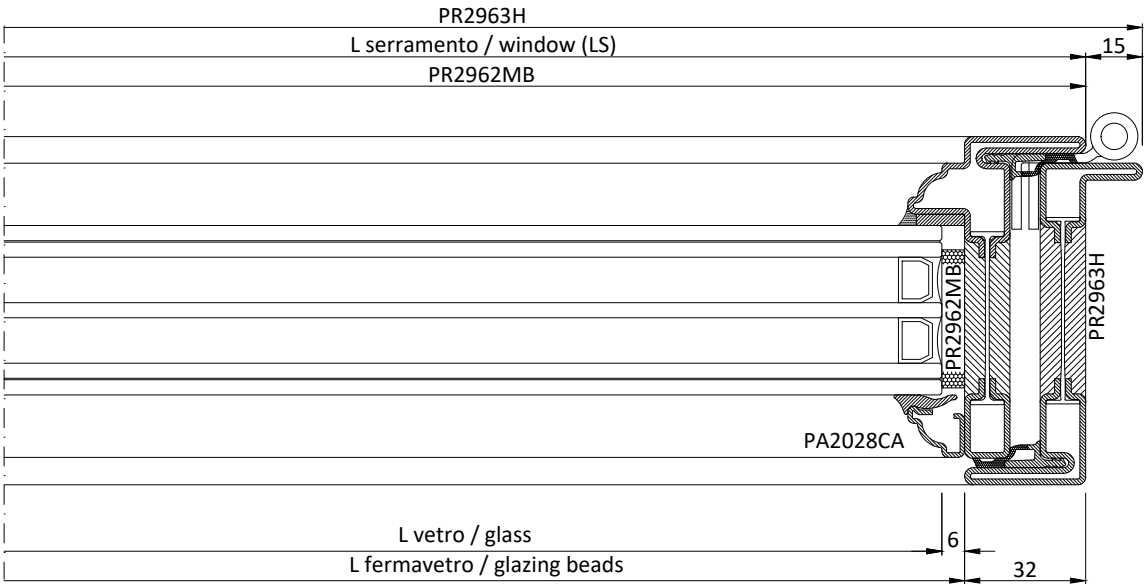
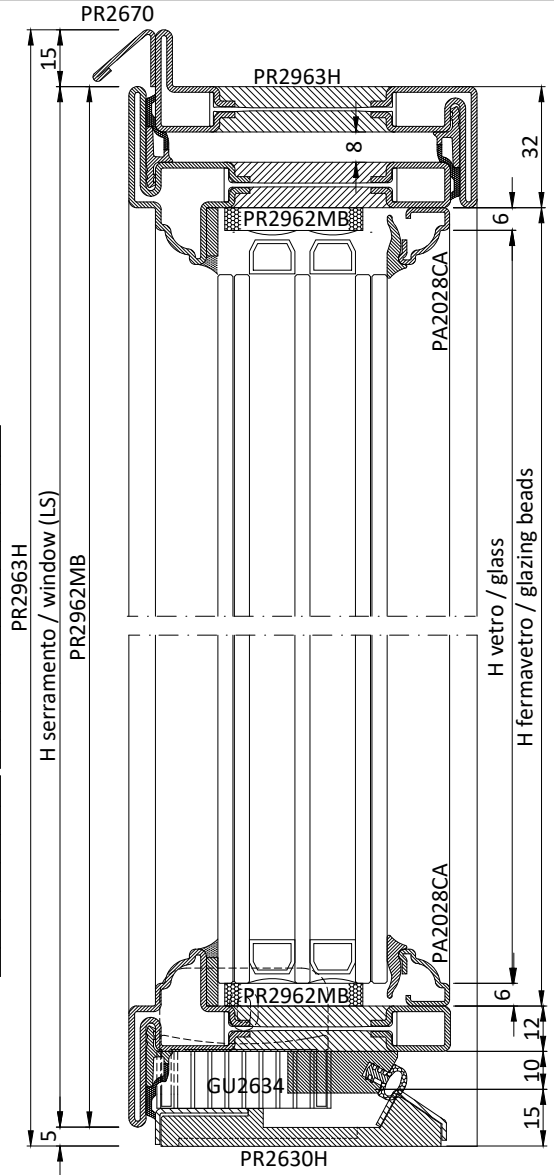


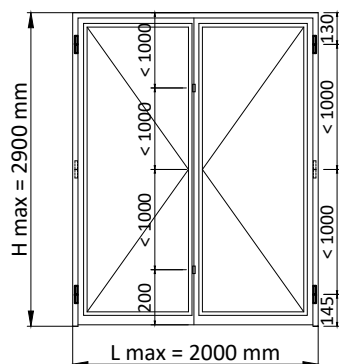
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°Dim.	Taglio	Cutting
Telaio		Frame			
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1 LS+30	45°	45°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1 HS+15	45°	90°
PR2963H	Profilo a "Z" telaio	"Z" profile frame	1 HS+15	90°	45°
PR2670	Profilo Gocciaio	Water drip profile	1 LS+30	90°	90°
PR2630H	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			
PR2962MB	Profilo a "T" anta	"T" profile leaf	4 LS/2+16	45°	45°
PR2962MB	Profilo a "T" anta	"T" profile leaf	3 HS-5	45°	45°
PR2963MB	Profilo a "Z" anta	"Z" profile leaf	1 HS-5	45°	45°
Fermavetri		Glazing beads			
PA2028CA	Profilo fermavetro	Glazing bead profile	4 LS/2-48	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	4 HS-69	45°	45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2 LS/2-60 x HS-81		



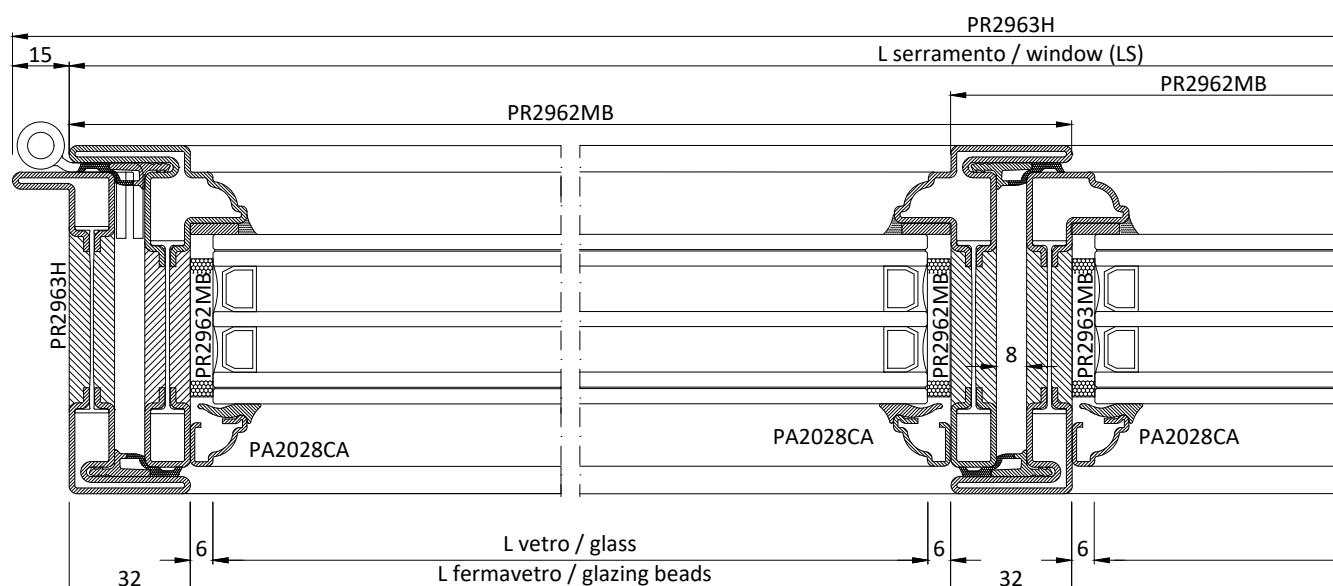
ACCESSORI		HARDWARE		
Cod.	Descrizione	Description	n°	
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.	
AC2621G.-	Catenaccio 2^ anta	Second leaf bolt	2	
AC1081T	Accessorio di battuta	Stop accesory	2	
AC2653	Fondino per 2^ anta	Botton plate for second leaf	2	
AC	Serratura	Lock	1	
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	
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.	
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	3xLS+6xHS
GE1001TT	Guarnizione di battuta	Rebating gasket	1	1xLS
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

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





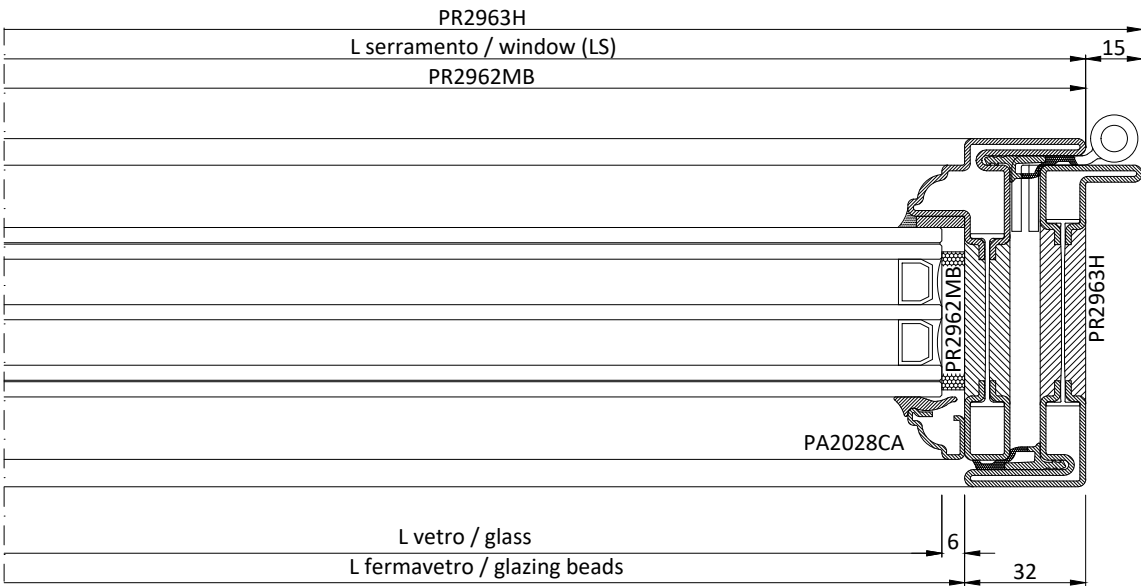
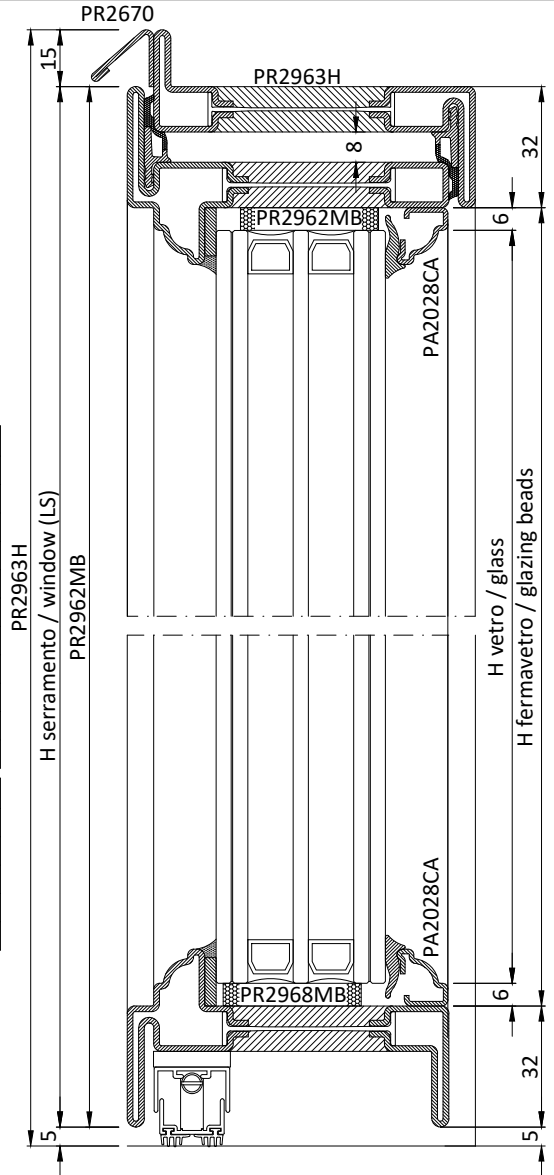
PROFILI			PROFILES				
Cod.	Descrizione		Description	n°	Dim.	Taglio	Cutting
Telaio			Frame				
PR2963H	Profilo a "Z" telaio		"Z" profile frame	1	LS+30	45°	45°
PR2963H	Profilo a "Z" telaio		"Z" profile frame	1	HS+15	45°	90°
PR2963H	Profilo a "Z" telaio		"Z" profile frame	1	HS+15	90°	45°
PR2670	Profilo Gocciolatoio		Watre drip profile	1	LS+30	90°	90°
Anta			Leaf				
PR2962MB	Profilo a "T" anta		"T" profile leaf	2	LS/2+16	45°	45°
PR2962MB	Profilo a "T" anta		"T" profile leaf	3	HS-5	45°	45°
PR2963MB	Profilo a "Z" anta		"Z" profile leaf	1	HS-5	45°	45°
PR2968MB	Profilo Zoccolo		Zocle profile leaf	2	LS/2+16	45°	45°
Fermavetri			Glazing beads				
PR2028CA	Profilo fermavetro		Glazing bead profile	4	LS/2-48	45°	45°
PR2028CA	Profilo fermavetro		Glazing bead profile	4	HS-69	45°	45°
Vetri			Glass unit				
-	Vetrocamera		Insulated glass	2	LS/2-60 x HS-81		

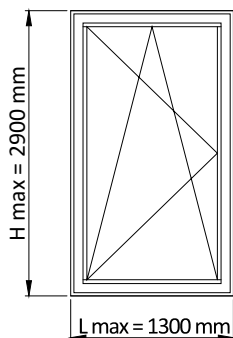


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2621G.-	Catenaccio 2^ anta	Second leaf bolt	2
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2
AC2653	Fondino per 2^ anta	Bottom plate for second leaf	2
AC	Serratura	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
AC2648R**	Rinforzo cerniera per PR2962BV	Reinforcement for PR2962BV	Var.

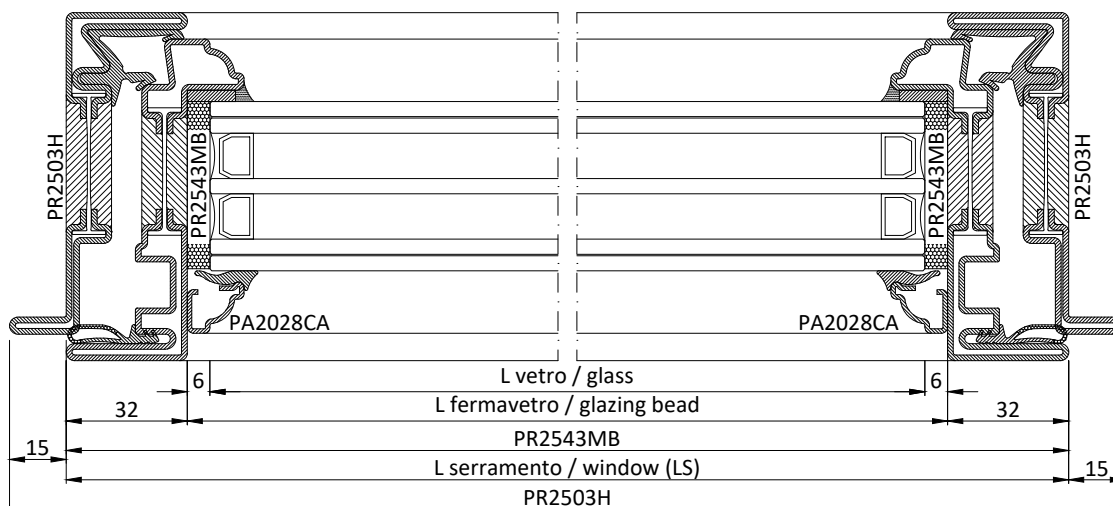
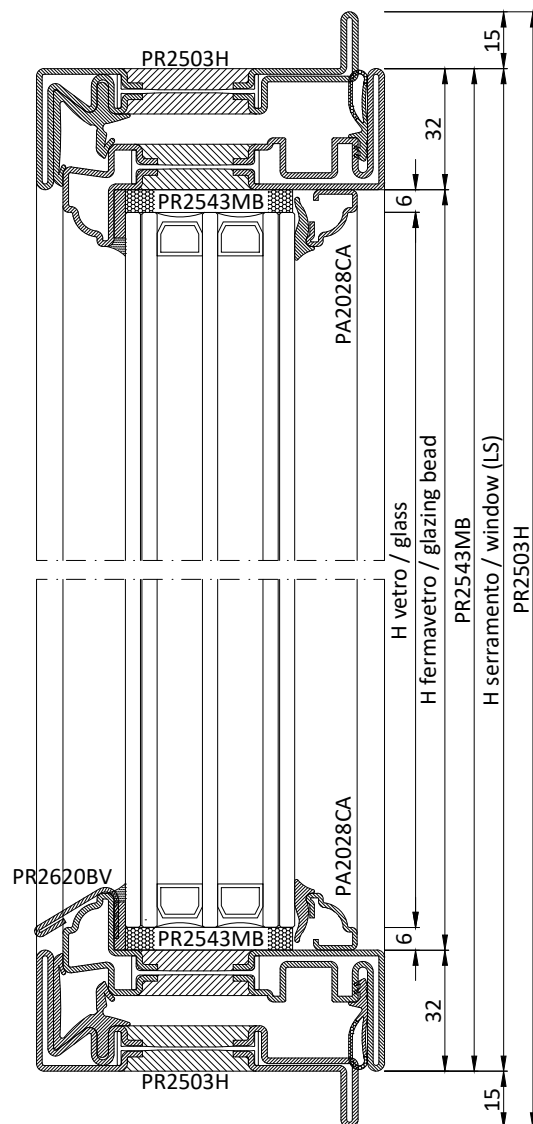
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna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

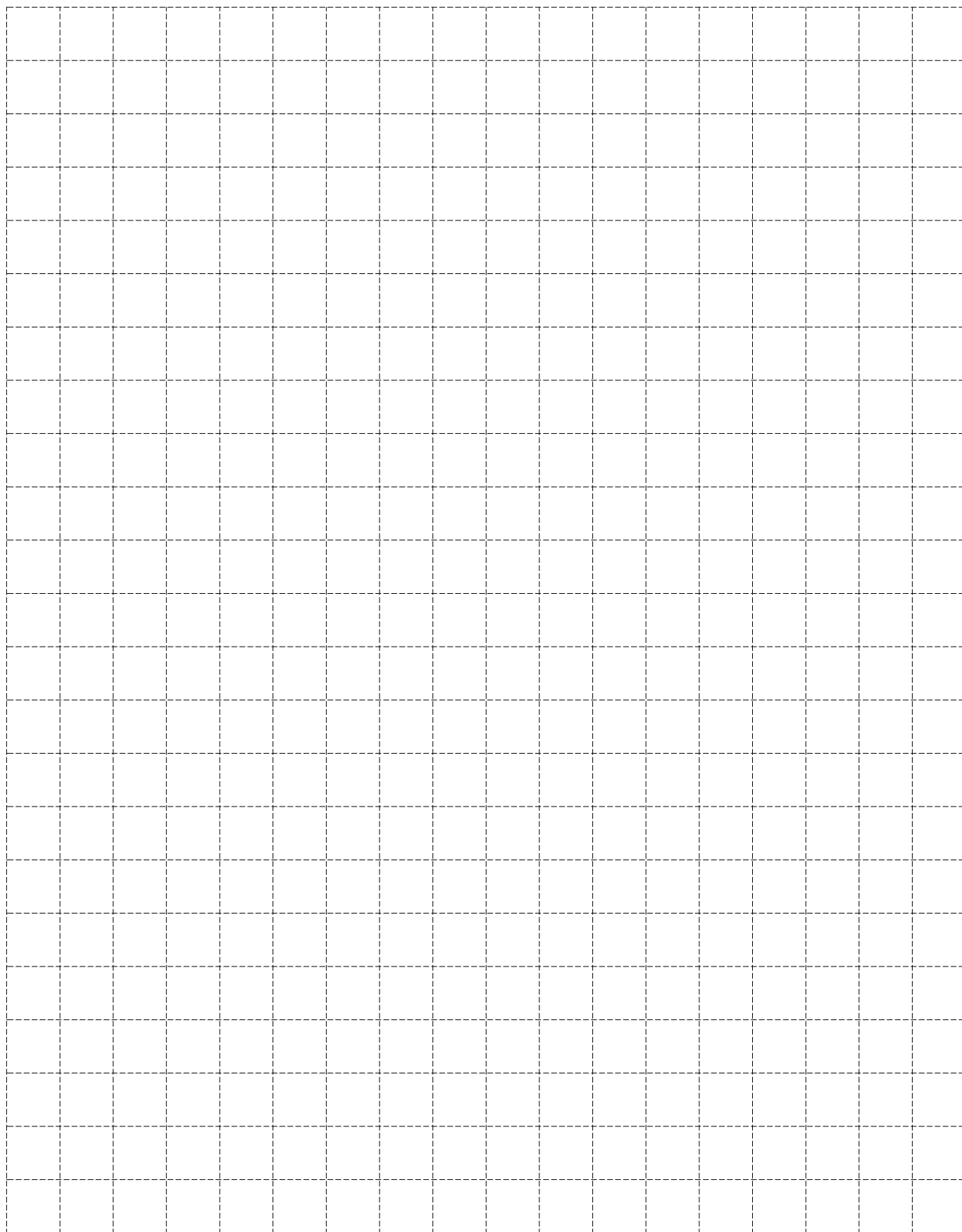
** 1 rinforzo per cerniera AC2648/ACB648/AC2949
1 reinforcement for hinge AC2648/ACB648/AC2949

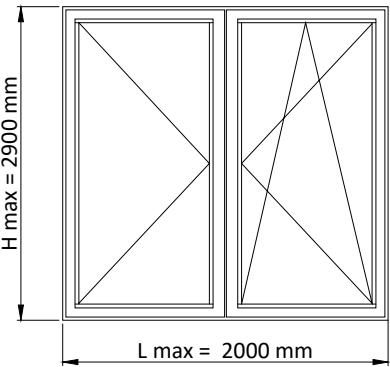




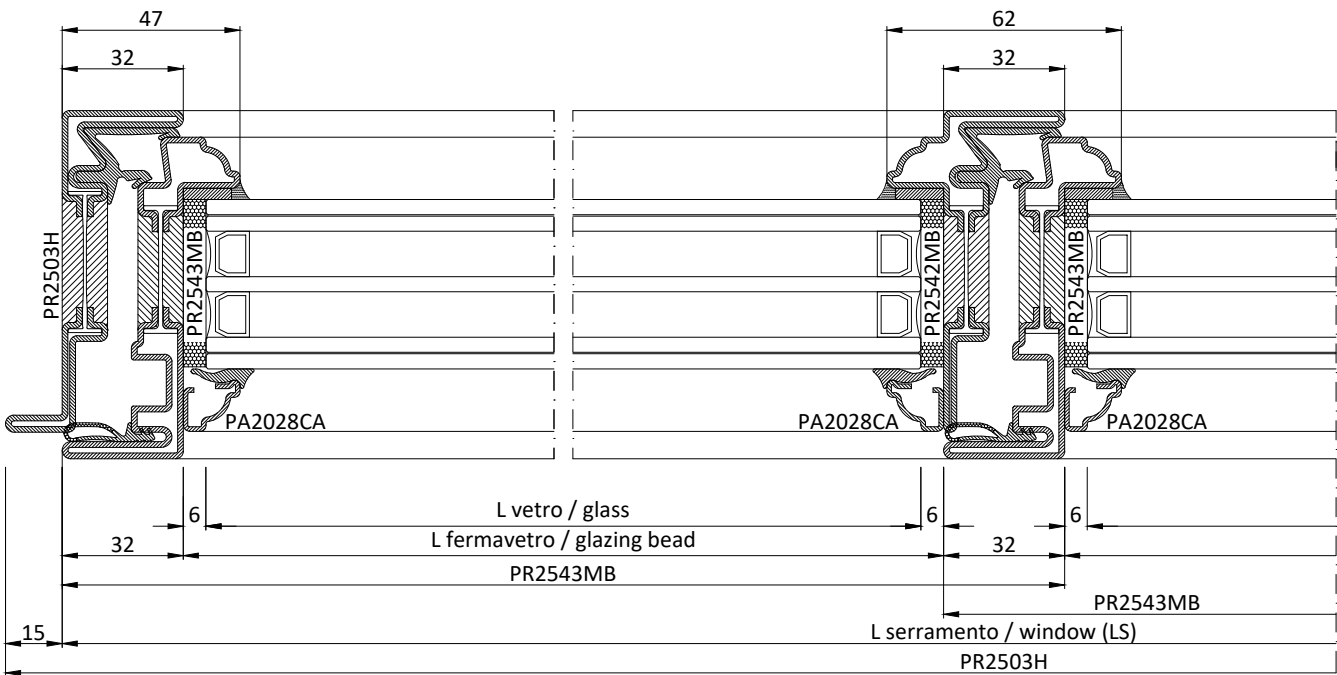
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2503H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2503H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
PR2543MB	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2543MB	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri		Glazing beads				
PR2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2028CA	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°			
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		





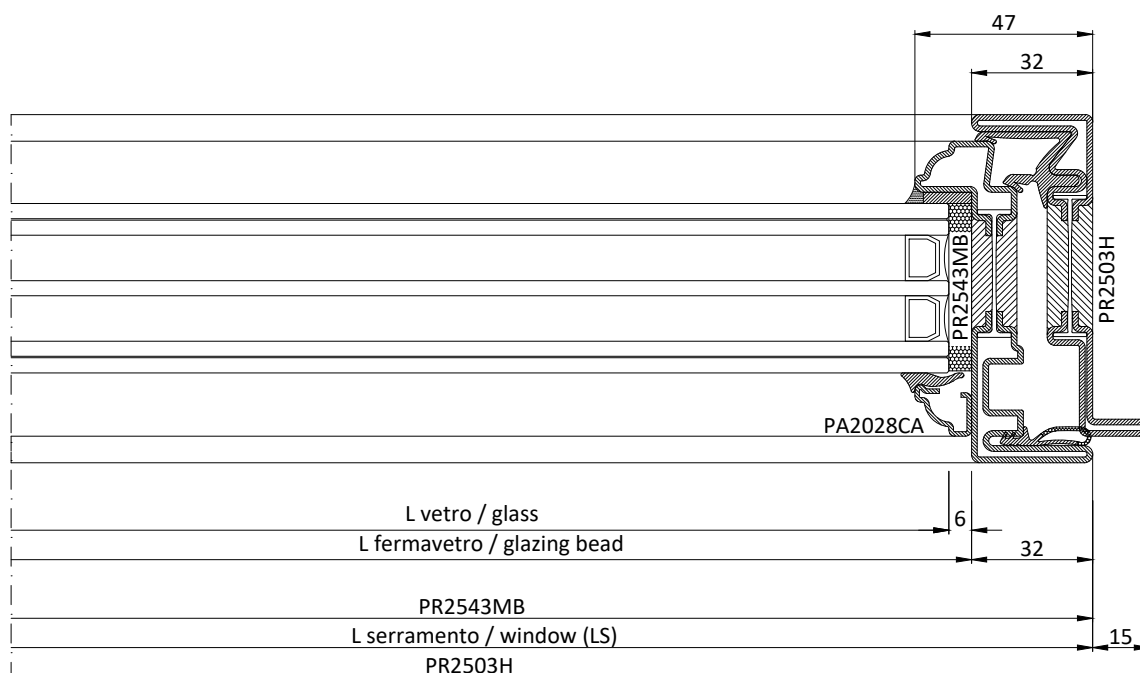
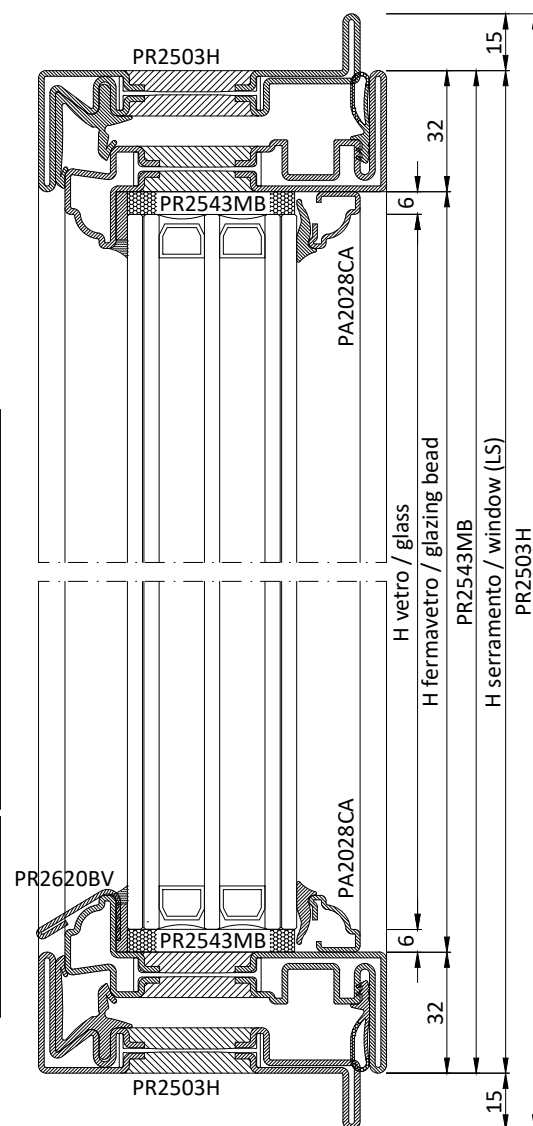


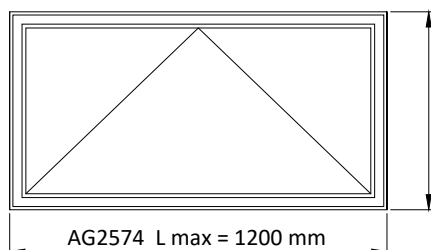
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2503H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2503H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
PR2543MB	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45°	45°
PR2543MB	Profilo a "Z" anta	"Z" profile leaf	3	HS	45°	45°
PR2542MB	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				
PA2028CA	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
PA2028CA	Profilo fermavetro	Glazing bead profile	4	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76		



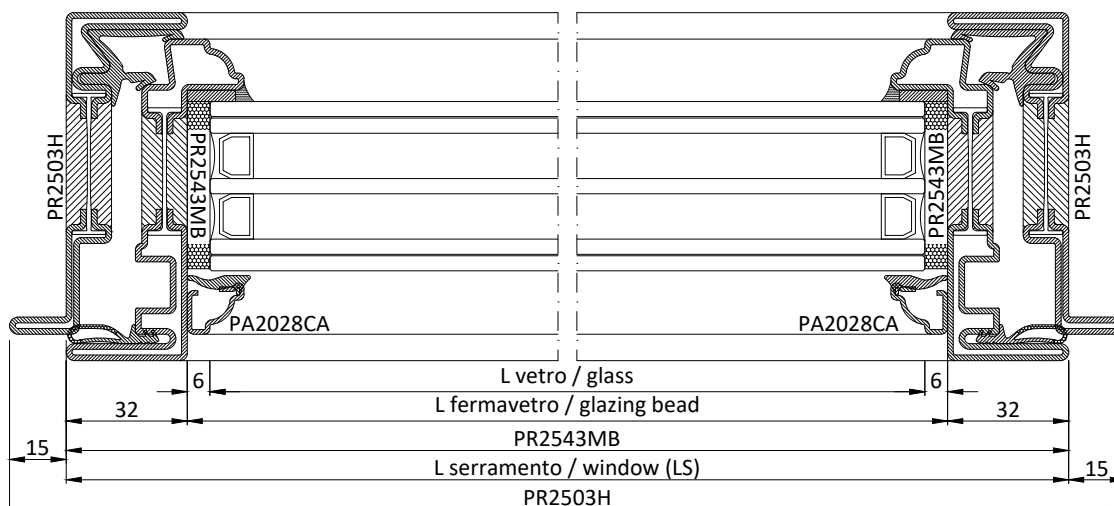
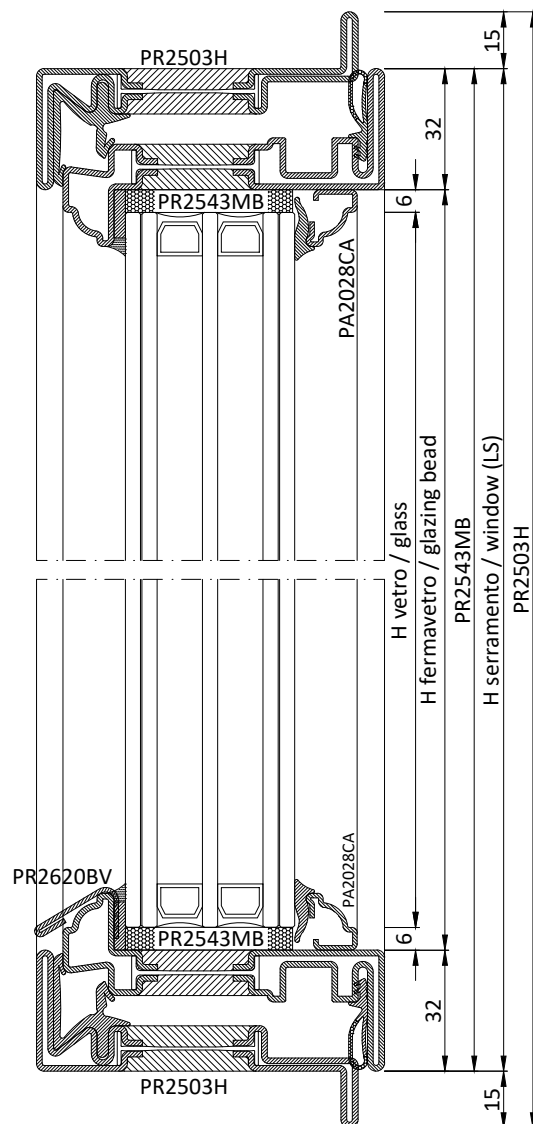
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2514	Kit inversione battuta 2^ anta	2nd leaf reverse closure kit	1
AC2617NG	Guarnizione d'angolo	Vulcanised corner gasket	4
AC2618.xx	Scarico acqua	Water drip	Var.
AGE581/2..	Meccanismo Anta Ribalta	Tilt and Turn mechanism	1
AGE585/6..	Meccanismo 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.

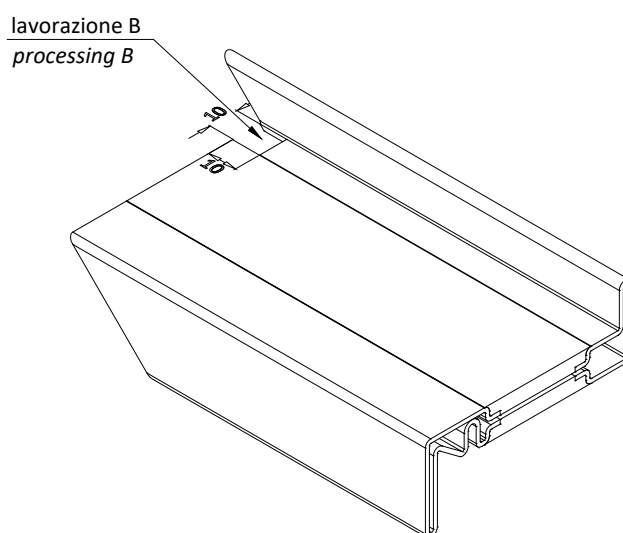
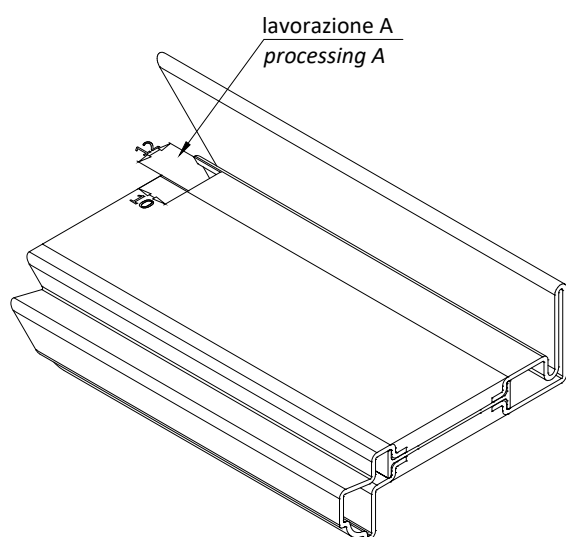
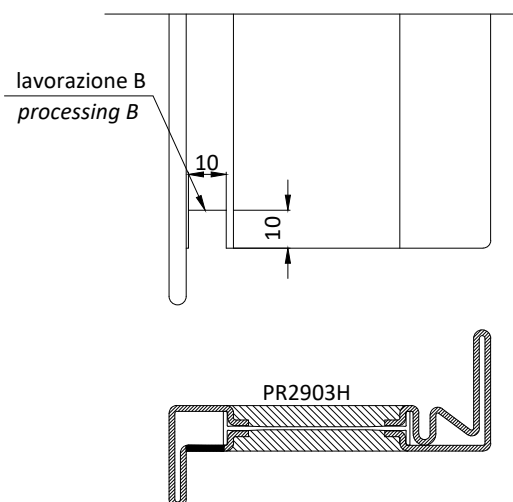
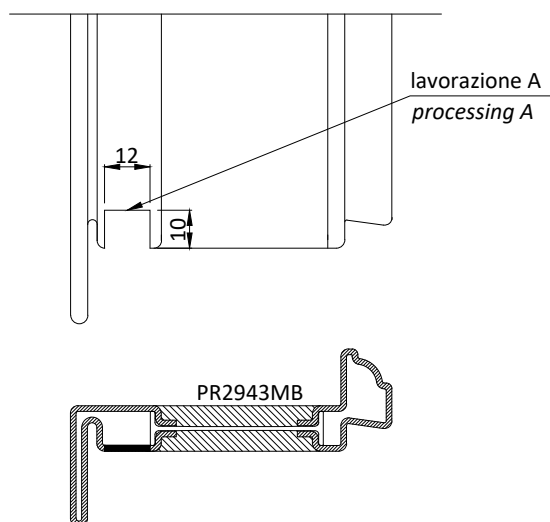
GUARNIZIONI		JOINTS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+3xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1	2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS



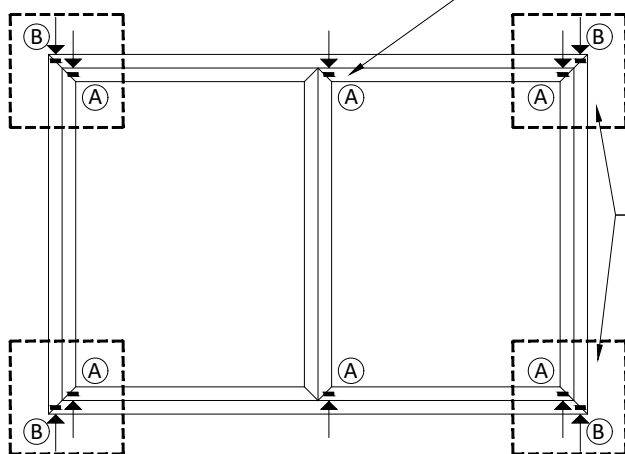


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
PR2503H	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
PR2503H	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta			Leaf			
PR2543MB	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
PR2543MB	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
PR2620BV	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri			Glazing beads			
PA2028CA	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PA2028CA	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°			
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		

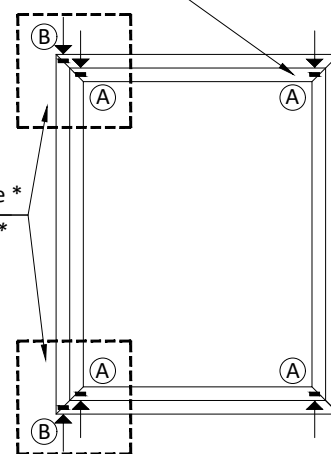




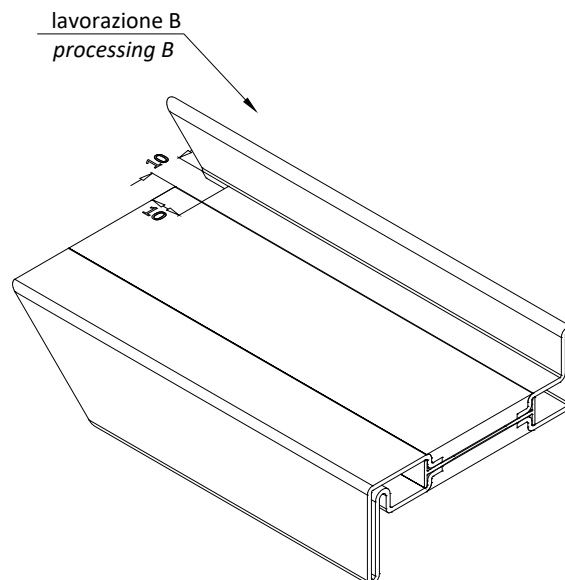
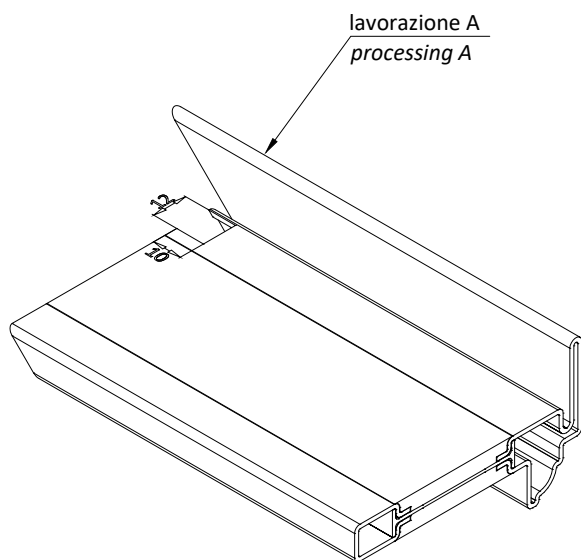
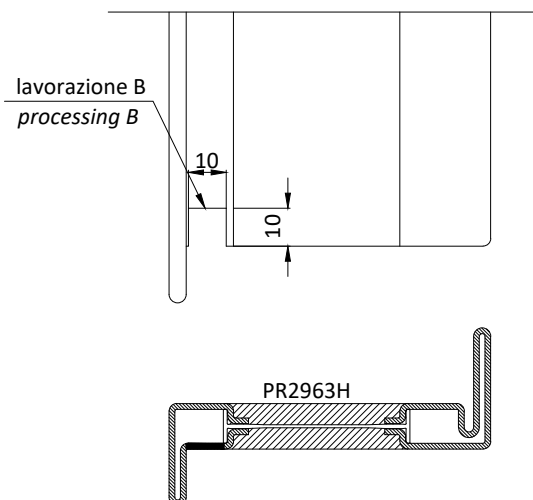
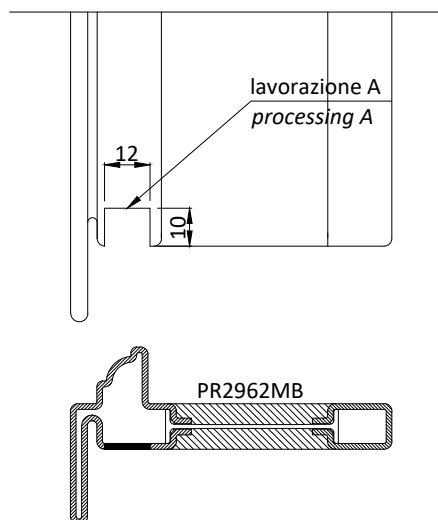
lavorazione per inserimento aste cremonese
processing for inserting cremone bolt rod



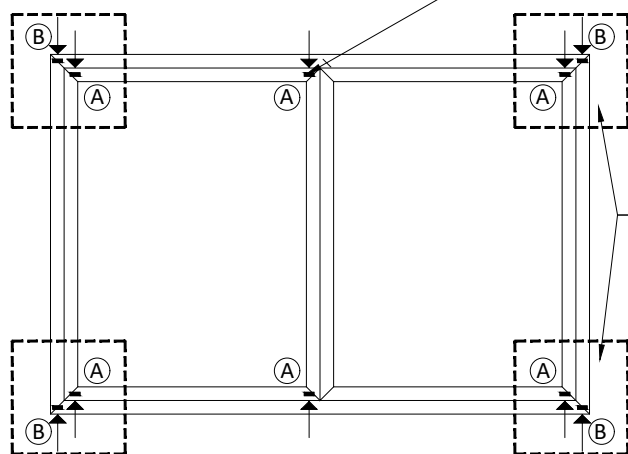
lavorazione per inserimento rinforzo cerniere *
processing for inserting hinge strengtheners *



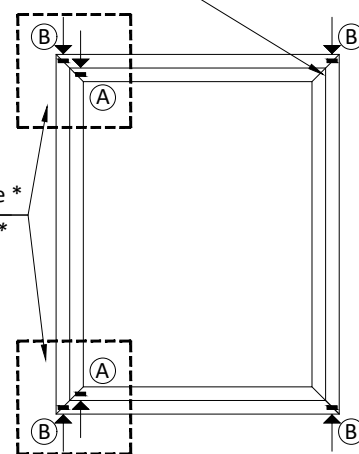
* Lavorazione per rinforzo cerniere necessaria per profili in ottone e acciaio inox
* Working for hinges reinforcement is necessary on brass and stainless steel profiles



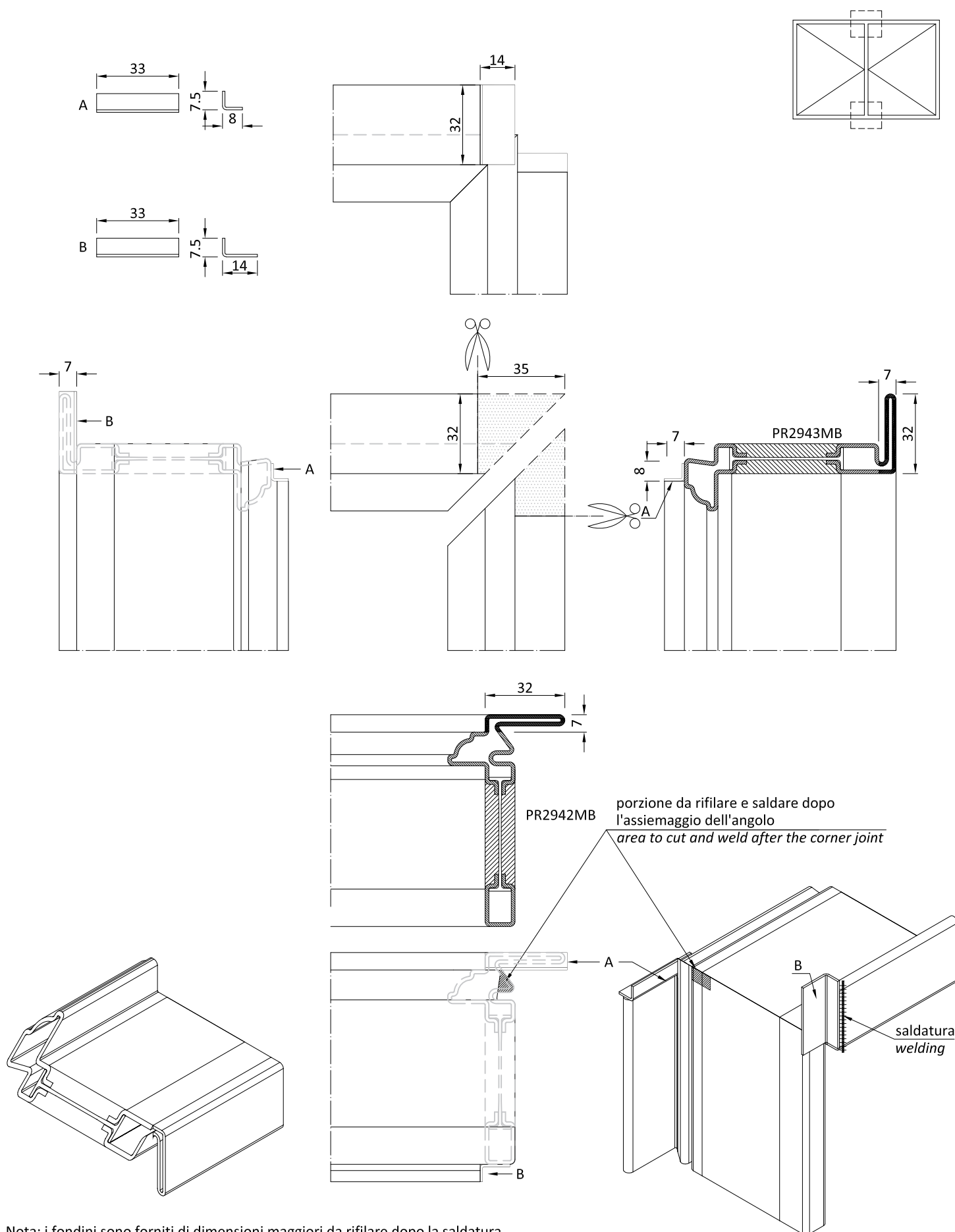
lavorazione per inserimento aste cremone
processing for inserting cremone bolt rod

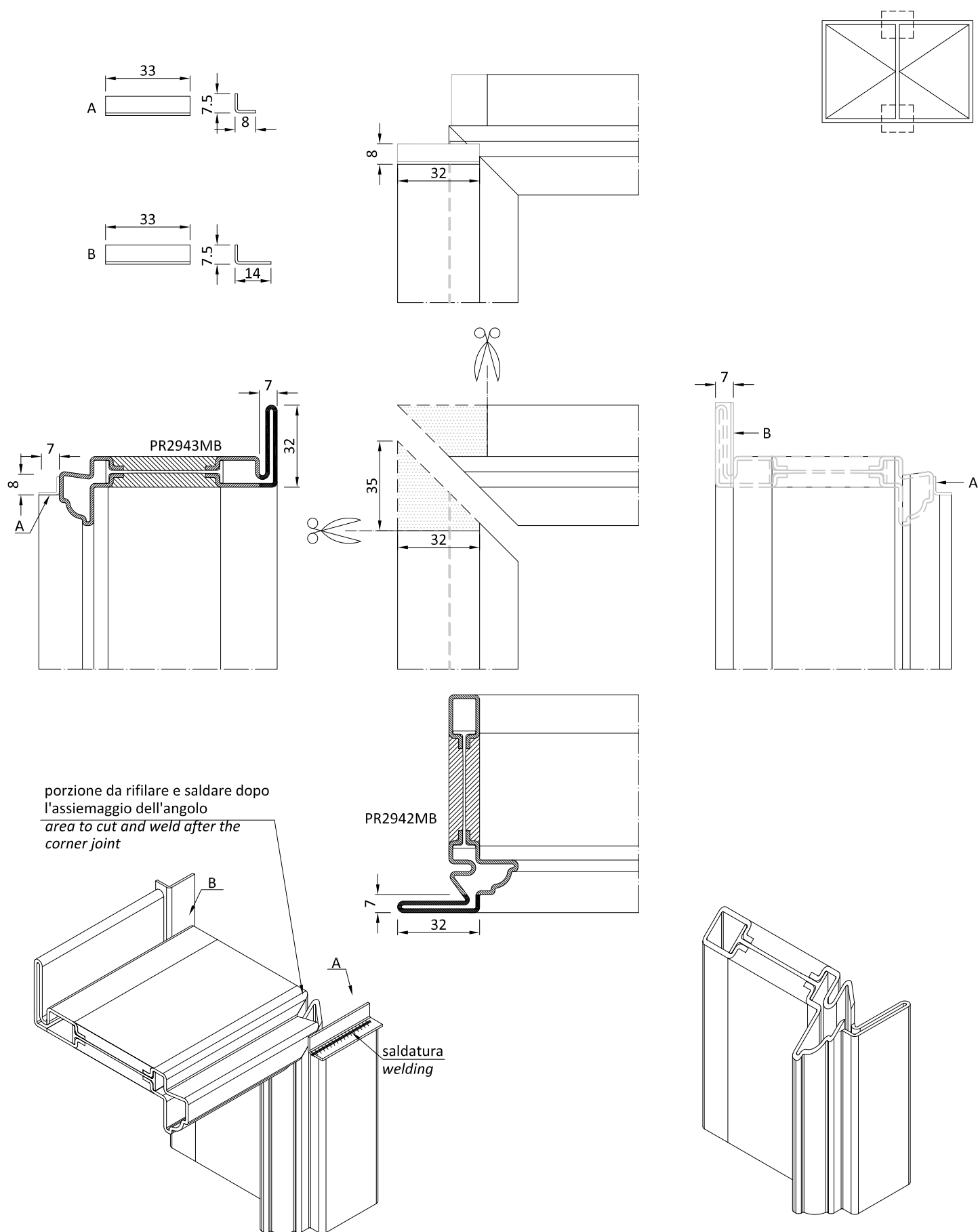


lavorazione per inserimento rinforzo cerniere *
processing for inserting hinge strengtheners *

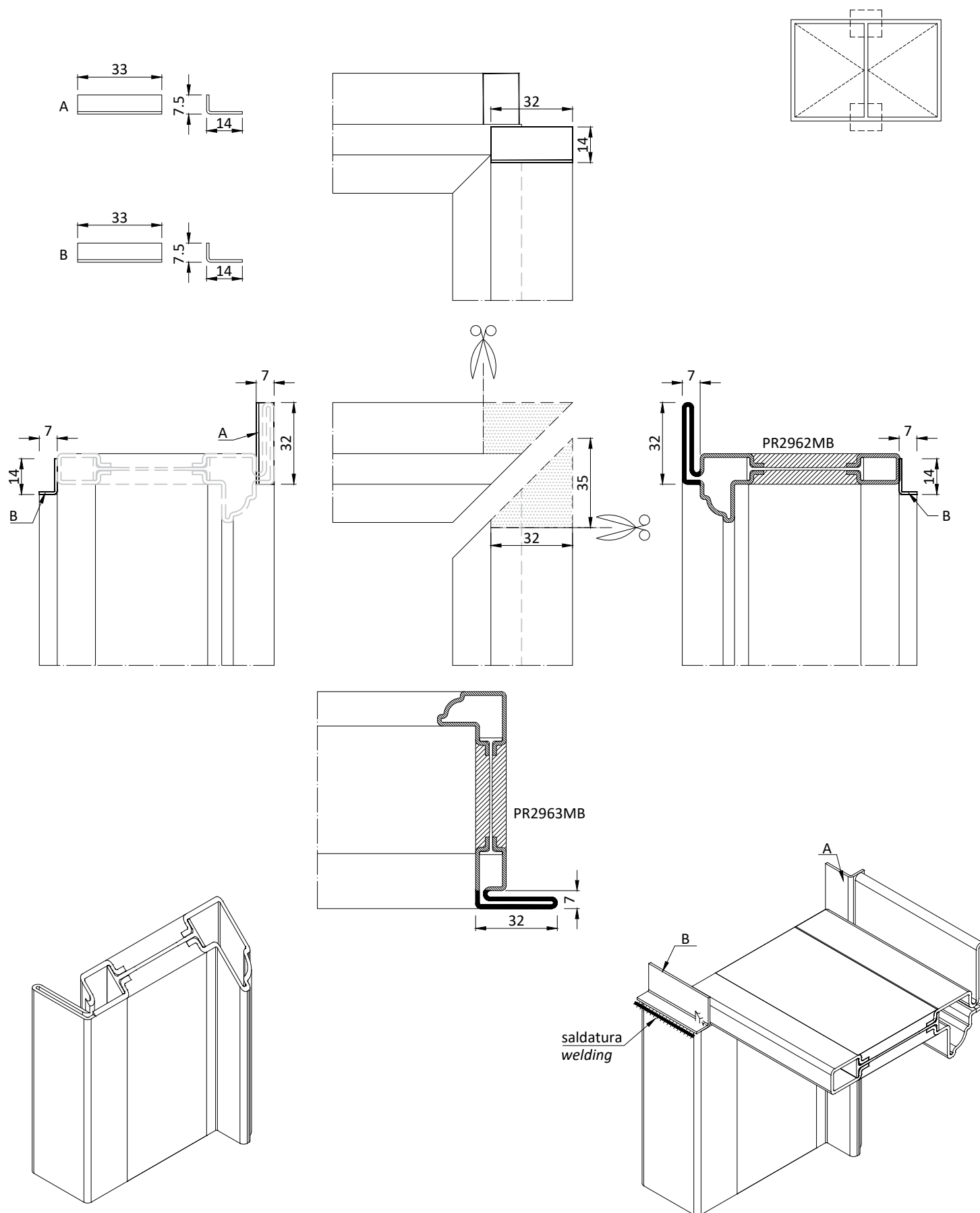


* Lavorazione per rinforzo cerniere necessaria per profili in ottone e acciaio inox
* Working for hinges reinforcement is necessary on brass and stainless steel profiles

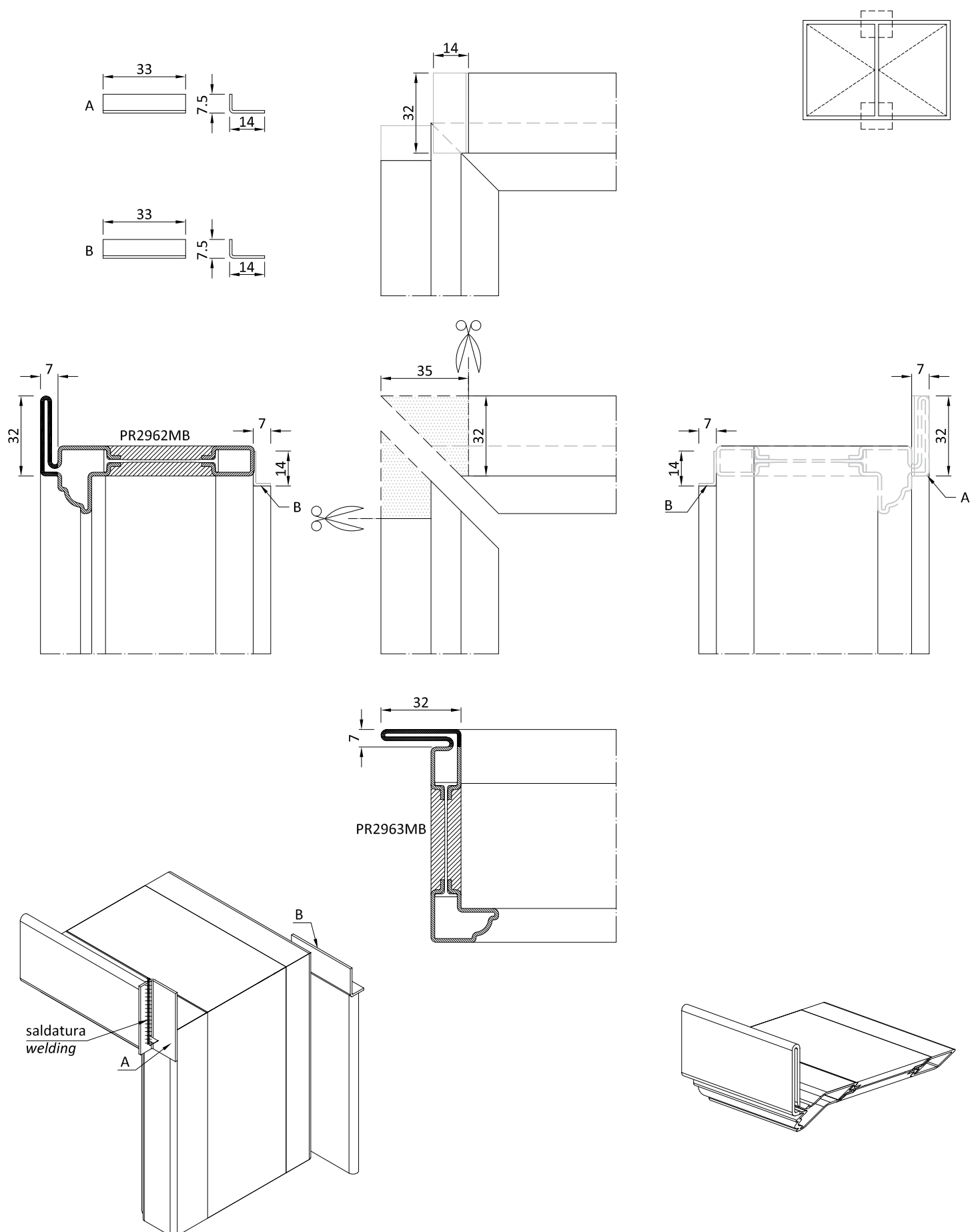




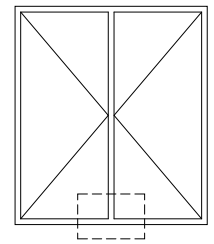
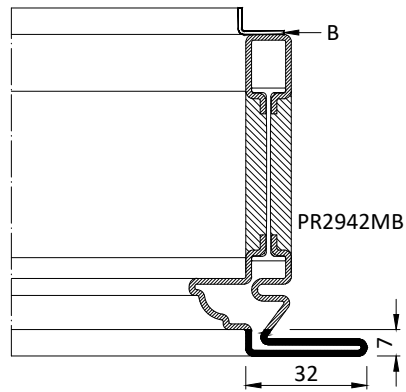
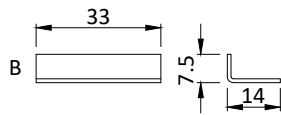
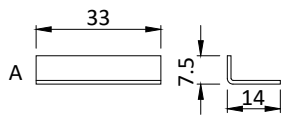
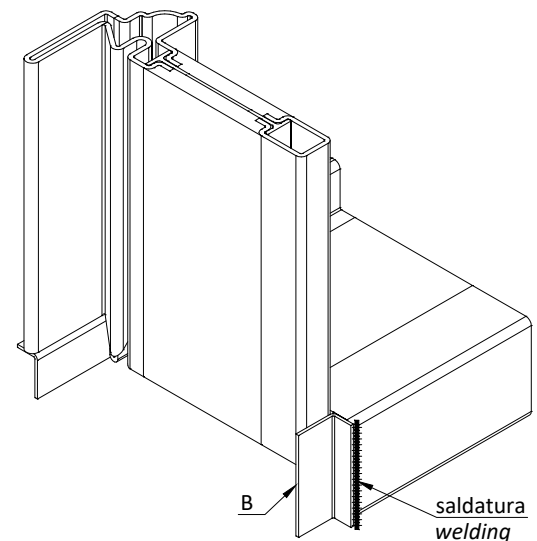
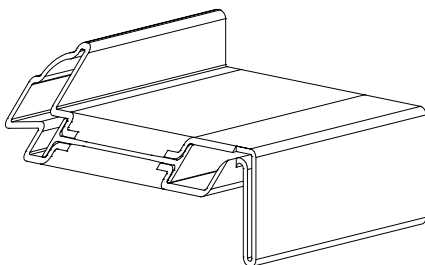
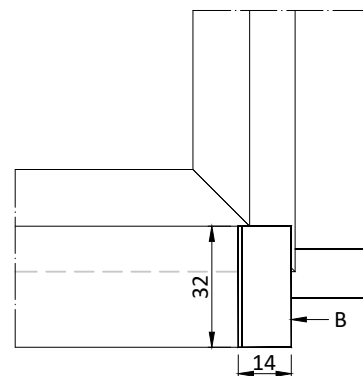
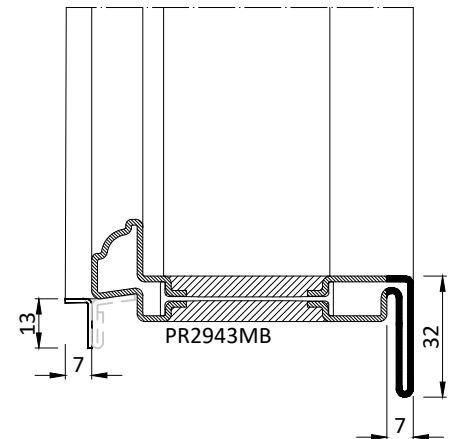
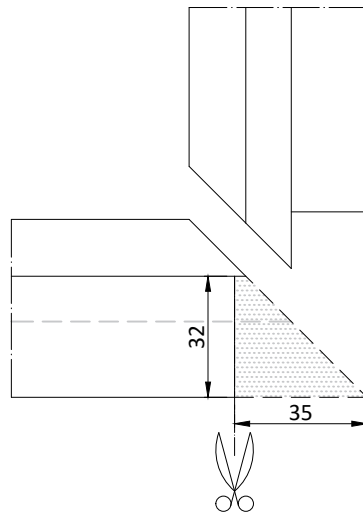
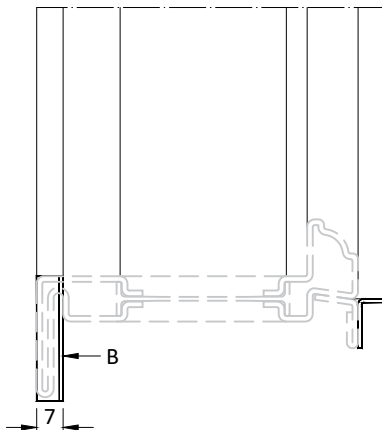
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



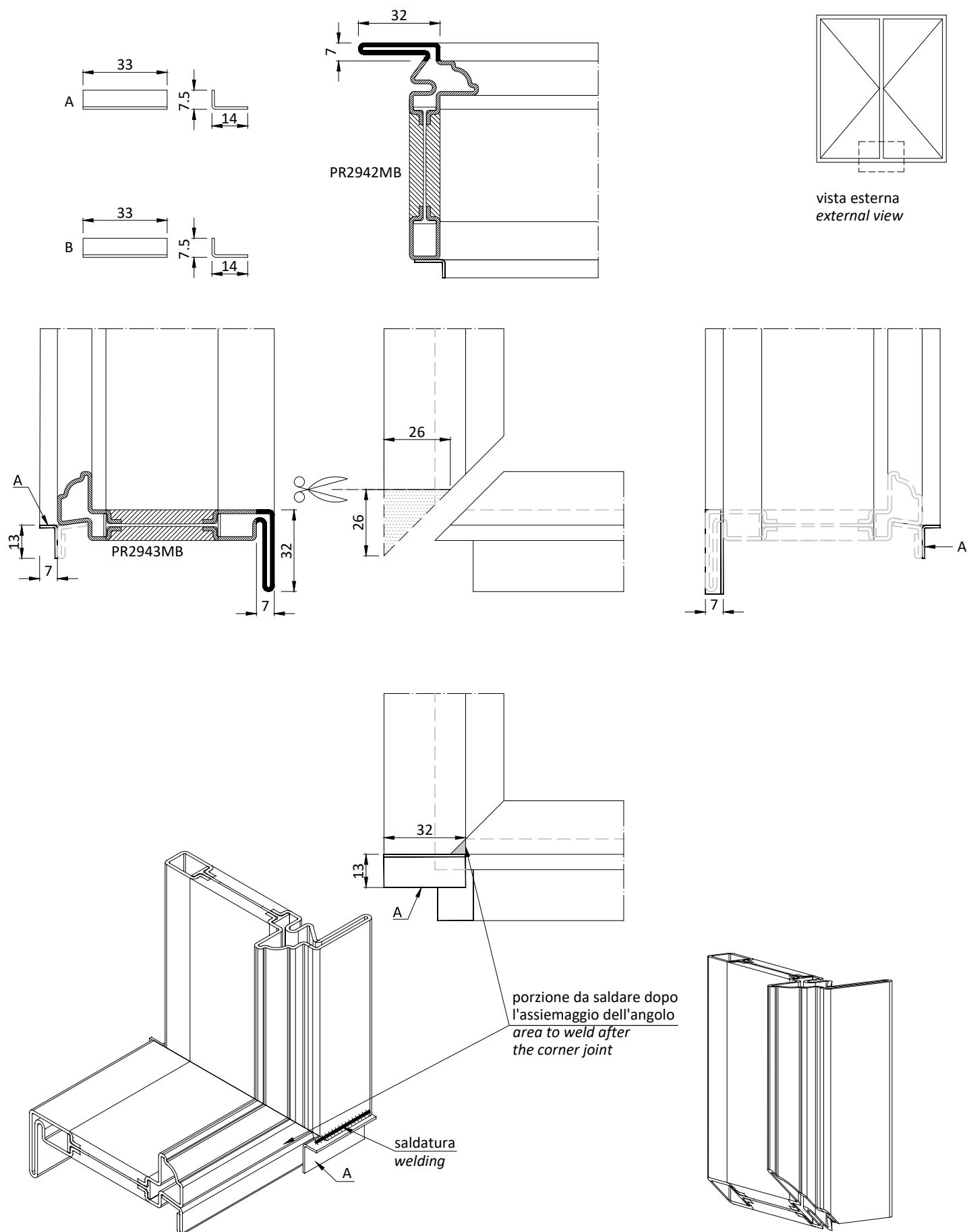
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



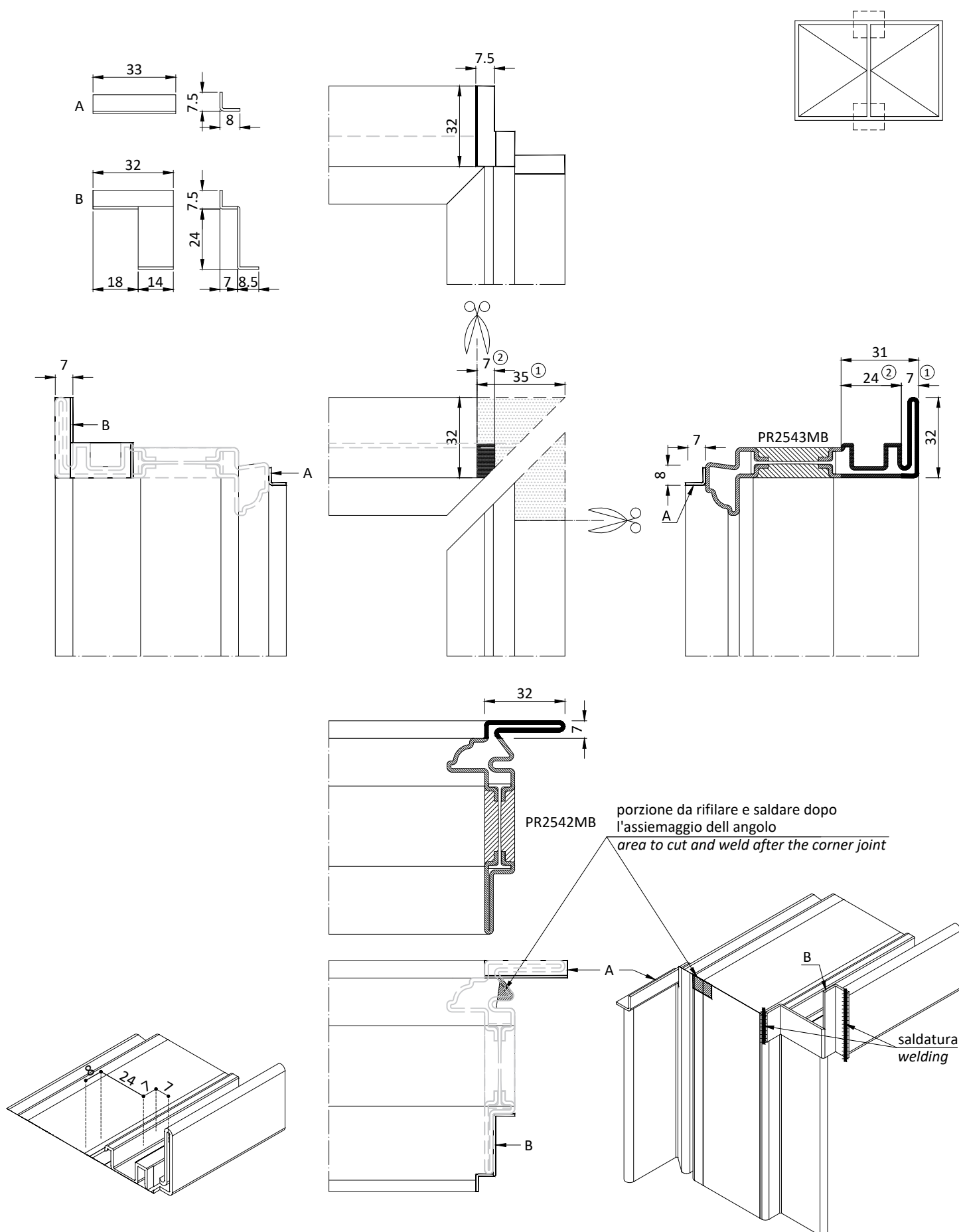
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding

vista interna
internal view

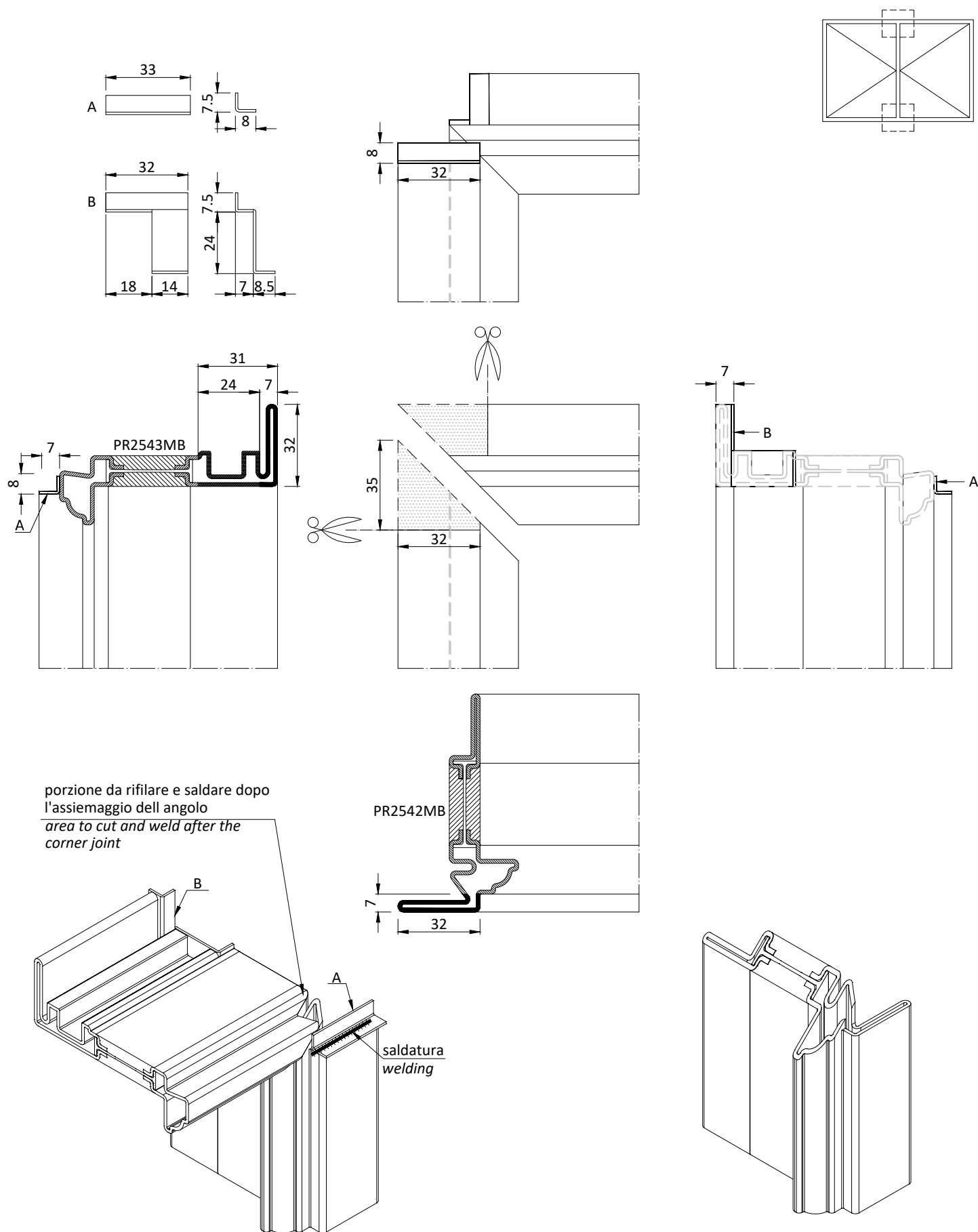
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



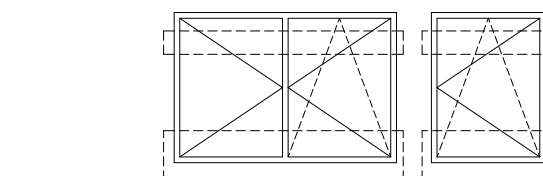
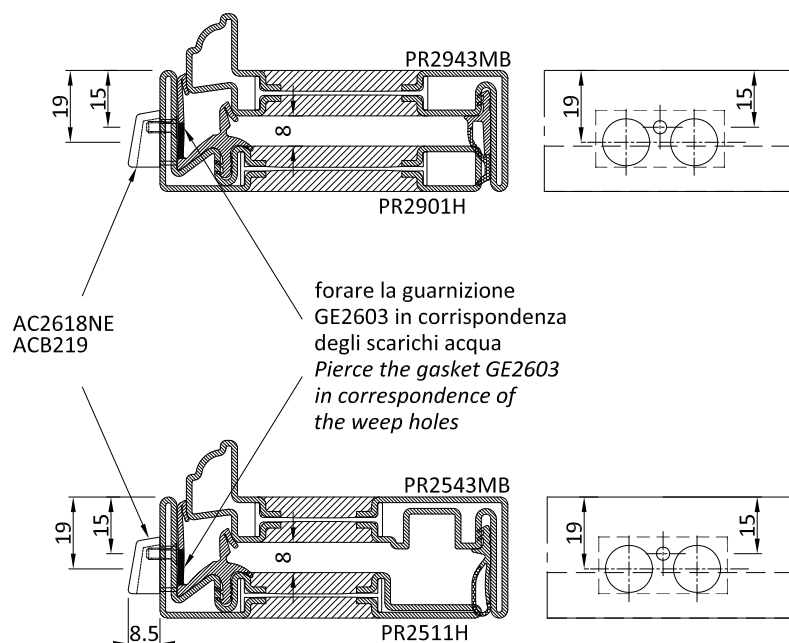
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



