



BSF70
FOLDING SLIDING
DOOR SYSTEM

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TECHNICAL MANUAL

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MANUAL REVISION

This manual is issue controlled, please check the index below for the latest revisions.
Any updates will be sent out via mail shot and published on the web site.

REVISION	DESCRIPTION	PAGE
01.08.2017	First issue	Complete manual
14.05.2018	General amends, N60630 replaces P-00-211	S1, S2, S3, S5, S6, S7, S8, S9 & S10

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DESCRIPTION

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SECTION 1 SPECIFICATION

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» GENERAL REMARKS

Dimensions and thickness of aluminium profiles shown in this manual are theoretical and may vary according to tolerance provided for in EN 12020-2 standards.

Cutting lists shown in this manual do not take into account these possible variations.

We therefore recommend carefully checking aluminium profile dimensions, as well as, the cutting accuracy of all machinery.

The system described in this manual has been designed and tested as a whole. The use of AluK brand is permitted only when original AluK components are used (sections, accessories and gaskets) and only when the technical specifications given in this manual are complied with.

In the event that any component of the system is not an original AluK component, the use of the AluK brand is not authorised.

The product shall be used in accordance with the specifications, regulations and laws in force in the country where the product itself is used. AluK waives all responsibility resulting from non-compliance with the above listed instructions.

Any details provided in this manual representing frames back to the structure are merely shown as an indication to assist designers and manufacturers.

TERMS & DEFINITIONS

Stile/Sash	The frame in which the glass is set
Cleats	Angle used for joining corner profiles together
Chevrons	Angle used for aligning profiles
Clear opening	Dimension of clear space when the door is opened
Accessory	
Hardware	
E Gasket	External gasket



Multiple colour options - see price list



Black & White colour options



Black, White & Silver colour options

► TECHNICAL DESCRIPTION

The BSF70 system consists of a range of thermally broken profiles and accessories incorporating sliding hardware designed to meet current building regulations with an improved thermal performance.

SECTIONS

The extruded aluminium profiles are made from homogenised billets, with limited composition tolerances, suitable for anodising or painting.

All extruded aluminium sections are supplied at physical state 6063 alloy T6.

Dimension tolerances are in compliance with EN 12020-2.

GASKETS

Gaskets are made of EPDM (ethylene + propylene elastomer).

ACCESSORIES

Patented AluK accessories of the highest quality are expressly designed by AluK to offer the utmost reliability and safety.

Corner joints are monolithic, extruded from the highest quality aluminium alloy and tested to the latest standards. Hinges, made from aluminium extrusion and are equipped with bushes made of anti-friction and synthetic material with stainless steel pins and screws.

GLAZING

The system allows the application of glass or panels with a thickness from 22mm to 40mm.

The choice of glazing is the responsibility of the fabricator/installer through compliance with legislation and glass manufactures recommendations.

SYSTEM DESIGN TOLERANCES

To ensure all products are manufactured in accordance with the fabrication manual, please follow guidelines laid out below:

- a. Manufacturing tolerances shall be within +/- 1.5 (cutting tolerance of +/- 0.5mm and assembly tolerance of +/-1.0mm).
- b. Installation Tolerance to be +/-2mm i.e. the difference between the diagonals of the assembled frame shall be not greater than above.

» TECHNICAL DESCRIPTION

ANODISING

The anodising process starts with a mechanical pre-treatment scotch-brite brushing of raw profiles. Afterwards, all other electro-chemical treatments and the related checks are performed according to the Technical Guidelines of the European quality mark QUALANOD.

The anodic oxide layer thickness is checked in compliance with EN ISO 2360 (eddy current method), while the fixing quality of the anodic oxide layer is referred to within ISO 3210 and EN 12373-4. The treatments are guaranteed with quality mark (EURAS-EWAA) QUALANOD, and are performed by a certified company to EN ISO 9001.

The profiles with parts in view have brushed finish E2, while for the profiles with parts not in view, the finish is Satin Chemicals E6.

The minimum compulsory oxide layer thickness is 15 microns, which can be increased to higher classes (20 or 25 microns) depending on customer's requirements and/or national laws in the destination countries.

Possible anodising treatments are: natural silver, light bronze, medium bronze, electro-coloured medium bronze, electro-coloured dark bronze, electro-coloured black.

PAINTING

Painting is done with powders and colour can be chosen from the RAL range of colours, from our colour quire and/or based on customer's requirement.

Before painting, section surface is pre-treated with a "in-tunnel" treatment, i.e.:

- degreasing
- washing
- etching
- washing
- chromium plating
- double washing in demineralized water
- furnace drying process

After that, special powders are applied by spray painting with electrostatic alternate spray guns, into an automatic booth, and then dried into furnace for paint polymerization.

The minimum compulsory paint layer thickness shall be at least 60 micron for external architectural use.

► SINGLE & DOUBLE ENTRANCE DOOR SIZE LIMITS

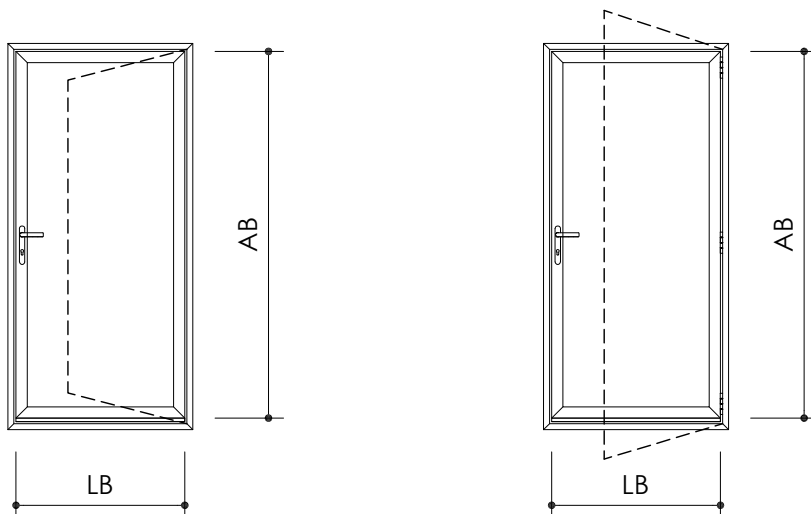


Table 1. SINGLE DOOR SIZE LIMITS (OPEN IN & OPEN OUT)(SECURITY & NON SECURITY LOCK)

SECTION	HINGE NUMBER PER LEAF	LEAF DIMENSION				MAX WEIGHT (Kg)
		LB*		AB*		
		MIN	MAX	MIN	MAX	
P-06-200 / 202	3	550	1200	1570	2400	100
	4	550	1200	1570	2400	130
P-06-200 / 202	3	550	1200	1570	2400	100
	4	550	1200	1570	2400	130

* Dependant on wind load, see page 1.06

NB Entrance Doors Are Not Supported within the scope of BSF70 and therefore are manufactured and guaranteed by the fabricator.

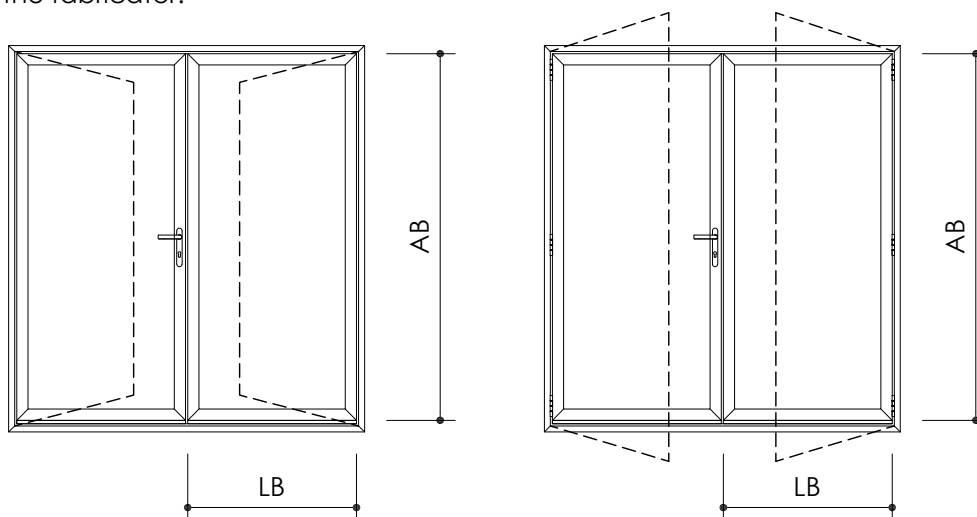
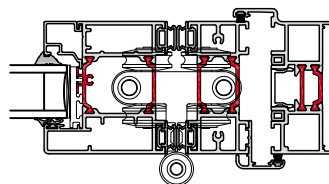
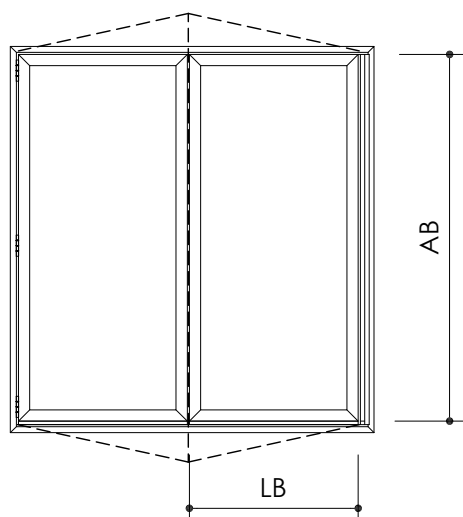


Table 2. DOUBLE DOOR SIZE LIMITS (OPEN IN & OPEN OUT)(SECURITY & NON SECURITY LOCK)

SECTION	HINGE NUMBER PER LEAF	LEAF DIMENSION				MAX WEIGHT (Kg)
		LB*		AB*		
		MIN	MAX	MIN	MAX	
P-06-200 / 202	3	550	1200	1570	2400	100
	4	550	1200	1570	2400	130
P-06-200 / 202	3	550	1200	1570	2400	100
	4	550	1200	1570	2400	130

* Dependant on wind load, see page 1.06

DOOR SIZE LIMITS

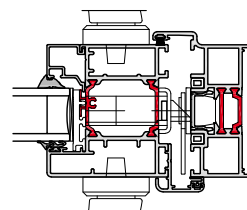
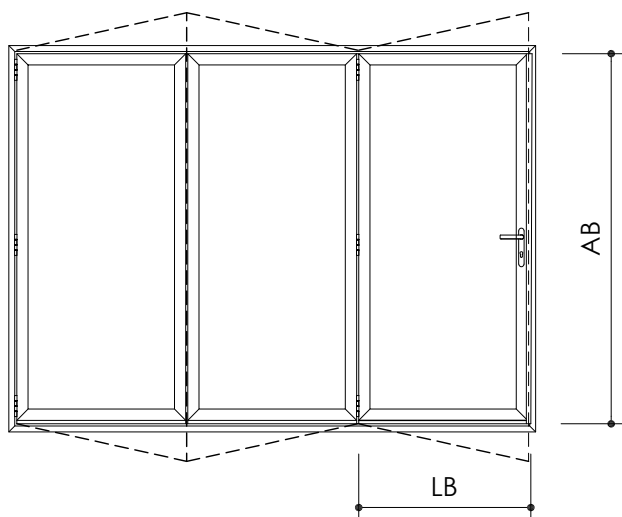


Using P-06-300 Slave
Door Adaptor

Table 3. DOOR SIZE LIMITS - NO TRAFFIC DOOR (OPEN IN & OPEN OUT) (SECURITY & NON SECURITY LOCK)

SECTION	HINGE NUMBER PER LEAF	LEAF DIMENSION				MAX WEIGHT (Kg)
		LB*		AB*		
		MIN	MAX	MIN	MAX	
P-06-200 / 202	3	700	1200	1000	3000	100
	4	700	1200	1000	3000	130
P-06-200 / 202	3	700	1200	1000	3000	100
	4	700	1200	1000	3000	130

* Dependant on wind load, see page 1.06. Leaf sizes greater than 1000mm x 2100mm requires 4 hinges. Weight over 100kg up to 130kg requires heavy duty rollers.



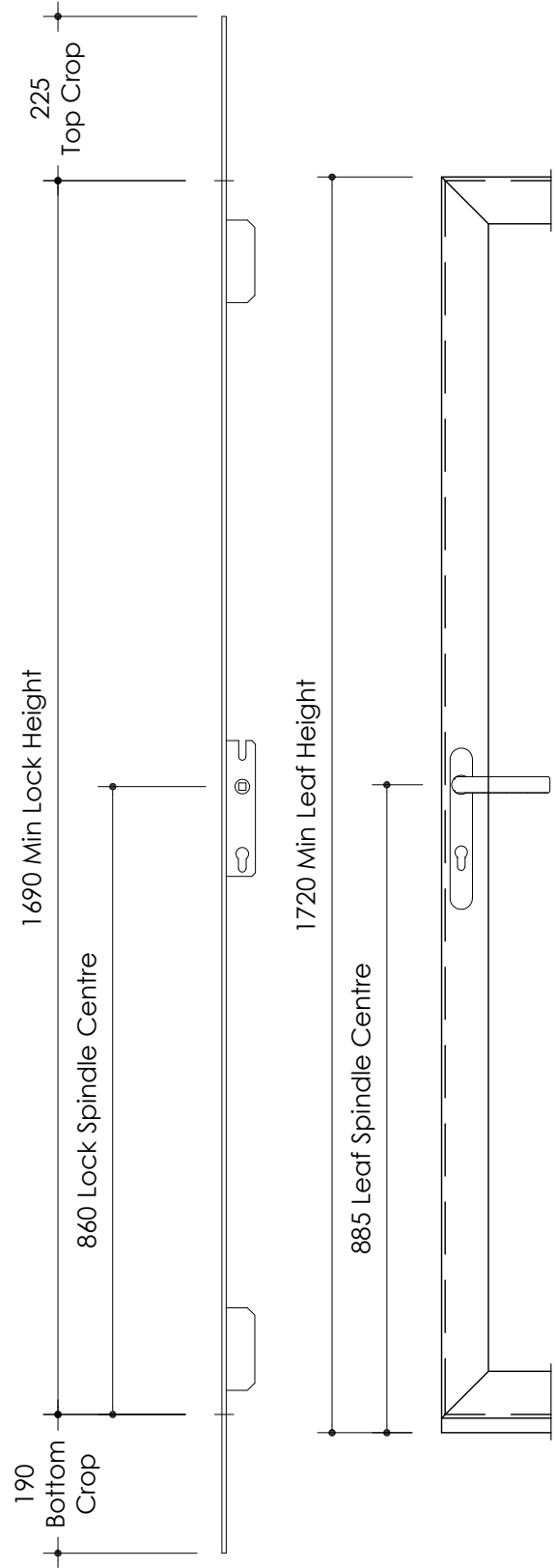
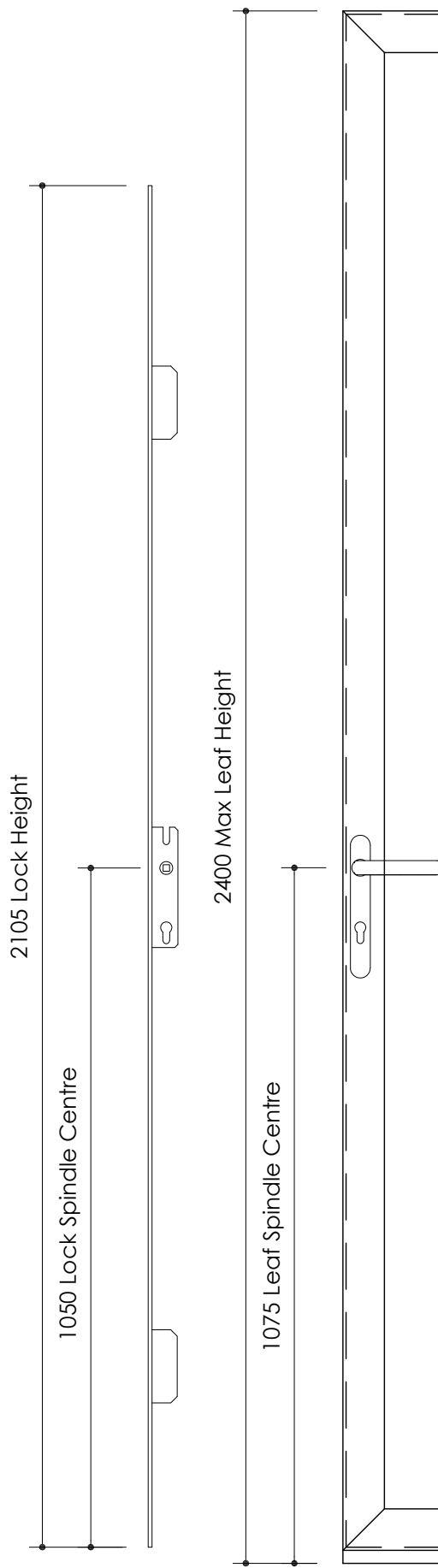
Using P-00-210 Rebate Adaptor

Table 4. DOOR SIZE LIMITS (OPEN IN & OPEN OUT) (SECURITY & NON SECURITY LOCK)

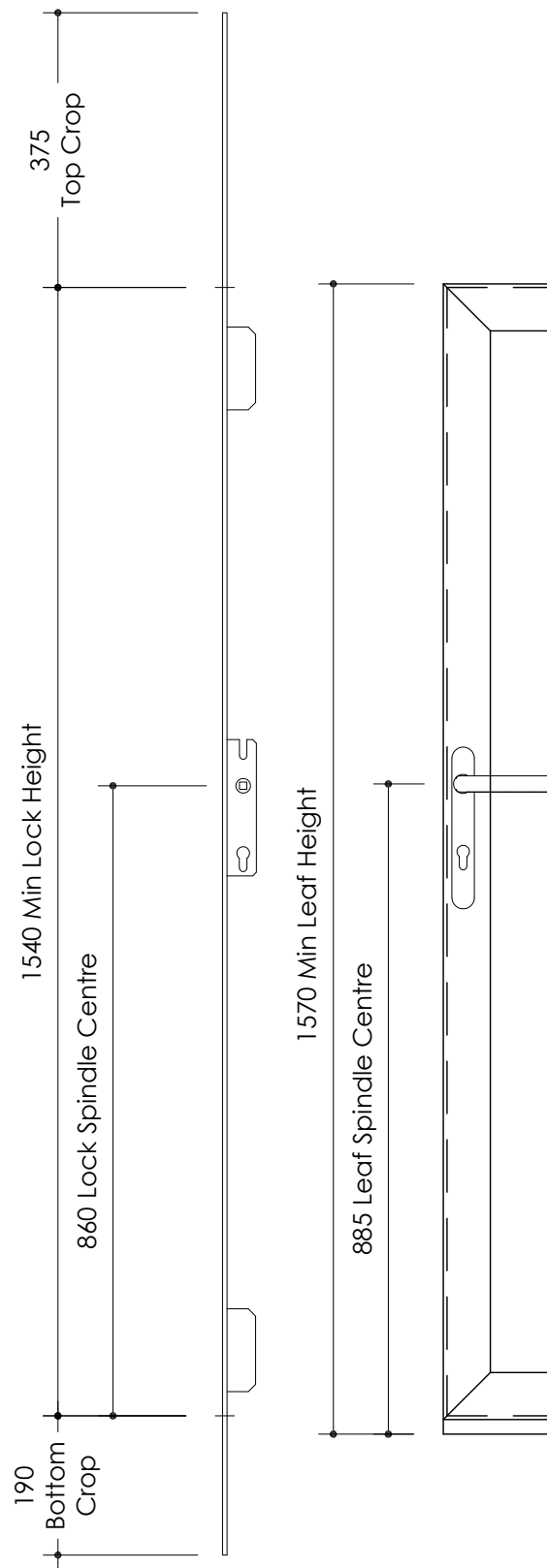
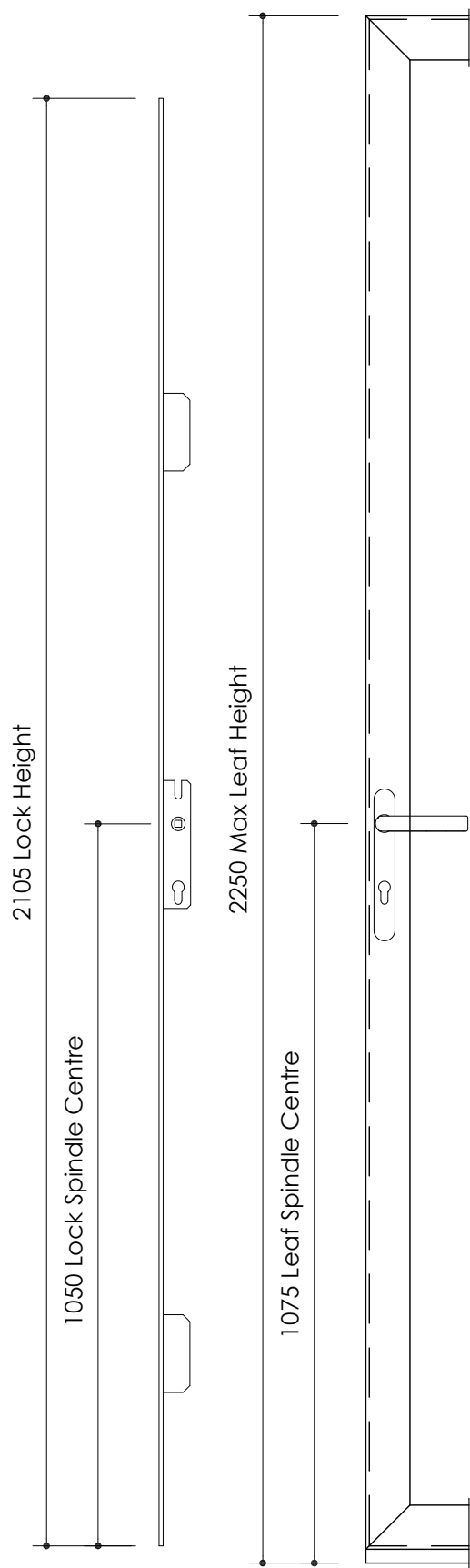
SECTION	HINGE NUMBER PER LEAF	LEAF DIMENSION				MAX WEIGHT (Kg)
		LB*		AB*		
		MIN	MAX	MIN	MAX	
P-06-200 / 202	3	550	1200	1570	2400	100
	4	550	1200	1570	2400	130
P-06-200 / 202	3	550	1200	1570	2400	100
	4	550	1200	1570	2400	130

* Dependant on wind load, see page 1.06. Leaf sizes greater than 1000mm x 2100mm requires 4 hinges. Weight over 100kg up to 130kg requires heavy duty rollers.

➤ TRAFFIC DOOR SIZE LIMITS - RX780 TRAFFIC DOOR LOCK



➤ TRAFFIC DOOR SIZE LIMITS - RX783 SHORT TRAFFIC DOOR LOCK

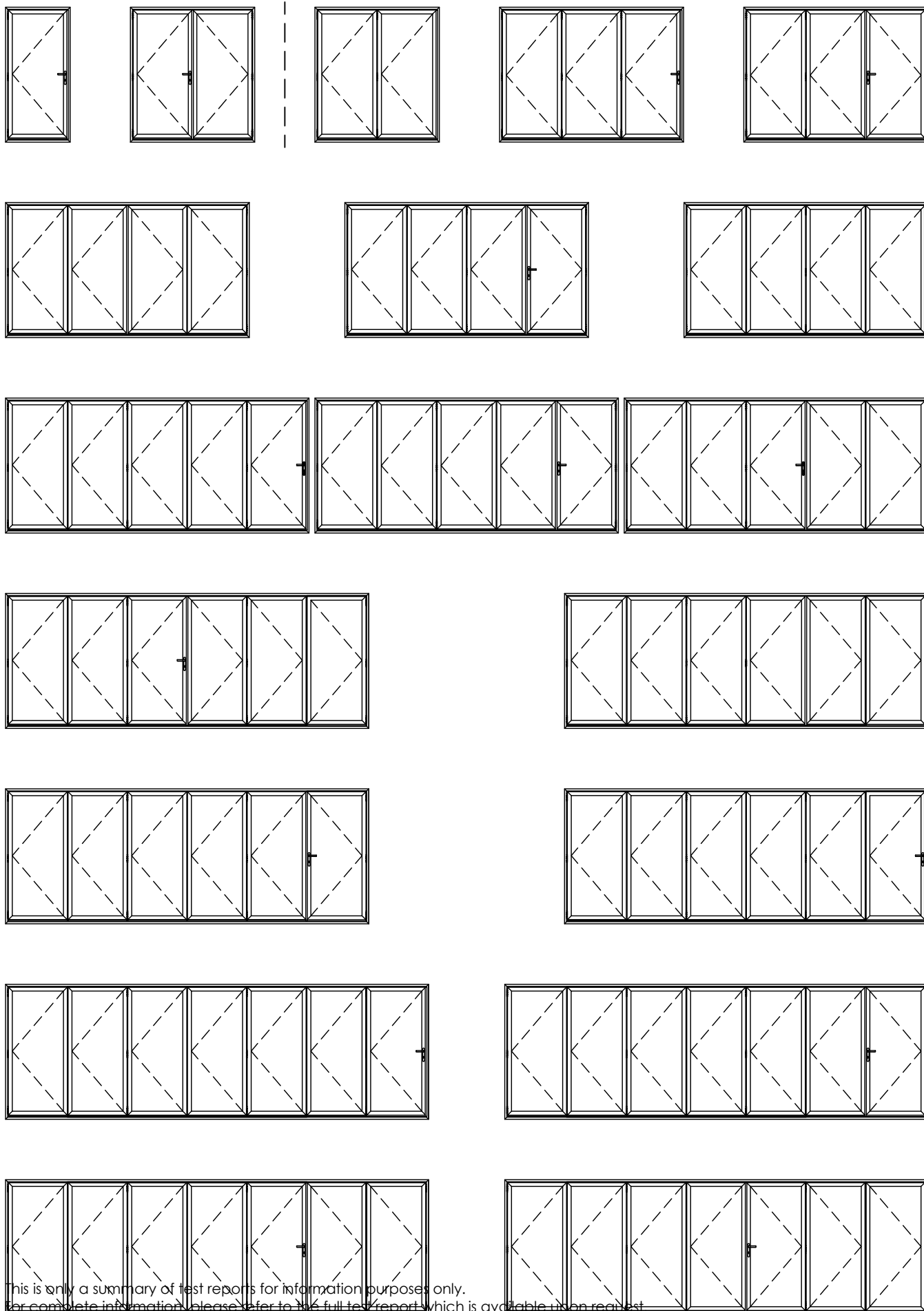


SPAN CHARTS

Deflection limited to a max of 12mm, no deflection allowable in head or cill of BSF70 due to running gear.

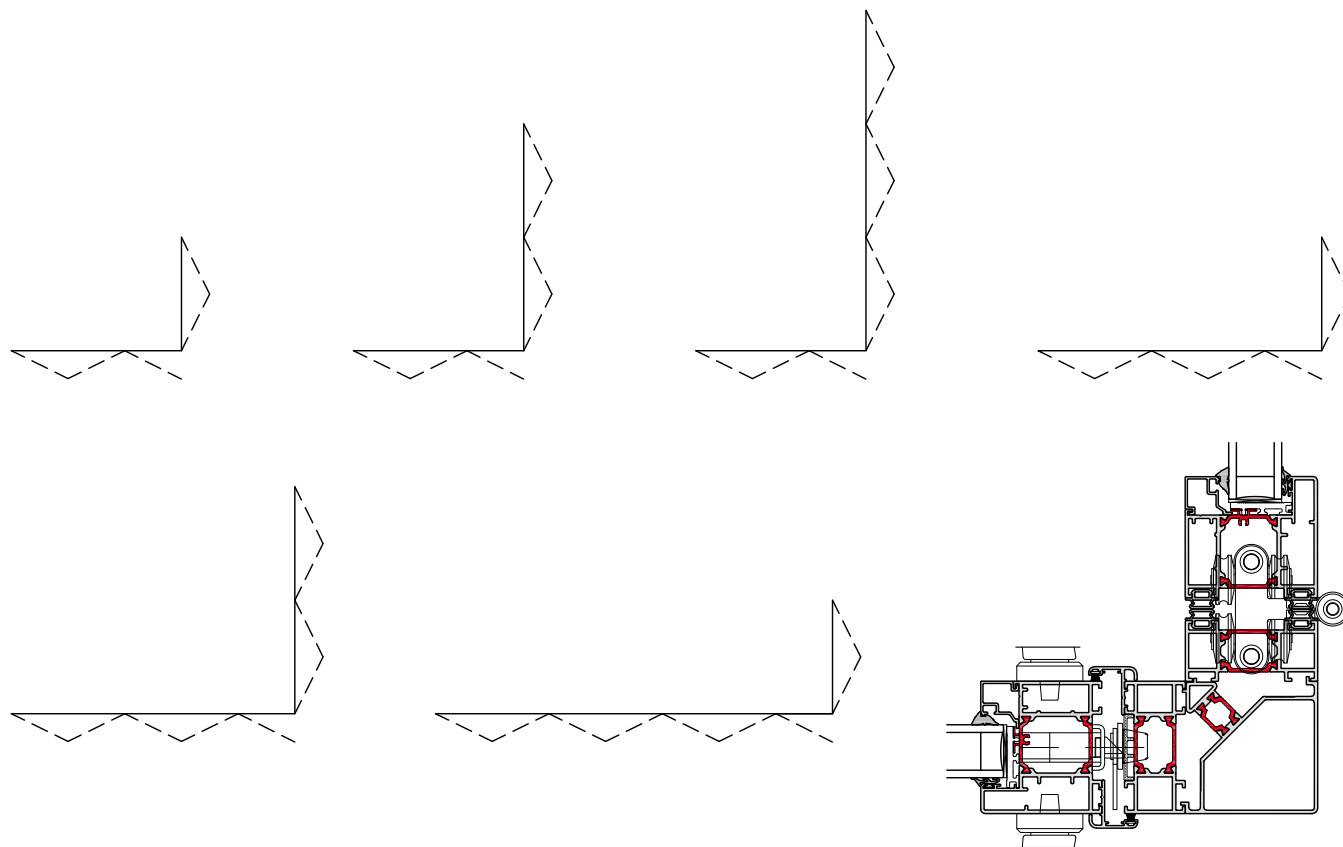
600 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	800
	2800	1000
	2600	1200
	2400	1200
	2200	1200
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
800 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	600
	2800	800
	2600	1100
	2400	1200
	2200	1200
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
1000 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	550
	2800	650
	2600	850
	2400	1100
	2200	1200
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
1200 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	-
	2800	550
	2600	700
	2400	1000
	2200	1200
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
1400 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	-
	2800	-
	2600	600
	2400	850
	2200	1200
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
1600 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	-
	2800	-
	2600	550
	2400	750
	2200	1050
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
1800 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	-
	2800	-
	2600	-
	2400	650
	2200	950
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
2000 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	-
	2800	-
	2600	-
	2400	600
	2200	850
	2000	1200
	1800	1200
	1600	1200
	1400	1200
	1200	1200
	1000	1200
2400 Pa	P-06-200/202 lxx = 68.1	
	Max. Panel Widths (mm)	
Overall Door Height (mm)	3000	-
	2800	-
	2600	-
	2400	-
	2200	550
	2000	750
	1800	950
	1600	1200
	1400	1200
	1200	1200
	1000	1200

► EXAMPLE CONFIGURATIONS

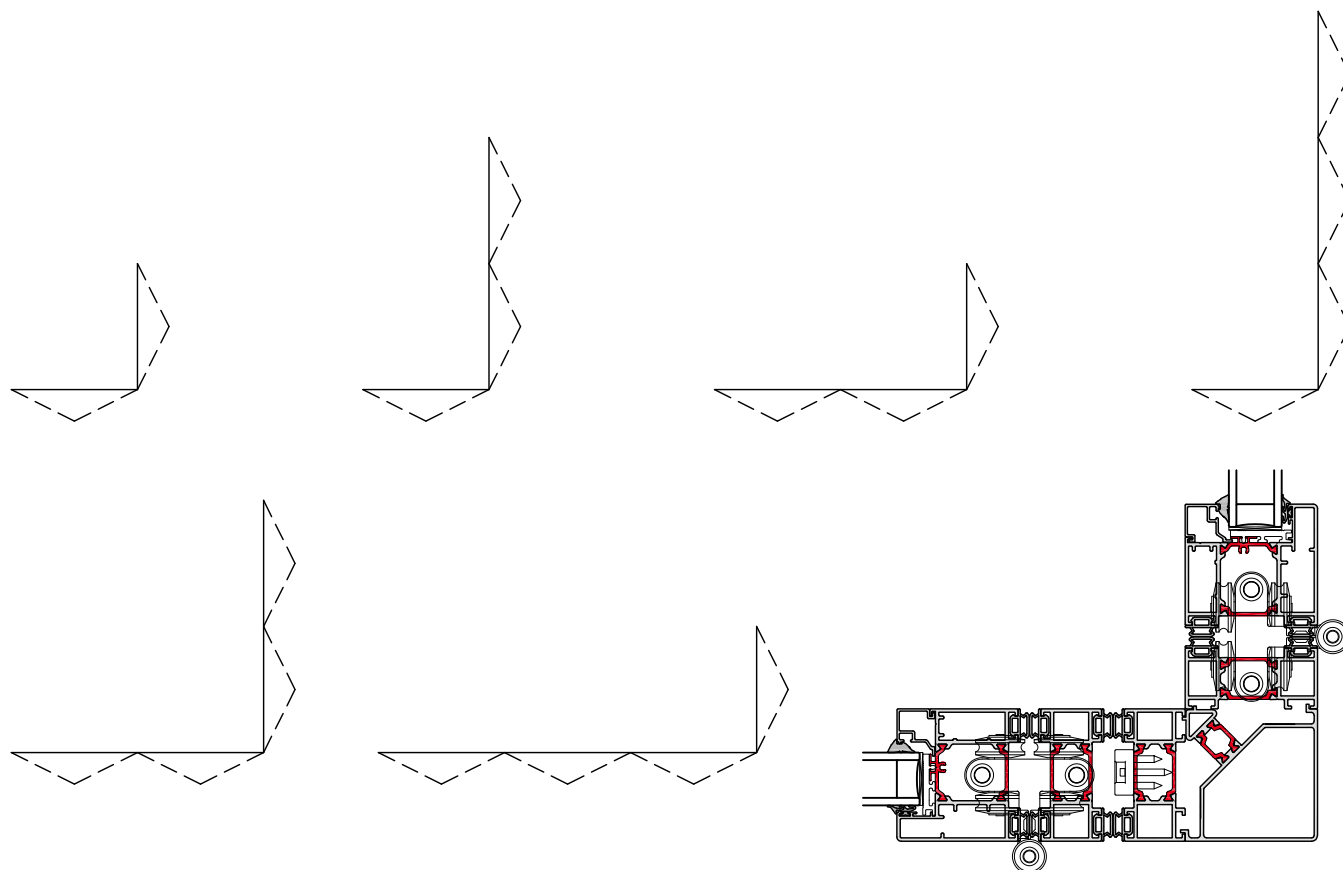


This is only a summary of test reports for information purposes only.
For complete information please refer to the full test report which is available upon request.

➤ EXAMPLE CONFIGURATIONS



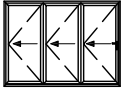
Corner Post configuration
Odd number of vents one direction,
Even number of vents in other direction



Corner Post configuration
Even number of vents in both directions

TEST PERFORMANCE

WEATHER TESTING

MOCK UP	AIR PERMEABILITY EN 1026 EN 12207	WATERTIGHTNESS EN 1027 EN 12208	RESISTANCE TO WIND LOAD EN 12211 EN 12210	CYCLIC OPERATION EN 1191 EN 12400	ENHANCED SECURITY PAS24
 L4120 H2640 mm	4 (600Pa)	9A (600Pa)	AE2400 (2400Pa)	1 (50 000 cycles)	PASS

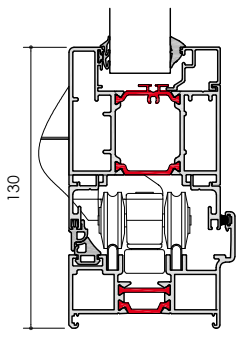
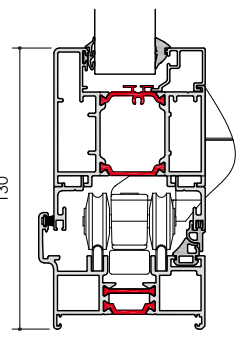
THERMAL TRANSMITTANCE (U_w)

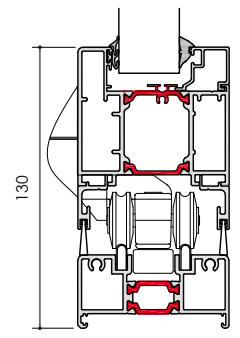
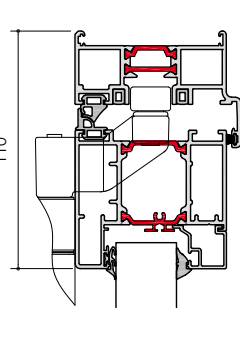
Glass U-value (W/m ² K)	Panel Variant						Door U-value (W/m ² K)
	1 Panel	2 Panel	3 Panel	4 Panel	5 Panel	6 Panel	
1.2	-	1.8	1.8	1.8	1.8	1.7	
1.1	-	1.8	1.8	1.7	1.7	1.7	
1.0	-	1.8	1.7	1.6	1.6	1.6	
0.9	-	1.6	1.6	1.5	1.5	1.5	
0.8	-	1.6	1.5	1.5	1.5	1.4	
0.7	-	1.5	1.4	1.4	1.4	1.4	

► THERMAL TRANSMITTANCE (U_f)

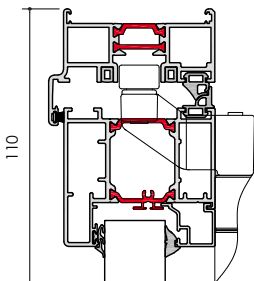
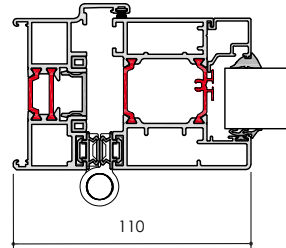
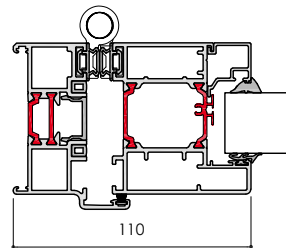
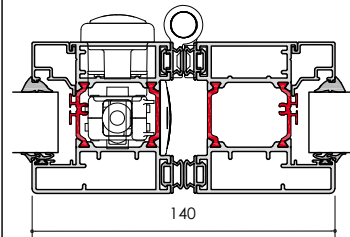
Thermal transmittance (U_f) of the nodes calculated according to EN ISO 10077-2.

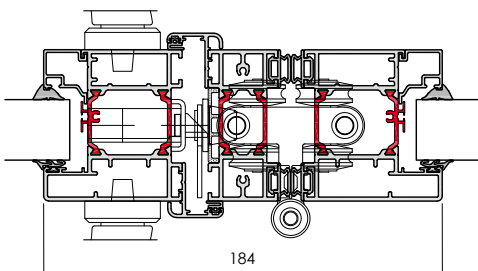
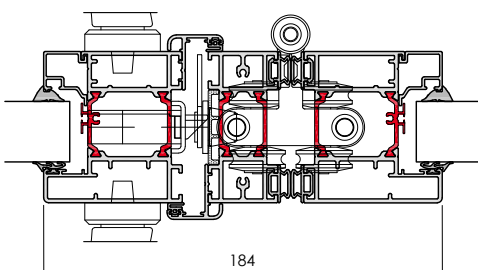
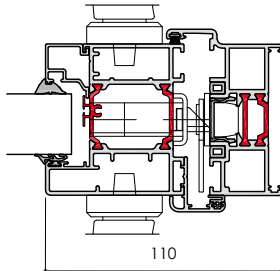
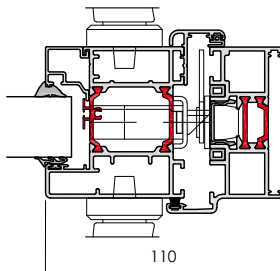
Profile Materials	Conductivity λ W/(m.K)	Emissivity ε
Aluminum alloy oxidized / painted	160	0.9
Polyamide	0.3	-
EPDM	0.25	-
Mohair sweep	0.14	-
PVC Flexible	0.14	-
PVC Rigid	0.17	-
Polyurethane solid	0.21	-
Polyurethane foam	0.05	-

	U_f [W/(m ² .K)]
	$\varepsilon = 0.9$
	3.35
P-06-100B P-06-200/202 N60630	
	3.29
P-06-100B P-06-200/202 N60630	

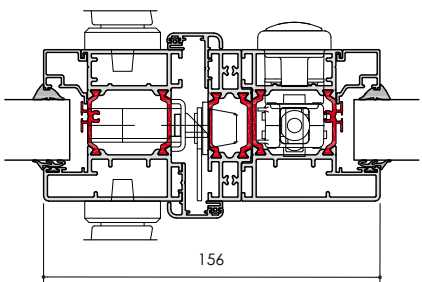
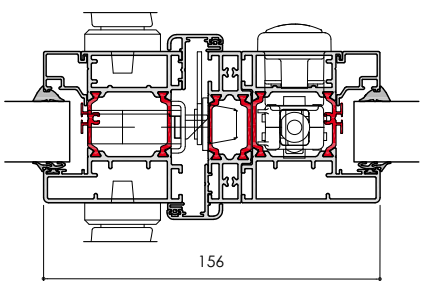
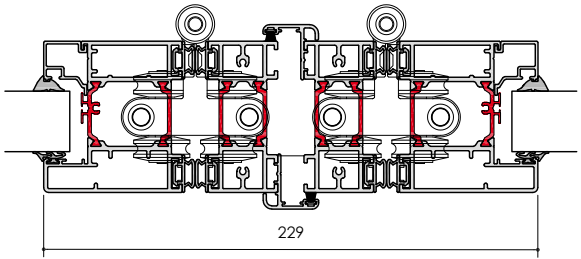
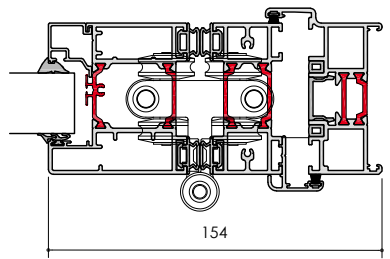
	U_f [W/(m ² .K)]
	$\varepsilon = 0.9$
	3.10
P-06-130 P-06-200/202 N60630	
	3.34
P-06-100B P-06-200/202	

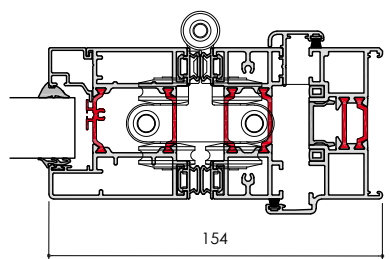
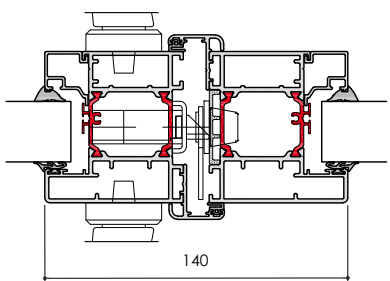
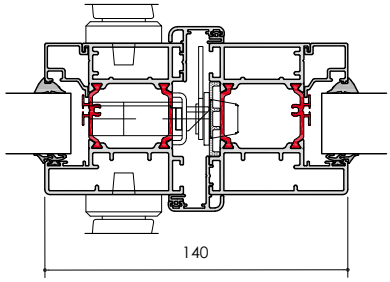
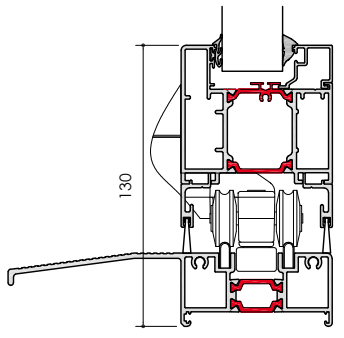
► THERMAL TRANSMITTANCE (U_f)

		U_f [W/(m ² .K)]
		$\epsilon = 0.9$
		3.27
	P-06-100B P-06-200/202 AW660	
		3.11
	P-06-100B P-06-200/202 AW660	
		3.06
	P-06-100B P-06-200/202 AW660	
		2.80
	P-06-200/202 AW660	

		U_f [W/(m ² .K)]
		$\epsilon = 0.9$
		
P-06-300 P-06-200/202 P-00-210 AW660		2.96
		
P-06-300 P-06-200/202 P-00-210 AW660		2.95
		
		3.17
		
		3.17
		P-06-100B P-06-200/202 P-00-210 AW660
		P-06-100B P-06-200/202 AW660

► THERMAL TRANSMITTANCE (U_f)

U_f [W/(m ² .K)] $\epsilon = 0.9$	
	
P-06-310 P-06-200/202 P-00-210 AW660	2.99
	
P-06-310 P-06-200/202 P-00-210 AW660	2.98
	
P-06-300 P-06-200/202 P-00-210 AW660	2.96
	
P-06-100B P-06-300 P-06-200/202 P-00-210 AW660	3.06

U_f [W/(m ² .K)] $\epsilon = 0.9$	
	
P-06-100B P-06-300 P-06-200/202 P-00-210 AW660	3.05
	
P-06-200/202 P-00-210 AW660	2.94
	
P-06-200/202 P-00-210 AW660	2.95
	
	3.16
	P-06-132 P-06-200/202 N60630 AW660

» WARRANTIES & LEGAL RESTRICTION

WARRANTIES

AluK S.A. (hereinafter "AluK") warrants that its systems meet the required technical characteristics.

Additional warranties may apply under certain conditions.

LEGAL RESTRICTION

All drawings and information in this technical manual are indicative and cannot engage our responsibility.

The AluK policy of continuous improvement determines the right to make the modifications without prior warning.

AluK cannot be held responsible for possible misprints or other technical errors in this manual. This technical manual cannot lead to any legal action whatsoever.

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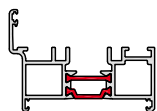
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SECTION 2 PROFILE INDEX

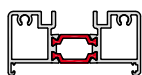


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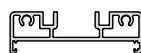
OUTERFRAME



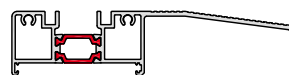
P-06-100B



P-06-130

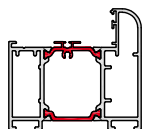


P-06-131

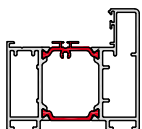


P-06-132

SASH

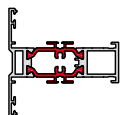


P-06-200

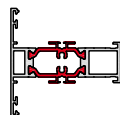


P-06-202

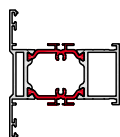
TRANSOM / MULLION



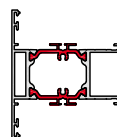
AD305



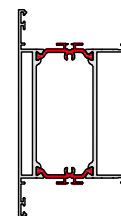
AD306



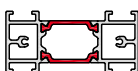
AD307



AD308

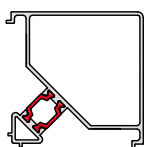


AD309



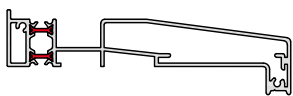
P-06-300

COUPLERS

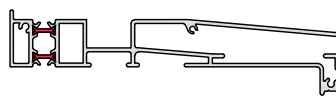


AW720

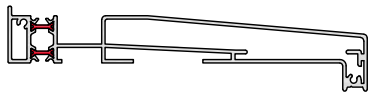
CILLS



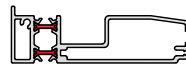
AW542r2



AW543r2



AW544r2



AW570r2



P-06-135

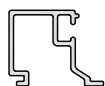
GLAZING BEAD / ADAPTOR



AW513



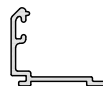
AW514



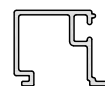
AW660



AW630



AW666



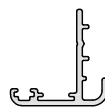
AW667



AW668



N60630



P-00-210



P-06-301

ADD ONS / ANCILLARY



AW645



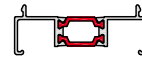
AW646



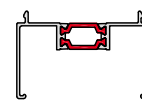
AW647



AW648



AW724



AW728



P-00-610



P-00-702

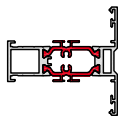
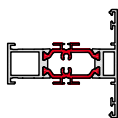
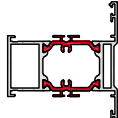
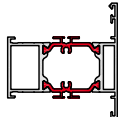
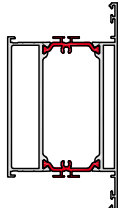


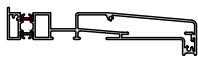
TW118



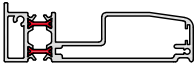
TW149

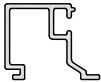
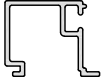
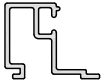
PROFILE INDEX

SECTION	CODE	DESCRIPTION
 5.04	AD305	20mm Transom (feature)
 5.04	AD306	20mm Transom (flat)
 5.05	AD307	32mm Transom (feature)
 5.05	AD308	32mm Transom (flat)
 5.06	AD309	110mm Midrail (flat)

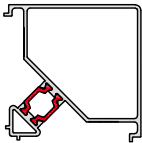
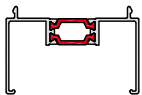
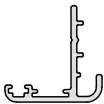
SECTION	CODE	DESCRIPTION
 5.07	AW513	28mm Bead
 5.07	AW514	36mm Bead
 5.08	AW542r2	150mm Drop nose cill
 5.08	AW543r2	177mm Drop nose sill
 5.08	AW544r2	190mm Drop nose cill

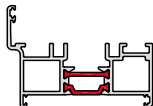
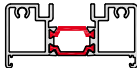
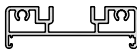
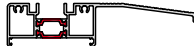
► PROFILE INDEX

SECTION	CODE	DESCRIPTION
 5.08	AW570r2	95mm Cill
 5.07	AW630	32mm bead
 5.10	AW645	Quadrant trim
 5.10	AW646	25mm x 5mm Trim
 5.10	AW647	35mm x 5mm Trim

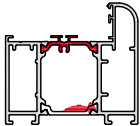
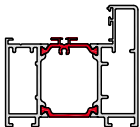
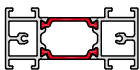
SECTION	CODE	DESCRIPTION
 5.10	AW648	70mm x 5mm Trim
 5.07	AW660	28mm Square bead
 5.07	AW666	44mm Bead
 5.07	AW667	24mm Square bead
 5.07	AW668	32mm Square bead

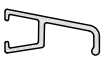
► PROFILE INDEX

SECTION	CODE	DESCRIPTION
 5.09	AW720	70mm Corner post
 5.09	AW724	20mm Frame extender (70mm)
 5.09	AW728	40mm Frame extender (70mm)
 5.06	N60630	Threshold adaptor
 5.06	P-00-210	FSD Rebate adaptor

SECTION	CODE	DESCRIPTION
 5.10	P-00-610	Georgian bar
 5.01	P-06-100B	FSD Outerframe
 5.01	P-06-130	FSD Low threshold (thermal)
 5.01	P-06-131	FSD Low threshold
 5.02	P-06-132	FSD Threshold ramp

► PROFILE INDEX

SECTION	CODE	DESCRIPTION
 5.02	P-06-135	FSD Drainage tray
 5.02	P-06-200	FSD Softline leaf
 5.03	P-06-202	FSD Square leaf
 5.03	P-06-300	FSD Floating mullion
 5.03	P-06-301	Slave door adaptor

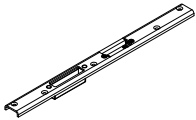
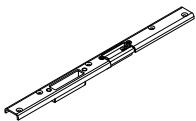
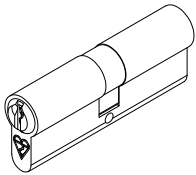
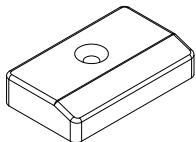
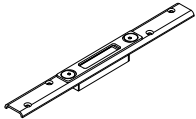
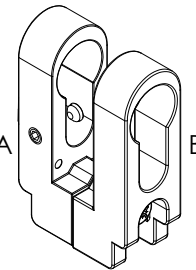
SECTION	CODE	DESCRIPTION
 5.10	TW118	Drip bar
 5.10	TW149	Georgian bar
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-	-	-
-	-	-

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SECTION 3 HARDWARE, ACCESSORY & FIXINGS

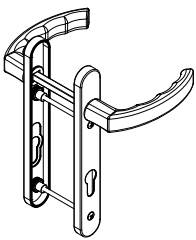
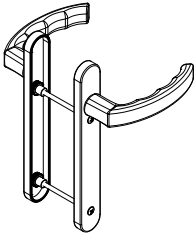
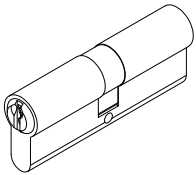
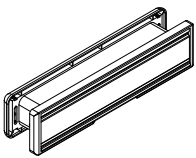
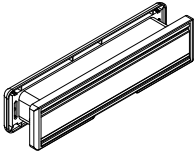
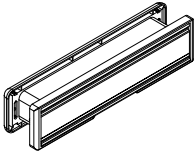


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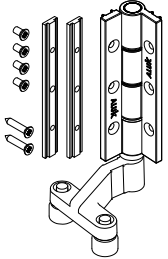
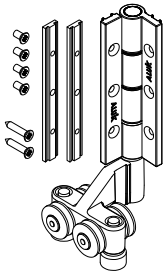
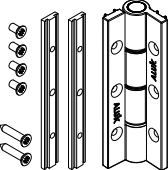
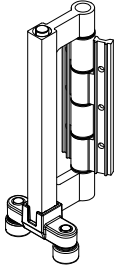
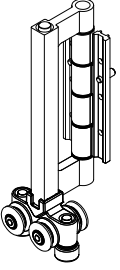
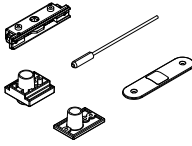
IMAGE	CODE	DESCRIPTION	FINISH
	RX012 LH	PAS24 Security hardware U26-952 centre keep LH	-
	RX012 RH	PAS24 Security hardware U26-952 centre keep RH	-
	RX014S	PAS24 Security hardware 40/40 Kitemark Euro double cylinder SNP	Satin nickel plated
	RX051	PAS24 Security hardware anti-jemmy block	White
	RX062	PAS24 Security hardware U26-952 MV1 hook keep (single pocket)	-
	RX110	PAS24 Security hardware ArmorShield cylinder guard A=External B=Internal	-

► HARDWARE

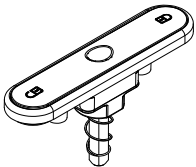
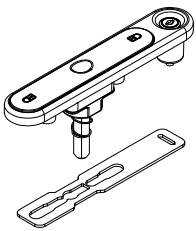
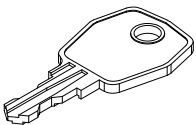
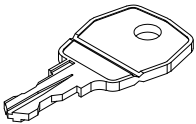
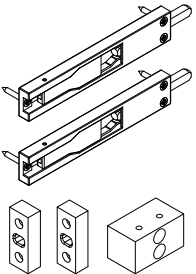
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IMAGE	CODE	DESCRIPTION	FINISH
	RX180	Lever - lever handle	 Chrome
	RX181	Dummy handle	 Chrome
	RX194	45/45 Standard cylinder SNP	Satin nickel plated
	RX591	Letterplate	White
	RX592	Letterplate	Silver
	RX594	Letterplate	Black

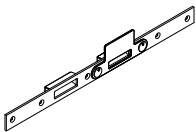
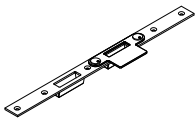
» HARDWARE

IMAGE	CODE	DESCRIPTION	FINISH
	RX701A	Top bogie	 Chrome
	RX702A	Bottom bogie	 Chrome
	RX703A	Hinge	 Chrome
	RX705	HD Top bogie	 Chrome
	RX706	HD bottom bogie	 Chrome
	RX710A	Shootbolt pack	-

► HARDWARE

IMAGE	CODE	DESCRIPTION	FINISH
	RX730	T handle	 Chrome Black Chrome
	RX731A	T locking handle	 Chrome Black Chrome
	RX740	Replacement / spare locking T handle key	-
	RX741	Flexible locking T handle key	-
	RX765	Finger bolt assembly	
	RX780 RH	Winkhaus traffic door lock	-

➤ HARDWARE

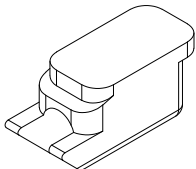
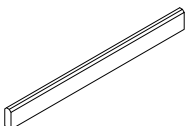
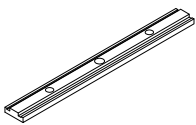
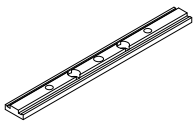
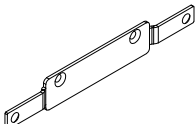
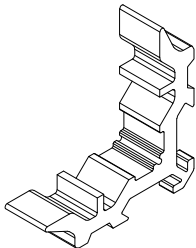
IMAGE	CODE	DESCRIPTION	FINISH
	RX780 LH	Winkhaus traffic door lock	-
	RX781 RH	Winkhaus centre keep	-
	RX781 LH	Winkhaus centre keep	-
	RX782	Winkhaus top / bottom keep	-
	RX783 RH	Short Winkhaus traffic door lock	-
	RX783 LH	Short Winkhaus traffic door lock	-

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ACCESSORY

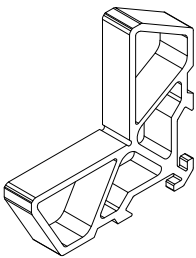
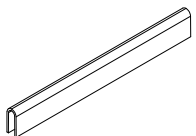
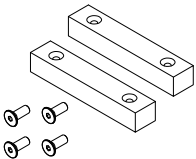
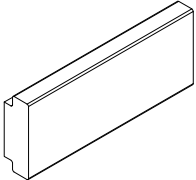
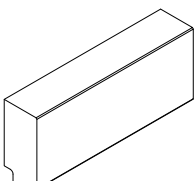
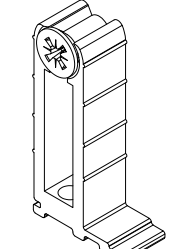
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HARDWARE, ACCESSORY & FIXINGS

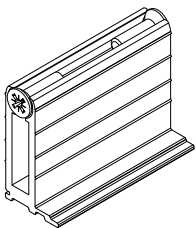
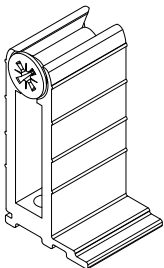
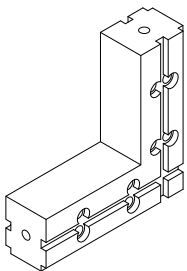
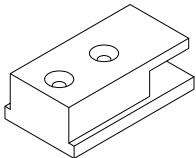
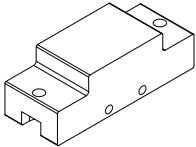
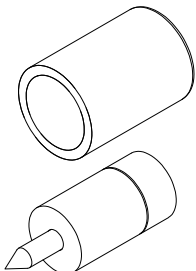
IMAGE	CODE	DESCRIPTION	FINISH
	A-00-110A	Mechanical cleat tensioning block	-
	RX016	Reinforced track insert 3.5m PAS24 & BSF70 corner post	-
	RX040	Hinge back plate	-
	RX041	RX706 Hinge back plate	-
	RX130	Midrail fixing bracket	-
	RX600	18.9mm Mechanical cleat	-

➤ ACCESSORY

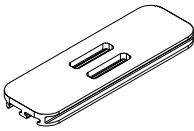
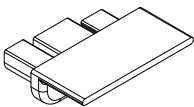
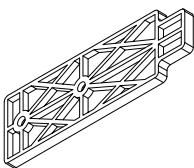
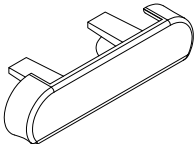
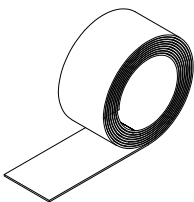
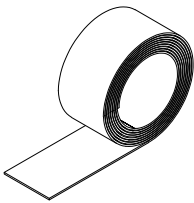
UNCONTROLLED COPY

IMAGE	CODE	DESCRIPTION	FINISH
	RX601	13.7mm Mechanical cleat	-
	RX610	6.5m FSD SS track	-
	RX627	Outer frame jointing kit (x4 parts within each kit)	-
	RX642	Jamb plug 34mm	-
	RX643	Jamb plug 34mm	-
	RX660	Slim transom / mullion fixing bracket	-

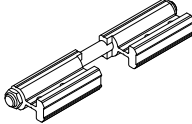
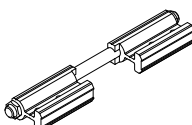
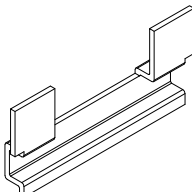
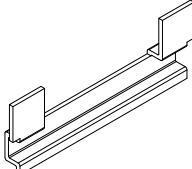
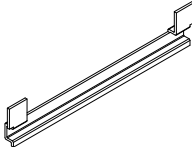
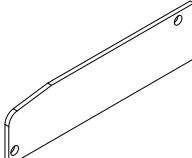
➤ ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH
	RX661	Midrail mechanical bracket	-
	RX662	Wide mullion / transom mechanical bracket	-
	RX665	BSF70 Corner post (AW720 & P-06-100B) 90° corner cleat / adaptor	-
	RX704	Floating mullion block	
	RX716B	BSF70 Corner post top / bottom shootbolt fixing	Black
	RX720	Traffic door magnet	

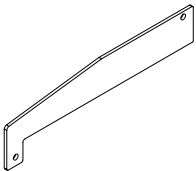
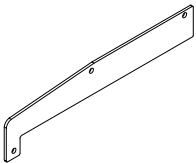
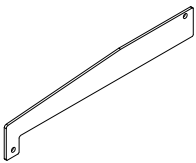
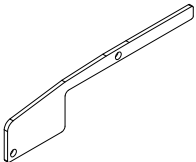
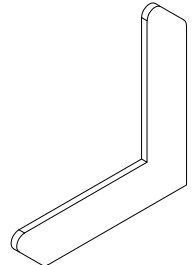
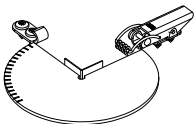
ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH
	RX756	Bridge packer	-
	RX770	P-00-210 End caps	
	RX775	Anti twist guide	-
	RX916	Drain hole cover	
	XA110	Low tack tape 50mm wide 100m roll	-
	XA111	Low tack tape 75mm wide 100m roll	-

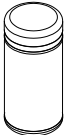
» ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH
	XA415	Slim cruciform bracket	-
	XA416	Wide cruciform bracket	-
	XA437	Anti twist (slim) transom clip	-
	XA438	Anti twist (standard) transom clip	-
	XA439	Anti twist (wide) transom clip	-
	XA790	96mm Cill end cap	

➤ ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH
	XA791	150mm Cill end cap	
	XA792	177mm Cill end cap	
	XA793	190mm Cill end cap	
	XA795	2 Part cill end cap	
	XA904	Narrow chevron	-
	XA946	Bay window cill jointing kit	-

» ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH
	A-52-253	Tremco PU540 sealant adhesive	1
	T50000	Small joint sealant, 290ml (Black)	12
	T50001	Small joint sealant, 290ml (White)	12
	T50002	Small joint sealant, 290ml (RAL7016)	12
	T50003	Aluk sealant wipes	6
	-	-	-

UNCONTROLLED COPY

FIXINGS

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HARDWARE, ACCESSORY & FIXINGS

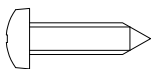
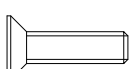
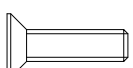
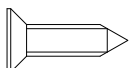
IMAGE	CODE	DESCRIPTION	FINISH
	-	Jamb post to low threshold Ø4.8mm x 32mm Pan S/S self tapping screw	-
	-	Shootbolt faceplate to gearbox M5 x 16mm Csk S/S screw	-
	-	'T' handle to gearbox M5 x 25mm Csk S/S screw	-
	-	Top shootbolt guide Bottom shootbolt guide Ø3.9mm x 32 Csk S/S self tapping screw	-
	-	P-00-211 threshold adaptor Lock keep Anti jimmy block Slave door adaptor Ø3.9mm x 25mm Csk S/S self tapping screw	-
	-	Traffic door lock Magnetic catch Hinge dead fix RX704 to floating mullion Ø4.2mm x 25mm Csk S/S self tapping screw	-

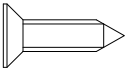
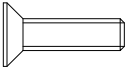
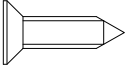
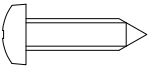
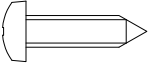
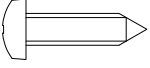
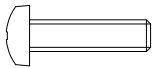
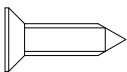
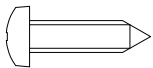
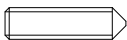
IMAGE	CODE	DESCRIPTION	FINISH
	-	P-00-210 rebate adaptor Ø3.9mm x 19mm Csk S/S self tapping screw	-
	-	Hinge to back plate M5 x 10mm Csk S/S screw	-
	-	RX775 to floating mullion Ø4.2mm x 19 Csk S/S self tapping screw	-
	-	RX761 to outer frame RX762 to leaf bottom Ø3.5mm x 19 Pan S/S self tapping screw	-
	-	Jamb to corner post Ø4.2mm x 13mm Pan S/S self tapping screw	-
	-	Jamb to corner post Ø4.2mm x 25mm Pan S/S self tapping screw	-

IMAGE	CODE	DESCRIPTION	FINISH
	-	RX665 to corner post M4 x 13mm Pan S/S screw	-
	-	Adaptor to corner post Ø3.5mm x 25mm Csk S/S self tapping screw	-
	-	RX716B to corner post Ø3.5mm x 25mm Pan S/S self tapping screw	-
	XA606	Mid-rail bracket fixing M6 Grub screw	-
	-	-	-
	-	-	-

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UNCONTROLLED COPY

SECTION 4 GASKET & PLASTIC PROFILE

UNCONTROLLED COPY

GASKET & PLASTIC PROFILE

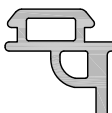
UNCONTROLLED COPY

IMAGE	CODE	DESCRIPTION	MATERIAL
	A-GS-240	Slide in E gasket	TPR & Plastic (Black)
	A-GS-304	Internal glazing gasket 4mm	EPDM (Black)
	A-GS-305	Internal glazing gasket 5mm	EPDM (Black)
	A-GS-306	Internal glazing gasket 6mm	EPDM (Black)
	A-GS-308	Internal glazing gasket 8mm	EPDM (Black)
	A-GS-504	Push in E gasket	EPDM (Black)

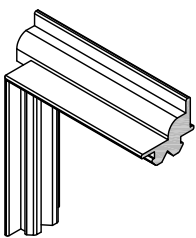
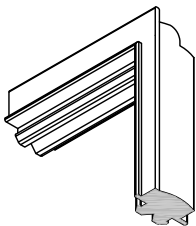
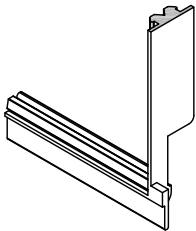
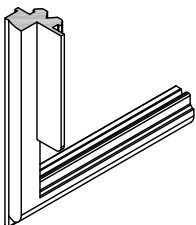
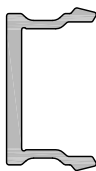
GASKET & PLASTIC PROFILE

➤ GASKET & PLASTIC PROFILE

UNCONTROLLED COPY

IMAGE	CODE	DESCRIPTION	MATERIAL
	PX302	4.8 825 WF wool pile	Poly-Bond (Grey)
	RX609	Interlock & jamb seal	EPDM (Black)
	RX611	FSD Track seal	EPDM (Black)
	RX612	Bottom frame seal	EPDM (Black)
	RX614	Head seal	EPDM (Black)
	RX615	Bottom carrier seal	EPDM (Black)

➤ GASKET & PLASTIC PROFILE

IMAGE	CODE	DESCRIPTION	MATERIAL
	RX616	Top bogie corner mould (left & right hand)	EPDM (Black)
	RX617A	Top corner mould (left & right hand)	EPDM (Black)
	RX618	Bottom bogie corner mould (left & right hand)	EPDM (Black)
	RX619A	Bottom bogie corner mould (left & right hand)	EPDM (Black)
	RX640	Push in flipper gasket	TPE (Black)
	RX641	Outer frame finishing trim - 3m	PVC (Black)

➤ GASKET & PLASTIC PROFILE

IMAGE	CODE	DESCRIPTION	MATERIAL
	RX644	19mm Low threshold brush woolpile - 3m	PP (Black)
	RX757	Keep packer	PVC (Black)
	-	-	-
	-	-	-
	-	-	-
	-	-	-

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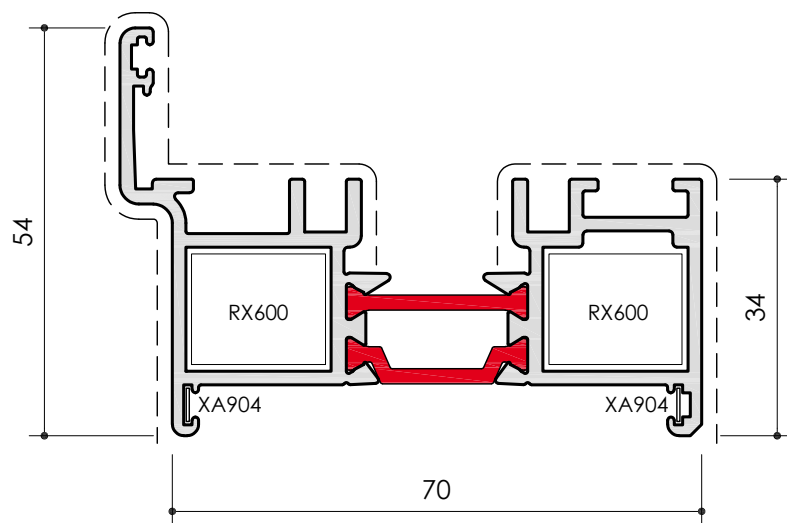
SECTION 5 PROFILE SECTION



UNCONTROLLED COPY

PROFILE SECTION

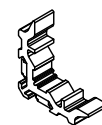
➤ OUTER FRAME



P-06-100B

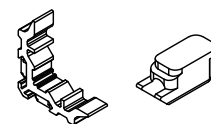
I_{xx}	38.1 cm ⁴	W_{xx}	cm ³
I_{yy}	7.3 cm ⁴	W_{yy}	cm ³
Profile length (m) 6.5			

CRIMP



RX600

MECHANICAL



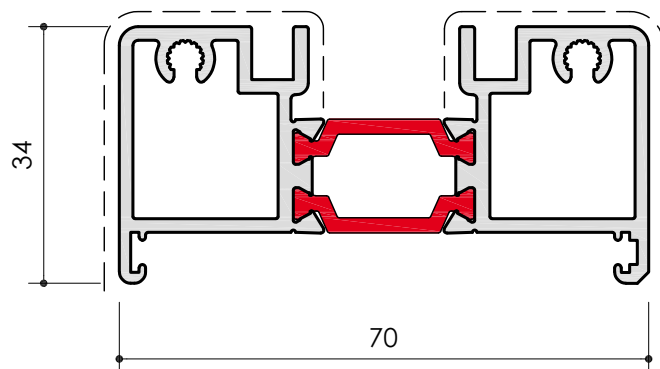
RX600 & A-00-110

CHEVRON



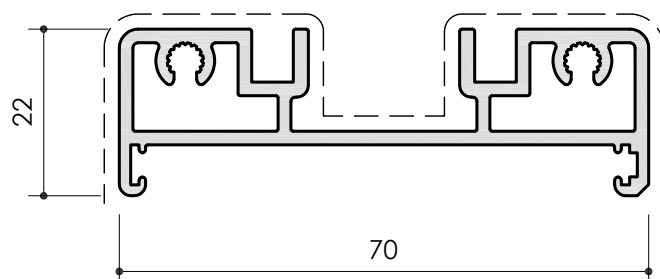
XA904

➤ LOW THRESHOLD



P-06-130

Profile length (m) 6.5

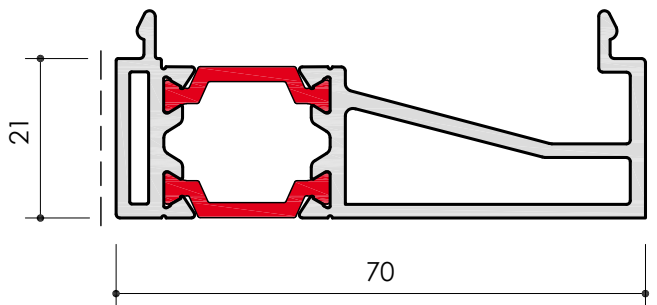


P-06-131

Profile length (m) 6.5

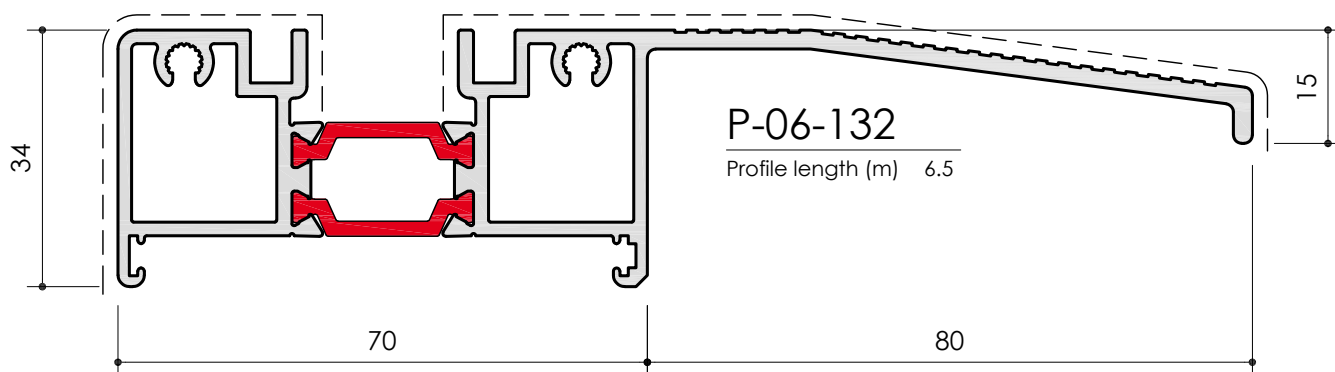
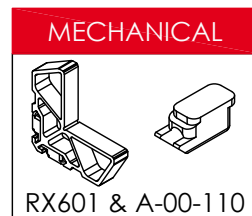
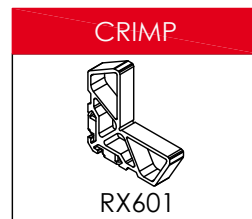
Primary surface — — — — —

► LOW THRESHOLD

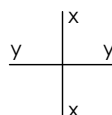
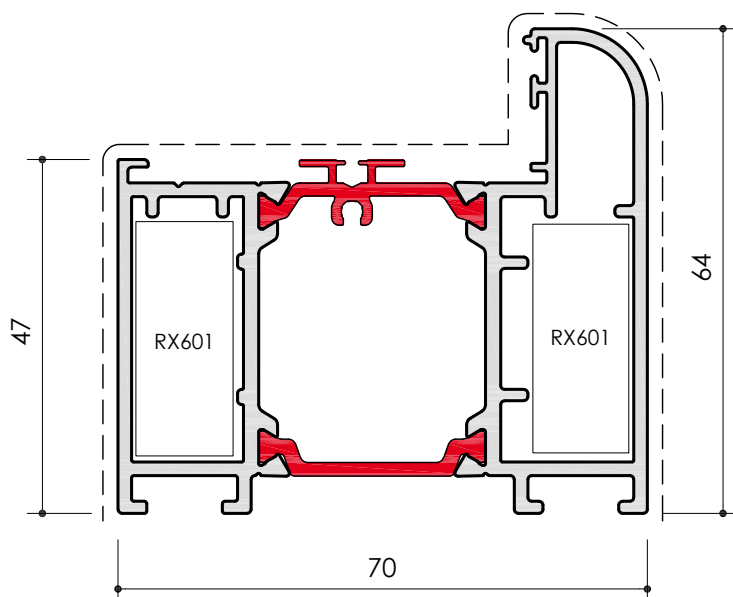


P-06-135

Profile length (m) 6.5



► DOOR LEAF



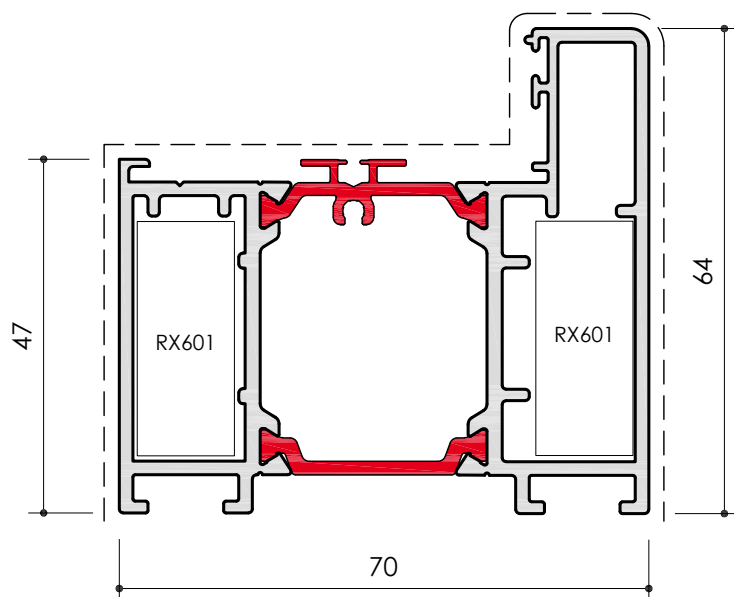
P-06-200

lxx	42.63 cm ⁴	Wxx	cm ³
lyy	23.28 cm ⁴	Wyy	cm ³

Profile length (m) 6.5

Primary surface — — — — —

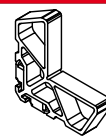
DOOR LEAF



P-06-202

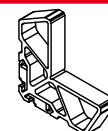
I_{xx}	43.73 cm ⁴	W_{xx}	cm ³
I_{yy}	23.67 cm ⁴	W_{yy}	cm ³
Profile length (m) 6.5			

