OS2

CATALOGO TECNICO TECHNICAL CATALOGUE

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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione in vista di 47 mm (nodo laterale) e 62 mm (nodo centrale), idoneo per la realizzazione di porte e finestre a 2 ante, rettangolari, sagomate o curve, con o senza fissi laterali e superiori.

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

Il taglio termico all'interno della sezione dei profili è realizzato tramite una resina poliuretanica ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce ottimi valori di resistenza torsionale e flettente.

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

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

Caratteristiche del sistema:
Sormonto interno ed esterno delle ante;
Sistema di guarnizioni a giunto aperto con guarnizione centrale di tenuta e guarnizione interna di battuta;
Cerniere ad avvitare negli stessi materiali del profilo per porte e per finestre;
Sistema integrato completo di accessori per lo scarico acqua;
Kit completo per apertura ad anta con ferramenta a scomparsa;
Kit per l'alloggiamento di serrature completo di scatole di copertura nei diversi materiali;
Paraspifferi inferiori con guarnizione a pinna.

PRESTAZIONI

Sistema finestre
Trasmittanza Termica (EN ISO 10077-2)
Nodo tipo (acciaio inox) con U_f =3,10 W/(m^2 x K)
Isolamento Acustico (DIN 52210 / DIN EN ISO 717-1)
Fino a 43 dB
Resistenza all'aria (DIN EN 12207)
Classe 4
Resistenza all'acqua (DIN EN 12208)
Classe 8A
Resistenza al vento (DIN EN 12210)
Classe C4
Prova di durata a cicli di apertura (DIN EN 1197-12400)
Classe 2 - 10.000 Cicli

Thermally insulated integrated system of profiles, accessories and gaskets *with visible section fo 47 mm (lateral section) and 62 mm (central section) suitable for rectangular, trapezoidal, arched shaped double leafed doors and windows for door and window with or without fixed side light.*

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

The thermal break connection *inside the section is obtained by means of a high density polyurethane resin, injected at high pressure. The connection is continuous, without interruptions, guaranteeing maximum resilience to torsional and bending stress.*

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

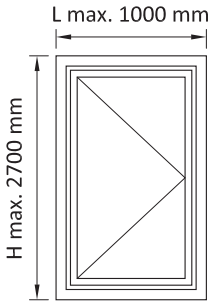
The system permits to use double or triple thermal insulated galzing with single or stratified glass (security glass).

Features of the system
Surmounted internal and external design of the sections;
Central and rebate gasket placed for the best water, wind, air tightness and acoustic performances;
High capacity hinges to be screwed in the same material of the profile;
Integrated system complete of accessories for water drain
Concealed hardware for side-hung windows;
Complete kit for lock with coverings in the same material of the profile;
Special drop down seal with fin.

PERFORMANCES

Windows system
Thermal trasmittance (EN ISO 10077-2)
Typical section (stainless steel) U_f =3,10 W/(m^2 x K)
Acoustic performance (DIN 52210 / DIN EN ISO 717-1)
Up to 43 dB
Air permeability (DIN EN 12207)
Class 4
Watertightness (DIN EN 12208)
Class 8A
Resistance to wind load (DIN EN 12210)
Class C4
Resistance to repeated opening and closing (DIN EN 1197-12400)
Class 2 - 10.000 opening and closing

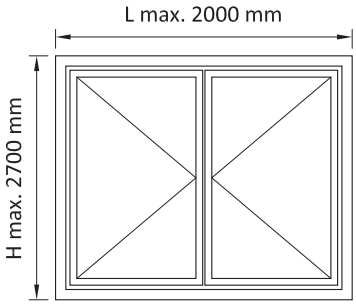
Limiti dimensionali - *Maximum dimension*



finestra ad un anta apertura INTERNA
one-leaf INWARD opening windows

peso massimo anta*
maximum leaf weight

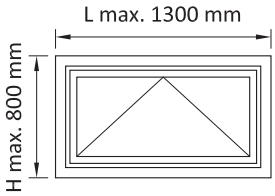
AC2629-30 - 50 kg
AC2628 - 100 kg
AC2631/A - 40 kg
AC2631/B - 70 kg
AC2632/B - 70 kg



finestra a due ante apertura INTERNA
two-leaf INWARD opening windows

peso massimo anta*
maximum leaf weight

AC2629-30 - 50 kg
AC2628 - 100 kg
AC2631/A - 40 kg
AC2631/B - 70 kg
AC2632/B - 70 kg



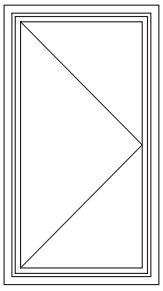
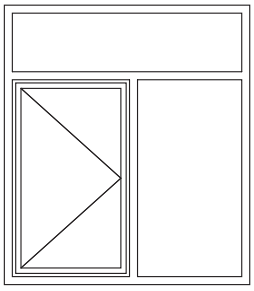
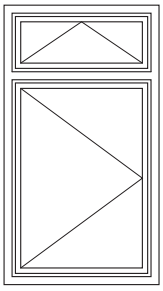
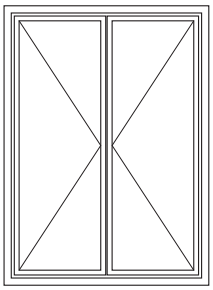
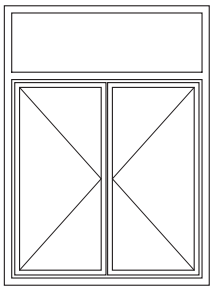
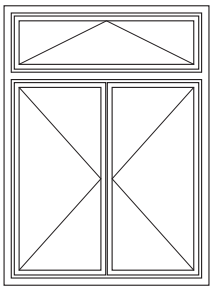
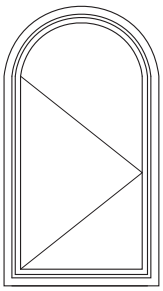
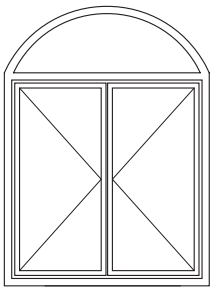
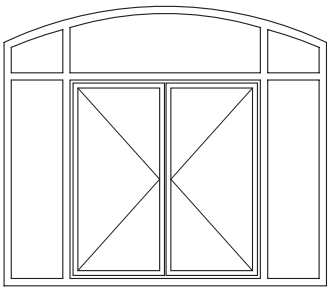
finestra vasistas apertura INTERNA
bottom-hung window

peso massimo anta*
maximum leaf weight

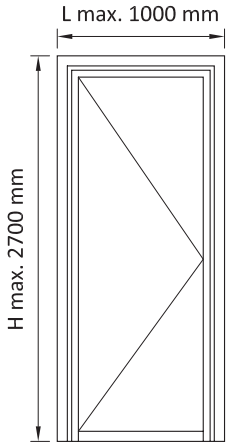
AC2629-30 - 40 kg
AC2631/A - 40 kg
AC2639 - 40 kg
AC2628 - 40 kg
AC2631/B - 40 kg
AC2632/B - 40 kg

* cerniera aggiuntiva per H serramento > 1400 mm
additional hinge for windows with height > 1400 mm

Esempi tipologie realizzabili - *Types of windows*

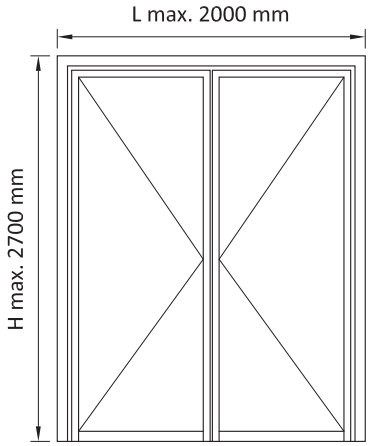
Limiti dimensionali - *Maximum dimension*



porta ad un anta apertura INTERNA
one-leaf INWARD opening doors

peso massimo anta*
maximum leaf weight

AC2629-30 - 50 kg
AC2628 - 100 kg
AC2631/A - 40 kg
AC2631/B - 70 kg
AC2632/B - 70 kg
AC2632/C - 80 kg



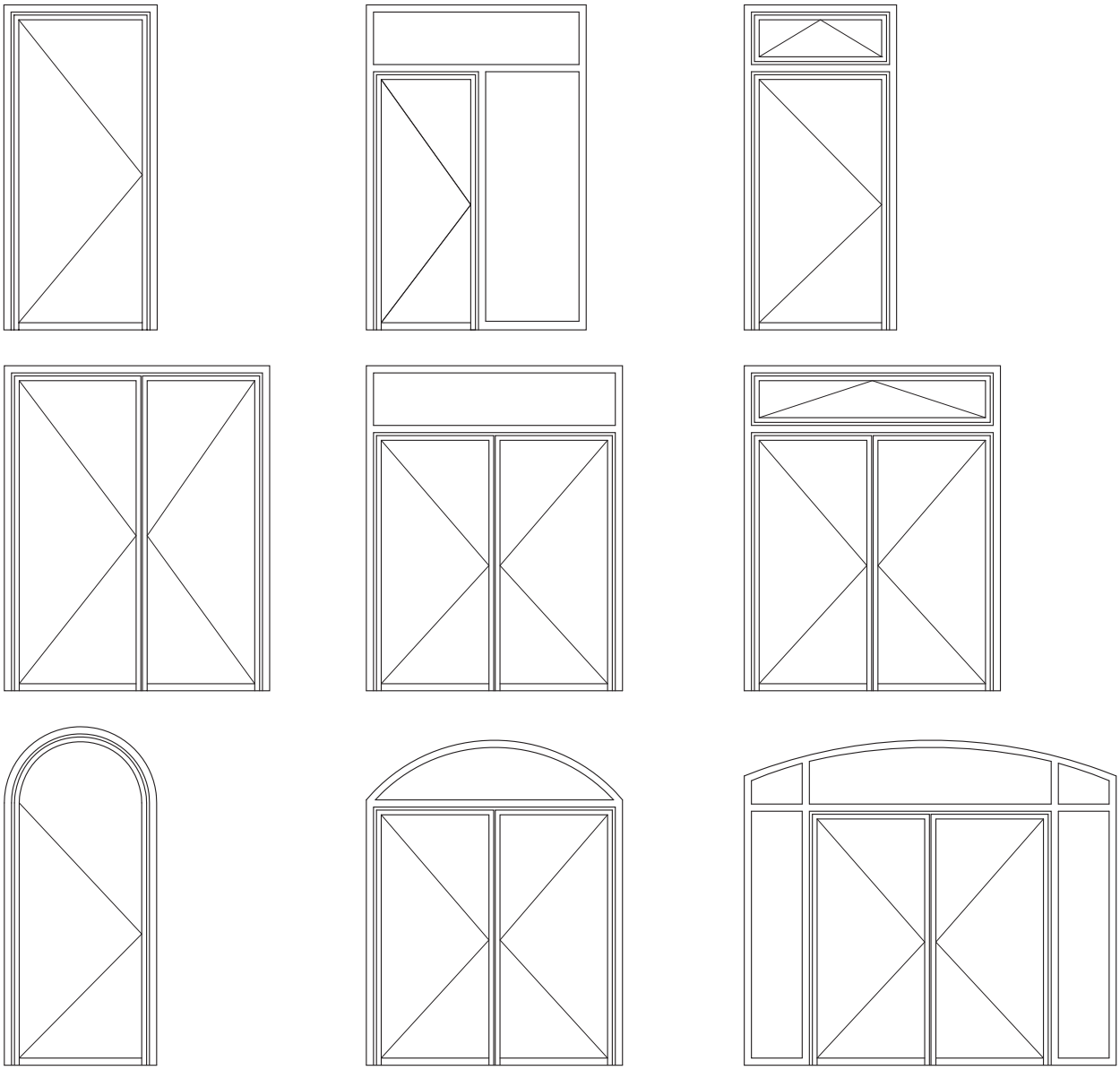
porta a due ante apertura INTERNA
two-leaf INWARD opening doors

peso massimo anta*
maximum leaf weight

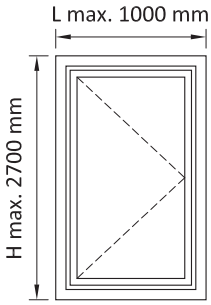
AC2629-30 - 50 kg
AC2628 - 100 kg
AC2631/A - 40 kg
AC2631/B - 70 kg
AC2632/B - 70 kg
AC2632/C - 80 kg

* cerniera aggiuntiva per H serramento > 2200 mm
additional hinge for doors with height > 2200 mm

Esempi tipologie realizzabili - *Types of door*



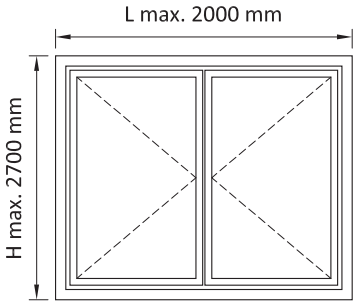
Limiti dimensionali - *Maximum dimension*



finestra ad un anta apertura ESTERNA
one-leaf OUTWARD opening windows

peso massimo anta*
maximum leaf weight

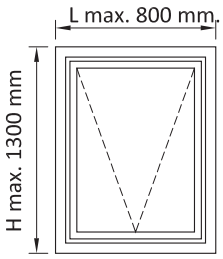
AC2649-50 - 50 kg
AC2648 - 100 kg
AC2631/A - 40 kg
AC2631/B - 70 kg
AC2632/B - 70 kg



finestra a due ante apertura ESTERNA
two-leaf OUTWARD opening windows

peso massimo anta*
maximum leaf weight

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



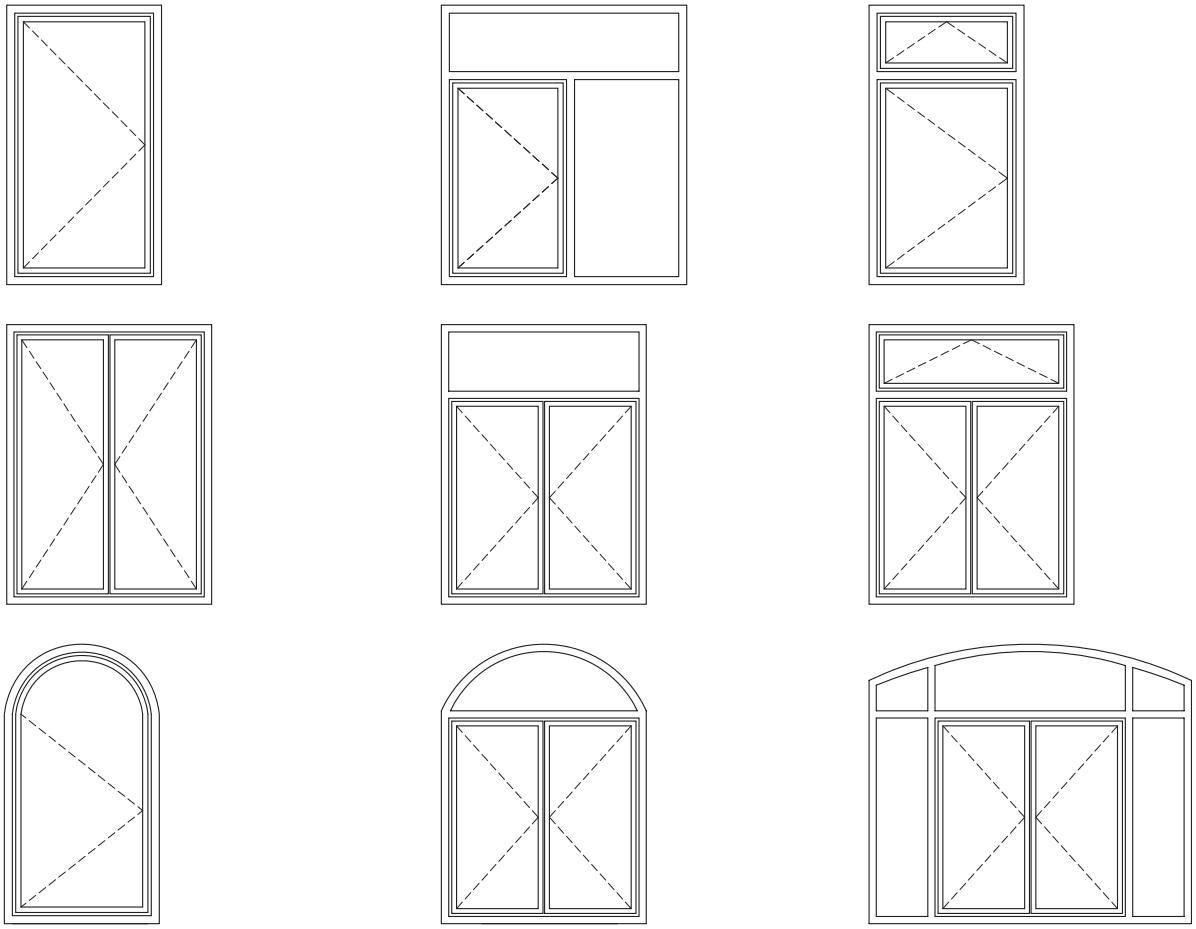
finestra a sporgere apertura ESTERNA
awning window

peso massimo anta*
maximum leaf weight

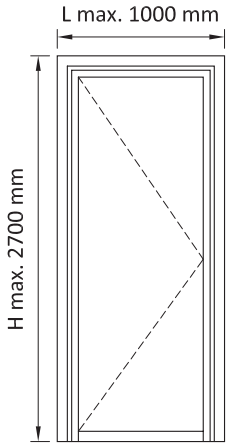
AC2649-50 - 40 kg
AC2689 - 40 kg
AC2648 - 40 kg
AC2631/A - 40 kg
AC2631/B - 40 kg
AC2632/B - 40 kg
AC2688 - 60 kg

* cerniera aggiuntiva per H serramento > 1400 mm
additional hinge for windows with height > 1400 mm

Esempi tipologie realizzabili - *Types of windows*



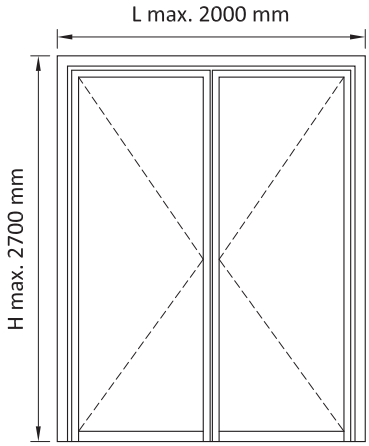
Limiti dimensionali - *Maximum dimension*



porta ad un anta apertura ESTERNA
one-leaf OUTWARD opening doors

peso massimo anta*
maximum leaf weight

AC2649-50 - 50 kg
AC2648 - 100 kg
AC2631/B - 70 kg
AC2632/B - 70 kg
AC2632/C - 80 kg



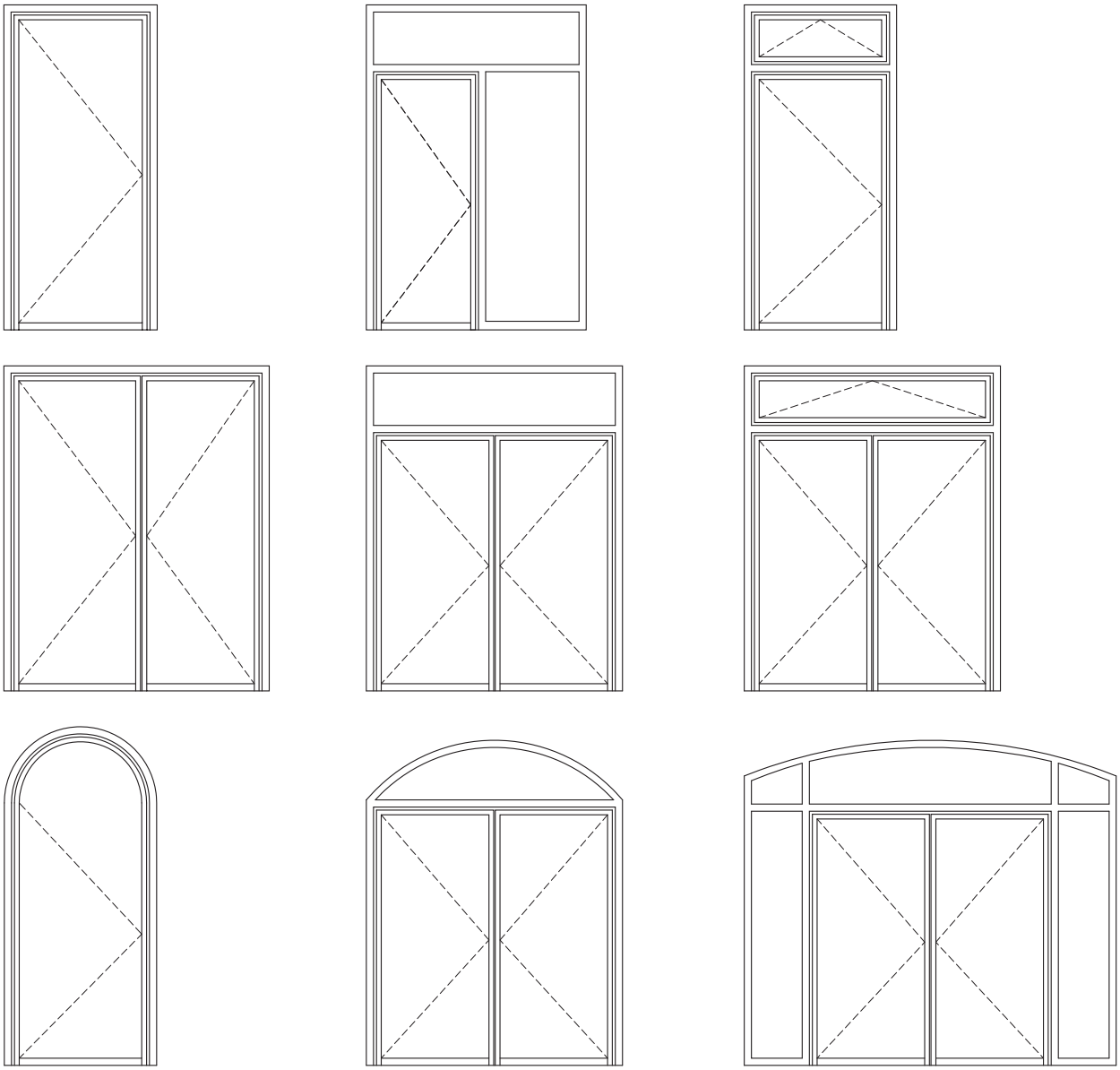
porta a due ante apertura ESTERNA
two-leaf OUTWARD opening doors

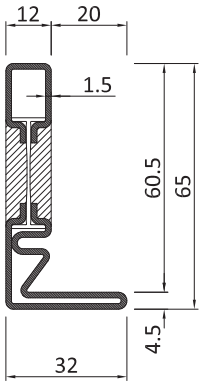
peso massimo anta*
maximum leaf weight

AC2649-50 - 50 kg
AC2648 - 100 kg
AC2631/B - 70 kg
AC2632/B - 70 kg
AC2632/C - 80 kg

* cerniera aggiuntiva per H serramento > 2200 mm
additional hinge for doors with height > 2200 mm

Esempi tipologie realizzabili - *Types of door*





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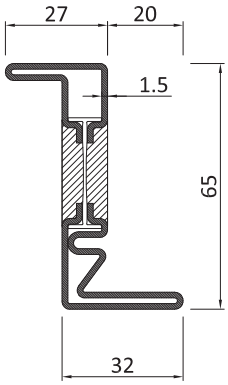

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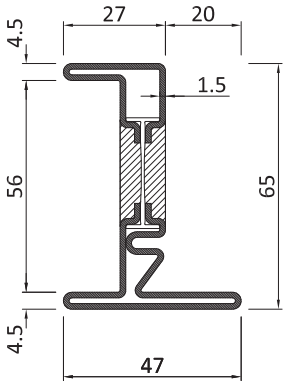

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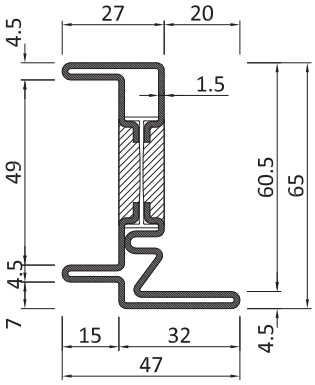

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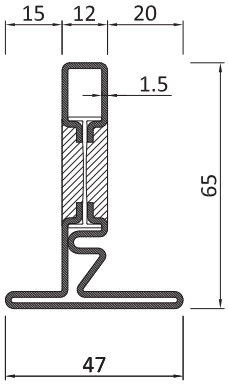

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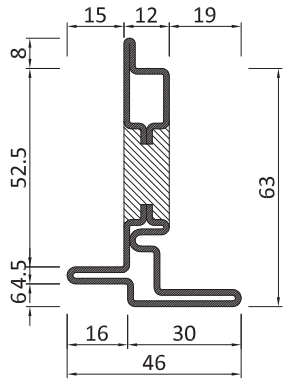
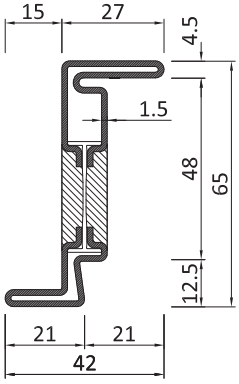


P2632 Non fornito in Inox
Not in Inox



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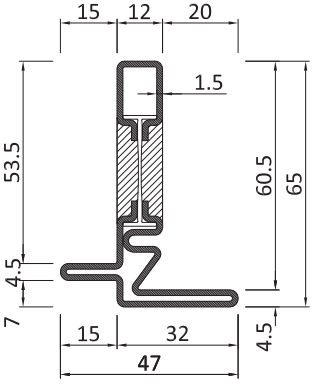

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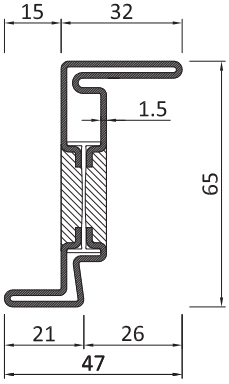
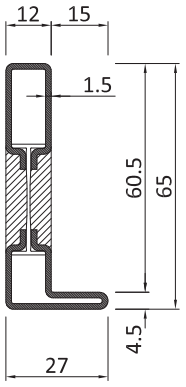


P2843

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2801	2.37	2.54	0.22	11.33	1.78	6
P2803	2.71	2.91	0.24	15.05	2.80	6
P2805	3.03	3.26	0.27	16.80	3.80	6
P2815	2.99	3.22	0.27	15.83	3.70	6
P2822	2.69	2.89	0.25	12.60	2.97	6

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2632	2.82	3.03	0.26	15.07	2.89	6
P2833	2.51	2.68	0.23	13.98	1.97	6
P2842	2.65	2.85	0.24	11.80	2.86	6
P2843	2.63	2.80	0.24	14.70	2.72	6



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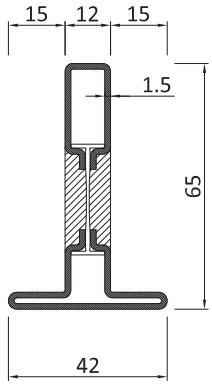
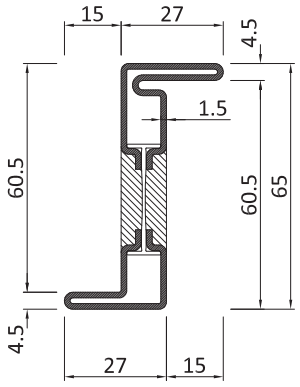
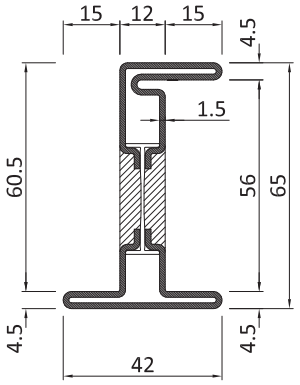


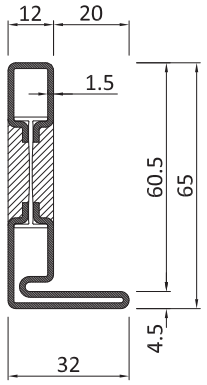
P2852



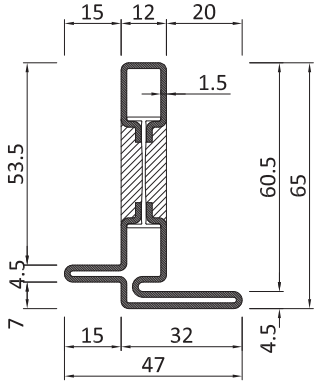
P2853



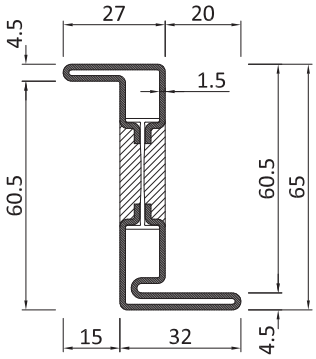
P2855



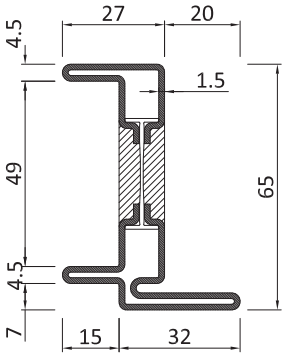
P2861



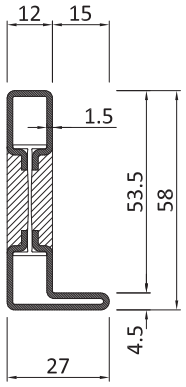
P2862



P2863



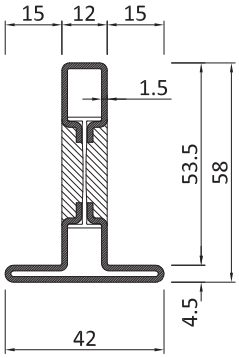
P2865



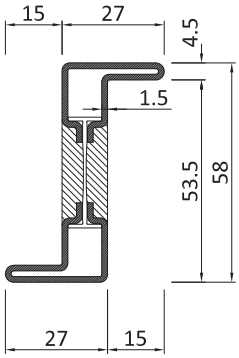
P2871

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2851	2.02	2.16	0.18	10.39	1.09	6
P2852	2.35	2.52	0.21	11.95	2.18	6
P2853	2.52	2.71	0.23	14.47	2.06	6
P2855	2.85	3.07	0.25	16.82	2.95	6
P2861	2.30	2.46	0.21	11.45	1.74	6

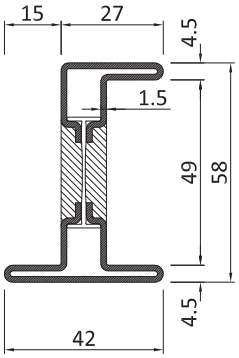
Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2862	2.57	2.76	0.24	11.90	2.97	6
P2863	2.64	2.83	0.24	15.19	2.79	6
P2865	2.95	3.13	0.26	15.96	3.82	6
P2871	1.85	1.98	0.17	7.82	1.02	6



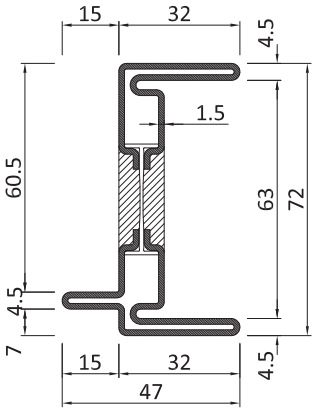
P2872



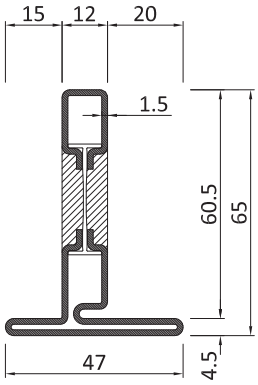
P2873



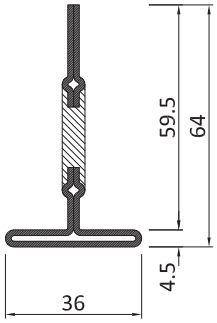
P2874



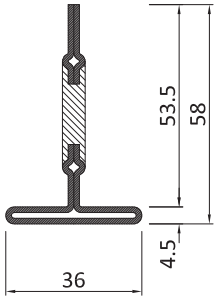
P2875



P2882



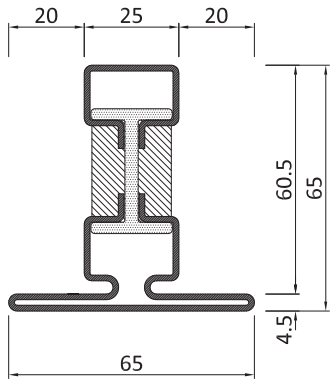
P2654 Non fornito in Inox
Not in Inox



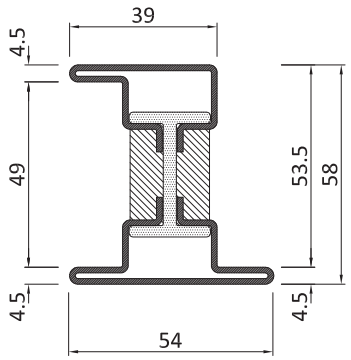
P2664 Non fornito in Inox
Not in Inox

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2872	2.18	2.34	0.20	9.00	2.12	6
P2873	2.19	2.35	0.20	10.44	3.32	6
P2874	2.52	2.71	0.23	12.17	2.87	6
P2875	3.36	3.61	0.30	22.81	4.36	6
P2882	2.57	2.76	0.24	12.68	2.98	6

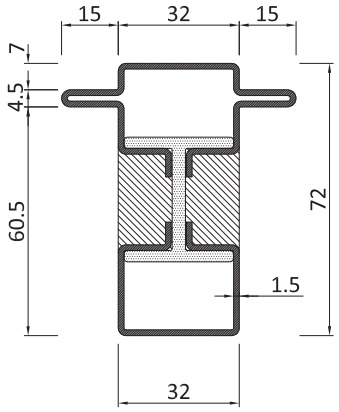
Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2654	2.42	2.62	0.20	12.28	1.20	6
P2664	2.28	2.47	0.19	9.23	1.20	6



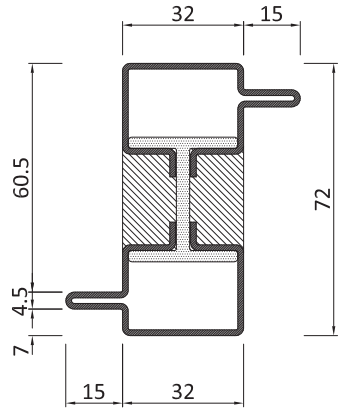
P2652



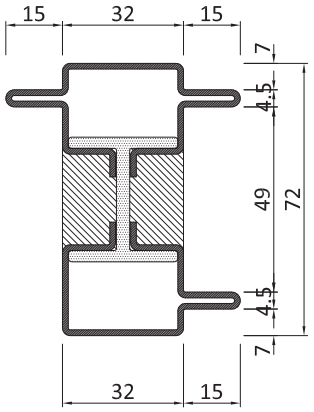
P2655



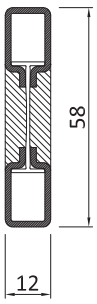
P2892



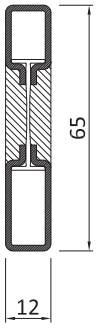
P2893



P2895



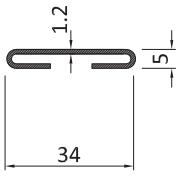
P2830



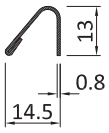
P2831

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2652	3.97	4.24	0.29	22.02	9.37	3
P2655	3.43	3.66	0.25	19.07	6.90	3
P2892	4.22	4.50	0.25	14.44	9.44	3
P2893	4.29	4.58	0.25	14.93	10.56	3
P2895	4.60	4.91	0.28	15.96	11.62	3

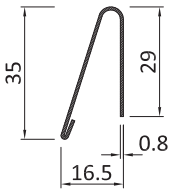
Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2830	2.04	2.14	0.14	8.16	0.30	6
P2831	2.21	2.32	0.16	7.95	0.36	6



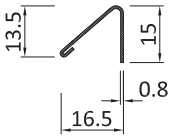
P2610



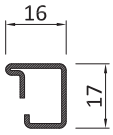
P2620



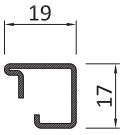
P2660



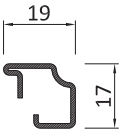
P2670



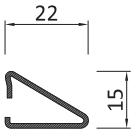
P2606



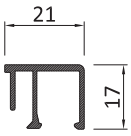
P2607



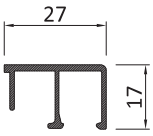
P2627



P2629



PA2607



PA2608

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2610	0.53	0.57				4.5
P2620	0.24	0.27				4.5
P2660	0.73	0.79				4.5
P2670	0.40	0.43				4.5
P2606	0.48	0.52				6

Profilo/*Profile* n°	P Kg/m ZN / Inox - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P2607	0.51	0.55				6
P2627	0.47	0.51				6
P2629	0.49	0.53				6
PA2607	alluminio 0.23					6.5
PA2608	alluminio 0.26					6.5

GZ acciaio zincato/*galvanized steel*
CZ acciaio corten grezzo/*untreated corten steel*
I acciaio inox/*stainless steel*
B ottone naturale/*natural brass*

AC 2603

Fondino dx per 2^ anta
apertura interna

RH fitting for T-Z joint
2nd inward opening leaf

AC 2604

Fondino sx per 2^ anta
apertura interna

LH fitting for T-Z joint
2nd inward opening leaf

AC 2608

Clips per fissaggio fermavetri
P2606 - P2607 - P2627 - P2629

Clips for securing
P2606 - P2607 - P2627 - P2629
glazing beads

AC 2609

Clips per fissaggio fermavetri
su profilo P.2654 - P.2664

Clips for securing glazing beads
on P.2654 - P.2664 profile

AC 2610I

Accessorio fissaggio P.2610

Securing fitting for P.2610

AC 2617

Guarnizione d'angolo
vulcanizzata
per GE 2602

Vulcanised corner gasket
for GE 2602

IZ acciaio inox grezzo verniciabile/*paintable untreated steel*
CZ acciaio corten grezzo/*untreated corten steel*
I acciaio inox AISI 304/*AISI 304 stainless steel*
B acciaio inox brunito/*burnisched stainless steel*

AC 2618

Scarico acqua per aperture
interne in metallo

Metal drip for
inward openings

AC 2618NE

Scarico acqua per aperture
interne in plastica nera

Black plastic drip for
inward openings

AC 2621R

Catenaccio 2^ anta per
porte/finestre
L = 150 mm

Second leaf flush bolt
for doors/windows
L = 150 mm

AC 2621M

Catenaccio 2^ anta per porta
L = 440 mm

Second leaf flush bolt
for doors
L = 440 mm

AC 2622

Fermo a scatto chiusura 2^ anta per finestra

Snapper for 2nd window leaf

AC 2626R

Punto di chiusura aggiuntivo per finestra

Additional locking point for windows

AC 2623D

Kit cremonese dx per finestre ad un anta | P.2833

RH cremone bolt set for single leaf windows | P.2833

AC 2623S

Kit cremonese sx per finestre ad un anta | P.2833

LH cremone bolt set for single leaf windows | P.2833

AC 2627

Chiusura mediana lato cerniere

Hinge-side middle closing

AC 2624D

Kit cremonese dx per finestre a due ante

RH cremone bolt set for double leaf windows

AC 2624S

Kit cremonese sx per finestre a due ante

LH cremone bolt set for double leaf windows

AC 2628

Cerniera a tre ali da avvitare | P.2833

Three-wing screw-on hinge | P.2833

AC 2625D

Kit cremonese dx per finestre ad un anta | P.2843

RH cremone bolt set for single leaf windows | P.2843

AC 2625S

Kit cremonese sx per finestre ad un anta | P.2843

LH cremone bolt set for single leaf windows | P.2843

AC 2629

Cerniera dx a due ali da avvitare | P.2833

RH two-wing screw-on hinge | P.2833

AC 2630

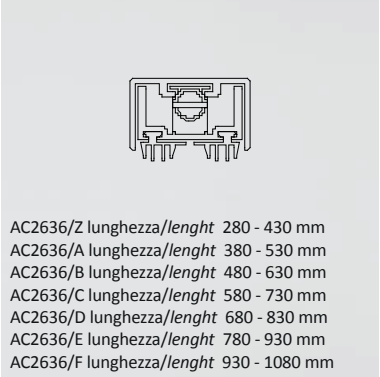
Cerniera sx a due ali da avvitare | P.2833

LH two-wing screw-on hinge | P.2833

AC 2631/A

Cerniera a due ali in acciaio zincato a saldare | Ø 10

Weld-on hinge in galvanised steel | Ø 10



AC 2636

Guarnizione automatica di tenuta sotto porta

Automatic bottom seal

AC 2631/B

Cerniera a due ali in acciaio zincato a saldare | Ø 13

Weld-on hinge in galvanised steel | Ø 13

AC 2639

Kit cerniere a scomparsa per vasistas "ochette"

Concealed hinges for bottom-hung windows

AC 2632/B

Cerniera registrabile a due ali in acciaio zincato a saldare | Ø 13

Adjustable weld-on hinge in galvanised steel | Ø 13

AC 2640

Cricchetto per vasistas

Finger catch for bottom-hung windows

AC 2632/C

Cerniera registrabile a due ali in acciaio zincato a saldare | Ø 16

Adjustable weld-on hinge in galvanised steel | Ø 16

AC 2641

Braccetti per vasistas

Stays for bottom-hung windows

GZ acciaio zincato
galvanized steel
CZ acciaio corten grezzo
untreated corten steel
I acciaio inox AISI 304
AISI 304 stainless steel
B acciaio inox brunito
burnished stainless steel

AC 2643

Fondino dx per 2^ anta
apertura esterna

RH fitting for T-Z joint
outward opening leaf

AC 2644

Fondino sx per 2^ anta
apertura esterna

LH fitting for T-Z joint
outward opening leaf

AC 2683D

Kit cremonese dx per finestre
ad un anta - apertura esterna

RH cremone bolt set for one-leaf
outward opening window

AC 2683S

Kit cremonese sx per finestre
ad un anta - apertura esterna

LH cremone bolt set for one-leaf
outward opening window

AC 2648

Cerniera a tre ali da avvitare |
P.2843 - P.2862

Three-wing screw-in hinge |
P.2843 - P.2862

AC 2684D

Kit cremonese dx per finestre
a due ante - apertura esterna

RH cremone bolt set for two-leaf
outward opening window

AC 2684S

Kit cremonese sx per finestre
a due ante - apertura esterna

LH cremone bolt set for two-leaf
outward opening window

AC 2649

Cerniera dx a due ali da avvitare |
P.2843 - P.2862

RH two wing hinge |
P.2843 - P.2862

AC 2650

Cerniera sx a due ali da avvitare |
P.2843 - P.2862

LH two wing hinge |
P.2843 - P.2862

AC 2687

Braccetti limitatori apertura
esterna finestre

Casement stays for outward
opening windows

GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox/*stainless steel*
B ottone naturale/*natural brass*

AC 2680

Maniglia di trascinamento
per aperture esterne

Pulling handle for
outward opening

AC 2688

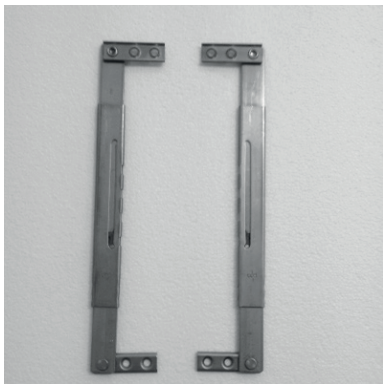
Coppia compassi
apertura a sporgere

Pair of side arms for
awning opening

AC 2689

Coppia compassi apertura a sporgere

Pair of side arms for awning opening



AC 2690

Braccetti limitatori apertura sporgere

Casement stays for awning opening

AC 2693

Serratura con scrocco e catenaccio

Latch and bolt lock

AC 2694D

Kit serratura multipunto dx per porta

RH Multi-lock set for door

AC 2694S

Kit serratura multipunto sx per porta

LH Multi-lock set for door

AC 2695D

Punto di chiusura aggiuntivo dx per porta

RH additional locking point for door

AC 2695S

Punto di chiusura aggiuntivo sx per porta

LH additional locking point for door

AC 2696

Scatola copri serratura Destra

RH lock cover box

AC 2697

Scatola copri serratura Sinistra

LH lock cover box

CV 5012

Boccola per fermavetri in alluminio

Bushing for alluminium glazing bead

CV 1023

Vite per boccola fermavetri in alluminio, TPS 4.2x13

Screw for alluminium glazing bead bushing, TPS 4.2x13

CV 1243

Vite per boccola fermavetri in alluminio, TPS M4x8

Screw for alluminium glazing bead bushing, TPS M4x8

AC 2801I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2801 - P.2801-P.2822
P.2803-P.2822 - P.2801-P.2842
P.2803-P.2842 - P.2805-P.2842
P.2815-P2842 - P.2861
P.2862-P.2863 telaio/*frame*

AC 2803I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2803
P.2815
P.2863
P.2865-P.2863

AC 2805I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2805

AC 2822I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2822
P.2805-P.2822

AC 2832I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2832-P.2833
P.2842-P.2843
P.2862-P2863

AC 2833I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2833

AC 2843I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2843

AC 2851I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2851

AC 2852I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2852

AC 2865I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2865

AC 2853I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2853
P.2873

AC 2871I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2871

AC 2855I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2855
P.2874

AC 2872I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2872

AC 2862I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2862

AC 2875I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2875

AC 2882I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2882

AC 2892I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2892
P.2893

AC 2895I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
P.2895

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 770

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

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

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 774

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

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

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 771

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

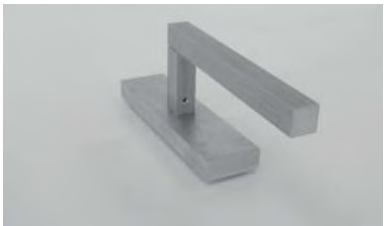
Cremone handle
small ”VITRUVIO”
for window
T | cut | round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 776

Martellina cremonese
”VITRUVIO”
per finestra
KIDS

Cremone handle
small ”VITRUVIO”
for window
KIDS



B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 772

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

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

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 777

Martellina cremonese
”VITRUVIO”
per finestra
OVALE

Cremone handle
small ”VITRUVIO”
for window
OVAL

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 773

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

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

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 779

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

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

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 780

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
T | quadra | tronca

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
T | cut | square

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 781

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
T | tonda| tronca

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
T | cut | round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 782

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
L | quadra | tronca

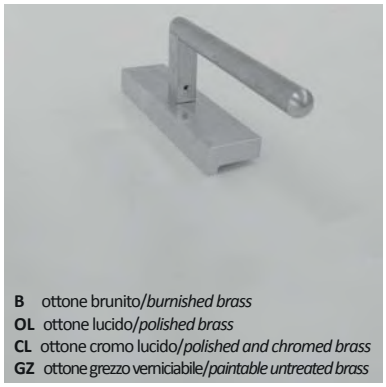
Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
L | cut | square

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 783

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
L | tonda| tronca

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
L | cut | round



B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 784

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
L | tonda| sfera

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
L | sphere | round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 786

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
KIDS

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
KIDS

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 787

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
OVALE

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
OVAL

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*

ACV 789

Martellina cremonese
”VITRUVIO” small
per finestra a un anta
P2833
T | tonda| sfera

Cremone handle
small ”VITRUVIO”
for single leaf window
P2833
T | sphere | round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 942

Coppia maniglie ”VITRUVIO”
medium
rosetta quadra
per porta
L | quadra | tronca

Double cremone handle
medium ”VITRUVIO”
square washer
for door
L | cut | square

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
CZ acciaio corten grezzo/*untreated corten steel*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 952

Coppia maniglie ”VITRUVIO”
medium
rosetta rettangolare
per porta
L | quadra | tronca

Double cremone handle
medium ”VITRUVIO”
rectangular washer
for door
L | cut | square

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 943

Coppia maniglie ”VITRUVIO”
medium
rosetta quadra
per porta
L | tonda| tronca

Double cremone handle
medium ”VITRUVIO”
square washer
for door
L | cut | round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 953

Coppia maniglie ”VITRUVIO”
medium
rosetta rettangolare
per porta
L | tonda| tronca

Double cremone handle
medium ”VITRUVIO”
rectangular washer
for door
L | cut | round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 944

Coppia maniglie ”VITRUVIO”
medium
rosetta quadra
per porta
L | tonda| sfera

Double cremone handle
medium ”VITRUVIO”
square washer
for door
L | sphere| round

B ottone brunito/*burnished brass*
OL ottone lucido/*polished brass*
CL ottone cromo lucido/*polished and chromed brass*
GZ ottone grezzo verniciabile/*paintable untreated brass*
SB acciaio inox AISI 304 Scotch Brite
Aisi 304 scotch-brite stainless steel

ACV 954

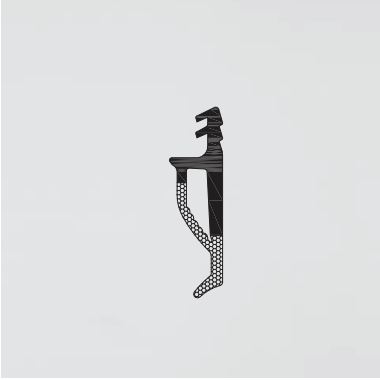
Coppia maniglie ”VITRUVIO”
medium
rosetta rettangolare
per porta
L | tonda| sfera

Double cremone handle
medium ”VITRUVIO”
rectangular washer
for door
L | sphere| round

GE 2600TT

Guarnizione di battuta interna su profilo P.2833

Internal weather strip with P.2833 profile



GE 2645TT

Guarnizione di battuta interna|esterna su profili P2843 - P2863 - P2862

Internal/external weather strip with P2843 - P2862 - P2863 profiles

GE 2602

Guarnizione per giunto aperto

Apertura interna

Weather strip for open joint

Inward opening

GP 0095

Guarnizione interna vetro spessore 3mm

Internal weather strip for glazing bead 3 mm thick

GE 2606

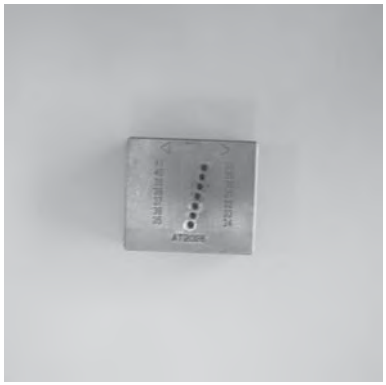
Guarnizione adesiva esterno vetro

Adhesive weather strip outer window

GU 2035

Piattina adesiva morbida per fondo giunto esterno vetro 15x3 mm

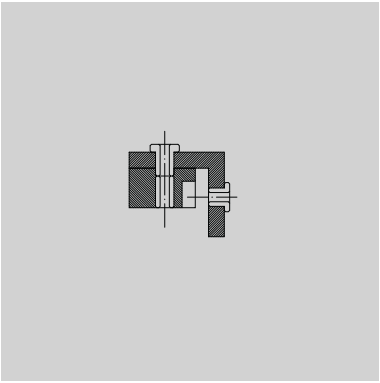
Soft adhesive shim for external window joint 15x3 mm



AT 2028

Maschera per esecuzione fori fissaggio fermavetri

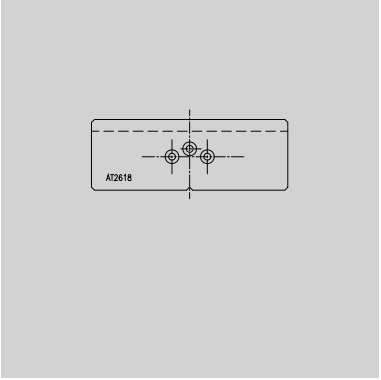
Drill jig for glazing beads securing



AT 2825

Maschera per applicazione cremonese AC2624-AC2625 Profilo P.2843 e aperture esterne

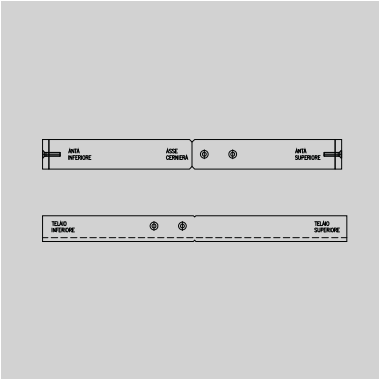
Jig for AC2624-AC2625 cremone bolt installation P.2843 profile and outward opening



AT 2818

Maschera per esecuzione fori per applicazione scarico acqua AC2618-AC2618NE

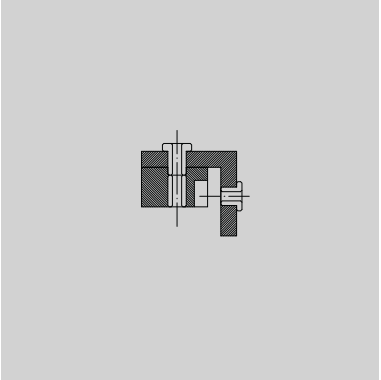
Drill jig for AC2618-AC2618NE water drip installation



AT 2629

Maschera per esecuzione fori fissaggio cerniere AC2629-AC2630

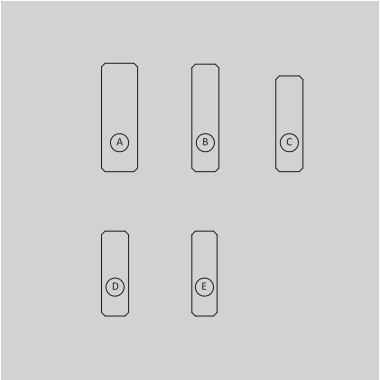
Drill jig for AC2629-AC2630 hinges



AT 2823

Maschera per applicazione cremonese AC2623 Profilo P.2833

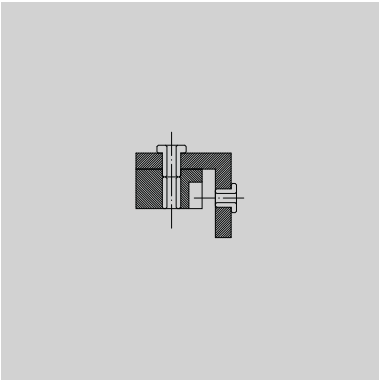
Jig for AC2623 cremone bolt installation P.2833 profile



AT 2800

Kit ganasce di taglio

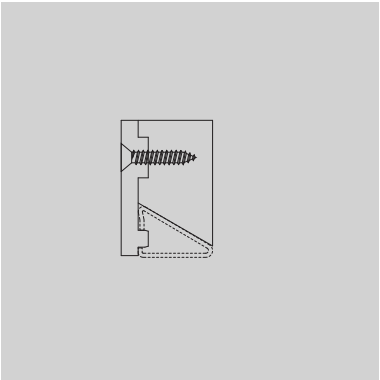
Kit of cutting jaws for profiles



AT 2824

Maschera per applicazione cremonese AC2624 Profilo P.2833

Jig for AC2624 cremone bolt installation P.2833 profile



AT 2829

Ganasce di taglio per fermavetro P.2629

Kit of cutting jaws for glazin bead P.2629

SA 2031

Liquido deumidificante vetri

Glass dehumidifying liquid

SA 3001

Acido per ossidazione corten

Oxidising acid for corten

SA 2032

Primer di adesione per profili verniciati

Adhesion primer for painted profiles

SA 3002

Passivante per ossidazione corten | 25 Kg

Passivating agent for corten | 25 Kg

SA 3002/5

Passivante per ossidazione corten | 5 Kg

Passivating agent for corten | 5 Kg

SA 2033

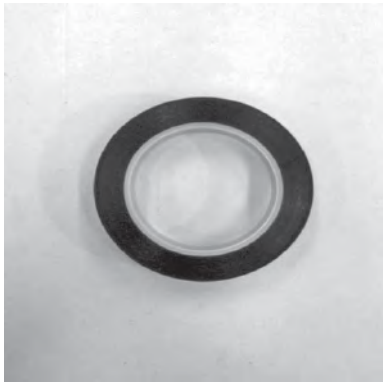
Liquido di adesione per materiale plastico

Adhesion liquid for plastic

SA 3003

Cera d'api per finitura corten

Beeswax for Corten finishing



SA 1024

Nastro adesivo protettivo per verniciatura

Sticky tape for painting

SA 005/10

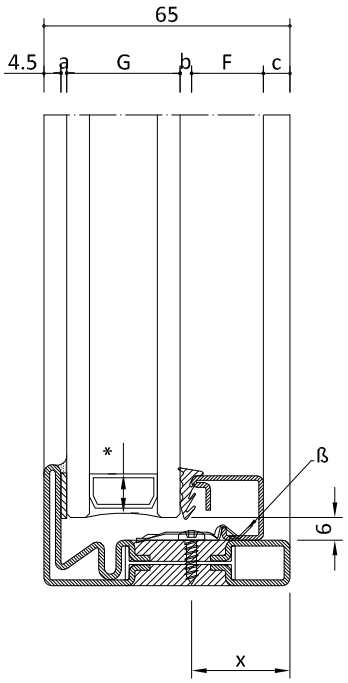
Liquido neritore per brunitura| 10 Kg

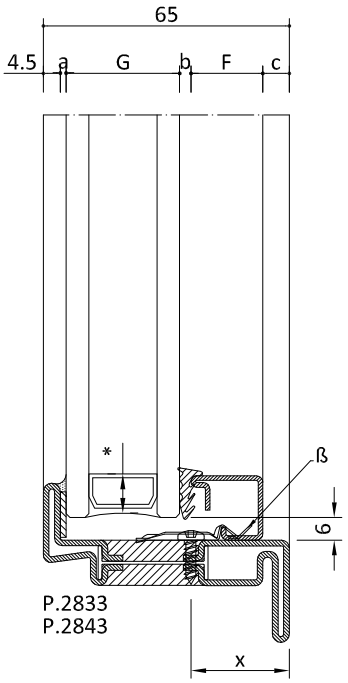
Liquid for burnishing | 10 Kg

SA 005/01

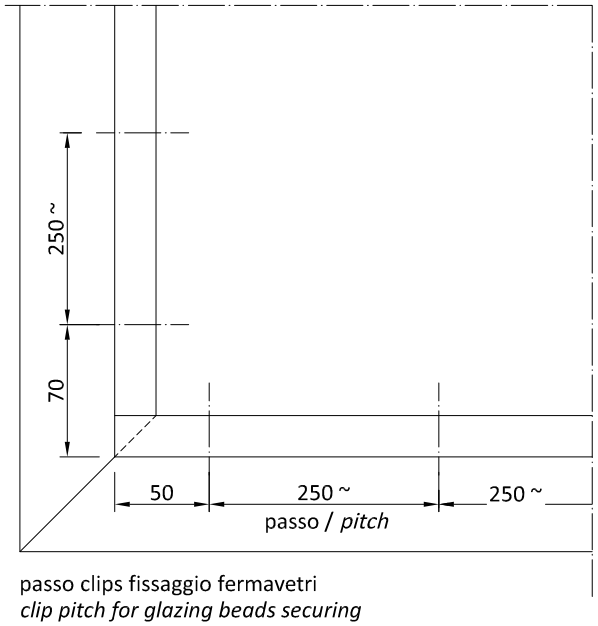
Liquido neritore per brunitura| 1 Kg

Liquid for burnishing | 1 Kg



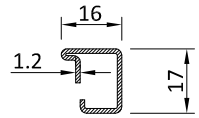
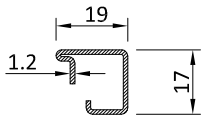
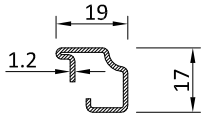
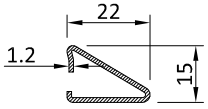


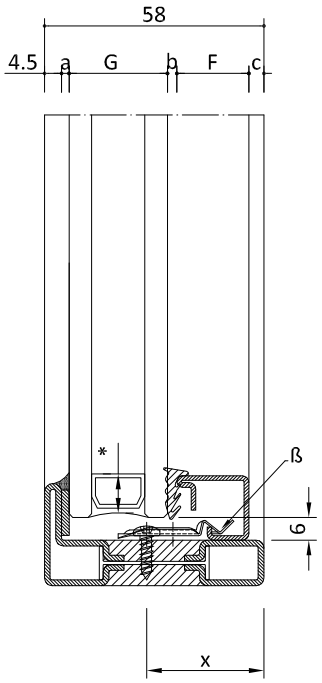
P.2833
P.2843

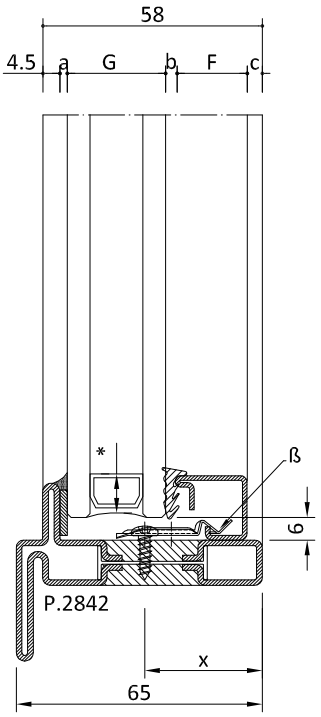


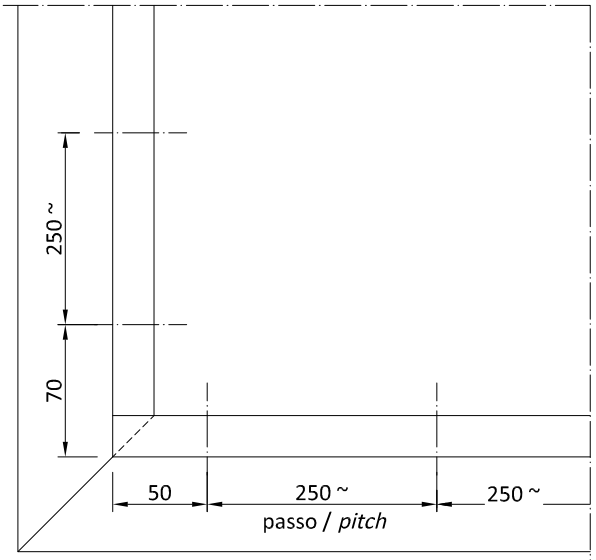
passo clips fissaggio fermavetri
clip pitch for glazing beads securing

* si consiglia l'utilizzo di canalina vetrocamera ridotta
* *we recommend to use a reduced glazing spacer*

F	G	guarnizioni *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2035 2 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
 P.2606	36 - 40	2	3	30 - 26	4 - 0	AC2608
 P.2607	32 - 37			30 - 26	4 - 0	AC2608
 P.2627	32 - 37			30 - 26	4 - 0	AC2608
 P.2629	30 - 34			34 - 30	4 - 0	AC2608

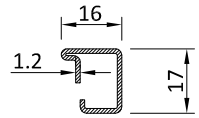
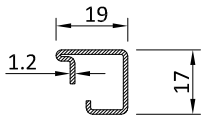
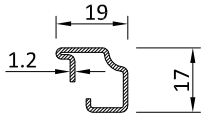
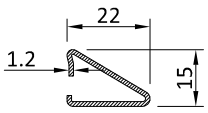


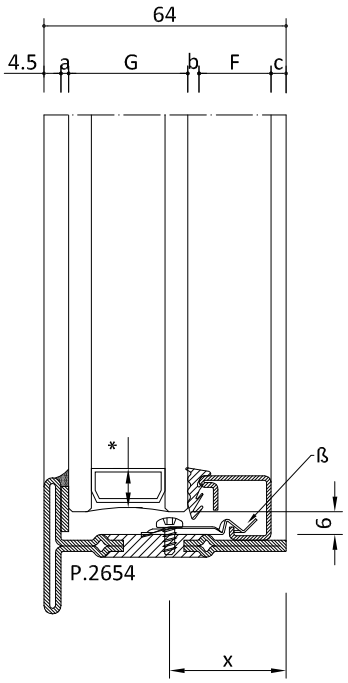


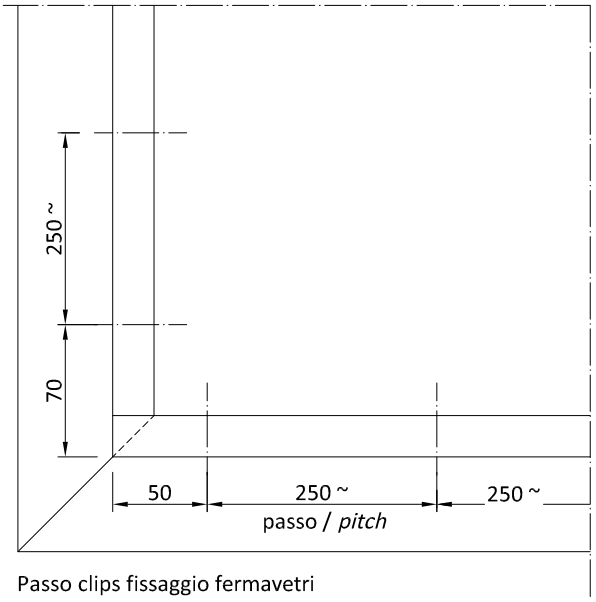


Passo clips fissaggio fermavetri
clip pitch for glazing beads securing

* si consiglia l'utilizzo di canalina vetrocamera ridotta
* *we recommend to use a reduced glazing spacer*

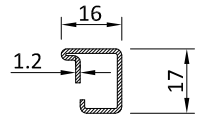
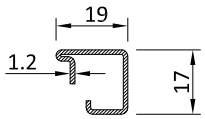
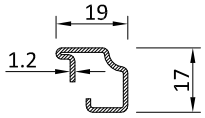
F	G	guarnizioni *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2035 2 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
 P.2606	30 - 33	2	3	30 - 27	4 - 0	AC2608
 P.2607	26 - 30			31 - 27	4 - 0	AC2608
 P.2627	26 - 30			31 - 27	4 - 0	AC2608
 P.2629	24 - 27			34 - 31	3 - 0	AC2608

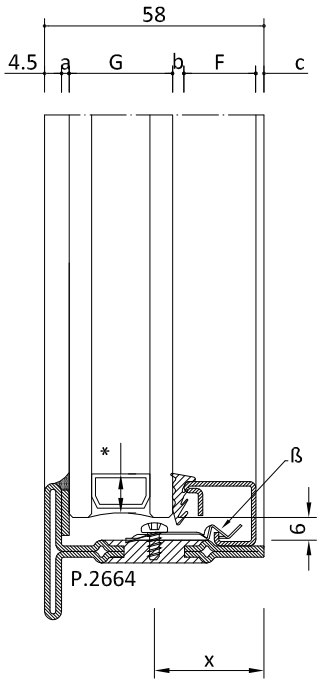


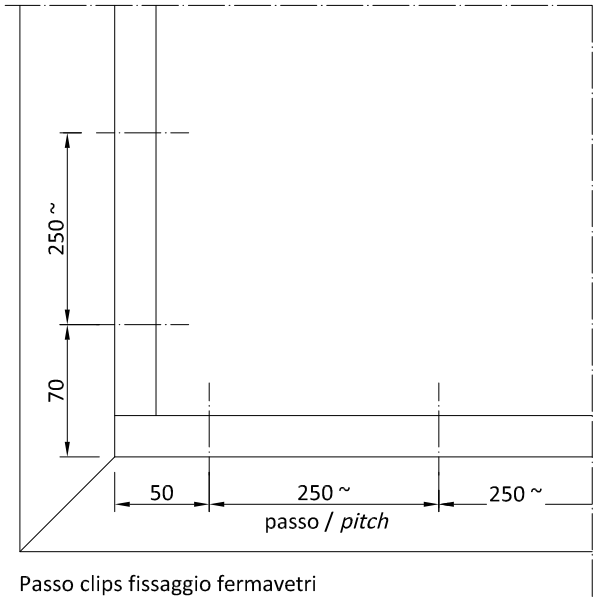


Passo clips fissaggio fermavetri
clip pitch for glazing beads securing

* si consiglia l'utilizzo di canalina vetrocamera ridotta
* *we recommend to use a reduced glazing spacer*

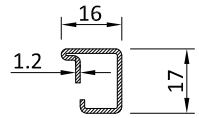
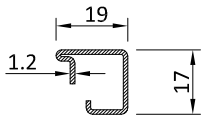
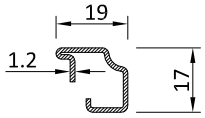
F	G	guarnizioni *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2035 2 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
 P.2606	36 - 40	2	3	30 - 26	4 - 0	AC2609
 P.2607	32 - 37			30.5 - 26.5	4 - 0	AC2609
 P.2627	32 - 37			30.5 - 26.5	4 - 0	AC2609

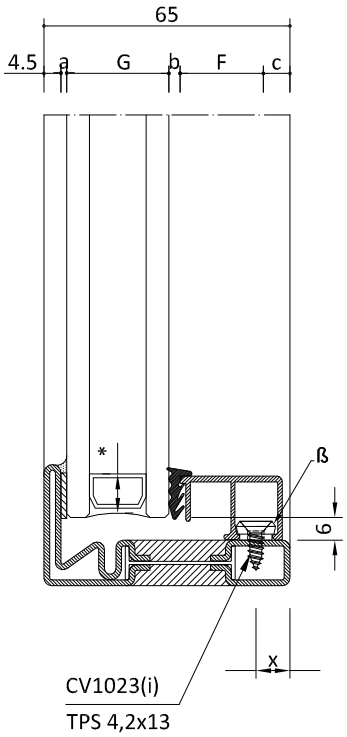


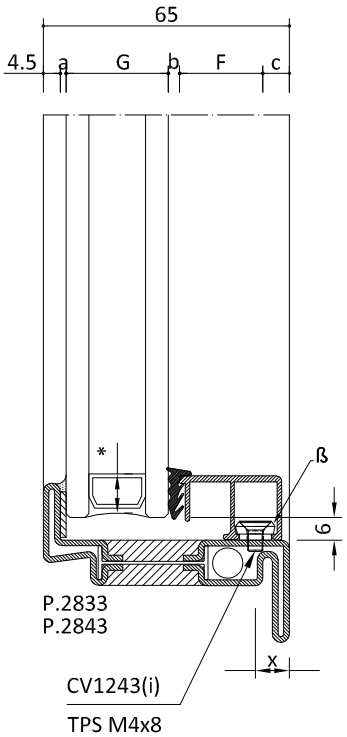


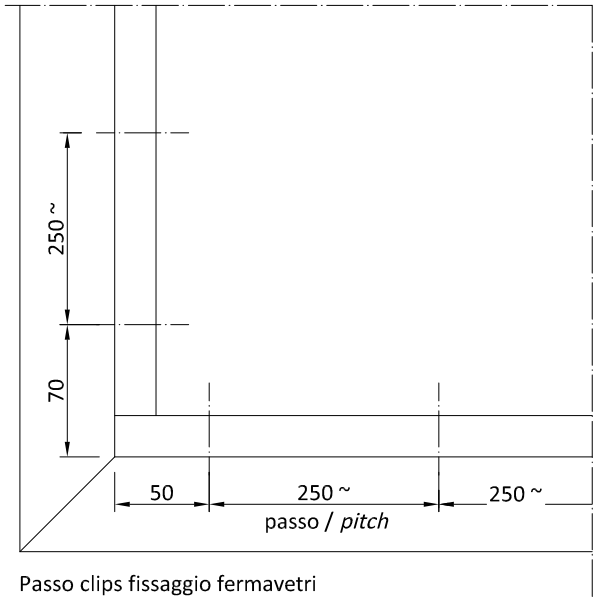
Passo clips fissaggio fermavetri
clip pitch for glazing beads securing

* si consiglia l'utilizzo di canalina vetrocamera ridotta
* *we recommend to use a reduced glazing spacer*

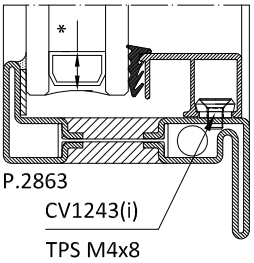
F	G	guarnizioni *gasket*				
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2035 2 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
 P.2606	30 - 32	2	3	29 - 27	2 - 0	AC2609
 P.2607	27 - 29			29 - 27	2 - 0	AC2609
 P.2627	27 - 29			29 - 27	4 - 0	AC2609





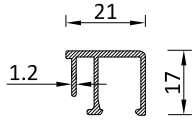
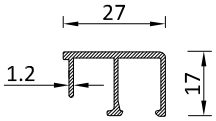


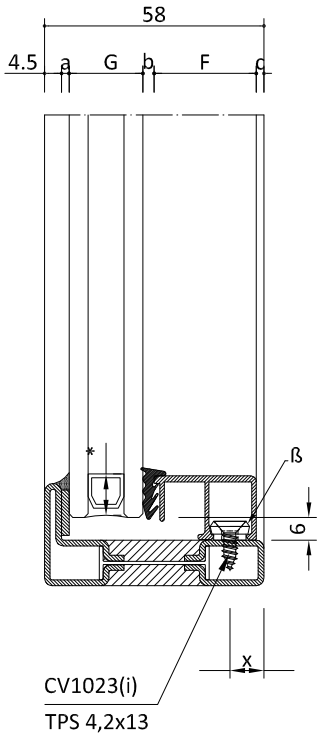
Passo clips fissaggio fermavetri
clip pitch for glazing beads securing

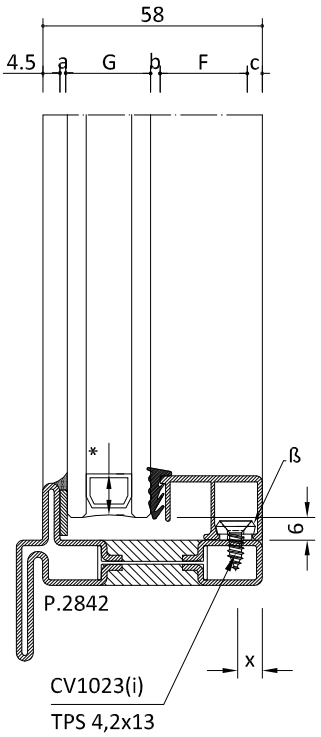


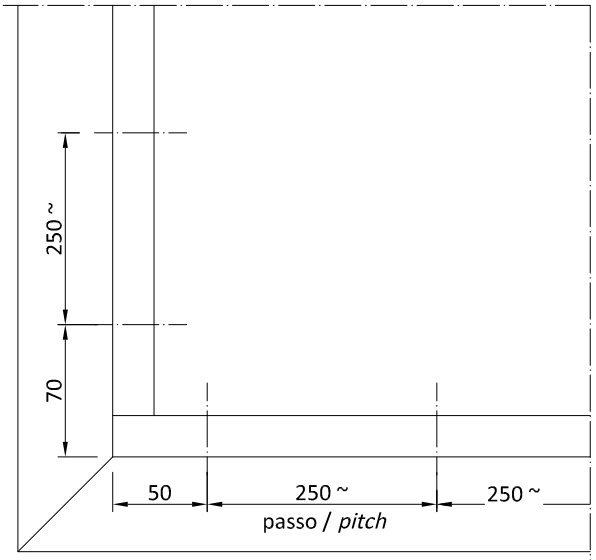
N.B. In corrispondenza delle aste di chiusura per fissare le boccoline fermavetro usare viti metriche TPS M4 x 8 (CV1243)
Use TPS M4x8 (CV1243) screws to secure bushings on the cremone rod

* si consiglia l'utilizzo di canalina vetrocamera ridotta
* we recommend to use a reduced glazing spacer

F	G	guarnizioni *gasket*				
fermavetri in alluminio *alluminium glazing beads*	spessore vetro *glass thickness*	GU2035 (2 mm) + sigillatura *+ seal*	GP0095 (2 / 3 mm)	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
 PA2607	33 - 35	2	3	9 - 7	2 - 0	CV5012(i) - CV1023(i) CV1243(i)
 PA2608	27 - 29			9 - 7	2 - 0	CV5012(i) - CV1023(i) CV1243(i)

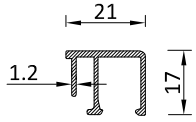
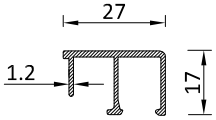


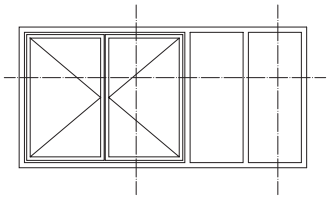




Passo clips fissaggio fermavetri
clip pitch for glazing beads securing

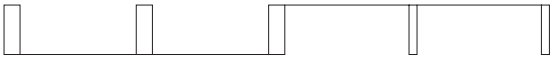
* si consiglia l'utilizzo di canalina vetrocamera ridotta
* *we recommend to use a reduced glazing spacer*

F	G	guarnizioni *gasket*				
fermavetri in allumninio *alluminium glazing beads*	spessore vetro *glass thickness*	GU2035 2 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	c	ß
 PA2607	26 - 28	2	3	9 - 7	2 - 0	CV5012(i) - CV1023(i) CV1243(i)
 PA2608*	20 - 22			9 - 7	2 - 0	CV5012(i) - CV1023(i) CV1243(i)



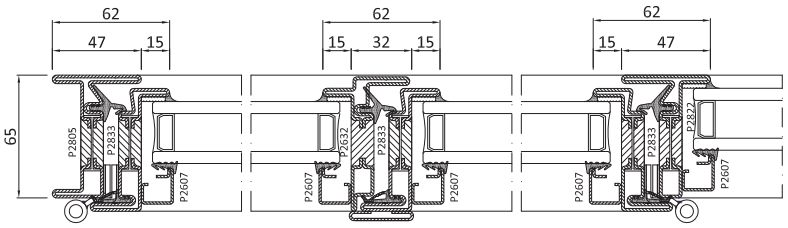
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa in luce

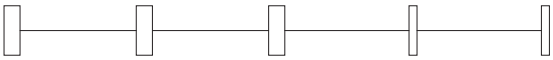
Type
double leaf window with fixed light
inward opening
laying middle wall



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

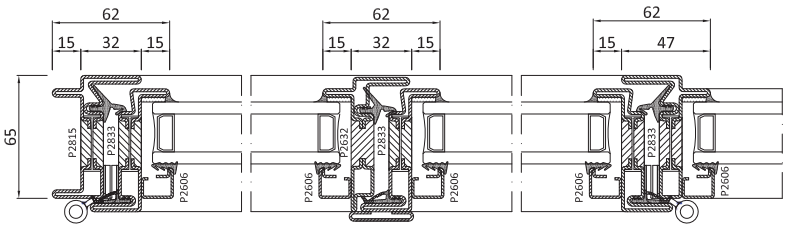
System 1
minimised sections
non-flush glasses
visible openings on the facade

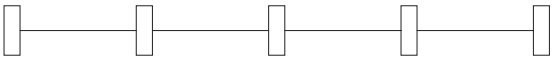




Sistema 2
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

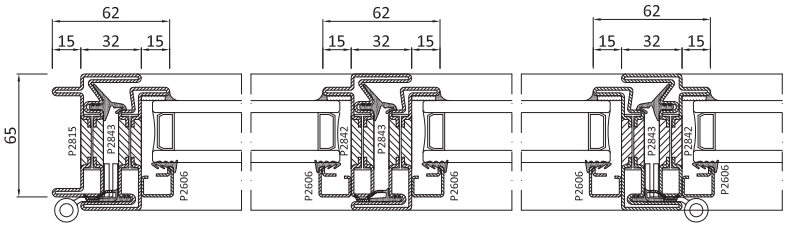
System 2
minimised sections
flush glasses
visible openings on the facade

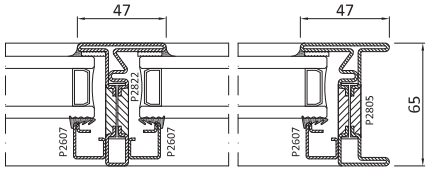




Sistema 3
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 3
congruent sections
flush glasses
invisible openings on the facade

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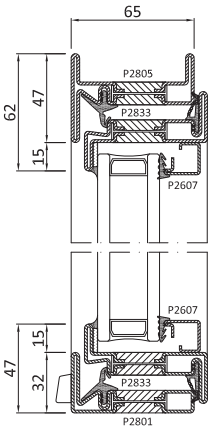
47
P2822
P2607
P2607
P2607
P2805
65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P2833
P2607
P2607
P2833
P2801
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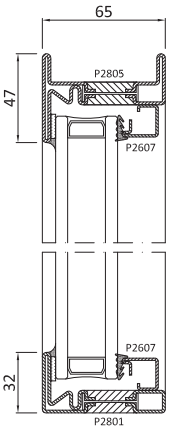
32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P2607
P2801
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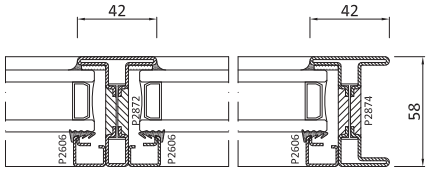
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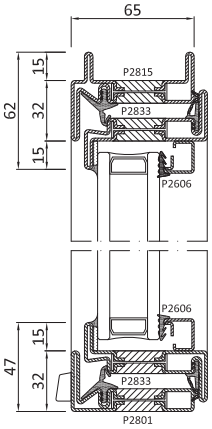
P2606
P2606
P2606
P2874
58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P2815
P2833
P2606
P2606
P2833
P2801
62
15
32
15
47
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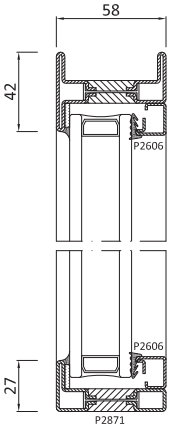
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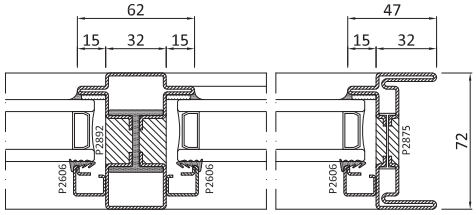
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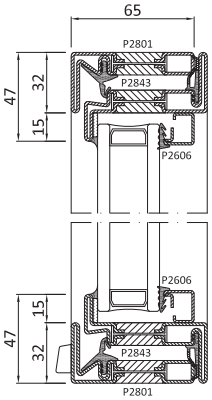
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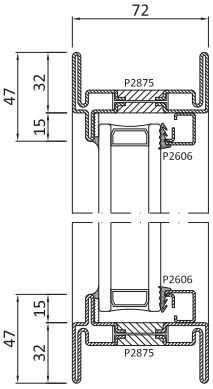
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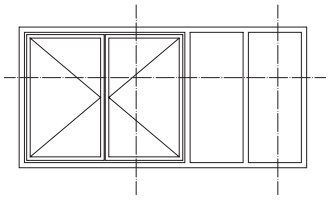
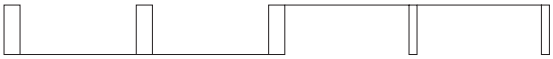


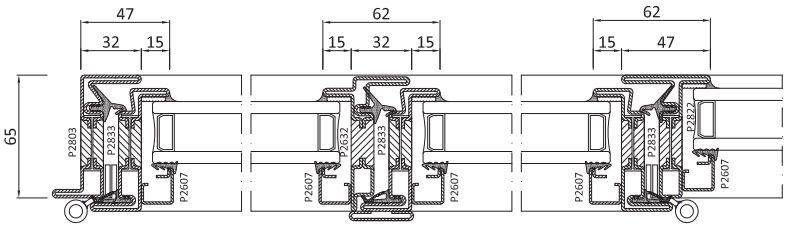
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa interno muro

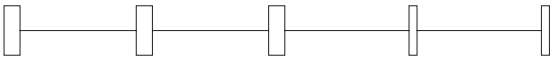
Type
double leaf window with fixed light
inward opening
laying internal wall



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

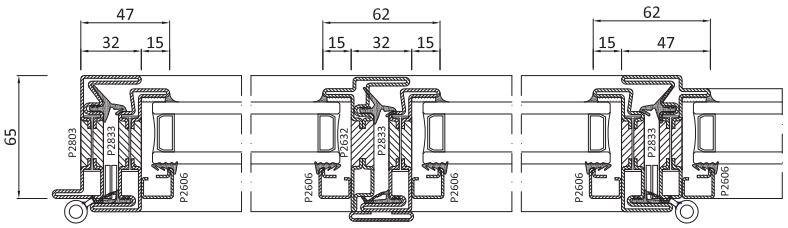
System 1
minimised sections
non-flush glasses
visible openings on the facade