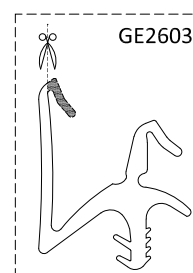
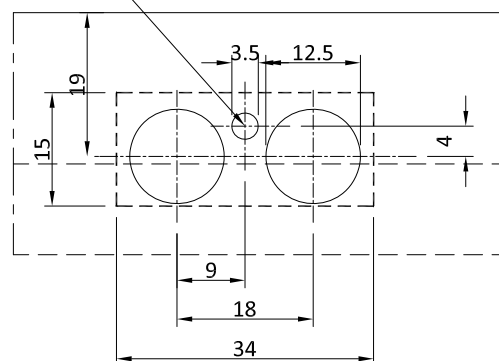
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



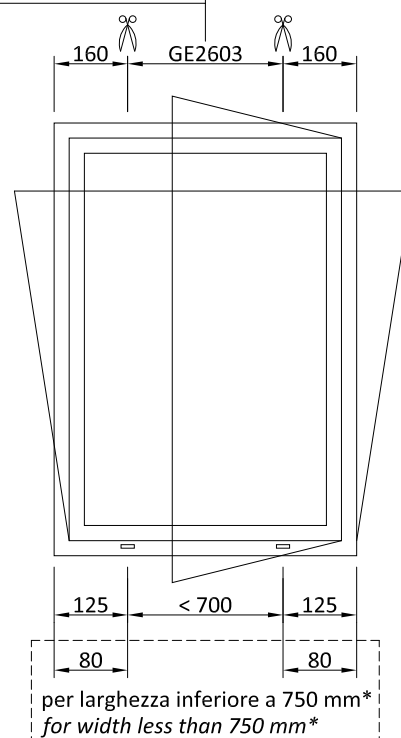
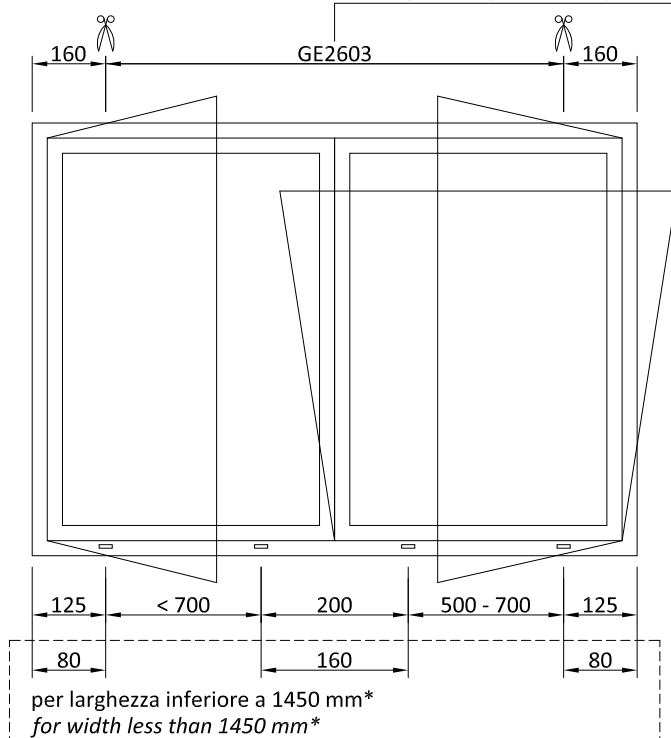
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



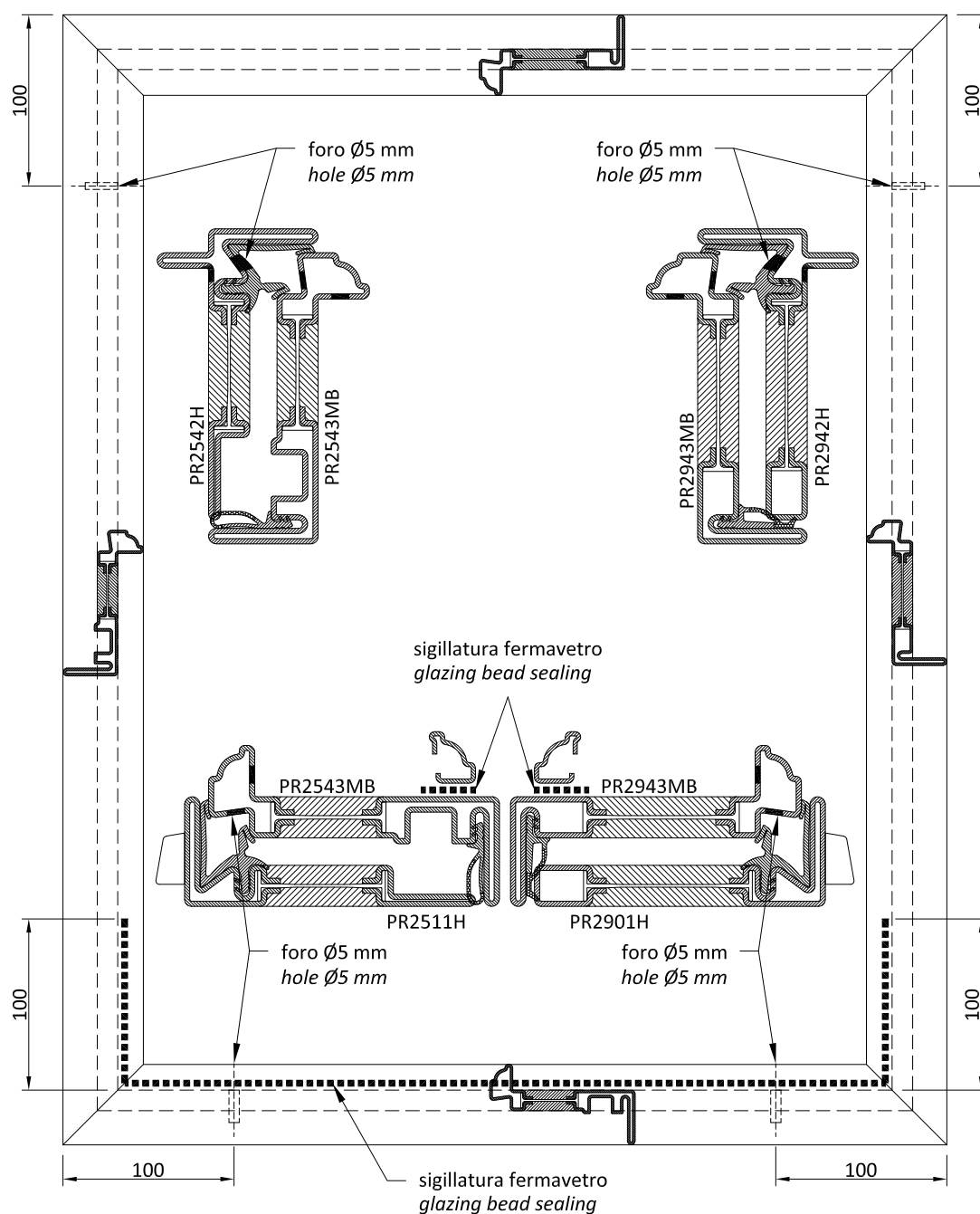
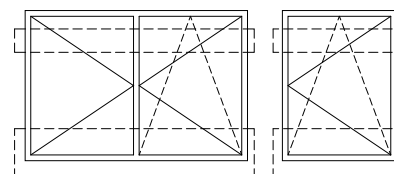
svasato
countersunk

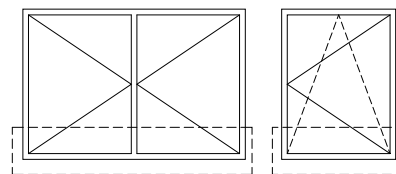
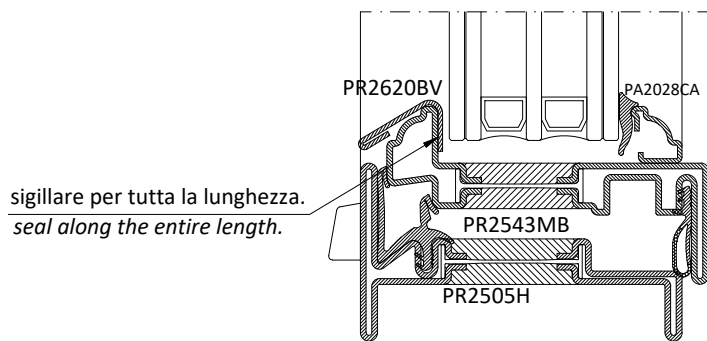


Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm



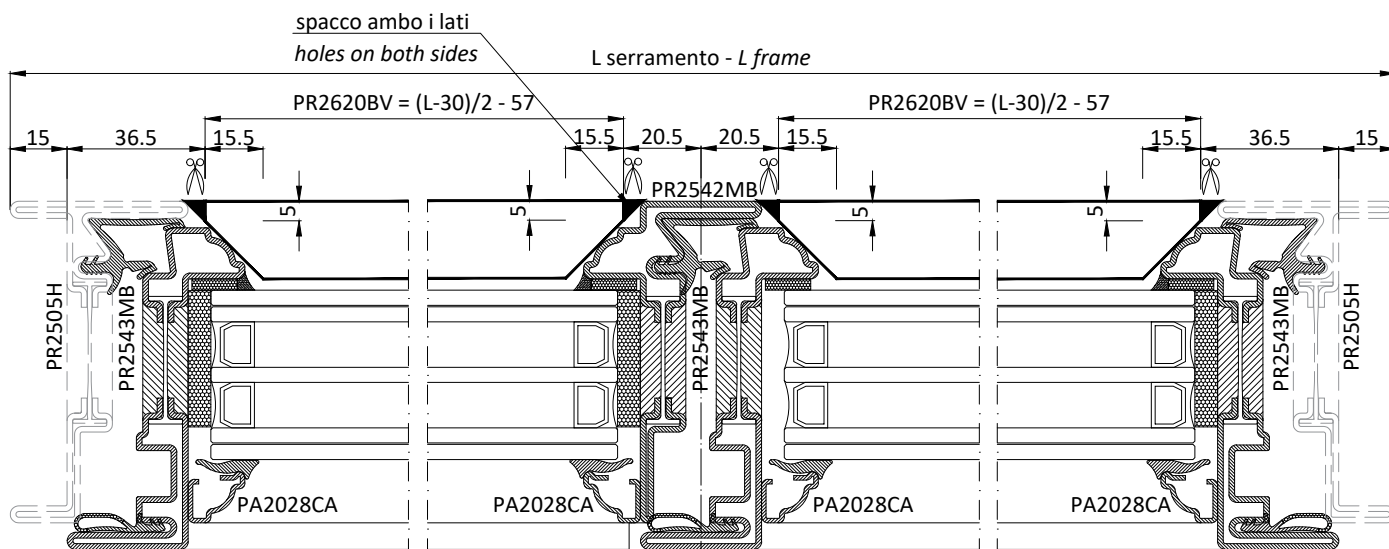
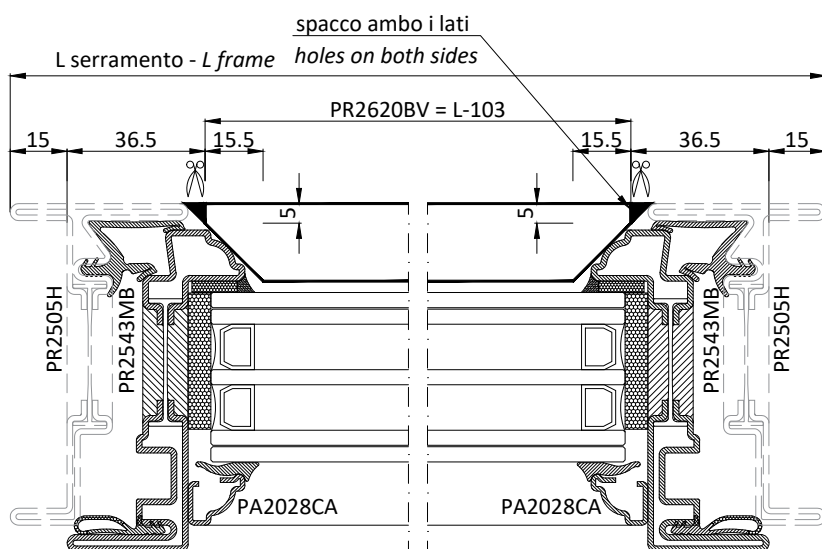
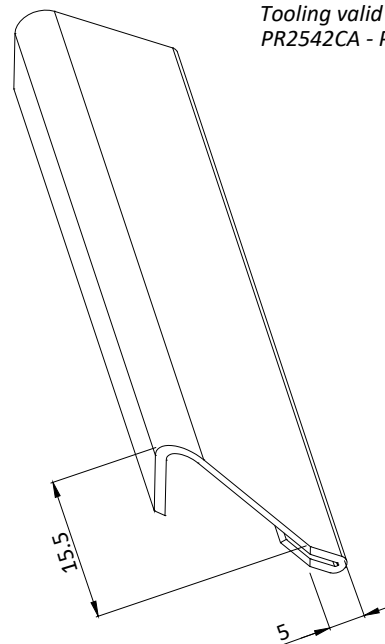
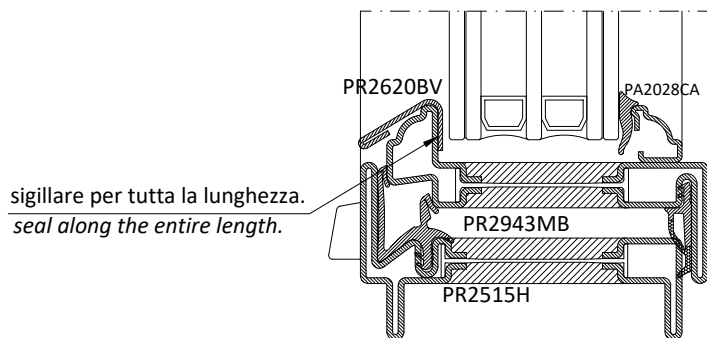
* tagliare l'angolo vulcanizzato AC2617NG per 30 mm
* cut the vulcanised corner gasket AC2617NG to 30 mm

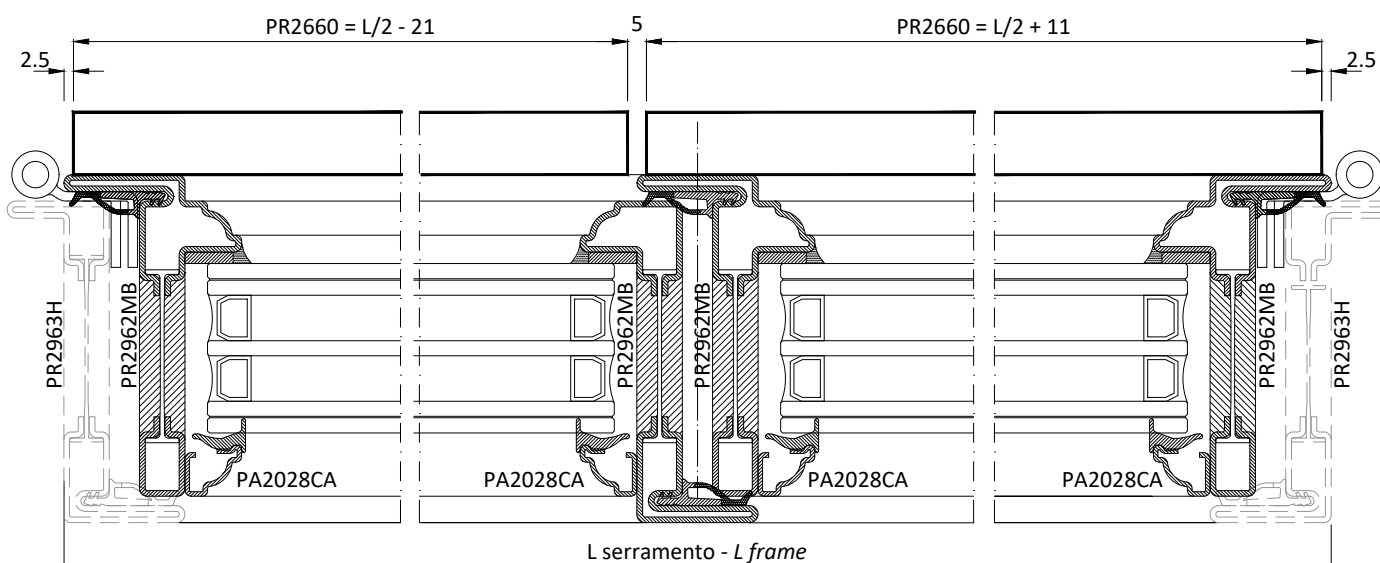
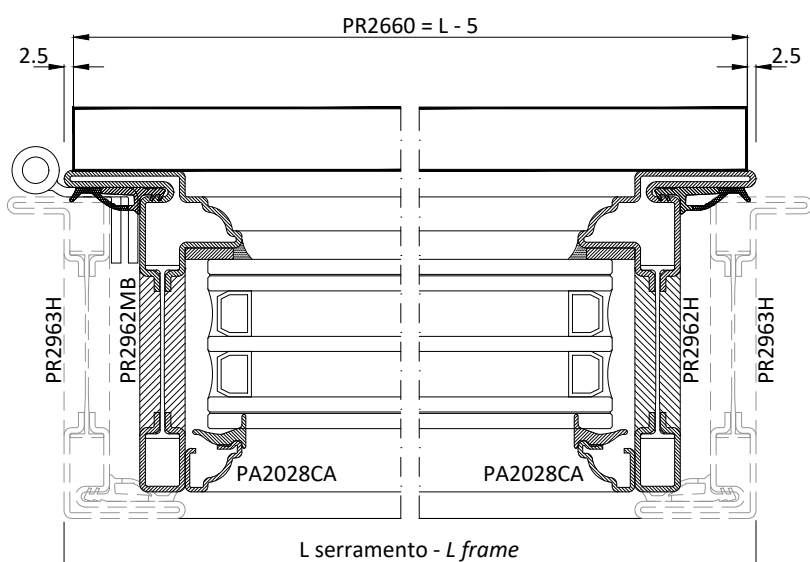
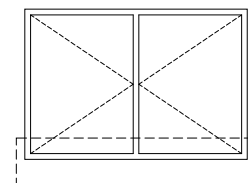
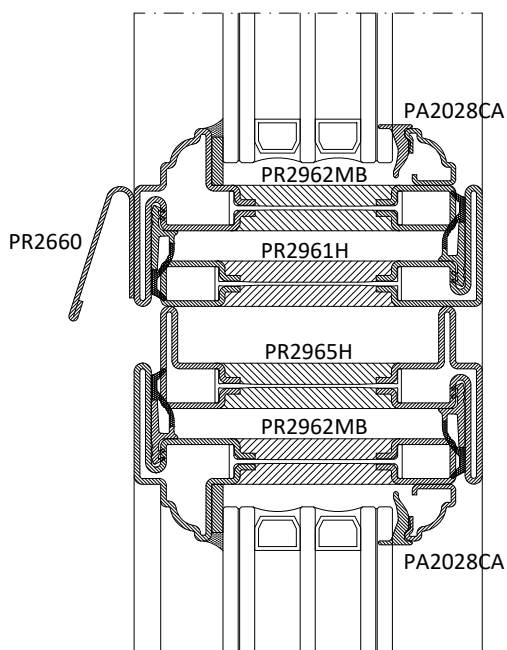


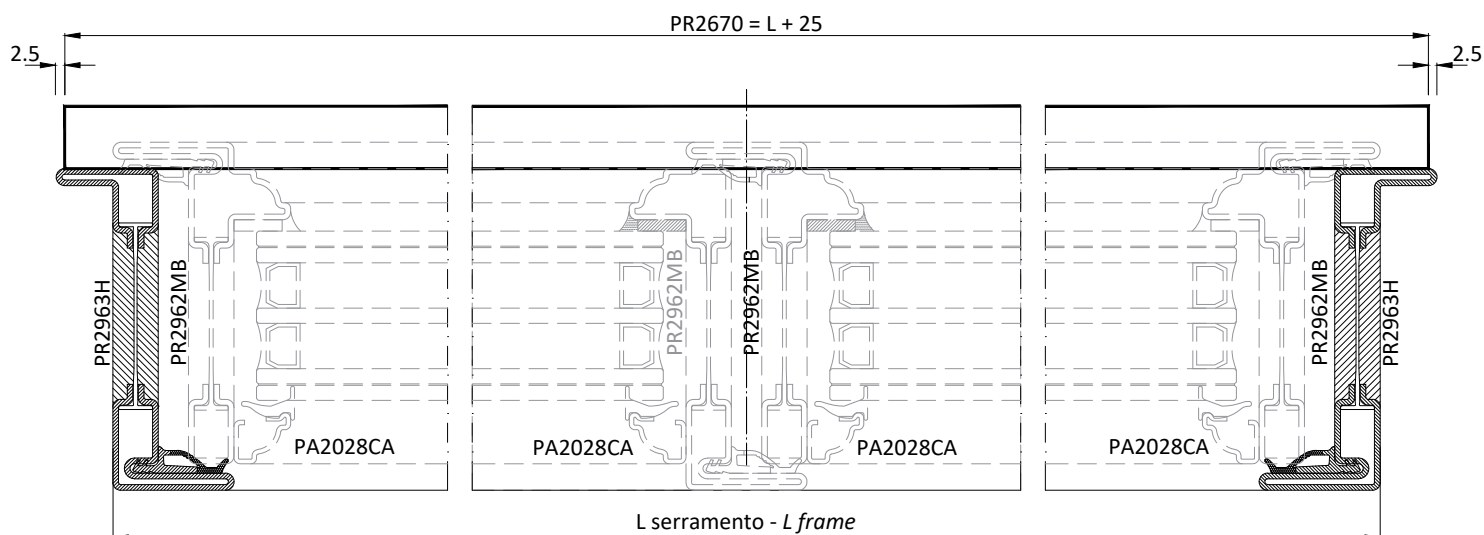
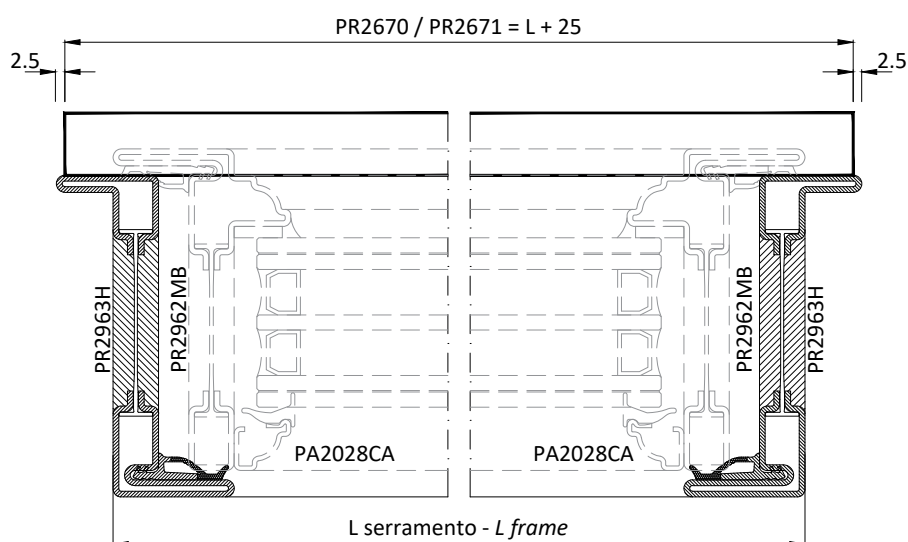
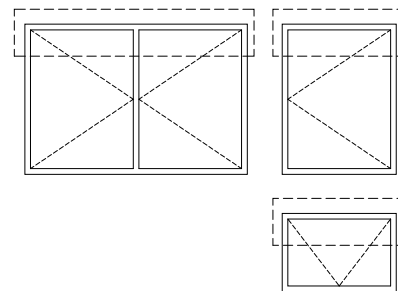
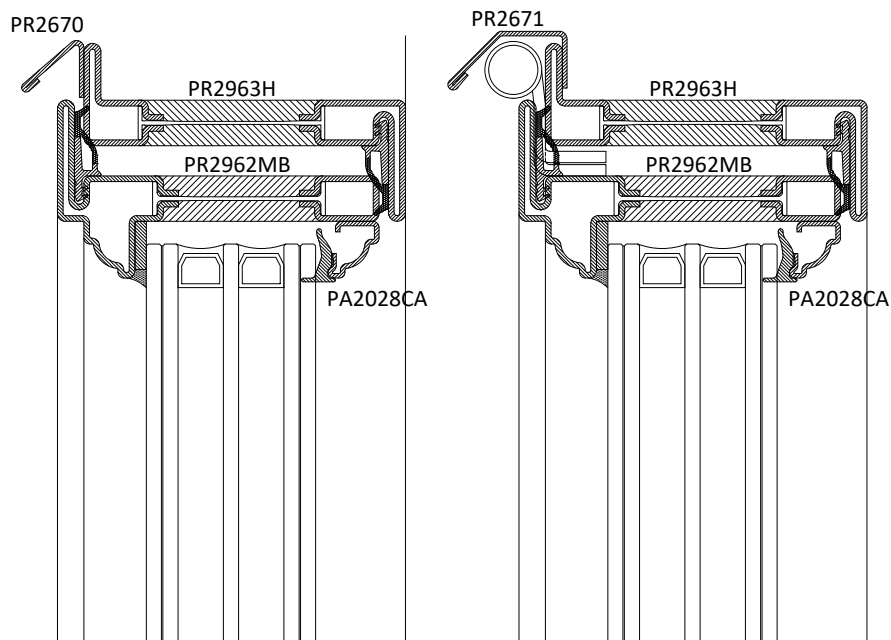


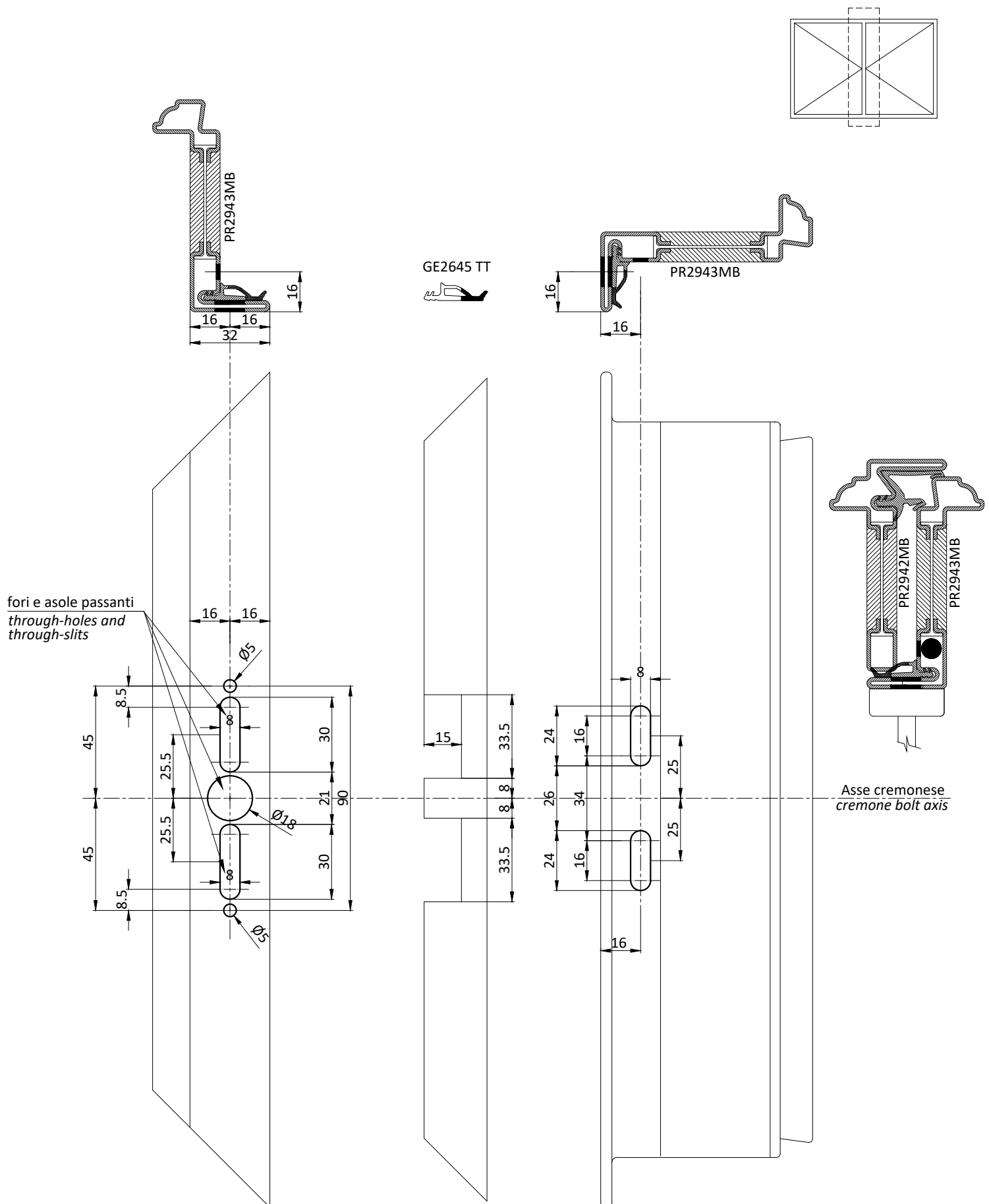
Lavorazione valida per
profili
PR2542CA-PR2543CA

Tooling valid for profiles
PR2542CA - PR2543CA

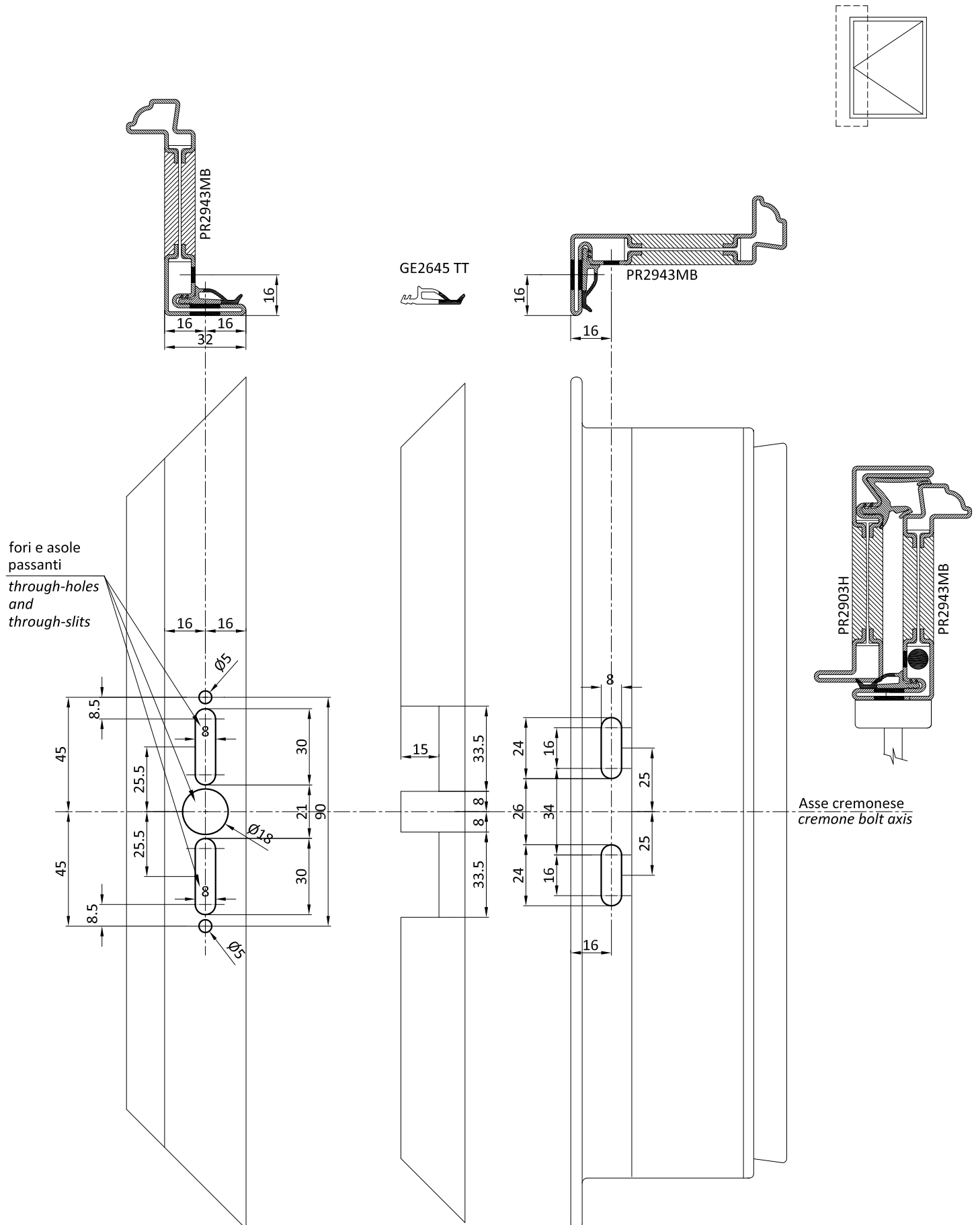


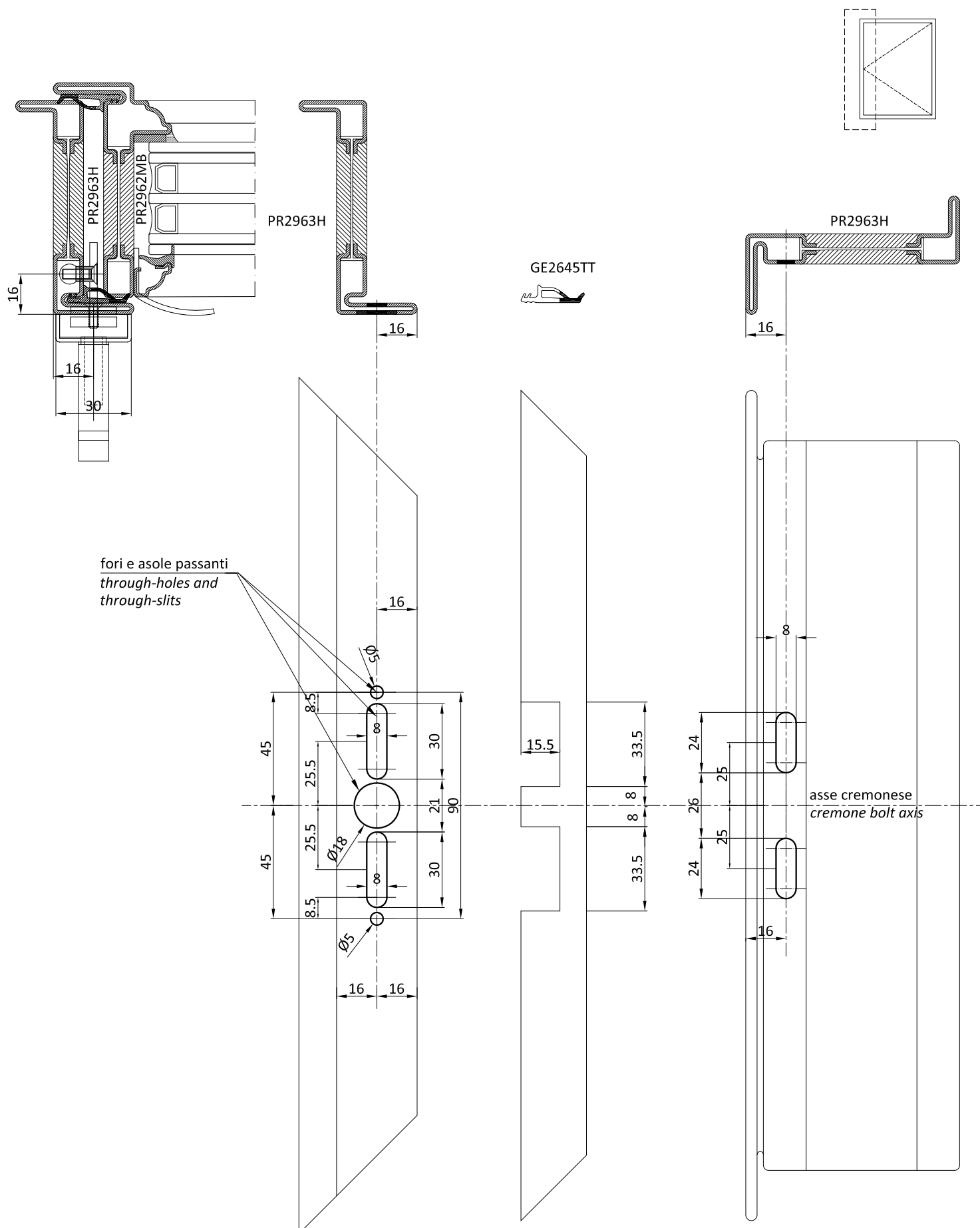






Per l'applicazione del cremone AC2624.D-S - AC2624SG.D-S, utilizzare maschera AT2825
For the installation of AC2624.D-S - AC2624SG.D-S cremone bolt, please use the jig AT2825

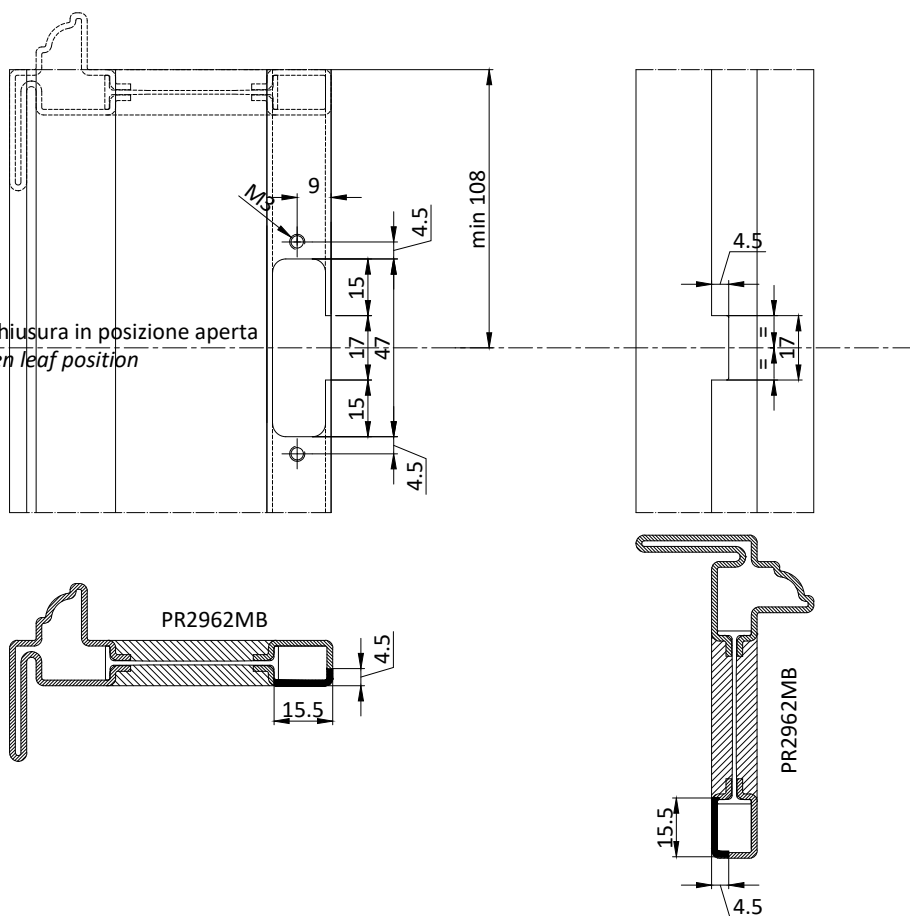




Per l'applicazione del cremonese AC2683.D-S, utilizzare maschera AT2825
For the installation of AC2683.D-S cremona bolt, please use the jig AT2825

lavorazione applicazione incontro
Processing for strike plate installation

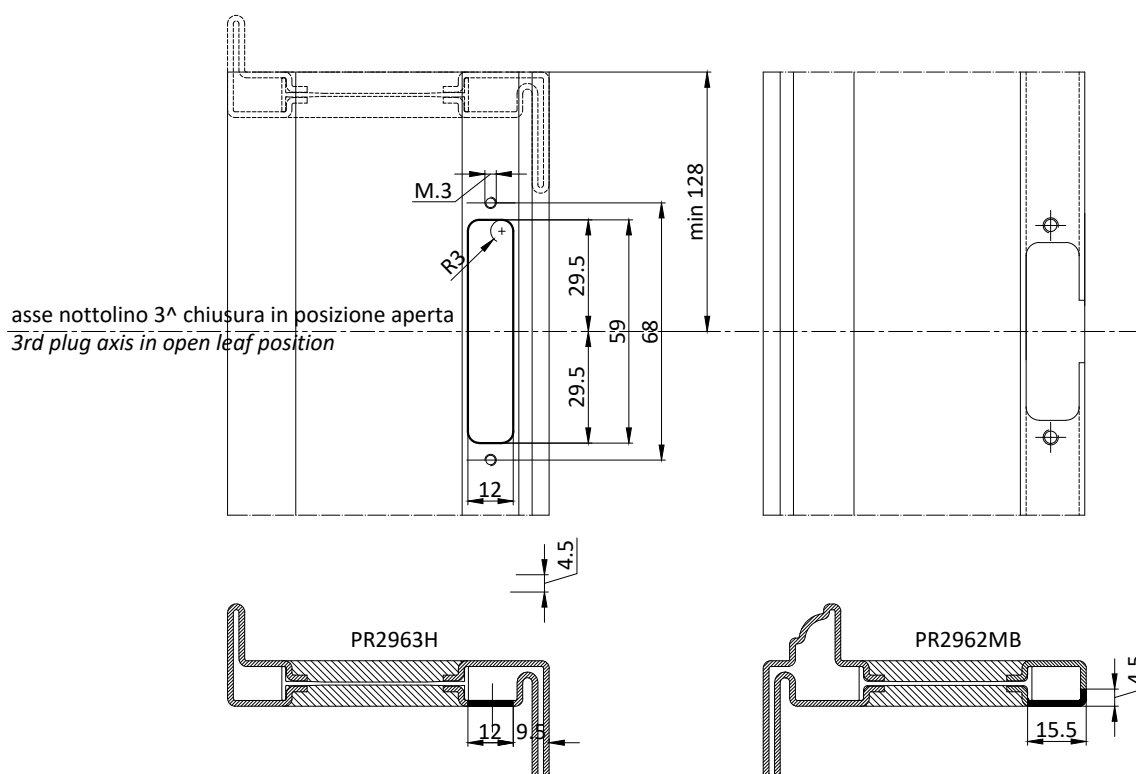
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position

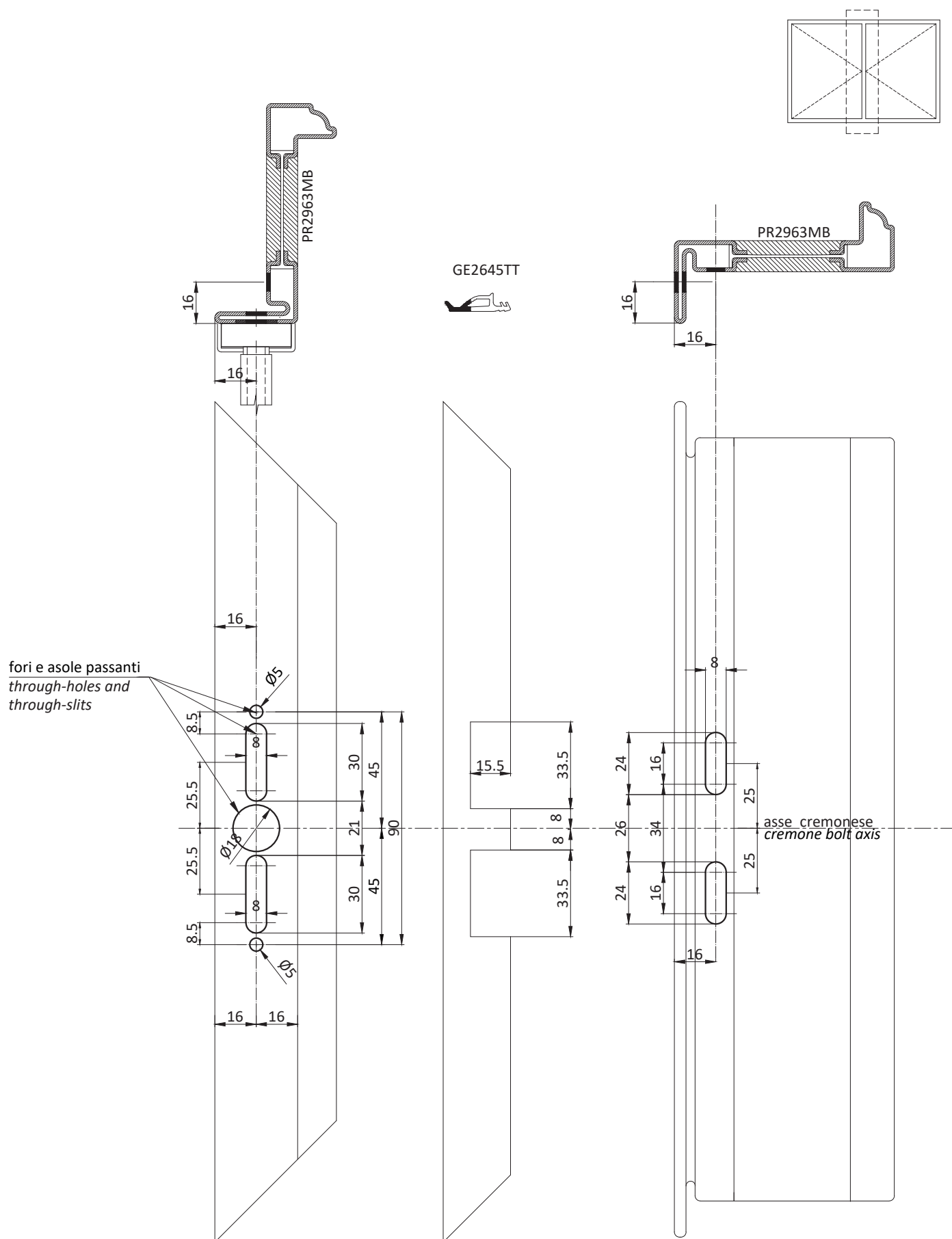


Incontro 3^a chiusura
3rd lock strike plate

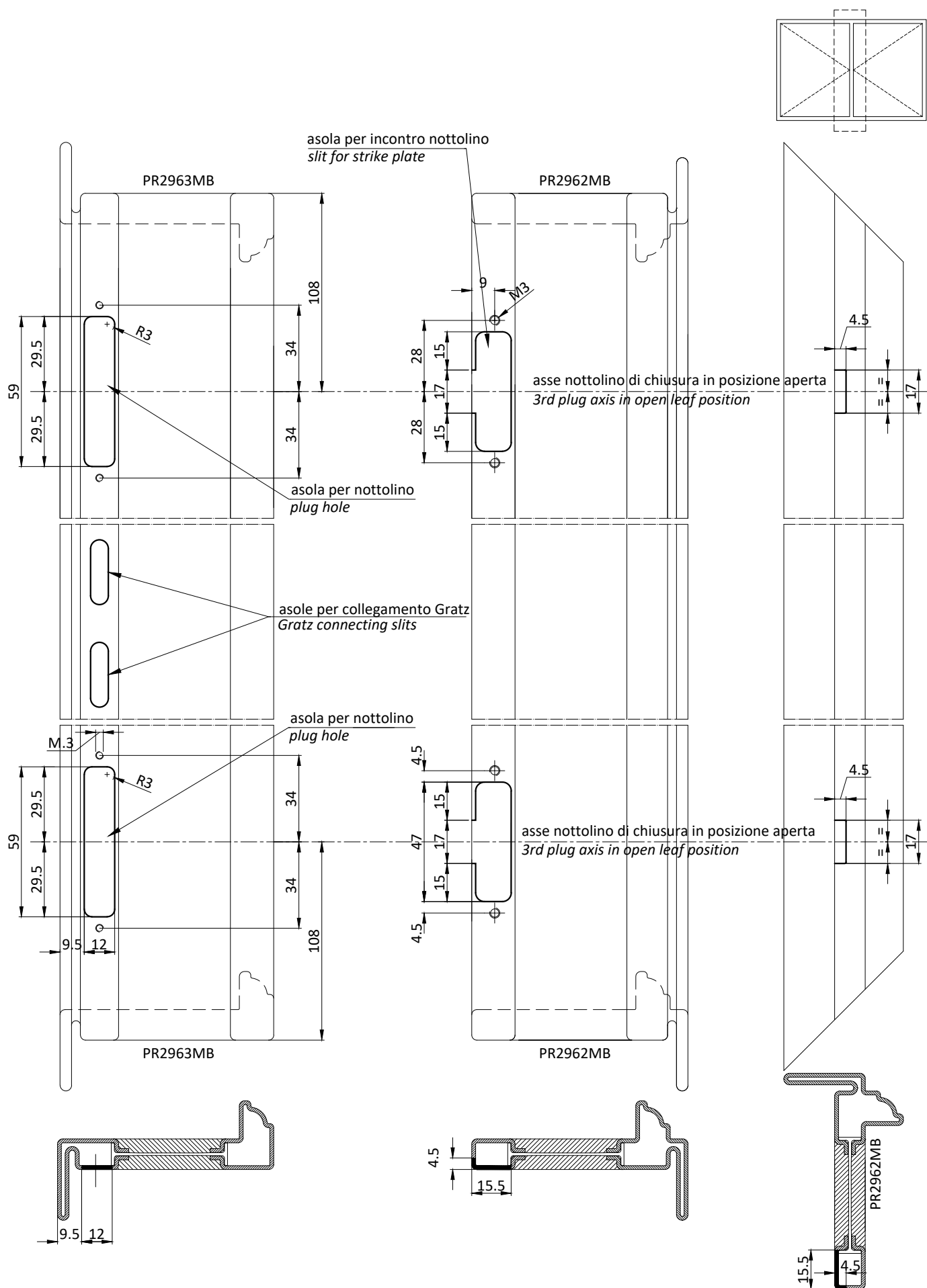
lavorazione applicazione nottolino
Processing for plug installation

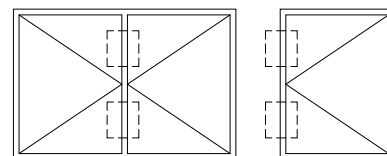
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position





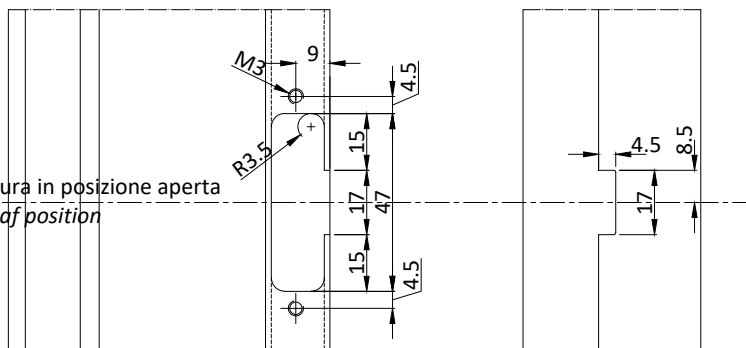
Per l'applicazione del cremonese AC2684.D-S - AC2684SG.D-S, utilizzare maschera AT2825
For the installation of AC2684.D-S - AC2684SG.D-S cremone bolt, please use the jig AT2825





lavorazione applicazione incontro
Processing for the installation of the strike plate

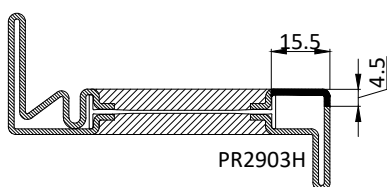
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



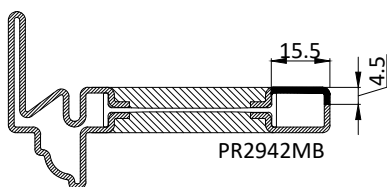
Incontro 3^a chiusura
3rd lock strike plate

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

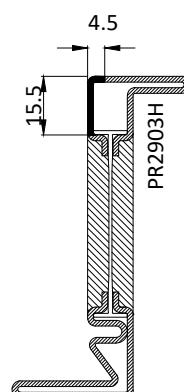
N.B.: Distance between the closing points max. 1000 mm



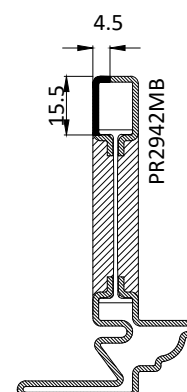
PR2903H



PR2942MB



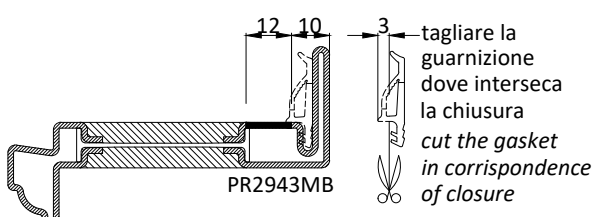
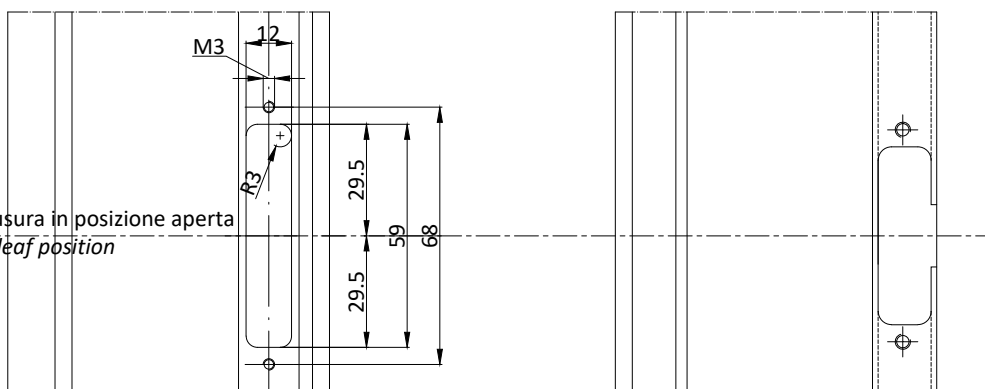
PR2903H



PR2942MB

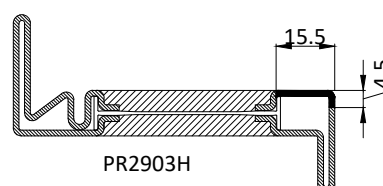
lavorazione applicazione nottolino
Processing for plug installation

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



PR2943MB

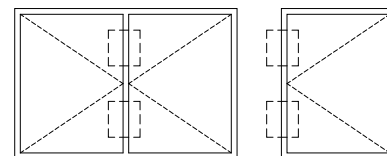
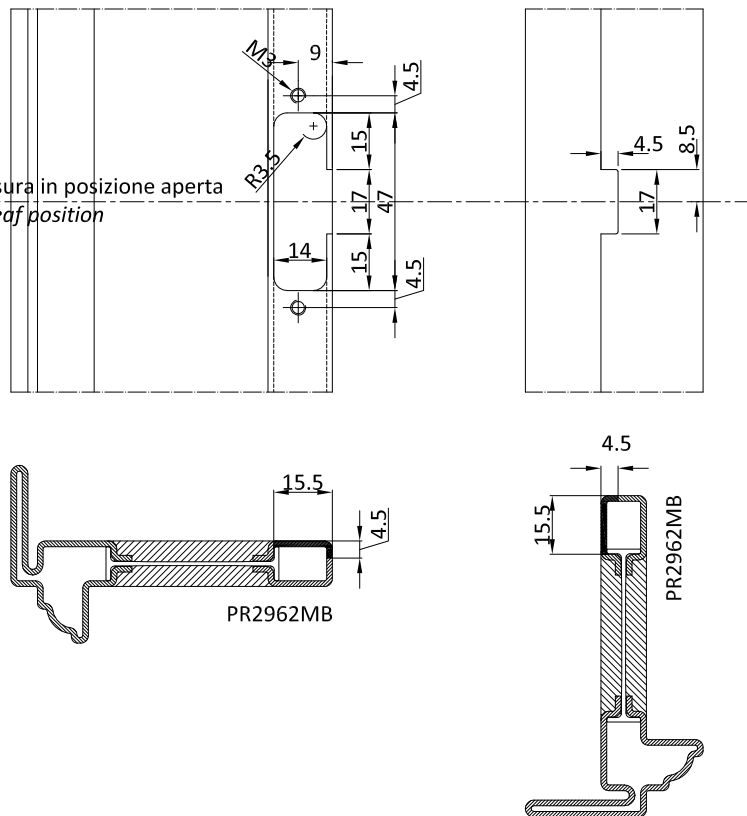
tagliare la
guarnizione
dove interseca
la chiusura
*cut the gasket
in correspondence
of closure*



PR2903H

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



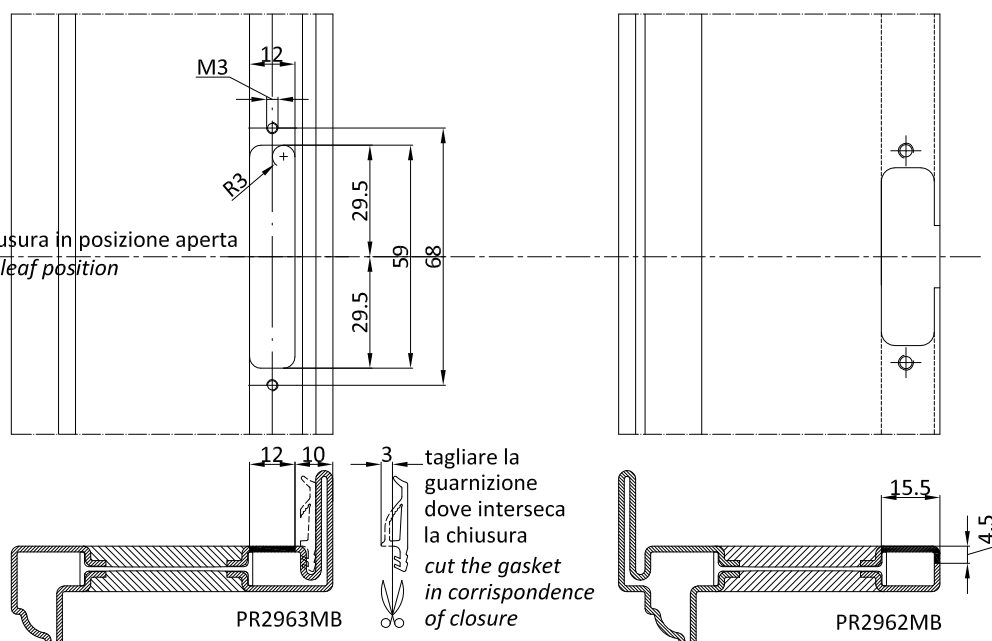
Incontro 3^a chiusura
3rd lock strike plate

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

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

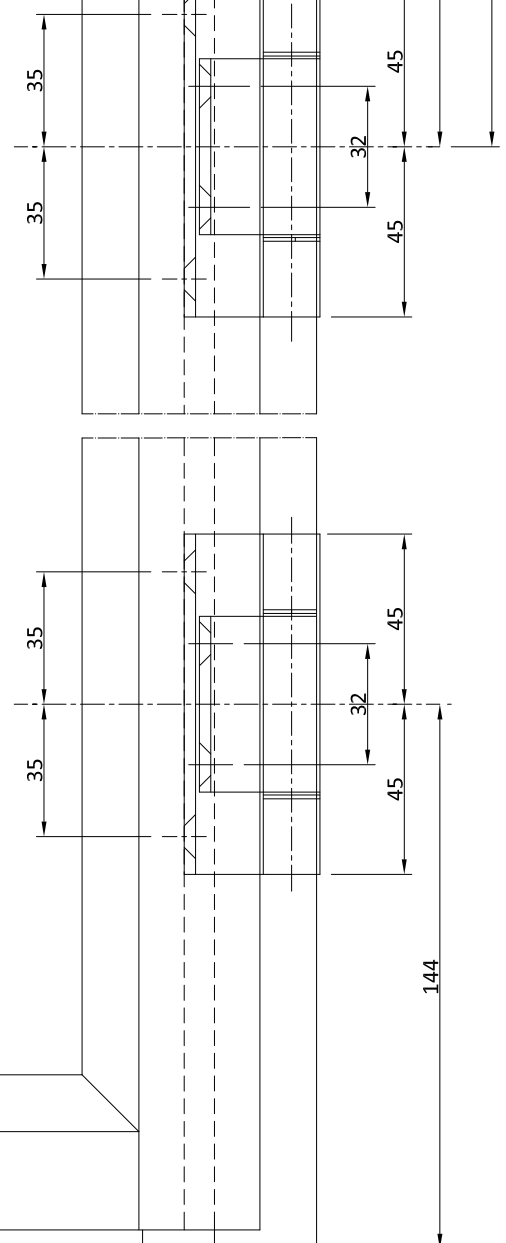
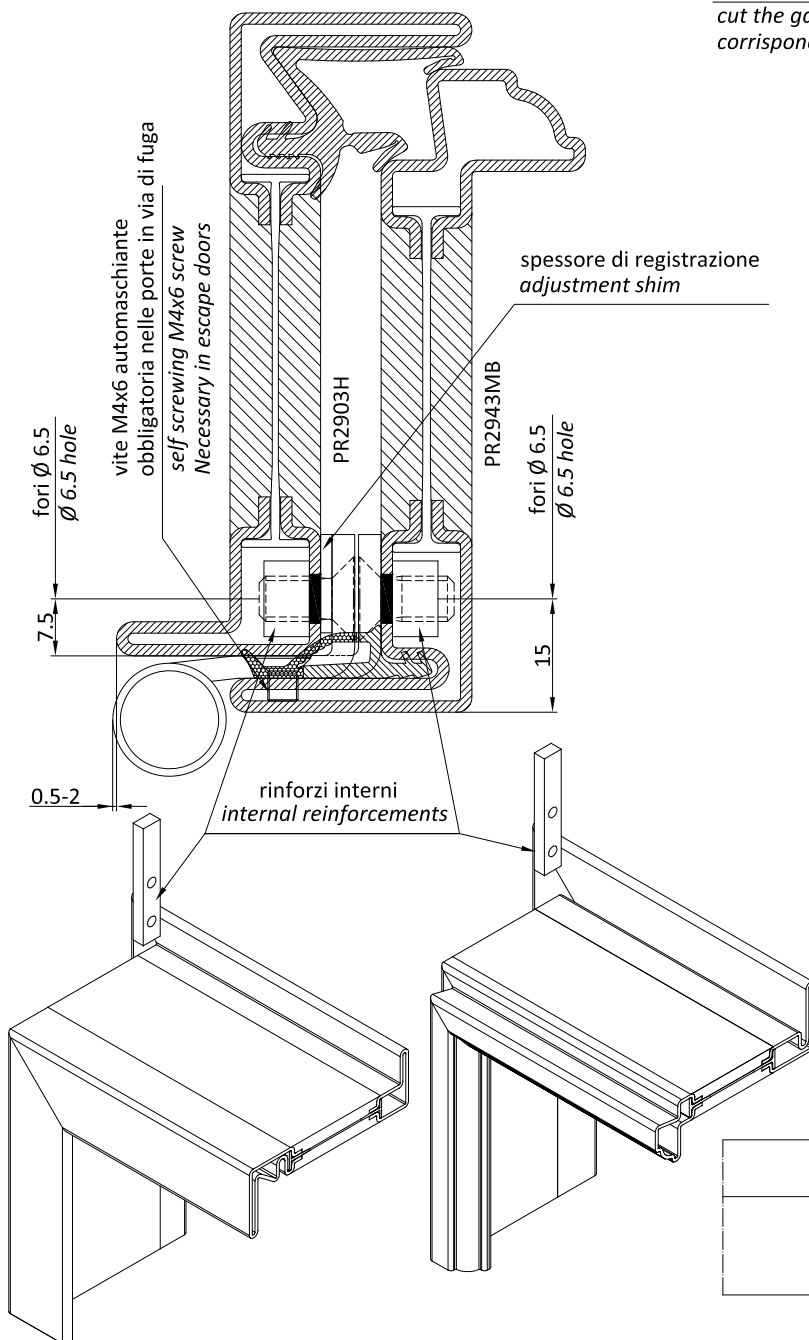
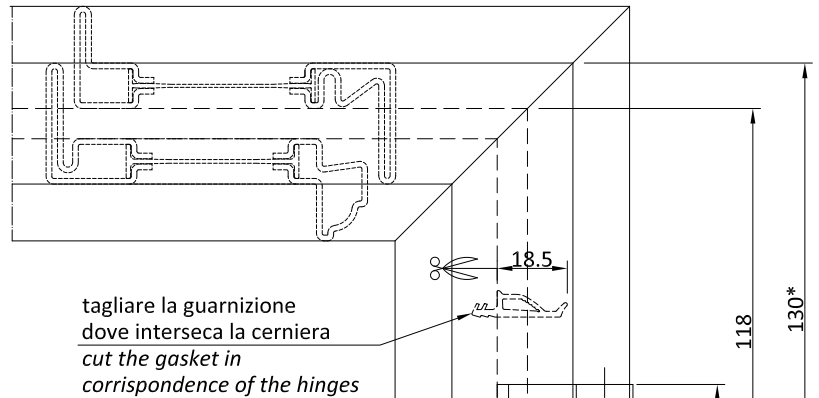
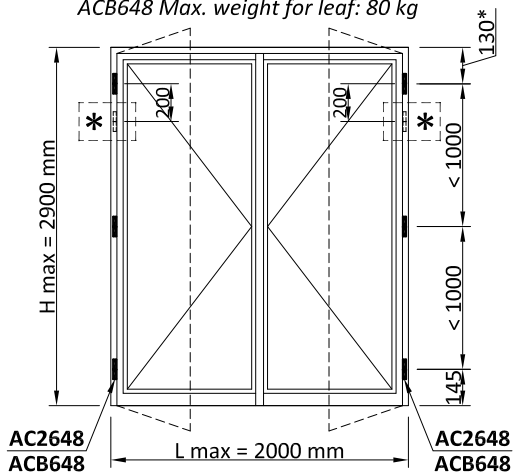
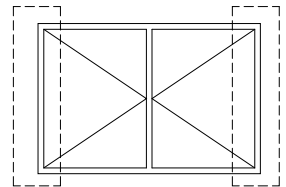
lavorazione applicazione nottolino
Processing for plug installation

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



AC2648 Peso max. per anta 100 kg
ACB648 Peso max. per anta 80 kg
AC2648 Max. weight for leaf: 100 kg
ACB648 Max. weight for leaf: 80 kg

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

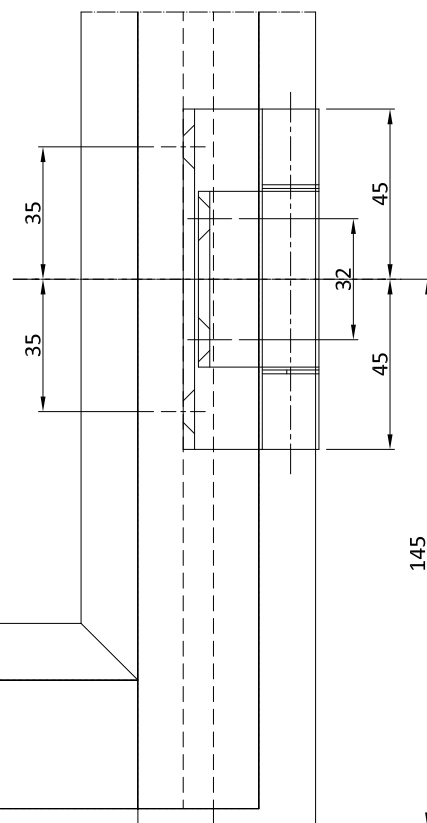
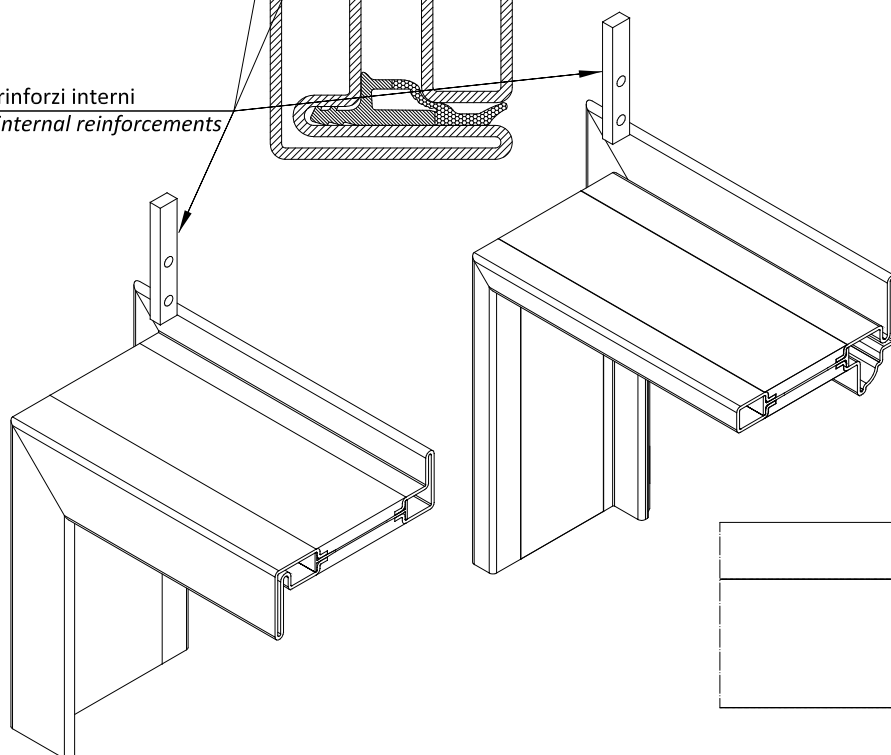
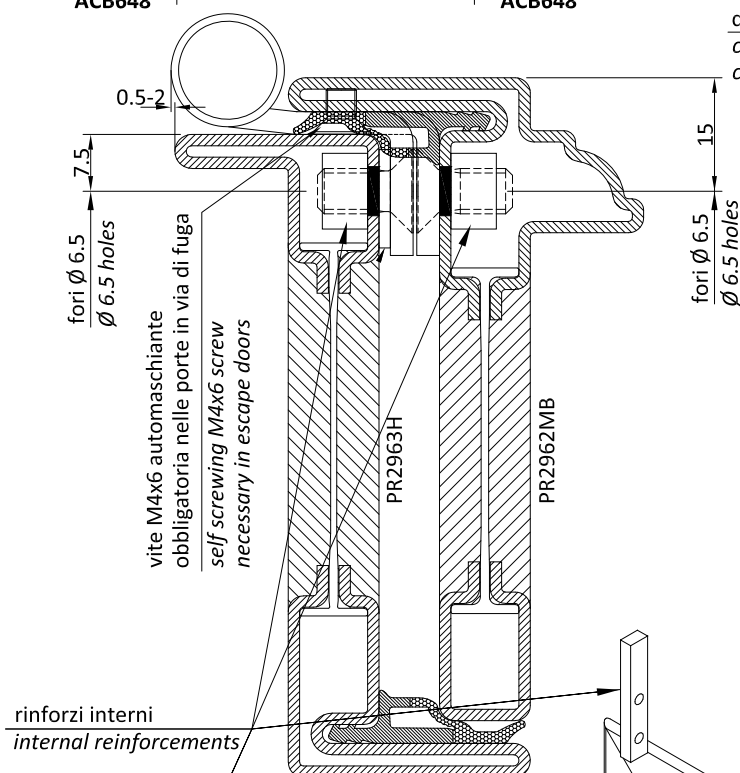
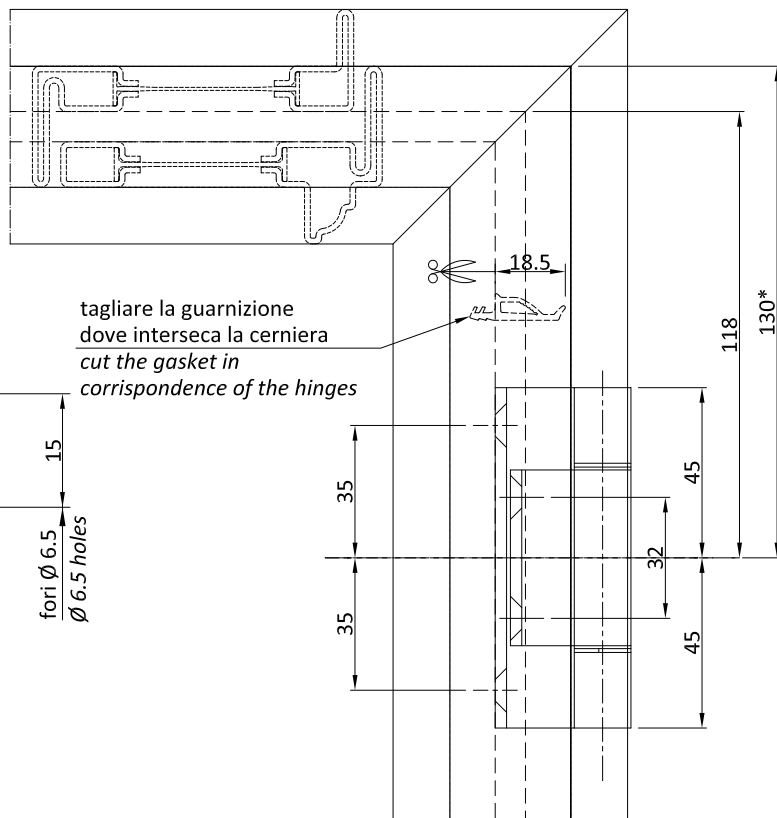
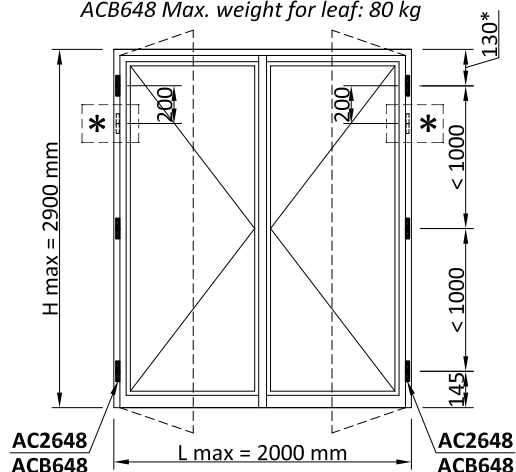
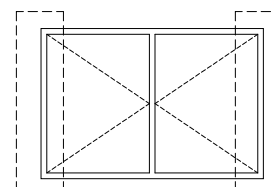


*150 mm ottone | brass

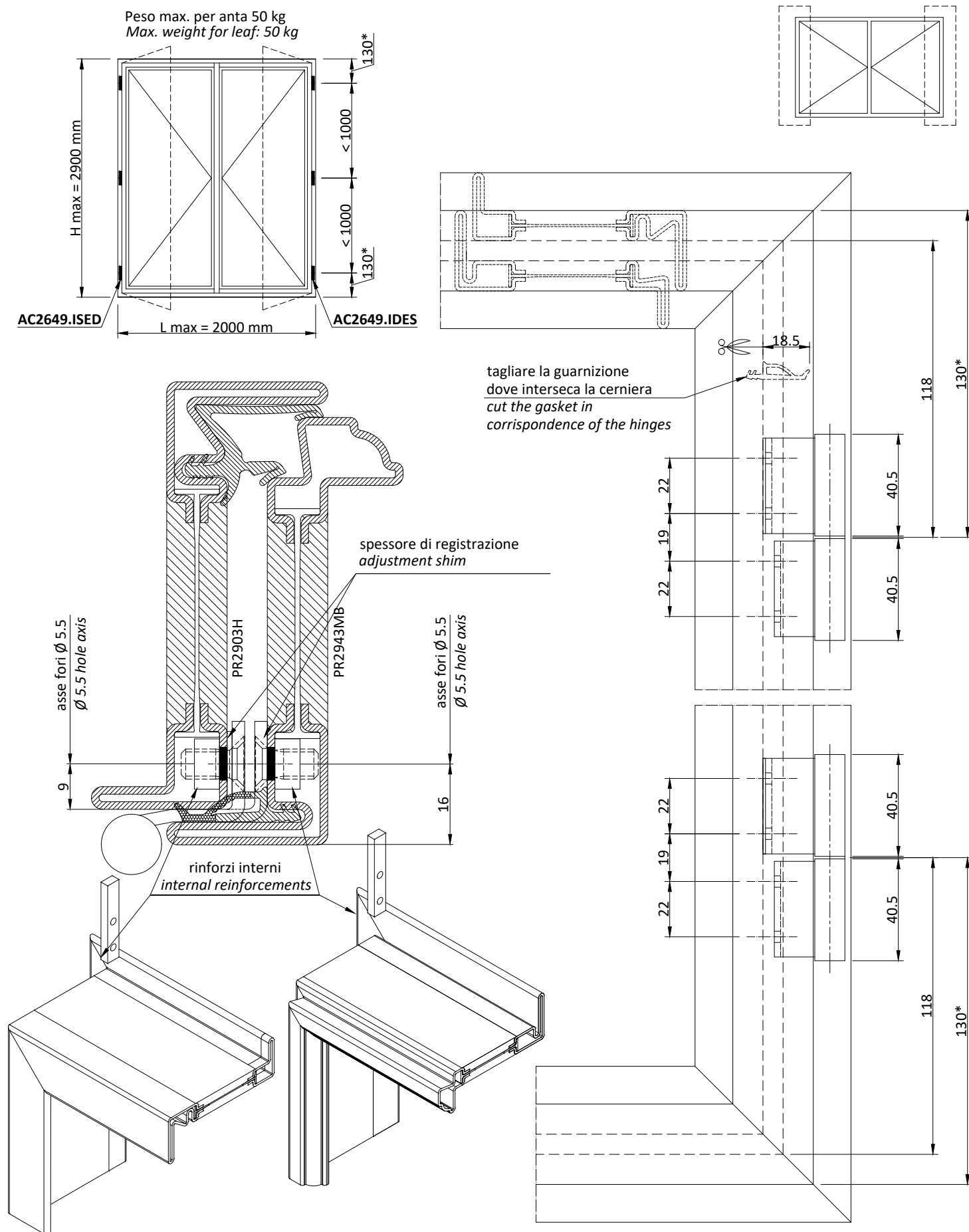
AC2648 Peso max. per anta 100 kg
ACB648 Peso max. per anta 80 kg
AC2648 Max. weight for leaf: 100 kg
ACB648 Max. weight for leaf: 80 kg

