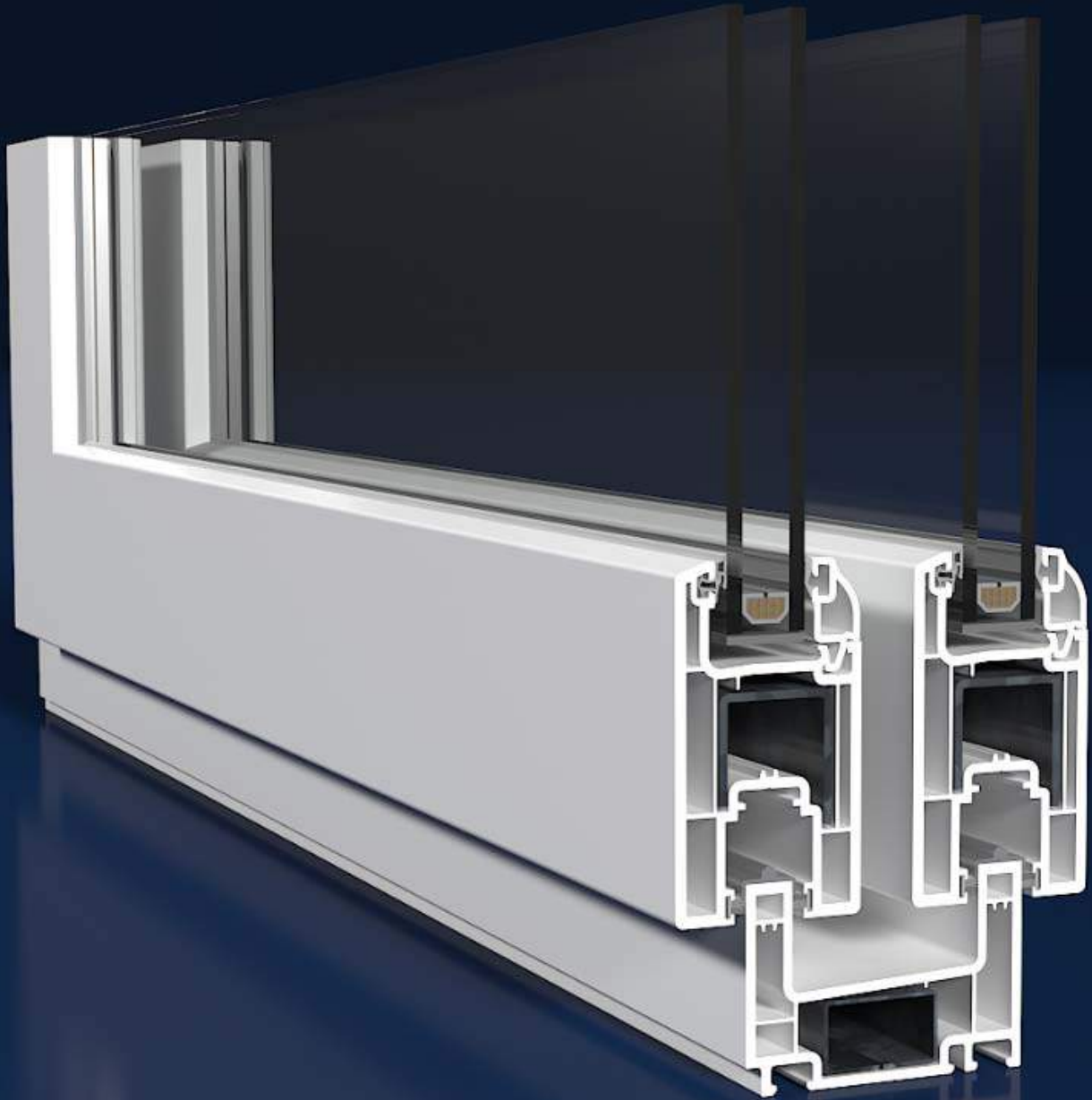


SLIDING FABRICATION MANUAL

deceuninck



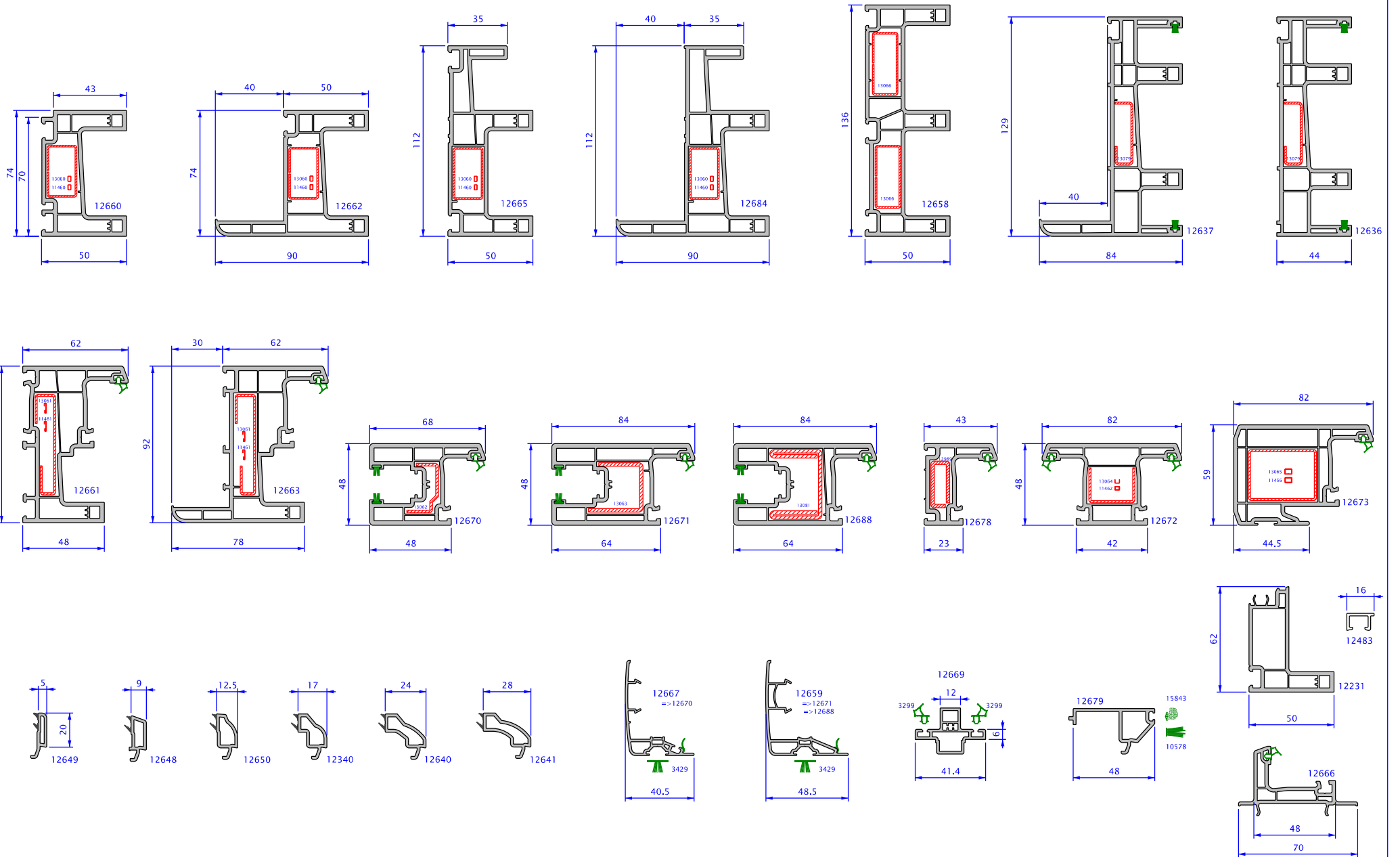
Fabrication Manual

December 2021

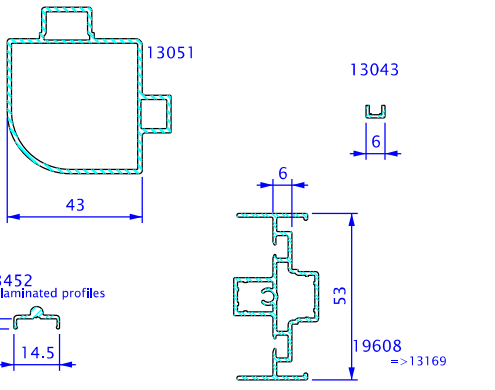
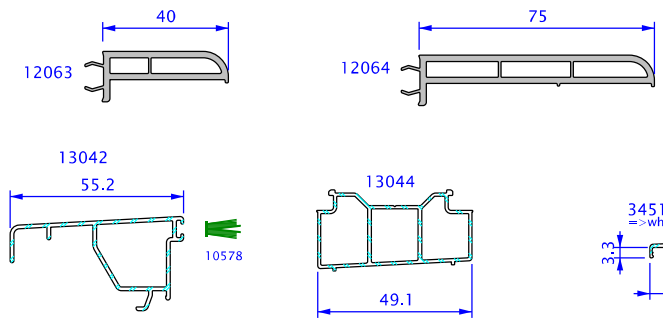
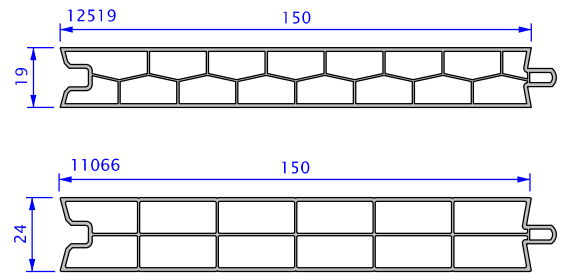
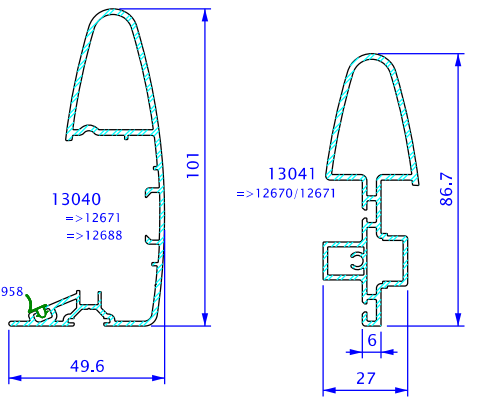
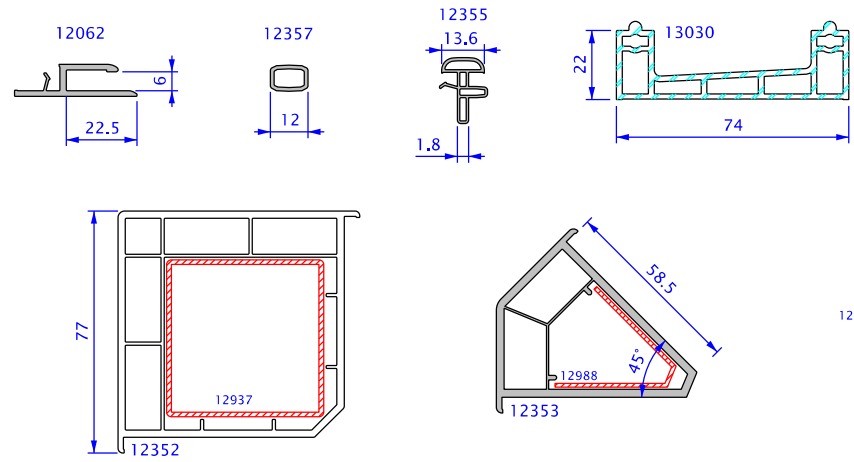
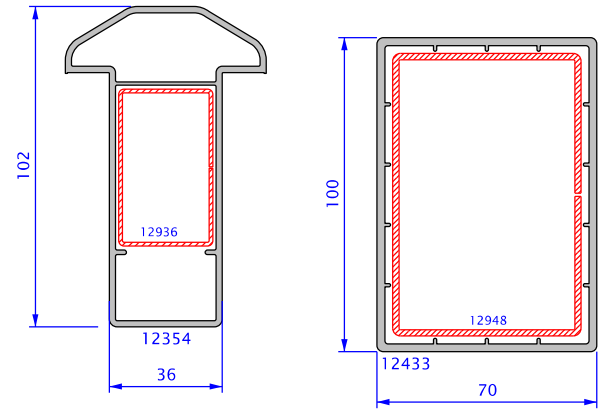
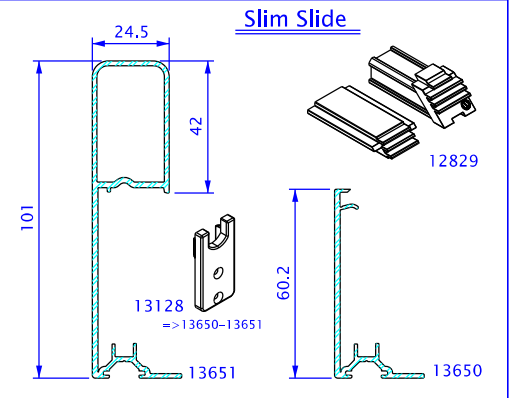
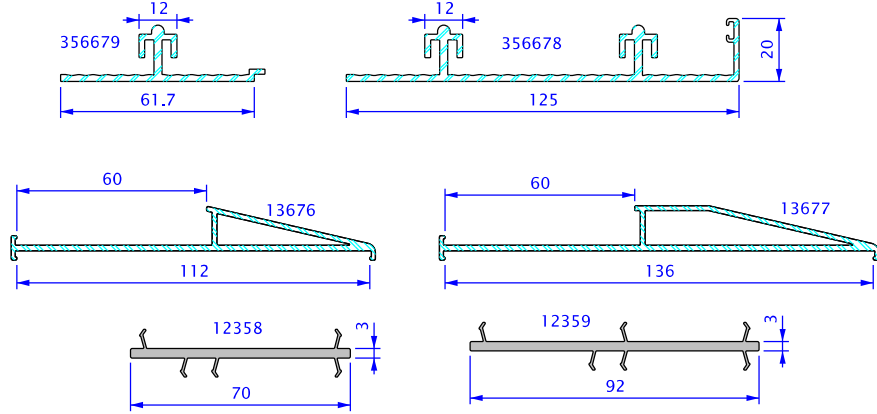
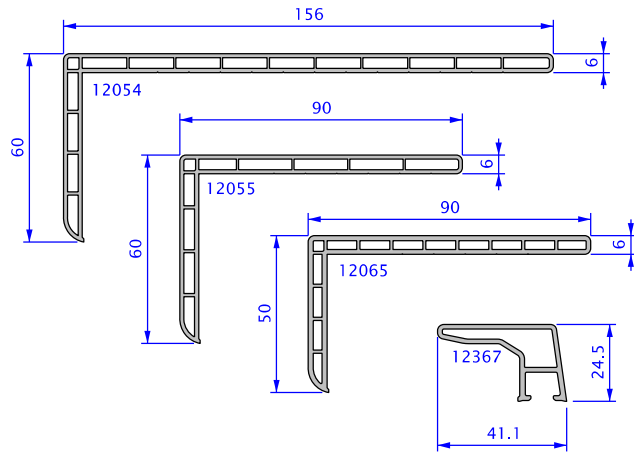


Building a sustainable home

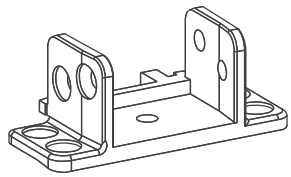
SLIDING SYSTEM	Page Number
System Overview	1
Cutting Sizes	12
Preparation of Profiles	18
Preparation of Profiles & Hardware	36
Welding & Corner Cleaning	47
Preparing of Transom	66
Application of Accessory Products	75
Slim Slide	95
DIFFERENT SLIDING APPLICATION	105
Alfresco Applications	105
Sliding Aluminium Bottom Frame Application	111
13514–Drainage cap of sliding application	116
12669–Sliding sash coupling application	117
SLIDING FLYSCREEN SYSTEM	118
ALUMINIUM SLIDING FLYSCREEN SYSTEM	137



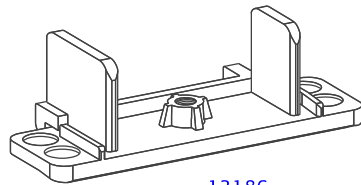
Technical documents are subject to change without notice



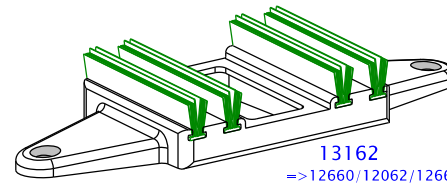
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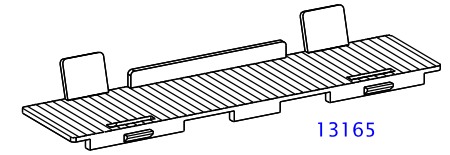
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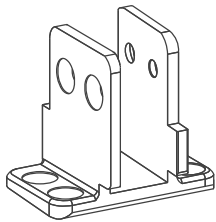
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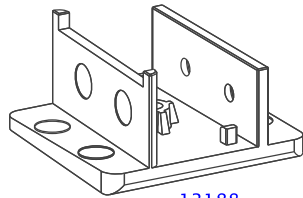
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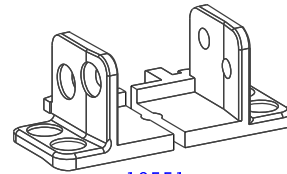
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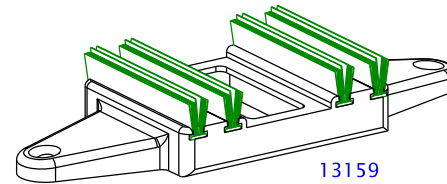
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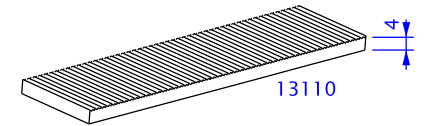
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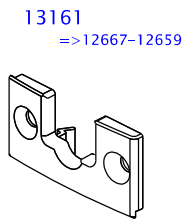
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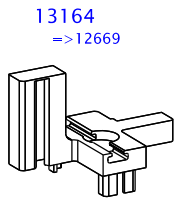
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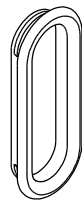
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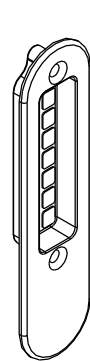
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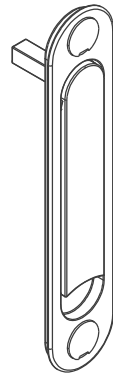
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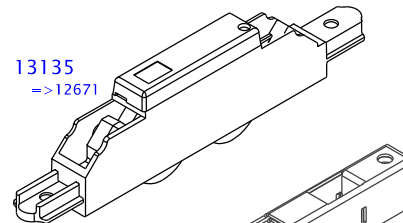
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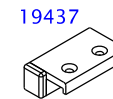
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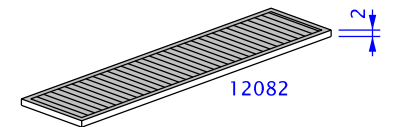
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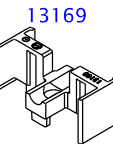
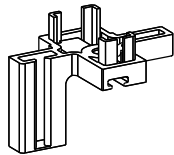
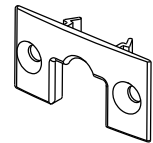
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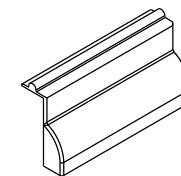
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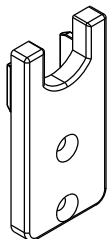
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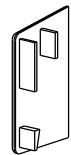
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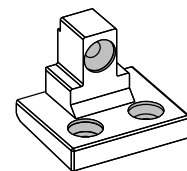
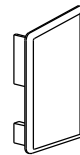
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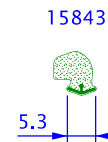
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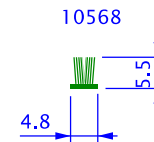
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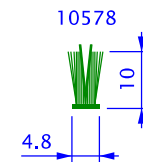
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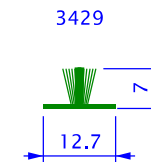
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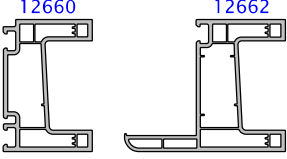

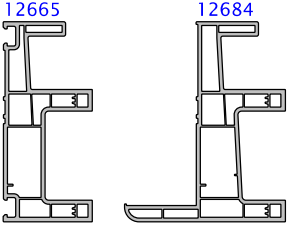

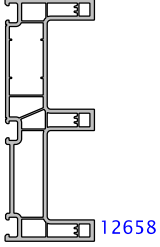

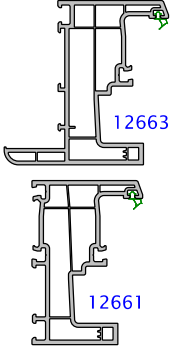


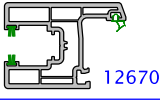

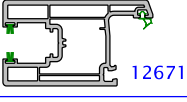

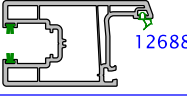

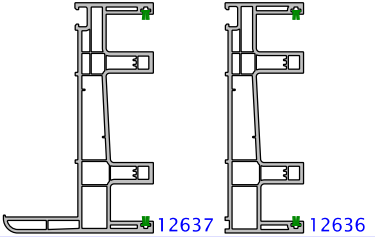





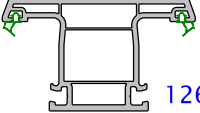


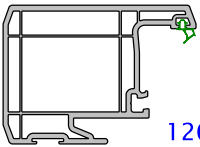


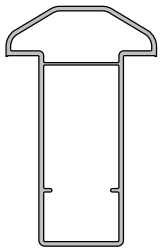

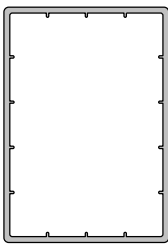
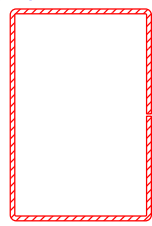
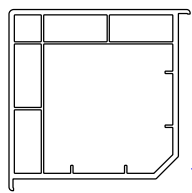
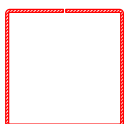
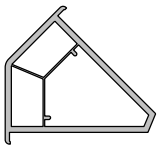
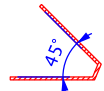
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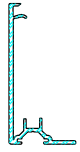
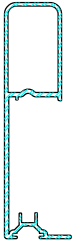
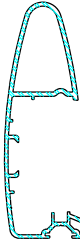
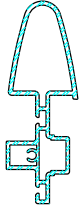
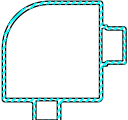
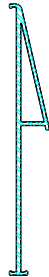




12958

GLAZING THICKNESS (mm)		GLAZING BEADS	DETAILS
4 mm			
8 mm			
16 mm			
17 mm			
20 mm			
24 mm			
28 mm			

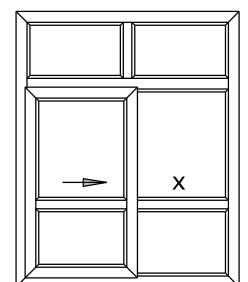
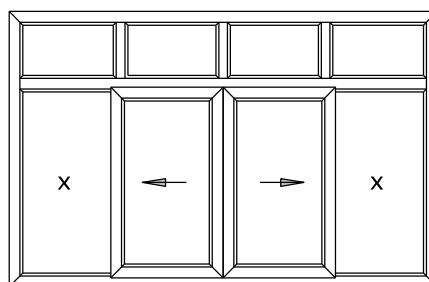
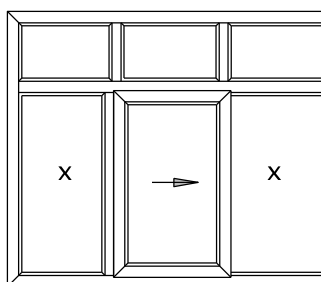
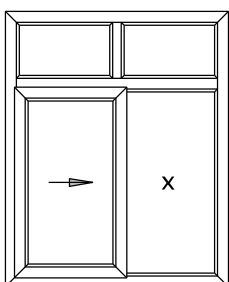
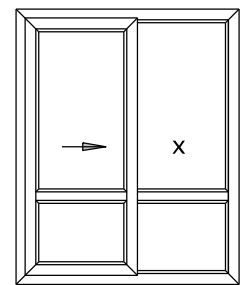
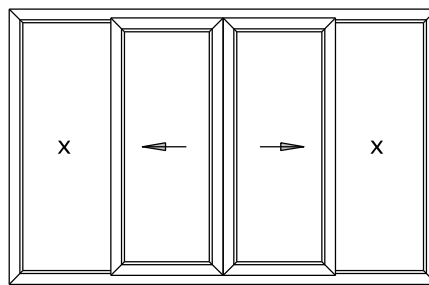
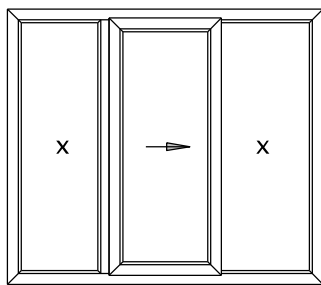
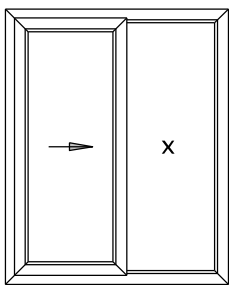
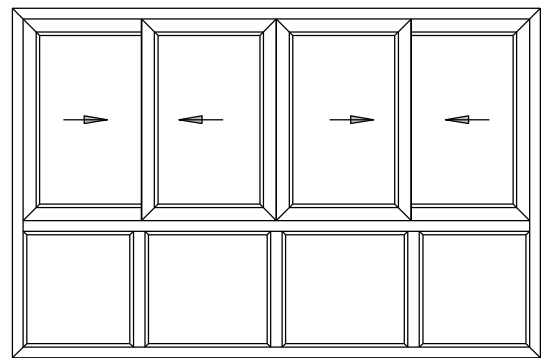
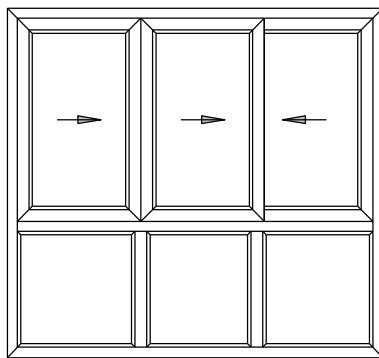
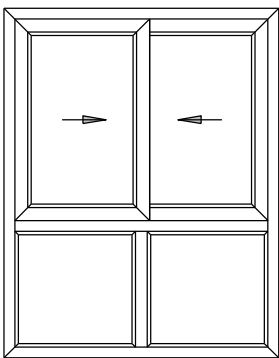
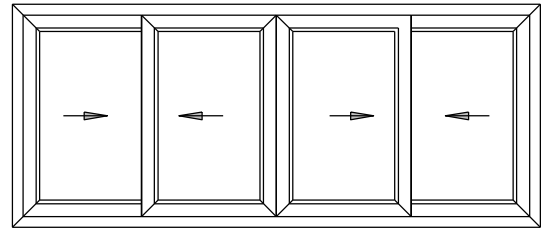
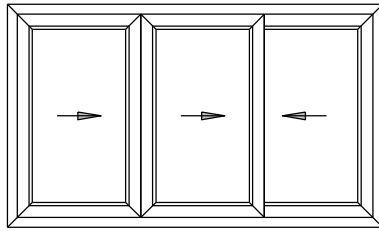
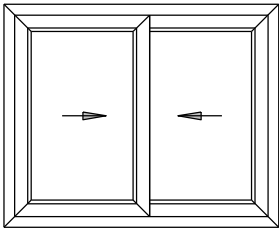
PVC	Reinforcement	Dimension	Ix (cm ⁴)	Iy (cm ⁴)
	13060 	17.5x30.5x1 89.28 (mm ³)	1.11	0.47
	11460 	17.5x30.5x1.5 130.28 (mm ³)	1.55	0.64
	13066 	15x37x1 97.28 (mm ³)	1.63	0.40
	13061 	17x12x59x9x17x1.2 128.77 (mm ³)	5.37	0.24
	11461 	17x12x59x9x17x1.5 158.78 (mm ³)	6.52	0.28
	13062 	13x29x18.5x1.5 81.56 (mm ³)	0.99	0.21
	13063 	26x29x32x2 163.42 (mm ³)	2.31	1.49
	13081 	30.5x41x30.5x5 303.47 (mm ³)	8.38	2.84
	13079 	10.5x37x10.5x11x1.2 76.00 (mm ³)	1.31	0.11
	12989 	11x27.4x2 129.10 (mm ³)	0.99	0.22

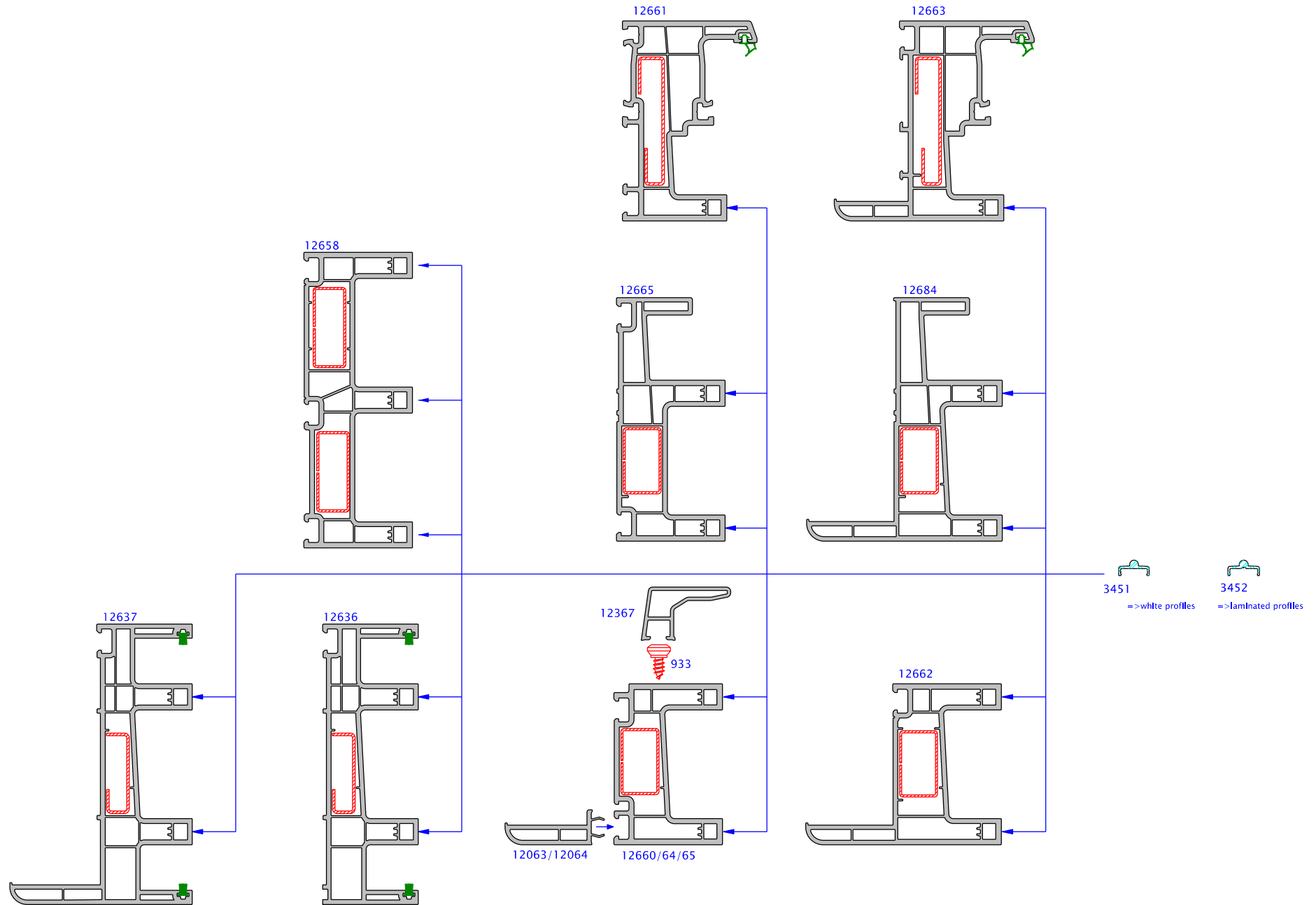
PVC	Reinforcement	Dimension	I _x (cm ⁴)	I _y (cm ⁴)
 12672	13064 	20.5x27x20.5x1.2 77.58 (mm ³)	0.34	0.95
	11462 	20.5x27x1.5 128.78 (mm ³)	0.83	1.29
 12673	13065 	30x40x1.2 159.37 (mm ³)	2.35	3.68
	11456 	30x40x2 256.85 (mm ³)	3.62	5.62
 12354	12936 	50x30x50x14x14x1.2 183.37 (mm ³)	6.31	2.85
 12433	12948 	60x90x60x44x44x2 576.84 (mm ³)	35.69	66.26
 12352	12937 	50x50x50x24.5x24.5x1.2 230.77 (mm ³)	9.09	9.16
 12353	12988 	32x7.2x38.6x1.2 92.70 (mm ³)	0.97	0.95

PVC	Dimension	Ix (cm ⁴)	Iy (cm ⁴)
 13650	28.5x60.2x1.8 178.93 (mm ³)	7.09	0.94
 13651	28.5x101x1.8 363.85 (mm ³)	41.48	3.21
 13040	49.6x101x1.5 432.20 (mm ³)	49.84	7.14
 13041	30.53x86.7x1.5 430.83 (mm ³)	25.09	3.03
 13051	53x52.2x1.4 296.97 (mm ³)	8.58	9.00
 13676	17.8x116x1.8 313.85 (mm ³)	34.40	0.40
 13677	17.3x140x1.8 394.19 (mm ³)	60.01	0.82
 19608	27x53x1.2 243.91 (mm ³)	6.17	1.19

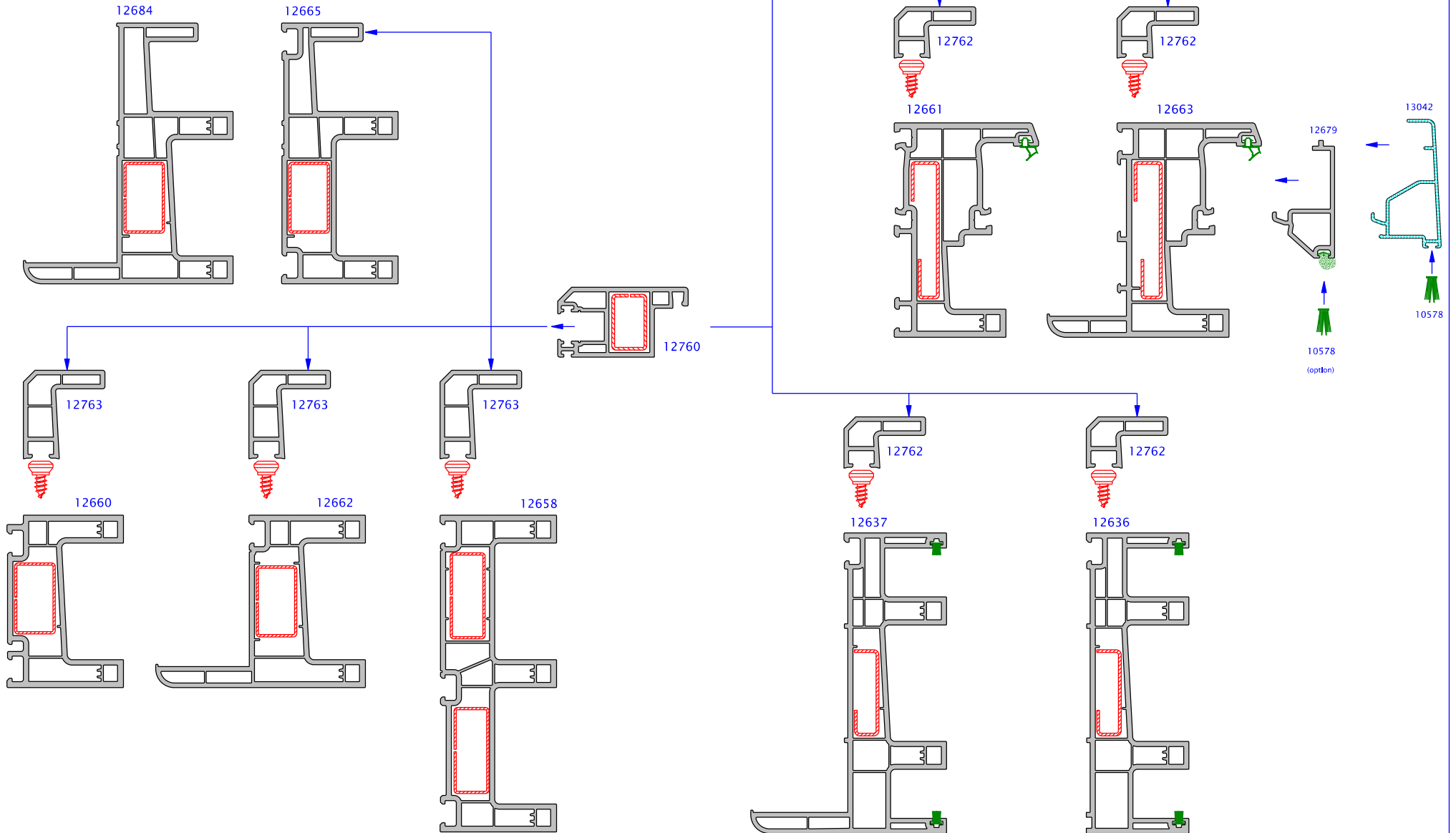
* Sliding door cannot be made with 12670 Sliding Window Sash.

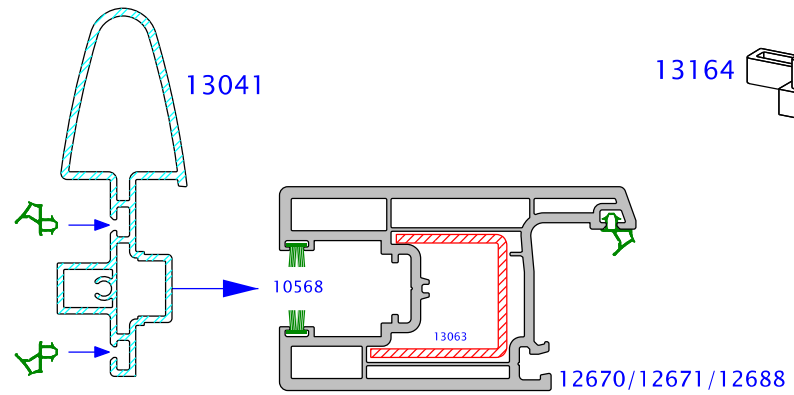
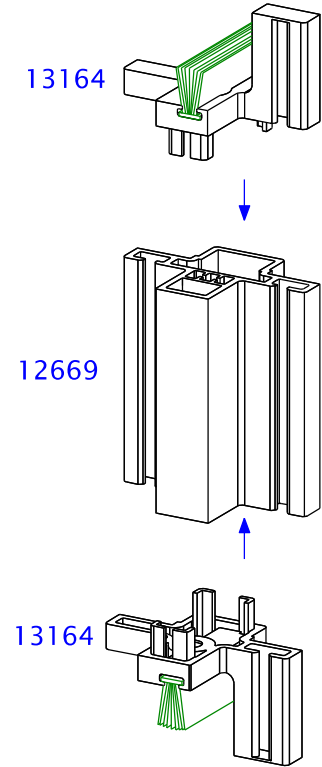
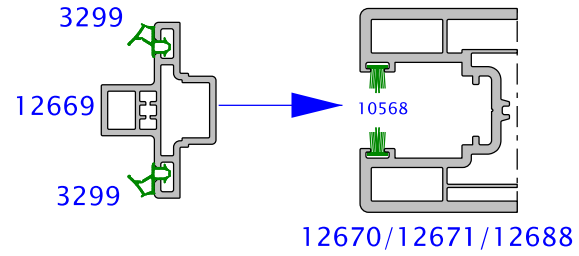
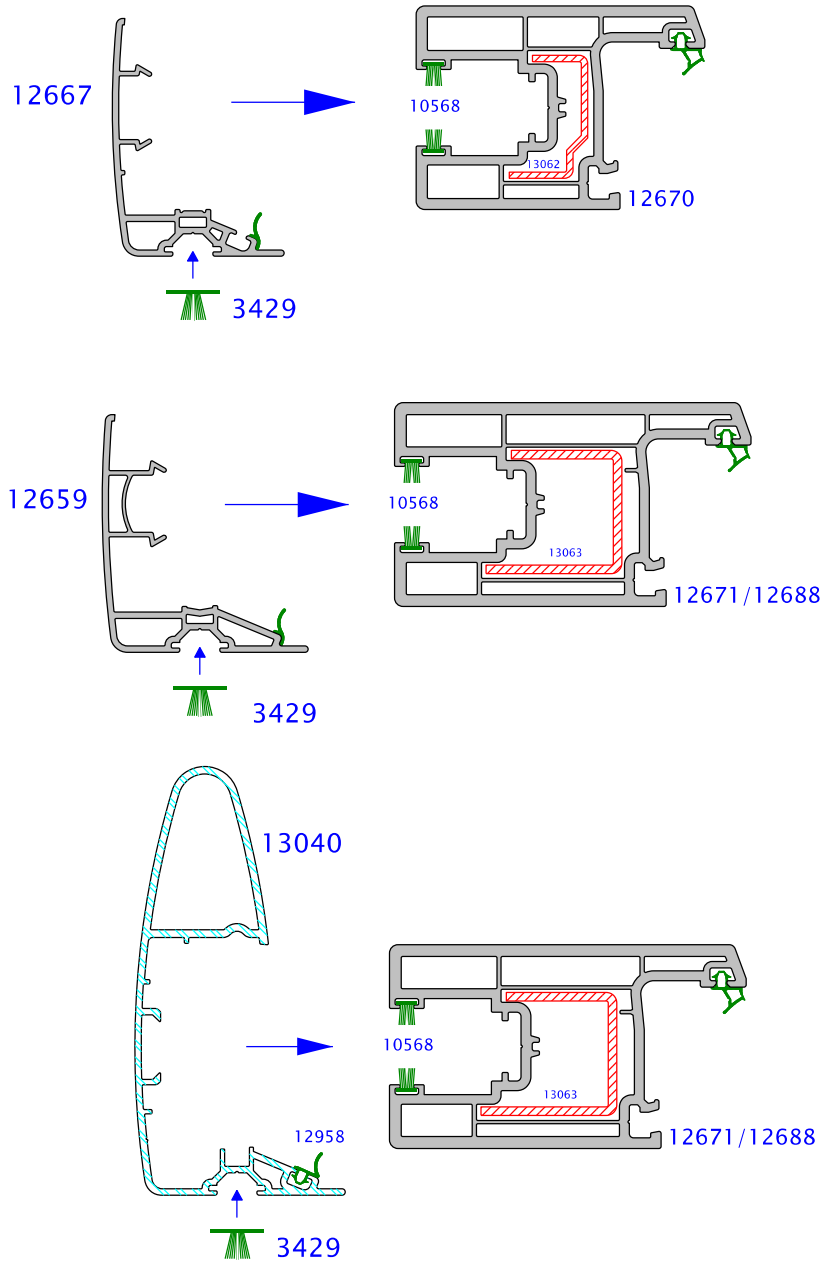
* The frame height of the window made with 12670 Sliding Window Sash is maximum 1500 mm.



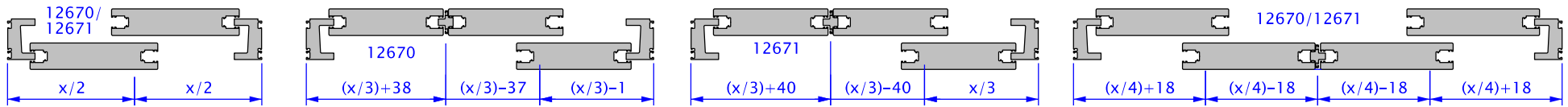


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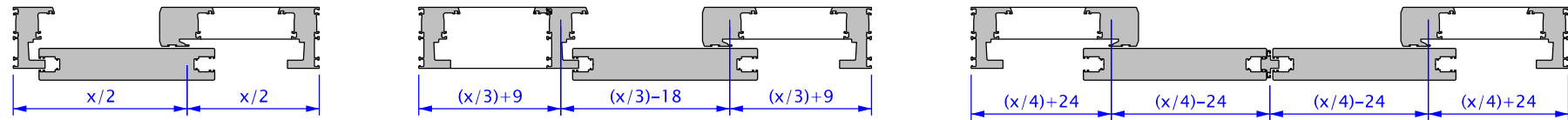
Axe Calculation : In the application of 12660,vertical axes should be determined as shown below.



The sash overlap is 9 mm.

Welding thickness is included	Dimension			Cross-section diagrams										
	Diagram 1	Diagram 2	Diagram 3	Diagram 4	Diagram 5	Diagram 6	Diagram 7	Diagram 8	Diagram 9	Diagram 10	Diagram 11	Diagram 12	Diagram 13	
Cutting Sliding Frame	x+6	x+6	x+6	-	-	-	-	-	-	-	-	-	-	
12660														
Cutting Sliding Window Sash	$\frac{x-2}{2}$	$\frac{x-6}{3}$	$\frac{x+68}{4}$	x-76	x-51	x-26	-	-	-	-	-	-	-	
12670														
Glass Sliding Window Sash	$\frac{x-226}{2}$	$\frac{x-342}{3}$	$\frac{x-380}{4}$	x-188	x-163	x-138	-	-	-	-	-	-	-	
12670														
Cutting Sliding Sash	$\frac{x+14}{2}$	$\frac{x+10}{3}$	$\frac{x+100}{4}$	x-76	x-51	x-26	-	-	-	-	-	-	-	
12671														
Glass Sliding Sash	$\frac{x-274}{2}$	$\frac{x-422}{3}$	$\frac{x-476}{4}$	x-220	x-195	x-170	-	-	-	-	-	-	-	
12671														
Cutting Sliding Transom	$\frac{x-206}{2}$	$\frac{x-312}{3}$	$\frac{x-340}{4}$	-	-	-	x-110	x-85	x-105	-	-	-	-	
12672														
Glass Sliding Transom	$\frac{x-226}{2}$	$\frac{x-342}{3}$	$\frac{x-380}{4}$	-	-	-	x-120	x-95	x-115	x-96	x-52	-	-	
12672														
Cutting Sliding Transom	$\frac{x-254}{2}$	$\frac{x-392}{3}$	$\frac{x-436}{4}$	-	-	-	x-126	x-101	-	-	-	-	-	
12672														
Glass Sliding Transom	$\frac{x-274}{2}$	$\frac{x-422}{3}$	$\frac{x-476}{4}$	-	-	-	x-136	x-111	-	-	-	-	-	
12672														
Cutting Sliding Frame(Transom)	-	-	-	x-60	-	-	-	-	-	-	-	-	-	
12660														
Glass Sliding Frame(Transom)	-	-	-	x-140	-	-	-	-	-	-	-	-	-	
12660														
Cutting Sliding Frame fix Adp.	-	-	-	x-100	-	-	-	-	-	x-75	-	-	-	
12666														

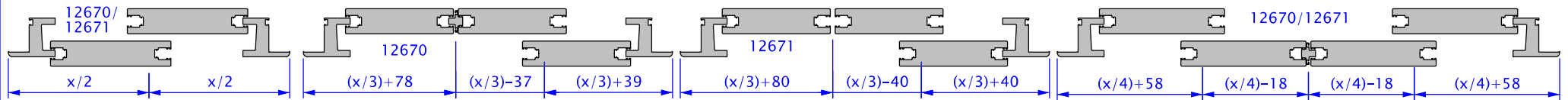
Axe Calculation : In the application of three and four sashes with 12661, vertical axes should be determined as shown below. Then, cutting and glass dimensions are calculated as shown in the table



Note: 12670 Sliding window sash is not used in these applications (12661). The sash overlap is 9 mm.

Dimension	Diagram 1 (2 sashes)			Diagram 2 (3 sashes)			Diagram 3 (4 sashes)					
Cutting Fixed Sliding Frame 12661	x_1+6	x_1+6	x_1+6	-	-	-	-	-	-	-	-	-
Cutting Sliding Sash 12671	$x+9$	$x+30$	$x+43$	$x-72$	$x-51$	-	-	-	-	-	-	-
Glass Sliding Sash 12671	$x-135$	$x-114$	$x-101$	$x-216$	$x-195$	-	-	-	-	-	-	-
Cutting Sliding Transom 12672	$x-125$	$x-104$	$x-91$	$x-84$	$x-63$	$x-63$	$x-63$	$x-63$	$x-63$	$x-42$	$x-124$	$x-103$
Glass Sliding Transom 12672	$x-135$	$x-114$	$x-101$	$x-94$	$x-73$	$x-73$	$x-73$	$x-73$	$x-73$	$x-52$	$x-134$	$x-113$
Cutting Sliding Vertical Transom 12673	-	-	-	$x-84$	$x-63$	-	-	-	-	-	-	-
Glass Sliding Vertical Transom 12673	-	-	-	$x-94$	$x-73$	-	-	-	-	-	-	-
Cutting Fixed Sli.Frame(Transom) 12661	-	-	-	$x-84$	$x-63$	-	-	-	-	-	-	-
Glass Fixed Sli.Frame(Transom) 12661	-	-	-	$x-94$	$x-73$	-	-	-	-	-	-	-
Cutting Glazing Bead 10mm 12648	-	-	-	$x-124$	$x-103$	-	-	-	-	-	-	-

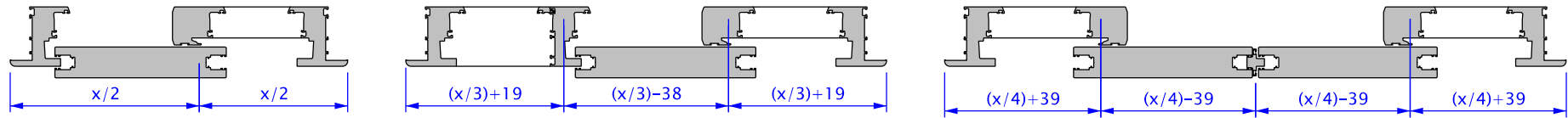
Axe Calculation : Use axe dimensions below to define the axes of vertical mullions if there is any fixed part on the top.



The sash overlap is 9 mm.

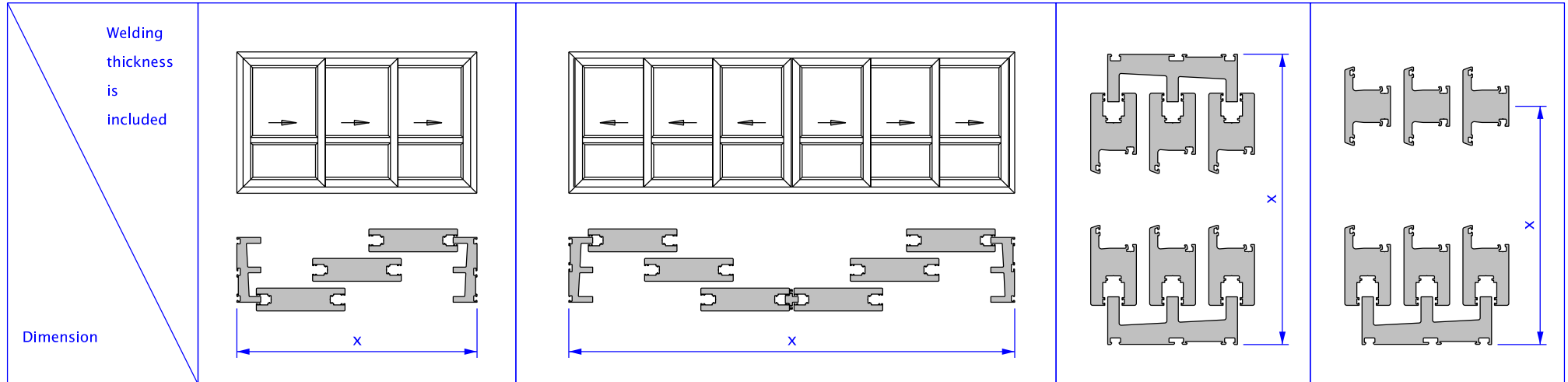
Welding thickness is included	Dimension			Cross-section diagrams with height dimension 'x'										
	Diagram 1	Diagram 2	Diagram 3	Diagram 4	Diagram 5	Diagram 6	Diagram 7	Diagram 8	Diagram 9	Diagram 10	Diagram 11	Diagram 12	Diagram 13	
Cutting Sliding Frame	$x+6$	$x+6$	$x+6$	-	-	-	-	-	-	-	-	-	-	
Cutting Sliding Window Sash	$\frac{x-82}{2}$	$\frac{x-86}{3}$	$\frac{x-12}{4}$	$x-156$	$x-91$	$x-26$	-	-	-	-	-	-	-	
Glass Sliding Window Sash	$\frac{x-306}{2}$	$\frac{x-422}{3}$	$\frac{x-460}{4}$	$x-268$	$x-203$	$x-138$	-	-	-	-	-	-	-	
Cutting Sliding Sash	$\frac{x-66}{2}$	$\frac{x-70}{3}$	$\frac{x+20}{4}$	$x-156$	$x-91$	$x-26$	-	-	-	-	-	-	-	
Glass Sliding Sash	$\frac{x-354}{2}$	$\frac{x-502}{3}$	$\frac{x-556}{4}$	$x-300$	$x-235$	$x-170$	-	-	-	-	-	-	-	
Cutting Sliding Transom	$\frac{x-286}{2}$	$\frac{x-392}{3}$	$\frac{x-420}{4}$	-	-	-	$x-150$	$x-85$	$x-145$	-	-	-	-	
Glass Sliding Transom	$\frac{x-306}{2}$	$\frac{x-422}{3}$	$\frac{x-460}{4}$	-	-	-	$x-160$	$x-95$	$x-155$	$x-136$	$x-52$	-	-	
Cutting Sliding Transom	$\frac{x-334}{2}$	$\frac{x-472}{3}$	$\frac{x-516}{4}$	-	-	-	$x-166$	$x-101$	-	-	-	-	-	
Glass Sliding Transom	$\frac{x-354}{2}$	$\frac{x-502}{3}$	$\frac{x-556}{4}$	-	-	-	$x-176$	$x-111$	-	-	-	-	-	
Cutting Sliding Frame(Transom)	-	-	-	$x-140$	-	-	-	-	-	-	-	-	-	
Glass Sliding Frame(Transom)	-	-	-	$x-220$	-	-	-	-	-	-	-	-	-	
Cutting Sliding Frame fix Adp.	-	-	-	$x-180$	-	-	-	-	-	$x-115$	-	-	-	

Axe Calculation : In the application of three and four sashes of 12663(Arch.frame),vertical axes should be determined as shown below. Cutting and glass dimensions are calculated as shown in the table



Note : Sliding window sash (12670) is not used in these applications (12663) The sash overlap is 9 mm.

Dimension	Welding thickness is included			Welding thickness is not included							
	Diagram 1	Diagram 2	Diagram 3	Diagram 4	Diagram 5	Diagram 6	Diagram 7	Diagram 8	Diagram 9	Diagram 10	Diagram 11
Cutting Fixed Sliding Arch. Frame 12663	x_1+6	x_1+6	x_1+6	-	-	-	-	-	-	-	-
Cutting Sliding Sash 12671	$x-21$	$x+30$	$x+43$	$x-132$	$x-81$	-	-	-	-	-	-
Glass Sliding Sash 12671	$x-165$	$x-114$	$x-101$	$x-276$	$x-225$	$x-93$	$x-93$	$x-93$	$x-42$	$x-154$	$x-103$
Cutting Sliding Transom 12672	$x-155$	$x-104$	$x-91$	$x-144$	$x-93$	$x-103$	$x-103$	$x-103$	$x-52$	$x-164$	$x-113$
Glass Sliding Transom 12672	$x-165$	$x-114$	$x-101$	$x-154$	$x-103$	-	-	-	-	-	-
Cutting Sliding Vertical Transom 12673	-	-	-	$x-144$	$x-93$	-	-	-	-	-	-
Glass Sliding Vertical Transom 12673	-	-	-	$x-154$	$x-103$	-	-	-	-	-	-
Cutting Fixed Sliding Frame(Transom) 12661	-	-	-	$x-144$	$x-93$	-	-	-	-	-	-
Glass Fixed Sliding Frame(Transom) 12661	-	-	-	$x-154$	$x-103$	-	-	-	-	-	-
Cutting Glazing Bead 10mm 12648	-	-	-	$x-184$	$x-133$	-	-	-	-	-	-



Welding thickness is included				
Dimension				
Cutting Sliding Frame	$x+6$	$x+6$	-	-
Cutting Sliding Window Sash	$\frac{x+72}{3}$	$\frac{x+216}{6}$	$x-76$	-
Glass Sliding Window Sash	$\frac{x-264}{3}$	$\frac{x-456}{6}$	$x-188$	-
Cutting Sliding Sash	$\frac{x+104}{3}$	$\frac{x+280}{6}$	$x-76$	-
Glass Sliding Sash	$\frac{x-328}{3}$	$\frac{x-584}{6}$	$x-220$	-
Cutting Sliding Transom	$\frac{x-234}{3}$	$\frac{x-396}{6}$	-	-
Glass Sliding Transom	$\frac{x-264}{3}$	$\frac{x-456}{6}$	-	$x-120$
Cutting Sliding Transom	$\frac{x-298}{3}$	$\frac{x-524}{6}$	-	-
Glass Sliding Transom	$\frac{x-328}{3}$	$\frac{x-584}{6}$	-	$x-136$

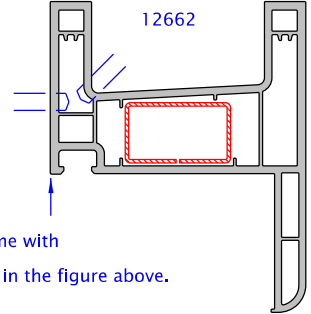
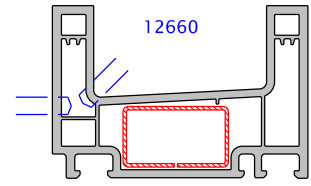
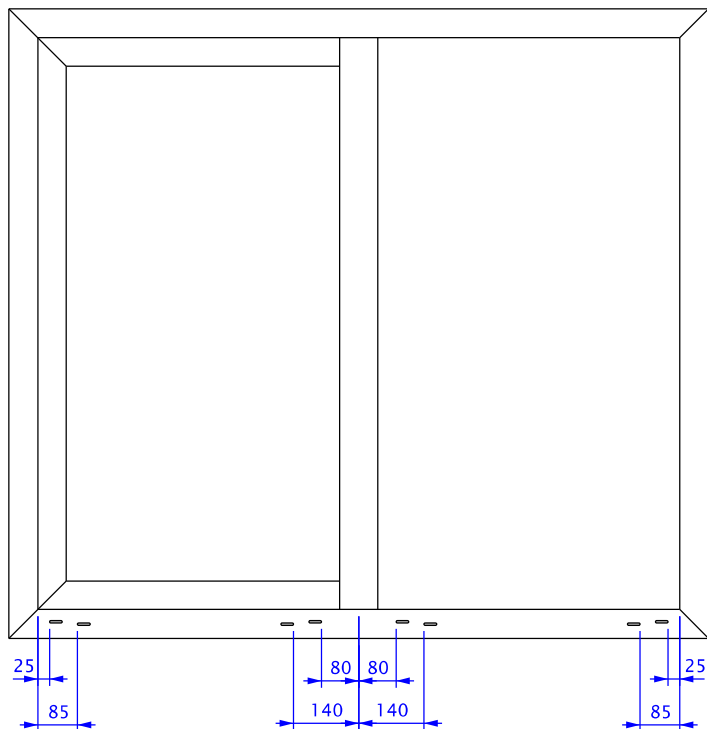
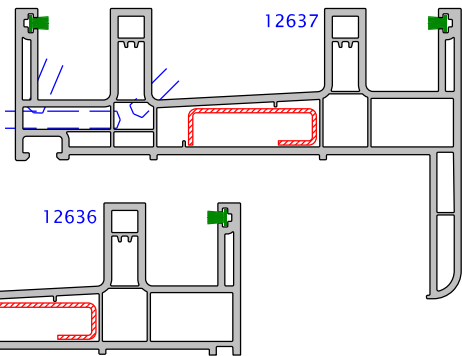
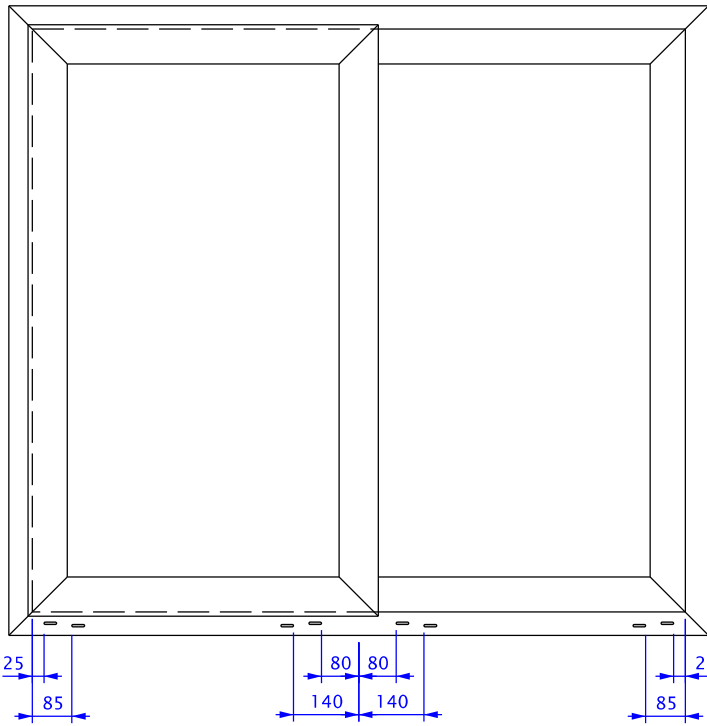
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The sash overlap is 9 mm.

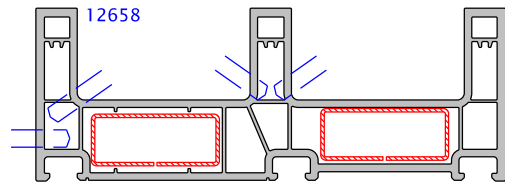
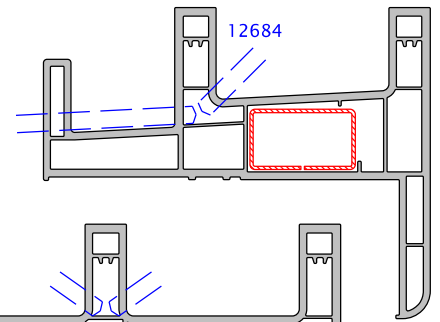
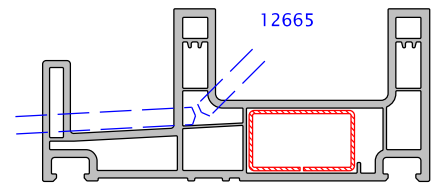
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Cutting Sliding Frame 12636	$x+6$	$x+6$	$x+6$	$x+6$
Cutting Sliding Sash 12671–12688	$\frac{x+26}{2}$	$\frac{x+22}{3}$	$\frac{x+112}{4}$	$x-64$
Glass Sliding Sash 12671–12688	$\frac{x-262}{2}$	$\frac{x-410}{3}$	$\frac{x-464}{4}$	$x-208$

The sash overlap is 9 mm.

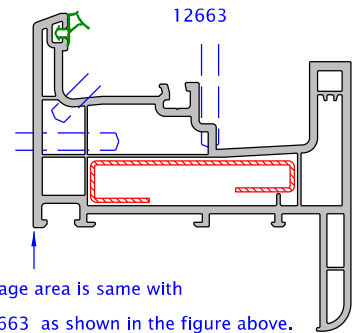
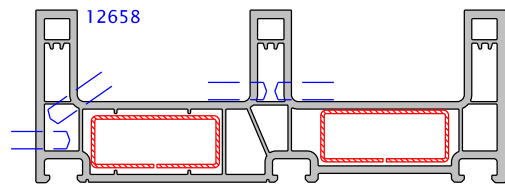
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Cutting Sliding Frame 12637	$x+6$	$x+6$	$x+6$	$x+6$
Cutting Sliding Sash 12671–12688	$\frac{x-54}{2}$	$\frac{x-58}{3}$	$\frac{x+32}{4}$	$x-144$
Glass Sliding Sash 12671–12688	$\frac{x-342}{2}$	$\frac{x-490}{3}$	$\frac{x-544}{4}$	$x-288$



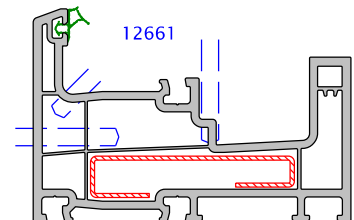
*The drainage area is same with 12661-12663 as shown in the figure above.

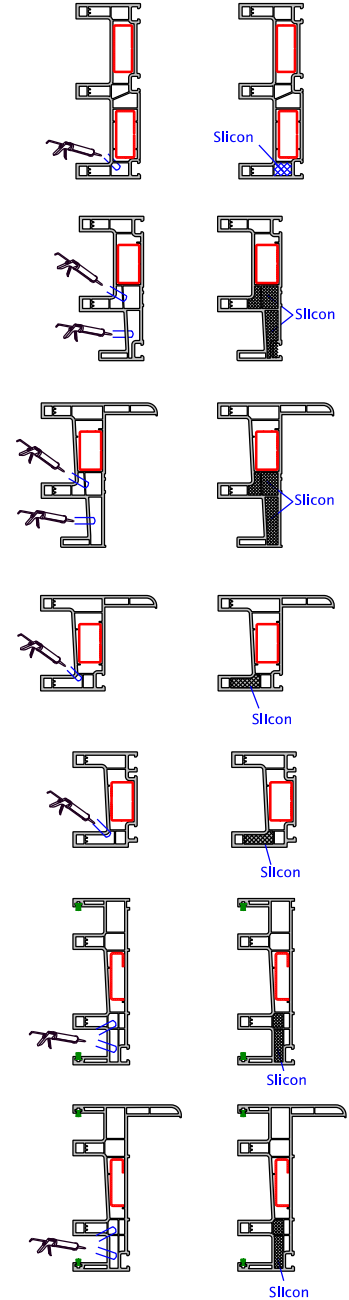
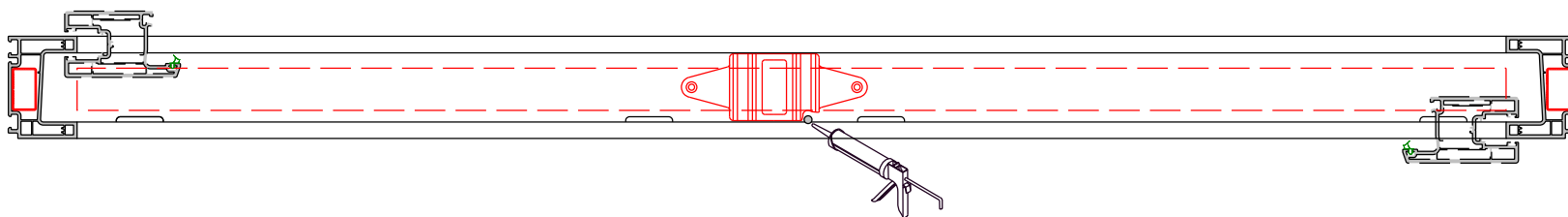
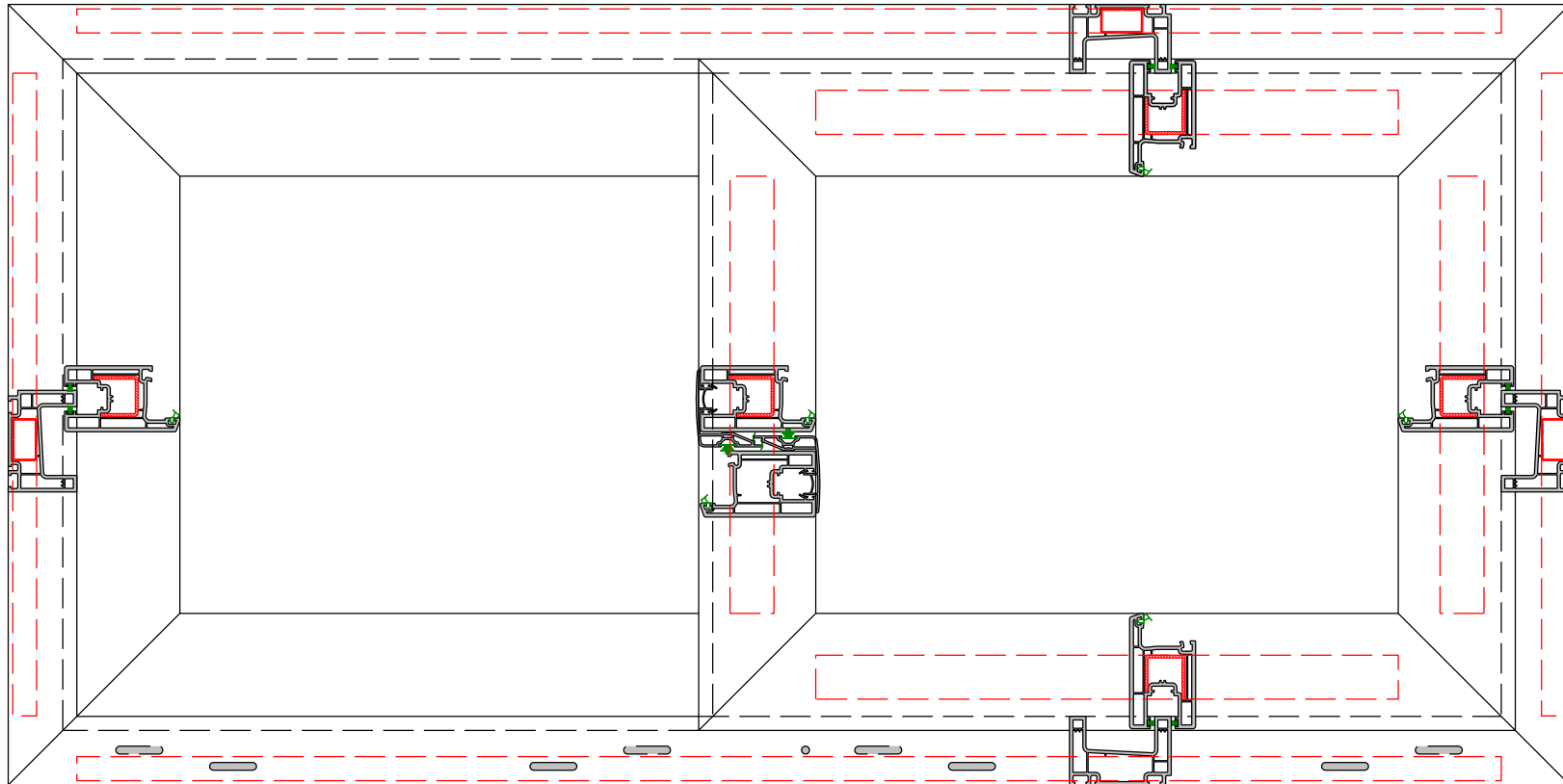
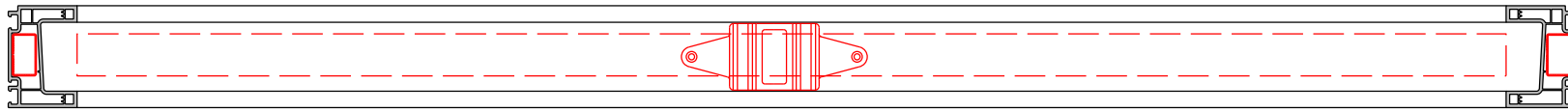


Drainage with punching method



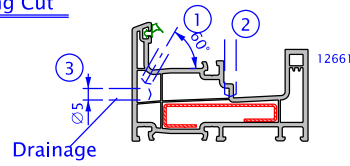
*The drainage area is same with 12661-12663 as shown in the figure above.





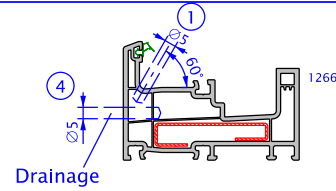
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Moving Cut

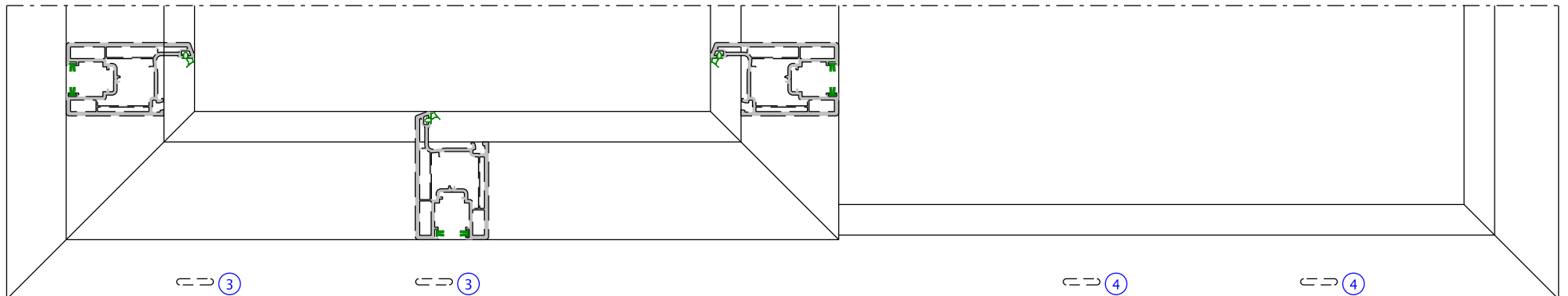
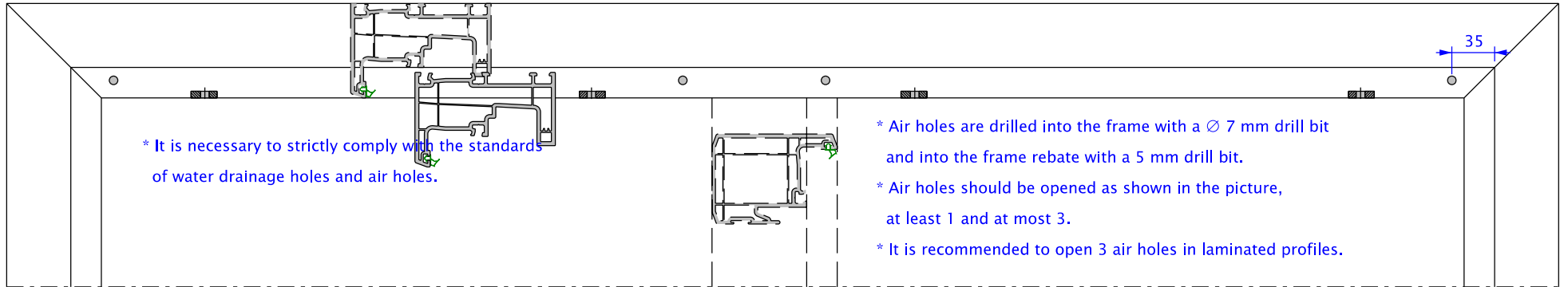
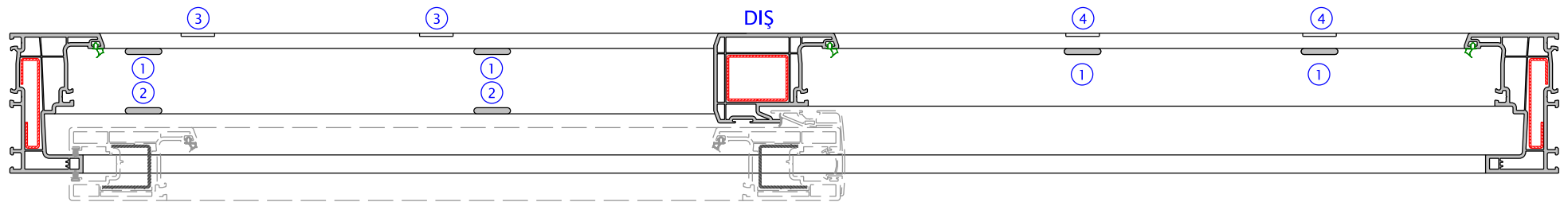


*Water drainage no. 3 (single feder) is drilled on the outside of the frame where the sliding wing is closed.