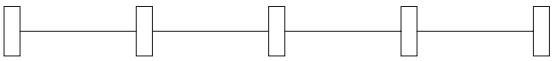




Sistema 2
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

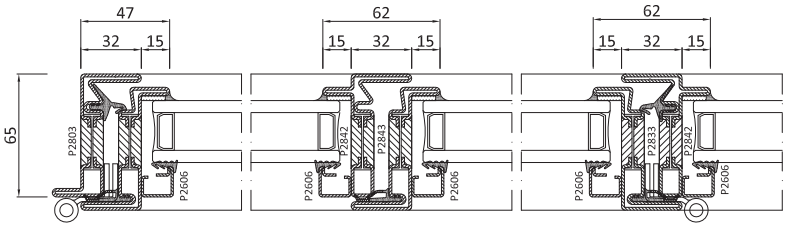
System 2
minimised sections
flush glasses
visible openings on the facade

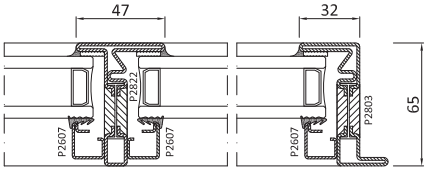




Sistema 3
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 3
congruent sections
flush glasses
invisible openings on the facade

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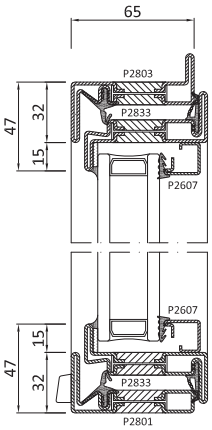
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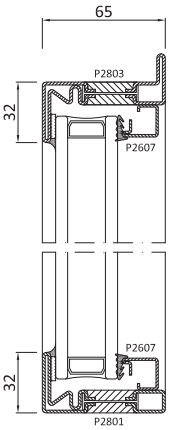
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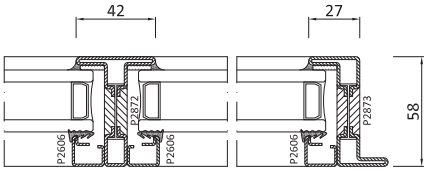
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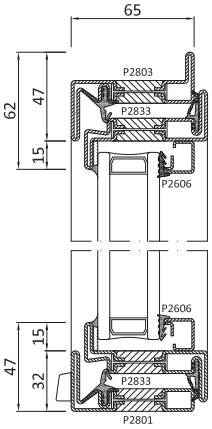
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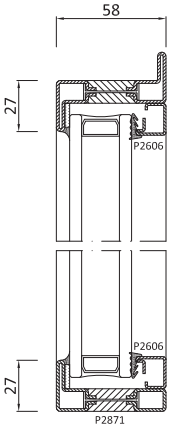
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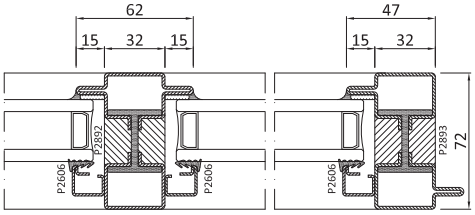
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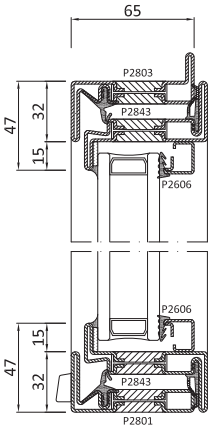
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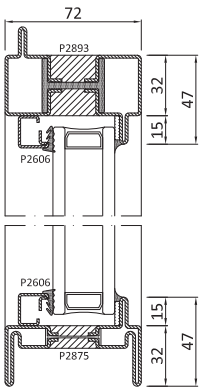
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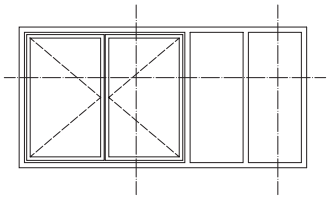
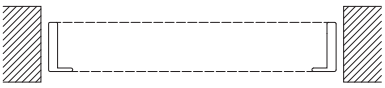
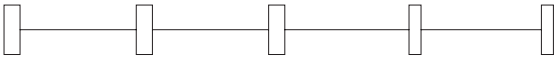




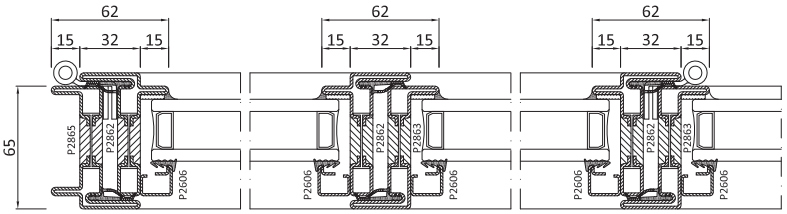
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa in luce

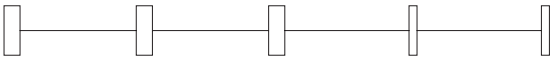
Type
double leaf window with fixed light
outward opening
laying middle wall



Sistema 1
sezioni minimizzate sez. 65 mm
vetri complanari
aperture in evidenza nel prospetto

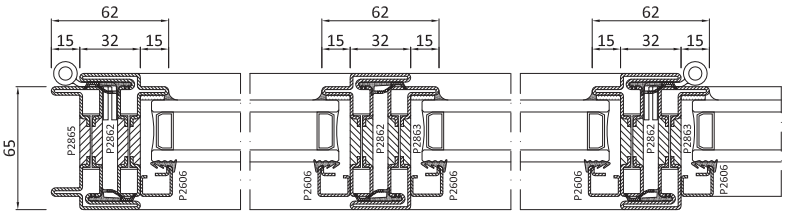
System 1
minimised sections 65 mm
flush glasses
visible openings on the facade

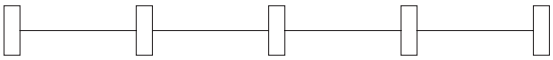




Sistema 2
sezioni minimizzate sez. 58 mm
vetri complanari
aperture in evidenza nel prospetto

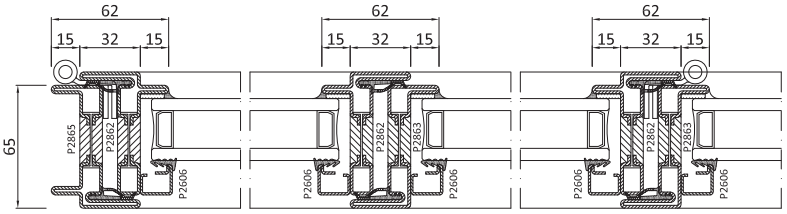
System 2
minimised sections 58 mm
flush glasses
visible openings on the facade

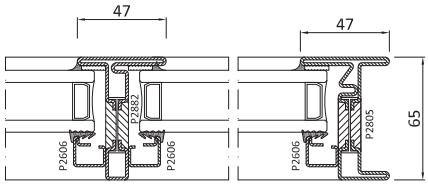




Sistema 3
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 3
congruent sections
flush glasses
invisible openings on the facade

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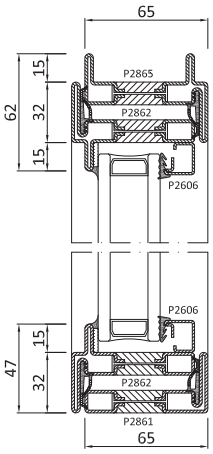
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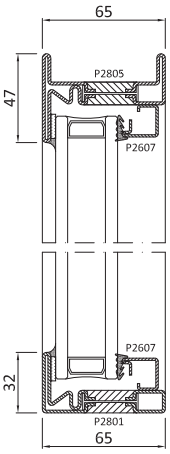
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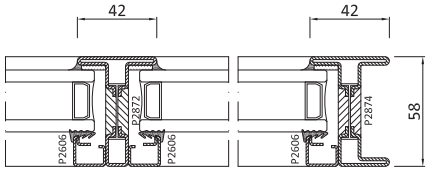
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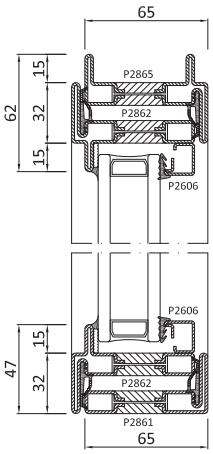
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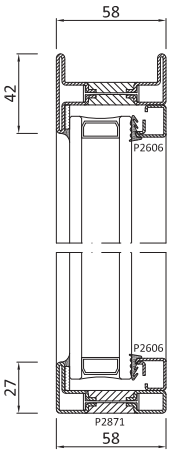
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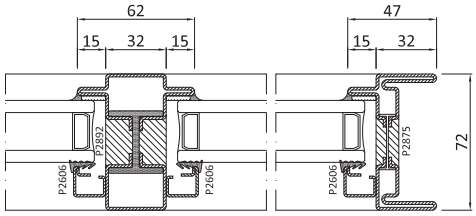
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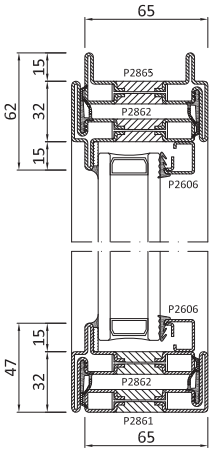
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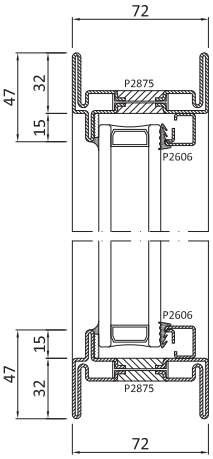
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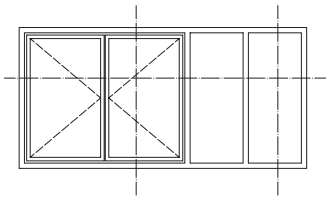
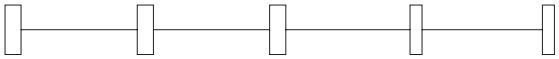


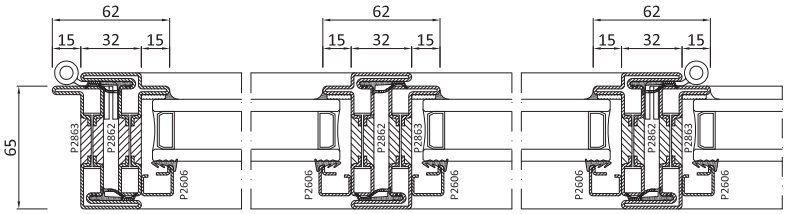
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa esterno muro

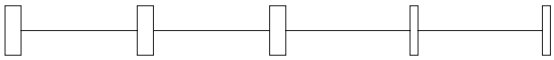
Type
double leaf window with fixed light
external opening
laying external wall



Sistema 1
sezioni minimizzate sez. 65 mm
vetri complanari
aperture in evidenza nel prospetto

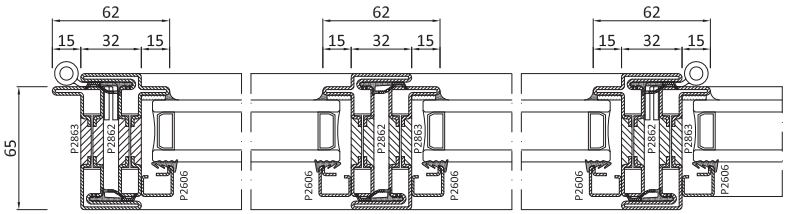
System 1
minimised sections 65 mm
flush glasses
visible openings on the facade

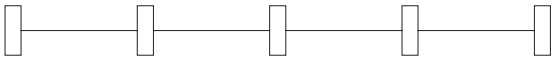




Sistema 2
sezioni minimizzate sez. 58 mm
vetri complanari
aperture in evidenza nel prospetto

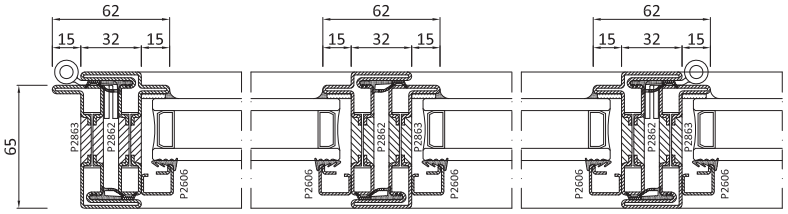
System 2
minimised sections 58 mm
flush glasses
visible openings on the facade

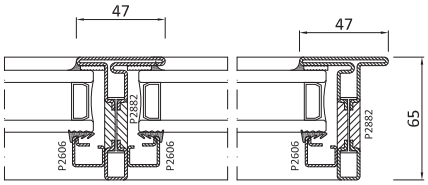




Sistema 3
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 3
congruent sections
flush glasses
invisible openings on the facade

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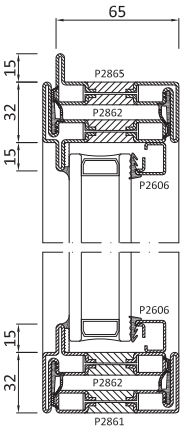
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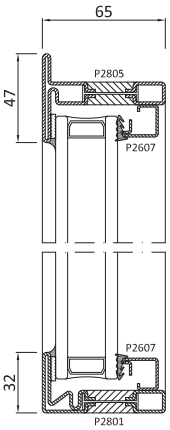
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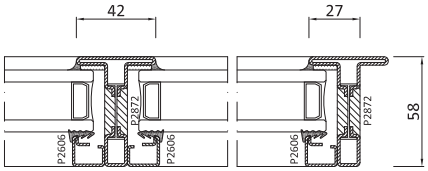
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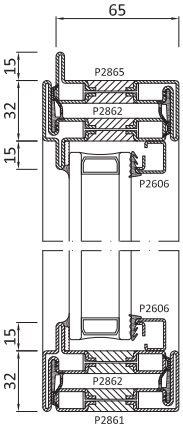
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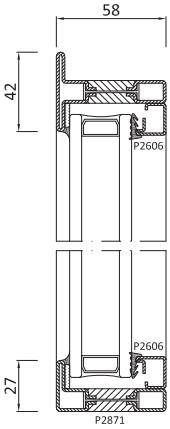
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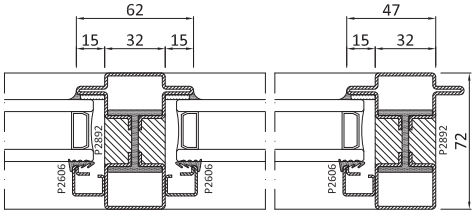
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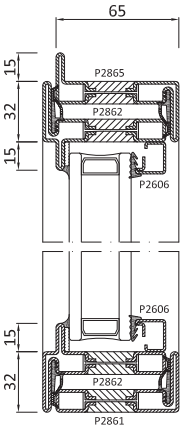
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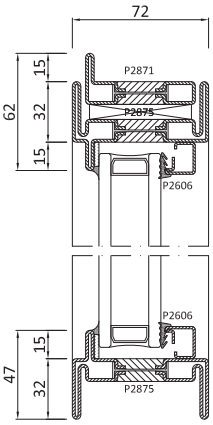
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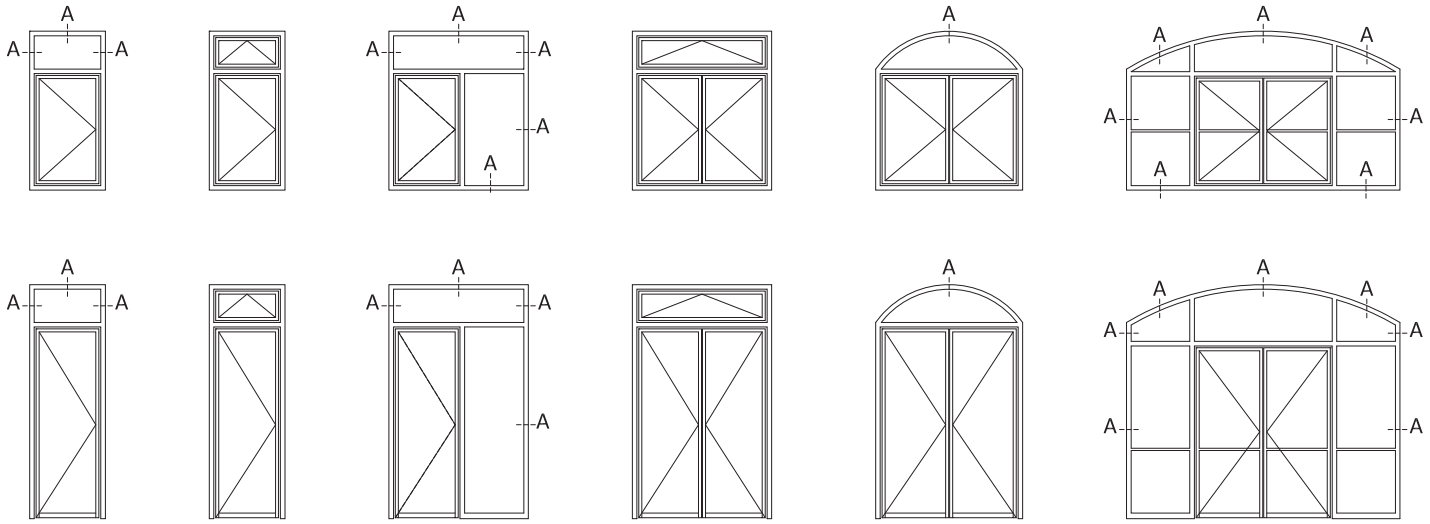
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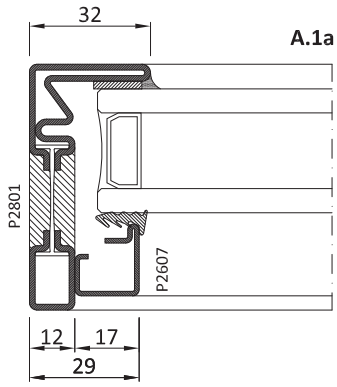
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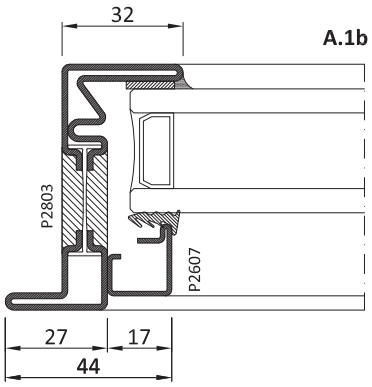
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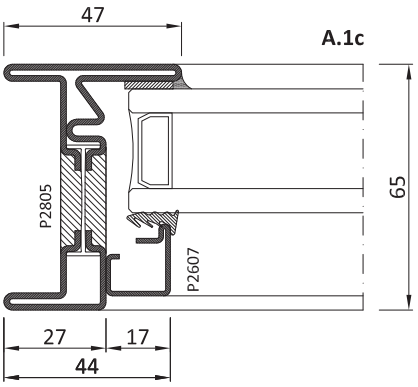
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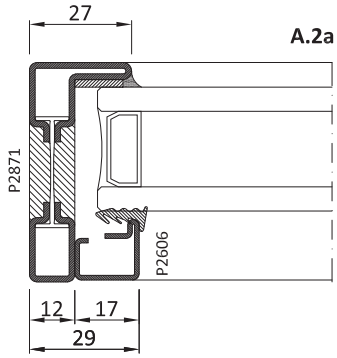
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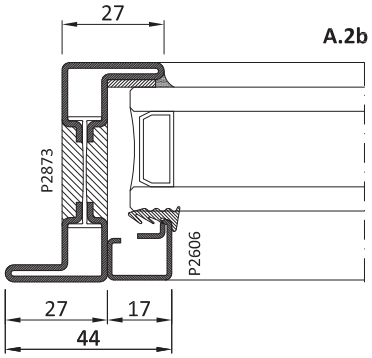
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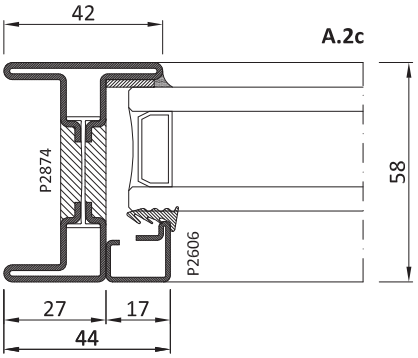
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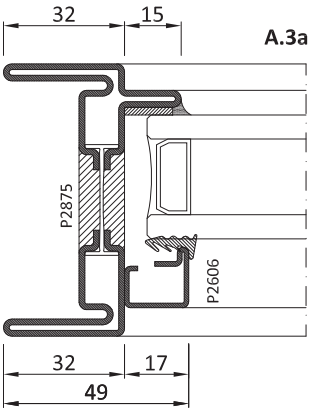
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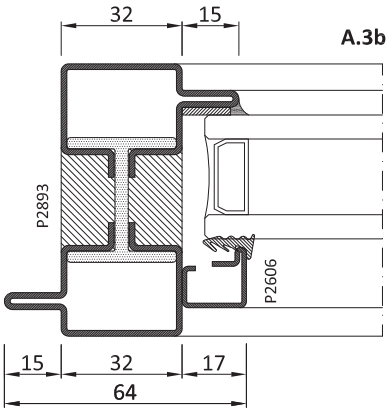
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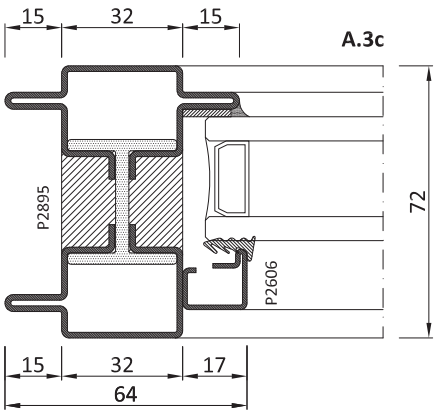
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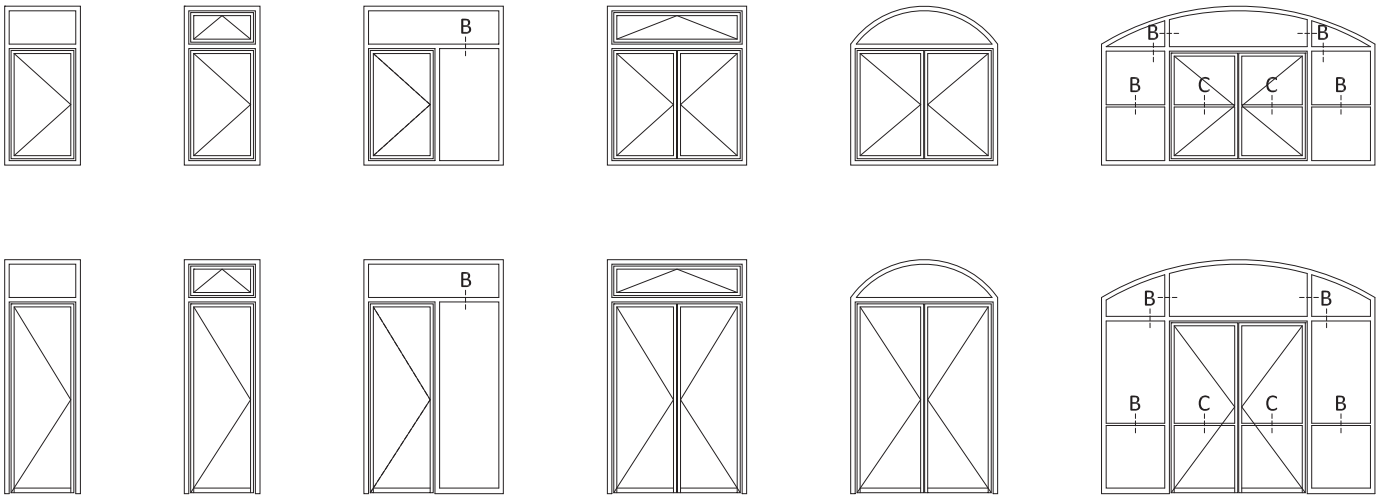
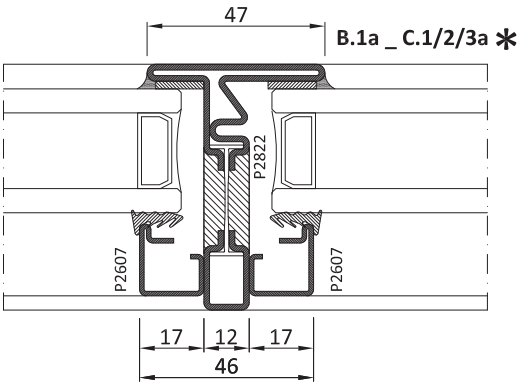
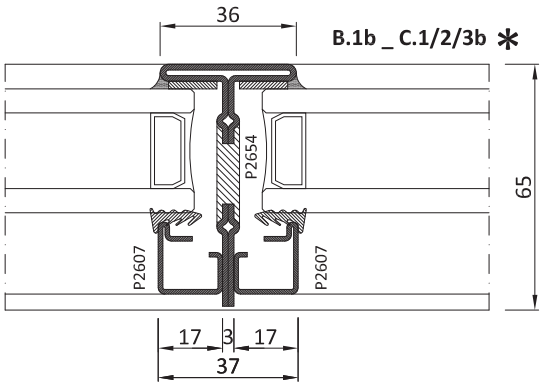
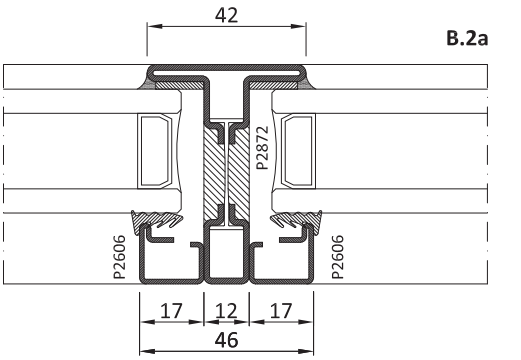
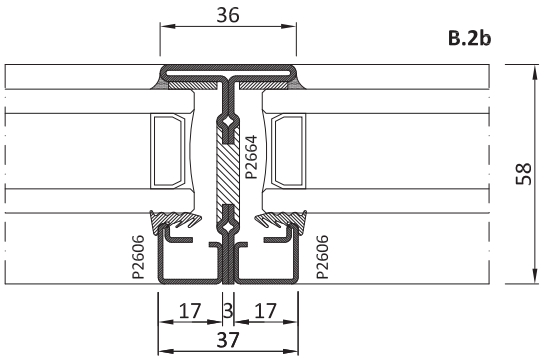
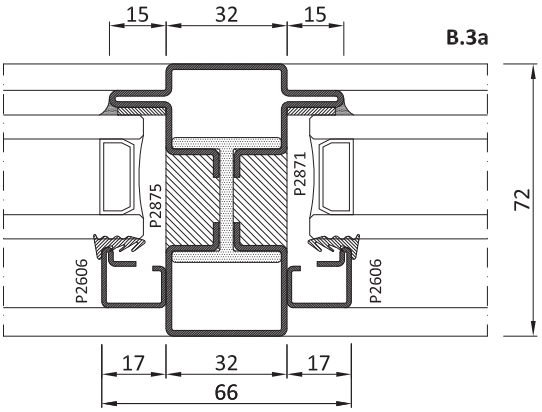






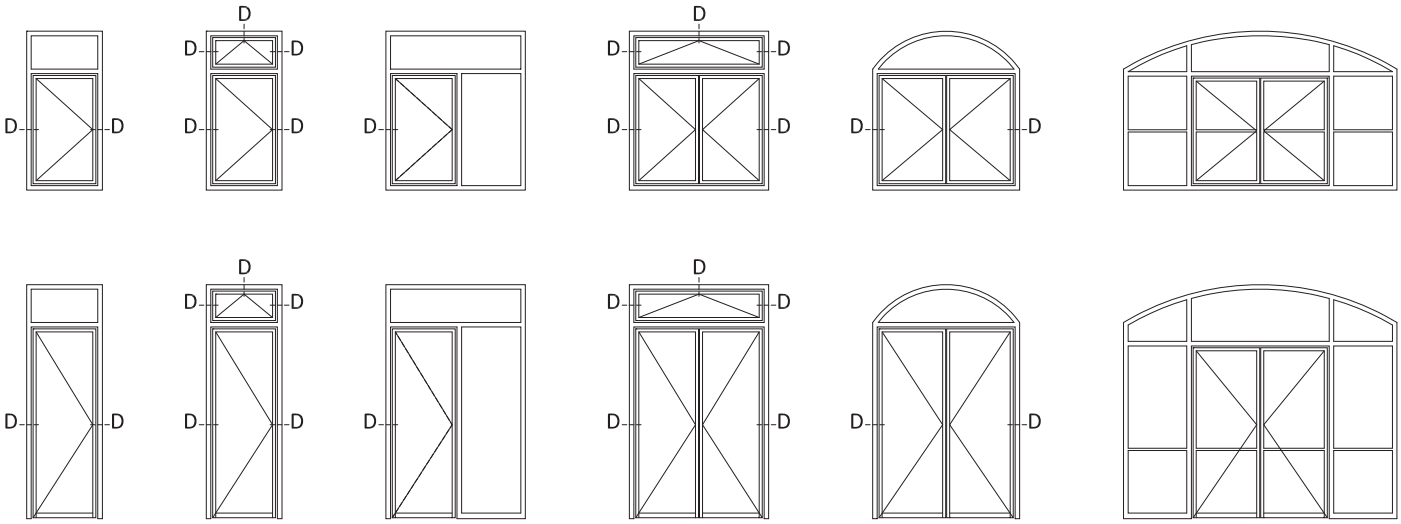






✱ **Attenzione non utilizzabile con profilo P2842**

✱ ***Unable to use with P2842 profile***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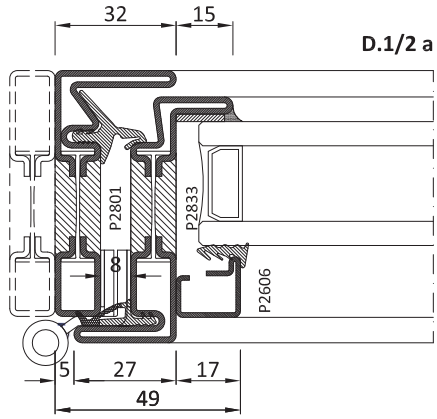
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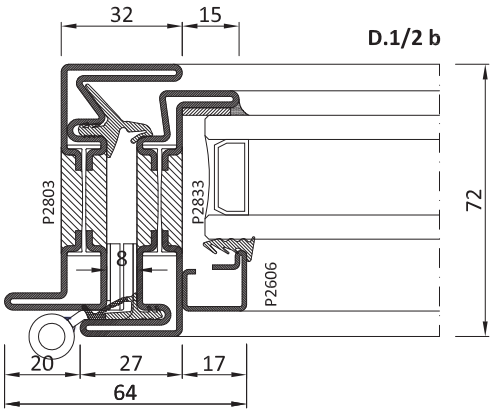
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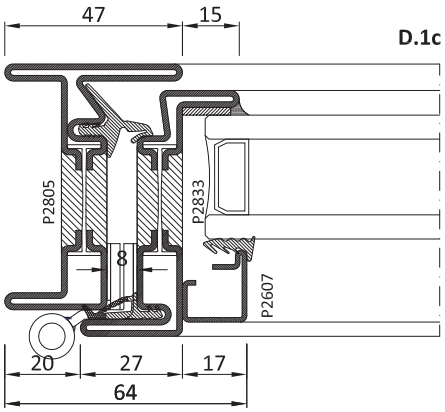
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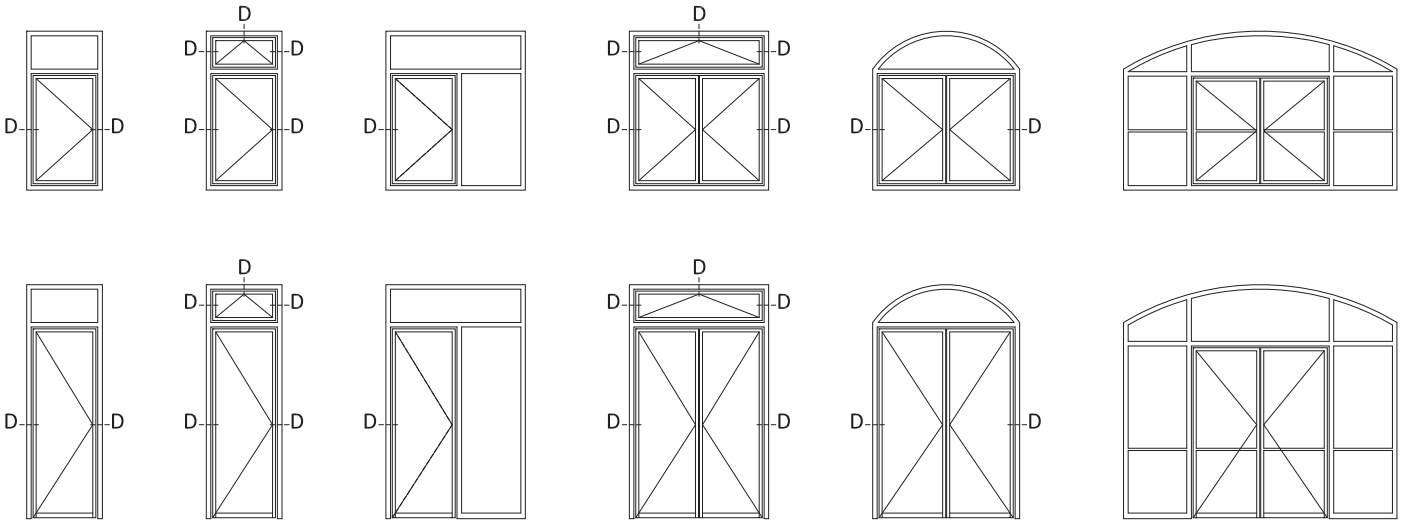
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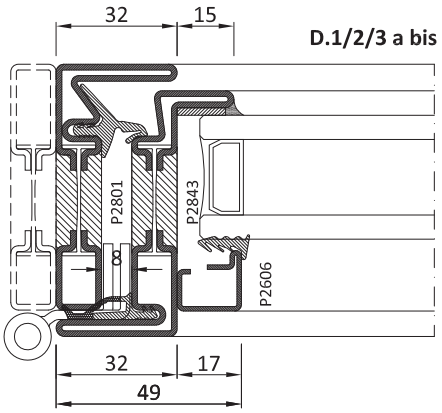
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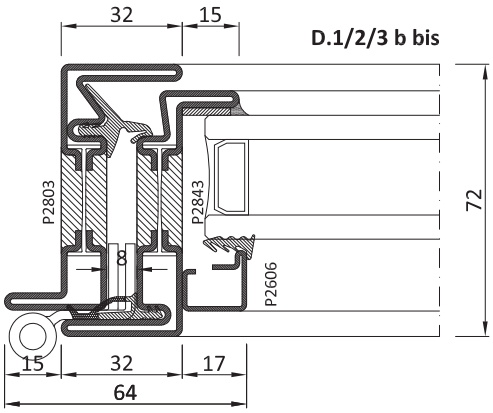
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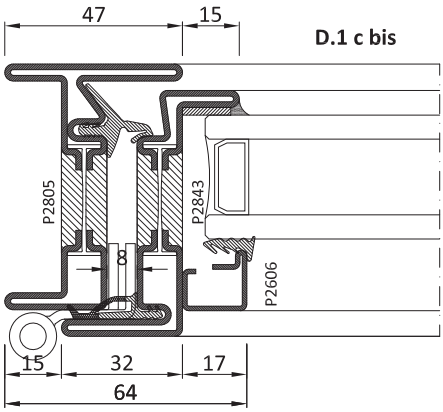
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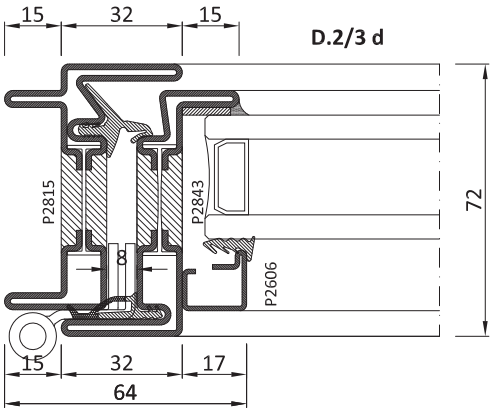
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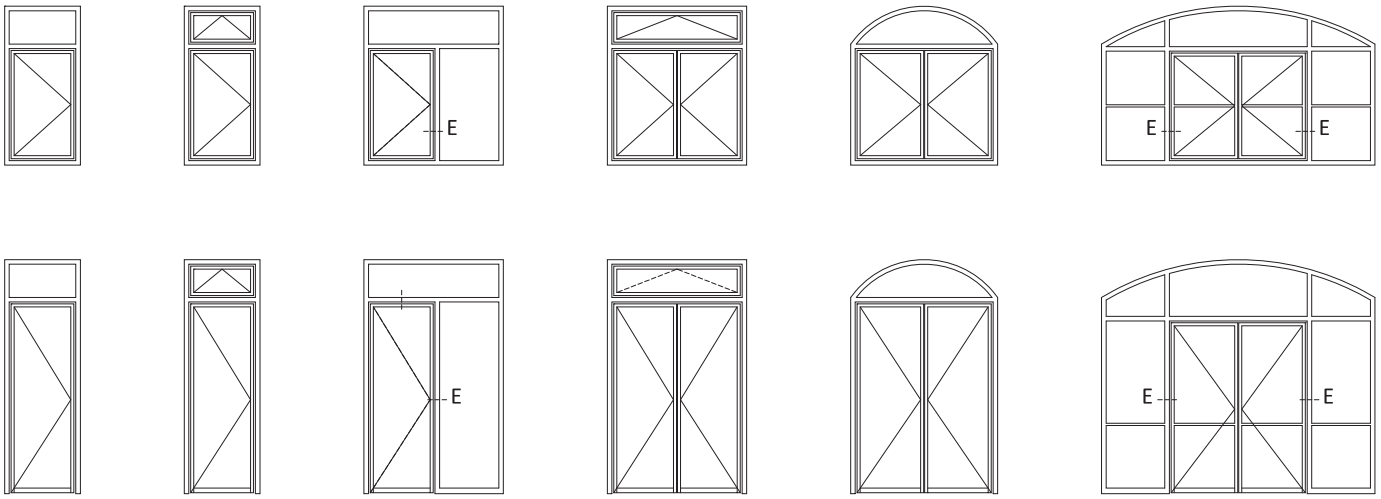
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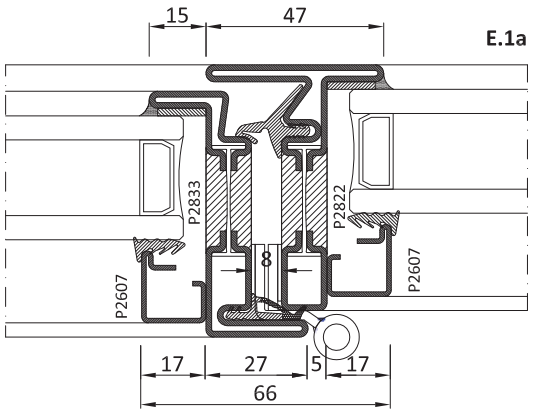
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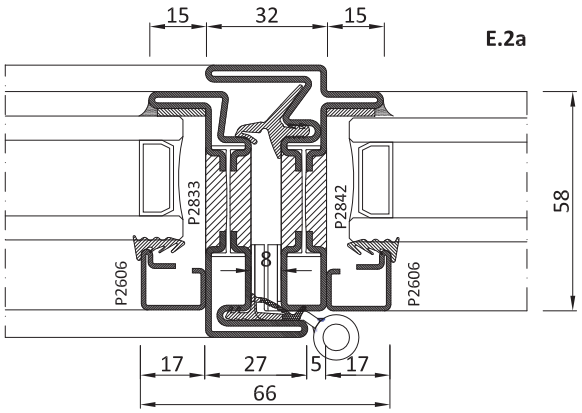
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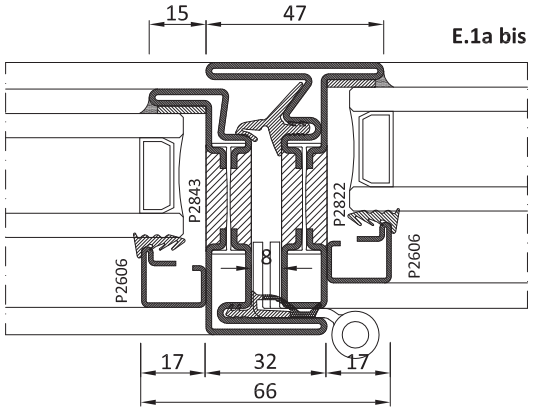
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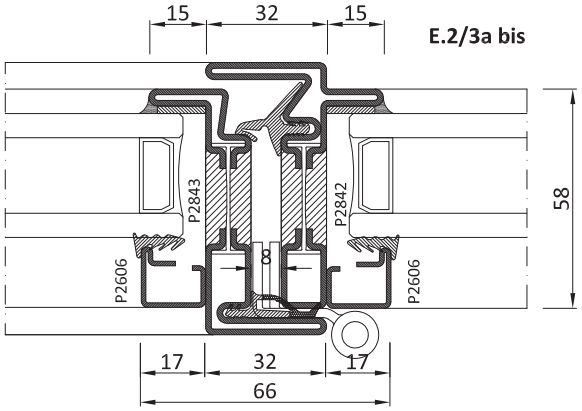
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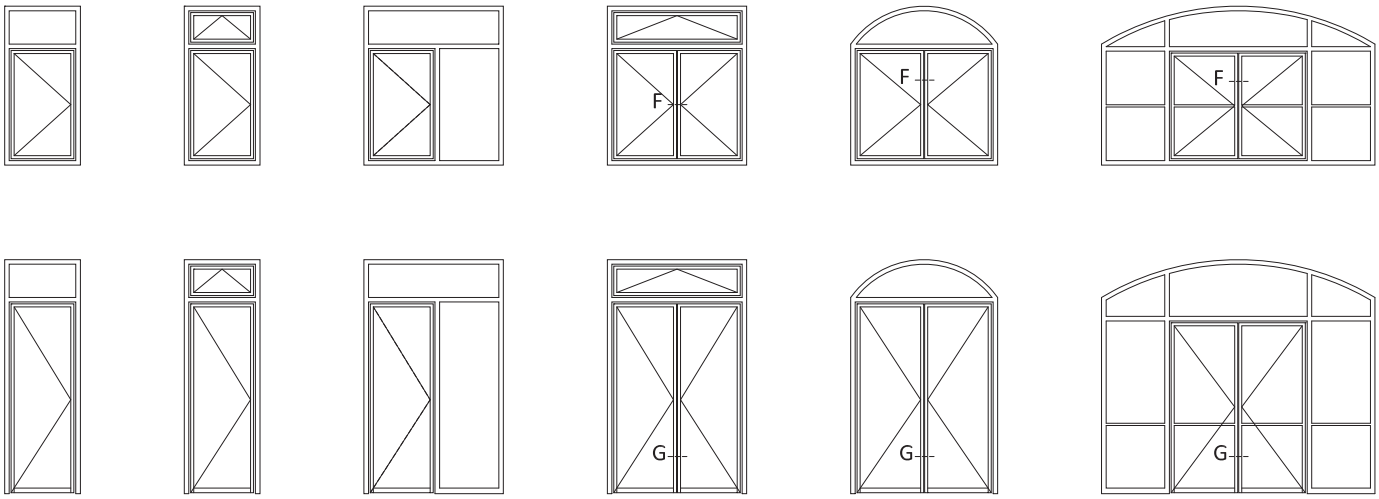
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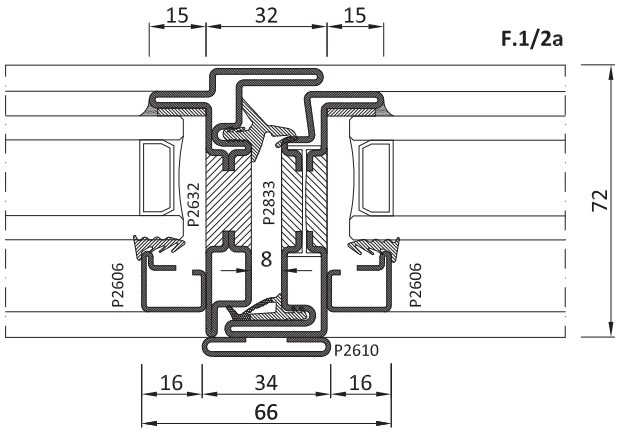
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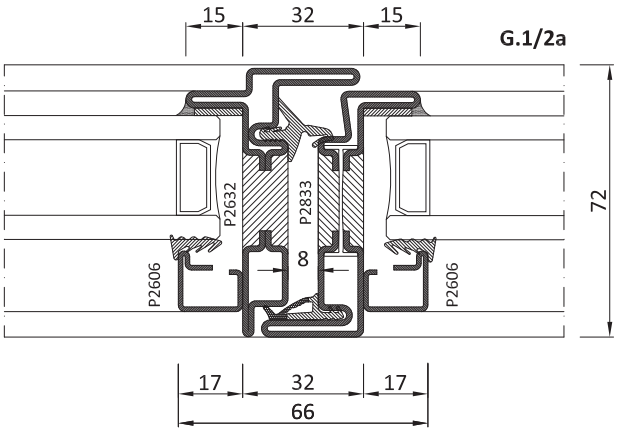
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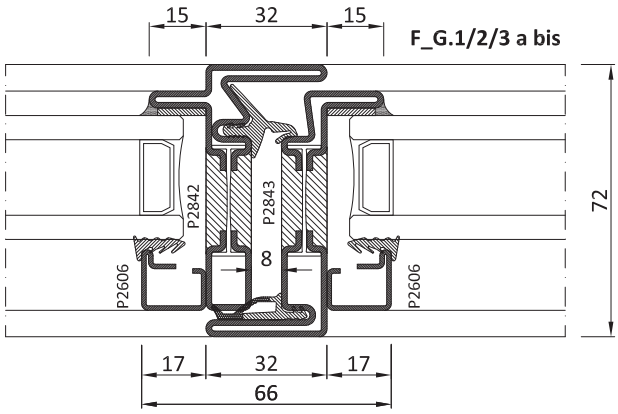
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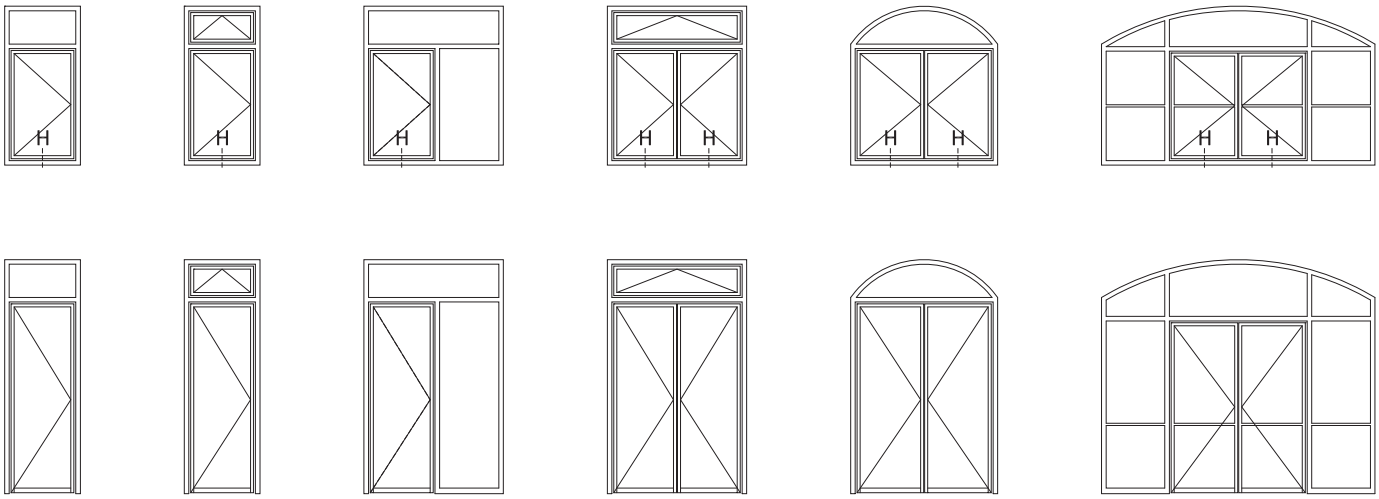

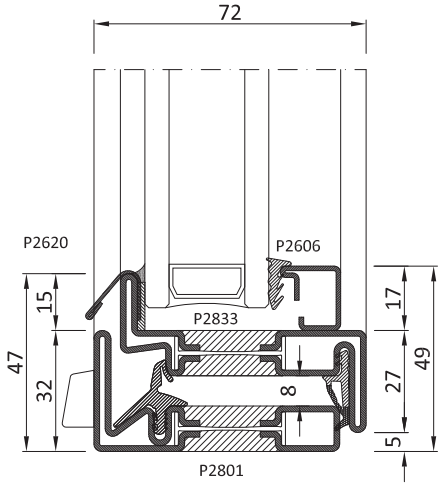

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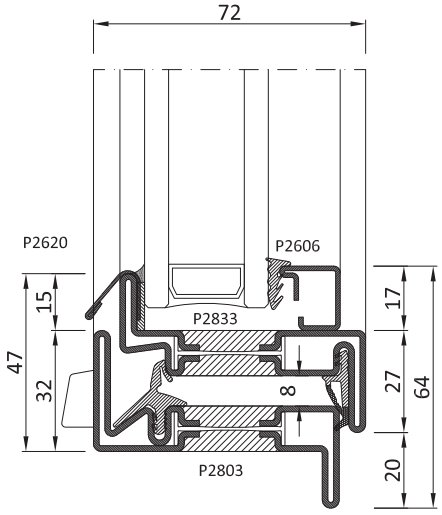
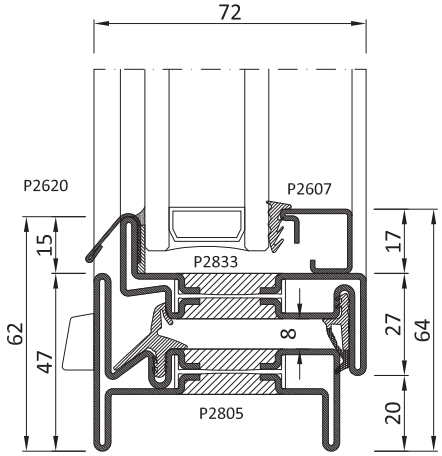


H.1/2 b



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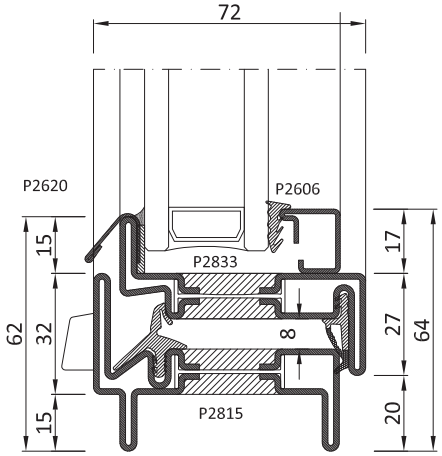

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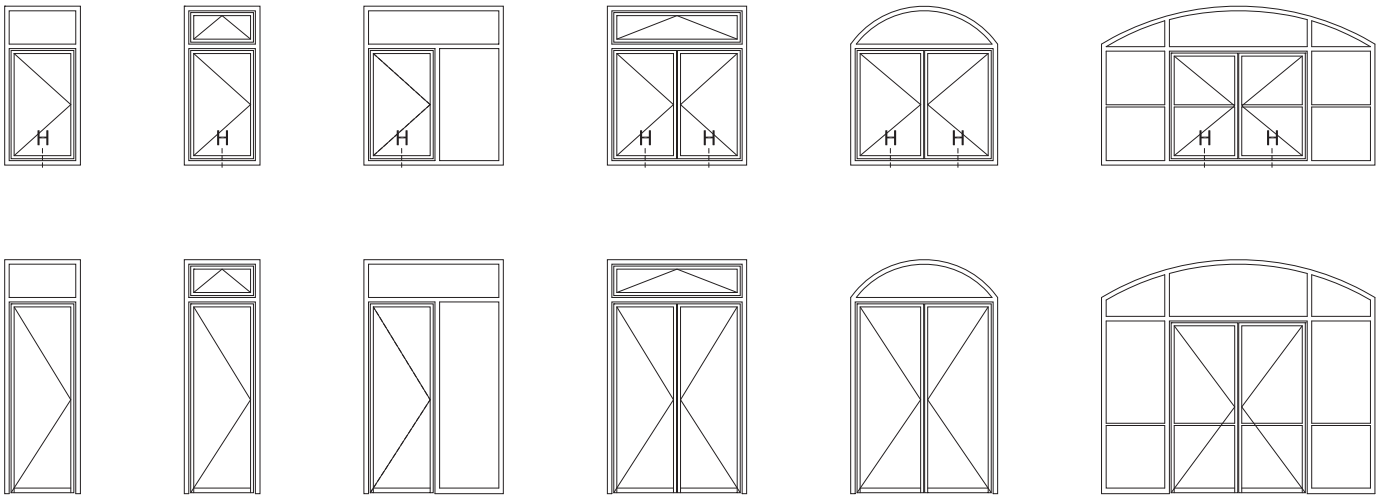
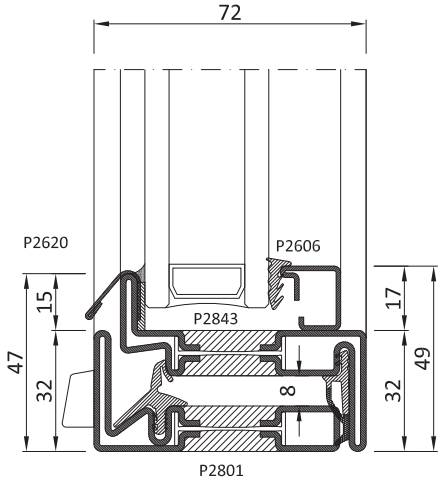
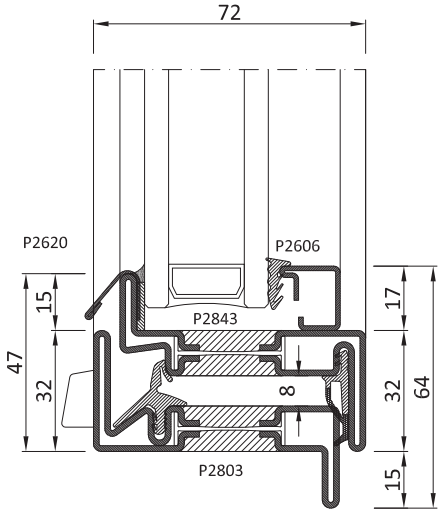
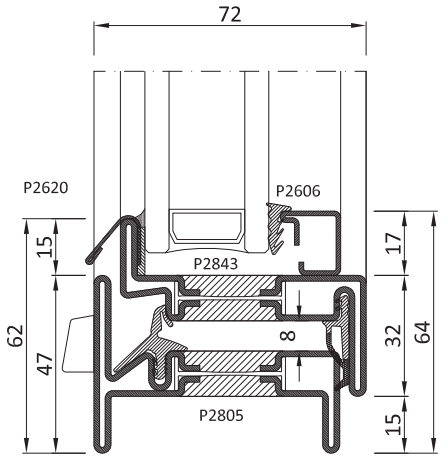




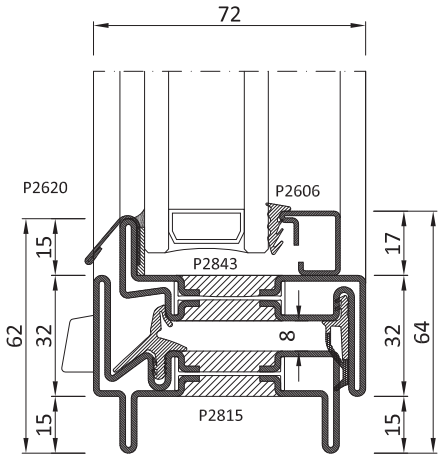
H.1/2/3 a bis



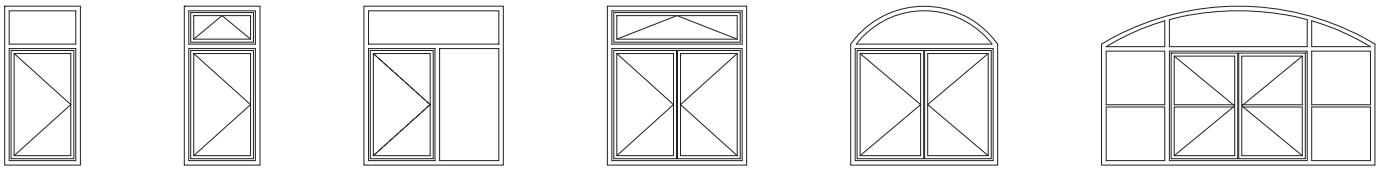
H.1/2/3 b bis

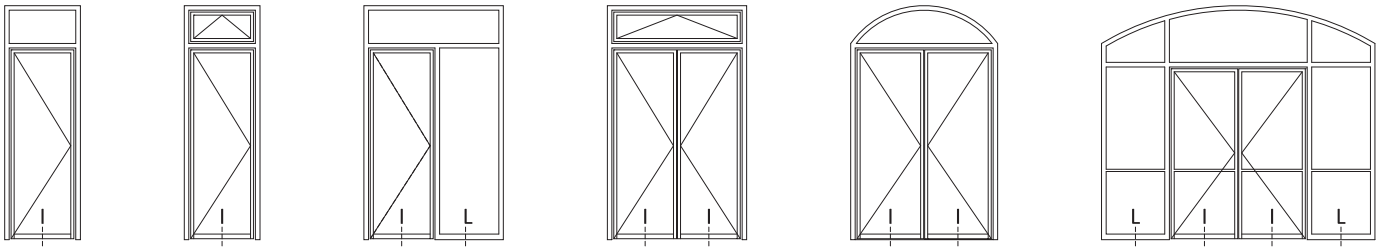


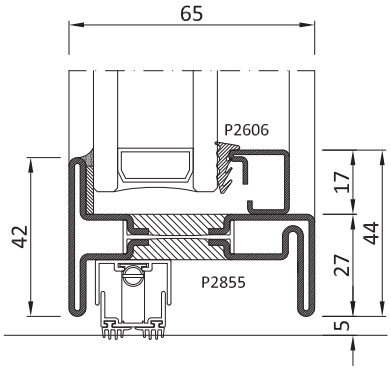
H.1 c bis



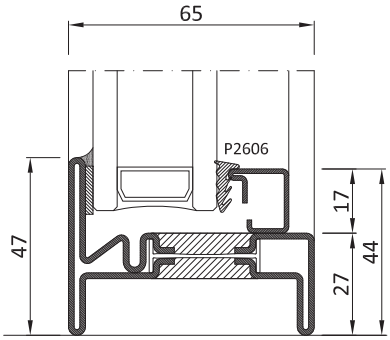
H.2/3 c bis



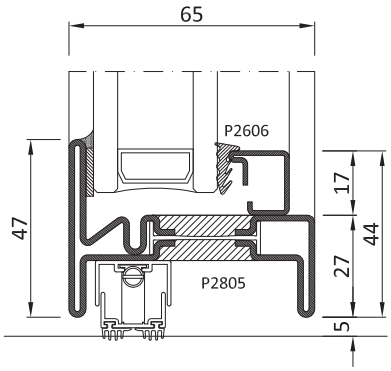




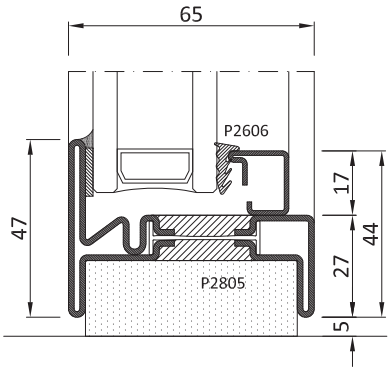
I.1a



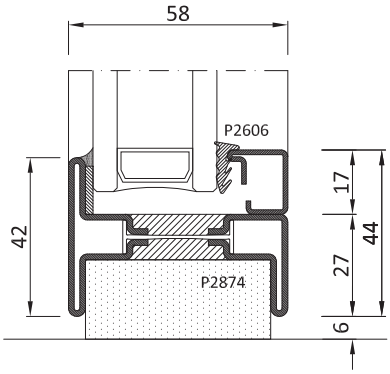
L.1a



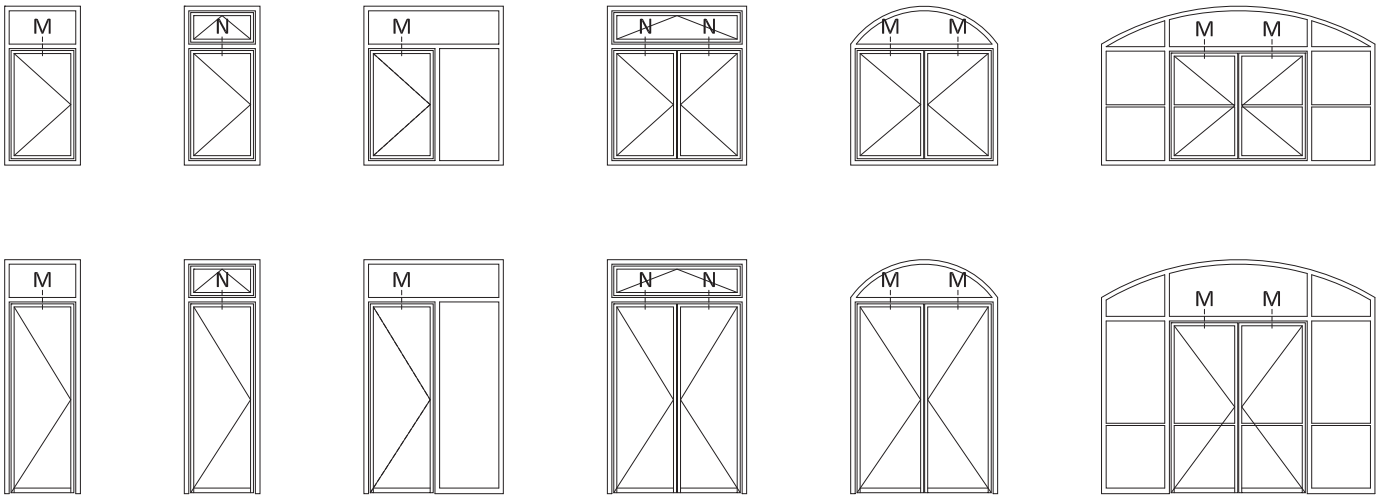
I.1a bis

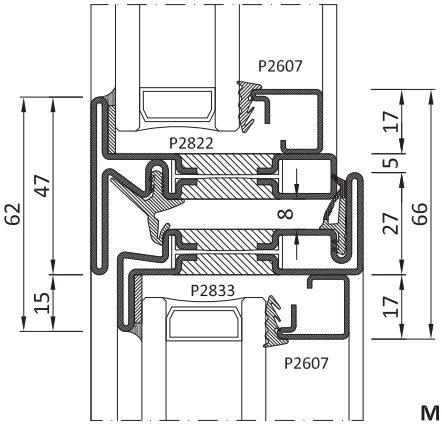


L.1a bis

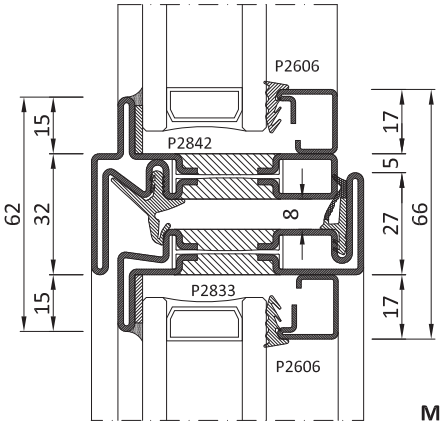


L.2/3 a

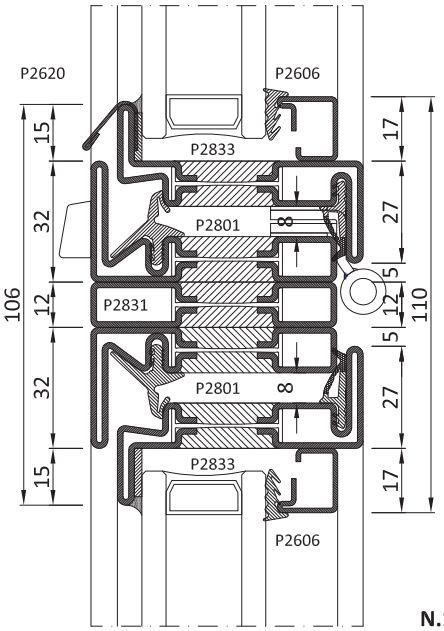




M.1 a



M.2 b



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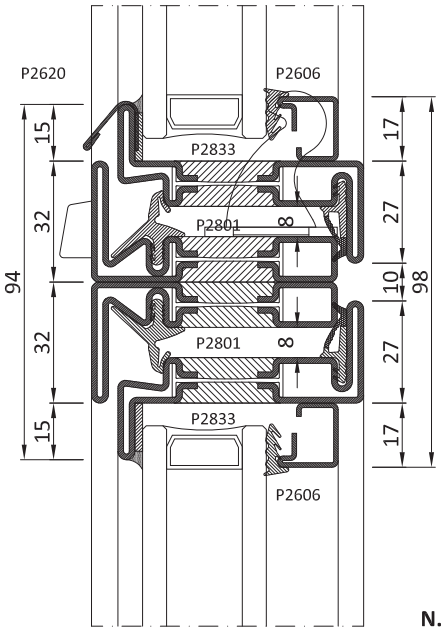

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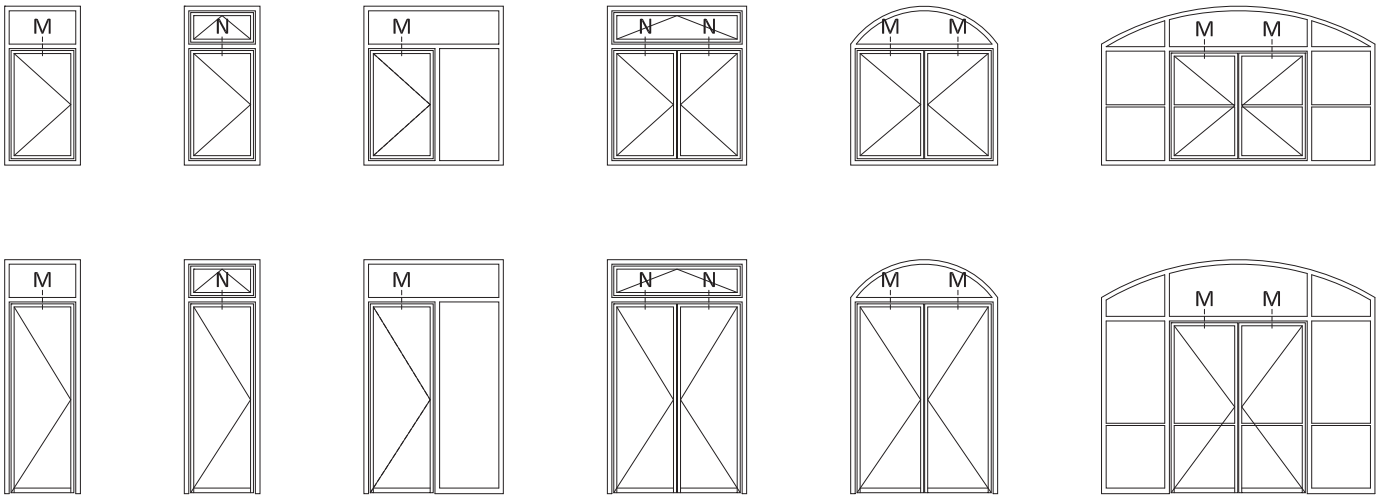
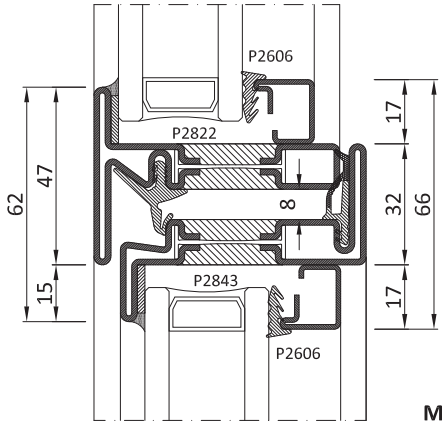
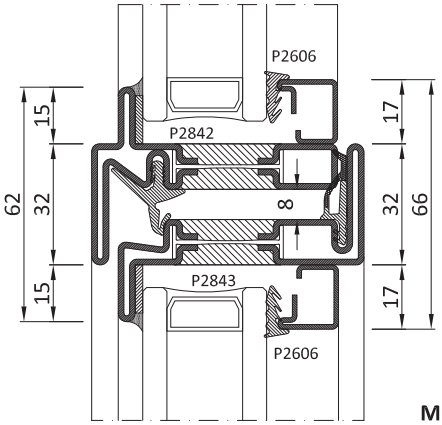




M.1 a bis



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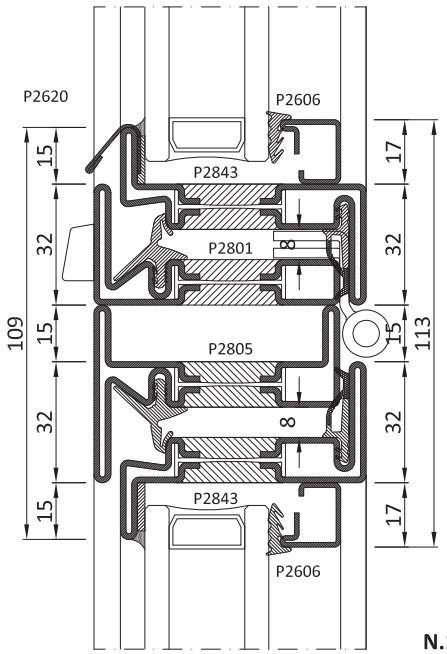

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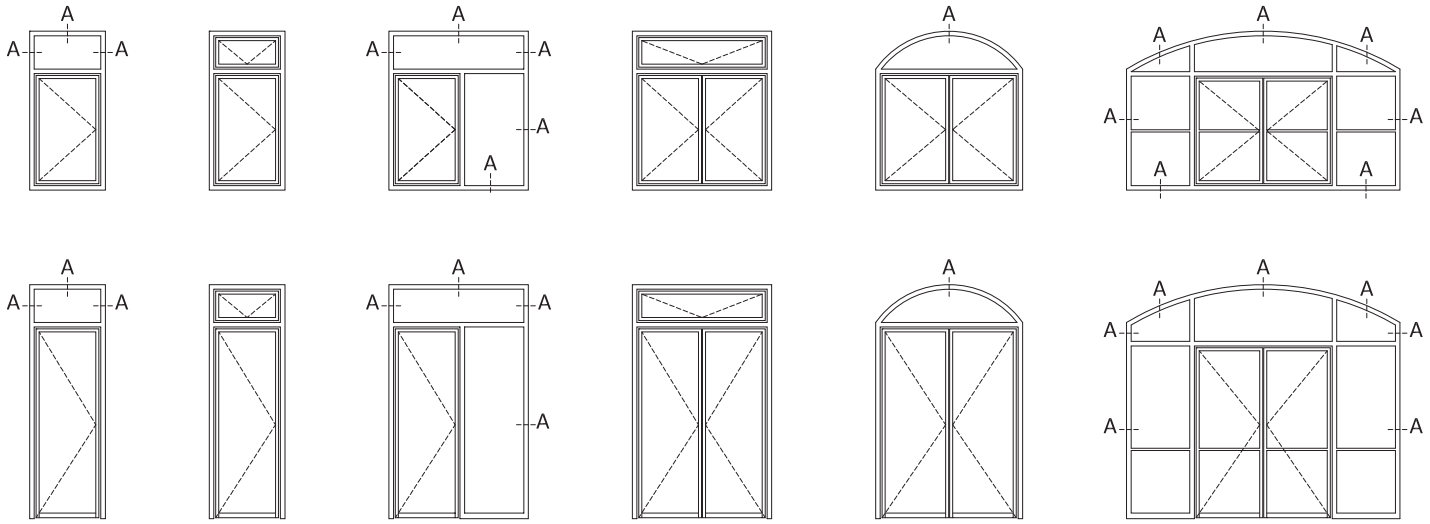
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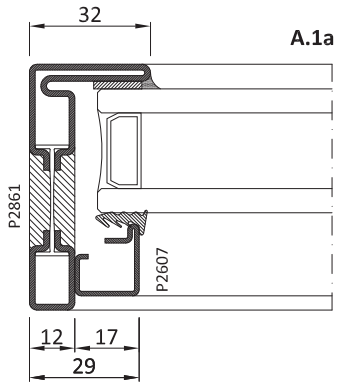
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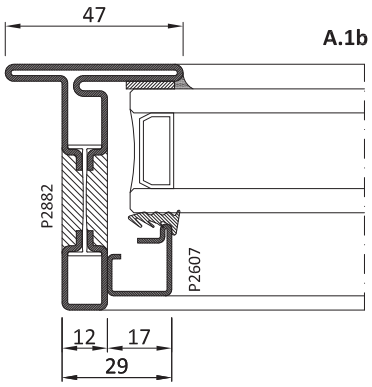
A.1b
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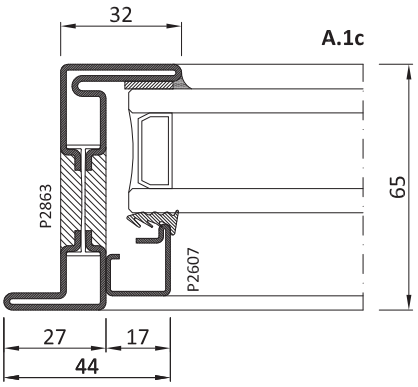
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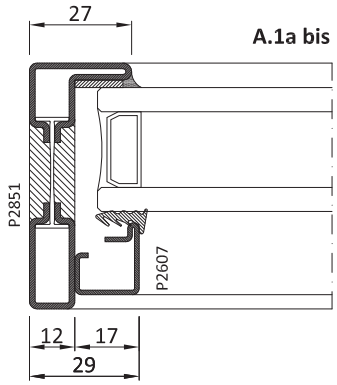
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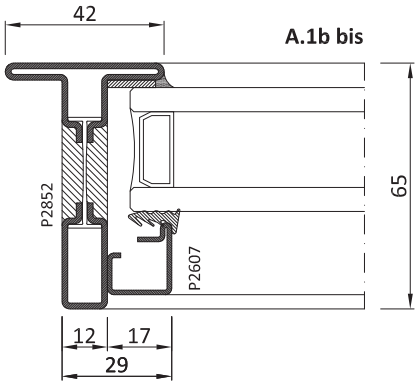
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P2607
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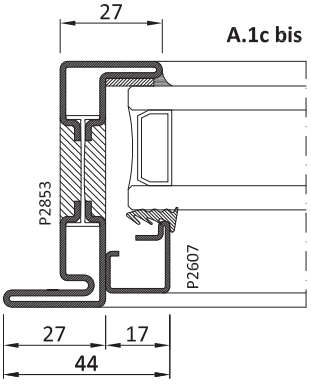
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P2853
P2607
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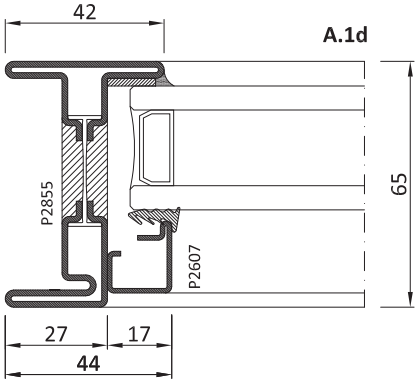
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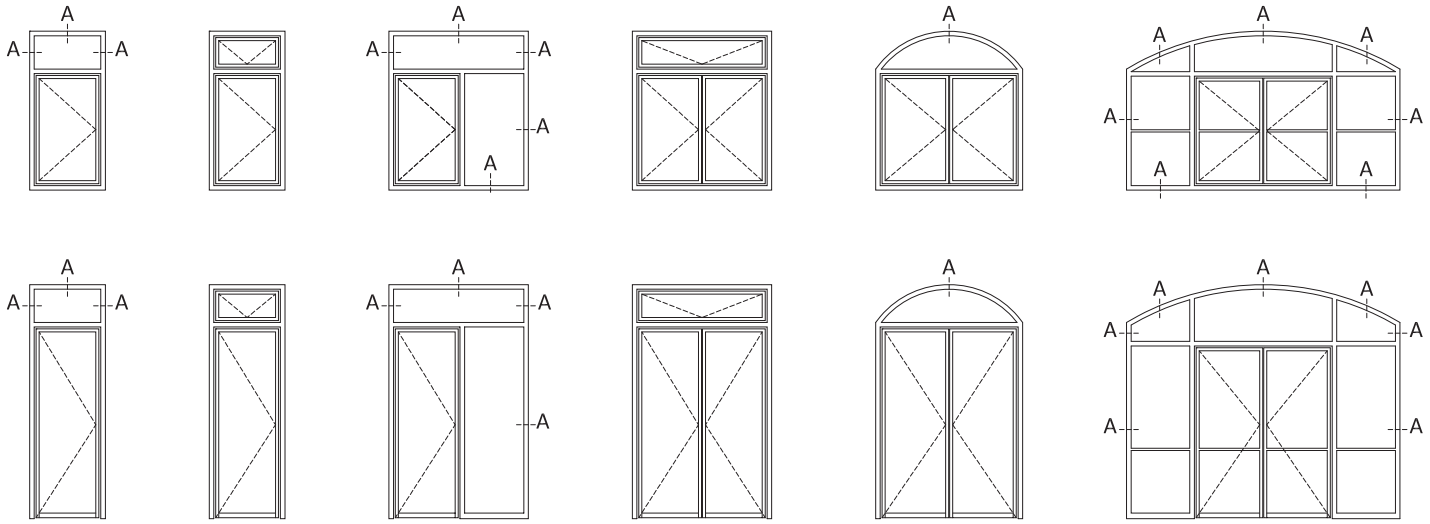
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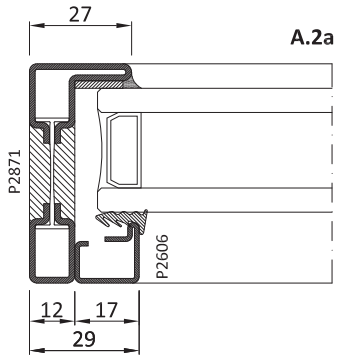
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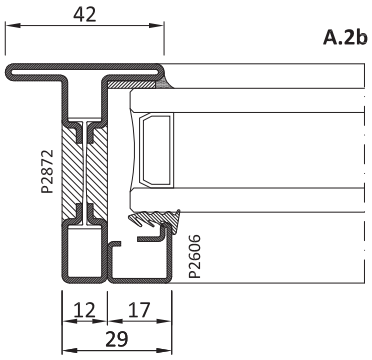
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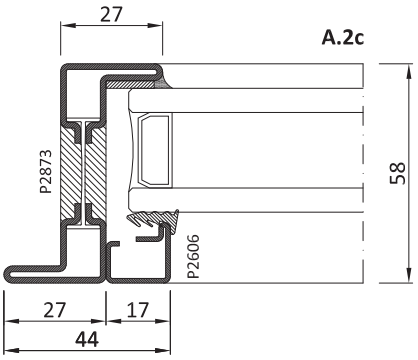
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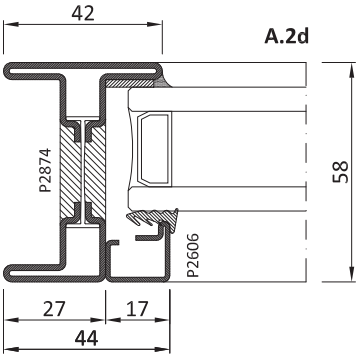
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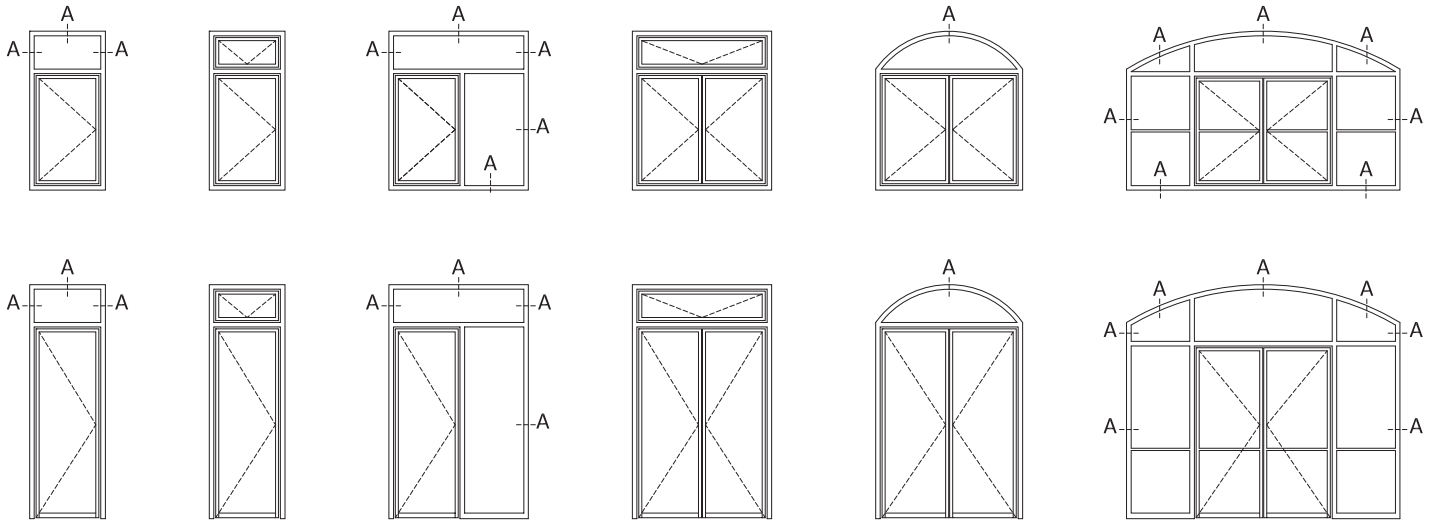
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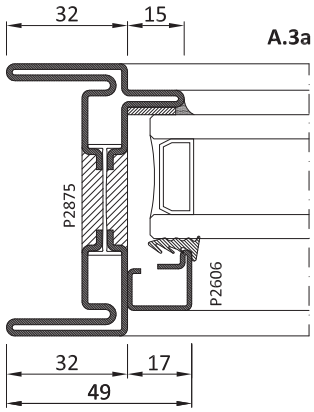
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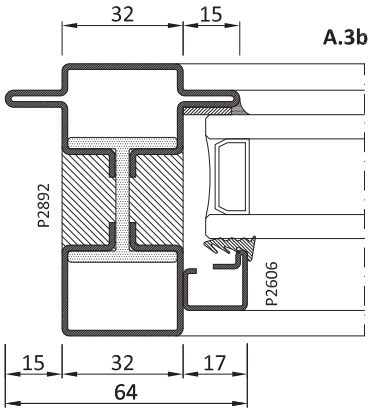
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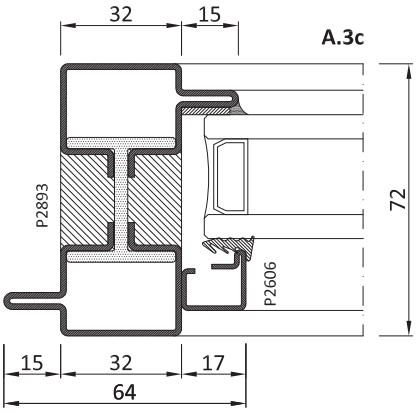
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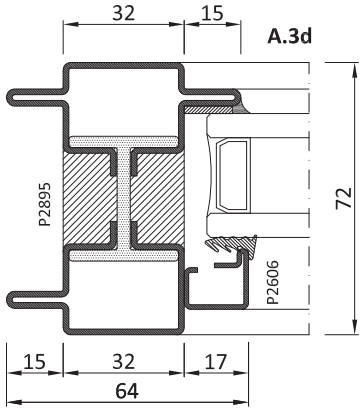
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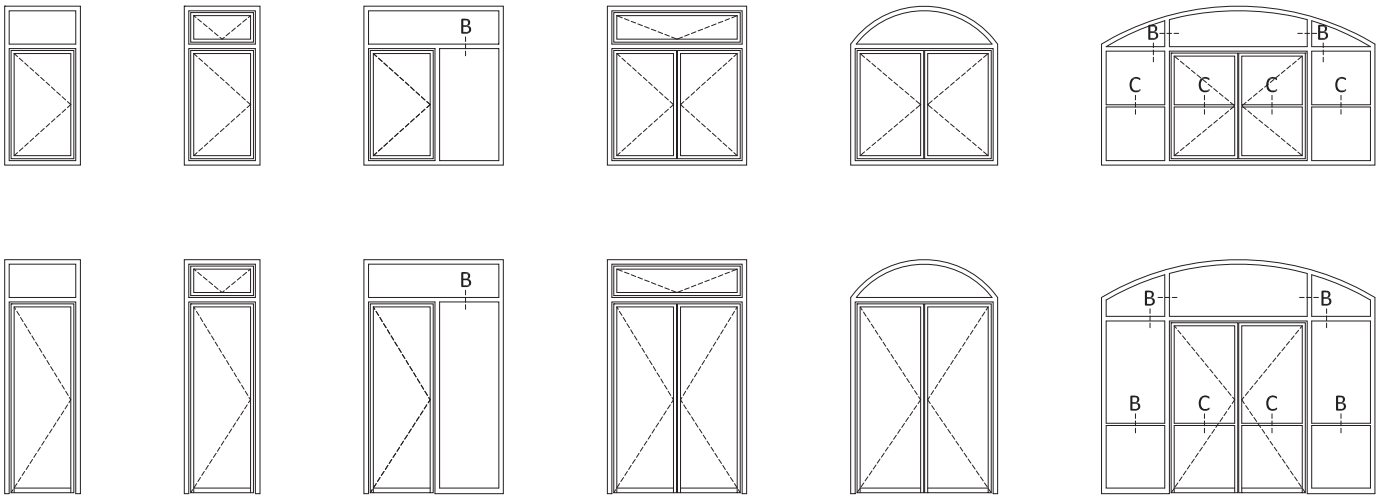
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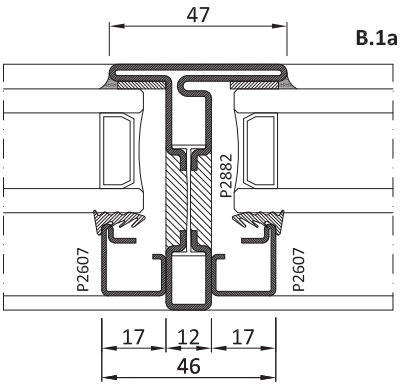
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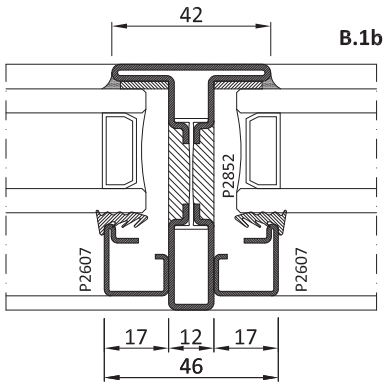
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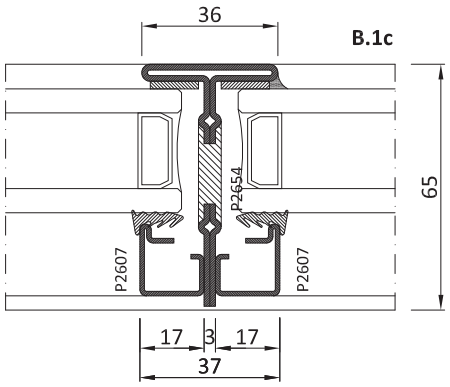
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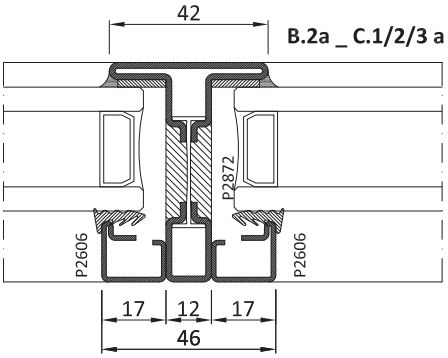
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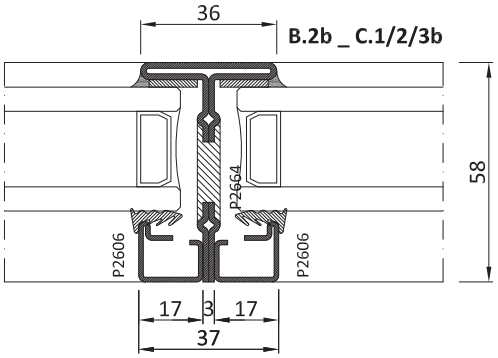
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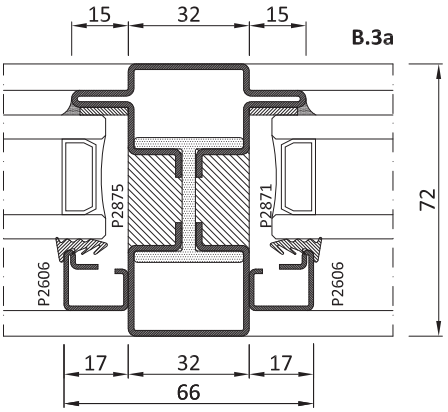
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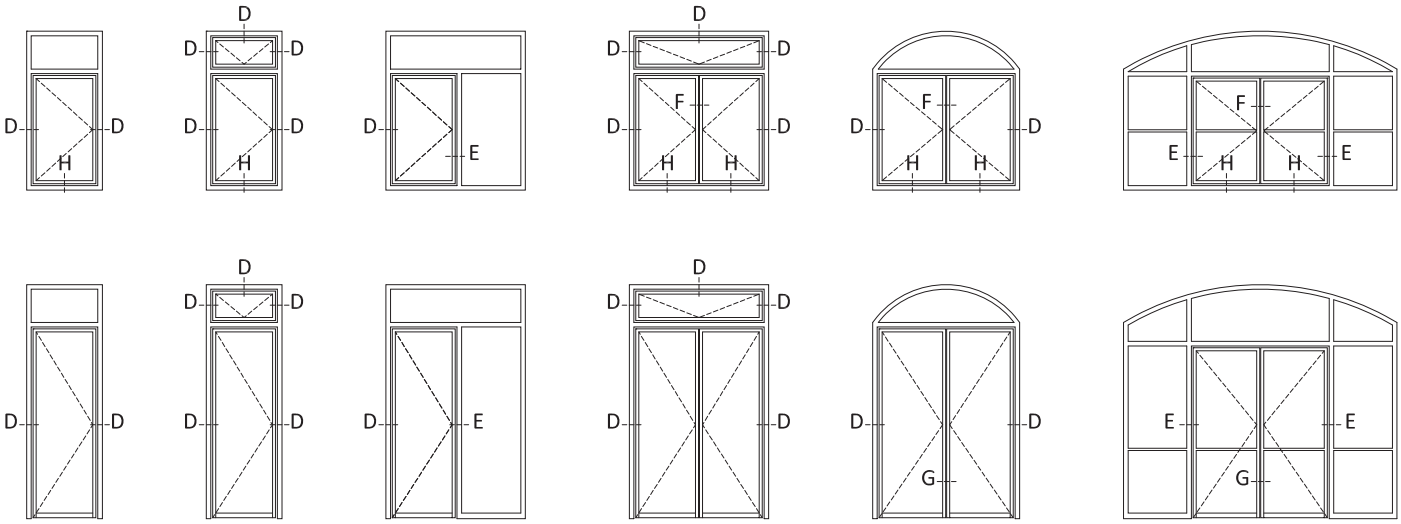
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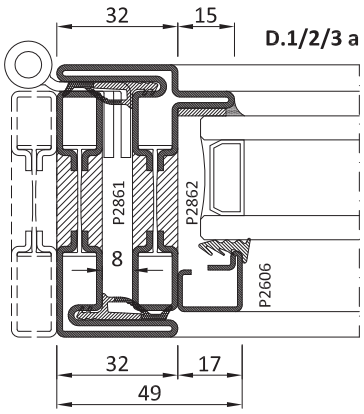
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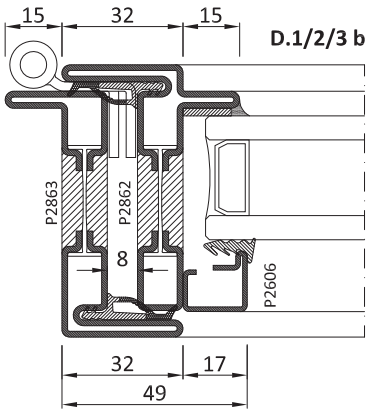
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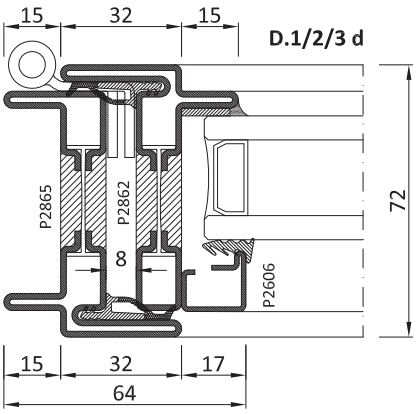
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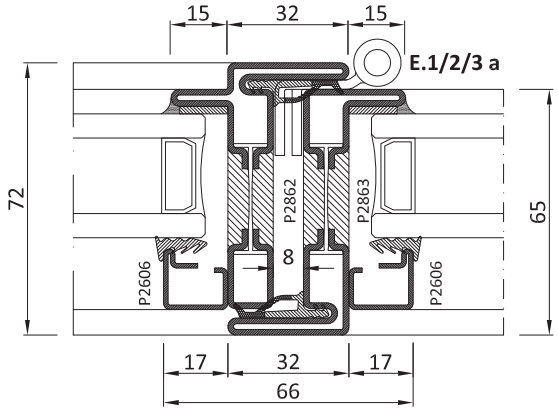
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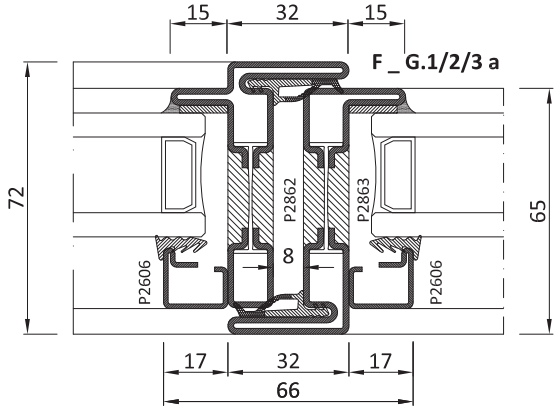
F _ G.1/2/3 a
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P2862
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P2606
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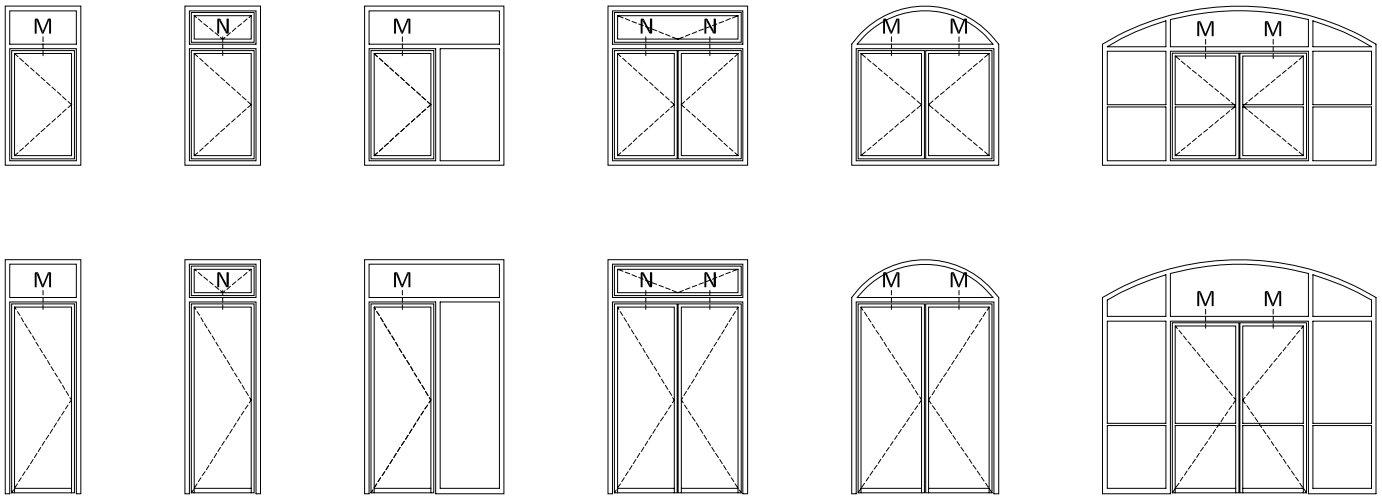