*AC2648

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



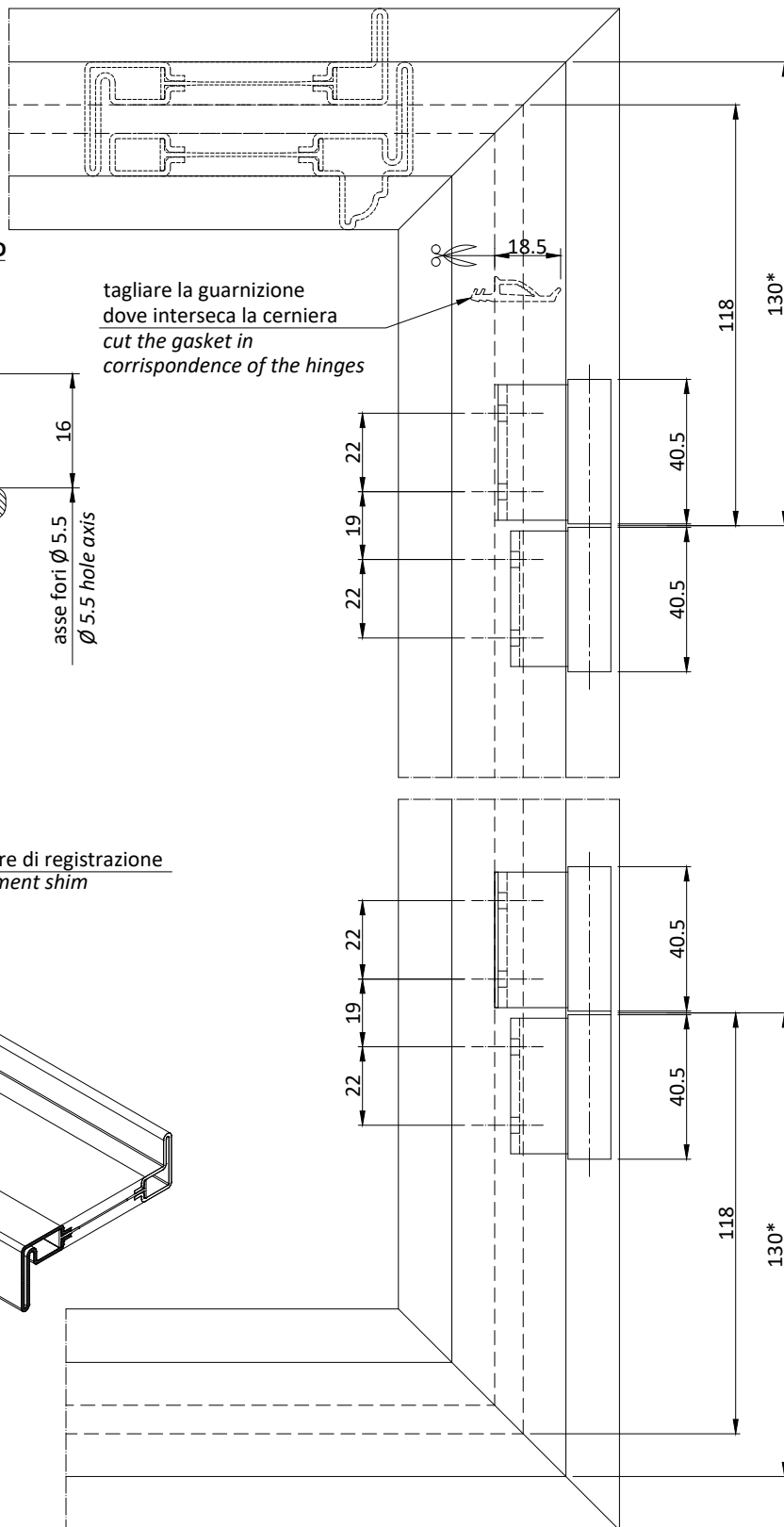
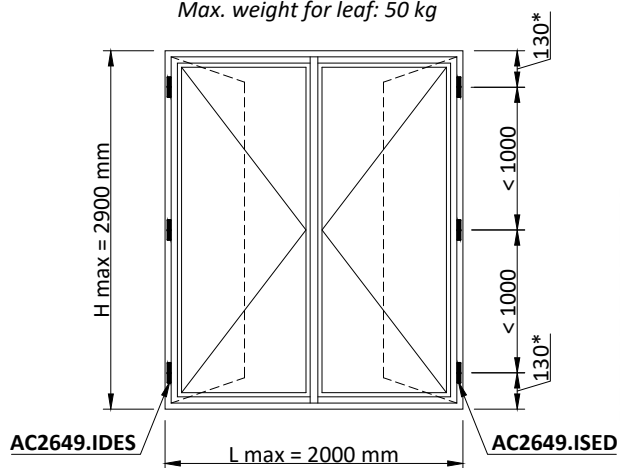
*150 mm ottone | brass



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

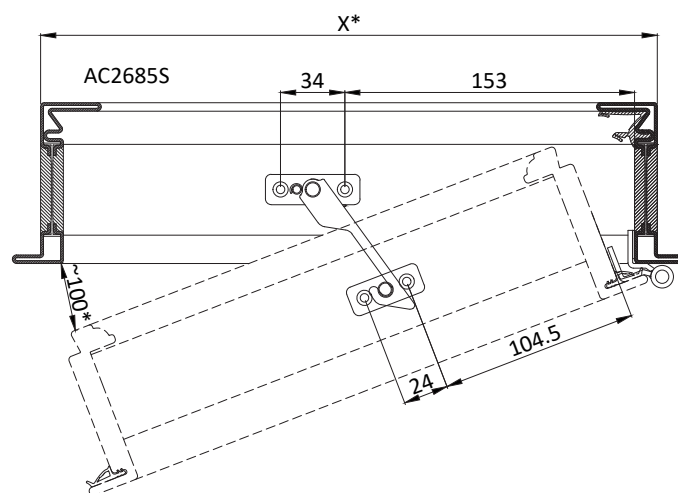
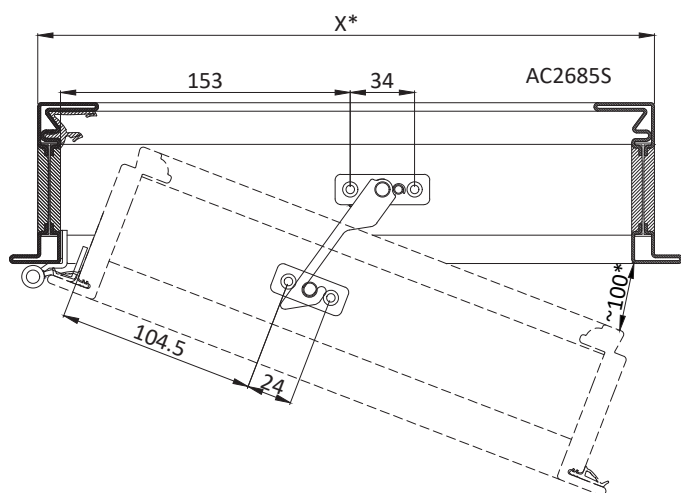
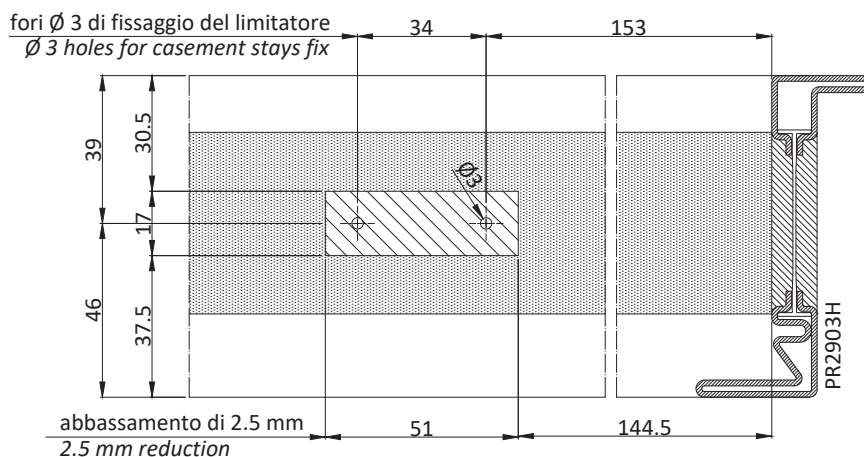
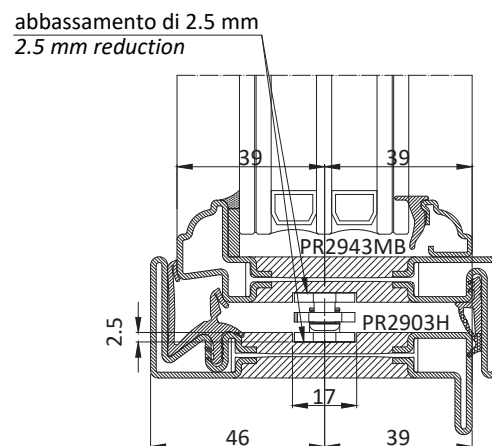
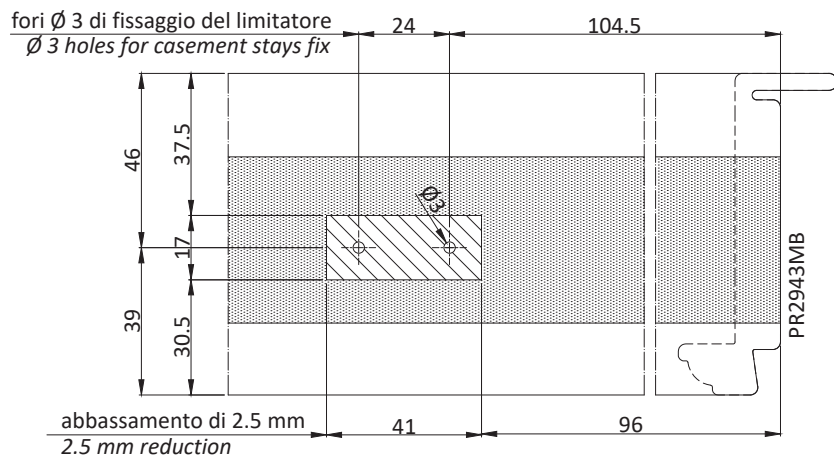
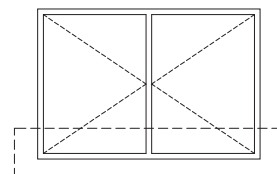
*150 mm ottone | brass

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

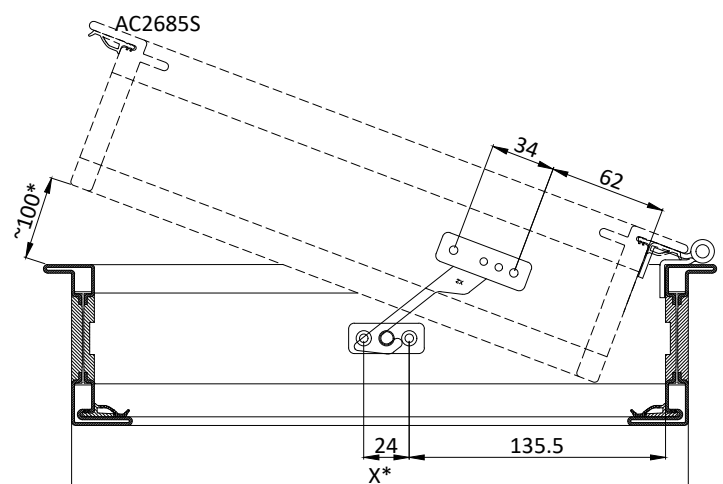
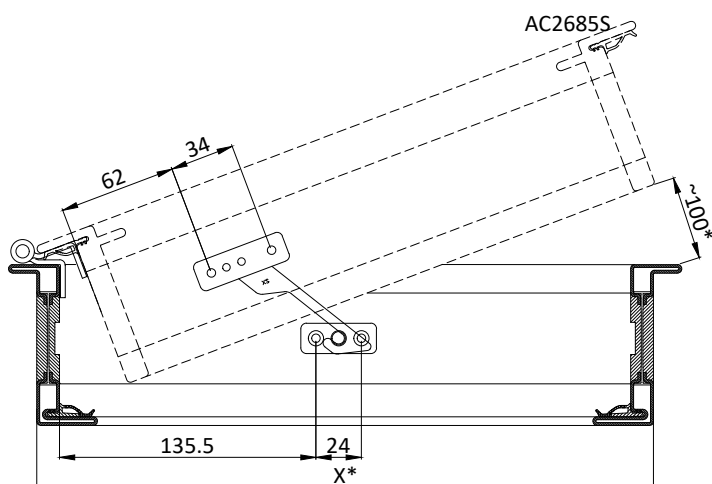
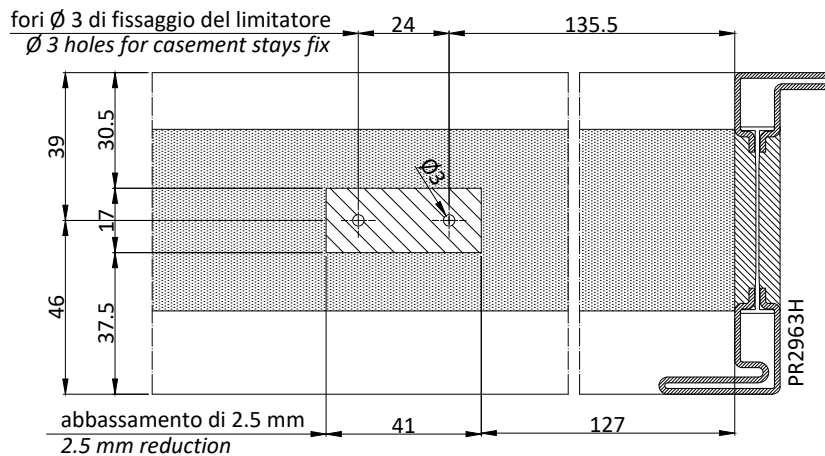
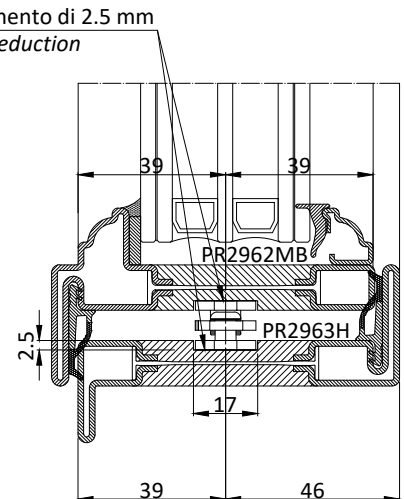
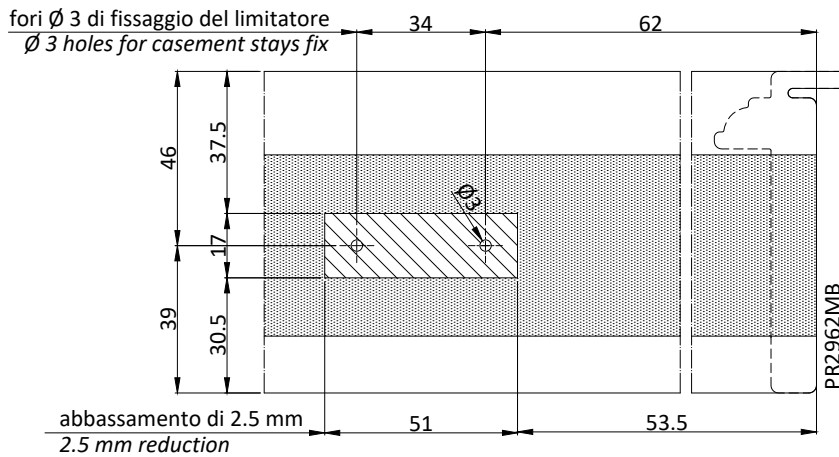
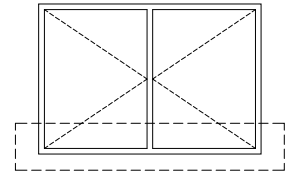


Per l'applicazione delle cerniere AC2649 utilizzare maschera AT2629
For the installation of hinges AC2649 please use the jig AT2629

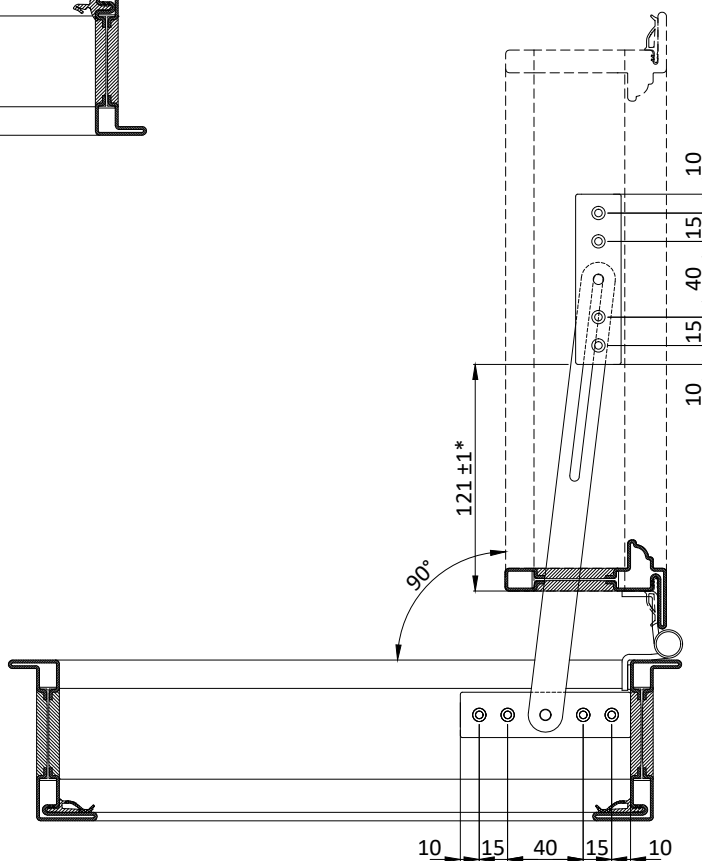
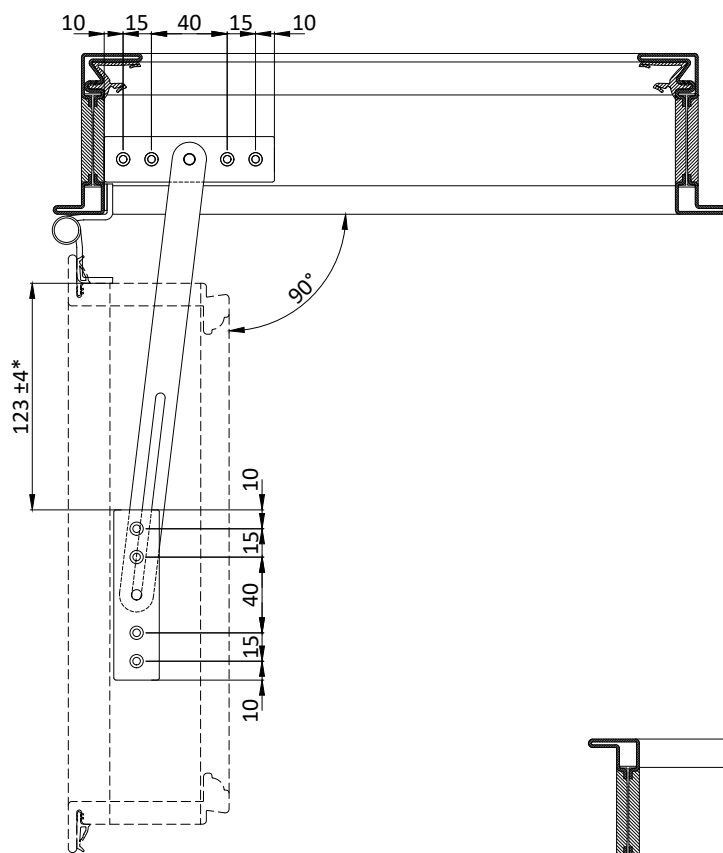
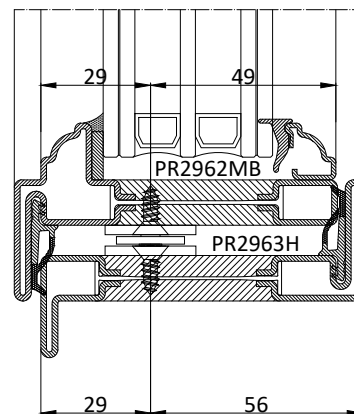
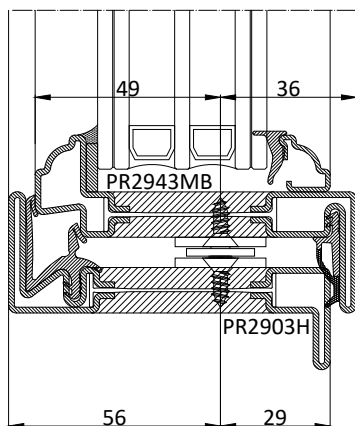
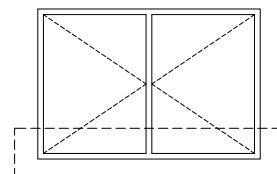
*150 mm ottone | brass



* 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

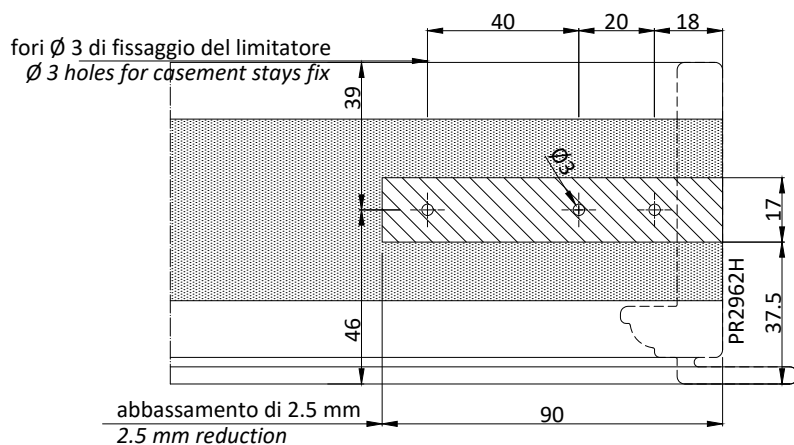
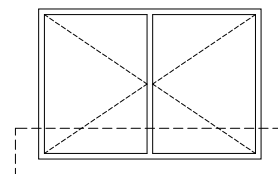


* *fitting simulation for frame width (X) 500mm and maximum opening ~100 mm*

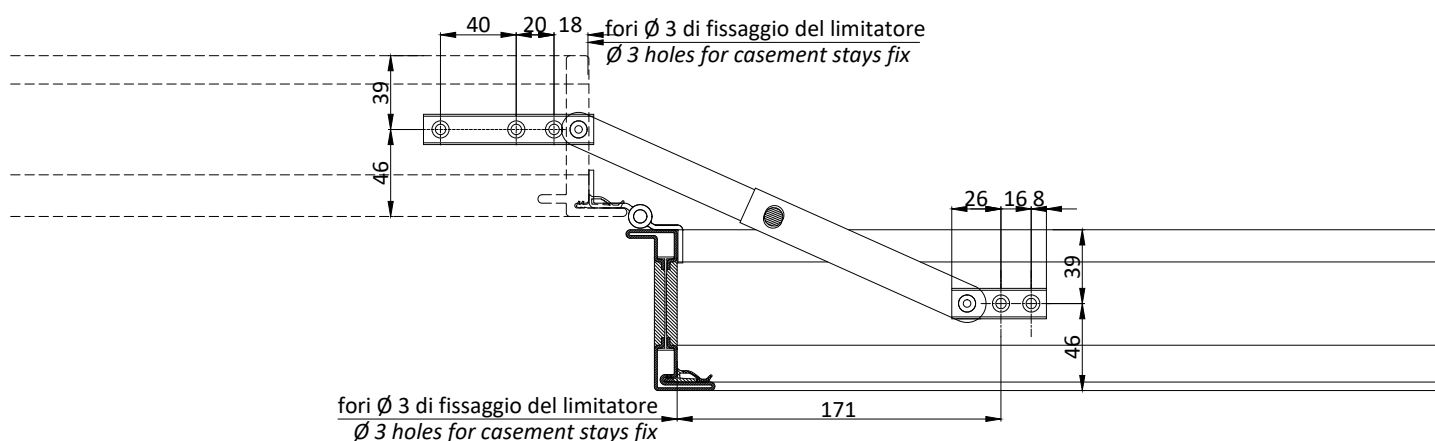
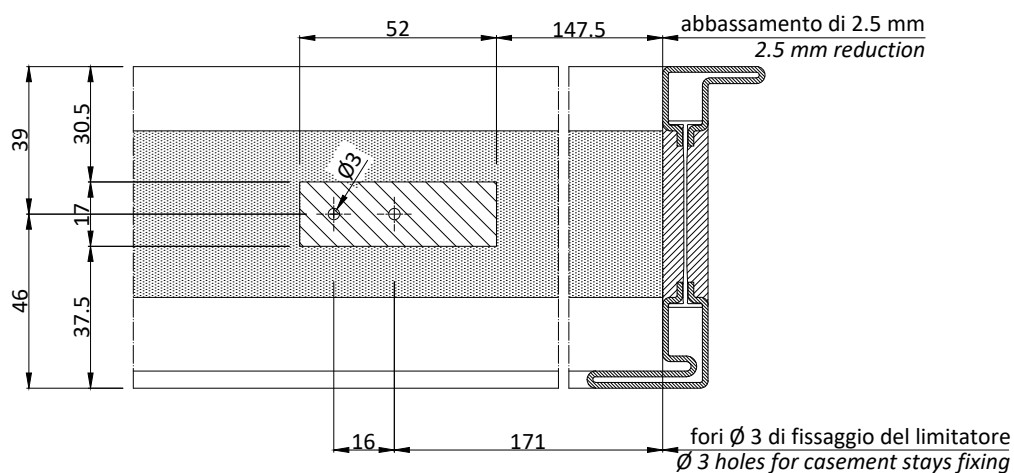
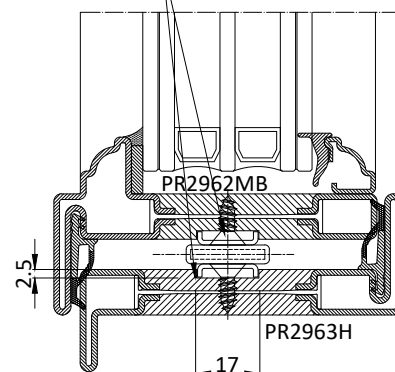


* dimensione variabile a seconda del profilo e delle cerniere utilizzate. Si consiglia il posizionamento sull'anta in opera.

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



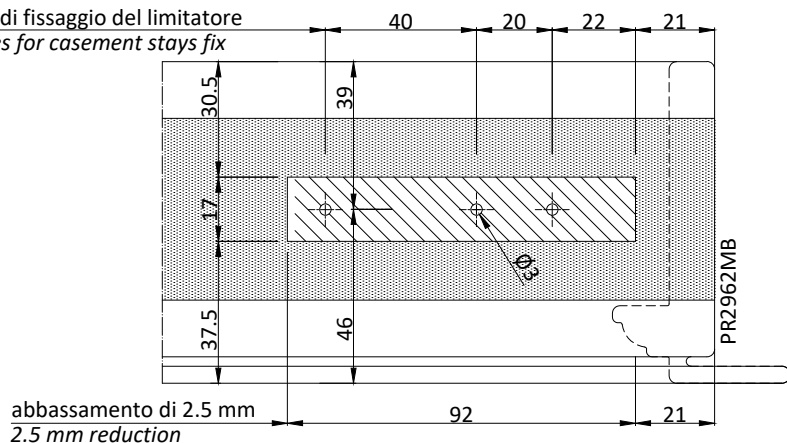
abbassamento di 2.5 mm
2.5 mm reduction



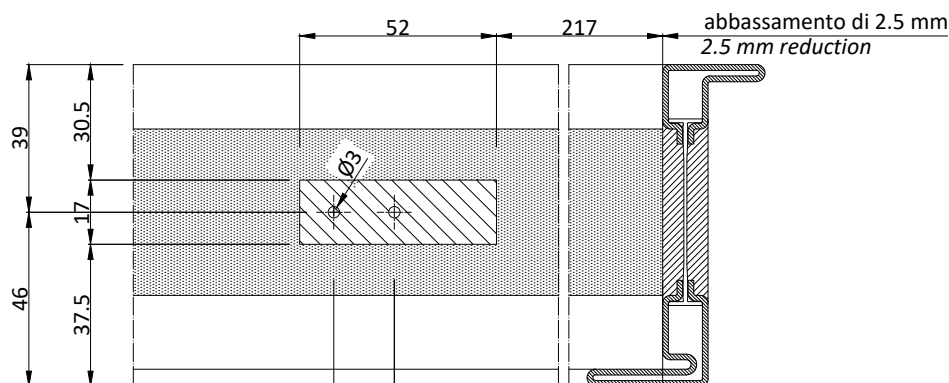
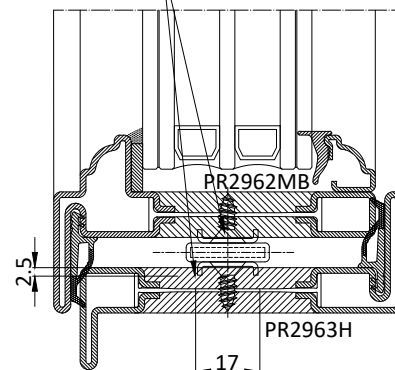
* ATTENZIONE non forzare l'apertura del limitatore oltre il fine corsa meccanico

* WARNING do not force the opening of the restrictor over its mechanical limit stop point

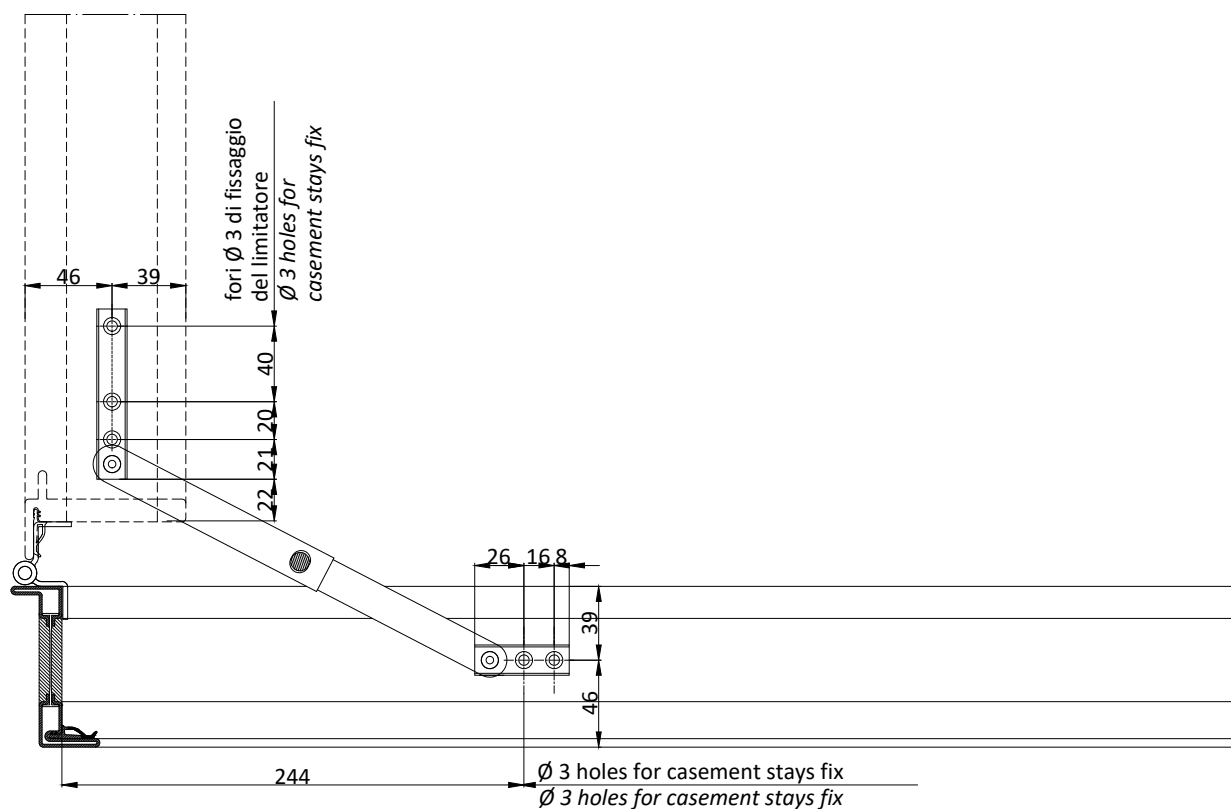
fori $\varnothing 3$ di fissaggio del limitatore
 $\varnothing 3$ holes for casement stays fix



abbassamento di 2.5 mm
2.5 mm reduction

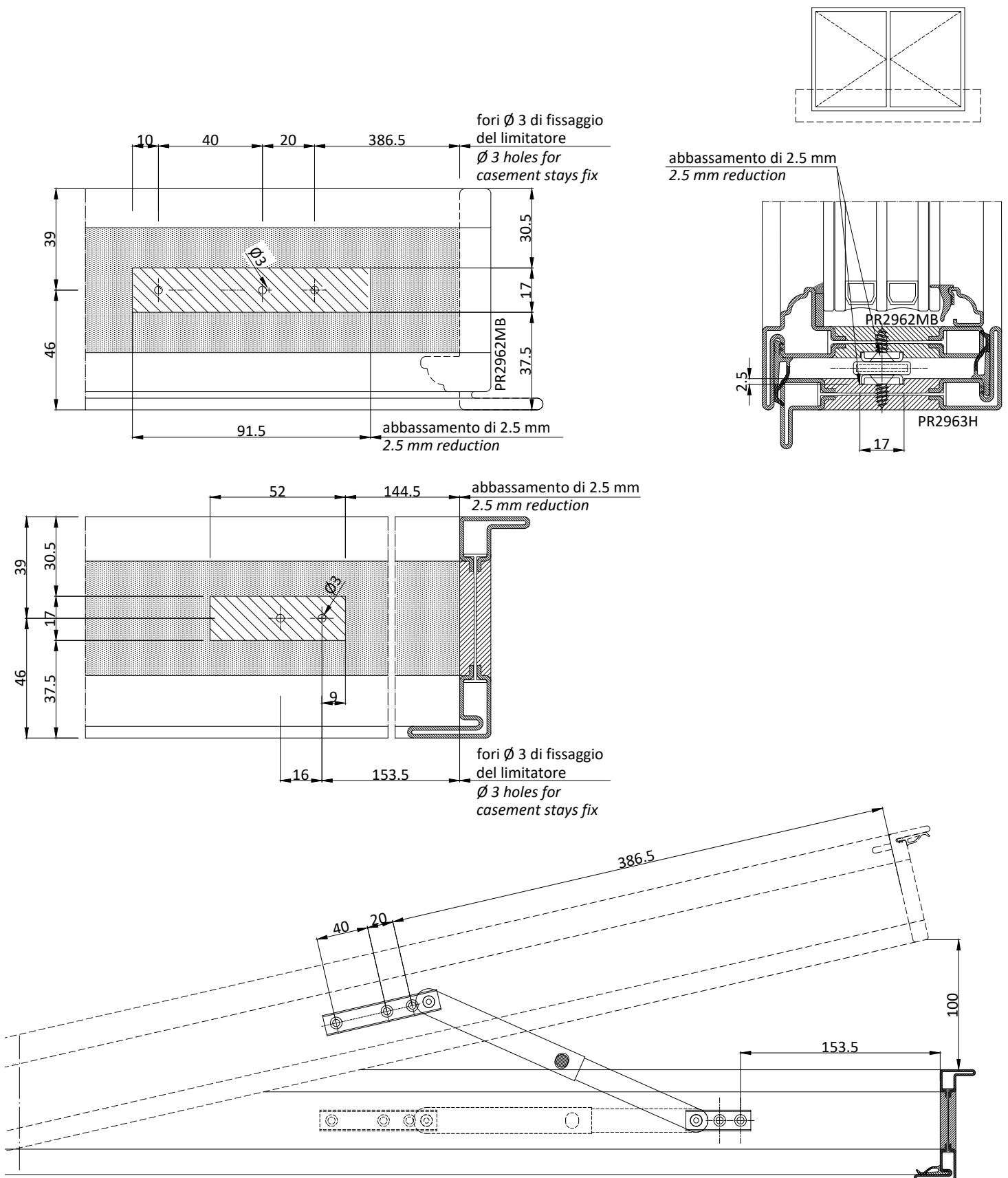


fori $\varnothing 3$ di fissaggio del limitatore
 $\varnothing 3$ holes for casement stays fix



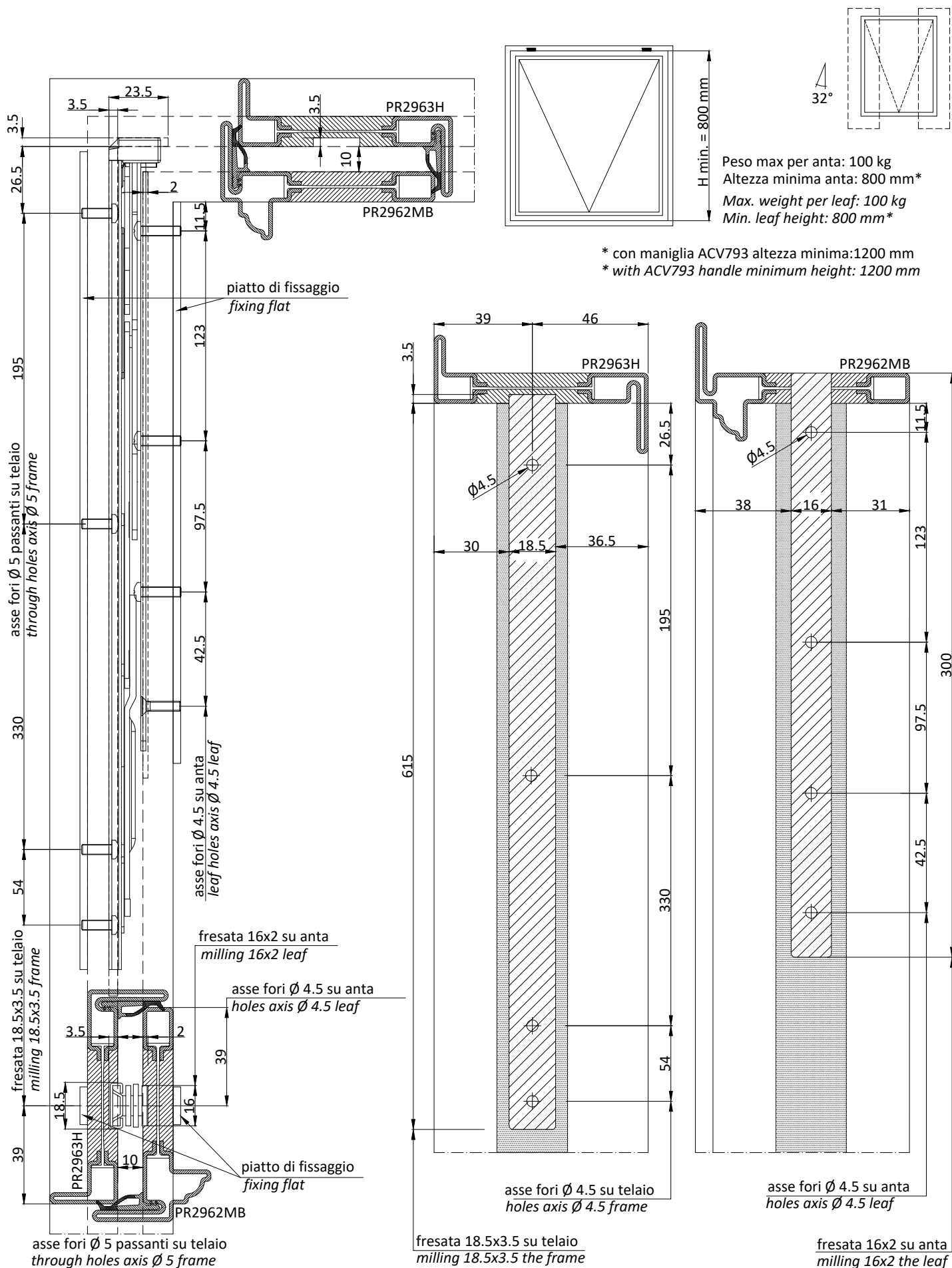
* ATTENZIONE non forzare l'apertura del limitatore oltre il fine corsa meccanico

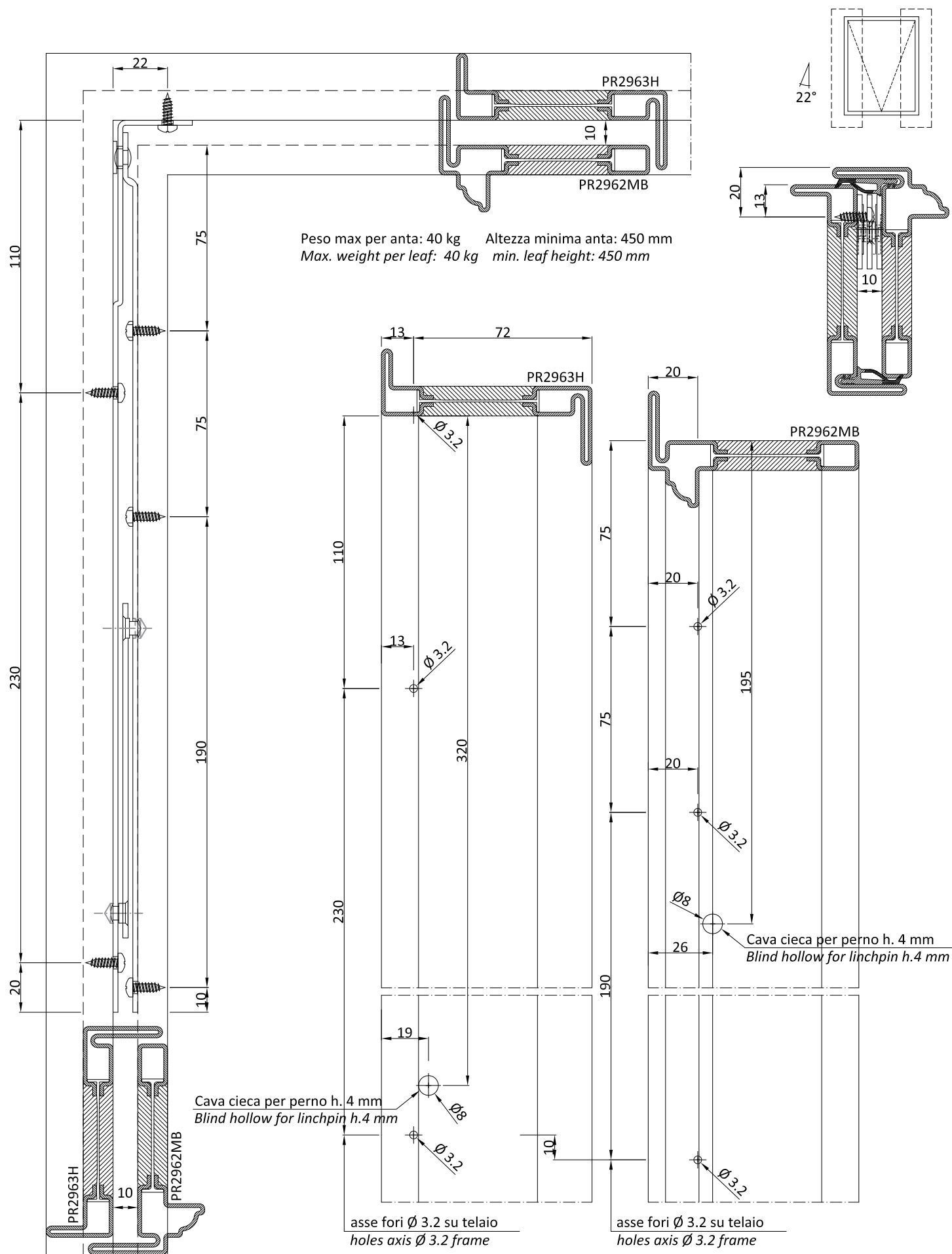
* WARNING do not force the opening of the restrictor over its mechanical limit stop point

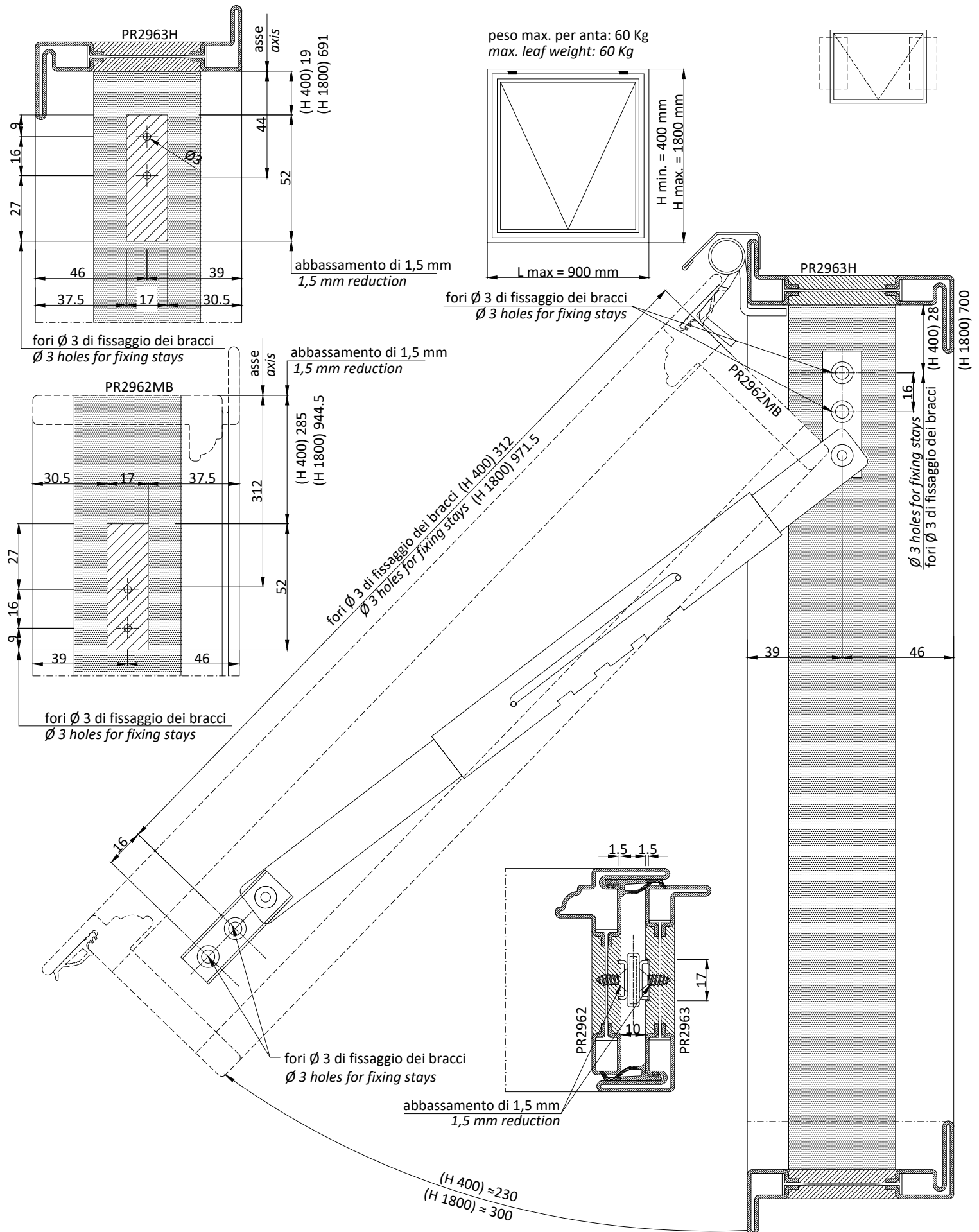


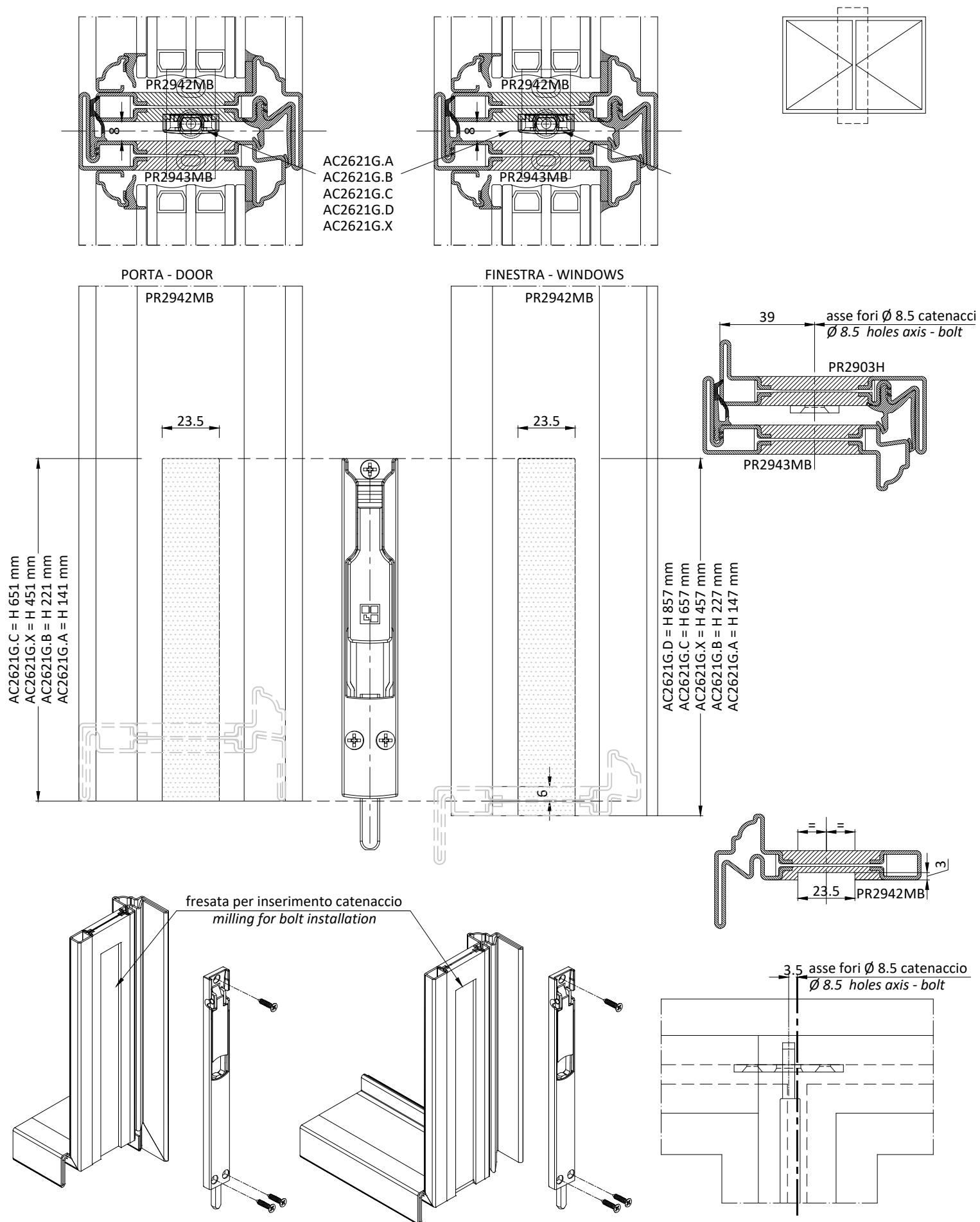
* ATTENZIONE non forzare l'apertura del limitatore oltre il fine corsa meccanico

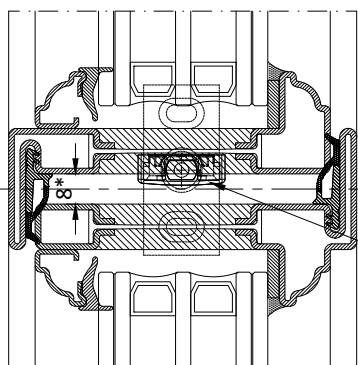
* WARNING do not force the opening of the restrictor over its mechanical limit stop point



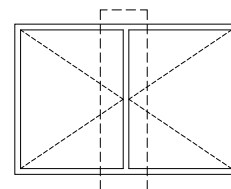
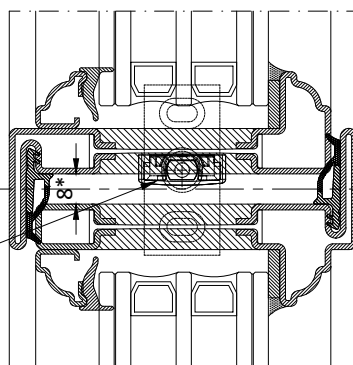








AC2621G.A
AC2621G.B
AC2621G.C
AC2621G.D
AC2621G.X



*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 2 mm
mill 8 mm and provide reinforcement plates
for fixing (not supplied); increase the air of
the central section of 2 mm

PORTA - DOOR

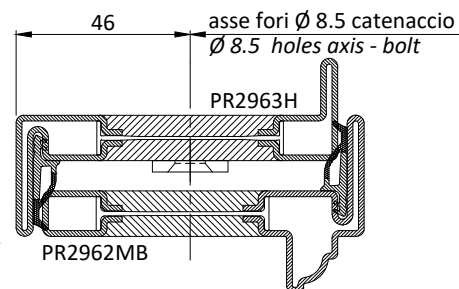
PR2963H

FINESTRA - WINDOWS

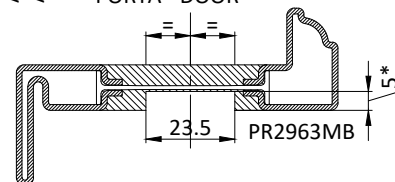
PR2963H

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

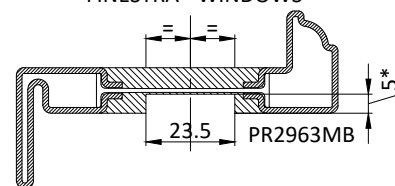
AC2621G.D = H 857 mm
AC2621G.C = H 657 mm
AC2621G.X = H 457 mm
AC2621G.B = H 227 mm
AC2621G.A = H 147 mm



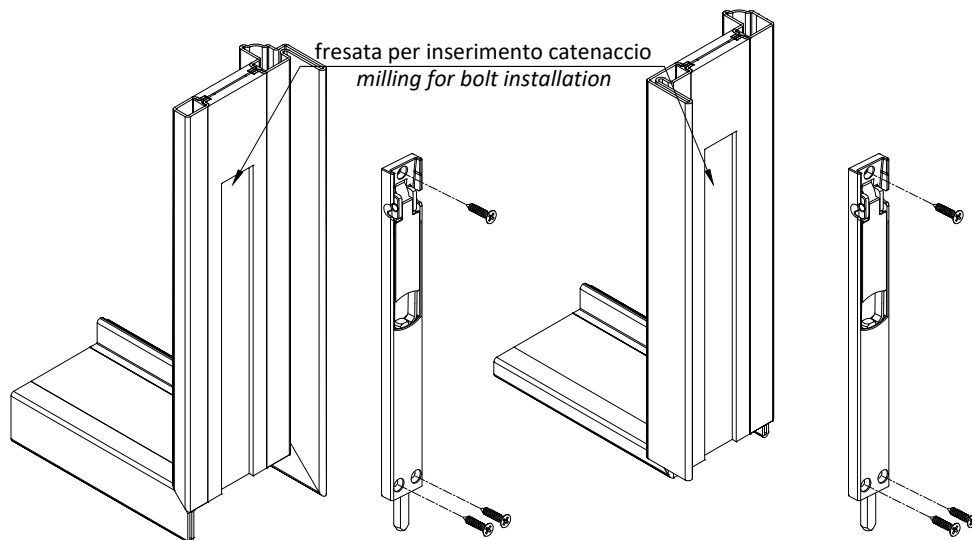
PORTA - DOOR



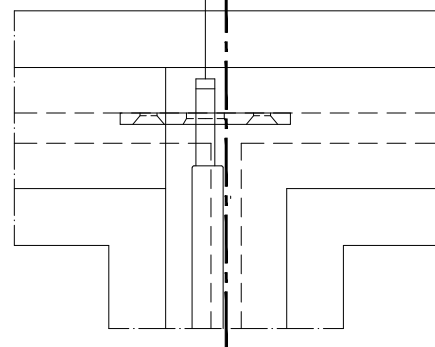
FINESTRA - WINDOWS

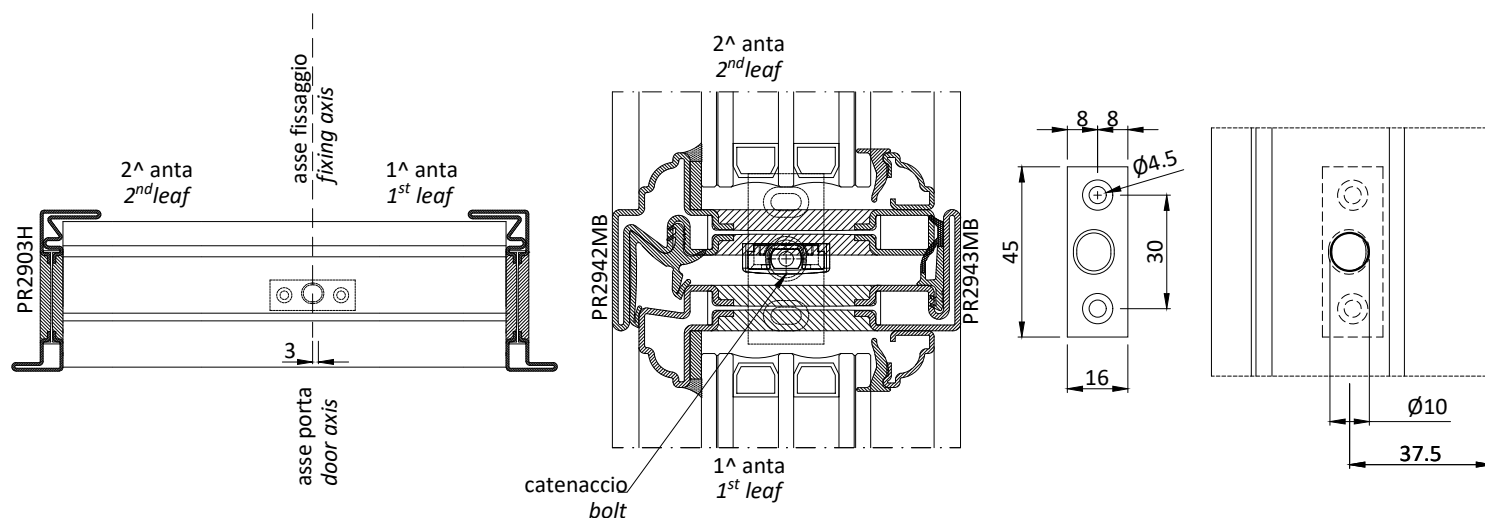
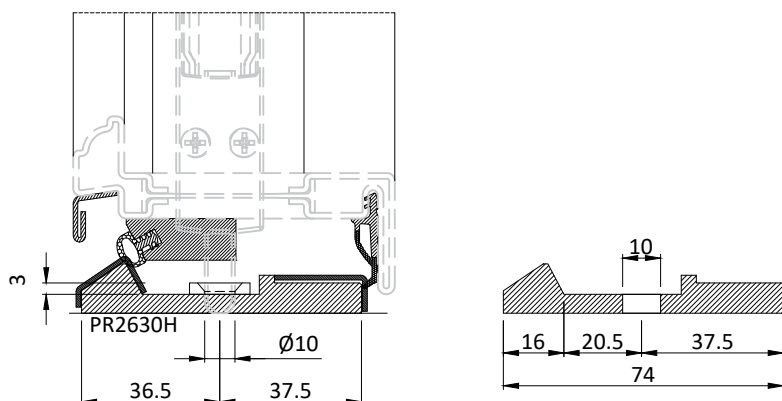
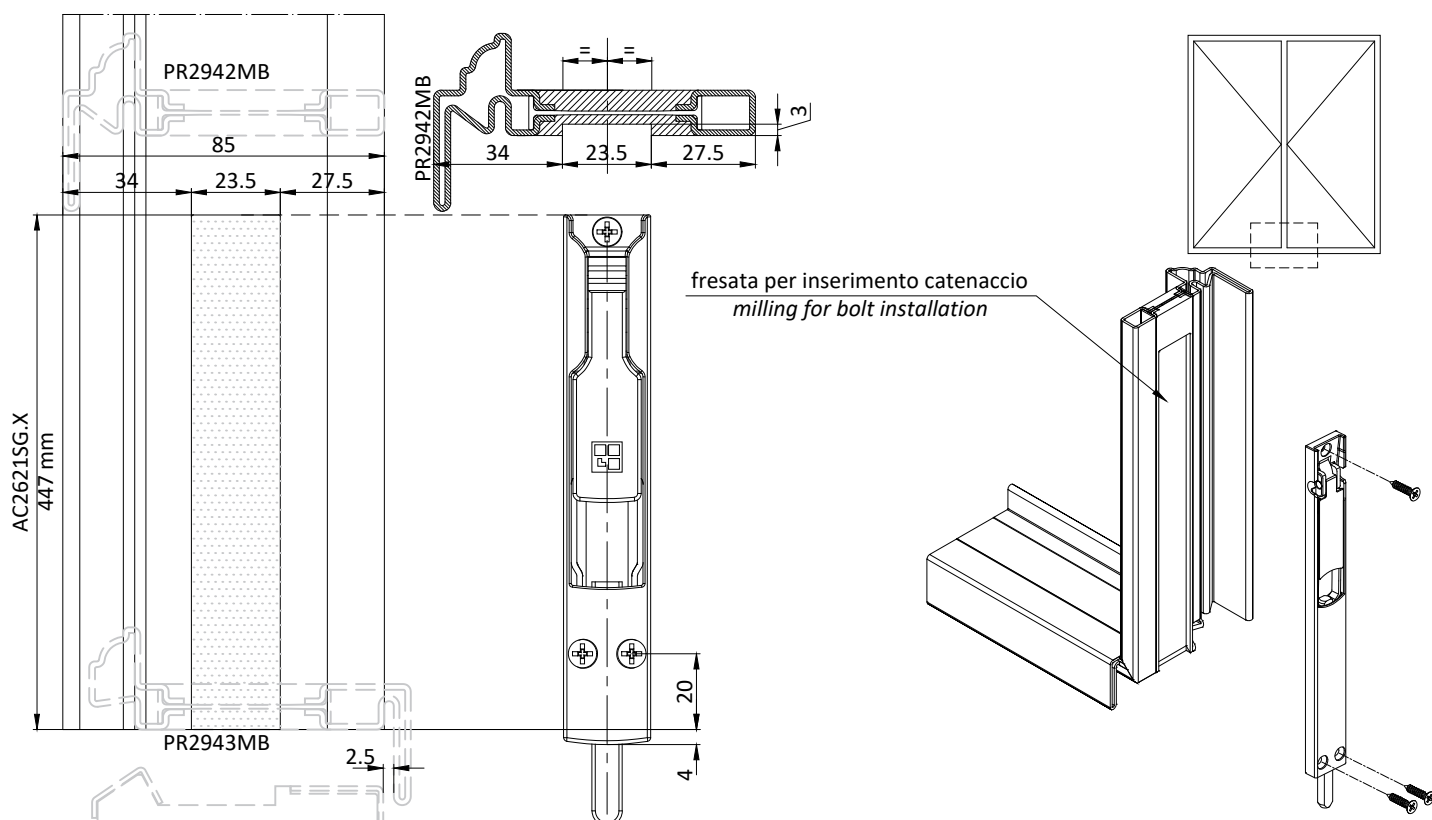


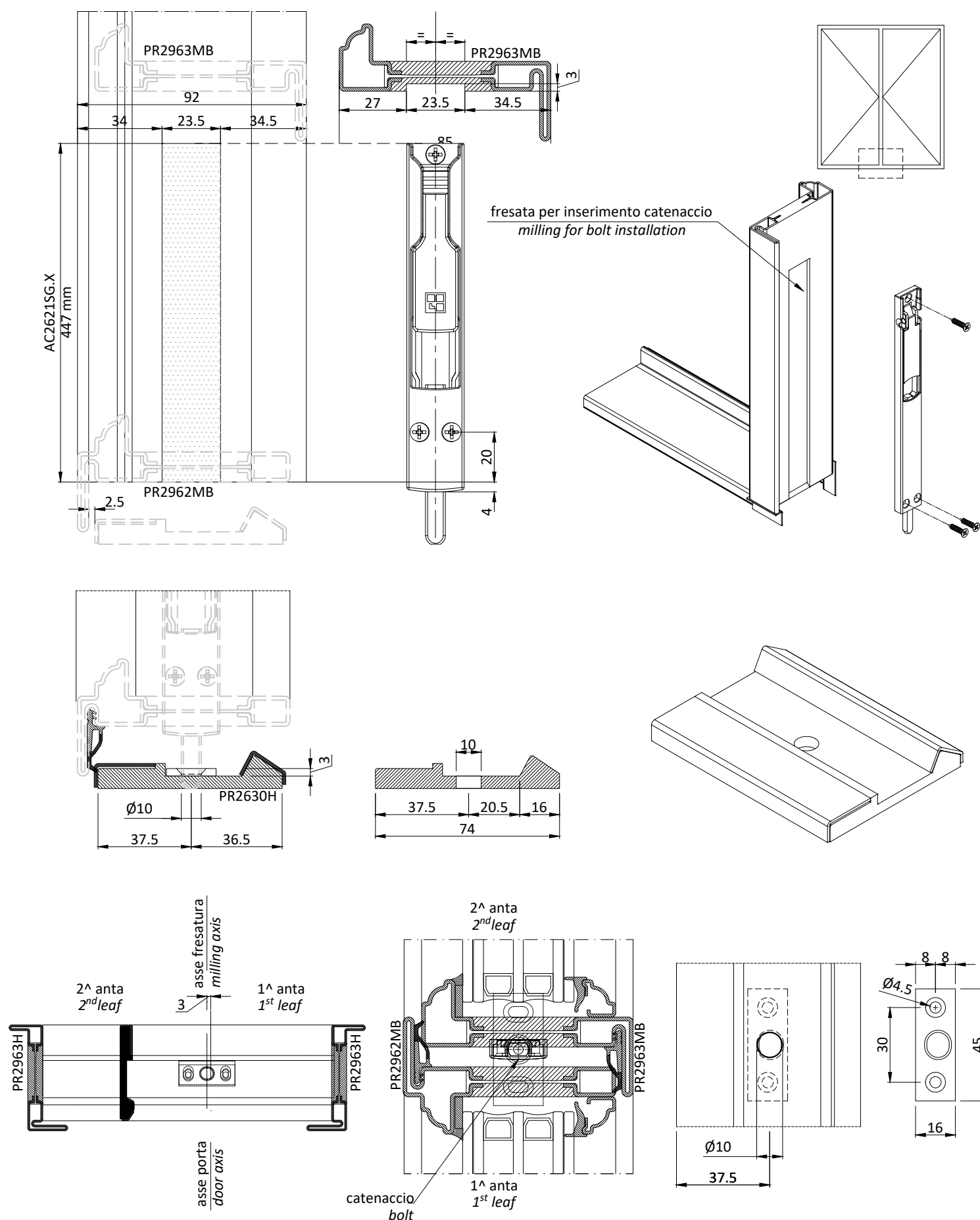
fresata per inserimento catenaccio
milling for bolt installation



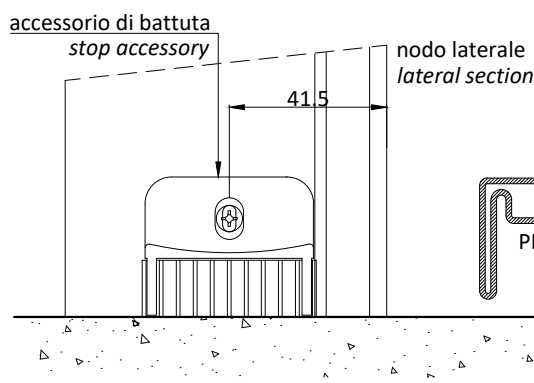
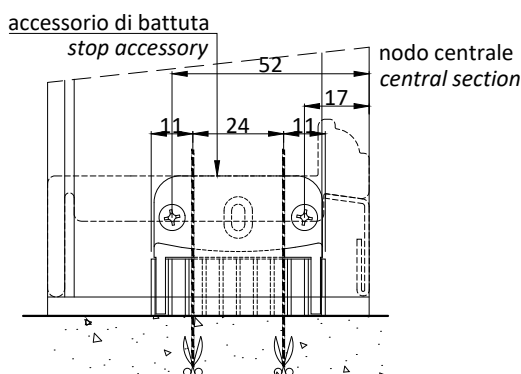
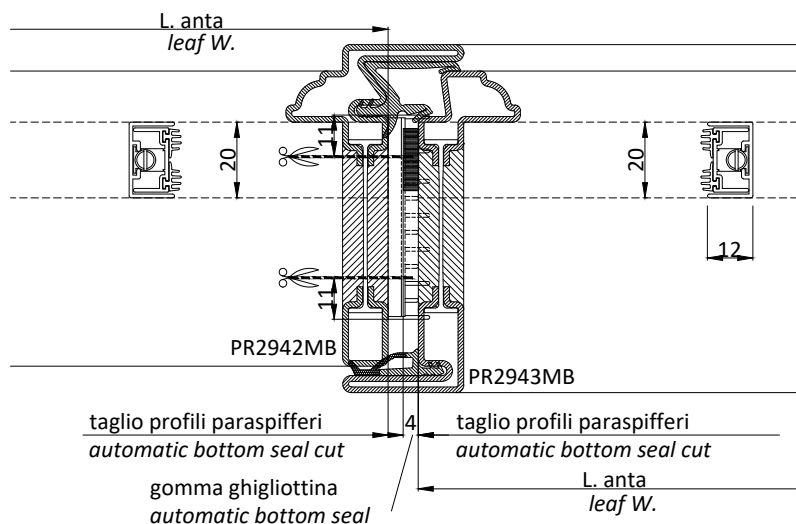
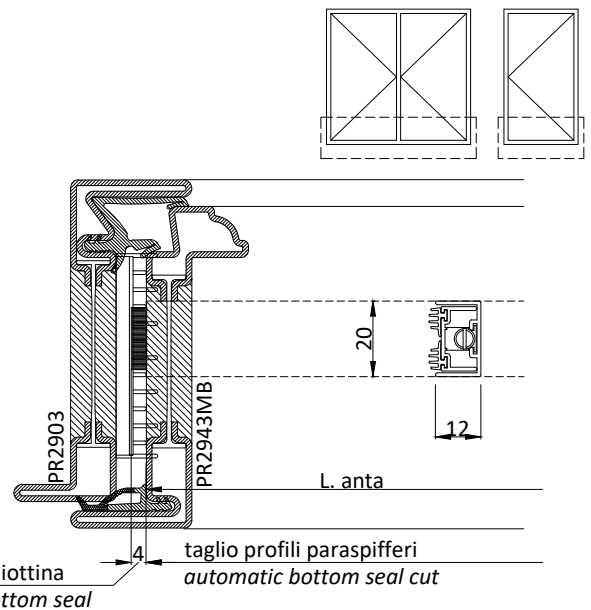
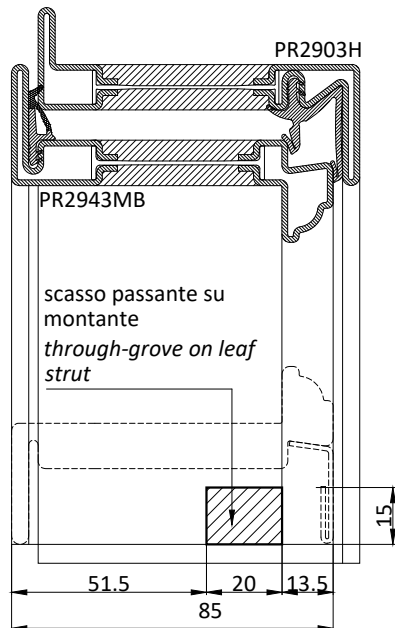
5.5 asse fori Ø 8.5 catenaccio
Ø 8.5 holes axis - bolt



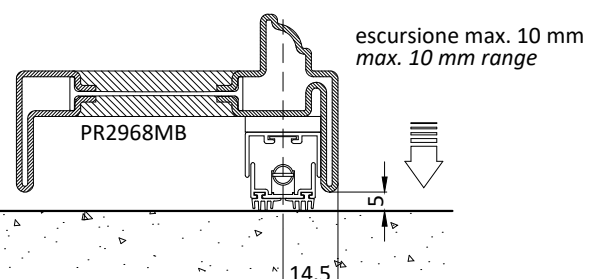
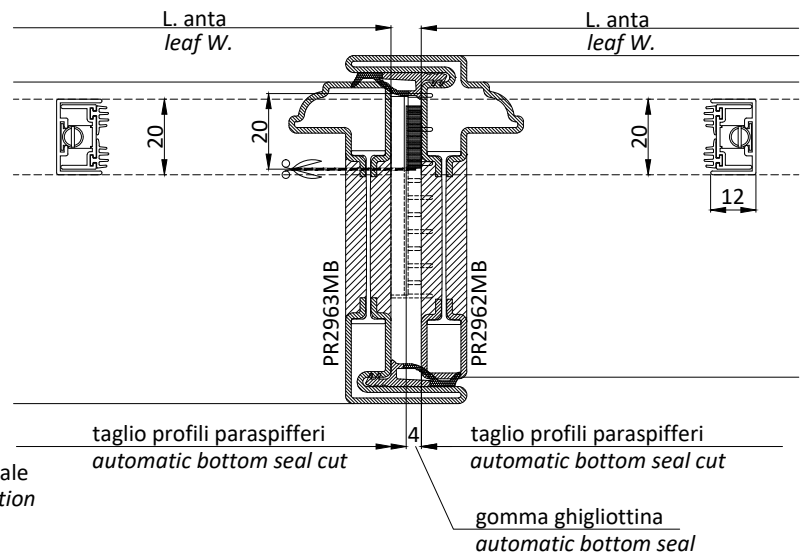
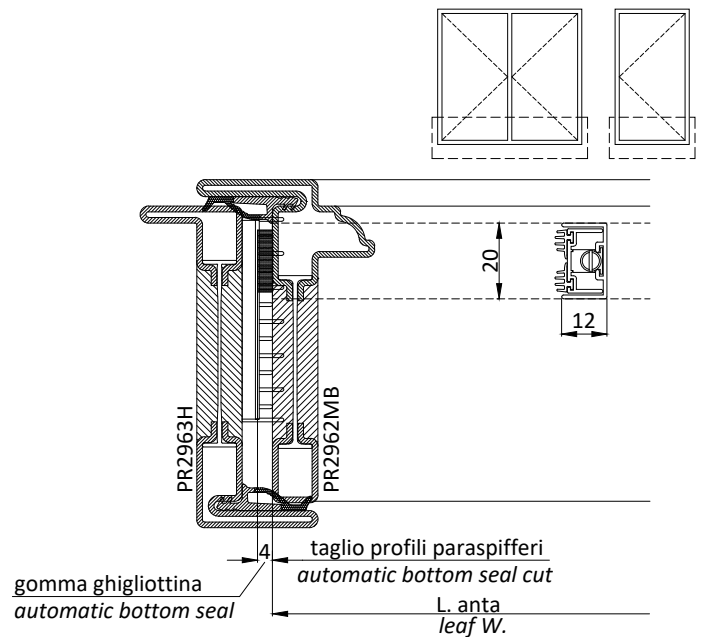
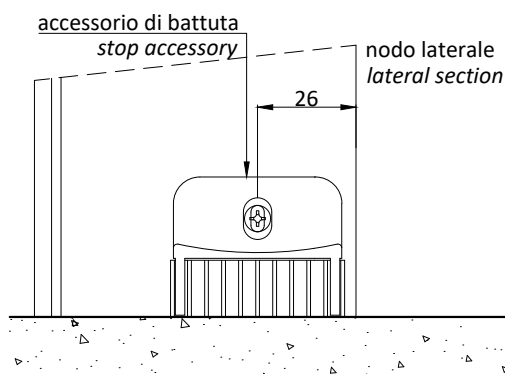
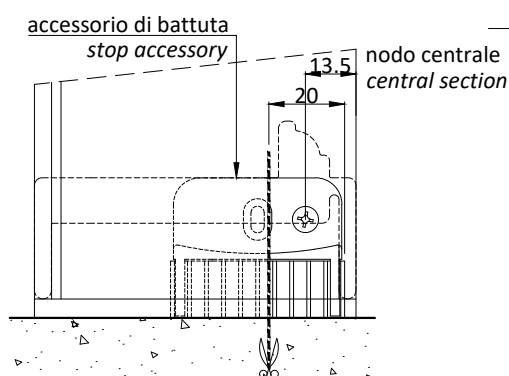
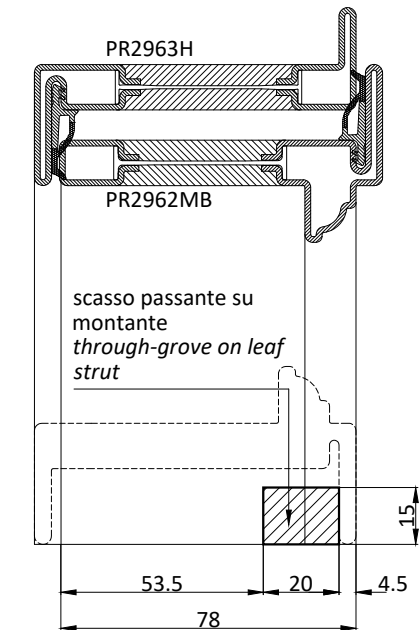


