



GlobAlum
Globaly Aluminum Passion



CASEMENT SYSTEM SERIES GC62

System U-Value

01-03

Profiles

04-27

Sections

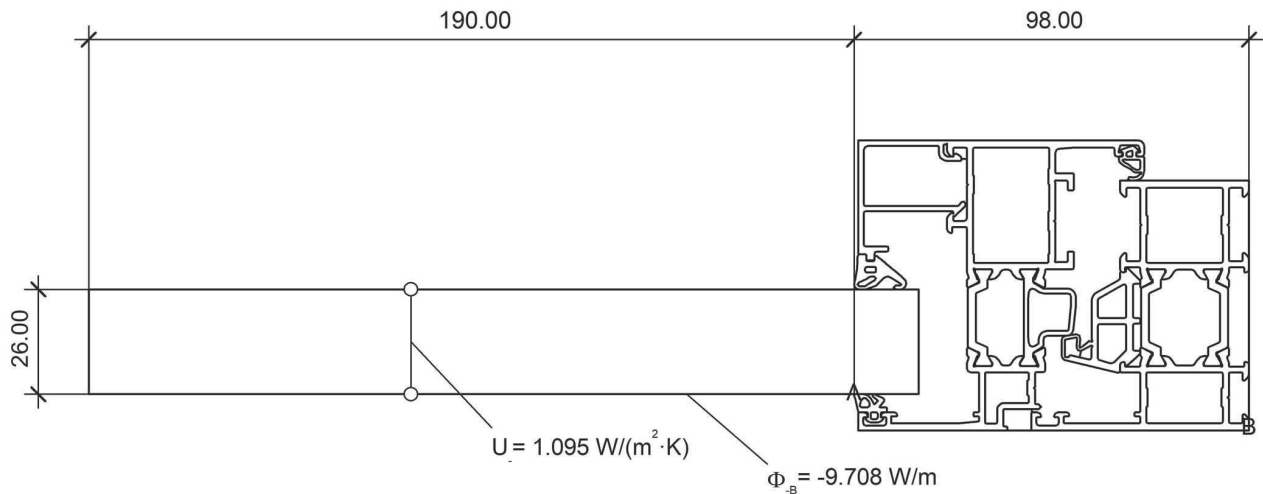
28-61

Work Drawings

62-86

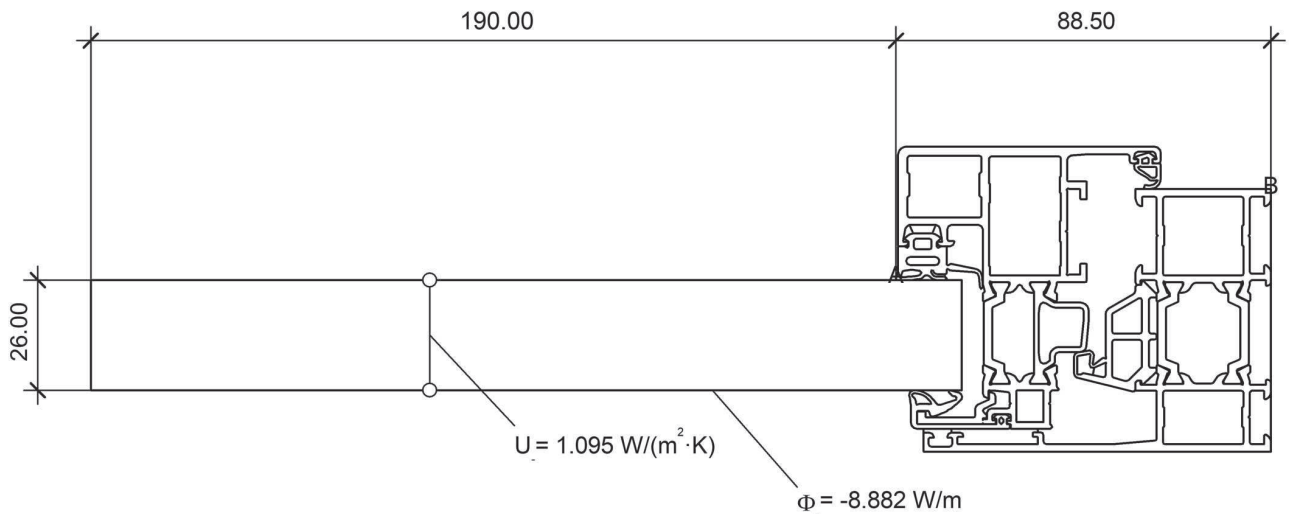
Glazing Table

87-90



$$U_{fA,B} = \frac{\frac{\Phi}{\Delta T} - U_p \cdot b_p}{b_f} = \frac{\frac{9.708}{20.000} - 1.095 \cdot 0.190}{0.098} = 2.83 \text{ W/(m}^2 \cdot \text{K)}$$