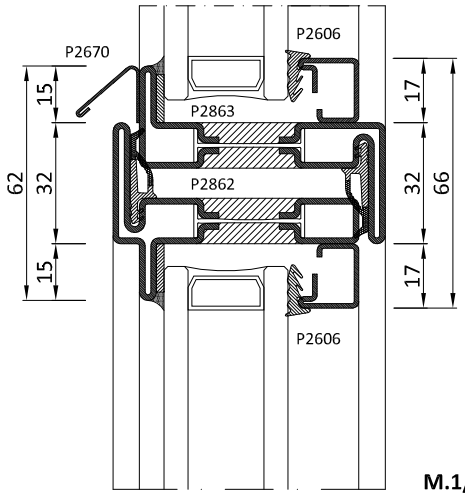

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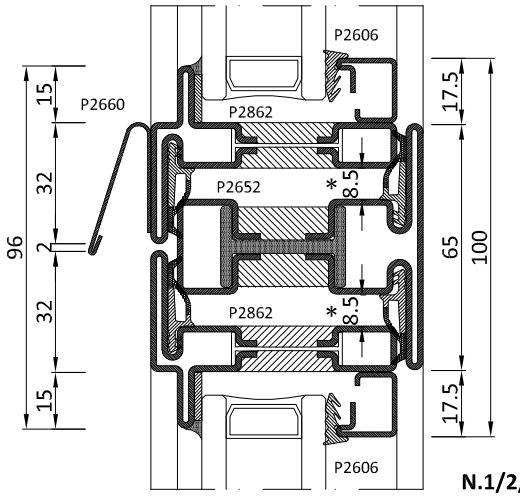
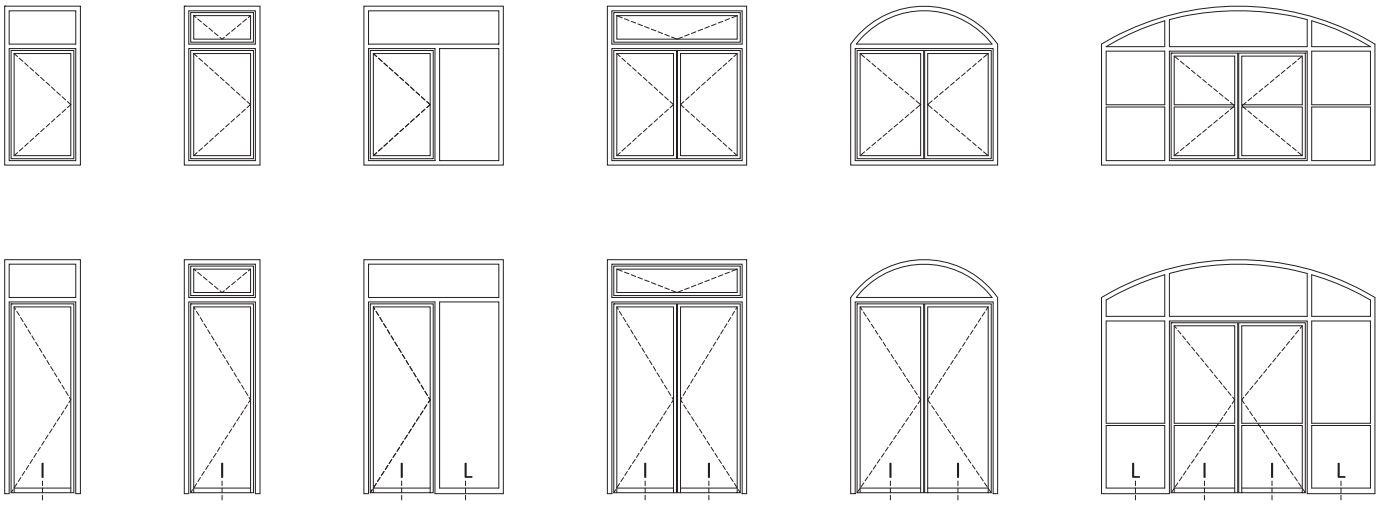
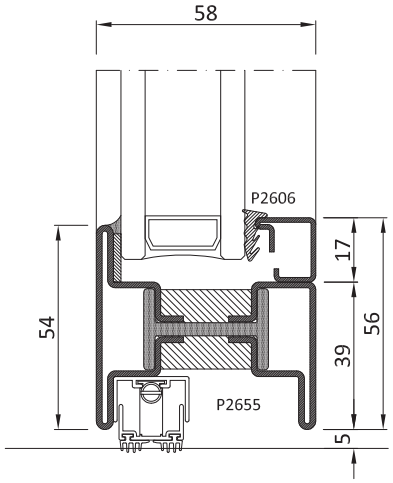


N.1/2/3 a

*** Attenzione aria mm. 8.5**
** Gap to be of mm. 8.5*





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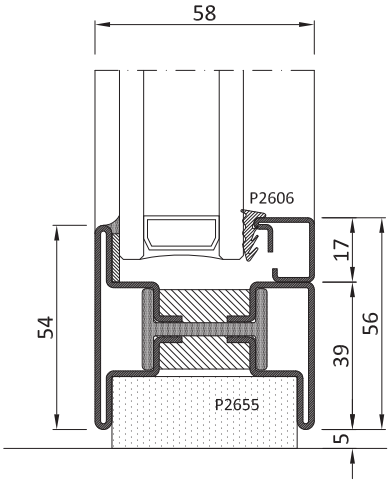

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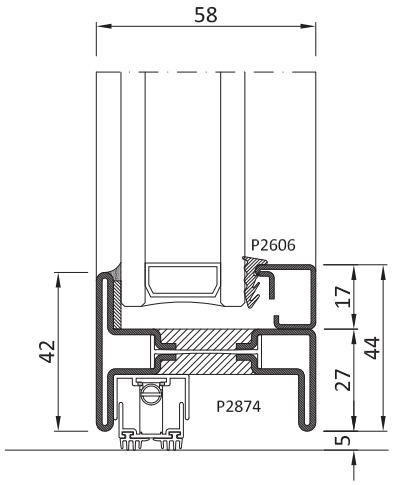

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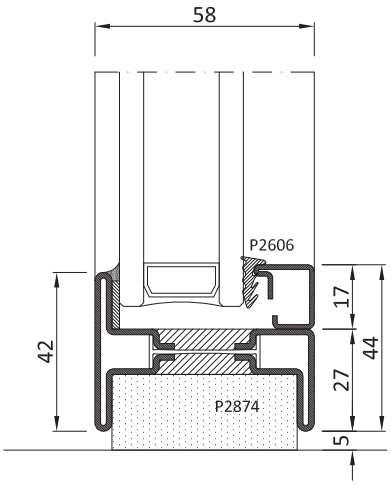

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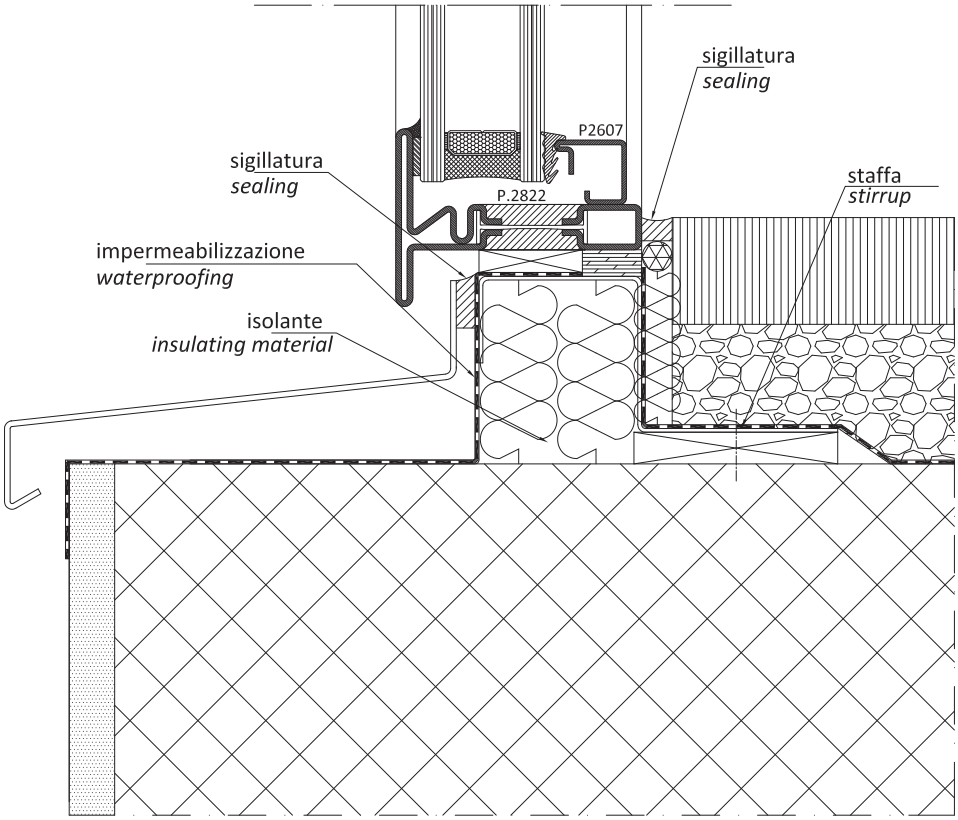
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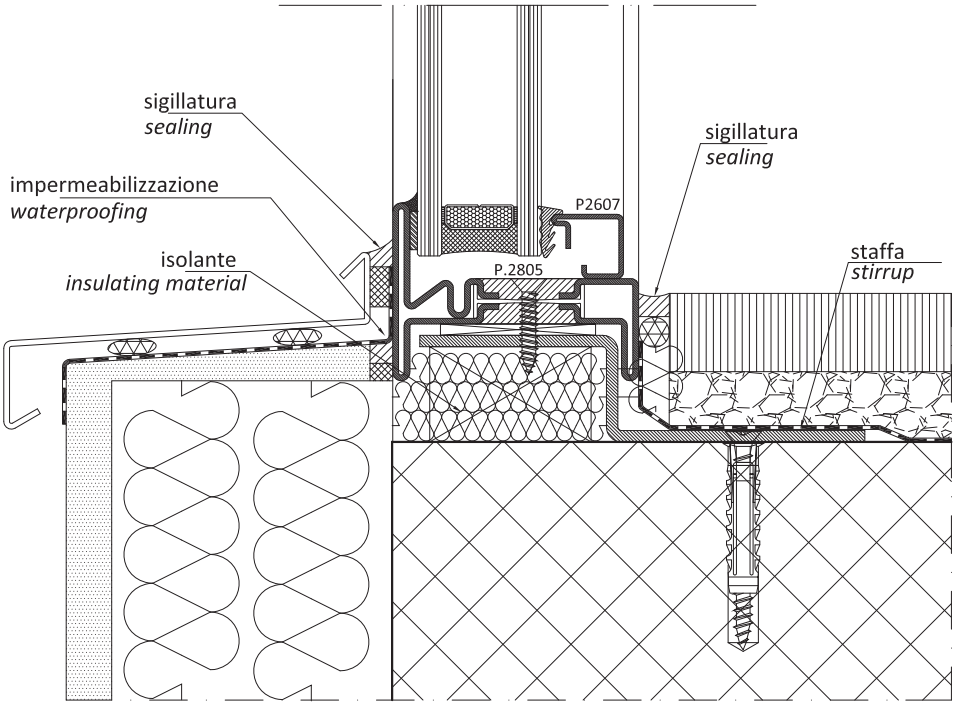
P2607
sigillatura
sealing
P.2822
staffa
stirrup
impermeabilizzazione
waterproofing
isolante
insulating material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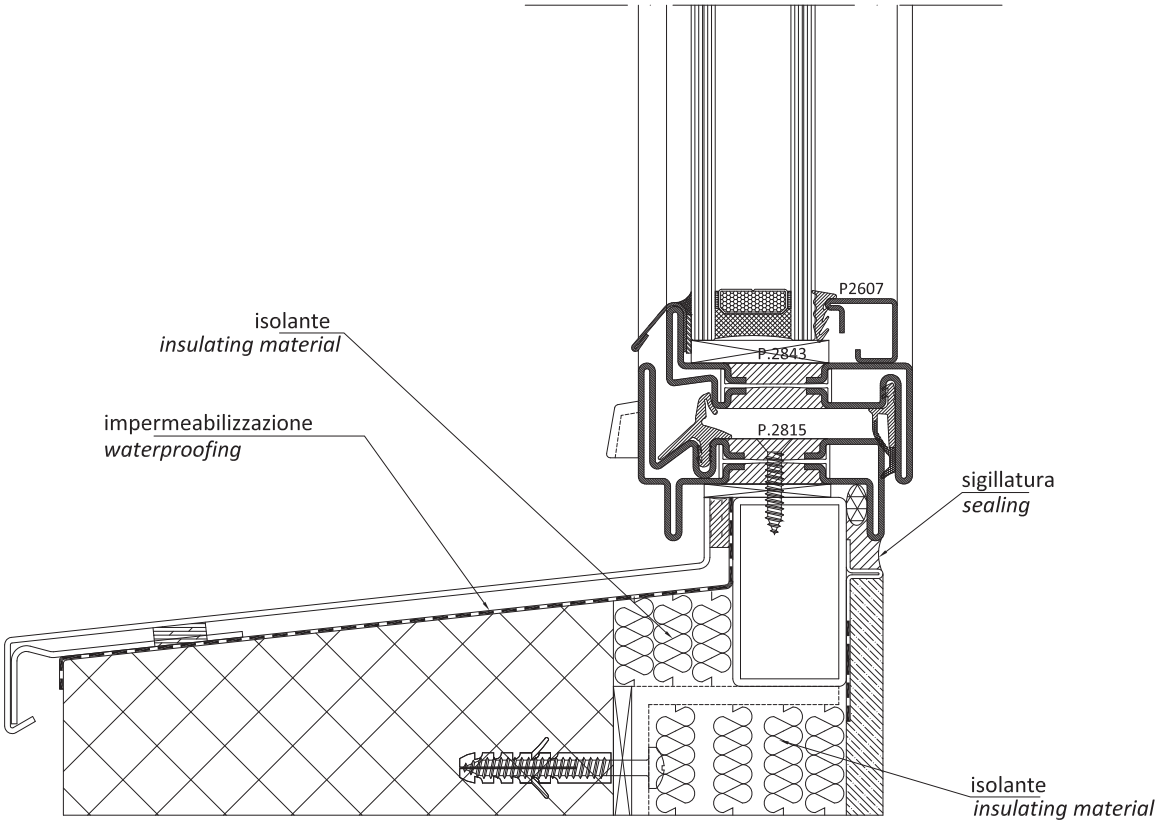
P.2805
staffa
stirrup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impermeabilizzazione
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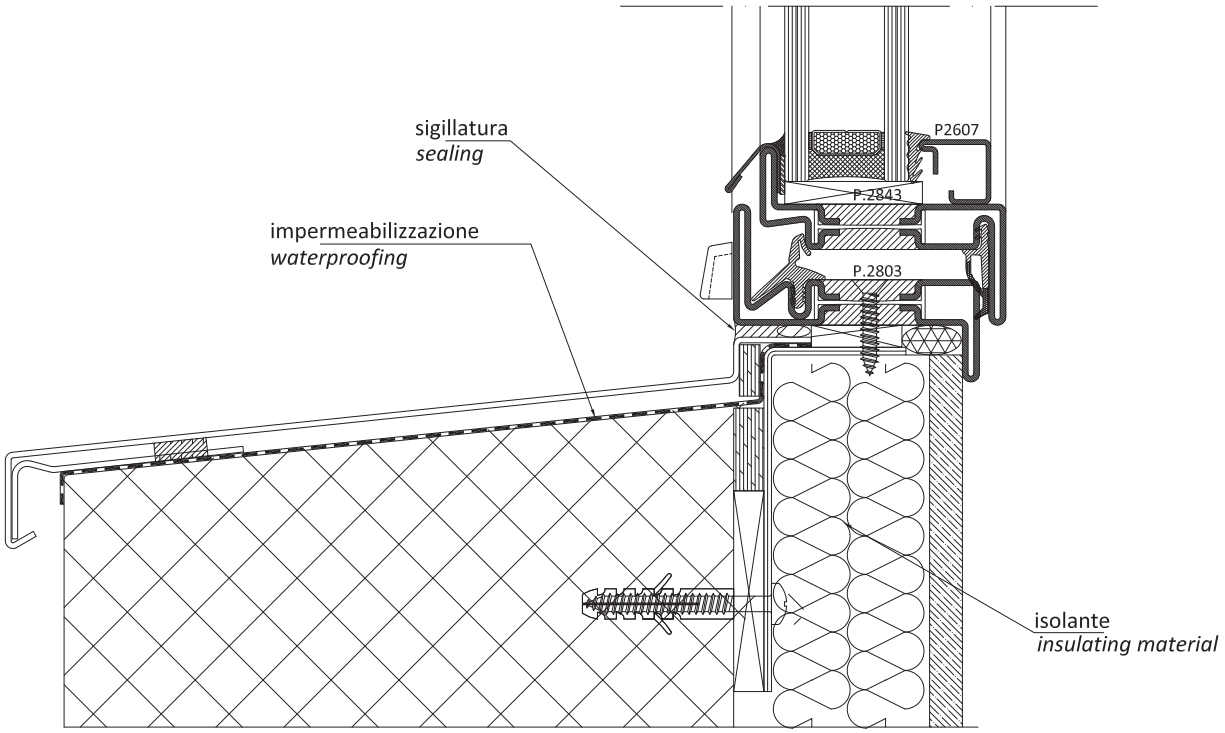
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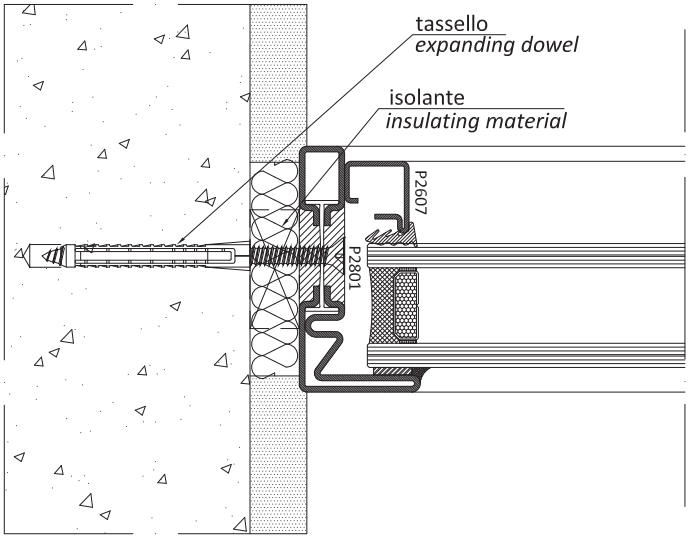
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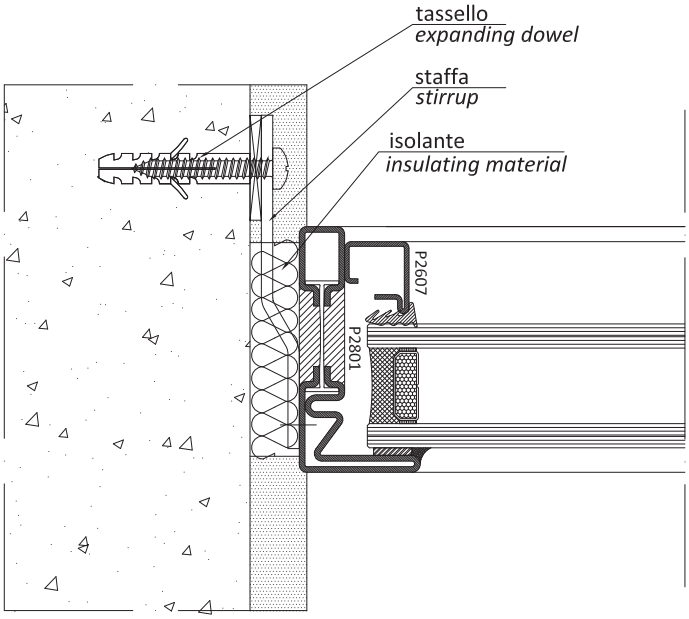
isolante
insulating material
P2607
P2801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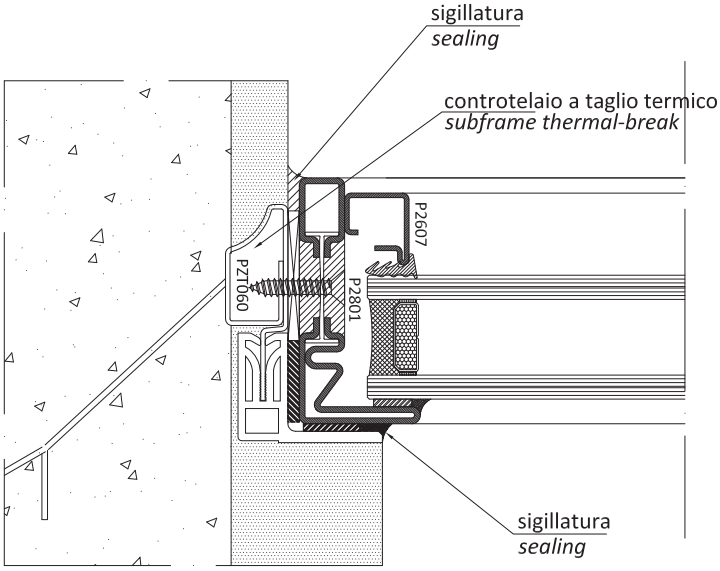
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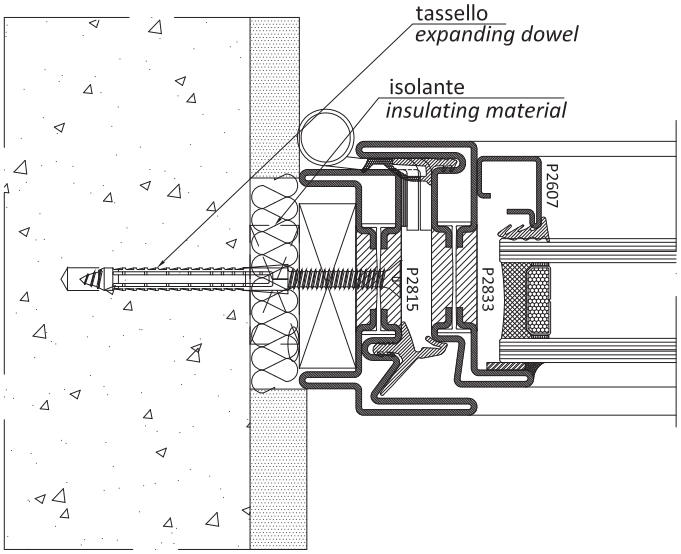
controtelaio a taglio termico
subframe thermal-break
P2607
P2801
P2T060
sigillatura
sealing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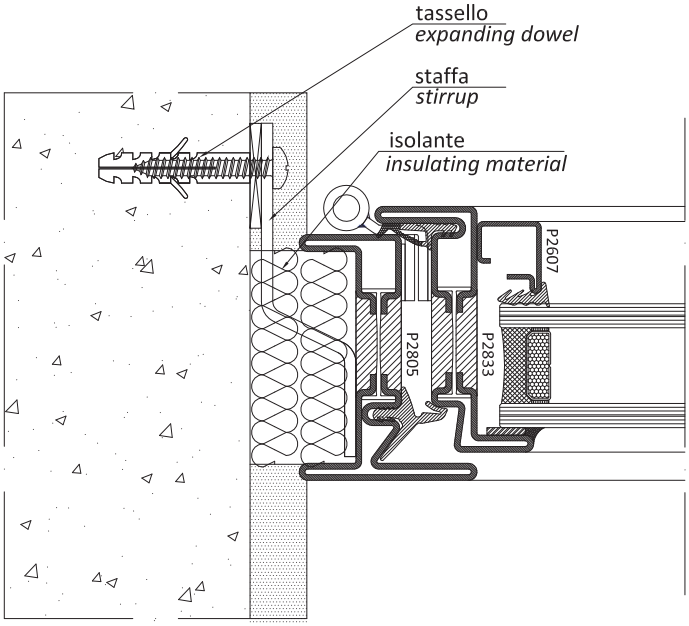
P2815
P2833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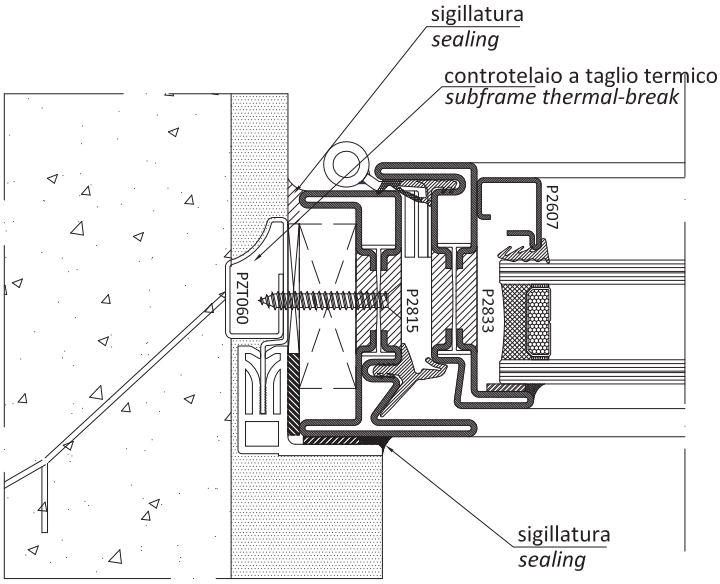
expanding dowel
staffa
stirrup
isolante
insulating material
P2607
P2805
P2833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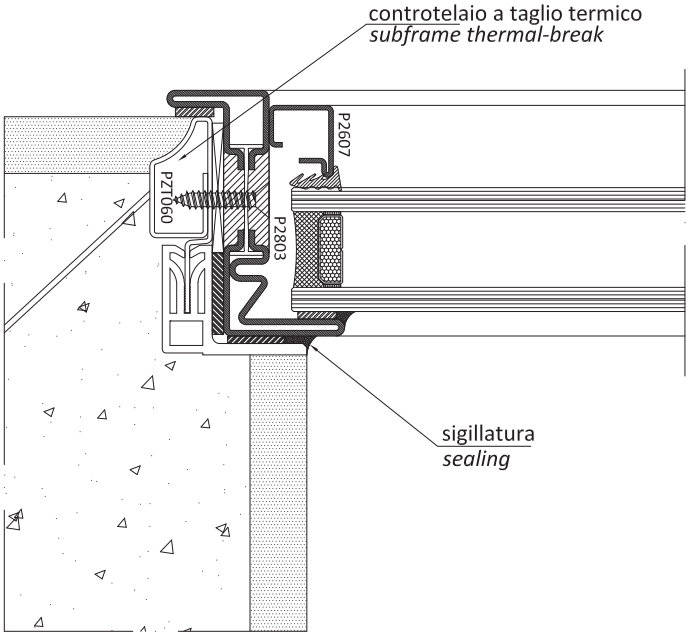
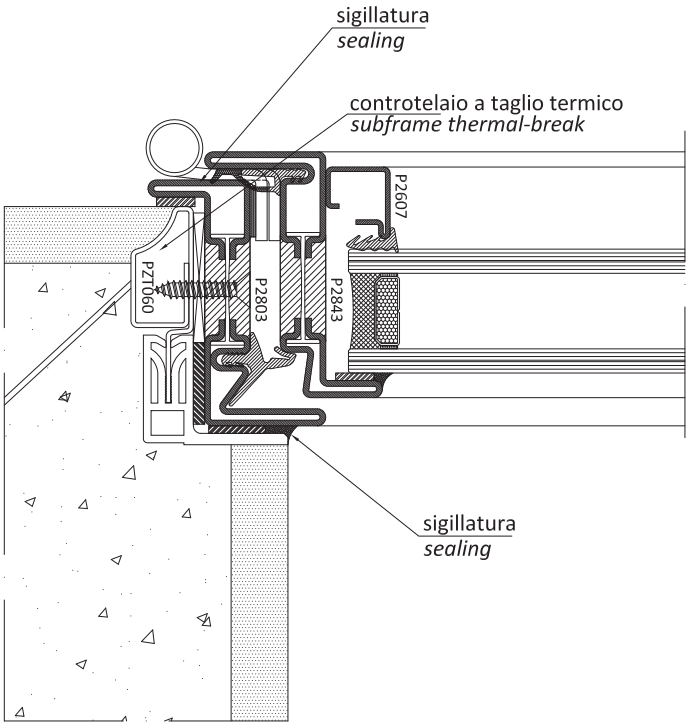
P2815
P2833
sigillatura
sealing


controtelaio a taglio termico
subframe thermal-break
P2607
PZT060
P2803
sigillatura
sealing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sealing
controtelaio a taglio termico
subframe thermal-break
P2607
PZT060
P2803
P2843
sigillatura
sealing

Lavorazioni su barra / *Section working*

Taglio / *Cut*	5.1.1 – 5.2.2
Fori per cerniere ad avvitare / *Screw-on hinges holes*	4.3.16 – 4.3.27
Fori e asole per cremonese / *Cremone bolt holes and slots*	4.3.7 – 4.3.14
Fori e asole per chiusura supplementare / *Additional locking points slots and holes*	4.3.15
Fori per scarico acqua / *Water drip holes*	4.3.5
Taglio punta per inversione battuta / *Secondary leaf top central joint working*	4.3.2 – 4.3.3
Fori inserimento rinforzi cerniere / *Hinge reinforcement holes*	4.3.1
Fresatura per catenacci 2° anta / *Secondary leaf flush bolt milling*	4.3.31
Fori limitatori apertura per apertura ad anta / *Casement restrictor stays holes*	4.3.28
Fresature per compassi e limitatori sporgere / *Stay arm and restrictor stays for awning windows milling*	4.3.29 – 4.3.30
Fori staffe per P.2610 / *P.2610 coupling brackets holes*	4.3.4
Lavorazione gocciolatoio / *Water drip section workink*	4.3.5
Fori fissaggio a muro / *Wall mounting holes*	3.3.1–3.3.5

Assiemaggio / *Assembly*

Costruzione telai / *Frame assembly*	
Saldatura / *Welding*	4.4.1
Inserimento squadrette (profili ottone) / *Brackets insertion (brass section)*	4.4.2 – 4.4.3
Sigillatura interna della giunzione (profili ottone) / *Internal joint sealing (brass sections)*	…
Applicazione accessori / *Accessories installation*	
Saldatura cerniere a saldare / *Screw-on hinges holes*	4.4.4 – 4.4.6
Fori snapper 2° anta / *Secondary leaf snapper holes*	4.5.7
Fori cerniera a scomparsa vasistas / *Concealed hinges for bottom- hung window holes*	4.5.16 – 4.5.17
Fori cricchetto e braccetti vasistas / *Finger catch and stay arms for bottom hung window holes*	4.5.18
Fori chiusure mediane a scomparsa / *Concealed hinge side middle closing holes*	4.5.15
Fori maniglia trascinamento seconda anta / *Pulling handle secondary leaf holes*	4.5.19
Fori limitatori apertura per apertura ad anta / *Restrictor stays holes*	4.3.28
Fori per compassi e limitatori sporgere / *Stay arm and restrictor stays for awning windows holes*	4.3.29– 30

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

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

Montaggio accessori / *Accessories installation*

Applicazione e sigillatura guarnizioni giunto aperto / *Sealing of central gasket*	4.5.1
Applicazione scarichi acqua / *Water drip installation*	4.5.1
Montaggio cerniere / compassi / vasistas etc. / *Hinges and arms installation (side hung, bottom-hung, awning)*	4.5.15 – 4.5.20
Montaggio cremonese e incontri / *Cremone bolt installion*	4.5.2 – 4.5.14
Montaggio guarnizioni di battuta / *Gasket installation*	…
Sigillatura angolo nel TT / *Corner joint sealing*	4.5.1

Vetrazione / *Glazing*

Applicazione clips fermavetro / G*lazing bead clips installation*	2.8.1– 2.8.6
Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)*	4.6.1

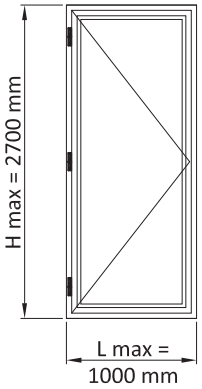
Lavorazioni su barra / ***Bar workings***	
Taglio / *Cut*	5.1.1 – 5.2.2
Fori per cerniere ad avvitare / *Screw-on hinges holes*	4.3.16 – 4.3.27
Fori e asole per serratura e incontri / *Lock and strike slots and holes*	4.3.34 – 4.3.36
Fori e asole per chiusura supplementare / *Additional locking points slots and holes*	4.3.37 – 4.3.38
Taglio punta per inversione battuta / *Secondary leaf top central joint working*	4.3.2 – 4.3.3
Fori inserimento rinforzi cerniere / *Hinge reinforcement holes*	4.3.1
Fresatura per catenacci 2° anta / *Secondary leaf flush bolt milling*	4.3.31
Fori fissaggio a muro / *Wall mounting holes*	3.3.1–3.3.5

Assiemaggio / *Assembly*	
Costruzione telai / *Frame assembly*	
Saldatura / *Welding*	4.4.1
Inserimento squadrette (profili ottone) / *Brackets insertion (brass section)*	4.4.2 – 4.4.3
Sigillatura interna della giunzione (profili ottone) / *Internal corner joint sealing (brass sections)*	…
Applicazione accessori / *Accessories installation*	
Saldatura cerniere a saldare / *Weld-on hinges welding*	4.4.4 – 4.4.6
Lavorazione per paraspiffero automatico / *Automatic door bottom seal working*	4.3.32 – 4.3.33

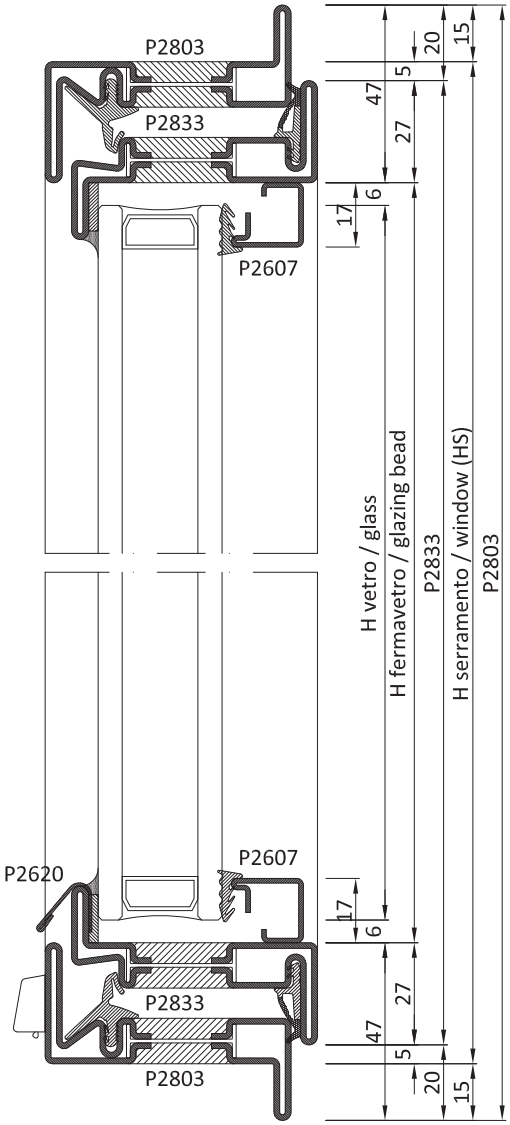
Preparazione per verniciatura e ossidazione / *Preparation for the powder coating – burnishing*	
Fori su telaio per scarichi liquidi pretrattamento / *Holes on frame for the drainage of pretreatment liquid*	5.1.4
Pulitura della superficie (ottone) / *Cleaning of the surface*	5.1.4

Montaggio accessori / *Accessories installation*	
Montaggio cerniere / *Hinges installation*	4.3.16 – 4.3.27
Montaggio serratura e incontri / *Lock and strikes installation*	4.5.21 – 4.5.24
Applicazione paraspiffero automatico / *Automatic door bottom seal installation*	4.3.32 – 4.3.33
Montaggio catenaccio / *Flush bolt installation*	4.3.21
Montaggio guarnizioni di battuta / *Gasket installation*	…
Sigillatura angolo nel TT / *Corner joint sealing*	4.5.1

Vetrazione / *Glazing*	
Applicazione clips fermavetro / G*lazing bead clips installation*	2.8.1– 2.8.6
Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)*	4.6.1

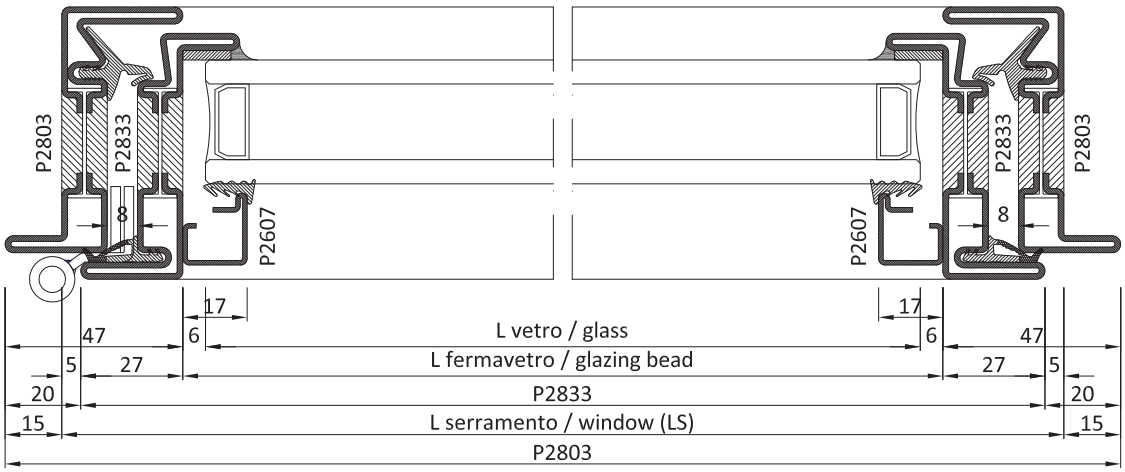


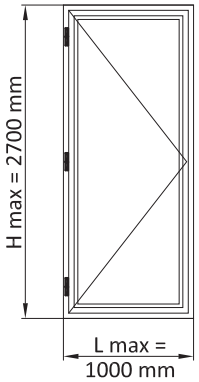
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.



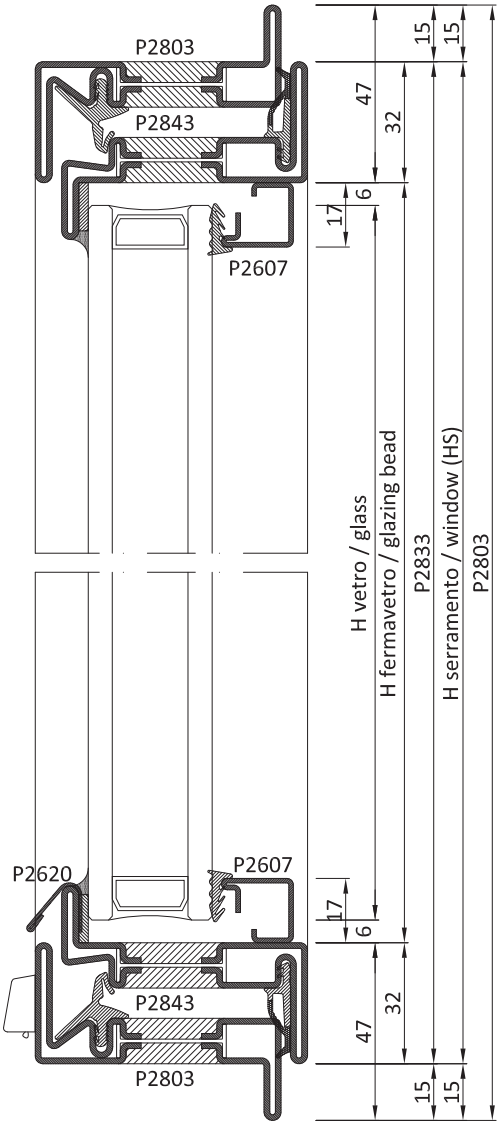
	PROFILI	***PROFILES***				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
P2803	Profilo a "Z" telaio	*"Z" profile frame*	2	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	2	HS+30	45°	45°
	Anta	***Leaf***				
P2833	Profilo a "Z" anta	*"Z" profile leaf*	2	LS-10	45°	45°
P2833	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-10	45°	45°
P2620	Profilo battiacqua	*water drip profile*	1	LS-69	90°	90°
	Fermavetri	***Glazing beads***				
P2607	Profilo fermavetro	*Glazing beads profile*	2	LS-64	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	2	HS-64	45°	45°
	Vetri	***Glass***				
	Vetro camera	*Double Glazing*	1	LS-76 x HS-76		

	ACCESSORI	***HARDWARE***		
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Setsquare kit for P2803*	4	
AC2833I	Kit squadrette per P2833	*Setsquare kit for P2833*	4	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	4	
AC2618	Scarico acqua	*Water drip*	var.	
AC2623D/S	Kit cremonese	*Cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC2627	Chiusura mediana lato cerniere	*Hinge-side middle closing*	var.	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
	GUARNIZIONI	***WEATHER STRIP***		
GE2600TT	Guarnizione di battuta	*Internal weather strip*	1	2xLS+2HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	2xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2HS



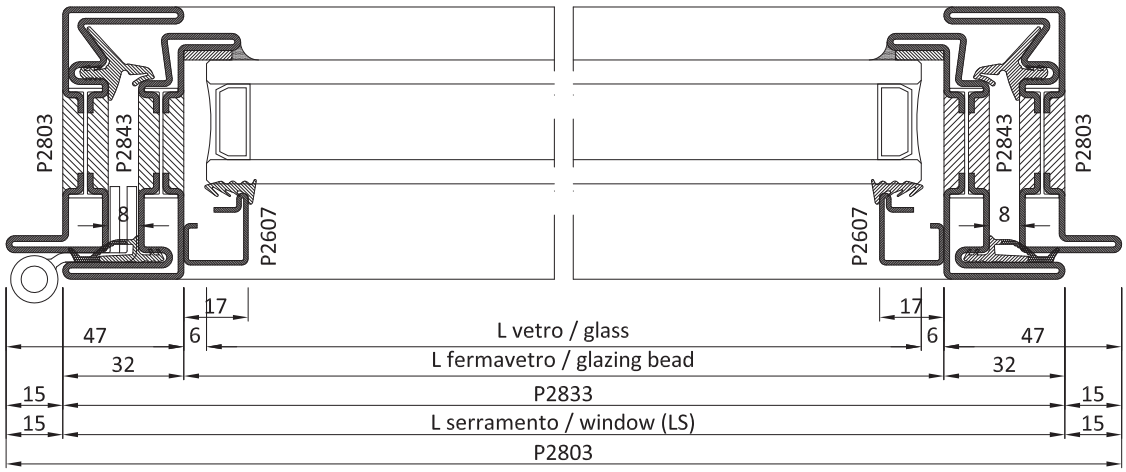


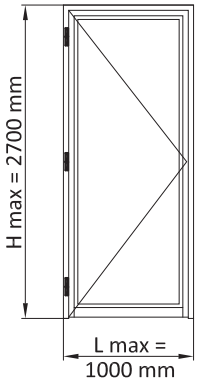
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.



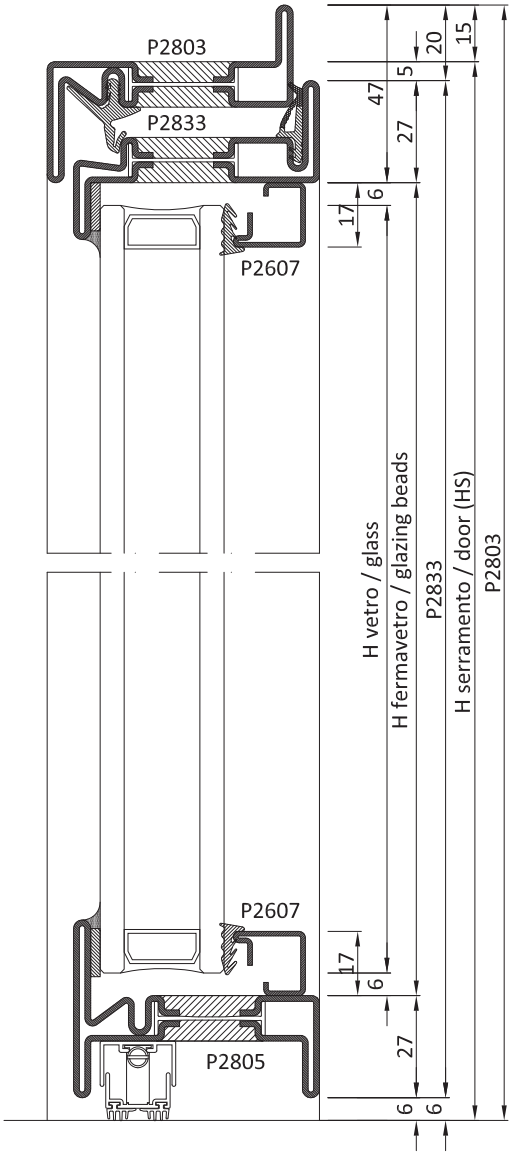
PROFILI *PROFILES*						
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.	Taglio	*Cutting*
Telaio		***Frame***				
P2803	Profilo a "Z" telaio	*"Z" profile frame*	2	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	2	HS+30	45°	45°
Anta		***Leaf***				
P2843	Profilo a "Z" anta	*"Z" profile leaf*	2	LS	45°	45°
P2843	Profilo a "Z" anta	*"Z" profile leaf*	2	HS	45°	45°
P2620	Profilo battiacqua	*water drip profile*	1	LS-69	90°	90°
Fermavetri		***Glazing beads***				
P2607	Profilo fermavetro	*Glazing beads profile*	2	LS-64	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	2	HS-64	45°	45°
Vetri		***Glass***				
	Vetro camera	*Double Glazing*	1	LS-76 x HS-76		

ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	4	
AC2843I	Kit squadrette per P2843	*Corner brackets kit for P2843*	4	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	4	
AC2618	Scarico acqua	*Water drip*	var.	
AC2625D/S	Kit cremonese	*Cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC2627	Chiusura mediana lato cerniere	*Hinge-side middle closing*	var.	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI		***WEATHER STRIP***		
GE2645TT	Guarnizione di battuta	*Internal weather strip*	1	2xLS+2HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	2xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2HS



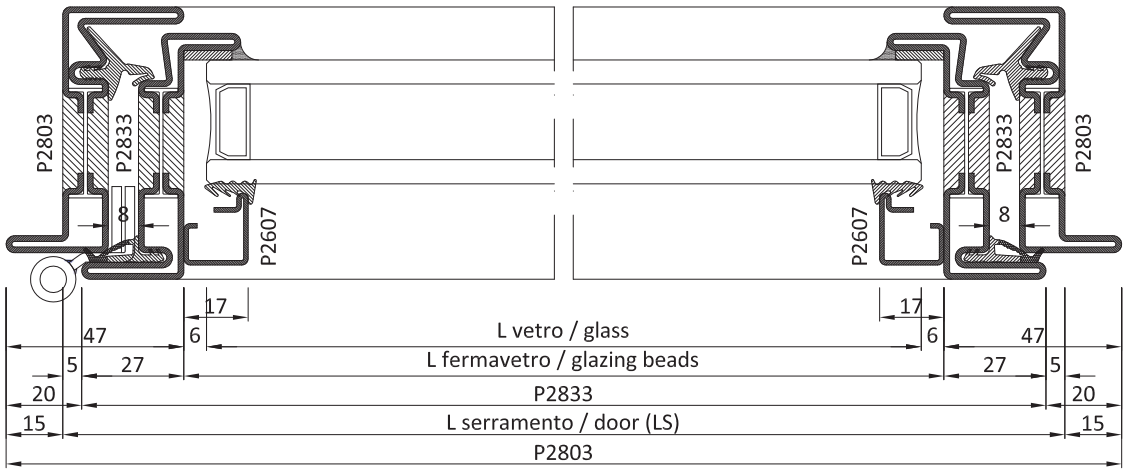


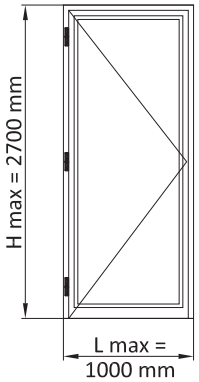
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.



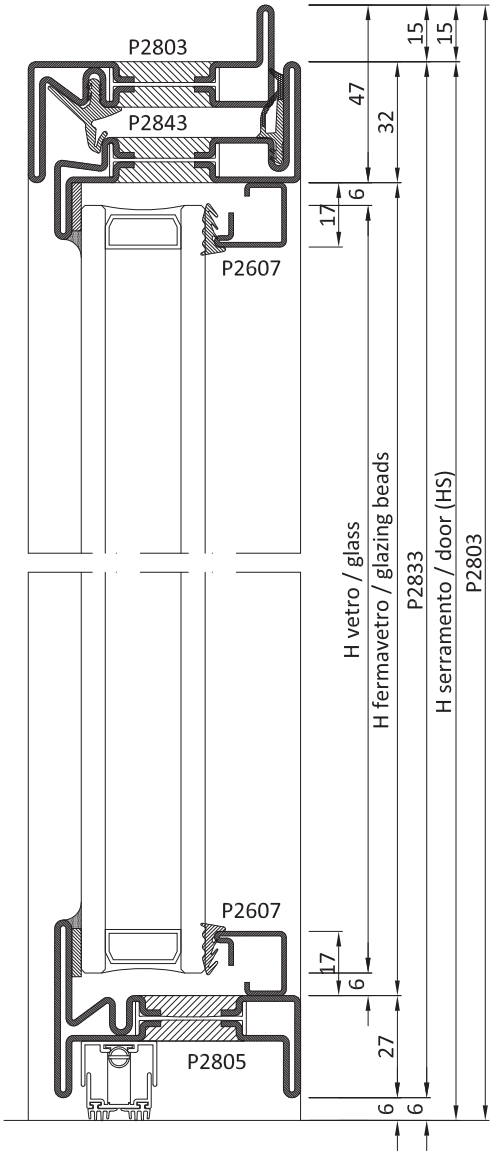
		PROFILI	***PROFILES***			
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.	Taglio	*Cutting*
		Telaio	***Frame***			
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	45°	90°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	90°	45°
		Anta	***Leaf***			
P2833	Profilo a "Z" anta	*"Z" profile leaf*	1	LS-10	45°	45°
P2833	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-11	45°	90°
P2833	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-11	90°	45°
P2805	Profilo Zoccolo	*socle profile*	1	LS-64	90°	90°
		Fermavetri	***Glazing beads***			
P2607	Profilo fermavetro	*Glazing beads profile*	2	LS-64	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	2	HS-65	45°	45°
		Vetri	***Glass***			
	Vetro camera	*Double Glazing*	1	LS-76 x HS-77		

	ACCESSORI	***HARDWARE***		
Codice *Code*	Descrizione	*Descriprion*	n°	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	2	
AC2833I	Kit squadrette per P2833	*Corner brackets kit for P2833*	2	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	2	
AC...	Serratura	*Lock*	1	
AC2695D/S	Punto di chiusura agg. (con AC2694)	*Additional closing*	opz.	
AC2696/97	Scatola copri serratura	*Lock cover box*	1	
AC2636/.	Guarnizione automatica	*Automatic underdoor seal gasket*	1	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
	GUARNIZIONI	***WEATHER STRIP***		
GE2600TT	Guarnizione di battuta	*Internal weather strip*	1	1xLS+2HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	1xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2HS



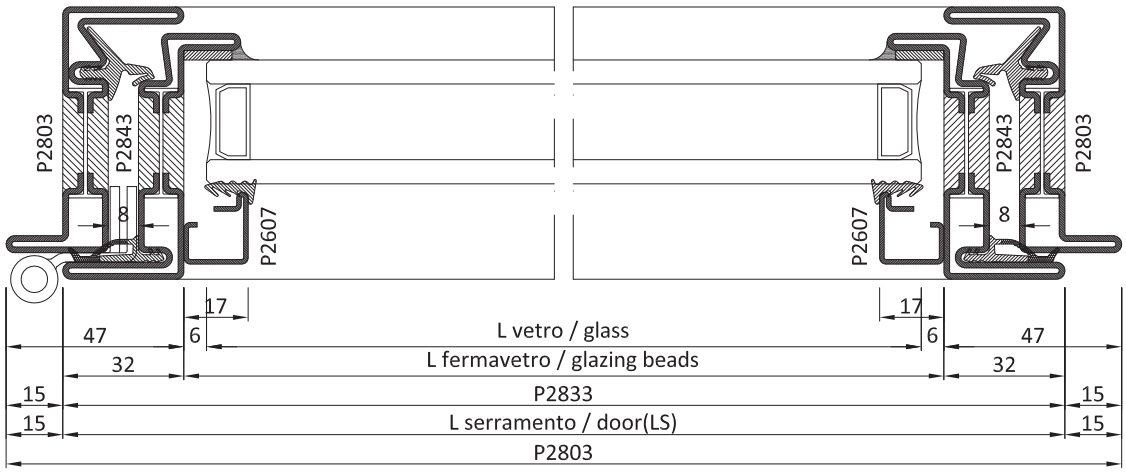


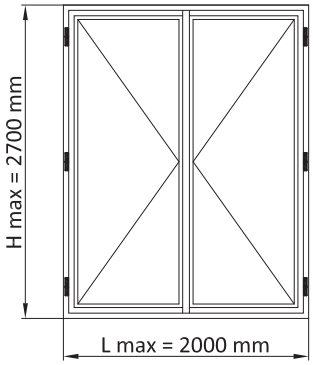
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.



		PROFILI	***PROFILES***			
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.	Taglio	*Cutting*
		Telaio	***Frame***			
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	45°	90°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	90°	45°
		Anta	***Leaf***			
P2843	Profilo a "Z" anta	*"Z" profile leaf*	1	LS	45°	45°
P2843	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-6	45°	90°
P2843	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-6	90°	45°
P2805	Profilo Zoccolo	*Socle rpofile*	1	LS-64	90°	90°
		Fermavetri	***Glazing beads***			
P2607	Profilo fermavetro	*Glazing beads profile*	2	LS-64	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	2	HS-65	45°	45°
		Vetri	***Glass***			
	Vetro camera	*Double Glazing*	1	LS-76 x HS-77		

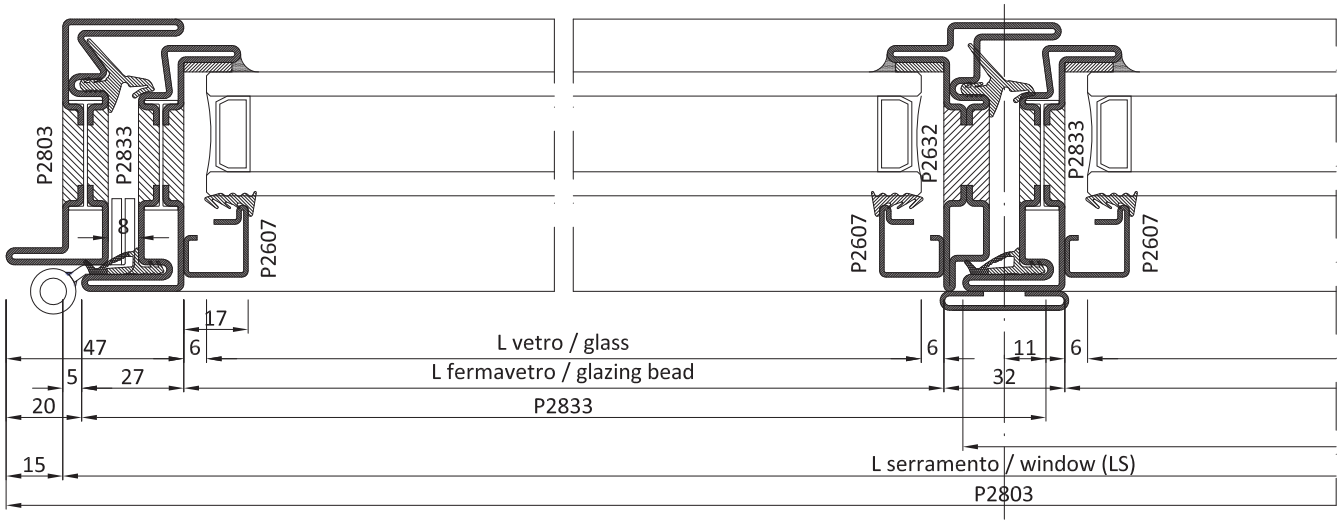
		ACCESSORI ***HARDWARE***		
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	2	
AC2843I	Kit squadrette per P2843	*Corner brackets kit for P2843*	2	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	2	
AC...	Serratura	*Serrure*	1	
AC2695D/S	Punto di chiusura agg. (con AC2694)	*Additional closing*	opz.	
AC2696/97	Scatola copri serratura	*Lock cover box*	1	
AC2636/.	Guarnizione automatica	*Automatic underdoor seal gasket*	1	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
		GUARNIZIONI ***WEATHER STRIP***		
GE2645TT	Guarnizione di battuta	*Internal weather strip*	1	1xLS+2HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	1xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2HS

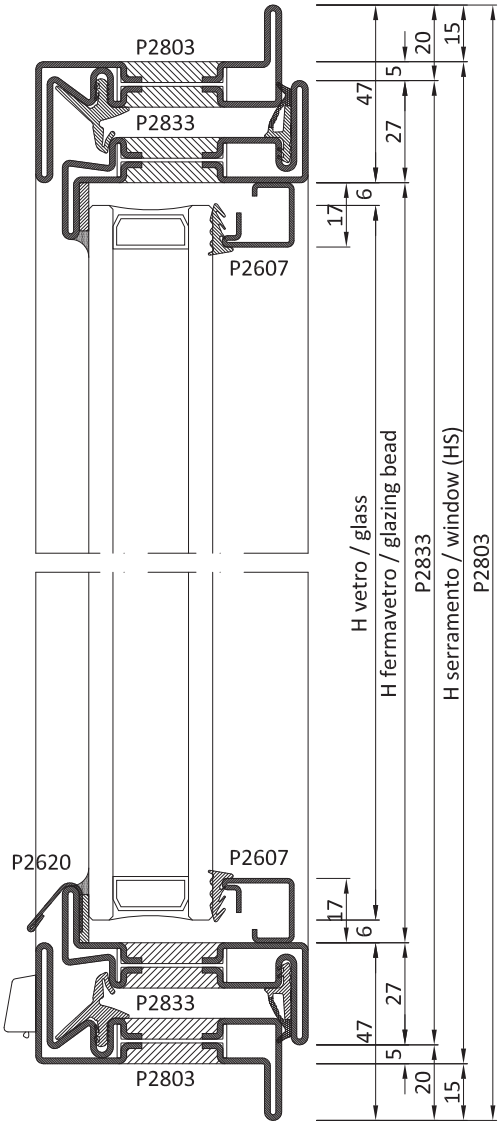




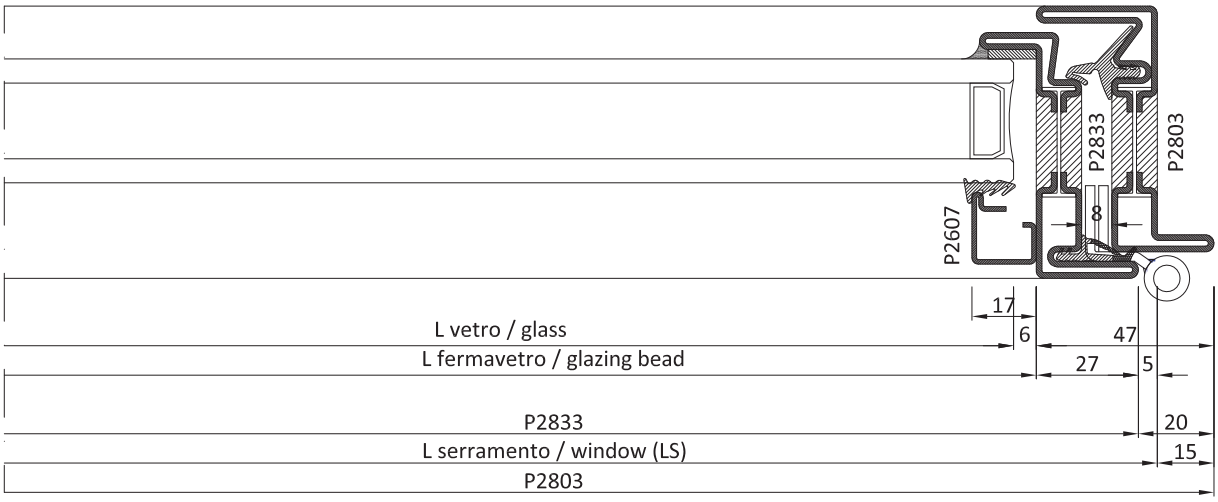
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.

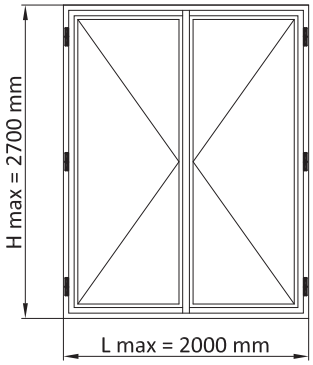
PROFILI *PROFILES*					
Codice *Code*	Descrizione *Descriprion*	n°	Dim.	Taglio	*Cutting*
Telaio	***Frame***				
P2803	Profilo a "Z" telaio *"Z" profile frame*	2	LS+30	45°	45°
P2803	Profilo a "Z" telaio *"Z" profile frame*	2	HS+30	45°	45°
Anta	***Leaf***				
P2833	Profilo a "Z" anta *"Z" profile leaf*	4	L/2+6	45°	45°
P2833	Profilo a "Z" anta *"Z" profile leaf*	3	HS-10	45°	45°
P2632	Profilo a "T" anta *"T" profile leaf*	1	HS-2	45°	45°
P2610	Profilo riporto per cremonese *additional profile for cremone*	1	HS-10	90°	90°
P2620	Profilo battiacqua *water drip profile*	2	L/2-53	90°	90°
Fermavetri	***Glazing beads***				
P2607	Profilo fermavetro *Glazing beads profile*	4	LS/2-48	45°	45°
P2607	Profilo fermavetro *Glazing beads profile*	4	HS-64	45°	45°
Vetri	***Glass***				
	Vetro camera *Double Glazing*	2	LS/2-60 x HS-76		





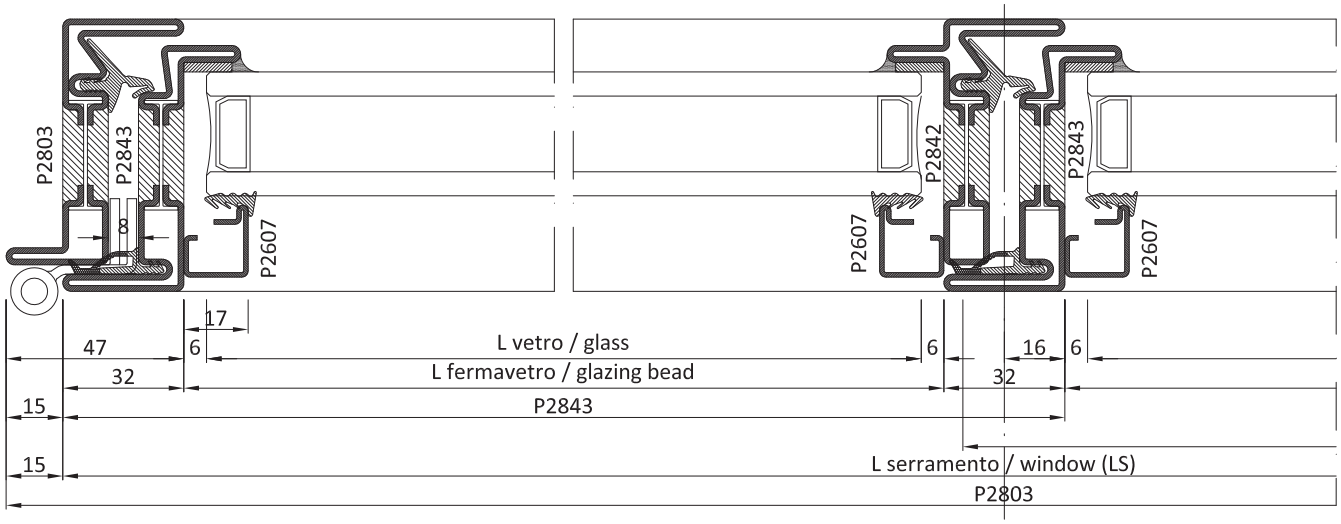
ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2603I	Fondino dx per 2^ anta	*Right botton plate for second leaf*	1	
AC2604I	Fondino sx per 2^ anta	*Left botton plate for second leaf*	1	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	4	
AC2833I	Kit squadrette per P2833	*Corner brackets kit for P2833*	6	
AC2832I	Kit squadrette P2833-32	*Corner brackets kit for P2833-32*	2	
AC2610I	Accessorio fissaggio P2610	*Accessories for fixing P2610*	6	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	4	
AC2618	Scarico acqua	*Water drip*	var.	
AC2622	Fermo a scatto per 2^ anta	*Snapper for second leaf window*	1	
AC2624D/S	Kit cremonese	*Cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC2627	Chiusura mediana lato cerniere	*Hinge-side middle closing*	var.	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*" Vitruvio" handle*	1	
GUARNIZIONI		***WEATHER STRIP***		
GE2600TT	Guarnizione di battuta	*Internal weather strip*	1	2xLS+3HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	2xLS+3HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4HS



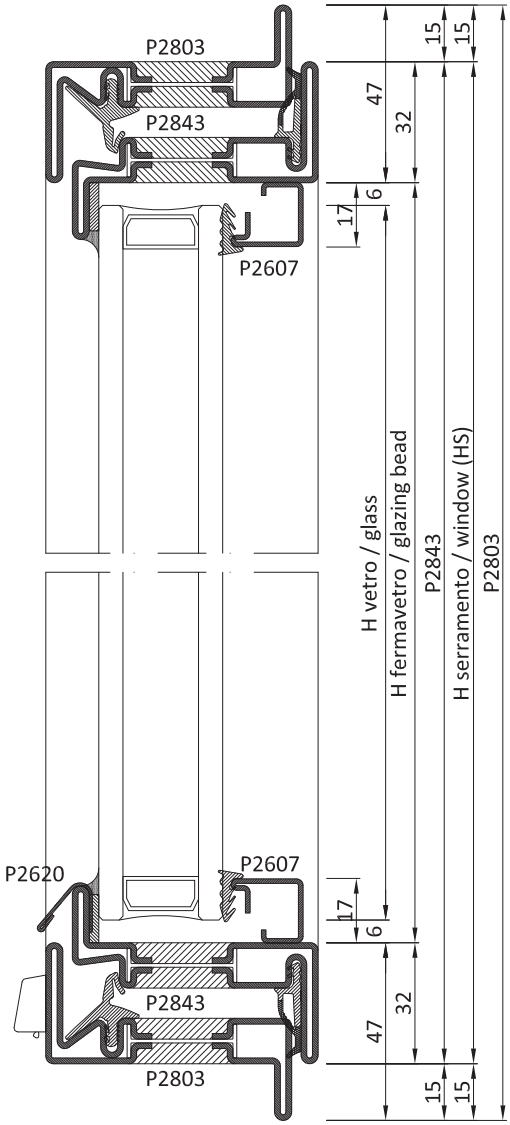


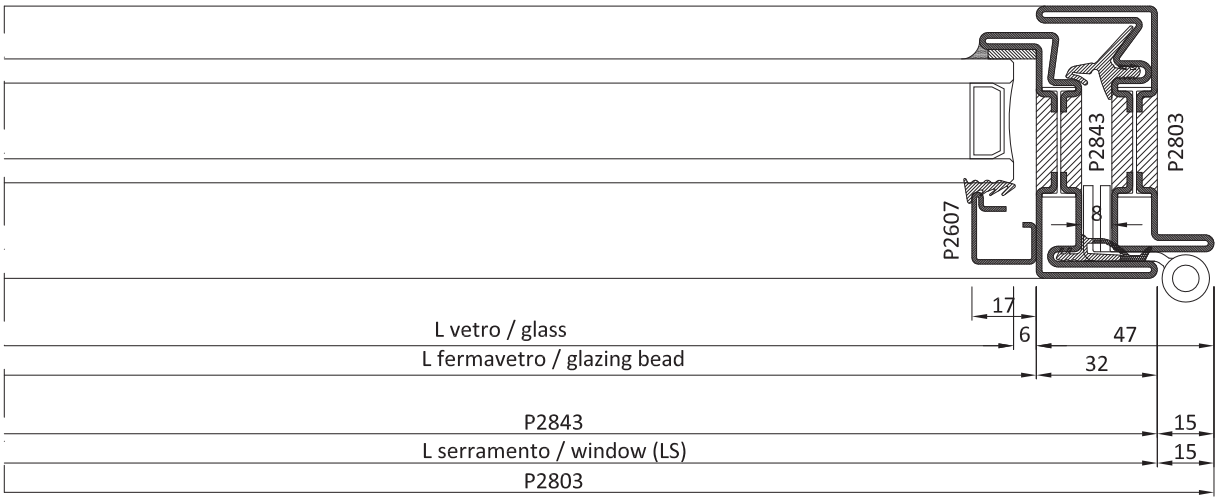
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.