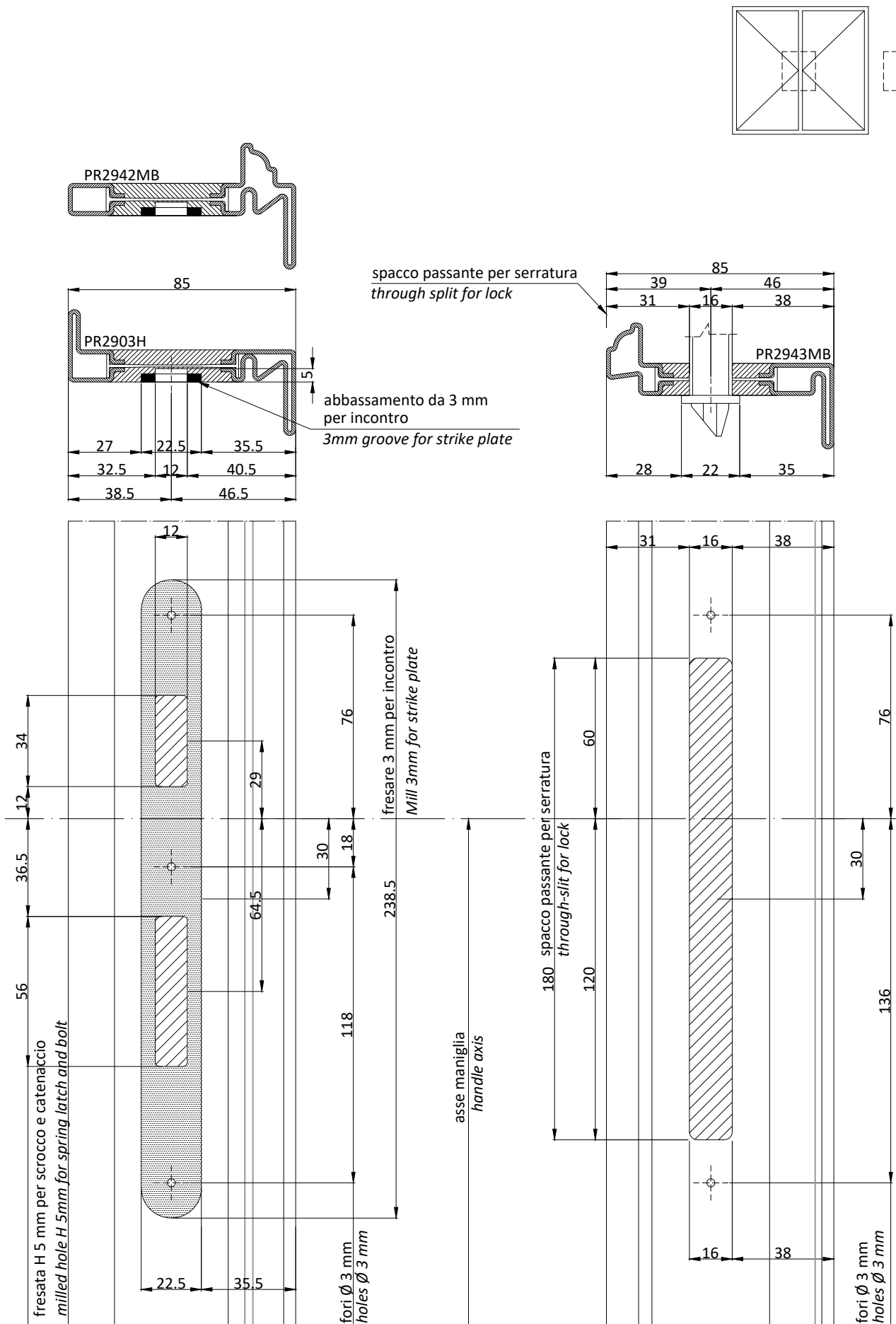


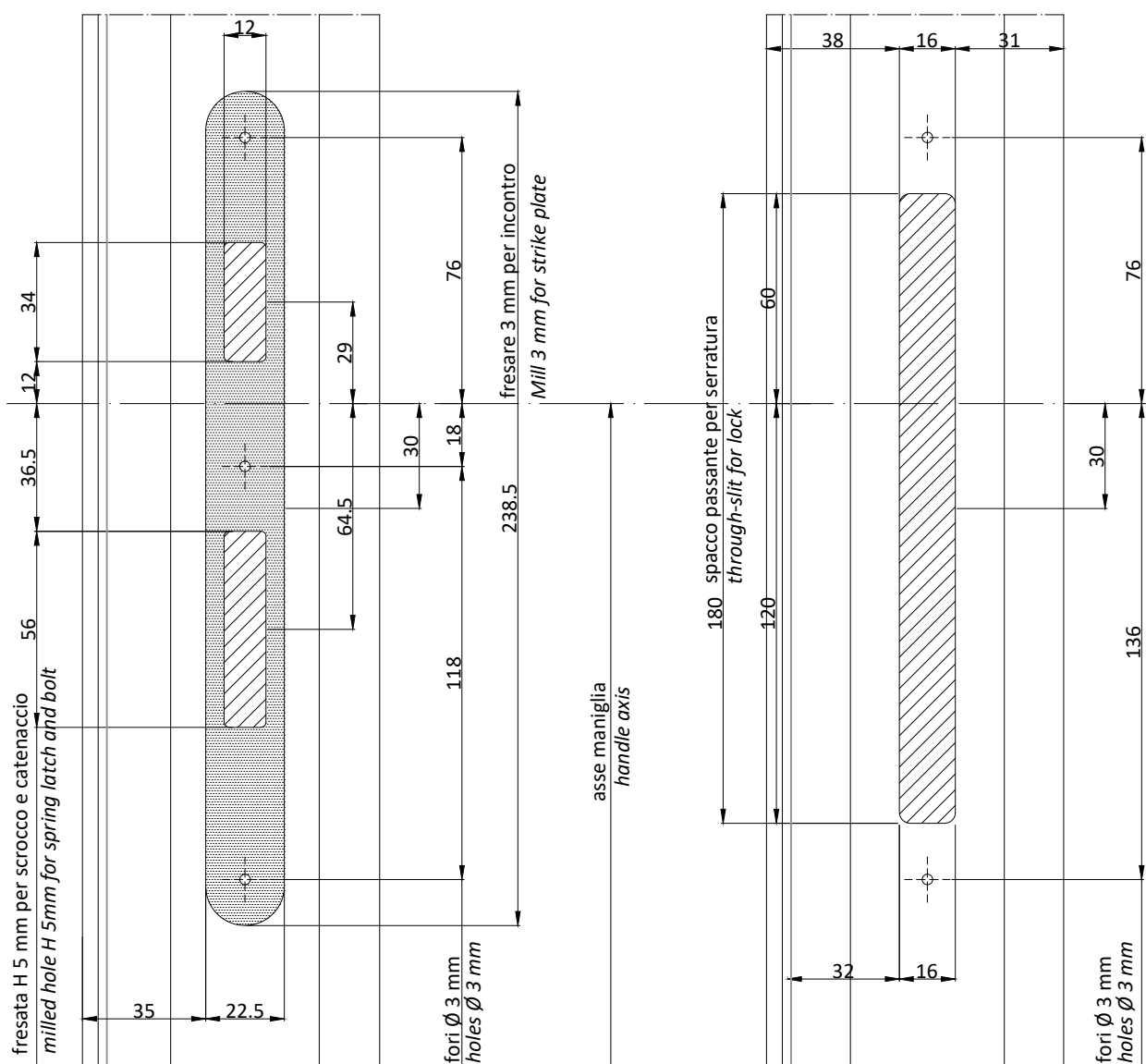
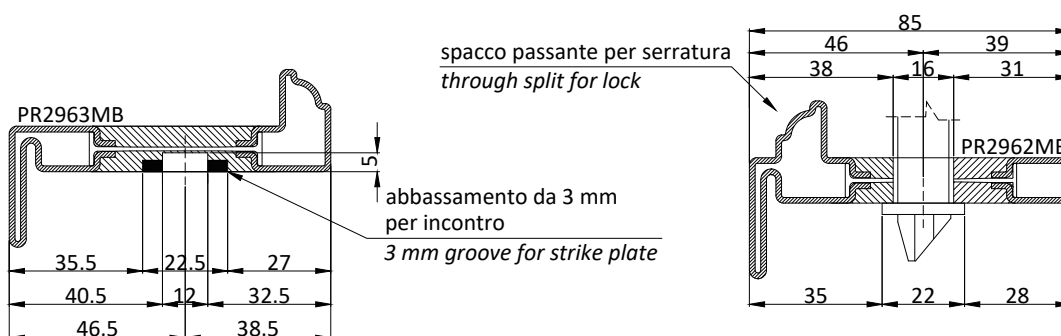
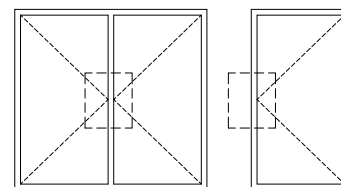
Cod. Cod.	lunghezza guarnizione automatica <i>automatic bottom seal lenght</i>	lunghezza anta <i>leaf width</i>
AC2636/Z	315 - 430 mm	299 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	880 - 1030 mm	864 - 1014 mm
AC2636/G	980 - 1130 mm	964 - 1164 mm
AC2636/H	1080 - 1230 mm	1114 - 1314 mm

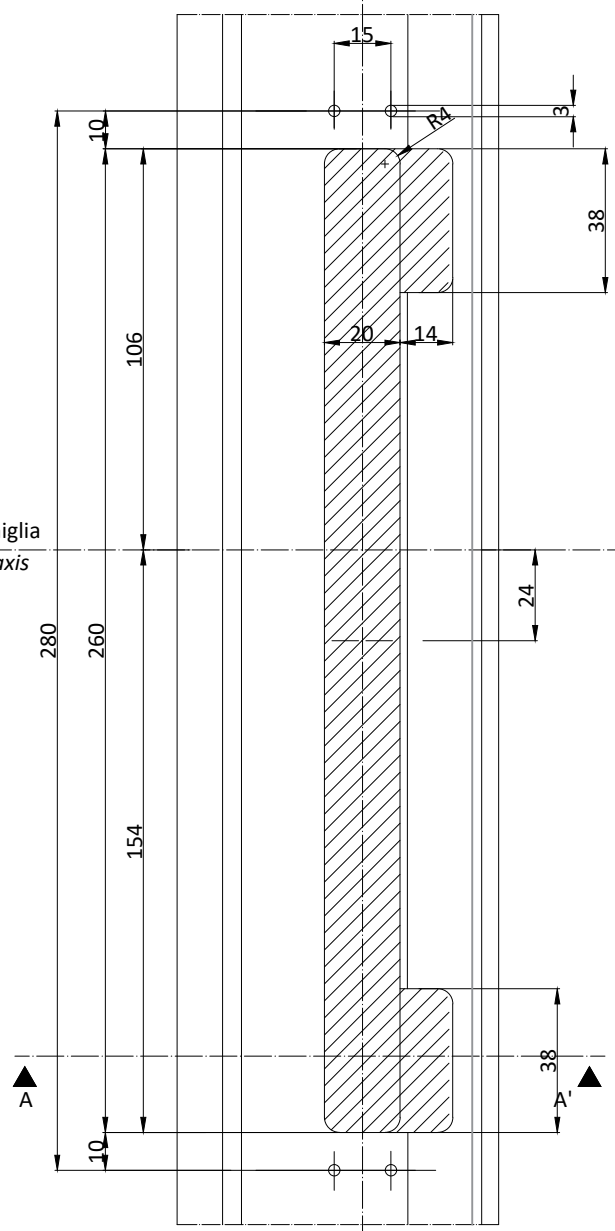
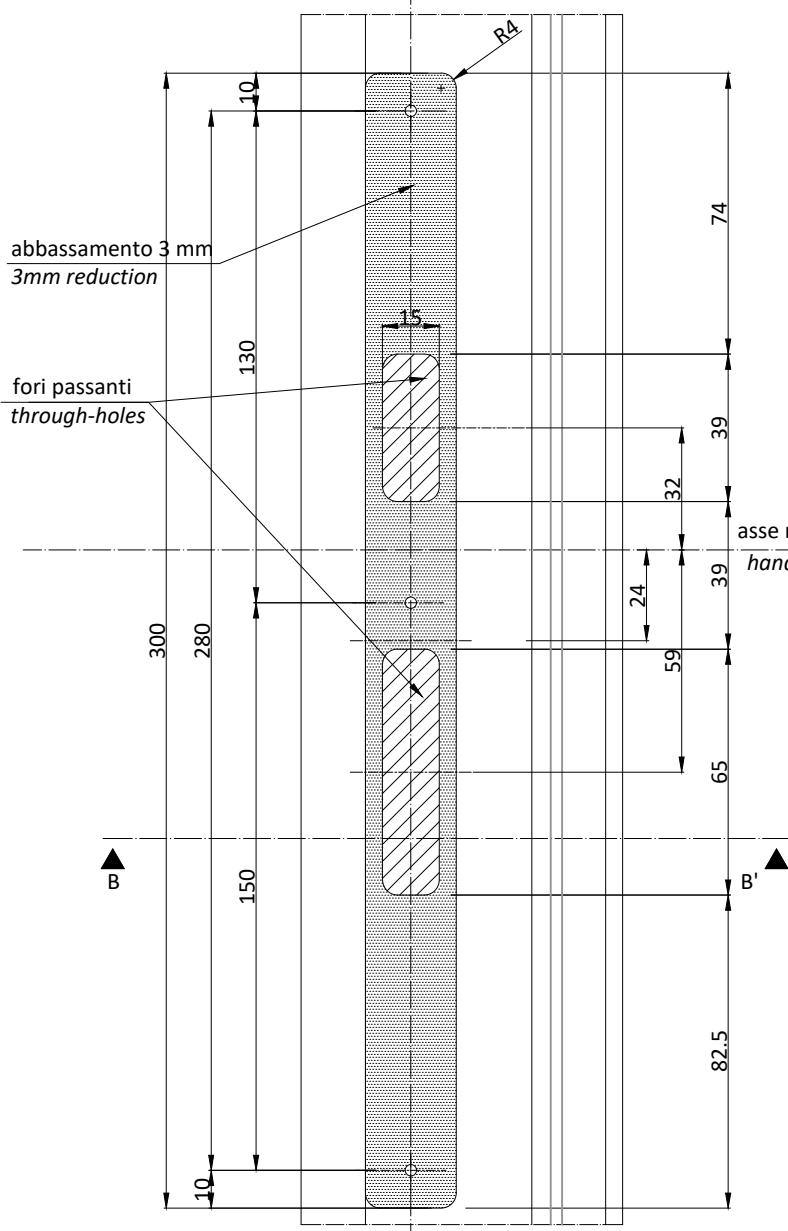
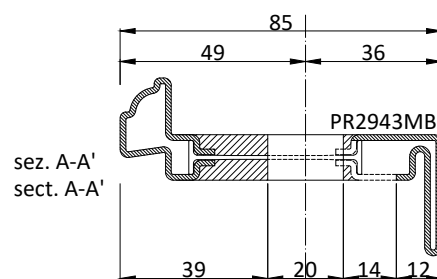
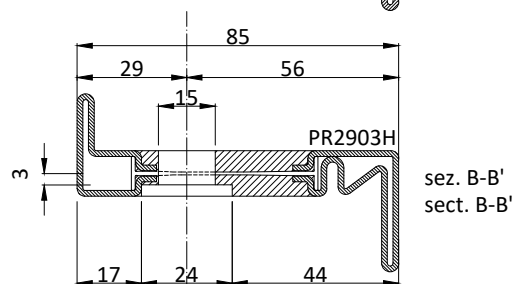
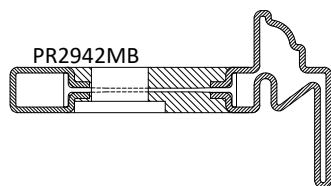
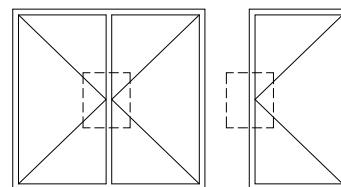


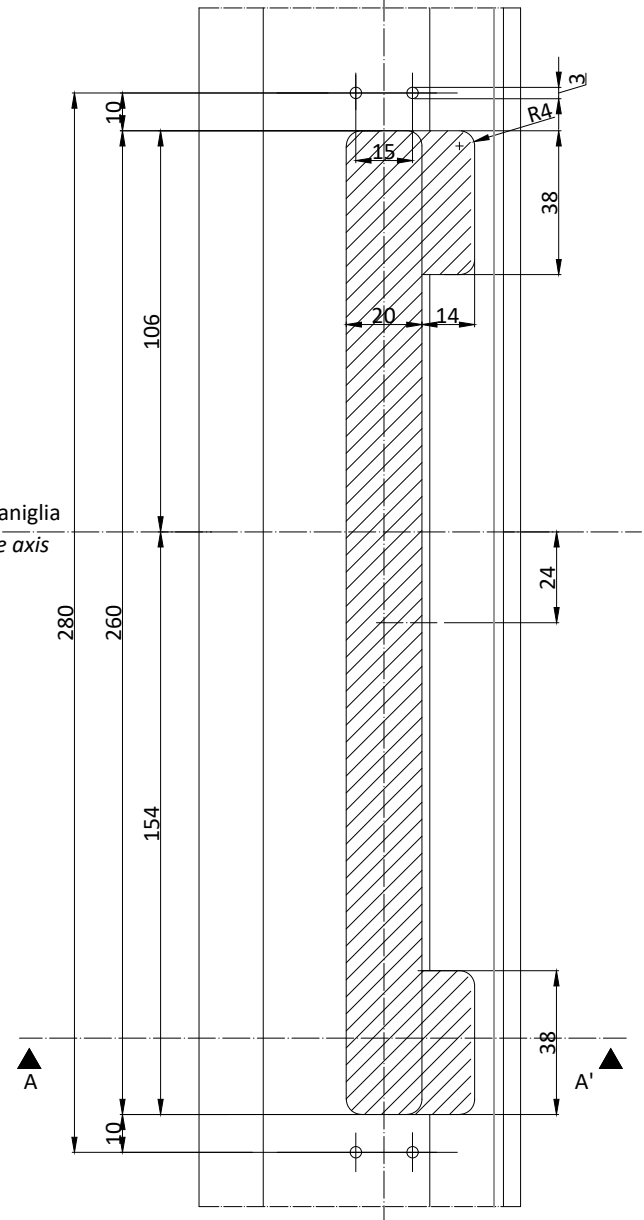
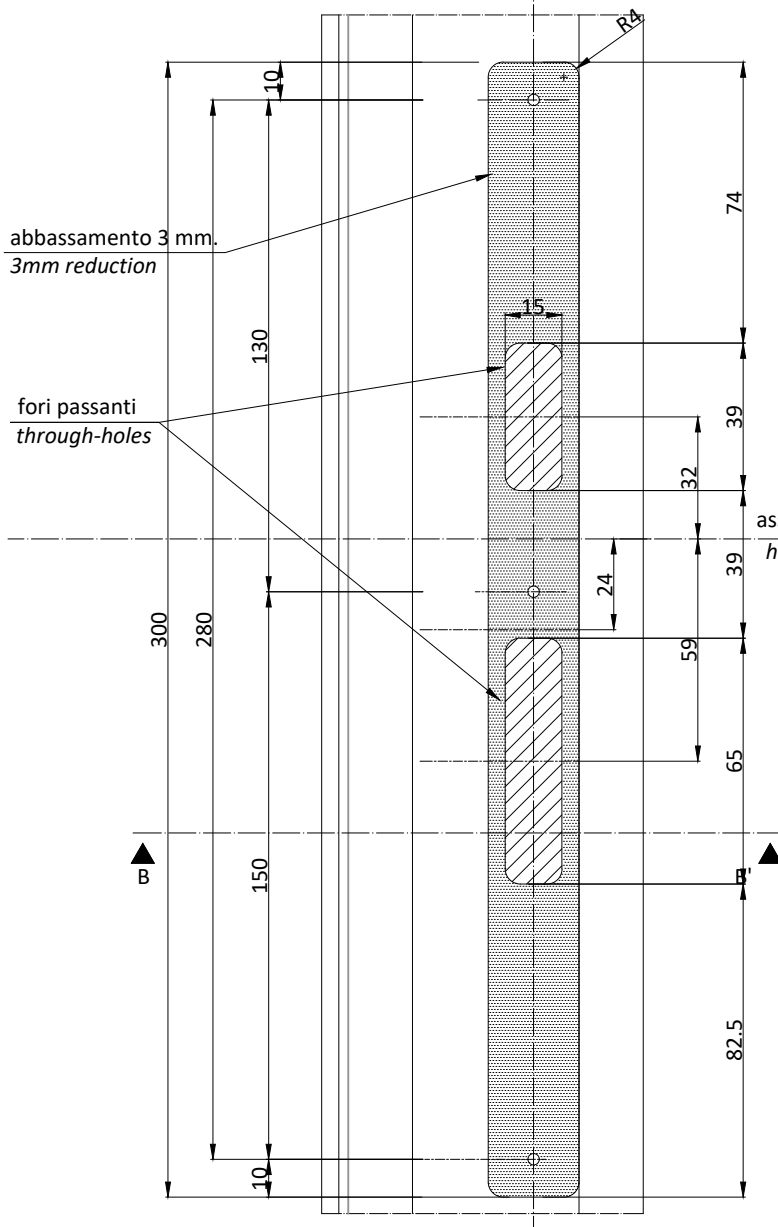
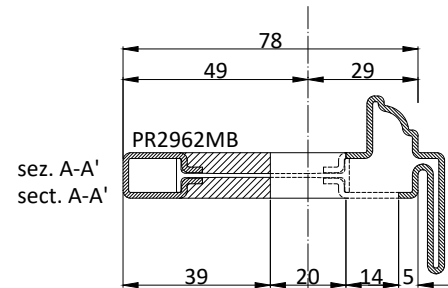
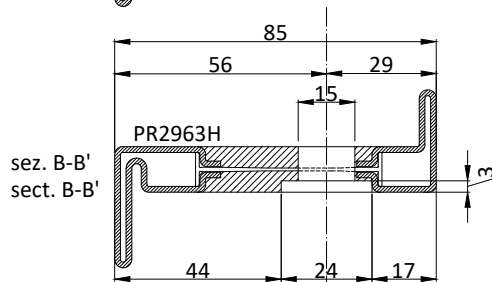
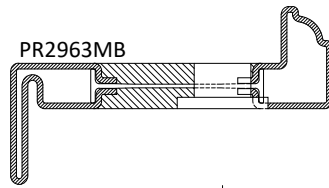
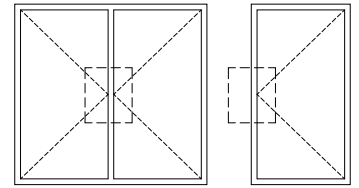
Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2636/Z	315 - 430 mm	299 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	880 - 1030 mm	864 - 1014 mm
AC2636/G	980 - 1130 mm	964 - 1164 mm
AC2636/H	1080 - 1230 mm	1114 - 1314 mm

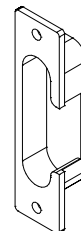
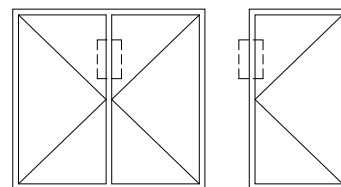
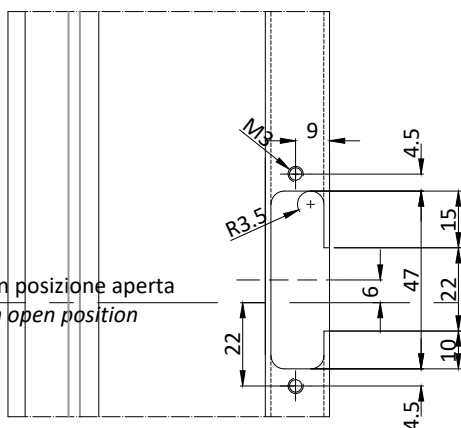
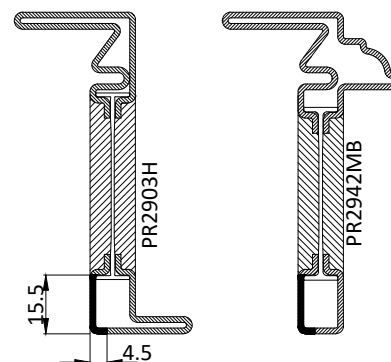
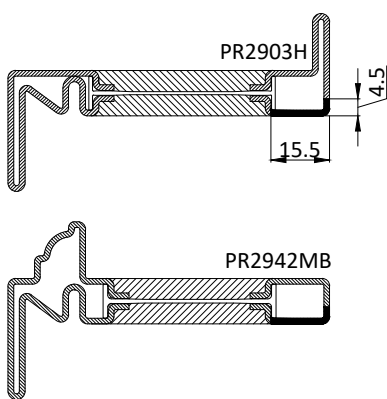
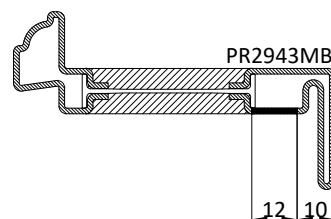
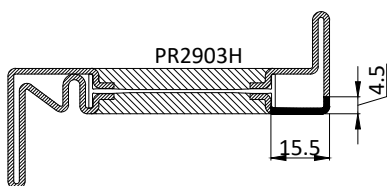
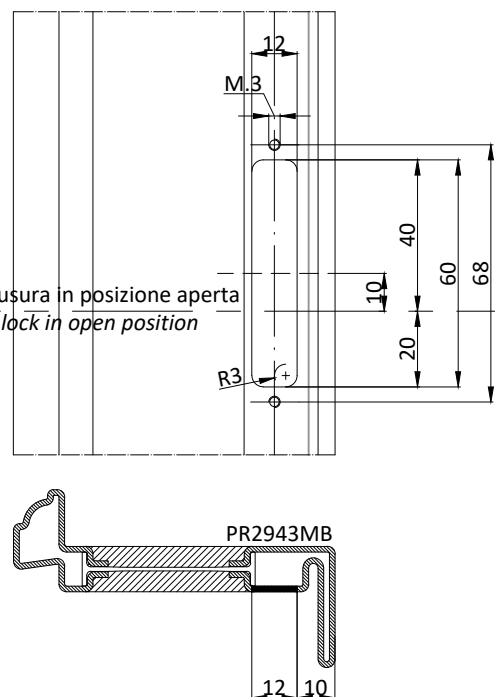
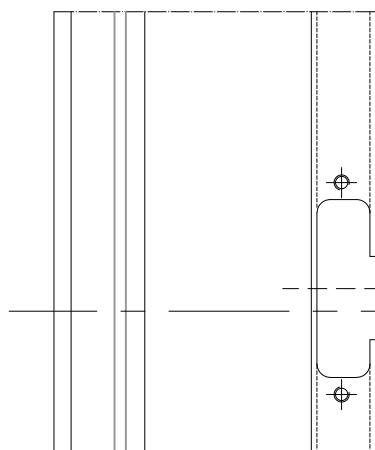






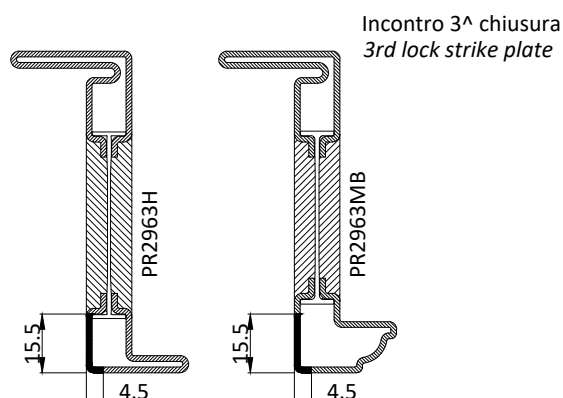
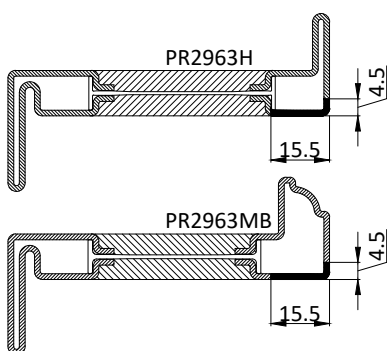
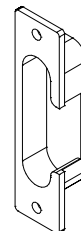
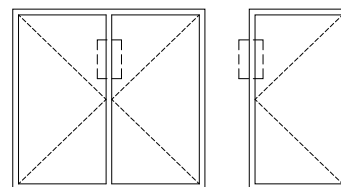
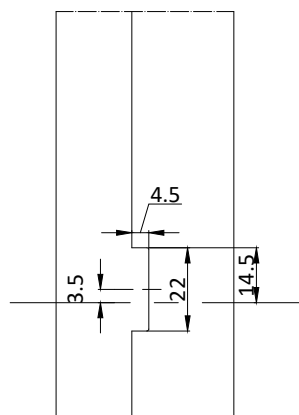
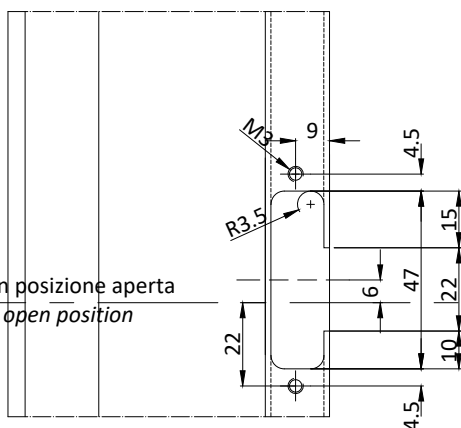




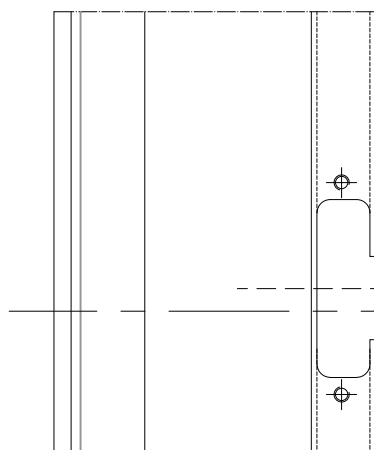
lavorazione applicazione incontro
*Processing strike plate installation*asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open positionIncontro 3^a chiusura
3rd lock strike platelavorazione applicazione nottolino
*Processing for the assembling of the 3rd lock*asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open positionlavorazione superiore-inferiore specchiata orizzontalmente
upper working-bottom working horizontally mirrored

lavorazione applicazione incontro
processing strike plate installation

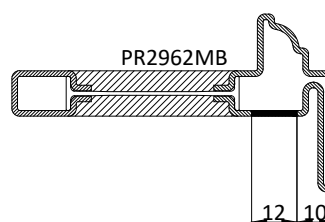
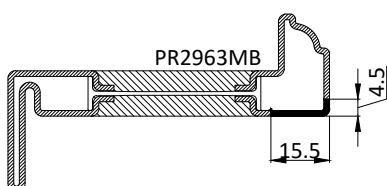
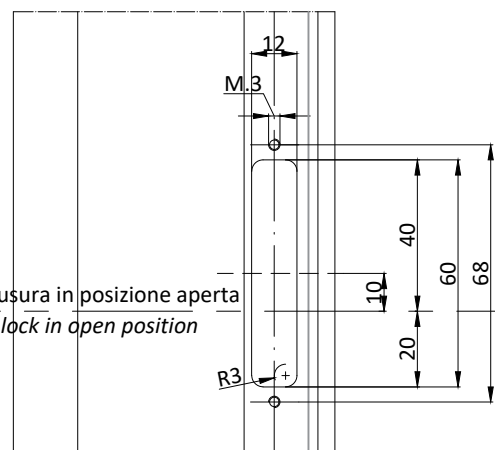
asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open position



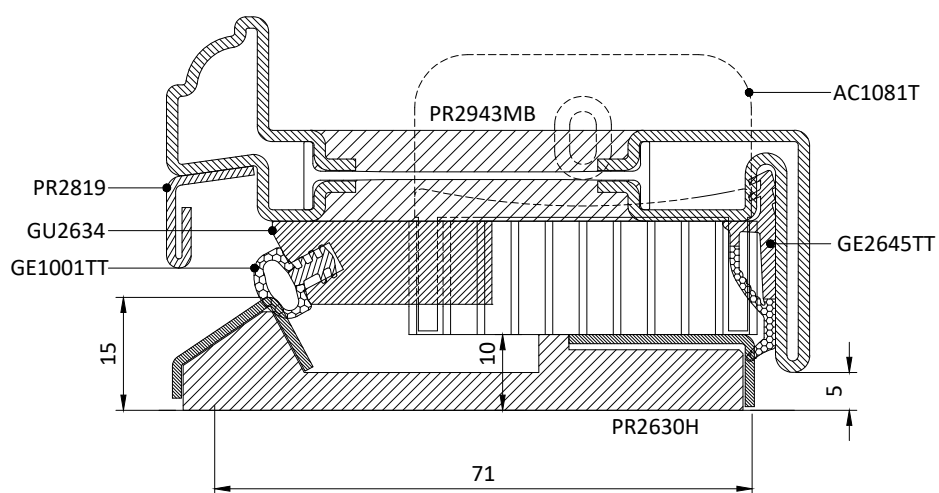
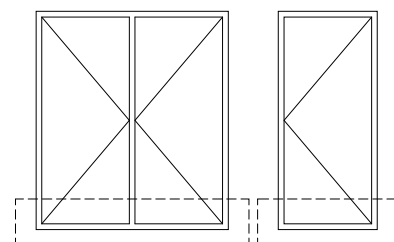
lavorazione applicazione nottolino
processing for the assembling of the 3rd lock

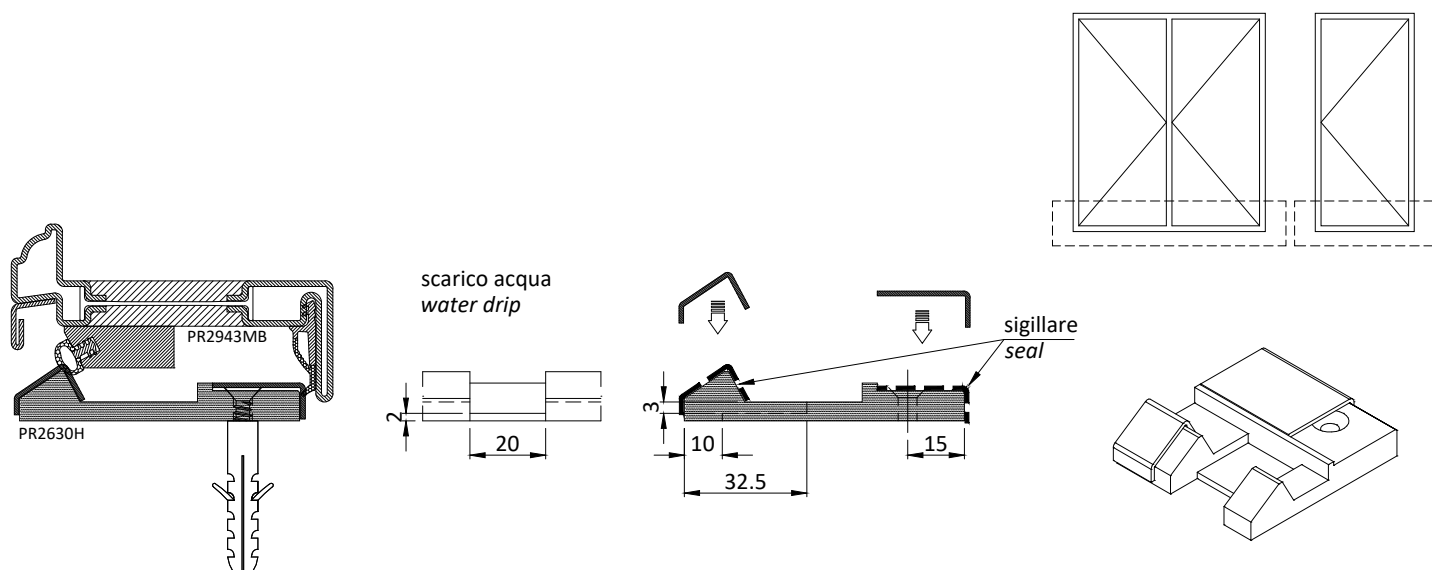


asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open position

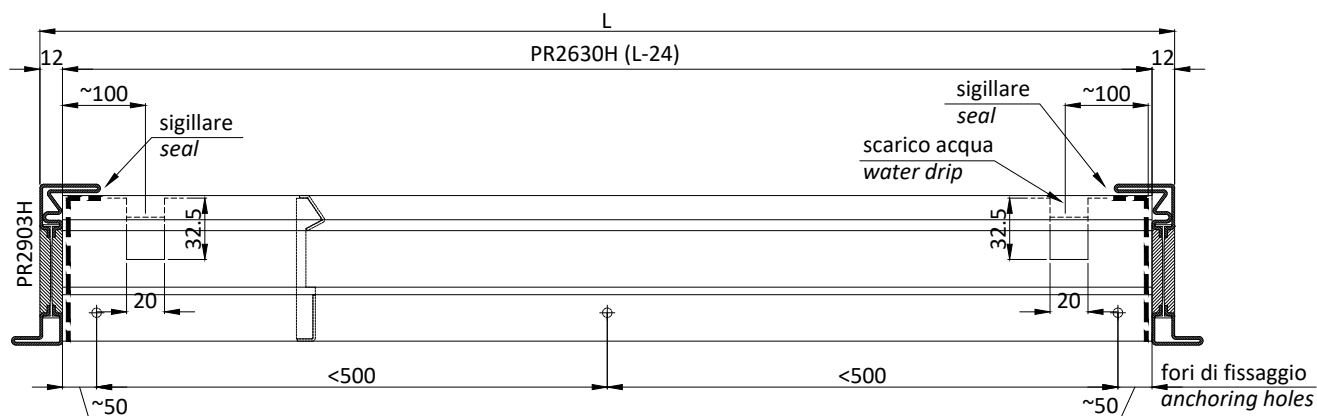


lavorazione superiore; inferiore specchiata orizzontalmente
upper working; bottom working horizontally mirrored

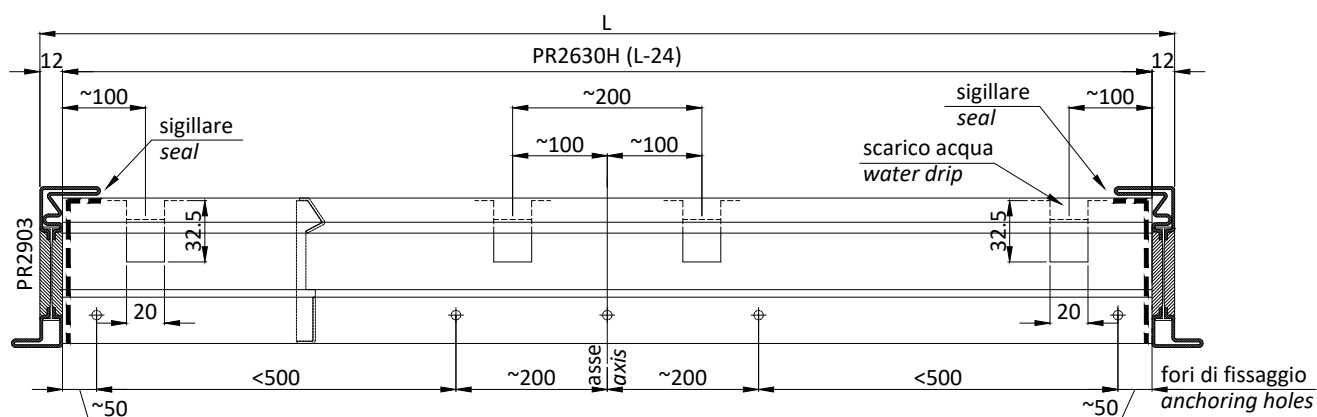


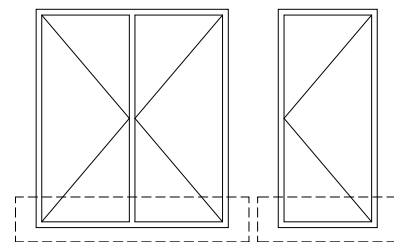
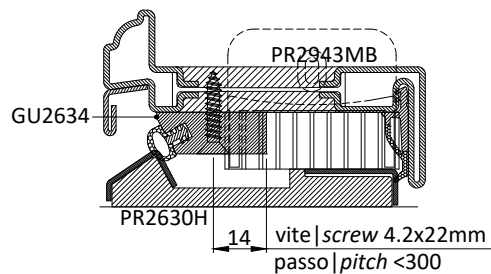


Lavorazione per porta ad 1 anta | Processing for single leaf door

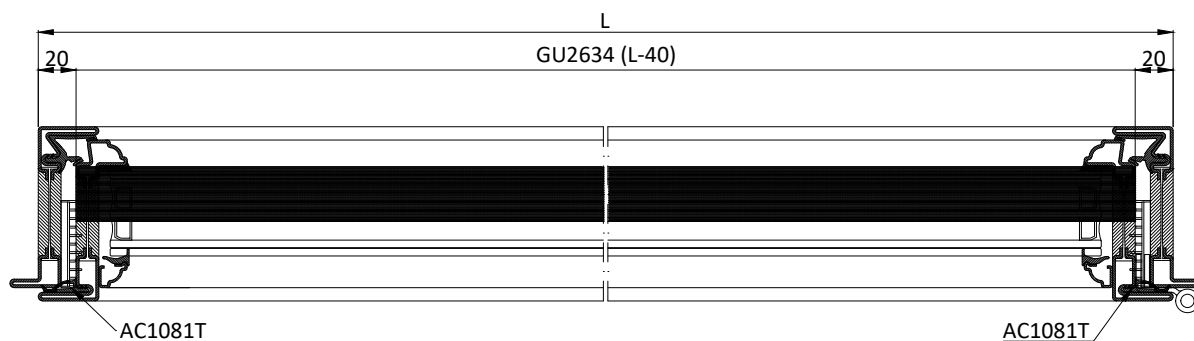


Lavorazione per porta a 2 ante | Processing for double leaf door

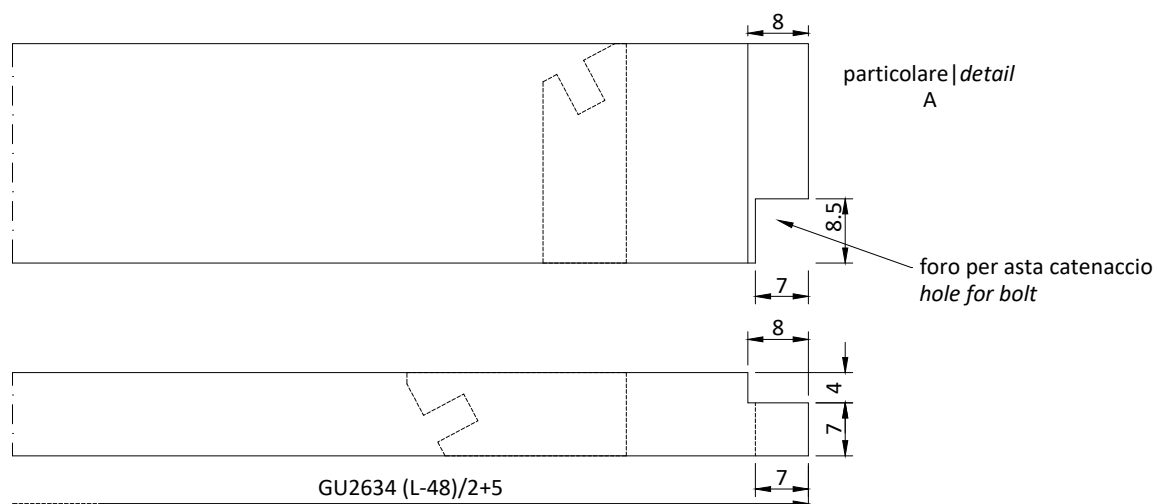
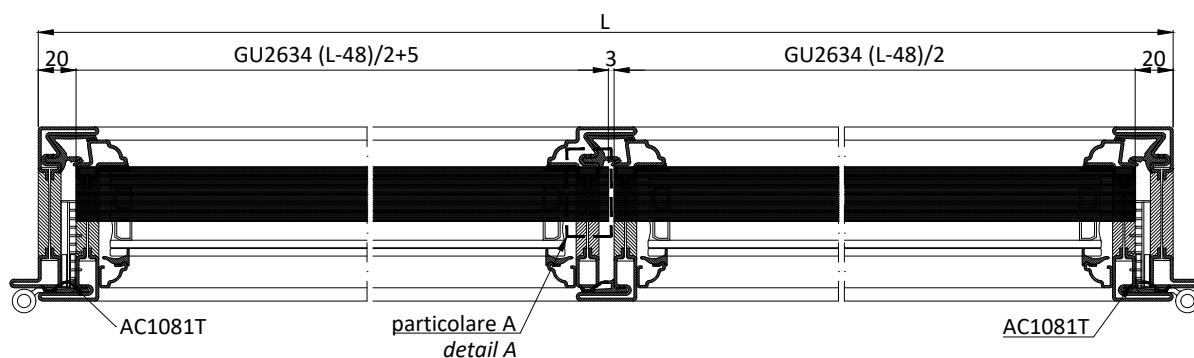


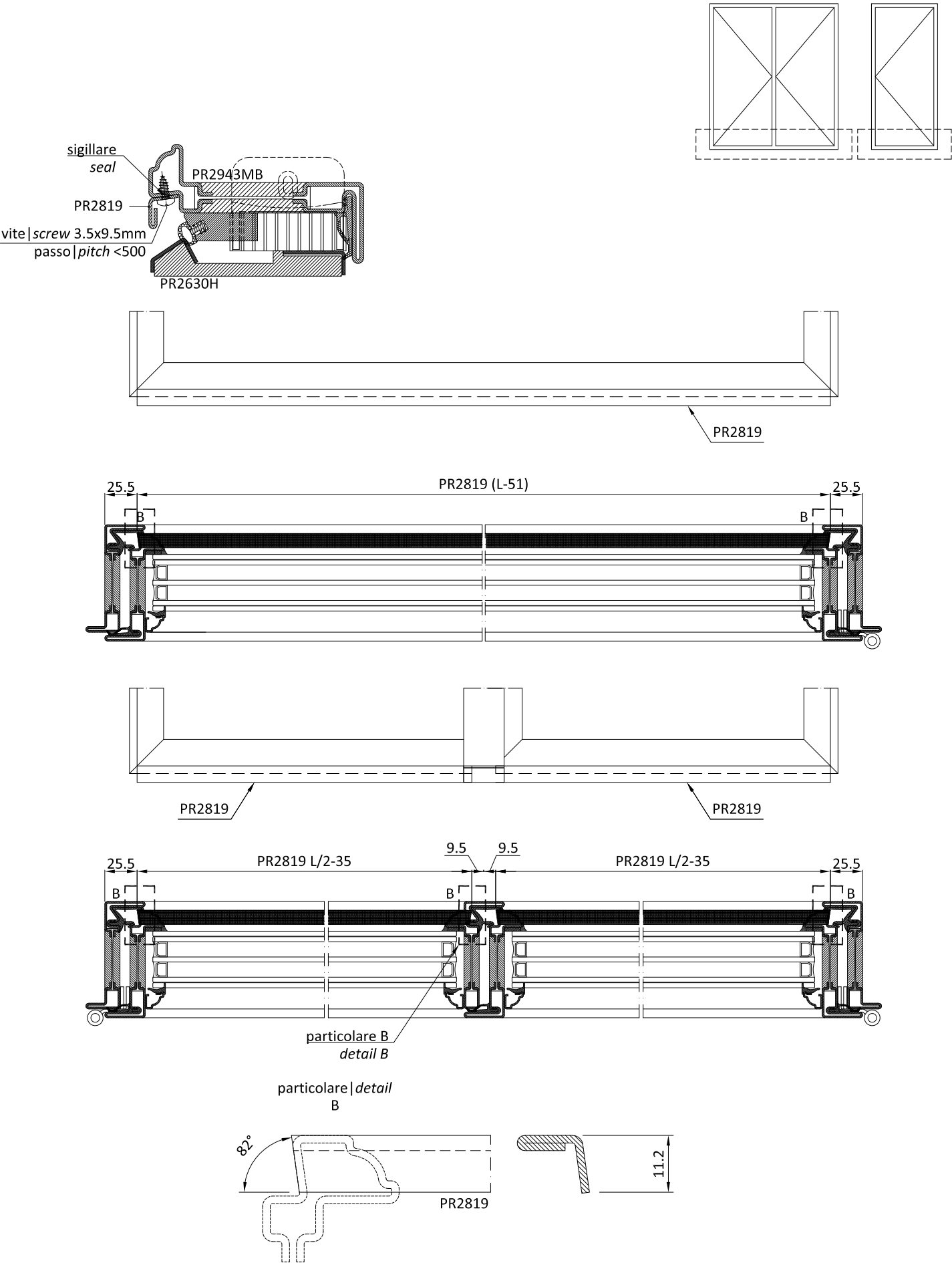


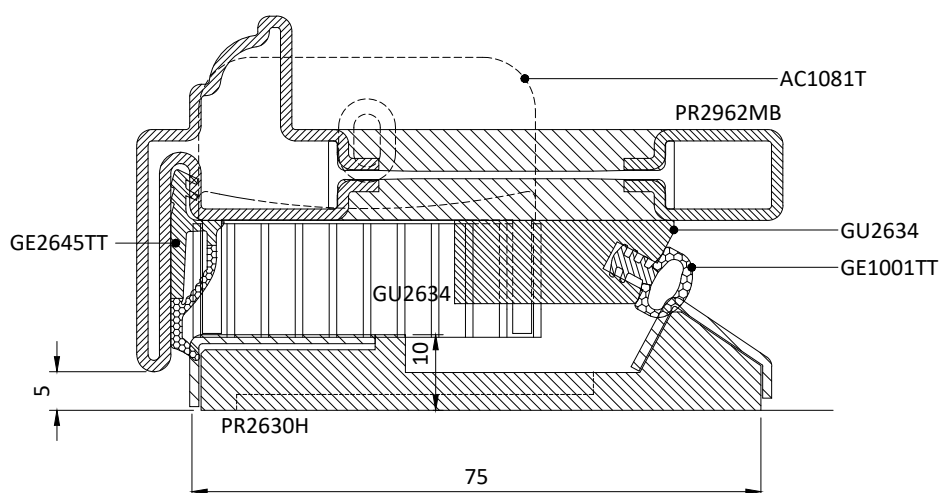
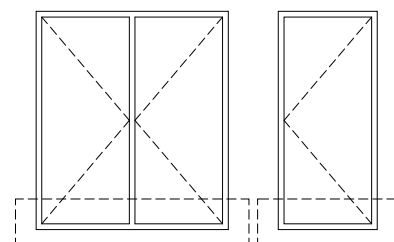
Lavorazione per porta ad 1 anta | Processing for single leaf door

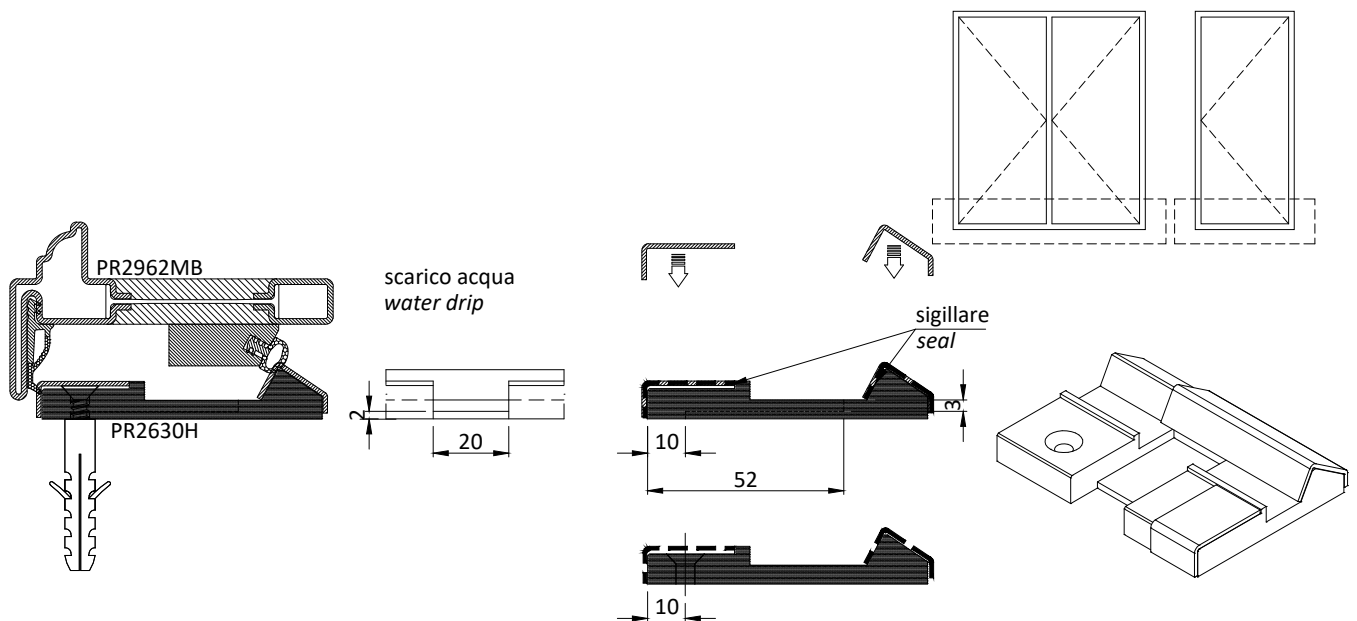


Lavorazione per porta a 2 ante | Processing for double leaf door

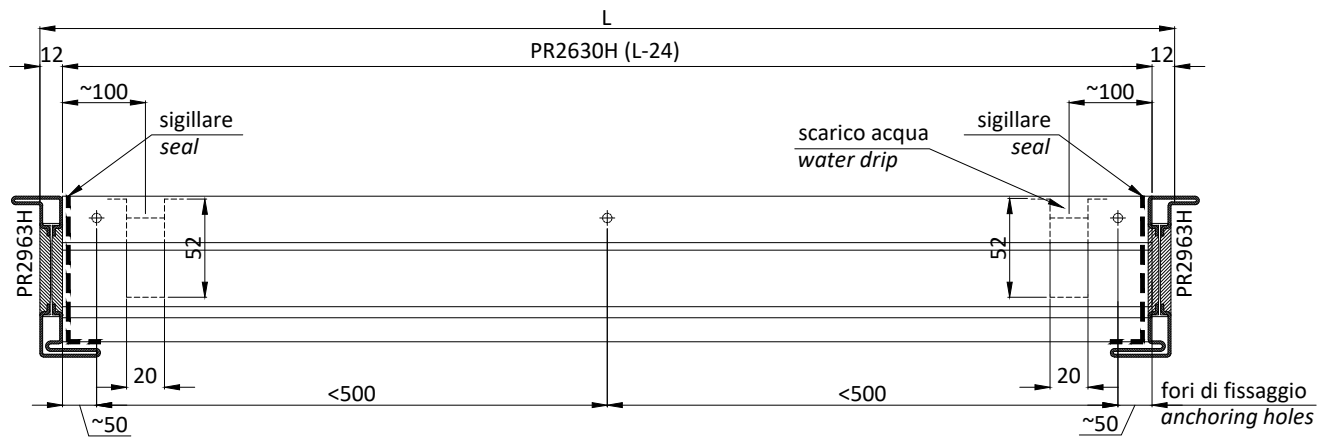




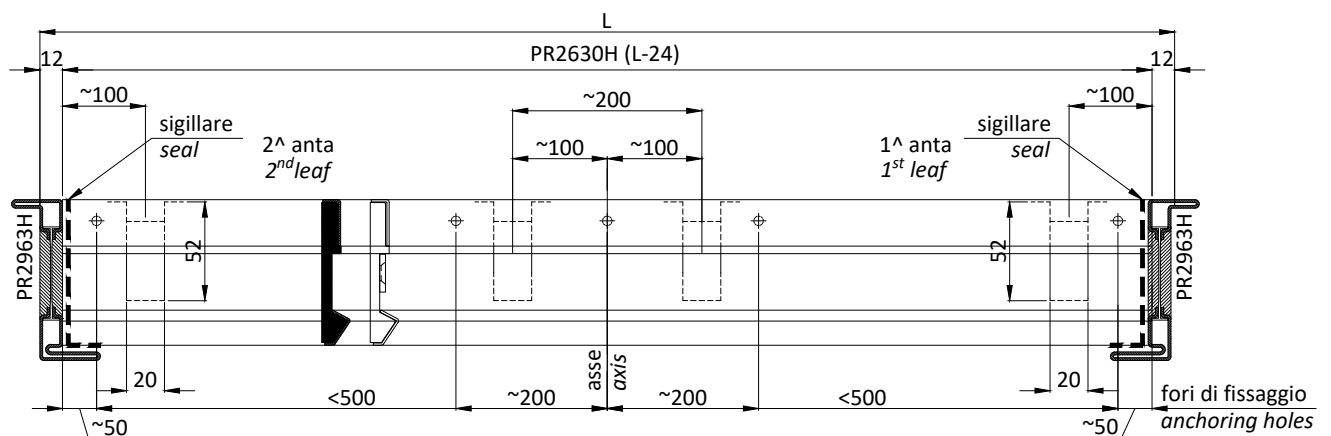


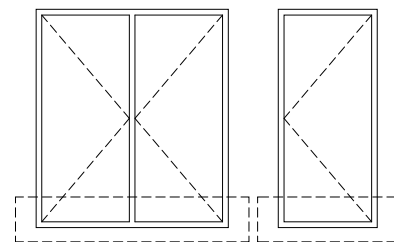
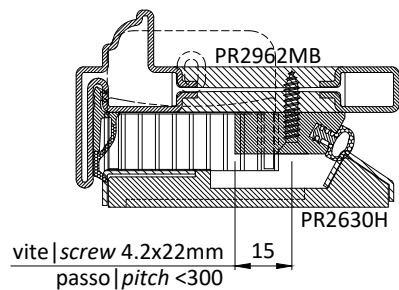


Lavorazione per porta ad 1 anta | Processing for single leaf door

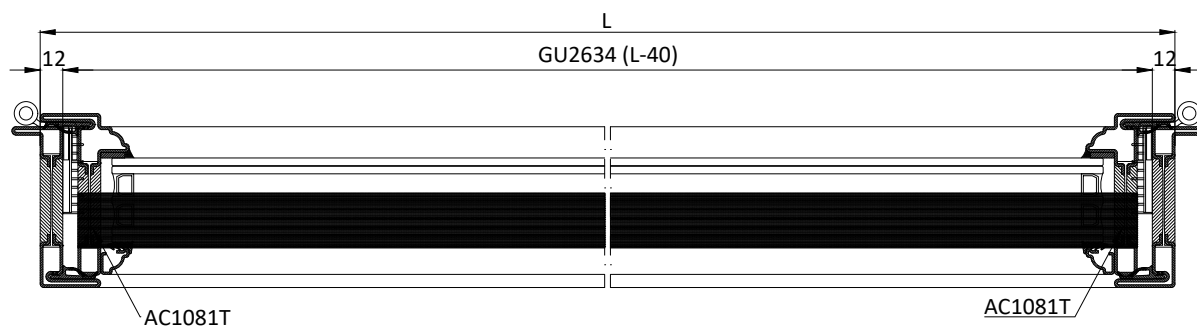


Lavorazione per porta a 2 ante | Processing for double leaf door

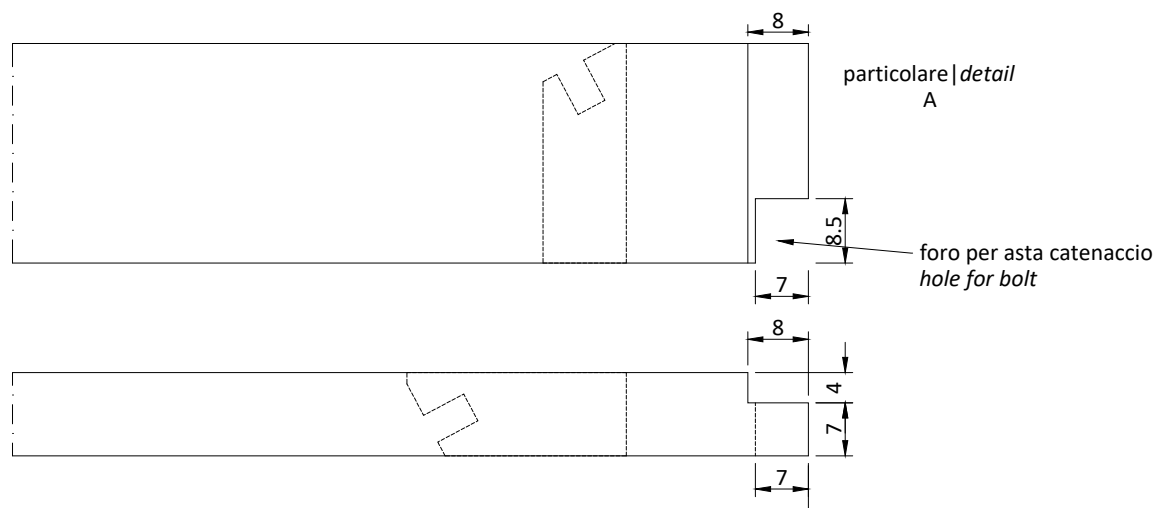
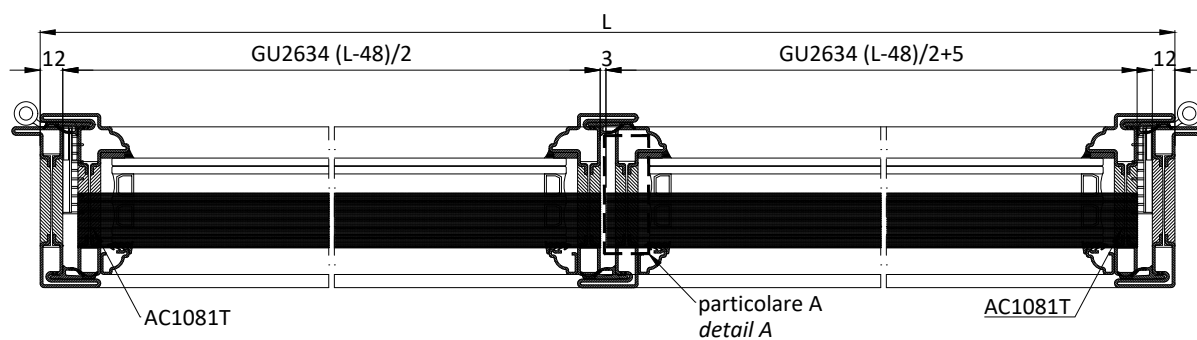


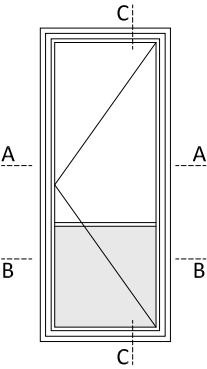


Lavorazione per porta ad 1 anta | Processing for single leaf door



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



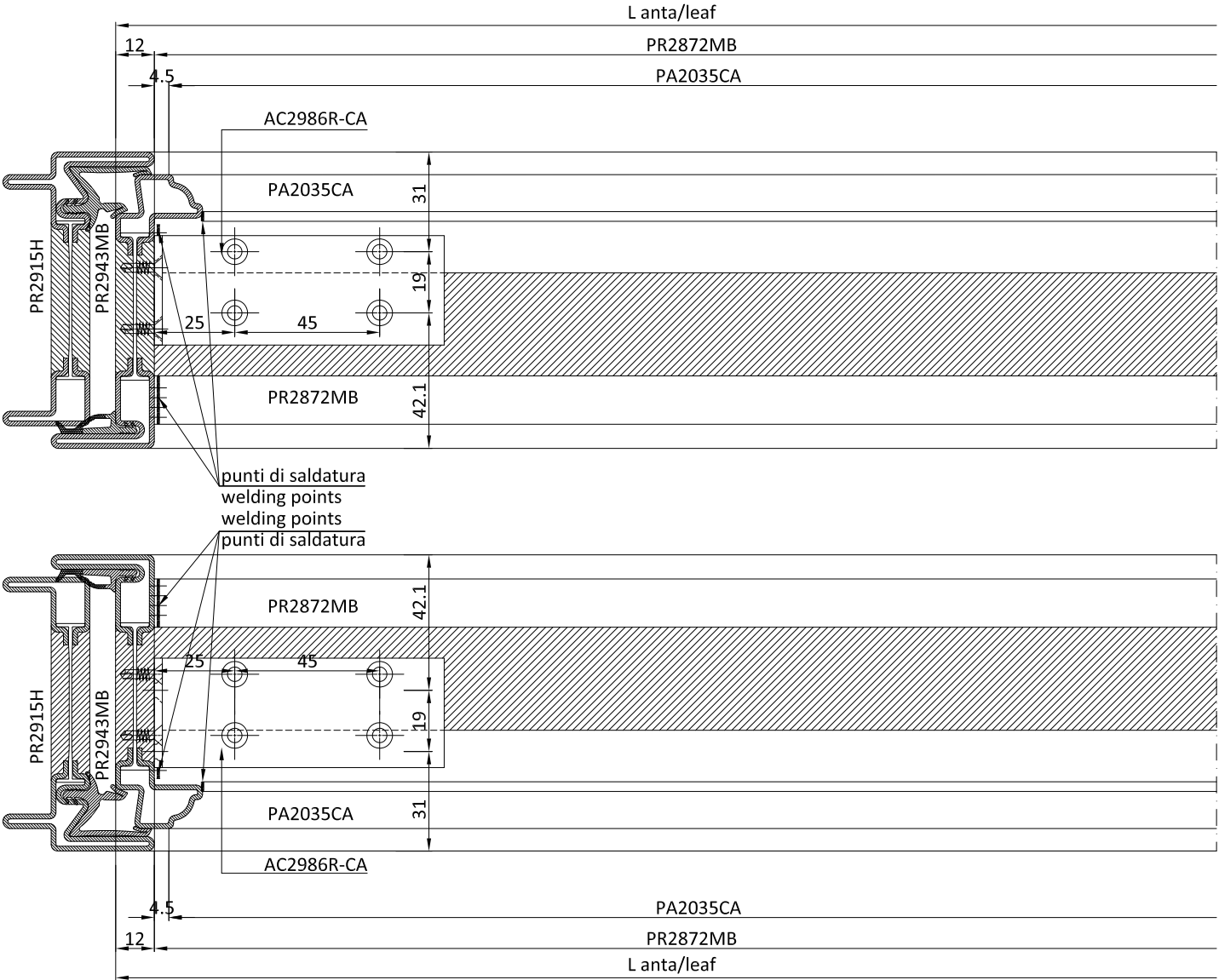


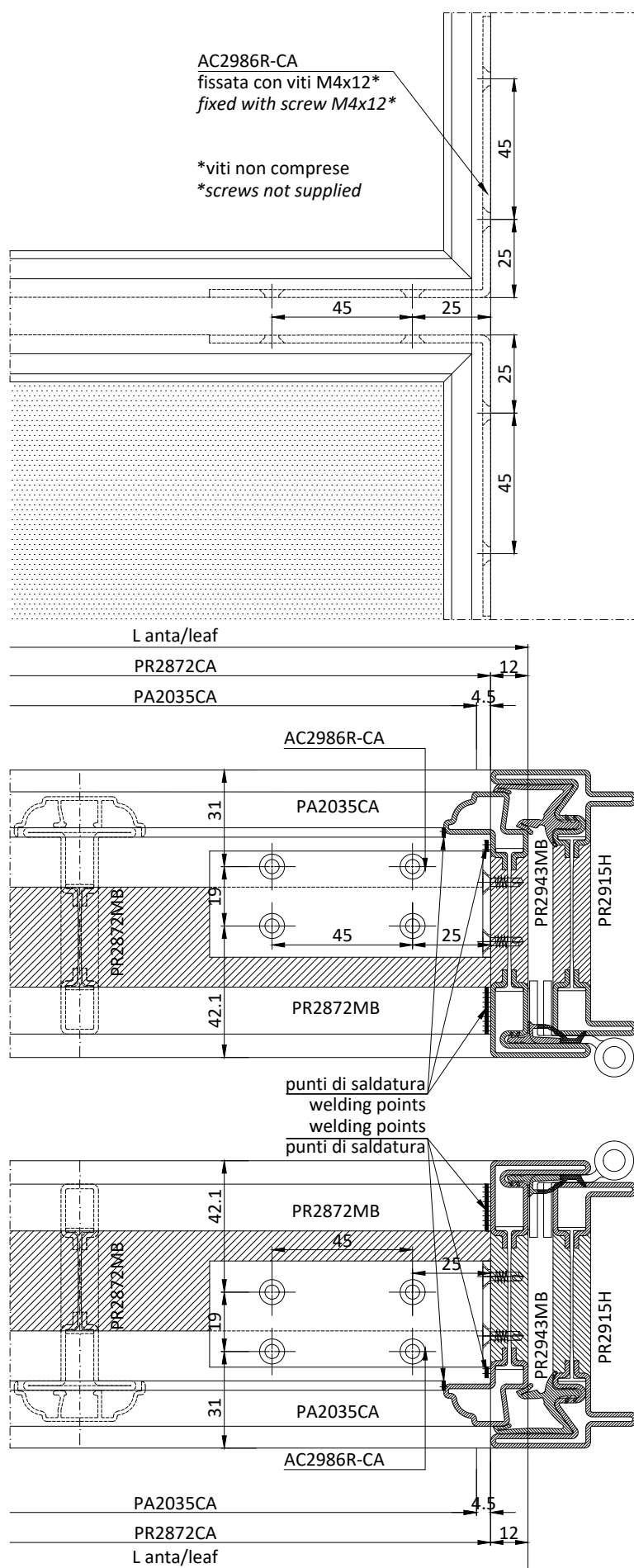
PROFILI		PROFILES					
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting	
Anta		Leaf					
PR2872CA	Profilo a "T" trasverso	"T" profile leaf	1	L-24	90°	90°	
Dividivetri		Glazing dividers					
PA2035CA	Profilo dividivetro	Glazing divider profile	1	L-33	fresatura	milling	

ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2986R-CA	Squadretta interna di assiemaggio	Assembling corner bracket	4
CV5012	Boccola per fermavetri in alluminio	Bushing for aluminium glazing bleed	var.
CV1023	Vite per boccola fermavetri	Screw for glazingbead bushing	var.