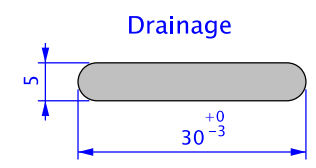
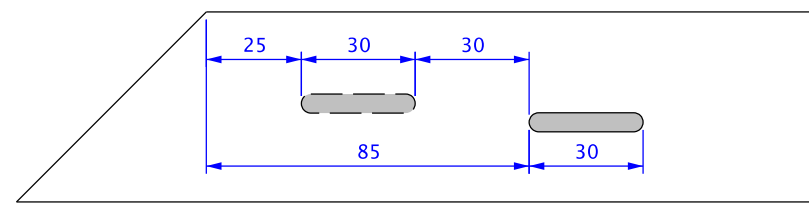
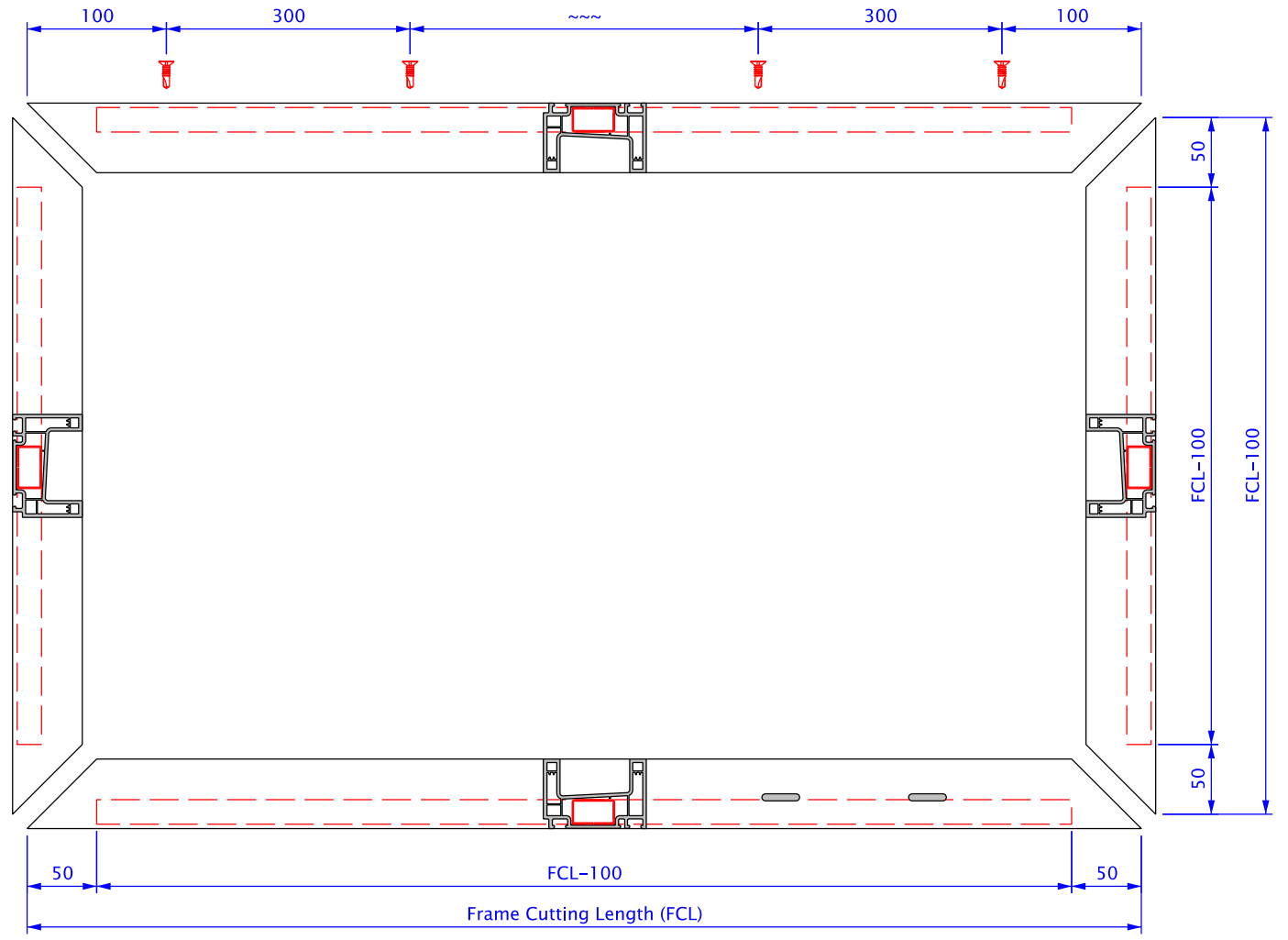
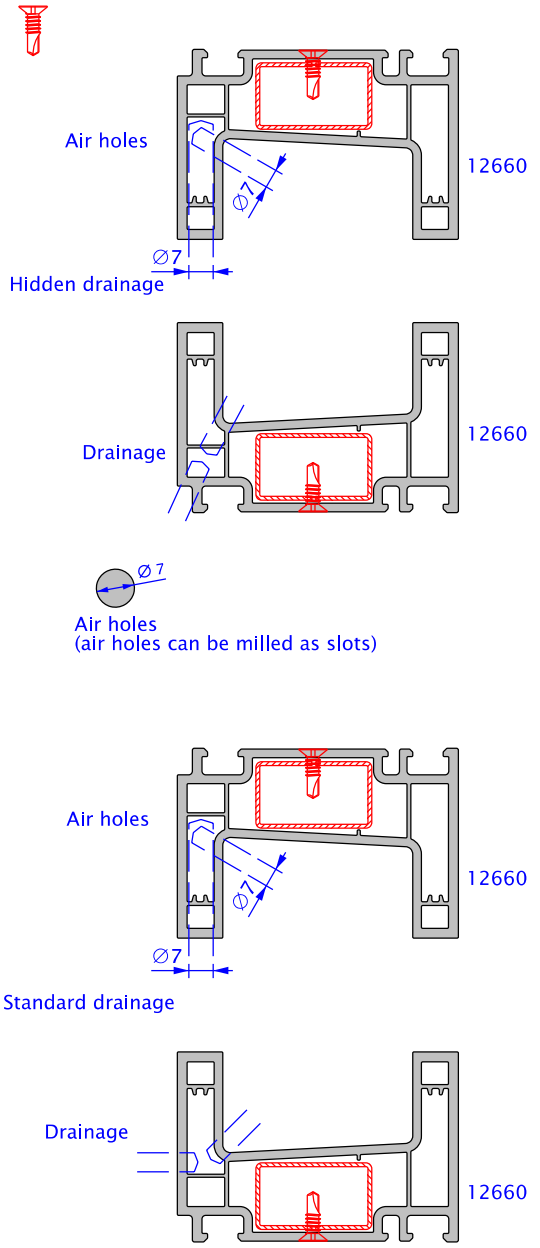
Fixed Side



*Water discharge hole no 4 (double feder) is drilled on the outside of the fixed side of the frame.

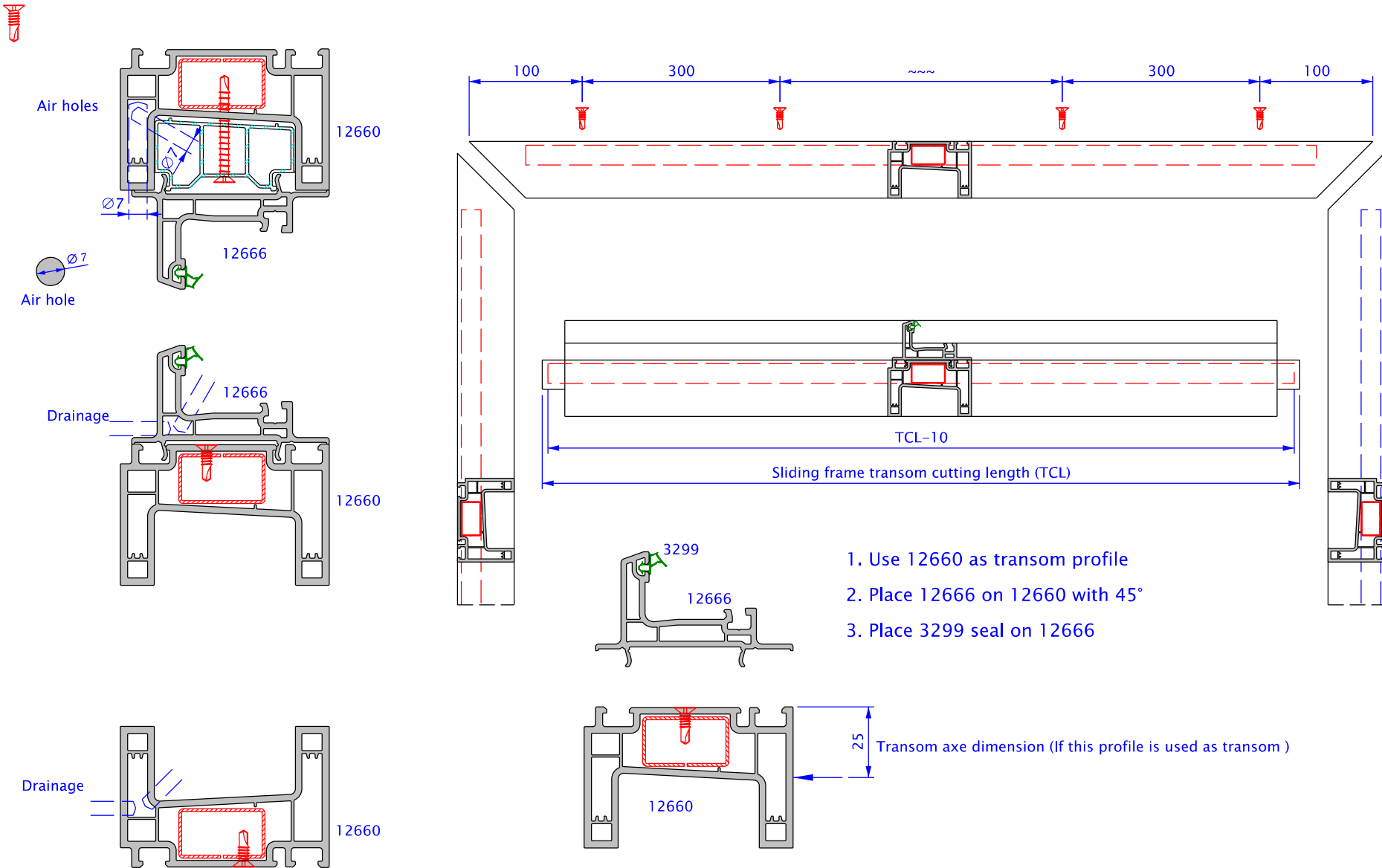


13001
3.9*13



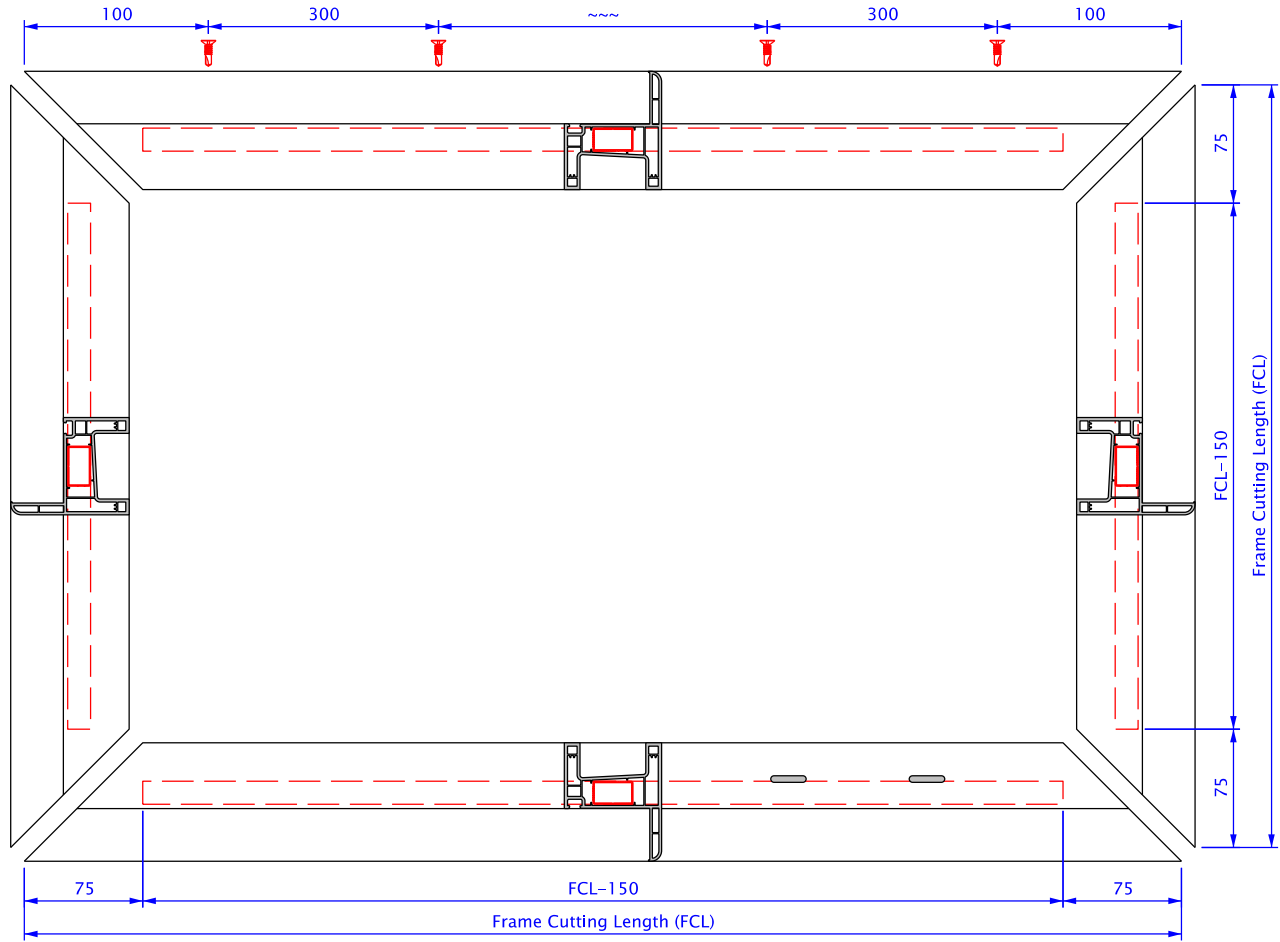
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13001
3.9*13



1. Use 12660 as transom profile
2. Place 12666 on 12660 with 45°
3. Place 3299 seal on 12666

13001
3.9*13



Air holes

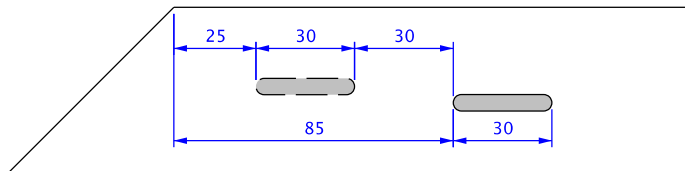
12662

Standard drainage

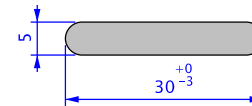
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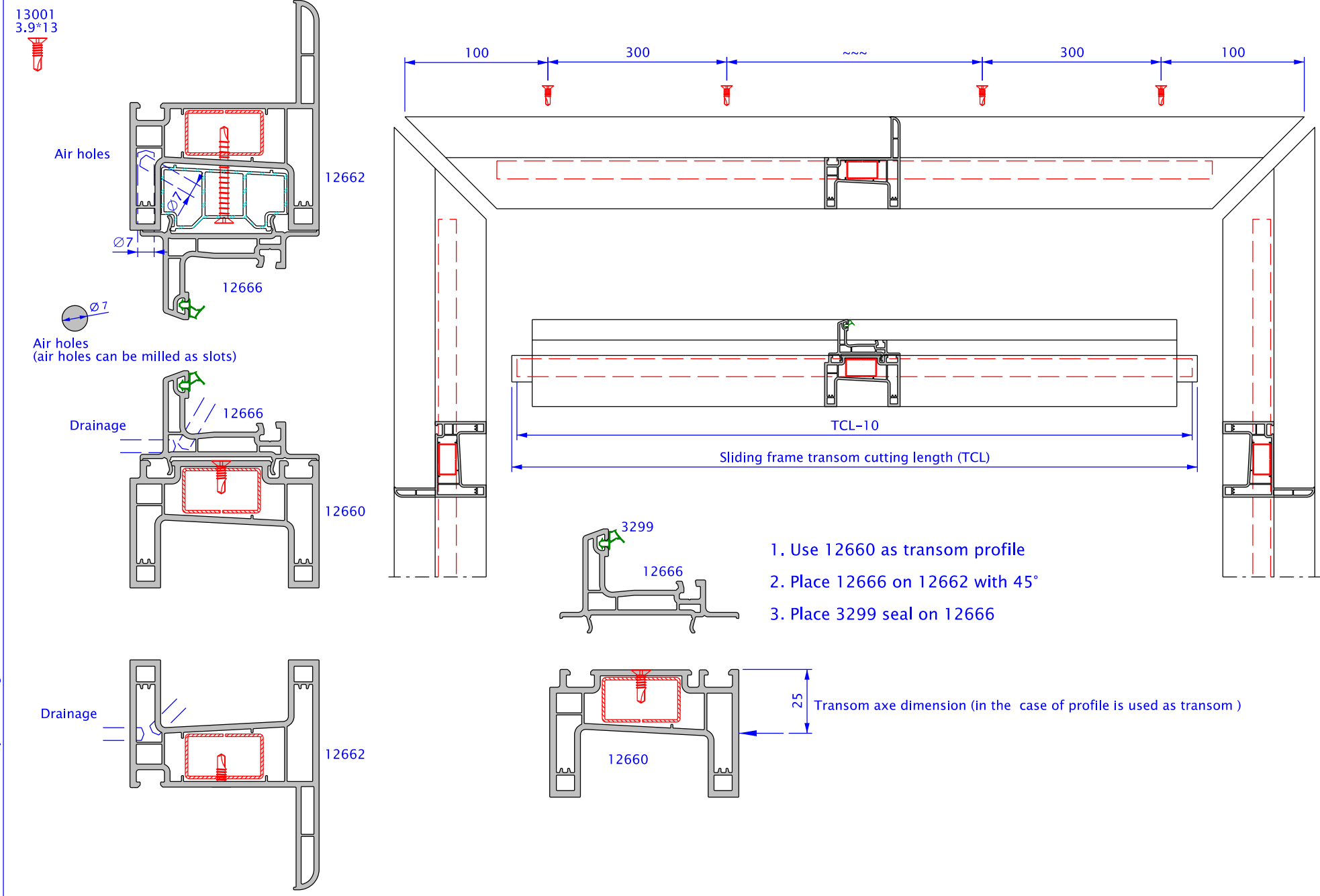
Drainage

12662

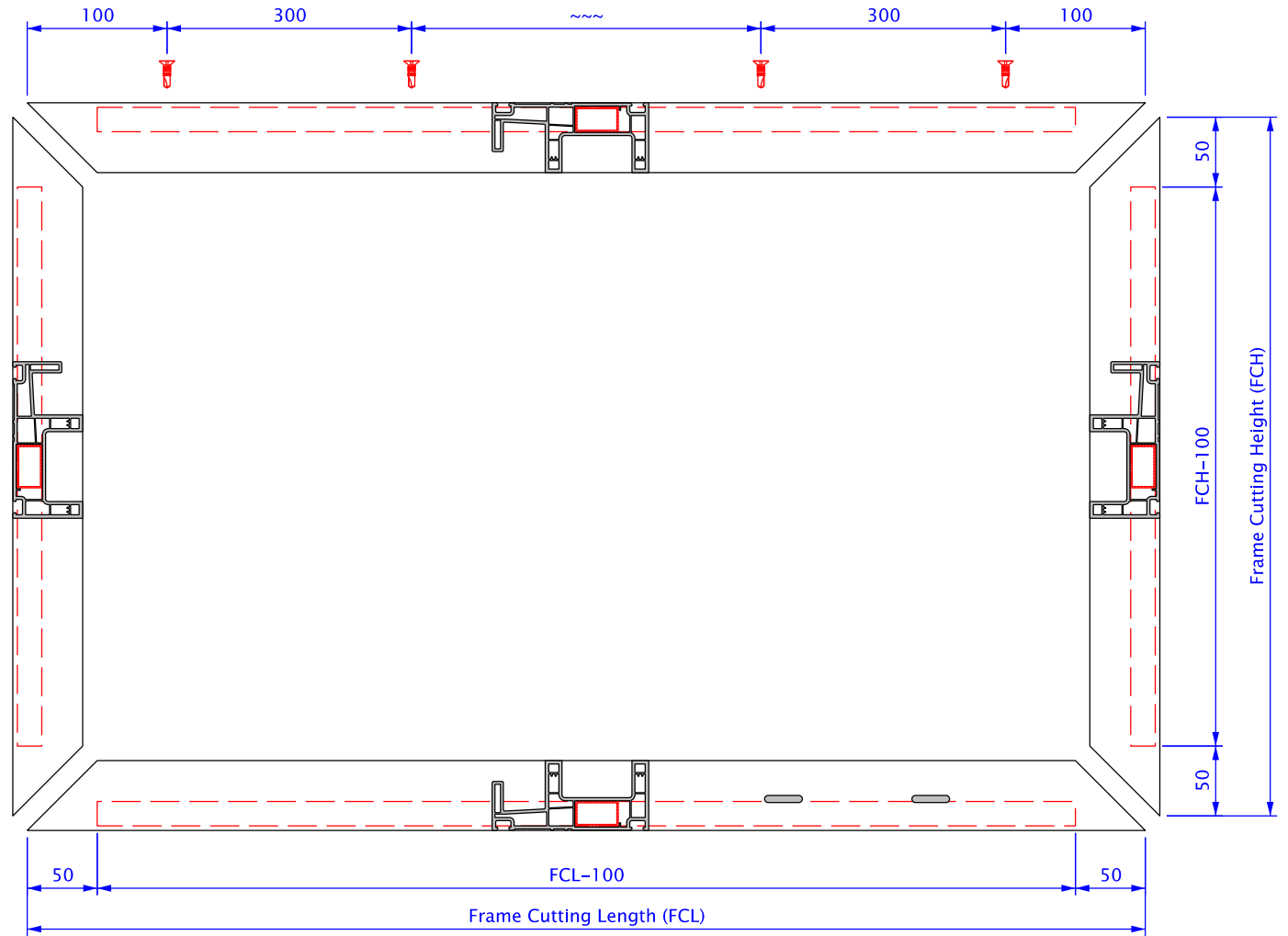
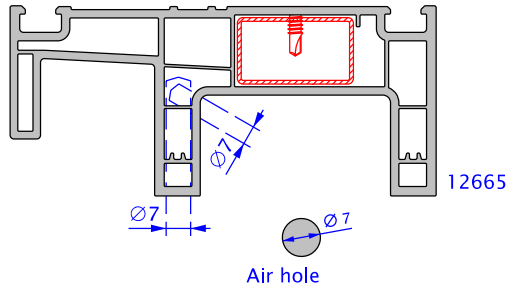


Drainage

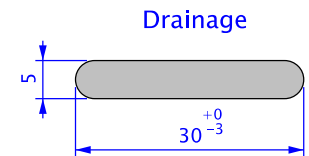
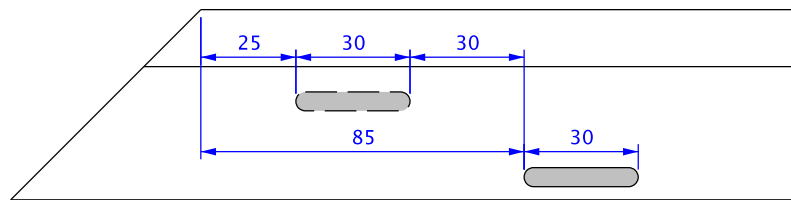
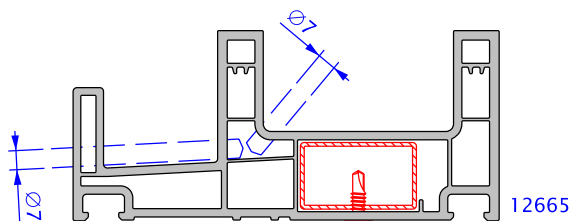




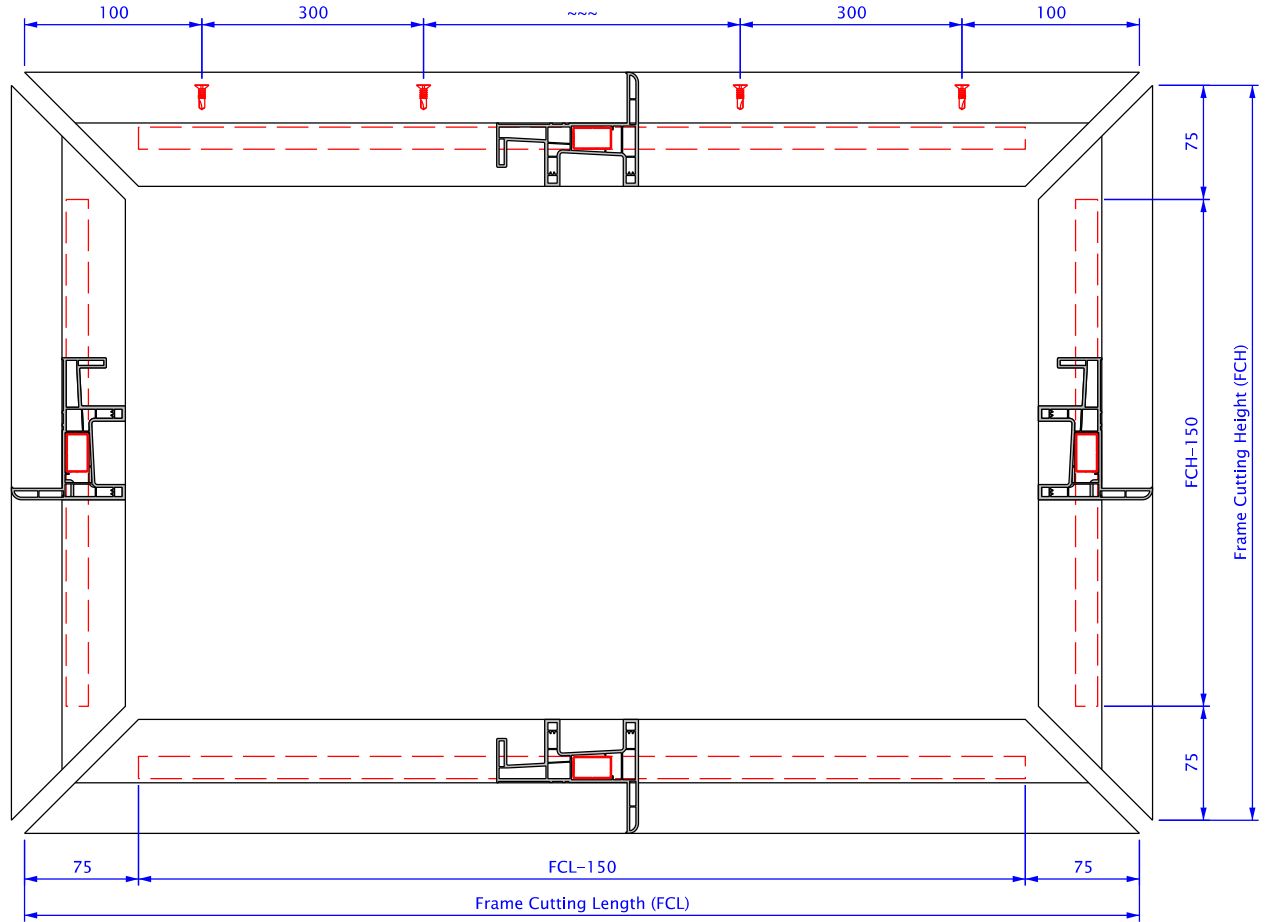
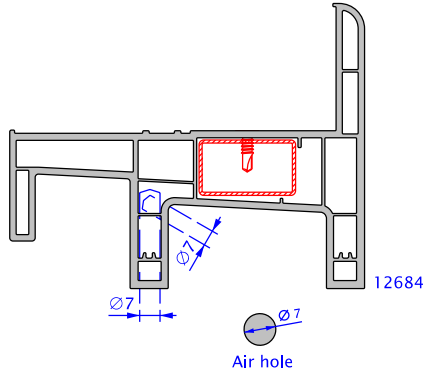
13001
3.9*13



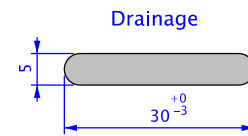
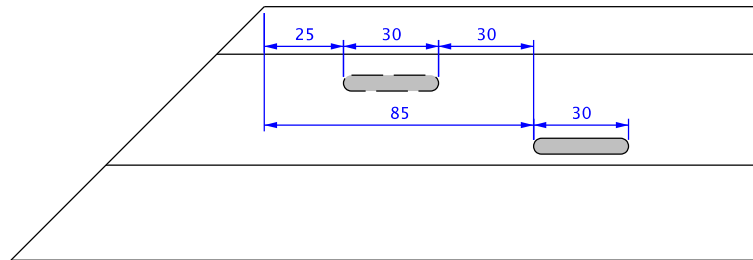
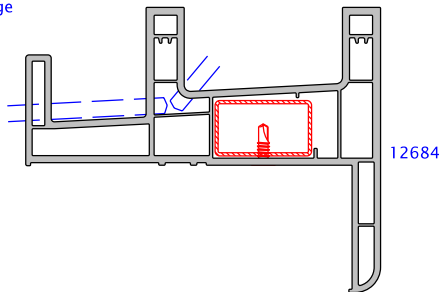
Drainage



13001
3.9*13



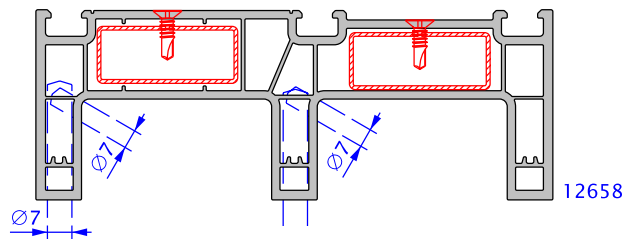
Drainage



13001
3.9*13



Air holes

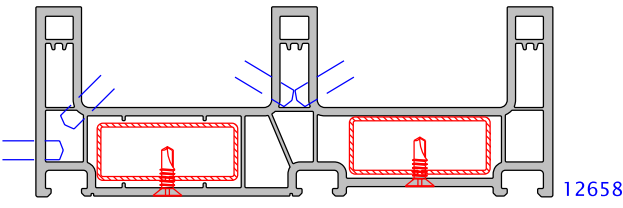


12658

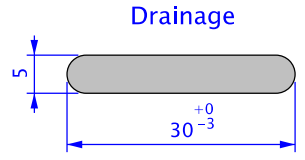
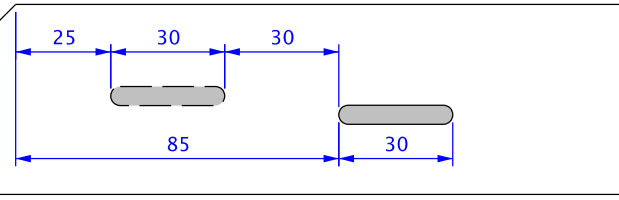
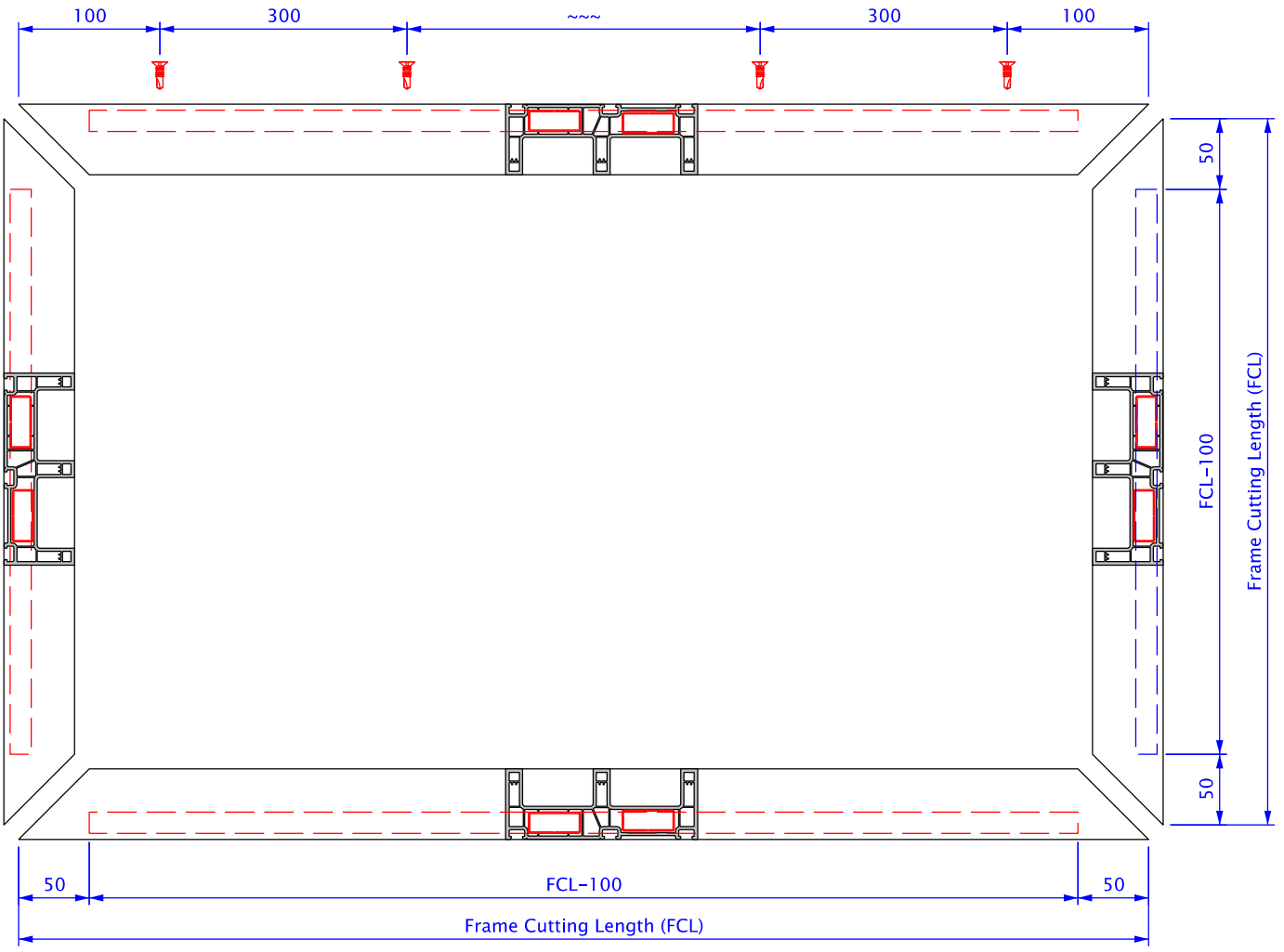
Air holes
(air holes can be milled as slots)



Drainage



12658

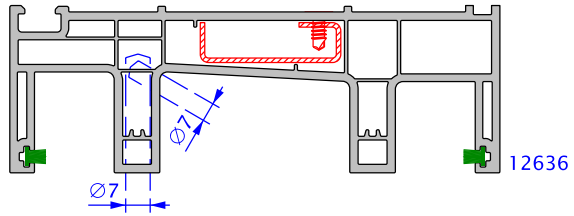


Technical documents are subject to change without notice

13001
3.9*13



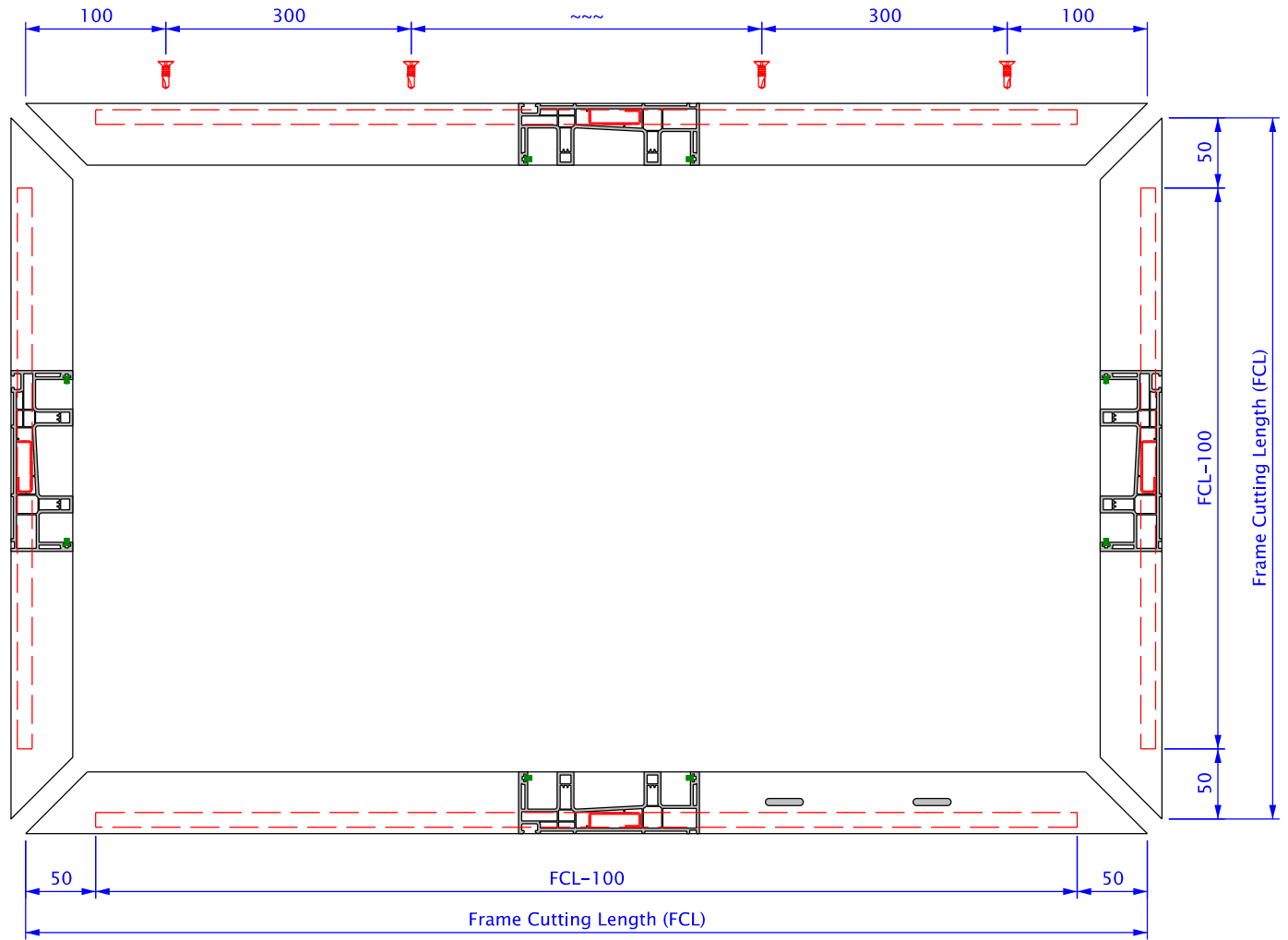
Air holes



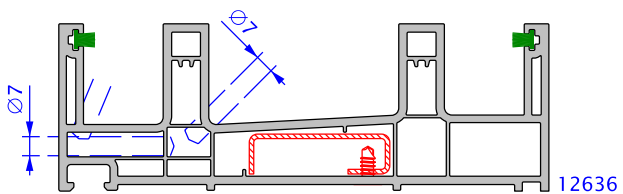
12636



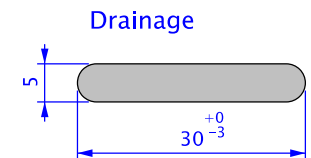
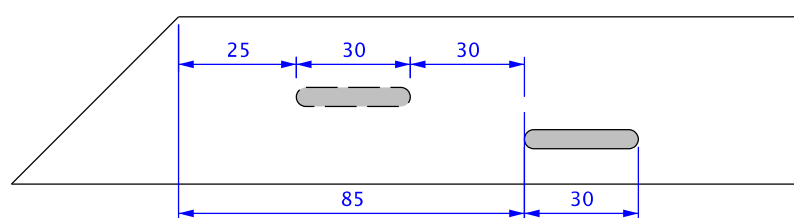
Air holes
(air holes can be milled as slots)



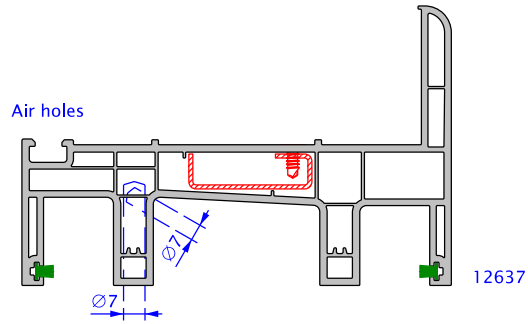
Drainage



12636



13001
3,9*13

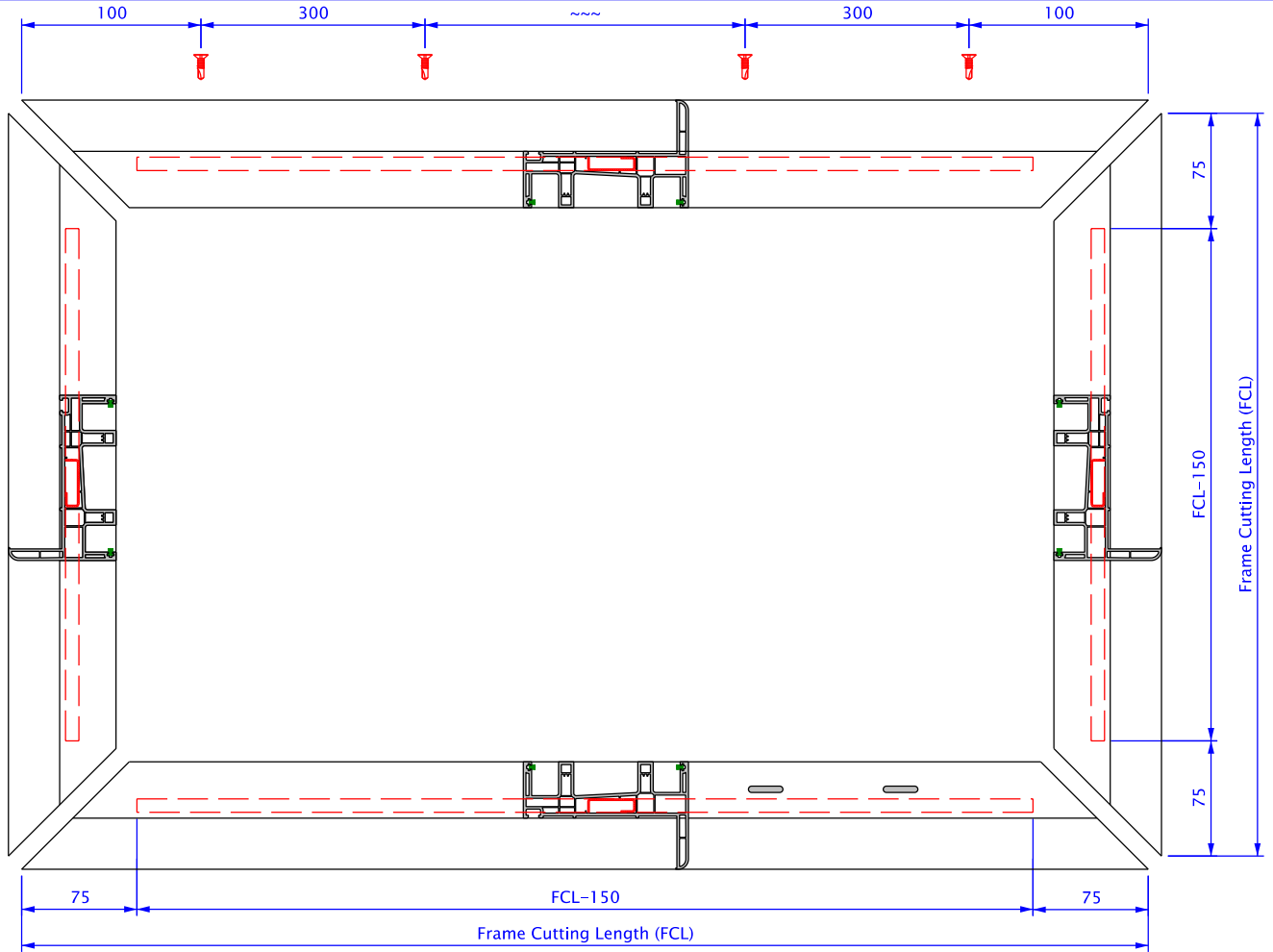


Air holes

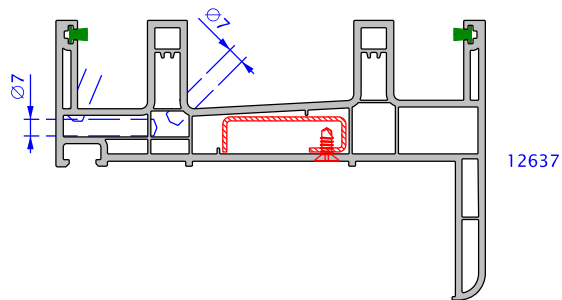
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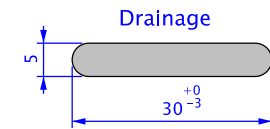
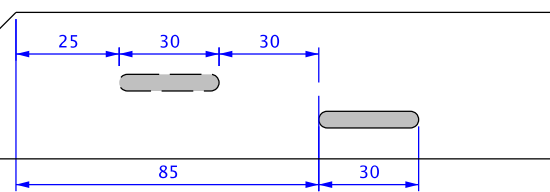
Air holes
(air holes can be milled as slots)



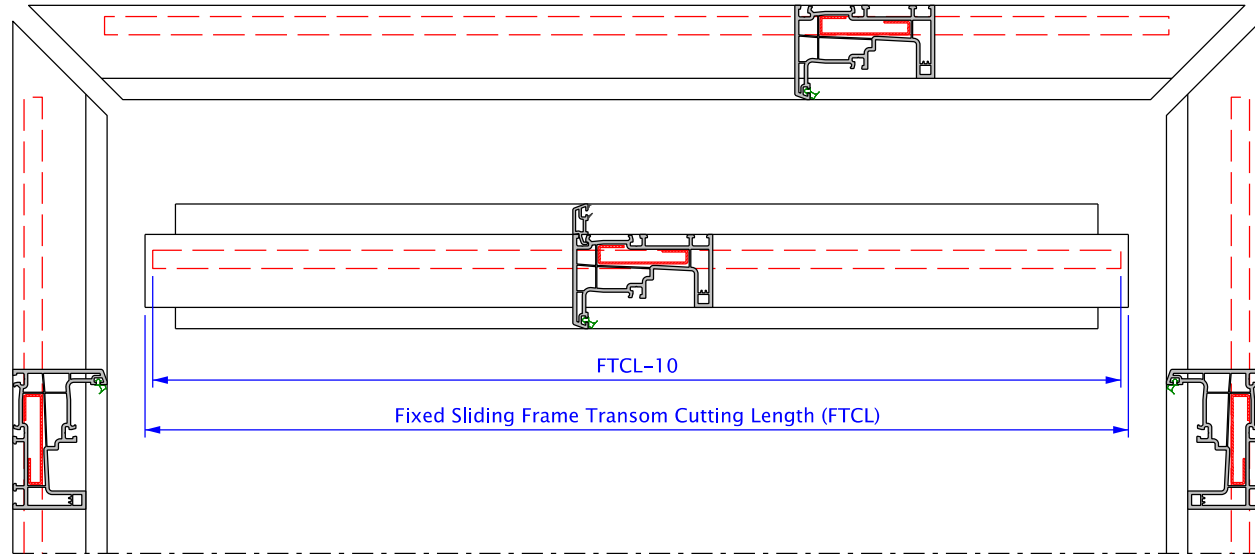
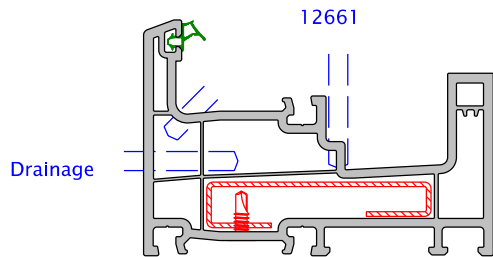
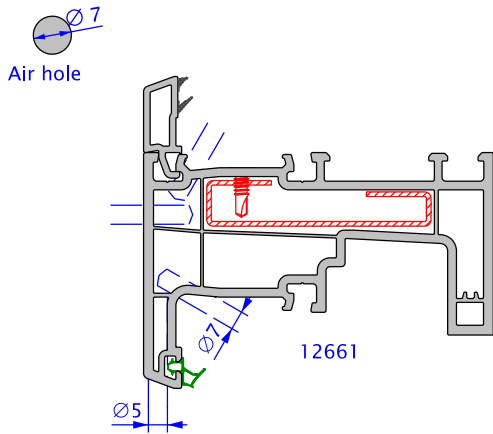
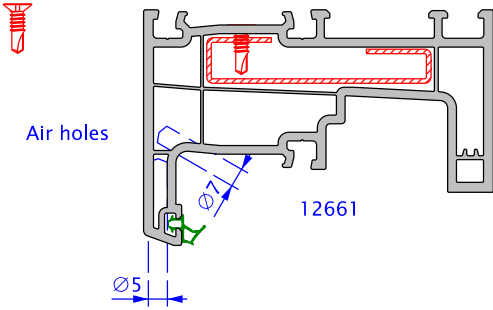
Drainage



12637



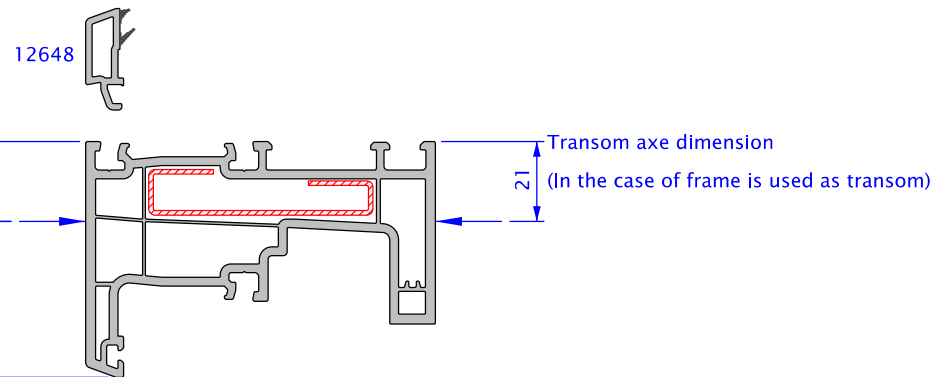
13001
3.9*13



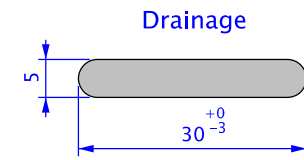
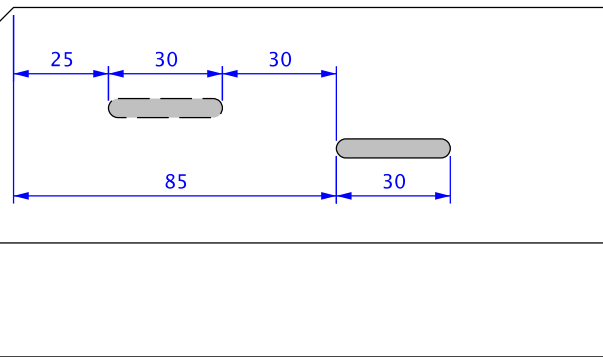
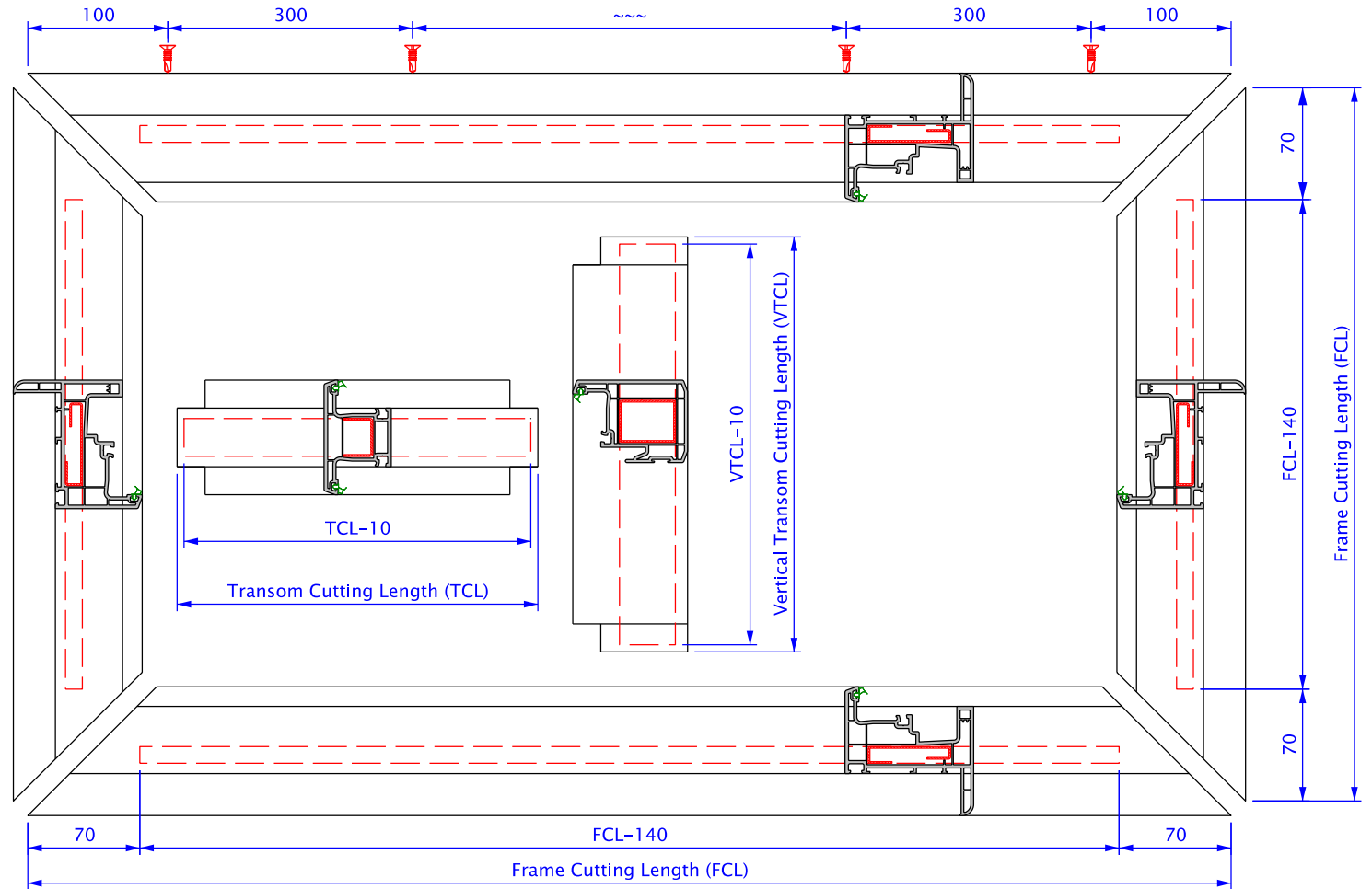
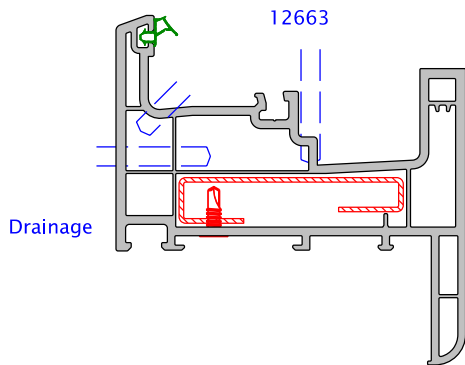
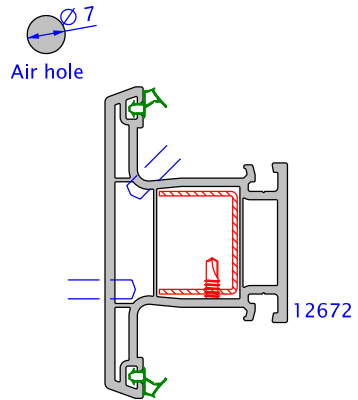
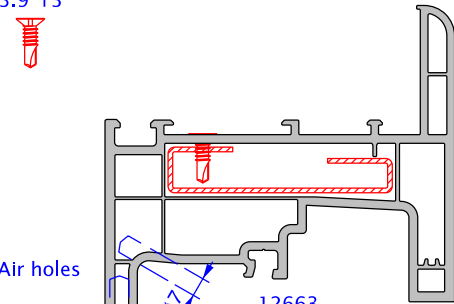
Preparing Transom with Glazing Bead

Alternative 1: After the placing the endmilled fixed sliding frame as transom glazing bead can be inserted.

Alternative 2: Glue together the glazing bead with fixed sliding frame as a transom and endmill them together. In this way, the glazing bead is also ready to size.



13001
3.9*13



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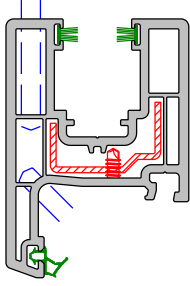
13001
3.9*13



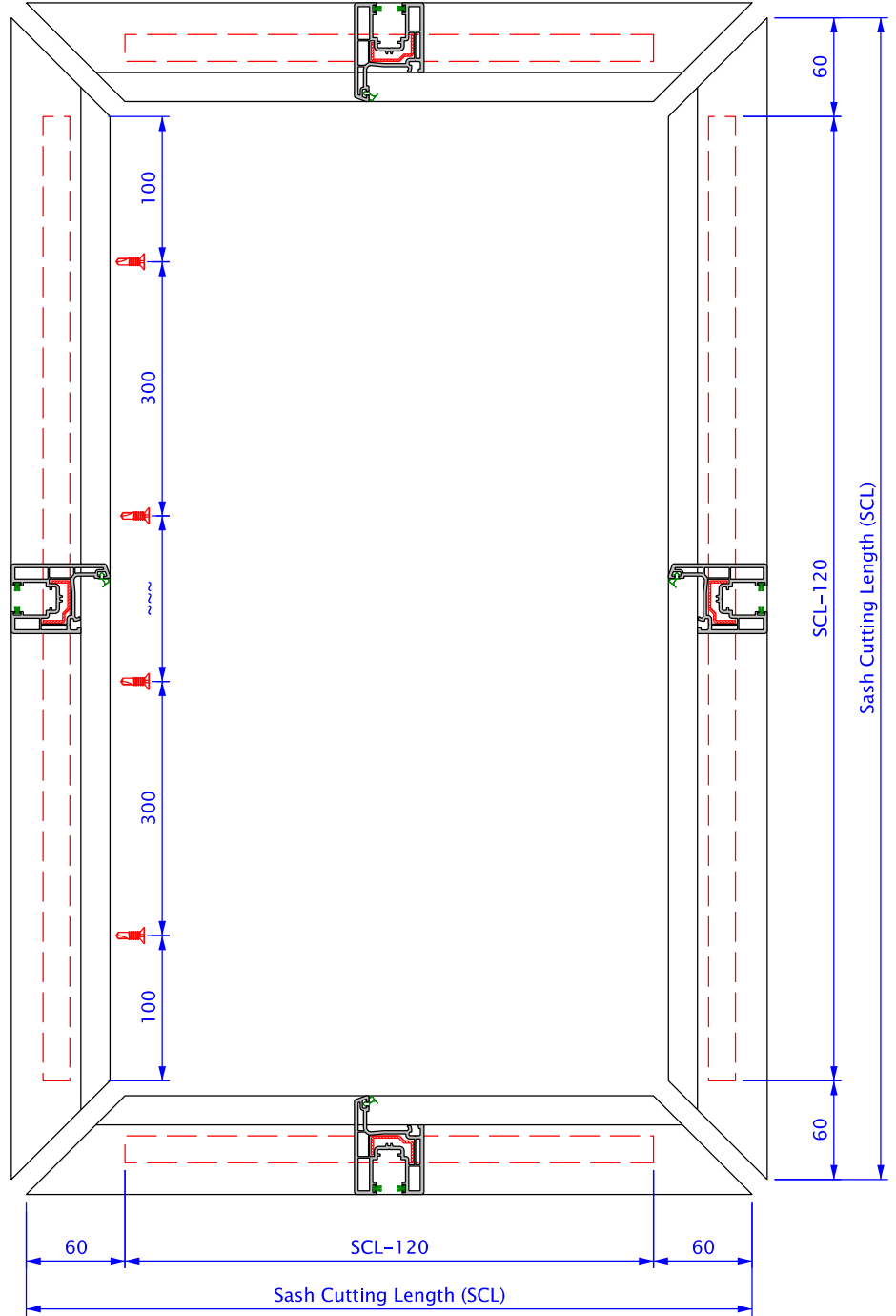
Ø 5

air holes
(air holes can be milled as slot)

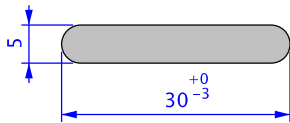
Air holes



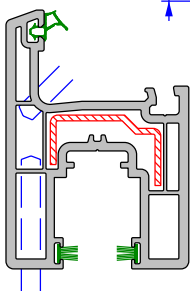
12670



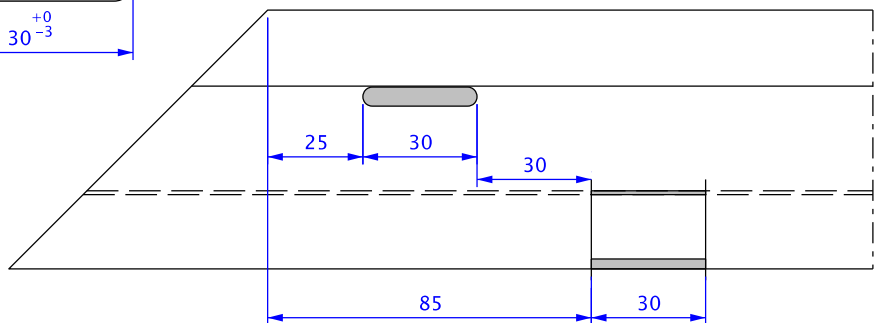
Drainage



Drainage

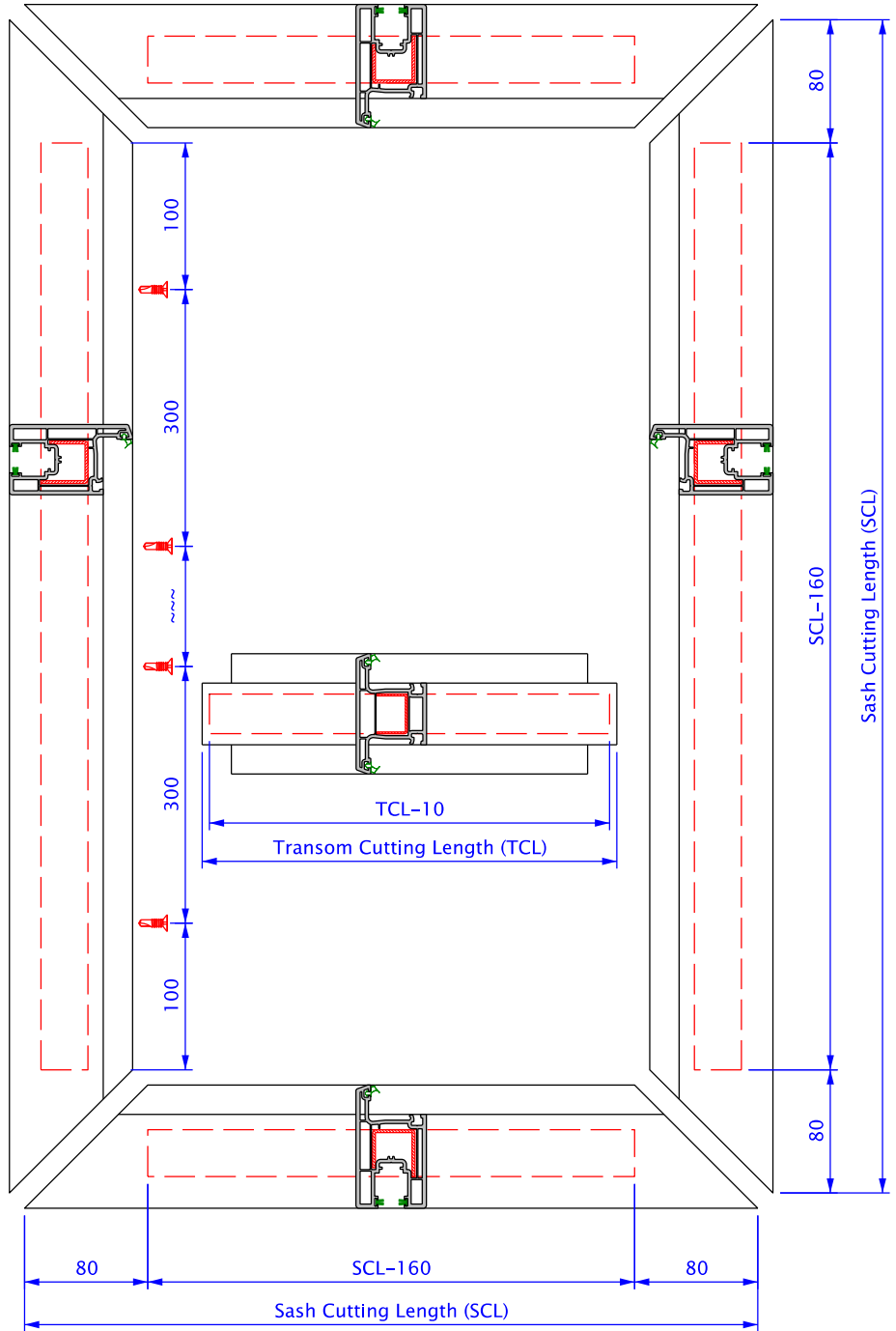
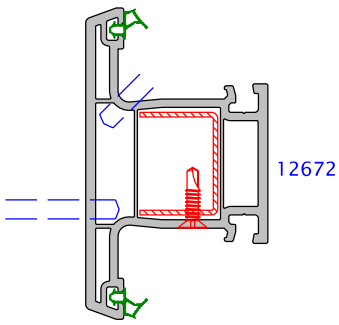
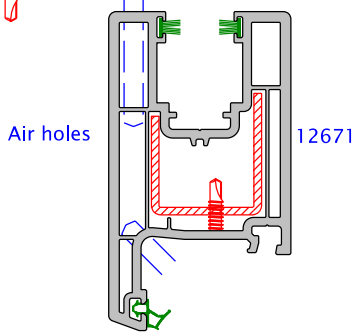


12670

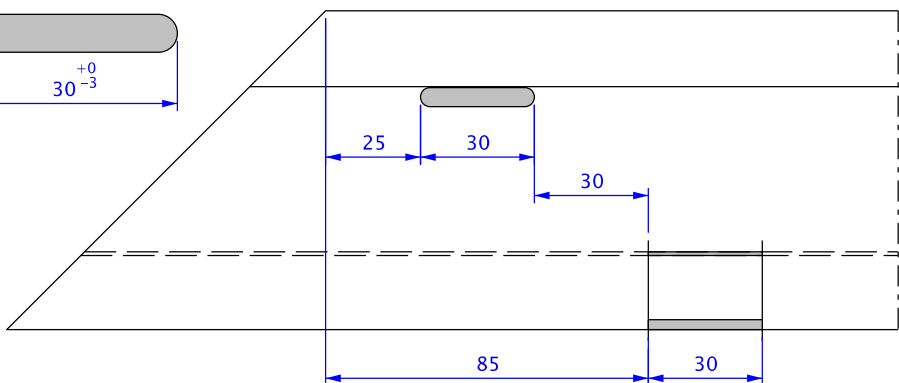
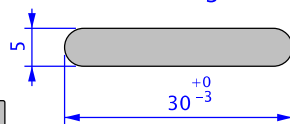
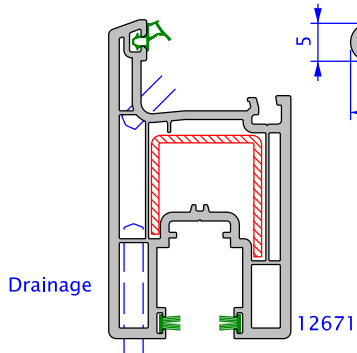


13000
3.9*16

air holes
(air holes can be milled as slot)



Drainage

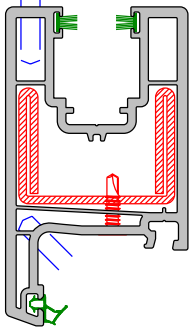


13000
3.9*16

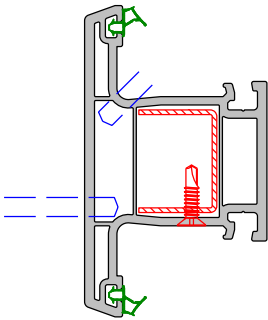


air holes
(air holes can be milled as slot)

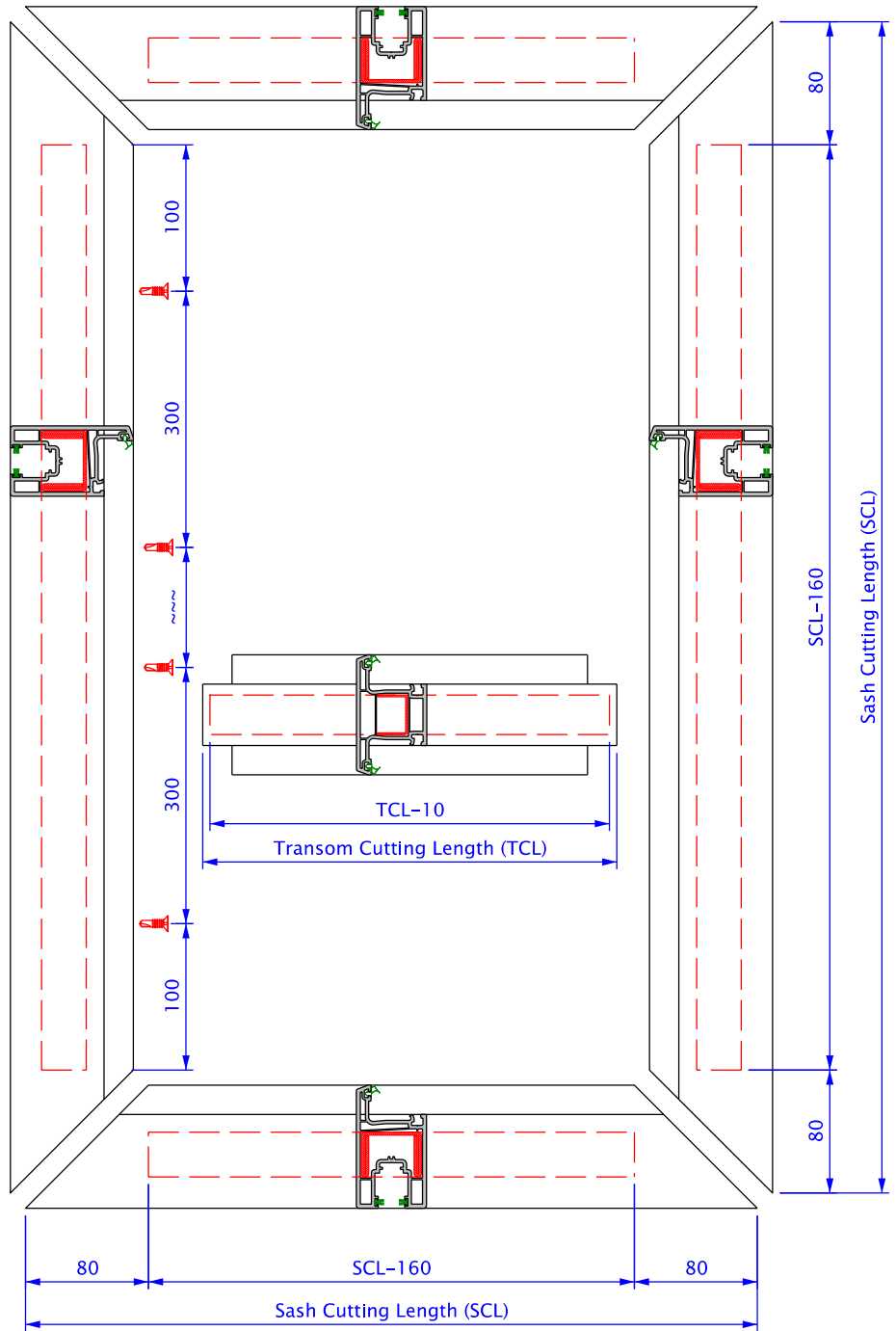
Air holes



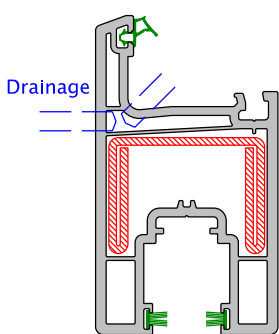
12688



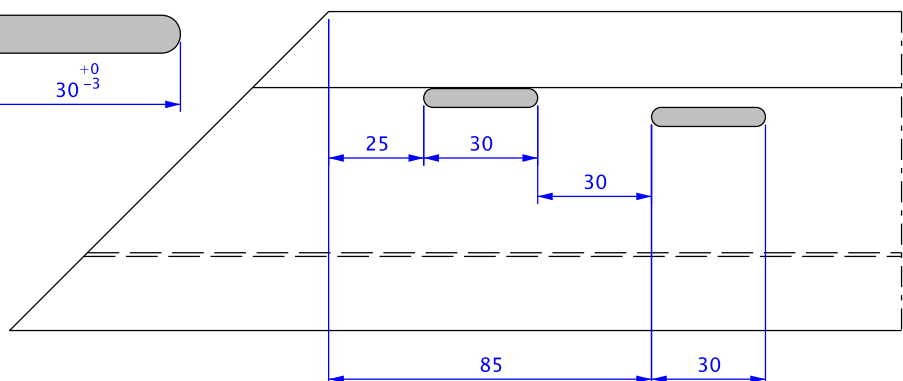
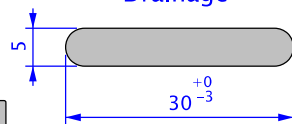
12672

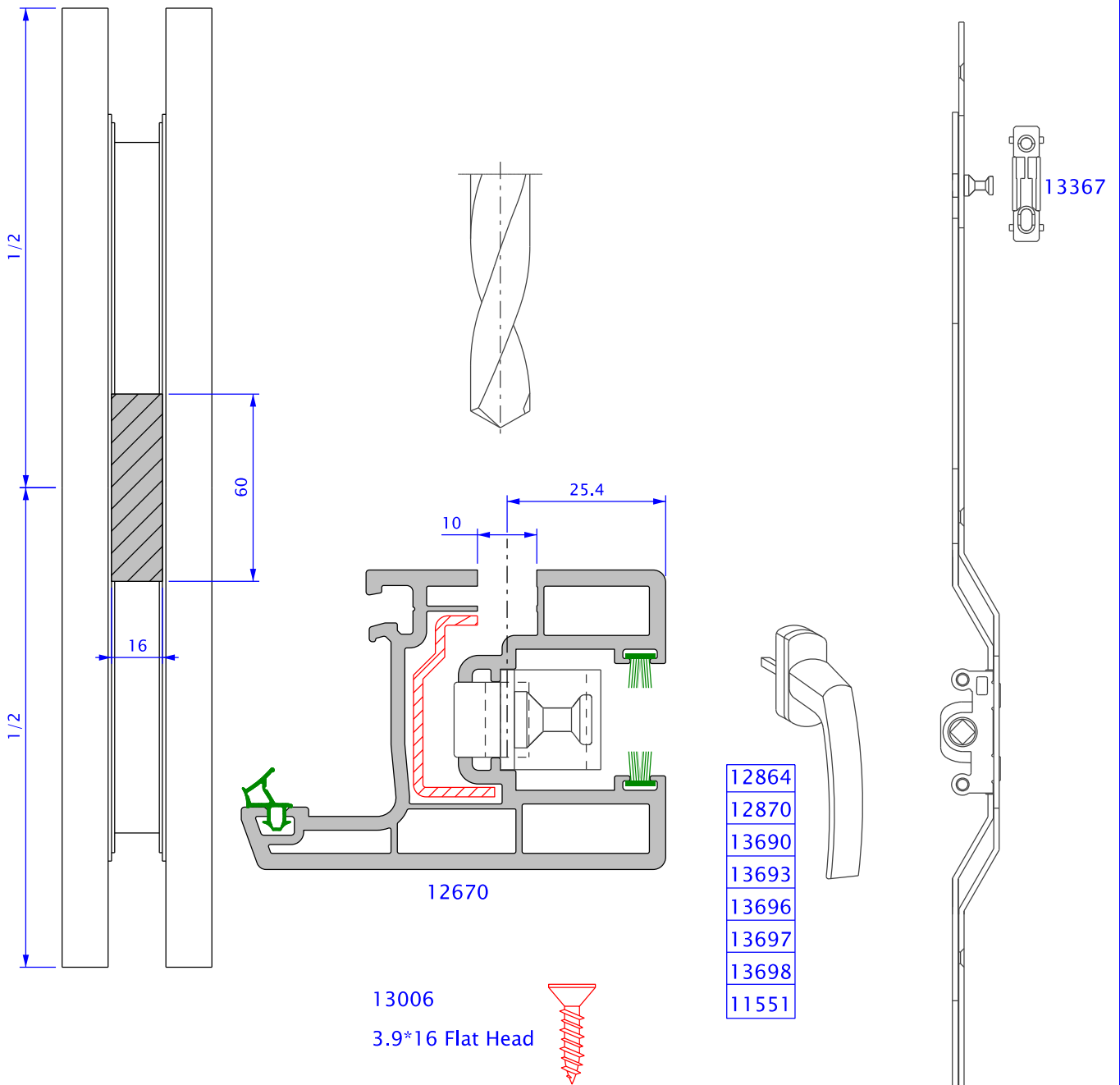


Drainage



12688

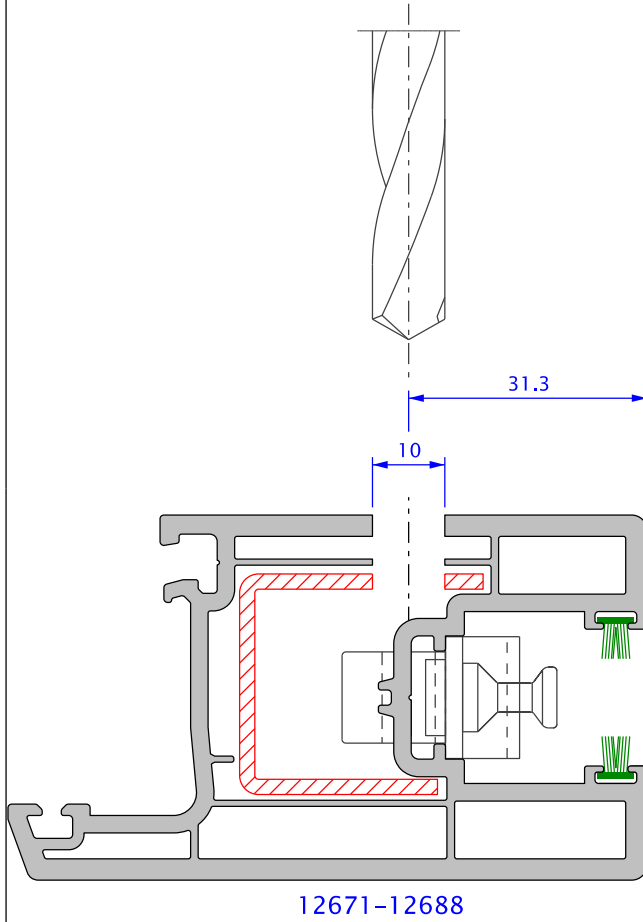
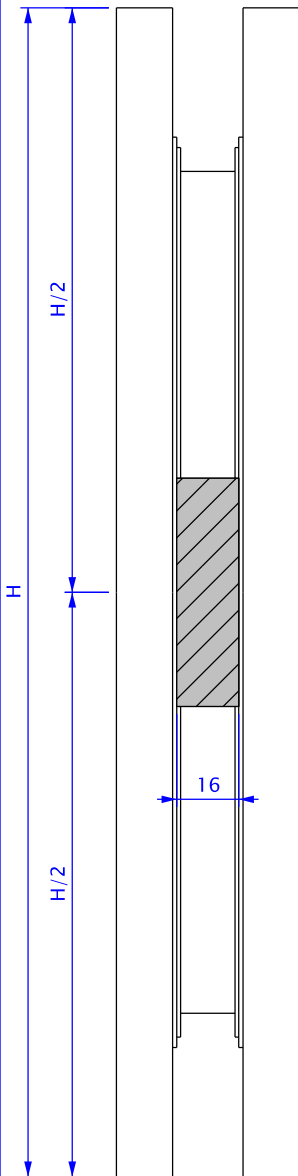




