

PRODUCT MANUAL

March 2019



CLIP 44™
OTHER INSERTS

General Documentation Disclaimer

This manual is intended as a manufacturing and installation advisory document. For correct specifications, sizing of profiles and structural information please consult the StarFront Application. If the information you require is not available through the StarFront Application, please contact your stockist before proceeding. It is advisable to have all sizing and performance criteria checked by a qualified structural engineer to ensure that the required criteria will be met.

All information, recommendations or advice contained in this documentation is given in good faith to the best of Wispeco's knowledge and is based on current procedures in effect.

Since the actual use of this documentation by the user is beyond the control of Wispeco, such use is within the exclusive responsibility of the user. Wispeco cannot be held responsible for any loss incurred through incorrect or faulty use of this documentation. Training of Wispeco systems is important for ensuring correct procedures in the manufacturing of products.

Great care has been taken to ensure that the information provided is correct.

Ensure that you have the latest available manual. The revision number and date can be checked on the latest StarFront version.

Wispeco will accept no responsibility for any errors and/or omissions, which may have inadvertently occurred.

Specifications concerning products and applications

This manual is based on standard configurations only. As there are many configurations not covered in this manual, contact your stockist with regards to a configuration not represented herein if required.

AutoDesk drawings (CAD Symbol Library) are available on request and can be issued with the consent of the Wispeco Technical Department.

All mechanical joints must be sealed with a **Crealco approved joint sealer**. Failure to correctly seal the joints can affect the performance of the system. Information on joint sealing can be found in the Cleaning & Maintenance Manual** available for download from www.crealco.co.za or from StarFront.

All drawings in the Wispeco Documentation are NOT to scale and are used for illustrative purposes only.

Wispeco will not accept responsibility for the use of standard products since Wispeco does not know where these products are being installed.

The hardware recommended in this documentation is suitable for use in most atmospheric environments. When hardware is used in severe coastal environments the manufacturer of the hardware must be consulted.

For the coastal regions and any other high corrosion areas, the following is advised: to minimize phylliform corrosion use SurTec650 RTU spray during the manufacturing of aluminium profile systems. This should be applied, before assembly, on all pre-work aluminium where the powder coating covering has been removed thereby exposing the raw aluminium base.

The use of non-specified hardware or incorrect mechanical fasteners can adversely affect the mechanical and weathering performance of the system and we strongly advise against deviations. A Wispeco Consultant can advise you of any hardware issues and limitations with regard to this system.

The use of anti-magnetic stainless steel screws and aluminium pop rivets is recommended to reduce galvanic corrosion in harsh environments.

Fixing lugs on frames must be positioned as per the user manual and used in accordance to the AAMSA specifications. When profiles are screwed together the screw centres must also be according to the user manual or as specified by an engineer.

All glass used within Wispeco products must comply with SAGGA regulations. Laminated glass must not stand in water.

***For Cleaning and Maintenance of this system please download the Wispeco Installation, Cleaning and Maintenance Procedures from the Crealco website (www.crealco.co.za).*

By continuing to use this documentation you acknowledge that you understand and accept the legal disclaimer.

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Index	ii
Legal Disclaimer.....	1

General System

Profile Identification.....	2-10
Hardware Components	11-13
Butterfly Gasket & Wedge Codes	14-15
Size Limitation Guide	16-17
Cross-Sectional Detail.....	
Cottage Pane 3x3 Pane.....	18
Y-Louvre Configuration.....	19
Vertical Louvre Configuration.....	20
Horizontal Louvre Configuration.....	21
Assembly Detail.....	22
Cross-Sectional Detail.....	
30mm Configuration with Midrail	23
Sill Configuration with 2 Mullions.....	24
Transom Configuration.....	25
Swift 28 Short Leg Outer Frame in Clip 44	26
Swift 30.5 Short Leg Outer Frame in Clip 44	27
Swift 34 Outer Frame in Clip 44	28
Swift 34 Short Leg Outer Frame in Clip 44	29
Swift 38 Insert - Two Top Hung over Fixed	30

Euro Sash

Cross-Sectional Details.....	31
Corner Joint Detail.....	
Option A - Using the Joining Corner.....	32
Option B - Using the Corner Connector.....	33
Machining Detail.....	
Sash & Locking Bar.....	34
Handle.....	35
Assembly Detail.....	
Corner Joint.....	36
Corner Connector.....	37
Locking Angle Detail.....	38
Fitting of Sash Spacer.....	39
Glazing Procedure.....	40

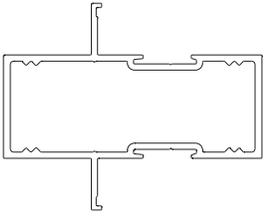
CLIP 44™
OTHER INSERTS



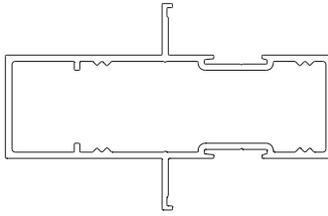
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Profile Identification

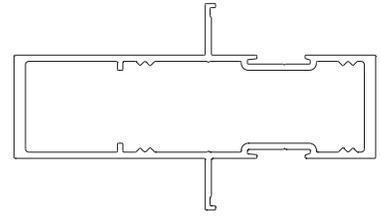
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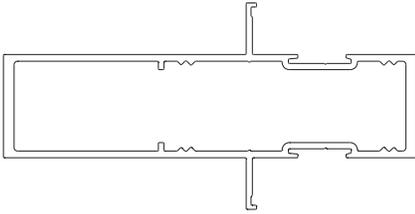
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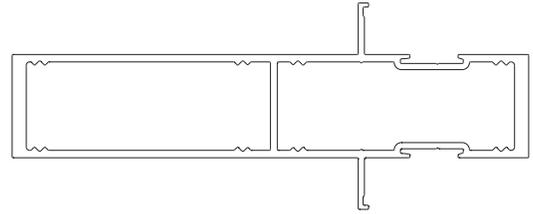
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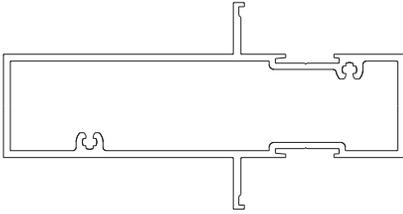
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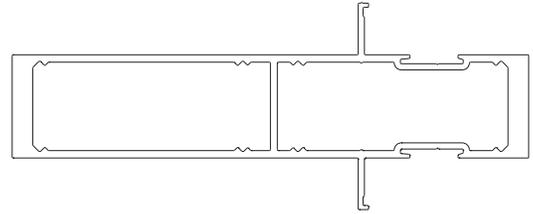
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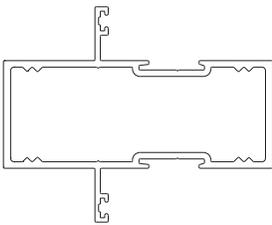
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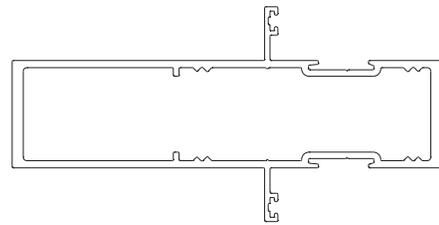
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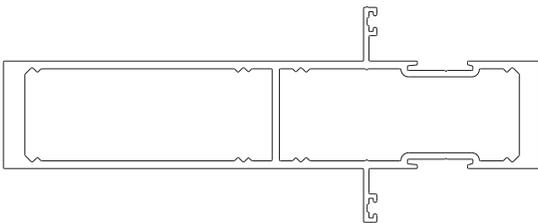
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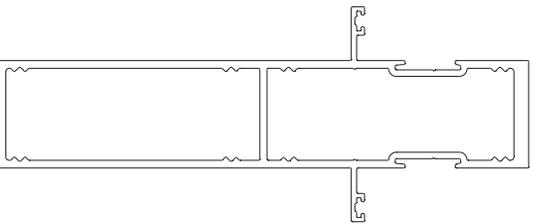
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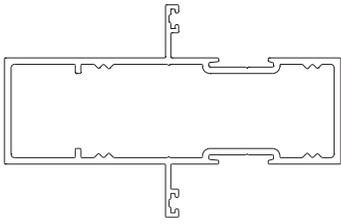
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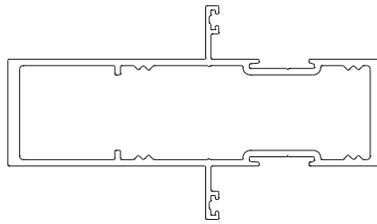
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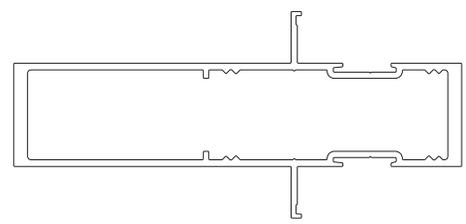
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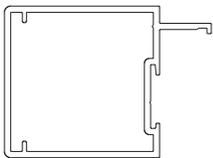
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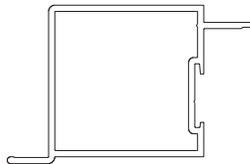
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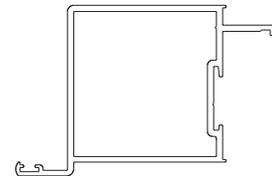
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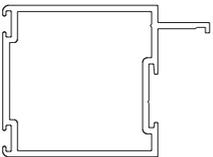
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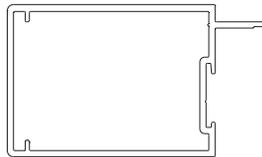
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DIE No. W44099 Clip44 R12 Special



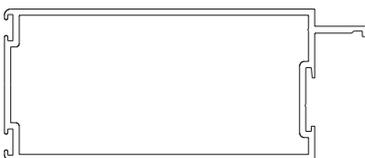
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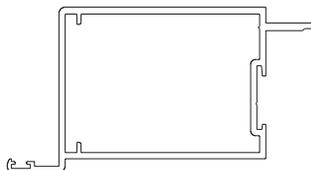
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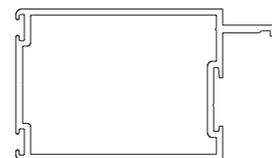
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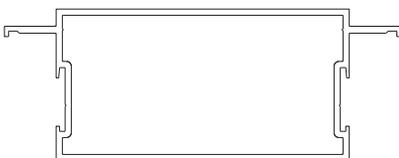
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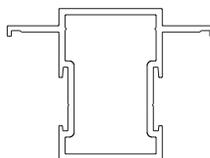
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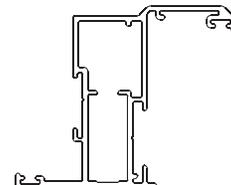
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DIE No. W44089 Clip44 R4 Special 85mm Mid-Rail



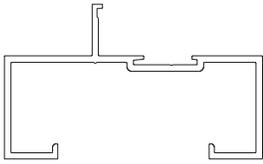
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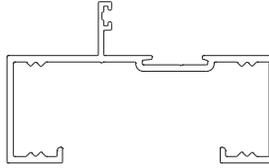
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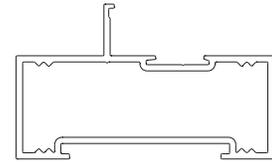
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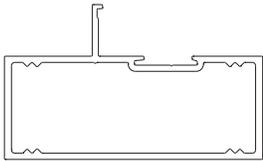
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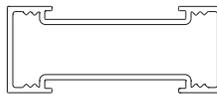
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Woolpile



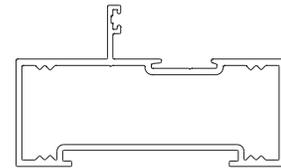
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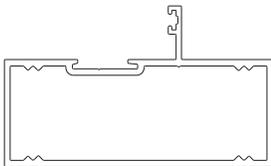
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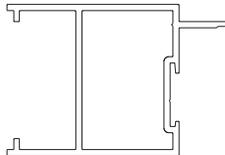
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Dbl Rec 26D



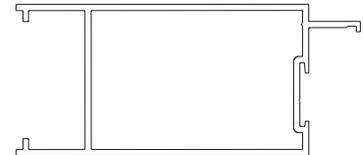
DIE No. W55824 | Clip44 Recessed Back
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DIE No. W55875 | Clip44 Flat Back
Woolpile



DIE No. W44087 | Clip44 R7 Head/
Sill Rail 50mm



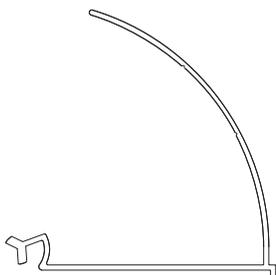
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Sill Rail 85mm



DIE No. W44094 | Clip44 R6 Sill
Rail 150mm



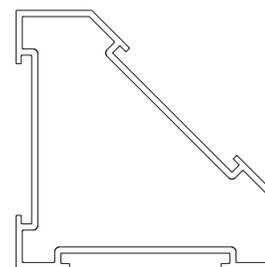
DIE No. W27038 | Clip44 Curved Clip
Hand Rail



DIE No. W28523 | Clip44 Corner
Mullion 1



DIE No. W28524 | Clip44 Corner
Mullion 2



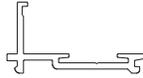
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Corner

Profile Identification

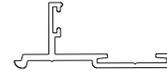
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DIE No. W25028 | Clip44 Transom



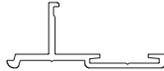
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DIE No. W26150 | Clip44 Door Adaptor



DIE No. W25029 | Clip44 Transom Cover



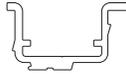
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DIE No. W26093 | Clip44 R4 End Filler



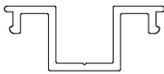
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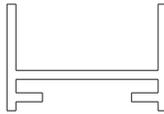
DIE No. W33921 | Clip44 Spigot



DIE No. W25025 | Clip44 40mm Cover Plate



DIE No. W30297 | Louvre Filler for Oval Louvre



DIE No. W01101 | Louvre Outer Frame Y-Louvre



DIE No. W23224 | Compensating Channel



DIE No. W31142 | New Clip44 Angled Glazing Bead



DIE No. W30468 | Clip44 Angled Glazing Bead



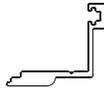
DIE No. W14108 | Clip44 Angled Glazing Bead



DIE No. W14109 | Clip44 Square Glazing Bead



DIE No. W32347 | Clip 44 Bead Double Glazing 33mm



DIE No. W35688 | Clip44 Euro Sash Adaptor



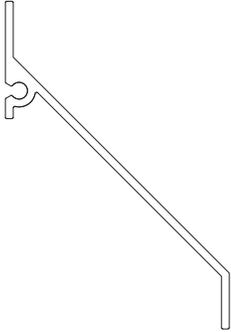
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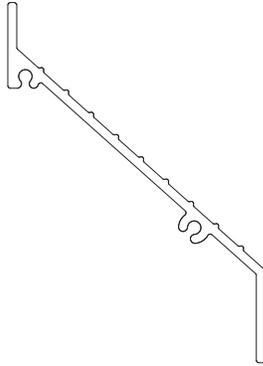
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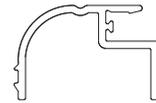
Clip44 Other Inserts Profiles



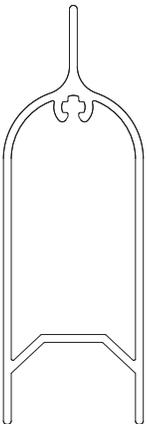
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One Screw Port



DIE No. W18679 Louvre Lazy Z
Ribbed 2 S/Port



DIE No. W29904 Sundry Insect
Screen



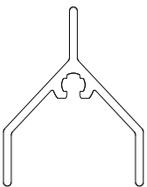
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Y-Louvre 75mm



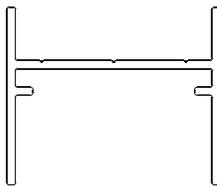
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50.1 x 10.6



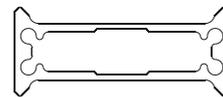
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Louvre