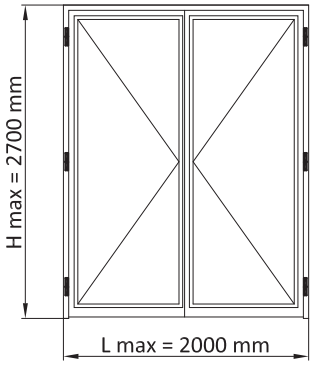
PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*		n°	Dim.	Taglio *Cutting*	
Telaio *Frame*						
P2803	Profilo a "Z" telaio	*"Z" profile frame*	2	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	2	HS+30	45°	45°
Anta *Leaf*						
P2843	Profilo a "Z" anta	*"Z" profile leaf*	4	L/2+16	45°	45°
P2843	Profilo a "Z" anta	*"Z" profile leaf*	3	HS	45°	45°
P2842	Profilo a "T" anta	*"T" profile leaf*	1	HS	45°	45°
P2620	Profilo battiacqua	*Water drip profile*	2	L/2-53	90°	90°
Fermavetri *Glazing beads*						
P2607	Profilo fermavetro	*Glazing beads profile*	4	LS/2-48	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	4	HS-64	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	2	LS/2-60 x HS-76		



ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2603I	Fondino dx per 2^ anta	*Right botton plate for second leaf*	1	
AC2604I	Fondino sx per 2^ anta	*Left botton plate for second leaf*	1	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	4	
AC2843I	Kit squadrette per P2843	*Corner brackets kit for P2843*	6	
AC2832I	Kit squadrette P2843-42	*Corner brackets kit for P2843-42*	2	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	4	
AC2618	Scarico acqua	*Water drip*	var.	
AC2622	Fermo a scatto per 2^ anta	*Snapper for second leaf window*	1	
AC2624D/S	Kit cremonese	*Cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC2627	Chiusura mediana lato cerniere	*Hinge-side middle closing*	var.	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI *WEATHER STRIP*				
GE2645TT	Guarnizione di battuta	*Internal weather strip*	1	2xLS+3HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	2xLS+3HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4HS

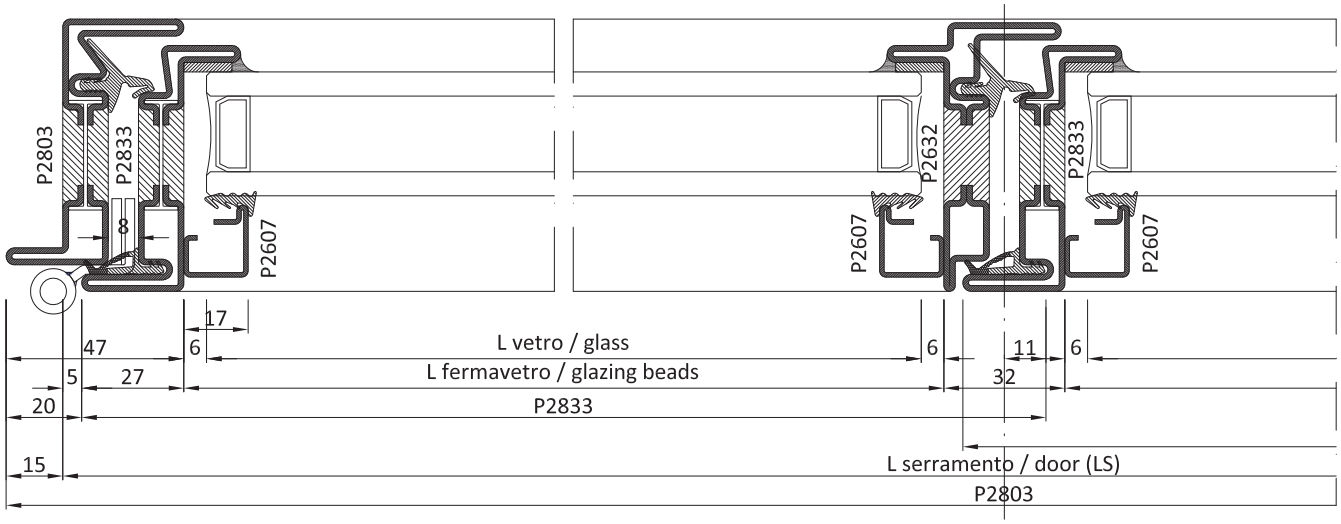


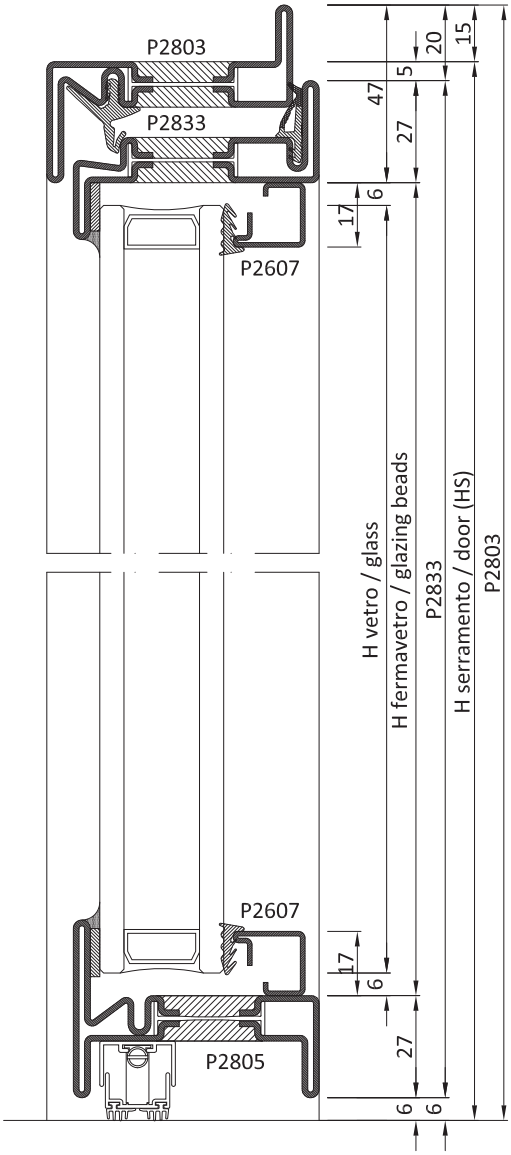




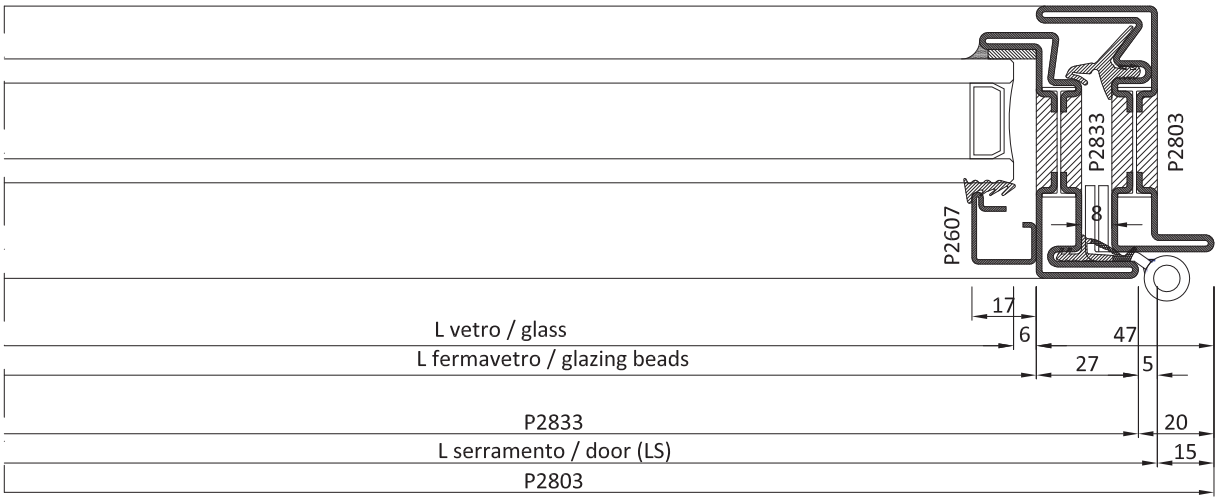
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.

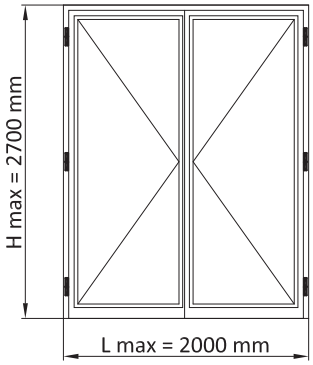
PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*			Dim.	Taglio *Cutting*	
Telaio *Frame*						
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	45°	90°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	90°	45°
Anta *Leaf*						
P2833	Profilo a "Z" anta	*"Z" profile leaf*	2	L/2+6	45°	45°
P2833	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-11	45°	90°
P2833	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-11	90°	45°
P2632	Profilo a "T" anta	*"T" profile leaf*	1	HS-6	90°	45°
P2632	Profilo Zoccolo	*Socle profile*	2	LS/2-48	90°	90°
Fermavetri *Glazing beads*						
P2607	Profilo fermavetro	*Glazing beads profile*	4	LS/2-48	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	4	HS-65	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	2	LS/2-60 x HS-77		





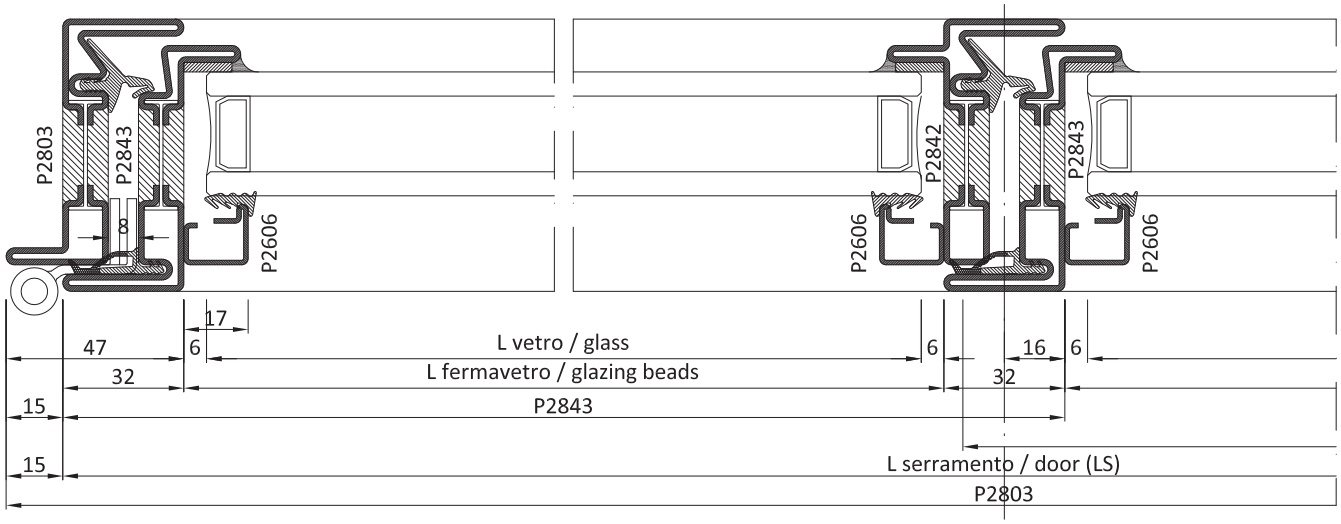
ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2603I	Fondino dx per 2^ anta	*Right botton plate for second leaf*	1	
AC2604I	Fondino sx per 2^ anta	*Left botton plate for second leaf*	1	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	2	
AC2833I	Kit squadrette per P2833	*Corner brackets kit for P2833*	3	
AC2832I	Kit squadrette P2833-32	*Corner brackets kit for P2833-32*	1	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	2	
AC2621R	Catenaccio 2^ anta (h 150)	*Second leaf bolt*	1	
AC2621M	Catenaccio 2^ anta (h 440)	*Second leaf bolt*	1	
AC...	Serratura	*Lock*	1	
AC2695D/S	Punto di chiusura agg. (con AC2694)	*Additional closing*	opz.	
AC2696/97	Scatola copri serratura	*Lock cover box*	1	
AC2636/.	Guarnizione automatica	*Automatic underdoor seal gasket*	1	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI *WEATHER STRIP*				
GE2600TT	Guarnizione di battuta	*Internal weather strip*	1	1xLS+3HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	1xLS+3HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4HS

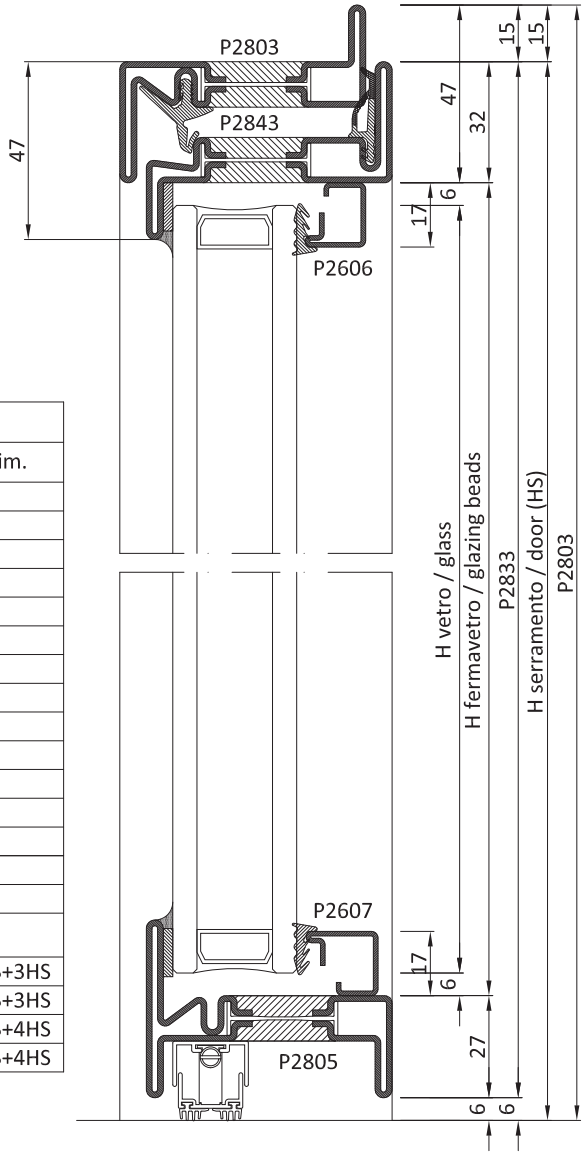




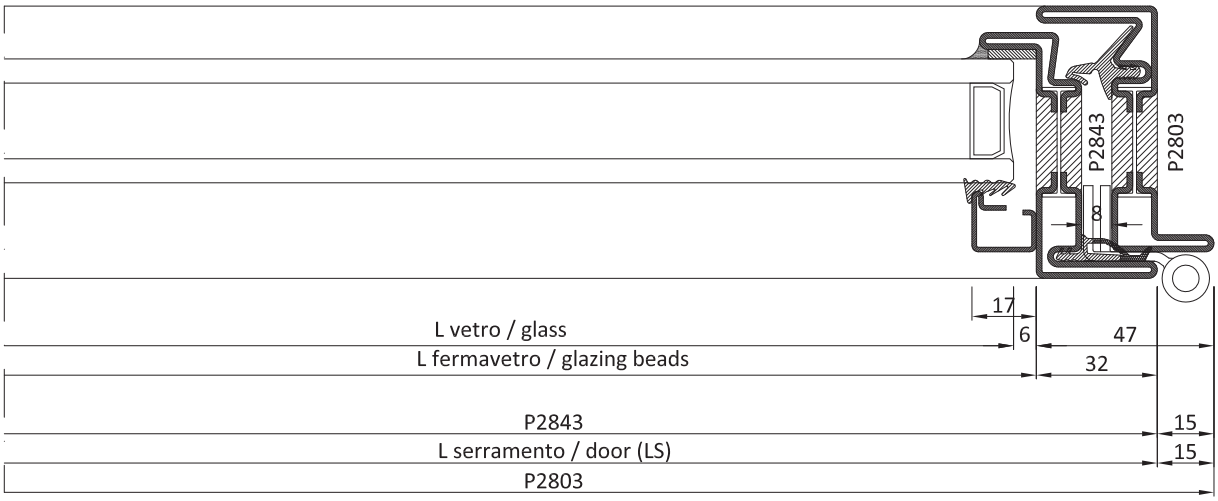
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.

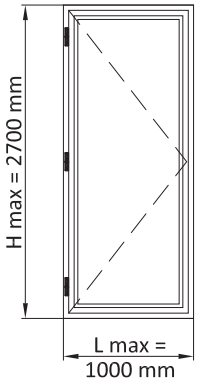
PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*			Dim.	Taglio *Cutting*	
Telaio *Frame*						
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	LS+30	45°	45°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	45°	90°
P2803	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	90°	45°
Anta *Leaf*						
P2843	Profilo a "Z" anta	*"Z" profile leaf*	2	L/2+16	45°	45°
P2843	Profilo a "Z" anta	*"Z" profile leaf*	2	HS-6	45°	90°
P2843	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-6	90°	45°
P2642	Profilo a "T" anta	*"T" profile leaf*	1	HS-6	90°	45°
P2805	Profilo Zoccolo	*Socle profile*	2	LS/2-48	90°	90°
Fermavetri *Glazing beads*						
P2607	Profilo fermavetro	*Glazing beads profile*	4	LS/2-48	45°	45°
P2607	Profilo fermavetro	*Glazing beads profile*	4	HS-65	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	2	LS/2-60 x HS-77		



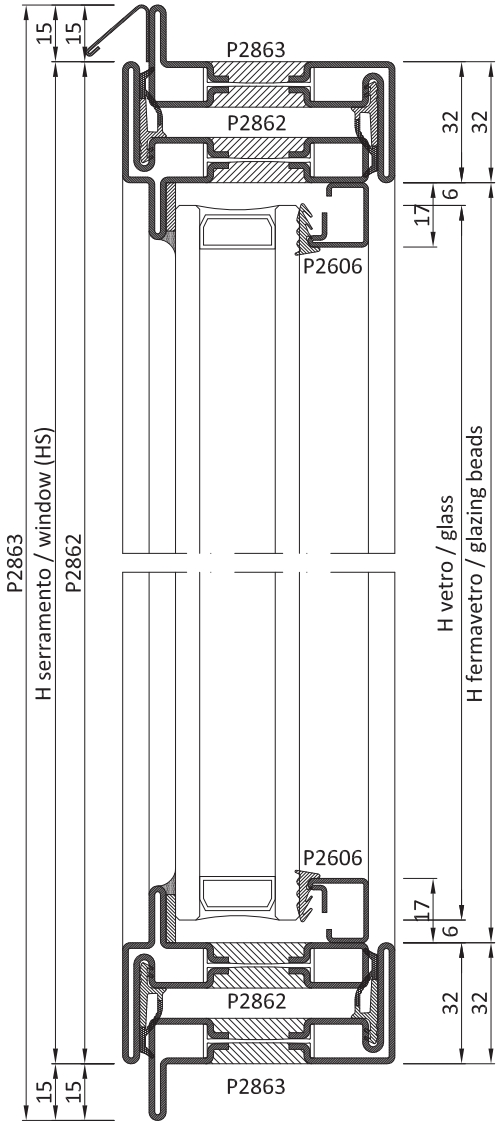


ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2603I	Fondino dx per 2^ anta	*Right botton plate for second leaf*	1	
AC2604I	Fondino sx per 2^ anta	*Left botton plate for second leaf*	1	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2803	*Corner brackets kit for P2803*	2	
AC2843I	Kit squadrette per P2843	*Corner brackets kit for P2833*	3	
AC2832I	Kit squadrette P2843-42	*Corner brackets kit for P2833-32*	1	
AC2617	Guarnizione d'angolo	*Vulcanised corner gasket*	2	
AC2621R	Catenaccio 2^ anta (h 150)	*Second leaf bolt*	1	
AC2621M	Catenaccio 2^ anta (h 440)	*Second leaf bolt*	1	
AC...	Serratura	*Lock*	1	
AC2695D/S	Punto di chiusura agg. (con AC2694)	*Additional closing*	opz.	
AC2696/97	Scatola copri serratura	*Lock cover box*	1	
AC2636/.	Guarnizione automatica	*Automatic underdoor seal gasket*	1	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI *WEATHER STRIP*				
GE2645TT	Guarnizione di battuta	*Internal weather strip*	1	2xLS+3HS
GE2602	Guarnizione giunto aperto	*Weather strip for open joint*	1	2xLS+3HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4HS



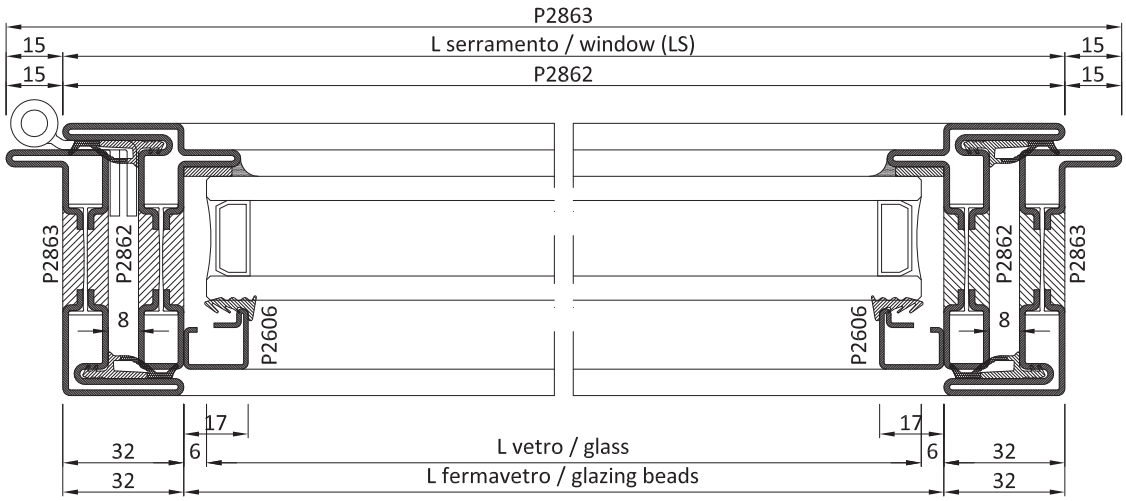


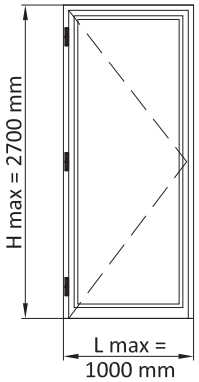
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.



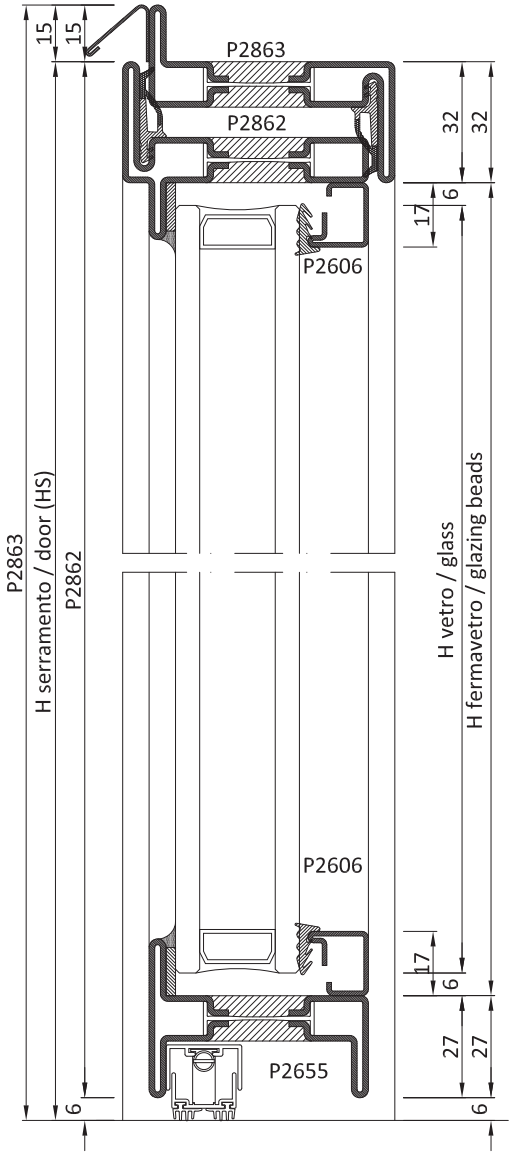
PROFILI *PROFILES*						
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.	Taglio	*Cutting*
Telaio *Frame*						
P2863	Profilo a "Z" telaio	*"Z" profile frame*	2	LS+30	45°	45°
P2863	Profilo a "Z" telaio	*"Z" profile frame*	2	HS+30	45°	45°
P2670	Profilo battiacqua	*water drip profile*	1	LS+30	90°	90°
Anta *Leaf*						
P2862	Profilo a "T" anta	*"T" profile leaf*	2	LS	45°	45°
P2862	Profilo a "T" anta	*"T" profile leaf*	2	HS	45°	45°
Fermavetri *Glazing beads*						
P2606	Profilo fermavetro	*Glazing beads profile*	2	LS-64	45°	45°
P2606	Profilo fermavetro	*Glazing beads profile*	2	HS-64	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	1	LS-76 x HS-76		

ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2863	*Corner brackets kit for P2863*	4	
AC2862I	Kit squadrette per P2862	*Corner brackets kit for P2862*	4	
AC2680	Maniglia di trascinamento	*Dragging leaf handle*	1	
AC2683 D/S	Kit cremonese chiusura	*Cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI *WEATHER STRIP*				
GE2645TT	Guarnizione di battuta	*Internal weather strip*	2	2xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2HS



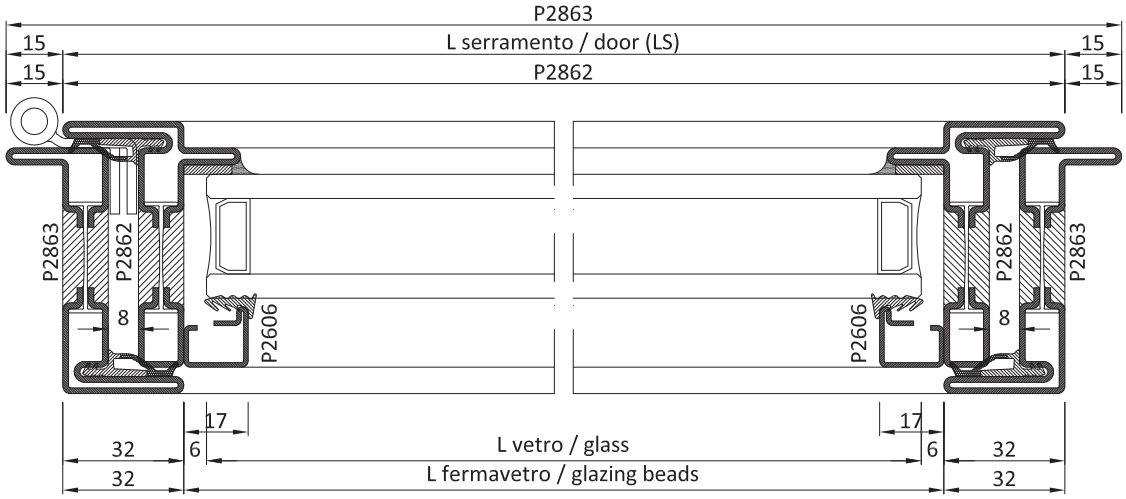


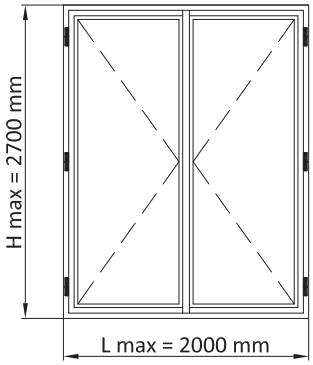
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.



PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*			Dim.	Taglio *Cutting*	
Telaio *Frame*						
P2863	Profilo a "Z" telaio	*"Z" profile frame*	1	LS+30	45°	45°
P2863	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	90°	45°
P2863	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	45°	90°
P2670	Profilo battiacqua	*water drip profile*	1	LS+30	90°	90°
Anta *Leaf*						
P2862	Profilo a "T" anta	*"T" profile leaf*	1	LS	45°	45°
P2862	Profilo a "T" anta	*"T" profile leaf*	1	HS-6	90°	45°
P2862	Profilo a "T" anta	*"T" profile leaf*	1	HS-6	45°	90°
P2655	Profilo Zoccolo	*socle profile*	1	LS-64	90°	90°
Fermavetri *Glazing beads*						
P2606	Profilo fermavetro	*Glazing beads profile*	2	LS-64	45°	45°
P2606	Profilo fermavetro	*Glazing beads profile*	2	HS-64	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	1	LS-76 x HS-76		

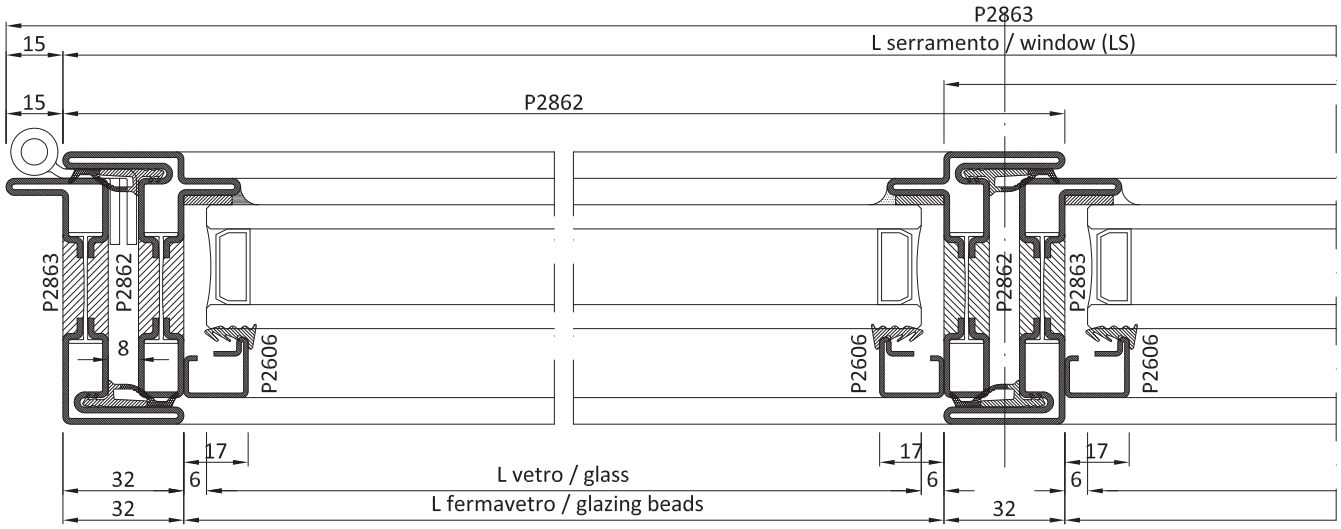
ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2863	*Corner brackets kit for P2863*	2	
AC2862I	Kit squadrette per P2862	*Corner brackets kit for P2862*	2	
AC...	Serratura	*Lock*	1	
AC2695D/S	Punto di chiusura agg. (con AC2694)	*Additional closing*	opz.	
AC2696/97	Scatola copri serratura	*Lock cover box*	1	
AC2636/.	Guarnizione automatica	*Automatic underdoor seal gasket*	1	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI *WEATHER STRIP*				
GE2645TT	Guarnizione di battuta	*Internal weather strip*	2	1xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2HS

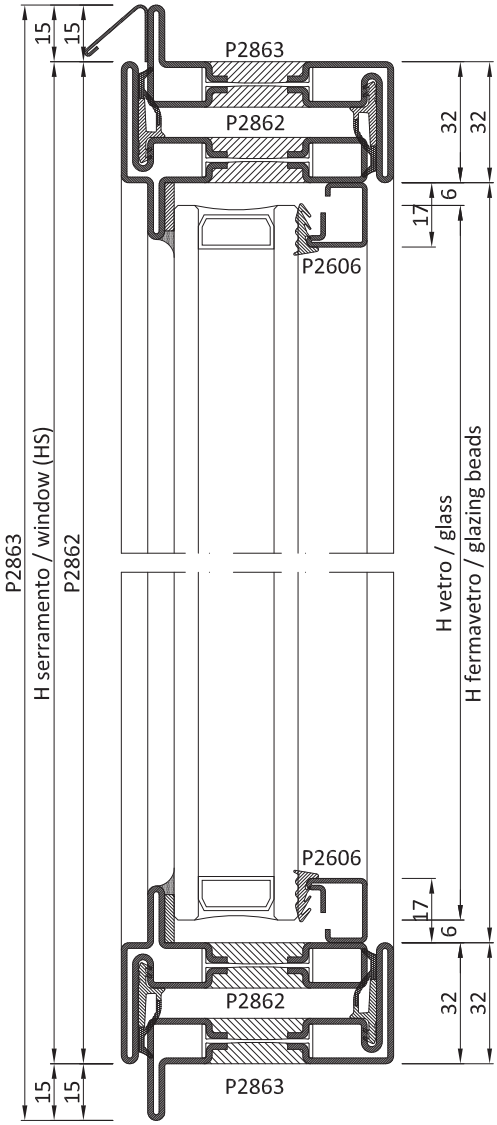




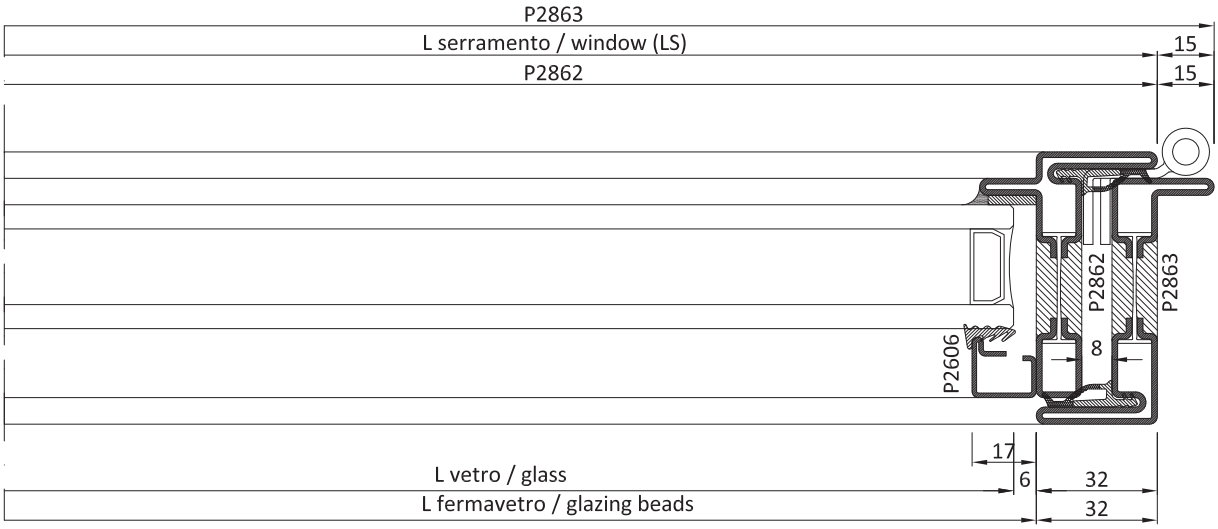
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.

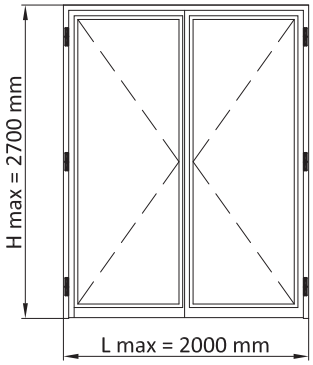
PROFILI *PROFILES*						
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.	Taglio	*Cutting*
Telaio		***Frame***				
P2863	Profilo a "Z" telaio	*"Z" profile frame*	2	LS+30	45°	45°
P2863	Profilo a "Z" telaio	*"Z" profile frame*	2	HS+30	45°	45°
P2670	Profilo battiacqua	*water drip profile*	1	LS+30	90°	90°
Anta		***Leaf***				
P2862	Profilo a "T" anta	*"T" profile leaf*	4	LS/2+16	45°	45°
P2862	Profilo a "T" anta	*"T" profile leaf*	3	HS	45°	45°
P2863	Profilo a "Z" anta	*"Z" profile leaf*	1	HS	45°	45°
Fermavetri		***Glazing beads***				
P2606	Profilo fermavetro	*Glazing beads profile*	4	LS/2-48	45°	45°
P2606	Profilo fermavetro	*Glazing beads profile*	4	HS-64	45°	45°
Vetri		***Glass***				
	Vetro camera	*Double Glazing*	2	LS/2-60 x HS-76		





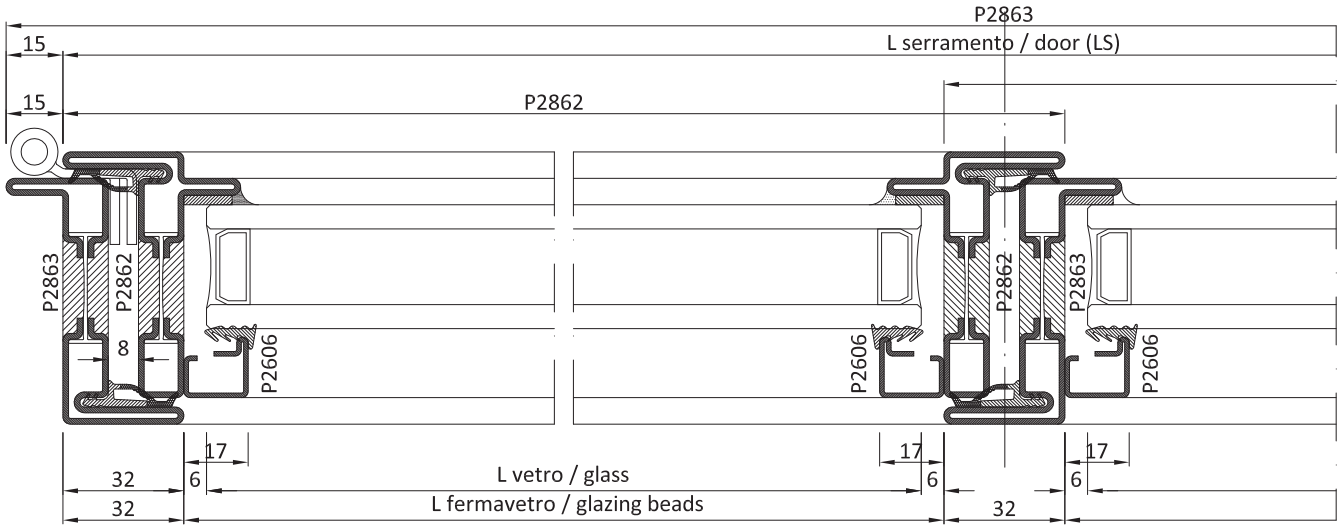
ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2643I	Fondino dx per 2^ anta	*Right botton plate for second leaf*	2	
AC2644I	Fondino sx per 2^ anta	*Left botton plate for second leaf*	2	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2863	*Corner brackets kit for P2863*	4	
AC2862I	Kit squadrette per P2862	*Corner brackets kit for P2862*	6	
AC2832I	Kit squadrette P2863-62	*Corner brackets kit for P2863-62*	2	
AC2680	Maniglia di trascinamento	*Dragging leaf handle*	1	
AC2684 D/S	Kit cremonese chiusura	*Cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI		***WEATHER STRIP***		
GE2645TT	Guarnizione di battuta	*Internal weather strip*	2	2xLS+3HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4HS

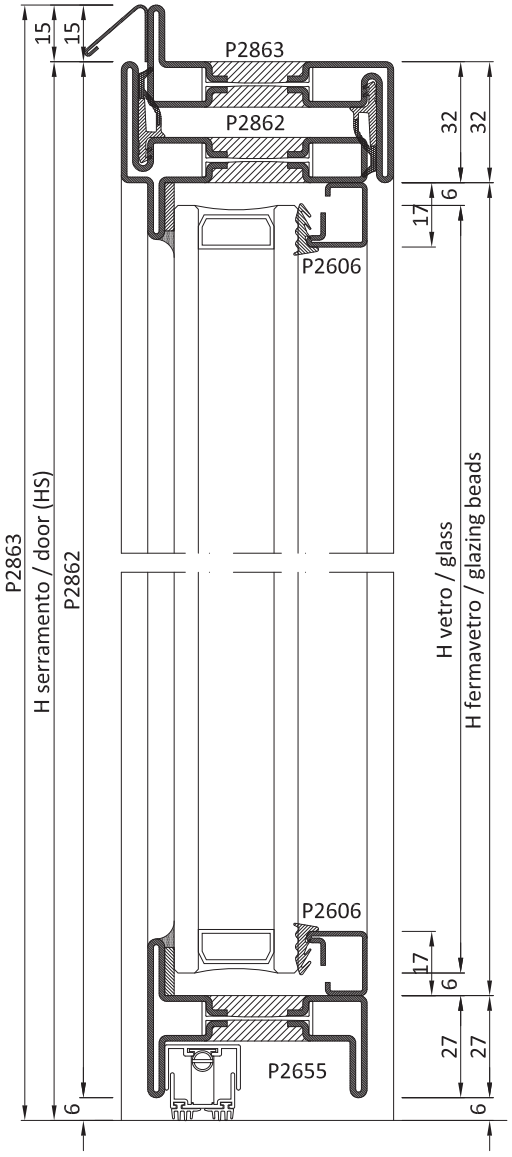




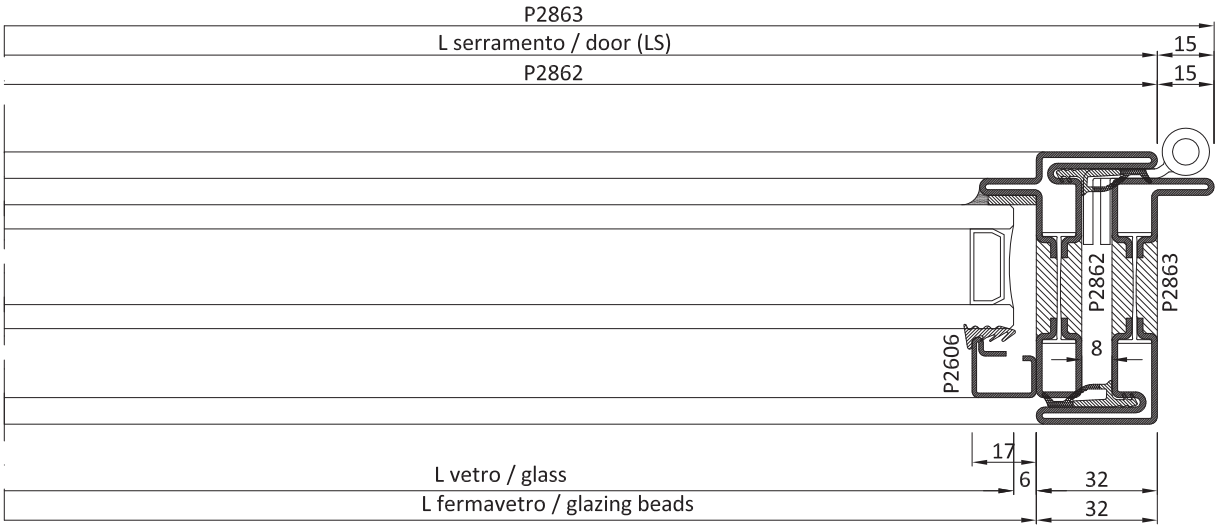
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm.

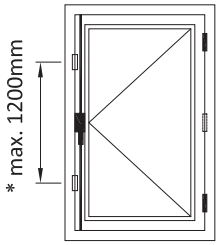
PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*			Dim.	Taglio *Cutting*	
Telaio *Frame*						
P2863	Profilo a "Z" telaio	*"Z" profile frame*	1	LS+30	45°	45°
P2863	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	90°	45°
P2863	Profilo a "Z" telaio	*"Z" profile frame*	1	HS+15	45°	90°
P2670	Profilo battiacqua	*water drip profile*	1	LS+30	90°	90°
P2862	Profilo a "T" anta	*"T" profile leaf*	4	LS/2+16	45°	45°
P2862	Profilo a "T" anta	*"T" profile leaf*	1	HS-6	90°	45°
P2862	Profilo a "T" anta	*"T" profile leaf*	1	HS-6	45°	90°
P2863	Profilo a "Z" anta	*"Z" profile leaf*	1	HS-6	45°	90°
P2655	Profilo Zoccolo	*socle profile*	2	LS/2-48	90°	90°
Fermavetri *Glazing beads*						
P2606	Profilo fermavetro	*Glazing beads profile*	4	LS/2-48	45°	45°
P2606	Profilo fermavetro	*Glazing beads profile*	4	HS-38	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	2	LS/2-60 x HS-76		

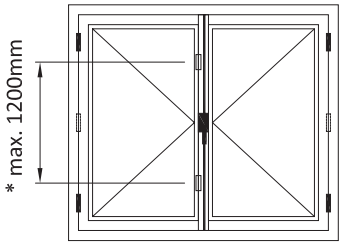


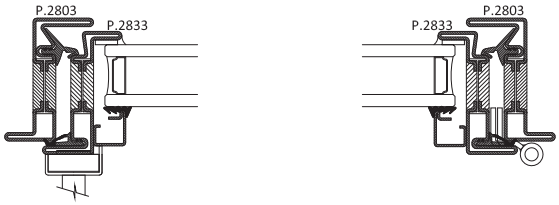


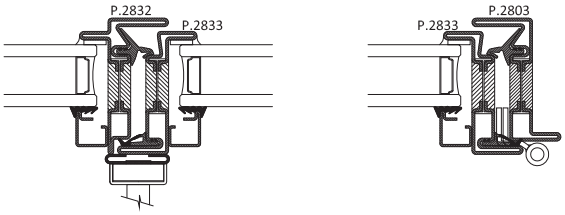
ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione	*Descriprion*	n°	Dim.
AC2643I	Fondino dx per 2^ anta	*Right botton plate for second leaf*	1	
AC2644I	Fondino sx per 2^ anta	*Left botton plate for second leaf*	1	
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2803I	Kit squadrette per P2863	*Corner brackets kit for P2863*	4	
AC2862I	Kit squadrette per P2862	*Corner brackets kit for P2862*	6	
AC2832I	Kit squadrette P2863-62	*Corner brackets kit for P2863-62*	2	
AC...	Serratura	*Lock*	1	
AC2695D/S	Punto di chiusura agg. (con AC2694)	*Additional closing*	opz.	
AC2696/97	Scatola copri serratura	*Lock cover box*	1	
AC2636/.	Guarnizione automatica	*Automatic underdoor seal gasket*	1	
AC	Cerniere	*Hinges*	var.	
ACV	Maniglie "Vitruvio"	*Handle " Vitruvio"*	1	
GUARNIZIONI	***WEATHER STRIP***			
GE2645TT	Guarnizione di battuta	*Internal weather strip*	2	1xLS+2HS
GU2035	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+4HS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+4HS









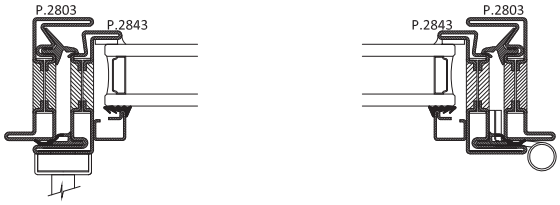


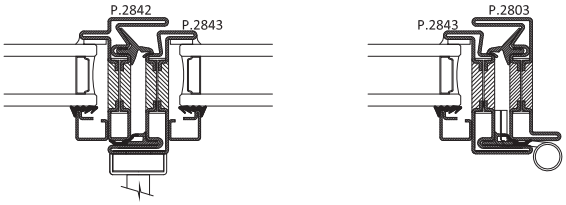
APERTURA INTERNA AD UN ANTA PROFILO P2833
ONE-LEAF INWARD OPENING P2833 PROFILE

Art. *Code*	Descrizione *Description*	Pag.
AC2623 D/S	Kit cremonese chiusura finestra ad un anta *Cremone bolt set for one-leaf window*	4.3.7 4.5.2|3
AC2628	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.16|17
AC2629/30	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.18|19
AC2631 A/B	Cerniere a saldare *Welding hinge*	4.4.4
AC2632 B/C	Cerniere a saldare *Welding hinge*	4.4.4
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15

APERTURA INTERNA A DUE ANTE PROFILO P2833
TWO-LEAF INWARD OPENING P2833 PROFILE

Art. *Code*	Descrizione *Description*	Pag.
AC2624 D/S	Kit cremonese chiusura finestra a due ante *Cremone bolt set for two-leaf window*	4.3.8 4.5.4|5
AC2622	Snapper chiusura 2^ anta *Snapper for 2nd leaf*	4.5.7
AC2628	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.16|17
AC2629/30	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.18|19
AC2631 A/B	Cerniere a saldare *Welding hinge*	4.4.4
AC2632 B/C	Cerniere a saldare *Welding hinge*	4.4.4
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15



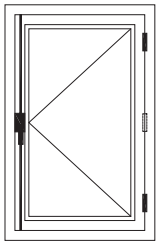


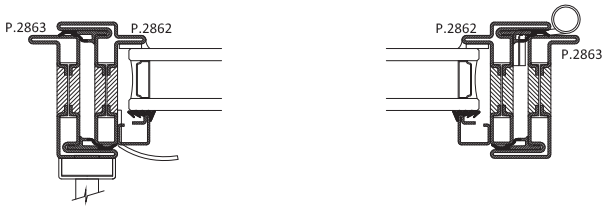
APERTURA INTERNA AD UN ANTA PROFILO P2843
ONE-LEAF INWARD OPENING P2843 PROFILE

Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura finestra ad un anta *Cremone bolt set for one-leaf window*	4.3.10 4.5.8|9
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.22|23
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.24|25
AC2631 A/B	Cerniere a saldare *Welding hinge*	4.4.5
AC2632 B/C	Cerniere a saldare *Welding hinge*	4.4.5
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15

APERTURA INTERNA A DUE ANTE PROFILO P2843
TWO-LEAF INWARD OPENING P2843 PROFILE

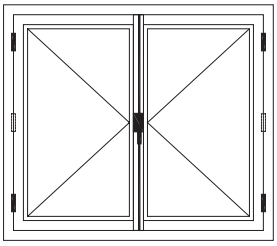
Art. *Code*	Descrizione *Description*	Pag.
AC2624 D/S	Kit cremonese chiusura finestra a due ante *Cremone bolt set for two-leaf window*	4.3.9 4.5.6|7
AC2622	Snapper chiusura 2^ anta *Snapper for 2nd leaf*	9.31
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.22|23
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.24|25
AC2631 A/B	Cerniere a saldare *Welding hinge*	4.4.5
AC2632 B/C	Cerniere a saldare *Welding hinge*	4.4.5
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15

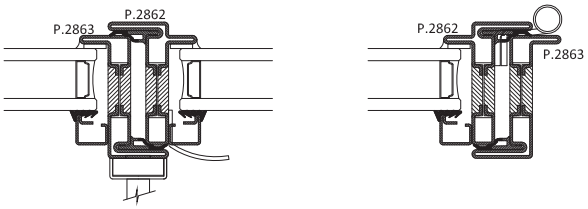




APERTURA ESTRERNA AD UN ANTA PROFILO P2862
ONE-LEAF OUTWARD OPENING P2862 PROFILE

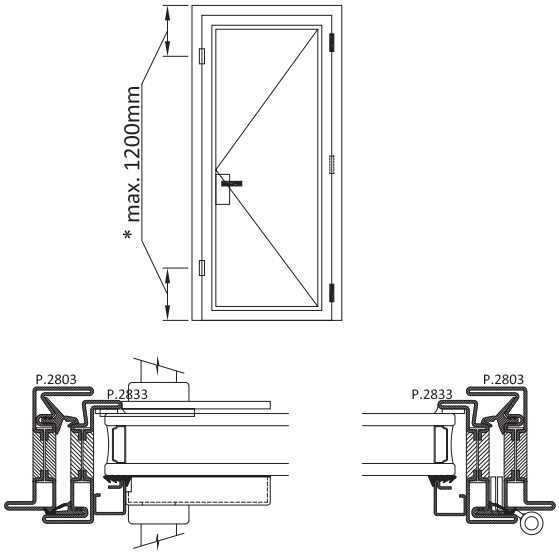
Codice *Code*	Descrizione *Description*	Pag.
AC2683 D/S	Kit cremonese chiusura finestra ad un anta *Cremone bolt set for one-leaf window*	4.3.11|12 4.5.10|11
AC2680	Maniglia trascinamento anta *Pulling handle*	4.5.19
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.20|21
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.26|27
AC2631 A/B	Cerniere a saldare *Welding hinge*	4.4.6
AC2632 B/C	Cerniere a saldare *Welding hinge*	4.4.6

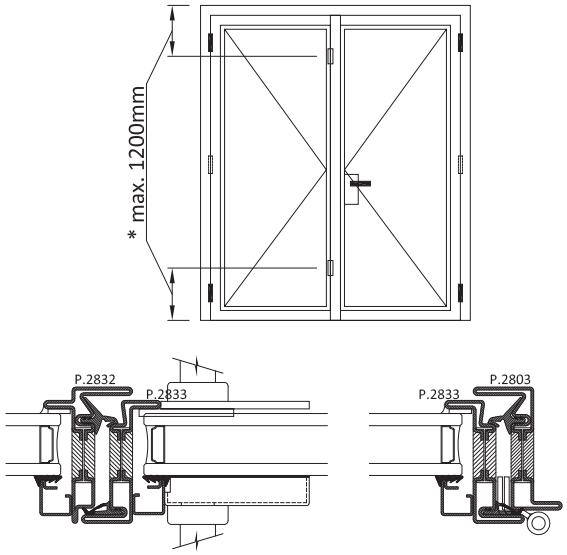




APERTURA ESTERNA A DUE ANTE PROFILO P2862
TWO-LEAF OUTWARD OPENING P2862 PROFILE

Codice *Code*	Descrizione *Description*	Pag.
AC2684 D/S	Kit cremonese chiusura finestra a due ante *Cremone bolt set for two-leaf window*	4.3.13|14 4.5.12|13
AC2680	Maniglia trascinamento anta *Pulling handle*	4.5.19
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.20|21
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.26|27
AC2631 A/B	Cerniere a saldare *Welding hinge*	4.4.6
AC2632 B/C	Cerniere a saldare *Welding hinge*	4.4.6



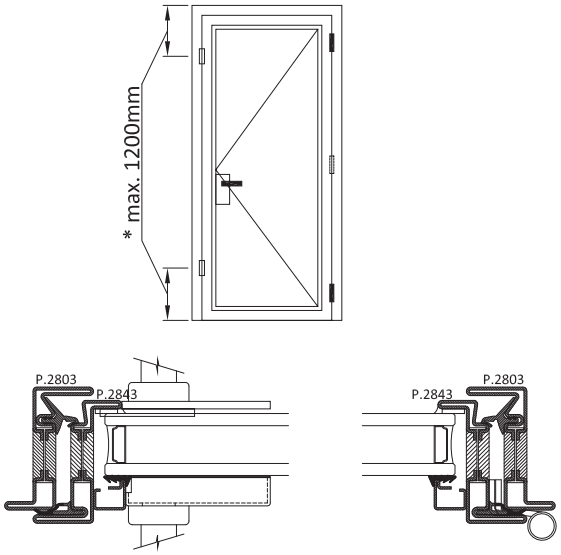


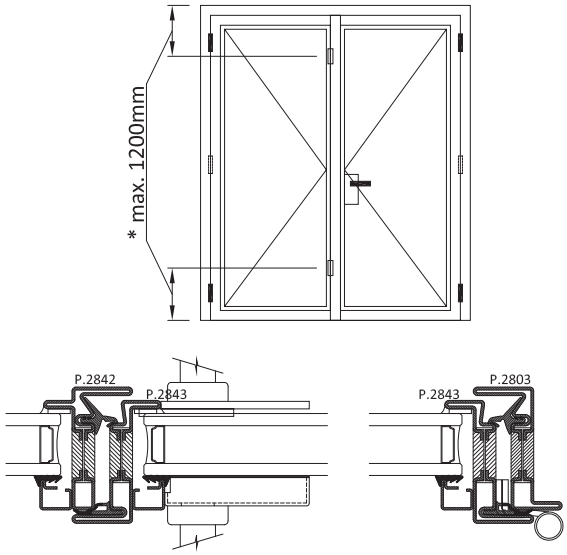
APERTURA INTERNA AD UN ANTA PROFILO P2833
ONE-LEAF INWARD OPENING P2833 PROFILE

Art. *Code*	Descrizione *Description*	Pag.
AC2693	Serratura con scrocco e catenaccio *Lock with spring latch and bolt*	4.3.34
AC2694 D/S	Kit serratura a multipunto *Multi-lock kit*	4.3.35 4.5.21|22
AC2695 D/S	Punto di chiusura aggiuntivo *Additional lock*	4.3.37 4.5.23
AC2696/97	Scatola copri serratura *Lock cover box*	4.5.24
AC2628	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.16|17
AC2629/30	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.18|19
AC2631/B	Cerniere a saldare *Welding hinge*	4.4.4
AC2632/B-C	Cerniere a saldare *Welding hinge*	4.4.4
AC2636	Guarnizione automatica sotto porta *Automatic underdoor seal gasket*	4.3.32
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15

APERTURA INTERNA A DUE ANTE PROFILO P2833
TWO-LEAF INWARD OPENING P2833 PROFILE

Art. *Code*	Descrizione *Description*	Pag.
AC2693	Serratura con scrocco e catenaccio *Lock with spring latch and bolt*	4.3.34
AC2694 D/S	Kit serratura a multipunto *Multi-lock kit*	4.3.35 4.5.21|22
AC2695 D/S	Punto di chiusura aggiuntivo *Additional lock*	4.3.37 4.5.23
AC2696/97	Scatola copri serratura *Lock cover box*	4.5.24
AC2621R/M	Catenaccio seconda anta *Second leaf bolt*	4.3.31
AC2628	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.16|17
AC2629/30	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.18|19
AC2631/B	Cerniere a saldare *Welding hinge*	4.4.4
AC2632/B-C	Cerniere a saldare *Welding hinge*	4.4.4
AC2636	Guarnizione automatica sotto porta *Automatic underdoor seal gasket*	4.3.32
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15



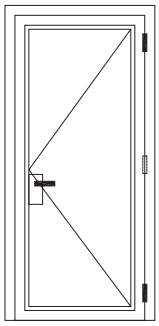


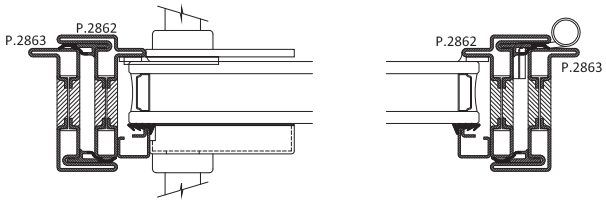
APERTURA INTERNA AD UN ANTA PROFILO P2843
ONE-LEAF INWARD OPENING P2843 PROFILE

Art. *Code*	Descrizione *Description*	Pag.
AC2693	Serratura con scrocco e catenaccio *Lock with spring latch and bolt*	4.3.34
AC2694 D/S	Kit serratura a multipunto *Multi-lock kit*	4.3.35 4.5.21|22
AC2695 D/S	Punto di chiusura aggiuntivo *Additional lock*	4.3.37 4.5.23
AC2696/97	Scatola copri serratura *Lock cover box*	4.5.24
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.22|23
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.24|25
AC2631/B	Cerniere a saldare *Welding hinge*	4.4.5
AC2632/B-C	Cerniere a saldare *Welding hinge*	4.4.5
AC2636	Guarnizione automatica sotto porta *Automatic underdoor seal gasket*	4.3.32
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15

APERTURA INTERNA A DUE ANTE PROFILO P2843
TWO-LEAF INWARD OPENING P2843 PROFILE

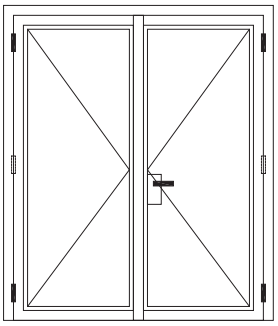
Art. *Code*	Descrizione *Description*	Pag.
AC2693	Serratura con scrocco e catenaccio *Lock with spring latch and bolt*	4.3.34
AC2694 D/S	Kit serratura a multipunto *Multi-lock kit*	4.3.35 4.5.21|22
AC2695 D/S	Punto di chiusura aggiuntivo *Additional lock*	4.3.37 4.5.23
AC2696/97	Scatola copri serratura *Lock cover box*	4.5.24
AC2621R/M	Catenaccio seconda anta *Second leaf bolt*	4.3.31
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.22|23
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.24|25
AC2631/B	Cerniere a saldare *Welding hinge*	4.4.5
AC2632/B-C	Cerniere a saldare *Welding hinge*	4.4.5
AC2636	Guarnizione automatica sotto porta *Automatic underdoor seal gasket*	4.3.32
AC2626 R *	Chiusura supplementare *Additional lock*	4.3.15

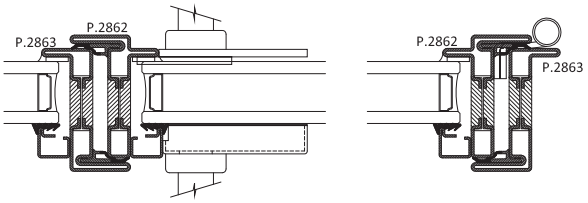




APERTURA ESTERNA AD UN ANTA PROFILO P2862
ONE-LEAF OUTWARD OPENING P2862 PROFILE

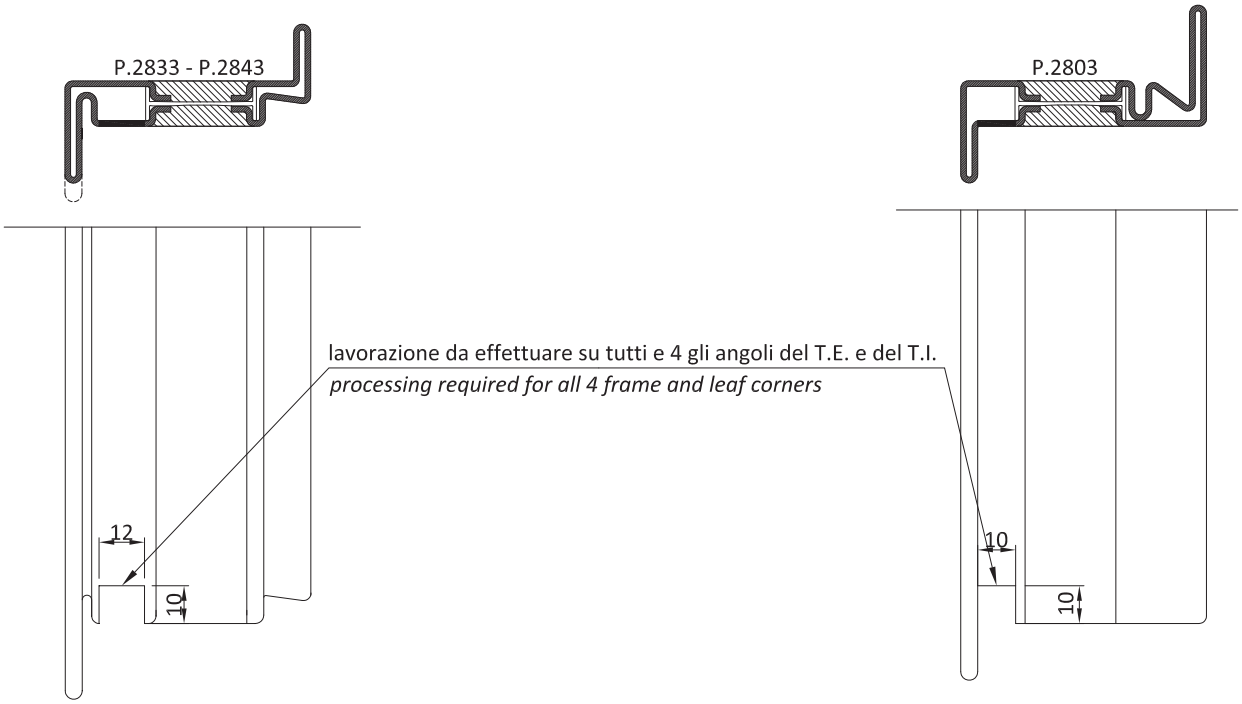
Codice *Code*	Descrizione *Description*	Pag.
AC2693	Serratura con scrocco e catenaccio *Lock with spring latch and bolt*	4.3.34
AC2694 D/S	Kit serratura a multipunto *Multi-lock kit*	4.3.35 4.5.21|22
AC2695 D/S	Punto di chiusura aggiuntivo *Additional lock*	4.3.37 4.5.23
AC2696/97	Scatola copri serratura *Lock cover box*	4.5.24
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.20|21
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.26|27
AC2631/B	Cerniere a saldare *Welding hinge*	4.4.6
AC2632/B-C	Cerniere a saldare *Welding hinge*	4.4.6
AC2636	Guarnizione automatica sotto porta *Automatic underdoor seal gasket*	4.3.33

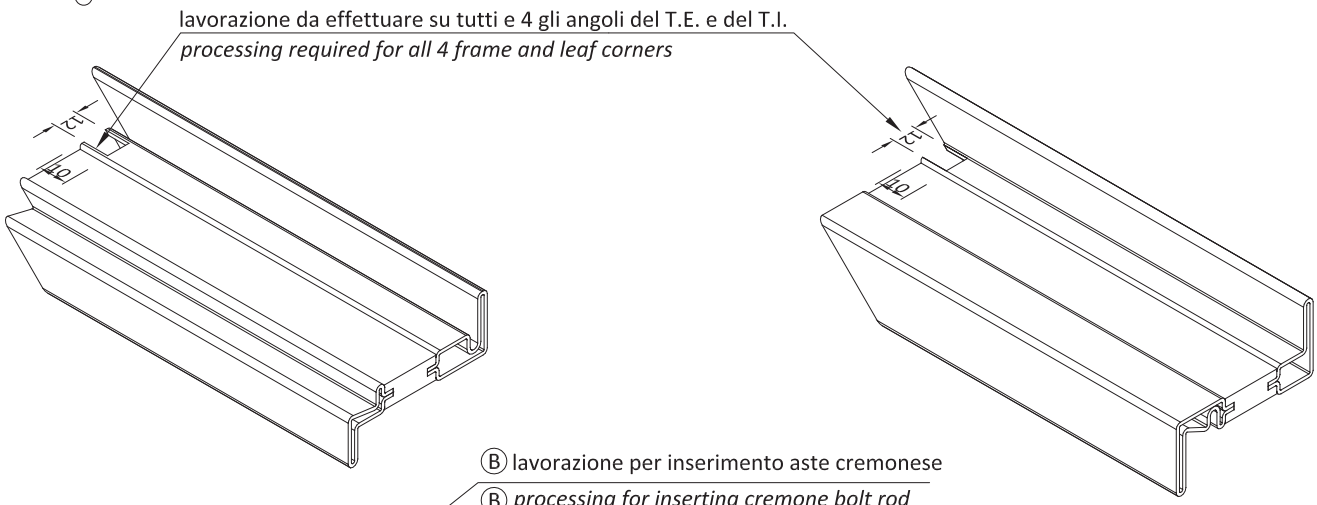


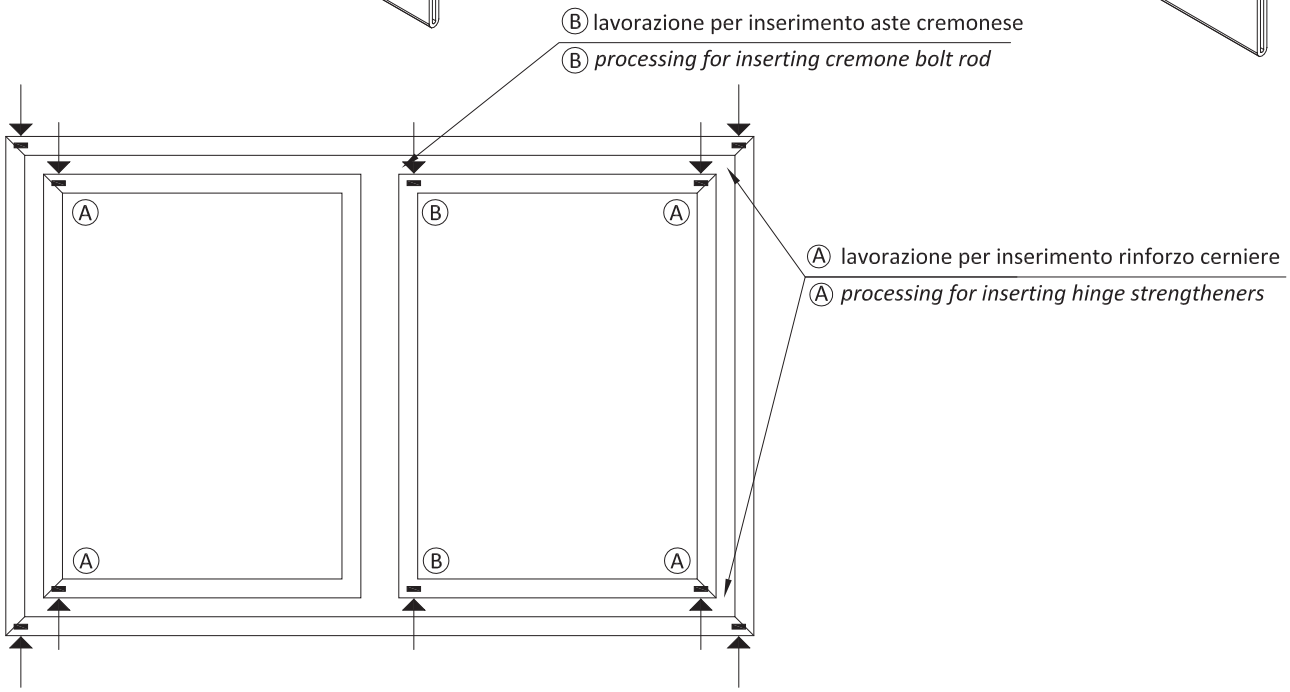


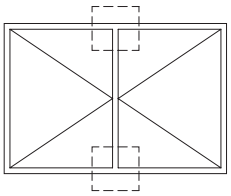
APERTURA ESTERNA A DUE ANTE PROFILO P2862
TWO-LEAF OUTWARD OPENING P2862 PROFILE

Codice *Code*	Descrizione *Description*	Pag.
AC2693	Serratura con scrocco e catenaccio *Lock with spring latch and bolt*	4.3.34
AC2694 D/S	Kit serratura a multipunto *Multi-lock kit*	4.3.35 4.5.21|22
AC2695 D/S	Punto di chiusura aggiuntivo *Additional lock*	4.3.37 4.5.23
AC2696/97	Scatola copri serratura *Lock cover box*	4.5.24
AC2621R/M	Catenaccio seconda anta *Second leaf bolt*	4.3.31
AC2648	Cerniere a tre ali ad avvitare *Three-wing screw-in hinge*	4.3.20|21
AC2649/50	Cerniere a due ali ad avvitare *Two-wing screw-in hinge*	4.3.26|27
AC2631/B	Cerniere a saldare *Welding hinge*	4.4.6
AC2632/B-C	Cerniere a saldare *Welding hinge*	4.4.6
AC2636	Guarnizione automatica sotto porta *Automatic underdoor seal gasket*	4.3.33

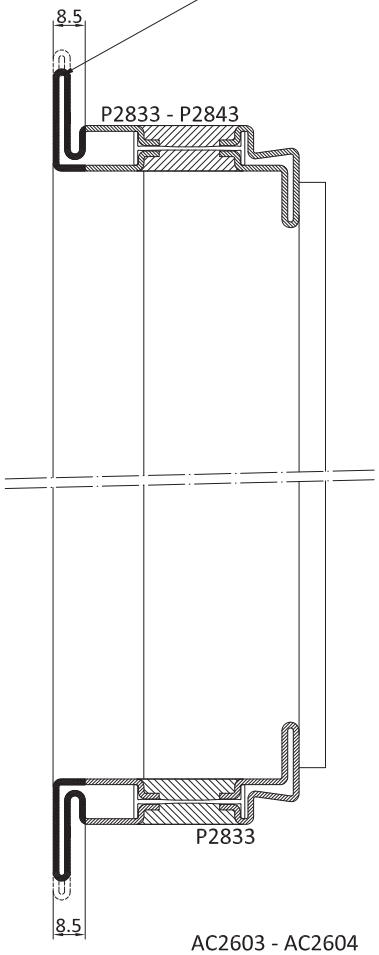

P.2833 - P.2843
P.2803
lavorazione da effettuare su tutti e 4 gli angoli del T.E. e del T.I.
processing required for all 4 frame and leaf corners
12
10
10
10

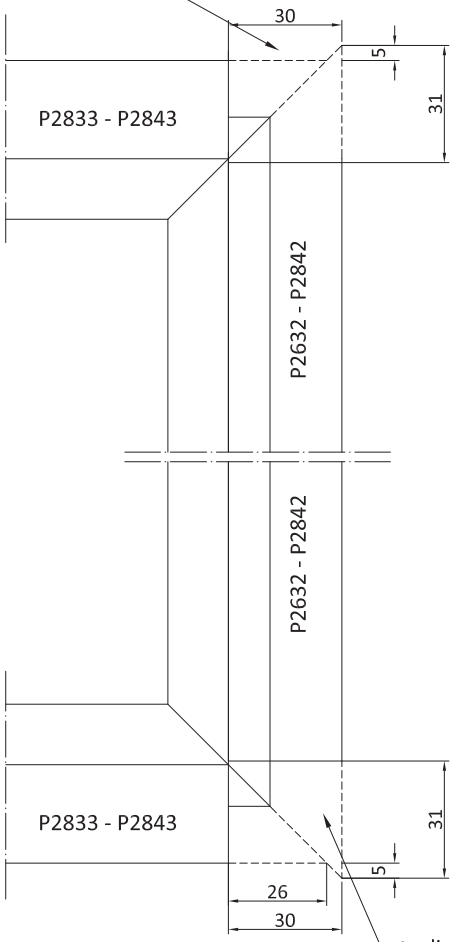

lavorazione da effettuare su tutti e 4 gli angoli del T.E. e del T.I.
processing required for all 4 frame and leaf corners
12
10
12
10

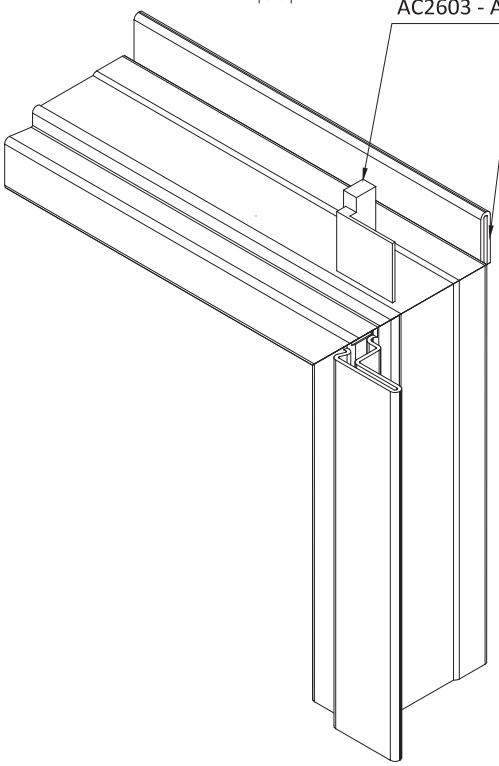

Ⓑ lavorazione per inserimento aste cremonese
Ⓑ *processing for inserting cremone bolt rod*
Ⓐ lavorazione per inserimento rinforzo cerniere
Ⓐ *processing for inserting hinge strengtheners*
A
B
A
A
B
A



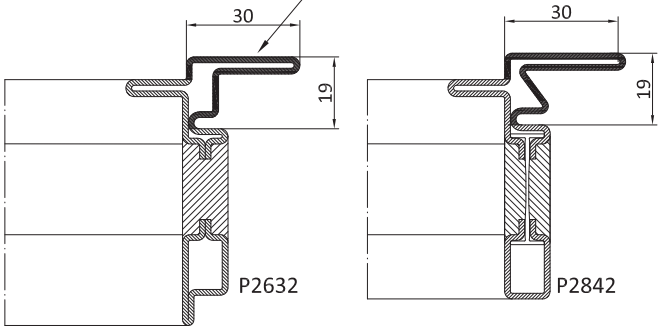
taglio punta su P2833
top cut on P2833

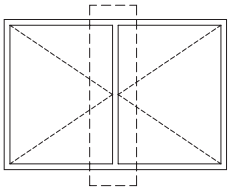


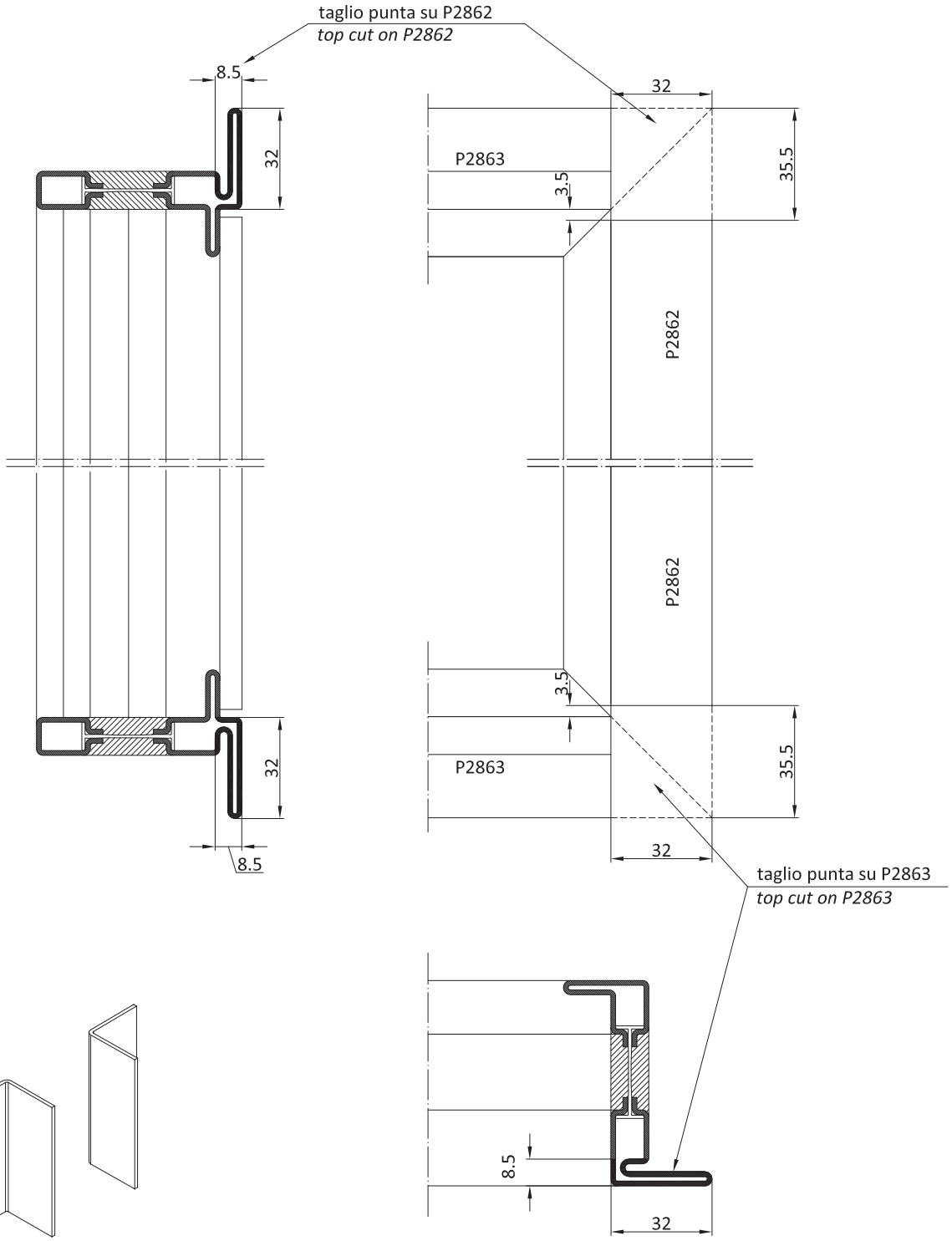


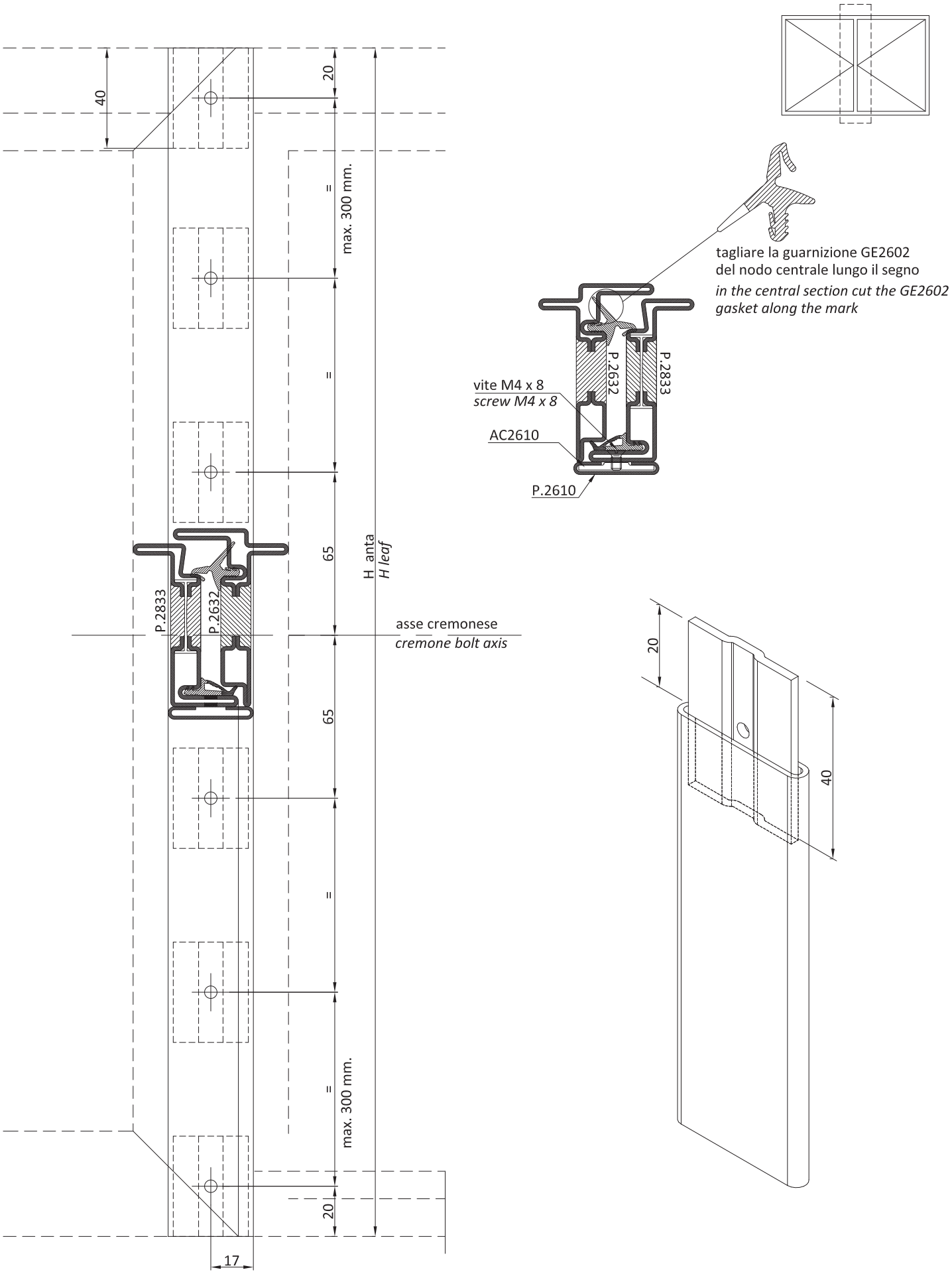


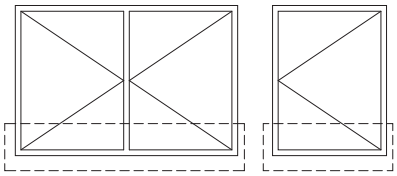
taglio punta su P2632 - P2842
top cut on P2632 - P2842