- * Sliding window sash(12670) is drilled for hardware as shown above,
- * Screw 3.9x16 (flat head) is used to fix the espagnolette to profile

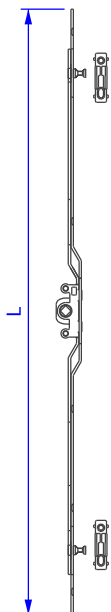
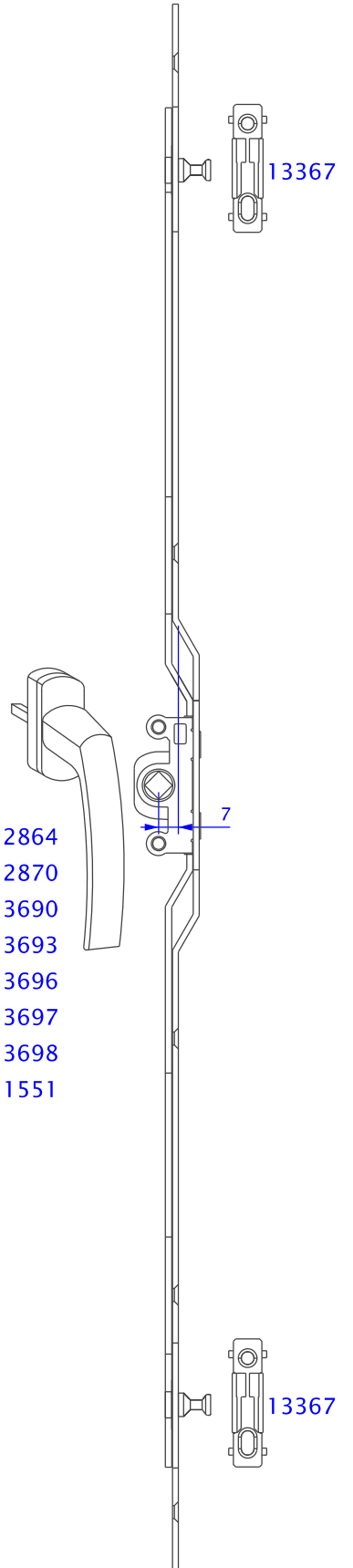
Sliding Window Espagnolettes

P number	Length (L)	# of Striker
13316	40 cm	2
13317	60 cm	2
13318	100 cm	2
13319	140 cm	3



- * Sliding Sash(12671-12688) is drilled for hardware as shown above
- * Screw 3.9x22 (Flat head) is used to fix the espagnolette to profile

- 12864
- 12870
- 13690
- 13693
- 13696
- 13697
- 13698
- 11551

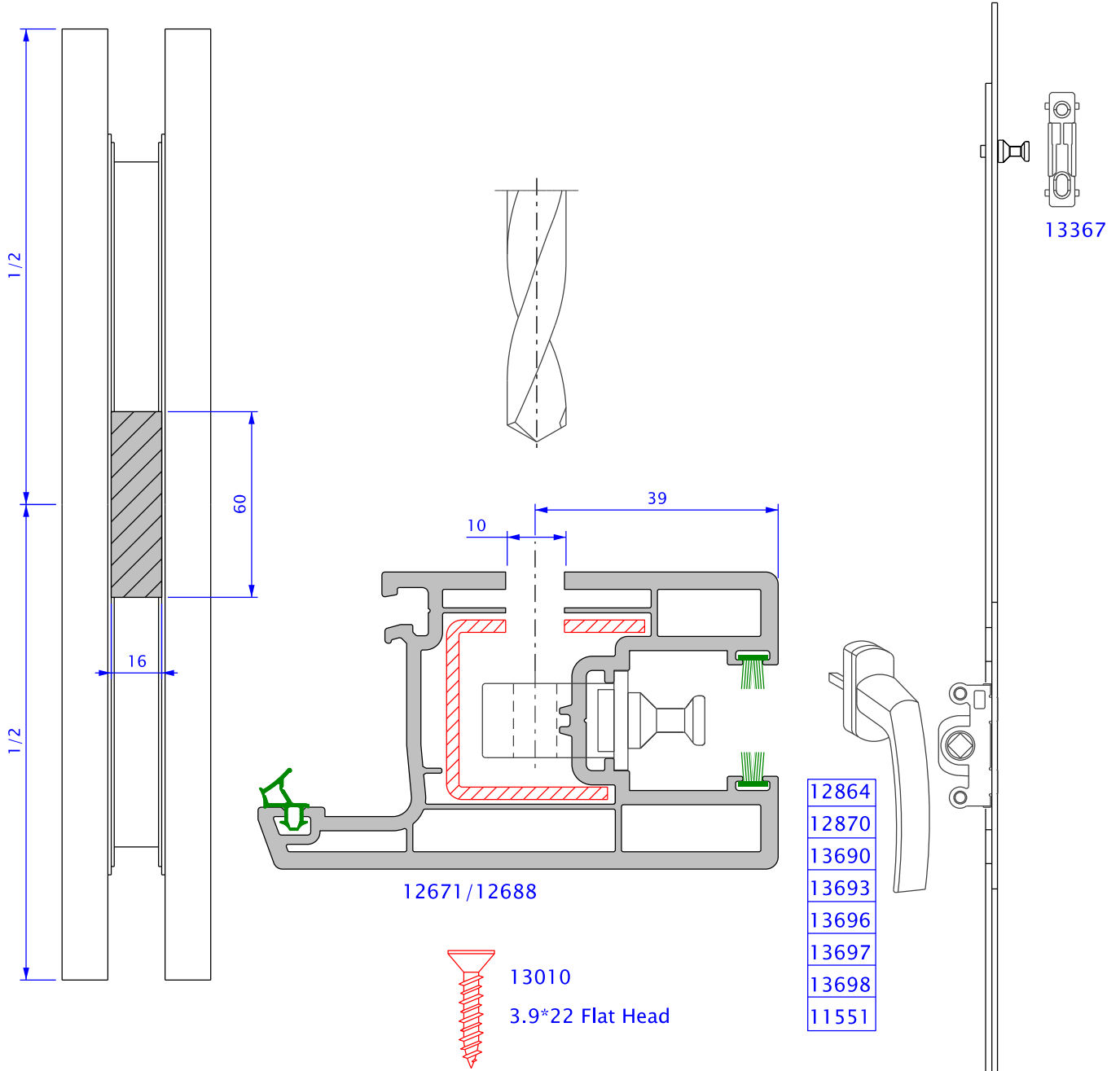


13010
3.9*22 Flat Head



Sliding Window Espagnolettes

P number	Length (L)	# of Striker
13368	40 cm	2
13369	60 cm	2
13370	100 cm	2
13371	140 cm	3

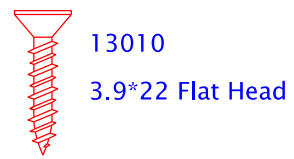
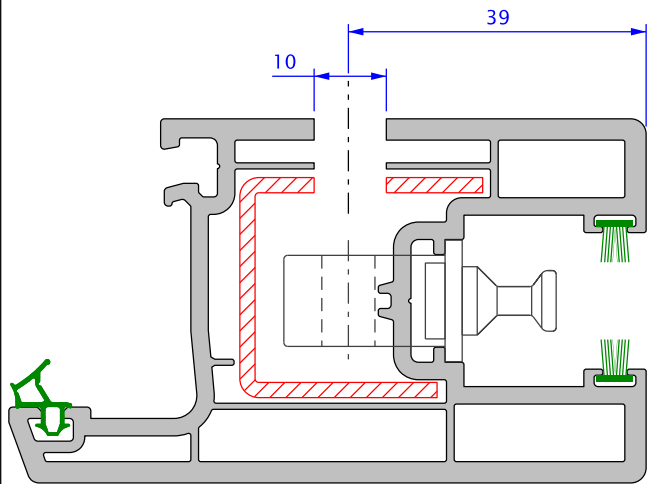
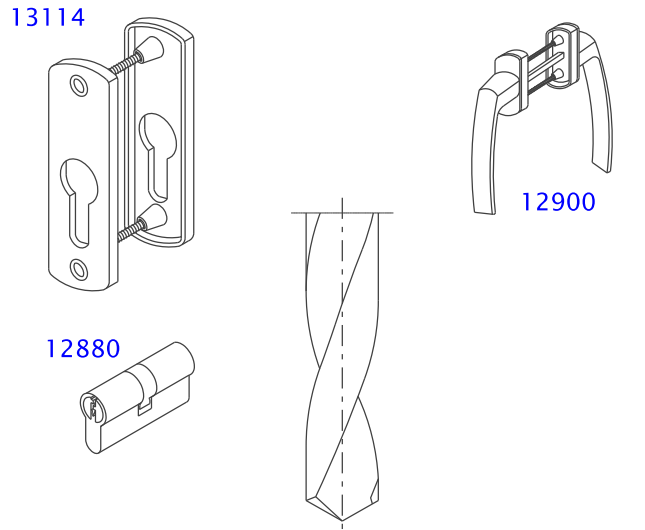
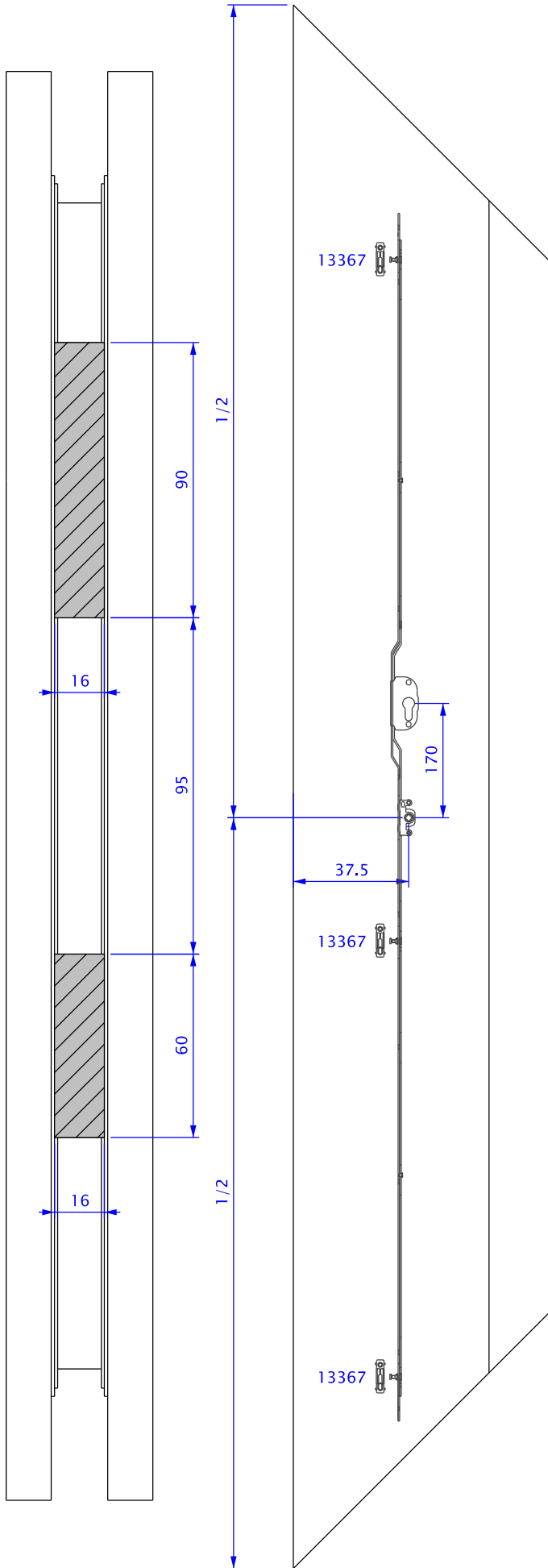


* Sliding Sash(12671–12688) is drilled for hardware as shown above

* Screw 3.9x16 (Flat head) is used to fix the espagnolette to profile

Sliding Espagnolettes

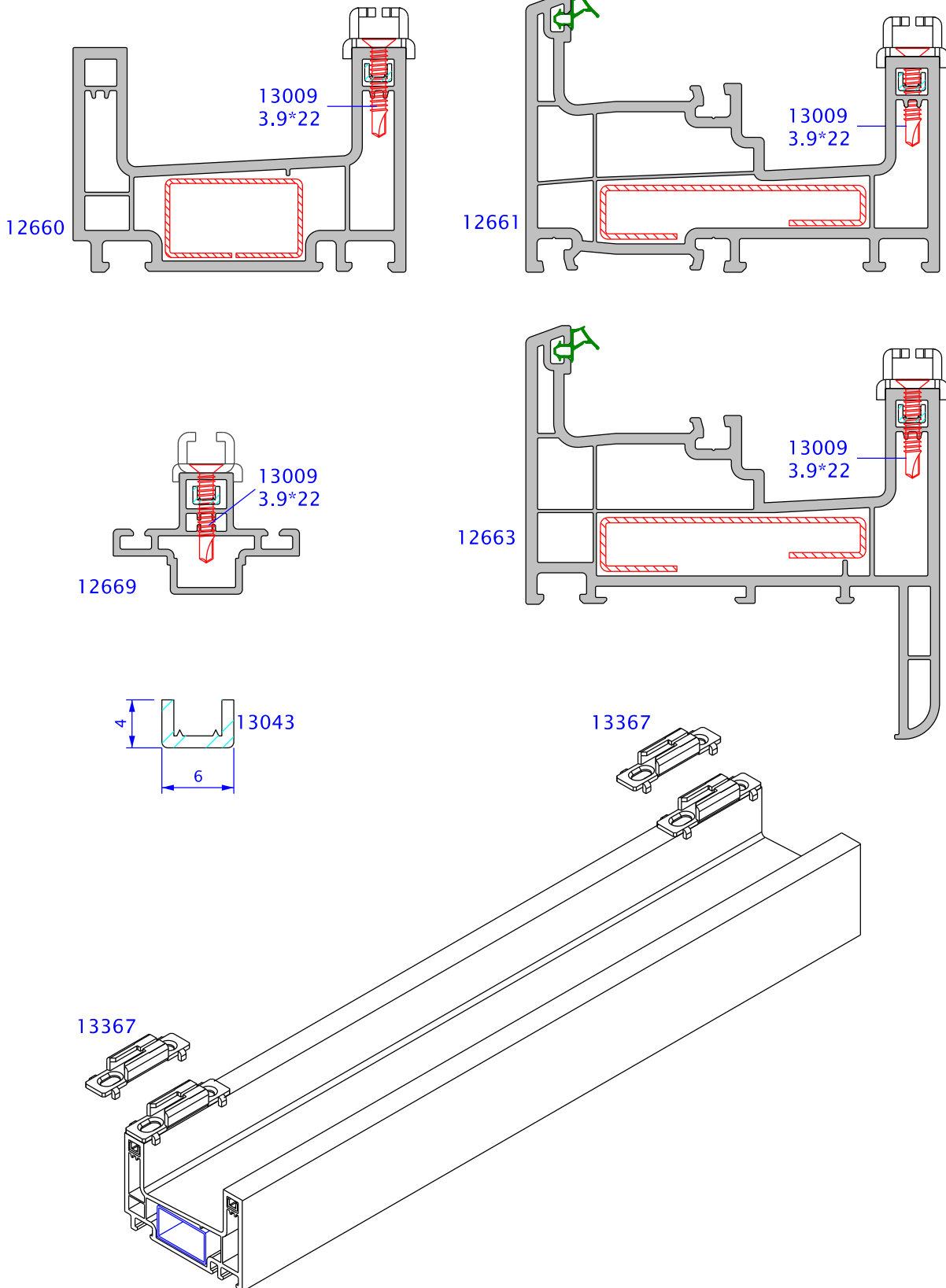
P number	Length (L)	# of Striker
13390	60 cm	2
13391	100 cm	2
13392	140 cm	3
13393	180 cm	3
13394	200 cm	4

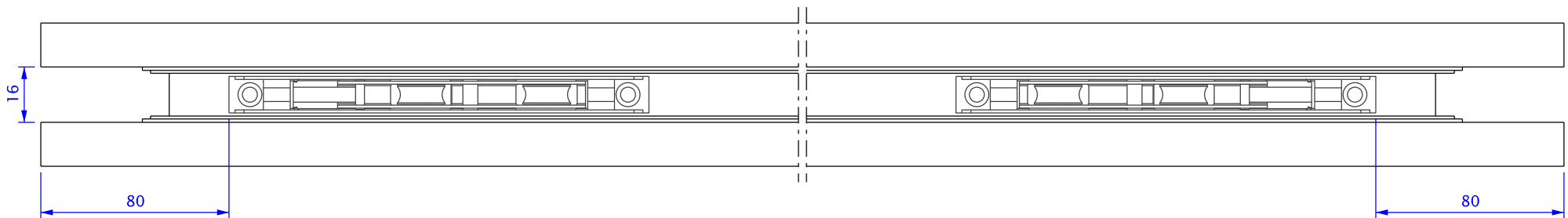
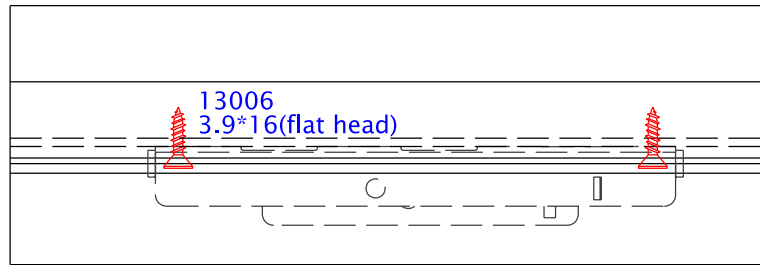
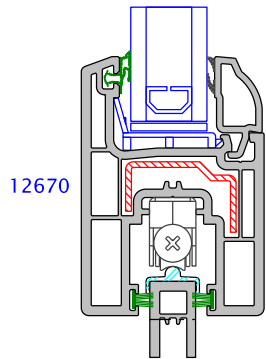
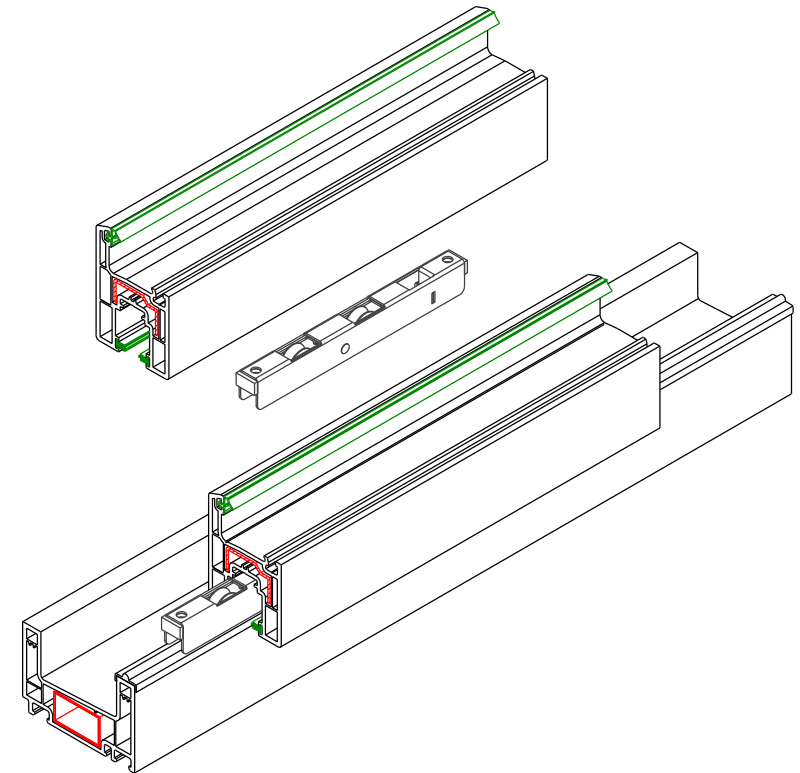
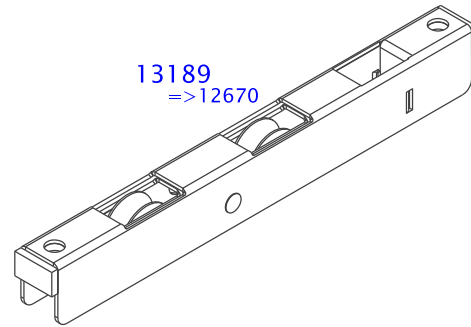


Sliding Locked Espagnolettes

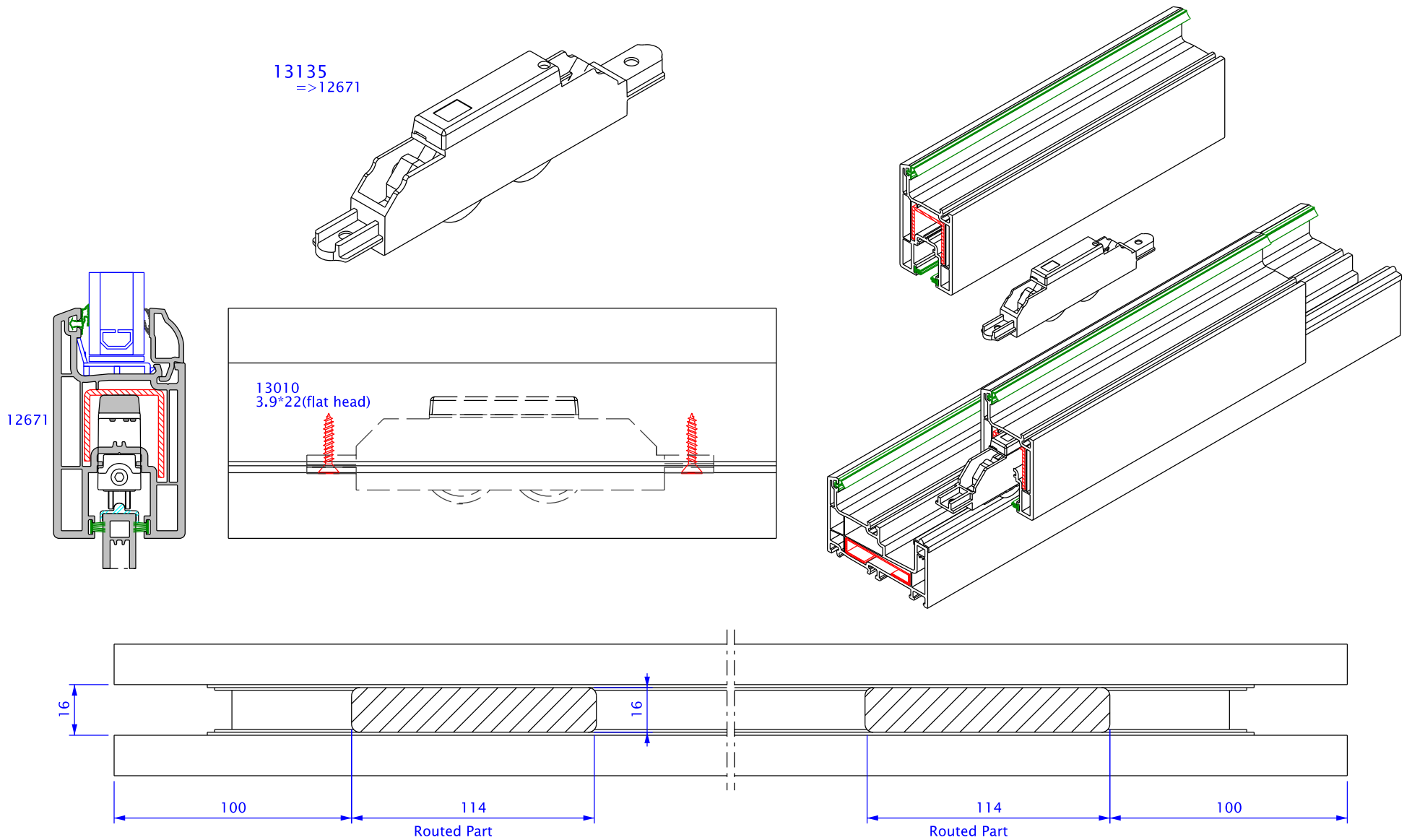
P number	Length (L)	# of Striker
13349	160 cm	2
12857	180 cm	3

1. Insert the aluminium support profile before welding,
2. Sliding strikers and anti-lift pieces which should be fixed through aluminium profile (13043)
3. 13043 (aluminium support) are fixed to frame with screw 3.9x22 (13009) (flat head).

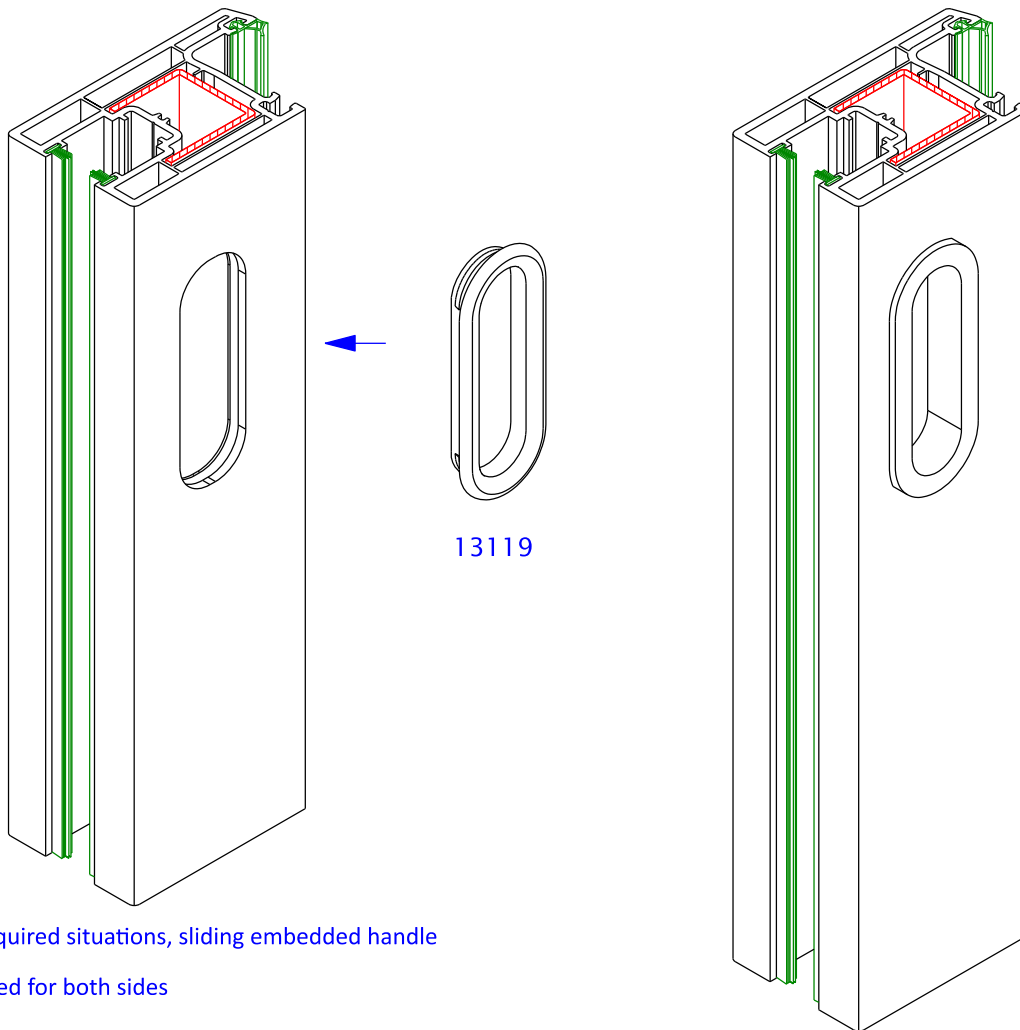




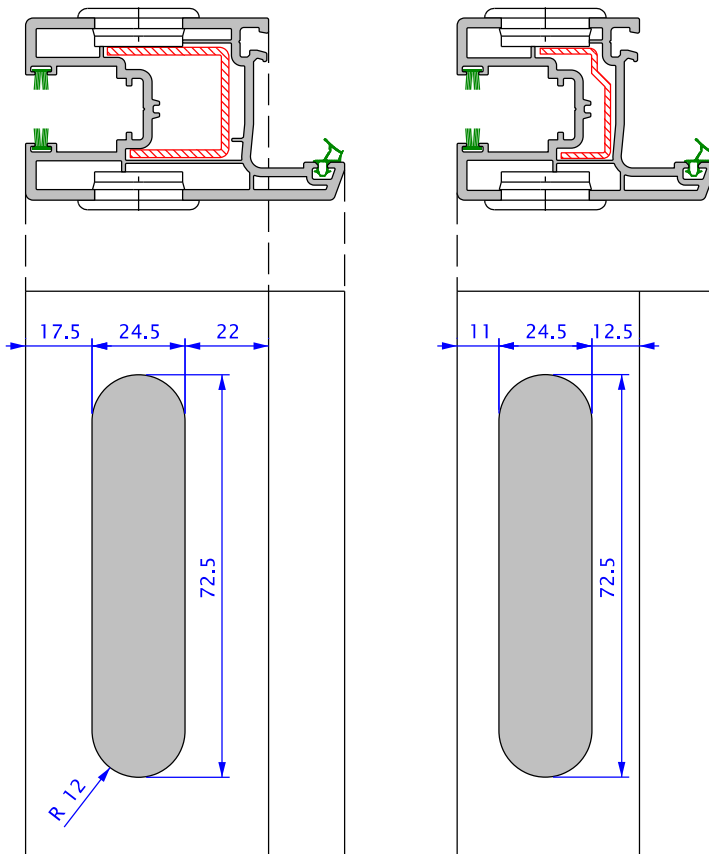
- * There is no need to mill the sash (12670) for installation of sliding roller (13189).
- * Sliding window sash roller (13189) must be installed as shown in the picture above.
- * Sliding roller (13189) can not be used in the application of sliding door sash (12671).



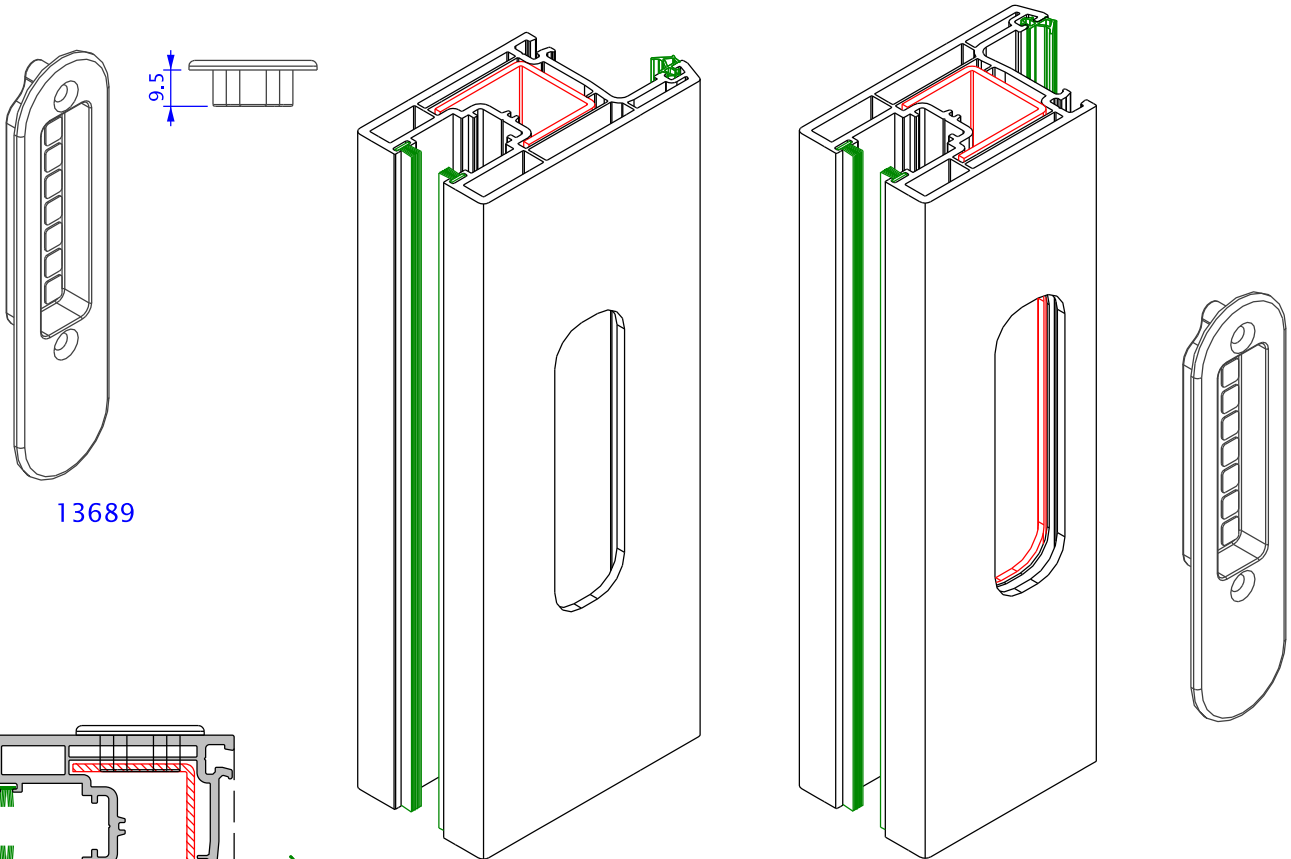
- * Sliding Sash (12671) should be freezed to install the roller (13135) as shown in the picture above
- * Sliding roller (13135) should be installed in the espagnolette groove on sash. It is fixed with screw 13010(3.9x22 flathead)



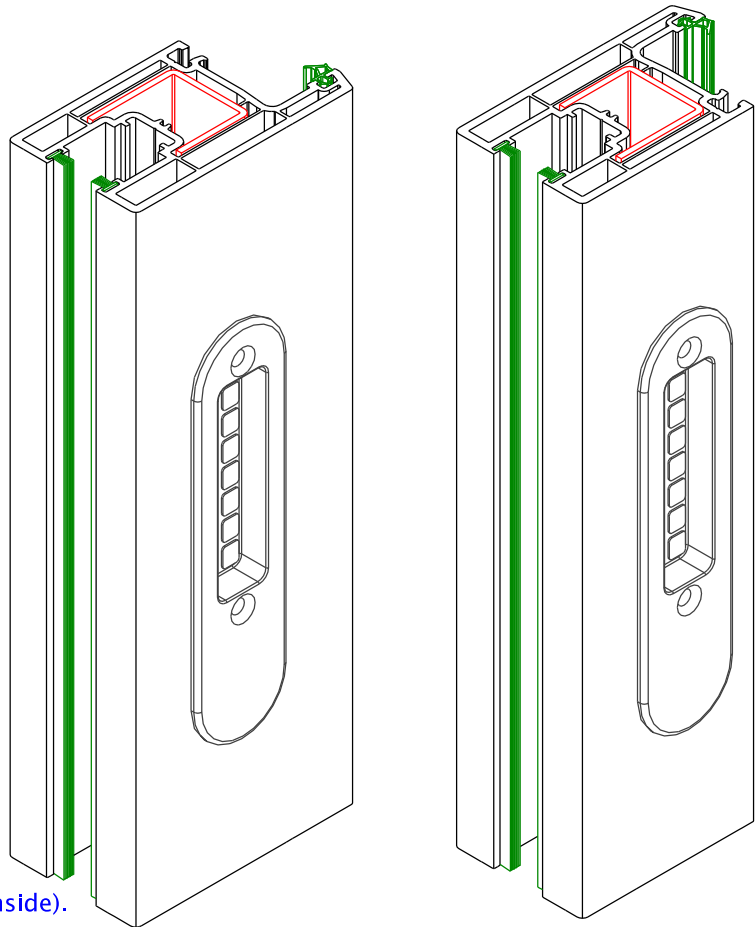
*When required situations, sliding embedded handle can be used for both sides



- * Sliding embedded handle (13119) can be used in both sash profile(12670/12671),
- * for windows :
13119 is used on only one side (inside)
- for doors :
It can be used on both sides(inside+outside),
- * Sash profiles should be routed for 13119 as shown left side.

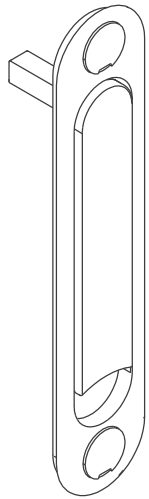


13689

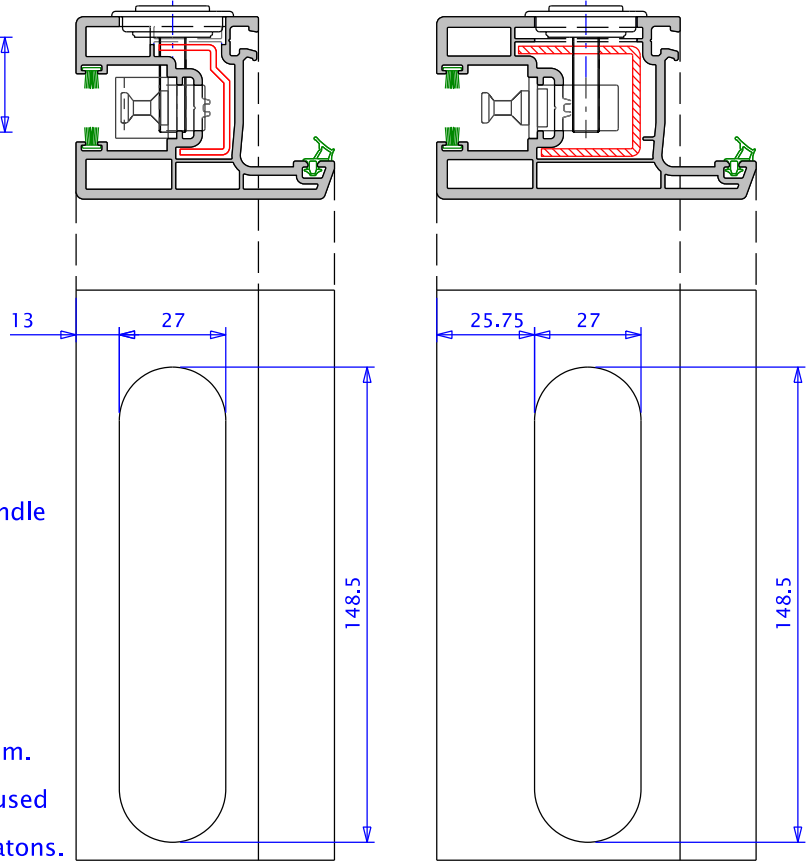
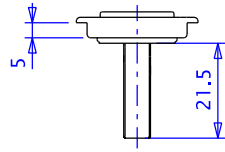


* 13689 – Sliding Alum. Concealed Handle can be used with double side for doors (inside & outside), one side for windows (only inside).

* Location of the 13689 Sliding Alum Concealed Handle on the sash must be milled according to given dimensions.



13630

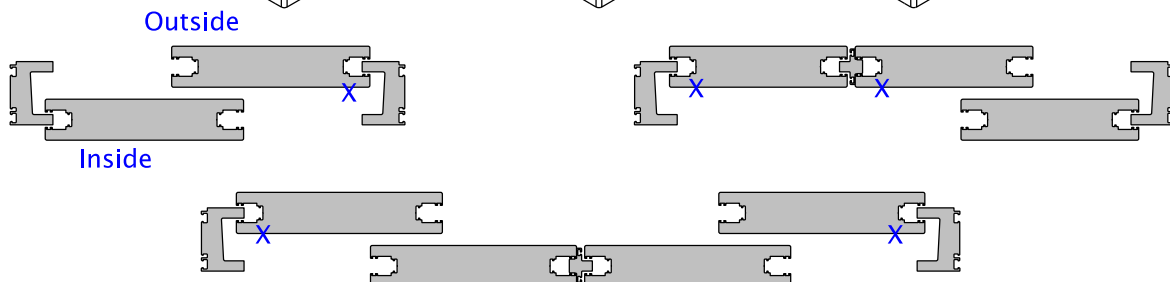
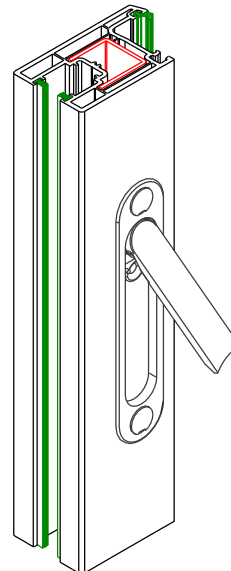
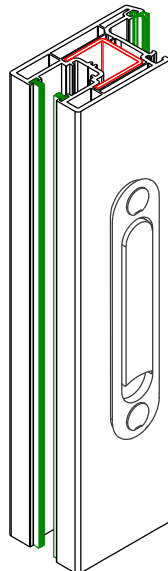
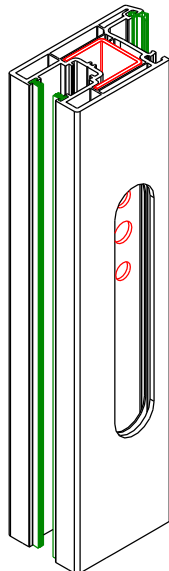


* Application of 13630 Sliding Embedded Handle 5 mm, only PVC profile must be milled.

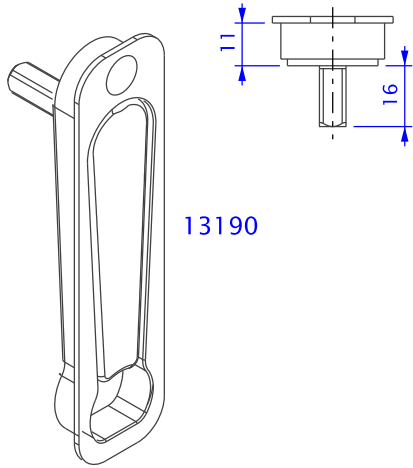
* Standard handle holes must be drilled on the reinforcement.

* 13630 Sliding Embedded Handle 5 mm, should be used each passive sash in the system.

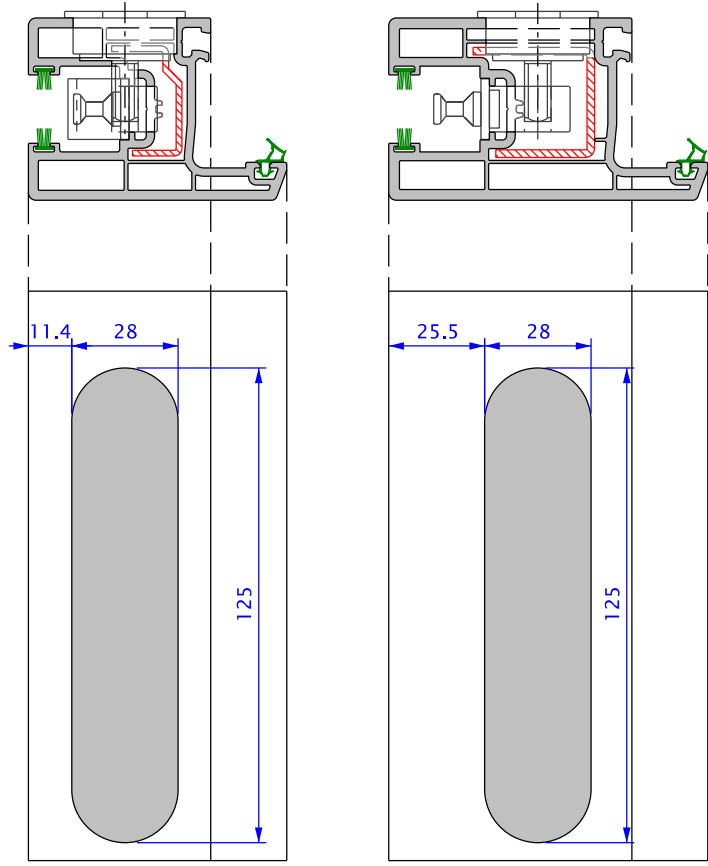
* 13630 Sliding Embedded Handle 5 mm, is used for close sash to outside in double rail applications.



Note: X label indicates where the sliding embedded handle can be used

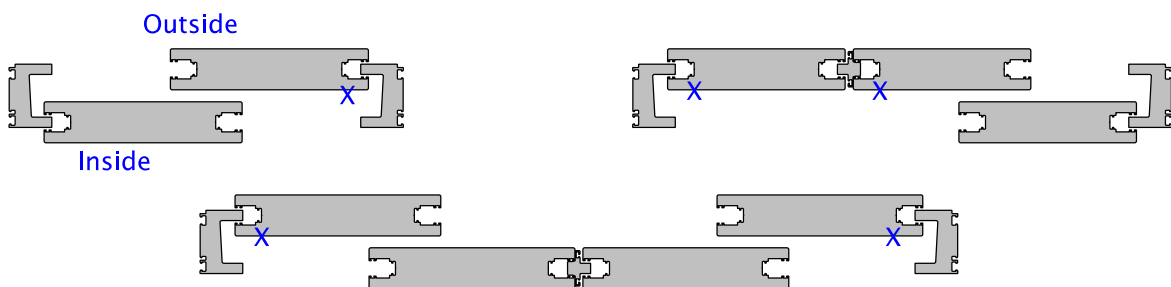
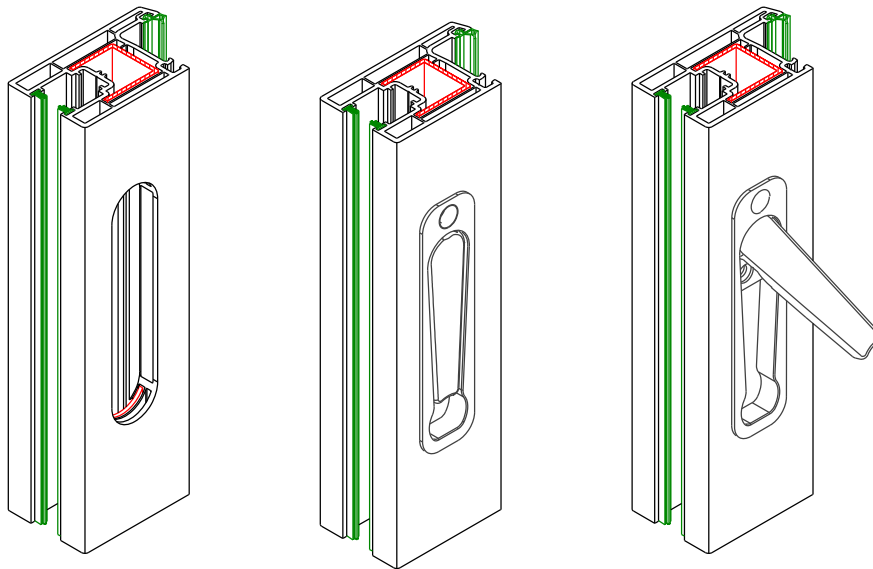


13190



* Sliding handle(13190) can be used in both sash profiles (12670/12671),

* This handle must be used on the outside sash that is sliding on external rail. It can also be used as an alternative handle for the internal rail.



Note: X label indicates where the sliding embedded handle can be used

To achieve best welding results, please observe the following :

1. The temperature of profile must be $> 15^{\circ}\text{C}$. (Store at room temperature of at least 15°C)
2. The cutting angle variation must not exceed 0.5°
3. The welding surface must be free of dirty, grease hand sweat, material chips, moisture and protective foils.
4. The welding parameter must be adjusted according to the following criteria.




4.1. Welding plate

Welding Plate Temperature $240^{\circ}\text{--}250^{\circ}\text{C}$,  \rightarrow  verification with measuring device on welding plate

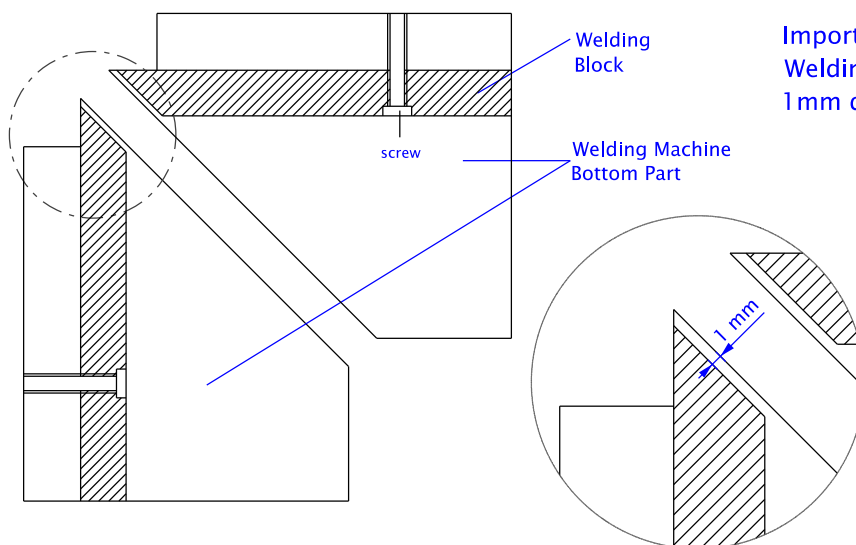
4.2 Welding times

- Heating time - a minimum of 15 seconds
- Change-over time as short as possible, maximum of 2 seconds
- Cooling time - a minimum of 30 seconds
- No accelerated cooling (by the use of compressed air)

4.3 Welding pressure:

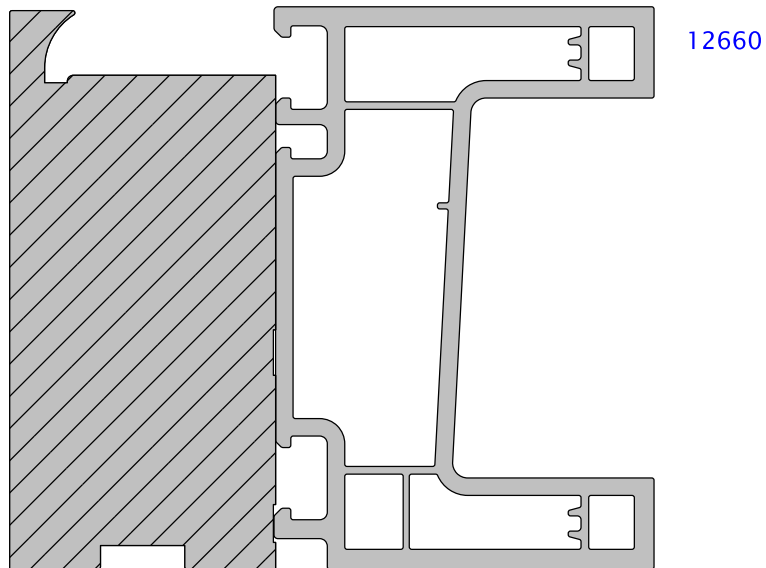
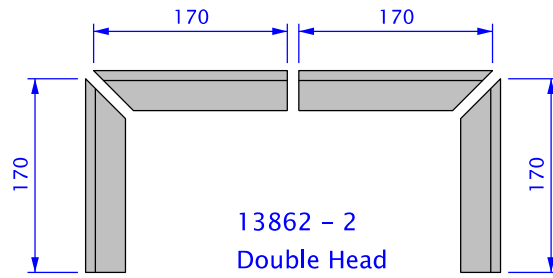
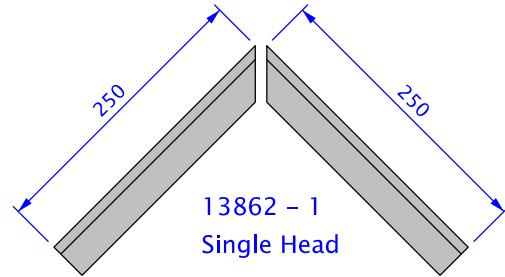
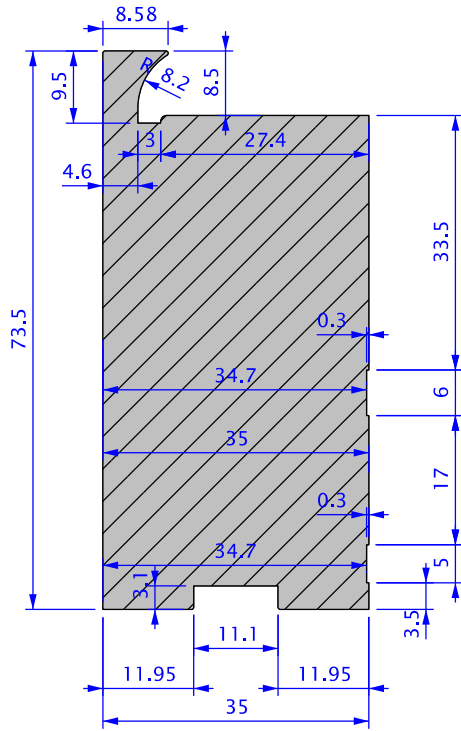
- Clamping pressure 6 bar 
- Adjusting pressure 2.5-3 bar 
- Welding pressure 6 bar 

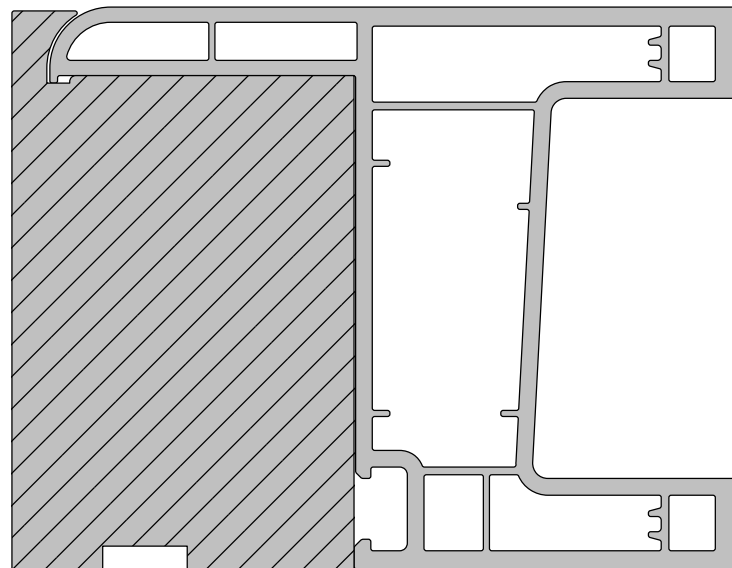
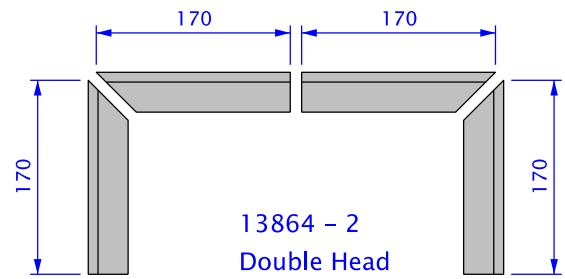
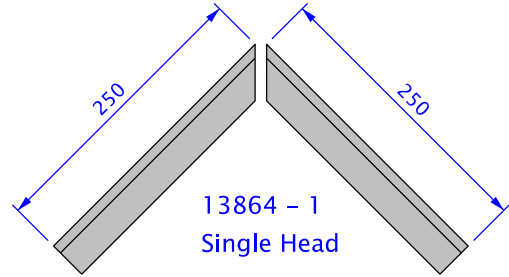
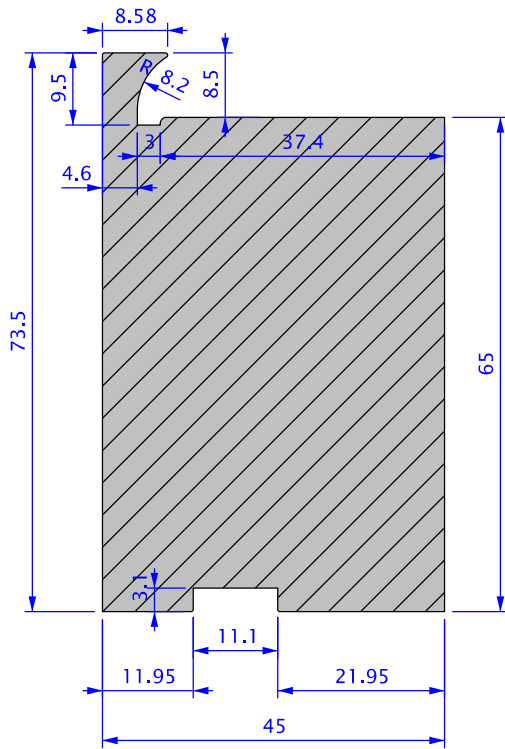
5. The welding support blocks must be used,



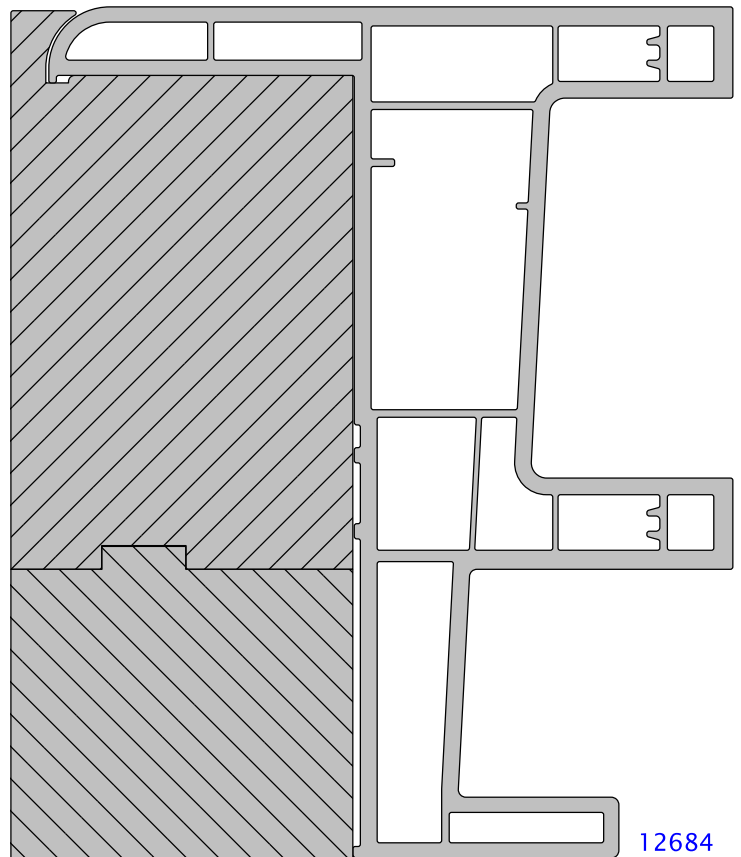
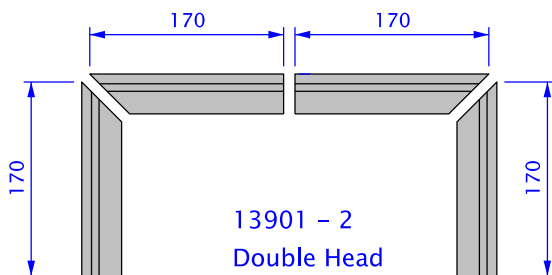
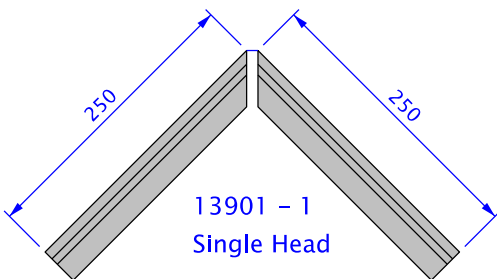
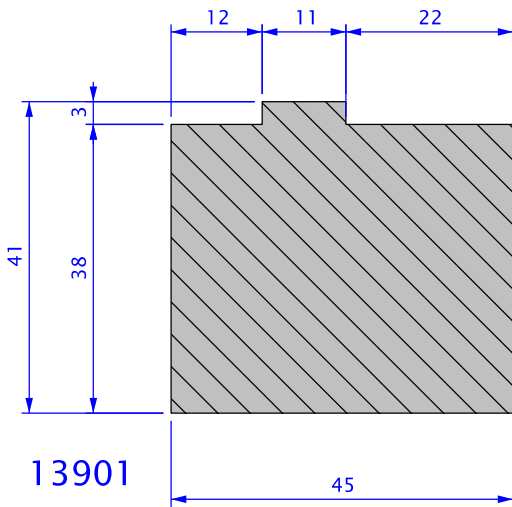
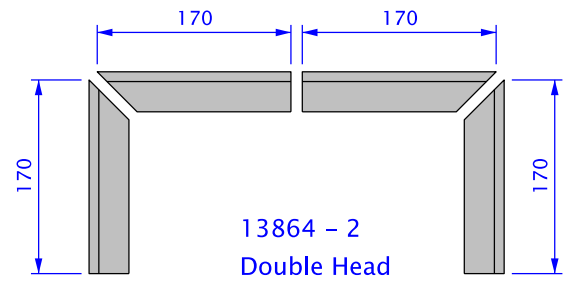
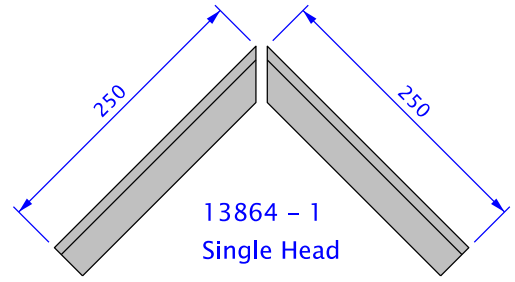
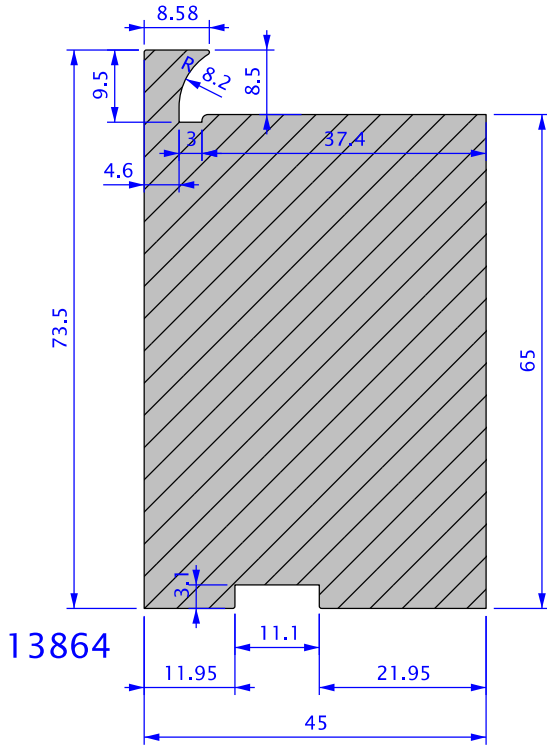
Important !
Welding support blocks must be fixed with 1 mm distance

6. Top and bottom pieces of welding support blocks must be parallel to each other
7. Welding thickness must be 3 mm

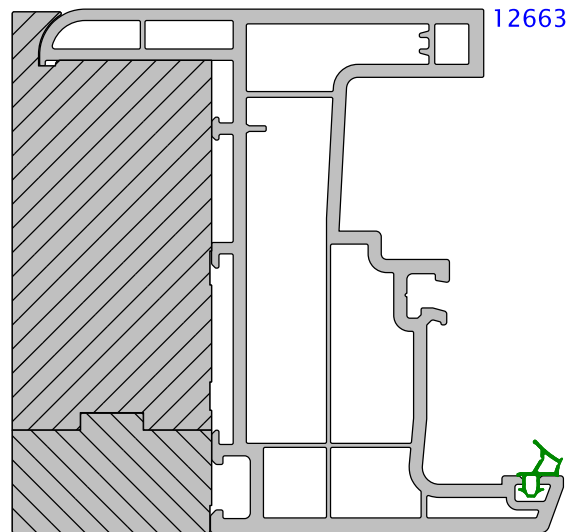
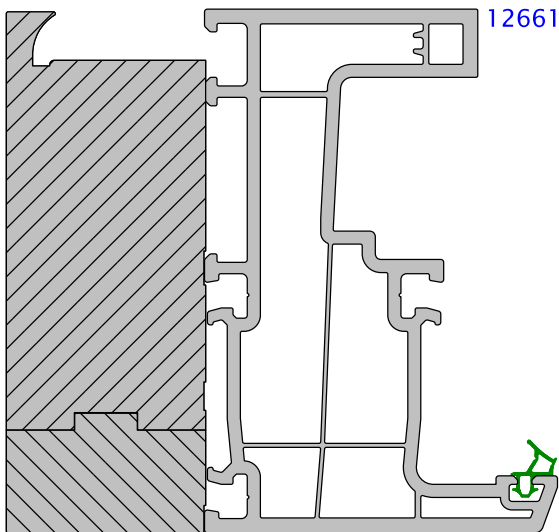
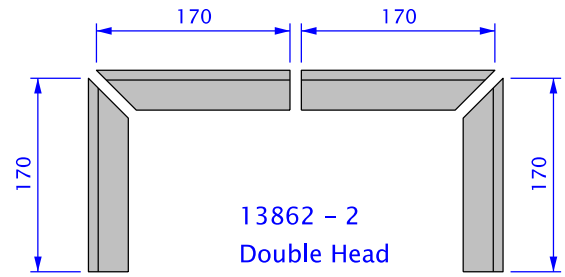
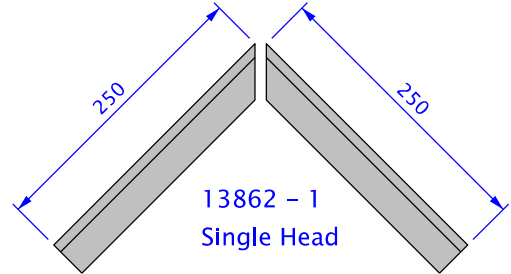
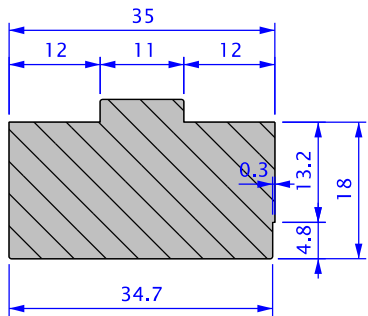
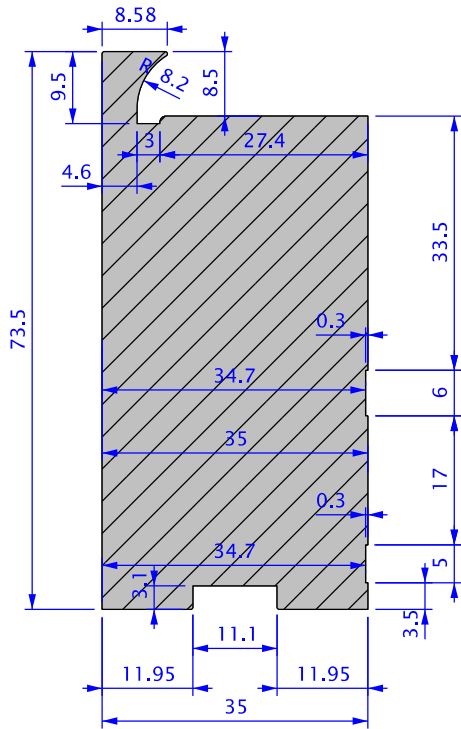


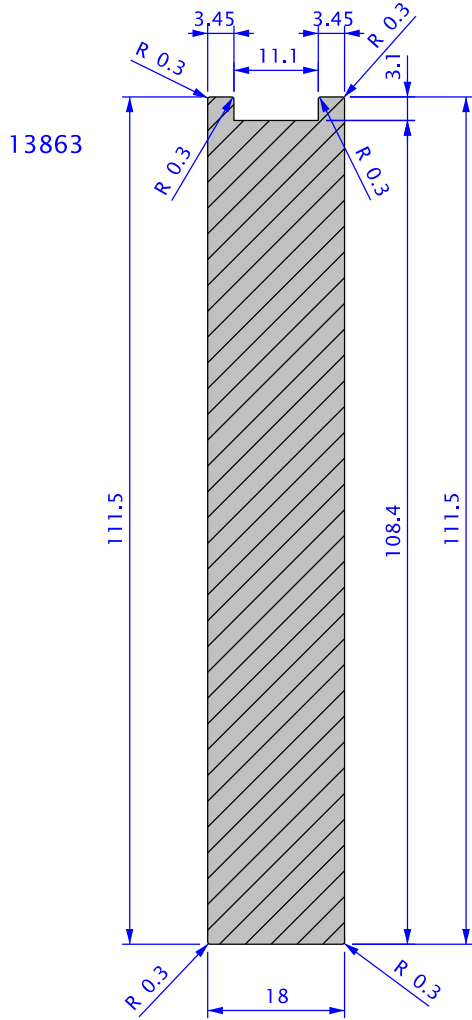


12662

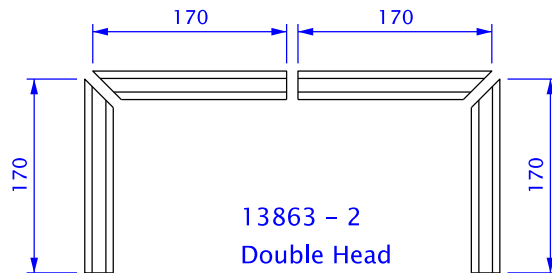
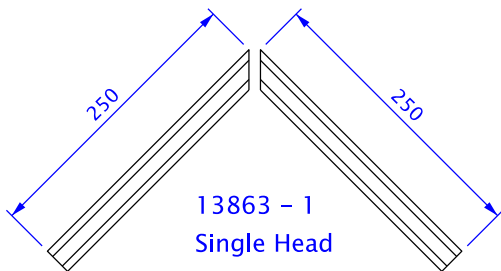
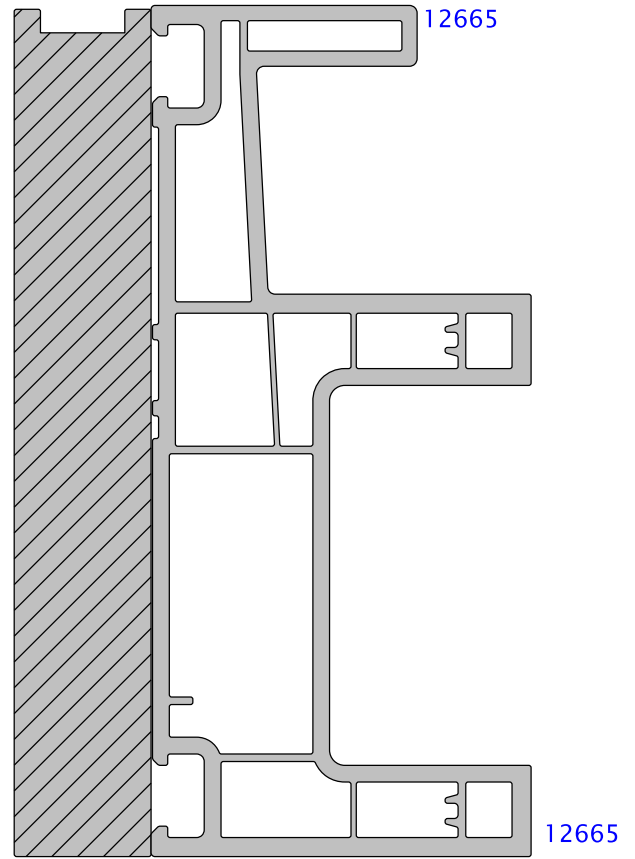


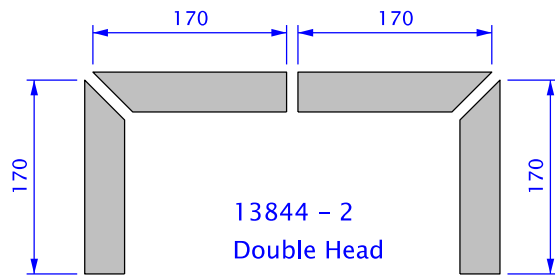
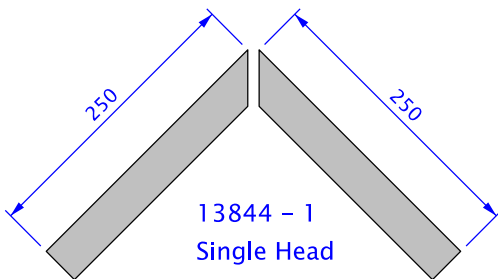
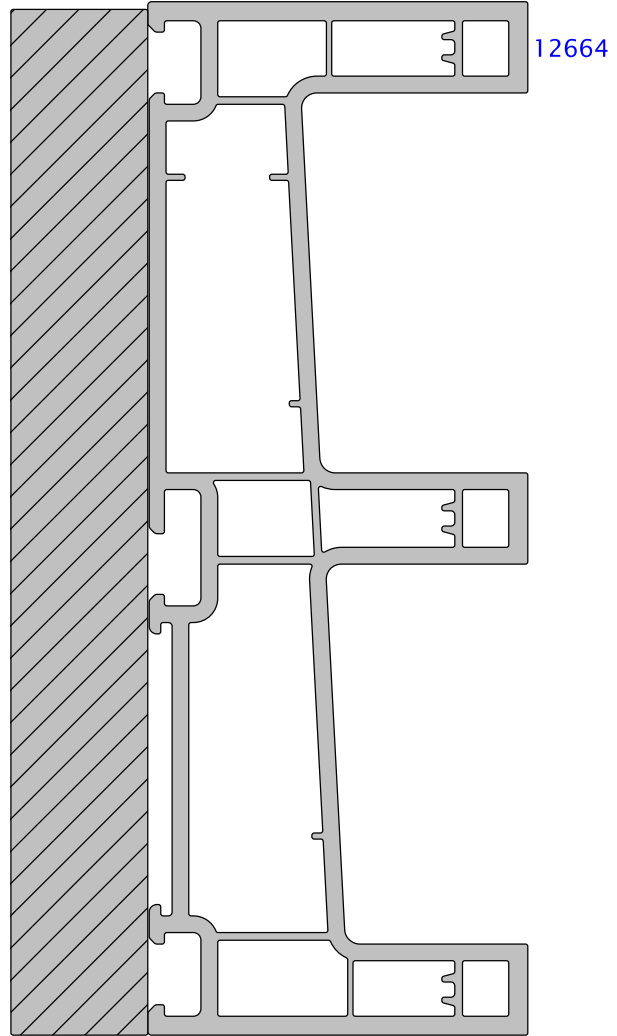
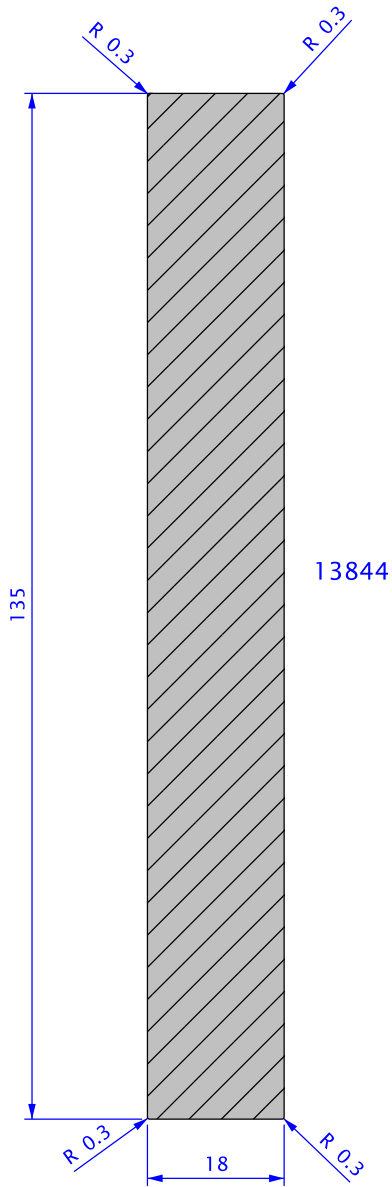
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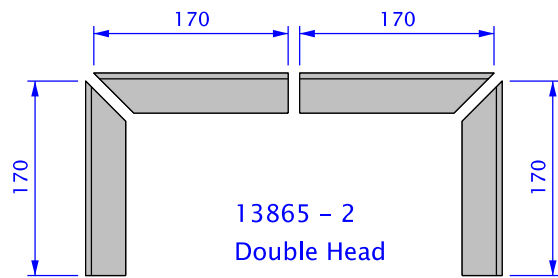
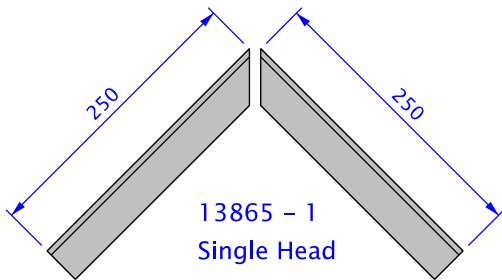
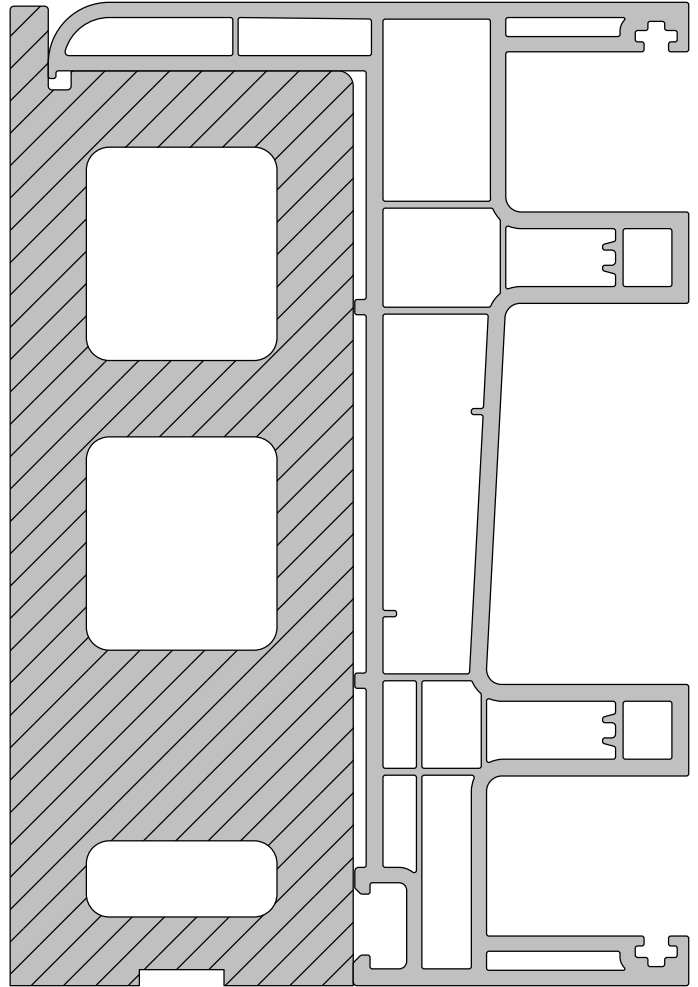
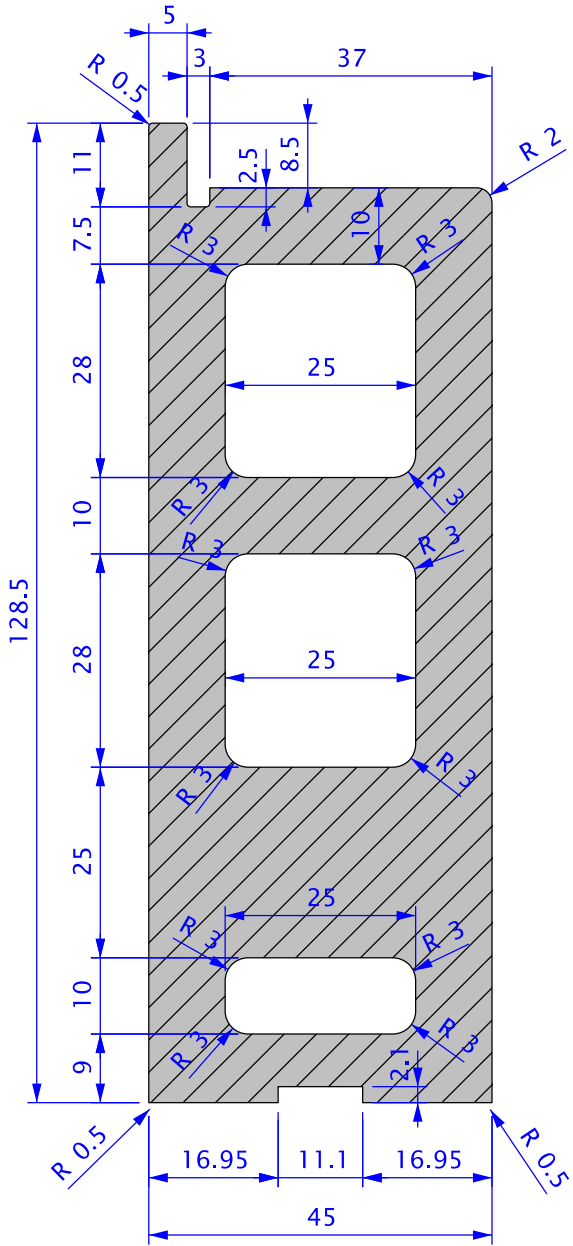


