PRODUCT MANUAL

March 2018

SWIFT™ 30.5

WINDOW (30.5 mm)

crealco
creative aluminium

A product of
WISPECO Aluminium

LEGAL DISCLAIMER

SWIFT™ 30.5 WINDOW (30.5 mm)

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 the Wispeco website 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 adversly 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.

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

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SWIFT™ 30.5
WINDOW (30.5 mm)

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INDEX

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INDEX

SWIFT™ 30.5 WINDOW (30.5 mm)

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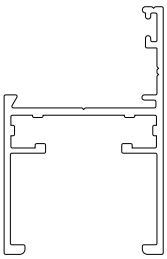
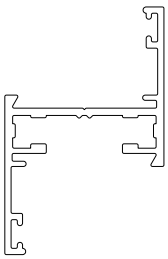
Profile Identification

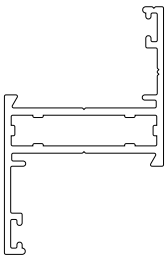
Swift 30.5 Window Profiles



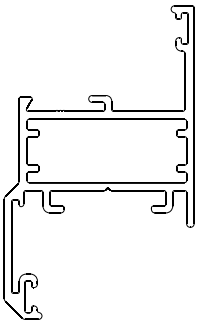
DIE No. W32028A | Swift 30.5 Frame 30mm Equal Leg



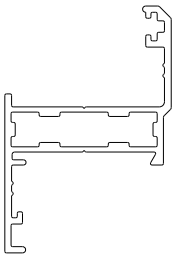
DIE No. W32027 | Swift 30.5 Frame 30mm Unequal Leg



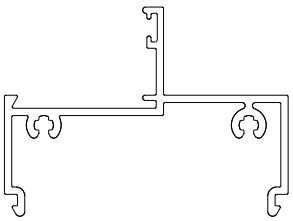
DIE No. W55684A | Swift 30.5 Sash Tubular



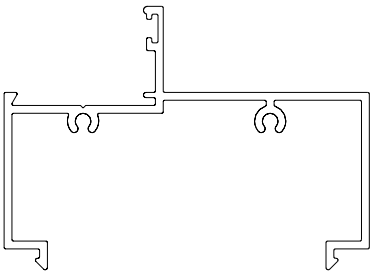
DIE No. W57602 | Swift 30.5 Sash Euro



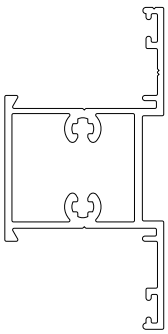
DIE No. W55441 | Swift 30.5 Sash Picture Frame



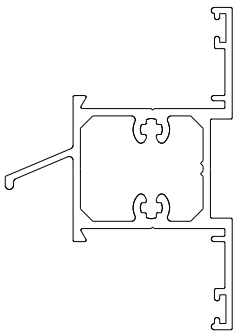
DIE No. W28481 | Swift 30.5 Frame 54mm



DIE No. W70968 | Swift 30.5 Frame 70mm Sidelight



DIE No. W55685A | Swift 30.5 Mullion 30mm Standard



DIE No. W53630 | Swift 30.5 Mullion 30mm Weather Bar

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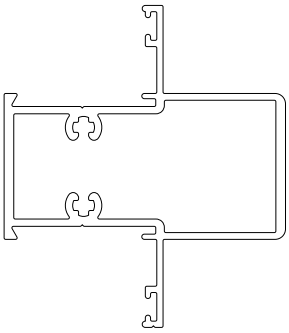
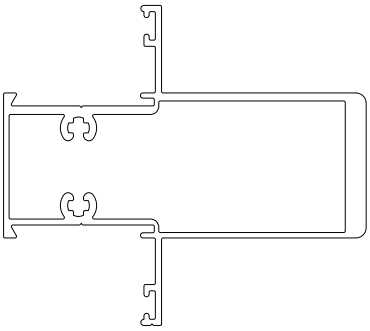
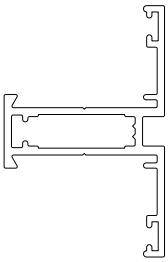


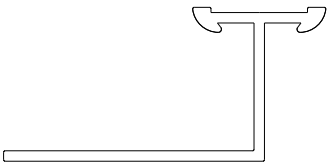
DIE No. W54651A | Swift 30.5 Mullion 54mm



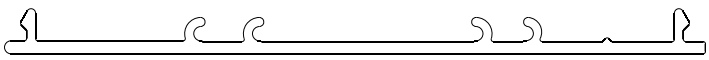
DIE No. W54652A | Swift 30.5 Mullion 70mm



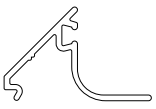
DIE No. W54867 | Swift 30.5 Mullion 30mmCottage Pane



DIE No. W28002 | Swift 30.5 Fixing Lug Twist In

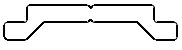


DIE No. W30607 | Fixing Lug

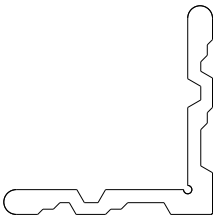


DIE No. W31139A | Swift 30.5 Bead Multi 13mm Gap

DIE No. W35620 | Swift 30.5 Bead Euro 13mm Gap



DIE No. W29131 | Locking Bar



DIE No. W27989 | Swift 30.5 Corner Cleat 40mm

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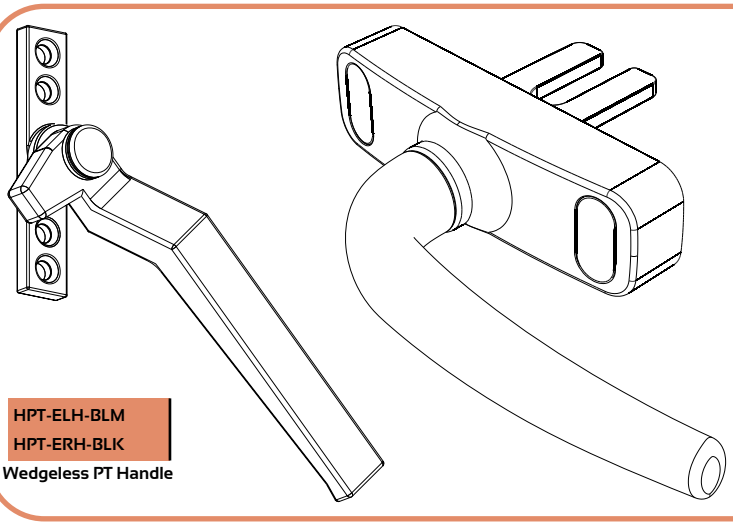
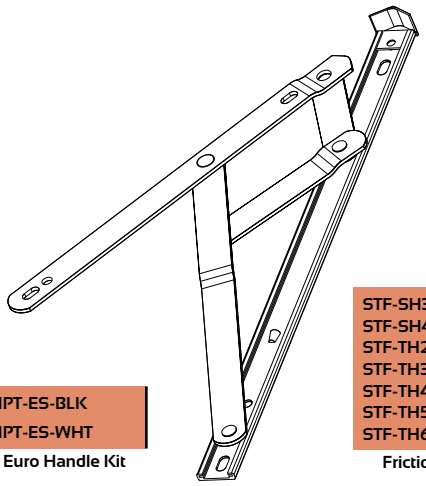
Hardware Components

RECOMMENDED SWIFT 30.5 COMPONENTS

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

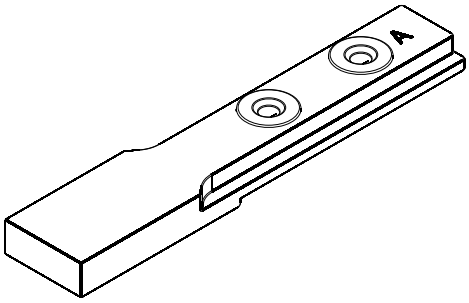


HPT-ELH-BLM
HPT-ERH-BLK
Wedgeless PT Handle

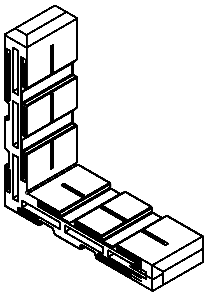


HPT-ES-BLK
HPT-ES-WHT
Euro Handle Kit

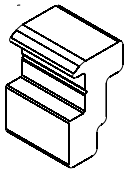
STF-SH300S-304
STF-SH400S-304
STF-TH200S-304
STF-TH300R-304
STF-TH400S-304
STF-TH500S-304
STF-TH600S-304
Friction Stay



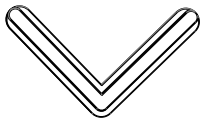
TLP-CJ
Euro Sash Jig



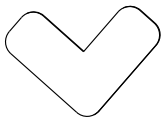
LGR-CCES
Euro Sash Corner Connector



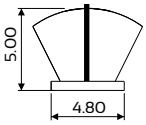
HPT-ESS
Euro Sash Spacer



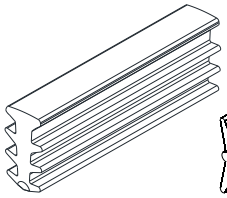
SGD-FM48
Frame Mitre Guide



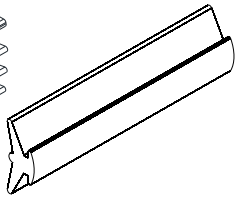
SGD-FMG520
Alignment Mitre Corner



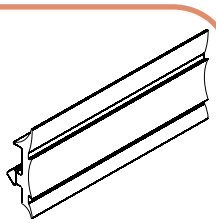
GFP-4850
Finpile



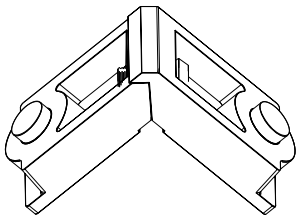
GWG-01G
GWG-02B
GWG-03R
GWG-04Y
GWG-05P
Wedge Gasket



GSL-AL-H602
Y Seal Gasket



GBF-ORG
Butterfly Gasket



LGC-J2410N
Joining Corner

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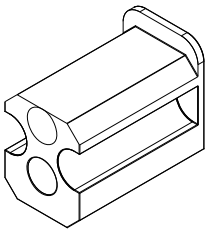
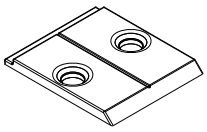
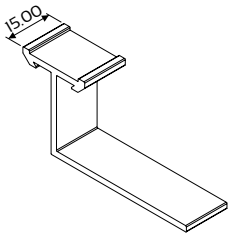


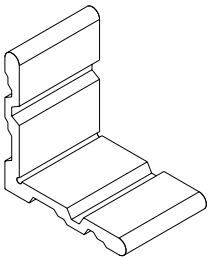
LGR-CC305B
30.5 Cross Connector (Black)



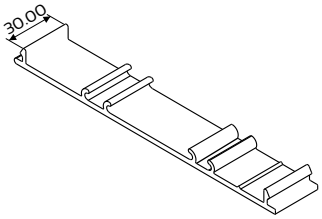
LGR-MP305B
Swift 30.5 Glazing Bar Packer (Black)



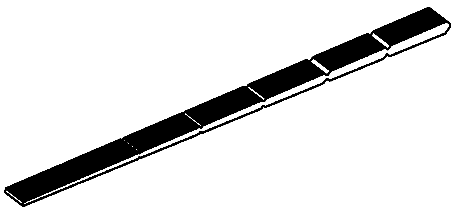
W13142
28 Fixing Lug Alum 15mm



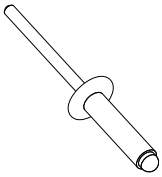
LGC-52695-28
30.5 Caselite Corner Cleat



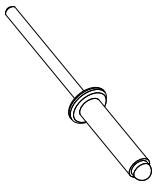
W30607
Multi Fixing Lug Alum 15mm



FSN-GSB
Glass Setting Blocks

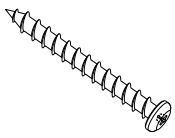


FRC-410
C/Sunk Rivet

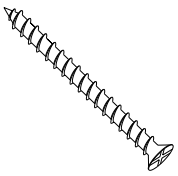


FRD-4810
Dome Rivet

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



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



FSC-0840P-SS
Countersunk POSI 8x40 S/S Screw

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Maintenance of the Friction Stay

With a minimal amount of care and maintenance your CREALCO CASEMENT windows will stay looking good and performing superbly for many years to come - a valuable, long lasting asset giving continued satisfaction and pride.

Basics of a Friction Stay
A friction stay is a type of hinge that controls the opening of the window so that it will stay open at the width you decide to open it to, not closing under its own weight or being too difficult to open and close.

Friction Stay Maintenance
As the name implies, a friction stay needs a level of friction to operate correctly. Too much friction and the friction stay arms can be bent in operation and the window will be stiff and difficult to open. Too little friction and the window will not stay at its required level.

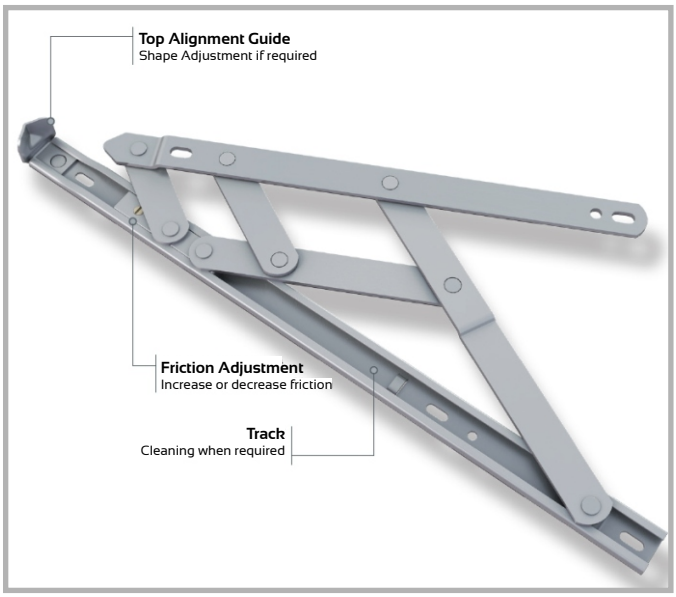
Key to the correct sealing of the casement sash is the top alignment guide which maintains the friction stay in the closed and sealed position. If the shape of the guide is altered or flared it can result in poor sealing of the sash as well as incorrect alignment of the friction stay.

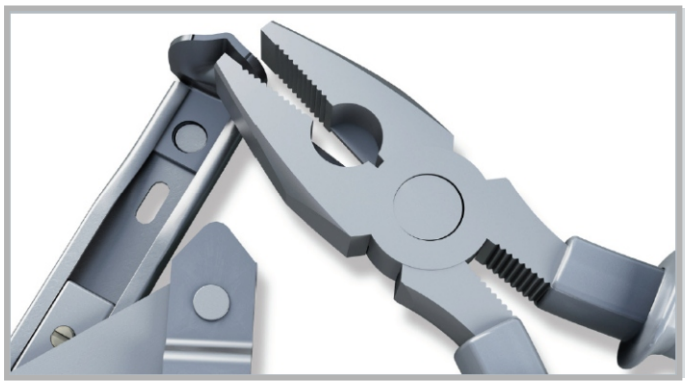
Track Maintenance
Ensure that the track is free from dirt and debris which can alter the friction of the hinge. It is best not to add lubricants as this can alter the friction as well as collect more debris which can cause wear within the track.

Friction Adjustment
The hinge is factory set and may after continue use become loose. Should this occur using a small flat bladed screwdriver turn the screw on the friction hinge clockwise to increase the amount of friction.

The same adjustment should be made to both the hinges on the window. Also should the window be stiff in operation turn the screw anti-clockwise until the desired result is achieved.

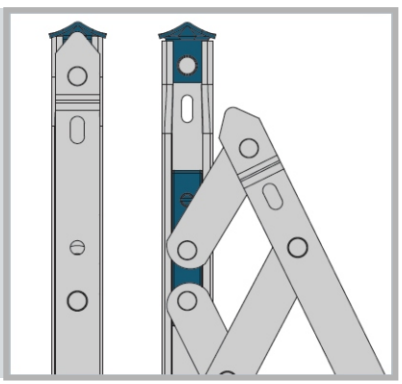
Top Alignment Guide
The top alignment guide can flare or distort due to a number of issues. For correct operation it is important to bend the alignment guide back into position.





Straighten the Guide with pliers or suitable tool

Correct Shape and Seating for Top Alignment Guide



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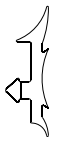
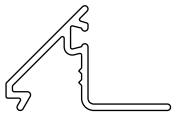
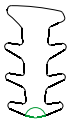
Butterfly Gasket & Wedge Codes



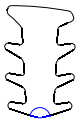
Butterfly Gasket
GBF-ORG



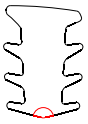
W31139 BEAD



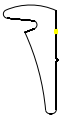
Wedge Gasket
GWG-01G



Wedge Gasket
GWG-02B

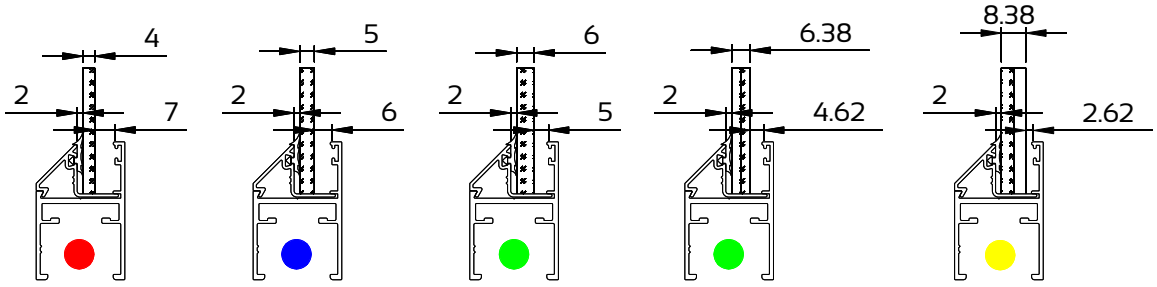


Wedge Gasket
GWG-03R



GWG-04Y

WEDGES



SWIFT 30.5 WITH W31139 BEAD

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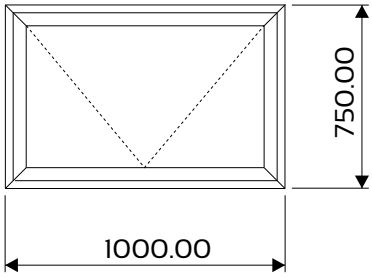
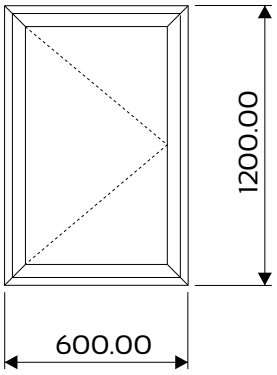
Sash Limitation Guide

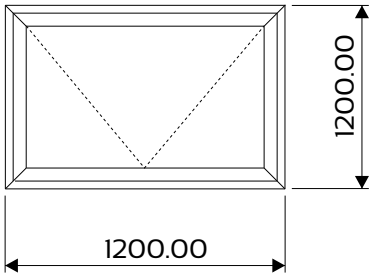
The sash limitations of the system are strictly calculated in accordance to AAMSA guidelines and take into account the aluminium specifications as well as the glass used. Please ensure that these are adhered to as any product produced outside of these limitations will not adhere to AAMSA regulations.

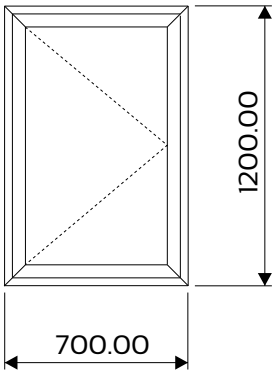
STANDARD SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W55684	1000	750
Side Hung		600	1200





EURO SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W57602	1200	1200
Side Hung		700	1200





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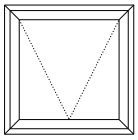
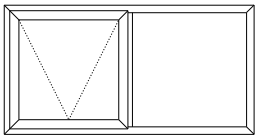
Typical Configurations

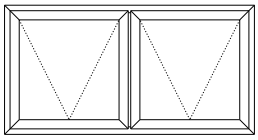
Standard Top Hung Window



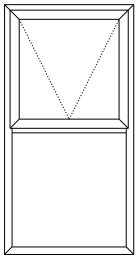
A
SINGLE TOP HUNG



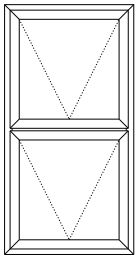
BB
TOP HUNG
NEXT TO FIXED



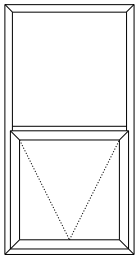
CC
TOP HUNG NEXT
TO TOP HUNG



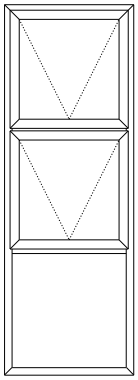
B
TOP HUNG
OVER FIXED



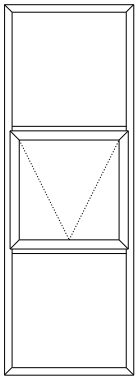
C
TOP HUNG
OVER TOP HUNG



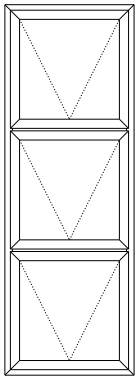
E
FIXED OVER
TOP HUNG



D
DOUBLE TOP HUNG
OVER FIXED



DD
FIXED OVER
TOP HUNG
OVER FIXED



EE
TRIPLE TOP HUNG

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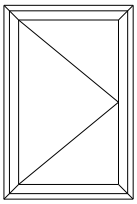
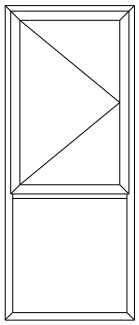
Typical Configurations

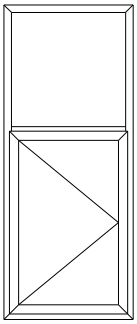
Standard Side Hung Window



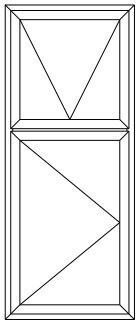
A
SINGLE SIDE HUNG



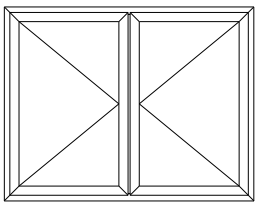
B
SIDE HUNG
OVER FIXED



C
FIXED OVER
SIDE HUNG



D
TOP HUNG
OVER SIDE HUNG



CC
SIDE HUNG NEXT
TO SIDE HUNG

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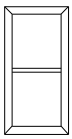
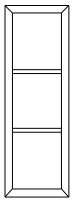
Typical Configurations

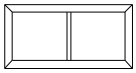
Cottage Pane Fixed Panel Window



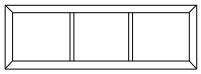
A
1 x 2 FIXED PANEL



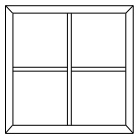
B
1 x 3 FIXED PANEL



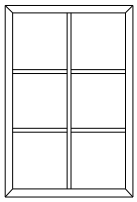
C
2 x 1 FIXED PANEL



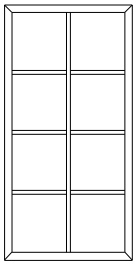
D
3 x 1 FIXED PANEL



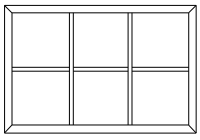
E
2 x 2 FIXED PANEL



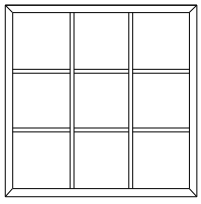
F
2 x 3 FIXED PANEL



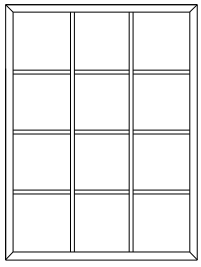
G
2 x 4 FIXED PANEL



H
3 x 2 FIXED PANEL



I
3 x 3 FIXED PANEL



J
3 x 4 FIXED PANEL

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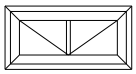
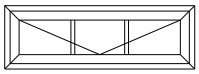
Typical Configurations

Cottage Pane Top Hung & Side Hung Window

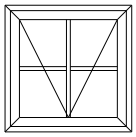
TOP HUNG



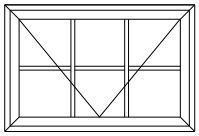
P
2 x 1 PANE
SINGLE TOP HUNG



R
3 x 1 PANE
SINGLE TOP HUNG

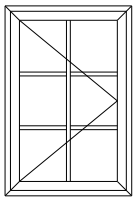


Q
2 x 2 PANE
SINGLE TOP HUNG

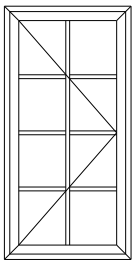


S
3 x 2 PANE
SINGLE TOP HUNG

SIDE HUNG



P
2 x 3 PANE
SINGLE SIDE HUNG



Q
2 x 4 PANE
SINGLE SIDE HUNG

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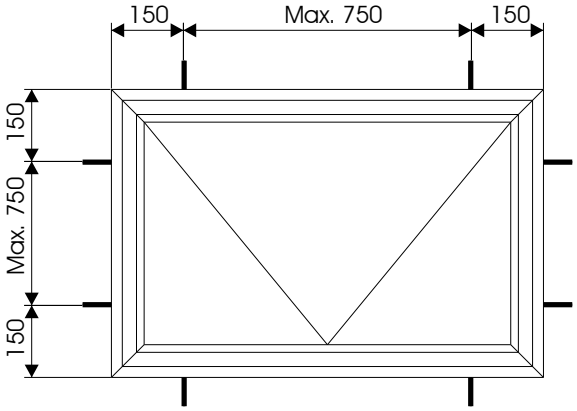
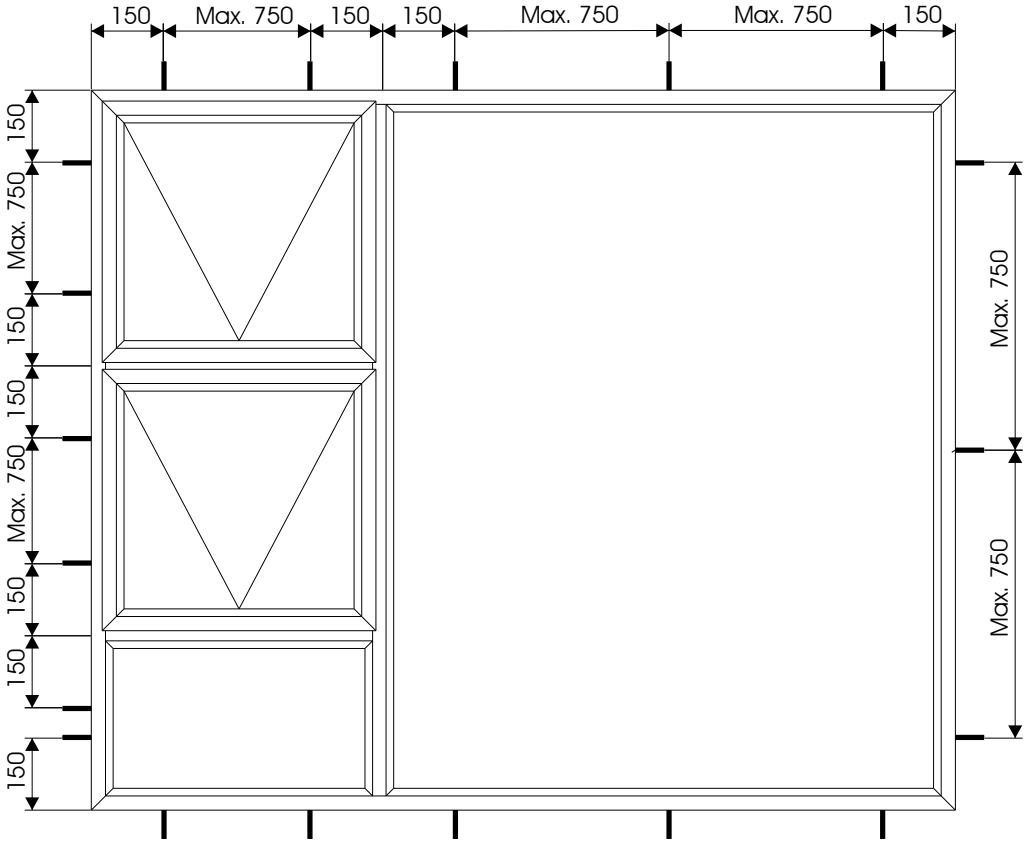
Typical Fastening Positions

IMPORTANT:
As there are many different methods of fixing the window to the structure, the illustration below is a general fixation detail. The illustration defines the general method and hole fixing. Before installation or machining of the holes, please ensure that you have checked the required fixing method with the appropriated building engineer and that your chosen methods meets their specifications

Failure to fix the window to correct building or engineer specifications will result in the door not meeting the required specifications.

