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Lift-and-slide door

lift-slide

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319432 | "Hebeschiebetür 85mm" VM | en (English) Englisch | Issue 2020-11a

VM

CL

AI

197 mm

85 mm

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About this manual:
The **printed** manual is published in DIN A4 size, and from chapter 01 P on in DIN A3 size.
The **digital** manual in PDF / Adobe Reader format is published in DIN A0 from chapter 01 P on: Apart from few exceptions, all sectional drawings are represented on a 1:1 scale, details on a 1:1 or 1:2 scale, spatial representations on a 1:4 scale.
Hence, selected details can be printed on a 1:1 scale from the PDF / Adobe Reader file.

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Currently not available!

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10 General Installation Guidelines

Page(s) Filename(s)

See manual "Handling"

Material properties

In compliance with the DIN EN ISO 1163 standard, aluplast uses the following uPVC molding compound as material for the profile systems:

ISO 1163 - PVC-U, EDLP, 082-50-T28

ISO standard DIN EN ...
PVC = Polyvinyl chloride
U = plasticiser-free (hard)
E = Extrusion
D = Powder (Dry-Blend)
L = Light and weathering stabilizer
P = Impact-resistant modified
082 = 80 - 84 °C = Vicat-softening temperature
50 = >40 kJ/m² = Impact strength
T28 = 2500 - 3000 N/mm² = Modulus of elasticity (tensile modulus = tension = T)

The formulation used is free of barium and cadmium.
Other versions / consignments according to system description or on request.

Characteristics CaZn (calcium zinc)

according to standard(s)	Description	Result	Unit
DIN EN ISO 306	Dimensional stability under heat Vicat-softening temperature VST/B 50	80 ± 2	°C
DIN EN ISO 179-1 / 1eA / 1eC / 1fC	Double-v impact strength a_v (RAL-toughness) Charpy / test bar according to RAL	Ø ≥ 40 no value below 20	kJ/m² at + 23 °C
DIN EN ISO 178 / 527-1 + 527-2	Flexural modulus E / tensile modulus E	2800	N/mm²
DIN EN ISO 182-2 / DIN 53 381-1	Stability time t pH-measurement methods, oil bath / conductivity measurement methods	40 ± 6	minutes at + 200 °C

General characteristics of uPVC

according to standard(s)	Description	Result	Unit
DIN 53752 Leitz-dilatometer	Coefficient of linear expansion from - 30 °C and + 50 °C	7 x 10 -5	1/K
DIN 52612-1/-2/-3 Guarded hot plate method	Thermal conductivity λ (Lambda)	0.16	W/mK
DIN 4102-1	Fire performance uPVC Flat profiles	B1	-
DIN 4102-1	Fire performance uPVC Hollow chamber profiles	B2	-
DIN EN 13501-1	Fire performance uPVC	E	-

1. Construction

1.1. Profile Design

The characteristic feature of the **aluplast** Lift-and-slide door **lift-slide** (Lift-and-slide door 85mm) is that all frame, sash, mullion, and transom profiles are designed as 4- or 5-chamber systems.

The **aluplast** Lift-and-slide door **lift-slide** is based on the 5-6-chamber backstop gasket system **IDEAL 7000** with 85mm profile depth, from which certain items have been taken.

The multiple inner- and outermost hollow chambers guarantee optimal thermal insulation properties. Additionally, the outermost chambers allow for the concealed drainage and air equalisation of the rebates.

The large middle chambers are designed to accommodate the structurally required reinforcement profiles.

1.2. Gasket Arrangement

Save for few exceptions, the main profiles come equipped with gaskets.
(See also paragraph 5. Gaskets)

Main profiles with pre-inserted TPE backstop and glazing gaskets can be welded.

Optional (repair) gaskets are available for main profiles without integrated gasket. Insert these (repair) gaskets circumferentially and in one plane. Do not break or cut the gasket in the mitre corner.

2. System Range

Design: Classic-line
(the valid product range according to Plan of Profiles)

- Door case (frame)

- Guide rails

- Sash

- Transoms

- Various additional profiles and accessories

aluskin (aluminium shells)

(Glazing beads available in Classic-line, Soft-line, and Round-line design)

aluplast Lift-and-slide door **lift-slide**: Schema overview

Option	**Schema A** 1) 2) 3) 4)	**Schema C** 1) 2) 3) 4)	**Schema D** 1) 2)	**Schema F** 1) 2)
Number of sashes	2	4	2	4
Sliding sash	1	2	2	4
Fixed sash	1	2	-	-

[1] Optionally with **aluskin** (aluminium shells)
[2] Optionally barrier-free [1]
[3] Optionally as **fixframe** [1]
[4] Optionally as **fixframe** + barrier-free [1]

For the option **fixframe**, an especially slim sash profile is used on three sides of the fixed sash in order to maximise the incidence of natural light through the fixed element.

3. Opening Types

In addition to the double-sash standard version, the **aluplast** Lift-and-slide door **lift-slide** is also available as a multi-sash lift-and-slide door.

The **aluplast** Lift-and-slide door **lift-slide** can be combined with the aluplast profile series **IDEAL 2000** to **IDEAL 8000**.

- Turn windows and doors
- Tilt-and-turn windows and doors
- Top-hung and bottom-hung windows
- French casement windows and doors
- Multi-sash windows and doors with mullion and transom
- Window walls
- Round-arched and segment-bow windows
- Fixed glazing

4. Hardware

Special hardware is required for the lift-and-slide door.

The type and the material of the screws used to fix the hardware (screw type) are specified by the hardware manufacturer.

Use only stainless steel screws – minimum quality V2A – to fix the aluminium components.

5. Gaskets

aluplast profiles are also available with integrated gaskets (for further information please refer to the valid price list).

TPE: can be welded, thermoplastic elastomer according to RAL-GZ 716/1 paragraph II
Base profile colour / lamination / integrated gasket: see valid price list or plans of profiles

For main profiles that come **without** gaskets, (repair) glazing gaskets and (repair) backstop gaskets, made of weathering and aging resistant EPDM-material, are optionally available in papyrus white or black. They are made of aging and weather resistant EPDM (APTK) material.

EPDM: cannot be welded, moulding compound according to DIN 7863

Gaskets must be inserted circumferentially and butt-jointed in the upper cross-piece of the frame or sash. It is not necessary to cut the gasket in the mitre corner.

6. Glazing

All customary single-layer glasses, insulating glasses and door panels can be installed.

Install the glazing with pre-assembled sealing profiles (dry glazing).

Applicable theoretical glazing thickness:
Standard: up to 52mm

7. Reinforcements and Aluminium Profiles

Depending on the window dimensions and structural requirements, cold-rolled, galvanised steel profiles must be inserted into frames, sashes, and mullions or transoms for reinforcement, provided that the profiles have suitable reinforcement chambers or another option for reinforcement.

Material:
Hollow profiles Band EN 10142 DX51D+Z275 NA-C
Open profiles Band EN 10142 DX51D+Z275 NA-C

Corrosion protection zinc coating according to DIN EN 10326
For inside reinforcements, the minimum zinc coating is 150g/m²
For outside reinforcements, the minimum zinc coating is 275g/m²

Aluminium profiles: AlMgSi

Use only stainless steel screws – minimum quality V2A – to fix the aluminium components.

8. Lamination and Colours

The profiles are available as laminated profiles. For further information on the available colour range, please refer to the valid price or lamination foil list.

The base profile colour is white, similar to RAL 9016, or brown (in case of laminated profiles), similar to RAL 8019.

9. Care and Maintenance

PVC window profiles can be cleaned easily using commercially-available mild cleansing agents. Do not use solvents or abrasive cleansing agents.

Lubricate the hardware parts as specified by the hardware manufacturer.

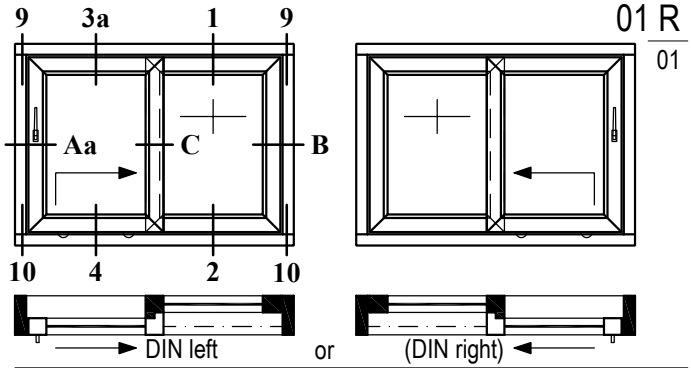
Refer also to **Chapter 10 R Cleaning, 10 S Maintenance, and 10 T Ventilation**.
Here you will find further information and cleaning agents recommended by aluplast.

10. Window Material

Refer to **Chapter 01 A Material Properties**

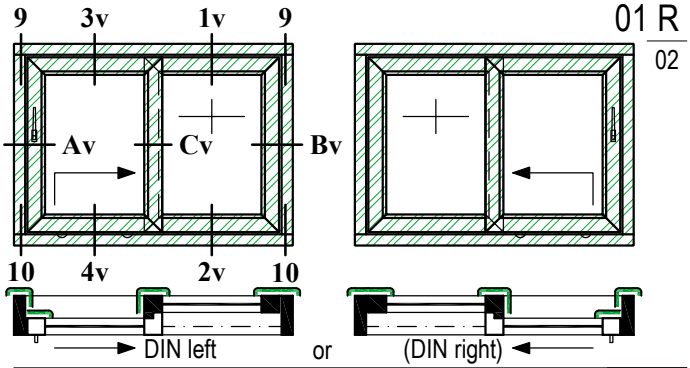
Lift-and-slide door 85mm

Schema A



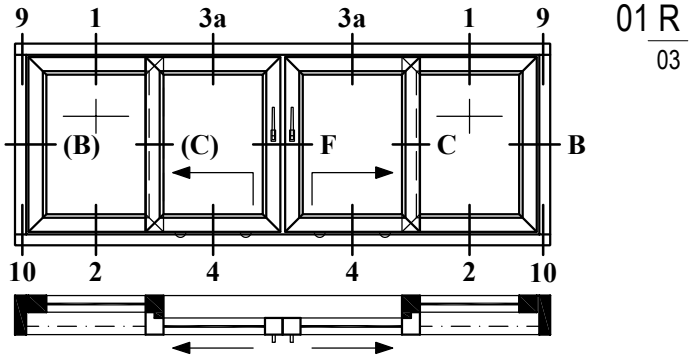
01 R 01

Schema A "v"
Aluminium shells



01 R 02

Schema C



01 R 03

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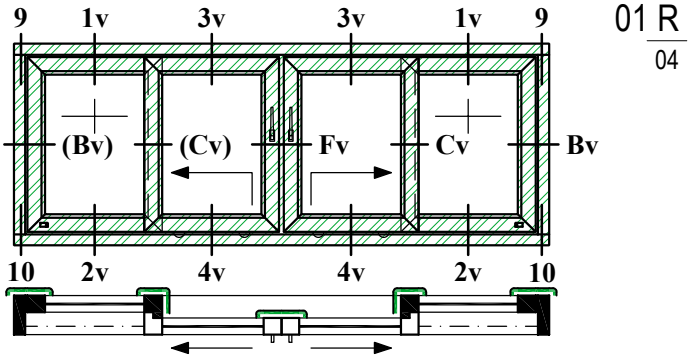
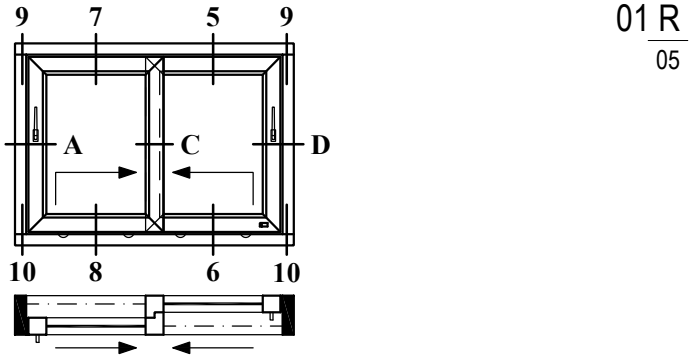


01 R 04

Schema D



01 R 05

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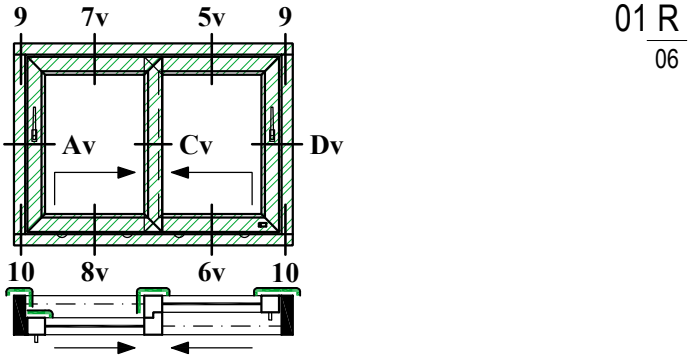
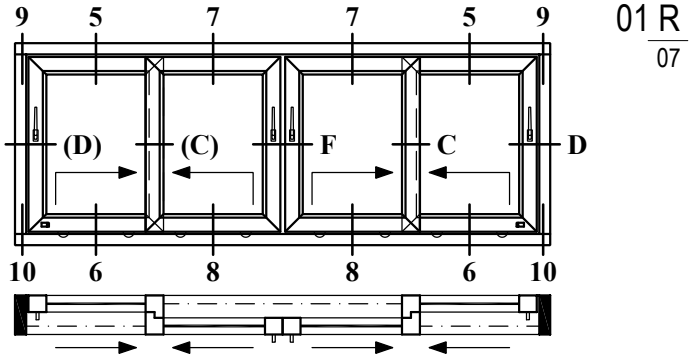
Aluminium shells



01 R 06

Schema F



01 R 07

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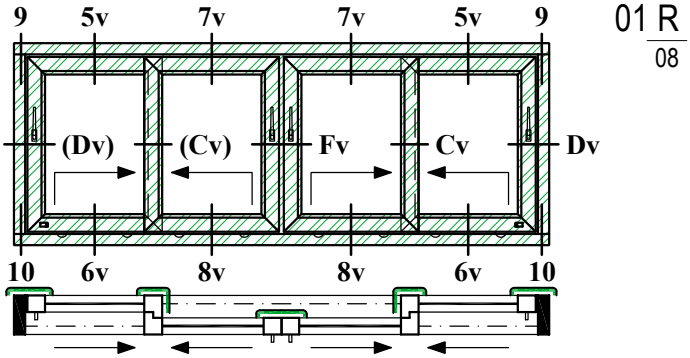
Aluminium shells



01 R 08

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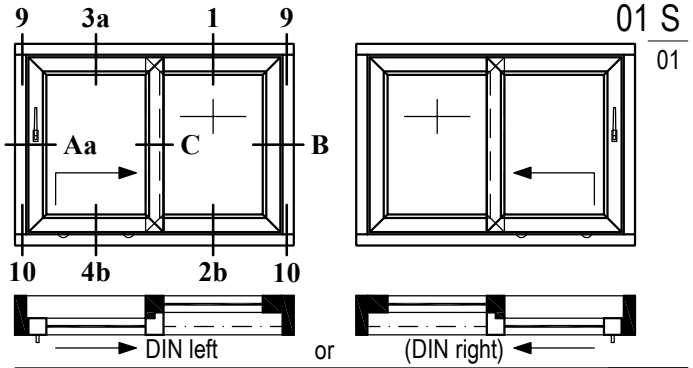
All views from inside

Lift-and-slide door 85mm

BF Schema A
barrier-free

01 S 01



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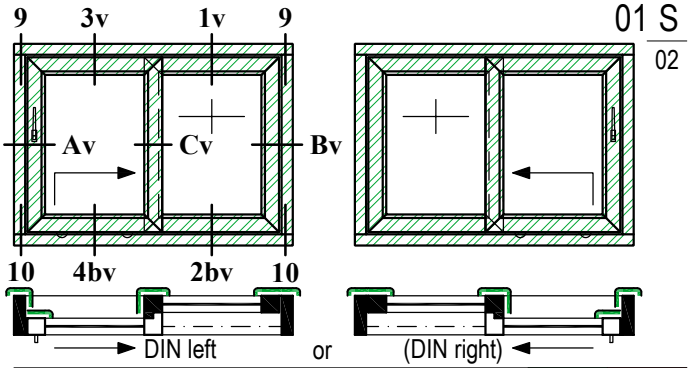
Aluminium shells
barrier-free

01 S 02



BF Schema C
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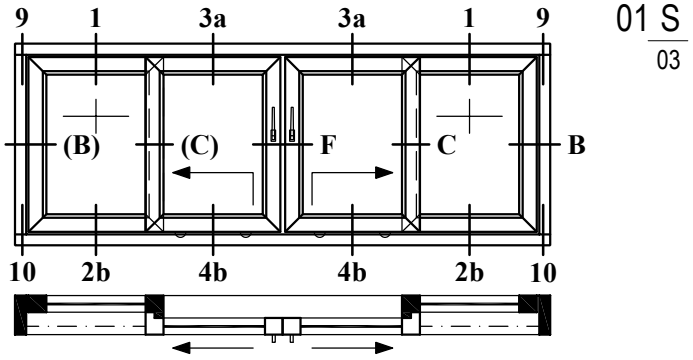
01 S 03



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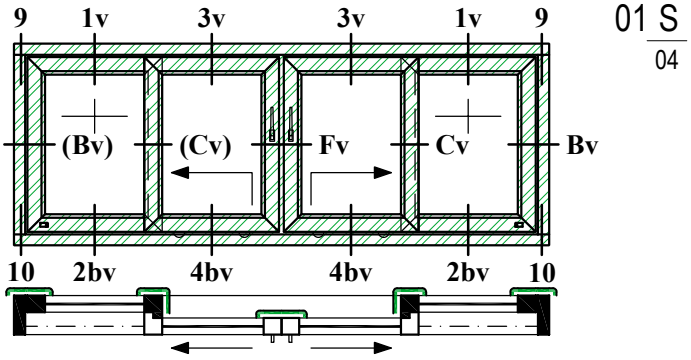
Aluminium shells
barrier-free

01 S 04



BF Schema D
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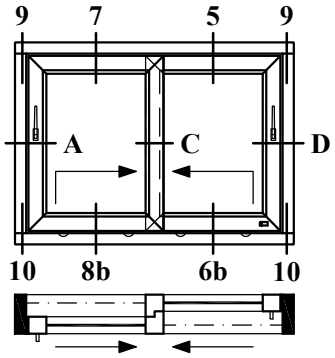
01 S 05



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Aluminium shells
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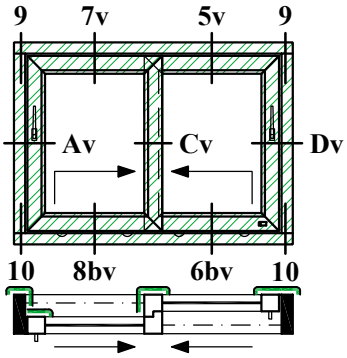
01 S 06



BF Schema F
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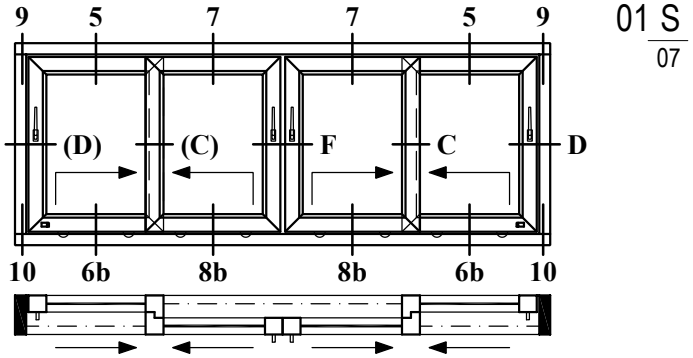
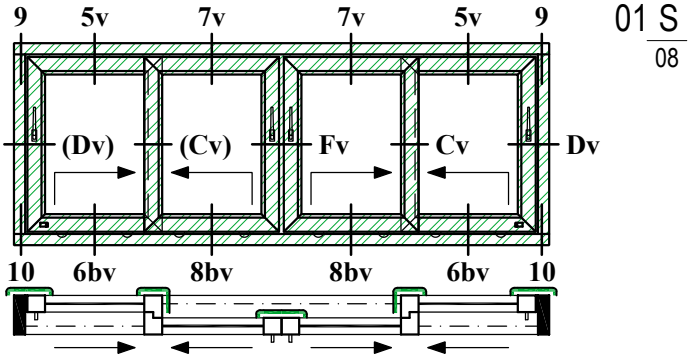
01 S 07



BF Schema F "v"
Aluminium shells
barrier-free

01 S 08



chapter
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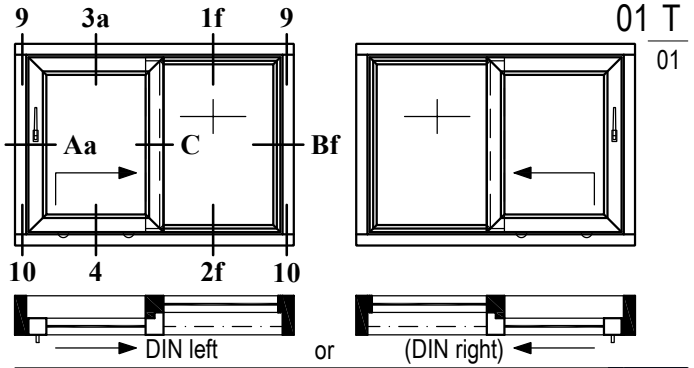
All views from inside

FF Schema A
fixframe

FF

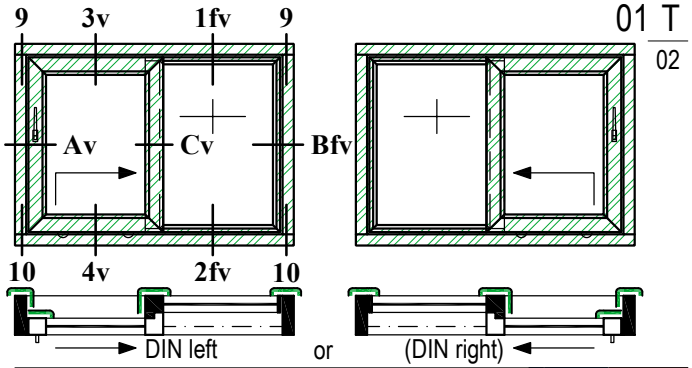
01 T 01



FF Schema A "v"
Aluminium shells
fixframe

FF AI

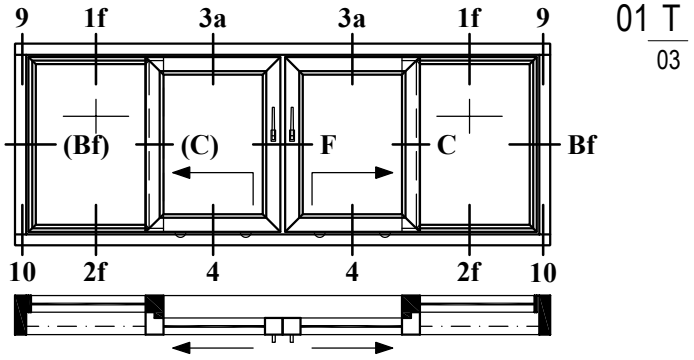
01 T 02



FF Schema C
fixframe

FF

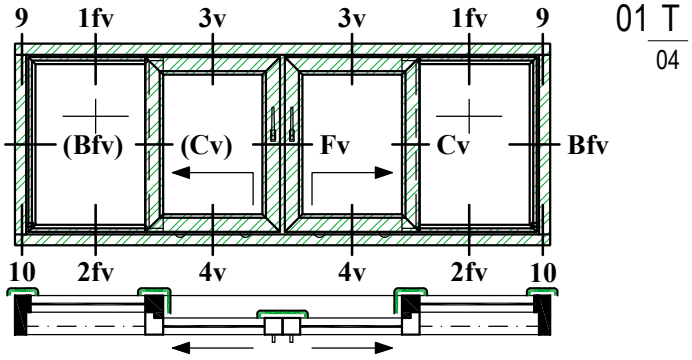
01 T 03



FF Schema C "v"
Aluminium shells
fixframe

FF AI

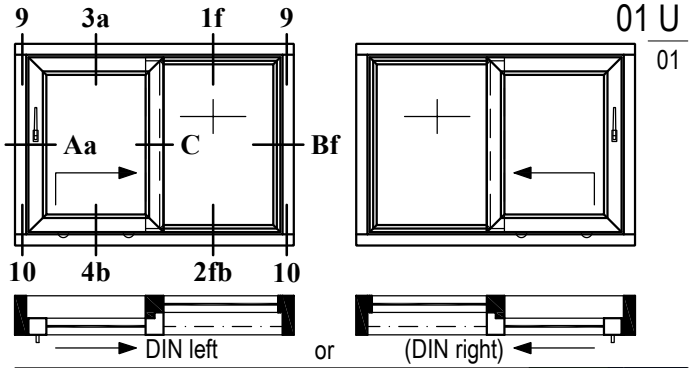
01 T 04



FFBF Schema A
fixframe + barrier-free

FF

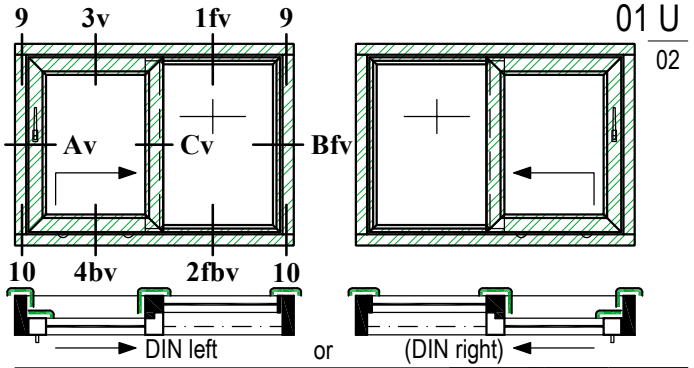
01 U
01



FFBF Schema A "v"
Aluminium shells
fixframe + barrier-free

FF AI

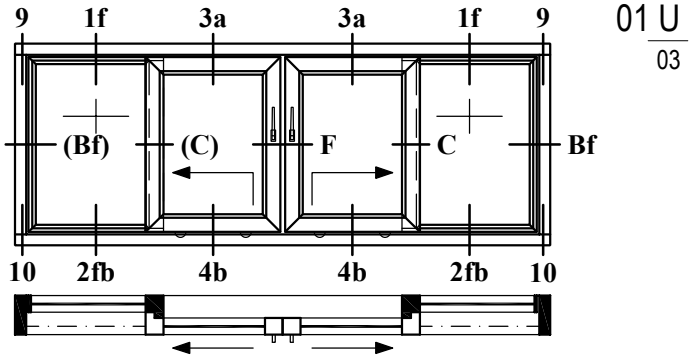
01 U
02



FFBF Schema C
fixframe + barrier-free

FF

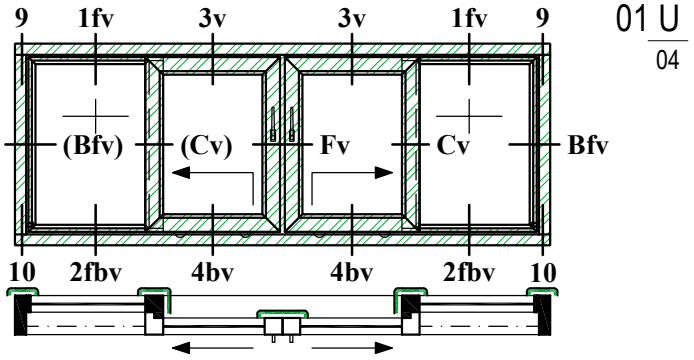
01 U
03



FFBF Schema C "v"
Aluminium shells
fixframe + barrier-free

FF AI

01 U
04



chapter
page

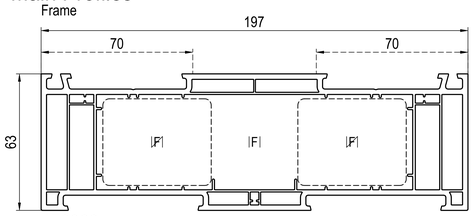
▫ / ▫ Stopper on left / right side (where required)

All views from inside

aluplast GmbH | uPVC window profile systems
Auf der Breit 2 | DE - 76227 Karlsruhe
fon: +49 721 47171-0 | fax: -999
info.de@aluplast.net | www.aluplast.net

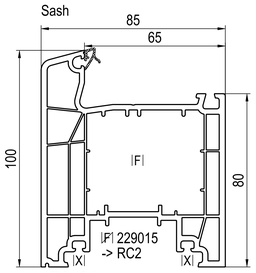
Main Profiles

Frame



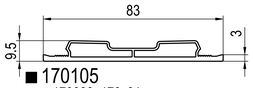
■ 170080
|F| 24922x, 27910x
|P| 229125, 229126 (2x)
|P| 279380, 279383, 279384
|Z| 670380, 679320

Sash

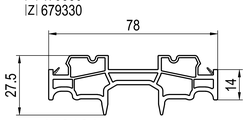


■ 170x81 (CL)
|A| 670301
|F| 229125, 229126, 279036, 279082, 279083, 279084
|F| 229114, 229115 + |Z| 670290
|P| 279381, 279382, 279386
|X| 479181
|Z| 679303, 679341

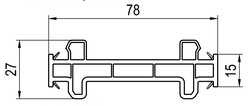
Additional Profiles



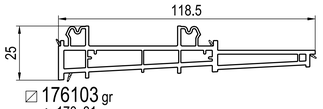
■ 170105
->170080, 170x81
|X| 479330
|Z| 679330



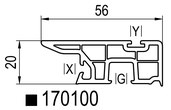
■ 170101
-> 170080, 170x81
|X| 679305, 679340



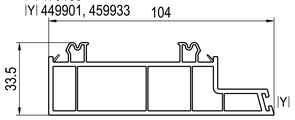
■ 170102
->170x81
|Z| 679302



◪ 176103 gr
-> 170x81
|X| 679300
|Z| 679302, 679303

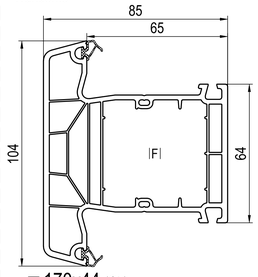


■ 170100
-> 170x81
|G| 652923
|O| 670901
|X| 479180
|Y| 449901, 459933

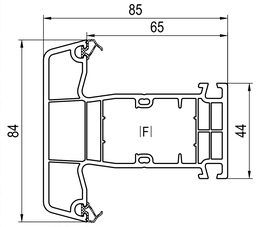


■ 170104
-> 170080
|Y| 449901, 459933
|Z| 679304

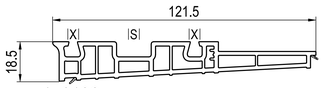
Transoms



■ 170x44 (CL)
-> 170x81
|A| 670301
|D| 677145 |D| 677146 ~170x4x ...
|Ø| 640046 ~ universal
|F| 249034, 249035
|P| 289343

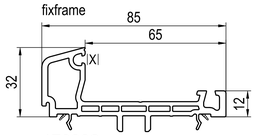


■ 170x41 (CL)
-> 170x81
|A| 670301
|D| 677101, 679141 ~170x4x ...
|Ø| 620046, 640046 ~universal
|F| 259043, 259044
|P| 289341



◪ 176106 gr
|S| 27713x, 277180
|X| 420250, 421250, 423250, 429250
|X| 679300
|Z| 679306

fixframe



◪ 170082 (CL)
|P| 279306, 279307
|X| 477025, 479025, 477015, 479015
|Z| 679306, 679382

Accessories

|A| Spacer

670301
-> 170x41, 170x44, 170x81

|D| Connector
|Ø| Connector without sticks
P~Plastic

-> Transoms

|D| 677146
|Ø| -
-> 170x44
|O| 670950
~170x4x ...

|D| -
|Ø| 677145
-> 170x44
|O| 670950
~170x4x ...

|D| 679141 P
|Ø| -
-> 170x41
|O| 670950
~170x4x ...

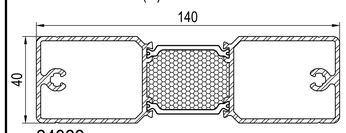
|D| 677101
|Ø| -
-> 170x41
|O| 670950
~170x4x ...

|Ø| 640046 P
~45x20x1000 mm
-> 170x41, 170x44
~ universal

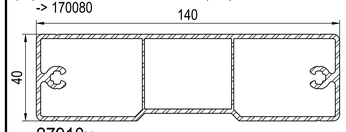
|Ø| 620046 P
~35x20x1000 mm
-> 170x41
~ universal

|F| |F| Reinforcements (...) = lx

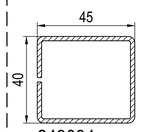
-> Transoms



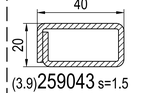
24922x
(65)249228 s=2.0 l= 6.7m (197)aluminium
-> 170080



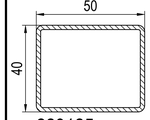
27910x
(69)279108 s=2.0 l= 6.7m (206)aluminium
-> 170080



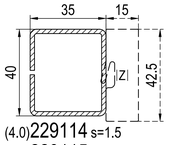
(6.1)249034 s=1.25
(9.2)249035 s=2.0
-> 170x44



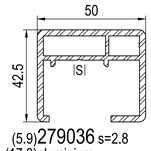
(3.9)259043 s=1.5
(5.6)259044 s=2.5
-> 170x41



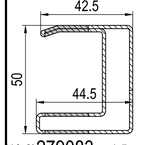
12.1)229125 s=2.0
16.8)229126 s=3.0
-> 170080 (2x),
170x81



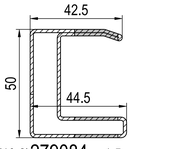
(4.0)229114 s=1.5
(5.0)229115 s=2.0
-> 170x81
+ |Z| 670290



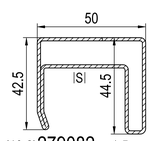
(5.9)279036 s=2.8
(17.8)aluminium
-> 170x81
|S| 279189



13.2)279083 s=1.5
~ |F| 279082 pierced hole
l= 2.30m blue
-> DIN left
-> 170x81



(13.2)279084 s=1.5
~ |F| 279082 pierced hole
l= 2.30m red
-> DIN right
-> 170x81



(13.2)279082 s=1.5
-> 170x81
|S| 279189

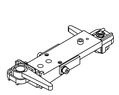
|G| Nipple screw / Clip

652923
-> uPVC
-> 170100
|O| 670901

|H| Installation / mounting anchor
see plan:
Additional Profiles
Structural profiles

(0.9)229015 s=1.5
-> 170x81 -> RC2

|O| Mounting accessories

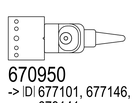


670918
-> |Z| 670380, 679320

670901
-> |G| 652923 + 170100

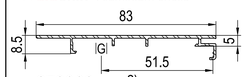
670941
-> |Z| 679341

-> Transoms

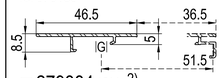


670950
-> |D| 677101, 677146, 679141
-> |Ø| 677142, 677144, 677145, 677241, 677244

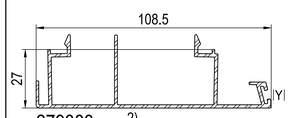
|P| **aluskin** Aluminium shells



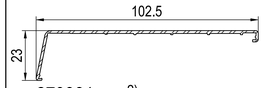
◪ 279380 (CL) 2) SL 111mm
-> 170080 (CL) AU 237mm
|G| 670180



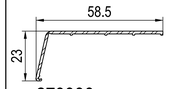
◪ 279384 (CL) 2) SL 75mm
-> 170080 (CL) AU 120mm
|G| 670180



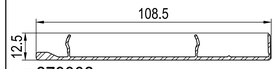
◪ 279383 (CL) 2) SL 212mm
-> 170080 (CL) AU 516mm
|Y| 459933



◪ 279381 (CL) 2) SL 132mm
-> 170x81 (CL) AU 260mm

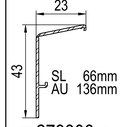


◪ 279386 (CL) SL 84mm
-> 170x81 (CL) AU 160mm



◪ 279382 (CL) SL 125mm
-> 170x81 (CL) AU 284mm

◪ 279387 (CL) SL 39mm
-> 170101 (CL) AU 59mm

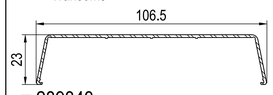


SL 66mm
AU 136mm

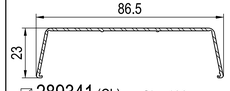
SL 59mm
AU 108mm

◪ 279306 (CL)
-> 170082 (CL)
+ 176106
-> Transoms

◪ 279307 (CL)
-> 170082 (CL)



◪ 289343 (CL) SL 150mm
-> 170x44 (CL) AU 292mm



◪ 289341 (CL) SL 130mm
-> 170x41 (CL) AU 252mm

aluskin |G| Nipple screw / Clip

670180 wh
-> |P| 279380, 279384

aluskin |X| Gaskets

459951 bl
-
-> Glazing

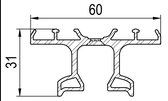
or

449986 bl
447986 pw
-> Glazing

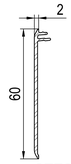
aluskin |Y| Brush seals

459933 bl
-> 170100, 170104
-> |P| 279383

|S| |S| |S| Aluminium profiles



27715x pierced hole
◪ 2771500003000 l= 3.00m
◪ 2771500004500 l= 4.50m
◪ 2771500006700 l= 6.70m
aluminium
-> 170080
|X| 679340
|Z| 6793410000098



◪ 277206 l= 6.70m
aluminium
-> |U| 27726x

27727x
◪ 2772700003000 l= 3.00m
◪ 2772700004500 l= 4.50m
◪ 2772700006700 l= 6.70m
aluminium
-> |U| 27726x

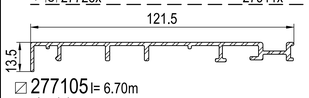
27713x
◪ 277130 l= 3.00m
◪ 277134 l= 4.50m
◪ 277138 l= 6.70m
aluminium
-> 176106
-> |S| 277106
-> |U| 27716x, 27911x

◪ 277205 l= 6.70m
aluminium
-> |U| 27726x
|S| 247200, 247900

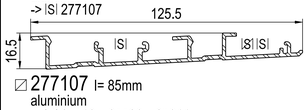
27729x
◪ 2772900003000 l= 3.00m
◪ 2772900004500 l= 4.50m
◪ 2772900006700 l= 6.70m
aluminium
-> |U| 27726x

◪ 277180 l= 6.70m
aluminium
-> 176106
-> |S| 277106
-> |U| 27716x, 27911x

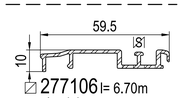
◪ 279189 l= 6.00m
aluminium
|F| 279036, 279082
|S| 27713x, 277180



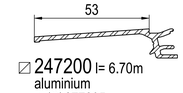
◪ 277105 l= 6.70m
aluminium
-> |S| 277107



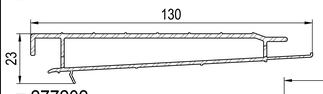
◪ 277107 l= 85mm
aluminium
-> |U| 27716x, 27726x, 27911x
|S| 277106 |S| 277105
|Z| 679306



◪ 277106 l= 6.70m
aluminium
-> |S| 277107
|S| 27713x, 277180

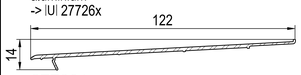


◪ 247200 l= 6.70m
aluminium
-> |S| 277205
|U| 27911x



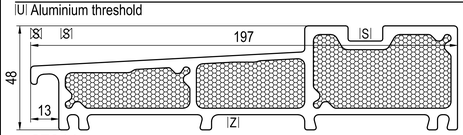
◪ 277202 l= 6.70m
aluminium
-> |U| 27726x

◪ 247900 l= 6.70m
aluminium
-> |S| 277205
|U| 27911x

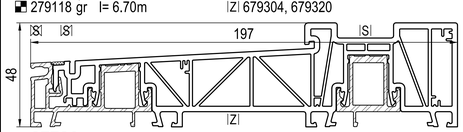


◪ 277201 l= 6.70m
aluminium
-> |U| 27726x

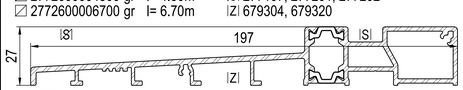
|U| Aluminium threshold



27911x GFK(GRP)
279110 gr l= 3.00m
279114 gr l= 4.50m
279118 gr l= 6.70m
|S| 27713x, 277180
|S| 277107
|Z| 679304, 679320
|S| 247200, 247900



27726x uPVC / aluminium
◪ 2772600003000 gr l= 3.00m
◪ 2772600004500 gr l= 4.50m
◪ 2772600006700 gr l= 6.70m
|S| 27727x, 27729x
|S| 277107, 277201, 277202
|Z| 679304, 679320
|S| 277205, 277206



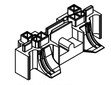
27716x uPVC / aluminium
◪ 277168 gr l= 6.70m
|S| 27713x, 277180
|S| 277107
|Z| 679304, 679320 cut

|X| Gaskets

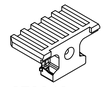
479181 bl
-> 170x81

479180 bl
-> 170100

479330 bl
-> 679330
+ 170105



679305 gr
-> 170101
+ 27716x, 27726x



679340 gr
-> 170101
+ 27715x

679300 gr
-> 679303 + 176103
-> 679306 + 176106

479025 bl
477025 pw
Standard

TPE
479015 bl
477015 pw

459922 bl
- pw

459925 bl
450925 pw

459923 bl
- pw

420250 wh
421250 br
423250 oc
429250 bl
-> 176106

429334 bl
427334 pw

429330 bl
420330 wh

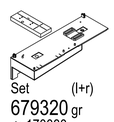
|Y| Brush seals

449901 gr
-> 170100, 170104
Standard

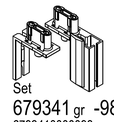
459933 bl
-> 170100, 170104
-> |P| 279383

|Z| Special accessories

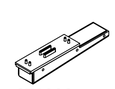
670380 wh
-> 170080
+ 170080
|O| 670918



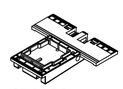
Set (l+r)
679320 gr
-> 170080
+ 27716x, 27726x, 27911x
|O| 670918



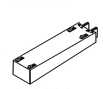
Set
679341 gr -98
6793410000098
-> 170x81
+ 27715x
|O| 670941



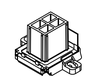
679302 gr
-> 170102
+ 176103



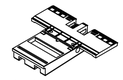
679303 gr
-> 170x81
+ 176103



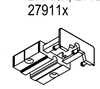
679304 gr
-> 170104
+ 27716x, 27726x, 27911x



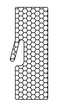
670382 wh
-> 170x81
+ 170082



679306 gr
-> 176106, |S| 277107



679330 gr
-> 170105
|X| 479330



670290
~15x42.5x1000 mm
-> 170x81
+ |F| 229114, 229115

|A| ... |X| ... *
|G| ... |Y| ...
|Z| ...
Set
679390
Accessories
-> Schema A
* see price list

◪ not laminated
■ laminated
foam inside -> ◪

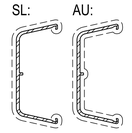
-> for
(CL) Classic-line

br brown
gr grey
oc ochre
bl black
pw papyrus-white
wh white

1)
2) or

SL visible length
AU exterior perimeter

SL: AU:



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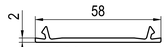
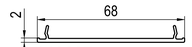
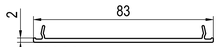
Extensions



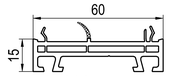
■ 120227 ->60/70mm



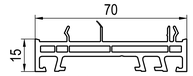
■ 140227 ->70mm



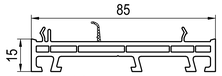
■ 180227 ->85mm



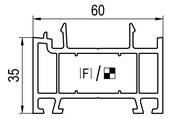
■ 120220 ->60/70mm



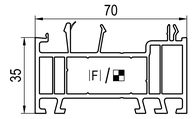
■ 140209 ->70mm
+ |H| 680200 ->85mm



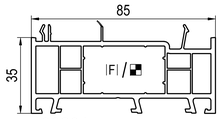
■ 180209 ->85mm



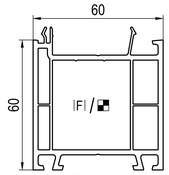
■ 120242 ->60/70mm
+ |H| 680200 ->85mm
|F| 229110, 229111
|P| 249335



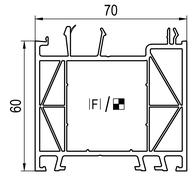
■ 140205 ->70/85mm
|F| 229110, 229111
|P| 249335



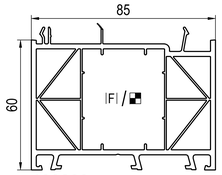
■ 180201 ->85mm
|F| 229098, 229100, 229101
|P| 249335



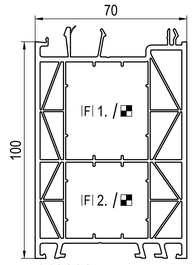
■ 120221 ->60/70mm
+ |H| 680200 ->85mm
|F| 229114, 229115
|P| 249360



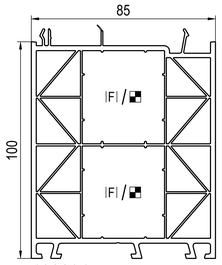
■ 140207 ->70/85mm
|F| 229017, 229114, 229115
|P| 249360



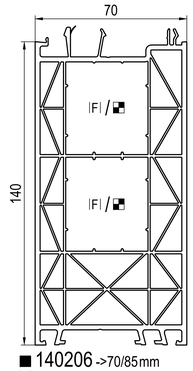
■ 180203 ->85mm
|F| 229114, 229115
|P| 249360



■ 140208 ->70/85mm
|F| 1. 229114, 229115
2. 259010, 259011
|P| 249310



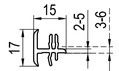
■ 180204 ->85mm
|F| 229114, 229115
|P| 249310



■ 140206 ->70/85mm
|F| 229114, 229115

Couplings

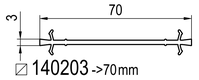
◪ 120116



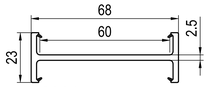
■ 120224
|X| 459905
-> |P| aluskin

449140 bl
447140 pw
= |X| Gaskets

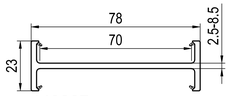
449141 bl
447141 pw
= |X| Gaskets



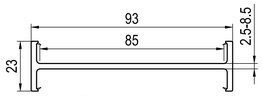
◪ 140203 ->70mm



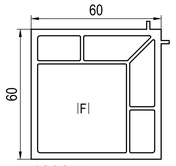
■ 120217 ->60mm



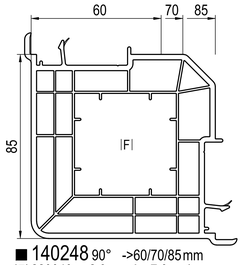
■ 140267 ->70mm



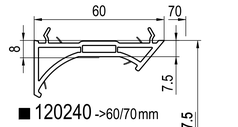
■ 180267 ->85mm



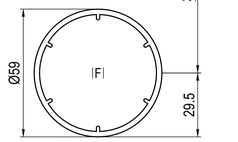
■ 120275 90° ->60mm
|F| 229040 s=2.0mm, Ix=7.0cm⁴
|H| 622041



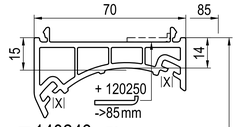
■ 140248 90° ->60/70/85mm
|F| 229040 s=2.0mm, Ix=7.0cm⁴
|H| 622041
|P| 249448



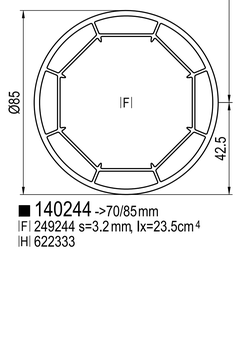
■ 120240 ->60/70mm



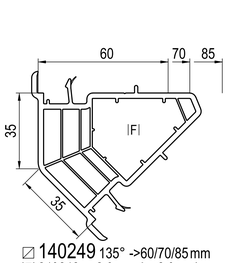
■ 120241 ->60/70mm
|F| 229140 s=3.25mm, Ix=11.7cm⁴
|H| 622140



■ 140243 ->70mm
|X| 447340, 449340,
447042, 449042



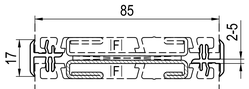
■ 140244 ->70/85mm
|F| 249244 s=3.2mm, Ix=23.5cm⁴
|H| 622333



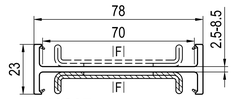
◪ 140249 135° ->60/70/85mm
|F| 249242 s=2.0mm, Ix=2.9cm⁴
|H| 622902

Structural profiles

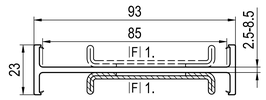
Couplings

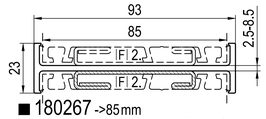


■ 120224 ->85mm
|F| 1x 289018 s=1.5mm, Ix=6.2cm⁴
2x 289018 s=1.5mm, Ix=12.4cm⁴
|H| 682331

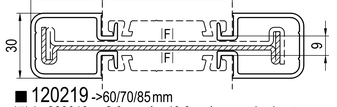


■ 140267 ->70mm
|F| 1x 209900 s=1.5mm, Ix=7.3cm⁴
2x 209900 s=1.5mm, Ix=14.6cm⁴
|H| 682331

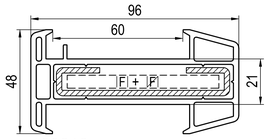




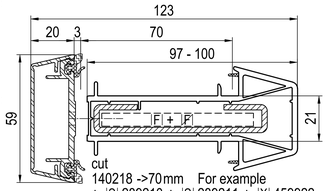
■ 180267 ->85mm
|F| 1. 1x 209900 s=1.5mm, Ix=7.3cm⁴
1. 2x 209900 s=1.5mm, Ix=14.6cm⁴
2. 1x 289018 s=1.5mm, Ix=6.2cm⁴
2. 2x 289018 s=1.5mm, Ix=12.4cm⁴
|H| 682331



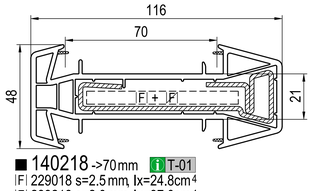
■ 120219 ->60/70/85mm
|F| 1x 229019 s=2.0mm, Ix=43.3cm⁴, punched out
2x 229019 s=2.0mm, Ix=86.6cm⁴, punched out
|H| 622019, 642025, 645050



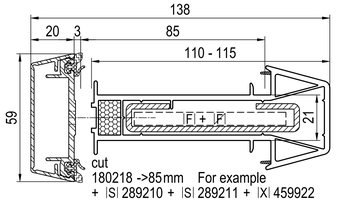
■ 120218 ->60mm T-01
|F| 229018 s=2.5mm, Ix=24.8cm⁴
|P| 229010 s=3.0mm, Ix=9.9cm⁴
|P| steel 70mm s=6.0mm, Ix=17.1cm⁴
|H| 622338, 622354, 682332, 682335



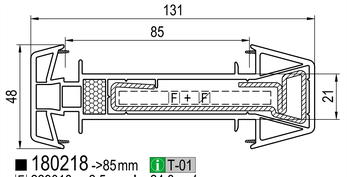
cut
140218 ->70mm For example
+ |S| 289210 + |S| 289211 + |X| 459922



■ 140218 ->70mm T-01
|F| 229018 s=2.5mm, Ix=24.8cm⁴
|F| 289218 s=2.0mm, Ix=37.0cm⁴
|P| 229010 s=3.0mm, Ix=9.9cm⁴
|P| steel 70mm s=6.0mm, Ix=17.1cm⁴
|H| 622338, 622354, 682332, 682335

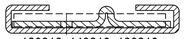


cut
180218 ->85mm For example
+ |S| 289210 + |S| 289211 + |X| 459922

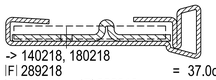


■ 180218 ->85mm T-01
|F| 229018 s=2.5mm, Ix=24.8cm⁴
|F| 289218 s=2.0mm, Ix=37.0cm⁴
|P| 229010 s=3.0mm, Ix=9.9cm⁴
|P| steel 70mm s=6.0mm, Ix=17.1cm⁴
|H| 622338, 622354, 682332, 682335

T-01 Ix [cm⁴]

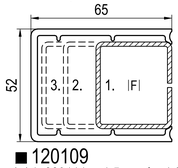


-> 120218, 140218, 180218
|F| 229018 = 24.8cm⁴
|F| 229018 + |P| 229010 = 34.7cm⁴
|F| 229018 + |P| steel 70x6 = 41.9cm⁴



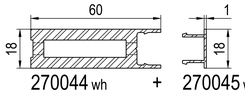
-> 140218, 180218
|F| 289218 = 37.0cm⁴
|F| 289218 + |P| 229010 = 46.9cm⁴
|F| 289218 + |P| steel 70x6 = 54.1cm⁴

Structural profiles



■ 120109
|F| 1. 229114 s=1.5mm, Ix=4.0cm⁴
1. 229115 s=2.0mm, Ix=5.0cm⁴
2. 229125 s=2.0mm, Ix=12.1cm⁴
2. 229126 s=3.0mm, Ix=16.8cm⁴
3. 259926 s=2.0mm, Ix=18.7cm⁴
|H| 622104 -> |F| 229125, 259926

|S| -> Structural profiles



270044 wh + 270045 wh
279044 aluminium + 279045 aluminium
|S| 270045, 279045 |S| 270044, 279044
SL 123mm SL 22mm
AU 180mm AU 80mm
GU 272mm
Ø5.5, a=250mm pierced hole
Ix/Iy=5.5/0.8cm⁴ steel ~16.5/2.5cm⁴ aluminium

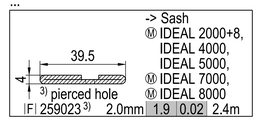
Accessories

|A| Spacer

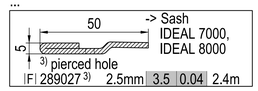
640302 2x50x100 mm
-> Couplings

|F| Reinforcements s Ix Iy

...



...



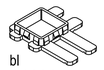
...

see plan: Reinforcements

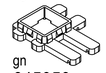
|G| Nipple screw / Clip

654930
-> aluminium
-> |P| ... e.g. 249448

|H| Installation / mounting anchor



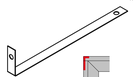
bl
642025 3mm
General
-> Couplings



gn
645050 5mm
General
-> Couplings

gn <- |A| *
685058
-> 050x04
-> 080x04, 180x04
* see plan: 1/4

680200
->85mm +
120221, 120223,
120242, 140209,
140200



644299
|X| 742299,
782299
-> Extension profile

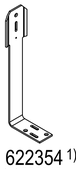
622140
|F| 229140
-> 120241

622333
|F| 249244
-> 140244

622041
|F| 229040
-> 120275,
140248

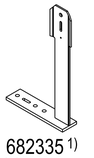
622104
|F| 229125,
259926
-> 120109

622338
|F| 229018,
289218
-> 120218,
140218,
180218



622354 1)
|F| 229018,
289218
-> 120218,
140218,
180218

682332
|F| 229018,
289218
-> 120218,
140218,
180218



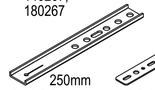
682335 1)
|F| 229018,
289218
-> 120218,
140218,
180218

682331 2)
|F| 209900,
289018
-> 120224,
140267,
180267

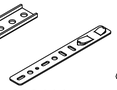
622019 2)
|F| 229019
-> 120219

622902 2)
|F| 249242
-> 140249

682333 3)



640331
protrusion
30mm ->100kg
50mm ->60kg
70mm ->30kg



680414
-> 080x04,
180x04

620410
-> General

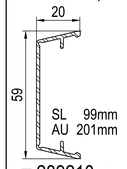
1) General e.g. -> Roller shutter box
2) General e.g. -> Couplings
3) General e.g. -> Extension profile

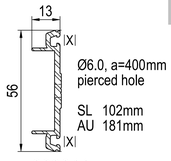
|P| aluskin Aluminium shells

|P| -> Extension profile
see
Extension profile

|P| -> Couplings
see
Couplings

|S| Aluminium profiles





◪ 289210 (CL) + ◪ 289211 (CL)
|S| 289211 |S| 289210
|X| 459922

-> e.g. 140218, 180218

|S| -> Structural profiles
see
Structural profiles

|X| Gaskets

449340 bl
447340 pw
Standard
-> 140243

TPE
449042 bl
447042 pw
-> 140243

459922 bl
- pw
|S| 289211

3mm
449140 bl
447140 pw
= Couplings

6mm
449141 bl
447141 pw
= Couplings

459905 bl
-> 120224

742299 bl
->70mm
-> Extension profile
|H| 644299

782299 bl
->85mm
-> Extension profile
|H| 644299

150
60x150mm
690060 l~24m
->60mm
-> Extension profile

150
70x150mm
690070 l=24m
->70mm
-> Extension profile

150
85x150mm
690085 l=24m
->85mm
-> Extension profile

◪ not laminated
■ laminated
foam inside -> ◪

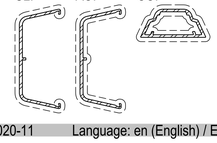
-> for

gn green
bl black
pw papyrus-white
wh white

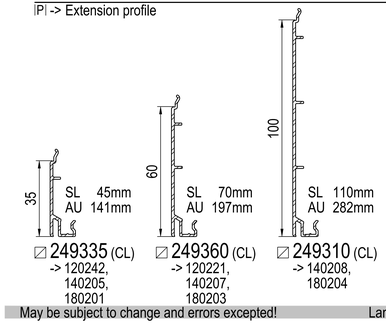
Construction depth
->60mm ->IDEAL 2000
->70mm ->IDEAL 4000 / 5000
->85mm ->IDEAL 7000 / 8000
... ->IDEAL 2000 - 8000

SL visible length
AU exterior perimeter
GU overall perimeter

SL: AU: GU:



|P| -> Extension profile

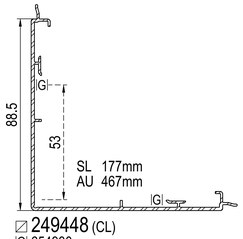


◪ 249335 (CL)
-> 120242,
140205,
180201

◪ 249360 (CL)
-> 120221,
140207,
180203

◪ 249310 (CL)
-> 140208,
180204

|P| -> Couplings



◪ 249448 (CL)
|G| 654930
-> 140248

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

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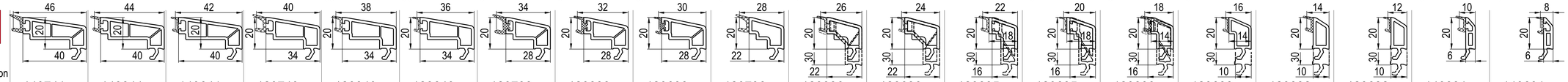
info.de@aluplast.net | www.aluplast.net

GLAZING BEADS

Glazing thickness [mm]

a	e.g. Profile serial	c 3)	d																					
85mm	IDEAL 7000 + 16mm + 4mm	protrusion	->170x39																					38-75
		-	38 - 39mm	40 - 41mm	42 - 43mm	44 - 45mm	46 - 47mm	48 - 49mm	50 - 51mm	52 - 53mm	54 - 55mm	56 - 57mm	58 - 59mm	60 - 61mm	62 - 63mm	64 - 65mm	66 - 67mm	68 - 69mm	70 - 71mm	72 - 73mm	74 - 75mm	-	[mm]
81mm	IDEAL 7000 + 16mm + 0mm	protrusion	->170x39																					
		-	34 - 35mm	36 - 37mm	38 - 39mm	40 - 41mm	42 - 43mm	44 - 45mm	46 - 47mm	48 - 49mm	50 - 51mm	52 - 53mm	54 - 55mm	56 - 57mm	58 - 59mm	60 - 61mm	62 - 63mm	64 - 65mm	66 - 67mm	68 - 69mm	70 - 71mm	-	34-71
73mm	IDEAL 8000 + 8mm / 180250	->180x26, 180x69	⚠➡|J|																				
		4mm	22 - 23mm	24 - 25mm	26 - 27mm	28 - 29mm	30 - 31mm	32 - 33mm	34 - 35mm	36 - 37mm	38 - 39mm	40 - 41mm	42 - 43mm	44 - 45mm	46 - 47mm	48 - 49mm	50 - 51mm	52 - 53mm	54 - 55mm	56 - 57mm	58 - 59mm	-	22-59
67mm	energeto 5000 view	Sash	->150x80			⚠➡|J|																	
		2mm	-	-	-	24 - 25mm	26 - 27mm	28 - 29mm	30 - 31mm	32 - 33mm	34 - 35mm	36 - 37mm	38 - 39mm	40 - 41mm	42 - 43mm	44 - 45mm	46 - 47mm	48 - 49mm	50 - 51mm	52 - 53mm	54 - 55mm	-	24-55
65mm	IDEAL 7000, IDEAL 8000, Nord-line	Frame	, lift-slide 4)				⚠➡|J|															⚠ +0.0/-1.0	
		4mm	14 - 15mm	16 - 17mm	18 - 19mm	20 - 21mm	22 - 23mm	24 - 25mm	26 - 27mm	28 - 29mm	30 - 31mm	32 - 33mm	34 - 35mm	36 - 37mm	38 - 39mm	40 - 41mm	42 - 43mm	44 - 45mm	46 - 47mm	48 - 49mm	50 - 51mm	52mm	14-52
63mm	IDEAL 4000 + 8mm, IDEAL 5000 + 8mm / 180250	->140x27, 140x48, 150x27							⚠➡|J|														
		4mm	12 - 13mm	14 - 15mm	16 - 17mm	18 - 19mm	20 - 21mm	22 - 23mm	24 - 25mm	26 - 27mm	28 - 29mm	30 - 31mm	32 - 33mm	34 - 35mm	36 - 37mm	38 - 39mm	40 - 41mm	42 - 43mm	44 - 45mm	46 - 47mm	48 - 49mm	-	12-49
55mm	IDEAL 4000, IDEAL 5000, Nord-line	Sash	, smart-slide 5) 6)	Ⓜ IDEAL 2000 + 8mm ->120x26, 120x32, 120x82, 120x86, 140x46, 140x47										⚠➡|J|								⚠ +0.0/-1.0	
		4mm	4 - 5mm	6 - 7mm	8 - 9mm	10 - 11mm	12 - 13mm	14 - 15mm	16 - 17mm	18 - 19mm	20 - 21mm	22 - 23mm	24 - 25mm	26 - 27mm	28 - 29mm	30 - 31mm	32 - 33mm	34 - 35mm	36 - 37mm	38 - 39mm	40 - 41mm	42mm	4-42
47mm	Ⓜ IDEAL 2000	->120x220000096, 120x300000096, 120x310000096															⚠➡|J|						
		⚠ 4mm	-	-	-	-	3 - 4mm	5 - 6mm	7 - 8mm	9 - 10mm	11 - 12mm	13 - 14mm	15 - 16mm	17 - 18mm	19 - 20mm	21 - 22mm	23 - 24mm	25 - 26mm	27 - 28mm	29 - 30mm	31 - 32mm	-	3-32
47mm	IDEAL 2000, multi-slide 5)																⚠➡|J|						
		3mm	-	-	-	-	4 - 5mm	6 - 7mm	8 - 9mm	10 - 11mm	12 - 13mm	14 - 15mm	16 - 17mm	18 - 19mm	20 - 21mm	22 - 23mm	24 - 25mm	26 - 27mm	28 - 29mm	30 - 31mm	32 - 33mm	-	4-33
38mm	vario-slide 5)																		⚠➡|J|				
		4mm	-	-	-	-	-	-	-	-	3 - 5mm	6 - 7mm	8 - 9mm	10 - 11mm	12 - 13 mm	14 - 15mm	16 - 17mm	18 - 19mm	20 - 21mm	22 - 23mm	24 - 25mm	-	3-25
32mm	easy-slide 5)	easy-slide 6)	->100078																				
		3mm	-	-	-	-	-	-	-	-	-	-	-	3 - 5mm	6 - 7mm	8 - 9mm	10 - 11mm	12 - 13 mm	14 - 15mm	16 - 17mm	18 - 19mm	-	3-19
20/22mm	mono-slide 5) 6)																						
		3/5mm	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	3 - 4mm	6 - 8mm	-	3-8

b Glazing Beads

			46mm	44mm	42mm	40mm	38mm	36mm	34mm	32mm	30mm	28mm	26mm	24mm	22mm	20mm	18mm	16mm	14mm	12mm	10mm	8mm
(CL) Classic-line																						
	Gasket	compression																				
h = 20mm 1) 2)	black	[mm]	■ 140741 [6]	■ 140841 [4]	■ 140641 [2]	■ 120740 [6]	■ 120840 [4]	■ 120640 [2]	■ 120738 [6]	■ 120838 [4]	■ 120638 [2]	■ 120736 [6]	■ 120836 [4]	■ 120636 [2]	■ 120835 [4]	■ 120635 [2]	■ 120833 [4]	■ 120633 [2]	■ 120832 [4]	■ 120632 [2]	■ 140831 [4]	■ 140631 [2]
	papyrus-white	[mm]	◪ 140771 [6]	◪ 140871 [4]	◪ 140671 [2]	◪ 120770 [6]	◪ 120870 [4]	◪ 120670 [2]	◪ 120768 [6]	◪ 120868 [4]	◪ 120668 [2]	◪ 120766 [6]	◪ 120866 [4]	◪ 120666 [2]	◪ 120865 [4]	◪ 120665 [2]	◪ 120863 [4]	◪ 120663 [2]	◪ 120862 [4]	◪ 120662 [2]	◪ 140861 [4]	◪ 140661 [2]
h = 30mm 2)	black	[mm]	-	-	-	-	-	-	-	-	-	-	■ 130836 [4]	■ 130636 [2]	■ 130754 [6]	■ 130854 [4]	■ 130654 [2]	■ 130753 [6]	■ 130853 [4]	■ 130653 [2]	-	-
	papyrus-white	[mm]	-	-	-	-	-	-	-	-	-	-	◪ 130866 [4]	◪ 130666 [2]	◪ 130784 [6]	◪ 130884 [4]	◪ 130684 [2]	◪ 130783 [6]	◪ 130883 [4]	◪ 130683 [2]	-	-

8-46 mm

(RL) Round-line

	Gasket	compression																				
h = 20mm 1) 2)	black	[mm]											■ 120850 [4]	■ 120650 [2]	■ 120859 [3-4]	■ 120659 [2-3]	■ 140852 [3-4]	◪ 120642 [2-3]				
	papyrus-white	[mm]											◪ 120880 [4]	◪ 120680 [2]	◪ 120889 [3-4]	◪ 120689 [2-3]	◪ 140882 [3-4]	◪ 120672 [2-3]				
h = 30mm 2)	black	[mm]											■ 130850 [4]	■ 130650 [2]	-	-	-	-				
	papyrus-white	[mm]											◪ 130880 [4]	◪ 130680 [2]	-	-	-	-				

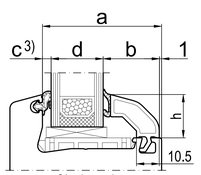
16-26 mm

(SL) Soft-line

	Gasket	compression																				
h = 20mm 1) 2)	black	[mm]											■ 120846 [4]	■ 120646 [2]	■ 120847 [4]	■ 120647 [2]	■ 120851 [4]	■ 120651 [2]	■ 120849 [4]	■ 120649 [2]		
	papyrus-white	[mm]									■ 120855 [4]		◪ 120876 [4]	◪ 120676 [2]	◪ 120877 [4]	◪ 120677 [2]	◪ 120881 [4]	◪ 120681 [2]	◪ 120879 [4]	◪ 120679 [2]		
h = 30mm 2)	black	[mm]									◪ 120885 [4]		■ 130856 [4]	■ 130656 [2]	■ 130857 [4]	■ 130657 [2]	■ 130858 [4]	■ 130658 [2]	■ 130859 [4]	■ 130659 [2]		
	papyrus-white	[mm]									-		◪ 130886 [4]	◪ 130686 [2]	◪ 130887 [4]	◪ 130687 [2]	◪ 130888 [4]	◪ 130688 [2]	◪ 130889 [4]	◪ 130689 [2]		

12-26 mm / 30 mm

Choose glazing bead
b = a - c - d - 1



a = Glazing rebate
b = Glazing bead + Gasket*
c 3) = Repair gaskets*
d = Glazing thickness
1 = 1mm protrusion

⚠➡|J| Bonding of pane
d ≥ 24 mm

Ⓜ |J|
Ⓝ |J|
Ⓥ |J|

* compressed gasket

1) for backstop gasket systems
2) for centre gasket systems
3) or profile with gasket
4) Sash (Lift-and-slide door)
5) Sash (Sliding window)
6) Frame (Sliding window)

◪ not laminated
■ laminated
|P| **alu**skin Aluminium shells

-> for

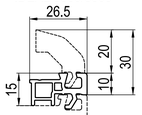
(CL) Classic-line
(RL) Round-line
(SL) Soft-line

bl black ~ RAL 9005
pw papyrus-white ~ RAL 9018

Additional Profiles

for centre gasket systems
for frame and mullion
with glazing beads h= 20mm

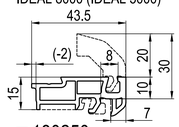
Glazing bead adapter
IDEAL 5000/8000



■ 130250 h= 10mm
|A| 650321, 680321
Spacer

= d
= a

Glazing rebate extension
IDEAL 8000 (IDEAL 5000)



■ 180250 h= 10mm
|A| 650321, 680321 = cut
Spacer

= d + 8mm
= a + 8mm

(...) 180250 = cut

Repair gaskets

|X| Gaskets
-> Main Profiles

Glazing thickness								
IDEAL 4000, IDEAL 5000, IDEAL 7000, IDEAL 8000, Nord-line, lift-slide 4), smart-slide 5) 6), vario-slide 5), Ⓜ IDEAL 2000							
-	= d + 1mm	= d + 1mm	= d + 1mm	= d Standard	= d Option	= d - 1mm	= d	= d	= d + 2mm
= d Standard	= d Option	= d Option	= d Option	-	-	= d - 2mm	-	-	-
-	= d Standard	= d Option	= d Option	= d - 1mm	= d - 1mm	= d - 2mm	-	-	-
-	= d + 2mm	= d + 2mm	= d + 2mm	= d + 1mm	= d + 1mm	= d Standard	-	-	-
-	= d	= d Option	= d Standard	= d Option	= d - 1mm	= d - 2mm	-	-	-
compression [mm]	[2.5-3.5]	[2.5-3.5]	[3-3.5]	[3-5]	[4-4.5]	[4-4.5]	[4.5-7.0]	[4]	[4]	⚠ [2]

|P| aluskin | |P| aluskin | |P| aluskin

|X| Gaskets
-> Glazing Beads ->

xxx6xx [2]	xxx8xx [3-4]	xxx7xx [6]								
429310 bl	429311 bl	429312 bl	429921 bl	459922 bl	409076 bl	459925 bl	479025 bl	479015 bl	459923 bl	459951 bl
427310 pw	427311 pw	427312 pw	427921 pw	- pw	- pw	450925 pw	477025 pw	477015 pw	- pw	- pw
			C = 3mm	C = 3mm	C = 3mm	C = 3mm	C = 4mm	C = 4mm	C = 5mm	C = 4mm
										Standard ->|P|

|P| aluskin	|P| aluskin
449986 bl	449347 bl
447986 pw	447347 pw
C = 4mm	C = 2mm
Option ->|P|	Option ->|P|
	⚠ -> Frame -> Mullion

Frame Mullion [2] ... 9830 ->|P| Al
= d + 2mm or b + 2mm

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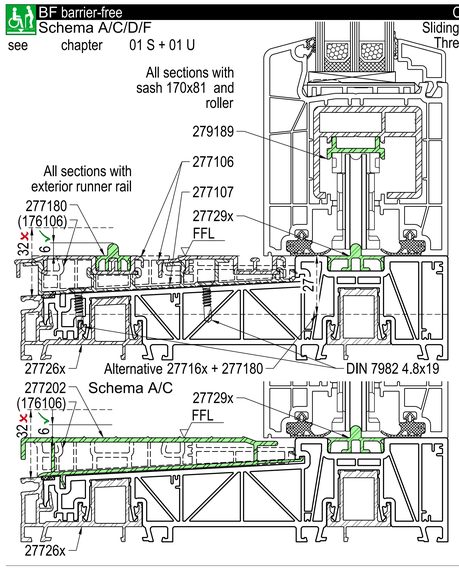
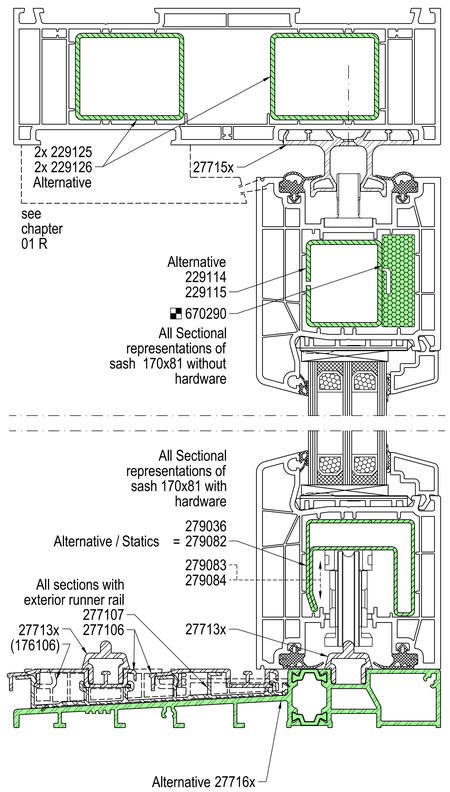
BF barrier-free — Option

Schema A/C/D/F — Sliding sash Threshold

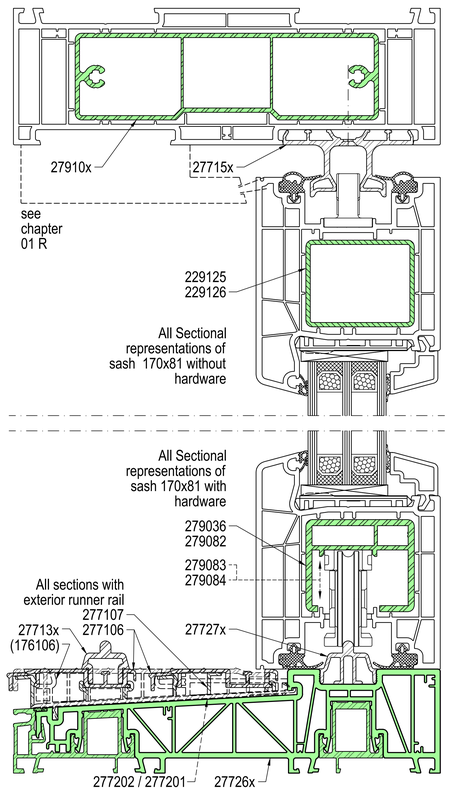
see chapter 01 S + 01 U



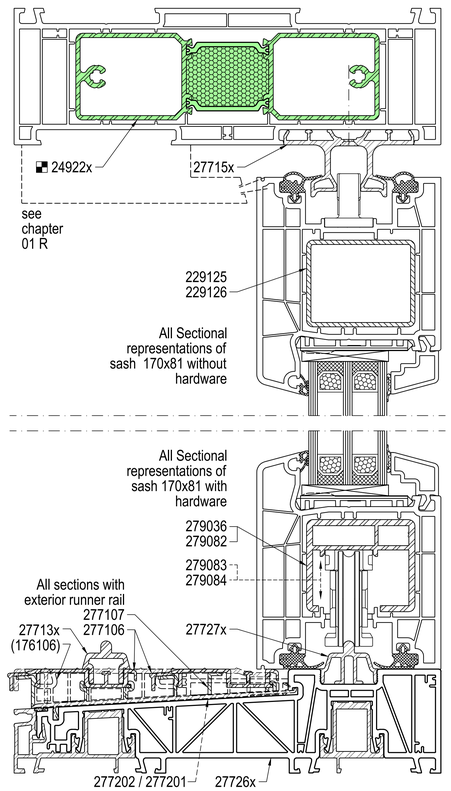
Alternative — Modules



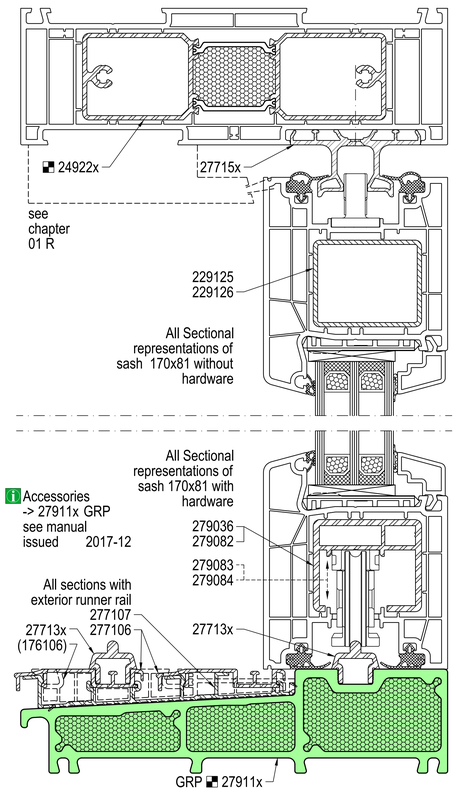
"basic" — Modules



"standard" — Modules



"premium" — Modules

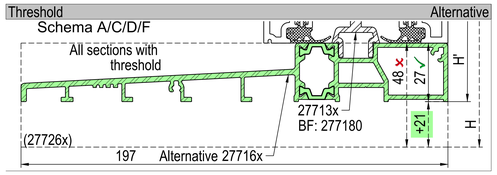


Brush seals — Alternative

Standard |Y| 449901	-> 170101, 170104	✓✓ ✓✓ ✓✓	-> ✗ ✗ ✗ ✗
Alternative |Y| 459933	-> 170101, 170104	✓✓ ✓✓ ✓✓	-> 170101, |P| 279383 ✓✓ ✓✓ ✓✓

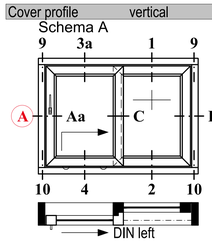
Threshold — Alternative

Schema A/C/D/F



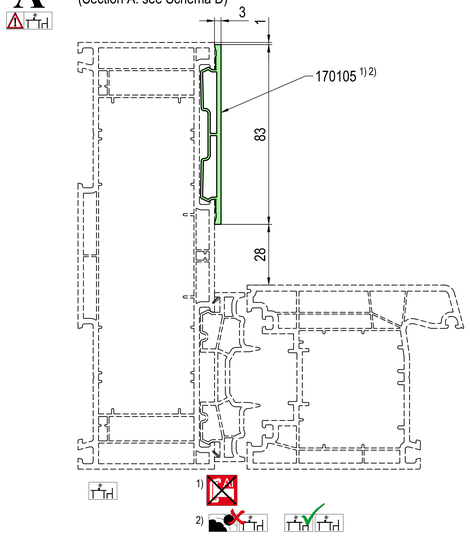
Cover profile vertical — Alternative

Schema A



A Frame-Sliding sash-Inside

(Section A: see Schema D)



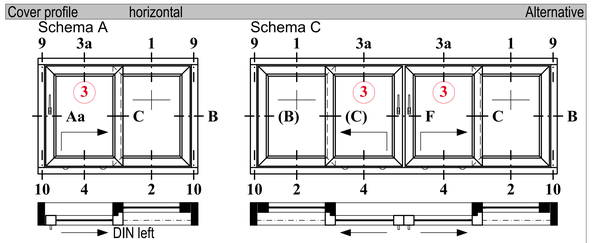
Schema A

Alternative to cover profile for Section:

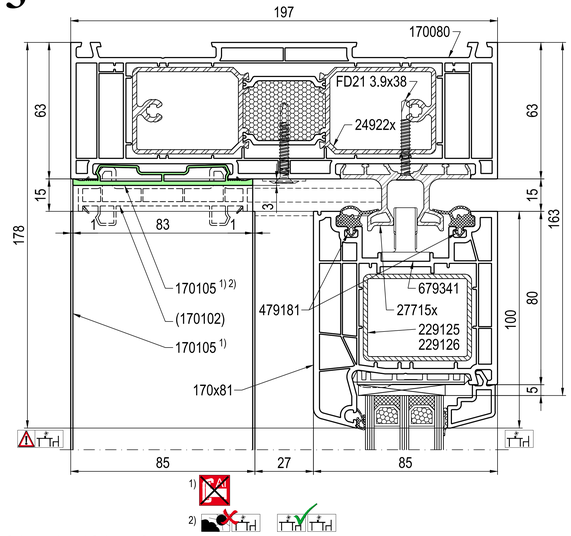
Aa Frame-Sliding sash-Inside with cover profile

Cover profile horizontal — Alternative

Schema A / Schema C



3 Top-Frame-Sliding sash-Inside



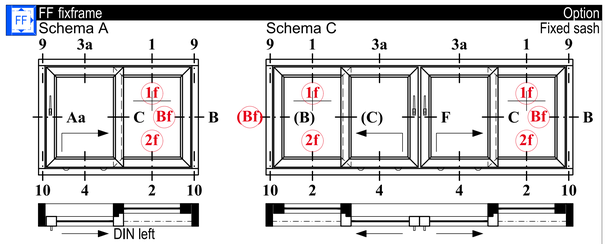
Schema A and Schema C

Alternative to cover profile for Section:

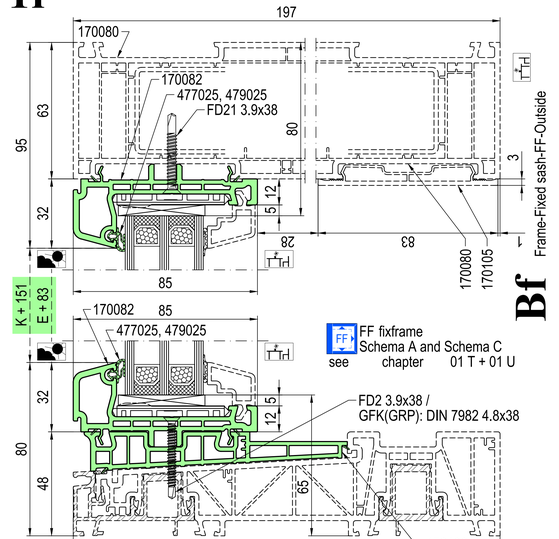
3a Top-Frame-Sliding sash-Inside with cover profile

FF fixframe — Option

Schema A / Schema C — Fixed sash



1f Top-Frame-Fixed sash-FF-Outside



2f Bottom-Threshold-Fixed sash-FF-Outside

Option	Modules +
BF barrier-free	Option =
Sliding sash	
FF fixframe	Option =
Fixed sash	(small)
"V" aluskin	Option =
Aluminium shells	

"V", BF, "V"BF, FF, "V"FF, FFBF, "V"FFBF

Schema A/C/D/F

General	"V"	BF	"V" BF
	AI		AI

Schema A/C

FF	"V" FF	FFBF	"V"FFBF
FF	FF AI	FF	FF AI

Modules: Options / Alternatives

	Alternative	"basic"	"standard"	"premium"
|F| Reinforcement for frame 170080	229125 3) 229126 3)	27910x	24922x	24922x
|F| Reinforcement for sash 170x81	229114 1) 229115 1) 279082 4)	229125 229126 279036 4)	229125 229126 279036 4)	229125 229126 279036 4)
|S| Guide rail	-	27715x	27715x	27715x
|S| Runner rail	27713x 277180 2)	27727x 27729x 2)	27727x 27729x 2)	27713x 277180 2)
|U| Threshold	⬇ 27716x	⬇ 27726x	⬇ 27726x	⬇ 27911x 5)
Cover profile for schema A/C	170105 Section 3 Section A	170104 Section 3a Section Aa	170104 Section 3a Section Aa	170104 Section 3a Section Aa

1) \|Z\| 670290 required

2) BF: \|S\| 279189 required

3) Simple frame connection

4) Option = \|F\| 279083, 279084 = ↕ vertical

5) GRP

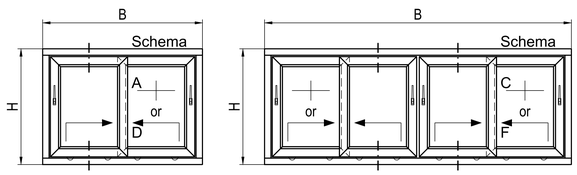
Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections

1, 2, 3, ...



chapter 01 General Information — page 01

01 Q Overview

Modules "basic" "standard" "premium"

Options / Alternatives

aluplast Kunststoff-Fenstersysteme — foam inside

www.aluplast.net — Lift-and-slide door 85mm

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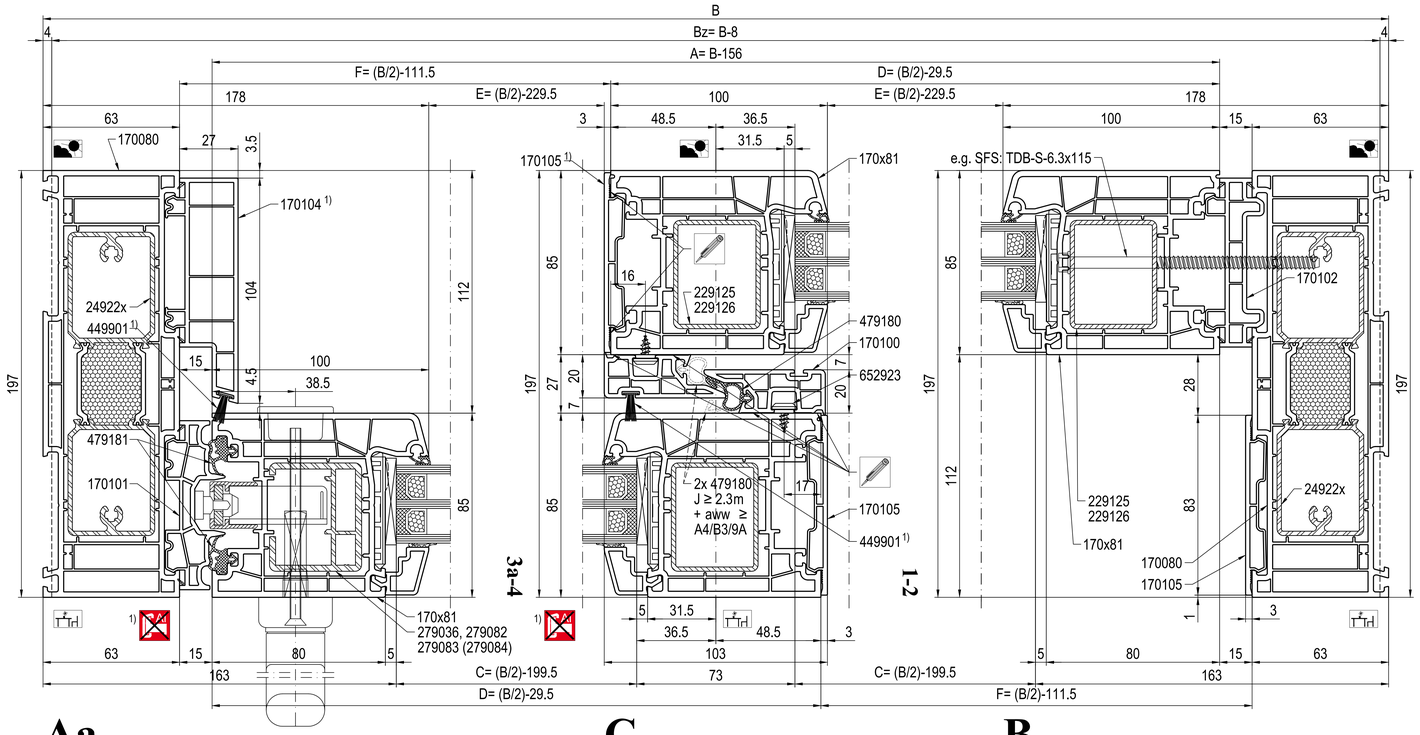
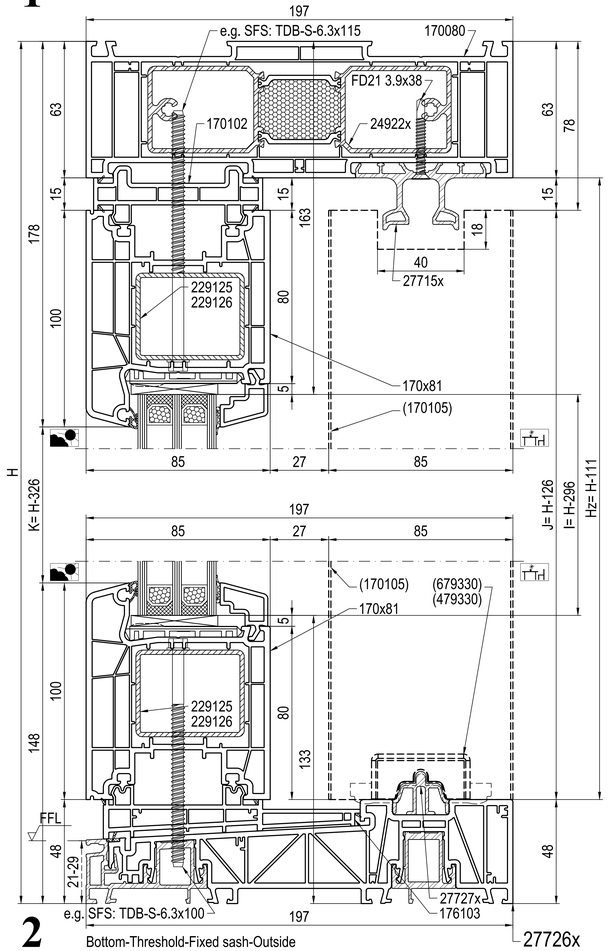


Aa Frame-Sliding sash-Inside with cover profile

C Interlock

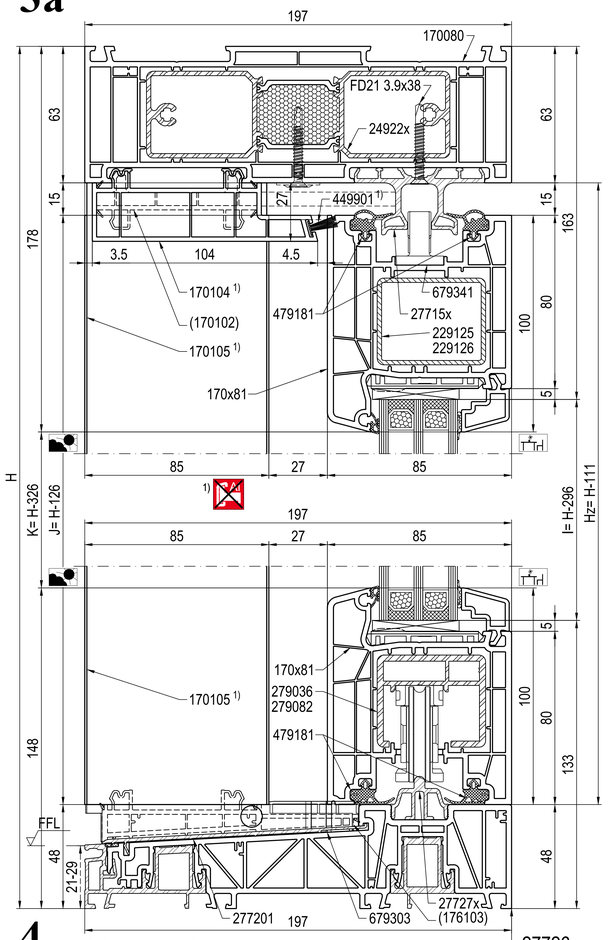
B Frame-Fixed sash-Outside

1 Top-Frame-Fixed sash-Outside



2 Bottom-Threshold-Fixed sash-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4 Bottom-Threshold-Sliding sash-Inside

Options / Alternatives

Modules 6)	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 3) 229126 3)
|F| Reinforcement for sash 170x81				
	229125 229126	279082 4)	229114 1) 229115 1)	
	279036 4)	279082 4)		
|S| Guide rail	27715x			
|S| Runner rail	27727x		27713x	27713x
	27729x 2)		277180 2)	277180 2)
|U| Threshold	⬇		⬇	⬇
	27726x		27911x 5)	27716x
Cover profile for schema A/C	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) |Z| 670290 required
2) BF: |S| 279189 required
3) Simple frame connection
4) Option = |F| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols

- Schema "v": Not admissible with aluminium shells
- Sealing (silicone rubber)
- FFL: Finished Floor Level
- Weather side / Outside
- Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions — Widths

	Schema A	Schema C		uPVC
	Schema D	Schema F		
A=	B-156	(B/2)-85	2 sashes	
B=	B	B	Element	
C=	(B/2)-199.5	(B/4)-164	Glass	
D=	(B/2)-29.5	(B/4)+6	Sash 1)	
E=	(B/2)-229.5	(B/4)-194	Sash clearance	
F=	(B/2)-111.5	(B/4)-76	Overall clearance	
G=	-	(B/2)-168	Overall clearance outside	
Bz=	B-8	B-8	Threshold, frame	
Ca=	-	-	Glass, deviant	
Da=	-	-	Sash, deviant	
Ea=	-	-	Sash clearance, deviant	

Vertical deduction dimensions — Heights

			uPVC	
h=	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296		✓	Glass
J=	H-126		✓	Sash 1)
K=	H-326		✓	Sash clearance
L=	-		✓	Exterior frame
M=	-		✓	Interior frame
Hz=	H-111		✓ ...	Frame

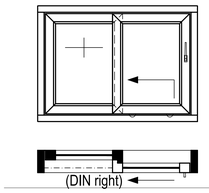
1) Weld shrinkage allowance to be added!