CRIMP



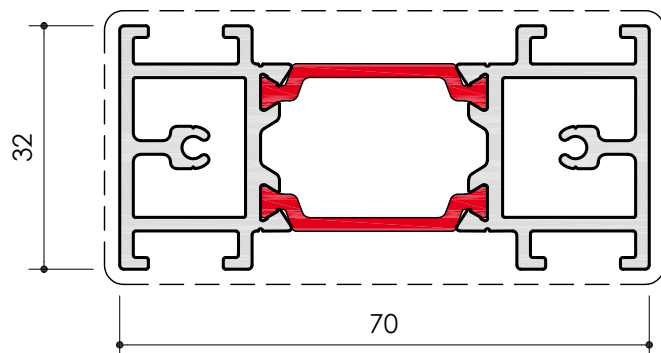
RX601

MECHANICAL



RX601 & A-00-110

FLOATING MULLION

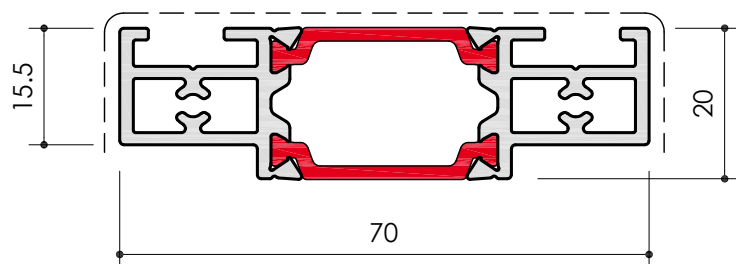


P-06-300

I_{xx}	28.72 cm ⁴	W_{xx}	cm ³
I_{yy}	5.35 cm ⁴	W_{yy}	cm ³

Profile length (m) 3.25
Profile length (m) 6.5

ADAPTOR

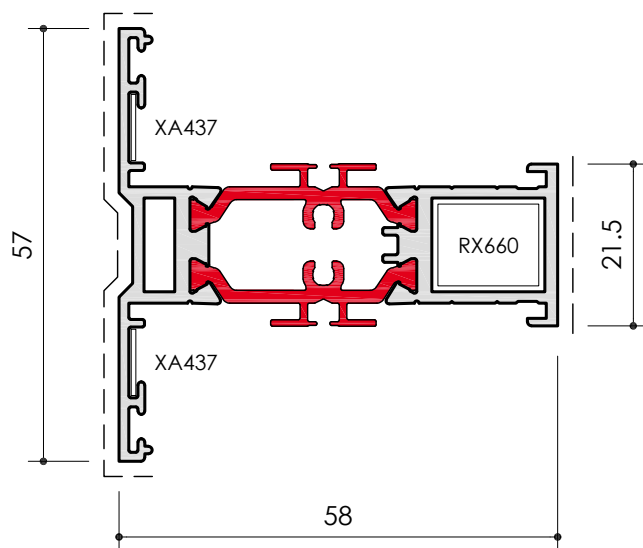


P-06-301

I_{xx}	20.50 cm ⁴	W_{xx}	cm ³
I_{yy}	1.98 cm ⁴	W_{yy}	cm ³

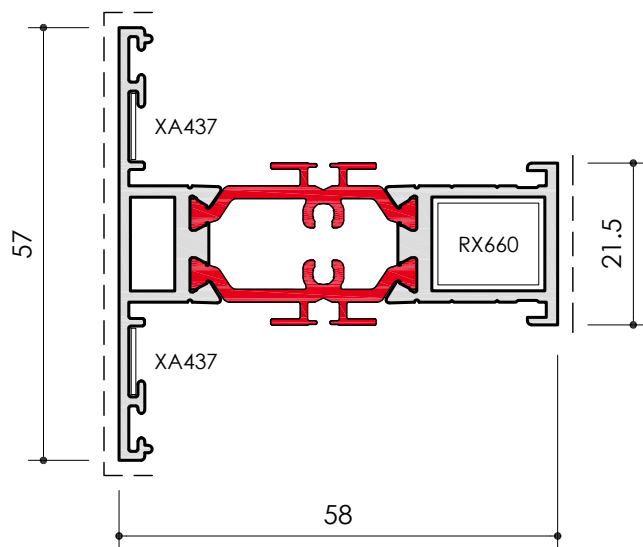
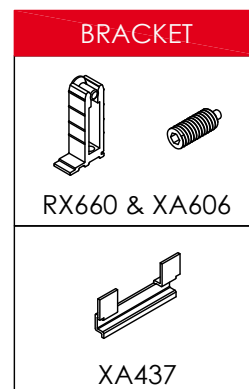
Profile length (m) 6.5

Primary surface — — — — —



AD305

$\begin{matrix} x \\ y \end{matrix}$	$\begin{matrix} x \\ y \end{matrix}$	I_{xx}	18.97 cm ⁴	W_{xx}	cm ³
$\begin{matrix} y \\ x \end{matrix}$	$\begin{matrix} x \\ y \end{matrix}$	I_{yy}	4.77 cm ⁴	W_{yy}	cm ³
Profile length (m) 5.0					

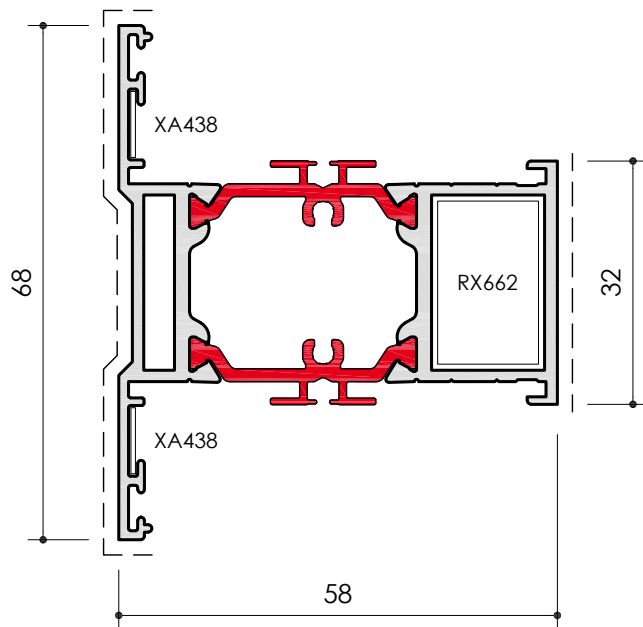


AD306

$\begin{matrix} x \\ y \end{matrix}$	$\begin{matrix} x \\ y \end{matrix}$	I_{xx}	19.07 cm ⁴	W_{xx}	cm ³
$\begin{matrix} y \\ x \end{matrix}$	$\begin{matrix} x \\ y \end{matrix}$	I_{yy}	4.71 cm ⁴	W_{yy}	cm ³
Profile length (m) 5.0					

Primary surface - - - - -

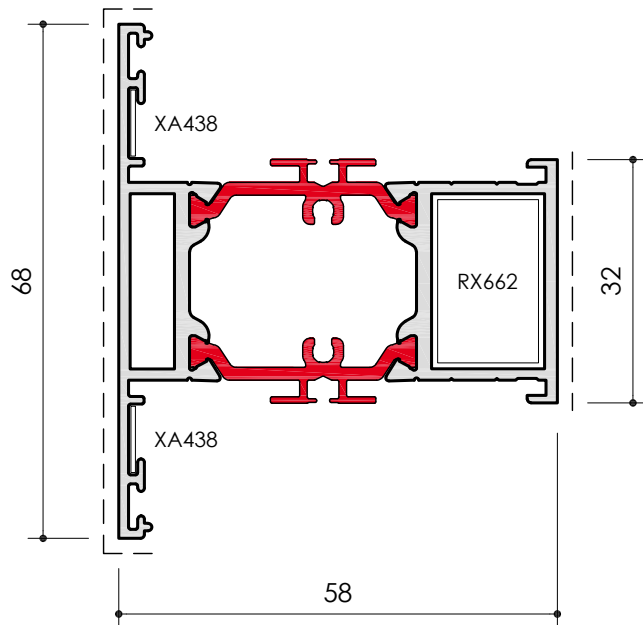
➤ MIDRAIL



AD307

I_{xx}	23.09 cm ⁴	W_{xx}	cm ³
I_{yy}	10.32 cm ⁴	W_{yy}	cm ³

Profile length (m) 5.0

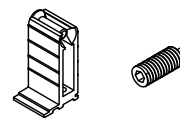


AD308

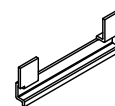
I_{xx}	23.35 cm ⁴	W_{xx}	cm ³
I_{yy}	10.31 cm ⁴	W_{yy}	cm ³

Profile length (m) 5.0

BRACKET



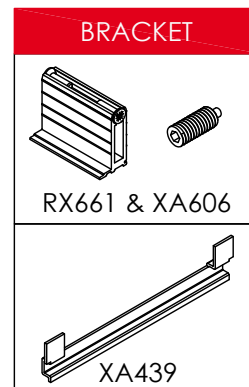
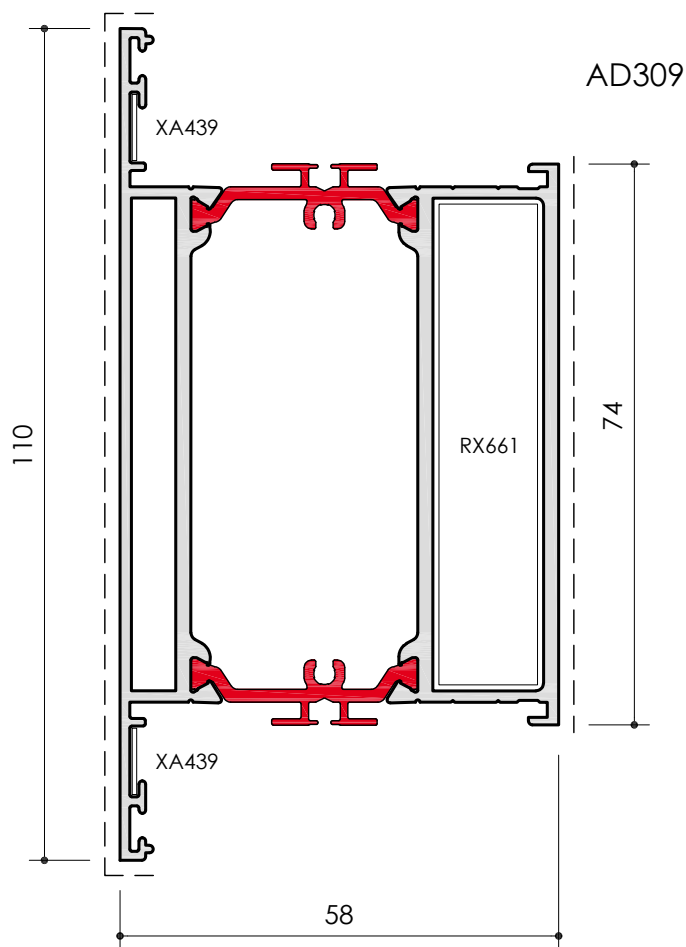
RX662 & XA606



XA438

Primary surface — — — — —

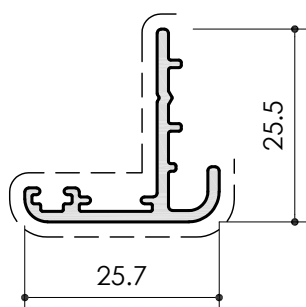
➤ MIDRAIL



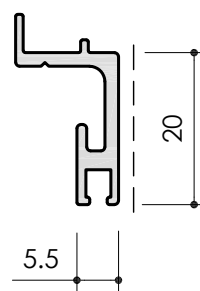
AD309

I_{xx}	41.16 cm ⁴	W_{xx}	cm ³
I_{yy}	72.09 cm ⁴	W_{yy}	cm ³
Profile length (m) 5.0			

➤ ADAPTOR



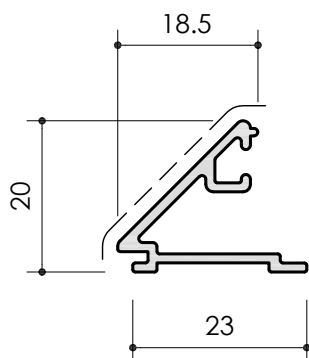
P-00-210
Profile length (m) 6.5



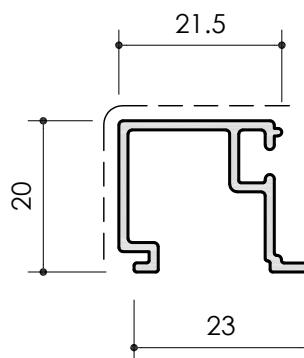
N60630
Profile length (m) 6.5

Primary surface — — — — —

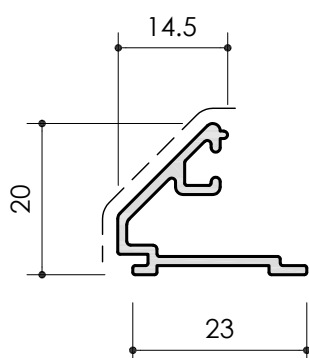
➤ BEAD



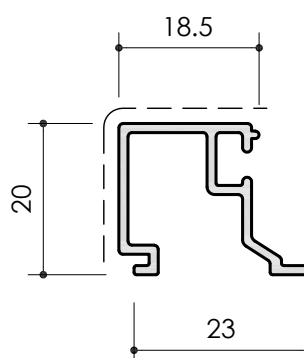
AW513
Profile length (m) 5.0



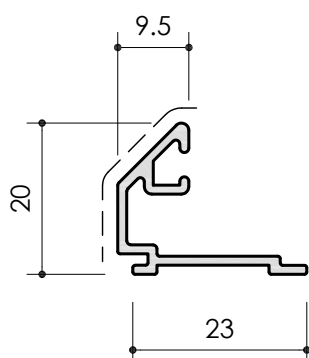
AW667
Profile length (m) 5.0



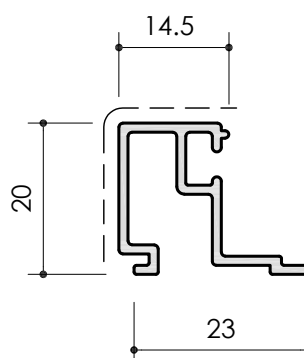
AW630
Profile length (m) 5.0



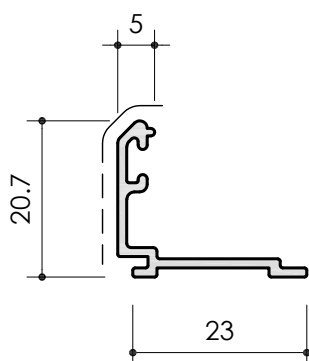
AW660
Profile length (m) 5.0



AW514
Profile length (m) 5.0

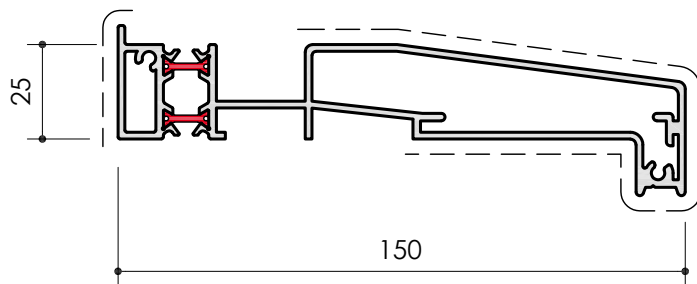


AW668
Profile length (m) 5.0



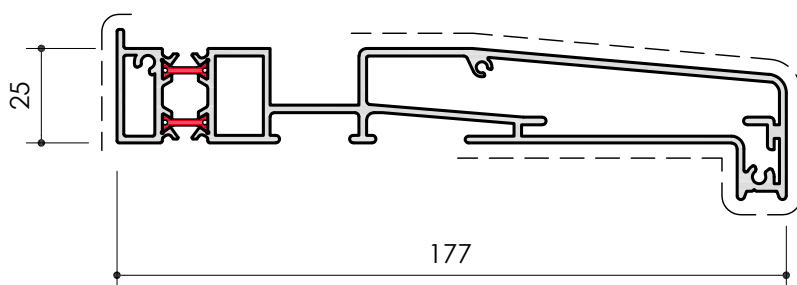
AW666
Profile length (m) 5.0

Primary surface - - - - -



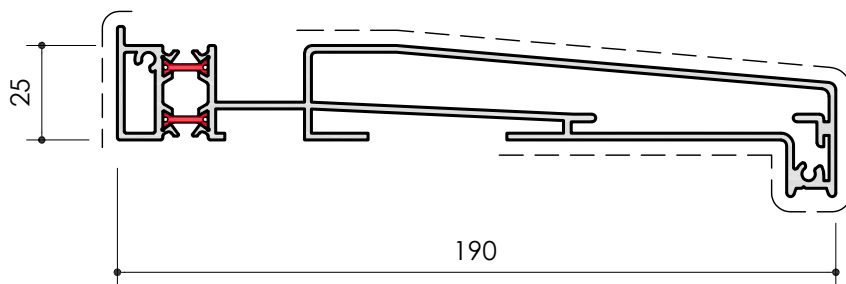
AW542r2

Profile length (m) 5.0
Profile length (m) 6.5
Scale 1:2



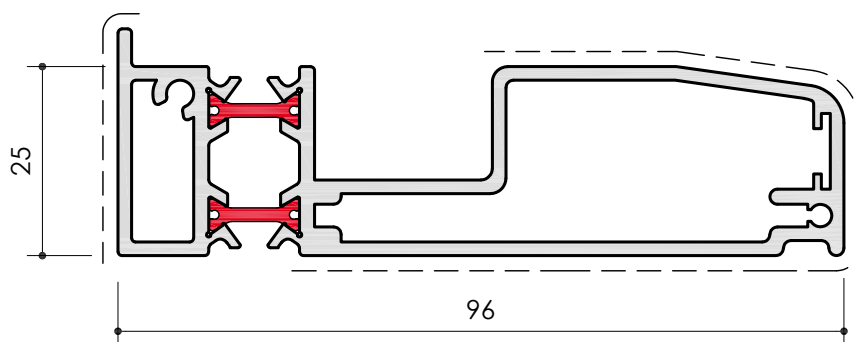
AW543r2

Profile length (m) 5.0
Scale 1:2



AW544r2

Profile length (m) 5.0
Profile length (m) 6.5
Scale 1:2

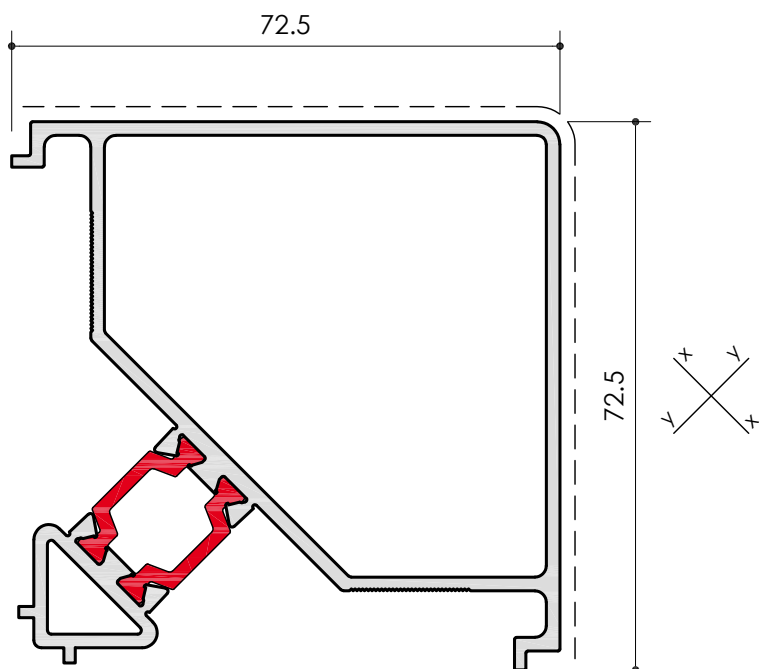


AW570r2

Profile length (m) 5.0

Primary surface — — — — —

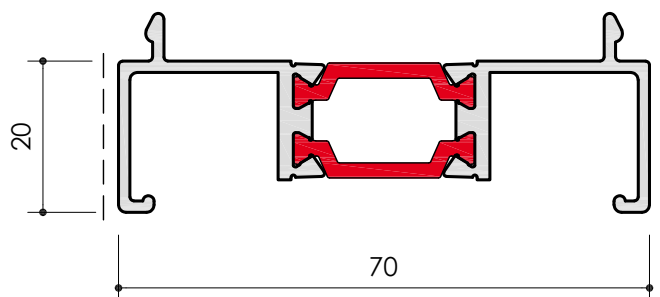
ANCILLARY



AW720

I_{xx}	45.44 cm ⁴	W_{xx}	cm ³
I_{yy}	37.67 cm ⁴	W_{yy}	cm ³
Profile length (m)		5.0	

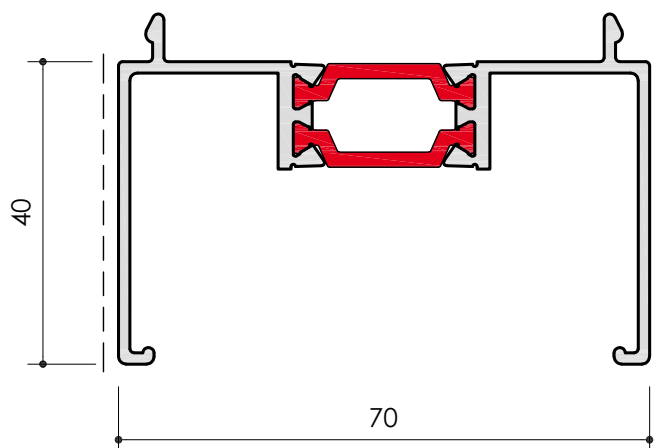
AW724



AW724

Profile length (m)	5.0
Profile length (m)	6.5

AW728

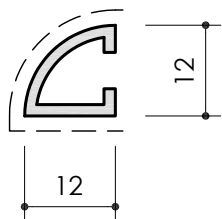


AW728

Profile length (m)	5.0
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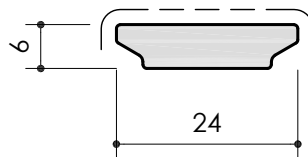
Primary surface ————

► ANCILLARY



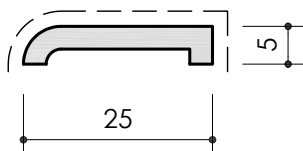
AW645

Profile length (m) 5.0



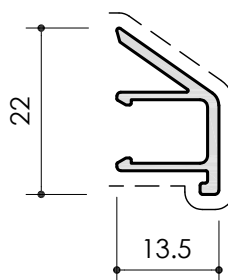
P-00-610

Profile length (m) 6.5



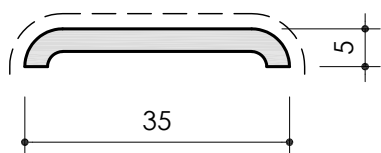
AW646

Profile length (m) 5.0



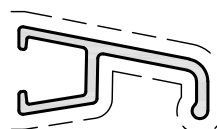
P-00-702

Profile length (m) 6.5



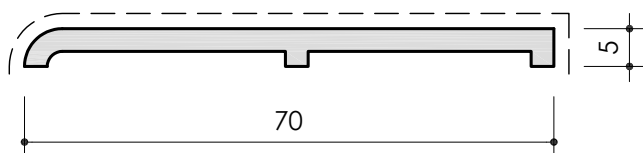
AW647

Profile length (m) 5.0



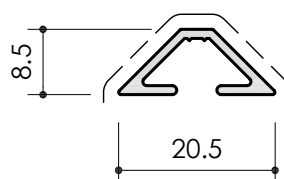
TW118

Profile length (m) 5.0



AW648

Profile length (m) 5.0



TW149

Profile length (m) 5.0

Primary surface — — — — —

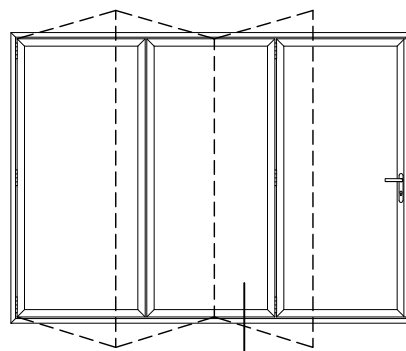
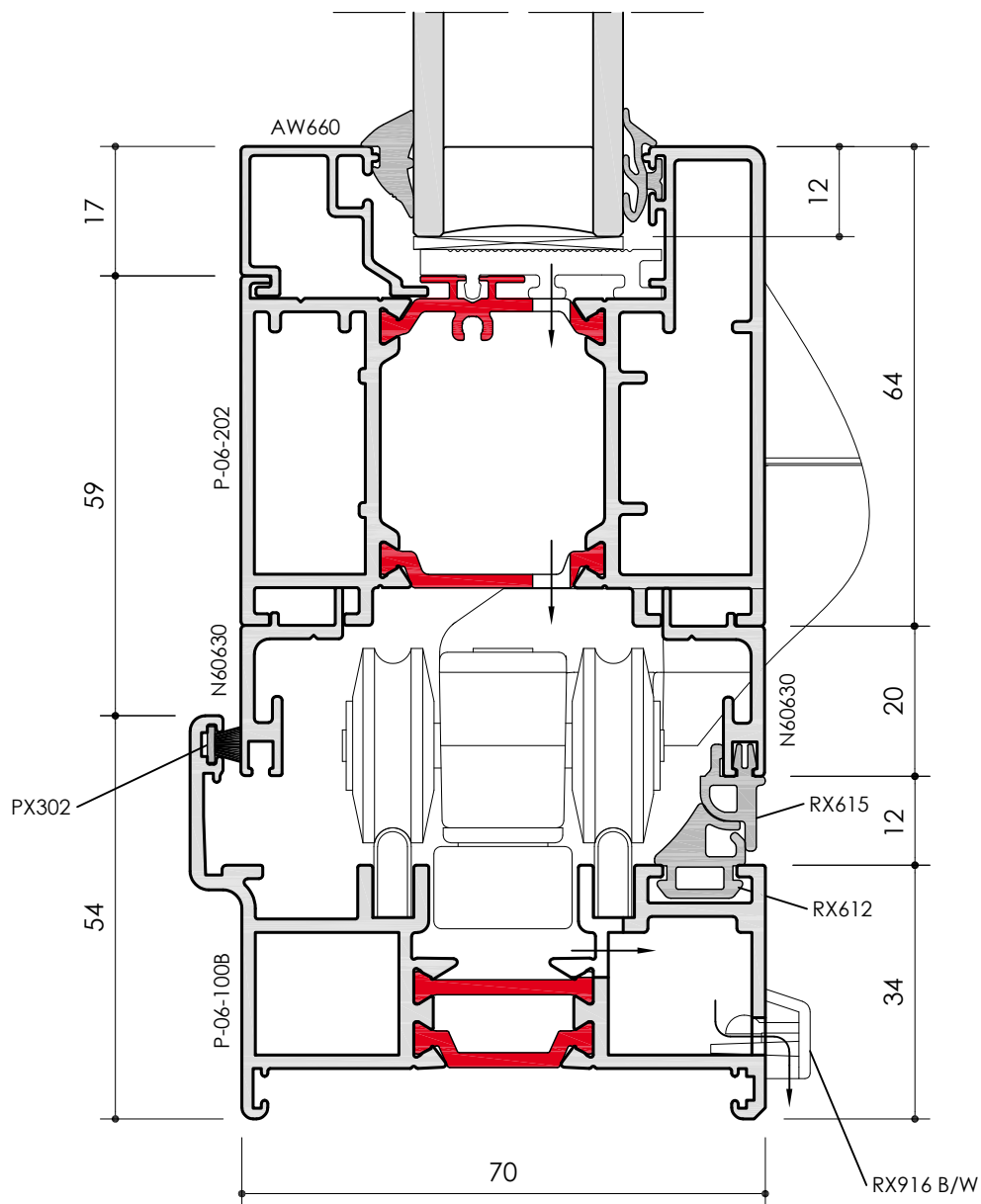
UNCONTROLLED COPY

SECTION 6 TYPICAL DETAIL

UNCONTROLLED COPY

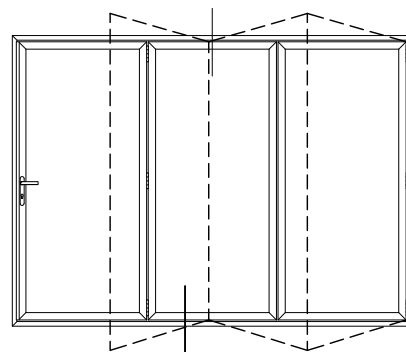
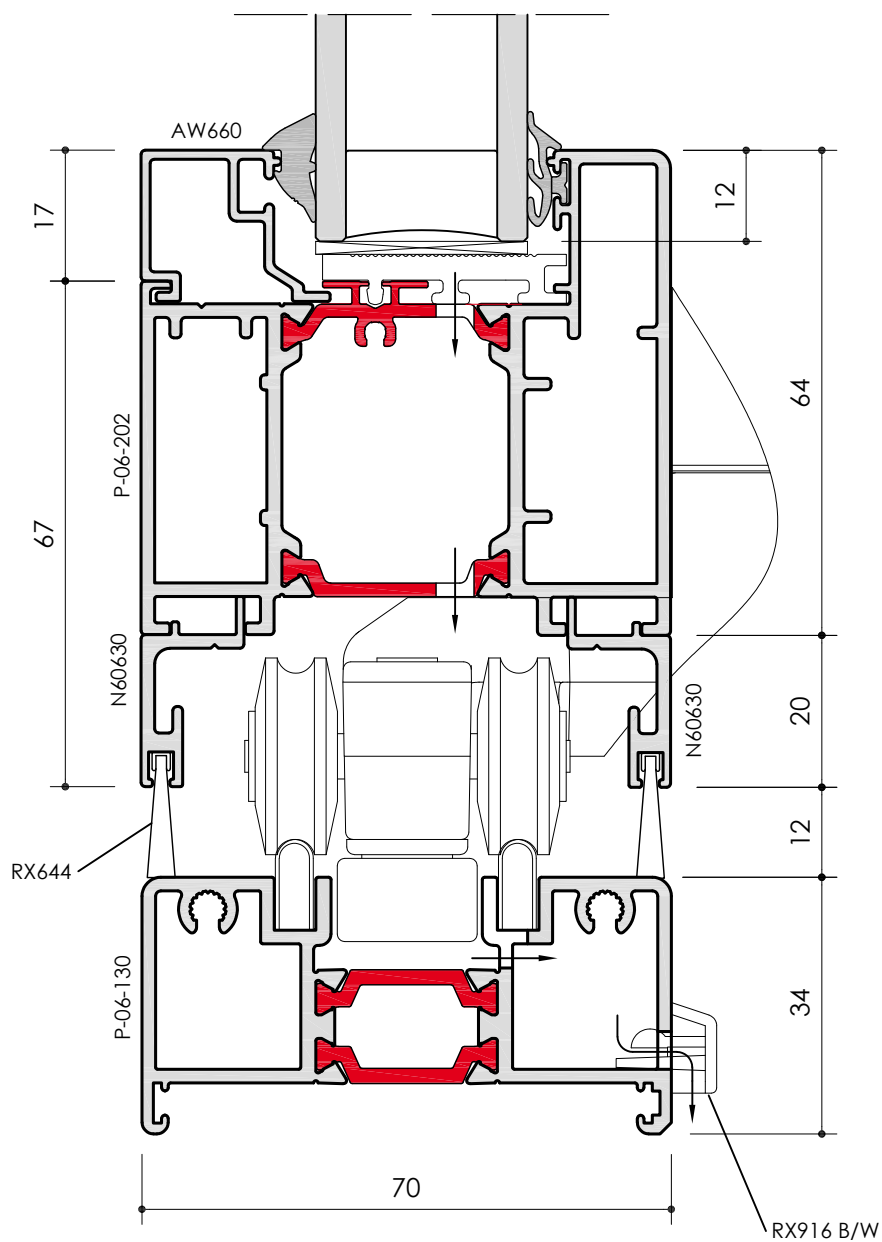
TYPICAL DETAIL

CILL
OPEN OUT



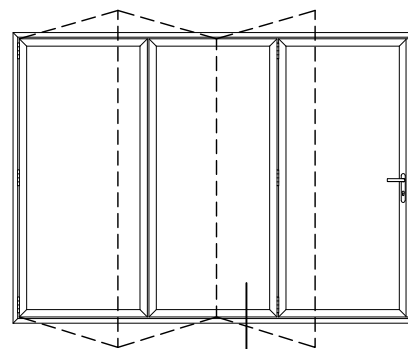
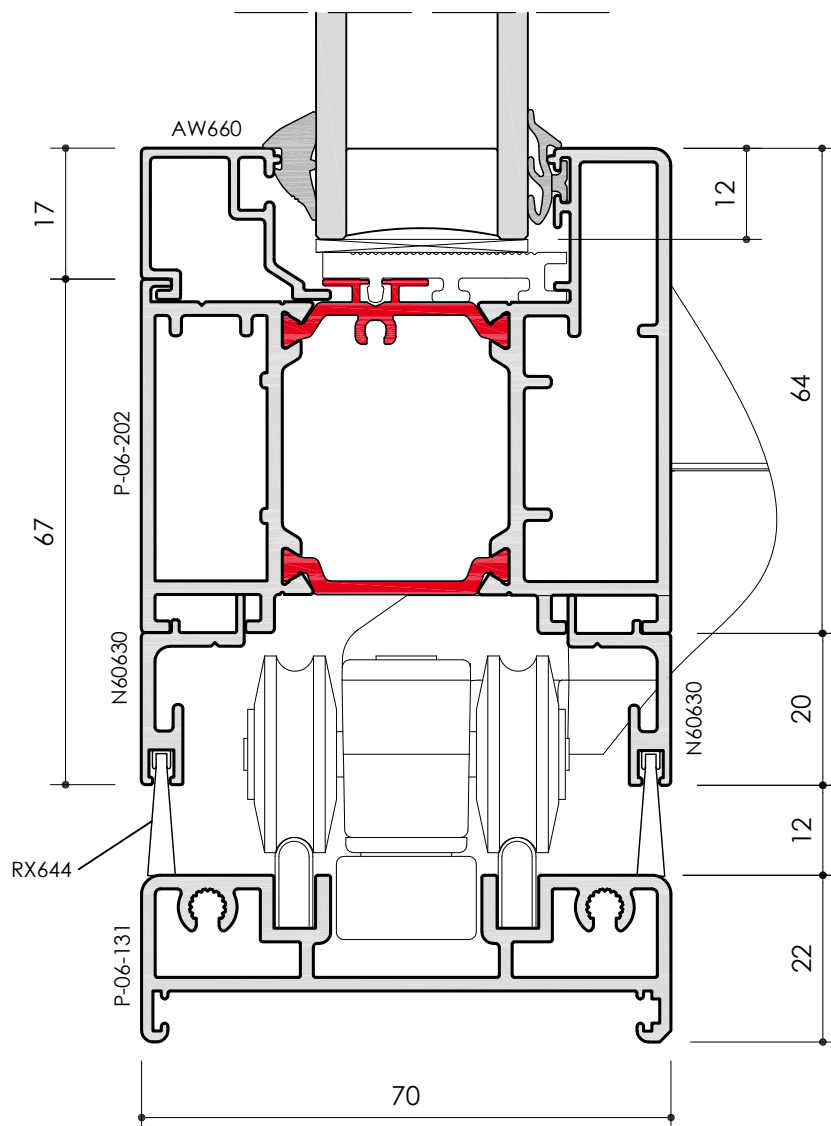
► TYPICAL DETAIL

CILL
OPEN OUT / OPEN IN



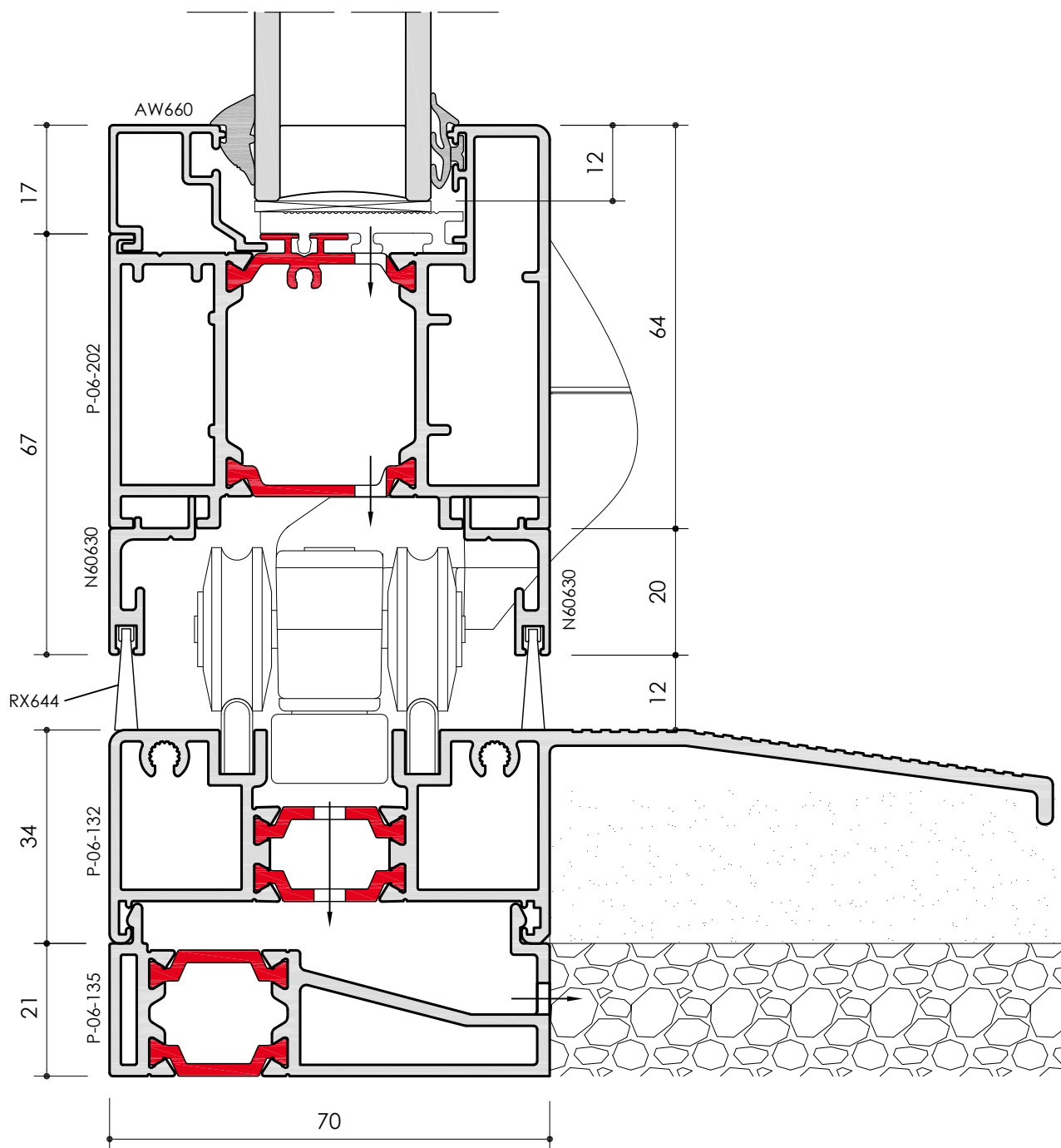
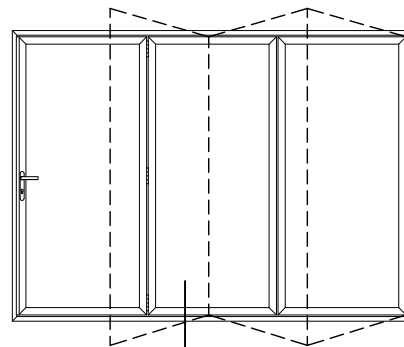
► TYPICAL DETAIL

CILL
OPEN OUT / OPEN IN



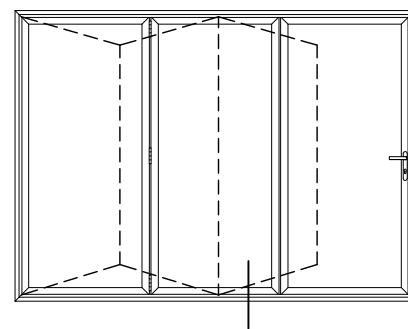
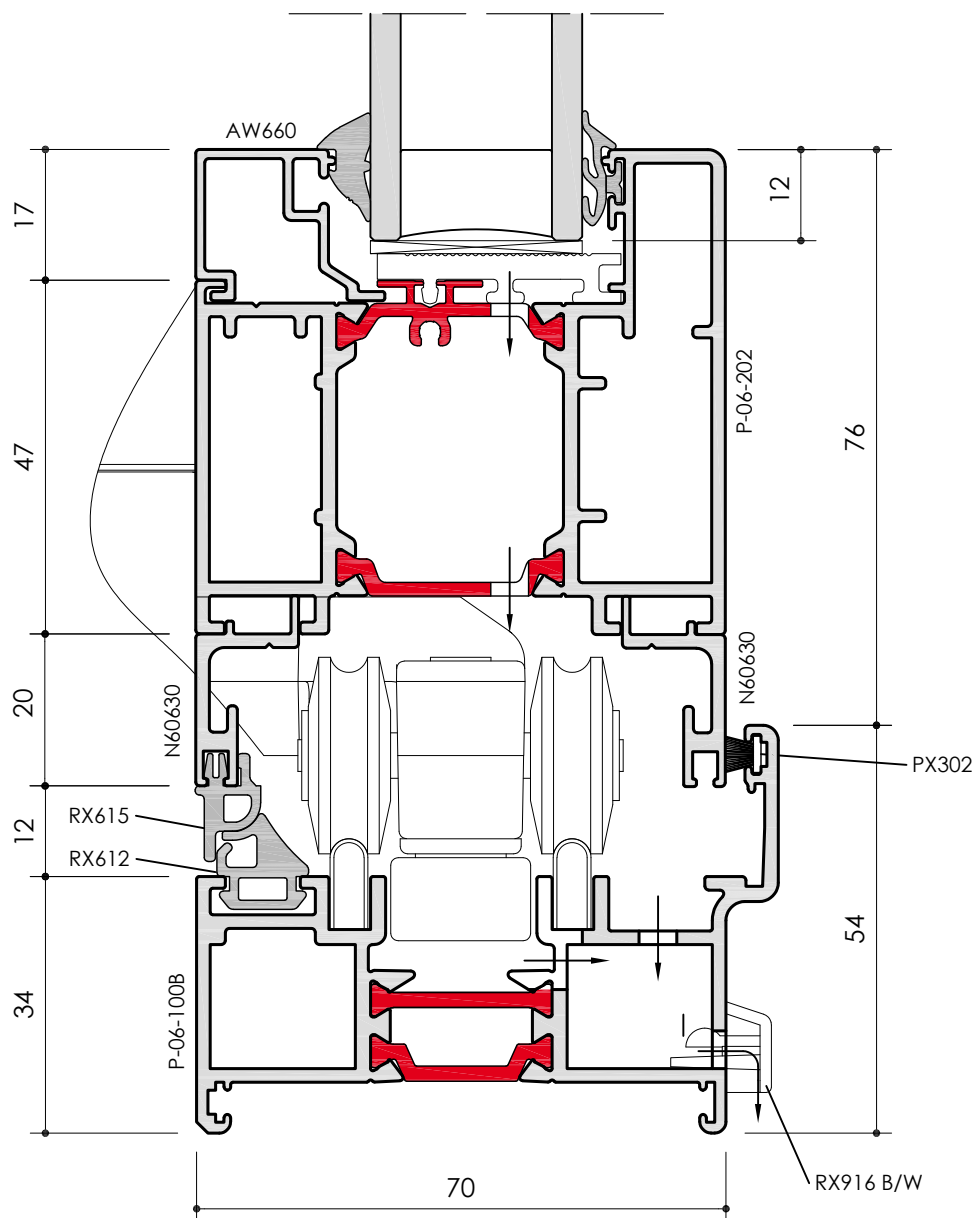
► TYPICAL DETAIL

CILL
OPEN OUT / OPEN IN



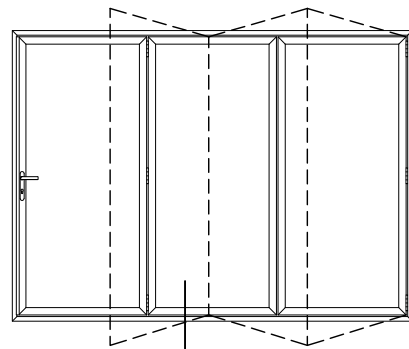
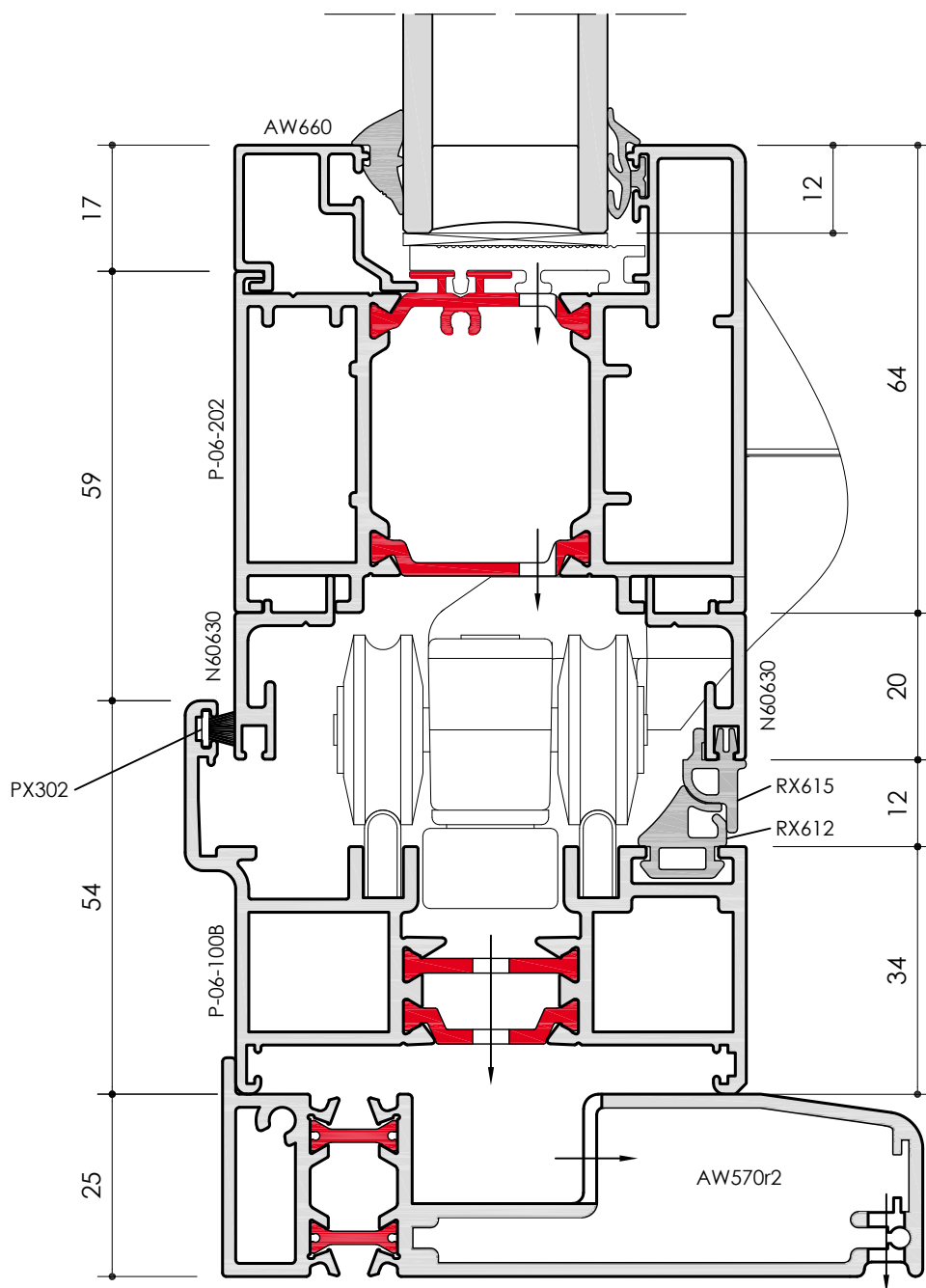
► TYPICAL DETAIL

CILL
OPEN IN



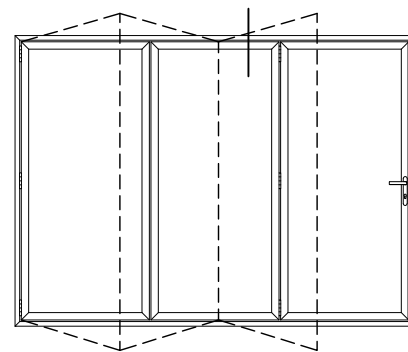
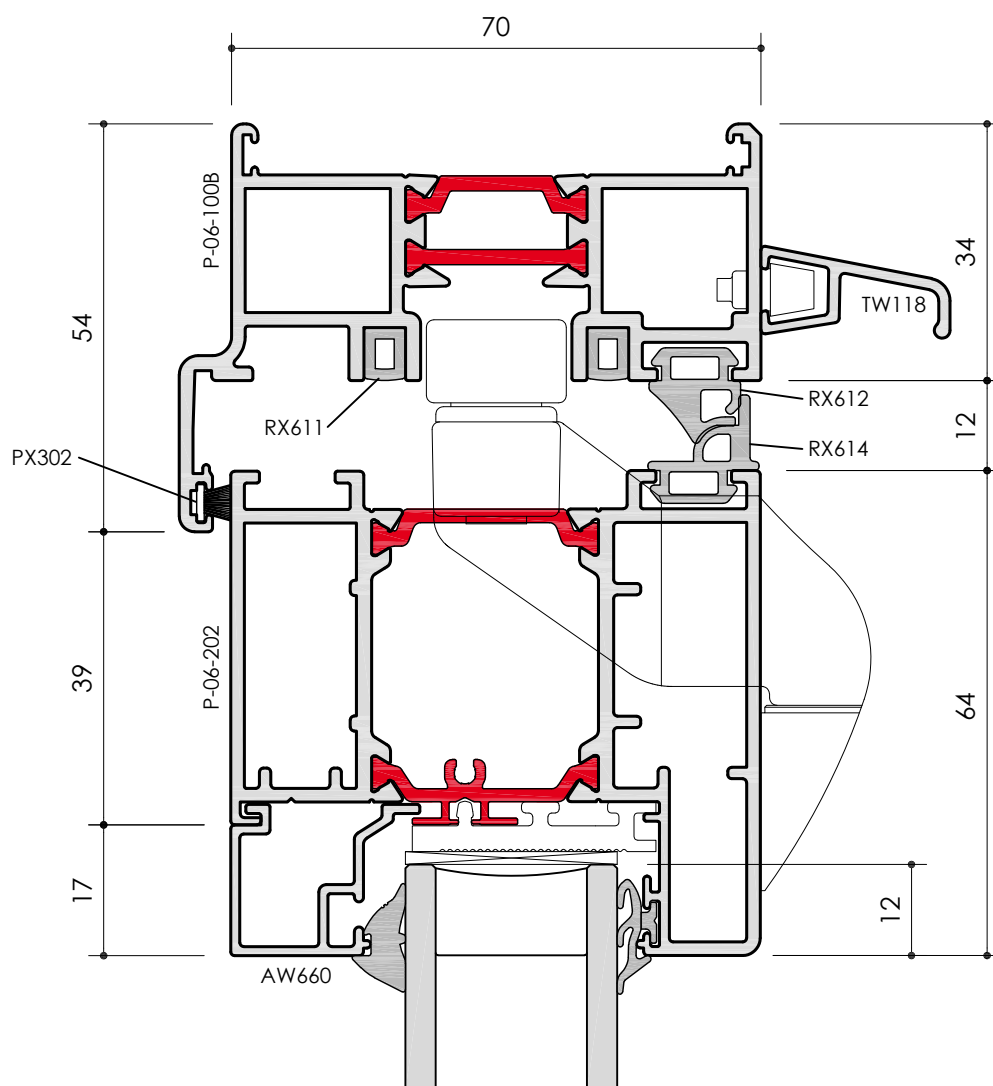
► TYPICAL DETAIL

CILL
OPEN OUT



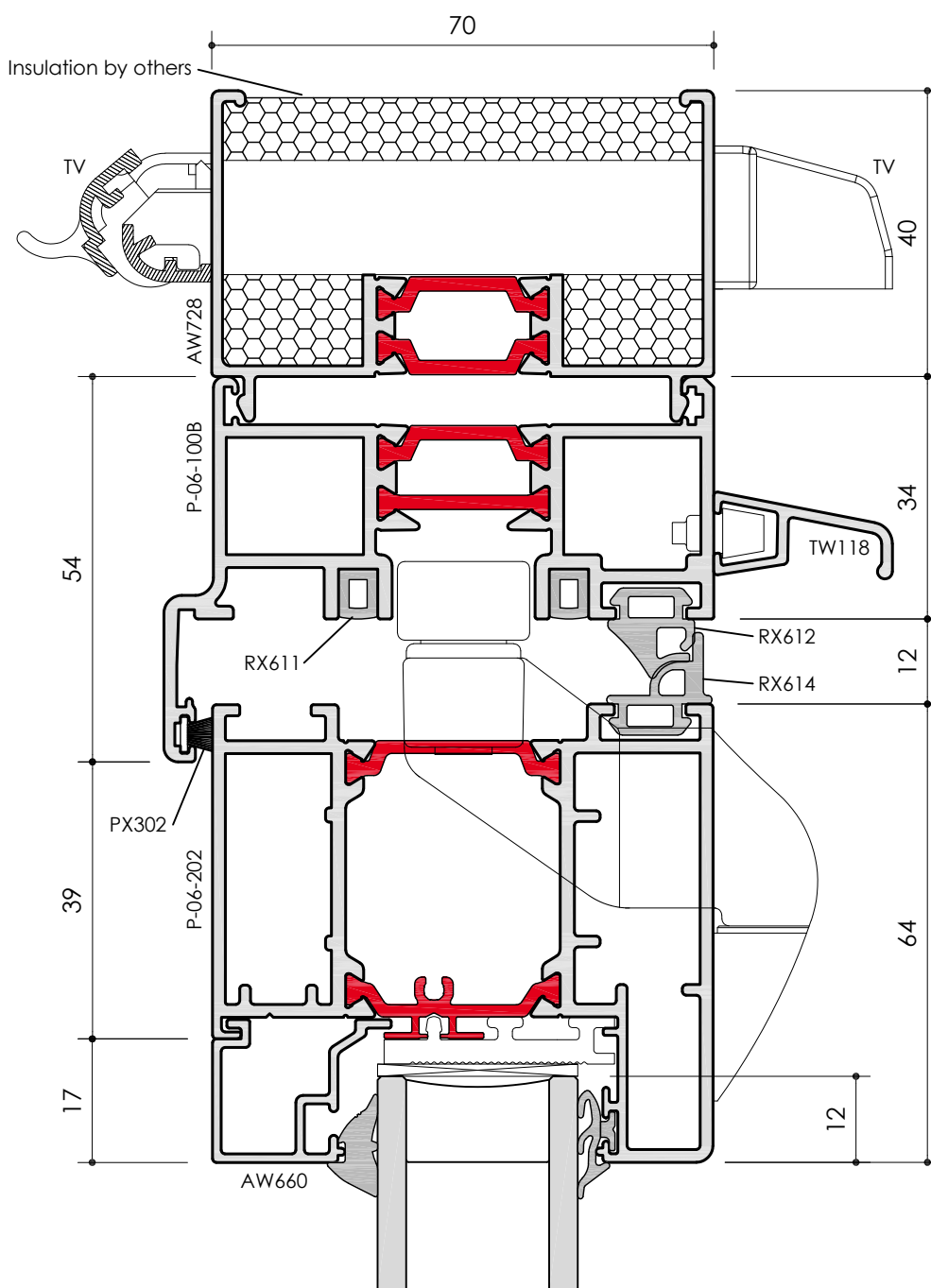
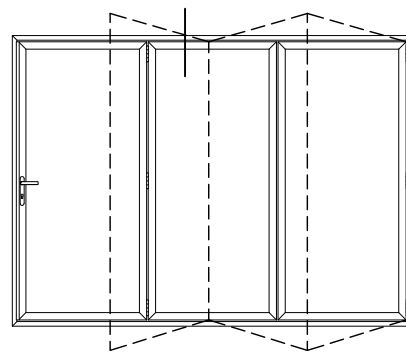
► TYPICAL DETAIL

HEAD
OPEN OUT



► TYPICAL DETAIL

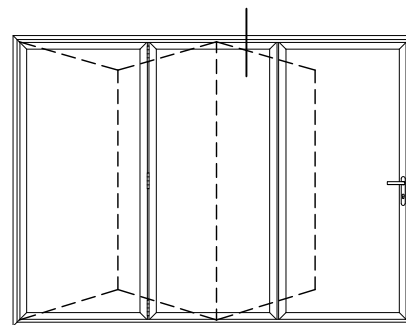
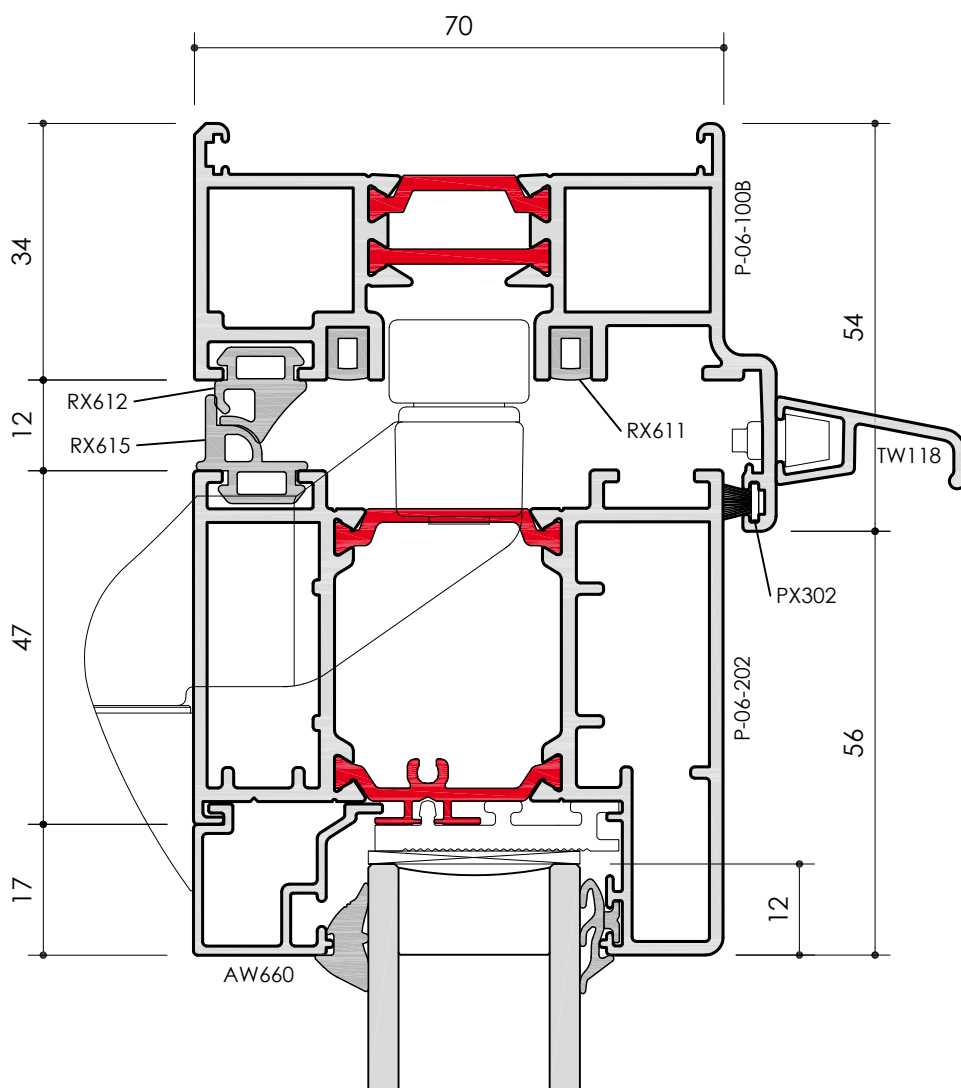
HEAD - TRICKLE VENTILATION OPEN OUT



TV = Trickle vent with sleeve (typical), not supply of AluK

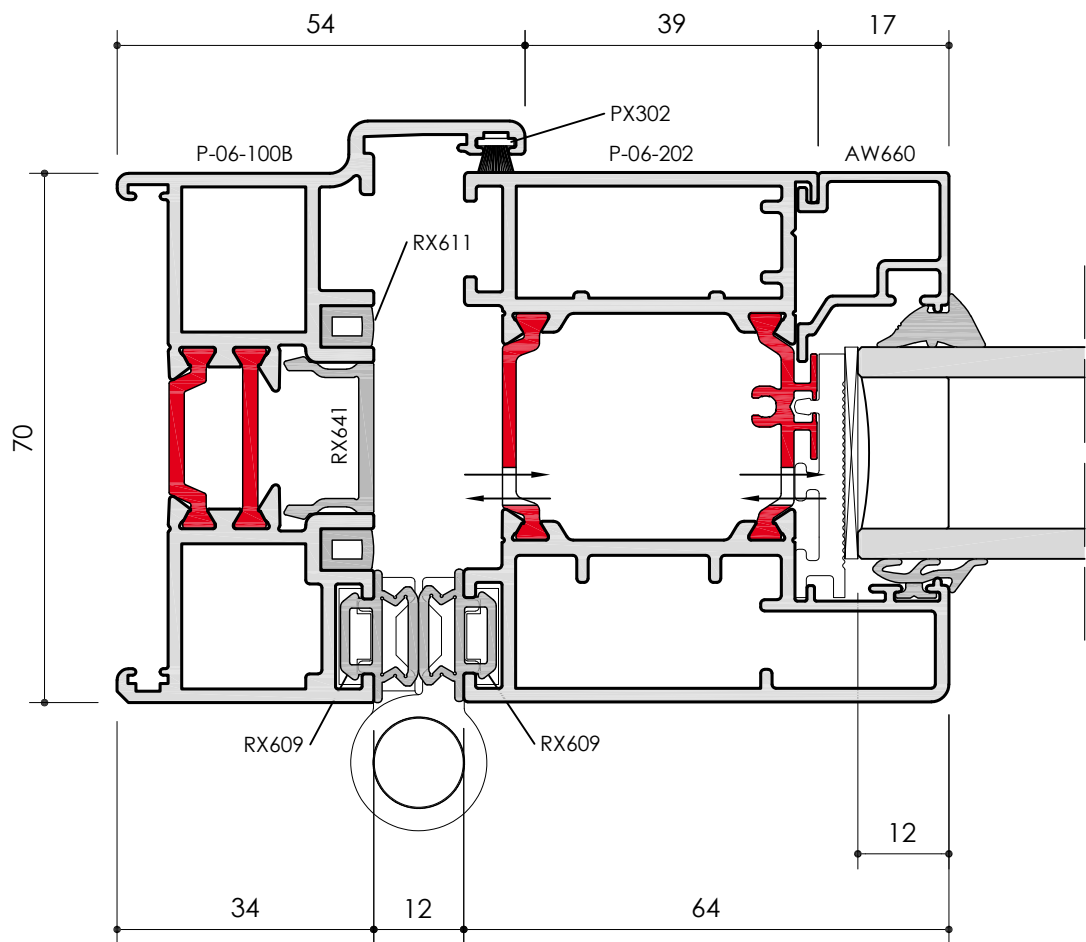
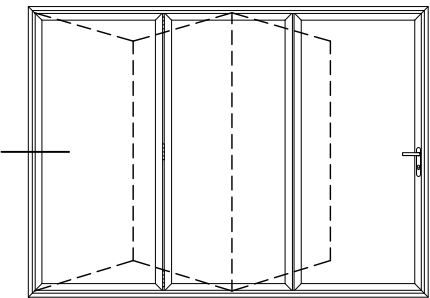
► TYPICAL DETAIL

HEAD
OPEN IN



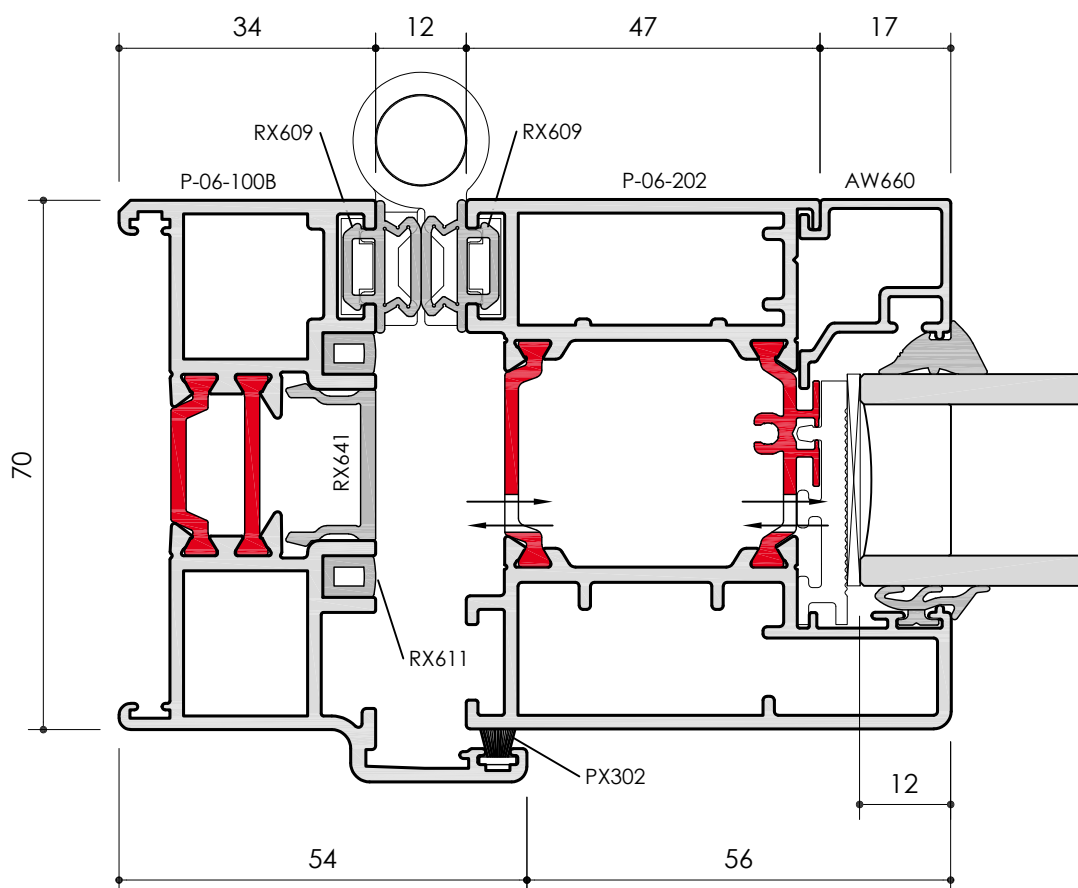
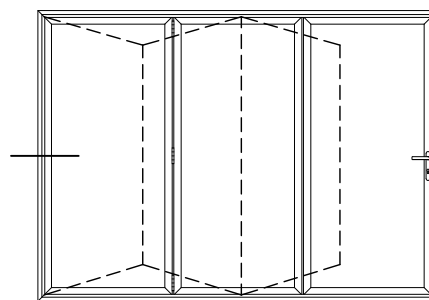
► TYPICAL DETAIL

JAMB HANGING STILE
OPEN IN



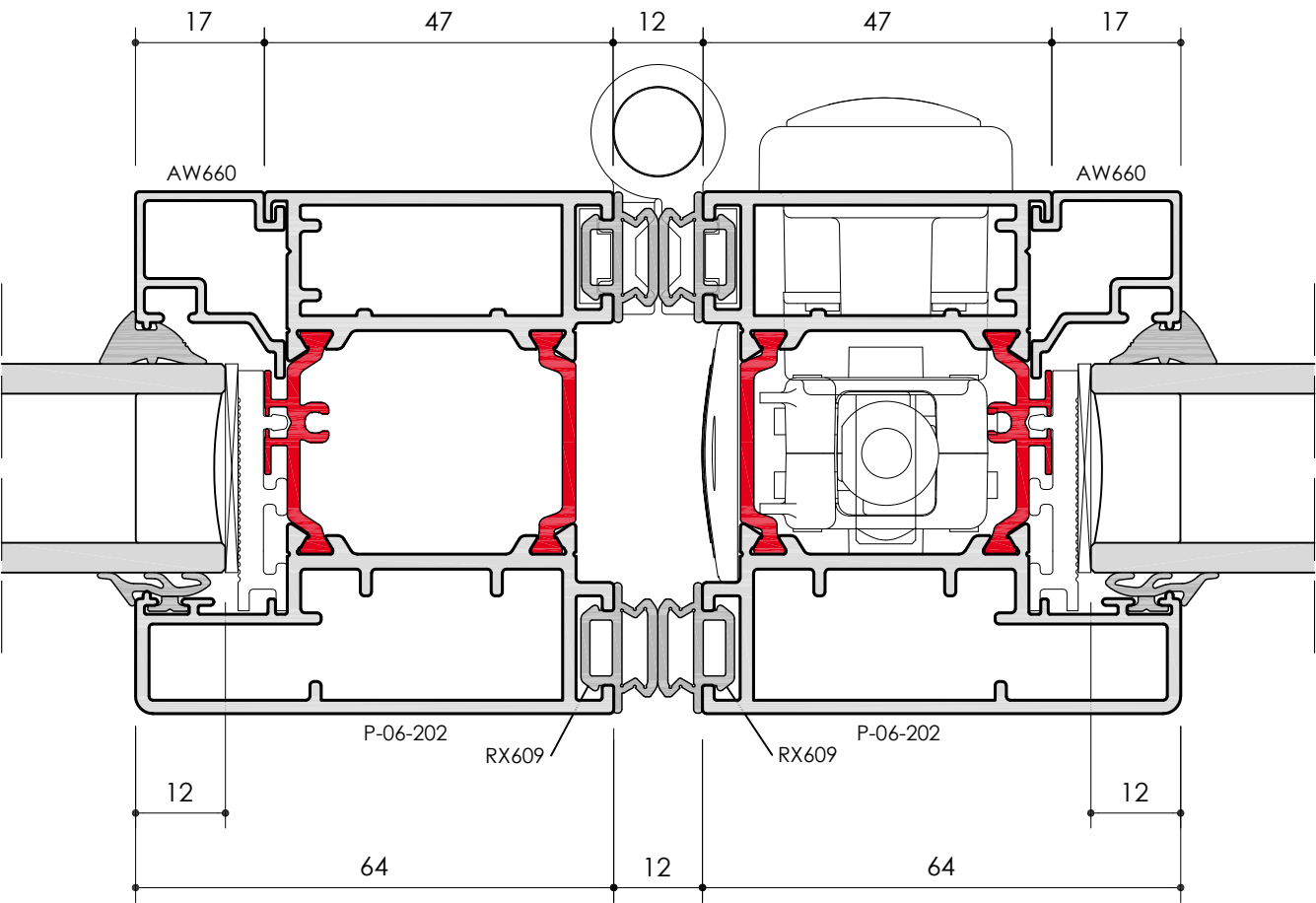
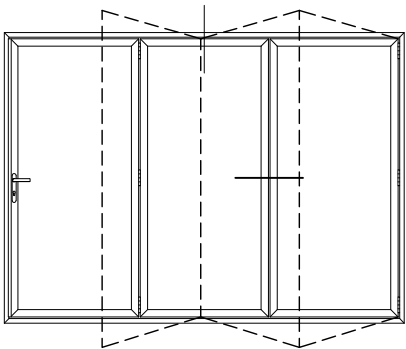
➤ TYPICAL DETAIL

JAMB HANGING STILE
OPEN IN



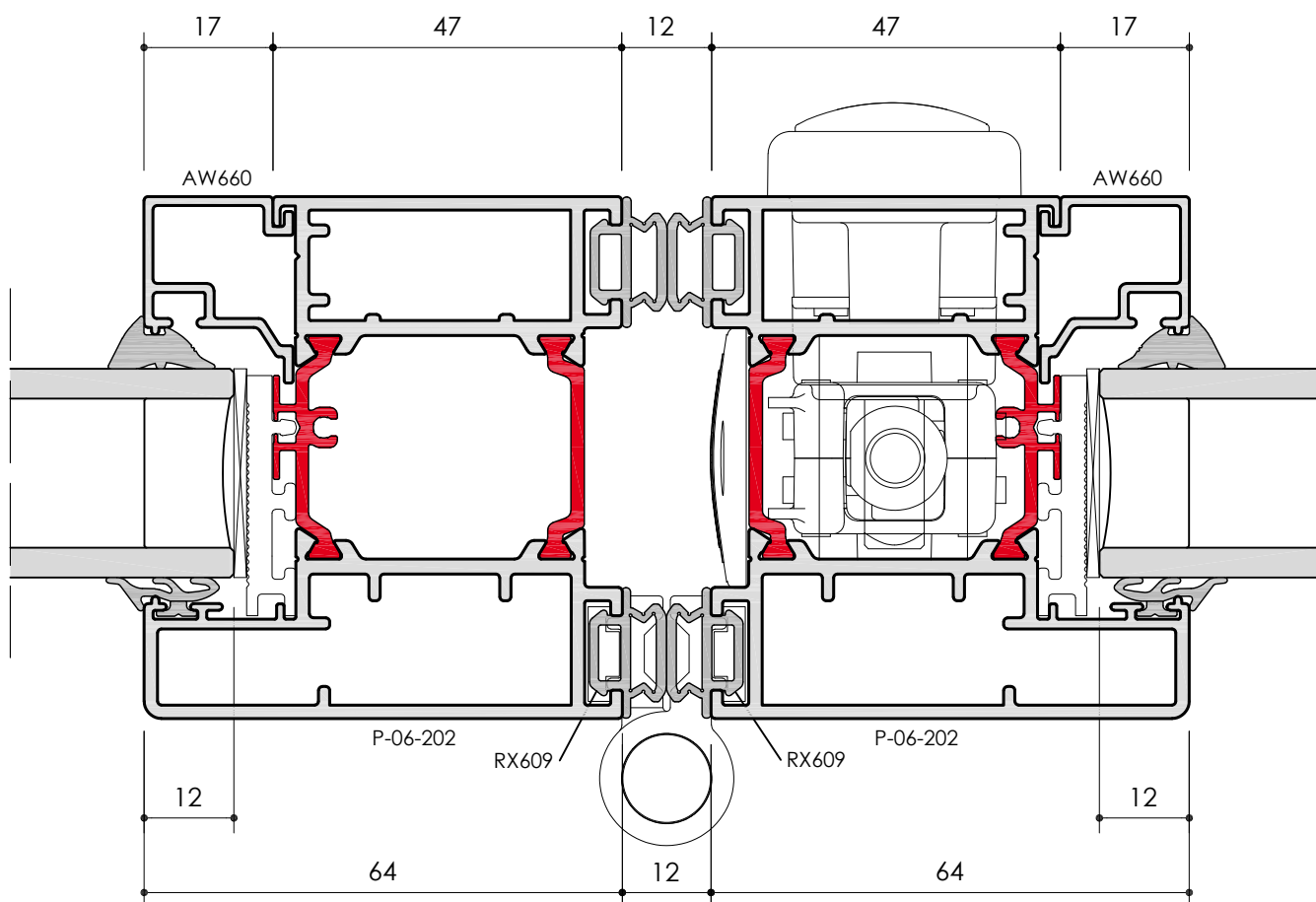
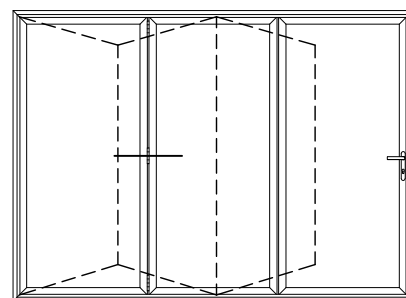
➤ TYPICAL DETAIL