DISCLAIMER: Please note that fixation of the frame to the structure is an element which MUST be specified and certified by an appropriate engineer and is not the responsibility of Wispeco.





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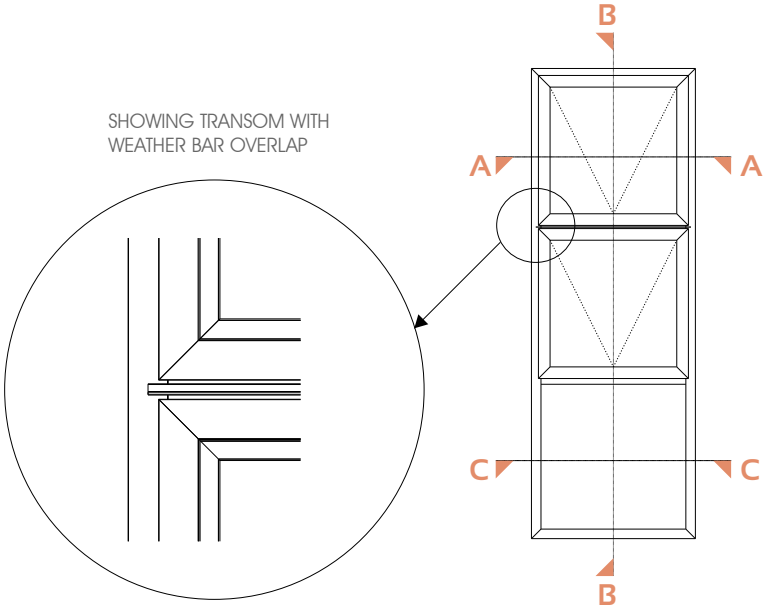
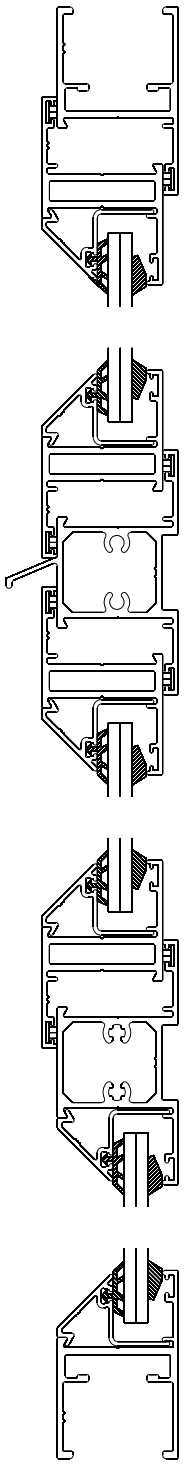
Typical Cross-sectional Details

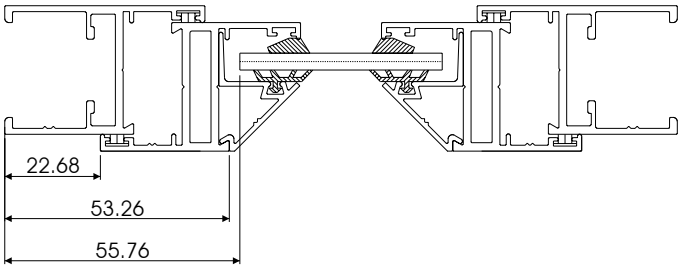
Double Top Hung Over Fixed



SECTION B-B
Section not to scale



SECTION A - A
Section not to scale



SECTION C-C
Section not to scale

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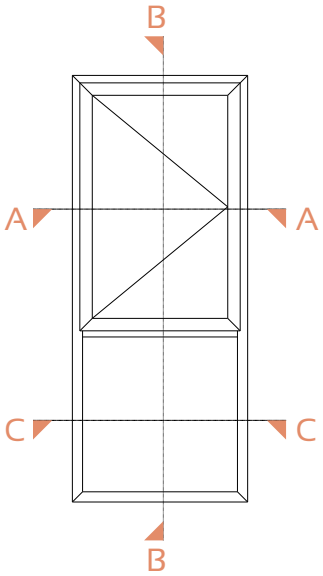
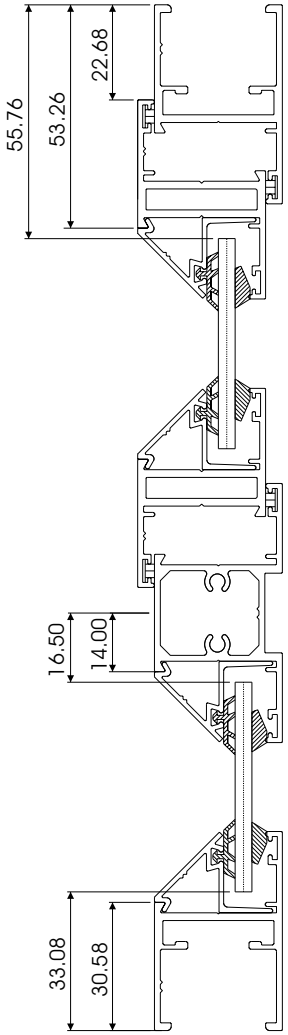
Typical Cross-sectional Details

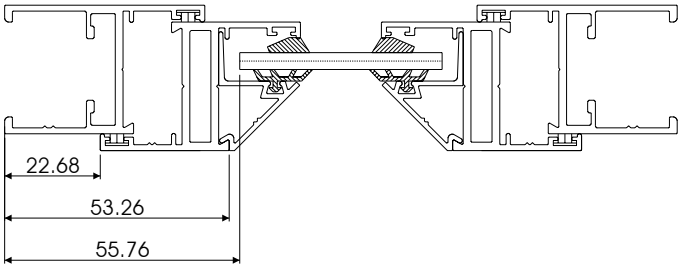
Side Hung Over Fixed



SECTION B-B
Section not to scale



SECTION A - A
Section not to scale



SECTION C-C
Section not to scale

crealco

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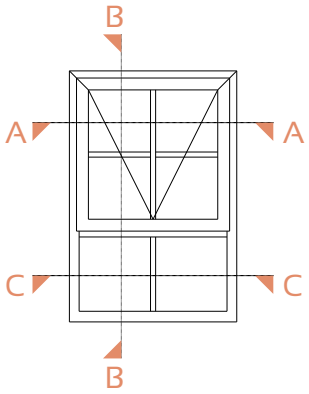
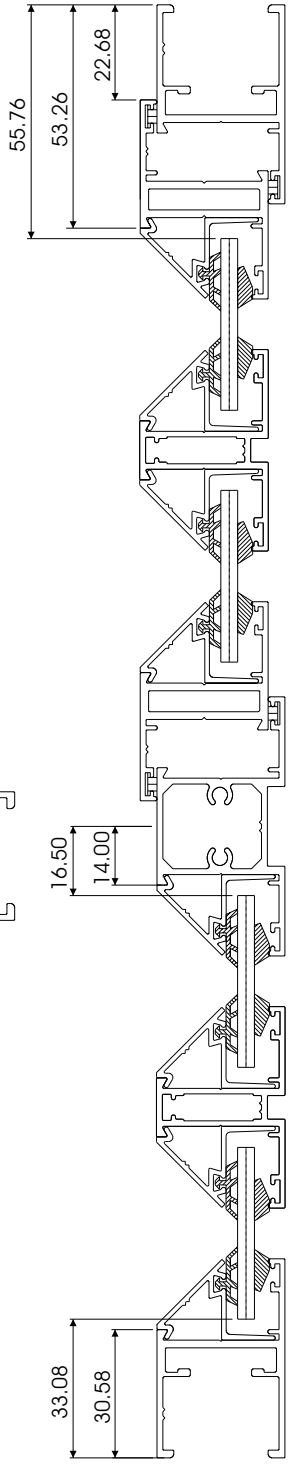
Typical Cross-sectional Details

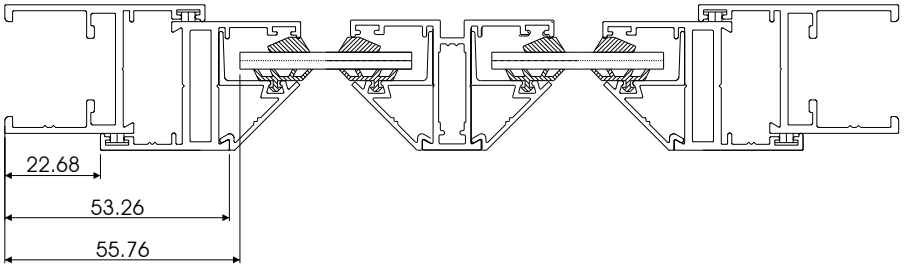
Cottage Pane 2x2 Top Hung Over 2x1 Fixed Panel



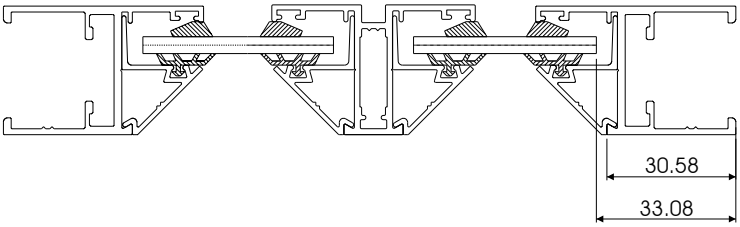
SECTION B-B
Section not to scale



SECTION A - A
Section not to scale



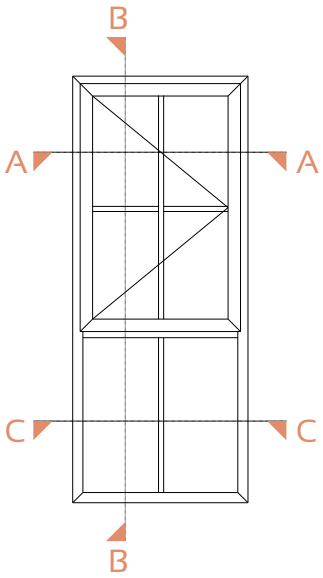
SECTION C-C
Section not to scale



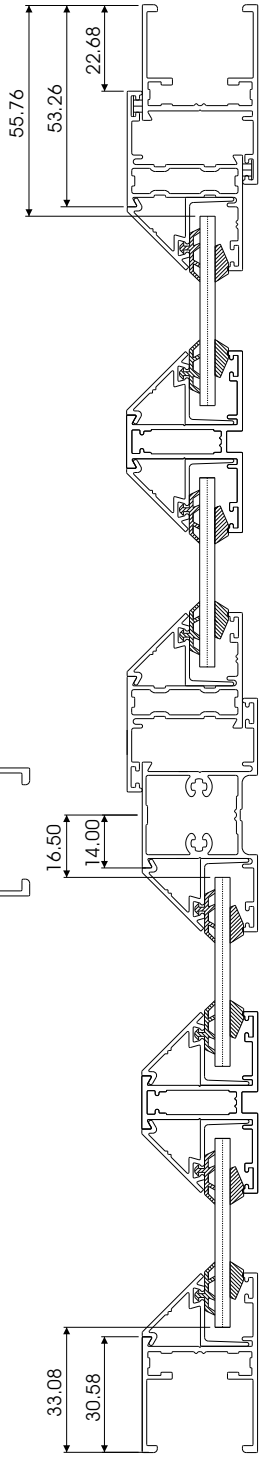
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cross-sectional Details

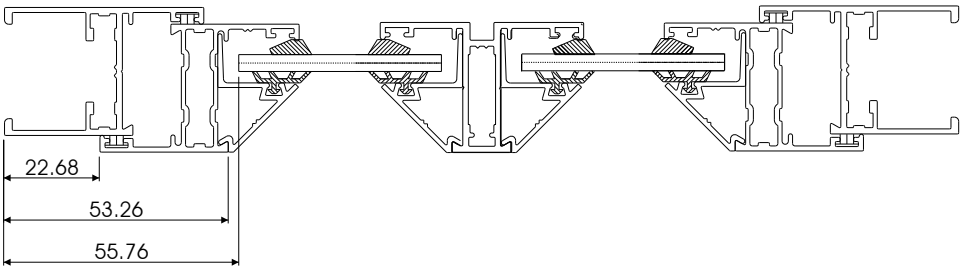
Cottage Pane Side Hung Over Fixed Panel



SECTION B-B
Section not to scale



SECTION A - A
Section not to scale



SECTION C-C
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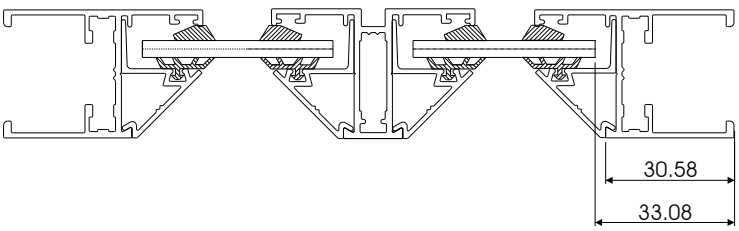

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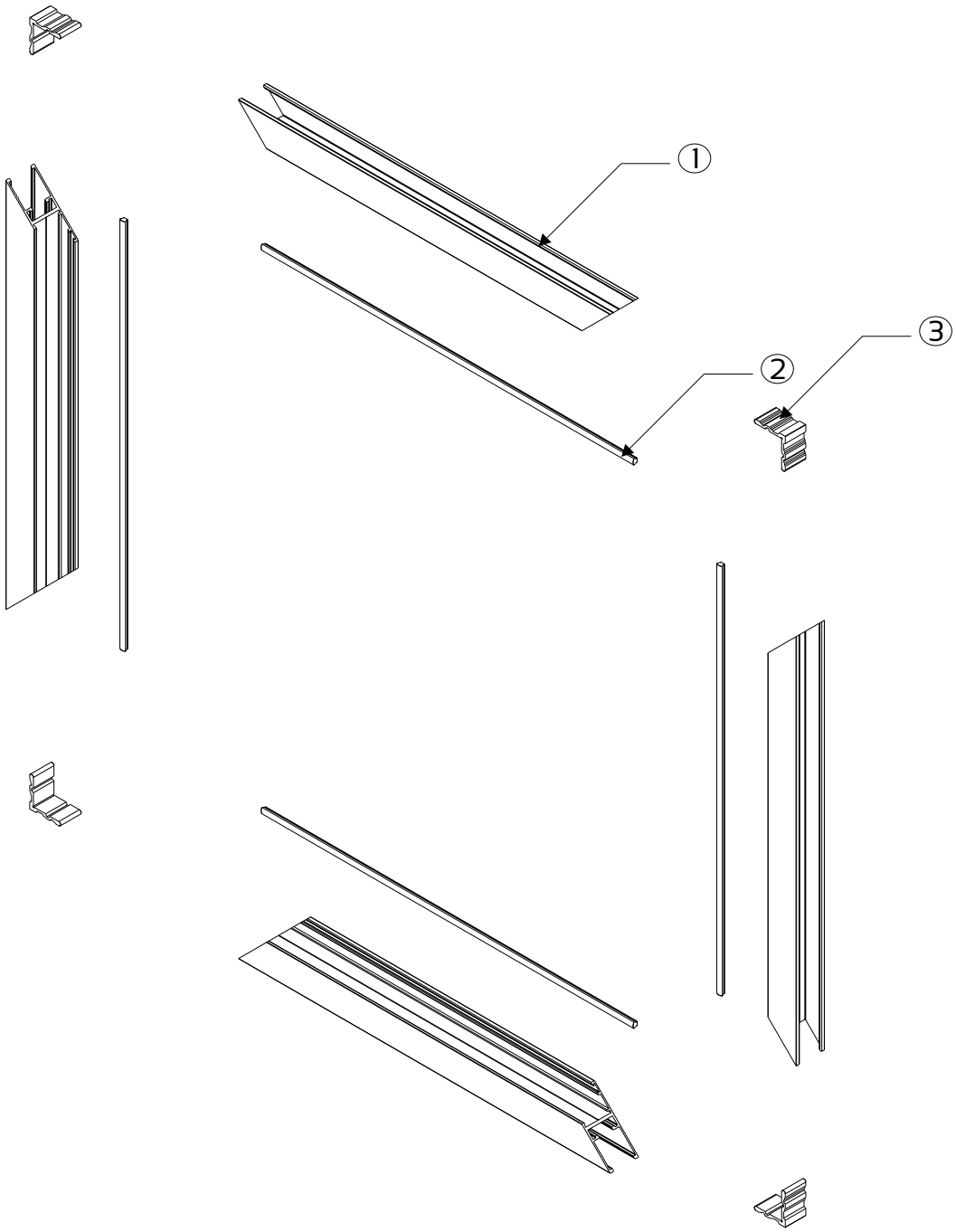
Typical Outer Frame Construction



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W32028	Frame 30mm Equal Leg Standard

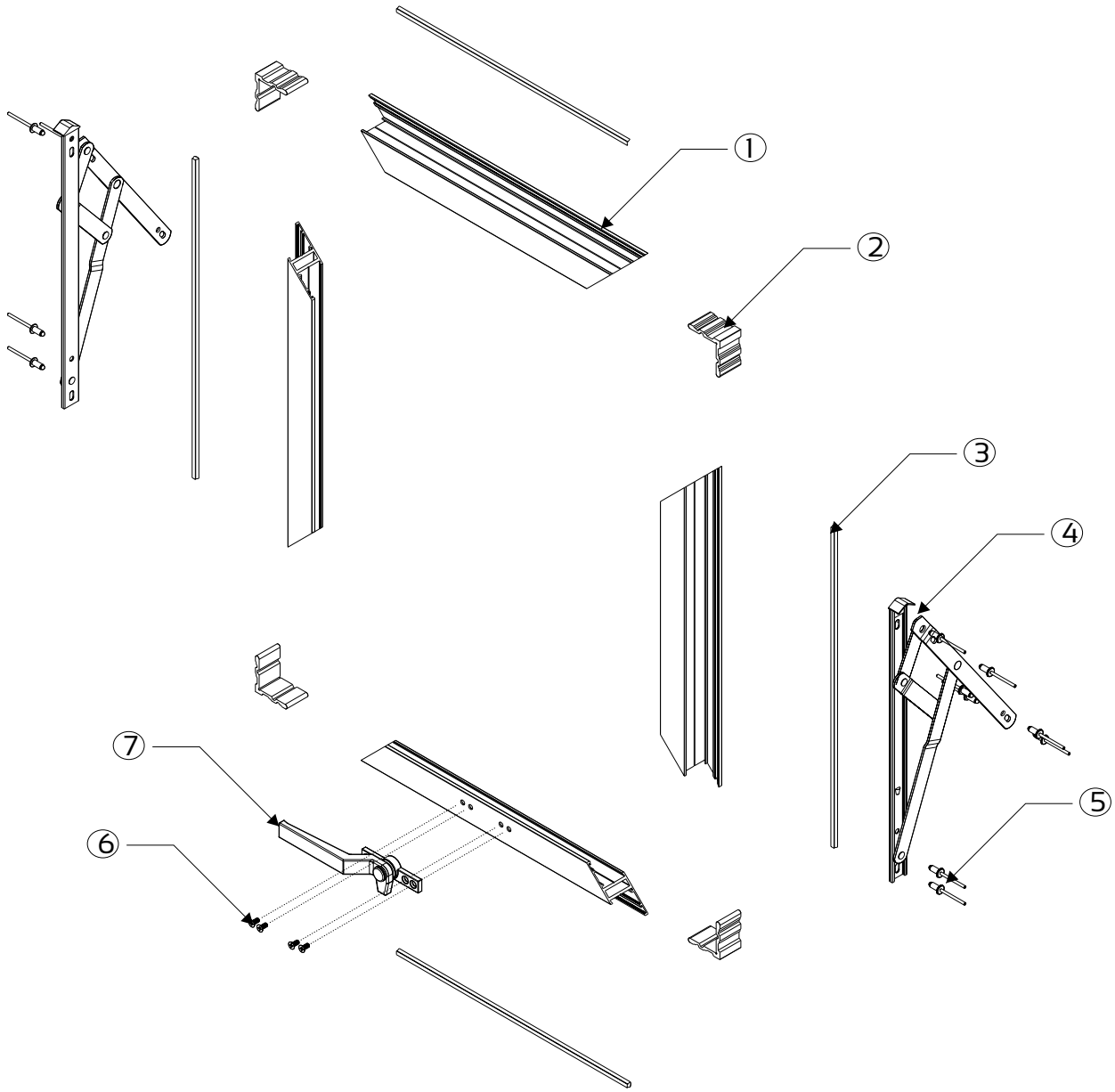
Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Finpile	Finpile
3	4	Corner Cleat	Swift 30.5 Corner Cleat 40mm

crealco

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.

Typical Sash Frame Construction



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W55684	Sash Tubular Standard

Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Corner Cleat	Swift 30.5 Corner Cleat 40mm
3	4	Finpile	Finpile
4	2	Friction Stay	Friction Stay
5	12	Pop Rivet	C/Sunk/Dome Rivet
6	4	Screw	Handle Screw Blunt Point
7	1	Handle	Euroline PT Handle

crealco

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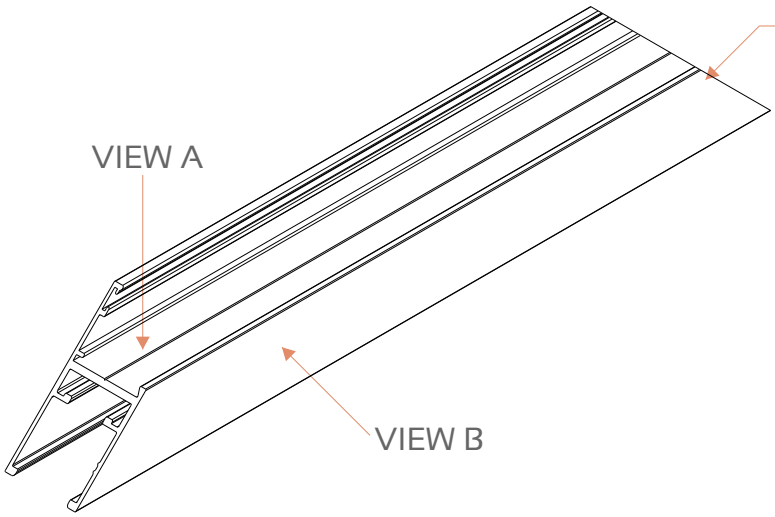
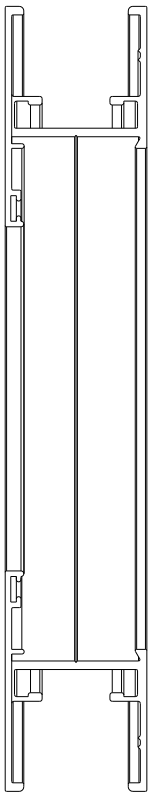
Typical Outer Frame Machining Details

Equal Leg

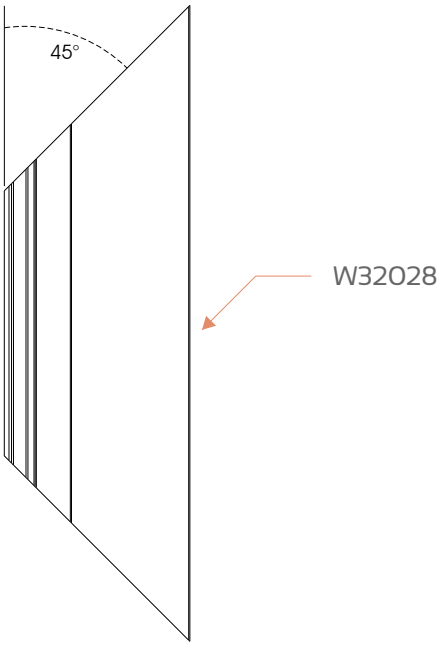
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

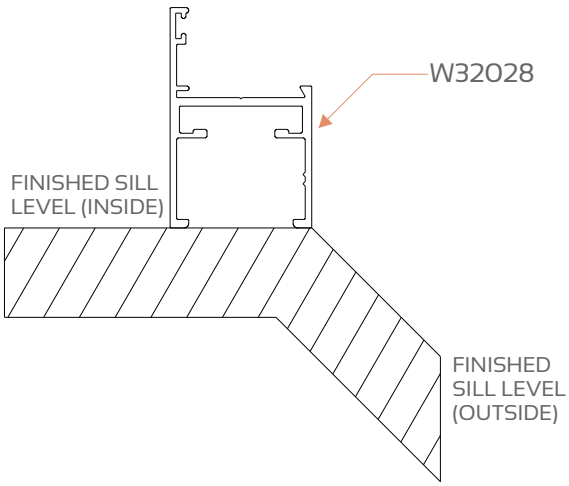


VIEW A-A
Section not to scale



VIEW B-B
Section not to scale





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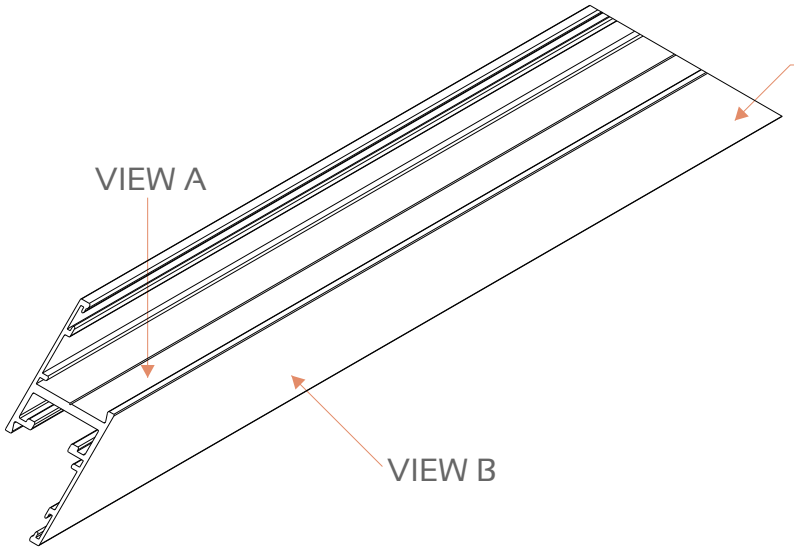
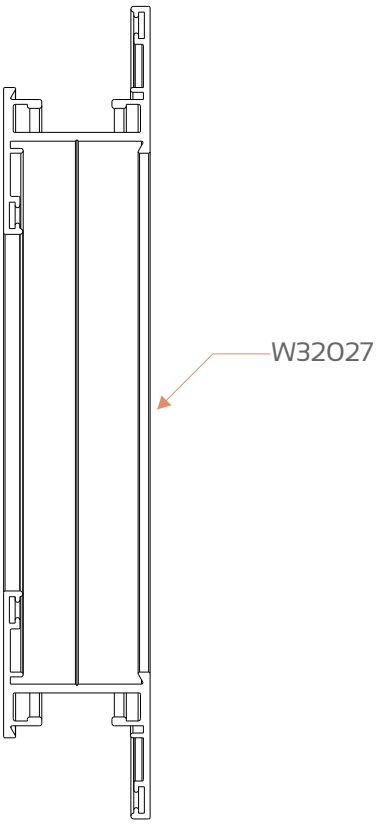
Typical Outer Frame Machining Details