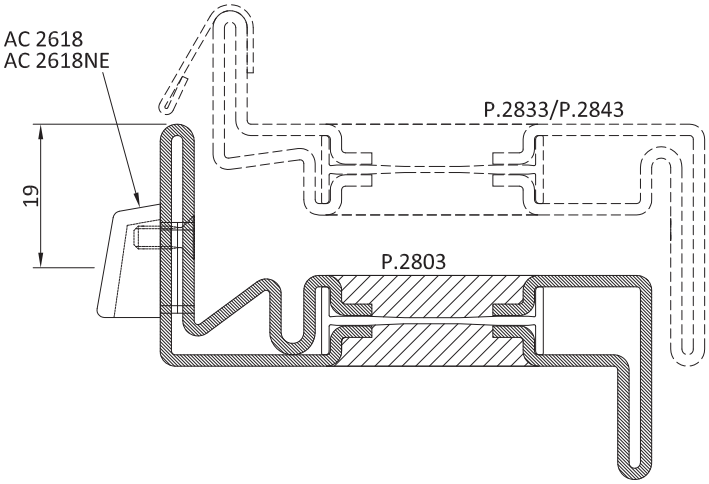


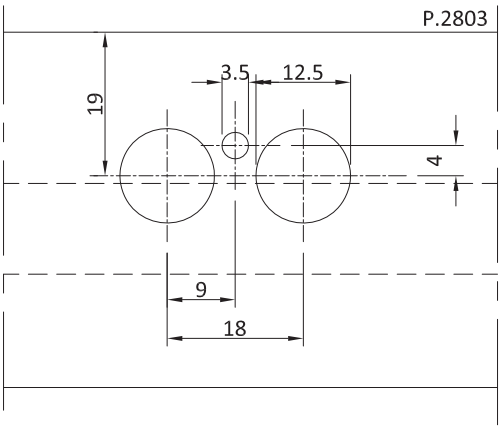


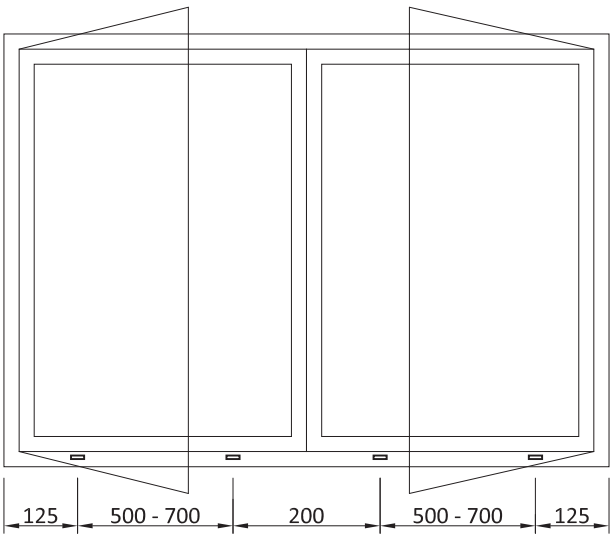

taglio punta su P2862
top cut on P2862
8.5
32
P2863
3.5
35.5
P2862
P2862
3.5
P2863
35.5
32
8.5
32
taglio punta su P2863
top cut on P2863
8.5
32

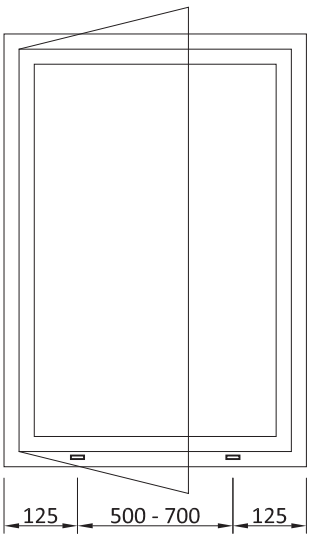

40
20
=
max. 300 mm.
=
65
H anta
H leaf
P.2833
P.2632
asse cremonese
cremone bolt axis
65
=
=
max. 300 mm.
20
17
tagliare la guarnizione GE2602
del nodo centrale lungo il segno
in the central section cut the GE2602
gasket along the mark
P.2632
P.2833
vite M4 x 8
screw M4 x 8
AC2610
P.2610
20
40

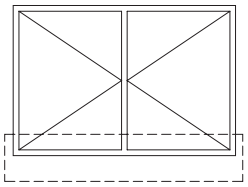


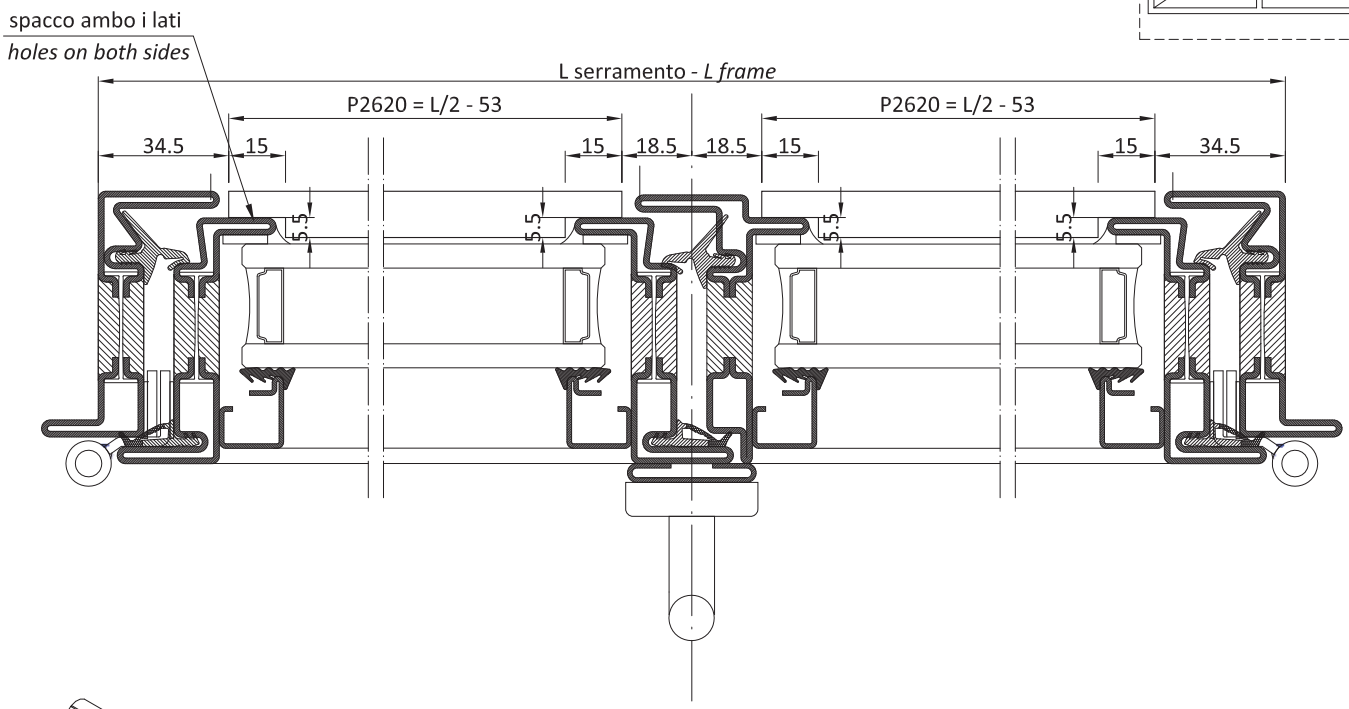

AC 2618
AC 2618NE
P.2833/P.2843
19
P.2803

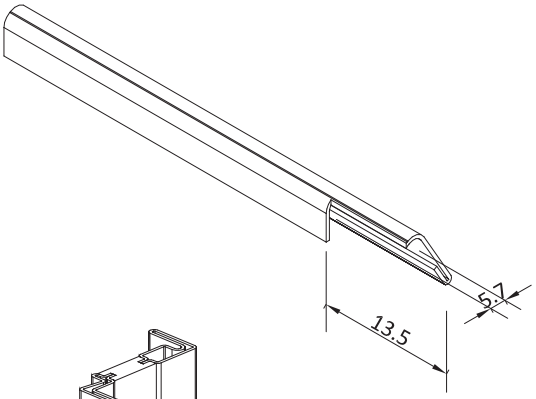

P.2803
19
3.5
12.5
4
9
18

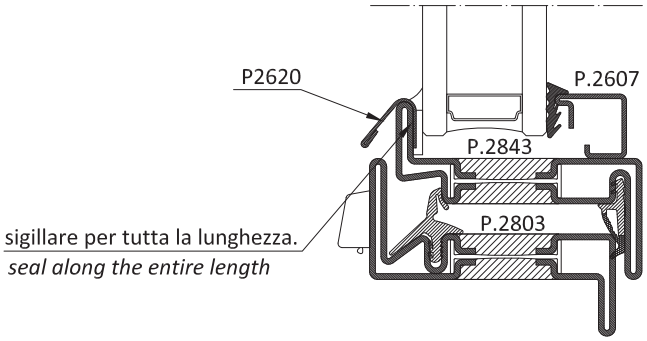

125
500 - 700
200
500 - 700
125

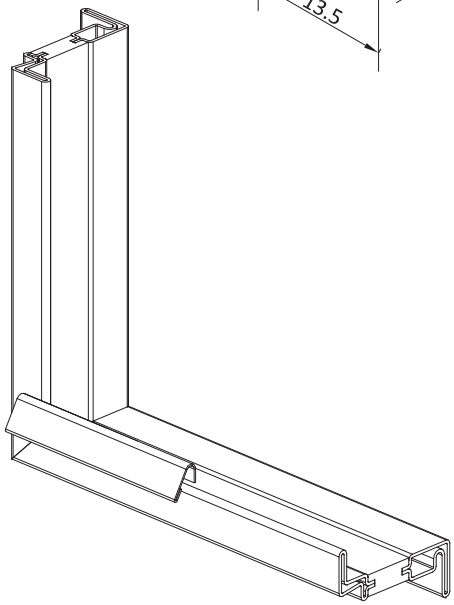

125
500 - 700
125

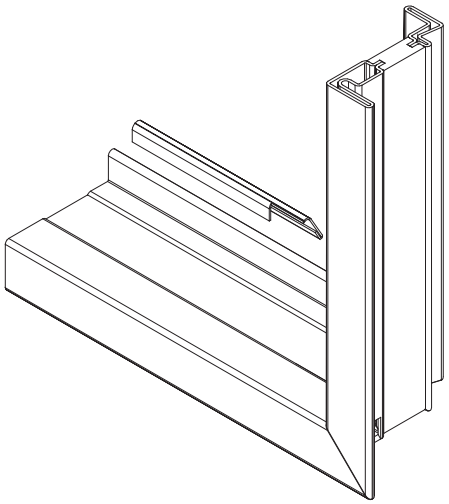


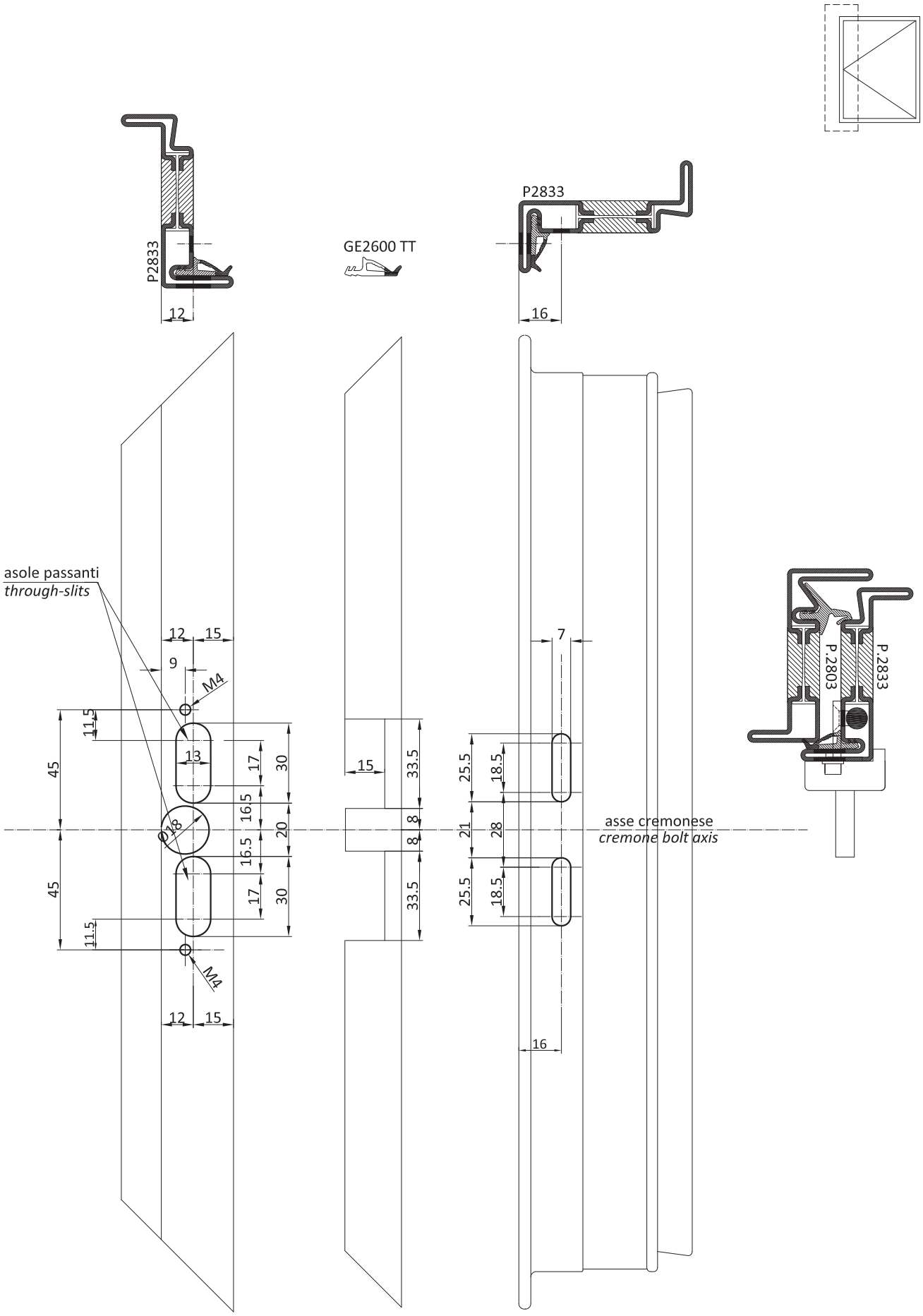

spacco ambo i lati
holes on both sides
L serramento - *L frame*
P2620 = L/2 - 53
P2620 = L/2 - 53
34.5
15
15
18.5
18.5
15
15
34.5
5.5
5.5
5.5
5.5

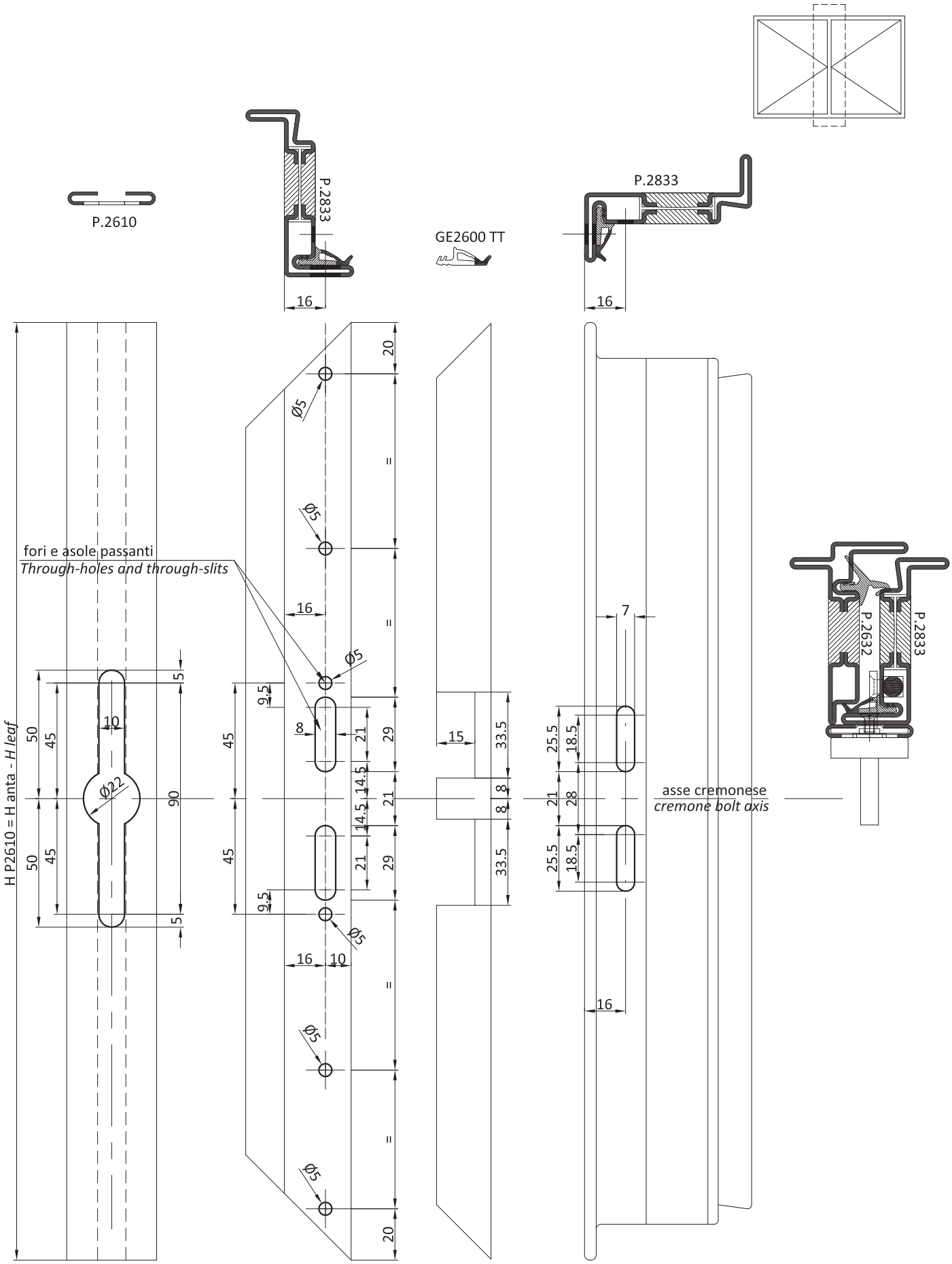

5.1
13.5

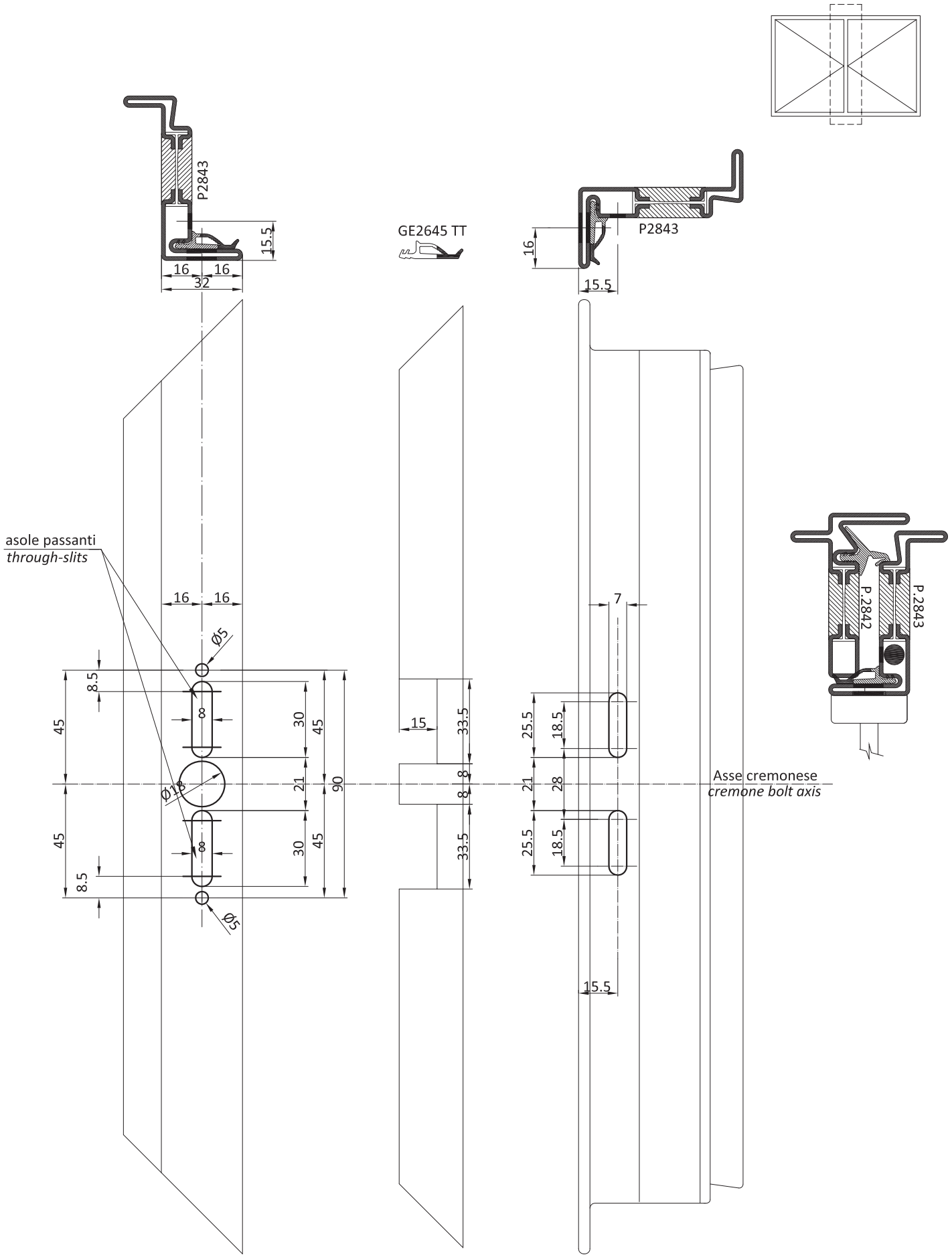

P2620
P.2607
P.2843
P.2803
sigillare per tutta la lunghezza.
seal along the entire length

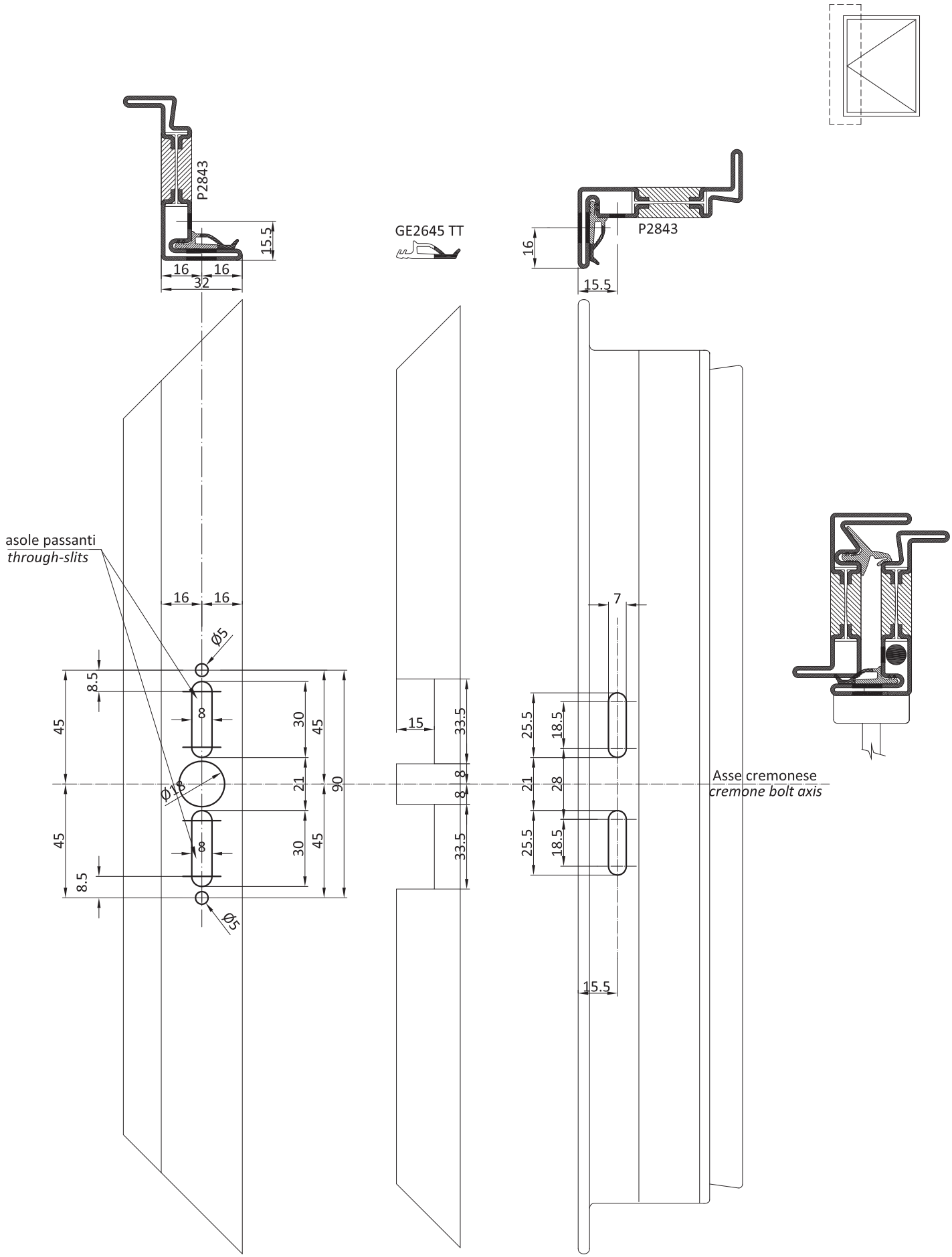


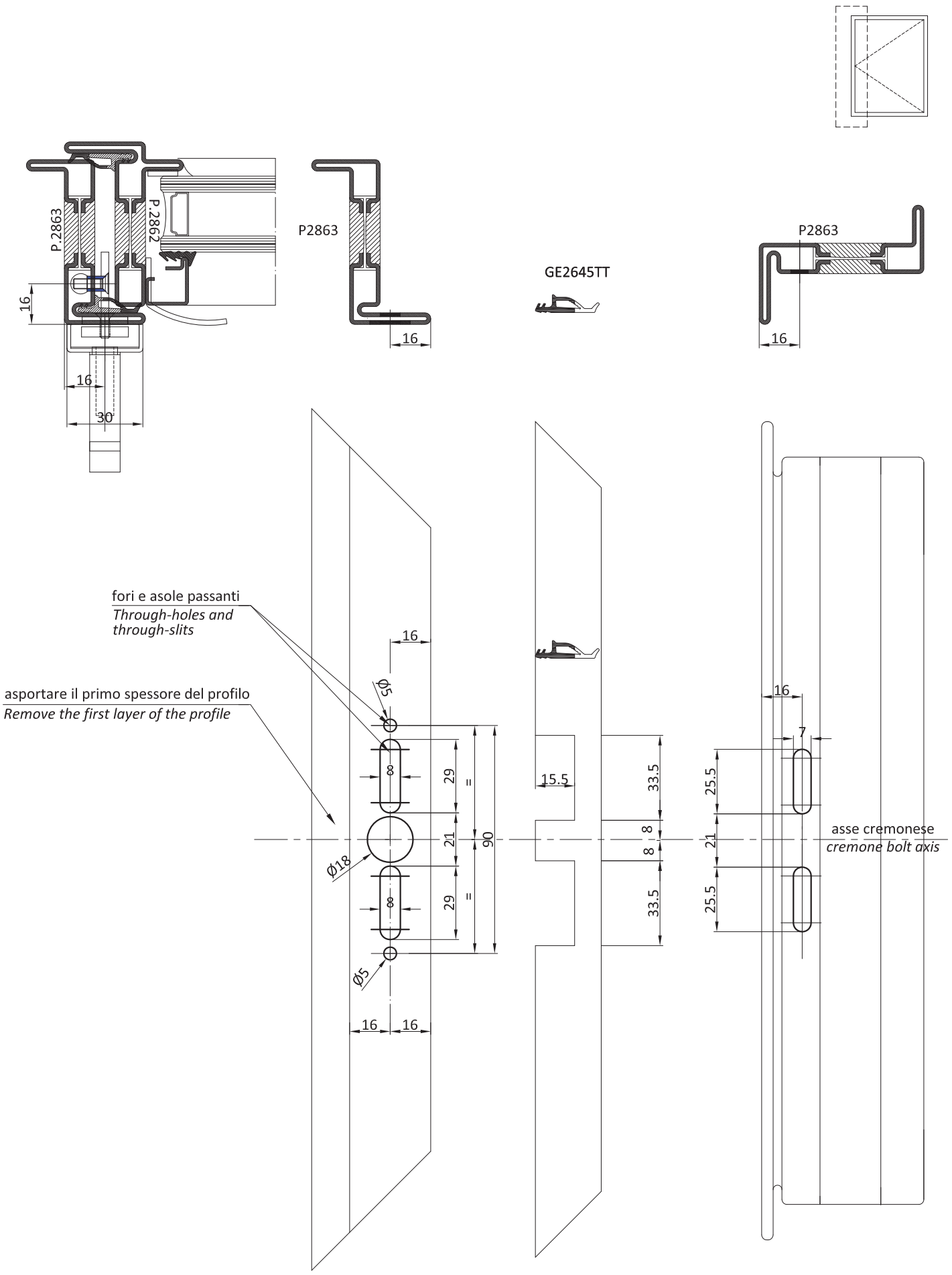


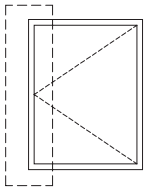

P2833
12
GE2600 TT
P2833
16
asole passanti
through-slits
12
15
9
M4
11.5
45
13
17
30
16.5
20
Ø18
16.5
17
30
45
11.5
M4
12
15
15
33.5
8
8
33.5
7
25.5
18.5
21
28
25.5
18.5
16
asse cremonese
cremone bolt axis
P.2803
P.2833


P.2610
P.2833
16
GE2600 TT
P.2833
16
fori e asole passanti
Through-holes and through-slits
H P2610 = H anta - *H leaf*
50
45
10
Ø22
90
5
Ø5
20
=
9.5
8
21
29
14.5
45
16
10
15
33.5
25.5
18.5
28
7
asse cremonese
cremone bolt axis
P.2632
P.2833

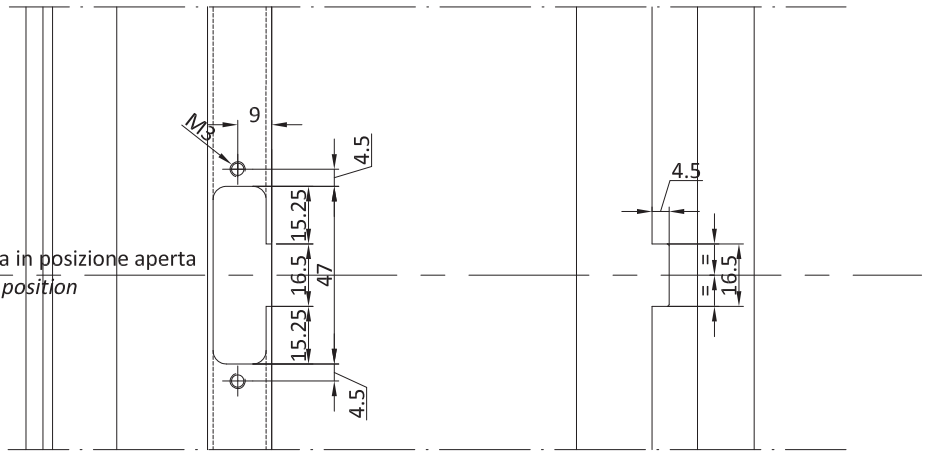

P2843
15.5
16
16
32
GE2645 TT
16
P2843
15.5
asole passanti
through-slits
16
16
Ø5
8.5
45
8
30
45
21
90
Ø18
45
8
30
45
8.5
Ø5
15
33.5
8
8
33.5
25.5
18.5
21
28
25.5
18.5
7
15.5
Asse cremonese
cremone bolt axis
P.2842
P.2843


P2843
15.5
16
16
32
GE2645 TT
16
P2843
15.5
asole passanti
through-slits
16
16
Ø5
8.5
45
8
30
45
21
90
Ø18
45
8
30
45
8.5
Ø5
15
33.5
8
8
33.5
7
25.5
18.5
21
28
25.5
18.5
Asse cremonese
cremone bolt axis
15.5

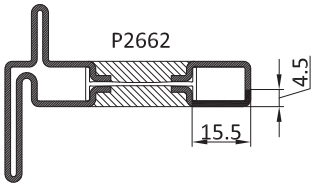

P.2863
P.2862
16
16
30
P2863
16
GE2645TT
P2863
16
fori e asole passanti
Through-holes and through-slits
asportare il primo spessore del profilo
Remove the first layer of the profile
16
Ø5
29
=
21
90
Ø18
29
=
Ø5
16
16
15.5
33.5
8
8
33.5
16
7
25.5
21
25.5
asse cremonese
cremone bolt axis

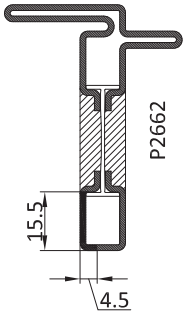


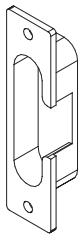
lavorazione applicazione incontro
Processing for strike plate installation



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

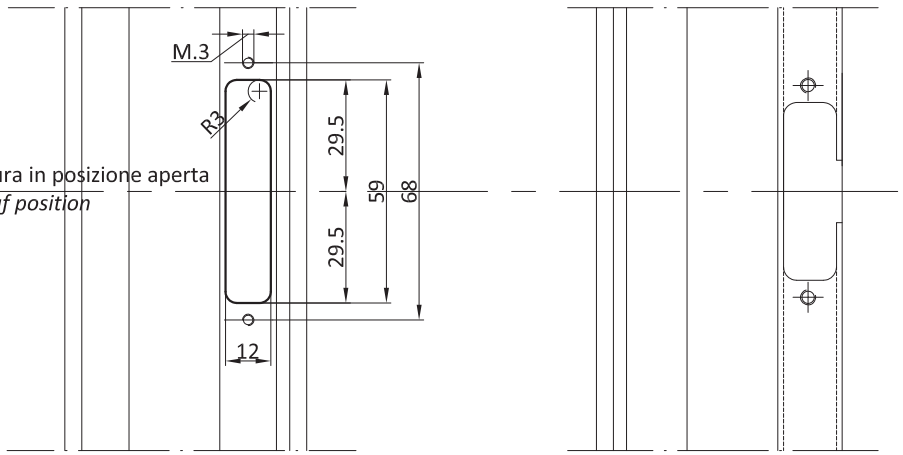




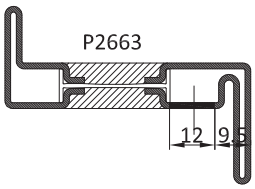


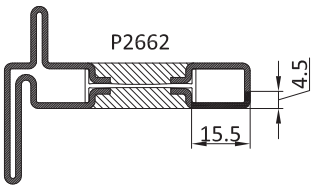
Incontro 3^ chiusura
3rd lock strike plate

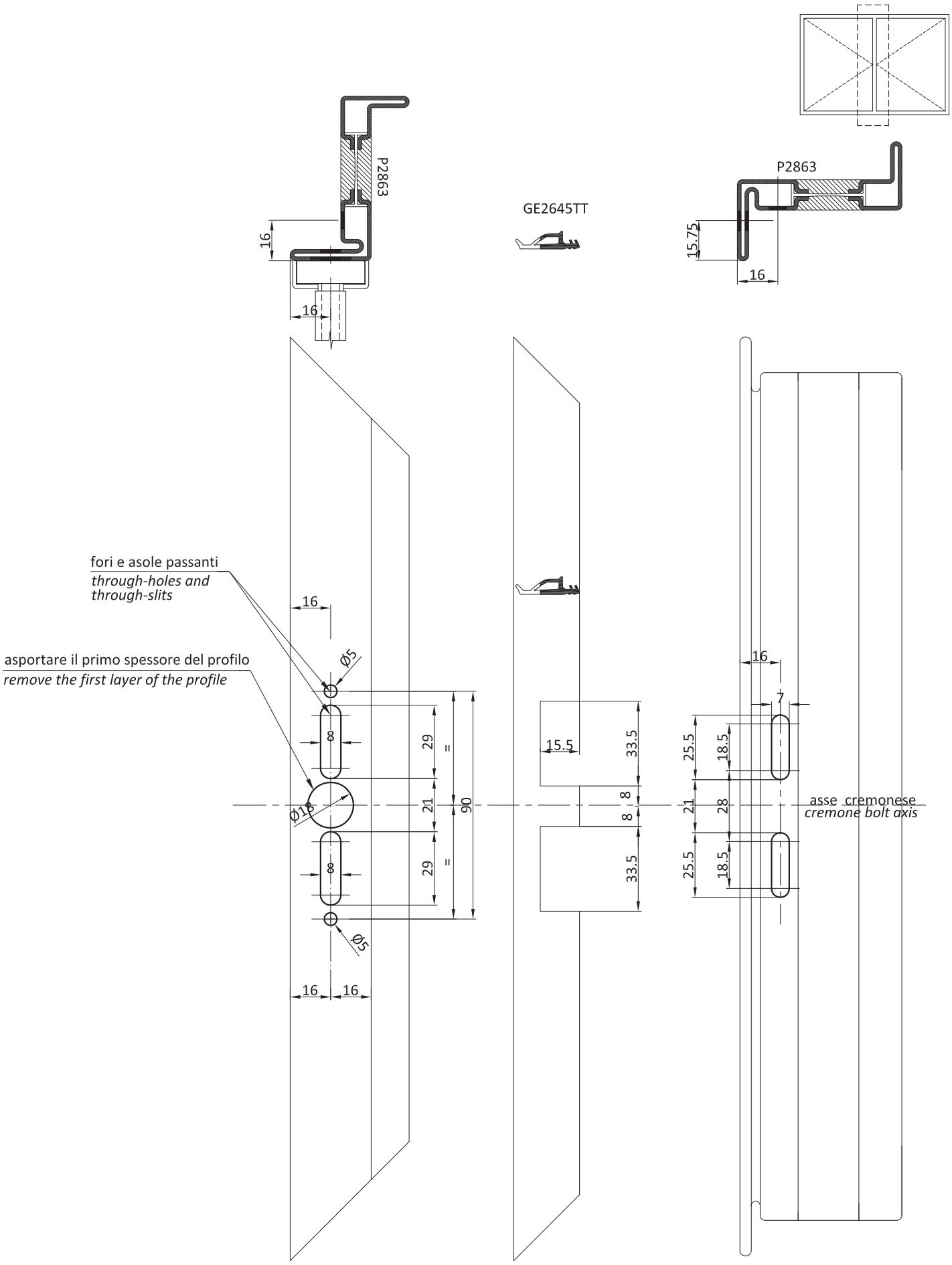
lavorazione applicazione nottolino
Processing for plug installation

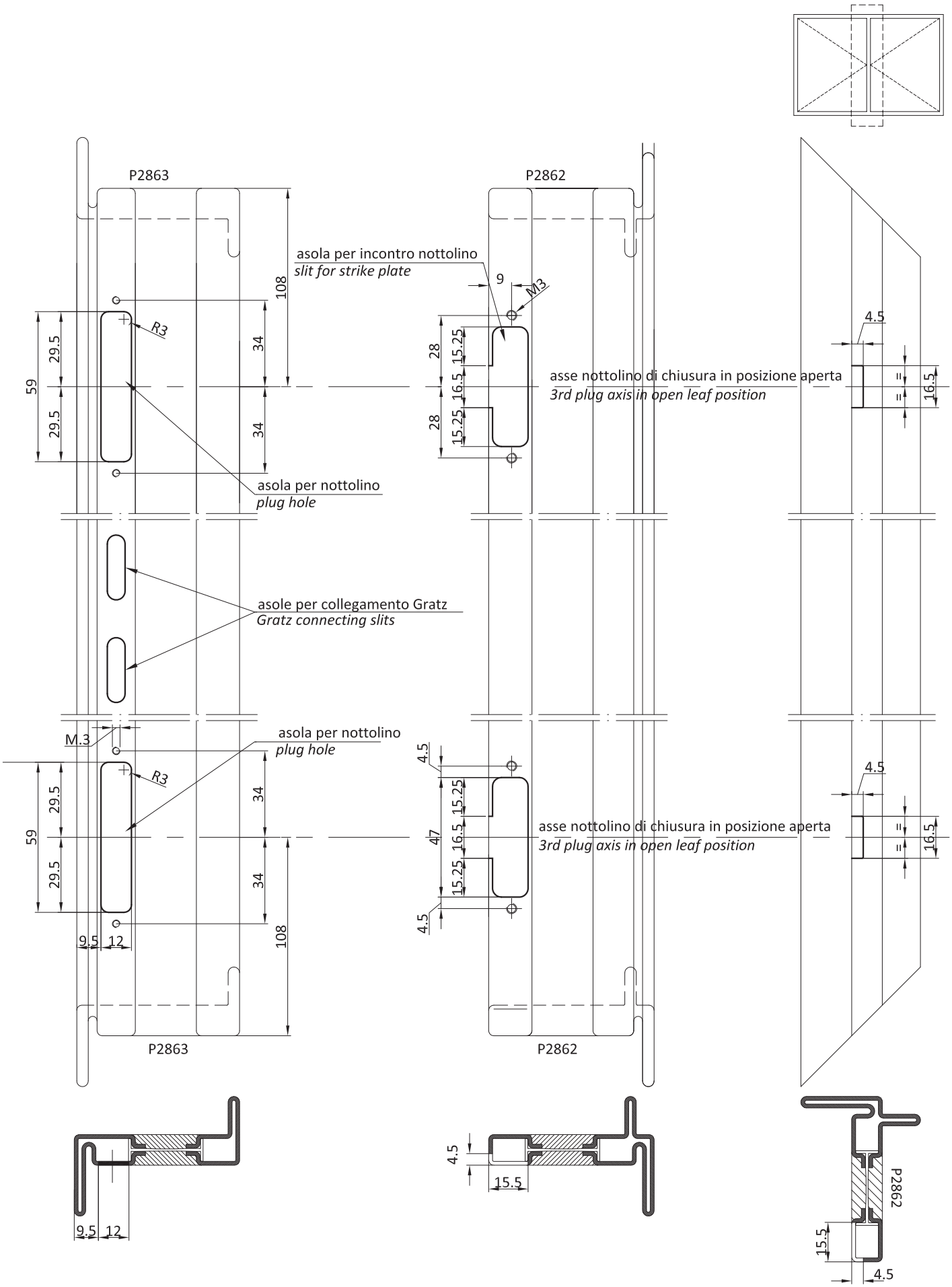


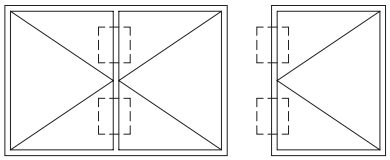
asse nottolino 3^ chiusura in posizione aperta
3rd plug axis in open leaf position



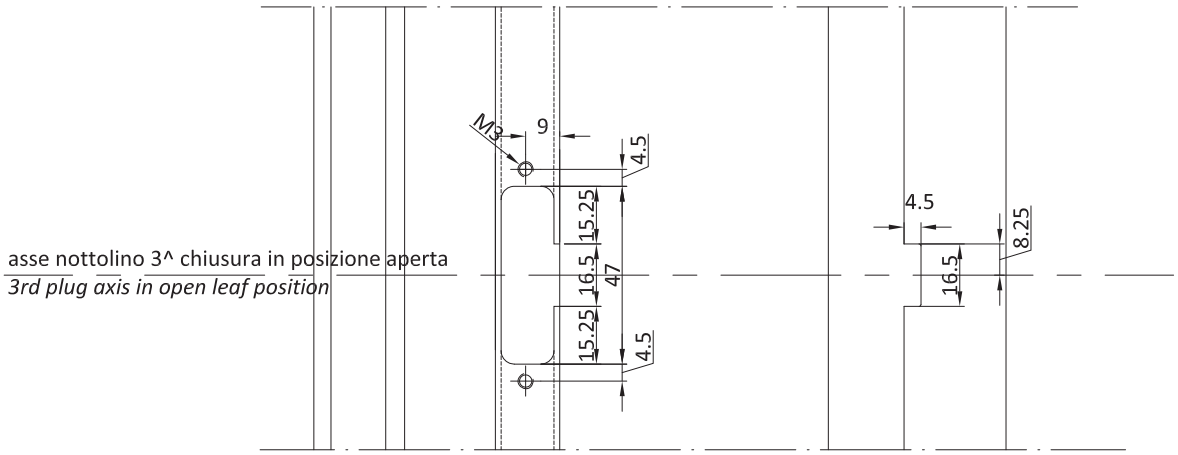


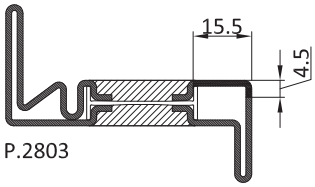

P2863
16
16
GE2645TT
P2863
15.75
16
fori e asole passanti
through-holes and through-slits
asportare il primo spessore del profilo
remove the first layer of the profile
16
Ø5
8
29
=
21
90
Ø18
8
29
=
Ø5
16
16
15.5
33.5
8
8
33.5
16
7
25.5
18.5
21
28
25.5
18.5
asse cremonese
cremone bolt axis

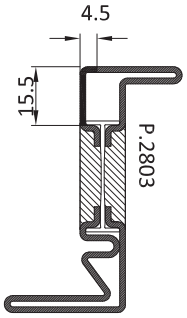

P2863
P2862
asola per incontro nottolino
slit for strike plate
9
M3
108
R3
29.5
34
59
28
15.25
16.5
4.5
asse nottolino di chiusura in posizione aperta
3rd plug axis in open leaf position
asola per nottolino
plug hole
asole per collegamento Gratz
Gratz connecting slits
M.3
47
9.5
12
15.5

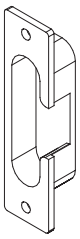


lavorazione applicazione incontro
Processing for the installation of the strike plate



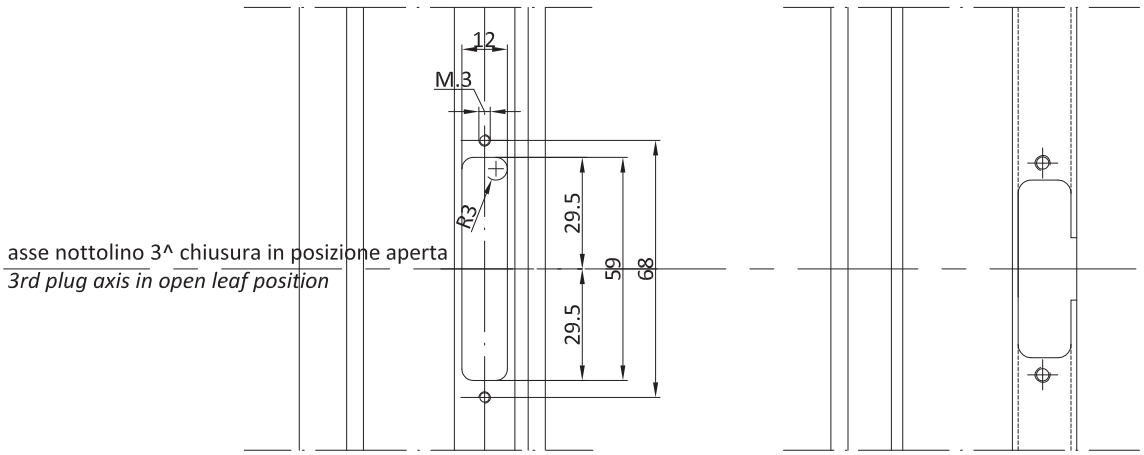


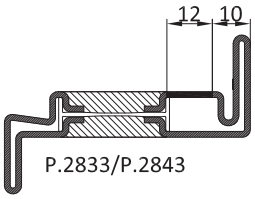


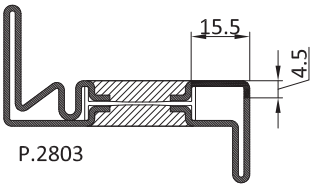


Incontro 3^ chiusura
3rd lock strike plate

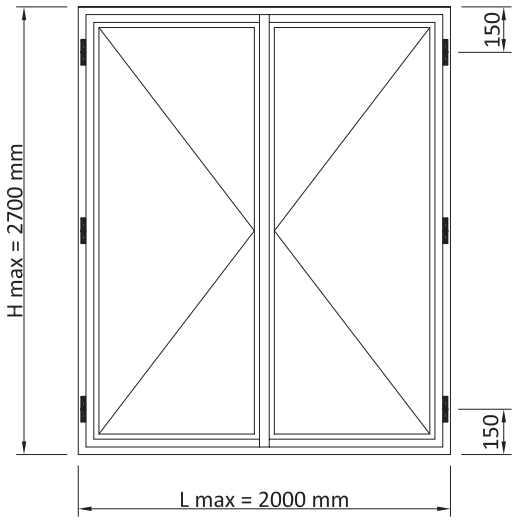
lavorazione applicazione nottolino
Processing for plug installation

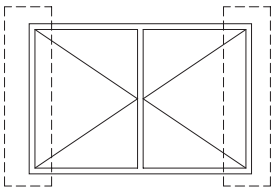


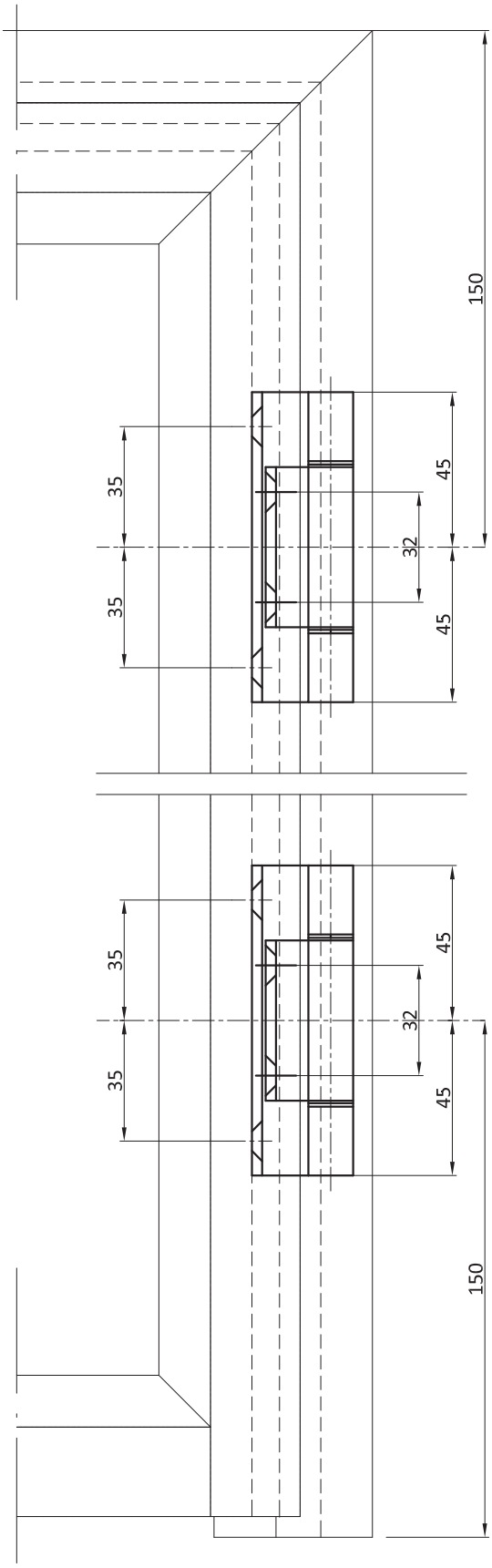


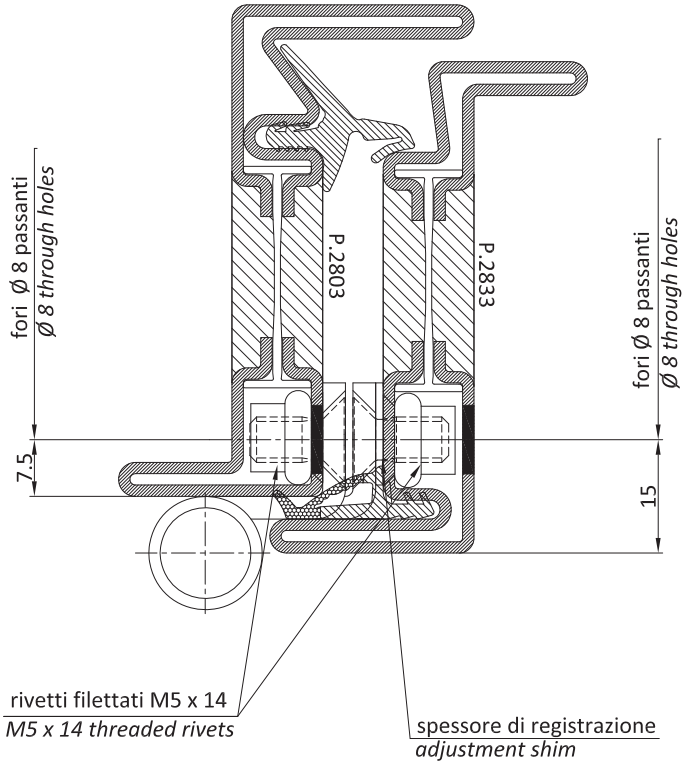


Cerniera centrale per H > 1400 mm - peso max. per anta 100 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 100 kg.

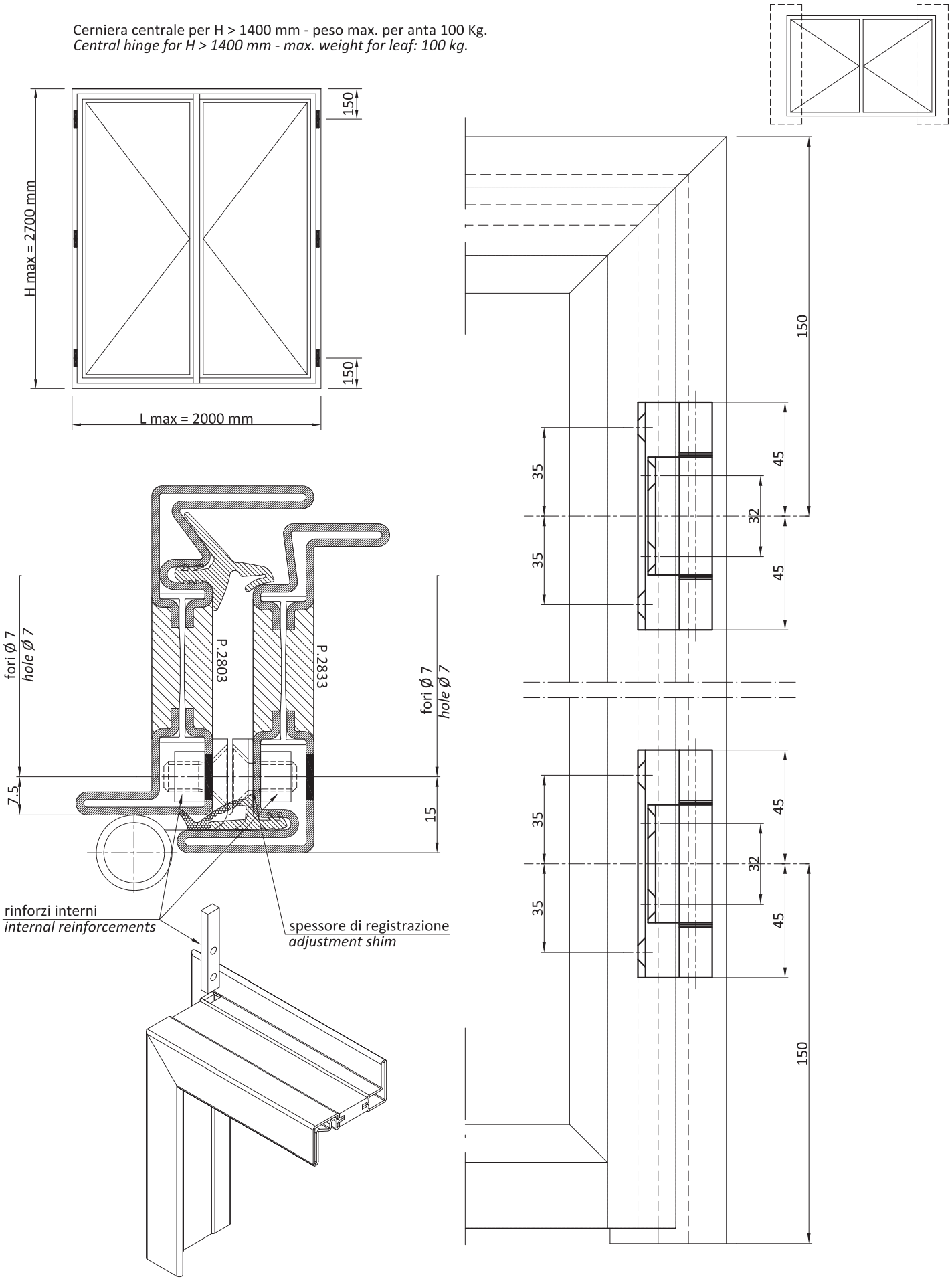




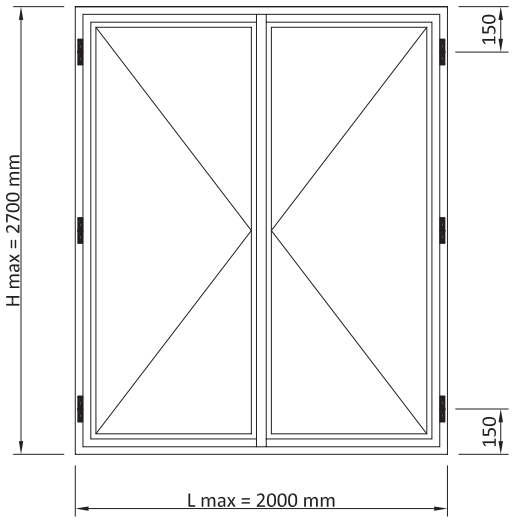


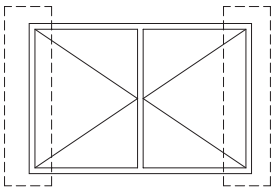


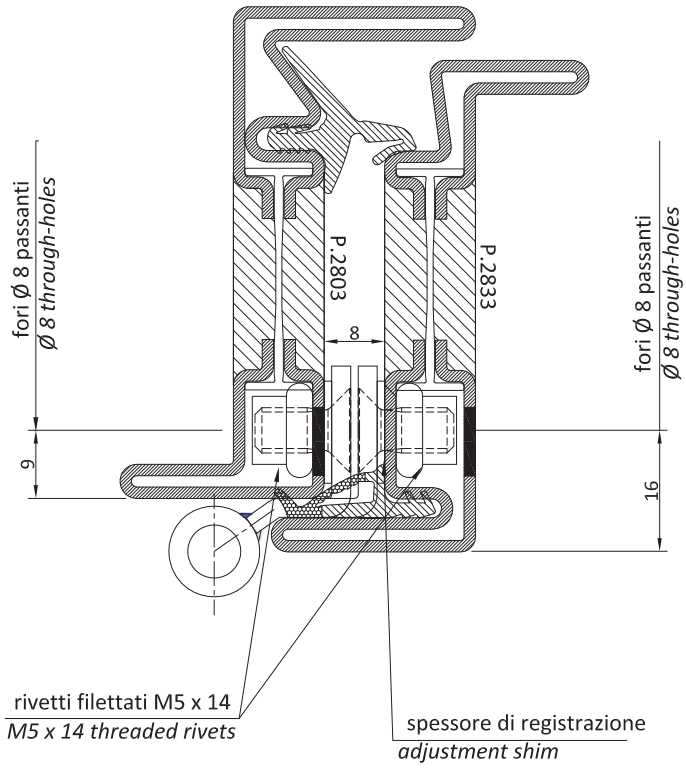
Cerniera centrale per H > 1400 mm - peso max. per anta 100 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 100 kg.

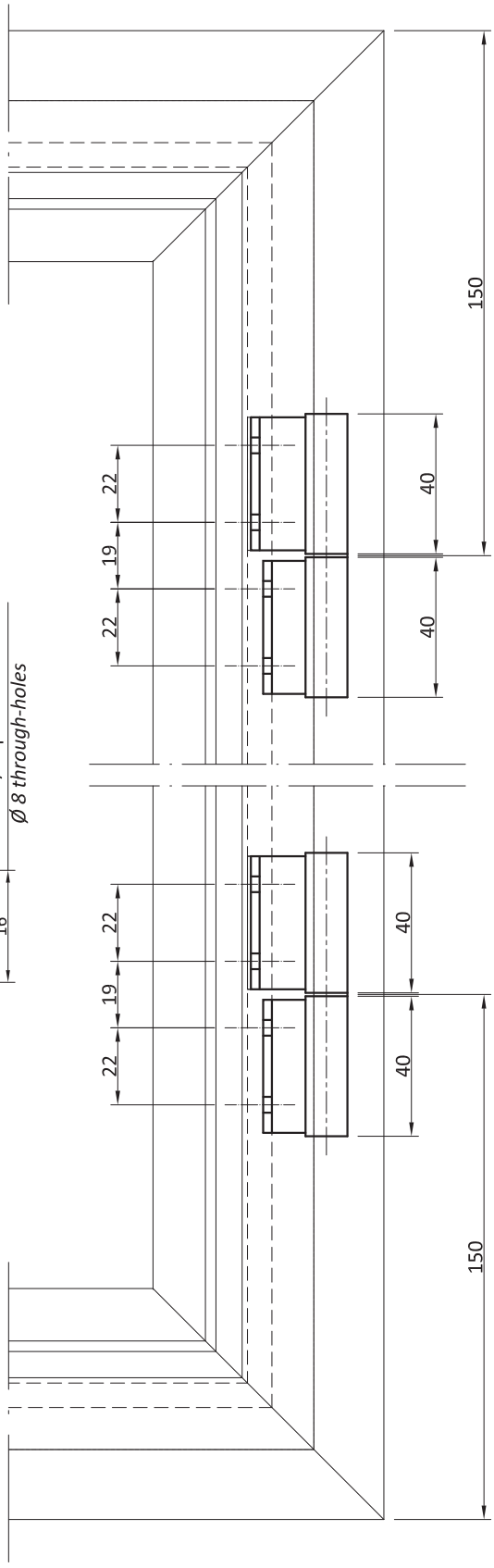


Cerniera centrale per H > 1400 mm - peso max. per anta 50 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 50 kg.

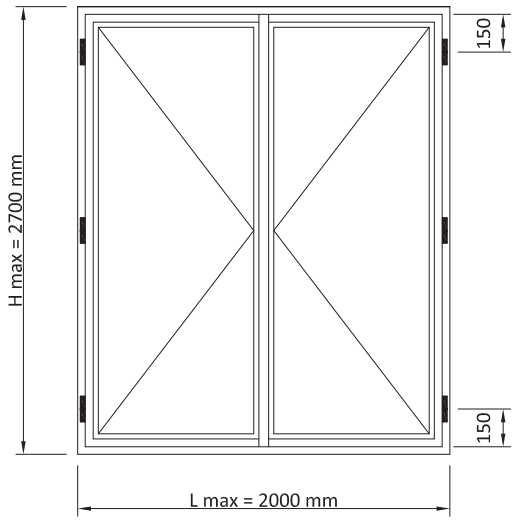


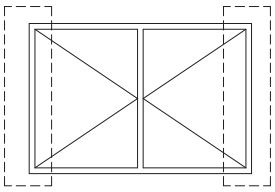


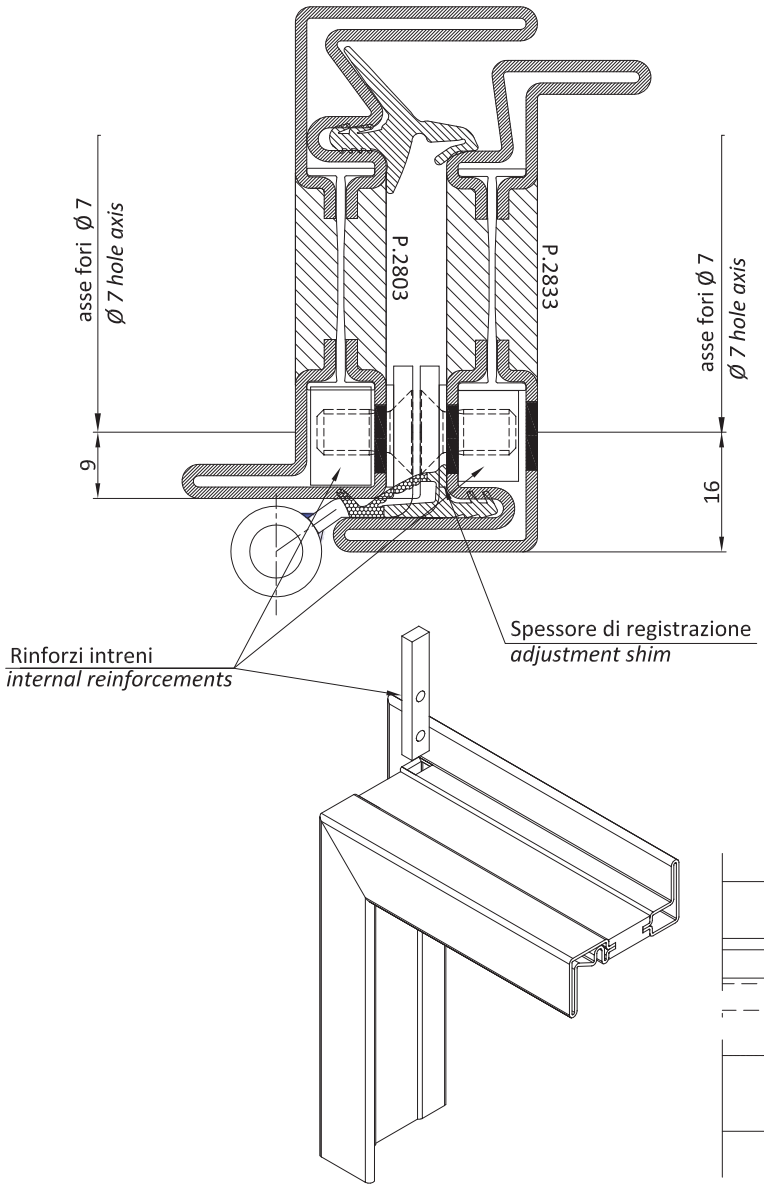


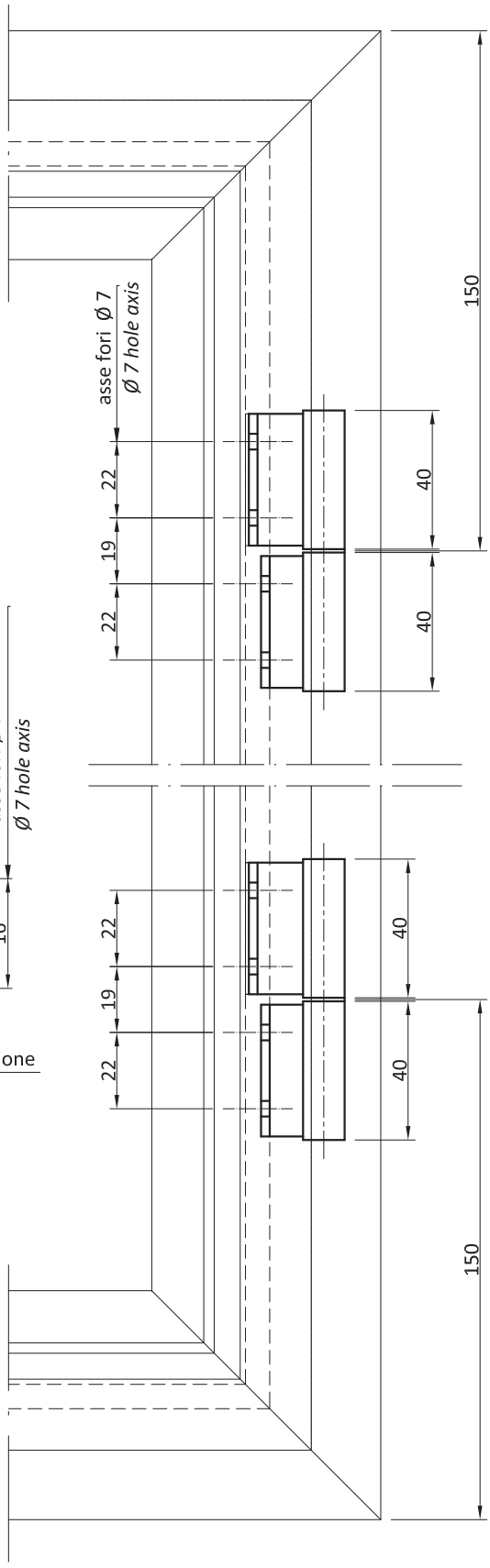


Cerniera centrale per H > 1400 mm - peso max. per anta 50 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 50 kg.

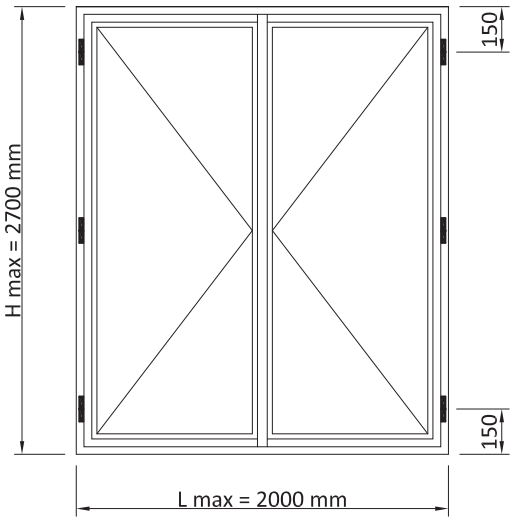


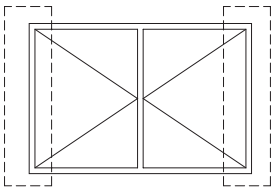


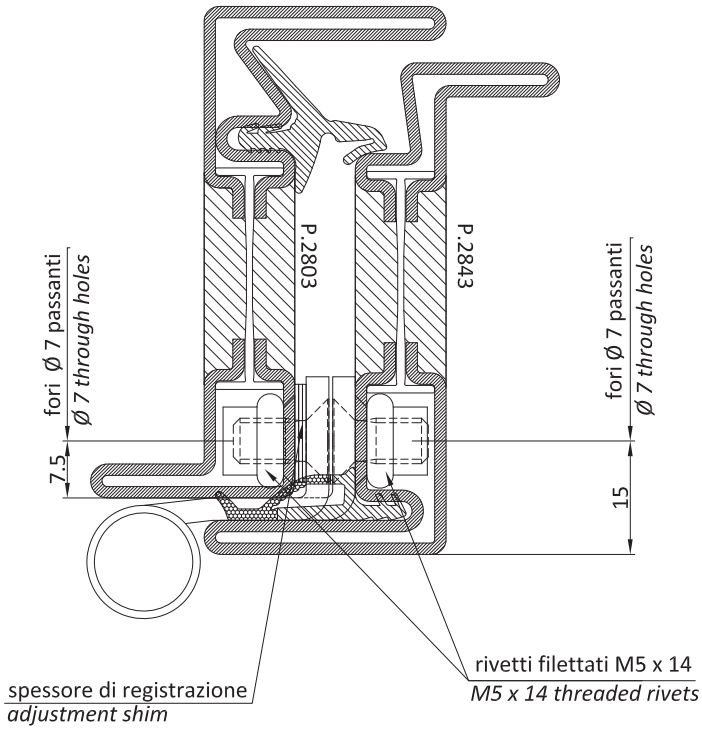


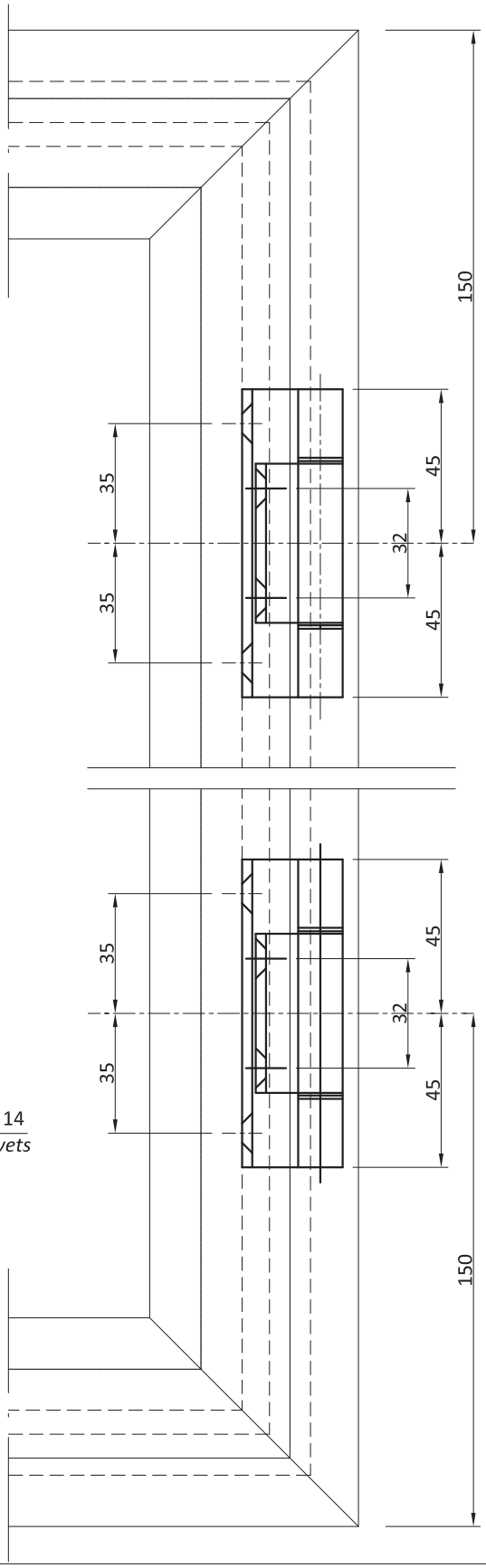


Cerniera centrale per H > 1400 mm - peso max. per anta 100 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 100 kg.

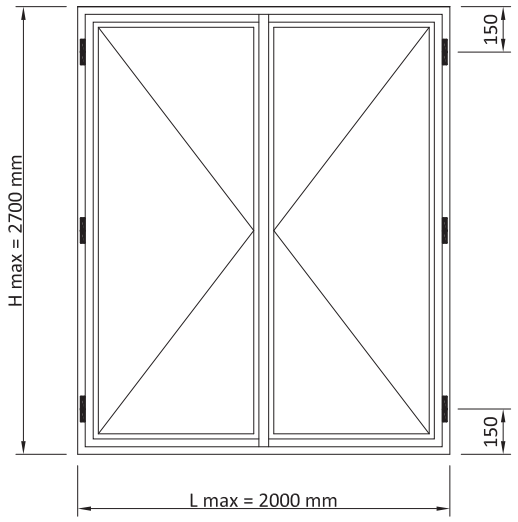


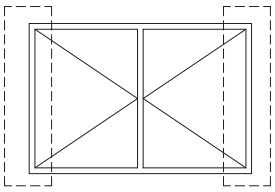


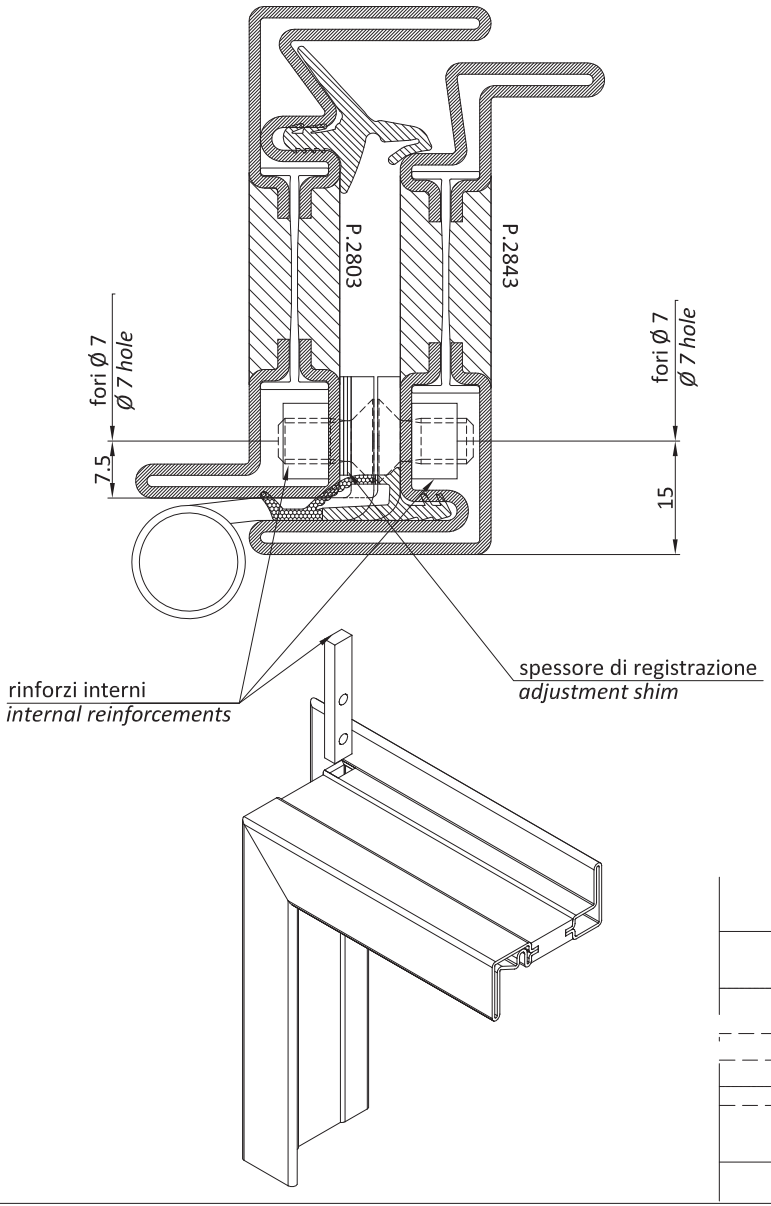


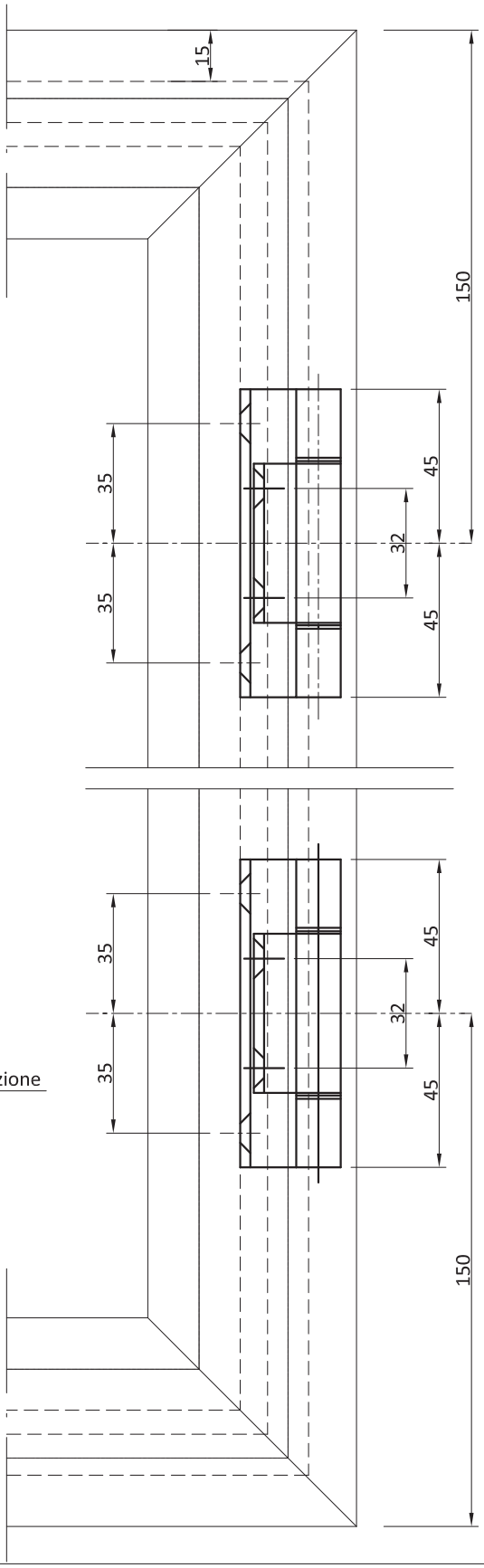


Cerniera centrale per H > 1400 mm - peso max. per anta 100 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 100 kg.

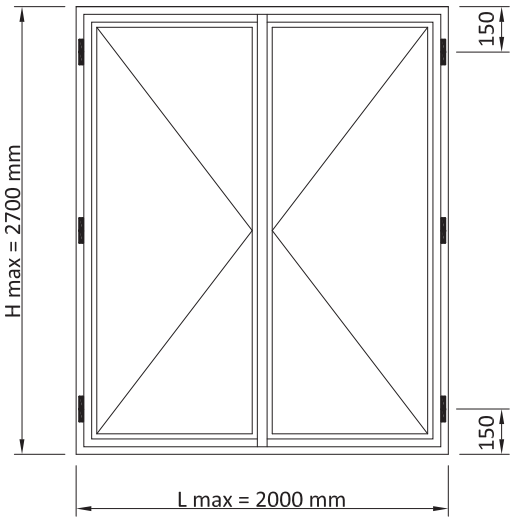


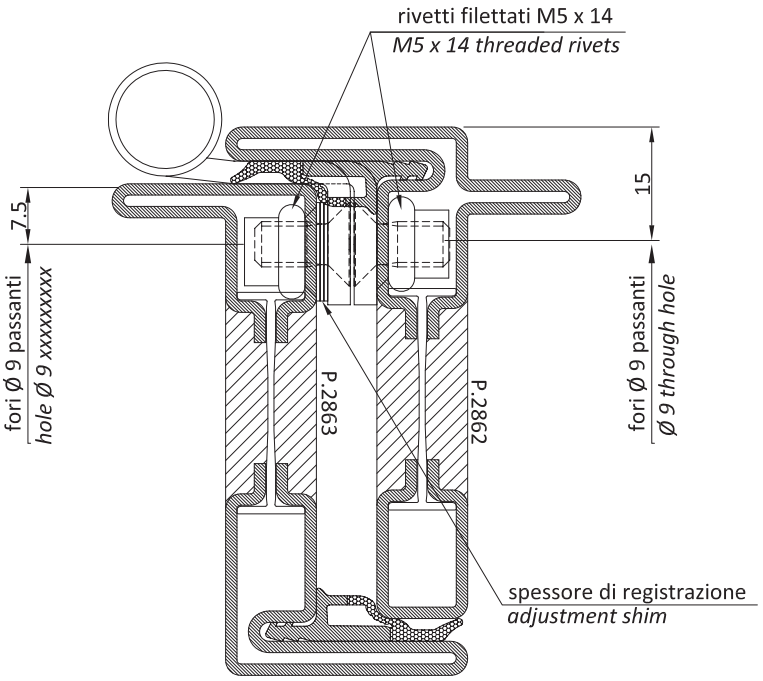


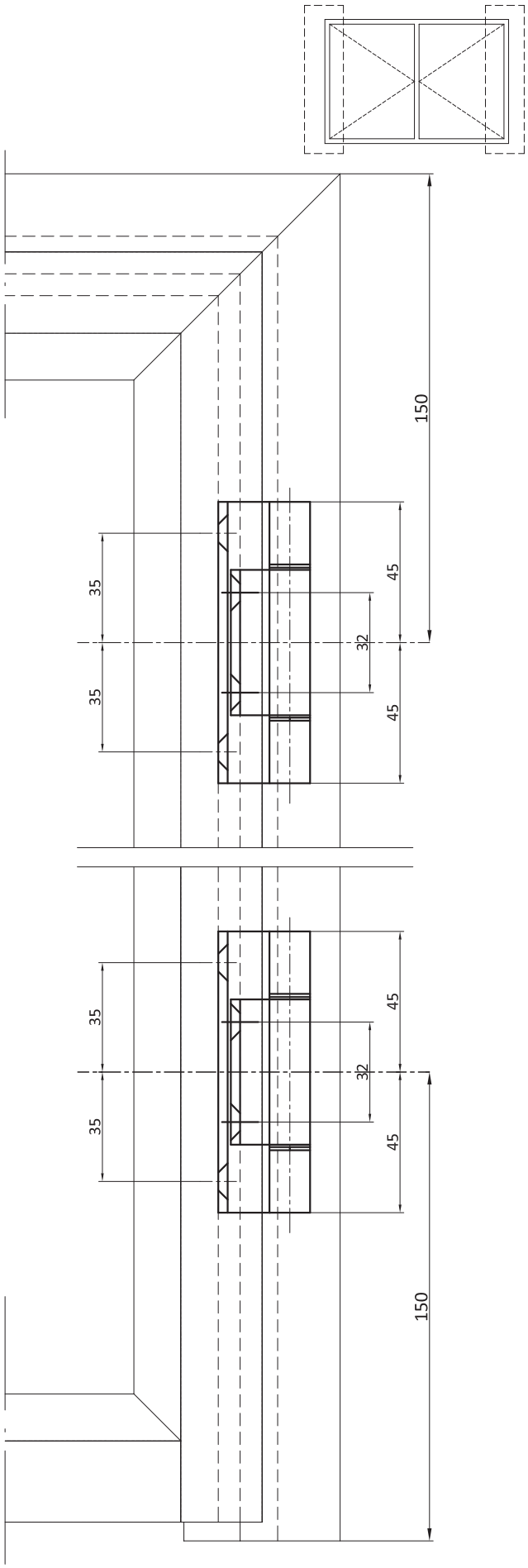




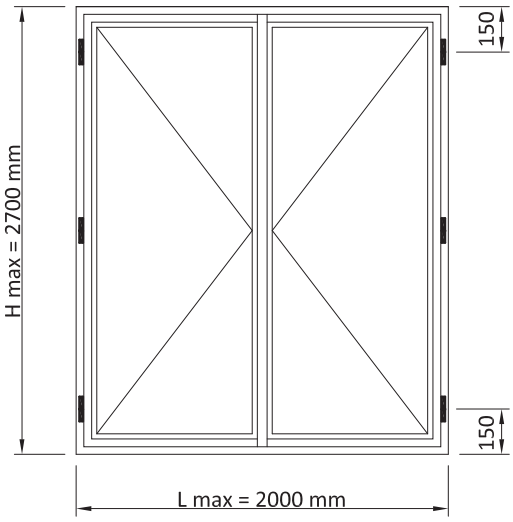
Cerniera centrale per H > 1400 mm - peso max. per anta 100 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 100 kg.