STANDARD VERSION



$$U_{fA,B} = \frac{\frac{\Phi}{\Delta T} - U_p \cdot b_p}{b_f} = \frac{\frac{8.882}{20.000} - 1.095 \cdot 0.190}{0.089} = 2.67 \text{ W/(m}^2 \cdot \text{K)}$$

HIDDEN VENT VERSION

Thermal Transmittance Calculation

EN ISO 10077-1:2008

The thermal transmittance of a single window, U_w , shall be calculated using Equation:

$$U_w = \frac{\sum U_g \cdot A_g + \sum U_f \cdot A_f + \sum \psi_g \cdot \Psi_g}{\sum A_g + \sum A_f}$$

Where

U_g = Thermal transmittance of the glazing;

U_f = Thermal transmittance of the frame;

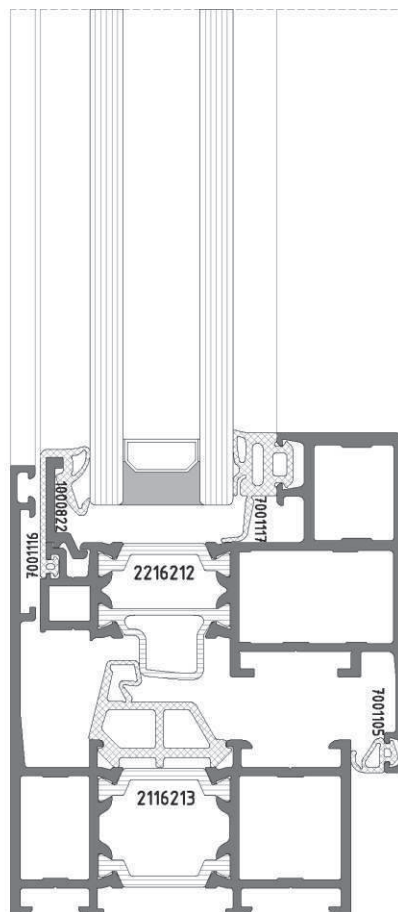
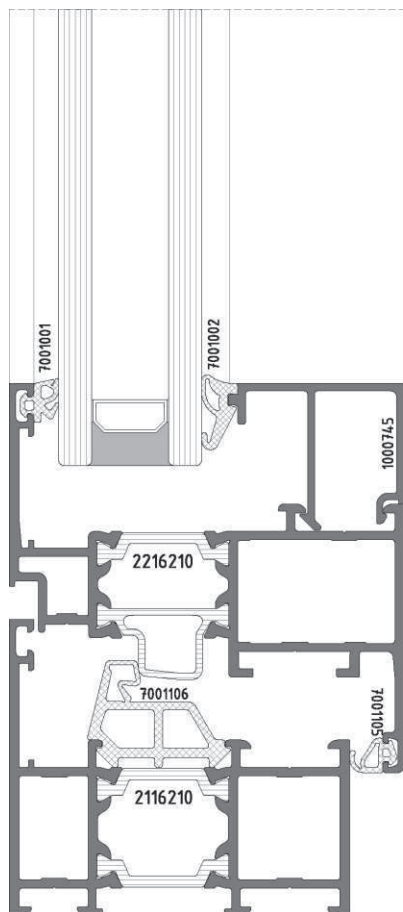
Ψ_g = Linear thermal transmittance due to the combined thermal effects of glazing, spacer and frame;

Values of linear thermal transmittance for common types of glazing spacer bars (e.g. aluminum or steel)

Frame Type	Linear thermal transmittance for different types of glazing Ψ_g	
	Double or triple glazing uncoated glass air -or gas -field	Double ^A or triple ^B glazing low-emissivity glass air -or gas -field
Wood or PVC	0,06	0,08
Metal with thermal break	0,08	0,11
Metal without thermal break	0,02	0,05
A: One pane coated for double glazed. B: Two panes coated for triple glazed.		

Values of linear thermal transmittance for common types of glazing spacer bars With improved thermal performance

Frame Type	Linear thermal transmittance for different types of glazing With improved thermal performance Ψ_g	
	Double or triple glazing uncoated glass air -or gas -field	Double ^A or triple ^B glazing low-emissivity glass air -or gas -field
Wood or PVC	0,05	0,06
Metal with thermal break	0,06	0,08
Metal without thermal break	0,01	0,04
A: One pane coated for double glazed. B: Two panes coated for triple glazed.		



GC62 Window - Thermal Transmittance

EN ISO 10077-1:2008

Casement Window 1230 x 1480 mm.