Unequal Leg

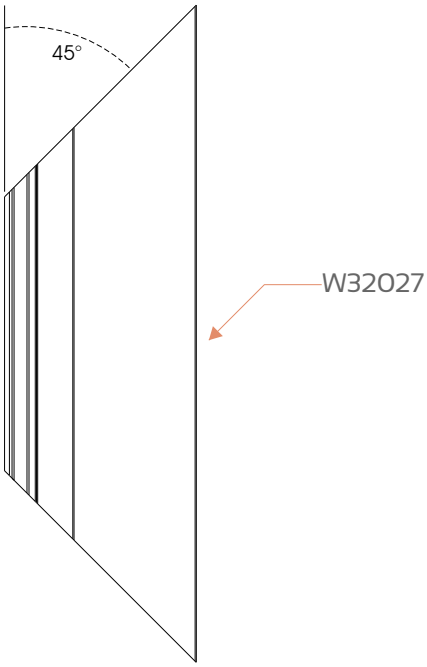
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

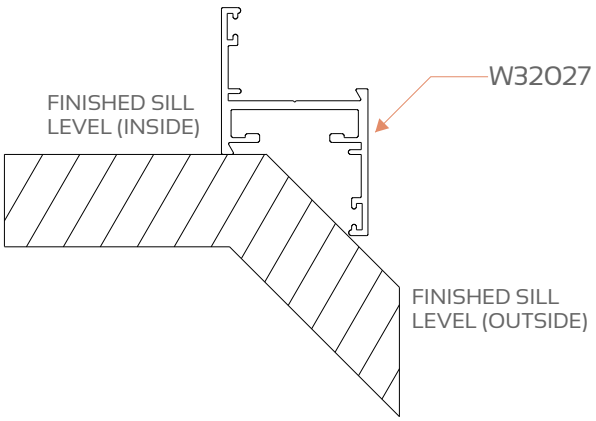


VIEW A-A
Section not to scale



VIEW B-B
Section not to scale





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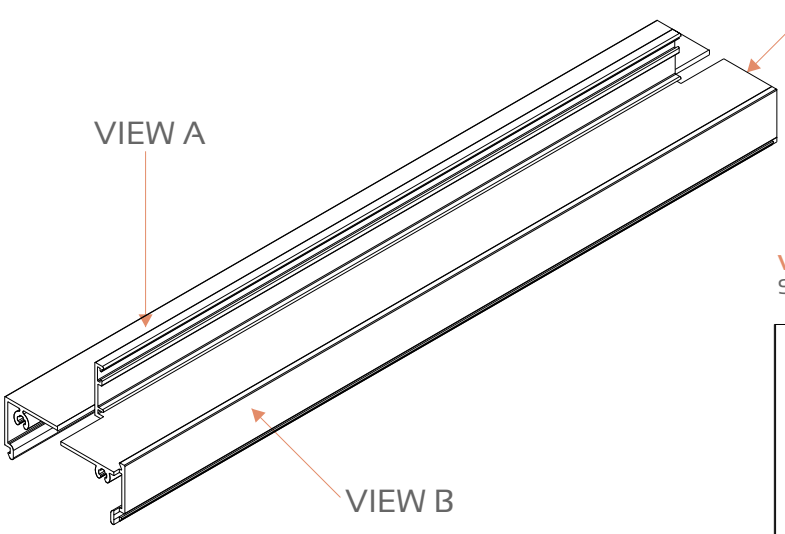
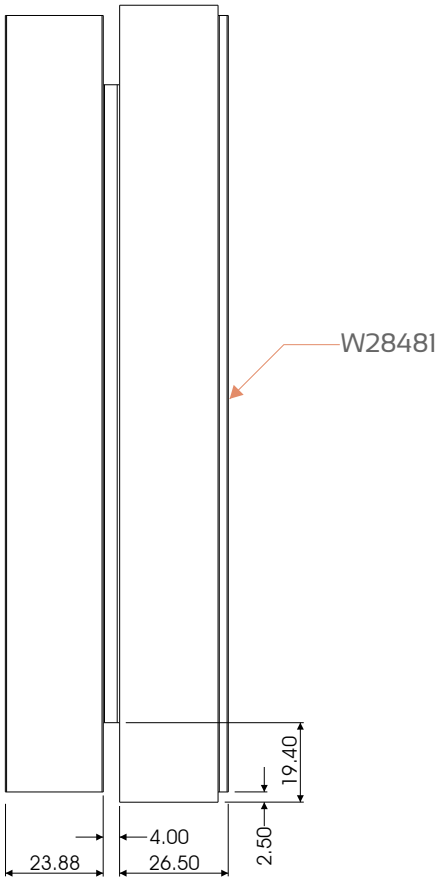
Typical Outer Frame Machining Details

54mm

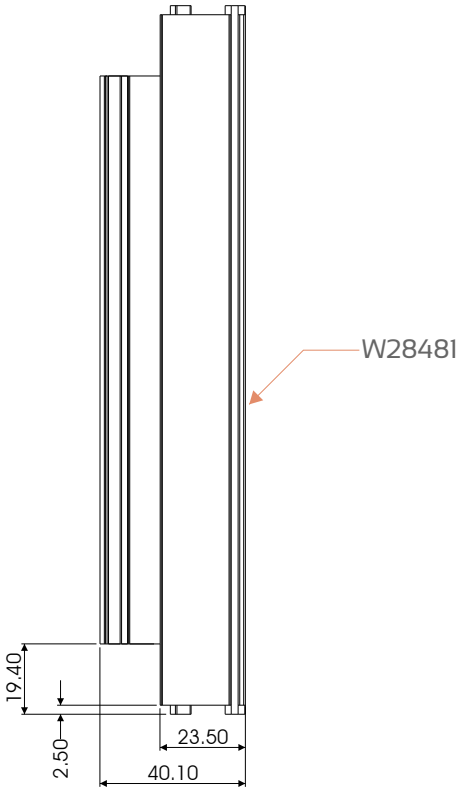
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

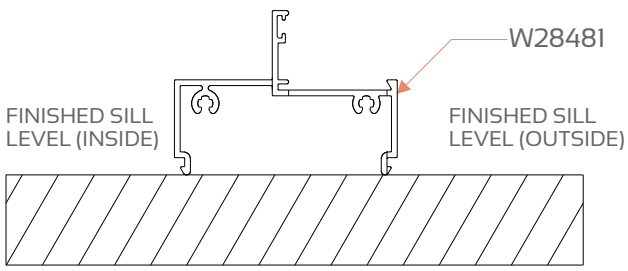


VIEW A-A
Section not to scale



VIEW B-B
Section not to scale





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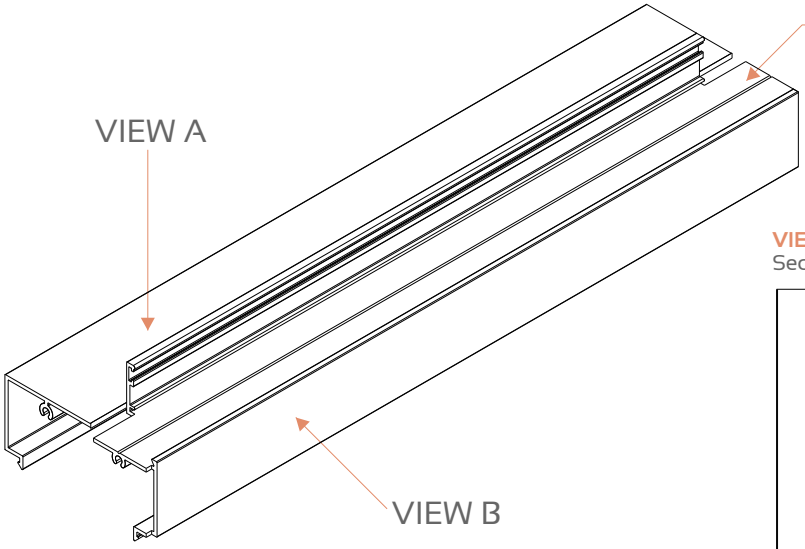
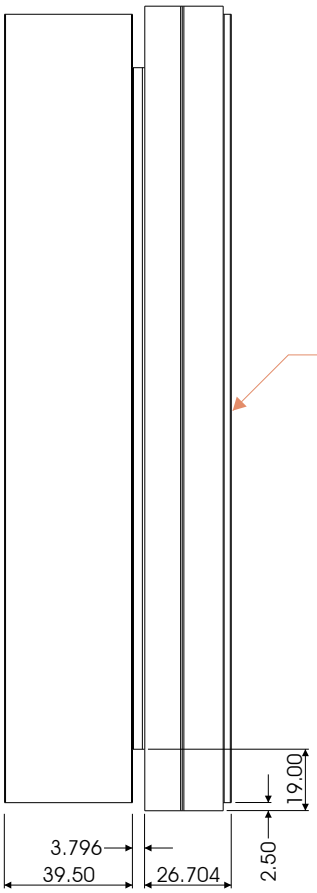
Typical Outer Frame Machining Details

70mm

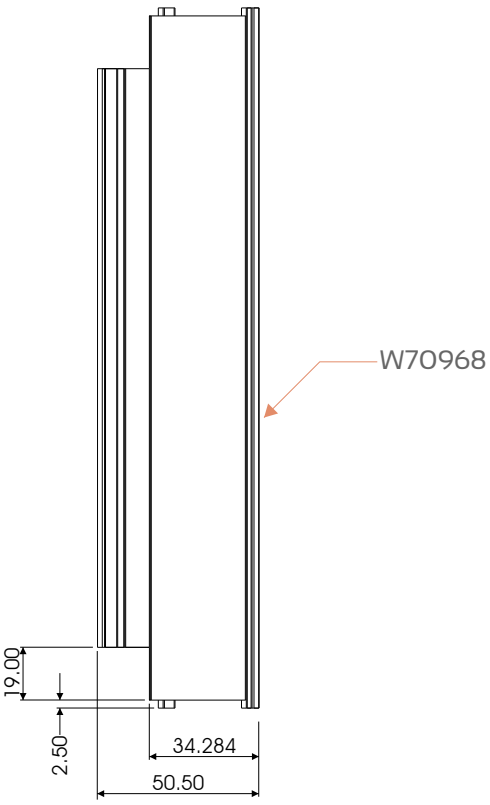
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

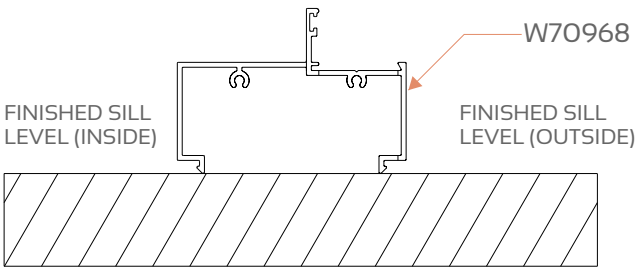


VIEW A-A
Section not to scale



VIEW B-B
Section not to scale





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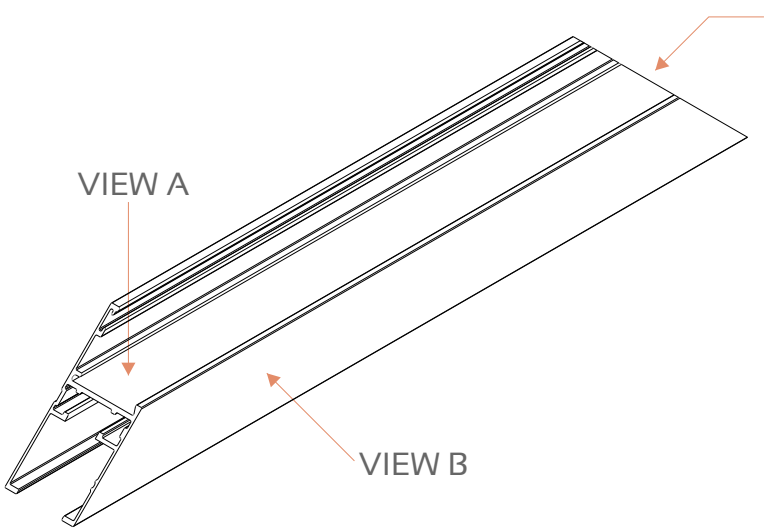
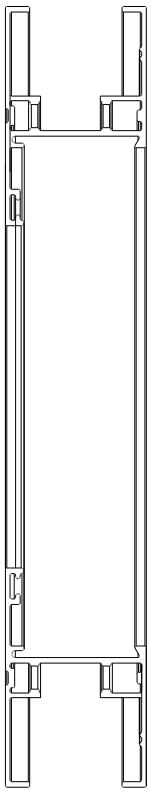
Typical Outer Frame Machining Details

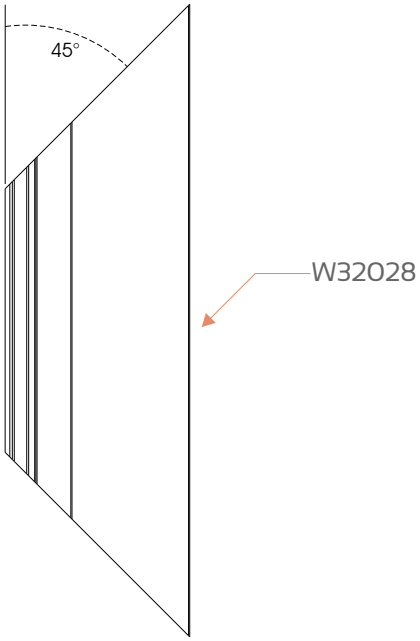
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

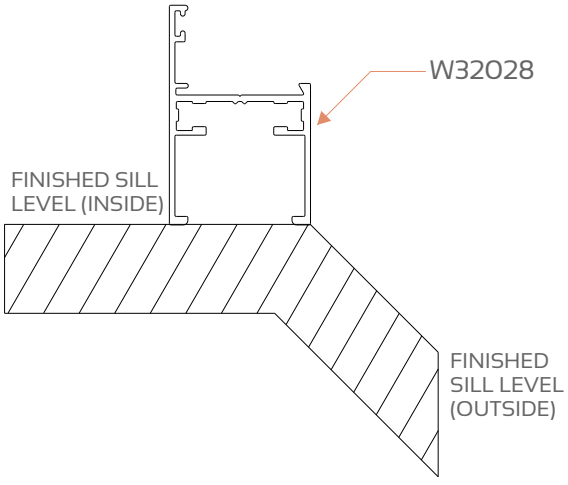


VIEW A-A
Section not to scale



VIEW B-B
Section not to scale

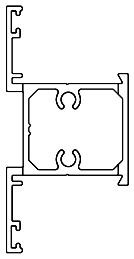




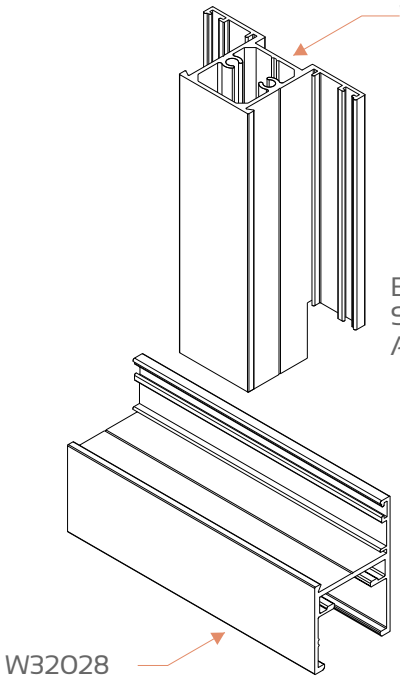
Typical Mullion Machining Details

Standard Machining Detail for End Milling on Equal Leg Outer Frame

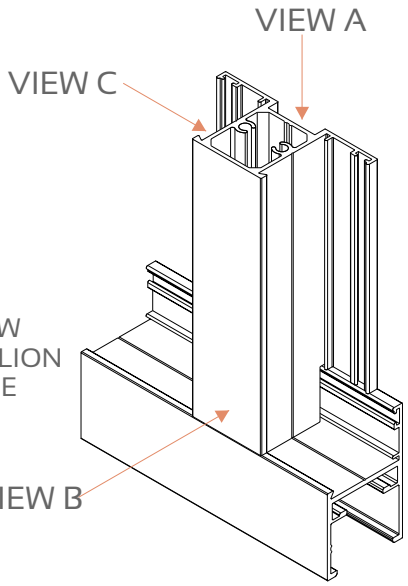
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



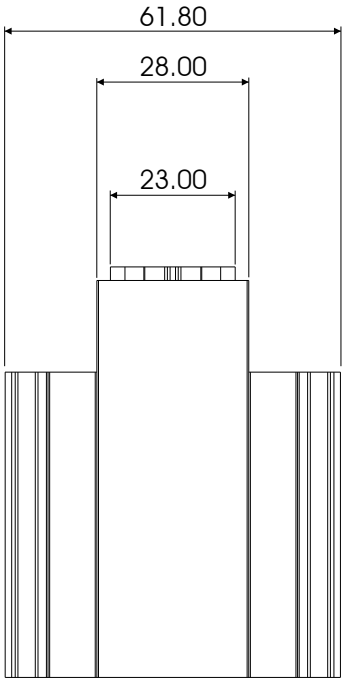
VIEW A-A
Standard Mullion
W53629



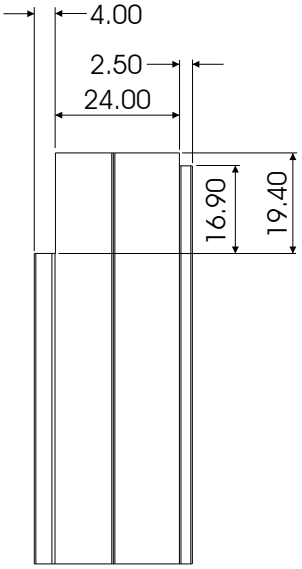
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

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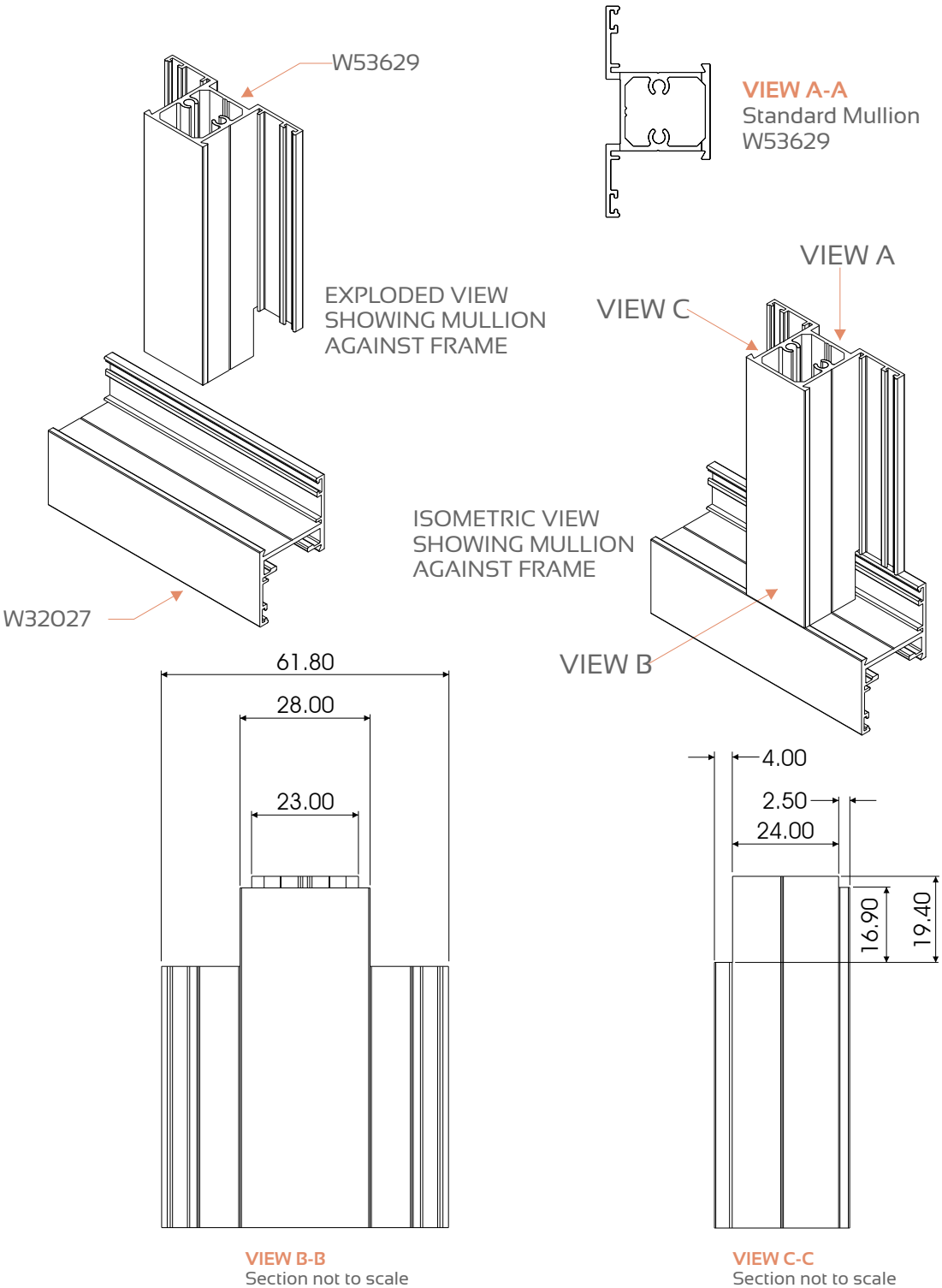
Typical Mullion Machining Details

Standard Machining Detail for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



VIEW B-B
Section not to scale

VIEW C-C
Section not to scale

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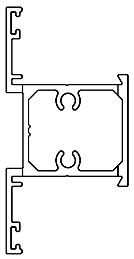
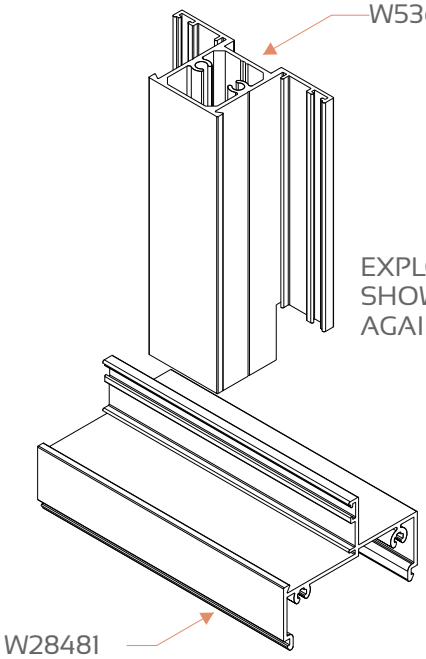
Typical Mullion Machining Details

Standard Machining Detail for End Milling on 54mm Outer Frame

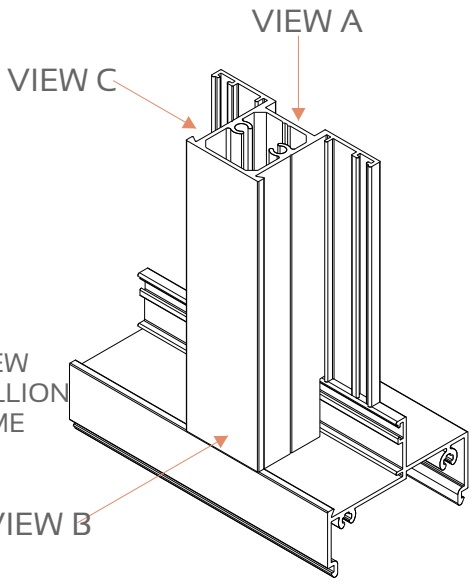
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



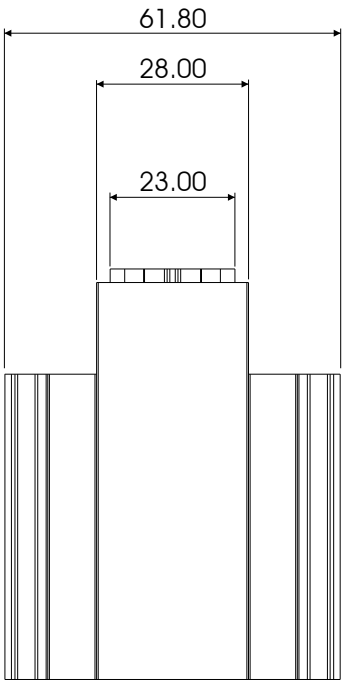
VIEW A-A
Standard Mullion
W53629



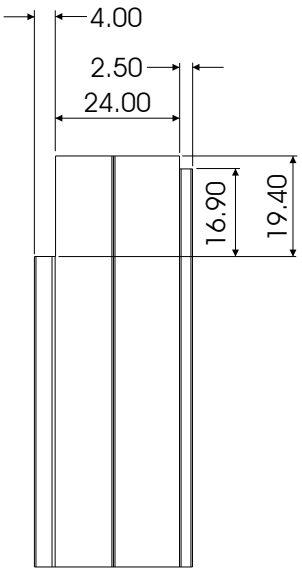
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

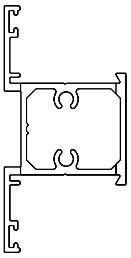
crealco

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.