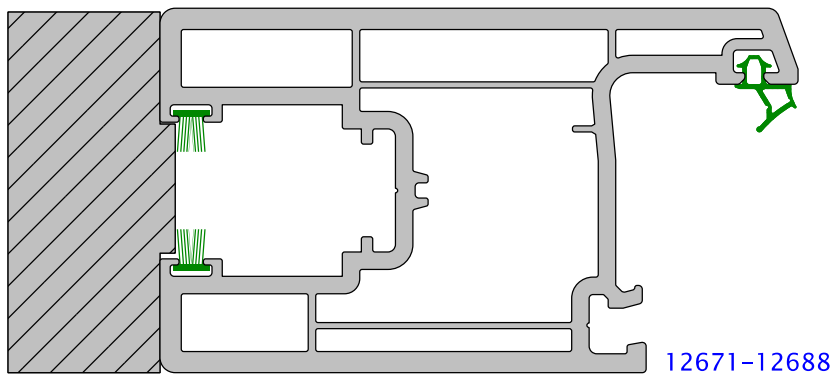
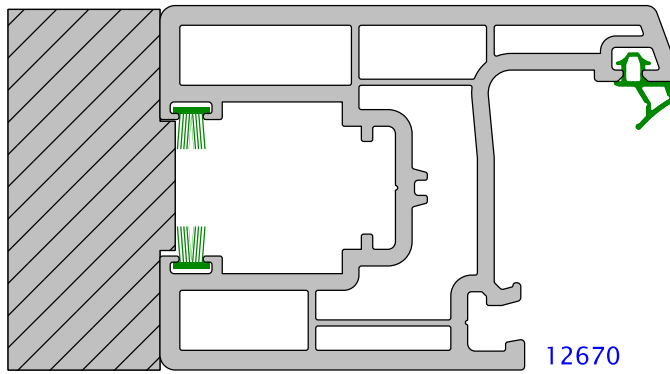
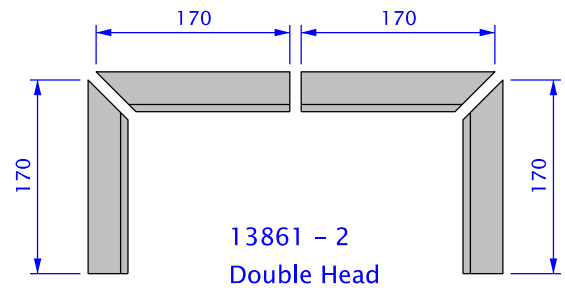
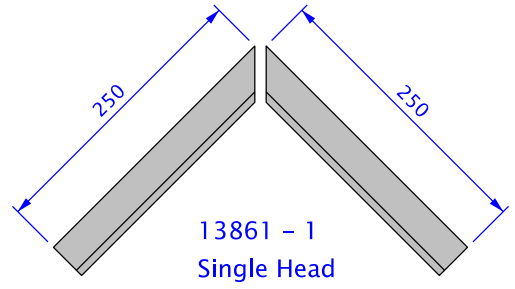
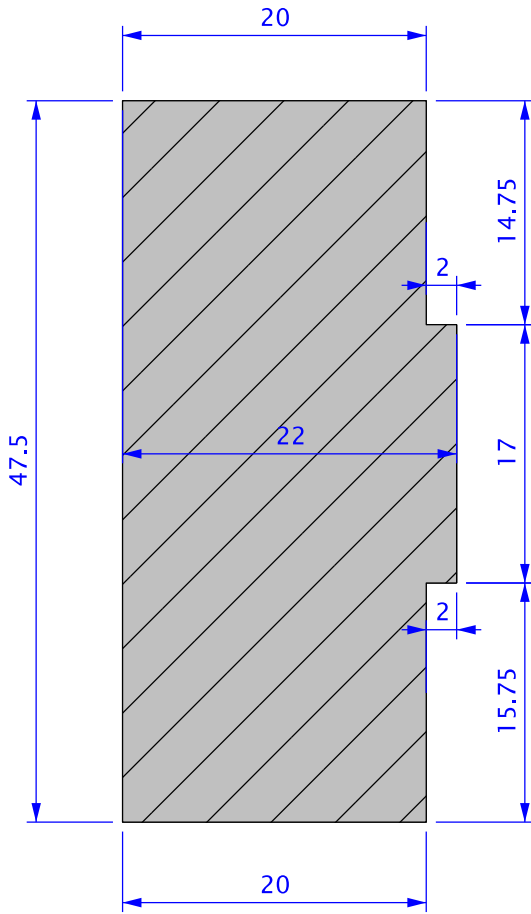


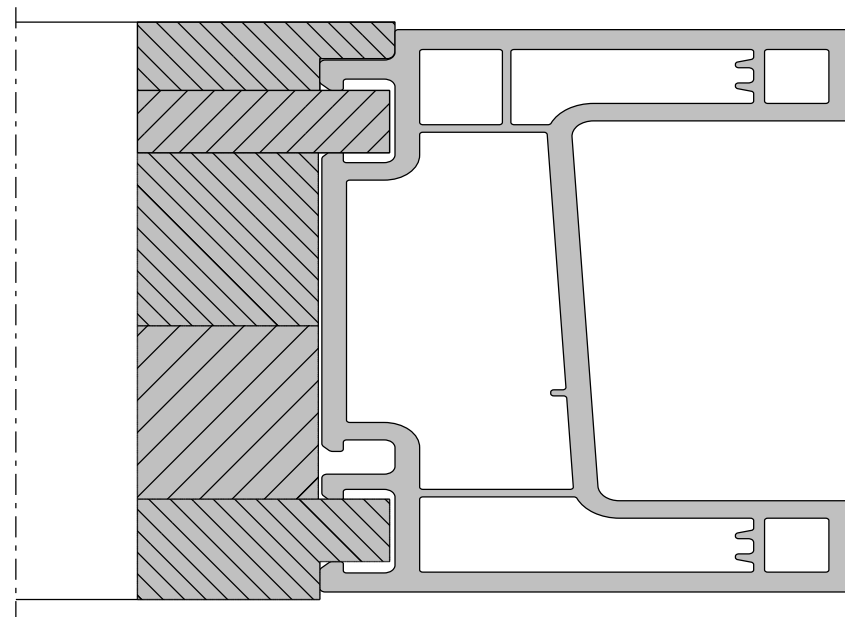
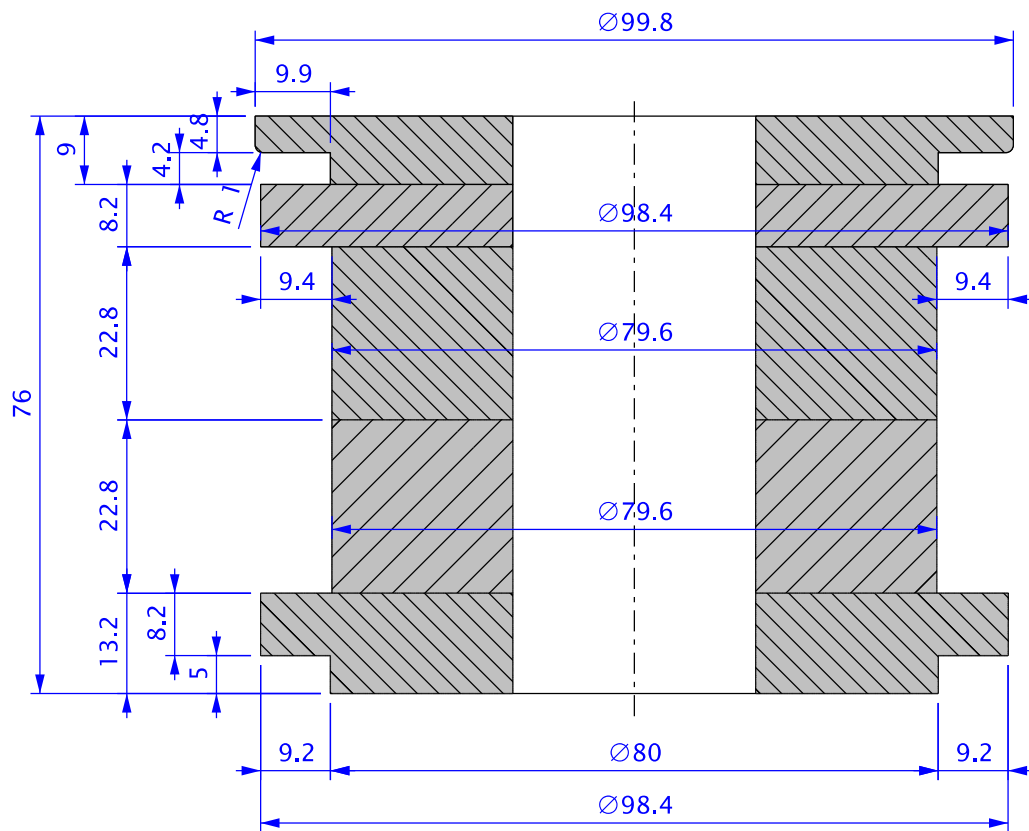
Welding Blocks



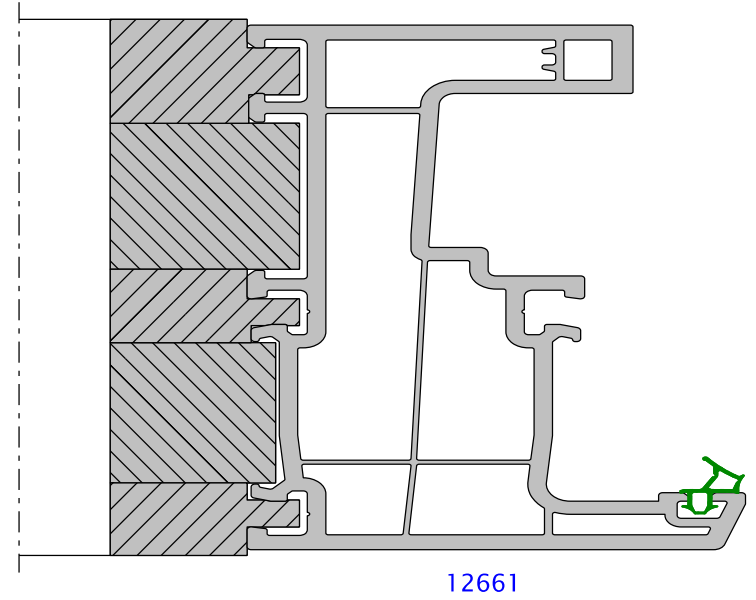
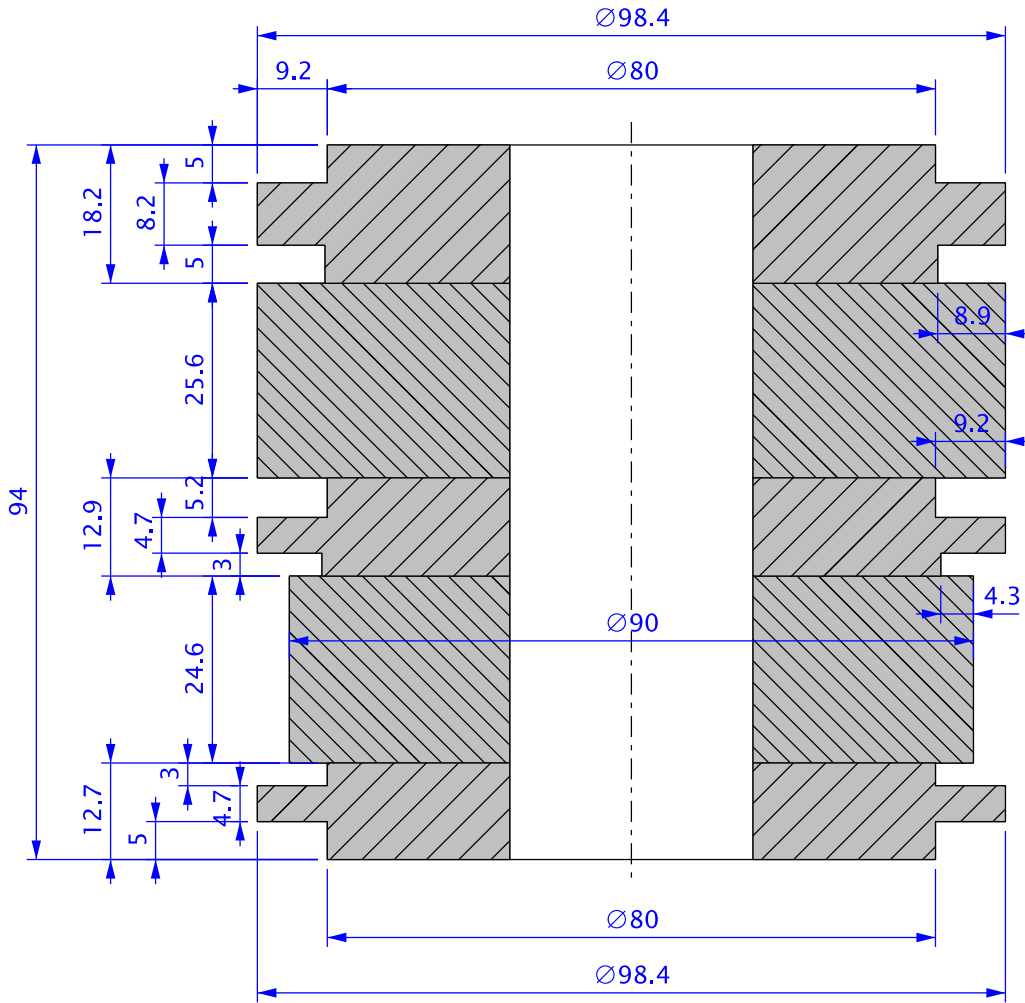


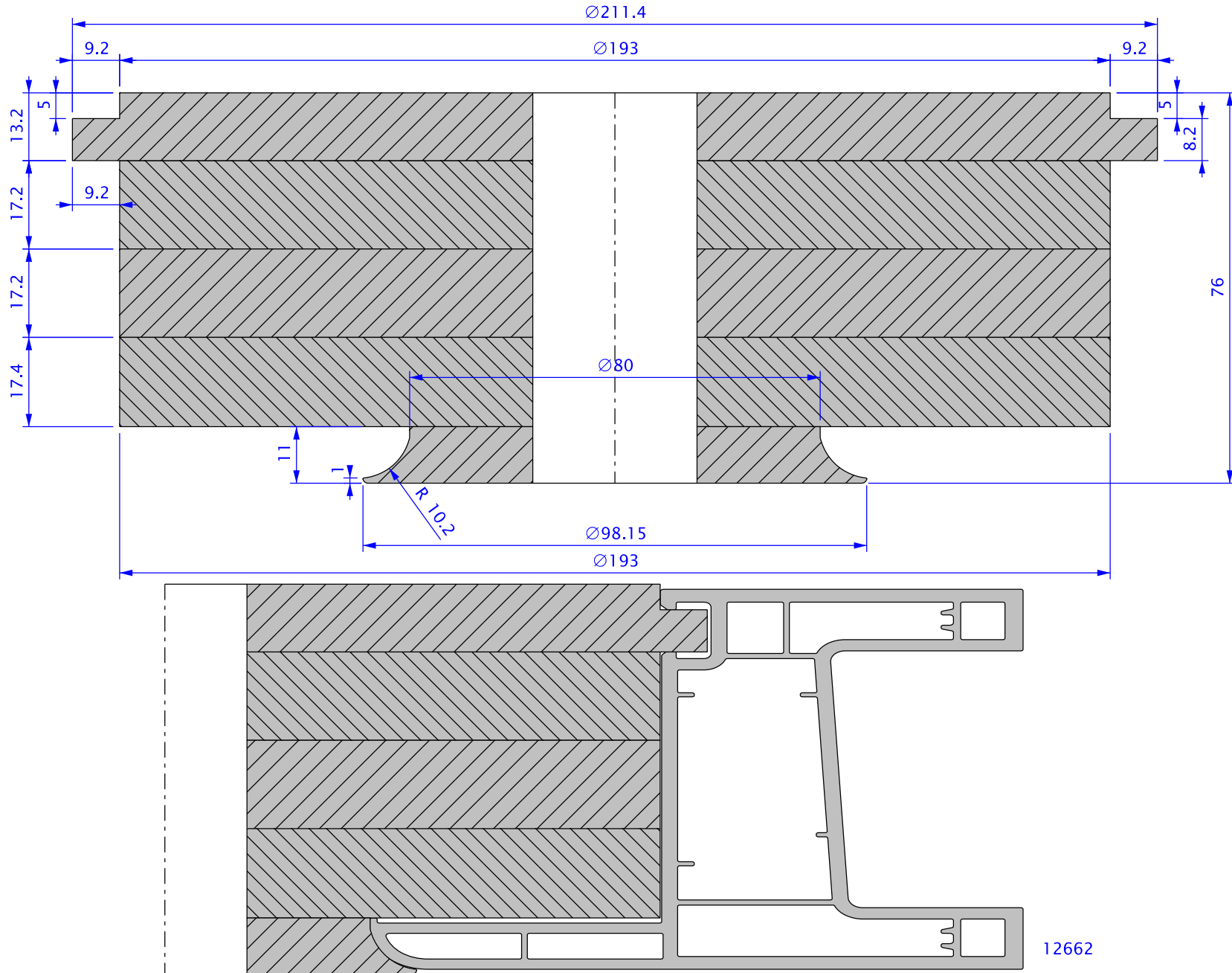


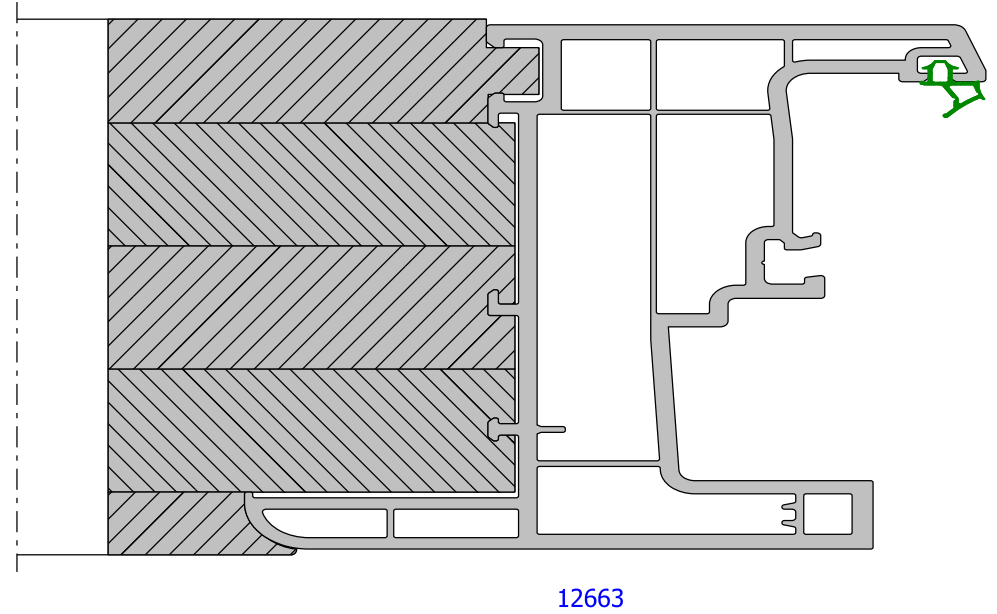
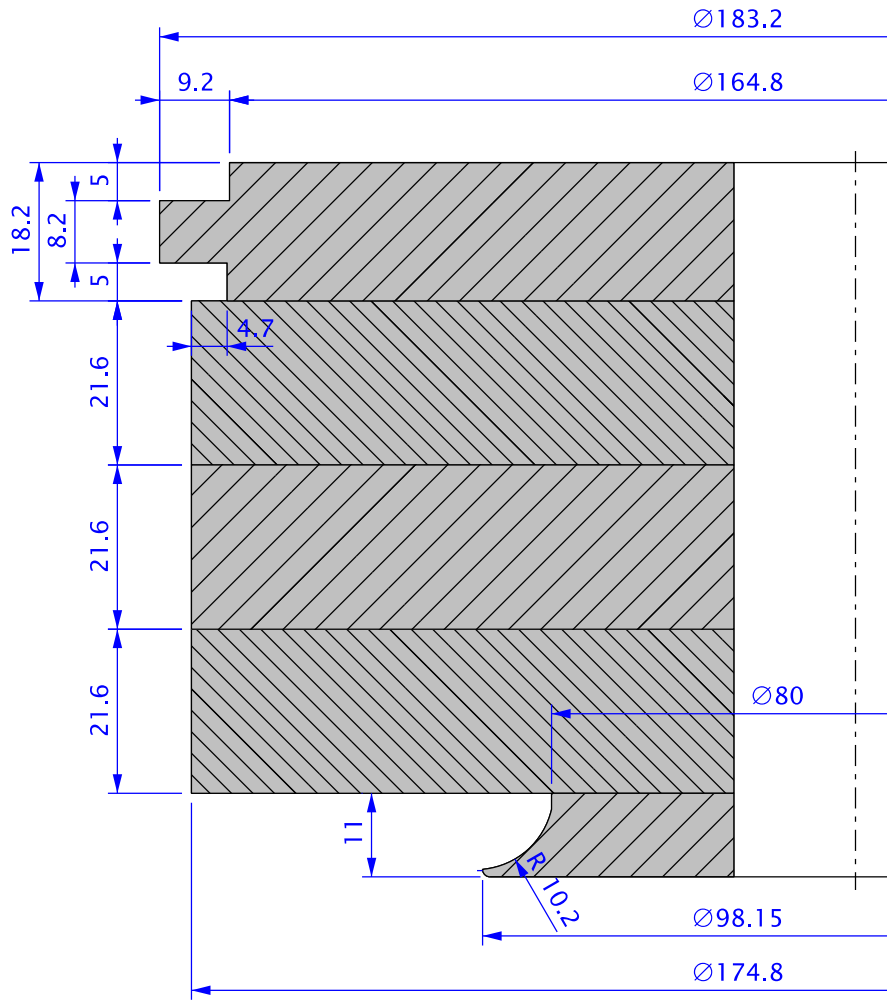


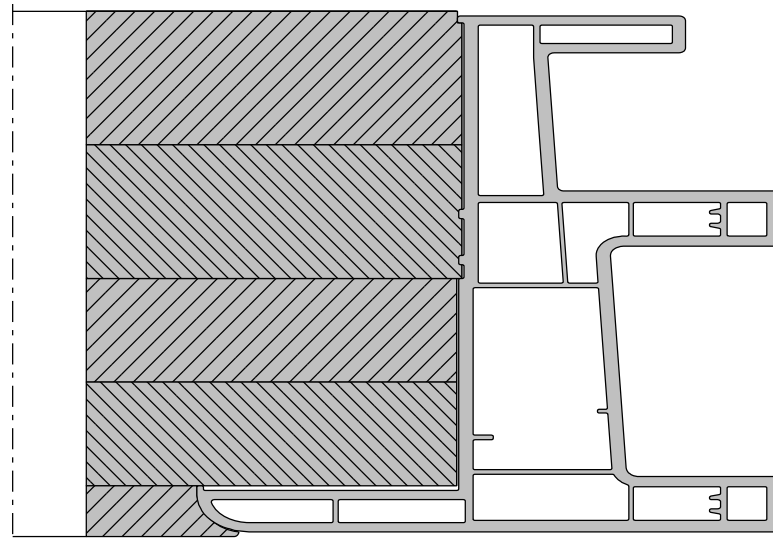
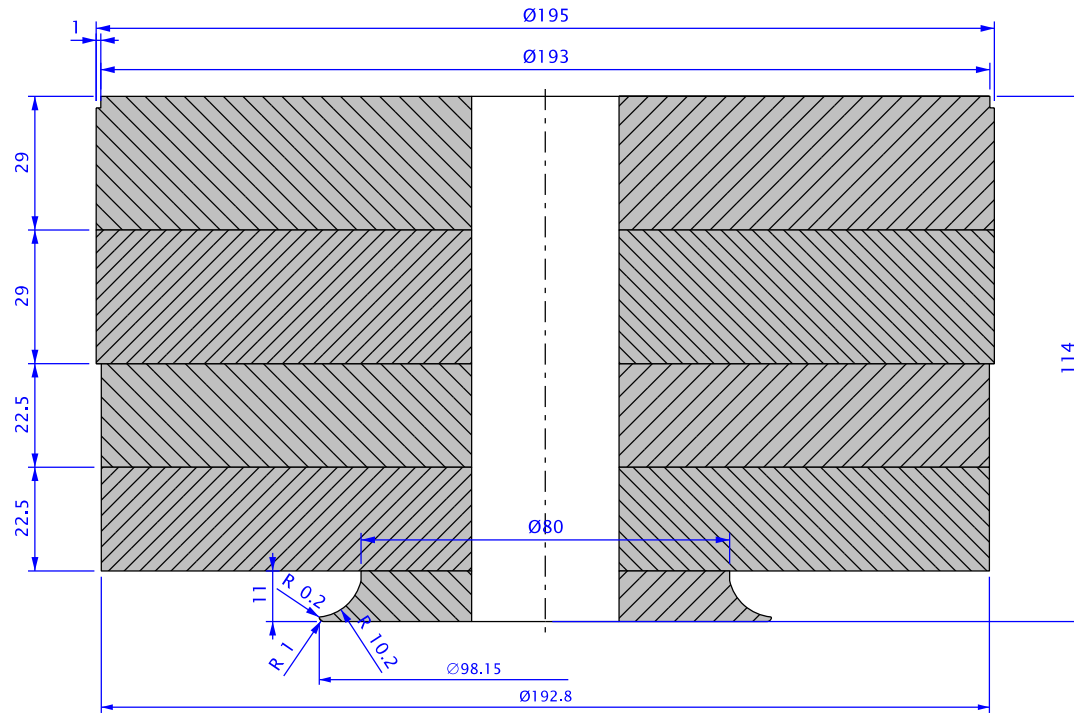


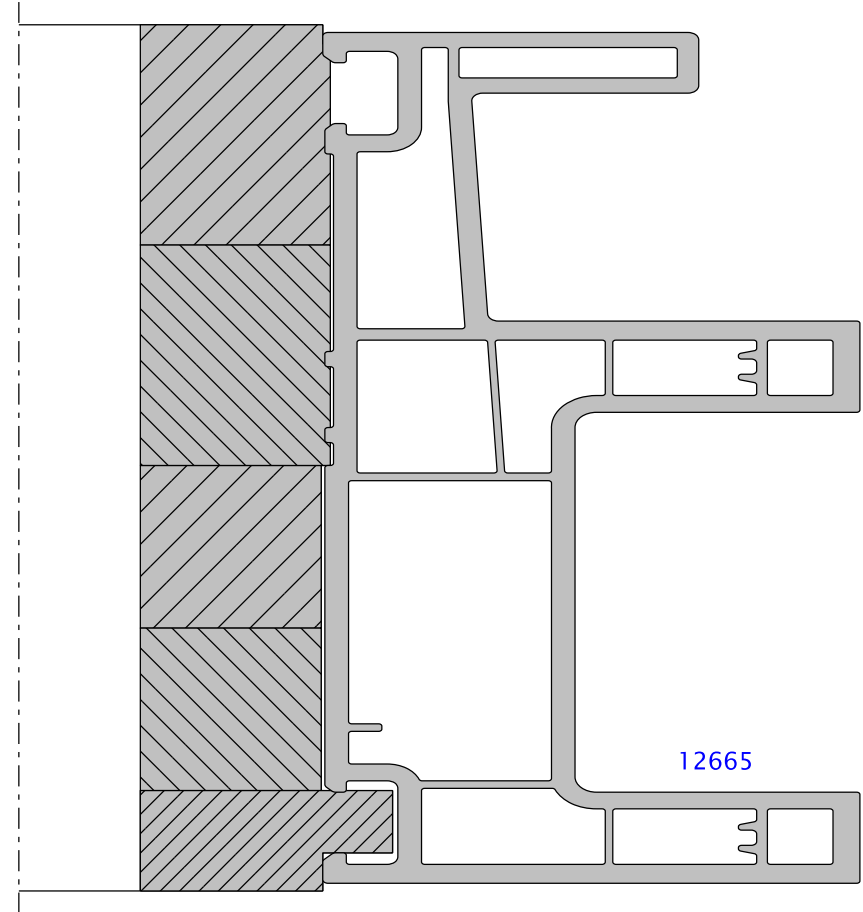
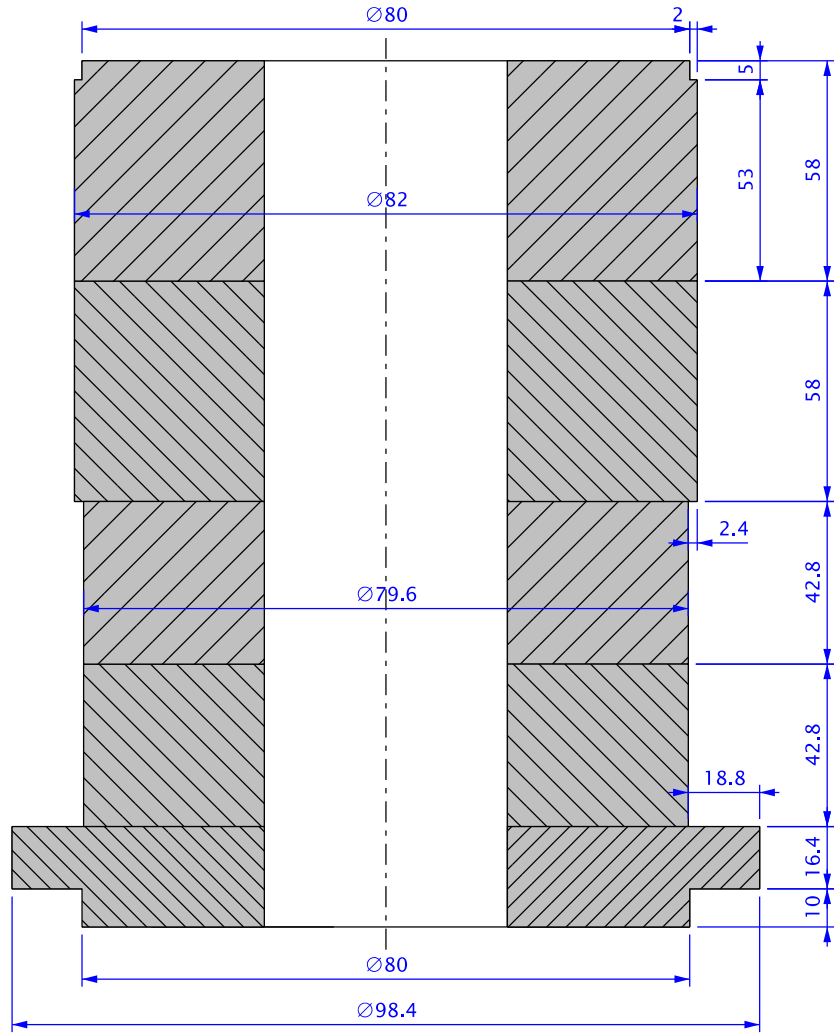
12660

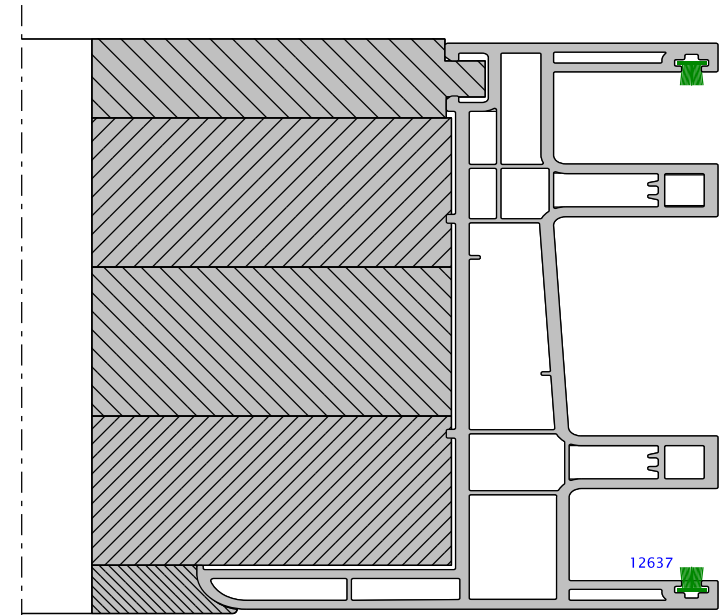
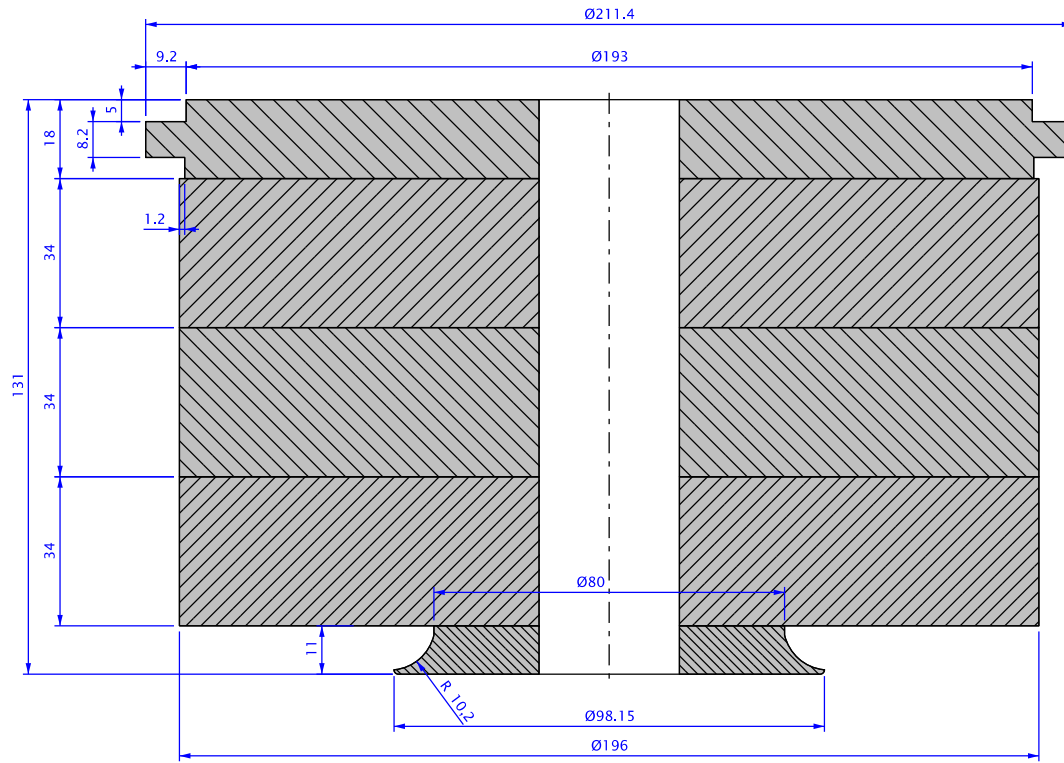


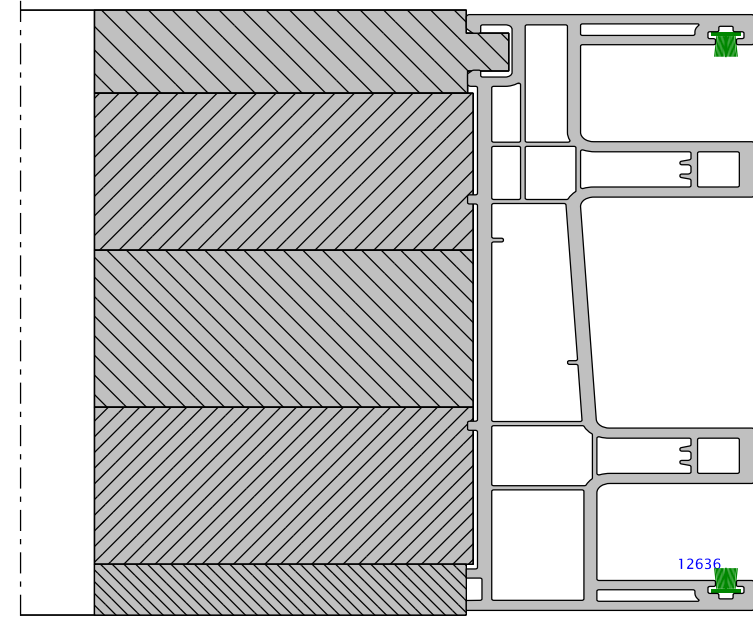
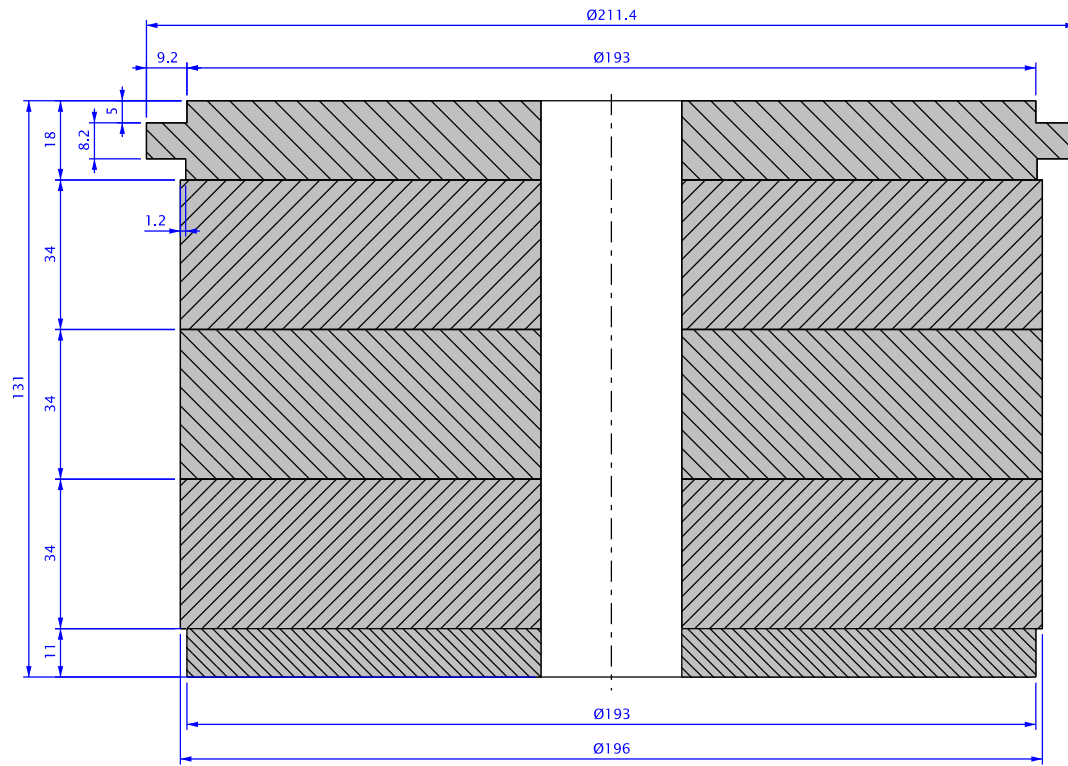


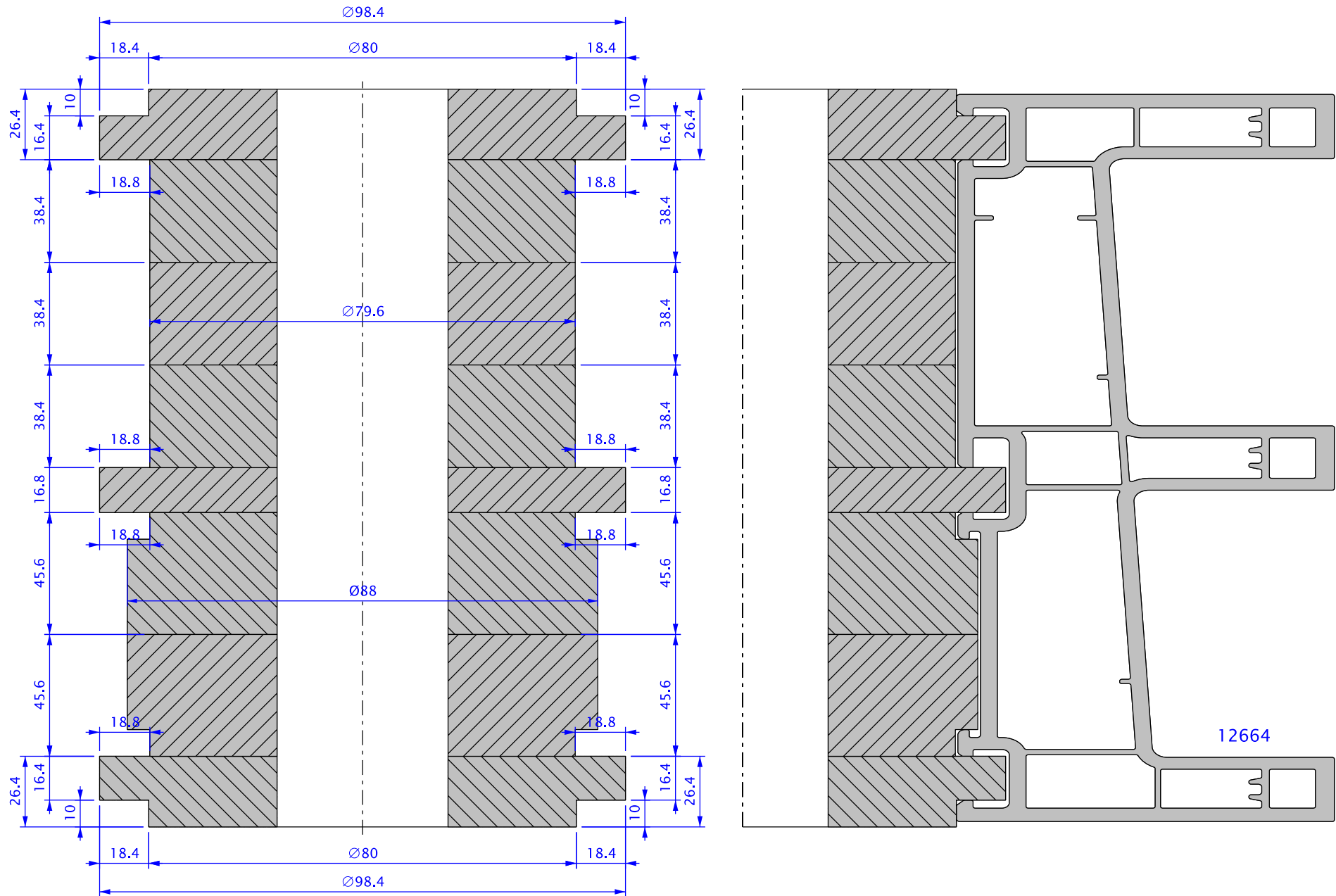




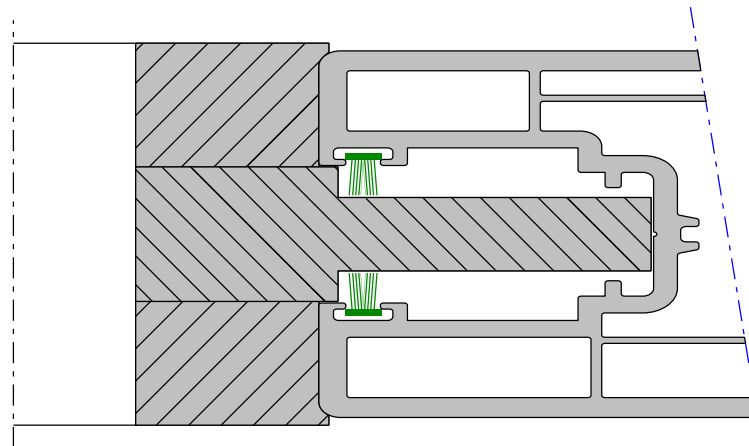
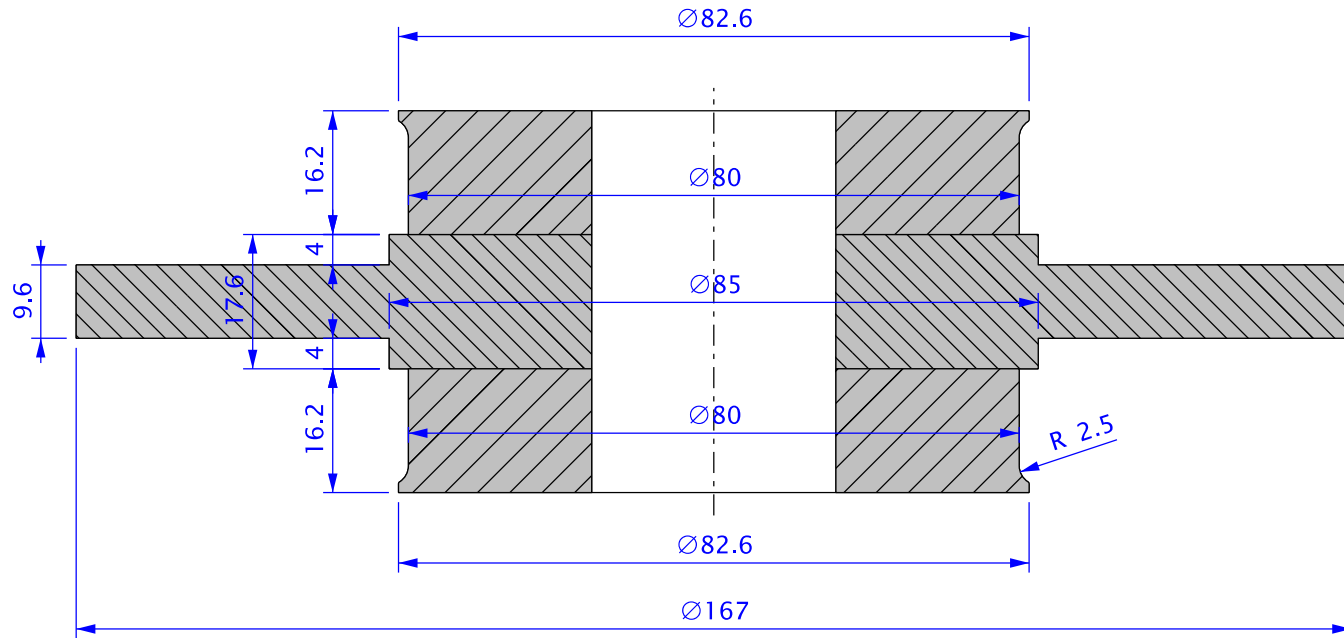






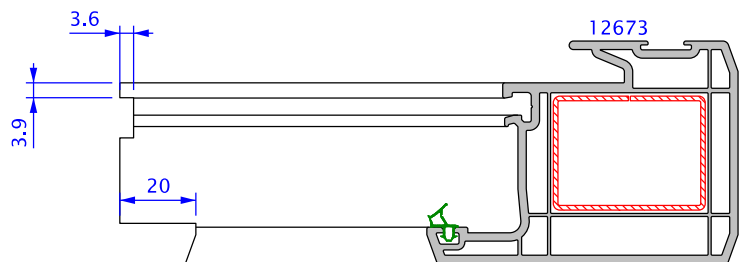
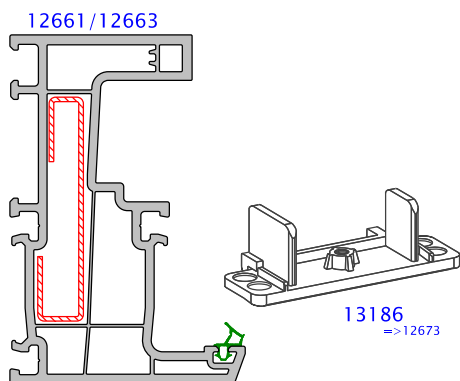
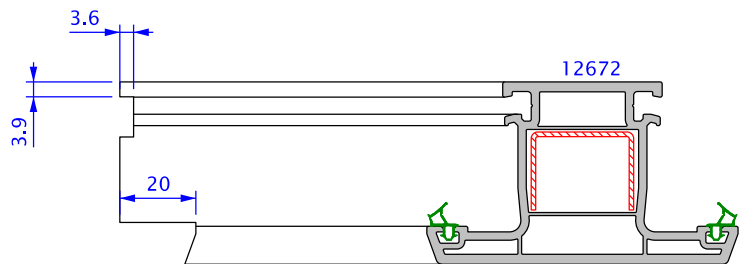
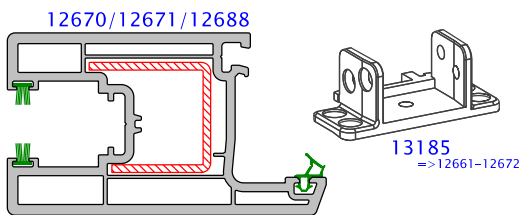
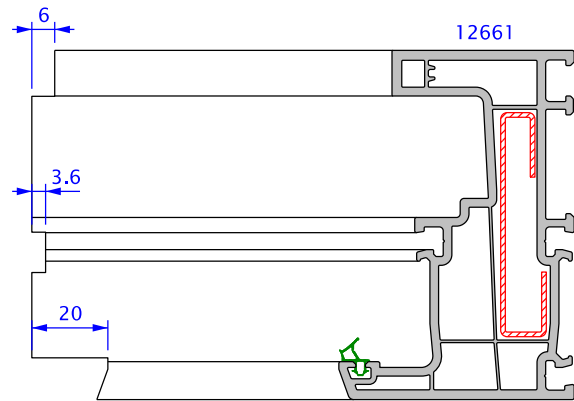
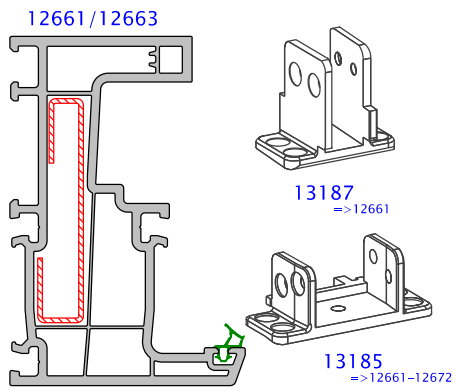
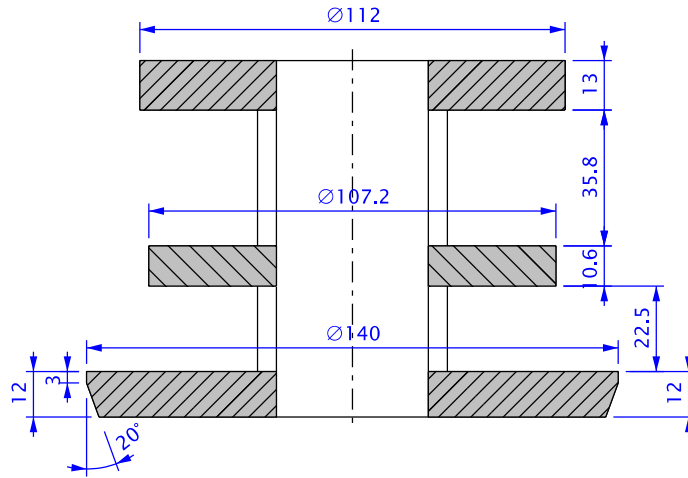


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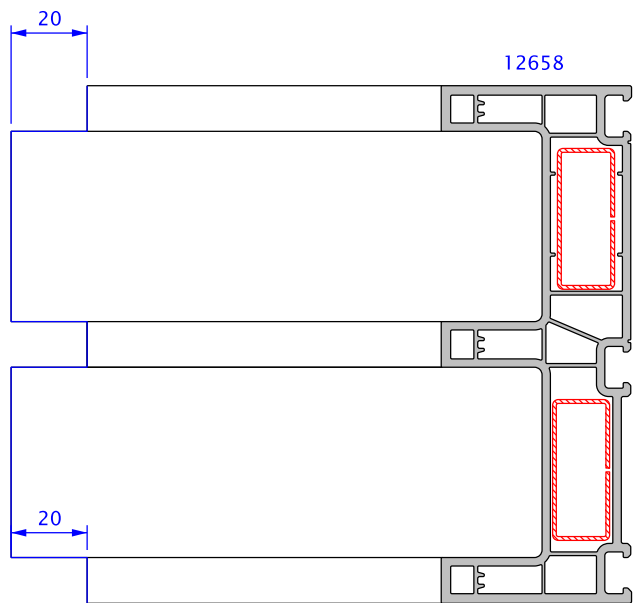
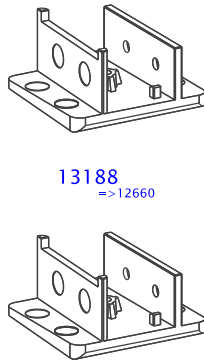
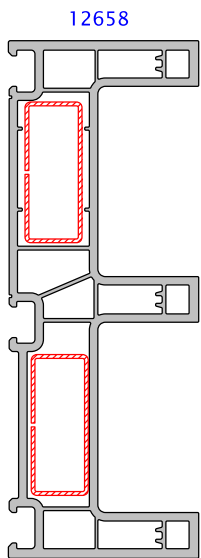
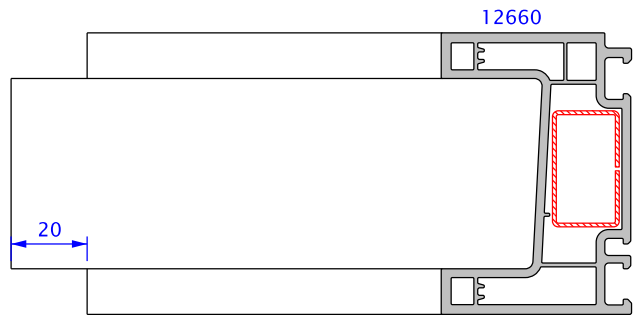
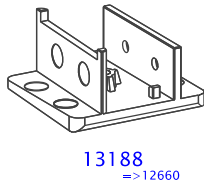
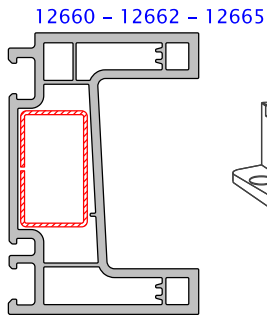
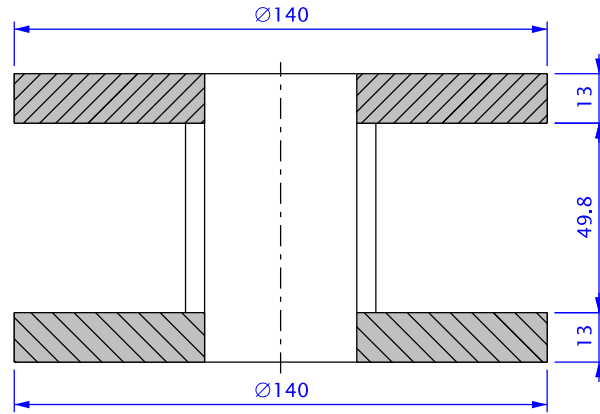


12670 / 12671 / 12688

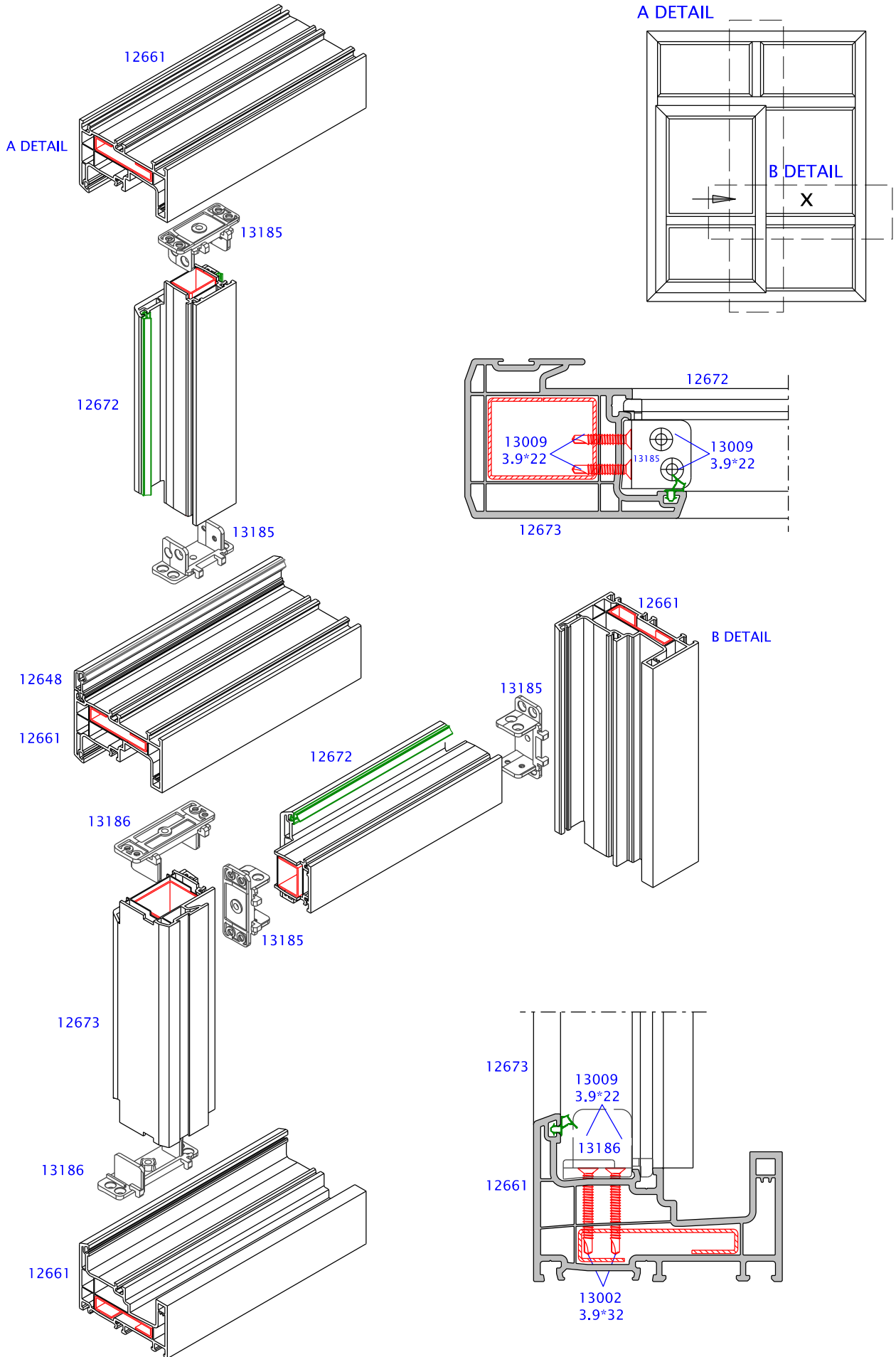
13795-End milling of sliding transom

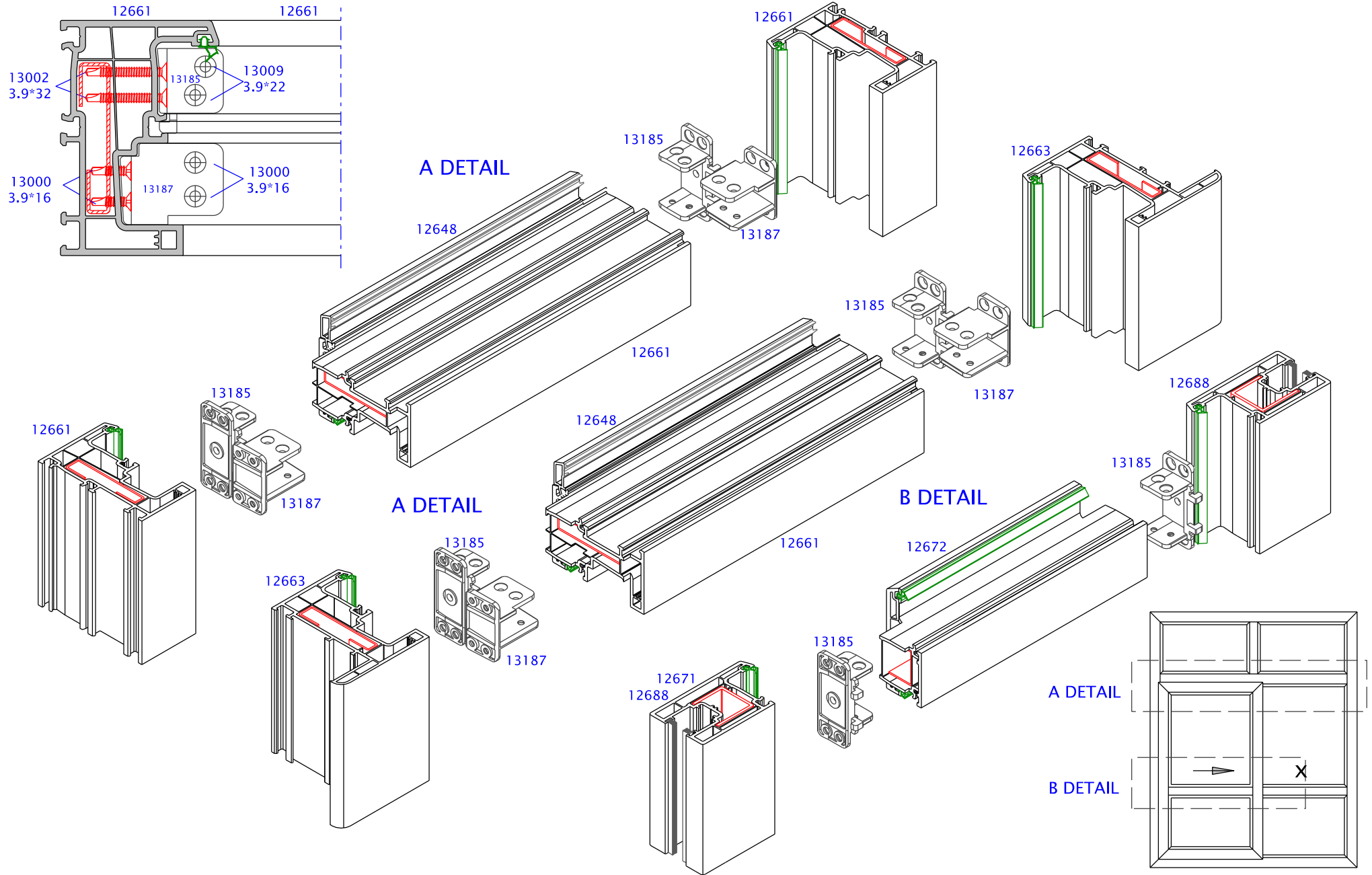


13796-End milling sliding of frame transom

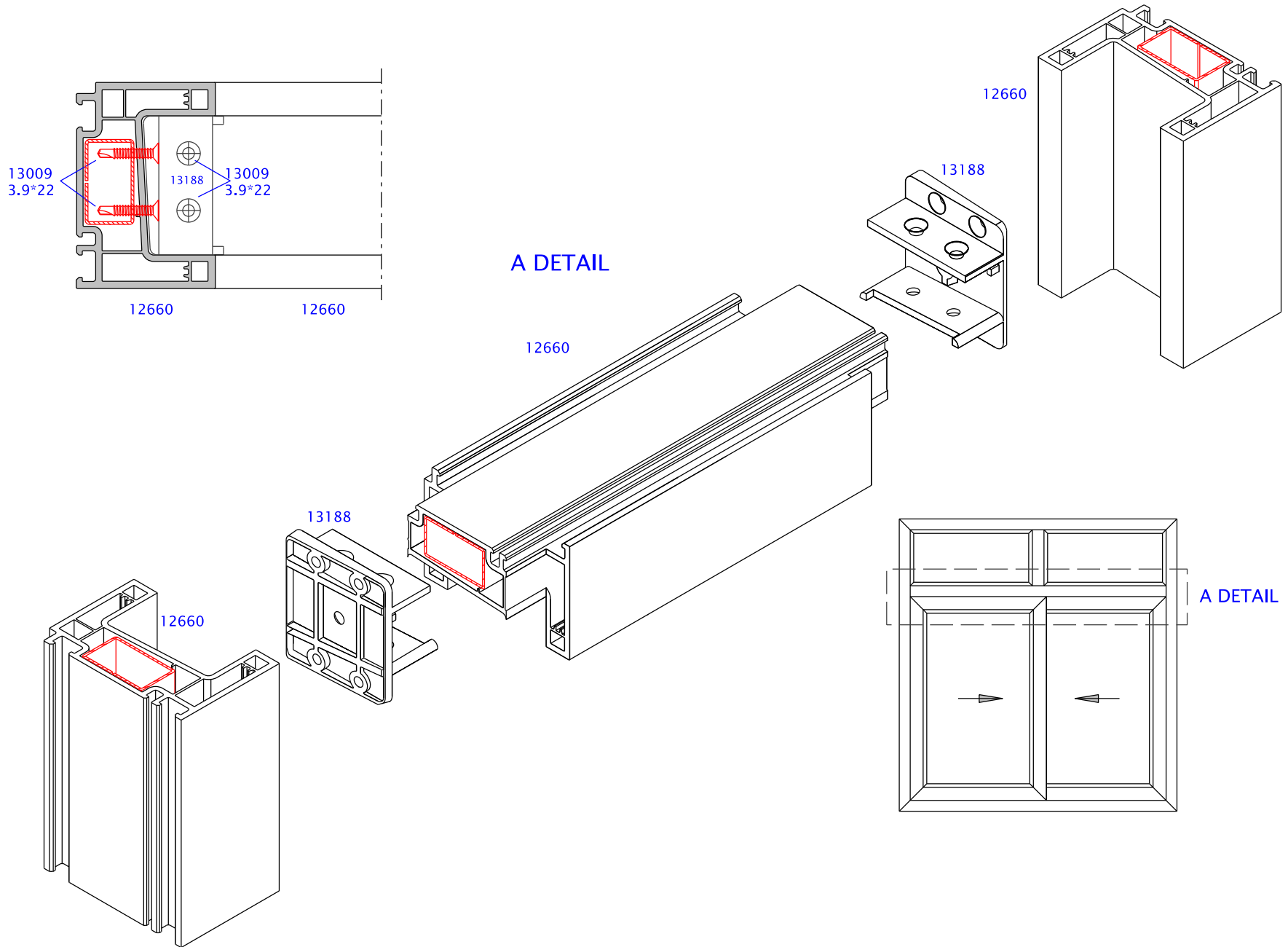


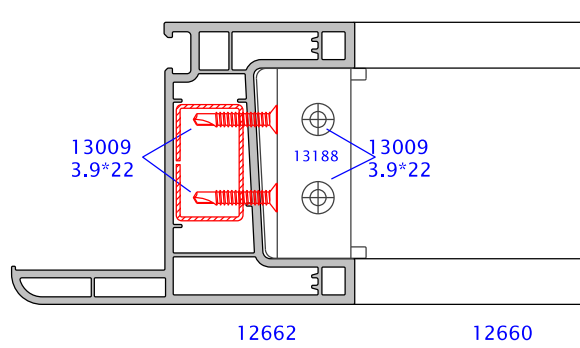
Ps: In the case of transom application of sliding 3 tracks frame, profile should be upside down on the plate.





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A DETAYI

12662

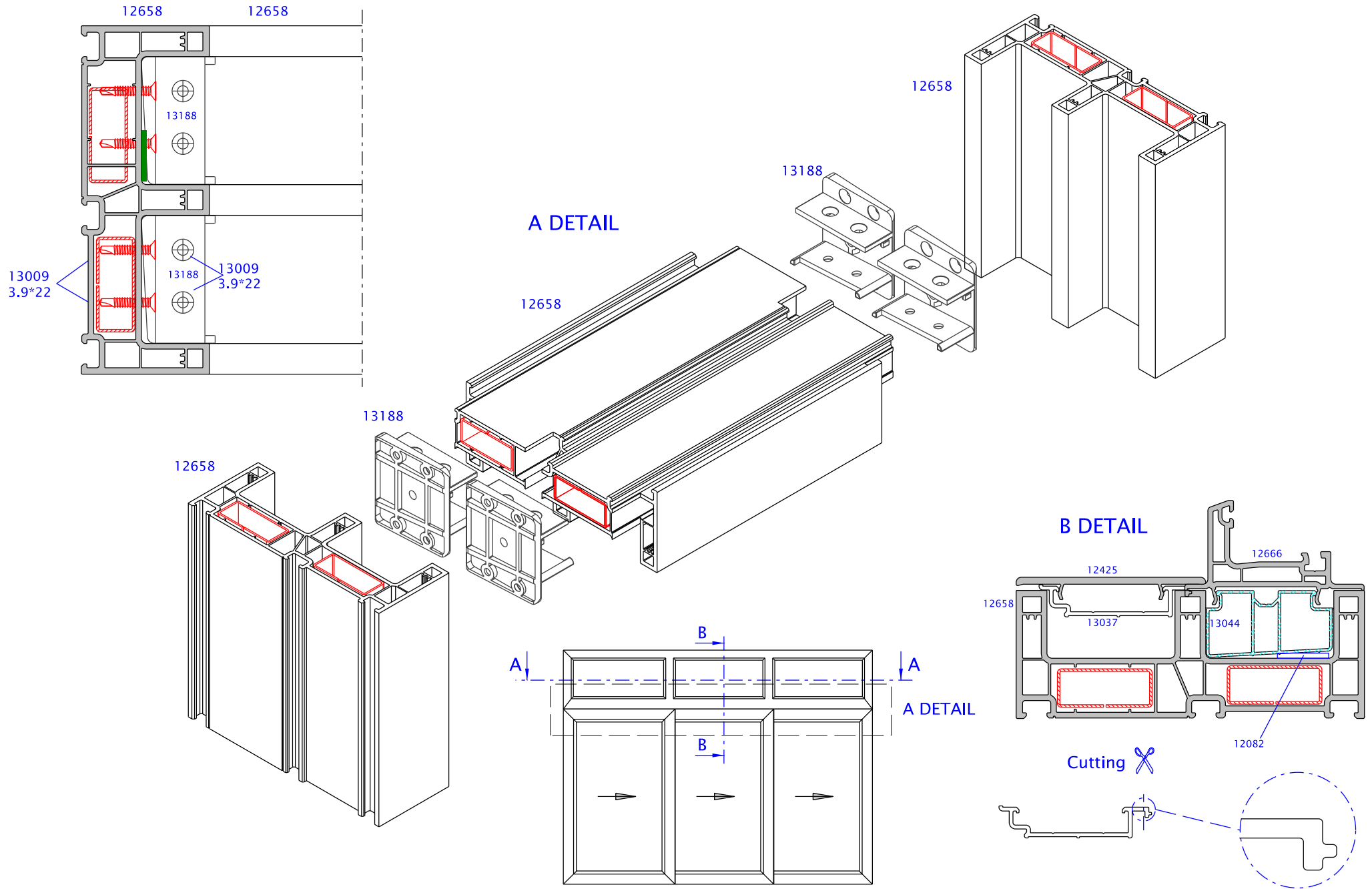
13188

12660

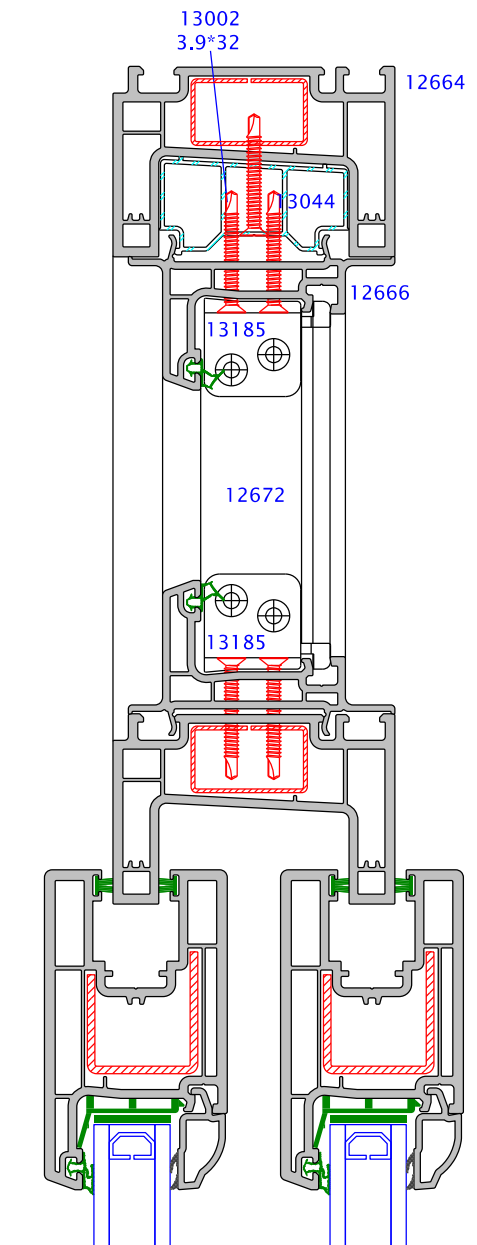
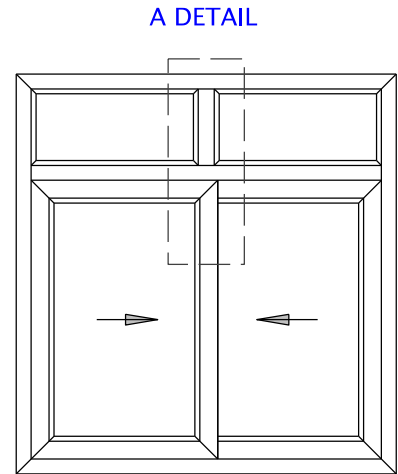
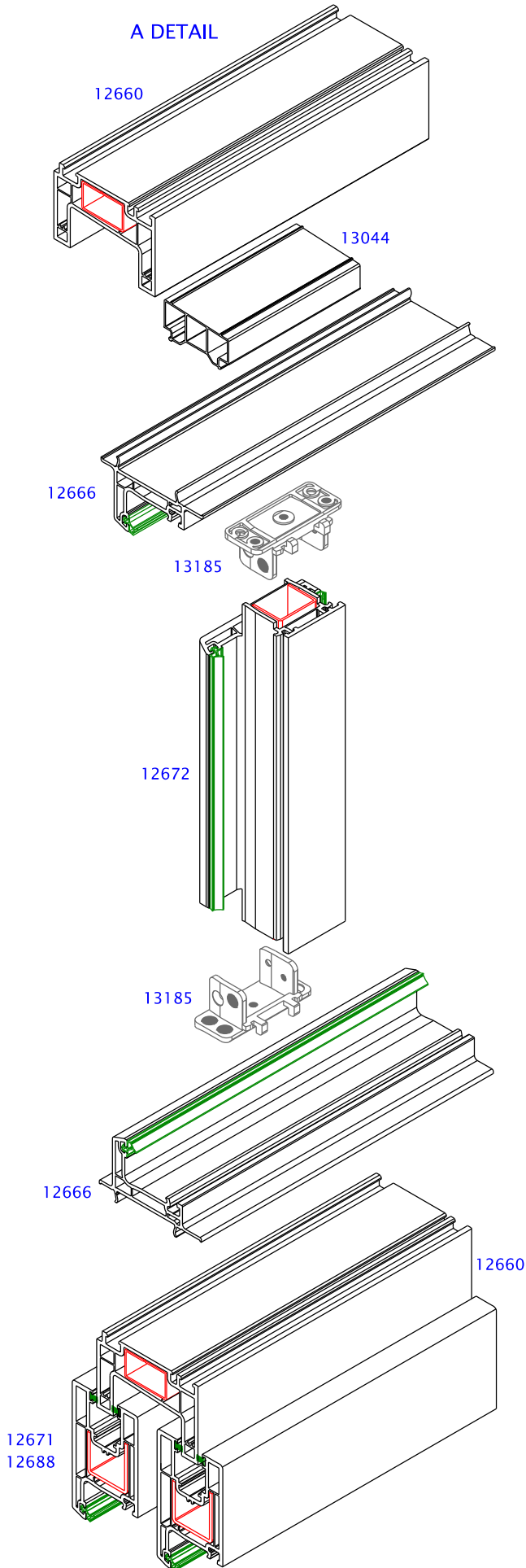
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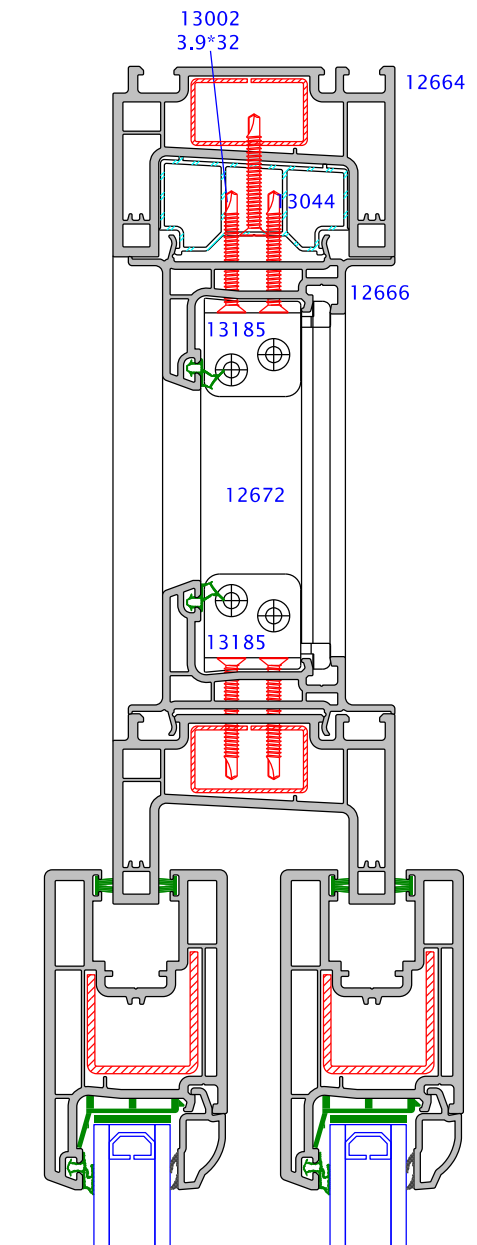
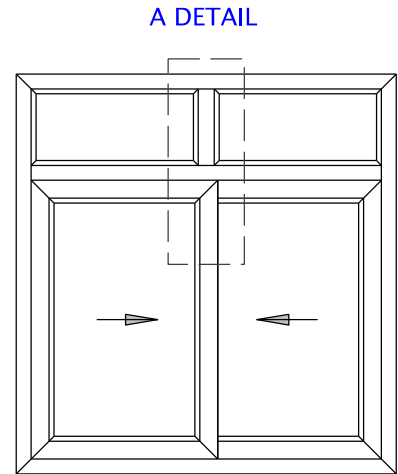
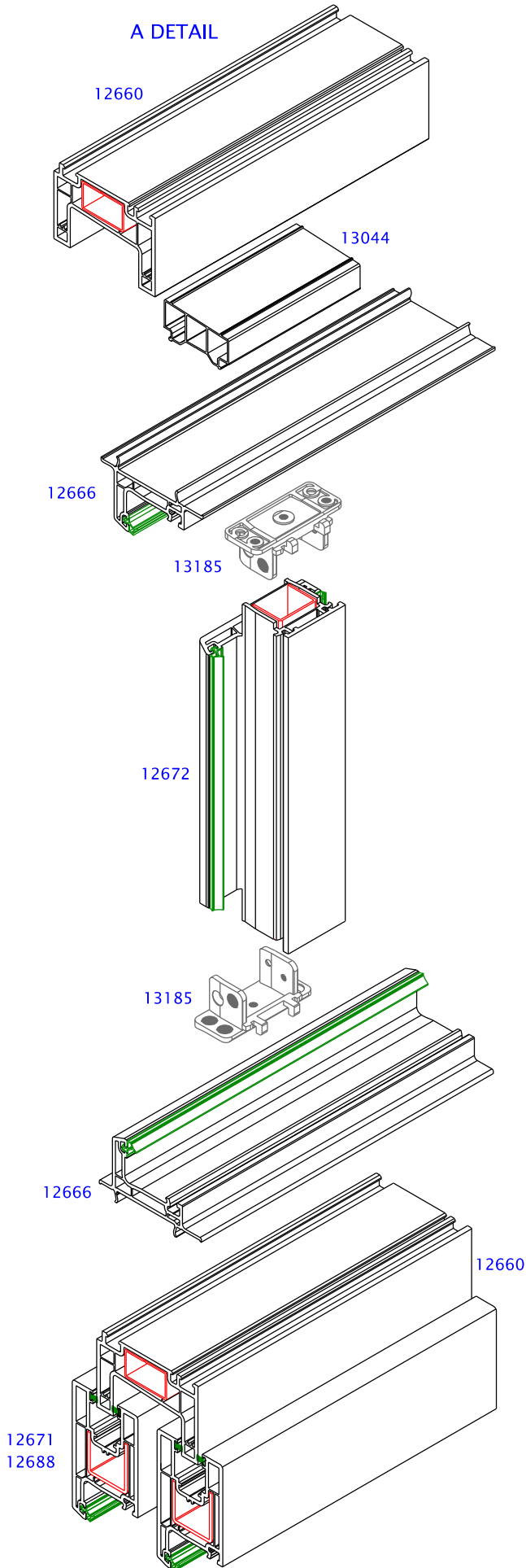
12662

A DETAIL

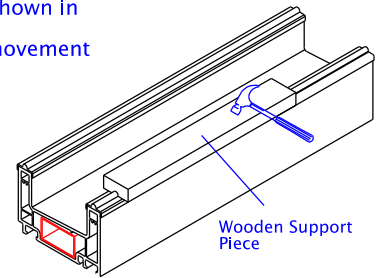


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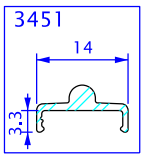


* It is advised that sliding aluminium rails must be installed by using wood support pieces as shown in the picture. If the rail is hammered directly, aluminium profile can be deformed and it effects the movement of sashes negatively.