Horizontal sections

A, B, C, ...

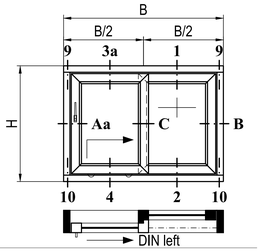
▫ / ▫ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



Vertical sections

1, 2, 3, ...



chapter 01 General Information — page

01 R Deduction Dimensions — 01 Schema A

Partition	1/2 : 1/2
Sash	2
Sliding sash	1
Fixed sash	1

aluplast Kunststoff-Fenstersysteme

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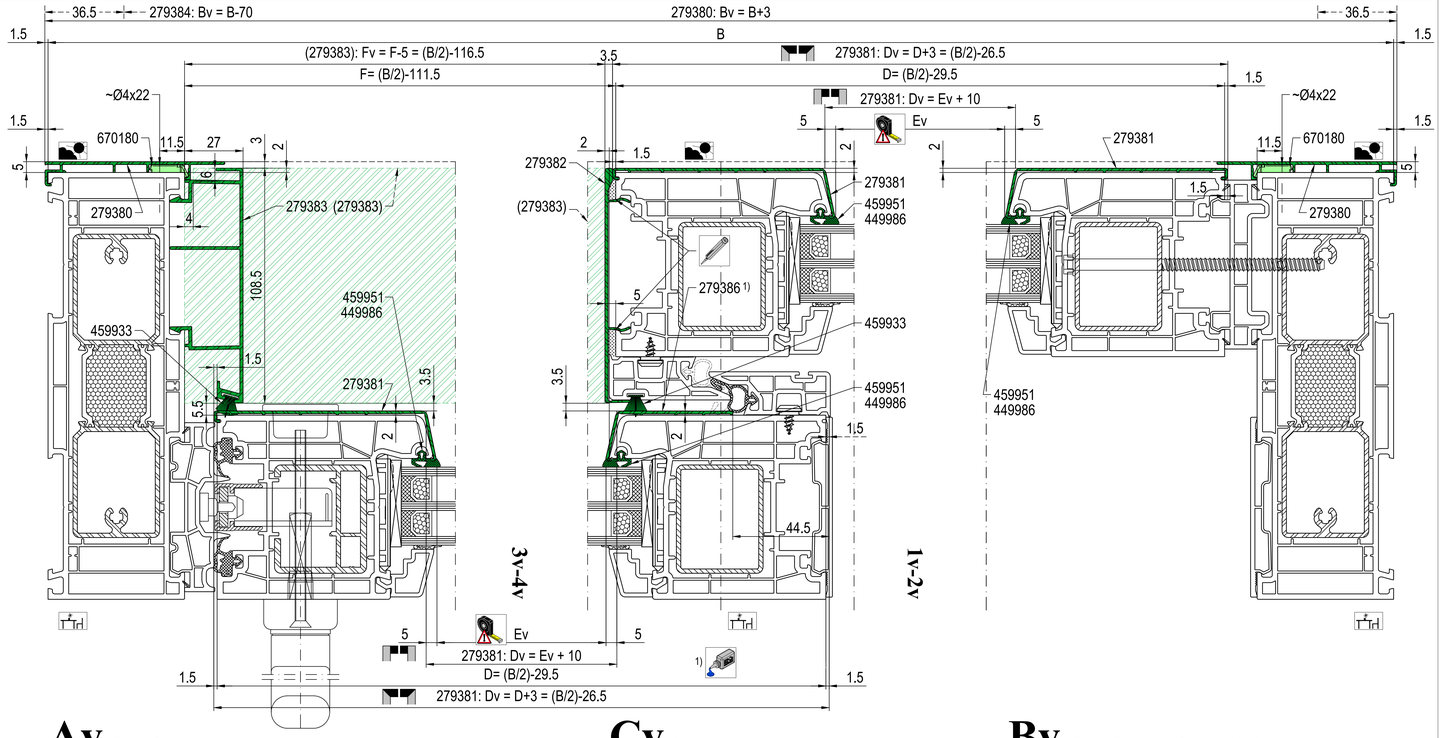
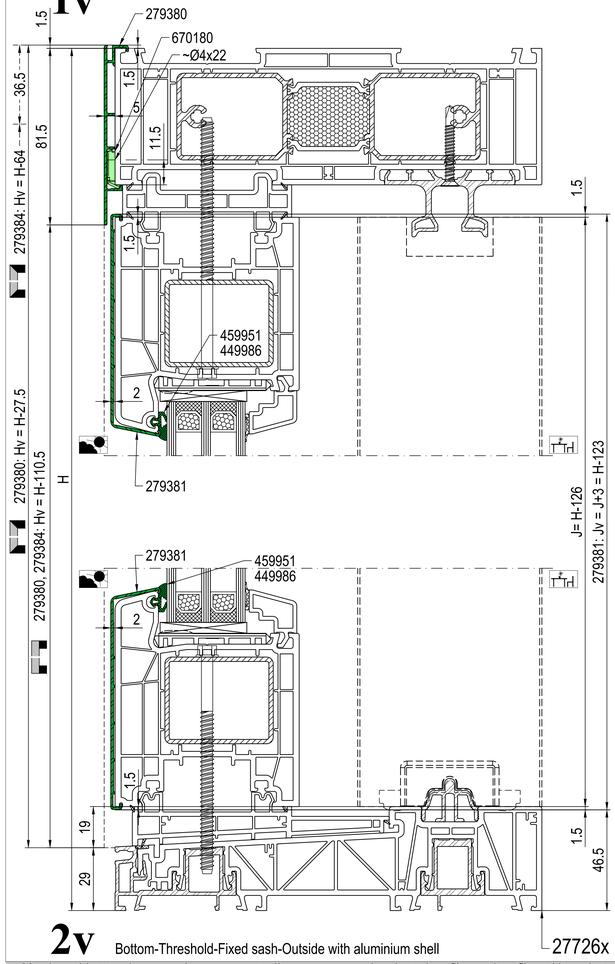


Av Frame-Sliding sash-Inside with aluminium shell

Cv Interlock with aluminium shell

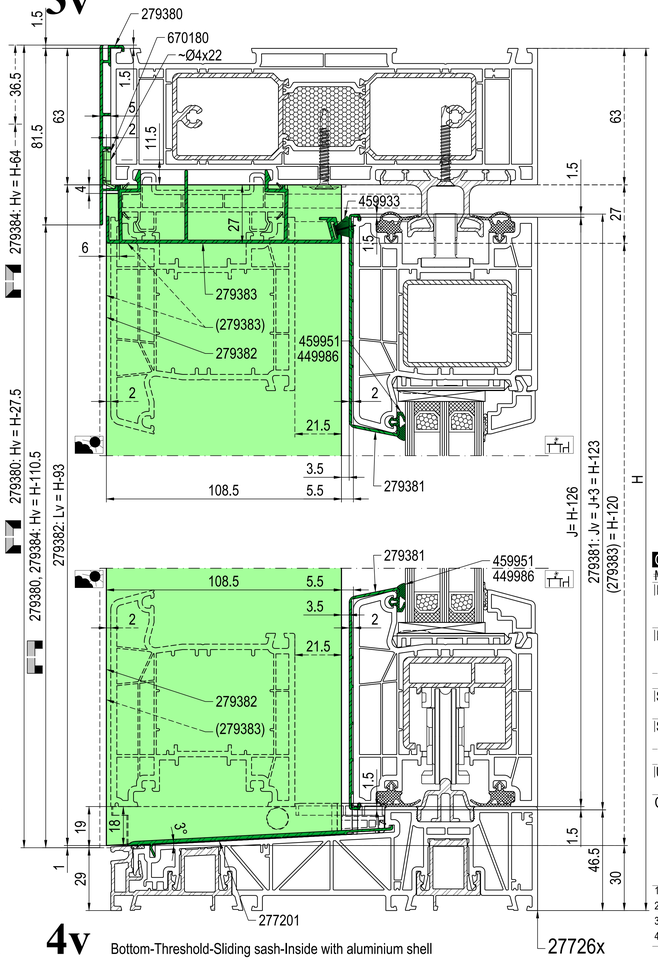
Bv Frame-Fixed sash-Outside with aluminium shell

1v Top-Frame-Fixed sash-Outside with aluminium shell



2v Bottom-Threshold-Fixed sash-Outside with aluminium shell

3v Top-Frame-Sliding sash-Inside with aluminium shell



4v Bottom-Threshold-Sliding sash-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A / Schema D	Schema C / Schema F	Widths uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Vertical deduction dimensions			Heights uPVC
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

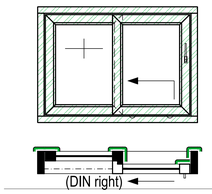
...v **aluskin** Aluminium shells

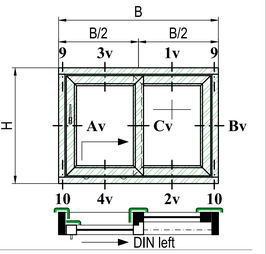
1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B





chapter 01 General Information
page

01 R Deduction Dimensions — 02 Schema A "v"

Partition	1/2 : 1/2
Sash	2
Sliding sash	1
Fixed sash	1
Aluminium shells	aluskin

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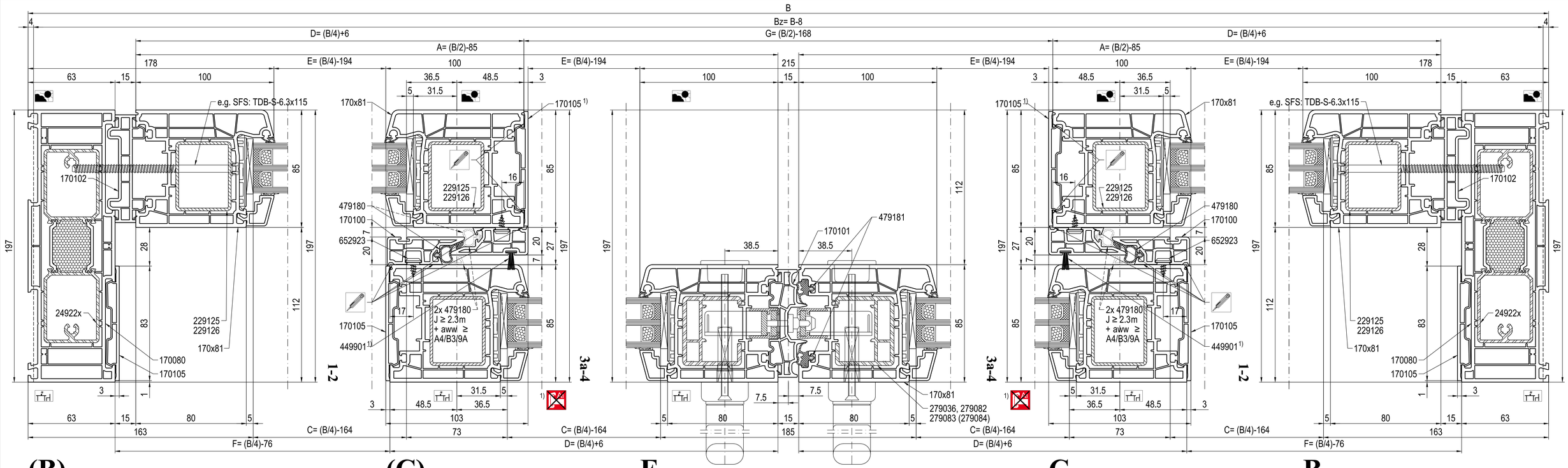


(B) Section B mirror-inverted

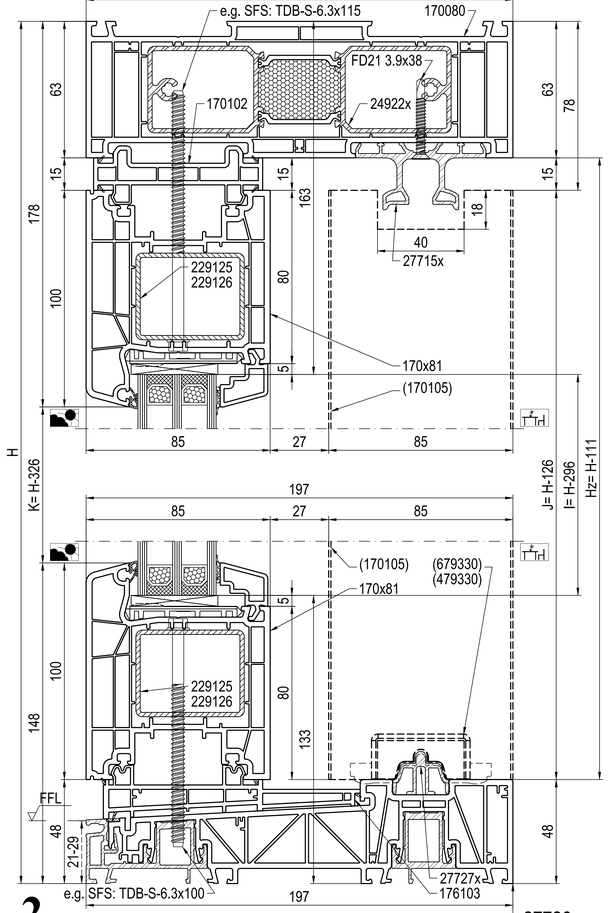
(C) Section C mirror-inverted

F Meeting rail-Sliding sash-Inside

C Interlock

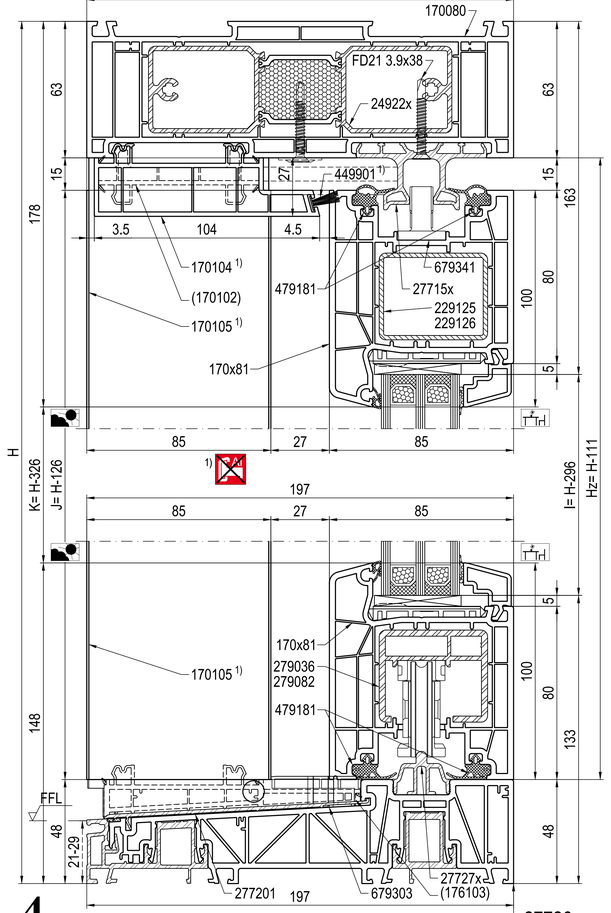
B Frame-Fixed sash-Outside

1 Top-Frame-Fixed sash-Outside



2 Bottom-Threshold-Fixed sash-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4 Bottom-Threshold-Sliding sash-Inside

Options / Alternatives				
Modules 6)	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080				
	24922x	27910x		229125 3) 229126 3)
F Reinforcement for sash 170x81				
	229125 229126	279082 4)	229114 1) 229115 1)	
	279036 4)	279082 4)		
S Guide rail				
	27715x			
S Runner rail				
	27727x		27713x	27713x
	27729x 2)		277180 2)	277180 2)
U Threshold	⬇		⬇	⬇
	27726x		27911x 5)	27716x
Cover profile for schema A/C				
	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols

- Schema "v" — Not admissible with aluminium shells
- Sealing (silicone rubber)
- FFL — Finished Floor Level
- Weather side / Outside
- Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
Schema D	Schema F	⚠ uPVC
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash 1)
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

Vertical deduction dimensions		Heights
		⚠ uPVC
h= 48 mm	27 mm	Threshold U
H= H	H'+21	Element
I= H-296	✓	Glass
J= H-126	✓	Sash 1)
K= H-326	✓	Sash clearance
L= -	✓	Exterior frame
M= -	✓	Interior frame
Hz= H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections

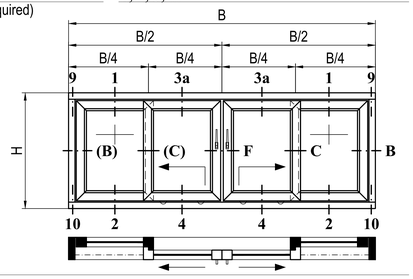
A, B, C, ...

▫ / ▫ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections

1, 2, 3, ...



chapter 01 General Information — page

01 R Deduction Dimensions — 03 Schema C

Partition	1/4 : 1/4 : 1/4 : 1/4
Sash	4
Sliding sash	2
Fixed sash	2

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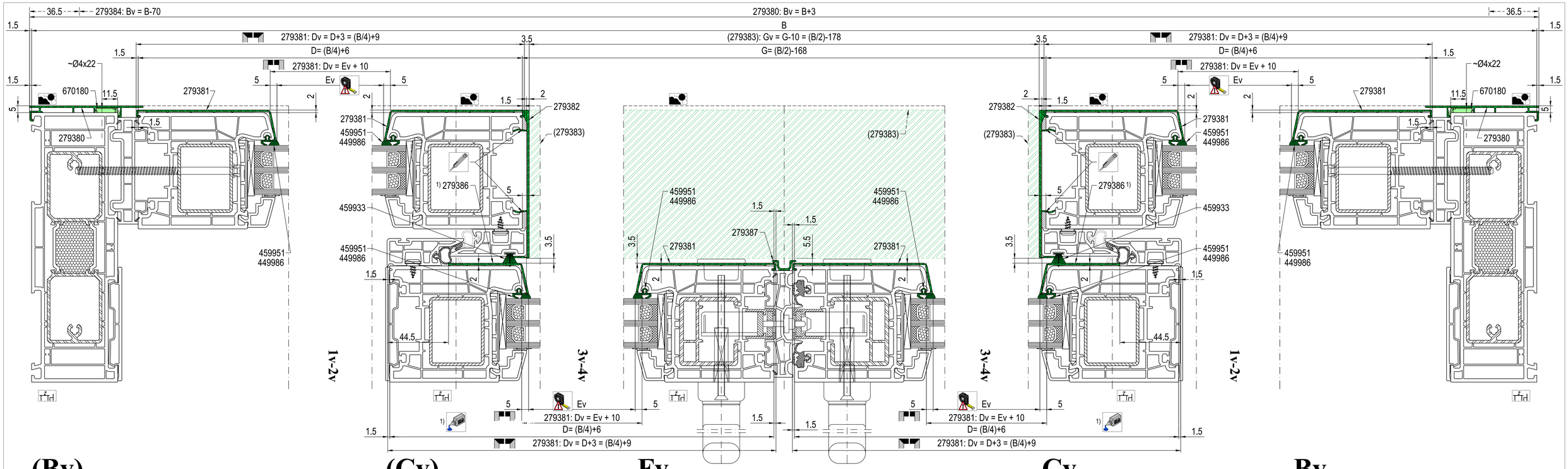


(Bv) Section Bv mirror-inverted

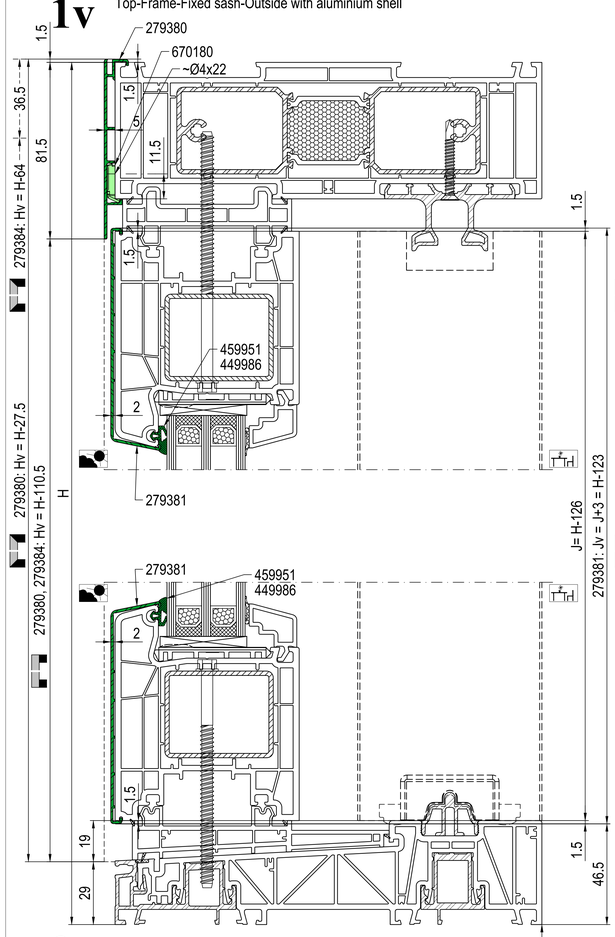
(Cv) Section Cv mirror-inverted

Fv Meeting rail-Sliding sash-Inside with aluminium shell

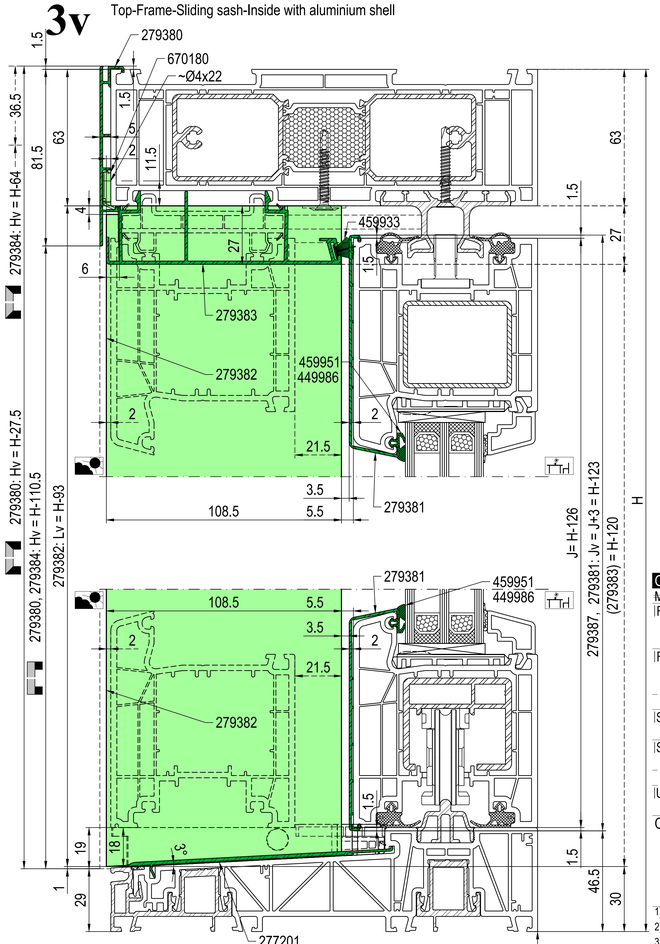
Cv Interlock with aluminium shell

Bv Frame-Fixed sash-Outside with aluminium shell

1v Top-Frame-Fixed sash-Outside with aluminium shell



3v Top-Frame-Sliding sash-Inside with aluminium shell



2v Bottom-Threshold-Fixed sash-Outside with aluminium shell

4v Bottom-Threshold-Sliding sash-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
	Schema A / Schema D	Schema C / Schema F
A=	B-156	(B/2)-85
B=	B	B
C=	(B/2)-199.5	(B/4)-164
D=	(B/2)-29.5	(B/4)+6
E=	(B/2)-229.5	(B/4)-194
F=	(B/2)-111.5	(B/4)-76
G=	-	(B/2)-168
Bz=	B-8	B-8
Ca=	-	-
Da=	-	-
Ea=	-	-

uPVC

2 sashes	
Element	
Glass	
Sash [1]	
Sash clearance	
Overall clearance	
Overall clearance outside	
Threshold, frame	
Glass, deviant	
Sash, deviant	
Sash clearance, deviant	

Vertical deduction dimensions			Heights
			uPVC
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash [1]
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

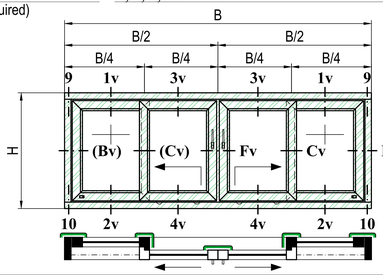
...v **aluskin** Aluminium shells

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



chapter 01 General Information page

01 R Deduction Dimensions 04 Schema C "v"

Partition	1/4 : 1/4 : 1/4 : 1/4
Sash	4
Sliding sash	2
Fixed sash	2
Aluminium shells	**aluskin**

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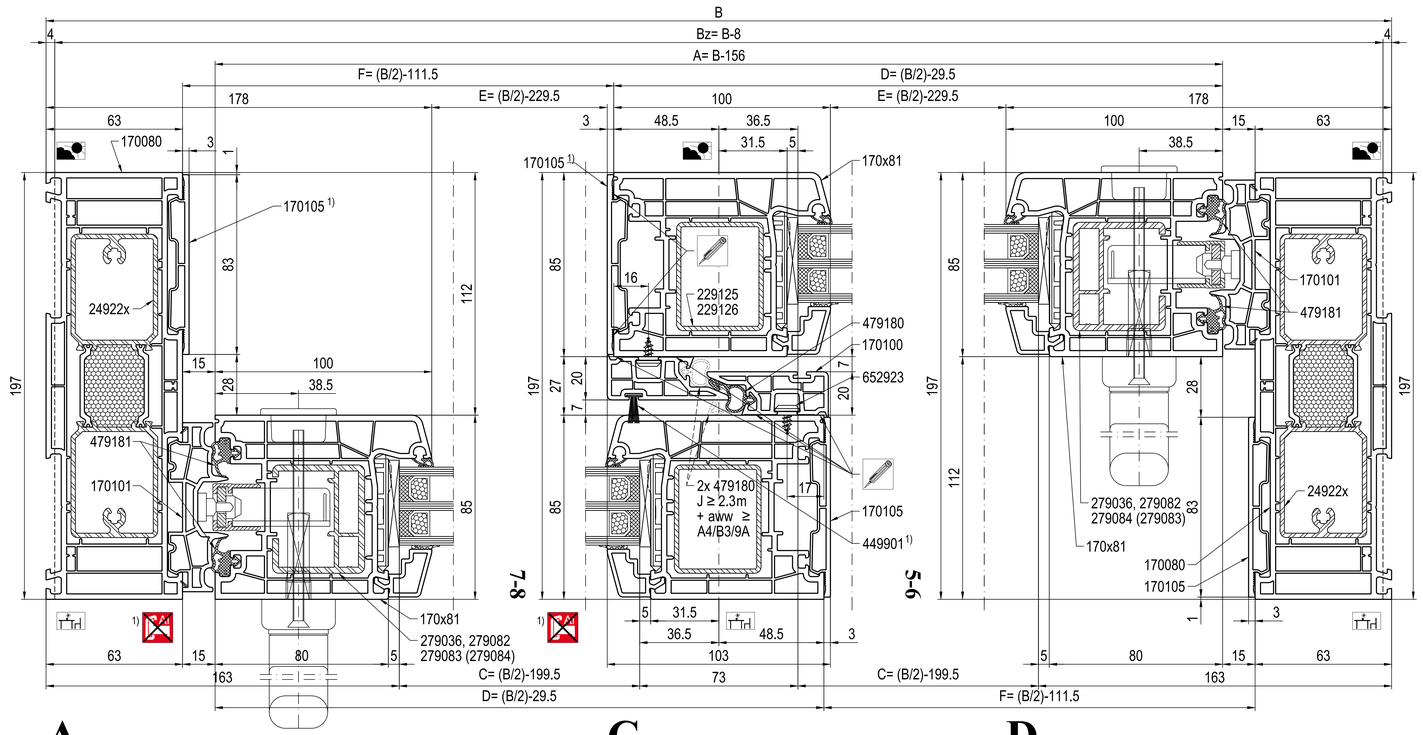
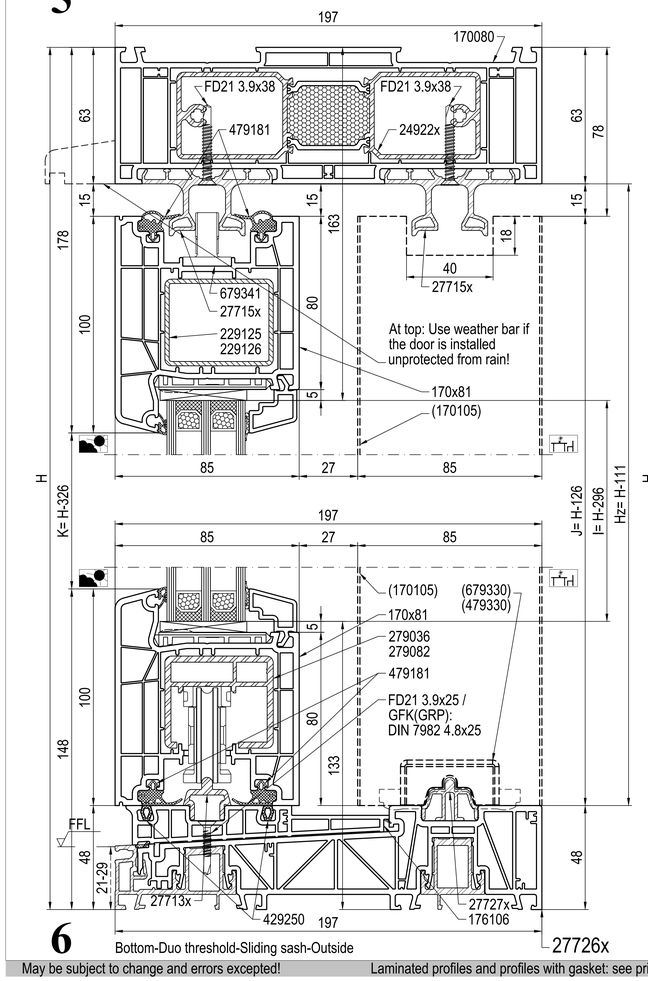


A Frame-Sliding sash-Inside

C Interlock

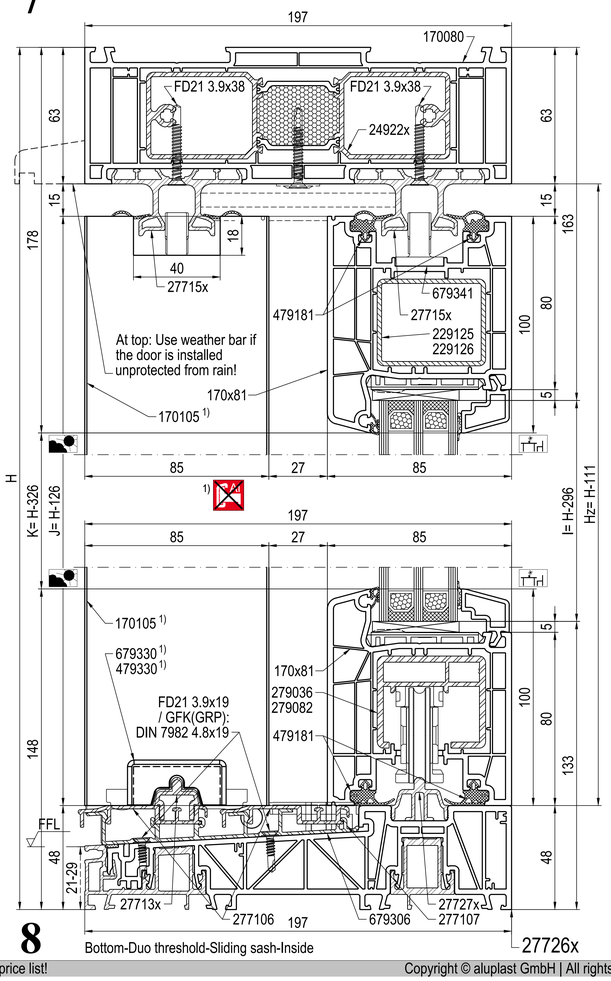
D Frame-Sliding sash-Outside

5 Top-Duo frame-Sliding sash-Outside



6 Bottom-Duo threshold-Sliding sash-Outside

7 Top-Duo frame-Sliding sash-Inside



8 Bottom-Duo threshold-Sliding sash-Outside

Options / Alternatives				
Modules 6)	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080				
	24922x	27910x		229125 3) 229126 3)
F Reinforcement for sash 170x81				
	229125 229126	279082 4)	229114 1) 229115 1)	
	279036 4)	279082 4)		
S Guide rail				
	27715x			
S Runner rail				
	27727x		27713x	27713x
	27729x 2)		277180 2)	277180 2)
U Threshold	⬇		⬇	⬇
	27726x		27911x 5)	27716x
Cover profile for schema A/C				
	170104 Section 3a Section Aa			170105 Section 3 Section A

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
Schema D	Schema F	⚠ uPVC
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash 1)
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

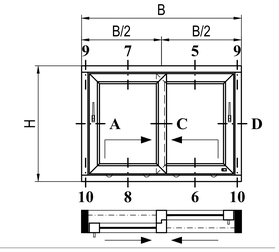
Vertical deduction dimensions		Heights
		⚠ uPVC
h= 48 mm	27 mm	Threshold U
H= H	H'+21	Element
I= H-296	✓	Glass
J= H-126	✓	Sash 1)
K= H-326	✓	Sash clearance
L= -	✓	Exterior frame
M= -	✓	Interior frame
Hz= H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ◂ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information page

01 R Deduction Dimensions 05 Schema D

Partition	1/2 : 1/2
Sash	2
Sliding sash	2
Fixed sash	-

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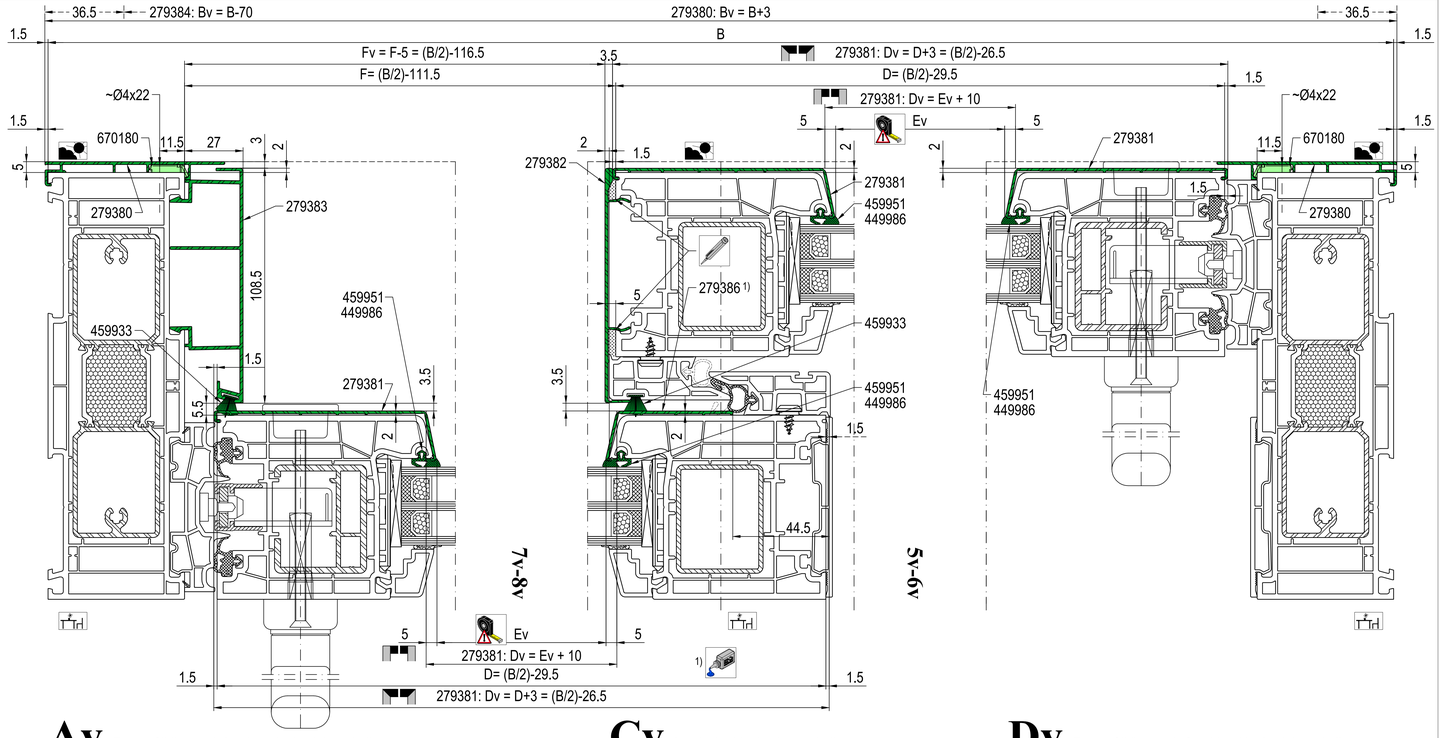
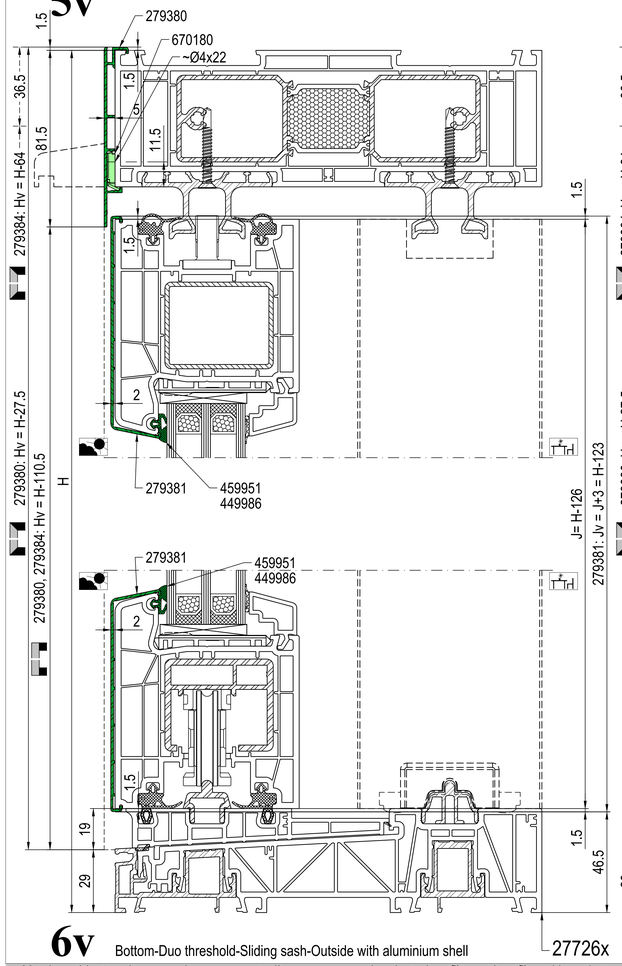


Av Frame-Sliding sash-Inside with aluminium shell

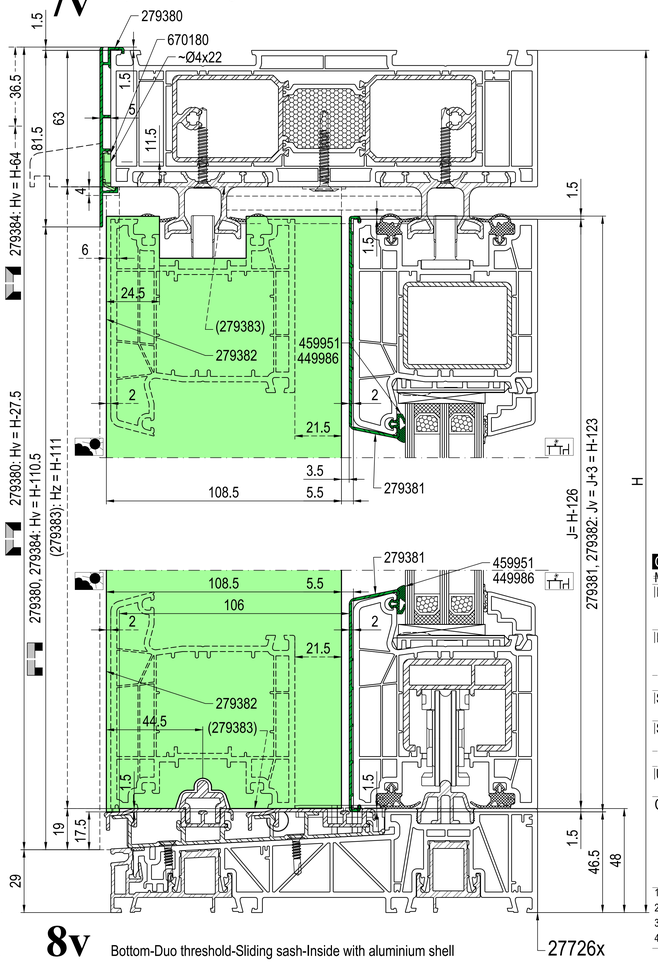
Cv Interlock with aluminium shell

Dv Frame-Sliding sash-Outside with aluminium shell

5v Top-Duo frame-Sliding sash-Outside with aluminium shell



7v Top-Duo frame-Sliding sash-Inside with aluminium shell



6v Bottom-Duo threshold-Sliding sash-Outside with aluminium shell

8v Bottom-Duo threshold-Sliding sash-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions			Widths
	Schema A	Schema C	
	Schema D	Schema F	uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

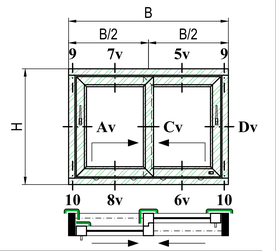
Vertical deduction dimensions			Heights
			uPVC
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...

...v **aluskin** Aluminium shells
1) Weld shrinkage allowance to be added!



chapter 01 General Information
page

01 R Deduction Dimensions — 06 Schema D "v"

Partition	1/2 : 1/2
Sash	2
Sliding sash	2
Fixed sash	-
Aluminium shells	aluskin

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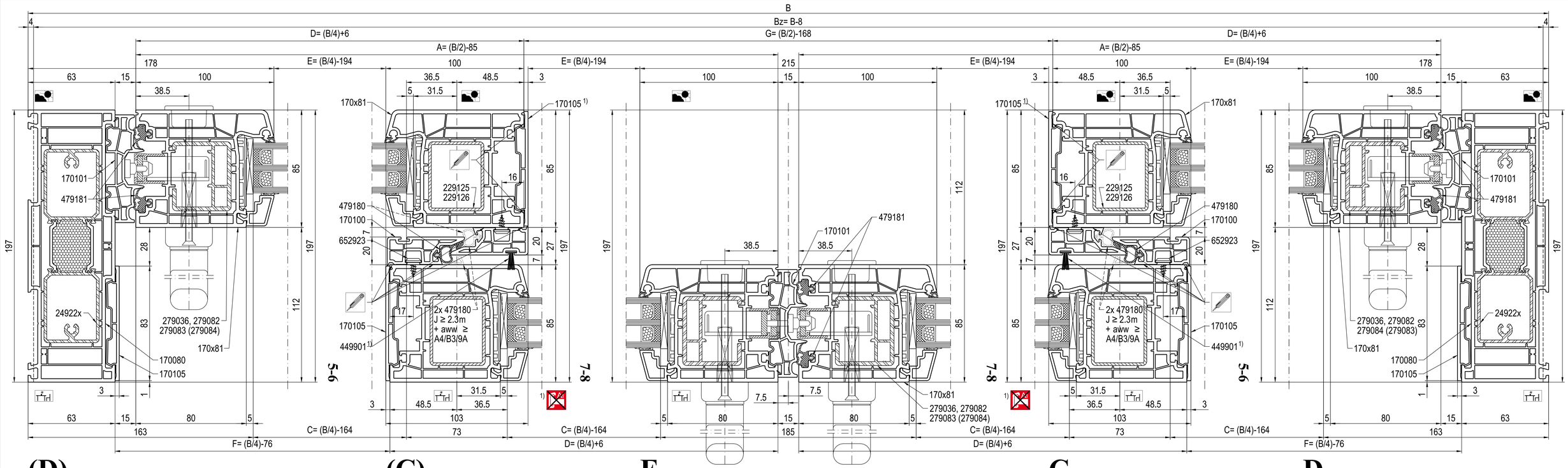


(D) Section D mirror-inverted

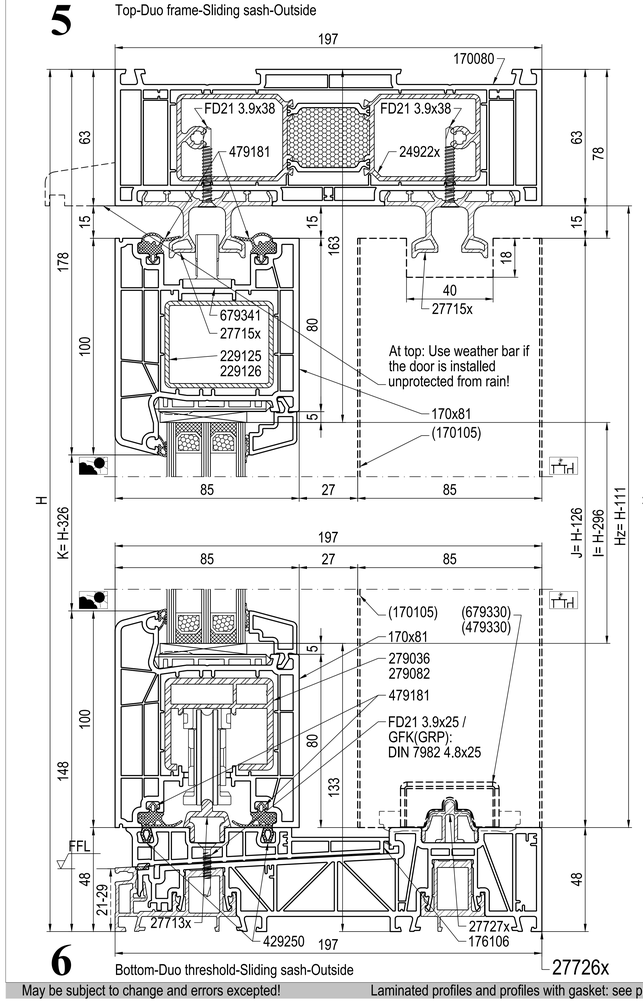
(C) Section C mirror-inverted

F Meeting rail-Sliding sash-Inside

C Interlock

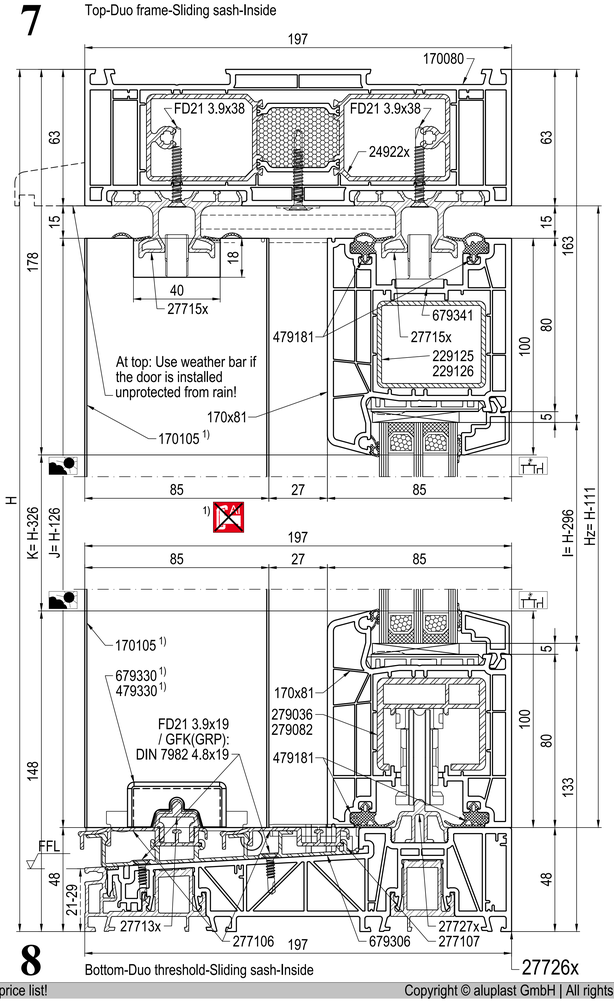
D Frame-Sliding sash-Outside

5 Top-Duo frame-Sliding sash-Outside



6 Bottom-Duo threshold-Sliding sash-Outside

7 Top-Duo frame-Sliding sash-Inside



8 Bottom-Duo threshold-Sliding sash-Outside

Options / Alternatives				
Modules 6)	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 3) 229126 3)
F Reinforcement for sash 170x81	229125 229126 279036 4)	279082 4)	229114 1) 229115 1)	
S Guide rail	27715x			
S Runner rail	27727x 27729x 2)		27713x 277180 2)	27713x 277180 2)
U Threshold	⬇ 27726x		⬇ 27911x 5)	⬇ 27716x
Cover profile for schema A/C	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
Schema D	Schema F	⚠ uPVC
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash 1)
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

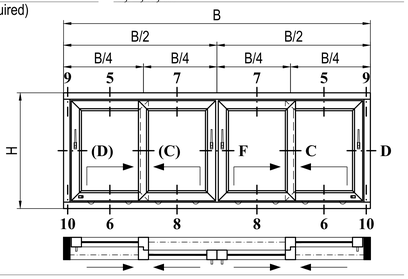
Vertical deduction dimensions			Heights
		⚠ uPVC	
h= 48 mm	27 mm	Threshold U	
H= H	H'+21	Element	
I= H-296	✓	Glass	
J= H-126	✓	Sash 1)	
K= H-326	✓	Sash clearance	
L= -	✓	Exterior frame	
M= -	✓	Interior frame	
Hz= H-111	✓ ...	Frame	

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ◂ Stopper left / right (where required)

9 Top-Frame-Profile
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information page

01 R Deduction Dimensions 07 Schema F

Partition	1/4 : 1/4 : 1/4 : 1/4
Sash	4
Sliding sash	4
Fixed sash	-

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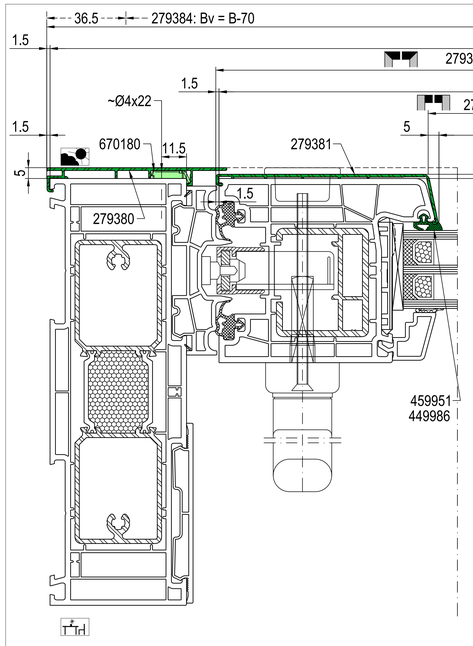
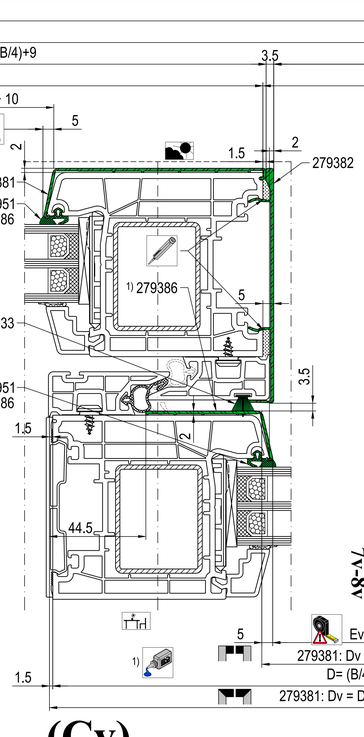
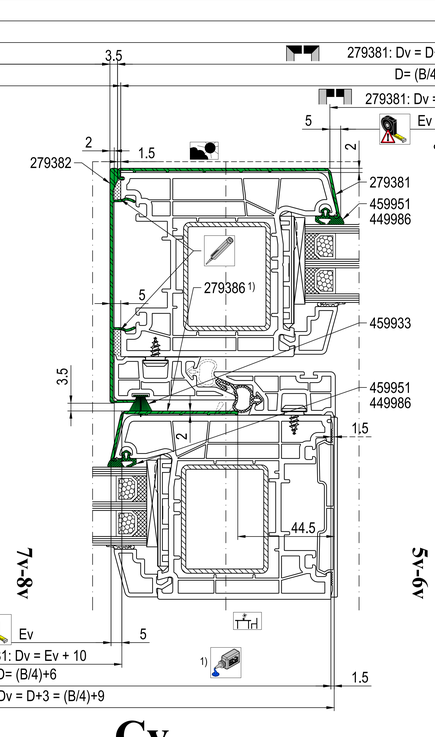
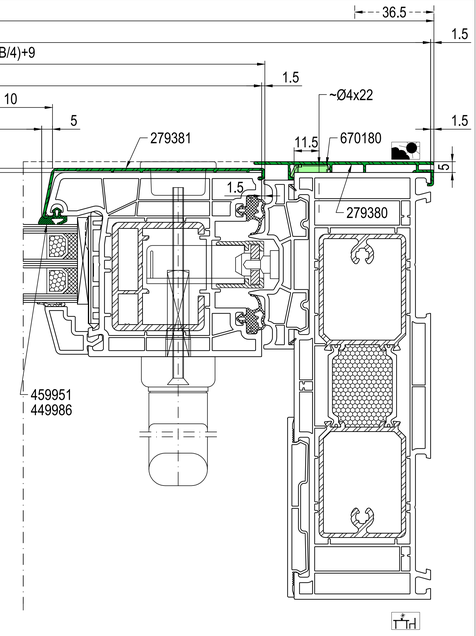








(Dv) Section Dv mirror-inverted

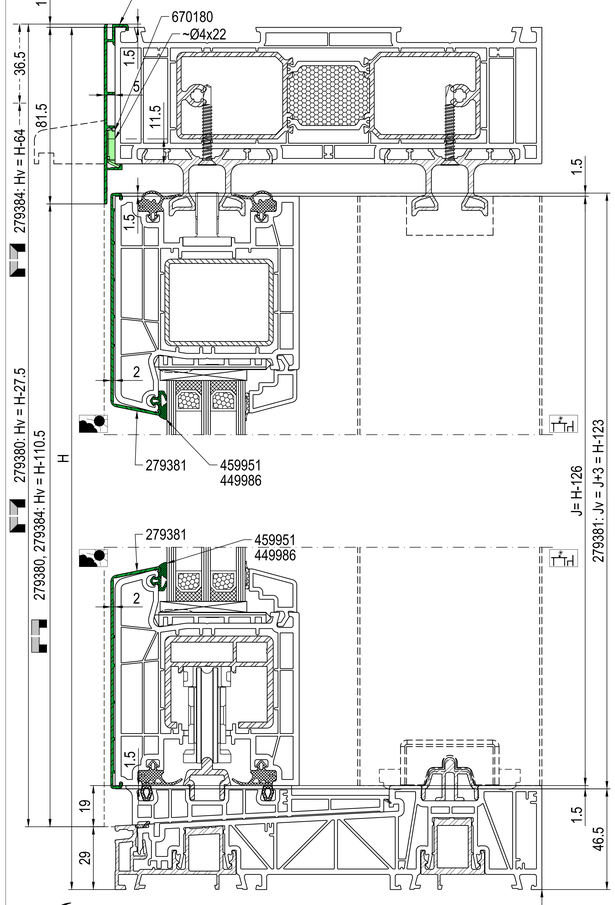
(Cv) Section Cv mirror-inverted

Fv Meeting rail-Sliding sash-Inside with aluminium shell

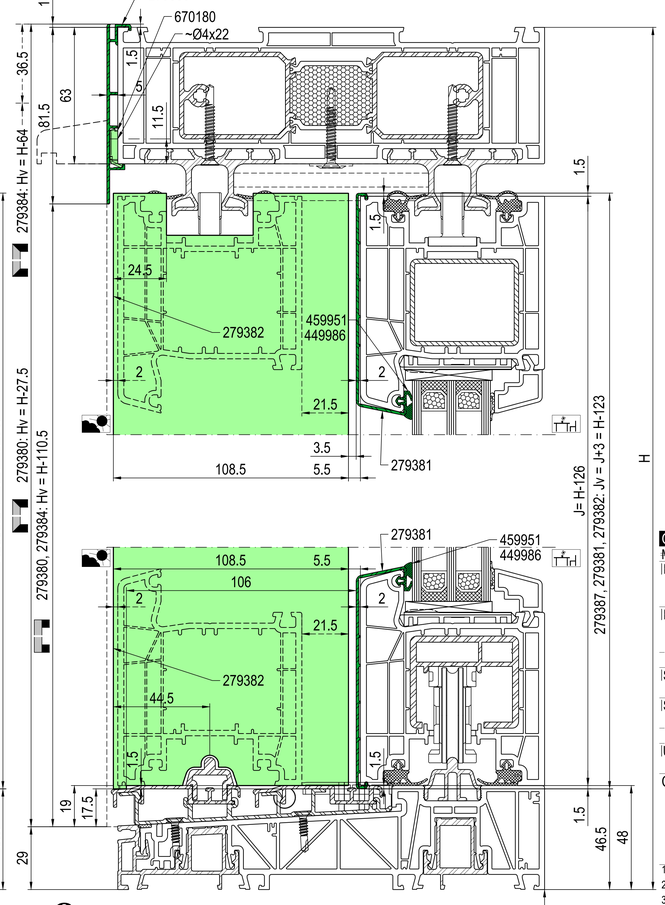
Cv Interlock with aluminium shell

Dv Frame-Sliding sash-Outside with aluminium shell

5v Top-Duo frame-Sliding sash-Outside with aluminium shell



7v Top-Duo frame-Sliding sash-Inside with aluminium shell



6v Bottom-Duo threshold-Sliding sash-Outside with aluminium shell

8v Bottom-Duo threshold-Sliding sash-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section 3a			Section 3
	Section Aa			Section A

1) |Z| 670290 required
2) BF: |S| 279189 required
3) Simple frame connection
4) Option = |F| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
	Schema A / Schema D	Schema C / Schema F
A=	B-156	(B/2)-85
B=	B	B
C=	(B/2)-199.5	(B/4)-164
D=	(B/2)-29.5	(B/4)+6
E=	(B/2)-229.5	(B/4)-194
F=	(B/2)-111.5	(B/4)-76
G=	-	(B/2)-168
Bz=	B-8	B-8
Ca=	-	-
Da=	-	-
Ea=	-	-

uPVC: 2 sashes; Element; Glass; Sash [1]; Sash clearance; Exterior frame; Interior frame; Overall clearance outside; Threshold, frame; Glass, deviant; Sash, deviant; Sash clearance, deviant

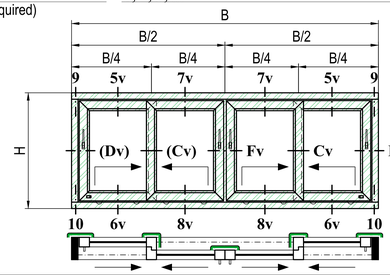
Vertical deduction dimensions			Heights
			uPVC
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash [1]
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

...v aluskin Aluminium shells

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▫ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...
9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



chapter 01 General Information page

01 R Deduction Dimensions 08 Schema F "v"

Partition	1/4 : 1/4 : 1/4 : 1/4
Sash	4
Sliding sash	4
Fixed sash	-
Aluminium shells	aluskin
	Lift-and-slide door 85mm

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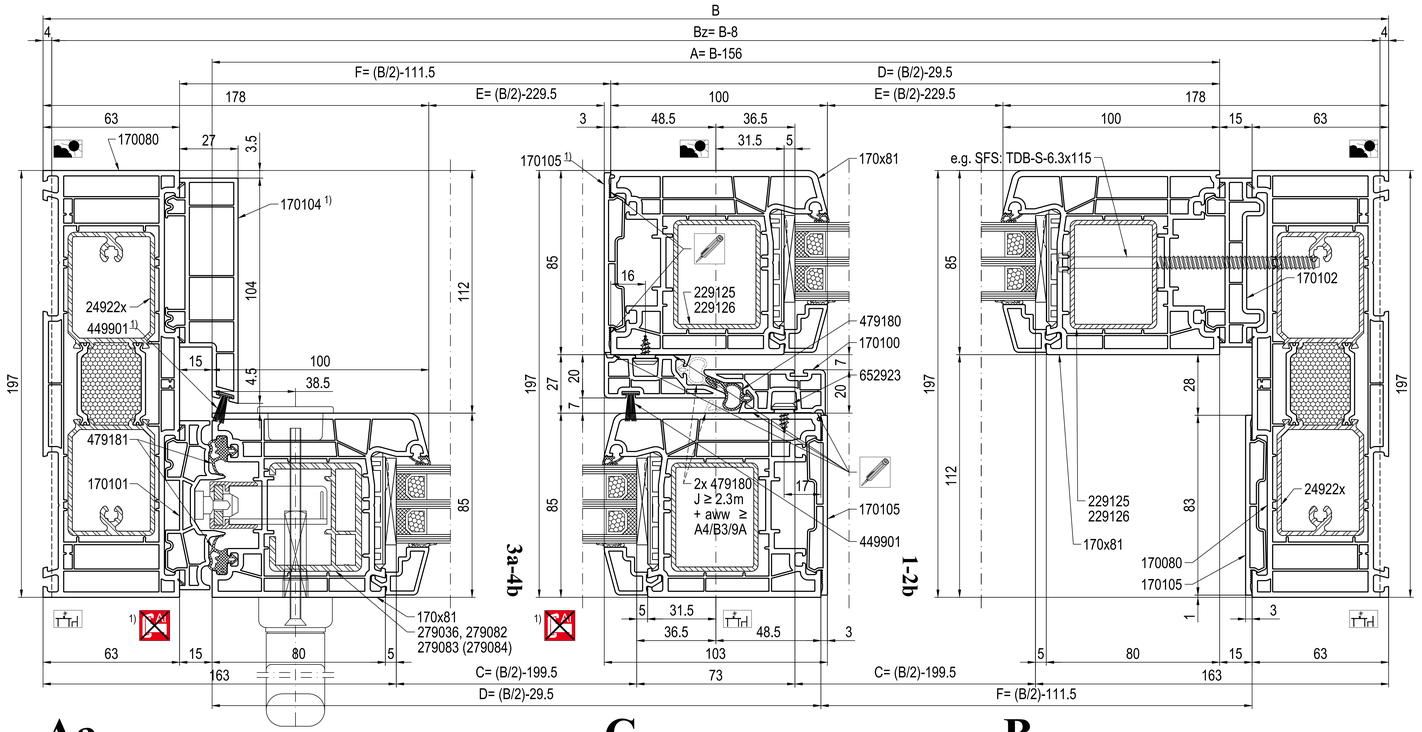
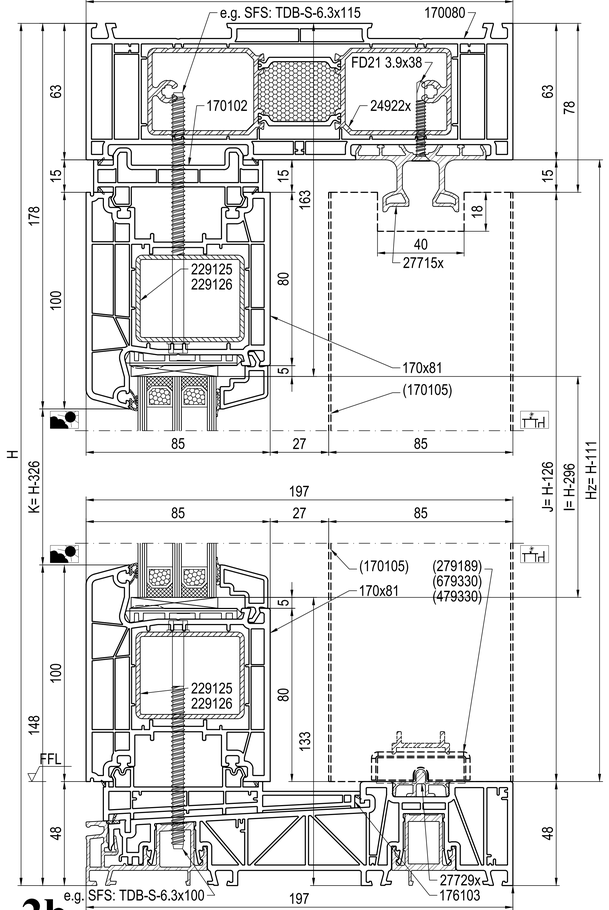


Aa Frame-Sliding sash-Inside with cover profile

C Interlock

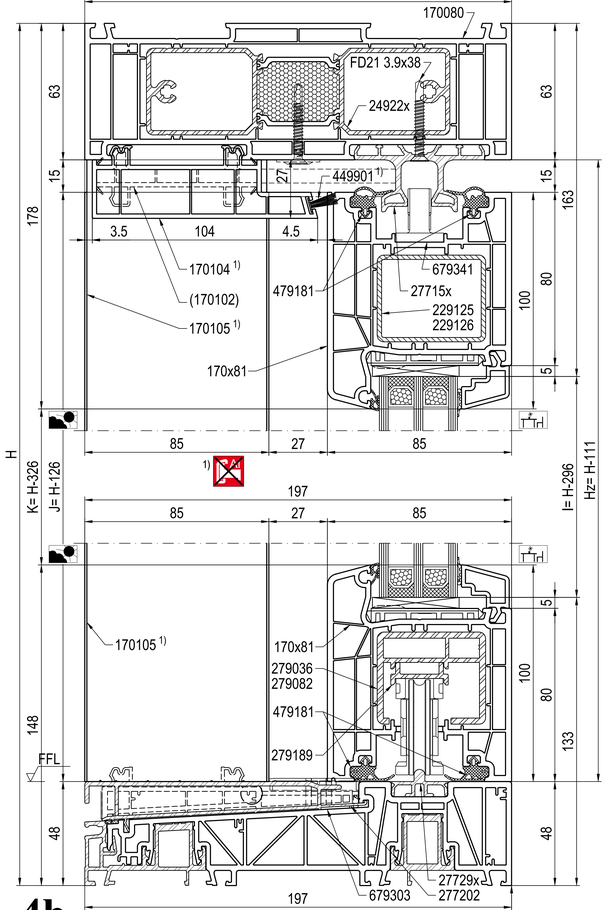
B Frame-Fixed sash-Outside

1 Top-Frame-Fixed sash-Outside



2b Bottom-Threshold-Fixed sash-BF-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4b Bottom-Threshold-Sliding sash-BF-Inside

Options / Alternatives				
Modules 6)	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080				
	24922x	27910x		229125 3) 229126 3)
F Reinforcement for sash 170x81				
	229125 229126	279082 4)	229114 1) 229115 1)	
	279036 4)	279082 4)		
S Guide rail				
	27715x			
S Runner rail				
	27727x		27713x	27713x
	27729x 2)		277180 2)	277180 2)
U Threshold	⬇		⬇	⬇
	27726x		27911x 5)	27716x
Cover profile for schema A/C				
	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) |Z| 670290 required
2) BF: |S| 279189 required
3) Simple frame connection
4) Option = |F| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A / Schema D	Schema C / Schema F	Widths uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

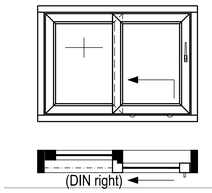
Vertical deduction dimensions			Heights uPVC
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

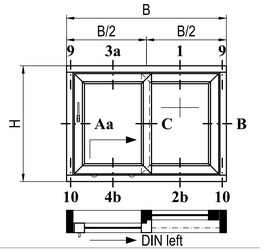
1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▫ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B





chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions — **01 Schema A** — **BF**

Partition	1/2 : 1/2	
Sash	2	
Sliding sash	1	BF barrier-free
Fixed sash	1	

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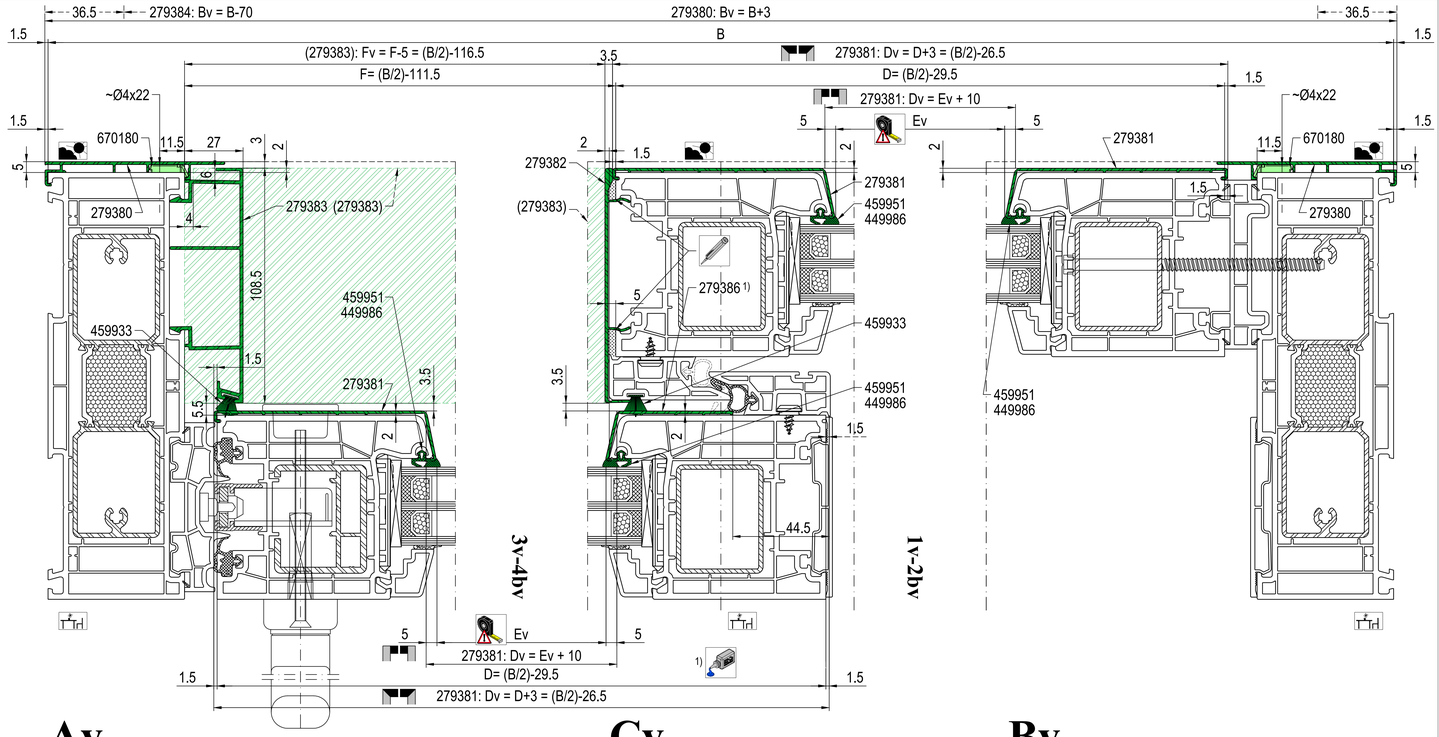
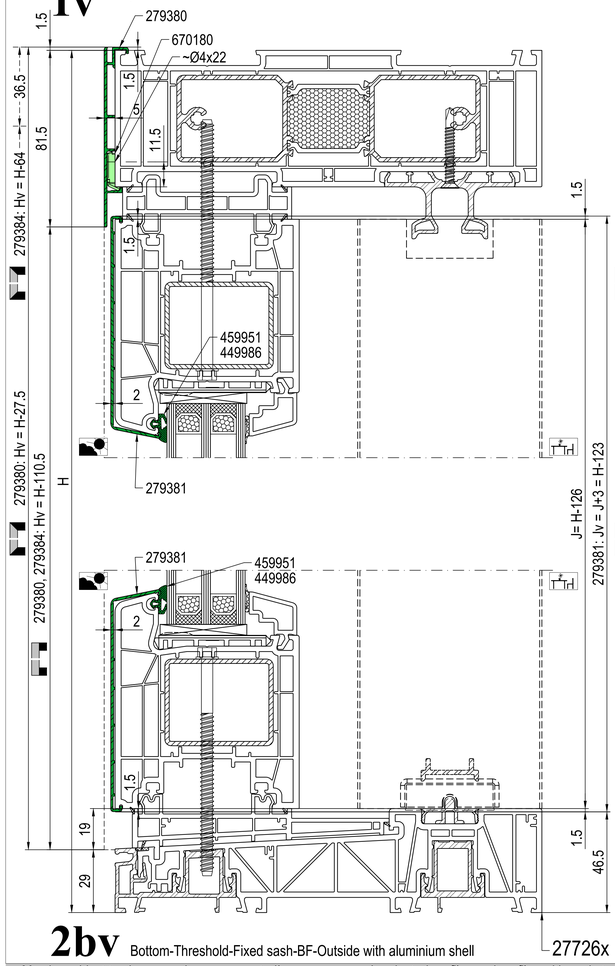