*viti per fissaggio staffe non comprese
*screws for brackets fixing not supplied

**AC2986R-CA non fornite da Secco
**AC2986R-CA not supplied by Secco

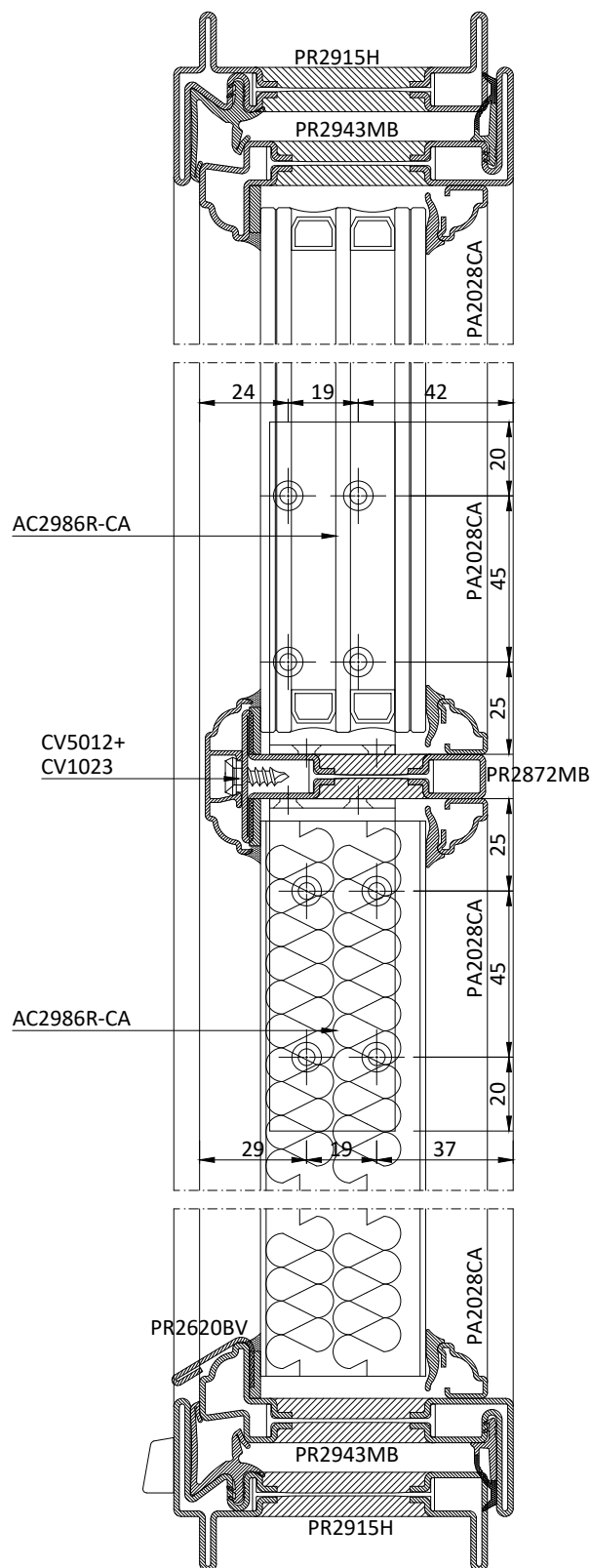


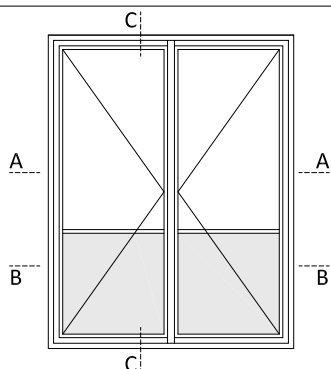


scaricare sulle due teste
per i primi 15 mm

mill the two
ends for 15 mm

3



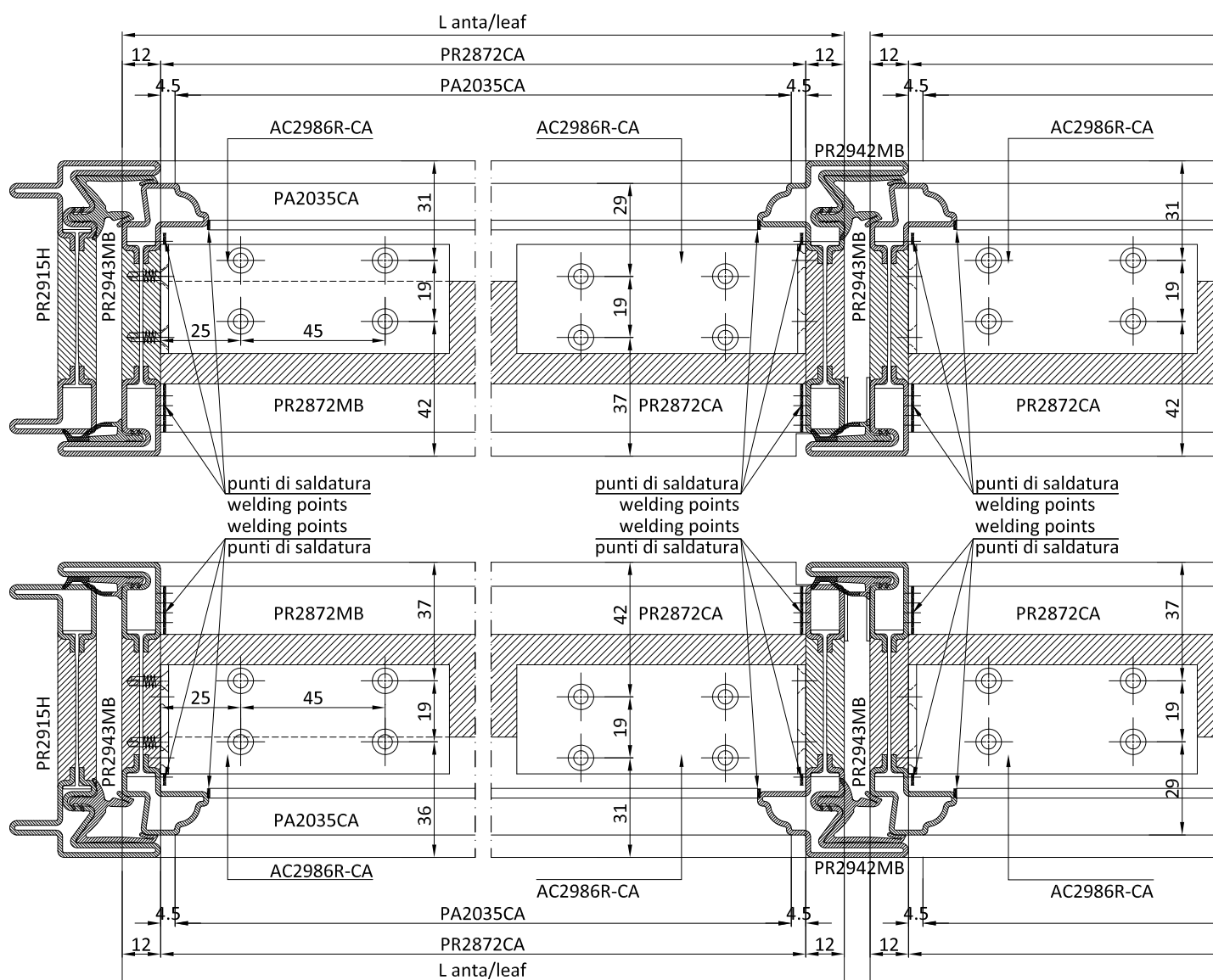


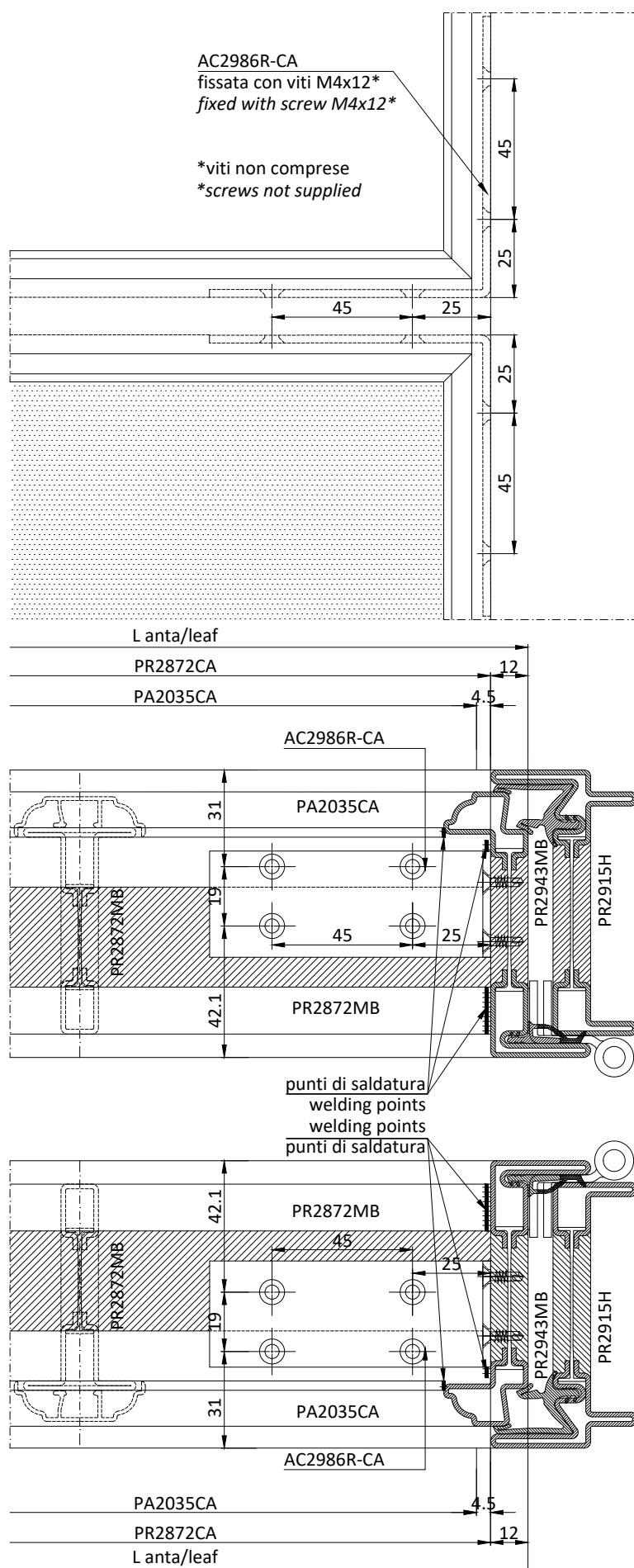
PROFILI		PROFILES					
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting	
Anta		Leaf					
PR2872CA	Profilo a "T" trasverso	"T" profile leaf	2	L-24	90°	90°	
Dividivetri		Glazing dividers					
PA2035CA	Profilo dividivetro	Glazing divider profile	2	L-33	fresatura	milling	

ACCESSORI		HARDWARE		
Cod.	Descrizione	Description	n°	
AC2986R-CA	Squadretta interna di assiemaggio	Assembling corner bracket	8	
CV5012	Boccola per fermavetri in alluminio	Bushing for aluminium glazing bleed	var.	
CV1023	Vite per boccola fermavetri	Screw for glazingbead bushing	var.	

*viti per fissaggio staffe non comprese
*screws for brackets fixing not supplied

**AC2986R-CA non fornite da Secco
**AC2986R-CA not supplied by Secco

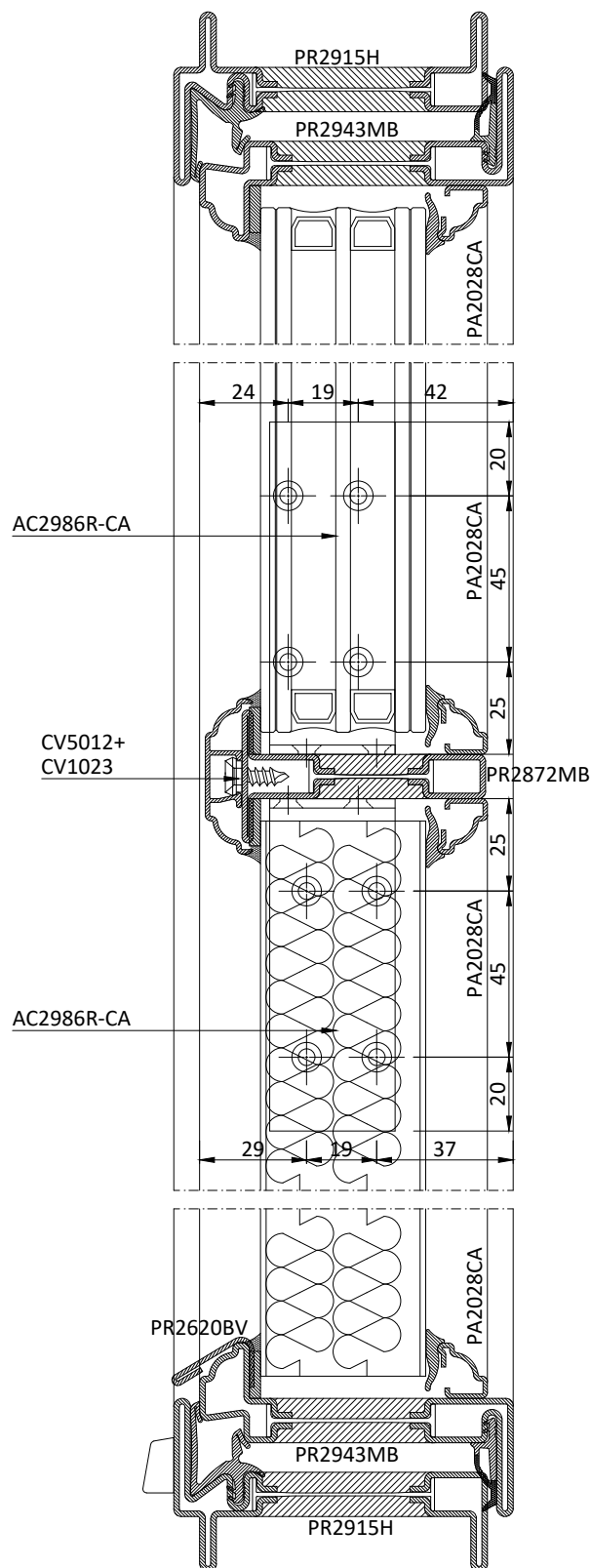


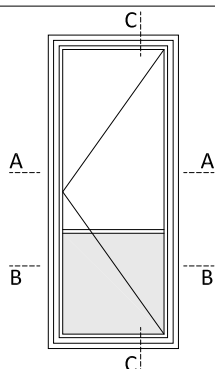


scaricare sulle due teste
per i primi 15 mm

mill the two
ends for 15 mm

3



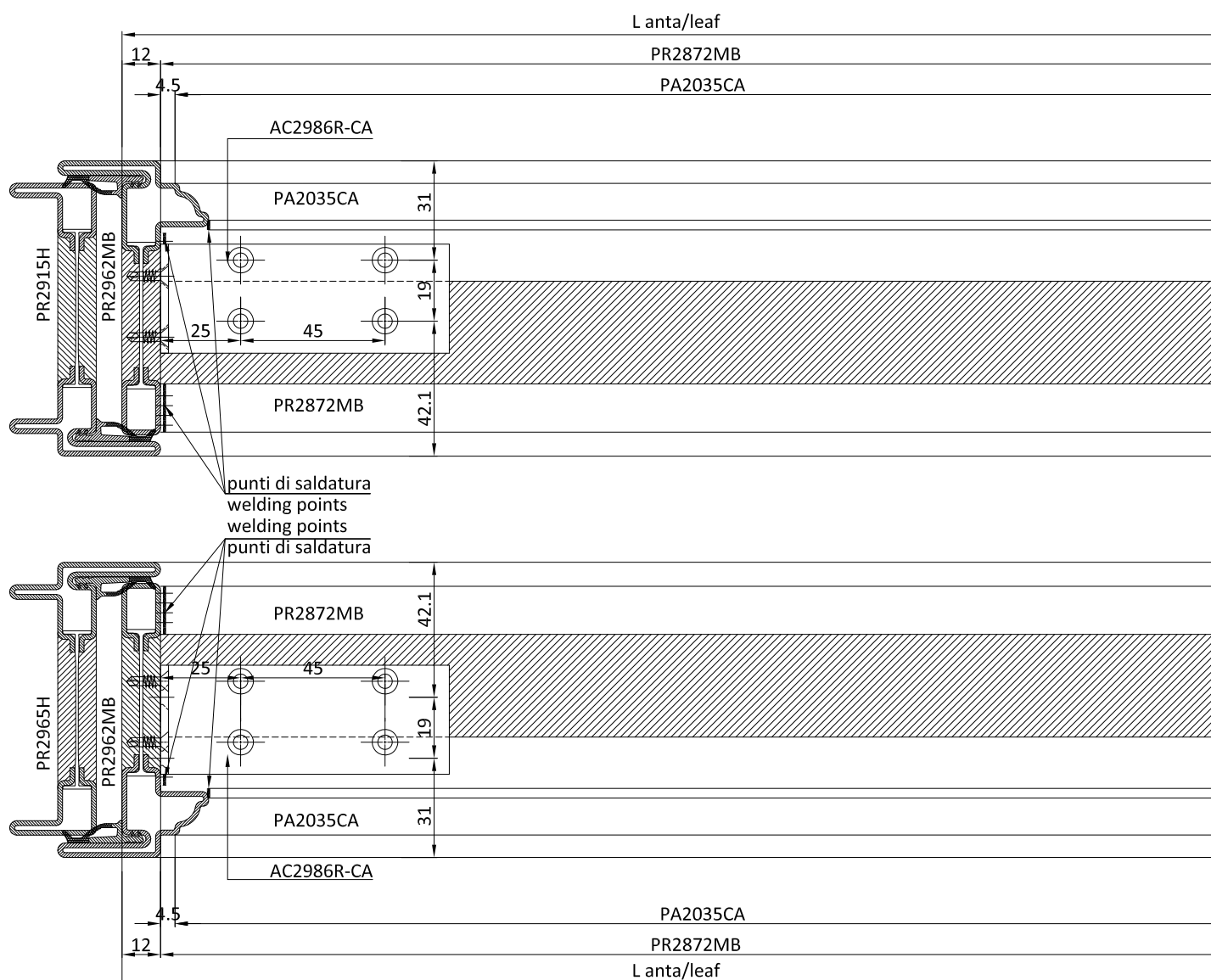


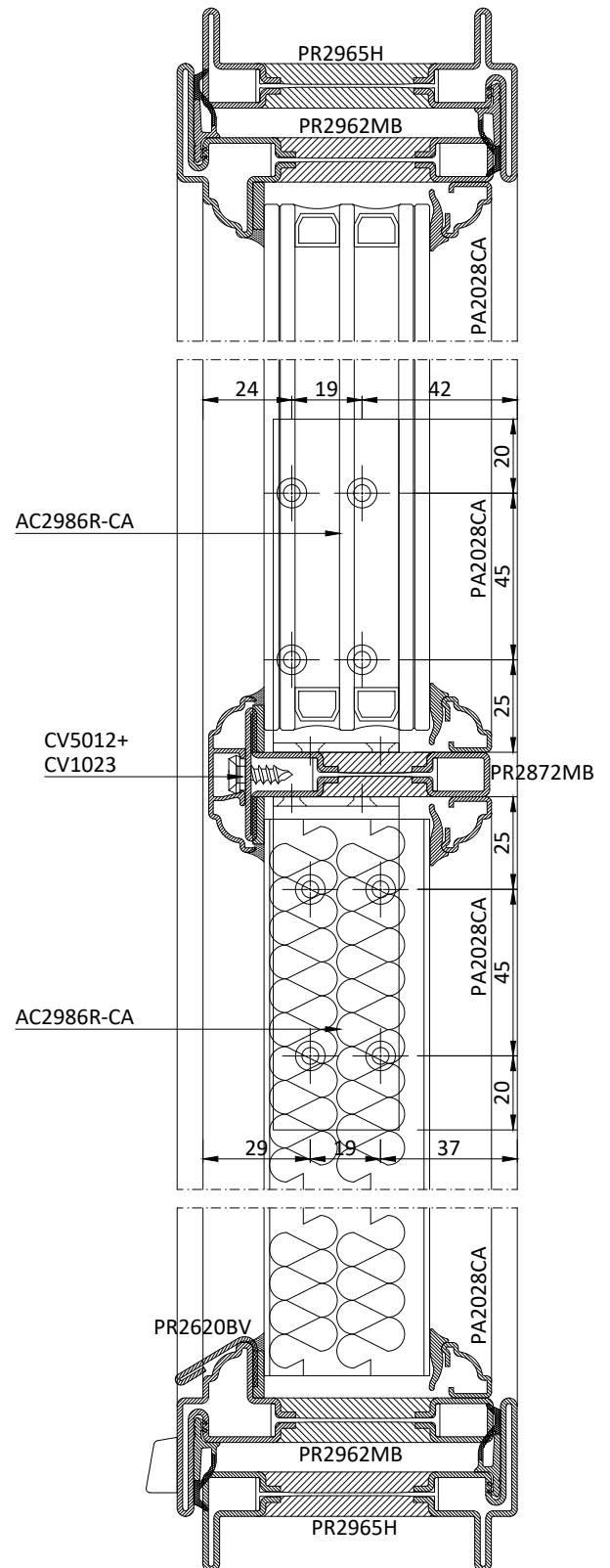
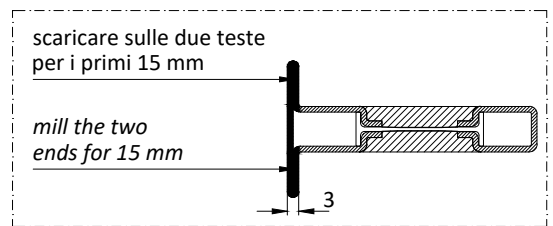
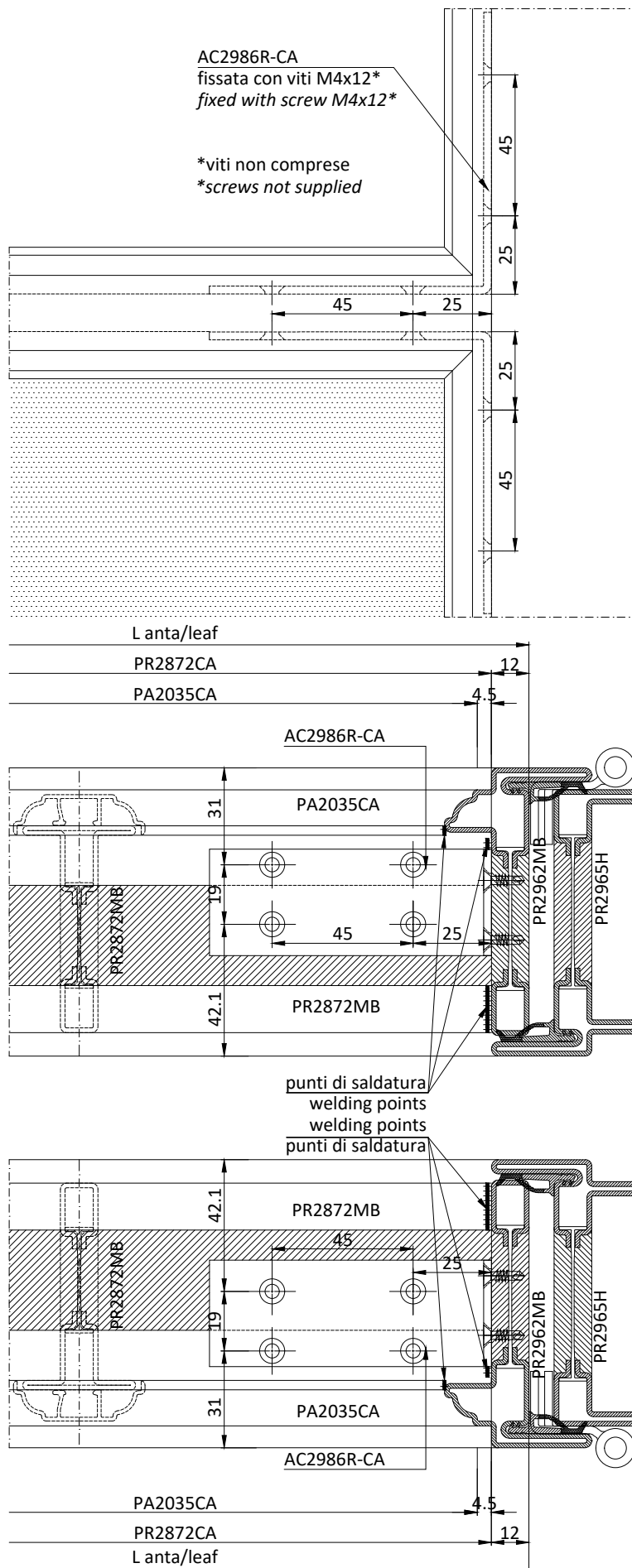
PROFILI		PROFILES					
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting	
Anta		Leaf					
PR2872CA	Profilo a "T" trasverso	"T" profile leaf	1	L-24	90°	90°	
Dividivetri		Glazing dividers					
PA2035CA	Profilo dividivetro	Glazing divider profile	1	L-33	fresatura	milling	

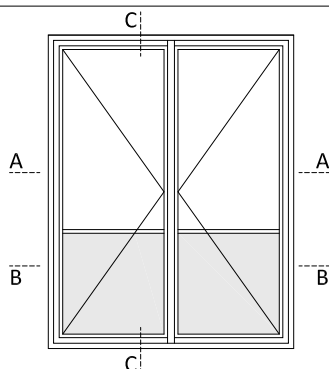
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2986R-CA	Squadretta interna di assiemaggio	Assembling corner bracket	4
CV5012	Boccola per fermavetri in alluminio	Bushing for aluminium glazing bleed	var.
CV1023	Vite per boccola fermavetri	Screw for glazingbead bushing	var.

*viti per fissaggio staffe non comprese
*screws for brackets fixing not supplied

**AC2986R-CA non fornite da Secco
**AC2986R-CA not supplied by Secco





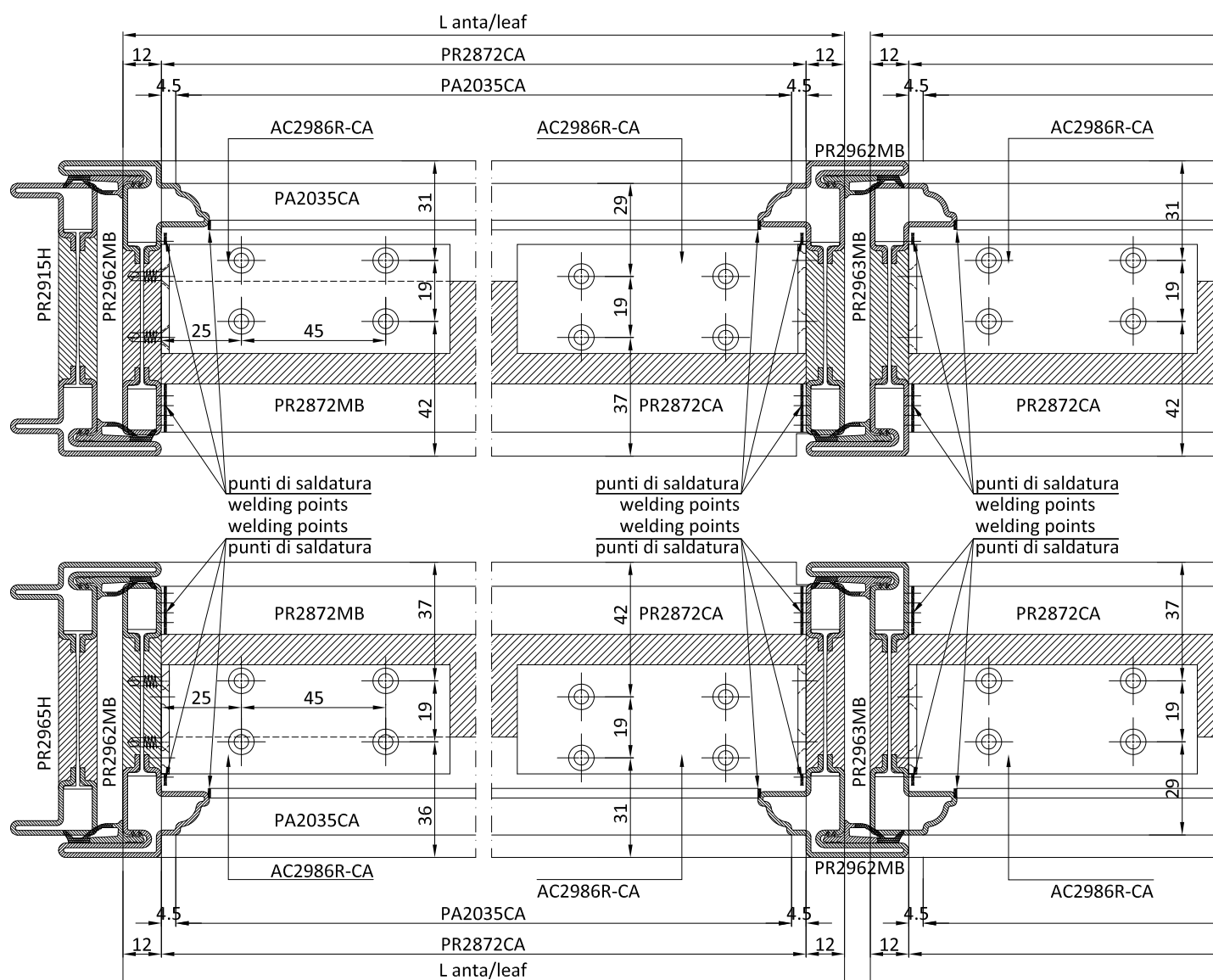


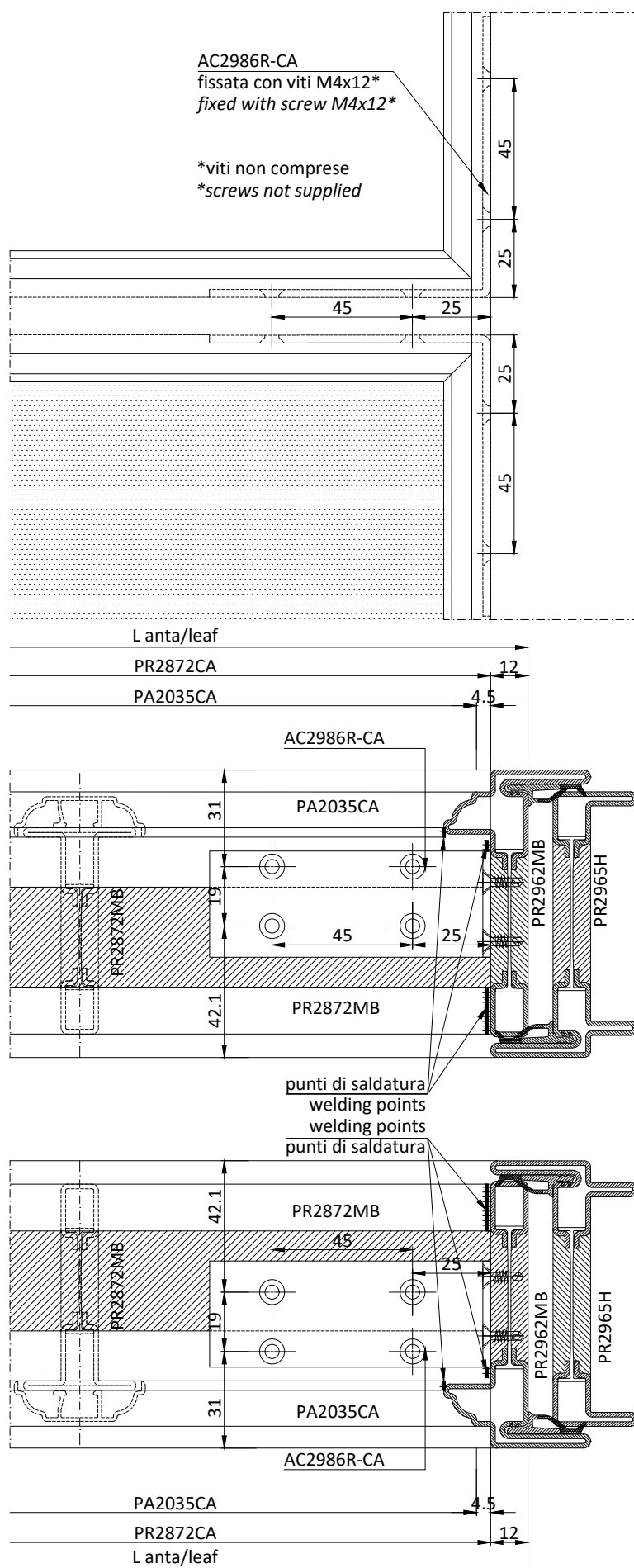
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Anta		Leaf				
PR2872CA	Profilo a "T" trasverso	"T" profile leaf	2	L-24	90°	90°
Dividivetri		Glazing dividers				
PA2035CA	Profilo dividivetro	Glazing divider profile	2	L-33	fresatura	milling

ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2986R-CA	Squadretta interna di assiemaggio	Assembling corner bracket	8
CV5012	Boccola per fermavetri in alluminio	Bushing for aluminium glazing bleed	var.
CV1023	Vite per boccola fermavetri	Screw for glazingbead bushing	var.

*viti per fissaggio staffe non comprese
*screws for brackets fixing not supplied

**AC2986R-CA non fornite da Secco
**AC2986R-CA not supplied by Secco

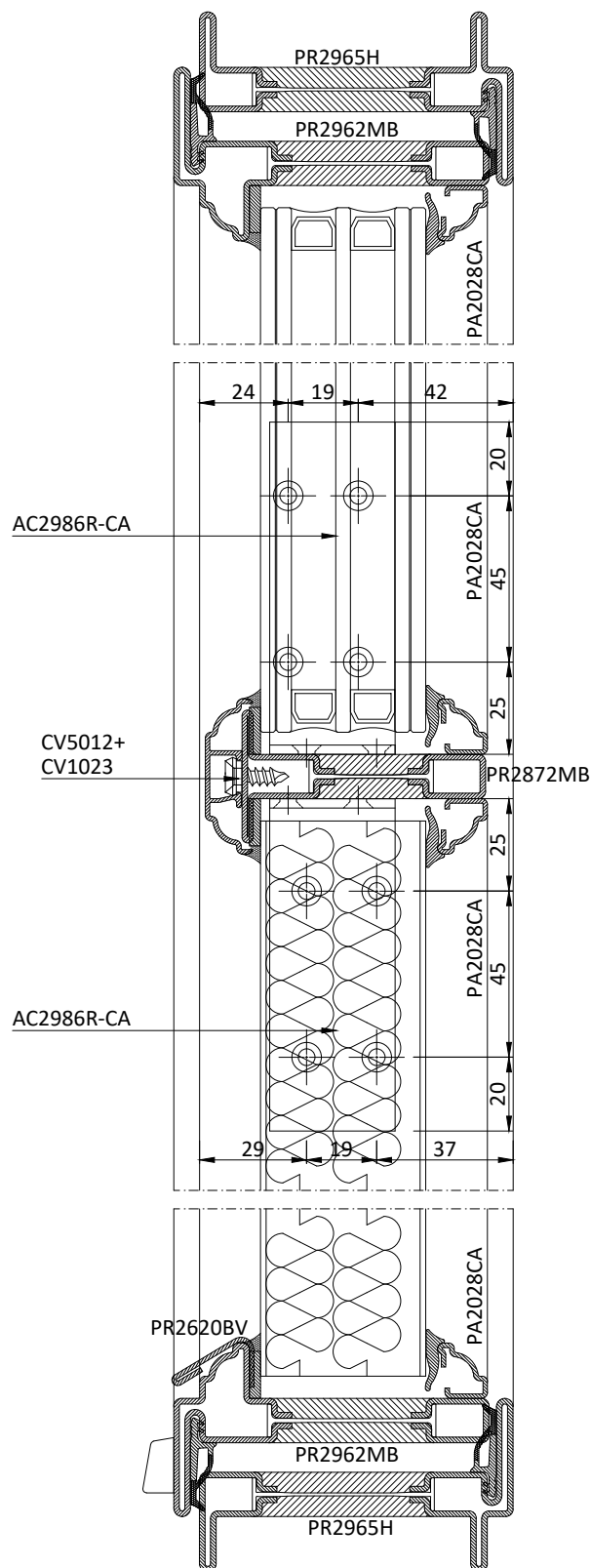


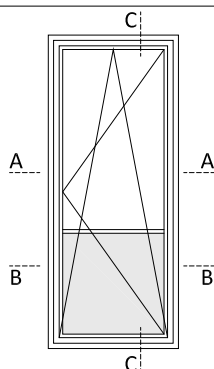


scaricare sulle due teste
per i primi 15 mm

mill the two
ends for 15 mm

3



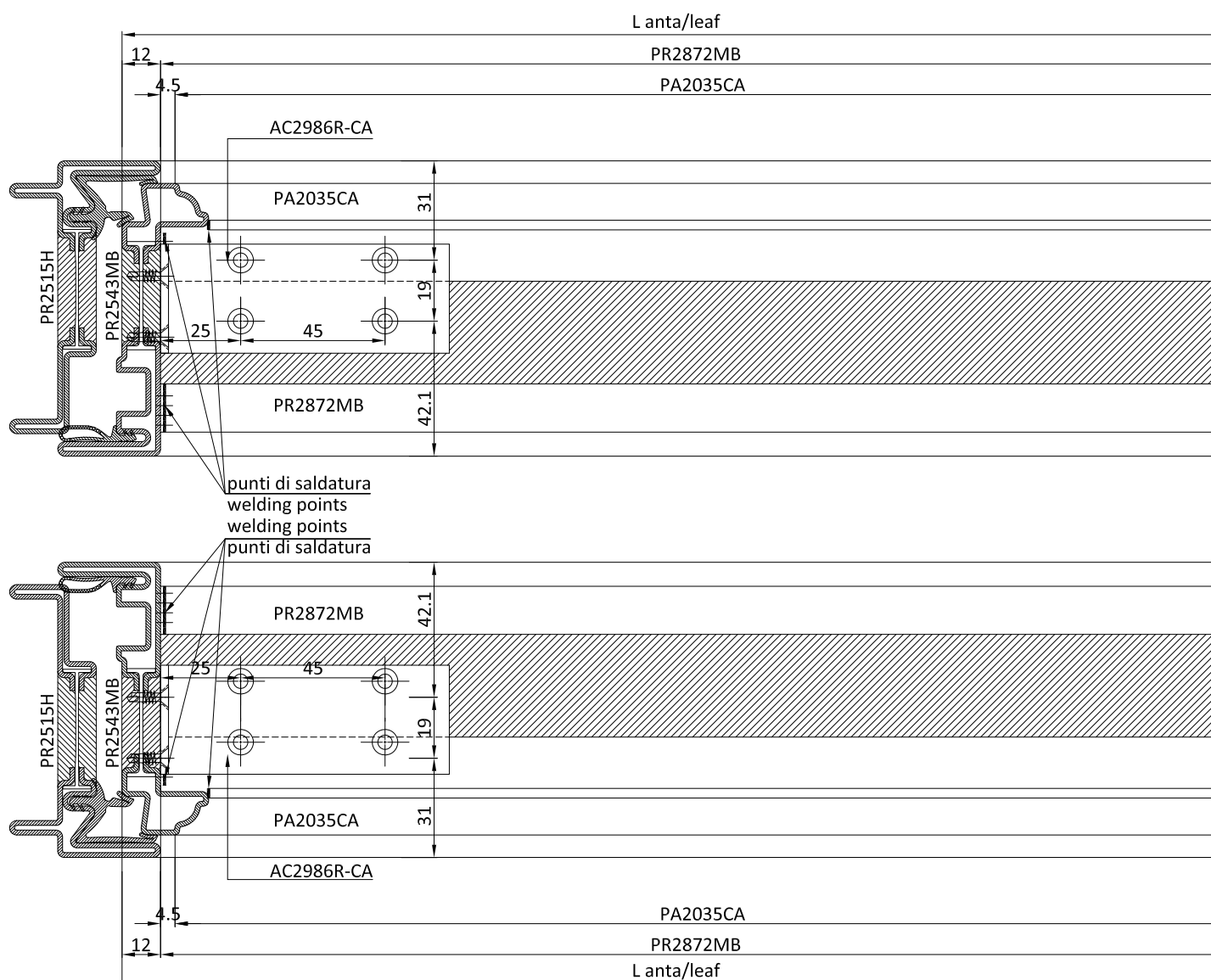


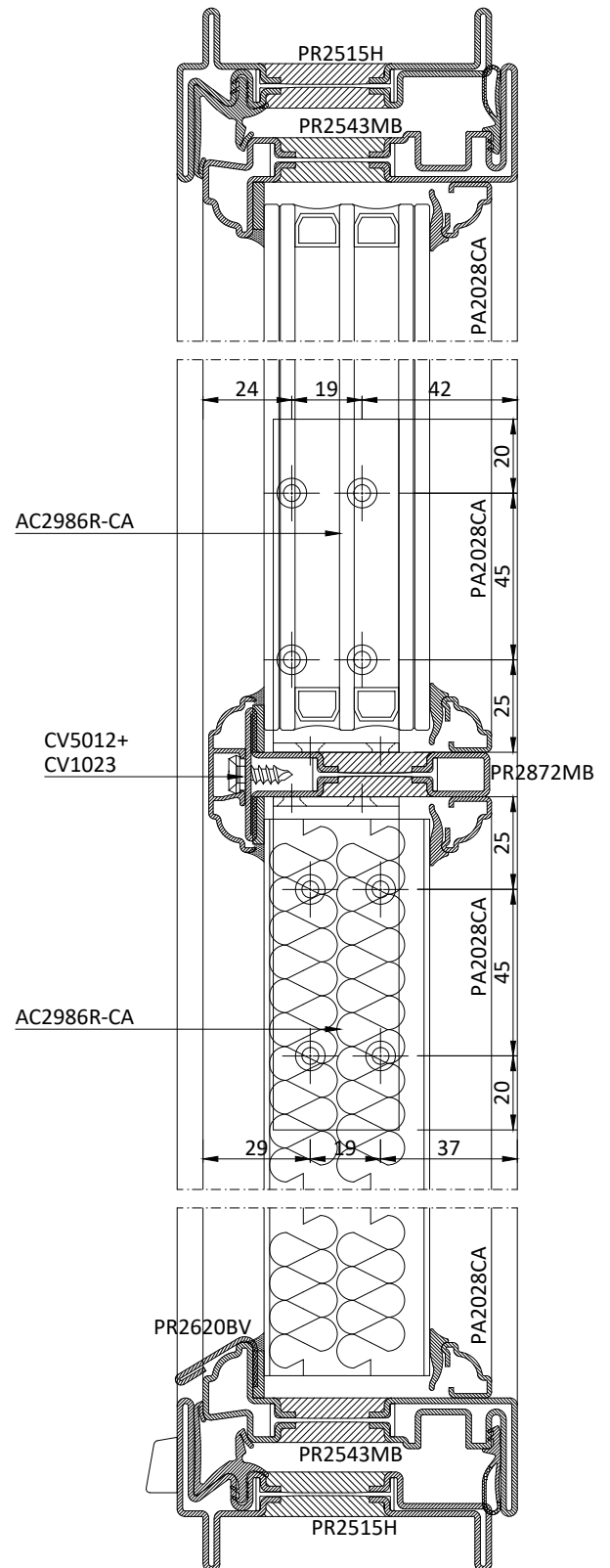
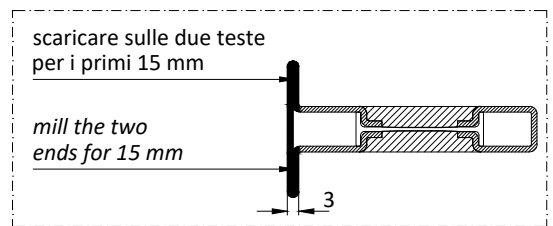
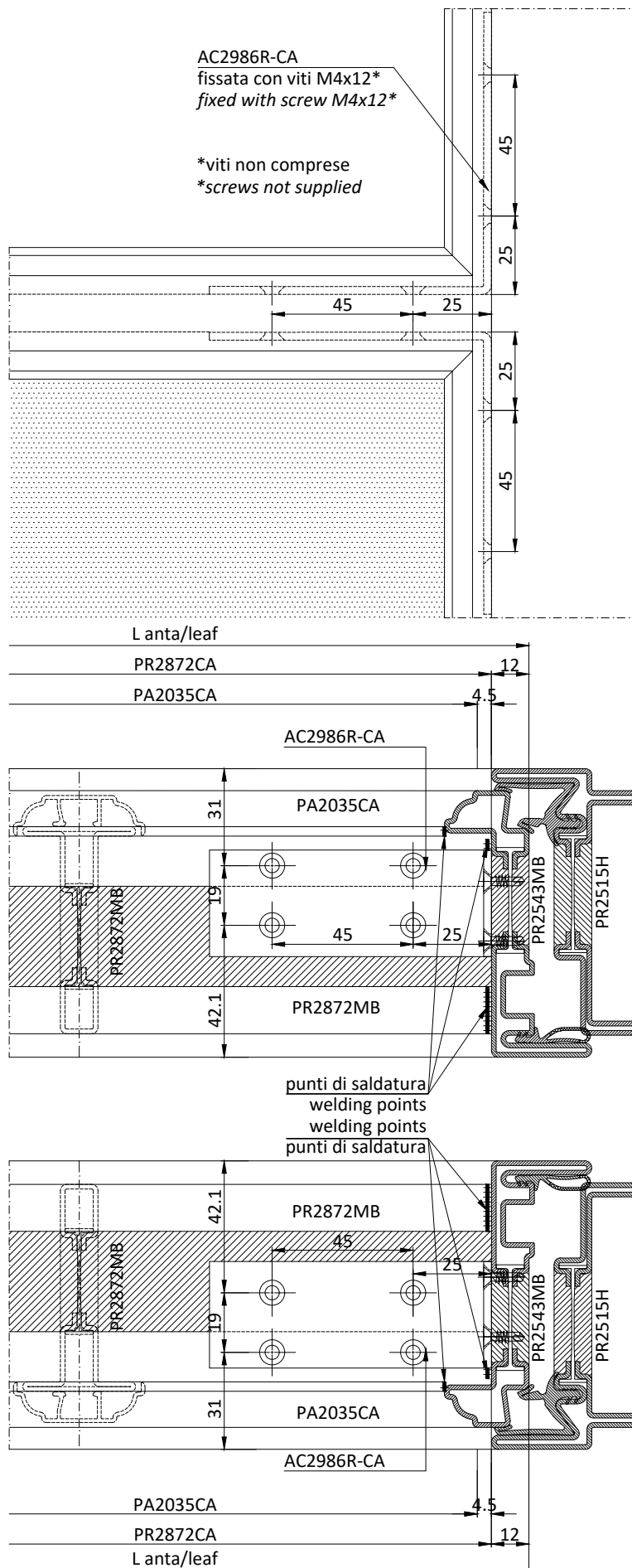
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Anta		Leaf				
PR2872CA	Profilo a "T" trasverso	"T" profile leaf	1	L-24	90°	90°
Dividivetri		Glazing dividers				
PA2035CA	Profilo dividivetro	Glazing divider profile	1	L-33	fresatura	milling

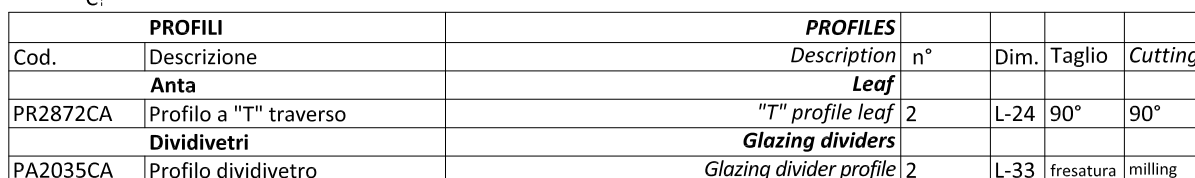
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2986R-CA	Squadretta interna di assiemaggio	Assembling corner bracket	4
CV5012	Boccola per fermavetri in alluminio	Bushing for aluminium glazing bleed	var.
CV1023	Vite per boccola fermavetri	Screw for glazingbead bushing	var.

*viti per fissaggio staffe non comprese
*screws for brackets fixing not supplied

**AC2986R-CA non fornite da Secco
**AC2986R-CA not supplied by Secco





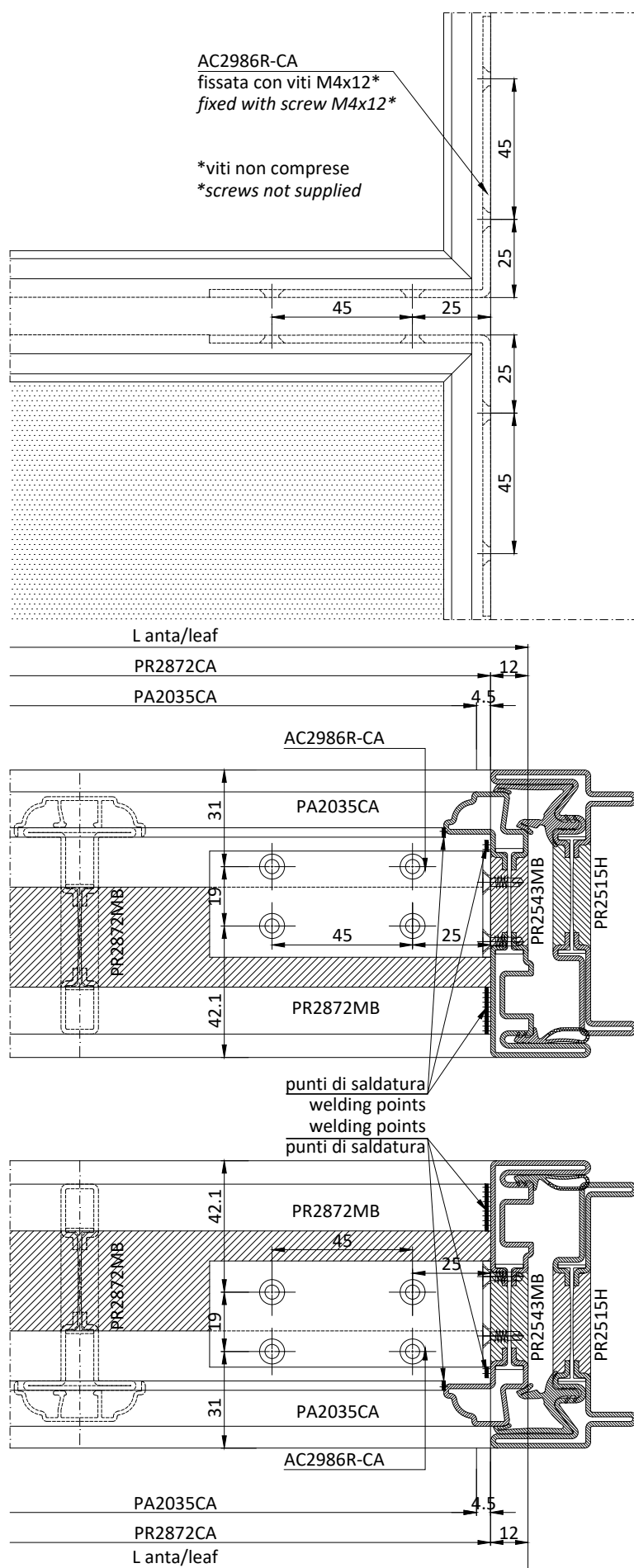


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2986R-CA	Squadretta interna di assiemaggio	Assembling corner bracket	8
CV5012	Boccola per fermavetri in alluminio	Bushing for alluminium glazing bleed	var.
CV1023	Vite per boccola fermavetri	Screw for glazingbead bushing	var.

*viti per fissaggio staffe non comprese
*screws for brackets fixing not supplied

**AC2986R-CA non fornite da Secco
 **AC2986R-CA not supplied by Secco

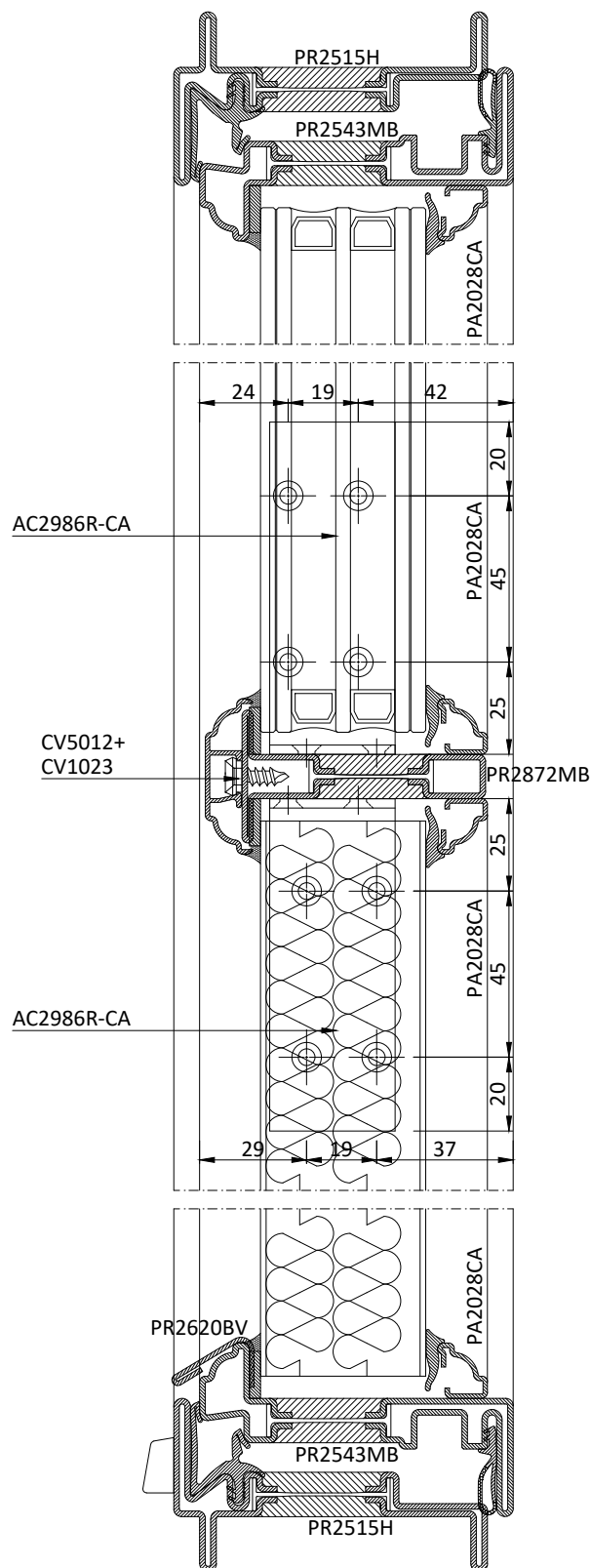


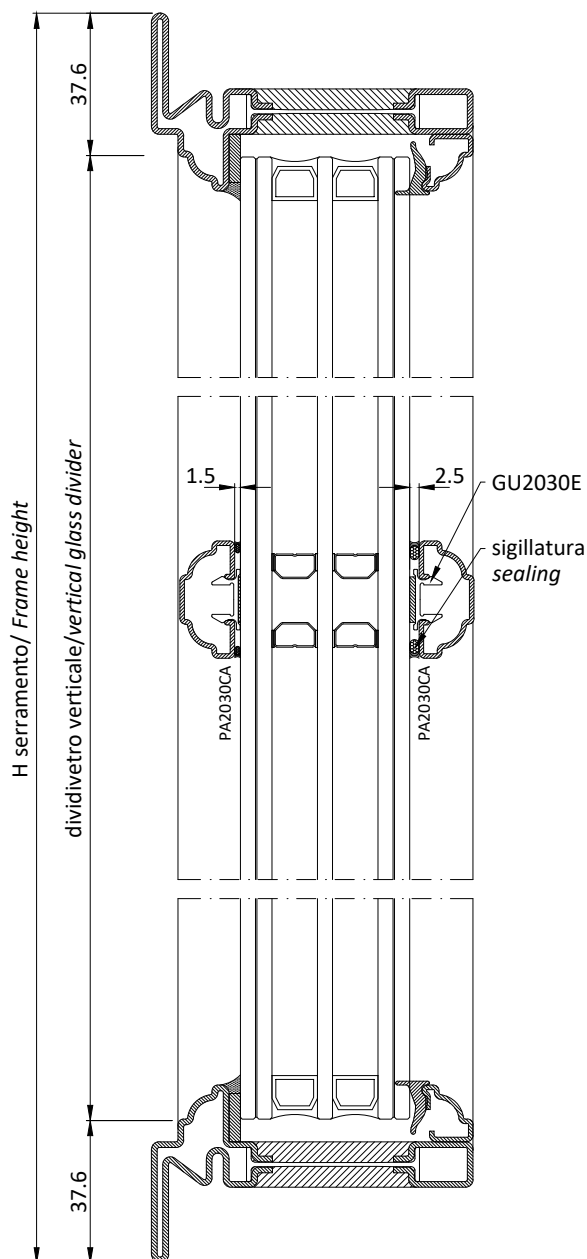


scaricare sulle due teste
per i primi 15 mm

mill the two
ends for 15 mm

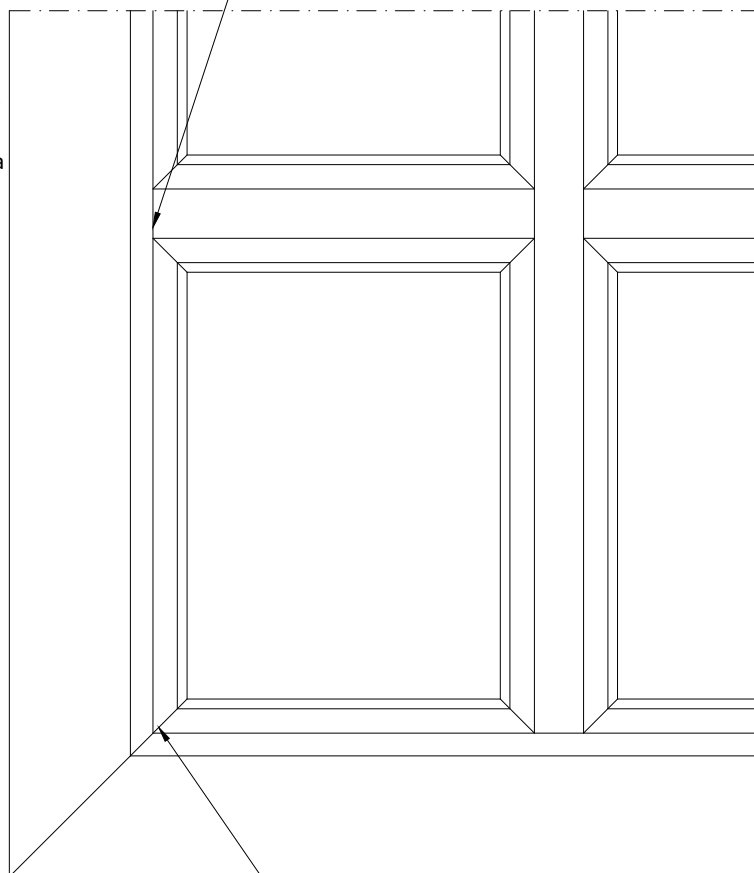
3





Lavorazione di intestatura effettuabile con
fresa ATE030CA

Butt join processing may be done with
gear-cutting ATE030CA



Taglio a 45° del fermavetro da effettuare
utilizzando la ganaschia ATE028CA

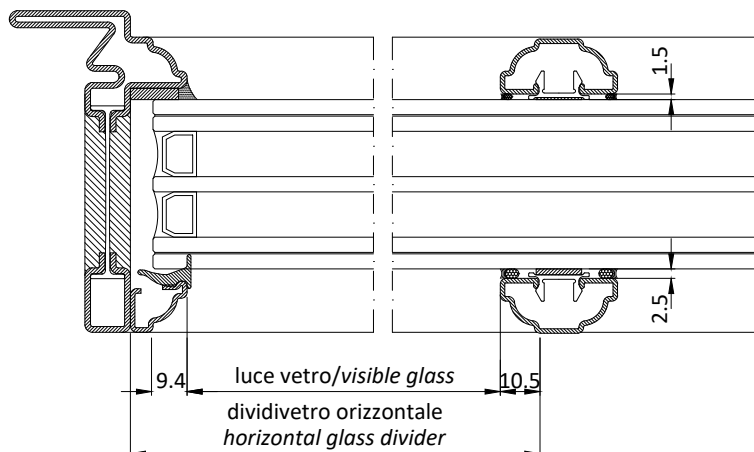
45° angle of the glass holder to be made
using the clamp ATE028CA

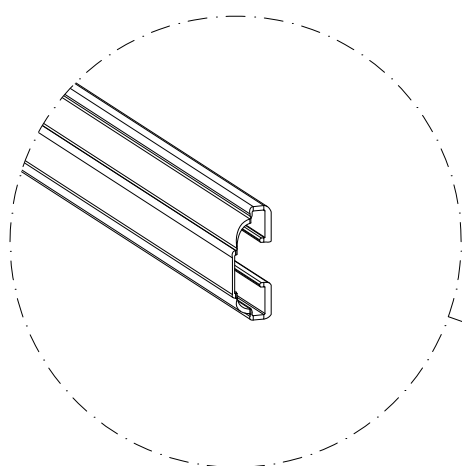
I dividivetro verticali sono dominanti rispetto ai
dividivetro orizzontali

Vertical glass dividers are dominant over the
horizontal ones

PA2030CA orizzontale = luce vetro+19.9mm
Horizontal PA2030CA = visible glass+19.9mm

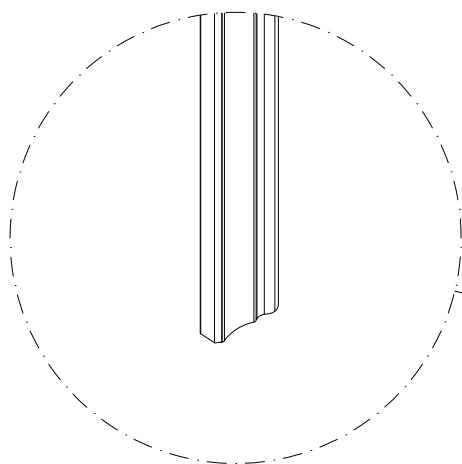
PA2030CA verticale = H serramento-75.2mm
Vertical PA2030CA = Frame height-75.2mm





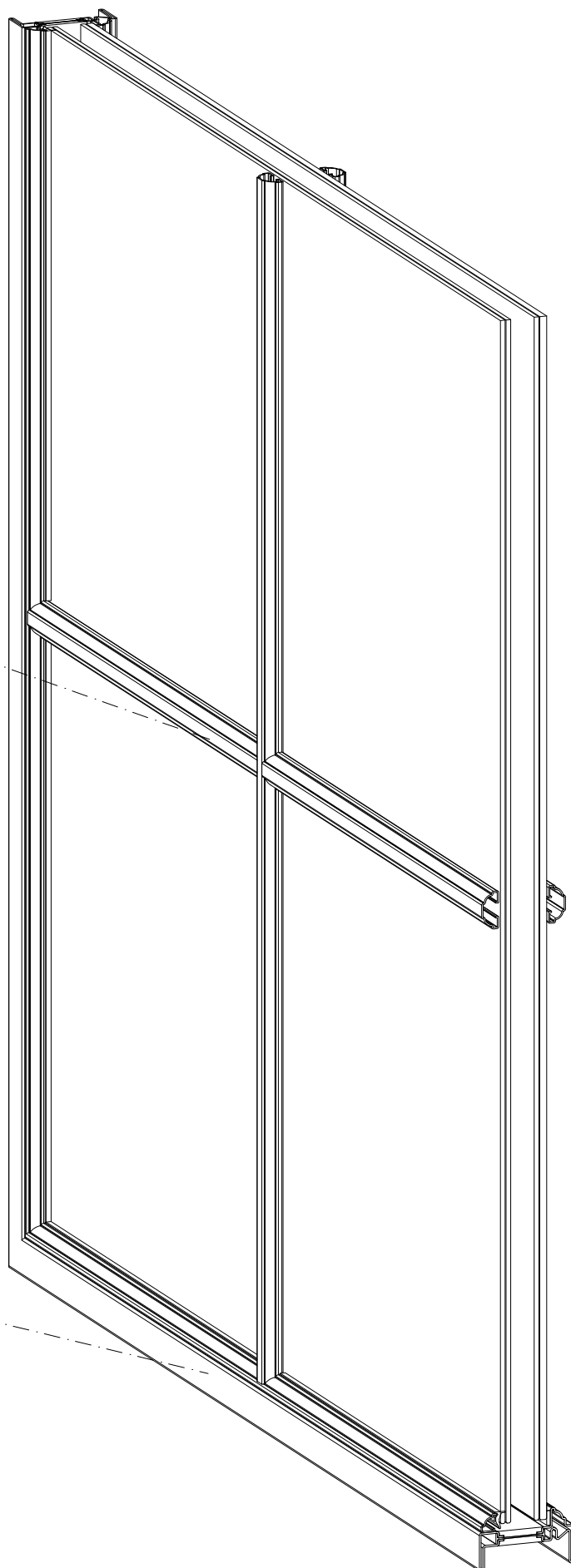
Lavorazione di intestatura effettuabile con
fresa ATE030CA

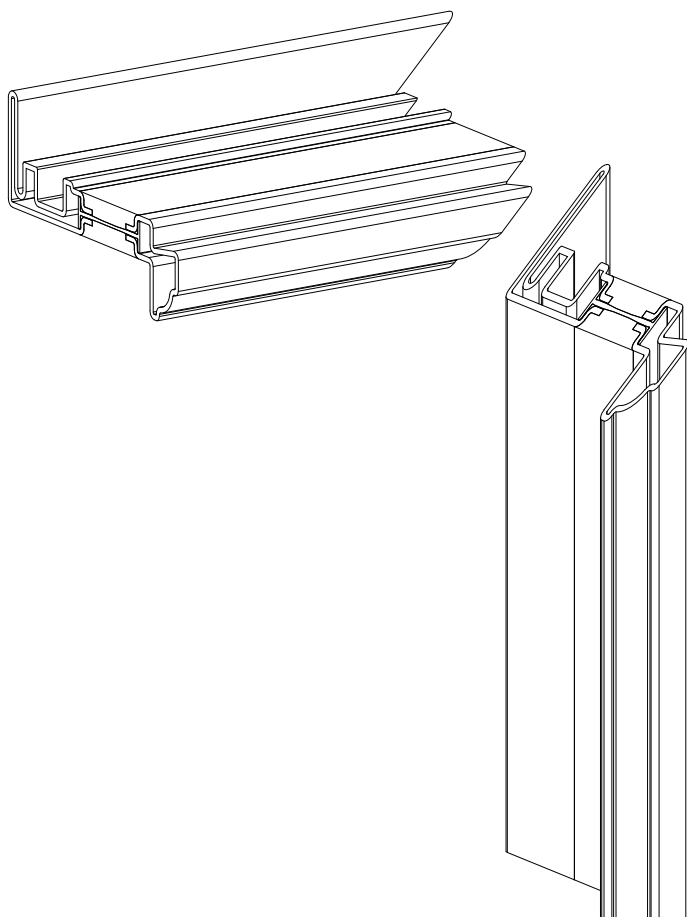
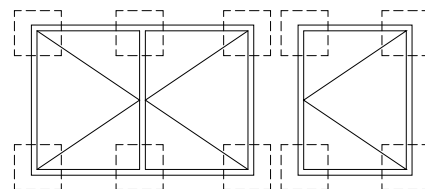
Butt join processing may be done with gear-cutting ATE030CA



Lavorazione di intestatura effettuabile con
fresa ATE030CA

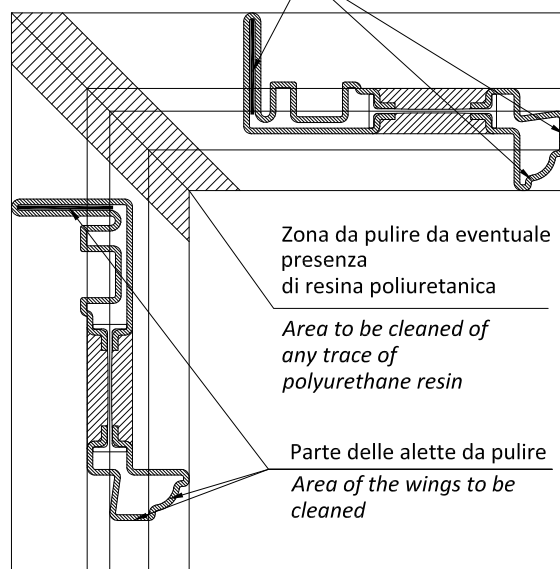
Butt join processing may be done with gear-cutting ATE030CA





Parte delle alette da pulire

Area of the wings to be cleaned



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.

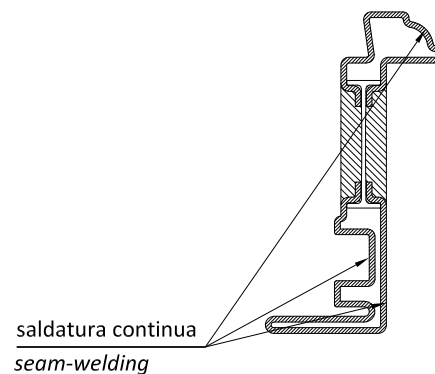
ATTN. Before welding the corner please remove any trace of polyurethane resin in the internal side of casin, heating the profile for ca. 20 mm to melt the resin and remove in this way all other impurities.

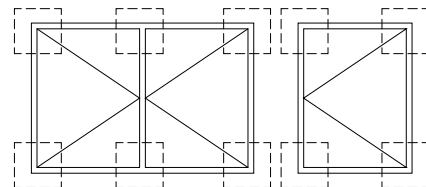
Ottone
Saldare in continuo le superfici di contatto.

Brass
Seam-weld all contact surfaces.

Acciaio zincato
Saldare in continuo le superfici di contatto.

Galvanised steel
Seam-weld all contact surfaces.

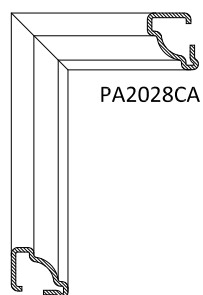
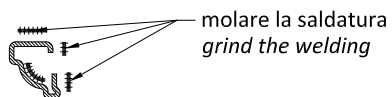


Alluminio

Saldare a TIG a punti le zone indicate.

Aluminum

Spot weld (TIG) the marked areas.



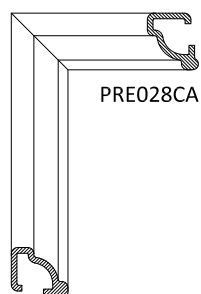
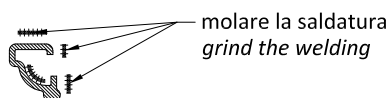
PA2028CA

Ottone

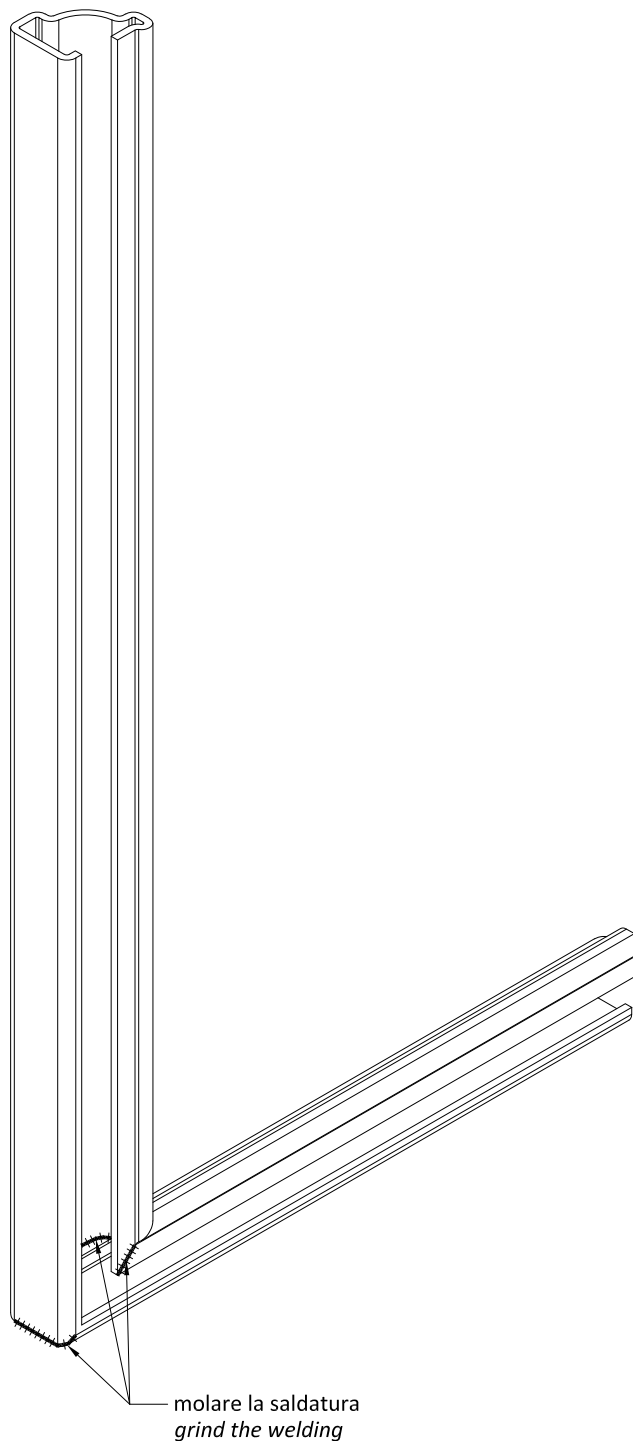
Saldare a TIG a punti le zone indicate.

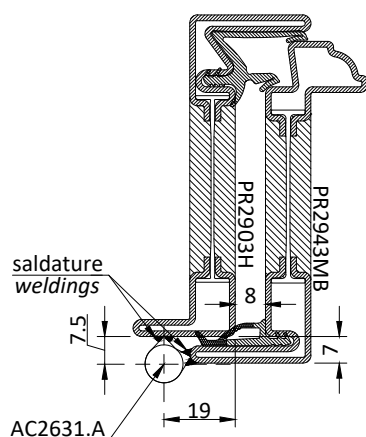
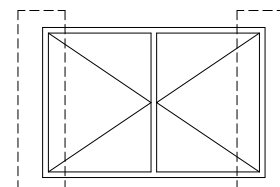
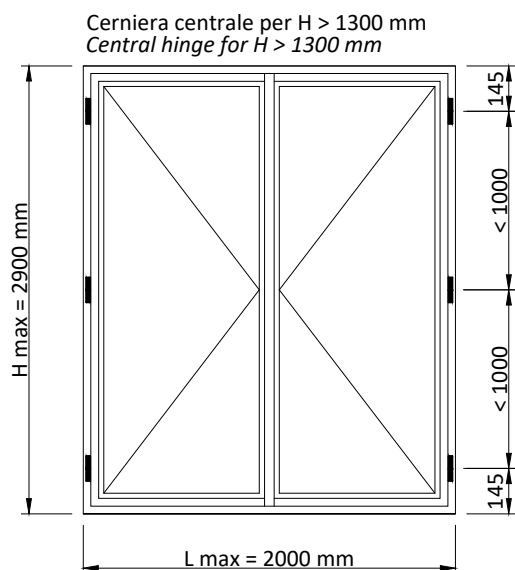
Brass

Spot weld (TIG) the marked areas.