DIE No. W18079 Louvre
Y-Louvre



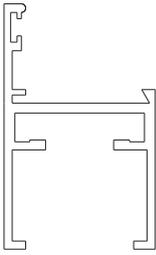
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Frame



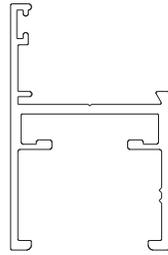
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Profile Identification

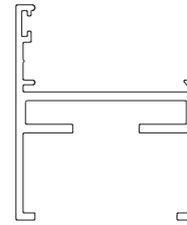
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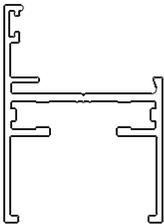
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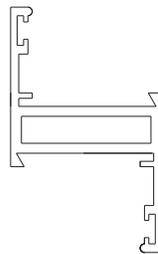
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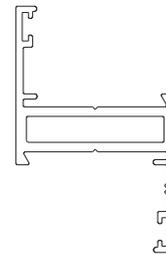
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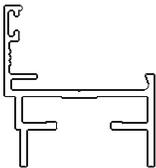
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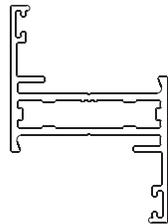
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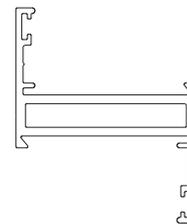
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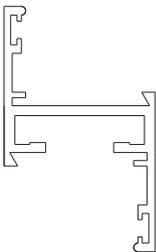
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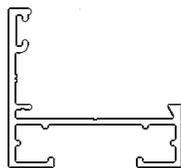
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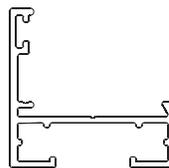
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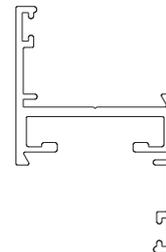
DIE No. W32025 Swift 28 Frame 28mm Unequal Leg



DIE No. W36831 Swift 30.5 Short Leg Outer Frame



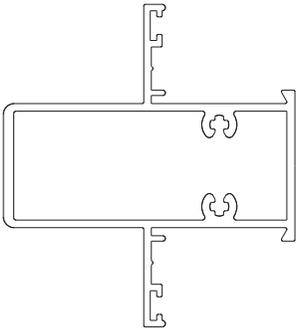
DIE No. W36832 Swift 28 Short Leg Outer Frame



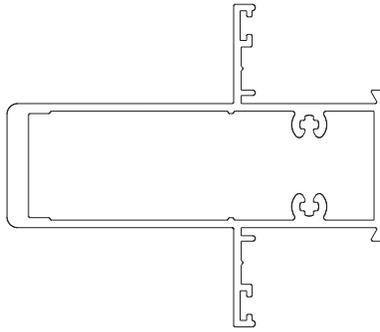
DIE No. W32027 Swift 30.5 Frame 30mm Unequal Leg

Profile Identification

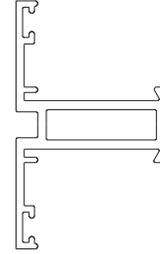
Clip44 Other Inserts Profiles



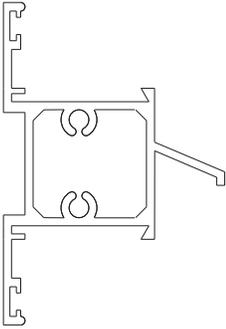
DIE No. W54348 | Swift 28
Mullion 54mm



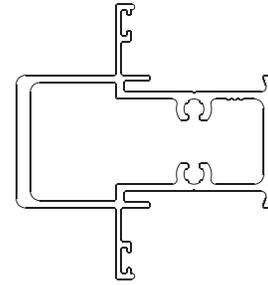
DIE No. W54329 | Swift 28
Mullion 70mm



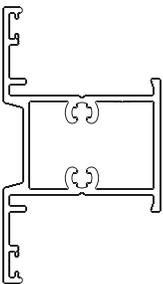
DIE No. W53283 | Swift 28 Mullion
28mm Cottage Pane



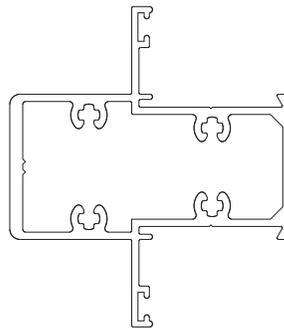
DIE No. W13142 | Swift 28 Mullion
28mm W/Bar



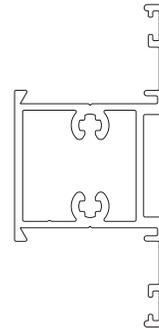
DIE No. W56269 | Swift 34
Mullion 54mm



DIE No. W55692 | Swift 34
Mullion 34mm



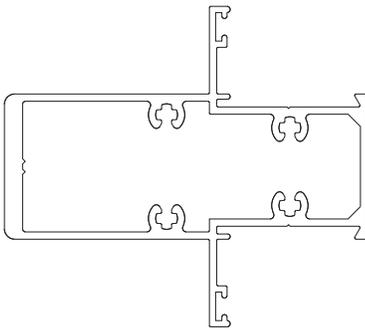
DIE No. W54651A | Swift 30.5
Mullion 54mm



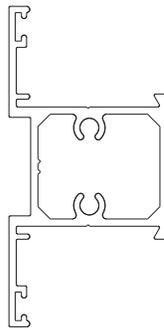
DIE No. <W55683> | Swift 28 Mullion
28mm

Profile Identification

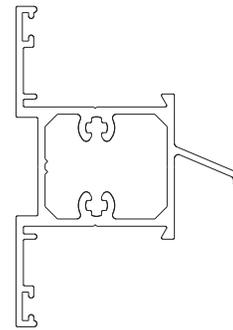
Clip44 Other Inserts Profiles



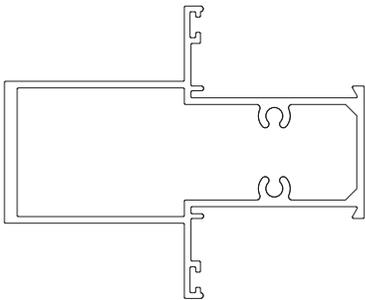
DIE No. W54652A Swift 30.5
Mullion 70mm



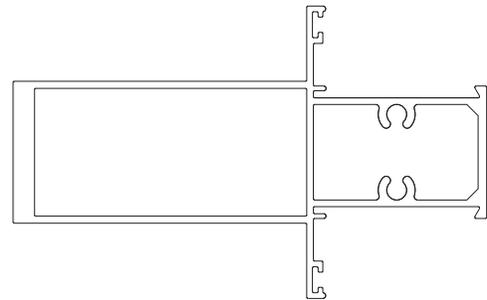
DIE No. W55685A Swift 30.5 Mullion
30mm Standard



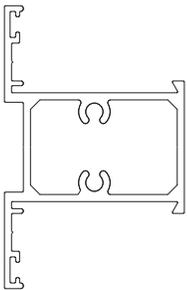
DIE No. W53630 Swift 30.5 Mullion
30mm W/Bar



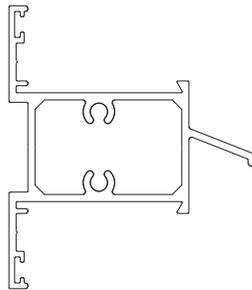
DIE No. W54455 Swift 38
Mullion 76mm



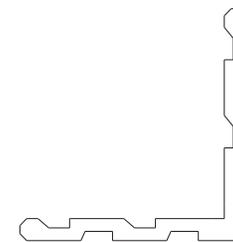
DIE No. W54454 Swift 38
Mullion 100mm



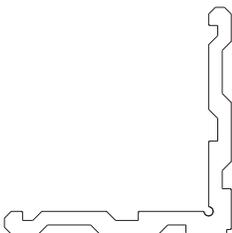
DIE No. W55718 Swift 38
Mullion/Transom



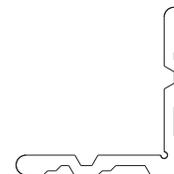
DIE No. W13408 Swift 38 Mullion
with W/Bar



DIE No. W52695 Swift 28 Corner
Cleat 50mm



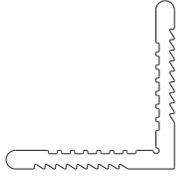
CLIQ241P Swift 34
Corner Cleat



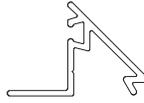
DIE No. W27989 Swift 30.5 Corner
Cleat 40mm

Profile Identification

Clip44 Other Inserts Profiles



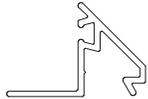
DIE No. W52538 | Osborne Multi
Corner Cleat



DIE No. W52693 | Swift 28 Bead
4mm



DIE No. W31140 | Swift 38 Angle
Bead 13mm Gap



DIE No. W31137 | Swift 28 Bead
Multi 13mm Gap



DIE No. W31139A | Swift 30.5 Bead
Multi 13mm Gap



DIE No. W33137 | Swift 34 Bead
Multi 13mm



DIE No. W27991 | Swift 30.5 Bead
4 & 5mm



DIE No. W25200 | Swift 38 Glazing
Bead 7mm-8mm



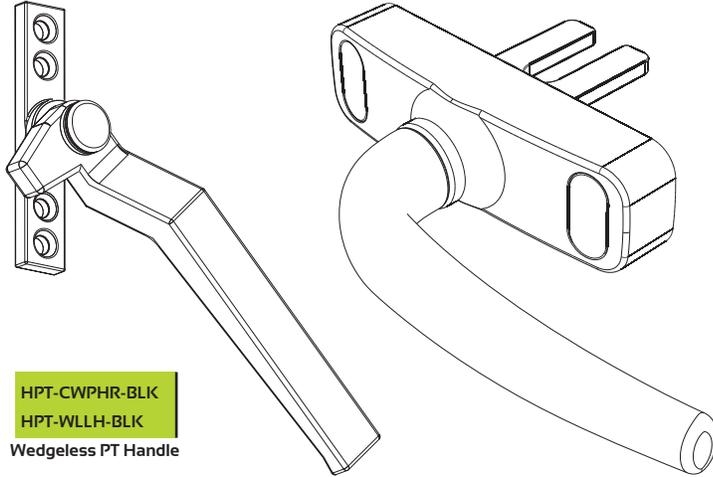
DIE No. W10083 | Swift 34 Add-On
W/Bar

Hardware Components

RECOMMENDED CLIP44 OTHER INSERTS HARDWARE COMPONENTS

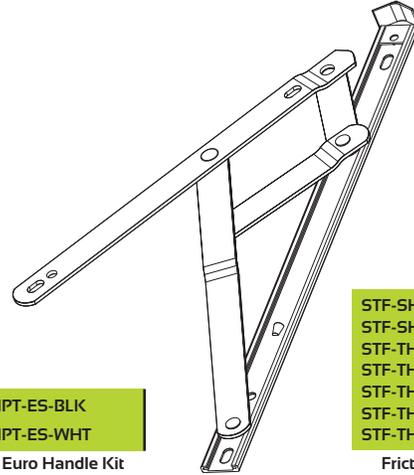
All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com

HANDLE & FRICTION STAY

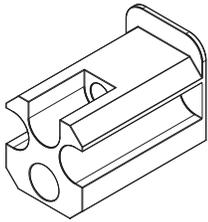


HPT-CWPHR-BLK
HPT-WLLH-BLK
Wedgeless PT Handle

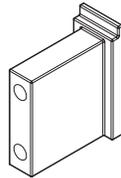
HPT-ES-BLK
HPT-ES-WHT
Euro Handle Kit



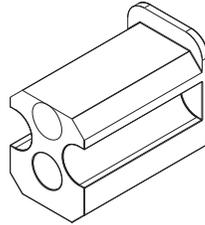
STF-SH300S-304
STF-SH400S-304
STF-TH200S-304
STF-TH300R-304
STF-TH400S-304
STF-TH500S-304
STF-TH600S-304
Friction Stay



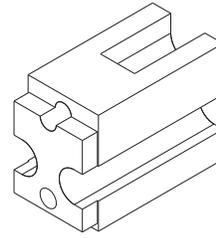
LGR-CC28R
28 Cross Connector
PVC



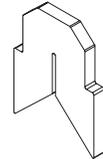
LGR-28CP
28 Cottage Pane
Cross Connector



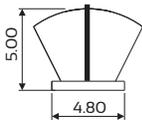
LGR-CC305B
30.5 Cross Connector
PVC



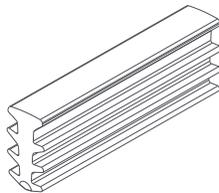
LGR-CC340N
340 Cross Connector



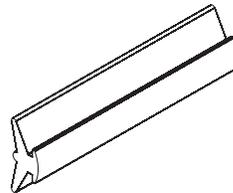
PPS-LPY
Louvre Spacer



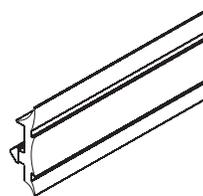
GFP-4850
Finpile



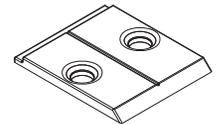
GWG-O1G
GWG-O2B
GWG-O3R
GWG-O4Y
GWG-O5P
Wedge Gasket



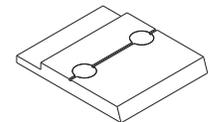
GSL-AL-H602
Y Seal Gasket



GBF-ORG
Butterfly Gasket



LGR-MP305B
30.5 Glazing Bar Packer
PVC

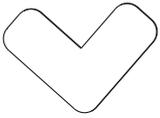


LGR-MP340T
Glazing Bar Packer Alum for 340

Hardware Components

RECOMMENDED CLIP44 OTHER INSERTS HARDWARE COMPONENTS

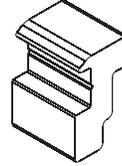
All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com



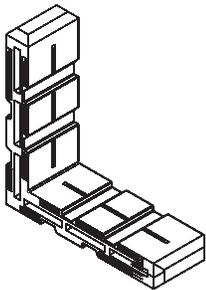
SGD-FMG520
Alignment Mitre Corner



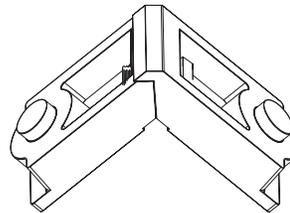
SGD-FM48
Frame Mitre Guide



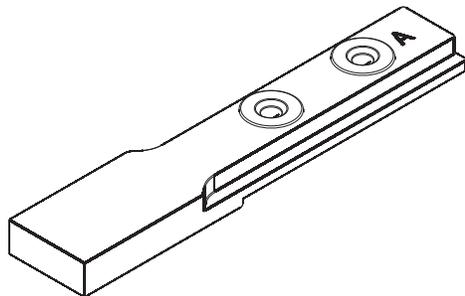
HPT-ESS
Euro Sash Spacer



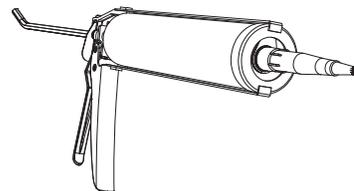
LGR-CCES
Euro Sash
Corner Connector



LGC-J2410N
Joining Corner



TLP-CJ
Euro Sash Jig



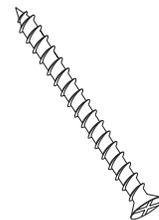
Crealco Silicone Tube



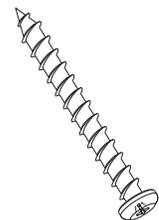
FSP-0830P-SS
8x30 P/Head POSI
S/S Screw



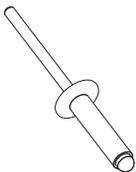
FSP-0630P-SS
6x30 P/Head POSI
S/S Screw



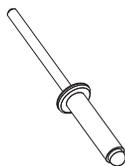
FSP-0840P-SS
8x40 Countersunk
POSI S/S Screws