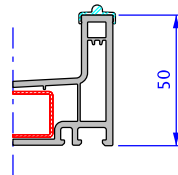


- * 12660, 12661 and 12663 (for white colours) => Sliding rail 14mm (3451) is used
- * 12660, 12661, and 12663 (for laminated colours) => Sliding rail 14,5mm (3452) is used
- * Sliding frames (12660) which has laminated one side (1XXX or 2XXX) both rails can be used (for the white side, 3451; laminated side 3452)
- * 3451 and 3452 have very similar designs. Sliding rail 14.5 (3452) which is used with laminated colored profile has a groove at bottom.

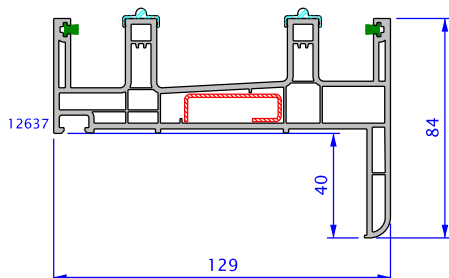
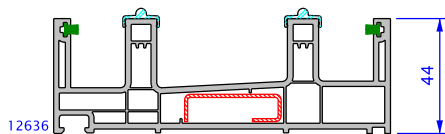
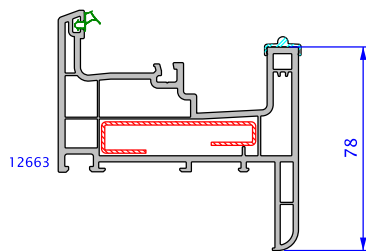
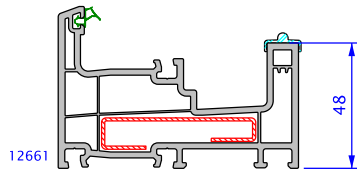
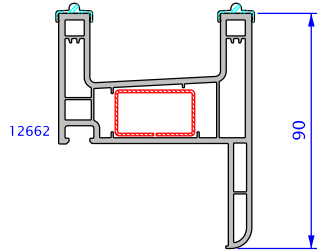
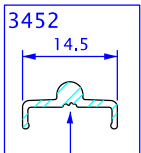
=> for white profiles



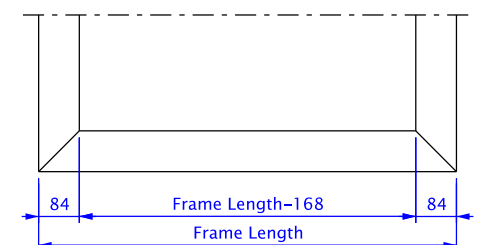
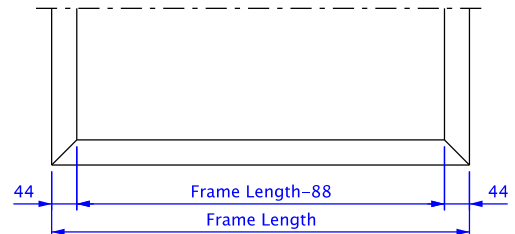
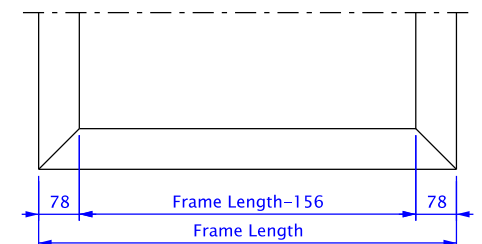
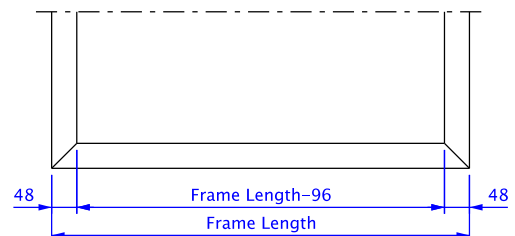
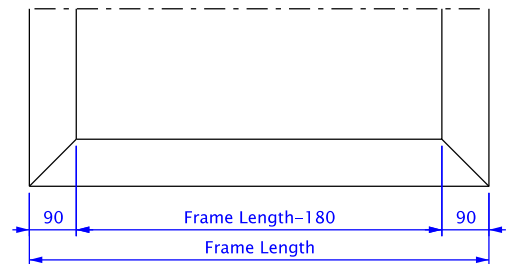
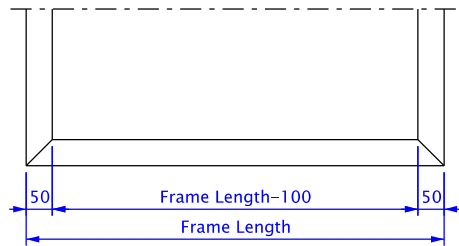
12660
12658
12665
12684



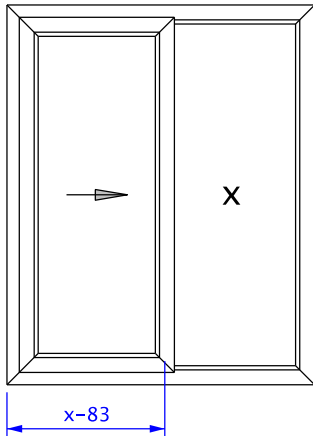
=> for laminated profiles



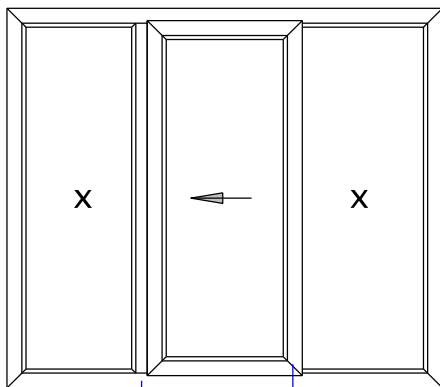
CUTTING SIZE of SLIDING RAIL



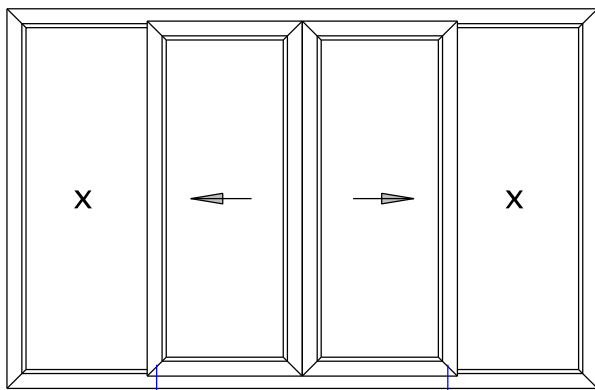
- * Cutting length of aluminium threshold (13042) is calculated from the axe points.
- * Aluminium threshold is endmilled , then brush (10578) which has the dimension of 48x1000 is inserted on the aluminium profile
- * Endmilled aluminium profile is clipped on frame.



Sample 1 :
Axe point: 1000mm
 $1000-83= 917\text{mm}$

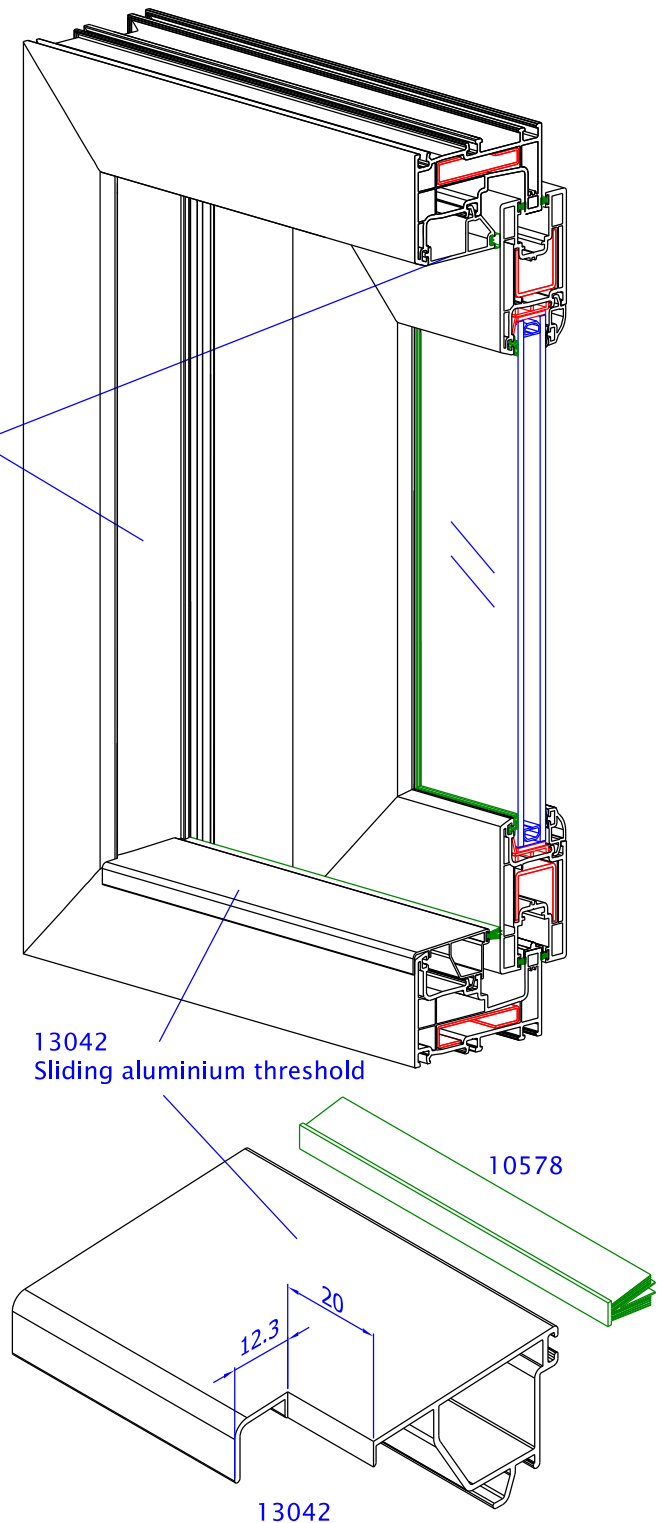


Sample 2 :
Axe point: 1000 mm
 $1000-62= 938\text{ mm}$



Sample 3 :
Axe point: 2000 mm
 $2000-82= 1918\text{ mm}$

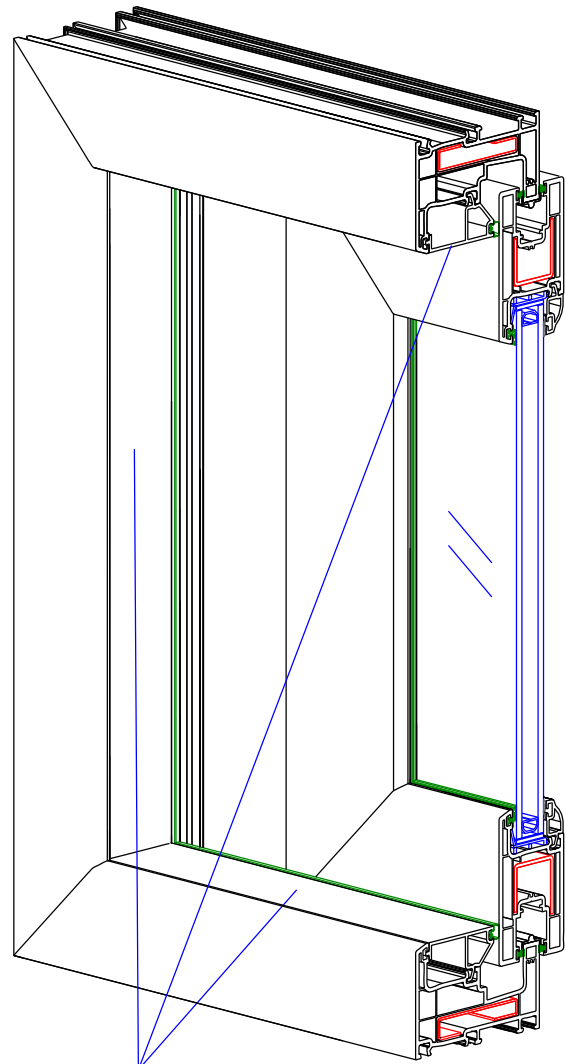
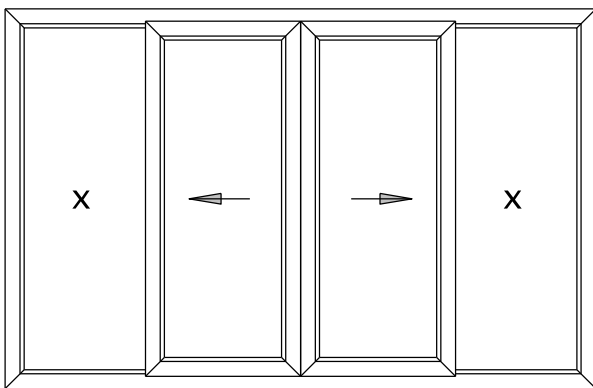
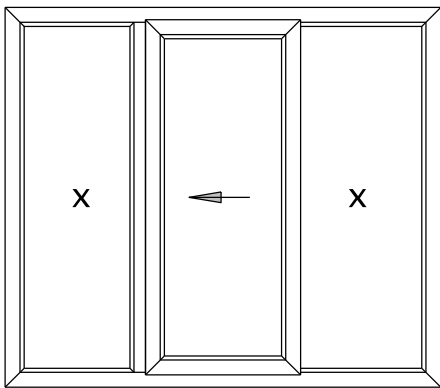
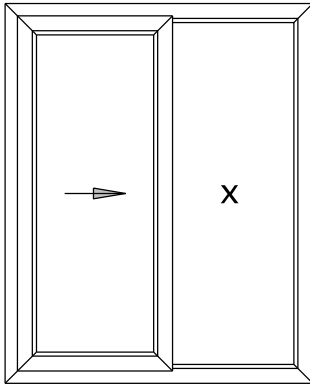
- * After the aluminium threshold is mounted on frame
- * Sliding closing (12679) is placed on sides and top of frame



Note : In this type of sliding windows (Sample 3) there is no need to endmilling the aluminium threshold.

* In the application of fixed-sliding frames , sliding closing (12679) profiles are used on back sides of movable sashes as 2 pieces horizontal and one piece as vertically.

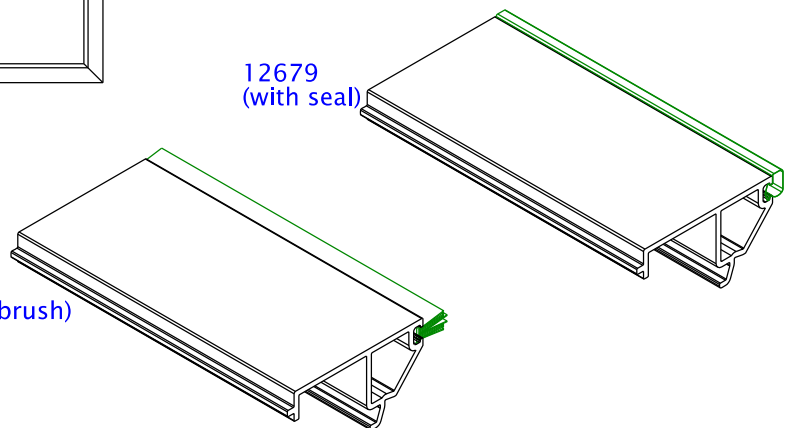
Profile should be cut 45° on corners.It can include seal or brush according to the application.

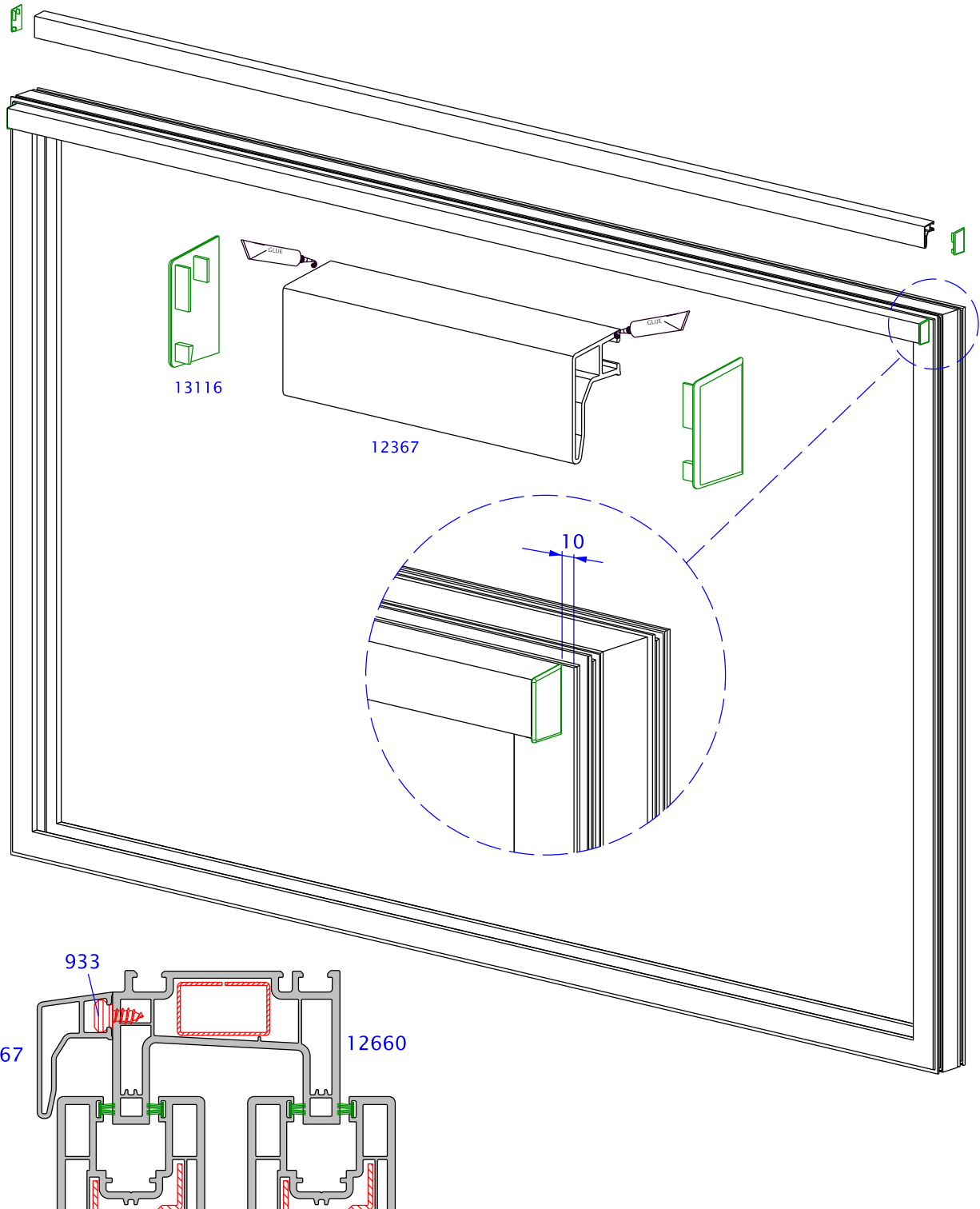


12679
Sliding closing

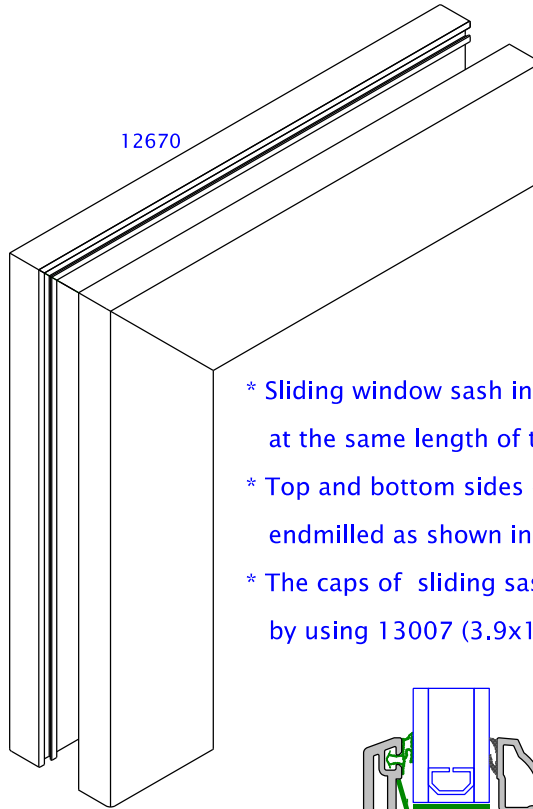
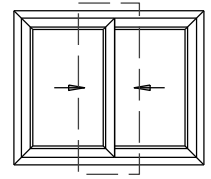
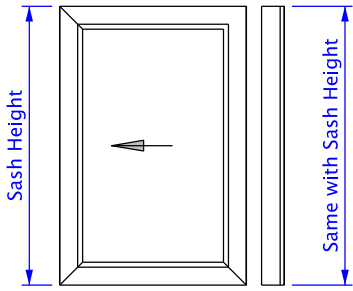
12679
(with seal)

12679
(48x1000 brush)





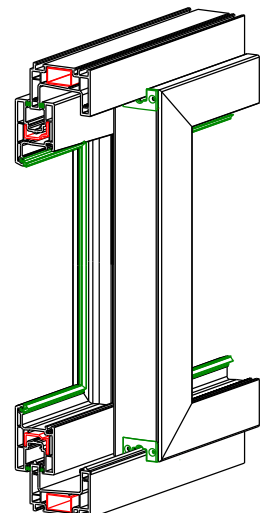
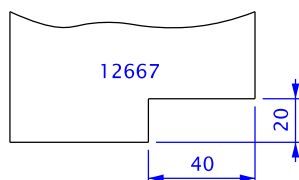
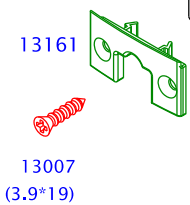
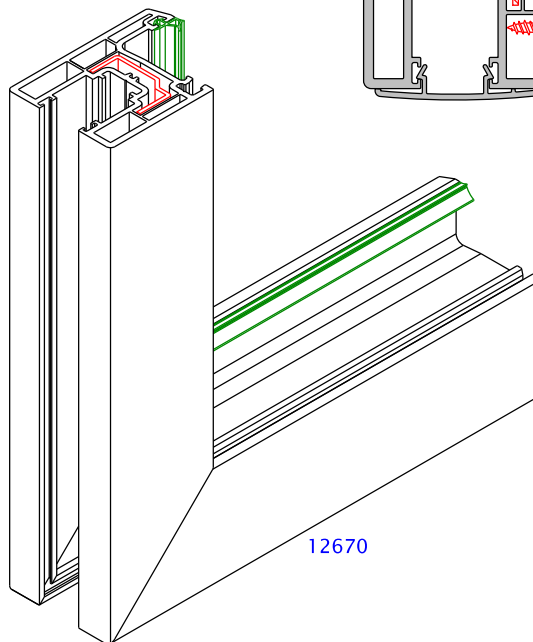
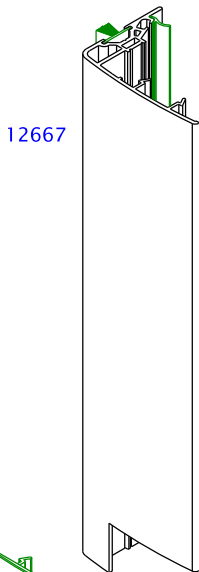
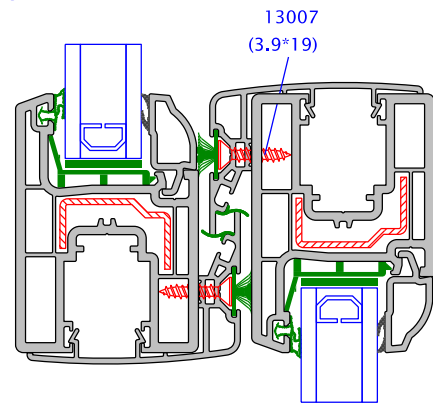
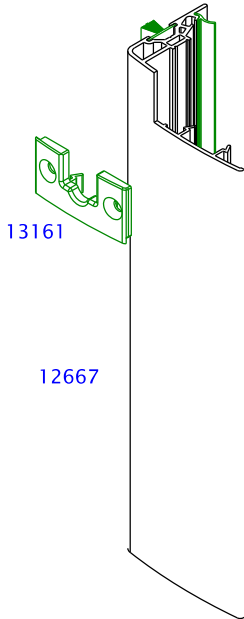
- * Sliding recess profile blocks the water that falling down directly to outside of sliding sash,
- * Clip screw(933) is fixed on the top-outside of the frame horizontally,
- * Sliding recess profile (12367) is hammered on these screws using plastic malet,
- * Bonding of end caps should carefully be carried out using glue. (e.g. loctite). Bonding surfaces must be clean, dry and free from grease.
- * Sliding recess endcap (13116) is used to cover the sides of the profile,
- * This profile is not used with sliding flyscreen , roller shutter and stor flyscreen
- * For the frames (12661/12663),since the sashes are moving on internal rail, therefore there is no need to use recess profile.

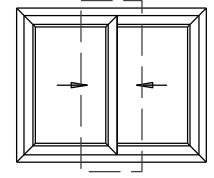
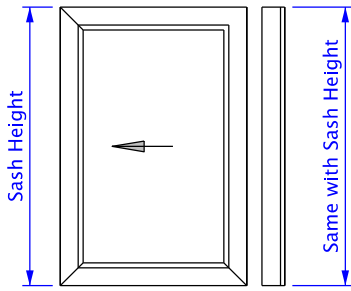


* Sliding window sash interlock (12667) should be cut at the same length of the sash.

* Top and bottom sides of profile are endmilled as shown in the picture.

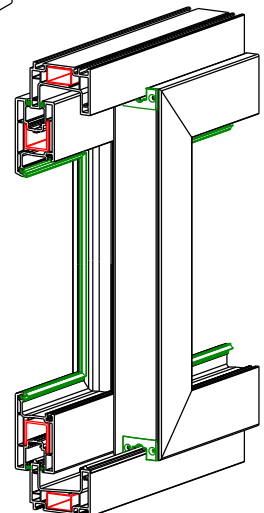
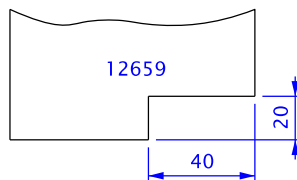
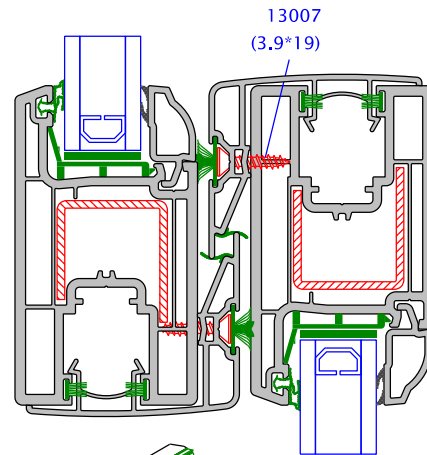
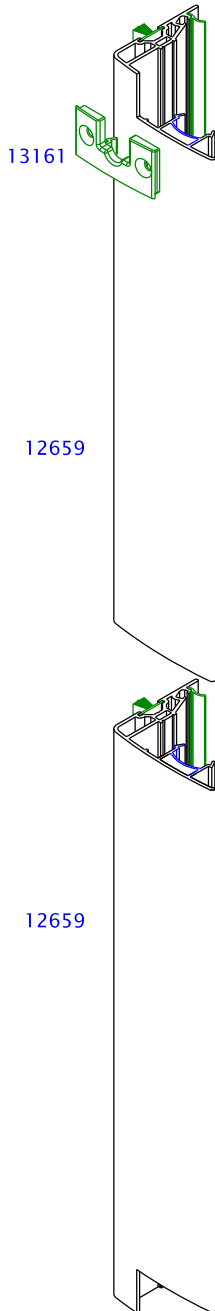
* The caps of sliding sash interlock (13161) is fixed by using 13007 (3.9x19-flathead) screw

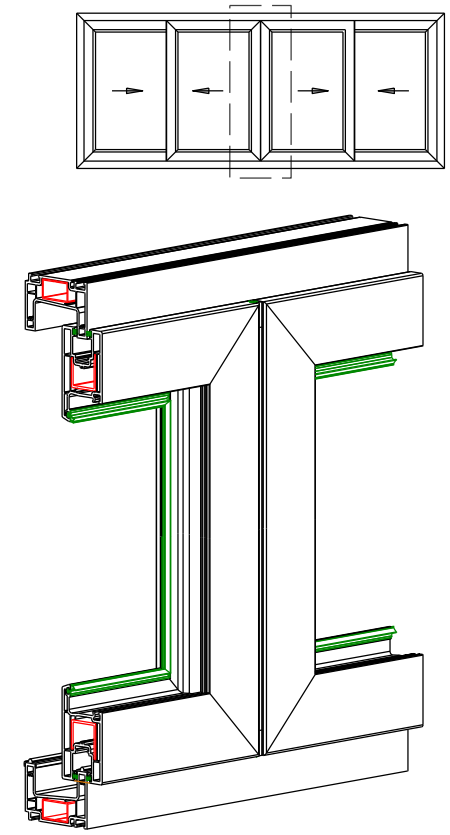
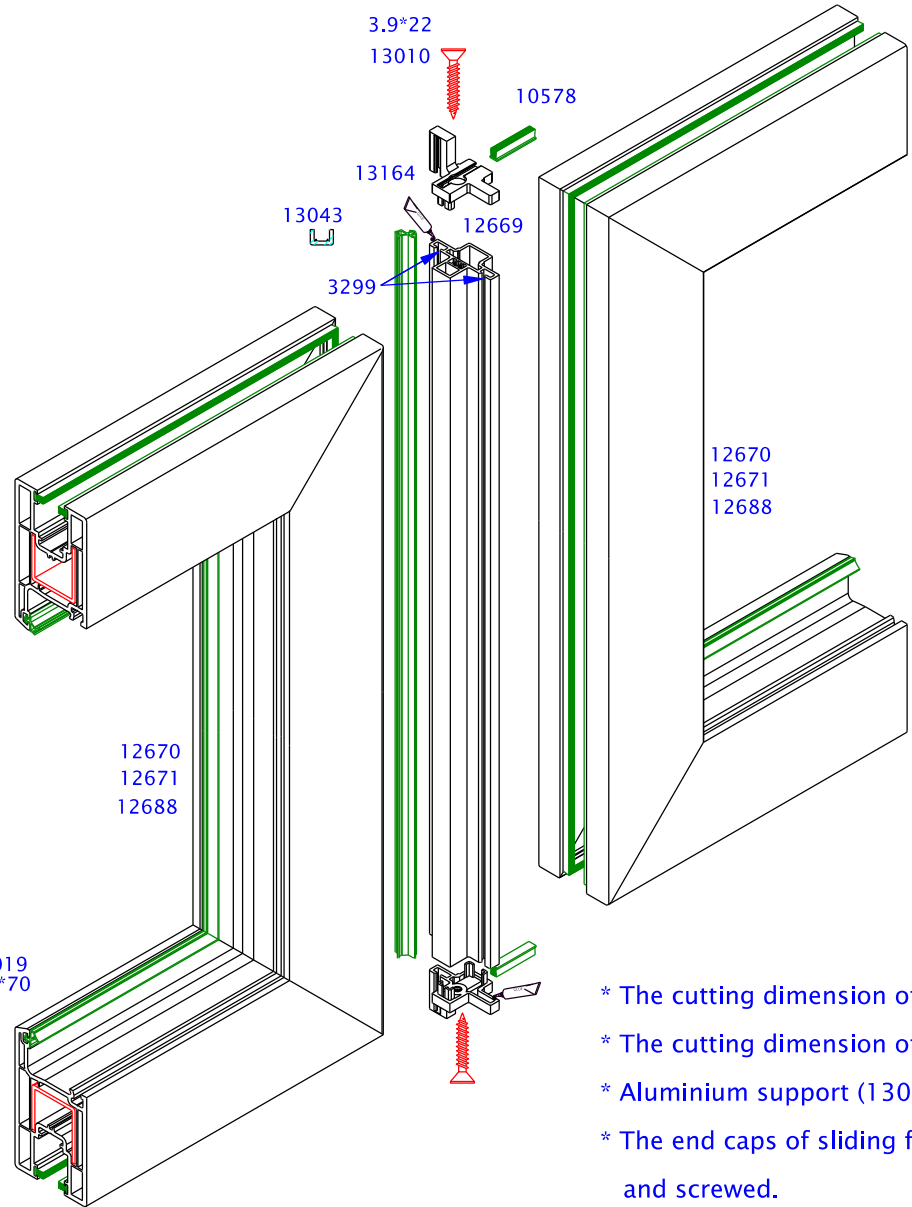
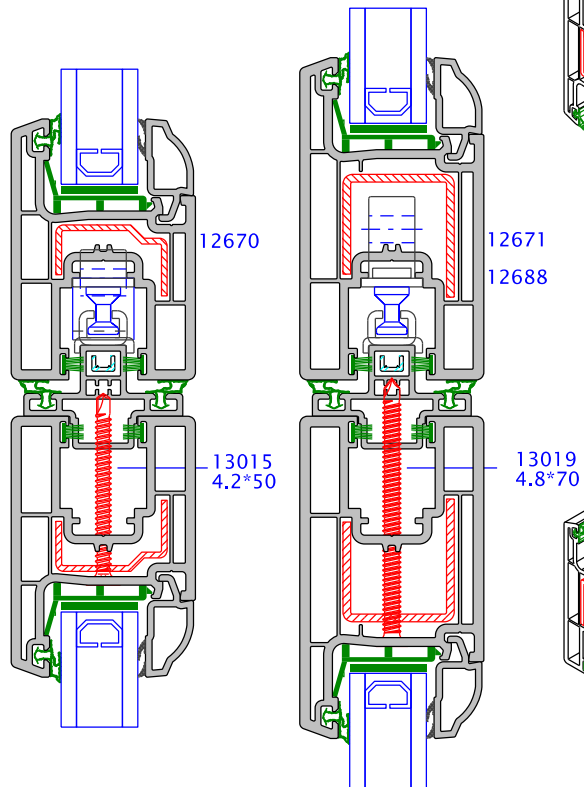
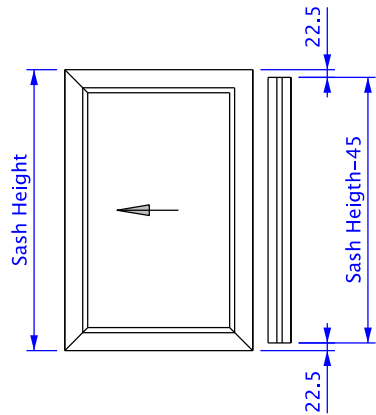




12671-12688

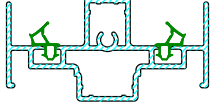
- * Sliding sash interlock (12659) should be cut at the same length of sash profile,
- * Top and bottom sides of profile (12659) are endmilled as shown in the picture,
- * The caps of sliding sash interlock (13161) are fixed by using 13007 (3.9x19 flat-head) screw.



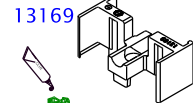


- * The cutting dimension of 12669 = Sash height - 45mm
- * The cutting dimension of 13043 = Height of 12669 - 20mm
- * Aluminium support (13043) profile is inserted into frame,
- * The end caps of sliding frontal closing (13164) should be glued and screwed.
- Then the brush (10578) which has the dimension of 48x1000 is inserted,
- * 3299 TPE seal is inserted on the 12669.

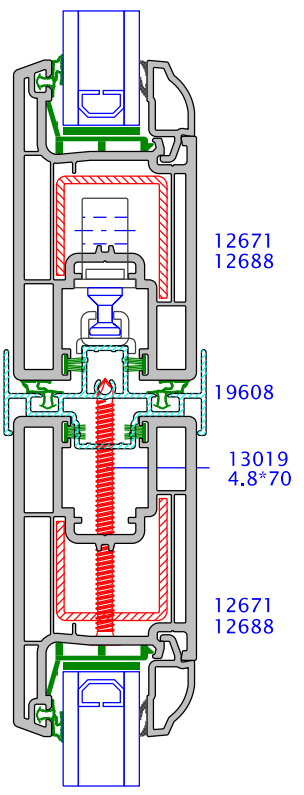
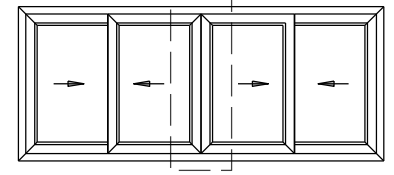
19608



3.9*22
13010



13169
19608
3299

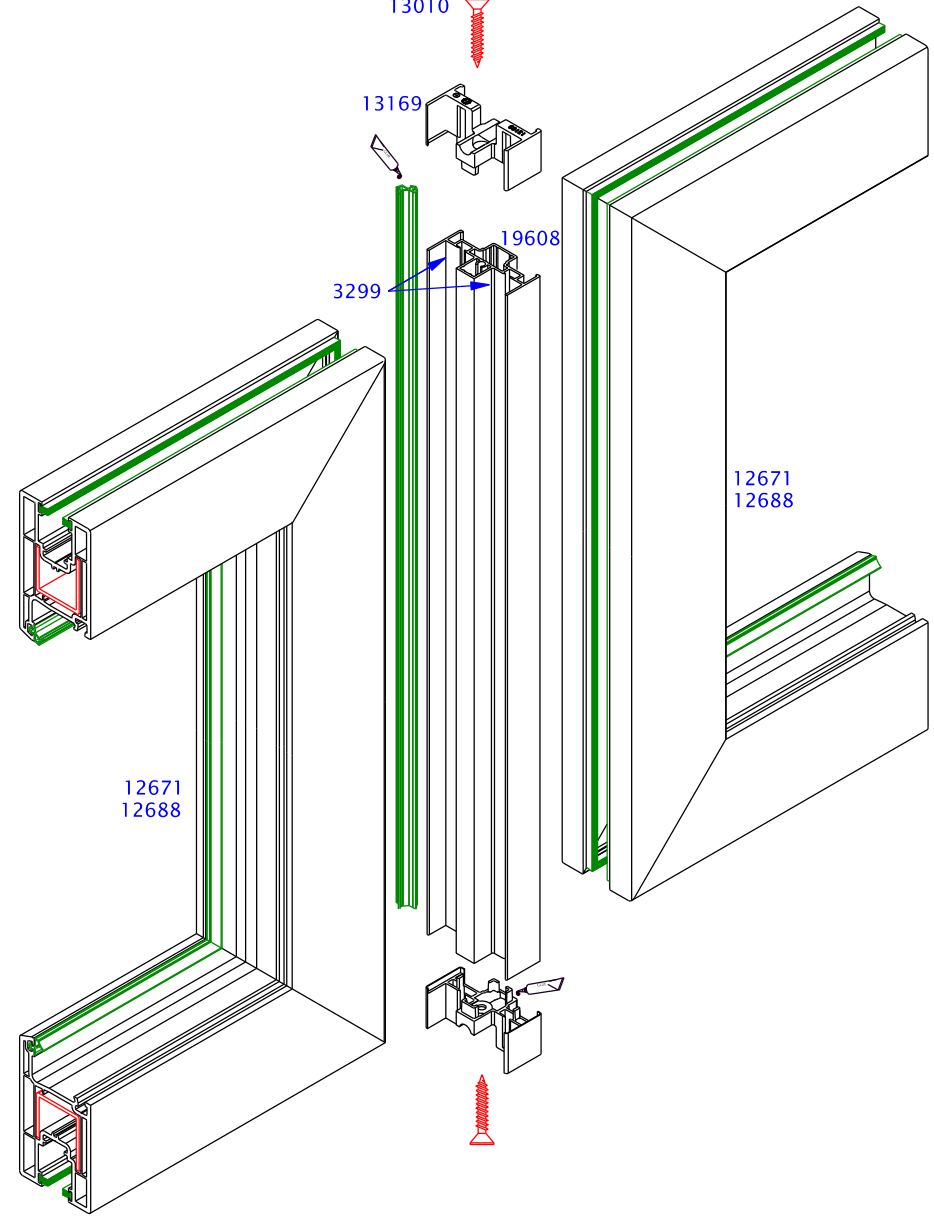


12671
12688

19608

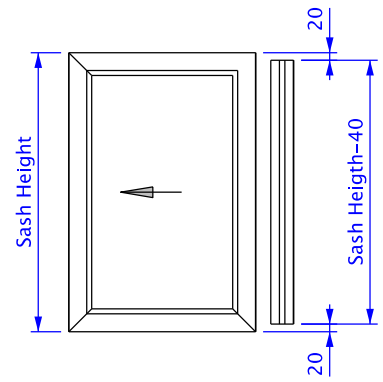
13019
4.8*70

12671
12688

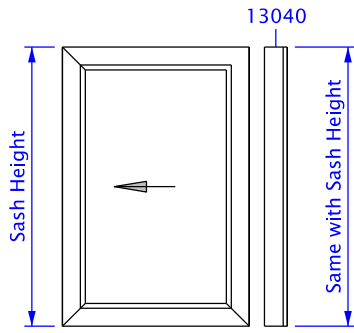


12671
12688

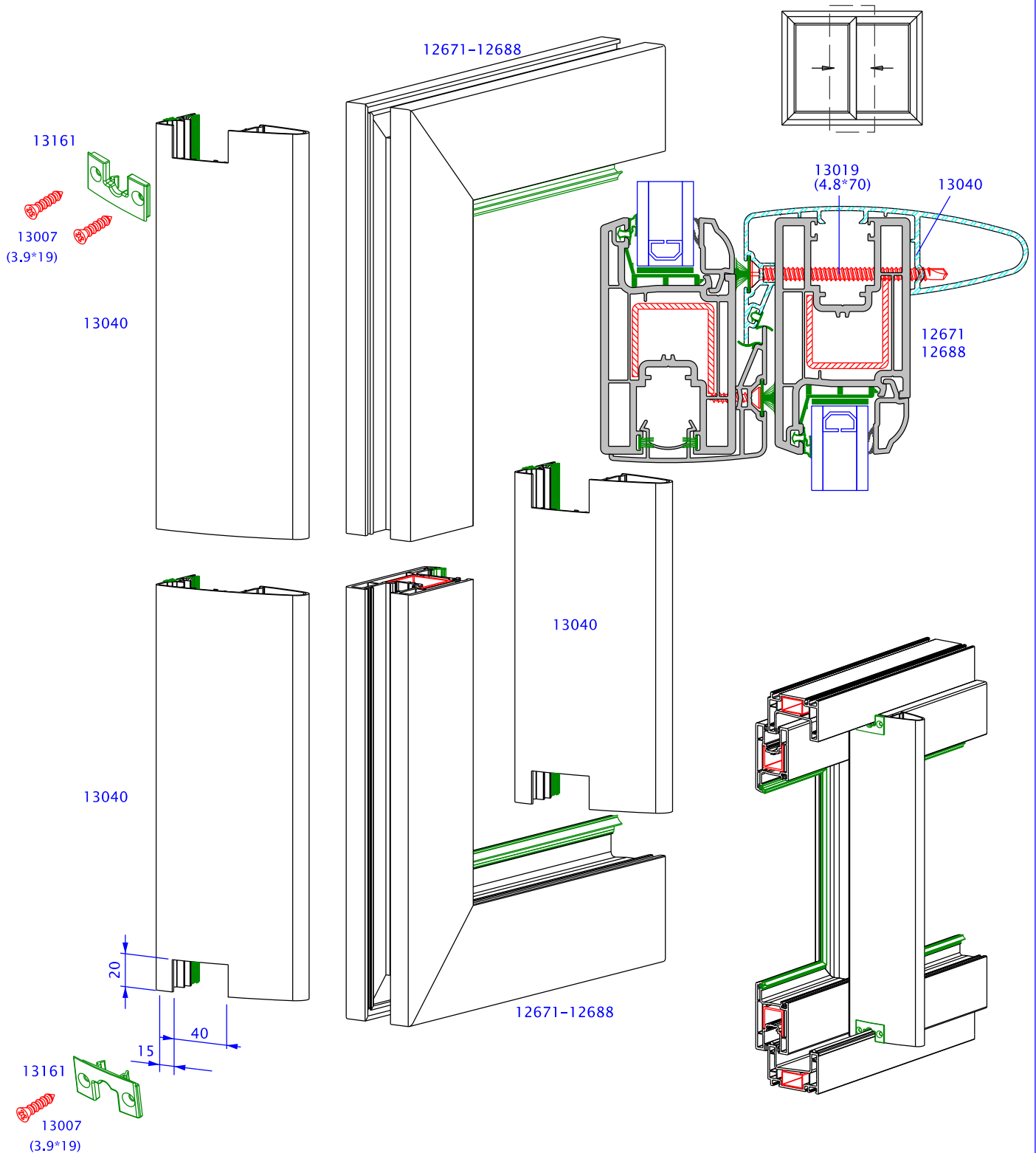
12671
12688

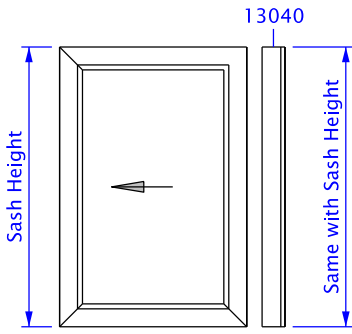


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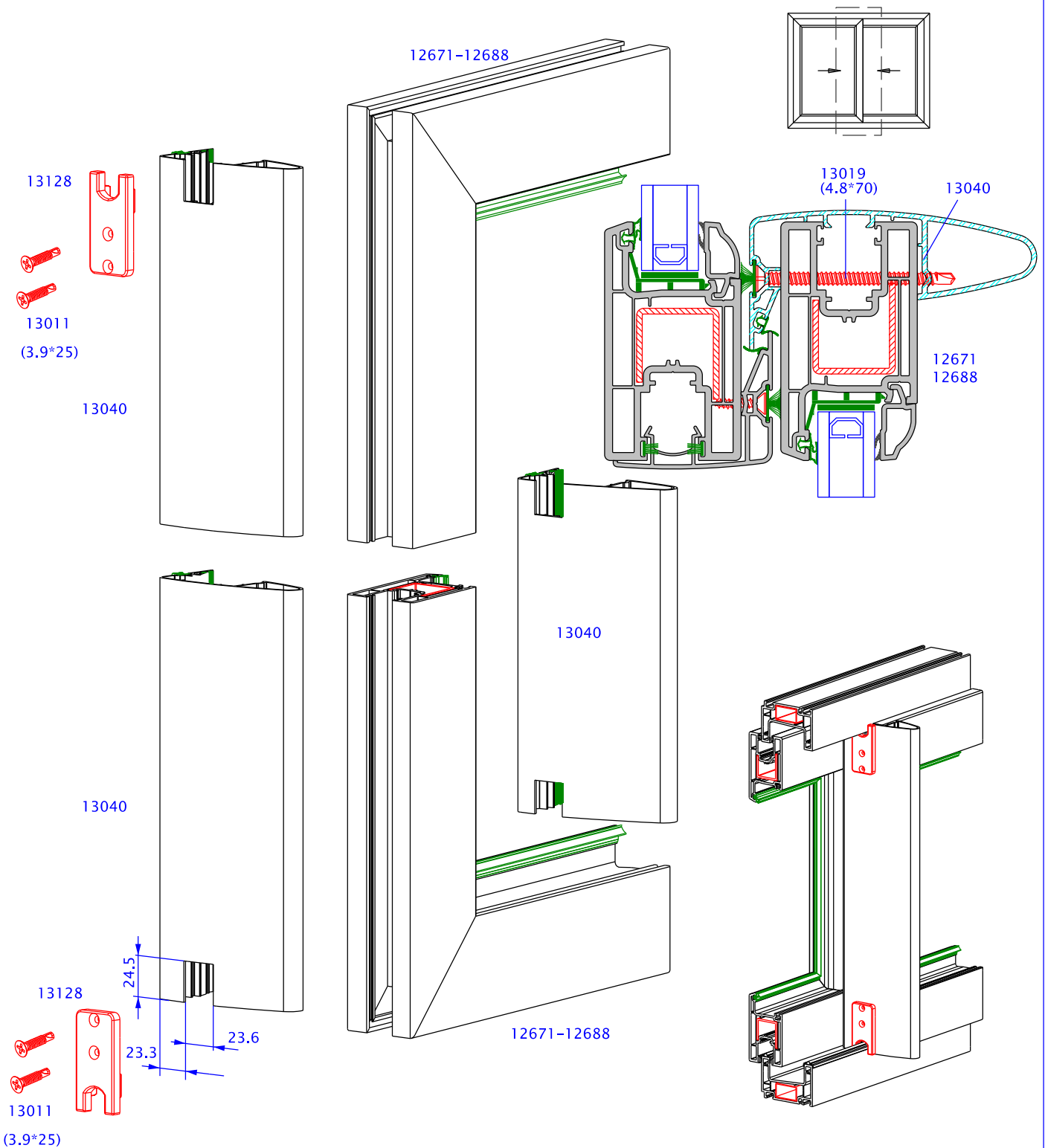


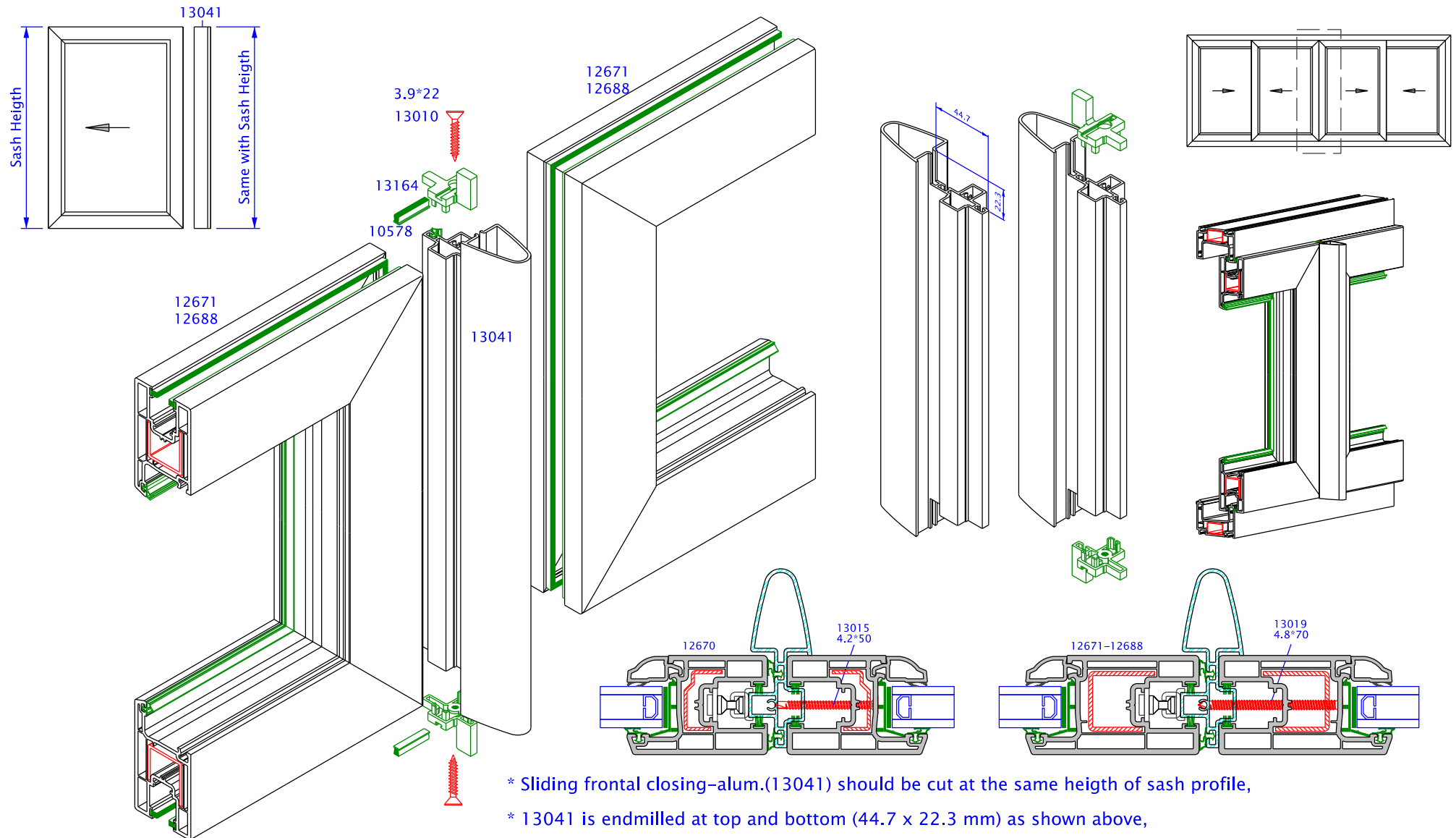
- * Sliding sash aluminium interlock should be cut (13040) at the same length of sash profile,
- * Top and bottom sides of profile are endmilled,
- * The endcaps of sliding interlock (13161) are fixed with the screw 13007 (3.9x19 flathead).
- * 13040 which gives more strength to window can be applied from inside/ outside or both.
- * 13040 is used only with 12671-12688.





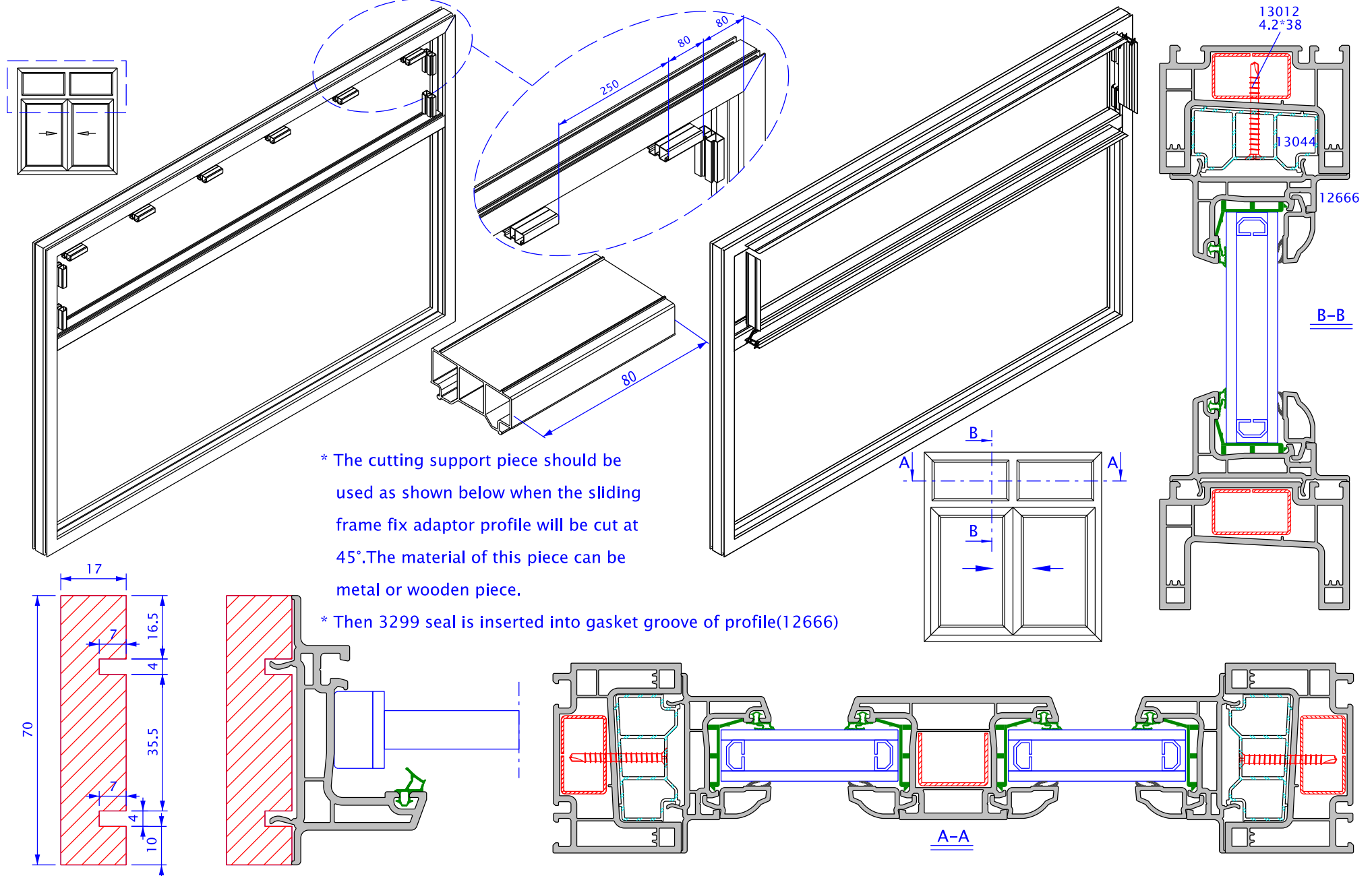
- * Sliding sash aluminium interlock should be cut (13040) at the same length of sash profile,
- * Top and bottom sides of profile are endmilled,
- * The endcaps of sliding interlock (13161) are fixed with the screw 13128 (3.9x25 flathead).
- * 13040 which gives more strength to window can be applied from inside/ outside or both.
- * 13040 is used only with 12671-12688.

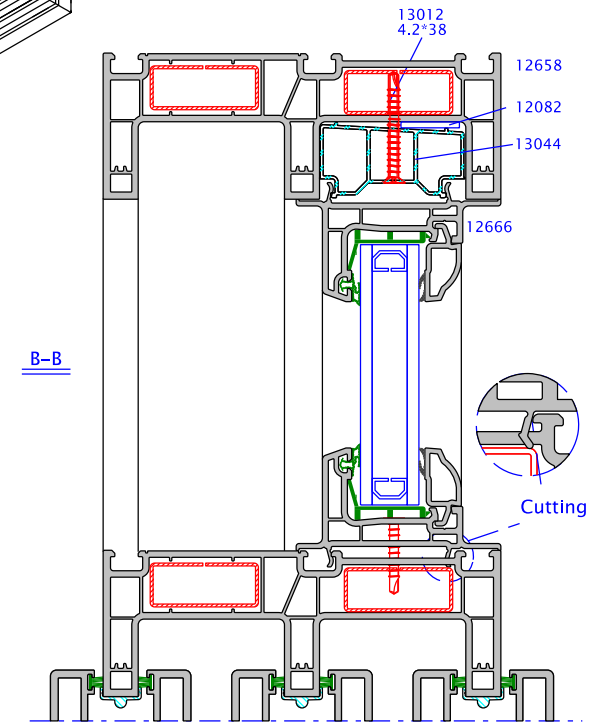
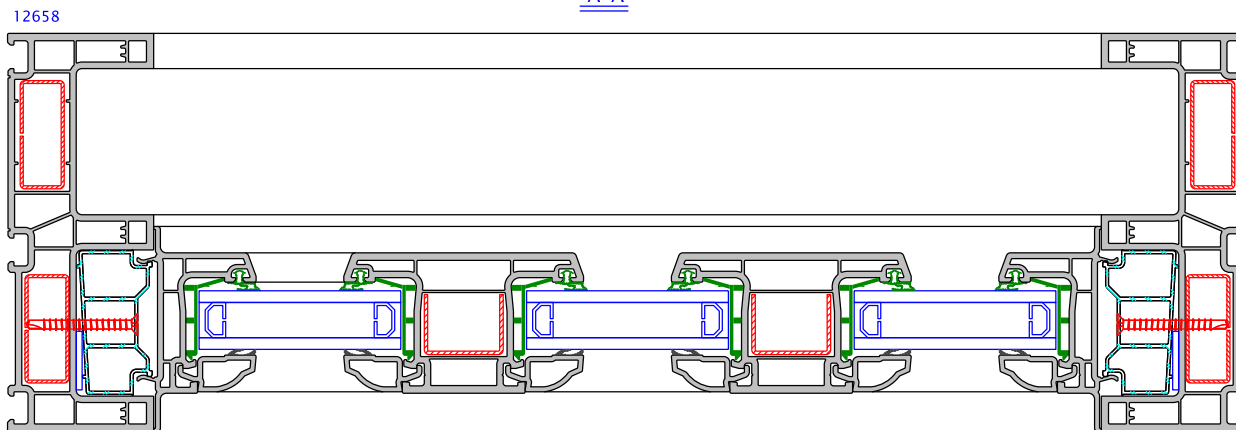
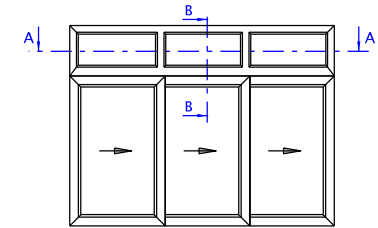
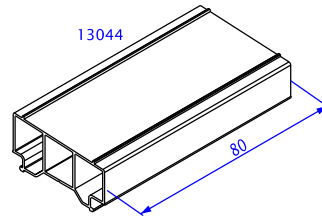
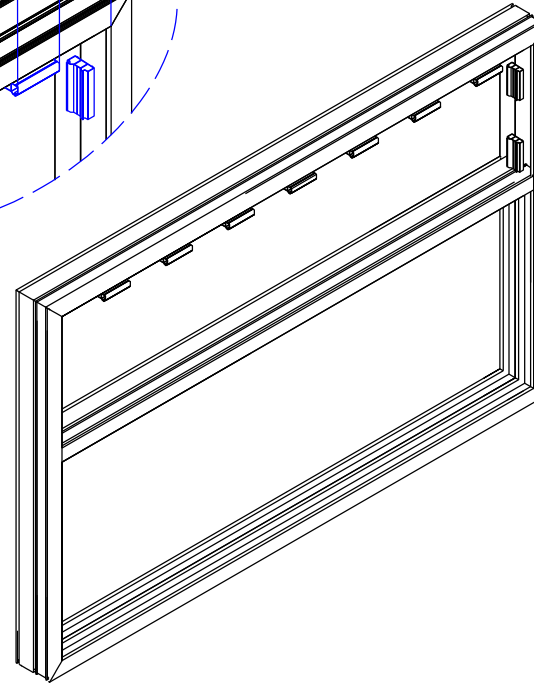
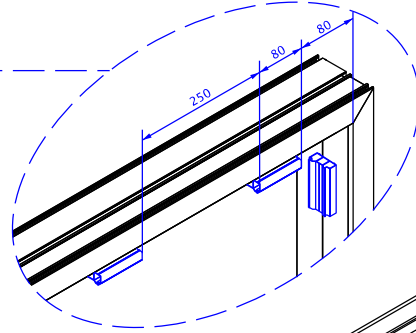
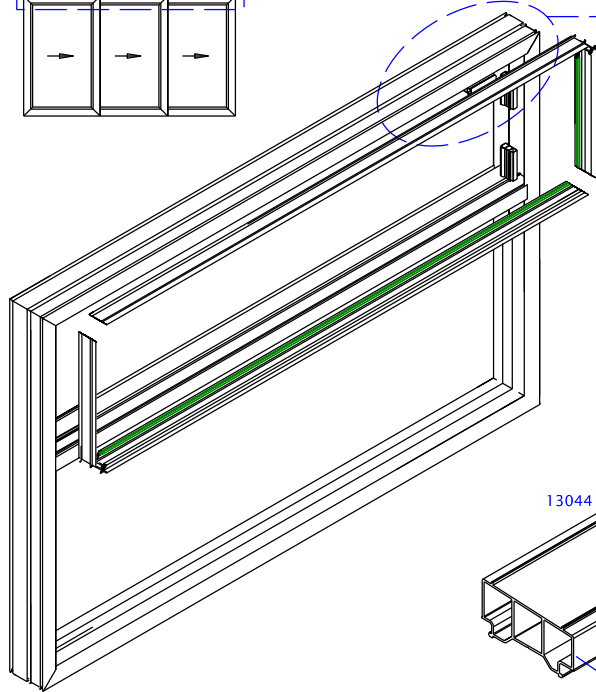
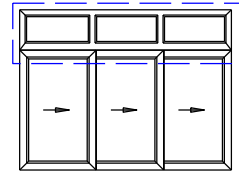


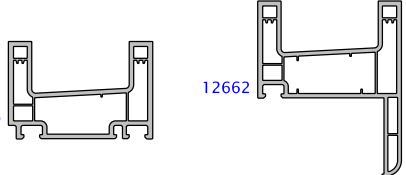
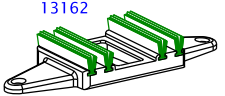
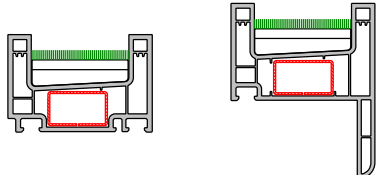
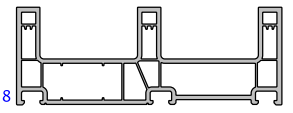
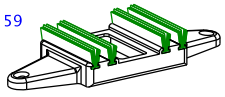
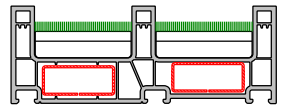
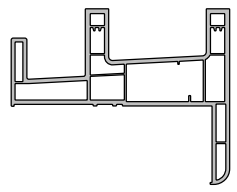

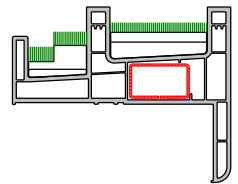
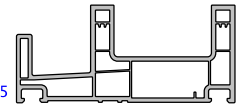
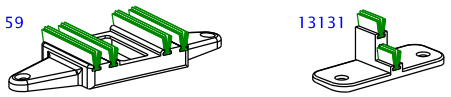
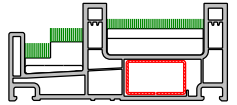
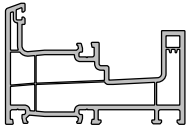
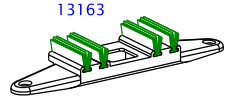
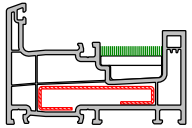
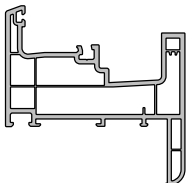
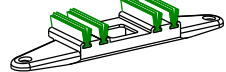
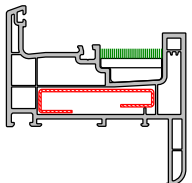
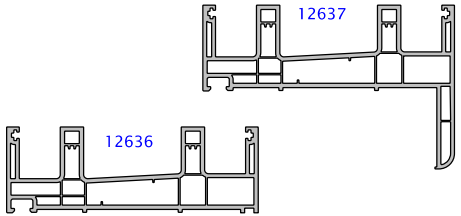
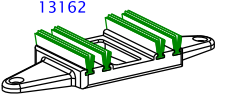
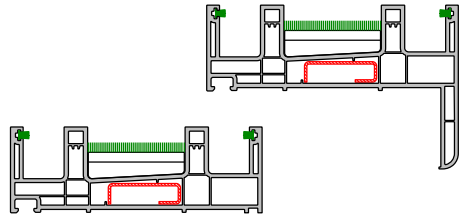


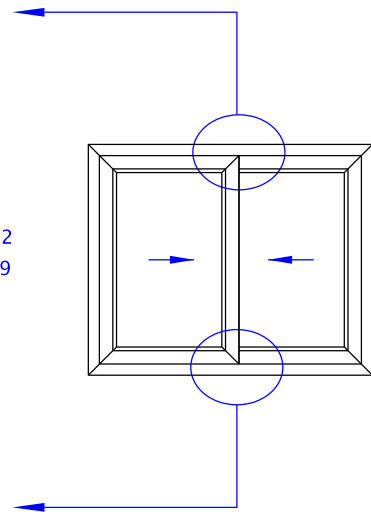
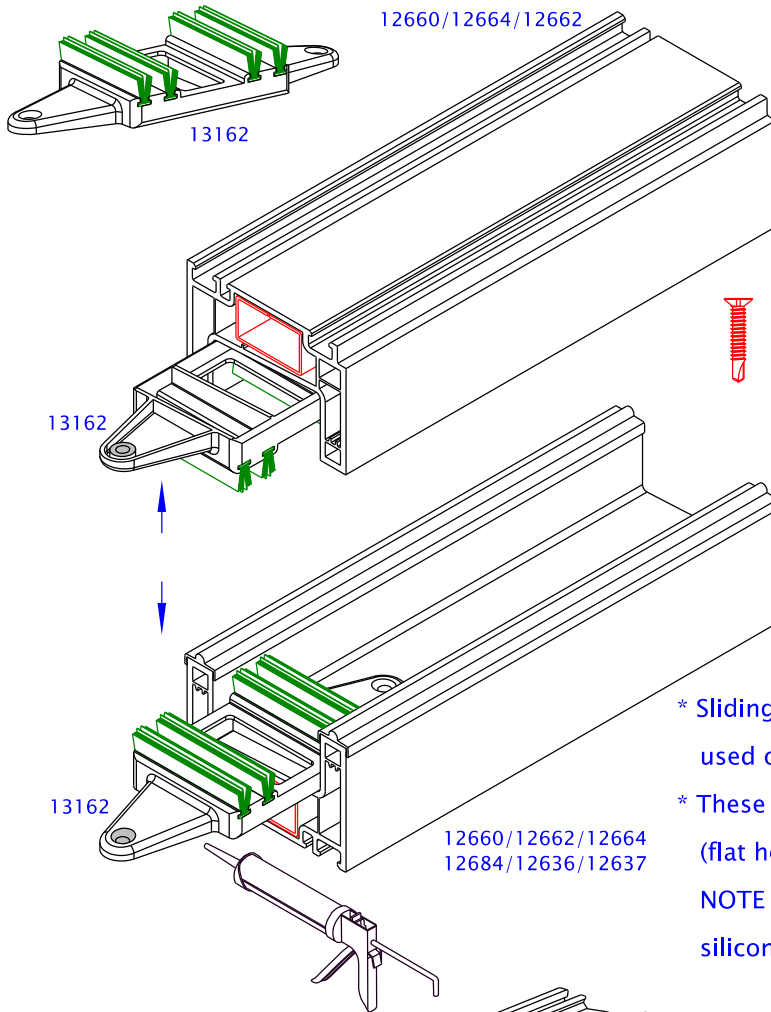
- * Sliding frontal closing-alum.(13041) should be cut at the same height of sash profile,
- * 13041 is endmilled at top and bottom (44.7 x 22.3 mm) as shown above,
- * The endcaps 5 must be bonded with glue (e.g.loctite). Bonding surfaces must be clean, dry and free from grease.
- * Then endcaps are fixed on the aluminium profile by using screw (13010),
- * 3299 TPE seal is inserted into gasket groove on aluminium profile.
- * 13041 can be used with both sash profiles (12670/12671/12688)

13044 and 12666 are used to obtain fix part in sliding windows.





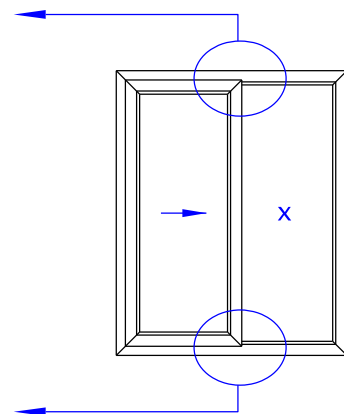
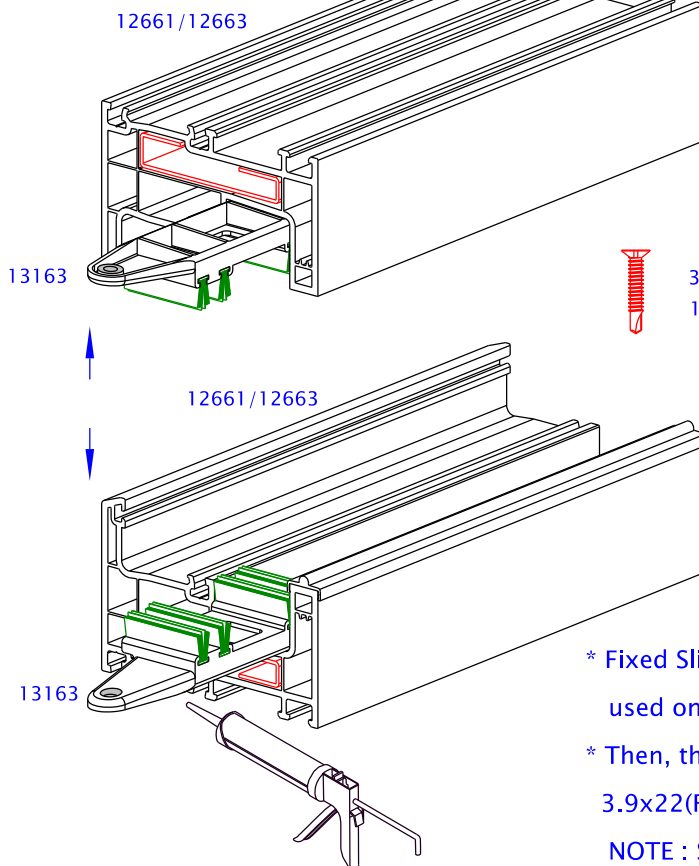
Sliding Frames	Sash Lifting Wedges	Application
 <p>12660 12662</p>	 <p>13162</p>	
 <p>12658</p>	 <p>13159</p>	
 <p>12684</p>	 <p>13162 13131</p>	
 <p>12665</p>	 <p>13159 13131</p>	
 <p>12661</p>	 <p>13163</p>	
 <p>12663</p>	 <p>13162</p>	
 <p>12637 12636</p>	 <p>13162</p>	



* Sliding lifting wedges (13162) must be used on axe point of top and bottom frames.

* These wedges are fixed with screw (13009) 3.9x22 (flat head)

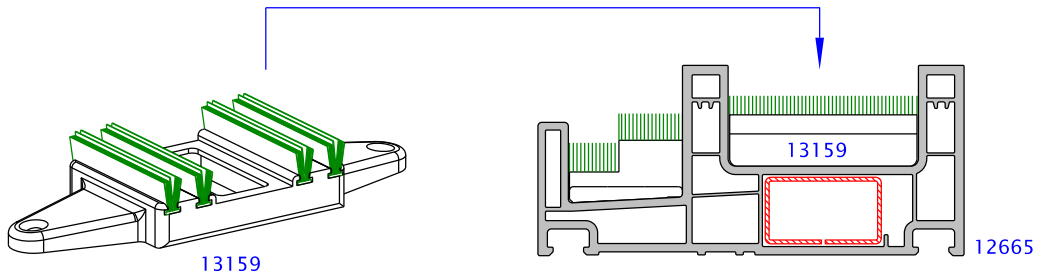
NOTE : Sliding wedges which are used at the bottom, silicon must be applied before screwing.