PRE028CA

molare la saldatura
grind the welding



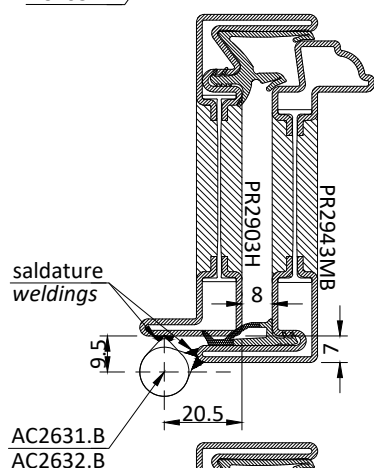
schema di fissaggio
AC2631.A non registrabile
cerniera Ø 10
peso massimo anta 40 kg

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

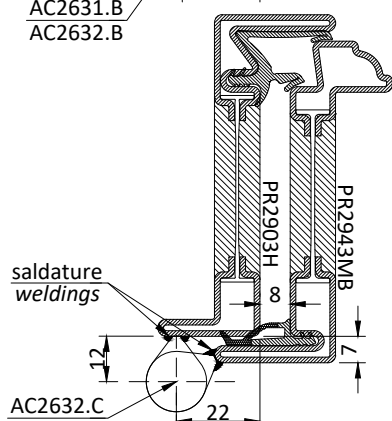
installation chart

AC2631.B non-adjustable

AC2632.B adjustable in height

Ø 13 Hinge

Max leaf weight 70 kg



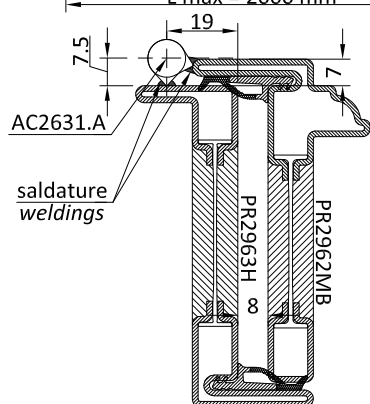
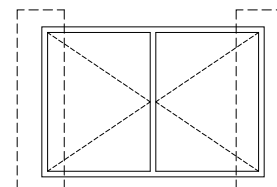
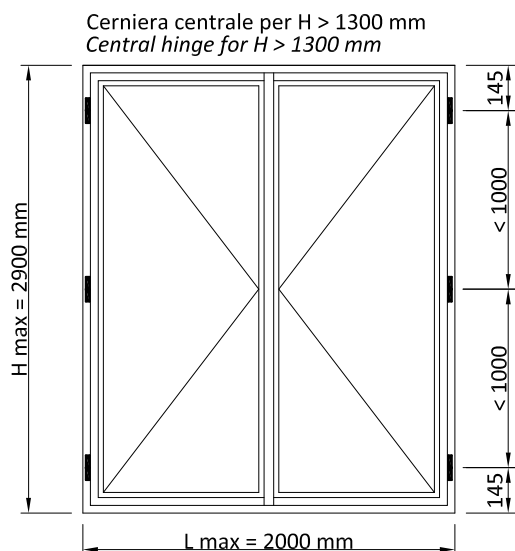
schema di fissaggio
AC2632.C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg

installation chart

AC2632.C adjustable in height

Ø 16 hinge

Max leaf weight 80 kg



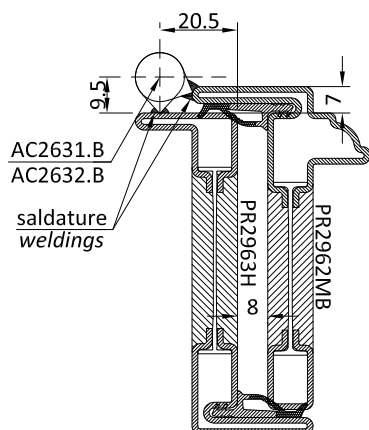
schema di fissaggio
AC2631.A non registrabile
cerniera Ø 10
peso massimo anta 40 kg

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

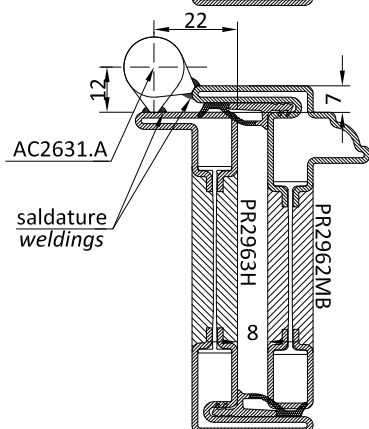
installation chart

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

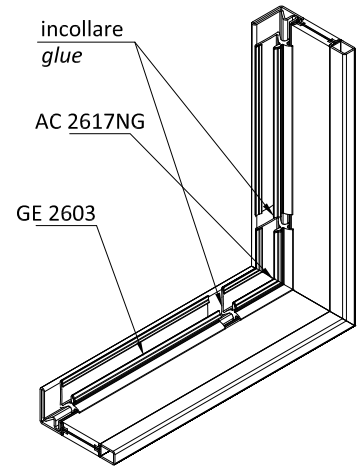
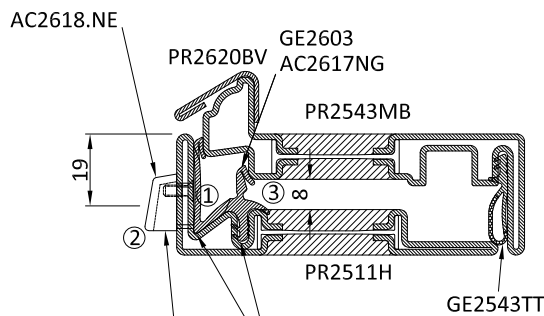
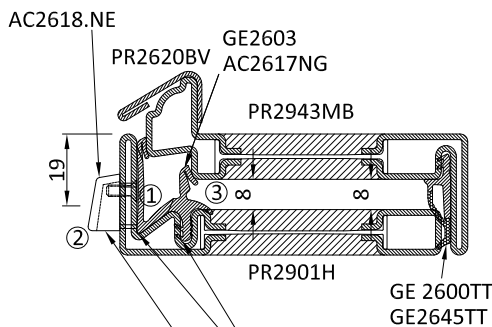
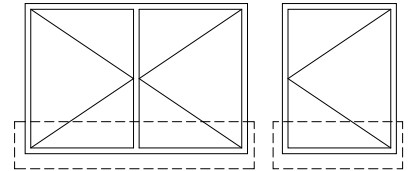
AC2632.C adjustable in height

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, sigillare e 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

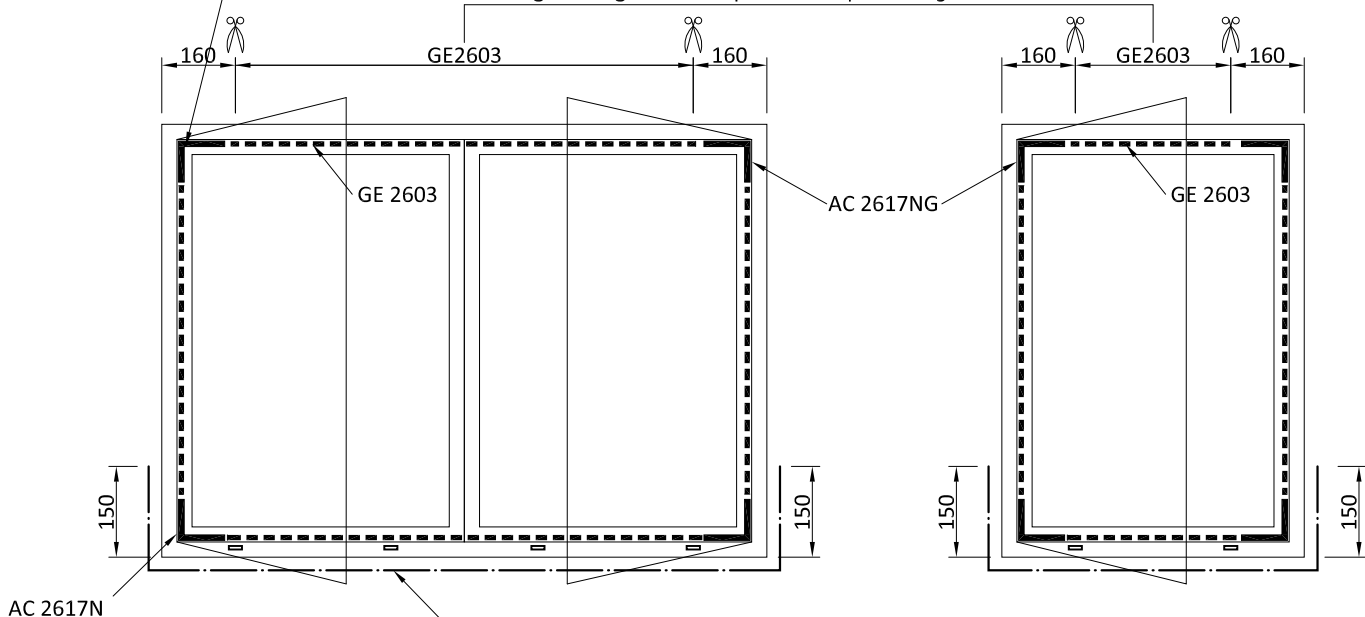


sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
seal the entire base of the frame and vertically for 150 mm

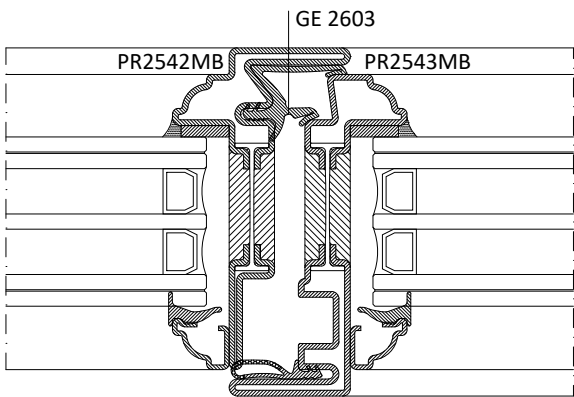
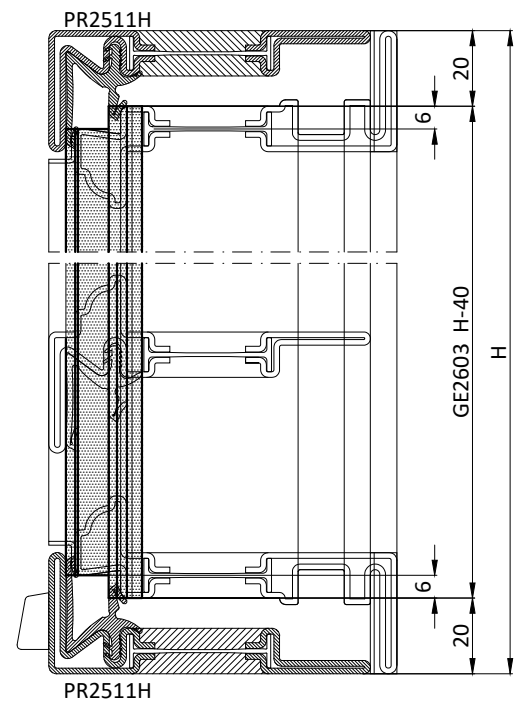
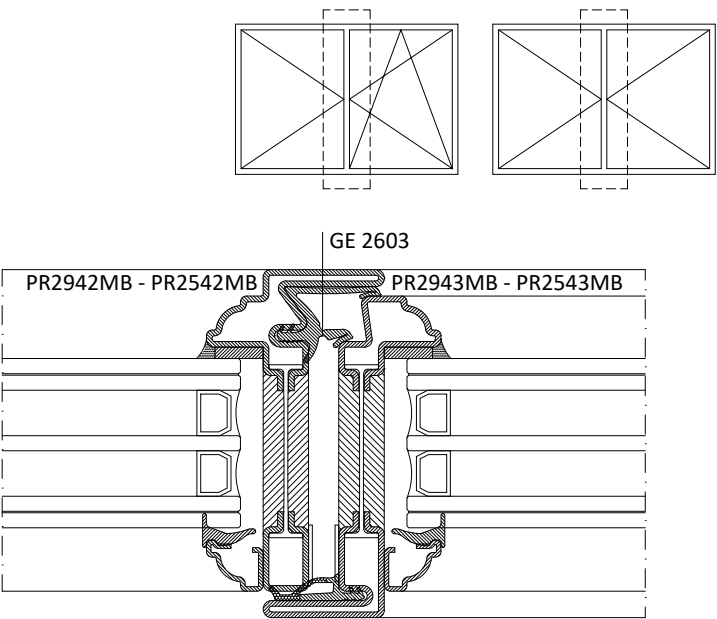
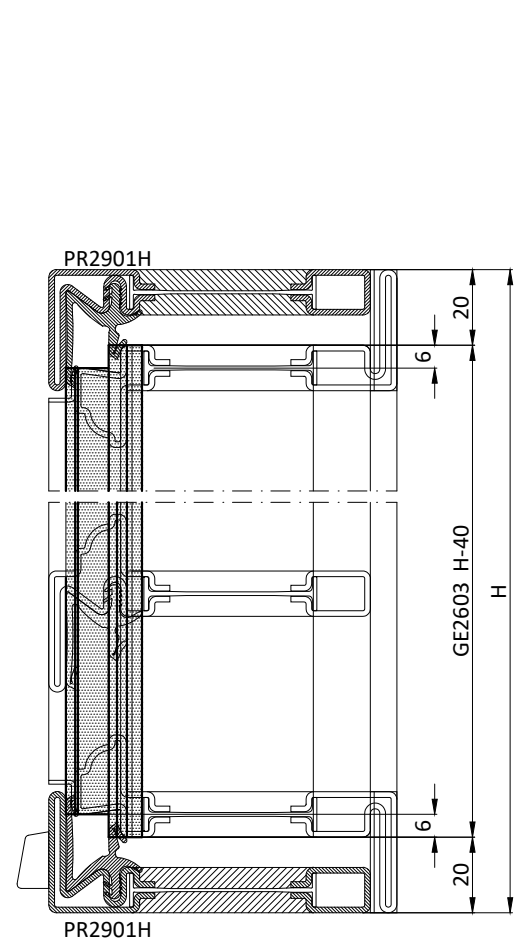
sigillare il perimetro dello scarico acqua
seal the perimeter of the water drip

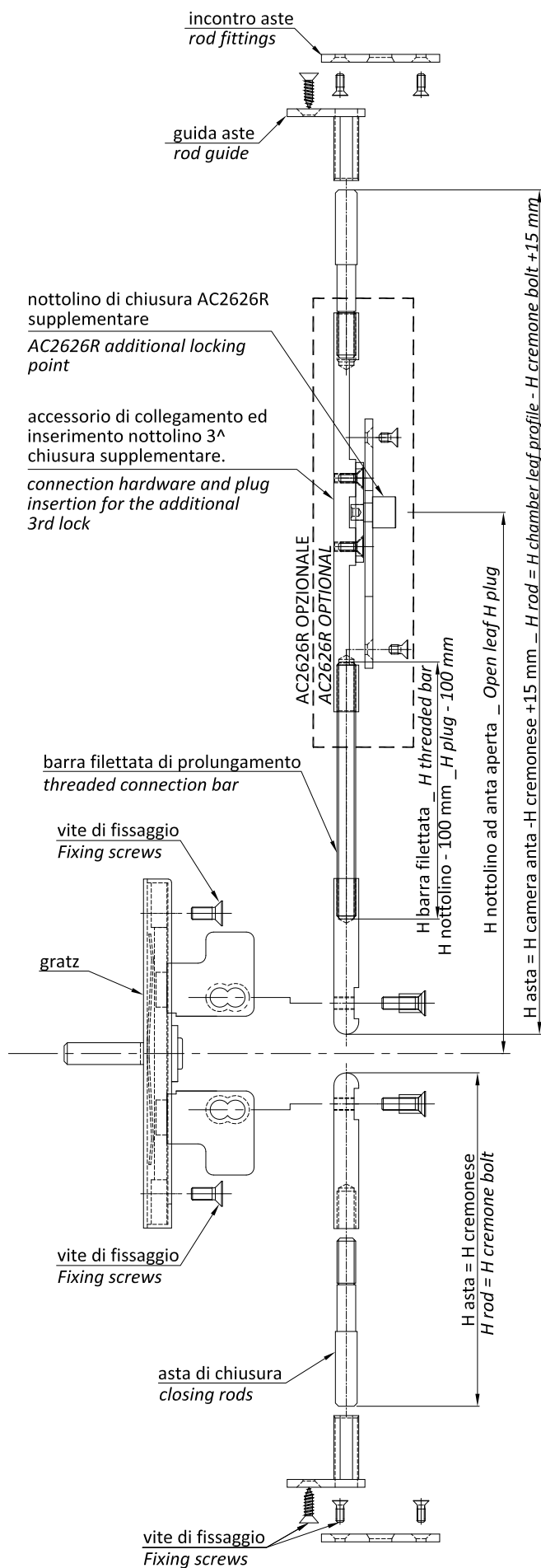
incollare gli angoli vulcanizzati AC 2617NG alla guarnizione con colla cianoacrilica
glue the AC 2617NG vulcanised corner to the gasket using cyanoacrylate glue

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



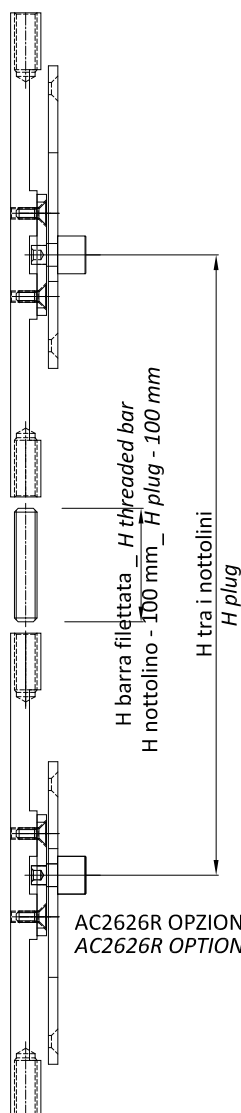
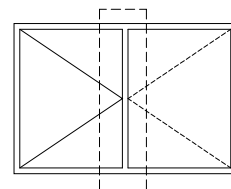
- ④ sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
- ④ seal the entire base of the frame and vertically for 150 mm





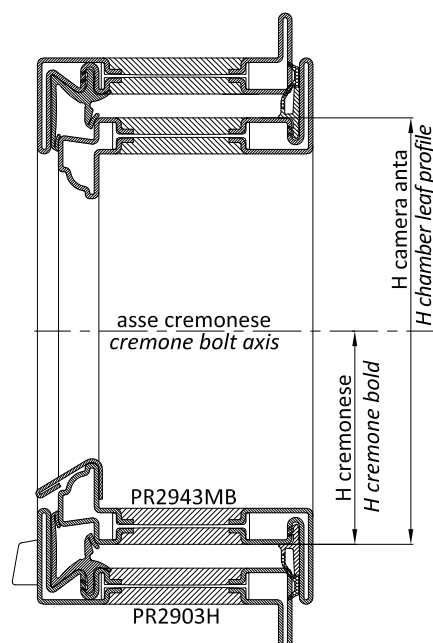
- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi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

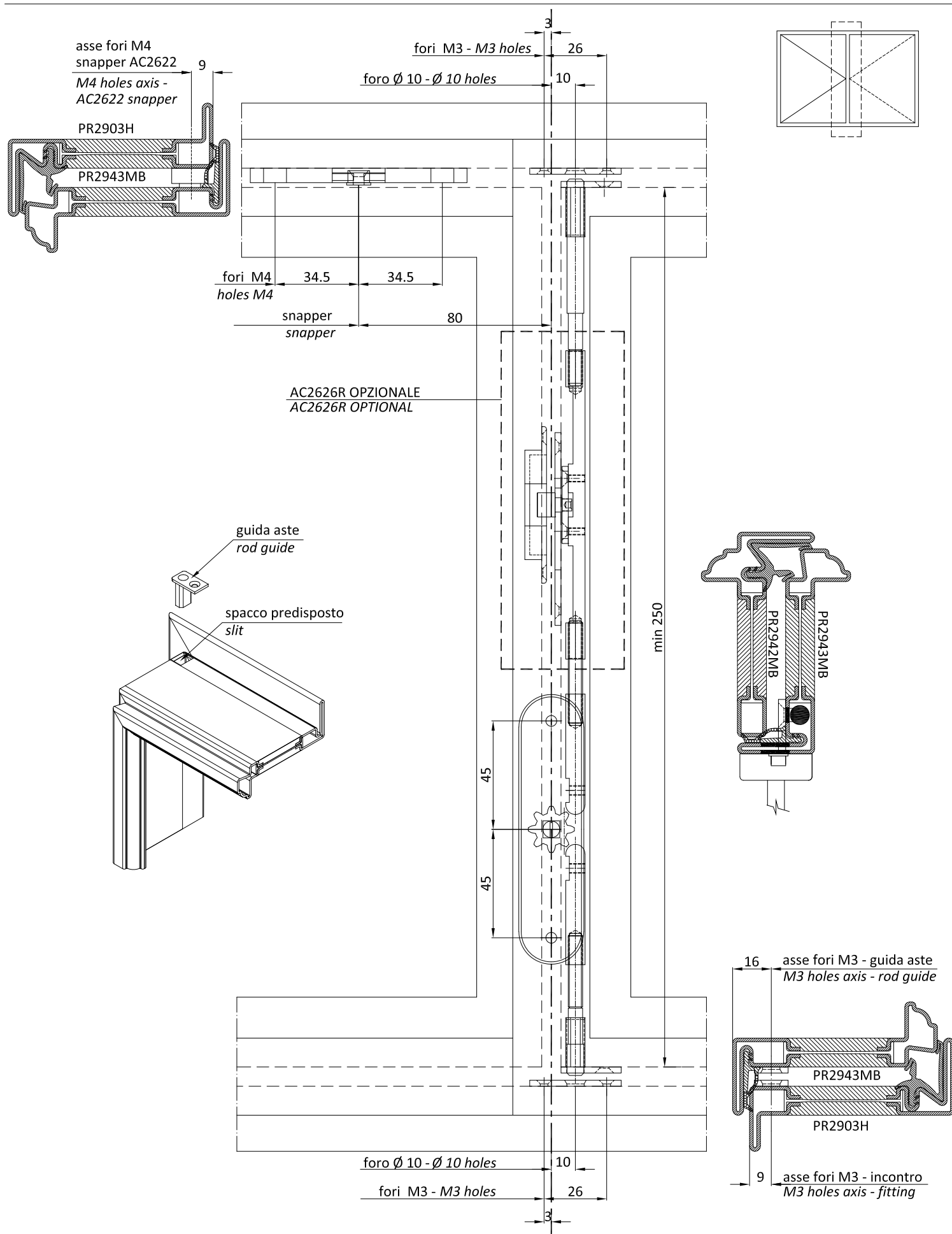
- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them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

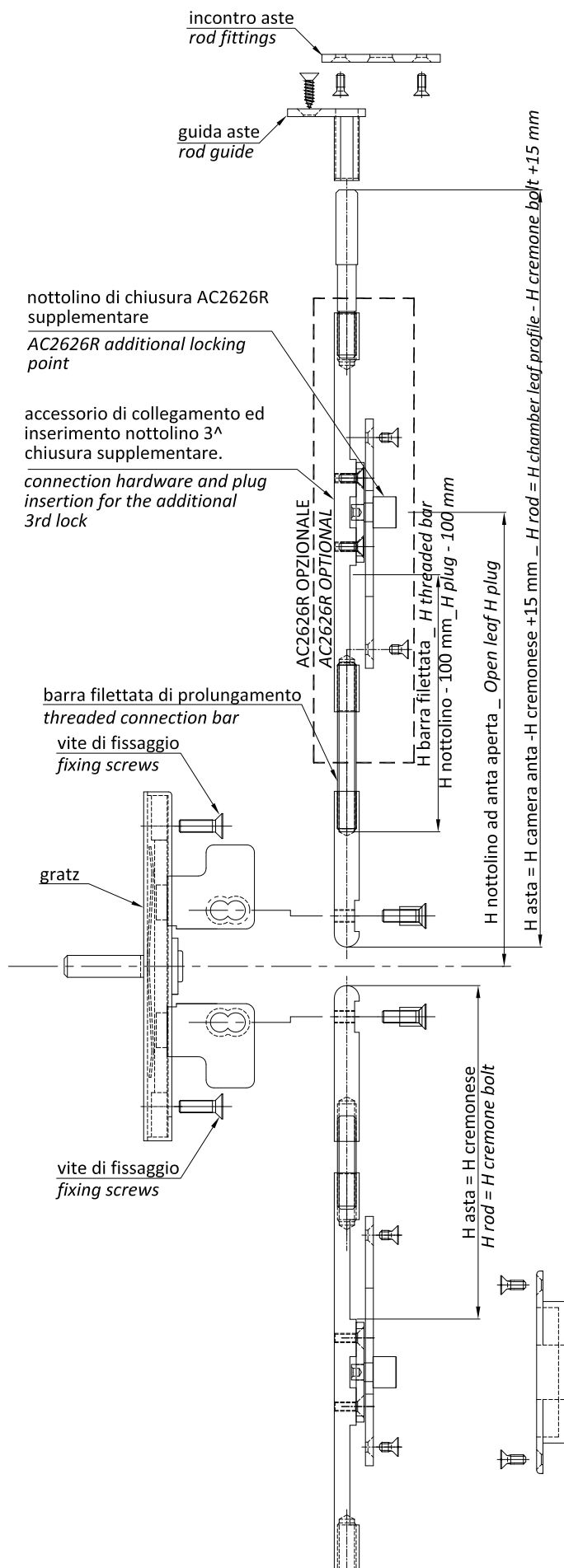


AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max.

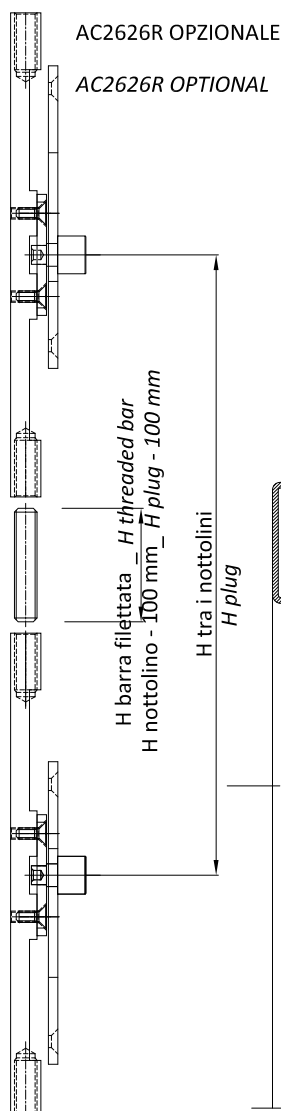






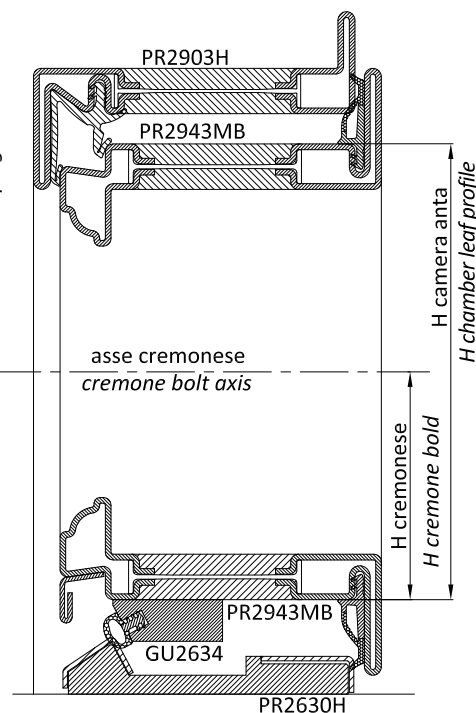
- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi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

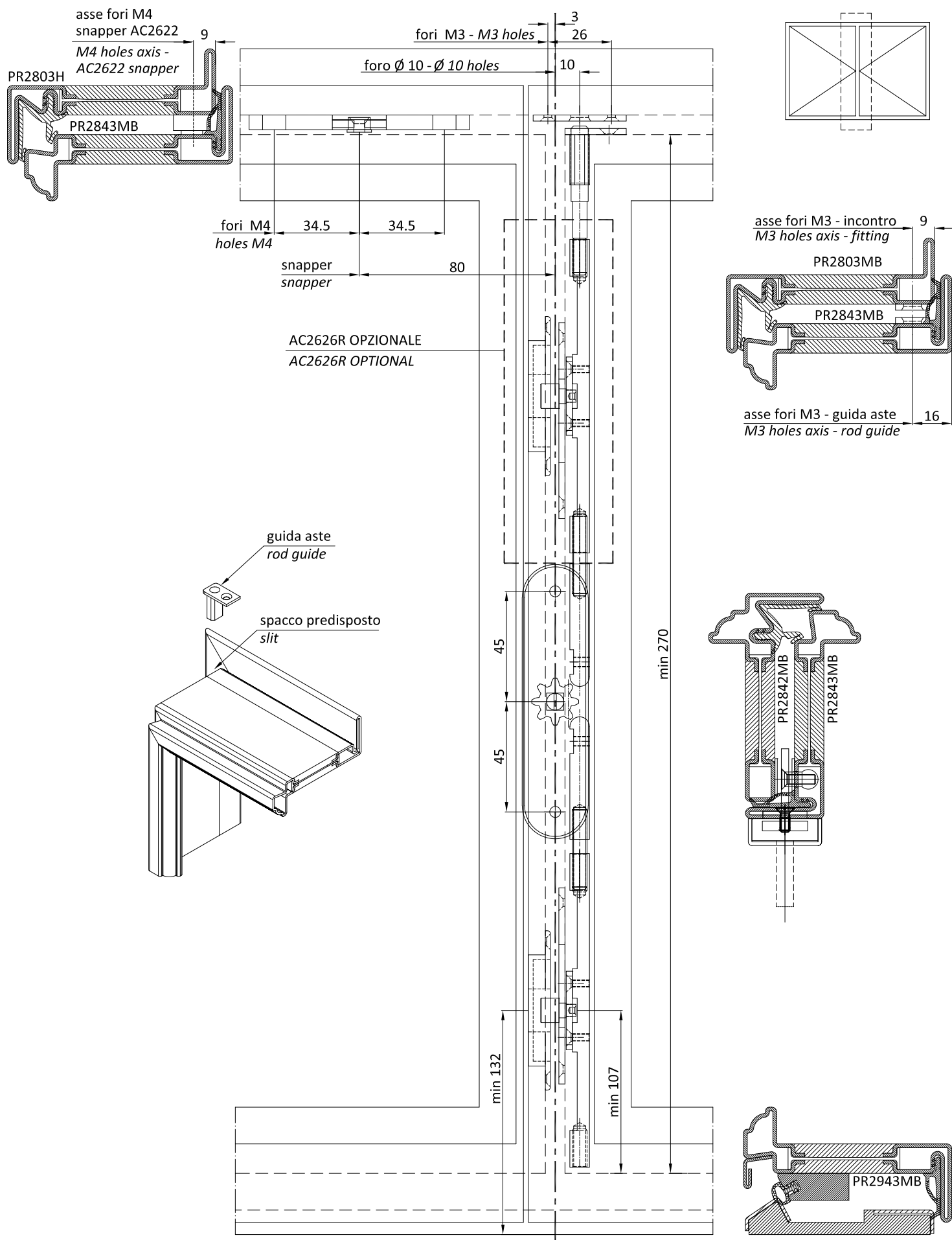
- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them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

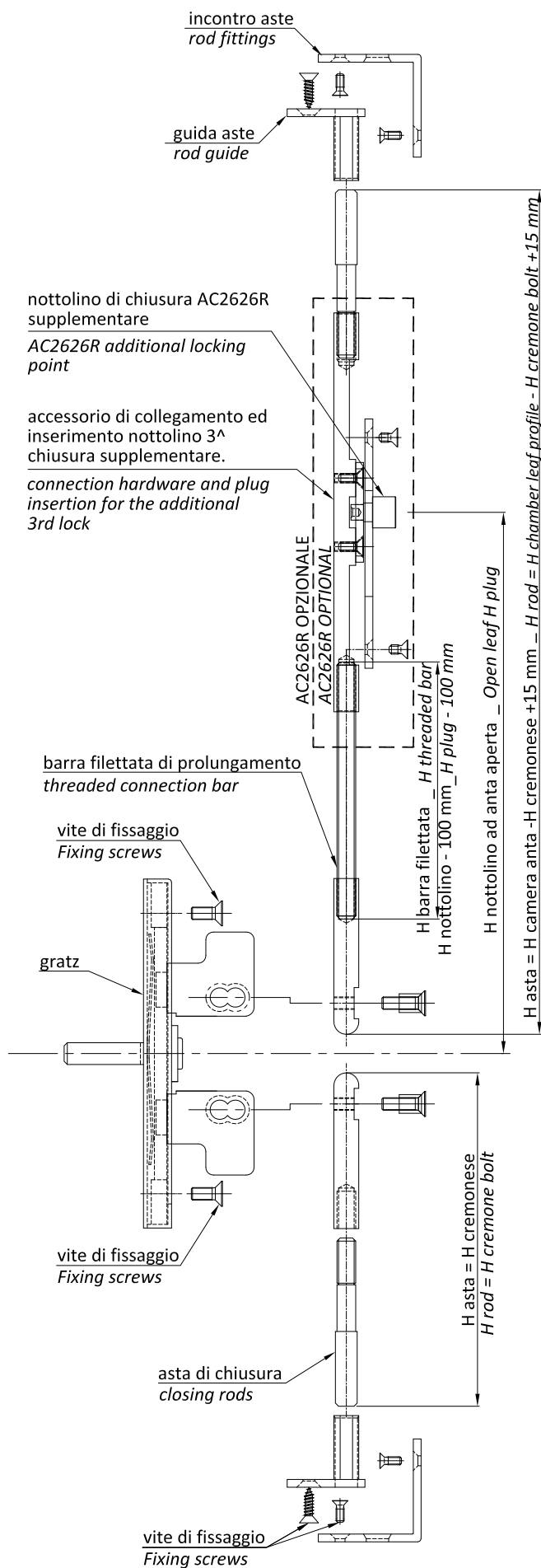


AC2626R incontro 3^a chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max.

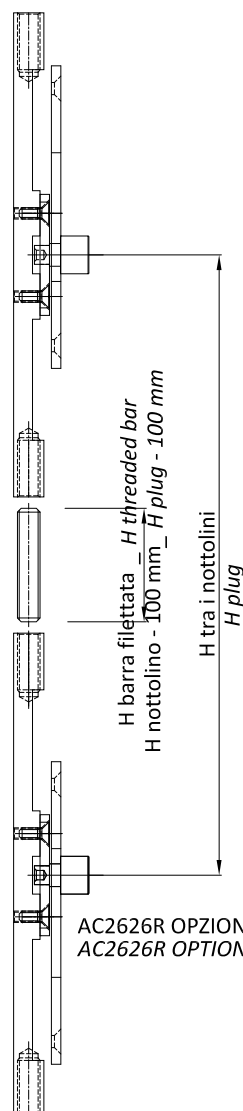
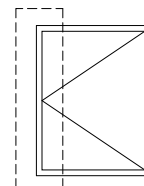






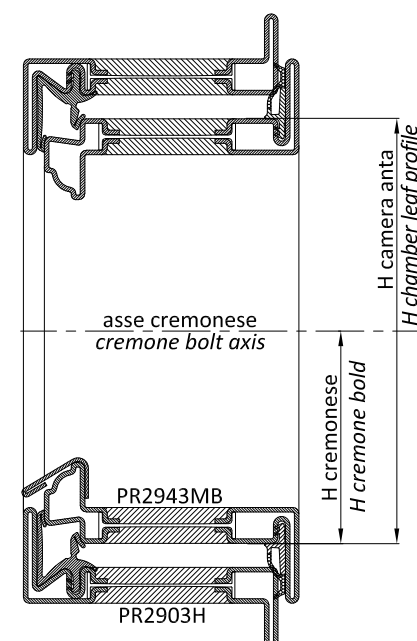
- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi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

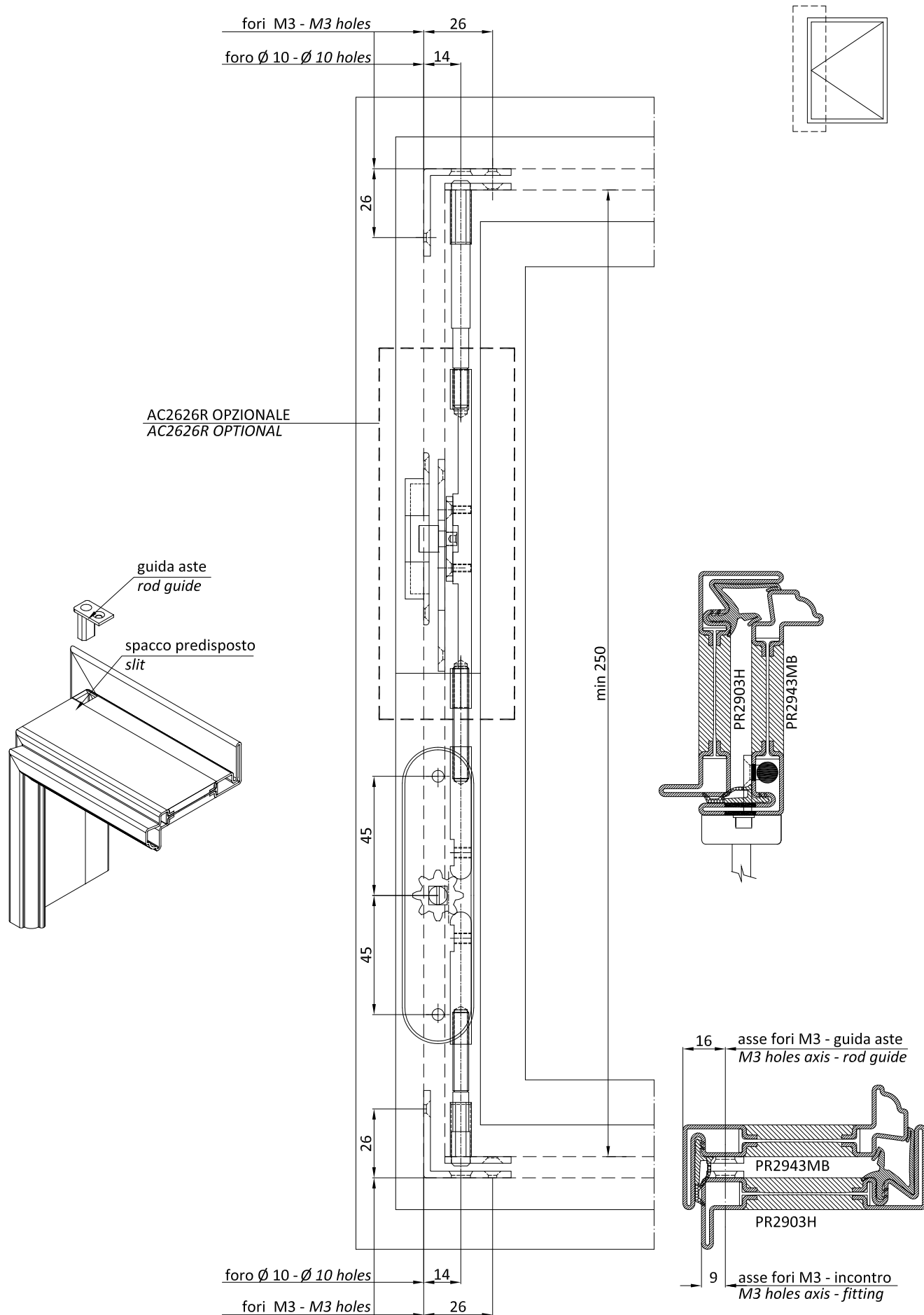
- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them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

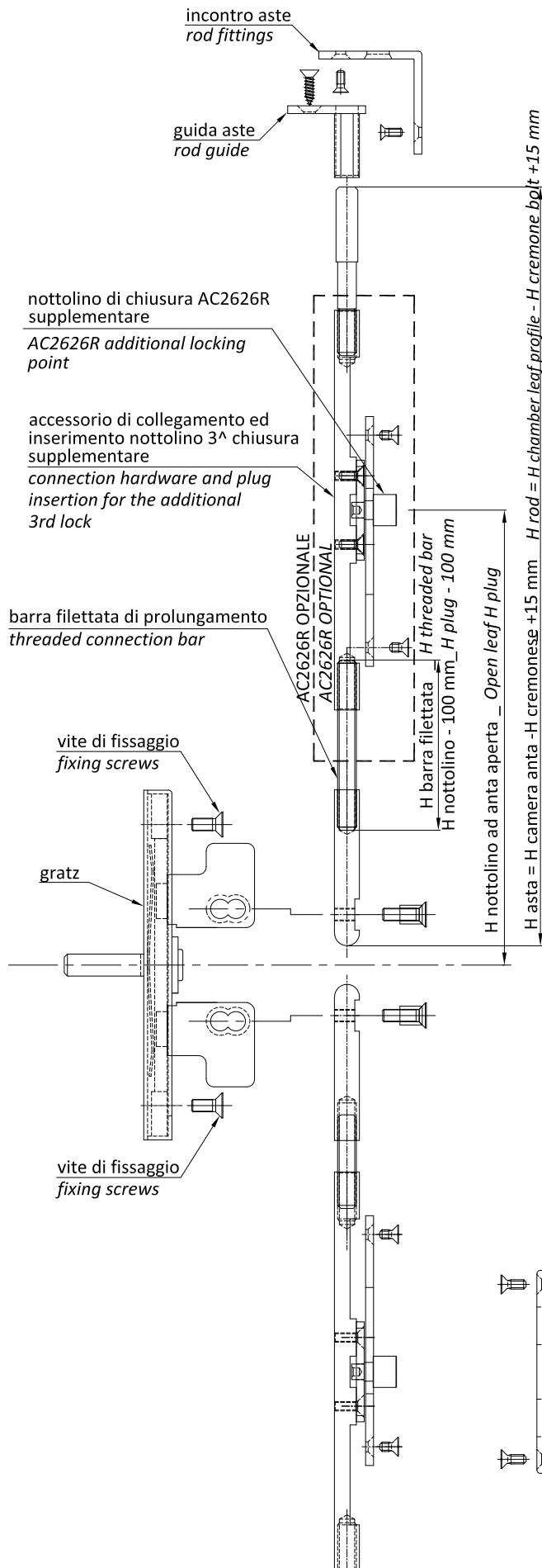


AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max.

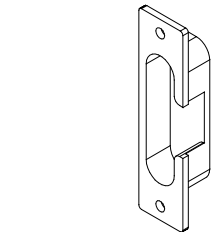
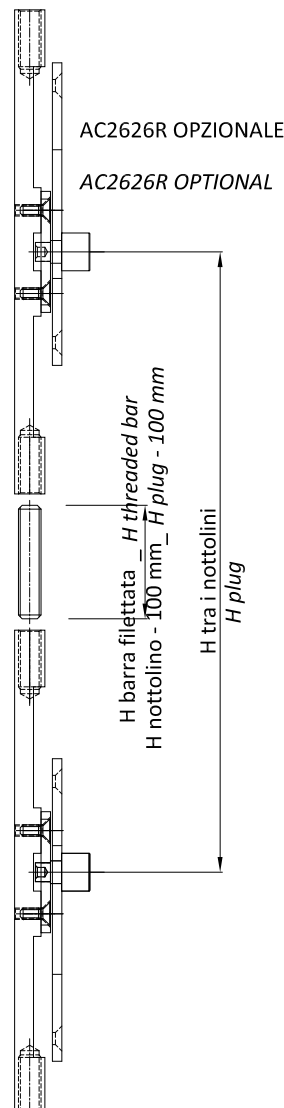
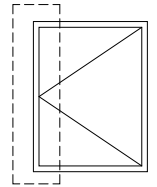






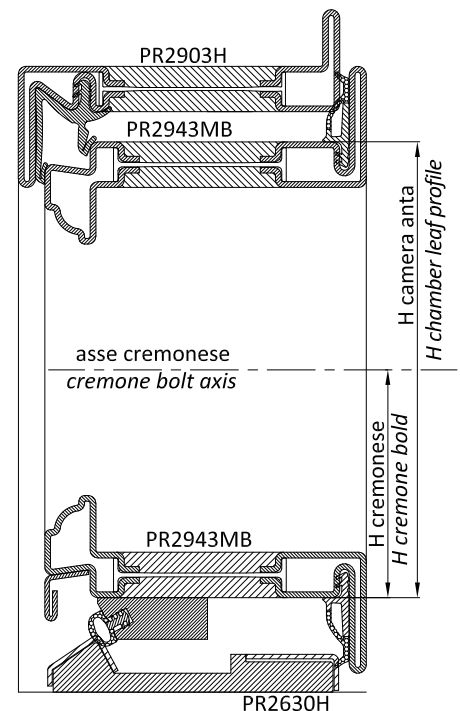
- 1) Avvitare le aste di chiusura agli accessori di collegamento
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta
- 3) Inserire e fissare il GRATZ all'anta
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione
- 5) Inserire gli accessori guida aste negli spacchi predisposti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

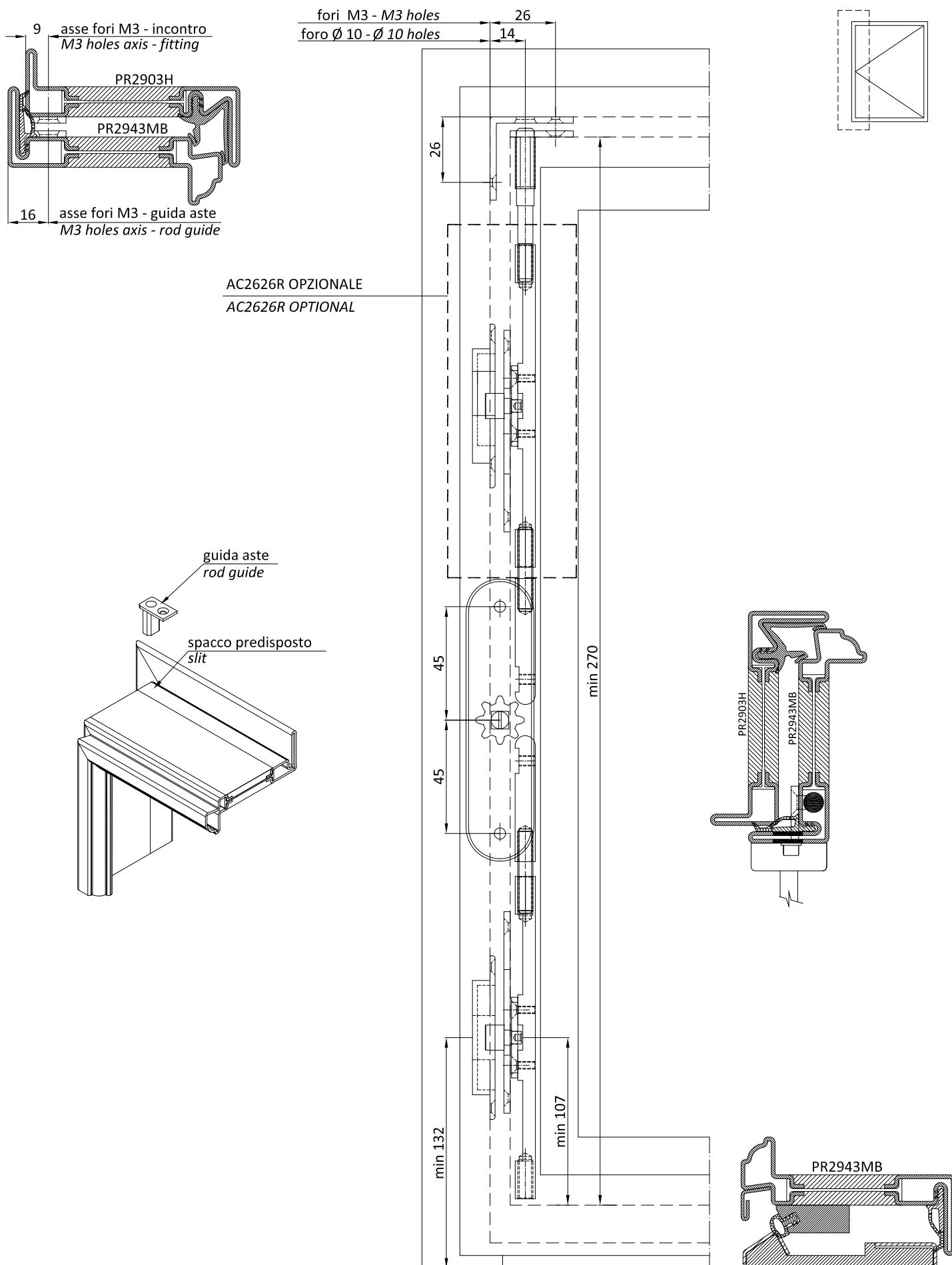
- 1) Screw the closing rods to the connection fittings
- 2) Insert the rods into the slits on the leaf corners
- 3) Insert the GRATZ mechanism into the leaf and secure
- 4) Secure the closing rods to the GRATZ mechanism using the M4 screws
- 5) Insert the rod guides into the slits and fix them to the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

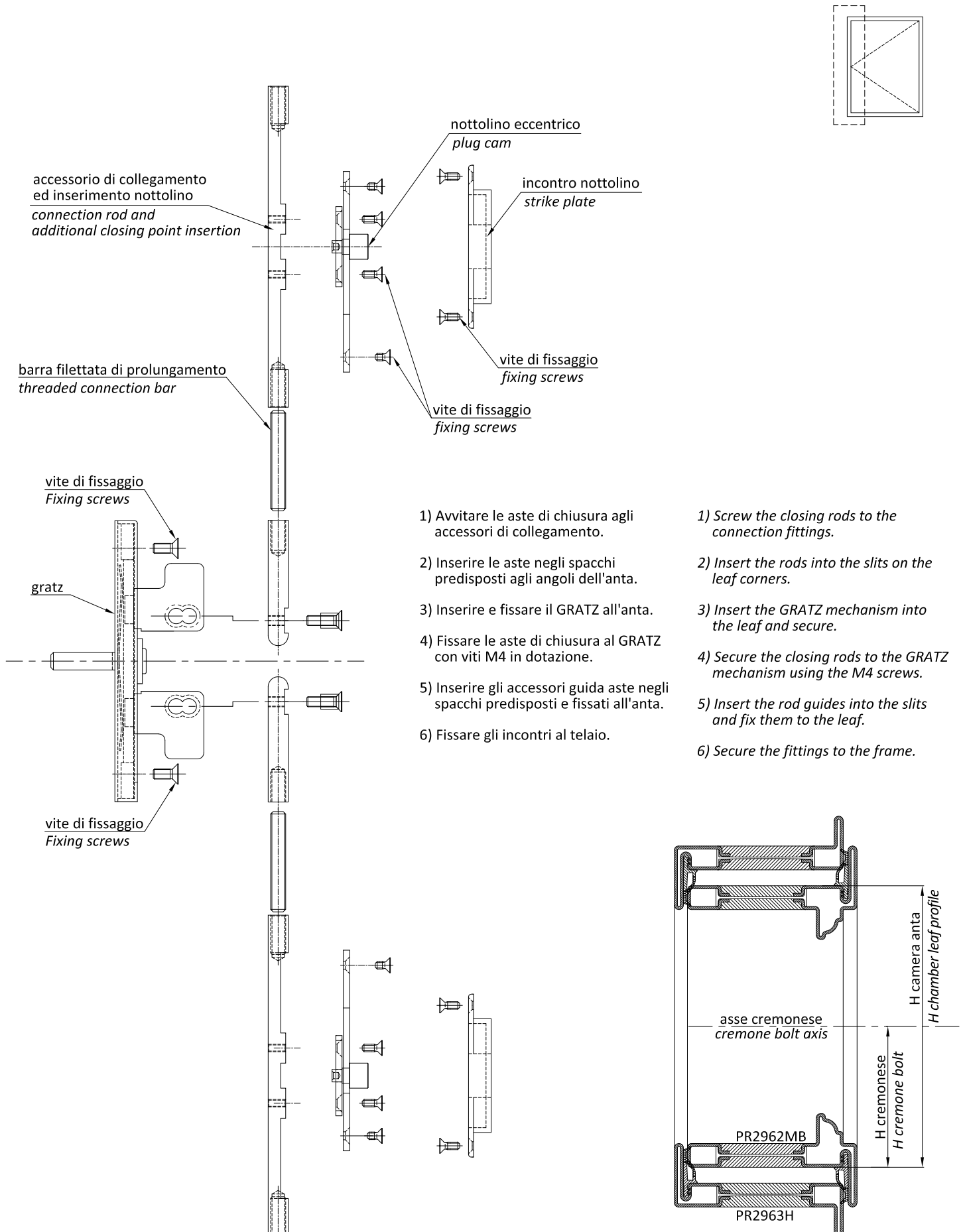


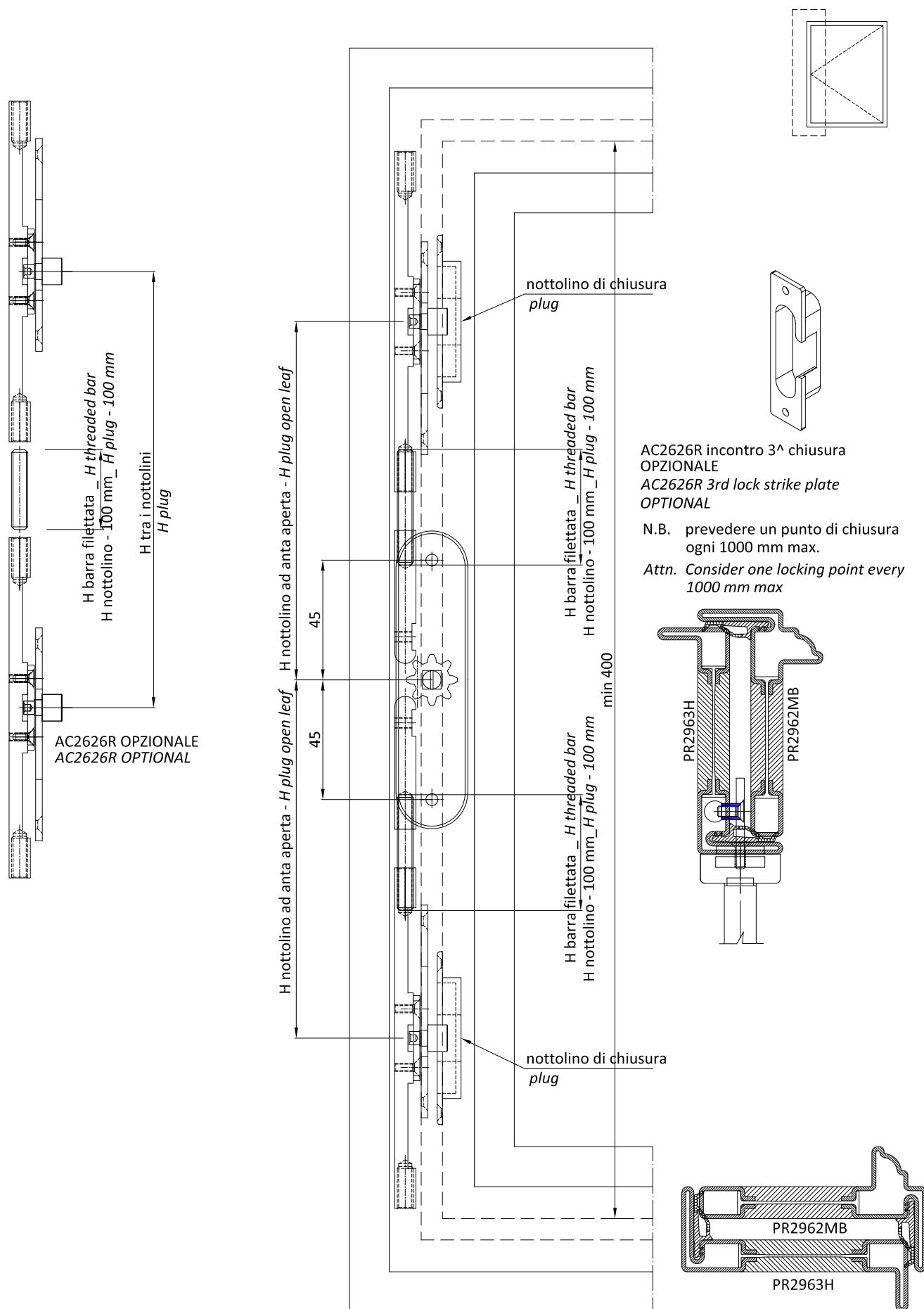
AC2626R incontro 3^ chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

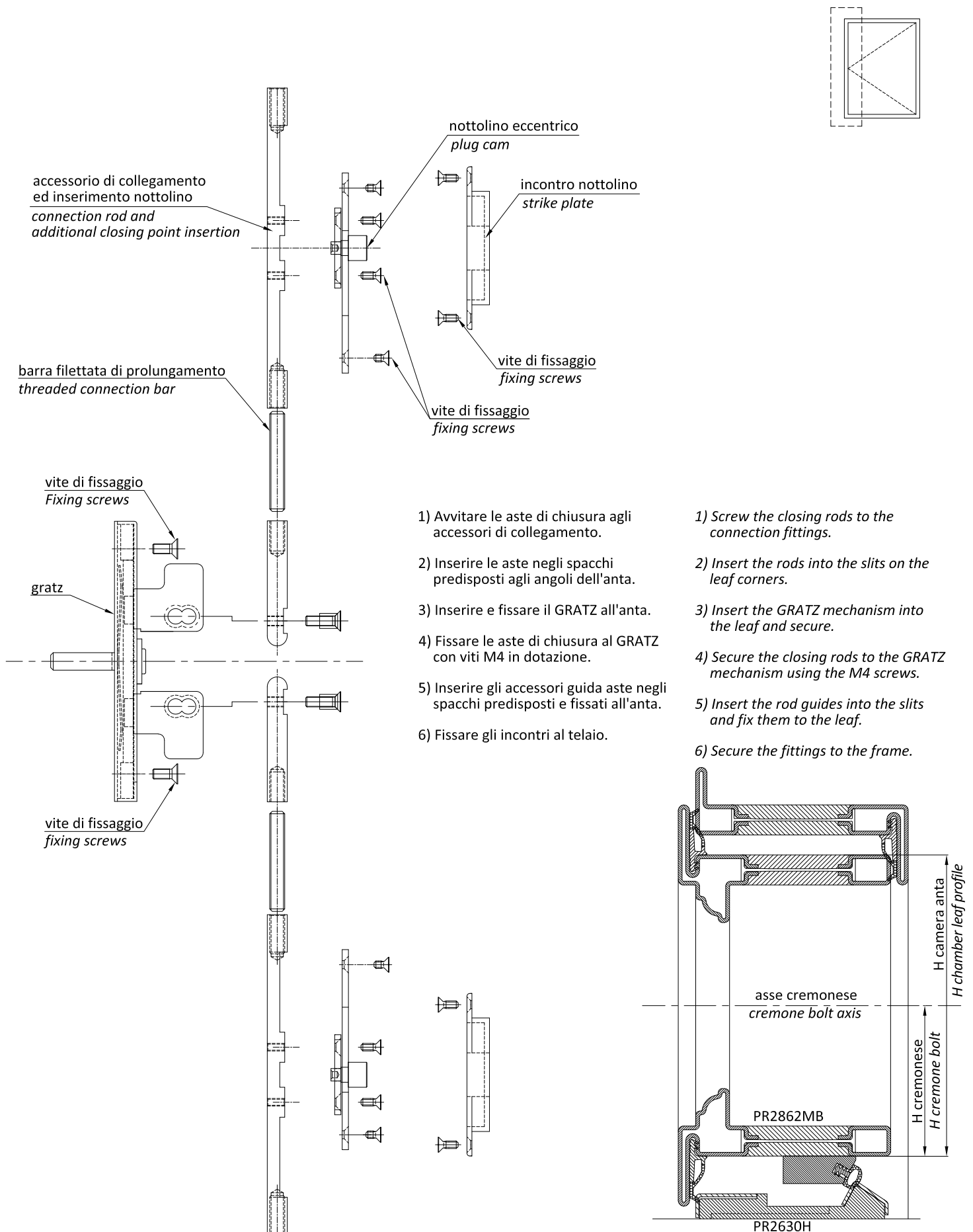
N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max

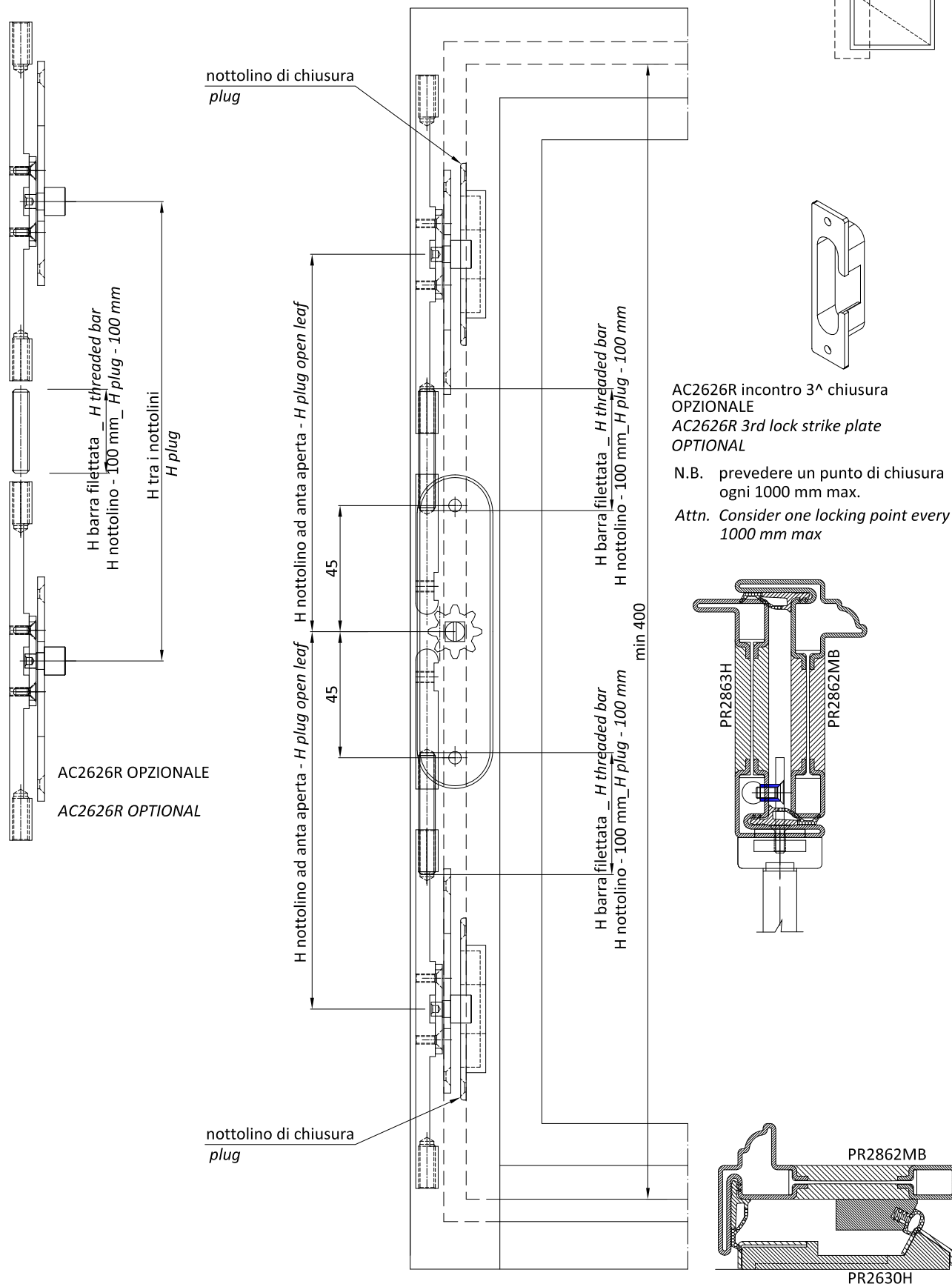


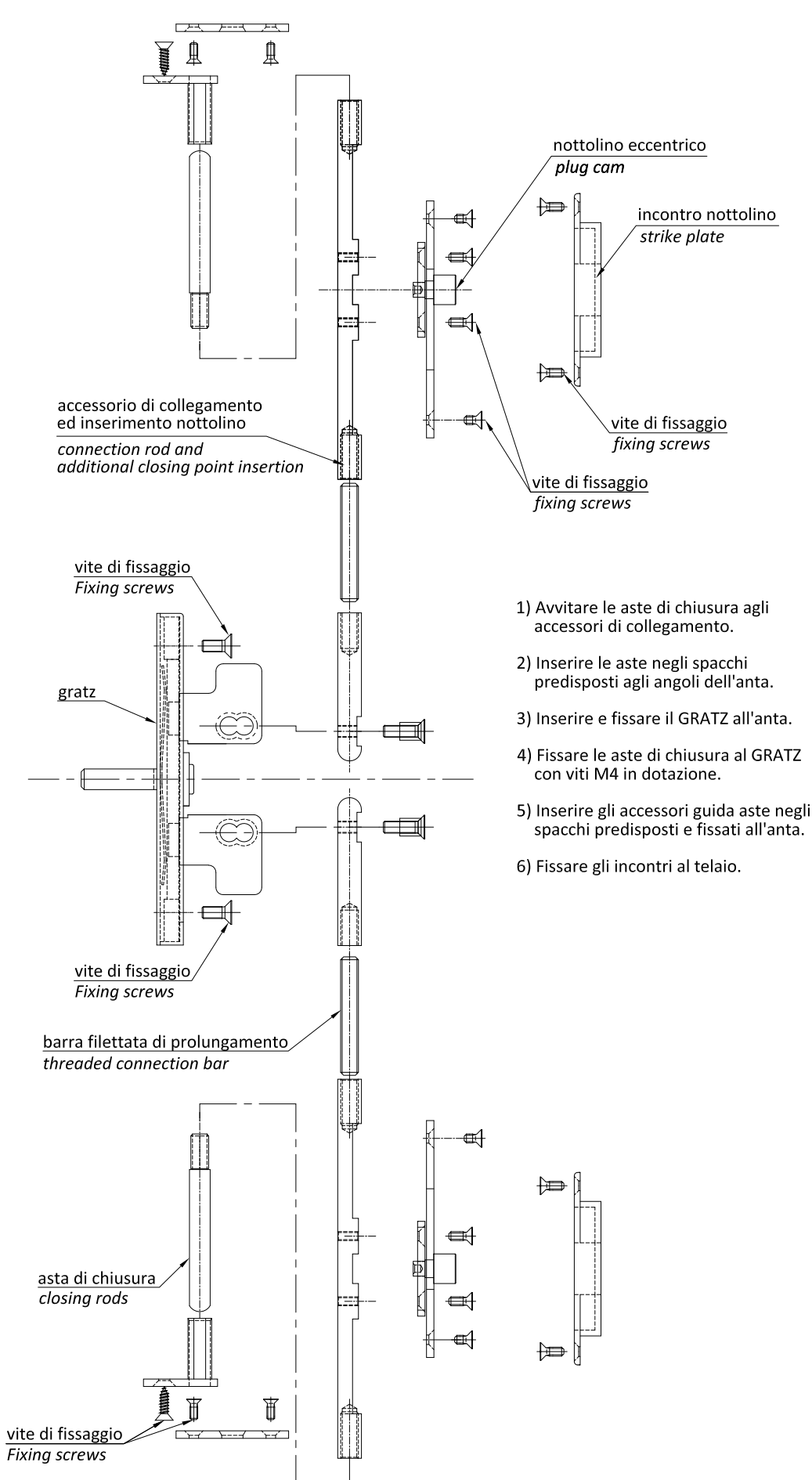






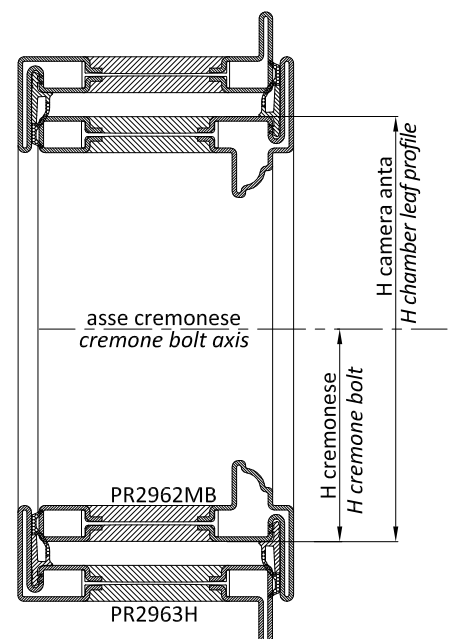


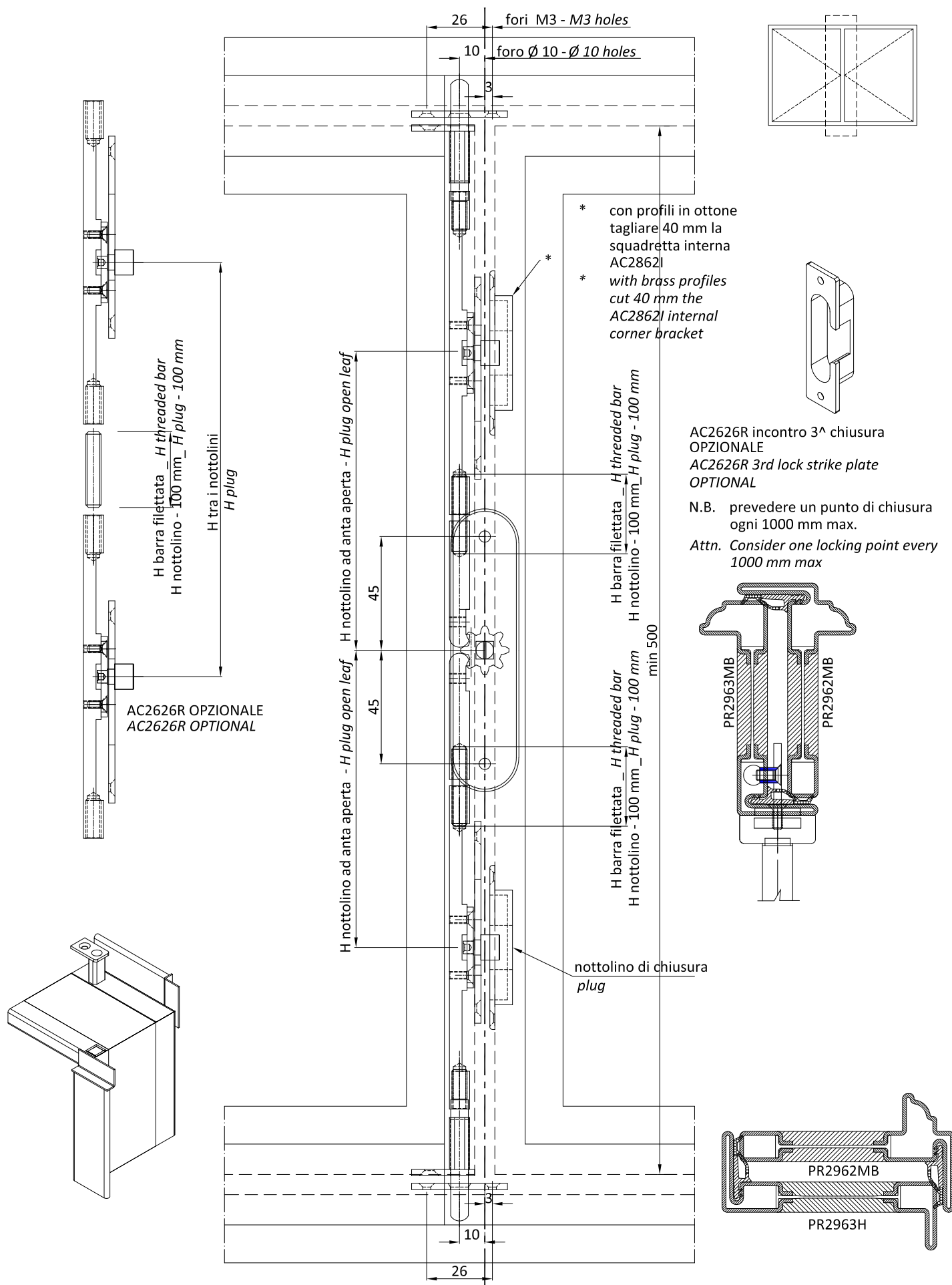


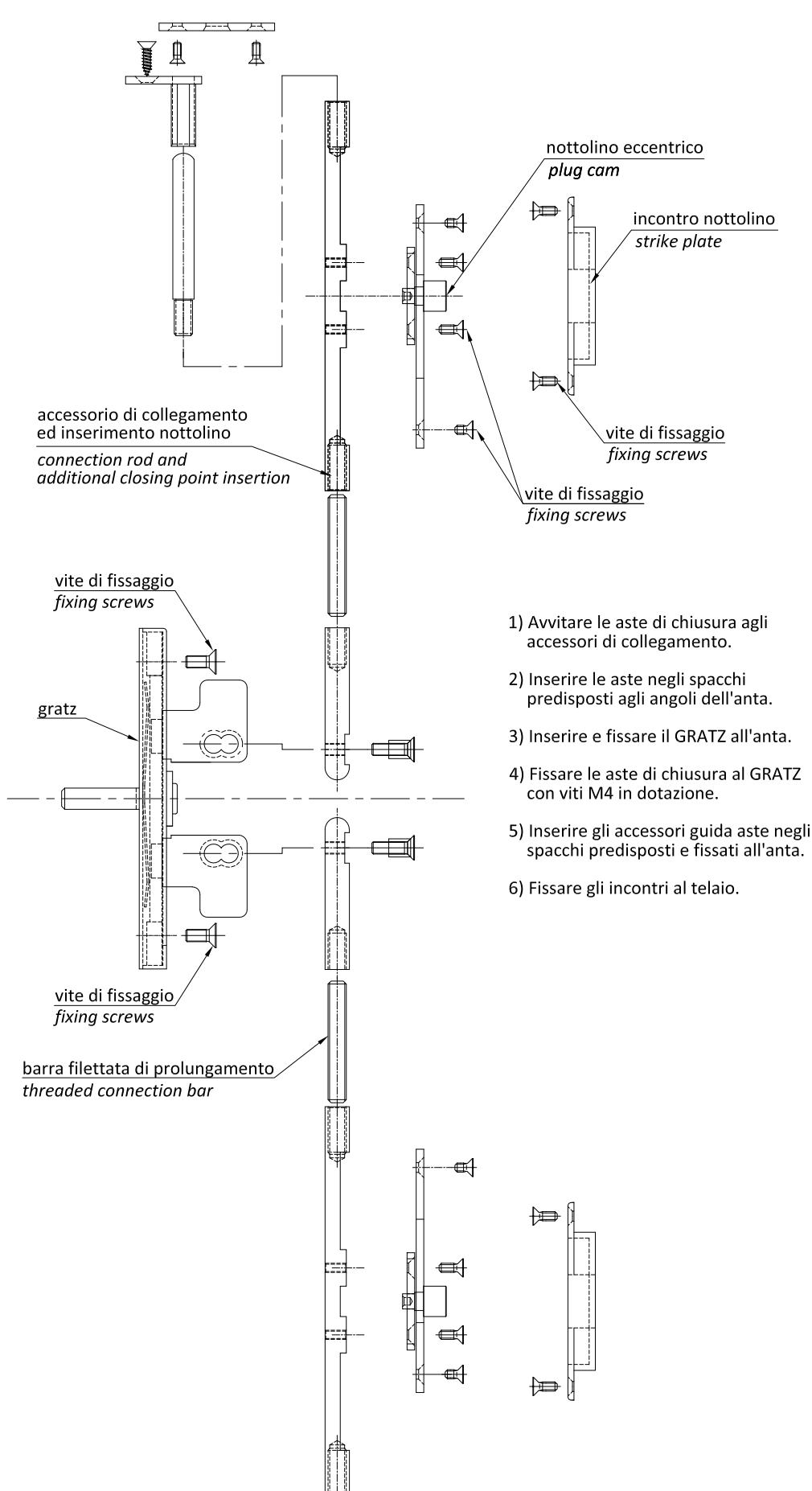


- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi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

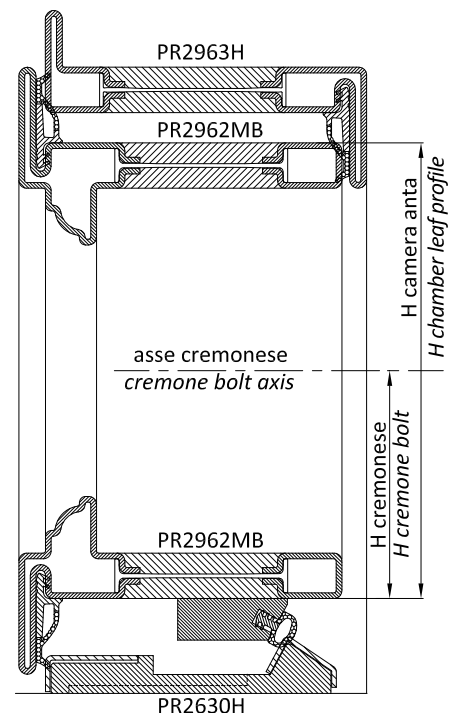


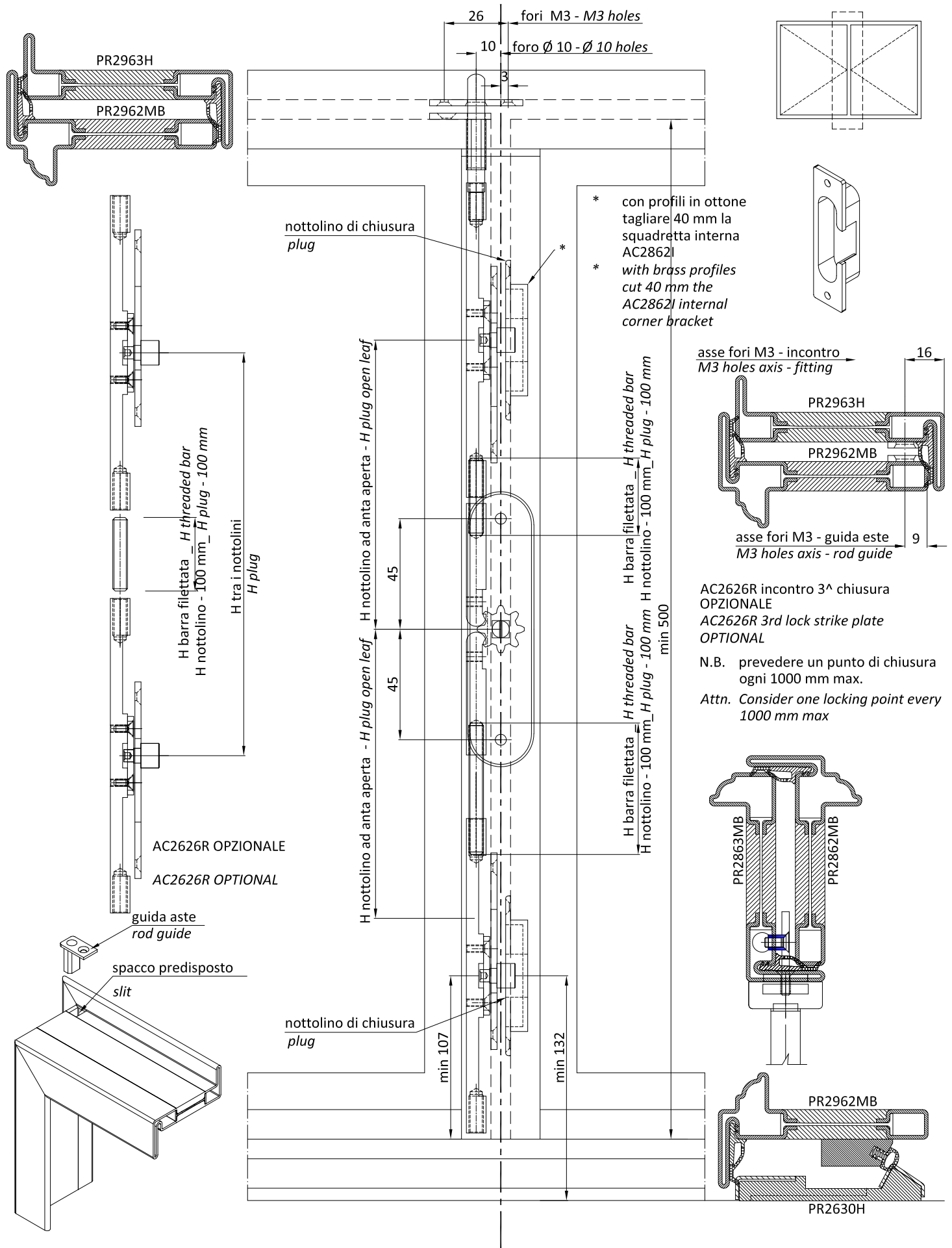


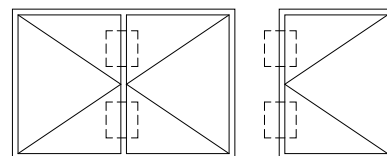
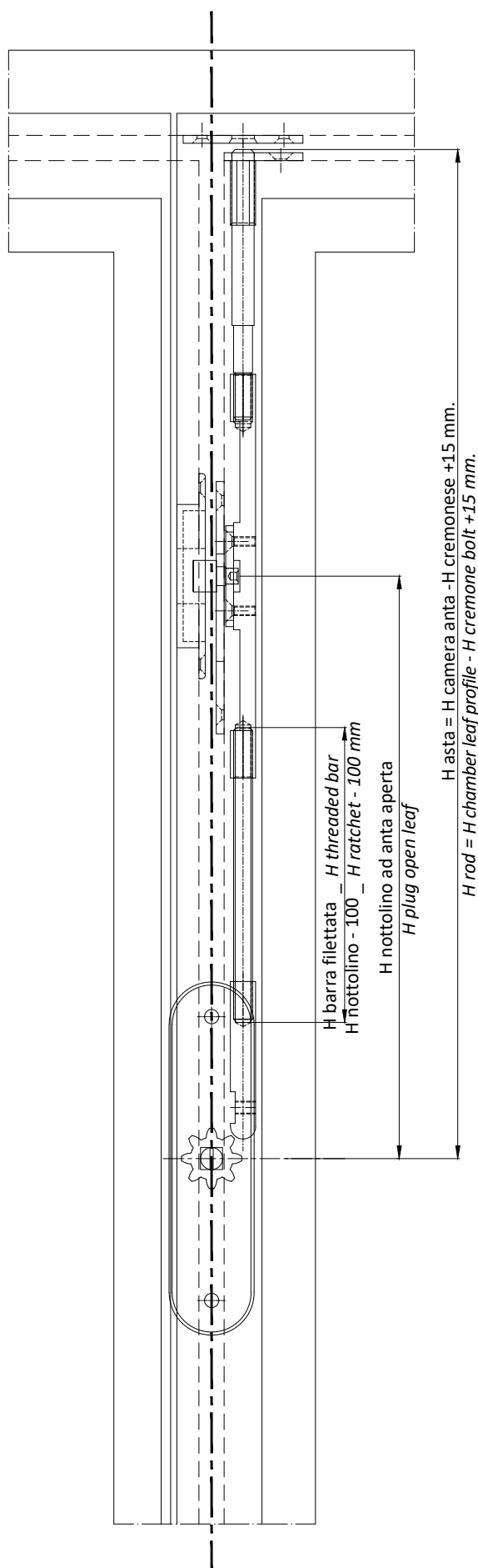


- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi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

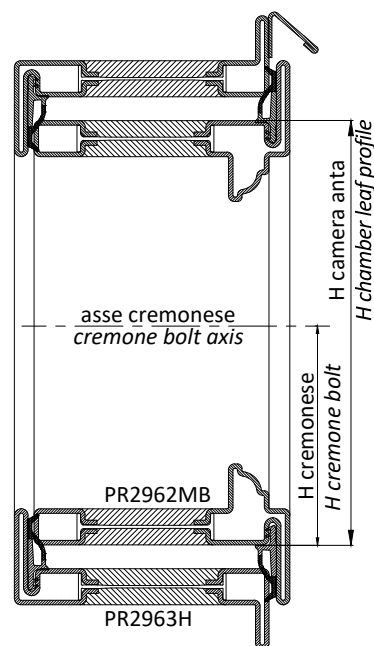
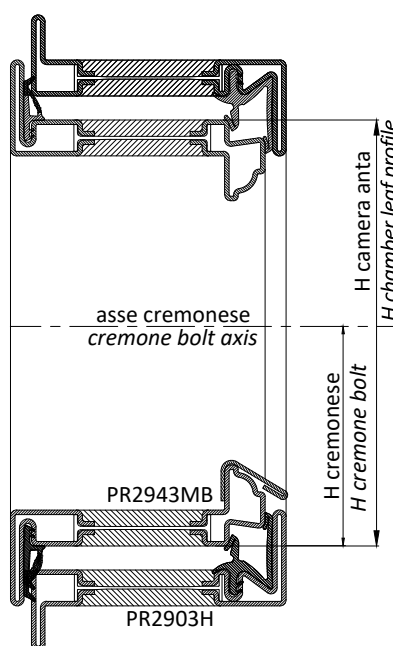
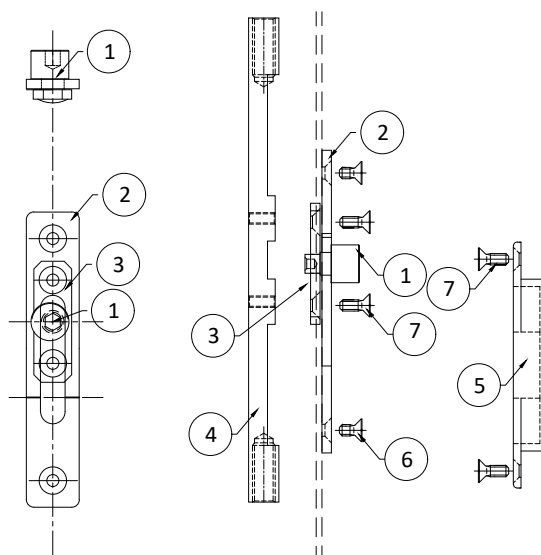