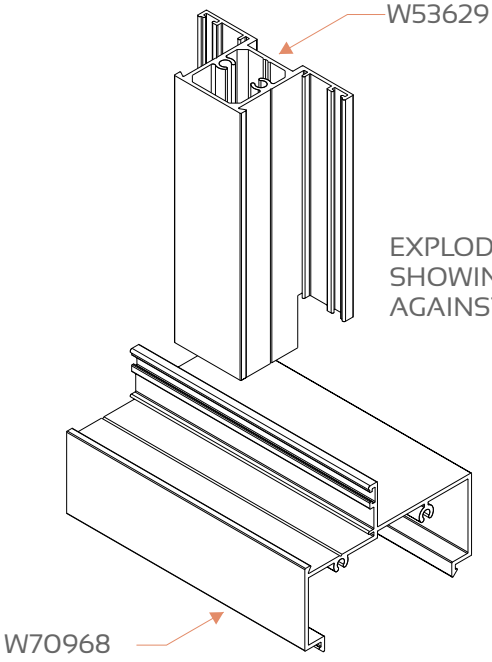
Typical Mullion Machining Details

Standard Machining Detail for End Milling on 70mm Outer Frame

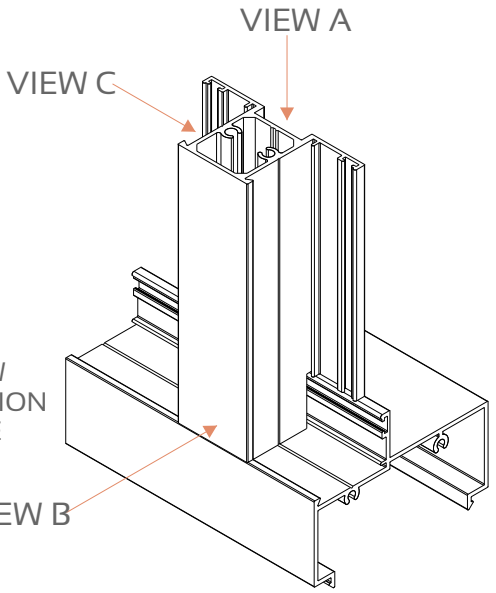
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



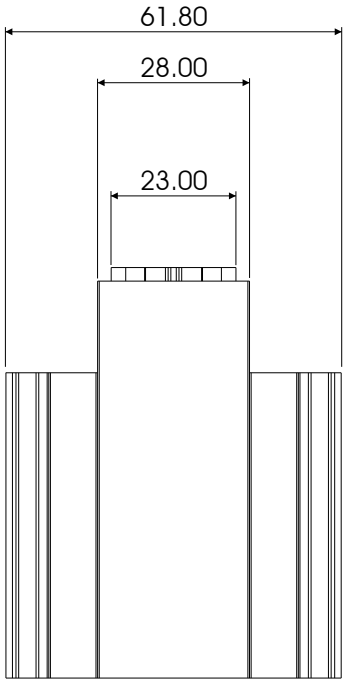
VIEW A-A
Standard Mullion
W53629



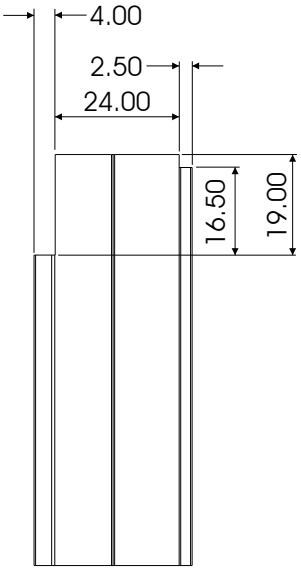
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



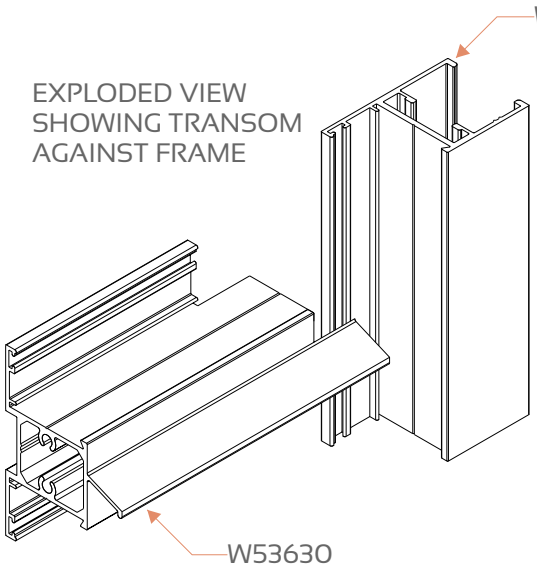
VIEW C-C
Section not to scale

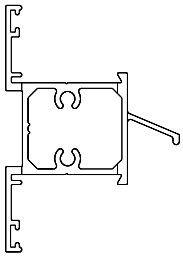
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Transom with W/Bar Machining Detail

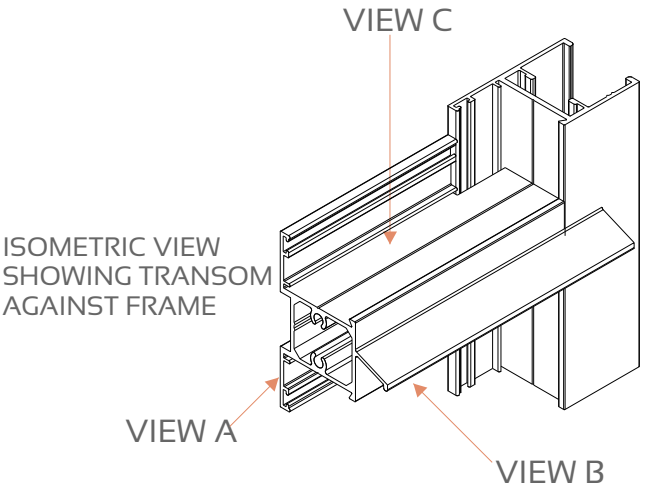
for End Milling on Equal Leg Outer Frame

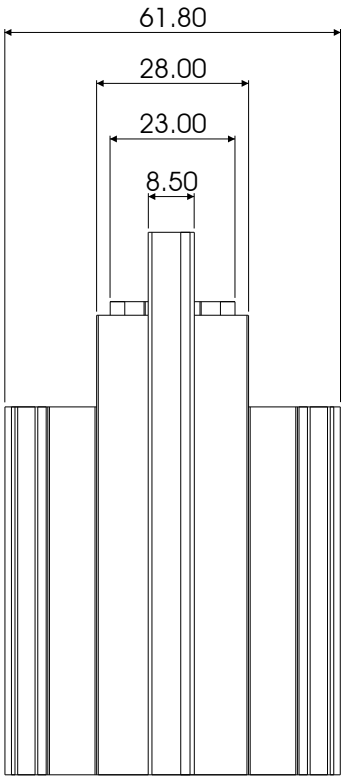
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



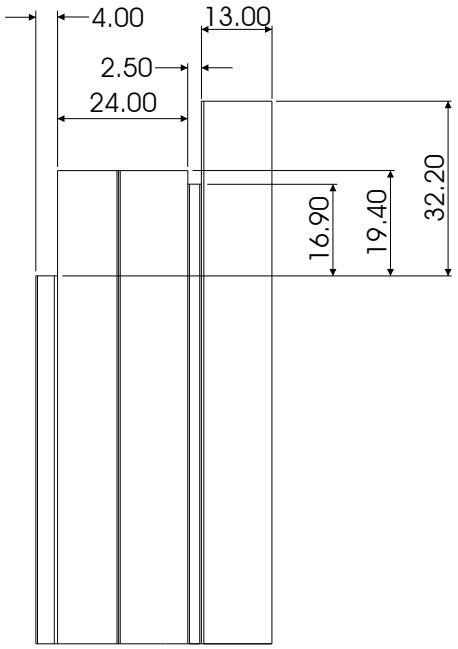


VIEW A-A
Standard Transom
with W/Bar
W53630





VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

crealco

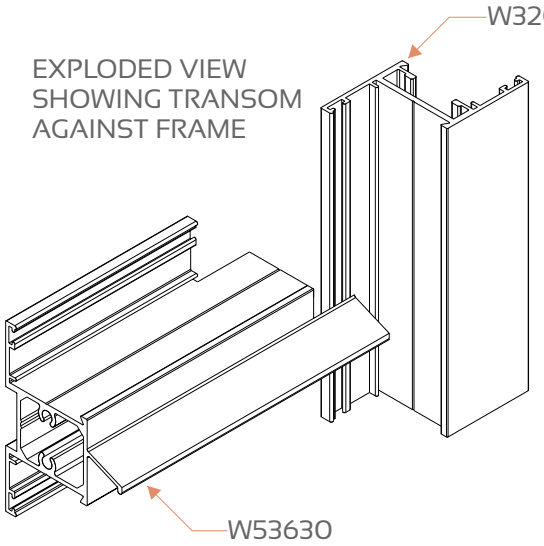
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

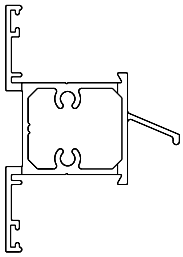
Typical Transom with W/Bar Machining Detail

for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

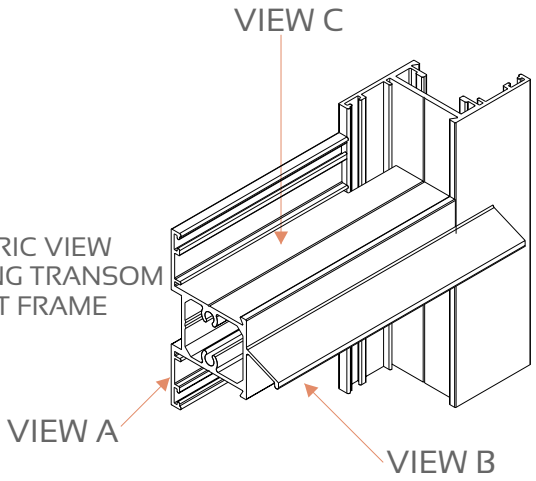
EXPLODED VIEW SHOWING TRANSOM AGAINST FRAME

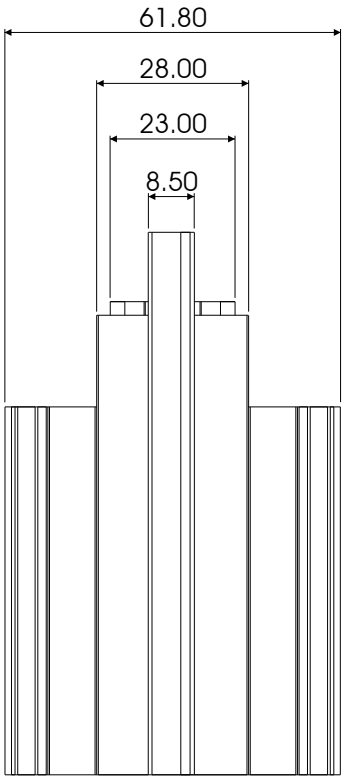




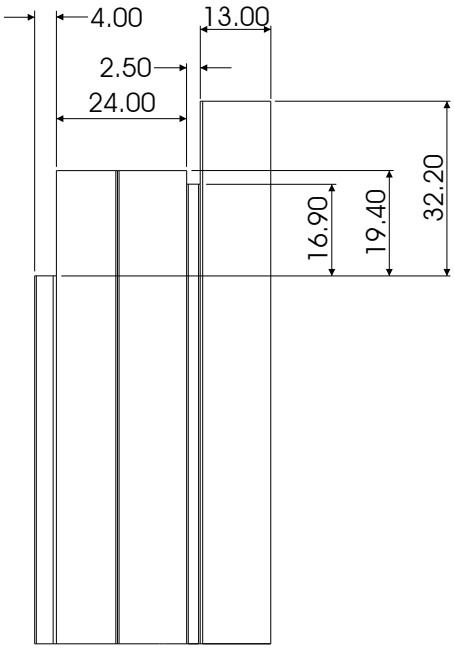
VIEW A-A
Standard Transom with W/Bar W53630

ISOMETRIC VIEW SHOWING TRANSOM AGAINST FRAME





VIEW B-B
Section not to scale



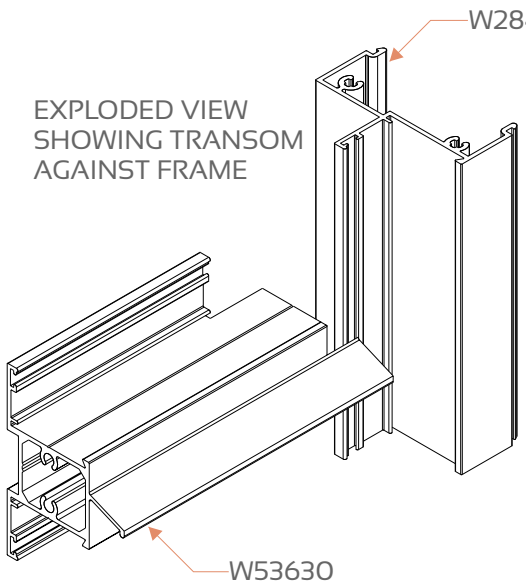
VIEW C-C
Section not to scale

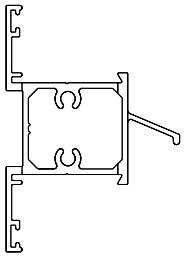
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Transom with W/Bar Machining Detail

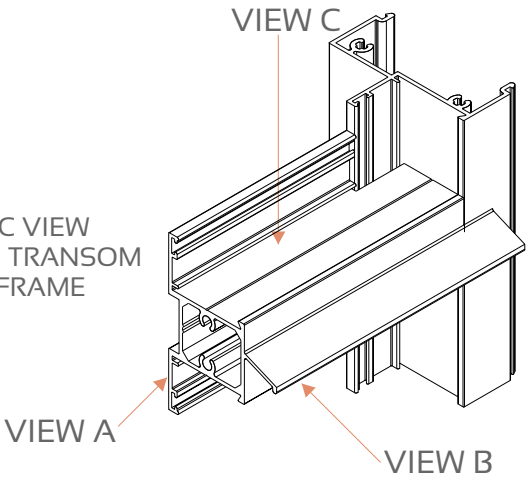
for End Milling on 54mm Outer Frame

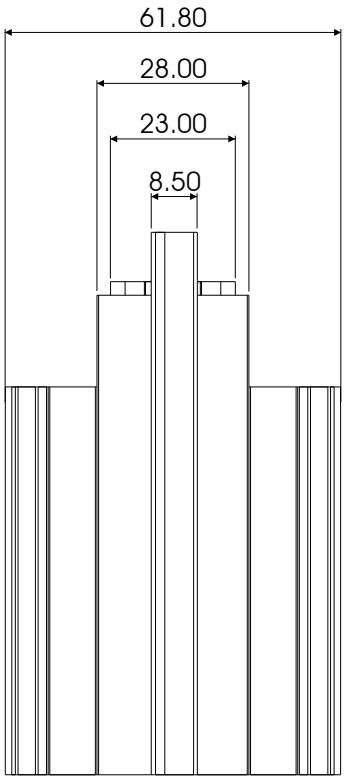
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



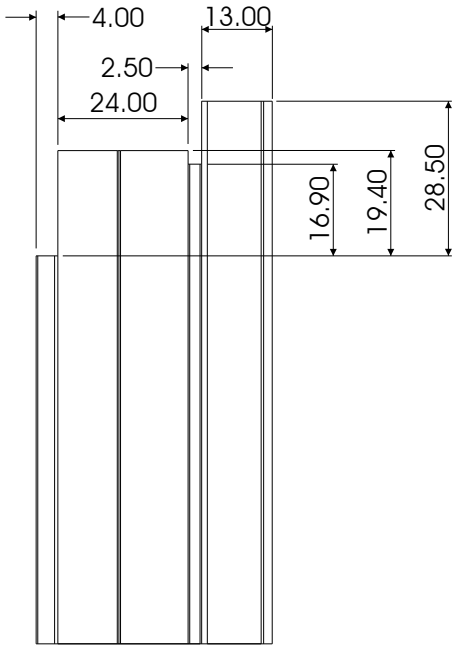


VIEW A-A
Standard Transom
with W/Bar
W53630





VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

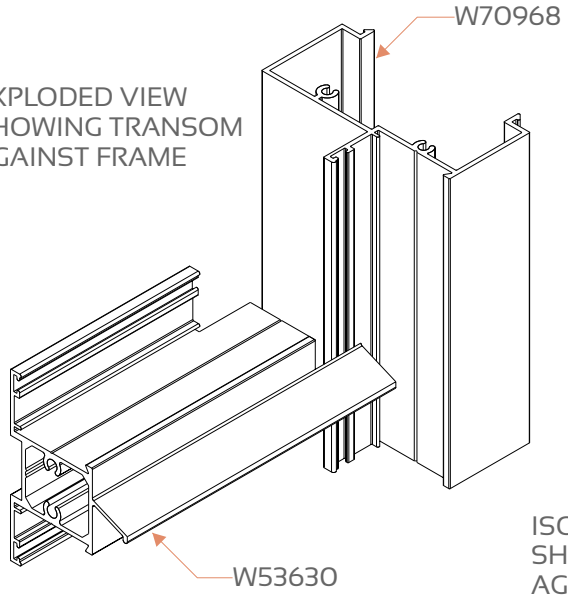
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

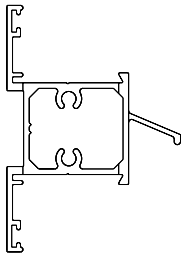
Typical Transom with W/Bar Machining Detail

for End Milling on 70mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

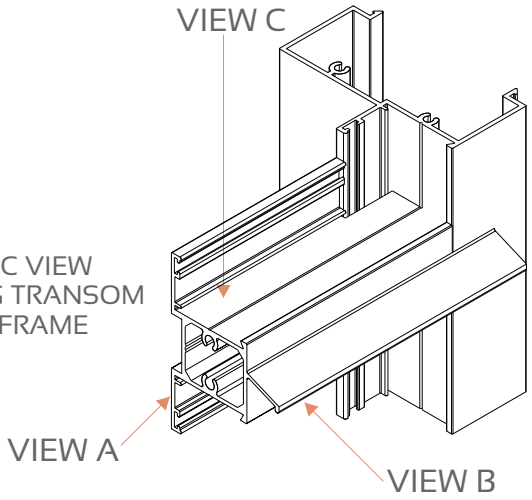
EXPLODED VIEW SHOWING TRANSOM AGAINST FRAME

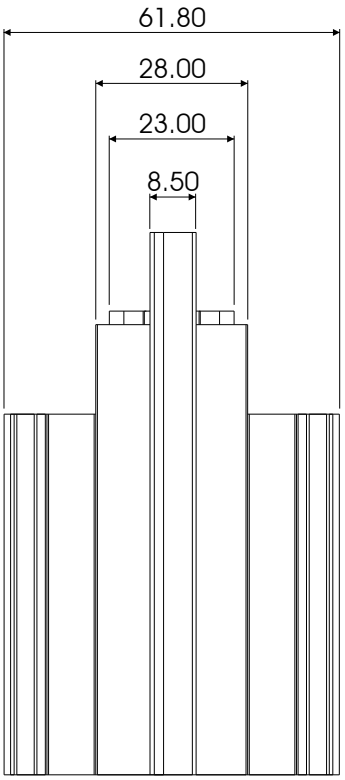




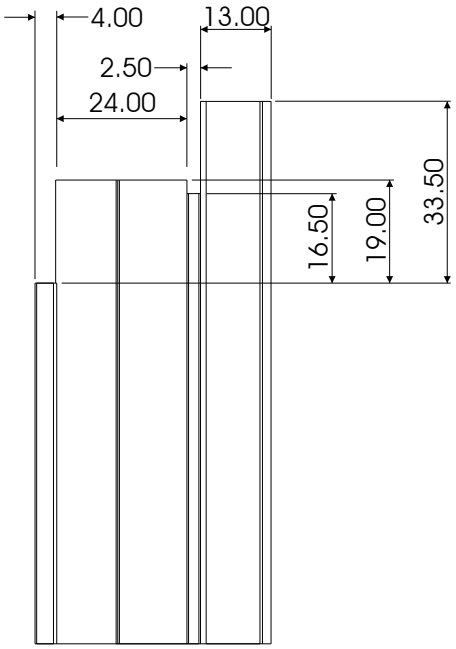
VIEW A-A
Standard Transom with W/Bar W53630

ISOMETRIC VIEW SHOWING TRANSOM AGAINST FRAME





VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

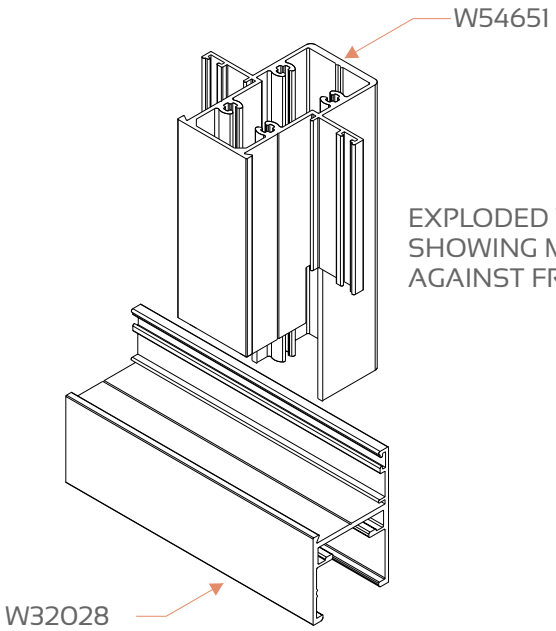
crealco

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.

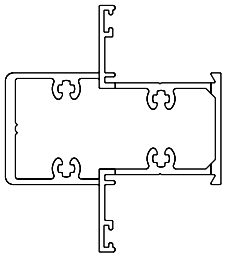
Typical 54mm Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

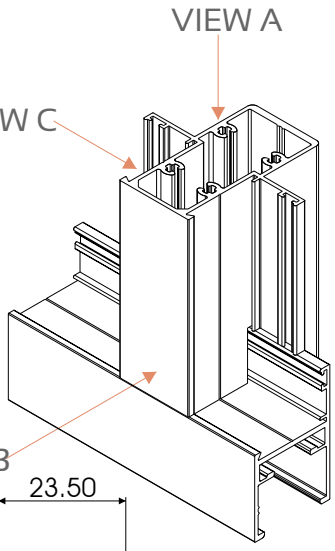
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



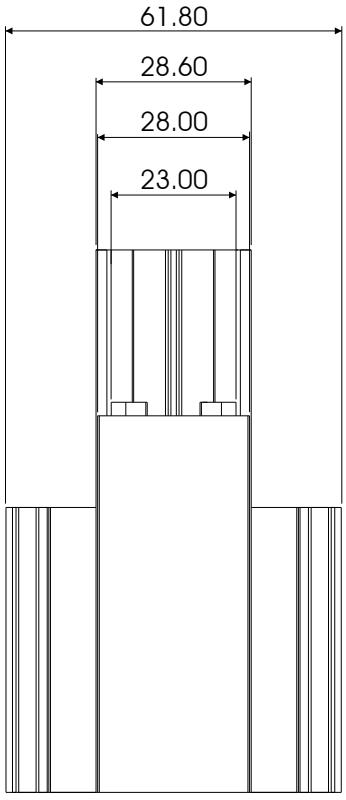
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



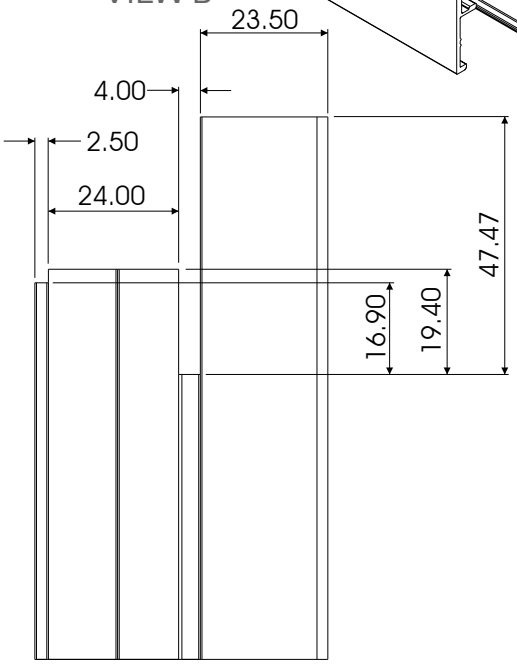
VIEW A-A
54mm Mullion
W54651



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



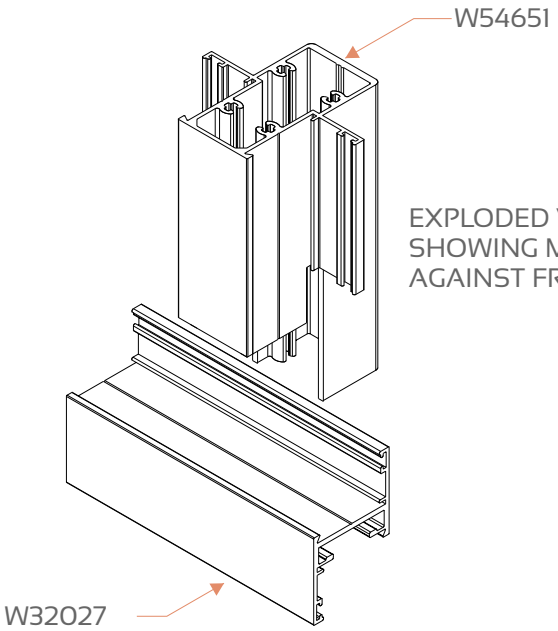
VIEW C-C
Section not to scale

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.

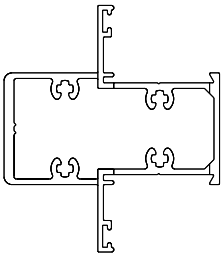
Typical 54mm Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

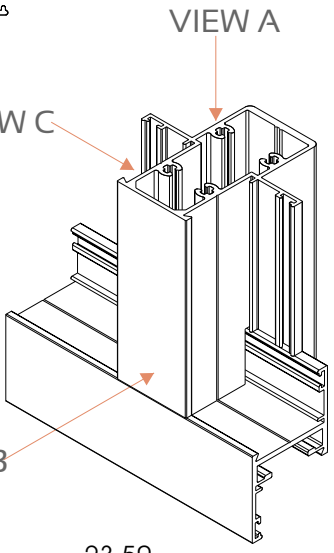
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



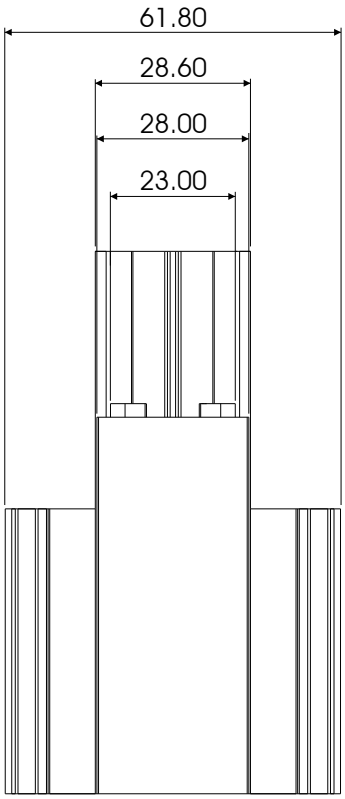
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



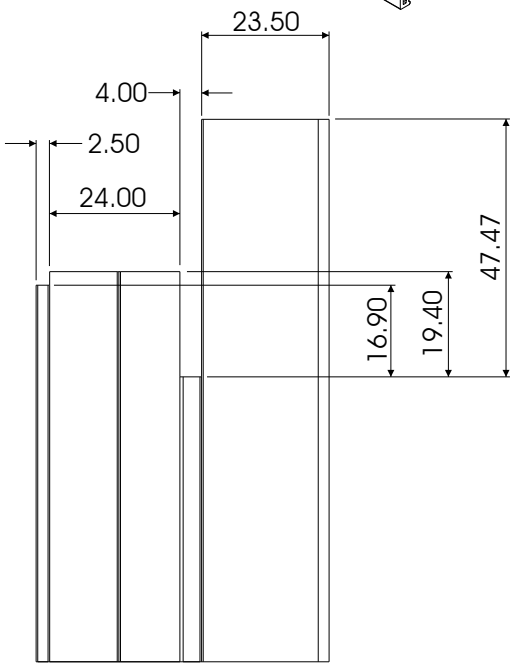
VIEW A-A
54mm Mullion
W54651



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



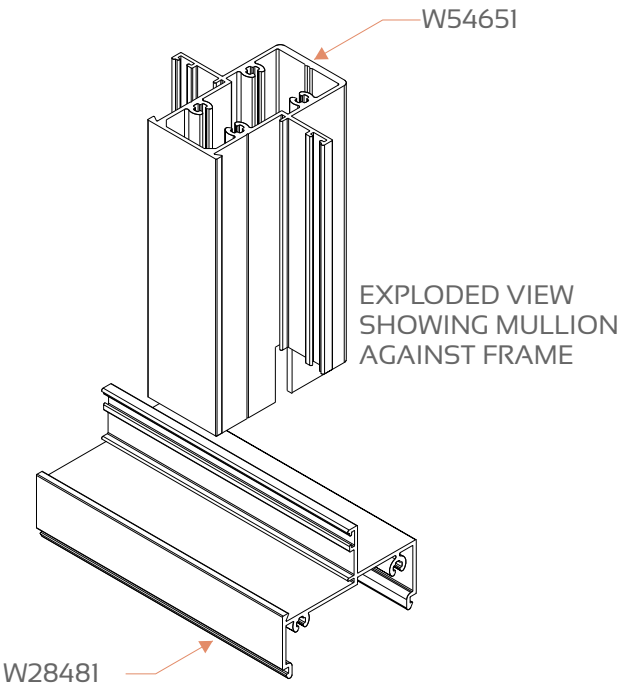
VIEW C-C
Section not to scale

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.