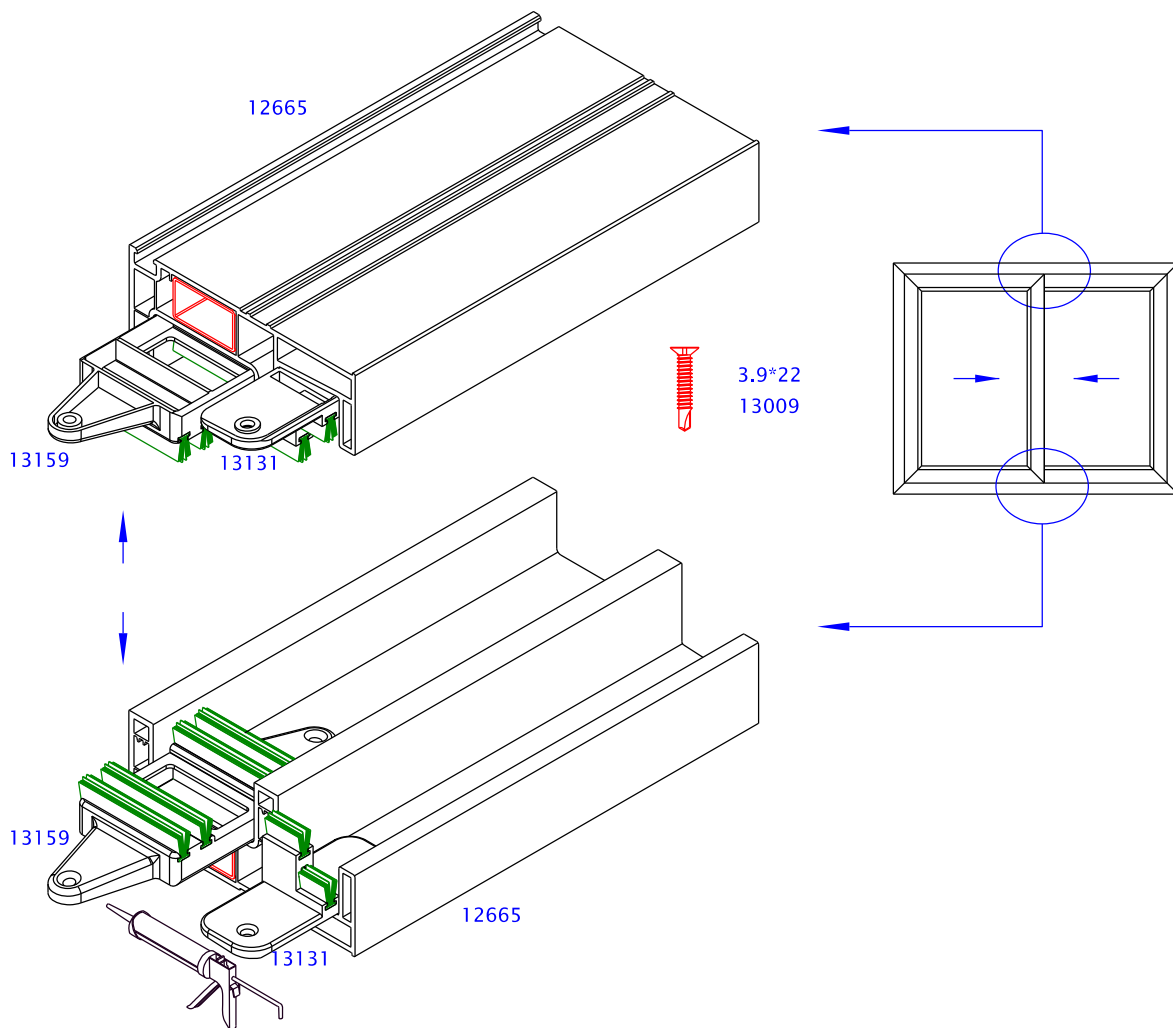
* Fixed Sliding sash lifting wedges (13163) must be used on axe point of on top and bottom of frames.

* Then, these wedges are fixed on frame with 3.9x22(Flathead)

NOTE : Sliding wedges which are used at the bottom, silicon must be applied before screwing.

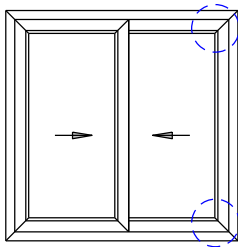
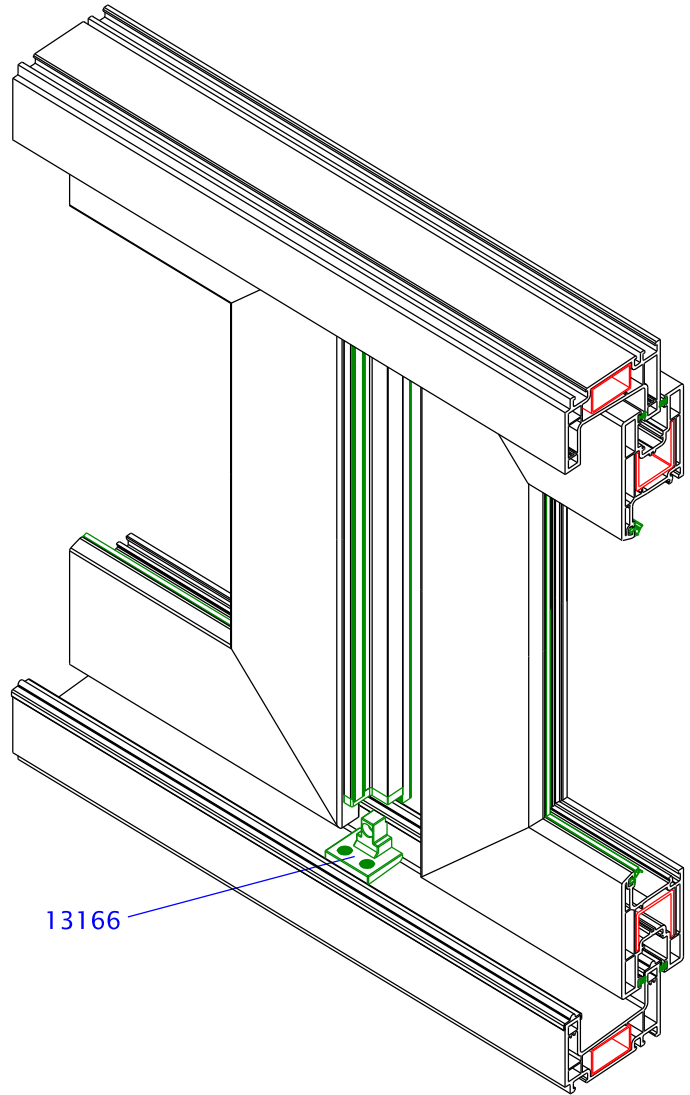
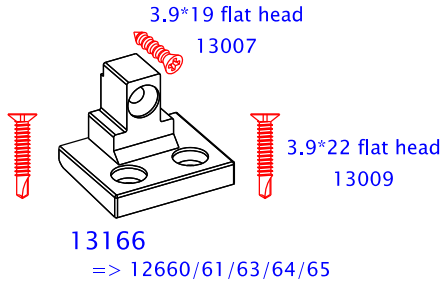


P13159 which is designed for the sliding frame with flyscreen has the flat bottom plate.
Therefore, the lifting wedge of 12660 can not be used in 12665.

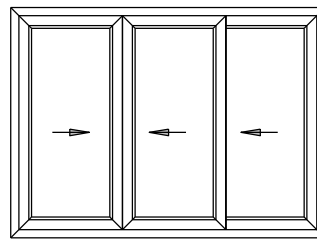


The Sash lifting wedge of 12665 must be screwed on the central of two sashes.
(with 3.9*22 screw) as shown in figure.

NOTE : It is advised to isolate with silicon for the bottom wedge before screwing.

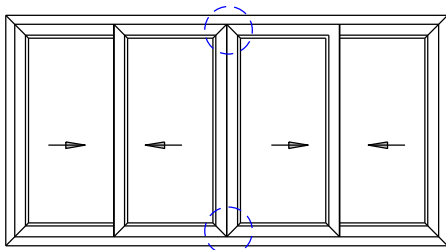


13166 is used
(Frame : 12660)

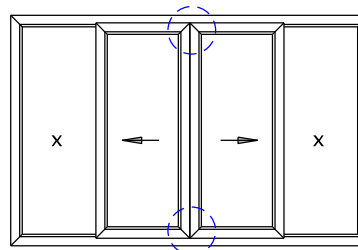


13166 can not be used
(Frame : 12660)

In the case of locking espagnolette applications, stopping piece (13166) is used to prevent the striking of door handle to other sash.

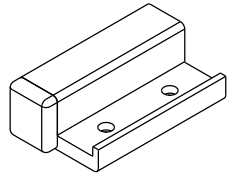


13166 is used
(Frame : 12660)

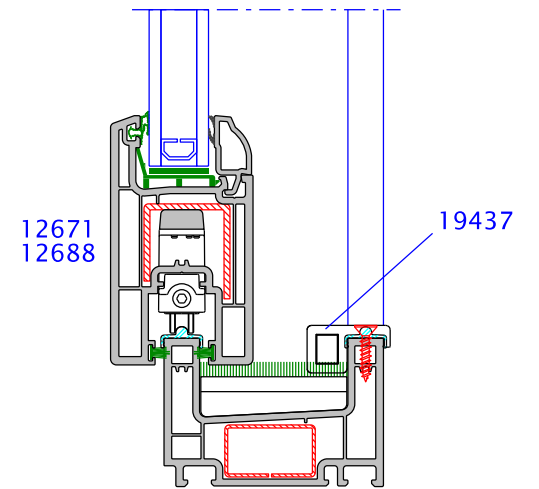
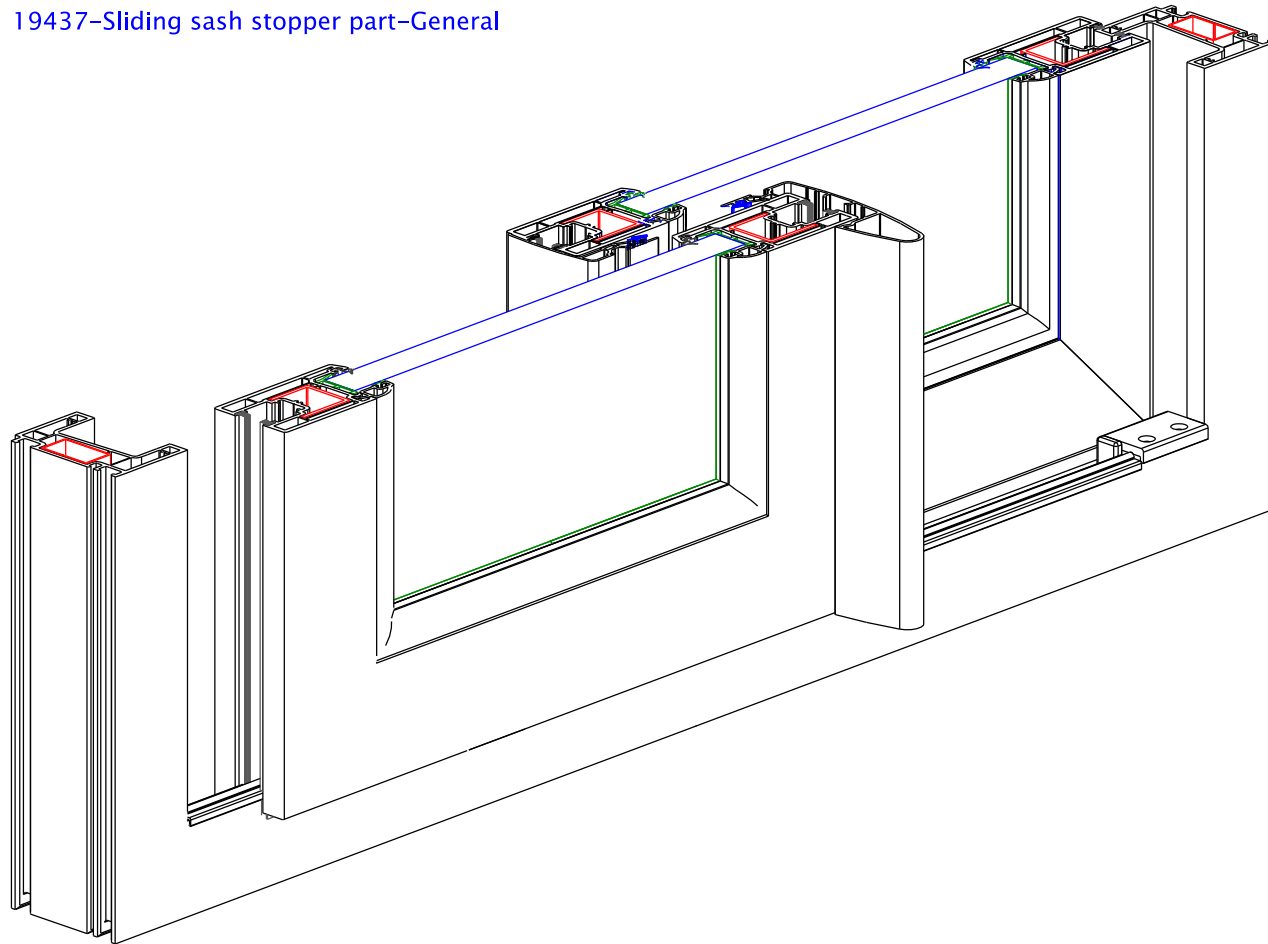


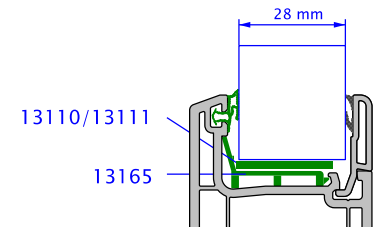
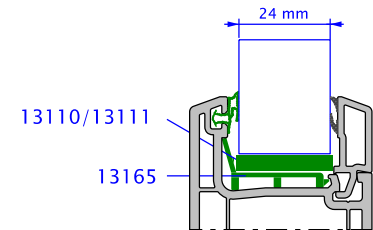
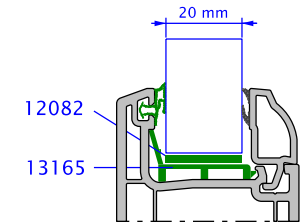
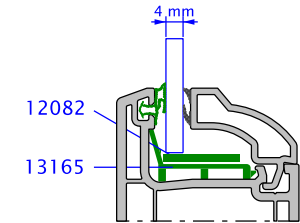
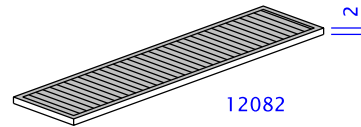
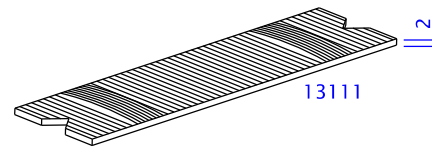
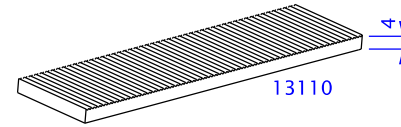
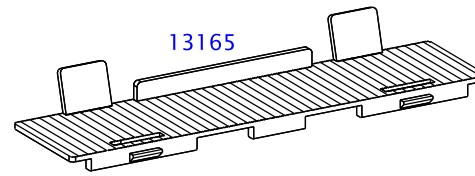
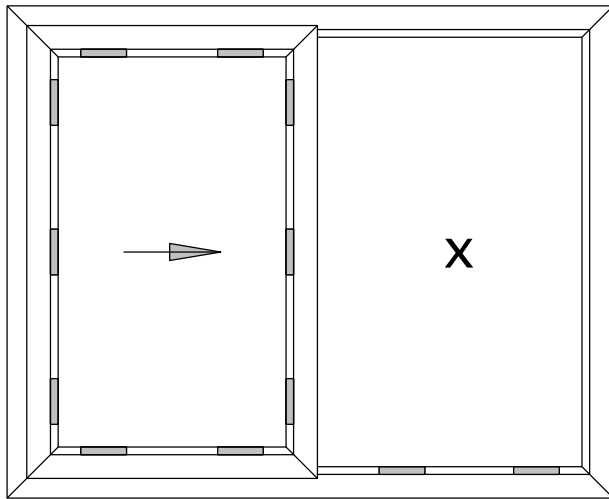
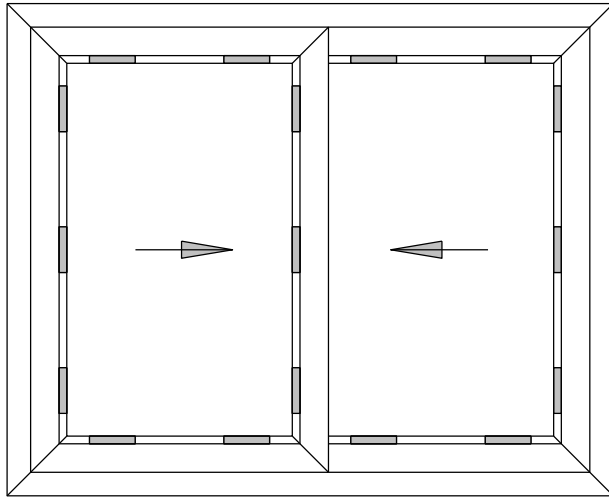
13166 is used
(Frame : 12661/12663)

Stopping piece (13166) is used in the sliding that includes 4 parts as shown above.



19437-Sliding sash stopper part-General

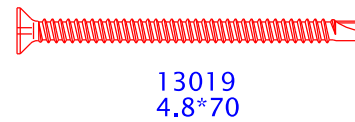
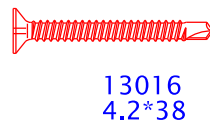
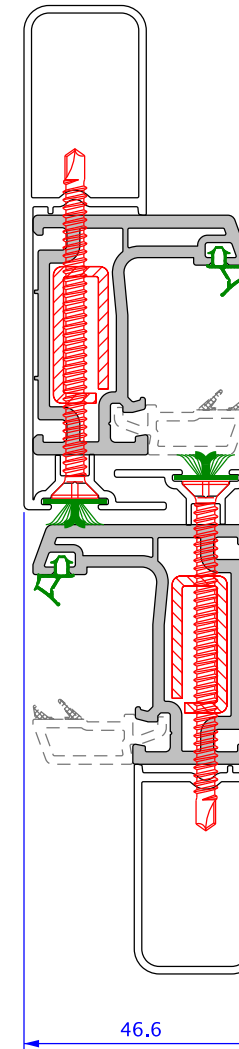
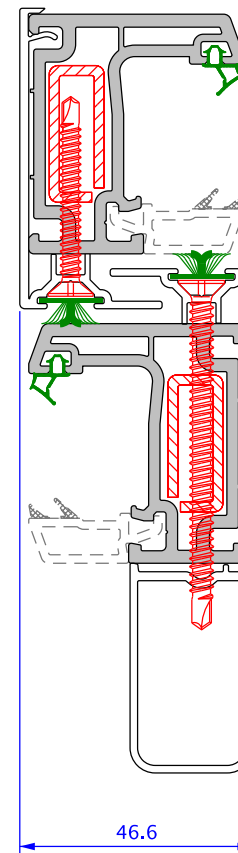
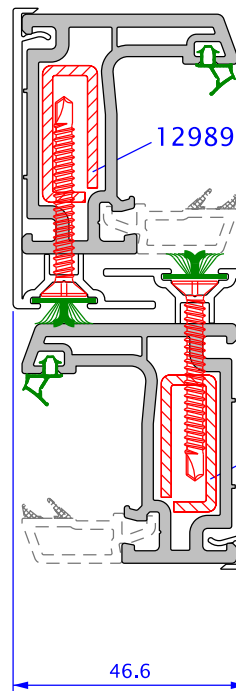
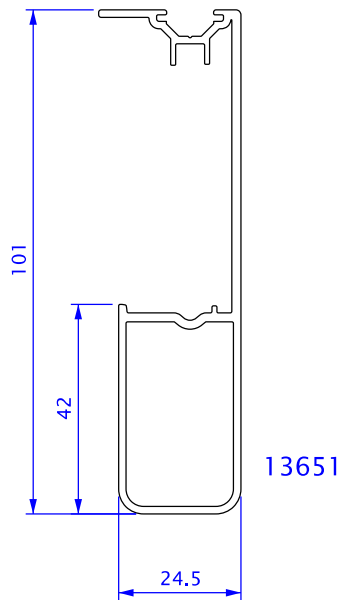
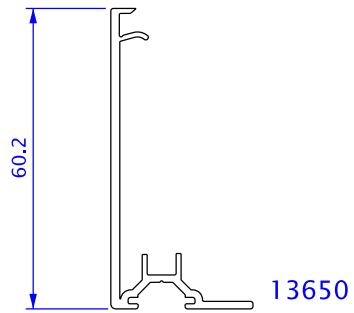


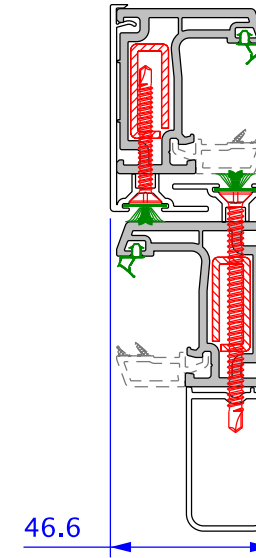
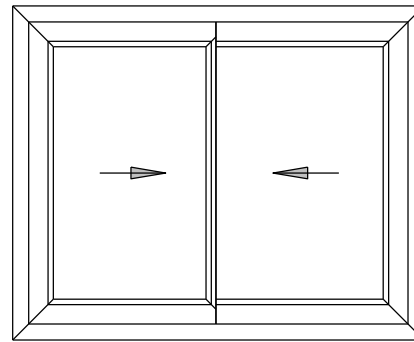


- * Sliding glazing wedge (13165) is placed in the movable sliding sashes,
- * In the application of sliding doors filler wedges(13110/13111/12082) must be used,
- * Glazing wedges and filler wedges are glued with silicone on the vertical sides and top sides.
- * Glazing beads are placed on the bottom frames, the silicone is not applied,
Glazing wedges should not be placed on drainage area at bottom. Because, it can block the water drainage.

According to the application types, interlocks are applied as in the drawing.

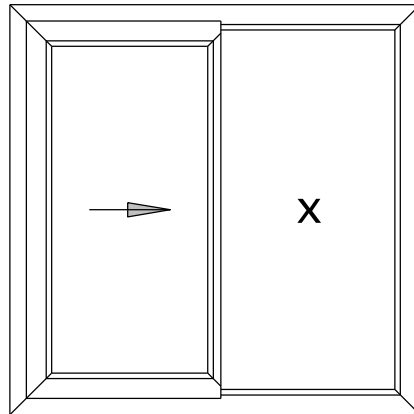
Only 12648 glazing bead-9 mm is used in Slim Slide applications.





The sash overlap is 9 mm.

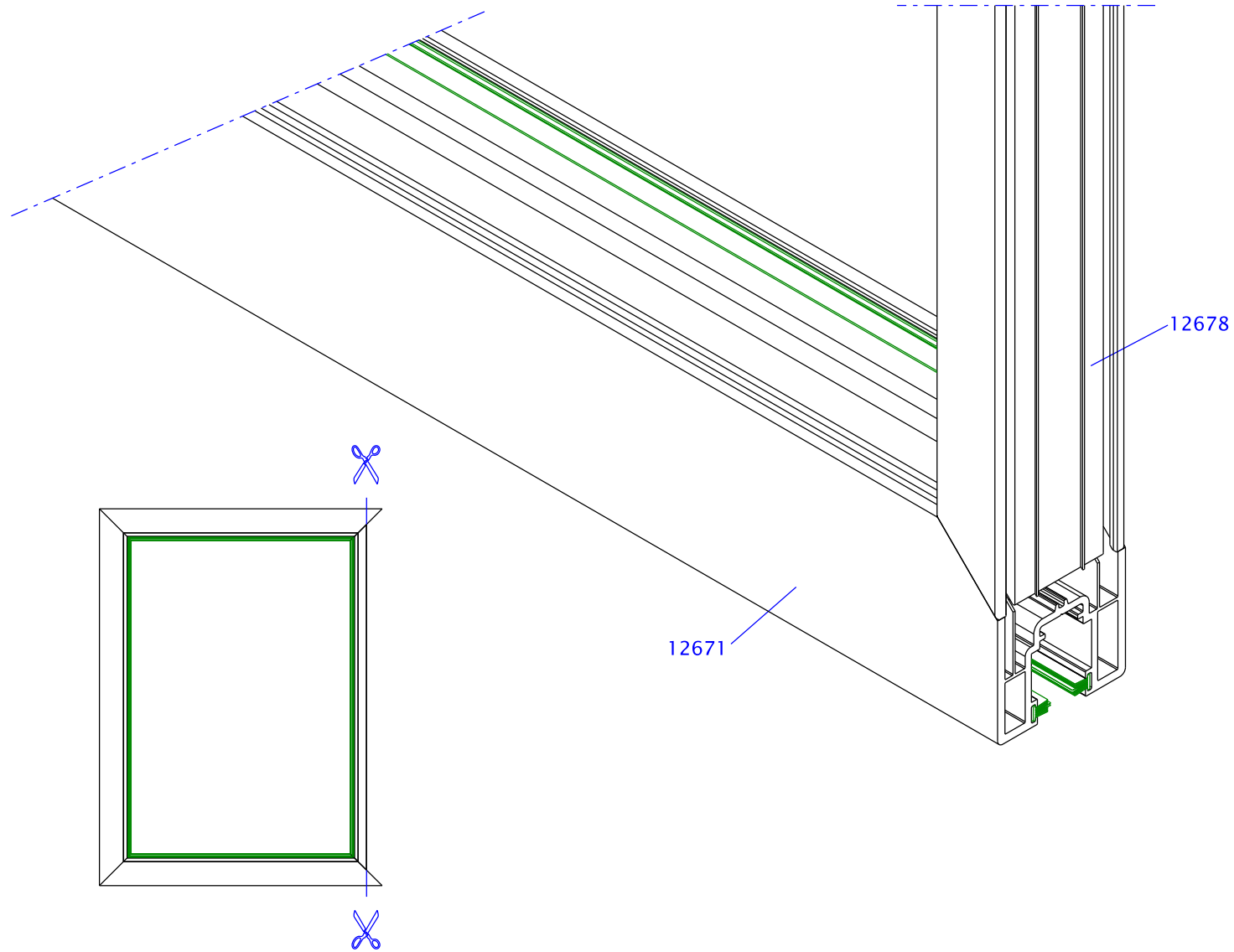
Dimension	12660-Horizontal	12660-Vertical	12662-Horizontal	12662-Vertical	12664-Horizontal	12664-Vertical	12636-Horizontal	12636-Vertical	12637-Horizontal	12637-Vertical
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Cutting Sliding Frame	X+6	X+6	X+6	X+6	X+6	X+6	X+6	X+6	X+6	X+6
Cutting Sliding Sash	$\frac{X+54}{2}$	X-76	$\frac{X-26}{2}$	X-156	$\frac{X+184}{3}$	X-76	$\frac{X+66}{2}$	X-64	$\frac{X+14}{2}$	X-144
<div style="display: flex; align-items: center;"> <div style="writing-mode: vertical-rl; transform: rotate(180deg); font-size: 8px; margin-right: 5px;">Technical documents are subject to change without notice</div> <div style="border: 1px solid black; padding: 2px 5px; font-size: 8px;">12671</div> </div>										
Cutting Sliding Slim Sash	—	X-158	—	X-238	—	X-158	—	X-146	—	X-224
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Glass Sliding Sash	$\frac{X-234}{2}$	X-220	$\frac{X-314}{2}$	X-156	$\frac{X-248}{3}$	X-220	$\frac{X-222}{2}$	X-208	$\frac{X-302}{2}$	X-288
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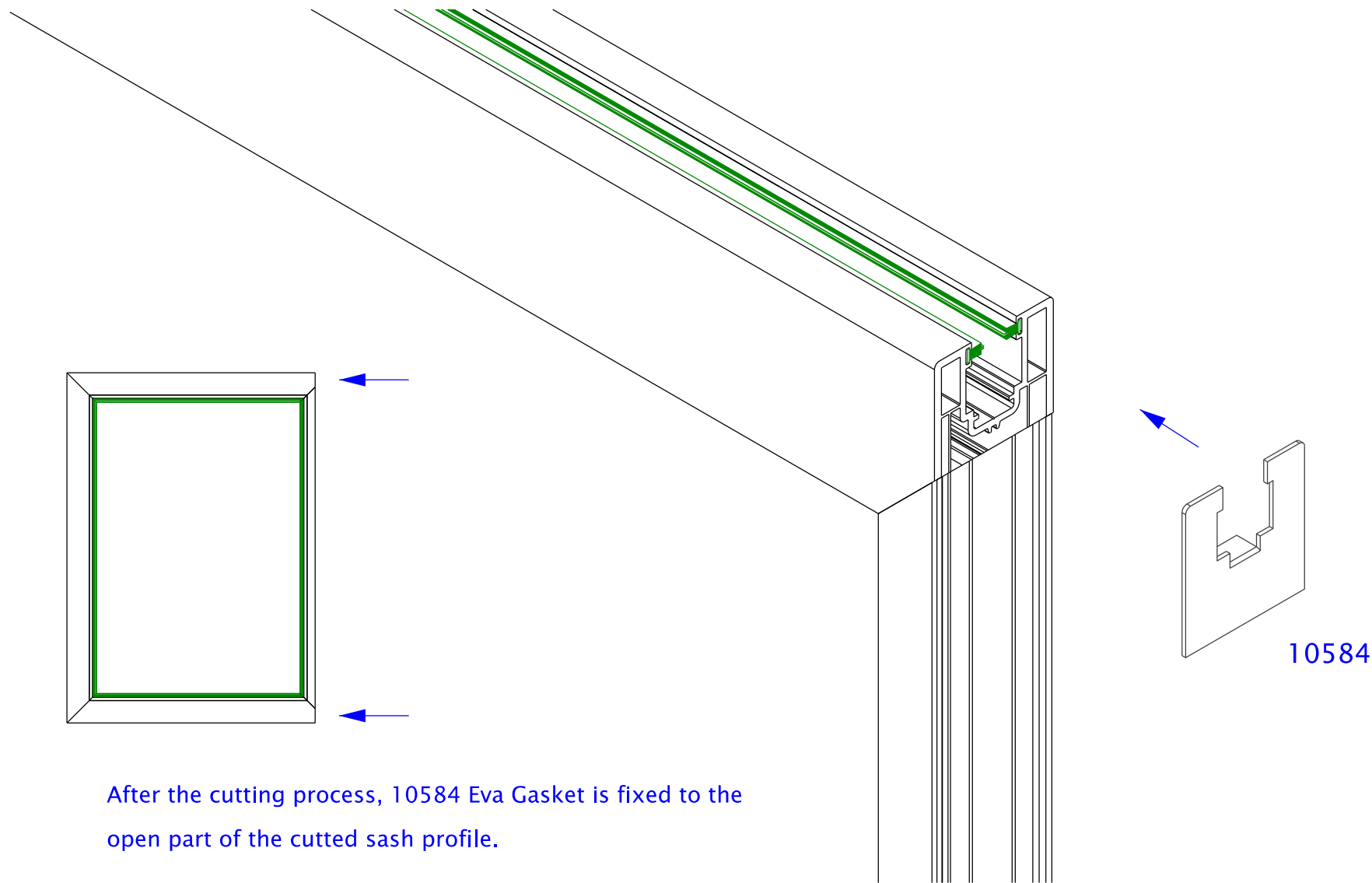
The sash overlap is 9 mm.

Welding thickness is included				
	Dimension	12661- Horizontal	12661-Vertical	12663-Horizontal
Cutting Sliding Frame	X_1+6	X_1+6	X_1+6	X_1+6
Cutting Sliding Sash 12671	$X+29$	$X-72$	$X-1$	$X-132$
Cutting Sliding Slim Sash 12678	—	$X-154$	—	$X-214$
Glass Sliding Sash 12671	X_2-115	$X-216$	X_2-145	$X-276$
Glass Fixed Sliding Fix Glass	X_2-54	$X-94$	X_2-84	$X-154$
Sliding Fix Transom 12678	—	$X-84$	—	$X-144$

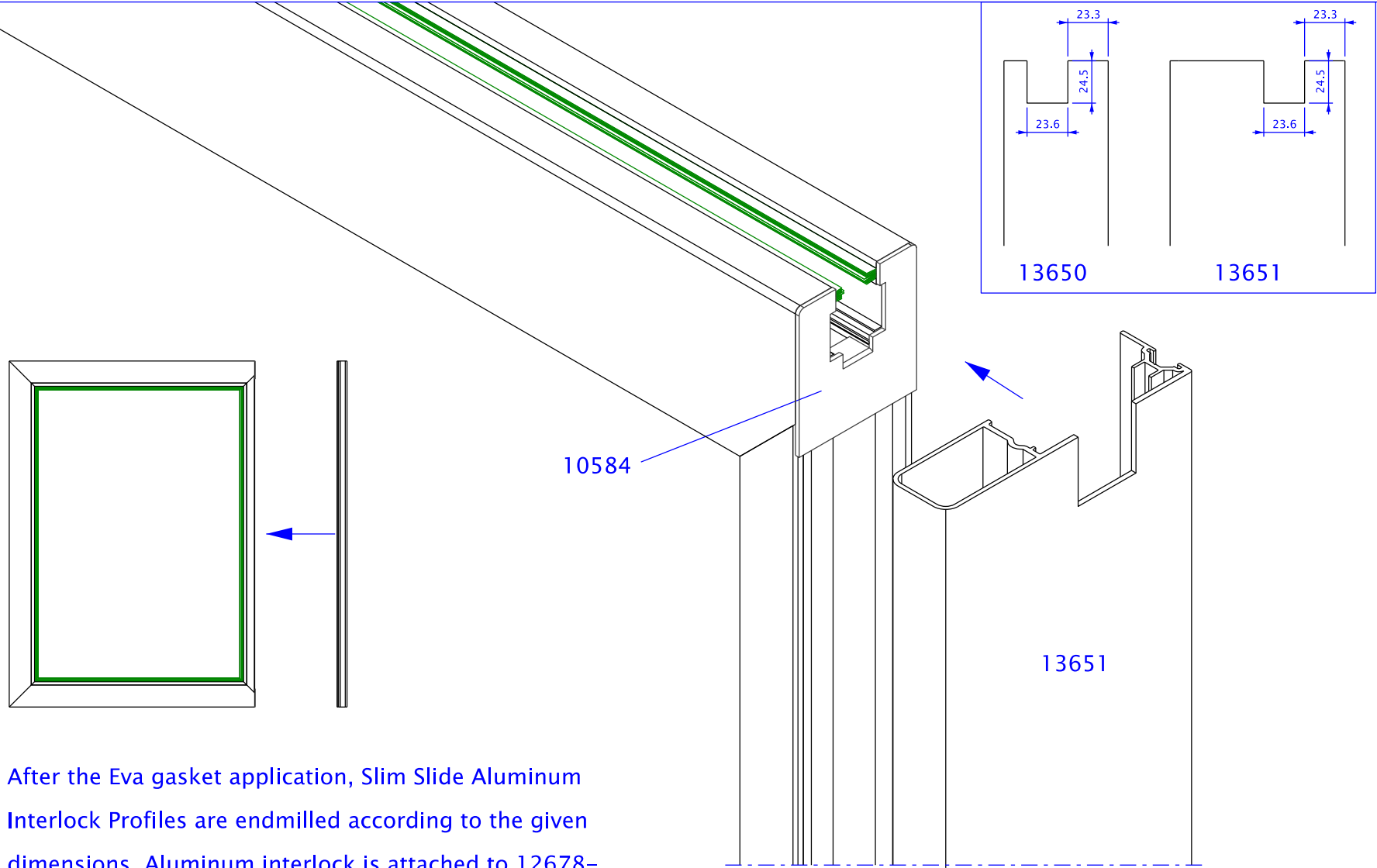
Technical documents are subject to change without notice



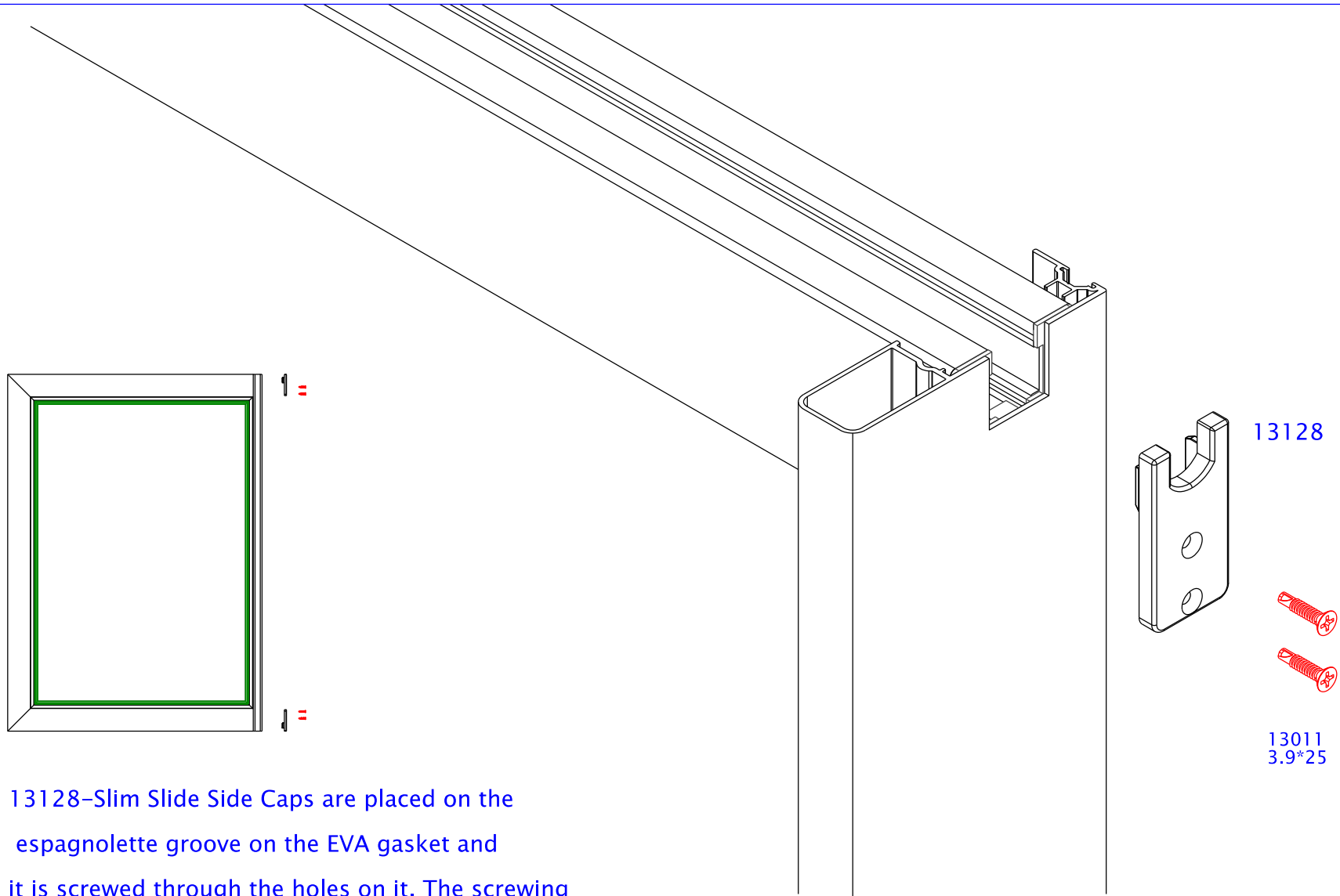
After the welding process, the excess parts of the sash profiles are cut off.



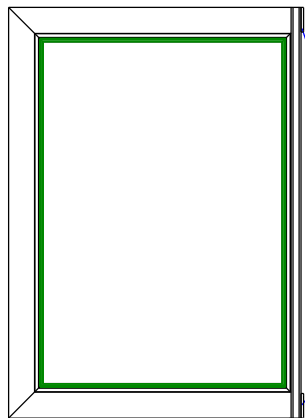
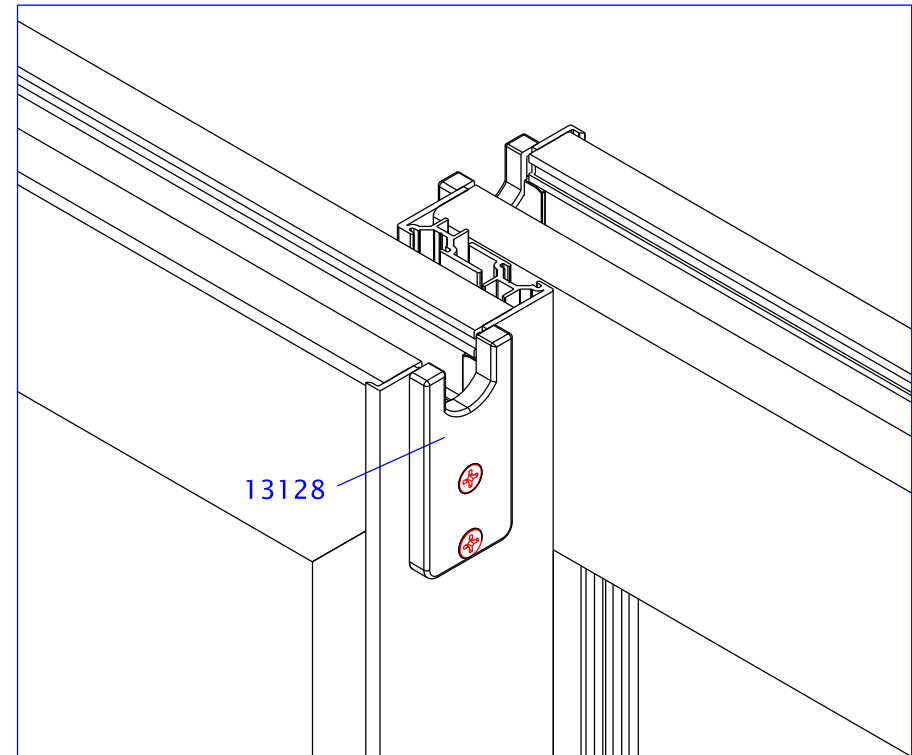
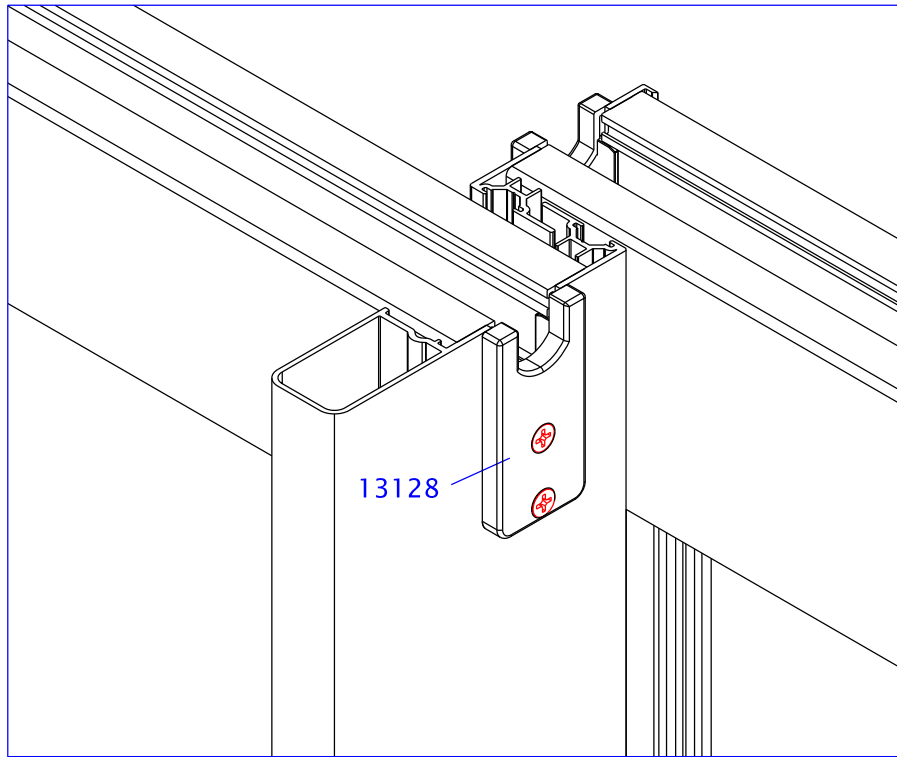
After the cutting process, 10584 Eva Gasket is fixed to the open part of the cutted sash profile.



After the Eva gasket application, Slim Slide Aluminum Interlock Profiles are endmilled according to the given dimensions. Aluminum interlock is attached to 12678–Slim Sash Profile as shown.



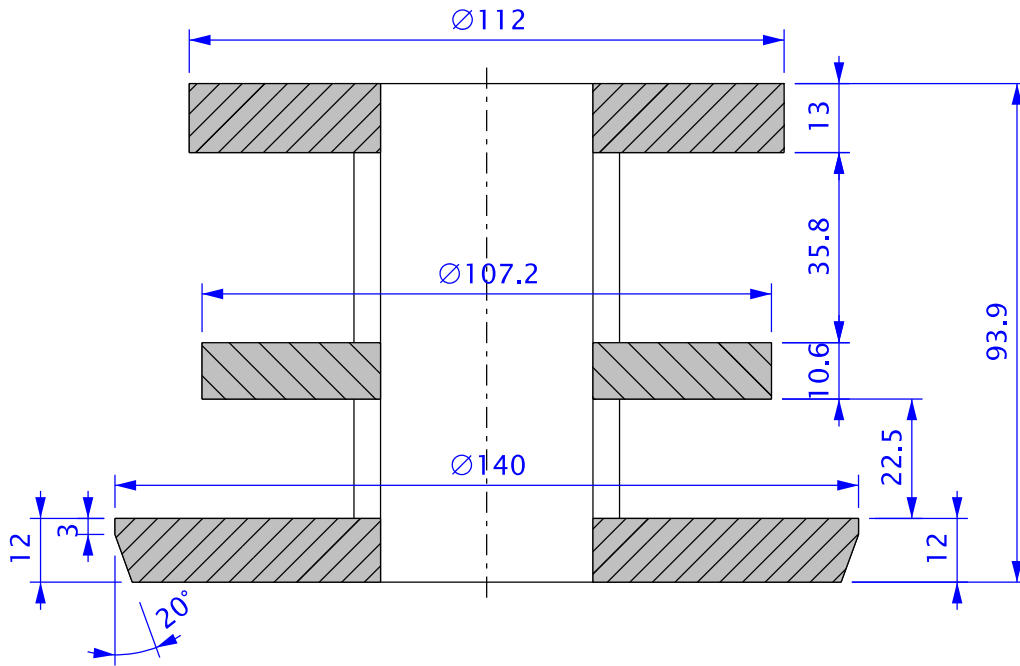
13128–Slim Slide Side Caps are placed on the espagnolette groove on the EVA gasket and it is screwed through the holes on it. The screwing process also fixes the aluminum interlock profiles on the 12678 profile.



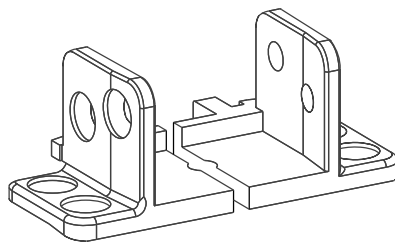
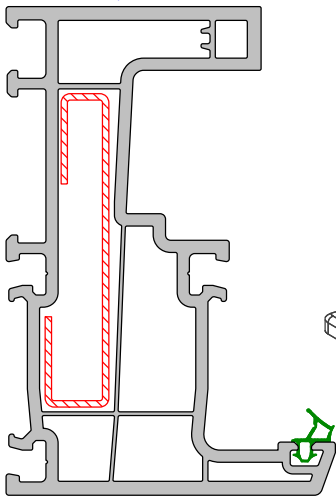
13128

After the 13128-Slim Slide Side Caps are attached, the production is completed.

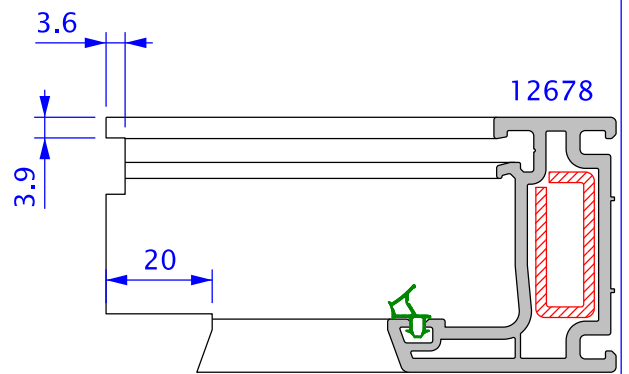
13795-Endmilling of Sliding Transom



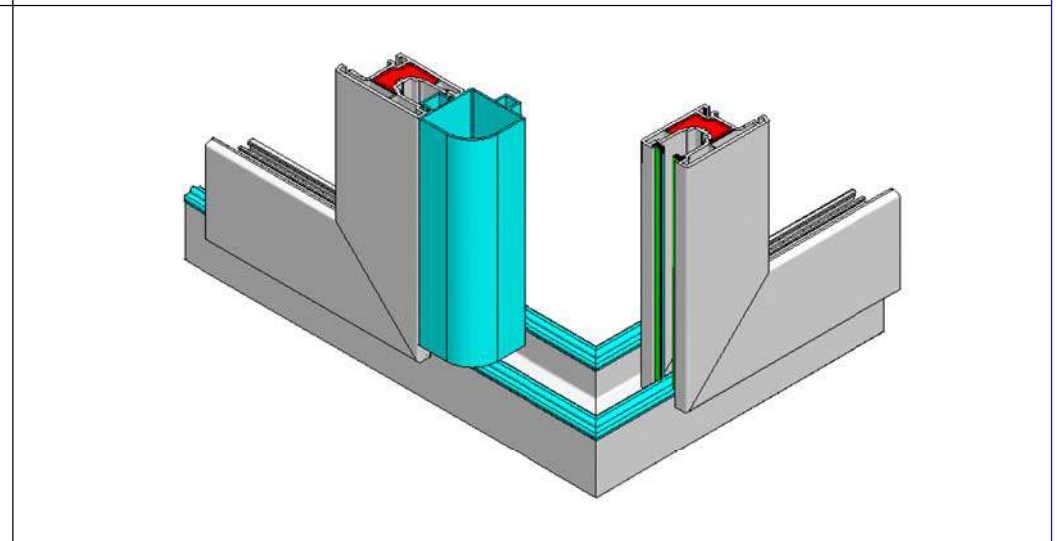
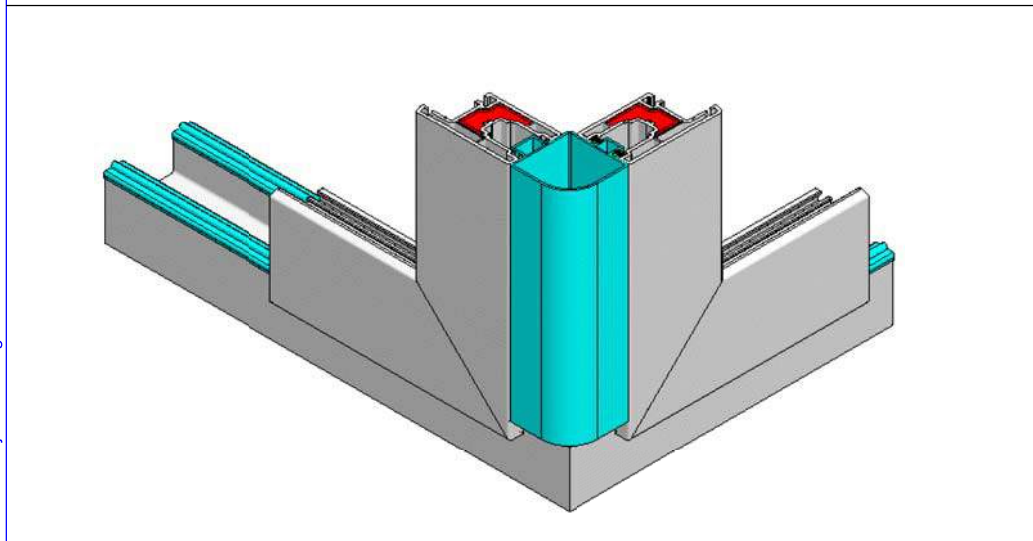
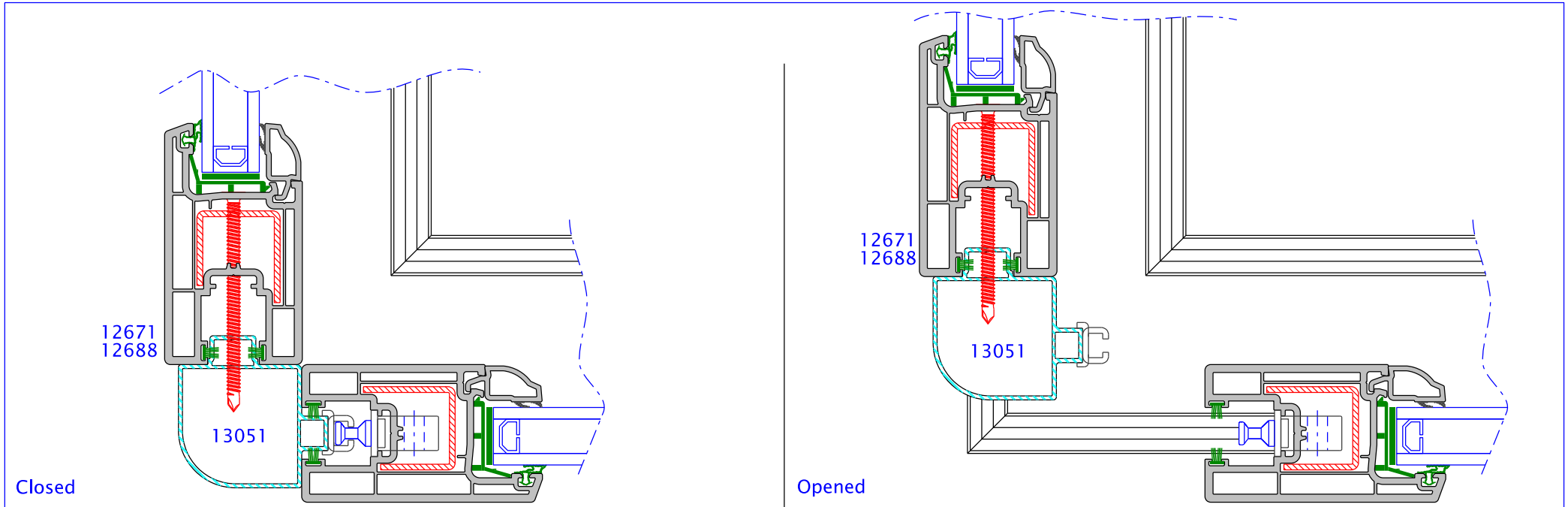
12661/12663



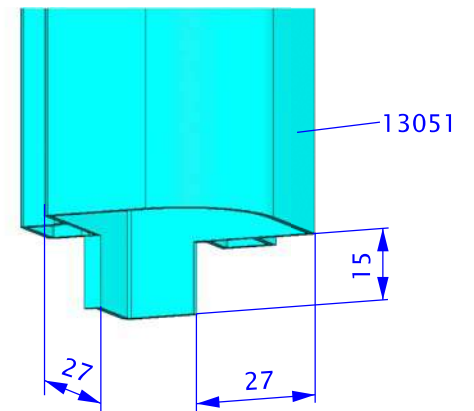
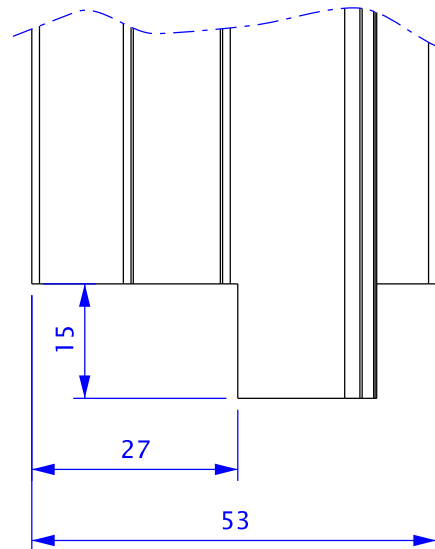
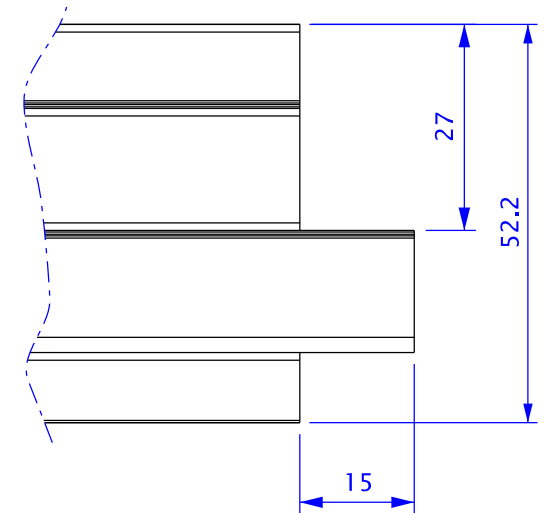
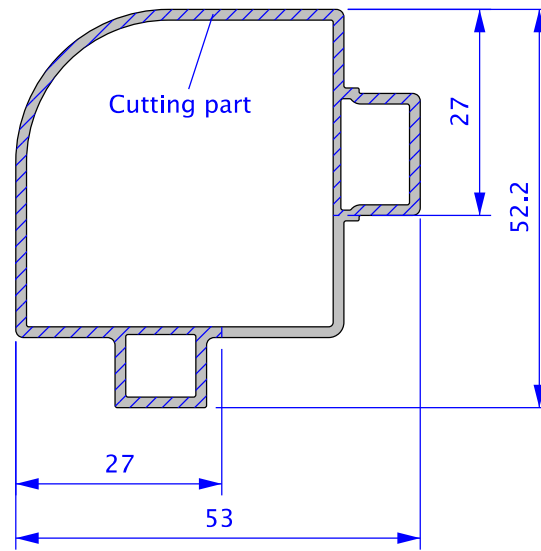
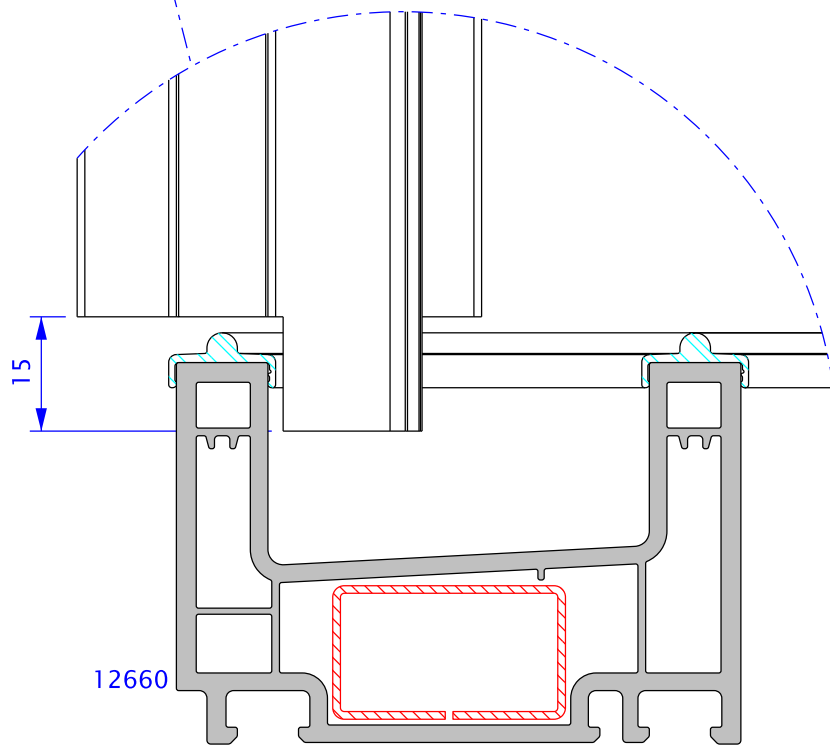
10551
=>12678



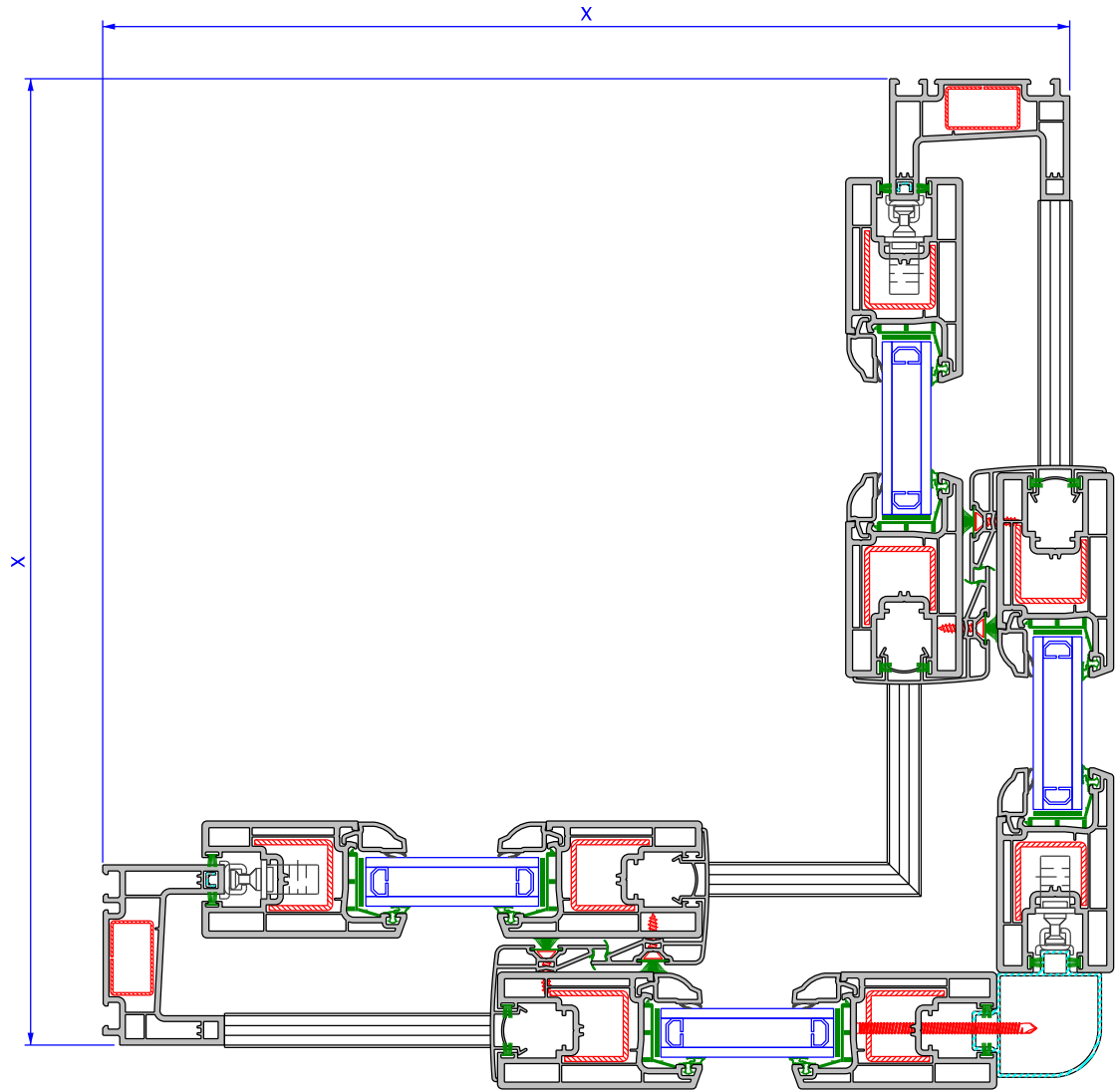
12678



- * In the case of Alfresco sliding applications , aluminium sliding 90° (13051) can be used on corners as vertically,
- * There is no vertical sliding frame on the corner in this application,13051 which is fixed on sliding sash is closed on other sliding sash profile on the corner.
- * Sliding strikers are fixed on 13051.



*The drawing shows bottom side of the aluminium profile ,
 *The horizontal mirror of freeze dimensions are also used on top part .



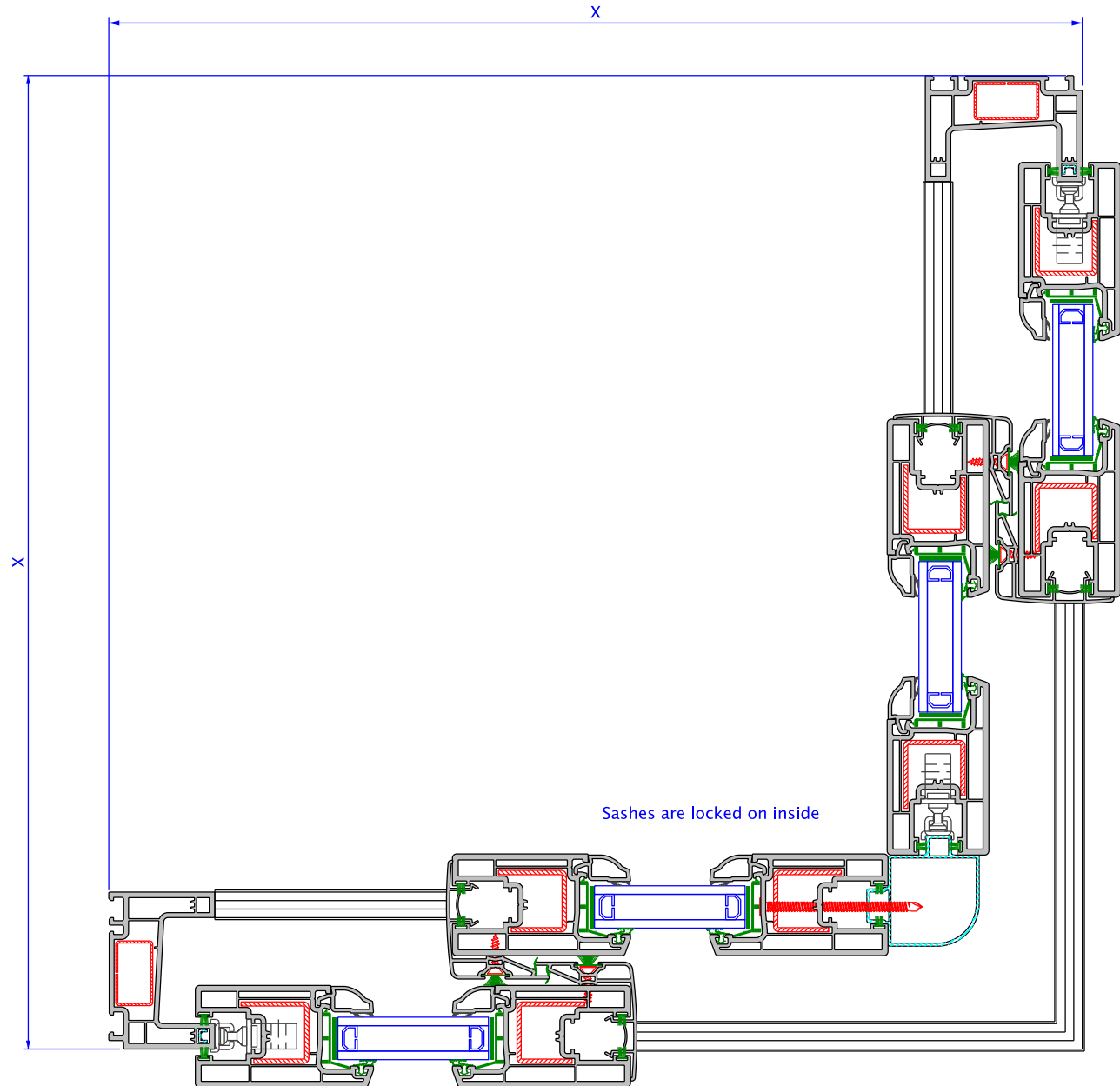
	Width	Height 12660 Sliding Frame	Height 13030 Alu. Frame
12670 Sliding Window Sash	$\frac{X+9}{2}$	X-76	X-48
12671 12688 Sliding Sash	$\frac{X+25}{2}$	X-76	X-48

*Welding thickness is included.

Sashes are locked on outside

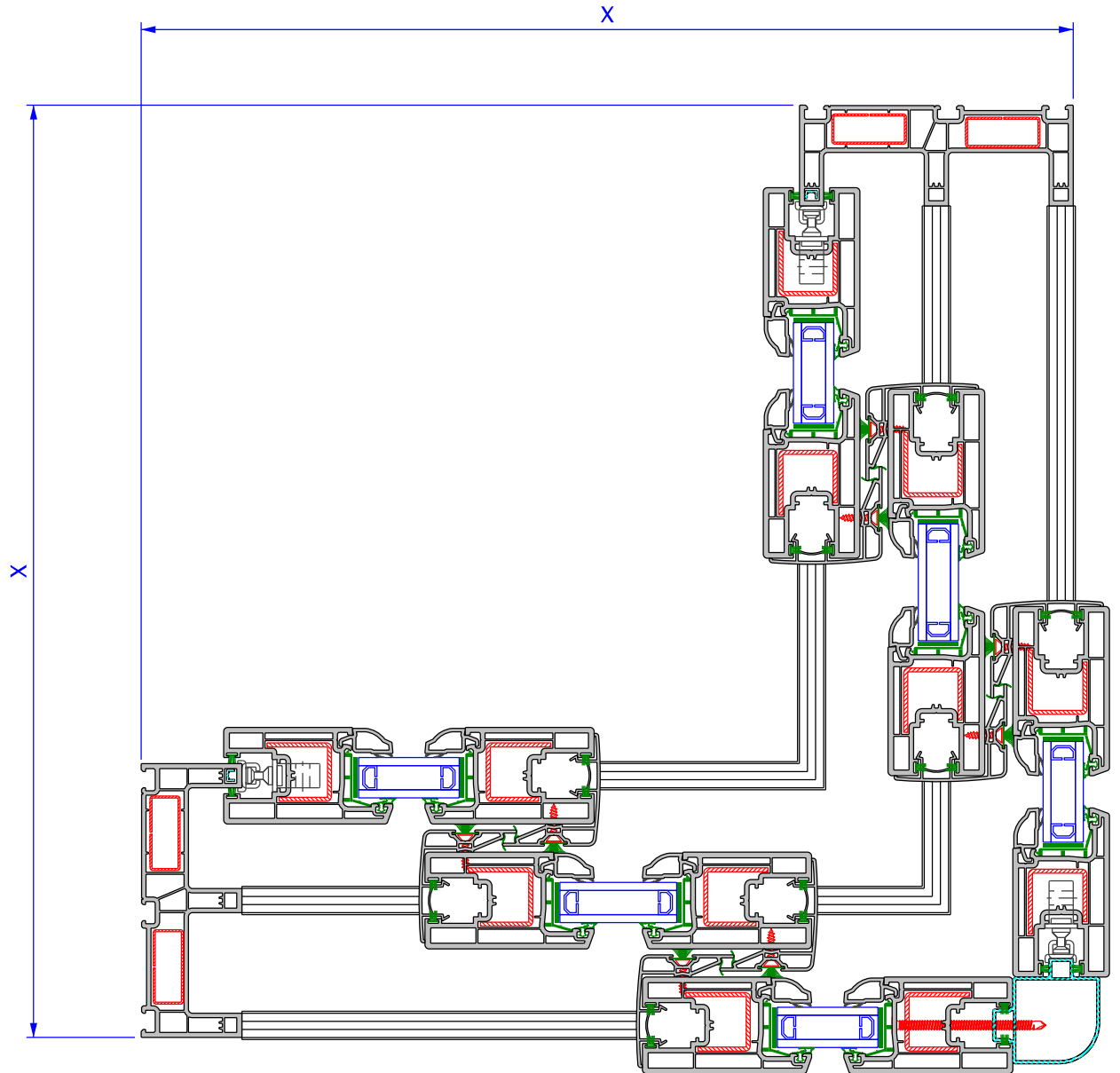
	Width	Height 12660 Sliding Frame	Height 13030 Alu. Frame
12670 Sliding Window Sash	$\frac{X-53}{2}$	X-76	X-48
12671 12688 Sliding Sash	$\frac{X-37}{2}$	X-76	X-48

*Welding thickness is included.



	Width	Height
12670 Sliding Window Sash	$\frac{X+83}{3}$	X-76
12671 12688 Sliding Sash	$\frac{X+115}{3}$	X-76

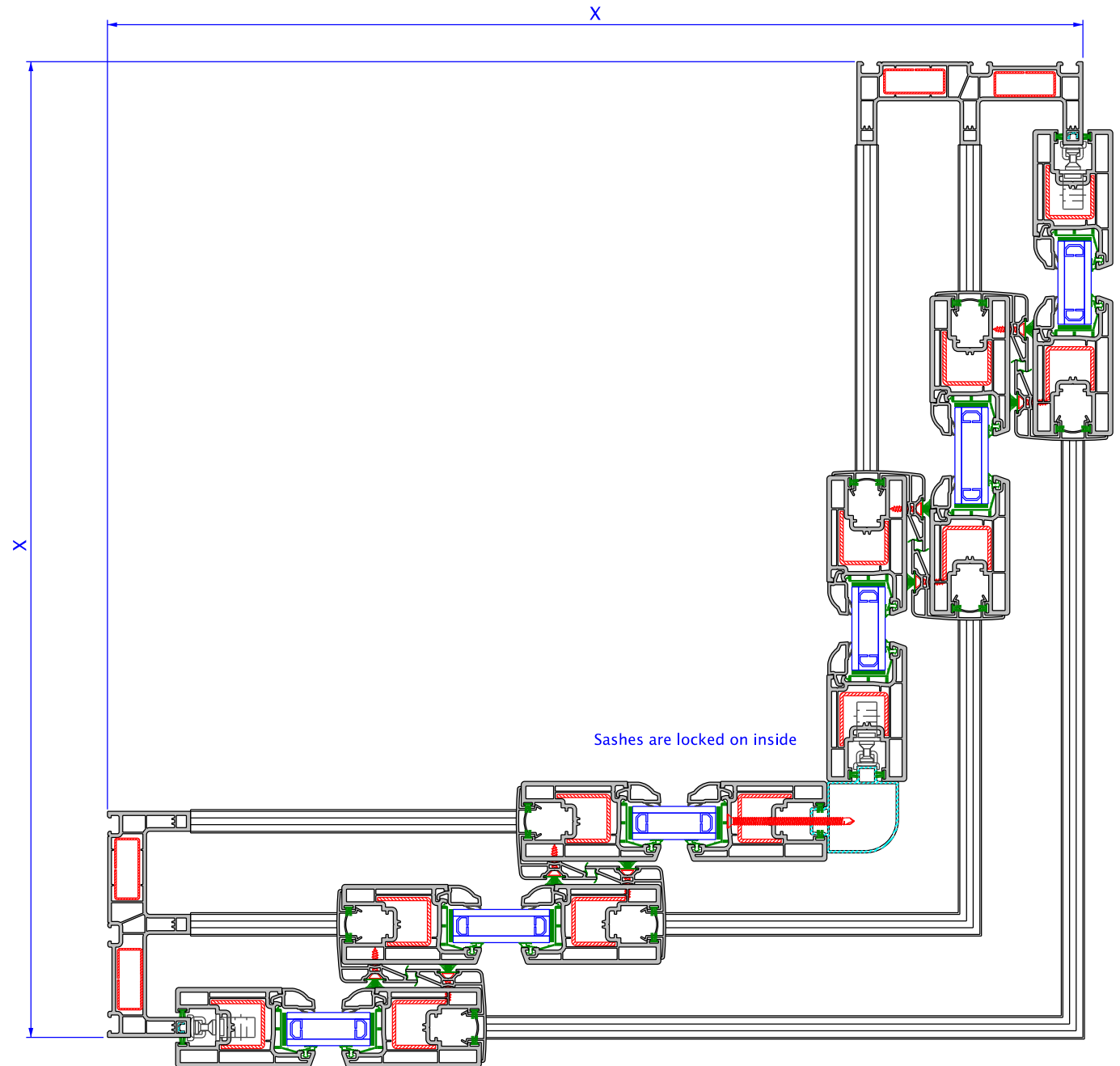
*Welding thickness is included.

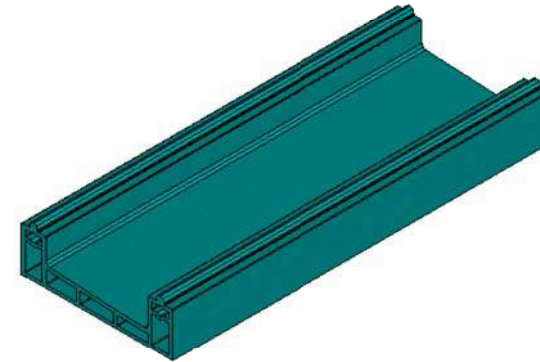
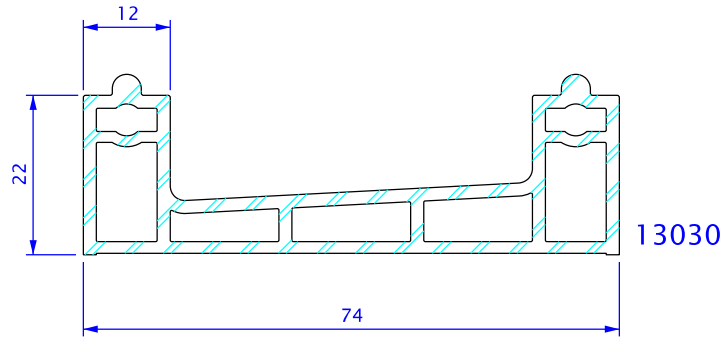


Sashes are locked on outside

	Width	Height
12670 Sliding Window Sash	$\frac{X-41}{3}$	X-76
12671 12688 Sliding Sash	$\frac{X-9}{3}$	X-76

*Welding thickness is included.