FSP-1032P-SS
Self Tapping Screw
No. 10x32mm



FRC-410
4x10 C/Sunk Rivet



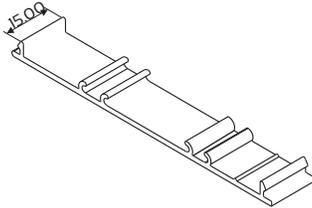
FRC-4810
4.8x10 Dome Head Rivet



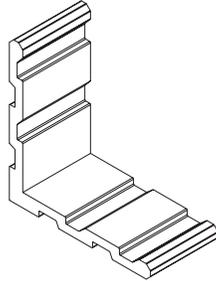
FSC-0809MBP
8x9 C/S Handle Screw
Blunt Point

RECOMMENDED CLIP44 OTHER INSERTS HARDWARE COMPONENTS

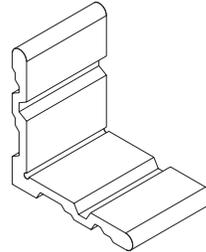
All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com



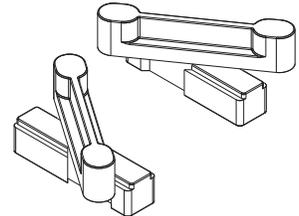
LGF-MULTI
Multi Fixing Lug
Alum 15mm



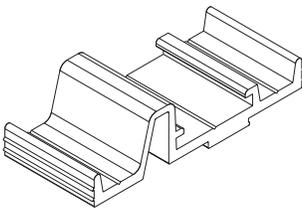
W52695
Corner Cleat



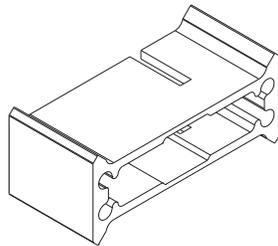
W27989
Corner Cleat



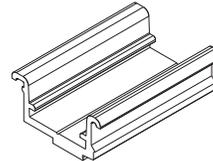
PPS-LPY
Oval Louvre Shutters



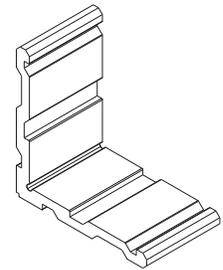
W26228
Frame Spigot



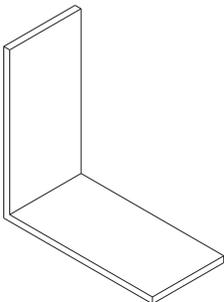
LGS-BS
Box Spigot 4x 5/Port



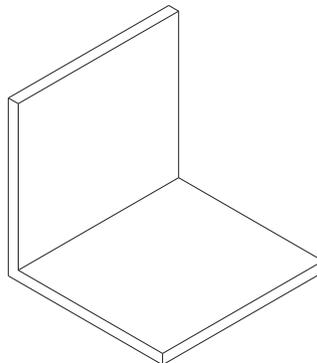
LGS-FS-119.9
LGS-FS-72.7
LGS-FS-55.3
LGS-FS-20.5
LGS-FS-17.7
Clip44 Frame Spigot



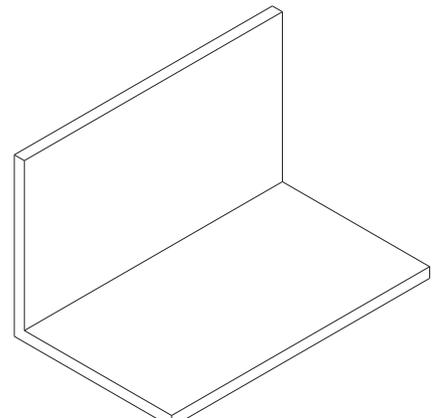
W10241
Swift 34
Corner Cleat



LGS-AFS-25
44,45X22,22X2,03



W10968
Equal Angle



W10968
Equal Angle



Butterfly Gasket



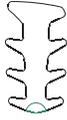
GBF-ORG



W31142 BEAD



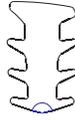
W30468 BEAD



Wedge Gasket



GWG-01G



Wedge Gasket



GWG-02B



Wedge Gasket



GWG-03R

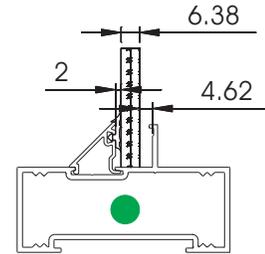
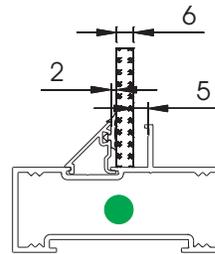
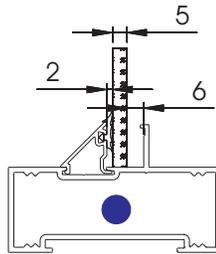
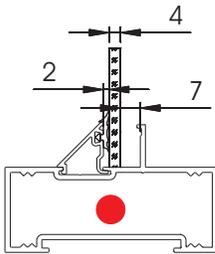


Wedge Gasket

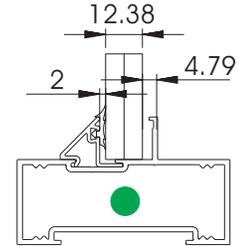
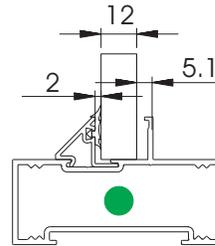
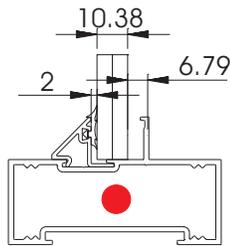
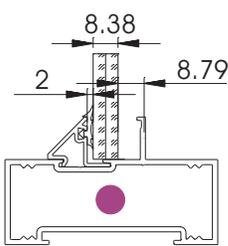


GWG-05P

WEDGES



CLIP 44 WITH W31142 BEAD



CLIP 44 WITH W30468 BEAD



● — GBF-ORG



W31142



Wedge Gasket

● GWG-03R



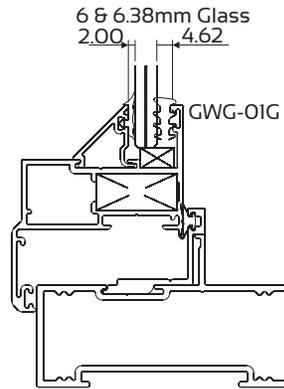
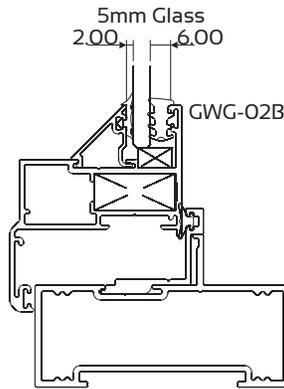
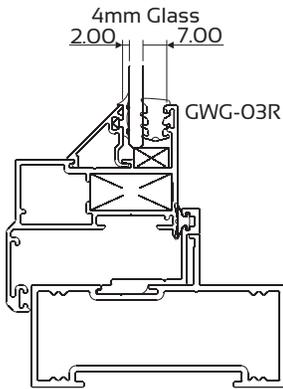
Wedge Gasket

● GWG-02B

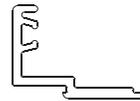


Wedge Gasket

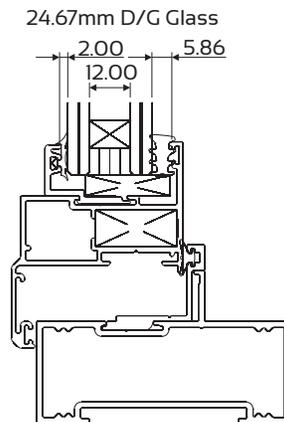
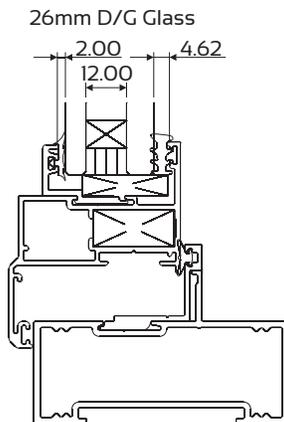
● GWG-01G



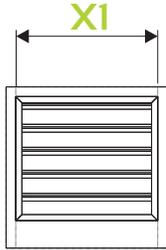
● — GBF-ORG



W32347

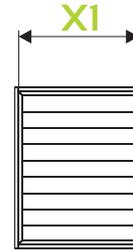


Y-LOUVRE, ROUNDED
Y-LOUVRE & LAZY Z-LOUVRE



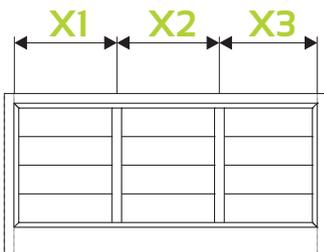
MAXIMUM LOUVRE BLADE LENGTH:
X1 = 900mm

ELLIPSOID LOUVRE



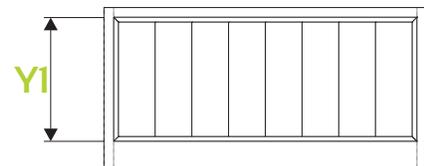
MAXIMUM LOUVRE BLADE LENGTH:
X1 = 1800mm

HORIZONTAL GLASS LOUVRE



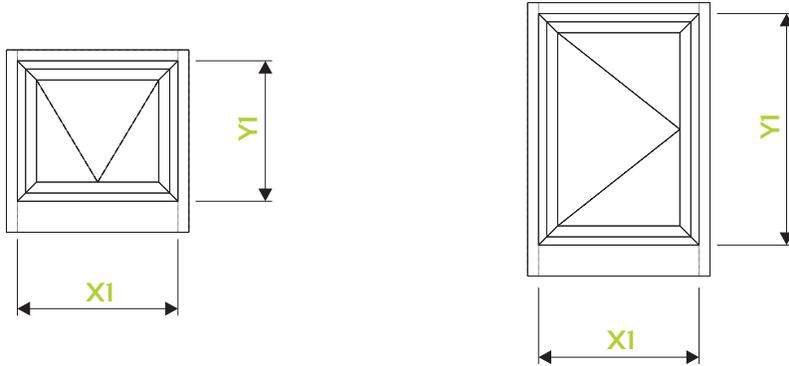
MAXIMUM LOUVRE BLADE LENGTH:
X1 = 900mm
X2 = 900mm
X3 = 900mm

VERTICAL GLASS LOUVRE

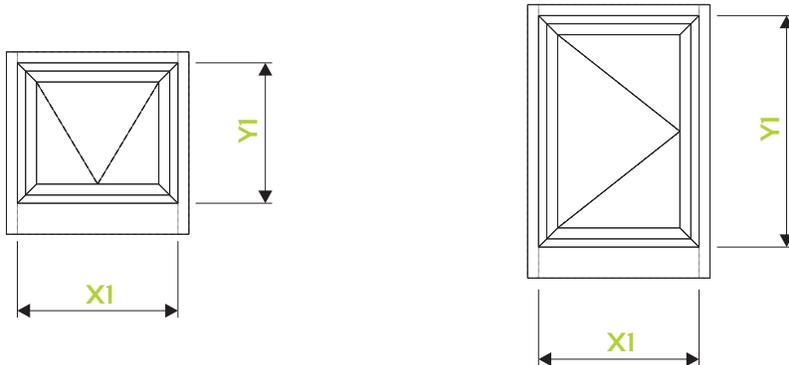


MAXIMUM LOUVRE BLADE LENGTH:
Y1 = 900mm

The sash limitations of the system are strictly calculated in accordance to AAMSA guidelines and take into account the aluminium specifications as well as the glass used. Please ensure that these are adhered to as any product produced outside of these limitations will not adhere to AAMSA regulations.



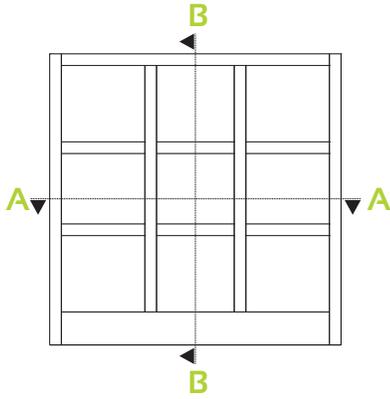
	Top Hung		Side Hung	
	Maximum Vent Width in mm	Maximum Vent Height in mm	Maximum Vent Width in mm	Maximum Vent Height in mm
Casement 28	900	600	600	1200
Casement 30.5	1000	750	600	1200
Casement 38	1500	1200	700	1500
Casement 34	1200	900	700	1500



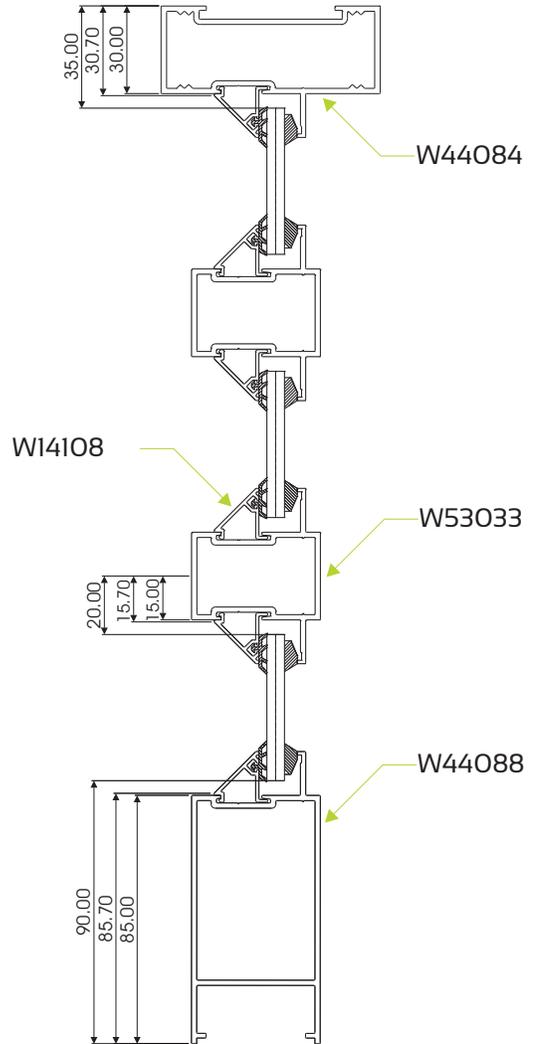
EURO SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W57630	1500	1200
Side Hung		700	1500