INTERLOCK STILES - SHOOTBOLT
OPEN OUT



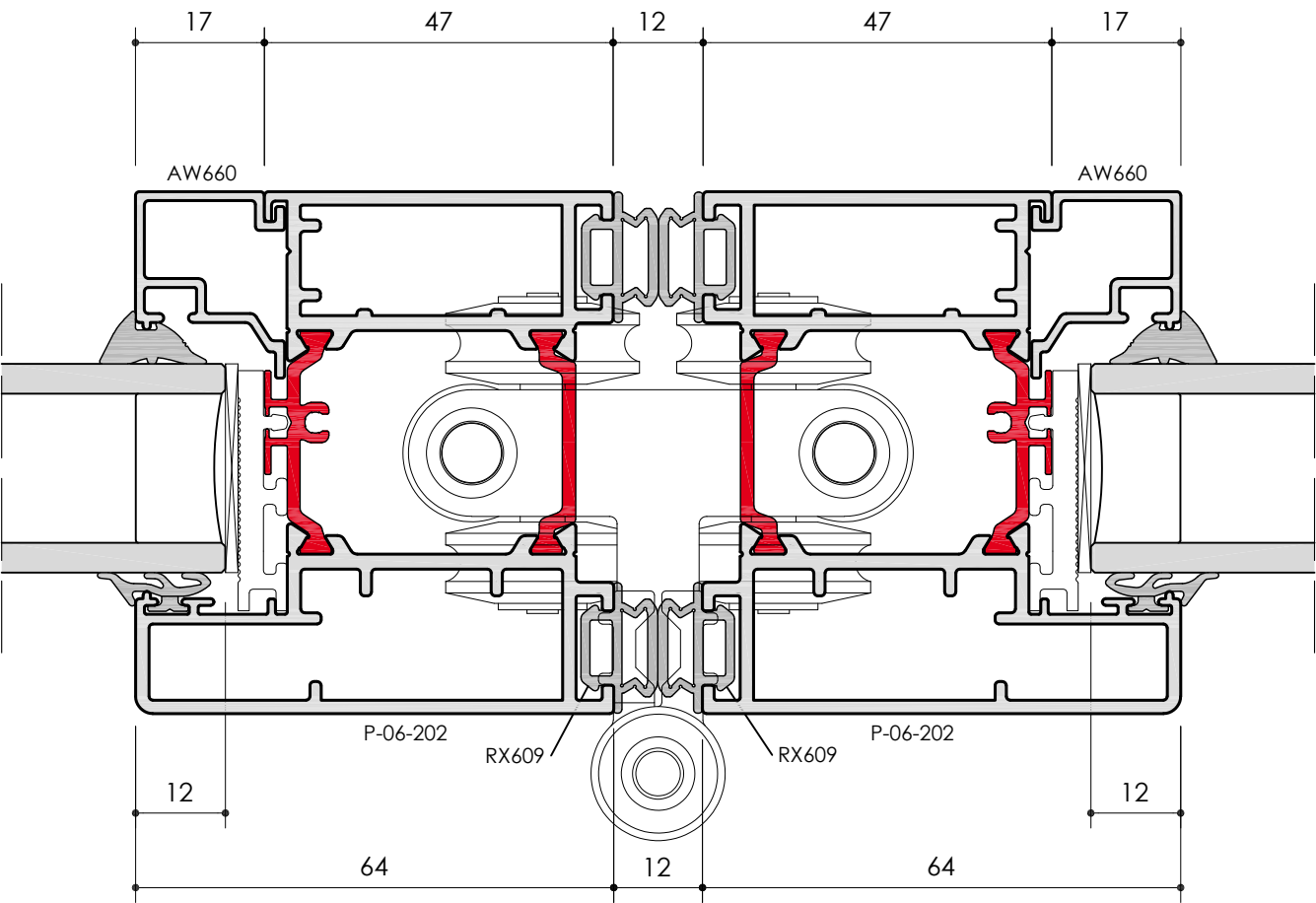
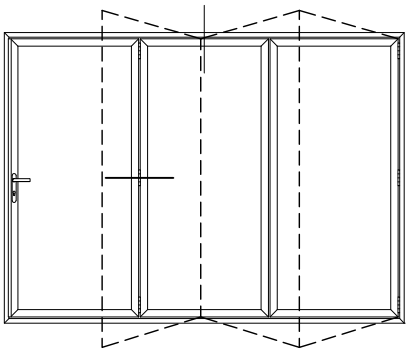
➤ TYPICAL DETAIL

INTERLOCK STILES - SHOOTBOLT
OPEN IN



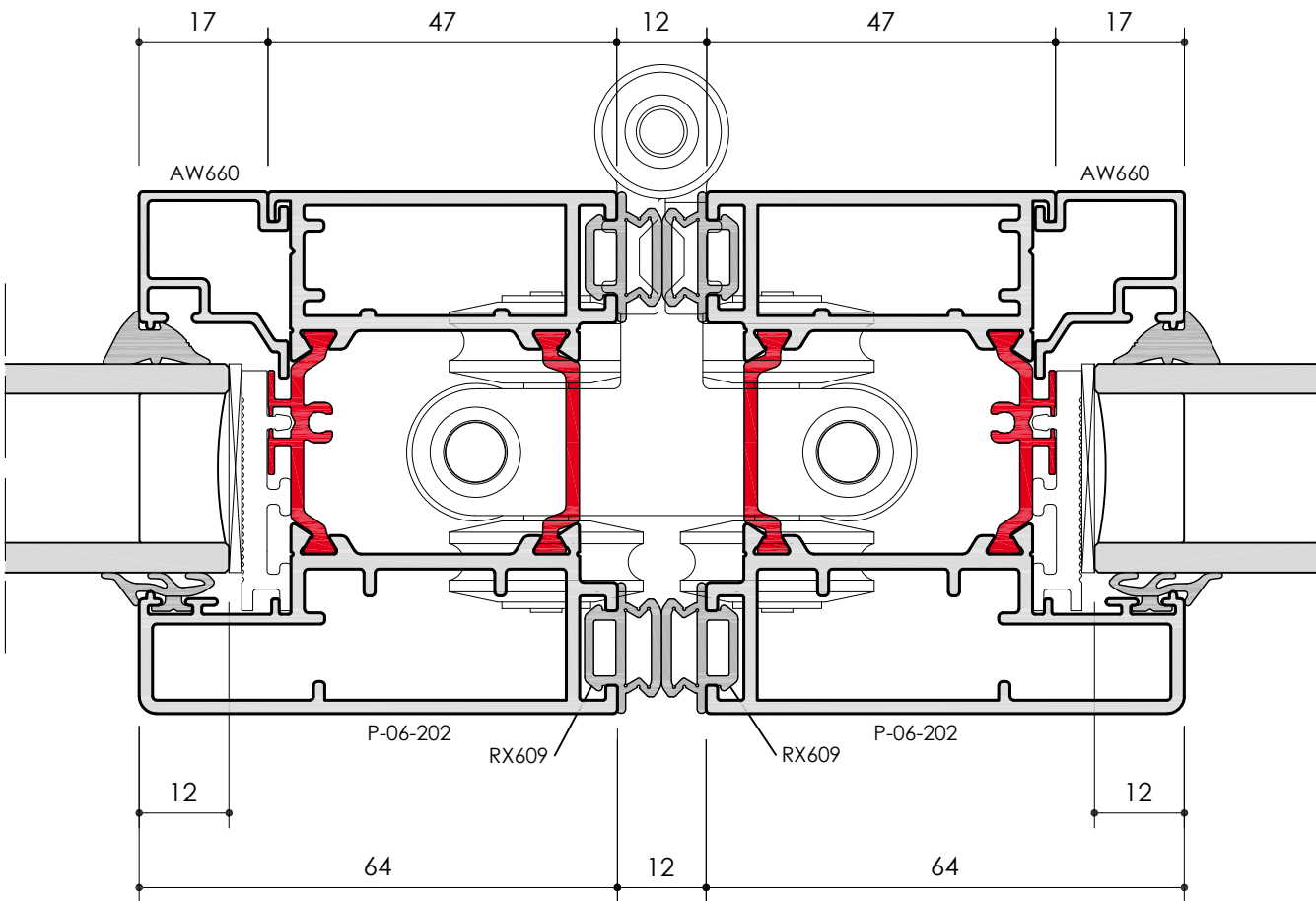
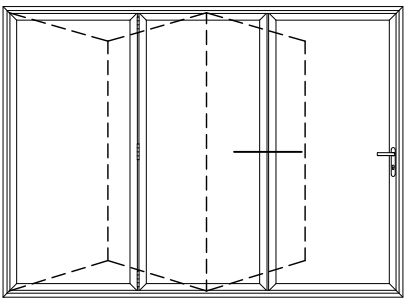
► TYPICAL DETAIL

INTERLOCK STILES - ROLLER
OPEN OUT



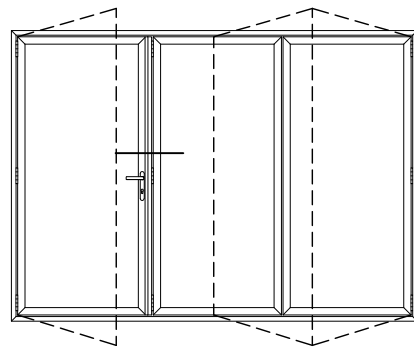
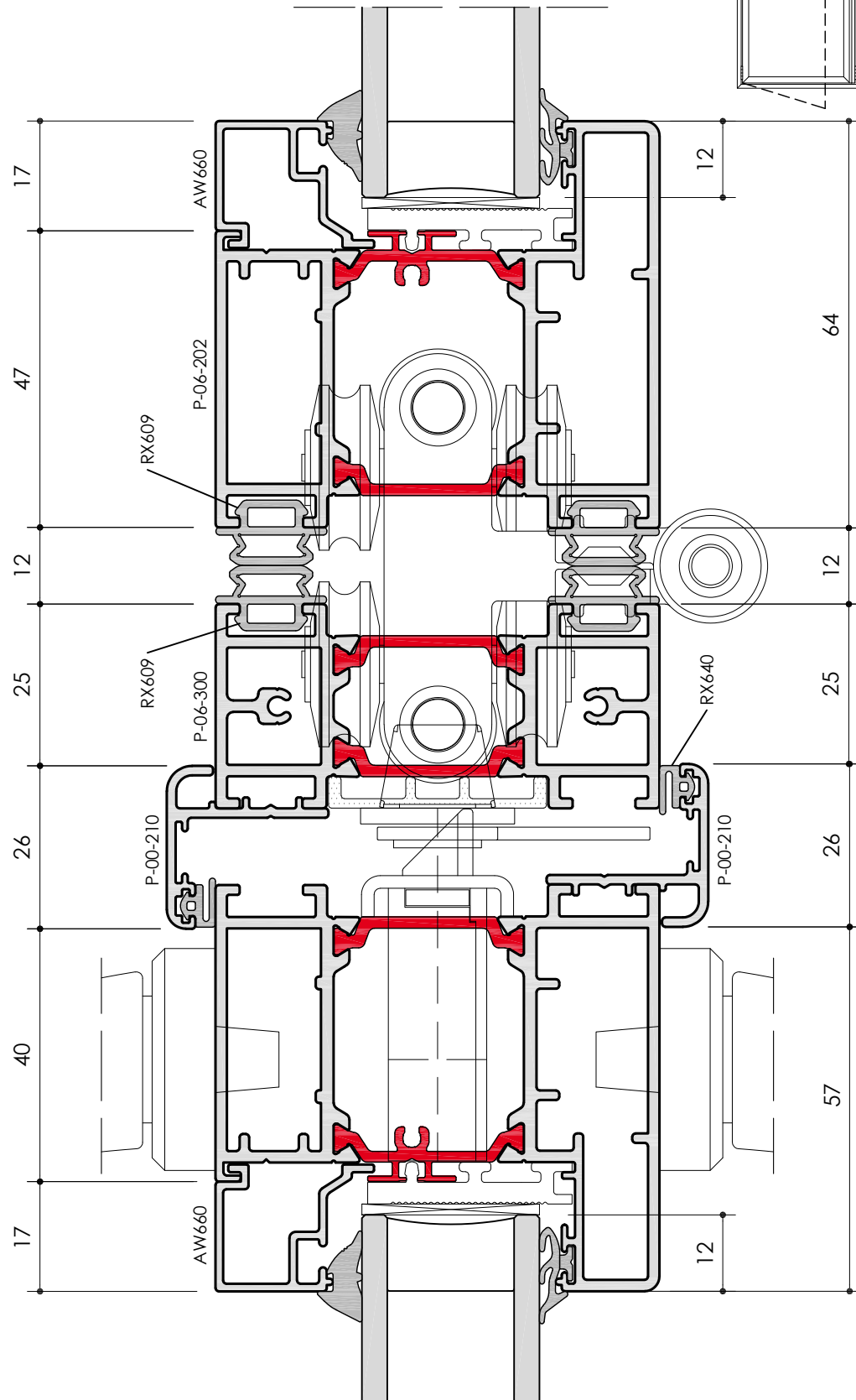
➤ TYPICAL DETAIL

INTERLOCK STILES - ROLLER
OPEN IN



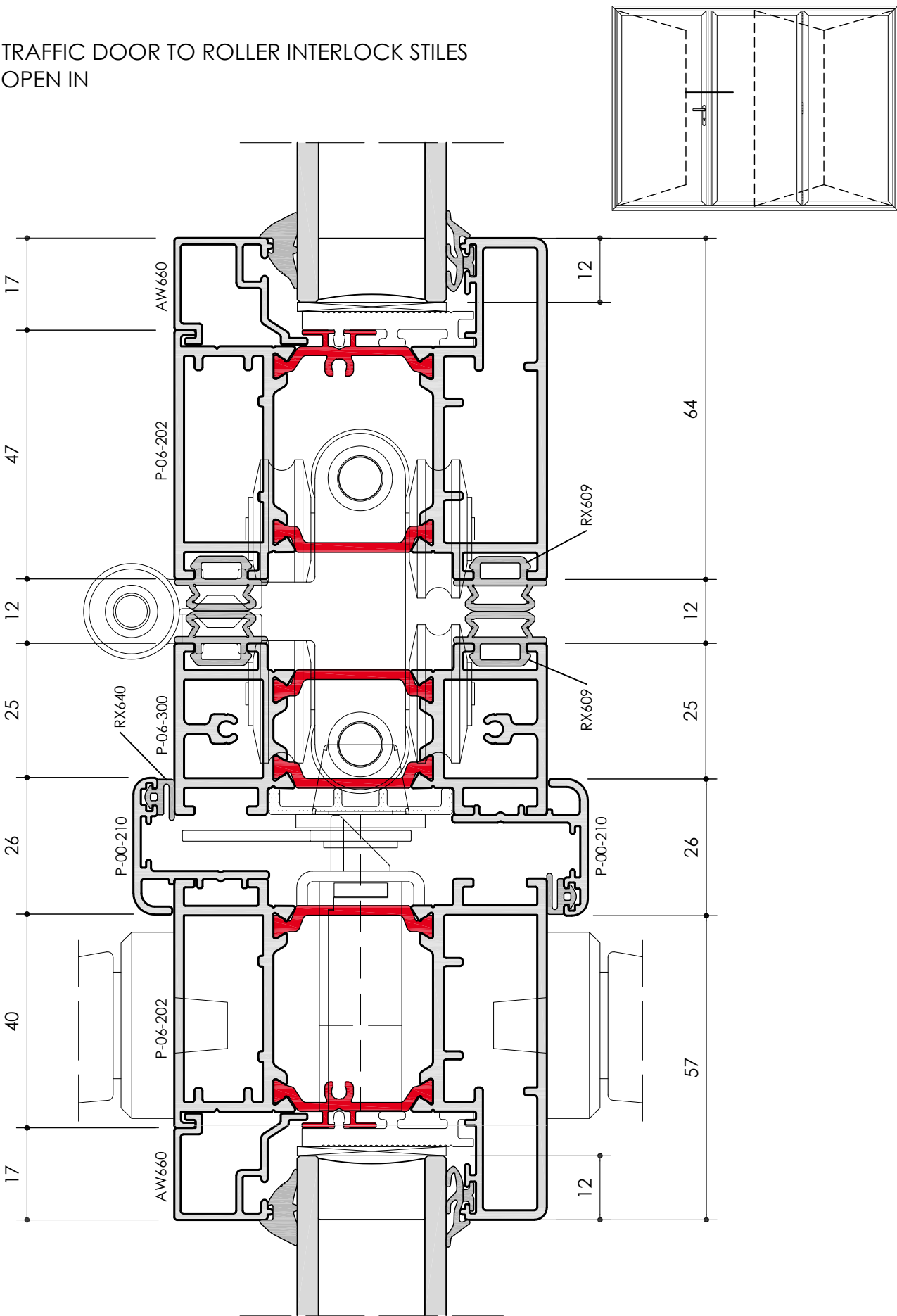
► TYPICAL DETAIL

TRAFFIC DOOR TO ROLLER INTERLOCK STILES
OPEN OUT



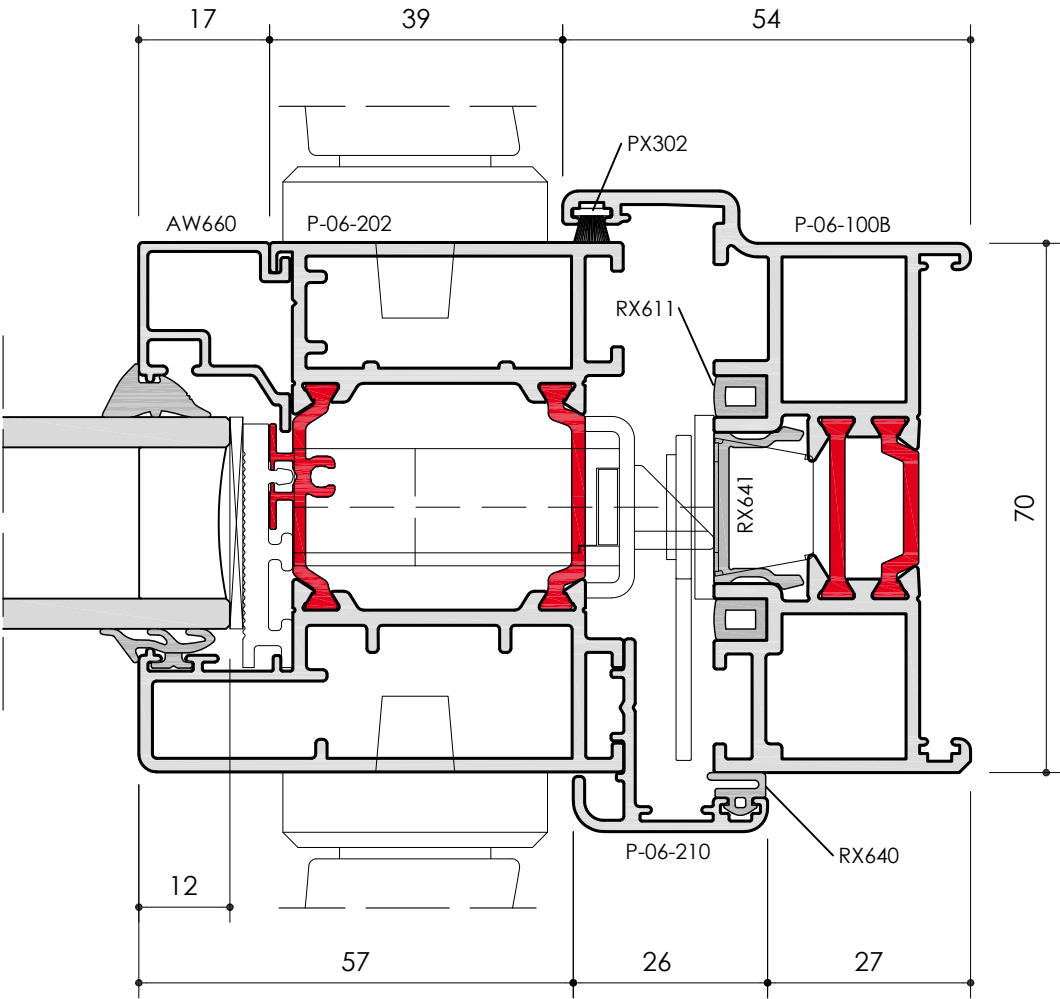
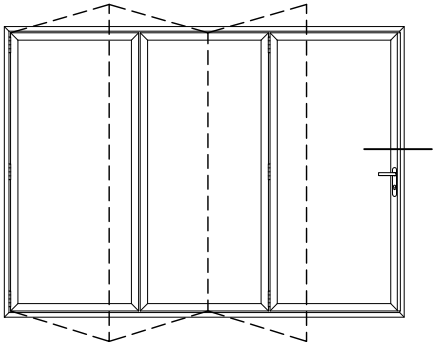
➤ TYPICAL DETAIL

TRAFFIC DOOR TO ROLLER INTERLOCK STILES
OPEN IN



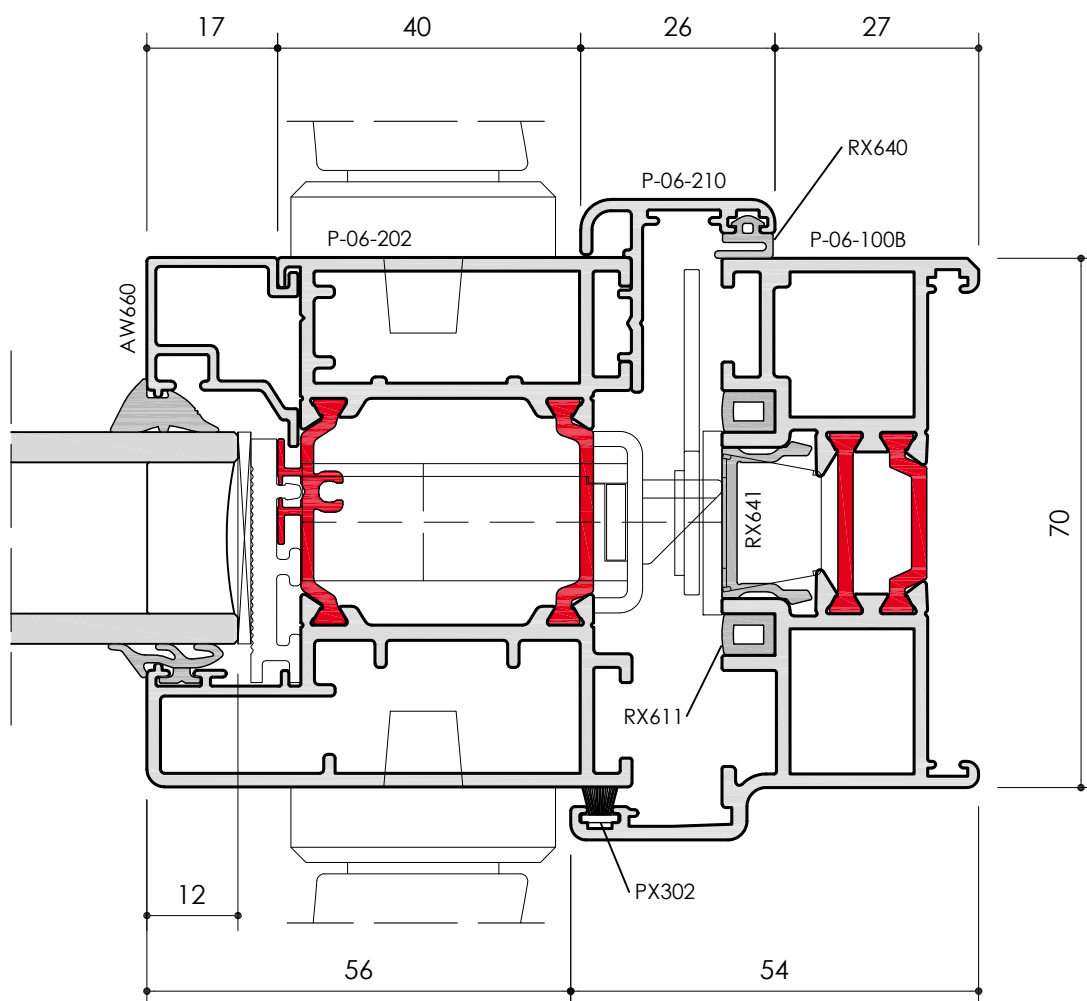
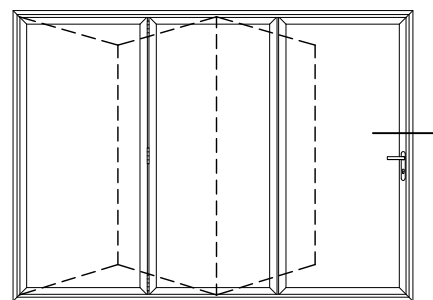
► TYPICAL DETAIL

TRAFFIC DOOR TO JAMB
OPEN OUT



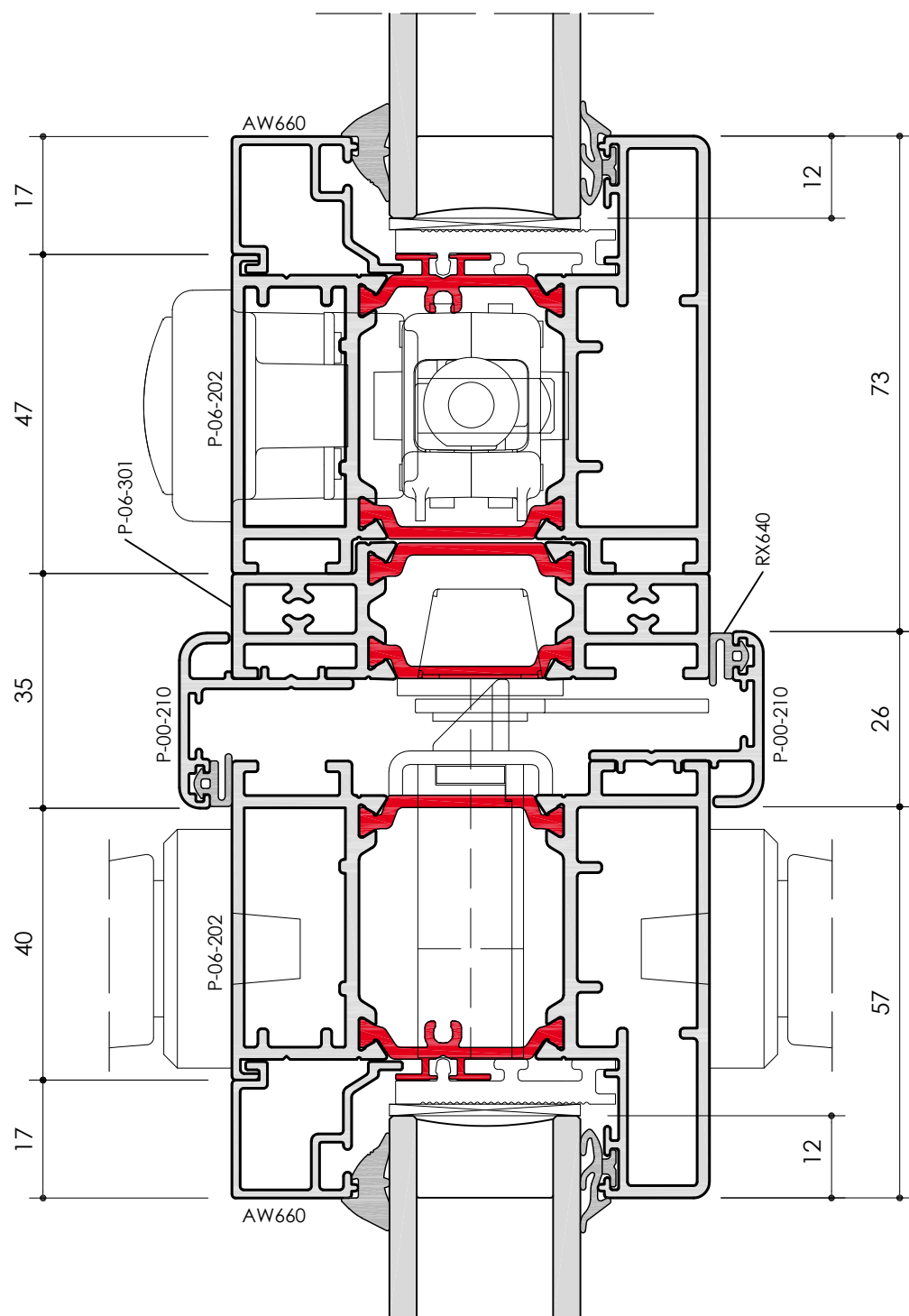
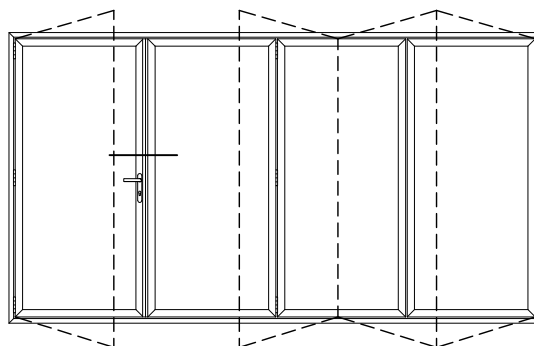
► TYPICAL DETAIL

TRAFFIC DOOR TO JAMB
OPEN IN



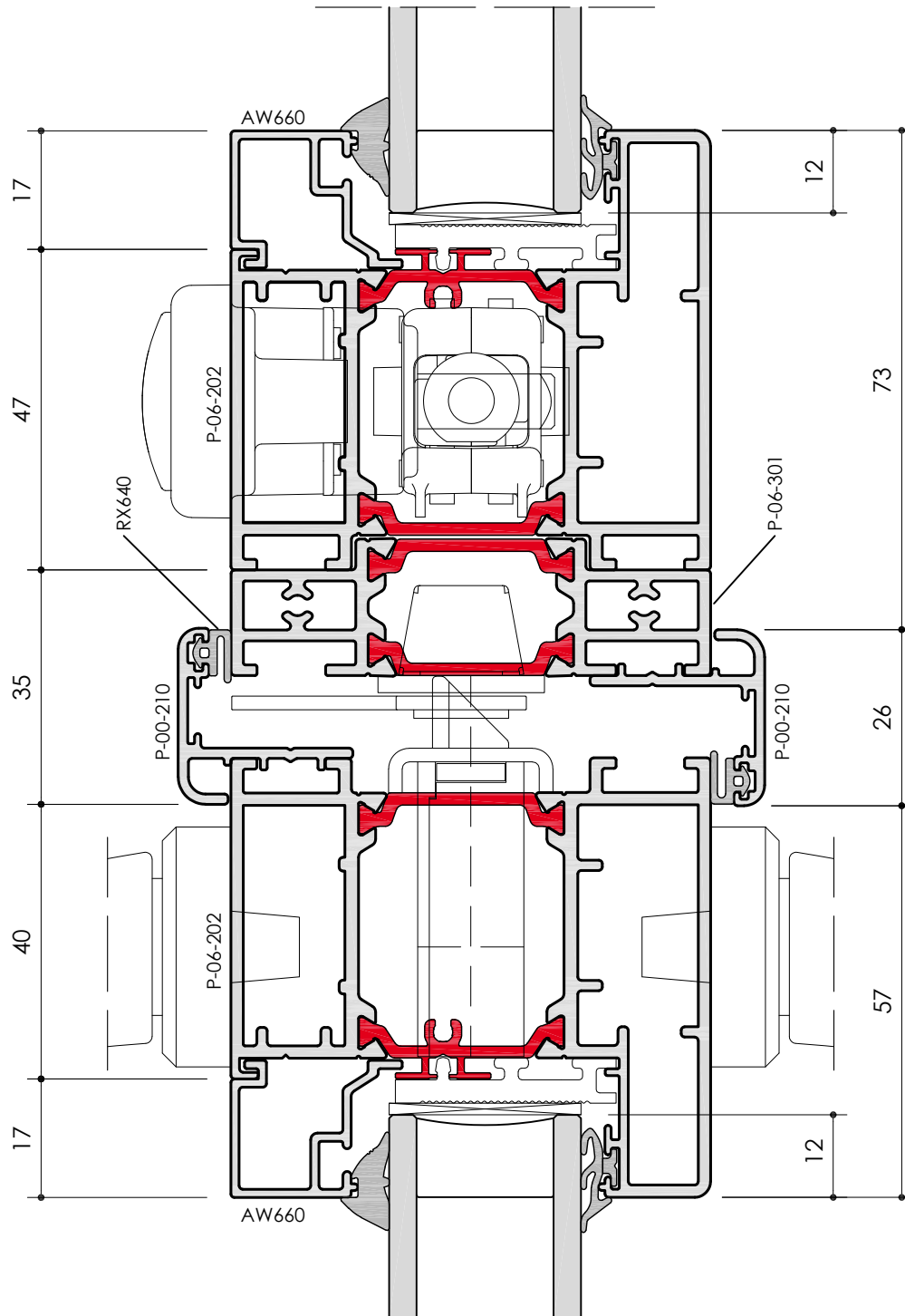
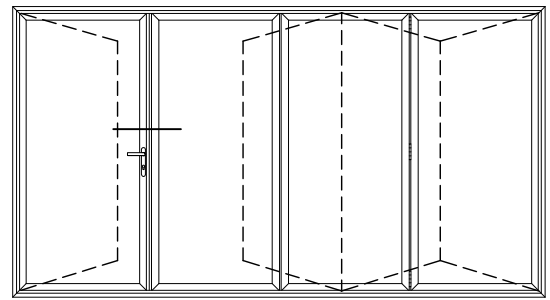
► TYPICAL DETAIL

TRAFFIC TO SLAVE DOOR (SHOOT BOLT)
OPEN OUT

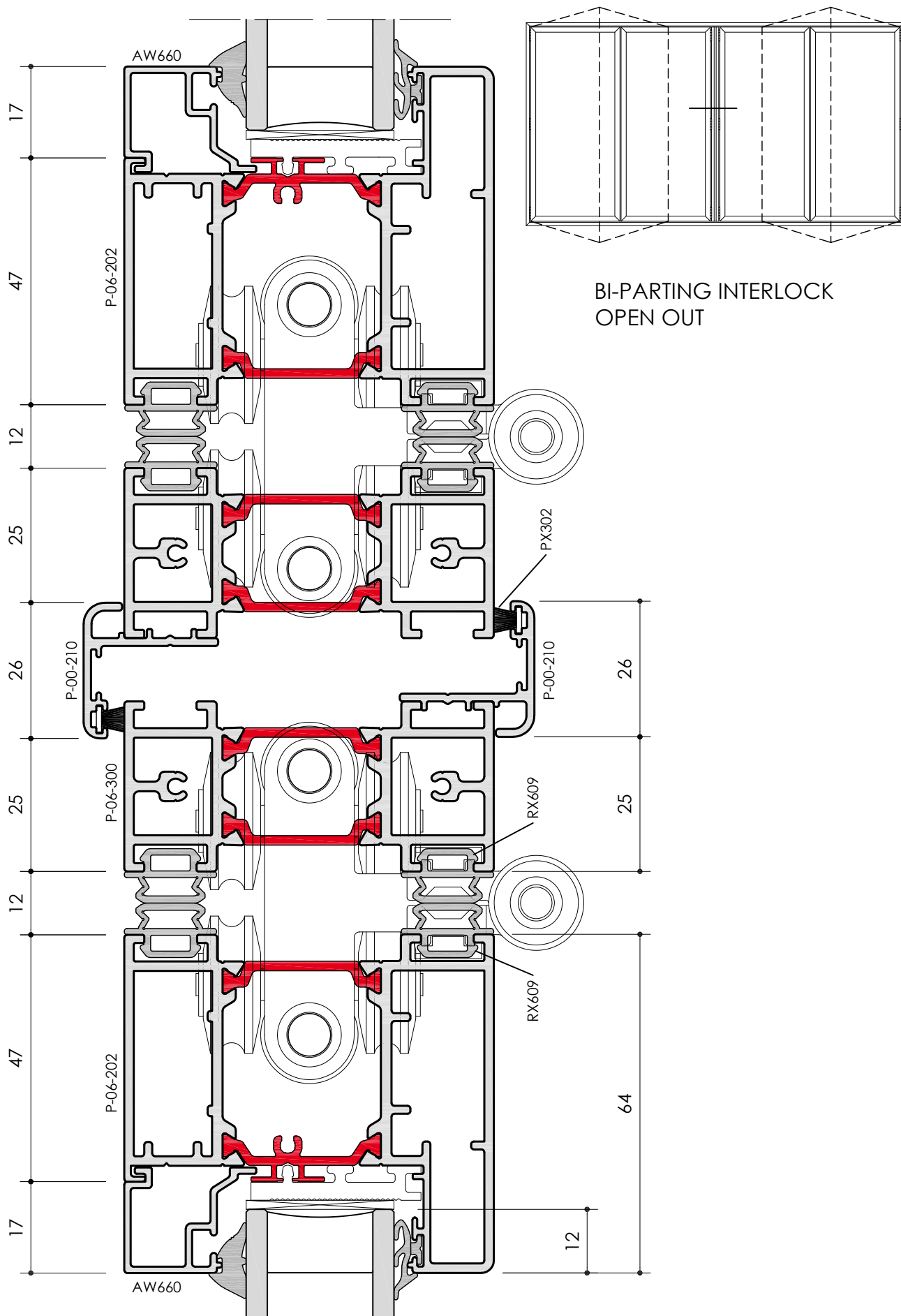


► TYPICAL DETAIL

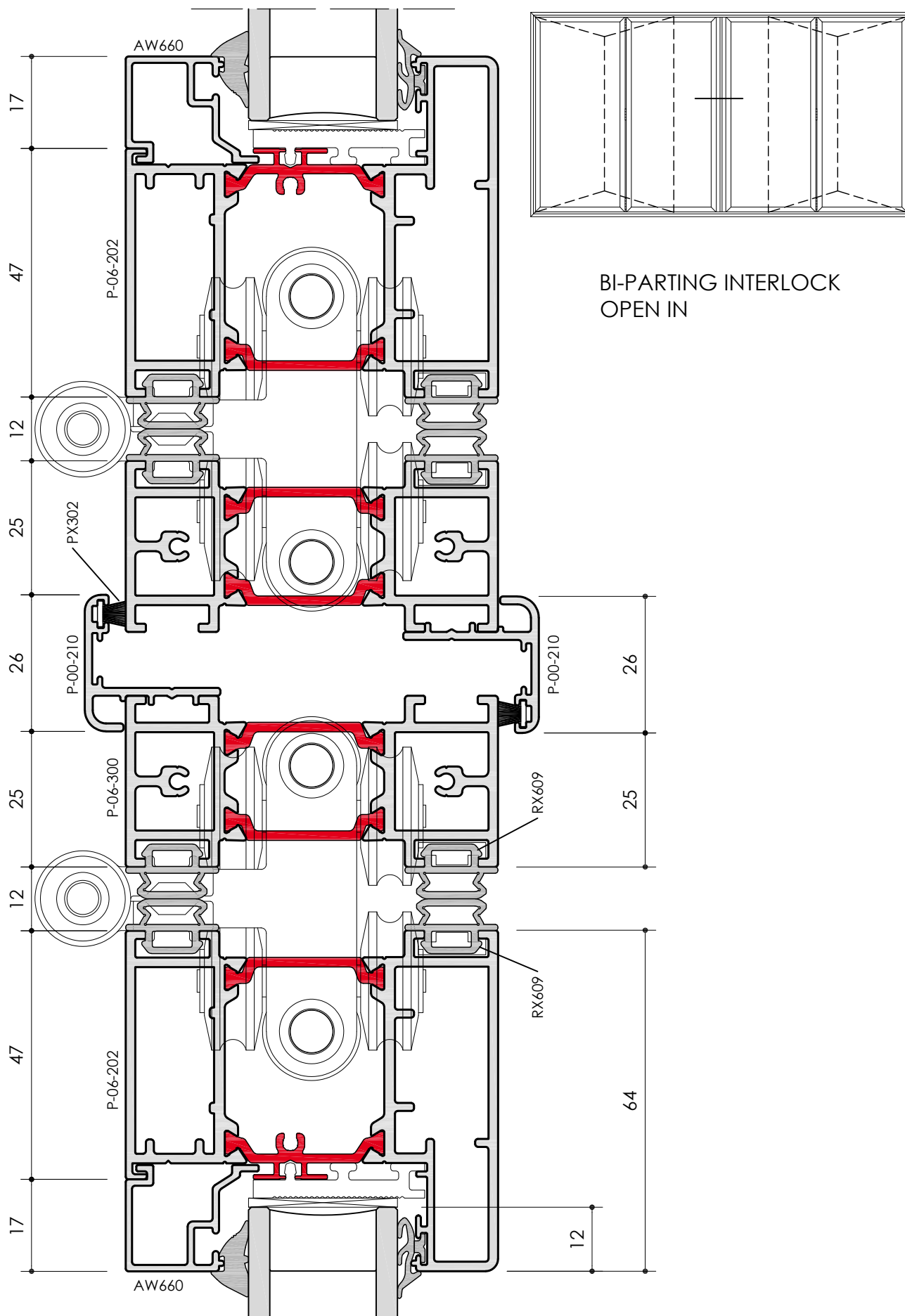
TRAFFIC TO SLAVE DOOR (SHOOT BOLT)
OPEN IN



► TYPICAL DETAIL

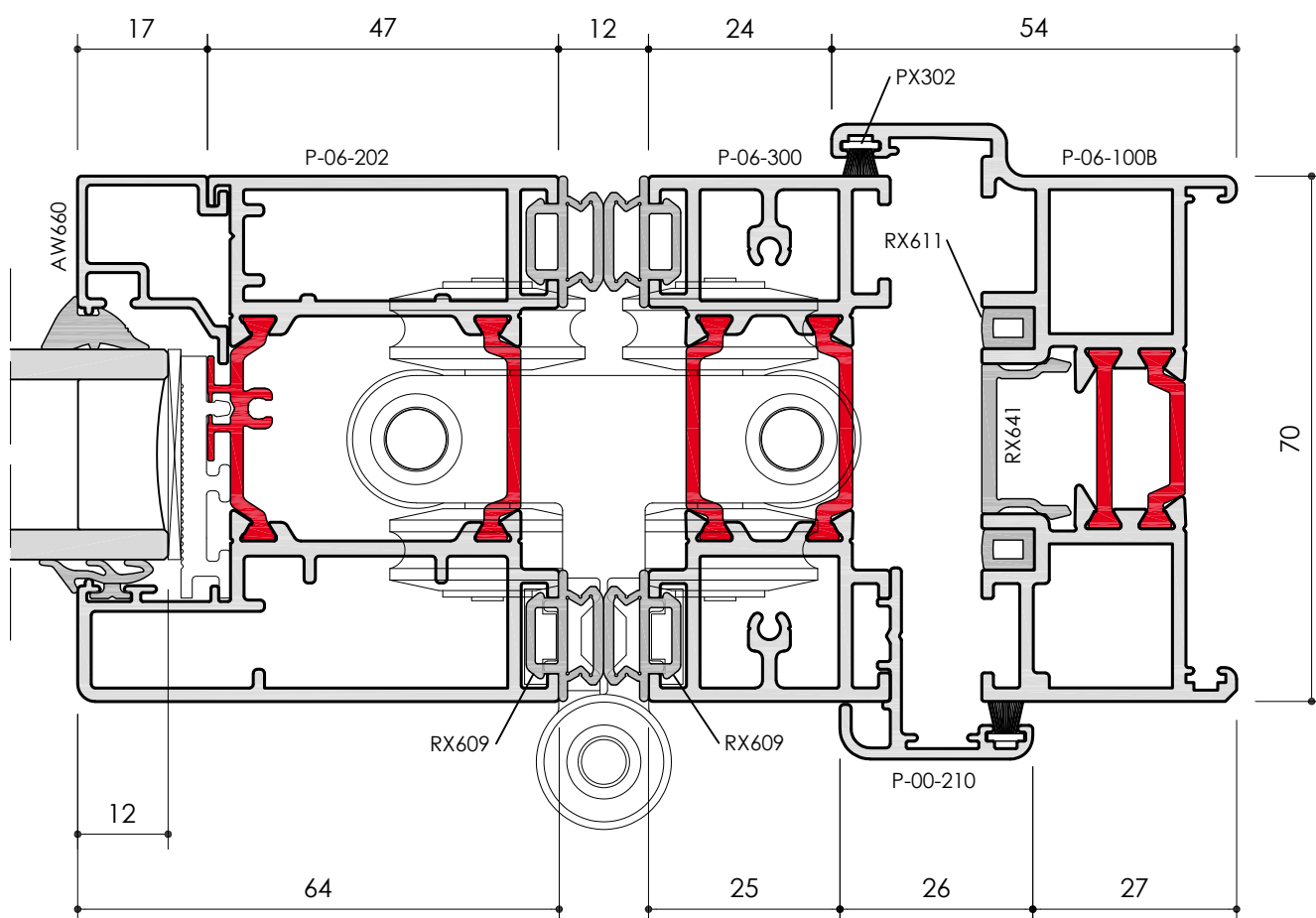
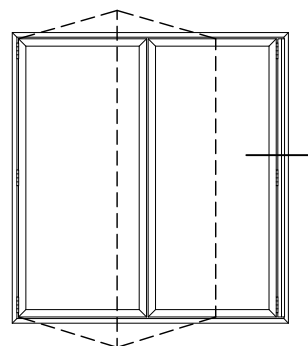


➤ TYPICAL DETAIL



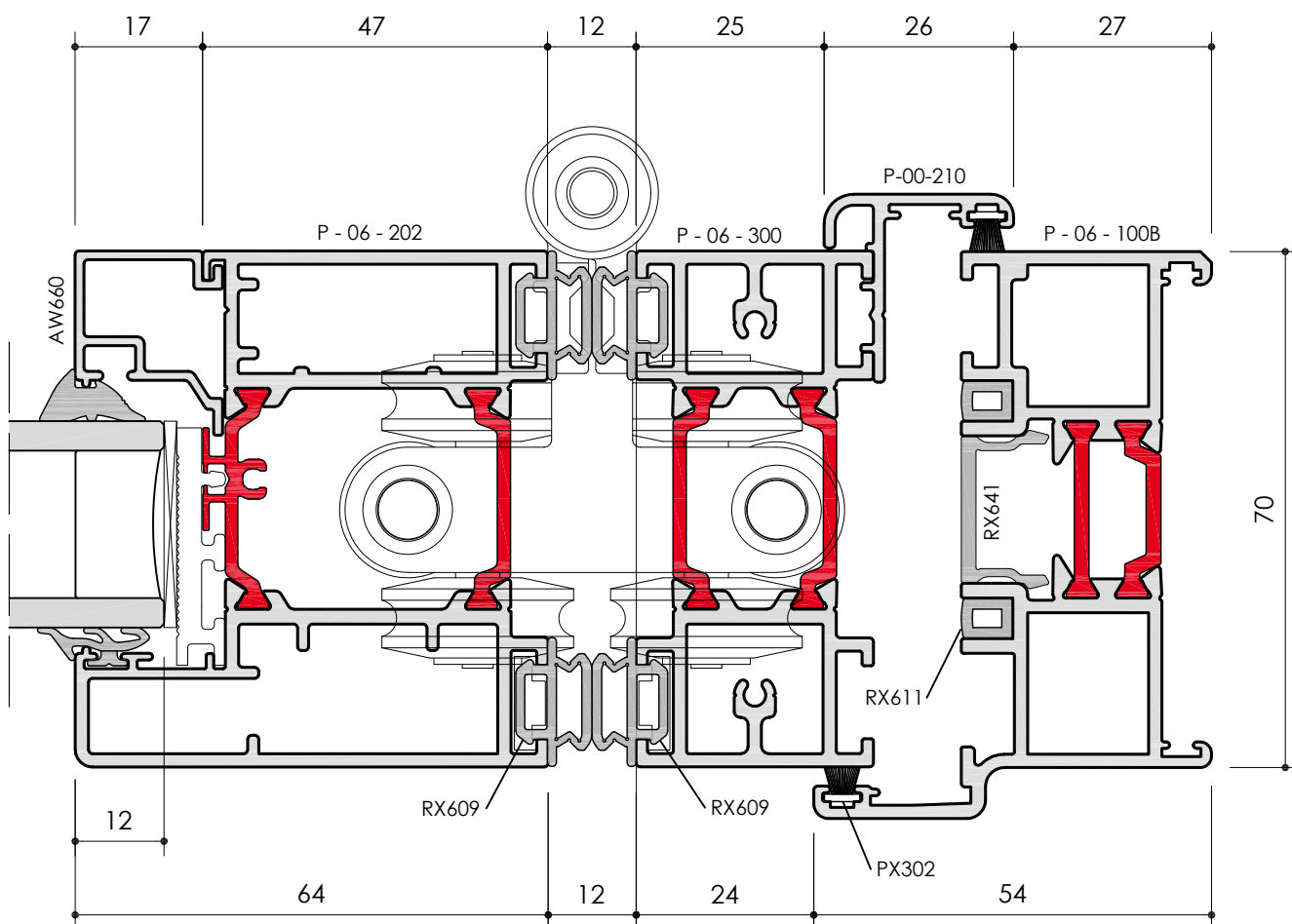
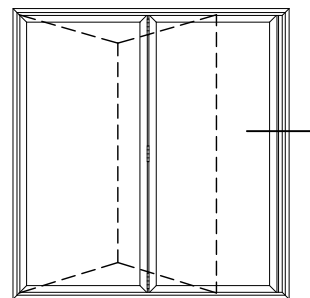
► TYPICAL DETAIL

ROLLER TO JAMB
OPEN OUT



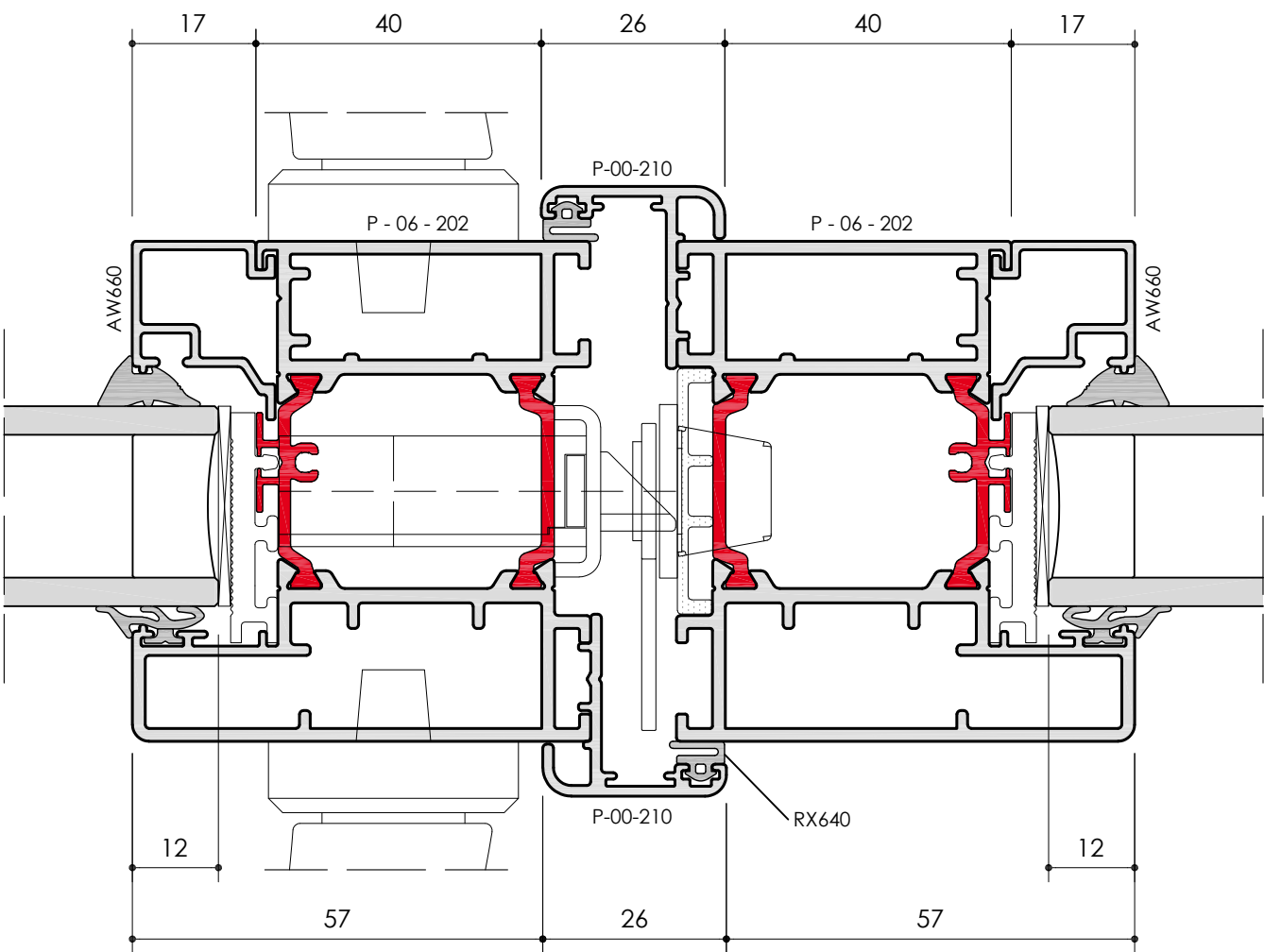
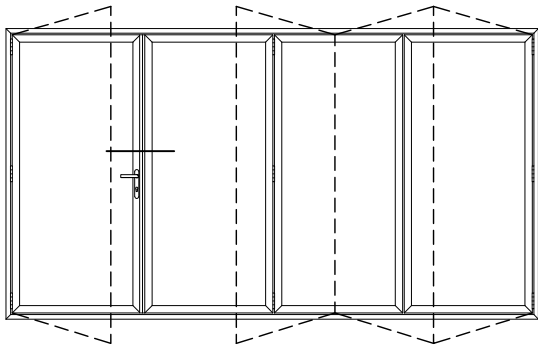
➤ TYPICAL DETAIL

ROLLER TO JAMB
OPEN IN



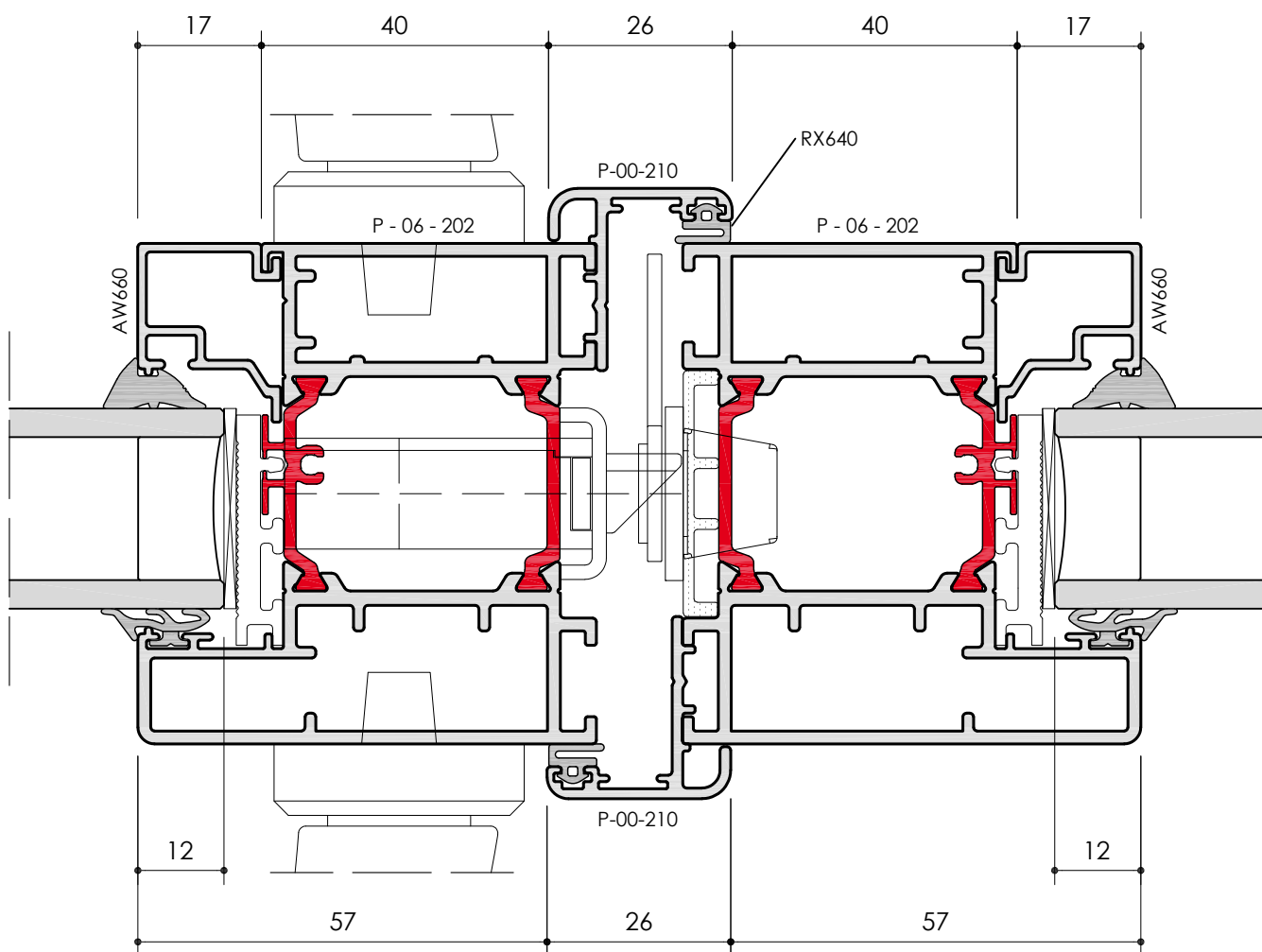
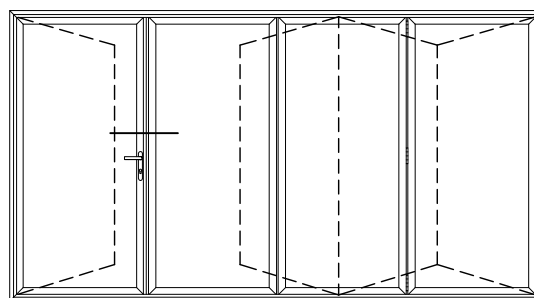
► TYPICAL DETAIL

TRAFFIC TO SLAVE DOOR (FINGER BOLT)
OPEN OUT



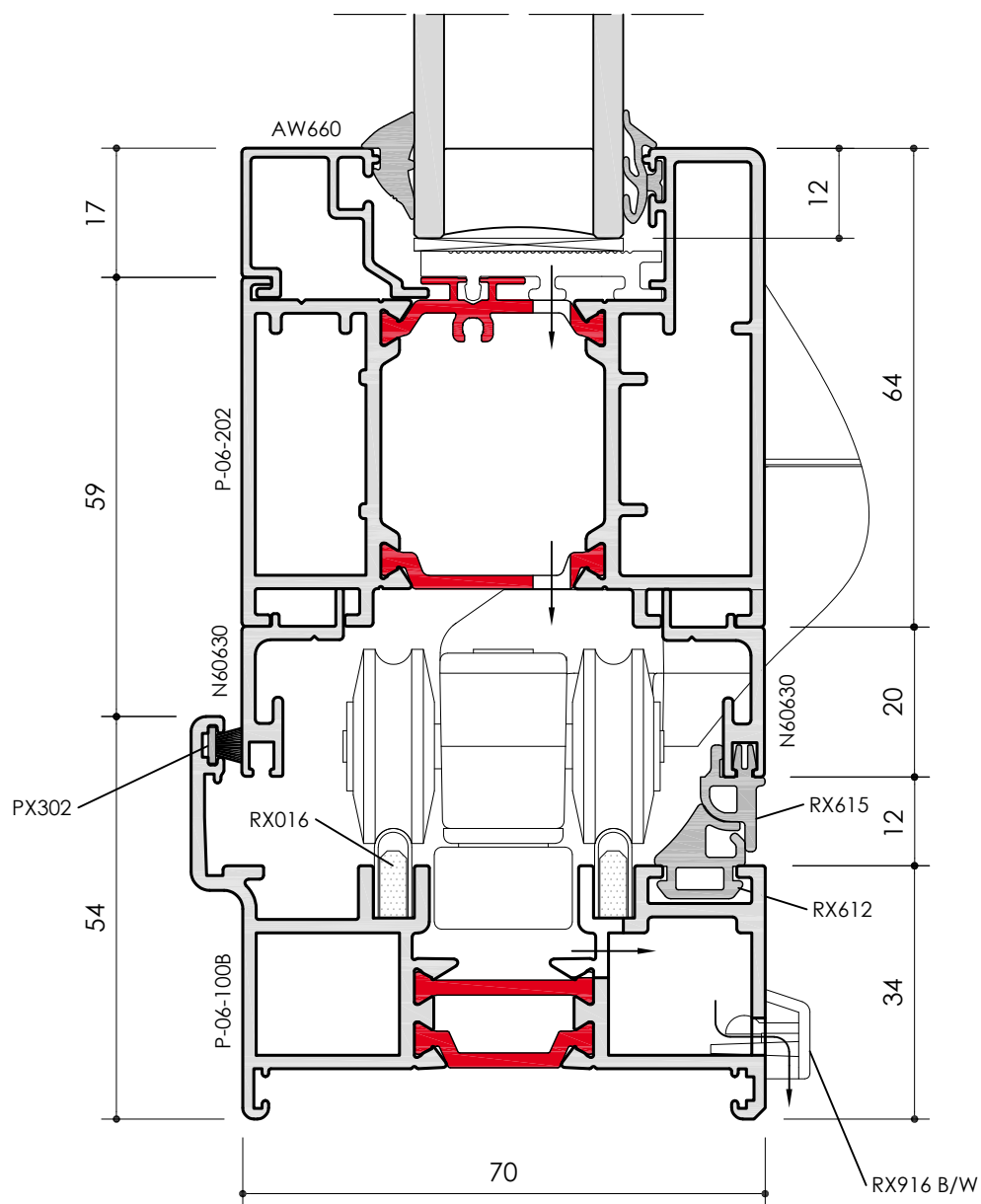
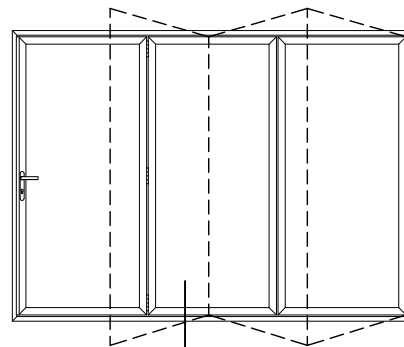
➤ TYPICAL DETAIL

TRAFFIC TO SLAVE DOOR (FINGER BOLT)
OPEN IN



► TYPICAL DETAIL

CILL
OPEN OUT - PAS24/SBD

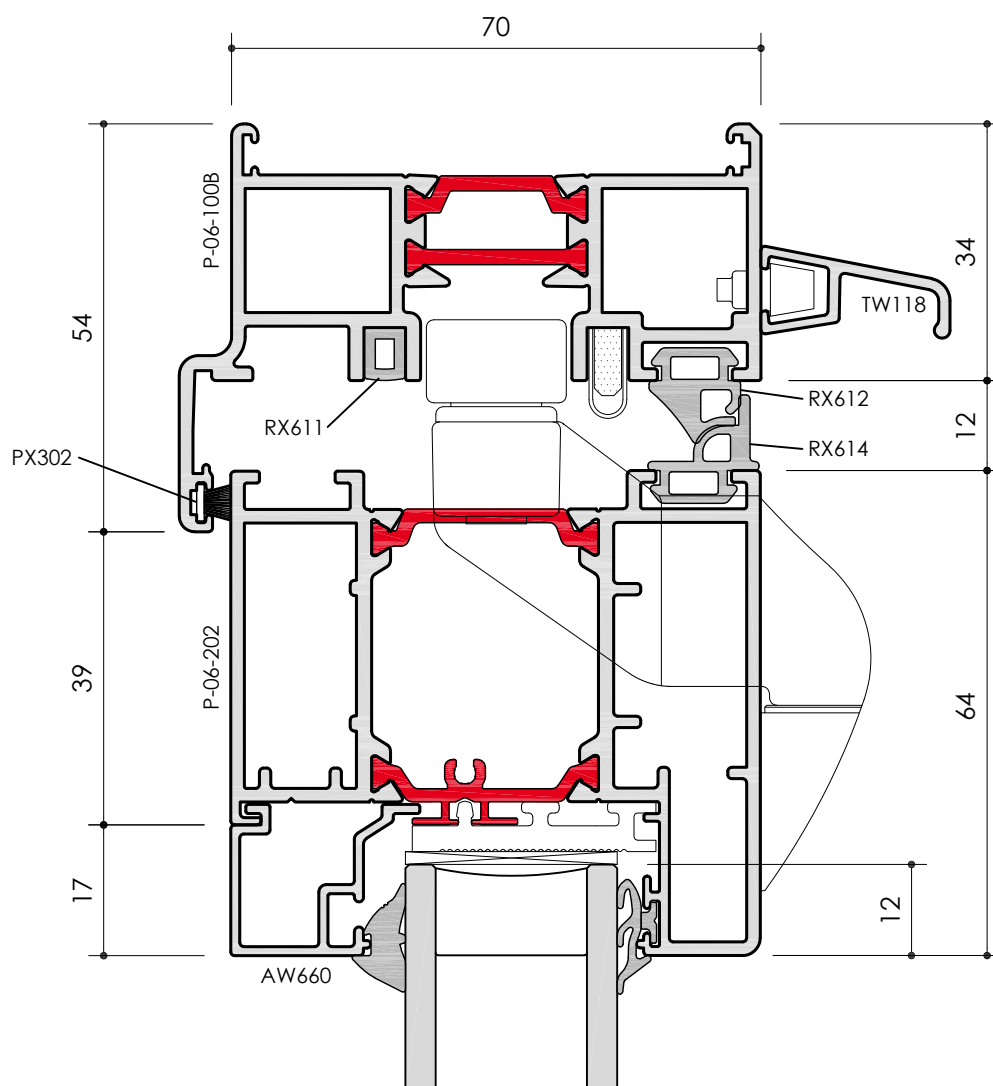
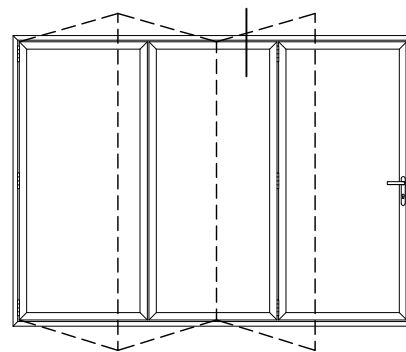


ONLY applicable to open out configurations
e.g. 3 Panel (3, 3-0), 5 Panel (5, 5-0) etc. Including traffic door.
OR

4 Panel (4, 2-2), 4 Panel (4, 4-0) Or 2 Panel (2, 2-0) etc. NOT including traffic door.

➤ TYPICAL DETAIL

HEAD
OPEN OUT - PAS24/SBD

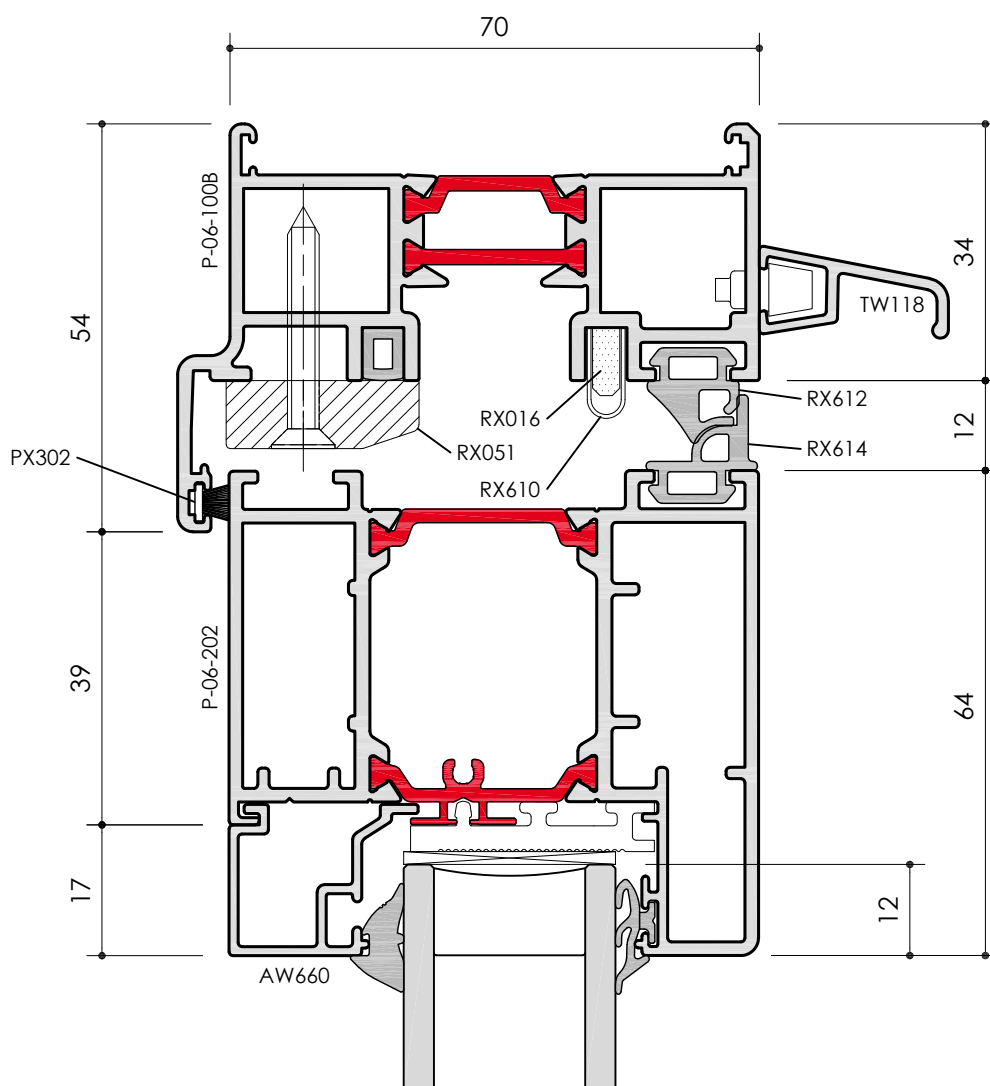
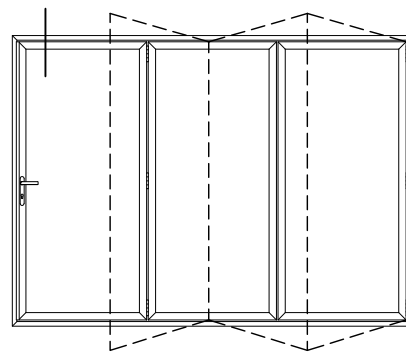


ONLY applicable to open out configurations
e.g. 3 Panel (3, 3-0), 5 Panel (5, 5-0) etc. Including traffic door.
OR

4 Panel (4, 2-2), 4 Panel (4, 4-0) Or 2 Panel (2, 2-0) etc. NOT including traffic door.

► TYPICAL DETAIL

HEAD TRAFFIC DOOR
OPEN OUT - PAS24/SBD



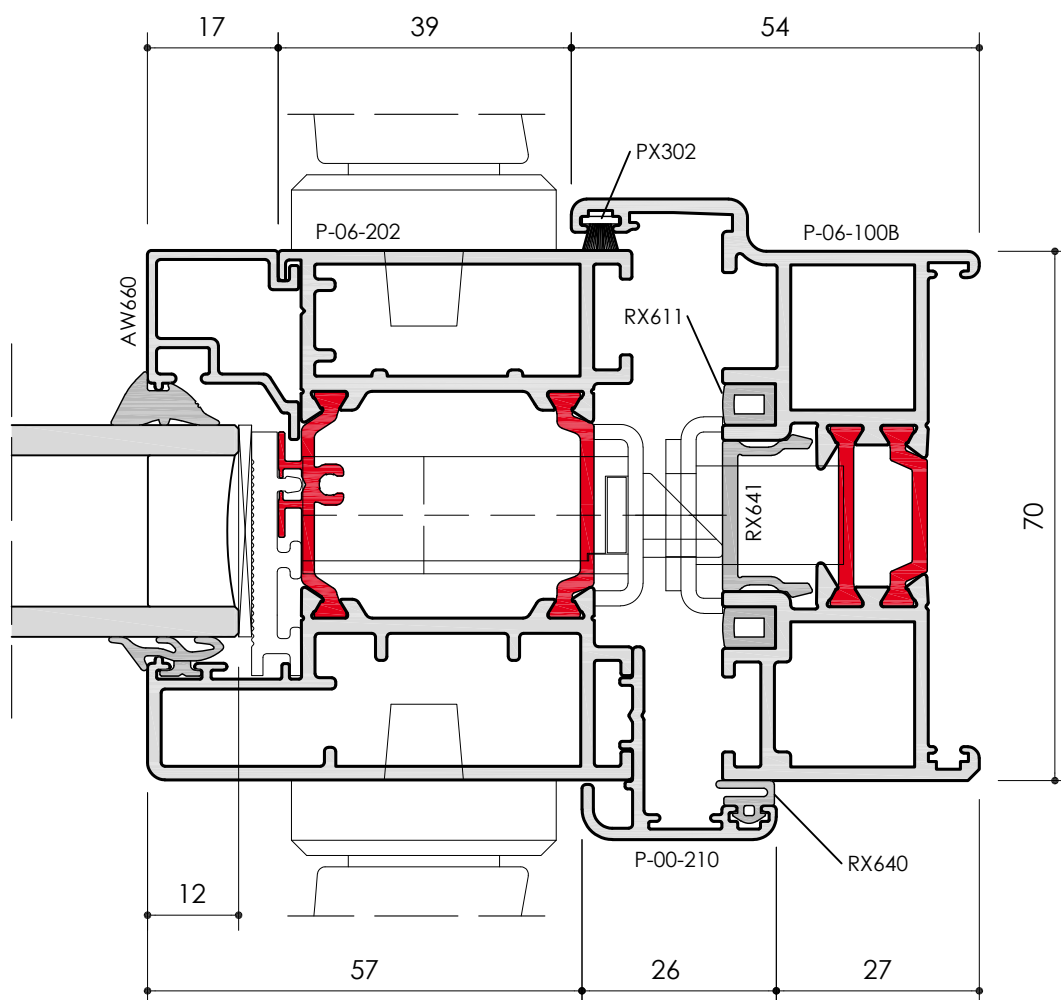
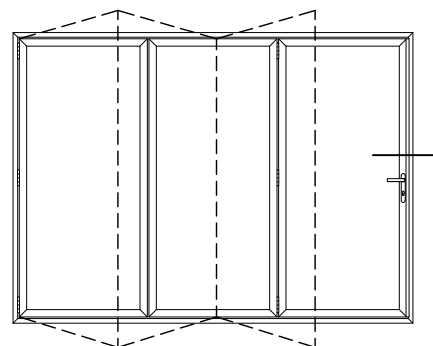
ONLY applicable to open out configurations
e.g. 3 Panel (3, 3-0), 5 Panel (5, 5-0) etc. Including traffic door.