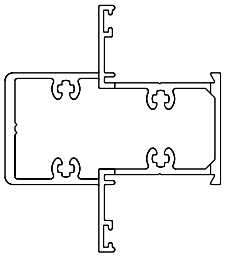
Typical 54mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

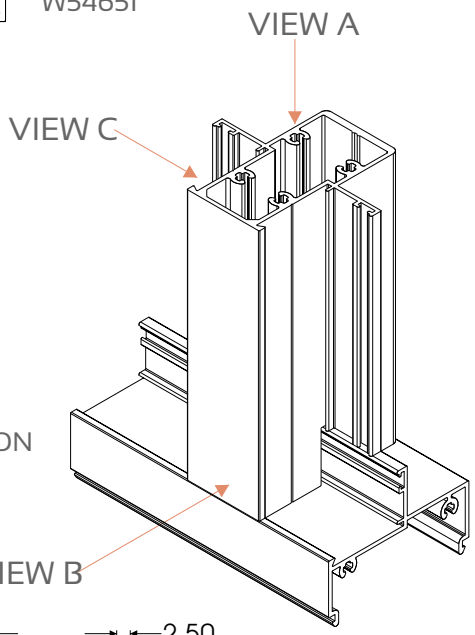
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



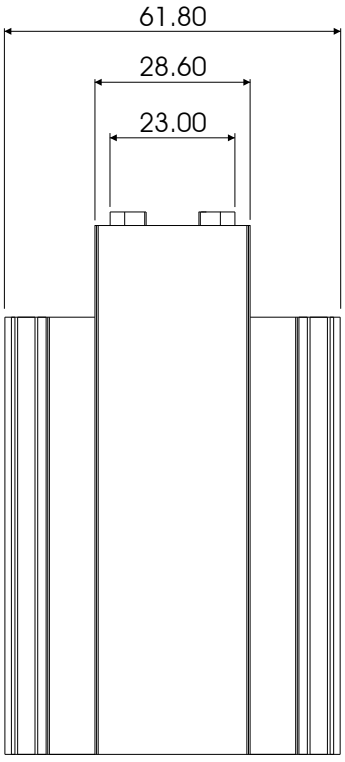
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



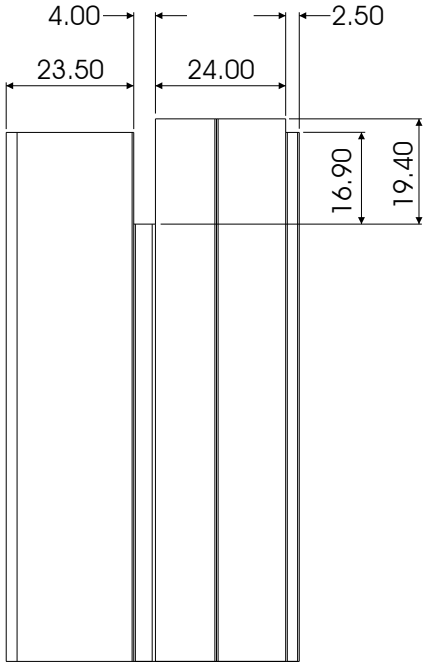
VIEW A-A
54mm Mullion
W54651



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



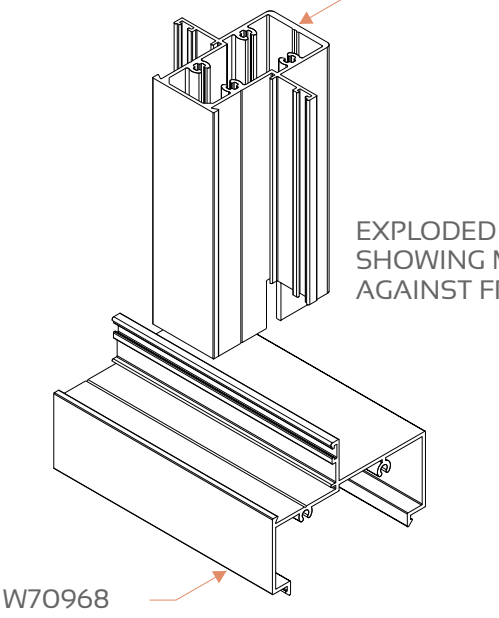
VIEW C-C
Section not to scale

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.

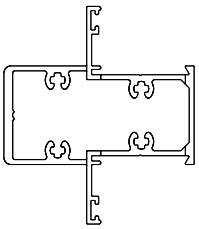
Typical 54mm Mullion Machining Detail

for End Milling on 70mm Outer Frame

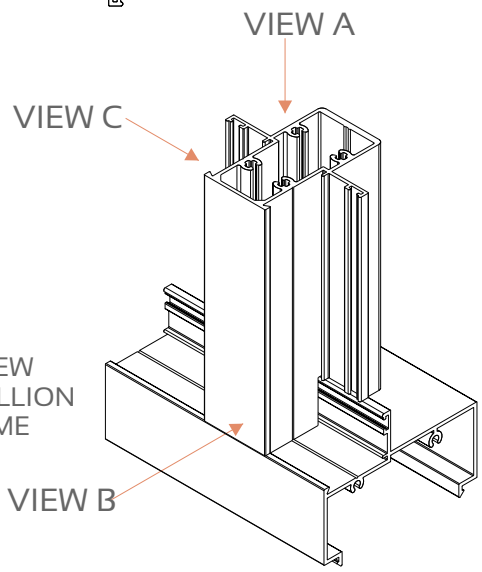
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



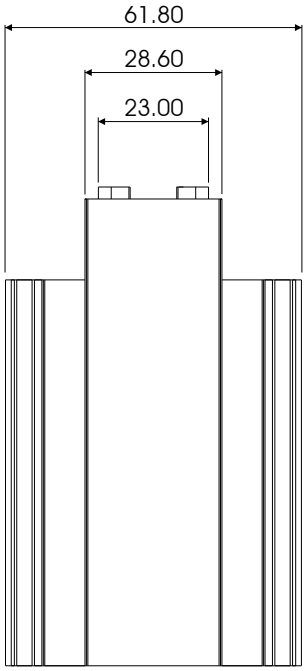
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



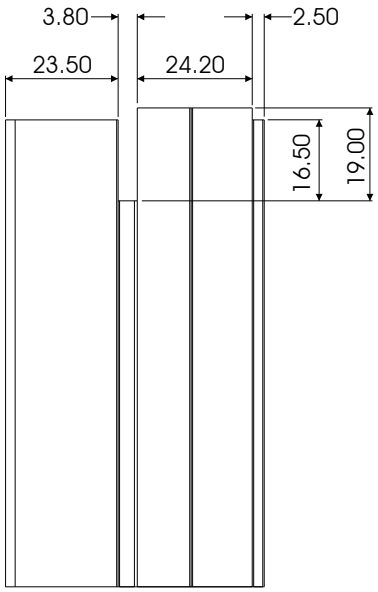
VIEW A-A
54mm Mullion
W54651



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



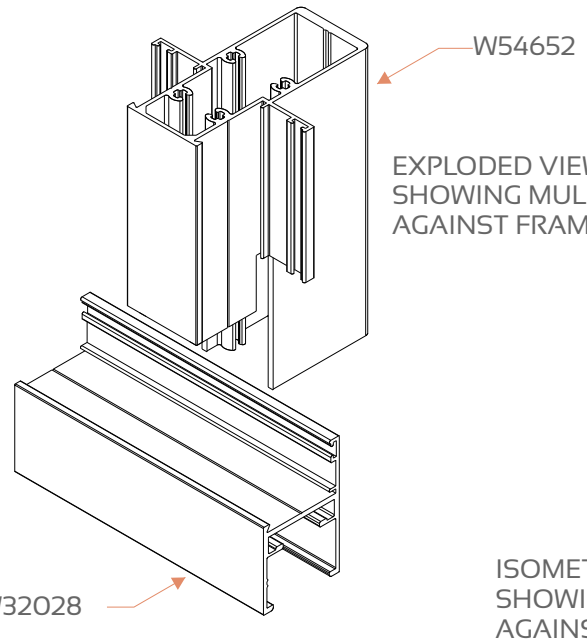
VIEW C-C
Section not to scale

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.

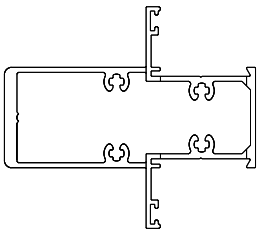
Typical 70mm Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

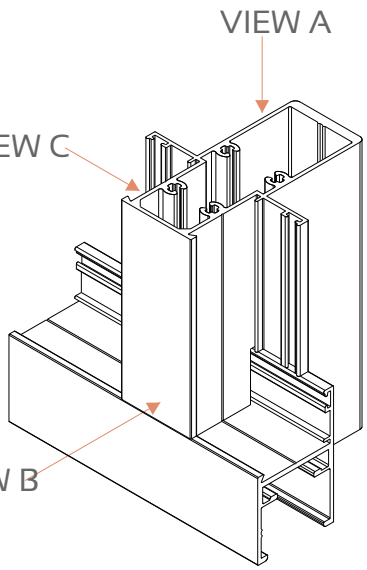
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



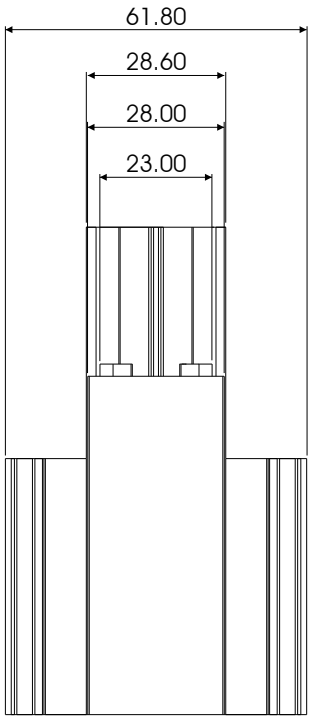
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



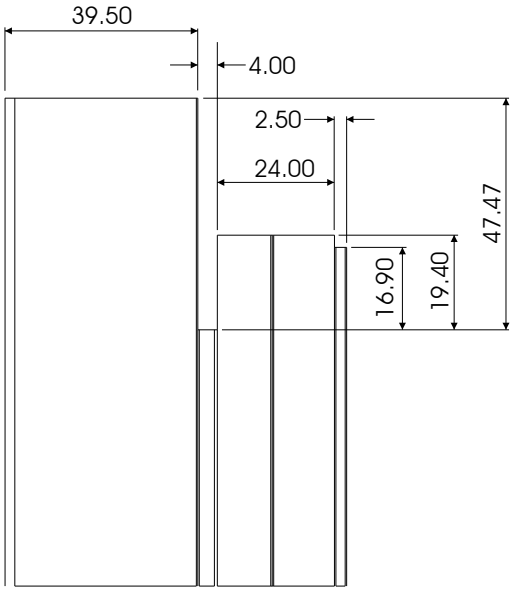
VIEW A-A
70mm Mullion
W54652



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



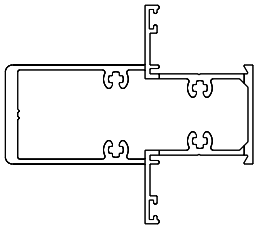
VIEW C-C
Section not to scale

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.

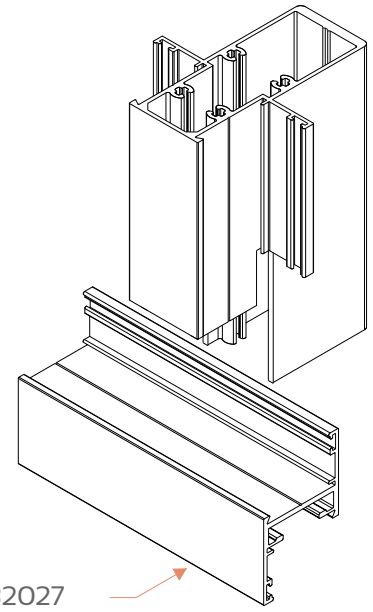
Typical 70mm Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

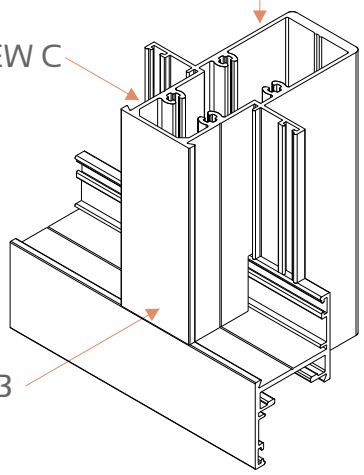
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



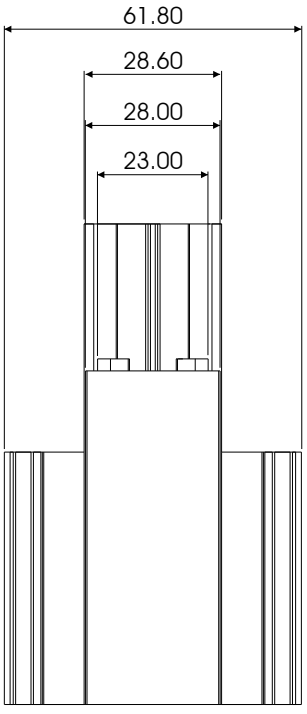
VIEW A-A
70mm Mullion
W54652



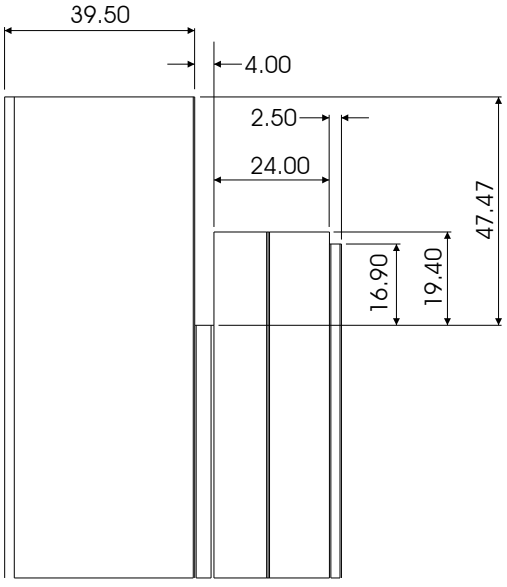
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



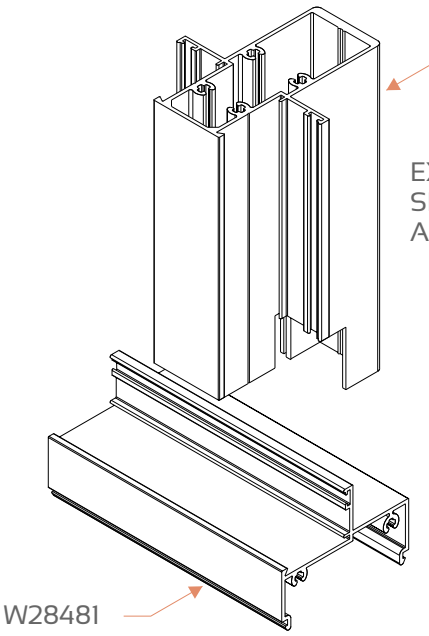
VIEW C-C
Section not to scale

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.

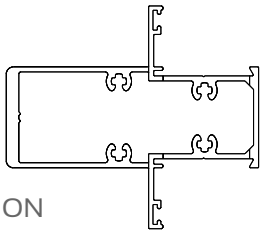
Typical 70mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME

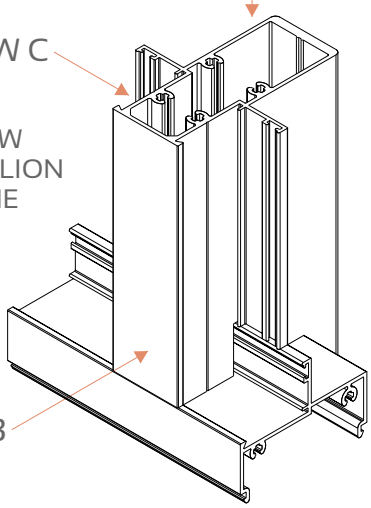


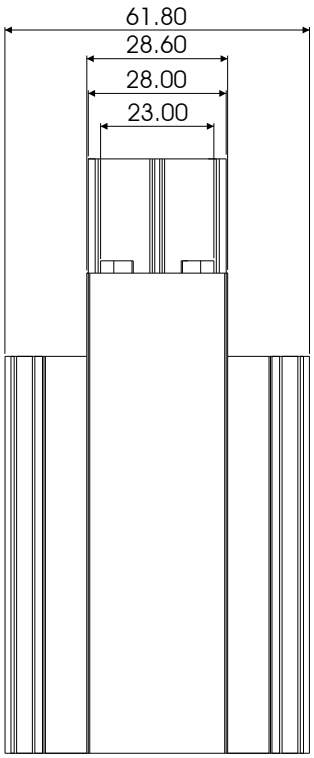
VIEW A-A
70mm Mullion
W54652

VIEW A

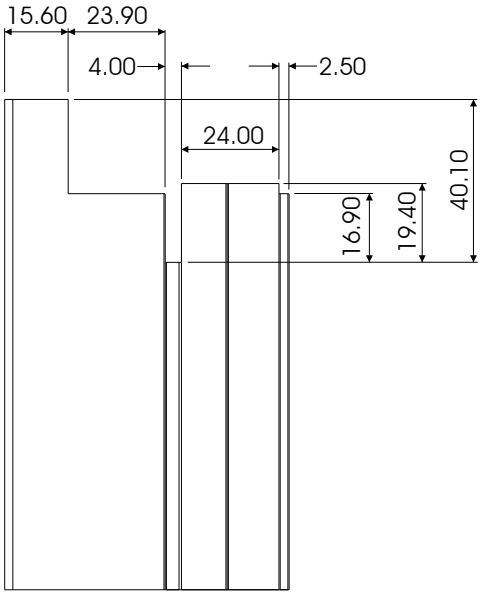
VIEW C

ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME





VIEW B-B
Section not to scale



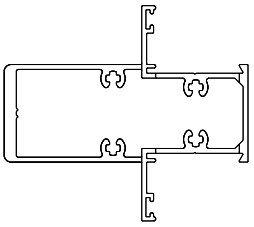
VIEW C-C
Section not to scale

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.

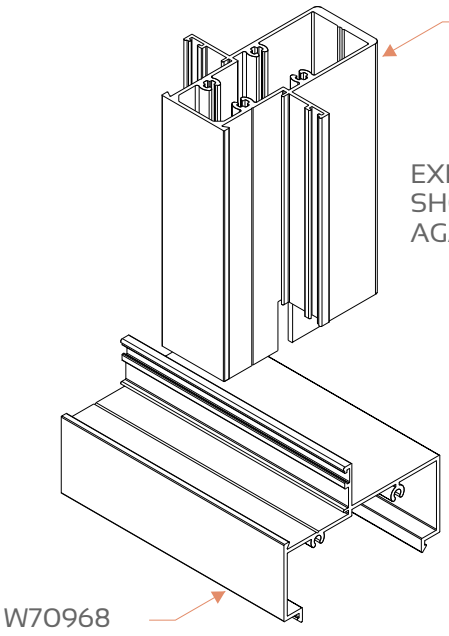
Typical 70mm Mullion Machining Detail

for End Milling on 70mm Outer Frame

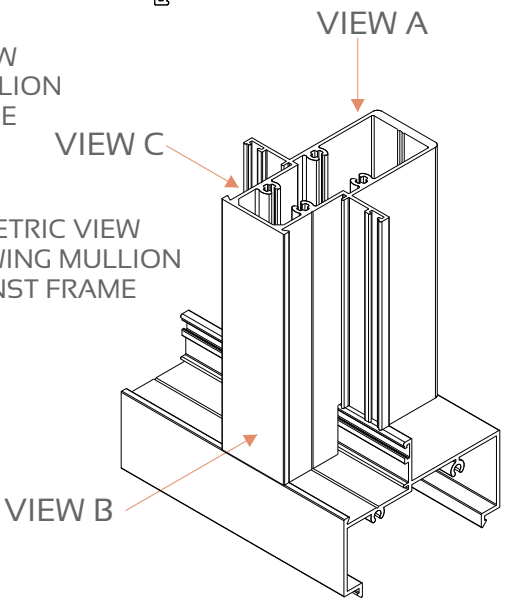
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



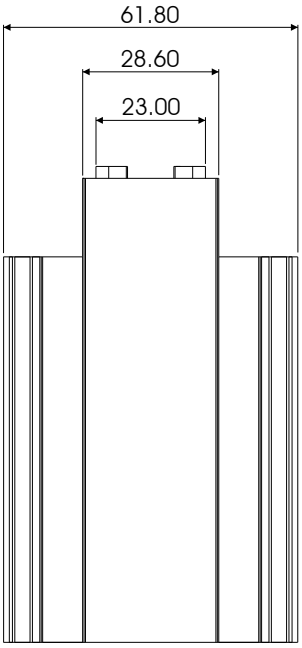
VIEW A-A
70mm Mullion
W54652



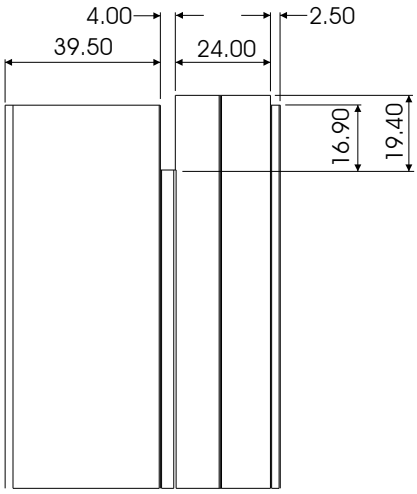
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



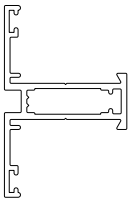
VIEW C-C
Section not to scale

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.

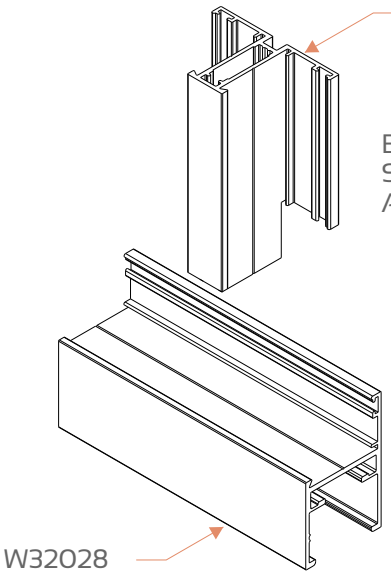
Typical Cottage Pane Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

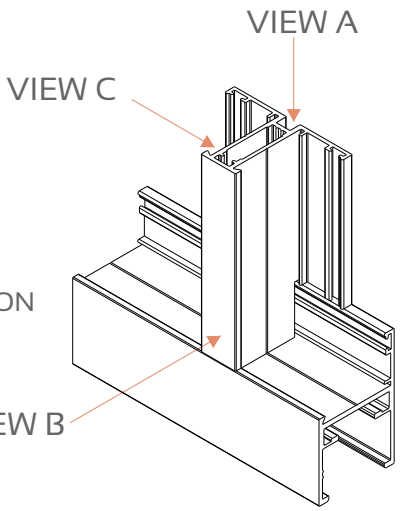
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



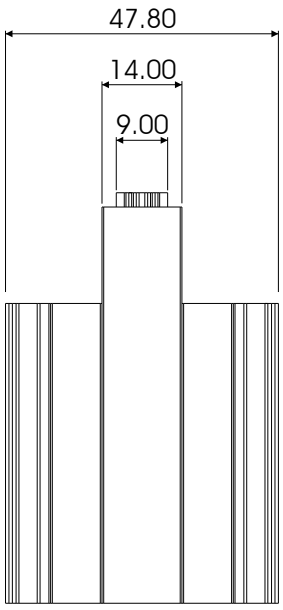
VIEW A-A
Cottage Pane Mullion
W54867



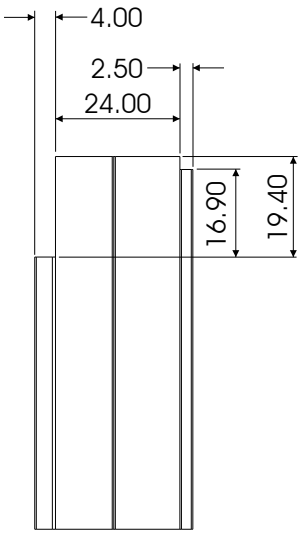
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



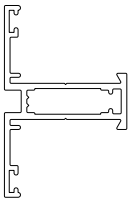
VIEW C-C
Section not to scale

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.

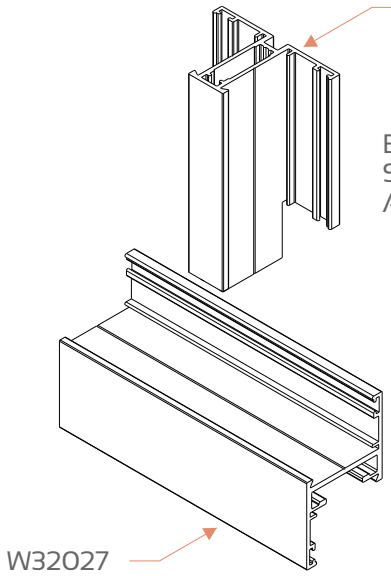
Typical Cottage Pane Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

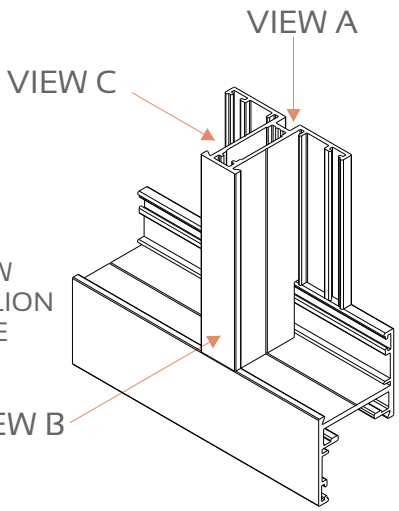
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



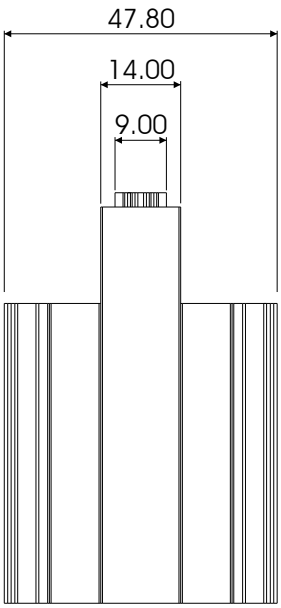
VIEW A-A
Cottage Pane Mullion
W54867



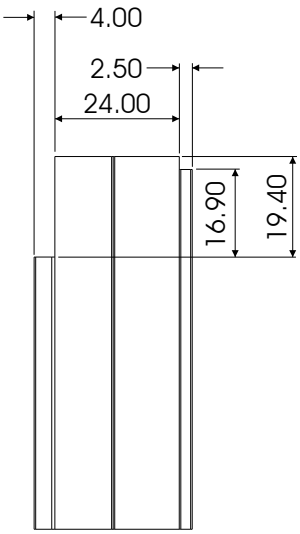
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



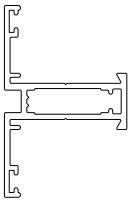
VIEW C-C
Section not to scale

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.