Cross-Sectional Detail

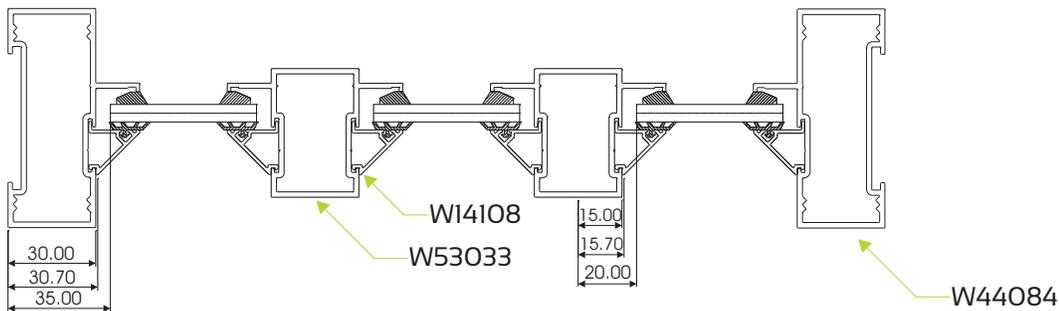
Cottage Pane 3x3 Pane



SECTION B-B
Section not to scale



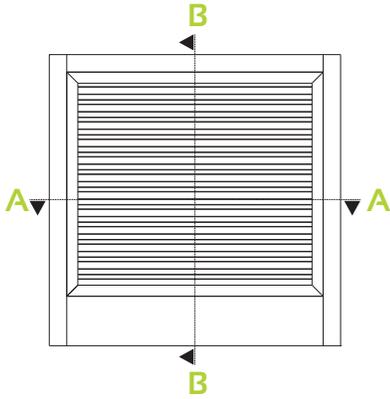
SECTION A - A
Section not to scale



This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

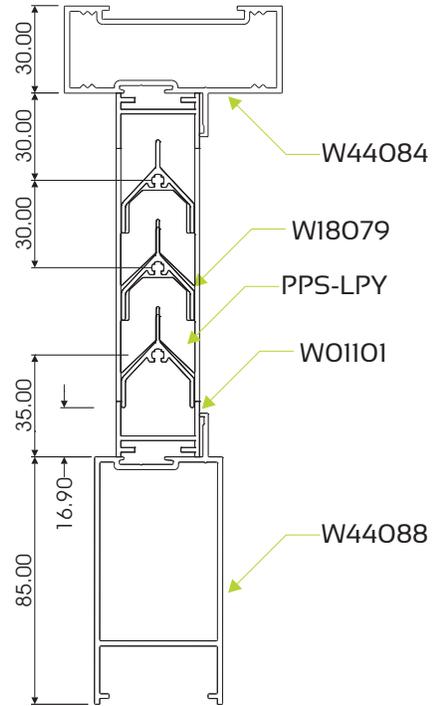
Cross-Sectional Detail

Y-Louvre Configuration



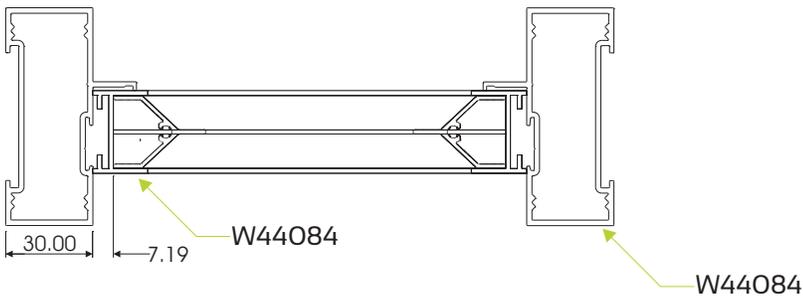
SECTION B-B

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SECTION A - A

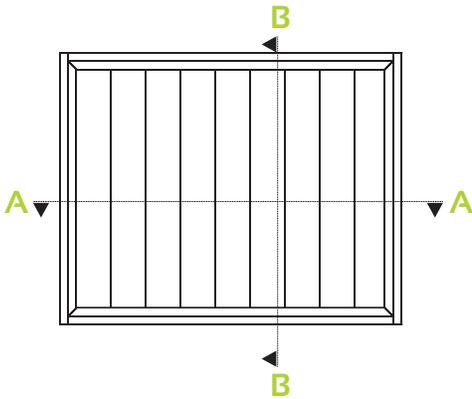
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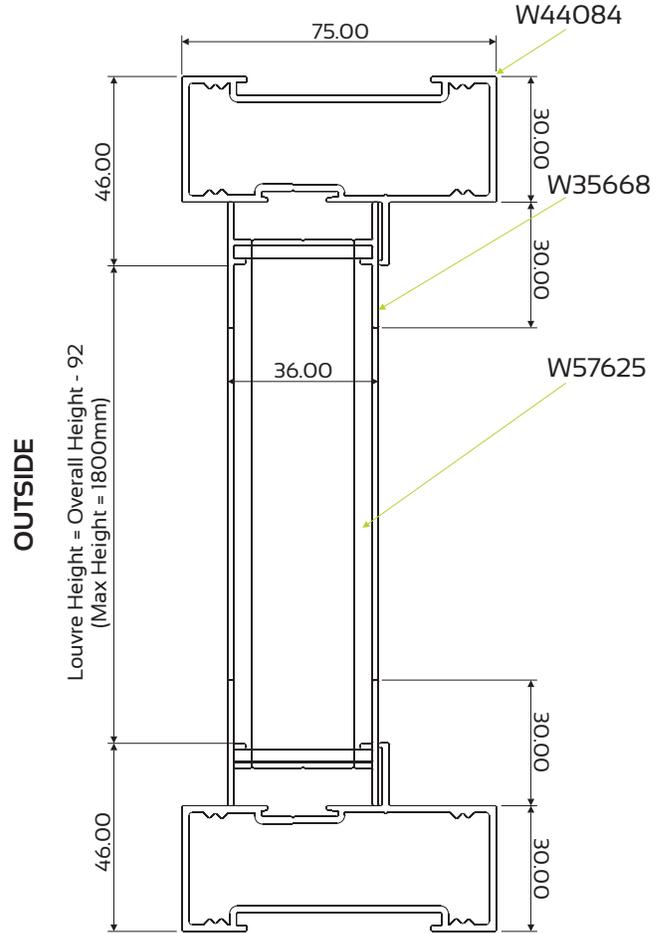
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Cross-Sectional Detail

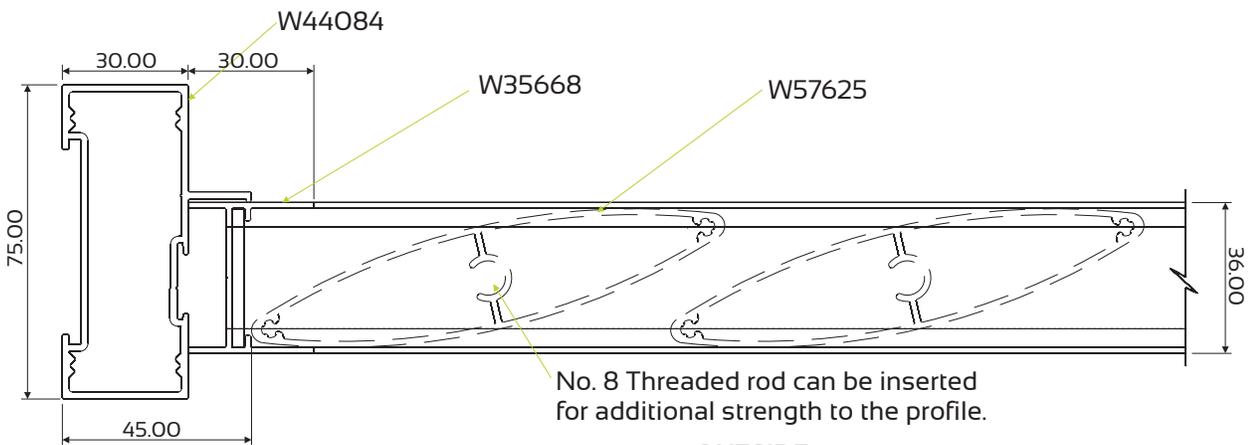
Vertical Louvre Configuration



SECTION B-B
Section not to scale



SECTION A - A
Section not to scale



No. 8 Threaded rod can be inserted for additional strength to the profile.

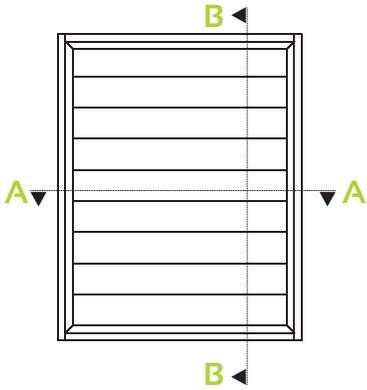
OUTSIDE



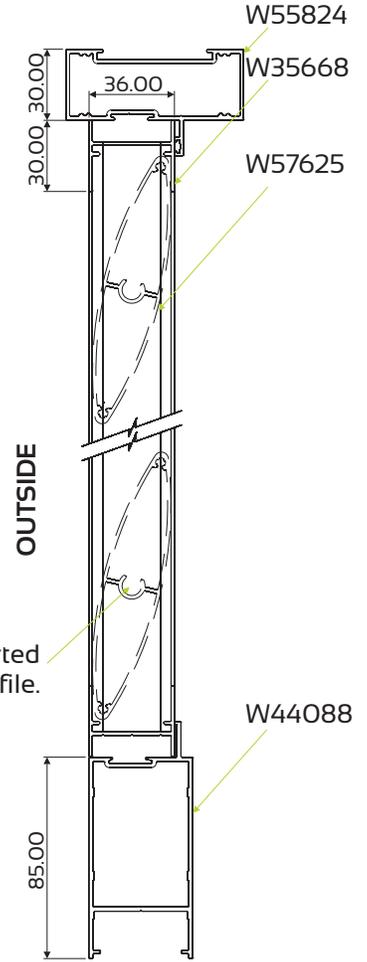
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Cross-Sectional Detail

Horizontal Louvre Configuration

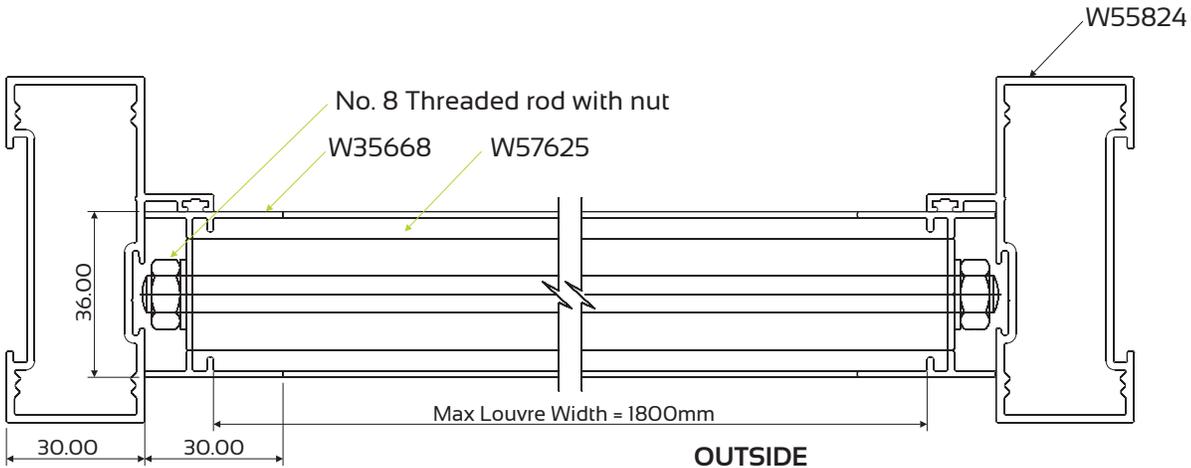


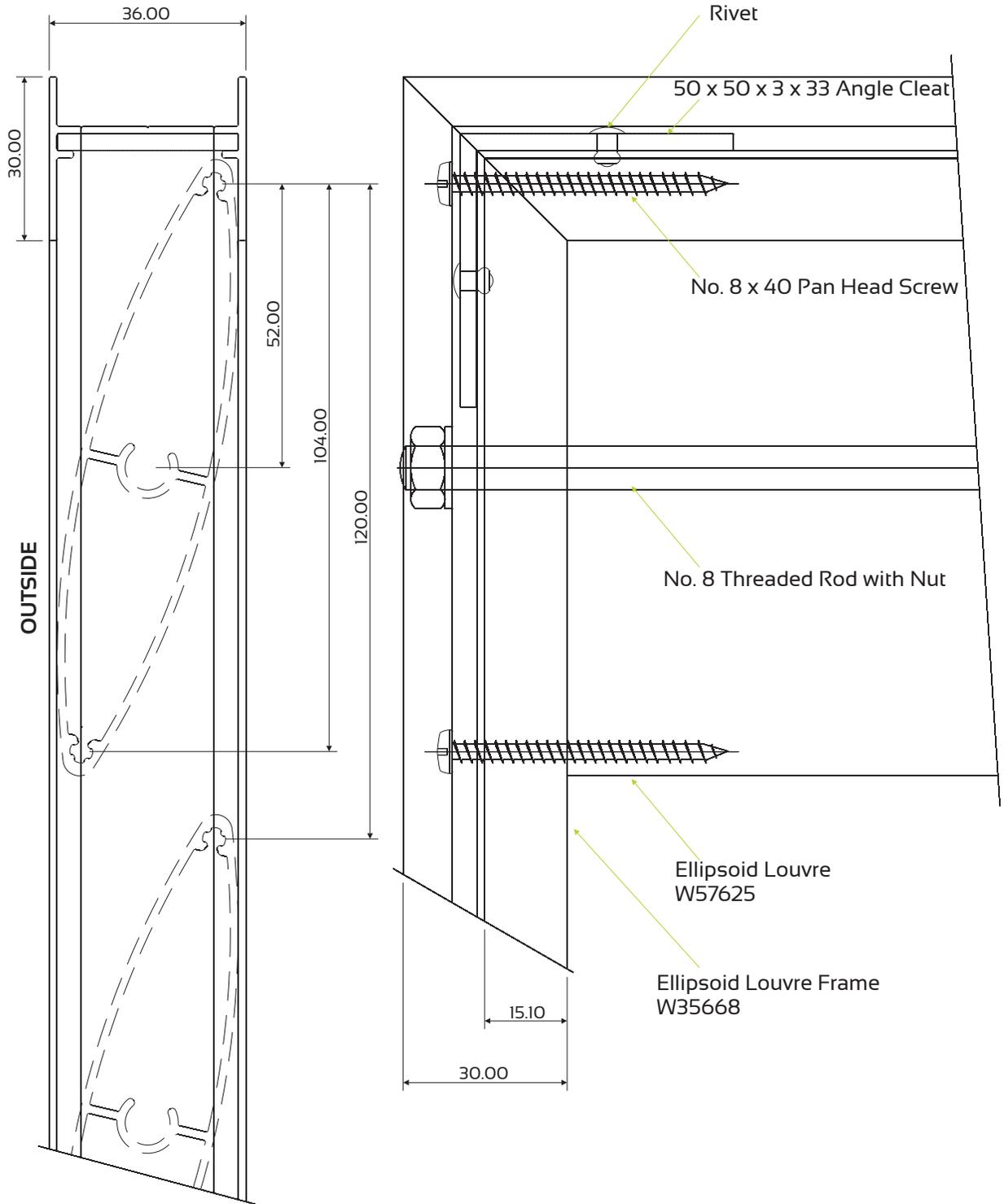
SECTION B-B
Section not to scale



No. 8 Threaded rod can be inserted for additional strength to the profile.