Av Frame-Sliding sash-Inside with aluminium shell

Cv Interlock with aluminium shell

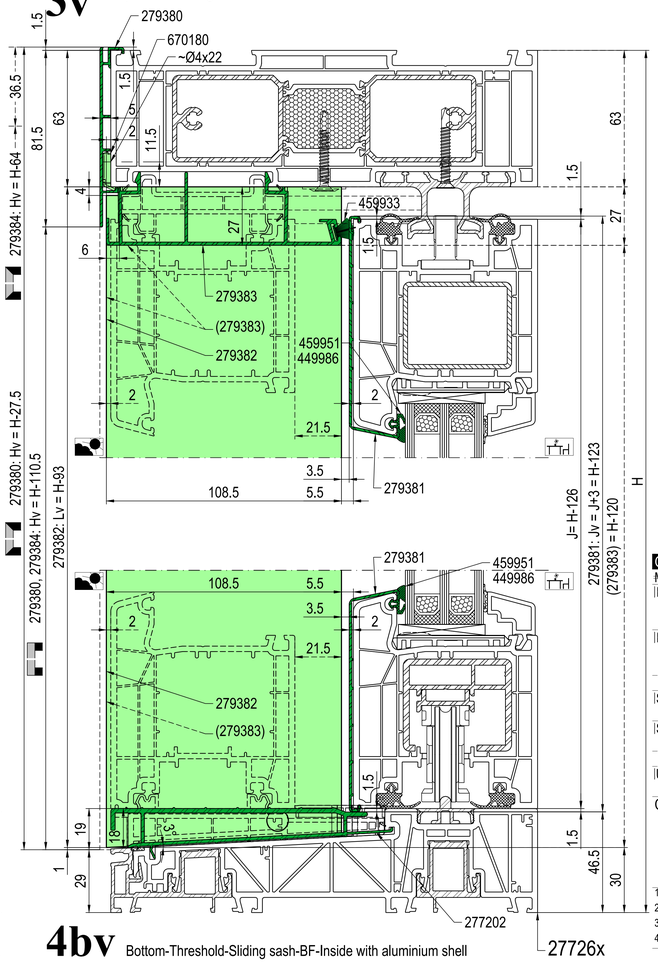
Bv Frame-Fixed sash-Outside with aluminium shell

1v Top-Frame-Fixed sash-Outside with aluminium shell



2bv Bottom-Threshold-Fixed sash-BF-Outside with aluminium shell

3v Top-Frame-Sliding sash-Inside with aluminium shell



4bv Bottom-Threshold-Sliding sash-BF-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols

- ... (black) — Cut: mitre joint
- ... (black) — Cut: butt joint
- Attention: measure the dimensions
- Sealing (silicone rubber)
- (suitable) Adhesive
- FFL — Finished Floor Level
- Weather side / Outside
- Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
Schema D	Schema F	uPVC
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash 1)
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

Vertical deduction dimensions			Heights
		uPVC	
h= 48 mm	27 mm		Threshold |U|
H= H	H'+21		Element
I= H-296		✓	Glass
J= H-126		✓	Sash 1)
K= H-326		✓	Sash clearance
L= -		✓	Exterior frame
M= -		✓	Interior frame
Hz= H-111	...	✓	Frame

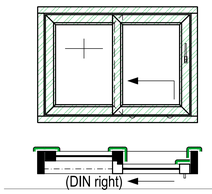
...v **aluskin** Aluminium shells

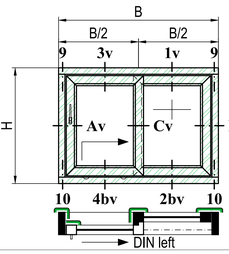
1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B





chapter 01 General Information — page barrier-free

01 S Deduction Dimensions — **02 Schema A "v"** — **BF**

Partition 1/2 : 1/2
Sash 2
Sliding sash 1 BF barrier-free
Fixed sash 1
Aluminium shells **aluskin**

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Lift-and-slide door 85mm

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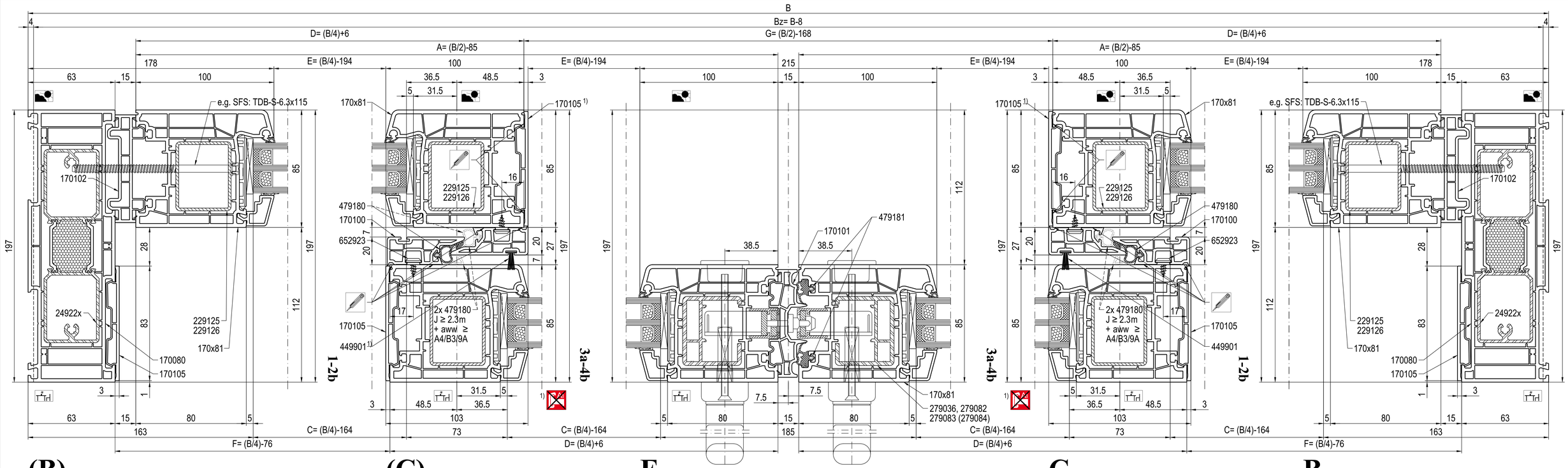


(B) Section B mirror-inverted

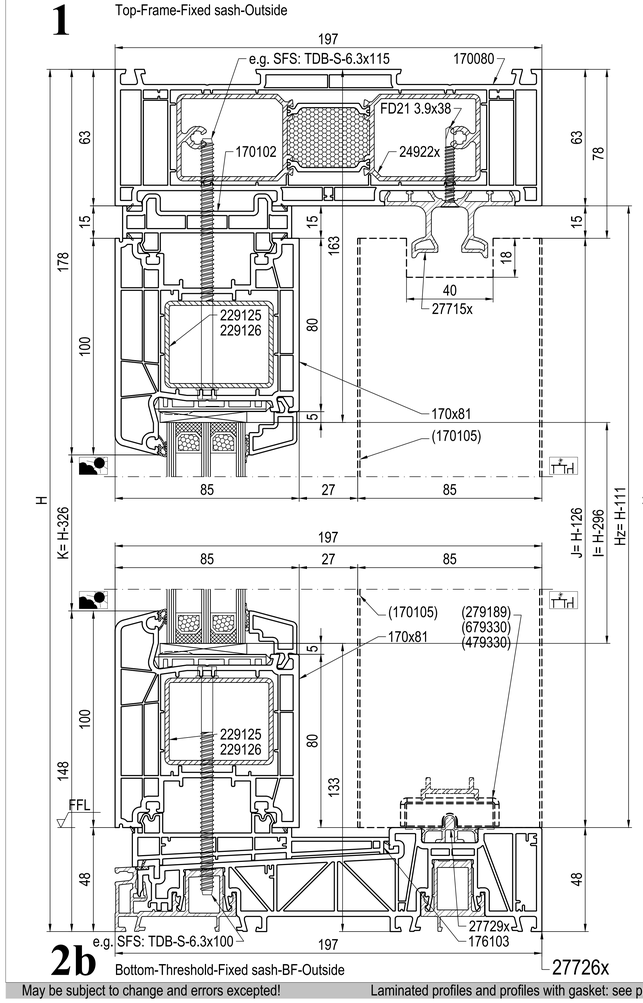
(C) Section C mirror-inverted

F Meeting rail-Sliding sash-Inside

C Interlock

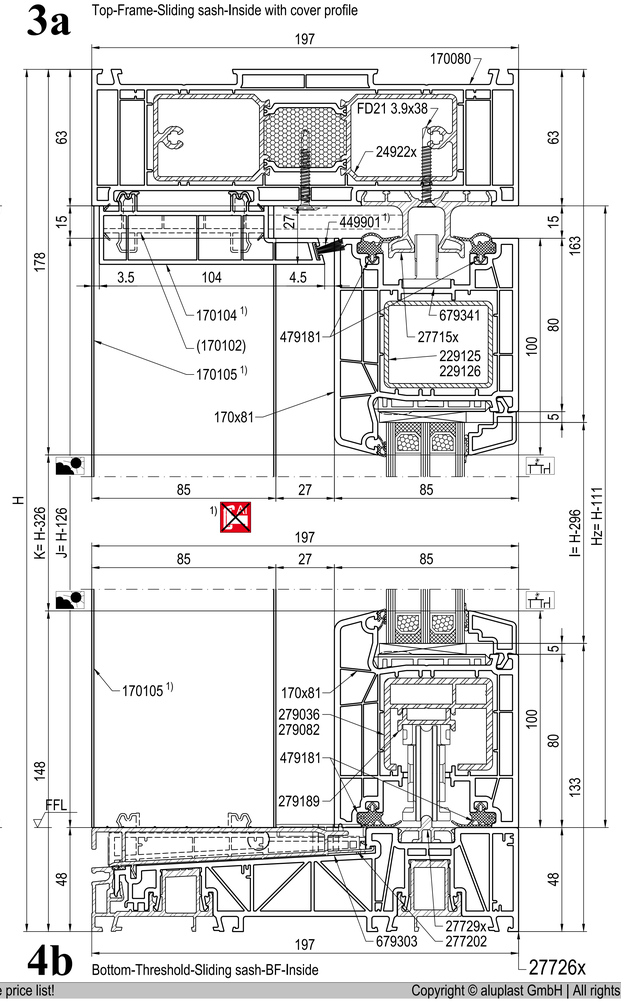
B Frame-Fixed sash-Outside

1 Top-Frame-Fixed sash-Outside



2b Bottom-Threshold-Fixed sash-BF-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4b Bottom-Threshold-Sliding sash-BF-Inside

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
F Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
S Guide rail	27715x			
S Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
U Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols

- Schema "v" — Not admissible with aluminium shells
- Sealing (silicone rubber)
- FFL — Finished Floor Level
- Weather side / Outside
- Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
	Schema A Schema C Schema D Schema F	⚠uPVC
A=	B-156	(B/2)-85 2 sashes
B=	B	B Element
C=	(B/2)-199.5	(B/4)-164 Glass
D=	(B/2)-29.5	(B/4)+6 Sash [1]
E=	(B/2)-229.5	(B/4)-194 Sash clearance
F=	(B/2)-111.5	(B/4)-76 Overall clearance
G=	-	(B/2)-168 Overall clearance outside
Bz=	B-8	B-8 Threshold, frame
Ca=	-	- Glass, deviant
Da=	-	- Sash, deviant
Ea=	-	- Sash clearance, deviant

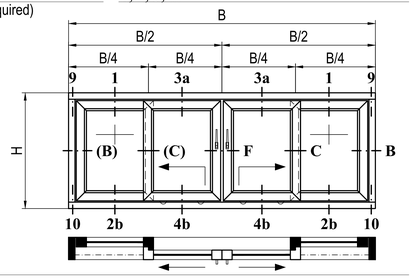
Vertical deduction dimensions		Heights
		⚠uPVC
h=	48 mm	27 mm Threshold U
H=	H	H'+21 Element
I=	H-296	✓ Glass
J=	H-126	✓ Sash [1]
K=	H-326	✓ Sash clearance
L=	-	✓ Exterior frame
M=	-	✓ Interior frame
Hz=	H-111	✓ ... Frame

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▫ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions — 03 — Schema C — BF

Partition	1/4 : 1/4 : 1/4 : 1/4	
Sash	4	
Sliding sash	2	BF barrier-free
Fixed sash	2	

aluplast Kunststoff-Fenstersysteme

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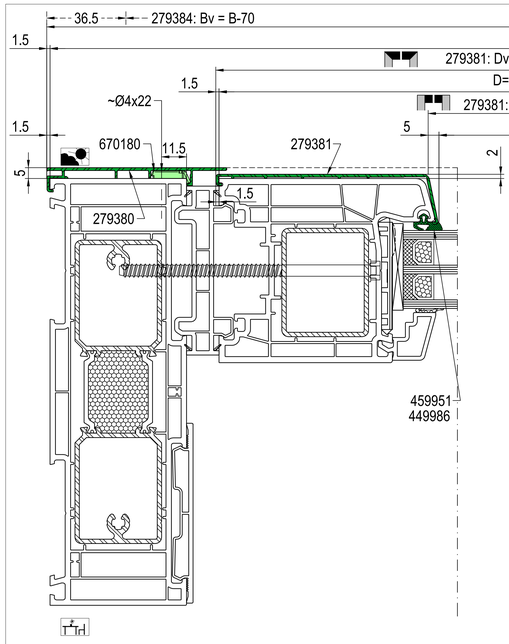
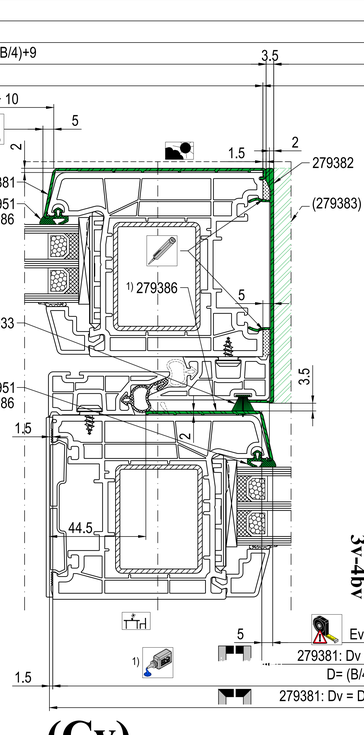
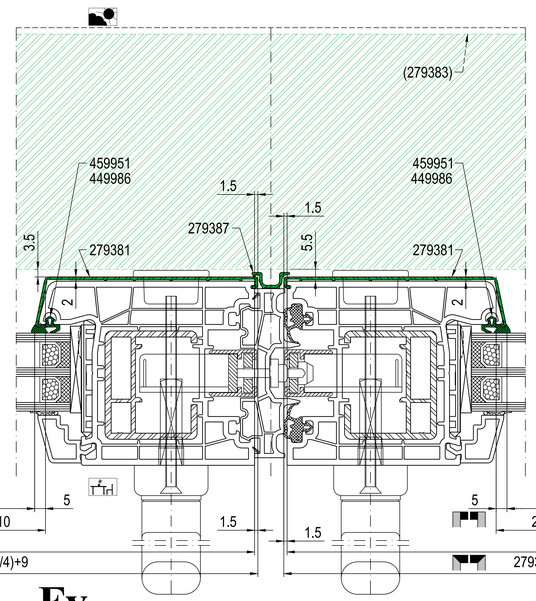


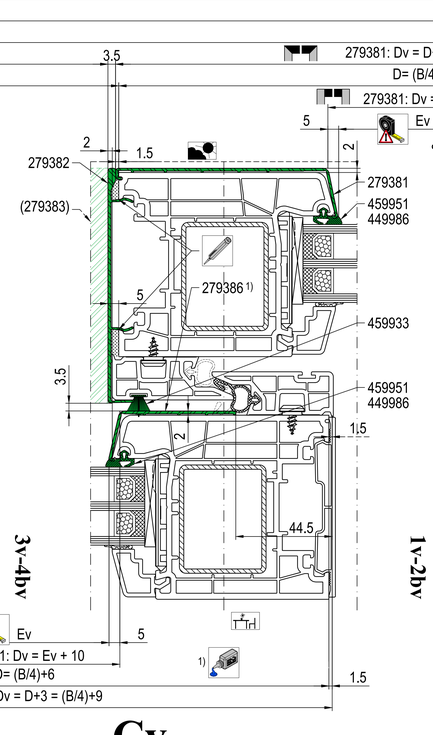
(Bv) Section Bv mirror-inverted



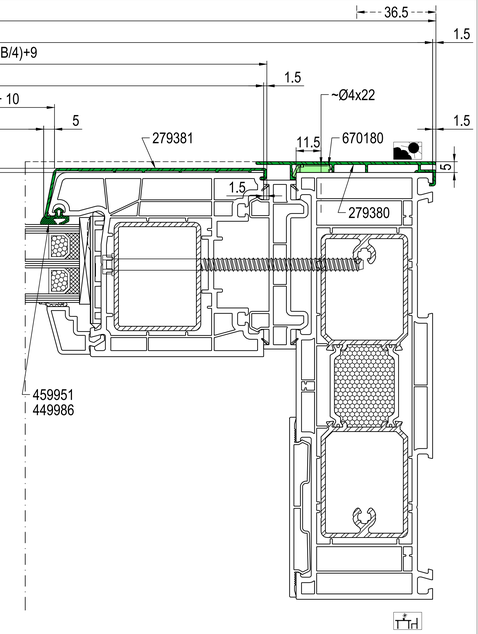
(Cv) Section Cv mirror-inverted



Fv Meeting rail-Sliding sash-Inside with aluminium shell

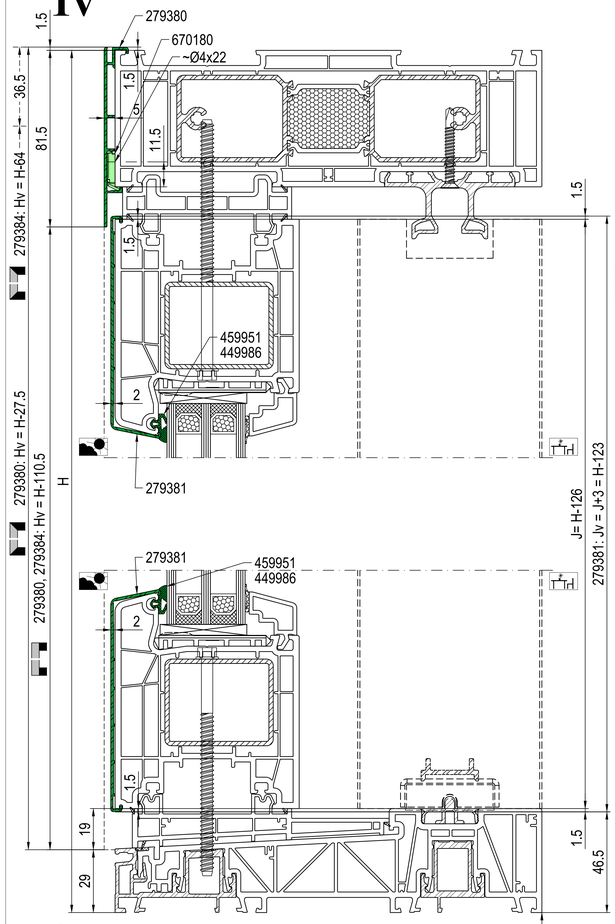


Cv Interlock with aluminium shell



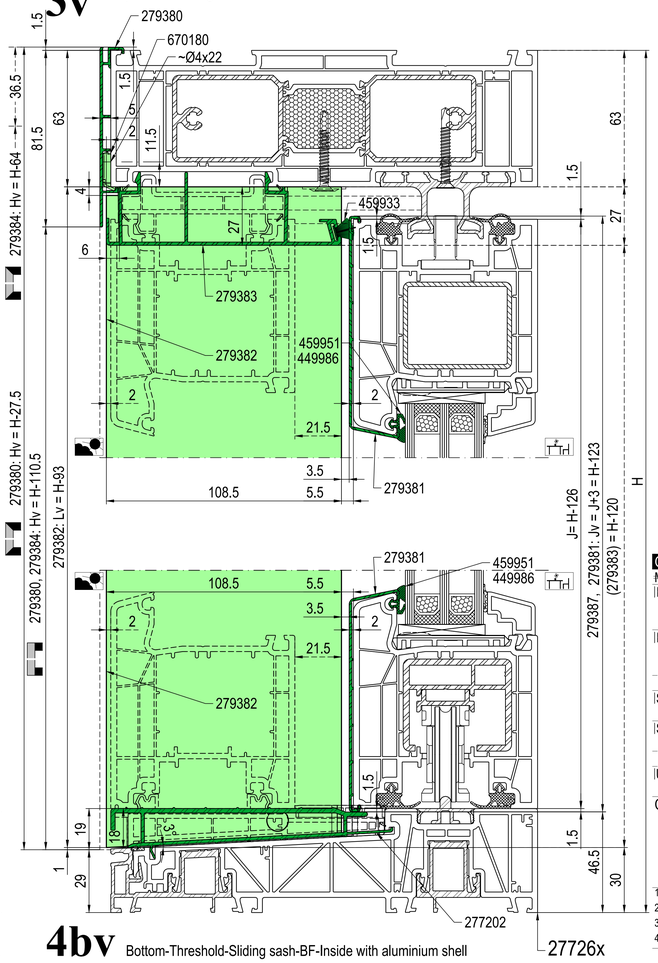
Bv Frame-Fixed sash-Outside with aluminium shell

1v Top-Frame-Fixed sash-Outside with aluminium shell



2bv Bottom-Threshold-Fixed sash-BF-Outside with aluminium shell

3v Top-Frame-Sliding sash-Inside with aluminium shell



4bv Bottom-Threshold-Sliding sash-BF-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section 3a			Section 3
	Section Aa			Section A

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions — Widths

	Schema A	Schema C		
	Schema D	Schema F	⚠ uPVC	
A=	B-156	(B/2)-85	2 sashes	
B=	B	B	Element	
C=	(B/2)-199.5	(B/4)-164	Glass	
D=	(B/2)-29.5	(B/4)+6	Sash [1]	
E=	(B/2)-229.5	(B/4)-194	Sash clearance	
F=	(B/2)-111.5	(B/4)-76	Overall clearance	
G=	-	(B/2)-168	Overall clearance outside	
Bz=	B-8	B-8	Threshold, frame	
Ca=	-	-	Glass, deviant	
Da=	-	-	Sash, deviant	
Ea=	-	-	Sash clearance, deviant	

Vertical deduction dimensions — Heights

			⚠ uPVC	
	h= 48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296		✓	Glass
J=	H-126		✓	Sash [1]
K=	H-326		✓	Sash clearance
L=	-		✓	Exterior frame
M=	-		✓	Interior frame
Hz=	H-111	✓ ...		Frame

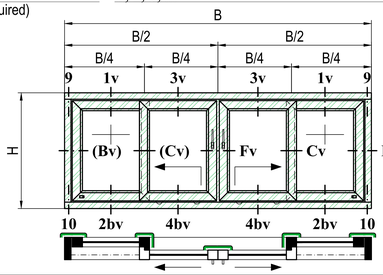
...v **aluskin** Aluminium shells

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions — 04 Schema C "v" — BF

Partition	1/4 : 1/4 : 1/4 : 1/4	
Sash	4	
Sliding sash	2	BF barrier-free
Fixed sash	2	
Aluminium shells	aluskin	
Lift-and-slide door 85mm		

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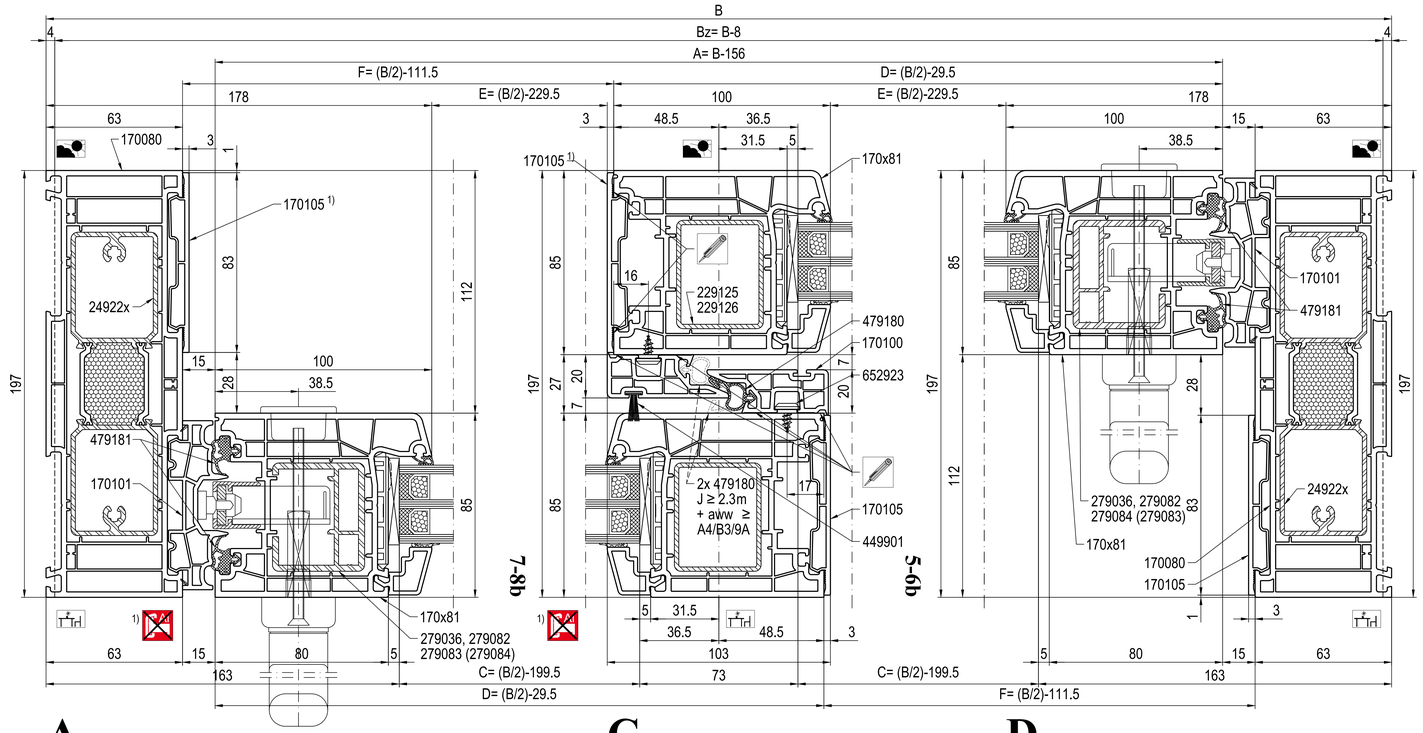
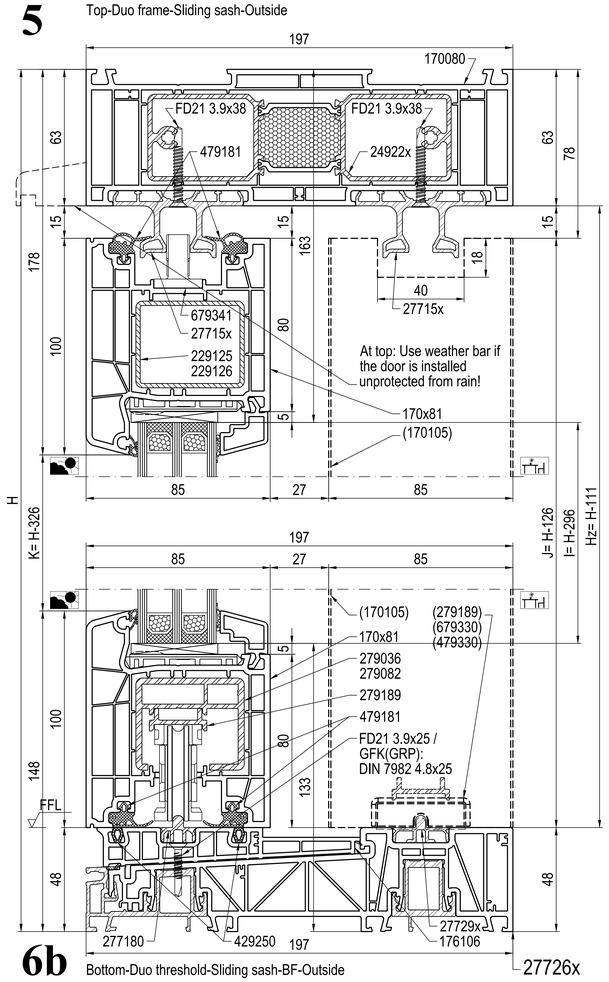
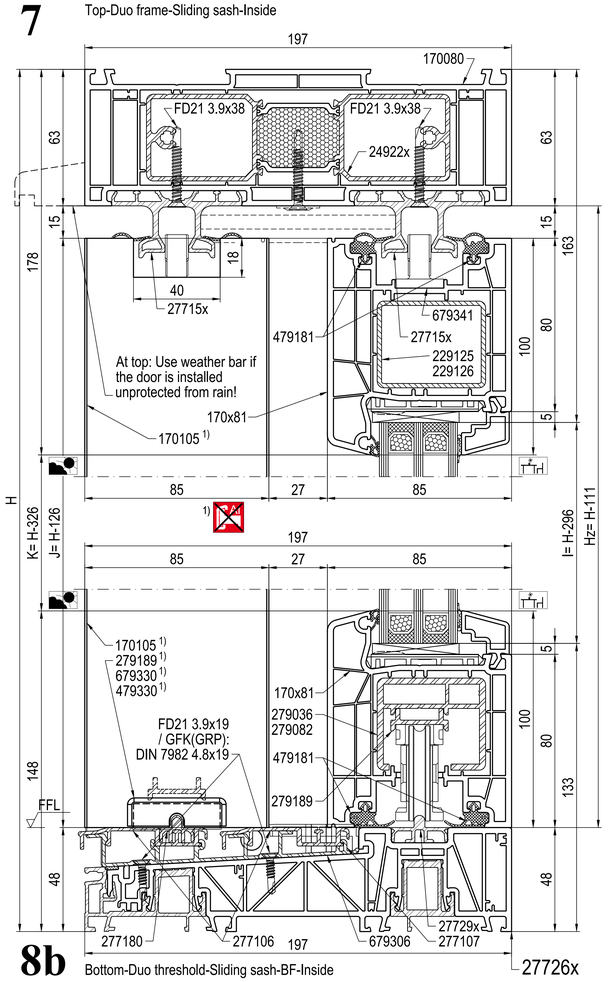


5 Top-Duo frame-Sliding sash-Outside



6b Bottom-Duo threshold-Sliding sash-BF-Outside

7 Top-Duo frame-Sliding sash-Inside



8b Bottom-Duo threshold-Sliding sash-BF-Inside

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
F Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
S Guide rail	27715x			
S Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
U Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
Schema D	Schema F	⚠ uPVC
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash 1)
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

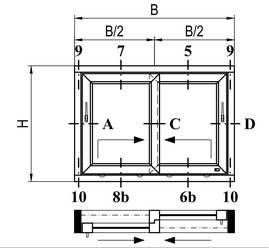
Vertical deduction dimensions		Heights
		⚠ uPVC
h= 48 mm	27 mm	Threshold U
H= H	H'+21	Element
I= H-296	✓	Glass
J= H-126	✓	Sash 1)
K= H-326	✓	Sash clearance
L= -	✓	Exterior frame
M= -	✓	Interior frame
Hz= H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ◂ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Frame-Frame
... see chapter 03 B



chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions — 05 — Schema D — BF

Partition 1/2 : 1/2
Sash 2
Sliding sash 2 BF barrier-free
Fixed sash -

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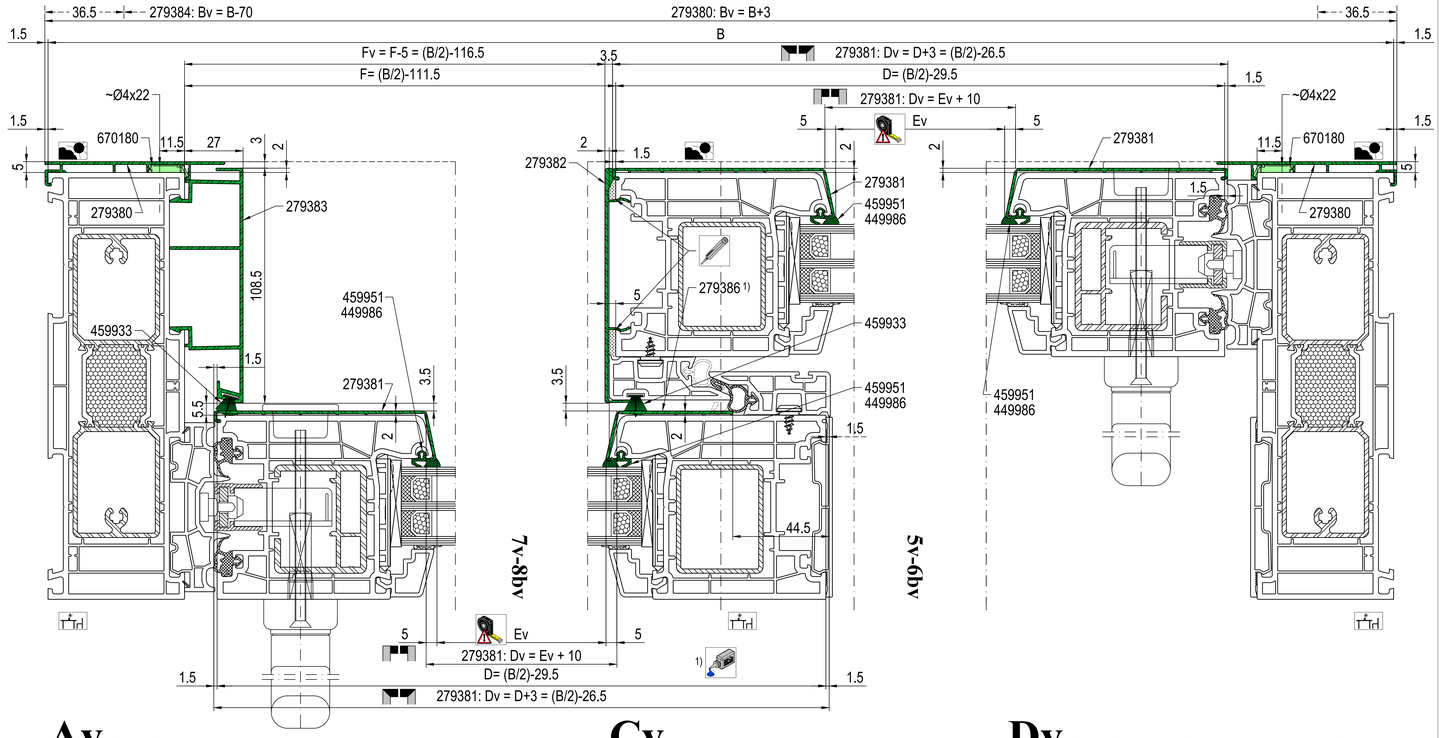
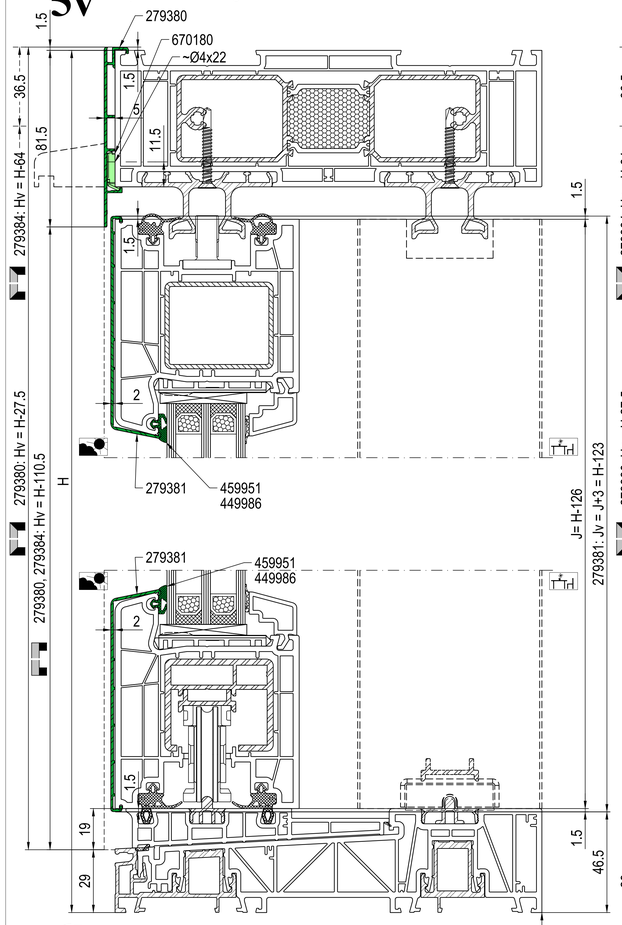


Av Frame-Sliding sash-Inside with aluminium shell

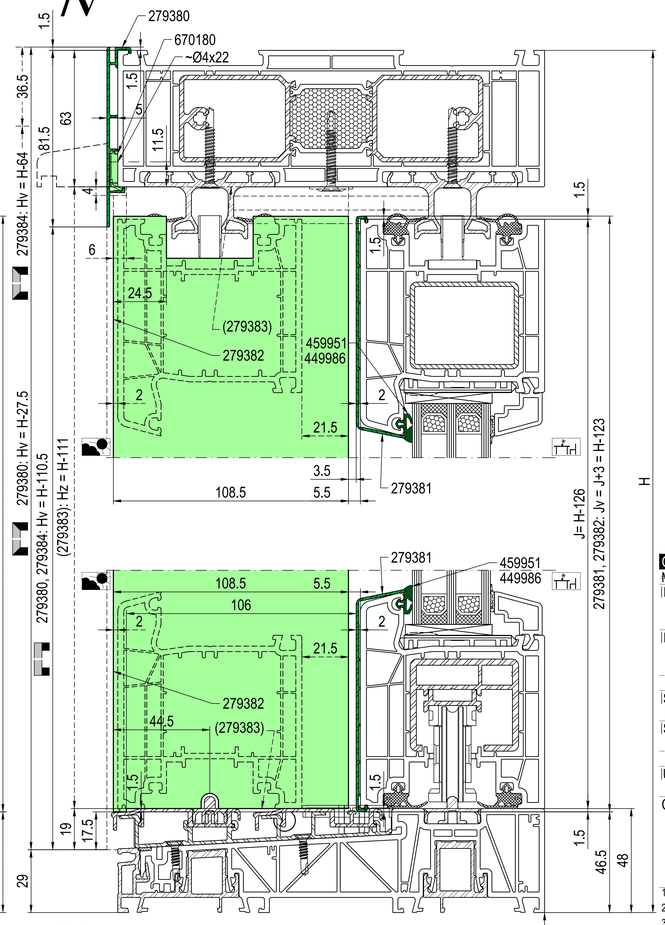
Cv Interlock with aluminium shell

Dv Frame-Sliding sash-Outside with aluminium shell

5v Top-Duo frame-Sliding sash-Outside with aluminium shell



7v Top-Duo frame-Sliding sash-Inside with aluminium shell



6bv Bottom-Duo threshold-Sliding sash-BF-Outside with aluminium shell

8bv Bottom-Duo threshold-Sliding sash-BF-Inside with aluminium shell

Options / Alternatives

Modules 6)	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 3) 229126 3)
|F| Reinforcement for sash 170x81				
	229125 229126	279082 4)	229114 1) 229115 1)	
	279036 4)	279082 4)		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x 2)		277180 2)	277180 2)
|U| Threshold	⬇		⬇	⬇
	27726x		27911x 5)	27716x
Cover profile for schema A/C				
	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols

- ... (black) Cut: mitre joint
- ... (black) Cut: butt joint
- Attention: measure the dimensions
- Sealing (silicone rubber)
- (suitable) Adhesive
- FFL Finished Floor Level
- Weather side / Outside
- Room side / Inside

Hardware

	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions — Widths

	Schema A Schema D	Schema C Schema F	uPVC	
A=	B-156	(B/2)-85		2 sashes
B=	B	B		Element
C=	(B/2)-199.5	(B/4)-164		Glass
D=	(B/2)-29.5	(B/4)+6		Sash 1)
E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

Vertical deduction dimensions — Heights

			uPVC	
h=	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296		✓	Glass
J=	H-126		✓	Sash 1)
K=	H-326		✓	Sash clearance
L=	-		✓	Exterior frame
M=	-		✓	Interior frame
Hz=	H-111		✓ ...	Frame

...v **aluskin** Aluminium shells

1) Weld shrinkage allowance to be added!

Horizontal sections

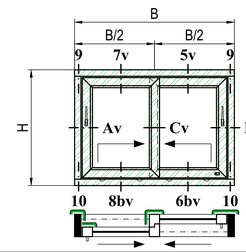
A, B, C, ...

▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections

1, 2, 3, ...



chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions — 06 Schema D "v" — BF

Partition 1/2 : 1/2
Sash 2
Sliding sash 2 BF barrier-free
Fixed sash -
Aluminium shells **aluskin**
Lift-and-slide door 85mm

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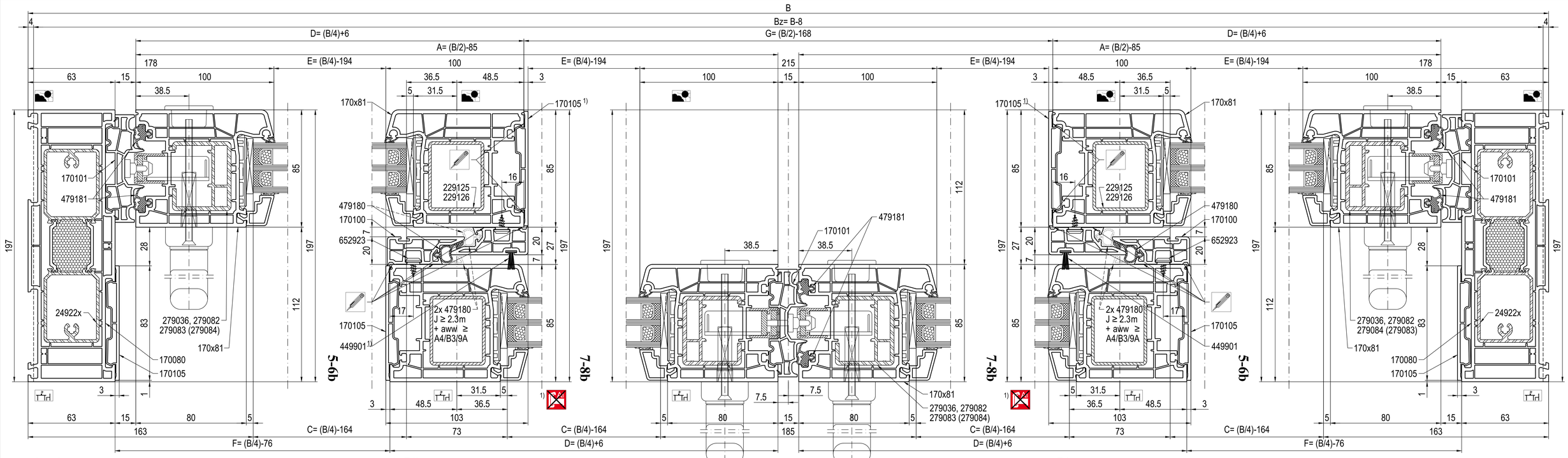


(D) Section D mirror-inverted

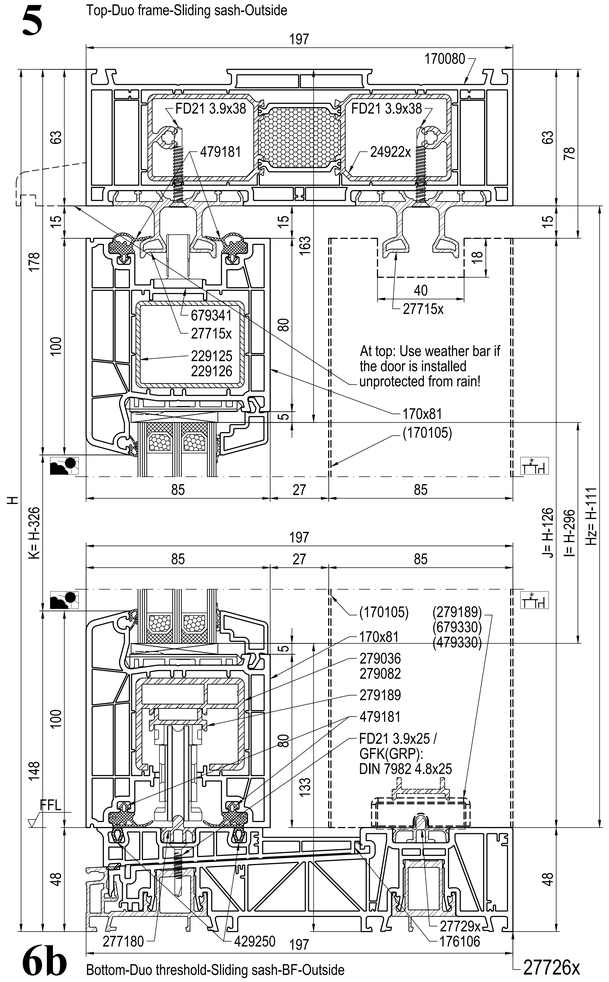
(C) Section C mirror-inverted

F Meeting rail-Sliding sash-Inside

C Interlock

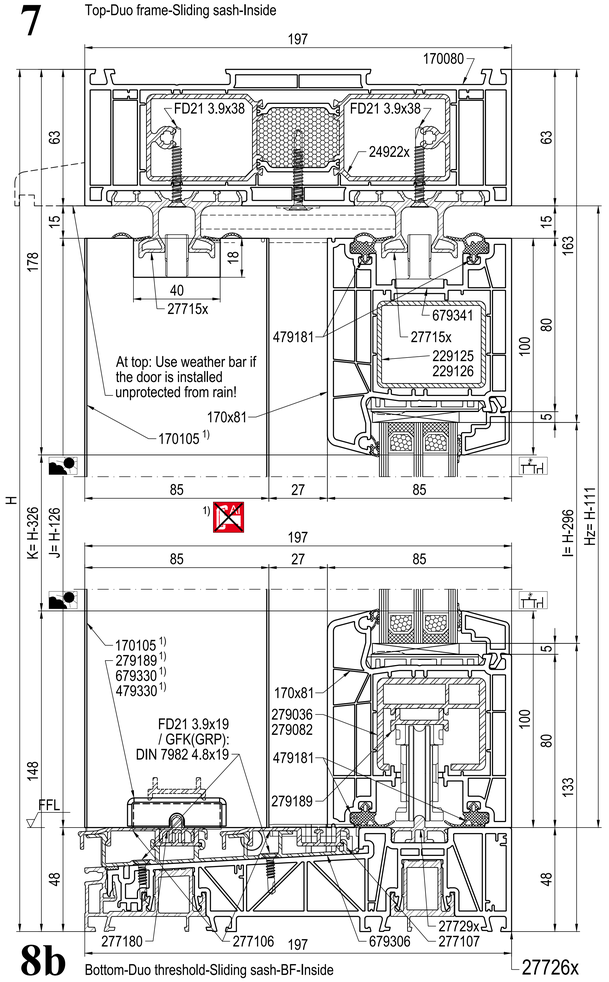
D Frame-Sliding sash-Outside

5 Top-Duo frame-Sliding sash-Outside



6b Bottom-Duo threshold-Sliding sash-BF-Outside

7 Top-Duo frame-Sliding sash-Inside



8b Bottom-Duo threshold-Sliding sash-BF-Inside

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
F Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
S Guide rail	27715x			
S Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
U Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
Schema D	Schema F	⚠ uPVC
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash 1)
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

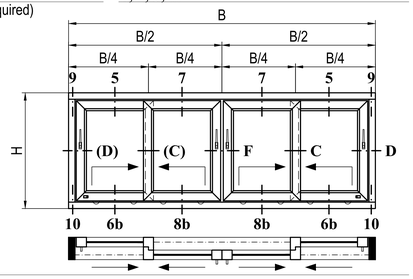
Vertical deduction dimensions			Heights
		⚠ uPVC	
h= 48 mm	27 mm	Threshold U	
H= H	H'+21	Element	
I= H-296	✓	Glass	
J= H-126	✓	Sash 1)	
K= H-326	✓	Sash clearance	
L= -	✓	Exterior frame	
M= -	✓	Interior frame	
Hz= H-111	✓ ...	Frame	

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ◂ Stopper left / right (where required)

9 Top-Frame-Pivot
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions — 07 — Schema F — BF

Partition	1/4 : 1/4 : 1/4 : 1/4
Sash	4
Sliding sash	4 BF barrier-free
Fixed sash	-

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www.aluplast.net — Lift-and-slide door 85mm

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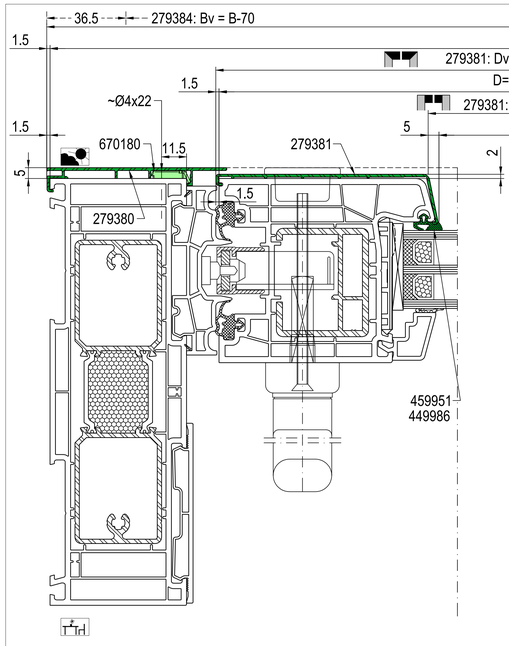
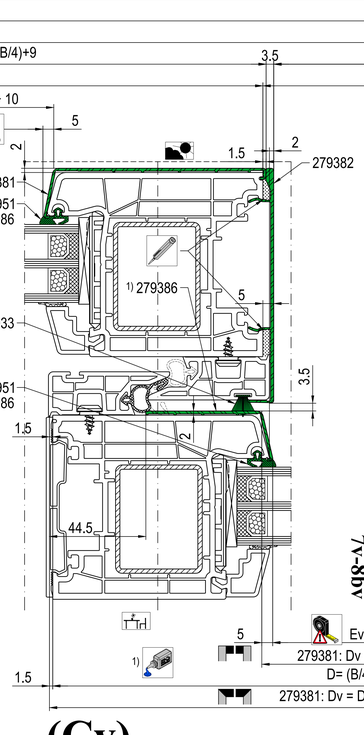
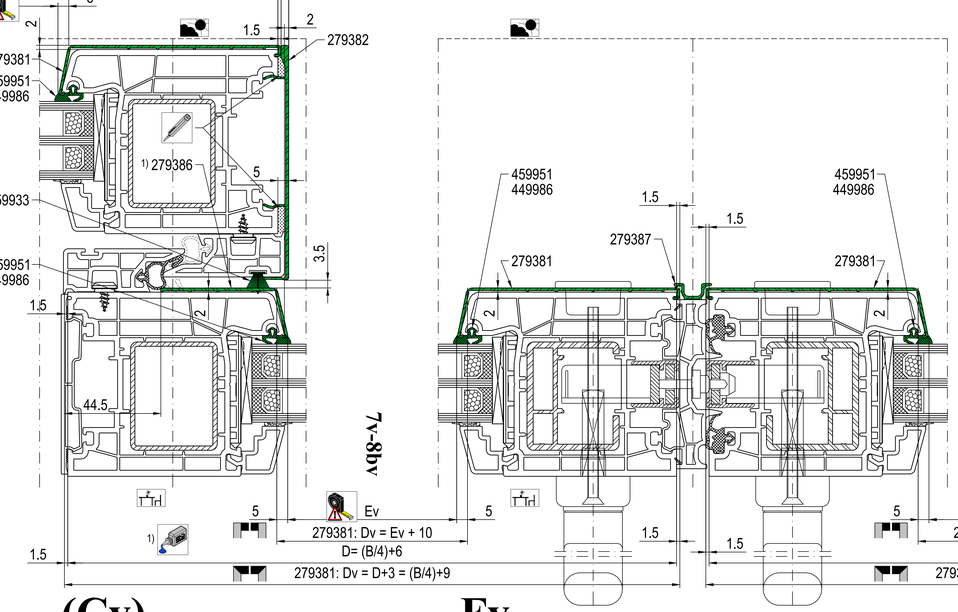


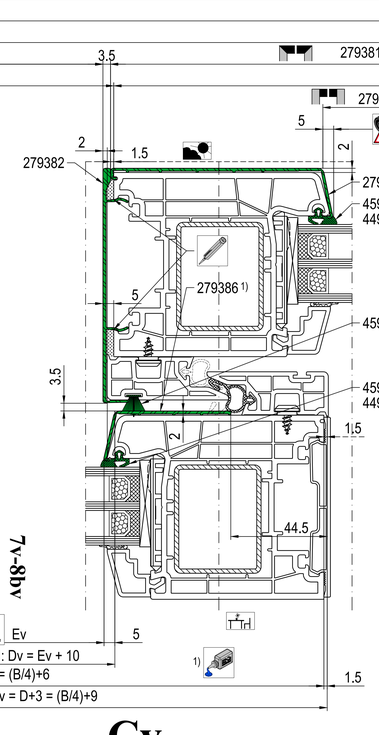
(Dv) Section Dv mirror-inverted



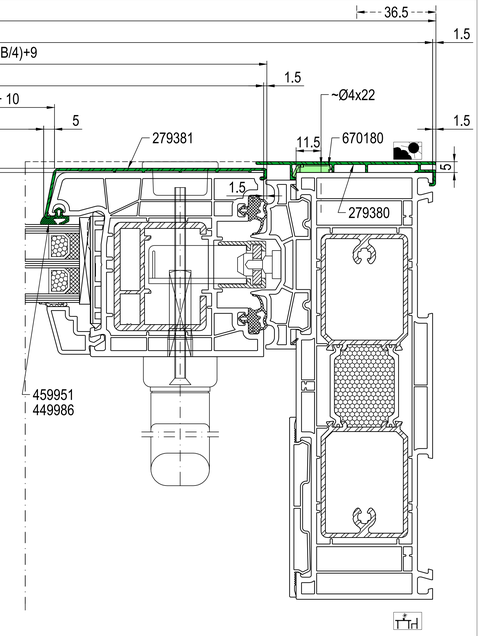
(Cv) Section Cv mirror-inverted



Fv Meeting rail-Sliding sash-Inside with aluminium shell

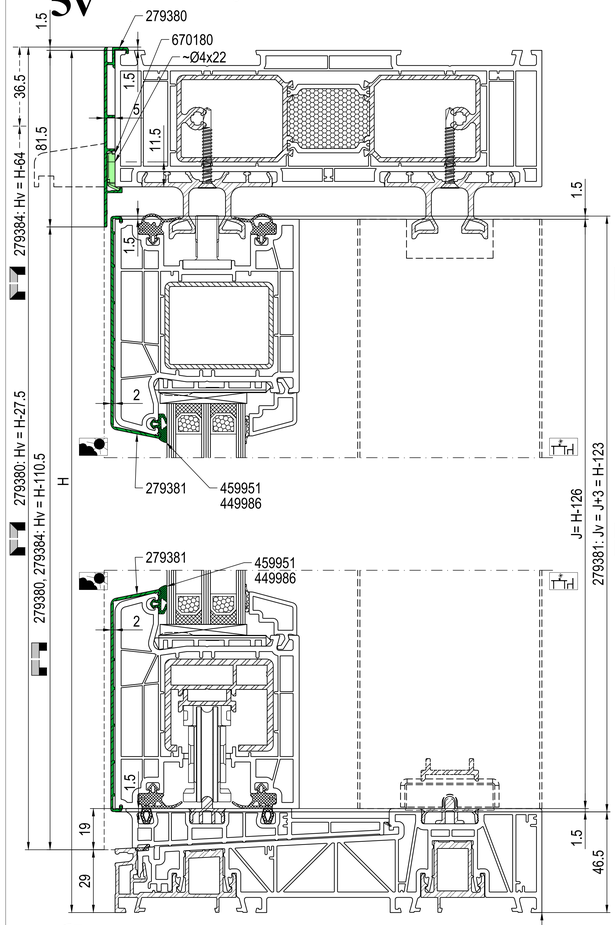


Cv Interlock with aluminium shell

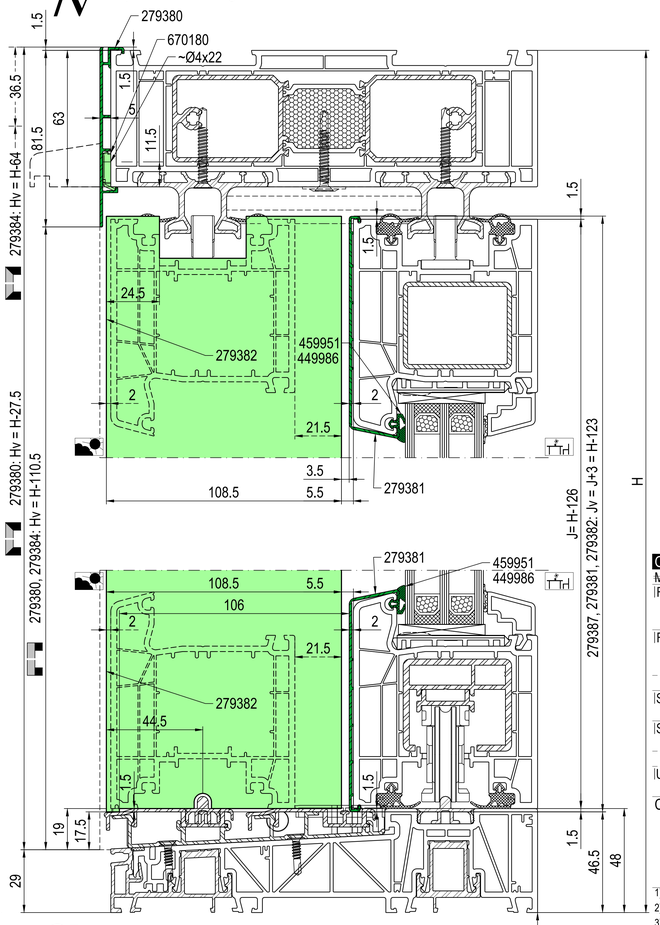


Dv Frame-Sliding sash-Outside with aluminium shell

5v Top-Duo frame-Sliding sash-Outside with aluminium shell



7v Top-Duo frame-Sliding sash-Inside with aluminium shell



6bv Bottom-Duo threshold-Sliding sash-BF-Outside with aluminium shell

8bv Bottom-Duo threshold-Sliding sash-BF-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols

- ... (black) — Cut: mitre joint
- ... (black) — Cut: butt joint
- Attention: measure the dimensions
- Sealing (silicone rubber)
- (suitable) Adhesive
- FFL — Finished Floor Level
- Weather side / Outside
- Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions — Widths

	Schema A / Schema D	Schema C / Schema F	uPVC	
A=	B-156	(B/2)-85		2 sashes
B=	B	B		Element
C=	(B/2)-199.5	(B/4)-164		Glass
D=	(B/2)-29.5	(B/4)+6		Sash 1)
E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

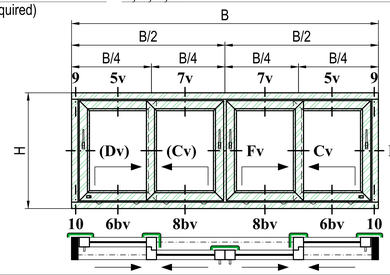
Vertical deduction dimensions — Heights

			uPVC	
h=	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296		✓	Glass
J=	H-126		✓	Sash 1)
K=	H-326		✓	Sash clearance
L=	-		✓	Exterior frame
M=	-		✓	Interior frame
Hz=	H-111	✓ ...		Frame

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



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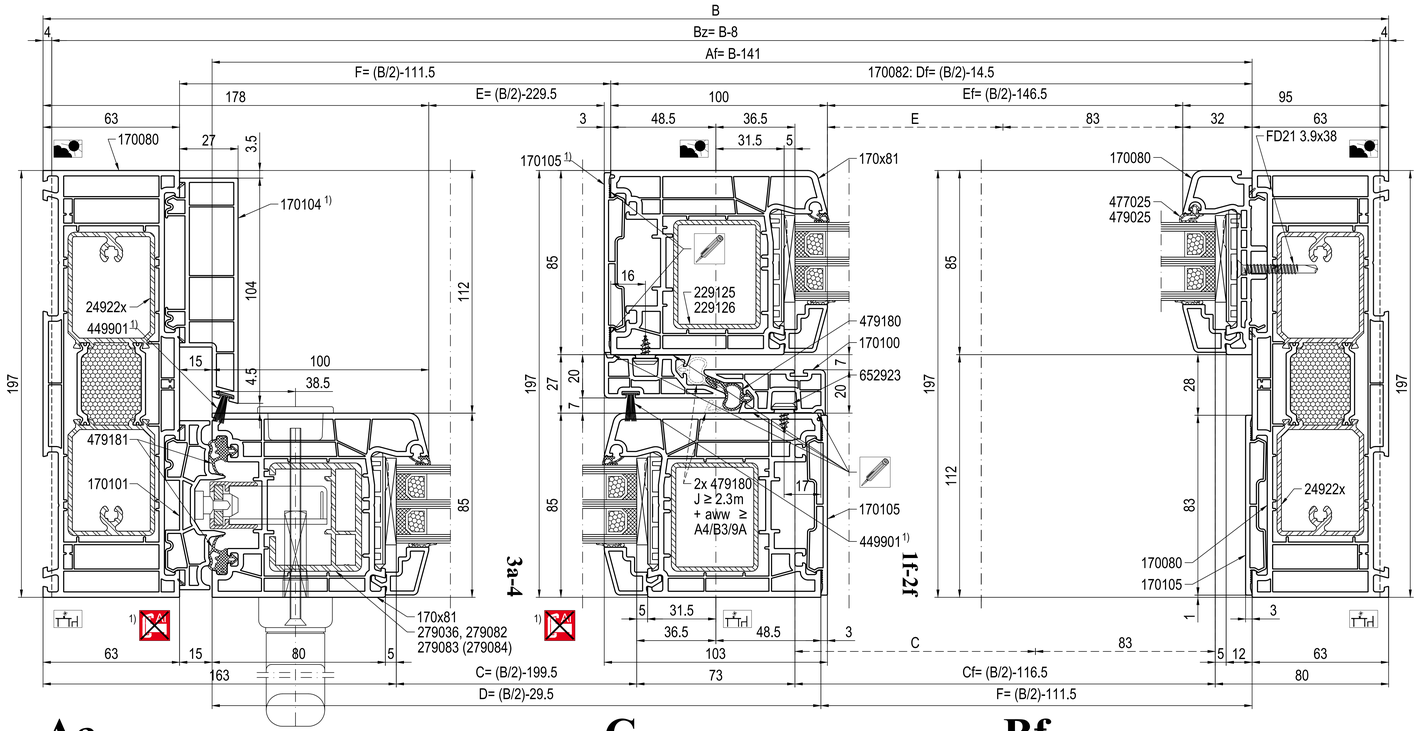
chapter 01 General Information — page — barrier-free

01 S Deduction Dimensions 08 Schema F "v" BF

Partition	1/4 : 1/4 : 1/4 : 1/4	
Sash	4	
Sliding sash	4	BF barrier-free
Fixed sash	-	
Aluminium shells aluskin		
Lift-and-slide door 85mm		

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten
DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *01_S_08_HST85* Issued: 2020-11a Language: en (English) / Englisch

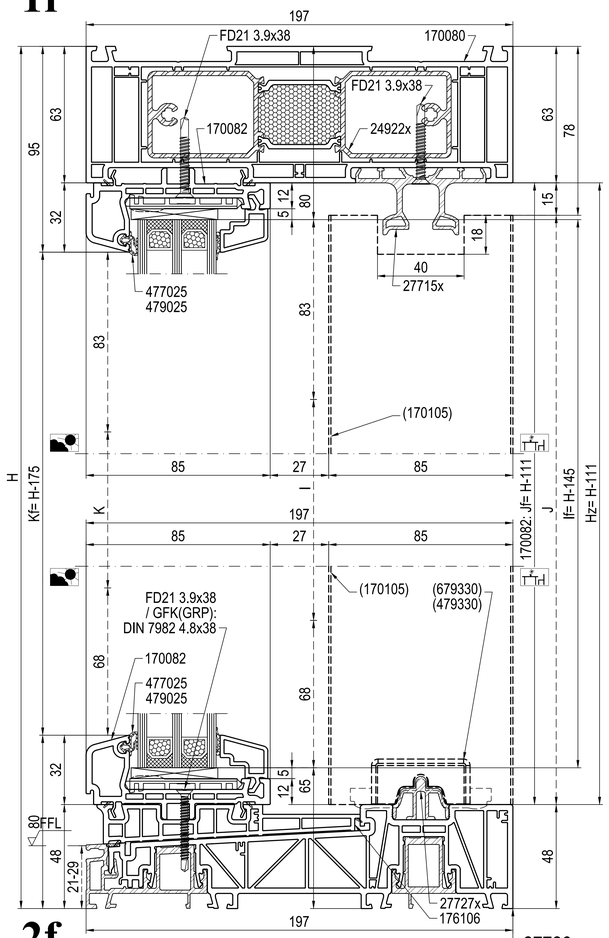


Aa Frame-Sliding sash-Inside with cover profile

C Interlock

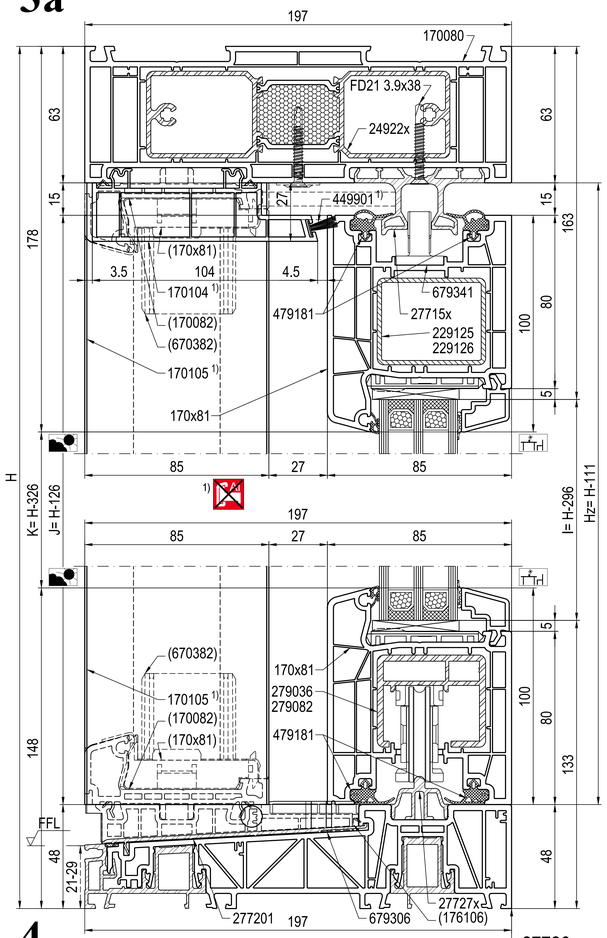
Bf Frame-Fixed sash-FF-Outside

1f Top-Frame-Fixed sash-FF-Outside



2f Bottom-Threshold-Fixed sash-FF-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4 Bottom-Threshold-Sliding sash-Inside

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
F Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
S Guide rail	27715x			
S Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
U Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A	Schema C	Widths
	...f fixframe	fixframe	⚠ uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash [1]
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash [1]
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

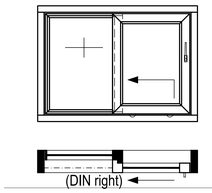
Vertical deduction dimensions					Heights
		...f	fixframe	⚠ uPVC	
h=	48 mm	27 mm			Threshold U
H=	H	H'+21	H=	H	Element
I=	H-296	✓	If=	H-145	Glass
J=	H-126	✓	Jf=	H-111	Sash [1]
K=	H-326	✓	Kf=	H-175	Sash clearance
L=	-	✓	-		Exterior frame
M=	-	✓	-		Interior frame
Hz=	H-111	✓ ...	Hz=	H-111	Frame

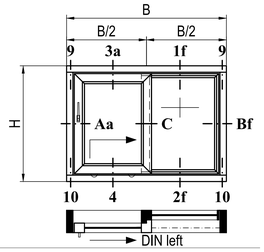
1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B





chapter 01 General Information

01 T Deduction Dimensions

page 01 Schema A FF

	Partition	1/2 : 1/2	
	Sash	2	
	Sliding sash	1	
(small)	Fixed sash	1	FF fixframe

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Lift-and-slide door 85mm

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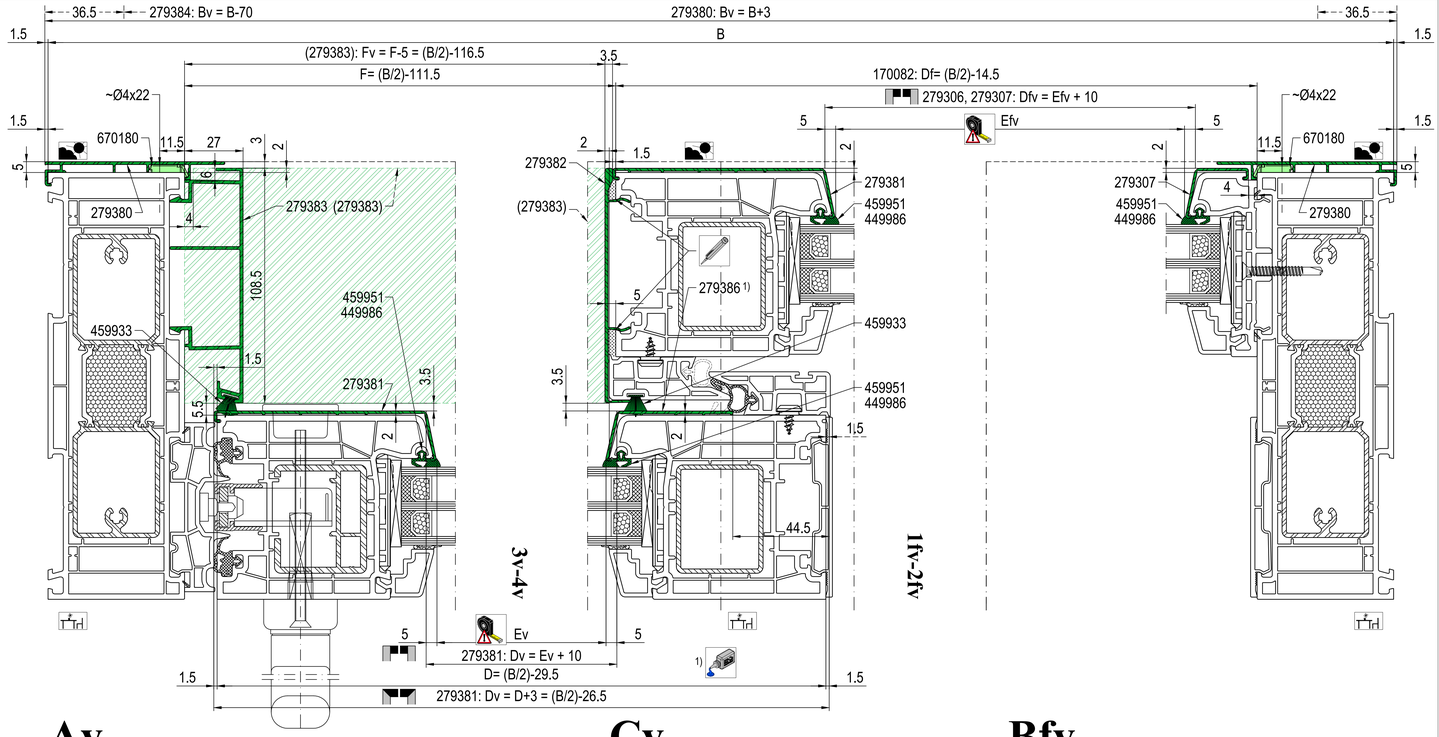
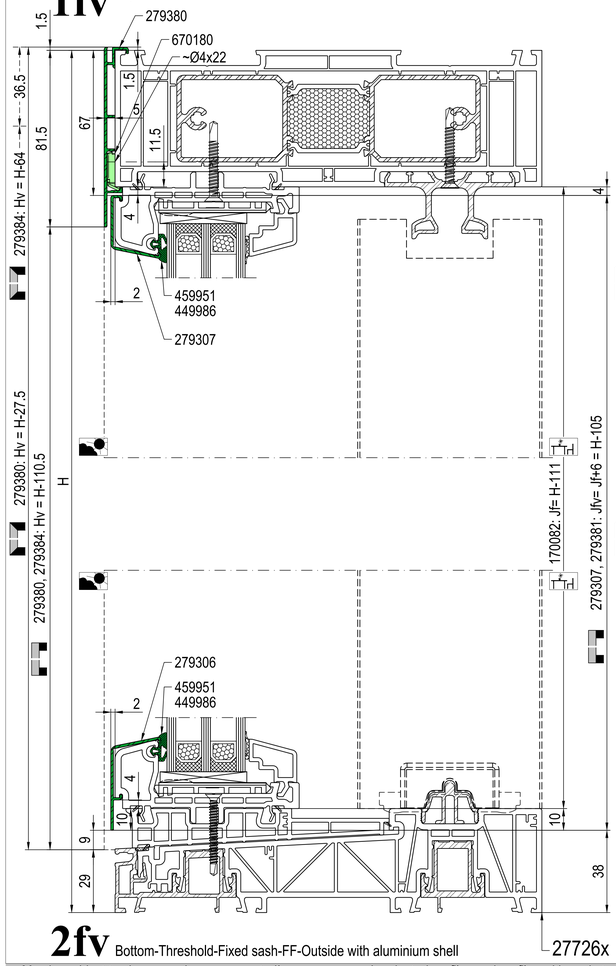


Av Frame-Sliding sash-Inside with aluminium shell

Cv Interlock with aluminium shell

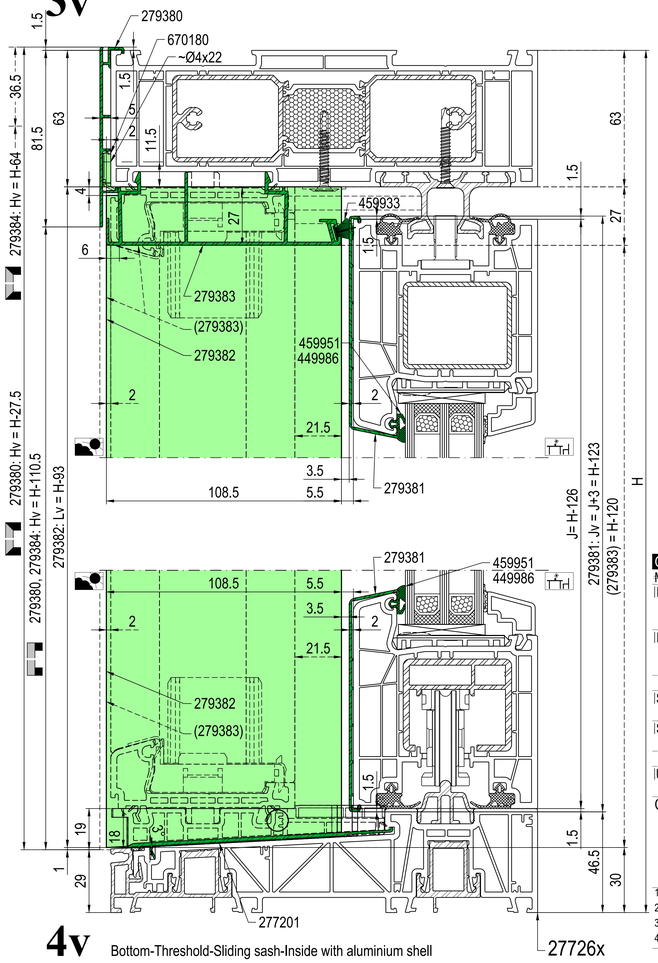
Bfv Frame-Fixed sash-FF-Outside with aluminium shell

1fv Top-Frame-Fixed sash-FF-Outside with aluminium shell



2fv Bottom-Threshold-Fixed sash-FF-Outside with aluminium shell

3v Top-Frame-Sliding sash-Inside with aluminium shell



4v Bottom-Threshold-Sliding sash-Inside with aluminium shell

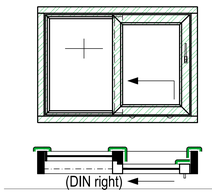
Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Horizontal deduction dimensions			Widths
	Schema A	Schema C	
...f	fixframe	fixframe	uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash 1)
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



Symbols

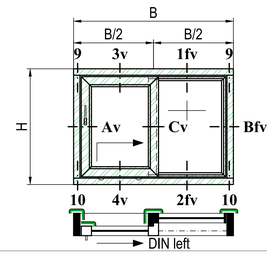
... (black) Cut: mitre joint
... (black) Cut: butt joint
Attention: measure the dimensions
Sealing (silicone rubber)
(suitable) Adhesive
FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Vertical deduction dimensions					Heights
			...f	fixframe	uPVC
h=	48 mm	27 mm			Threshold |U|
H=	H	H'+21	H=	H	Element
I=	H-296	✓	If=	H-145	Glass
J=	H-126	✓	Jf=	H-111	Sash 1)
K=	H-326	✓	Kf=	H-175	Sash clearance
L=	-	✓	-		Exterior frame
M=	-	✓	-		Interior frame
Hz=	H-111	✓ ...	Hz=	H-111	Frame

...v **aluskin** Aluminium shells
1) Weld shrinkage allowance to be added!