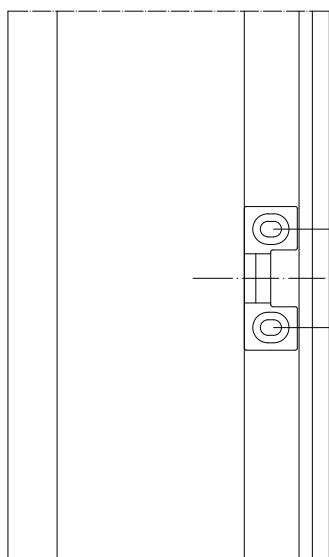
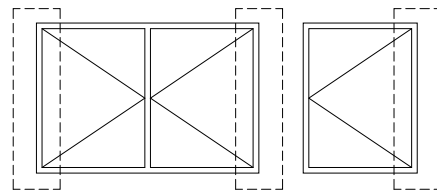
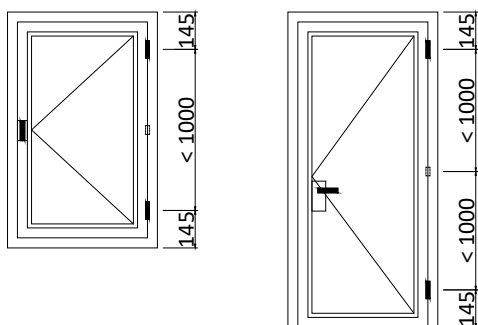




- 1) Rullino eccentrico
- 2) Piastra di fissaggio
- 3) Piastra di collegamento
- 4) Accessorio aggancio aste
- 5) Incontro 3^a chiusura
- 6) viti M3 x 6
- 7) viti M3 x 8

- 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

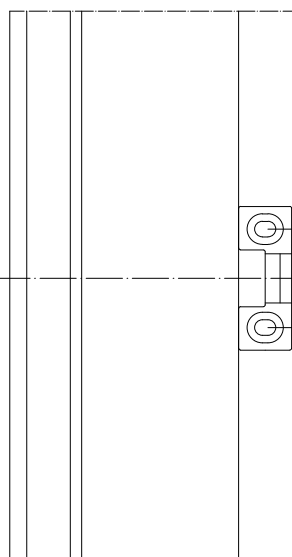




asse fori filettati M4
M4 threaded holes axis

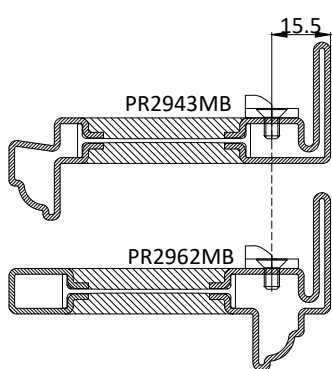
asse chiusura mediana
middle closing axis

26



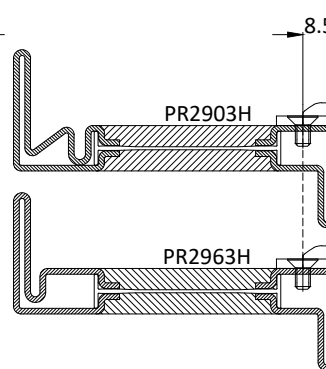
asse fori filettati M4
M4 threaded holes axis

26



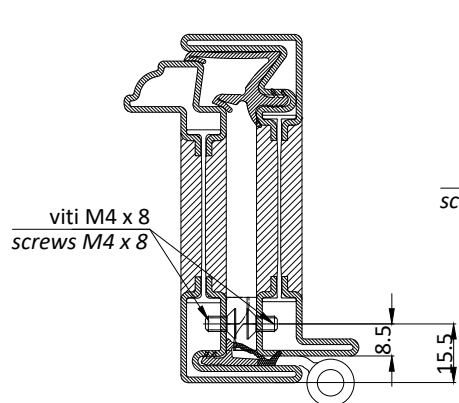
15.5

asse fori filettati M4
M4 threaded holes axis

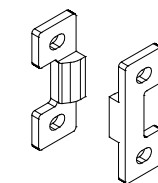
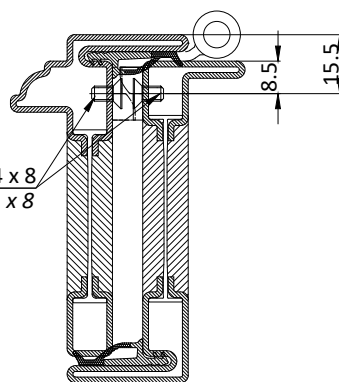


8.5

asse fori filettati M4
M4 threaded holes axis

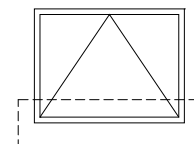
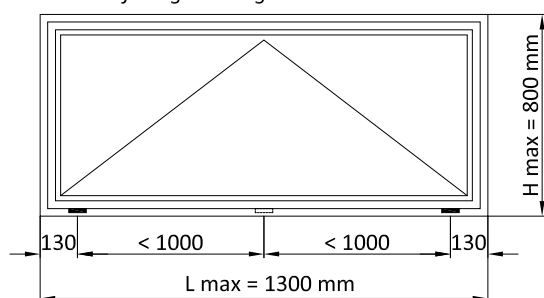


viti M4 x 8
screws M4 x 8



chiusura mediana
Middle closing

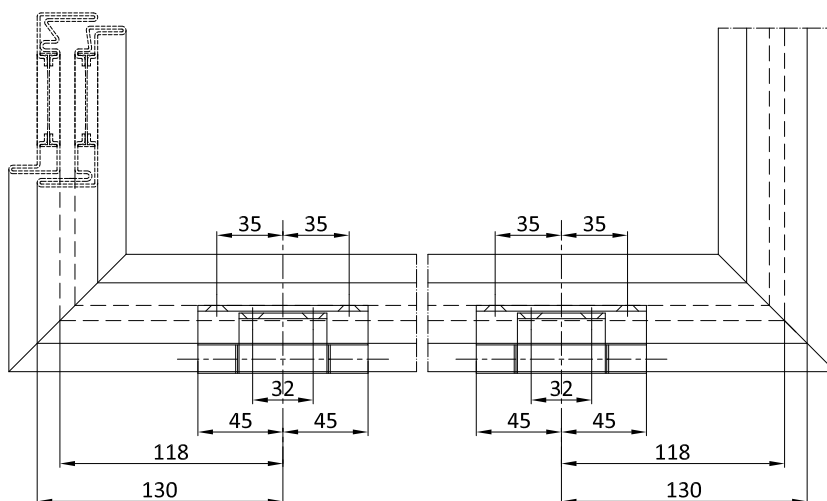
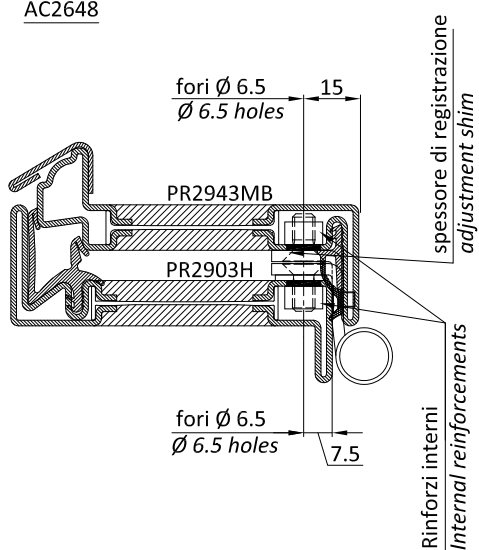
peso max. per anta: 50 kg
max. leaf weight: 50 kg



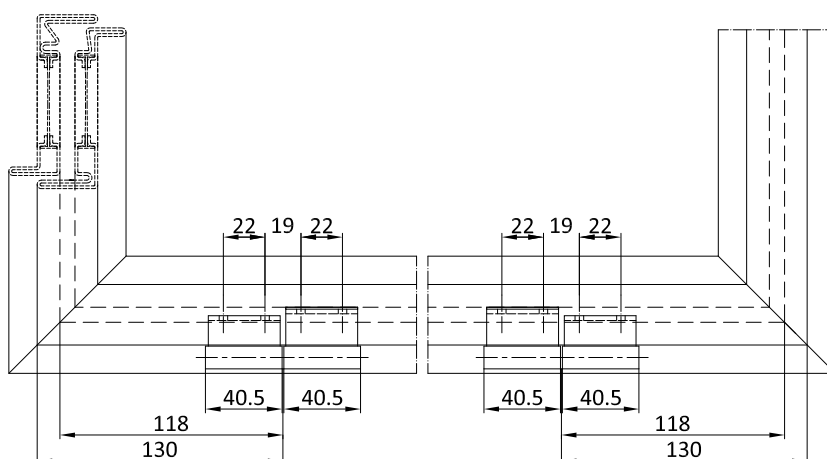
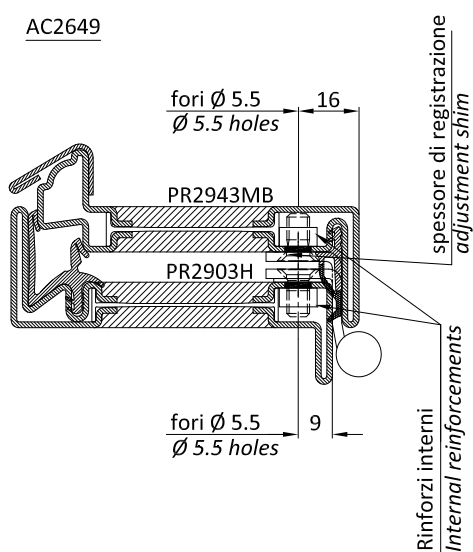
NOTA: Con cerniere AC2648 e AC2649
installare braccetti limitatori AC2641

ATTN: With hinges AC2648 and AC2649
please install the restrictor stay AC2641

AC2648



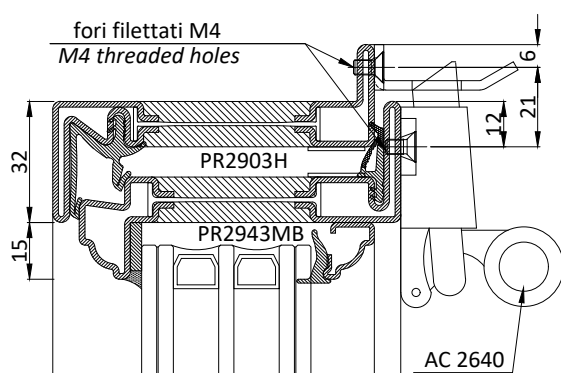
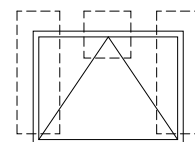
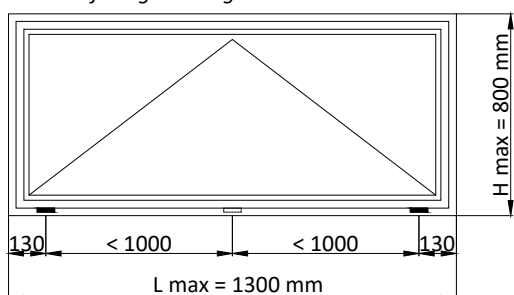
AC2649



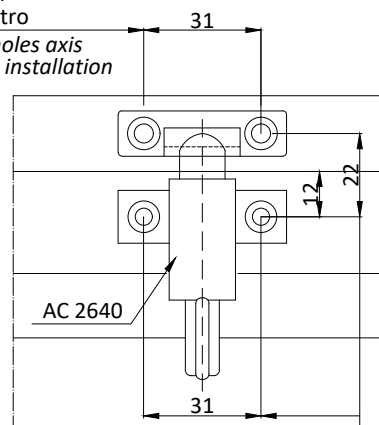
NOTA: Per vasistas installare una cerniera destra
AC2649.ISED e una cerniera sinistra AC2649.IDES

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

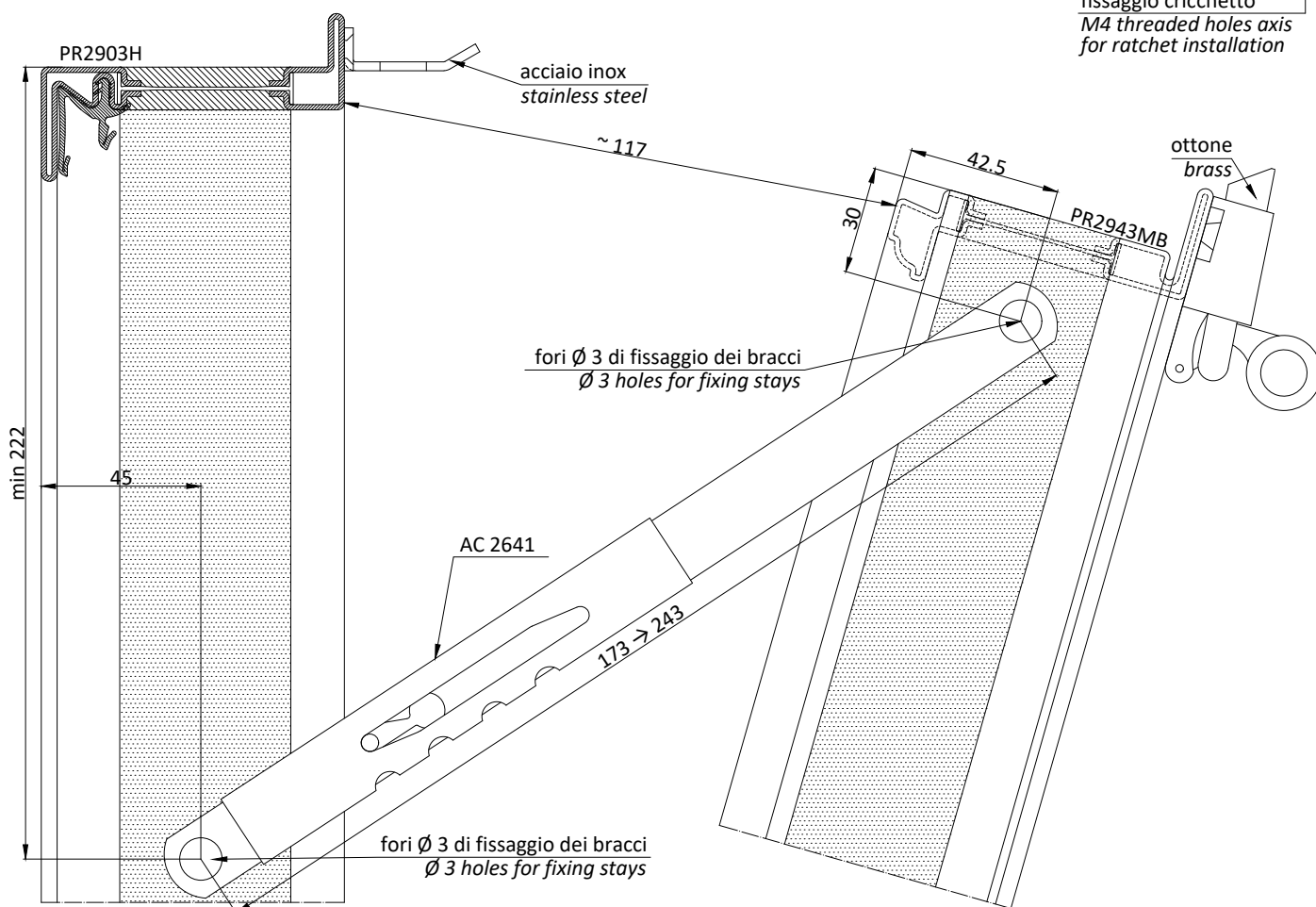
peso max. per anta: 50 kg
max. leaf weight: 50 kg

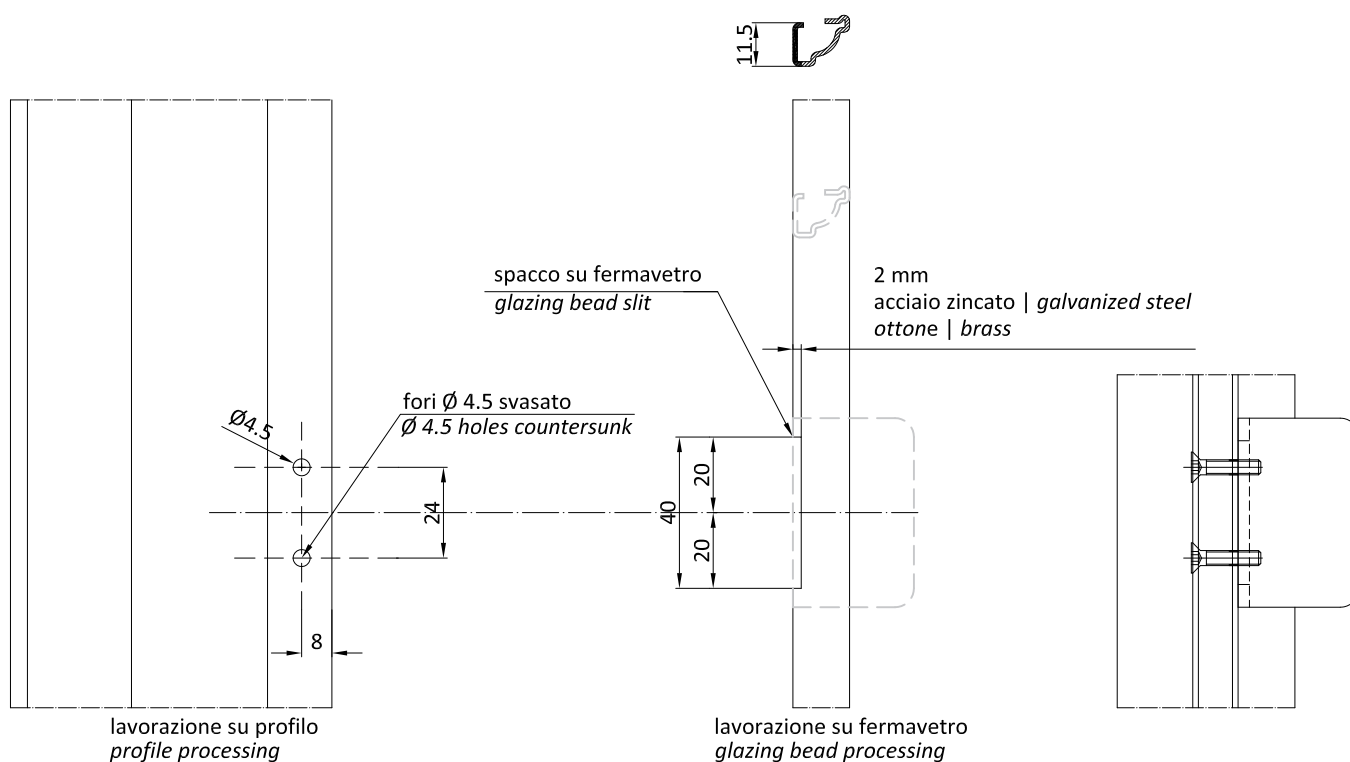
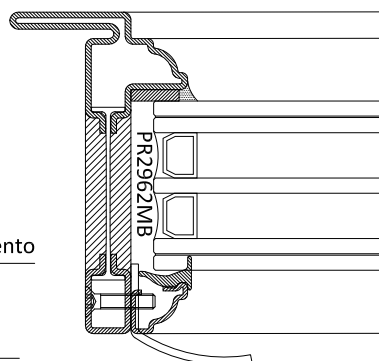
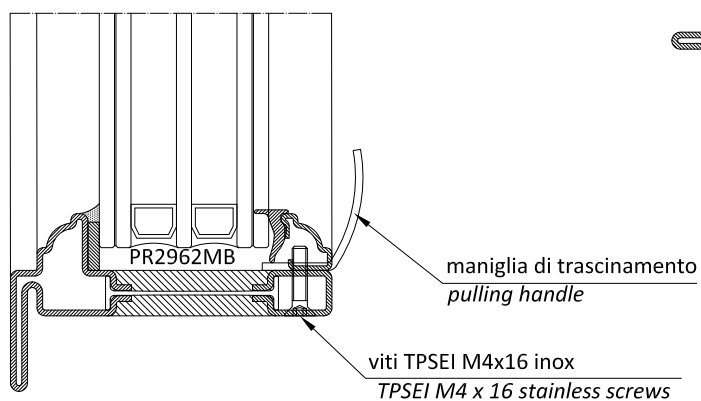
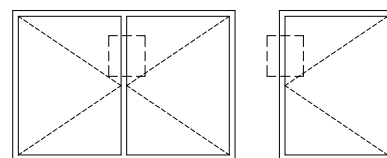
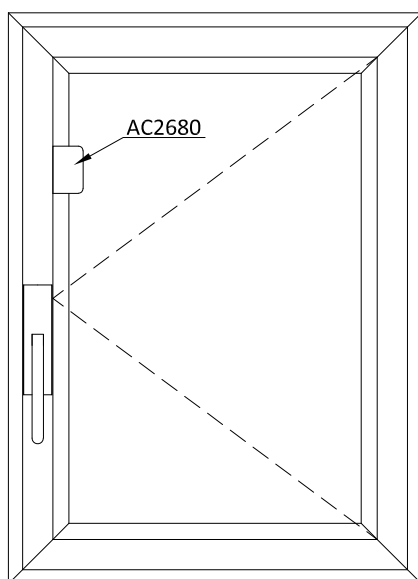


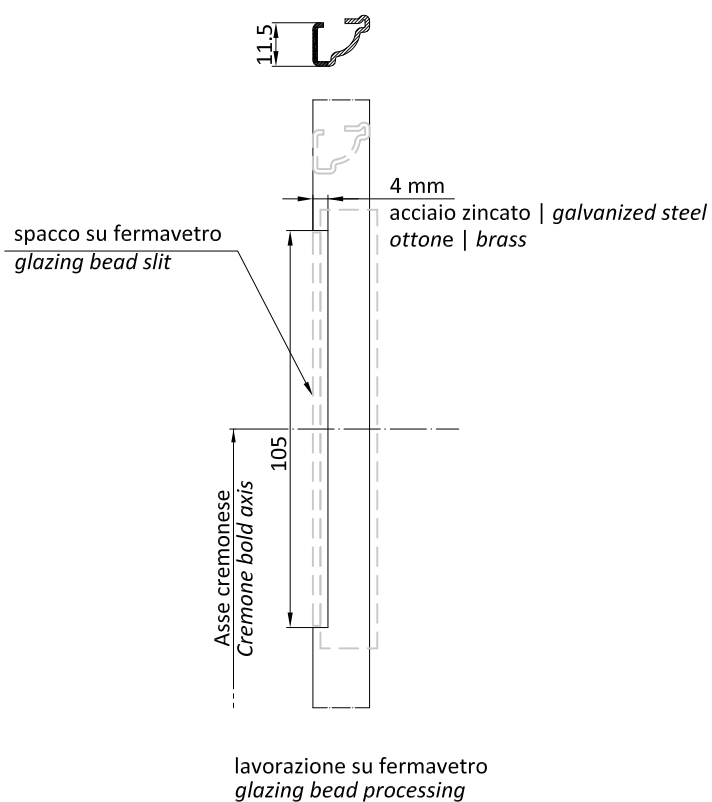
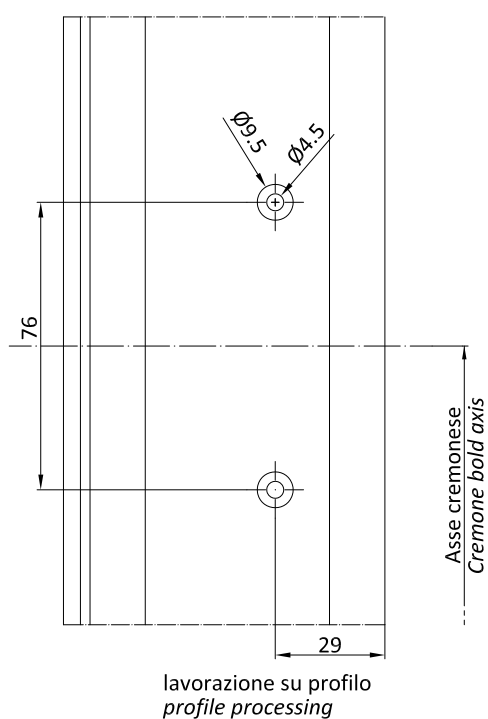
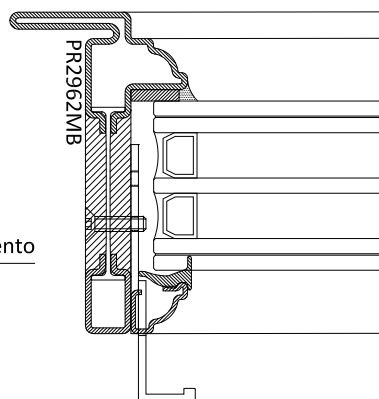
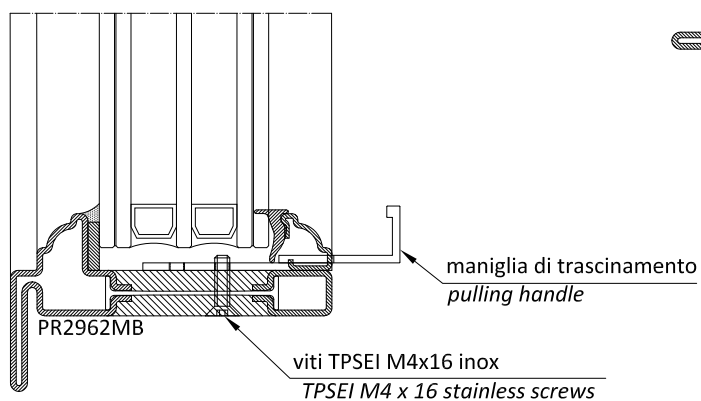
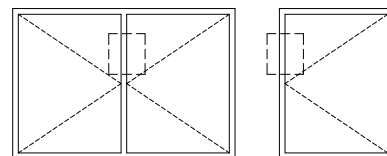
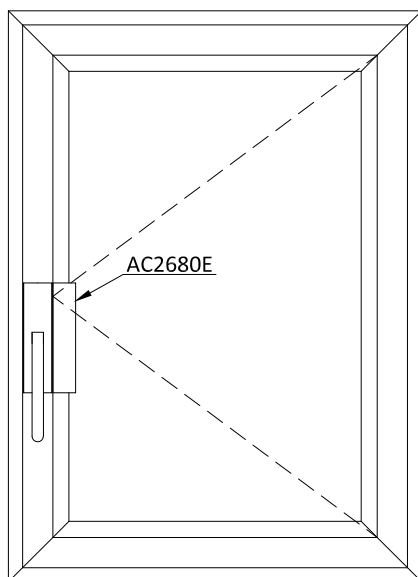
fori filettati M4
fissaggio incontro
M4 threaded holes axis
for strike plate installation

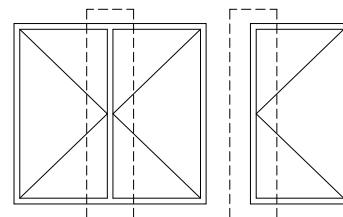
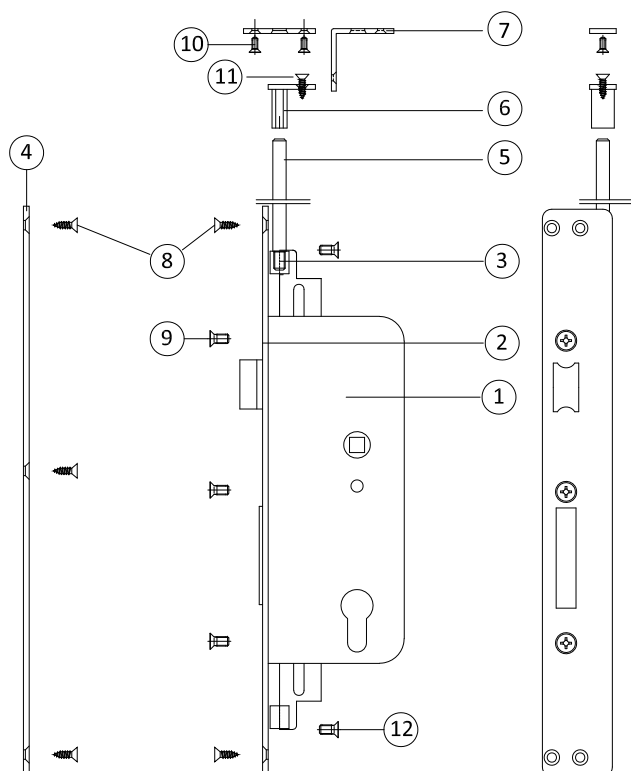


fori filettati M4
fissaggio cricchetto
M4 threaded holes axis
for ratchet installation

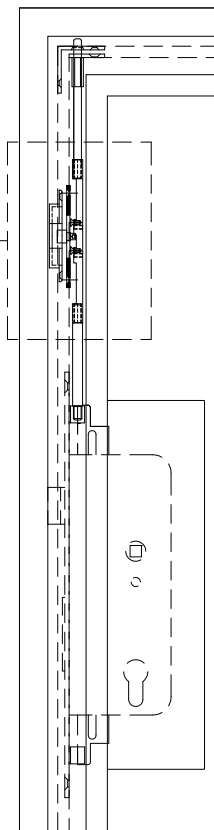








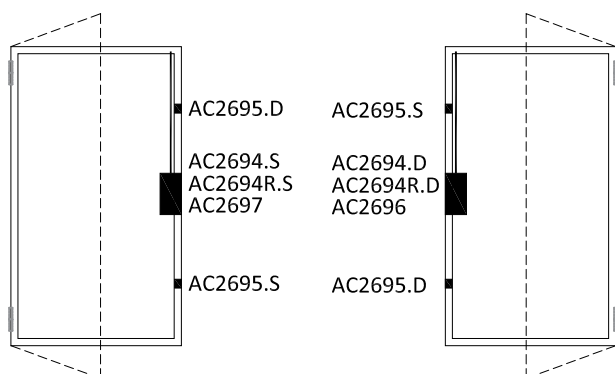
AC2695 OPZIONALE
AC2695 OPTIONAL



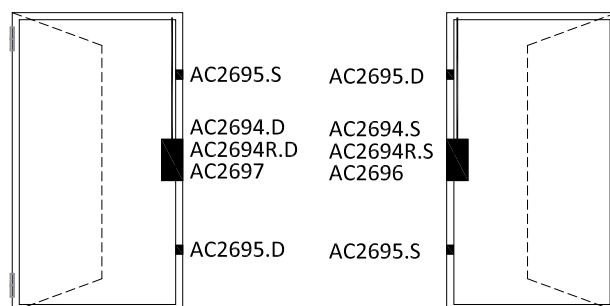
- 1) Serratura
- 2) Frontalino (Dx o Sx)
- 3) Riduttore di collegamento
- 4) Incontro per serratura
- 5) Aste inox
- 6) Guida aste superiore
- 7) Incontro aste per porte a due ante
- 7 bis) Incontro aste per porte ad un'anta
- 8) Viti autof. Inox A2 T.PRT.C. 3,9x13
- 9) Viti Inox T.PRT.C. M5x10
- 10) Viti Inox T.PRE.I. 3x8
- 11) Viti autof. Inox T.PRT.C. 3,5x13
- 12) Viti Inox T.S.PRE.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.PRT.C. 3,9x13 self-drilling stainless screws
- 9) T.PRT.C. M5x10 stainless screws
- 10) T.PRE.I. 3x8 stainless screws
- 11) T.PRT.C. 3,5x13 self-drilling stainless screws
- 12) T.S.PRE.I. M4x8 stainless screws

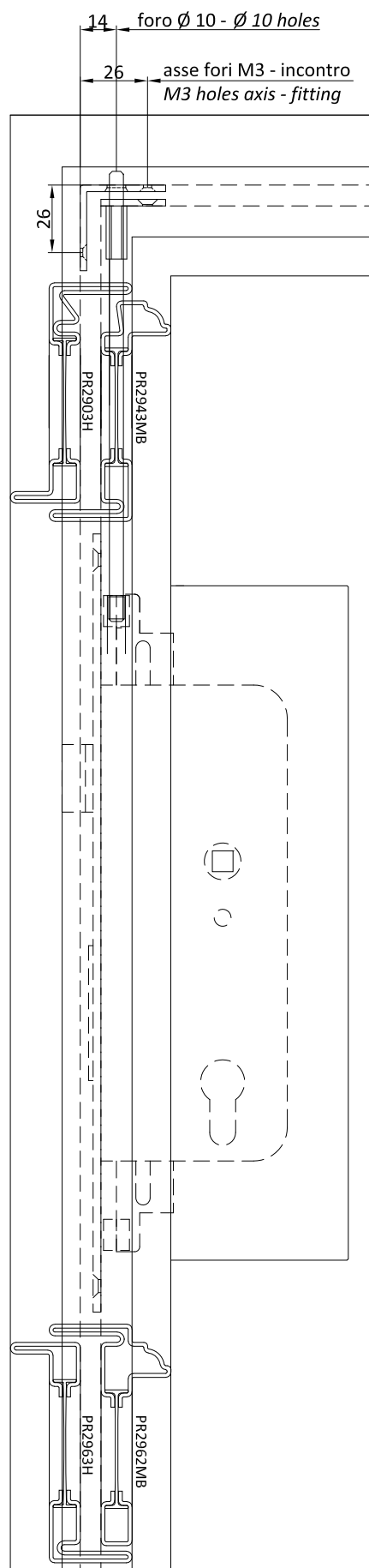
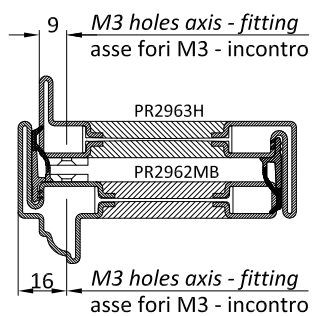
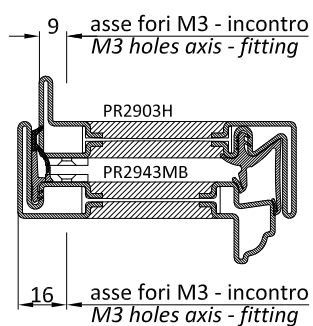
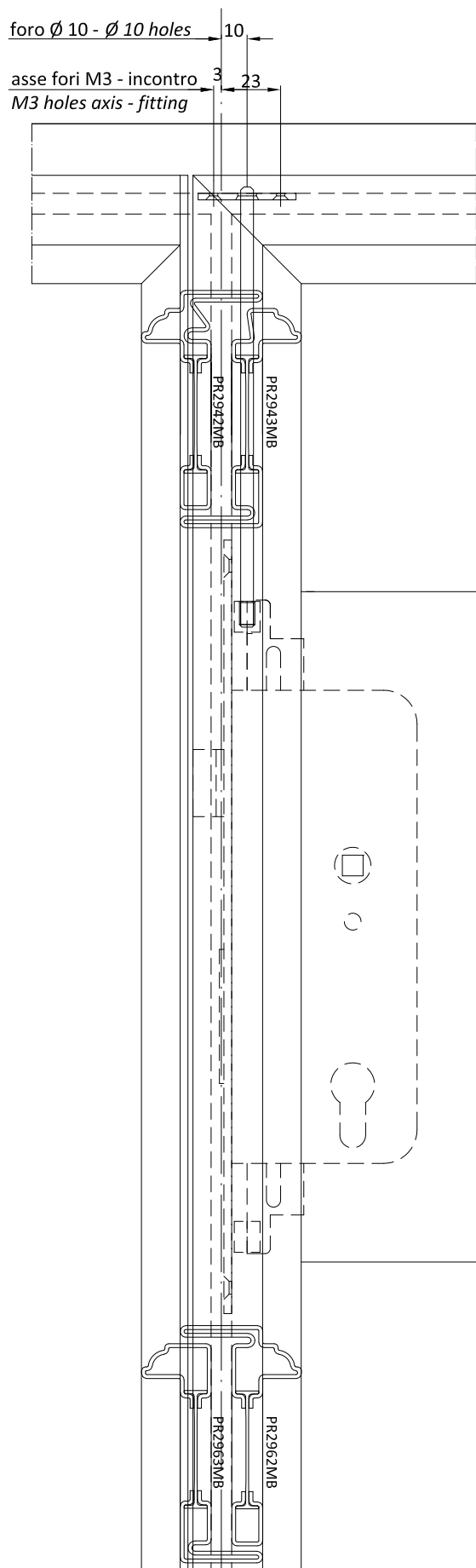
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE CHART FOR THE USE OF LOCKS AND THIRD LOCKS



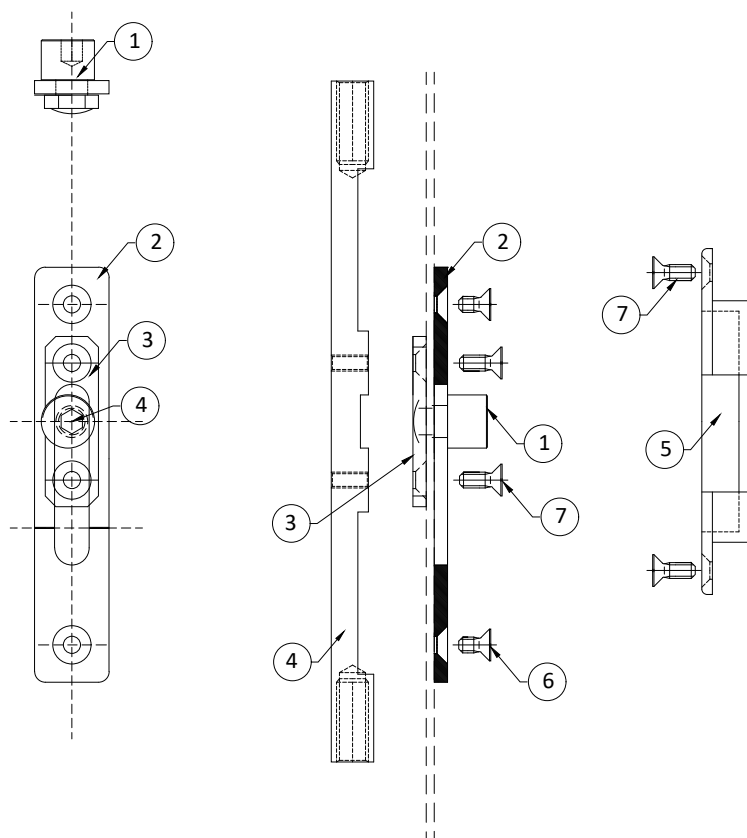
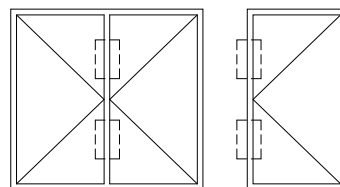
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



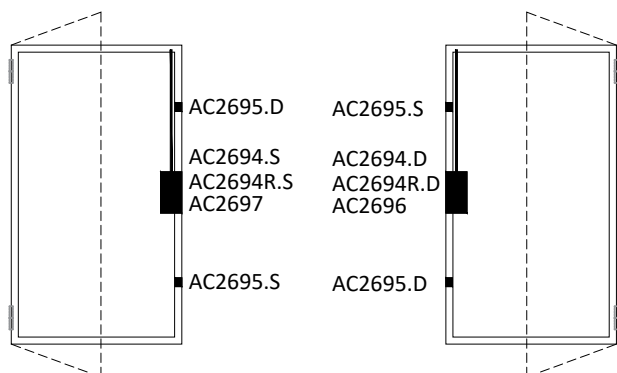
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



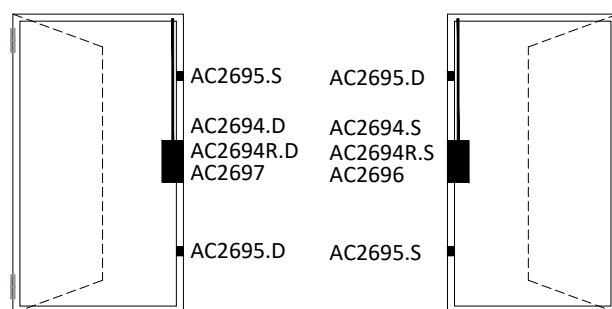
- | | |
|-------------------------------------|--------------------------|
| 1) Rullino eccentrico | 1) Barrel cam |
| 2) Piastra di fissaggio | 2) Installation plate |
| 3) Piastra di collegamento | 3) Connecting plate |
| 4) Accessorio aggancio aste | 4) Rod docking accessory |
| 5) Incontro 3 ^a chiusura | 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 |



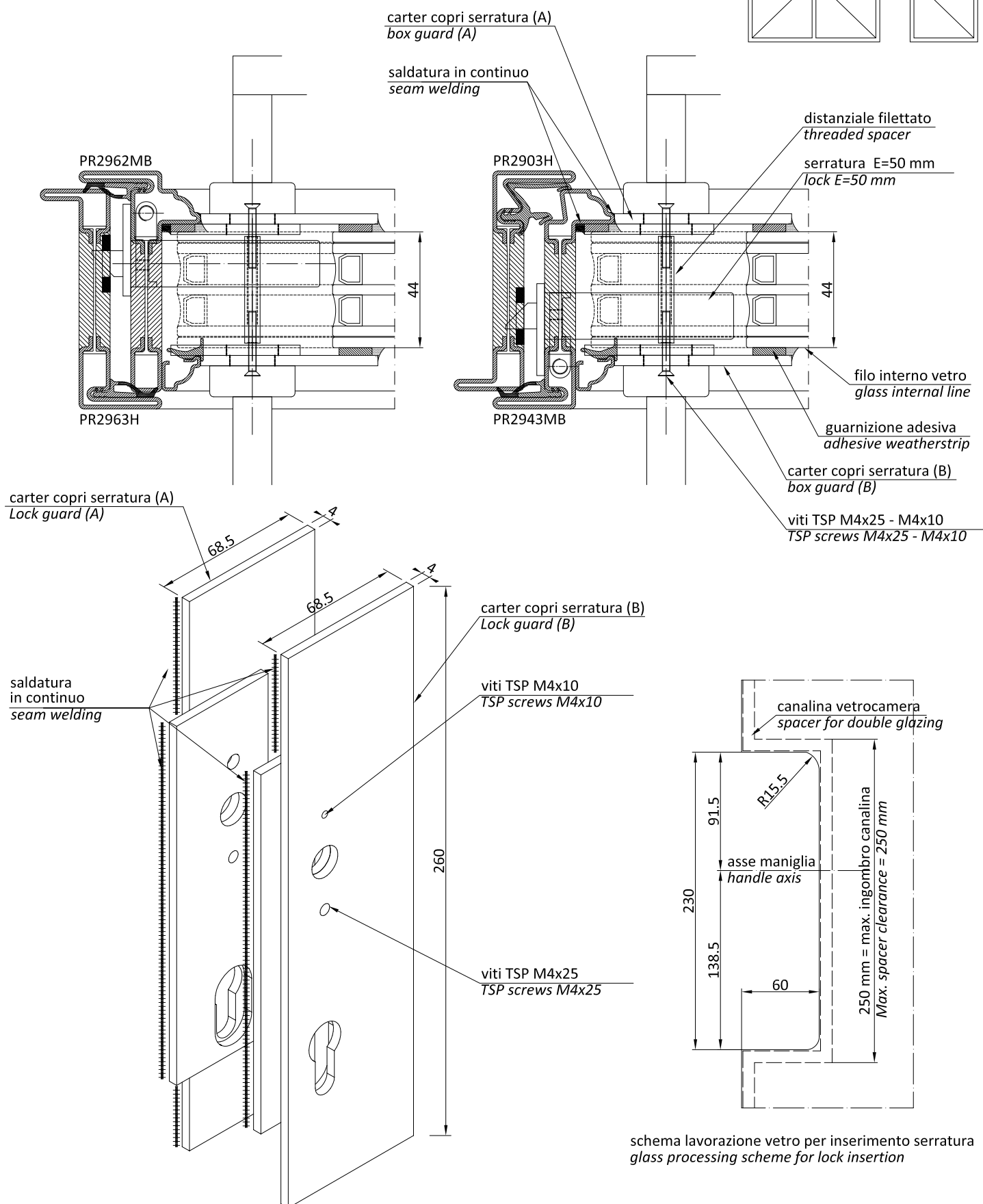
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

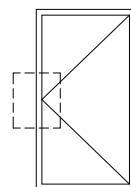


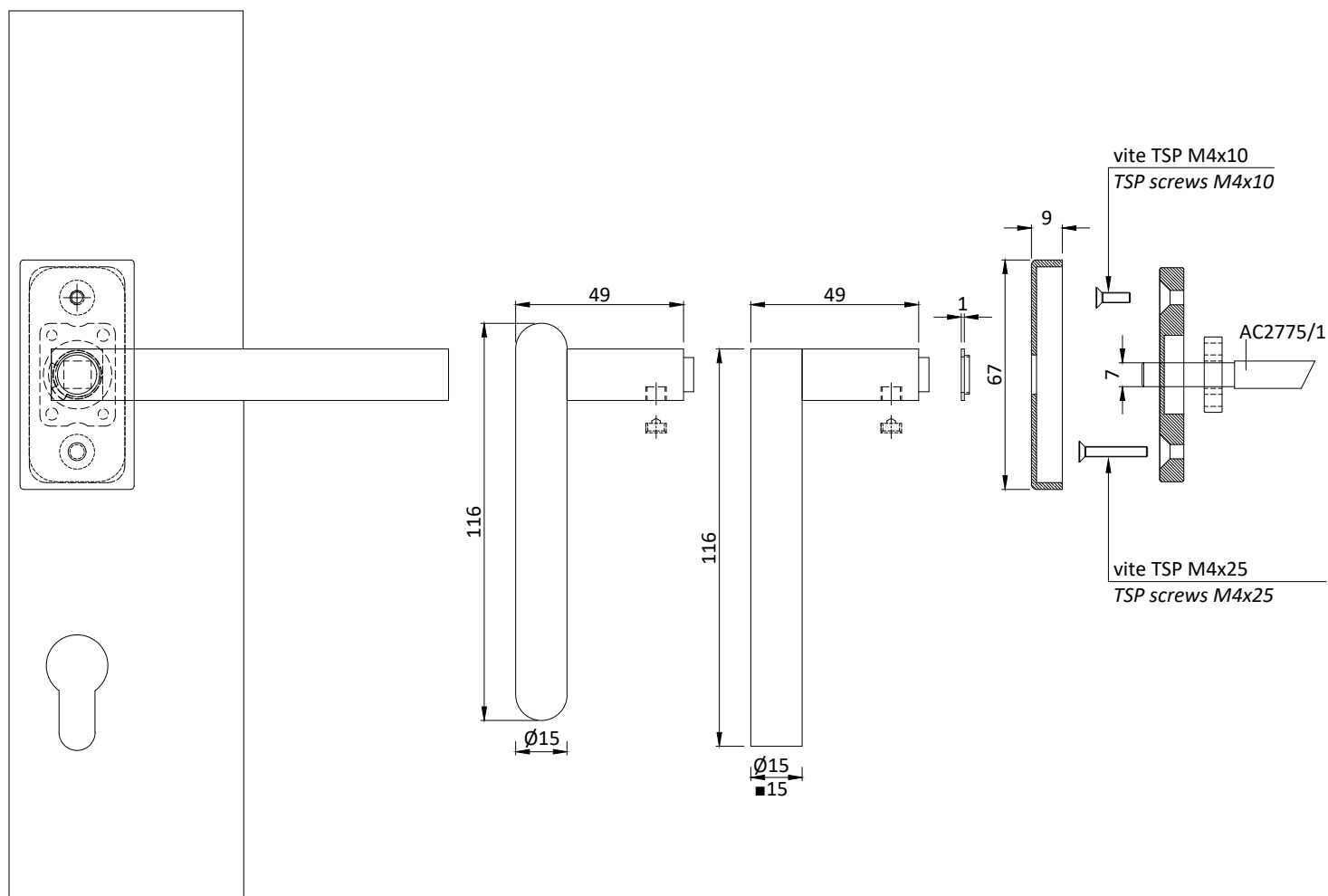
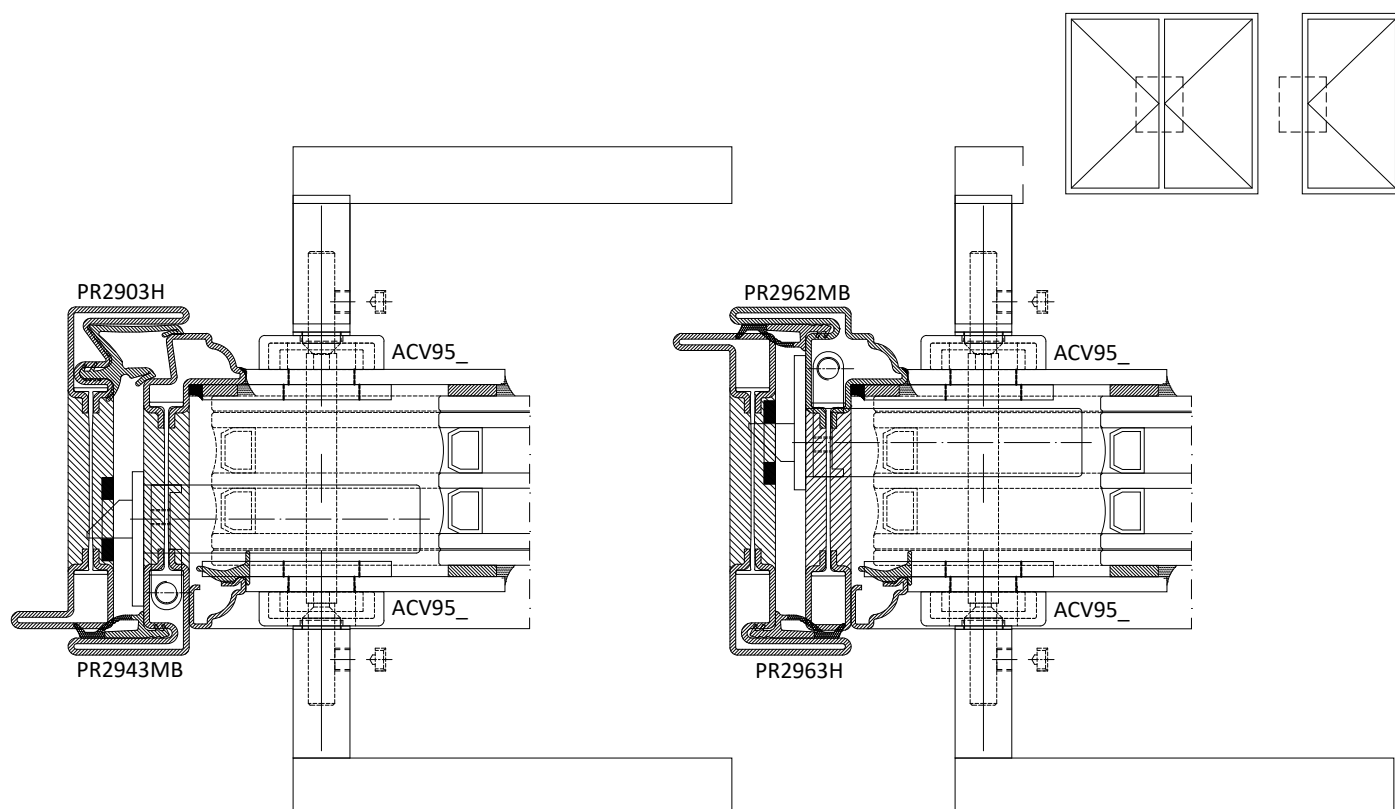
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

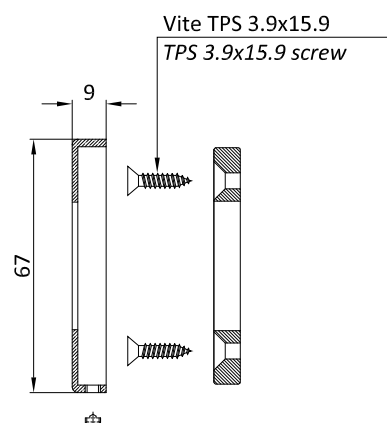
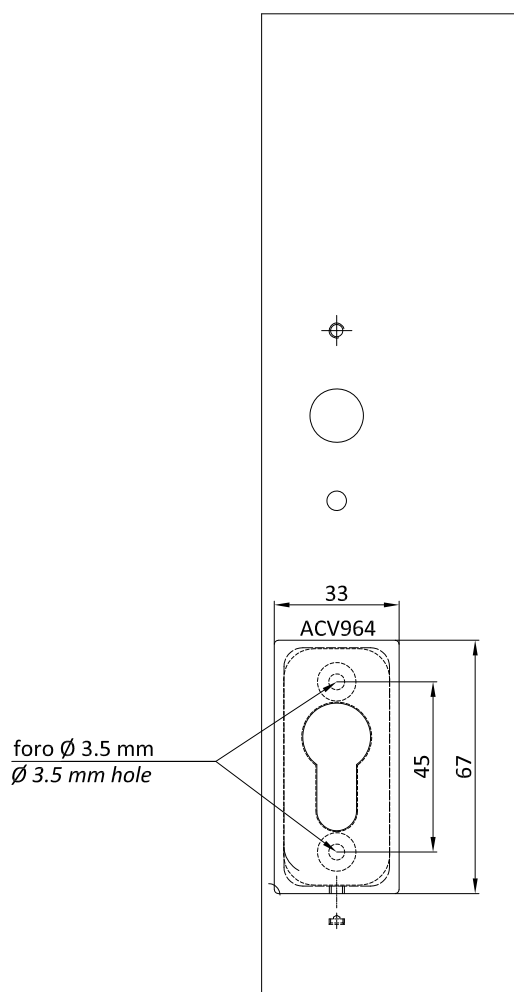
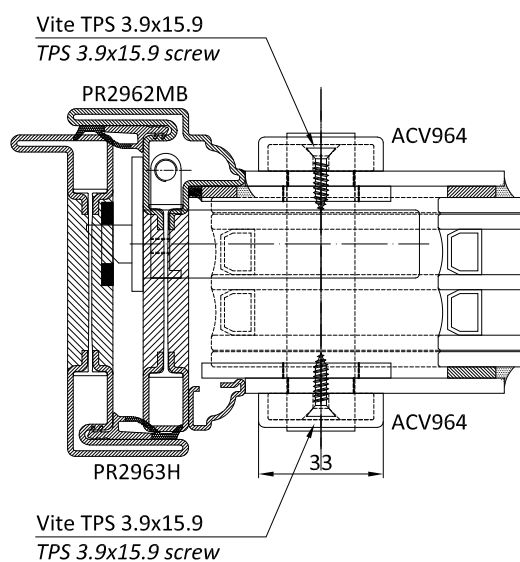
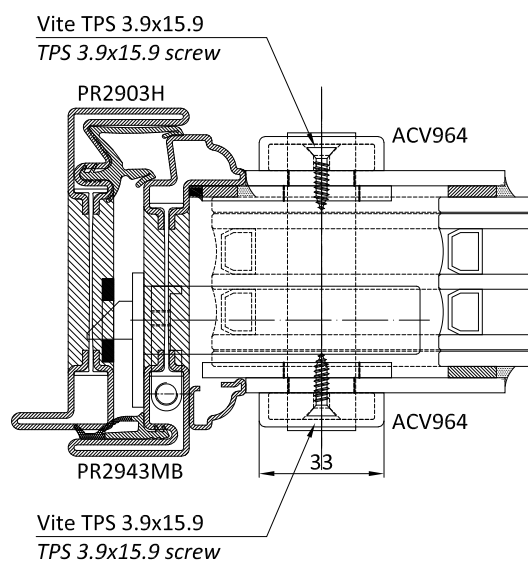
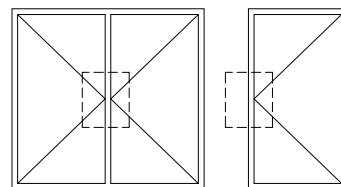


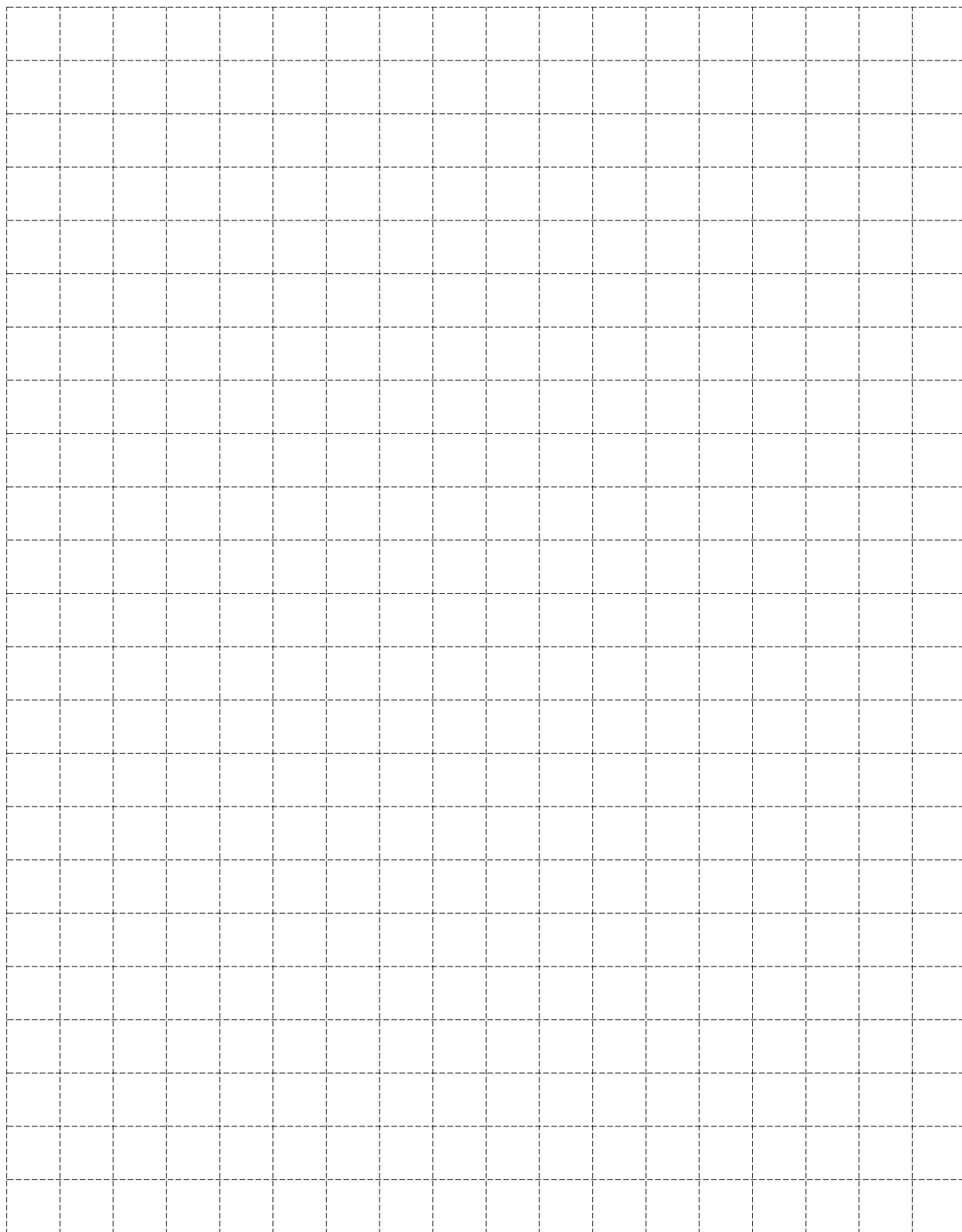
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

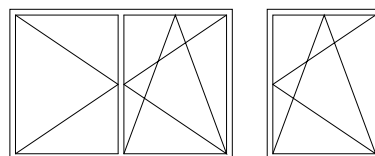




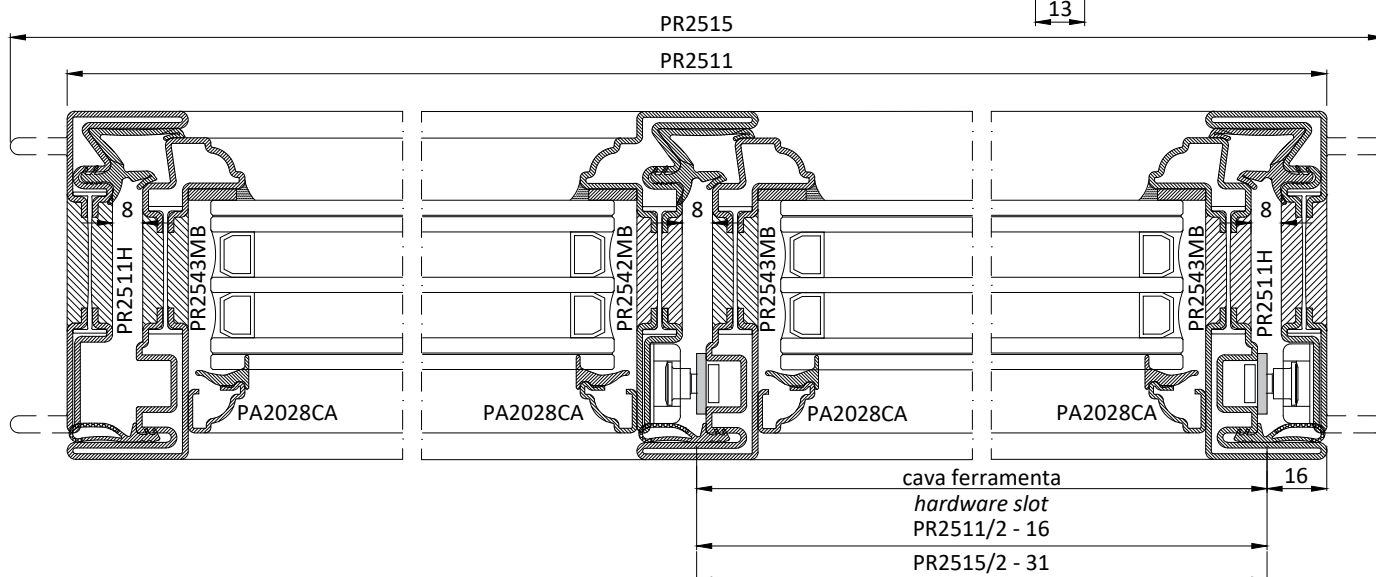
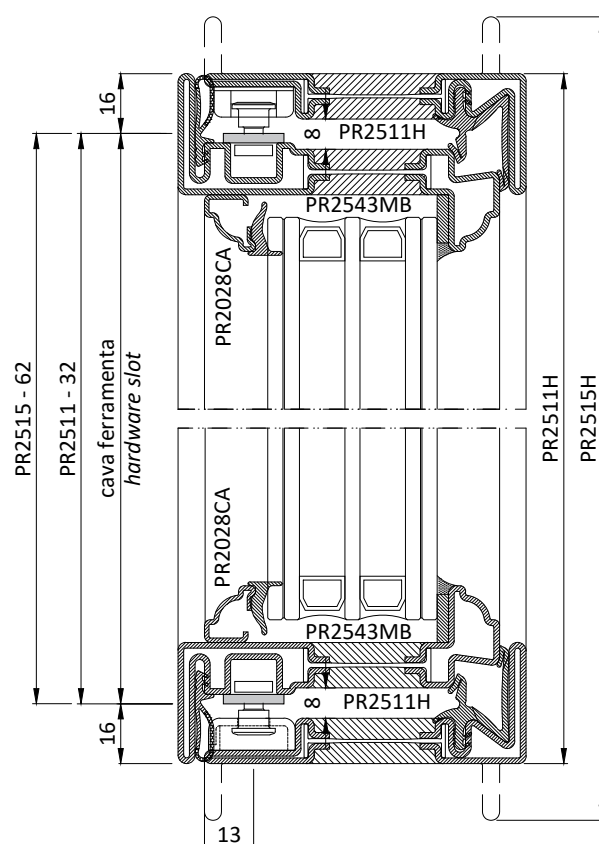
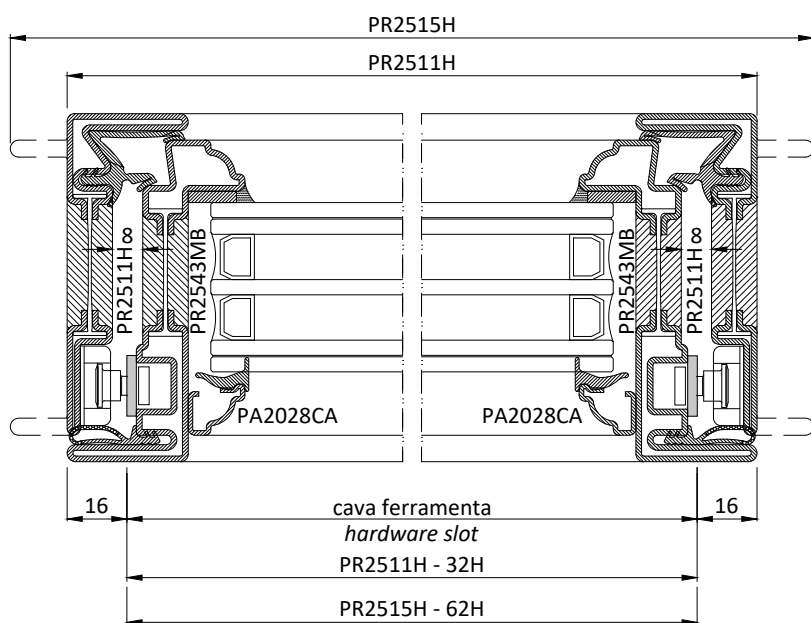




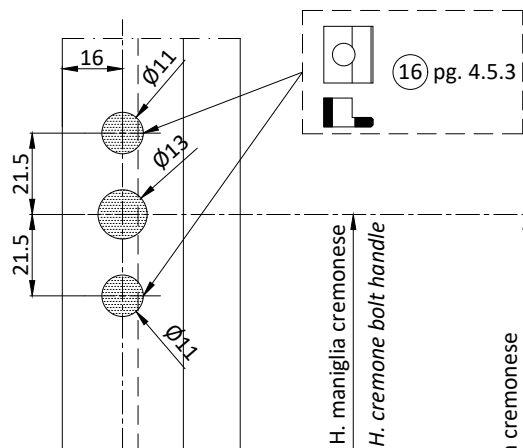


AGE581-2-5-6
AG2578130 kg
80 kgEasy
Easy

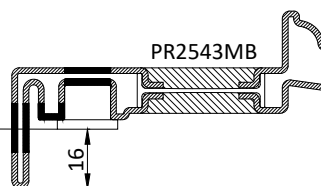
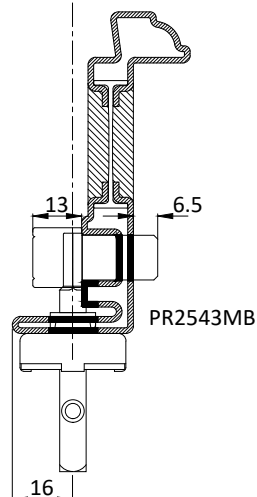
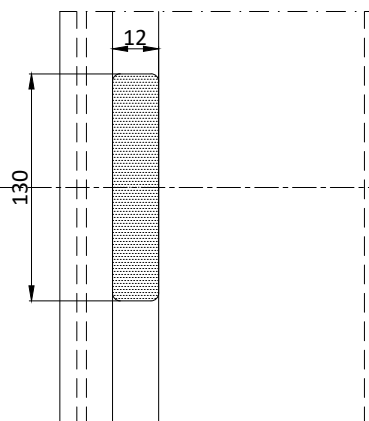
		H altezza - height											
Easy		670 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400	2401 2600	2601 2800	2801 2900
L larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1	J1	K1	L1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2	J2	K2	L2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3	J3	K3	L3
	1201-1400	-	-	-	D4	E4	F4	G4	H4	I4	J4	K4	-



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



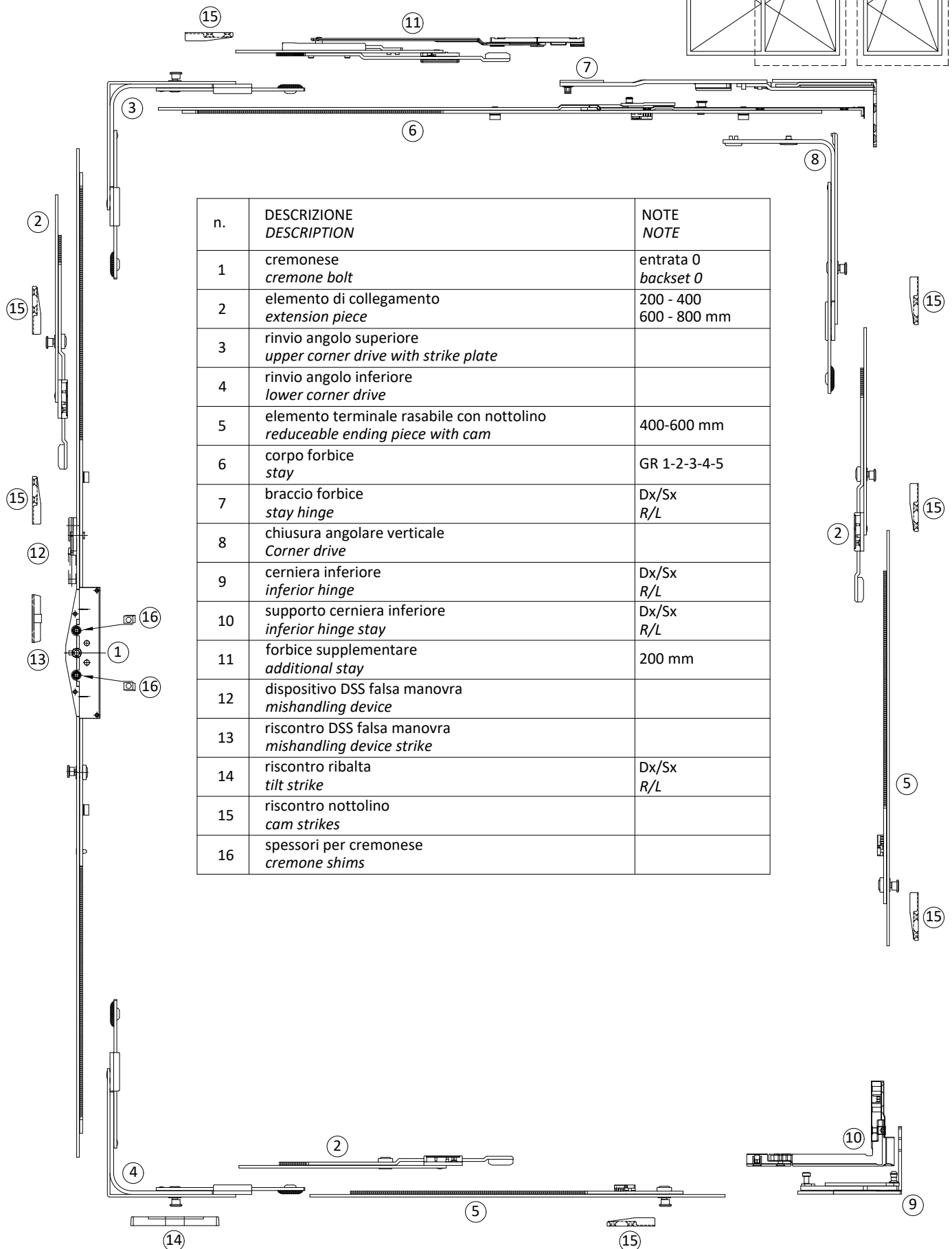
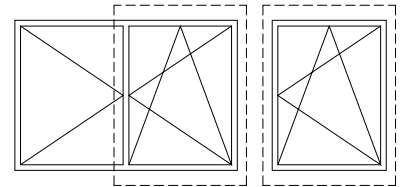
Asola per inserimento meccanismo cremone
Slot for insertion of cremone mechanism



ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	H cava ferramenta - H hardware slot Easy - RC2	H maniglia cremone 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

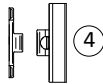
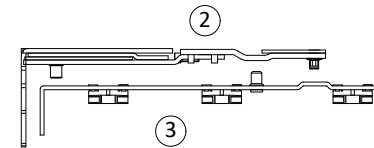
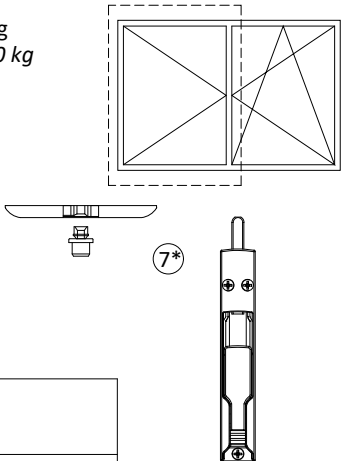
Easy

peso massimo anta 130 kg
maximum leaf weight 130 kg



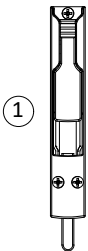
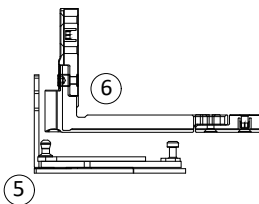
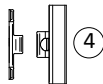
Easy

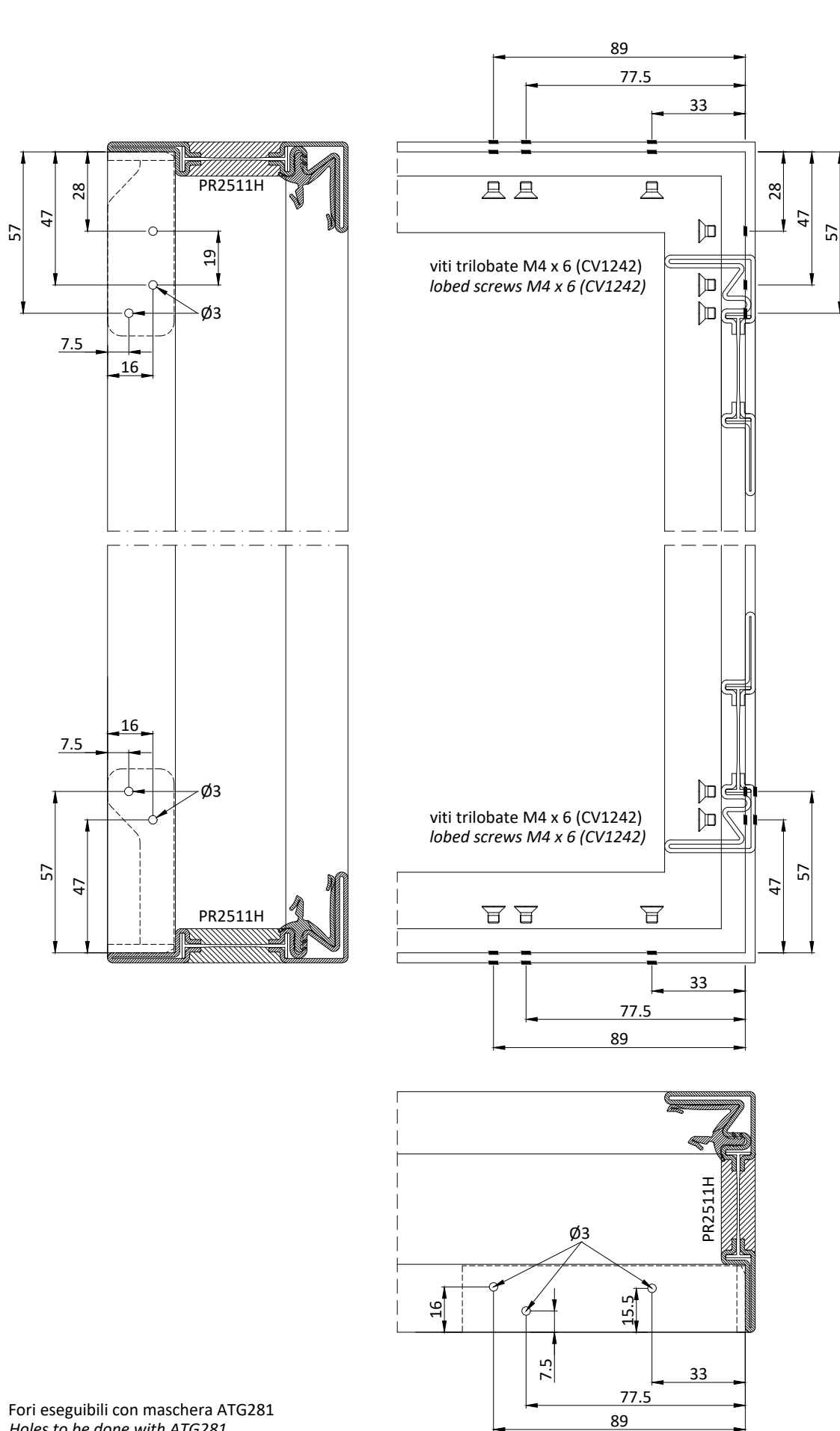
peso massimo anta 130 kg
maximum leaf weight 130 kg



n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	catenaccio inferiore seconda anta lower 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
7	snapper o catenaccio superiore* snapper or upper flush bolt*	650-850 mm