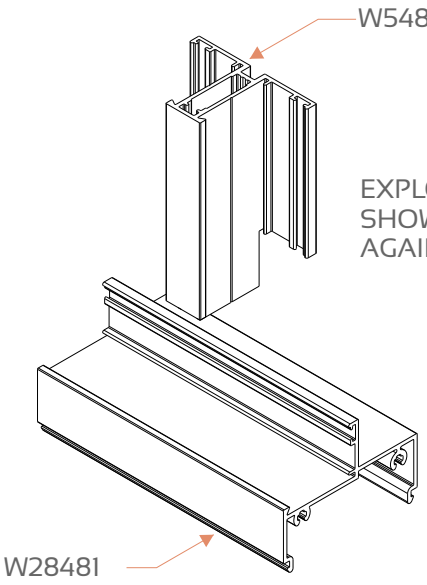
Typical Cottage Pane Mullion Machining Detail

for End Milling on 54mm Outer Frame

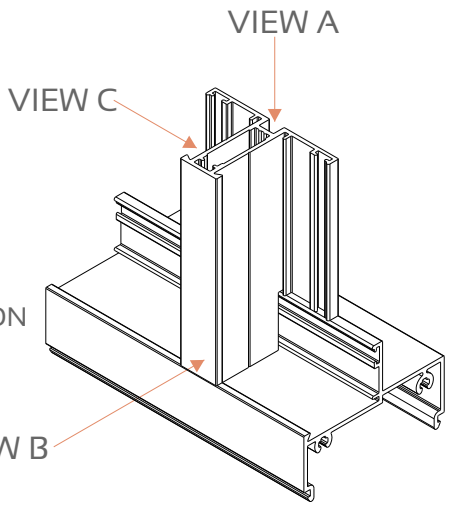
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



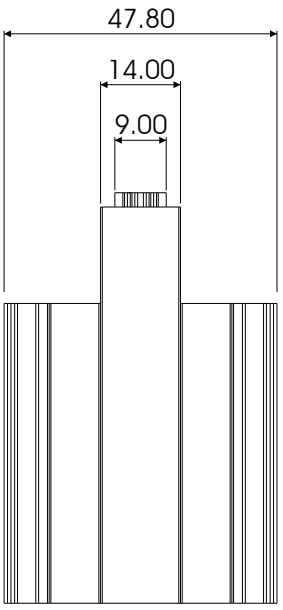
VIEW A-A
Cottage Pane Mullion
W54867



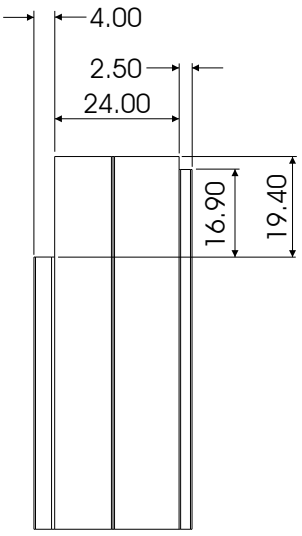
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



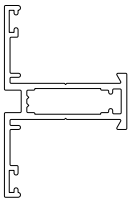
VIEW C-C
Section not to scale

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.

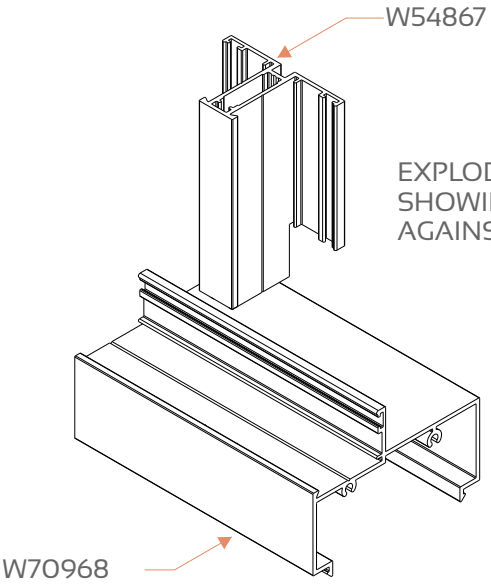
Typical Cottage Pane Mullion Machining Detail

for End Milling on 70mm Outer Frame

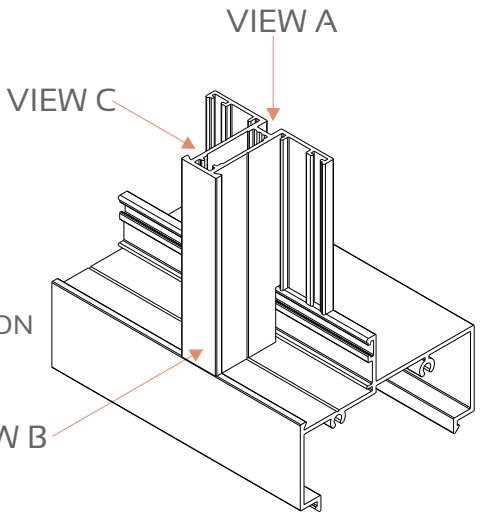
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



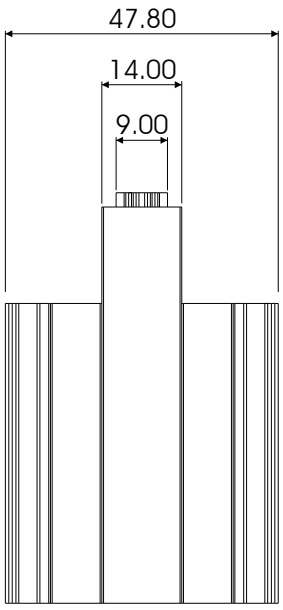
VIEW A-A
Cottage Pane Mullion
W54867



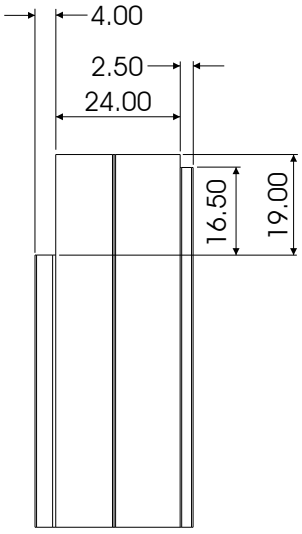
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale

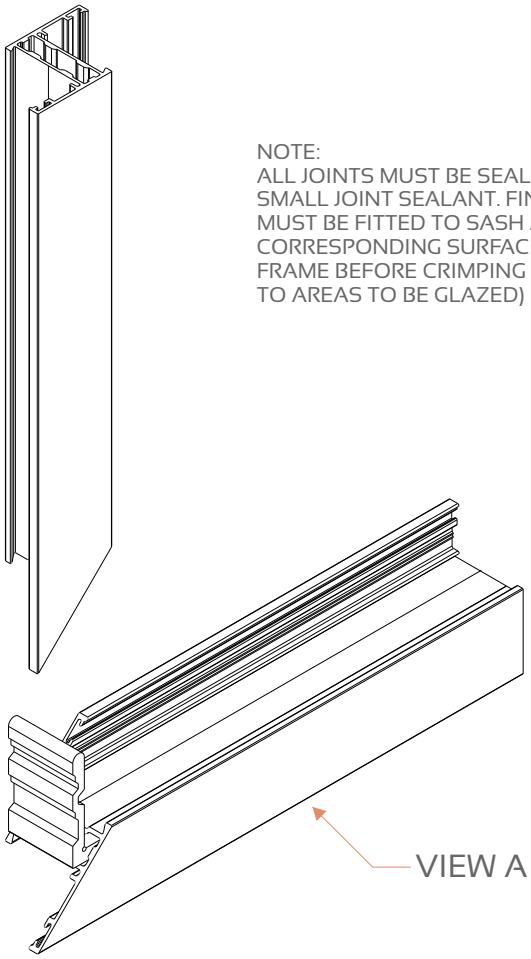


VIEW C-C
Section not to scale

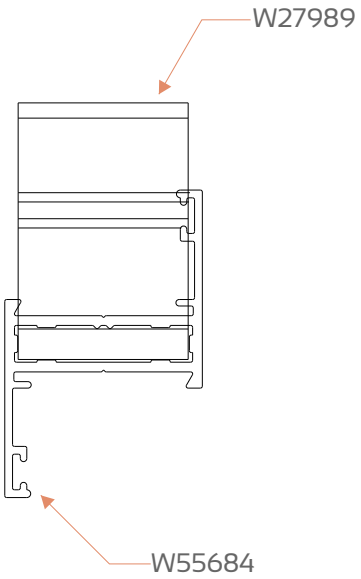
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Corner Cleat Assembly Detail

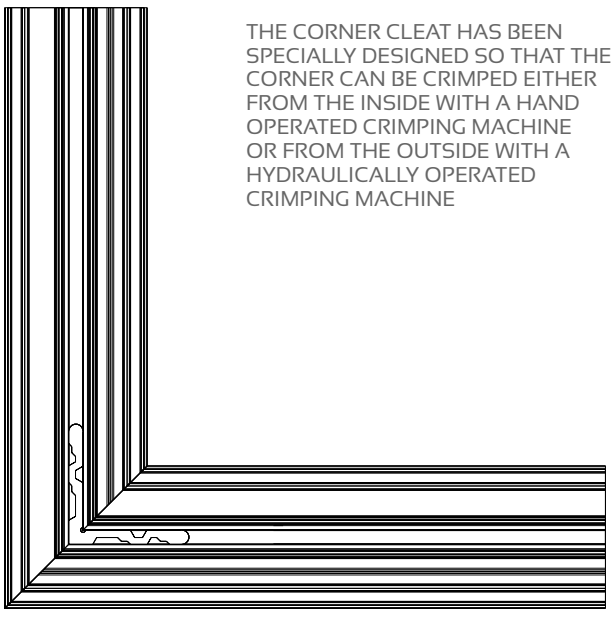
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



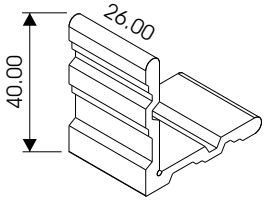
NOTE:
ALL JOINTS MUST BE SEALED WITH SMALL JOINT SEALANT. FINPILE MUST BE FITTED TO SASH AND CORRESPONDING SURFACES OF FRAME BEFORE CRIMPING (NOT TO AREAS TO BE GLAZED)



VIEW A



THE CORNER CLEAT HAS BEEN SPECIALLY DESIGNED SO THAT THE CORNER CAN BE CRIMPED EITHER FROM THE INSIDE WITH A HAND OPERATED CRIMPING MACHINE OR FROM THE OUTSIDE WITH A HYDRAULICALLY OPERATED CRIMPING MACHINE



W27989

VIEW A-A

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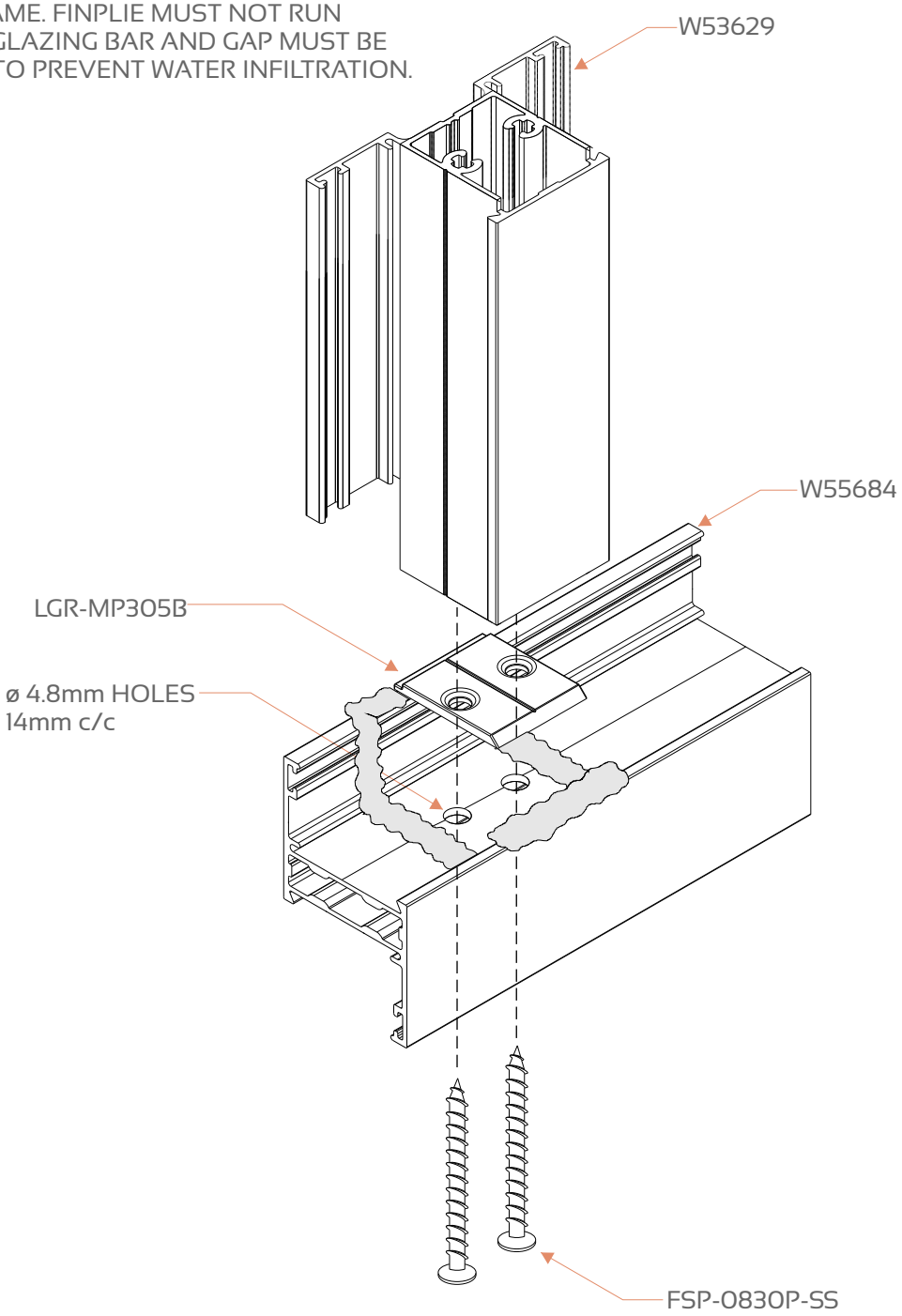
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Mullion Packer Frame Joint

Assembly Detail

NOTE: ALL JOINTS MUST BE SEALED WITH SMALL JOINT SEALANT. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPLIE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.

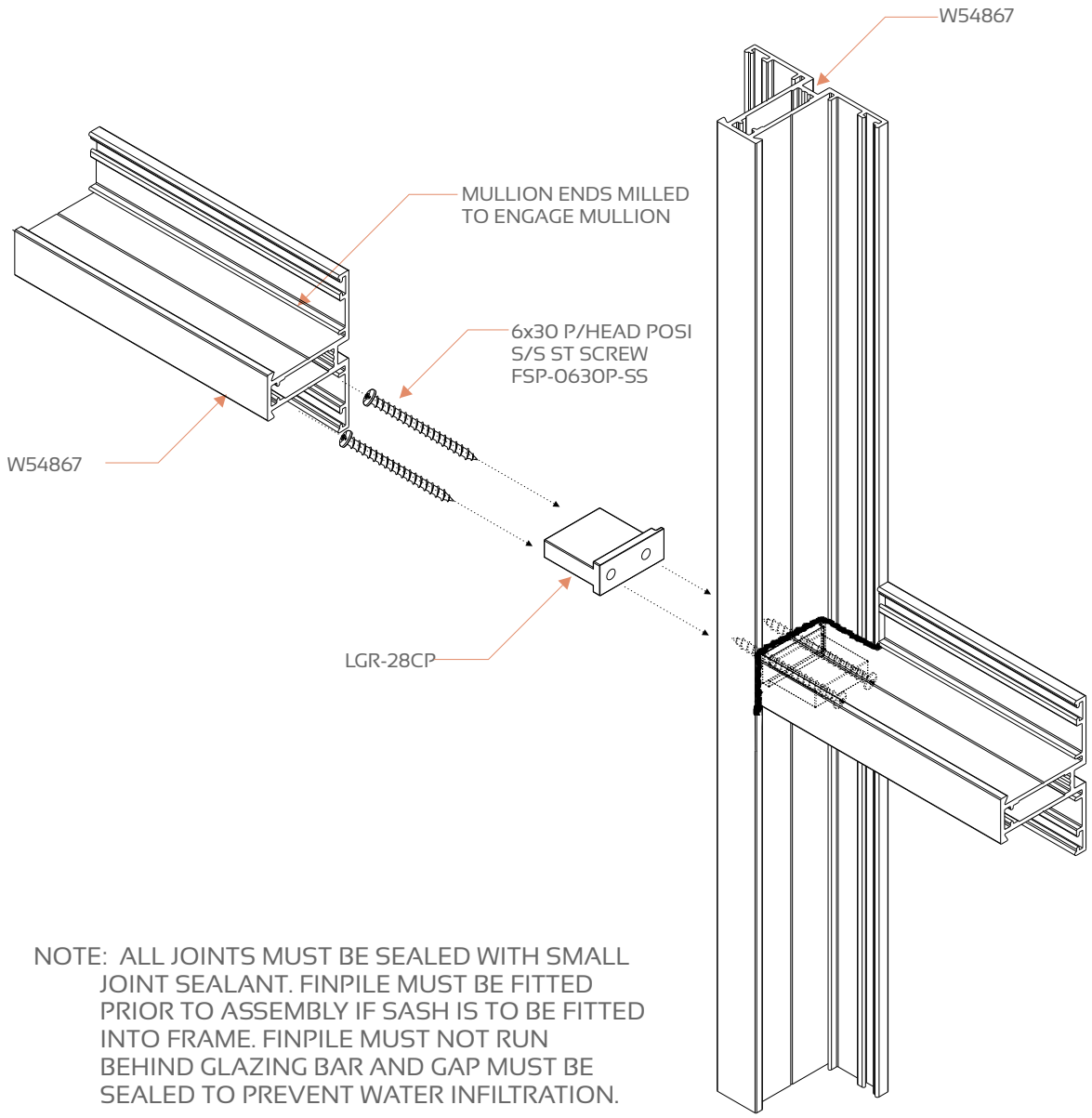


crealco

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.

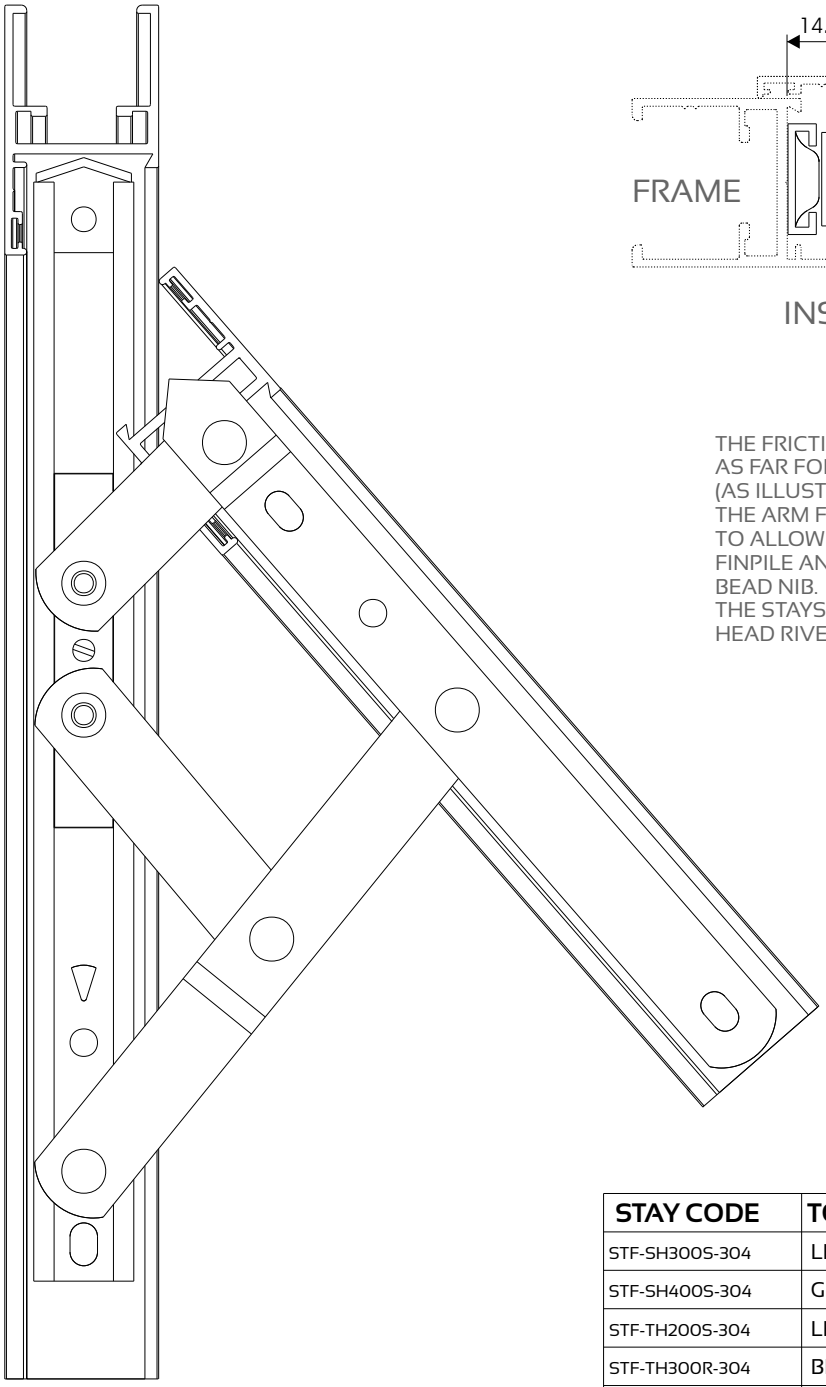
Typical Cross Joint Assembly Detail

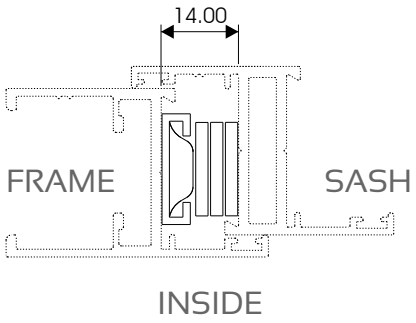
Cottage Pane Mullion



NOTE: ALL JOINTS MUST BE SEALED WITH SMALL JOINT SEALANT. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPILE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.

Typical Friction Stay Assembly Detail





THE FRICTION STAY SHOULD ALWAYS BE FITTED AS FAR FORWARD IN THE FRAME AS POSSIBLE. (AS ILLUSTRATED)
THE ARM FIXED TO THE SASH SHOULD BE FITTED TO ALLOW CORRECT COMPRESSION OF THE FINPILE AND PACKED TO CLEAR GLAZING BEAD NIB.
THE STAYS ARE SECURED WITH 4.8 x 10 DOME HEAD RIVETS.