Vertical sections
1, 2, 3, ...



chapter 01 General Information
page

01 T Deduction Dimensions

02 Schema A "v" FF

Partition 1/2 : 1/2
Sash 2
Sliding sash 1
(small) Fixed sash 1 FF fixframe
Aluminium shells **aluskin**

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Lift-and-slide door 85mm

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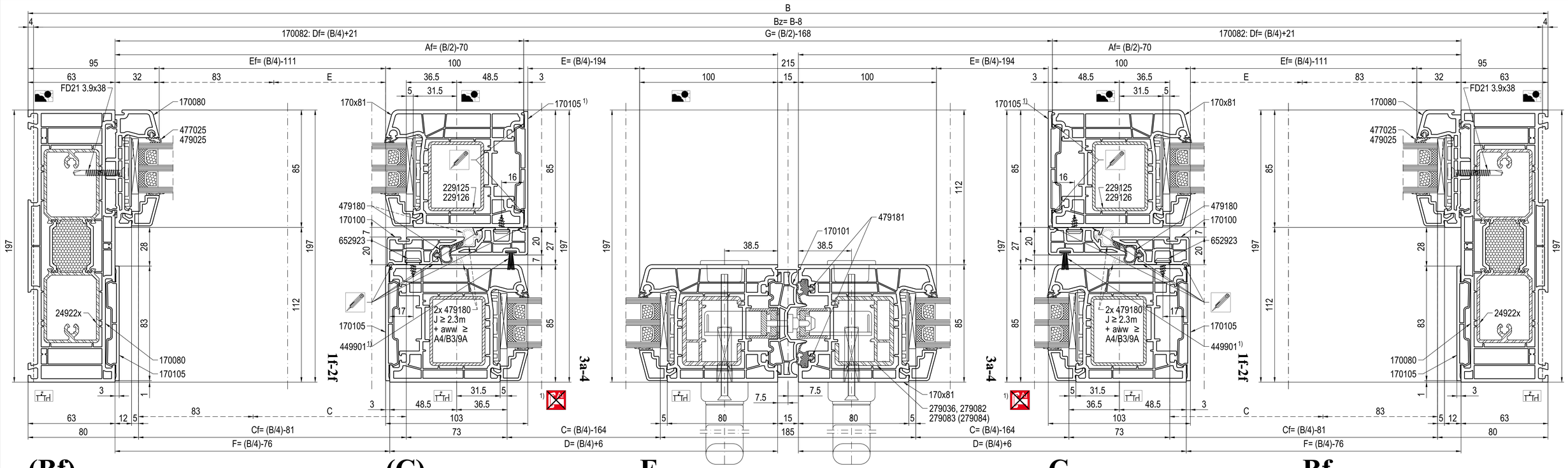


(Bf) Section B mirror-inverted

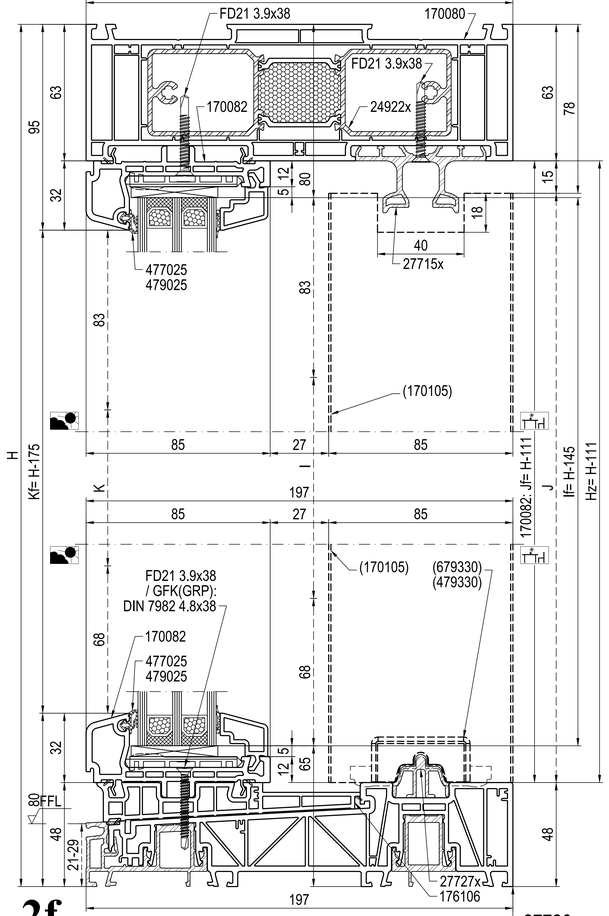
(C) Section C mirror-inverted

F Meeting rail-Sliding sash-Inside

C Interlock

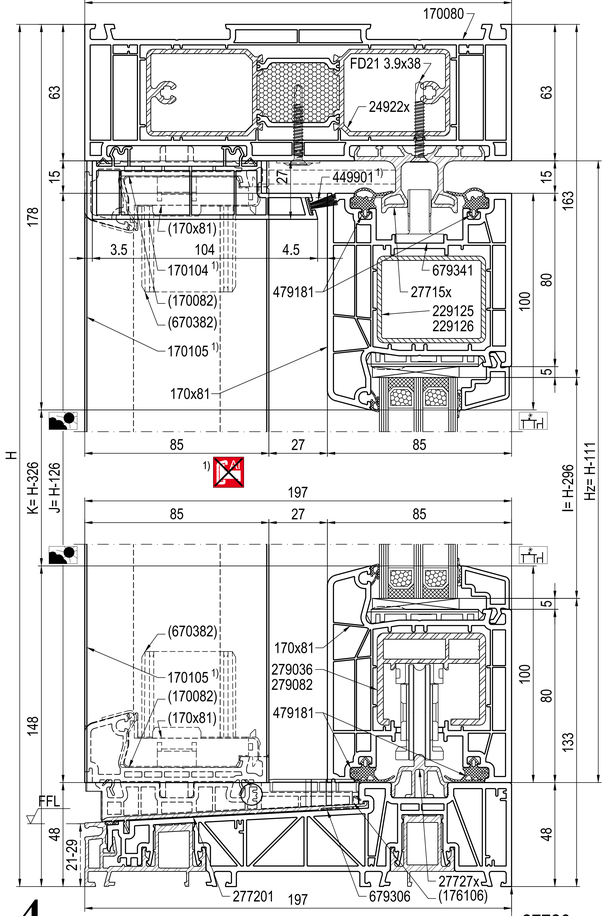
Bf Frame-Fixed sash-FF-Outside

1f Top-Frame-Fixed sash-FF-Outside



2f Bottom-Threshold-Fixed sash-FF-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4 Bottom-Threshold-Sliding sash-Inside

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
|F| Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail	27715x			
|S| Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A	Schema C	Widths
	...f fixframe	fixframe	⚠ uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash [1]
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash [1]
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

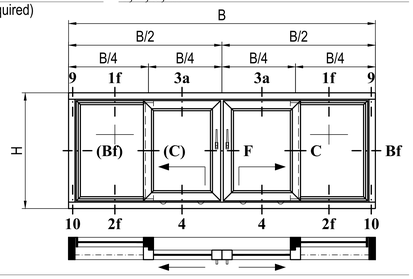
Vertical deduction dimensions					Heights
		...f	fixframe	⚠ uPVC	
h=	48 mm	27 mm			Threshold |U|
H=	H	H+21	H=	H	Element
I=	H-296	✓	If=	H-145	Glass
J=	H-126	✓	Jf=	H-111	Sash [1]
K=	H-326	✓	Kf=	H-175	Sash clearance
L=	-	✓	-		Exterior frame
M=	-	✓	-		Interior frame
Hz=	H-111	✓ ...	Hz=	H-111	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▫ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information
page

01 T Deduction Dimensions 03 Schema C FF

	Partition	1/4 : 1/4 : 1/4 : 1/4	
	Sash	4	
	Sliding sash	2	
(small)	Fixed sash	2	FF fixframe

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Lift-and-slide door 85mm

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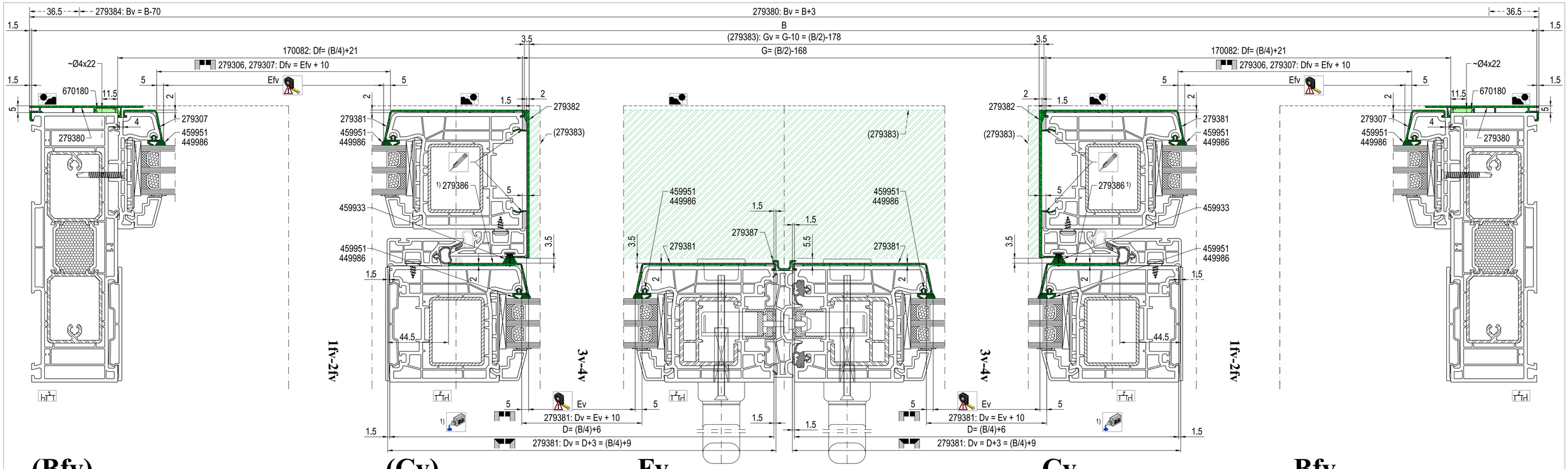


(Bfv) Section Bv mirror-inverted

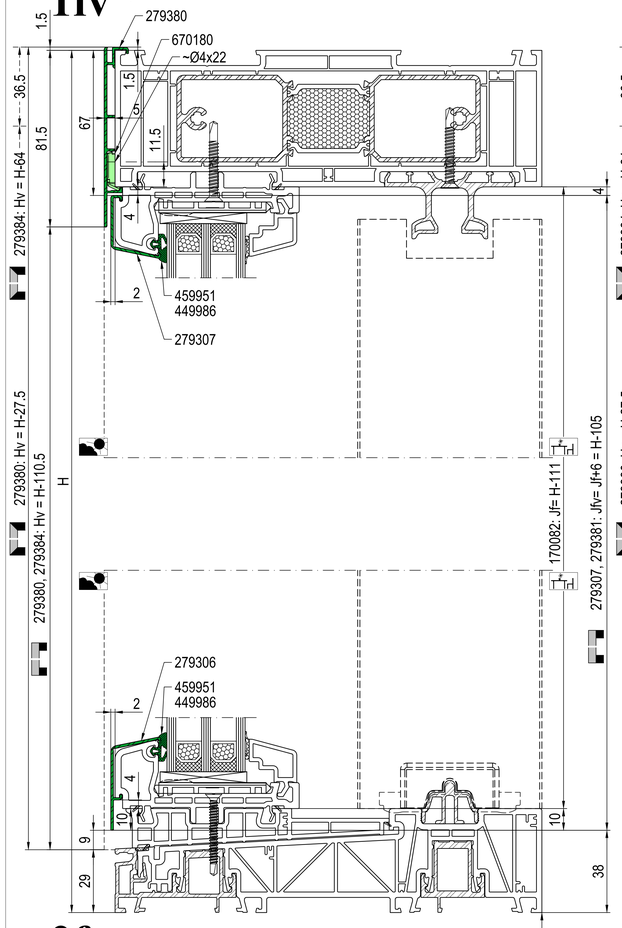
(Cv) Section Cv mirror-inverted

Fv Meeting rail-Sliding sash-Inside with aluminium shell

Cv Interlock with aluminium shell

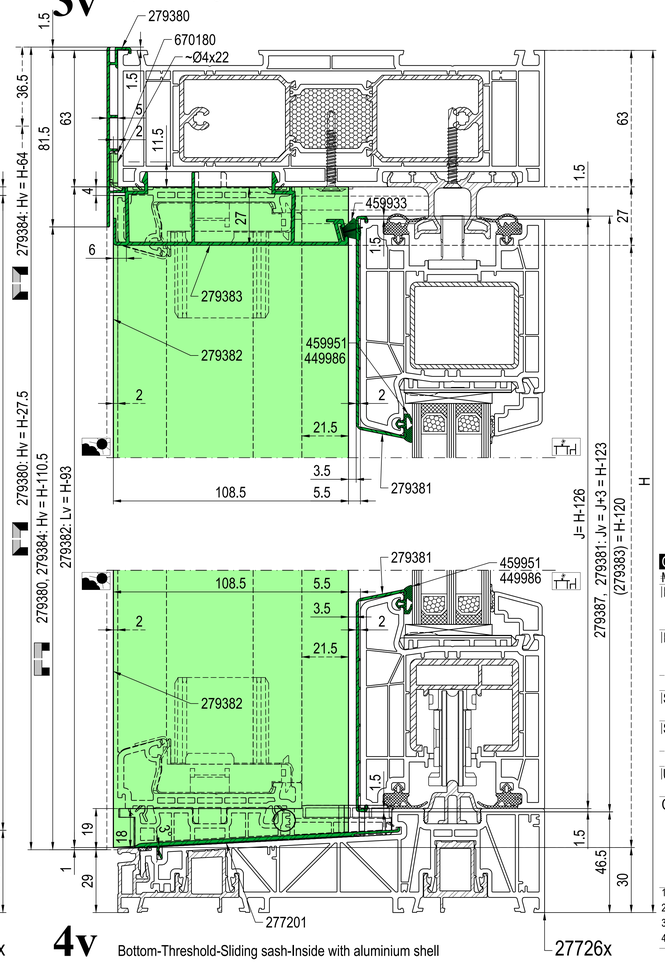
Bfv Frame-Fixed sash-FF-Outside with aluminium shell

1fv Top-Frame-Fixed sash-FF-Outside with aluminium shell



2fv Bottom-Threshold-Fixed sash-FF-Outside with aluminium shell

3v Top-Frame-Sliding sash-Inside with aluminium shell



4v Bottom-Threshold-Sliding sash-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
...f fixframe	fixframe	⚠uPVC
Af= B-141	(B/2)-70	2 sashes
Cf= (B/2)-116.5	(B/4)-81	Glass
Df= (B/2)-14.5	(B/4)+21	Sash [1]
Ef= (B/2)-146.5	(B/4)-111	Sash clearance
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash [1]
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

Vertical deduction dimensions					Heights
			...f	fixframe	⚠uPVC
					Threshold |U|
h= 48 mm		27 mm			
H= H		H'+21	H=	H	Element
I= H-296	✓		If=	H-145	Glass
J= H-126	✓		Jf=	H-111	Sash [1]
K= H-326	✓		Kf=	H-175	Sash clearance
L= -	✓		-		Exterior frame
M= -	✓		-		Interior frame
Hz= H-111	✓	...	Hz=	H-111	Frame

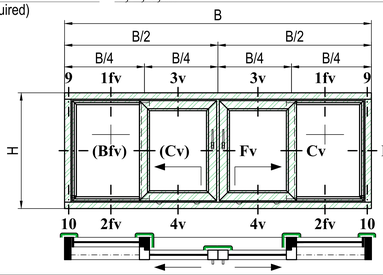
...v **aluskin** Aluminium shells

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information page

01 T Deduction Dimensions 04 Schema C "v" FF

Partition	1/4 : 1/4 : 1/4 : 1/4	
Sash	4	
Sliding sash	2	
(small) Fixed sash	2	FF fixframe
Aluminium shells **aluskin**		
Lift-and-slide door 85mm		

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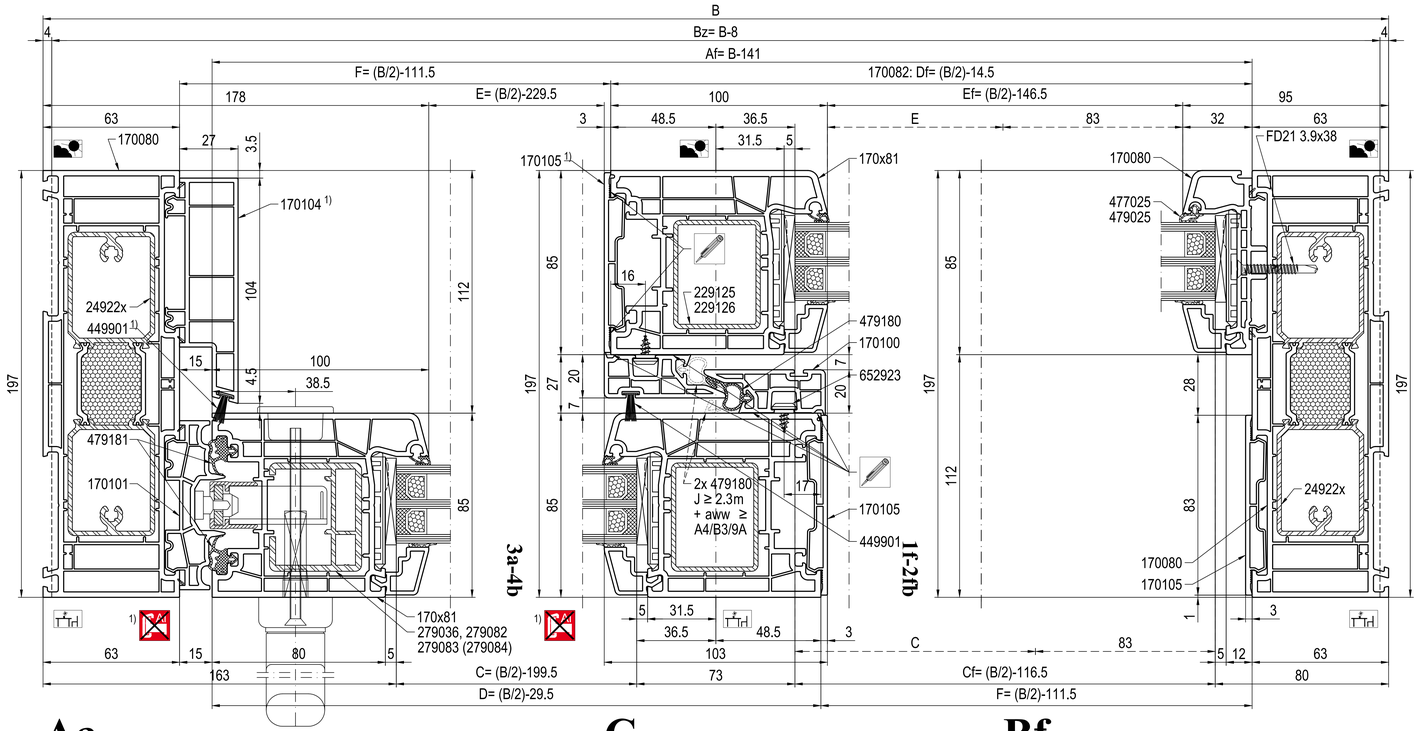
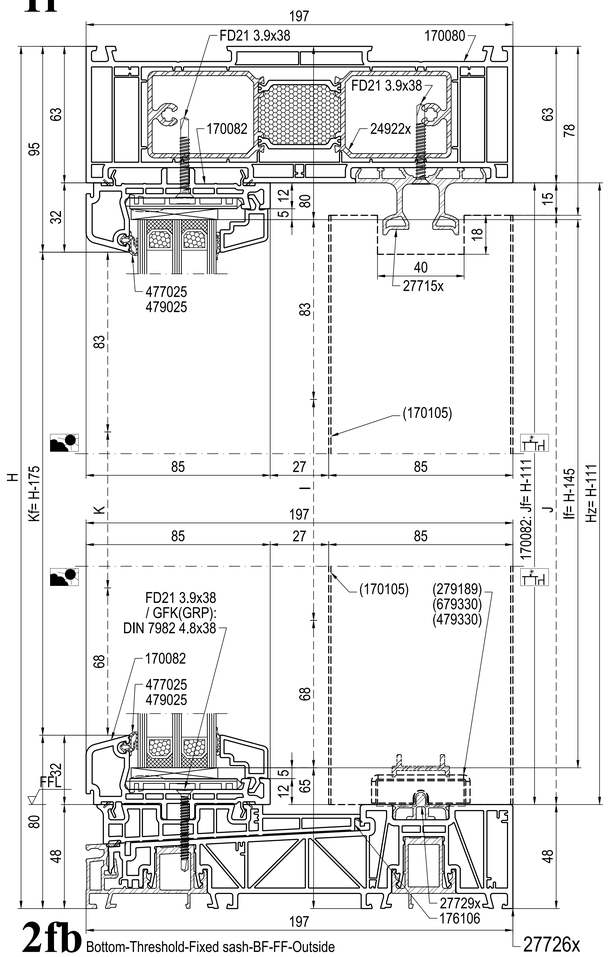


Aa Frame-Sliding sash-Inside with cover profile

C Interlock

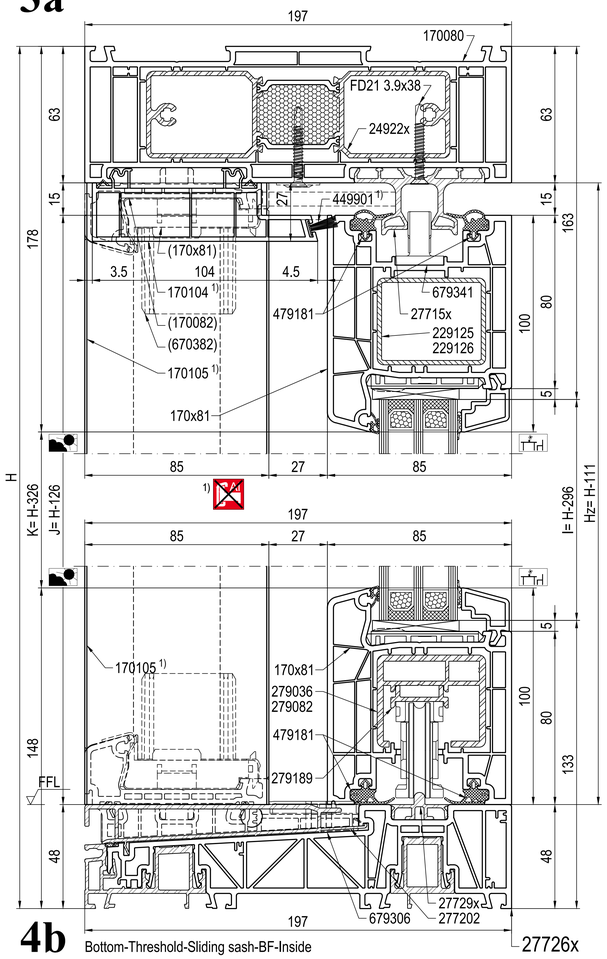
Bf Frame-Fixed sash-FF-Outside

1f Top-Frame-Fixed sash-FF-Outside



2fb Bottom-Threshold-Fixed sash-BF-FF-Outside

3a Top-Frame-Sliding sash-Inside with cover profile



4b Bottom-Threshold-Sliding sash-BF-Inside

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
F Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
S Guide rail	27715x			
S Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
U Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) |Z| 670290 required
2) BF: |S| 279189 required
3) Simple frame connection
4) Option = |F| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A	Schema C	Widths
	...f fixframe	fixframe	⚠ uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash [1]
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash [1]
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

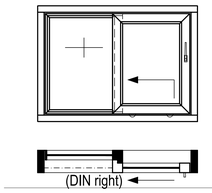
Vertical deduction dimensions	...f fixframe	⚠ uPVC	Heights
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	If= H-145 Glass
J=	H-126	✓	Jf= H-111 Sash [1]
K=	H-326	✓	Kf= H-175 Sash clearance
L=	-	✓	- Exterior frame
M=	-	✓	- Interior frame
Hz=	H-111	✓ ...	Hz= H-111 Frame

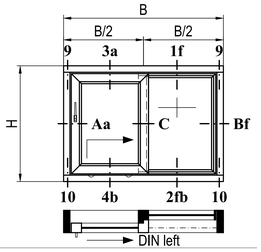
1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▫ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B





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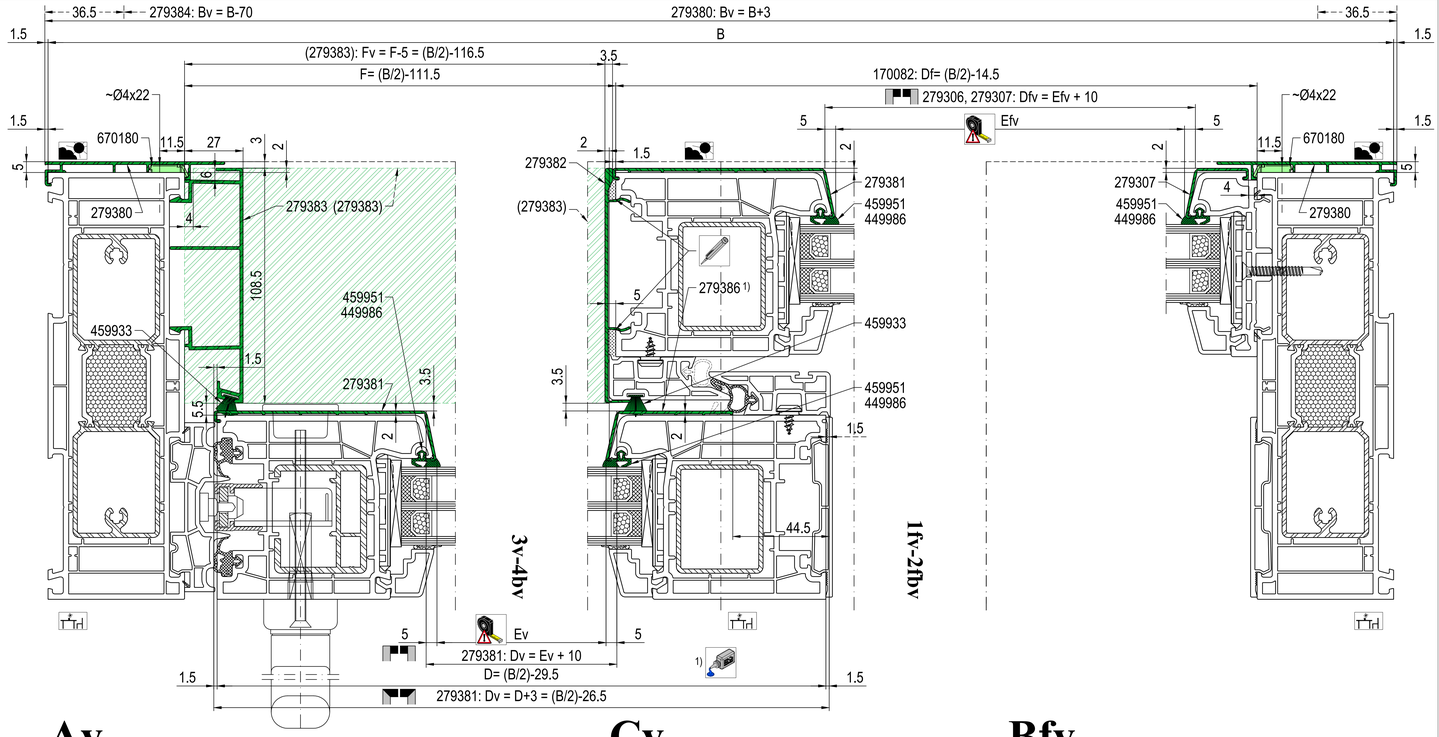
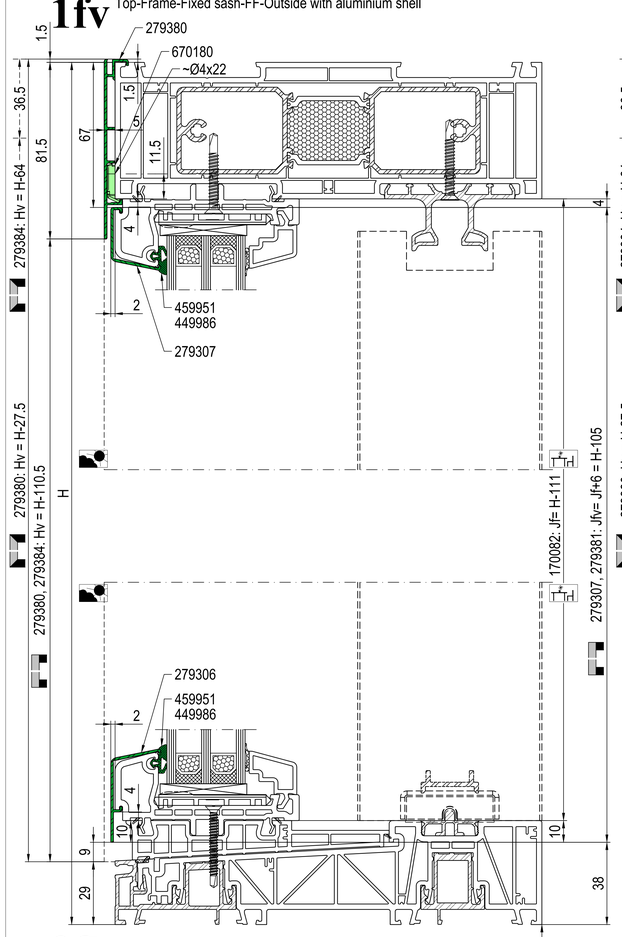


Av Frame-Sliding sash-Inside with aluminium shell

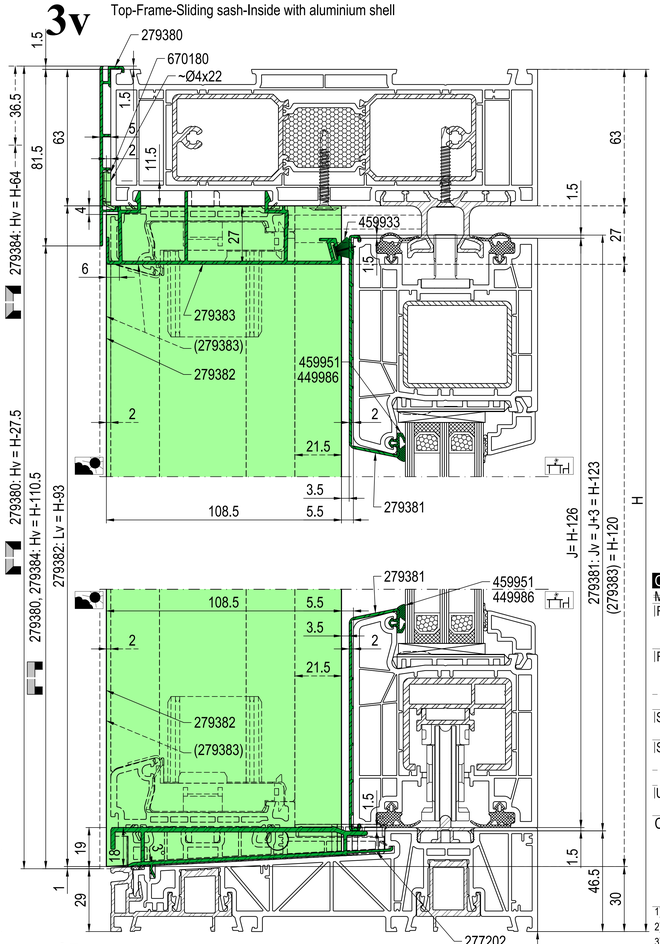
Cv Interlock with aluminium shell

Bfv Frame-Fixed sash-FF-Outside with aluminium shell

1fv Top-Frame-Fixed sash-FF-Outside with aluminium shell



3v Top-Frame-Sliding sash-Inside with aluminium shell



2fbv Bottom-Threshold-Fixed sash-BF-FF-Outside with aluminium shell

4bv Bottom-Threshold-Sliding sash-BF-Inside with aluminium shell

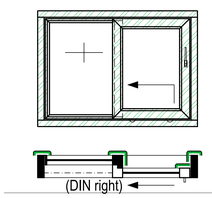
Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Horizontal deduction dimensions			Widths
	Schema A	Schema C	
...f	fixframe	fixframe	⚠uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash 1)
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



Symbols

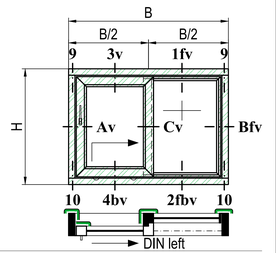
... (black) Cut: mitre joint
... (black) Cut: butt joint
Attention: measure the dimensions
Sealing (silicone rubber)
(suitable) Adhesive
FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Vertical deduction dimensions					Heights
			...f	fixframe	⚠uPVC
h=	48 mm	27 mm			Threshold |U|
H=	H	H'+21	H=	H	Element
I=	H-296	✓	If=	H-145	Glass
J=	H-126	✓	Jf=	H-111	Sash 1)
K=	H-326	✓	Kf=	H-175	Sash clearance
L=	-	✓	-		Exterior frame
M=	-	✓	-		Interior frame
Hz=	H-111	✓ ...	Hz=	H-111	Frame

...v **aluskin** Aluminium shells
1) Weld shrinkage allowance to be added!

Vertical sections
1, 2, 3, ...



chapter 01 General Information
page barrier-free

01 U Deduction Dimensions 02 Schema A "v" FFBF

Partition	1/2 : 1/2	
Sash	2	
Sliding sash	1	BF barrier-free
(small) Fixed sash	1	FF fixframe
Aluminium shells **aluskin**		
Lift-and-slide door 85mm		

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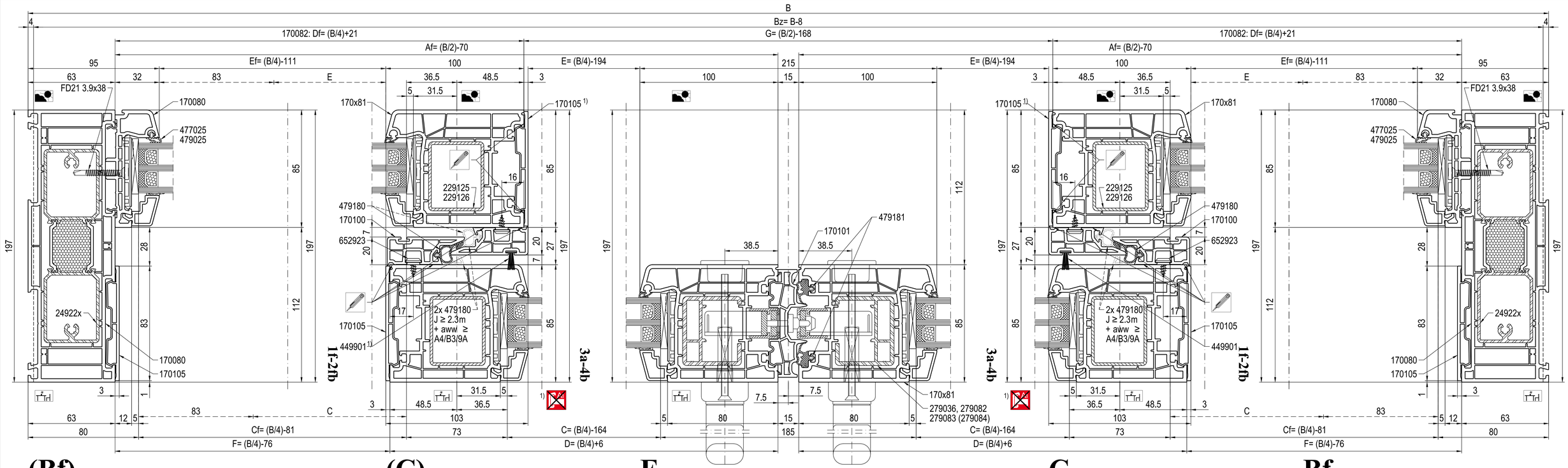
DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *01_U_02_HST85* Issued: 2020-11a Language: en (English) / Englisch



Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
F Reinforcement for frame 170080	24922x	27910x		229125 [3] 229126 [3]
F Reinforcement for sash 170x81	229125 229126	279082 [4]	229114 [1] 229115 [1]	
	279036 [4]	279082 [4]		
S Guide rail	27715x			
S Runner rail	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
U Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C	170104 Section **3a** Section **Aa**			170105 Section **3** Section **A**

1) Z 670290 required
2) BF: S 279189 required
3) Simple frame connection
4) Option = F 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
	Schema "v" Not admissible with aluminium shells
	Sealing (silicone rubber)
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A	Schema C	Widths
	...f fixframe	fixframe	⚠uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash 1)
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

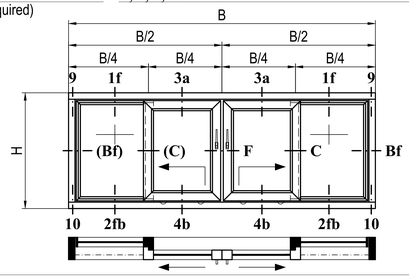
Vertical deduction dimensions					Heights
			...f fixframe	⚠uPVC	
h=	48 mm	27 mm			Threshold U
H=	H	H+21	H= H		Element
I=	H-296	✓	If= H-145		Glass
J=	H-126	✓	Jf= H-111		Sash 1)
K=	H-326	✓	Kf= H-175		Sash clearance
L=	-	✓	-		Exterior frame
M=	-	✓	-		Interior frame
Hz=	H-111	✓ ...	Hz= H-111		Frame

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B

Vertical sections
1, 2, 3, ...



chapter 01 General Information | page | barrier-free

01 U Deduction Dimensions | 03 | Schema C | FFBF

Partition	1/4 : 1/4 : 1/4 : 1/4		
Sash	4		
Sliding sash	2	BF	barrier-free
(small) Fixed sash	2	FF	fixframe

aluplast Kunststoff-Fenstersysteme
www.aluplast.net
Lift-and-slide door 85mm

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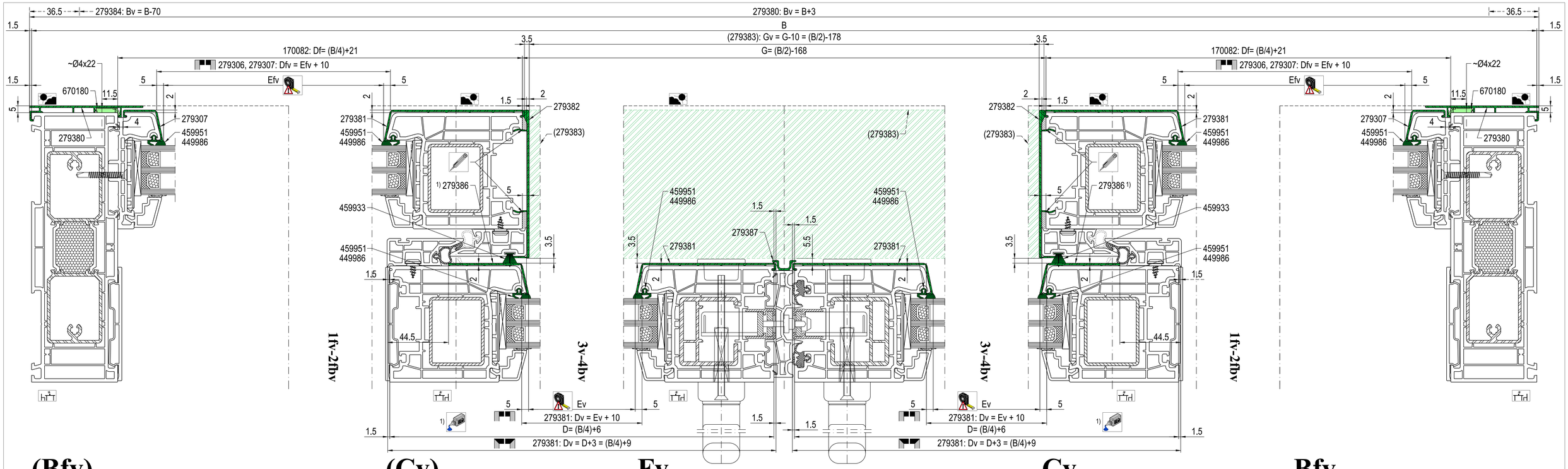


(Bfv) Section Bv mirror-inverted

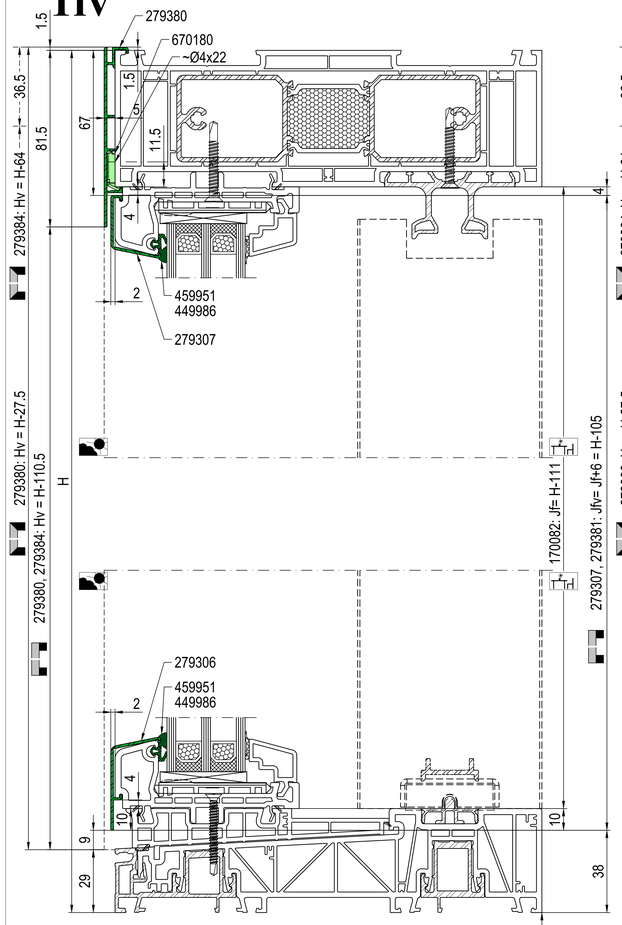
(Cv) Section Cv mirror-inverted

Fv Meeting rail-Sliding sash-Inside with aluminium shell

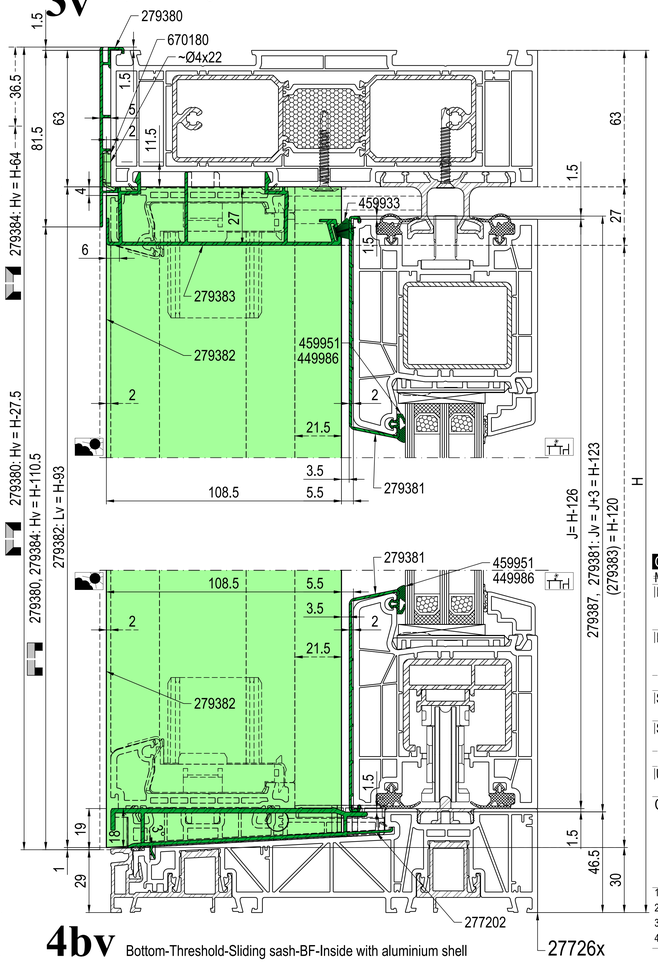
Cv Interlock with aluminium shell

Bfv Frame-Fixed sash-FF-Outside with aluminium shell

1fv Top-Frame-Fixed sash-FF-Outside with aluminium shell



3v Top-Frame-Sliding sash-Inside with aluminium shell



2fbv Bottom-Threshold-Fixed sash-BF-FF-Outside with aluminium shell

4bv Bottom-Threshold-Sliding sash-BF-Inside with aluminium shell

Options / Alternatives				
Modules [6]	Standard	Alternative	Alternative	Alternative
|F| Reinforcement for frame 170080				
	24922x	27910x		229125 [3]
				229126 [3]
|F| Reinforcement for sash 170x81				
	229125	279082 [4]	229114 [1]	
	229126		229115 [1]	
	279036 [4]	279082 [4]		
|S| Guide rail				
	27715x			
|S| Runner rail				
	27727x		27713x	27713x
	27729x [2]		277180 [2]	277180 [2]
|U| Threshold	⬇		⬇	⬇
	27726x		27911x [5]	27716x
Cover profile for schema A/C				
	170104			170105
	Section **3a**			Section **3**
	Section **Aa**			Section **A**

1) \|Z\| 670290 required
2) BF: \|S\| 279189 required
3) Simple frame connection
4) Option = \|F\| 279083, 279084 = ↕ vertical
5) GRP
6) See: chapter 01 Q Overview

Symbols	
... (black)	Cut: mitre joint
... (black)	Cut: butt joint
	Attention: measure the dimensions
	Sealing (silicone rubber)
	(suitable) Adhesive
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions		Widths
Schema A	Schema C	
...f fixframe	fixframe	⚠uPVC
Af= B-141	(B/2)-70	2 sashes
Cf= (B/2)-116.5	(B/4)-81	Glass
Df= (B/2)-14.5	(B/4)+21	Sash [1]
Ef= (B/2)-146.5	(B/4)-111	Sash clearance
A= B-156	(B/2)-85	2 sashes
B= B	B	Element
C= (B/2)-199.5	(B/4)-164	Glass
D= (B/2)-29.5	(B/4)+6	Sash [1]
E= (B/2)-229.5	(B/4)-194	Sash clearance
F= (B/2)-111.5	(B/4)-76	Overall clearance
G= -	(B/2)-168	Overall clearance outside
Bz= B-8	B-8	Threshold, frame
Ca= -	-	Glass, deviant
Da= -	-	Sash, deviant
Ea= -	-	Sash clearance, deviant

Vertical deduction dimensions					Heights
			...f fixframe	⚠uPVC	
h= 48 mm	27 mm				Threshold |U|
H= H	H'+21	H= H			Element
I= H-296	✓	If= H-145			Glass
J= H-126	✓	Jf= H-111			Sash [1]
K= H-326	✓	Kf= H-175			Sash clearance
L= -	✓	-			Exterior frame
M= -	✓	-			Interior frame
Hz= H-111	✓ ...	Hz= H-111			Frame

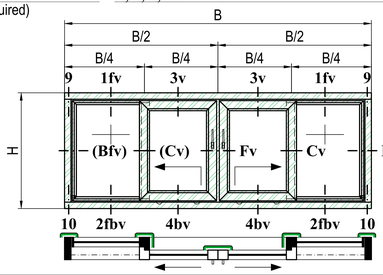
...v **aluskin** Aluminium shells

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...

9 Top-Frame-Frame
10 Bottom-Threshold-Frame
... see chapter 03 B



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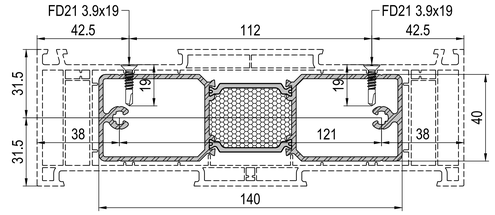
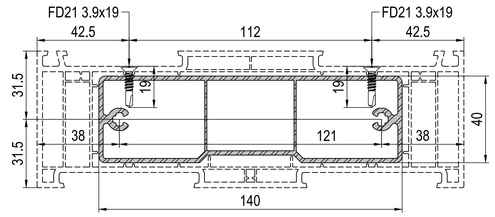
|F| Reinforcements (...) = lx



(65)24922x s=2.0 (197)aluminium

~ |D| Connector
-> 2x|F| 229125, 229126

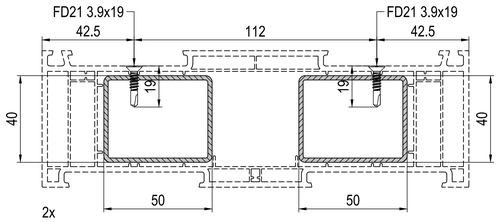
Seal screw heads in the horizontal rebate.



(69)27910x s=2.0 (206)aluminium

~ |D| Connector
-> 2x|F| 229125, 229126

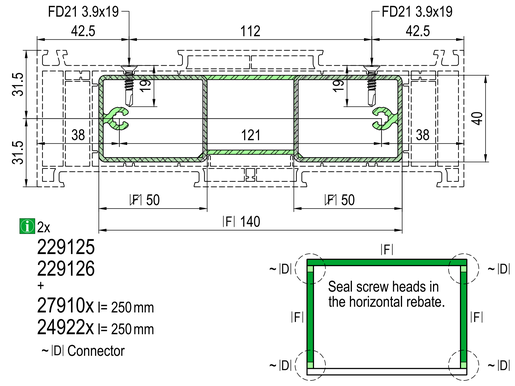
Seal screw heads in the horizontal rebate.



(12.1)229125 s=2.0
(16.8)229126 s=3.0

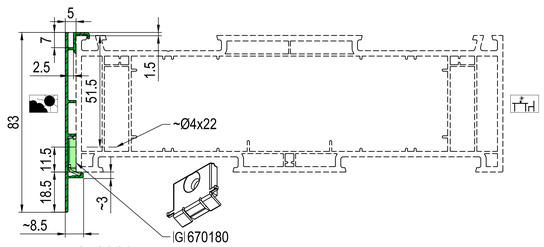
|F| 27910x, 24922x l= 250 mm
~ |D| Connector

Seal screw heads in the horizontal rebate.

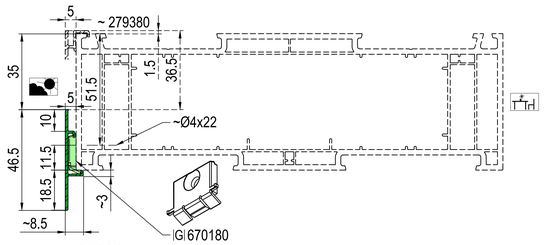


2x
229125
229126
+
27910x l= 250 mm
24922x l= 250 mm
~ |D| Connector

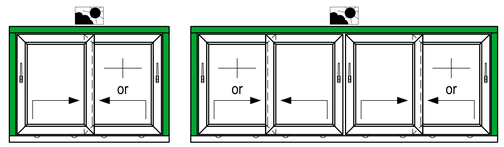
|P| aluskin Aluminium shells

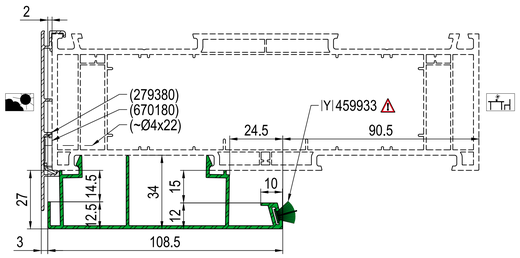


279380 (CL) SL 111mm
Standard AU 237mm

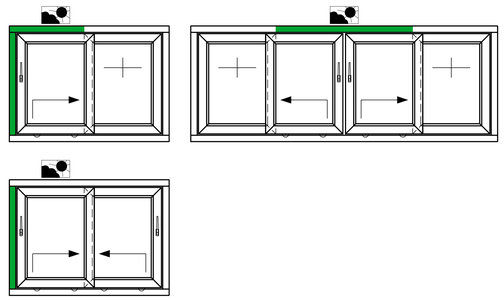


279384 (CL) SL 75mm
Alternative AU 120mm

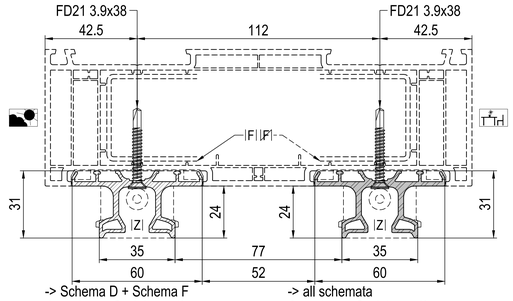




279383 (CL) SL 212mm
AU 516mm

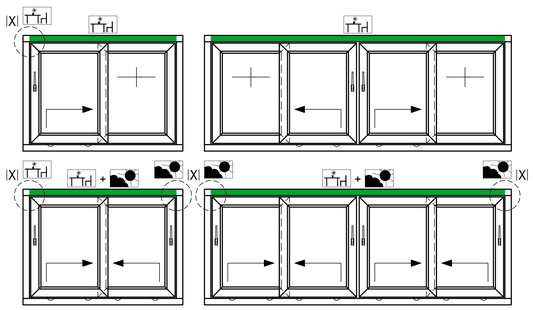


|S| Aluminium profiles

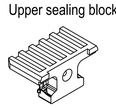


-> Schema D + Schema F
27715x Guide rail

-> all schemata
27715x Guide rail

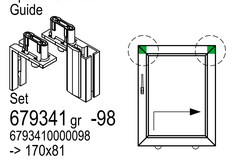


|X| Gaskets
Upper sealing block

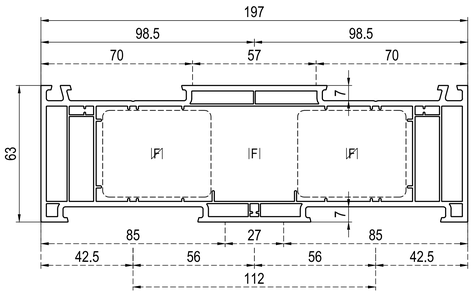


679340 gr
-> 170101
+ 27715x

|Z| Special accessories
Guide

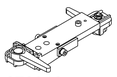


Set
679341 gr -98
6793410000098
-> 170x81
+ 27715x
|O| 670941



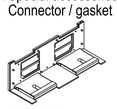
170080 Frame

|O| Mounting accessories

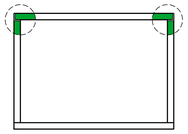


670918
-> |Z| 670380, 679320

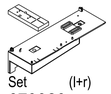
|Z| Special accessories
Connector / gasket



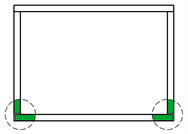
670380 wh
-> 170080
+ 170080
|O| 670918



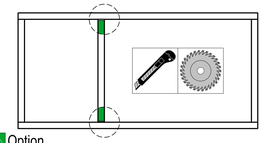
Connector / gasket



Set (l+r)
679320 gr
-> 170080
+ 27716x, 27726x
|O| 670918



Option
|Z| 670380 = cut



Option
|Z| 679320 = cut

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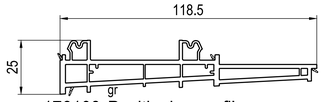
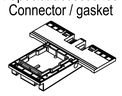


176103 Positioning profile
->170x81 + 27716x, 27726x

|X| Gaskets

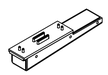
679300 gr
-> 679303 + 176103
-> 679306 + 176106

|Z| Special accessories
Connector / gasket

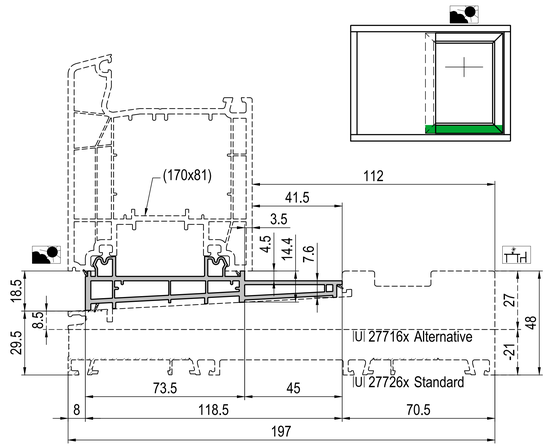


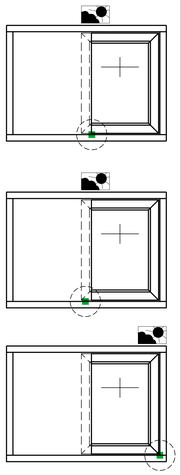
679303 gr
-> 170x81
+ 176103

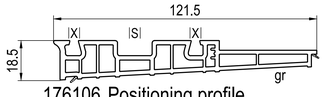
Connector / gasket



679302 gr
-> 170102
+ 176103

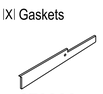






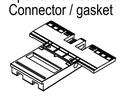
176106 Positioning profile
->170x81, 170082 + 27716x, 27726x

|X| Gaskets

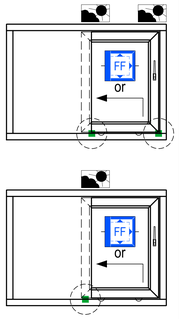


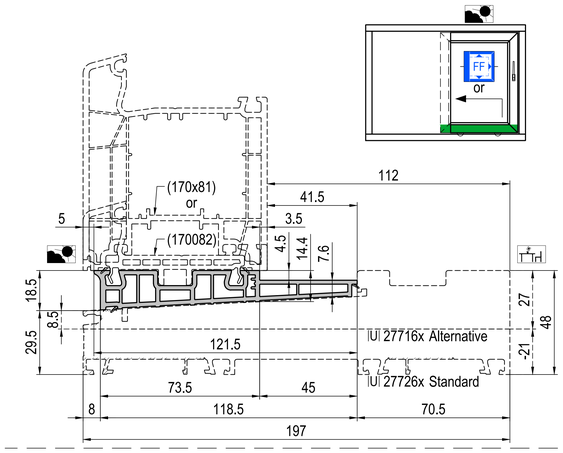
679300 gr
-> 679303 + 176103
-> 679306 + 176106

|Z| Special accessories
Connector / gasket

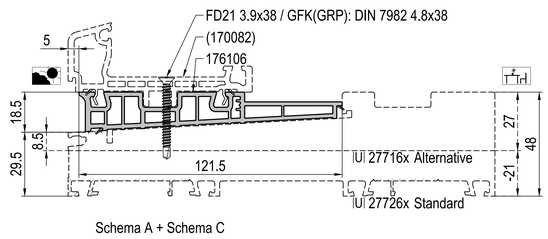


679306 gr
-> 176106,
|S| 277107

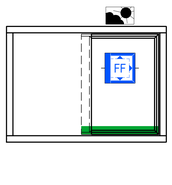




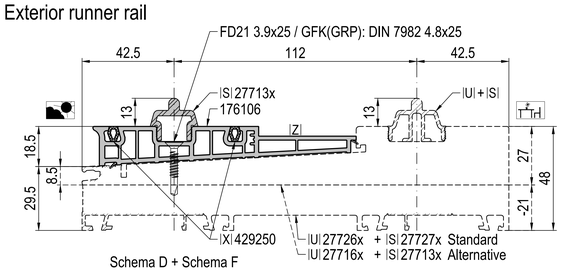
FF fixframe



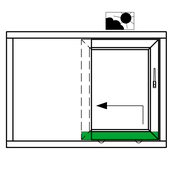
Schema A + Schema C



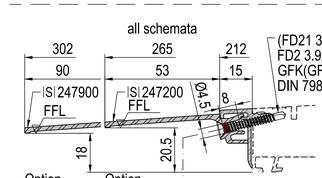
Exterior runner rail



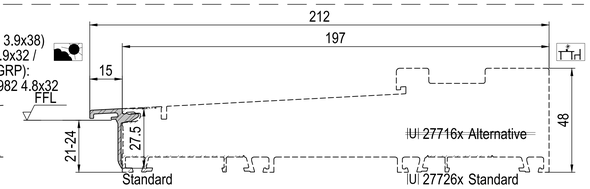
Schema D + Schema F



|S|S|S| Aluminium profiles

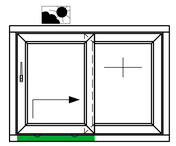


Option
247900 ↔ aluminium
Option
247200 aluminium ⌀ 4.5 + 277205 aluminium

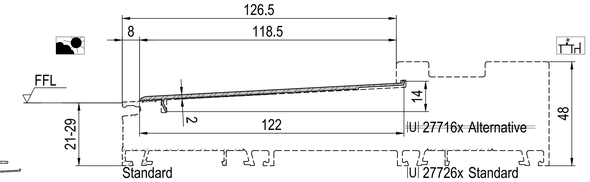


Standard
277205 Connecting profile
aluminium

Schema A + Schema C



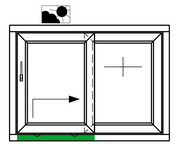
Option
|S| 277202



Standard
277201 Aluminium step protection
aluminium

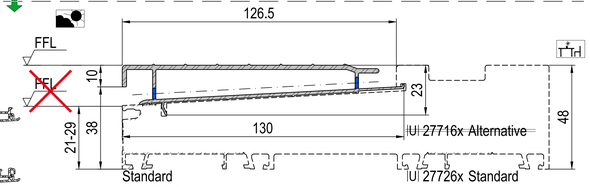
BF barrier-free

barrier-free Schema A + Schema C



Alternative
|S| 277107 + 277105

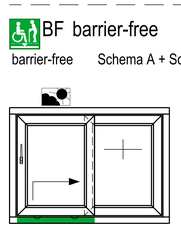
Alternative
|S| 277107 + 277106



Standard
277202 Aluminium step protection
aluminium punched out

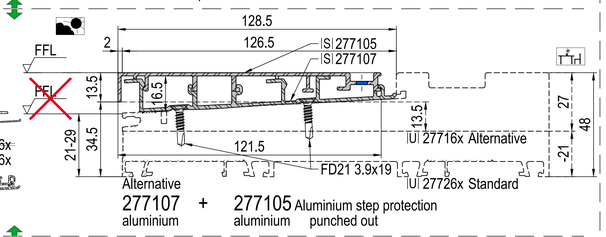
BF barrier-free

barrier-free Schema A + Schema C



Standard |U| ~~27716x~~
|S| 277202 -> |U| 27726x

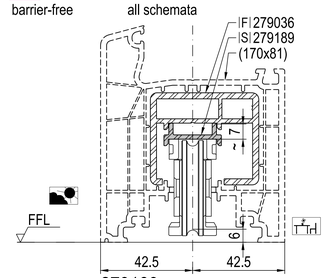
Alternative
|S| 277107 + 277106



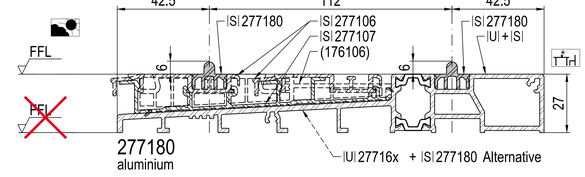
Alternative
277107 + 277105 Aluminium step protection
aluminium aluminium punched out

BF barrier-free

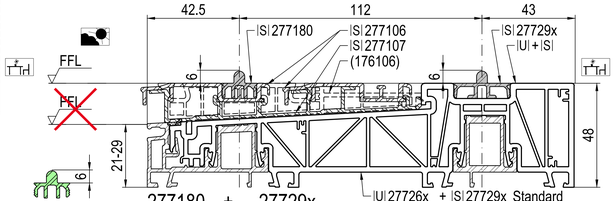
barrier-free all schemata



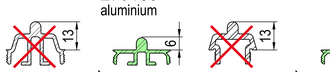
279189
aluminium



277180
aluminium

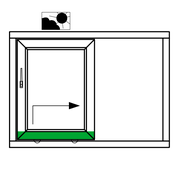


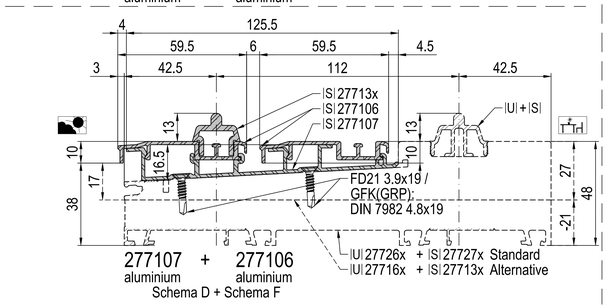
277180 + 277129x
aluminium aluminium



|S| 27727x → |S| 27729x |S| 27713x → |S| 277180

Exterior runner rail

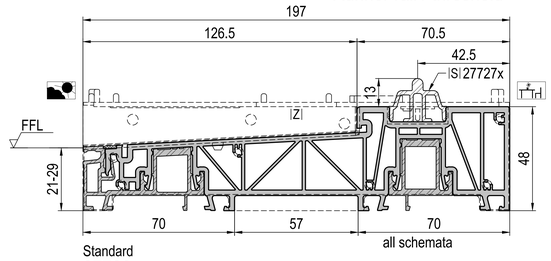




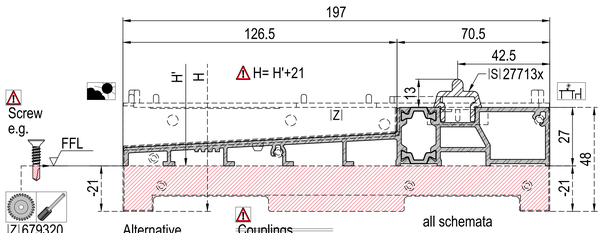
277107 + 277106
aluminium aluminium
Schema D + Schema F

|U| Aluminium threshold

Runner rail / threshold

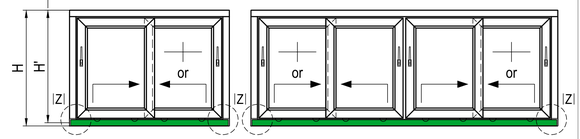


Standard
27726x
uPVC/aluminium



Alternative
27716x
uPVC/aluminium

Couplings ...
Extension profile ...
|S| 277205, 277206
|S| 277201, 277202



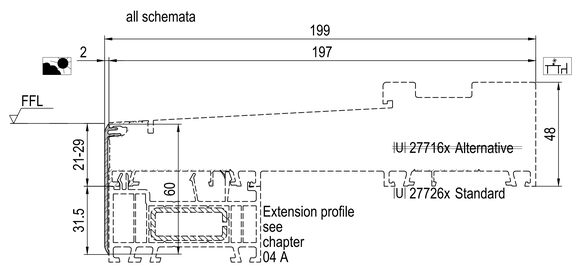
|O| Mounting accessories

670918
-> |Z| 670380,
679320

|Z| Special accessories
Connector / gasket

Set (l+r)
679320 gr
-> 170080
+ 27716x, 27726x
|O| 670918

|S|S|S| Aluminium profiles



Extension profile
see
chapter
04 A

277206 Connecting profile
aluminium

chapter 02 Overview
page
02 A Profiles and Accessories 02

NOTE: Assembly sequence and details on component parts according to assembly plan!

176103 Positioning profile 27726x Threshold
176106 Positioning profile 27716x Threshold
BF barrier-free

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Lift-and-slide door 85mm

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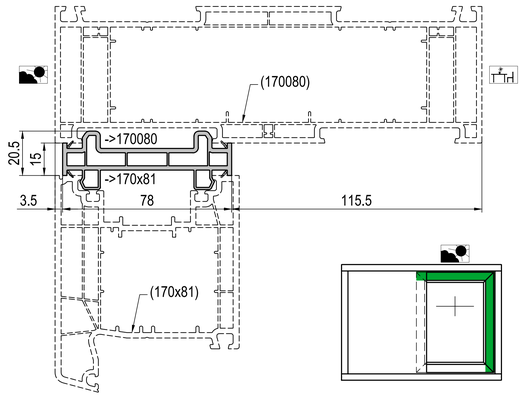
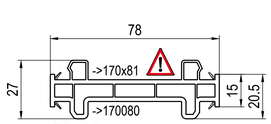
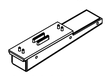


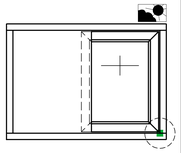


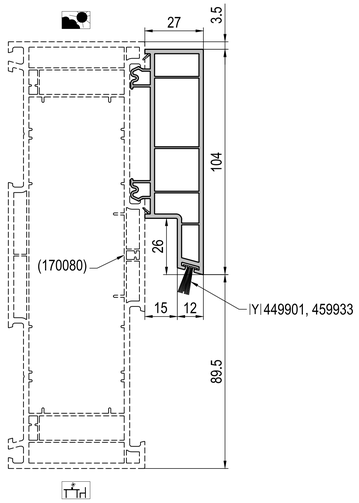
170102 Extension profile
->170x81 + 170080

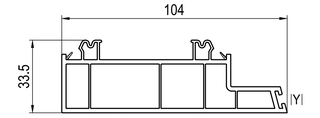
|Z| Special accessories
Connector / gasket



679302 gr
-> 170102
+ 176103

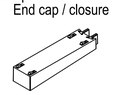




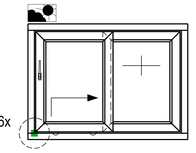


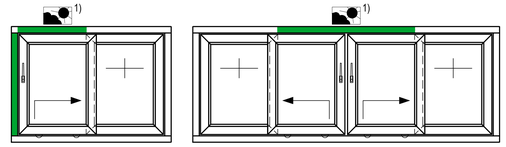
170104 Cover profile
->170080

|Z| Special accessories
End cap / closure

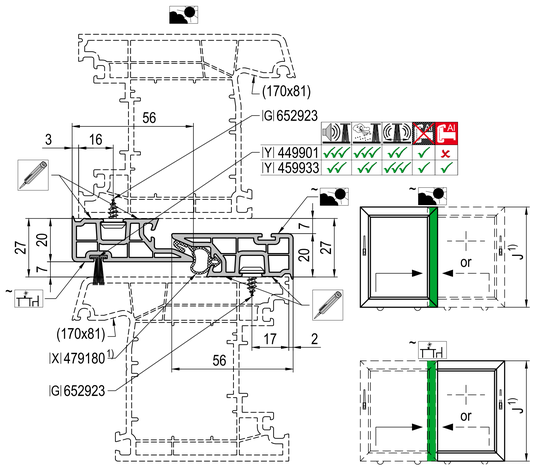


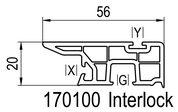
679304 gr
-> 170104
+ 27716x, 27726x





1) 170104 = Standard
170105 = Option
279383 = Aluminium shells



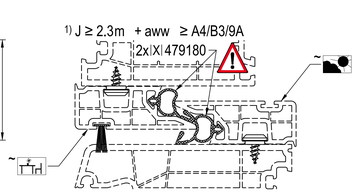


170100 Interlock
->170x81

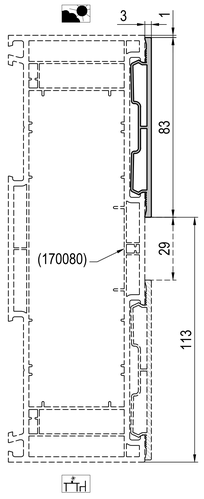
|O| Mounting accessories

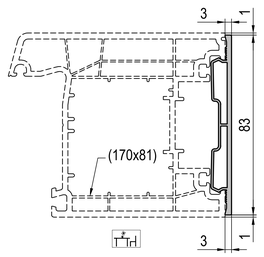
670901
-> |G| 652923
+ 170100

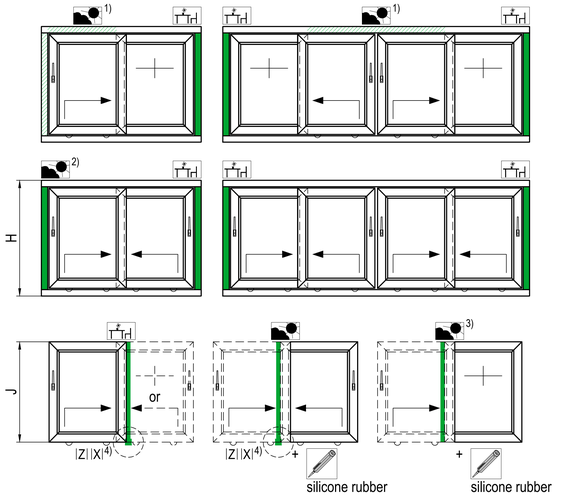
1) J ≥ 2.3m + aww ≥ A4/B3/9A



Sealing (silicone rubber)







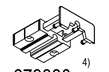
170105 Cover profile
->170080, 170x81

1) 170104 = Standard
170105 = Option
279383 = Aluminium shells

2) 170105 = Standard
279383 = Aluminium shells

3) 170105 = Standard
279382 = Aluminium shells

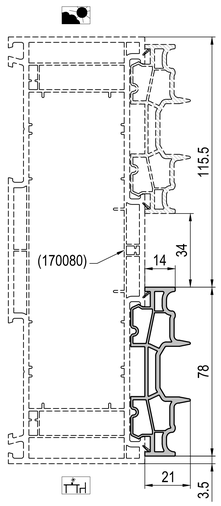
4) Option
|Z| Special accessories
End cap + |X| Gaskets

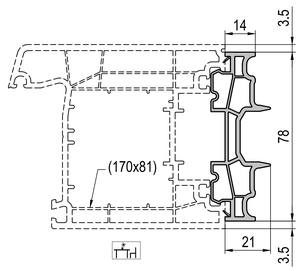


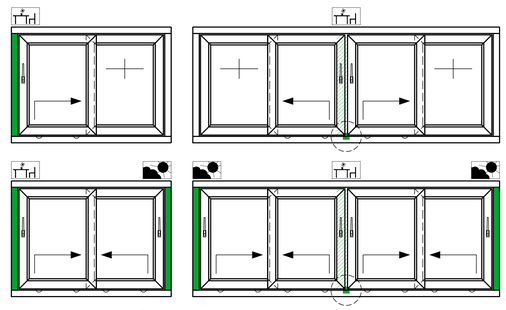
679330 gr 4)
-> 170105
|X| 479330

479330 bl 4)
-> 679330
+ 170105

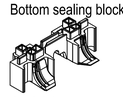
+ |S| 279189 -> BF barrier-free



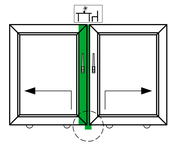


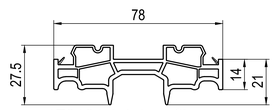


Bottom sealing block



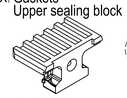
679305 gr
-> 170101
+ 27716x, 27726x



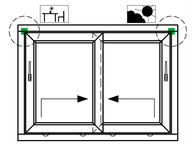


170101 Inlet profile
->170080, 170x81

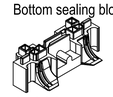
|X| Gaskets
Upper sealing block



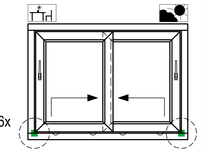
679340 gr
-> 170101
+ 27715x



Bottom sealing block



679305 gr
-> 170101
+ 27716x, 27726x



chapter 02 Overview page

02A Profiles and Accessories 03

NOTE: Assembly sequence and details on component parts according to assembly plan!

170102 Extension profile	170104 Cover profile
170100 Interlock	170105 Cover profile
	170101 Inlet profile

www.aluplast.net Lift-and-slide door 85mm

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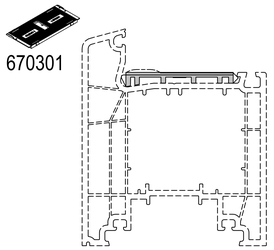
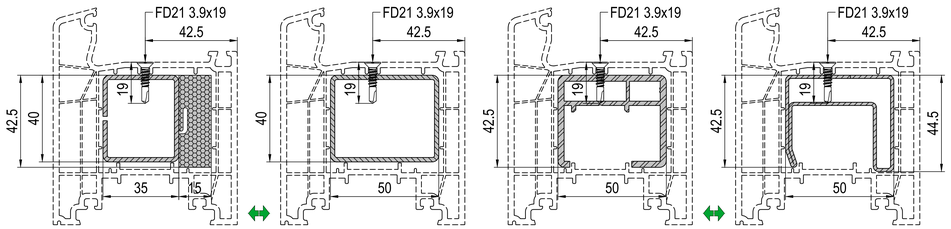
|A| Spacer



|F| Reinforcements (...) = Ix

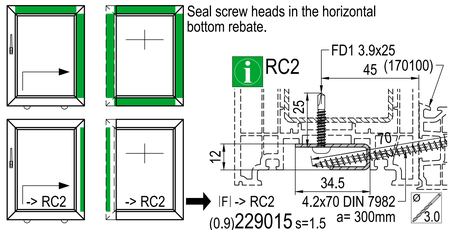


(4.0)229114 s=1.5 + |Z| 670290
(5.0)229115 s=2.0 + |Z| 670290

(12.1)229125 s=2.0
(16.8)229126 s=3.0

(5.9)279036 s=2.8
(17.8)aluminium

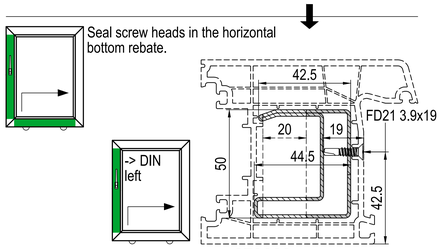
(13.2)279082 s=1.5



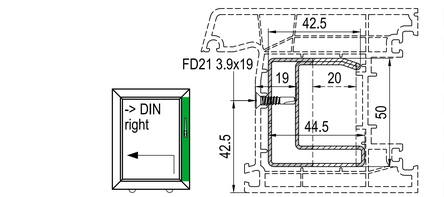
Seal screw heads in the horizontal bottom rebate.

|F| -> RC2
(0.9)229015 s=1.5

Seal screw heads in the horizontal bottom rebate.

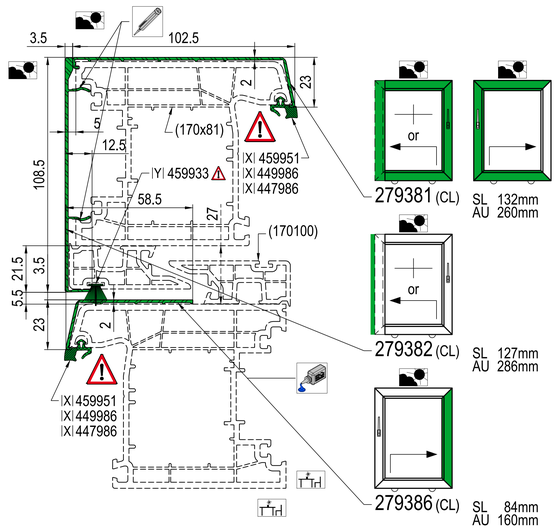


(13.2)279083 s=1.5 -> DIN left ● blue pierced hole



(13.2)279084 s=1.5 -> DIN right ● red pierced hole

|P| **alu**skin Aluminium shells



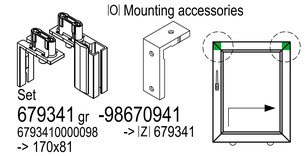
279381 (CL) SL 132mm AU 260mm

279382 (CL) SL 127mm AU 286mm

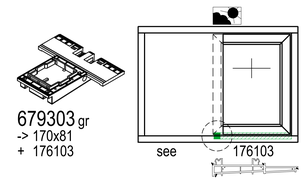
279386 (CL) SL 84mm AU 160mm

|Z| Special accessories

|O| Mounting accessories



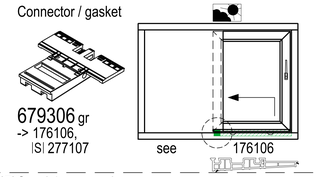
Set
679341 gr -98670941
6793410000098 -> |Z| 679341
-> 170x81
+ 27715x
|O| 670941



679303 gr
-> 170x81
+ 176103

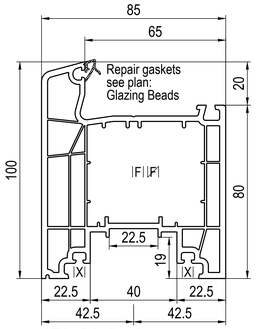
see 176103

Connector / gasket



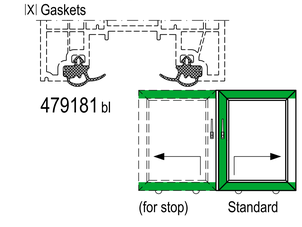
679306 gr
-> 176106,
|S| 277107

see 176106



170x81 Sash

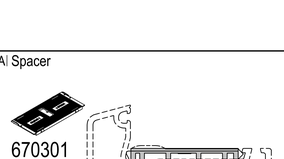
|X| Gaskets



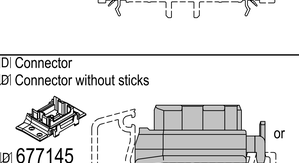
479181 bl

(for stop) Standard

|A| Spacer

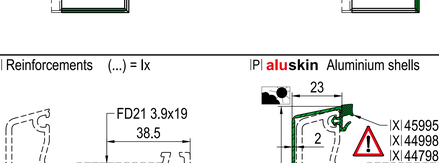


|Z| Special accessories



Connector
670382 wh
Butt joint

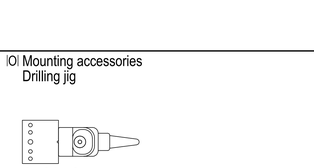
|P| **alu**skin Aluminium shells



279306 (CL) SL 66mm AU 136mm

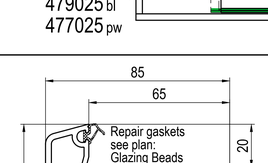
279307 (CL) SL 59mm AU 108mm

|Z| Special accessories
Connector / gasket



679306 gr
-> 176106,
|S| 277107

see 176106

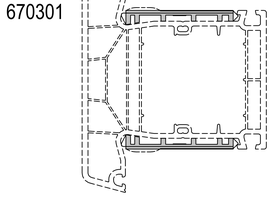


170082 Fixed sash
(small)

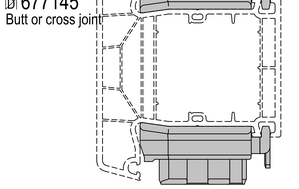
|X| Gaskets

479025 bl
477025 pw

|A| Spacer



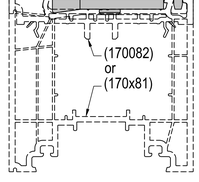
|D| Connector
|D| Connector without sticks



|D| 677145
Butt or cross joint

or

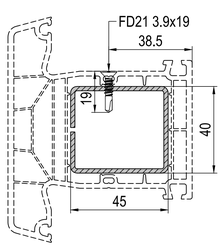
|D| 677146
Butt joint



|D| Connector for inclined connections

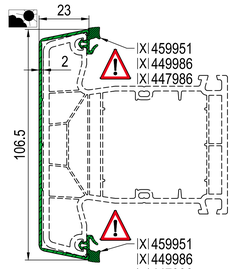
|D| 640046 P
~45x20x1000 mm
-> 170x41, 170x44

|F| Reinforcements (...) = Ix



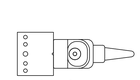
(6.1)249034 s=1.25
(9.2)249035 s=2.0

|P| **alu**skin Aluminium shells

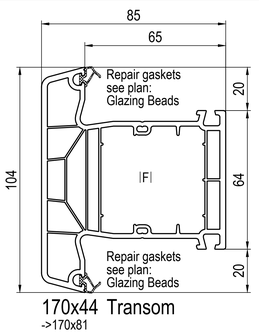


289343 (CL) SL 150mm AU 292mm

|O| Mounting accessories
Drilling jig

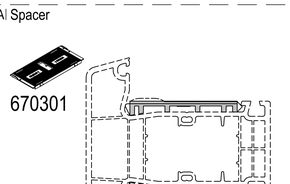


670950
-> |D| 677101, 677146, 679141
-> |D| 677142, 677144, 677145, 677241, 677244

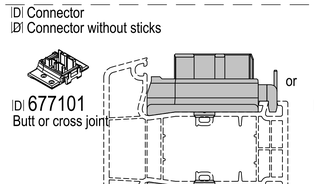


170x44 Transom
->170x81

|A| Spacer



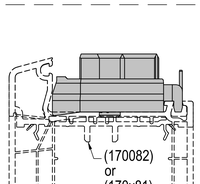
|D| Connector
|D| Connector without sticks



|D| 677101
Butt or cross joint

or

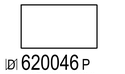
|D| 679141
Butt joint



|D| Connector for inclined connections

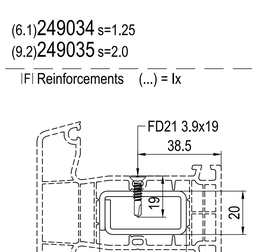
|D| 620046 P
~35x20x1000 mm
-> 170x41

or



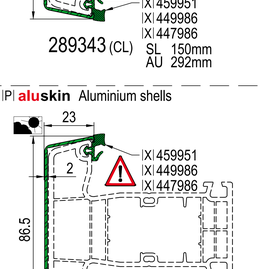
|D| 640046 P
~45x20x1000 mm
-> 170x41, 170x44

|F| Reinforcements (...) = Ix



(3.9)259043 s=1.5
(5.6)259044 s=2.5

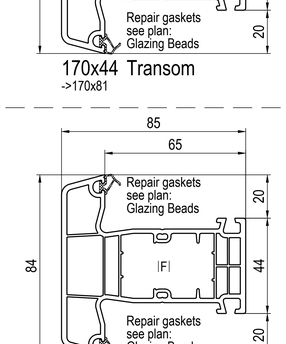
|P| **alu**skin Aluminium shells



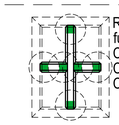
289341 (CL) SL 130mm AU 252mm

|O| Mounting accessories
Drilling jig

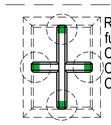
670950
-> |D| 677101, 677146, 679141
-> |D| 677142, 677144, 677145, 677241, 677244



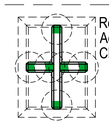
170x41 Transom
->170x81



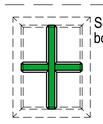
Refer to manual "IDEAL 7000" for further details on 170x41, 170x44:
Chapter 02 D
Chapter 03 J
Chapter 09 H



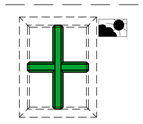
Refer to manual "IDEAL 7000" for further details on 170x41, 170x44:
Chapter 02 D
Chapter 03 J
Chapter 09 H



Refer to manual "Additional Profiles / Accessories"
Chapter 05 D Connectors



Seal screw heads in the horizontal bottom rebate.



chapter 02 Overview page

02A Profiles and Accessories 04

aluplast Kunststoff-Fenstersysteme

NOTE: Assembly sequence and details on component parts according to assembly plan!