OR

4 Panel (4, 2-2), 4 Panel (4, 4-0) Or 2 Panel (2, 2-0) etc. NOT including traffic door.

➤ TYPICAL DETAIL

TRAFFIC DOOR TO JAMB
OPEN OUT - PAS24/SBD

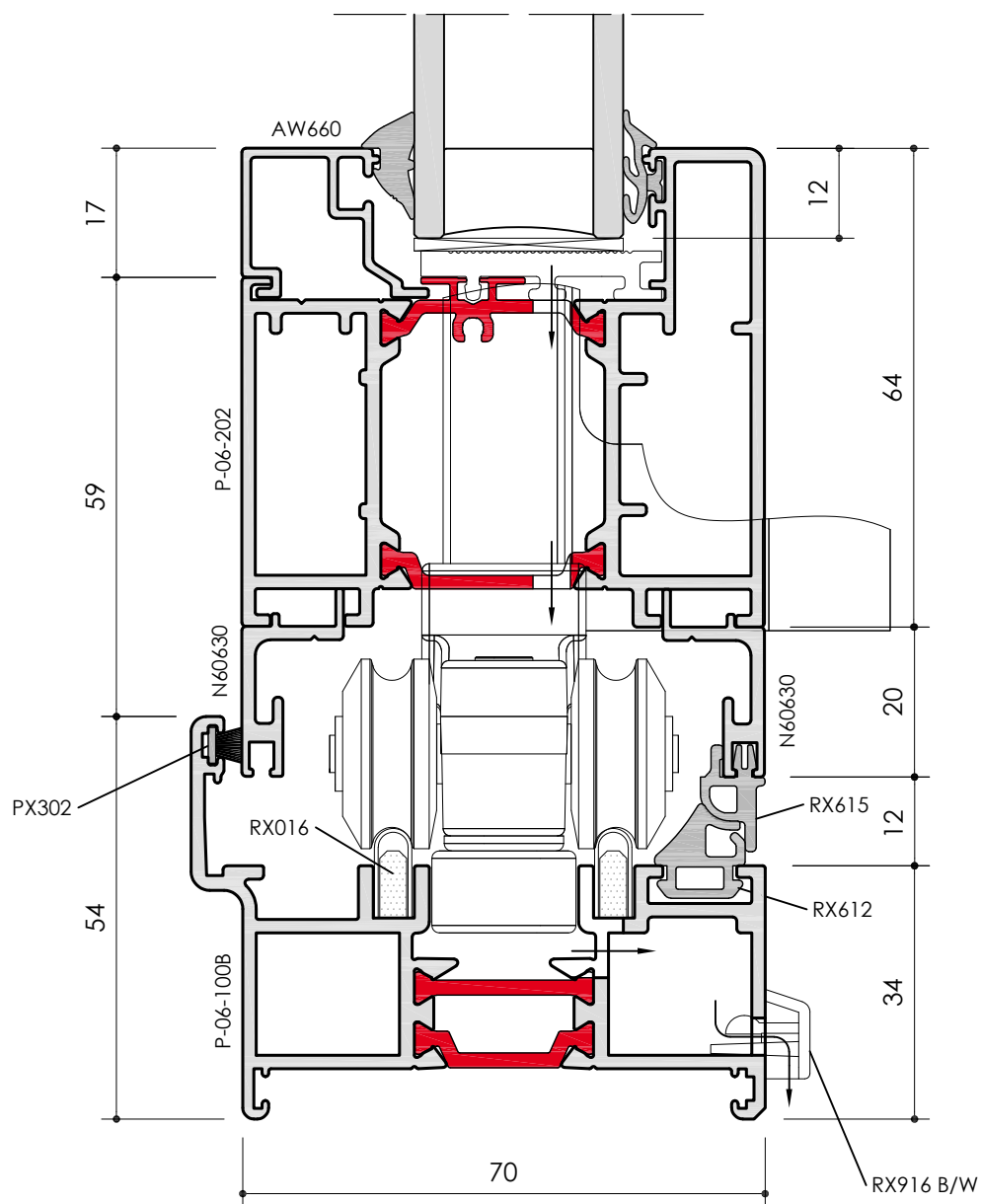
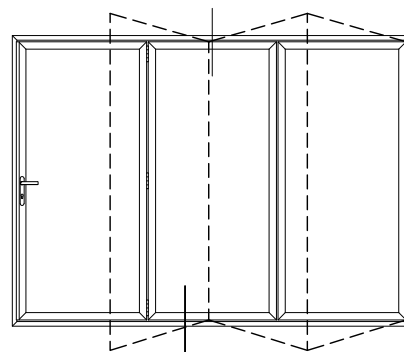


ONLY applicable to open out configurations
e.g. 3 Panel (3, 3-0), 5 Panel (5, 5-0) etc. Including traffic door.
OR

4 Panel (4, 2-2), 4 Panel (4, 4-0) Or 2 Panel (2, 2-0) etc. NOT including traffic door.

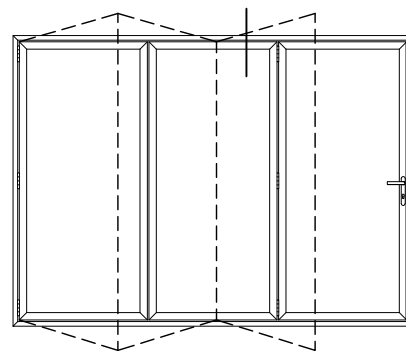
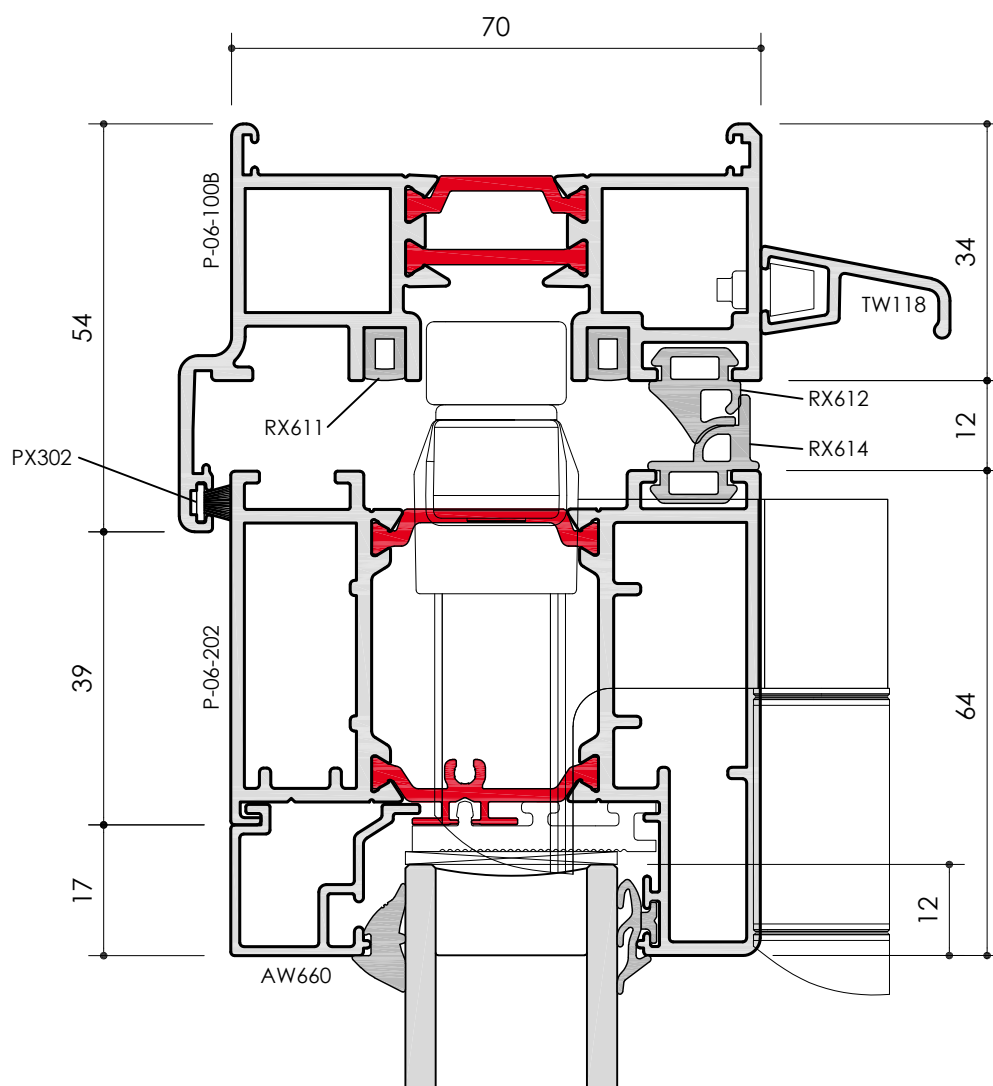
► TYPICAL DETAIL

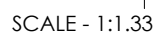
CILL - HEAVY DUTY ROLLER
OPEN OUT



➤ TYPICAL DETAIL

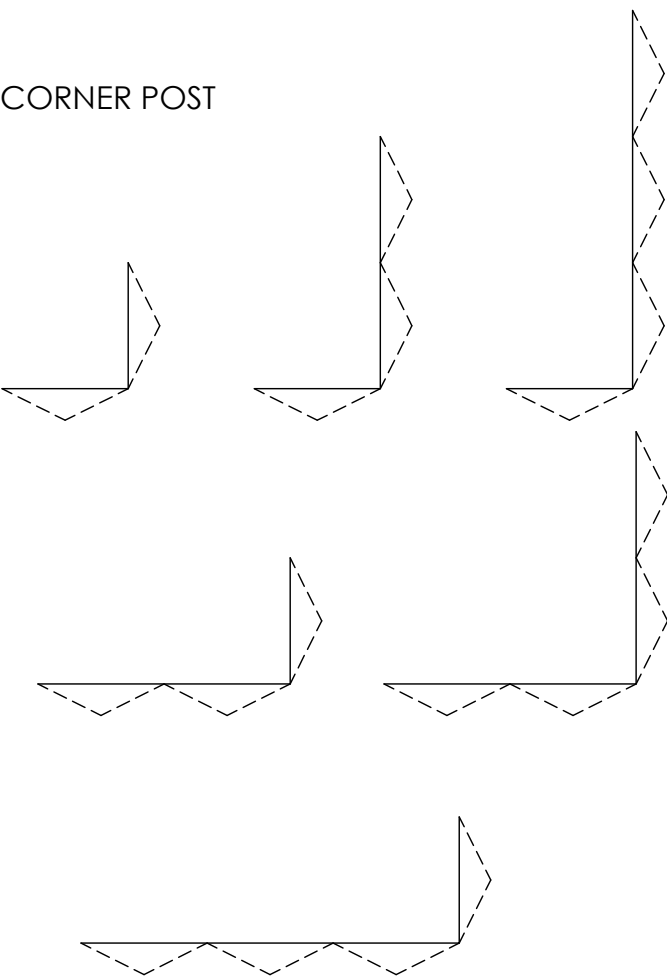
HEAD - HEAVY DUTY TOP GUIDE
OPEN OUT



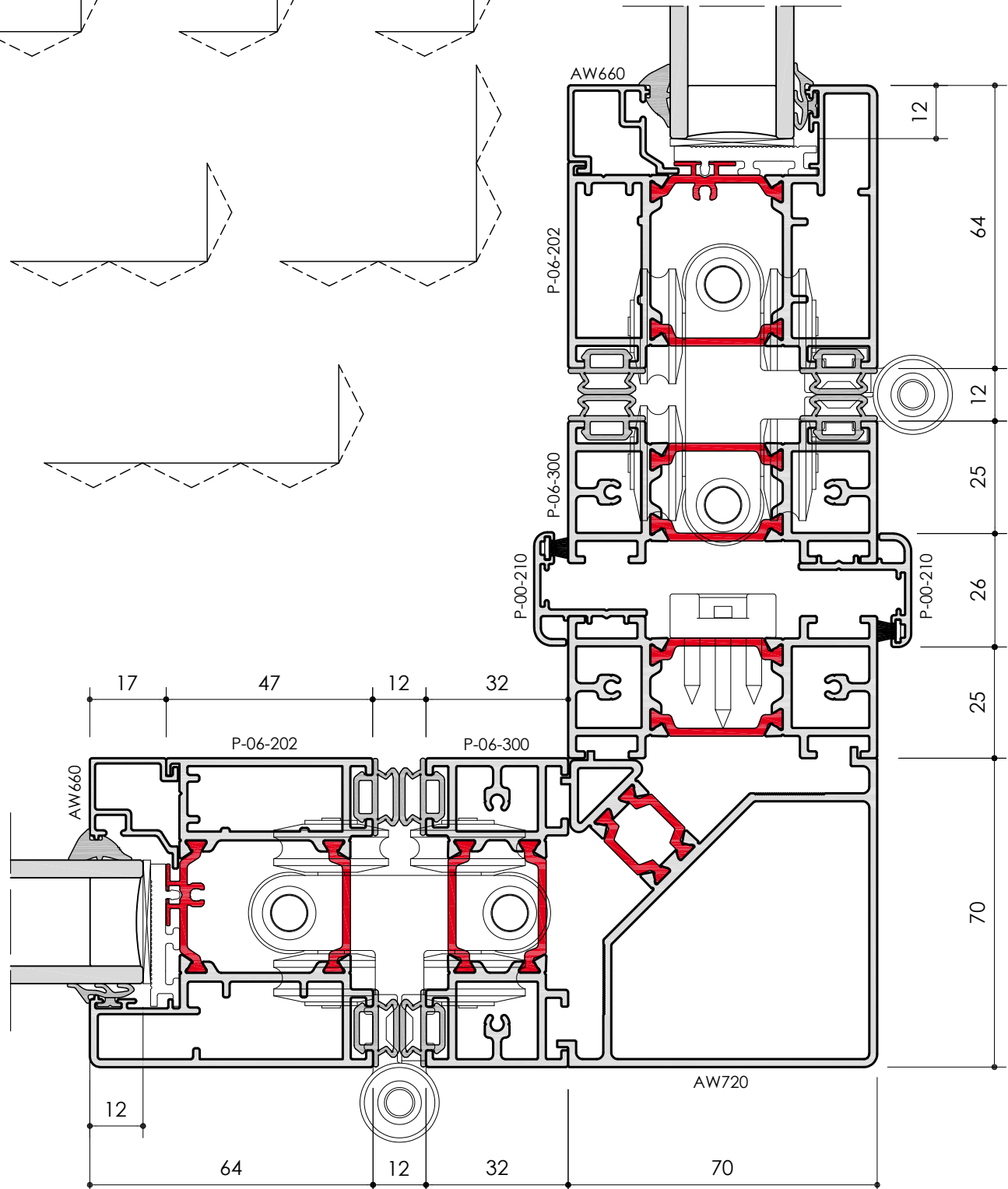


» TYPICAL DETAIL

CORNER POST



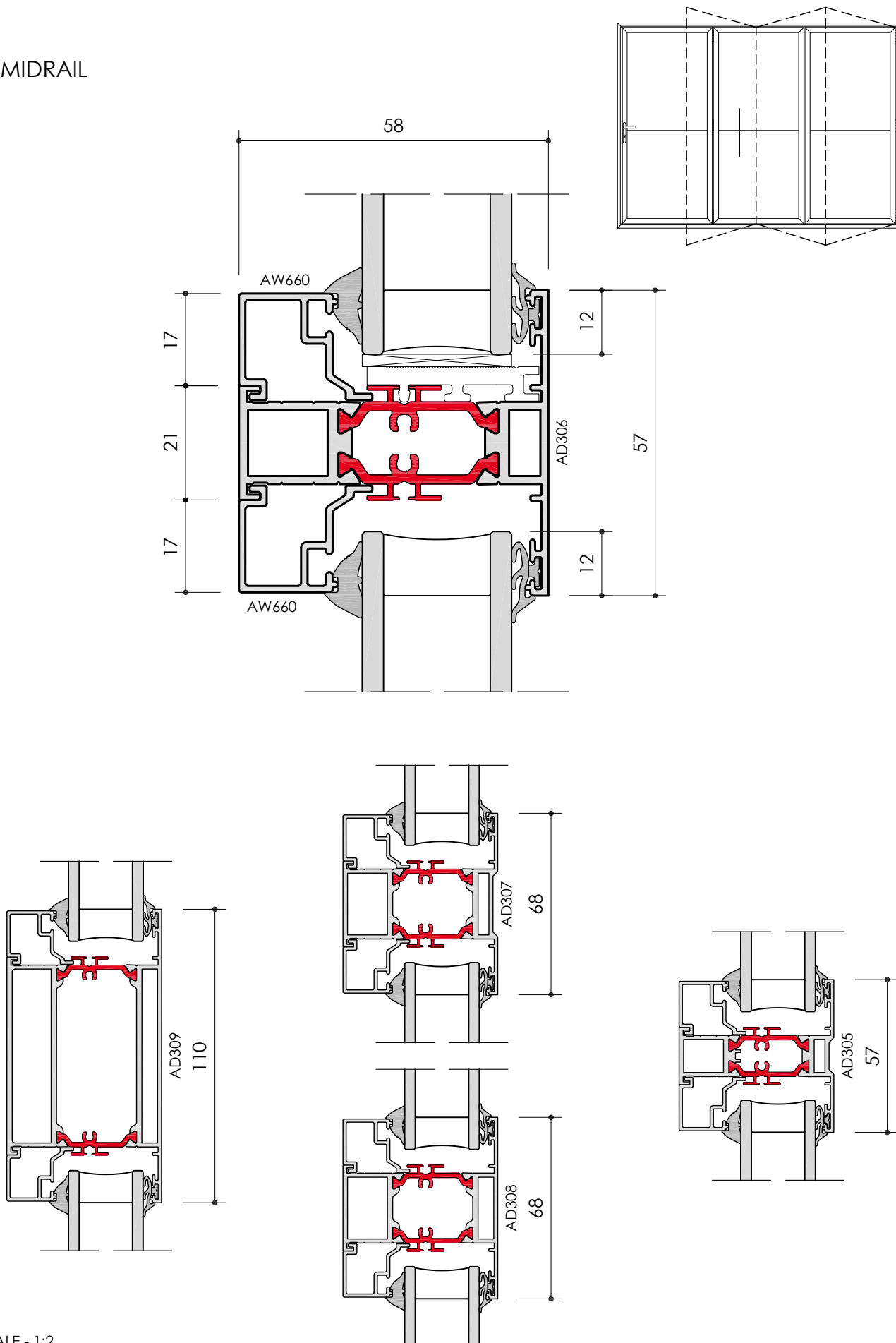
Corner Post configuration
Even number of vents in both directions



SCALE - 1:1.33

► TYPICAL DETAIL

MIDRAIL



SCALE - 1:2

BSF70

6.36

01.08.2017

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SECTION 7 GLAZING DETAILS



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GLAZING DETAILS

GLAZING

All glazing should conform with BS6262 and BS 8000-7 documentation.

Support the glass units correctly in accordance with BS6262 setting blocks and location blocks

Examine all glass units for damage prior to installation. Defective units should not be used.

Insulated glass units incorporating safety glass should be installed with the safety glass on the appropriate side. The safety glass mark must be visible after installation.

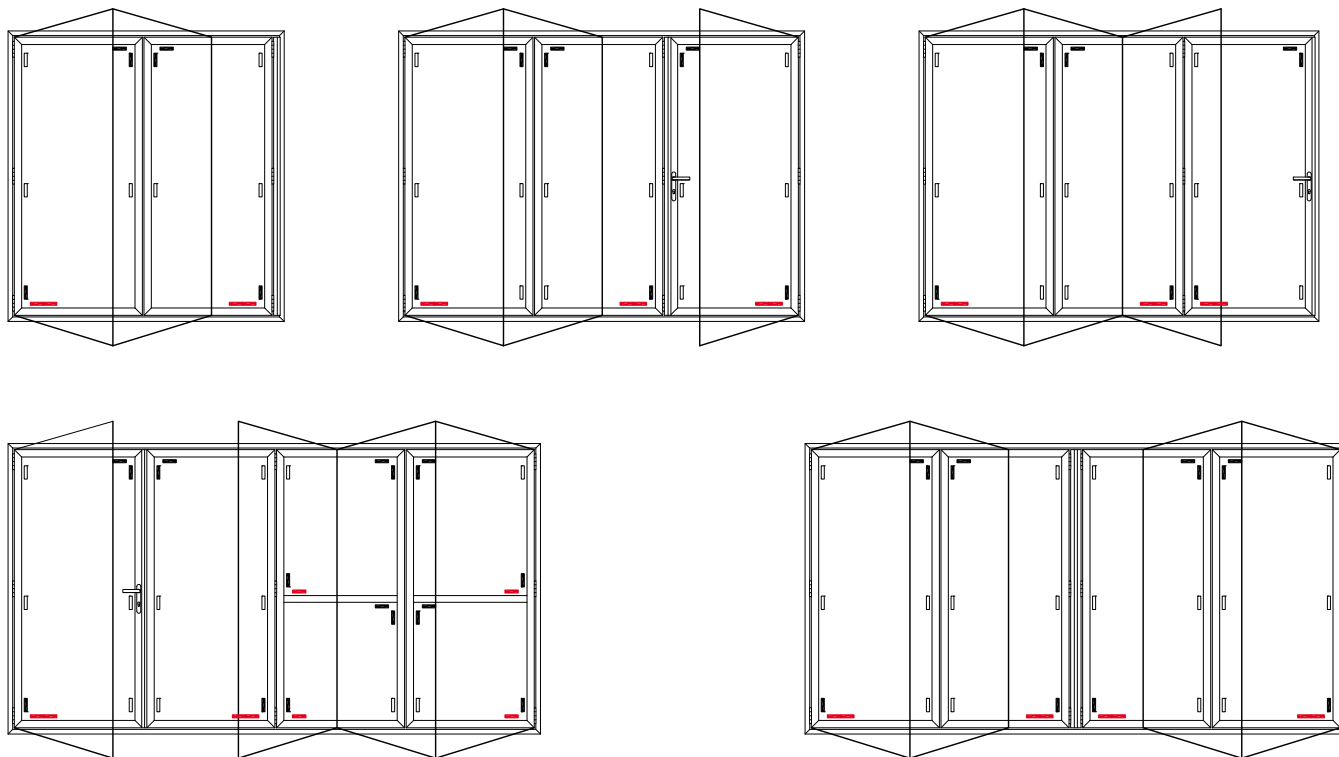
Insulation units with low emissivity coating should be installed in conjunction with the manufactures instruction. Failure to do so may make the coating less effective.

SETTING AND LOCATION BLOCK POSITIONS

Setting blocks are used on the underside of the glass unit to transfer load through the frame to the structure.

Location blocks are used between the glass and frame to centralise the glass unit, to prevent movement of the glass in the frame and to prevent the weight of glass causing the frame to be out of square. Location blocks are also used to aid security, positioned at door lock points and hinge positions, restricting frame movement and transferring attack loads through the frame to the structure.

Setting and location block positions to typical door setouts indicated below.

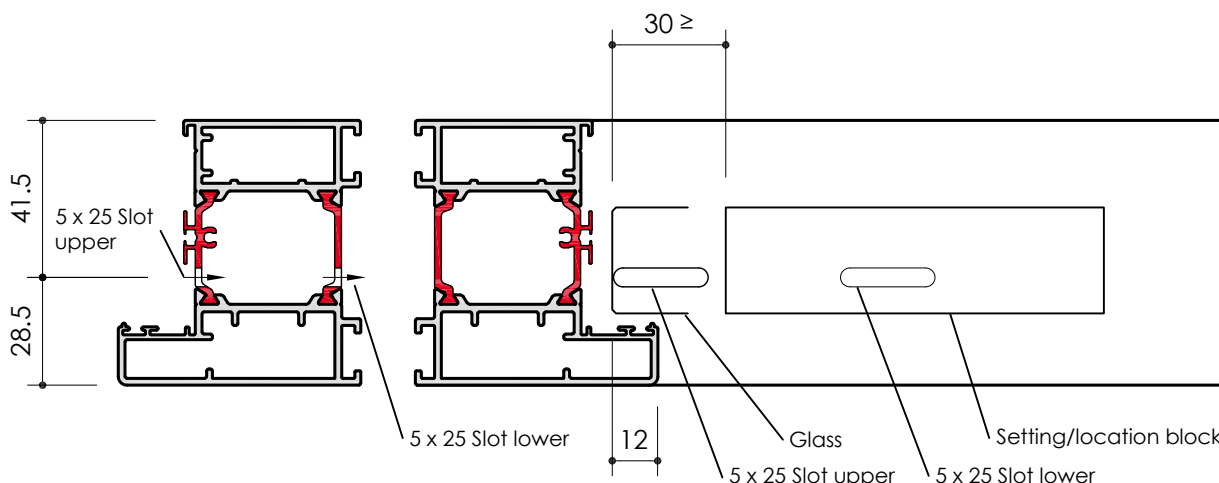


- Setting block
- Location block
- Location block for security
- Length 50mm per 1m² of glass
- Minimum length 25mm
- Minimum length 25mm

► GLAZING DETAILS

SETTING AND LOCATION BLOCK POSITIONS

The setting and location blocks should be positioned no less than 30mm from the glass edge. Ensure the upper drainage slot in the bottom rail of the door leaf and the pressure equalisation holes through the door leaf jambs are not obstructed.



INSTALLING GLASS

Full glass door

Close all door leaves, with the master leaf closed on its latch and all other leaves with shootbolt engaged.

- 1) Work from jamb post doors are hung off.
- 2) Apply bridge packers RX756 to setting and location block positions
- 3) Fit setting block to the bottom corner nearest the hinge.
- 4) Fit horizontal location block to the top corner diagonally opposite the setting block. Using a glazing shovel placed between glass and top rail of door leaf apply pressure to lift the door leaf so that it is parallel to the outer frame. Place location blocks as required between the door leaf and the glass to ensure the leaf remains parallel with the outer frame.
- 5) Fit vertical location blocks in line with the hinge between the glass unit and the door leaf. Using a glazing shovel placed between glass and door leaf above the door latch/central of door, apply pressure to bring the door leaf parallel to the outer frame/adjacent door leaf. Place location blocks as required between the door leaf and the glass to ensure the leaf remains parallel with both adjacent jamb members.
- 6) Open, close, lock and unlock the door leaves to ensure correct operation.
- 7) Upon satisfactory operation apply suitable sealant compatible with glass unit construction to all block positions to hold them in place.
- 8) If required, position location blocks for security. Blocks located parallel to vertical location blocks and also in line about position of door latch/centre of glass/central door hinge. Blocks to be loose fit between glass and door. Apply sealant to retain in position.
- 9) Bead up the door leaves taking care not to dislodge the packers.

Midrail door

Proceed as instructions for full glass door to the upper unit first, then repeat for the lower unit.

» GLAZING DETAILS

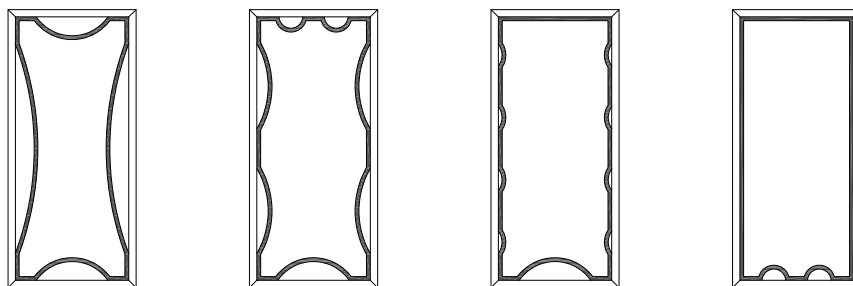
GASKET INSTALLATION

Gaskets should be installed into clean gaps. They should not be twisted, kinked or stressed. Linear gaskets should be taken from the reel cut to approximate length and allowed to relax before installation. Any damaged lengths of gasket should be cut out and discarded. Picture frame gaskets should be unbundled and allowed to relax.

Gaskets should be of the correct width for the gap. Wedge gaskets may have to be selected to accommodate variations in glass type and thickness from opening to opening.

Gaskets should not be stretched during installation. A gasket that is placed in tension during installation will attempt to revert to its original length. This may lead to opening up of a simple butt joint or tearing of a bonded or vulcanised joint. The gasket should be cut three per cent over length and put under linear compression as it is installed into place.

Uniform linear compression can best be achieved by following the installation sequence shown below. The corners or ends are inserted first followed by the mid-points. The quarter-points are then inserted and so on until the gasket is neatly compressed in the gap along its whole length.

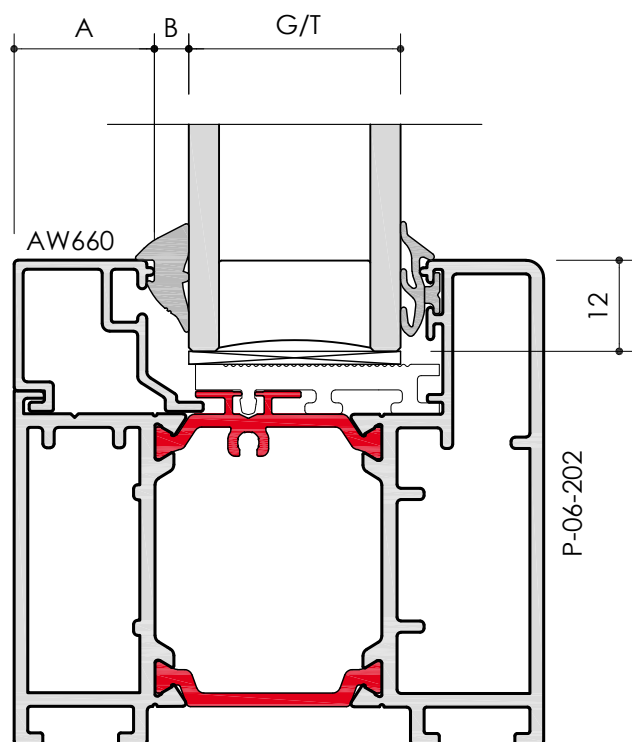


GASKET JOINTING

Gaskets may be formed into picture frame gaskets by bonding or vulcanising the corners in the factory. Alternatively corners may be formed by mitring two lengths of gasket and bonding the mitred faces, using preformed corners that are then bonded to square cut lengths of gasket or butt jointing with the abutting faces being bonded.

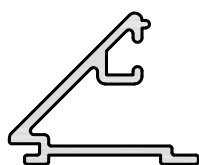
Gasket joints to be sealed using:
Cyanoacrylate

GLAZING DETAILS

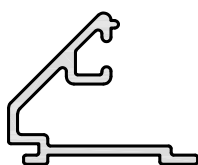


Applicable Profile/s:
P-06-200 & P-06-202

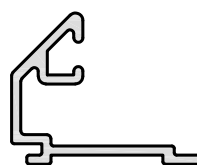
GLAZING CHART		
G/T	BEAD	GASKET
mm	A	B [WEDGE]
22	AW667	A-GS-308
23	AW667	A-GS-308
24	AW667	A-GS-306
25	AW667	A-GS-305
26	AW660/AW513	A-GS-308
27	AW660/AW513	A-GS-306
28	AW660/AW513	A-GS-305
29	AW668/AW630	A-GS-308
30	AW668/AW630	A-GS-308
31	AW668/AW630	A-GS-306
32	AW668/AW630	A-GS-305
33	AW668/AW630	A-GS-304
34	AW514	A-GS-308
35	AW514	A-GS-308
36	AW514	A-GS-306
37	AW514	A-GS-305
38	AW666	A-GS-308
39	AW666	A-GS-308
40	AW666	A-GS-306



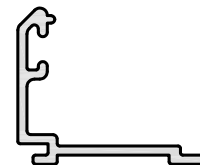
AW513



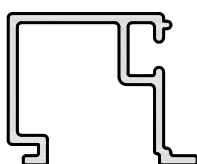
AW630



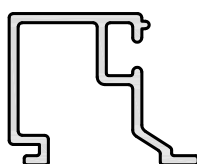
AW514



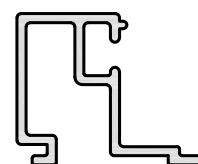
AW666



AW667



AW660



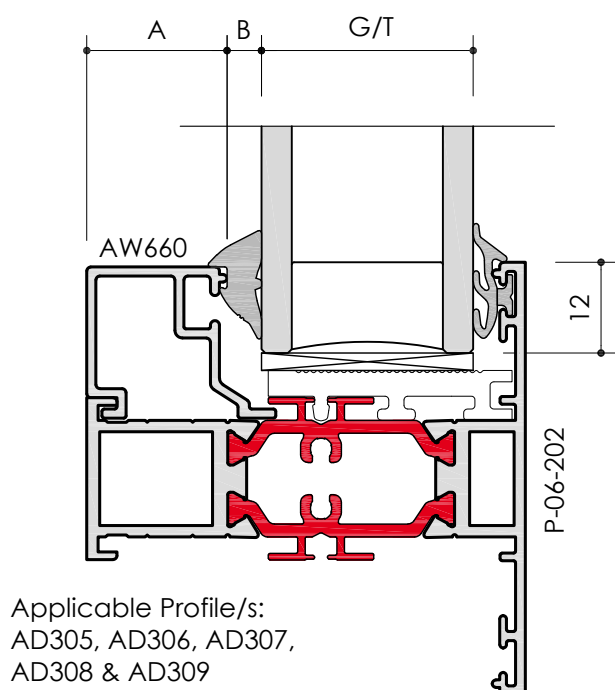
AW668

WEDGE GASKET			
A-GS-304	A-GS-305	A-GS-306	A-GS-308
4	5	6	8

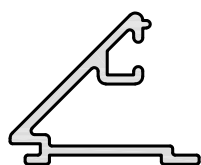
E-GASKET	
A-GS-240	A-GS-504

NB: Glazing charts are based upon standard glass combinations. When utilising laminated or acoustic glass, the gasket options should be trialled using a sample of the glazing unit in question prior to orders being placed.

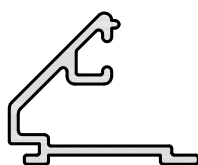
GLAZING DETAILS



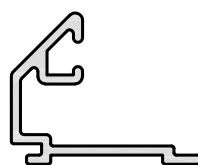
GLAZING CHART		
G/T	BEAD	GASKET
mm	A	B [WEDGE]
22	AW667	A-GS-308
23	AW667	A-GS-308
24	AW667	A-GS-306
25	AW667	A-GS-305
26	AW660/AW513	A-GS-308
27	AW660/AW513	A-GS-306
28	AW660/AW513	A-GS-305
29	AW668/AW630	A-GS-308
30	AW668/AW630	A-GS-308
31	AW668/AW630	A-GS-306
32	AW668/AW630	A-GS-305
33	AW668/AW630	A-GS-304
34	AW514	A-GS-308
35	AW514	A-GS-308
36	AW514	A-GS-306
37	AW514	A-GS-305
38	AW666	A-GS-308
39	AW666	A-GS-308
40	AW666	A-GS-306



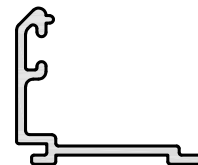
AW513



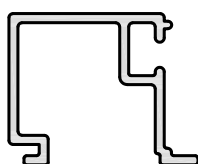
AW630



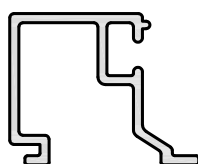
AW514



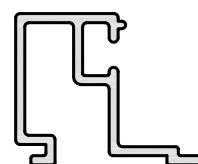
AW666



AW667



AW660



AW668

WEDGE GASKET			
A-GS-304	A-GS-305	A-GS-306	A-GS-308
 4	 5	 6	 8

E-GASKET	
A-GS-240	A-GS-504

NB: Glazing charts are based upon standard glass combinations. When utilising laminated or acoustic glass, the gasket options should be trialled using a sample of the glazing unit in question prior to orders being placed.

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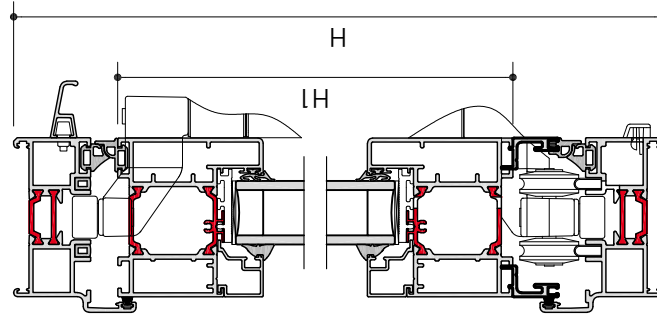
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SECTION 8 CUTTING LIST

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BSF70
OPEN OUT/OPEN IN
2-2-0

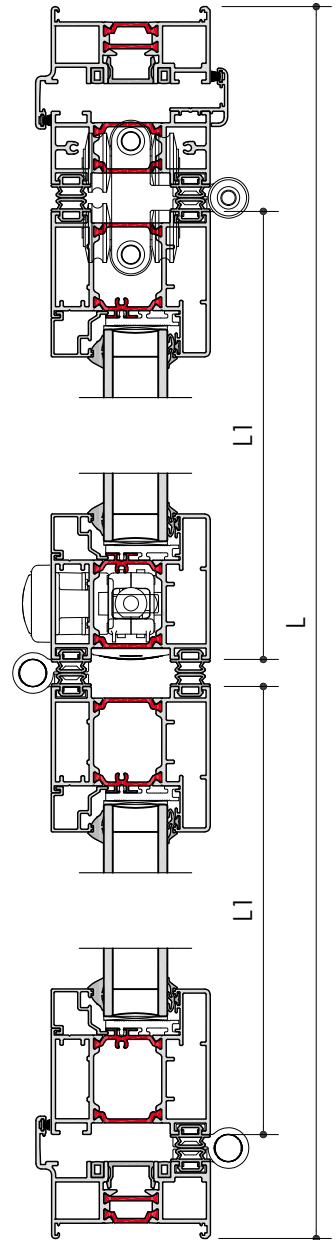
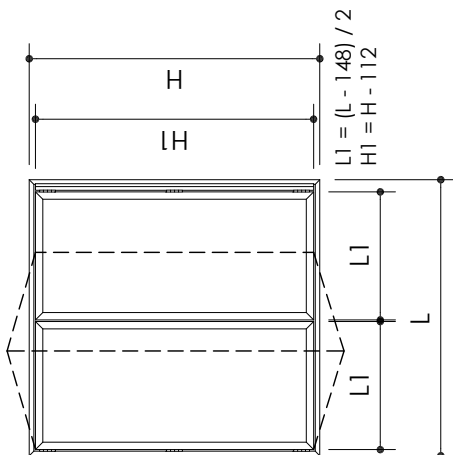
Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
End mill cutter - BSD703
Press tool - BSD706



HARDWARE		NO.
RX701A	Top bogie	1
RX702A	Bottom bogie	1
RX703A	Hinge	7
RX710	Shootbolt pack	1
RX730 - 731	T handle / T locking handle	1
RX740 - 741	Replacement / spare locking T handle keys	1
ACCESSORIES		NO.
A-00-100	Mechanical cleat tensioning block	24
RX16	Drip bar rivet	4
RX600	18.9mm Mechanical cleat	8
RX601	13.7mm Mechanical cleat	16
RX610	6.5m FSD SS Track	1
RX704	Floating mullion block	2
RX756	Bridge packer	4 Min.
RX770	P-00-210 End caps	1 Pair
RX775	Anti twist guide	2
RX904	Narrow chevron	8
RX916	Drain hole cover	4
GASKET / PLASTIC PROFILES		NO.
A-GS-240	Slide in E gasket	4L1 + 4H1
A-GS-304 - 308	Internal glazing gasket	4L1 + 4H1
A-GS-504	Push in E gasket	4L1 + 4H1
PX302	4.8mm 825 WF Woolpile (grey)	2L + 3H
RX609	Interlock & jamb seal	10H
RX611	FSD Track seal	2L + 4H
RX612	Bottom frame seal	2L
RX614	Head seal	L
RX615	Bottom carrier seal	L
RX616	Top bogie corner mould	1
RX617A	Top corner mould	4
RX618	Bottom bogie corner mould	1
RX619A	Bottom corner mould	4
RX641	Outer frame finishing trim	2H

Key:
45° - 45°
90° - 90°

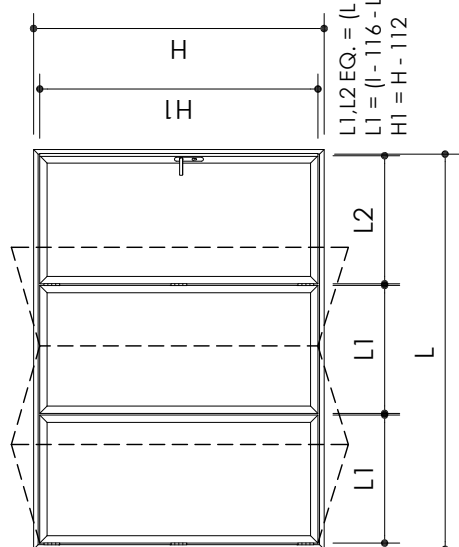
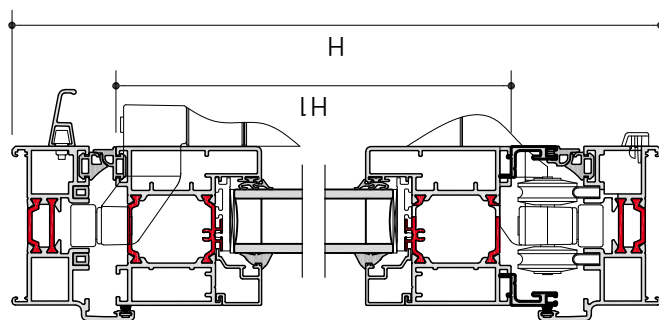
PROFILE	NO.	SIZE
P-06-100	2	H
P-06-100	2	L
P-06-202	4	L1
P-06-202	4	H1
P-06-300	1	H1
P-00-210	1	H - 92
N60630	4	L1
N60630	2	32mm
AW660	4	L1 - 94
AW660	4	H1 - 128.5
TW118	1	L
GLASS	NO.	WIDTH
Glass unit 28mm	2	L1 - 104
		H1 - 104



BSF70
OPEN OUT/ OPEN IN
3-3-0

Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
Press tool - BSD706

HARDWARE		NO.
RX180	Lever - lever handle	1
RX194	45/45 Standard cylinder	1
RX701A	Top bogie	1
RX702A	Bottom bogie	1
RX703A	Hinge	7
RX710	Shootbolt pack	1
RX730 - 731	T handle / T locking handle	1
RX740 - 741	Replacement / spare locking T handle keys	1
RX780LH/RH	Winkhaus traffic door lock	1
RX781LH/RH	Winkhaus centre keep	1
RX782	Winkhaus top / bottom keep	2
ACCESSORIES		NO.
A-00-100	Mechanical cleat tensioning block	32
RX16	Drip bar rivet	6
RX600	18.9mm Mechanical cleat	8
RX601	13.7mm Mechanical cleat	24
RX610	6.5m FSD SS Track	2
RX720	Traffic door magnet	1
RX756	Bridge packer	6 Min.
RX770	P-00-210 End caps	1 Pair
RX904	Narrow chevron	8
RX916	Drain hole cover	6
GASKET / PLASTIC PROFILES		NO.
A-GS-240	Slide in E gasket	4L1 + 2L2 + 6H1
A-GS-302 - 308	Internal glazing gasket	4L1 + 2L2 + 6H1
A-GS-504	Push in E gasket	4L1 + 2L2 + 6H1
PX302	4.8mm 825 WF Woolpile (grey)	2L + 2H
RX609	Interlock & jamb seal	10H
RX611	FSD Track seal	2L + 4H
RX612	Bottom frame seal	2L
RX614	Head seal	L
RX615	Bottom carrier seal	L
RX616	Top bogie corner mould	1
RX617A	Top corner mould	4
RX618	Bottom bogie corner mould	1
RX619A	Bottom corner mould	4
RX640	Push in lipper gasket	H
RX641	Outer frame finishing trim	2H



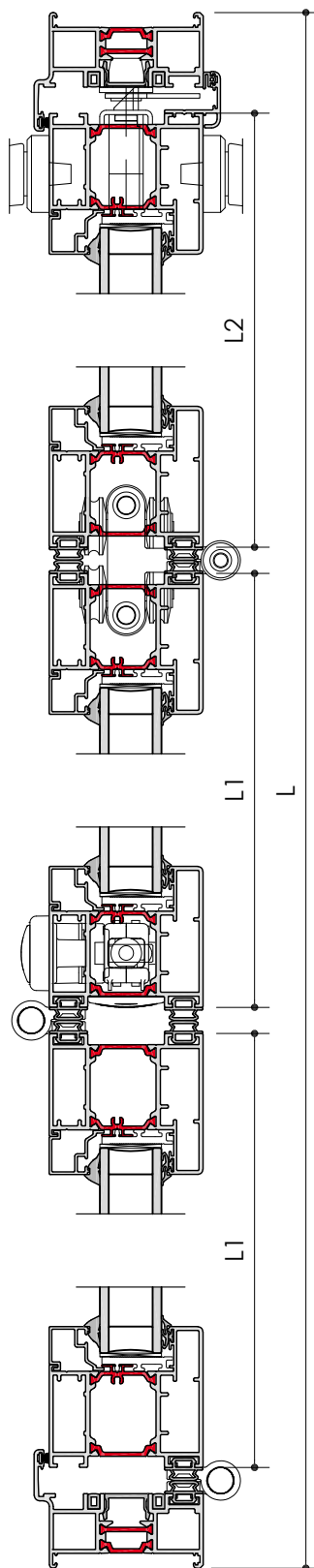
$$L1, L2 \text{ EQ.} = (L - 116) / 3$$

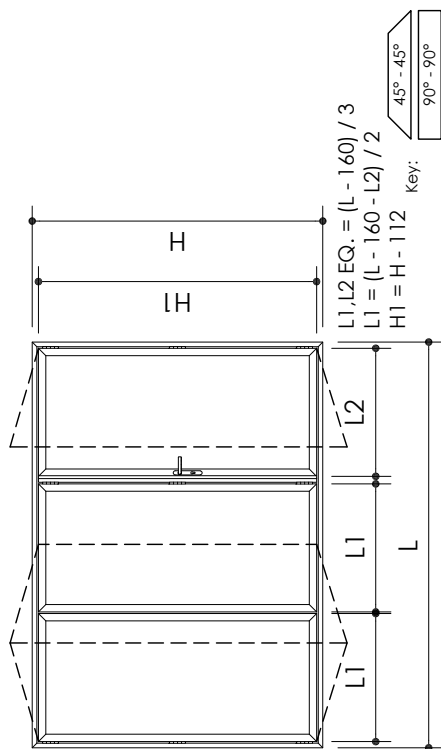
$$L1 = (L - 116 - L2) / 2$$

$$H1 = H - 112$$

Key:
45° - 45°
90° - 90°

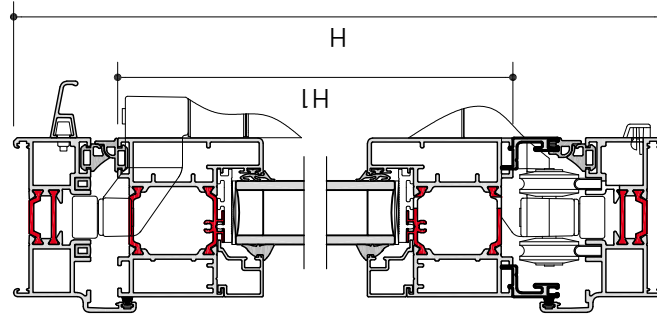
PROFILE		NO.	SIZE
P-06-100	Outerframe	2	H
P-06-100	Outerframe	2	L
P-06-202	Sash (L1)	4	L1
P-06-202	Sash (L2)	2	L2
P-06-202	Sash (H1)	6	H1
P-00-210	Rebate adaptor	1	H - 92
N60630	Threshold adaptor (L1)	4	L1
N60630	Threshold adaptor (L2)	2	L2
AW660	28mm Bead (L1)	4	L1 - 94
AW660	28mm Bead (L2)	2	L2 - 94
AW660	28mm Bead (H1)	6	H1 - 128.5
TW118	Drip bar	1	L
GLASS	NO.	WIDTH	HEIGHT
Glass unit 28mm	2	L1 - 104	H1 - 104
Glass unit 28mm	1	L2 - 104	H1 - 104





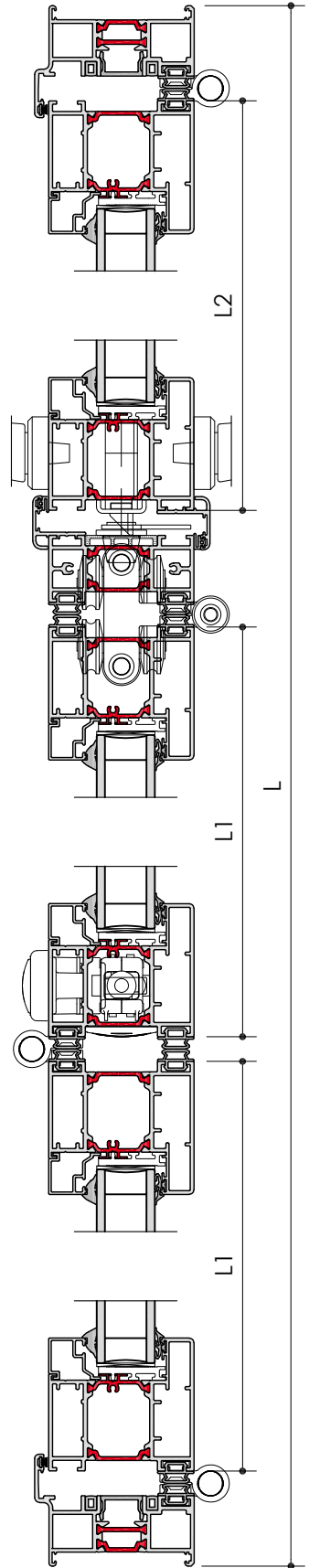
BSF70
OPEN OUT/OPEN IN
3-2-1

Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
End mill cutter - BSD703
Press tool - BSD706



HARDWARE	NO.
RX180	Lever - lever handle
RX194	45/45 Standard cylinder
RX701A	Top bogie
RX702A	Bottom bogie
RX703A	Hinge
RX710	Shootbolt pack
RX730 - 731	T handle / T locking handle
RX740 - 741	Replacement / spare locking T handle keys
RX780LH/RH	Winkhaus traffic door lock
RX781LH/RH	Winkhaus centre keep
RX782	Winkhaus top / bottom keep
ACCESSORIES	NO.
A-00-100	Mechanical cleat tensioning block
RX16	Drip bar rivet
RX600	18.9mm Mechanical cleat
RX601	13.7mm Mechanical cleat
RX610	6.5m FSD SS Track
RX704	Floating mullion block
RX756	Bridge packer
RX770	P-00-210 End caps
RX775	Anti twist guide
RX904	Narrow chevron
RX916	Drain hole cover
GASKET / PLASTIC PROFILES	NO.
A-GS-240	Slide in E gasket
A-GS-302 - 308	Internal glazing gasket
A-GS-504	Push in E gasket
PX302	4.8mm 825 WF Woolpile (grey)
RX609	Interlock & jamb seal
RX611	FSD Track seal
RX612	Bottom frame seal
RX614	Head seal
RX615	Bottom carrier seal
RX616	Top bogie corner mould
RX617A	Top corner mould
RX618	Bottom bogie corner mould
RX619A	Bottom corner mould
RX640	Push in flipper gasket
RX641	Outer frame finishing trim
RX757	Keep packer

PROFILE	NO.	SIZE
P-06-100	2	H
P-06-100	2	L
P-06-202	4	L1
P-06-202	2	L2
P-06-202	6	H1
P-06-300	1	H1
P-00-210	1	H - 92
P-00-210	1	H - 122
N60630	4	L1
N60630	2	L2
P-00-211	2	32mm
AW660	4	L1 - 94
AW660	2	L2 - 94
AW660	6	H1 - 128.5
TW118	1	L
GLASS	NO.	WIDTH
Glass unit 28mm	2	L1 - 104
Glass unit 28mm	1	L2 - 104

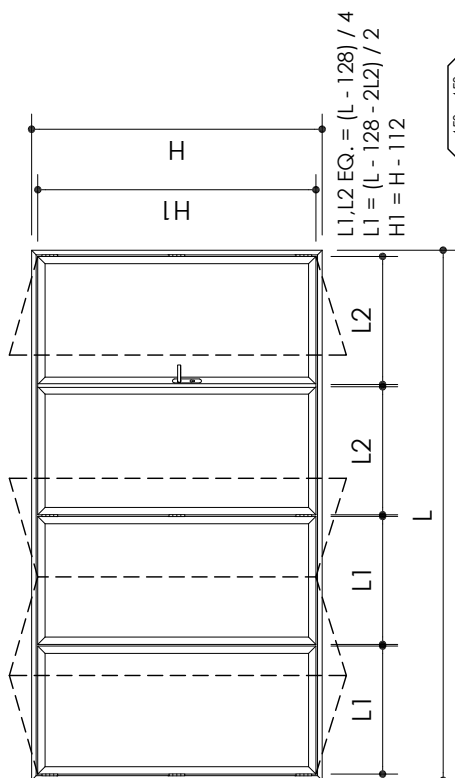


CUTTING LIST

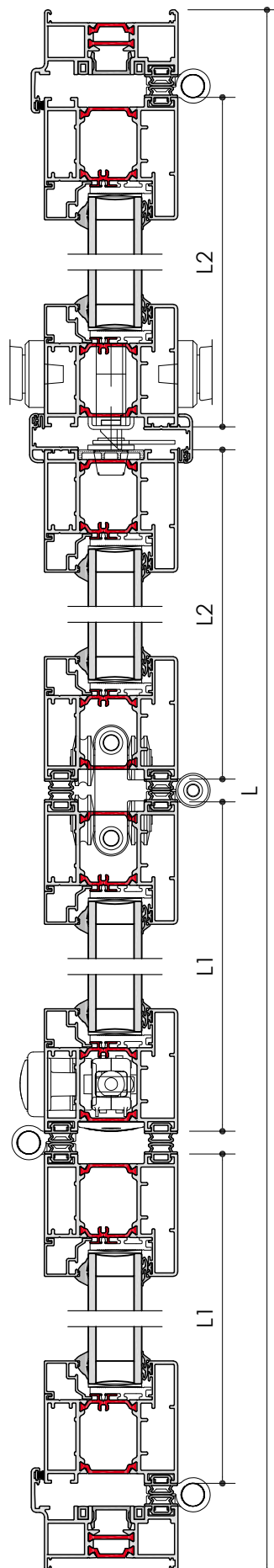
BSF70
OPEN OUT/OPEN IN
4-3-1

Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
End mill cutter - BSD703
Press tool - BSD706

HARDWARE	NO.
RX180 Lever - lever handle	1
RX194 45/45 Standard cylinder	1
RX701A Top bogie	1
RX702A Bottom bogie	1
RX703A Hinge	10
RX710 Shootbolt pack	1
RX730 - 731 T handle / T locking handle	1
RX740 - 741 Replacement / spare locking T handle keys	1
RX765 Finger bolt assembly	1
RX780LH/RH Winkhaus traffic door lock	1
RX781LH/RH Winkhaus centre keep	1
RX782 Winkhaus top / bottom keep	2
ACCESSORIES	NO.
A-00-100 Mechanical cleat tensioning block	40
RX16 Drip bar rivet	8
RX600 18.9mm Mechanical cleat	8
RX601 13.7mm Mechanical cleat	32
RX610 6.5m FSD SS Track	2
RX704 Floating mullion block	2
RX720 Traffic door magnet	1
RX756 Bridge packer	8 Min.
RX770 P-00-210 End caps	2 Pair
RX775 Anti twist guide	2
RX904 Narrow chevron	8
RX916 Drain hole cover	8
GASKET / PLASTIC PROFILES	NO.
A-GS-240 Slide in E gasket	4L2 + 4L2 + 8H1
A-GS-302 - 308 Internal glazing gasket	4L2 + 4L2 + 8H1
A-GS-504 Push in E gasket	4L2 + 4L2 + 8H1
PX302 4.8mm 825 WF Woolpile (grey)	2L + 2H
RX609 Interlock & jamb seal	12H
RX611 FSD Track seal	2L + 4H
RX612 Bottom frame seal	2L
RX614 Head seal	L
RX615 Bottom carrier seal	L
RX616 Top bogie corner mould	1
RX617A Top corner mould	5
RX618 Bottom bogie corner mould	1
RX619A Bottom corner mould	5
RX640 Push in flipper gasket	2H
RX641 Outer frame finishing trim	2H
RX757 Keep packer	H1



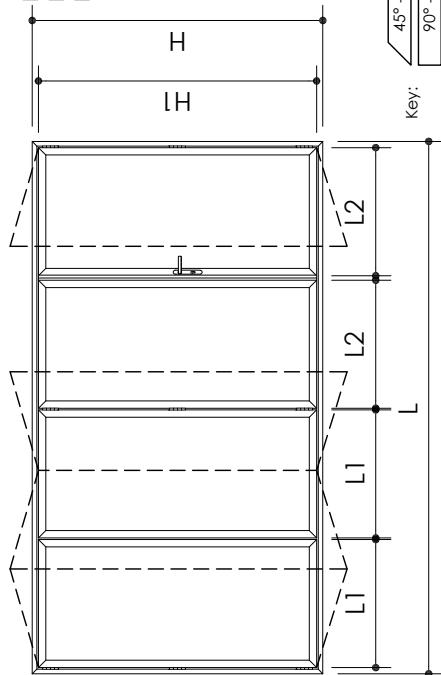
PROFILE		NO.	SIZE
P-06-100	Outerframe	2	H
P-06-100	Outerframe	2	L
P-06-202	Sash (L1)	4	L1
P-06-202	Sash (L2)	4	L2
P-06-202	Sash (H1)	8	H1
P-00-210	Rebate adaptor	1	H - 92
P-00-210	Rebate adaptor	1	H - 122
N60630	Threshold adaptor (L1)	4	L1
N60630	Threshold adaptor (L2)	4	L2
AW660	28mm Bead (L1)	4	L1 - 94
AW660	28mm Bead (L2)	4	L2 - 94
AW660	28mm Bead (H1)	8	H1 - 128.5
TW118	Drip bar	1	L
GLASS	NO.	WIDTH	HEIGHT
Glass unit 28mm	2	L1 - 104	H1 - 104
Glass unit 28mm	2	L2 - 104	H1 - 104

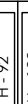
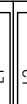
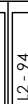
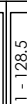


$$L1, L2 \text{ EQ.} = (L - 143.5) / 3$$

$$L1 = (L - 143.5 - 2L2) / 2$$

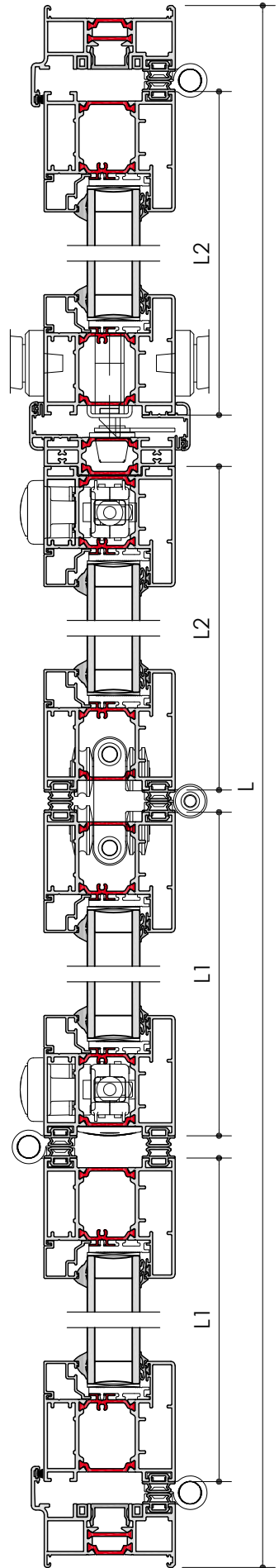
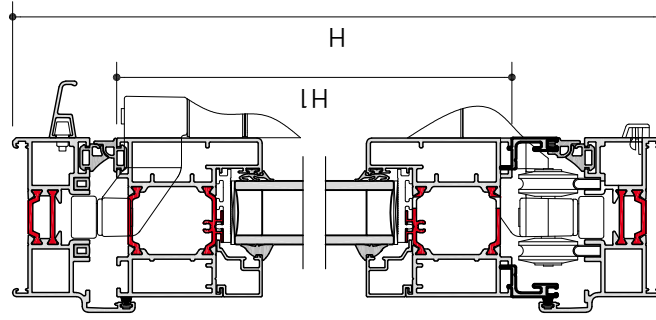
$$H1 = H - 112$$



PROFILE		NO.	SIZE
P-06-100	Outerframe	2	
P-06-100	Outerframe	2	
P-06-202	Sash (L1)	4	
P-06-202	Sash (L2)	4	
P-06-202	Sash (H1)	8	
P-06-301	Slave door adaptor	1	
P-00-210	Rebate adaptor	1	
P-00-210	Rebate adaptor	1	
N60630	Threshold adaptor (L1)	4	
N60630	Threshold adaptor (L2 traffic)	2	
N60630	Threshold adaptor (L2 slave)	2	
AW660	28mm Bead (L1)	4	
AW660	28mm Bead (L2)	2	
AW660	28mm Bead (H1)	6	
TW118	Drip bar	1	
GLASS		NO.	WIDTH
Glass unit 28mm		2	L1 - 104
Glass unit 28mm		2	L2 - 104
			H1 - 104

HARDWARE		
RX180	Lever - lever handle	1
RX194	45/45 Standard cylinder	1
RX701A	Top bogie	1
RX702A	Bottom bogie	1
RX703A	Hinge	10
RX710	Shootbolt pack	2
RX730 - 731	T handle / T locking handle	2
RX740 - 741	Replacement / spare locking T handle keys	1
RX780LH/RH	Winkhaus traffic door lock	1
RX781LH/RH	Winkhaus centre keep	1
RX782	Winkhaus top / bottom keep	2
ACCESSORIES		
A-00-100	Mechanical cleat tensioning block	NO. 40
RX16	Drip bar rivet	8
RX600	18.9mm Mechanical cleat	8
RX601	13.7mm Mechanical cleat	32
RX610	6.5m FSD SS Track	2
RX720	Traffic door magnet	1
RX756	Bridge packer	8 Min.
RX770	P-00-210 End caps	2 Pair
RX904	Narrow chevron	8
RX916	Drain hole cover	8
GASKET / PLASTIC PROFILES		
A-GS-240	Slide in E gasket	NO. 4L1 + 4L2 + 8H1
A-GS-302 - 308	Internal glazing gasket	4L1 + 4L2 + 8H1
A-GS-504	Push in E gasket	4L1 + 4L2 + 8H1
PX302	4.8mm 825 WF Woolpile (grey)	2L + 2H
RX609	Interlock & jamb seal	12H
RX611	FSD Track seal	2L + 4H
RX612	Bottom frame seal	2L
RX614	Head seal	L
RX615	Bottom carrier seal	L
RX616	Top bogie corner mould	1
RX617A	Top corner mould	5
RX618	Bottom bogie corner mould	1
RX619A	Bottom corner mould	5
RX640	Push in flipper gasket	2H
RX641	Outer frame finishing trim	2H

Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
End mill cutter - BSD703
Press tool - BSD706

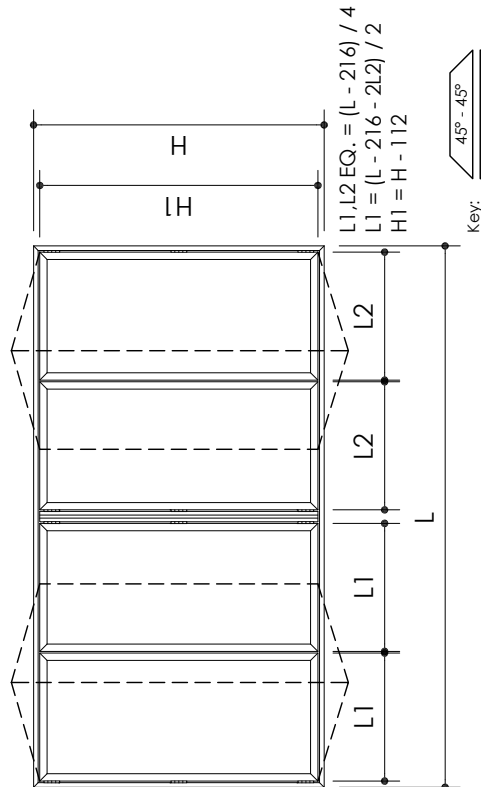


CUTTING LIST

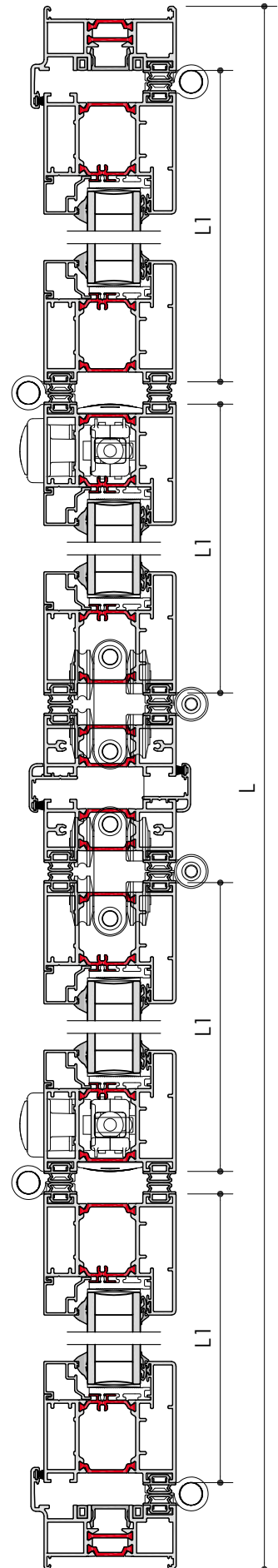
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OPEN OUT/OPEN IN
4-2-2

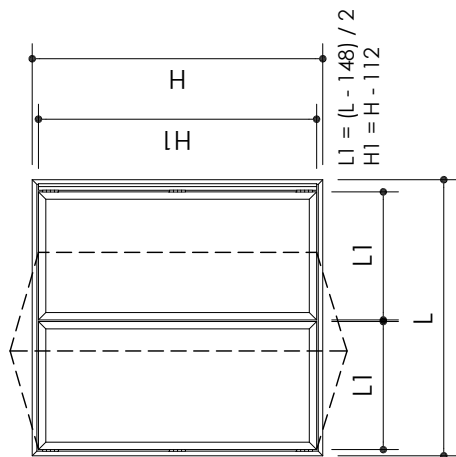
Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
End mill cutter - BSD703
Press tool - BSD706

HARDWARE		NO.
RX701A	Top bogie	2
RX702A	Bottom bogie	2
RX703A	Hinge	14
RX710	Shootbolt pack	2
RX730 - 731	T handle / T locking handle	2
RX740 - 741	Replacement / spare locking T handle keys	1
ACCESSORIES		NO.
A-00-100	Mechanical cleat tensioning block	40
RX16	Drip bar rivet	8
RX600	18.9mm Mechanical cleat	8
RX601	13.7mm Mechanical cleat	32
RX610	6.5m FSD SS Track	2
RX704	Floating mullion block	4
RX756	Bridge packer	8 Min.
RX770	P-00-210 End caps	2 Pair
RX775	Anti twist guide	4
RX904	Narrow chevron	8
RX916	Drain hole cover	8
GASKET / PLASTIC PROFILES		NO.
A-GS-240	Slide in E gasket	4L1 + 4L2 + 8H1
A-GS-304 - 308	Internal glazing gasket	4L1 + 4L2 + 8H1
A-GS-504	Push in E gasket	4L1 + 4L2 + 8H1
PX302	4.8mm 825 WF Woolpile (grey)	2L + 4H
RX609	Interlock & jamb seal	20H
RX611	FSD Track seal	2L + 4H
RX612	Bottom frame seal	2L
RX614	Head seal	L
RX615	Bottom carrier seal	L
RX616	Top bogie corner mould	2
RX617A	Top corner mould	8
RX618	Bottom bogie corner mould	2
RX619A	Bottom corner mould	8
RX641	Outer frame finishing trim	2H



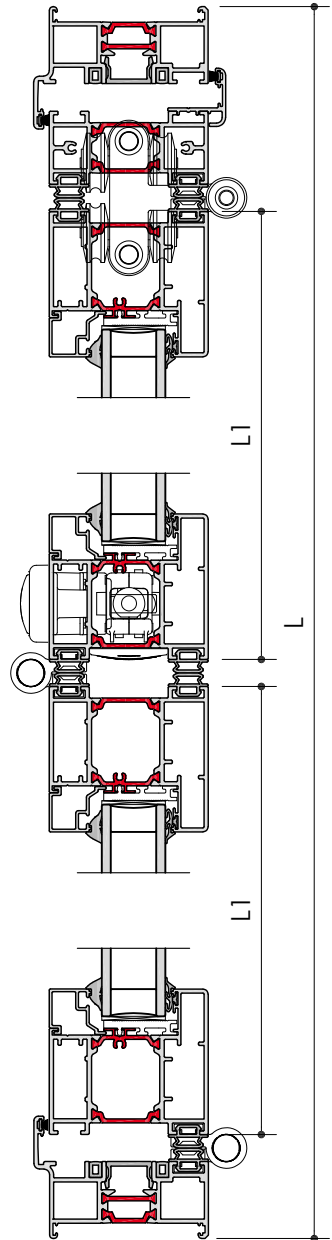
PROFILE	NO.	SIZE
P-06-100	2	H
P-06-100	2	L
P-06-202	4	L1
P-06-202	4	L2
P-06-202	8	H1
P-06-300	1	H1
P-00-210	1	H - 92
P-00-210	1	H - 122
N60630	4	L1
N60630	2	32mm
AW660	4	L1 - 94
AW660	8	H1 - 128.5
TW118	1	L
GLASS		HEIGHT
Glass unit 28mm	2	H1 - 104
Glass unit 28mm	2	H1 - 104





Key:
45° - 45°
90° - 90°

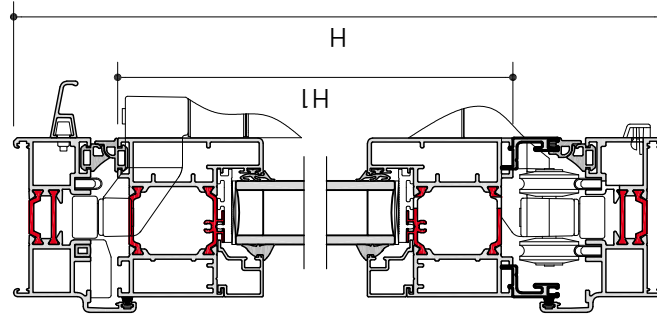
PROFILE	NO.	SIZE
P-06-100	2	H
P-06-100	2	L
P-06-202	4	L1
P-06-202	4	H1
P-06-300	1	H1
P-00-210	1	H - 92
N60630	4	L1
N60630	2	32mm
AW660	4	L1 - 94
AW660	4	H1 - 128.5
TW118	1	L
GLASS Glass unit 28mm	2	HEIGHT H1 - 104
		WIDTH L1 - 104



CUTTING LIST

BSF70
OPEN OUT
PAS24 2-2-0

Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
End mill cutter - BSD703
Press tool - BSD706

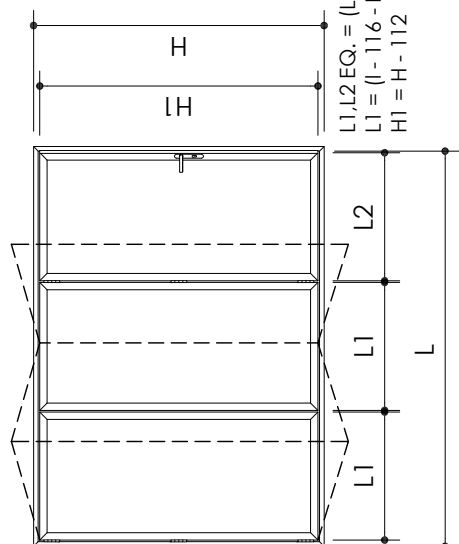


HARDWARE	NO.
RX051 PAS24 Anti-jimmy block	1
RX701A Top bogie	1
RX702A Bottom bogie	1
RX703A Hinge	7
RX710 Shootbolt pack	1
RX731 Locking handle	1
RX740 - 741 Replacement / spare locking T handle keys	1
ACCESSORIES	NO.
A-00-100 Mechanical cleat tensioning block	24
RX116 Drip bar rivet	4
RX600 18.9mm Mechanical cleat	8
RX601 13.7mm Mechanical cleat	16
RX610 6.5m FSD SS Track	2
RX704 Floating mullion block	2
RX756 Bridge packer	4 Min.
RX770 P-00-210 End caps	1 Pair
RX775 Anti twist guide	2
RX904 Narrow chevron	8
RX916 Drain hole cover	4
GASKET / PLASTIC PROFILES	NO.
A-GS-240 Slide in E gasket	4L1 + 4H1
A-GS-304 - 308 Internal glazing gasket	4L1 + 4H1
A-GS-504 Push in E gasket	4L1 + 4H1
PX302 4.8mm 825 WF Woolpile (grey)	2L + 3H
RX016 Reinforced track insert	3
RX609 Interlock & jamb seal	10H
RX611 FSD Track seal	2L + 4H
RX612 Bottom frame seal	2L
RX614 Head seal	L
RX615 Bottom carrier seal	L
RX616 Top bogie corner mould	1
RX617A Top corner mould	4
RX618 Bottom bogie corner mould	1
RX619A Bottom corner mould	4
RX641 Outer frame finishing trim	2H

CUTTING LIST

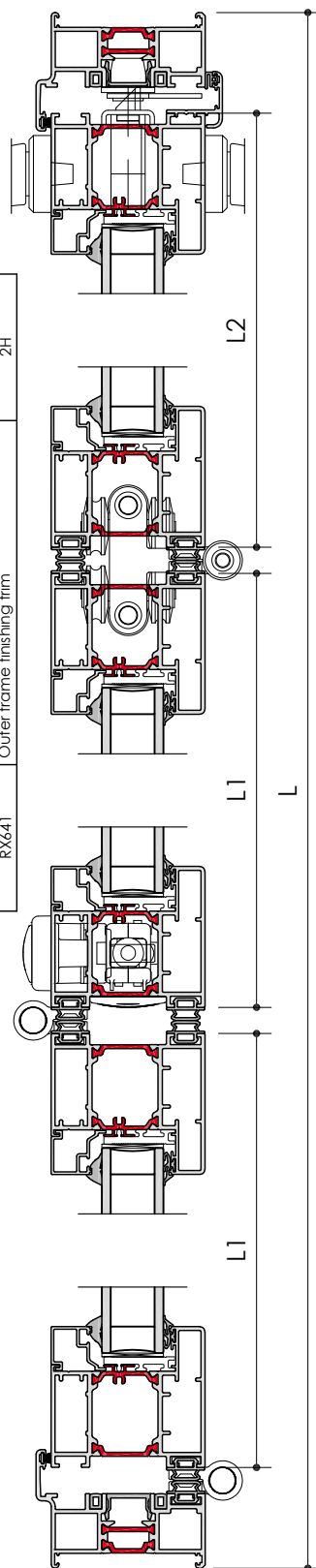
BSF70
OPEN OUT
PAS24 3-3-0

Tooling:
Hinge jig - BSD635
Hinge jig - BSD636
Hinge jig - BSD637
Router plate - BSD638
Press tool - BSD706



Key: 45° - 45° 90° - 90°	PROFILE			NO.	SIZE
	P-06-100	Outerframe		2	H
	P-06-100	Outerframe		2	L
	P-06-202	Sash (L1)		4	L1
	P-06-202	Sash (L2)		2	L2
	P-06-202	Sash (H1)		6	H1
	P-00-210	Rebate adaptor		1	H - 92
	N60630	Threshold adaptor (L1)		4	L1
	N60630	Threshold adaptor (L2)		2	L2
	AW660	28mm Bead (L1)		4	L1 - 94
	AW660	28mm Bead (L2)		2	L2 - 94
	AW660	28mm Bead (H1)		6	H1 - 128.5
GLASS	TW118	Drip bar		1	L
	NO.	WIDTH	HEIGHT		
Glass unit 28mm	2	L1 - 104	H1 - 104		
Glass unit 28mm	1	L2 - 104	H1 - 104		

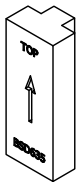
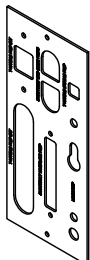
HARDWARE		NO.
RX012	PAS24 U26-952 Centre keep	1
RX014S	PAS24 40/40 Kitemark Euro double cylinder	1
RX051	PAS24 Anti-jimmy block	1
RX062	PAS24 U26-952 MV1 Hook keep	2
RX110	PAS24 AmorShield cylinder guard	1
RX180	Lever - lever handle	1
RX701A	Top bogie	1
RX702A	Bottom bogie	1
RX703A	Hinge	7
RX710	Shootbolt pack	1
RX730 - 731	T handle / T locking handle	1
RX740 - 741	Replacement / spare locking T handle keys	1
RX780LH/RH	Winkhaus traffic door lock	1
ACCESSORIES		NO.
A-00-100	Mechanical cleat tensioning block	32
RX16	Drip bar rivet	6
RX600	18.9mm Mechanical cleat	8
RX601	13.7mm Mechanical cleat	24
RX610	6.5m FSD SS Track	3
RX720	Traffic door magnet	1
RX756	Bridge packer	6 Min.
RX770	P-00-210 End caps	1 Pair
RX904	Narrow chevron	8
RX916	Drain hole cover	6
GASKET / PLASTIC PROFILES		NO.
A-GS-240	Slide in E gasket	4L1 + 2L2 + 6H1
A-GS-302 - 308	Internal glazing gasket	4L1 + 2L2 + 6H1
A-GS-504	Push in E gasket	4L1 + 2L2 + 6H1
RX016	Reinforced track insert 3.5m	4
PX302	4.8mm 825 WF Woolpile (grey)	2L + 2H
RX609	Interlock & jamb seal	10H
RX611	FSD Track seal	2L + 4H
RX612	Bottom frame seal	2L
RX614	Head seal	L
RX615	Bottom carrier seal	L
RX616	Top bogie corner mould	1
RX617A	Top corner mould	4
RX618	Bottom bogie corner mould	1
RX619A	Bottom corner mould	4
RX640	Push in flipper gasket	H
RX641	Outer frame finishing trim	2H



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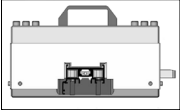
SECTION 9 MACHINING

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IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	BSD210	5 Tonne Press	-	1
	BSD635	Hinge Jig - Frame	-	1
	BSD636	Hinge Jig - Leaf top	-	1
	BSD637	Hinge Jig - Leaf bottom	-	1
	BSD638	Router plate	-	1
-	BSD703	End mill cutter - Floating mullion	-	1

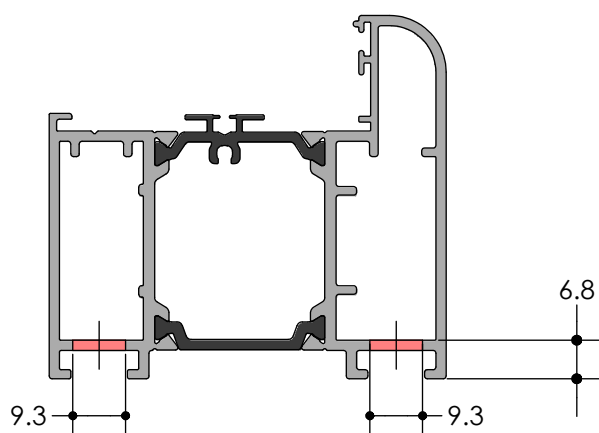
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➤ MACHINING

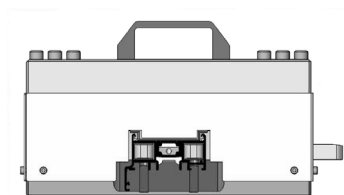
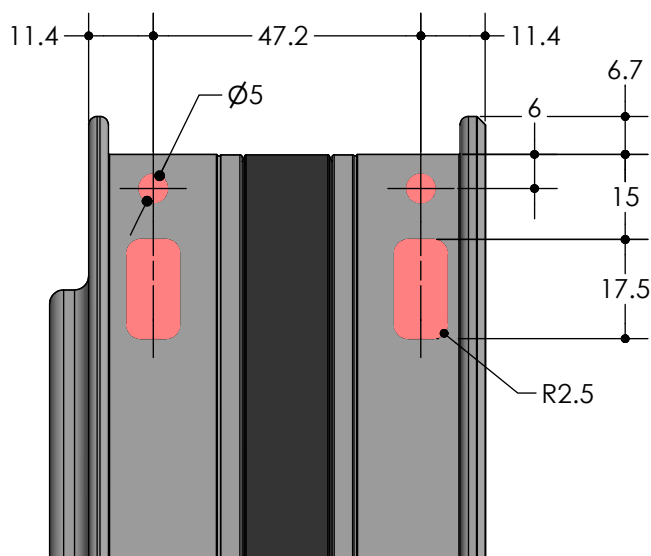
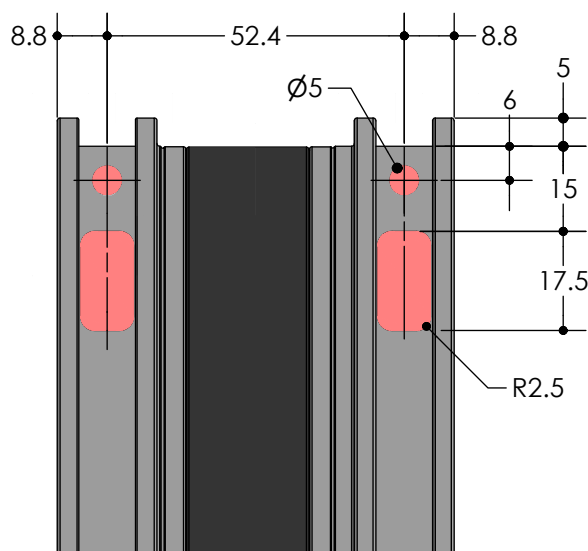
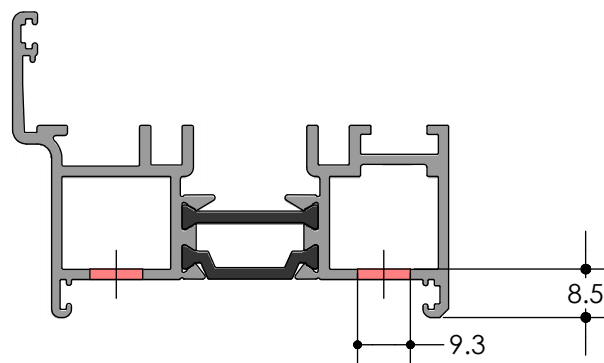
IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	BSD706	Punching Tool	-	1

MECHANICAL CLEAT PREPARATION

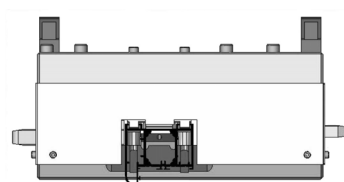
P-06-200 / P-06-202



P-06-100B



Station 1



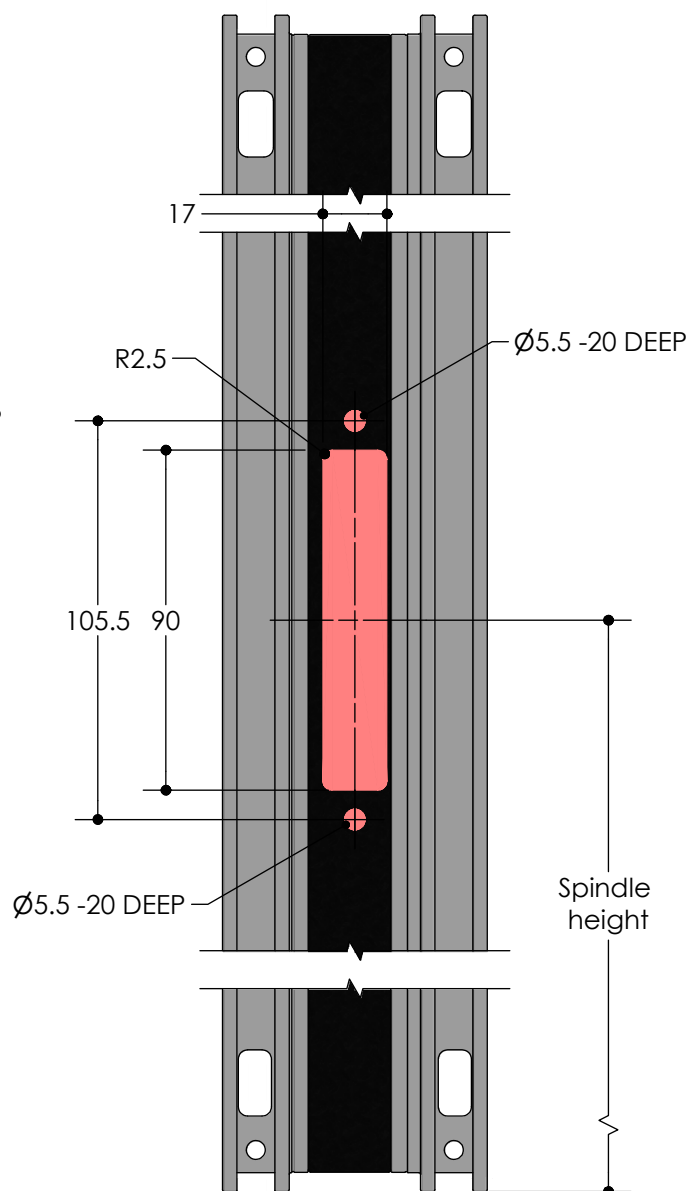
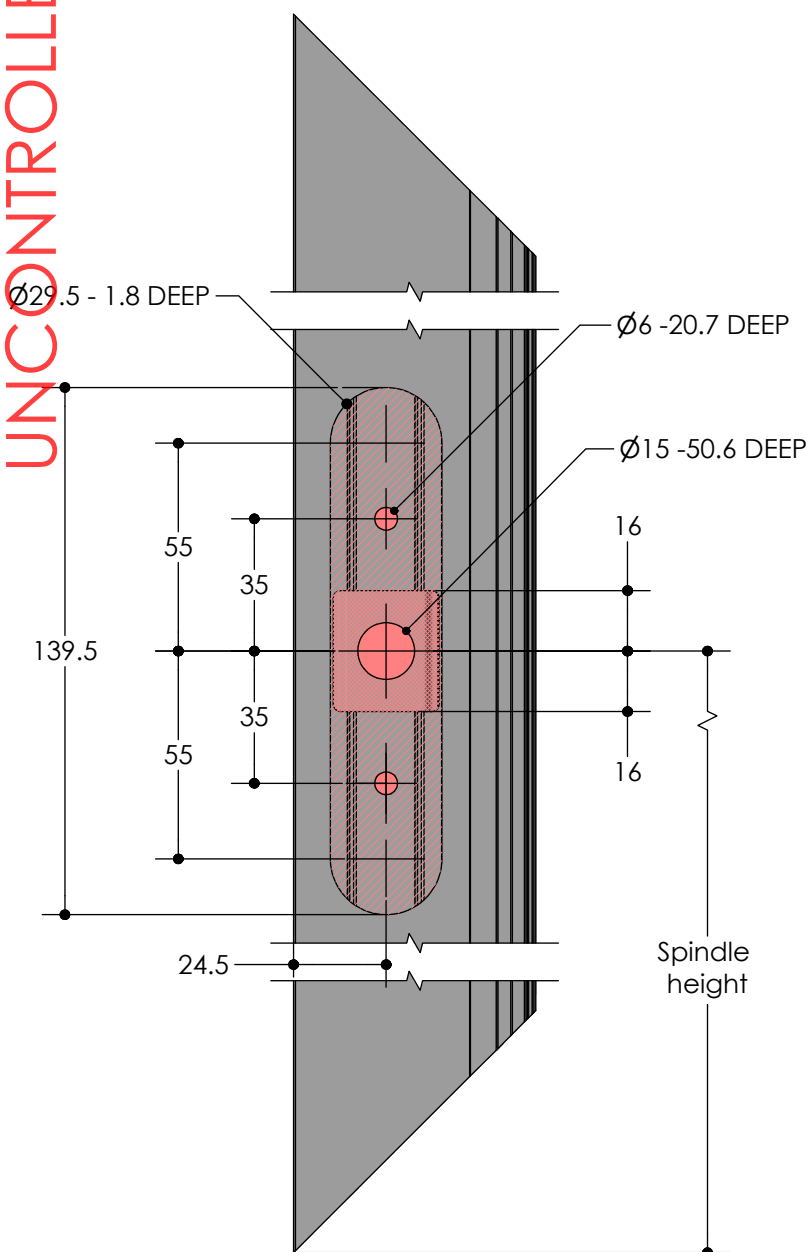
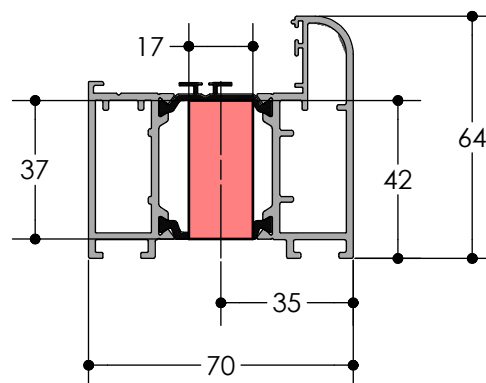
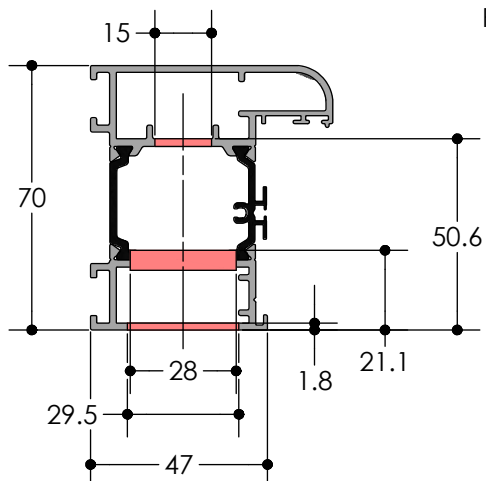
Station 2

NB: Multi-station press tool available for both frame and sash profiles (P-06-200/2 & P-06-100B).