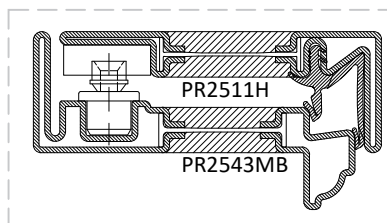
* catenaccio per H > 1800 mm
* flush bolt for H>1800 mm





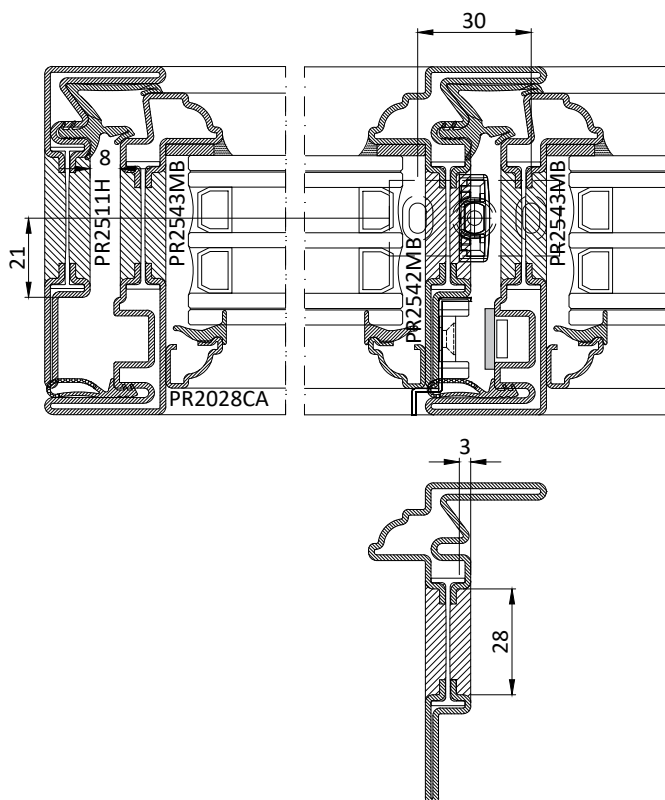
Fori eseguibili con maschera ATG281
Holes to be done with ATG281

* chiusura superiore con fermo a scatto
* upper closure with snapper



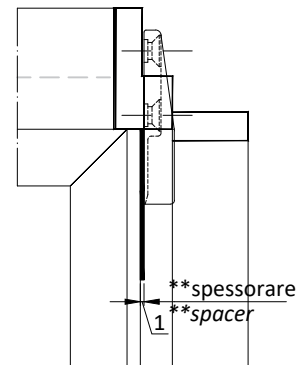
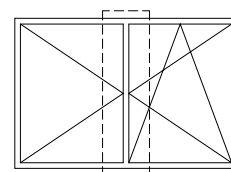
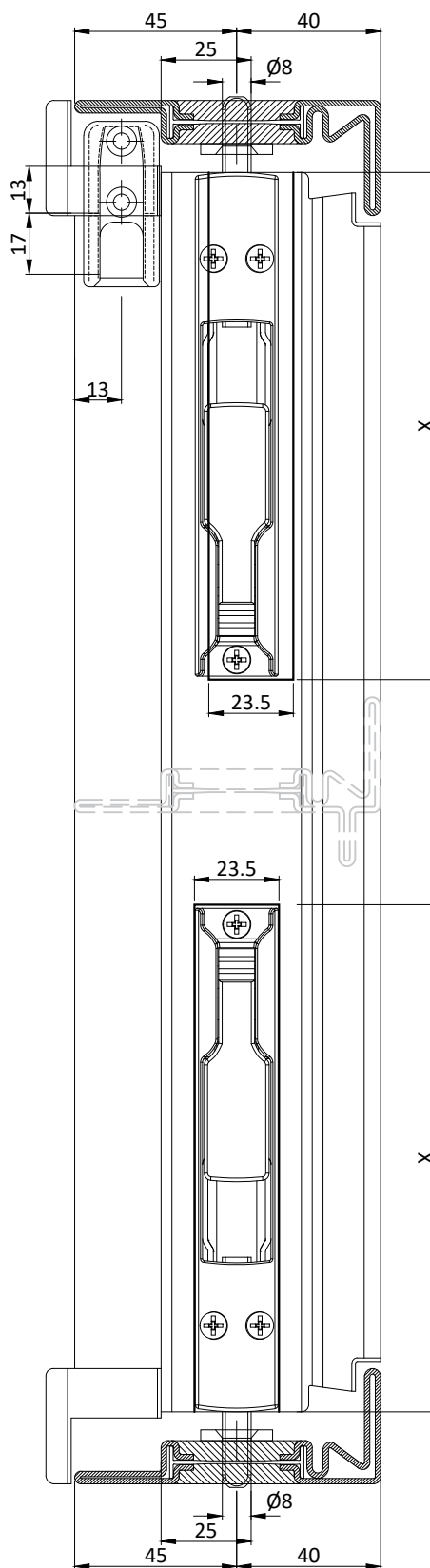
CHIUSURA SUPERIORE - UPPER LOCK

X		H altezza - height						
		480 670	671 860	861 1200	1201 1600	1601 1800	1801 2400	2401 3000
L	345-440	/	141	221	451	651	651	851
larghezza width	441-1400	*	*	*	*	*	651	851

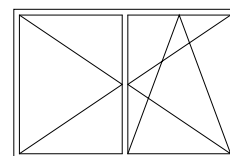


CATENACCIO INFERIORE - LOWER FLUSH BOLT

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



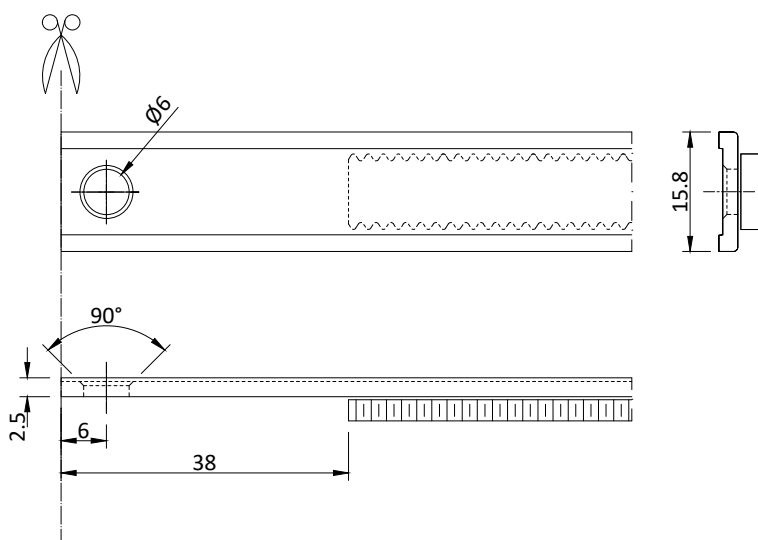
** spessore non fornito
** spacer not supplied



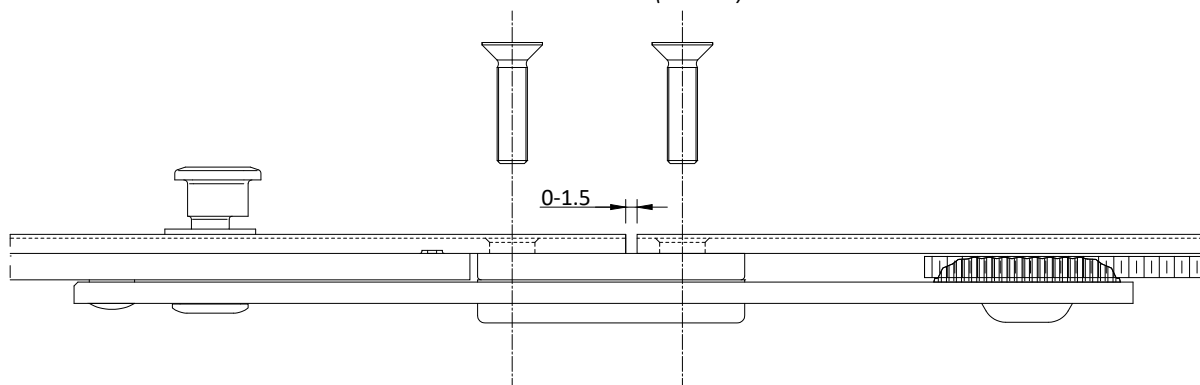
Lavorazione da eseguire sui componenti rasabili della ferramenta
Working on the cuttable pieces of the hardware

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

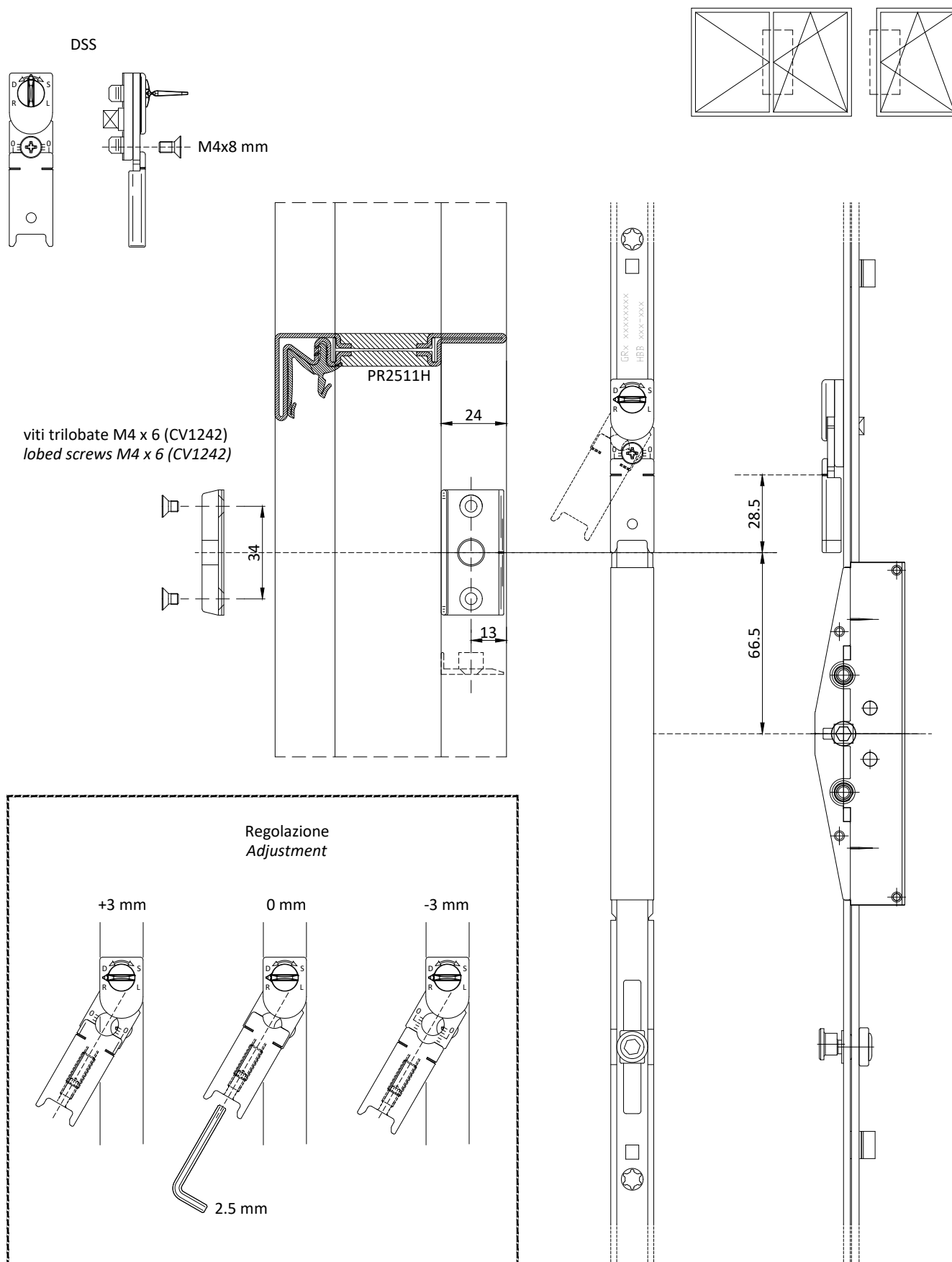
- 1 - Cutting of the hardware
- 2 - Hole drilling and countersink



viti trilobate M4x16 (CV1271)
lobed screws M4x16 (CV1271)

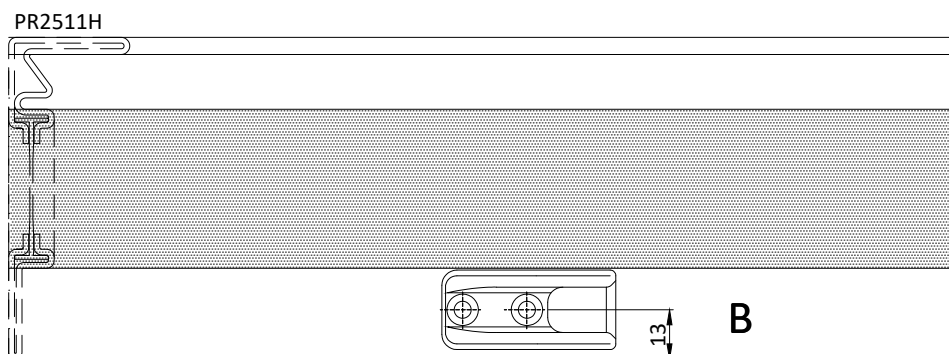
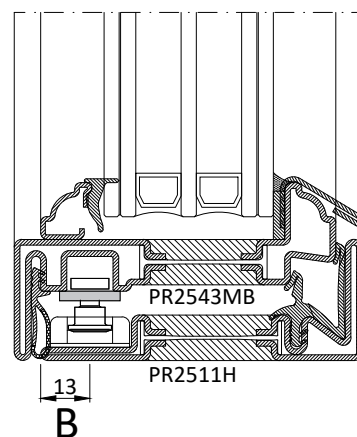
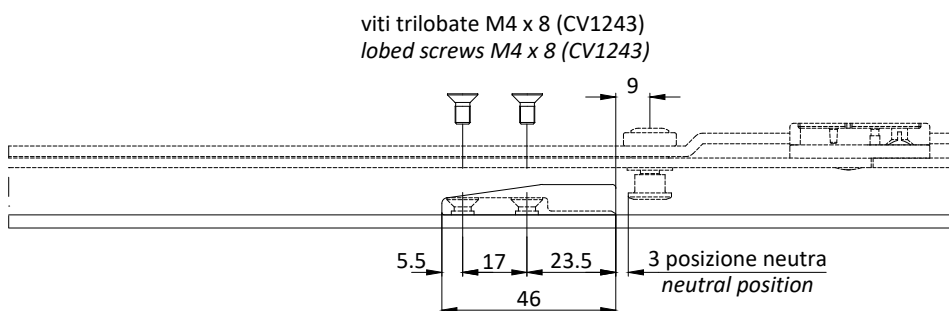
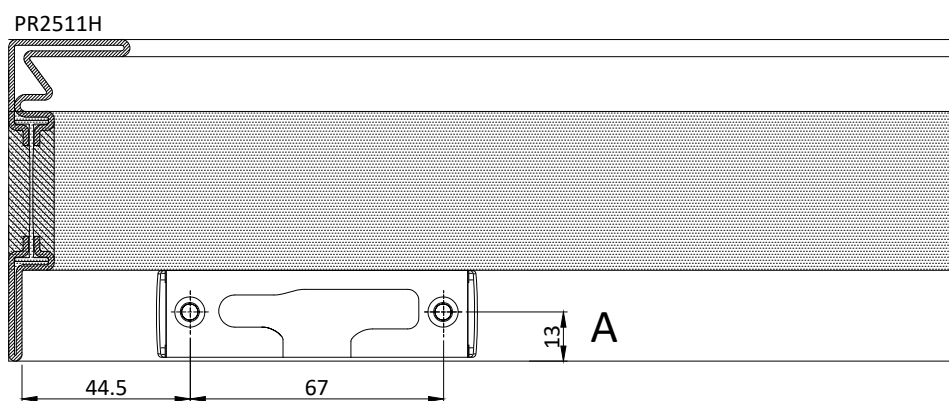
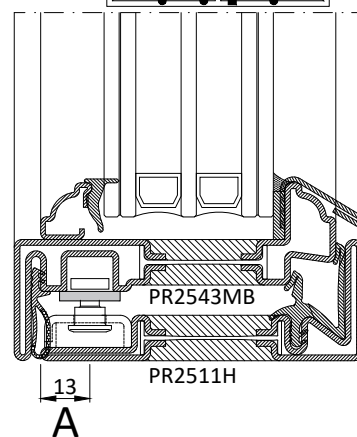
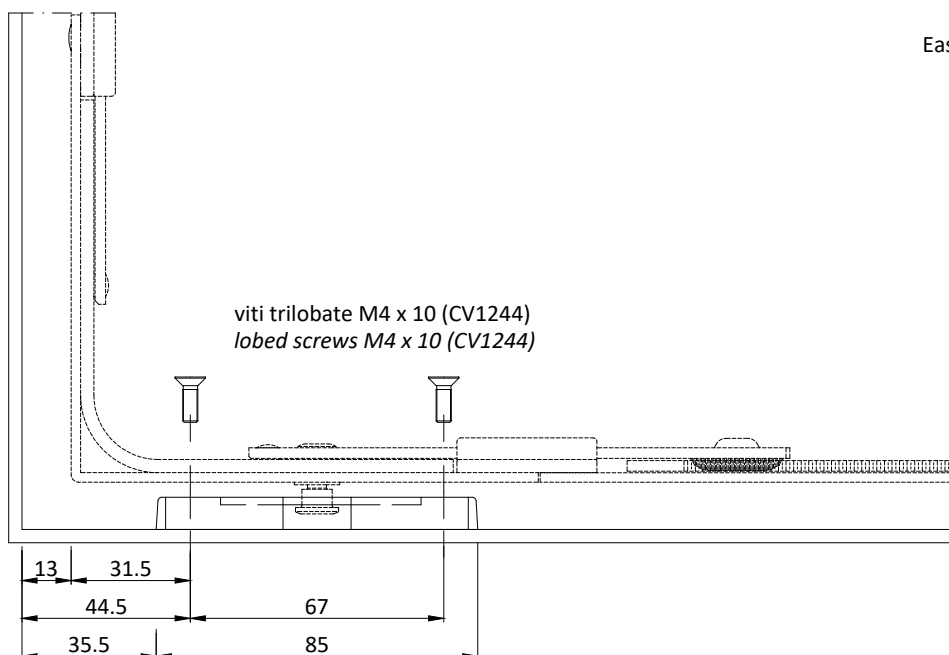


Lavorazione eseguibile con trancia ATG 311 o ATG 312
Tooling possible with punching machine ATG 311 or ATG 312

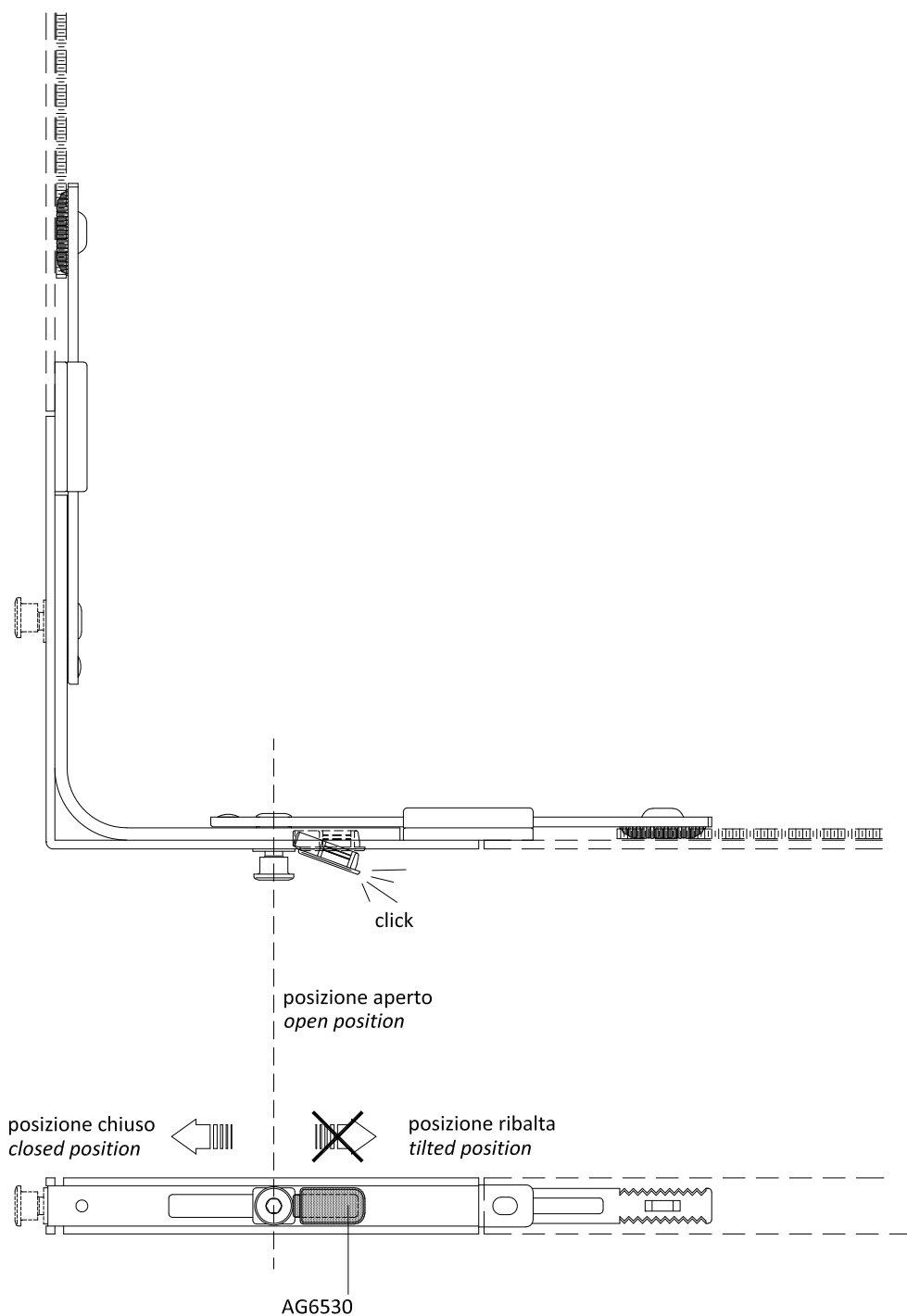
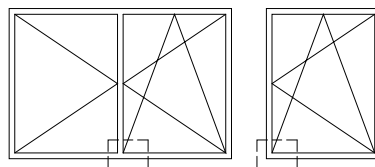
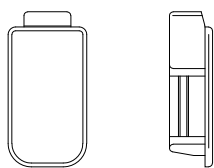


Easy

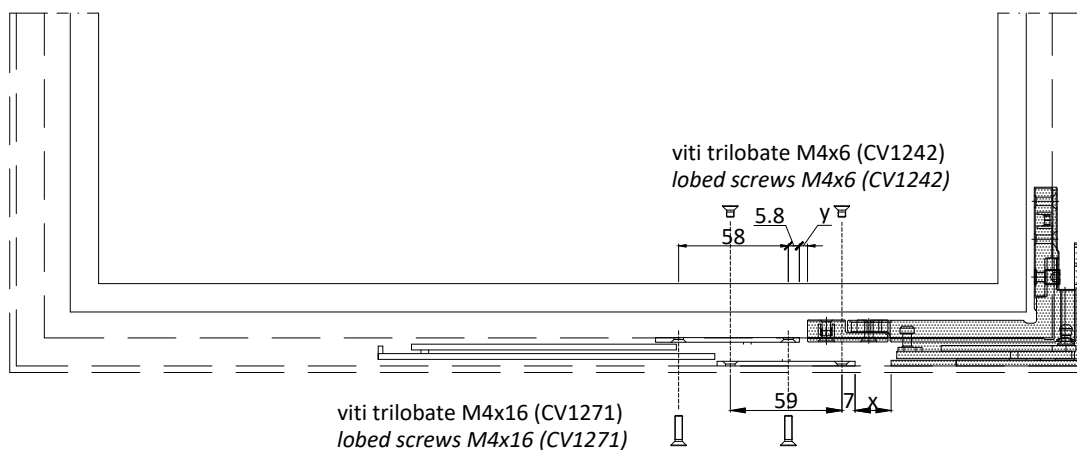
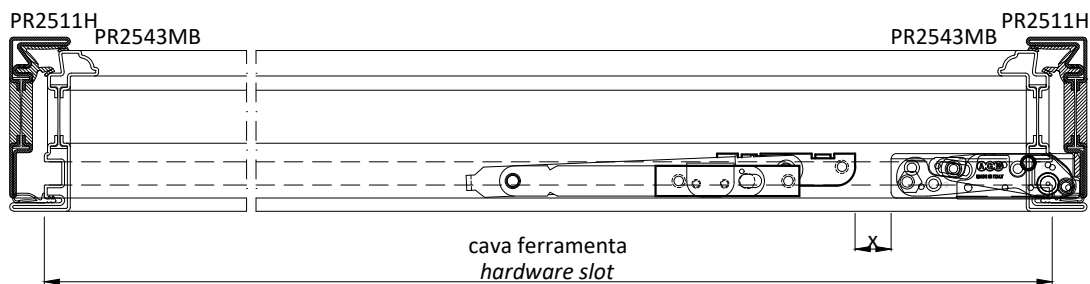
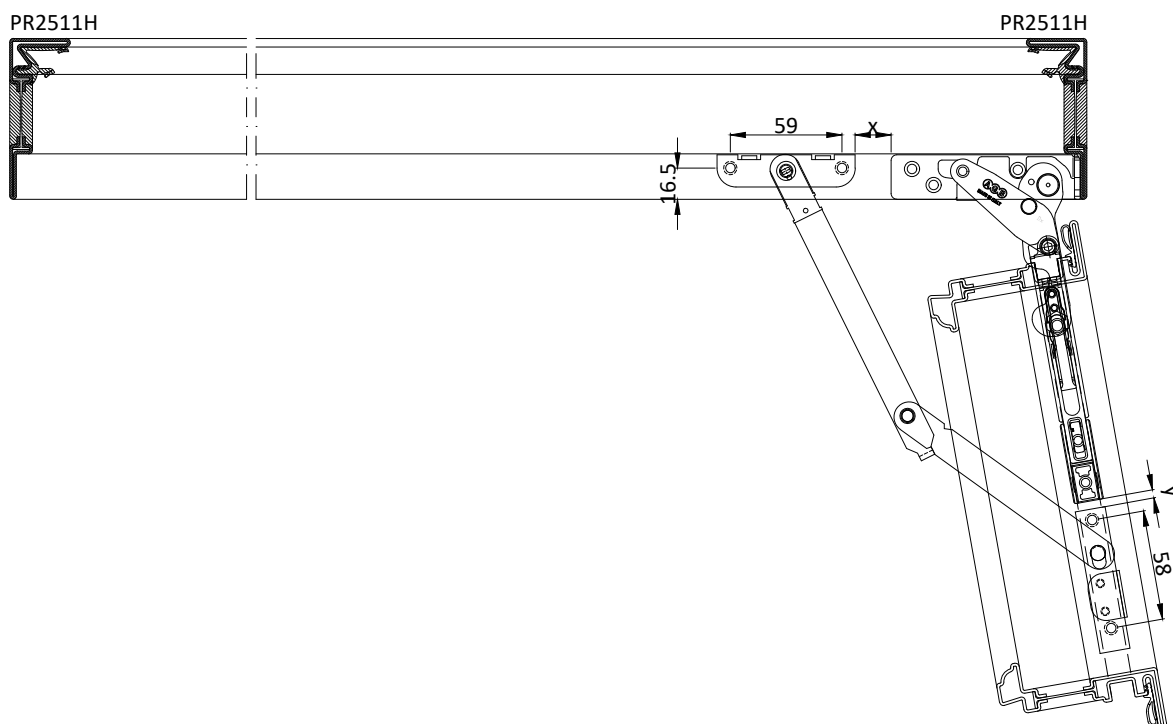
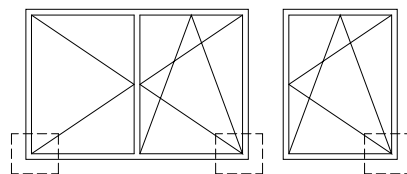
■ A
● B



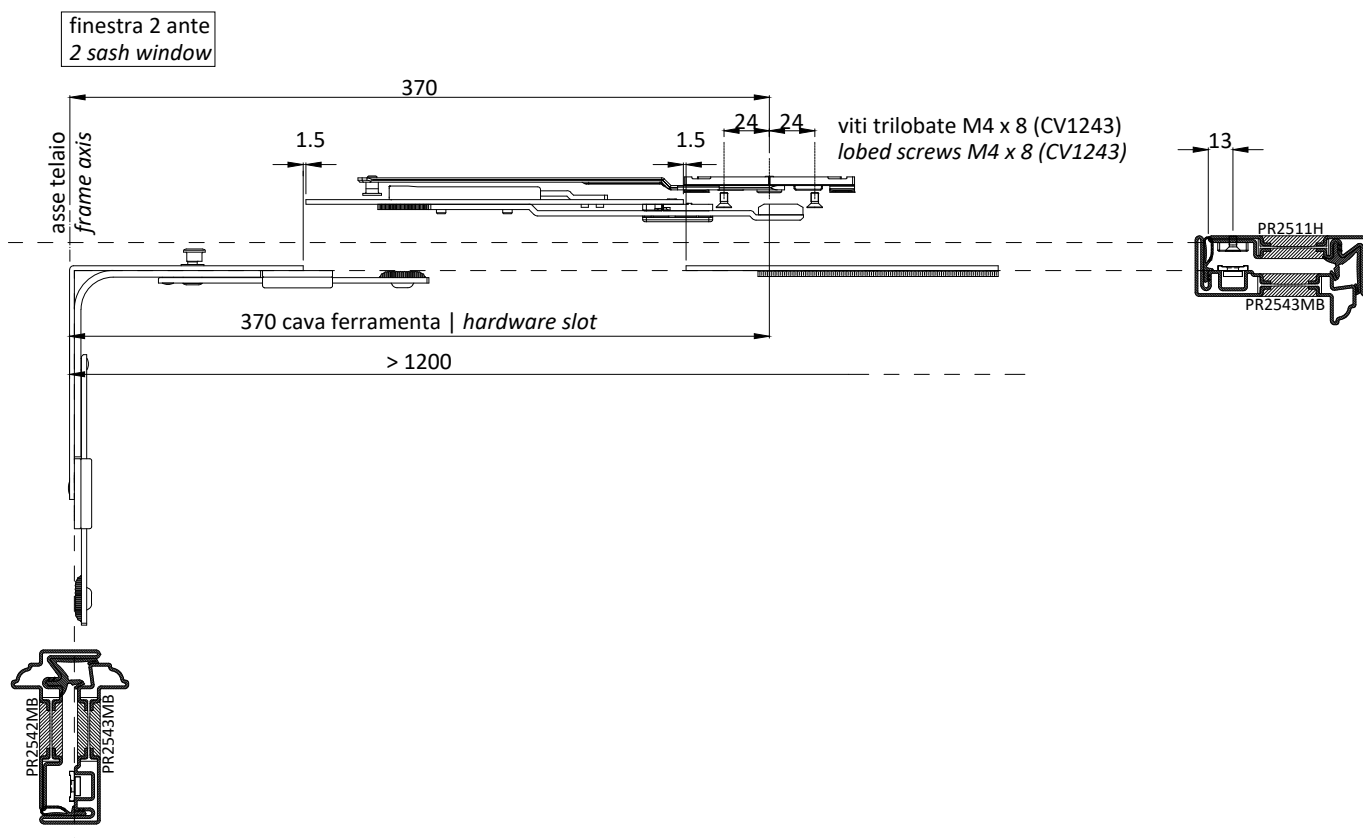
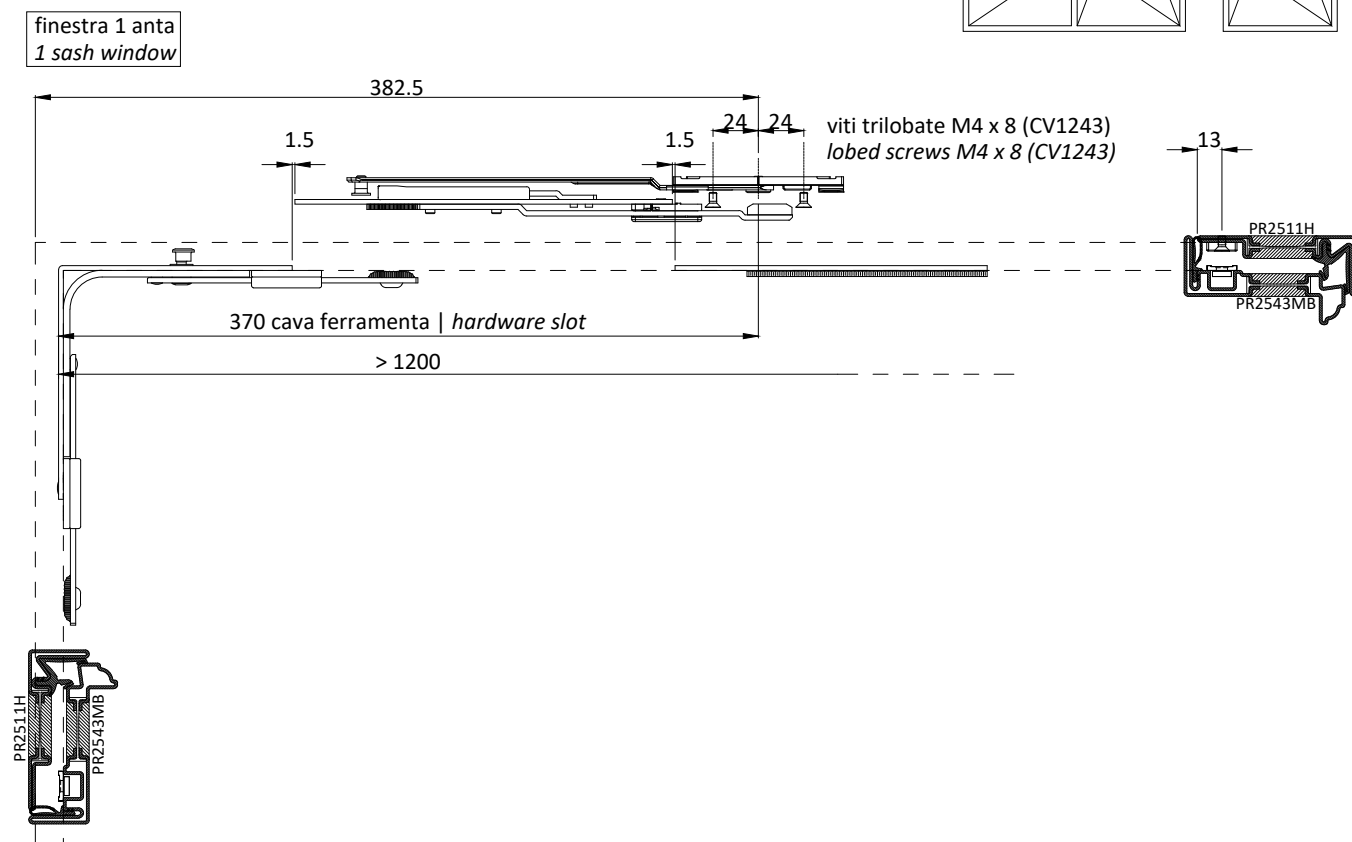
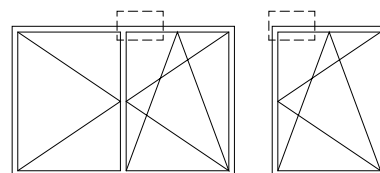
AG6530

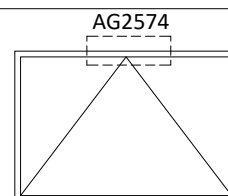


α	x [mm]	y [mm]	min. cava ferramenta hardware slot min. [mm]
90°	31	16.3	450
100°	19	4.3	450



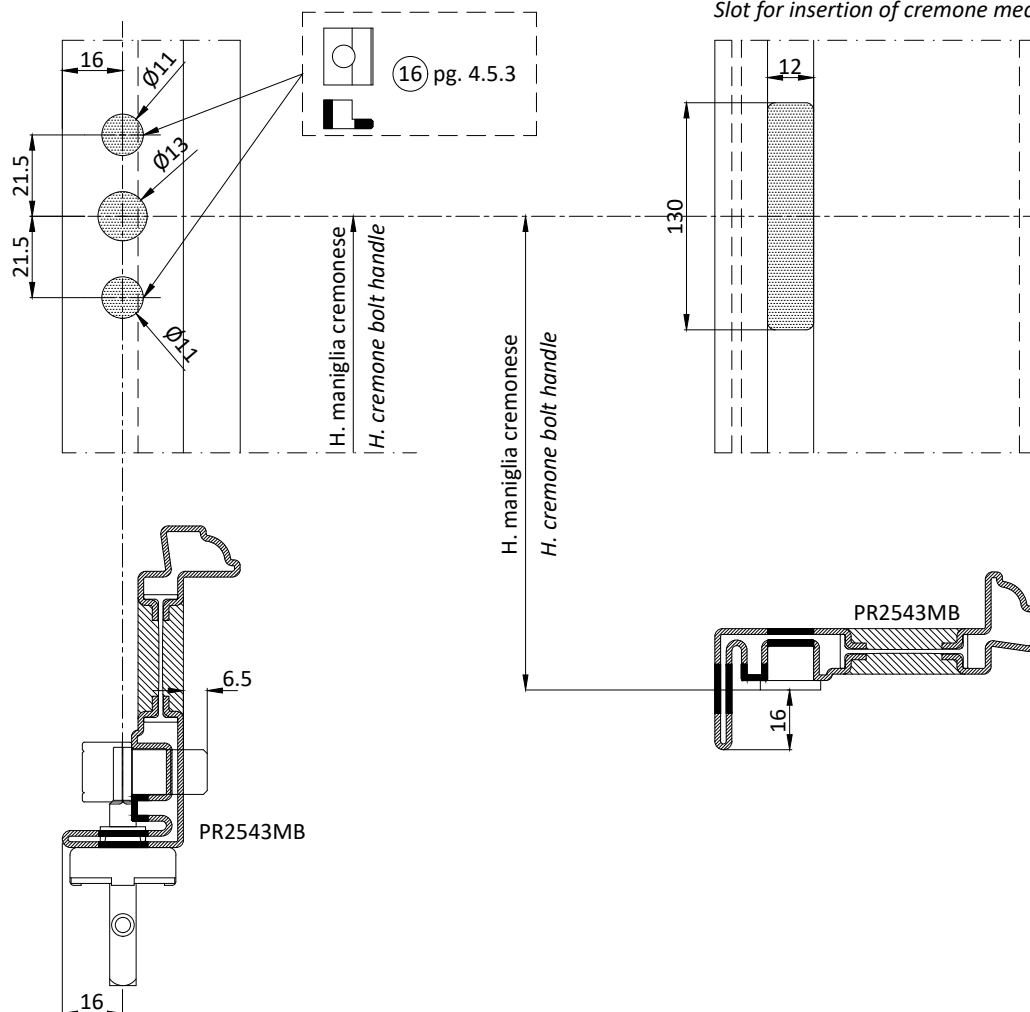
Applicazione braccetto supplementare per larghezza anta, cava ferramenta >1200 mm
Additional arm application for sash width, hardware slot >1200 mm



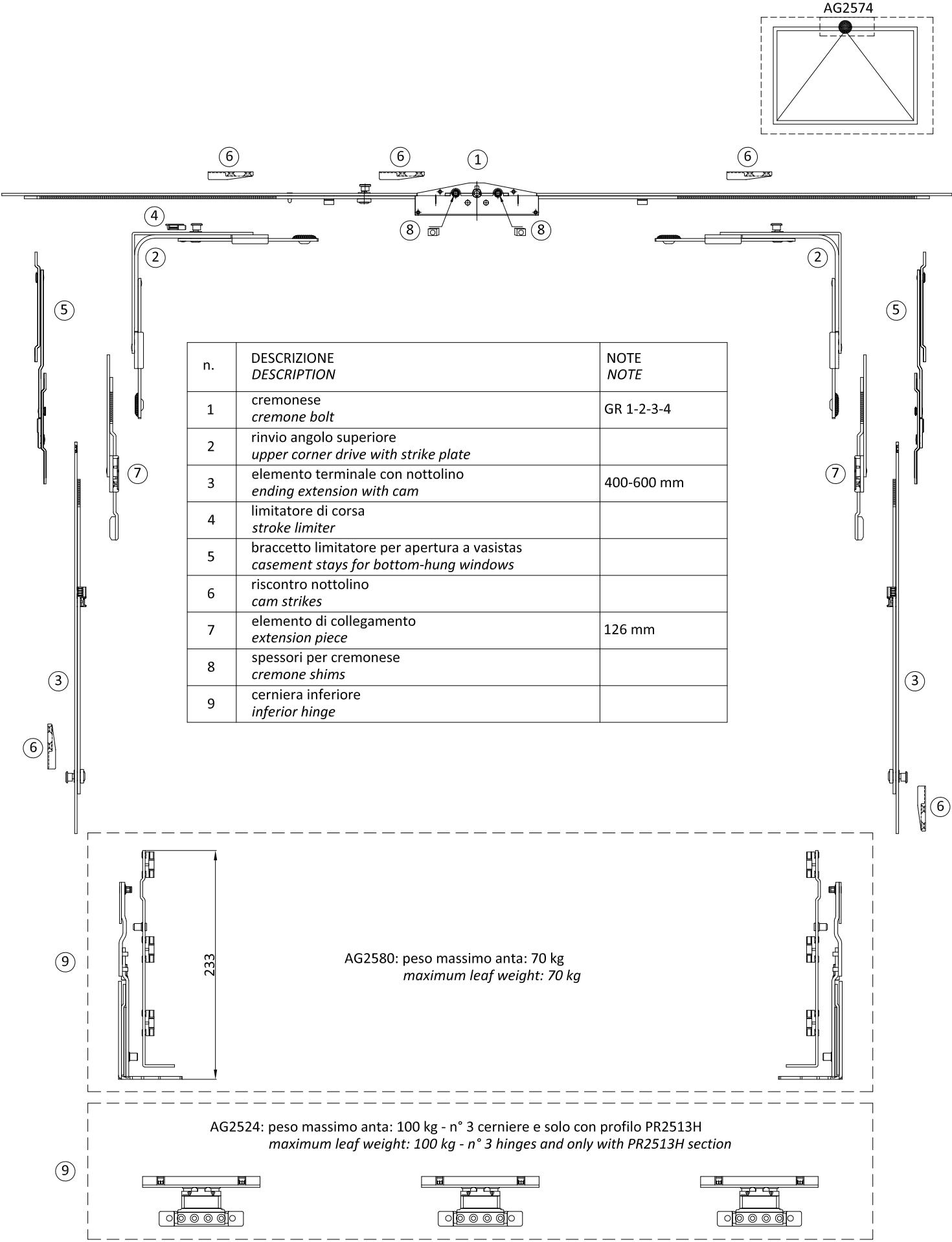


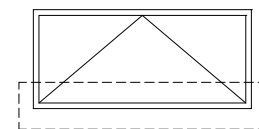
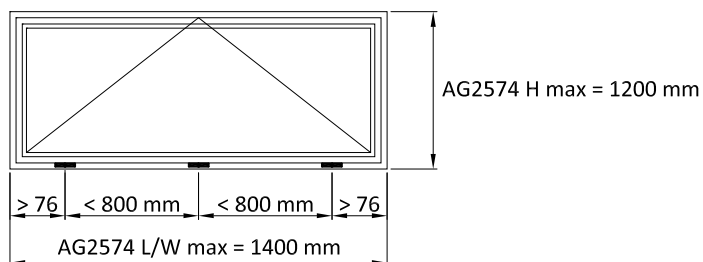
Fori per inserimento quadro comando e
fissaggio maniglia / movimento DK
*holes for inserting control panel and
anchoring of handle / TT (tilt and turn)
movement*

Asola per inserimento meccanismo cremonese
Slot for insertion of cremone mechanism



AG2574 POSIZIONE MANIGLIA CREMONESE - CREMONE BOLT HANDLE POSITION		
Tipo Type	cava ferramenta hardware slot	maniglia cremonese cremone bolt handle
Vasistas Bottom-hung	520 → 670	L/2
	671 → 860	L/2
	861 → 1200	L/2
	1201 → 1400	L/2

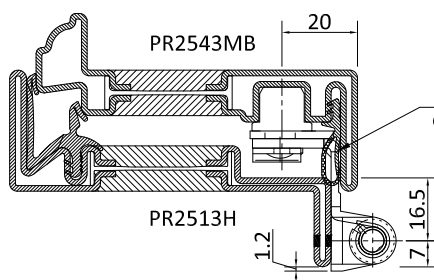




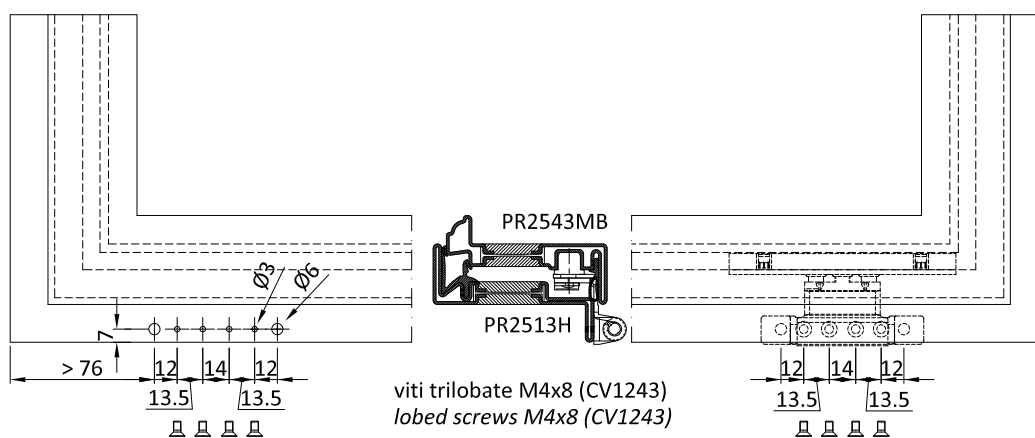
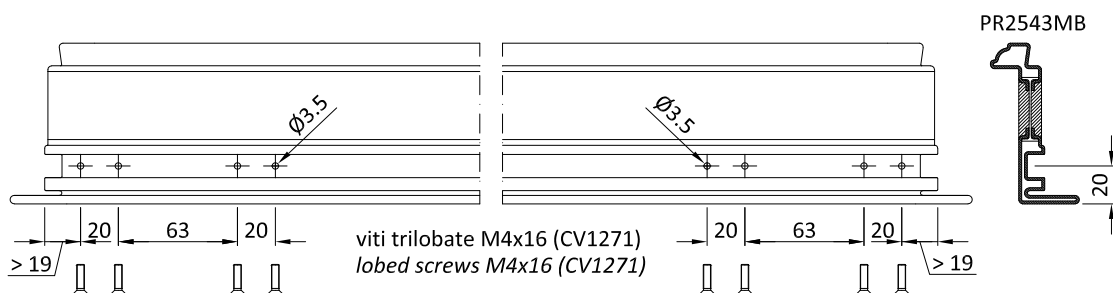
solo con profilo PR2513H
only with PR2513H section

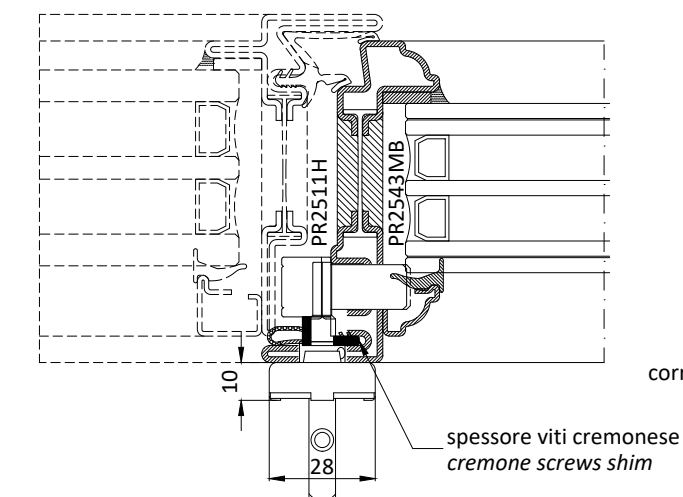
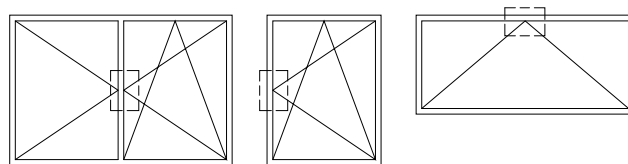
2 cerniere
peso massimo anta 70 kg
3 cerniere
peso massimo anta 100 kg

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



GE2543TT - tagliare la guarnizione
dove interseca la cerniera
GE2543TT - cut the gasket where it
intersects the hinge

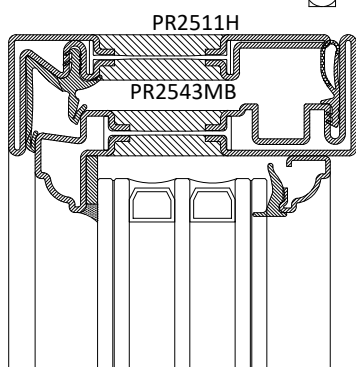




ATT:
aria 7.5 mm
gap 7.5 mm

ATT:
rimuovere se necessario
remove if necessary

ATT:
forare la guarnizione in
corrispondenza delle viti e del quadro
make a hole on gasket for screws
and spandle

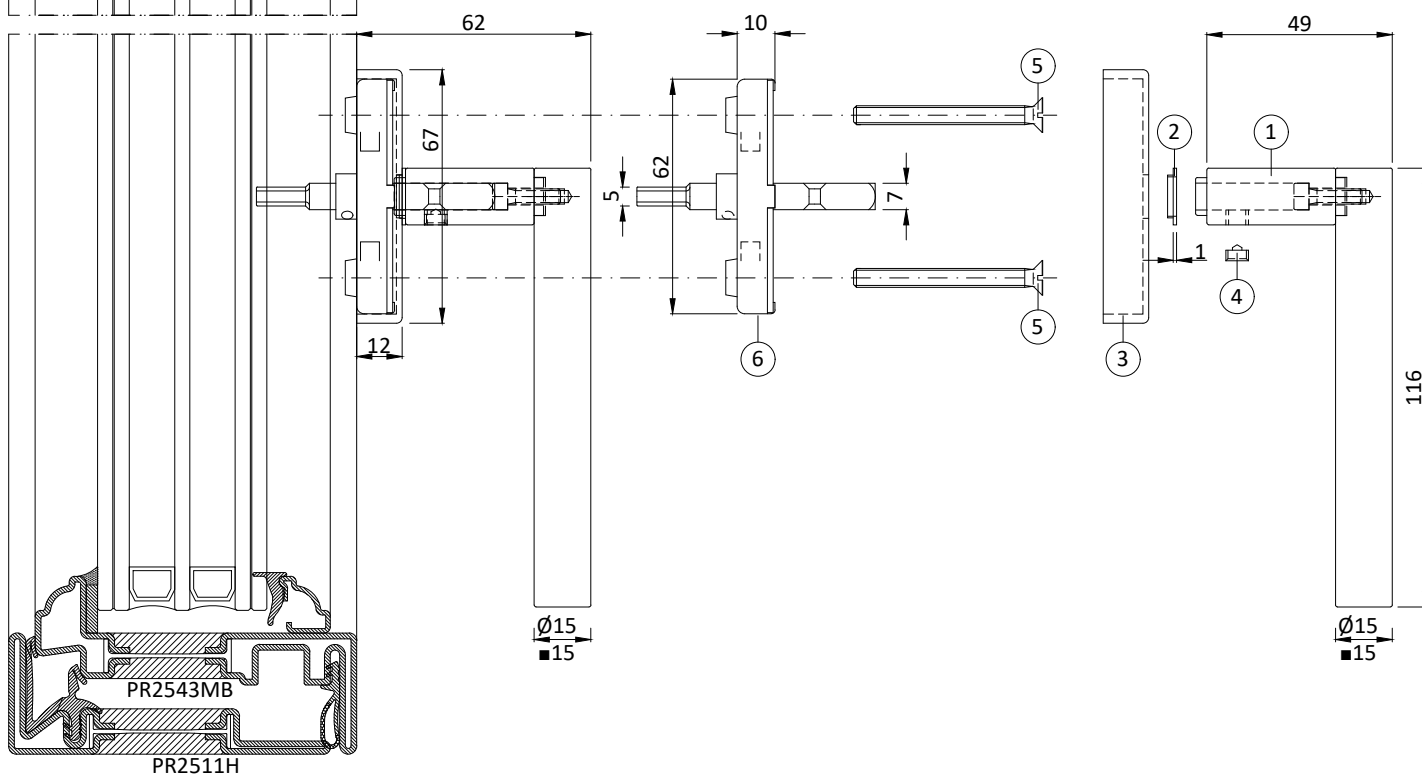
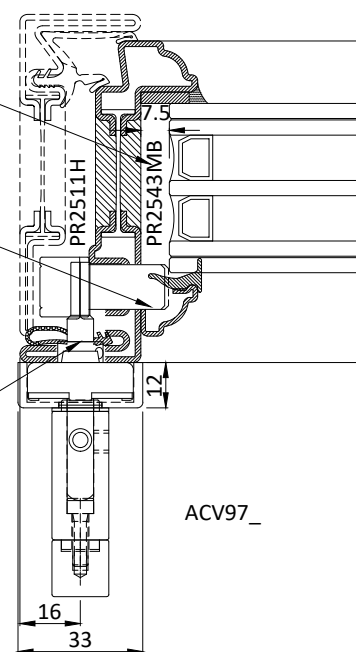


ACV97_ :

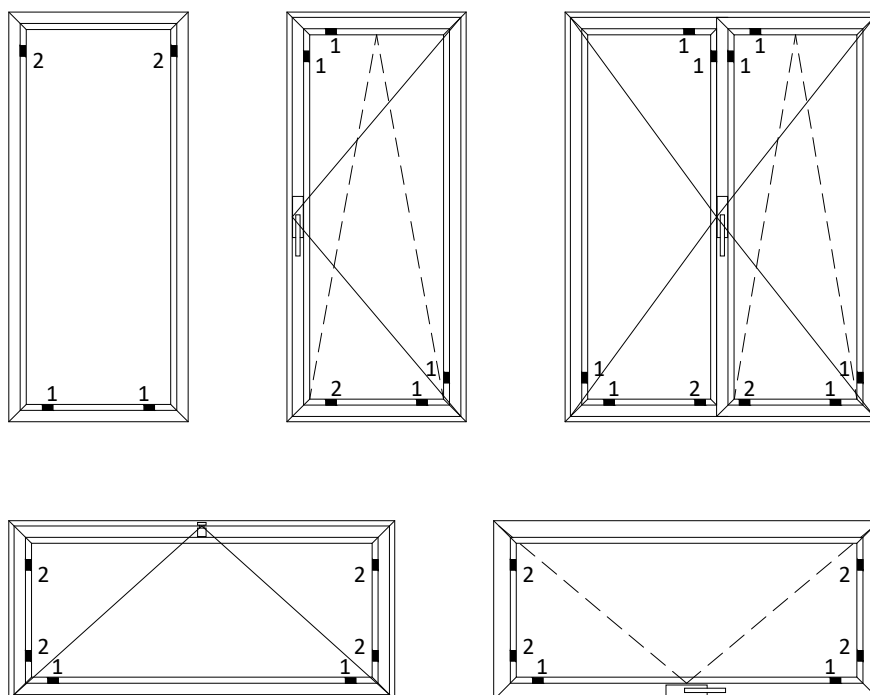
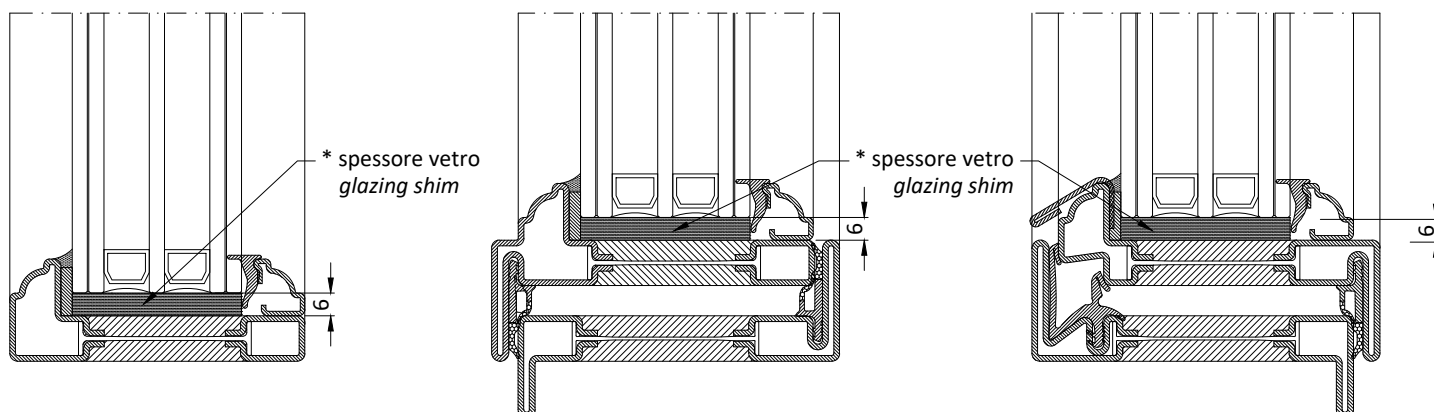
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Vite TP M5x50 (non fornite)
- 6) AC2556 Movimento DK

ACV97_ :

- 1) Handle grip
- 2) Ring
- 3) Rose
- 4) Dowel M6x6
- 5) Flat head screws M5x50 (not supplied)
- 6) Tilt-turn movement AC2556



Finestra | Window

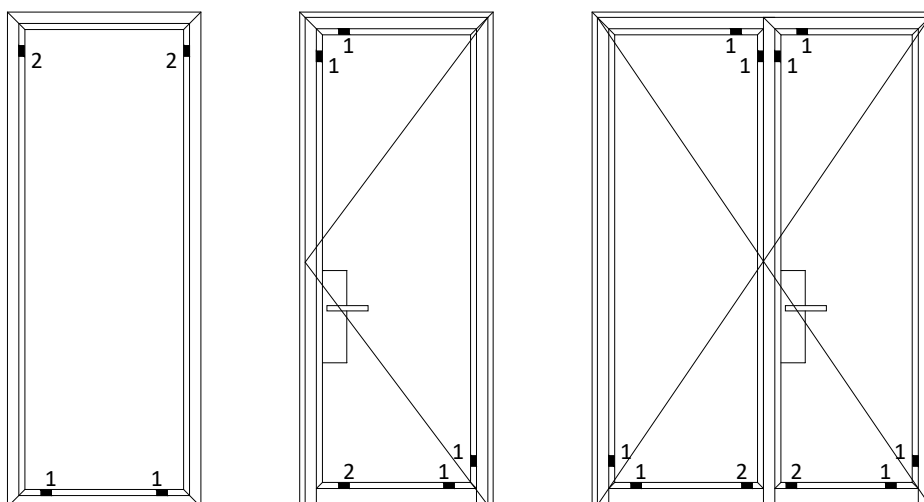
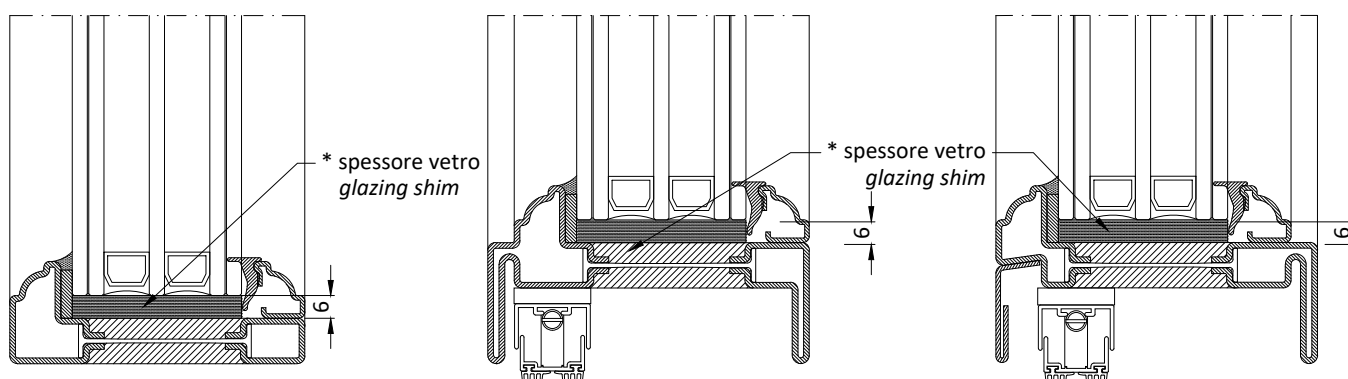
1) spessore portante | *carry shim*2) spessore distanziatore | *compensation shim*

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 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*

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

Tolleranze

MB 85 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 MB 85 in acciaio possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2900MB+ATE028CA) 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 $-1^\circ/+1^\circ$. 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 MB 85 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. 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 MB 85 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 e mandati in pressione con l'incastro dell'apposita guarnizione e all'esterno, l'utilizzo di siliconatura o inserimento della guarnizione adesiva GE2606 (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m^2 di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

Installazione

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

General information

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

Tolerance

MB 85 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

MB 85 profiles in steel can be cut with normal saws, like the ones used for steel pipes. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2900MB+ATE028CA) 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

MB 85 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special DPIs provided and in areas with sufficient ventilation and with fumes disposing systems. 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).

Painting/Burnishing

MB 85 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

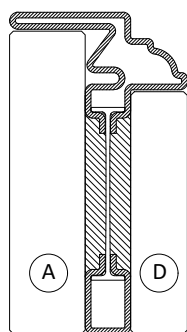
The glazing unit is secured by means of glazing beads which must be fixed by pressure with the dedicated clips to then fit the appropriate gasket.

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).

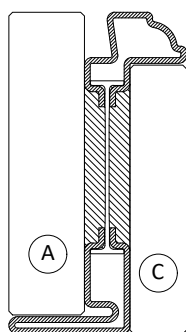
In order to ensure the correct behaviour of the system, it is recommended to verify the proper pressurization of the internal glass bead gaskets and that the external silicone perimeter is completely free of imperfections.

Set up

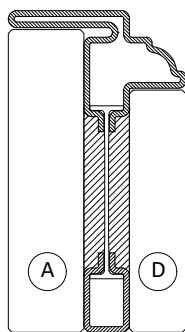
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished,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



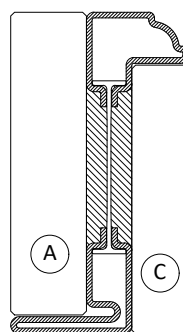
PR2942MB



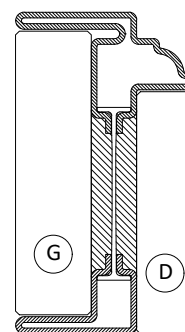
PR2943MB



PR2962MB

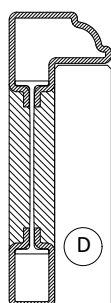


PR2963MB

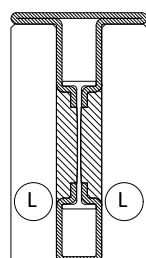
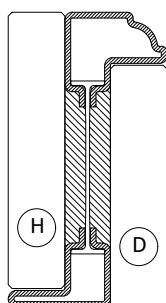


PR2968MB

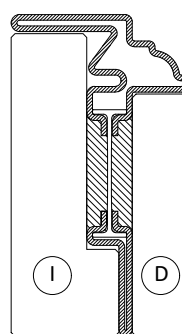
*applicazione esclusivamente
su traverso inferiore porta AE*



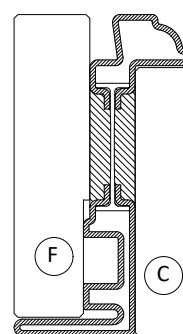
PR2971MB

PR2972MB
solo zincato

PR2973MB



PR2542MB



PR2543MB

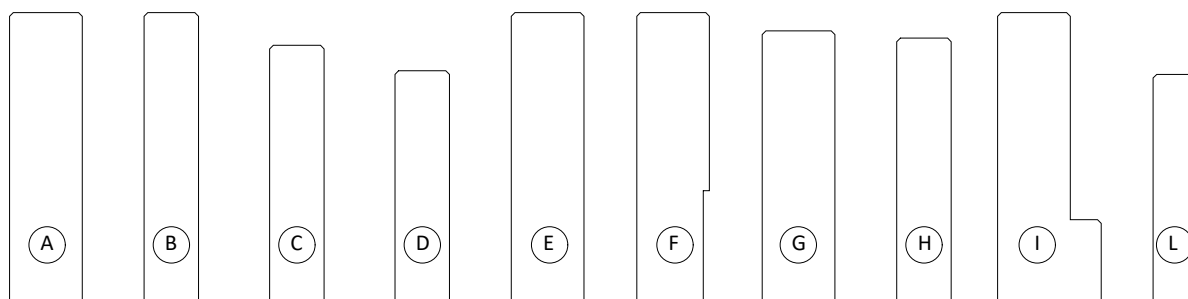


PA2028CA



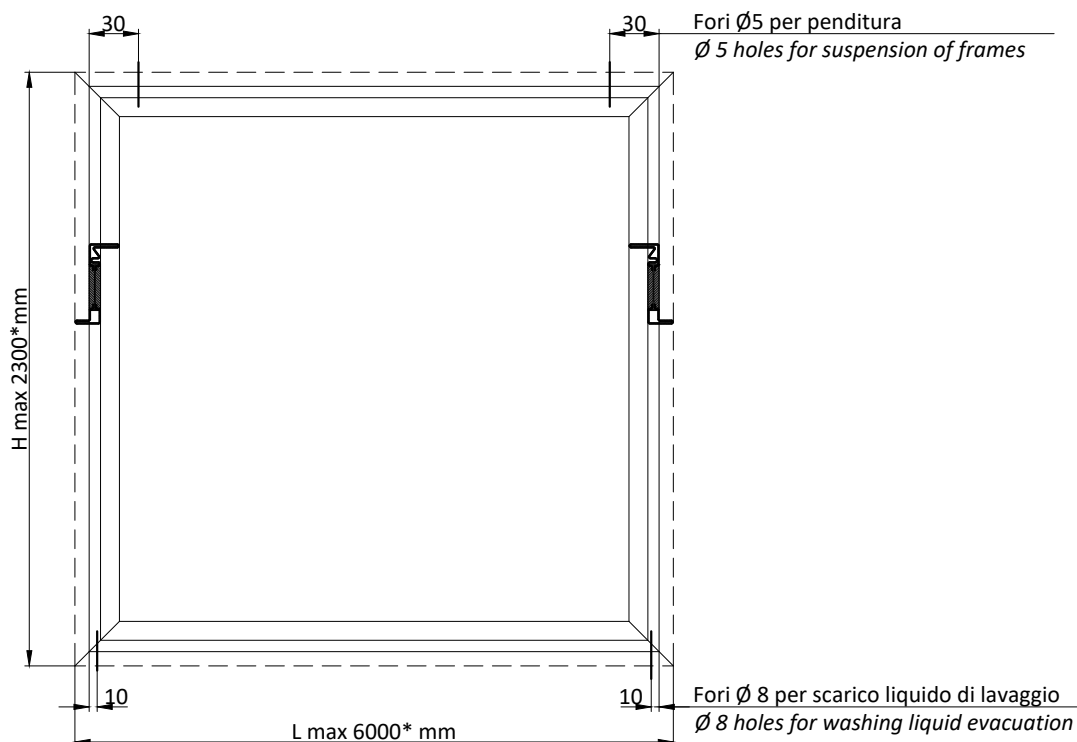
PRE028CA

AT2900MB



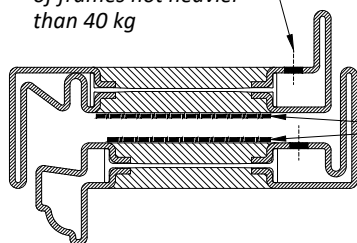
ATE028CA





Fori Ø5 per pendinatura
telai con peso inferiore
a 40 kg

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

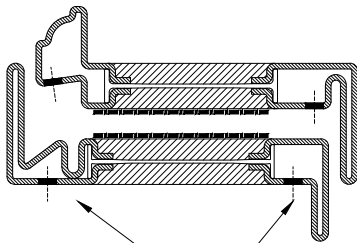


SOLO PER VERNICIATURA

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).

Pantografocaratteristiche minime della macchina

- Mandrino con velocità regolabile 2000-11000 giri/min;
- 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 rpm for stainless steel;
60-90 rpm for galvanised and corten steel;
90 rpm 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).

PhantographMinimum requirements for the use of the machine

- Mandrel with a 2000-11000 rpm adjustable speed;
- 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.

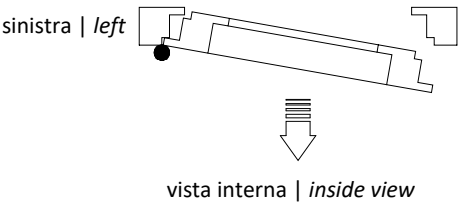
DrillingHow to mount closing and moving components on a stainless steel profile

- 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.

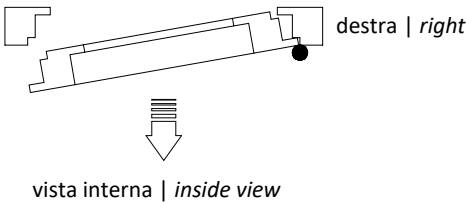
Milling slots and loops in the profiles

- 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

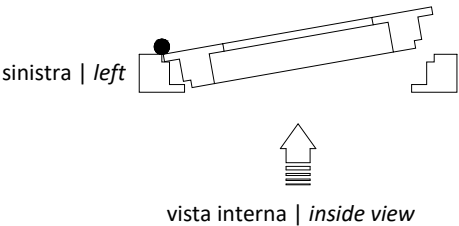


Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2624.S - AC2624SG.S	PR2943MB
AC2625.S - AC2625SG.S	PR2943MB
Cerniere Hinges	
AC2649.ISED	PR2943MB
Serratura multipunto Multi-lock set	
AC2694.S - AC2694R.S	PR2943H

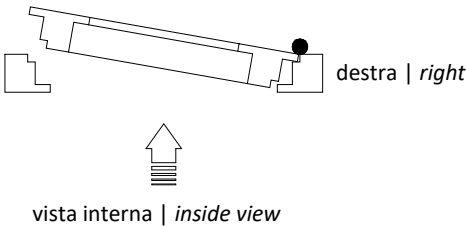


Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2624.D - AC2624SG.D	PR2943MB
AC2625.D - AC2625SG.D	PR2943MB
Cerniere Hinges	
AC2650.IDES	PR2943MB
Serratura multipunto Multi-lock set	
AC2694.D - AC2694R.D	PR2943H

APERTURA ESTERNA | OUTWARD OPENING



Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2683.S	PR2962MB
AC2684.S - AC2684SG.S	PR2962MB
Cerniere Hinges	
AC2649.IDES	PR2962MB
Serratura multipunto Multi-lock set	
AC2694.D - AC2694R.D	PR2962MB



Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC2683.D	PR2962MB
AC2684.D - AC2684SG.D	PR2962MB
Cerniere Hinges	
AC2649.ISED	PR2962MB
Serratura multipunto Multi-lock set	
AC2694.S - AC2694R.S	PR2962MB

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 / <i>Deep scratches</i> | verifica visiva / <i>visual control</i> |
| • Botte e avvallamenti sulla superficie / <i>Bumps and dips on surface</i> | verifica visiva / <i>visual control</i> |
| • Rettilineità barre / <i>Profiles straightness tolerance</i> | 0,002 x L |
| • Svergolamento / <i>Profiles twist tolerance</i> | 1° x m |

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

- | | |
|--|---------|
| • Misura lunghezza / <i>Length measurement</i> | ±0.5 mm |
| • Verifica 45° / <i>45° Control</i> | ± 1° |
| • Verifica 90° / <i>90° Control</i> | ± 1° |

3. Controlli su prodotto finito / *Control on finished element*

- | | |
|--|--|
| a. Verifica distanza tra anta e telaio /
<i>Control of gap between leaf and frame</i> | +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> | |

4. 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 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**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.

INDICE ANALITICO | SUBJECT INDEX

AC2514.xx	4.3.9-10	ACV773.xx	4.5.29
AC2556	4.6.16	ACV776.xx	4.5.29
AC2608	2.8.1-3-5	ACV777.xx	4.5.29
AC2608AR	2.8.4-5	ACV779.xx	4.5.29
AC2617NG	4.3.11 4.5.1	ACV871.xx	4.5.29
AC2618.xx	4.3.11-12 4.5.1	ACV872.xx	4.5.29
AC2621G.x	4.3.37-38 4.5.1	ACV873.xx	4.5.29
AC2621SG.x	4.3.39-40	ACV874S.xx	4.5.29
AC2622	4.5.3-6	ACV879.xx	4.5.29
AC2624.D-S	4.3.16 4.5.3-4 5.3.1	ACV952.xx	4.5.30
AC2624SG.D-S	4.3.16 4.5.5-6 5.3.1	ACV952B.xx	4.5.30
AC2625.D-S	4.3.17 4.5.7-8 5.3.1	ACV952C.xx	4.5.30
AC2625SG.D-S	4.3.17 4.5.9-10 5.3.1	ACV953.xx	4.5.30
AC2626R	4.3.22-23 4.5.19	ACV953B.xx	4.5.30
AC2627	4.5.20	ACV953C.xx	4.5.30
AC2631.x	1.2.1-4 4.4.17-18	ACV954S.xx	4.5.30
AC2632.x	1.2.1-4 4.4.17-18	ACV954SB.xx	4.5.30
AC2636.x	4.3.41-42	ACV954SC.xx	4.5.30
AC2640.xx	4.5.22	ACV955.xx	4.5.30
AC2641	4.5.22	ACV955C.xx	4.5.30
AC2648.xx	1.2.1-4 4.3.24-25 4.5.21	ACV964.xx	4.5.31
AC2649.xx.ISED	1.2.1-4 4.3.26-27 4.5.21	ACV972.xx	4.6.16
AC2649.xx.IDES	1.2.1-4 4.2.26-27 4.4.21	ACV972H.xx	4.6.16
AC2625.D-S	4.3.17 4.5.7-8 5.3.1	ACV973.xx	4.6.16
AC2625S.D-S	4.3.17 4.5.9-10 5.3.1	ACV973H.xx	4.6.16
AC2652.xx	4.3-4	ACV974S.xx	4.6.16
AC2653.xx	4.3.5-8	ACV974SH.xx	4.6.16
AC2680.xx	4.3.23	ACV976.xx	4.6.16
AC2680E.xx	4.4524	ACV977.xx	4.6.16
AC2683.D-S	4.3.18-19 4.5.11-14 5.3.1	AG1386	4.6.11
AC2684.D-S	4.3.20-21 4.5.15-16 5.3.1	AG2524	4.6.14
AC2684SG.D-S	4.5.17-18 5.3.1	AG2574.xx	4.6.13
AC2685.D-S	4.3.28-29	AG2578.xx	4.6.1
AC2686	4.3.30	AG2580	1.2.1 4.6.14
AC2687	4.3.31-33	AG6530	4.6.10
AC2688M	1.2.3 4.3.34	AGE581.xx	1.2.5 4.6.1 4.6.3-5
AC2689	1.2.3 4.3.35	AGE582.xx	1.2.5 4.6.1 4.6.3 4.6.5
AC2690	4.3.36	AGE585.xx	1.2.5 4.6.1 4.6.4-5
AC2693	4.3.43-44	AGE586.xx	1.2.5 4.6.1 4.6.4-5
AC2694.D-S	4.3.45-46 4.5.25-26	AT2900MB	5.1.3
AC2694R.D-S	4.3.45-46 4.4.25-26	ATE028CA	5.1.3
AC2695.D-S	4.3.47-48 4.5.27	CV1023	4.4.1-12
AC2696BV.xx	4.5.28	CV1242	4.6.5 4.6.8 4.6.11
AC2618NE	4.2.11 4.5.1	CV1243	4.5.9 4.5.12-15
AC2986R-CA	4.4.1-12	CV1244	4.6.9
ACB219.xx	4.3.11	CV1271	4.6.7 4.6.11 4.6.15
ACB648.xx	1.2.1-4 4.3.24-25	GE2603	4.5.2
AC2775/1	4.5.30	GU2634	4.3.51 4.3.55
ACV770.xx	4.5.29	PA2030CA	4.4.13-14
ACV771.xx	4.5.29	PR2620BV	4.3.13 4.5.1

PR2630H	4.3.39-40 4.3.51-54
PR2660	4.3.14
PR2670	4.3.15
PR2671	4.3.15
PR2819	4.3.52



Secco Sistemi spa
via Terraglio 195
31022 Preganziol TV - Italy
tel. +39 0422 497700
fax +39 0422 497705
info@seccosistemi.it
www.seccosistemi.it