		170x81 Sash
FF fixframe:	(small)	170082 Fixed sash
		170x44 Transom
		170x41 Transom

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Lift-and-slide door 85mm

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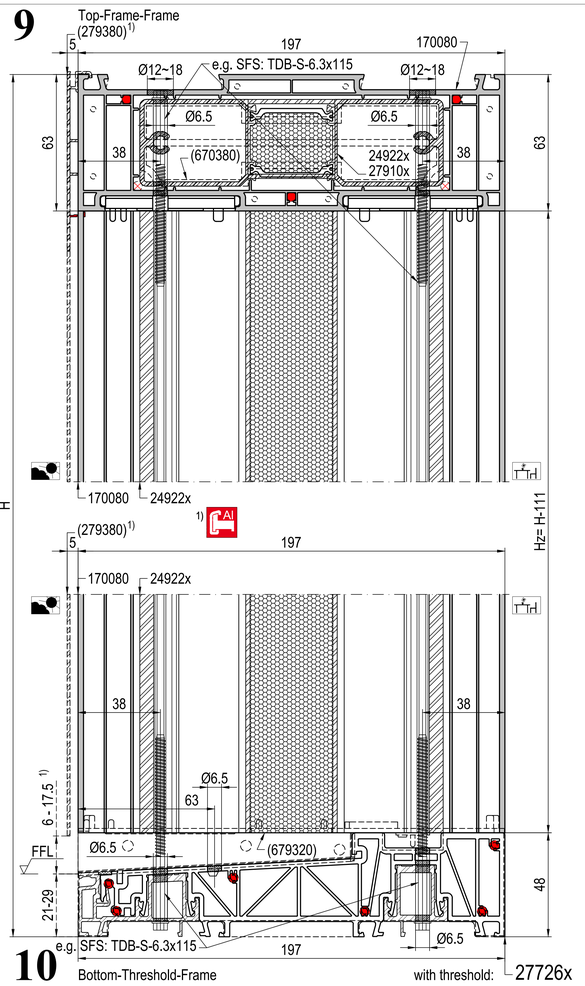
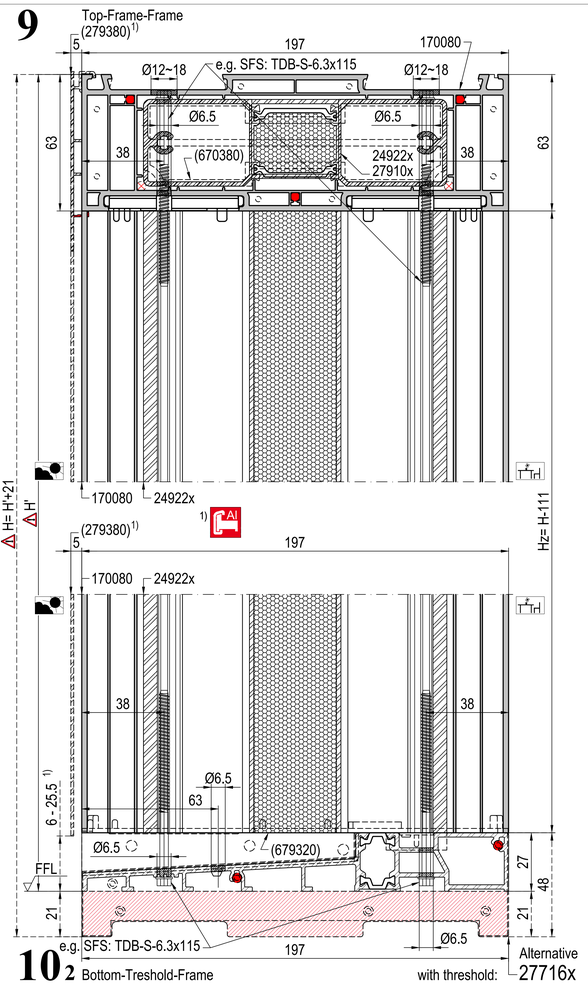




Symbols

Al	Schema "v" with aluminium shells
FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions	Schema A	Schema C / Schema D / Schema F	Widths uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Vertical deduction dimensions			Heights uPVC
h=	48 mm	27 mm	Threshold (U)
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

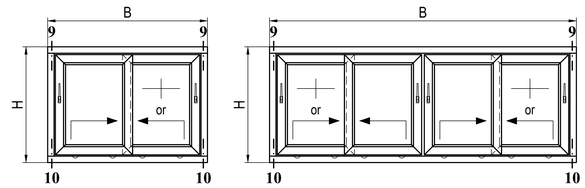
Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections

1, 2, 3, ...



chapter 03 Combinations — page

03 B Deduction dimensions — **01 General**

Section 9
Section 10
Section 9-10

www.aluplast.net — Lift-and-slide door 85mm

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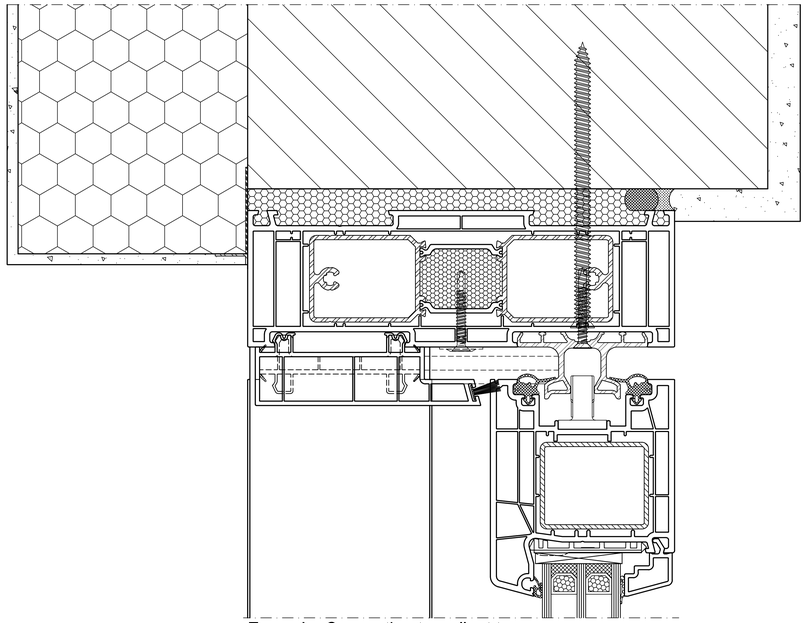
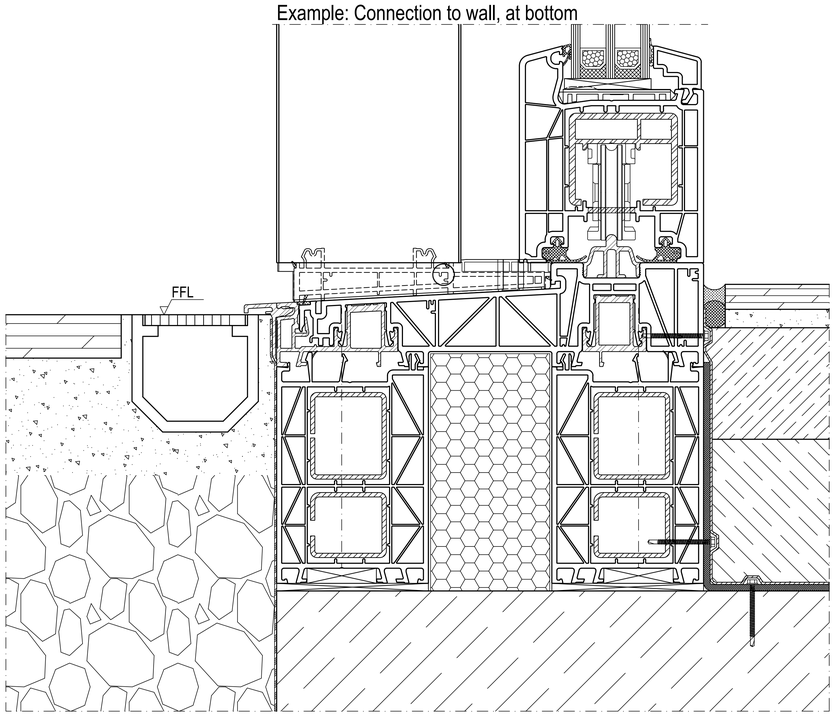
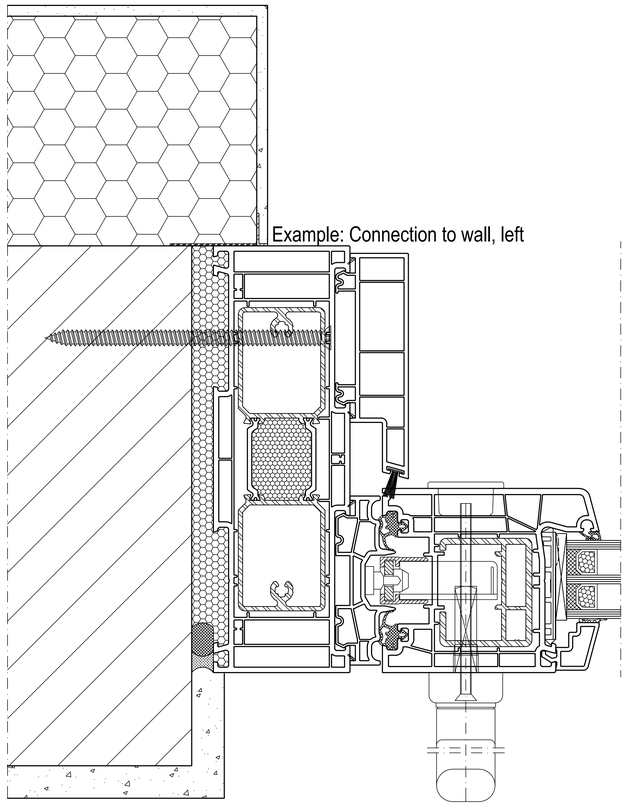


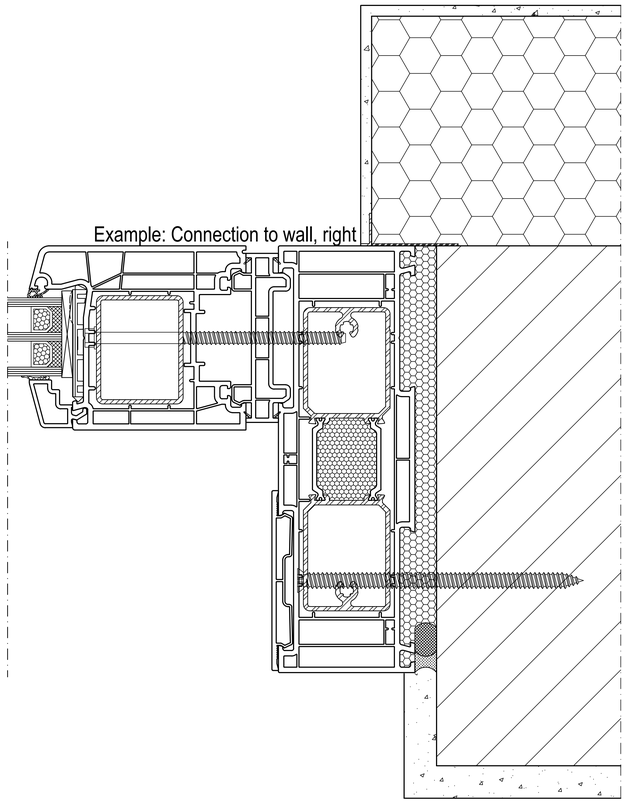
Example: Connection to wall, at top

Example: Connection to wall, at bottom

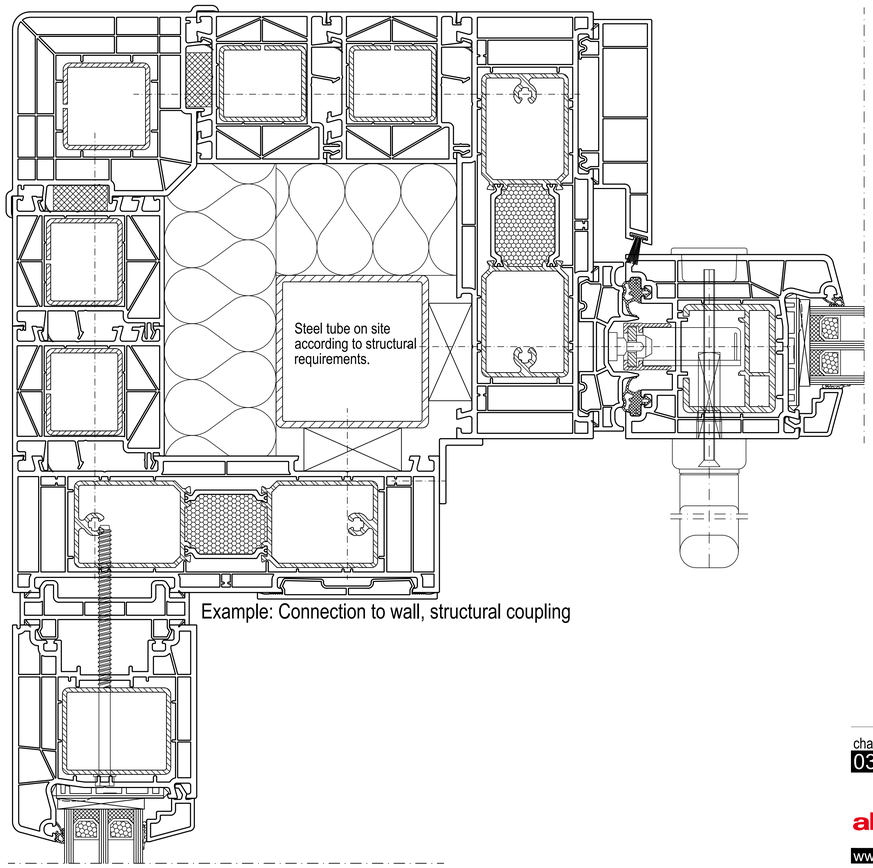




Example: Connection to wall, left

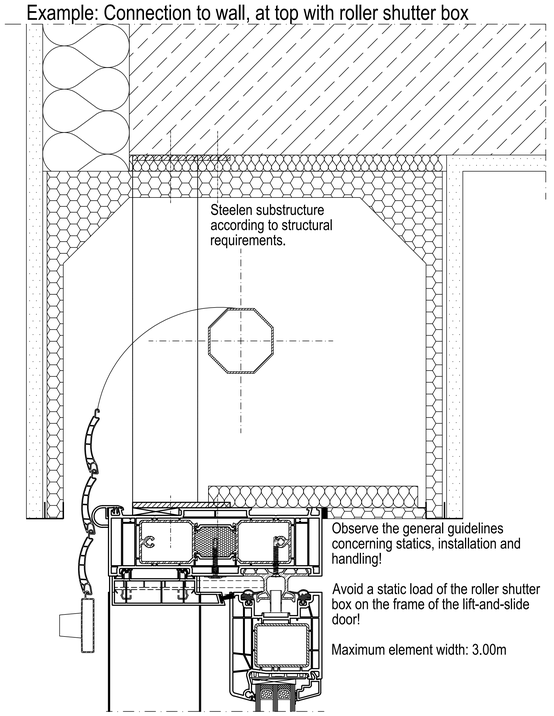


Example: Connection to wall, right

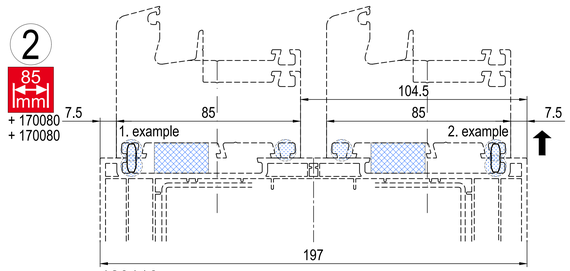


Example: Connection to wall, structural coupling

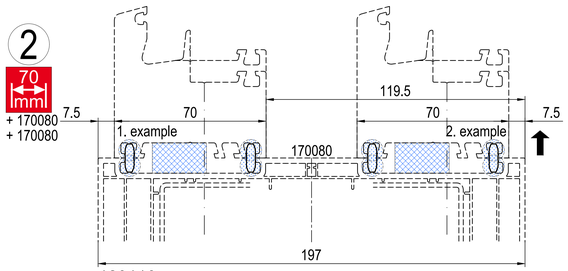
Example: Connection to wall, at top with roller shutter box



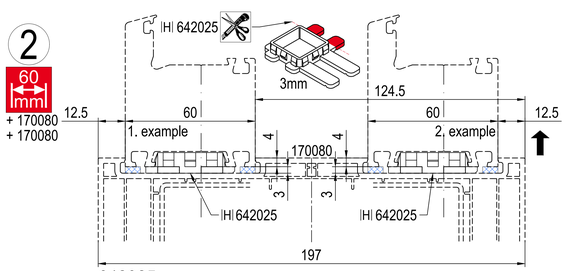
May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten



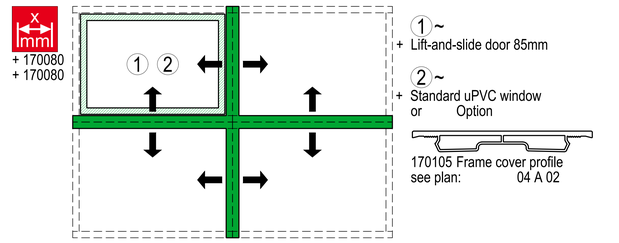
120116 Tongue coupling profile

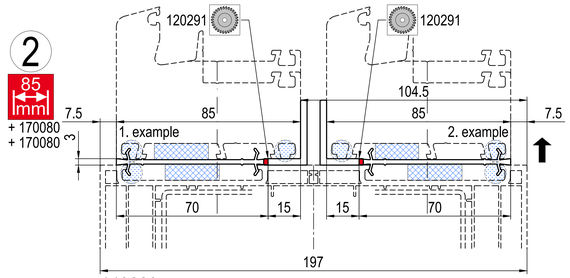


120116 Tongue coupling profile

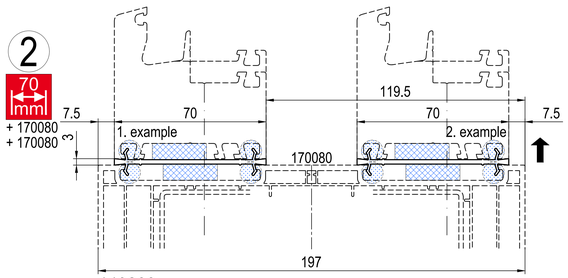


|H| 642025 Expansion plate

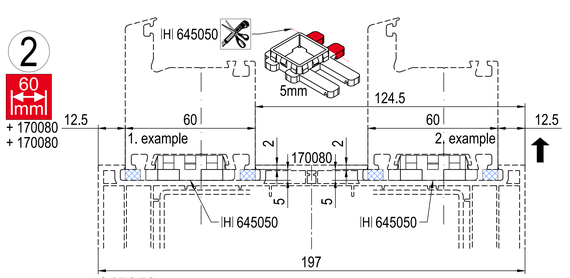




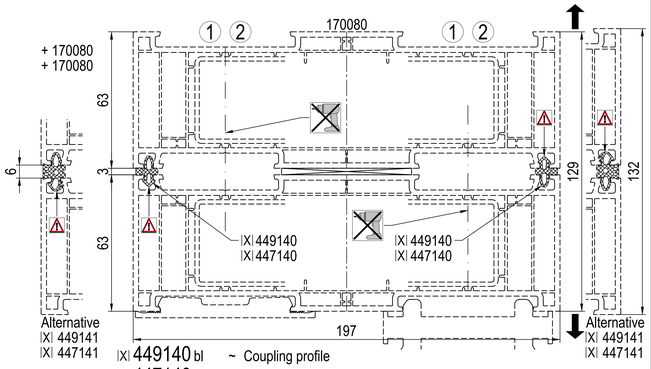
140203 Coupling profile



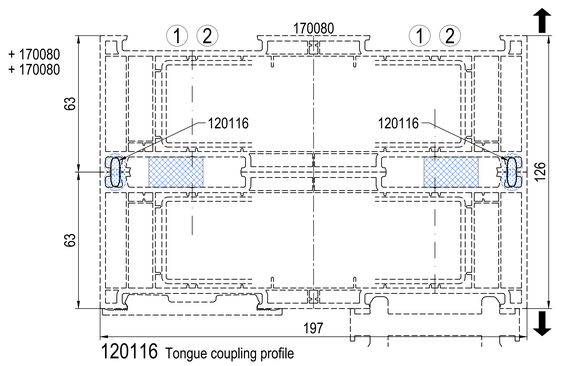
140203 Coupling profile



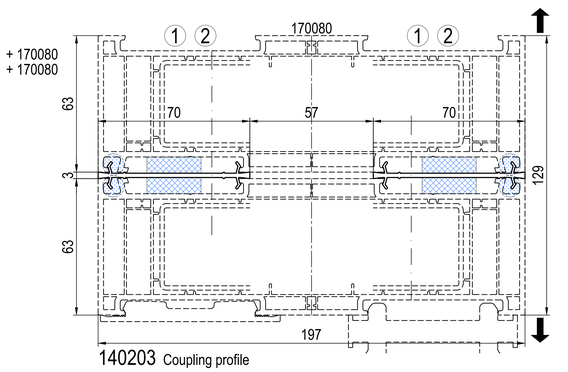
|H| 645050 Expansion plate



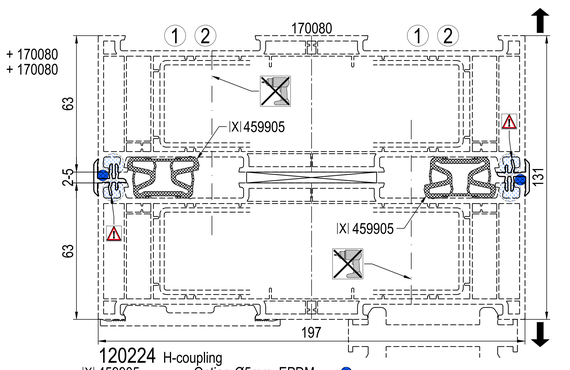
|X| 449140 bl ~ Coupling profile
|X| 447140 pw



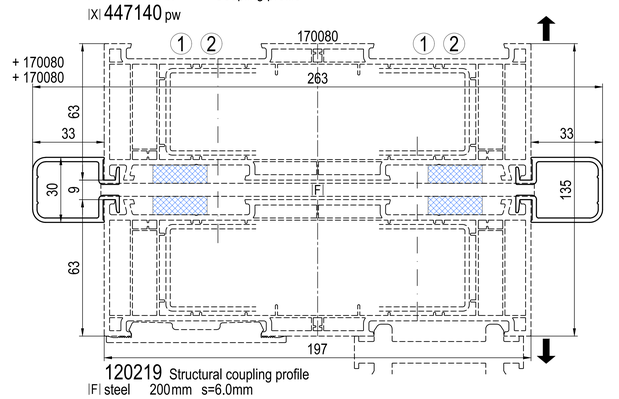
120116 Tongue coupling profile



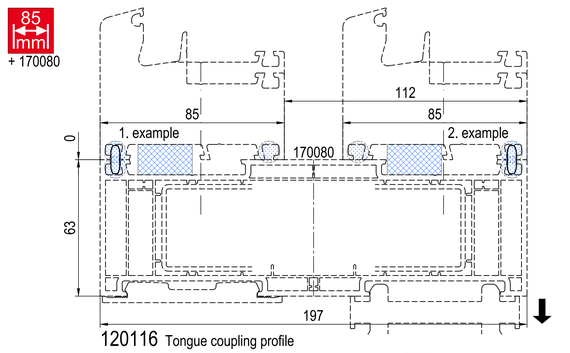
140203 Coupling profile



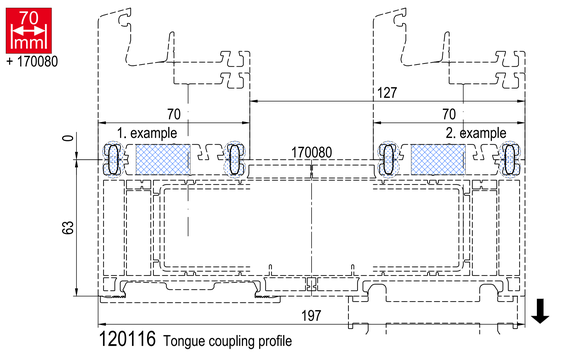
120224 H-coupling
|X| 459905 Option Ø5mm, EPDM: Round chord



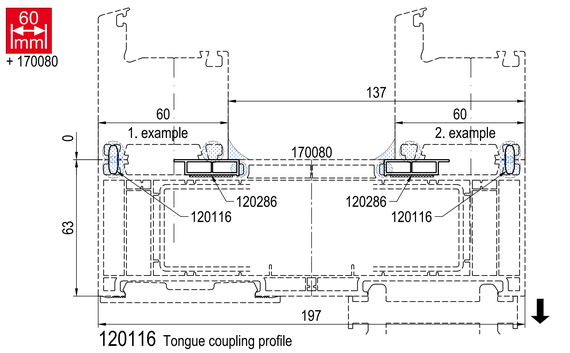
120219 Structural coupling profile
|F| steel 200mm s=6.0mm



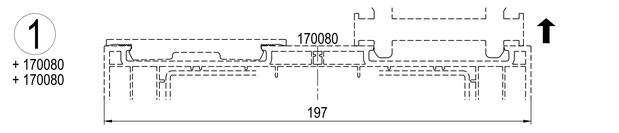
120116 Tongue coupling profile

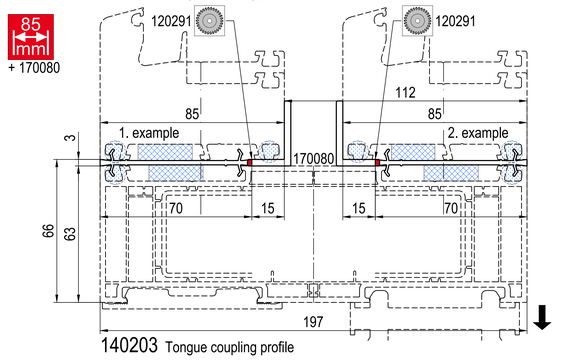


120116 Tongue coupling profile

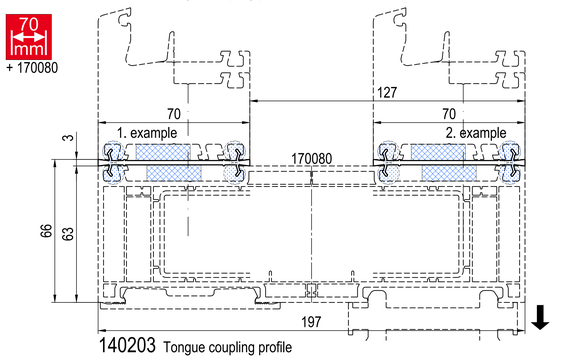


120116 Tongue coupling profile

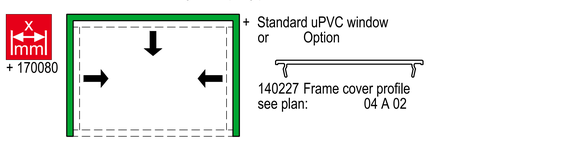




140203 Tongue coupling profile



140203 Tongue coupling profile



+ Standard uPVC window
or Option

140227 Frame cover profile
see plan: 04 A 02

+ 140248 Coupling profile 90°
+ 140249 Coupling profile 135°
+ 140243 Bay profile
+ 140244 Bay pipe Ø85mm

see plan: 04 A 02

Accessories -> Couplings

|F| Reinforcements
see plan:
Reinforcements

|H| Installation / mounting anchor

642025 bl 3mm General
645050 gn 5mm General
622333 |F| 249244 -> 140244
622041 |F| 229040 -> 120275, 140248
622902 |F| 249242 -> 140249 General
682333 General
622019 General
682331 General

|X| Gaskets

449340 bl
447340 pw -> 140243
459905 bl -> 120224
420250 wh
421250 br
423250 oc
429250 bl General
449140 bl 3mm
447140 pw Couplings
449141 bl 6mm
447141 pw Couplings
429320 bl General

Symbols -> Chapter 04 A

- Original shape cut
- No clip function (offset possible)
- Screw hand-tight
- Sealing required
- Can be used mirror-inverted

foam inside

chapter 04 Additional Profiles
page 01

04 A Additional Profiles

⚠ NOTE: For additional sealing / screwing etc. please refer to manual Handling, chapter 08 C 3.

~ Chapter 04 D Couplings
+ 170080 Frame

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Lift-and-slide door 85mm

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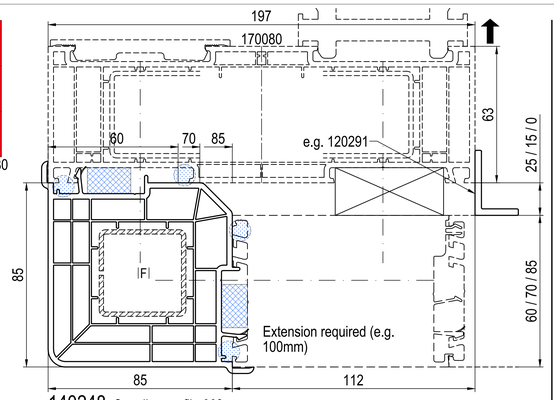
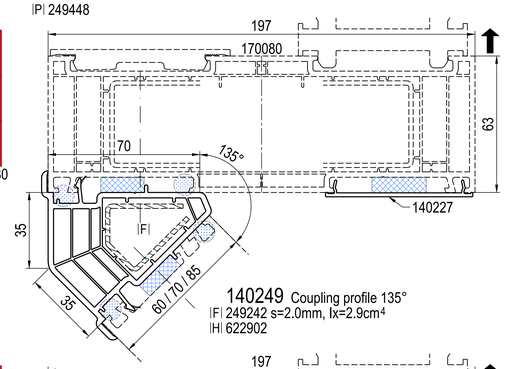
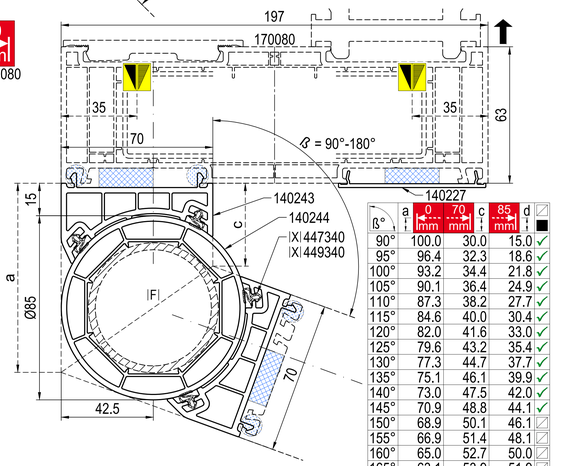
60 mm
70 mm
85 mm
+ 170080



140248 Coupling profile 90°
|F| 229040 s=2.0mm, Ix=7.0cm⁴
|H| 622041
|P| 249448

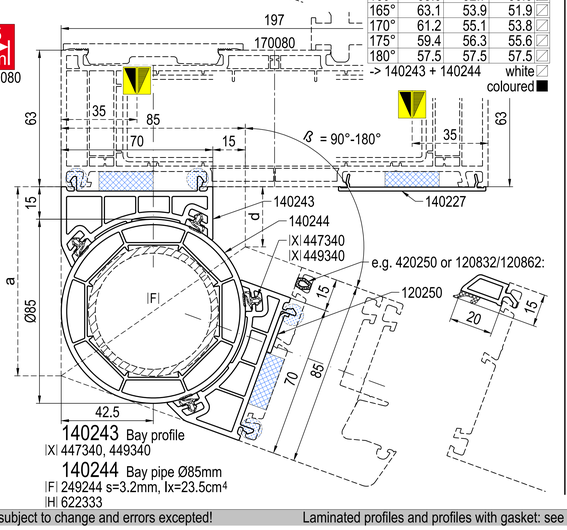


140249 Coupling profile 135°
|F| 249242 s=2.0mm, Ix=2.9cm⁴
|H| 622902



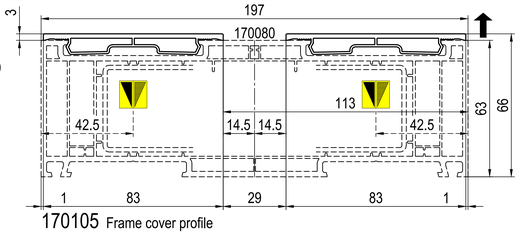
ß°	a	0 mm	70 mm	c	85 mm	d	
90°	100.0	30.0	15.0	✓			
95°	96.4	32.3	18.6	✓			
100°	93.2	34.4	21.8	✓			
105°	90.1	36.4	24.9	✓			
110°	87.3	38.2	27.7	✓			
115°	84.6	40.0	30.4	✓			
120°	82.0	41.6	33.0	✓			
125°	79.6	43.2	35.4	✓			
130°	77.3	44.7	37.7	✓			
135°	75.1	46.1	39.9	✓			
140°	73.0	47.5	42.0	✓			
145°	70.9	48.8	44.1	✓			
150°	68.9	50.1	46.1				
155°	66.9	51.4	48.1				
160°	65.0	52.7	50.0				
165°	63.1	53.9	51.9				
170°	61.2	55.1	53.8				
175°	59.4	56.3	55.6				
180°	57.5	57.5	57.5				

-> 140243 + 140244 white / coloured

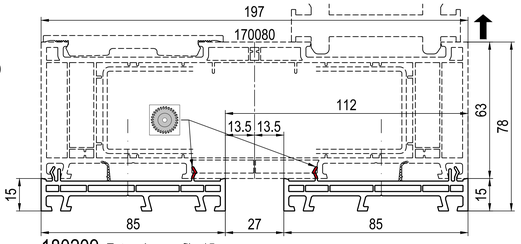


140243 Bay profile
|X| 447340, 449340

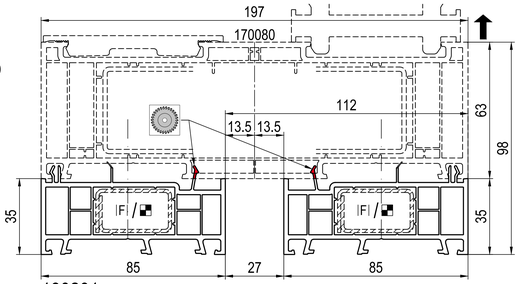
140244 Bay pipe Ø85mm
|F| 249244 s=3.2mm, Ix=23.5cm⁴
|H| 622333



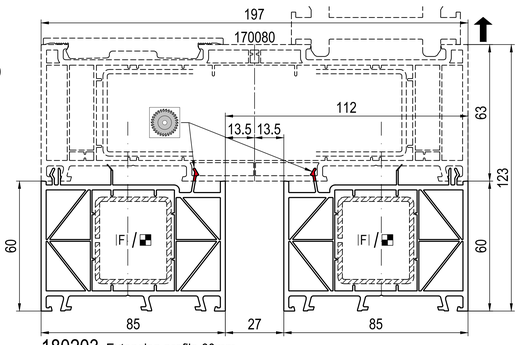
170105 Frame cover profile



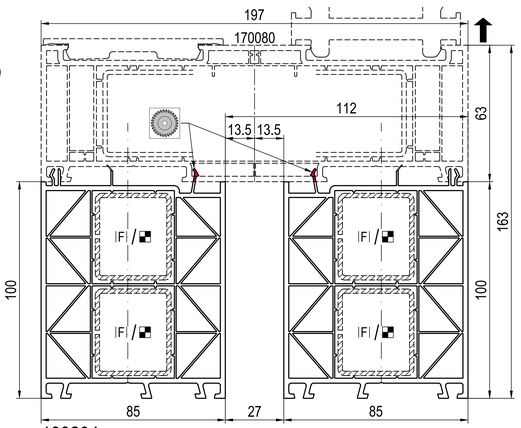
180209 Extension profile 15mm



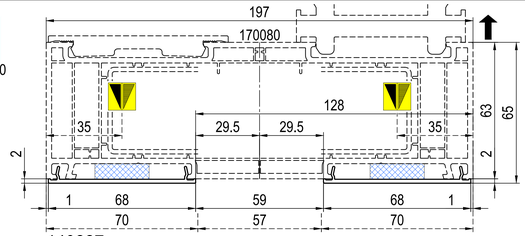
180201 Extension profile 35mm
|F| 229098, 229100, 229101
|P| 249335



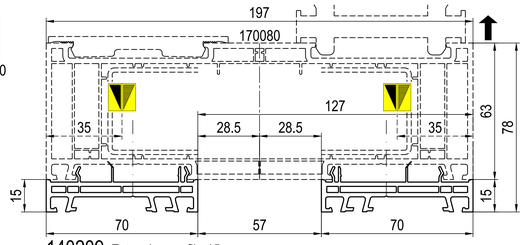
180203 Extension profile 60mm
|F| 229114, 229115
|P| 249360



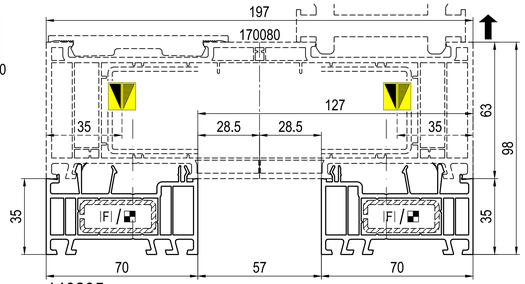
180204 Extension profile 100mm
|F| 229114, 229115
|P| 249310



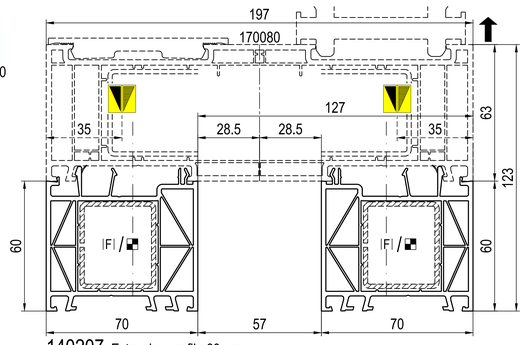
140227 Frame cover profile



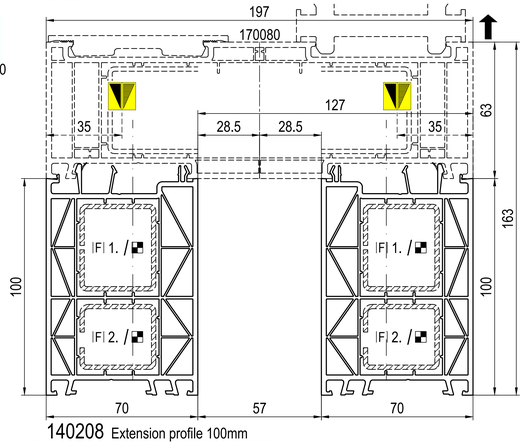
140209 Extension profile 15mm



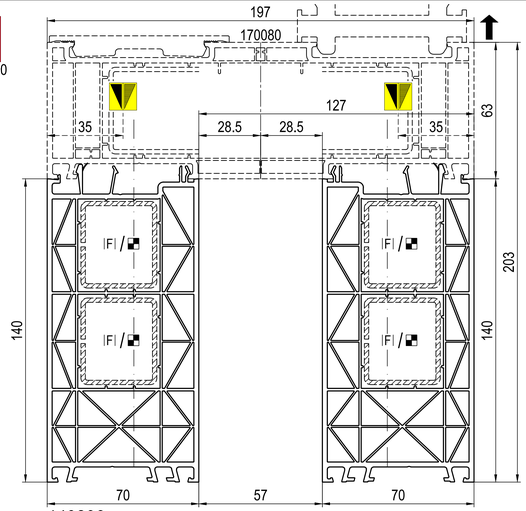
140205 Extension profile 35mm
|F| 229110, 229111
|P| 249335



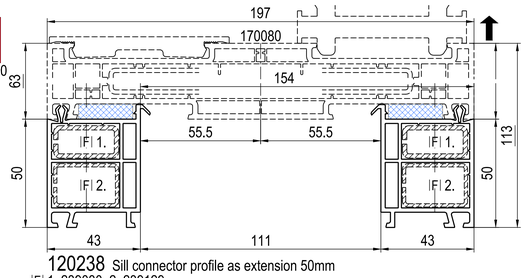
140207 Extension profile 60mm
|F| 229017, 229114, 229115
|P| 249360



140208 Extension profile 100mm
|F| 1. 229114, 1. 229115, 2. 259010, 2. 259011
|P| 249310



140206 Extension profile 140mm
|F| 229114, 229115



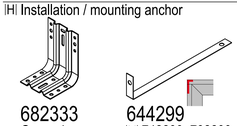
120238 Sill connector profile as extension 50mm
|F| 1. 239030, 2. 239129

Accessories -> Couplings see plan: 04 A 01

Accessories -> Extension profile

|F| Reinforcements
see plan:
Reinforcements

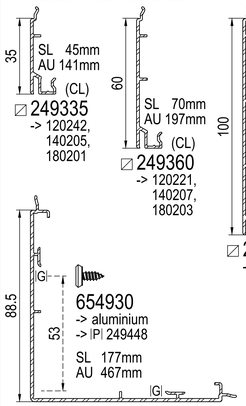
|H| Installation / mounting anchor



682333 General

644299 |X| 742299, 782299

|P| **aluskin** Aluminium shells



249335 -> 120242, 140205, 180201

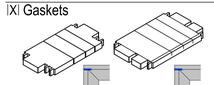
249360 -> 120221, 140207, 180203

249310 -> 140208, 180204

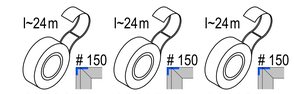
654930
-> aluminium
-> |P| 249448
SL 177mm
AU 467mm

249448 (CL)
|G| 654930 Nipple screw / Clip
-> 140248 Couplings

|X| Gaskets

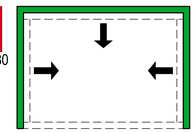


742299 bl ->70mm |H| 644299
782299 bl ->85mm |H| 644299
420250 wh
421250 br
423250 oc
429250 bl General
429320 bl General



690060 60x150mm ->60mm
690070 70x150mm ->70mm
690085 85x150mm ->85mm

x mm + 170080



Symbols -> Chapter 04 A

- Original shape cut
- No clip function (offset possible)
- Screw hand-tight
- Sealing required
- Can be used mirror-inverted
- foam inside

chapter 04 Additional Profiles page

04 A Additional Profiles 02

⚠ NOTE: For additional sealing / screwing etc. please refer to manual Handling, chapter 08 C 3.

~ Chapter 04 D Couplings
~ Chapter 04 E Frame cover profiles
~ Chapter 04 F Extensions
~ Chapter 04 J Sill connector profiles + 170080 Frame

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Lift-and-slide door 85mm

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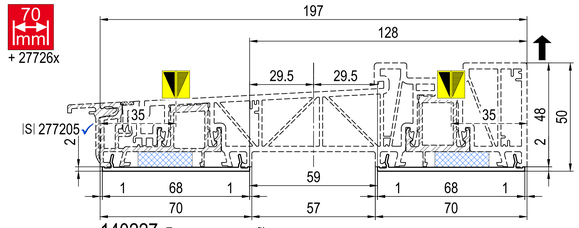
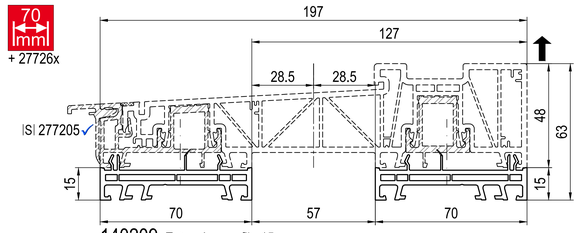
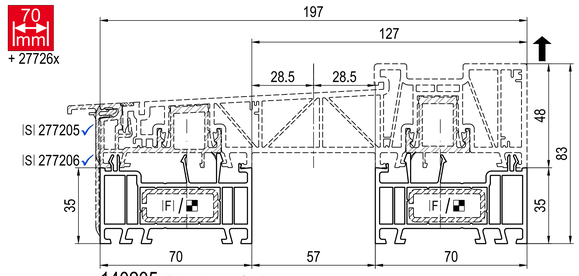


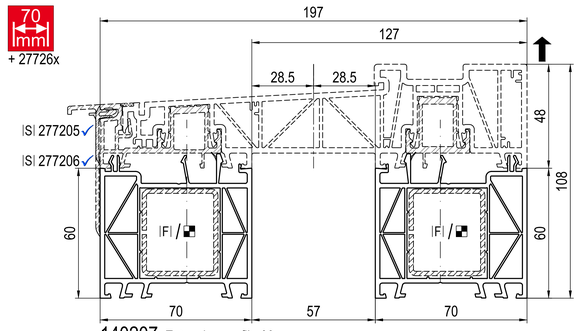
140227 Frame cover profile



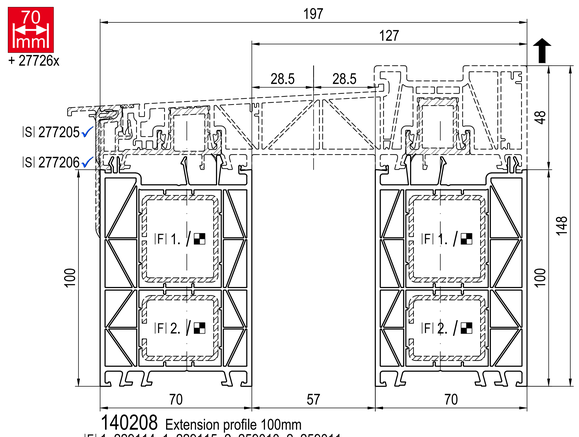
140209 Extension profile 15mm



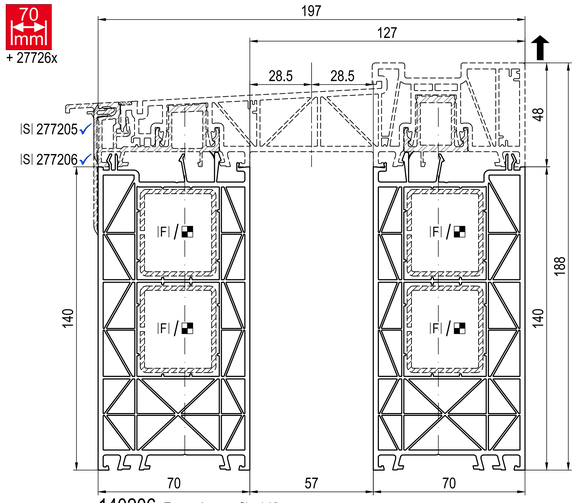
140205 Extension profile 35mm
|F| 229110, 229111



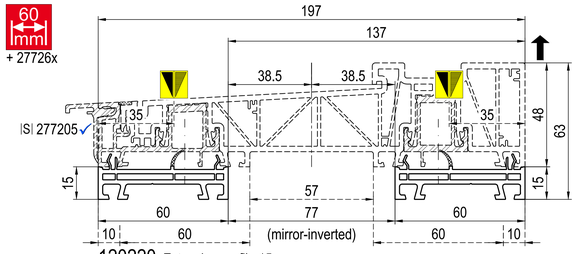
140207 Extension profile 60mm
|F| 229017, 229114, 229115



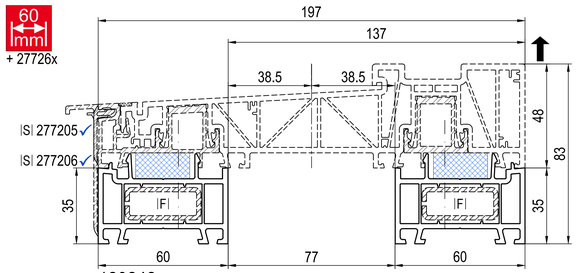
140208 Extension profile 100mm
|F| 1. 229114, 1. 229115, 2. 259010, 2. 259011



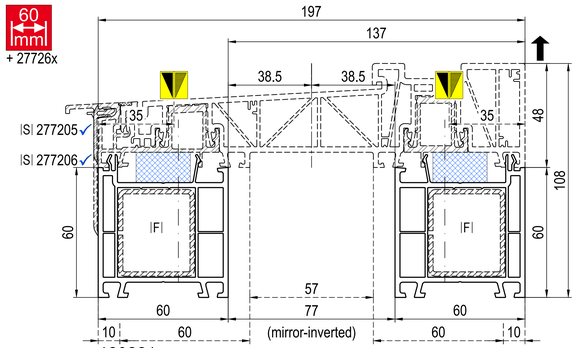
140206 Extension profile 140mm
|F| 229114, 229115



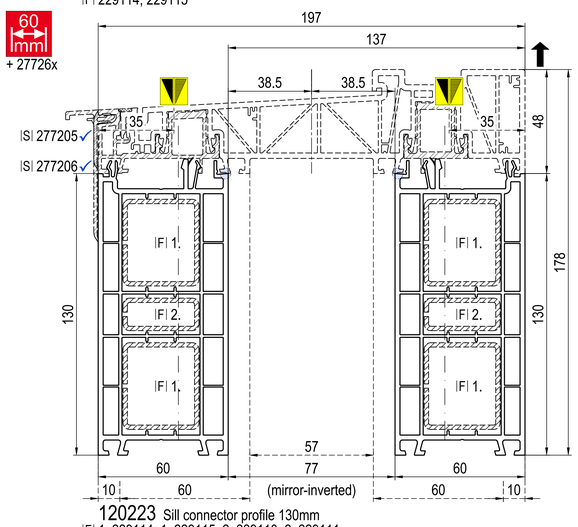
120220 Extension profile 15mm



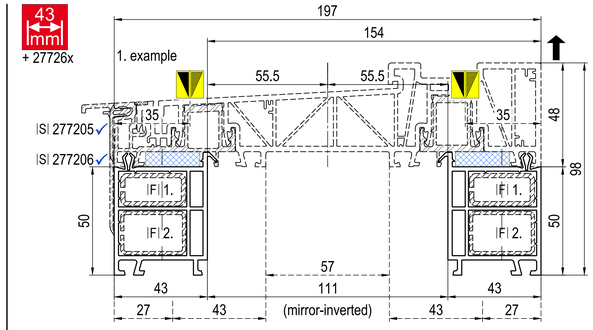
120242 Extension profile 35mm
|F| 229110, 229111

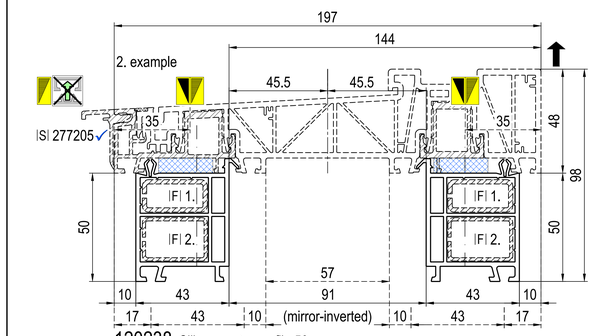


120221 Extension profile 60mm
|F| 229114, 229115



120223 Sill connector profile 130mm
|F| 1. 229114, 1. 229115, 2. 229110, 2. 229111



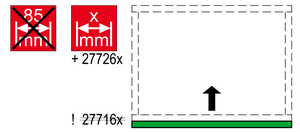


120238 Sill connector profile 50mm
|F| 1. 239030, 2. 239129

Symbols -> Chapter 04 A

- Original shape cut
- No clip function (offset possible)
- Screw hand-tight
- Sealing required
- Can be used mirror-inverted

foam inside

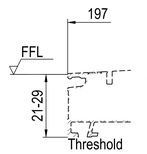


Accessories

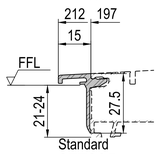
-> Extension profile see plan: 04 A 02

Accessories

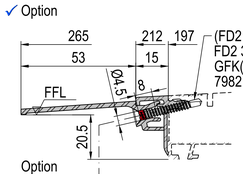
-> Threshold ✓ Option



Threshold

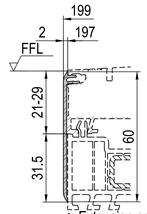


Standard
277205 ✓ aluminium

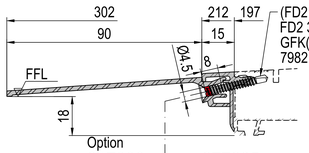


(FD21 3.9x38) FD2 3.9x32 / GFK(GRP): DIN 7982 4.8x32

Option
247200 Ø 4.5 aluminium + 277205 ✓ aluminium



-> Extension profile
277206 ✓ aluminium



(FD21 3.9x38) FD2 3.9x32 / GFK(GRP): DIN 7982 4.8x32

Option
247900 Ø 4.5 aluminium + 277205 ✓ aluminium

chapter 04 Additional Profiles page

04 A Additional Profiles 03

aluplast Kunststoff-Fenstersysteme

NOTE: For additional sealing / screwing etc. please refer to manual Handling, chapter 08 C 3.

~ Chapter 04 E Frame cover profiles
~ Chapter 04 F Extensions
~ Chapter 04 J Sill connector profiles
+ 27726x Threshold

www.aluplast.net Lift-and-slide door 85mm

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

☐ not laminated
All information for white profiles only (no lamination, no colour).

white

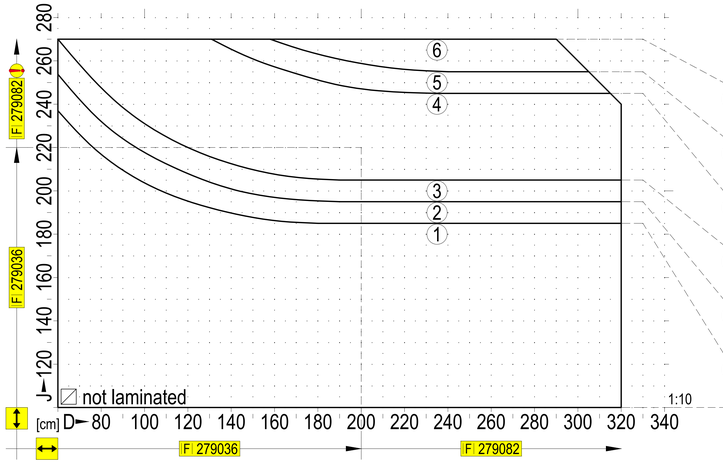
Not with ... |P| aluskin ✕
⚠ ~ ■ coloured

Resistance to wind load EN 12210

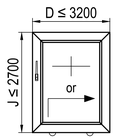
Class B2

Sash dimensions: The application diagrams show the relation between feasible sash widths and sash heights as a function of different glazing weights or overall glazing thicknesses, respectively. The thus resulting sash dimensions and sash formats (upright or horizontal format) - as well as the maximum sash weight - must not be exceeded. In addition, the maximum load bearing capacity of the hardware as specified by the hardware manufacturer must be observed.

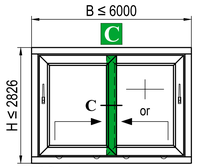
Glazing thickness	[mm]	d = ...	20	22	24	26	28	30	32	34	36	...
Theoretical pane weight	[kg/m²]	~ 2.5 x d = ...	50	55	60	65	70	75	80	85	90	...



Schema A/C/D/F

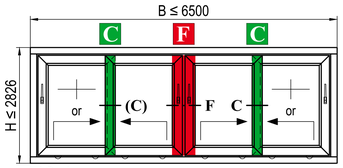


Schema A/D



☐ Sash
☐ Frame
according to Section:
C

Schema C/F



☐ Sash
☐ Frame
according to Section:
F < C or C < F

Schema A/D

	Ix [cm4]	Section	|F| Reinforcements
6	34cm4	C	= 2x |F| 229126
5	26cm4	C	= 2x |F| 279082
4	24cm4	C	= 2x |F| 229125
3	24cm4	C	= 2x |F| 229125
2	10cm4	C	= 2x |F| 229115
1	8cm4	C	= 2x |F| 229114

C ~ C = 1x |F| ...

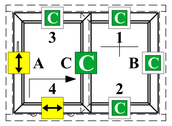
Schema C/F

	Ix [cm4]	Section	|F| Reinforcements
6	✕		
5	26cm4	C	= 2x |F| 279082 F = C
	26cm4	F	= 2x |F| 279082 !
4	24cm4	C	= 2x |F| 229125 C < F
	26cm4	F	= 2x |F| 279082 !
3	24cm4	C	= 2x |F| 229125 F < C
	12cm4	F	= 2x |F| 279036
2	10cm4	C	= 2x |F| 229115 C < F
	12cm4	F	= 2x |F| 279036
1	8cm4	C	= 2x |F| 229114 C < F
	12cm4	F	= 2x |F| 279036

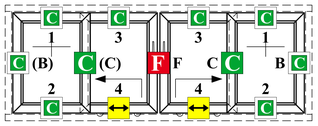
C ~ C = 1x |F| ...

|F| Reinforcements required
-> Sash = Section ...
vertical
↕ = 1x |F| ... C = 2x |F| ...
C ~ 1x |F| ...
horizontal
↔ = 1x |F| ... F = 2x |F| ...
-> Frame = Standard

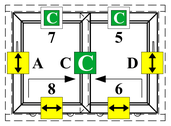
☐ Schema A



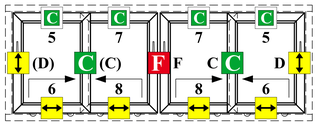
☐ Schema C



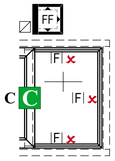
☐ Schema D



☐ Schema F



☐ FF



■ laminated
All information for laminated / coloured profiles only.

coloured

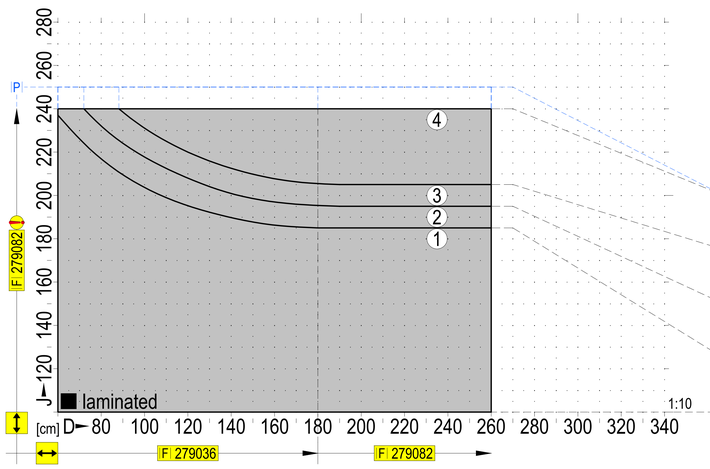
Option |P| aluskin Aluminium shells
⚠ ~ ■ coloured -> J + 10cm (≤ 2.50m) = |P| ---- Schema "v"

Resistance to wind load EN 12210

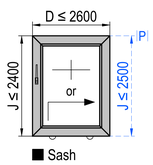
Class B2

Sash dimensions: The application diagrams show the relation between feasible sash widths and sash heights as a function of different glazing weights or overall glazing thicknesses, respectively. The thus resulting sash dimensions and sash formats (upright or horizontal format) - as well as the maximum sash weight - must not be exceeded. In addition, the maximum load bearing capacity of the hardware as specified by the hardware manufacturer must be observed.

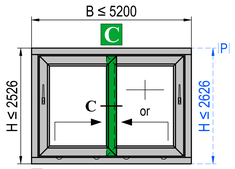
Glazing thickness	[mm]	d = ...	20	22	24	26	28	30	32	34	36	...
Theoretical pane weight	[kg/m²]	~ 2.5 x d = ...	50	55	60	65	70	75	80	85	90	...



Schema A/C/D/F

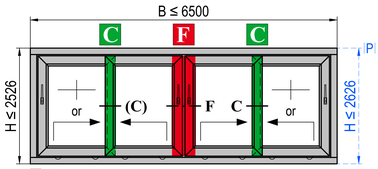


Schema A/D



■ Sash
■ Frame
according to Section:
C

Schema C/F



■ Sash
■ Frame
according to Section:
F < C or C < F

Schema A/D

	Ix [cm4]	Section	|F| Reinforcements
6	✕		
5	✕		
4	24cm4	C	= 2x |F| 229125
3	24cm4	C	= 2x |F| 229125
2	10cm4	C	= 2x |F| 229115
1	8cm4	C	= 2x |F| 229114

C ~ C = 1x |F| ...

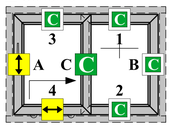
Schema C/F

	Ix [cm4]	Section	|F| Reinforcements
6	✕		
5	✕		
4	24cm4	C	= 2x |F| 229125 C < F
	26cm4	F	= 2x |F| 279082 !
3	24cm4	C	= 2x |F| 229125 F < C
	12cm4	F	= 2x |F| 279036
2	10cm4	C	= 2x |F| 229115 C < F
	12cm4	F	= 2x |F| 279036
1	8cm4	C	= 2x |F| 229114 C < F
	12cm4	F	= 2x |F| 279036

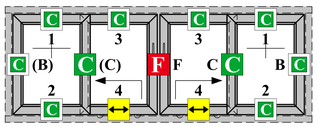
C ~ C = 1x |F| ...

|F| Reinforcements required
-> Sash = Section ...
vertical
↕ = 1x |F| ... C = 2x |F| ...
C ~ 1x |F| ...
horizontal
↔ = 1x |F| ... F = 2x |F| ...
-> Frame = Standard

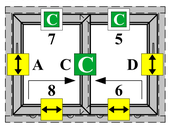
■ Schema A



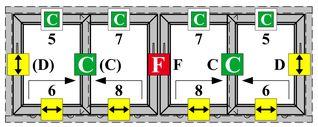
■ Schema C



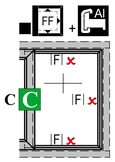
■ Schema D



■ Schema F

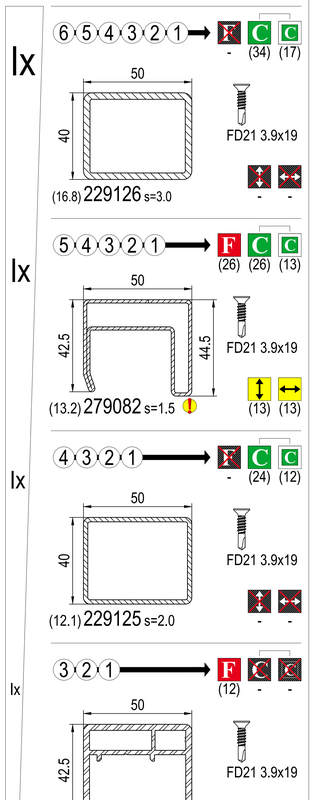


■ FF + ⚠

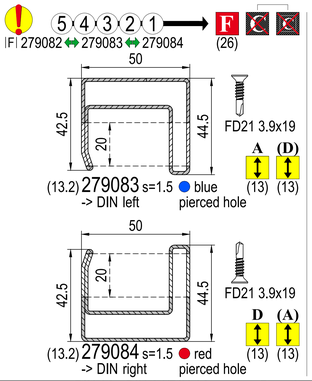


|F| Reinforcements ~ 1x ↕ 1x ↔ 2x F 2x C 1x C
(...) = Ix [cm4]

Ix



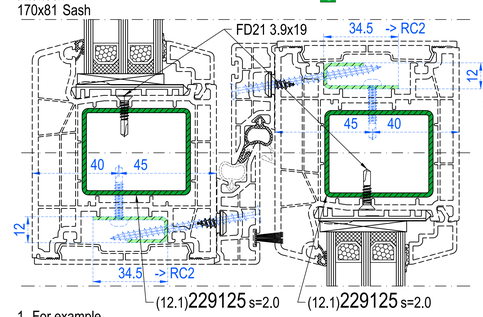
Ix



C For example in detail

Schema A/C/D/F
Section C
Interlock
170x81 Sash

Schema A/D
according to Section:
C



RC2
2x |F|
(0.9) 229015 s=1.5
+ 4.2x70 DIN 7982
+ FD1 3.9x25
☐ a= 300mm
■ a= 250mm
⚠ ... glued
➡ Test report
Ø 3.0
, ...

1. For example
Schema A/D

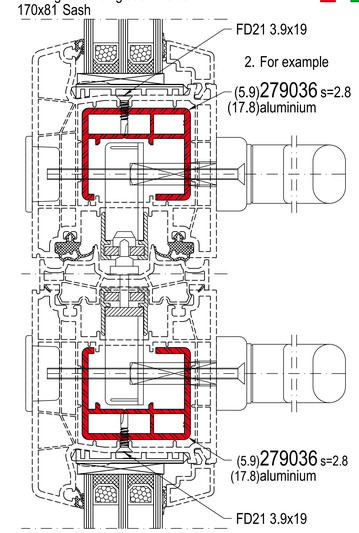
(12.1) + (12.1) = 24.2cm4 ~ 24cm4

≤ ④ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125 = ④

F For example in detail

Schema C/F
Section F
Meeting rail-Sliding sash-Inside
170x81 Sash

Schema C/F
according to Section:
F < C or C < F



2. For example
Schema C/F

(12.1) + (12.1) = 24.2cm4 ~ 24cm4 see 1. For example

~~④~~ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125
≤ ③ 12cm4 F = 2x |F| 279036 F < C = ③
(5.9) + (5.9) = 11.8cm4 ~ 12cm4

3. For example
Schema C/F

(12.1) + (12.1) = 24.2cm4 ~ 24cm4 see 1. For example

≤ ④ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125
~~⑤~~ 26cm4 F = 2x |F| 279082 ! C < F = ④
(13.2) + (13.2) = 26.4cm4 ~ 26cm4

chapter 09 Individual Handling
09 C Maximum Dimensions
page 01
Resistance to wind load EN 12210
Class B2
aluplast Kunststoff-Fenstersysteme
www.aluplast.net
Lift-and-slide door 85mm

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☐ not laminated
All information for white profiles only (no lamination, no colour).

white

Not with ... |P| aluskin ✕
⚠ ~ ■ coloured

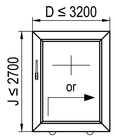
Resistance to wind load EN 12210

Class B3

Sash dimensions: The application diagrams show the relation between feasible sash widths and sash heights as a function of different glazing weights or overall glazing thicknesses, respectively. The thus resulting sash dimensions and sash formats (upright or horizontal format) - as well as the maximum sash weight - must not be exceeded. In addition, the maximum load bearing capacity of the hardware as specified by the hardware manufacturer must be observed.

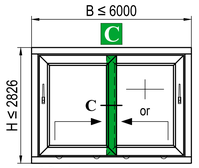
Glazing thickness	[mm]	d = ...	20	22	24	26	28	30	32	34	36	...
Theoretical pane weight	[kg/m²] ~ 2.5 x d = ...	50	55	60	65	70	75	80	85	90	...

Schema A/C/D/F



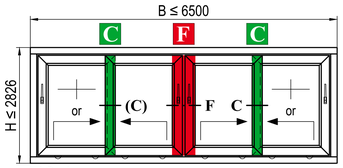
☐ Sash

Schema A/D

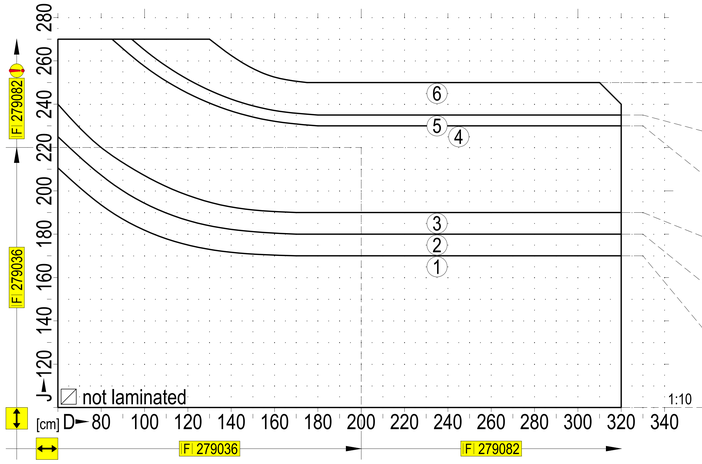


☐ Sash
☐ Frame
according to Section:
C

Schema C/F



☐ Sash
☐ Frame
according to Section:
F < C or C < F



Schema A/D

	Ix [cm4]	Section	|F| Reinforcements
6	34cm4	C	= 2x |F| 229126
5	26cm4	C	= 2x |F| 279082
4	24cm4	C	= 2x |F| 229125
3	24cm4	C	= 2x |F| 229125
2	10cm4	C	= 2x |F| 229115
1	8cm4	C	= 2x |F| 229114

C ~ C = 1x |F| ...

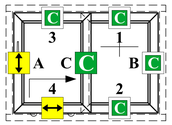
Schema C/F

	Ix [cm4]	Section	|F| Reinforcements
6	✕		
5	26cm4	C	= 2x |F| 279082 F = C
	26cm4	F	= 2x |F| 279082 ⚠
4	24cm4	C	= 2x |F| 229125 C < F
	26cm4	F	= 2x |F| 279082 ⚠
3	24cm4	C	= 2x |F| 229125 F < C
	12cm4	F	= 2x |F| 279036
2	10cm4	C	= 2x |F| 229115 C < F
	12cm4	F	= 2x |F| 279036
1	8cm4	C	= 2x |F| 229114 C < F
	12cm4	F	= 2x |F| 279036

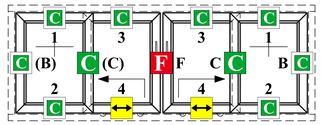
C ~ C = 1x |F| ...

|F| Reinforcements required
-> Sash = Section ...
vertical
↕ = 1x |F| ... C = 2x |F| ...
C ~ 1x |F| ...
horizontal
↔ = 1x |F| ... F = 2x |F| ...
-> Frame = Standard

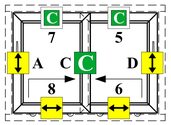
Schema A



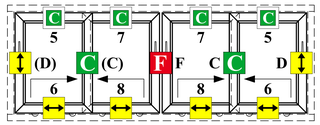
Schema C

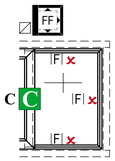


Schema D



Schema F





■ laminated
All information for laminated / coloured profiles only.

coloured ■

Option |P| aluskin Aluminium shells
⚠ ~ ■ coloured -> J + 10cm (≤ 2.50m) = |P| ---- Schema "v"

glue ⚠ Al

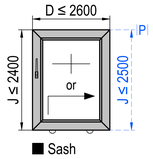
Resistance to wind load EN 12210

Class B3

Sash dimensions: The application diagrams show the relation between feasible sash widths and sash heights as a function of different glazing weights or overall glazing thicknesses, respectively. The thus resulting sash dimensions and sash formats (upright or horizontal format) - as well as the maximum sash weight - must not be exceeded. In addition, the maximum load bearing capacity of the hardware as specified by the hardware manufacturer must be observed.

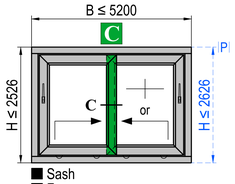
Glazing thickness	[mm]	d = ...	20	22	24	26	28	30	32	34	36	...
Theoretical pane weight	[kg/m²] ~ 2.5 x d = ...	50	55	60	65	70	75	80	85	90	...

Schema A/C/D/F



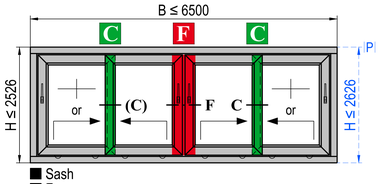
■ Sash

Schema A/D

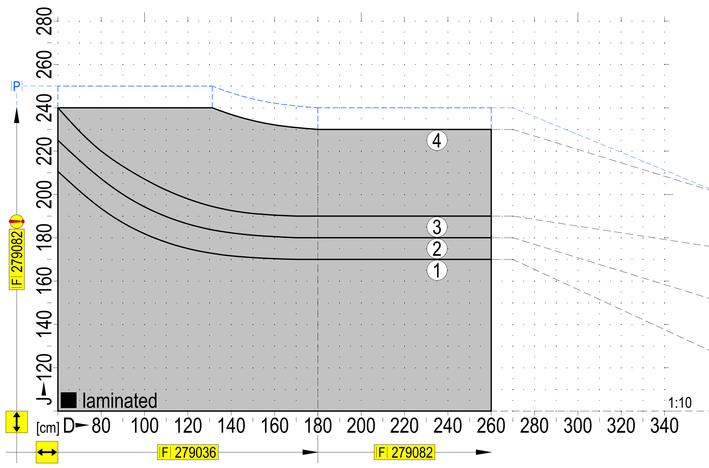


■ Sash
■ Frame
according to Section:
C

Schema C/F



■ Sash
■ Frame
according to Section:
F < C or C < F



Schema A/D

	Ix [cm4]	Section	|F| Reinforcements
6	✕		
5	✕		
4	24cm4	C	= 2x |F| 229125
3	24cm4	C	= 2x |F| 229125
2	10cm4	C	= 2x |F| 229115
1	8cm4	C	= 2x |F| 229114

C ~ C = 1x |F| ...

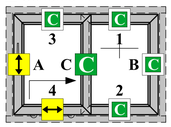
Schema C/F

	Ix [cm4]	Section	|F| Reinforcements
6	✕		
5	✕		
4	24cm4	C	= 2x |F| 229125 C < F
	26cm4	F	= 2x |F| 279082 ⚠
3	24cm4	C	= 2x |F| 229125 F < C
	12cm4	F	= 2x |F| 279036
2	10cm4	C	= 2x |F| 229115 C < F
	12cm4	F	= 2x |F| 279036
1	8cm4	C	= 2x |F| 229114 C < F
	12cm4	F	= 2x |F| 279036

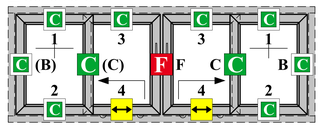
C ~ C = 1x |F| ...

|F| Reinforcements required
-> Sash = Section ...
vertical
↕ = 1x |F| ... C = 2x |F| ...
C ~ 1x |F| ...
horizontal
↔ = 1x |F| ... F = 2x |F| ...
-> Frame = Standard

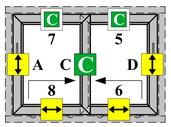
Schema A



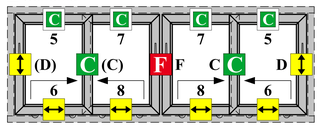
Schema C

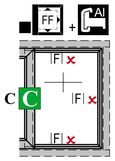


Schema D



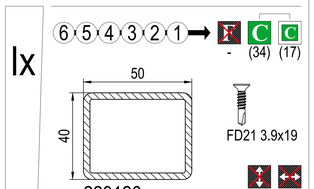
Schema F



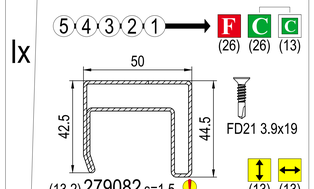


|F| Reinforcements ~ 1x ↕ 1x ↔ 2x F 2x C 1x C
(...) = Ix [cm4]

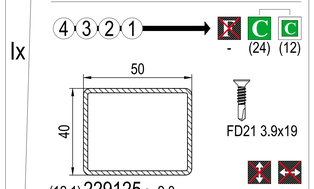
Ix



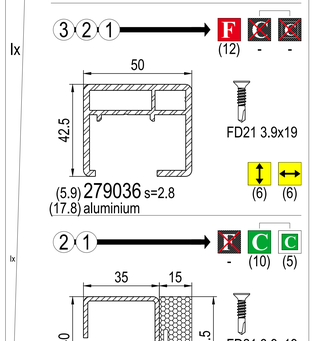
Ix



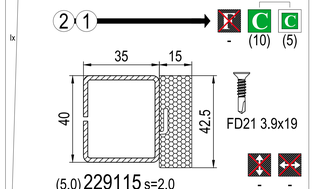
Ix

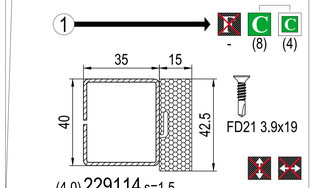


Ix



Ix



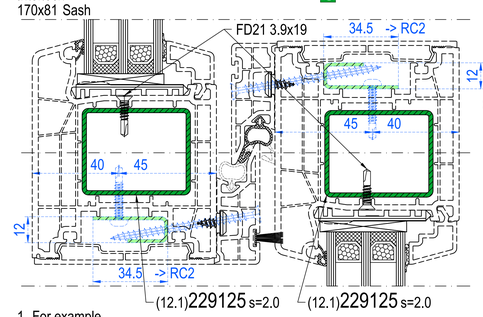


|F| 279082 ↔ 279083 ↔ 279084

C For example in detail

Schema A/C/D/F
Section C
Interlock
170x81 Sash

Schema A/D
according to Section:
C



1. For example
Schema A/D

(12.1) + (12.1) = 24.2cm4 ~ 24cm4

≤ ④ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125 = ④

F For example in detail

Schema C/F
Section F
Meeting rail-Sliding sash-Inside
170x81 Sash

Schema C/F
according to Section:
F < C or C < F

2. For example
Schema C/F

(12.1) + (12.1) = 24.2cm4 ~ 24cm4 see 1. For example

~~④~~ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125
≤ ③ 12cm4 F = 2x |F| 279036 F < C = ③
(5.9) + (5.9) = 11.8cm4 ~ 12cm4

3. For example
Schema C/F

(12.1) + (12.1) = 24.2cm4 ~ 24cm4 see 1. For example

≤ ④ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125
~~⑤~~ 26cm4 F = 2x |F| 279082 ⚠ C < F = ④
(13.2) + (13.2) = 26.4cm4 ~ 26cm4

chapter 09 Individual Handling
page 02

09 C Maximum Dimensions

Resistance to wind load EN 12210
Class B3

aluplast Kunststoff-Fenstersysteme
www.aluplast.net

Lift-and-slide door 85mm

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☐ not laminated

All information for white profiles only (no lamination, no colour).

white

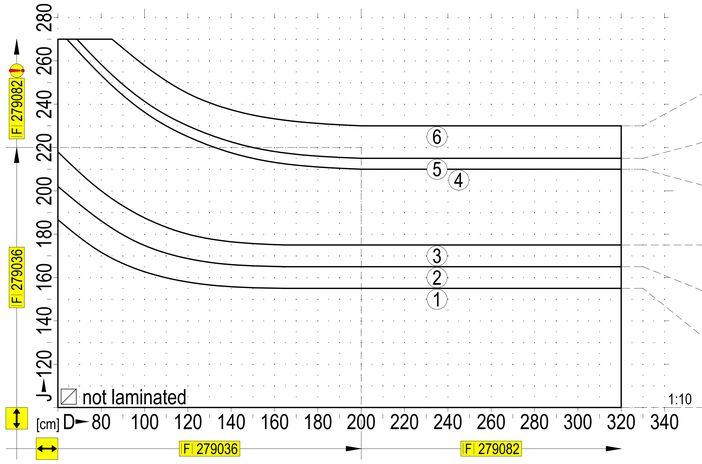
Not with ... |P| aluskin ✕ ⚠ ~ ■ coloured

Resistance to wind load EN 12210

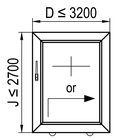
Class B4

Sash dimensions: The application diagrams show the relation between feasible sash widths and sash heights as a function of different glazing weights or overall glazing thicknesses, respectively. The thus resulting sash dimensions and sash formats (upright or horizontal format) - as well as the maximum sash weight - must not be exceeded. In addition, the maximum load bearing capacity of the hardware as specified by the hardware manufacturer must be observed.

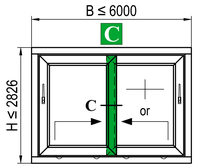
Glazing thickness	[mm]	d = ...	20	22	24	26	28	30	32	34	36	...
Theoretical pane weight	[kg/m²]	~ 2.5 x d = ...	50	55	60	65	70	75	80	85	90	...