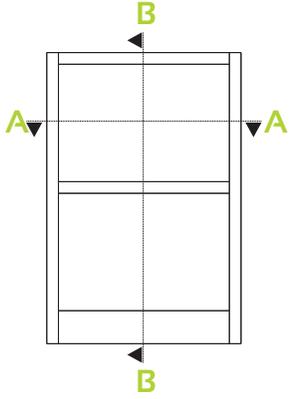
SECTION A - A
Section not to scale





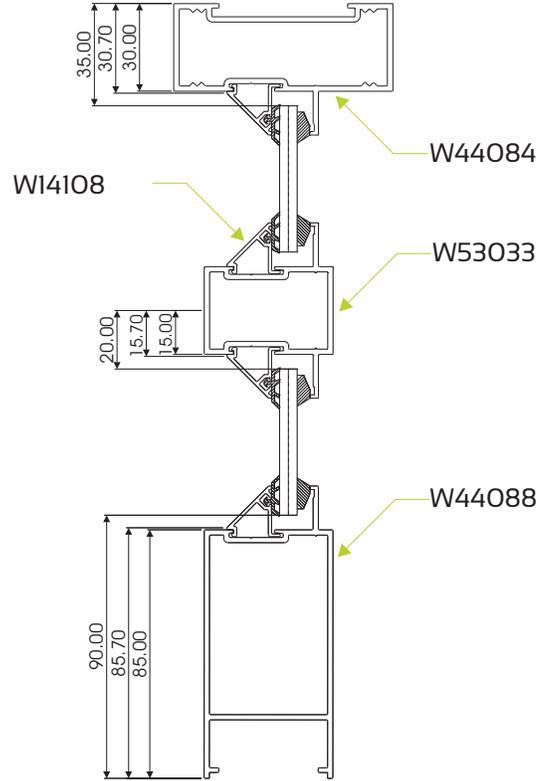
Cross-Sectional Detail

30mm Configuration with Midrail



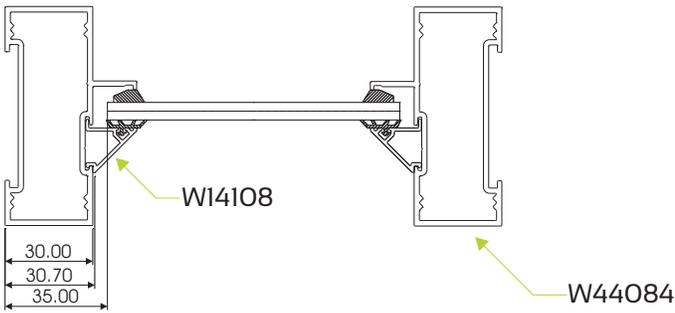
SECTION B-B

Section not to scale



SECTION A - A

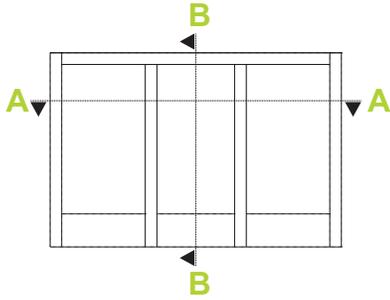
Section not to scale



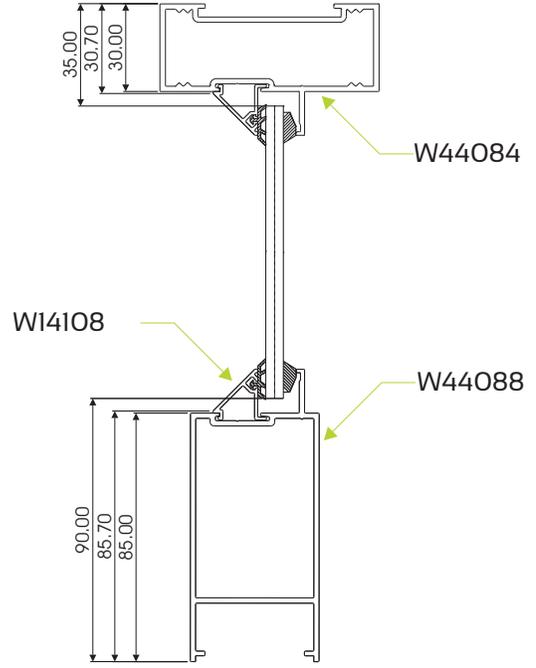
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Cross-Sectional Detail

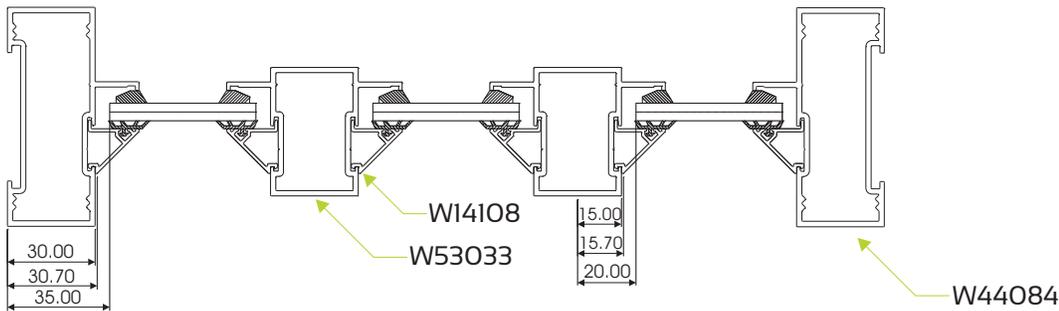
Sill Configuration with 2 Mullions



SECTION B-B
Section not to scale

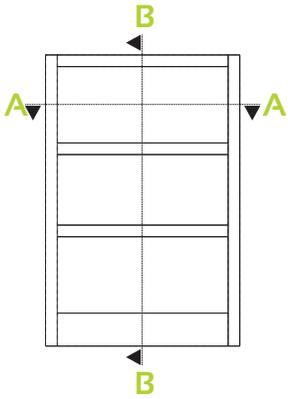


SECTION A - A
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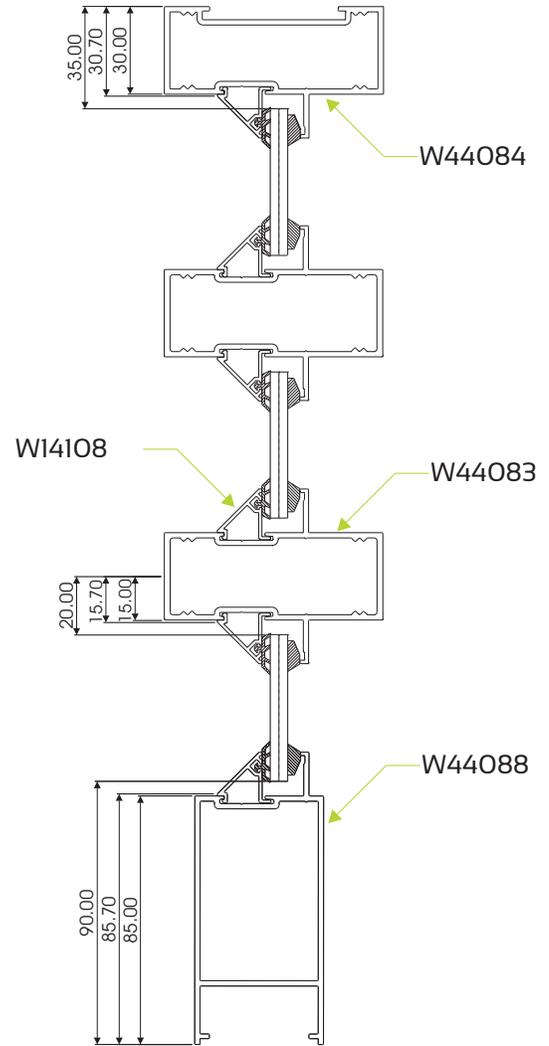


Cross-Sectional Detail

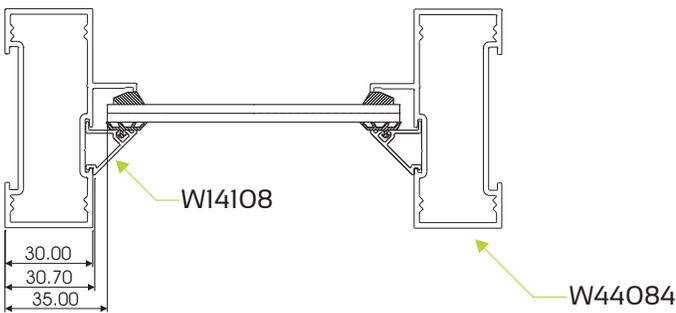
Transom Configuration



SECTION B-B
Section not to scale



SECTION A - A
Section not to scale

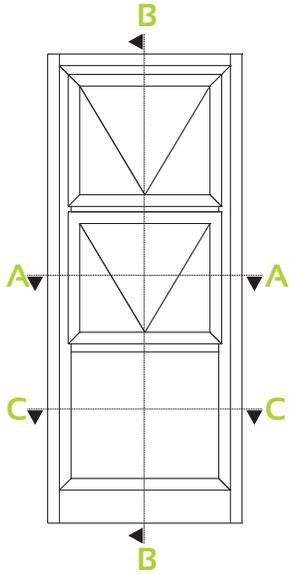
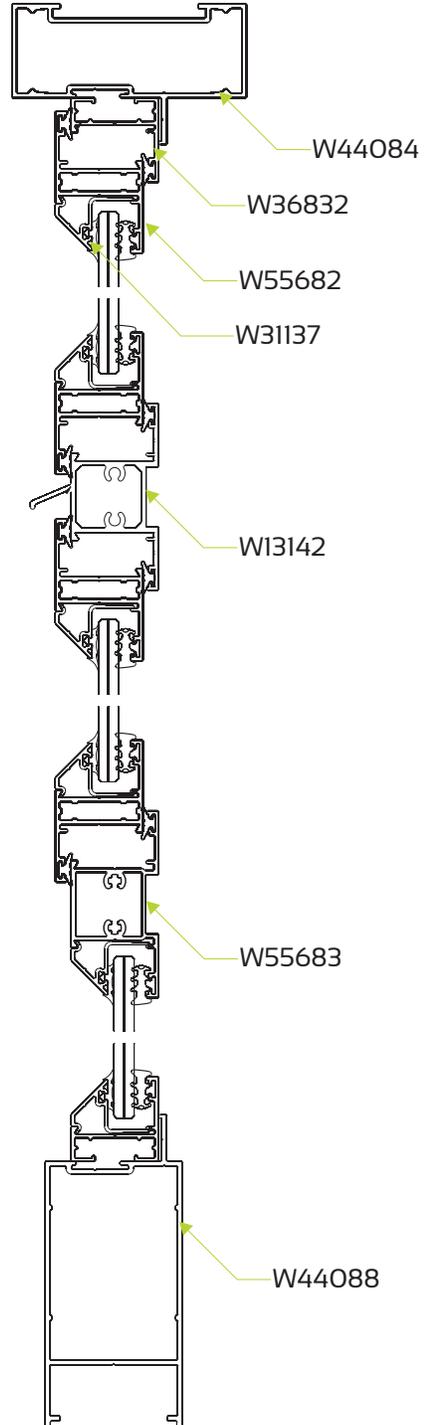


Cross-Sectional Detail

Swift 28 Short Leg Outer Frame in Clip 44

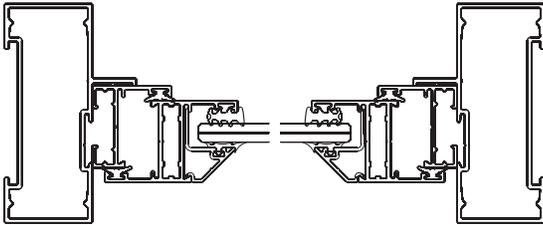
SECTION B-B

Section not to scale



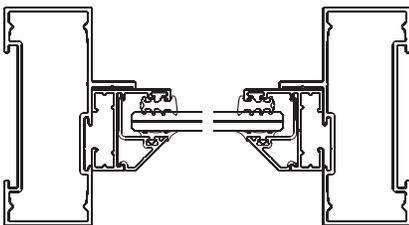
SECTION A - A

Section not to scale



SECTION C-C

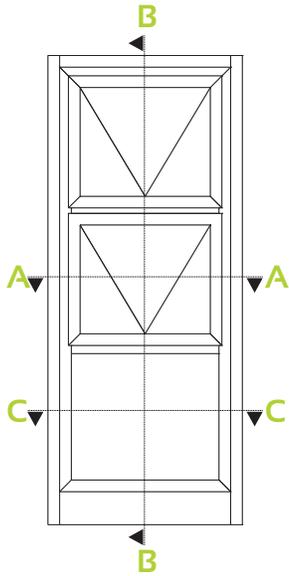
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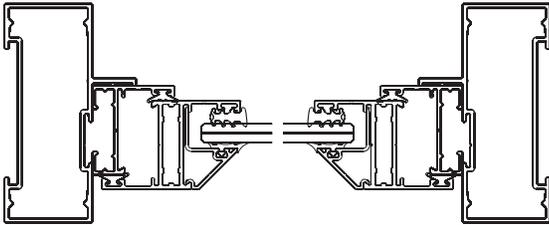
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Cross-Sectional Detail

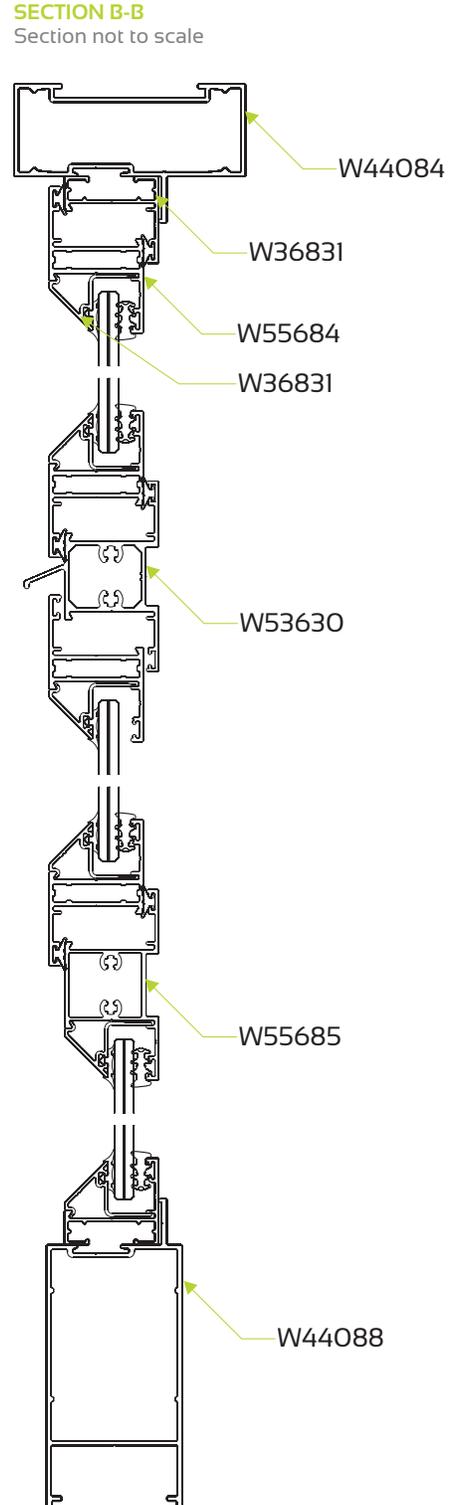
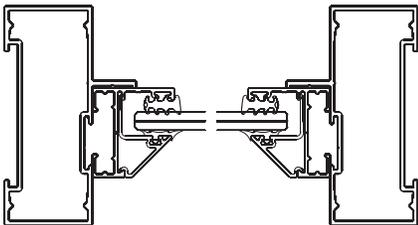
Swift 30.5 Short Leg Outer Frame in Clip 44



SECTION A - A
Section not to scale



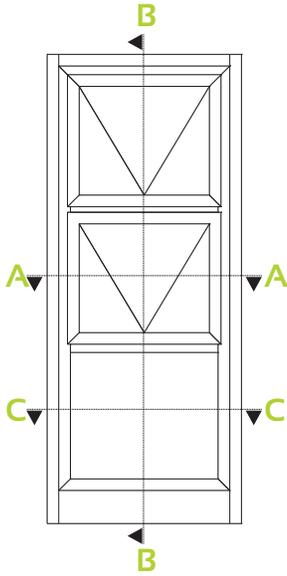
SECTION C - C
Section not to scale



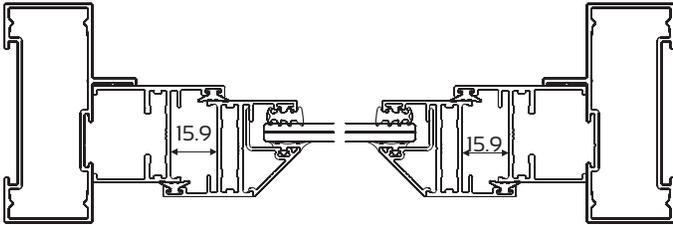
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Cross-Sectional Detail

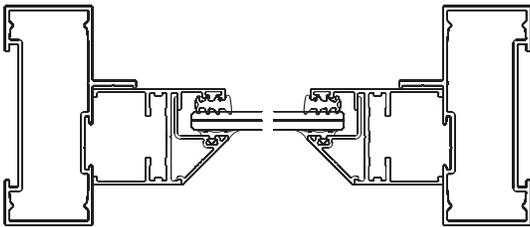
Typical Vertical Section showing the Swift 34 Outer Frame in Clip 44