Multi-station Press Tool
BSD706 Station 1 & 2

➤ T- HANDLE PREPARATION

P-06-200 / P-06-202



NB: Always machine the T-handle slot towards the inside of the profile. Router Plate Number BSD 638

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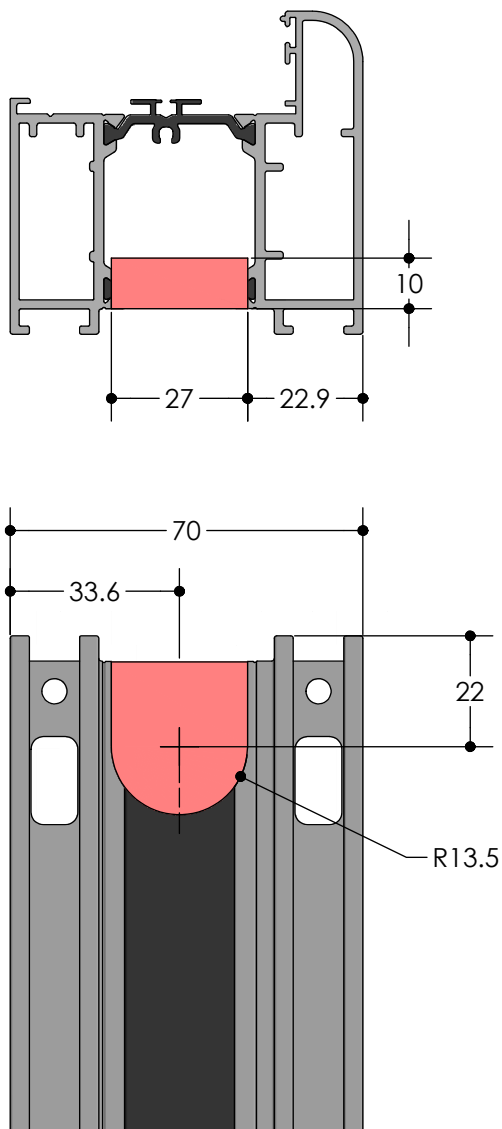
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SHOOTBOLT PREPARATION

P-06-200 / P-06-202

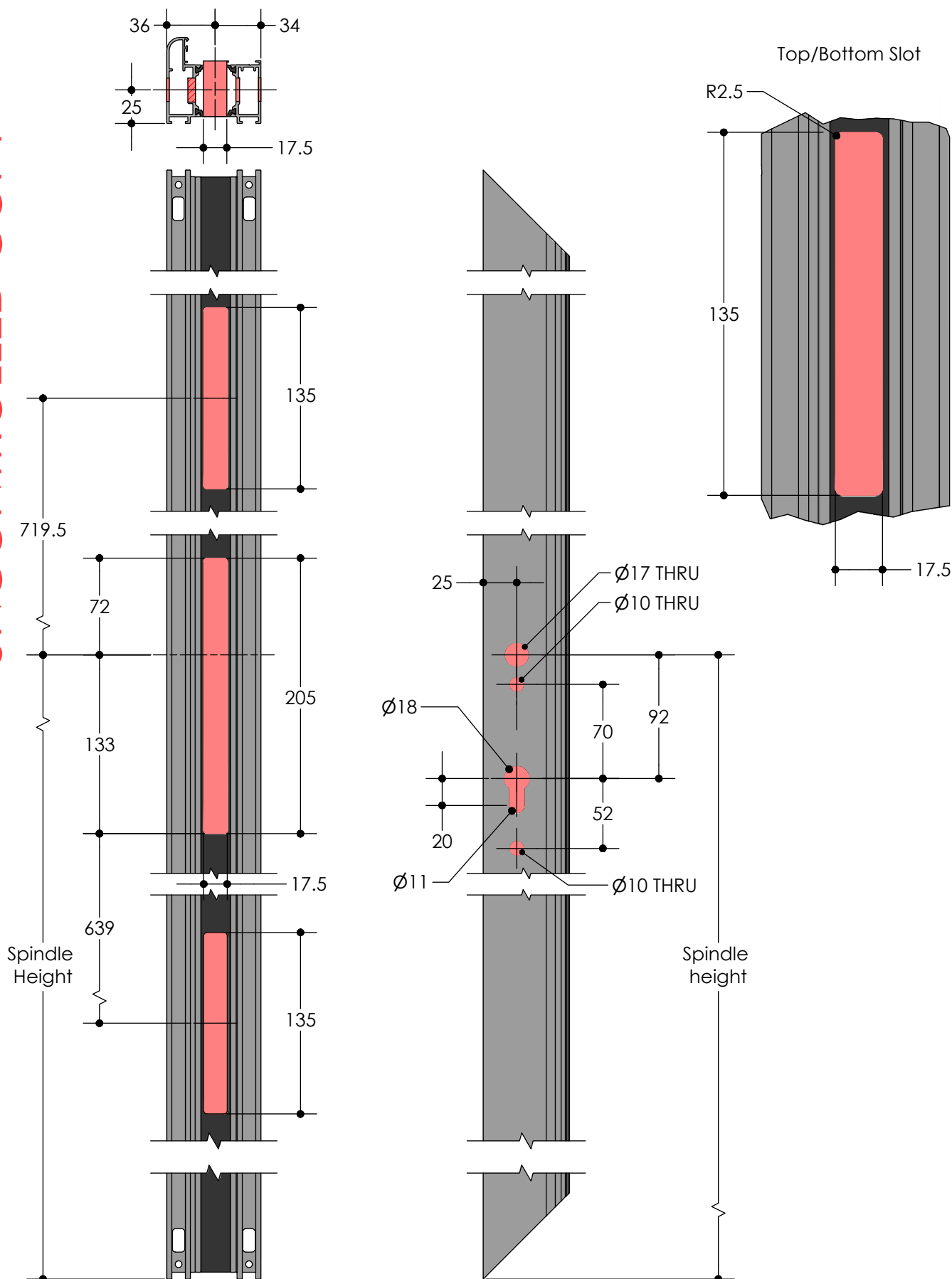


Only machine the top and bottom rails of each lockable sash.

NB: Preparation can also be routed as a rectangle i.e. 17mm x 33.5mm.
Router Plate Number BSD 638

TRAFFIC DOOR LOCK

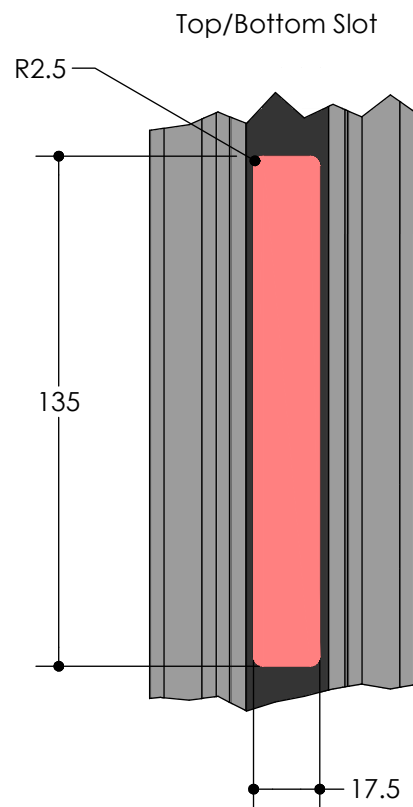
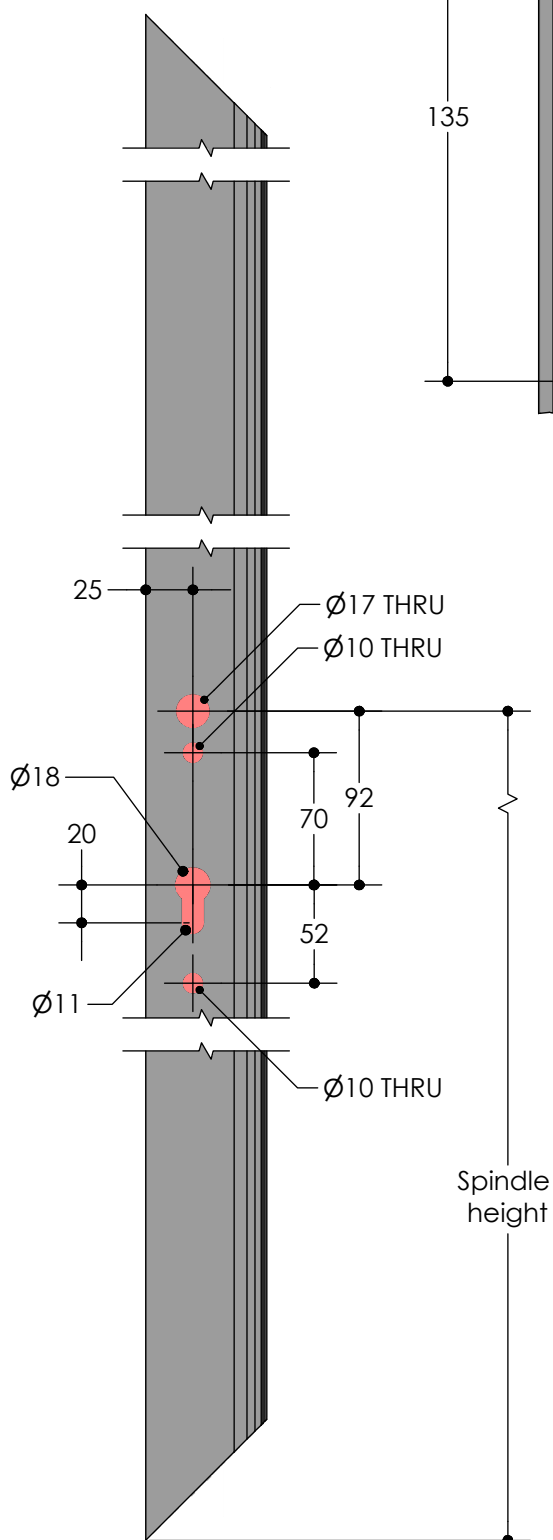
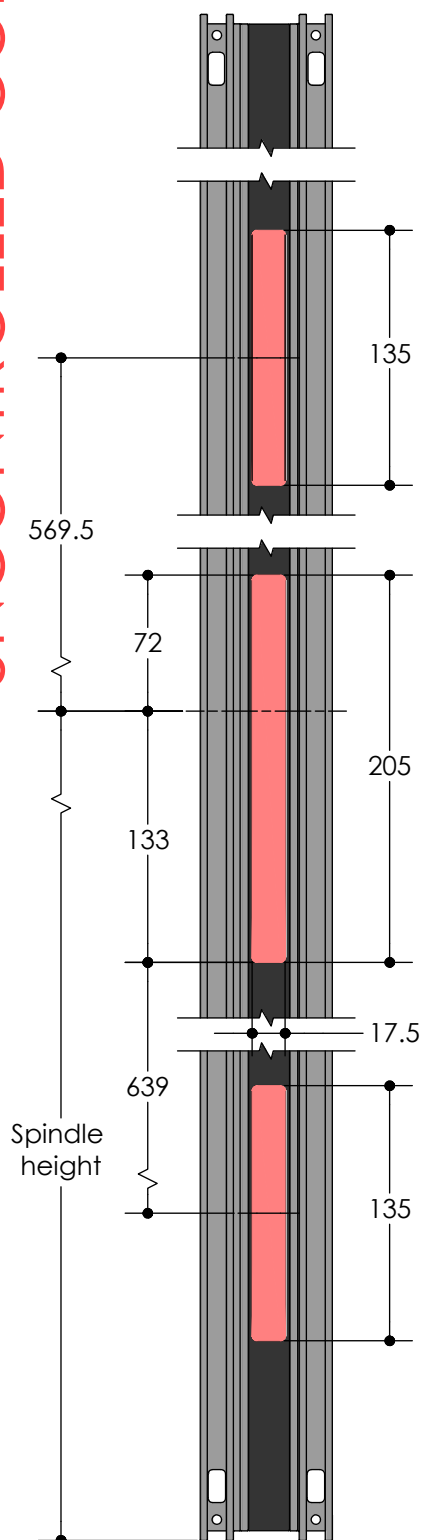
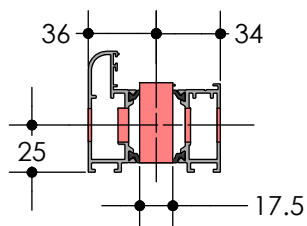
P-06-200 / P-06-202



NB: Router Plate Number BSD 638

▶ SHORT TRAFFIC DOOR LOCK

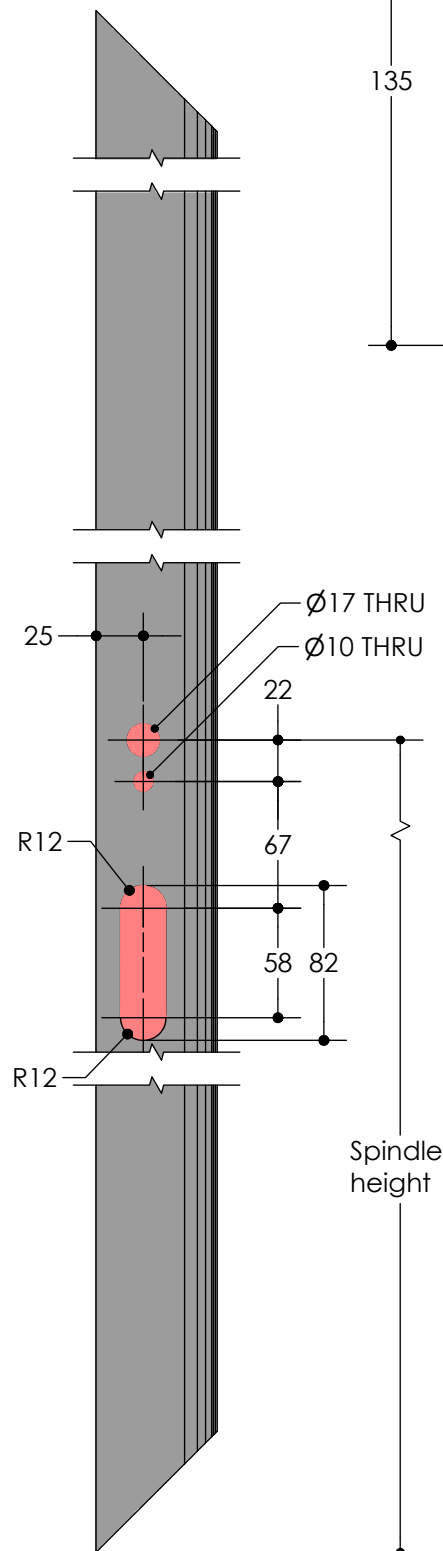
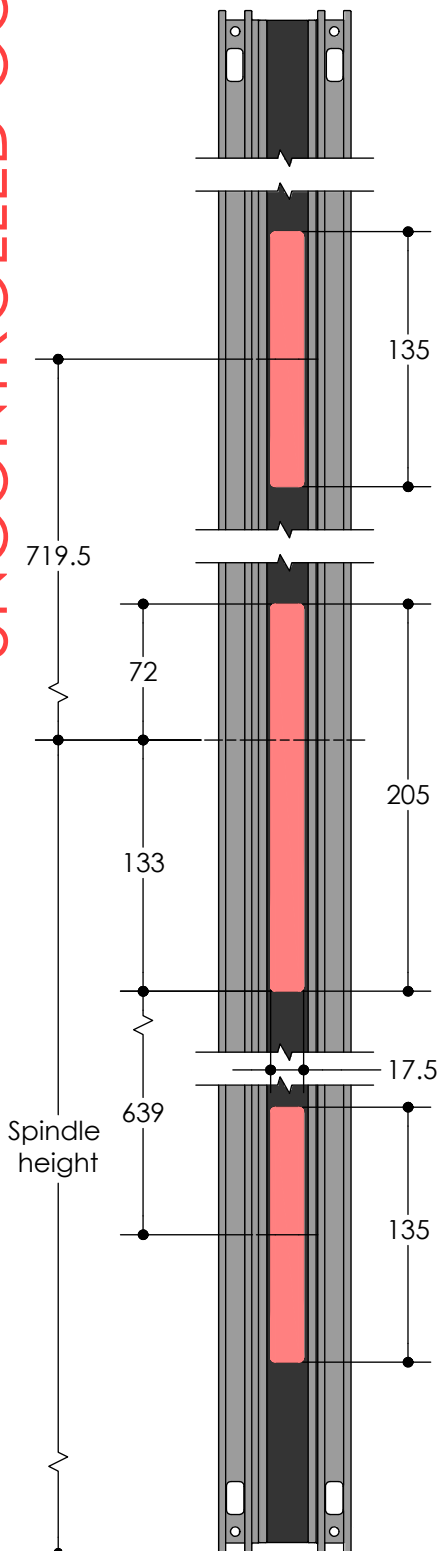
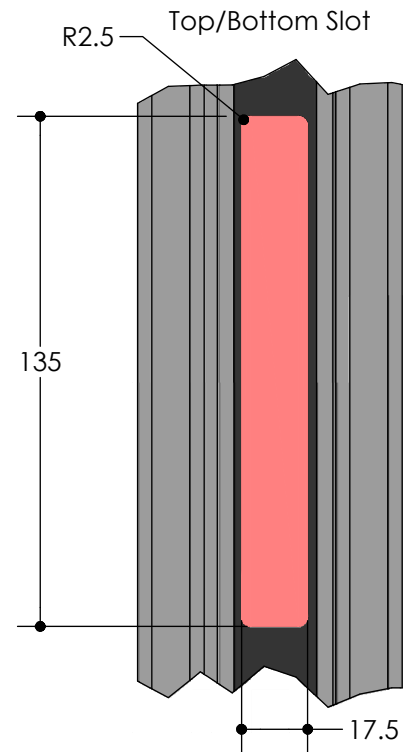
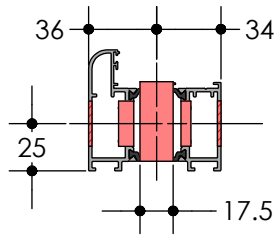
P-06-200 / P-06-202



NB: Router Plate Number BSD 638

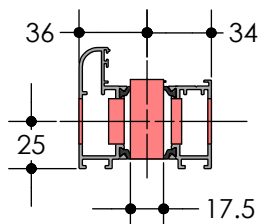
TRAFFIC DOOR LOCK (PAS 24)

P-06-200 / P-06-202

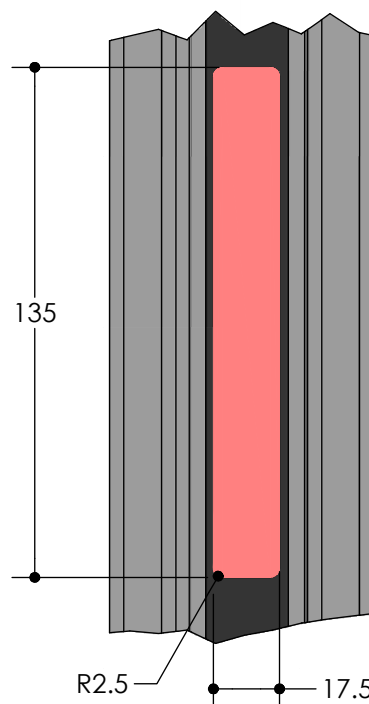


► SHORT TRAFFIC DOOR LOCK (PAS 24)

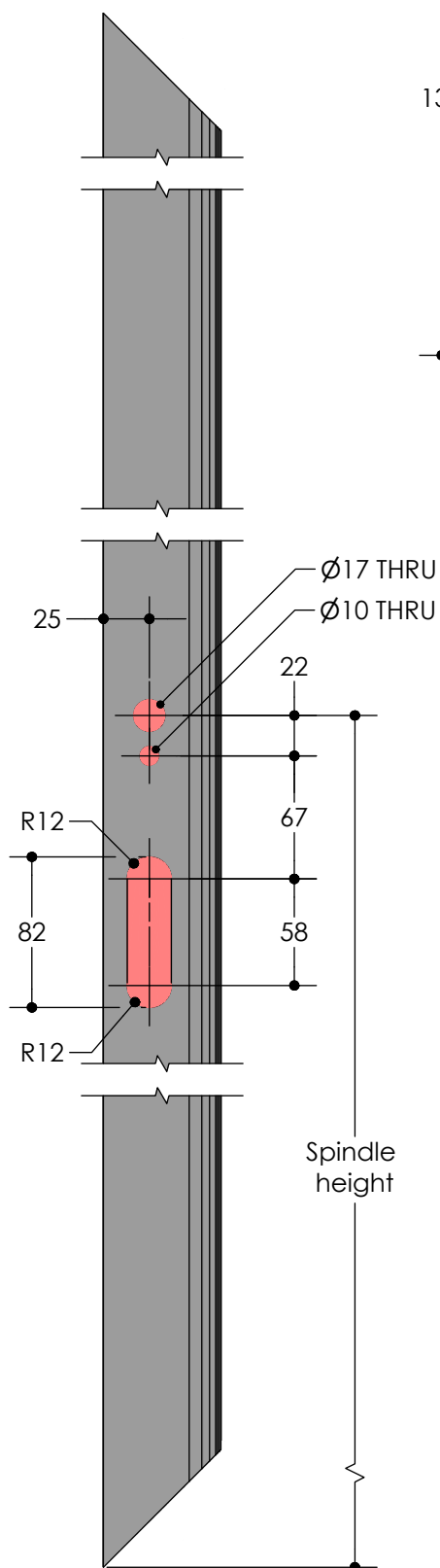
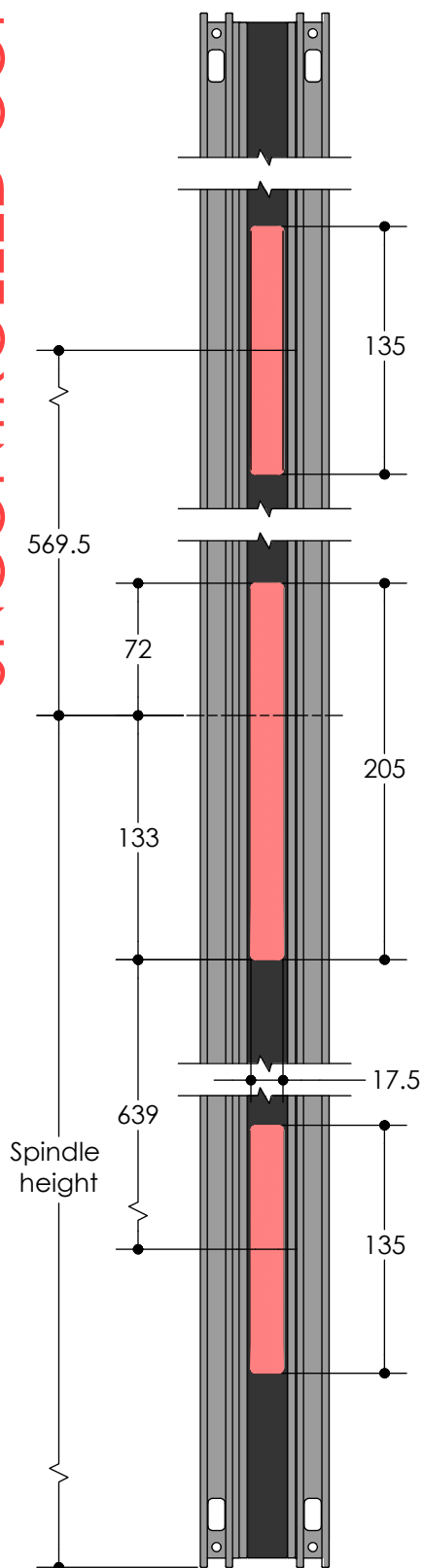
P-06-200 / P-06-202



Top/Bottom Slot

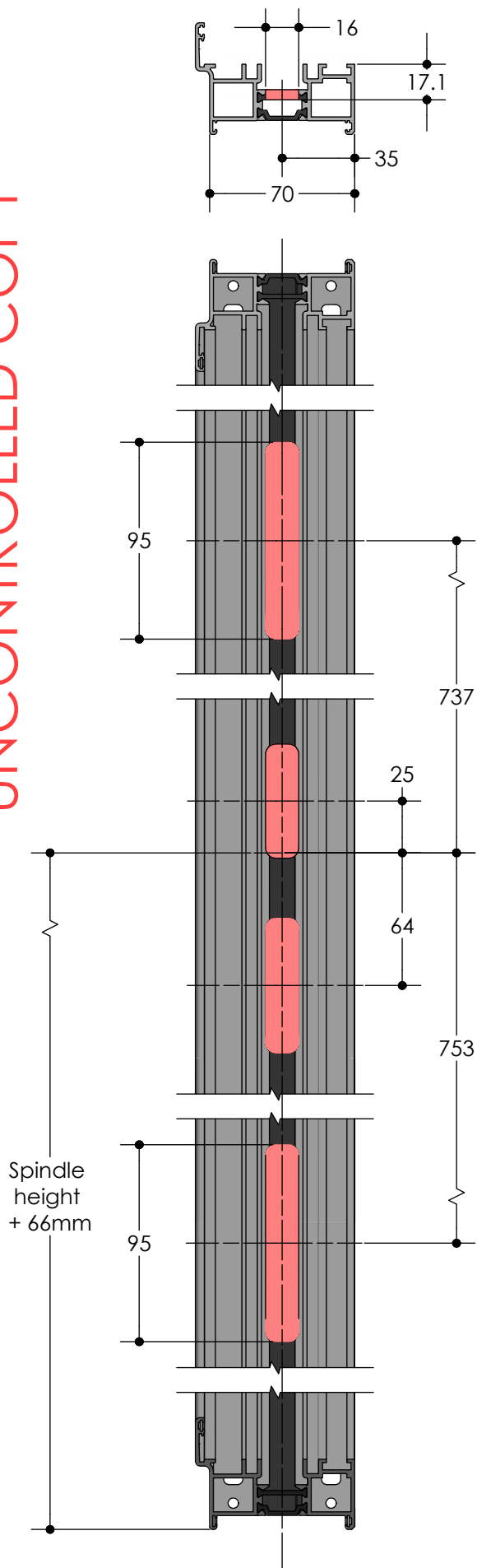


UNCONTROLLED COPY

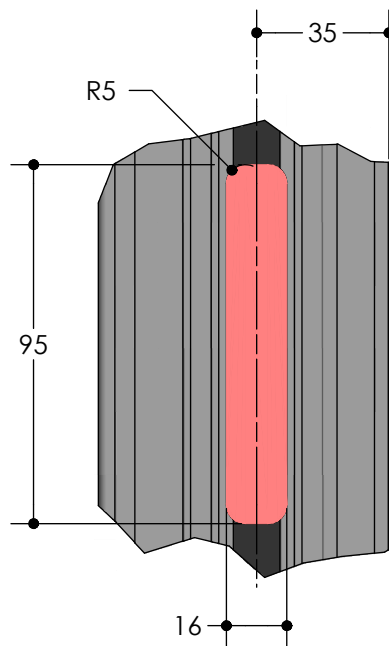


KEEP PREPARATION

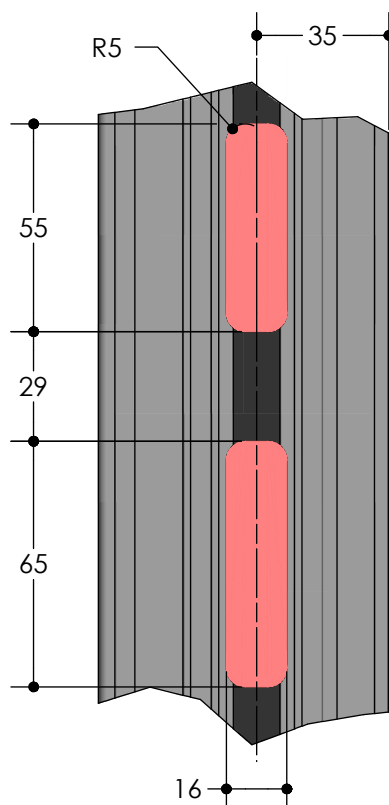
P-06-100B



Top / Bottom Keeps

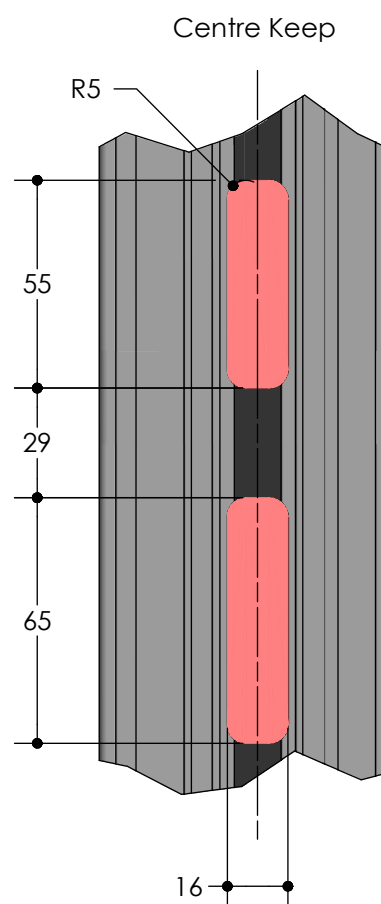
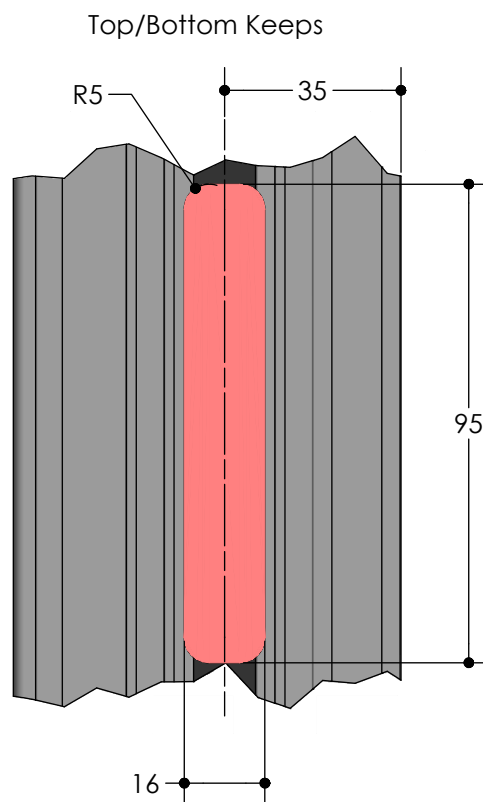
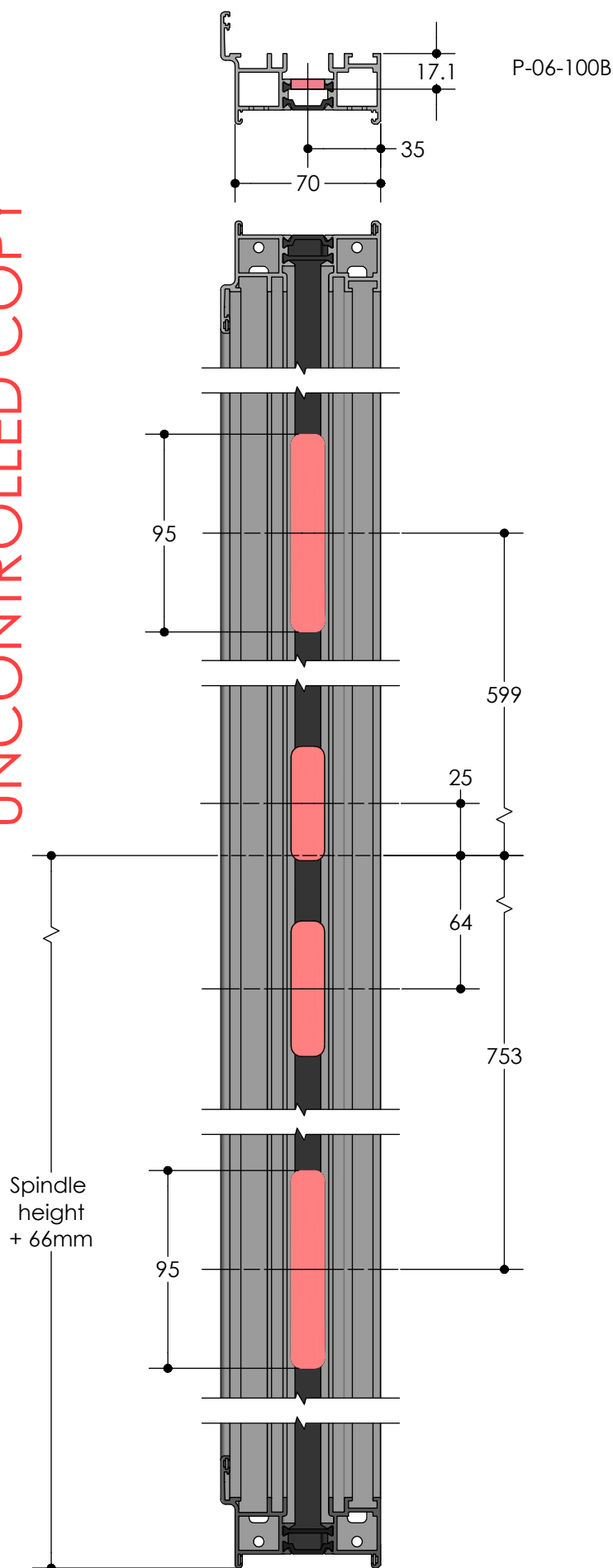


Centre Keep



NB: Machine slot through one wall only.

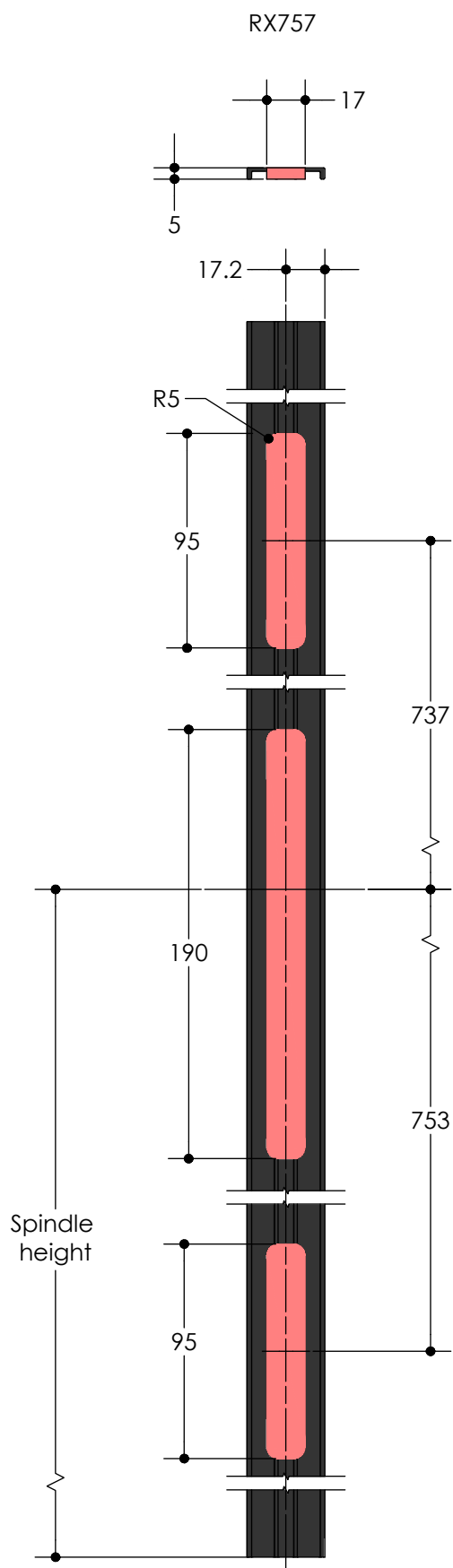
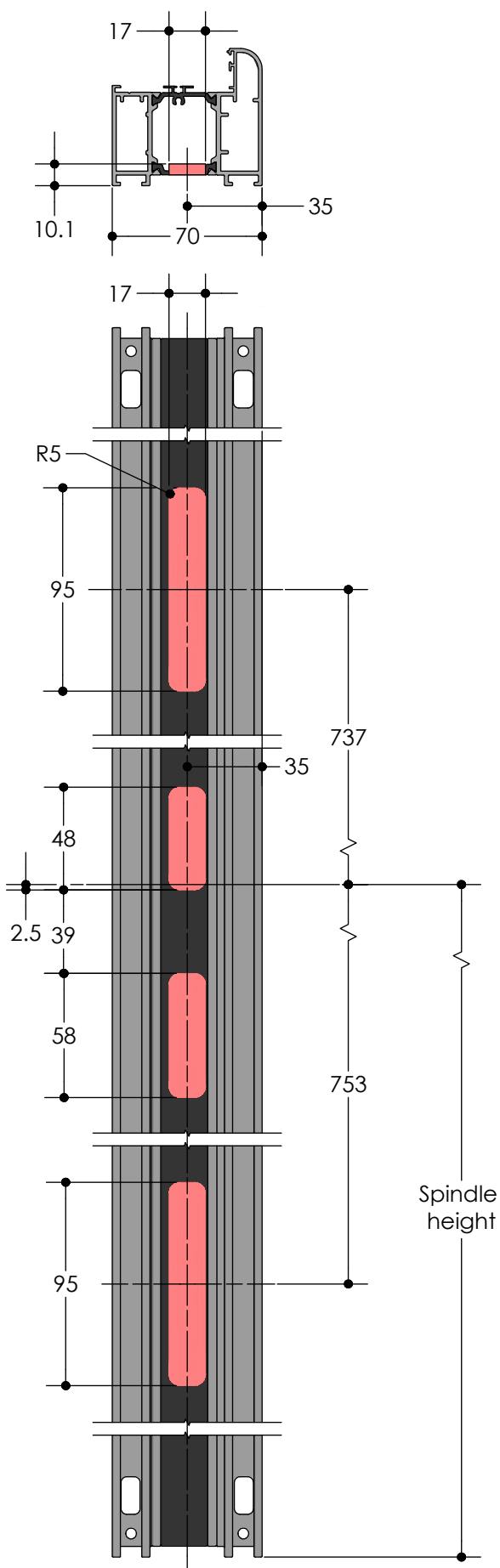
➤ SHORT LOCK KEEP PREPARATION



NB: Machine slot through one wall only.

KEEP PREPARATION

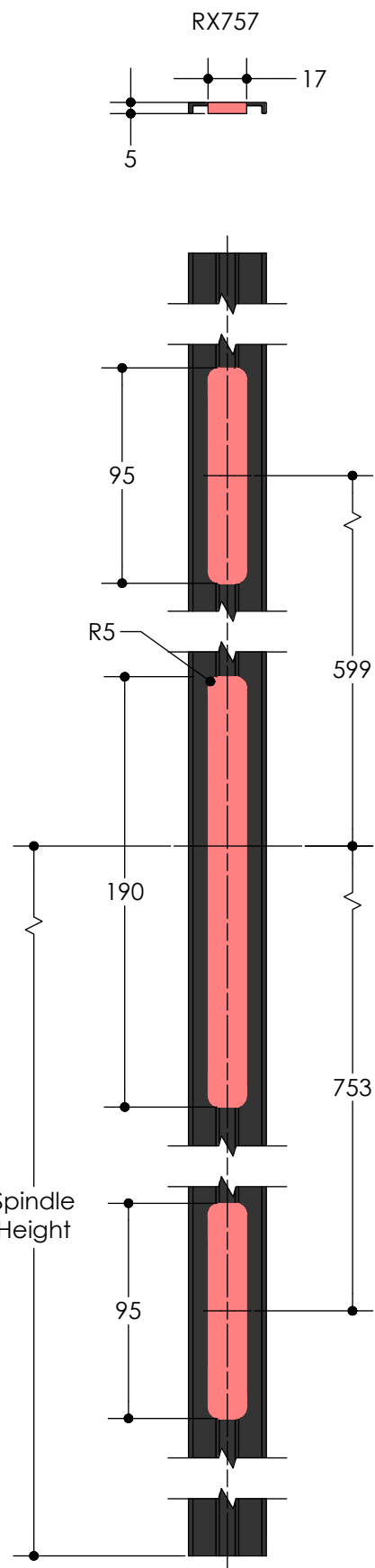
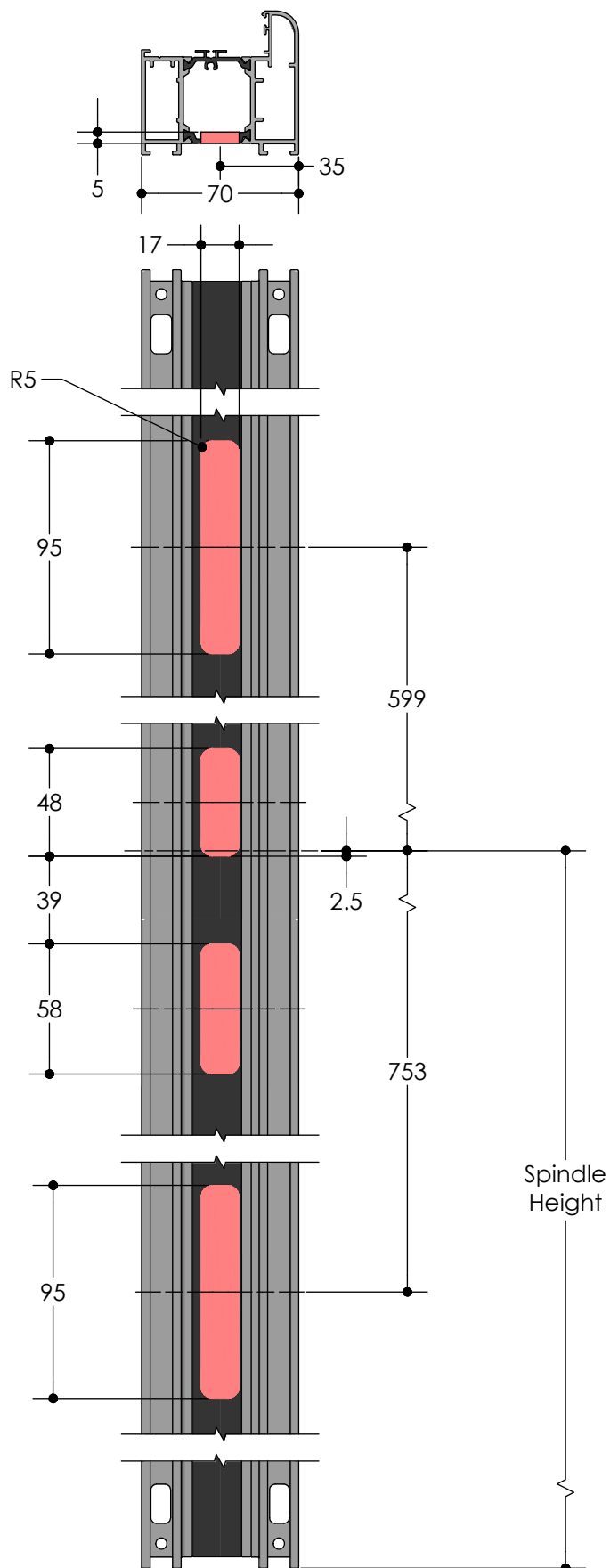
P-06-200/P-06-202/P-06-300/P-06-301



NB: Machine slot through one wall only.

► SHORT LOCK KEEP PREPARATION

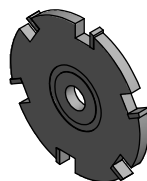
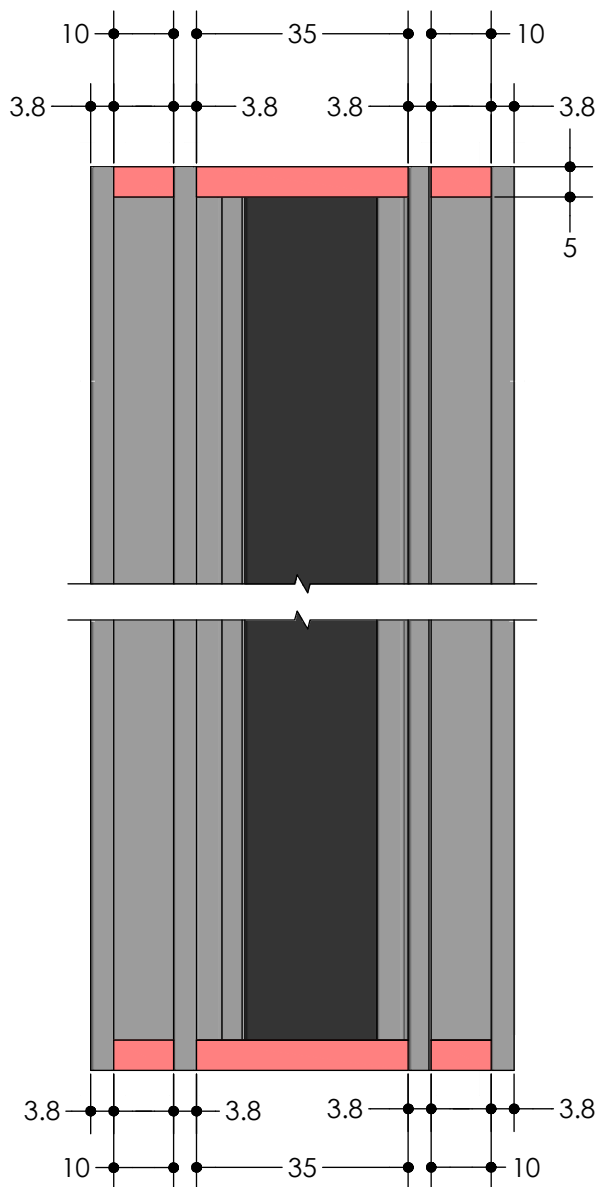
P-06-200/P-06-202/P-06-300/P-06-301



NB: Machine slot through one wall only.

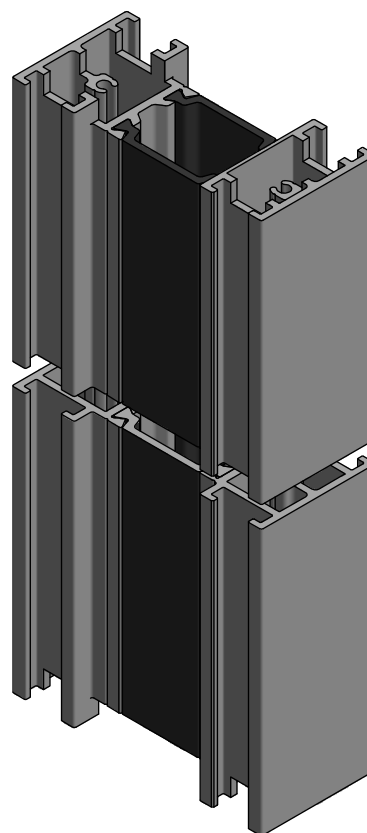
END MILL PREPARATION

P - 06 - 300



NB: End mill cutters available, please contact ALUK for further details (P-06-300).

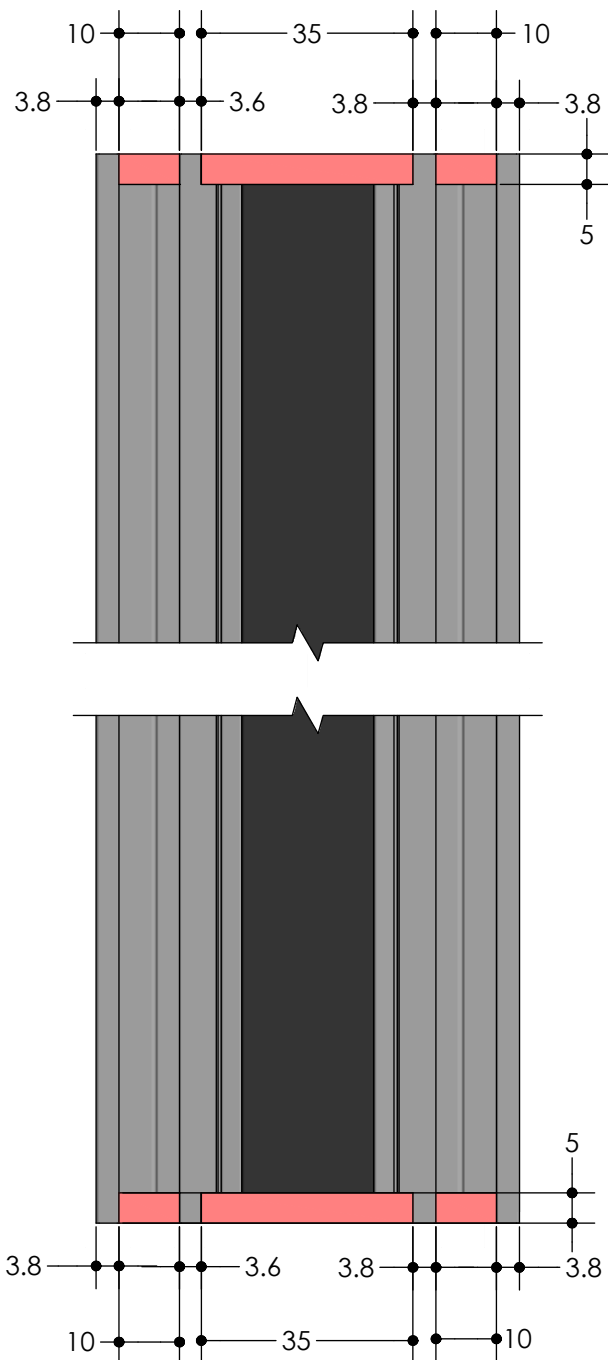
FSD End Mill Tool - BSD703



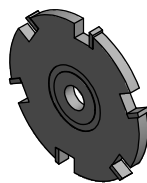
P-06-300 to be end milled at both ends using BSD 703.

END MILL PREPARATION

P - 06 - 301

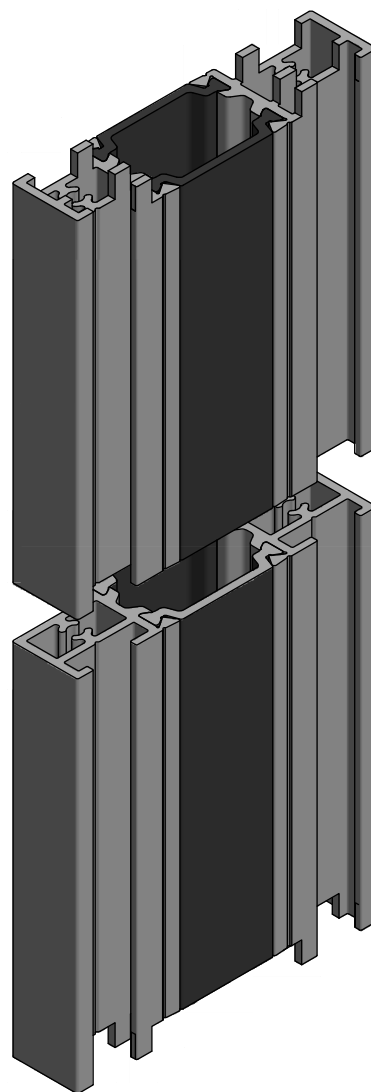


P - 06 - 301 to be end milled at both ends using BSD 703.



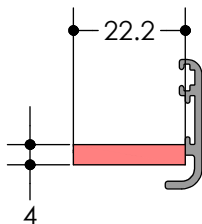
NB: End mill cutters available, please contact ALUK for further details (P-06-300).

FSD End Mill Tool - BSD703



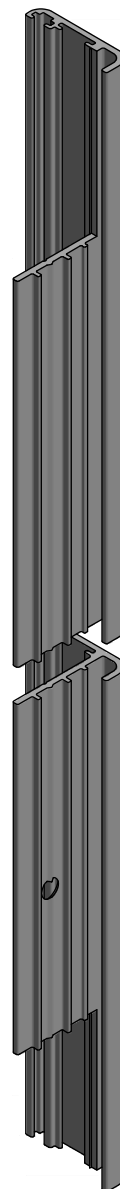
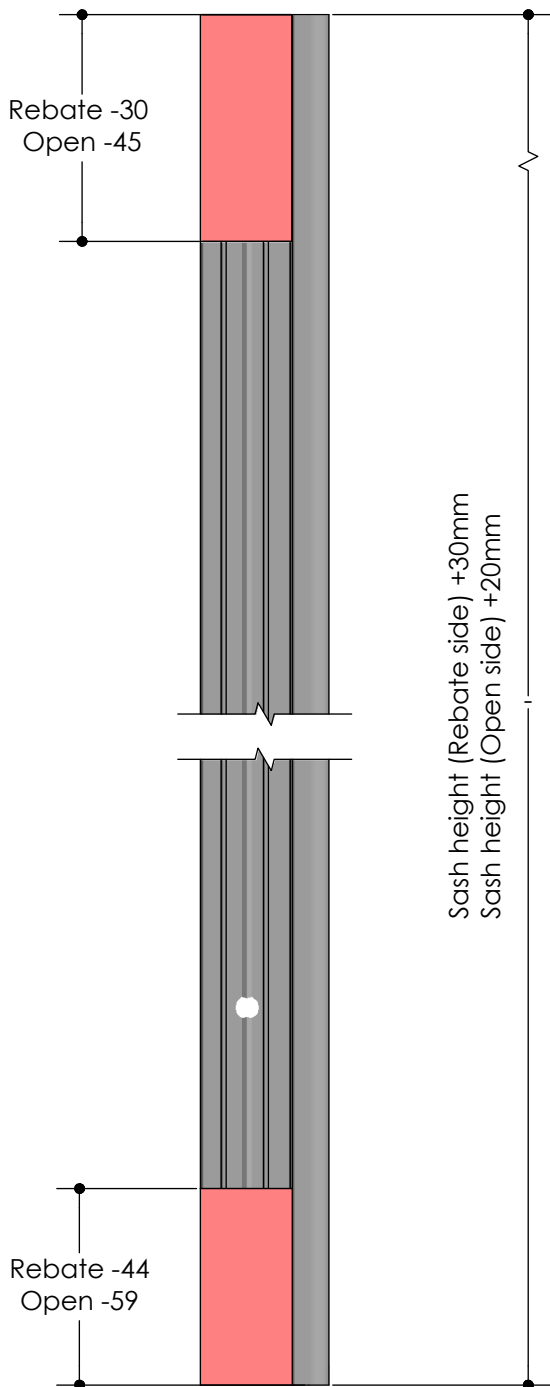
➤ END MILL/NOTCH (TRAFFIC DOOR)

P-00-210



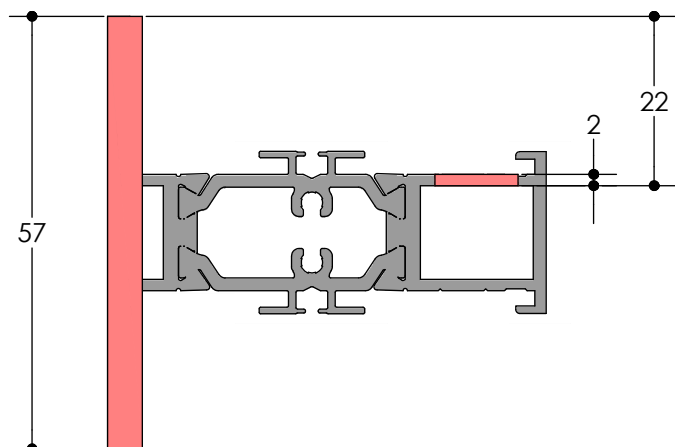
End mill P-00-210 at top and bottom of each traffic door and floating mullion.

NB: Notch to allow for left and right hand corner moulds, RX616 / RX617 / RX618 and RX619.

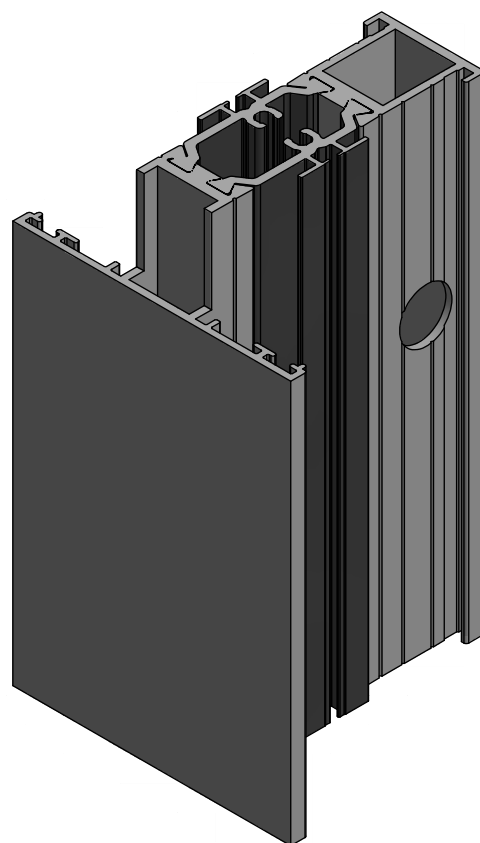
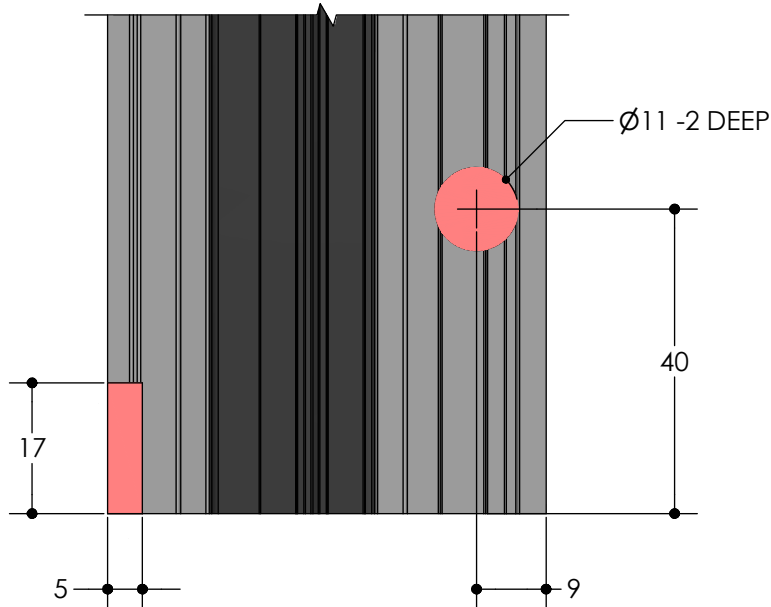
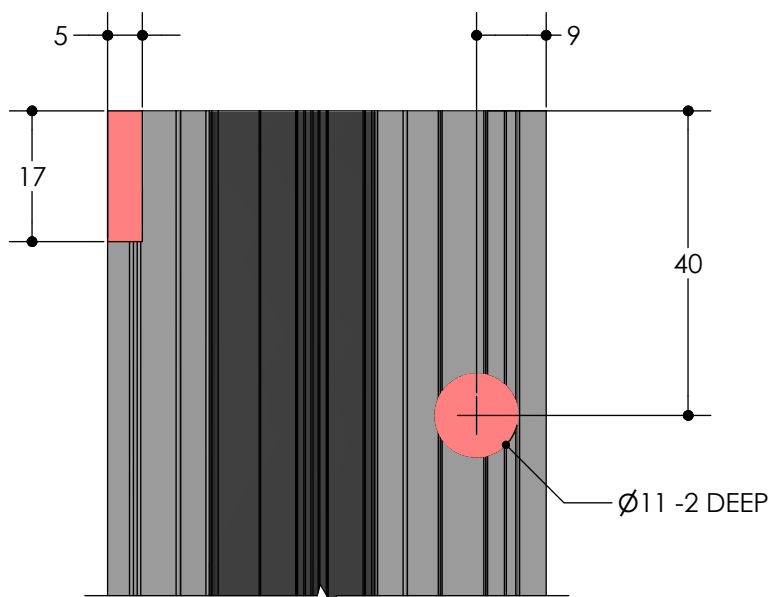


➤ AD306 TRANSOM/MIDRAIL PREP

AD306 END PREP

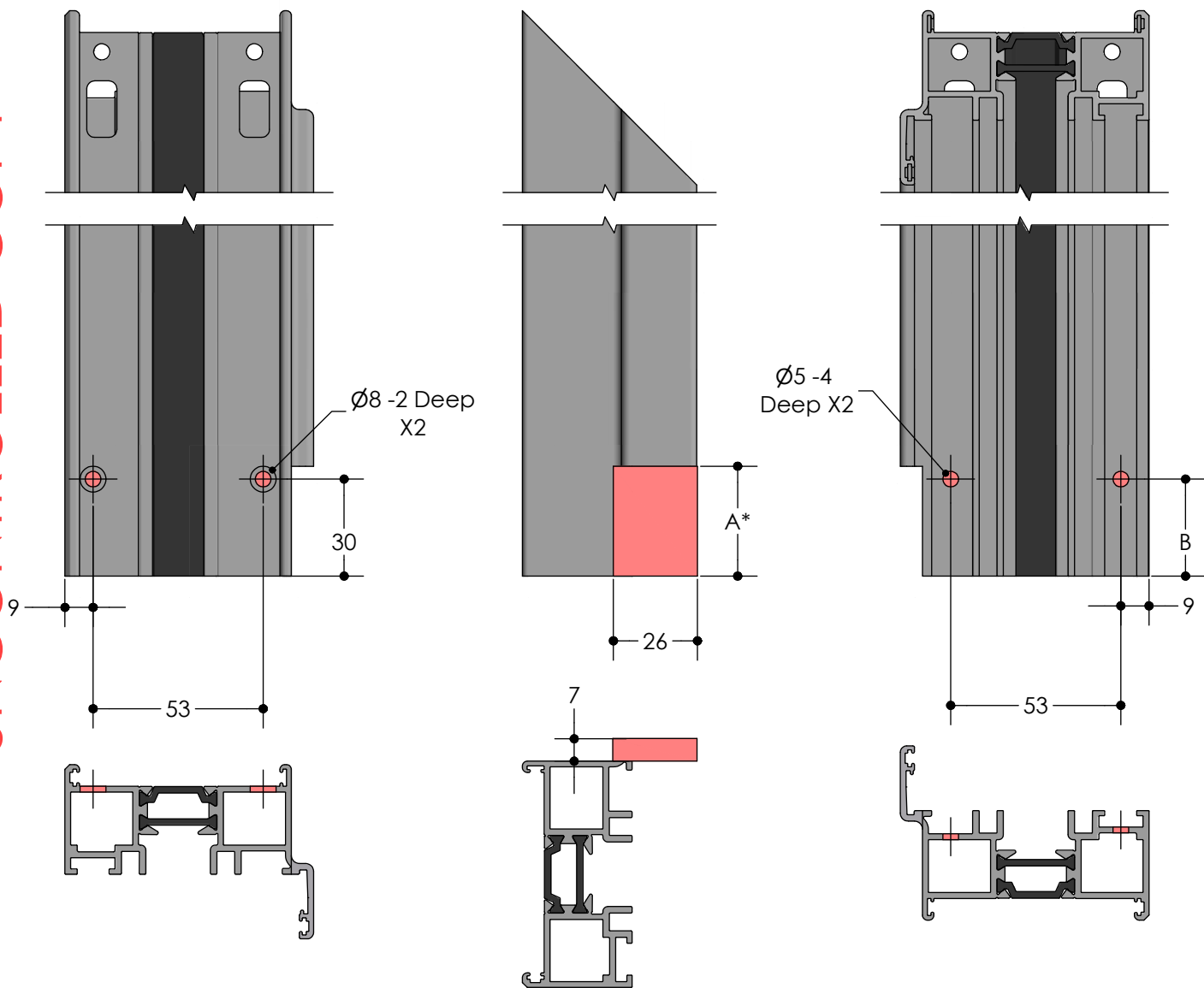


NB: Use punch tool BSD705 station 9/10 for Ø11 holes. For end mill single cut use BSD666 for multi cut use BSD610.



▶ LOW THRESHOLD PREPARATION

P-06-100B, P-06-130 & P-06-131



Machine rebate of P - 06 - 100 to allow low threshold (P - 06 - 132) to be positioned.

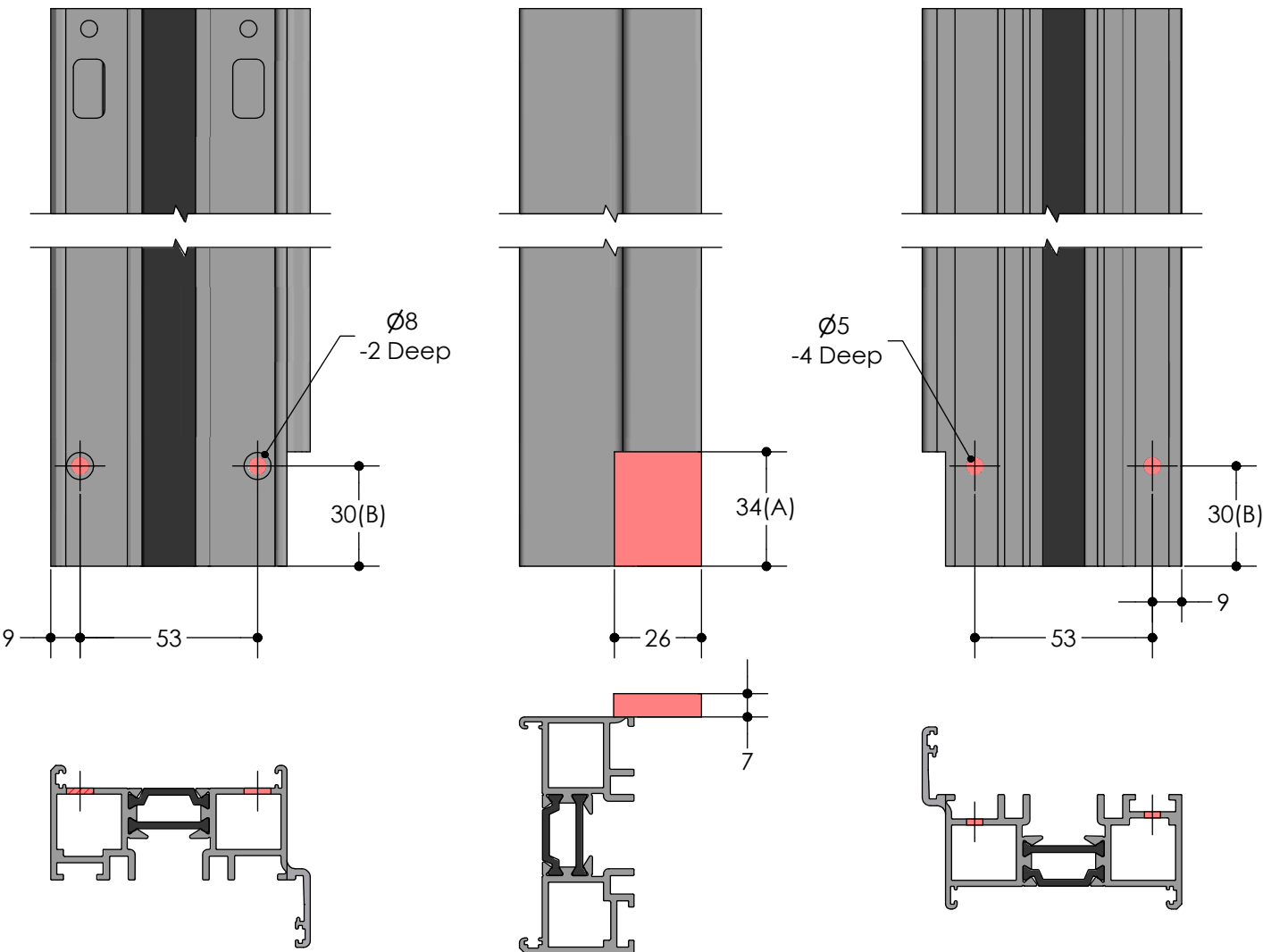
MACHINING DETAILS - LOW THRESHOLD		
BOTTOM CONFIGURATION	DIM (A)	DIM (B)
	34	30

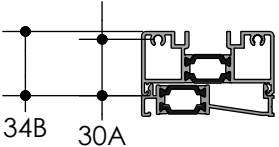
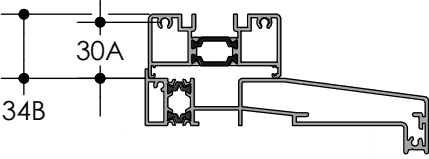
NB: Machining details only applicable when using P - 06 - 135 (Drainage Tray).