Schema A/C/D/F

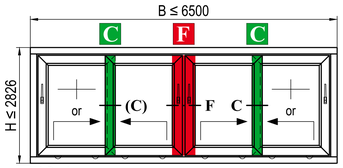


Schema A/D



☐ Sash
☐ Frame
according to Section: C

Schema C/F

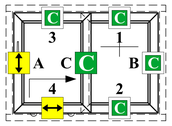


☐ Sash
☐ Frame
according to Section: F < C or C < F

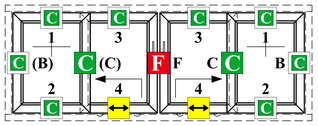
	Schema A/D Ix [cm4]	Section	|F| Reinforcements	Schema C/F Ix [cm4]	Section	|F| Reinforcements
6	34cm4	C	= 2x |F| 229126	6	✕	
5	26cm4	C	= 2x |F| 279082	5	26cm4	C = 2x |F| 279082 F = C
					26cm4	F = 2x |F| 279082 !
4	24cm4	C	= 2x |F| 229125	4	24cm4	C = 2x |F| 229125 C < F
					26cm4	F = 2x |F| 279082 !
3	24cm4	C	= 2x |F| 229125	3	24cm4	C = 2x |F| 229125 F < C
					12cm4	F = 2x |F| 279036
2	10cm4	C	= 2x |F| 229115	2	10cm4	C = 2x |F| 229115 C < F
					12cm4	F = 2x |F| 279036
1	8cm4	C	= 2x |F| 229114	1	8cm4	C = 2x |F| 229114 C < F
					12cm4	F = 2x |F| 279036
	C ~ C		= 1x |F| ...		C ~ C	= 1x |F| ...

|F| Reinforcements required
-> Sash = Section ...
vertical
↕ = 1x |F| ... C = 2x |F| ...
C ~ 1x |F| ...
horizontal
↔ = 1x |F| ... F = 2x |F| ...
-> Frame = Standard

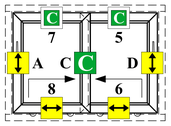
☐ Schema A



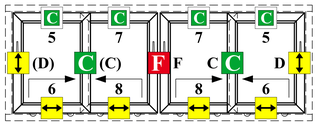
☐ Schema C



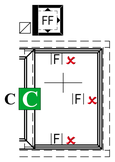
☐ Schema D



☐ Schema F



☐ FF



■ laminated

All information for laminated / coloured profiles only.

coloured ■

Option |P| aluskin Aluminium shells ⚠ ~ ■ coloured -> J + 10cm (≤ 2.50m) = |P| ---- Schema "v"

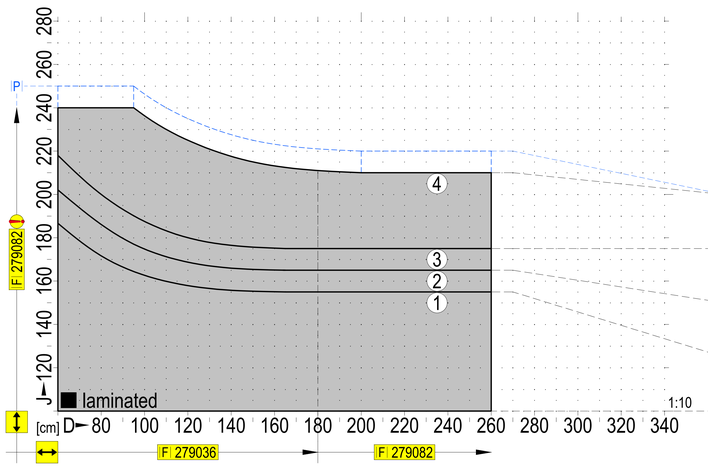
glue ⚠ Al

Resistance to wind load EN 12210

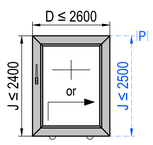
Class B4

Sash dimensions: The application diagrams show the relation between feasible sash widths and sash heights as a function of different glazing weights or overall glazing thicknesses, respectively. The thus resulting sash dimensions and sash formats (upright or horizontal format) - as well as the maximum sash weight - must not be exceeded. In addition, the maximum load bearing capacity of the hardware as specified by the hardware manufacturer must be observed.

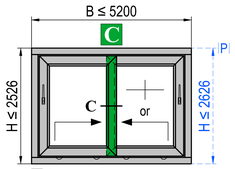
Glazing thickness	[mm]	d = ...	20	22	24	26	28	30	32	34	36	...
Theoretical pane weight	[kg/m²]	~ 2.5 x d = ...	50	55	60	65	70	75	80	85	90	...



Schema A/C/D/F

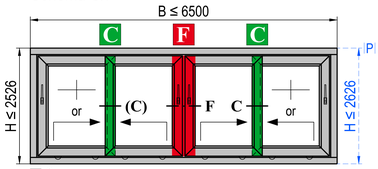


Schema A/D



■ Sash
■ Frame
according to Section: C

Schema C/F

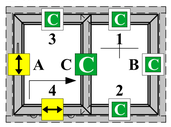


■ Sash
■ Frame
according to Section: F < C or C < F

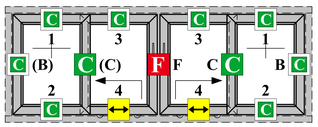
	Schema A/D Ix [cm4]	Section	|F| Reinforcements	Schema C/F Ix [cm4]	Section	|F| Reinforcements
6	✕			6	✕	
5	✕			5	✕	
4	24cm4	C	= 2x |F| 229125	4	24cm4	C = 2x |F| 229125 C < F
					26cm4	F = 2x |F| 279082 !
3	24cm4	C	= 2x |F| 229125	3	24cm4	C = 2x |F| 229125 F < C
					12cm4	F = 2x |F| 279036
2	10cm4	C	= 2x |F| 229115	2	10cm4	C = 2x |F| 229115 C < F
					12cm4	F = 2x |F| 279036
1	8cm4	C	= 2x |F| 229114	1	8cm4	C = 2x |F| 229114 C < F
					12cm4	F = 2x |F| 279036
	C ~ C		= 1x |F| ...		C ~ C	= 1x |F| ...

|F| Reinforcements required
-> Sash = Section ...
vertical
↕ = 1x |F| ... C = 2x |F| ...
C ~ 1x |F| ...
horizontal
↔ = 1x |F| ... F = 2x |F| ...
-> Frame = Standard

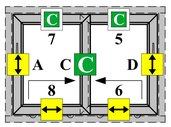
■ Schema A



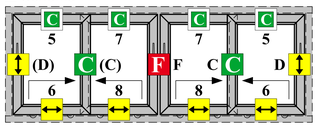
■ Schema C



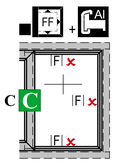
■ Schema D



■ Schema F

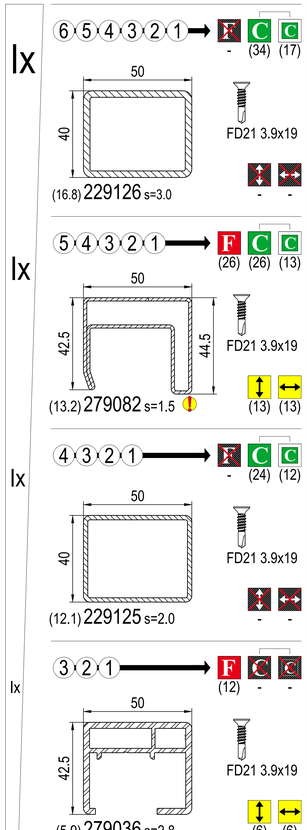


■ FF + Al



|F| Reinforcements ~ 1x ↕ 1x ↔ 2x F 2x C 1x C (...) = Ix [cm4]

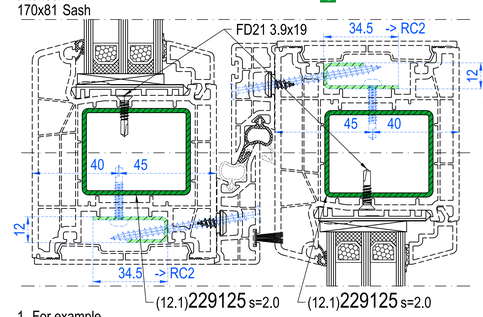
Ix



C For example in detail

Schema A/C/D/F
Section C
Interlock
170x81 Sash

Schema A/D
according to Section: C



RC2
2x |F|
(0.9) 229015 s=1.5
+ 4.2x70 DIN 7982
+ FD1 3.9x25
☐ a= 300mm
■ a= 250mm
⚠ ... glued
➡ Test report

1. For example
Schema A/D

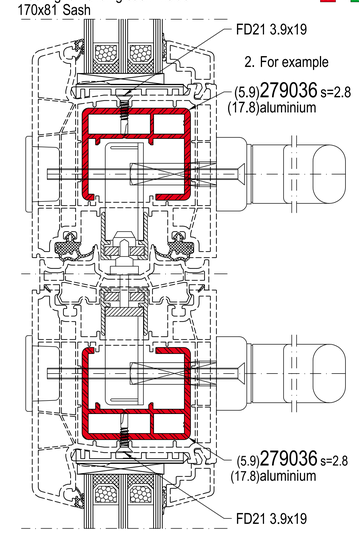
(12.1) + (12.1) = 24.2cm4 ~ 24cm4

≤ (4) 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125 = (4)

F For example in detail

Schema C/F
Section F
Meeting rail-Sliding sash-Inside
170x81 Sash

Schema C/F
according to Section: F < C or C < F



2. For example
Schema C/F

(12.1) + (12.1) = 24.2cm4 ~ 24cm4 see 1. For example

~~4~~ 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125
≤ (3) 12cm4 F = 2x |F| 279036
(5.9) + (5.9) = 11.8cm4 ~ 12cm4

F < C = (3)

3. For example
Schema C/F

(12.1) + (12.1) = 24.2cm4 ~ 24cm4 see 1. For example

≤ (4) 24cm4 C = 2x |F| 229125 ~ C = 1x |F| 229125
~~5~~ 26cm4 F = 2x |F| 279082 !
(13.2) + (13.2) = 26.4cm4 ~ 26cm4

C < F = (4)

chapter 09 Individual Handling
09 C Maximum Dimensions
page 03
Resistance to wind load EN 12210
Class B4
aluplast Kunststoff-Fenstersysteme
www.aluplast.net
Lift-and-slide door 85mm

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09 M Drainage and Air Equalisation in the Glazing Rebate

ATTENTION: Do not damage the wall of the reinforcement chamber when drilling or milling the drainage and air equalisation openings!

09 M 1. (1) and (2): Drainage

Water is drained from fixed sashes and sliding sashes through milled slots; alternatively, water is drained to the bottom and front through drill holes.

(1) In the rebate, the distance from the openings to the inner corners shall be about 50 mm; the distance from one opening to the other shall be 700 mm or less. The drain slots in the rebate shall amount to at least 5x25 mm. The openings in the glazing rebate must not be covered by glazing packers or compensating blocks.

(2) To the outside, drain 2x per window field. Water is drained either through concealed drainage to the bottom or through visible face drainage to the front. The drainage openings must be milled/drilled in an offset pattern, 50 mm recessed to the rebate opening. The distance from one drainage opening to the other must not exceed 900 mm. The standard drainage opening is a drain slot of 5x25mm. Alternatively, the openings to the outside and to the front can be drilled with a minimum drill diameter of ø10mm.

When aluminium shells are used, concealed drainage to the bottom is recommended.

09 M 2. (3) and (4): Pressure equalisation openings for buildings in exposed positions

Information: In lift-and-slide doors, (7) fulfils the function of (3), and (8) fulfils the function of (4).

09 M 3. (5) to (8): Air equalisation with glazing

Information: In lift-and-slide doors, (1) fulfils the function of (5), and (2) fulfils the function of (6).

(5) and (7) Glazing rebates must be ventilated adequately via two openings both in the bottom (5) and in the (7) top traverse according to the guidelines of the insulated glass manufacturer. The slots for air equalisation (min. 5x20 mm) must be milled at a distance of approx. 50 mm to the inner corner. The openings in the glazing rebate must not be covered by glazing packers or compensating blocks.

(6) and (8) Air equalisation to the outside is realised via the front chamber of the sash either through drill holes (min. diameter ø8mm) approx. 50 mm recessed to the rebate opening or via slots 5x20 mm.

In lift-and-slide doors, for (7-8), the lip of the gasket in fixed sashes and sliding sashes can alternatively be cut out over a length of 50 mm in the two upper corners at a distance of 100 mm from the mitre corner.

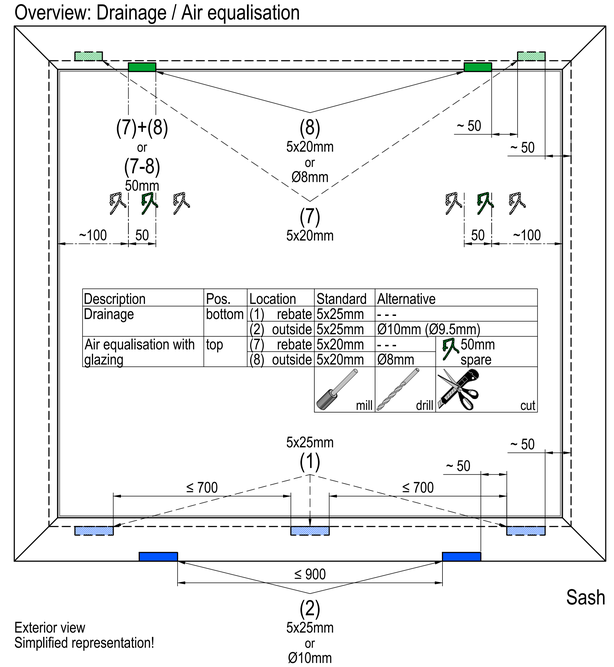
When aluminium shells are used, it is recommended to cut out the gasket for air equalisation.

09 M 4. Additional air equalisation in laminated, lacquered or solid-coloured profiles

In the case of laminated (decor), lacquered or solid-coloured profiles, additional drill holes for air equalisation in the chambers are required.

Refer to chapter 09 N Lamination and Colour: Coloured Profiles.

Overview: Drainage / Air equalisation



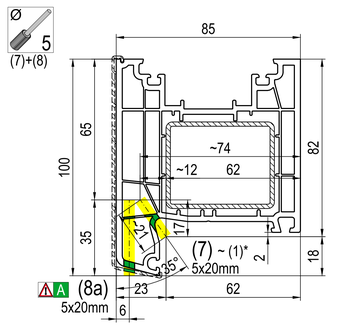
Description	Pos.	Location	Standard	Alternative
Drainage	bottom	(1) rebate	5x25mm	- - -
		(2) outside	5x25mm	Ø10mm (Ø9.5mm)
Air equalisation with glazing	top	(7) rebate	5x20mm	- - - / 50mm spare
		(8) outside	5x20mm	Ø8mm / mill, drill, cut

Exterior view
Simplified representation!

☐ not laminated
■ laminated
In the case of laminated (decor), lacquered or solid-coloured profiles, additional drill holes for air equalisation in the chambers are required!
Refer to chapter 09 N Lamination and Colour: Coloured Profiles.

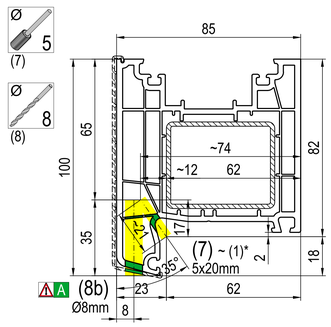
Profile processing — Sash 170x81

Standard top without aluskin / **Alternative top** with aluskin



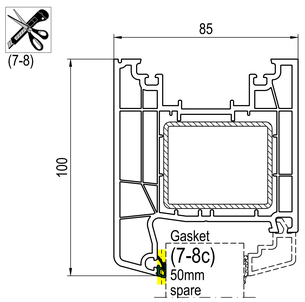
* Axis (7) = Axis (1)

Alternative top without / with aluskin

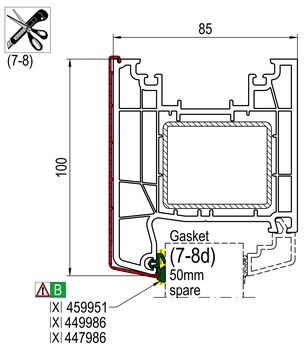


* Axis (7) = Axis (1)

Alternative top without aluskin



Standard top with aluskin



A B C D
NOTE
aluskin (aluminium shell)

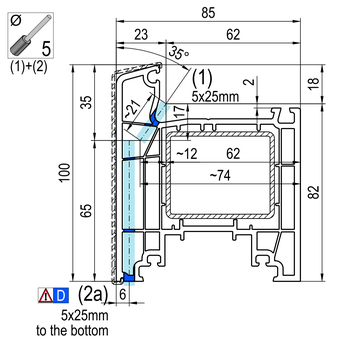
A Air equalisation outside/top (8a) or (8b):
The slots / holes leading to the outside are milled / drilled after the aluminium shells have been mounted. Mill / drill directly through the already mounted aluminium shell.

B We recommend air equalisation outside/top by means of cutting out the gasket over a length of 50 mm (7-8d).

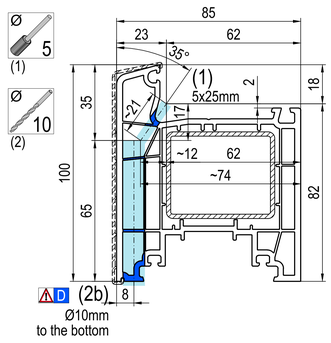
C Drainage outside/bottom + to the front (2c):
Water from the inside must not enter the space between aluminium shell and PVC profile. For this reason use a suitable pre-compressed sealing tape or silicone rubber in the area of the drain slot / drill hole. The slots / holes leading to the outside are therefore milled / drilled after sealing and after the aluminium shells have been mounted. Mill / drill directly through the sealed and already mounted aluminium shell.

D When aluminium shells are used, we recommend drainage outside/bottom + to the bottom (2a) or (2b).

Standard bottom without / with aluskin

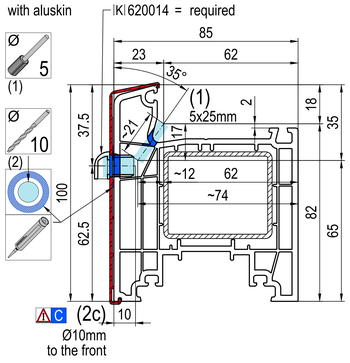


Alternative bottom without / with aluskin



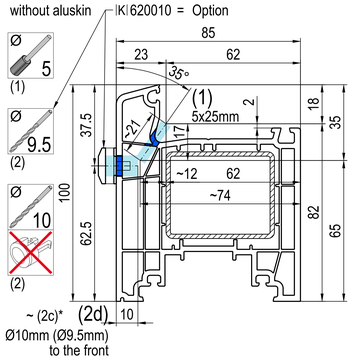
Alternative bottom with aluskin

K 620014 = required



Alternative bottom without aluskin

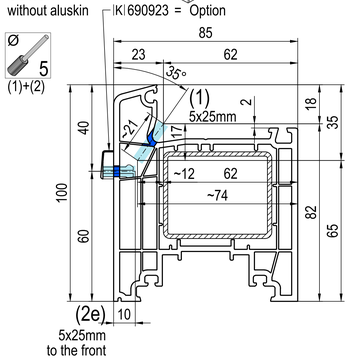
K 620010 = Option



* Axis (2d) = Axis (2c)

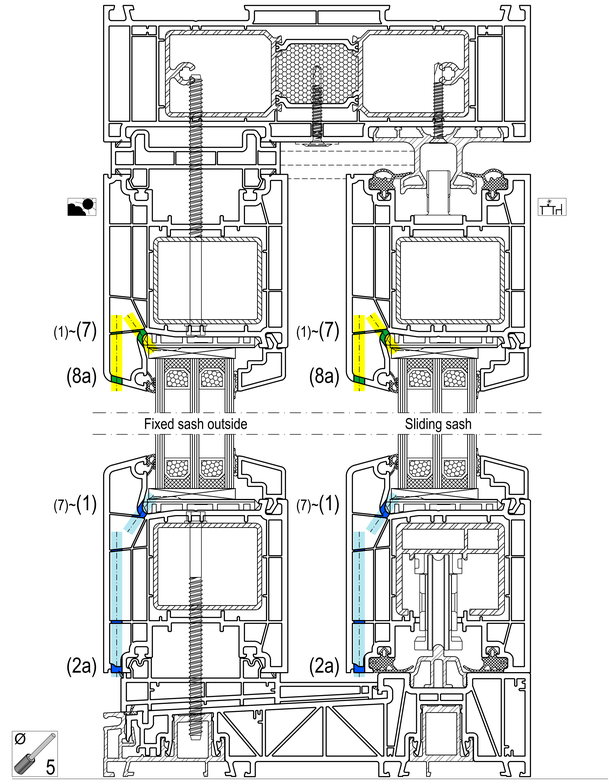
Alternative bottom without aluskin

K 690923 = Option



Example: Standard — Sash 170x81

☐ not laminated
without aluskin



chapter 09 Individual Handling — page 01

09 M Drainage / Air Equalisation

170x81 Sash

aluplast Kunststoff-Fensersysteme

www.aluplast.net — Lift-and-slide door 85mm

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09 M Drainage and Air Equalisation in the Glazing Rebate

ATTENTION: Do not damage the wall of the reinforcement chamber when drilling or milling the drainage and air equalisation openings!

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Water is drained from fixed sashes and sliding sashes through milled slots; alternatively, water is drained to the bottom and front through drill holes.

(1) In the rebate, the distance from the openings to the inner corners shall be about 50 mm; the distance from one opening to the other shall be 700 mm or less. The drain slots in the rebate shall amount to at least 5x25 mm. The openings in the glazing rebate must not be covered by glazing packers or compensating blocks.

(2) To the outside, drain 2x per window field. Water is drained either through concealed drainage to the bottom or through visible face drainage to the front. The drainage openings must be milled/drilled in an offset pattern, 50 mm recessed to the rebate opening. The distance from one drainage opening to the other must not exceed 900 mm. The standard drainage opening is a drain slot of 5x25mm. Alternatively, the openings to the outside and to the front can be drilled with a minimum drill diameter of ø10mm.

When aluminium shells are used, concealed drainage to the bottom is recommended.

09 M 2. (3) and (4): Pressure equalisation openings for buildings in exposed positions

Information: In lift-and-slide doors, (7) fulfils the function of (3), and (8) fulfils the function of (4).

09 M 3. (5) to (8): Air equalisation with glazing

Information: In lift-and-slide doors, (1) fulfils the function of (5), and (2) fulfils the function of (6).

(5) and (7) Glazing rebates must be ventilated adequately via two openings both in the bottom (5) and in the (7) top traverse according to the guidelines of the insulated glass manufacturer. The slots for air equalisation (min. 5x20 mm) must be milled at a distance of approx. 50 mm to the inner corner. The openings in the glazing rebate must not be covered by glazing packers or compensating blocks.

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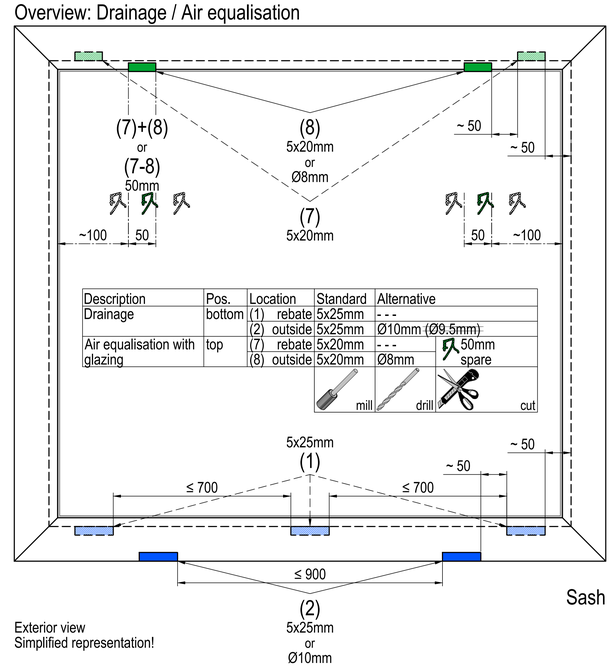
When aluminium shells are used, it is recommended to cut out the gasket for air equalisation.

09 M 4. Additional air equalisation in laminated, lacquered or solid-coloured profiles

In the case of laminated (decor), lacquered or solid-coloured profiles, additional drill holes for air equalisation in the chambers are required.

Refer to chapter 09 N Lamination and Colour: Coloured Profiles.

Overview: Drainage / Air equalisation



Description	Pos.	Location	Standard	Alternative
Drainage	bottom	(1) rebate	5x25mm	- - -
		(2) outside	5x25mm	Ø10mm (Ø9.5mm)
Air equalisation with glazing	top	(7) rebate	5x20mm	- - - / 50mm spare
		(8) outside	5x20mm	Ø8mm

mill drill cut

not laminated
laminated
In the case of laminated (decor), lacquered or solid-coloured profiles, additional drill holes for air equalisation in the chambers are required!
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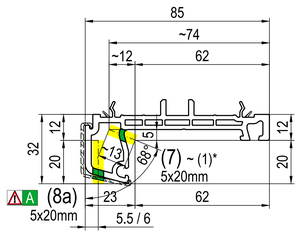
Profile processing — Sash - FF fixframe 170082

Standard top without aluskin — **Alternative top** with aluskin

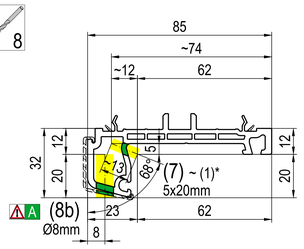
Ø 5 (7)+(8)



* Axis (7) = Axis (1)

Alternative top without / with aluskin

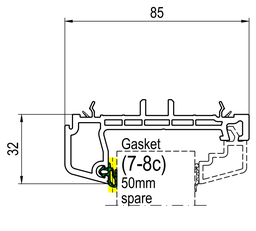
Ø 5 (7)
Ø 8 (8)



* Axis (7) = Axis (1)

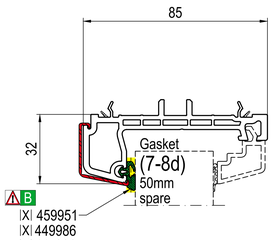
Alternative top without aluskin

(7-8)



Standard top with aluskin

(7-8)



A B C D

NOTE
aluskin (aluminium shell)

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B We recommend air equalisation outside/top by means of cutting out the gasket over a length of 50 mm (7-8d).

C Drainage outside/bottom + to the front (2c):
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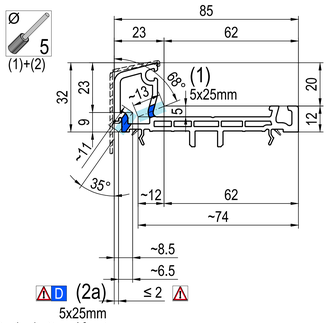
D When aluminium shells are used, we recommend drainage outside/bottom + to the bottom (2a) or (2b).

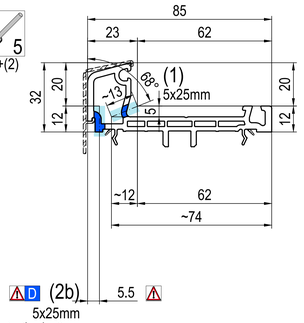
Standard bottom without / with aluskin

Ø 5 (1)+(2)



Alternative bottom without / with aluskin

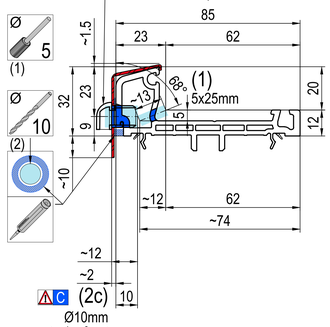
Ø 5 (1)+(2)



Alternative bottom with aluskin

K 620014 = required

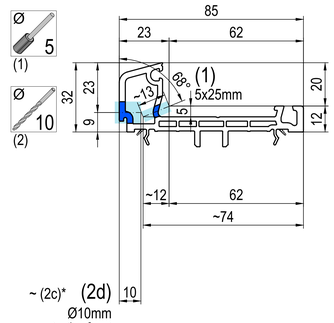
Ø 5 (1)
Ø 10 (2)



Alternative bottom without aluskin

K 620010

Ø 5 (1)
Ø 10 (2)

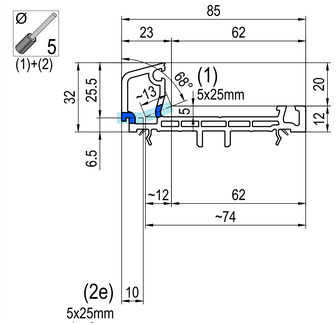


* Axis (2d) = Axis (2c)

Alternative bottom without aluskin

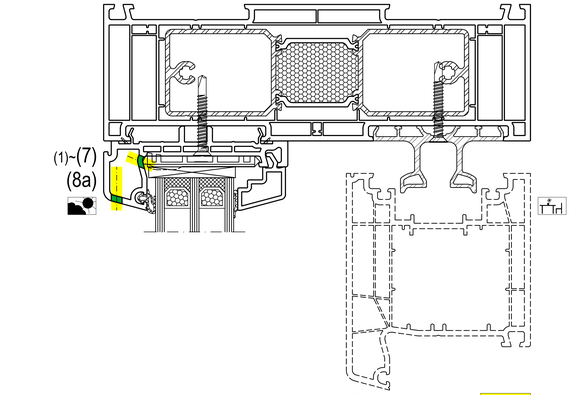
K 690923

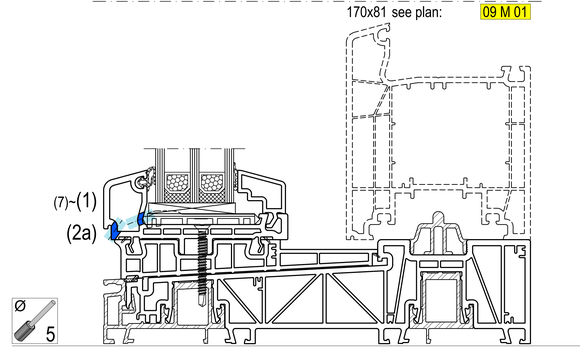
Ø 5 (1)+(2)



Example: Standard — Sash - FF fixframe 170082

not laminated
without aluskin





chapter 09 Individual Handling — page 02

09 M Drainage / Air Equalisation

170082 Sash

FF fixframe

Lift-and-slide door 85mm

aluplast Kunststoff-Fenstersysteme

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The present installation guidelines complement the manual “General Handling” that contains further processing and installation instructions. Observe these instructions on any account, even if they are not referred to explicitly in the present manual, or if the individual chapters or sub-chapters are not mentioned explicitly.

09 N Lamination and Colours: Coloured Profiles

09 N 1.	**General Information**	See manual “General Handling”, chapter 08 K 1.
09 N 2.	**Colours**	See manual “General Handling”, chapter 08 K 2.
09 N 3.	**Area of application**	See manual “General Handling”, chapter 08 K 3.
09 N 4.	**Regional restrictions**	See manual “General Handling”, chapter 08 K 4.
09 N 5.	**Protection of surfaces**	See manual “General Handling”, chapter 08 K 5.
09 N 6.	**Handling advices**	See manual “General Handling”, chapter 08 K 6.

09 N 6.7. Air equalisation openings of exterior chambers

Dark profiles absorb more heat (e.g. due to solar radiation) than white profiles. The surface temperature on the (exterior) weather side of laminated profiles – and accordingly also the temperature in the thermally insulating outer chambers – can increase to over 75 °C under extreme conditions. The immense heat can cause an excessive pressure in the outer chamber which may deform the profile wall.

Drainage and air equalisation openings must always be provided. For the corresponding handling instructions please refer to chapter 09 M Drainage / Air equalisation.

In addition, the outermost chambers of all coloured main and additional profiles must be provided with at least 2 air equalisation drill holes per profile length. The holes shall have a min. diameter of Ø5.0mm. This applies independent of size and both to vertical and horizontal profiles, unless the outermost chambers are already drained or ventilated directly through holes / slots or indirectly through end caps or connecting profiles.

It is advisable that the air equalisation openings are still accessible after glazing and after the installation of the door.

IMPORTANT: Do not damage the wall of the reinforcement chamber when drilling or milling the drainage and air equalisation openings!

09 N 6.8. Fastening of coloured clip profiles

Fasten all clip profiles (e.g. weather bars) every 150 mm.

In addition, the side exposed to sunlight must be glued (see chapter 09 N 6.9.) to avoid distortion and warping in the clip area.

09 N 6.9. Bonding of uPVC profiles on lamination foils (laminated elements)

The lamination foil presents different material properties than PVC! For this reason, do not use standard PVC-adhesives but only adhesive agents suitable for lamination foils when processing laminated elements.

According to the statements and technical information given by the manufacturer Weiss Chemie + Technik GmbH & Co.KG, the product COSMOPLAST 515 is suitable for this purpose.

For copyright reasons, further technical information must not be given in the present manual. Please contact the manufacturer directly for up-to-date technical information on COSMOPLAST 515:

Weiss Chemie + Technik GmbH & Co.KG
Geschäftsbereich Chemie
Hansastraße 2
D-35708 Haiger

Phone: +49 (0)2773/815-0
Fax +49 (0)2773/815-200
E-mail: ch@weiss-chemie.de
http://www.weiss-chemie.de

09 N 7.	**Cleaning and Care**	See manual “General Handling”, chapter 08 K 7.
09 N 8.	**Adhesion of Sealants**	

Laminated surfaces must not come into contact with Thiokol rubber sealants (PVC-adhesives etc.).

Check the compatibility of the sealant and the lamination materials. For the required information see the manufacturer’s handling guidelines.

09 N 9.	**Element Installation**	See manual "General Handling”, chapter 08 K 9.
09 N 10.	**Connection Joints**	See manual “General Handling”, chapter 08 K 10.
09 N 11.	**Fabrication of Arched Profiles**	See manual “General Handling”, chapter 08 K 11.
09 N 12.	**(Residential) Doors**	See manual “General Handling”, chapter 08 K 12.
09 N 13.	**Notes**	See manual “General Handling”, chapter 08 K 13.

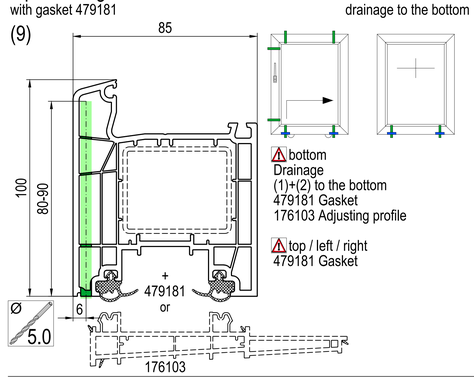
Note: In this chapter, the standard item numbers are complemented with xxx to indicate the item number of laminated decor profiles.
For the actual item number of laminated decor profiles, please refer to the valid price list!

Profile processing

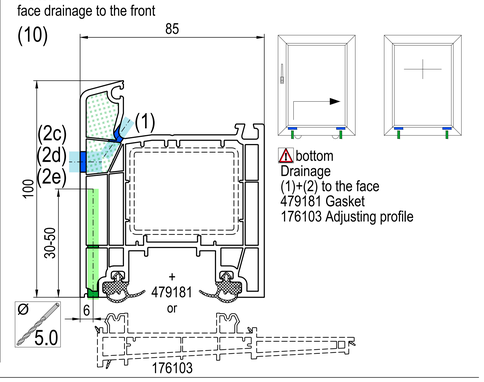
Sash 170x81xxx

■ laminated
Fixed sashes and sliding sashes must always be provided with openings for drainage (1) to (2), and air equalisation (3) to (8)! Please refer to chapter 09 M Drainage / Air Equalisation.

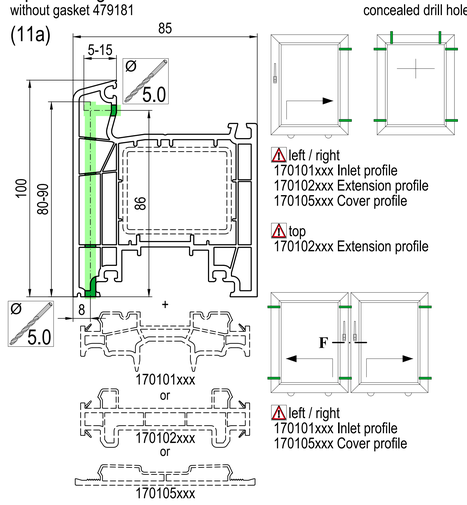
top / left / right — with gasket 479181 — bottom — drainage to the bottom



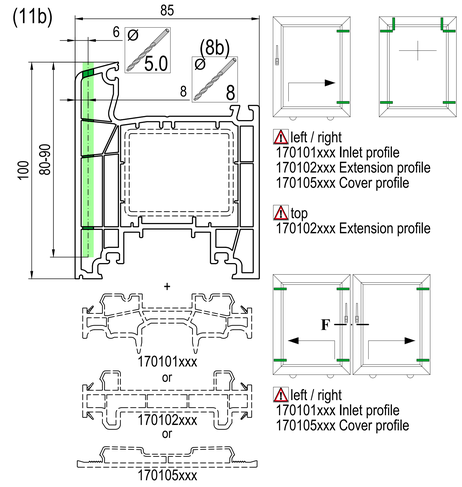
bottom — face drainage to the front



top / left / right — without gasket 479181 — concealed drill hole



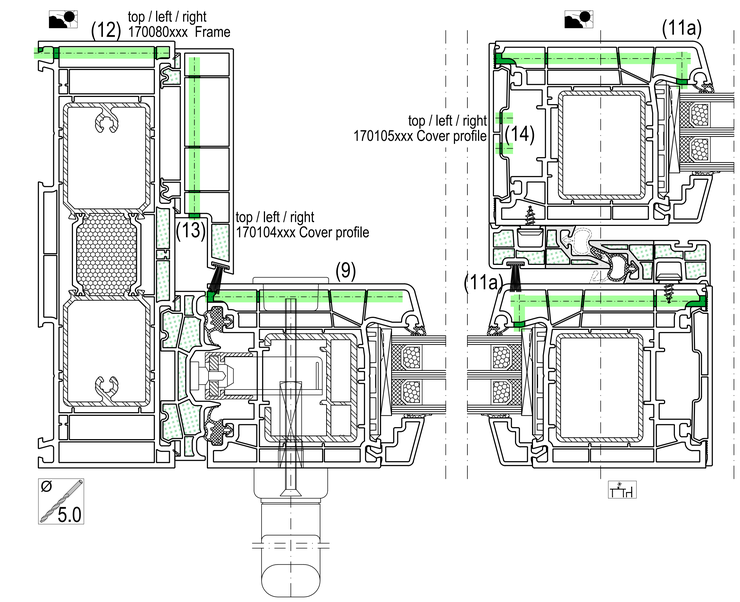
visible drill hole



Examples top / left / right

Sash
Frame

■ laminated
without aluskin

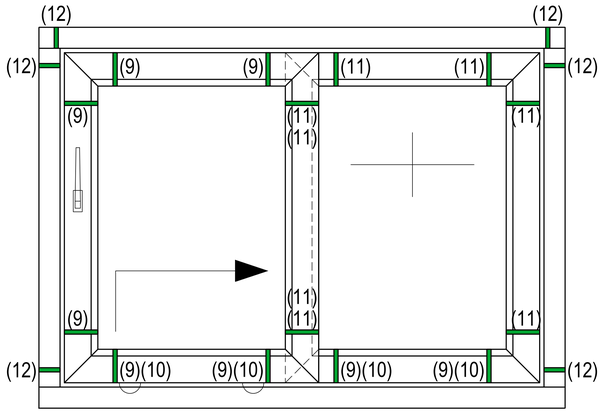


□ indirectly ventilated (e.g. through end caps or connecting profiles), or low expected solar radiation

Overview: Air Equalisation of Decor Profiles

The outermost chambers of all coloured main and additional profiles must be provided with at least 2 additional air equalisation drill holes per vertical and horizontal profile length. The holes shall have a min. diameter of Ø5.0mm. This applies unless the outermost chambers are already drained or ventilated sufficiently.

The depicted openings (9)... are examples only that are not intended to be exhaustive. Other coloured profiles shall be ventilated accordingly unless indirect air equalisation is guaranteed through e.g. end caps or connecting profiles!



Sash
Frame

Interior view
Simplified representation!

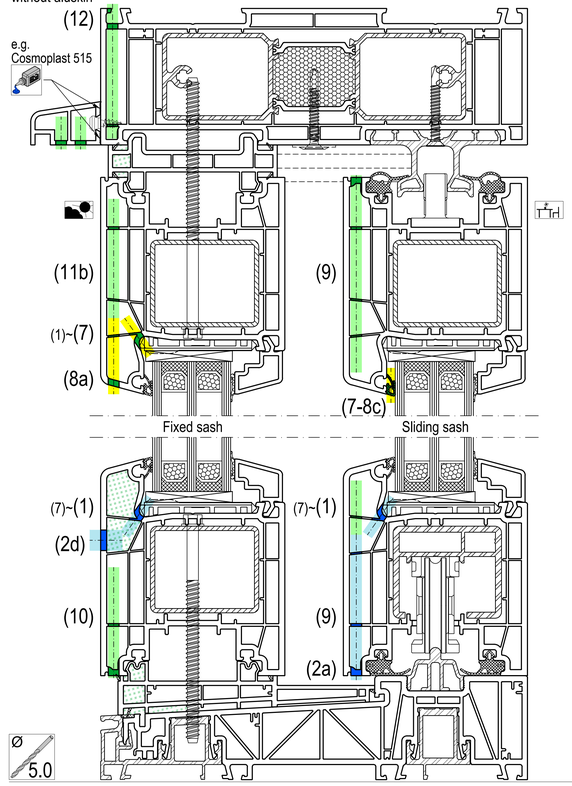
Basic drainage and air equalisation is not represented!

▨ not laminated
■ laminated
Fixed sashes and sliding sashes must always be provided with openings for drainage (1) to (2), and air equalisation (3) to (8)!
Please refer to chapter 09 M Drainage / Air Equalisation.

Examples top / bottom

Sash
Frame

■ laminated
without aluskin



chapter 09 Individual Handling — page
09 N Lamination and Colours — 01

aluplast Kunststoff-Fenstersysteme
www.aluplast.net — Lift-and-slide door 85mm

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Schema A/D or Schema C/F

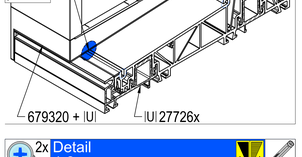
Important
2x as represented;
1x as represented + 1x mirror-inverted

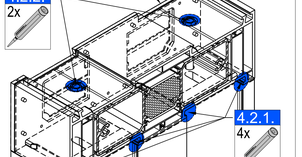
1. Cutting 1.1. - 1.4.
Circular saw blade -> uPVC / aluminium
Circular saw blade -> GRP
Cutting
Knife

2. Drilling / Milling 2.1. - 2.6.
670918 Drilling jig ->670380, 679320
Drill Ø
Milling cutter Ø 6.5 2)

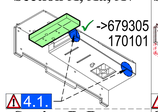
3. Assembly 3.1. - 3.6.
ATTENTION: In parts Sealing and Assembly 4.
Screws
8x 6.3x115mm 2)
18x Spax 4.0x30mm ->27726x
10x Spax 4.0x30mm ->27716x

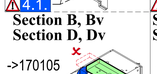
4. Sealing / Gluing 4.1. - 4.2.
Silicone rubber = =

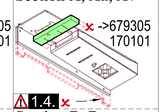
2x **Detail 2-2** Ø 6.5
Section 10 Drilling jig 670918


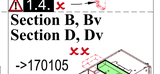
2x **Detail 2-4** Ø 6.5
Section 9 Drilling jig 670918


(...) = Ø12<>Ø18 2)
Blind hole in the PVC, only at top 2)

Detail 3-1 Z 679320
4.1. U 27726x


Section A, Aa, Av
4.1.


Section B, Bv Section D, Dv
4.1.
1.4. U 27716x


Section A, Aa, Av
1.4.


Section B, Bv Section D, Dv
1.4.

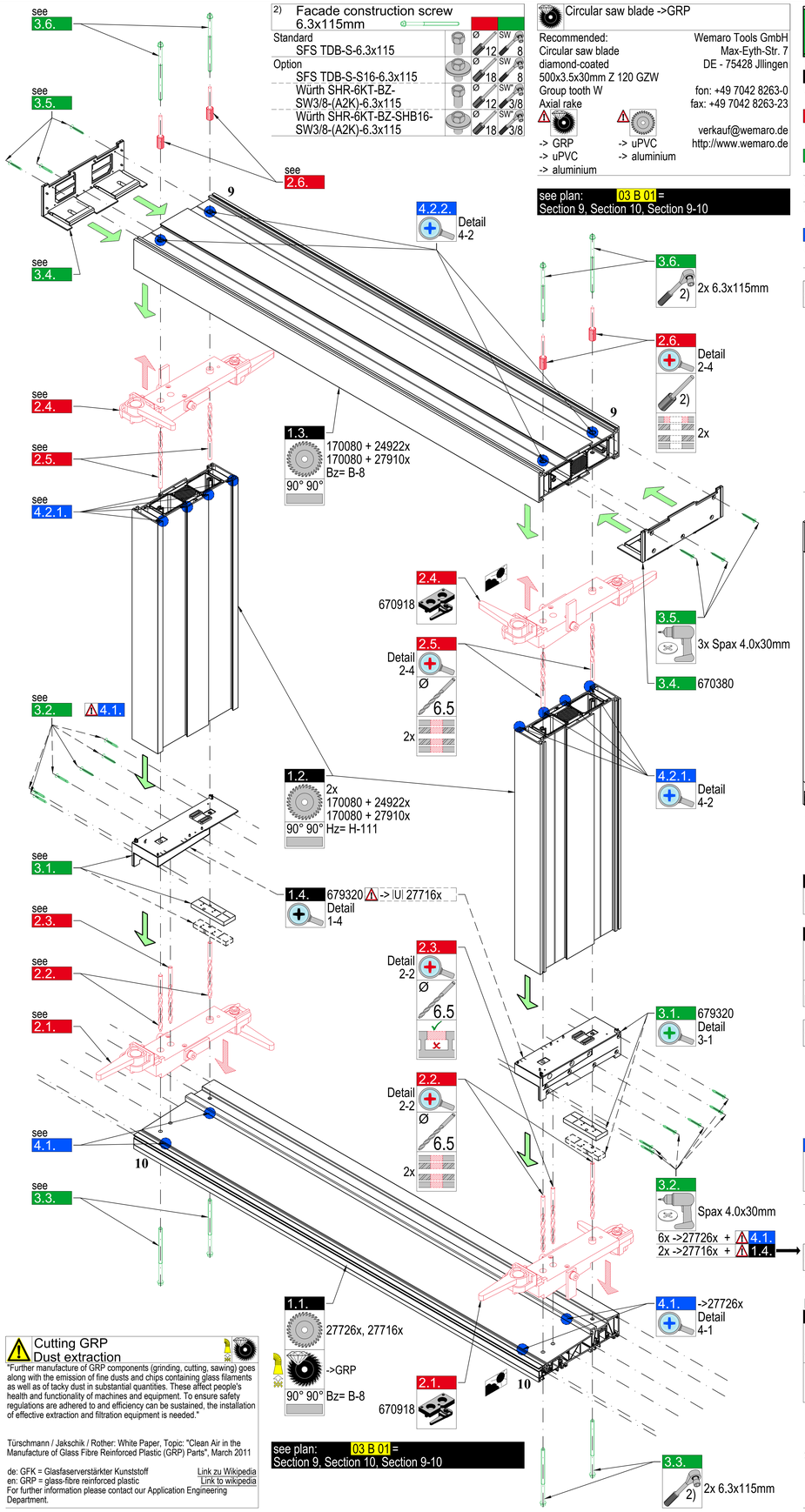
2x **Detail 4-1**

2x **Detail 4-2**

Cutting GRP Dust extraction
"Further manufacture of GRP components (grinding, cutting, sawing) goes along with the emission of fine dusts and chips containing glass filaments as well as of tacky dust in substantial quantities. These affect people's health and functionality of machines and equipment. To ensure safety regulations are adhered to and efficiency can be sustained, the installation of effective extraction and filtration equipment is needed."

Türschmann / Jakschik / Rother: White Paper, Topic: "Clean Air in the Manufacture of Glass Fibre Reinforced Plastic (GRP) Parts", March 2011

de: GFK = Glasfaserverstärkter Kunststoff Link zu Wikipedia
en: GRP = glass-fibre reinforced plastic Link to Wikipedia
For further information please contact our Application Engineering Department.



2) **Facade construction screw 6.3x115mm**

	Ø	SW
Standard SFS TDB-S-6.3x115	12	8
Option SFS TDB-S-S16-6.3x115	18	8
Würth SHR-6KT-BZ-SW3/8-(A2K)-6.3x115	12	3/8
Würth SHR-6KT-BZ-SHB16-SW3/8-(A2K)-6.3x115	18	3/8

Circular saw blade ->GRP
Recommended: Circular saw blade diamond-coated 500x3.5x30mm Z 120 GZW Group tooth W Axial rake
-> GRP -> uPVC -> aluminium
-> uPVC -> aluminium

Wemaro Tools GmbH
Max-Eyth-Str. 7
DE - 75428 Jllingen
fon: +49 7042 8263-0
fax: +49 7042 8263-23
verkauf@wemaro.de
http://www.wemaro.de

see plan: 03 B 01 = Section 9, Section 10, Section 9-10

Schema A/D

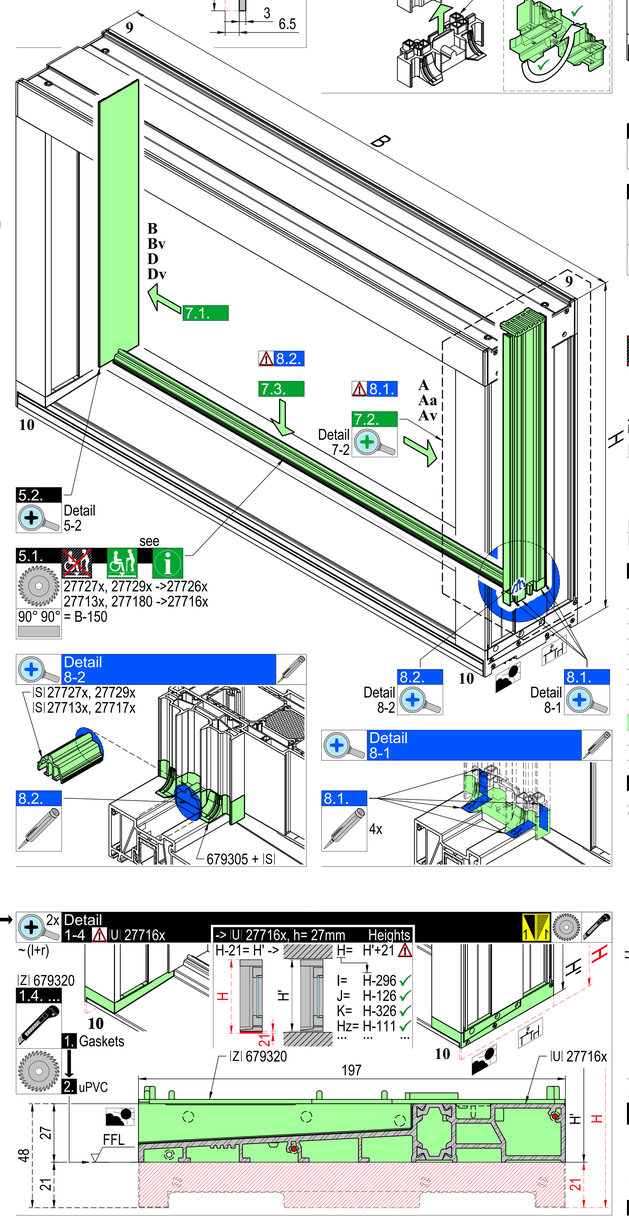
5. Cutting 5.1. - 5.3.
Circular saw blade -> uPVC / aluminium

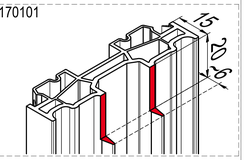
6. Drilling / Milling 6.1. - 6.1.
Milling cutter

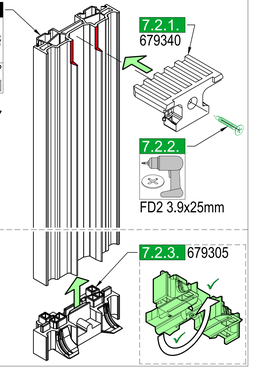
7. Assembly 7.1. - 7.3.
ATTENTION: in parts Sealing and Assembly 8.
Screws
1x FD2 3.9x25mm
Clip or mount

8. Sealing / Gluing 8.1. - 8.2.
Silicone rubber = =

Detail 5-2
1x 170105 = H-111
5.2. 90° 90°



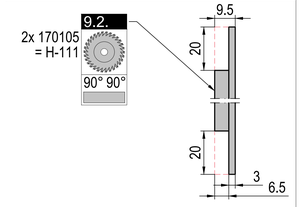
Detail 7-2
Section A, Aa, Av Section D, Dv
6.1. 170101 or


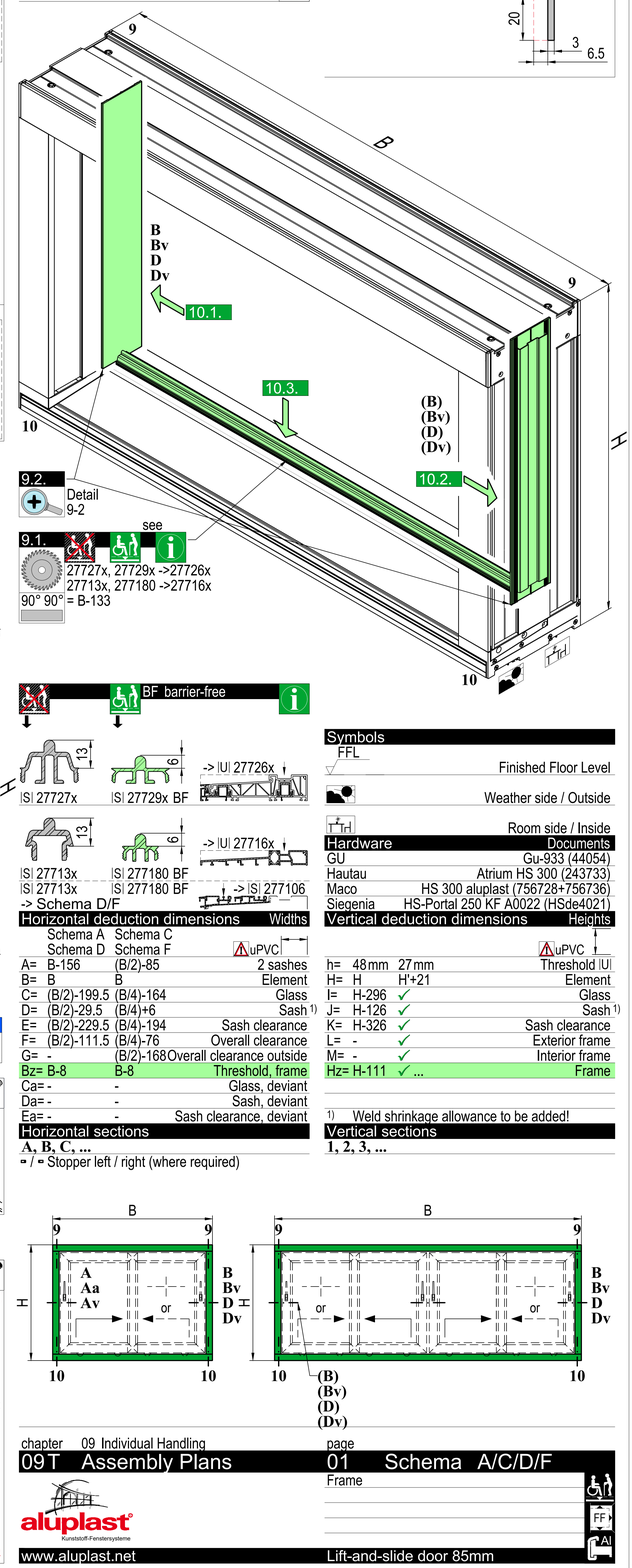
5.3. 90° 90° 170101 = H-127


Schema C/F

9. Cutting 9.1. - 9.2.
Circular saw blade -> uPVC / aluminium

10. Assembly 10.1. - 10.3.
Clip or mount

2x **Detail 9-2**
2x 170105 = H-111
9.2. 90° 90°




BF barrier-free

-> Schema D/F

Horizontal deduction dimensions Widths

Schema A	Schema C		
Schema D	Schema F	uPVC	
A= B-156	(B/2)-85	2 sashes	
B= B	B	Element	
C= (B/2)-199.5	(B/4)-164	Glass	
D= (B/2)-29.5	(B/4)+6	Sash 1)	
E= (B/2)-229.5	(B/4)-194	Sash clearance	
F= (B/2)-111.5	(B/4)-76	Overall clearance	
G= -	(B/2)-168	Overall clearance outside	
Bz= B-8	B-8	Threshold, frame	
Ca= -	-	Glass, deviant	
Da= -	-	Sash, deviant	
Ea= -	-	Sash clearance, deviant	

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical deduction dimensions Heights

			uPVC	
	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296	✓		Glass
J=	H-126	✓		Sash 1)
K=	H-326	✓		Sash clearance
L=	-	✓		Exterior frame
M=	-	✓		Interior frame
Hz=	H-111	✓	...	Frame

1) Weld shrinkage allowance to be added!

Vertical sections
1, 2, 3, ...

Symbols
FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

chapter 09 Individual Handling
page
09T Assembly Plans
01 Schema A/C/D/F
Frame
aluplast Kunststoff-Fensersysteme
www.aluplast.net
Lift-and-slide door 85mm

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *09_T_01_HST85* Issued: 2020-11 Language: en (English) / Englisch

Schema D = 1x | Schema F = 2x (l+r)

Important | Schema F | F ...

2x as represented;
1x as represented + 1x mirror-inverted

1. Cutting 1.1. - 1.8.
Circular saw blade -> uPVC / aluminium

Cutting
Scissors; knife

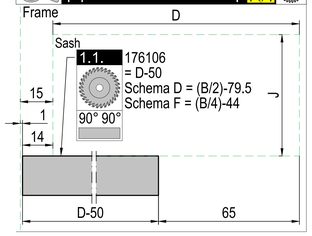
2. Drilling / Milling 2.1. - 2.3.
Drill Ø 4.0 / Ø 3.0
Milling cutter 8.3
Countersink Ø

3. Assembly 3.1. - 3.8.
ATTENTION: In parts Sealing and Assembly ⚠4.
Screws
\+ FD21 3.9x25 / GFK(GRP): DIN 7982 4.8x25
\+ FD21 3.9x19 / GFK(GRP): DIN 7982 4.8x19
1x Spax 4.0x80mm 2x -> F ...
1x FD2 3.9x25mm 2x -> F ...
Fasten (temporarily) e.g. with screw clamp
Clip or mount

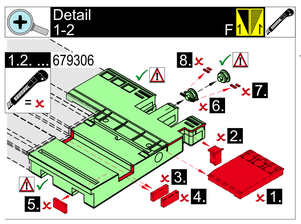
Aluminium shells Continue with... ➡ / Not applicable with ... ✕ ⚠AI

4. Sealing / Gluing 4.1. - 4.6.
Silicone rubber = ● =
Gluing surface (remove protective film)

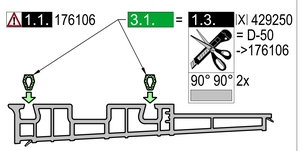
Detail 1-1



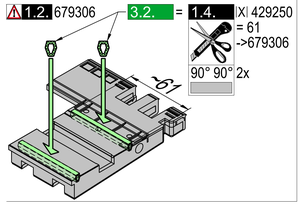
Detail 1-2



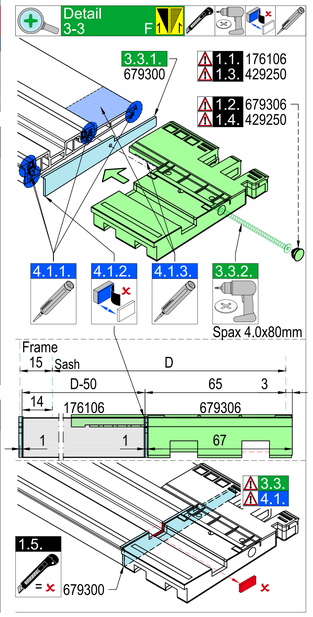
3-1



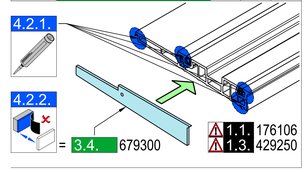
Detail 3-2



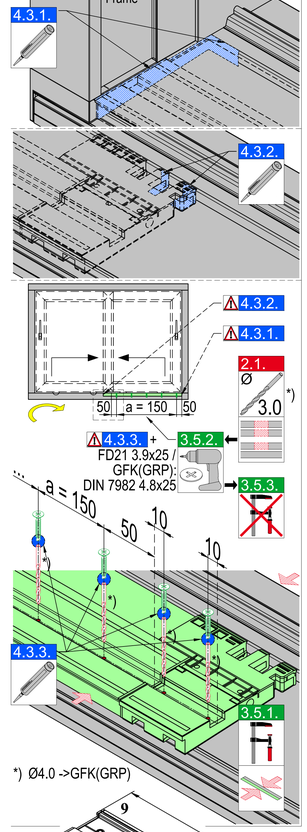
Detail 3-3



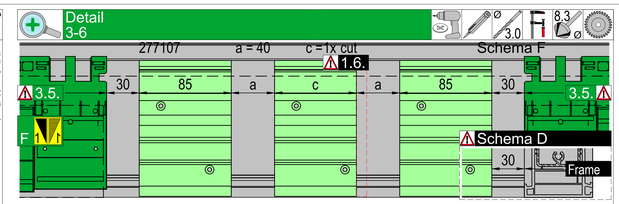
Detail 3-4

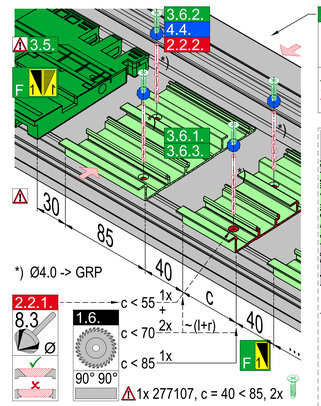


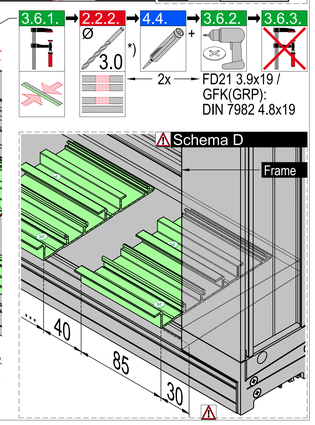
Detail 3-5



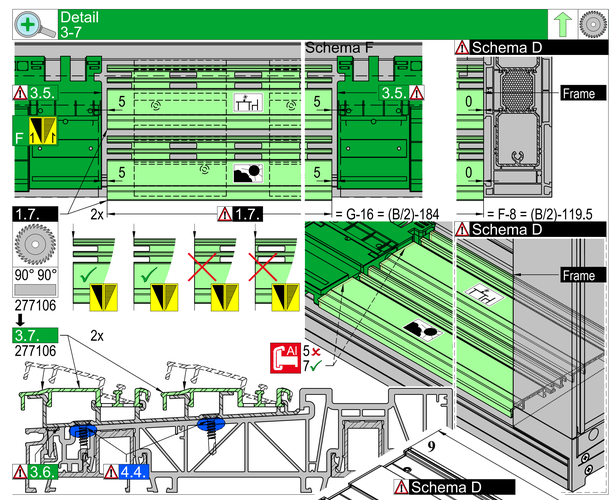
Detail 3-6





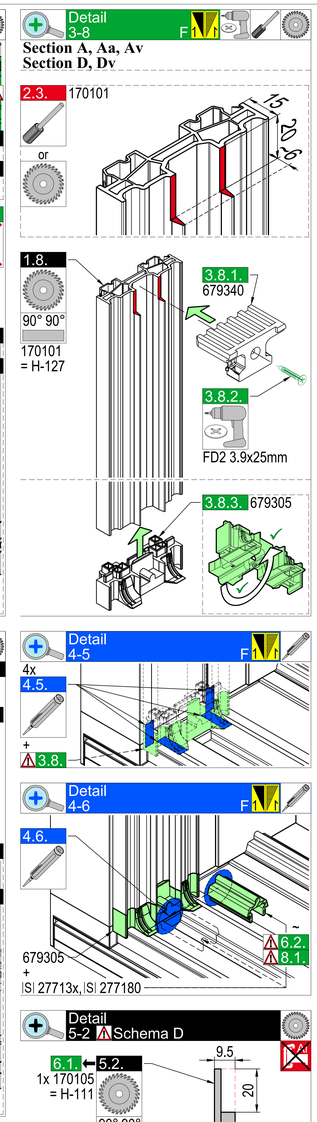


Detail 3-7

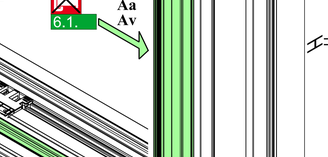


Detail 3-8

Section A, Aa, Av
Section D, Dv



Detail 4-5



Detail 4-6

Detail 5-2

⚠Schema D

5. Cutting 5.1. - 5.2.

Schema D = 1x
Circular saw blade -> uPVC / aluminium

6. Assembly 6.1. - 6.2.

ATTENTION: In parts Sealing and Assembly ⚠4.
Clip or mount

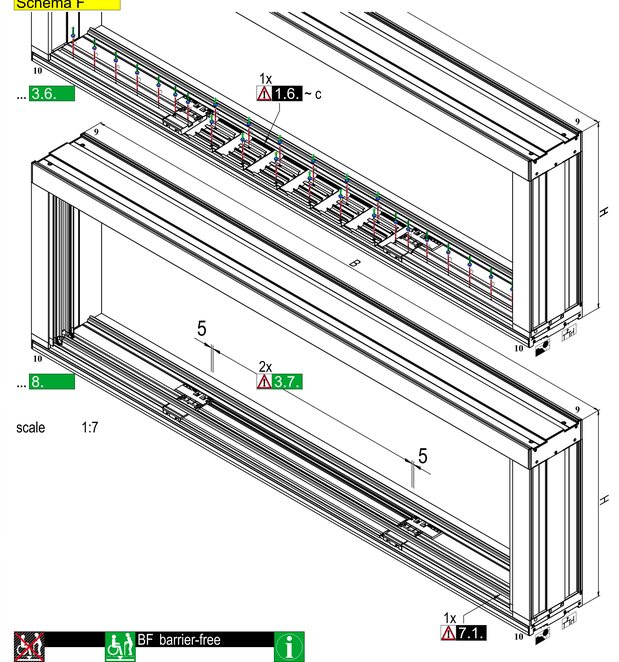
7. Cutting 7.1. - 7.1.

Schema F = 1x
Circular saw blade -> uPVC / aluminium

8. Assembly 8.1. - 8.1.

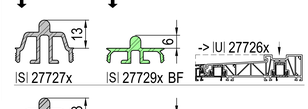
ATTENTION: In parts Sealing and Assembly ⚠4.
Clip or mount

For example
Schema F



scale 1:7

BF barrier-free



Symbols

FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions — Widths

	Schema A	Schema C		
	Schema D	Schema F	⚠uPVC	
A=	B-156	(B/2)-85	2 sashes	
B=	B	B	Element	
C=	(B/2)-199.5	(B/4)-164	Glass	
D=	(B/2)-29.5	(B/4)+6	Sash	1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance	
F=	(B/2)-111.5	(B/4)-76	Overall clearance	
G=	-	(B/2)-168	Overall clearance outside	
Bz=	B-8	B-8	Threshold, frame	
Ca=	-	-	Glass, deviant	
Da=	-	-	Sash, deviant	
Ea=	-	-	Sash clearance, deviant	

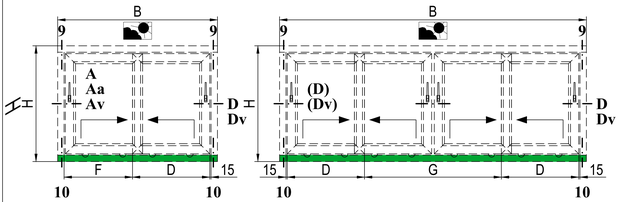
Vertical deduction dimensions — Heights

	⚠uPVC	
h= 48 mm	27 mm	Threshold |U|
H= H	H'+21	Element
I= H-296	✓	Glass
J= H-126	✓	Sash 1)
K= H-326	✓	Sash clearance
L= -	✓	Exterior frame
M= -	✓	Interior frame
Hz= H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...



May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

Schema A = 1x or Schema C = 2x (l+r)

1. Cutting 1.1. - 1.6.

Circular saw blade -> uPVC / aluminium

Cutting
Scissors; knife

2. Drilling / Milling 2.1. - 2.3.

670901 Drilling jig ->652923 + 170100

Drill Ø 2.5 Ø 4.5 Ø 6.5

3. Assembly 3.1. - 3.10.

ATTENTION: in parts Sealing and Assembly 4.

Screws
2x 4.2x30mm
2x 4.3x38mm
6x 4.3x45mm Option
2x Spax 3.0x10mm
1x Spax 4.0x80mm
\+ 6.3x100mm or 5.5x100mm
\+ 6.3x115mm or 5.5x115mm
\+ G| 652923

Fasten (temporarily)
e.g. with screw clamp

Clip or mount

Aluminium shells Continue with... Al
Not applicable with ...

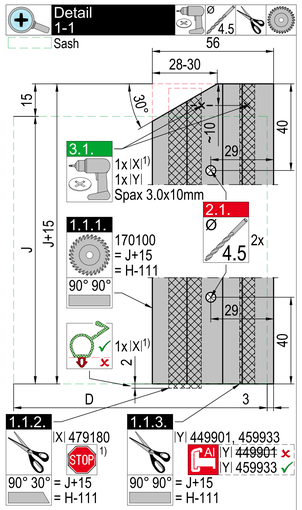
4. Sealing / Gluing 4.1. - 4.8.

Silicone rubber = =

Gluing surface (remove protective film)

Detail 1-1

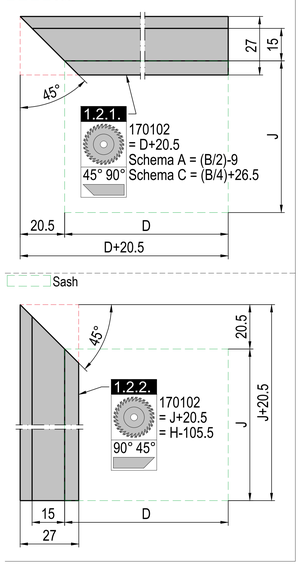
Sash



1) |X| 479180 -> J ≥ 2.3m + aww ≥ A4/B3/9A

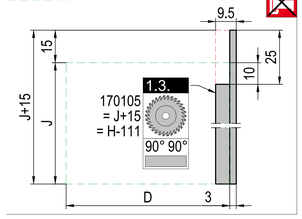
Detail 1-2

Sash



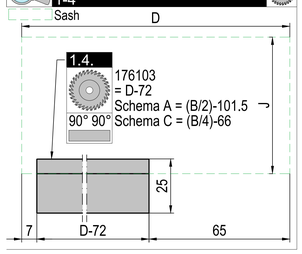
Detail 1-3

Sash

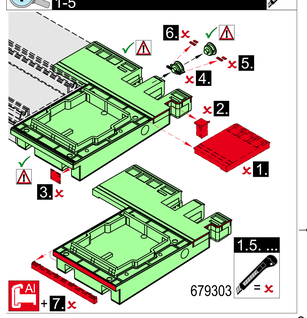


Detail 1-4

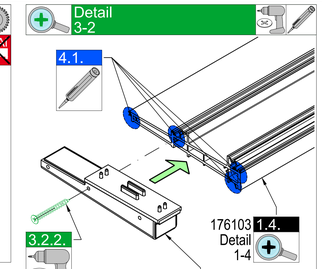
Sash



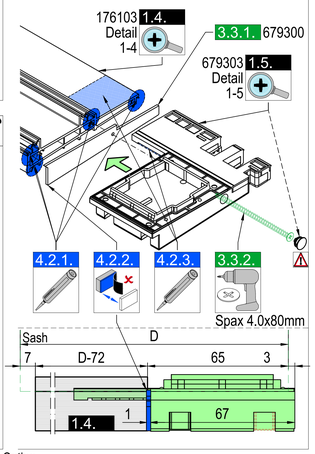
Detail 1-5



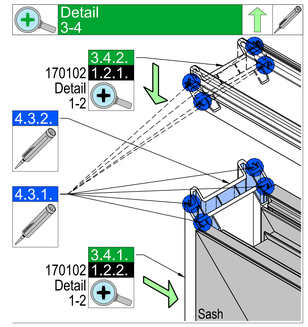
Detail 2-2



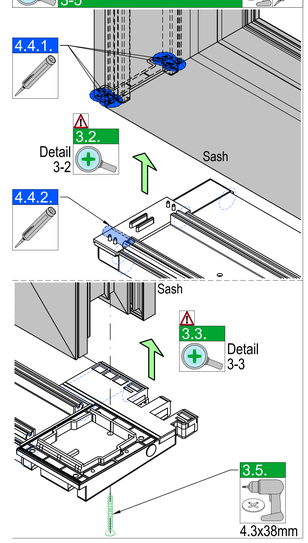
Detail 3-3

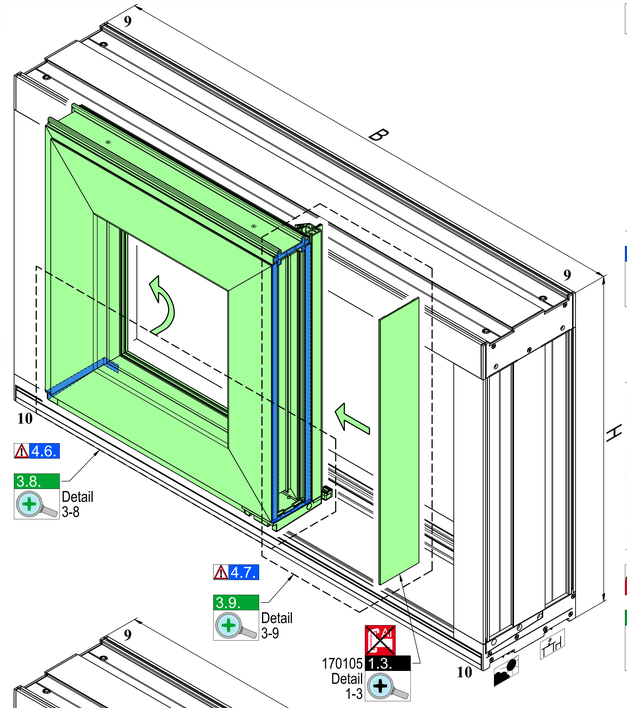


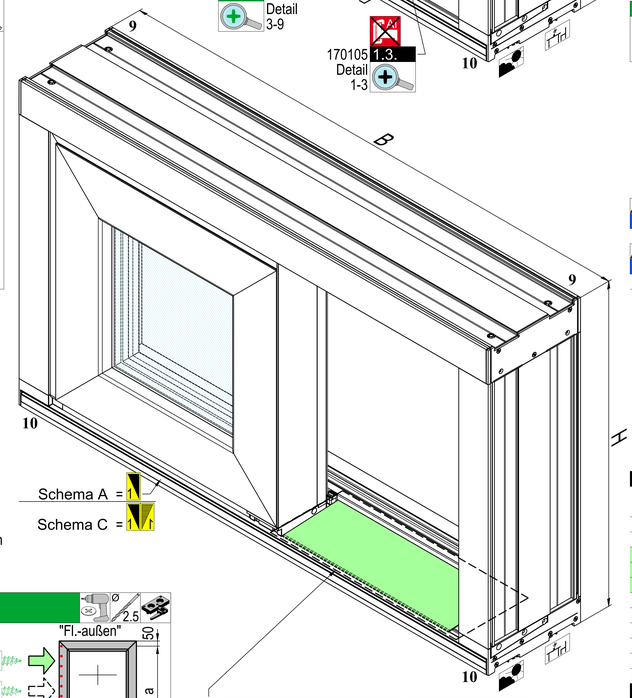
Detail 3-4

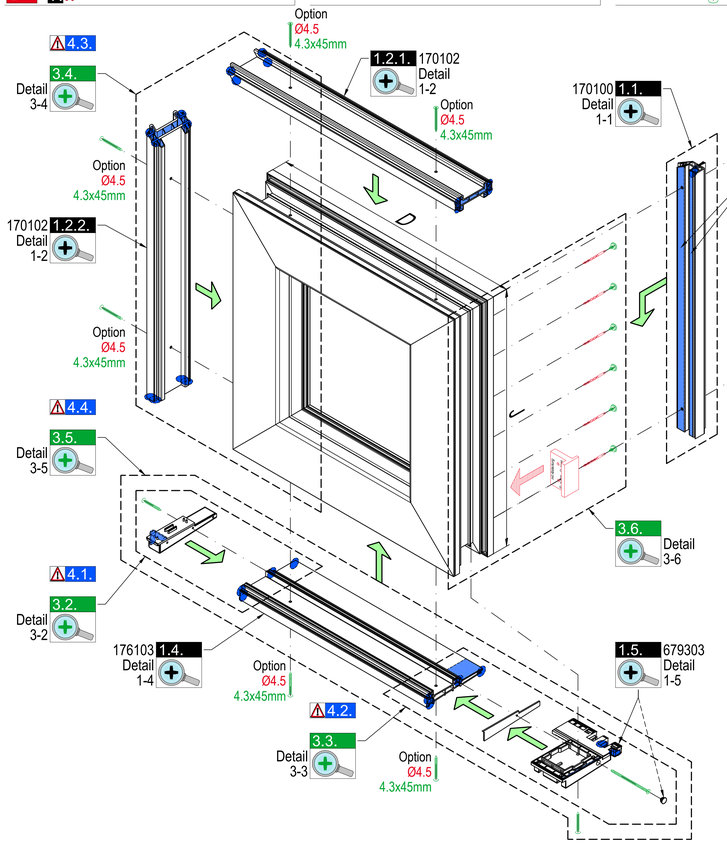


Detail 3-5

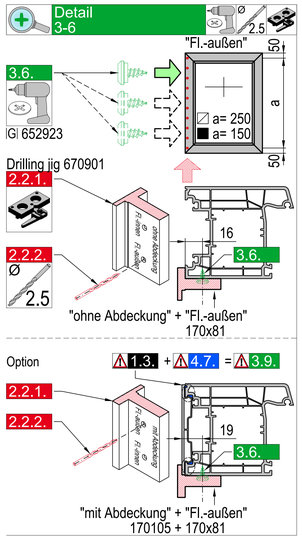




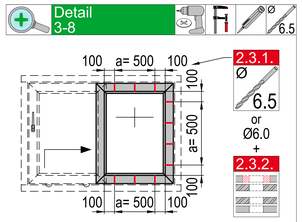


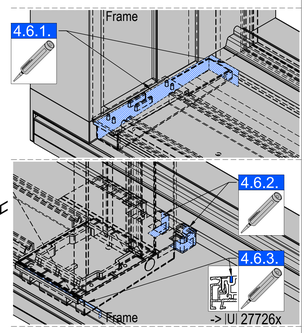


Detail 3-6

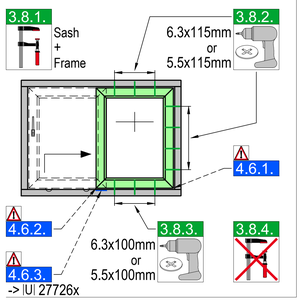


Detail 3-8

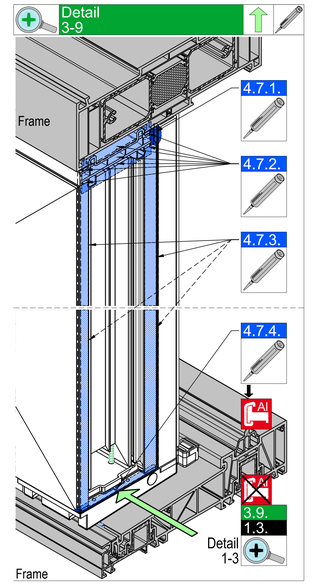




2.3.1. + 2.3.2.

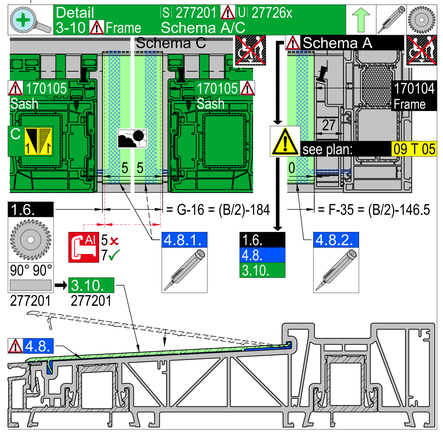


Detail 3-9



Detail 3-10 Frame

S 277201 U 27726x Schema A/C



Symbols

FFL Finished Floor Level

Weather side / Outside

Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions Widths

	Schema A / Schema D	Schema C / Schema F	uPVC	
A=	B-156	(B/2)-85		2 sashes
B=	B	B		Element
C=	(B/2)-199.5	(B/4)-164		Glass
D=	(B/2)-29.5	(B/4)+6		Sash 1)
E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

Vertical deduction dimensions Heights

		uPVC	
h=	48mm 27mm		Threshold |U|
H=	H H'+21		Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

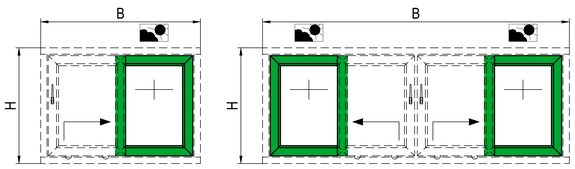
Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections

1, 2, 3, ...



chapter 09 Individual Handling
09 T Assembly Plans

page
03 Schema A/C
Fixed sash-outside
Lift-and-slide door 85mm

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F1 or F3 F1

Schema D = 1x Schema F = 2x (I+r)

⚠ Important	Schema F	F ...
Sliding sash No. 3 left;		F3
Sliding sash No. 1 right		F1
2x as represented;		
1x as represented + 1x mirror-inverted		

1. Cutting 1.1. - 1.6.

Circular saw blade	-> uPVC / aluminium
Circular saw blade	-> GRP
Cutting	
Scissors; knife; prybar	
Blanking:	
Milling, sawing, cutting, drilling ...	

2. Drilling / Milling 2.1. - 2.5.

670901 Drilling jig	->652923 + 170100
670941 Drilling jig	->679341
Drill	Ø 2.5 3.0 4.5 10
Milling cutter	Ø 8

3. Assembly 3.1. - 3.11.

ATTENTION: In parts Sealing and Assembly ⚠ 4.

Screws	-> F ...
2x 4.2x30mm	4x
2x Spax 3.0x10mm	4x
2x Spax 3.0x30mm	4x
2x Spax 3.0x40mm	4x
2x Spax 3.5x25mm	4x
+ FD21 3.9x38mm	
+ |G| 652923	

Clip or mount; dismounting or temporary mounting

Tilt; set upright

Aluminium shells Continue with ... / Not applicable with ... ⚠ AI

4. Sealing / Gluing 4.1. - 4.3.

Silicone rubber; (suitable) Adhesive = ● =

Detail 1-1 F

1.1. 170105 = J = H-126, 90° 90°

2.1.1. Ø 8 1)

2.1.2.

or

2.1.3. = Option

-> |Z| 679330 + |X| 479330

1) ~~|Z| 679330~~ ~~|X| 479330~~

Ø 8 2.1.2.