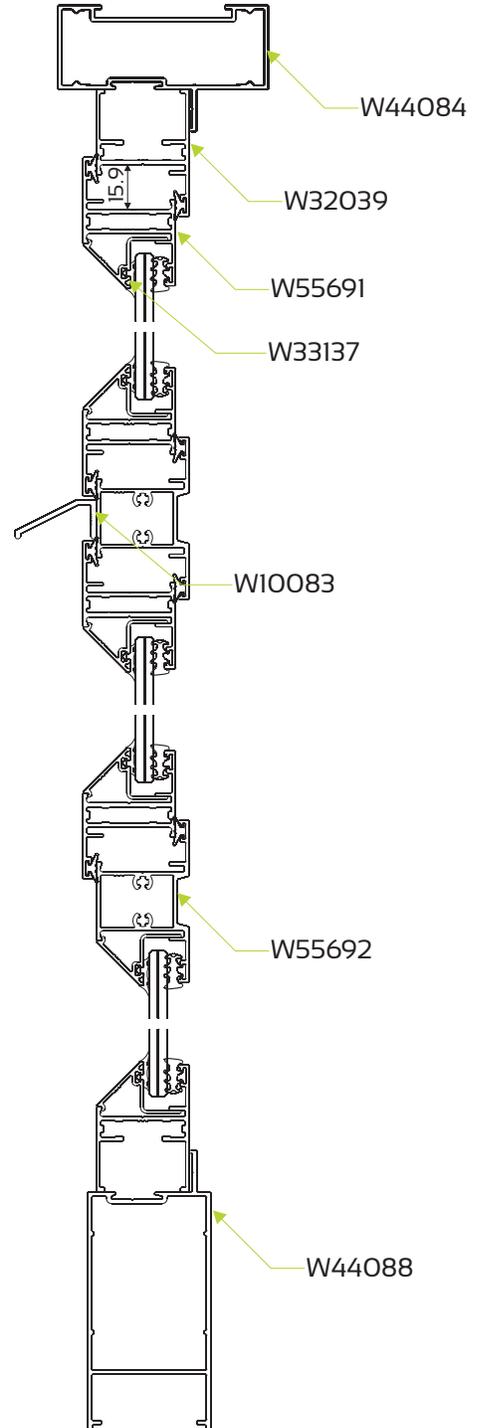
SECTION A - A
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SECTION C - C
Section not to scale

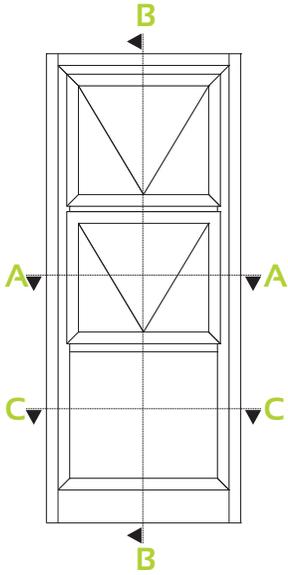


SECTION B - B
Section not to scale

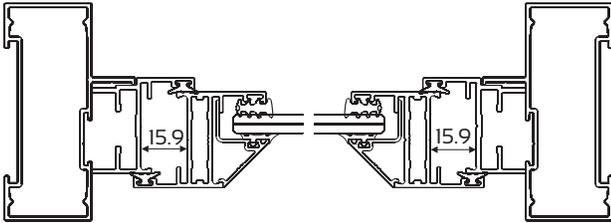


Cross-Sectional Detail

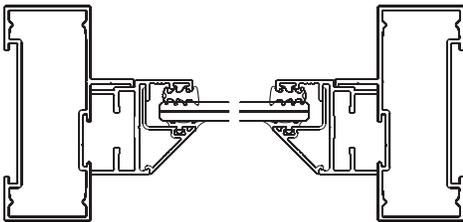
Typical Vertical Section showing the Swift 34 Short Leg Outer Frame in Clip 44



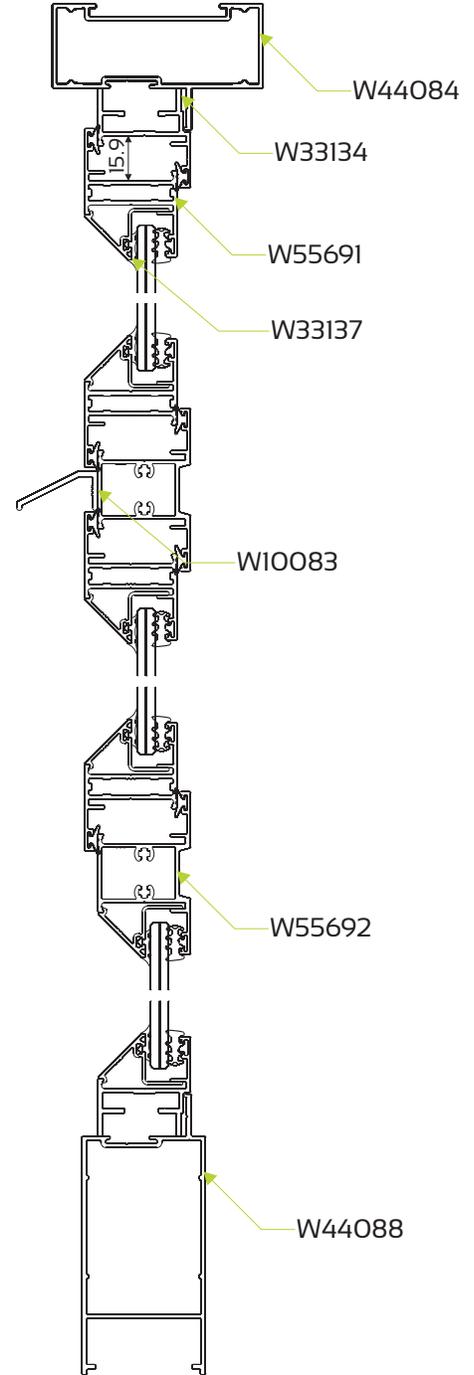
SECTION A - A
Section not to scale



SECTION C - C
Section not to scale



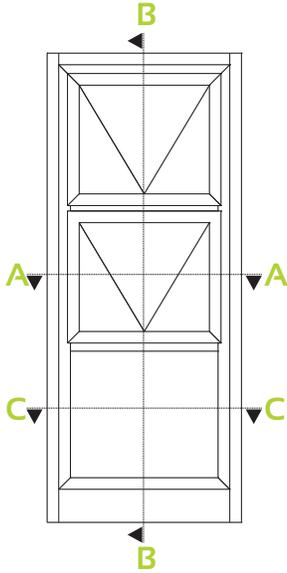
SECTION B - B
Section not to scale



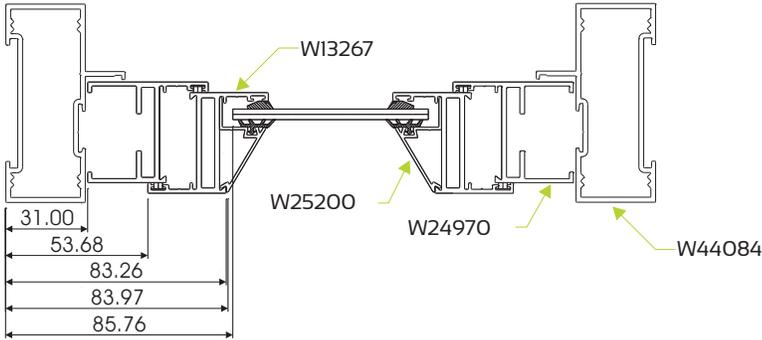
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Cross-Sectional Detail

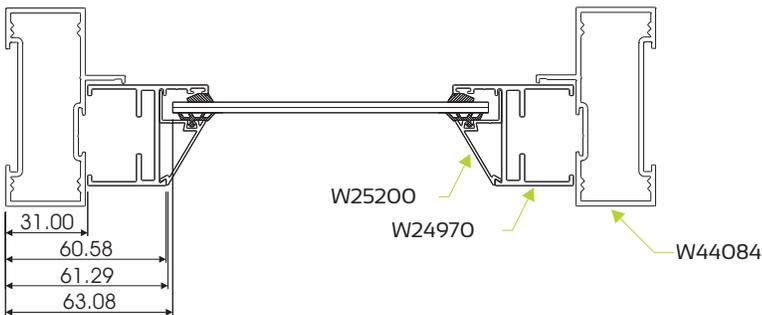
Swift 38 Insert - Two Top Hung Over Fixed



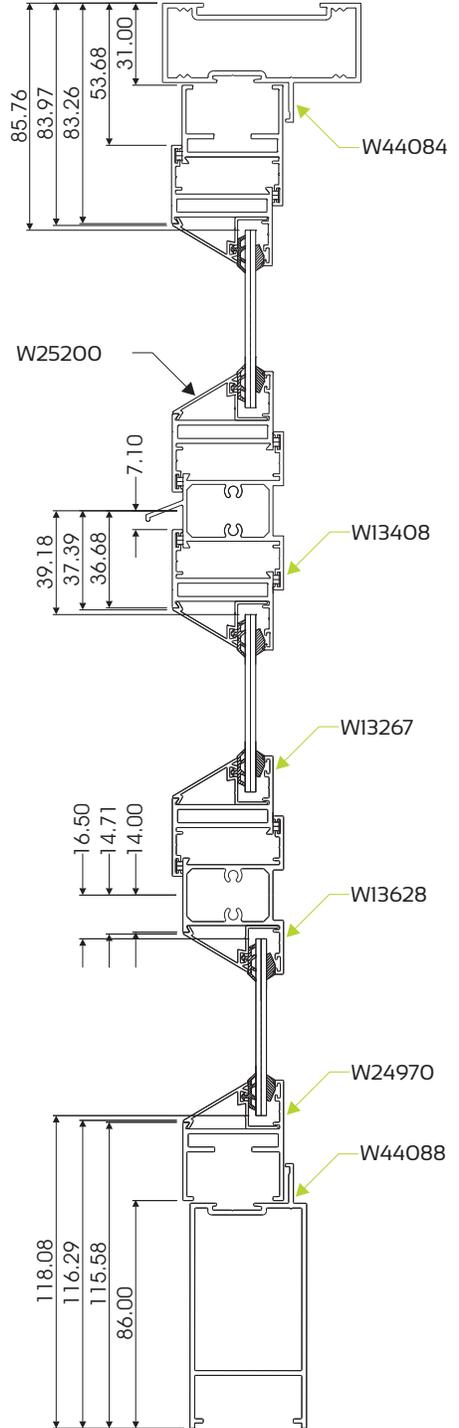
SECTION A - A
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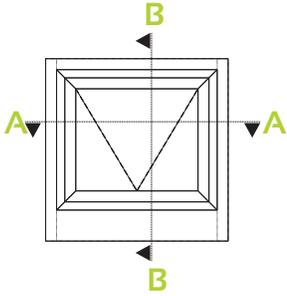
SECTION C - C
Section not to scale



SECTION B - B
Section not to scale

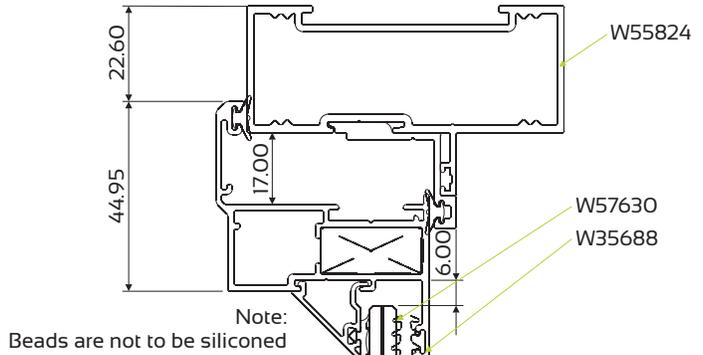


Euro Sash Cross-Sectional Detail

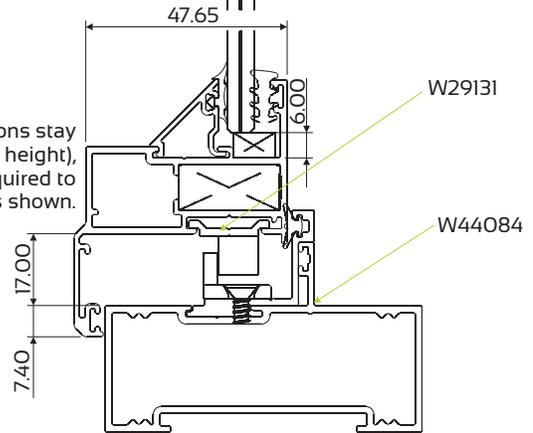


SECTION B-B

Section not to scale

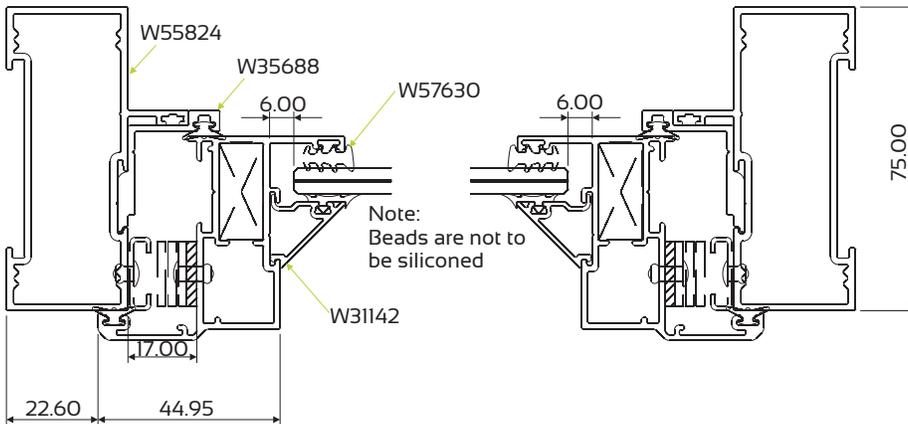


Note: Should a small frictions stay be used (14mm stack height), then a 3mm spacer is required to have a total gap of 17mm as shown.