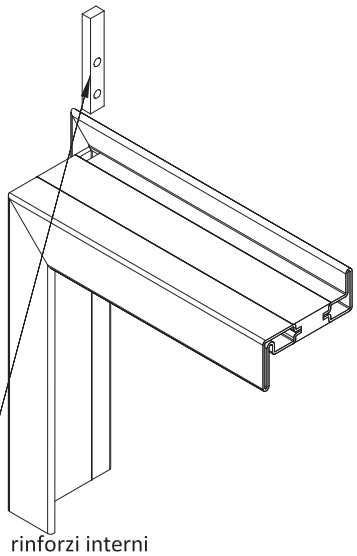


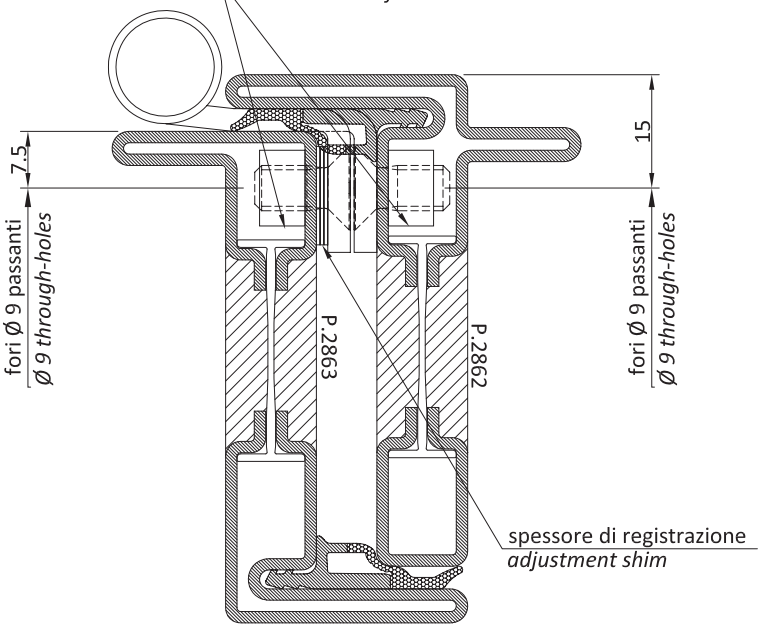


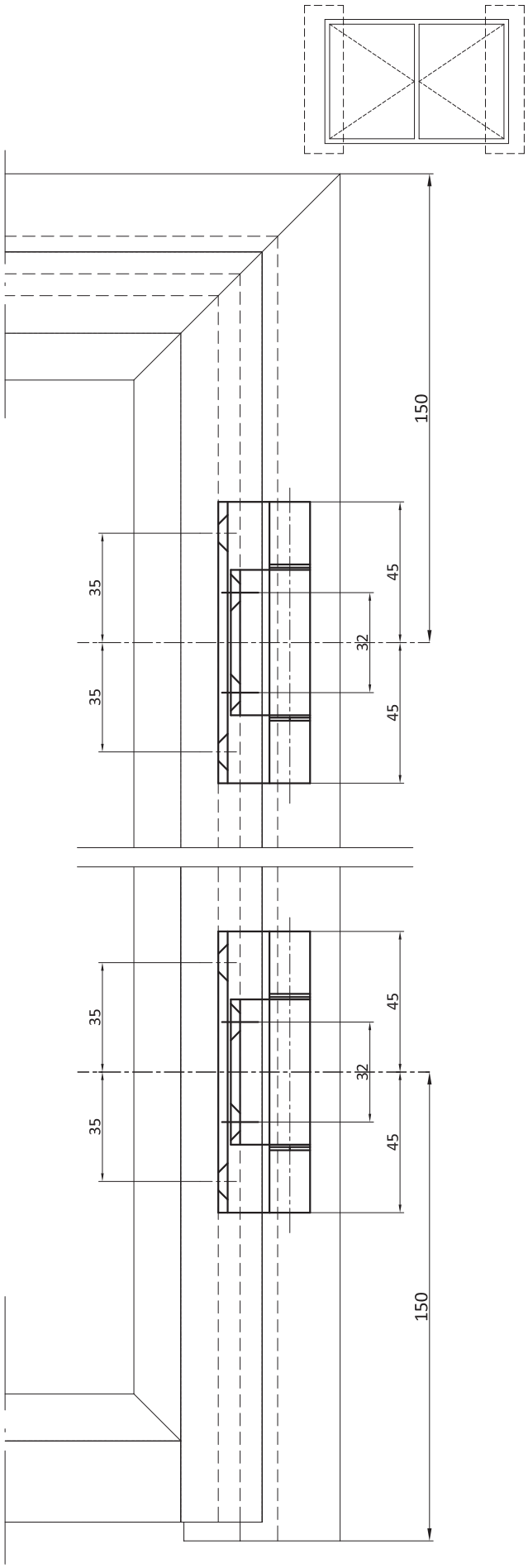


Cerniera centrale per H > 1400 mm - peso max. per anta 100 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 100 kg.

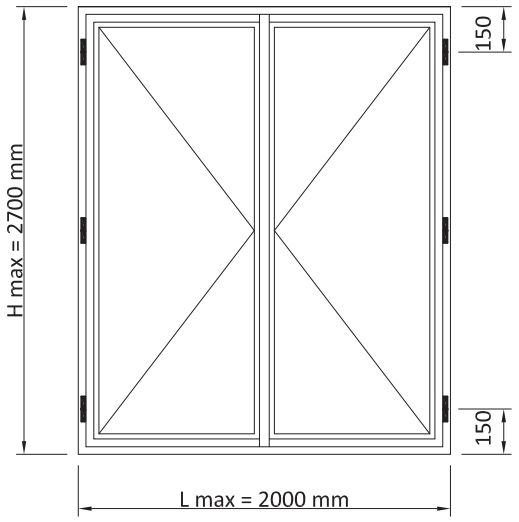


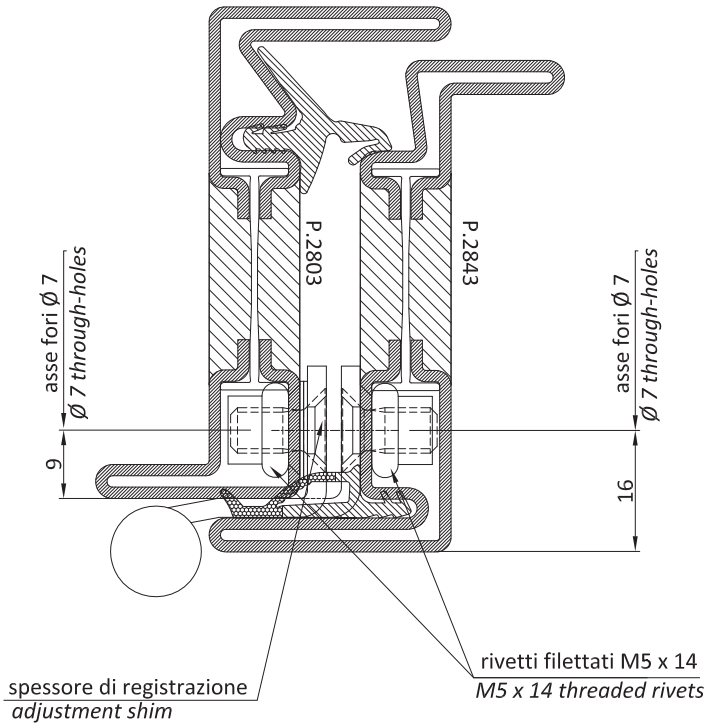


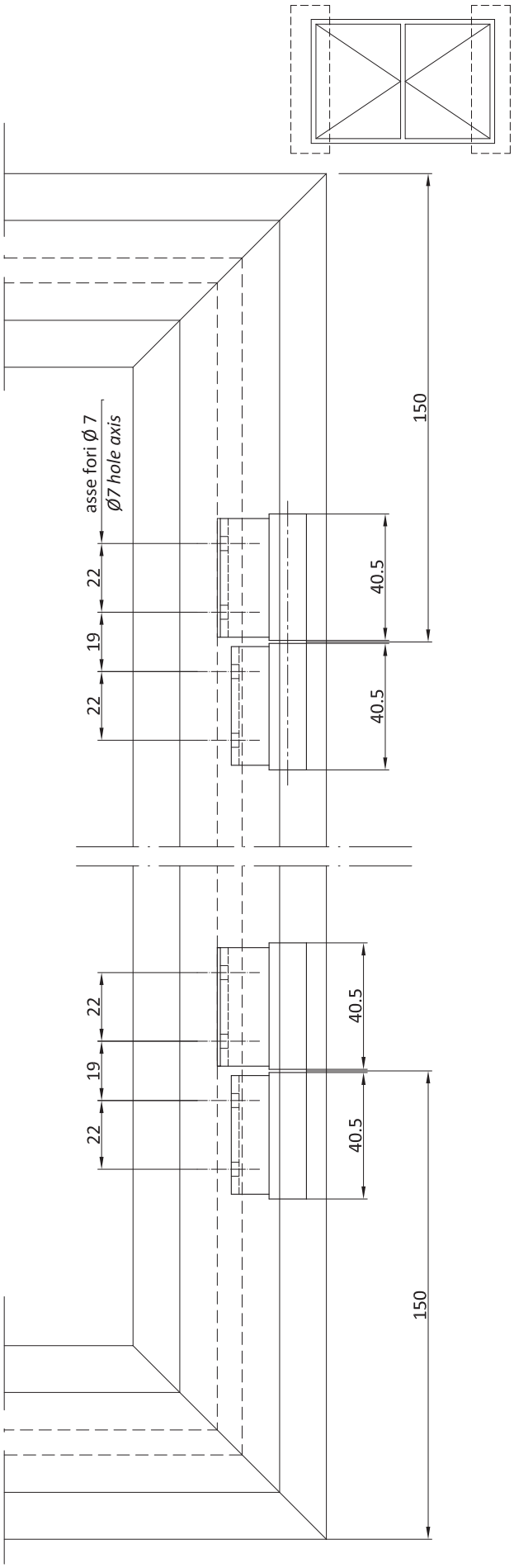




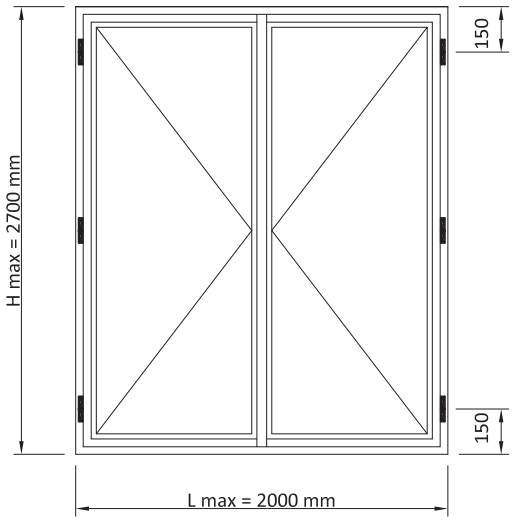
Cerniera centrale per H > 1400 mm - peso max. per anta 50 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 50 kg.

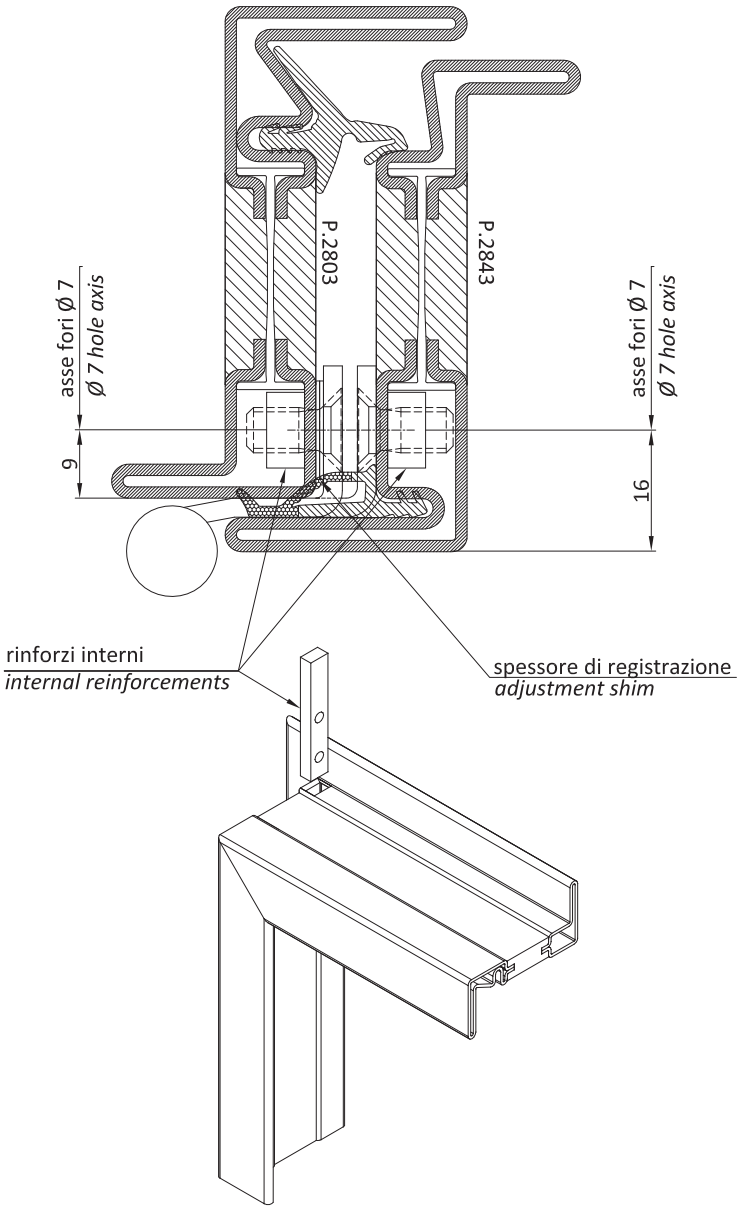


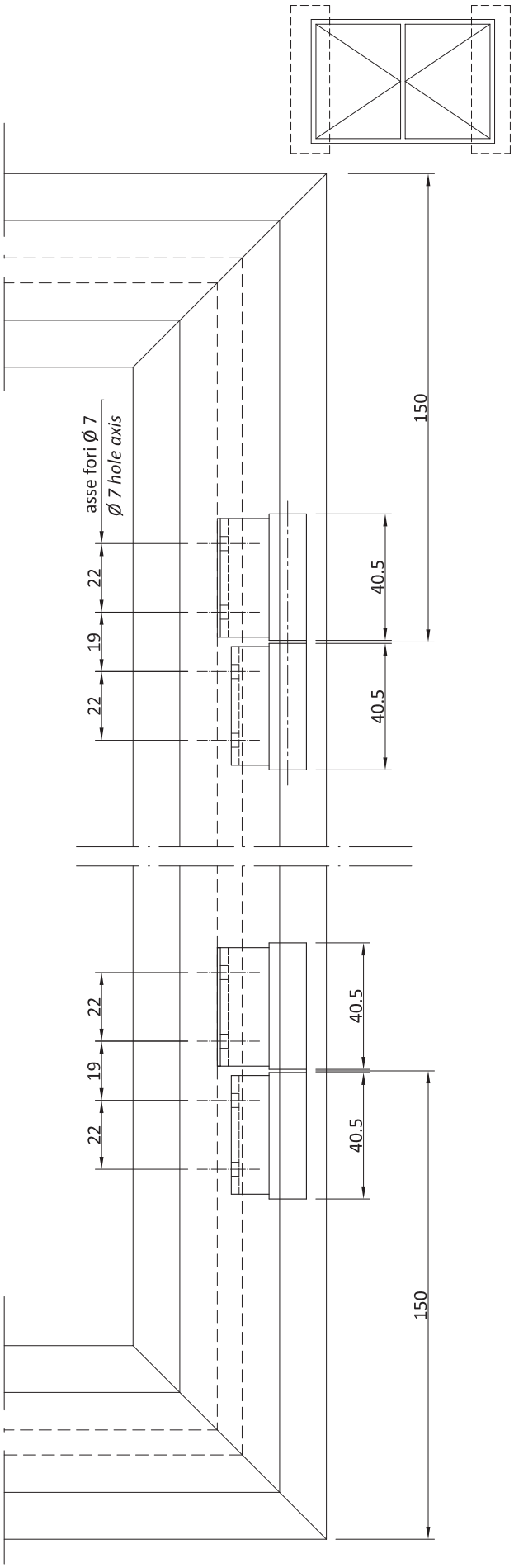




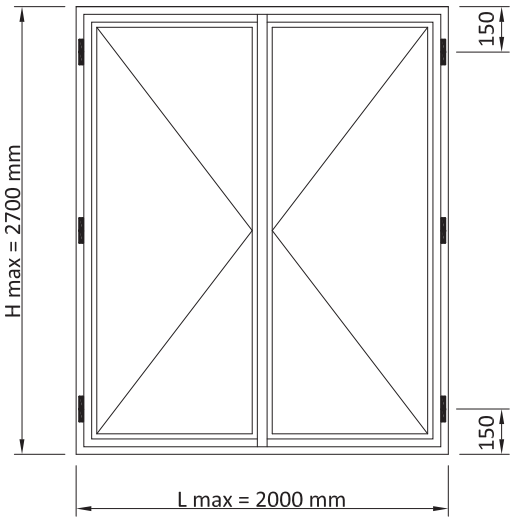
Cerniera centrale per H > 1400 mm - peso max. per anta 50 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 50 kg.

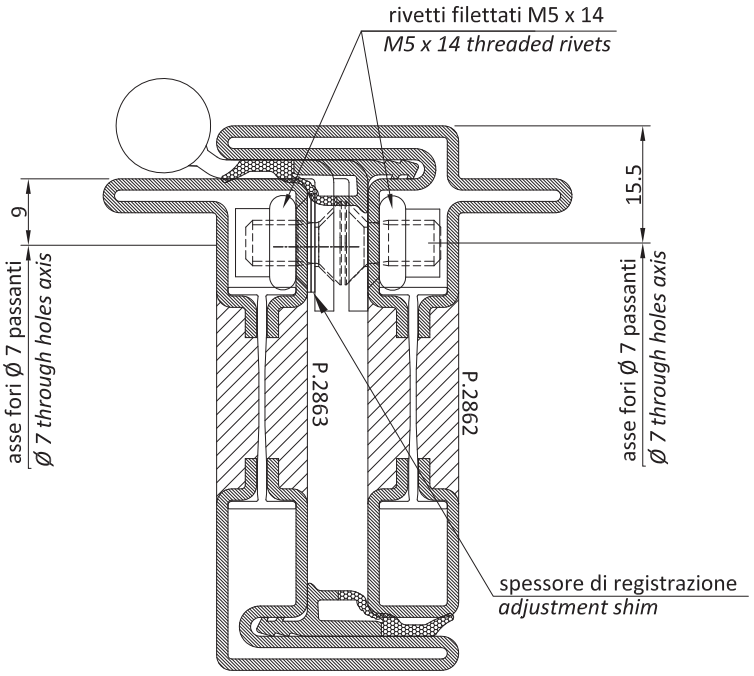


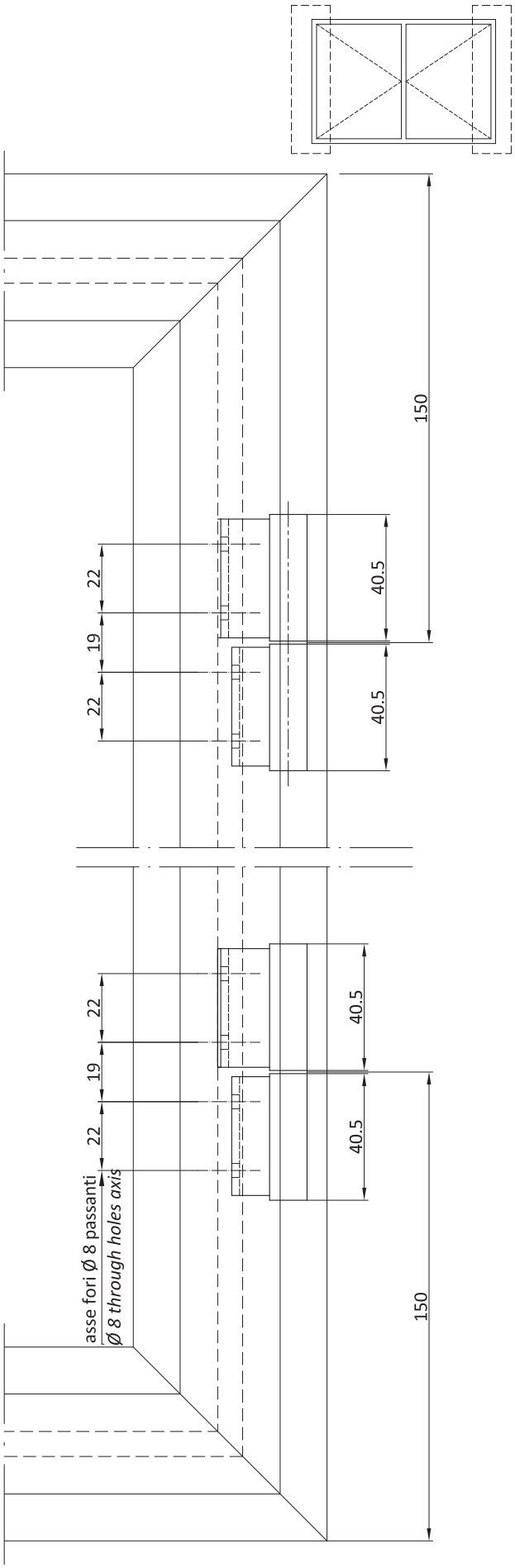




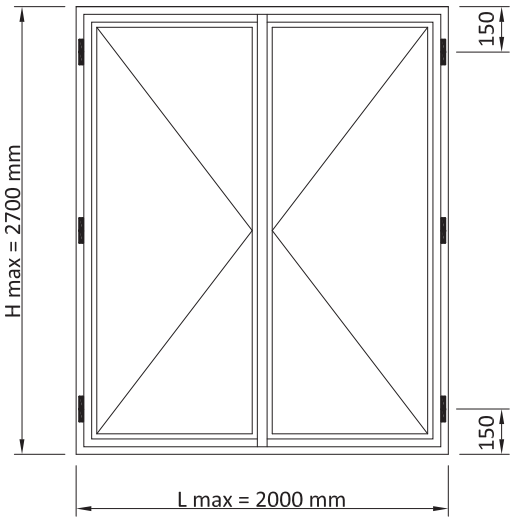
Cerniera centrale per H > 1400 mm - peso max. per anta 50 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 50 kg.

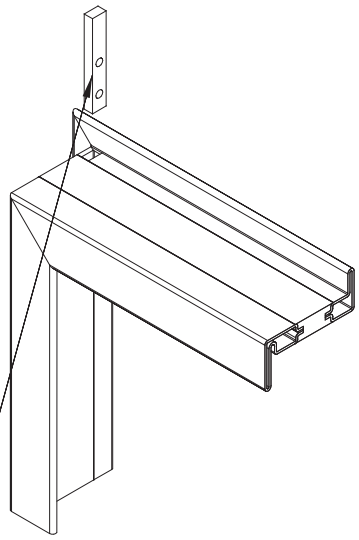


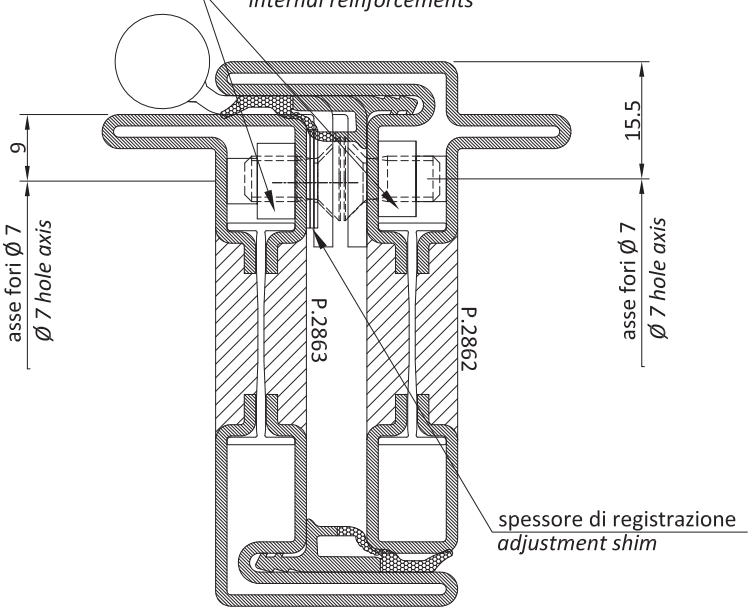


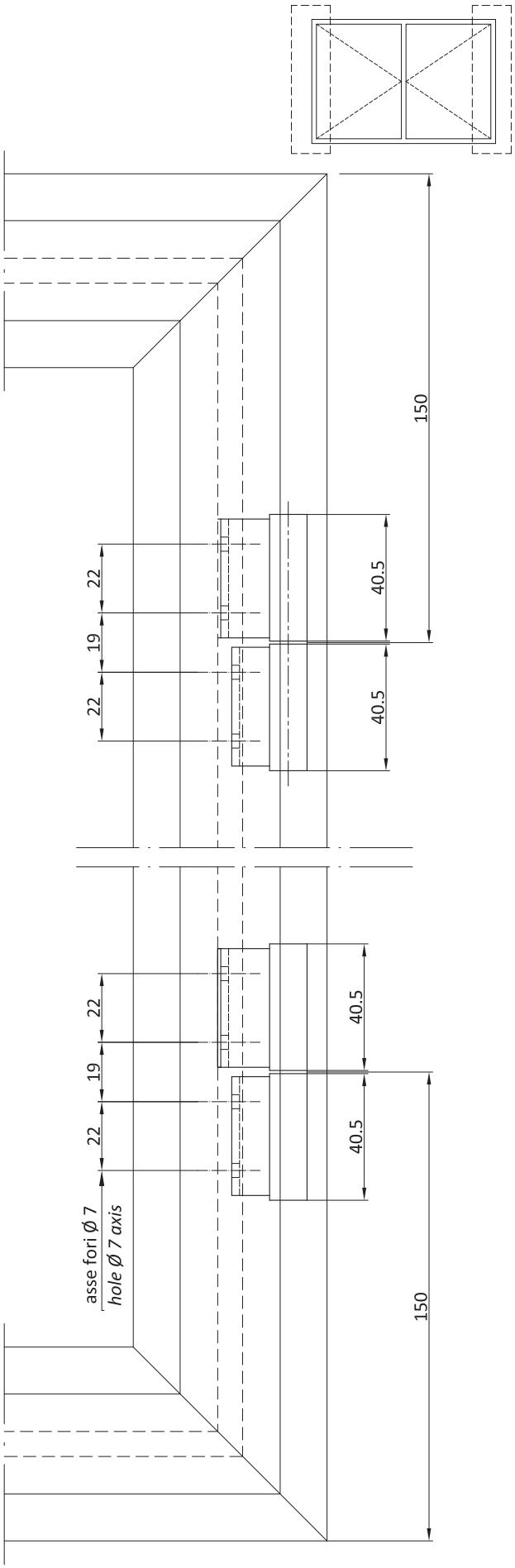


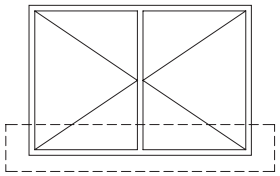
Cerniera centrale per H > 1400 mm - peso max. per anta 50 Kg.
Central hinge for H > 1400 mm - max. weight for leaf: 50 kg.

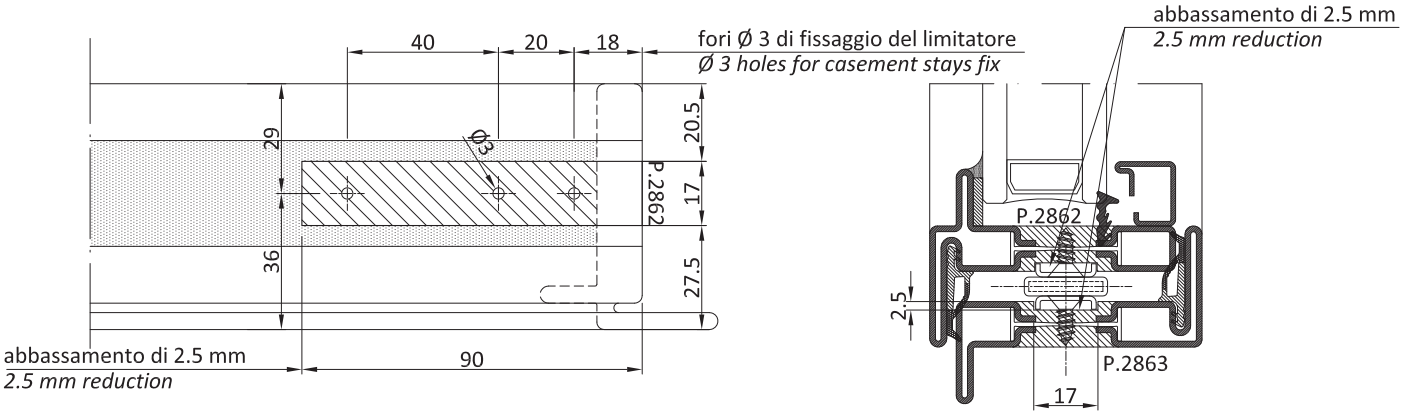


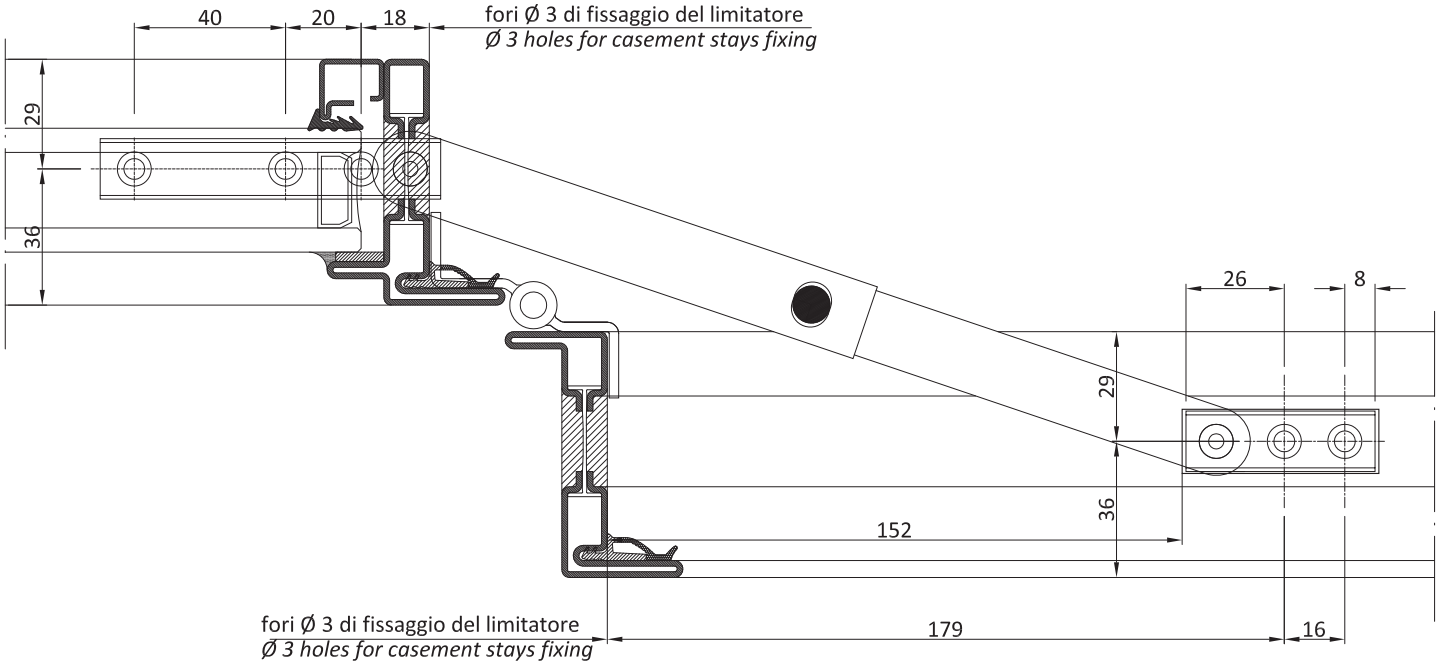


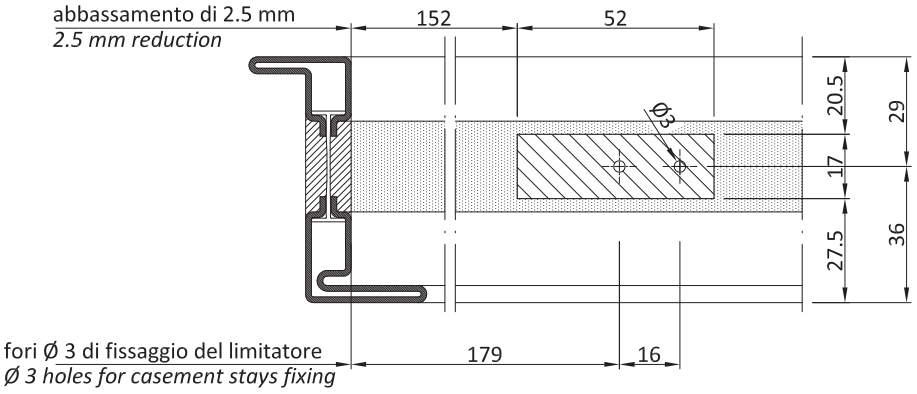


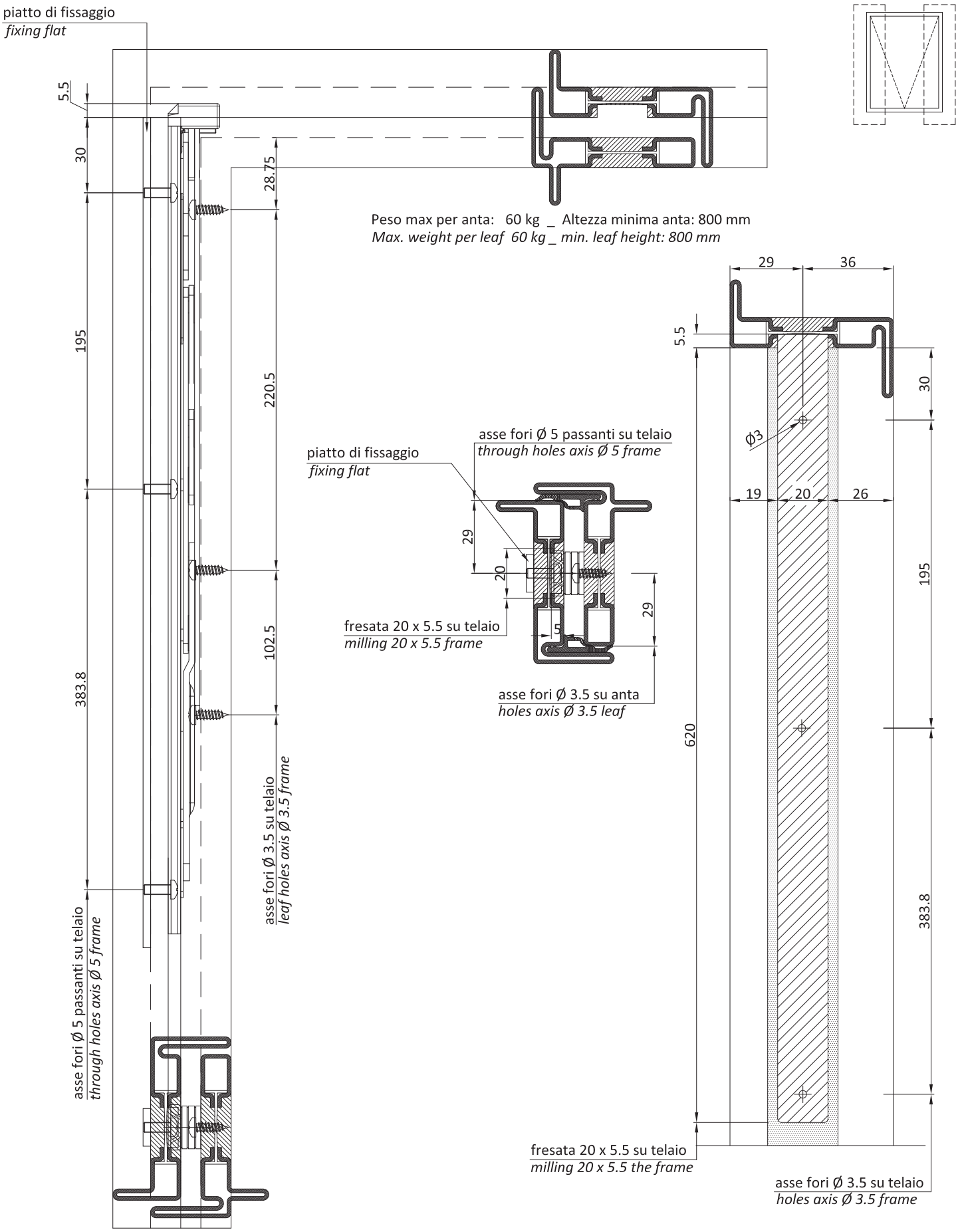




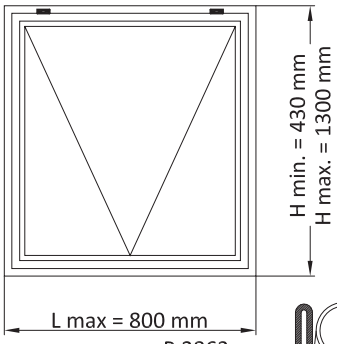

40
20
18
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fix
abbassamento di 2.5 mm
2.5 mm reduction
29
36
Ø3
P.2862
20.5
17
27.5
90
P.2862
P.2863
2.5
17

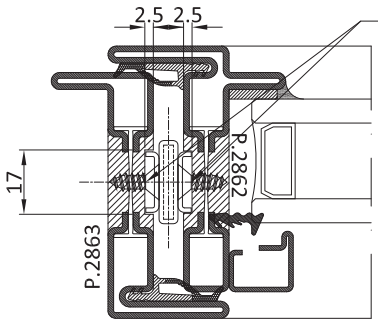

40
20
18
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fixing
29
36
26
8
29
36
152
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fixing
179
16

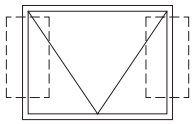

abbassamento di 2.5 mm
2.5 mm reduction
152
52
Ø3
20.5
17
27.5
29
36
fori Ø 3 di fissaggio del limitatore
Ø 3 holes for casement stays fixing
179
16

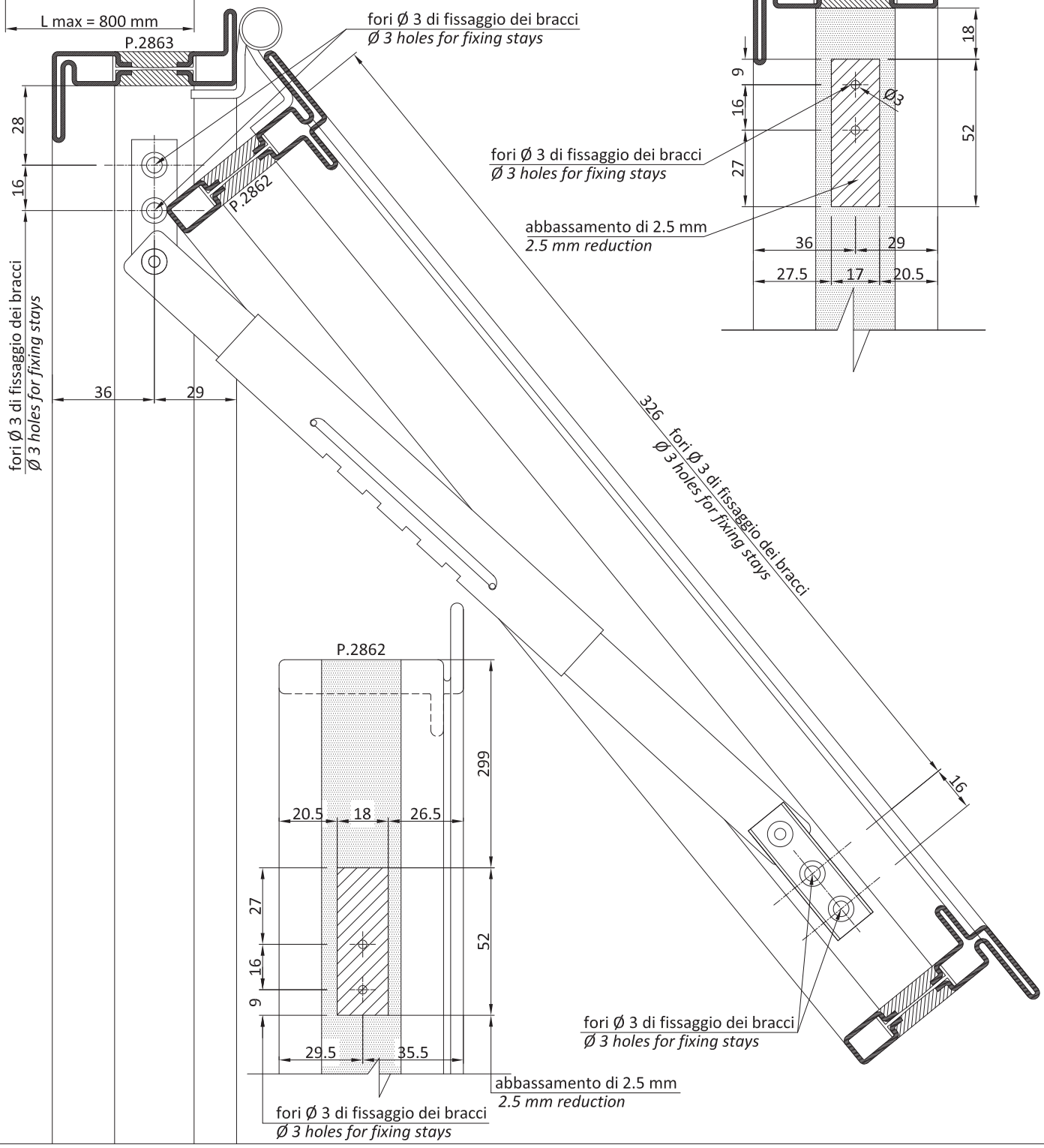

piatto di fissaggio
fixing flat
5.5
30
195
383.8
28.75
220.5
102.5
asse fori Ø 3.5 su telaio
leaf holes axis Ø 3.5 frame
asse fori Ø 5 passanti su telaio
through holes axis Ø 5 frame
Peso max per anta: 60 kg _ Altezza minima anta: 800 mm
Max. weight per leaf 60 kg _ min. leaf height: 800 mm
asse fori Ø 5 passanti su telaio
through holes axis Ø 5 frame
piatto di fissaggio
fixing flat
29
20
fresata 20 x 5.5 su telaio
milling 20 x 5.5 frame
29
asse fori Ø 3.5 su anta
holes axis Ø 3.5 leaf
29
36
5.5
30
Ø3
19
20
26
195
620
383.8
fresata 20 x 5.5 su telaio
milling 20 x 5.5 the frame
asse fori Ø 3.5 su telaio
holes axis Ø 3.5 frame

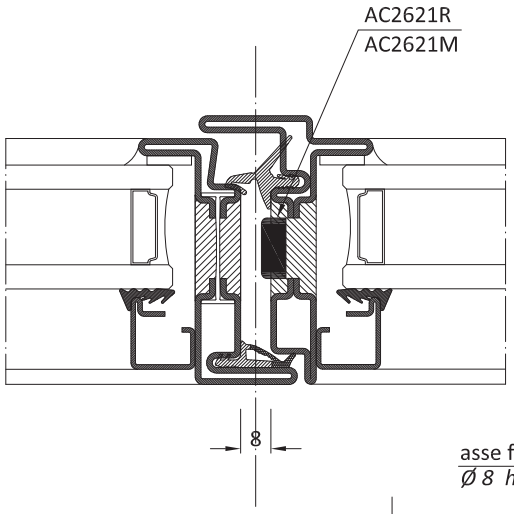
peso max. per anta: 60 Kg
max. leaf weight: 60 Kg

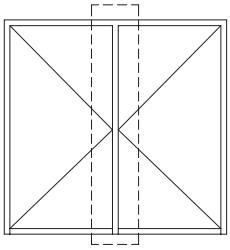


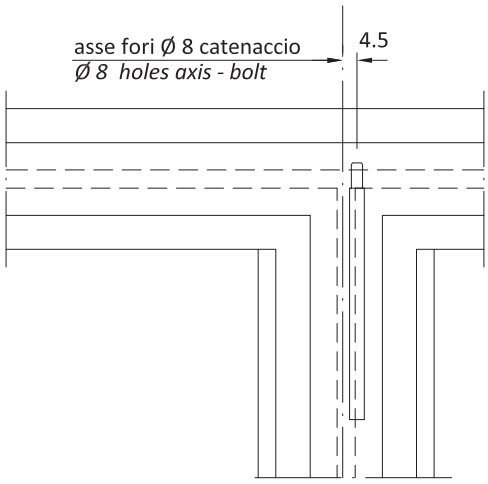


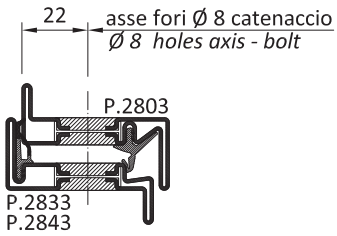


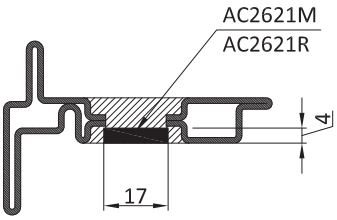


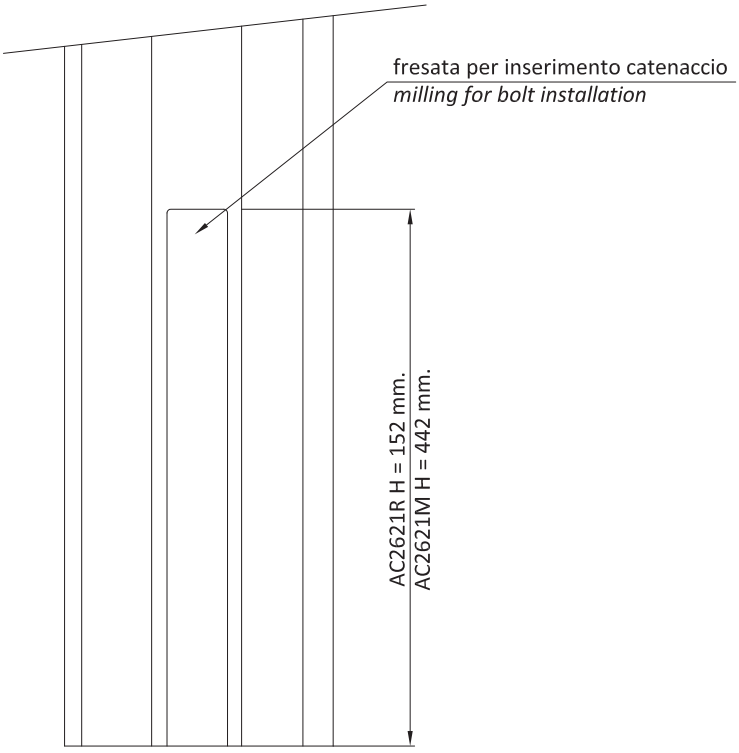

AC2621R
AC2621M
8

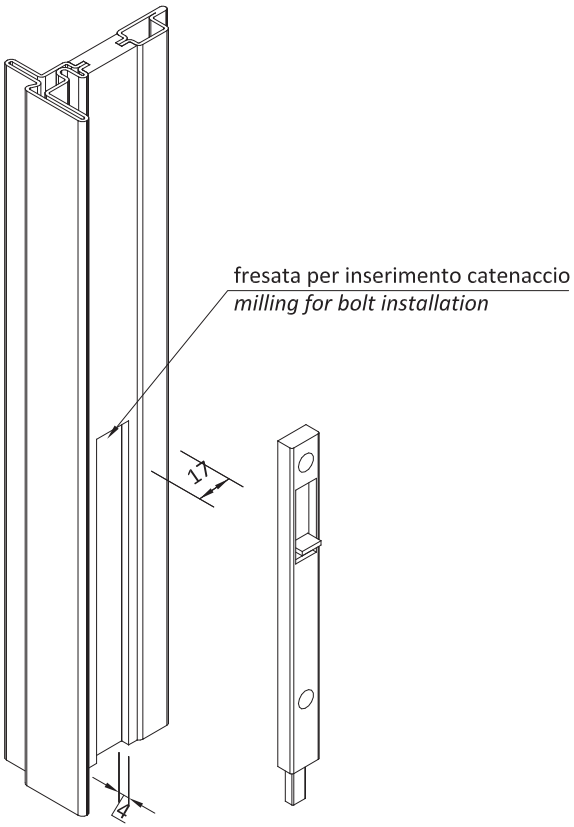


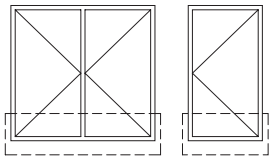

asse fori Ø 8 catenaccio
Ø 8 holes axis - bolt
4.5

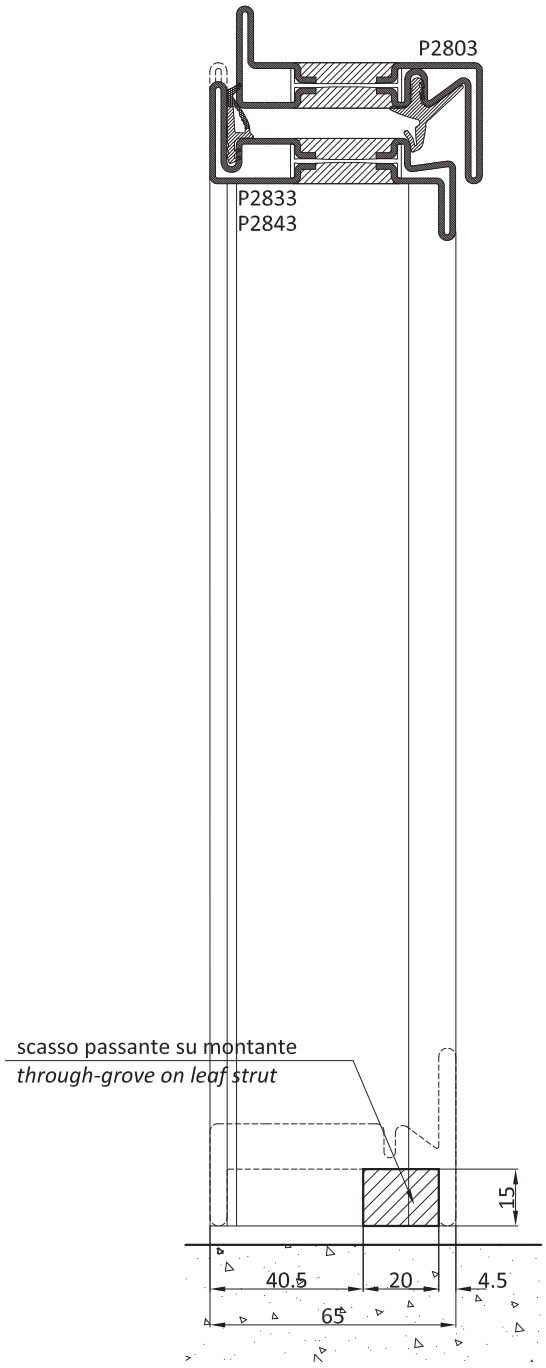

22
asse fori Ø 8 catenaccio
Ø 8 holes axis - bolt
P.2803
P.2833
P.2843

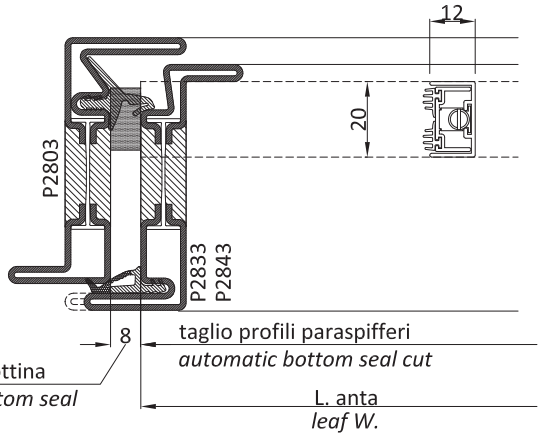

AC2621M
AC2621R
4
17

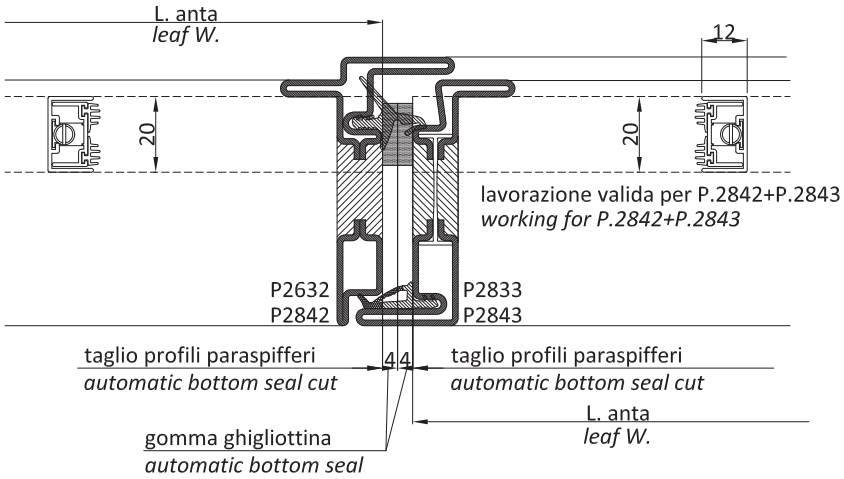

fresata per inserimento catenaccio
milling for bolt installation
AC2621R H = 152 mm.
AC2621M H = 442 mm.

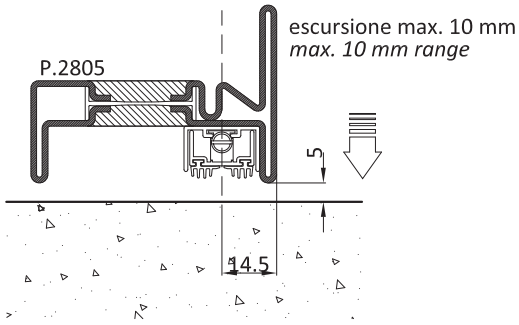

fresata per inserimento catenaccio
milling for bolt installation
17
4



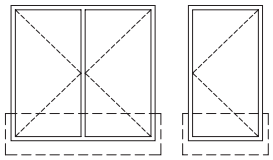


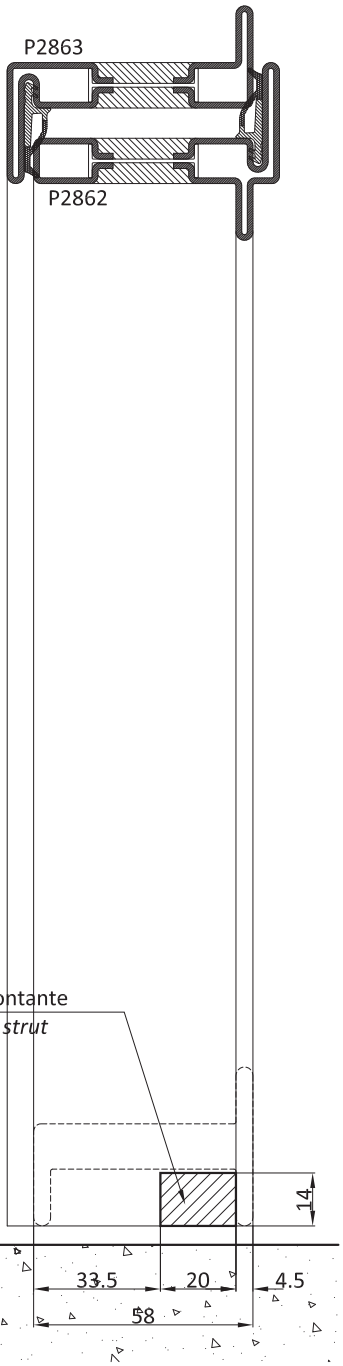


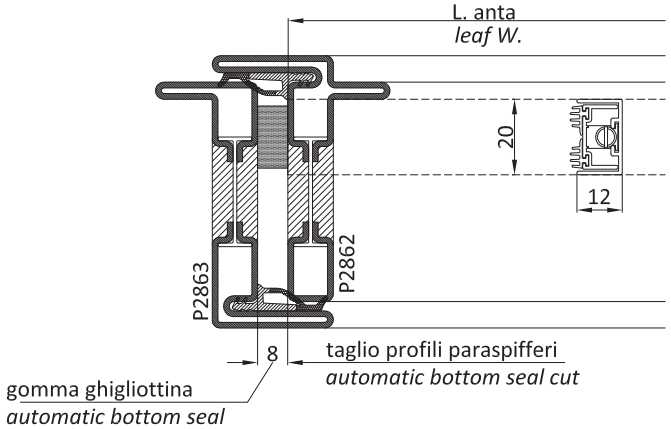


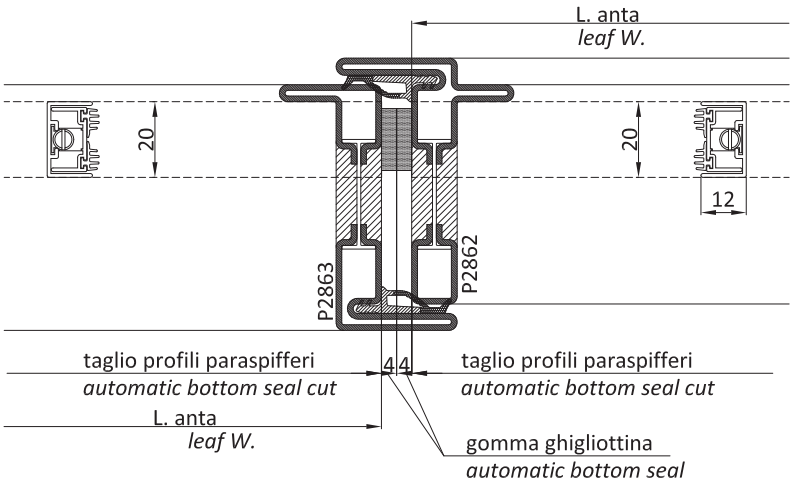


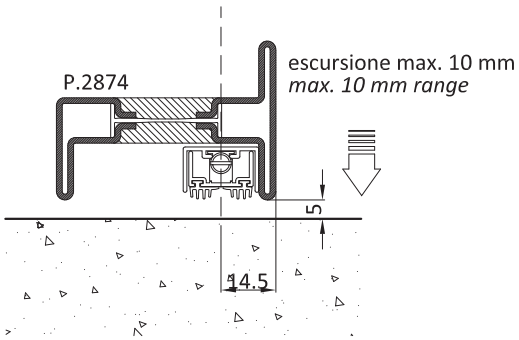
Cod. *Cod.*	lunghezza guarnizione automatica *automatic bottom seal lenght*	larghezza anta *leaf width*
AC2636/Z	280 - 430 mm	264 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	930 - 1080 mm	914 - 1000 mm



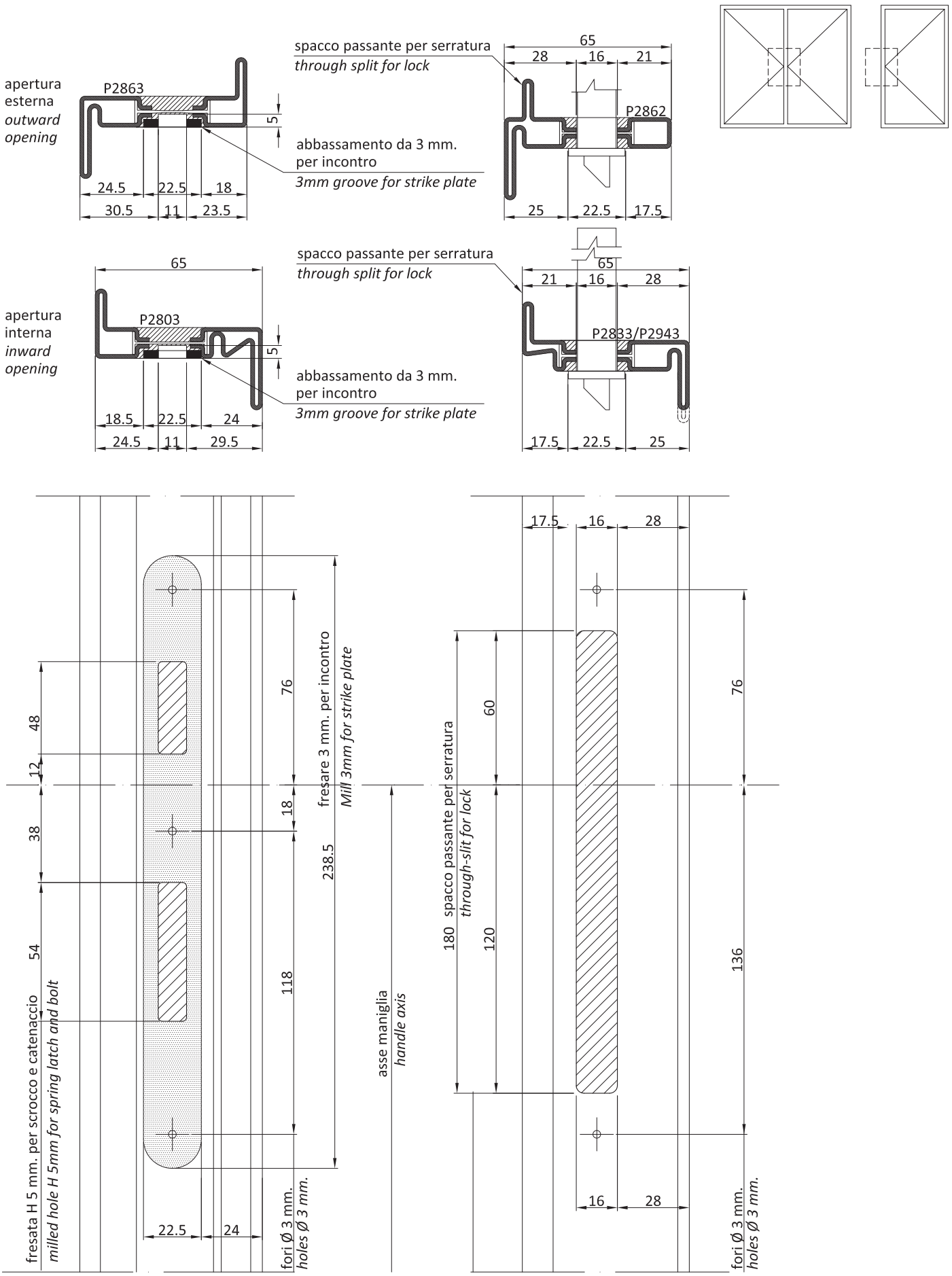




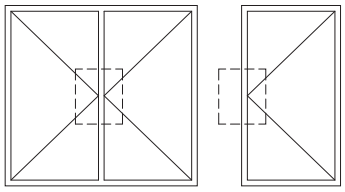


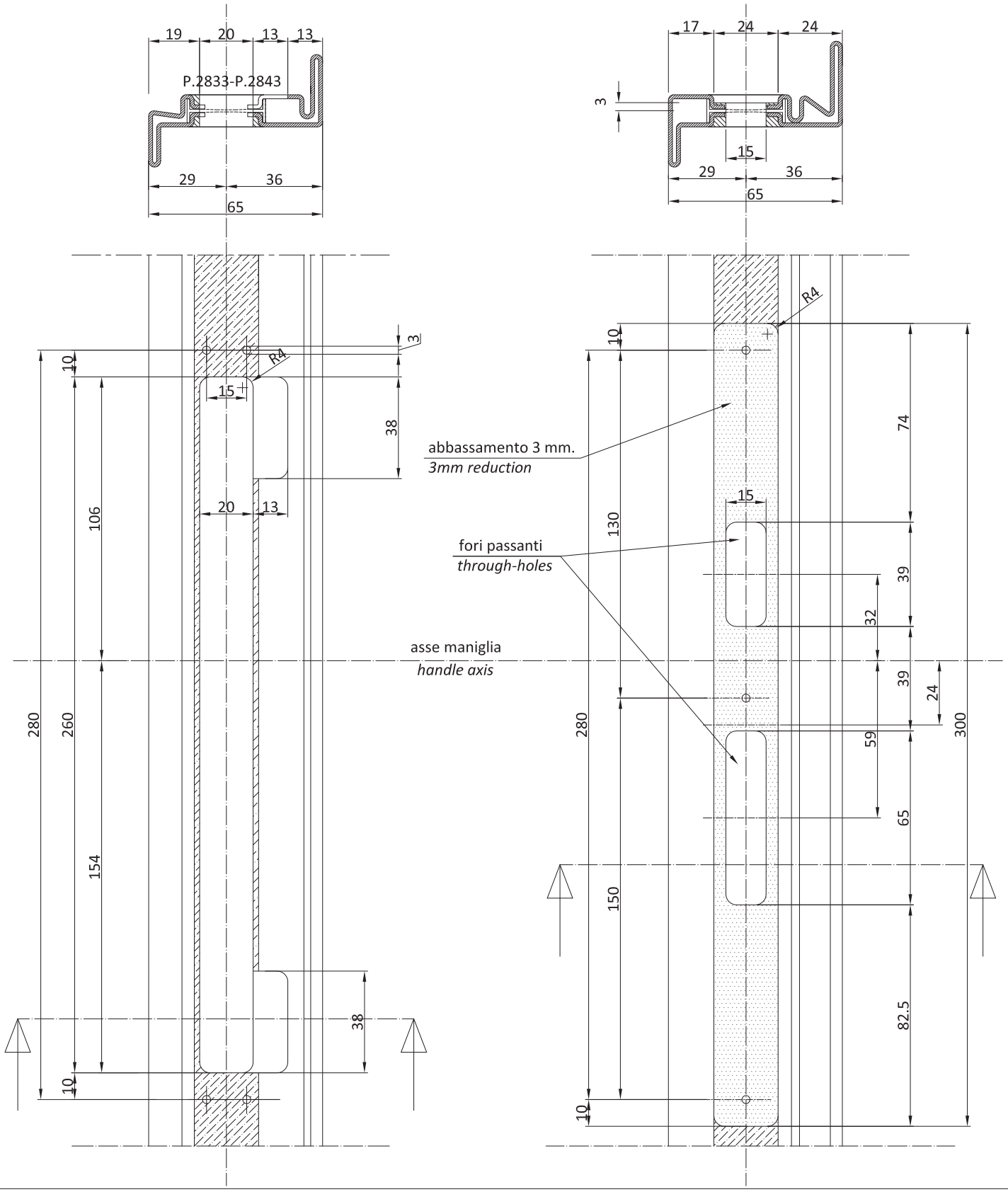


Cod. *Cod.*	lunghezza guarnizione automatica *automatic bottom seal lenght*	larghezza anta *leaf width*
AC2636/Z	280 - 430 mm	264 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	930 - 1080 mm	914 - 1000 mm

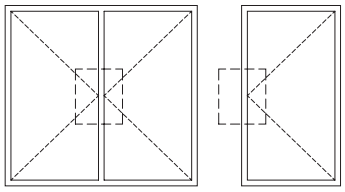

apertura
esterna
outward
opening
P2863
5
24.5
22.5
18
30.5
11
23.5
spacco passante per serratura
through split for lock
abbassamento da 3 mm.
per incontro
3mm groove for strike plate
65
28
16
21
P2862
25
22.5
17.5
apertura
interna
inward
opening
65
P2803
5
18.5
22.5
24
24.5
11
29.5
spacco passante per serratura
through split for lock
65
21
16
28
P2833/P2943
17.5
22.5
25
fresata H 5 mm. per scrocco e catenaccio
milled hole H 5mm for spring latch and bolt
48
12
38
54
76
18
118
238.5
fresare 3 mm. per incontro
Mill 3mm for strike plate
22.5
24
fori Ø 3 mm.
holes Ø 3 mm.
asse maniglia
handle axis
17.5
16
28
180
spacco passante per serratura
through-slit for lock
60
120
76
136
16
28
fori Ø 3 mm.
holes Ø 3 mm.

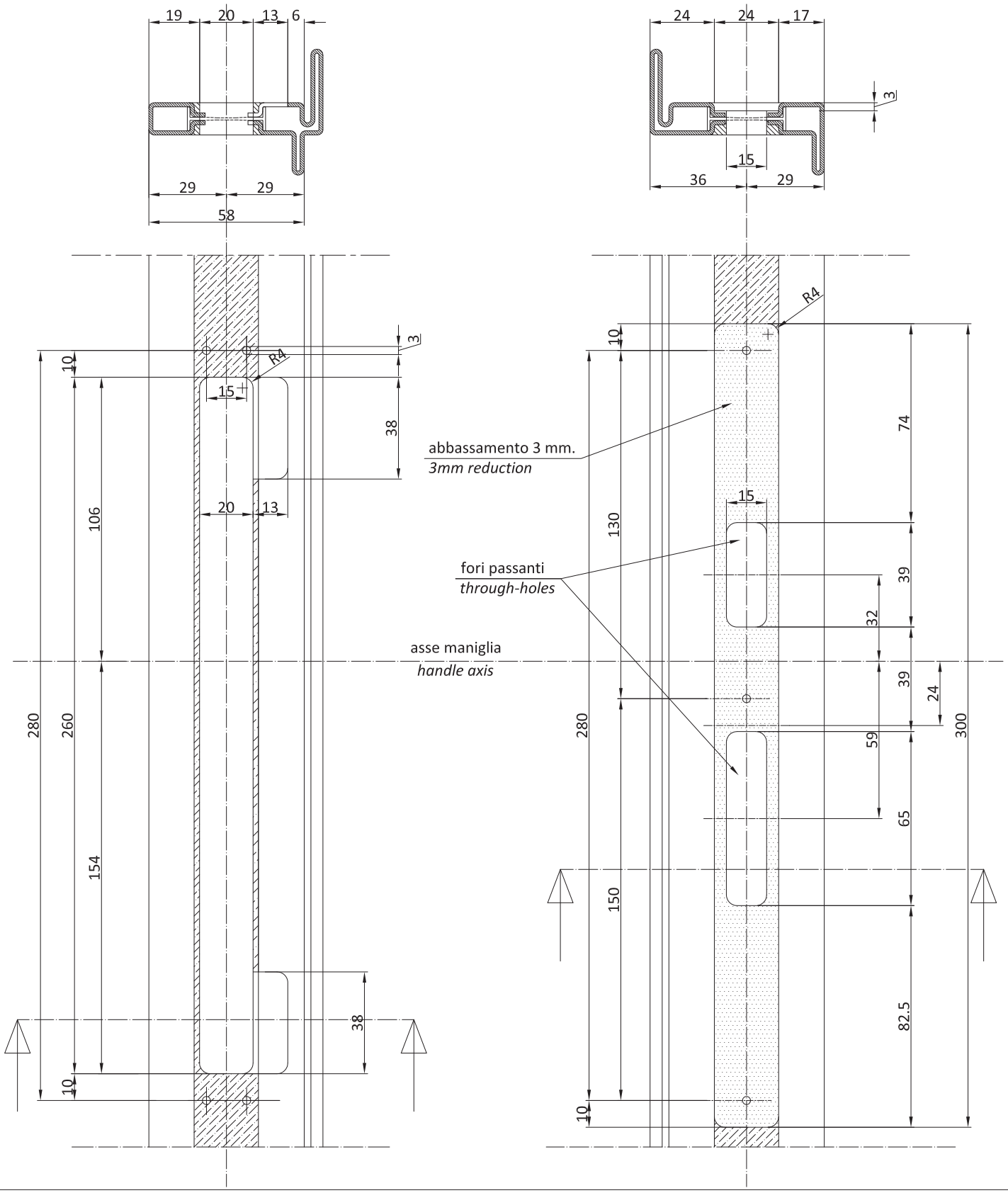
Apertura interna
Inward opening

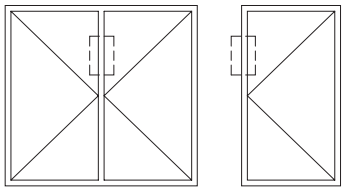




Apertura esterna
Outward opening

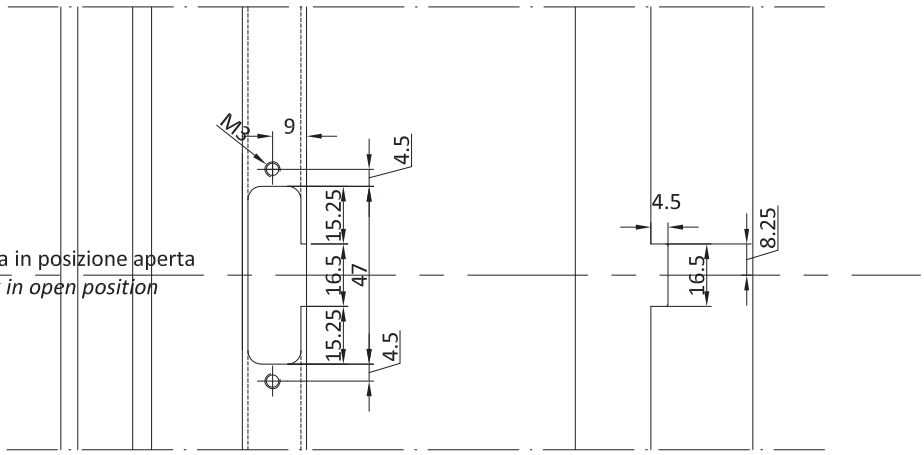


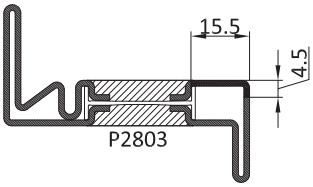


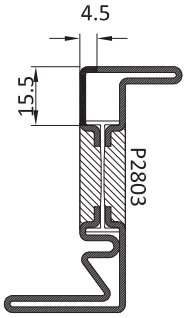


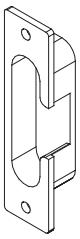
lavorazione applicazione incontro
Processing strike plate installation

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





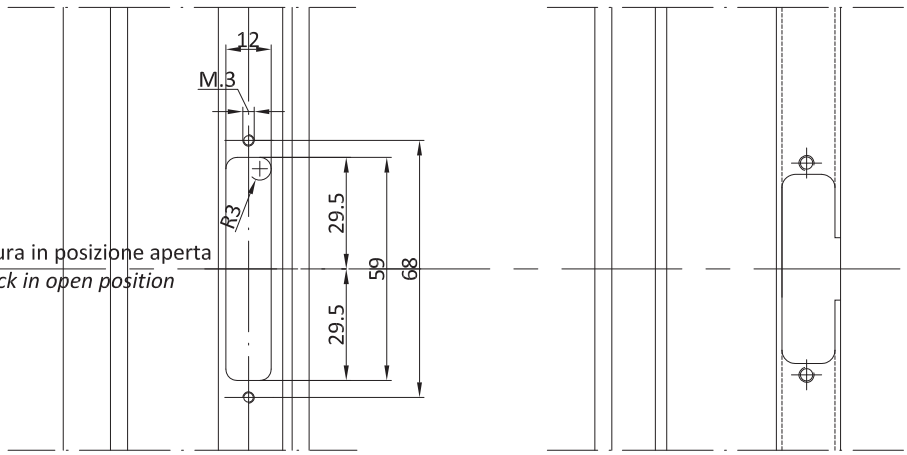


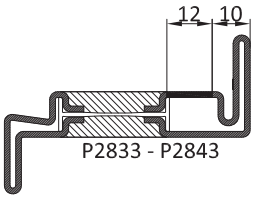


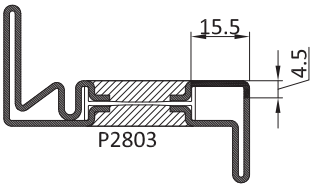
Incontro 3^ chiusura
3rd lock strike plate

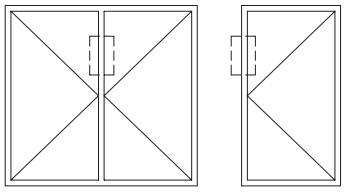
lavorazione applicazione nottolino
Processing for the assembling of the 3rd lock

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



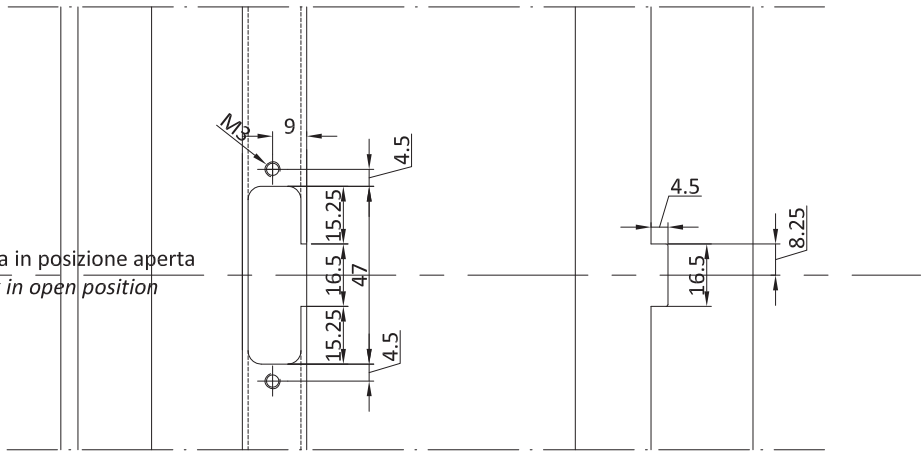


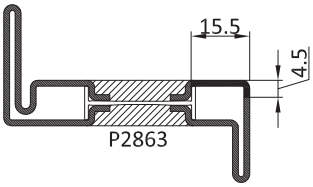


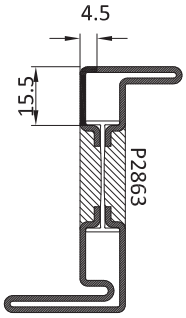


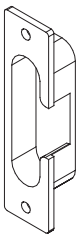
lavorazione applicazione incontro
Processing strike plate installation

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





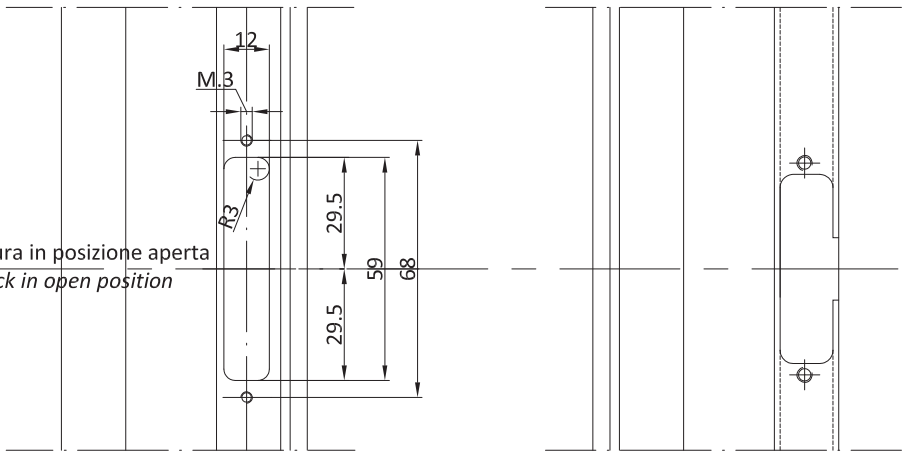


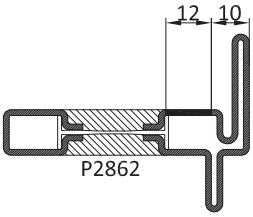


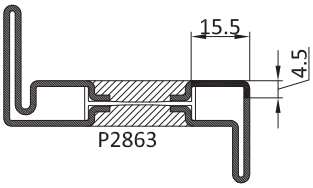
Incontro 3^ chiusura
3rd lock strike plate

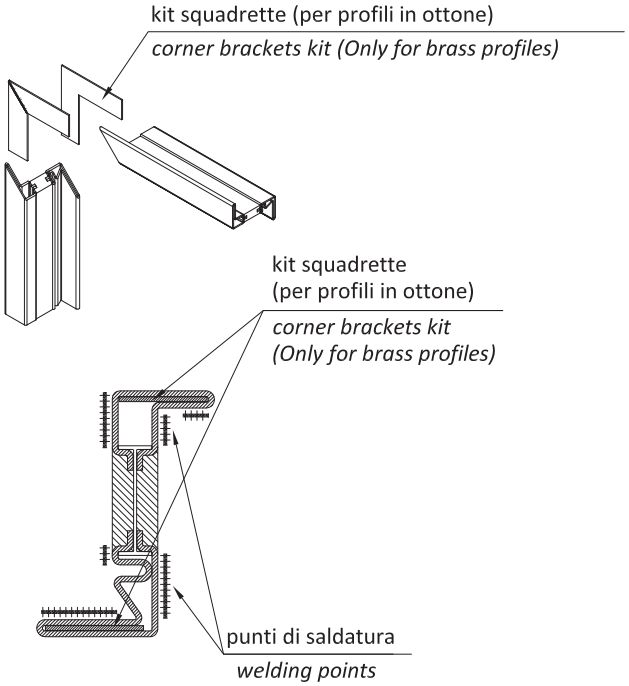
lavorazione applicazione nottolino
Processing for the assembling of the 3rd lock

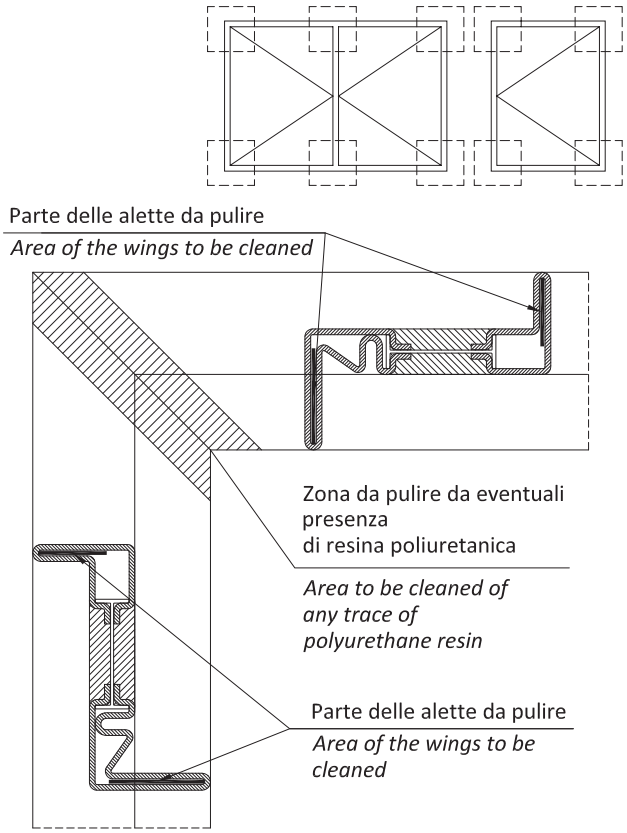
asse nottolino 3^ chiusura in posizione aperta
Latch axis for the 3rd lock in open position











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

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

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

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

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

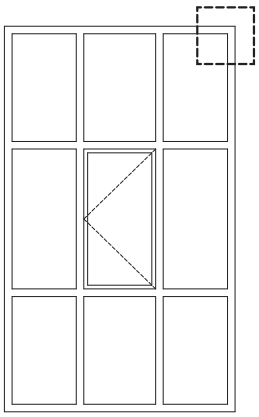
ATTN. Before welding the corner please remove any trace of polyurethane resin in the internal side of casin, heating the profile for ca. 20 mm to melt the resin and removein this way all other impurities.