* Removal of leg optional dependant upon structure finishing for open out. Leg removed for open in

▶ LOW THRESHOLD PREPARATION CONT.

P-06-100B, P-06-130 & P-06-131



MACHINING DETAILS - LOW THRESHOLD		
BOTTOM CONFIGURATION	DIM (A)	DIM (B)
 34B 30A	34	30
 30A 34B	34	30



If Using P-06-131 use following dimensions

DIM A = 22MM

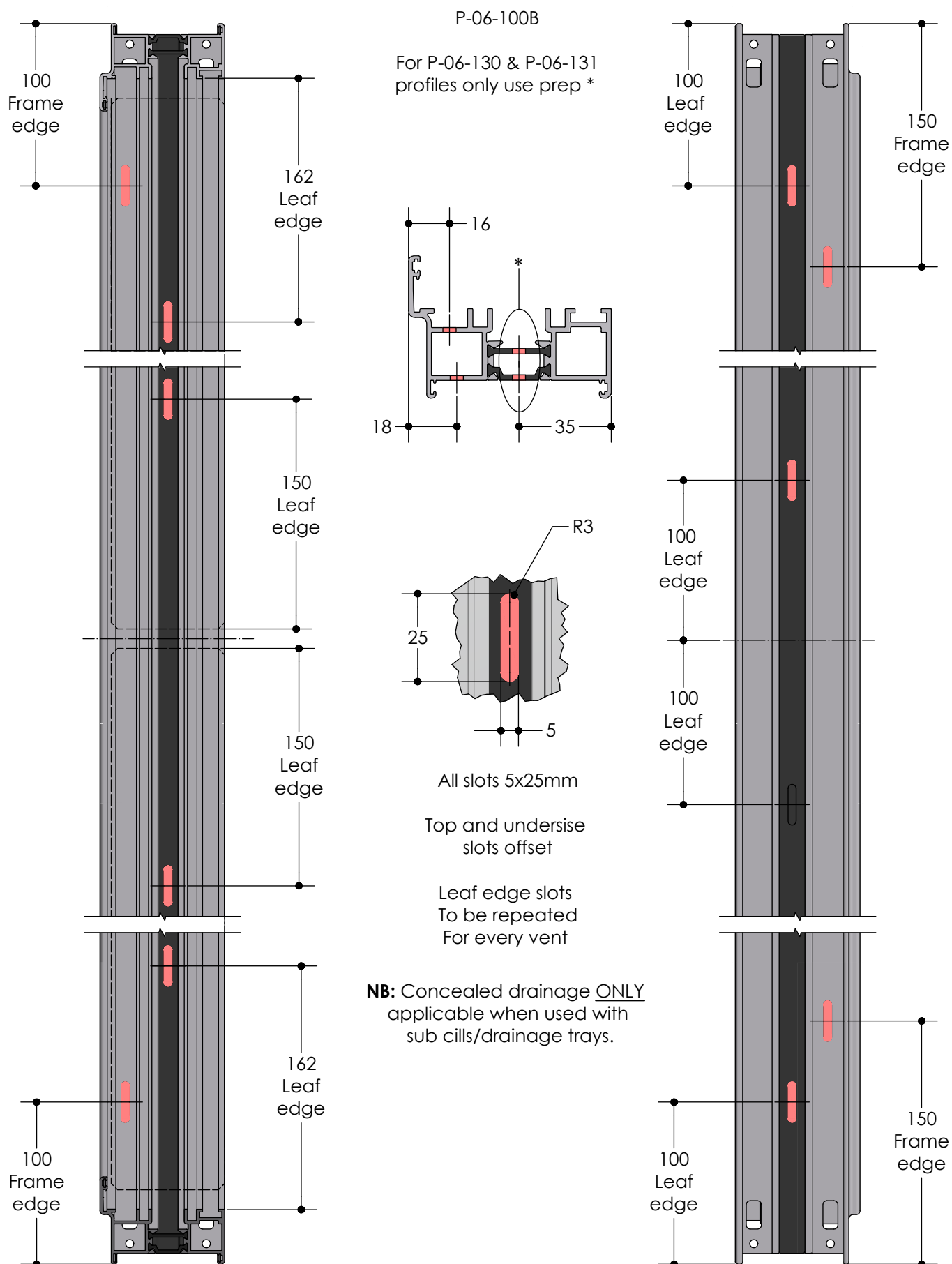
DIM B = 18MM

NB: P-06-131 Only used in Internal Partitions (Non Thermal)

NB: Machining details only applicable when face draining the frame cill, if using AW726 (Drainage Tray) or other sub cills see table above.

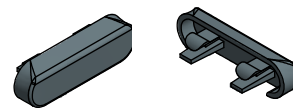
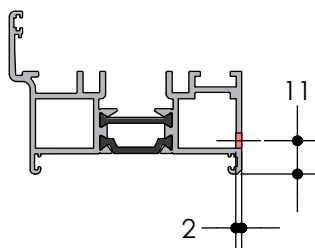
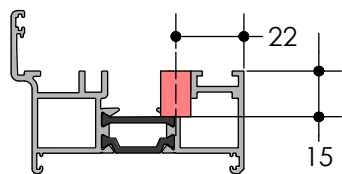
* Removal of leg optional dependant upon structure finishing for open out. Leg removed for open in

CONCEALED DRAINAGE PREPARATION



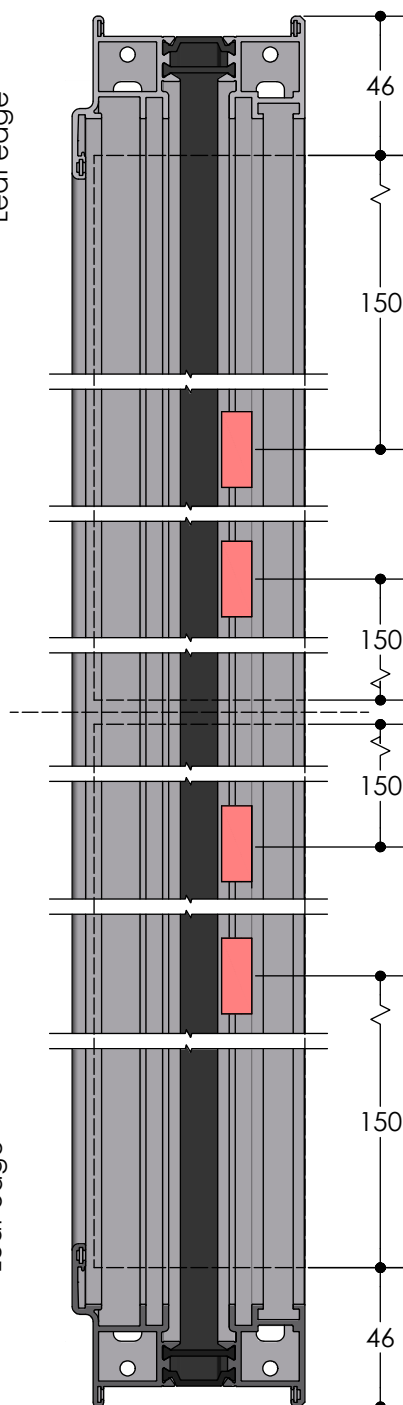
▶ FACE DRAINAGE PREPARATION (OPEN OUT)

P-06-100B & P-06-130

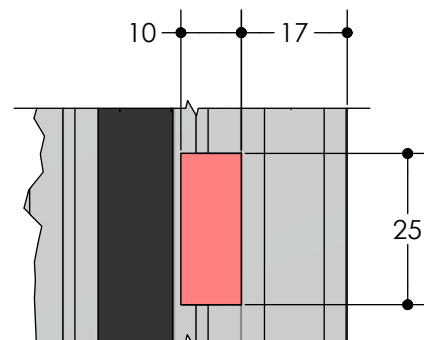
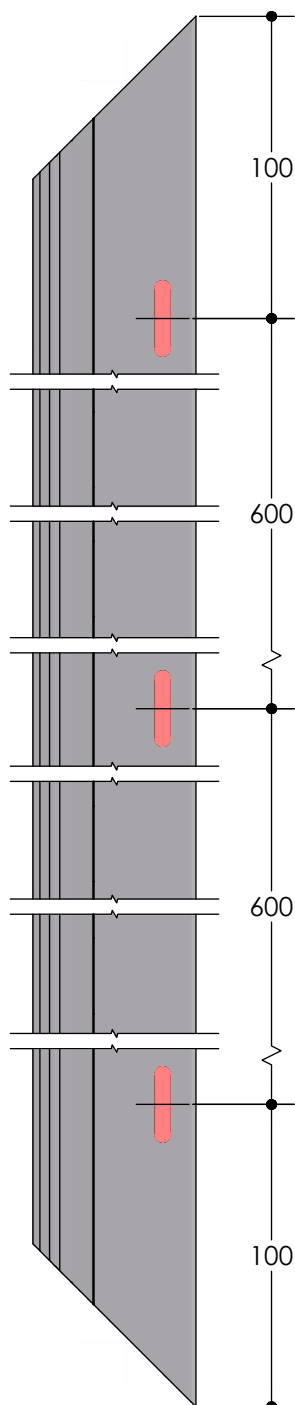


RX916 B/W
Face drainage slots cover caps

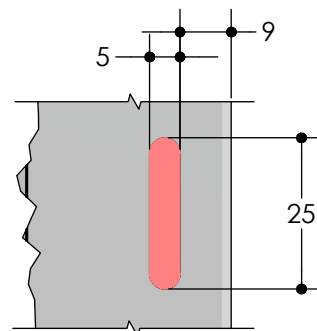
Leaf edge



Leaf edge



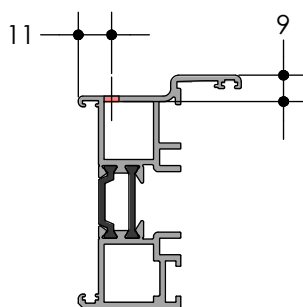
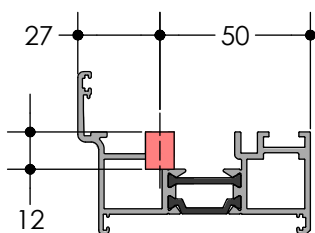
Above Slot to be machined
at 150mm in from the edge
of each leaf i.e. 2 per sash.



Above Slot to be machined at
150mm from each corner and
machined at a minimum of
600mm centres.

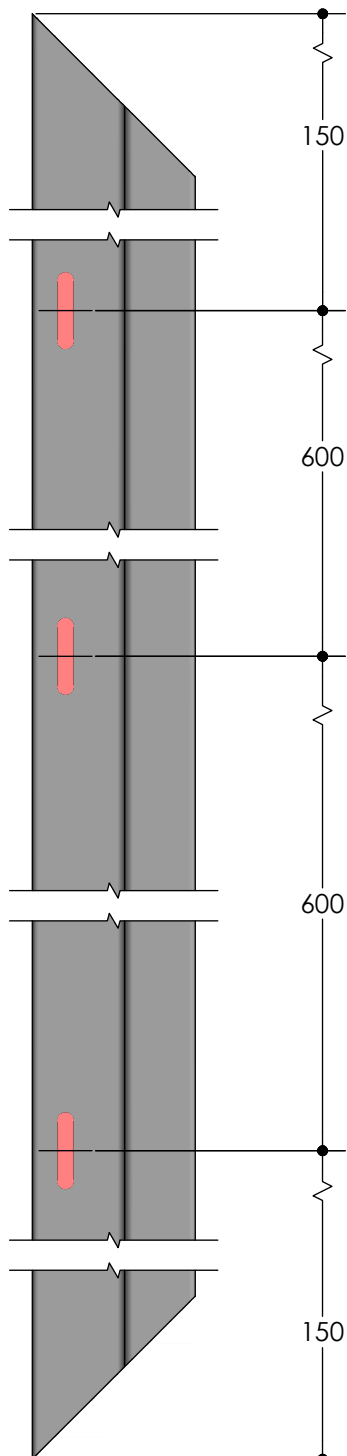
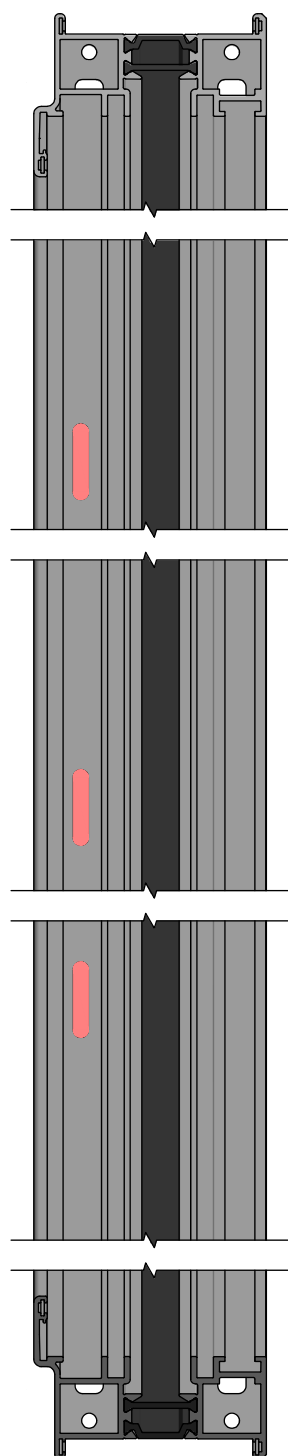
➤ FACE DRAINAGE PREPARATION (OPEN IN)

P-06-100B & P-06-130



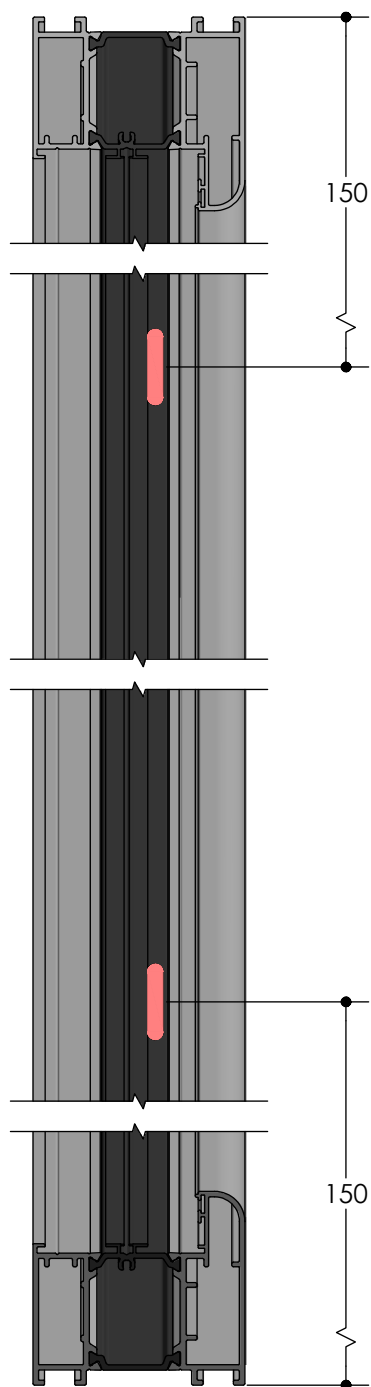
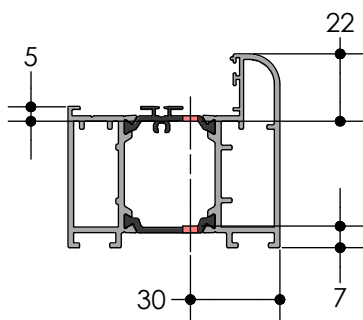
RX916 B/W

Face drainage slots cover caps

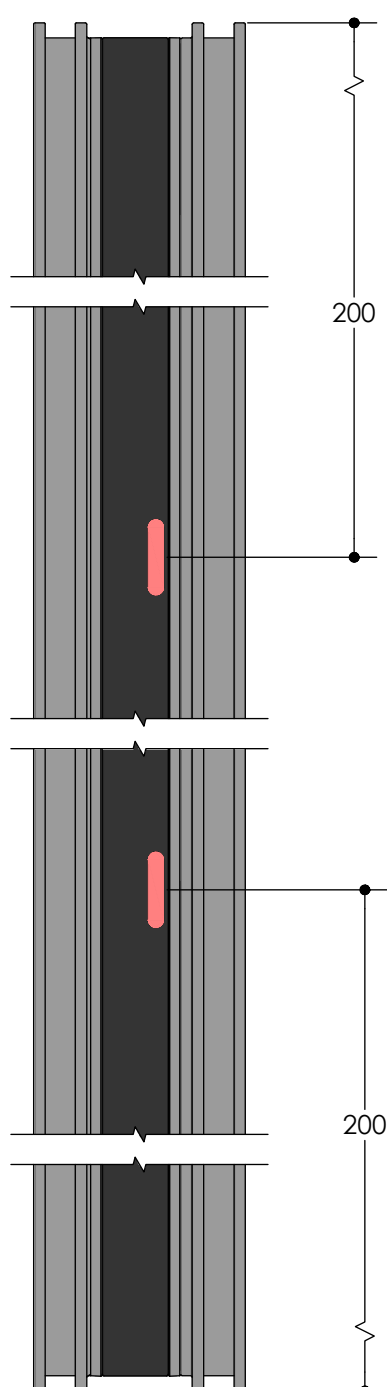


Slot to be 150mm from each corner and machined at approx 600mm centres.

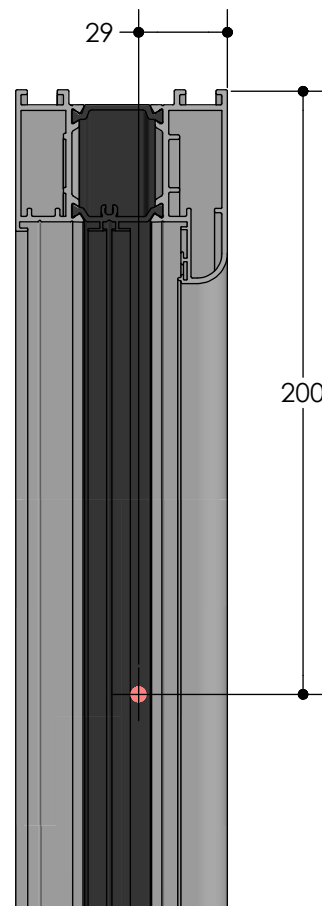
➤ SASH DRAINAGE AND PRESSURE EQUALISATION



Top view



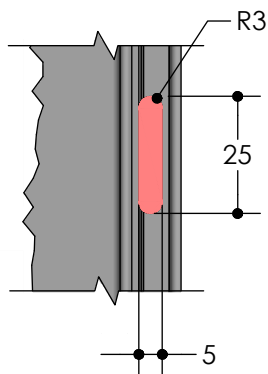
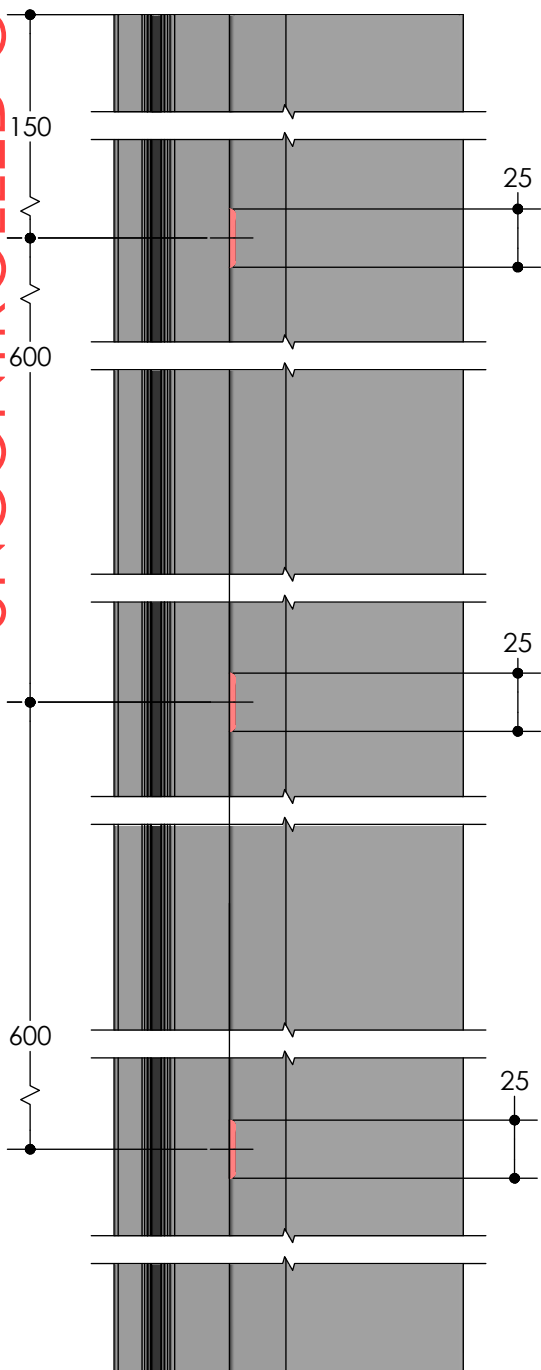
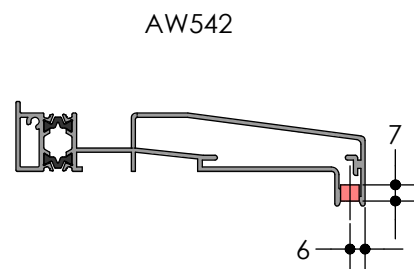
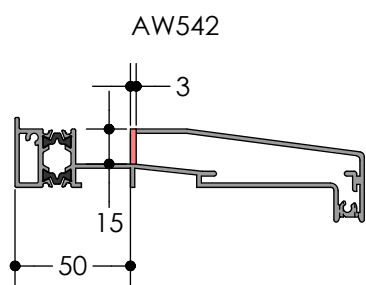
Bottom view



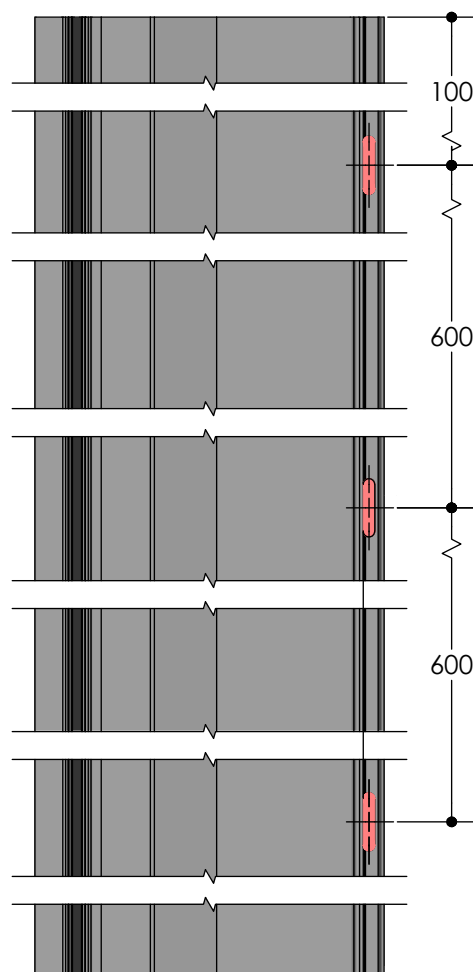
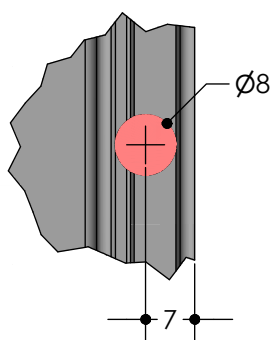
Pressure equalisation
5mm THRU hole on
each vent jamb
200mm from head

➤ CONCEALED DRAINAGE PREP.

UNCONTROLLED COPY

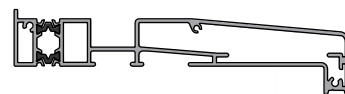


ALT. DRAINAGE

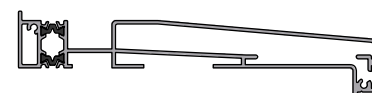


Also applicable to AW543 and AW544, see below:

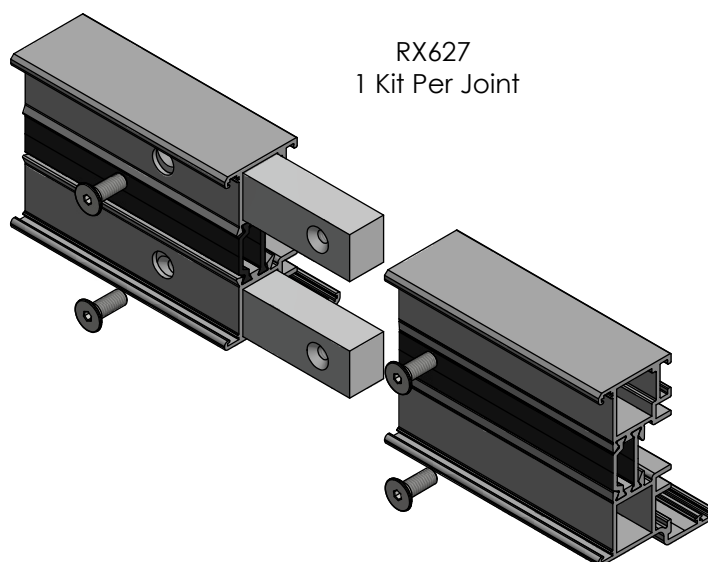
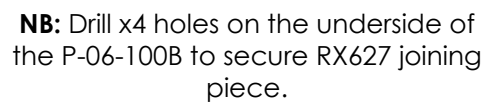
AW543



AW544



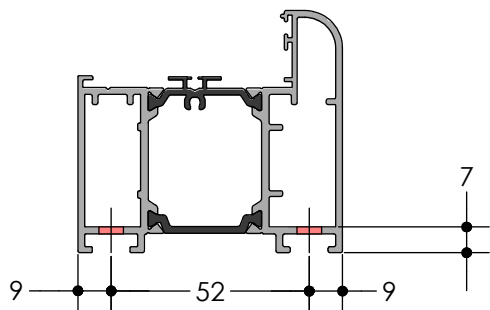
NB: When drilling a drainage hole a minimum diameter of 8mm must be used and countersunk to remove any burrs.



BSF70

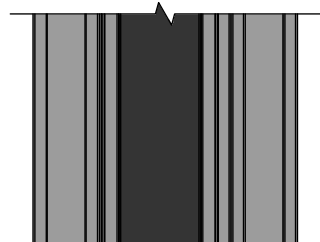
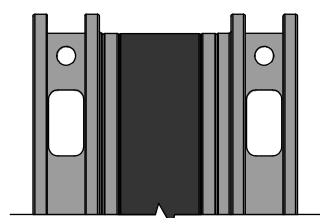
➤ RX706 HD ROLLER PIN POSITION

P-06-200/202



NB: Drill $\varnothing 6.5$ hole at bottom of the door sash where fitting RX706.

No hole is required when fitting top HD top guide (RX705).

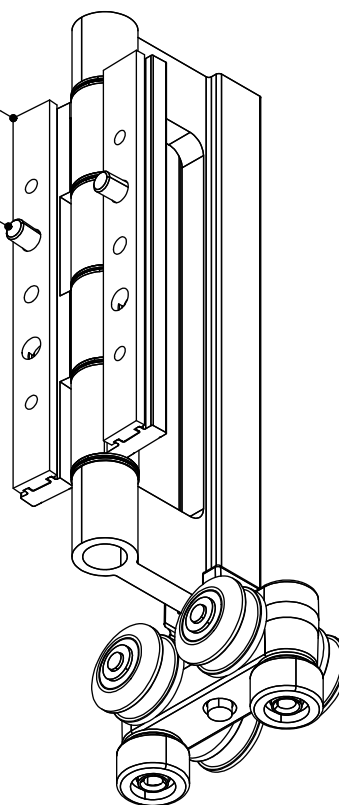


RX041
Backing Plate

n6 pin to fit through
backing plate into profile

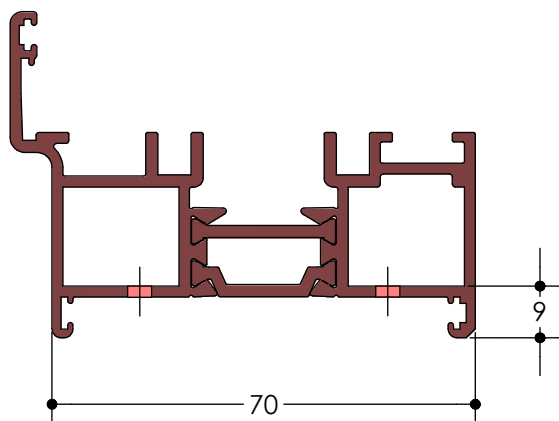
$\varnothing 7$ THRU
X2

104

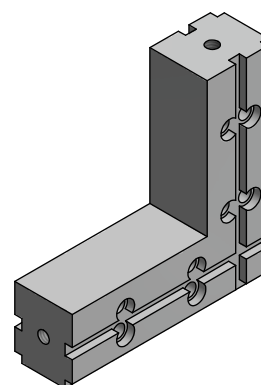
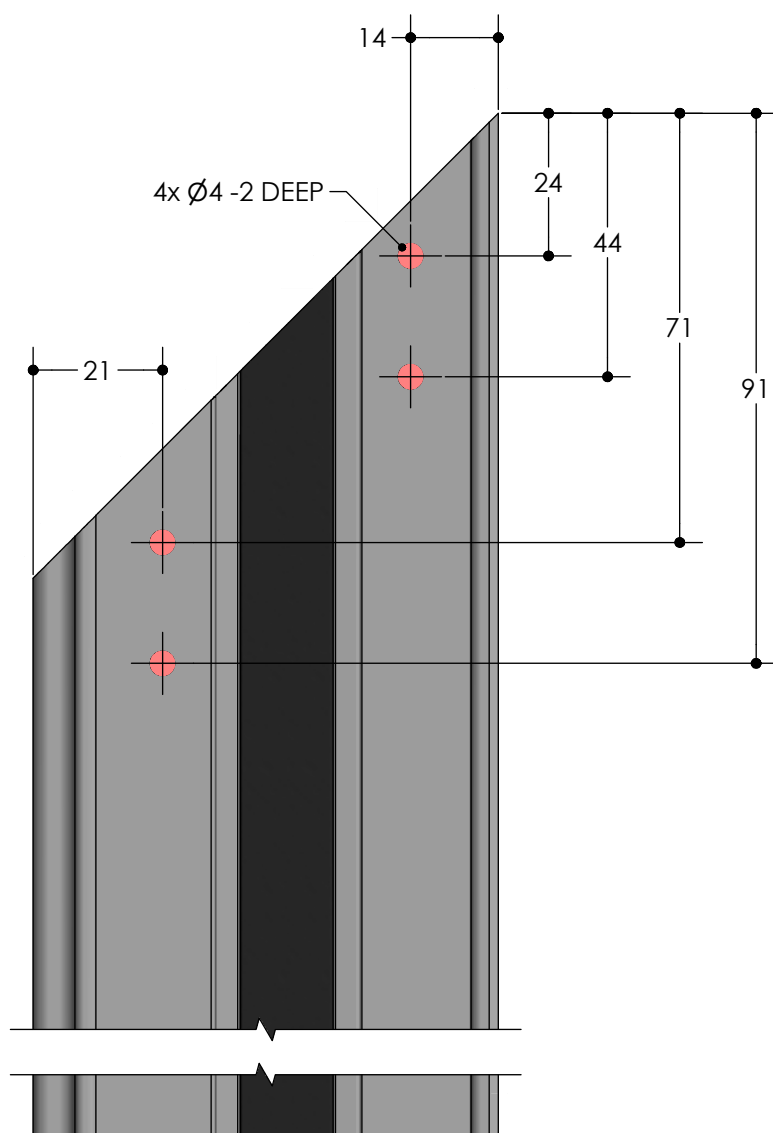


► CLEAT PREP. CORNER POST

P-06-100B



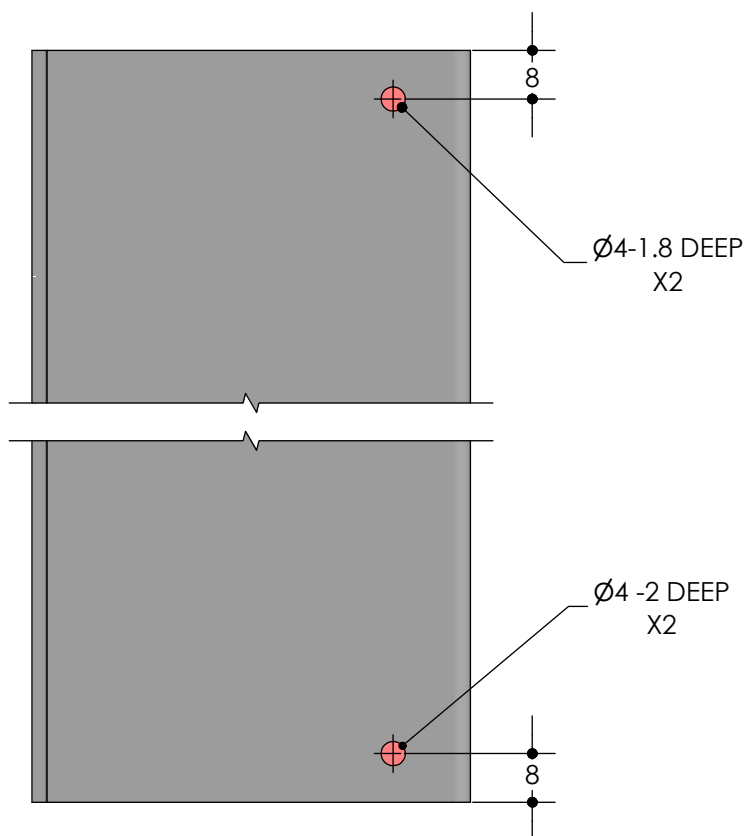
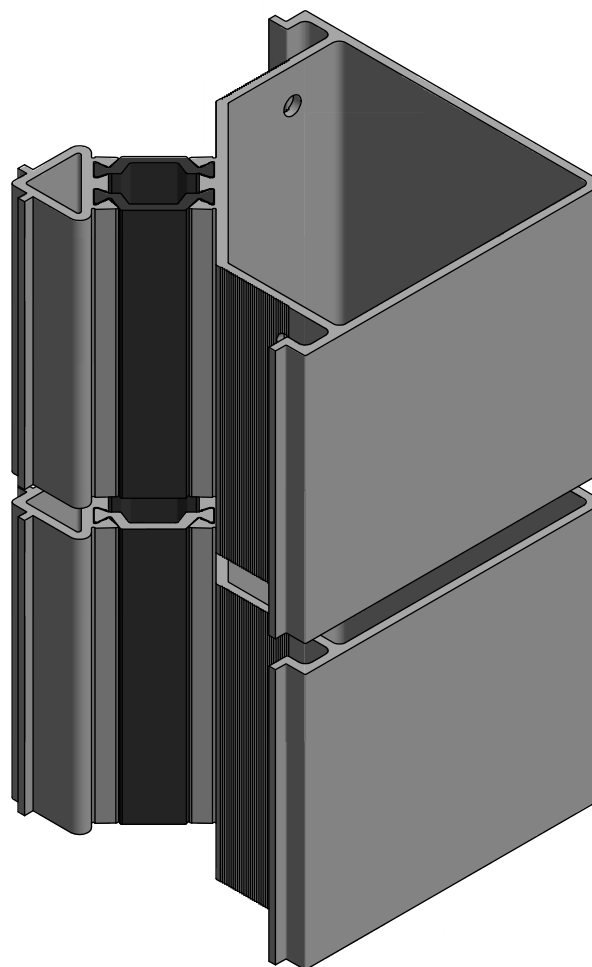
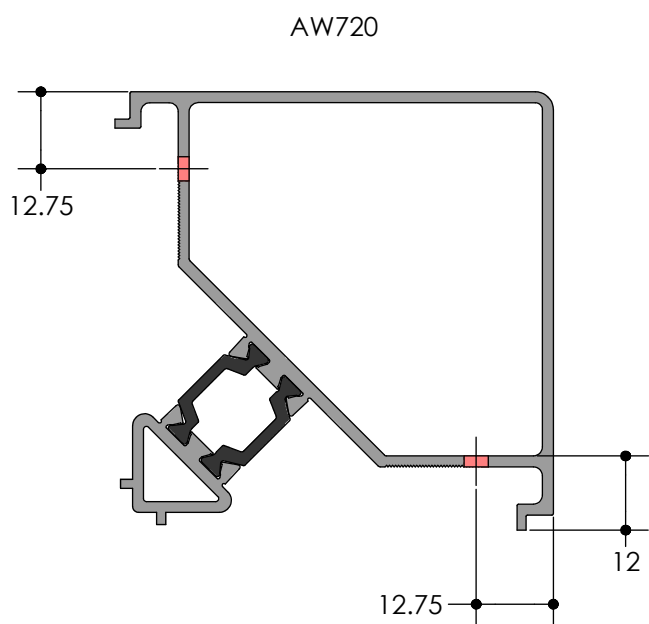
NB: Drill (x4) 4mm holes on the underside of the P-06-100B to secure RX665 cleat/corner post adaptor.



RX665

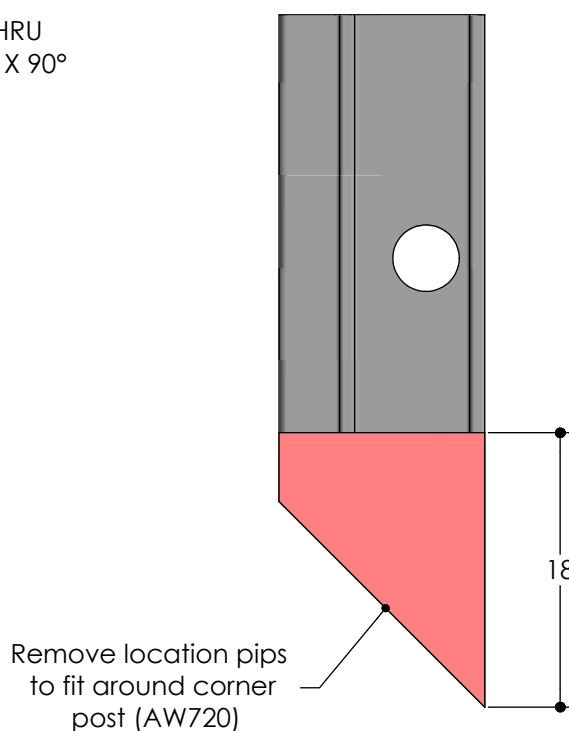
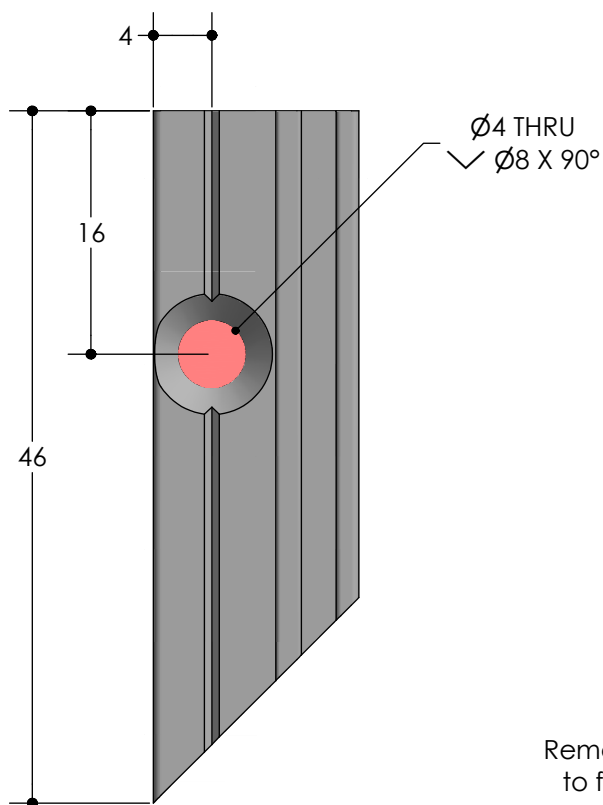
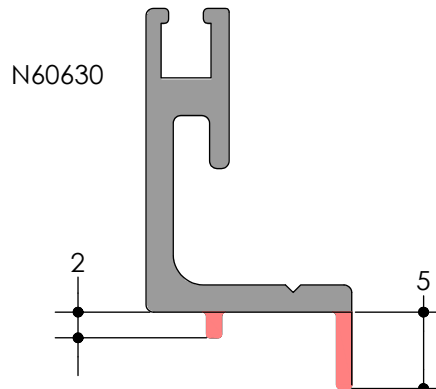
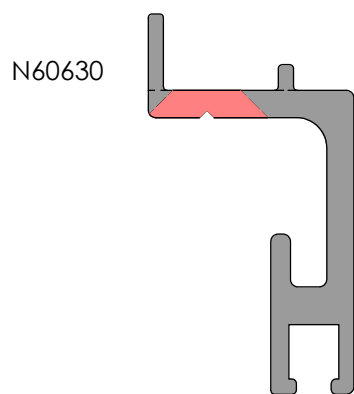
(x2) per corner

➤ CORNER POST PREP. CORNER DETAIL



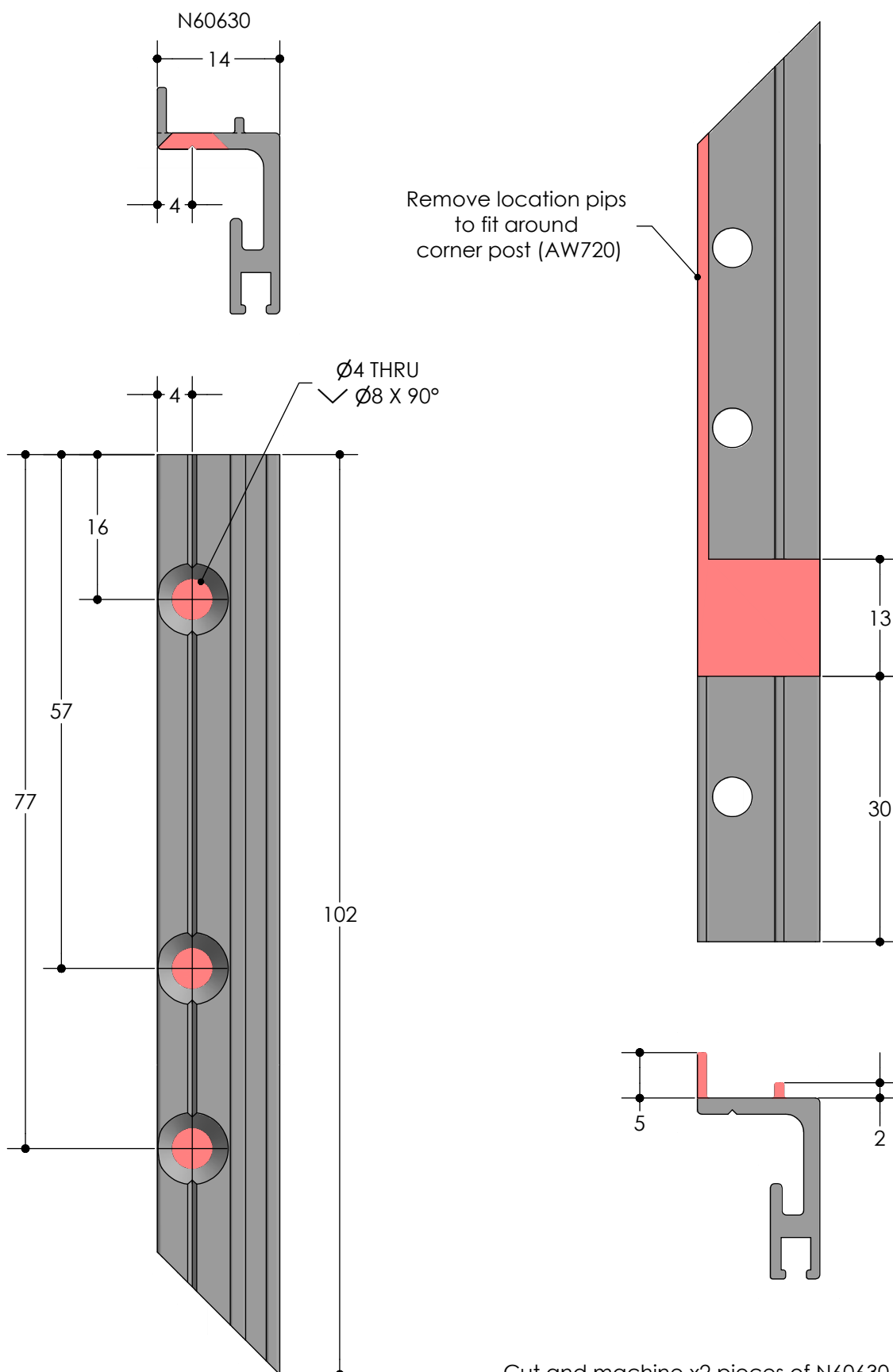
NB: Drill (x4) Ø4mm holes on the top and bottom of the corner post (AW720).

► N60630 CORNER POST PREP. CORNER DETAIL



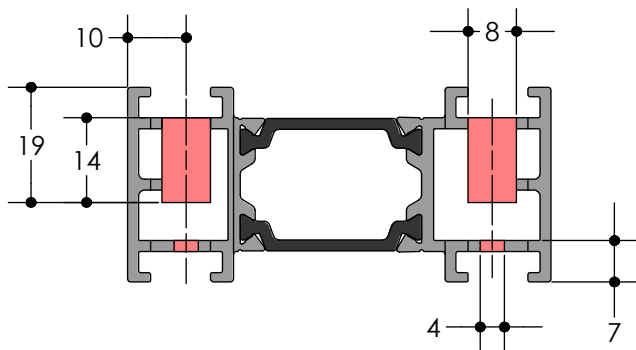
Cut and machine x2 pieces of N60630 to fit on the internal side of corner post.

➤ N60630 CORNER POST PREP. CORNER DETAIL

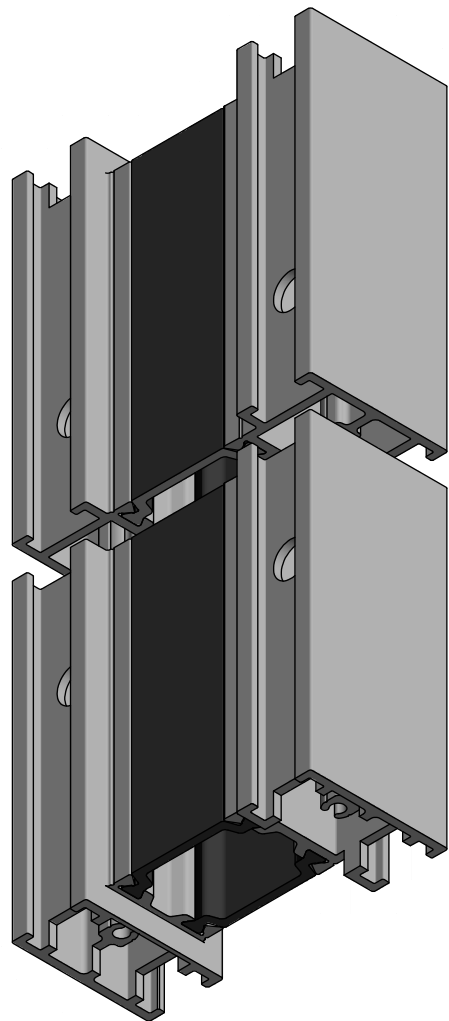
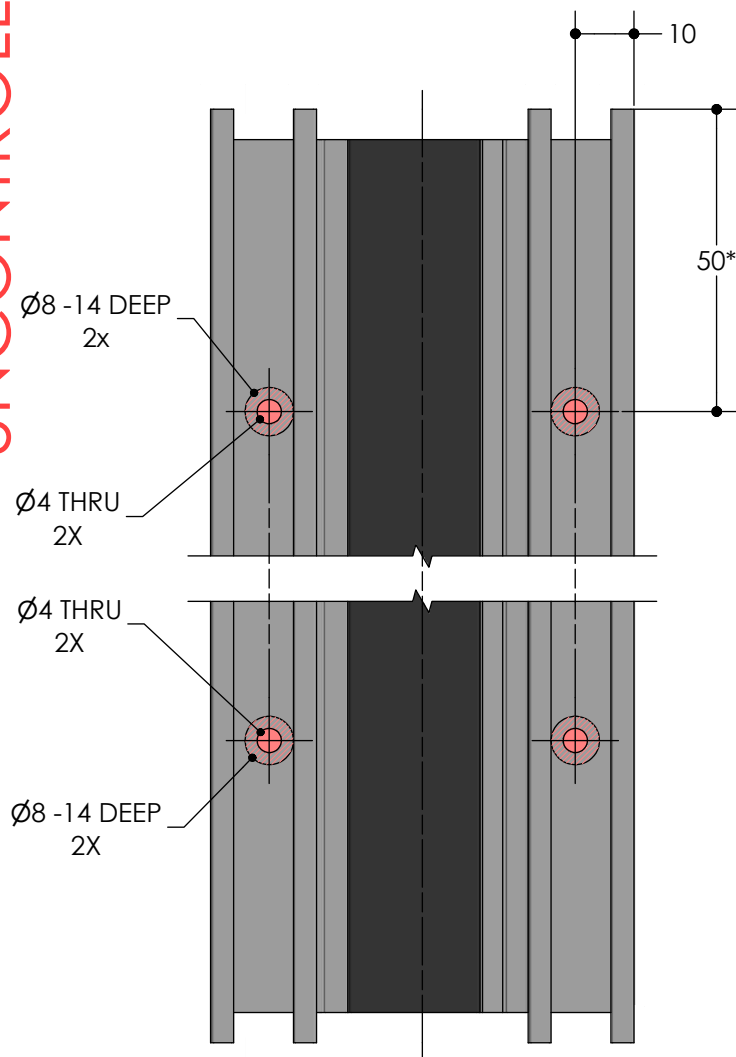


Cut and machine x2 pieces of N60630 to fit on the external side of corner post.

➤ P-06-300 CORNER POST PREP. DETAIL



NB: Repeat end mill and counter bored holes on x2 P-06-300 to fit either side of the corner post (AW720).



* Counter bore and drill holes 50mm from top/bottom and continue @ 600 Centres.

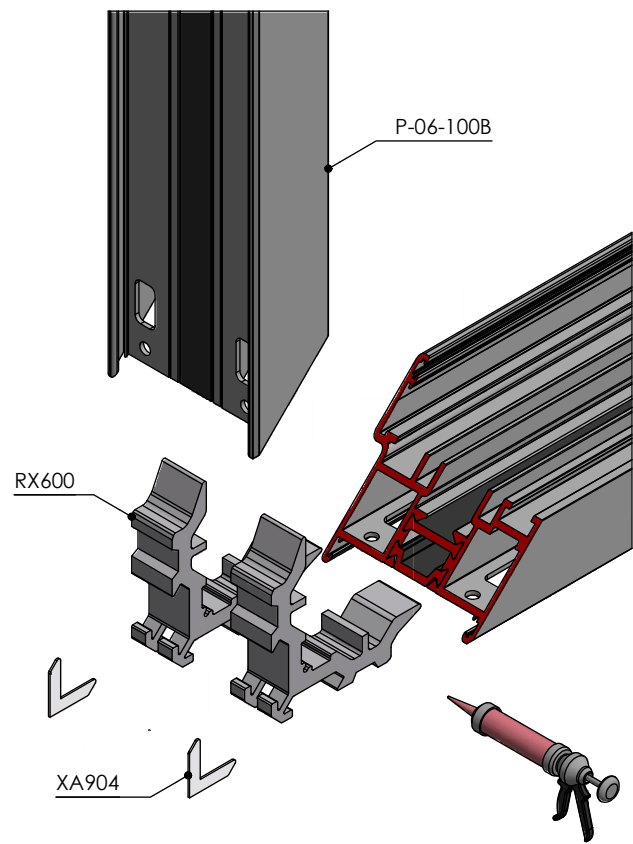
UNCONTROLLED COPY

SECTION 10 ASSEMBLY

UNCONTROLLED COPY

ASSEMBLY

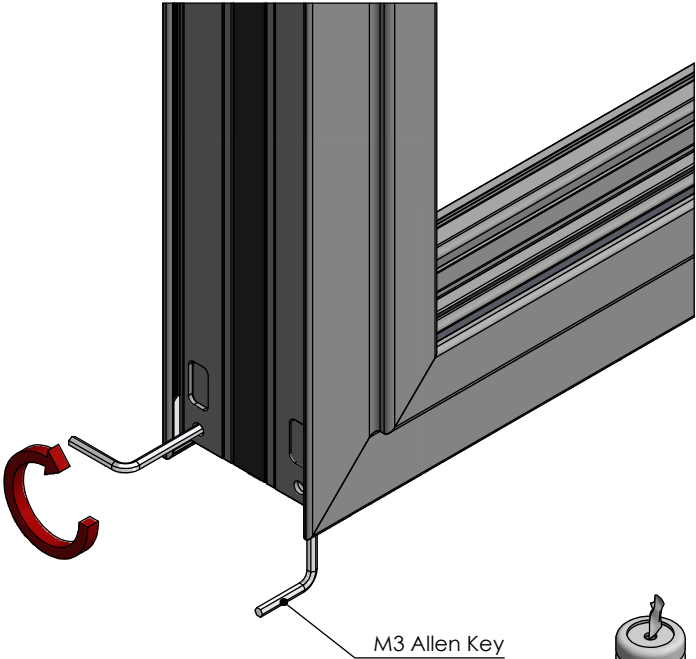
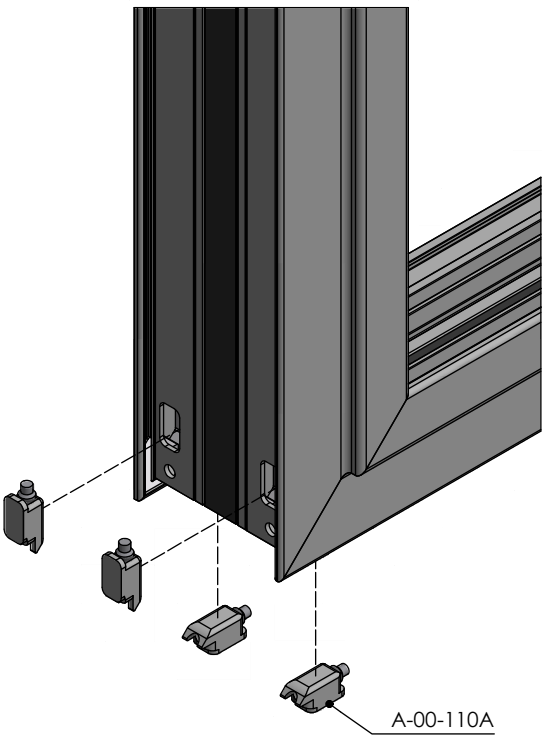
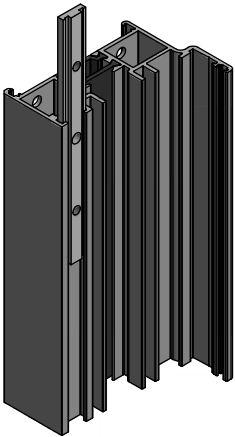
➤ FRAME ASSEMBLY



Frame Assembly Parts List (Per Corner)		
Part No.	Description	Qty
P-06-100B	Outer frame	2
RX600	18.9mm Mechanical cleat	2
XA904	Narrow chevron	2
A-00-110A	Mechanical cleat tensioning block	4
T50000 - 2	Small joint sealant	-
T50003	Aluk sealant wipes	-
RX040 - RX041	Hinge back plate	-

NB: Remember to seal each corner joint before final fix.

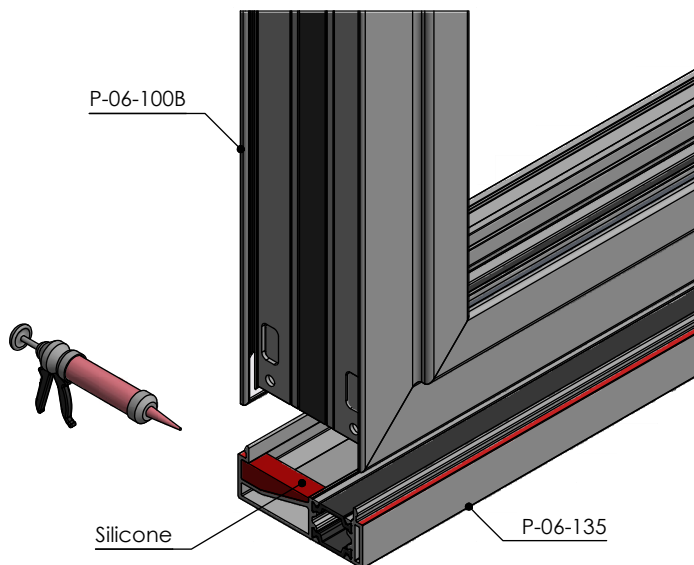
Insert RX040/RX041 hinge backing plates into frame profile before joining corners



NB: Remove excess sealant with Aluk sealant wipes (T50003).



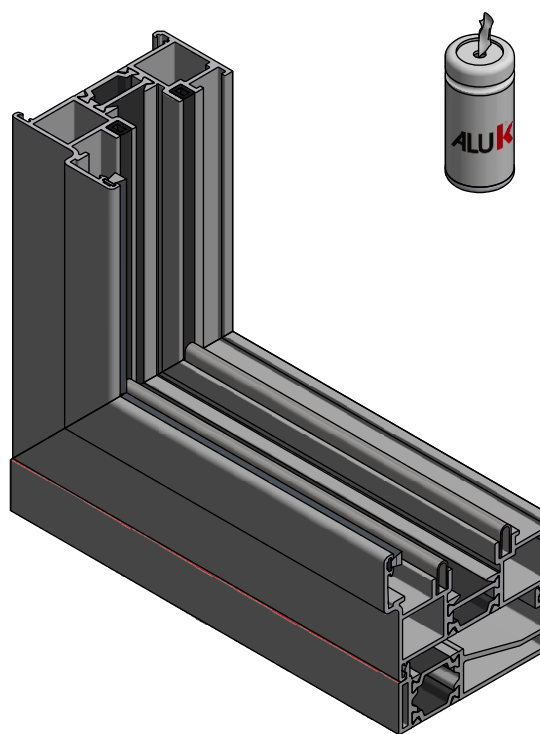
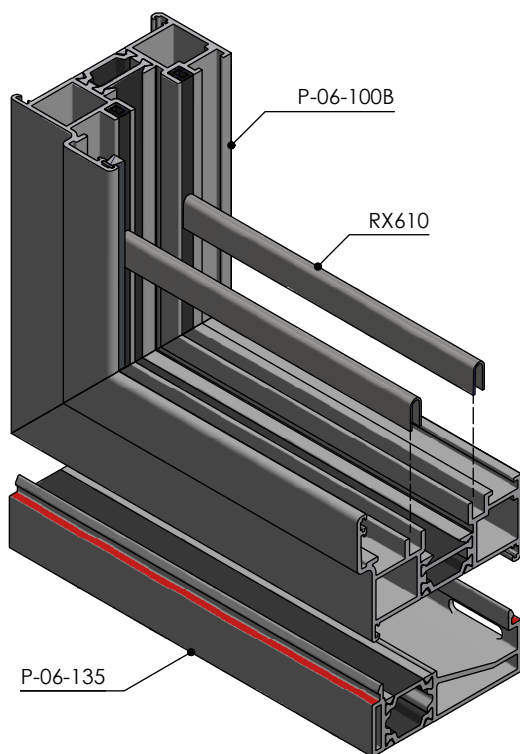
➤ DRAINAGE TRAY ASSEMBLY



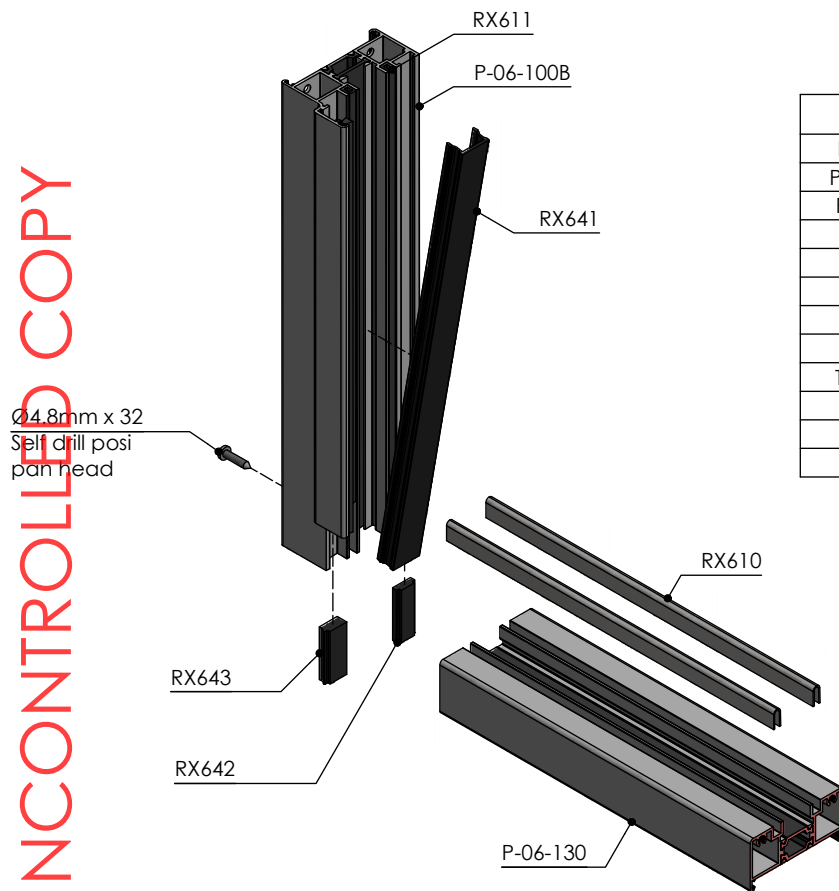
Drainage Tray Assembly Parts List (Per Corner)		
Part No.	Description	Qty
P-06-100B	Outerframe	2
P-06-135	Drainage tray	1
RX610	Stainless steel track	2
T50000-2	Small joint sealant	-
T50003	Aluk sealant wipes	-

NB: Remember to seal each profile before final fix.

NB: Remove excess sealant with Aluk sealant wipes (T50003).



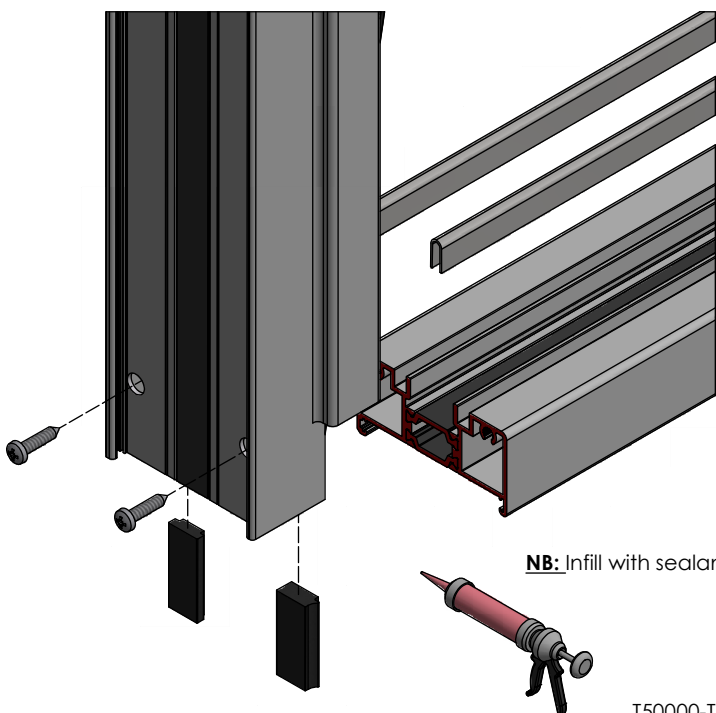
➤ LOW THRESHOLD ASSEMBLY



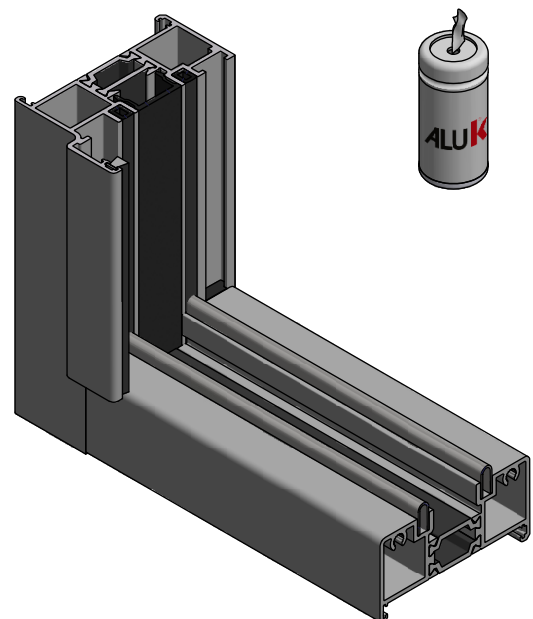
Low Threshold Parts List (Per Corner)		
Part No.	Description	Qty
P-06-100B	BSF70 Frame	1
P-06-130	Low threshold	1
RX957	4.8 600 EC grey woolpile	1
RX643	Frame jamb plug (A)	1
RX642	Frame jamb plug (B)	1
RX641	Outer frame finishing trim	1
Type 7	Ø4.8mm x 32 Self drill posi pan head	2
T50000-2	Small joint sealant	-
T50003	Aluk sealant wipes	-
RX610	SS track	2
RX611	Track Seal	2

NB: Remember to seal joint before final fix

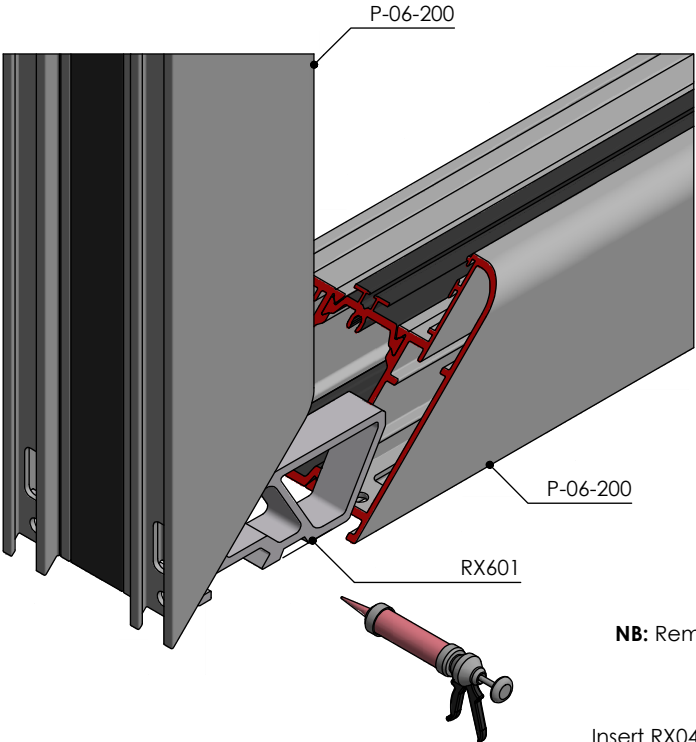
NB: Remove excess sealant with Aluk sealant wipes (T50003).



T50000-T50002

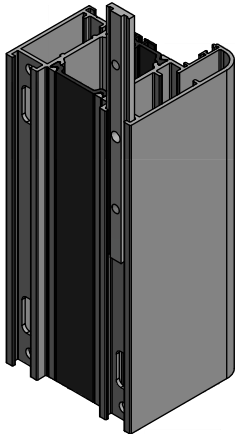


▶ LEAF ASSEMBLY



Leaf Assembly Parts List (Per Corner)		
Part No.	Description	Qty
P-06-200	Softline leaf	2
RX601	13.7mm Mechanical cleat	2
A-00-110A	Mechanical cleat tensioning block	4
A-GS-240	Slide in E gasket	2
T50000-2	Small joint sealant	-
T50003	Aluk seant wipes	-

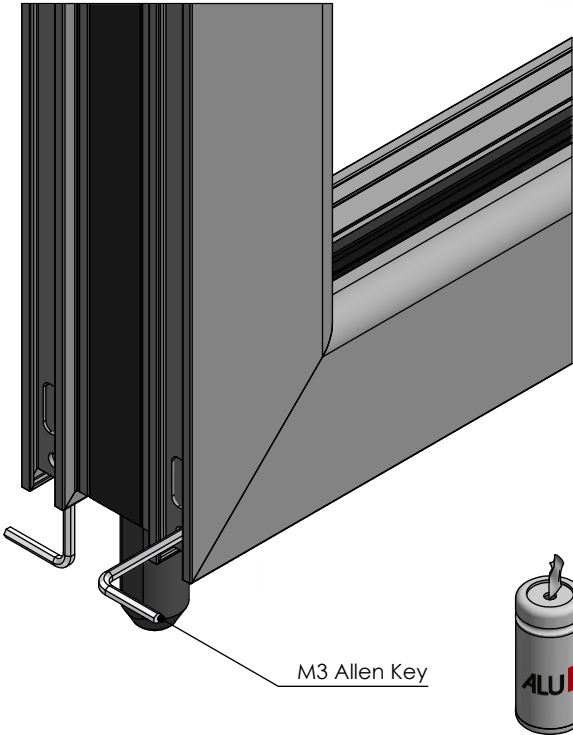
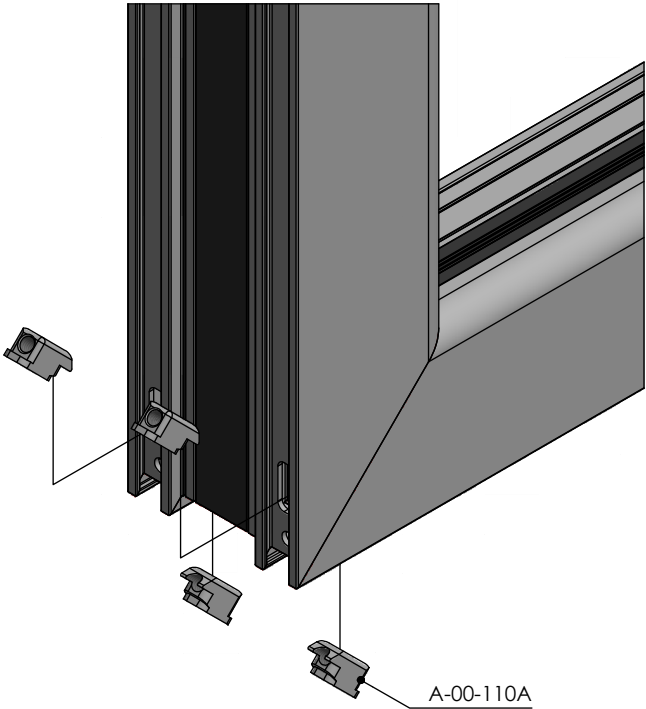
GASKETS NOT SHOWN



NB: Remember to seal each corner joint before final fix.

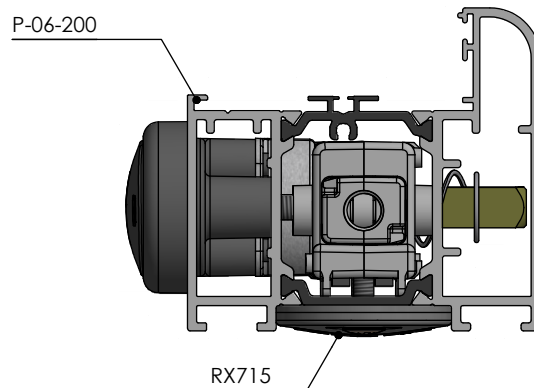
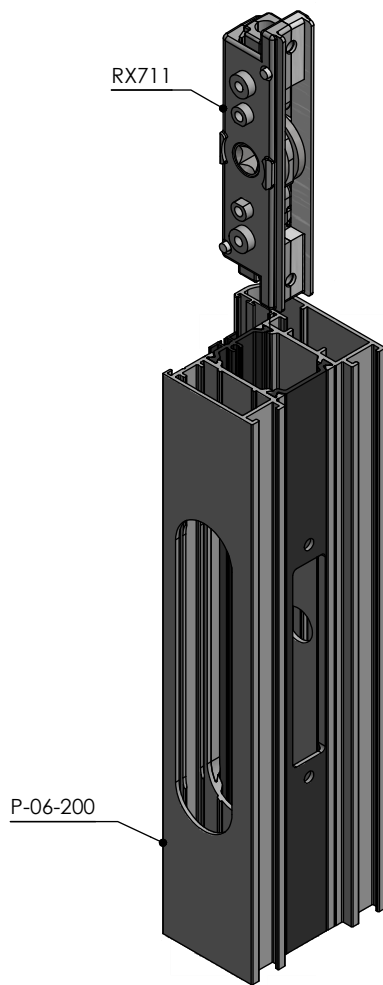
Insert RX040/RX041 hinge backing plates into vent profile before joining corners

T50000-T50002



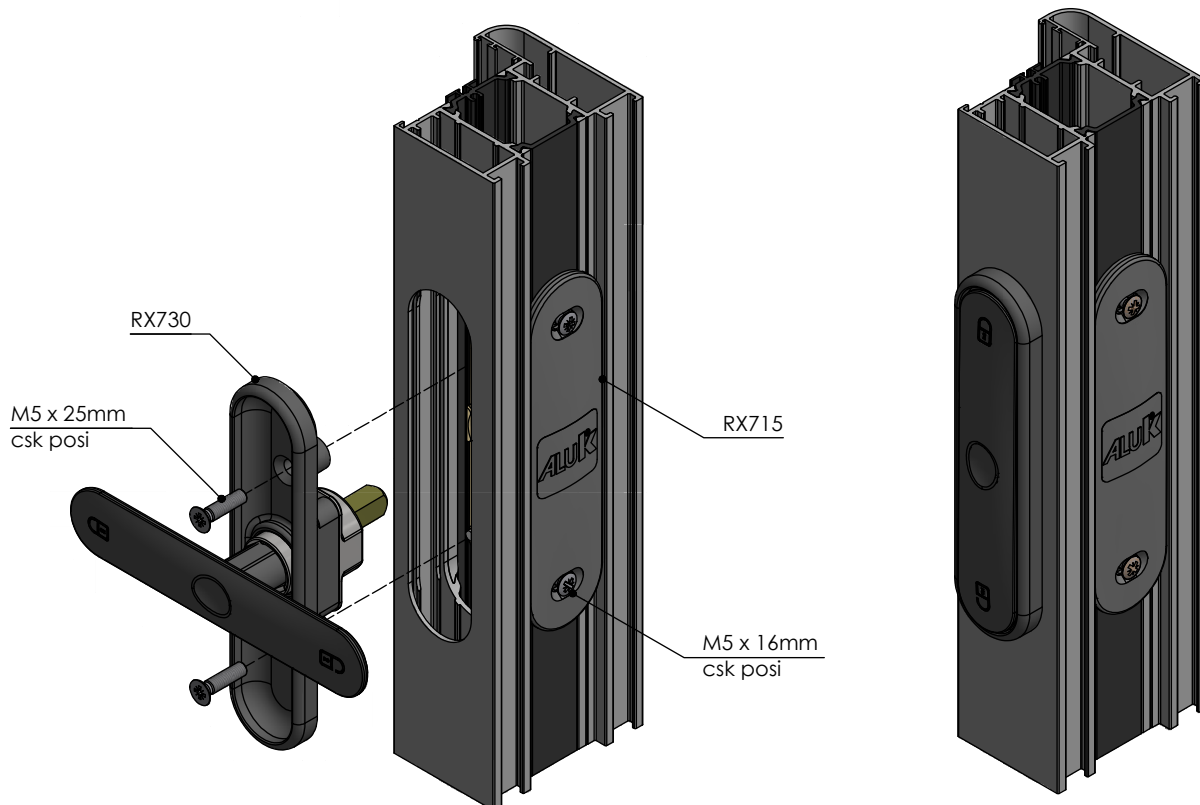
NB: Remove excess sealant with Aluk sealant wipes (T50003).