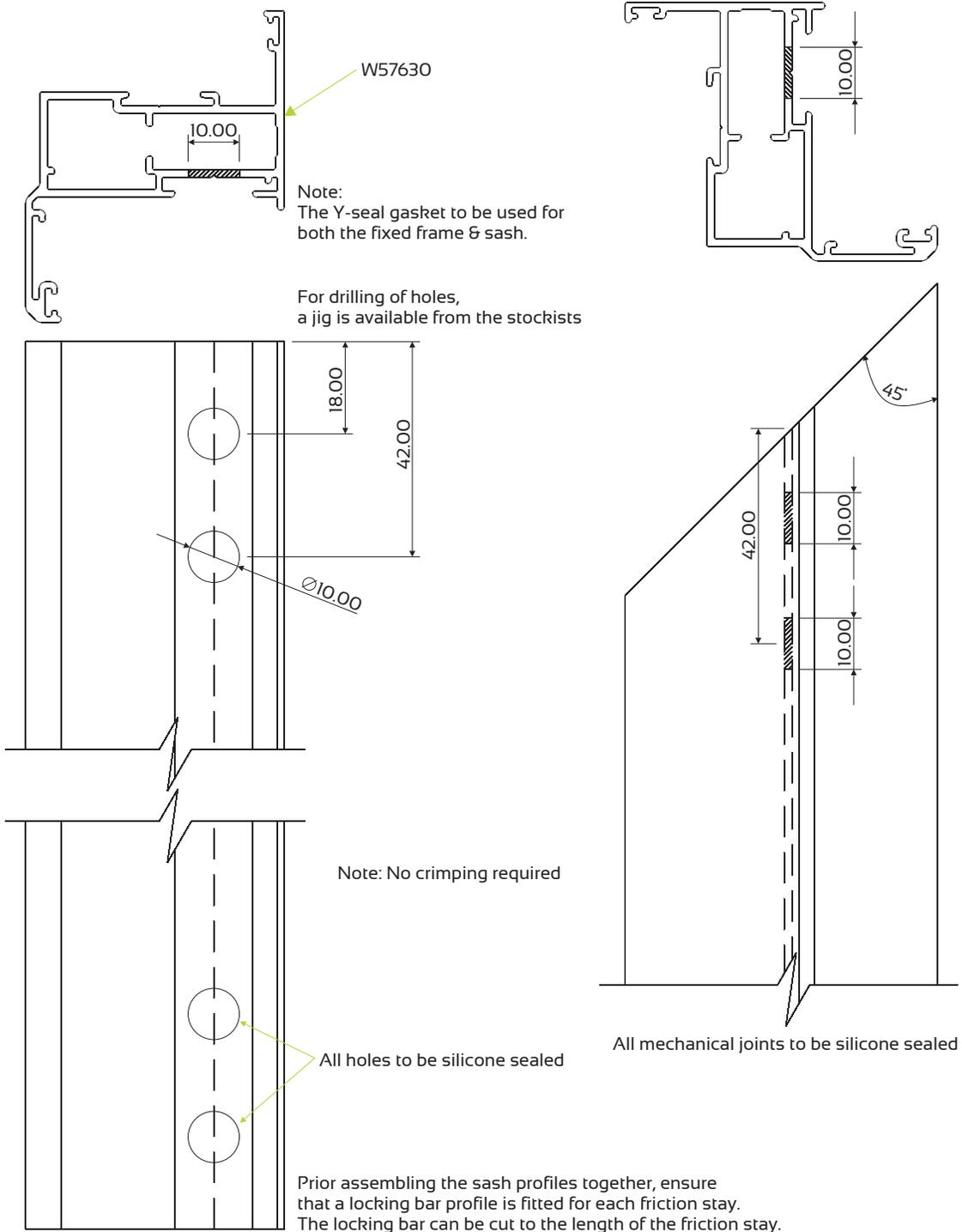


SECTION A - A

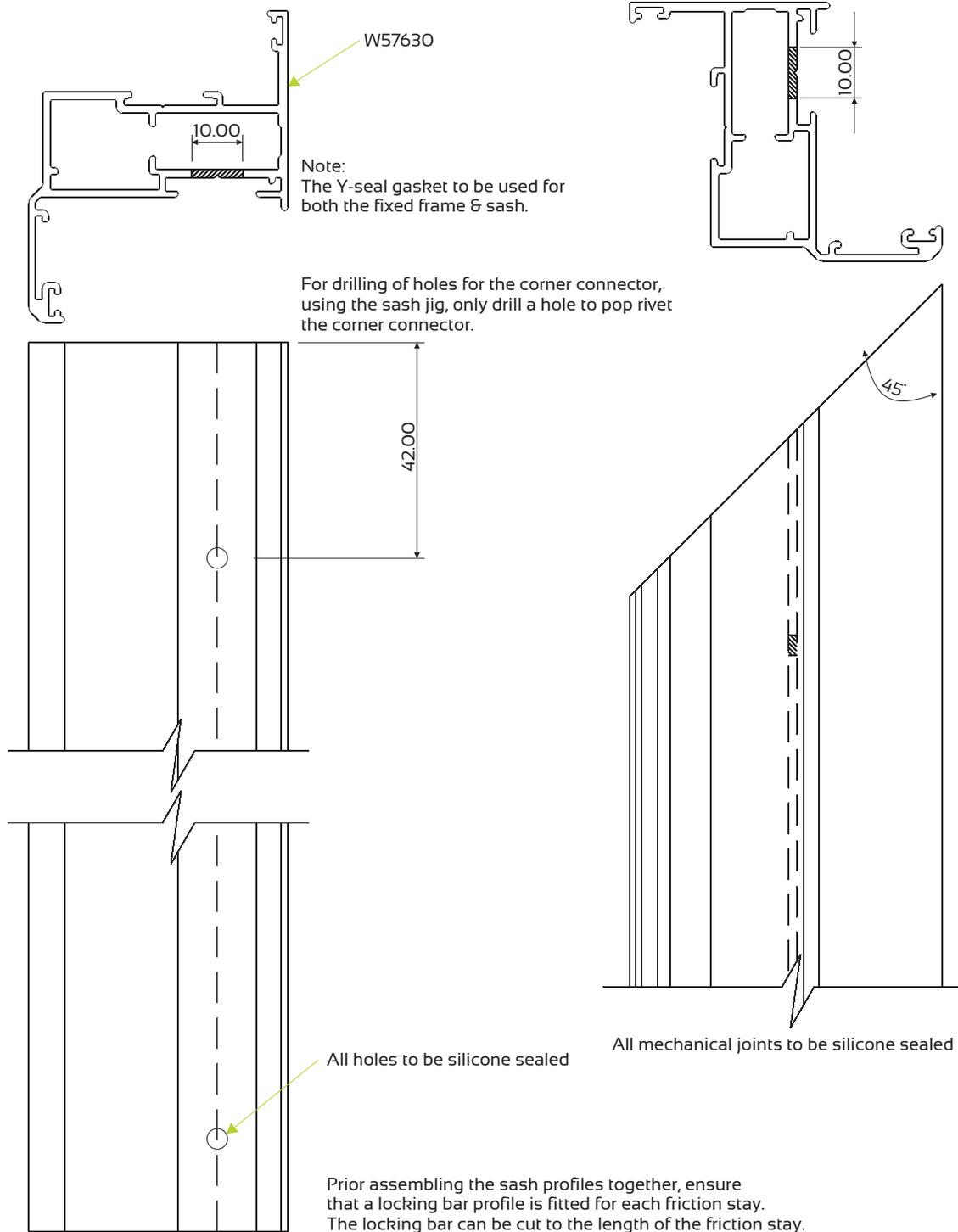
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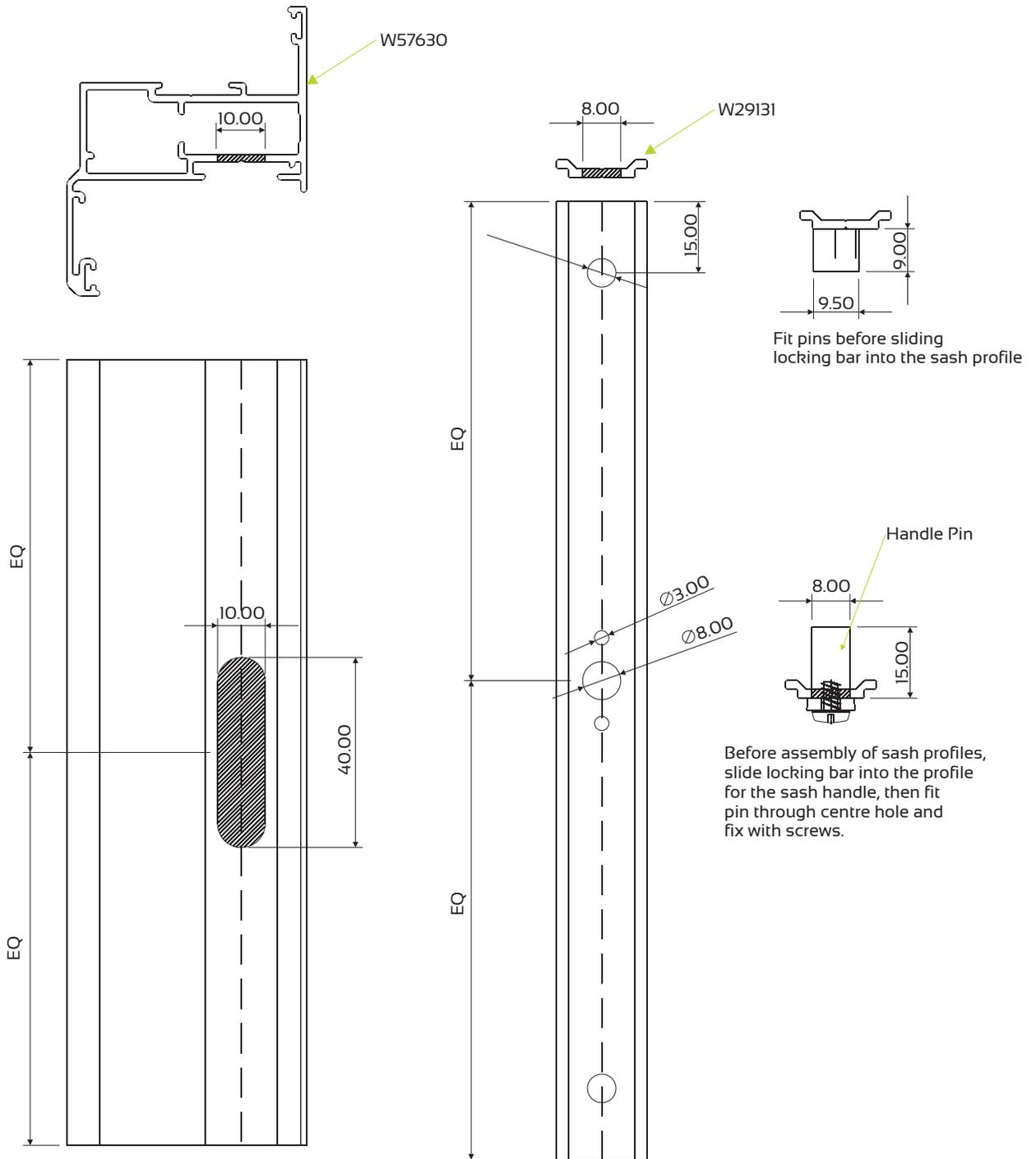


OPTION A - USING THE JOINING CORNER

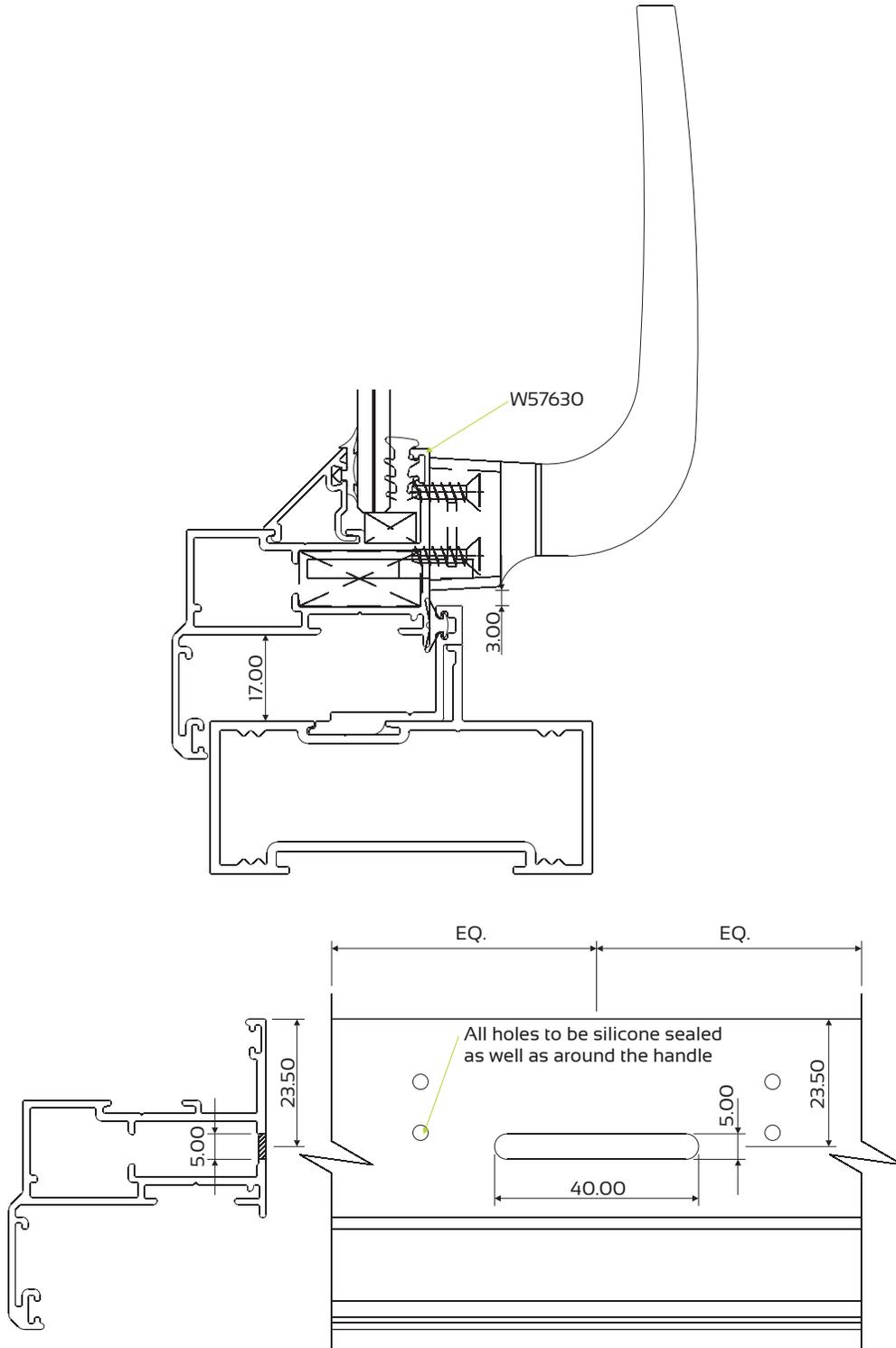


OPTION B - USING THE CORNER CONNECTOR

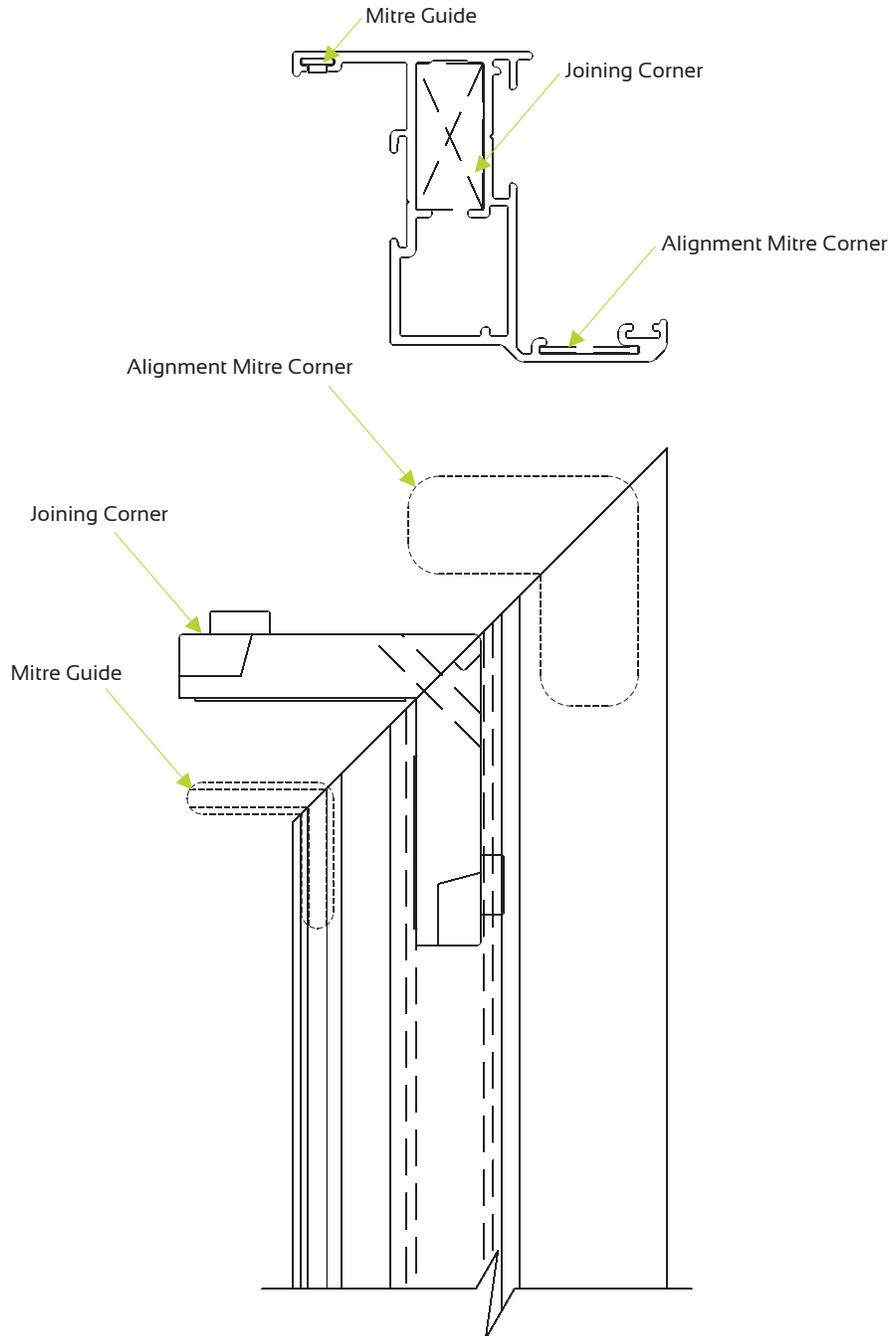




Note:
Before assembly of the sash frame, the locking bar needs to be inserted into the bottom sash profile with the locking pins fitted & holes drilled to receive the handle pin.