Detail 1-2 F

Sash

1.2.1. 170100 = J = H-126, 90° 90°

2.2. Ø 4.5 2x

3.1. 1x |X| 1) 1x |Y| Spax 3.0x10mm

1x |X| 1) 2x

1.2.2. |X| 479180 STOP 1) 90° 30° = J = H-126

1.2.3. |Y| 449901, 459933 ⚠AI |Y| 449901 ✗ |Y| 459933 ✓ 90° 90° = J = H-126

1) |X| 479180 -> J ≥ 2.3m + aww ≥ A4/B3/9A

Detail 1-3 F

Sash

1.3. 4x

Detail 2-3 F

(I+r)

Drilling jig 670941

2.3.1. 1x (I+r)

2.3.3. Ø 10 1x (I+r)

2.3.2. Ø 3.0 3x (I+r)

Sash

Detail 3-2 F

1.4. Set 679341

3.2.5. ⚠2.3. 3.2.1. 3.2.4.

3.2.6. + 3.2.7. Spax 3.0x30mm

3.2.2. + 3.2.3. Spax 3.0x40mm

Detail 3-3 F

Sash

|X| 479330 + |Z| 679330

3.3.1. 3.3.2. ⚠2.1.2.

2.4. Ø 2.5 2x Option

⚠2mm ⚠0mm

3.3.3. Spax 2x 3.5x25mm

Detail 3-5 F

"Fl.-außen" a= 250 a= 150

3.5. |G| 652923

Drilling jig 670901

2.5.1. 2.5.2. Ø 2.5

16 3.5.

"ohne Abdeckung" + "Fl.-außen" 170x81

Option ⚠1.1. + ⚠3.4.

2.5.1. 2.5.2.

19 3.5.

"mit Abdeckung" + "Fl.-außen" 170105 + 170x81

Detail 3-7 F

1.5.1. |X| 479181 = D+J+D 90° 90° 2x

4.2. 1.5.2. ⚠1.3.

3.7. =

Detail 4-3 F

Sash

4.3. 100

Nut 2x ~ (I+r)

Schema D

9 ⚠Schema D

B

10

H

F1

3.11. 5.1. FD21 3.9x38mm

3.10. 5.2.

⚠3.9.

Schema F

9 ⚠Schema F

B

10

F1

3.11. 5.1. FD21 3.9x38mm

3.10. 5.2.

⚠3.9.

F F1

F3

(3.11.) (5.1.) FD21 3.9x38mm

(3.10.) (5.2.)

⚠(3.9.)

H

3.7. |X| 479181 Detail 3-7

3.8. F1

Sash

3.9. 5.3.

(3.9.) (5.3.)

1.6. 27715x

-> GRP

Schema D 1x 90° 90° = B-155 or 1x = (B/2)-179.5 & 1x = (B/2)+24.5

Schema F 2x 90° 90° = (B/2)-88

(3.7.) |X| 479181 Detail 3-7

(3.8.)

F3

5. Dismounting of the sash 5.1. - 5.3.

see 5.1. → 5.2. → 5.3. / 3.11. → 3.10. → 3.9.

3. Mounting of the sash 3.9. - 3.11.

see 3.9. → 3.10. → 3.11.

F

see 3.2. / see 2.3. / see 4.3.

2.3. Detail 2-3

F1

4.1. + 3.6. 2x 4.2x30mm

3.5. Detail 3-5

4.3. Detail 4-3

Sash 1.3. Detail 1-3

3.2. Detail 3-2

170100 1.2. Detail 1-2

170105 1.1. Detail 1-1

3.3. Detail 3-3

170105 3.4.

Cutting GRP Dust extraction

"Further manufacture of GRP components (grinding, cutting, sawing) goes along with the emission of fine dusts and chips containing glass filaments as well as of tacky dust in substantial quantities. These affect people's health and functionality of machines and equipment. To ensure safety regulations are adhered to and efficiency can be sustained, the installation of effective extraction and filtration equipment is needed."

Türschmann / Jakschik / Rother: White Paper, Topic: "Clean Air in the Manufacture of Glass Fibre Reinforced Plastic (GRP) Parts", March 2011

de: GFK = Glasfaserverstärkter Kunststoff — Link zu Wikipedia
en: GRP = glass-fibre reinforced plastic — Link to wikipedia

For further information please contact our Application Engineering Department.

Horizontal deduction dimensions — Widths

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A=	B-156	(B/2)-85	2	sashes
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E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Symbols

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Weather side / Outside

Room side / Inside

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Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Vertical deduction dimensions — Heights

			⚠uPVC	
h=	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296		✓	Glass
J=	H-126		✓	Sash 1)
K=	H-326		✓	Sash clearance
L=	-		✓	Exterior frame
M=	-		✓	Interior frame
Hz=	H-111		✓ ...	Frame

1) Weld shrinkage allowance to be added!

Vertical sections

1, 2, 3, ...

B H F1 / B H F3 F1

Circular saw blade ->GRP

Recommendation:
Circular saw blade
diamond-coated
500x3.5x30mm Z 120 GZW
Group tooth W
Axial rake

⚠ -> GRP -> uPVC -> aluminium

⚠ -> uPVC -> aluminium

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chapter 09 Individual Handling — page

09 T Assembly Plans — **04 Schema D/F**

Sliding sash-Outside

aluplast Kunststoff-Fenstersysteme

www.aluplast.net — Lift-and-slide door 85mm

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Schema A or Schema D

1. Cutting 1.1. - 1.7.

Circular saw blade -> uPVC / aluminium
Circular saw blade -> GRP
Cutting:
Scissors; knife; prybar
Blanking:
Milling, sawing, cutting, drilling ...

2. Milling / Drilling 2.1. - 2.5.

670901 Drilling jig ->652923 + 170100
670941 Drilling jig ->679341
Drill Ø 2.5 3.0 4.5 10
Milling cutter Ø 8

3. Assembly 3.1. - 3.12.

ATTENTION: In parts Sealing and Assembly ⚠4.
Screws
2x 4.2x30mm
1x Spax 3.0x10mm
2x Spax 3.0x30mm
2x Spax 3.0x40mm
2x Spax 3.5x25mm
+ FD21 3.9x38mm
+ |G| 652923
Clip or mount; dismounting or temporary mounting
Tilt; set upright
Aluminium shells Continue with ... ➡
Not applicable with ... ✕ ⚠A!

4. Sealing / Gluing 4.1. - 4.3.

Silicone rubber; (suitable) Adhesive = ● =

Detail 1-1

1.1. 170105 = J = H-126, 90° 90°
2.1.1. Ø 8
2.1.2. 1) ⚠ Ø 8
or
-> |Z| 679330 + |X| 479330
1) ⚠ |Z| 679330 |X| 479330
2.1.3. = Option

Detail 1-2

1.2. 170100 = J = H-126, 90° 90°
2.2. Ø 4.5 2x
1.2.1. 170100 = J = H-126, 90° 90°
1.2.2. |X| 479180 = J = H-126, 90° 30°

Detail 1-3

1.3. 4x

Detail 2-3

Drilling jig 670941
2.3.1. 1x (l+r)
2.3.2. Ø 3.0 3x (l+r)
2.3.3. Ø 10 1x (l+r)

Detail 3-2

1.4. Set 679341

Detail 3-3

3.3.1. |X| 479330 + |Z| 679330
3.3.2. 2x Option
3.3.3. Spax 2x 3.5x25mm

Detail 3-5

3.5. |G| 652923
Drilling jig 670901
2.5.1.
2.5.2. Ø 2.5
"ohne Abdeckung" + "Fl.-innen" 170x81
Option
⚠1.1. + ⚠3.4.
2.5.1.
2.5.2.
"mit Abdeckung" + "Fl.-innen" 170105 + 170x81

Detail 3-7

⚠1.3. 1.5.2. 4.2. 1.5.1. |X| 479181 90° 90° = D+J+D 2x
=3.7.

Detail 3-12

Interlock gasket
1.7.
3.12. FD21 3.9x38mm

Detail 4-3

100 Sash 4.3. Nut 1x

12. Dismounting of the sash 12.1. - 12.4.

see 12.1. → 3.12. | see 12.2. → 3.11. | see 12.3. → 3.10. | see 12.4. → 3.9.

3. Mounting of the sash 3.9. - 3.12.

see 3.9. → 3.10. | see 3.10. → 3.11. | see 3.11. → 3.12.

3.7. |X| 479181 Detail 3-7

Cutting GRP Dust extraction

"Further manufacture of GRP components (grinding, cutting, sawing) goes along with the emission of fine dusts and chips containing glass filaments as well as of tacky dust in substantial quantities. These affect people's health and functionality of machines and equipment. To ensure safety regulations are adhered to and efficiency can be sustained, the installation of effective extraction and filtration equipment is needed."

Türschmann / Jakschik / Rother: White Paper, Topic: "Clean Air in the Manufacture of Glass Fibre Reinforced Plastic (GRP) Parts", March 2011

de: GFK = Glasfaserverstärkter Kunststoff — Link zu Wikipedia
en: GRP = glass-fibre reinforced plastic — Link to wikipedia
For further information please contact our Application Engineering Department.

Circular saw blade ->GRP

Recommended:
Circular saw blade
diamond-coated
500x3.5x30mm Z 120 GZW
Group tooth W
Axial rake
-> GRP -> uPVC -> aluminium
-> uPVC -> aluminium

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Schema A

5. Cutting 5.1. - 5.4.

Circular saw blade -> uPVC / aluminium
Cutting
Scissors; knife

6. Assembly 6.1. - 6.3.

ATTENTION: In parts Sealing and Assembly ⚠7.
Clip or mount

7. Sealing / Gluing 7.1. - 7.2.

Silicone rubber; (suitable) Adhesive = ● =

Schema D

Option ->

8. Cutting 8.1. - 8.1.

Circular saw blade -> uPVC / aluminium

9. Drilling / Milling 9.1. - 9.1.

Drill Ø 2.5 Option

10. Sealing / Gluing 10.1. - 10.2.

(suitable) Adhesive = ■

11. Assembly 11.1. - 11.3.

Screws
+ |G| 659918
Clip or mount

Detail 6-1

Schema A
5.1. 170104
5.2. |Y| 449901, 459933
= 90° 90° = D-85 = (B/2) -114.5
5.3. 170104
5.4. |Y| 449901, 459933
= 90° 90° = J-12 = H-138
7.1. or 7.2.
6.1. 6.2. 6.3. 679304
⚠6.2.

Detail 11-1

Schema D
11.1. |G| 659918
9.1. Ø 2.5 Option
10.1. Option
11.2. 120100
10.2.
11.3. 650914 (l+r)
8.1. 90° 90° = B-4 120100

Symbols

FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions Widths

	Schema A / Schema D	Schema C / Schema F	⚠uPVC	
A=	B-156	(B/2)-85	2 sashes	
B=	B	B	Element	
C=	(B/2)-199.5	(B/4)-164	Glass	
D=	(B/2)-29.5	(B/4)+6	Sash 1)	
E=	(B/2)-229.5	(B/4)-194	Sash clearance	
F=	(B/2)-111.5	(B/4)-76	Overall clearance	
G=	-	(B/2)-168	Overall clearance outside	
Bz=	B-8	B-8	Threshold, frame	
Ca=	-	-	Glass, deviant	
Da=	-	-	Sash, deviant	
Ea=	-	-	Sash clearance, deviant	

Vertical deduction dimensions Heights

	⚠uPVC	
h= 48mm	27mm	Threshold |U|
H= H	H'+21	Element
I= H-296	✓	Glass
J= H-126	✓	Sash 1)
K= H-326	✓	Sash clearance
L= -	✓	Exterior frame
M= -	✓	Interior frame
Hz= H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections

A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections

1, 2, 3, ...

B, H, or

chapter 09 Individual Handling
09 T Assembly Plans
page 05 Schema A/D
Sliding sash-Inside
Lift-and-slide door 85mm
aluplast Kunststoff-Fensersysteme
www.aluplast.net

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

Schema C/F

Important

Sliding sash No. 4 left; F4 F2
Sliding sash No. 2 right
2x as represented;
1x as represented + 1x mirror-inverted

1. Cutting 1.1. - 1.9.

Circular saw blade -> uPVC / aluminium
Circular saw blade -> GRP
Cutting
Scissors; knife; prybar
Blanking:
Milling, sawing, cutting, drilling ...

2. Drilling / Milling 2.1. - 2.6.

670901 Drilling jig ->652923 + 170100
670941 Drilling jig ->679341
Drill Ø 2.5 3.0 4.5 10
Milling cutter Ø 8

3. Assembly 3.1. - 3.14.

ATTENTION: In parts Sealing and Assembly 4.
Screws
4x 4.2x30mm
2x Spax 3.0x10mm
4x Spax 3.0x30mm
4x Spax 3.0x40mm
4x Spax 3.5x25mm
+ FD21 3.9x38mm
+ |G| 652923
Clip or mount; dismounting or temporary mounting
Tilt; set upright

Aluminium shells Continue with ... Not applicable ...

4. Sealing / Gluing 4.1. - 4.4.

Silicone rubber; = =
(suitable) Adhesive

2x 1-1

1.1. 170105 = J = H-126, 90° 90°
2.1.1. Ø 8
2.1.2. 1)
or
-> |Z| 679330 + |X| 479330
1) ~~|Z| 679330~~ ~~|X| 479330~~
Ø 8 2.1.2.
2.1.3. = Option

2x Detail 1-2

Sash, Ø 4.5
3.1. Spax 3.0x10mm
2.2. Ø 4.5 2x
1.2.1. 170100 = J = H-126, 90° 90°
1.2.2. |X| 479180 = J = H-126, 90° 30°
D

2x Detail 1-3

Sash
1.3. 4x

2x Detail 2-3

Ø 10 3.0
(I+r)
(Ø3.0) Ø10, 26, 5.5, Ø3.0, 46, Ø3.0
Drilling jig 670941
2.3.1. 1x (I+r)
2.3.3. Ø 10 1x (I+r)
2.3.2. Ø 3.0 3x (I+r)
Sash

2x Detail 2-2

1.4. Set 679341

2x Detail 3-2

2x Detail 3-3

|X| 479330
3.3.1. + |Z| 679330
3.3.2.
Sash
2.4. Ø 2.5 2x Option
2.1.2.
3.3.3. Spax 2x 3.5x25mm

2x Detail 3-5

"Fl.-innen" a= 250 a= 150
3.5. |G| 652923
Drilling jig 670901
2.5.1.
2.5.2. Ø 2.5
"ohne Abdeckung" + "Fl.-innen" 170x81
Option 1.1. + 3.4.
2.5.1.
2.5.2.
"mit Abdeckung" + "Fl.-innen" 170105 + 170x81

1x Detail 3-8 F4

Section F
2.6.1. 170101 Ø 8 or
64, 40, 16
1.5.1. 90° 90° 170101 = J-16 = H-142
(3.7.)
2.6.2. *)
1.5.2. 679305 *)
3.8. 679305
*) Cutout according to hardware manufacturer

1x Detail 3-9 F4

1.6.2. ~ 21mm
4.2.
3.8.
= 3.9.1. 1.3.
1.6.1. |X| 479181 90° 90° = D + 14 2x
1.6.3. 90° 90° = D 2x
= 3.9.2. 1.3.

1x Detail 3-10 F2

1.3. 4.3. 1.7.1. |X| 479181 90° 90° = D+J+D 2x
1.7.2.
= 3.10.

3x Detail 3-14

Interlock gasket
1.9.
3.14.
FD21 3.9x38mm
1x -> Section C
1x -> Section (C)
2x -> Section F

3.10. |X| 479181 Detail 3-10

11. Dismounting of the sash 11.1. - 11.4.

see 11.1. -> see 11.2. -> see 11.3. -> see 11.4.

3. Mounting of the sash 3.11. - 3.14.

see 3.11. -> see 3.12. -> see 3.13. -> see 3.14.

2x Detail 4-4

100, Sash 4.4., Nut 1x

Cutting GRP Dust extraction

*Further manufacture of GRP components (grinding, cutting, sawing) goes along with the emission of fine dusts and chips containing glass filaments as well as of tacky dust in substantial quantities. These affect people's health and functionality of machines and equipment. To ensure safety regulations are adhered to and efficiency can be sustained, the installation of effective extraction and filtration equipment is needed."

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For further information please contact our Application Engineering Department.

1x Detail 6-1

Schema C
Frame
6.1.
5.1. 170104
5.2. |Y| 449901, 459933
= 90° 90° = G-6 = (B/2)-174

Schema F
Option ->

7. Cutting 7.1. - 7.1.

Circular saw blade -> uPVC / aluminium

8. Drilling / Milling 8.1. - 8.1.

Drill Option Ø 2.5

9. Sealing / Gluing 9.1. - 9.2.

(suitable) Adhesive = =

10. Assembly 10.1. - 10.3.

Screws
+ |G| 659918
Clip or mount

Detail 10-1

Schema F
Option ->
10.1. |G| 659918
8.1. Ø 2.5 Option
50, a, 50, 10, a= 250, a= 150
Frame
9.1. Option
10.2. 120100
9.2.
10.3. 650914 (I+r)
32.5, 20, 10, 10, 7.1., 90° 90° = B-4

Schema C
Frame
5. Cutting 5.1. - 5.2.
Circular saw blade -> uPVC / aluminium
Cutting
Scissors; knife
6. Assembly 6.1. - 6.1.
Clip or mount

Schema C
Frame
1.9.
62+1
3.14.
Schema F
Frame
1.9.
90+1
3.14.

Symbols

FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions — Widths

	Schema A / Schema D	Schema C / Schema F	uPVC	
A=	B-156	(B/2)-85	2	sashes
B=	B	B		Element
C=	(B/2)-199.5	(B/4)-164		Glass
D=	(B/2)-29.5	(B/4)+6		Sash 1)
E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

Vertical deduction dimensions — Heights

			uPVC	
h=	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296		✓	Glass
J=	H-126		✓	Sash 1)
K=	H-326		✓	Sash clearance
L=	-		✓	Exterior frame
M=	-		✓	Interior frame
Hz=	H-111		✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections A, B, C, ...
Vertical sections 1, 2, 3, ...

▫ / ▫ Stopper left / right (where required)

B, H, F4, F2, or, or

Circular saw blade ->GRP

Recommendation:
Circular saw blade
diamond-coated
500x3.5x30mm Z 120 GZW
Group tooth W
Axial rake
-> GRP -> uPVC -> aluminium
-> uPVC -> aluminium

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DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *09_T_06_HST85* Issued: 2020-11 Language: en (English) / Englisch

Schema A = 1x or Schema C = 2x (I+r)

Important
1x as represented + 1x mirror-inverted

1. Cutting 1.1. - 1.10.
Circular saw blade -> uPVC / aluminium
Cutting:
Scissors; knife; prybar
2. Drilling / Milling 2.1. - 2.8.
670901 Drilling jig ->652923 + 170100
Drill Ø 2.5 Ø 3.0 Ø 4.0 Ø 4.5
Milling cutter
Countersink
3. Assembly 3.1. - 3.11.
ATTENTION: in parts Sealing and Assembly 4.
Screws -> C ...
2x 4.2x30mm 4x
2x 4.3x38mm 4x
\+ FD21 3.9x19
\+ FD21 3.9x38 / GFK(GRP): DIN 7982 4.8x38
1-2x Spax 3.0x10mm 2-4x
1x Spax 4.0x80mm 2x
12x Spax 5.0x55mm 24x
4x DIN 7504 P 4.8x50mm / GFK(GRP): DIN 7982 4.8x50mm 8x
Fasten (temporarily) e.g. with screw clamp
Clip or mount
Aluminium shells Continue with... Not applicable with ...
4. Sealing / Gluing 4.1. - 4.8.
Silicone rubber; (suitable) Adhesive
Gluing surface (remove protective film)

Detail 1-1
170082: Df= D+15; ~170x81: D; 45° 45°; 32; 15; ~7
1.1.1 170082 1) = Df= D+15, Schema A = (B/2)-14.5, 45° 90° Schema C = (B/4)+21
1.1.2 170082 = Jf= J+15 = H-111, 45° 45°
1.1.3 170082 2) = Df= D+15, Schema A = (B/2)-14.5, 45° 90° Schema C = (B/4)+21
1) + 1.1.4. + 1.1.5. = 170082; ≥1.5; ≥1.5; 2
2) Al

Detail 1-2
2x; 170082 Sash; 1.2. or 2.1.; 170082

Detail 1-3
Sash; 170082: Jf= J+15; 170x81: P= Jf-24; |X|= P-44; |F|= P-22; ~170x81: J; 12; 22; 11; 15; K
P 1.3.1. 90° 90°; |X| 1.3.2. Gaskets = Jf-68 = J-53 = H-179; K 2.2. **); |F| 1.3.3. 90° 90°; 3.1. Reinforcements = Jf-46 = J-31 = H-157 FD21 3.9x19mm
170x81 Sash ~ Mullion = Jf-24 = J-9 = H-135
*) |F| 229125 229126
**) Mill the outline K. Milling cutter / milling patterns on enquiry.

Detail 1-4
170082: Df= D+15; 28-30; 3; 56; Sash; 15; 40; 29; ~170x81: J; ~170x81: D
3.2. 1x |X| (1) 1x |Y| Spax 3.0x10mm
1.4.1. 170100 = Jf= J+15 = H-111, 90° 90°
2.3. Ø 4.5 2x
1x |X| (1)
1.4.2. |X| 479180 STOP 1) 90° 30° = Jf= J+15 = H-111
1.4.3. |Y| 449901, 459933 |Y| 449901 |Y| 459933 90° 90° = Jf= J+15 = H-111
1) |X| 479180 -> J ≥ 2.3m + aww ≥ A4/B3/9A

Detail 1-5
170082: Df= D+15; 9.5; 3; Sash; 15; 20; 35; 35; 170082: Jf= J+15; ~170x81: J; ~170x81: D
170105 1.5. Jf= J+15 = H-111, 90° 90°

Detail 1-6
Sash; 15; ~170x81: D; 170x81: J; 170082: Jf= J+15; 1; 14; Df-65 = D-50; 65; 170082: Df= D+15
1.6. 176106 = Df-65 = D-50, Schema A = (B/2)-79.5, 90° 90° Schema C = (B/4)-44

Detail 1-7
679306 1.7. ...

Detail 1-8
2x; 670382 1.8. ...; 1.1.1. 1.1.3. 170082; 1.3. 170x81; 3.3.

Detail 1-4 (1.4.)
1.4. 170100 Detail 1-4
3.6. Detail 3-6
4.4. + 3.7. 2x 4.2x30mm

Detail 3-5
Sash; 1.2.; 4.2. + 3.4.; 4.3.; 2.5. Ø 4.0 1x; 3.5. 2x 4.3x38mm

Detail 3-9
Frame; Sash; 2x 2.8.1. Ø 4.0 ~45° ~30°; 2x 2.8.2. Ø 4.0 ~25° ~35°; 4x; 4.6.; 3.9. DIN 7504 P 4.8x50mm / GFK(GRP): DIN 7982 4.8x50mm

Detail 3-11
Frame; Sash; 4.8.1.; 4.8.2.; 4.8.3.; 4.8.4.; 4.6.; 3.11. 1.5. 170105 Detail 1-5

Detail 3-3
2x; 170x81 + 2x 670382 ...; 1.3. + 4.1. + 1.1. 170082; 2.4.1. 4x Ø 4.0 2x; 2.4.3.; 2.4.2. 4x; 2.4.4. 2x; 3.3.1. 4x; 3.3.2. 2x bottom / top = 12x Spax 5.0x55mm; ...3.9.; 1.8. 3.3.3. 670382; ...4.8.; 1.1. 170082

Detail 3-6
170x81 "Fl.-außen"; a= 250; a= 150; 3.6. 652923; Drilling jig 670901; 2.6.1.; 2.6.2. Ø 2.5; 170105 "ohne Abdeckung" + "Fl.-außen"; + 170105 = 1.5. + 4.8. + 3.11.; ~ 2.6.1.; ~ 2.6.2.; 170105 "mit Abdeckung" + "Fl.-außen"; Option

Detail 3-8
4.5.1.; Frame; 4.5.2.; Sash; 4.5.3.; 4.5.4.; Frame; -> |U| 27726x
Sash + Frame; 4.5.1.; 4.5.2.; 4.5.3.; 4.5.4.; 30 100 a= 150 100; a= 150
3.8.1. 2.7.1. Ø 3.0 *) 2.7.2. 3.8.2. 3.8.3. FD21 3.9x38 / GFK(GRP): DIN 7982 4.8x38
*) Ø4.0 ->GFK(GRP)
4.5.5. 30 100 a= 150 100; Seal screw heads in the horizontal bottom rebate.

Detail 3-4
4.2.1.; 4.2.2. = 3.4.1. 679300; 176106 1.6.

Detail 3-10
1.10. -> 3.10. 4.7. 2x; 1x; 90° 90°; |X| -> 170082; |X| + (X) 479025, 477025; |X| 170x81; |X| 170082; ~ Ef+Kf+Ef+24; Gaskets

Detail 1-2 (1.2.)
1.2. 170082 Detail 1-2; 1.1. 170082 Detail 1-1; 1.1.1.; Df; 1.1.2.; 1.1.3.; 4.1. + 3.3. Detail 3-3; 1.8. 3.3.3.; 2.4.3. 2.4.4. 4.1. + 3.3.2.; 4.3. + 3.5. Detail 3-5; 4.2. + 3.4. Detail 3-4; 1.6. 176106 Detail 1-6; 679306 1.7. Detail 1-7; 670382 1.8. Detail 1-8; 4.5. + 3.8. Detail 3-8; 4.7. + 3.10. Detail 3-10; 4.6. + 3.9. Detail 3-9; 4.8. 3.11. Detail 3-11; 1.5. 170105 Detail 1-5; 10; scale 1:4

Detail 1-3 (1.3.)
1.1.1.; 1.8. 3.3.3.; 2.4.1. 2.4.2. 3.3.1.; 1.3. Detail 1-3; 1.1.3.

Detail 3-2
1.4. 170100 Detail 1-4; 3.6. Detail 3-6; 4.4. + 3.7. 2x 4.2x30mm; 3.5.

Detail 3-1
2x; 170x81 + 2x 670382 ...; 1.3. + 4.1. + 1.1. 170082; 2.4.1. 4x Ø 4.0 2x; 2.4.3.; 2.4.2. 4x; 2.4.4. 2x; 3.3.1. 4x; 3.3.2. 2x bottom / top = 12x Spax 5.0x55mm; 58; 21; ...3.9.; 1.8. 3.3.3. 670382; 45; 50; 25; 35; 15; ...4.8.; 1.1. 170082

Detail 3-7
4.2.1.; 4.2.2. = 3.4.1. 679300; 176106 1.6.; 176106 1.6.; 679300 3.4.2.; 679306 1.7.; 4.2.3.; 4.2.4.; 4.2.5.; 3.4.3. Spax 4.0x80mm; Sash; 170082: Df= D+15; ~170x81: D; Df-65 = D-50; 65; 3; 14; 176106; 679306; 1; 67; 3.4.; 4.2.; 1.9. = 679300

Detail 3-12
Plan 09 T 03 Detail 3-10 Schema A/C |S| 277201 -> |U| 27726x
Schema A = 1; Schema C = 1 I r; 9; 10; H; scale 1:5

Symbols
FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware Documents
GU Gu-933 (44054)
Hautau Atrium HS 300 (243733)
Maco HS 300 aluplast (756728+756736)
Siegenia HS-Portal 250 KF A0022 (HSde4021)

Vertical deduction dimensions Heights

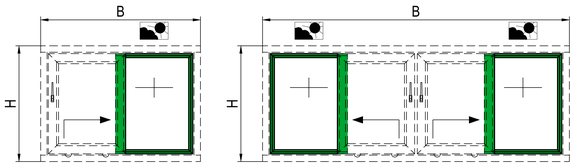
	Schema A ...f	Schema C ...f	uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash 1)
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Horizontal sections
A, B, C, ...
▫ / ▪ Stopper left / right (where required)

	uPVC	Threshold |U|
h=	48 mm	27 mm
H=	H	H'+21
I=	H-296 ✓	If= H-145 Glass
J=	H-126 ✓	Jf= H-111 Sash 1)
K=	H-326 ✓	Kf= H-175 Sash clearance
L=	- ✓	- Exterior frame
M=	- ✓	- Interior frame
Hz=	H-111 ✓ ...	Hz= H-111 Frame

1) Weld shrinkage allowance to be added!

Vertical sections
1, 2, 3, ...



chapter 09 Individual Handling
09T Assembly Plans
page 07 Schema A/C FF
Fixed sash outside
(small) Fixed sash FF fixframe

aluplast Kunststoff-Fenstersysteme
www.aluplast.net

Lift-and-slide door 85mm

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *09_T_07_HST85* Issued: 2020-11a Language: en (English) / Englisch

Schema D = 1x -> Frame or Schema F = 1x -> Frame

Important Schema D/F see plan: 09 T 02

Schema A = 1x -> Frame or Schema C = 1x -> Frame

Important Schema C C ...

1x as represented + 1x mirror-inverted

A |S| 277202 -> |U| 27726x 1:3

9. Cutting 9.1. - 9.1.

Circular saw blade -> uPVC / aluminium

10. Sealing / Gluing 10.1. - 10.2.

Silicone rubber = ● =

11. Assembly 11.1. - 11.1.

Clip or mount Continue with ... ➡

Aluminium shells Continue with ... ✓ Not applicable with ... ✗

B |S| 277107 + |S| 277105 -> |U| 27726x, 27716x 1:3

C |S| 277107 + 2x |S| 277106 -> |U| 27726x, 27716x 1:3

1. Cutting 1.1. - 1.2.

Circular saw blade -> uPVC / aluminium

2. Drilling / Milling 2.1. - 2.1.

Drill Ø 4.0 Ø 3.0

Countersink 8.3 Ø

3. Assembly 3.1. - 3.2.

ATTENTION: In parts Sealing and Assembly ⚠4

Screws FD21 3.9x19 / GFK(GRP): DIN 7982 4.8x19

Fasten (temporarily) e.g. with screw clamp

Clip or mount Continue with ... ➡

Aluminium shells Continue with ... ✓ Not applicable with ... ✗

4. Sealing / Gluing 4.1. - 4.1.

Silicone rubber = ● =

B Detail 3-1 ⚠Frame |S 277107 Schema A/C

C 277107 c = 1x cut ⚠1.1. Schema C

170105 Sash 30 85 a c a 85 30 170105 Sash

C -> |S 277106 a = 40 c ⚠

B -> |S 277105 a ≤ 200 c ✗

⚠Schema A 30 27 170104 Frame

170105 Sash 3.1.2. 4.1. 2.1.2. 3.1.1. 3.1.3.

*) Ø4.0 -> GRP

30 85 a c a

2.1.1. 8.3 Ø ✓ ✗ c < 55 1x + 2x ~(I+r)

1.1. c < 70 c < 85 90° 90° 1x

⚠1x 277107, c = 40 < 85, 2x

3.1.1. → 2.1.2. → 4.1. → 3.1.2. → 3.1.3.

Ø 3.0 *) 2x FD21 3.9x19 / GFK(GRP): DIN 7982 4.8x19

⚠Schema A 170104 Frame a 85 30

B Detail 3-2 ⚠Frame |S 277105, 277106 Schema A/C

C 170105 Sash C = 2x |S 277106 -or example B = 1x |S 277105

Schema C 170105 Sash Schema A 170104 Frame

1.2. ⚠1.2. 90° 90°

= G-16 = (B/2)-184 = F-35 = (B/2)-146.5

C 3.2. B ⚠5 ✓7 ⚠3.1. ⚠4.1.

1:3 A ↔ B ↔ C

A Detail 11-1 ⚠Frame |S 277202 Schema C

170105 Sash 170105 Sash C 5 5

9.1. = G-16 = (B/2)-184 ⚠5 ✗ ✓7

90° 90° 10.1. ⚠5 ✗ ✓7

11.1. 277202 277202

Schema A 170105 Sash 170104 Frame 27

⚠ see plan: 09 T 05

0 5 = F-35 = (B/2)-146.5

9.1. ⚠5 ✗ ✓7 10.2. 9. 10. 11.

90° 90° 10.1.

11.1. 277202 ⚠10.

⚠Schema A Schema C

09 T 01 + 09 T 03 / 09 T 07 Plan ➡

|S| 277202 11.1. Detail 11-1 A

|S| 277107 3.1. Detail 3-1 B C

|S| 277105 3.2. Detail 3-2 B C |S| 277106

1:7 scale

⚠ see plan: 09 T 01 + 09 T 02 = Frame + 09 T 03 = Fixed sash-outside / 09 T 07 = FF fixframe (+ barrier-free ~ FFBF)

F2 Schema A = 1x or F4 F2 Schema C = 2x

F2 F1 Schema D = 2x or F3 F4 F2 F1 Schema F = 4x

Important

Sliding sash = as represented F3 ~ F2 =

Sliding sash = mirror-inverted F4 ~ F1 =

5. Cutting 5.1. - 5.5.

Circular saw blade -> uPVC / aluminium

Cutting Scissors; knife

Blanking: Milling, sawing, cutting, drilling ...

6. Drilling / Milling 6.1. - 6.7.

Drill Ø 5.0 Ø 4.0 Ø 2.5

Milling cutter Ø 8

7. Assembly 7.1. - 7.5.

ATTENTION: In parts Sealing and Assembly ⚠8.

Screws ~ 1x Sliding sash

1x Spax 3.5x25mm

2x Spax 3.5x35mm

5x 4.8x38mm (4.8x32mm)

Clip or mount Continue with ... ➡

Aluminium shells Continue with ... ✓ Not applicable with ... ✗

8. Sealing / Gluing 8.1. - 8.1.

Silicone rubber = ● =

5-1 ⚠Sliding sash

5.1. 170105 = J = H-126 90° 90°

83 21.5 40 21.5 32 18 16 14 R4 1/2 1/2

6.1.1. Ø 8

6.1.2. 1) or

21.5 40 21.5 32 11 16 7

-> ⚠5.4. + ⚠5.3. + ⚠5.2. 1)

|Z| 679330 |X| 479330 |S| 279189

5.4. 5.3. 5.2.

1) ~~|Z| 679330 |X| 479330 |S| 279189~~

6.1.3. ~~6.1.2.~~ = Option ~8x7

5-2 ⚠Sliding sash Ø 4.0

|S| 279189 -> |Z| 679330

5.2. 1x 90° 90° 40 20 20

6.2. Ø 4.0 1x

5-3 ⚠Sliding sash

|Z| 679330 5.3. .... 1x 13 ~

5-4 ⚠Sliding sash

|X| 479330 -> |Z| 679330

5.4. .... 1x 12.5 ~

5-5 ⚠Sliding sash 2x Ø 5.0

|S| 279189 5.5. 2x 90° 90° ~300 - 400 A./B.

6.3. Ø 2-3x 5.0 A. B. A. B.

F2 = For example

7.5. 6.7. 170x81 7 mm 7 mm 7 mm

-> Sliding sash-Outside Schema D/F F3 F1 +

170105 5.1. Detail 5-1

|S| 279189 5.2. Detail 5-2

|Z| 679330 5.3. Detail 5-3

|X| 479330 5.4. Detail 5-4

|S| 279189 5.5. Detail 5-5

7.1. |S| 279189 Detail 7-1

7.2. |Z| 679330 |X| 479330 Detail 7-2

7.3. 170105 + 8.1. Detail 8-1

7.4. |S| 279189, A./B. Detail 7-4

|S| 279189 7 mm A./B.

B. A.

⚠ see plan: 09 T 04 D/F + 09 T 05 A/D + 09 T 06 C/F = Sliding sash / Schema

Detail 7-1 ⚠Sliding sash Ø 2.5

|S| 279189 ⚠5.2. Sash

6.4. Ø 2.5 1x Option

7.1. Spax 1x Ø3.5x25mm

0 20 23 40

Detail 7-2 ⚠Sliding sash Ø 2.5

|Z| 679330 ⚠5.3. Sash

|X| 479330 ⚠5.4. 7.2.1.

6.5. Ø 2.5 2x Option

7.2.2. Spax 2x 3.5x35mm

|S| 279189 ⚠7.1.

0 43.5 0mm 3 64 2 41.5 2mm 5 64

Detail 7-4 ⚠Sliding sash 2x Ø 4.0

170x81 6.6.1. 22

|S| 279189 7.4.1. A./B.

7.4.2. |F| 279036, 279082 6.6.2. Ø 4.0 2-3x

⚠5.5. ⚠6.3. 22 A./B. 75

7.4.3. e.g. 2-3x Ø4.8x25mm Ø4.8x32mm Ø4.8x32mm Ø4.8x38mm

A./B.+|S|+|F| 7 mm A. B.

7.4. ... 6.6. ... A. B.

8-1 ⚠Sliding sash

170105 5.1. 7.3. Sash 100

8.1.1. 8.1.2. Nut

Frame BF barrier-free + ⚠Runner rail BF barrier-free

Schema D/F see Plan 09 T 01 ⚠ 09 T 02 ⚠ *

Schema A/C see Plan 09 T 01 ⚠ 09 T 03 ** 09 T 07 ***

A 9. 10. 11. ↕ or B C 1. 2. 3. 4.

197 42.5 112 42.5 48

FFL |S| 277202 A |S| 27729x ⚠ 6

|S| 277105 |S| 277107 B |U| 27726x

|S| 277180 * ⚠ 6 |S| 277106 |S| 277107 C * |S| 27729x

|U| 27726x A ↔ B ↔ C

|U| 27716x B ↔ C

197 42.5 112 42.5 27

|S| 277180 * ⚠ 6 |S| 277106 |S| 277107 C * |S| 277180 ⚠ 6

|U| 27716x Alternative or B = |S| 277105 + |S| 277107

* Runner rail-outside

** Fixed sash-outside

***FF fixframe (+ barrier-free ~ FFBF)

Sliding sash BF barrier-free

Schema A/C/D/F see Plan 09 T 04 D/F 09 T 05 A/D 09 T 06 C/F

5. 6. 7. 8.

170x81 |F| 279036, 279082 |S| 279189 A./B. 7 7

|S| 279189 |Z| 679330 |X| 479330

42.5 42.5

⚠Runner rail BF barrier-free

⚠|S| 27729x -> |U| 27726x 6

⚠|S| 277180 -> |U| 27716x -> |S| 277106 * see Frame 6

~~|S| 27727x~~ ~~|S| 27713x~~ 13

Symbols

FFL Finished Floor Level

Weather side / Outside

Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions Widths

	Schema A / Schema D	Schema C / Schema F	⚠uPVC	
A=	B-156	(B/2)-85	2 sashes	
B=	B	B	Element	
C=	(B/2)-199.5	(B/4)-164	Glass	
D=	(B/2)-29.5	(B/4)+6	Sash 1)	
E=	(B/2)-229.5	(B/4)-194	Sash clearance	
F=	(B/2)-111.5	(B/4)-76	Overall clearance	
G=	-	(B/2)-168	Overall clearance outside	
Bz=	B-8	B-8	Threshold, frame	
Ca=	-	-	Glass, deviant	
Da=	-	-	Sash, deviant	
Ea=	-	-	Sash clearance, deviant	

Vertical deduction dimensions Heights

	⚠uPVC		
h=	48mm	27mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

1) Weld shrinkage allowance to be added!

Horizontal sections A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections 1, 2, 3, ...

B H or 4b 8b 2b / 2fb 6b

B H or 2b / 2fb 6b 4b 8b 4b 8b 2b / 2fb 6b

chapter 09 Individual Handling page barrier-free

09 T Assembly Plans 08 Schema A/C/D/F BF

Frame Schema A/C BF barrier-free

Sliding sash BF barrier-free

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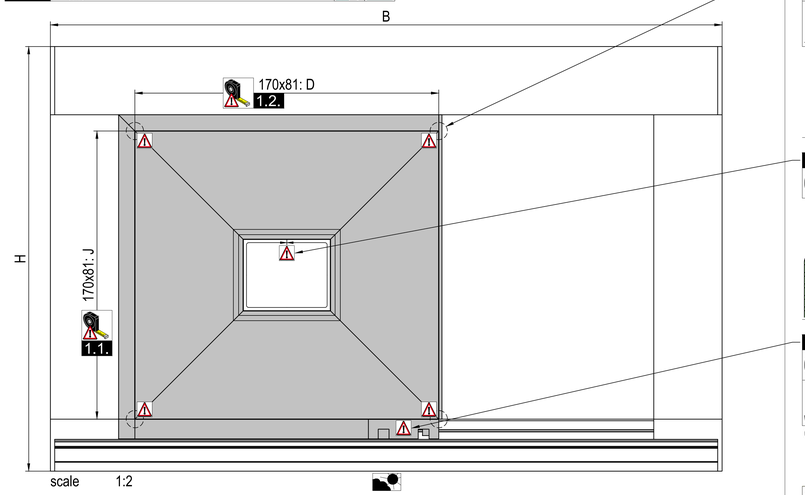
Lift-and-slide door 85mm

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *09_T_08_HST85* Issued: 2020-11 Language: en (English) / Englisch

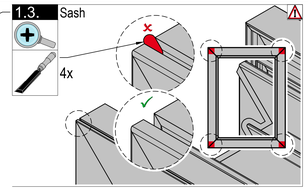
1. Attention: measure the dimensions 1.1. - 1.5.

Sash
170x81

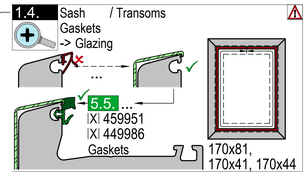


1.3. Sash

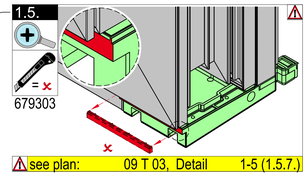
4x



1.4. Sash / Transoms Gaskets -> Glazing



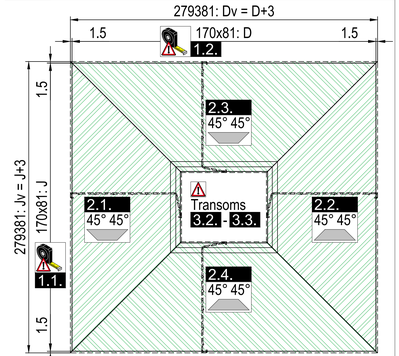
1.5.



⚠ see plan: 09 T 03, Detail 1-5 (1.5.7.)

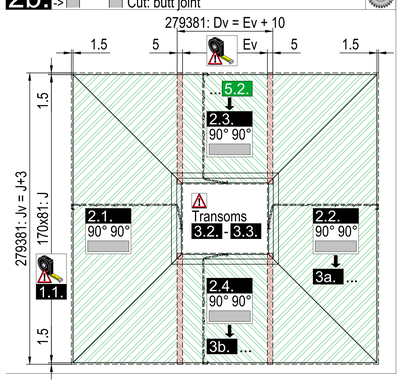
2a. Cutting 2.1. - 2.4.

-> Circular saw blade -> uPVC / aluminium
Cut: mitre joint



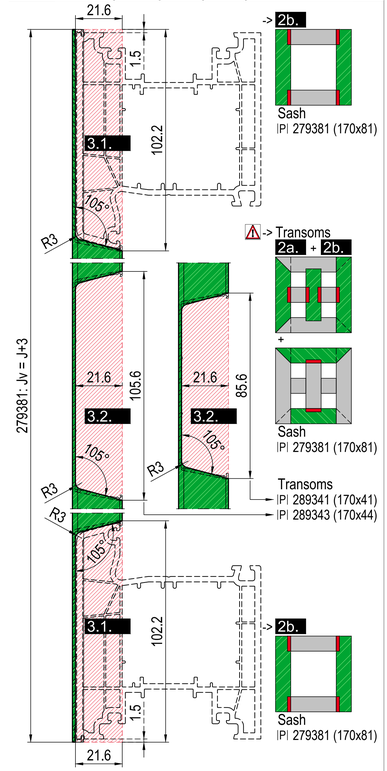
2b. Cutting 2.1. - 2.4.

-> Circular saw blade -> uPVC / aluminium
Cut: butt joint



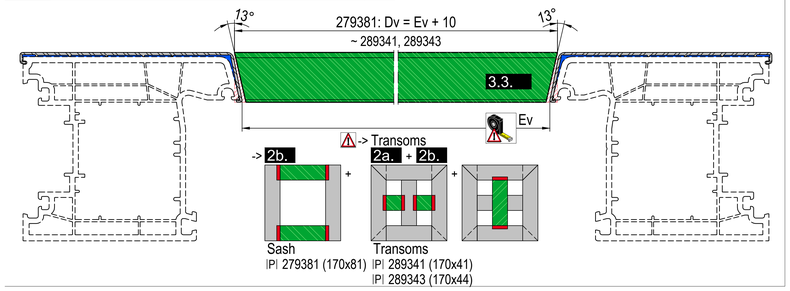
3a. Blanking 3.1. - 3.2.

Blanking:
Milling, sawing, cutting, drilling ...

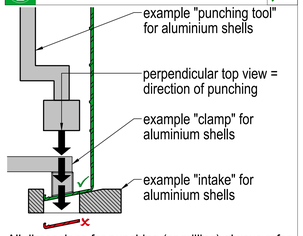


3b. Cutting 3.3.

Circular saw blade -> uPVC / aluminium



Blanking

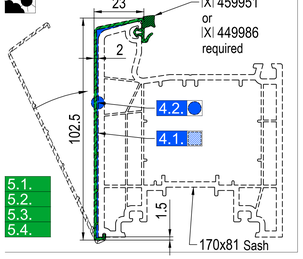


All dimensions for punching (or milling) always refer to a perpendicular top view (= direction of punching).

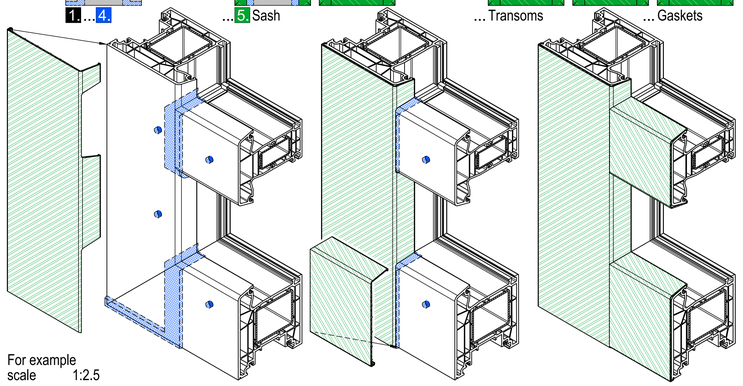
For punching, tools are required like (e.g.)
- punching tool
- clamp for aluminium shell
- intake for aluminium shell etc.

|P| 279381 (CL) SL 132mm
aluskin AU 260mm

Gaskets
⚠ 5.5.
|X| 459951
or
|X| 449986
required



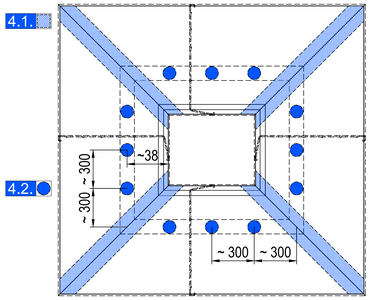
5.1.
5.2.
5.3.
5.4.



For example
scale 1:2.5

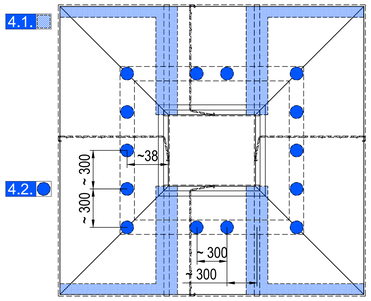
4a. Sealing / Gluing 4.1. - 4.2.

-> Silicone rubber
Cut: mitre joint
⚠ -> aluminium



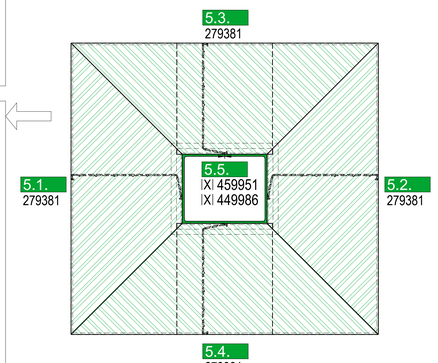
4b. Sealing / Gluing 4.1. - 4.2.

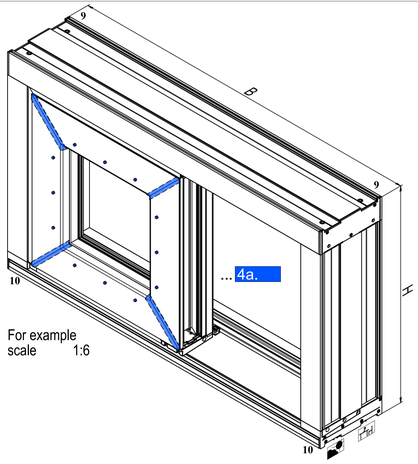
-> Silicone rubber
Cut: butt joint
⚠ -> aluminium



5. Assembly 5.1. - 5.5.

Clip or mount

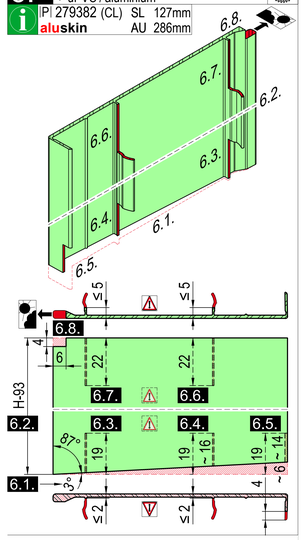




6. Cutting 6.1. - 6.8.

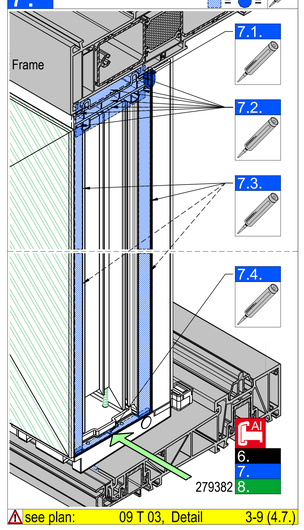
Circular saw blade
-> uPVC / aluminium

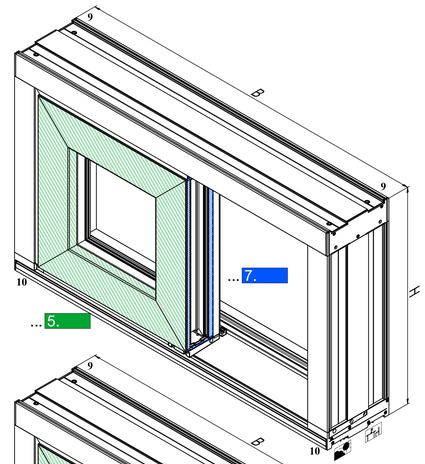
|P| 279382 (CL) SL 127mm
aluskin AU 286mm

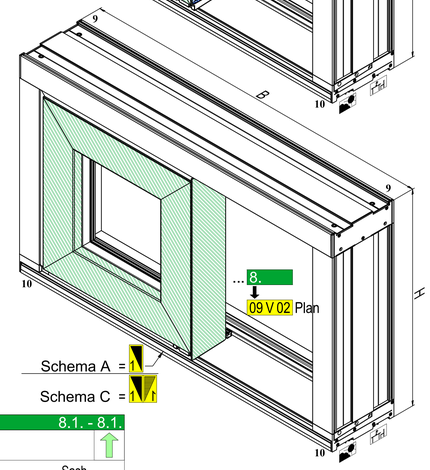


7. Sealing / Gluing 7.1. - 7.4

Silicone rubber
⚠ -> aluminium

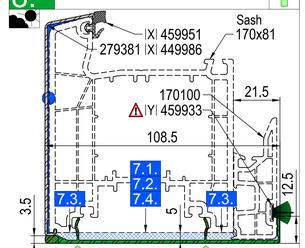






8. Assembly 8.1. - 8.1.

Clip or mount



Symbols

FFL Finished Floor Level

Weather side / Outside

Room side / Inside

Hardware Documents

GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions Widths

	Schema A / Schema D	Schema C / Schema F	⚠ uPVC	
A=	B-156	(B/2)-85	2	sashes
B=	B	B		Element
C=	(B/2)-199.5	(B/4)-164		Glass
D=	(B/2)-29.5	(B/4)+6		Sash 1)
E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

Vertical deduction dimensions Heights

			⚠ uPVC	
h=	48 mm	27 mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296	✓		Glass
J=	H-126	✓		Sash 1)
K=	H-326	✓		Sash clearance
L=	-	✓		Exterior frame
M=	-	✓		Interior frame
Hz=	H-111	✓ ...		Frame

...v aluskin Aluminium shells

1) Weld shrinkage allowance to be added!

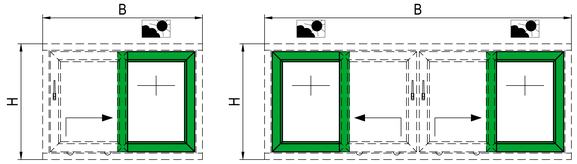
Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections

1, 2, 3, ...



chapter 09 Individual Handling
page

09 V Assembly Plans "v"

01 Schema A/C "v"

Fixed sash-outside

⚠ see manual Handling chapter 08 L - General aluskin Aluminium shells

Aluminium shells aluskin

aluplast Kunststoff-Fenstersysteme

www.aluplast.net

Lift-and-slide door 85mm

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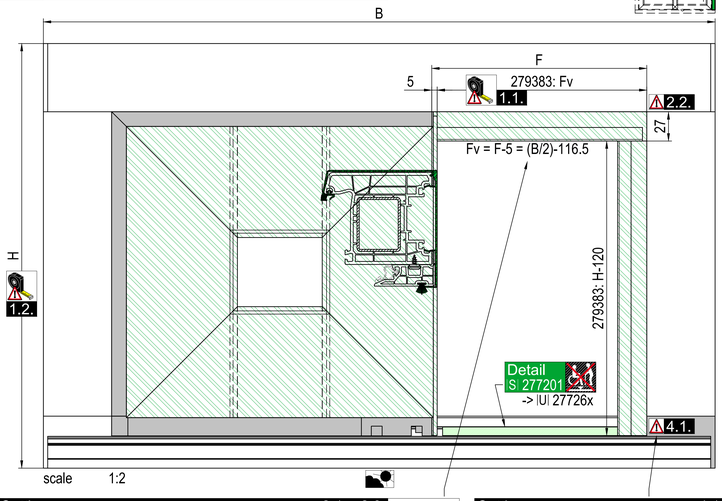
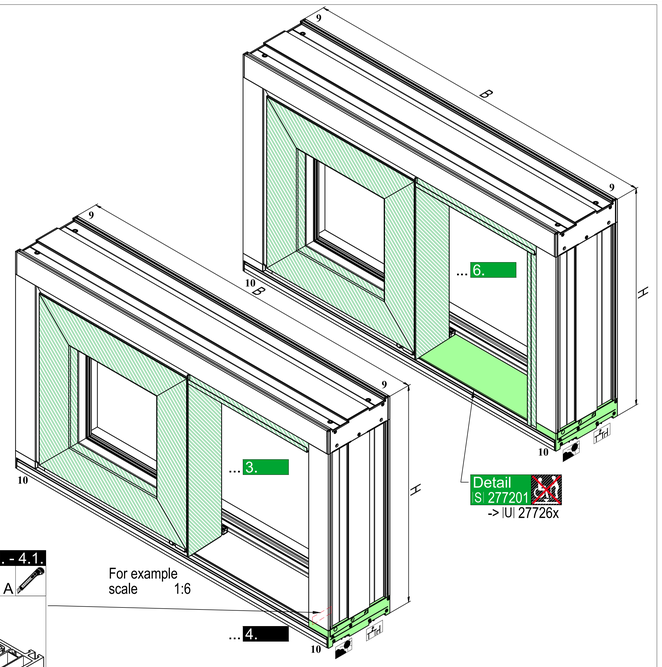
Attention: measure the dimensions 1.1. - 1.2.

1. A Sash 170x81

Schema A

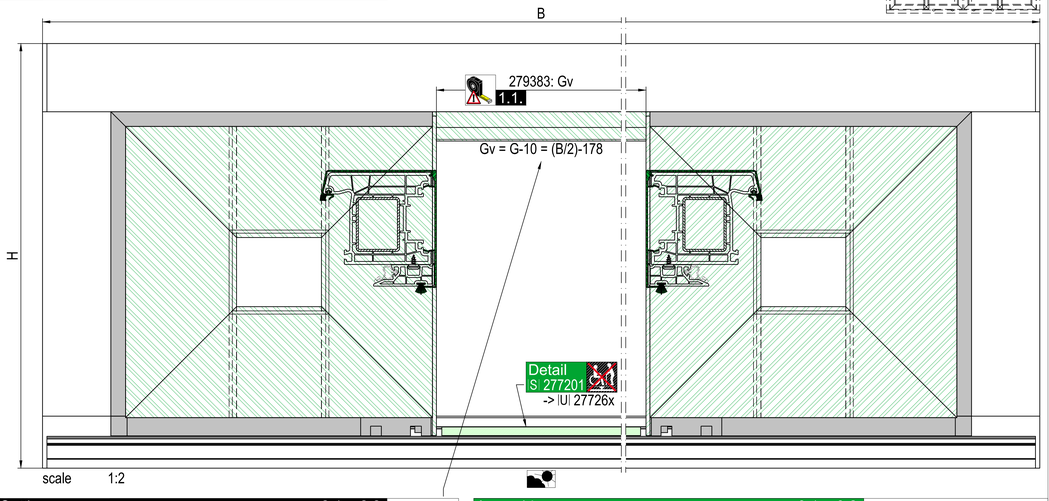




Attention: measure the dimensions 1.1. - 1.1.

1. C Sash 170x81

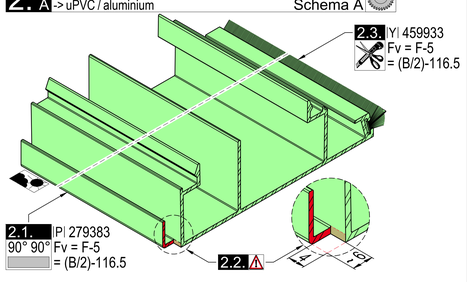
Schema C



Cutting 2.1. - 2.3.

2. A Circular saw blade -> uPVC / aluminium

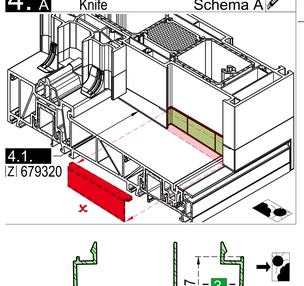
Schema A



Cutting 4.1. - 4.1.

4. A Cutting Knife

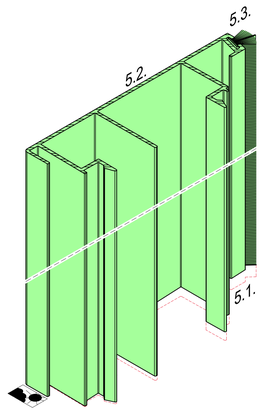
Schema A



Cutting 5.1. - 5.3.

5. A Circular saw blade -> uPVC / aluminium

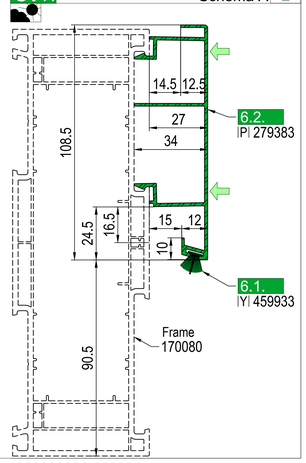
Schema A



Assembly 6.1. - 6.2.

6. A Clip or mount

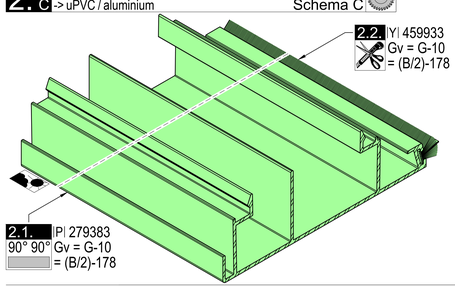
Schema A



Cutting 2.1. - 2.2.

2. C Circular saw blade -> uPVC / aluminium

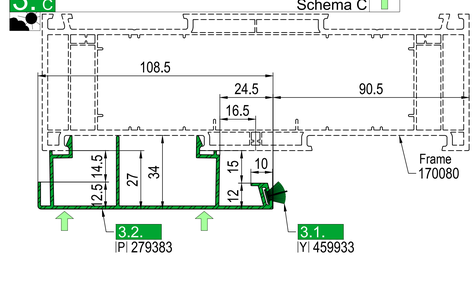
Schema C



Assembly 3.1. - 3.2.

3. C Clip or mount

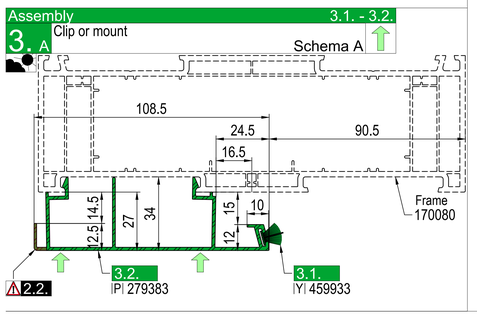
Schema C



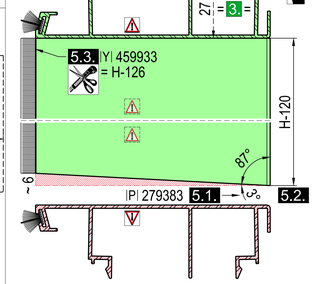
Assembly 3.1. - 3.2.

3. A Clip or mount

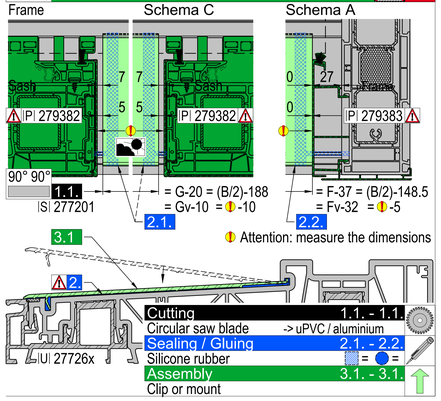
Schema A



Cutting 5.1. - 5.3.



Detail Schema A/C -> U 27726x



|P| 279383 (CL) SL 212mm
aluskin AU 516mm

Horizontal deduction dimensions — Widths

	Schema A / Schema D	Schema C / Schema F	uPVC	
A=	B-156	(B/2)-85	2 sashes	
B=	B	B	Element	
C=	(B/2)-199.5	(B/4)-164	Glass	
D=	(B/2)-29.5	(B/4)+6	Sash 1)	
E=	(B/2)-229.5	(B/4)-194	Sash clearance	
F=	(B/2)-111.5	(B/4)-76	Overall clearance	
G=	-	(B/2)-168	Overall clearance outside	
Bz=	B-8	B-8	Threshold, frame	
Ca=	-	-	Glass, deviant	
Da=	-	-	Sash, deviant	
Ea=	-	-	Sash clearance, deviant	

Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical deduction dimensions — Heights

		uPVC	
h=	48mm 27mm		Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

...v aluskin Aluminium shells

1) Weld shrinkage allowance to be added!

Vertical sections

1, 2, 3, ...

Symbols

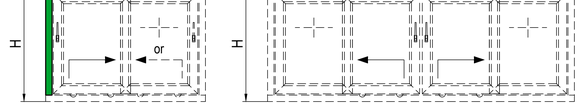
FFL — Finished Floor Level

Weather side / Outside

Room side / Inside

Hardware — Documents

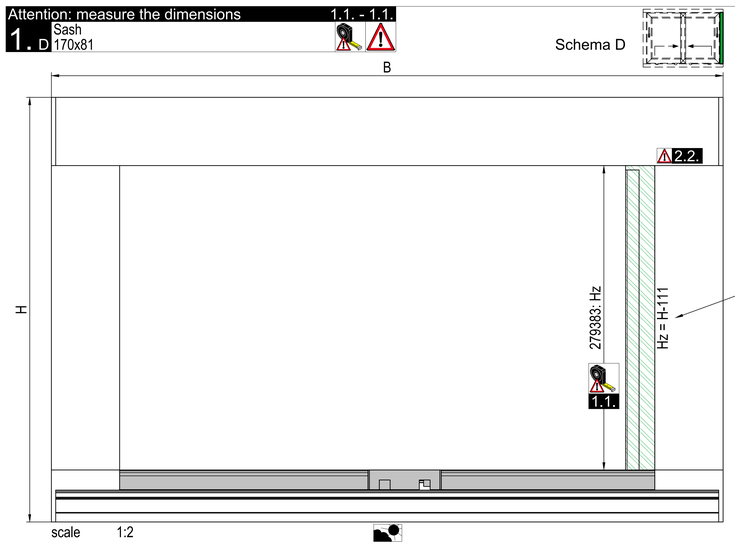
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)



Attention: measure the dimensions 1.1. - 1.1.

1. D Sash 170x81

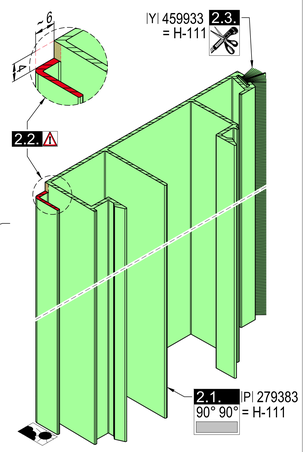
Schema D



Cutting 2.1. - 2.3.

2. D Circular saw blade -> uPVC / aluminium

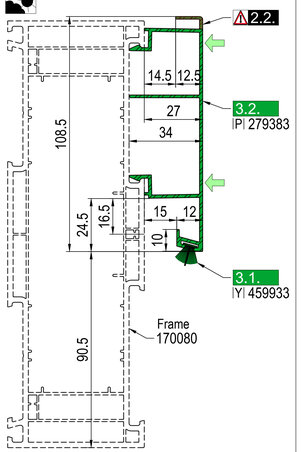
Schema D



Assembly 3.1. - 3.2.

3. D Clip or mount

Schema D



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09 V Assembly Plans "v"

02 Schema A/C/D "v"

279383 Cover profile

see manual Handling chapter 08 L - General aluskin Aluminium shells

Aluminium shells aluskin

Lift-and-slide door 85mm

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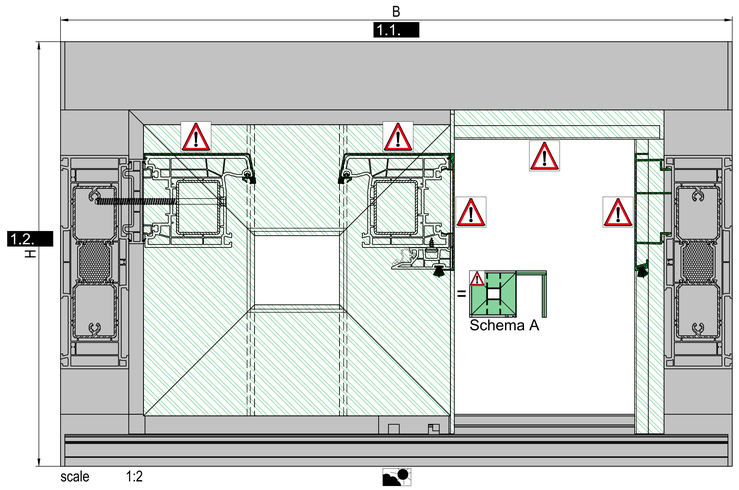
DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *09_V_02_HST85* Issued: 2020-11 Language: en (English) / Englisch

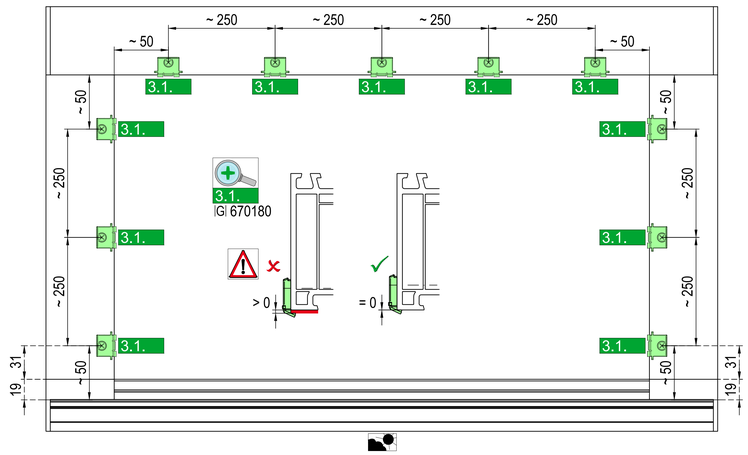
Attention: measure the dimensions 1.1. - 1.2.

1.



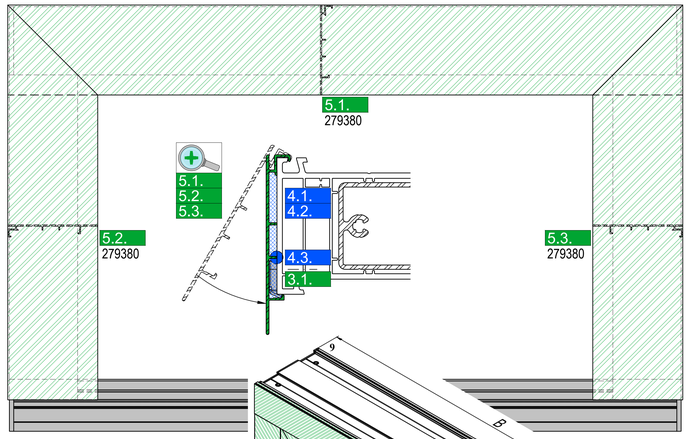
Assembly 3.1. - 3.1.

3. Screws
... ~4.0x22mm + ... |G| 670180



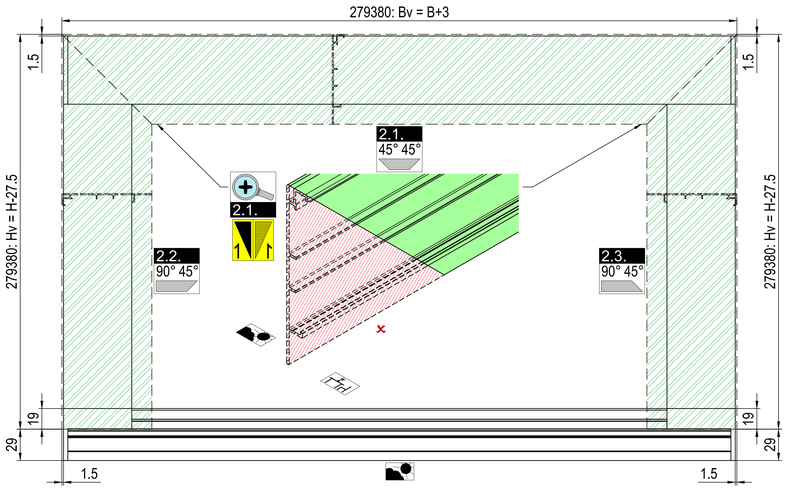
Assembly 5.1. - 5.3.

5. Clip or mount



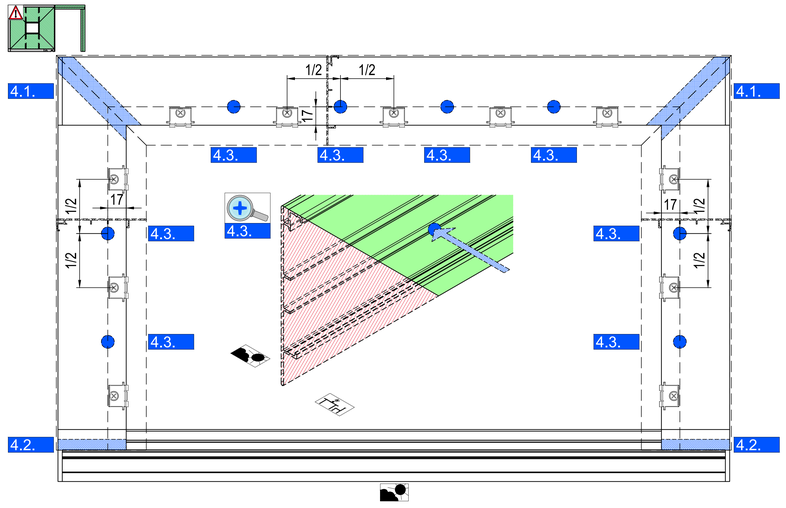
Cutting 2.1. - 2.3.

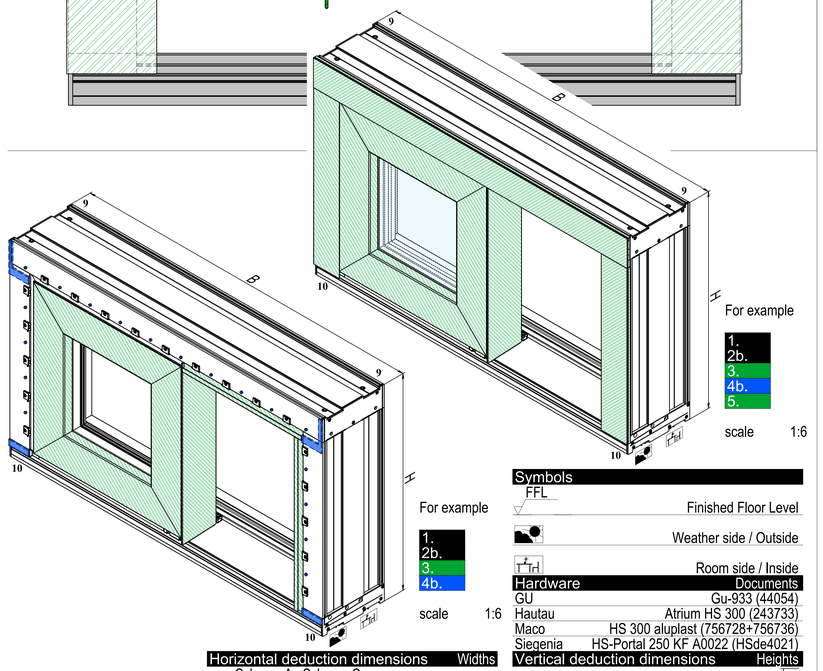
2a. -> Circular saw blade -> uPVC / aluminium
Cut: mitre joint



Sealing / Gluing 4.1. - 4.3.

4a. -> Silicone rubber -> aluminium
Cut: mitre joint





Symbols

FFL	Finished Floor Level
	Weather side / Outside
	Room side / Inside

Hardware	Documents
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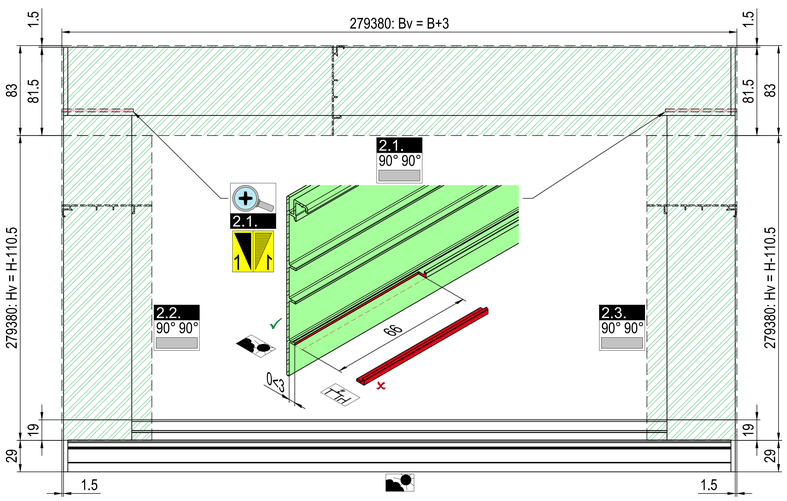
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

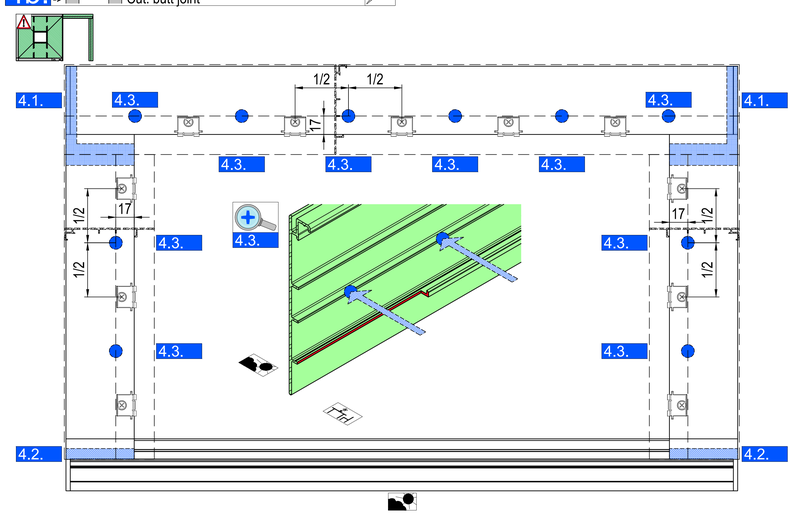
Cutting 2.1. - 2.3.

2b. -> Circular saw blade -> uPVC / aluminium
Cut: butt joint



Sealing / Gluing 4.1. - 4.3.

4b. -> Silicone rubber -> aluminium
Cut: butt joint



Horizontal deduction dimensions	Schema A / Schema D	Schema C / Schema F	Widths uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
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Vertical deduction dimensions			Heights uPVC
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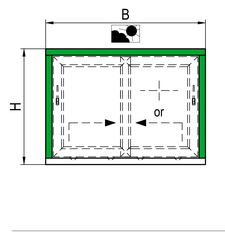
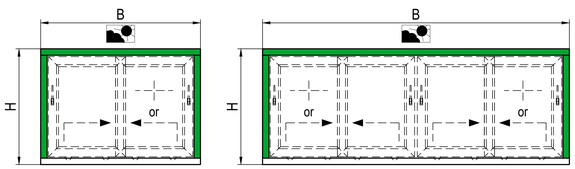
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

...v **aluskin** Aluminium shells
1) Weld shrinkage allowance to be added!

Horizontal sections A, B, C, ...
▫ / ▪ Stopper left / right (where required)

Vertical sections 1, 2, 3, ...





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09 V Assembly Plans "v" — **03 Schema A/C/D/F "v"**

279380 + Frame

aluplast Kunststoff-Fenstersysteme

see manual Handling - General chapter 08 L **aluskin** Aluminium shells

Aluminium shells **aluskin**

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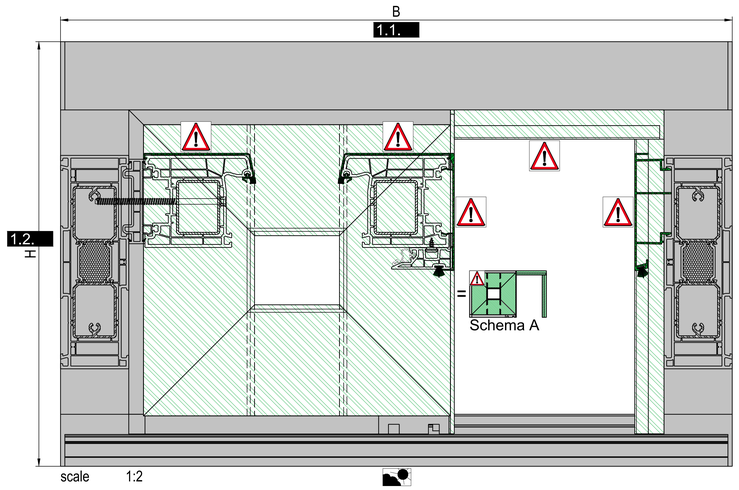
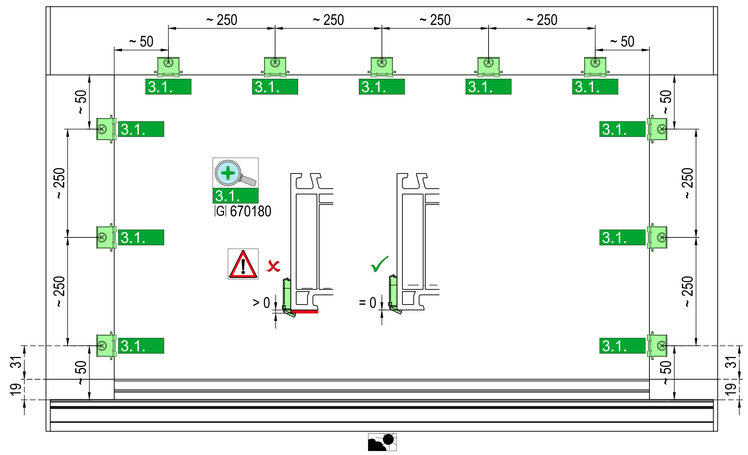
Attention: measure the dimensions 1.1. - 1.2.

1.



Assembly 3.1. - 3.1.

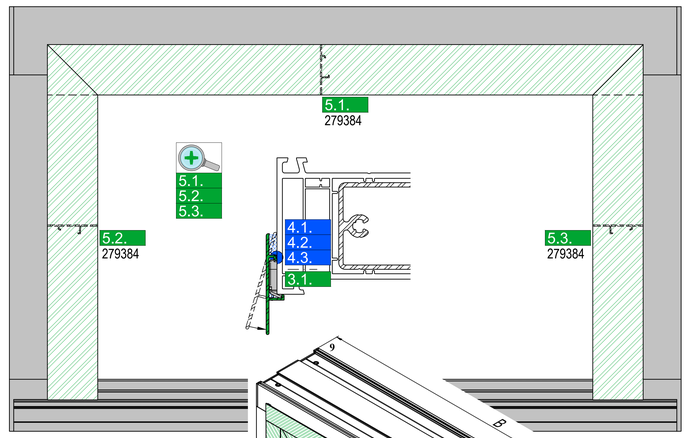
3. Screws ... ~4.0x22mm + ... G 670180



Assembly 5.1. - 5.3.