STAY CODE	TO BE USED FOR SASH SIZE
STF-SH300S-304	LESS THAN OR EQUAL TO 434 mm
STF-SH400S-304	GREATER THAN 434 mm
STF-TH200S-304	LESS THAN OR EQUAL TO 334 mm
STF-TH300R-304	BETWEEN 335 mm & 434 mm
STF-TH400S-304	BETWEEN 435 mm & 534 mm
STF-TH500S-304	BETWEEN 535 mm & 634 mm
STF-TH600S-304	GREATER THAN 634 mm

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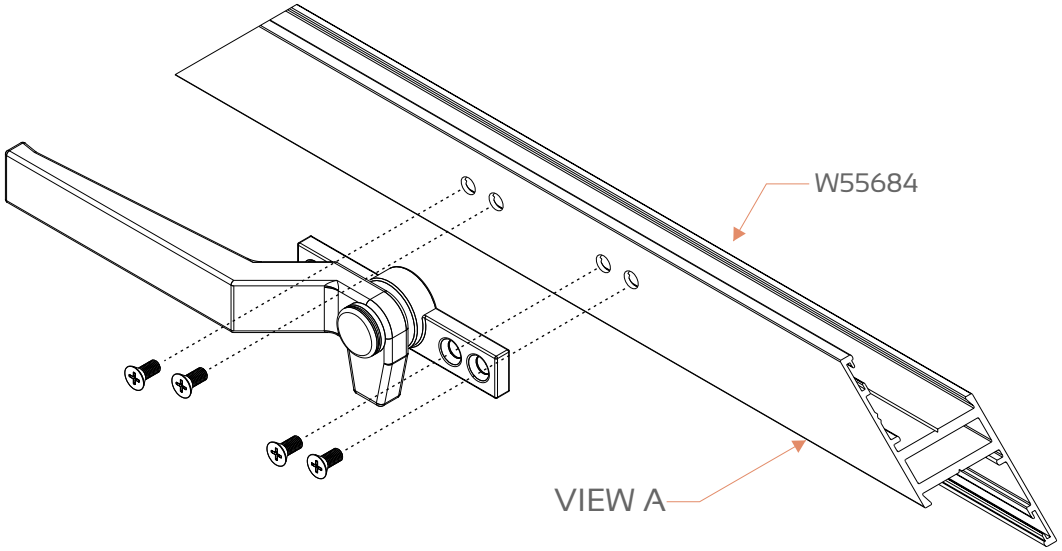
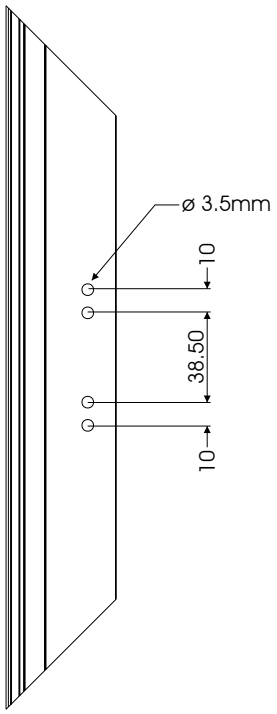
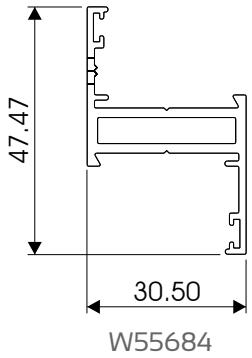
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Handle Assembly Detail



NO 8 x 10 COUNTERSUNK SELF-TAPPING
FLAT END SCREWS



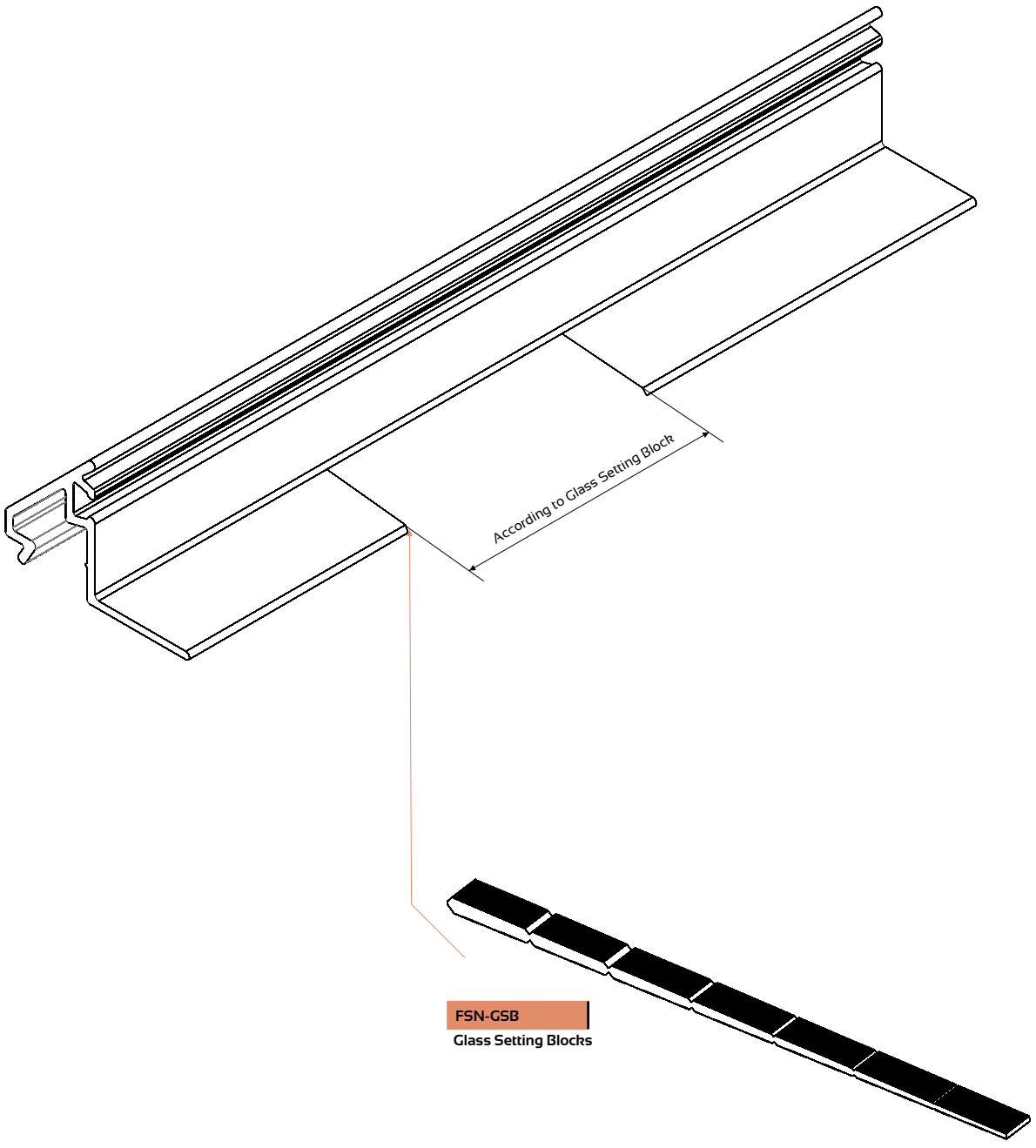


VIEW A-A

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.

Typical Bead Cut-Out for Setting Block

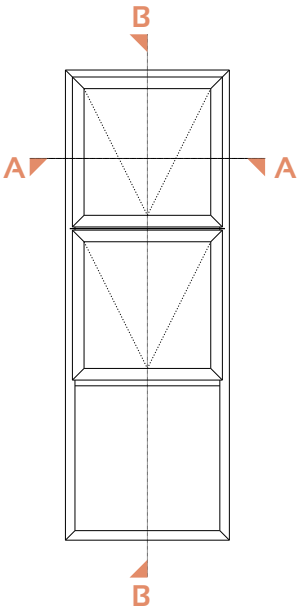
Bead must be notched out at position of all glass setting blocks according to the length of the glass setting block used.



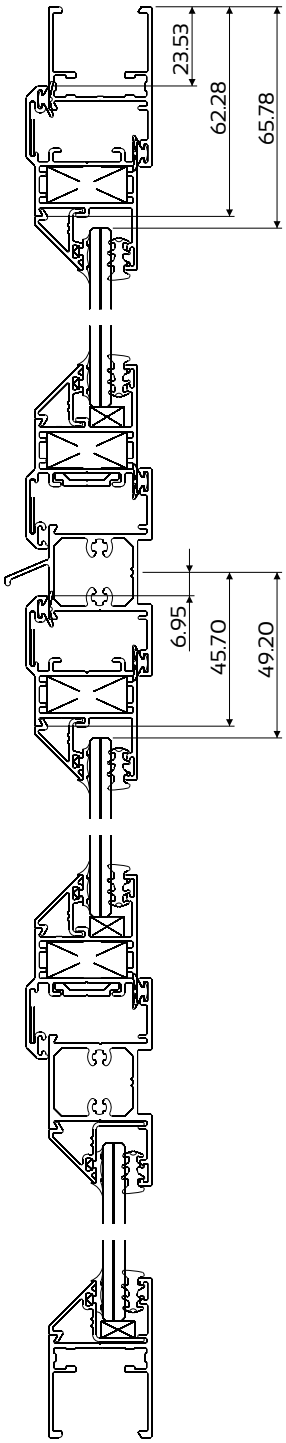
FSN-GSB
Glass Setting Blocks

Typical Cross-sectional Details

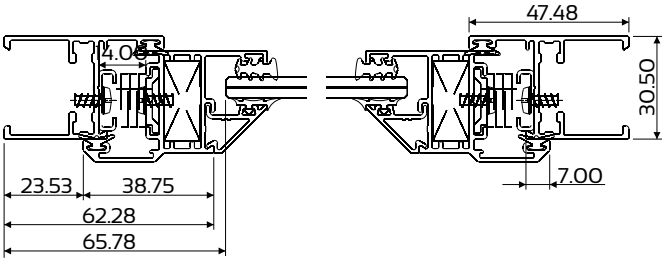
Double Top Hung over Fixed



SECTION B-B
Section not to scale



SECTION A - A
Section not to scale



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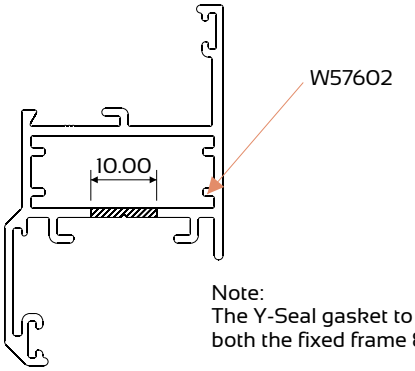
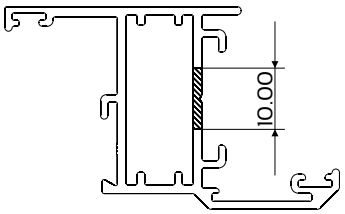
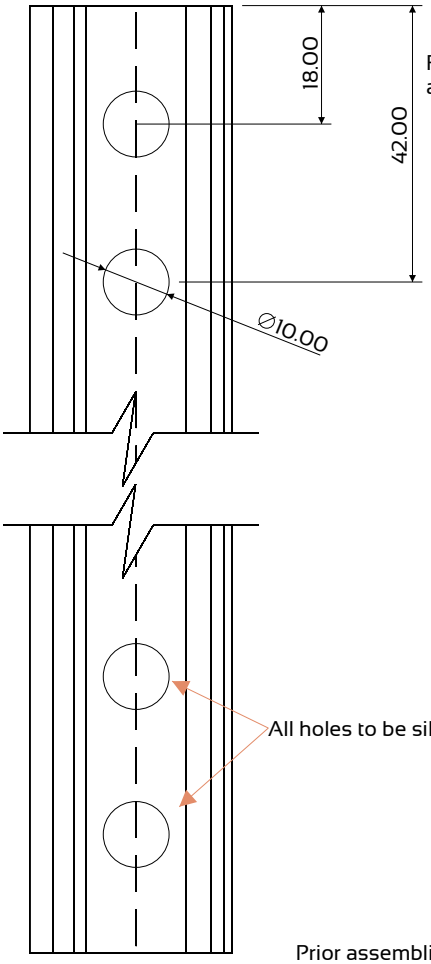
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

OPTION A - USING THE JOINING CORNER



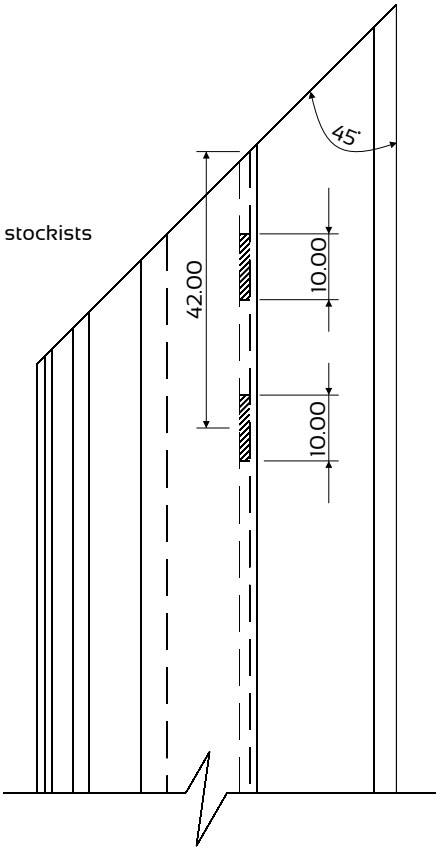
Note:
The Y-Seal gasket to be used for
both the fixed frame & sash.





For drilling of holes
a jig is available from the stockists

All holes to be silicone sealed



All mechanical joints to be silicone sealed

No crimping required.

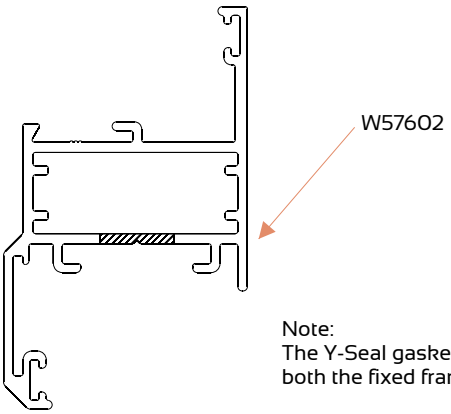
Prior assembling the sash profiles together, ensure
that a locking bar profile is fitted for each friction stay.

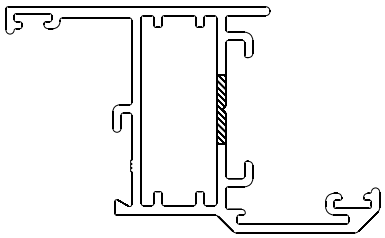
Cut locking bar to the same length as the friction stay.

Typical Euro Sash Corner Joint Detail

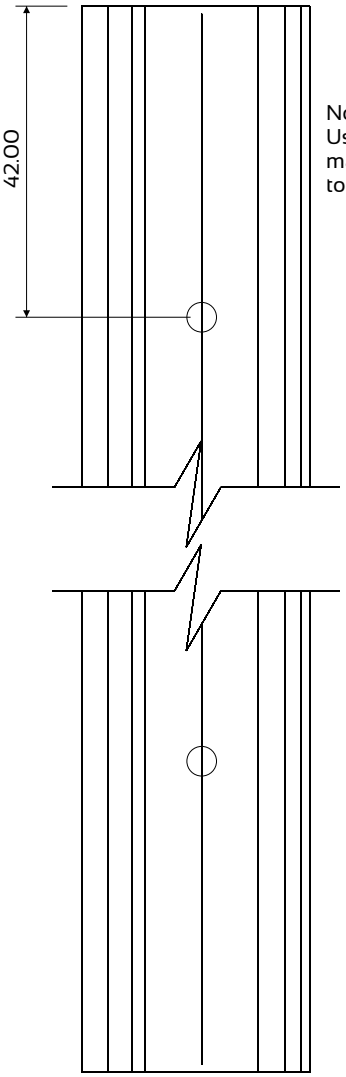
Option B - Using the Corner Connector

OPTION B - USING THE CORNER CONNECTOR

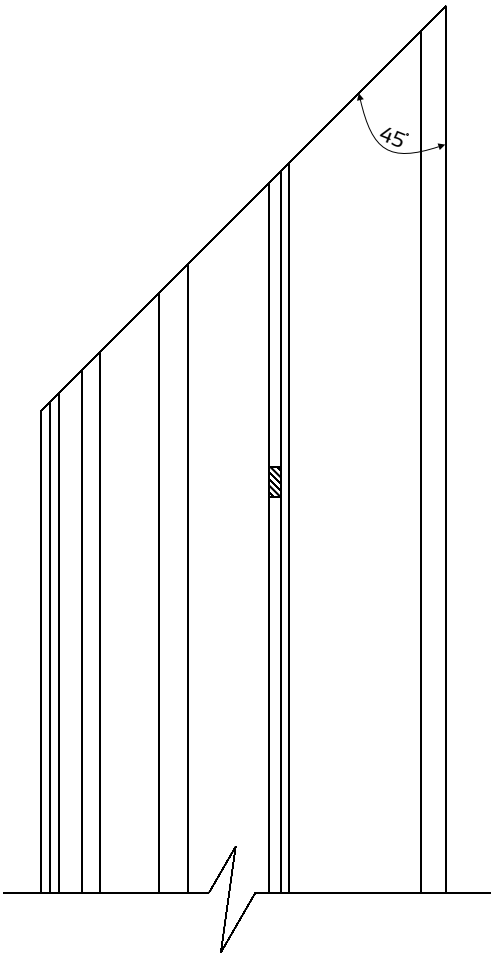




Note:
The Y-Seal gasket to be used for both the fixed frame & sash.

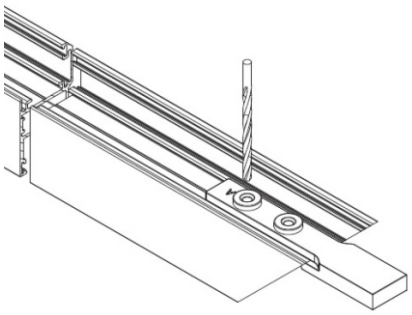


Note:
Use the jig for drilling the holes marked "A" to fix the pop rivet to the corner connector.



All mechanical joints to be silicone sealed

No crimping required.



Prior assembling the sash profiles together, ensure that a locking bar profile is fitted for each friction stay.

Cut locking bar to the same length as the friction stay.

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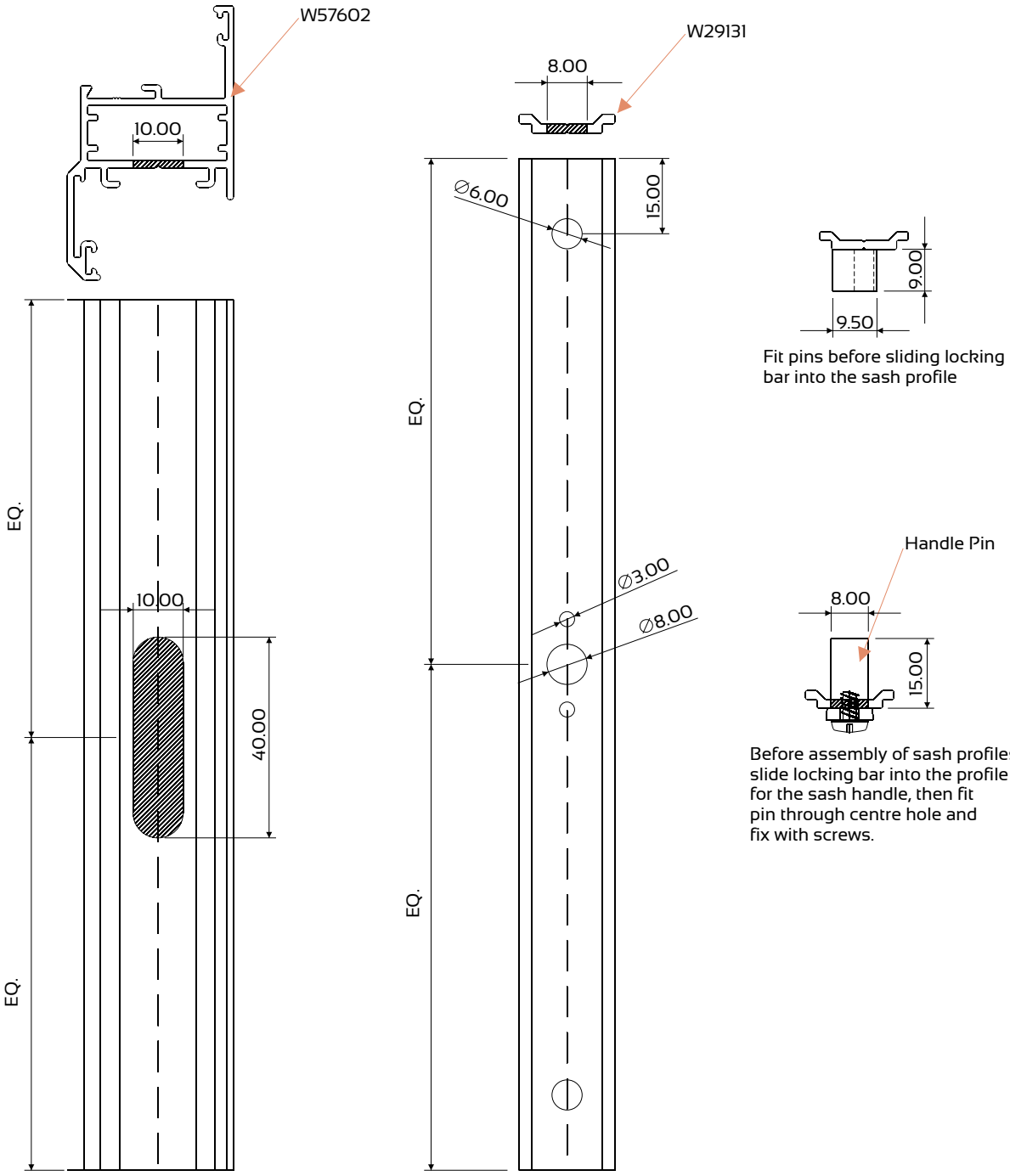
Typical Euro Sash Machining Detail

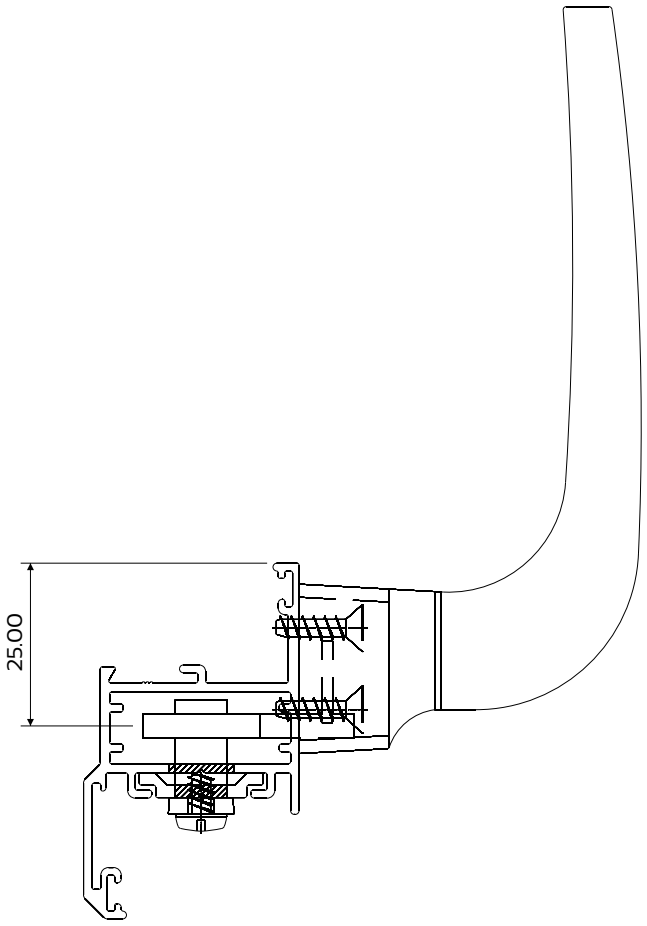
Sash & Locking Bar

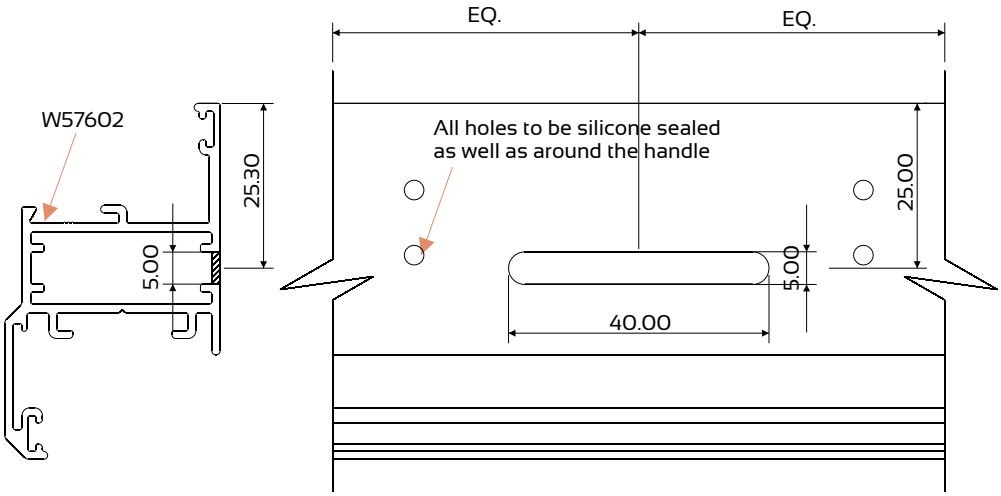


Note:
Before assembly of the sash frame, the locking bar needs to be inserted into the bottom sash profile with the locking pins fitted & holes drilled to receive the handle pin.

Typical Euro Sash Machining Detail

Handle





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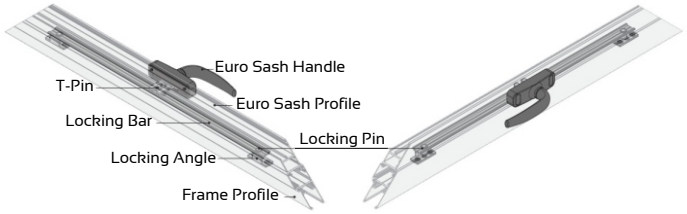
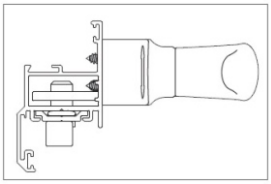
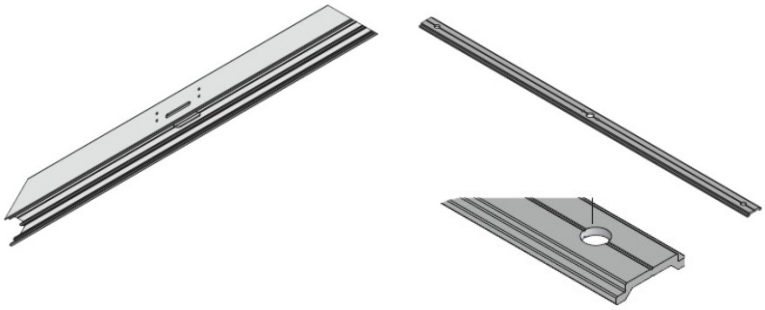
Typical Fitting of Euro Sash Handles



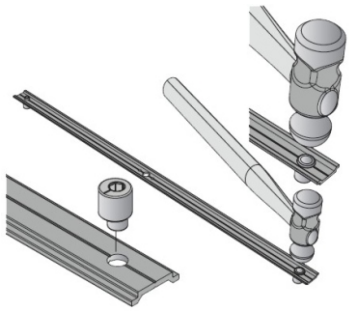




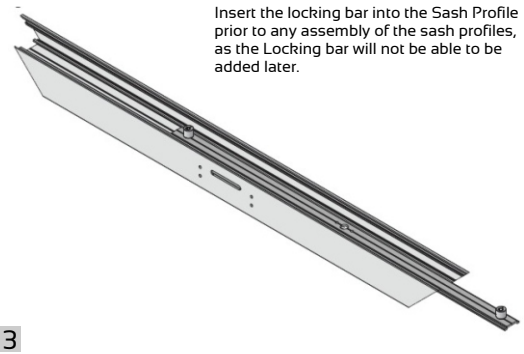
Once all frame profiles have been cut to length and deburred, machine the handle profile according to Maching details as shown on the previous page.

Cut the locking bar as per StarFront & machine as shown in diagram 2.

2

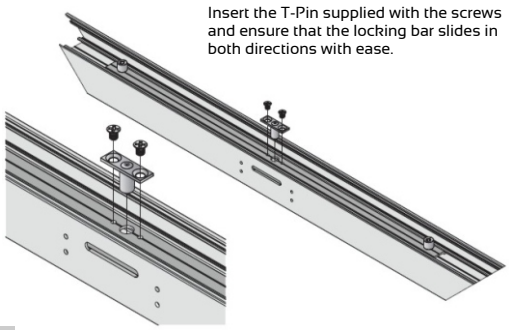


Insert the locking pins into the locking bar. Deform the protruding part of the pin using a ball peen hammer or punch to fix them onto the locking bar.



Insert the locking bar into the Sash Profile prior to any assembly of the sash profiles, as the Locking bar will not be able to be added later.

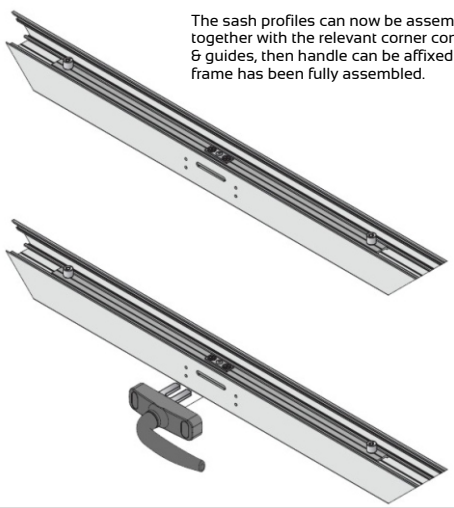
3



Insert the T-Pin supplied with the screws and ensure that the locking bar slides in both directions with ease.