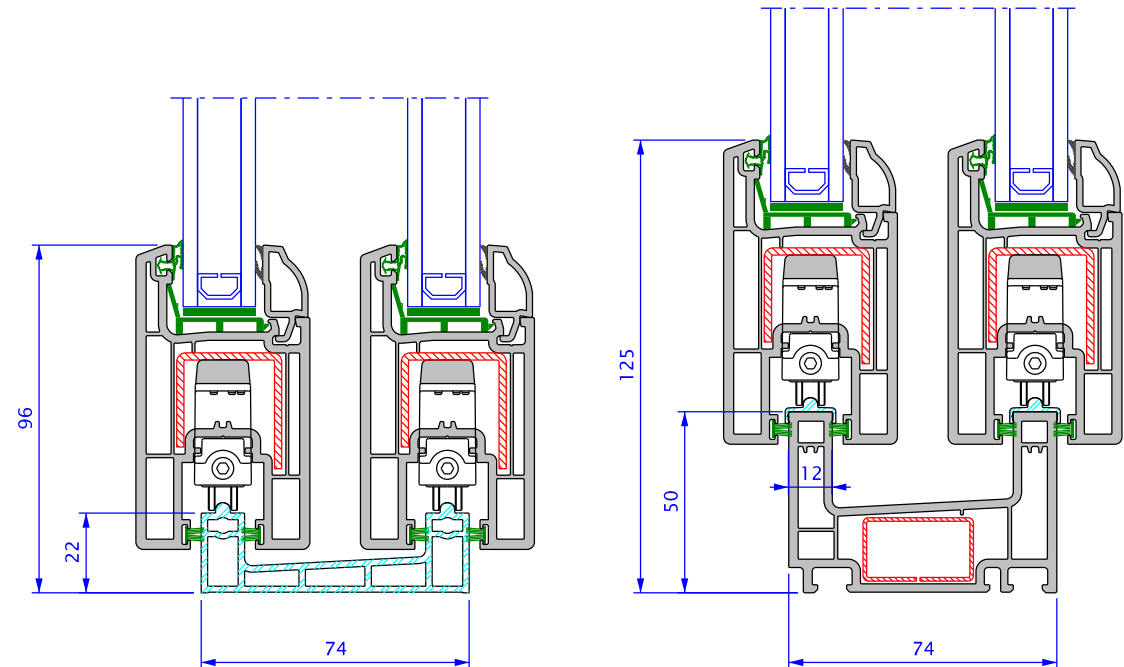




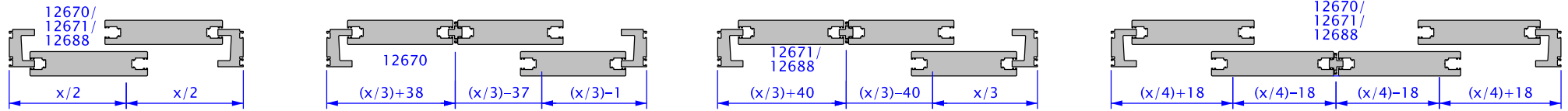
*Sliding aluminium bottom frame has 22 mm height that is lower than 12660 (50 mm). It has an advantage with low threshold as visually at the bottom

*Since the bottom frame material is aluminium, the sash works stable although there is any ground disorder.

*The design of aluminium frame includes aluminium rail. Therefore, there is no need to use additional rails.



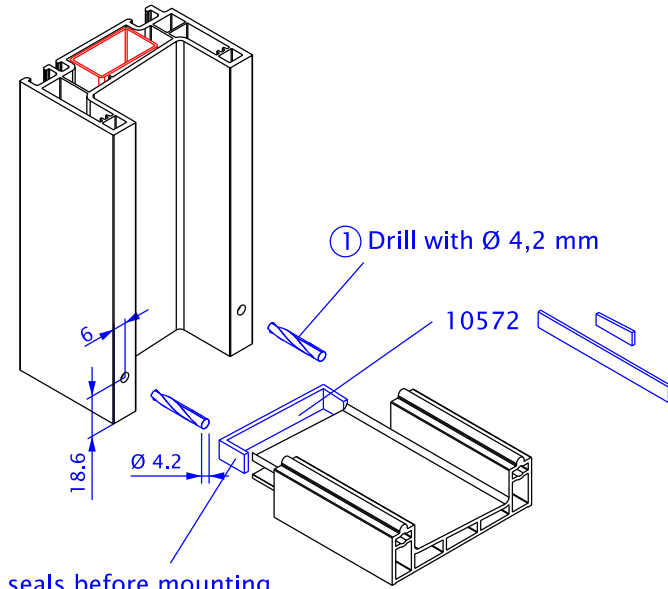
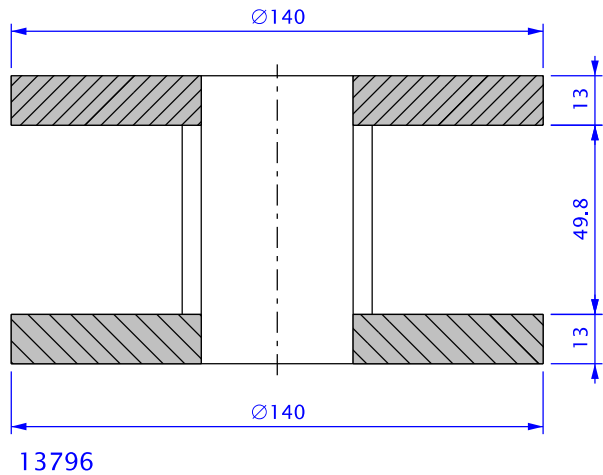
Axe Calculation : In the application of 12660, vertical axes should be determined as shown below.



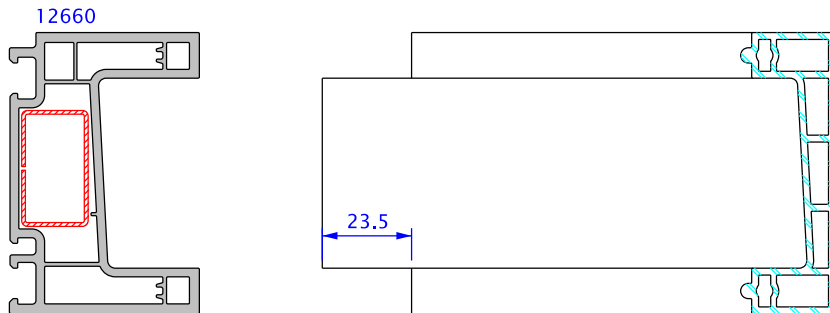
The sash overlap is 9 mm.

Welding thickness is included	Dimension			Cross-section diagrams										
Cutting Sliding Frame 12660	$x+6$ (45°)	$x+6$ (45°)	$x+6$ (45°)	$x+3$ (45°-90°)	-	-	-	-	-	-	-	-	-	-
Sliding Alum.Frame 13030	$x-53$ (90°)	$x-53$ (90°)	$x-53$ (90°)	-	-	-	-	-	-	-	-	-	-	-
Cutting Sliding Window Sash 12670	$\frac{x-2}{2}$	$\frac{x-6}{3}$	$\frac{x+68}{4}$	$x-48$	-	$x-23$	$x-26$	-	-	-	-	-	-	-
Glass Sliding Window Sash 12670	$\frac{x-226}{2}$	$\frac{x-342}{3}$	$\frac{x-380}{4}$	$x-160$	-	$x-135$	$x-138$	-	-	-	-	-	-	-
Cutting Sliding Sash 12671	$\frac{x+14}{2}$	$\frac{x+10}{3}$	$\frac{x+100}{4}$	$x-48$	-	$x-23$	$x-26$	-	-	-	-	-	-	-
Glass Sliding Sash 12671	$\frac{x-274}{2}$	$\frac{x-422}{3}$	$\frac{x-476}{4}$	$x-192$	-	$x-167$	$x-170$	-	-	-	-	-	-	-
Cutting Sliding Transom 12672	$\frac{x-206}{2}$	$\frac{x-312}{3}$	$\frac{x-340}{4}$	-	-	-	-	$x-82$	$x-85$	$x-105$	-	-	-	-
Glass Sliding Transom 12672	$\frac{x-226}{2}$	$\frac{x-342}{3}$	$\frac{x-380}{4}$	-	-	-	-	$x-92$	$x-95$	$x-115$	$x-96$	$x-52$	-	-
Cutting Sliding Transom 12672	$\frac{x-254}{2}$	$\frac{x-392}{3}$	$\frac{x-436}{4}$	-	-	-	-	$x-98$	$x-101$	-	-	-	-	-
Glass Sliding Transom 12672	$\frac{x-274}{2}$	$\frac{x-422}{3}$	$\frac{x-476}{4}$	-	-	-	-	$x-108$	$x-111$	-	-	-	-	-
Cutting Sliding Frame(Transom) 12660	-	-	-	-	$x-60$	-	-	-	-	-	-	-	-	-
Glass Sliding Frame(Transom) 12660	-	-	-	-	$x-140$	-	-	-	-	-	-	-	-	-
Cutting Sliding Frame fix Adp. 12666	-	-	-	-	$x-100$	-	-	-	-	-	$x-75$	-	-	-

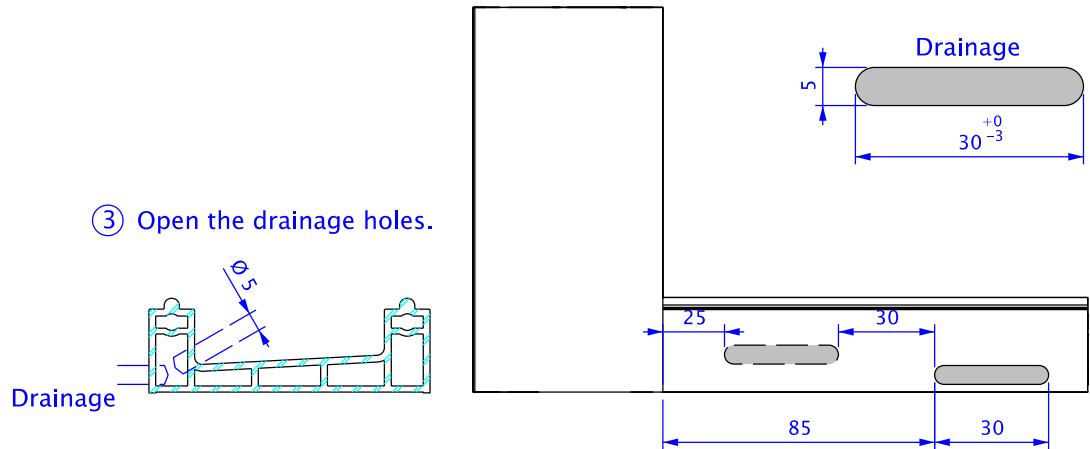
Technical documents are subject to change without notice



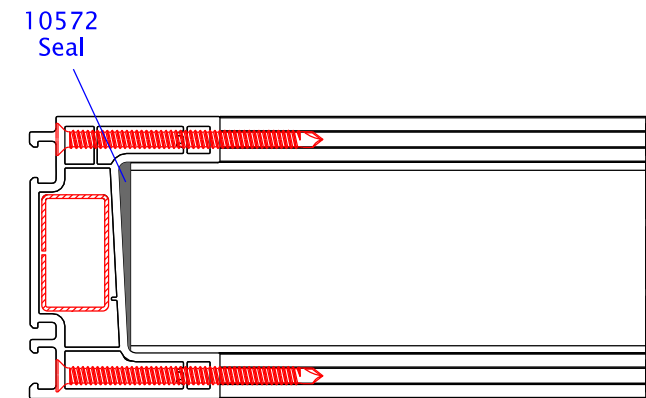
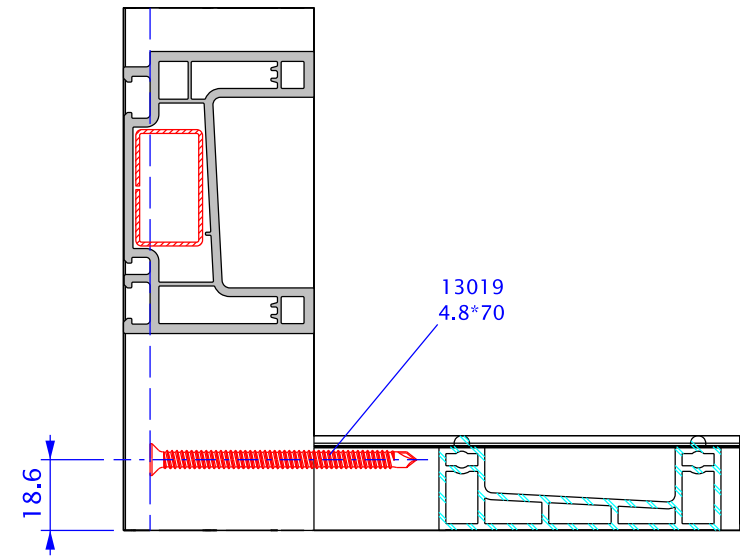
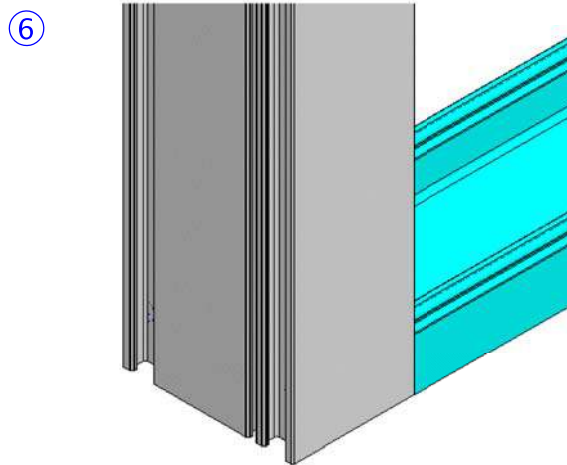
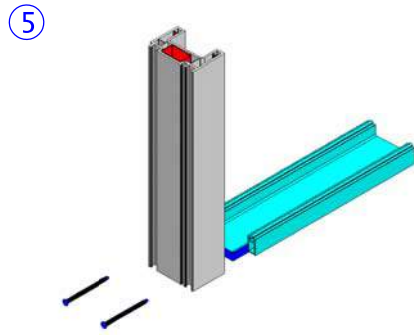
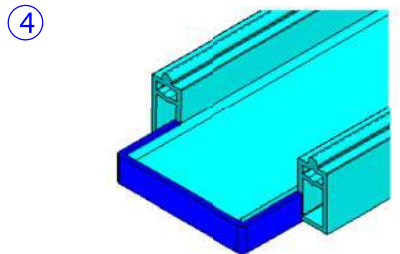
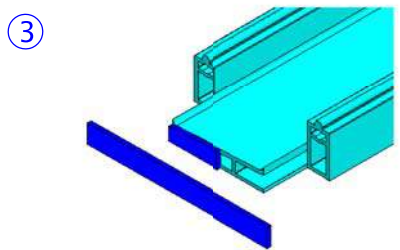
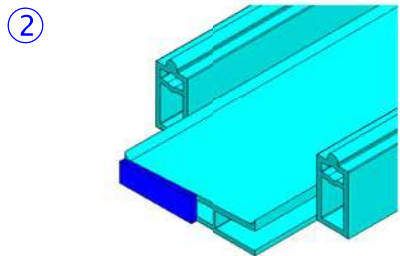
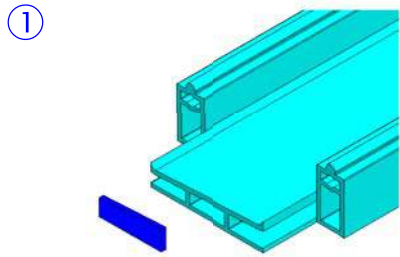
④ Use the seals before mounting frame.



② 13030 Is end-milled with 13796

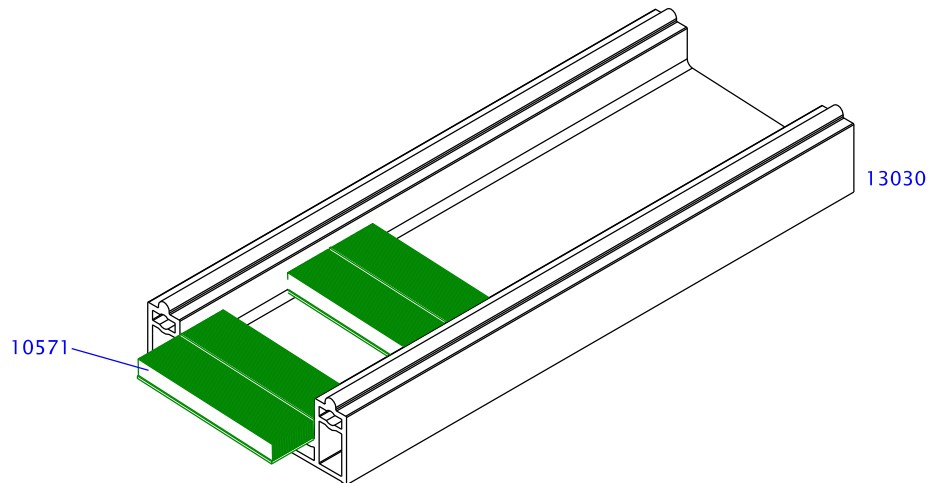
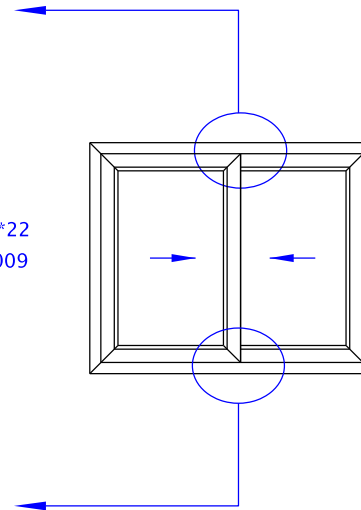
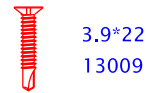
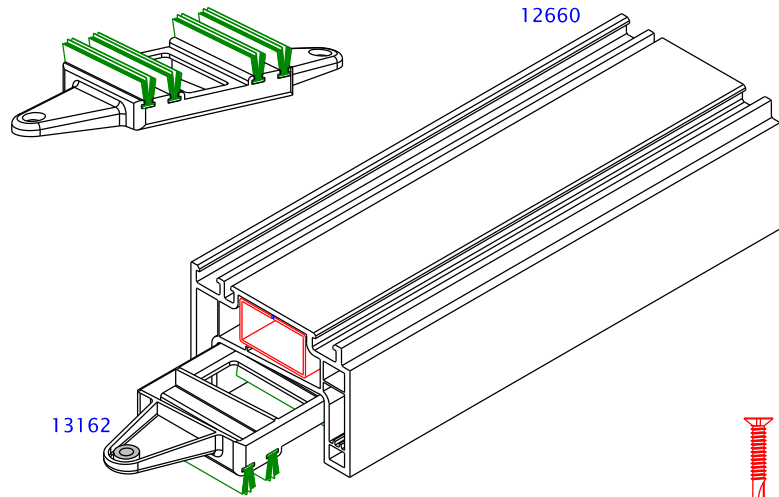


③ Open the drainage holes.



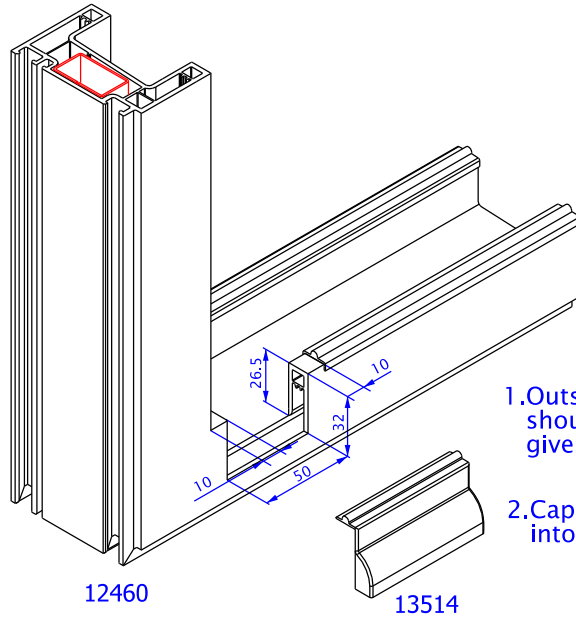
* After the end-milling is finished, seals are bonded to the frame on both sides.

Then , the aluminium profile is fixed to vertical sliding frames from outside.



* Use 10571 (brush) on aluminium frame at the bottom.
13162 is used on top side of frame as standart.

In sliding windows/doors , 13514-sliding water drainage cap can be used to have advantage of faster water discharge.

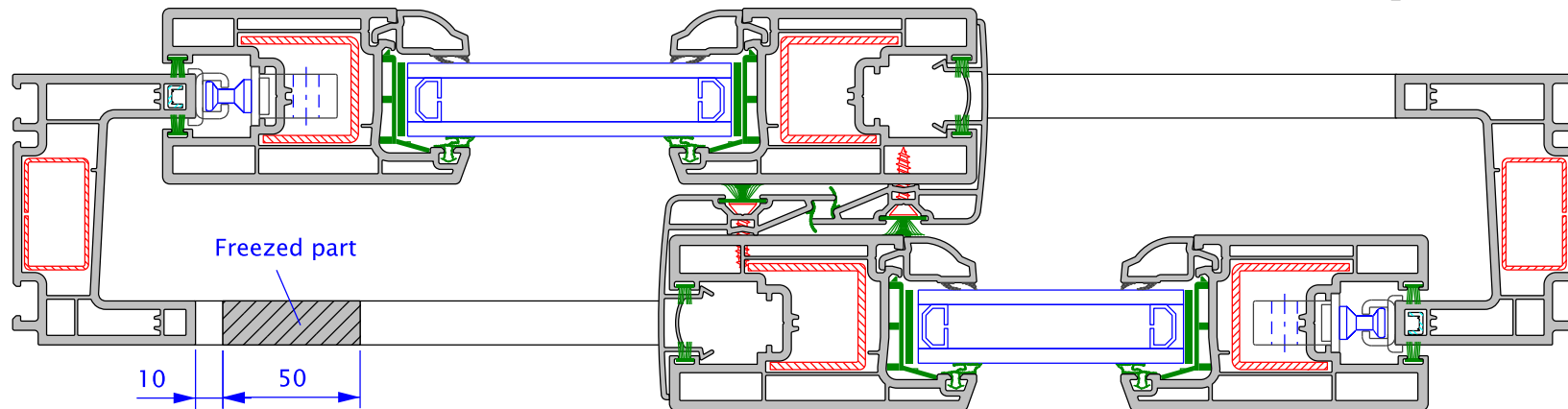
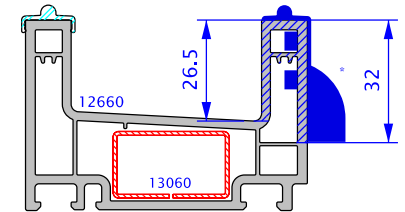
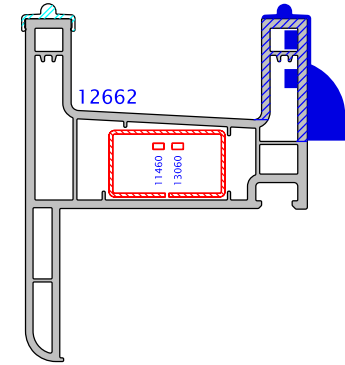
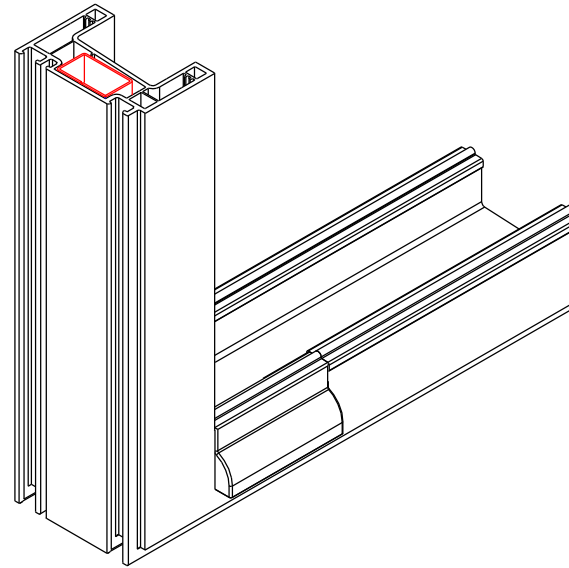


12460
Outside view

13514

1. Outside rail of frame should be freeze as given dimensions on left

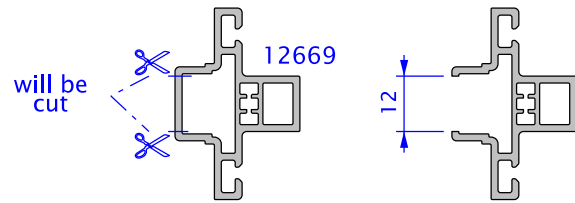
2. Cap is inserted into this groove



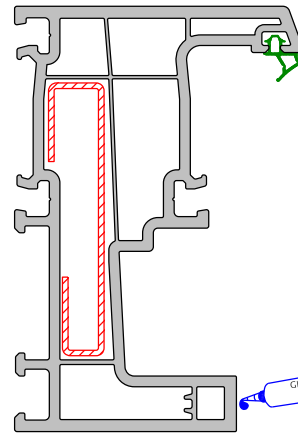
Freezed part

10 50

12669–Sliding Sash Coupling profile is cut as 96 mm decreased from 12661 height and 156 mm from 12663, according to frame options.

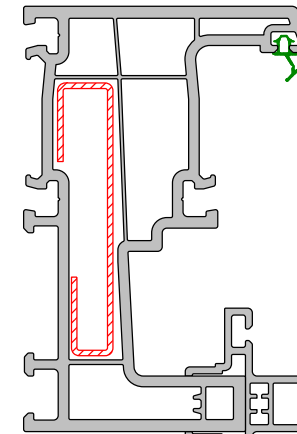
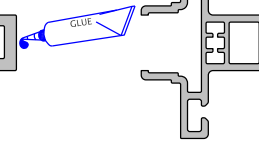


12669 sash coupling profile is cut as given in the figure



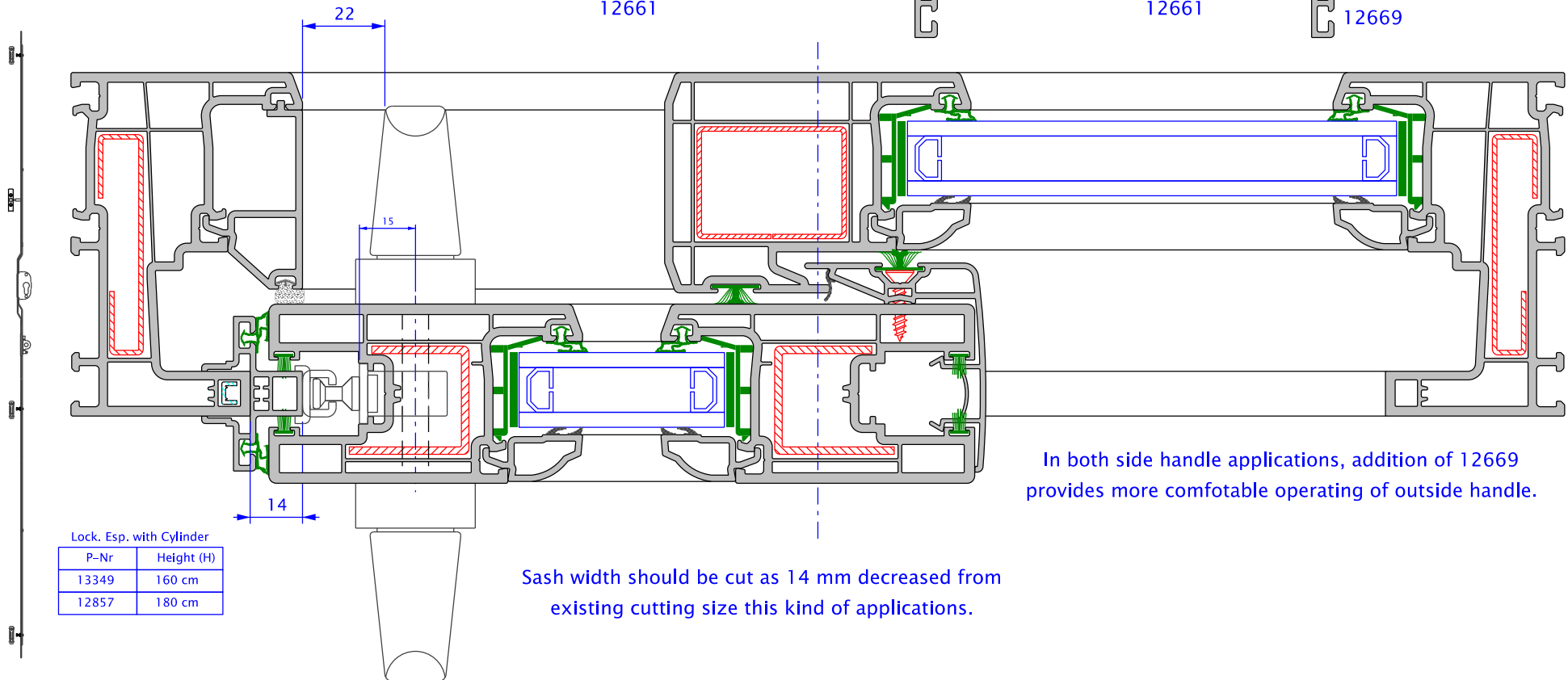
12661

Cut 12669 is glued along with frame



12661

12669

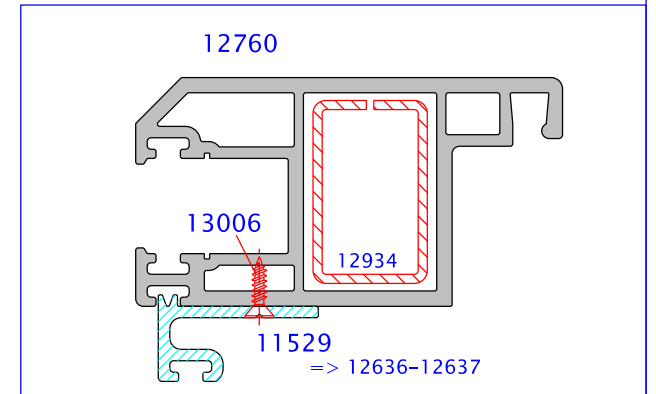
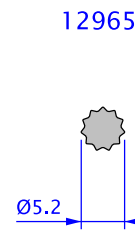
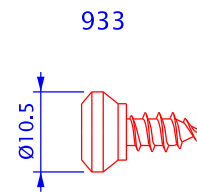
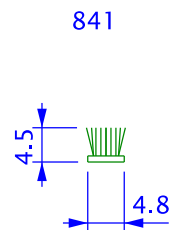
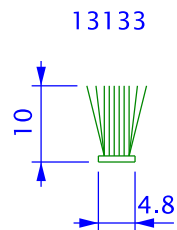
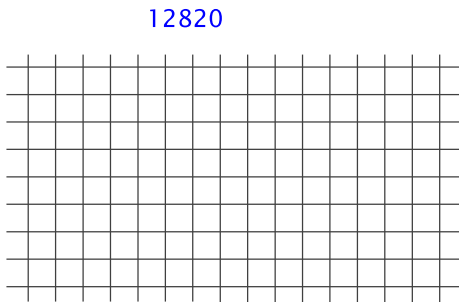
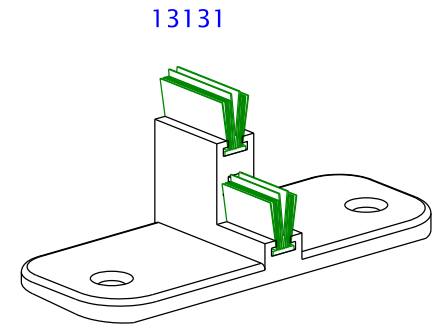
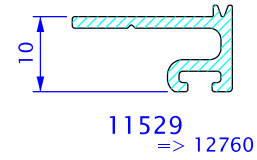
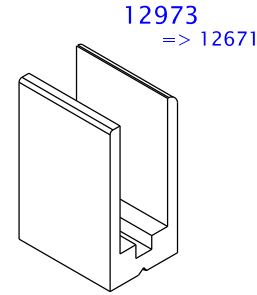
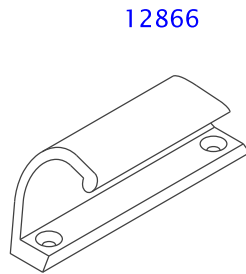
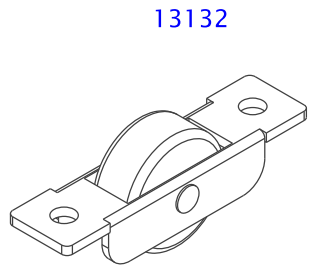
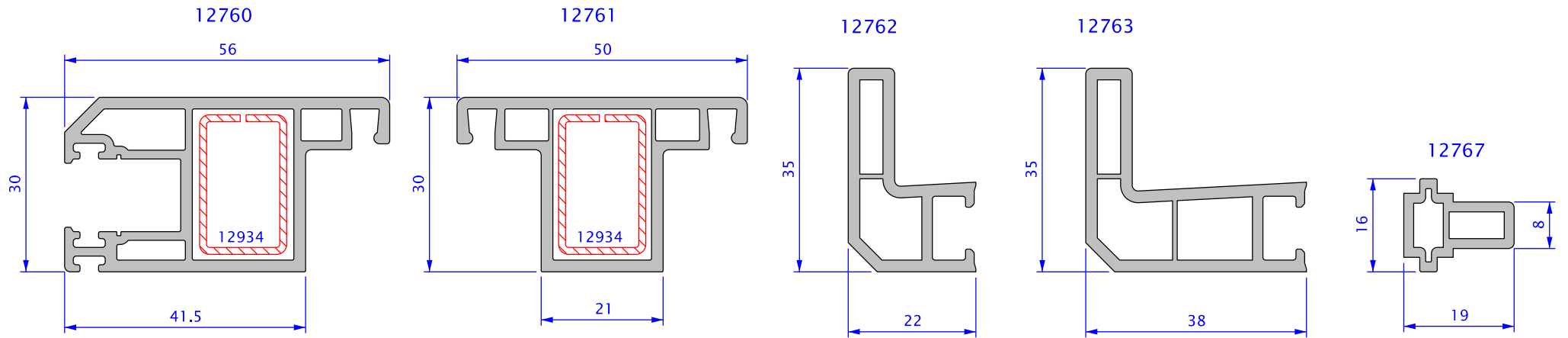


Lock. Esp. with Cylinder

P-Nr	Height (H)
13349	160 cm
12857	180 cm

Sash width should be cut as 14 mm decreased from existing cutting size this kind of applications.

In both side handle applications, addition of 12669 provides more comfortable operating of outside handle.

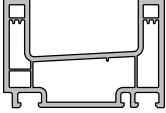

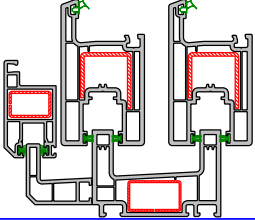
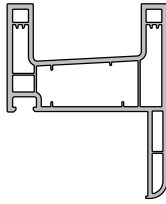

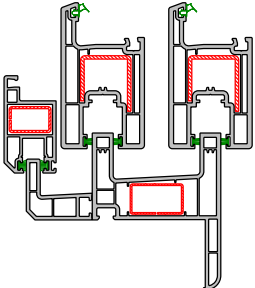
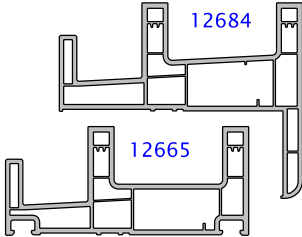

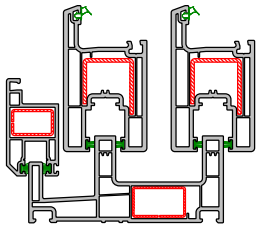
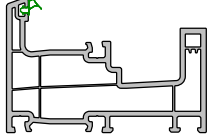

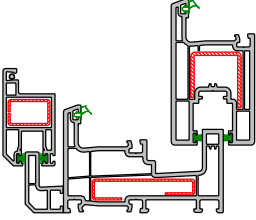
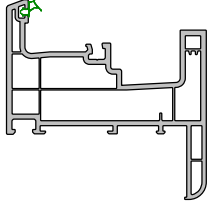

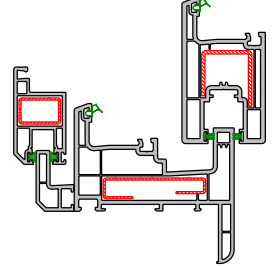
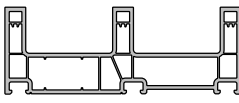

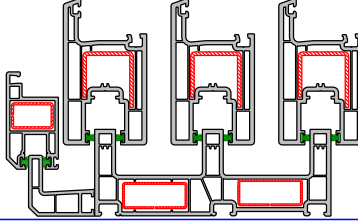
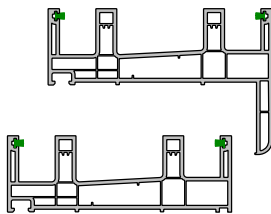

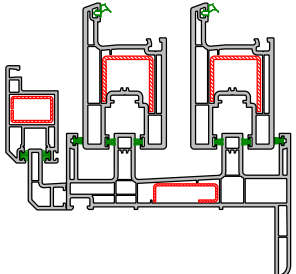


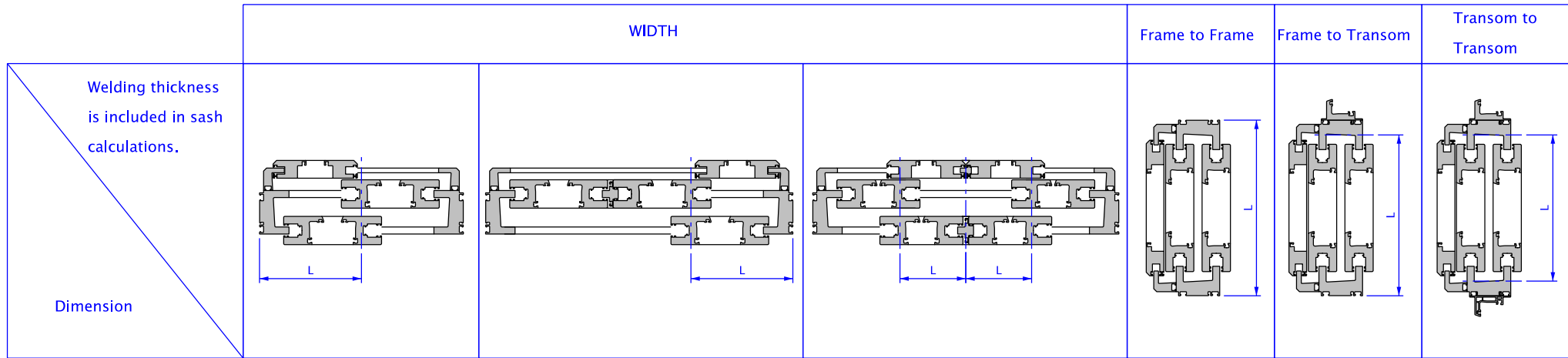
Sliding flyscreen rail must be chosen depending on the sliding frame.

There are 2 types of sliding flyscreen rails :

* Sliding flyscreen 22 mm

* Sliding flyscreen 38 mm

PVC	Flyscreen Rail	Application
12660 	12763 	
12662 	12763 	
 12684  12665	Flyscreen Rail is existing on the frame profile	
12661 	12762 	
12663 	12762 	
12658 	12763 	
	12762 	

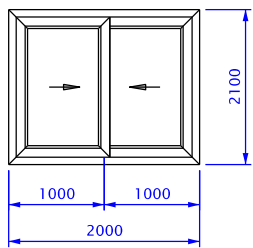


	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
				Width and Height	Width and Height	Width and Height
12763 Flyscreen Rail 38mm				L - 8	L + 17	L + 42

	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
				Height	Height	Height
SLIDING FLYSCREEN CALCULATION :						
12670 Sliding Window Sash	L - 24	L - 24	L - 2	L - 62	L - 37	L - 12
12671 Sliding Door Sash	L - 31	L - 31	L - 9	L - 62	L - 37	L - 12

EXAMPLE :

Sliding Frame (12660) , Sliding Sash (12671)

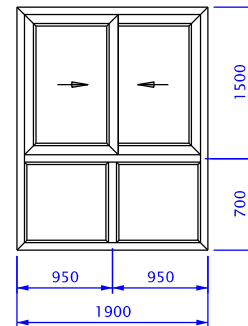


Flyscreen Rail 38 mm (12763)
Width : $2000 - 8 = 1992$ mm
Height : $2100 - 8 = 2092$ mm

Flyscreen Sash (12670)
Width : $1000 - 31 = 969$ mm
Height : $2100 - 62 = 2038$ mm

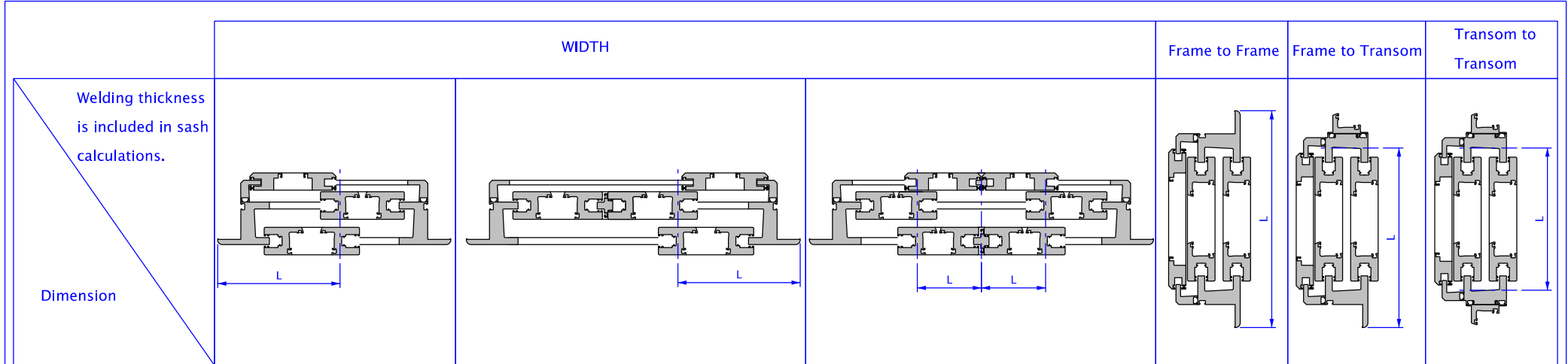
EXAMPLE :

Sliding Frame (12660) , Sliding Window Sash (12670)



Flyscreen Rail 38 mm (12763)
Width : $1900 - 8 = 1892$ mm
Height : $1500 + 17 = 1517$ mm

Flyscreen Sash (12670)
Width : $950 - 24 = 926$ mm
Height : $1500 - 37 = 1463$ mm

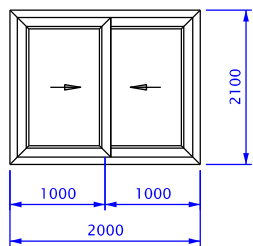


				Width and Height	Width and Height	Width and Height
12763 Flyscreen Rail 38mm				L - 8	L + 17	L + 42

SLIDING FLYSCREEN CALCULATION :				Height	Height	Height
12670 Sliding Window Sash	L - 71	L - 71	L - 2	L - 128	L - 70	L - 12
12671 Sliding Door Sash	L - 78	L - 78	L - 9	L - 128	L - 70	L - 12

EXAMPLE :

Sliding Architrave Frame (12662) , Sliding Door Sash (12671)

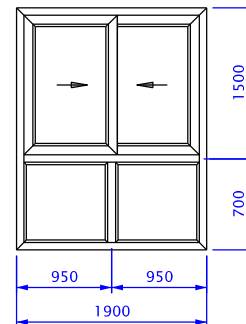


Flyscreen Rail 38 mm (12763)
Width : $2000 - 74 = 1926$ mm
Height : $2100 - 74 = 1926$ mm

Flyscreen Sash (12760)
Width : $1000 - 78 = 922$ mm
Height : $2100 - 128 = 1972$ mm

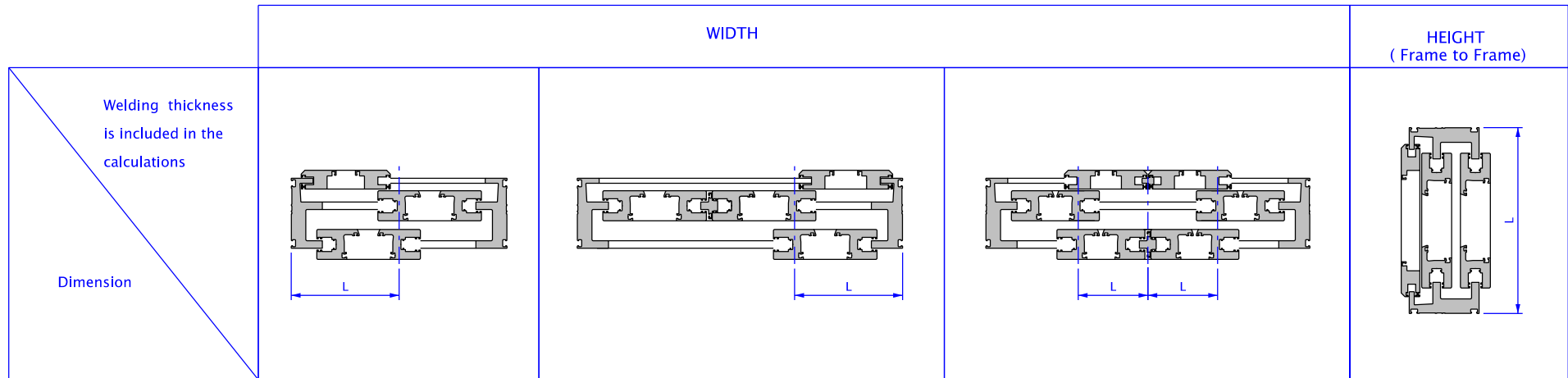
EXAMPLE :

Sliding Architrave Frame (12662) , Sliding Window Sash (12670)



Flyscreen Rail 38 mm (12763)
Width : $1900 - 74 = 1826$ mm
Height : $1500 - 16 = 1484$ mm

Flyscreen Sash (12760)
Width : $950 - 71 = 879$ mm
Height : $1500 - 70 = 1430$ mm



Cutting sizes of flyscreen sash :

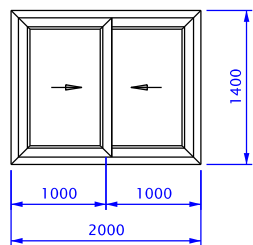
	WIDTH			HEIGHT (Frame to Frame)
12670 Sliding Window Sash	L - 10	L - 10	L - 2	L - 48
12671 Sliding Sash	L - 17	L - 17	L - 9	L - 48

EXAMPLE :

Calculations are based on Sliding window sash (12670)

Frame : Sliding Frame with of Screen (12665)

Sash : Sliding Window Sash (12670)



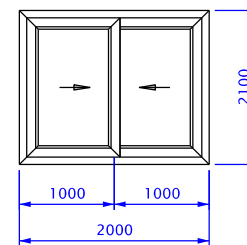
Flyscreen Sash (12760)
 Width : $1000 - 10 = 990$ mm
 Height : $1400 - 48 = 1352$ mm

EXAMPLE :

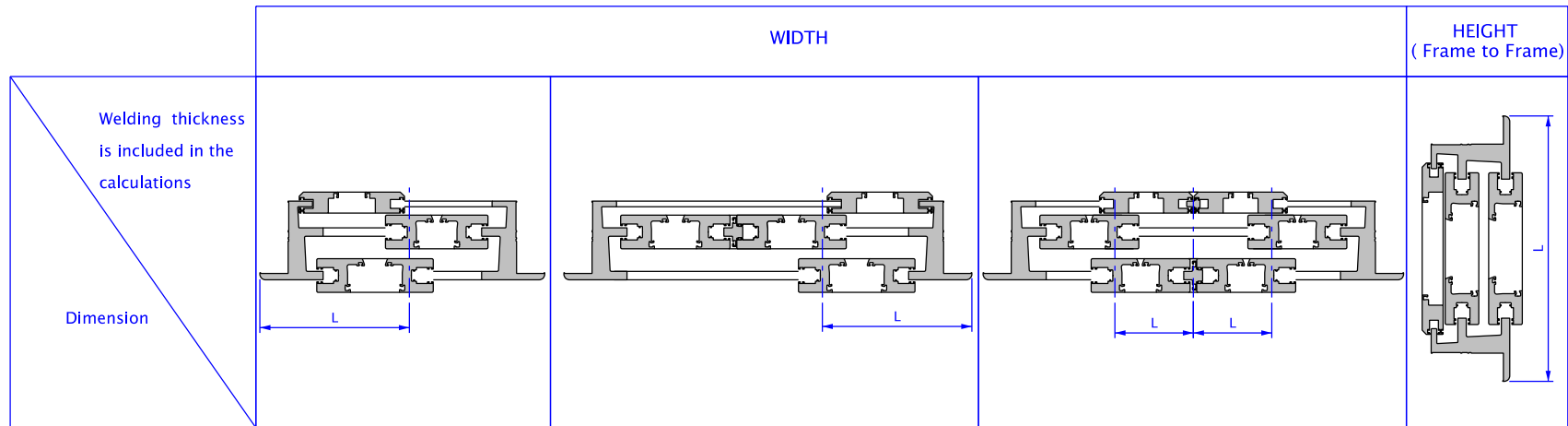
Calculations are based on Sliding window sash (12671)

Frame : Sliding Frame with of Screen (12665)

Sash : Sliding Sash (12671)



Flyscreen Sash (12760)
 Width : $1000 - 17 = 983$ mm
 Height : $2100 - 48 = 2052$ mm

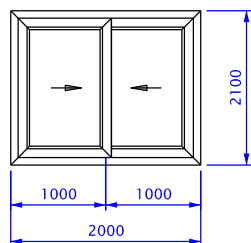


Cutting sizes of flyscreen sash :

				Height
12670 Sliding Window Sash	L - 71	L - 71	L - 2	L - 128
12671 Sliding Sash	L - 78	L - 78	L - 9	L - 128

EXAMPLE :

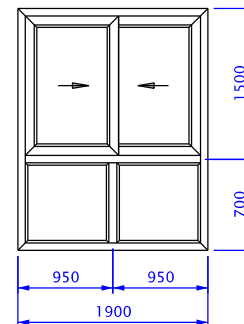
Sliding Arc. Frame with Flyscreen (12684) , Sliding Door Sash (12671)



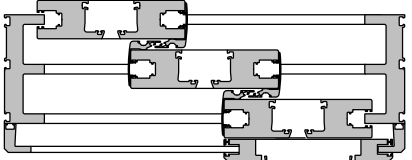
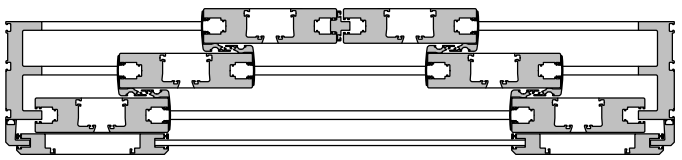
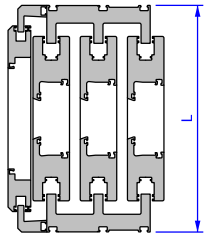
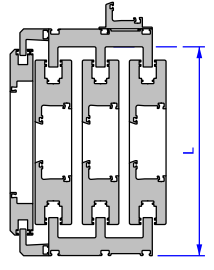
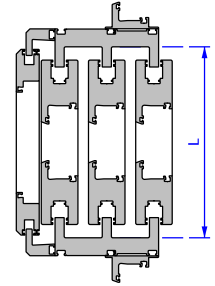
Flyscreen Sash (12760)
 Width : $1000 - 78 = 922$ mm
 Height : $2100 - 128 = 1972$ mm

EXAMPLE :

Sliding Arc. Frame with Flyscreen (12684) , Sliding Window Sash (12670)

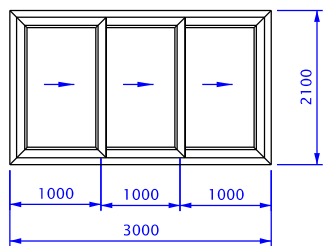


Flyscreen Sash (12760)
 Width : $950 - 71 = 879$ mm
 Height : $1500 - 70 = 1430$ mm

Welding thickness is included in sash calculations. Dimension	WIDTH		Frame to Frame	Frame to Transom	Transom to Transom
					
			Width and Height	Width and Height	Width and Height
12763 Flyscreen Rail 38mm			L + 6	L + 31	L + 56
SLIDING FLYSCREEN CALCULATION :			Height	Height	Height
12670 Sliding Window Sash	L - 17	L - 17	L - 48	L - 23	L + 2
12671 Sliding Door Sash	L - 24	L - 24	L - 48	L - 23	L + 2

EXAMPLE :

Sliding frame 3 rails (12664) , Sliding Door Sash (12671)

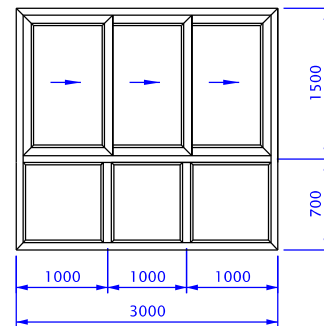


Flyscreen Rail 38 mm (12763)
Width : $3000+6=3006$ mm
Height : $2100+6=2106$ mm

Flyscreen Sash (12760)
Width : $1000-24=976$ mm
Height : $2100-48=2052$ mm

EXAMPLE :

Sliding frame 3 rails (12664) , Sliding Window Sash (12670)



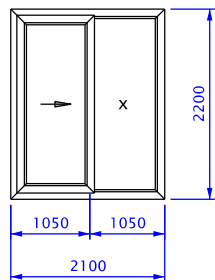
Flyscreen Rail 38 mm (12763)
Width : $3000+6=3006$ mm
Height : $1500+31=1531$ mm

Sürme Sineklik Kanat (12760)
Width : $1000-17=983$ mm
Height : $1500-23=1477$ mm

Welding thickness is included in sash calculations. Dimension	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
				Width and Height	Width and Height	Width and Height
12762 Flyscreen Rail 22 mm				L + 6	L + 27	L + 48
SLIDING FLYSCREEN CALCULATION :				Height	Height	Height
12671 Sliding Door Sash	L - 5	L + 16	L + 10	L - 48	L - 27	L - 6

EXAMPLE :

Sliding Fixed Frame (12661) , Sliding Door Sash (12671)

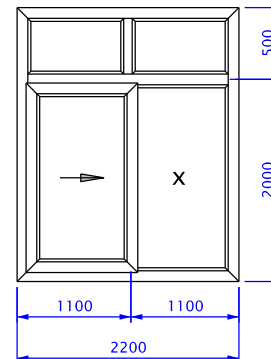


Flyscreen Rail 22 mm (12762)
 Width : $2100+6=2106$ mm
 Height : $2200+6=2206$ mm

Flyscreen Sash (12760)
 Width : $1050-5=1045$ mm
 Height : $2200-48=2152$ mm

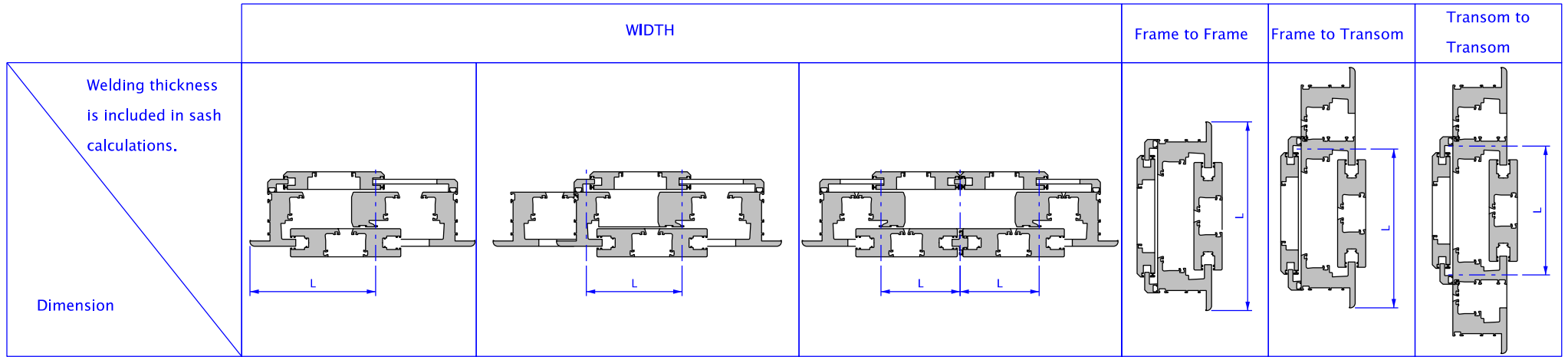
EXAMPLE :

Sliding Fixed Frame (12661) , Sliding Door Sash (12671)



Flyscreen Rail 22 mm (12762)
 Width : $2200+6=2206$ mm
 Height : $2000+27=2027$ mm

Flyscreen Sash (12760)
 Width : $1100-5=1095$ mm
 Height : $2000-27=1973$ mm

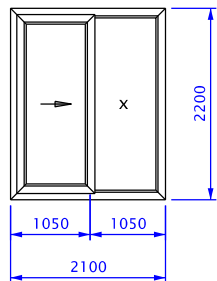


				Width and Height	Width and Height	Width and Height
12762 Flyscreen Rail 22 mm				L - 54	L - 3	L + 48

SLIDING FLYSCREEN CALCULATION :				Height	Height	Height
12671 Sliding Door Sash	L - 35	L + 16	L + 10	L - 108	L - 57	L - 6

EXAMPLE :

Fixed Sliding Architrave Frame (12663) , Sliding Door Sash (12671)

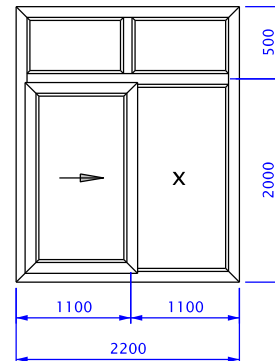


Flyscreen Rail 22 mm (12762)
Width : $2100 - 54 = 2046$ mm
Height : $2200 - 54 = 2146$ mm

Flyscreen Sash (12760)
Width : $1050 - 35 = 1015$ mm
Height : $2200 - 108 = 2092$ mm

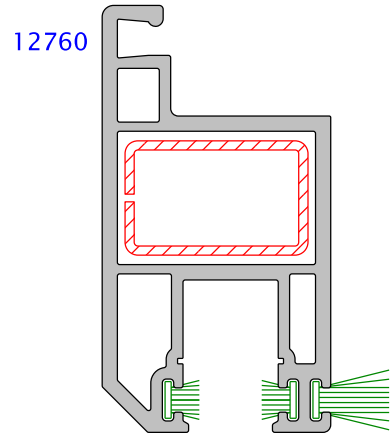
EXAMPLE :

Fixed Sliding Architrave Frame (12663) , Sliding Door Sash (12671)

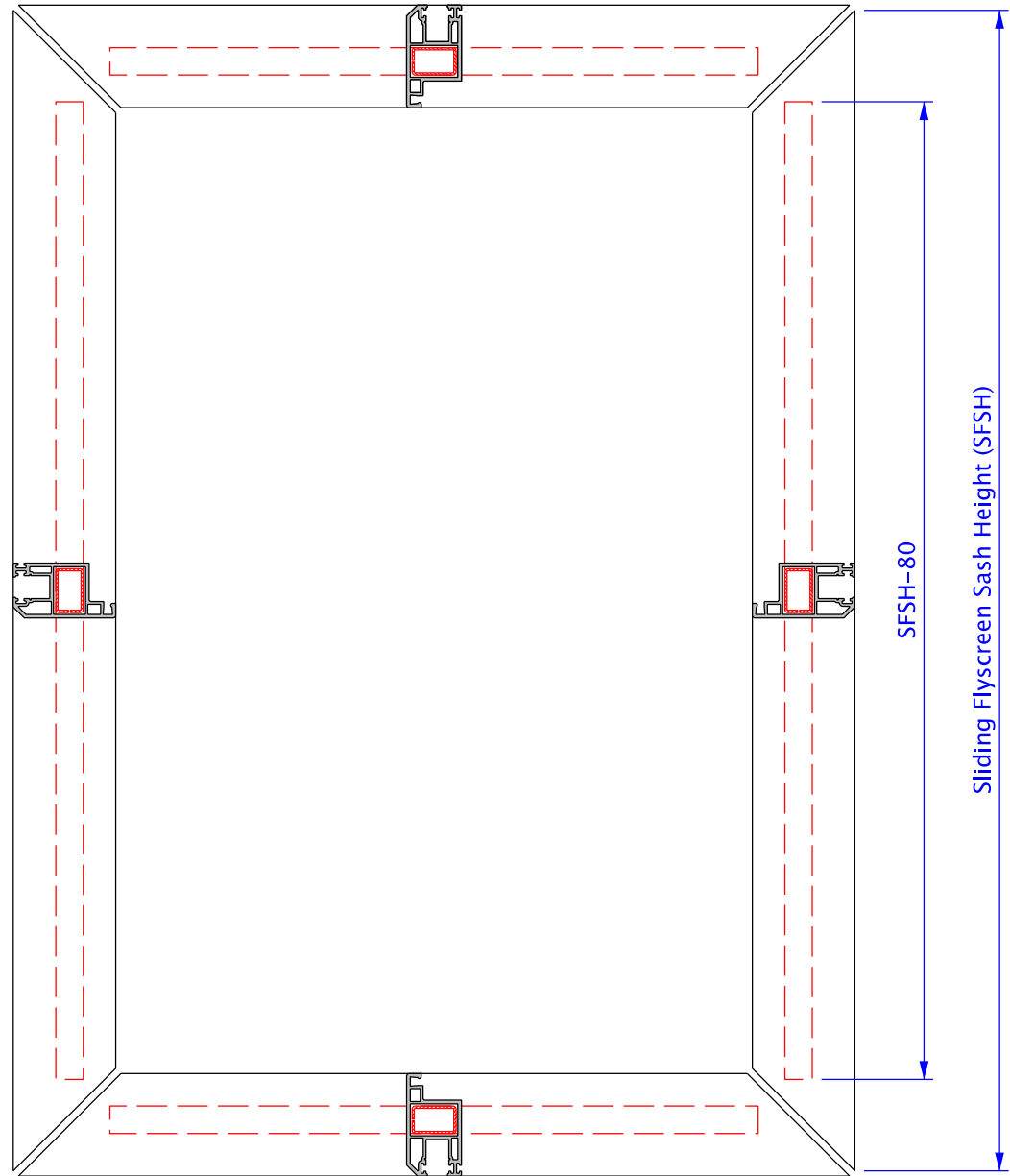
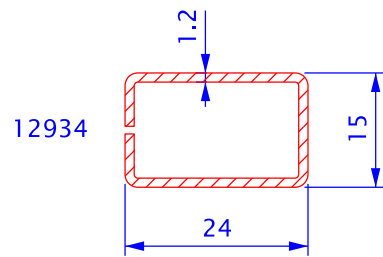


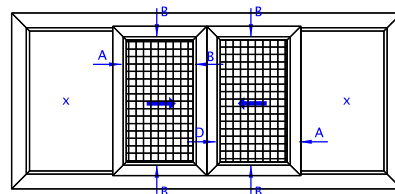
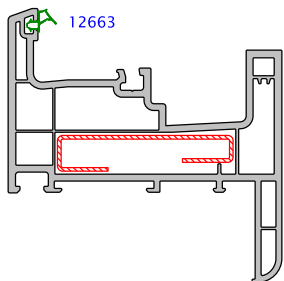
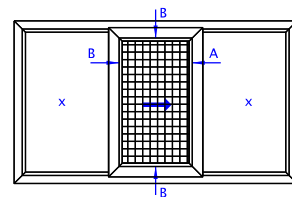
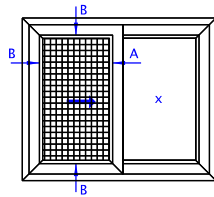
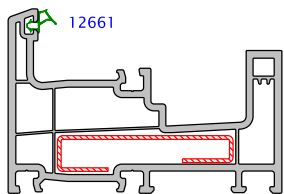
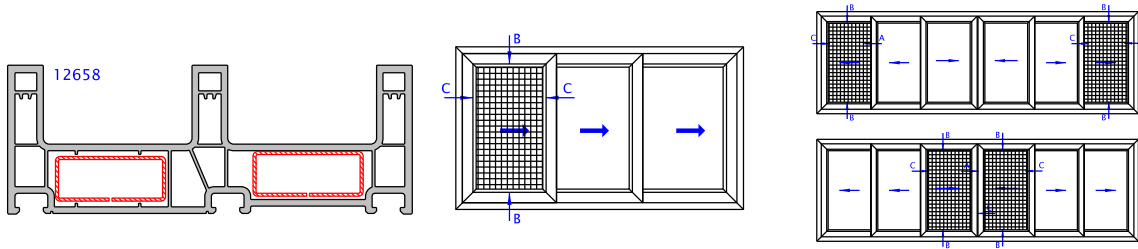
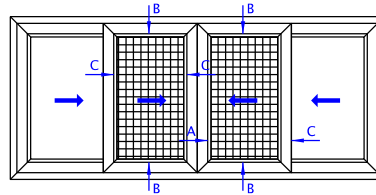
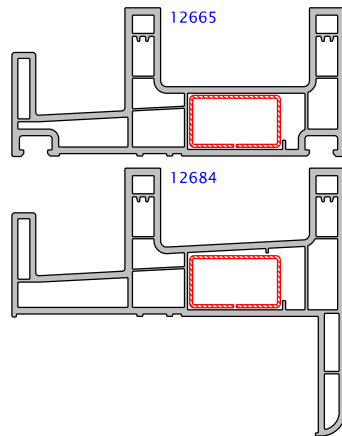
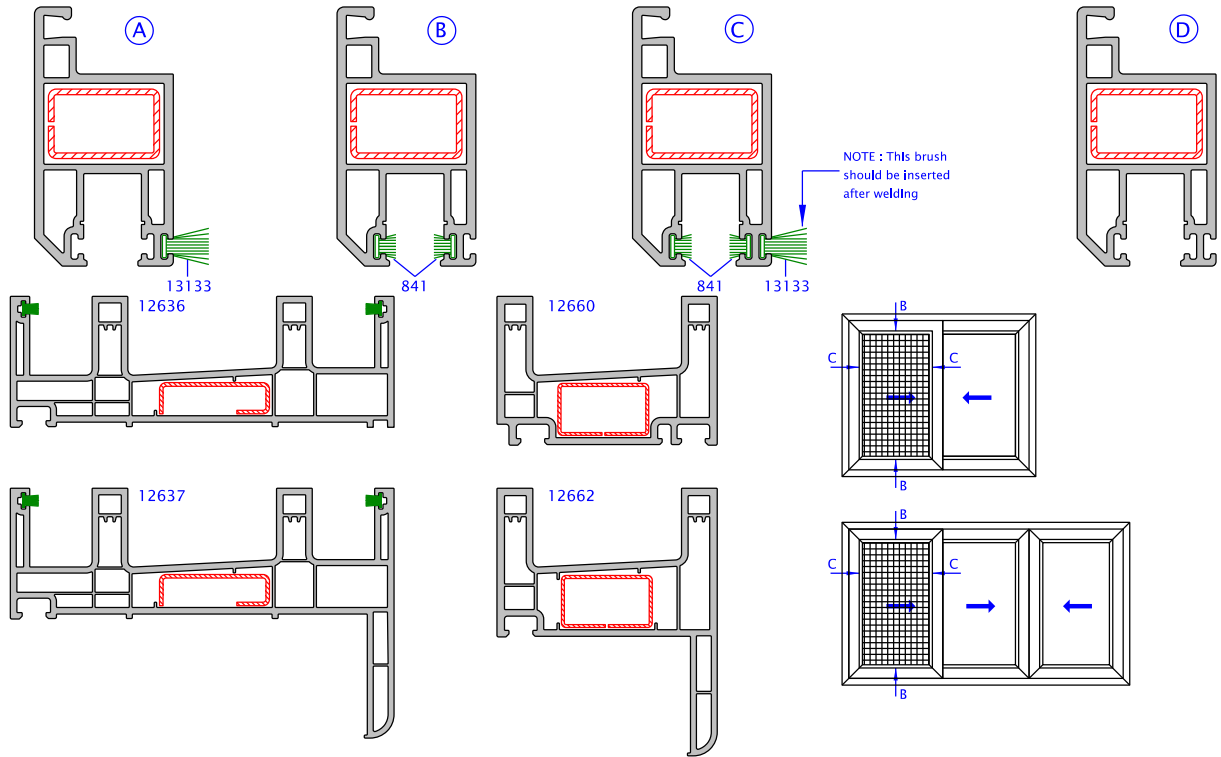
Flyscreen Rail 22 mm (12762)
Width : $2200 - 54 = 2146$ mm
Height : $2000 - 3 = 1997$ mm

Flyscreen Sash (12760)
Width : $1100 - 35 = 1065$ mm
Height : $2000 - 57 = 1943$ mm

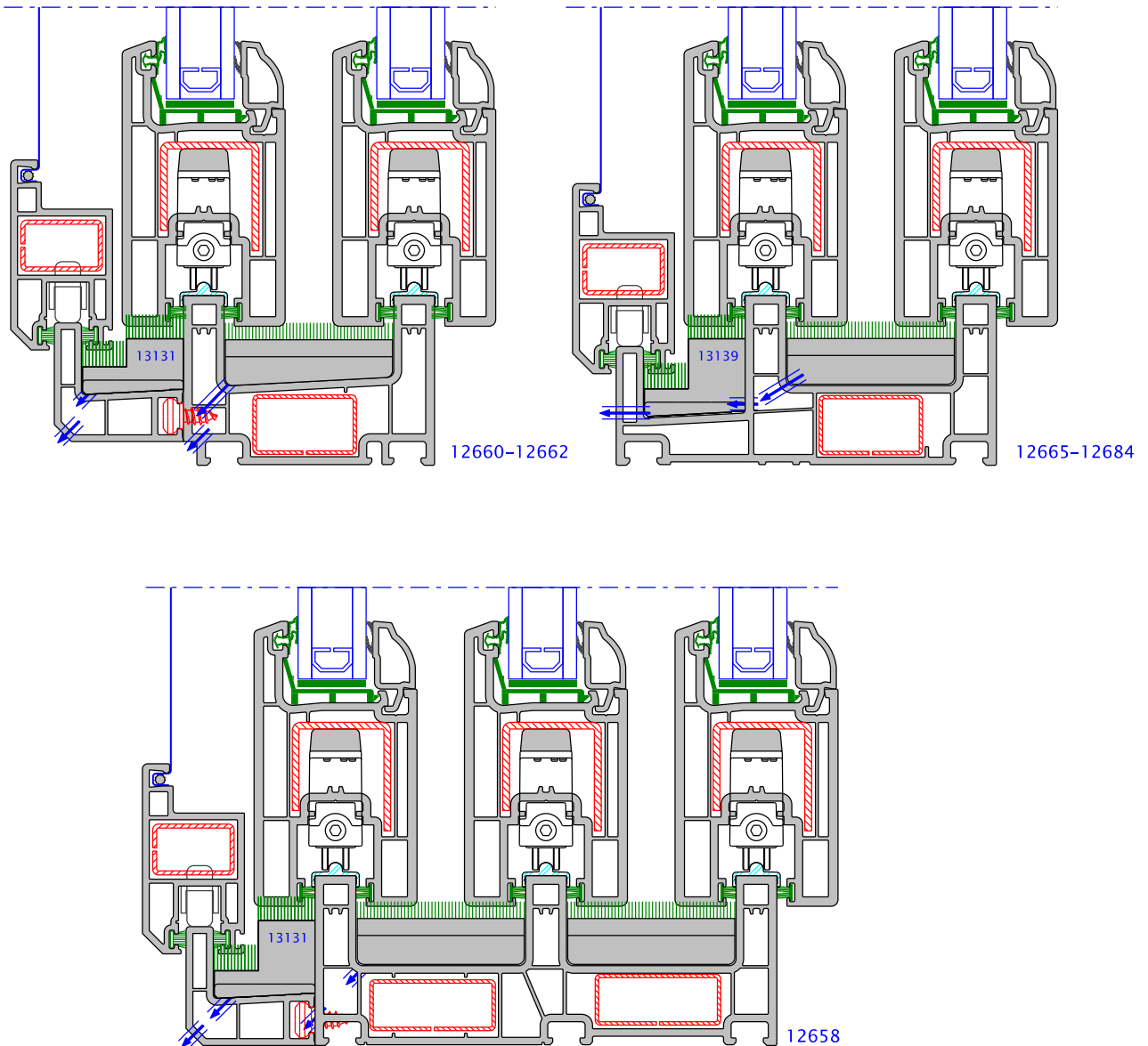


* Brushes (841 and 13133) are inserted before welding.





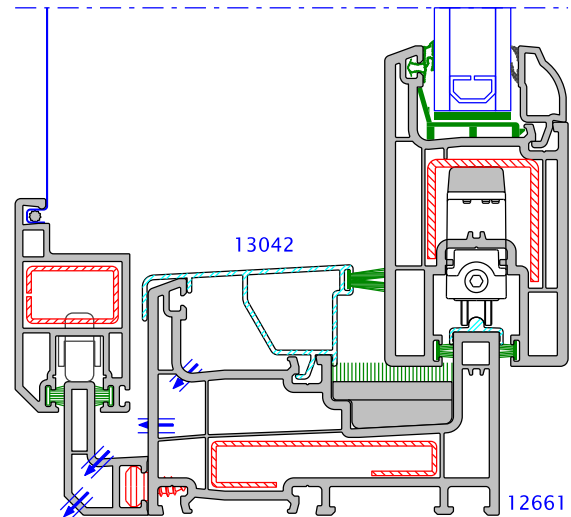
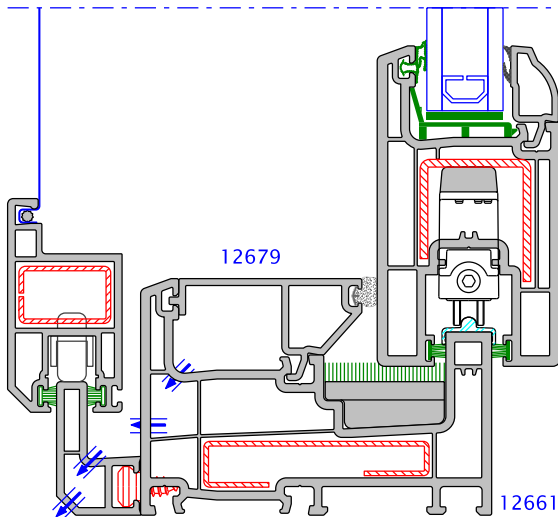
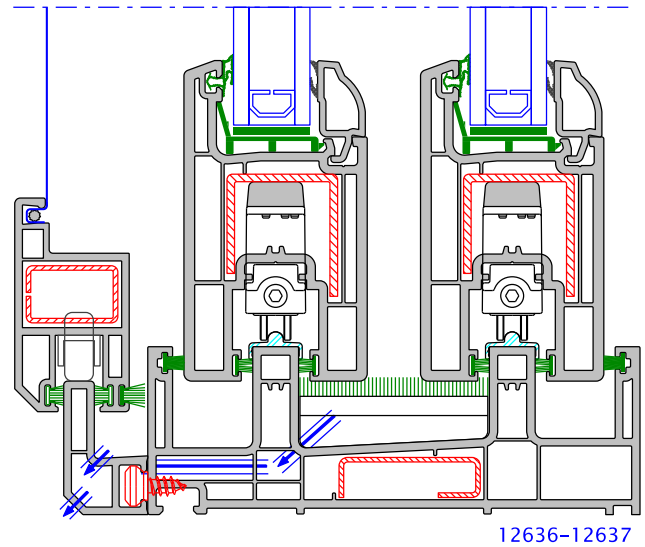
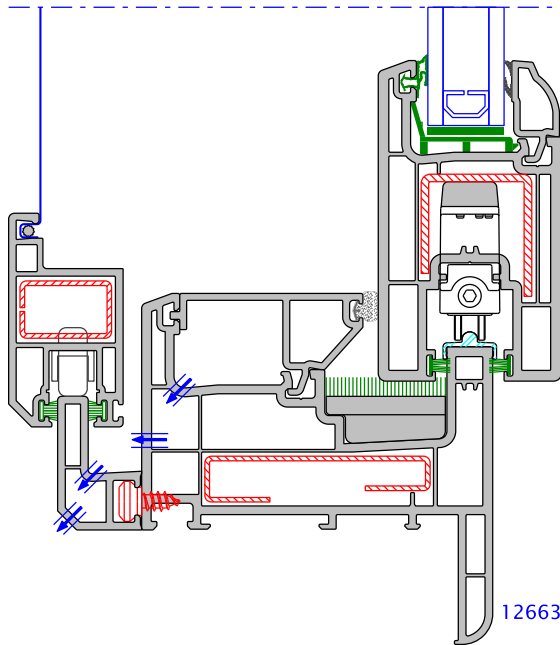
In the case of sliding frames (12660,12665 and 12664) since it is not possible to install drainage caps , water slots should be drilled also on flyscreen rails. The numbers of water discharge slots for flyscreen rails should be equal to sliding frame. Please find the application on the drawing below.



WELDING :

- * Flyscreen rails are welded and corner cleanings are done.
- * Brushes which are used inside of flyscreen sash, are inserted before welding.
- * After corner cleaning process, the brush that has the dimension as 48x1000 is inserted on outside of flyscreen sash according to the detail.

Other sliding frame applications are shown in the figure below. Drainage holes should be opened on both frame and flyscreen rails.