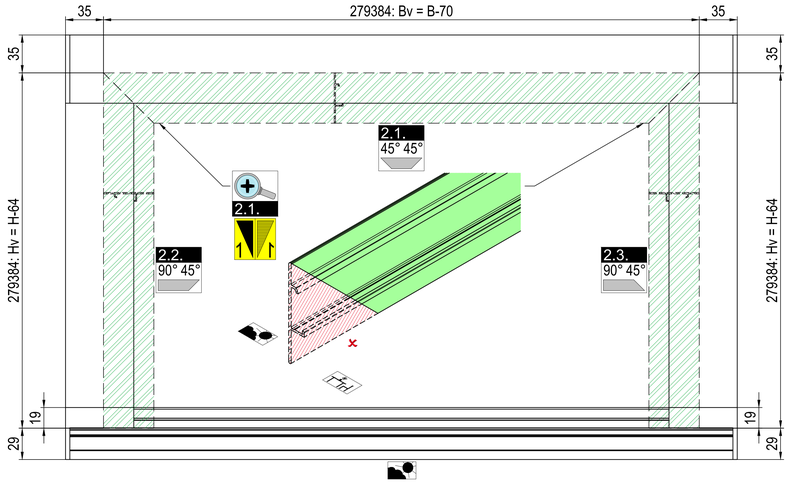
5. Clip or mount

Driving-rain resistant Connection to wall e.g. ILLMOD 600 15/7-12



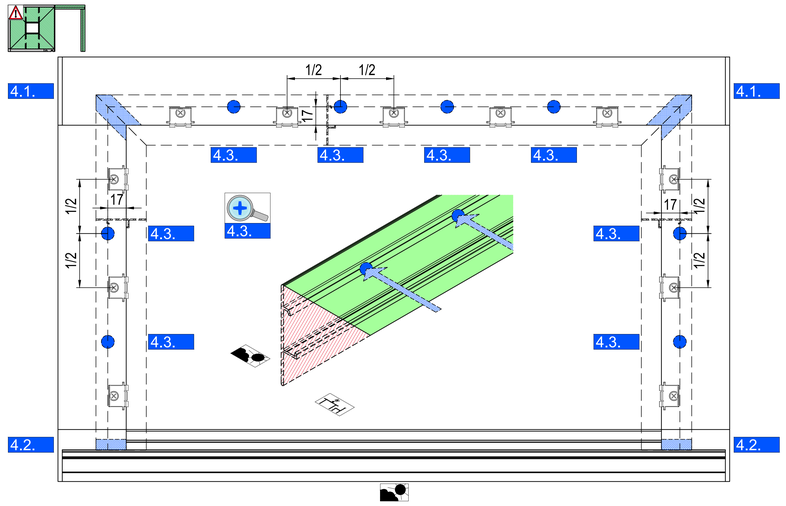
Cutting 2.1. - 2.3.

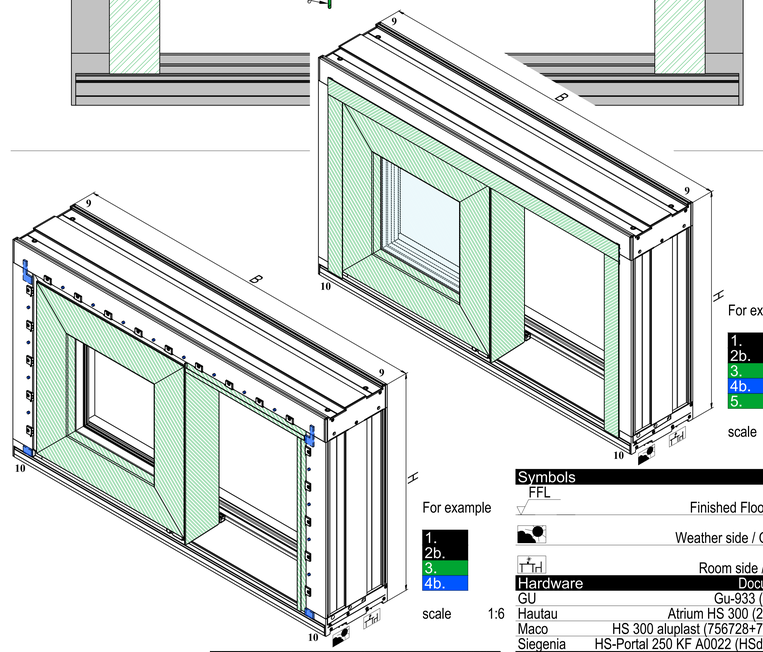
2a. -> Circular saw blade -> uPVC / aluminium
Cut: mitre joint



Sealing / Gluing 4.1. - 4.3.

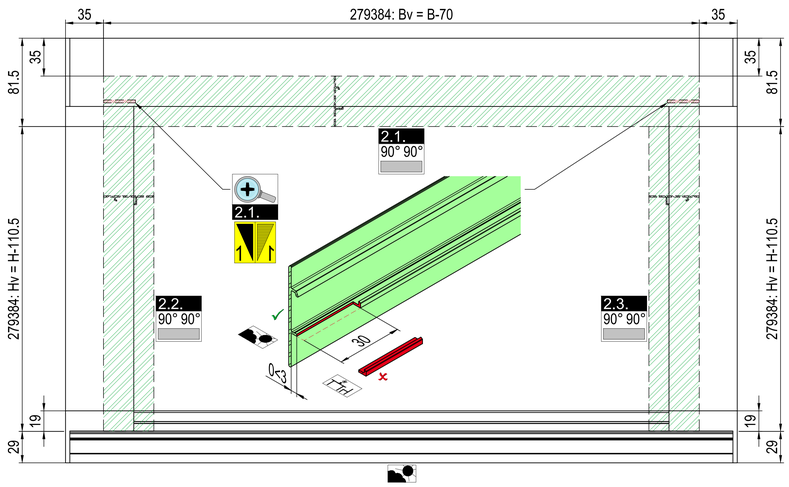
4a. -> Silicone rubber -> aluminium
Cut: mitre joint





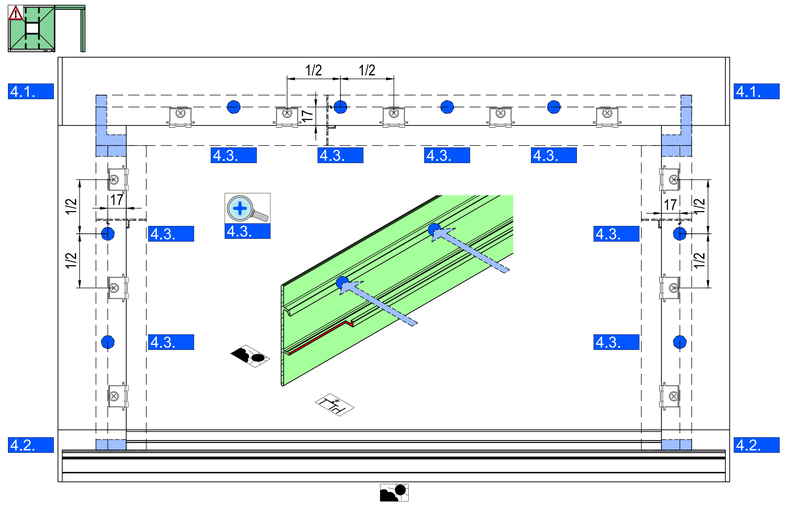
Cutting 2.1. - 2.3.

2b. -> Circular saw blade -> uPVC / aluminium
Cut: butt joint

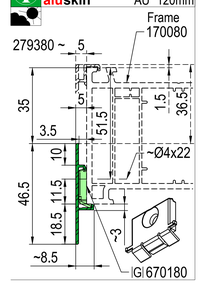


Sealing / Gluing 4.1. - 4.3.

4b. -> Silicone rubber -> aluminium
Cut: butt joint



P 279384 (CL) SL 75mm
aluskin AU 120mm



Symbols

FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware	Documents
GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions Widths

	Schema A	Schema C	
	Schema D	Schema F	uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Vertical deduction dimensions Heights

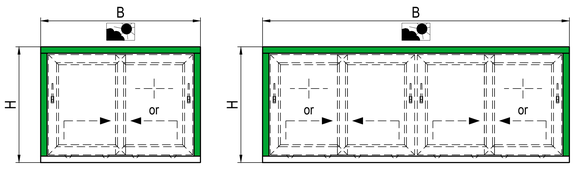
		uPVC	
h=	48mm	27mm	Threshold U
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

...v aluskin Aluminium shells
1) Weld shrinkage allowance to be added!

Horizontal sections
A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections
1, 2, 3, ...



chapter 09 Individual Handling
page

09 V Assembly Plans "v"
04 Schema A/C/D/F "v"

see manual Handling chapter 08 L - General aluskin Aluminium shells
279384 + Frame
Aluminium shells aluskin

aluplast Kunststoff-Fenstersysteme
www.aluplast.net
Lift-and-slide door 85mm

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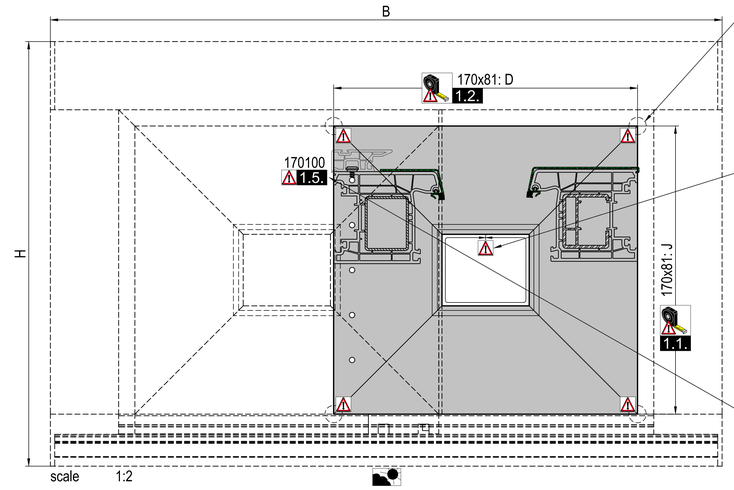
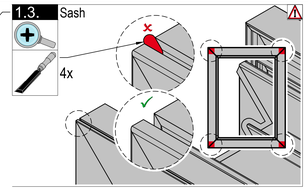
1. Attention: measure the dimensions 1.1. - 1.5.

Sash 170x81

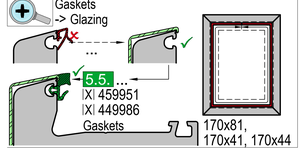


1.3. Sash

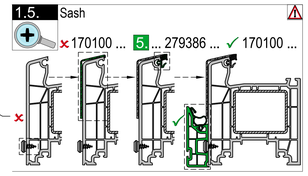


1.4. Sash / Transoms

Gaskets -> Glazing

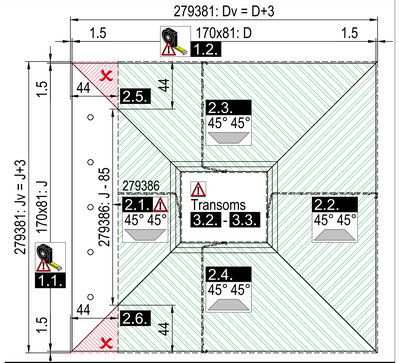


1.5. Sash



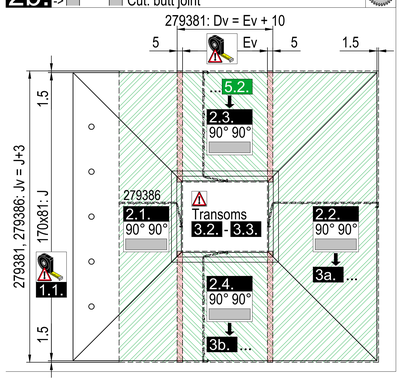
2a. Cutting 2.1. - 2.6.

Circular saw blade -> uPVC / aluminium
Cut: mitre joint



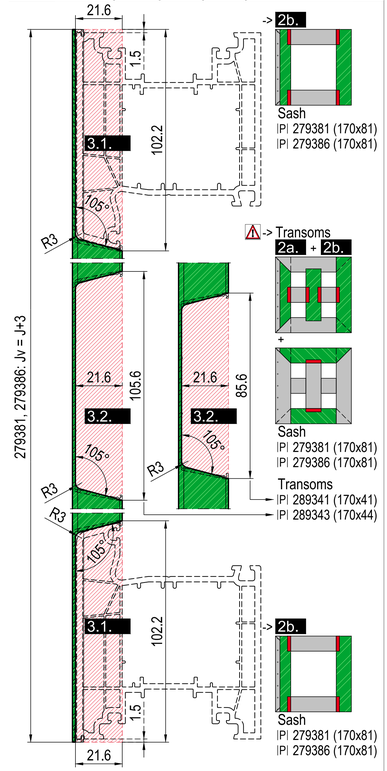
2b. Cutting 2.1. - 2.4.

Circular saw blade -> uPVC / aluminium
Cut: butt joint



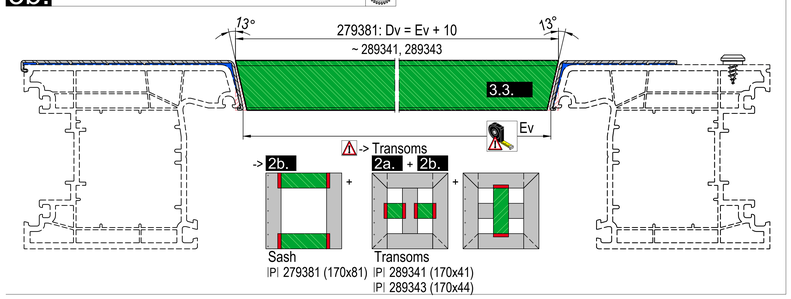
3a. Blanking 3.1. - 3.2.

Blanking:
Milling, sawing, cutting, drilling ...

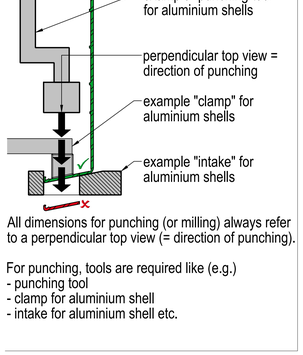


3b. Cutting 3.3.

Circular saw blade -> uPVC / aluminium



Blanking

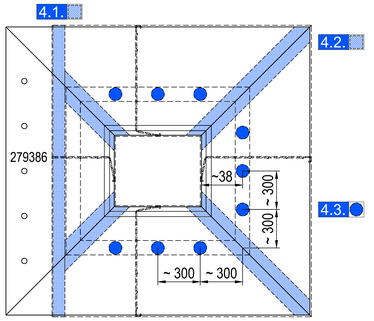


All dimensions for punching (or milling) always refer to a perpendicular top view (= direction of punching).

For punching, tools are required like (e.g.)
- punching tool
- clamp for aluminium shell
- intake for aluminium shell etc.

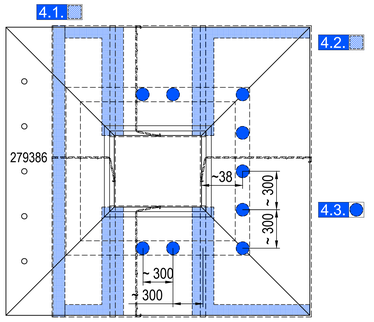
4a. Sealing / Gluing 4.1. - 4.3.

-> Silicone rubber
Cut: mitre joint
-> aluminium



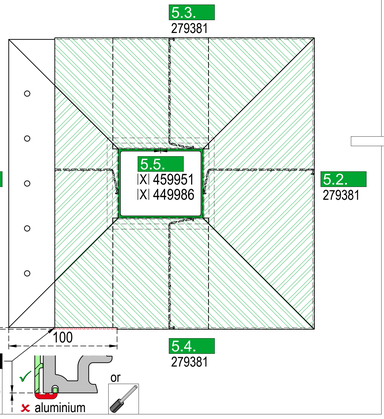
4b. Sealing / Gluing 4.1. - 4.3.

-> Silicone rubber
Cut: butt joint
-> aluminium

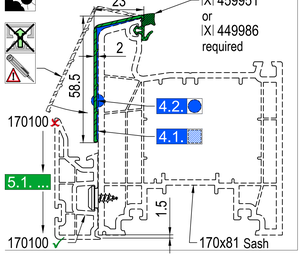


5. Assembly 5.1. - 5.6.

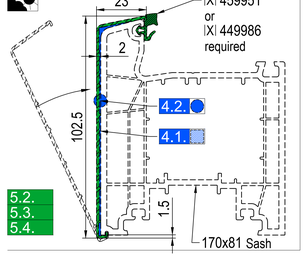
Clip or mount
Circular saw blade -> uPVC / aluminium

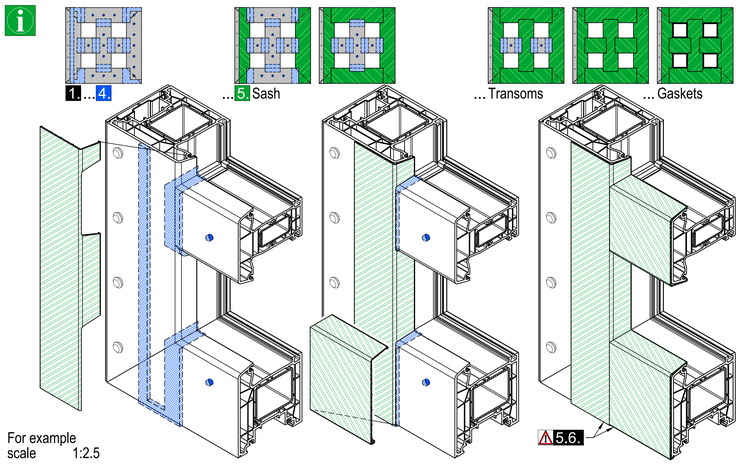


|P| 279386 (CL) SL 84mm Gaskets
aluskin AU 160mm



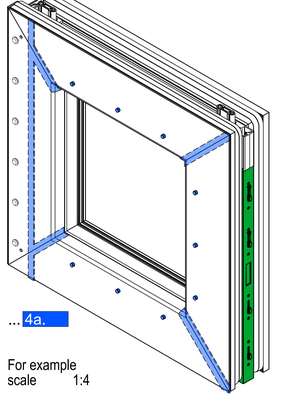
|P| 279381 (CL) SL 132mm Gaskets
aluskin AU 260mm

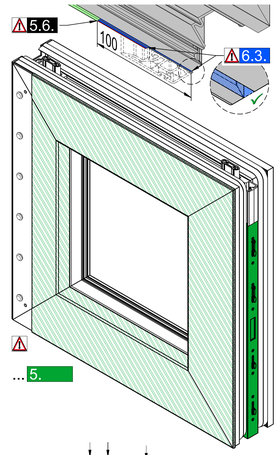




Sealing / Gluing 4.1. - 4.3.

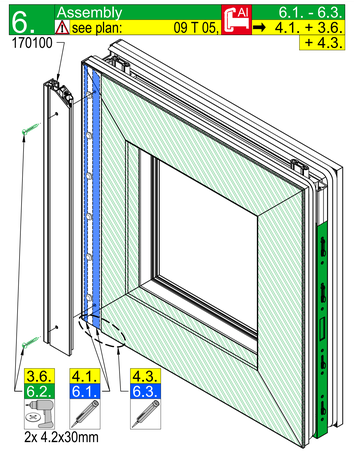
-> Silicone rubber
Cut: mitre joint
-> aluminium

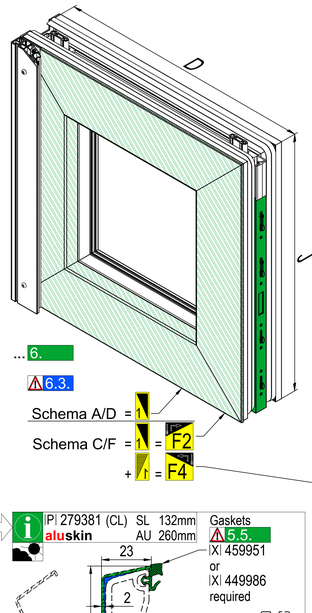


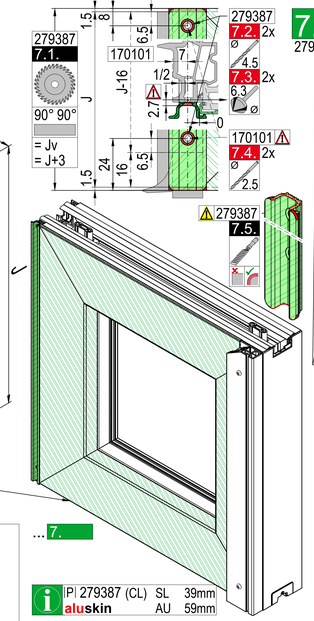


6. Assembly 6.1. - 6.3.

see plan: 09 T 05, -> 4.1. + 3.6. + 4.3.

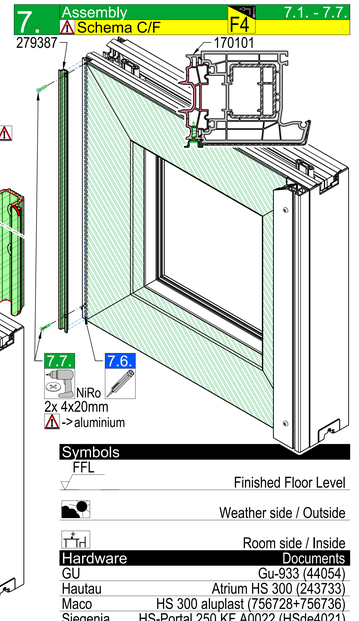






7. Assembly 7.1. - 7.7.

Schema C/F F4



|P| 279387 (CL) SL 39mm
aluskin AU 59mm

Symbols

FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware Documents

GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions Widths

	Schema A / Schema D	Schema C / Schema F	uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Vertical deduction dimensions Heights

		uPVC	
h=	48mm	27mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

...v aluskin Aluminium shells
1) Weld shrinkage allowance to be added!

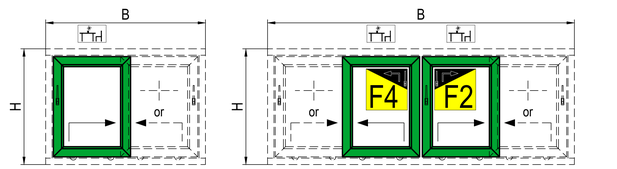
Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical sections

1, 2, 3, ...



chapter 09 Individual Handling
09 V Assembly Plans "v"
see manual Handling chapter 08 L - General aluskin Aluminium shells

page
05 Schema A/C/D/F "v"
Sliding sash-Inside
Aluminium shells aluskin
Lift-and-slide door 85mm

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www.aluplast.net

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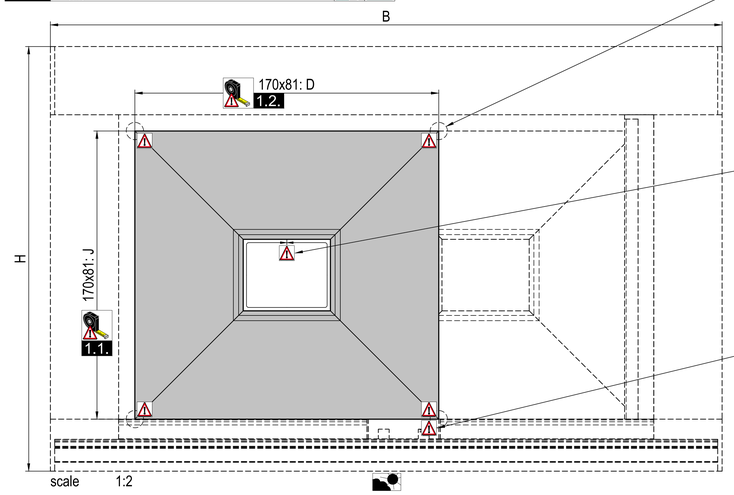
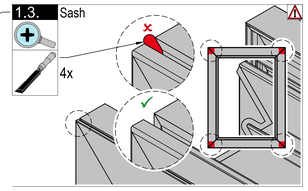
1. Attention: measure the dimensions 1.1. - 1.4.

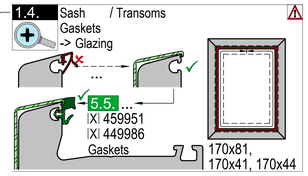
Sash 170x81



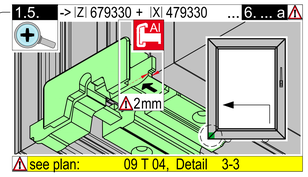
1.3. Sash



1.4. Sash / Transoms Gaskets -> Glazing



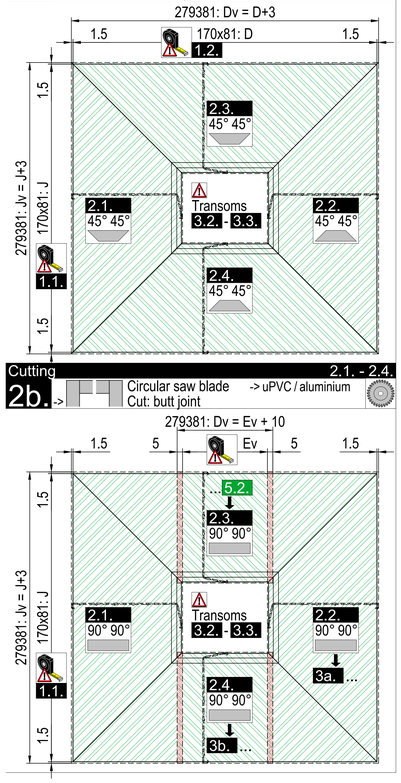
1.5. -> |Z| 679330 + |X| 479330 ... 6. ... a



see plan: 09 T 04, Detail 3-3

2a. Cutting 2.1. - 2.4.

Circular saw blade -> uPVC / aluminium
Cut: mitre joint

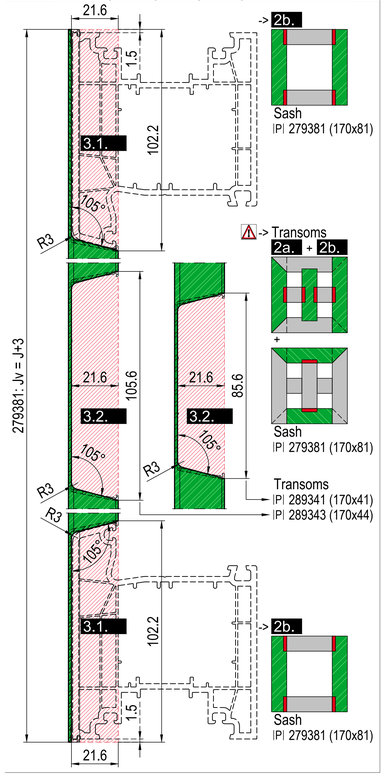


2b. Cutting 2.1. - 2.4.

Circular saw blade -> uPVC / aluminium
Cut: butt joint

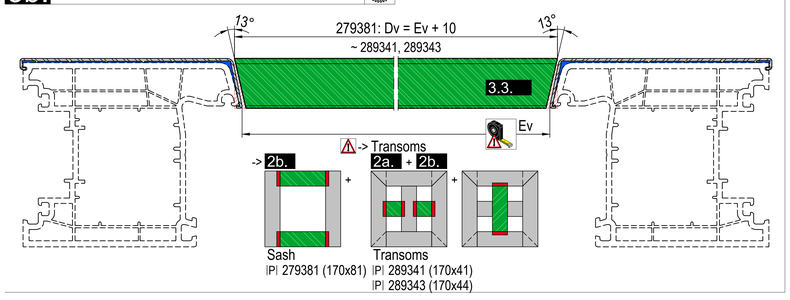
3a. Blanking 3.1. - 3.2.

Blanking:
Milling, sawing, cutting, drilling ...

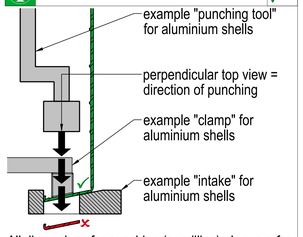


3b. Cutting 3.3.

Circular saw blade -> uPVC / aluminium



Blanking

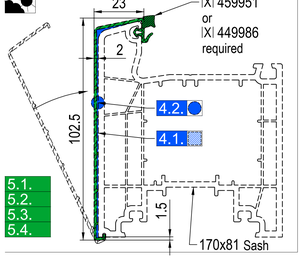


All dimensions for punching (or milling) always refer to a perpendicular top view (= direction of punching).

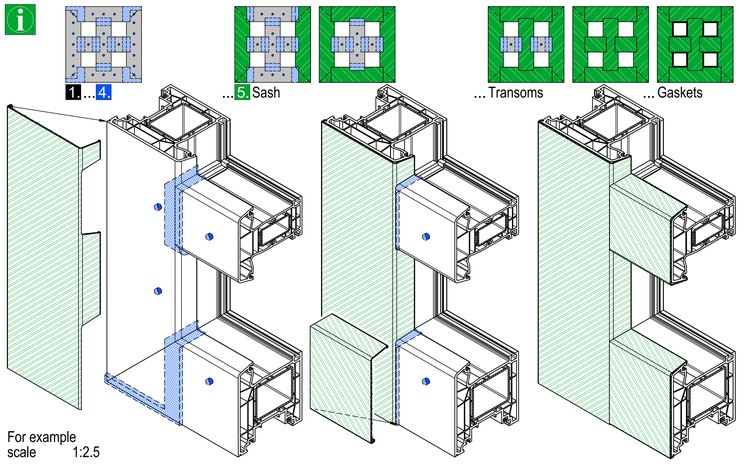
For punching, tools are required like (e.g.)
- punching tool
- clamp for aluminium shell
- intake for aluminium shell etc.

|P| 279381 (CL) SL 132mm
aluskin AU 260mm

Gaskets 5.5.
|X| 459951
or
|X| 449986
required

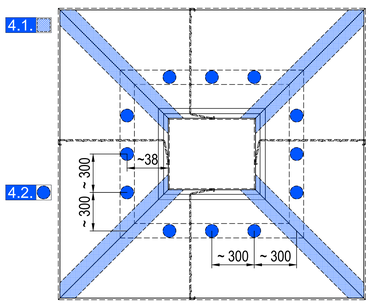


5.1. 5.2. 5.3. 5.4.



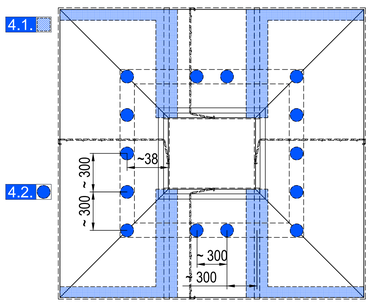
4a. Sealing / Gluing 4.1. - 4.2.

Silicone rubber -> aluminium
Cut: mitre joint



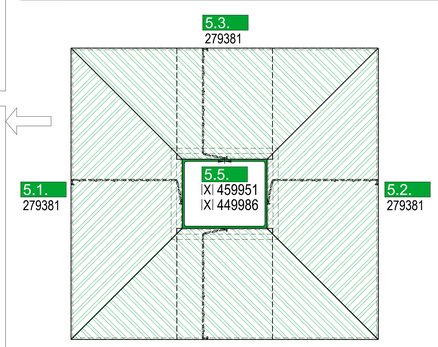
4b. Sealing / Gluing 4.1. - 4.2.

Silicone rubber -> aluminium
Cut: butt joint



5. Assembly 5.1. - 5.5.

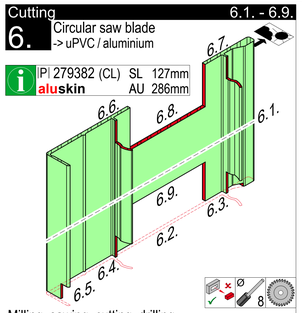
Clip or mount



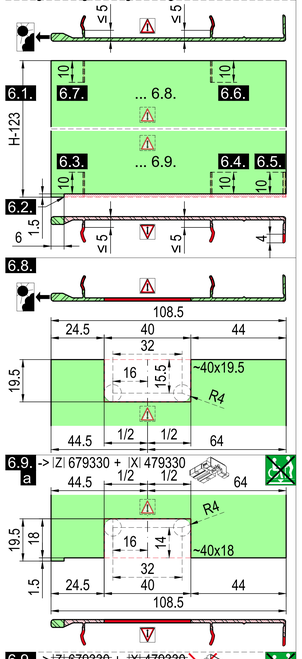
6. Cutting 6.1. - 6.9.

Circular saw blade -> uPVC / aluminium

|P| 279382 (CL) SL 127mm
aluskin AU 286mm

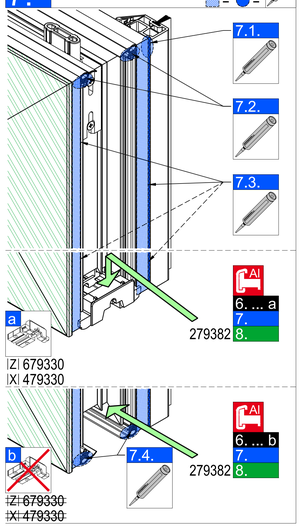


Milling, sawing, cutting, drilling ...



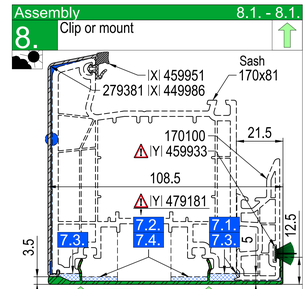
7. Sealing / Gluing 7.1. - 7.4.

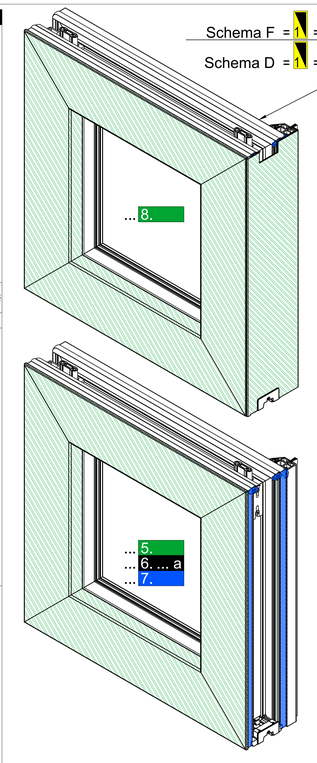
Silicone rubber -> aluminium



8. Assembly 8.1. - 8.1.

Clip or mount





Symbols

FFL Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware

GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

Horizontal deduction dimensions

	Schema A	Schema C	Widths
	Schema D	Schema F	uPVC
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

Vertical deduction dimensions

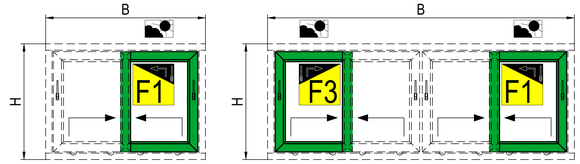
			Heights
			uPVC
h=	48 mm	27 mm	Threshold |U|
H=	H	H'+21	Element
I=	H-296	✓	Glass
J=	H-126	✓	Sash 1)
K=	H-326	✓	Sash clearance
L=	-	✓	Exterior frame
M=	-	✓	Interior frame
Hz=	H-111	✓ ...	Frame

...v aluskin Aluminium shells

1) Weld shrinkage allowance to be added!

Vertical sections

1, 2, 3, ...



chapter 09 Individual Handling
page

09 V Assembly Plans "v"

06 Schema D/F "v"

Sliding sash-Outside

see manual Handling chapter 08 L - General aluskin Aluminium shells

Aluminium shells aluskin

aluplast Kunststoff-Fenstersysteme

www.aluplast.net

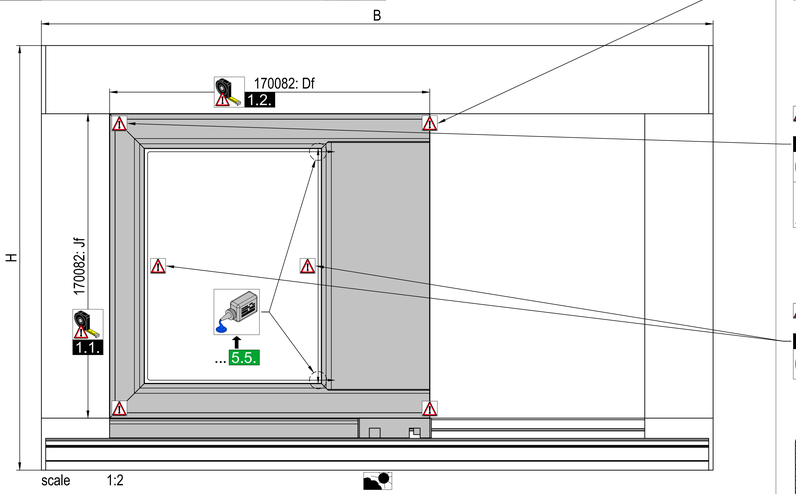
Lift-and-slide door 85mm

May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

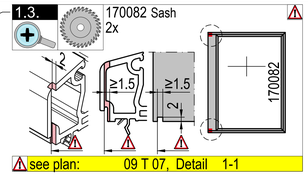
DIN A0->DIN A4/DIN A3 Draughtsman: RTH Filename: *09_V_06_HST85* Issued: 2020-11 Language: en (English) / Englisch

Attention: measure the dimensions 1.1. - 1.5.

1. Sash
170x81 + 170082

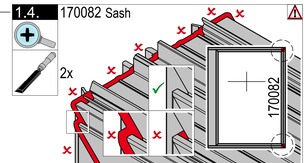


1.3. 170082 Sash
2x



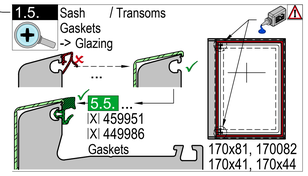
see plan: 09 T 07, Detail 1-1

1.4. 170082 Sash
2x



see plan: 09 T 07, Detail 1-2

1.5. Sash / Transoms
Gaskets
-> Glazing



170x81, 170082
170x41, 170x44

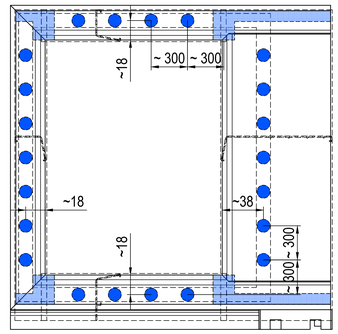
Sealing / Gluing

4a. -> Cut: mitre joint

Sealing / Gluing 4.1. - 4.2.

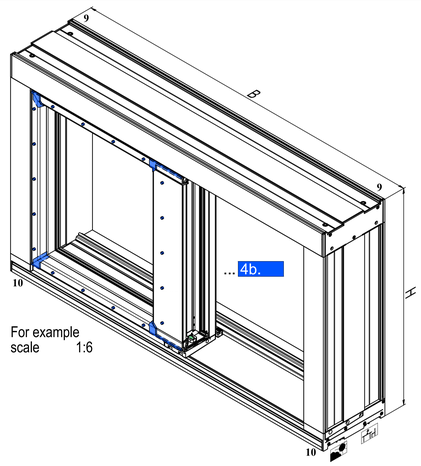
4b. -> Silicone rubber
Cut: butt joint
-> aluminium

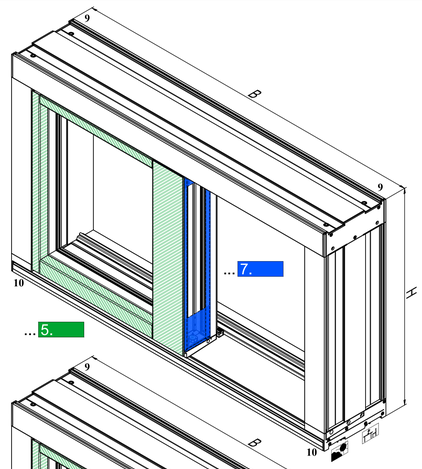
4.1.
4.2.

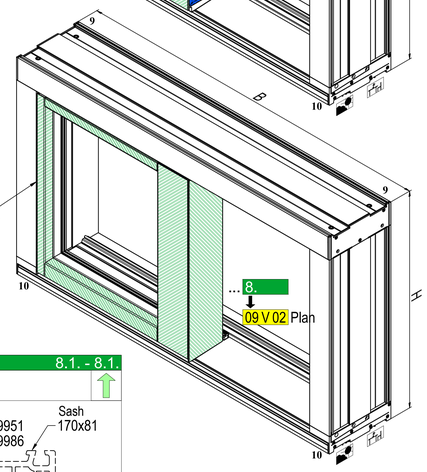


Assembly 5.1. - 5.5.

5. Clip or mount







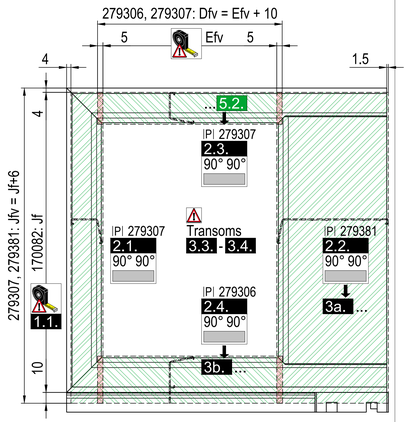
Schema A =
Schema C =

Cutting

2a. -> Cut: mitre joint

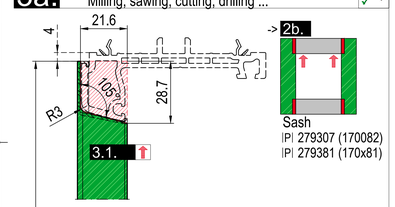
Cutting 2.1. - 2.4.

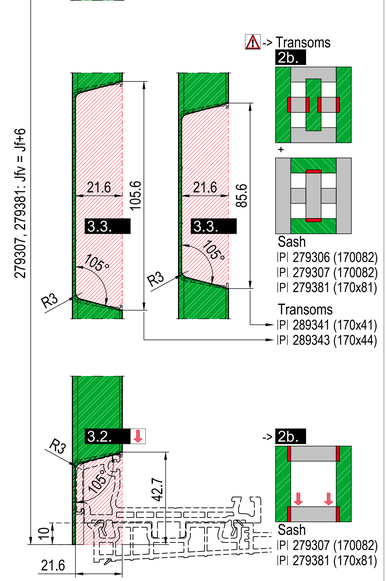
2b. -> Circular saw blade -> uPVC / aluminium
Cut: butt joint



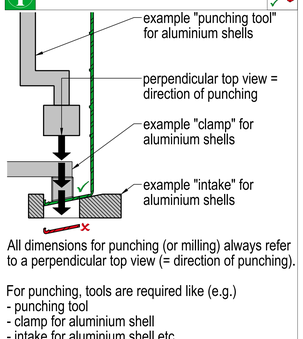
Blanking 3.1. - 3.3.

3a. Blanking:
Milling, sawing, cutting, drilling ...





Blanking

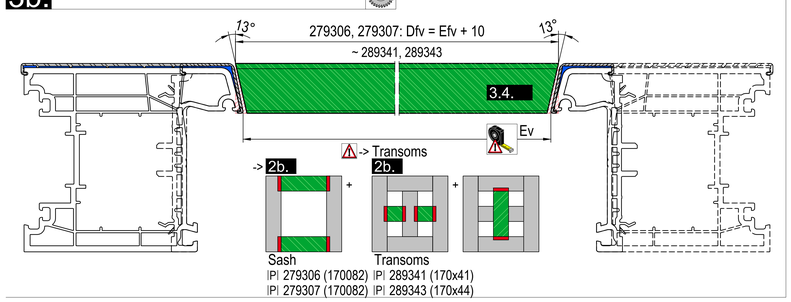


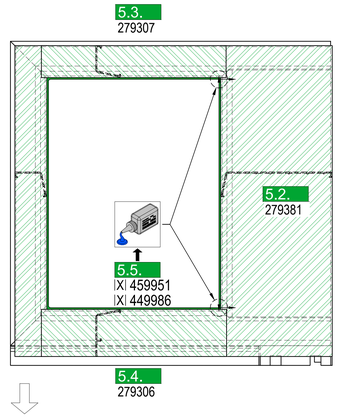
All dimensions for punching (or milling) always refer to a perpendicular top view (= direction of punching).

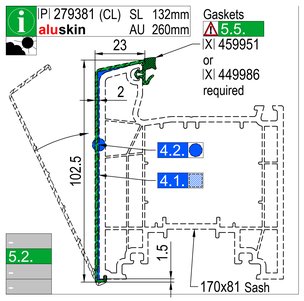
For punching, tools are required like (e.g.)
- punching tool
- clamp for aluminium shell
- intake for aluminium shell etc.

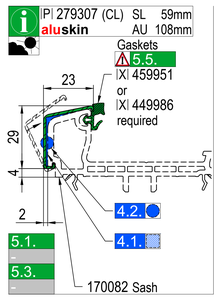
Cutting 3.4.

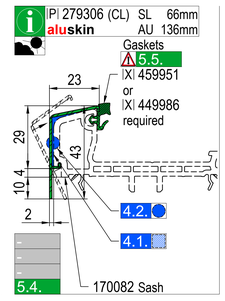
3b. Circular saw blade -> uPVC / aluminium

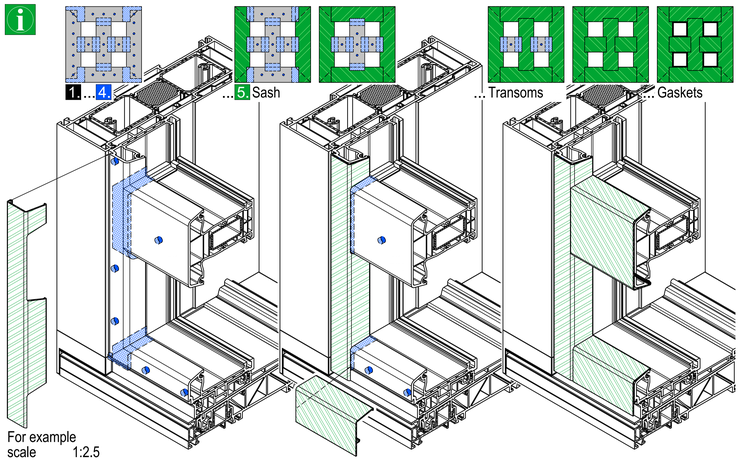








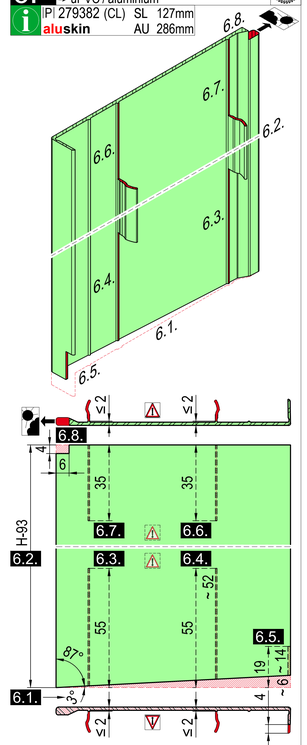




Cutting 6.1. - 6.8.

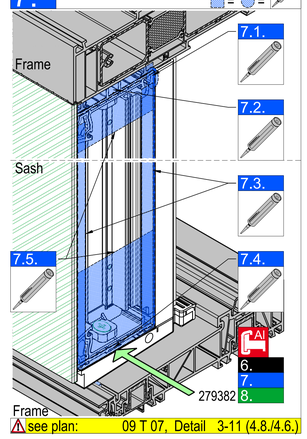
6. Circular saw blade
-> uPVC / aluminium

|P| 279382 (CL) SL 127mm
aluskin AU 286mm



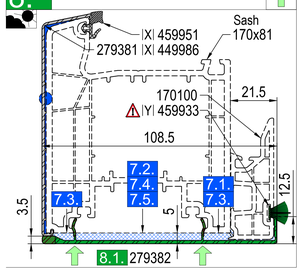
Sealing / Gluing 7.1. - 7.5.

7. Silicone rubber
-> aluminium



Assembly 8.1. - 8.1.

8. Clip or mount



Horizontal deduction dimensions Widths

	Schema A	Schema C	
...f	fixframe	fixframe	uPVC
Af=	B-141	(B/2)-70	2 sashes
Cf=	(B/2)-116.5	(B/4)-81	Glass
Df=	(B/2)-14.5	(B/4)+21	Sash 1)
Ef=	(B/2)-146.5	(B/4)-111	Sash clearance
A=	B-156	(B/2)-85	2 sashes
B=	B	B	Element
C=	(B/2)-199.5	(B/4)-164	Glass
D=	(B/2)-29.5	(B/4)+6	Sash 1)
E=	(B/2)-229.5	(B/4)-194	Sash clearance
F=	(B/2)-111.5	(B/4)-76	Overall clearance
G=	-	(B/2)-168	Overall clearance outside
Bz=	B-8	B-8	Threshold, frame
Ca=	-	-	Glass, deviant
Da=	-	-	Sash, deviant
Ea=	-	-	Sash clearance, deviant

Horizontal sections
A, B, C, ...

▫ / ▫ Stopper left / right (where required)

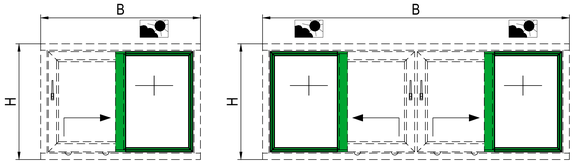
Vertical deduction dimensions Heights

		...f	fixframe	uPVC
h=	48mm	27mm		Threshold |U|
H=	H	H'+21	H= H	Element
I=	H-296	✓	If= H-145	Glass
J=	H-126	✓	Jf= H-111	Sash 1)
K=	H-326	✓	Kf= H-175	Sash clearance
L=	-	✓	-	Exterior frame
M=	-	✓	-	Interior frame
Hz=	H-111	✓ ...	Hz= H-111	Frame

...v **aluskin** Aluminium shells

1) Weld shrinkage allowance to be added!

Vertical sections
1, 2, 3, ...



Symbols

FFL Finished Floor Level

Weather side / Outside

Room side / Inside

Hardware Documents

GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

chapter 09 Individual Handling
page

09 V Assembly Plans "v"
07 Schema A/C "v" FF

see manual Handling chapter 08 L - General **aluskin** Aluminium shells

Fixed sash-outside

(small) Fixed sash FF fixframe

Aluminium shells **aluskin**

aluplast Kunststoff-Fenstersysteme

www.aluplast.net

Lift-and-slide door 85mm

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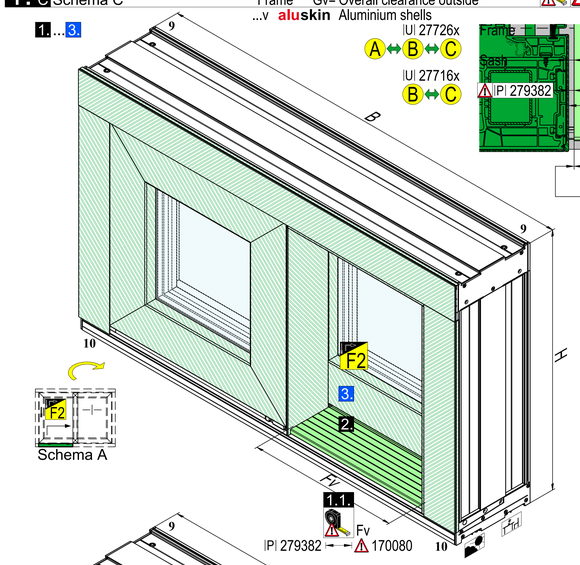
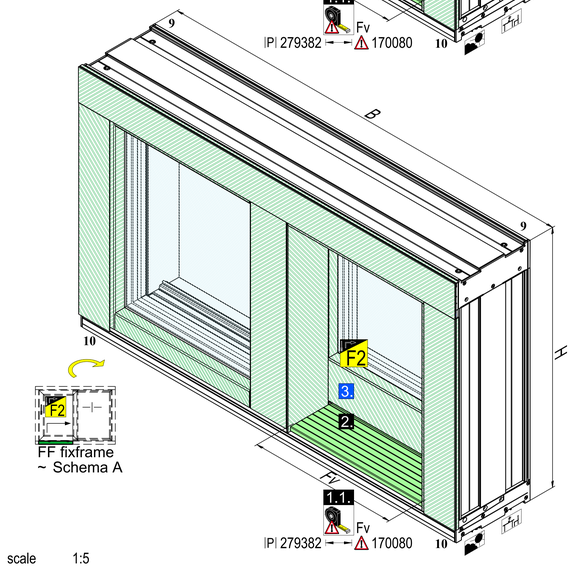
Attention: measure the dimensions — 1.1. - 1.2.

1. A Schema A — Frame Fv= Overall clearance
   C Schema C — Frame Gv= Overall clearance outside
...v **aluskin** Aluminium shells

1...3.



Schema A



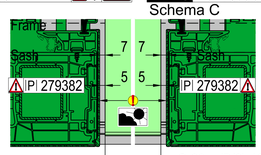
FF fixframe
~ Schema A

scale 1:5

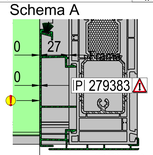
Cutting — 2.1. - 2.1.

2. A Circular saw blade
   C -> uPVC / aluminium

Schema C



Schema A

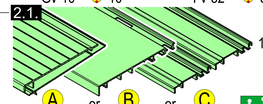


|U| 27726x
A ↔ B ↔ C
|U| 27716x
B ↔ C

= G-20 = (B/2)-188
= Gv-10 = -10

= F-37 = (B/2)-148.5
= Fv-32 = -5

2.1.



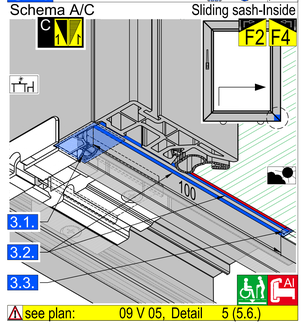
A or B or C
|S| 277202 ↔ |S| 277105 ↔ |S| 277106

see plan: 09 T 08, Detail 3-1, 3-2, 3-11

Sealing / Gluing — 3.1. - 3.3.

3. A Silicone rubber — -> aluminium
   C

Schema A/C — Sliding sash-Inside

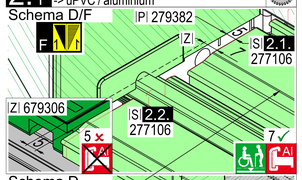


see plan: 09 V 05, Detail 5 (5.6.)

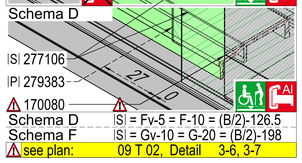
Cutting — 2.1. - 2.2.

2. D Circular saw blade
   F -> uPVC / aluminium

Schema D/F



Schema D



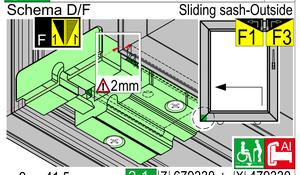
Schema D — |S| = Fv-5 = F-10 = (B/2)-126.5
Schema F — |S| = Gv-10 = G-20 = (B/2)-198

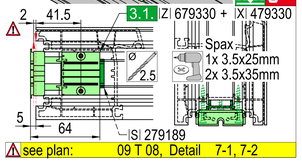
see plan: 09 T 02, Detail 3-6, 3-7

Assembly — 3.1. - 3.1.

3. D Drill / Screws
   F

Schema D/F — Sliding sash-Outside



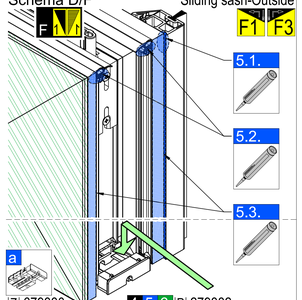


see plan: 09 T 08, Detail 7-1, 7-2

Sealing / Gluing — 5.1. - 5.4.

5. D Silicone rubber — -> aluminium
   F

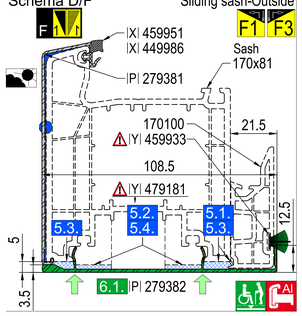
Schema D/F — Sliding sash-Outside



Assembly — 6.1. - 6.1.

6. D Clip or mount
   F

Schema D/F — Sliding sash-Outside



Important

Sliding sash-Inside
F2 = as represented
mirror-inverted = F4
Schema A/C/D/F — Schema C/F

Sliding sash-Outside
F1 = as represented
mirror-inverted = F3
Schema D/F — Schema F

Schema ... C F 1 1
1x as represented + 1x mirror-inverted

Horizontal deduction dimensions — Widths

	Schema A / Schema D	Schema C / Schema F	uPVC	
A=	B-156	(B/2)-85		2 sashes
B=	B	B		Element
C=	(B/2)-199.5	(B/4)-164		Glass
D=	(B/2)-29.5	(B/4)+6		Sash 1)
E=	(B/2)-229.5	(B/4)-194		Sash clearance
F=	(B/2)-111.5	(B/4)-76		Overall clearance
G=	-	(B/2)-168		Overall clearance outside
Bz=	B-8	B-8		Threshold, frame
Ca=	-	-		Glass, deviant
Da=	-	-		Sash, deviant
Ea=	-	-		Sash clearance, deviant

Horizontal sections

A, B, C, ...

▫ / ▪ Stopper left / right (where required)

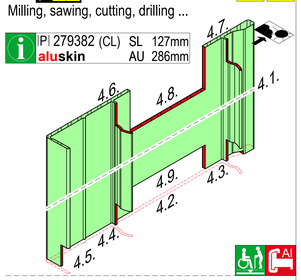
Cutting — 4.1. - 4.9.

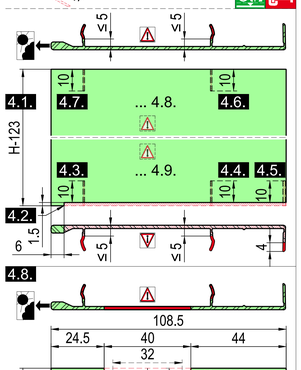
4. D Circular saw blade
   F -> uPVC / aluminium

Schema D/F — Sliding sash-Outside

Milling, sawing, cutting, drilling ...

|P| 279382 (CL) SL 127mm
aluskin AU 286mm

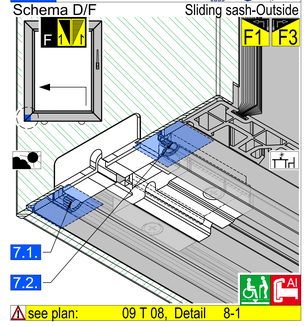




Sealing / Gluing — 7.1. - 7.2.

7. D Silicone rubber — -> aluminium
   F

Schema D/F — Sliding sash-Outside

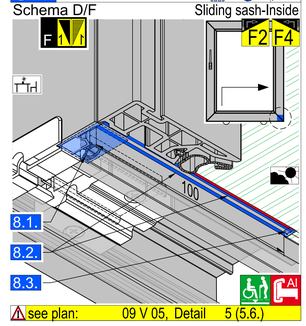


see plan: 09 T 08, Detail 8-1

Sealing / Gluing — 8.1. - 8.3.

8. D Silicone rubber — -> aluminium
   F

Schema D/F — Sliding sash-Inside



see plan: 09 V 05, Detail 5 (5.6.)

Symbols

FFL — Finished Floor Level
Weather side / Outside
Room side / Inside

Hardware — Documents

GU	Gu-933 (44054)
Hautau	Atrium HS 300 (243733)
Maco	HS 300 aluplast (756728+756736)
Siegenia	HS-Portal 250 KF A0022 (HSde4021)

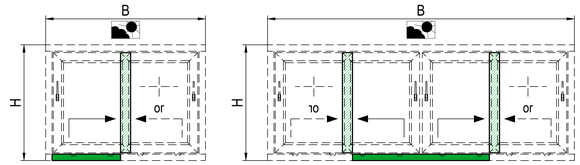
Vertical deduction dimensions — Heights

			uPVC	
h=	48mm	27mm		Threshold |U|
H=	H	H'+21		Element
I=	H-296	✓		Glass
J=	H-126	✓		Sash 1)
K=	H-326	✓		Sash clearance
L=	-	✓		Exterior frame
M=	-	✓		Interior frame
Hz=	H-111	✓ ...		Frame

...v **aluskin** Aluminium shells
1) Weld shrinkage allowance to be added!

Vertical sections

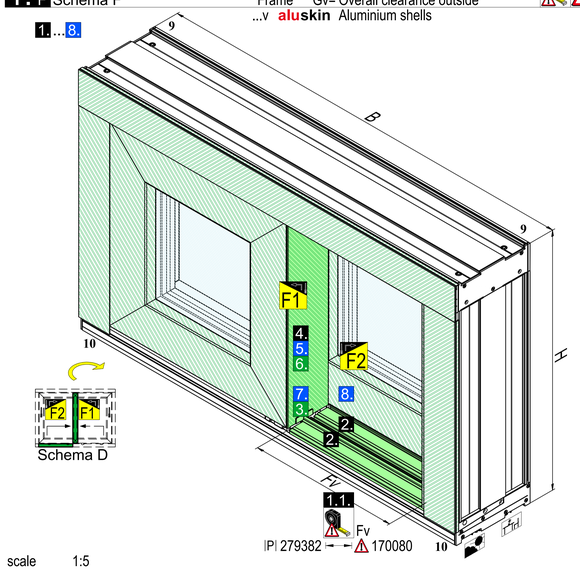
1, 2, 3, ...



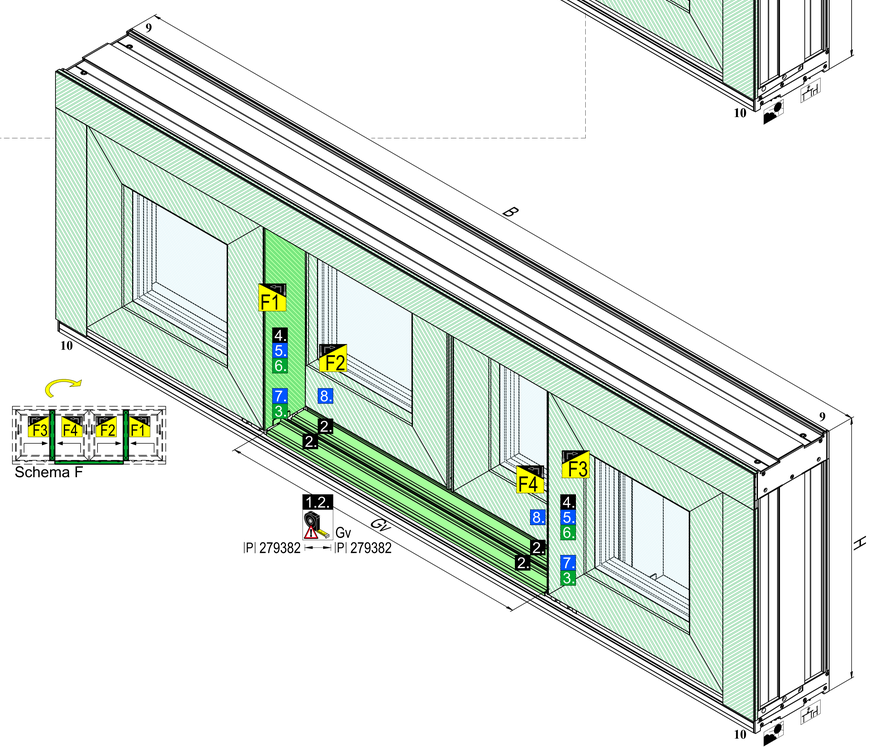
Attention: measure the dimensions — 1.1. - 1.2.

1. D Schema D — Frame Fv= Overall clearance
   F Schema F — Frame Gv= Overall clearance outside
...v **aluskin** Aluminium shells

1...8.



Schema D



Schema F

scale 1:5

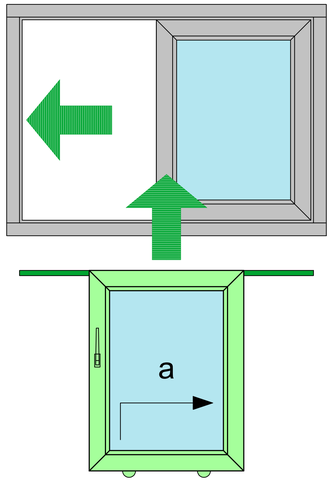
chapter 09 Individual Handling
09 V Assembly Plans "v"
see manual Handling chapter 08 L - General **aluskin** Aluminium shells
www.aluplast.net

page barrier-free
08 Schema A/C/D/F "v" BF
Frame-outside
Sliding sash — BF barrier-free
Aluminium shells **aluskin**
Lift-and-slide door 85mm

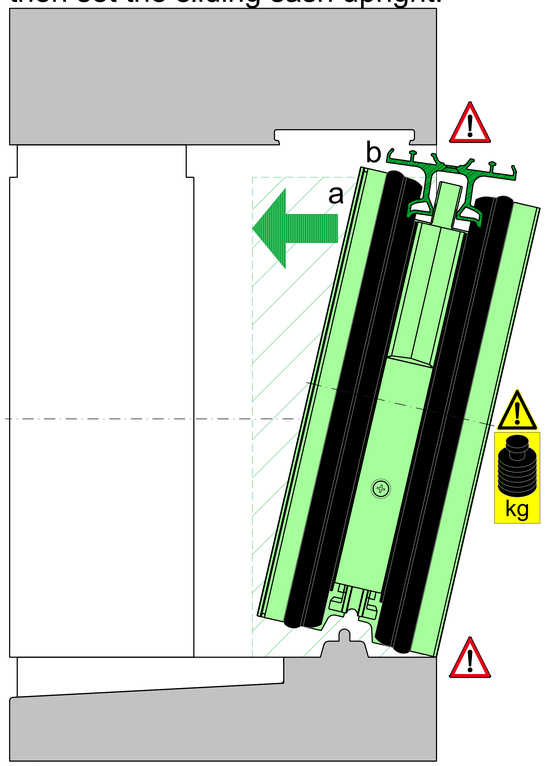
May be subject to change and errors excepted! Laminated profiles and profiles with gasket: see price list! Copyright © aluplast GmbH | All rights reserved | Alle Rechte vorbehalten

Mounting
of the Sliding Sash

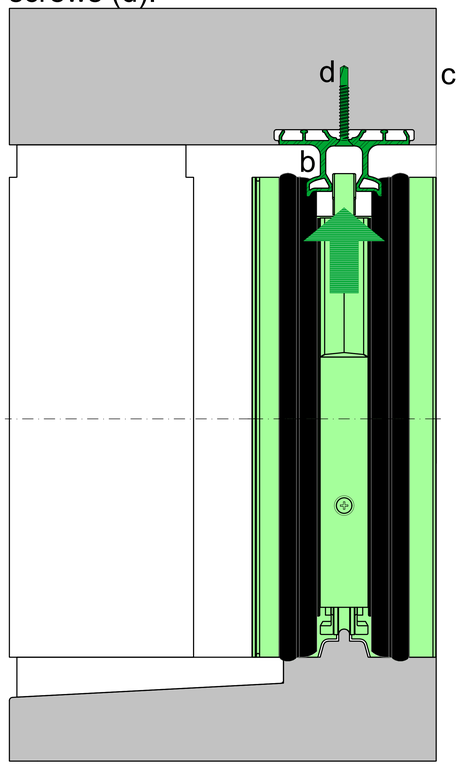
Mounting



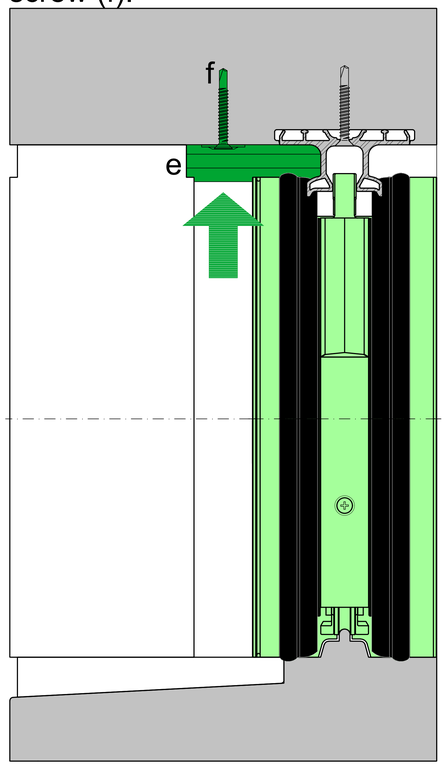
1. Position the tilted sliding sash (a) with the already inserted guide rail (b), then set the sliding sash upright.



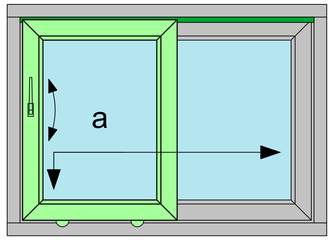
2. Place the guide rail (b) in the frame (c) and fix it with FD21 3.9x38mm screws (d).



3. Insert the gasket pad (e) laterally and fix it with a FD21 3.9x38mm screw (f).

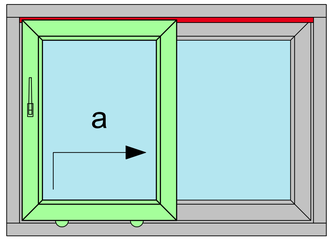


4. Check the sliding sash's (a) functionality.

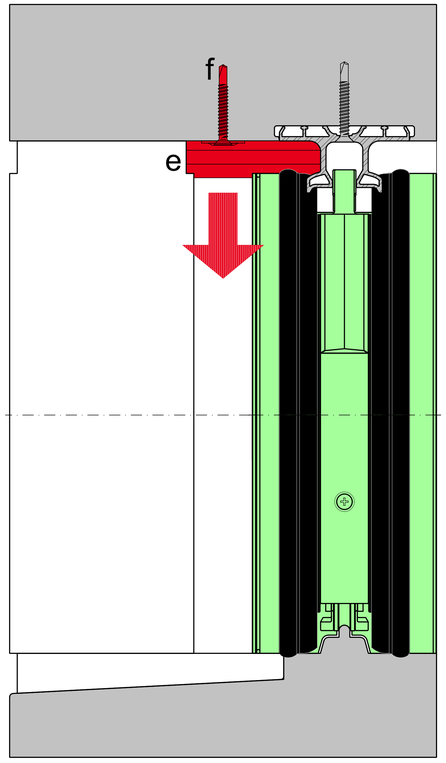


Dismounting
of the Sliding Sash

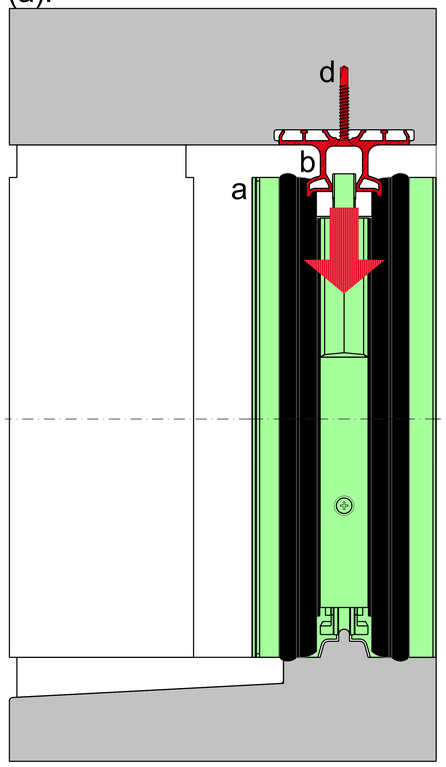
Dismounting



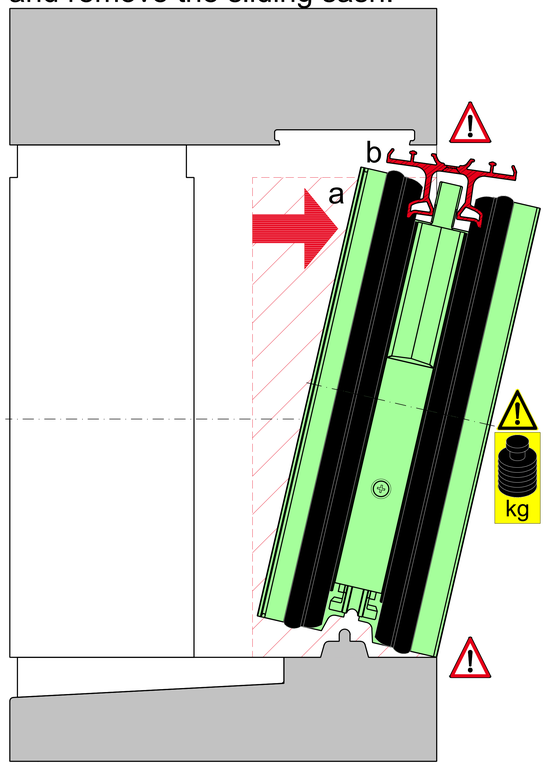
1. Remove the screw (f) and the gasket pad (e) laterally.

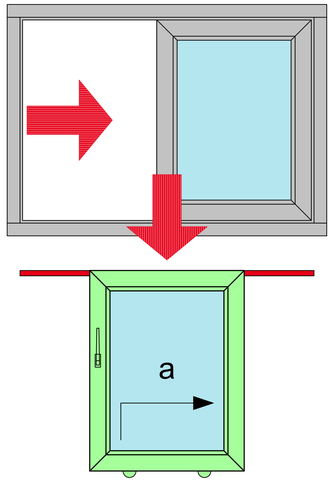


2. Remove the screws (d), the guide rail (b) remains in the sliding sash (a).



3. Tilt the sliding sash (a) with the guide rail (b) still being in place and remove the sliding sash.





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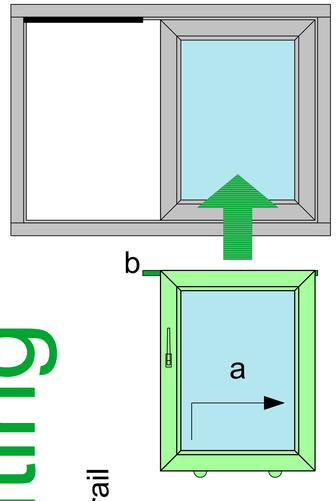
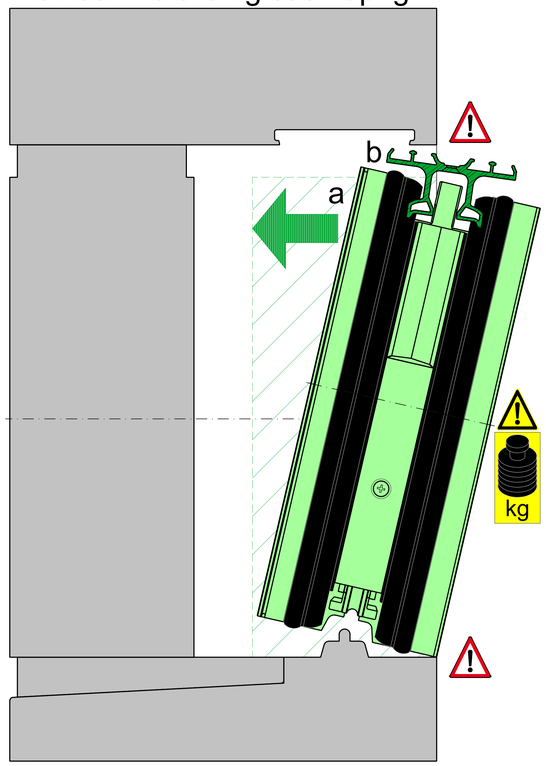
Mounting

of the Sliding Sash
with divided guide rail

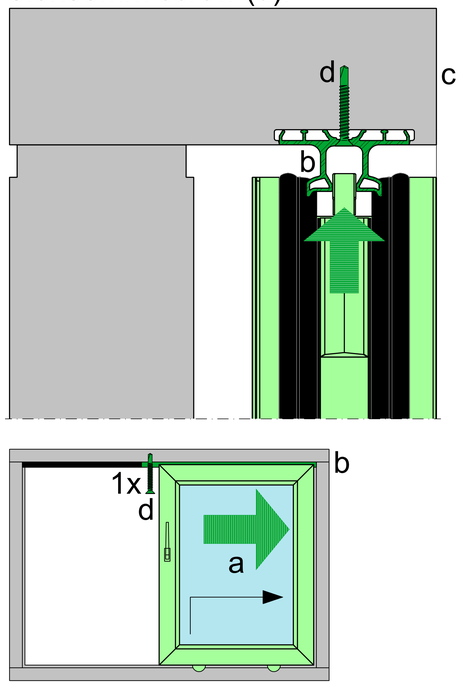
Mounting



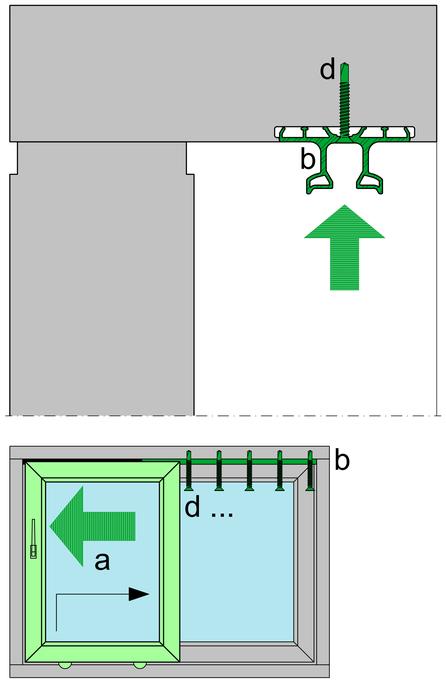
1. Position the tilted sliding sash (a) with the already inserted guide rail (b), then set the sliding sash upright.



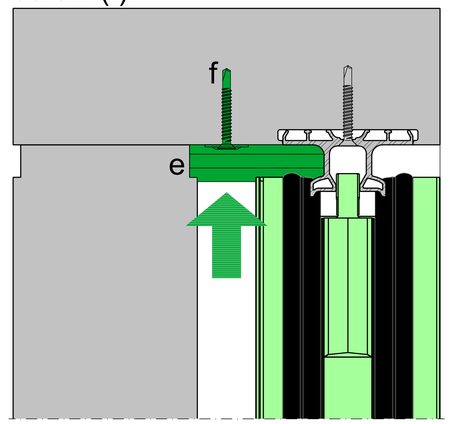
2. Place the guide rail (b) in the frame (c) and fix it with the first FD21 3.9x38mm screw (d).



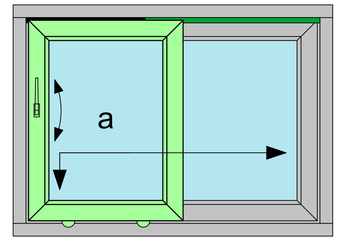
3. Fix the guide rail (b) with FD21 3.9x38mm screws (d).



4. Insert the gasket pad (e) laterally and fix it with a FD21 3.9x38mm screw (f).



5. Check the sliding sash's (a) functionality.

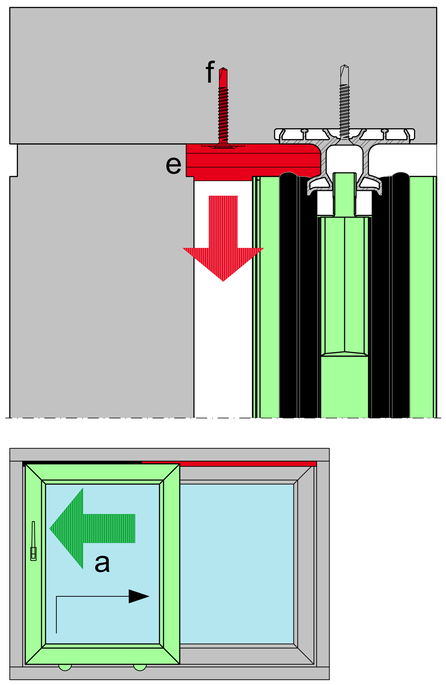


Dismounting

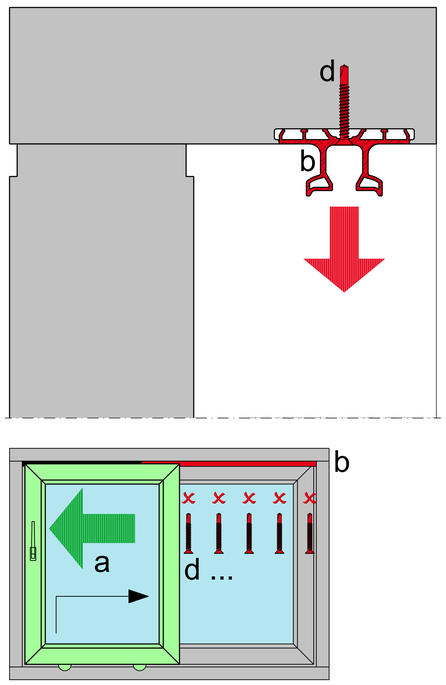
of the Sliding Sash
with divided guide rail

Dismounting

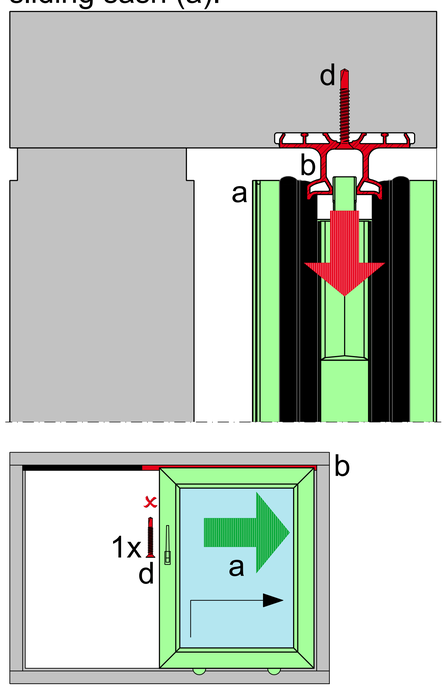
1. Remove the screw (f) and the gasket pad (e) laterally.



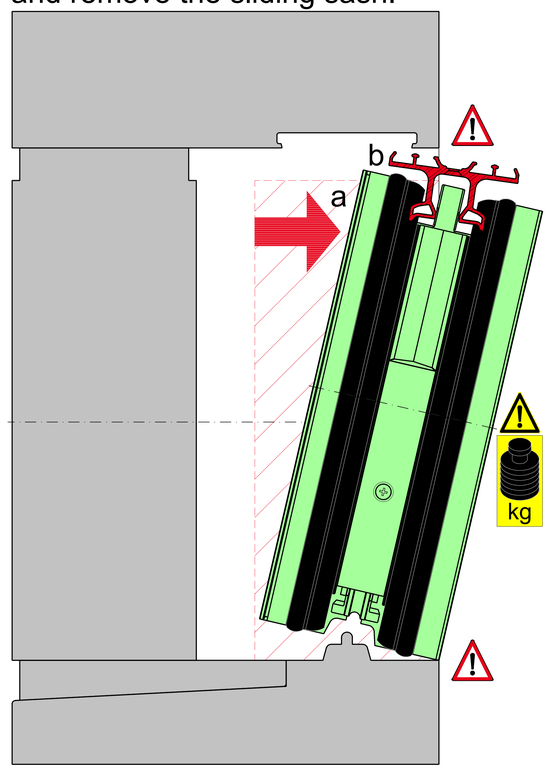
2. Remove the screws (d).



3. Remove the screw (d), the guide rail (b) remains in the sliding sash (a).



4. Tilt the sliding sash (a) with the guide rail (b) still being in place and remove the sliding sash.



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