➤ SHOOTBOLT ASSEMBLY - STANDARD

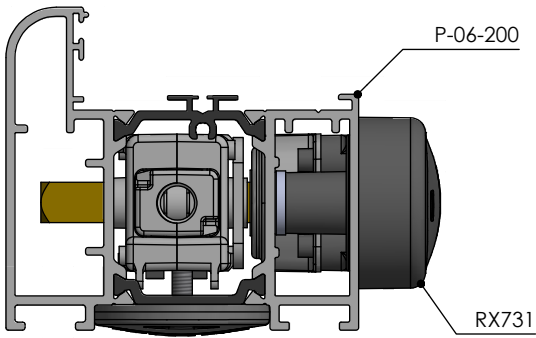
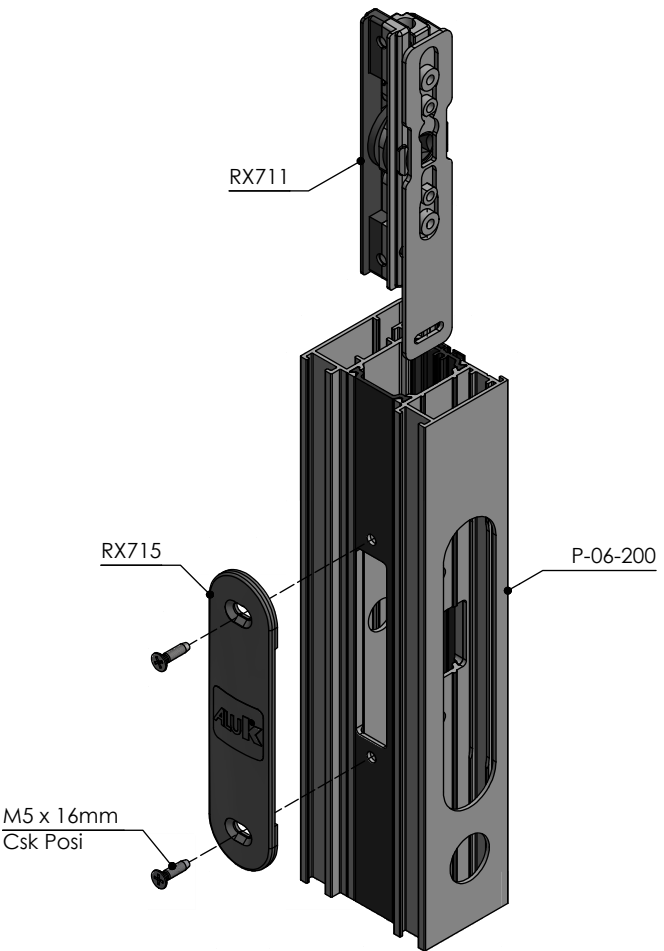


Shootbolt Assembly Parts List (Per Corner)		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
RX711	T-handle gear box	1
RX712	Shootbolt rod	2
RX715	Gear box face plate	1
RX730	T-Handle	1
-	M5 x 16mm Csk Posi	2
-	M5 x 25mm Csk Posi	2

SHOOTBOLT ROD NOT SHOWN

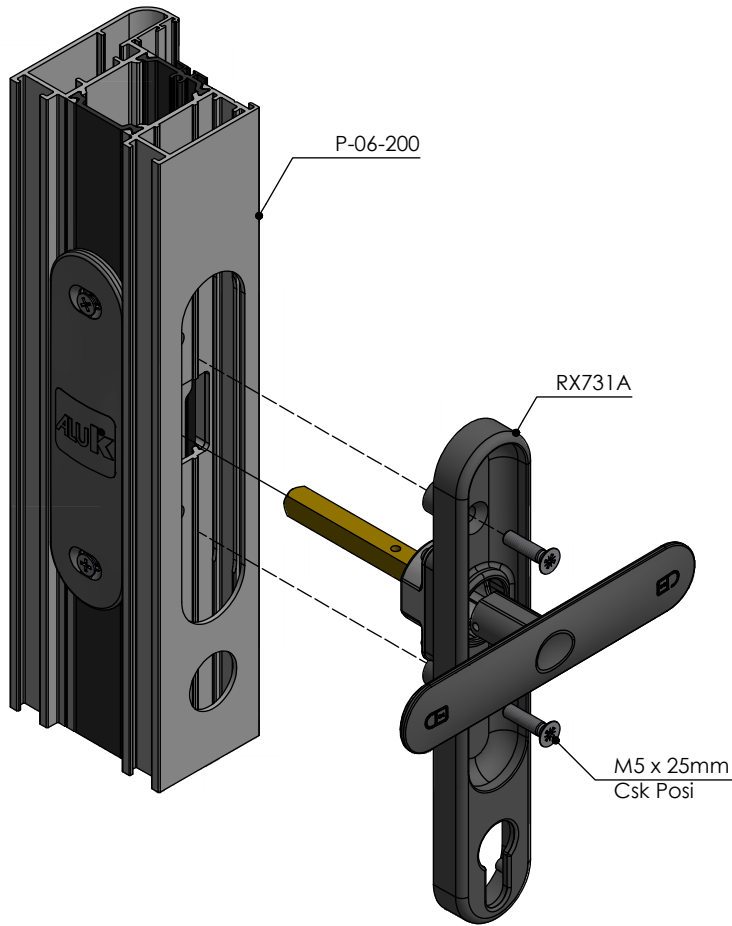


➤ SHOOTBOLT ASSEMBLY - LOCKING

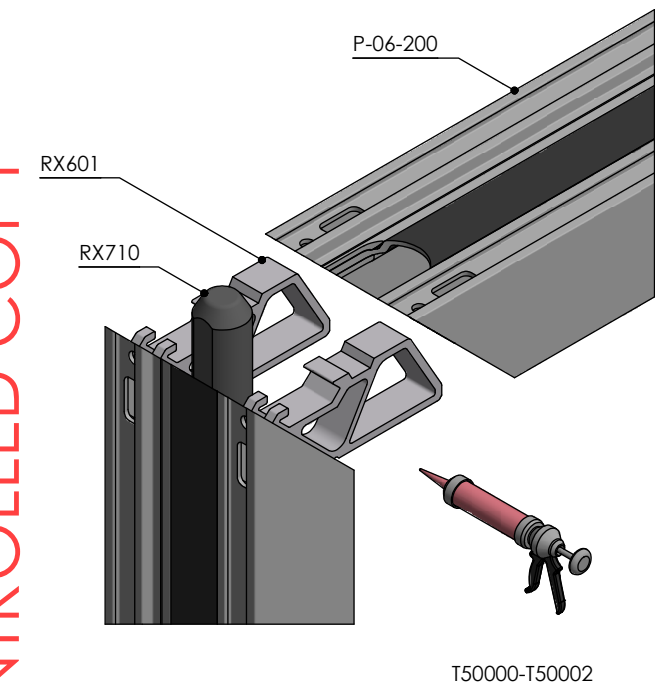


Shootbolt Assembly Parts List (Per Corner)		
Part No.	Description	Qty
P-06-200	Softline Sash	1
RX711	T-handle gear box	1
RX715	Gear box face plate	1
RX731	Locking T-Handle	1
-	M5 x 16mm Csk Posi	2
-	M5 x 25mm Csk Posi	2

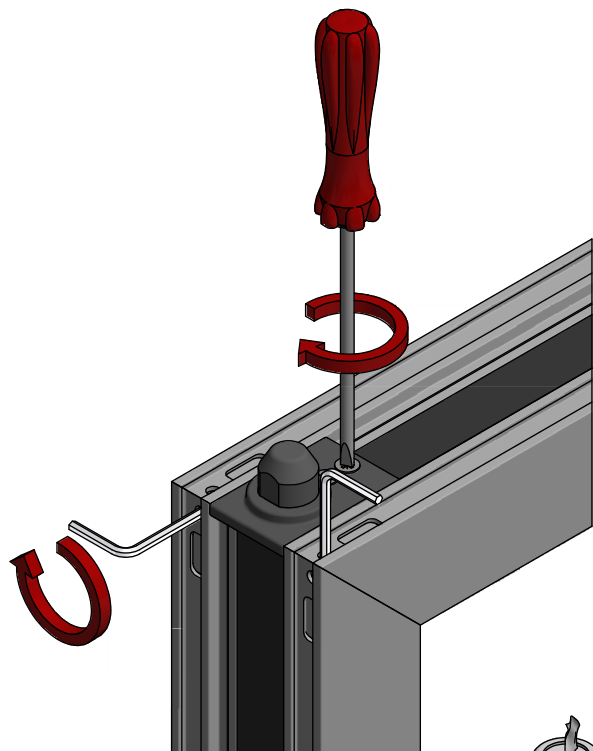
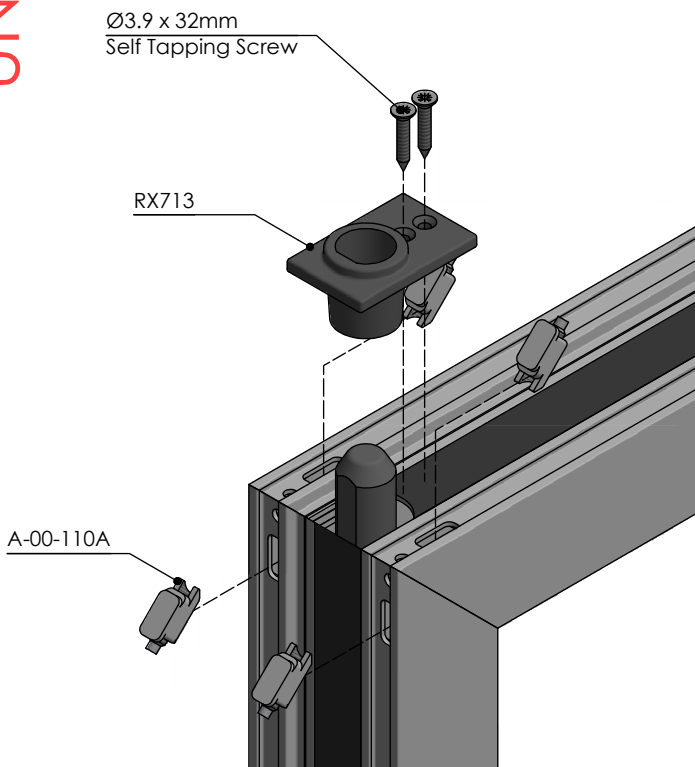
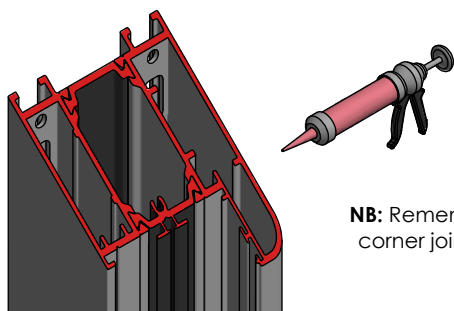
SHOOTBOLT ROD NOT SHOWN



VENT ASSEMBLY TOP (SHOOTBOLT PART 1)



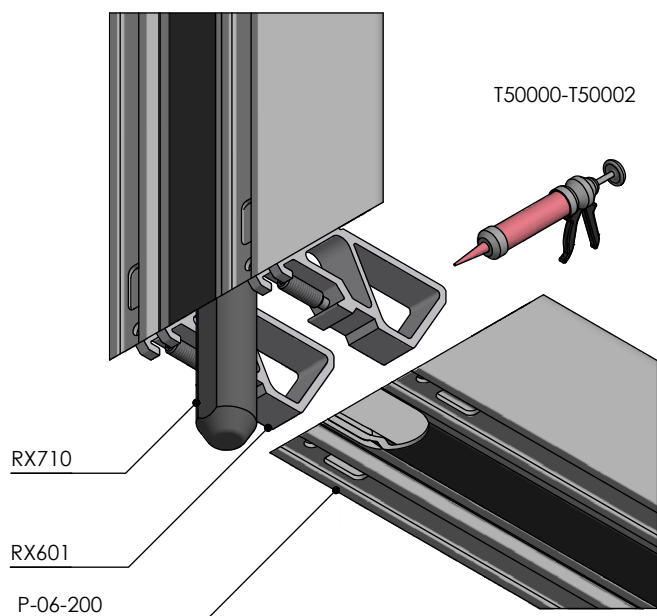
Shootbolt Assembly Parts List (Per Corner)		
Part No.	Description	Qty
RX601	13.7mm Mechanical cleat	2
P-06-200	Soffline Leaf	2
A-GS-240	Slide In Gasket	2
RX710	Shootbolt pack	1
A-00-110A	Mechanical cleat tensioning block	4
RX713	Top Guide	1
-	Ø3.9 x 32mm Self Tapping Screw	2
T50000-2	Small joint sealant	-
T50003	Aluk sealant wipes	-



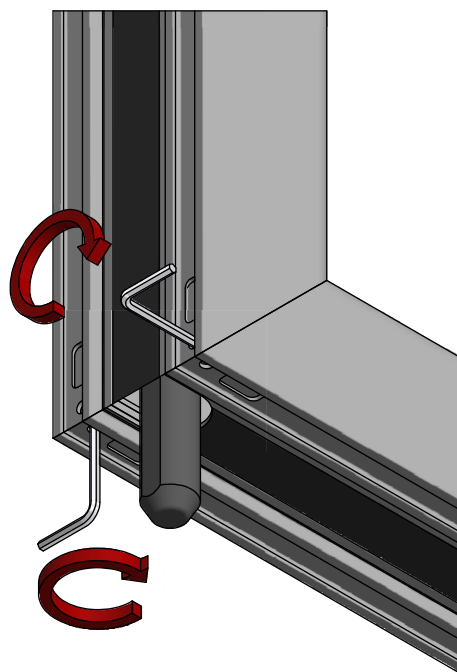
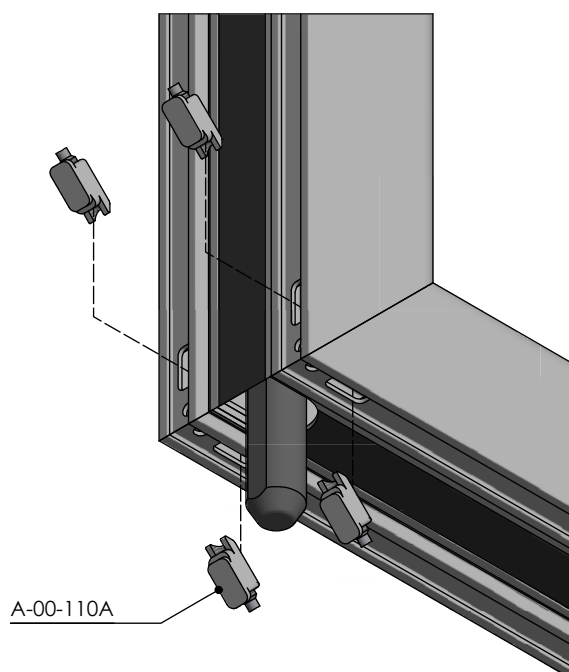
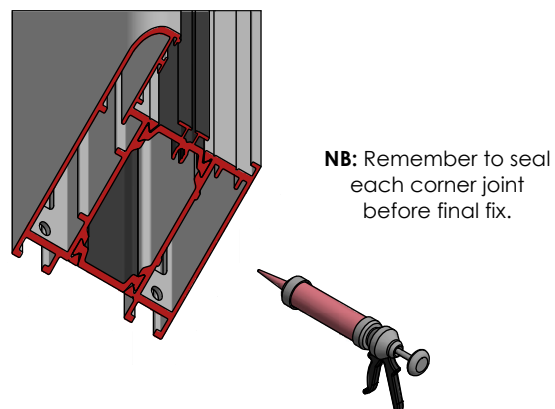
NB: Remove excess sealant with Aluk sealant wipes (T50003).



VENT ASSEMBLY BOTTOM (SHOOTBOLT PART 2)



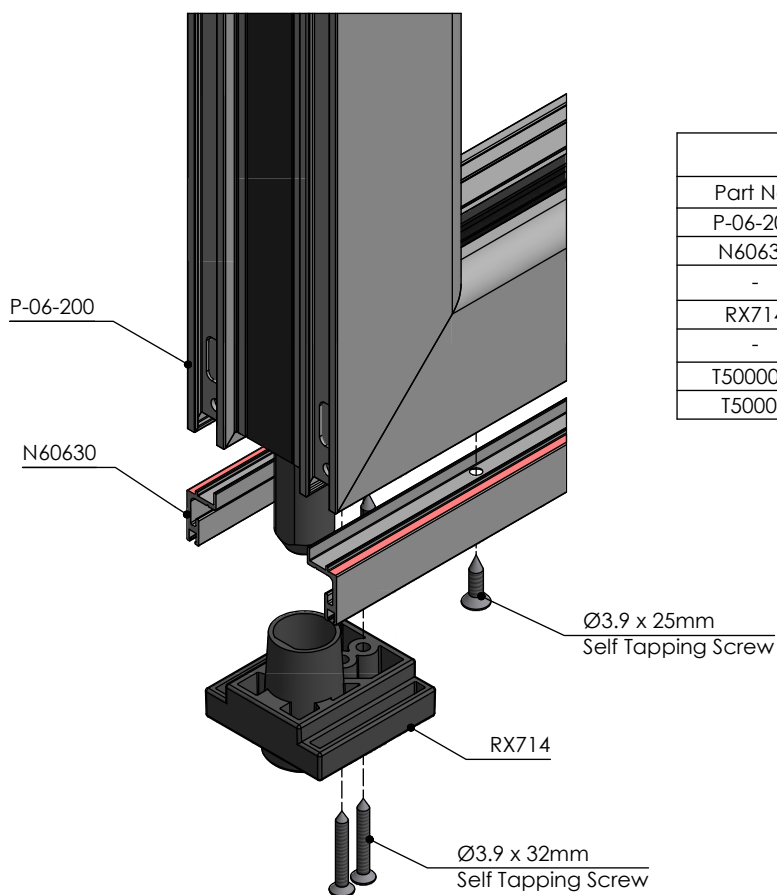
Shootbolt Assembly Parts List (Per Corner)		
Part No.	Description	Qty
RX601	13.7mm Mechanical cleat	2
P-06-200	Softline Leaf	2
A-GS-240	Slide In Gasket	2
RX710	Shootbolt pack	1
A-00-110A	Mechanical cleat tensioning block	4
T50000-2	Small joint sealant	-
T50003	Aluk sealant wipes	-



NB: Remove excess sealant with Aluk sealant wipes (T50003).



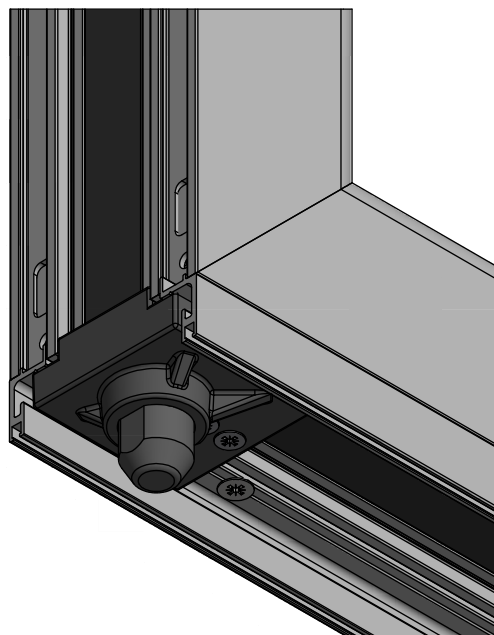
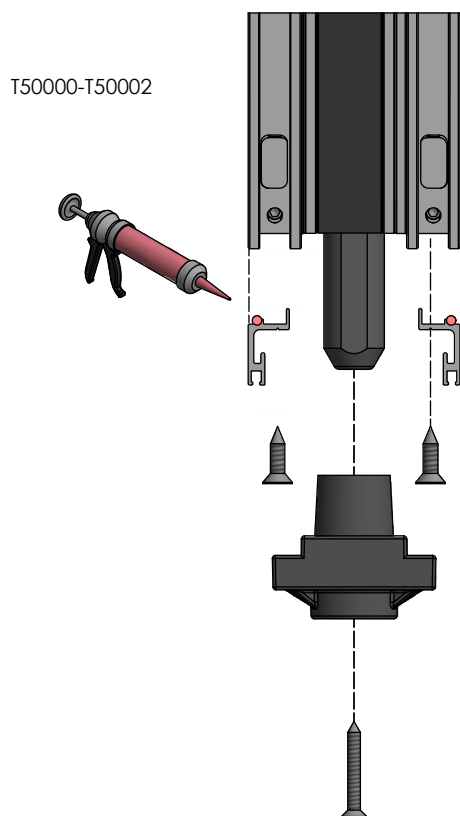
VENT ASSEMBLY BOTTOM SHOOTBOLT GUIDE



Bottom Shootbolt Guide Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	2
N60630	Threshold Adaptor	2
-	Ø3.9 x 32mm CSK Self Tapping Screw	2
RX714	Bottom Guide	1
-	Ø3.9 x 25mm CSK Self Tapping Screw	2
T50000-2	Small joint sealant	-
T50003	ALUK sealant wipes	-

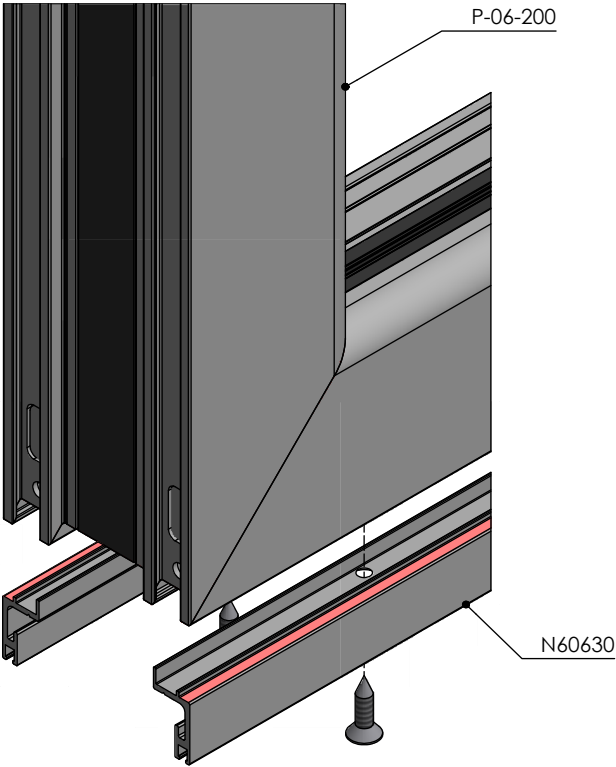
NB: Remember to seal joint before final fix.

NB: Remove excess sealant with Aluk sealant wipes (T50003).



NB: Shootbolt must protrude 40mm from P-06-200 profile when in a locked position

➤ THRESHOLD ADAPTOR

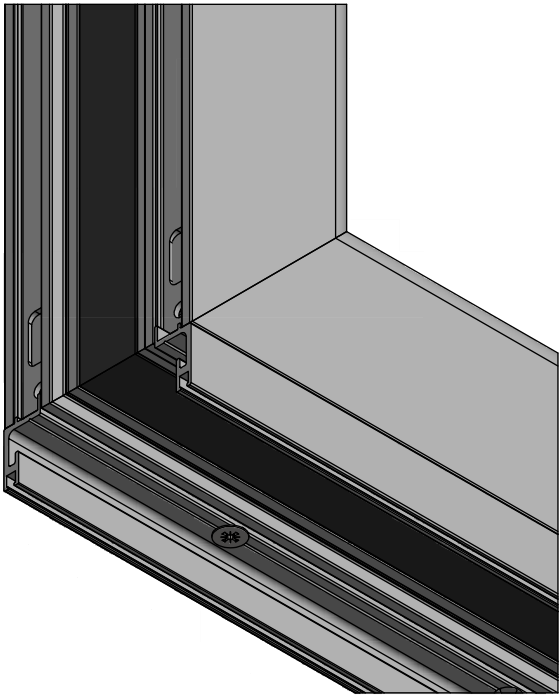
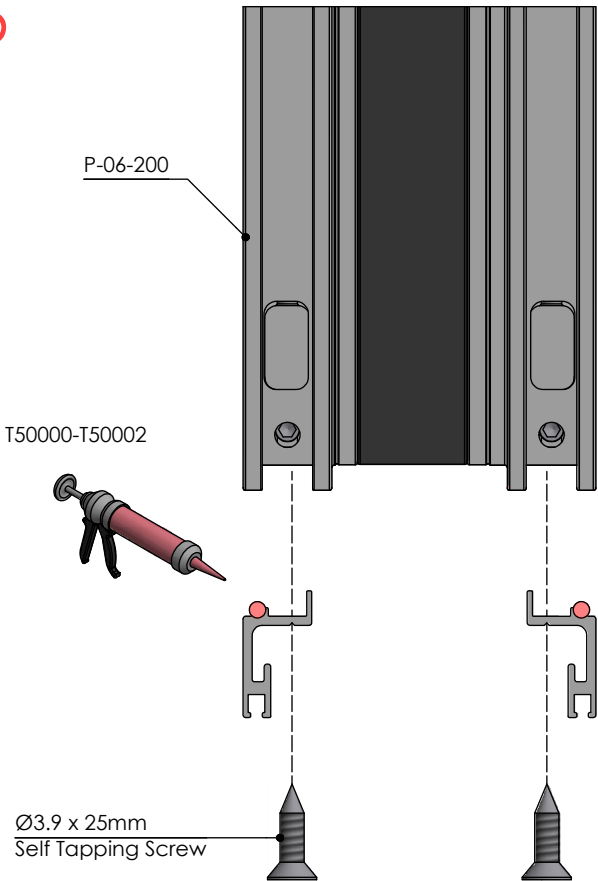


Threshold Adaptor Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	2
N60630	Threshold Adaptor	2
-	Ø3.9 x 25mm CSK Self Tapping Screw	2
T50000-2	Small joint sealant	-
T50003	Aluk sealant wipes	-

NB: Remember to seal each joint before final fix.



NB: Remove excess sealant with Aluk sealant wipes (T50003).



TOP & BOTTOM GUIDE ADJUSTMENT

To position the shootbolt guides correctly each end guide must be extended to at least 8mm into the outer frame (P-06-100A), see below.

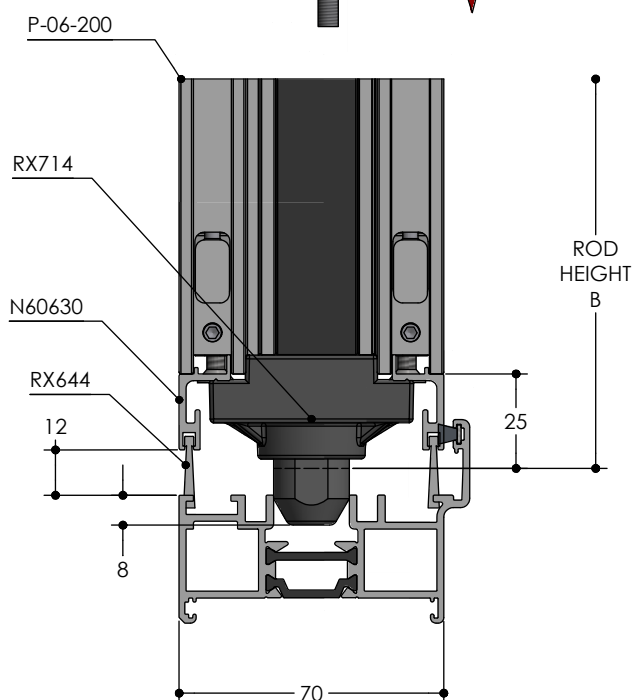
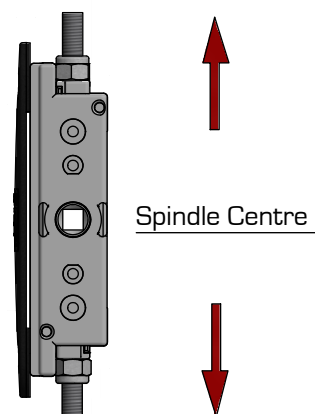
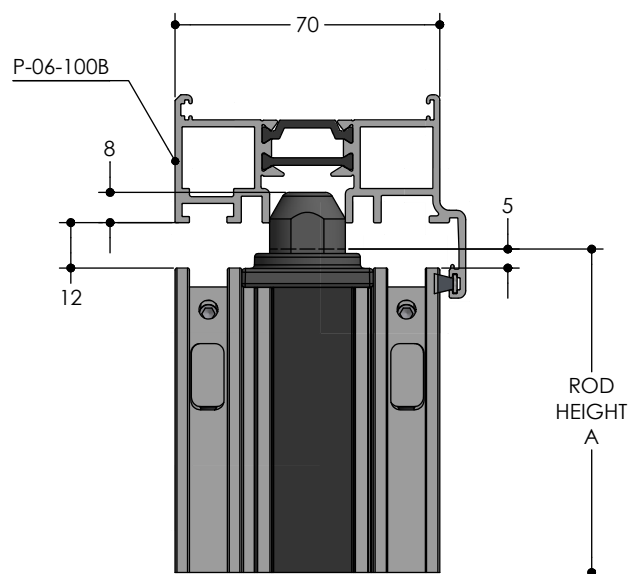
Shootbolt Guide Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	2
P-06-100B	Outerframe	2
N60630	Threshold Adaptor	2
RX644	19mm Low threshold brush woolpile - 3m	2
RX711	T-Handle Geat Box	
RX714	Bottom Guide	1

$(LH - \text{Spindle Height}^*) - 50 = \text{Rod Height A}$

$\text{Spindle Height}^* - 30\text{mm} = \text{Rod Height B}$

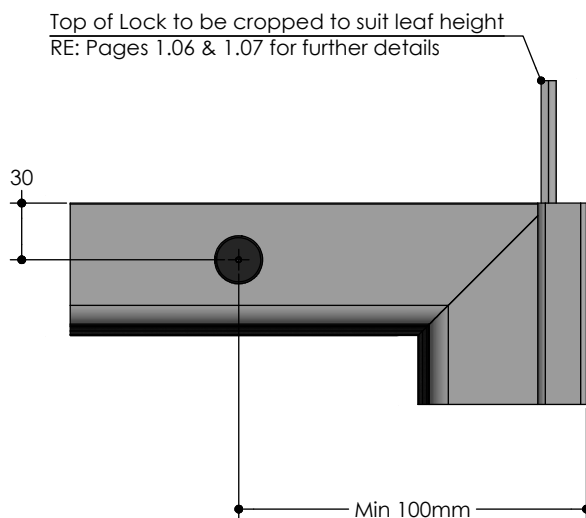
* Spindle height does not include N60630 (20mm Threshold Adaptor)

Wind rod into gear box in retracted open position

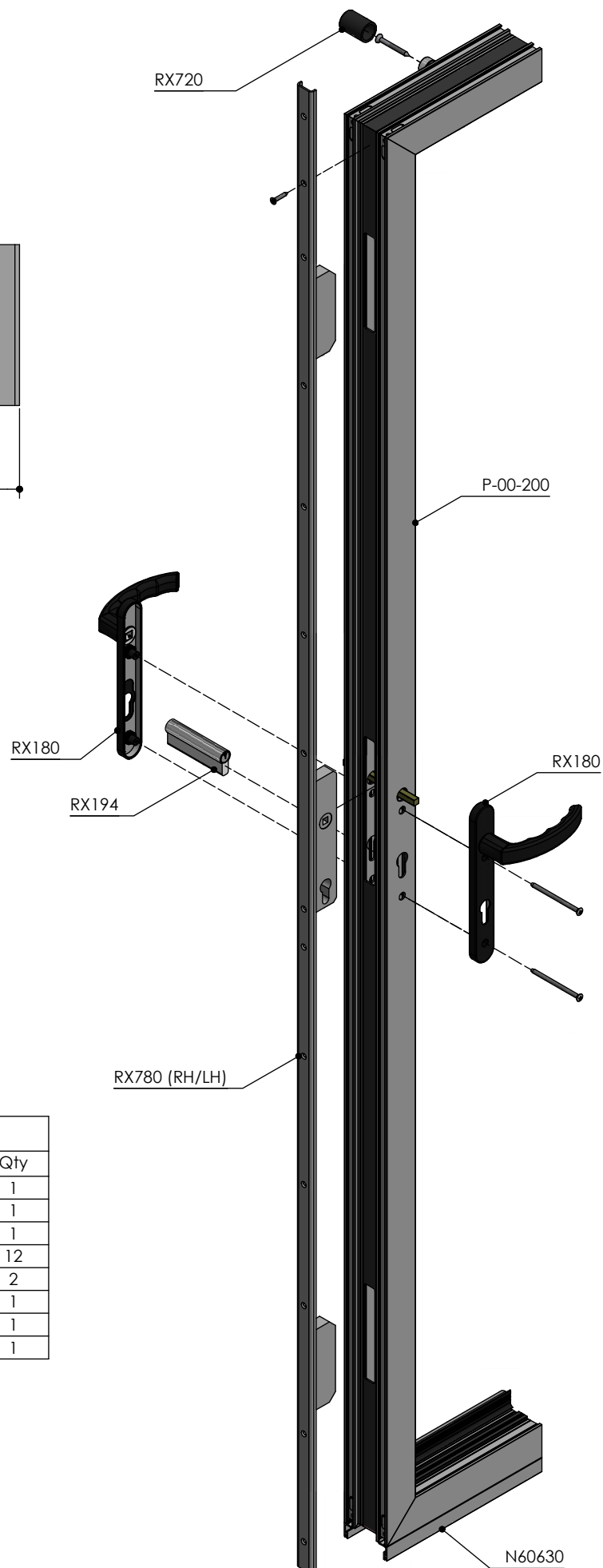


NB: Adjustment can only be made before the shootbolt and rod assembly is inserted into the lock style (P-06-200). See page 3 - 08 for further details.

TRAFFIC DOOR HANDLE & LOCK



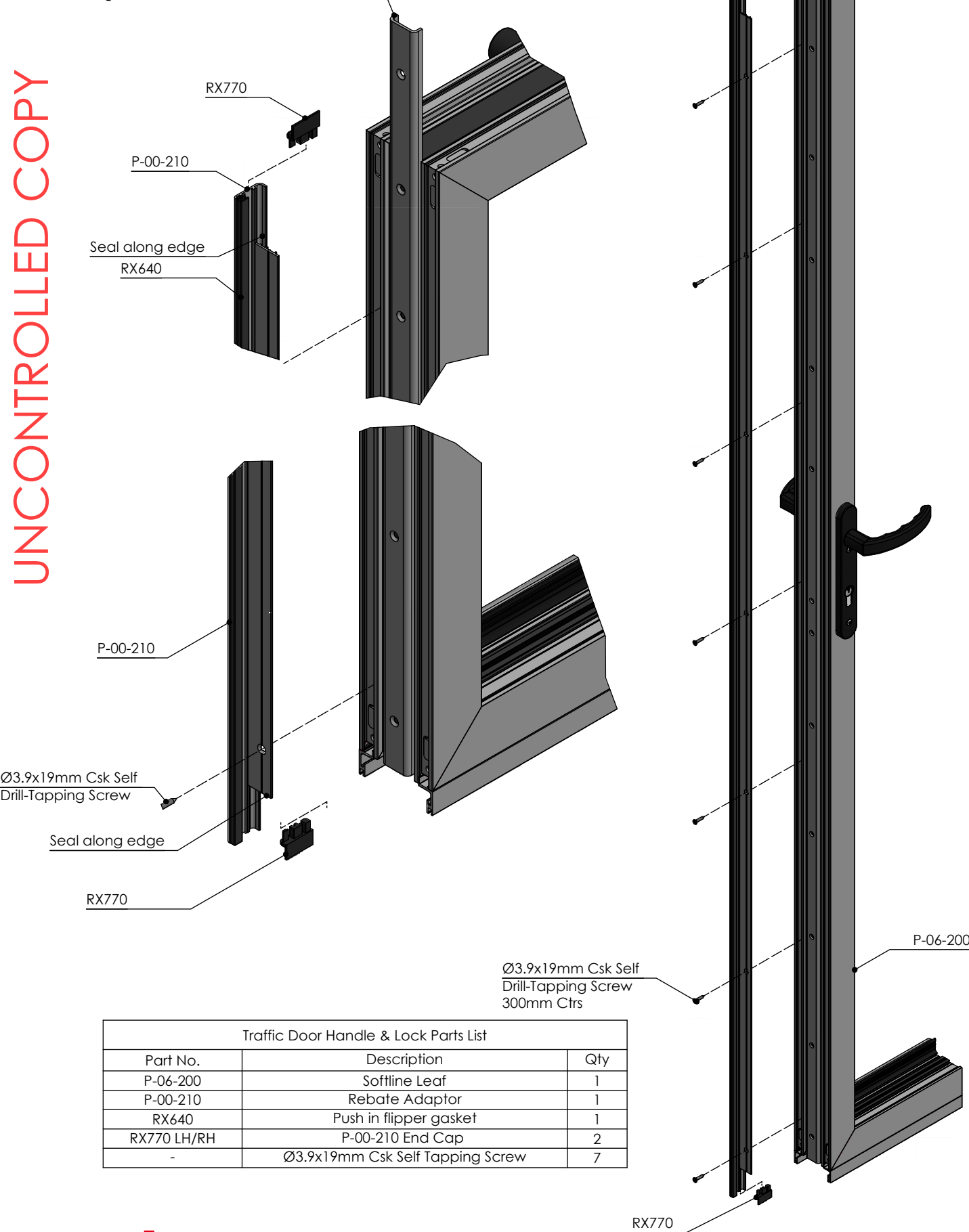
Fix Magnetic Catch (RX720) to the top/bottom rail, a minimum of 100mm from the lock side edge, with supplied screw.



Traffic Door Handle & Lock Parts List		
Part No.	Description	Qty
P-06-200	Softline Vent	1
RX180	Lever/Lever Handle (*Colour)	1
RX720	Traffic Door Magnetic Catch	1
-	Ø4.2x25mm Csk Self Tapping Screw	12
N60630	Threshold Adaptor	2
RX780 LH/RH	Winhaus Traffic Door Lock	1
RX783 LH/RH	Winhaus Traffic Short Door Lock	1
RX194	45/45 Standard cylinder	1

REBATE ADAPTOR

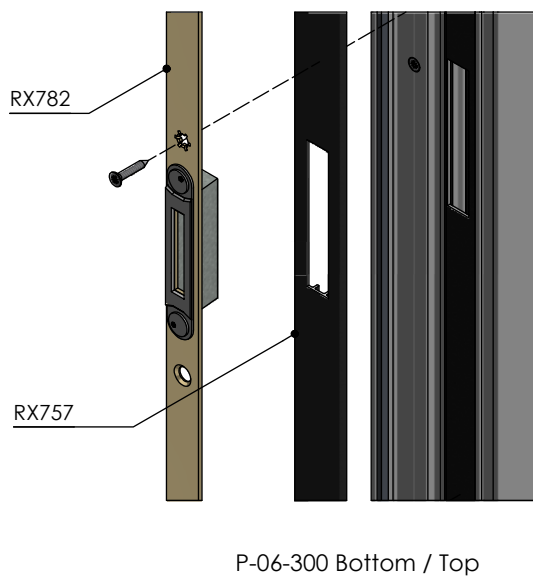
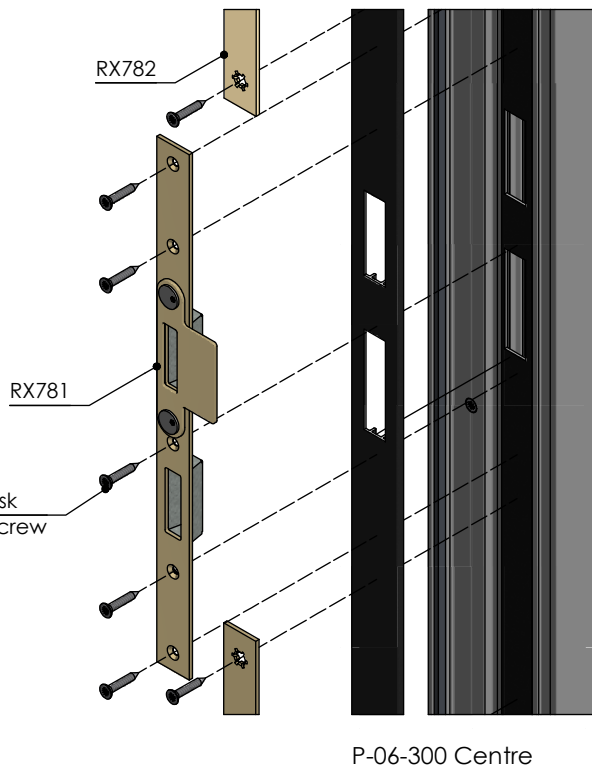
Top of Lock to be cropped to suit leaf height
RE: Pages 1.06 & 1.07 for further details



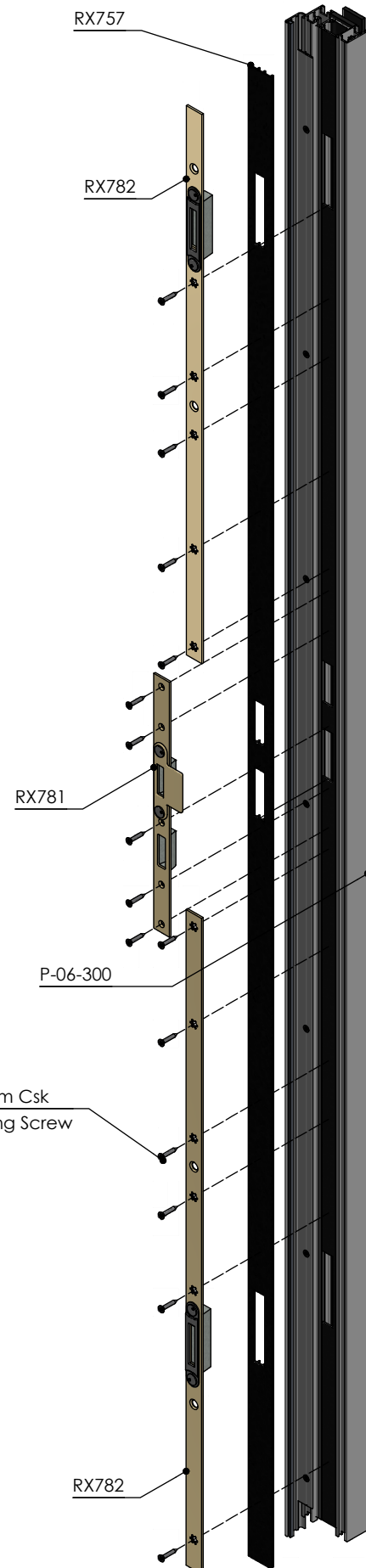
Traffic Door Handle & Lock Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
P-00-210	Rebate Adaptor	1
RX640	Push in flipper gasket	1
RX770 LH/RH	P-00-210 End Cap	2
-	Ø3.9x19mm Csk Self Tapping Screw	7

WINKHAUS KEEP ASSEMBLY

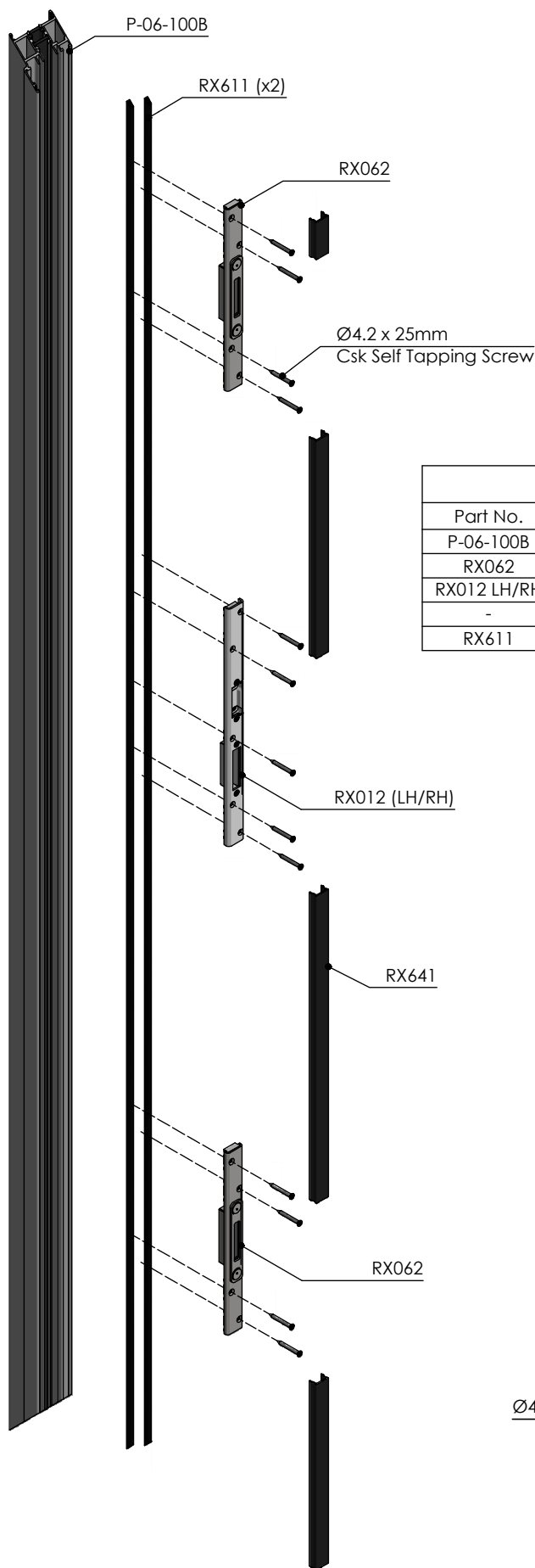
Floating Mullion Parts List		
Part No.	Description	Qty
P-06-300	Floating Mullion	1
P-00-211	Threshold Adaptor	1
RX757	Keep packer	1



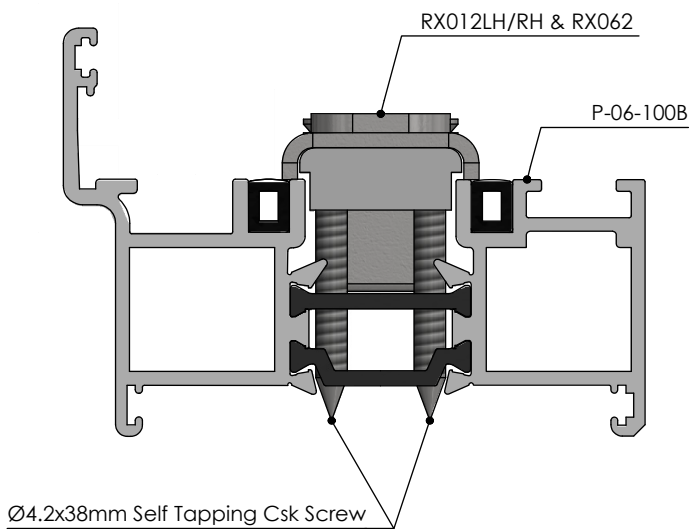
Top & Bottom Keeps Parts List		
Part No.	Description	Qty
RX782	Winkhaus Top/Bottom Keep	2
RX781 LH/RH	Winkhaus Centre Keep (LH & RH)	1
-	Ø4.2x25mm Csk Self Tapping Screw	25

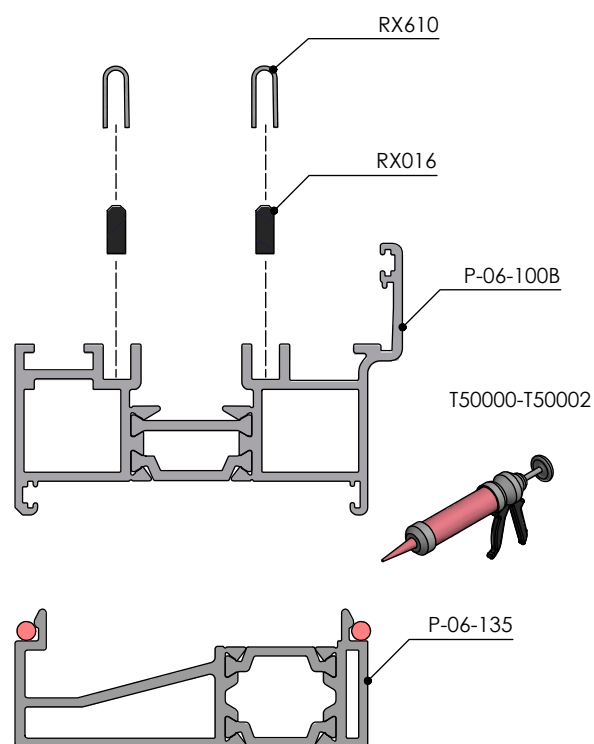
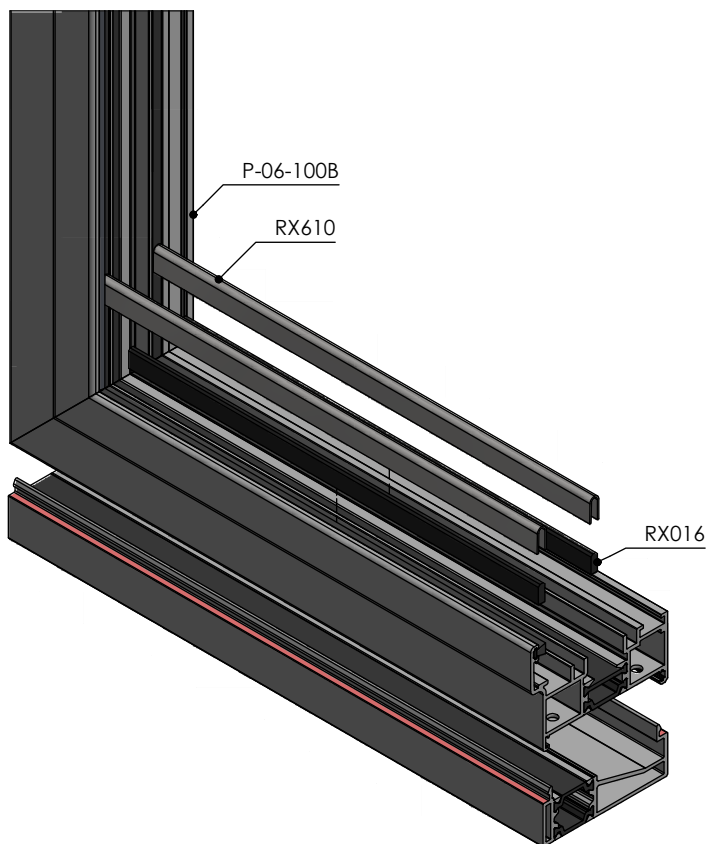


➤ WINKHAUS PAS 24 SECURITY KEEP ASSEMBLY



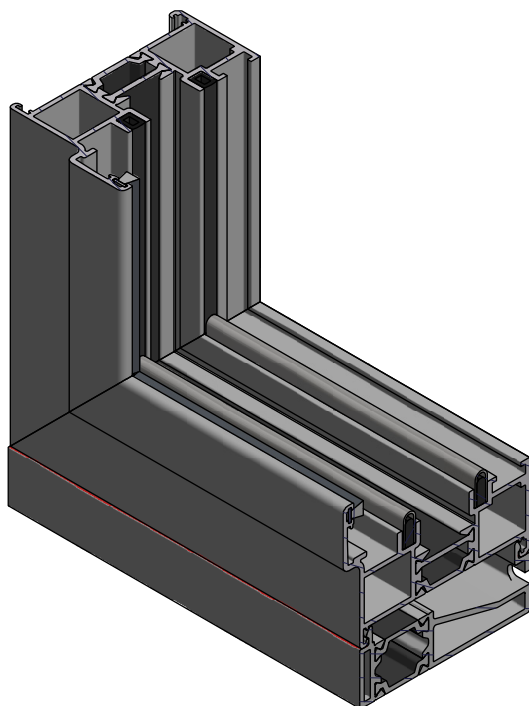
Parts List		
Part No.	Description	Qty
P-06-100B	Outerframe	1
RX062	Winkhaus FSD SBD Top/Bottom Keep	2
RX012 LH/RH	Winkhaus FSD SBD Centre Keep Left/Right Hand	1
-	Ø4.2x38mm Self Tapping Csk Screw	13
RX611	FSD Track Seal	2





Rebated threshold

NB: Remember to seal each profile joint before final fix.

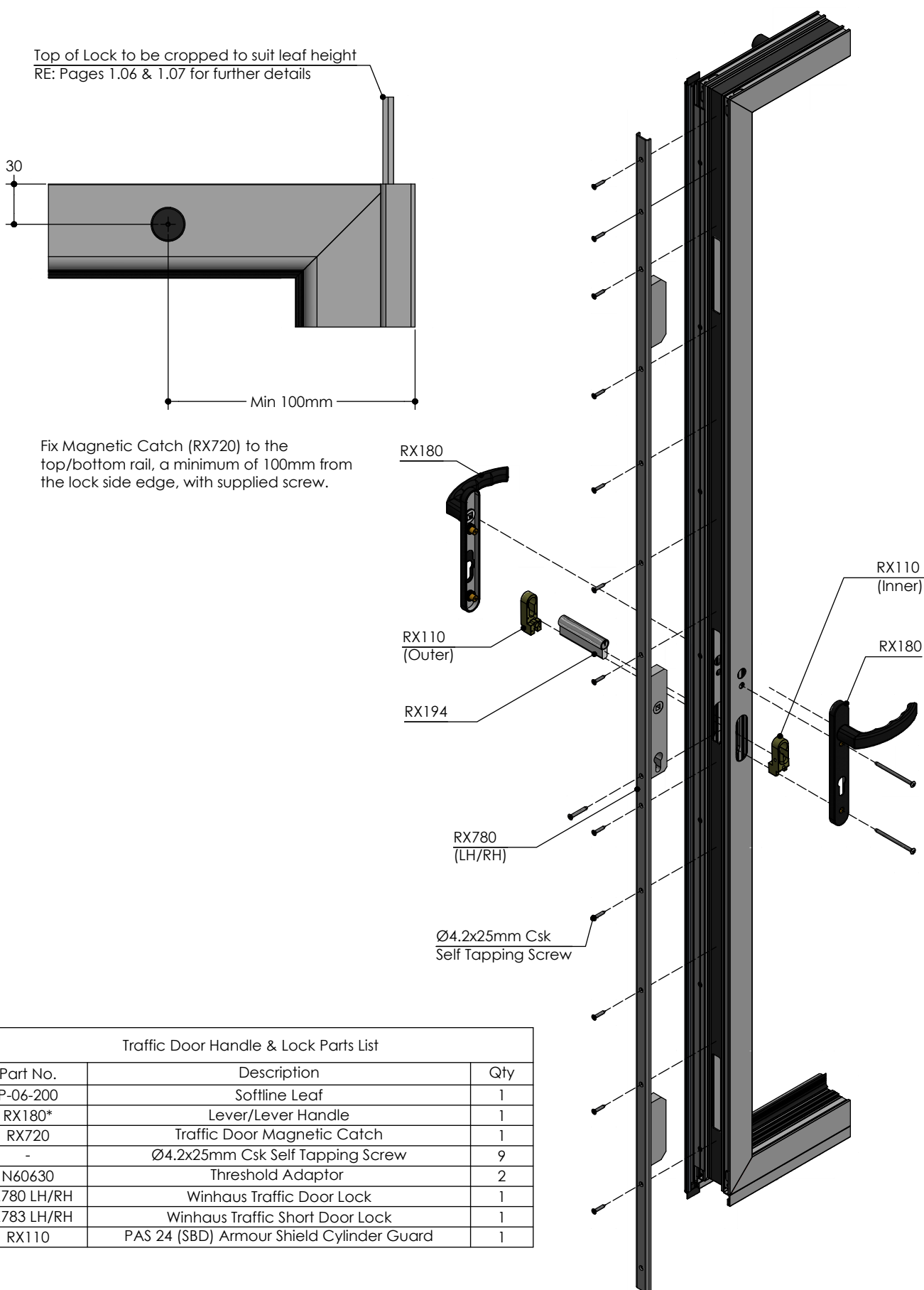


Low Threshold Parts List (Per Corner)		
Part No.	Description	Qty
P-06-100B	Outerframe	1
P-06-130	Low Threshold	1
RX957	4.8 600 EC Grey Woolpile	1
RX643	Frame Jamb Plug (A)	1
RX642	Frame Jamb Plug (B)	1
RX641	Centre Jamb Clip	1
-	Ø4.8mm x 32 Self Drill Posi Pan Head	2
RX016	Reinforced Track Insert	2
T50000-2	Small joint sealant	-
T50003	Aluk sealant wipes	-

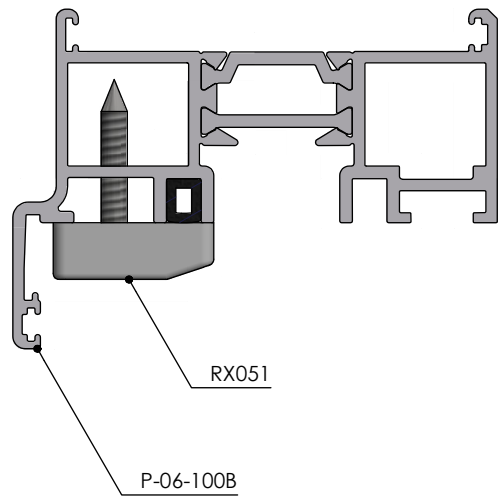
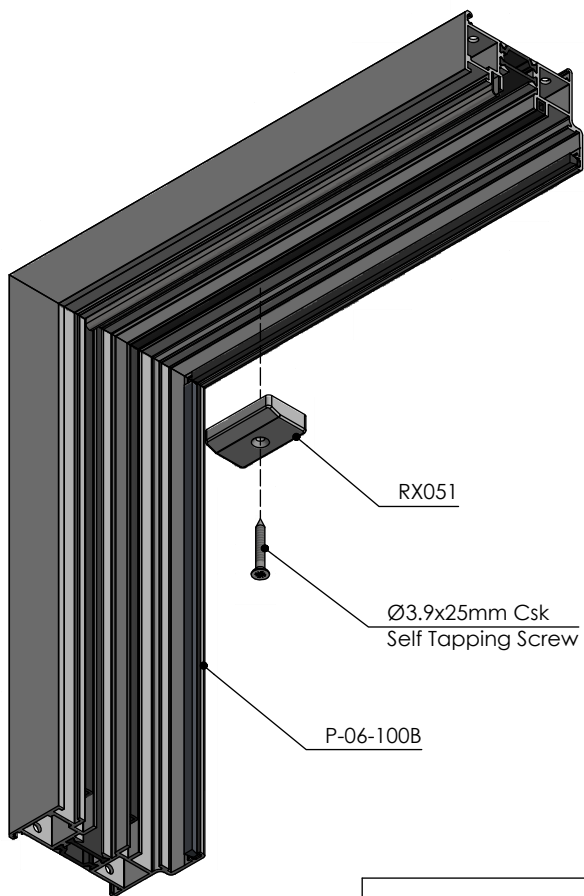
NB: Remove excess sealant with Aluk sealant wipes (T50003).



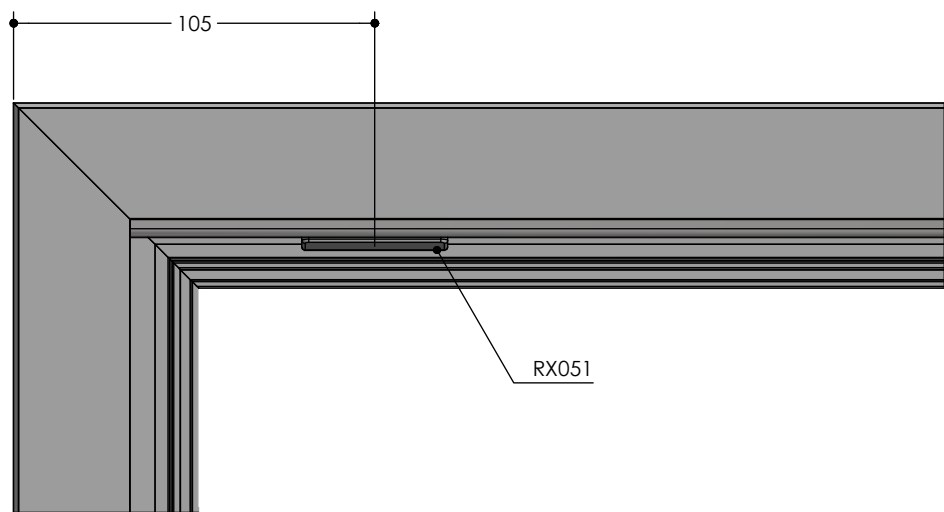
PAS 24 ARMOUR SHIELD CYLINDER GUARD



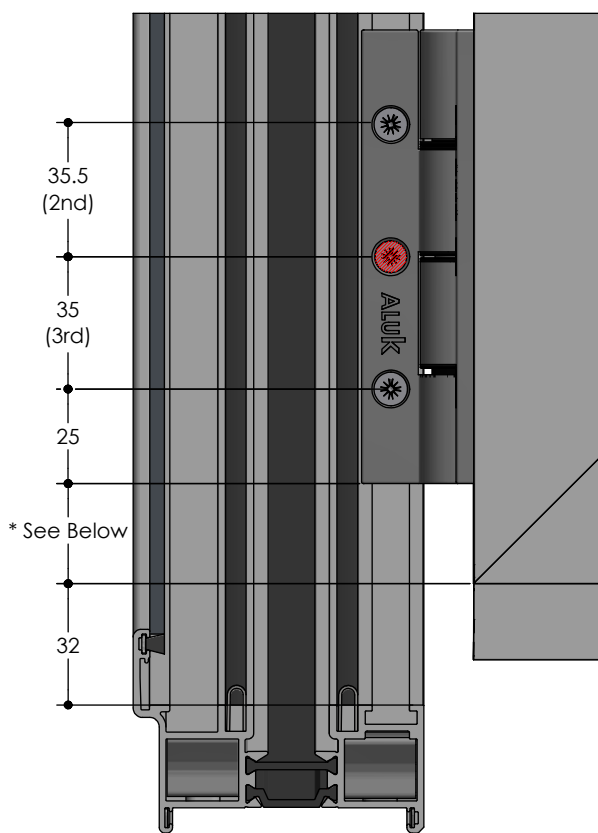
➤ PAS 24 ANTI JEMMY BLOCK



Anti Jemmy Parts List		
Part No.	Description	Qty
P-06-100B	Outerframe	2
RX051	Anti Jemmy Block	1
-	Ø3.9x25mm Csk Self Tapping Screw	1
RX611	FSD Track Seal	2



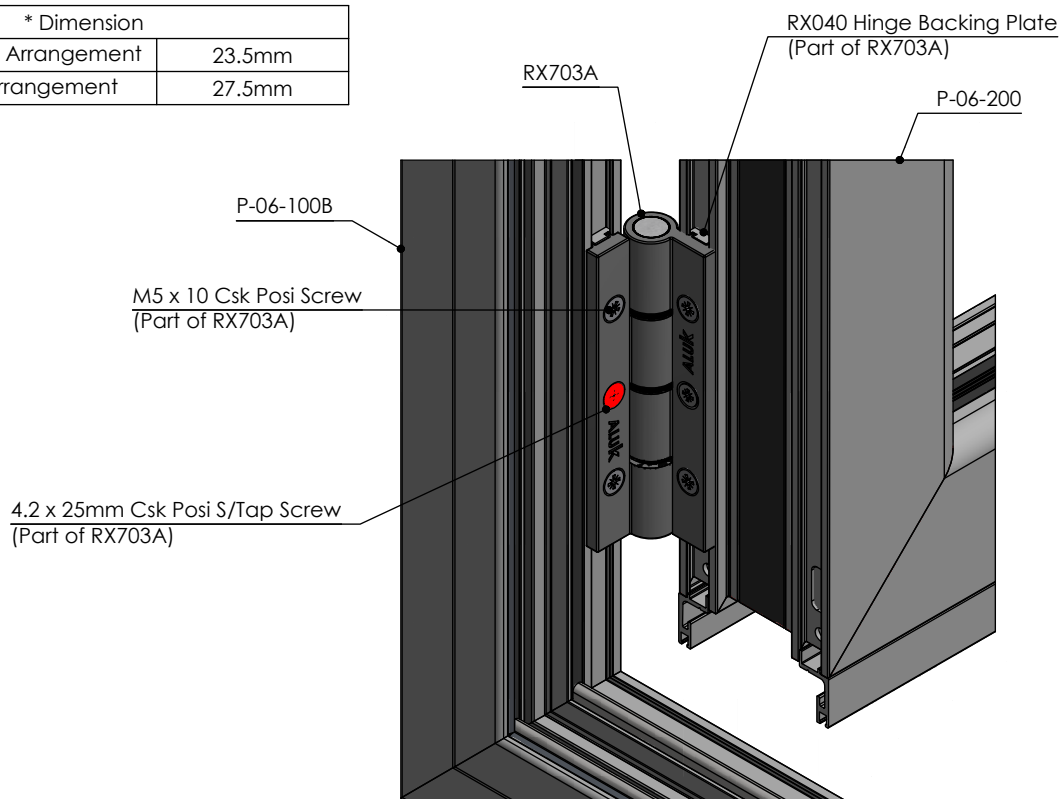
▶ BOTTOM HINGE TO FRAME ASSEMBLY



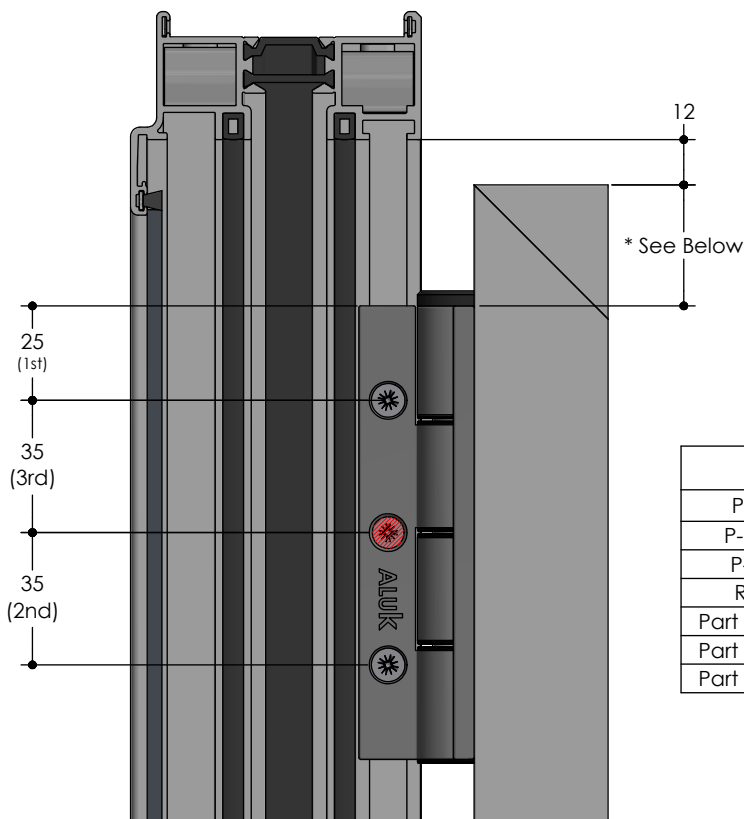
Parts List		
Part No.	Description	Qty
P-06-100B	Outerframe	1
P-06-200	Softline Leaf	1
RX703A	Hinge	1
Part of RX703A	Hinge Backing Plate	2
Part of RX703A	M5 x 10 Csk Posi Screw	4
Part of RX703A	4.8 x 25mm Csk Posi S/Tap Screw	2

Final fixing position

* Dimension	
Hinge Standard Arrangement	23.5mm
Heavy Duty Arrangement	27.5mm



➤ TOP HINGE TO FRAME ASSEMBLY

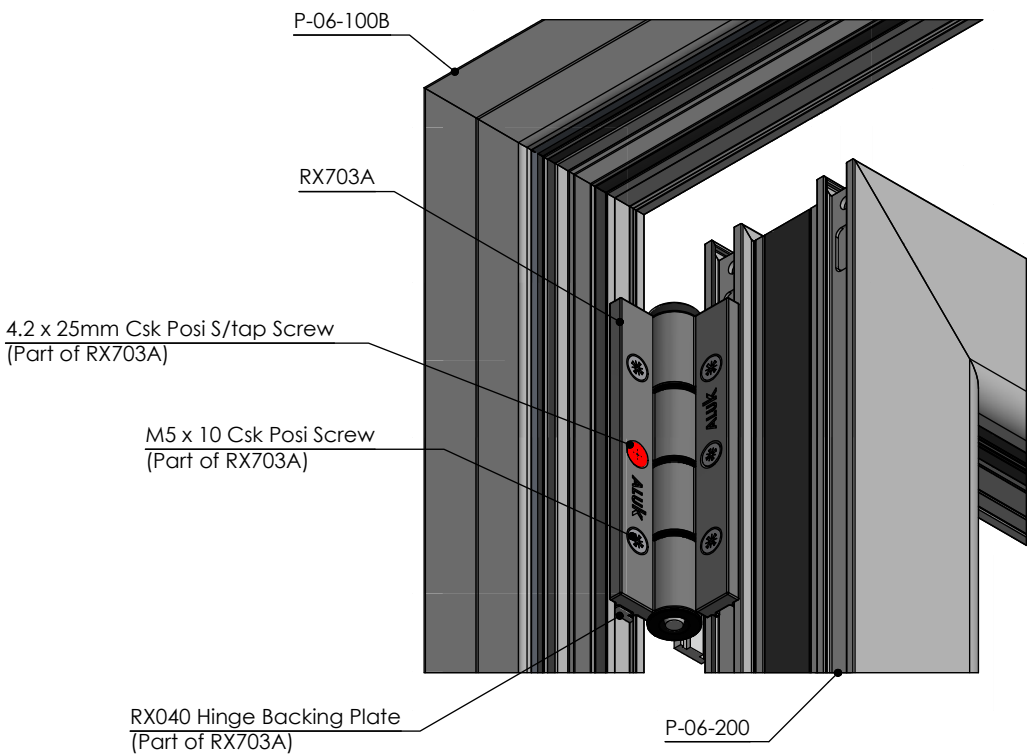


Parts List		
Part No.	Description	Qty
P-06-100B	Outerframe	1
P-06-200	Softline Leaf	1
RX703A	FSD Hinge	1
Part of RX703A	Hinge Backing Plate	2
Part of RX703A	M5 x 10 Csk Posi Screw	4
Part of RX703A	4.8 x 25mm Csk Posi S/Tap Screw	2

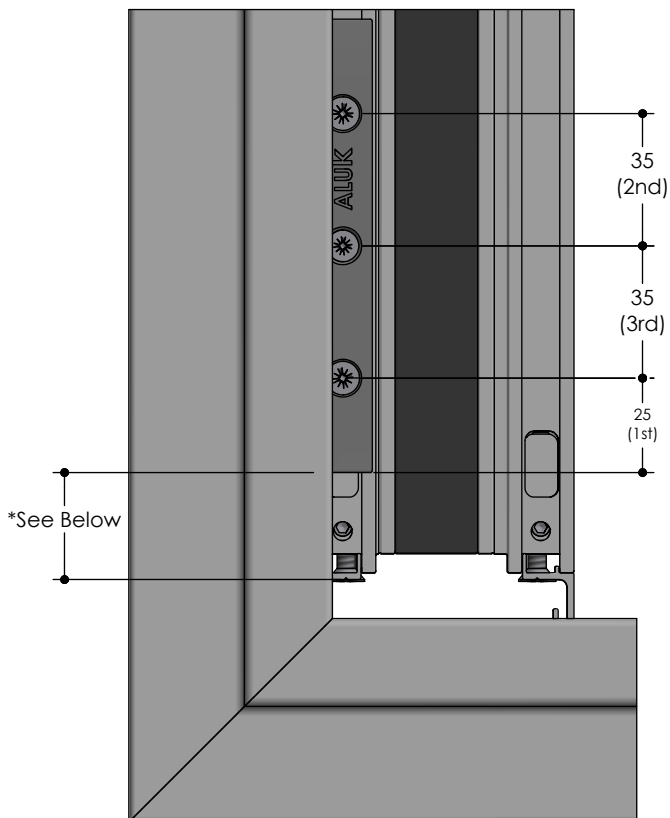
Use BSD635 hinge jig for position

* Dimension	
Hinge Standard Arrangement	31mm
Heavy Duty Arrangement	31mm

Final fixing position



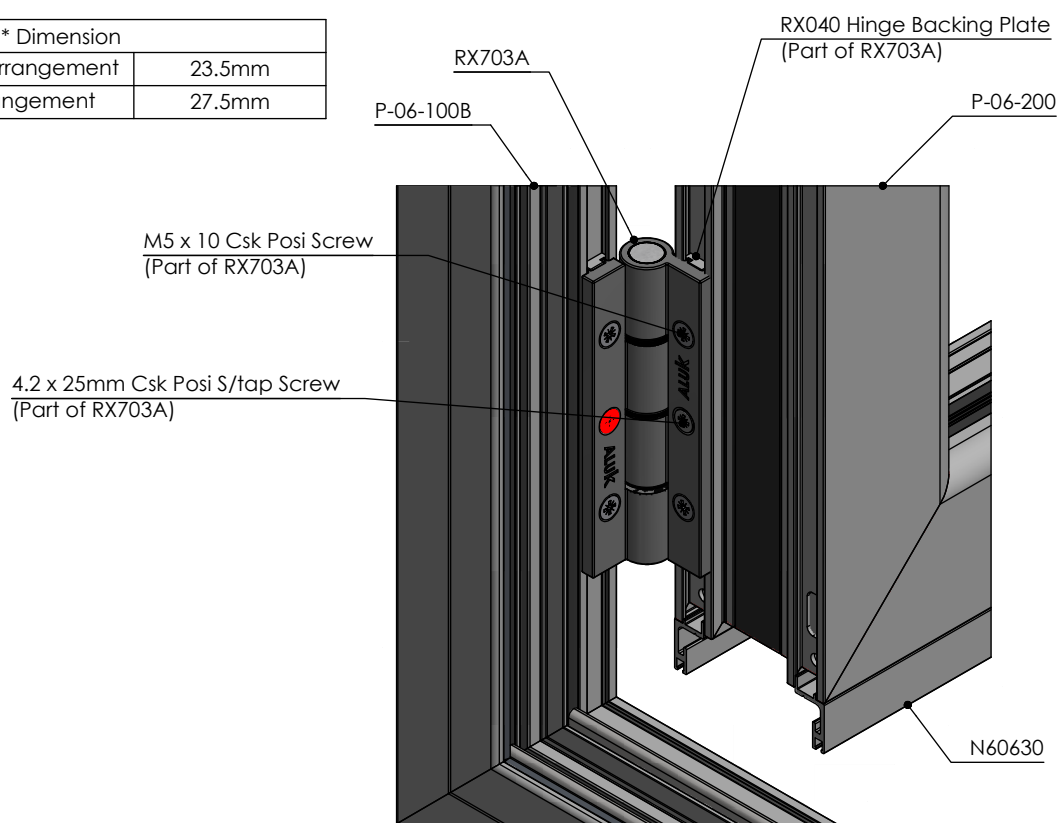
▶ BOTTOM HINGE TO SASH ASSEMBLY



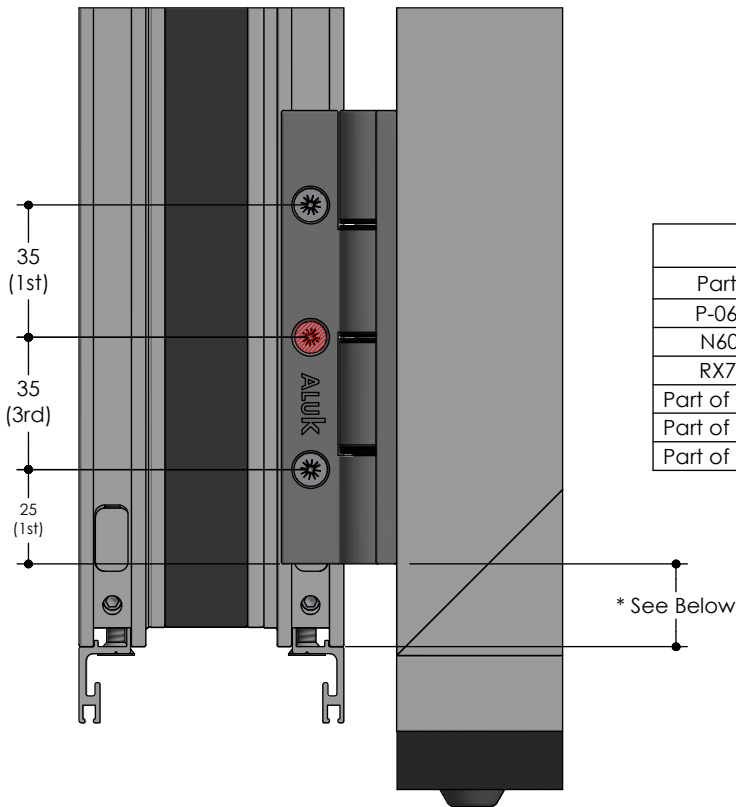
Parts List		
Part No.	Description	Qty
P-06-100B	Outerframe	1
P-06-200	Softline Leaf	1
N60630	Threshold Adaptor	2
RX703A	FSD Hinge	1
Part of RX703A	Hinge Backing Plate	2
Part of RX703A	M5 x 10 Csk Posi Screw	4
Part of RX703A	4.8 x 25mm Csk Posi S/Tap Screw	2