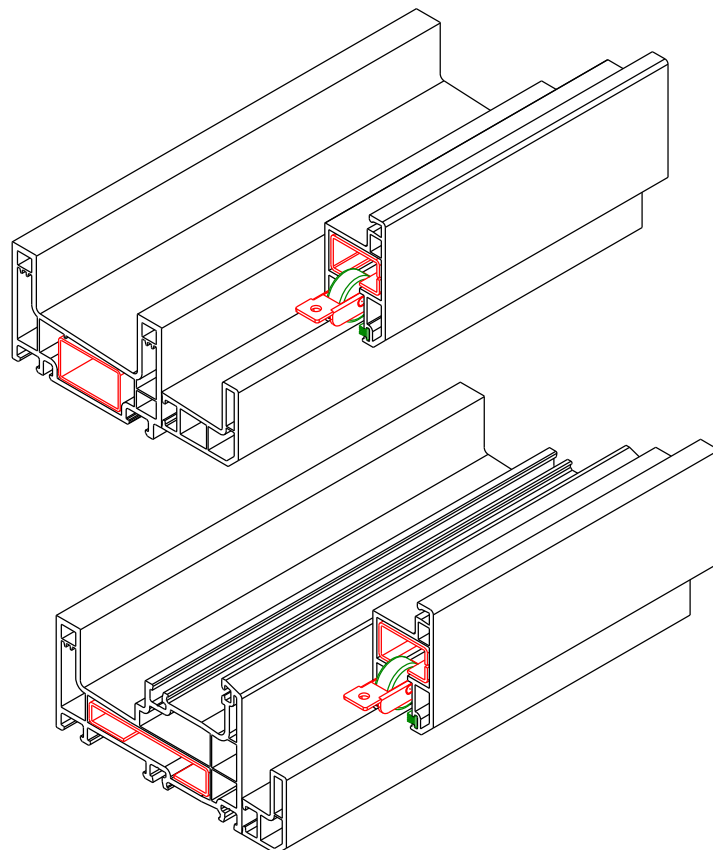
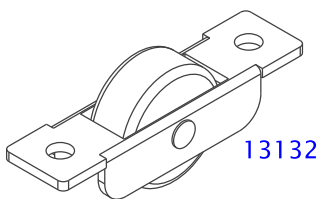
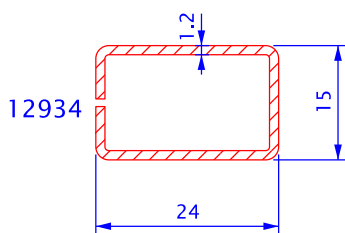
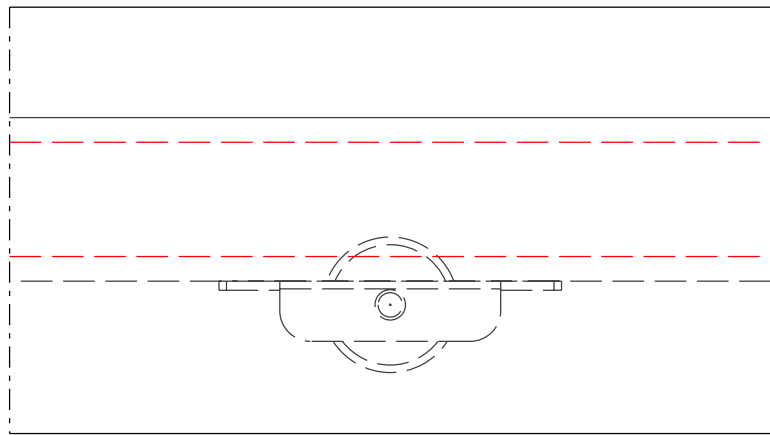
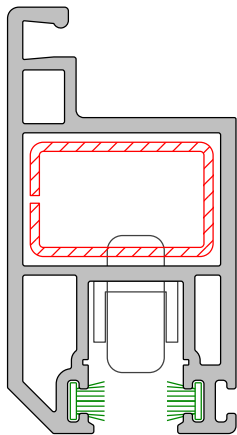
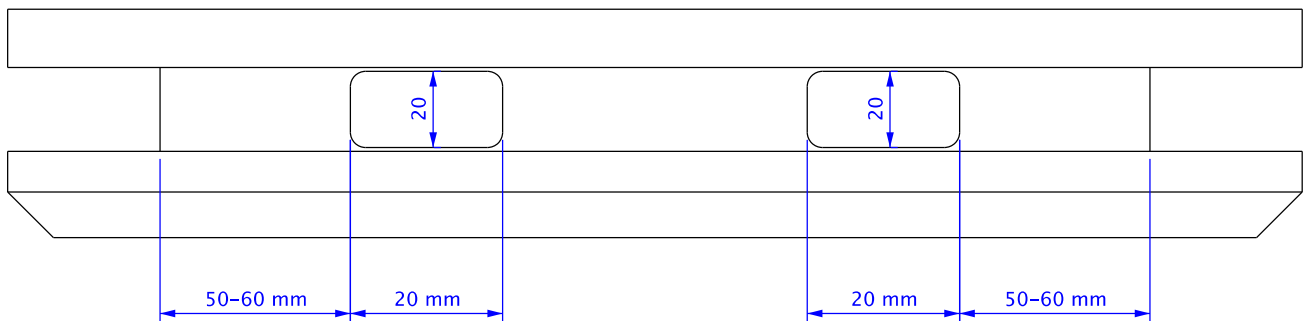
WELDING :

- * Flyscreen rails are welded and corner cleanings are done.
- * Brushes which are used inside of flyscreen sash, are inserted before welding.
- * After corner cleaning process, the brush that has the dimension as 48x1000 is inserted on outside of flyscreen sash according to the detail.

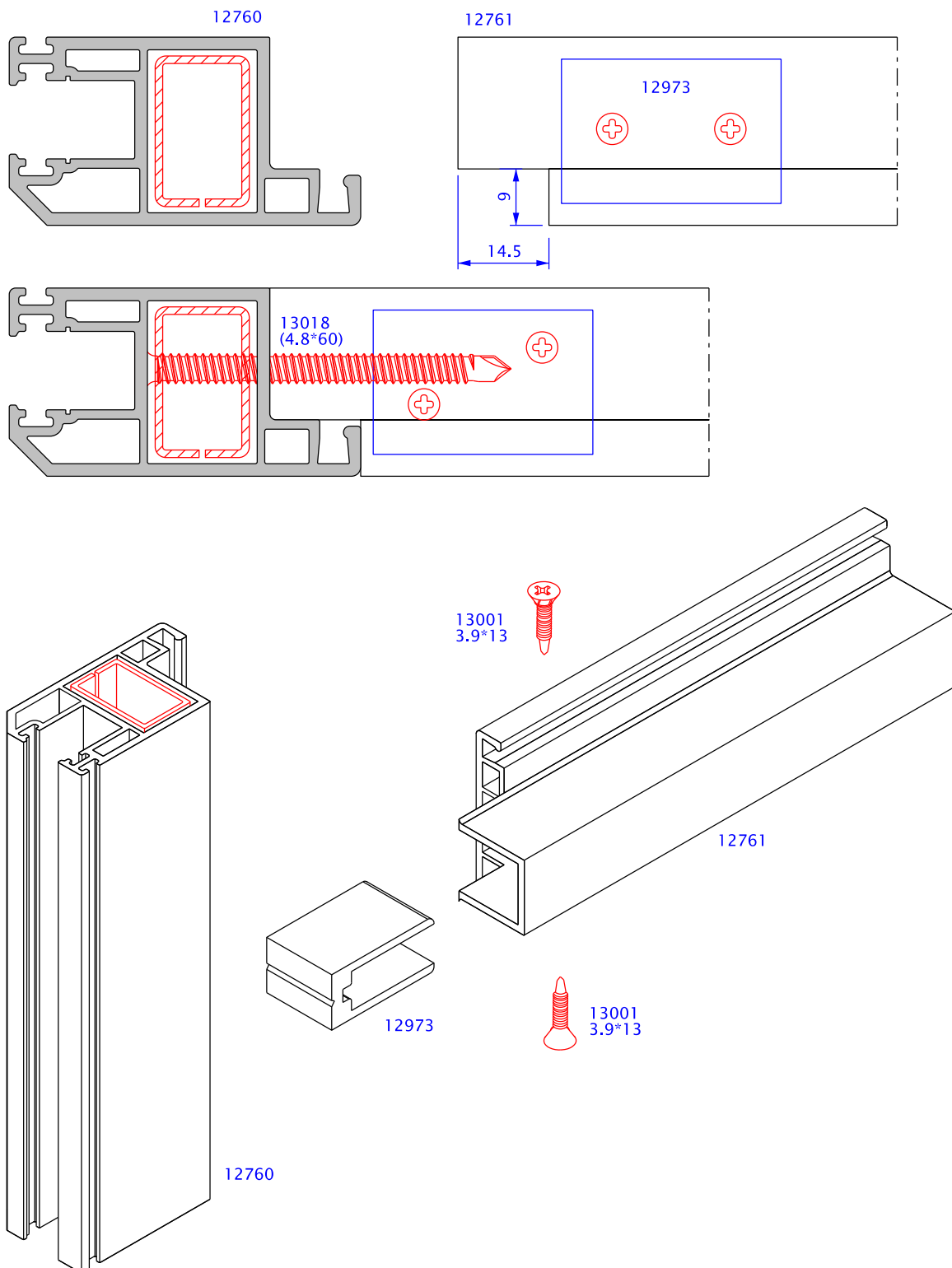
- * Reinforcement 15x24 mm (12934) is used in the sliding flyscreen sash (12760) and sliding flyscreen transom (12761) profiles,
- * The screw 3.9x16 cylindrical head must be used as 3 pieces/m

Flyscreen Roller (13132):

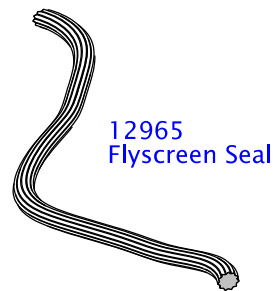
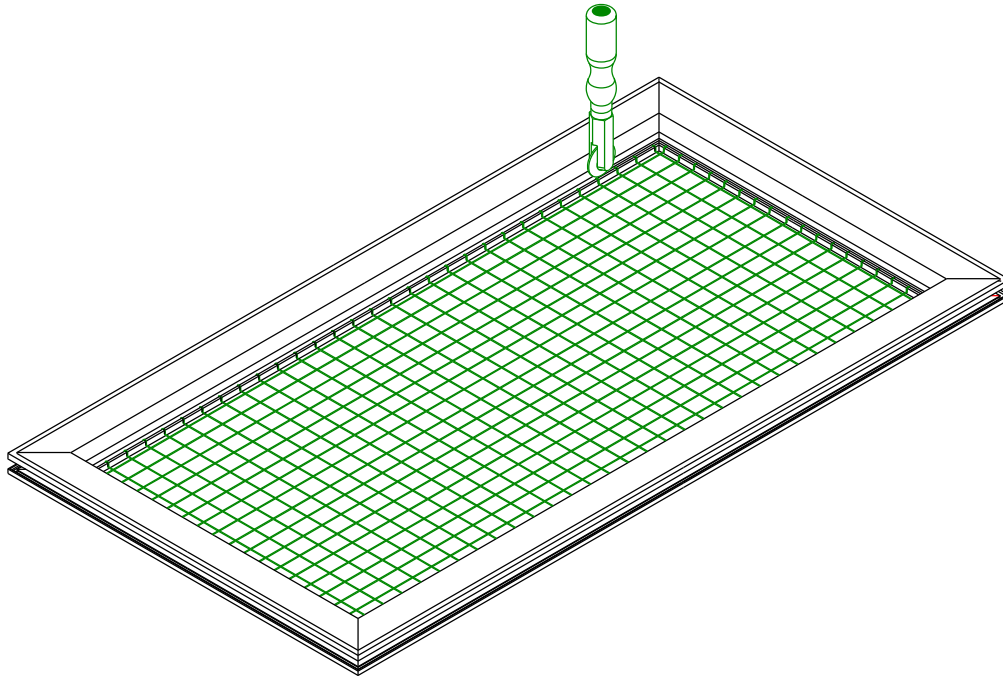
Flyscreen rollers (13132) can be mounted before welding of sash profiles.



- * Flyscreen transom profile is end milled,
- * Mechanical joint (12973) is fixed from the both side of flyscreen transom with screws that has the dimensions of 3.9x22.
- * The transom profile is mounted into the flyscreen sash. Profile by using screw 4.8x60 (flat head or cylindrical)
- * It is adviced to use transom profile when the sash length exceeds 1 m.



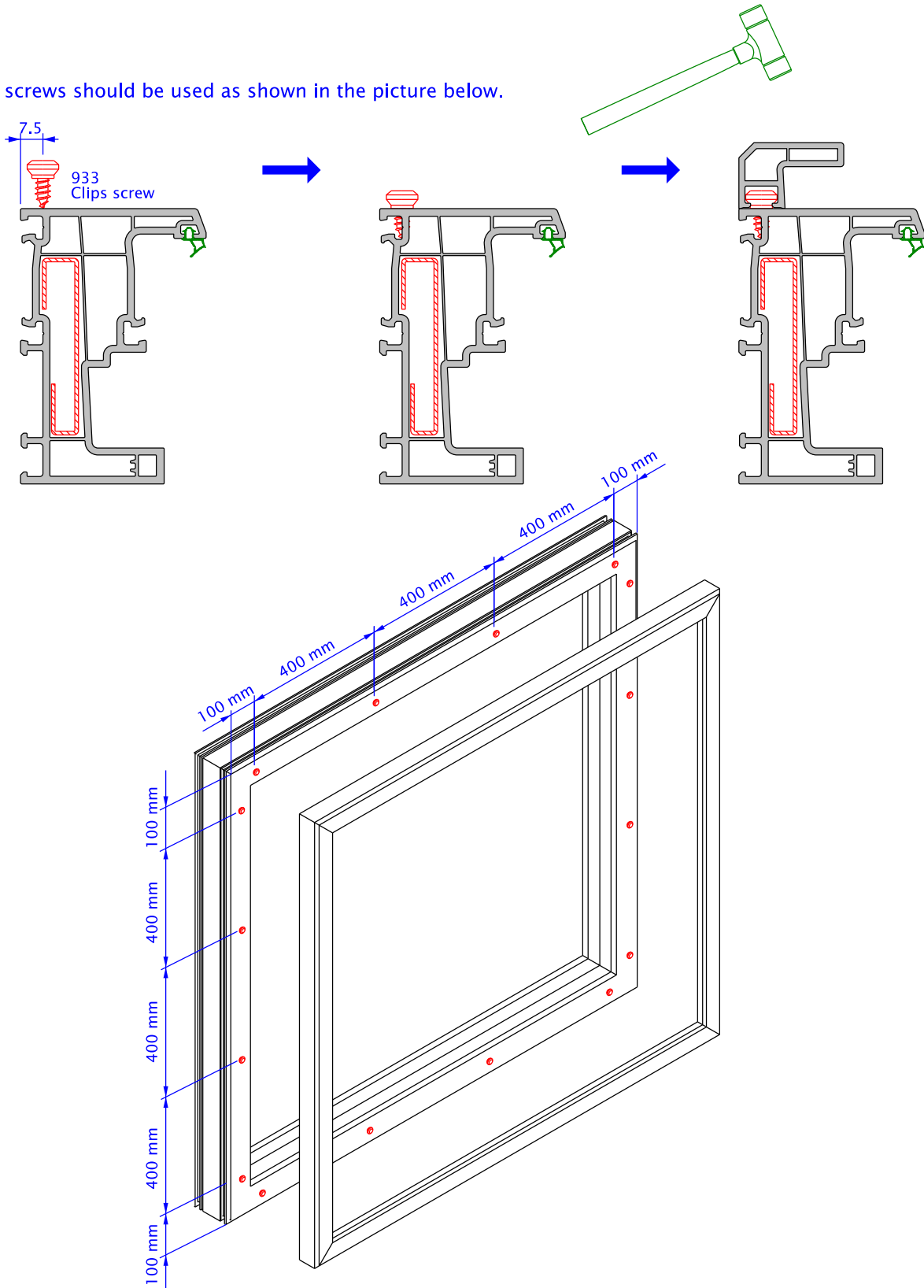
- * The flyscreen mesh is prepared by cutting 2–3 cm more than inside dimensions of flyscreen sash.
- * The mesh must be installed from the top corner,
- * The extensions of flyscreen mesh is cut after installation.



After the welding of flyscreen rails,

- * Clip screws are used on the outside of sliding frames (12660, 12661, 12663)
- * Sliding flyscreen rail can be bonded with glue (e.g. loctite) before hammering.
(Bonding surfaces must be clean, dry and free from grease on clip screw (933))
- * Flyscreen rails are installed on sliding windows by using hammer.

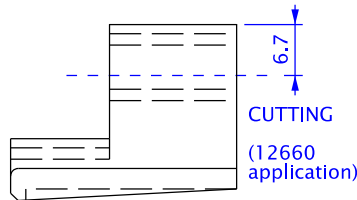
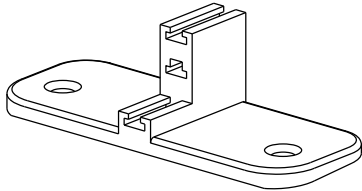
Clip screws should be used as shown in the picture below.



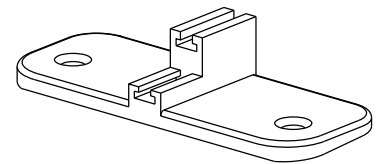
In the application of sliding frames (12660) flyscreen rail 38 mm is used. The flyscreen wedge (13131) is used at top and bottom. The brush (13133) that has the dimensions 048x1000 mm is inserted into flyscreen wedge (13131).

In the application of 12660, flyscreen wedge (13131) must be cut as shown below.

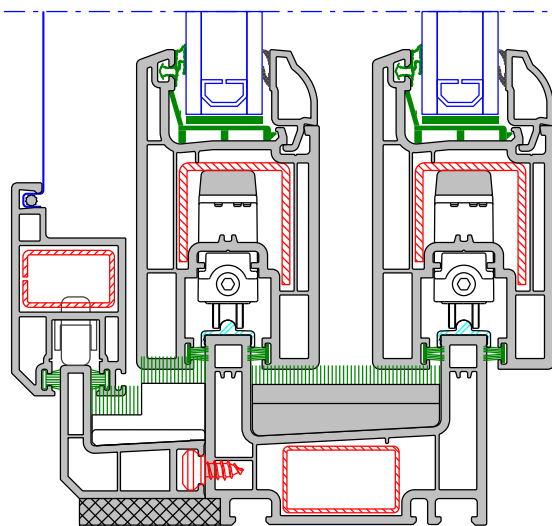
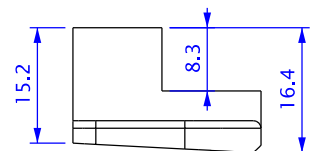
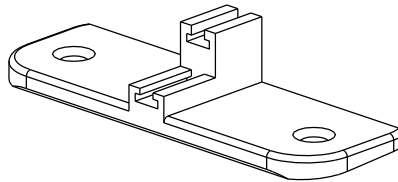
13131
=>12662-12658



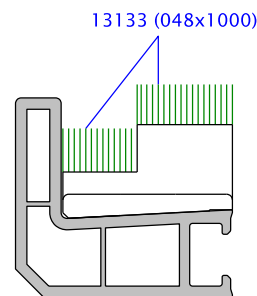
13131
=>12660



13139
=>12665-12684



Wooden Wedge

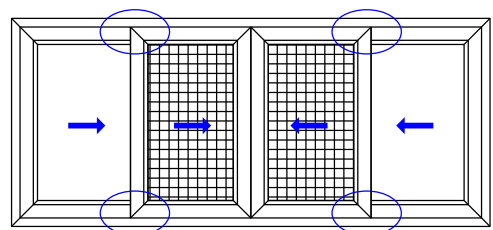
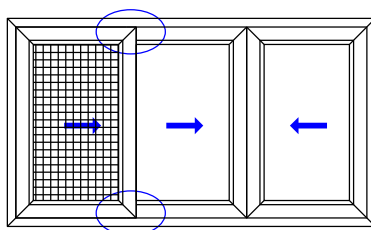
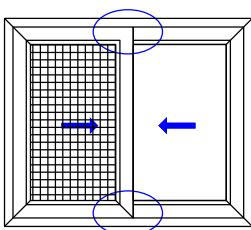


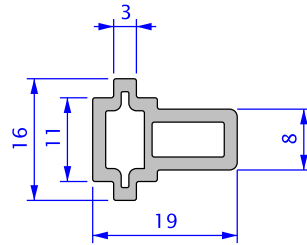
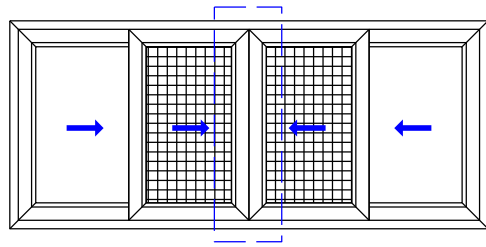
NOTE : Plastic or wooden wedges can be used to fill the empty area at the bottom of rail.

Flyscreen Wedge Applications :

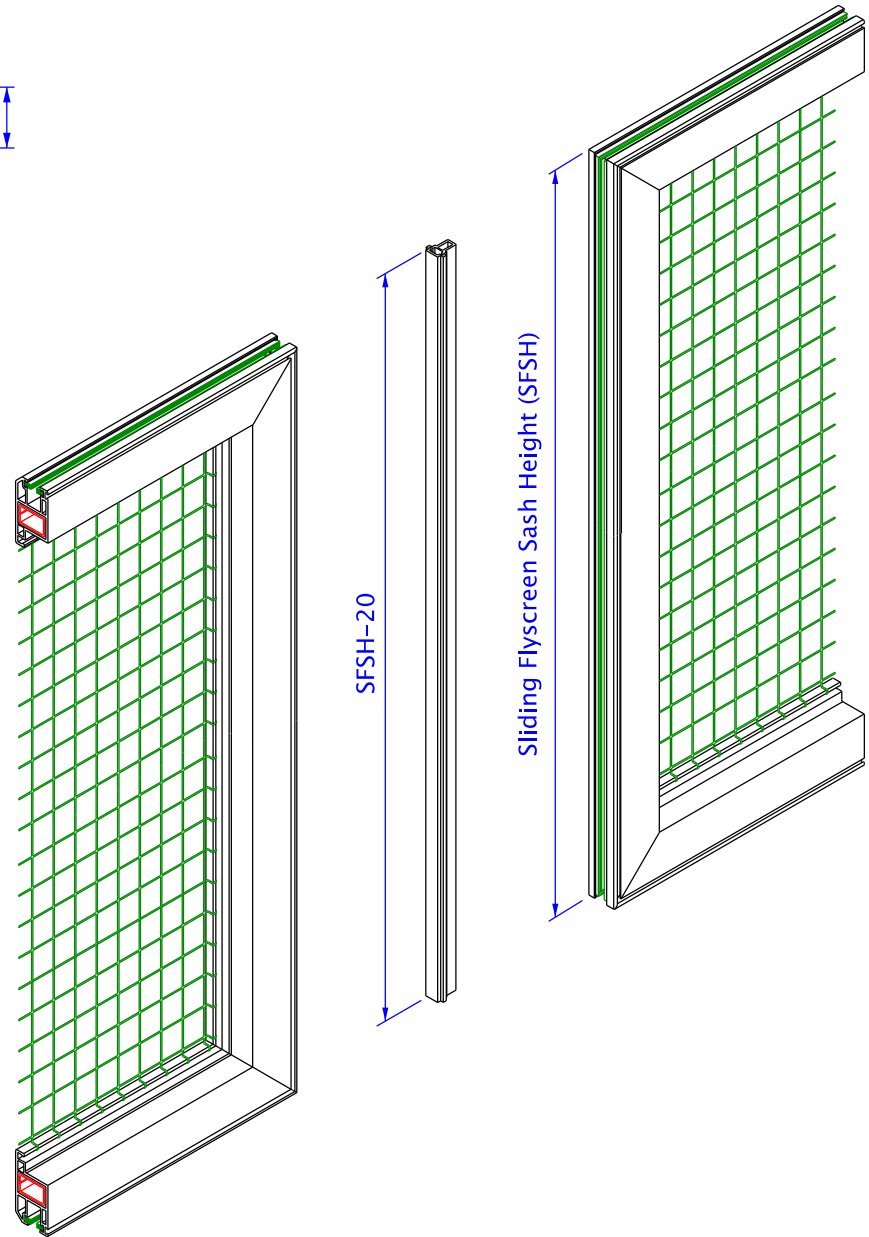
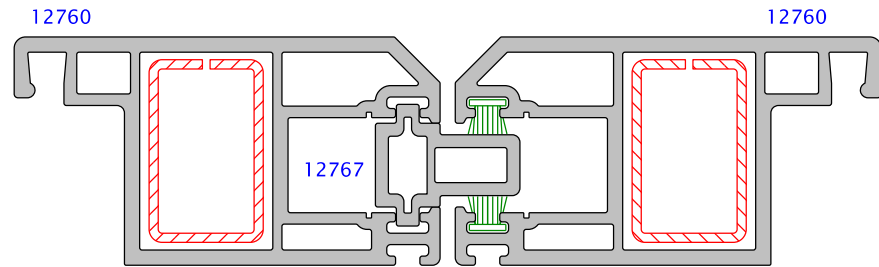
SLIDING FRAME (12660/12665)

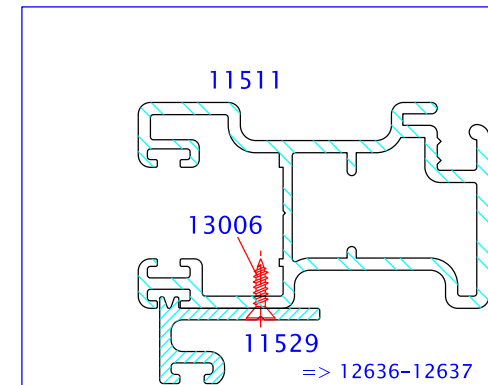
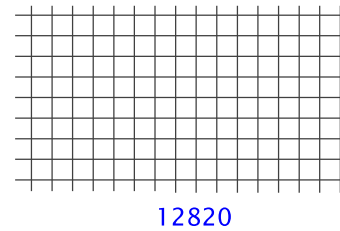
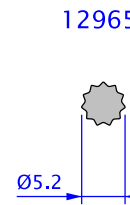
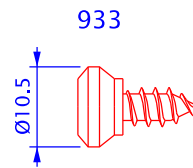
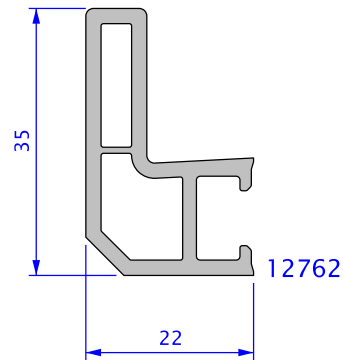
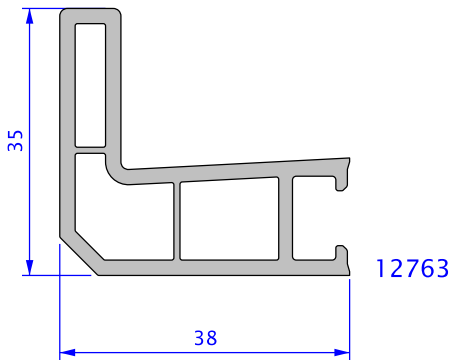
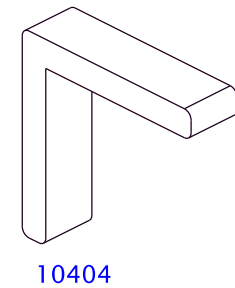
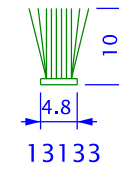
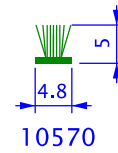
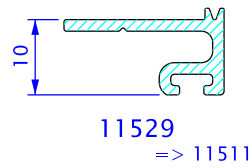
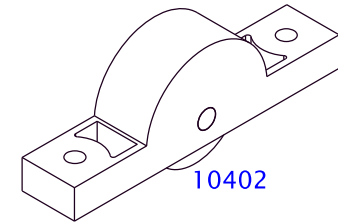
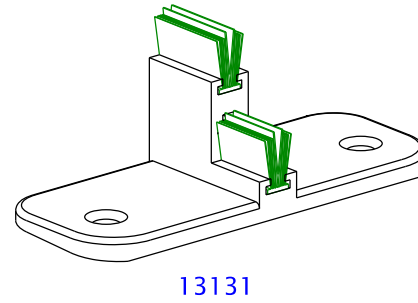
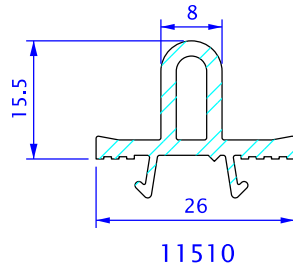
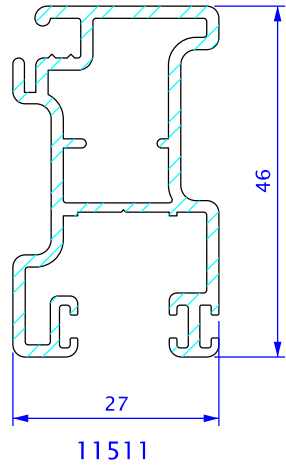
Flyscreen wedge must be used on the window where it has been shown below with circle.





12767



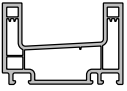

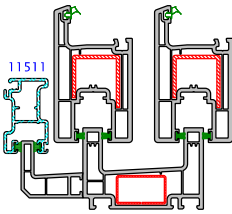
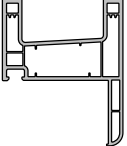

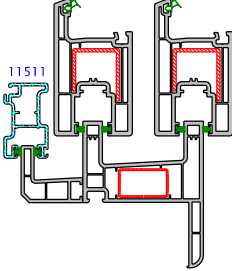
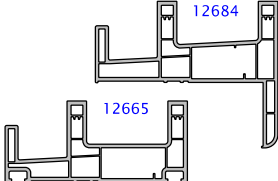

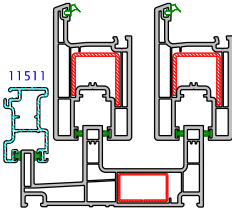
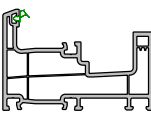

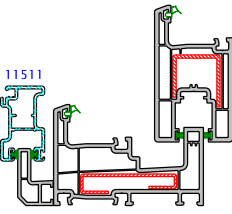
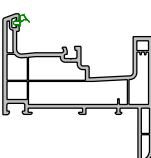

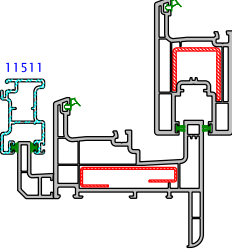
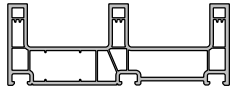

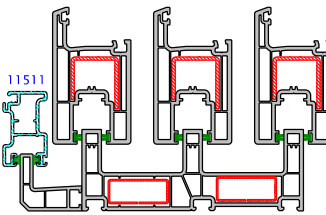
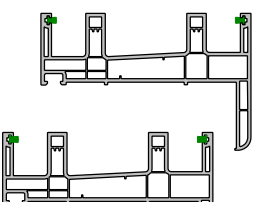

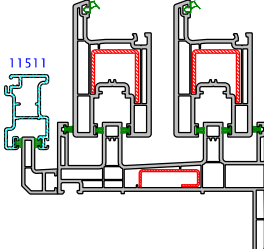


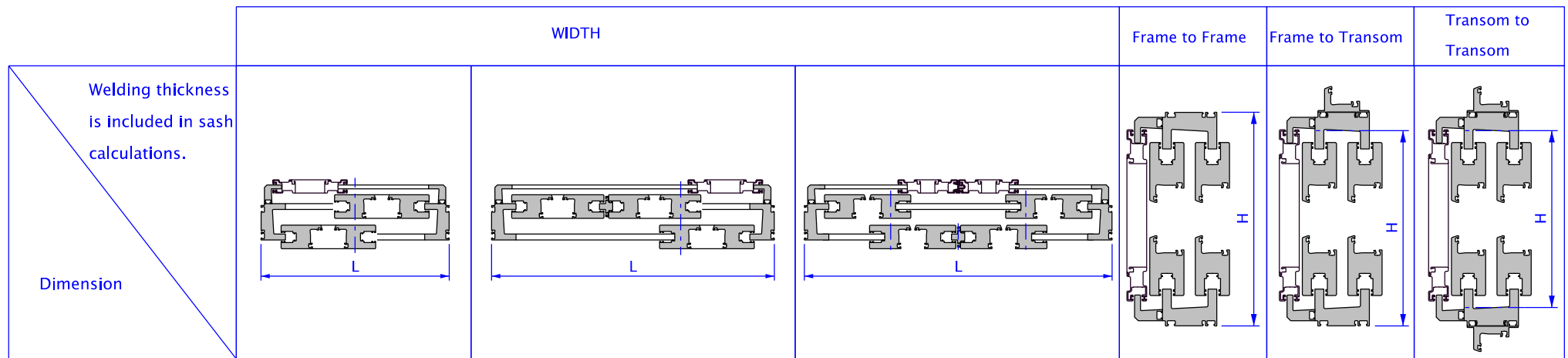
Sliding flyscreen rails should be chosen according to the sliding frame.

There are 2 types of sliding flyscreen rails :

* Sliding flyscreen 22 mm

* Sliding flyscreen 38 mm

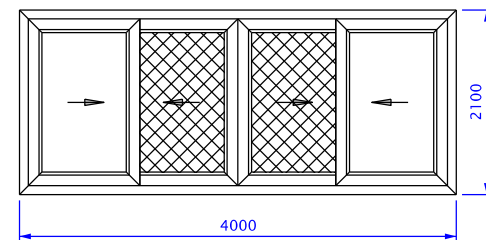
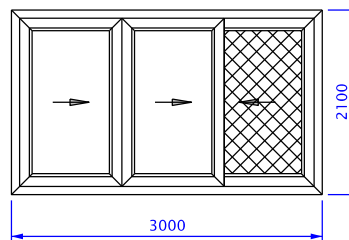
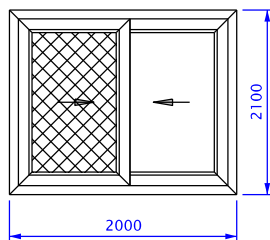
PVC	Flyscreen Rail	Application
12660 	12763 	
12662 	12763 	
12684 12665 	Sineklik rayı profil üzerinde bulunmaktadır. 	
12661 	12762 	12660 
12663 	12762 	12660 
	12763 	
	12762 	



	Frame to Frame	Frame to Transom	Transom to Transom
12763 Flyscreen Rail 38mm	H - 8	H + 17	H + 42

L : Frame Width
H : Height

	L / 2 - 33	L / 3 - 33	L / 4 - 29	Height	Height	Height
11511 Aluminium sliding flyscreen	H - 68	H - 43	H - 18	Height	Height	Height



EXAMPLE :

Sliding Frame (12660)

Flyscreen Rail 38 mm (12763)
Width : 2000-8=1992 mm
Height : 2100-8=2092 mm

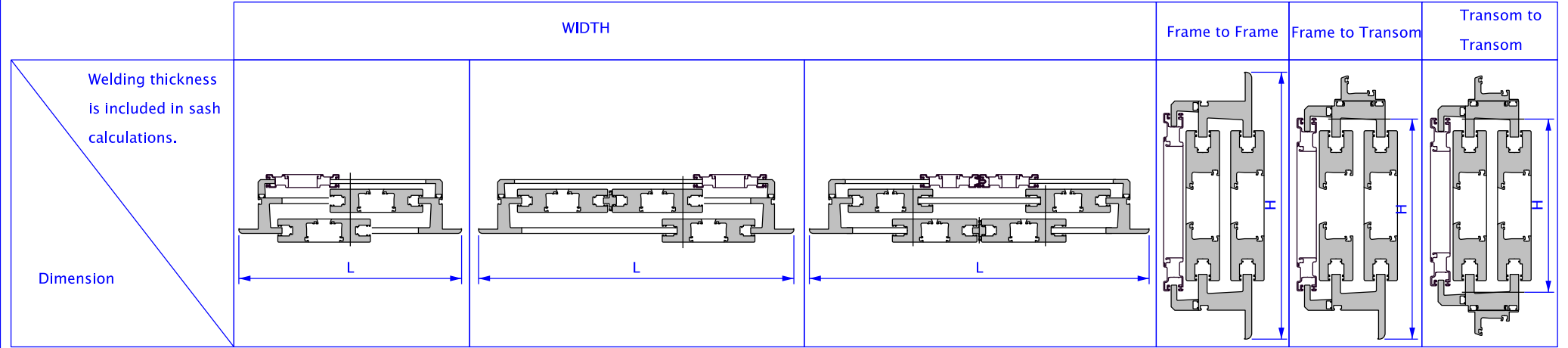
Aluminium sliding flyscreen sash (11511)
Width : 2000 / 2=1000 mm
Height : 1000-33=967 mm

Flyscreen Rail 38 mm (12763)
Width : 3000-8=2992 mm
Height : 2100-8=2092 mm

Aluminium sliding flyscreen sash (11511)
Width : 3000 / 3=1000 mm
Height : 1000-33=967 mm

Flyscreen Rail 38 mm (12763)
Width : 4000-8=3992 mm
Height : 2100-8=2092 mm

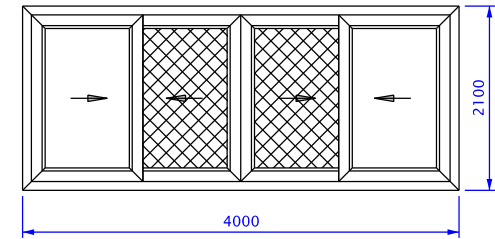
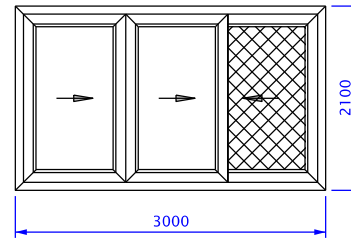
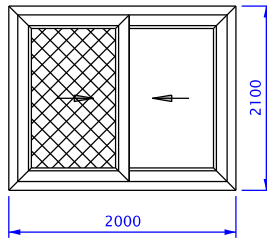
Aluminium sliding flyscreen sash (11511)
Width : 4000 / 4=1000 mm
Height : 1000-29=971 mm



				Width and Height	Width and Height	Width and Height
12763 Flyscreen Rail 38mm				H - 74	H - 16	H + 42

L : Frame Width
H : Height

				Height	Height	Height
11511 Aluminium sliding flyscreen	- 66	- 66	- 49	H - 134	H - 76	H - 18



EXAMPLE :

Sliding Archtrave Frame (12662)

Flyscreen Rail 38 mm (12763)

Width : $2000 - 74 = 1926$ mm

Height : $2100 - 74 = 2026$ mm

Aluminium sliding flyscreen sash (11511)

Width : $2000 / 2 = 1000$ mm

Height : $1000 - 66 = 934$ mm

Flyscreen Rail 38 mm (12763)

Width : $3000 - 74 = 2926$ mm

Height : $2100 - 74 = 2026$ mm

Aluminium sliding flyscreen sash (11511)

Width : $3000 / 3 = 1000$ mm

Height : $1000 - 66 = 934$ mm

Flyscreen Rail 38 mm (12763)

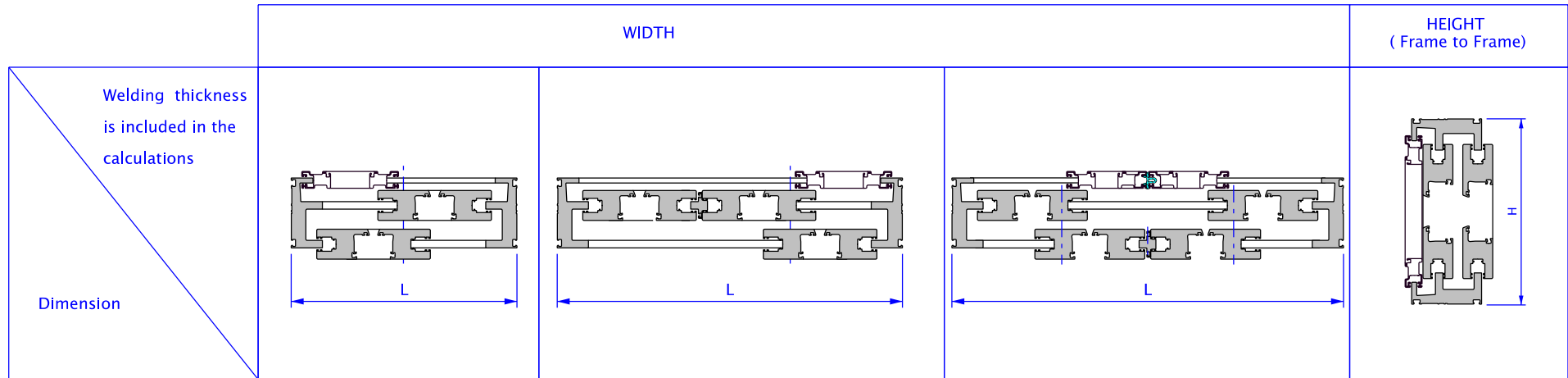
Width : $4000 - 74 = 3926$ mm

Height : $2100 - 74 = 2026$ mm

Aluminium sliding flyscreen sash (11511)

Width : $4000 / 4 = 1000$ mm

Height : $1000 - 49 = 951$ mm



L : Frame Width
H : Height

	WIDTH			HEIGHT (Frame to Frame)
	L / 2 - 26	L / 3 - 26	L / 4 - 29	L - 54

11511 Aluminium sliding flyscreen

L / 2 - 26

L / 3 - 26

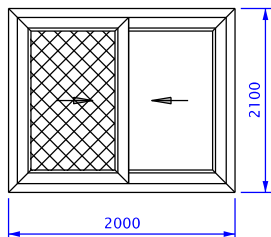
L / 4 - 29

Height

L - 54

EXAMPLE :

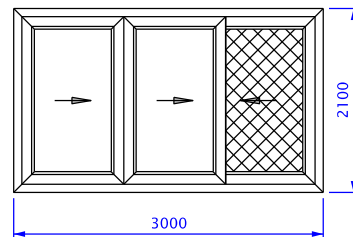
Sliding Frame with Flyscreen (12665)



Aluminium sliding flyscreen sash (11511)

Width : 2000 / 2=1000 mm

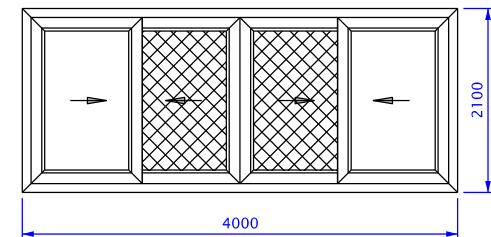
Height : 1000-26=974 mm



Aluminium sliding flyscreen sash (11511)

Width : 3000 / 3=1000 mm

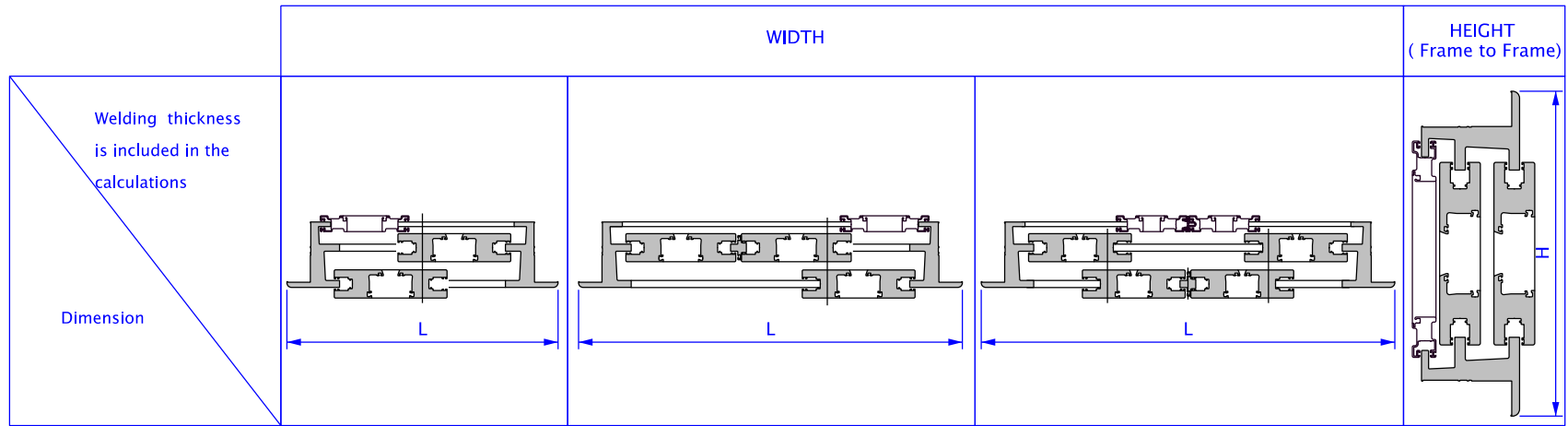
Height : 1000-26=974 mm



Aluminium sliding flyscreen sash (11511)

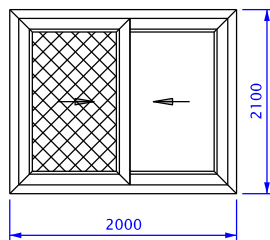
Width : 4000 / 4=1000 mm

Height : 1000-29=971 mm



L : Frame Width
H : Height

				Height
11511 Aluminium sliding flyscreen	- 66	- 66	- 49	H - 134



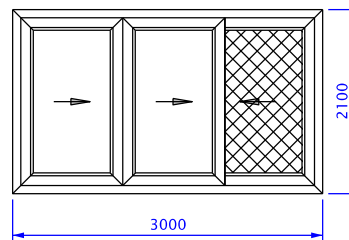
EXAMPLE :

Sliding Arc. Frame with Flyscreen (12684)

Aluminium sliding flyscreen sash (11511)

Width : 2000 / 2=1000 mm

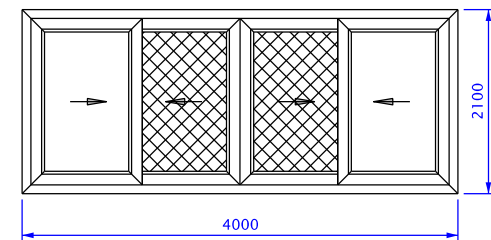
Height : 1000-66=934 mm



Aluminium sliding flyscreen sash (11511)

Width : 3000 / 3=1000 mm

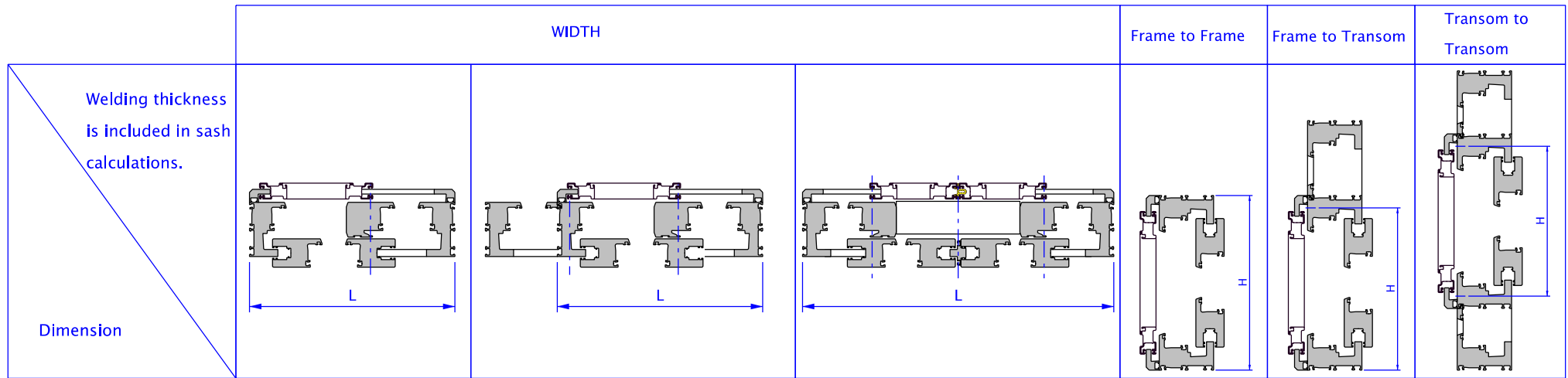
Height : 1000-66=934 mm



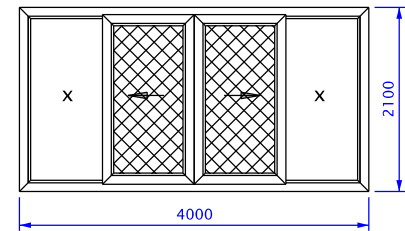
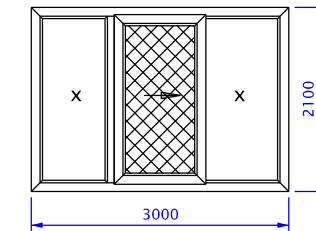
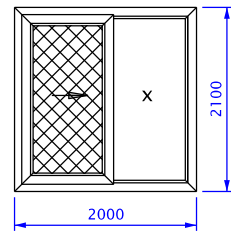
Aluminium sliding flyscreen sash (11511)

Width : 4000 / 4=1000 mm

Height : 1000-49=951 mm



Dimension	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
	$L + 6$	$\frac{L}{3} \times 2 + 6$	$L + 6$	Width and Height	Width and Height	Width and Height
L : Frame Width H : Height				Width and Height	Width and Height	Width and Height
12762 Flyscreen Rail 22 mm	$L + 6$	$\frac{L}{3} \times 2 + 6$	$L + 6$	H + 6	H + 27	H + 48
11511 Aluminium sliding flyscreen	-13	-10	$\frac{L}{4} - 22$	Height	Height	Height
				H - 54	H - 33	H - 12



EXAMPLE :
Sliding Fixed Frame (12661)

Flyscreen Rail 38 mm (12763)
Width : $2000 + 6 = 2006$ mm
Height: $2100 + 6 = 2106$ mm

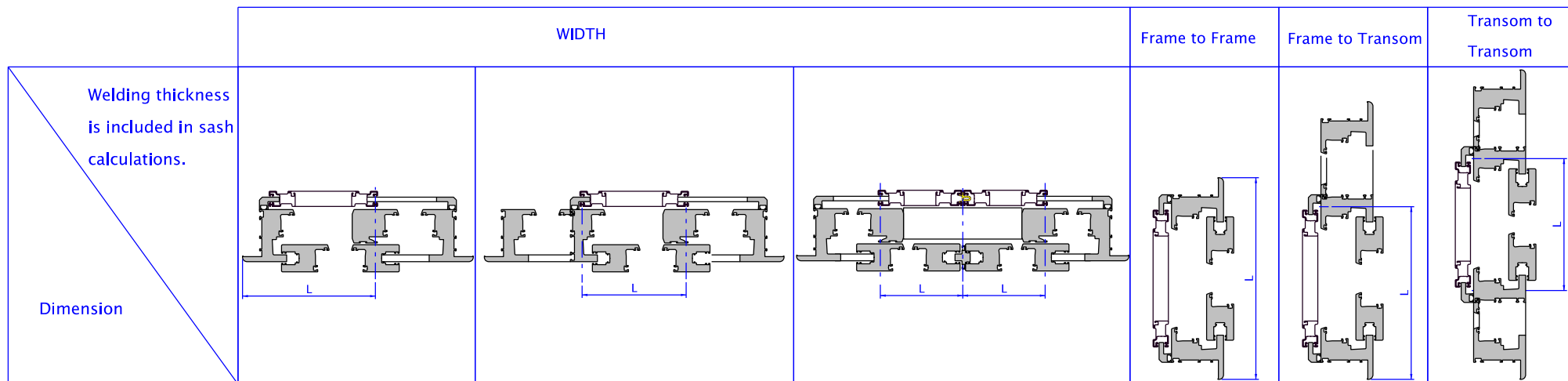
Aluminium sliding flyscreen sash (11511)
Width : $2000 / 2 = 1000$ mm
Height : $1000 - 13 = 987$ mm

Flyscreen Rail 38 mm (12763)
Width : $3000 / 3 = 1000$ mm
 $1000 \times 2 = 2000$ mm
 $2000 + 6 = 2006$ mm

Height : $2100 + 6 = 2106$ mm
Aluminium sliding flyscreen sash (11511)
Width : $3000 / 3 = 1000$ mm
Height : $1000 - 10 = 990$ mm

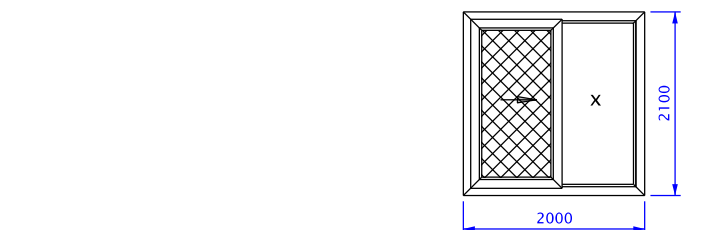
Flyscreen Rail 38 mm (12763)
Width : $4000 + 6 = 4006$ mm
Height : $2100 + 6 = 2106$ mm

Aluminium sliding flyscreen sash (11511)
Width : $4000 / 4 = 1000$ mm
Height : $1000 - 22 = 978$ mm



L : Frame Width
H : Height

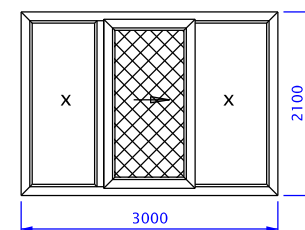
	WIDTH	Frame to Frame	Frame to Transom	Transom to Transom
12762 Flyscreen Rail 22 mm	L - 54	$\frac{L}{3} \times 2 - 22$	L - 54	L + 48
11511 Aluminium sliding flyscreen	-43	$\frac{L}{3} - 30$	$\frac{L}{4} - 37$	L + 48



EXAMPLE :
Fixed Sliding Architrave Frame (12663)

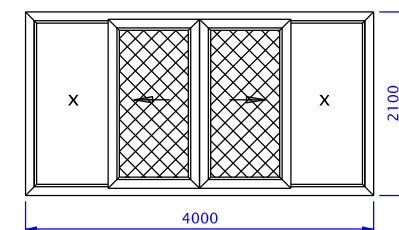
Flyscreen Rail 38 mm (12763)
Width : 2000-54=1946 mm
Height : 2100-54=2046 mm

Aluminium sliding flyscreen sash (11511)
Width : 2000 / 2=1000 mm
Height : 1000-43=957 mm



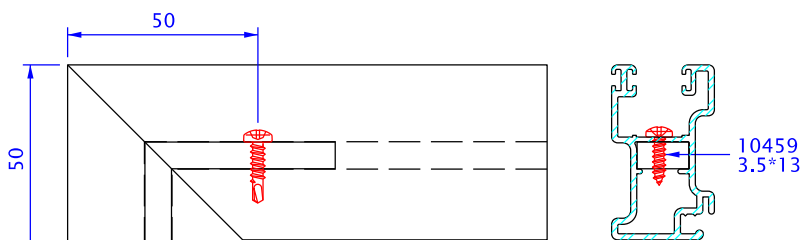
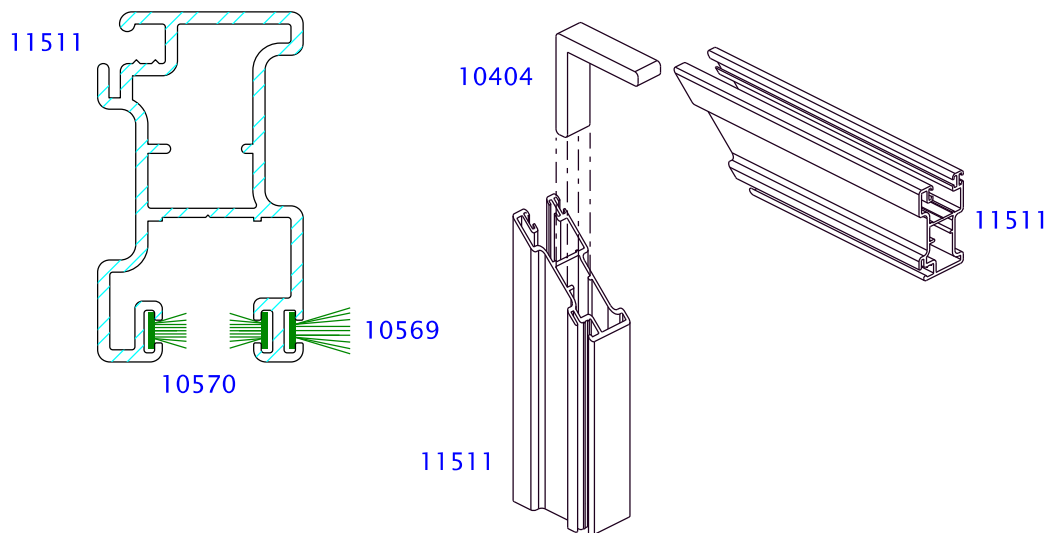
Flyscreen Rail 38 mm (12763)
Width : 3000 / 3 = 1000 mm
1000 x 2 = 2000 mm
2000 - 22 = 1978 mm

Height : 2100 - 54 = 2046 mm
Aluminium sliding flyscreen sash (11511)
Width : 3000 / 3=1000 mm
Height : 1000 - 30 = 970 mm

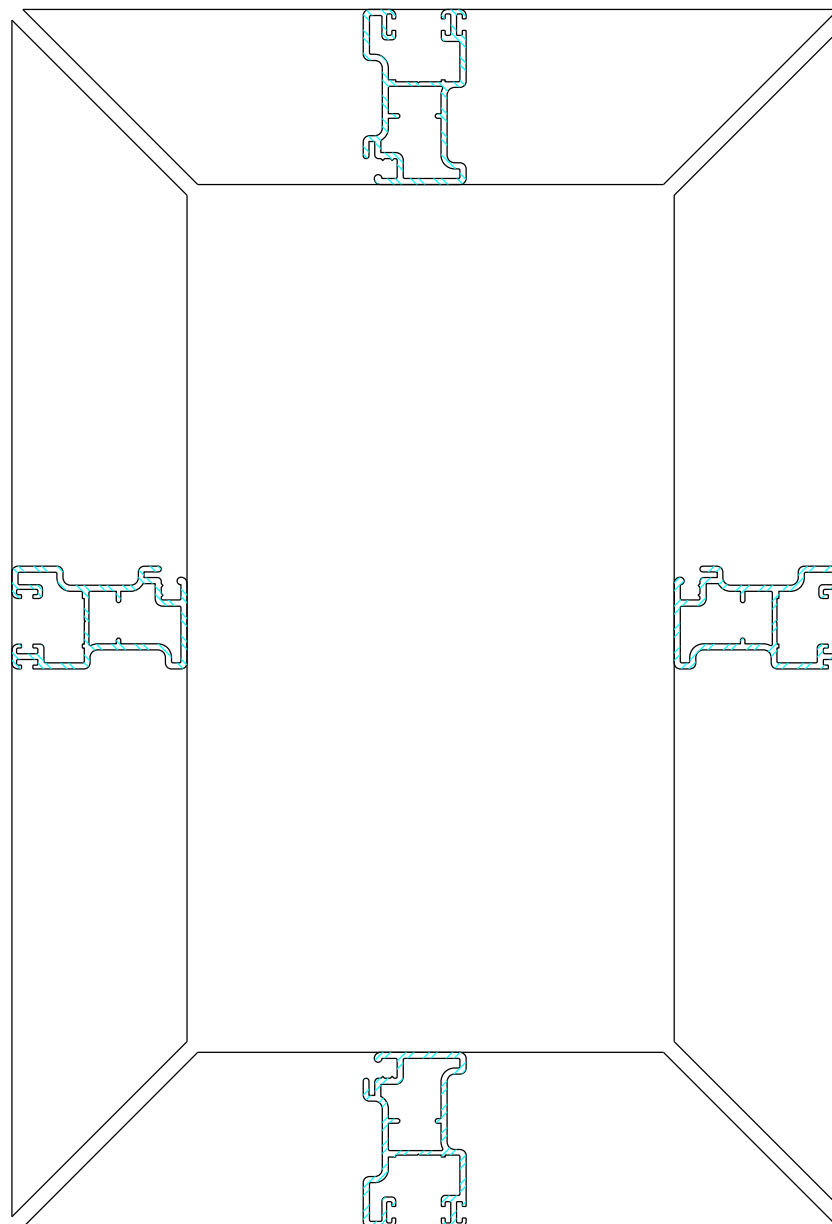


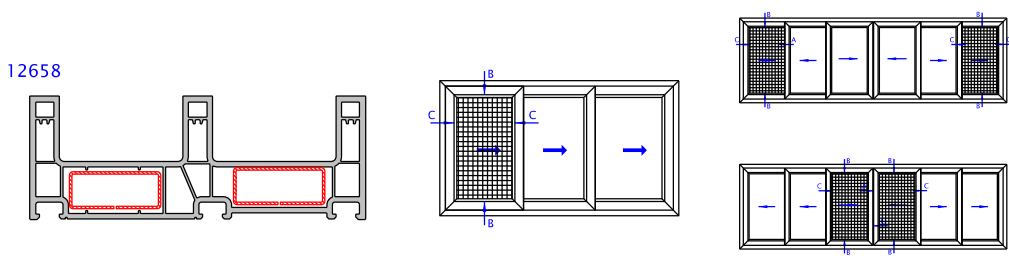
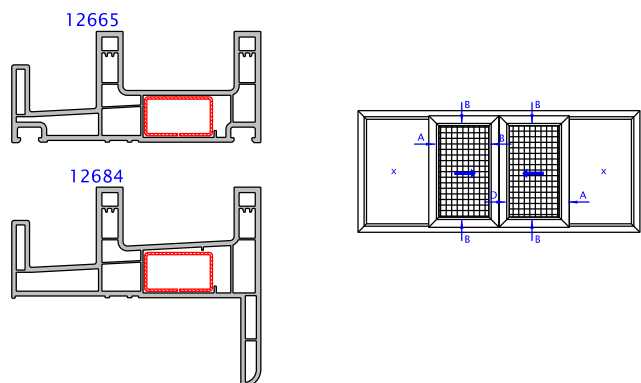
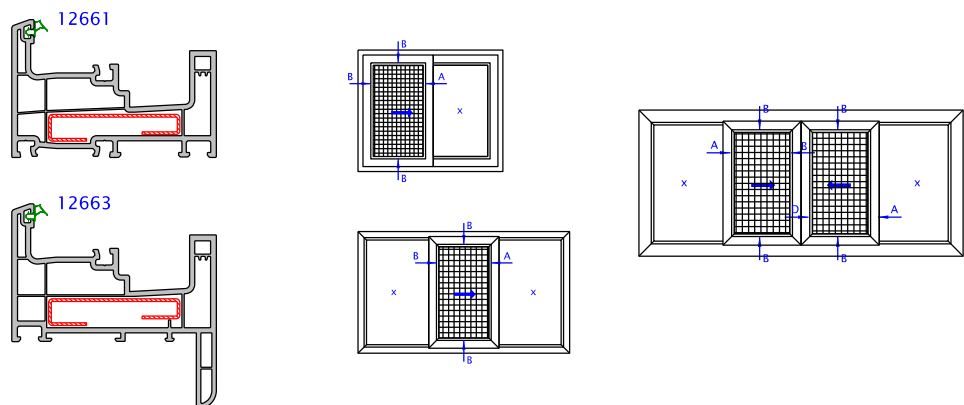
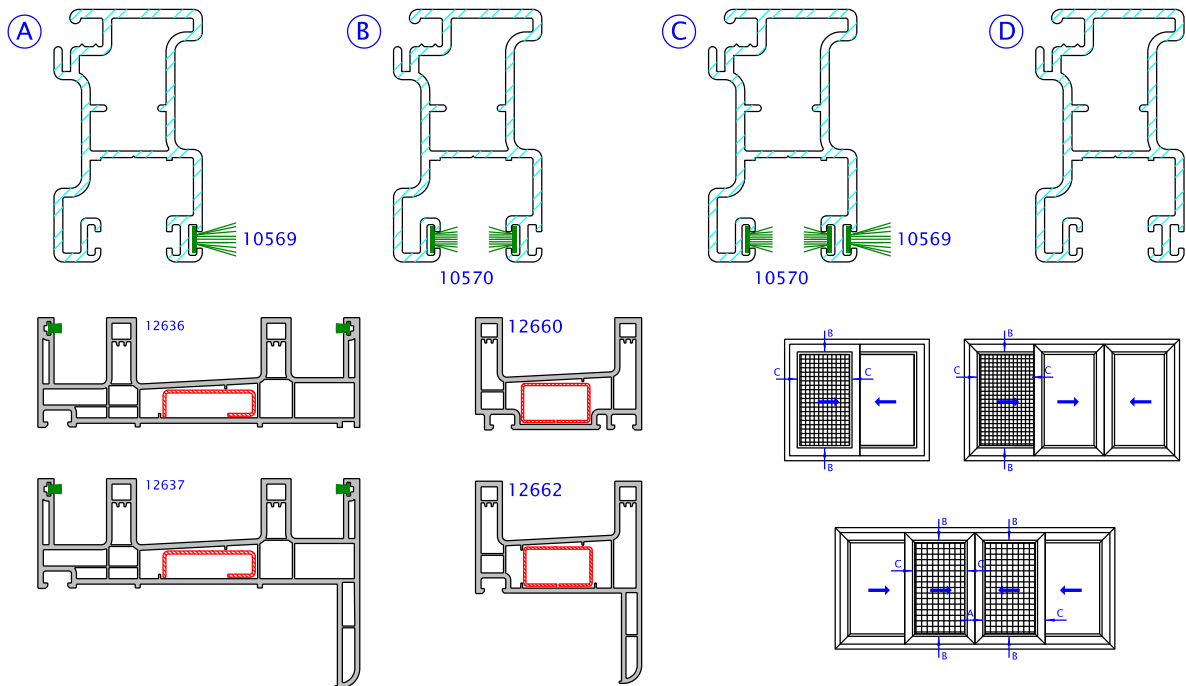
Flyscreen Rail 38 mm (12763)
Width : 4000-54=3946 mm
Height : 2100-54=2046 mm

Aluminium sliding flyscreen sash (11511)
Width : 4000 / 4=1000 mm
Height : 1000-37=963 mm

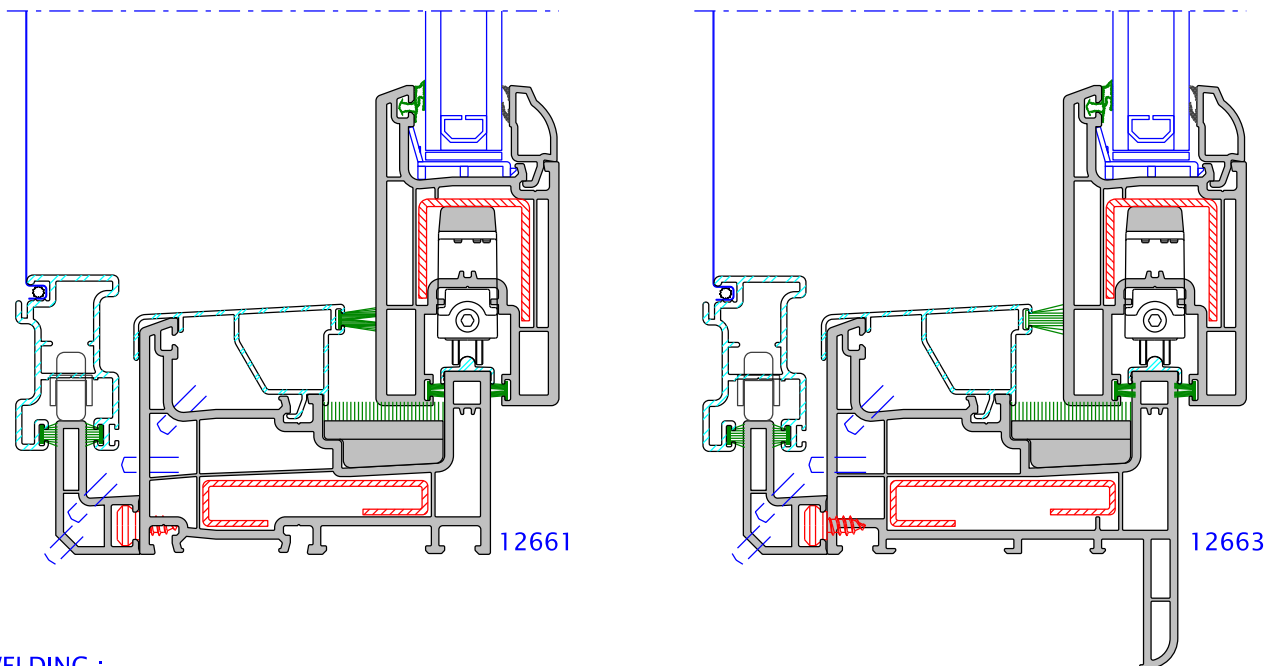
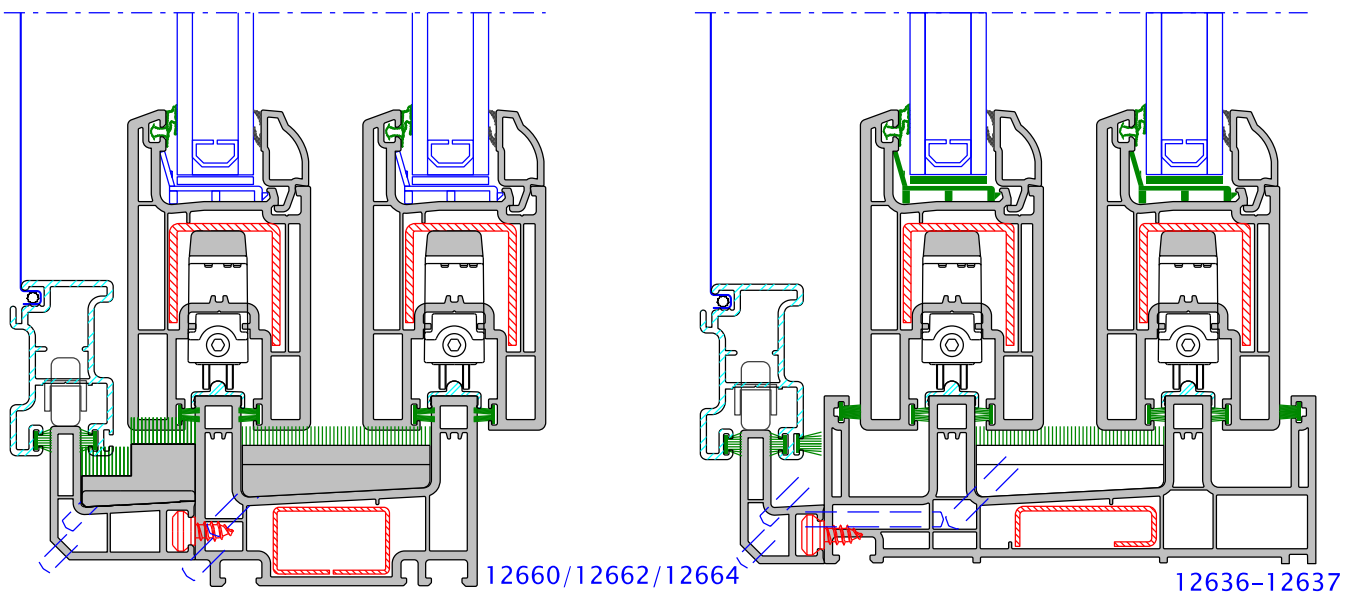


- * Before connection of corners for sash, brushes should be inserted
- * If the height of flyscreen is higher than 1300 mm , it is advised to use aluminium sash.
- * Drilling of connection pieces with $\text{Ø}3$ mm point is advised before screwing.



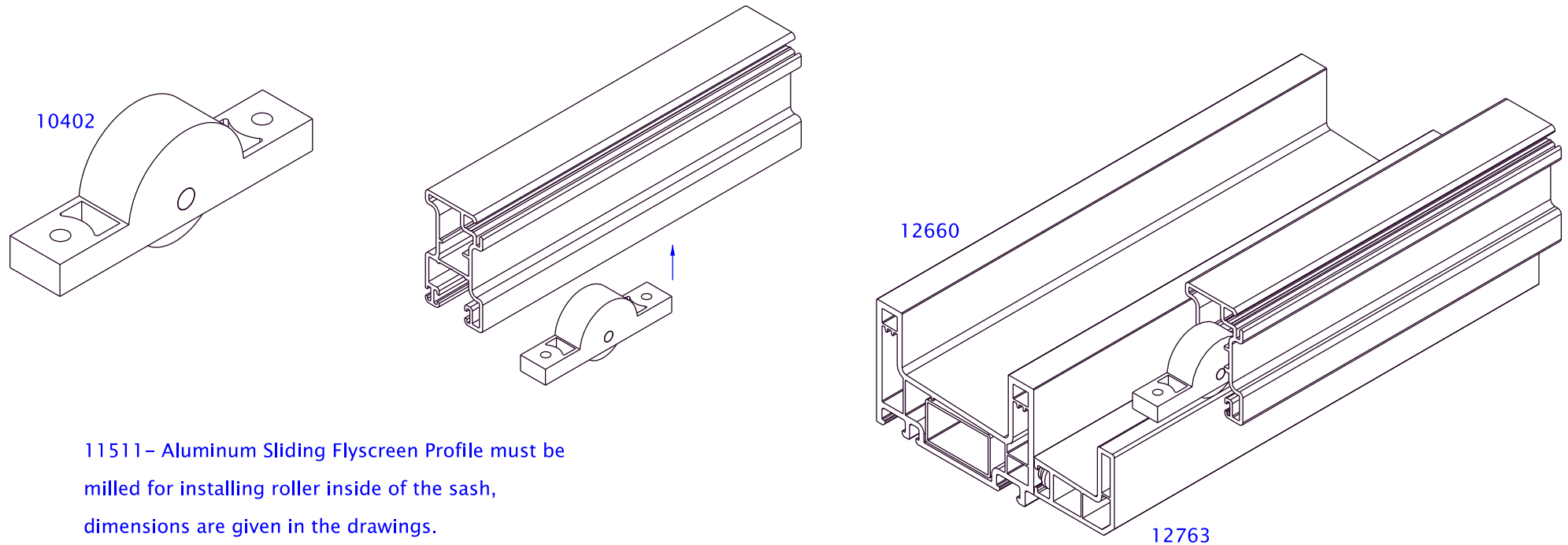


In the case of sliding frames (12660,12662,12664,12661 and 12663) since it is not possible to install drainage caps , water slots should be drilled also on flyscreen rails.The numbers of water discharge slots for flyscreen rails should be equal to sliding frame.Please find the application on the drawing below.



WELDING :

- * Flyscreen rails are welded and corner cleanings are done.
- * Brushes which are used inside of flyscreen sash, are inserted before welding.
- * After corner cleaning process, the brush that has the dimension as 48x1000 is inserted on outside of flyscreen sash according to the detail.

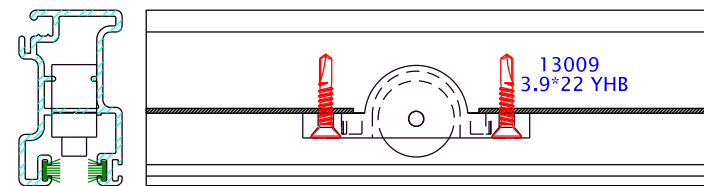


11511- Aluminum Sliding Flyscreen Profile must be milled for installing roller inside of the sash, dimensions are given in the drawings.

* 10402 Sliding flyscreen sash roller must be installed in the espagnolette groove's milled side according to figure which is given in the drawings,

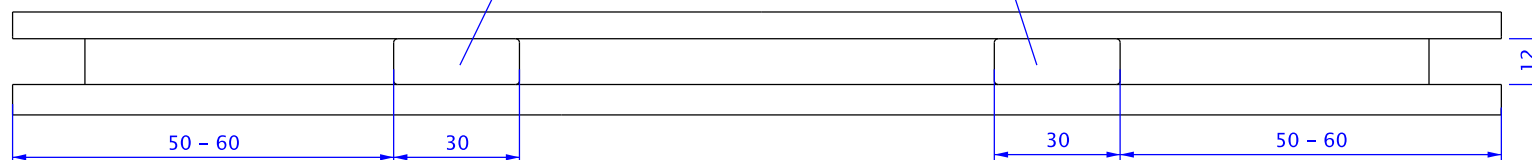
11166 => must be fixed with 10456 4.0x22 screw ,

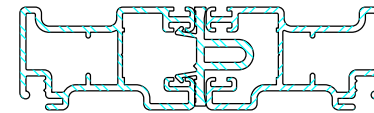
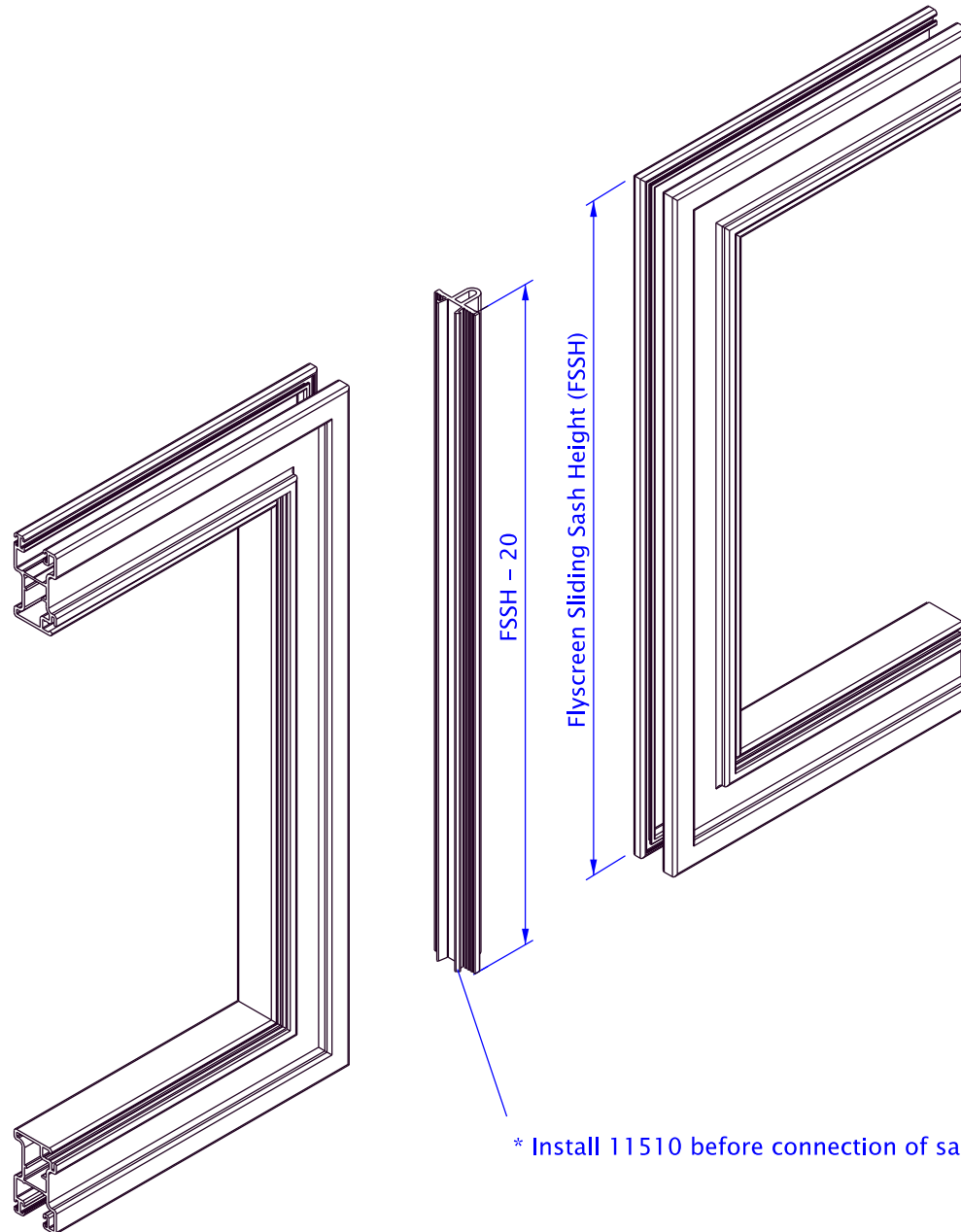
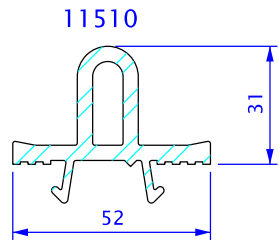
11511 => must be fixed 13009 3.9x22 screw.



11511

Freeze this part to insert flyscreen rollers on sash





* Install 11510 before connection of sash profiles