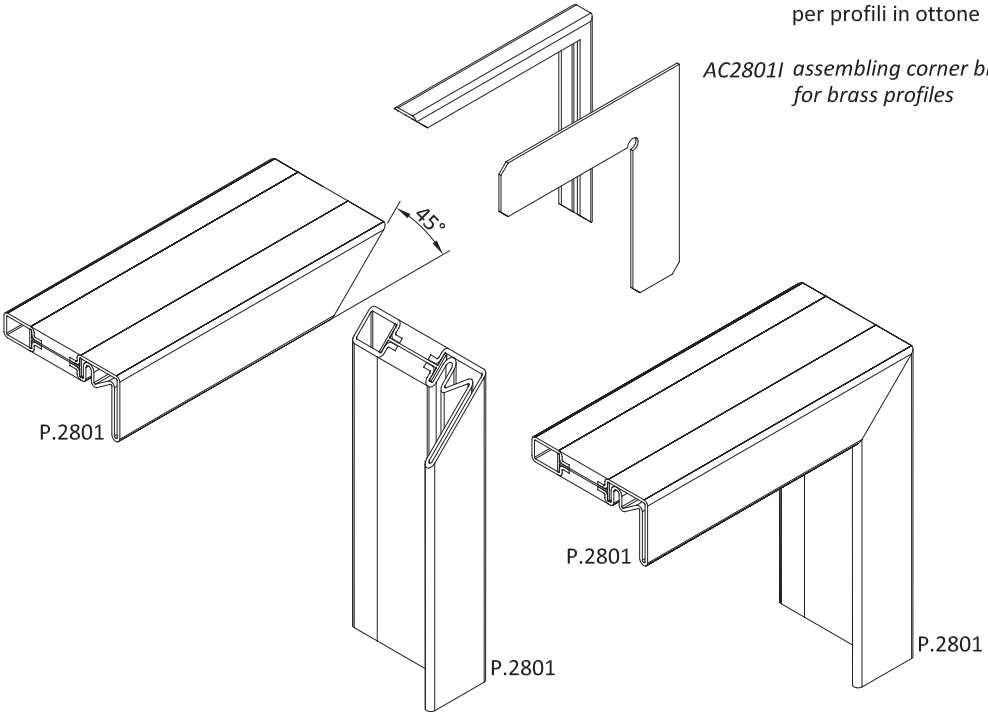
Profilo *Profile*	Kit squadrette *Corner brackets set*
Codice *Code*	Codice *Code*
P.2801	AC 2801I
P.2803	AC 2803I
P.2805	AC 2805I
P.2801-P.2822	AC 2801I
P.2803-P.2822	AC 2801I
P.2805-P.2822	AC 2822I
P.2815	AC 2803I
P.2822	AC 2822I
P.2832-P.2833	AC 2832I
P.2833	AC 2833I
P.2842-P.2843	AC 2832I
P.2843	AC 2843I
P.2801-P.2842	AC 2801I
P.2803-P.2842	AC 2801I
P.2805-P.2842	AC 2801I
P.2815-P.2842	AC 2801I
P.2851	AC 2851I
P.2852	AC 2852I

Profilo *Profile*	Kit squadrette *Corner brackets set*
Codice *Code*	Codice *Code*
P.2853	AC 2853I
P.2855	AC 2855I
P.2861	AC 2801I
P.2862	AC 2862I
P.2863	AC 2803I
P.2865	AC 2865I
P.2862-P.2863	AC 2832I anta / *leaf*
P.2862-P.2863	AC 2801I telaio / *frame*
P.2865-P.2863	AC 2803I
P.2871	AC 2871I
P.2872	AC 2872I
P.2873	AC 2853I
P.2874	AC 2855I
P.2875	AC 2875I
P.2882	AC 2882I
P.2892	AC 2892I
P.2893	AC 2892I
P.2895	AC 2895I

AC2801I squadretta di assiemaggio per profili in ottone

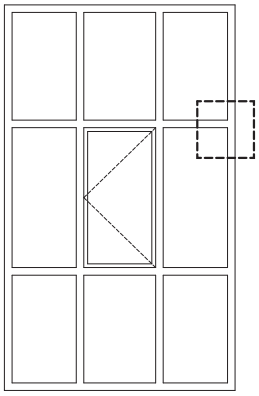
AC2801I assembling corner brackets for brass profiles

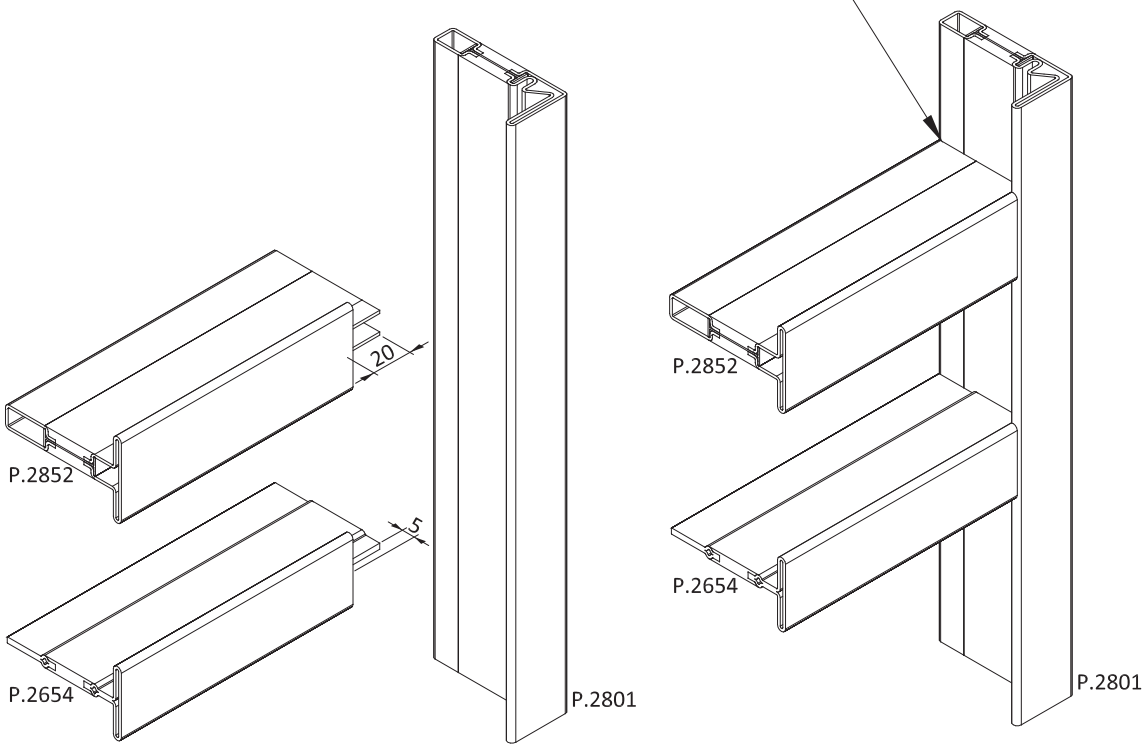


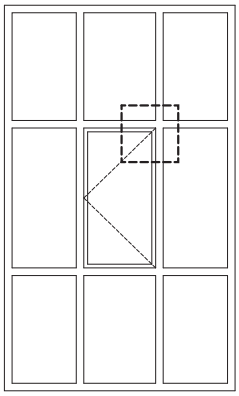


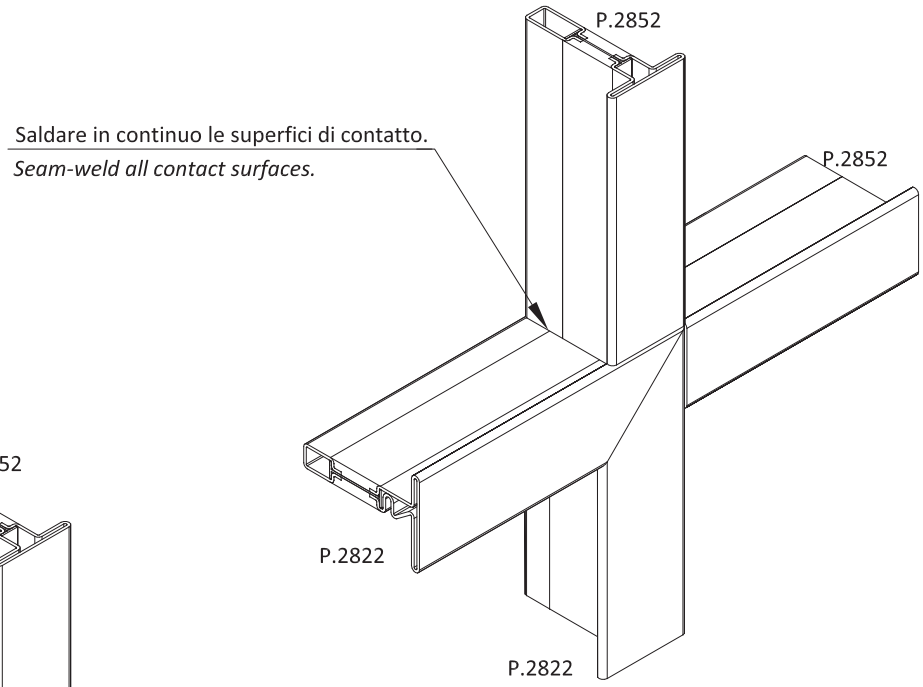
Saldare in continuo le superfici di contatto.

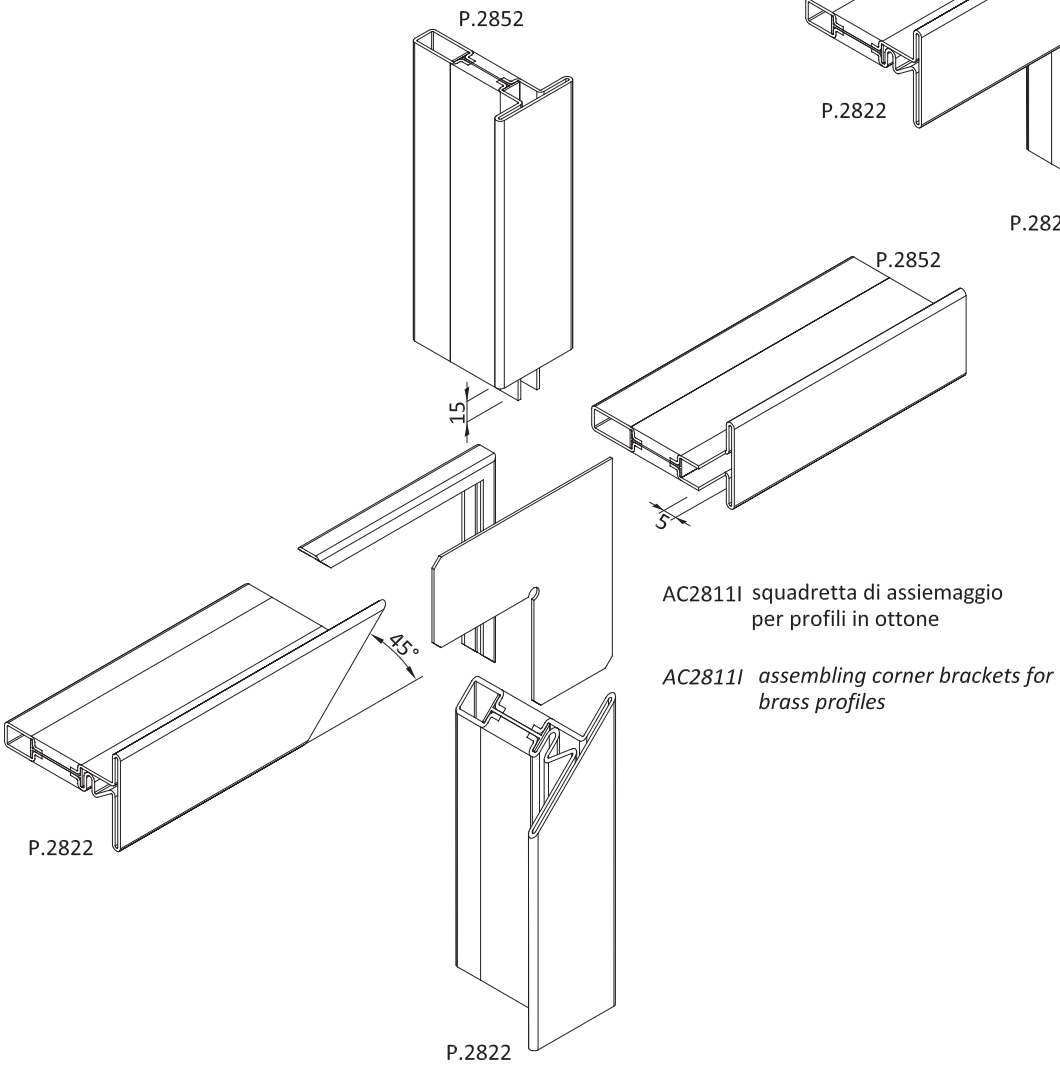
Seam-weld all contact surfaces.





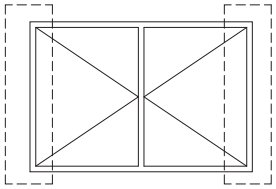




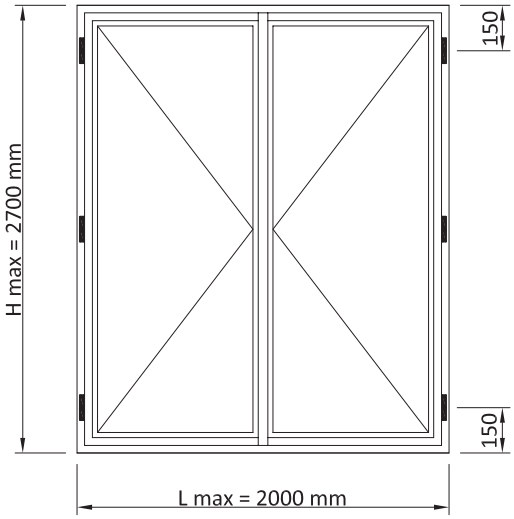


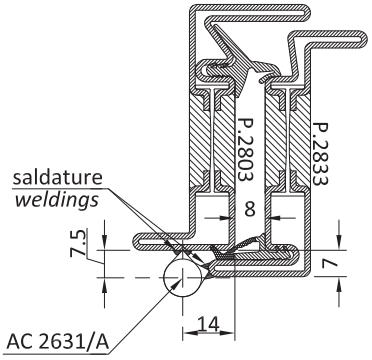
AC2811I squadretta di assiemaggio per profili in ottone

AC2811I assembling corner brackets for brass profiles



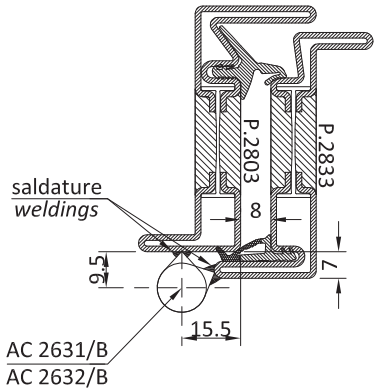
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm





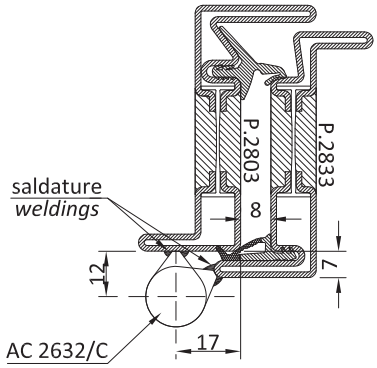
schema di fissaggio
AC 2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

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



schema di fissaggio
AC 2631/B non registrabile
AC 2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

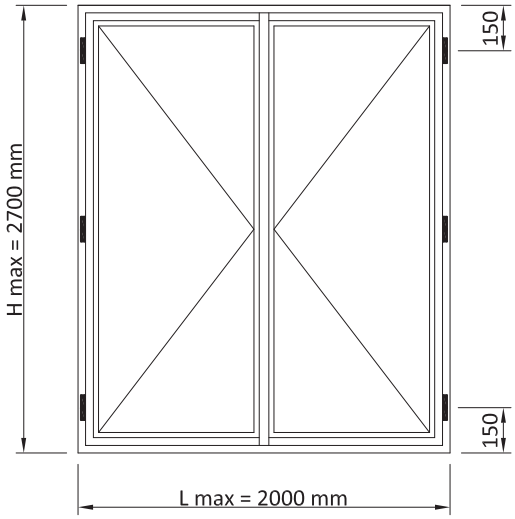
installation chart
AC2631/B non-adjustable
AC2632/B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg

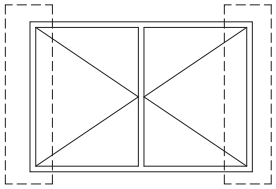


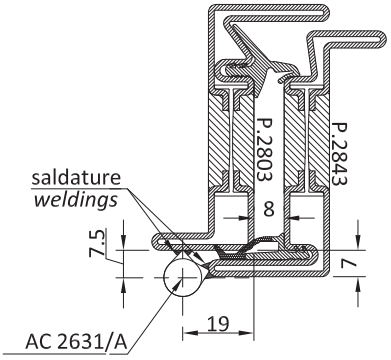
schema di fissaggio
AC 2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

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

Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm

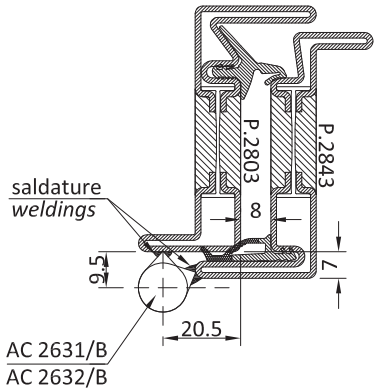






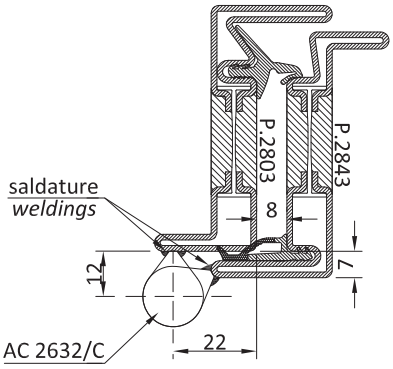
schema di fissaggio
AC 2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

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



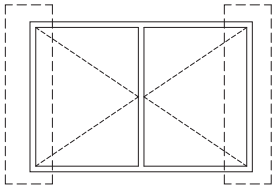
schema di fissaggio
AC 2631/B non registrabile
AC 2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

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

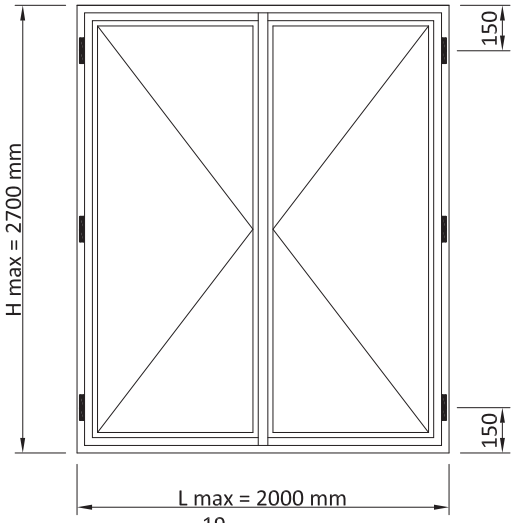


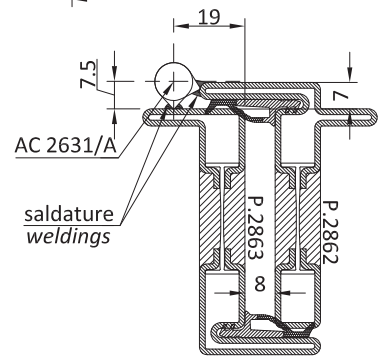
schema di fissaggio
AC 2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

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



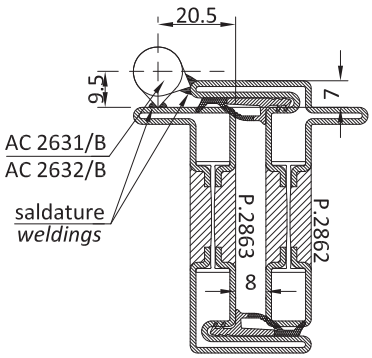
Cerniera centrale per H > 1400 mm
Central hinge for H > 1400 mm





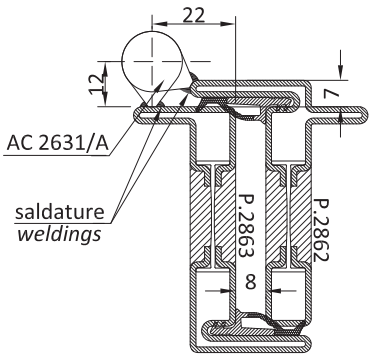
schema di fissaggio
AC 2631/A non registabile
cerniera Ø 10
peso massimo anta 40 kg.

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



schema di fissaggio
AC 2631/B non registabile
AC 2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

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



schema di fissaggio
AC 2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

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

1) Eseguire i fori come da disegno (lavorazione effettuabile con maschera AT2618)

2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione Inox A2.

3) Posizionare la guarnizione di giunto centrale e gli angoli vulcanizzati, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica.

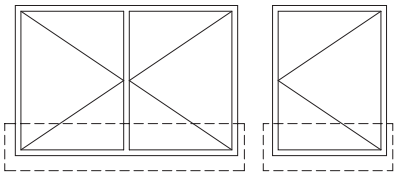
4) Sigillare per tutta la lunghezza la base inferiore e per 150 mm. in altezza il telaio.

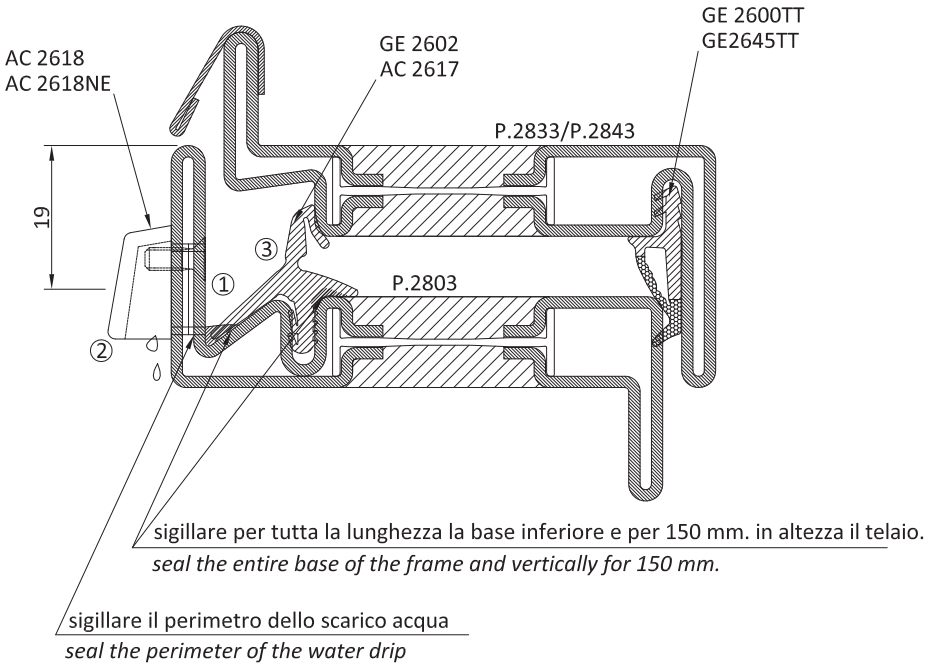
1) Drill the holes as shown in the diagram (using jig AT2618)

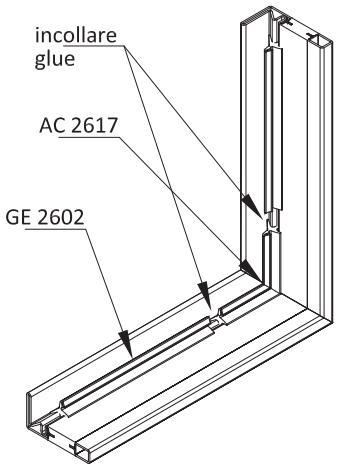
2) Position the water drain, seal and secure with the supplied A2 stainless screw

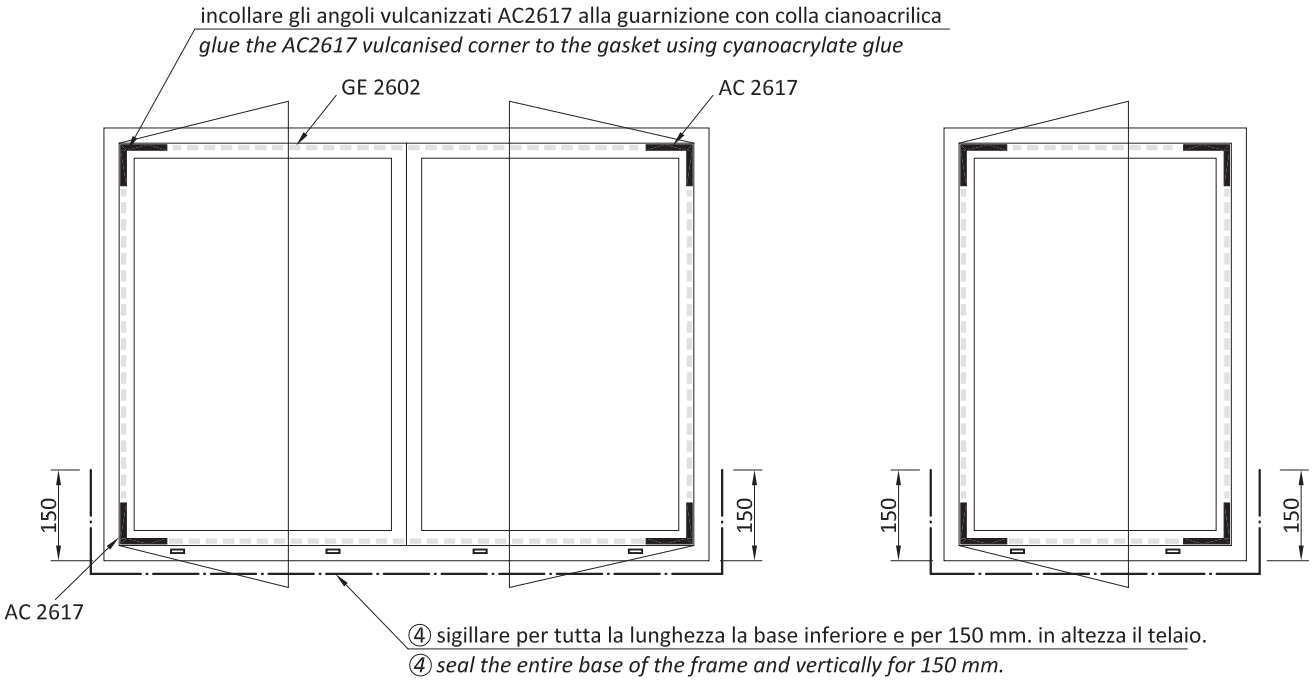
3) Position the central weather strip and vulcanised corner, glue the corners to the weathers strip using cyanoacrylate glue

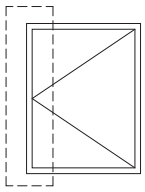
4) seal the entire lower base of the frame and vertically for 150 mm.











incontro aste
rod fittings

guida aste
rod guide

nottolino di chiusura AC2626R supplementare
AC2626R additional locking point

accessorio di collegamento ed inserimento nottolino 3^ chiusura supplementare
connection hardware and plug insertion for the 3rd lock additional

barra filettata di prolungamento
threaded connection bar

vite di fissaggio
Fixing screws

gratz

vite di fissaggio
Fixing screws

asta di chiusura
closing rods

H barra filettata - *H threaded bar*
H nottolino - 100 - *H plug - 100 mm.*

H nottolino ad anta aperta - *Open leaf H plug*

H asta = H anta -H cremonese -15 mm. - *H rod = H leaf - H cremone bolt -15 mm.*

H asta = H cremonese -19 mm.
H rod = H cremone bolt -19 mm.

1) Avvitare le aste di chiusura agli accessori di collegamento

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

3) Inserire e fissare il GRATZ all'anta

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

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

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

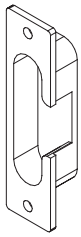
2) Insert the rods into the slits on the leaf corners

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

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

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

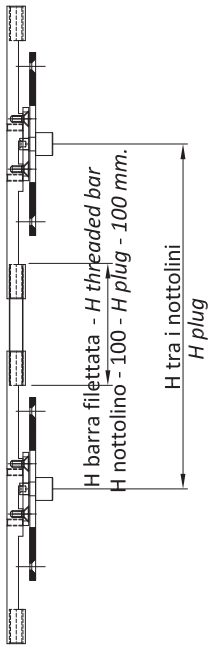
6) Secure the fittings to the frame

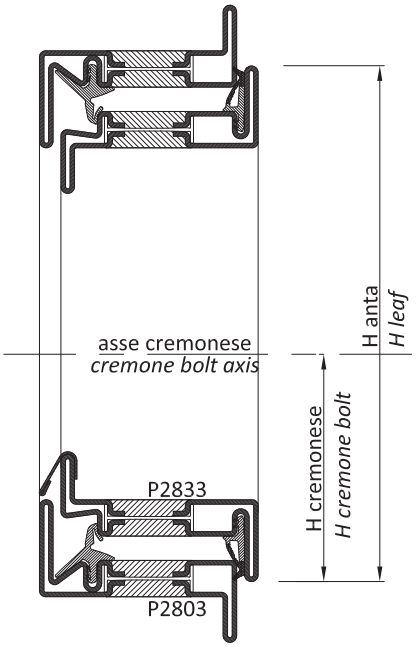


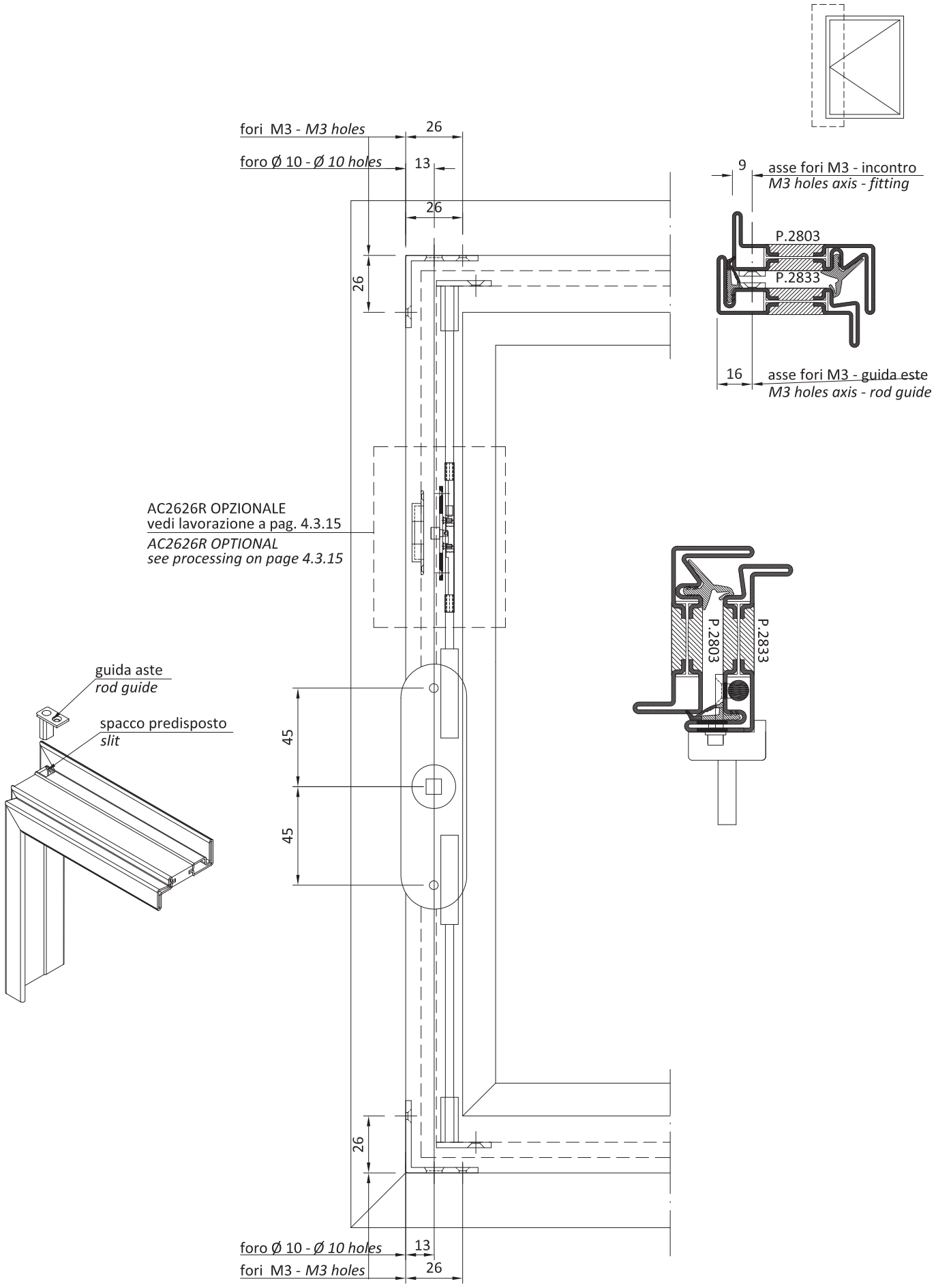
AC2626R incontro 3^ chiusura
AC2626R 3rd lock strike plate

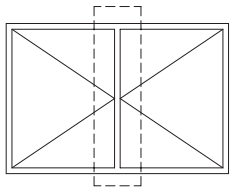
N.B. prevedere un punto di chiusura ogni 1000 mm. max.

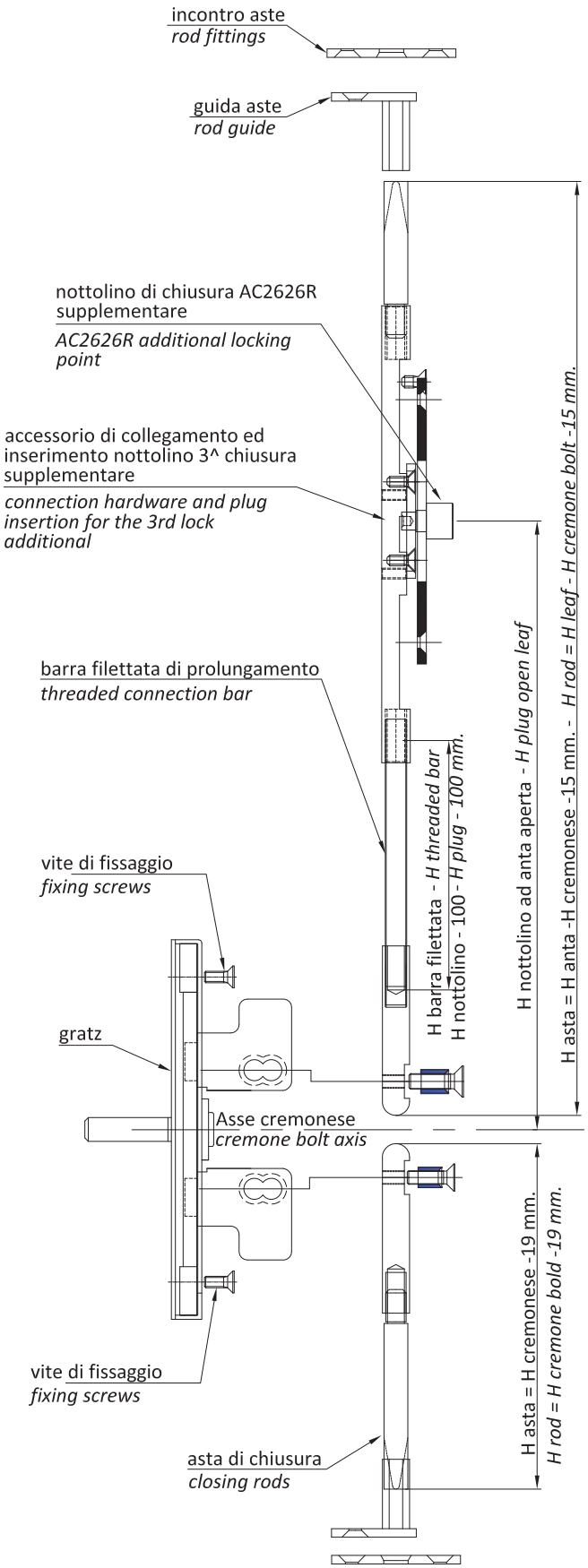
Attn. Consider one locking point every 1000 mm max






fori M3 - *M3 holes*
26
foro Ø 10 - *Ø 10 holes*
13
26
26
9
asse fori M3 - incontro
M3 holes axis - fitting
P.2803
P.2833
16
asse fori M3 - guida este
M3 holes axis - rod guide
AC2626R OPZIONALE
vedi lavorazione a pag. 4.3.15
AC2626R OPTIONAL
see processing on page 4.3.15
P.2803
P.2833
guida aste
rod guide
spacco predisposto
slit
45
45
26
foro Ø 10 - *Ø 10 holes*
13
fori M3 - *M3 holes*
26





1) Avvitare le aste di chiusura agli accessori di collegamento

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

3) Inserire e fissare il GRATZ all'anta

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

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

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

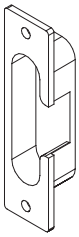
2) Insert the rods into the slits on the leaf corners

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

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

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

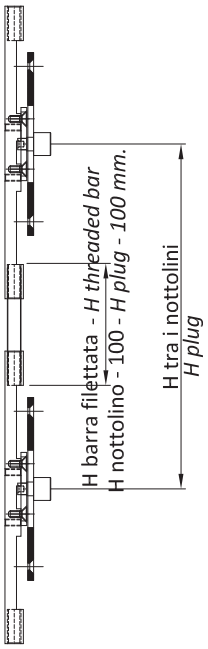
6) Secure the fittings to the frame

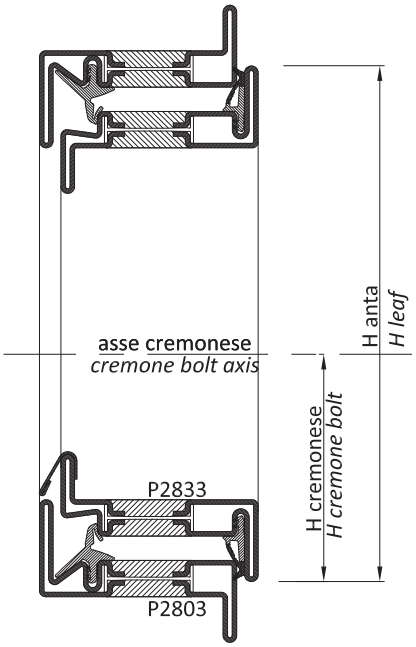


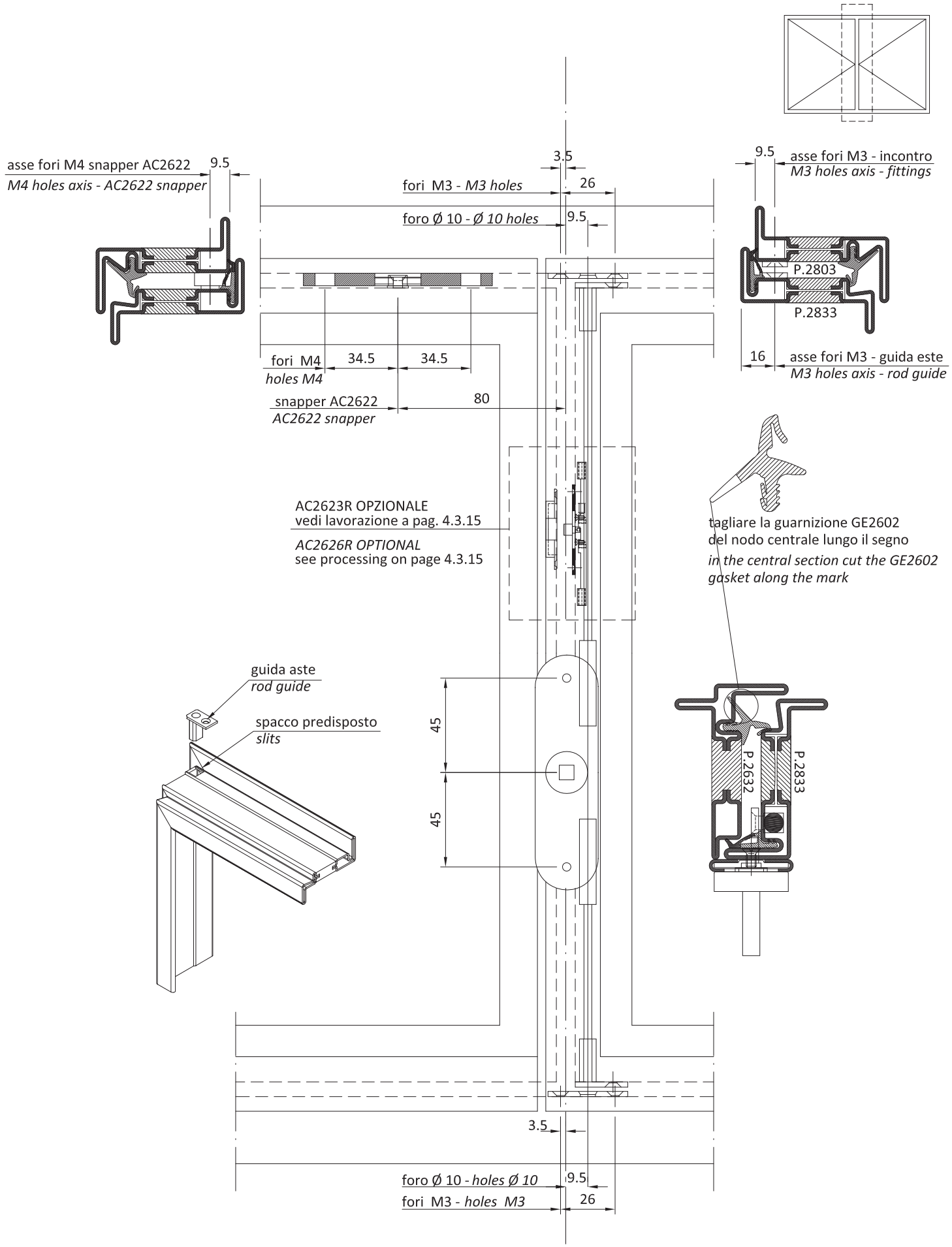
AC2626R incontro 3^ chiusura
AC2626R 3rd lock strike plate

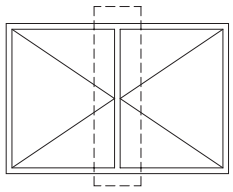
N.B. prevedere un punto di chiusura ogni 1000 mm. max.

ATTN. Consider one locking point every 1000 mm max






asse fori M4 snapper AC2622
M4 holes axis - AC2622 snapper
9.5
3.5
fori M3 - M3 holes
26
foro Ø 10 - Ø 10 holes
9.5
9.5
asse fori M3 - incontro
M3 holes axis - fittings
P.2803
P.2833
fori M4
holes M4
34.5
34.5
16
asse fori M3 - guida este
M3 holes axis - rod guide
snapper AC2622
AC2622 snapper
80
AC2623R OPZIONALE
vedi lavorazione a pag. 4.3.15
AC2626R OPTIONAL
see processing on page 4.3.15
tagliare la guarnizione GE2602
del nodo centrale lungo il segno
in the central section cut the GE2602
gasket along the mark
guida aste
rod guide
spacco predisposto
slits
45
45
P.2632
P.2833
3.5
foro Ø 10 - holes Ø 10
9.5
fori M3 - holes M3
26



incontro aste
rod fittings

guida aste
rod guide

nottolino di chiusura AC2626R supplementare
AC2626R additional locking point

accessorio di collegamento ed inserimento nottolino 3^ chiusura supplementare
connection hardware and plug insertion for the 3rd lock additional

barra filettata di prolungamento
threaded connection bar

vite di fissaggio
fixing screws

gratz

Asse cremonese
cremone bolt axis

vite di fissaggio
fixing screws

asta di chiusura
closing rods

H barra filettata - *H threaded bar*
H nottolino - 100 - *H plug - 100 mm.*

H nottolino ad anta aperta - *H plug open leaf*

H asta = H anta -H cremonese -15 mm. - *H rod = H leaf - H cremone bolt -15 mm.*

H asta = H cremonese -19 mm.
H rod = H cremone bold -19 mm.

1) Avvitare le aste di chiusura agli accessori di collegamento

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

3) Inserire e fissare il GRATZ all'anta

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

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

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

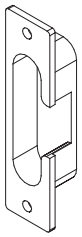
2) Insert the rods into the slits on the leaf corners

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

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

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

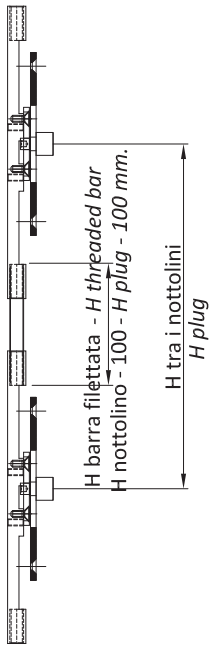
6) Secure the fittings to the frame

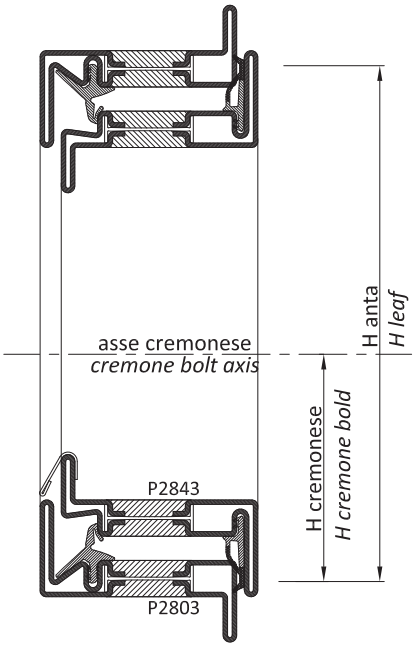


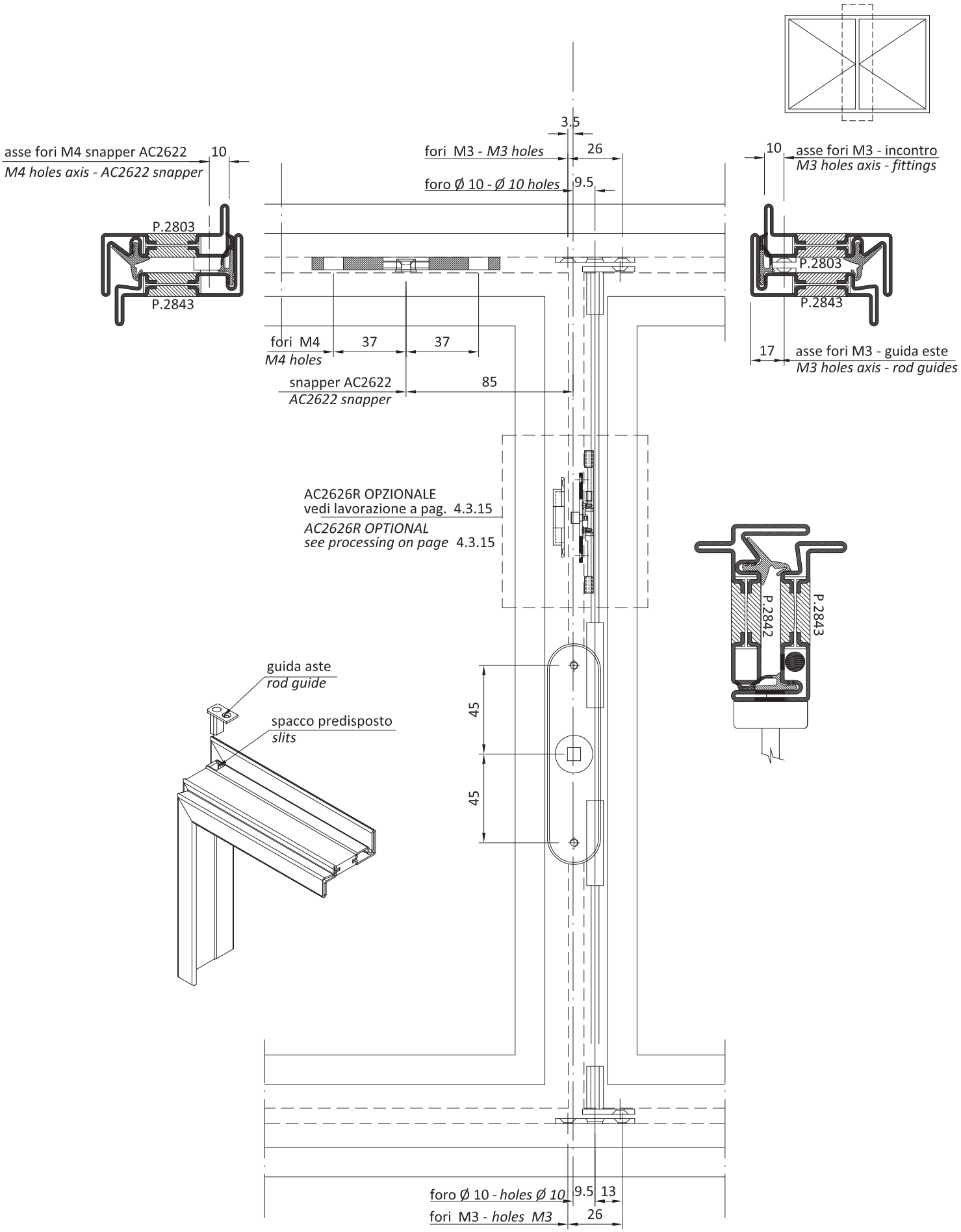
AC2626R incontro 3^ chiusura
AC2626R 3rd lock strike plate

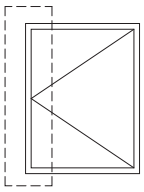
N.B. prevedere un punto di chiusura ogni 1000 mm. max.

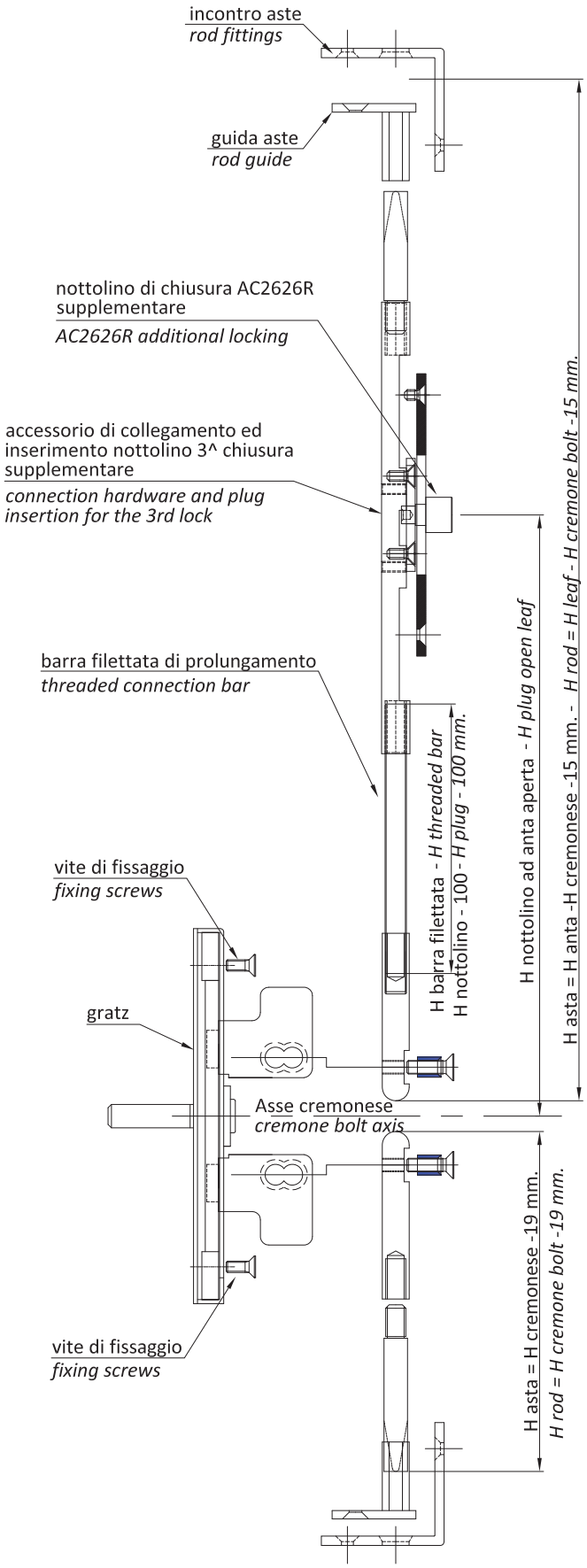
ATTN. Consider one locking point every 1000 mm max






asse fori M4 snapper AC2622
M4 holes axis - AC2622 snapper
10
P.2803
P.2843
3.5
fori M3 - M3 holes
26
foro Ø 10 - Ø 10 holes
9.5
10
asse fori M3 - incontro
M3 holes axis - fittings
P.2803
P.2843
fori M4
M4 holes
37
37
17
asse fori M3 - guida este
M3 holes axis - rod guides
snapper AC2622
AC2622 snapper
85
AC2626R OPZIONALE
vedi lavorazione a pag. 4.3.15
AC2626R OPTIONAL
see processing on page 4.3.15
P.2842
P.2843
guida aste
rod guide
spacco predisposto
slits
45
45
foro Ø 10 - holes Ø 10
9.5
13
fori M3 - holes M3
26





1) Avvitare le aste di chiusura agli accessori di collegamento

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

3) Inserire e fissare il GRATZ all'anta

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

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

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

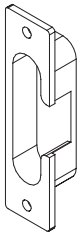
2) Insert the rods into the slits on the leaf corners

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

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

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

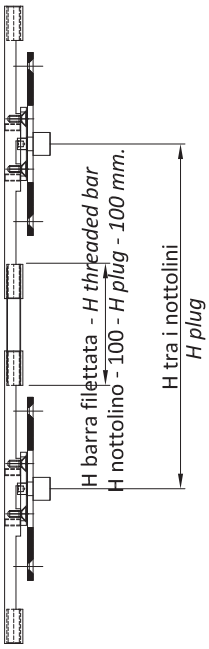
6) Secure the fittings to the frame

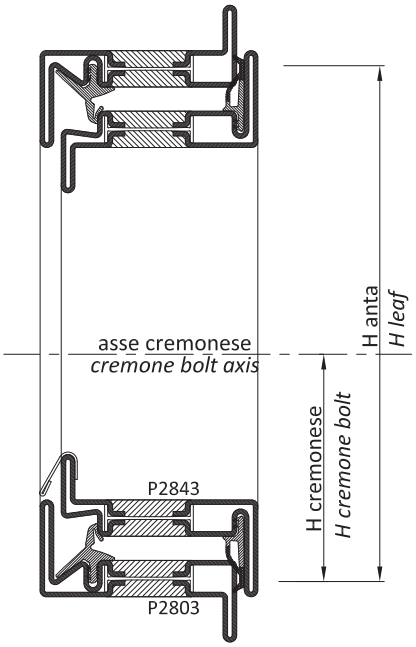


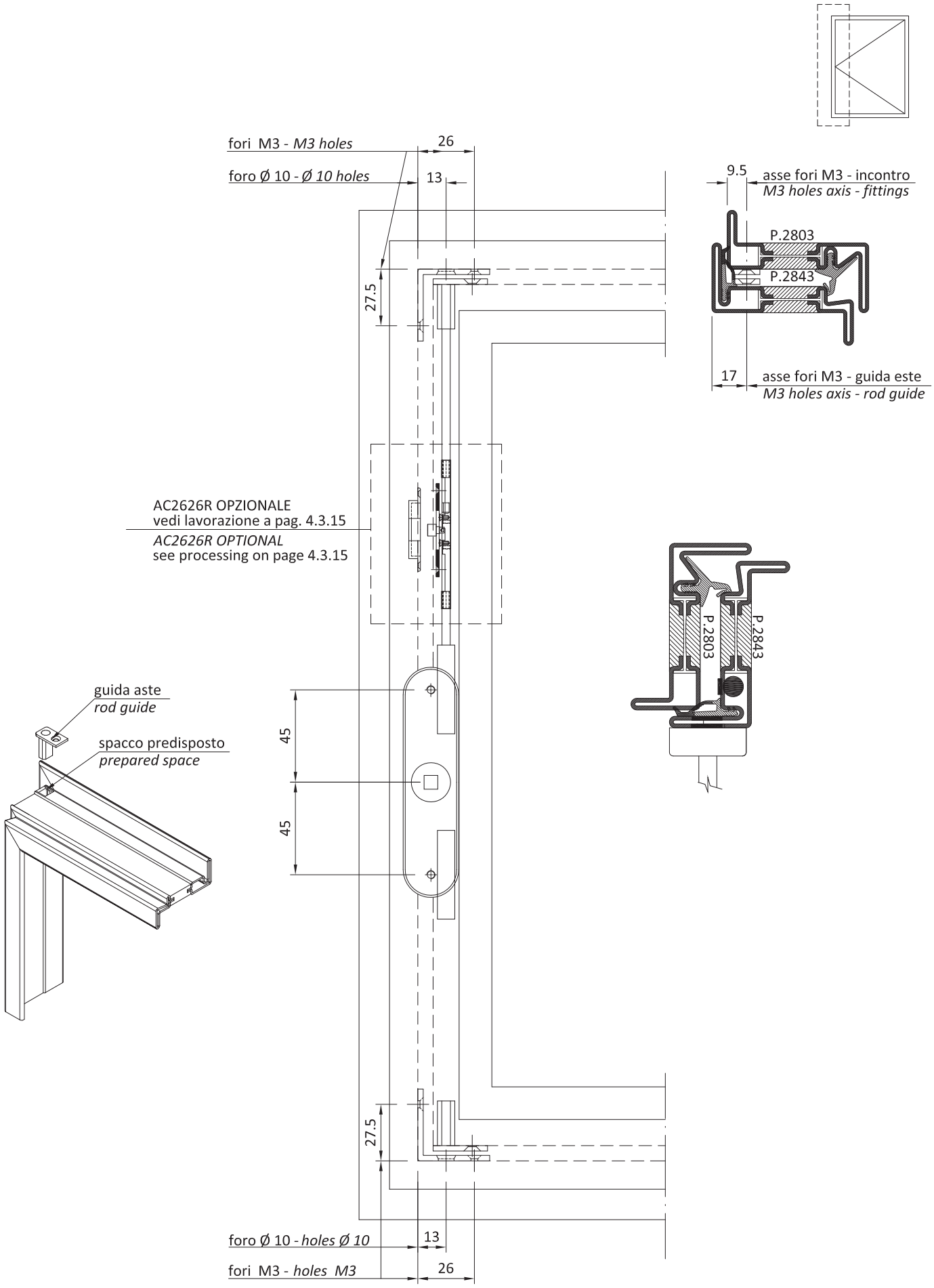
AC2626R incontro 3^ chiusura
AC2626R 3rd lock strike plate

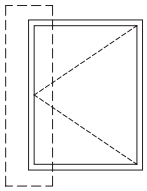
N.B. prevedere un punto di chiusura ogni 1000 mm. max.

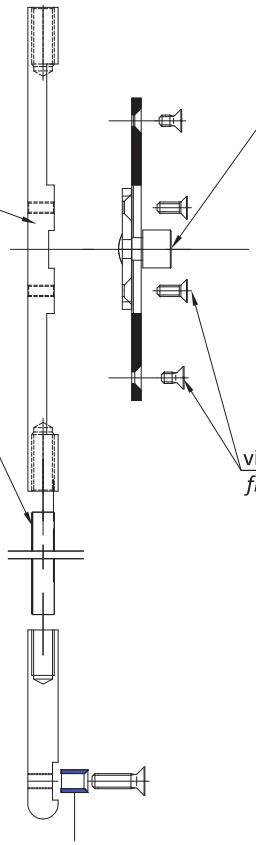
ATTN. Consider one locking point every 1000 mm max

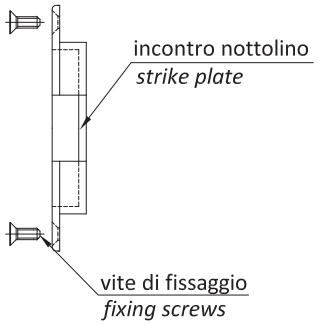


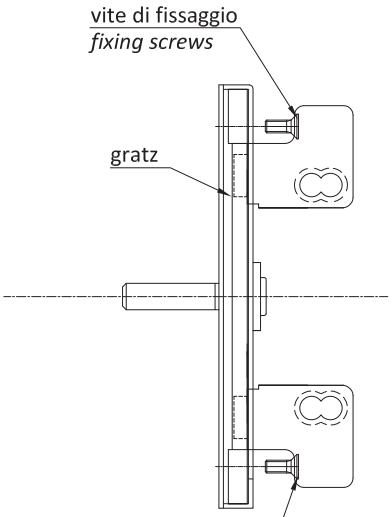



fori M3 - *M3 holes*
26
foro Ø 10 - *Ø 10 holes*
13
9.5
asse fori M3 - incontro
M3 holes axis - fittings
P.2803
P.2843
27.5
17
asse fori M3 - guida este
M3 holes axis - rod guide
AC2626R OPZIONALE
vedi lavorazione a pag. 4.3.15
AC2626R OPTIONAL
see processing on page 4.3.15
P.2803
P.2843
guida aste
rod guide
spacco predisposto
prepared space
45
45
27.5
foro Ø 10 - *holes Ø 10*
13
fori M3 - *holes M3*
26









1) Avvitare le aste di chiusura agli accessori di collegamento

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

3) Inserire e fissare il GRATZ all'anta

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

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

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

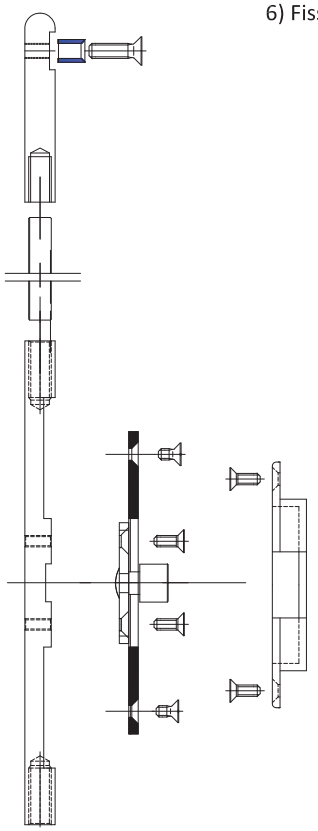
2) Insert the rods into the slits on the leaf corners

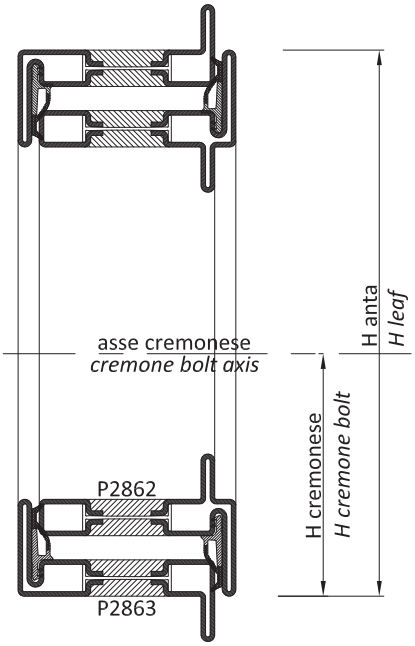
3) Insert the "GRATZ" mechanism into the leaf and secure

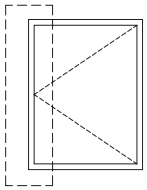
4) Fix the closing rods to the "GRATZ" mechanism using the M4 screws

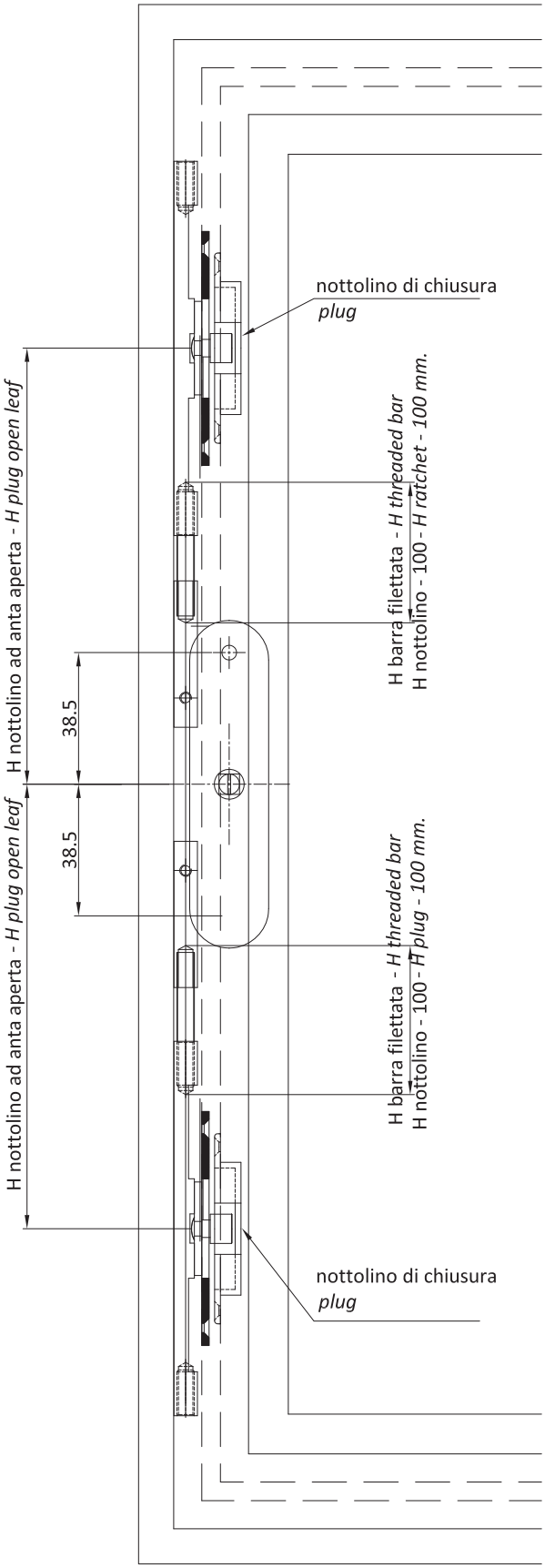
5) Insert the rod guides into the slits and fix them to the leaf

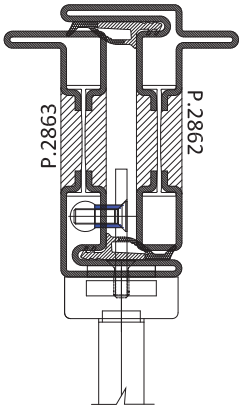
6) Secure the fittings to the frame

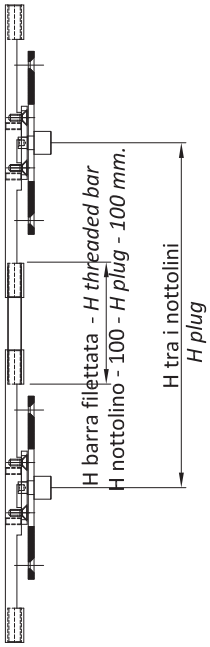


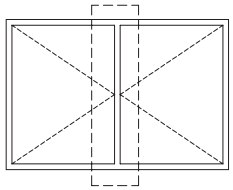


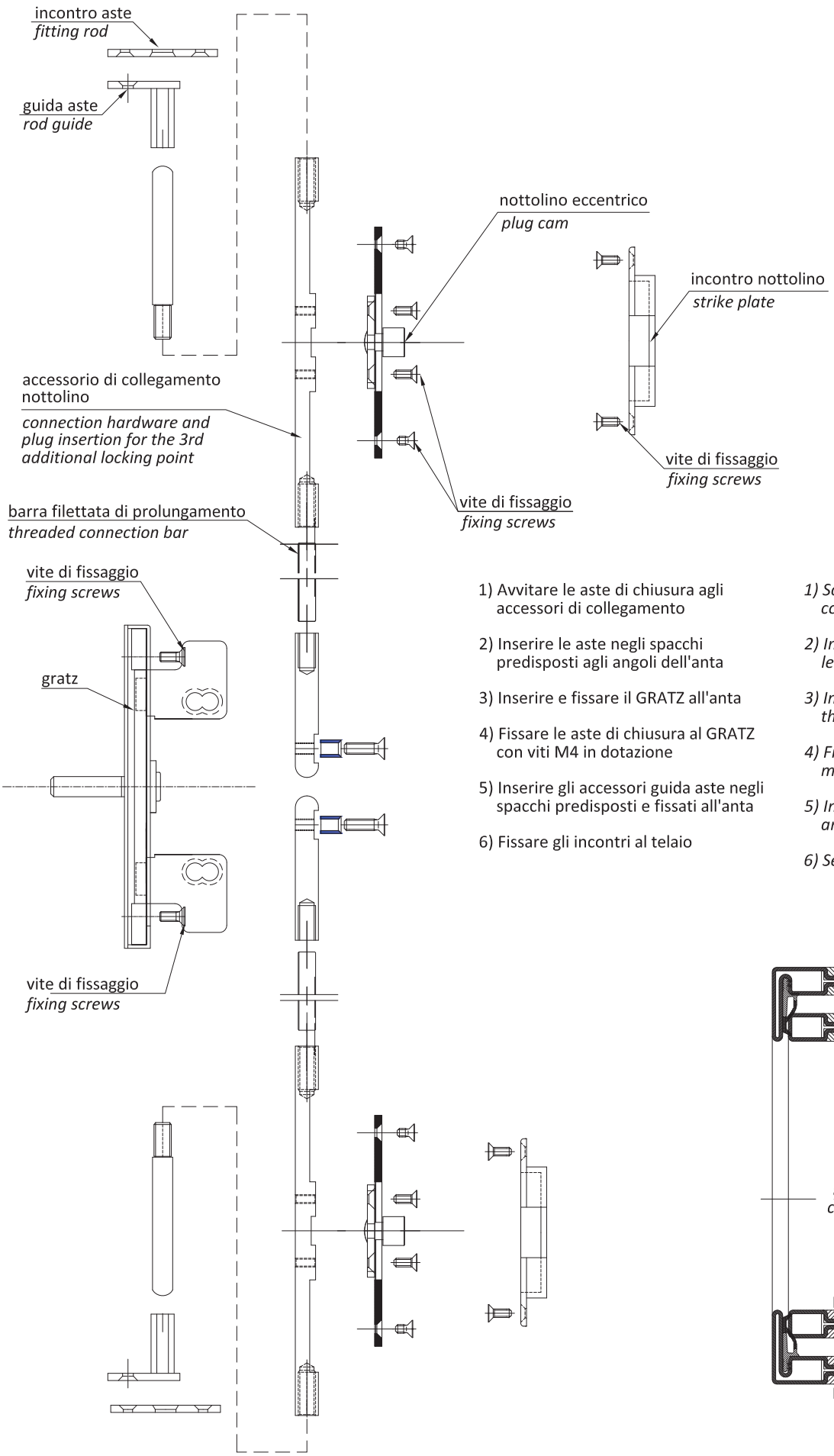



nottolino di chiusura
plug
H nottolino ad anta aperta - *H plug open leaf*
38.5
38.5
H nottolino ad anta aperta - *H plug open leaf*
H barra filettata - *H threaded bar*
H nottolino - 100 - *H ratchet - 100 mm.*
H barra filettata - *H threaded bar*
H nottolino - 100 - *H plug - 100 mm.*
nottolino di chiusura
plug


P.2863
P.2862


H barra filettata - *H threaded bar*
H nottolino - 100 - *H plug - 100 mm.*
H tra i nottolini
H plug





1) Avvitare le aste di chiusura agli accessori di collegamento

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

3) Inserire e fissare il GRATZ all'anta

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

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

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

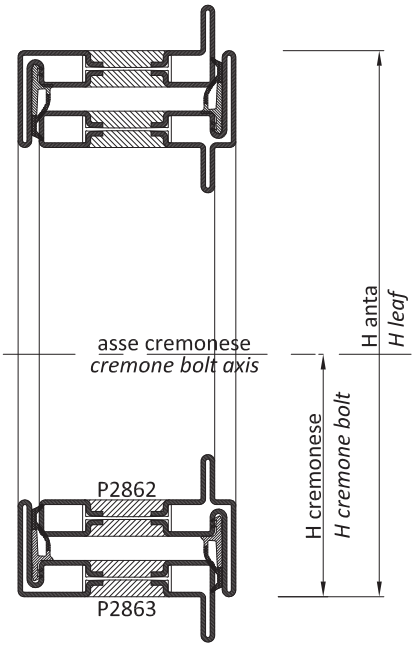
2) Insert the rods into the slits on the leaf corners

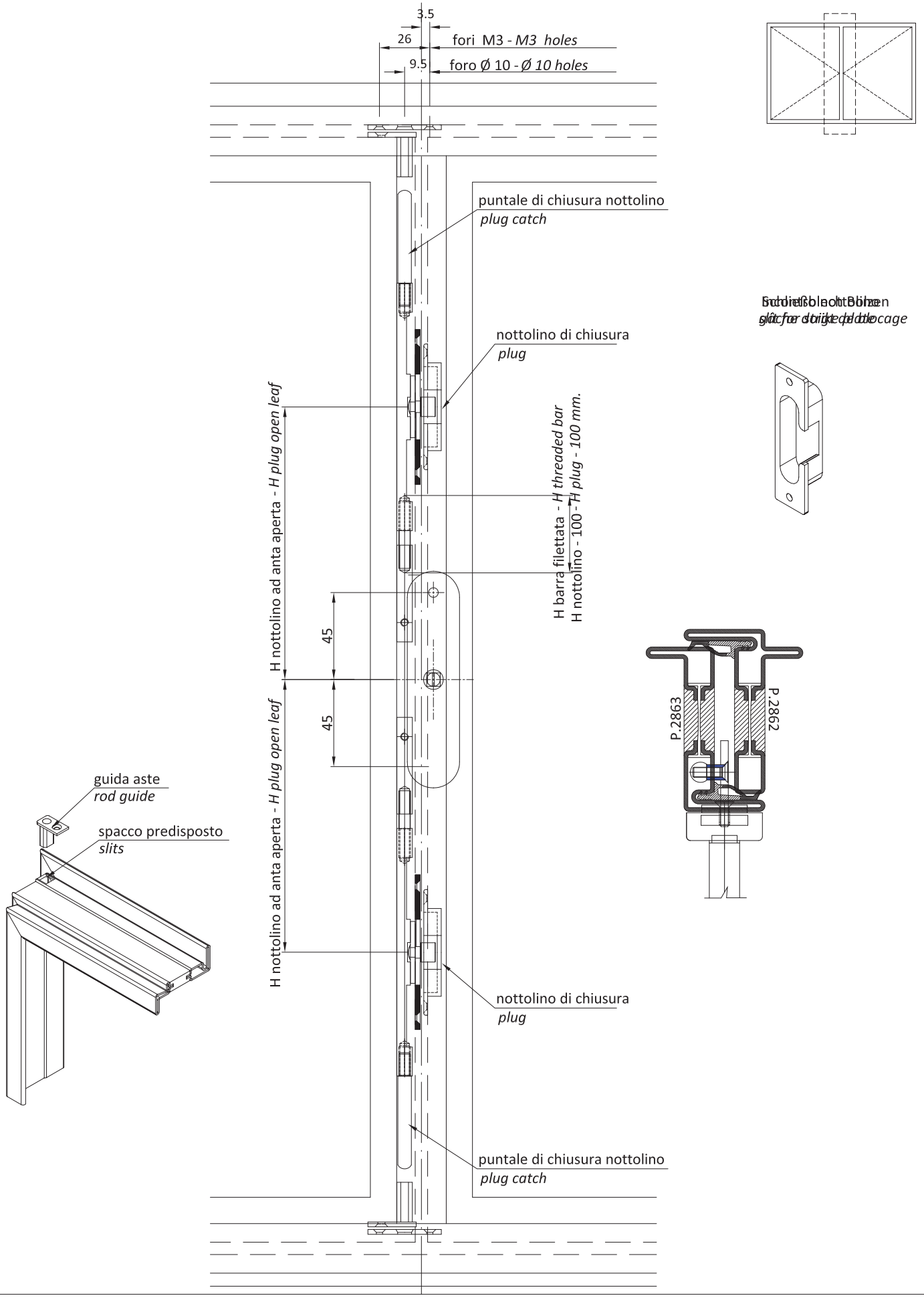
3) Insert the "GRATZ" mechanism into the leaf and secure

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

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

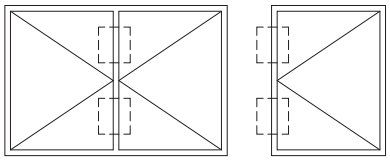
6) Secure the fittings to the frame

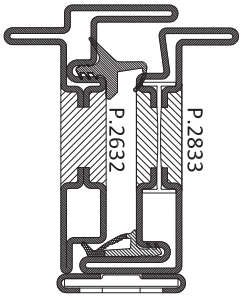


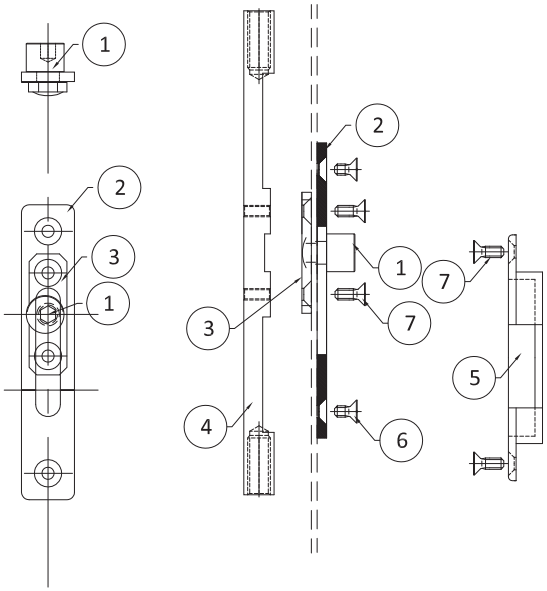

3.5
26
fori M3 - *M3 holes*
9.5
foro Ø 10 - *Ø 10 holes*
puntale di chiusura nottolino
plug catch
nottolino di chiusura
plug
H nottolino ad anta aperta - *H plug open leaf*
H barra filettata - *H threaded bar*
H nottolino - 100 - *H plug - 100 mm.*
45
45
H nottolino ad anta aperta - *H plug open leaf*
P.2863
P.2862
guida aste
rod guide
spacco predisposto
slits
nottolino di chiusura
plug
puntale di chiusura nottolino
plug catch

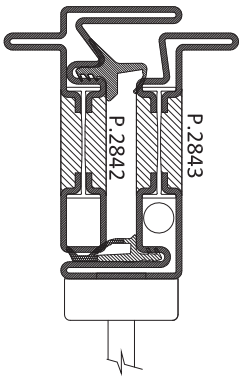
1) Rullino eccentrico
2) Piastra di fissaggio
3) Piastra di collegamento
4) Accessorio aggancio aste
5) Incontro 3^ chiusura
6) viti M3 x 6
7) viti M3 x 8

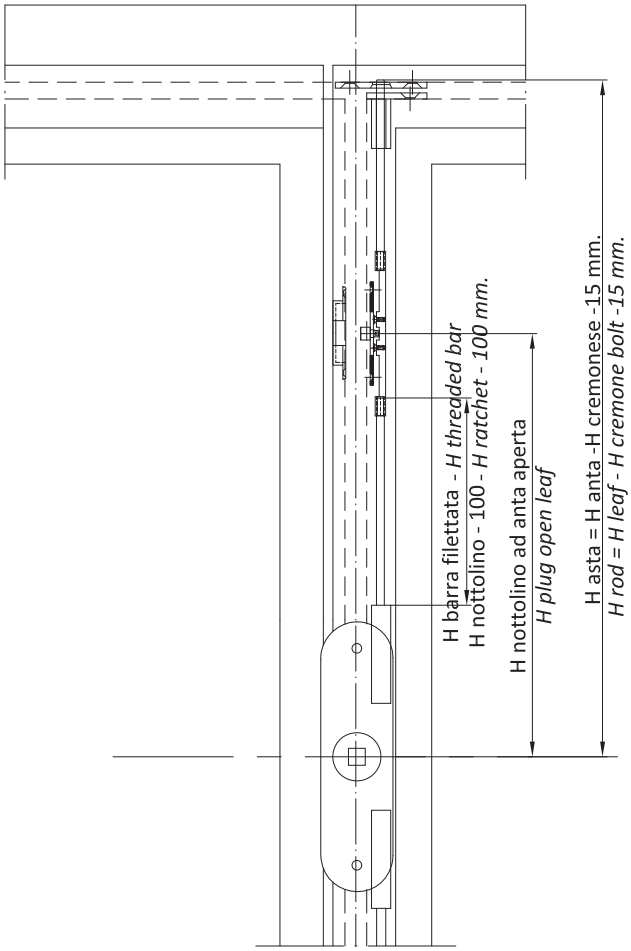
1) Barrel cam
2) Installation plate
3) Connecting plate
4) Rod docking accessory
5) 3rd lock strike plate
6) screws M3 x 6
7) screws M3 x 8

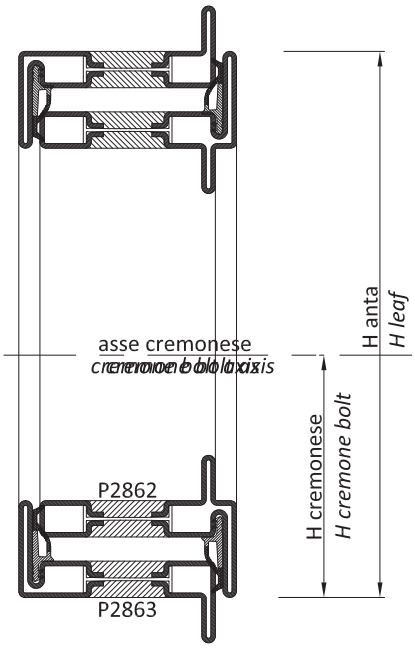


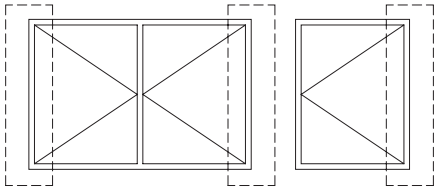


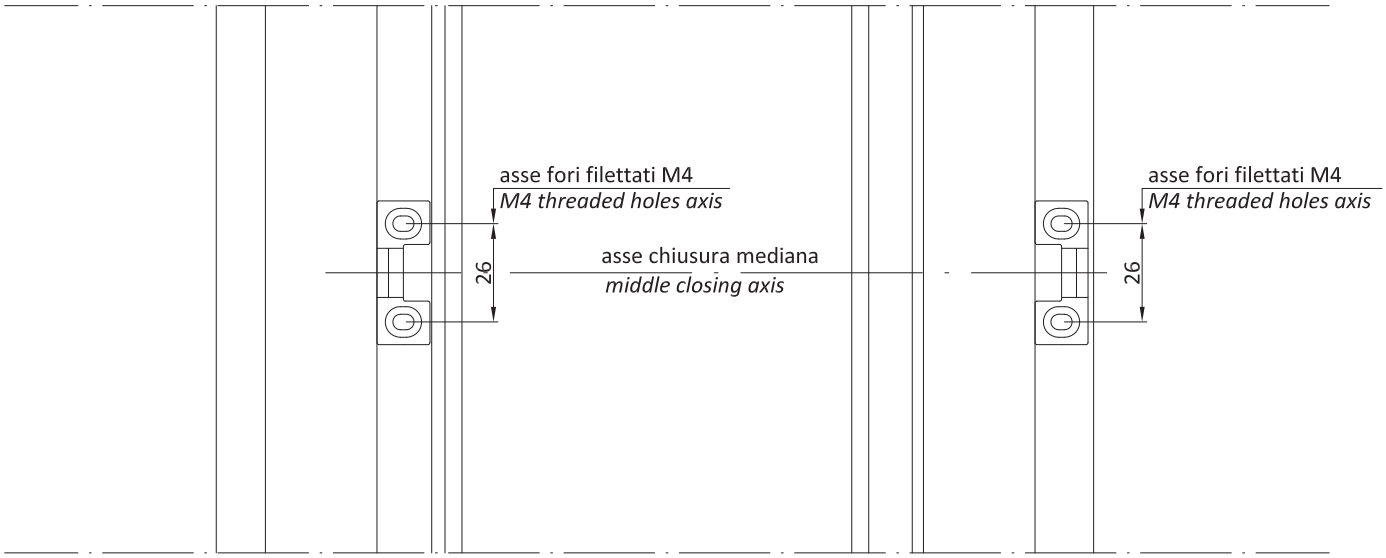


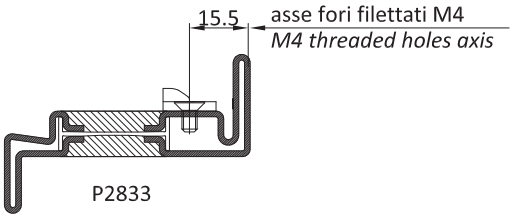


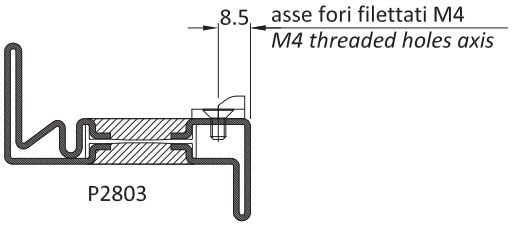


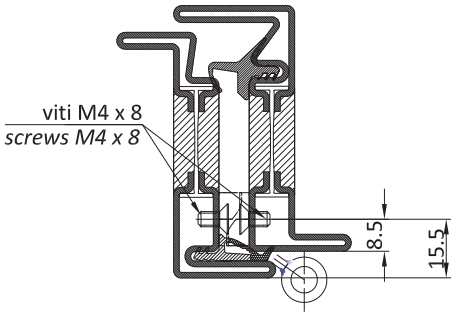


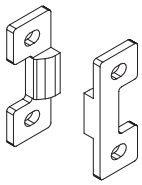






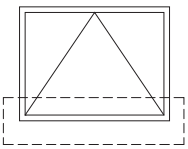


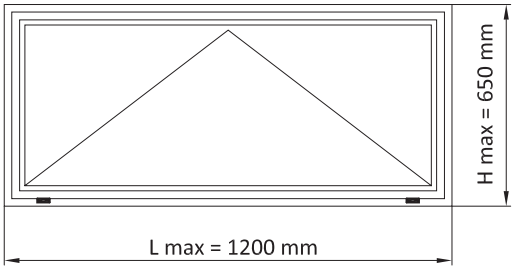


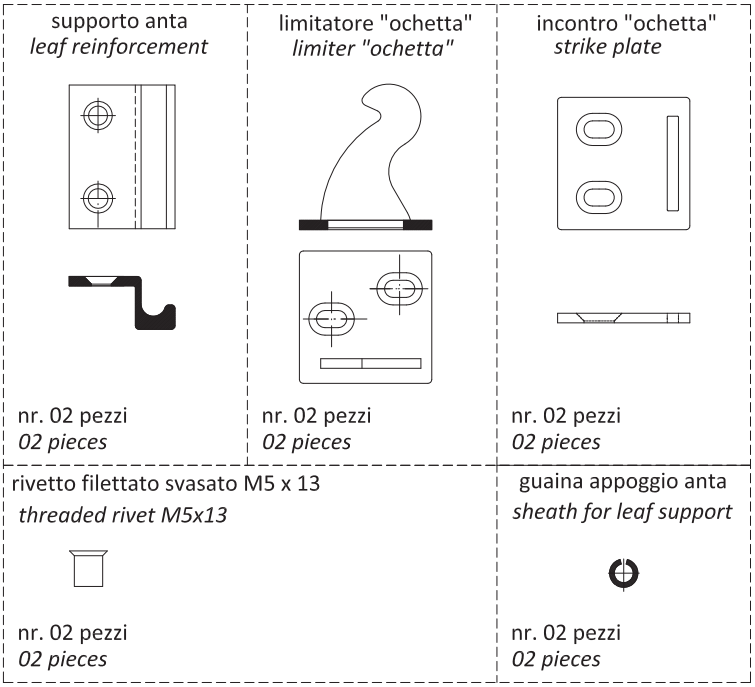


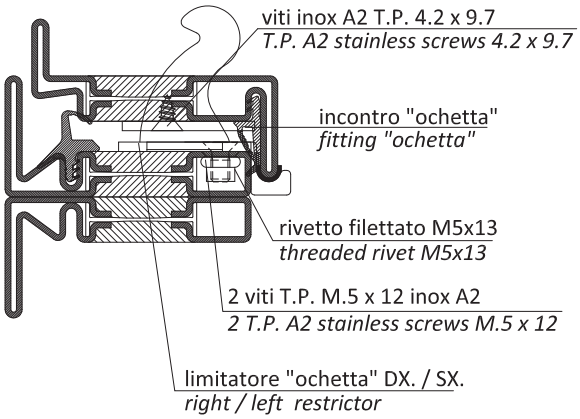
chiusura mediana
Middle closing

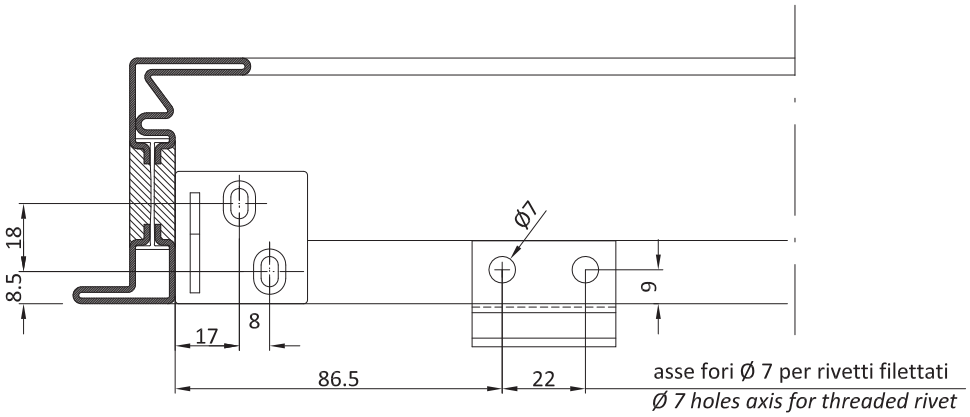
peso max. per anta: 40 kg.
max. leaf weight: 40 kg.