* Dimension	
Hinge Standard Arrangement	23.5mm
Heavy Duty Arrangement	27.5mm

Final fixing position

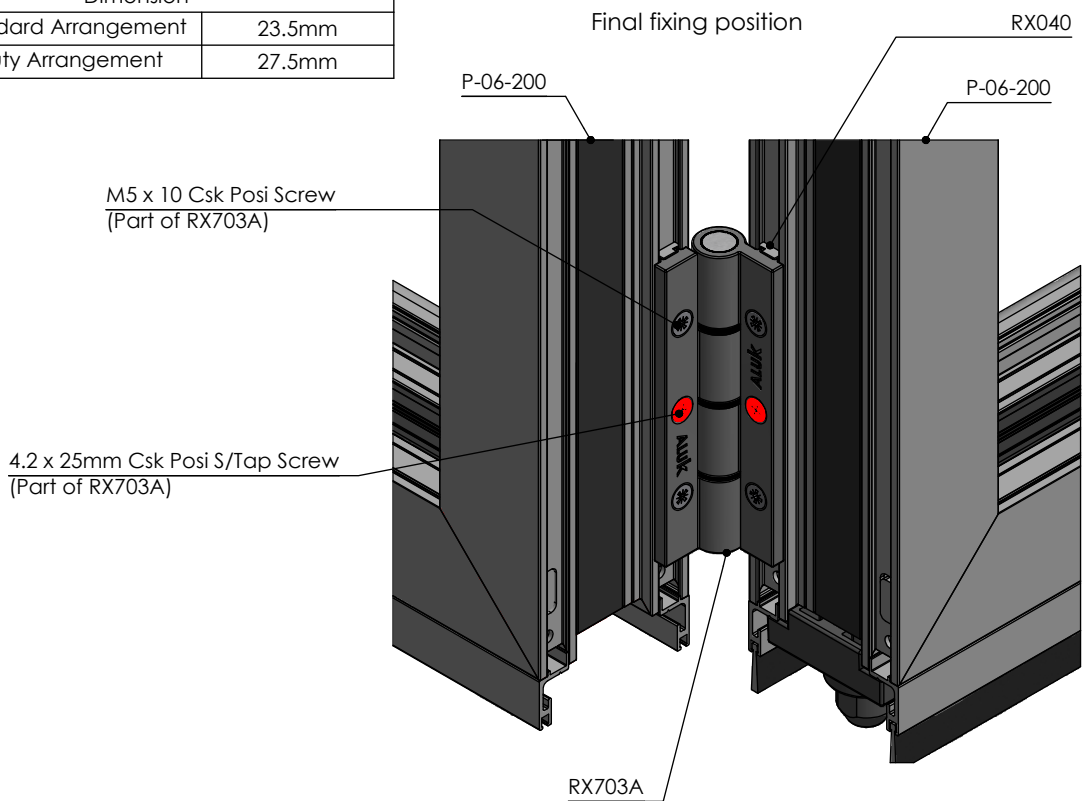


➤ BOTTOM HINGE INTERLOCK

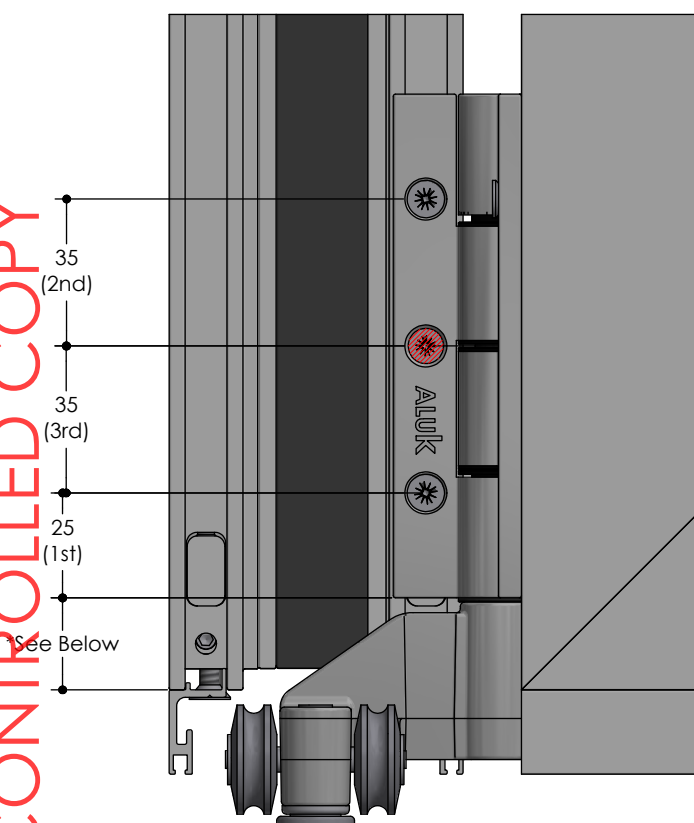


Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
N60630	Threshold Adaptor	1
RX703A	FSD Hinge	2
Part of RX703A	M5 x 10 Csk Posi Screw	4
Part of RX703A	Hinge Backing Plate	2
Part of RX703A	4.8 x 25mm Csk Posi S/Tap Screw	2

* Dimension	
Hinge Standard Arrangement	23.5mm
Heavy Duty Arrangement	27.5mm



▶ BOTTOM BOGIE ASSEMBLY

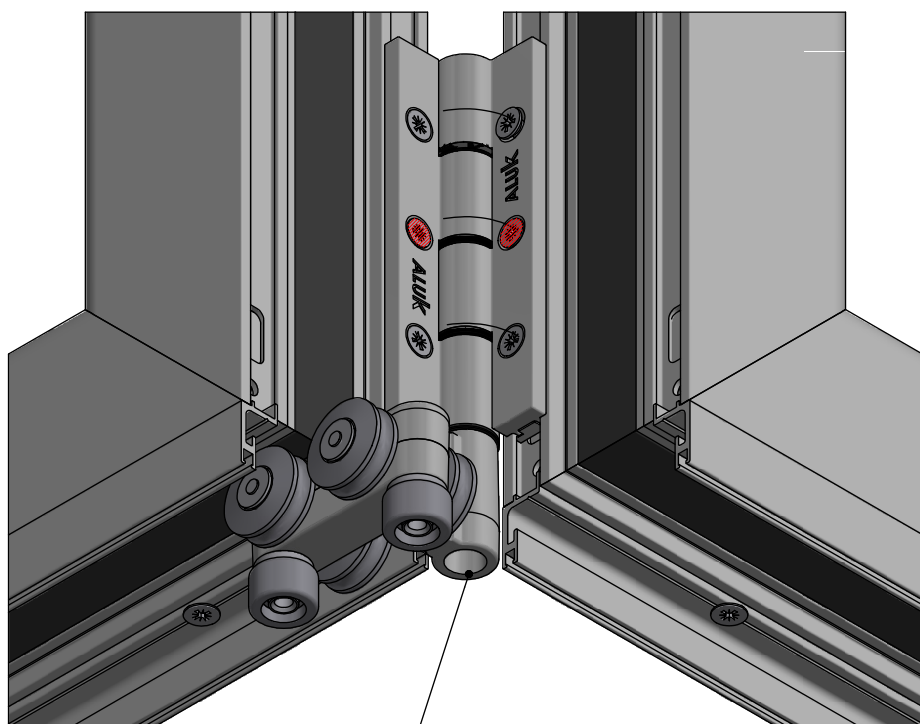


* Dimension	
Standard Bogie	23.5mm
Heavy Duty Bogie	27.5mm

Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
N60630	Threshold Adaptor	1
RX702A	FSD Bottom Bogie	1
Part of RX702A	M5 x 10 Csk Pos Screw	4
Part of RX702A	Hinge Backing Plate	2
Part of RX702A	4.8 x 25mm Csk Posi S/Tap Screw	2

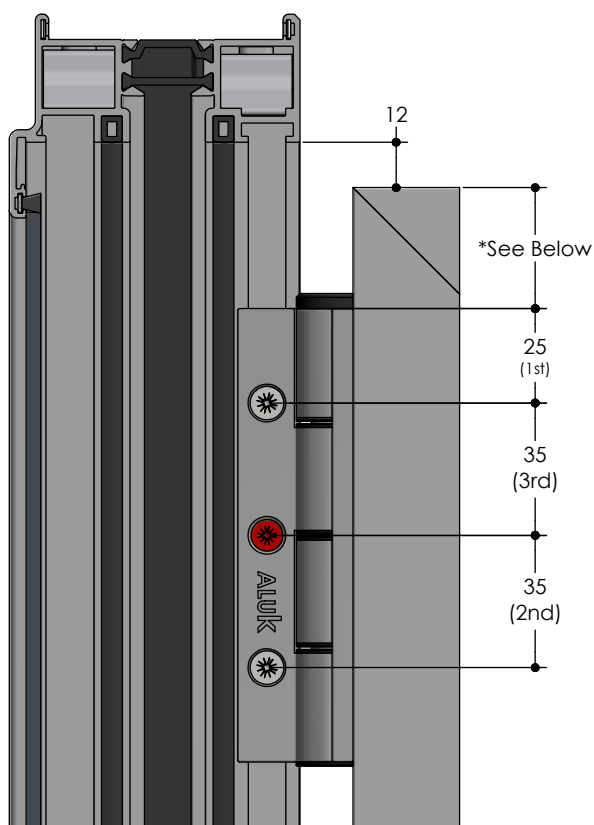
NB: For heavy duty roller, refer to table below. For preparation details see Page 9.27

Parts List		
Part No.	Description	Qty
RX706	HD Bottom Bogie	1
RX041	Hinge Back Plate	2
-	M5 x 10 Csk Pos Screw	4
-	4.8 x 25mm Csk Posi S/Tap Screw	2



RX702 (Standard)
RX706 (Heavy Duty)

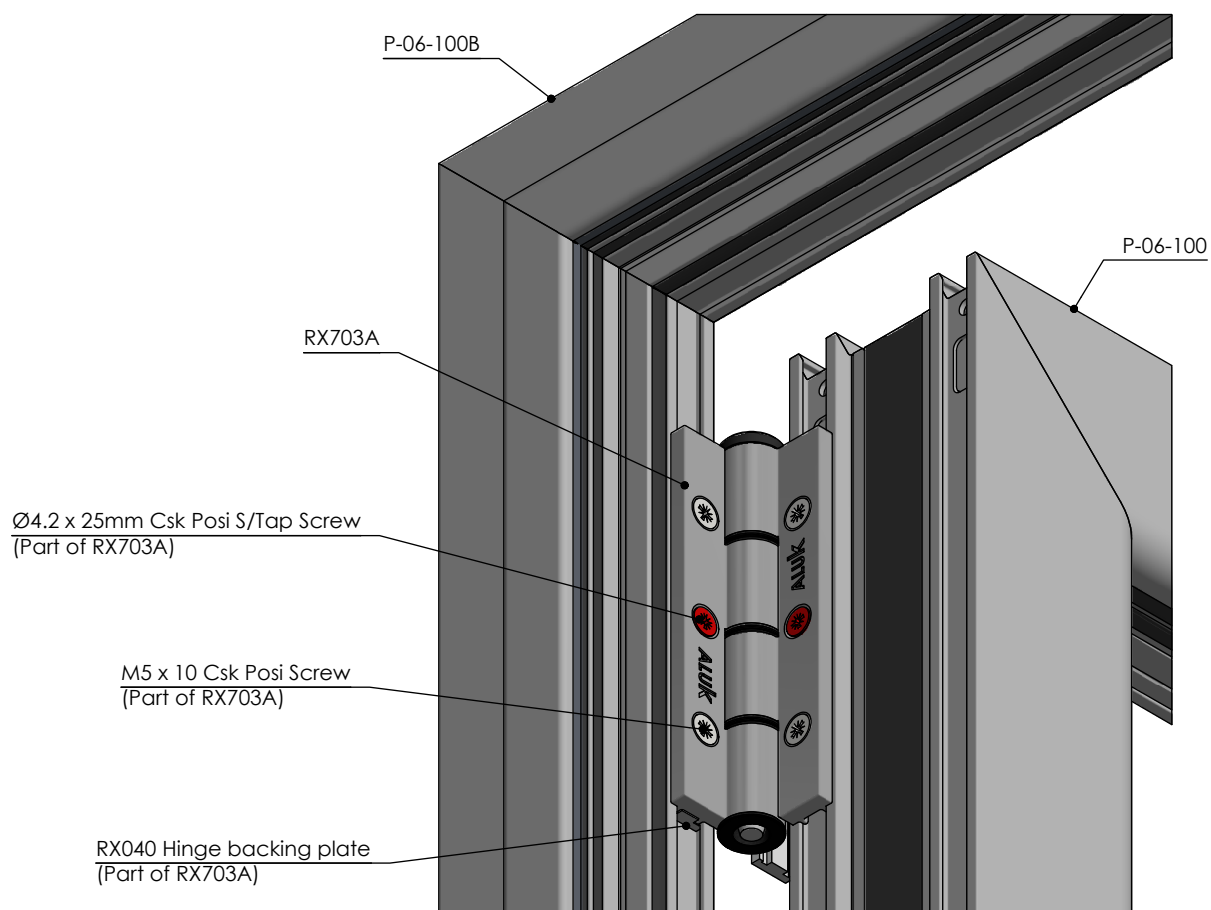
➤ TOP HINGE TO SASH ASSEMBLY



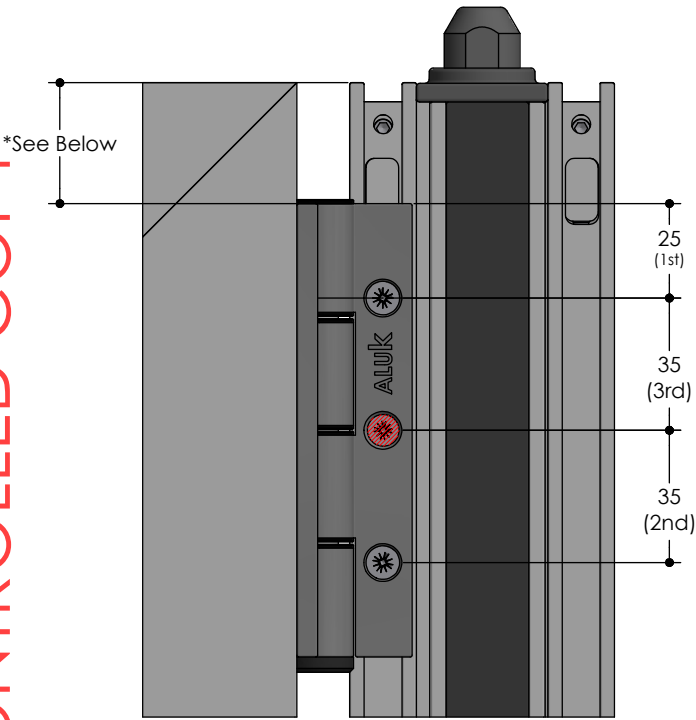
* Dimension	
Hinge Standard Arrangement	31mm
Heavy Duty Arrangement	31mm

Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
P-06-100B	Outerframe	1
RX703A	FSD Hinge	1
Part of RX703A	Hinge Backing Plate	2
Part of RX703A	M5 x 10 Csk Posi Screw	4
Part of RX703A	4.8 x 25mm Csk Posi S/Tap Screw	2

Final fixing position

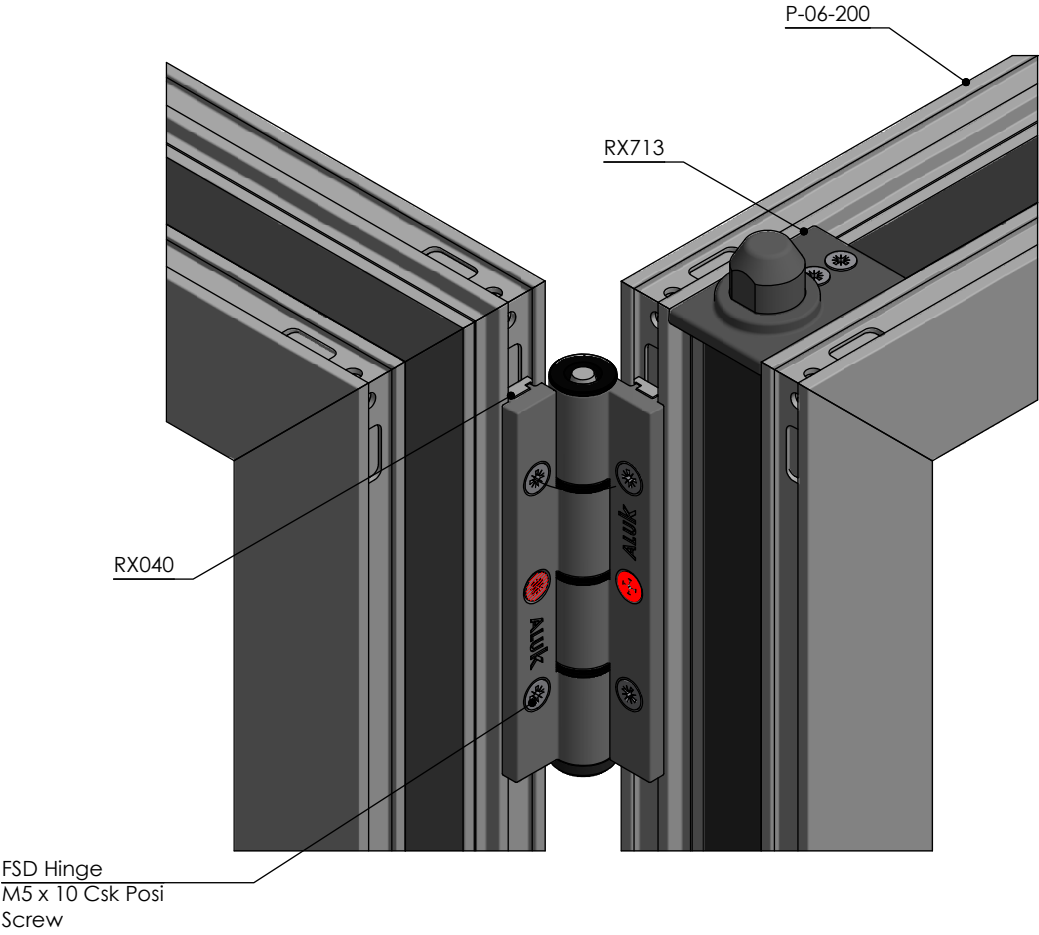


TOP HINGE INTERLOCK ASSEMBLY



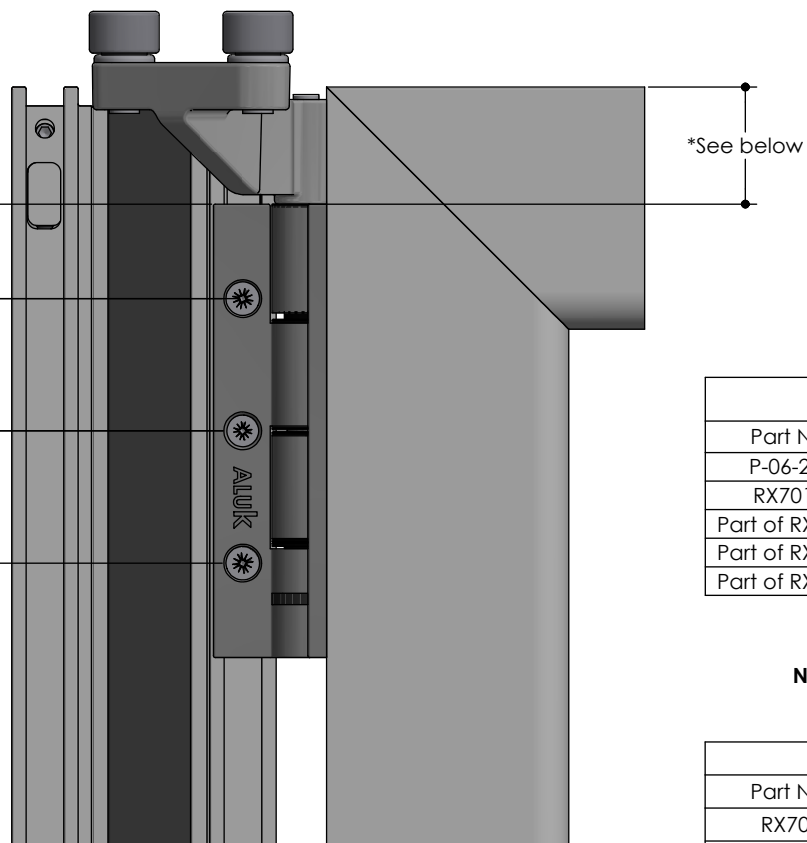
* Dimension	
Hinge Standard Arrangement	31mm
Heavy Duty Arrangement	31mm

Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
RX713	Shootbolt Guide	1
RX703A	FSD Hinge	1
Part of RX703A	M5 x 10 Csk Posi Screw	4
Part of RX703A	Hinge Backing Plate	2
Part of RX703A	4.8 x 25mm Csk Posi S/Tap Screw	2



TOP BOGIE ASSEMBLY

UNCONTROLLED COPY

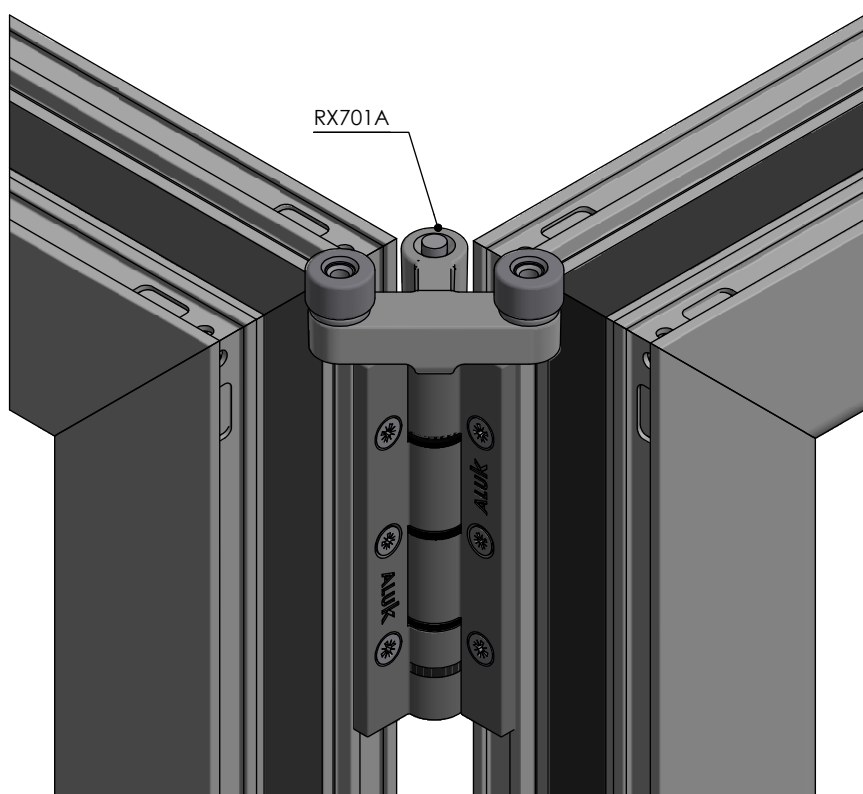


* Dimension	
Hinge Standard Arrangement	31mm
Heavy Duty Arrangement	31mm

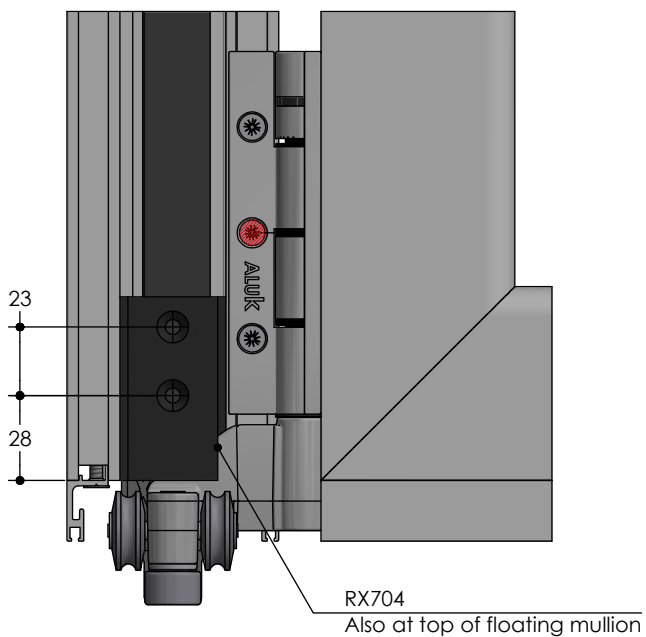
Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
RX701A	Top Bogie	1
Part of RX701A	M5 x 10 Csk Posi Screw	4
Part of RX701A	Hinge Backing Plate	2
Part of RX701A	4.8 x 25mm Csk Posi S/Tap Screw	2

NB: For heavy duty roller, refer to table below.

Parts List		
Part No.	Description	Qty
RX705	HD Top Bogie	1
RX040	Hinge Back Plate	2
-	M5 x 10 Csk Pos Screw	4
-	4.8 x 25mm Csk Posi S/Tap Screw	2



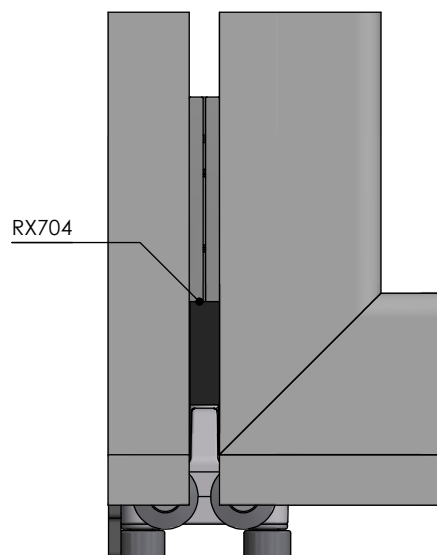
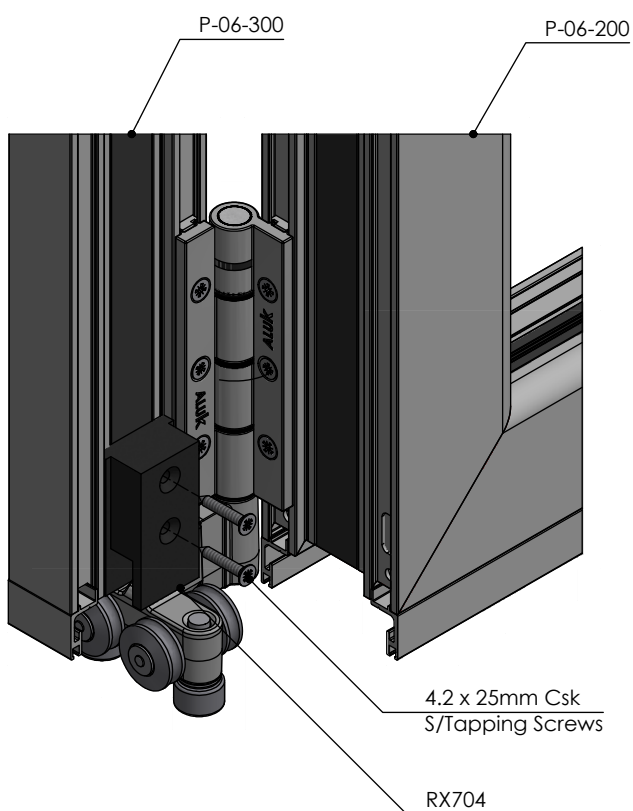
▶ BOTTOM ROLLER ASSEMBLY



Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
RX704	Floating Mullion Block	1
P-06-300	Floating Mullion	1
-	4.2 x 25mm Csk S/Tapping Screws	2

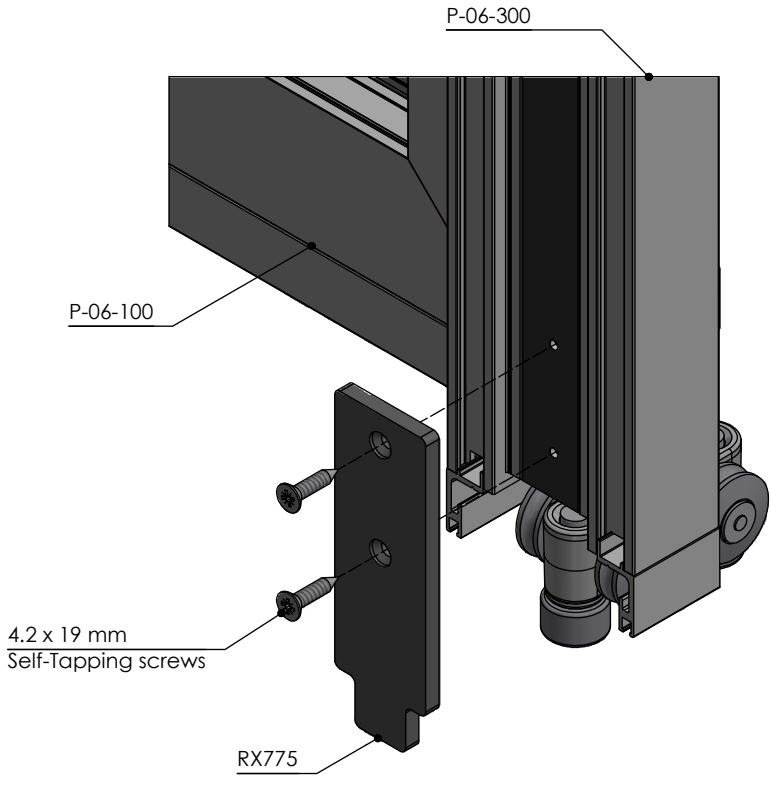
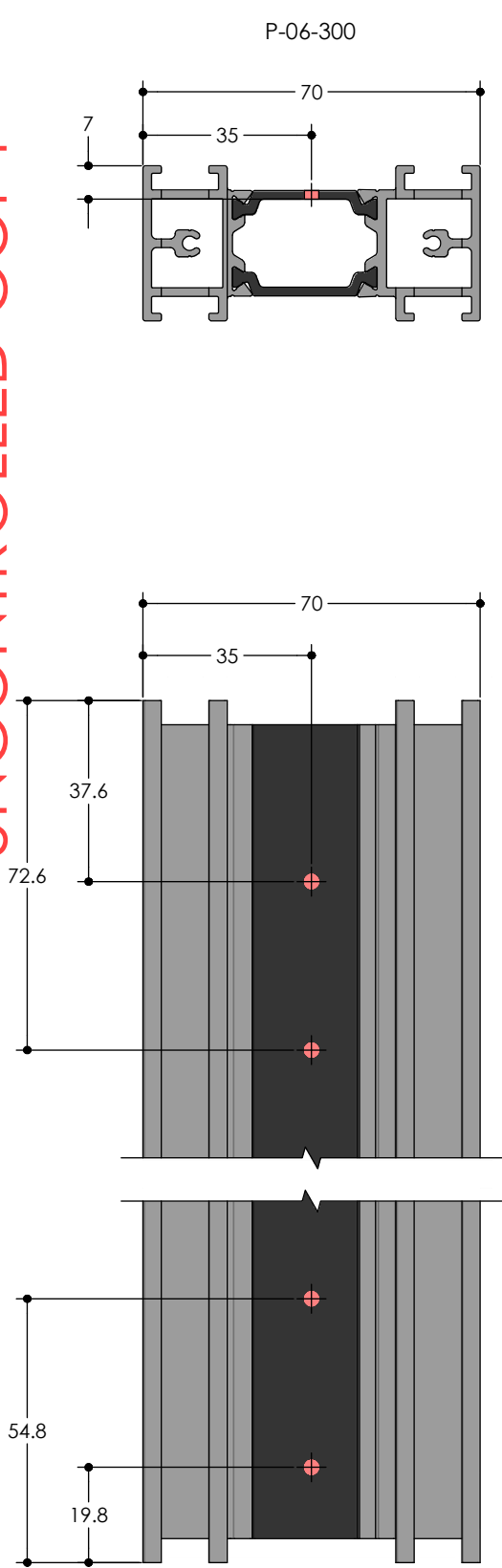
RX704 - Locked Position

Bottom Roller Assembly



NB: Please ensure that the locking block (RX704) is fitted to the top and bottom of the floating mullion (P-06-300).

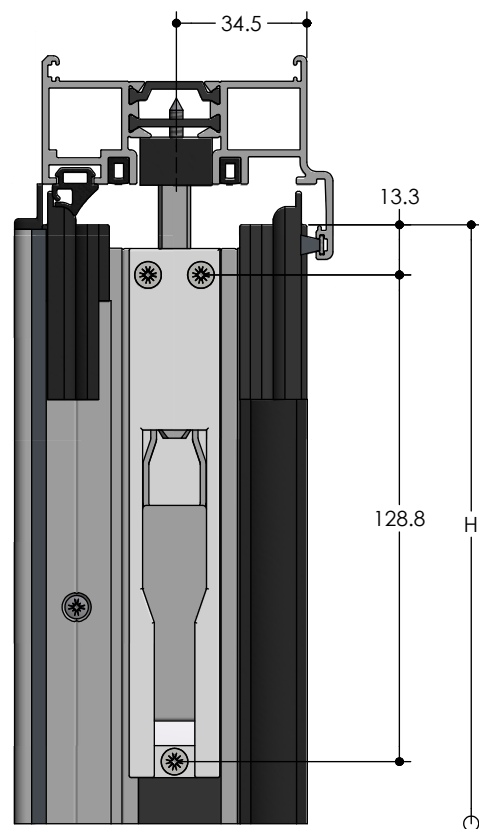
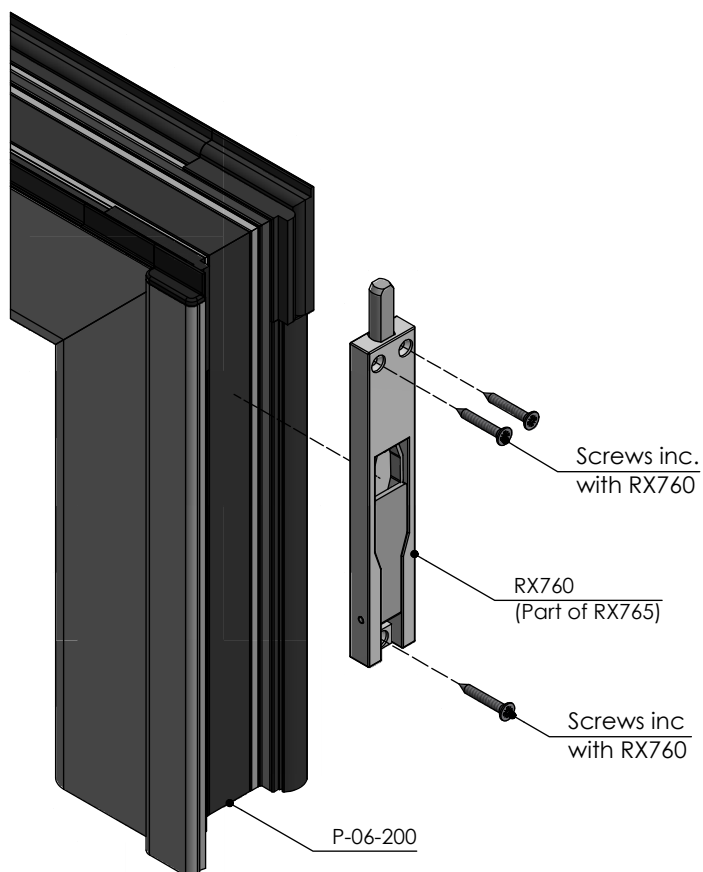
➤ ANTI TWIST GUIDE



Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
RX775	Floating Mullion Block	1
P-06-300	Floating Mullion	1
-	4.2x19mm Self-Tapping Screw	2

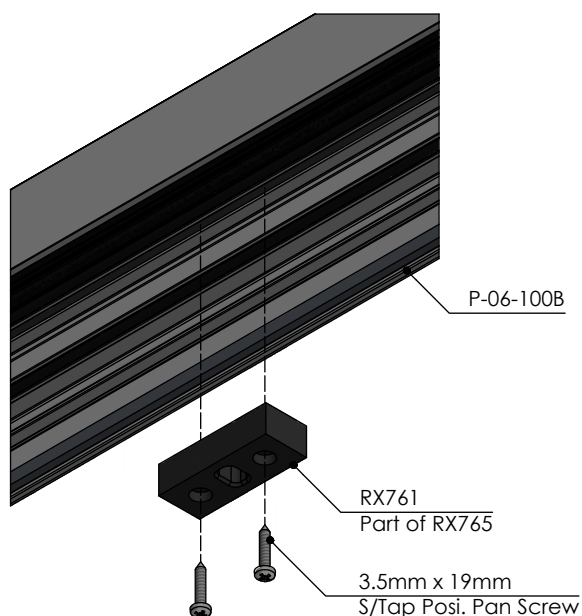
NB: Make sure that the anti-twist guide (RX775) is fitted to the top and bottom of the floating mullion (P-06-300)

SLAVE DOOR FINGER BOLT



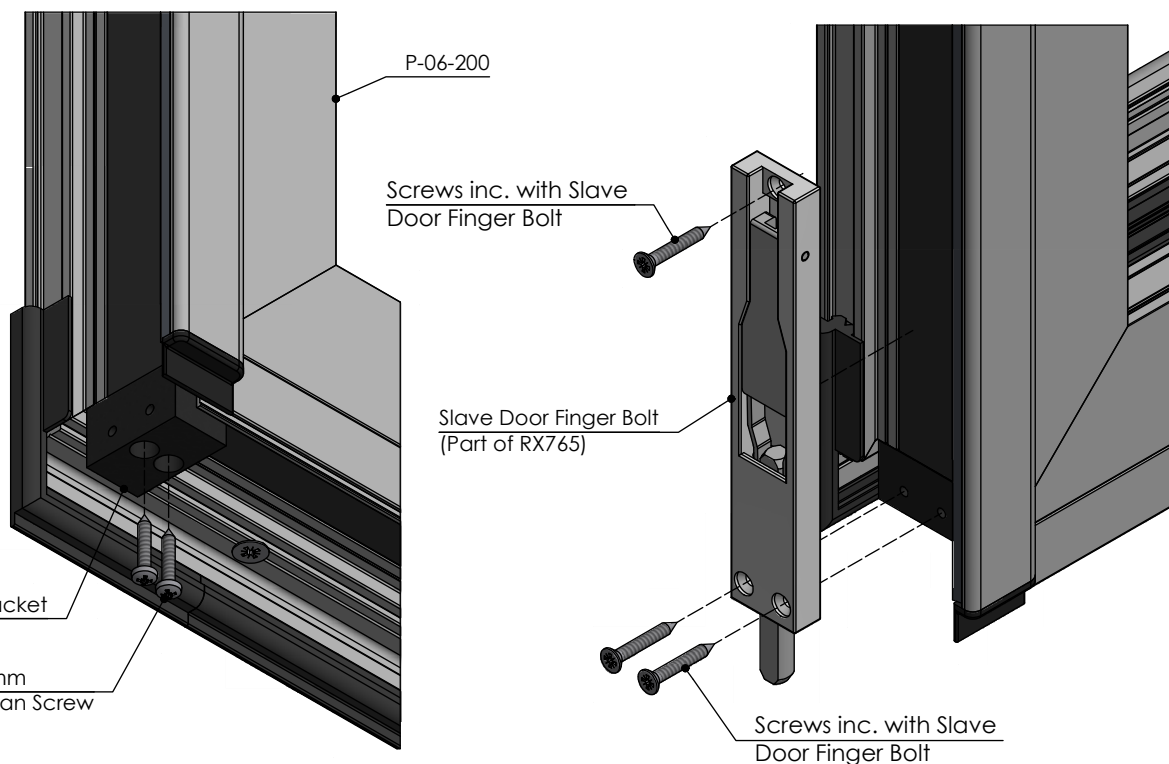
H = Leaf Height

Parts List		
Part No.	Description	Qty
P-06-200	Softline Leaf	1
P-06-100B	Outerframe	1
Part of RX765	Slave Door Finger Bolt	1
Part of RX765	Finger Bolt Keep	2
-	3.5mm x 19mm S/Tap Posi. Pan Screw	2

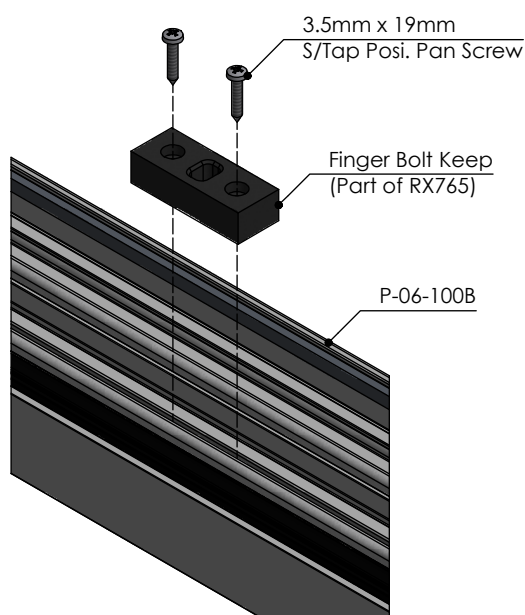


NB: Ensure the fingerbolt does not interfere with the operation of the door.

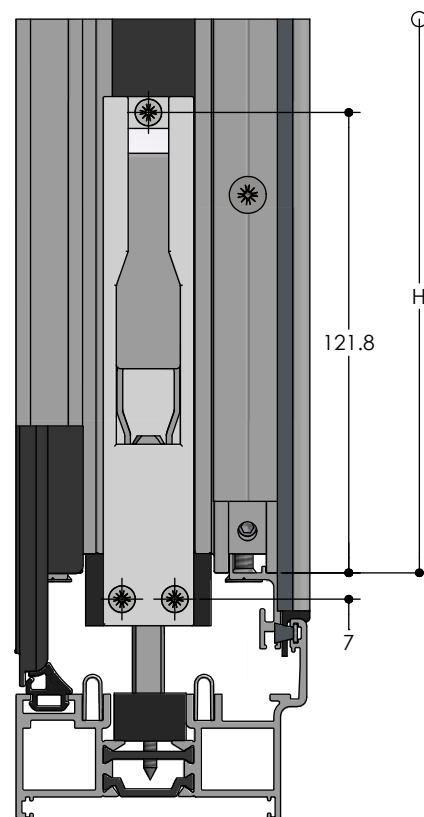
➤ SLAVE DOOR BOTTOM ASSEMBLY



Parts List		
Part No.	Description	Qty
P-06-100B	Outerframe	1
P-06-200	Softline Leaf	1
Part of RX765	Slave Door Finger Bolt	1
Part of RX765	FSD Finger Bolt Bracket	1
Part of RX765	Finger Bolt Keep	2
-	3.5mm x 19mm S/Tap Posi. Pan Screw	2

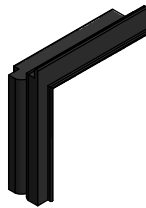
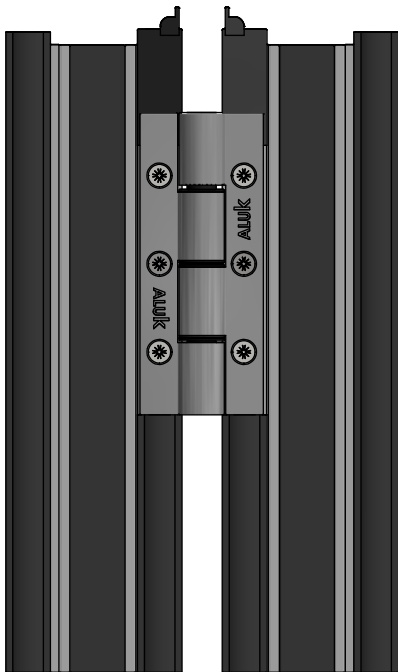


H = Leaf Height



CORNER MOULDING APPLICATION

Top

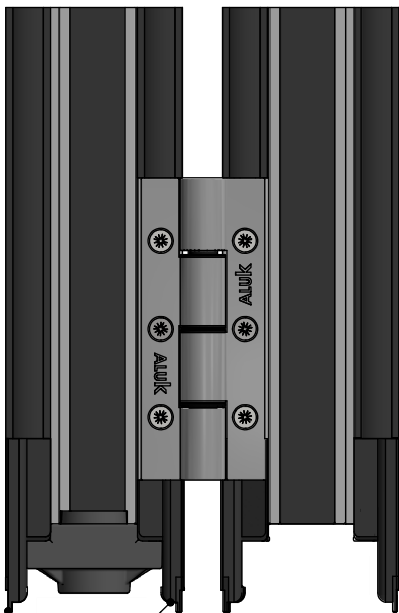
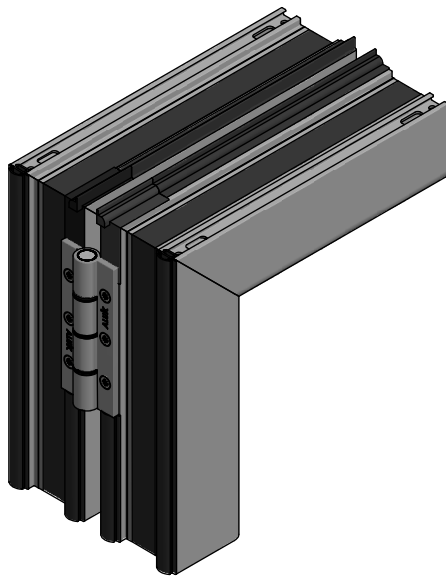


RX617 LH (3)



RX617 RH (2)

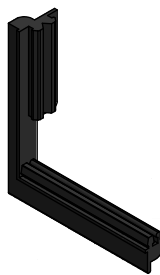
NB: Trim gasket mouldings to abut hinge



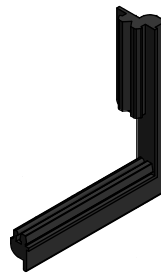
RX619A RH

RX619A LH *

Bottom



RX619 LH (5)



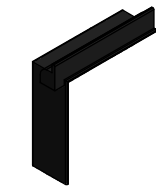
RX619 RH (4)

Parts List

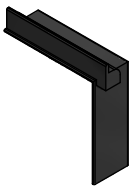
Part No.	Description	Qty
RX609	FSD Sash Seal (Interlocking)	1
RX617 RH	Corner Moulding (Top Hinge) RH	1
RX617 LH	Corner Moulding (Top Hinge) LH	1
RX619 RH	Corner Moulding (Bottom Hinge) RH	1
RX619 LH	Corner Moulding (Bottom Hinge) LH	2

➤ LEAF CORNER MOULDING

Top



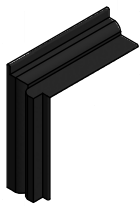
RX616 LH (6)



RX616 RH (7)



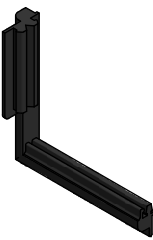
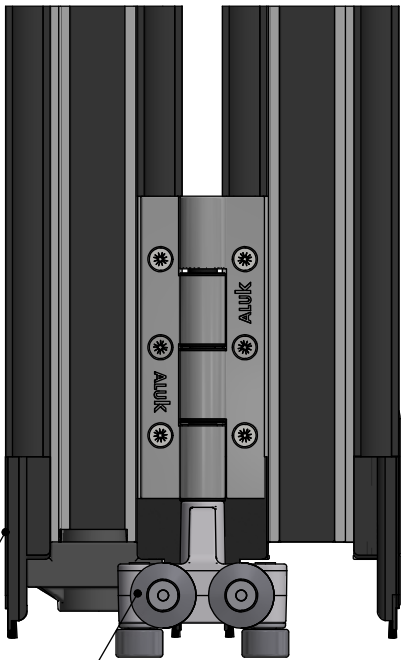
RX617 RH (3)



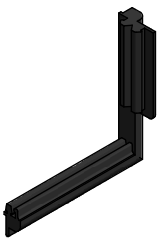
RX617 RH (2)

NB: Trim gasket mouldings to abut hinge

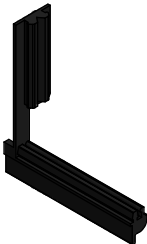
Parts List		
Part No.	Description	Qty
RX609	BSF70 Leaf Seal (Interlocking)	1
RX617 RH	Corner Moulding (Top Hinge) RH	1
RX617 LH	Corner Moulding (Top Hinge) LH	1
RX619 RH	Corner Moulding (Bottom Hinge) RH	1
RX619 LH	Corner Moulding (Bottom Hinge) RH	2
RX616 LH	Corner Moulding (Top Bogie) LH	
RX616 RH	Corner Moulding (Top Bogie) RH	
RX618 LH	Corner Moulding (Bottom Bogie) LH	
RX618 RH	Corner Moulding (Bottom Bogie) RH	



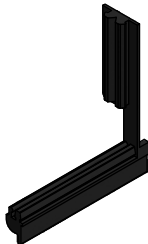
RX619 LH (5)



RX619 RH (5)



RX618 LH (8)



RX618 RH (9)

RX619 RH

RX618 LH *

Bottom

➤ FSD CORNER POST - ASSEMBLY METHOD 1

FSD Corner Post Parts List

Part No.	Description	Qty/Corner
AW720	70mm 90 Deg. Corner Post	-
RX665	FSD Corner Adp./Cleave	2
P-06-300	Floating Mullion	2
-	Ø4.2x13mm S/S Posi pan head screw	-
-	Ø4.2x25mm S/S Posi pan head screw	-
-	M4x13mm Posi pan head	-

* First fixing to be within 100mm of top edge of P-06-300, Fixings to be applied along entire length of P-06-300 at 600mm centres.

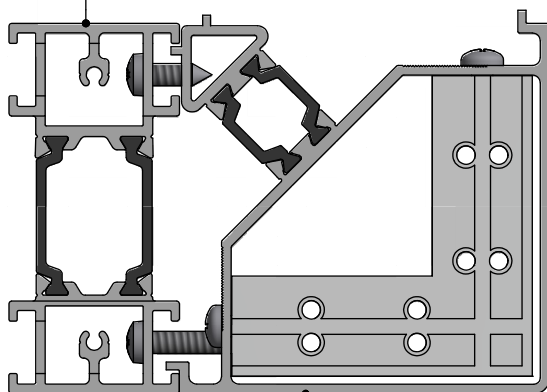
M4 x 13mm
Posi Pan Head

RX665

AW720

M4 x 13mm
Posi Pan Head

P-06-300



AW720

P-06-300

AW720

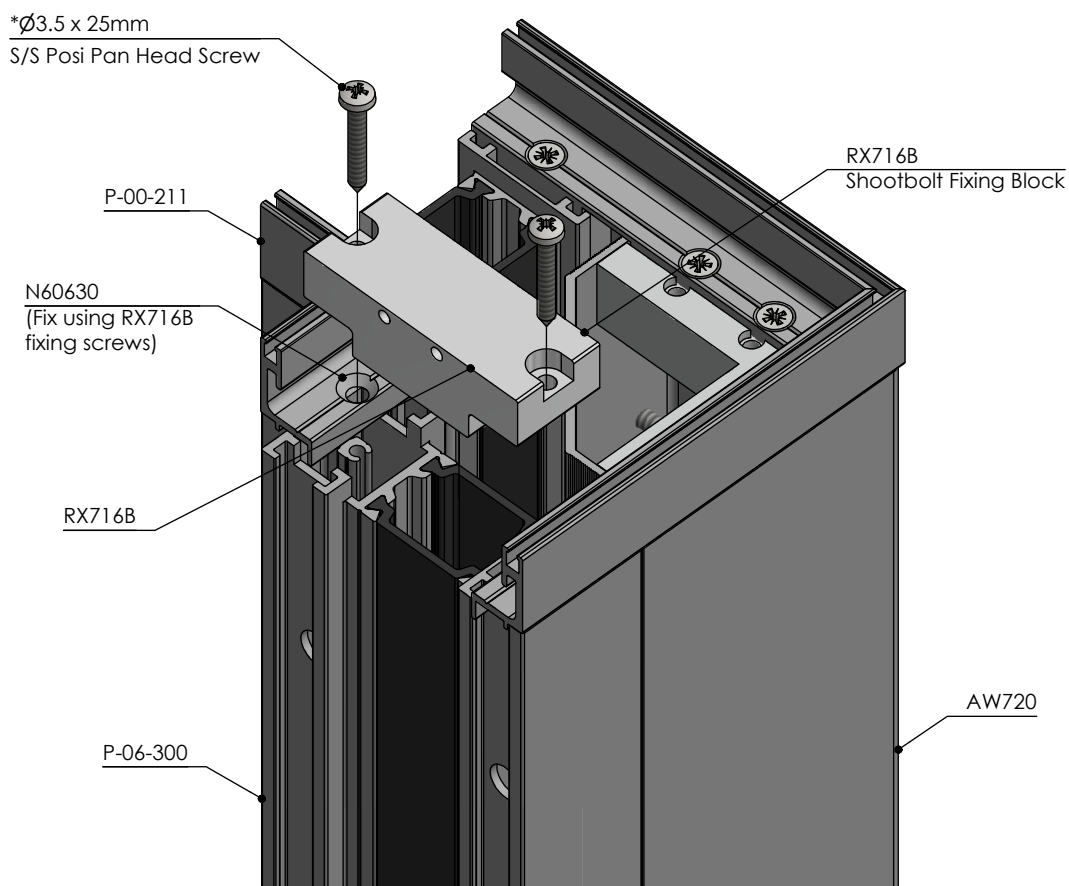
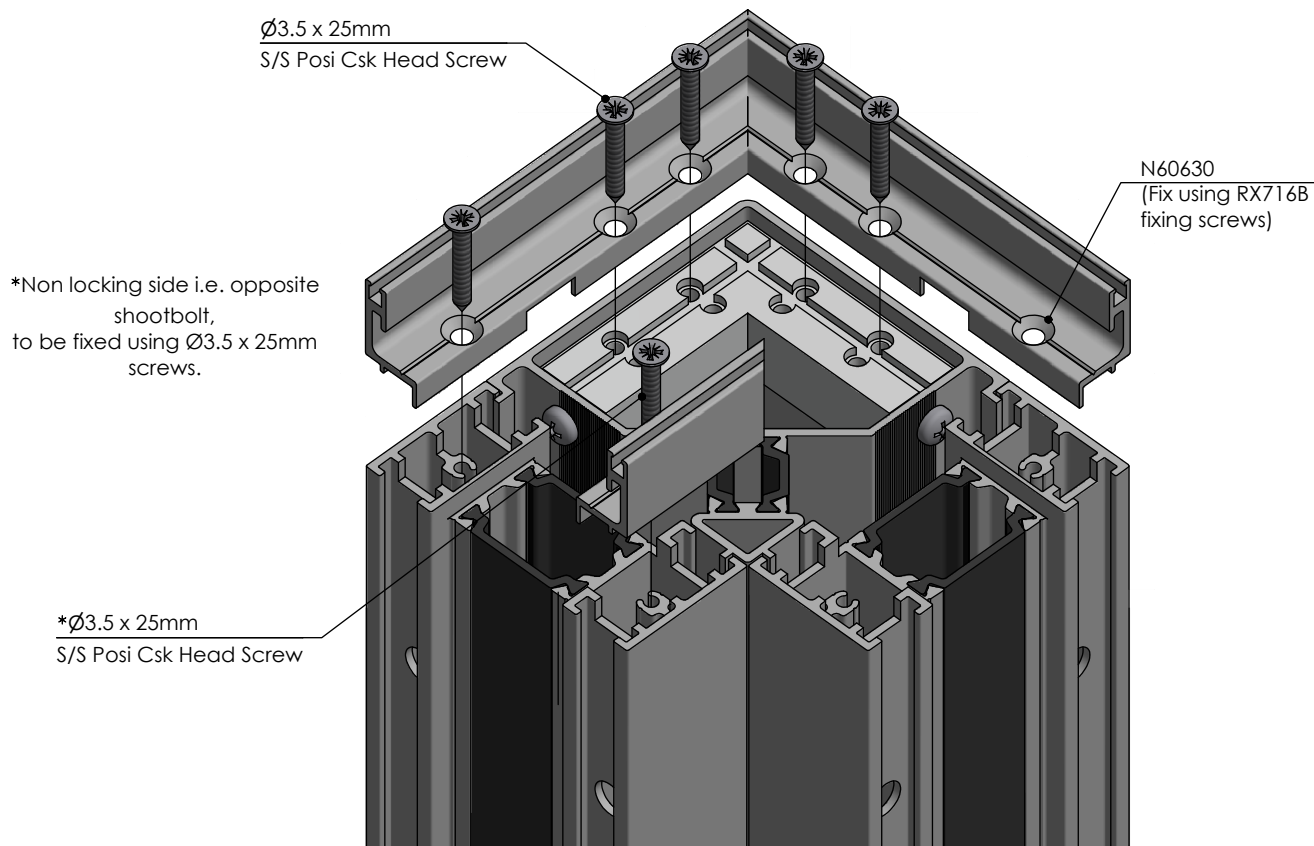
*Ø4.2 x 13mm
S/S Posi Pan Head Screw

P-06-300

*Ø4.2 x 25mm
S/S Posi Pan Head Screw

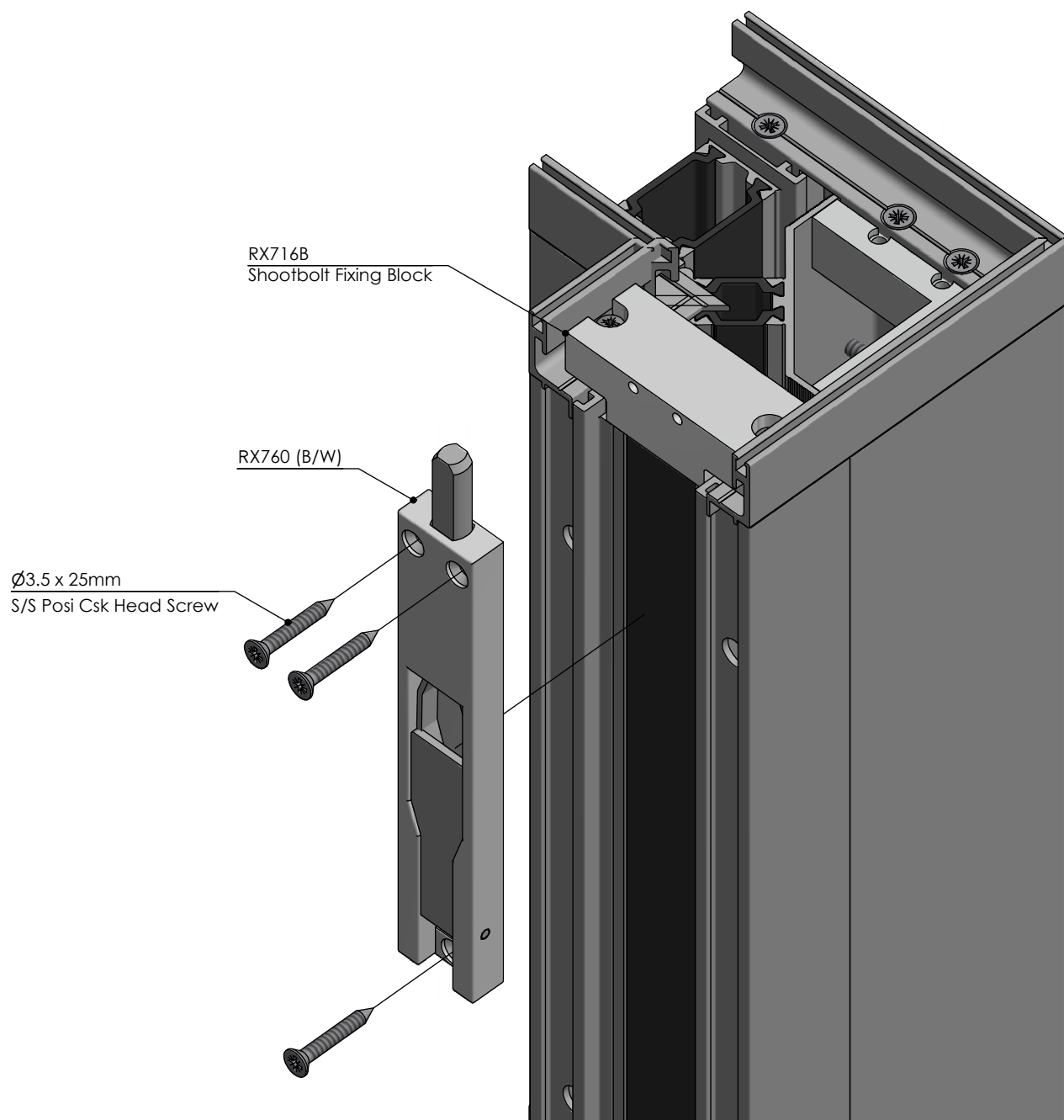
NB: Copy assembly method for the top and bottom of the corner post (AW720).

➤ CORNER POST - ASSEMBLY METHOD 2



NB: Copy assembly method for the top and bottom of the corner post (AW720).

➤ CORNER POST - ASSEMBLY METHOD 3

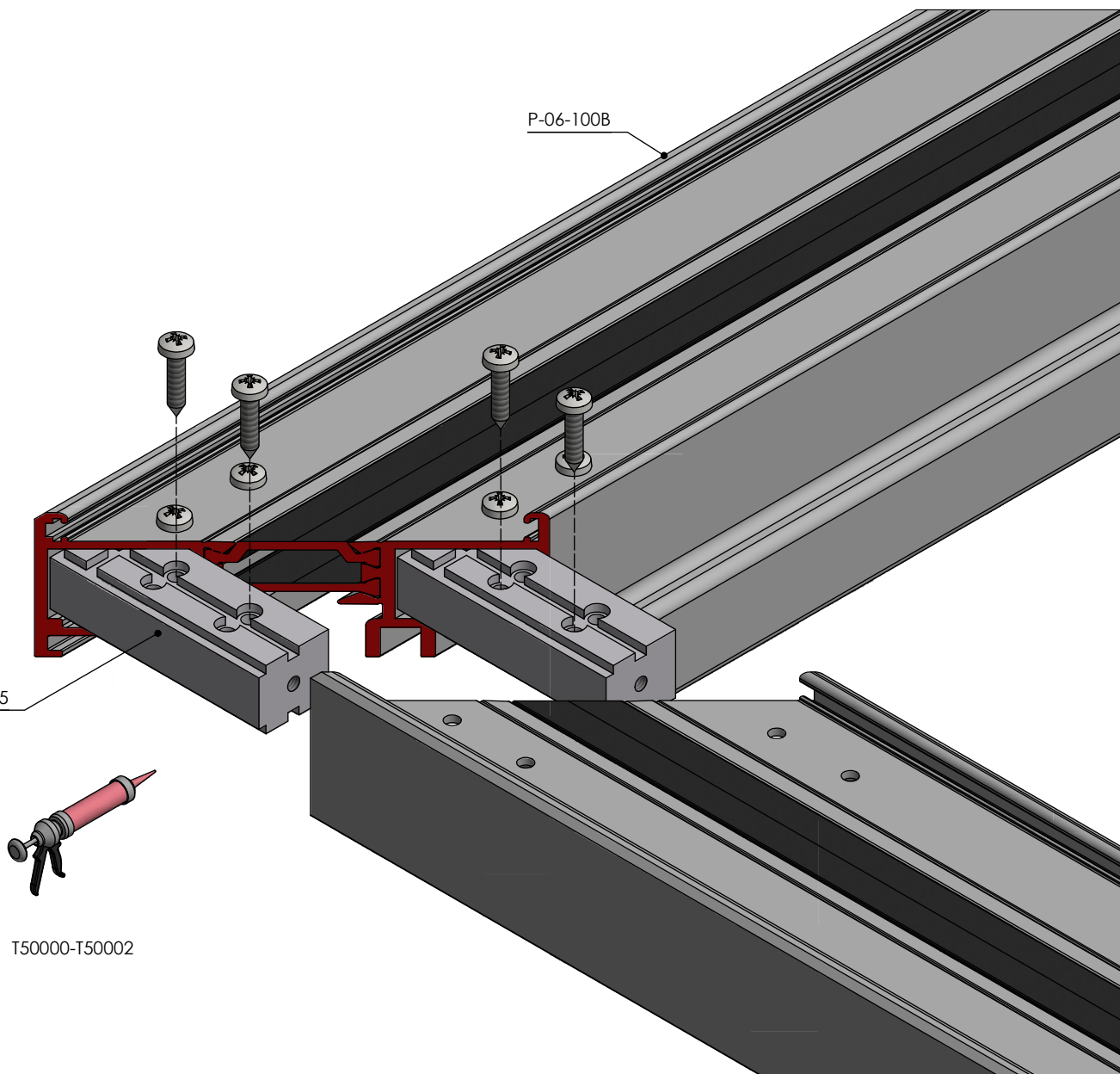


FSD Corner Post Parts List		
Part No.	Description	Qty/Corner
AW720	70mm 90 Deg. Corner Post	-
RX665	FSD Corner Adp./Cleat	2
RX760 B/W	Slave Door Shootbolt (Black/White)	2
N60630	Thershold/Head Adaptor	-
P-06-300	Floating Mullion	2
RX716B	Shootbolt Fixing Block	2

NB: Copy assembly method for the top and bottom of the corner post (AW720).

CORNER POST ASSEMBLY

UNCONTROLLED COPY



NB: Copy assembly method for the top and bottom of the corner.

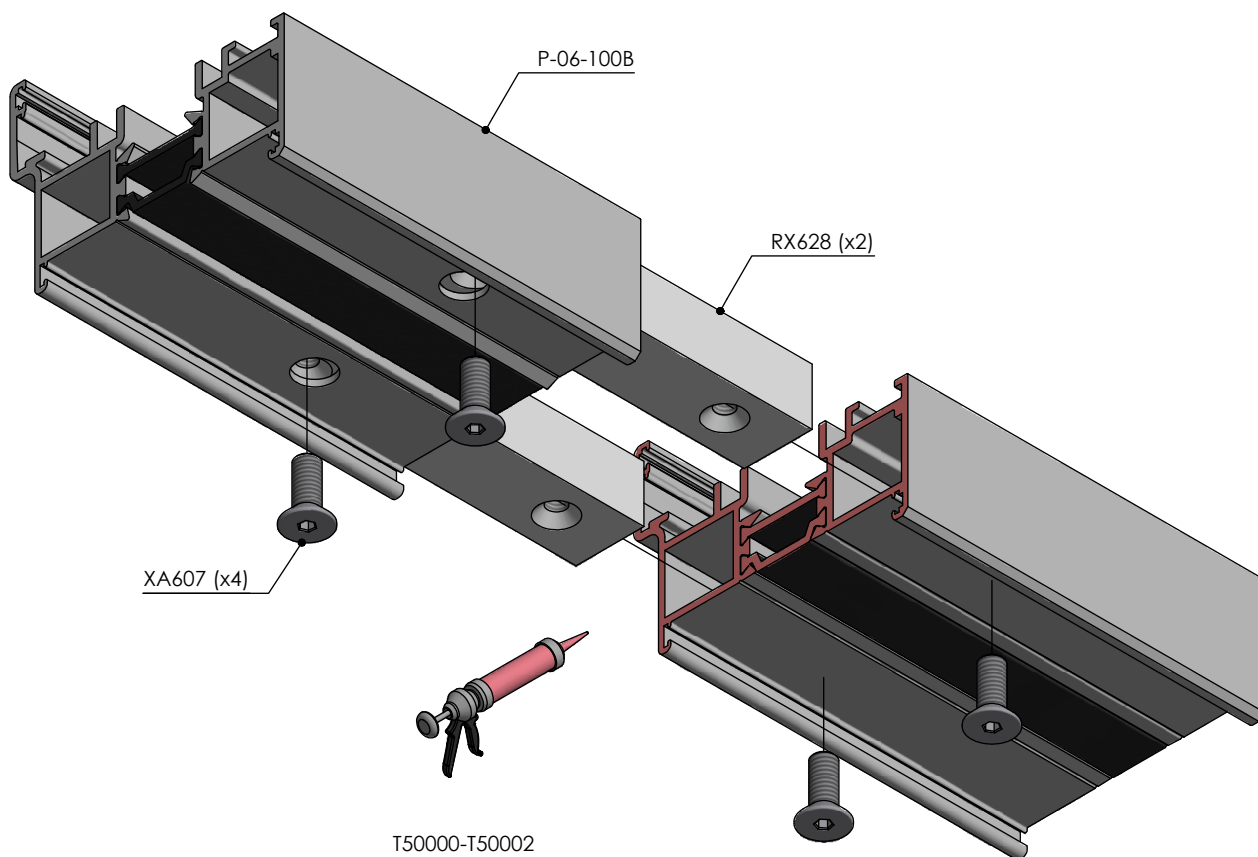
Do not forget to insert PX302 (Woolpile) into rebate of outer frame before assembly.

Remember to seal each profile before final fix.

Remove excess sealant with Aluk sealant wipes (T50003)

FSD Corner Post Parts List		
Part No.	Description	Qty/Corner
P-06-100B	FSD Outer Frame	2
PX302	Woolpile	-
RX610	S/S Track	-
RX665	FSD Corner Adp./Cleat	4

FRAME JOINING METHOD



NB: Copy assembly method for the top and bottom of the corner.

Do not forget to insert PX302 (Woolpile) into rebate of outer frame before assembly.

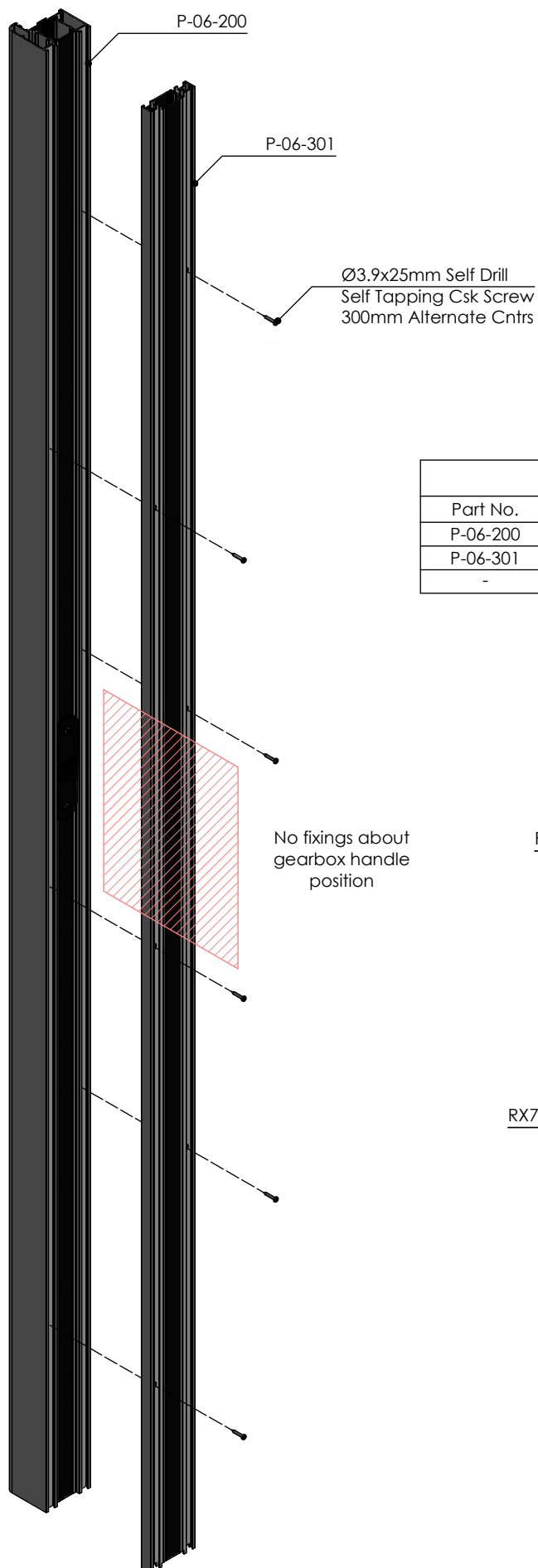
Remember to seal each profile before final fix.

Remove excess sealant with Aluk sealant wipes (T50003)

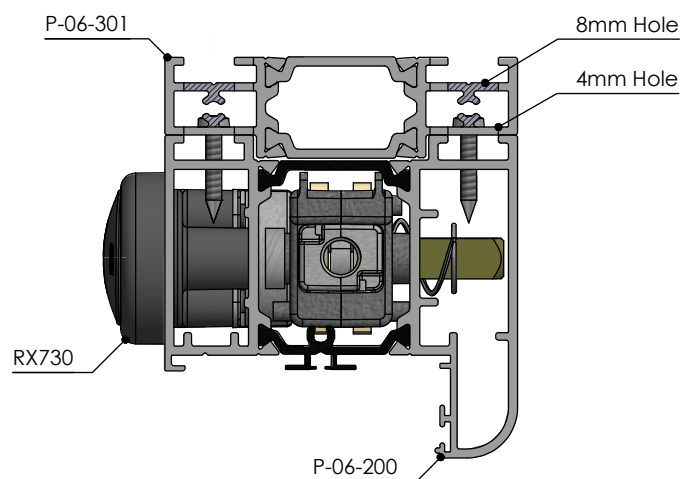
FSD Joining Kit (RX627)		
Part No.	Description	Qty/Join
P-06-100B	FSD Outer Frame	2
RX627*	Joining Kit	1

* RX627 contains enough components i.e. (x4) RX628 & (x8) XA607, to join P-06-100B in one position at the head and Cill.

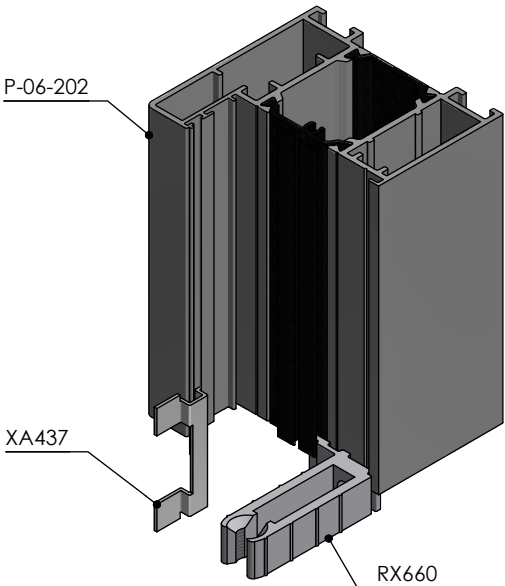
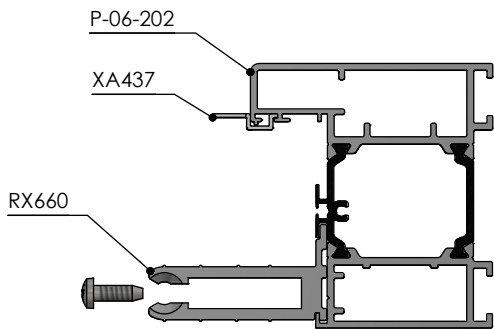
➤ SLAVE DOOR ADAPTOR



Parts List		
Part No.	Description	Qty
P-06-200	BSF70 Vent	1
P-06-301	FSD Slave Door Adaptor	1
-	Ø3.9x25mm Self Drill Self Tapping Csk Screw	6



▶ TRANSOM / MID RAIL

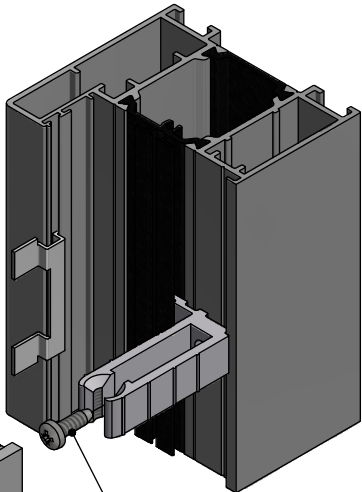


AD305/AD306 20mm Transom		
Part No.	Description	Qty.
RX660	Slim Transom Mechanical Bracket	2
Part of RX660	M6 x 13mm Csk Machine Screw	2
XA437	Anti Twist (Slim) Transom Clip	2
-	Ø4.2 x 13mm Posi Pan S/Tap Screw	2

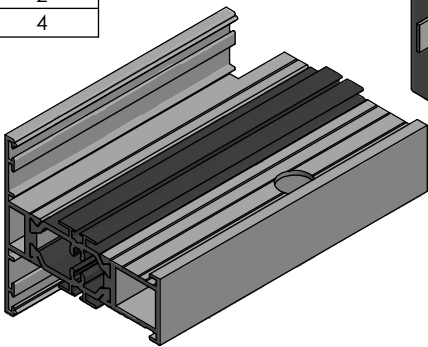
AD307/AD308 32mm Transom		
Part No.	Description	Qty.
RX662	Slim Transom Mechanical Bracket	2
Part of RX662	M6 x 13mm Csk Machine Screw	2
XA438	Anti Twist (Standard) Transom Clip	2
-	Ø4.2 x 13mm Posi Pan S/Tap Screw	4

AD309 110mm Midrail		
Part No.	Description	Qty.
RX661	Slim Transom Mechanical Bracket	2
Part of RX661	M6 x 13mm Csk Machine Screw	2
XA439	Anti Twist (Wide) Transom Clip	2
-	Ø4.2 x 13mm Posi Pan S/Tap Screw	4

T50000-T50002



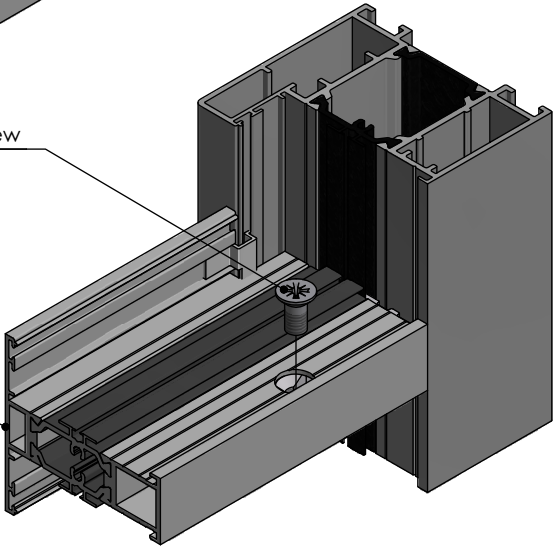
NB: Remember to seal front and back face of transom / mid rail profile



M6 x 13mm CSK Machine Screw
Supplied with RX660

NB: Remove excess sealant with Aluk sealant wipes (T50003).

AD306



END OF MANUAL



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