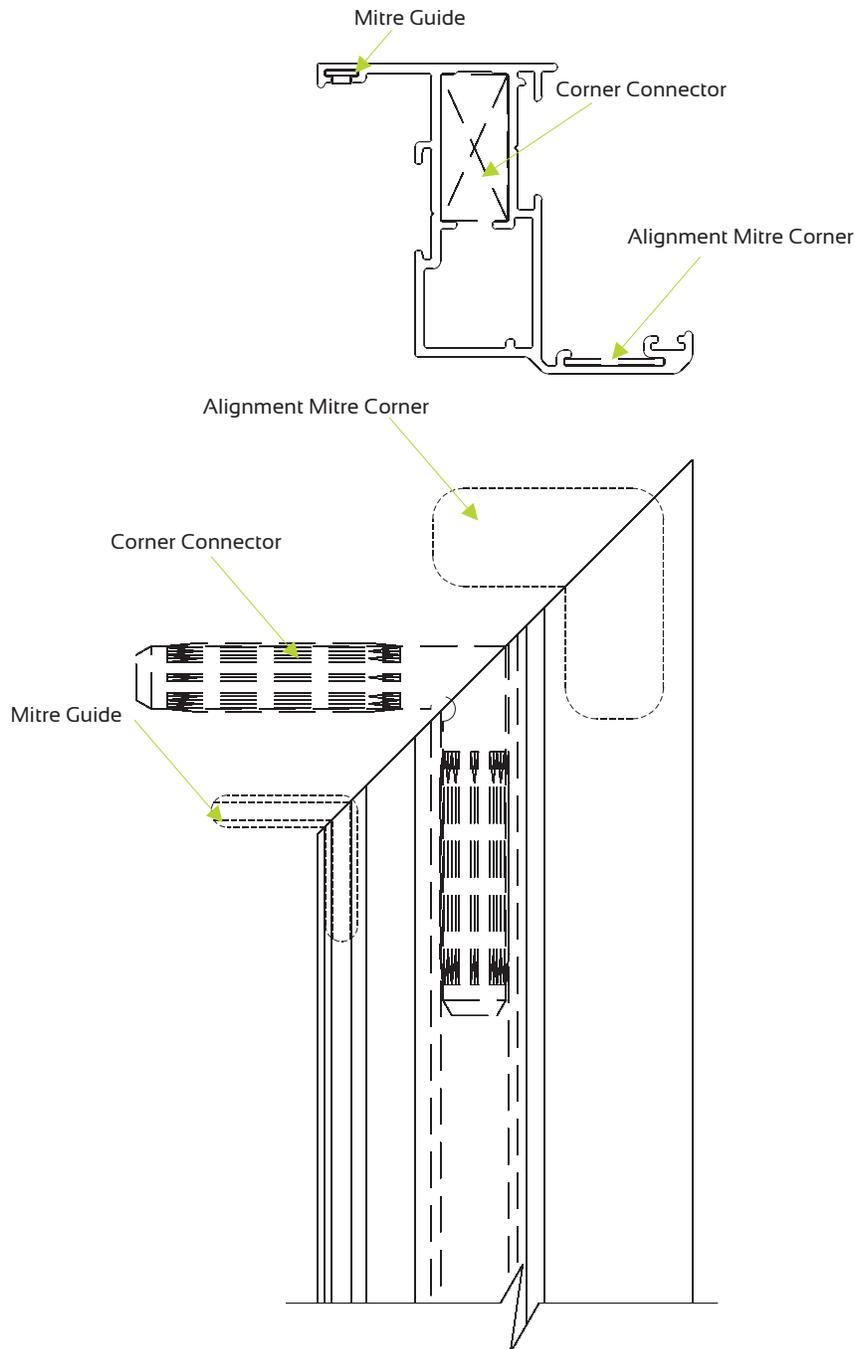


OPTION A - USING THE JOINING CORNER



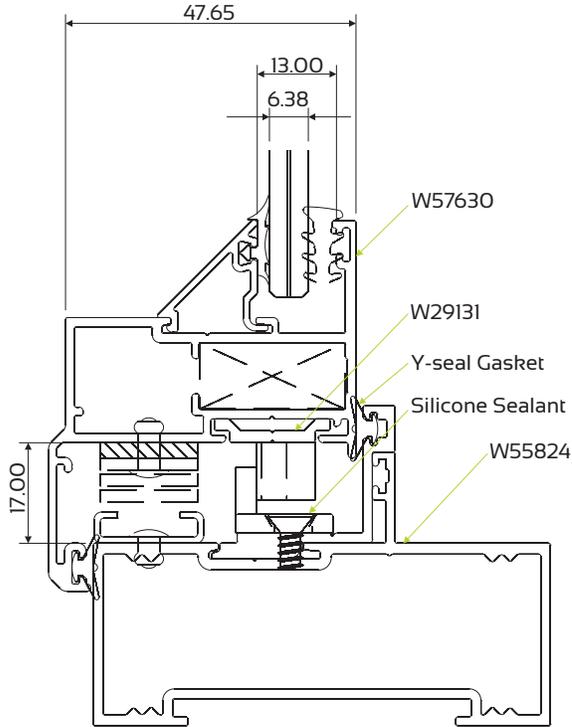
All mechanical joints to be Crealco silicone sealed
Prior assembling the sash profiles together, ensure
that the relevant locking bar profiles are fitted into the sash profiles.
The locking bars can be cut to the length of the friction stays.

OPTION B - USING CORNER CONNECTOR

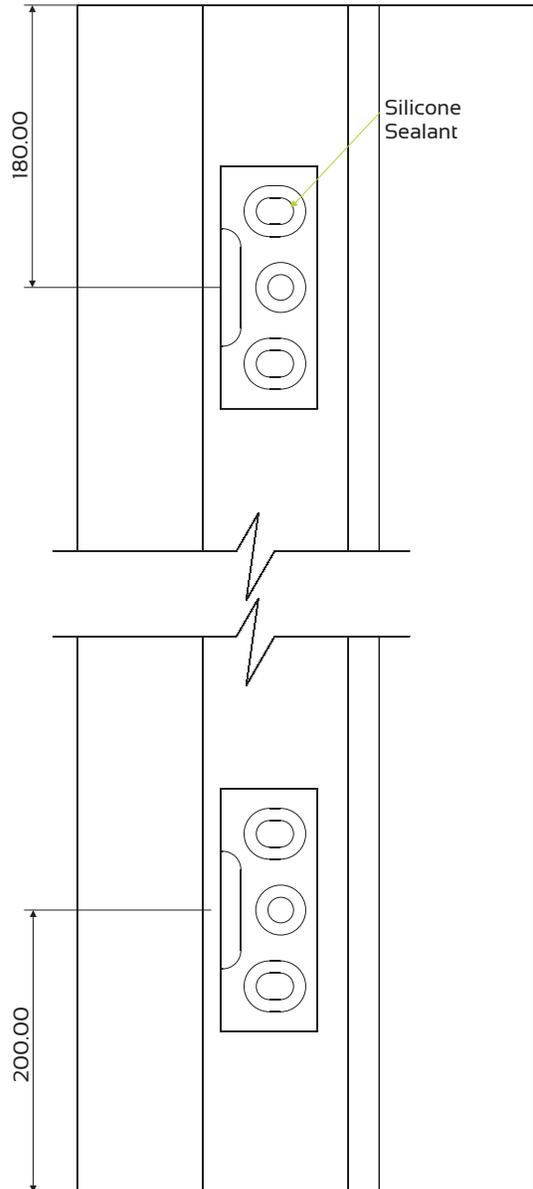
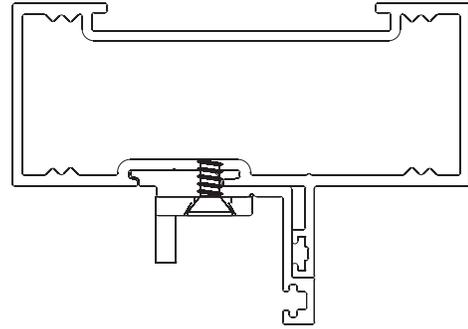


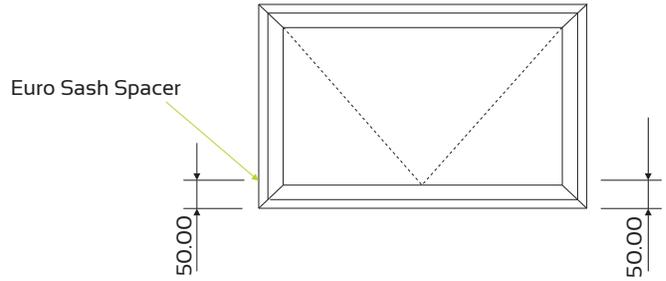
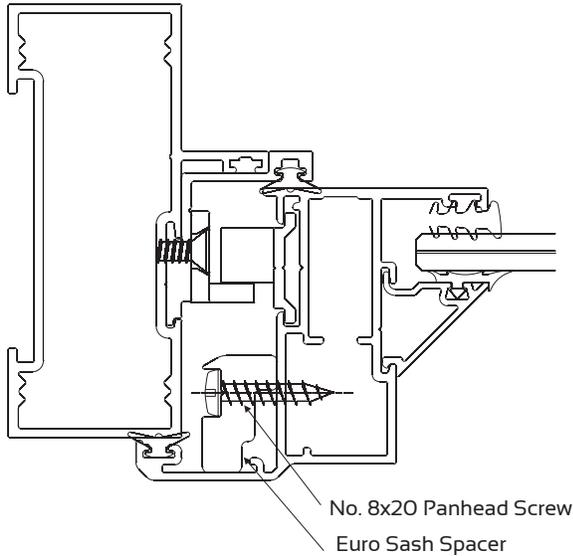
All mechanical joints to be Crealco silicone sealed
Prior assembling the sash profiles together, ensure
that the relevant locking bar profiles are fitted into the sash profiles.
The locking bars can be cut to the length of the friction stays.

Note:
Beads are not to be siliconed

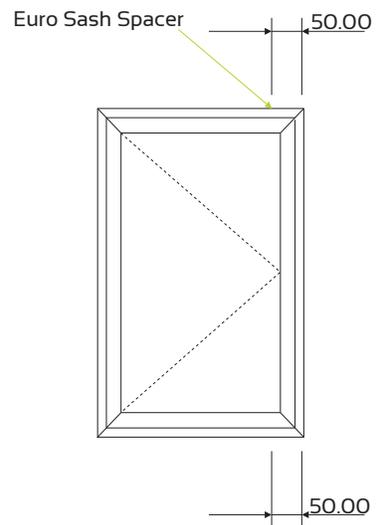
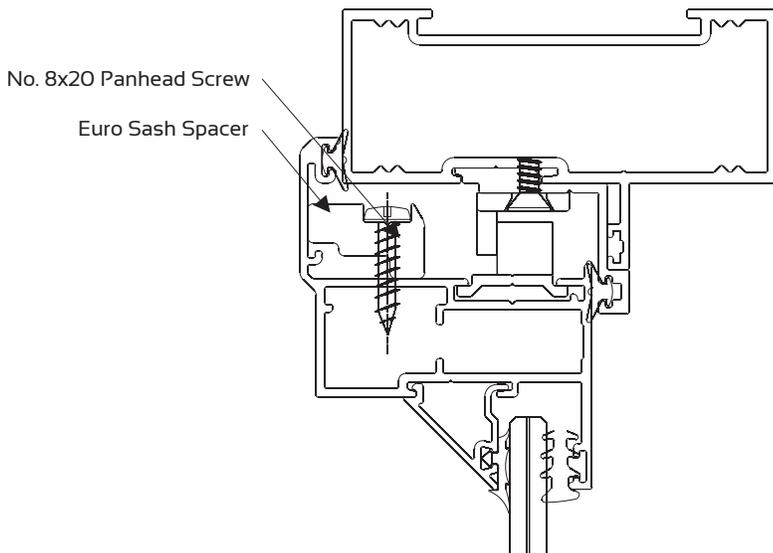


Note:
No Y-seal gasket to be fitted
for the bottom sash profile unless
the building is over 3 stories high or as required.





Note:
To assist the top hung sash in opening & closing squarely, a Euro sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.



Note:
To assist the top hung sash in opening & closing squarely, a Euro sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.

GLAZING

1. SELECTION OF GLAZING METHODS

1.1 SETTING AND LOCATION BLOCKS

Glass-to-metal contact must be avoided at all times by using setting and location blocks having a hardness of 50° to 90° shore A durometer. Use only blocks made of Neoprene, EPDM, Silicone or other elastomeric material.

Setting blocks are to have a minimum thickness of 3mm and must be at least 27mm in length per square metre of glass area.

The position of the setting and location blocks is illustrated in Figure 2.

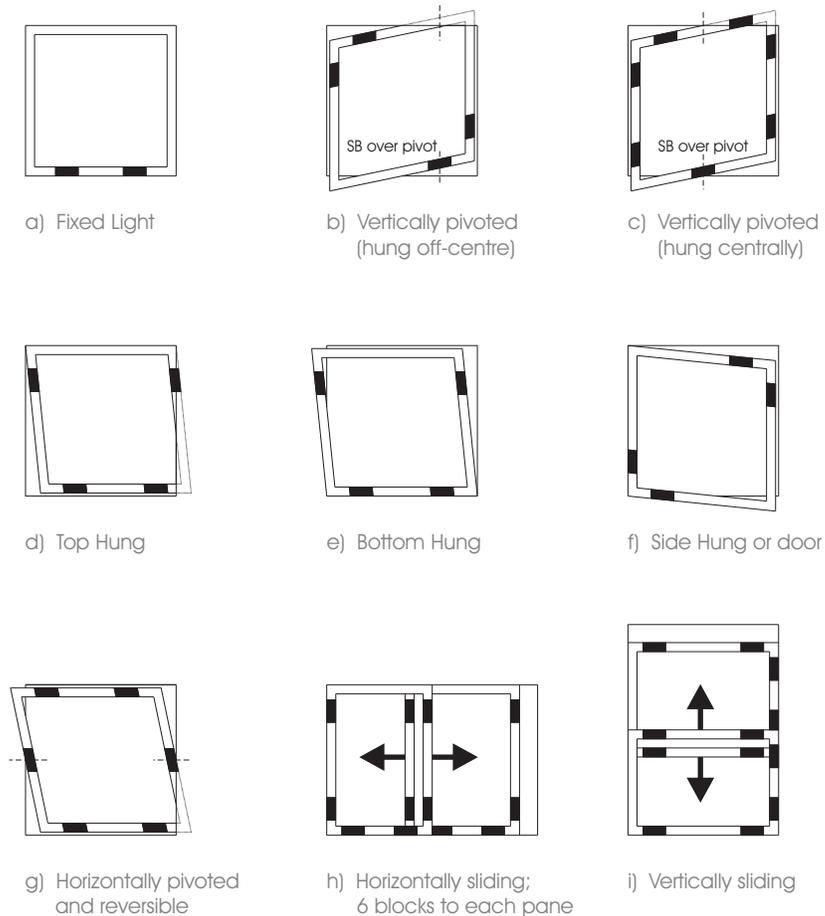


FIGURE 2 - POSITION OF SETTING AND LOCATION BLOCKS