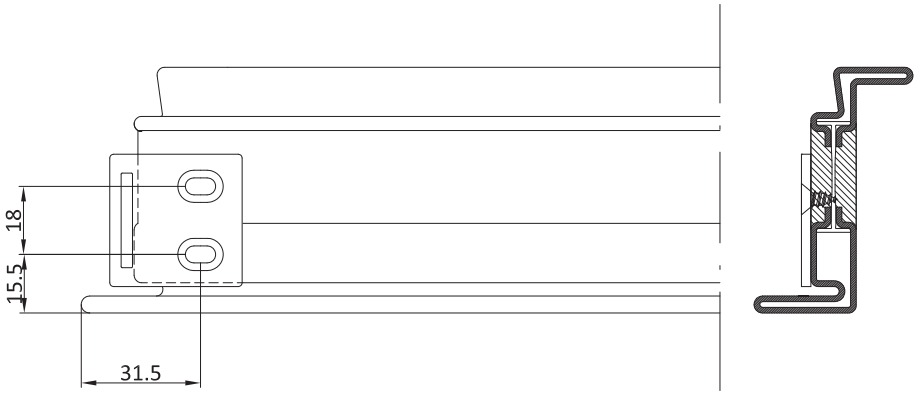




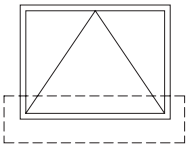


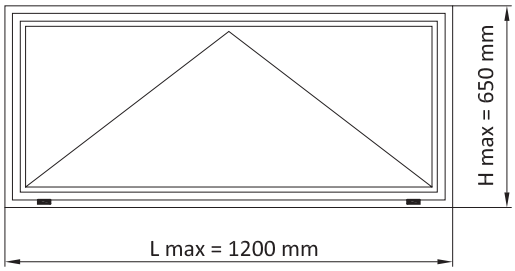


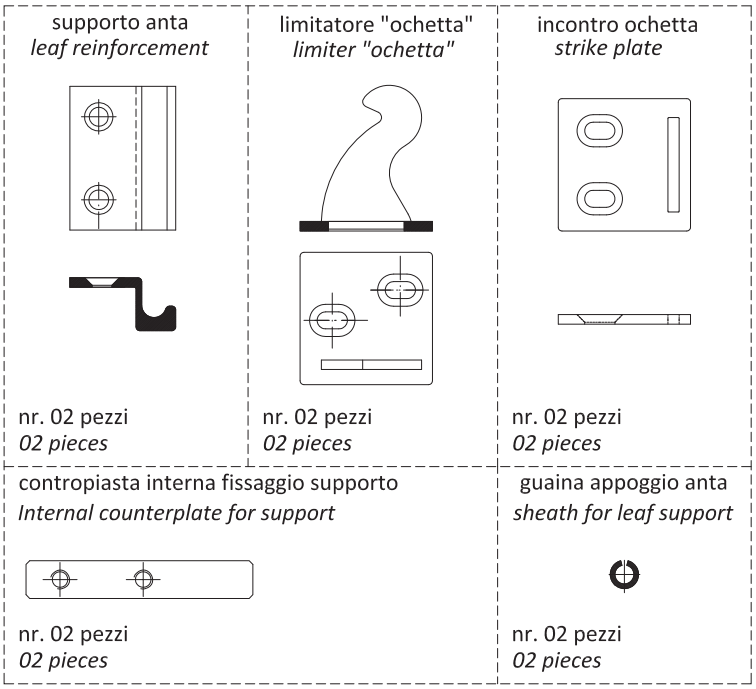


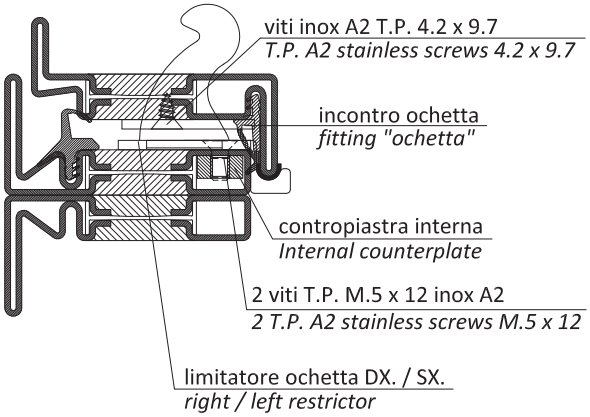


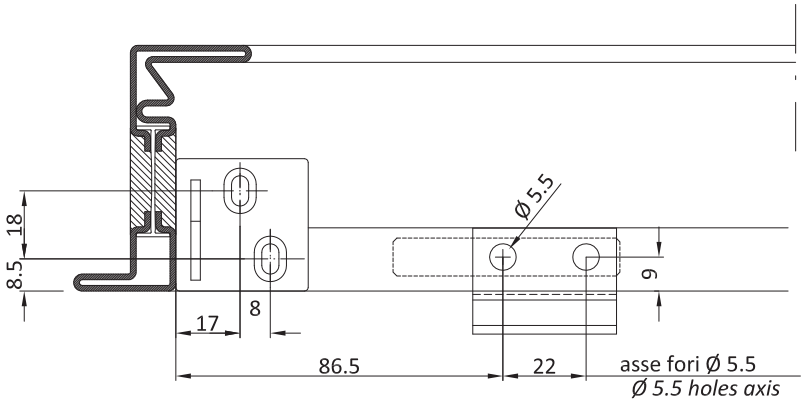
peso max. per anta: 40 kg.
max. leaf weight: 40 kg.

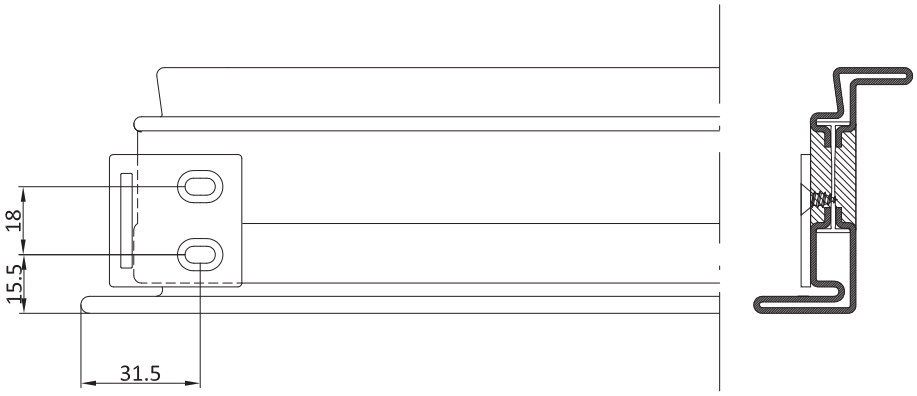


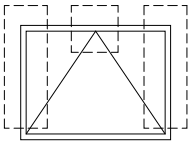




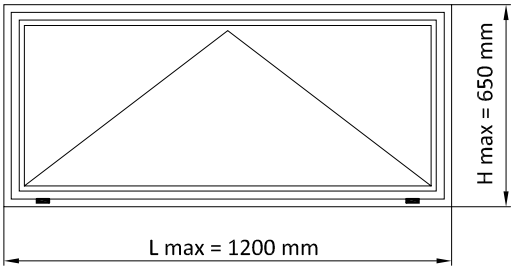


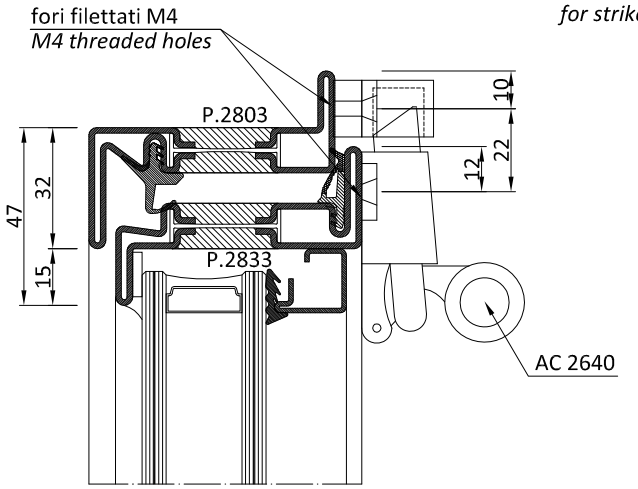


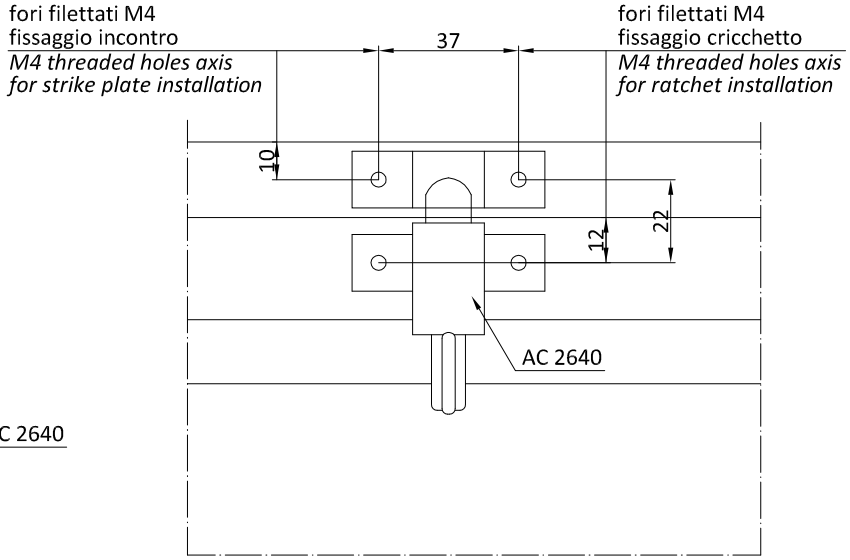


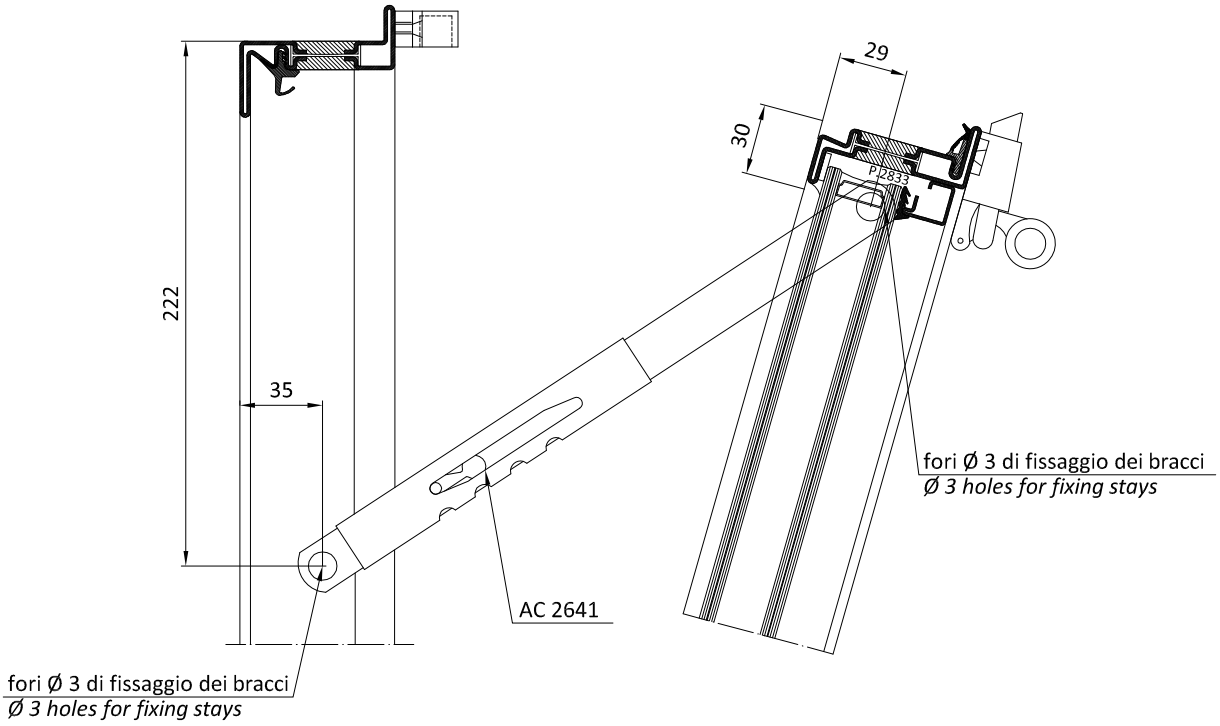


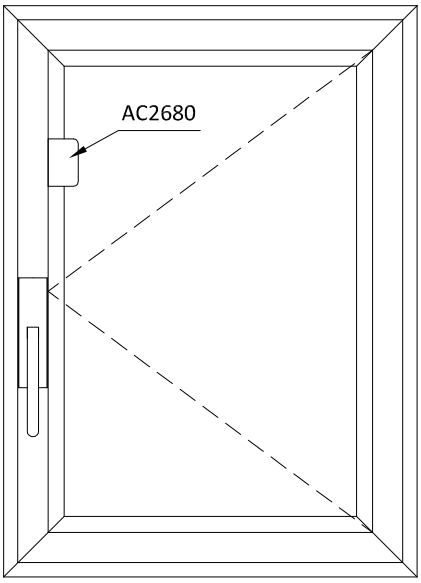
peso max. per anta: 40 kg.
max. leaf weight: 40 kg.

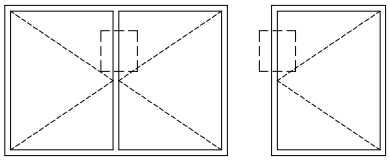


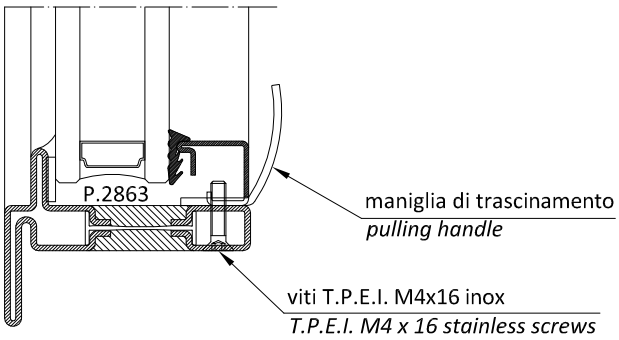


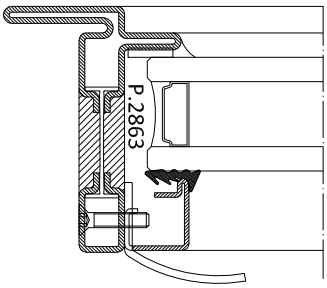


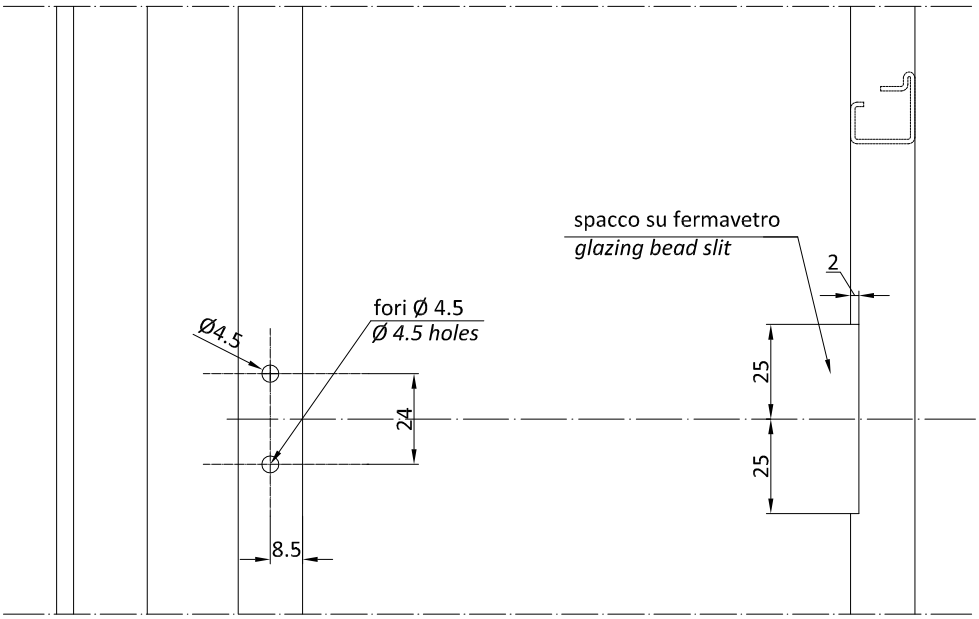






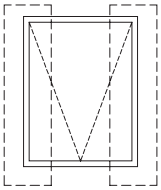


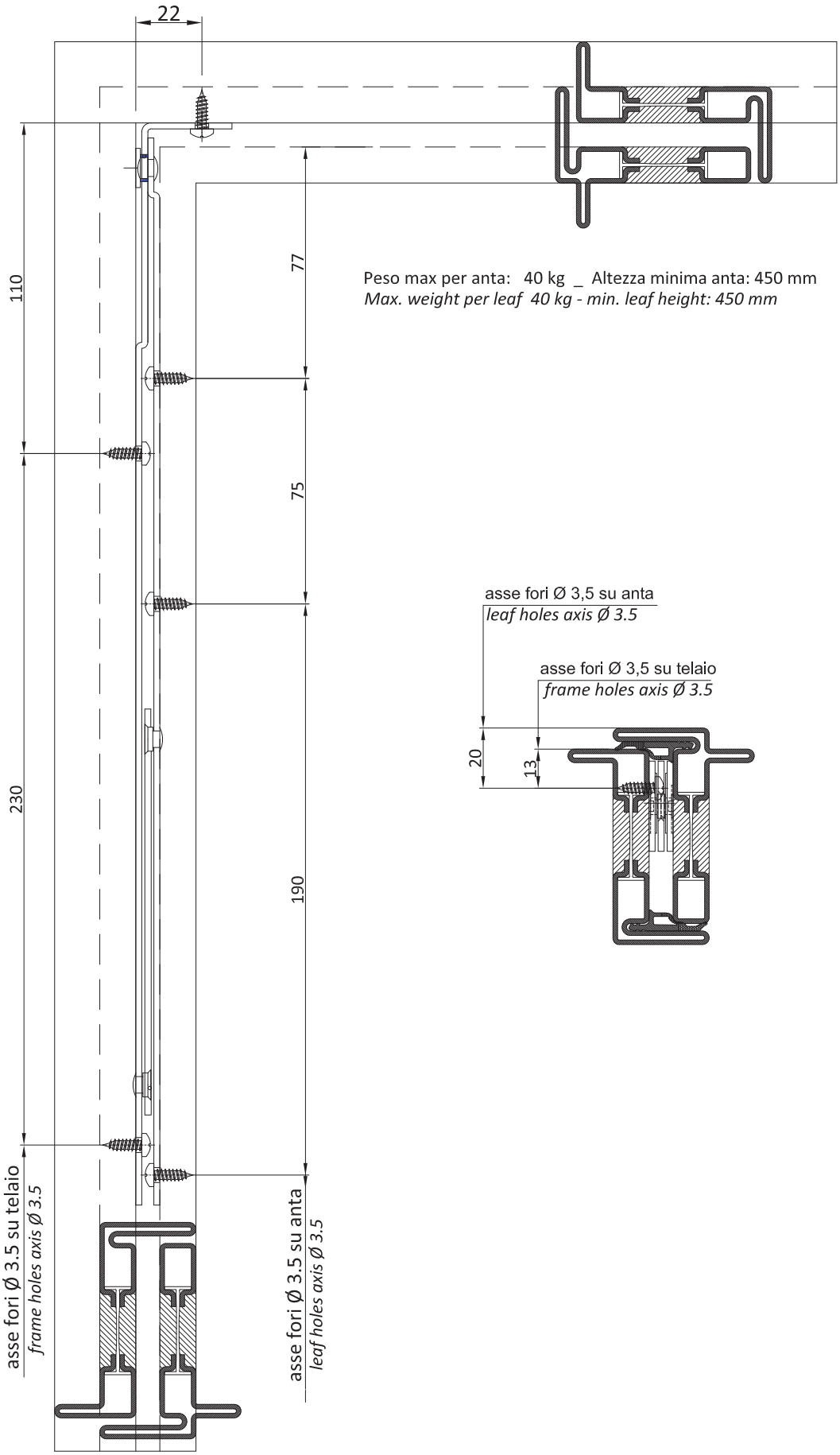




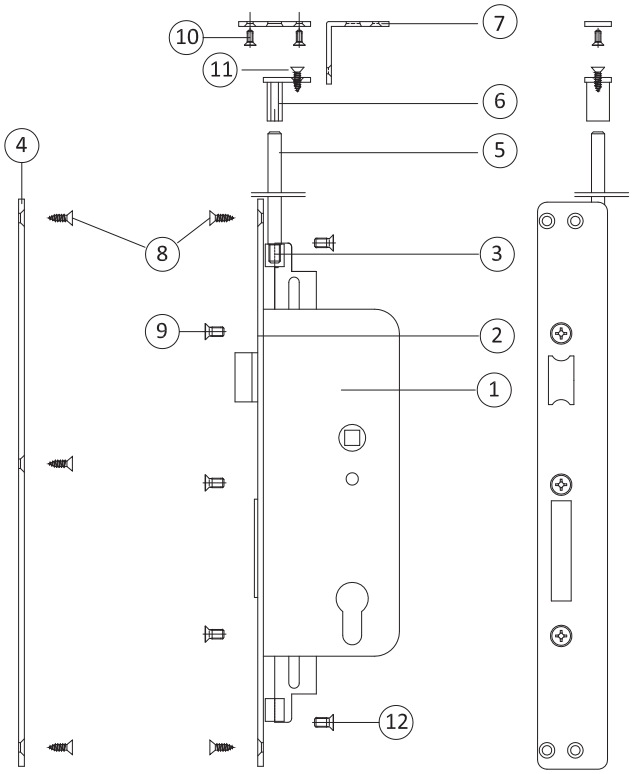
lavorazione su profilo
profile processing

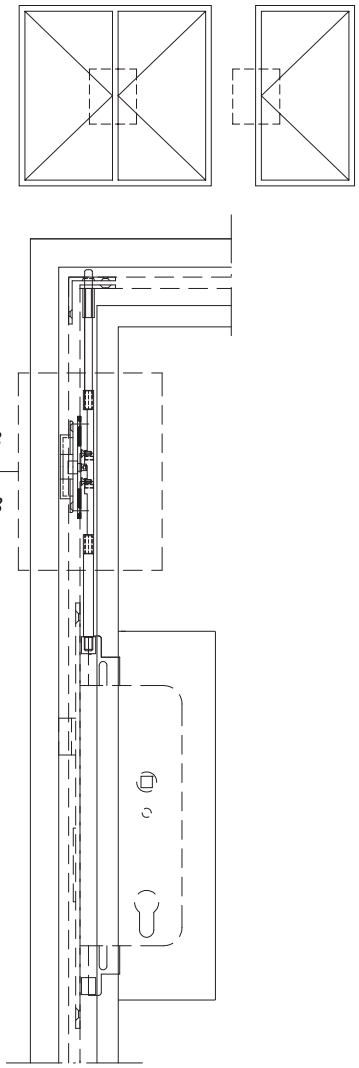
lavorazione su fermavetro
profile processing





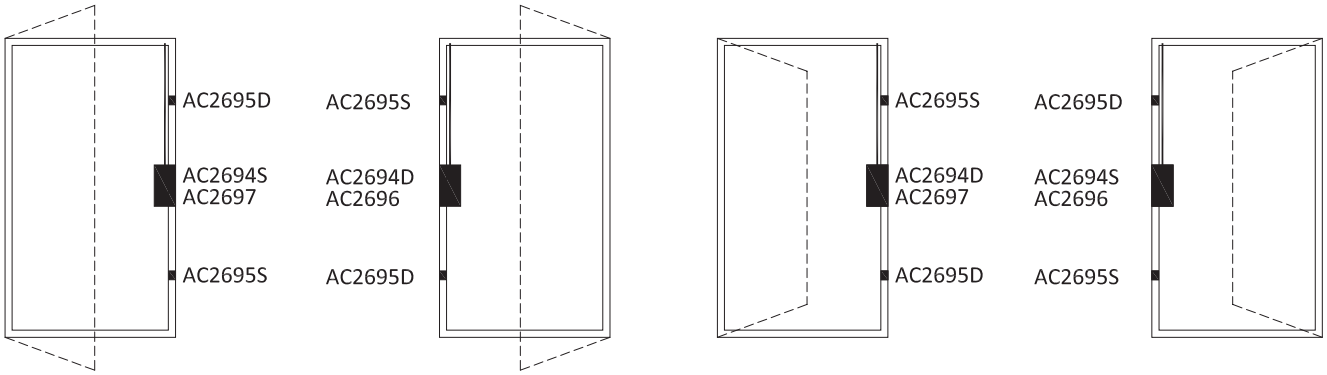
Peso max per anta: 40 kg _ Altezza minima anta: 450 mm
Max. weight per leaf 40 kg - min. leaf height: 450 mm

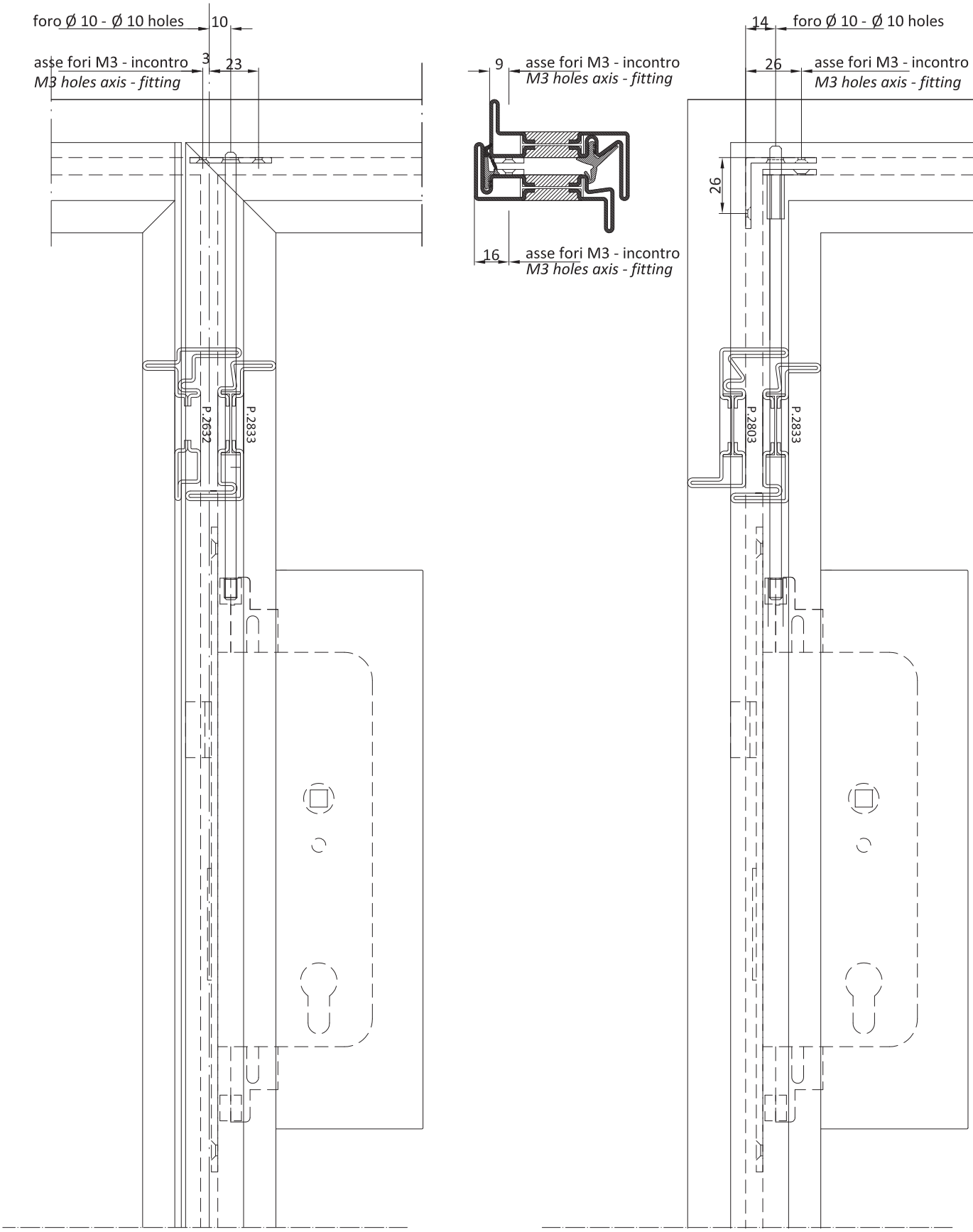


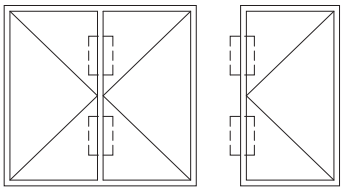


1)	Serratura	*1)*	*Lock*
2)	Frontalino (Dx o Sx)	*2)*	*Faceplate right/left*
3)	Riduttore di collegamento	*3)*	*Connecting adaptor*
4)	Incontro per serratura	*4)*	*Strike plate for lock*
5)	Aste inox	*5)*	*Stainless rods*
6)	Guida aste superiore	*6)*	*Upper rods guide*
7)	Incontro aste per porte a due ante	*7)*	*Rod fittings for two-leaf doors*
7 bis	Incontro aste per porte ad un anta	*7 bis*	*Rod fittings for one-leaf doors*
8)	Viti autof. Inox A2 T.P.T.C. 3,9x13	*8)*	*A2 T.P.T.C. 3.9x13 self-drilling stainless screws*
9)	Viti Inox T.P.T.C. m5x10	*9)*	*T.P.T.C. m5x10 stainless screws*
10)	Viti Inox T.P.E.I. 3x8	*10)*	*T.P.E.I. 3x8 stainless screws*
11)	Viti autof. Inox T.P.T.C. 3,5x13	*11)*	*T.P.T.C. 3.9 x 13 self-drilling stainless screws*
12)	Viti Inox T.S.P.E.I. M4x8	*12)*	*T.S.P.E.I. M4 x 8 stainless screws*

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

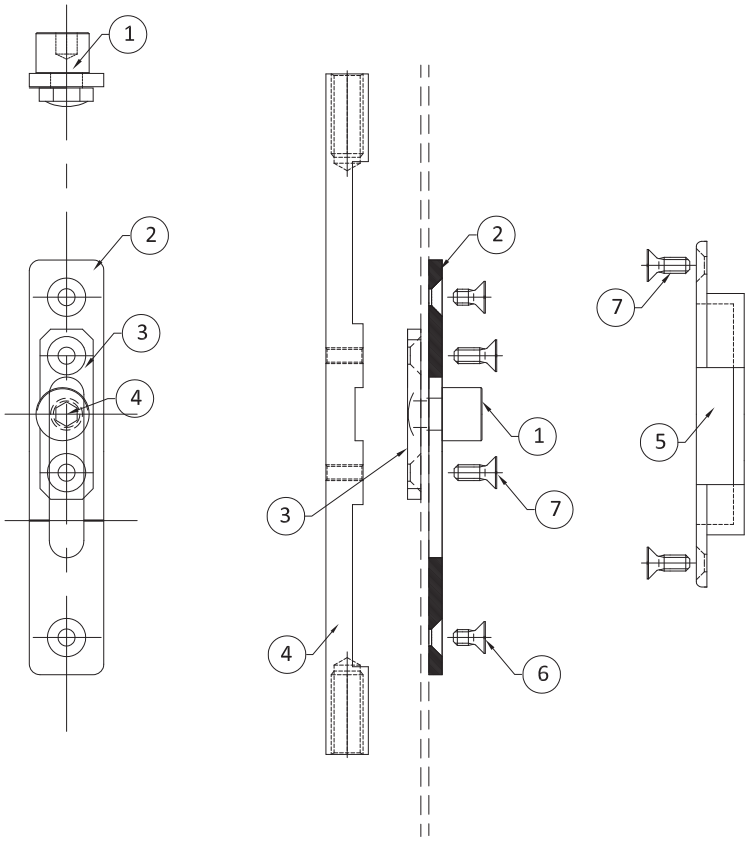



foro Ø 10 - Ø 10 holes
10
asse fori M3 - incontro
M3 holes axis - fitting
3
23
P.2632
P.2833
9
asse fori M3 - incontro
M3 holes axis - fitting
16
asse fori M3 - incontro
M3 holes axis - fitting
14
foro Ø 10 - Ø 10 holes
26
asse fori M3 - incontro
M3 holes axis - fitting
26
P.2803
P.2833

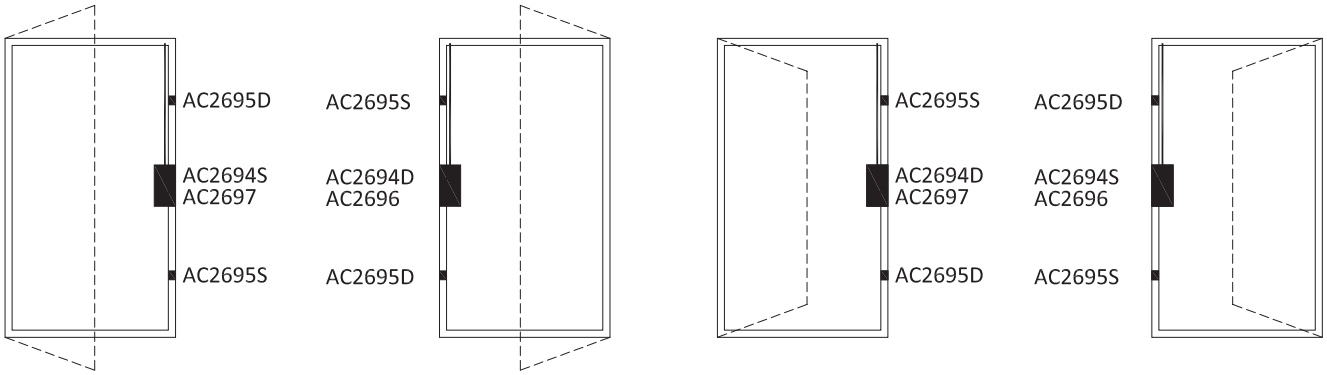


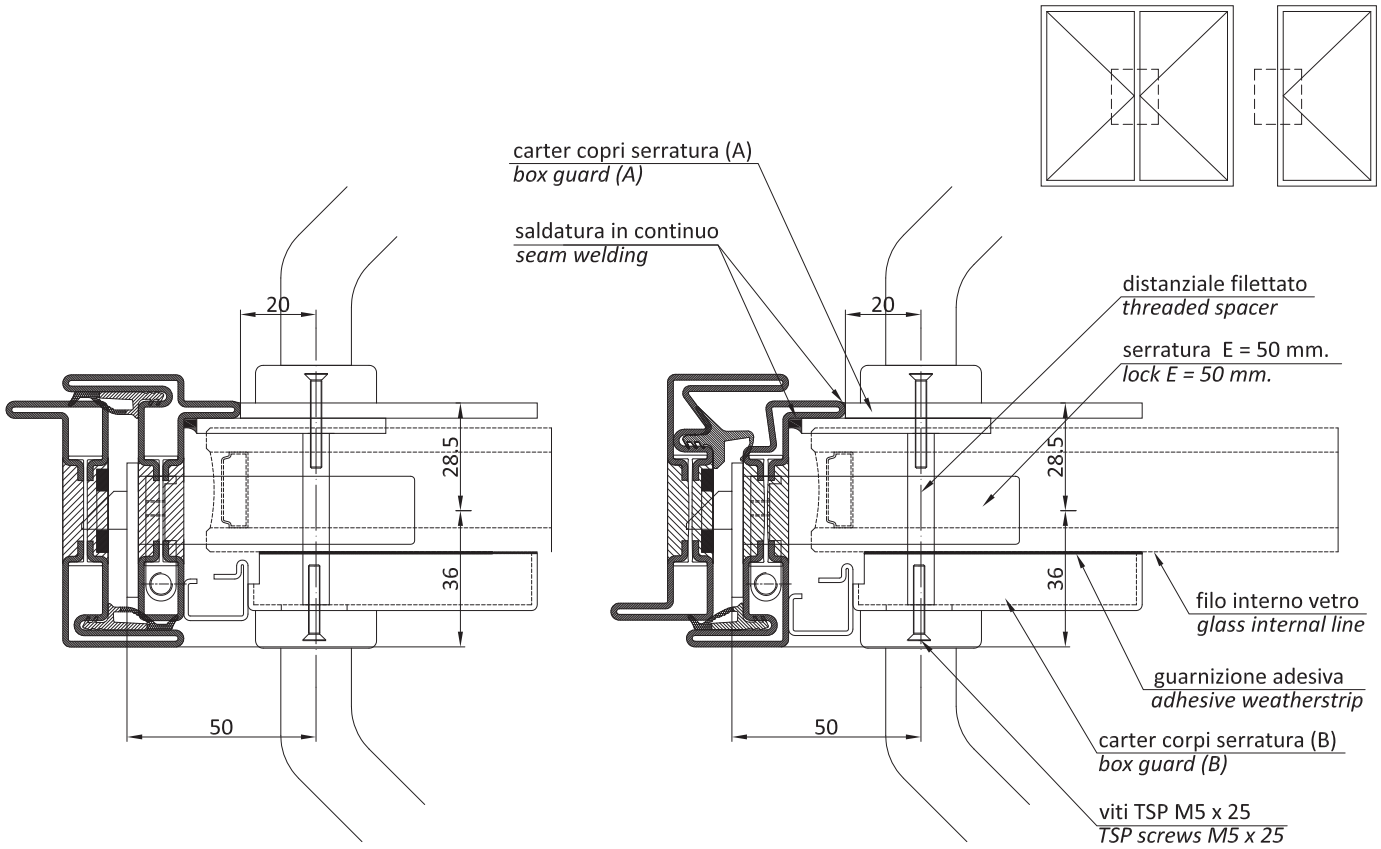
1) Rullino eccentrico
2) Piastra di fissaggio
3) Piastra di collegamento
4) Accessorio aggancio aste
5) Incontro 3^ chiusura
6) viti M3 x 6
7) viti M3 x 8

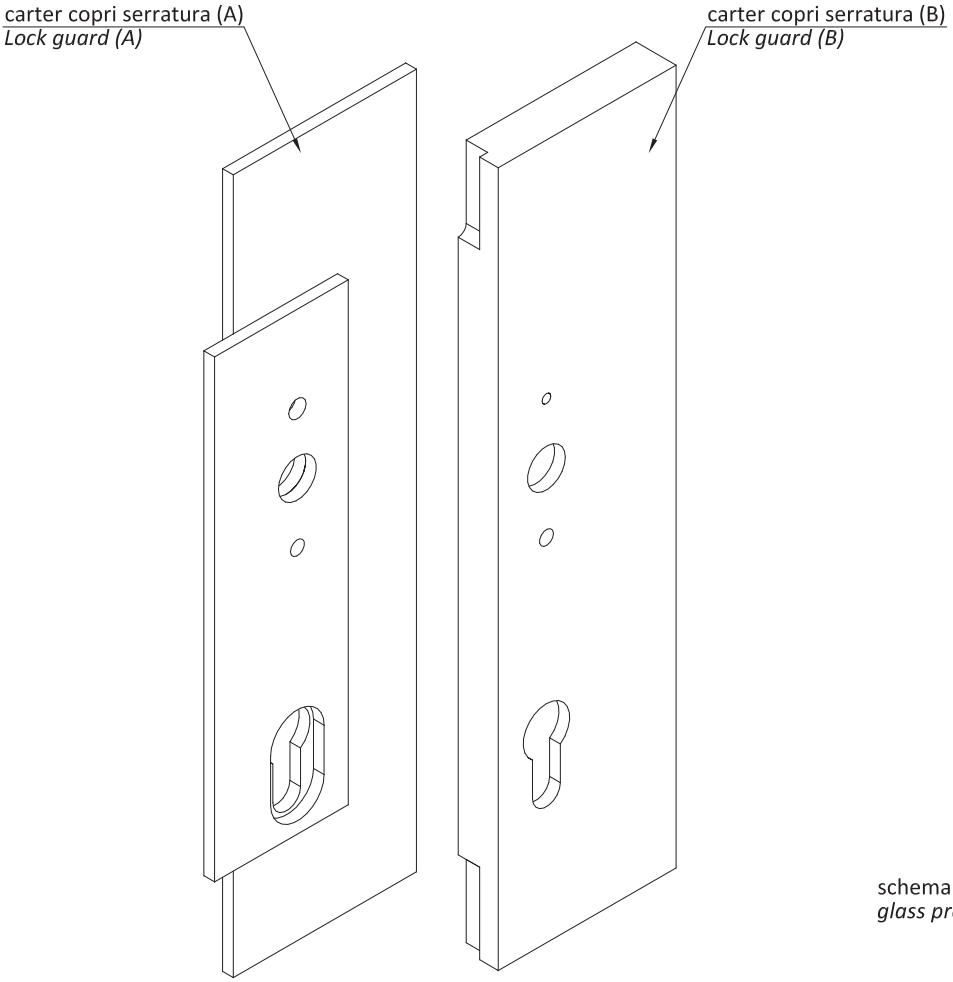
1) Barrel cam
2) Installation plate
3) Connecting plate
4) Rod docking accessory
5) 3rd lock strike plate
6) screws M3 x 6
7) screws M3 x 8

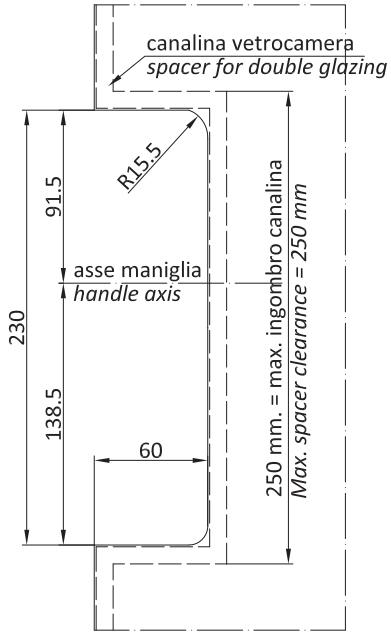


SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS



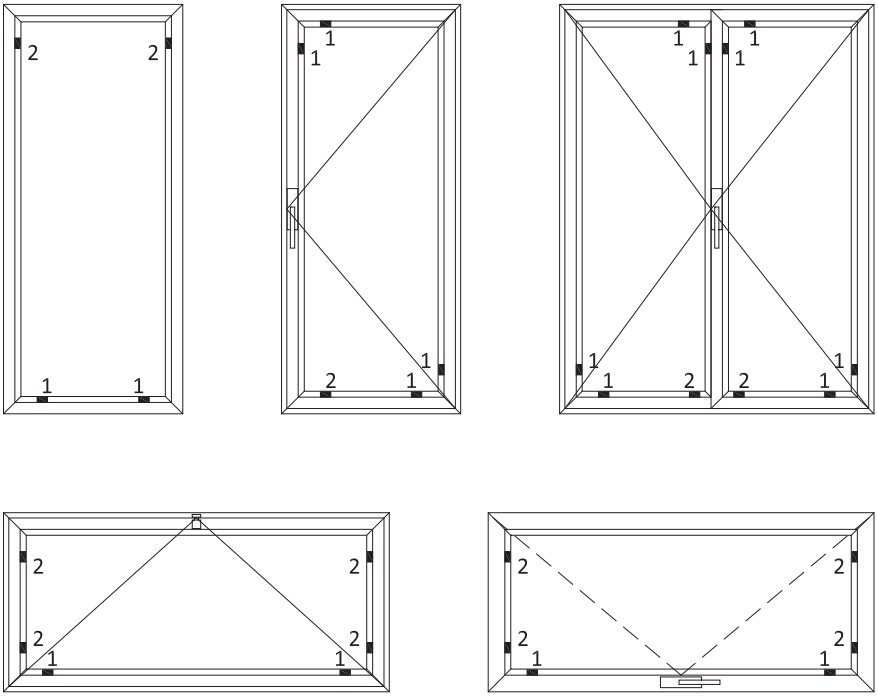






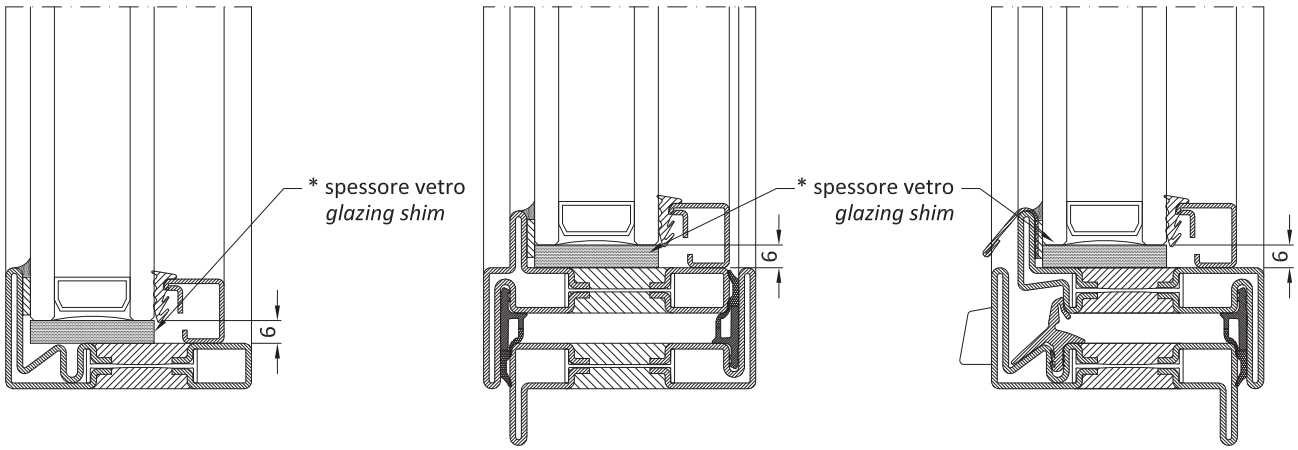
schema lavorazione vetro per inserimento serratura
glass processing scheme for lock insertion

finestra | *window*



1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*



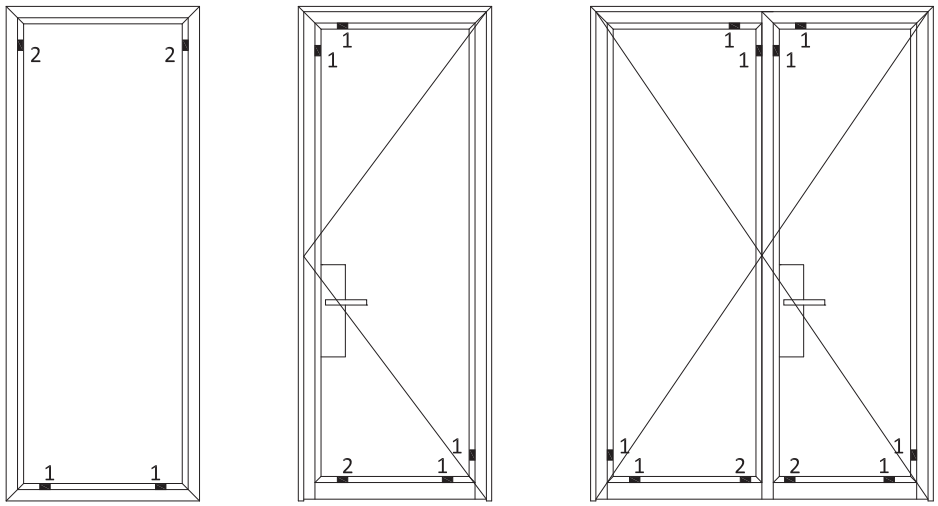
Note / *Note*

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

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

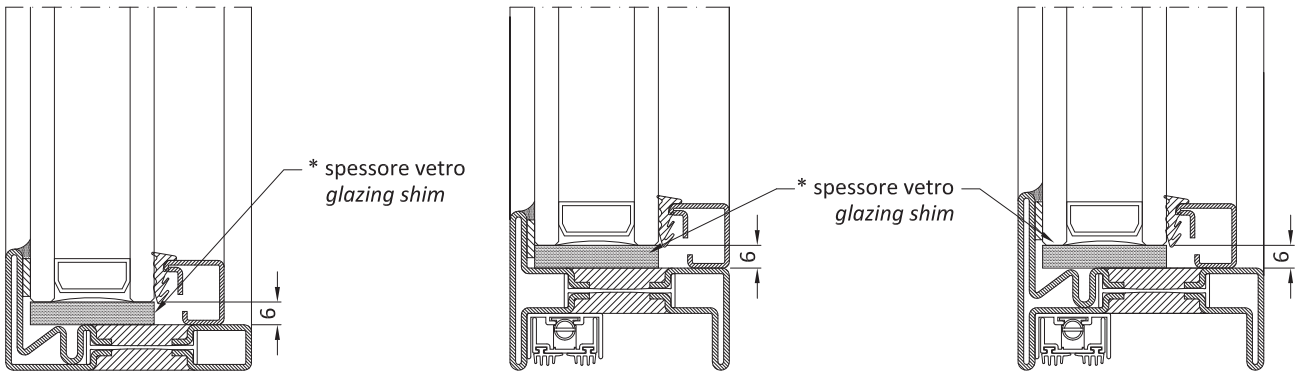
* spessori vetro non inclusi - *glazing shims not included*

porta | door



1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*



Note / *Note*

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
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- *The shims position has to be provided by using an appropriate material which avoids any movements.*

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

Tolleranze
OS2 è composto da una serie di profili dalle ridottissime dimensioni e prevede un accoppiamento dei telai esterni con le ante apribili con distanza di 8mm. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione:si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-1mm e la tolleranza per il sormonto degli stessi compresa tra +0/+0.5 mm.

Taglio/Lavorazioni
I profili OS2 in acciaio, acciaio inox e corten possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio, mentre per il taglio dei profili in ottone possono anche essere utilizzate troncatrici utilizzate per le serie di alluminio . Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2800) per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio sia per la sezione inclinata a 45° che per la sezione verticale a 90° dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura
I profili OS2 possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica ed evitando di saldare in prossimità della giunzione a taglio termico. L'eventuale riscaldamento del poliuretano libera sostanze gassose a base di aldeidi e CO: per tale ragione si consiglia di saldare con gli appositi DPI previsti e in zone con sufficiente areazione e in presenza di sistema per l'evacuazione dei fumi. I profili in corten devono essere saldati con apposito filo in corten mentre per i profili in ottone si può utilizzare un filo CuSi3. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura/Brunitura
I profili OS2 sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. La zona a taglio termico in poliuretano non è in grado di accogliere con sufficiente adesione le polveri poliesteri e perciò si consiglia di ricoprire tali zone, nelle sole parti destinate ad essere in vista, con apposite pellicole adesive idonee al passaggio in forno (SA1024/33/42/52). I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento.
Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrazione
Il sistema di fissaggio del vetro prevede l'utilizzo di fermavetri agganciati all'interno tramite clips o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione e, all'esterno, l'utilizzo di siliconatura o di inserimento di apposita guarnizione adesiva (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m^2 di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

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

Tolerance
OS2 is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm. To ensure the correct use of hardware and gaskets the processing must be performed with great care and precision. It is advised to keep the tolerance between +0/-1 mm for opening elements and between +0/+0.5mm for their overlapping area.

Cut / Processing
OS2 profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. OS2 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2800) to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between -1°/+1°. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

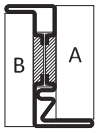
Welding
OS2 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special DPIs provided and in areas with sufficient ventilation and with fumes disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for a later painting without any visible imperfections (pores and ripples).
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised

Painting/Burnishing
OS2 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024/33/42/52). Holes must be drilled (as per instructions) in the frames before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooling.
It is advised to follow pre-treatment and painting cycles as outlined in Secco Sistemi documentation.

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

Set up
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, you should verify the proper behaviour of the window/door (easiness of opening/closing, stability of the open leaf, etc.), the correctness of joints and overlapping areas between opening leaves and fixed frames, the proper positioning of gaskets and seals, the drainage of frames with weep system and the absence of any aesthetic defects on the frame and glass surfaces.

P2801



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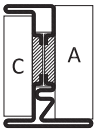

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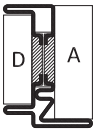

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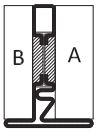

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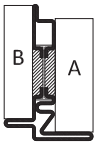

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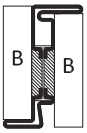

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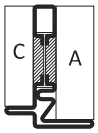

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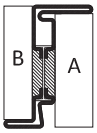

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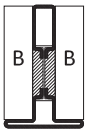

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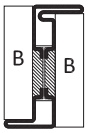

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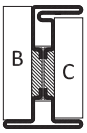

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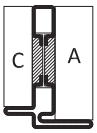

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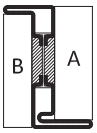

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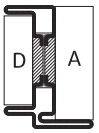

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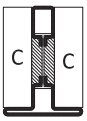

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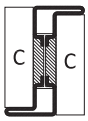

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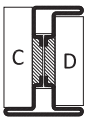

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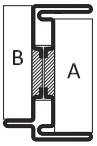

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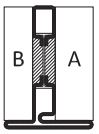

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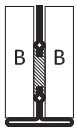

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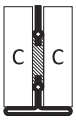

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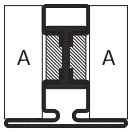

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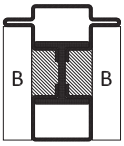

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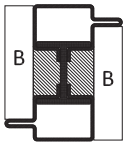

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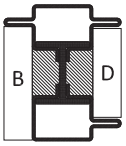

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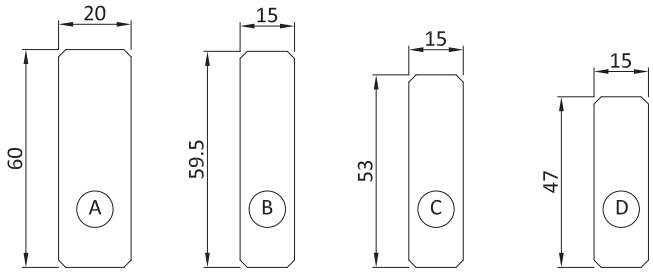

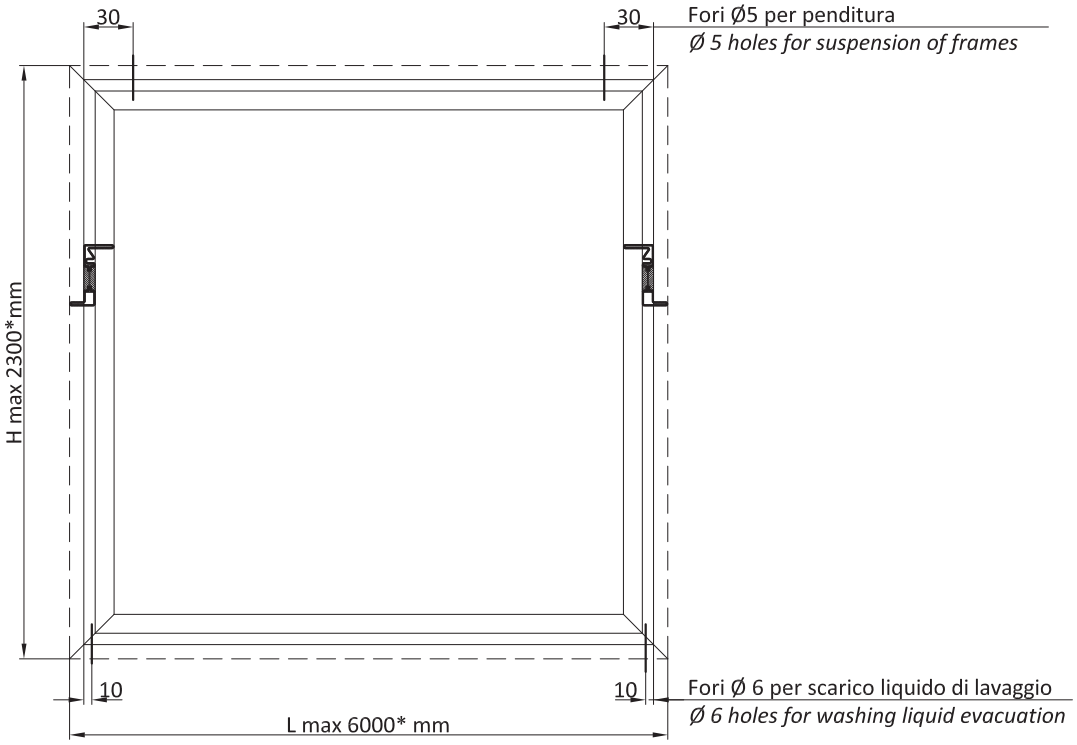

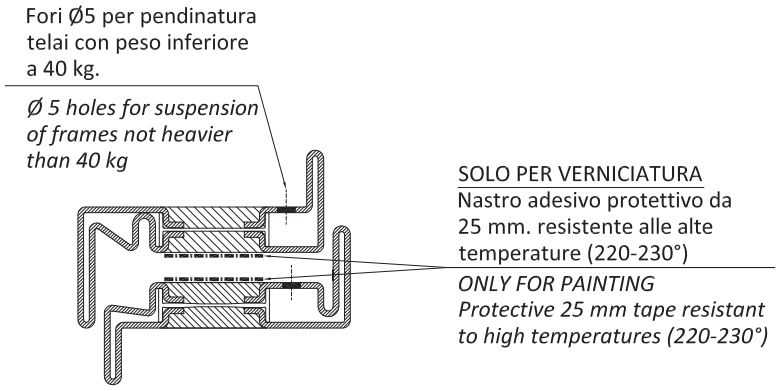

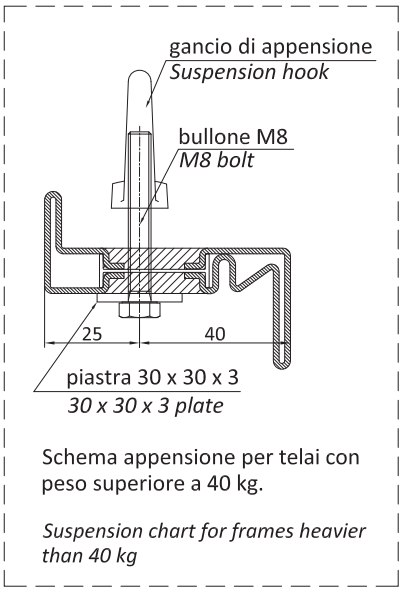

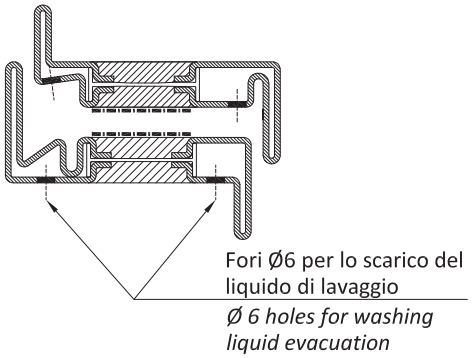

SOLO PER BRUNITURA

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

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

ONLY FOR BURNISHING

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

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

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

Troncatrice

caratteristiche minime della macchina

- Potenza: 1.8 – 2.5 kW;
- Possibilità di taglio a 45° nei due sensi e a 90°;
- Velocità di taglio ideali: 15-30 giri/min per acciaio inox;
  40-60 giri/min per acciaio zincato e decapato;
  90 giri/min per bronzo (OT/67);
- Capacita di taglio: 150 x 80 mm a 90° ;
  100 mm taglio a 45°.

caratteristiche della lama

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

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

Pantografo

caratteristiche minime della macchina

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

caratteristiche minime delle frese

- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle frese);
- Frese a 4 denti;
- Frese con diametro 5 mm per le lavorazioni di scasso (da 10 mm per abbassamento aggraffatura).

Forature

montaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

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

fresatura di cave e asole sui profili inox

- adoperare macchine (pantografi o fresatrici) adegute alle lavorazioni dell'acciaio.
- regolazione del numero di giri max (3000 giri/1').
- impiego di frese di diametro massimo di 8mm a 4 pale in acciaio HSS.
- abbondare con la lubrificazione, concentrata sull'utensile.
- ridurre l'avanzamento fino ad accertare un taglio il più regolare possibile.
- è normale un'usura accellerata dell'utensile.

Cutter

Minimum requirements for the use of the machine

- Power: 1.8 – 2.5 kW;
- Possibility of cutting at 45° in both directions and at 90°;
- Ideal cutting speed: 15-30 rpm for stainless steel;
  40-60 rpm for galvanised and stripped steel;
  90 rpm for bronze (OT/67);
- Cutting capability: 150 x 80 mm at 90°;
  100 mm cut at 45°.

Blade specifications

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

Note: OT/67 alloy can be cut with blades made for aluminium

Pantograph

Minimum requirements for the use of the machine

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

Minimum requirements for the use of a milling machine

- Material: HSS (please verify availability of longer lasting material on the market)
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing (a 10-mm to lower a hemming)

Drilling

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

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

Milling slots and loops in the profiles

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

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

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

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

2. Taglio barre e controllo barre / *Cut and Control of profiles*
   - Misura lunghezza / *Length measurement* — ±0.5 mm
   - Verifica 45° / *45° Control* — ± 1°
   - Verifica 90° / *90° Control* — ± 1°

3. Lavorazioni su barra / *Section processing*

Finestra / *Window*	Aperture interne / *Inward opening*		Aperture esterne / *Outward opening*	
Fori per cerniere a tre ali *Three-wing hinge holes*	AC2628 sez 4.3.16|17	AC2648 sez 4.3.20|21	AC2648 sez 4.3.22|23	
Foratura per cerniera a due ali *Two-wing hinge holes*	AC2629/30 sez 4.3.18|19	AC2649/50 sez 4.3.24|25	AC2649/50 sez 4.3.26|27	
Fori e asole per cremonese anta singola *Single leaf windows espagnolette holes*	AC2623 sez 4.3.7	AC2625 sez 4.3.10	AC2683 sez 4.3.11|12	
Fori e asole per cremonese anta doppia *Double leaf windows espagnolette holes*	AC2624 sez 4.3.8	AC2624 sez 4.3.9	AC2684 sez 4.3.13|14	
Fori e asole per chiusura supplementare *Additional locking points slots and holes*	AC2626R sez 4.3.15			
Fori per scarico acqua *Water drip holes*	AC2618 sez 4.3.5			
Taglio punta per inversione battuta *Secondary leaf top central joint working*	AC2603/4 sez 4.3.2	AC2643/4 sez 4.3.3		
Fori inserimento rinforzi cerniere *Hinge reinforcement holes*	- sez 4.3.1			
Fresatura per catenacci 2° anta *Secondary leaf flush bolt milling*	AC2621R/M sez 4.3.31		AC2621R/M sez 4.3.31	
Fori limitatori apertura per apertura ad anta *Restrictor stays holes*			AC2687 sez 4.3.28	
Fresature per compassi sporgere *Stay arm for awning windows milling*			AC2688 sez 4.3.29	
Fresature per limitatori sporgere *Stay arm for awning windows milling*	-	-	AC2690 sez 4.3.30	
Fori staffe per P.2610 *P.2610 coupling brackets holes*	AC2610 sez 4.3.4			
Lavorazione gocciolatoio *Water drip section workink*	P.2620 sez 4.3.6			
Fori fissaggio a muro *Wall mounting holes*				

Porta / *Door*	Aperture interne / *Inward opening*		Aperture esterne / *Outward opening*	
Fori per cerniere a tre ali *Three-wing hinge holes*	AC2628 sez 4.3.16|17	AC2648 sez 4.3.20|21	AC2648 sez 4.3.22|23	
Foratura per cerniera a due ali *Two-wing hinge holes*	AC2629/30 sez 4.3.18|19	AC2649/50 sez 4.3.24|25	AC2649/50 sez 4.3.26|27	
Fori e asole per serratura e incontri *Lock and strike slots and holes*	AC2693 sez 4.3.34	AC2694 sez 4.3.35	AC2693 sez 4.3.34	AC2694 sez 4.3.36
Fori e asole per chiusura supplementare *Additional locking points slots and holes*	AC2695 sez 4.3.37		AC2695 sez 4.3.38	
Taglio punta per inversione battuta *Secondary leaf top central joint working*	AC2603/4 sez 4.3.2	AC2643/4 sez 4.3.3		
Fori inserimento rinforzi cerniere *Hinge reinforcement holes*	- sez 4.3.1			
Fresatura per catenacci 2° anta *Secondary leaf flush bolt milling*	AC2621R/M sez 4.3.31		AC2621R/M sez 4.3.31	
Fori fissaggio a muro *Wall mounting holes*	-	-	-	-

4. Assiemaggio / *Assembly*

Finestra / *Window*	Aperture interne / *Inward opening*		Aperture esterne / *Outward opening*	
Costruzione telai				
Inserimento squadrette (profili ottone) – Saldatura / *Brackets insertion (brass section) - Welding*	AC28xx sez 4.4.1|3		AC28xx sez 4.4.1|3	
Sigillatura interna della giunzione (ottone) *Internal joint sealing (brass sections)*	AC28xx sez 4.4.1|3		AC28xx sez 4.4.1|3	
Taglio punta per inversione battuta *Secondary leaf top central joint working*	AC2603/4 sez 4.3.2		AC2643/4 sez 4.3.3	
Applicazione accessori				
Fori inserimento rinforzi cerniere *Hinge reinforcement holes*	- sez 4.3.1			
Fori per cerniere a tre ali *Three-wing hinge holes*	AC2628 sez 4.3.16|17	AC2648 sez 4.3.20|21	AC2648 sez 4.3.22|23	
Foratura per cerniera a due ali *Two-wing hinge holes*	AC2629/30 sez 4.3.18|19	AC2649/50 sez 4.3.24|25	AC2649/50 sez 4.3.26|27	
Saldatura cerniere a saldare *Hinge welding*	AC2631/32 sez 4.4.4|6		AC2631/32 sez 4.4.4|6	
Fori snapper 2° anta *Secondary leaf snapper holes*	AC2622 sez 4.5.7		AC2622 sez 4.5.7	
Fori cerniera a scomparsa vasistas *Concealed hinges for bottom hung window holes*	AC2639 sez 4.5.16|17			
Fori cricchetto e braccetti vasistas *Finger catch and stay arms for bottom hung window holes*	AC2640/41 sez 4.5.18			
Fori chiusure mediane a scomparsa Concealed medians closures holes	AC2627 sez 4.5.15			
Fori maniglia trascinamento seconda anta *Fixed handle for secondary leaf holes*			AC2680 sez 4.5.19	
Fori limitatori apertura per apertura ad anta *Restrictor stays holes*			AC2687 sez 4.3.28	
Fori compassi sporgere *Stay arm for awning windows holes*			AC2688 sez 4.3.29	AC2689 sez 4.5.20
Fori limitatori sporgere *Stay arm for awning windows holes*	-	-	AC2690 sez 4.3.30	

Porta / *Door*	Aperture interne / *Inward opening*		Aperture esterne / *Outward opening*	
Costruzione telai / *Frame assembly*				
Inserimento squadrette (profili ottone) – Saldatura / *Brackets insertion (brass section) - Welding*	AC28xx sez 4.4.1|3		AC28xx sez 4.4.1|3	
Sigillatura interna della giunzione (ottone) *Internal joint sealing (brass sections)*	AC28xx sez 4.4.1|3		AC28xx sez 4.4.1|3	
Taglio punta per inversione battuta *Secondary leaf top central joint working*	AC2603/4 sez 4.3.2		AC2643/4 sez 4.3.3	

Applicazione accessori / *Accessories installation*

Fori inserimento rinforzi cerniere *Hinge reinforcement holes*	- sez 4.3.1		
Fori per cerniere a tre ali *Three-wing hinge holes*	AC2628 sez 4.3.16|17	AC2648 sez 4.3.20|21	AC2648 sez 4.3.22|23
Foratura per cerniera a due ali *Two-wing hinge holes*	AC2629/30 sez 4.3.18|19	AC2649/50 sez 4.3.24|25	AC2649/50 sez 4.3.26|27
Saldatura cerniere a saldare *Hinge welding*	AC2631/32 sez 4.4.4|6		AC2631/32 sez 4.4.4|6
Lavorazione per paraspiffero automatico *Automatic door bottom seal installation holes*	AC2636 sez 4.3.32		AC2636 sez 4.3.33

5. Preparazione per verniciatura - brunitura / *Preparation for the powder coating - burnishing*
   a. Fori su telaio per scarichi liquidi pretrattamento — sez 5.1.4
      Holes on frame for the drainage of pretreatment liquid
   b. Marcatura e imballo telai esterni e ante — -
      External frames and leafs branding and packing
   c. Marcatura e imballo telai fermavetro — -
      Glazingbeads frames branding and packing
   d. Marcatura e imballo profili complementari — -
      Additional profiles branding and packing
   e. Imballo scarichi acqua e cerniere — -
      Accessories (water drip, hinges) branding and packing

6. Applicazione accessori e sigillatura / *Hardware and accessories installation and sealing*
   a. Porta / *Door*
      i. Montaggio cerniere / *Hinges installation* — sez 4.3.16|27
      ii. Montaggio serratura e incontri / *Lock and strikes installation* — sez 4.5.21|24
      iii. Applicazione paraspiffero automatico / *Automatic door bottom seal installation holes* — sez 4.3.32|33
      iv. Montaggio catenaccio / *Flush bolt installation* — sez. 4.3.31
      v. Montaggio guarnizioni di battuta / *Gasket installation*
      vi. Sigillatura angolo nel TT / *Corner joint sealing*
   b. Finestra e fissi
      i. Applicazione e sigillatura guarnizioni giunto aperto / *Sealing of central gasket* — sez 4.5.1
      ii. Applicazione scarichi acqua / *water drip installation* — sez 4.5.1
      iii. Montaggio cerniere / compassi / vasistas etc / *Hinges and arms installation (side hung, bottom hung, awning, etc)* — sez 4.5.15|20
      iv. Montaggio cremonese e incontri / *Espagnolette installion* — sez 4.5.2|14
      v. Montaggio guarnizioni di battuta / *Gasket installation*
      vi. Sigillatura angolo nel TT / *Corner joint sealing*

7. Vetrazione / *Glazing*
   a. Applicazione clips fermavetro / *glazing bead clips installation* — sez 2.8.1|6
   b. Applicazione guarnizione esterna / *External glazing gasket installation*
   c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* — sez 4.6.1|2
   d. Inserimento fermavetri / *Glazing beads application*
   e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
   f. Verifica corretta compressione guarnizione / *Control of the right compression of the gasket*

8. Controlli su prodotto finito / *Control on finished element*
   a. Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* — +0,+0.5 mm
   b. Verifica sormonto anta su telaio / *Control of leaf surmount* — +0, +1 mm
   c. Verifica sigillature per scarico acqua / *Control of central gasket sealing* — test con acqua su giunto / *test with water*
   d. Verifica funzionamento cremonese/maniglia serratura *Control of hardware functioning*
   e. Verifica finitura superficiale / *Control of surface finishing*

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

MATERIALI

ACCIAIO INOX
Materiale
Profilati ricavati da nastro di lamiera di acciaio inox laminato a freddo pre-trattato industrialmente per garantire la massima qualità e uniformità.
Caratteristiche fisiche
AISI 316L Marino (X2 CrNiMo 17-12-2)
Norme di riferimento
EN 10088-2; EU 114
Trattamenti superficiali
Finitura lucida: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2R riflettività 53% e successiva lucidatura a specchio.
Finitura Scotch Brite: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2B con successiva spazzolatura Scoth Brite.

ACCIAIO COR-TEN
Materiale
Profilati ottenuti da nastro in acciaio altoresistenziale, autopassivante (che un tempo veniva commercializzato con il nome Cor-Ten) tale da formare, se esposto all'aria, uno strato di ossido uniforme e stabile che, ricoprendo la lamiera, ne arresta la corrosione atmosferica.
Caratteristiche fisiche
Fe 510 X (C max % 0,12: Si % 0,25-0,75: Mn % 0,20-0,50: P % 0,07-0,15: Cu % 0,25-0,55: Cr % 0,30-1,25: Ni max % 0,65)
Norme di riferimento
EN 10149
Trattamenti superficiali
Dopo la profilatura il materiale viene immerso in speciali bagni ossidanti tali da accelerare la formazione dello strato protettivo. Raggiunta la tonalità desiderata della superficie si procede ad una ceratura di stabilizzazione del materiale.

ACCIAIO ZINCATO VERNICIATO
Materiale
Profilati ottenuti da nastro in lamiera di acciaio zincato a caldo sistema Sendzimir finitura skinpassata
Caratteristiche fisiche
FeP02 GZ 200 (copertura di zinco pari a 200gr/mq per faccia)
Norme di riferimento
UNI EN 10142/3/7; EURONORM 143
Trattamenti superficiali per la verniciatura
La preparazione del supporto zincato si effettua tramite i processi di sgrassaggio, decapaggio, nitrocobaltazione e passivazione zirconica. Segue l'applicazione di un primer cataforetico di fondo, cotto in forno a 150 °C per 15 minuti per ottenere un film di vernice di fondo compatto (11-14 micron), uniforme nello spessore ed esente da colature. Infine applicazione della mano a finire con polveri poliestere cotte in forno a 180 °C per 25 minuti.

LEGA DI RAME OT67
Materiale
Profilati ottenuti da nastro di Lega di Rame OT67 laminato a freddo rincrudito allo stato grezzo.
Caratteristiche fisiche
Cu Zn 33 CW 506L (OT 67, 67% rame)
Norme di riferimento
EN 1652:1999
Trattamenti superficiali
Finitura brunita: dopo la profilatura viene eseguita una ricottura di distensione, quindi la pulitura meccanica con abrasivo e la successiva brunitura per immersione con liquido brunitore; il profilo viene poi lavato e asciugato ed infine protetto mediante trattamento con olio di vaselina.
Finitura lucida: dopo la profilatura viene eseguita una ricottura di distensione e successivamente la lucidatura a specchio.

MATERIALS

STAINLESS STEEL
Materials
Sections processed out of the cold-rolled coils, industrially pre-treated for utmost quality and uniformity.
Physical features
AISI 316L Marino (X2 CrNiMo 17-12-2)
Norms of reference
EN 10088-2; EU 114
Surface treatment
Polished: obtained on AISI 316L (marine) coil pre-finish with 2R surface finish, 53% reflectivity, and mirror post-polish.
Scotch Brite: obtained on AISI 316L (marine) coil 2B pre-finish with Scotch-Brite post-scrubbing.

CORTEN STEEL
Materials
Sections processed out of highly resistant self-oxidising steel coils – once traded under the name Cor-Ten. If exposed to the open air, it produces a uniform protective layer that reduces weather corrosion.
Physical features
Fe 510 X (C max % 0,12: Si % 0,25-0,75: Mn % 0,20-0,50: P % 0,07-0,15: Cu % 0,25-0,55: Cr % 0,30-1,25: Ni max % 0,65)
Norms of reference
EN 10149
Surface treatment
After forming, sections are plunged into a special oxydising bath to catalyze formation of the protective coating. Once the desired tone obtained, sections are stabilized by a wax coating.

GALVANIZED AND PAINTED STEEL
Materials
Sections processed out of hot galvanized steel coils, band "Sendzimir, skinpassed finishing.
Physical features
FeP02 GZ 200 (copertura di zinco pari a 200gr/mq per faccia / *with zinc coating of 200 gr/sq x m on both faces*)
Norms of reference
UNI EN 10142/3/7; EURONORM 143
Pre-painted surface treatment
After forming, the galvanized support undergoes the degreasing, pickling, nitro-cobalting and zirconium alloy oxidation stages, followed by a cataphoresis primer baked at 150°C for 15 minutes. This allows the film of paint to be extremely compact (11-14 micron), uniform in thickness and sagging-proof. The last layer is applied PE powders baked at 180 °C for 25 minutes.

COPPER ALLOY OT67
Materials
Sections processed out of copper alloy coils, industrially cold-rolled.
Physical features
Cu Zn 33 CW 506L (OT 67, 67% rame / *copper* e 33% zinco / *zinc*)
Norms of reference
EN 1652:1999
Surface treatment
Burnished finish: after forming, the product is submitted to stress relieving, then to mechanical cleaning with abrasive products and ultimately to burnishing by plunging into a burnishing solution. It is then washed and dried and protected with a vaseline coating.
Glossy finish: after forming, the product is submitted to stress relieveing and then mirror-like polished.

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