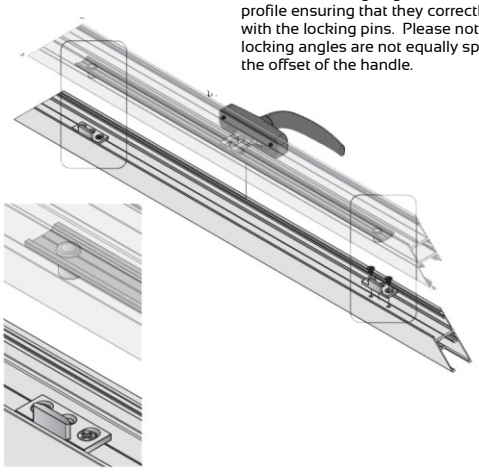
4

5



The sash profiles can now be assembled together with the relevant corner connectors & guides, then handle can be affixed after the frame has been fully assembled.

6



Install the locking angles to the outer frame profile ensuring that they correctly align with the locking pins. Please note that the locking angles are not equally spaced due to the offset of the handle.

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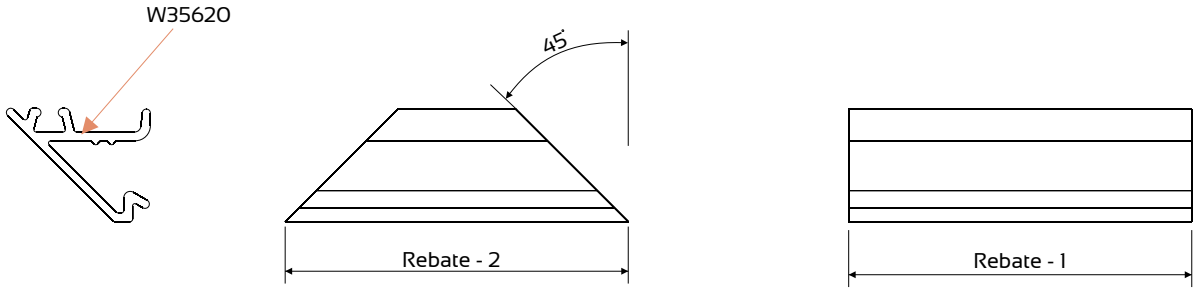
Typical Euro Sash Cutting Detail

for Bead



Vertical Glazing Bead

Horizontal Glazing Bead

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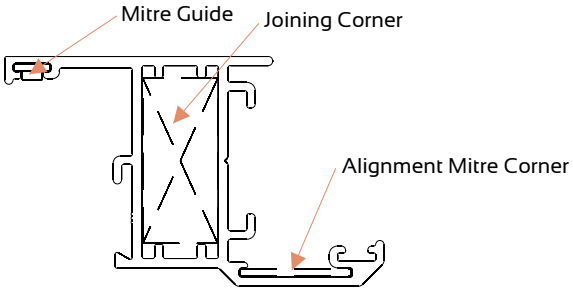
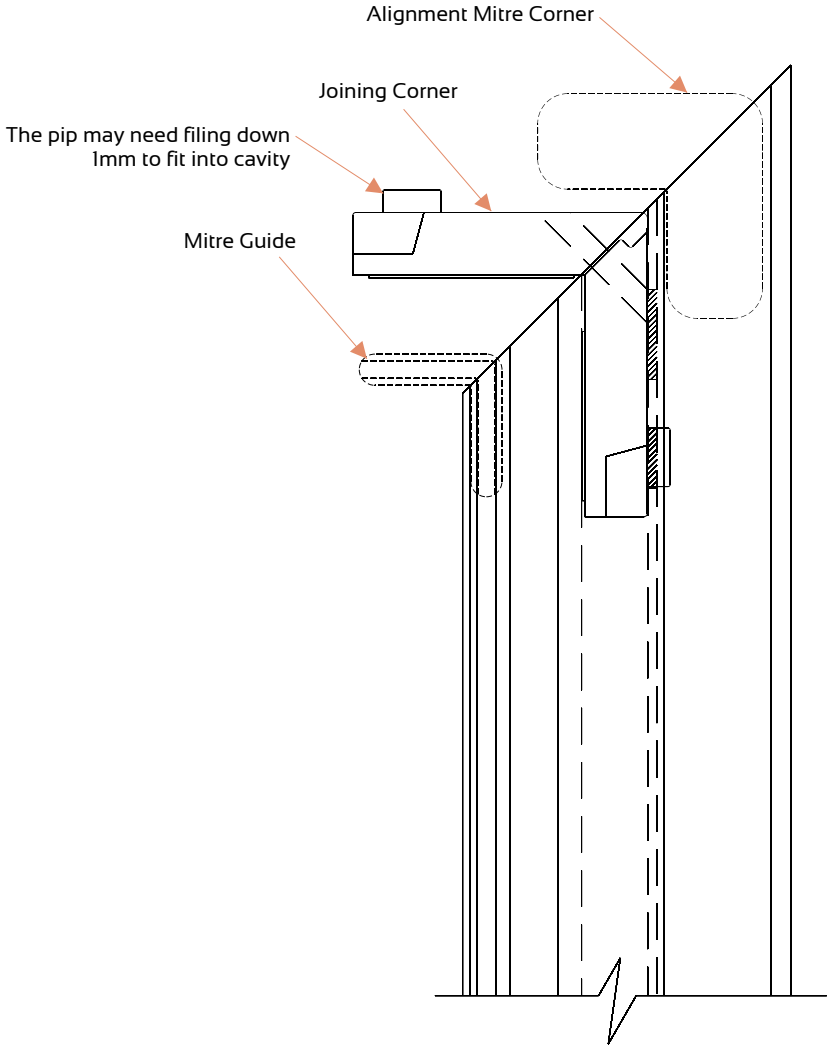
Typical Euro Sash Assembly Detail

Corner Joint

OPTION A - USING THE JOINING CORNER





All mechanical joints to be Crealco silicone sealed
Note: Remember to fit the locking bars for friction stays before assembly of sash frame.

No crimping required.

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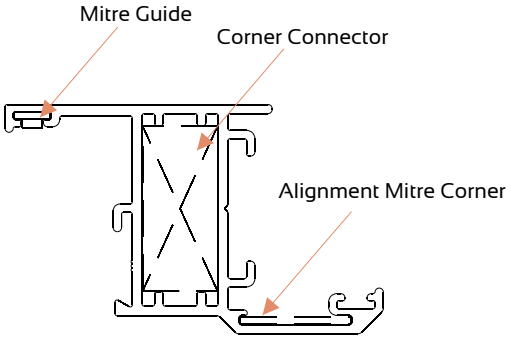
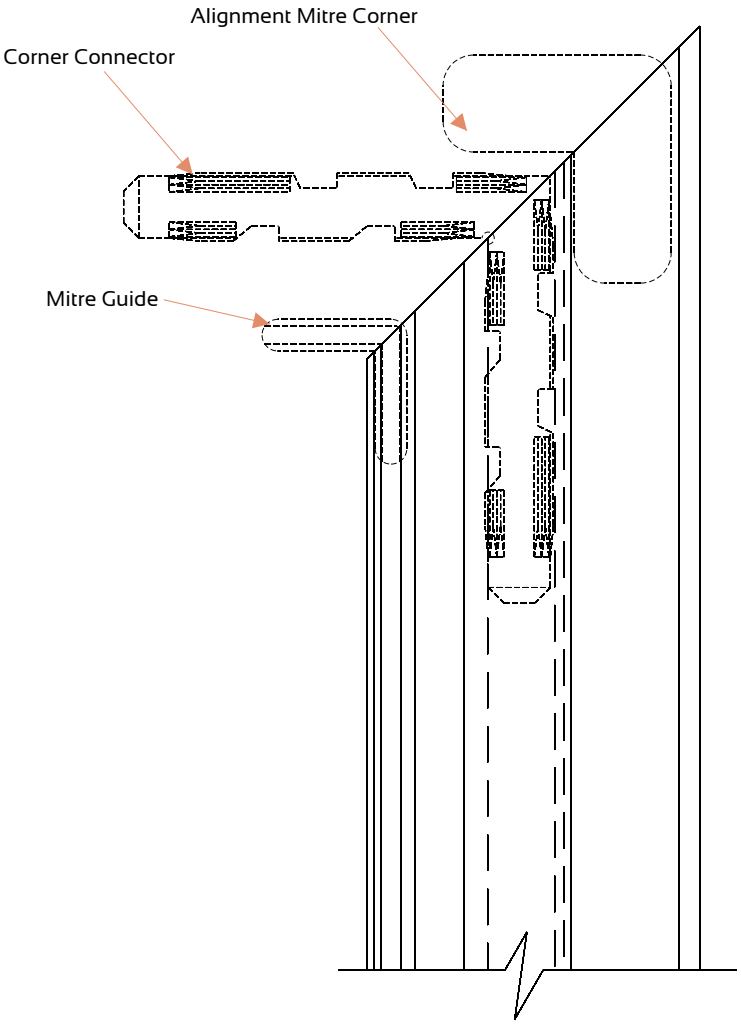
OPTION B - USING CORNER CONNECTOR

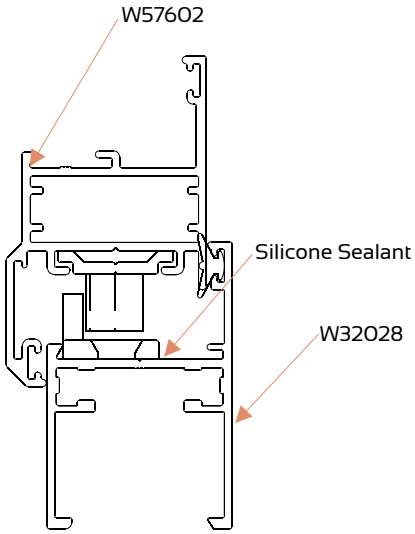




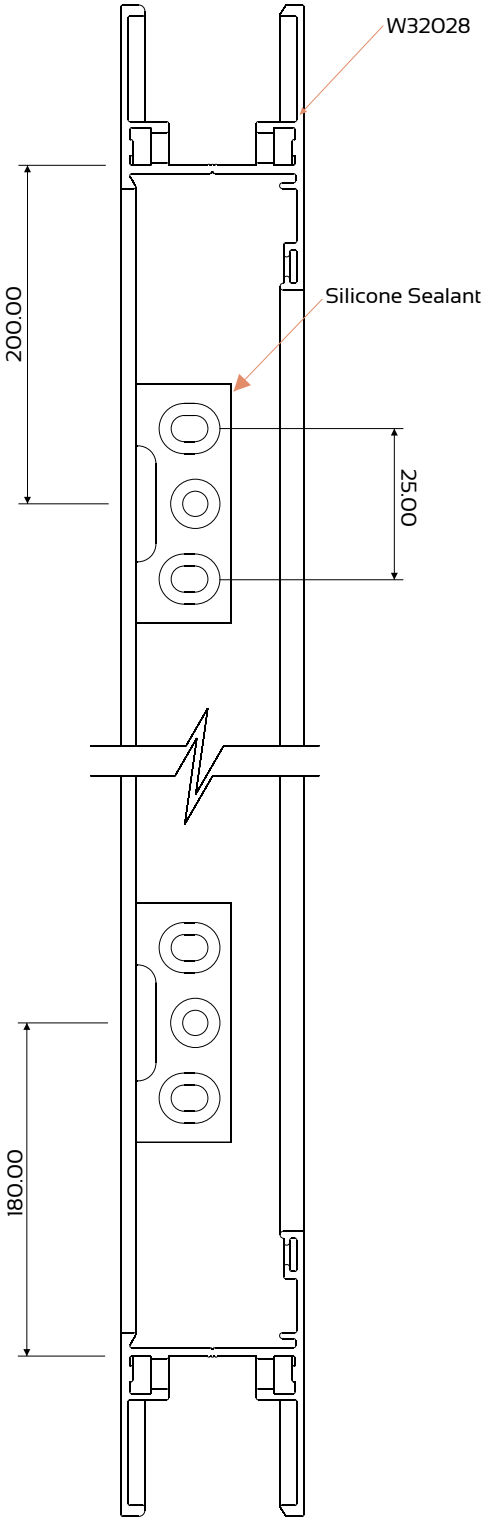
All mechanical joints to be Crealco silicone sealed
Note: Remember to fit the locking bars for friction stays before assembly of sash frame.

No crimping required.

Typical Euro Sash Locking Angle Detail

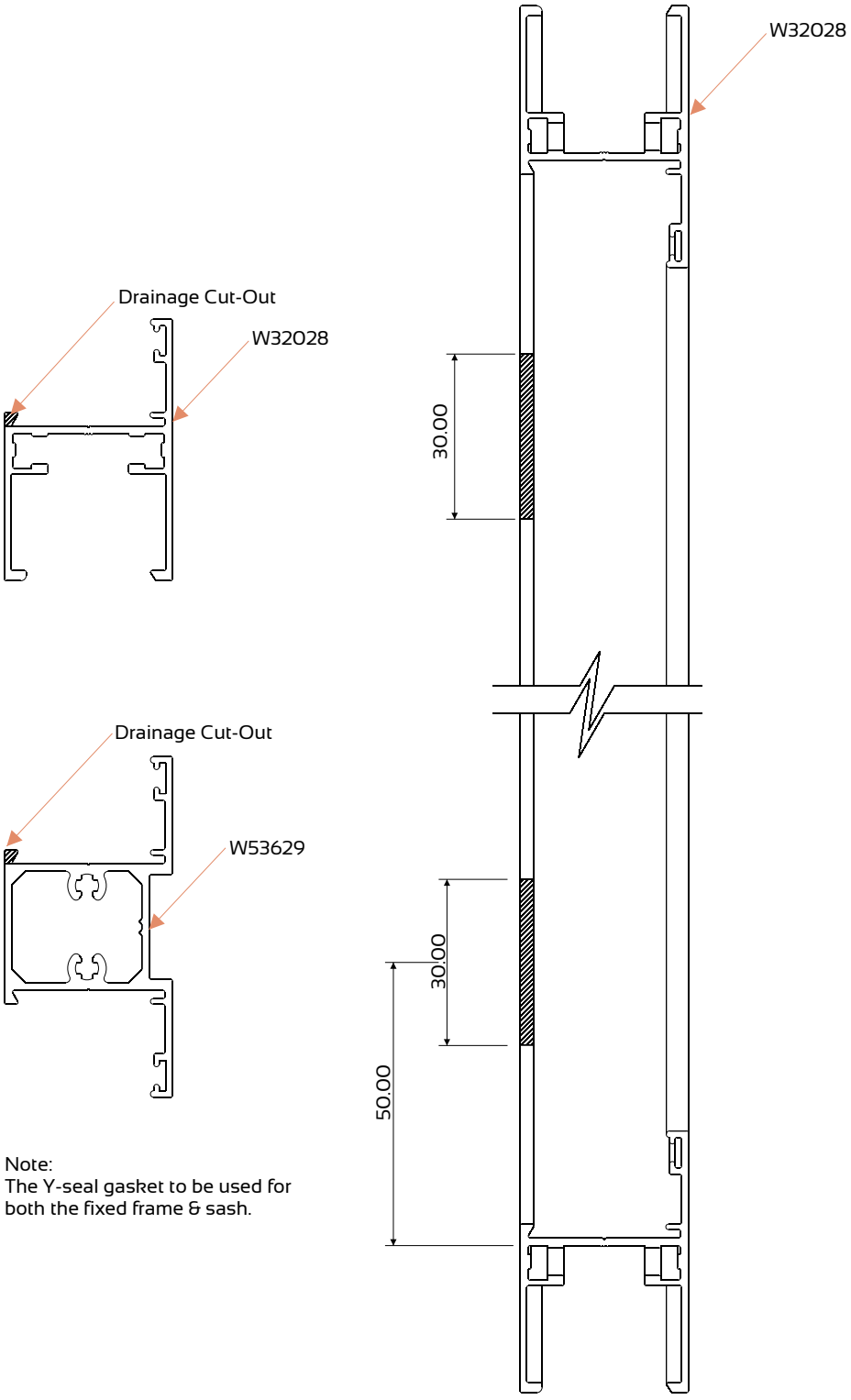


Note:
No Y-seal gasket to be fitted for the bottom sash profile unless the building is over 5 stories high. Ensure the Y-seal gasket sits between the drainage cut-out.



Typical Euro Sash Outer Frame Drainage Detail

Detail for Severe Weather Conditions



Note:
The Y-seal gasket to be used for both the fixed frame & sash.

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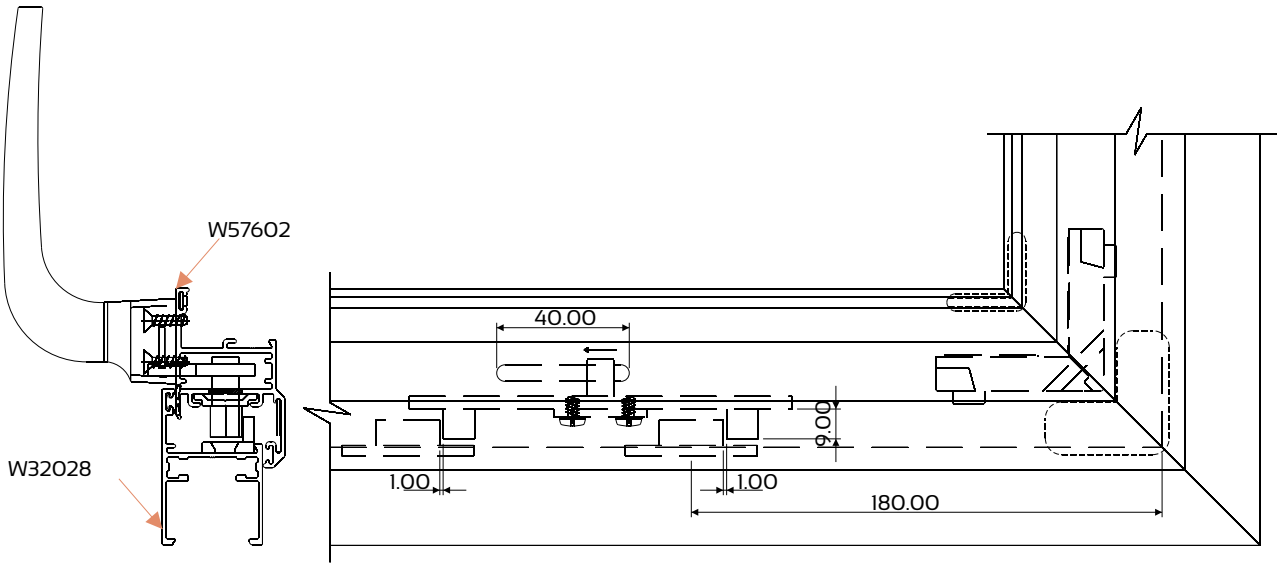
Typical Position of Locking Bar



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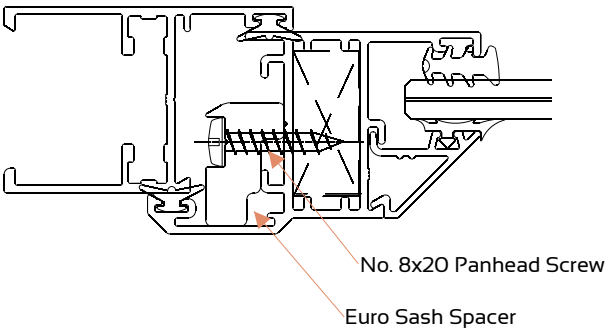
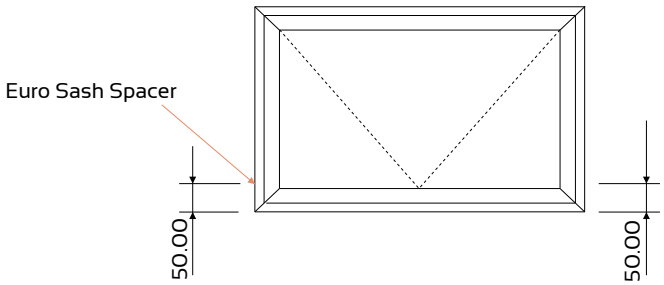
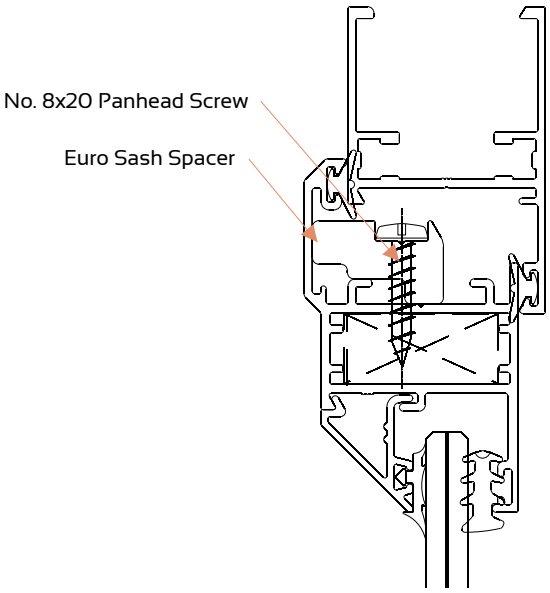
Typical Fitting of Euro Sash Spacer

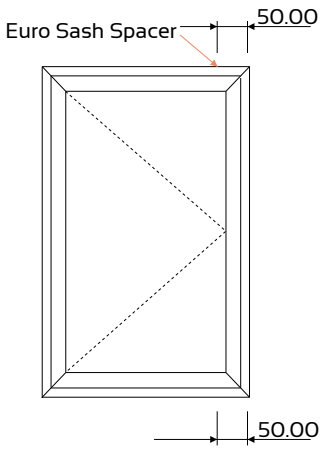


Note:
To assist the top hung sash in opening & closing squarely, a Euro sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.





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.



Note:
For optimal performance against air & water infiltration,
it is important to position friction stays as shown so that the sash fits almost right against the frame.

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Typical Glazing Procedure

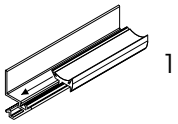
Insert the pull-in vinyl gasket into glazing beads by sliding or pressing it into the groove (1). Before cutting gasket, ensure that it has not stretched and cut 6mm longer so that corners are in compression at all times.

Position bottom glazing bead in glazing bead rebate (2).

Place glass on glazing blocks (3).

Insert top and then side glazing beads ensuring that they are in correctly.

Starting from top centre, insert roll in gasket (4) without stretching it (5). Stop 150mm from corner and partly cut gasket 6mm longer than the edge of the vertical bead. Insert gasket at corner and then roll in remaining 150mm. Repeat this on the other sides. Where gasket ends meet, cut gasket 6mm longer. Insert cut ends first and complete.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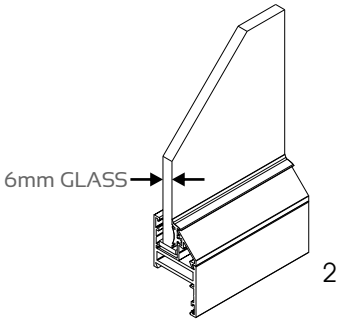
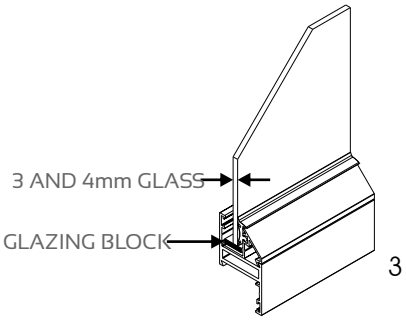
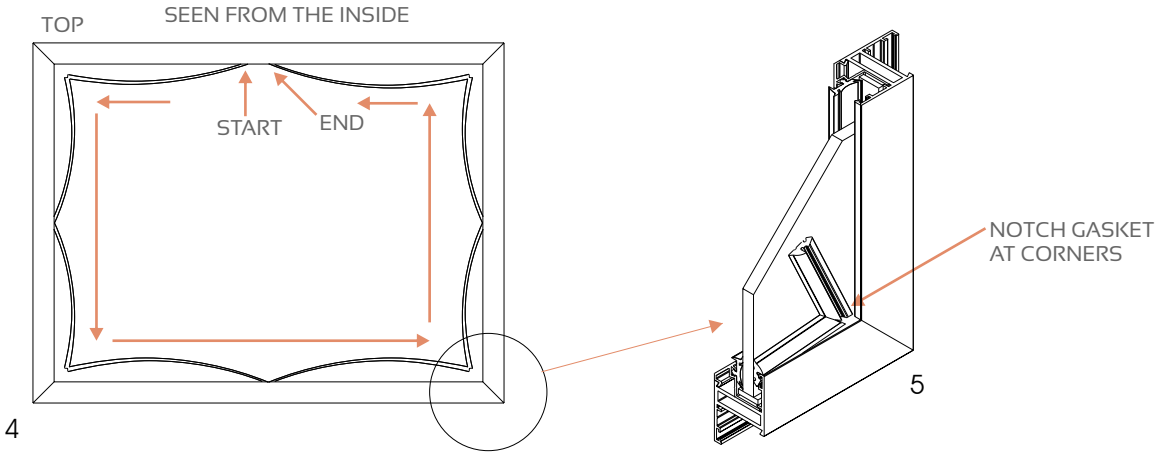


2



3

ENSURE GASKETS ARE NOT STRETCHED AT ANY STAGE



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5

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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.

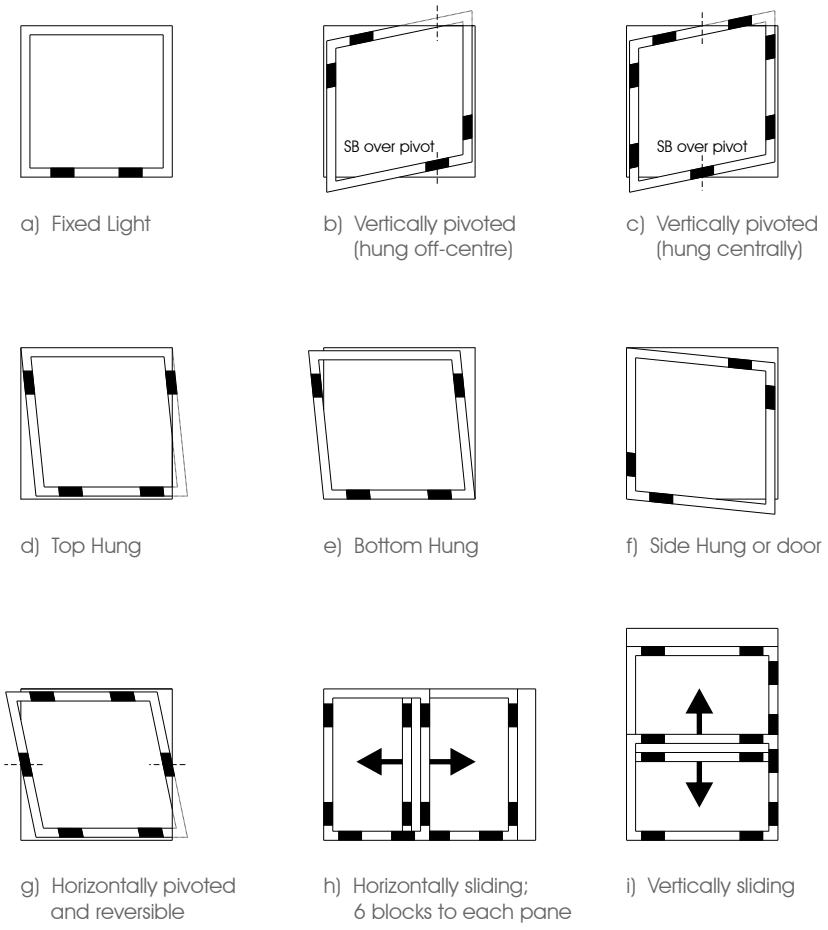

FIGURE 2 - POSITION OF SETTING AND LOCATION BLOCKS