Casement Window Combination	PSI Ψ_g	Glazing Ug									
		0.70	0.90	1.10	1.30	1.50	1.70	1.90	2.10	2.30	2.50
2116210 Frame 2216210 Sash	0.06	1.40	1.55	1.70	1.85	1.99	2.14	2.29	2.44	2.59	2.74
	0.08	1.45	1.60	1.75	1.90	2.04	2.19	2.34	2.49	2.64	2.79
	0.11	1.53	1.68	1.82	1.97	2.12	2.27	2.42	2.57	2.71	2.86
2116213 Frame 2216212 Sash	0.06	1.29	1.44	1.59	1.74	1.89	2.04	2.19	2.34	2.49	2.64
	0.08	1.34	1.49	1.64	1.79	1.94	2.09	2.24	2.39	2.54	2.69
	0.11	1.42	1.57	1.72	1.87	2.02	2.17	2.32	2.47	2.62	2.77

PROFILES :

Number	Shape	DESCRIPTION	Corner Nail / Crimp	Corner Alignment	T.Connector
2116210		Frame profile 54/32	5767182 5767122	7501020	—
2116211		Frame profile 64/42	5195182 5195122	7501020	—
2116212		Frame profile 77/55	5236182 5236122	7501020	—
2116213		HV Frame profile 82/32	5767182 5767122	7501020	—
2216210		Sash profile 37/49	5767282 5766072	7501011	—
2216211		Sash profile 47/59	5195282 5732072	7501011	—
2216212		HV Sash profile 16/62	5301141 5301277 5487071	—	—
2316210		Sash profile 68/80	5260282 5236072	7501011	—
2316211		Sash profile 102/46	5790072 5790252	7501011	—
2416210		Mullion/Transom 76/32	—	—	5824180 5823180
2416211		Mullion/Transom 86/42	—	—	5824280 5823280
2416212		Mullion/Transom 99/55	—	—	5824410 5823410
2416213		HV Mullion/Transom 132/32	—	—	5824180 5823180
2416214		HV Mullion/Transom 104/32	—	—	5824180 5823180

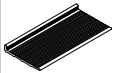
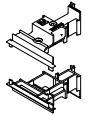
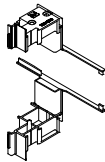
PROFILES :

Number	Shape	DESCRIPTION	Corner Nail / Crimp	Corner Alignment	T.Connector
2416215		Sash Mullion/Transom 76/32	—	—	5824180 5823180
2416216		Sash Mullion/Transom 99/55	—	—	5824410 5823410
2616210		Meeting profile	—	—	—
2616211		HV Meeting profile	—	—	—
2616212		Pivot sash adaptor	5196282	—	—
2616213		Outward adaptor Profile	5767130 5767122	—	—
2616214		Threshold profile	—	—	—
2616215		90 Degree Coupling	—	—	—
2616216		135 Degree Coupling	—	—	—
2616217		Round Coupling	—	—	—

PROFILES :

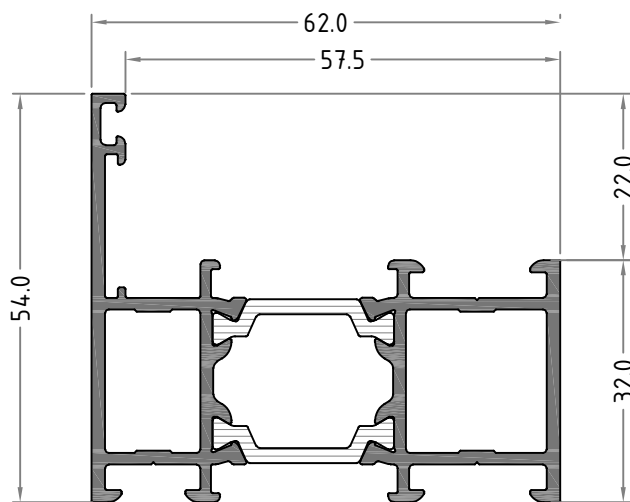
Number	Shape	DESCRIPTION
1000876		Curtain wall adaptor
1000771		Door adaptor profile
1000774		Threshold profile
1000773		Door adaptor profile
1000760		Round Coupling Adaptor
1000761		Round Coupling Adaptor
1000466		Glazing bead 4 mm
1000409		Glazing bead 12 mm
1000840		Glazing bead 16 mm
1000405		Glazing bead 20 mm
1000841		Glazing bead 24 mm
1000414		Glazing bead 28 mm
1000749		Glazing bead 32mm
1000467		Glazing bead 36 mm
1000750		Glazing bead 40mm
1000842		Glazing bead 44 mm
1000822		HV Sash Glazing bead
1000831		Glazing convertor
1000501		Add on Profile 28mm
1000488		Architrave Profile 55mm / 4.3
1000612		Architrave Profile 55mm / 9.3
1000200		Cover profile
1000456		Cover profile
1000582		Reinforce profile
1000626		Reinforce profile

Pieces :

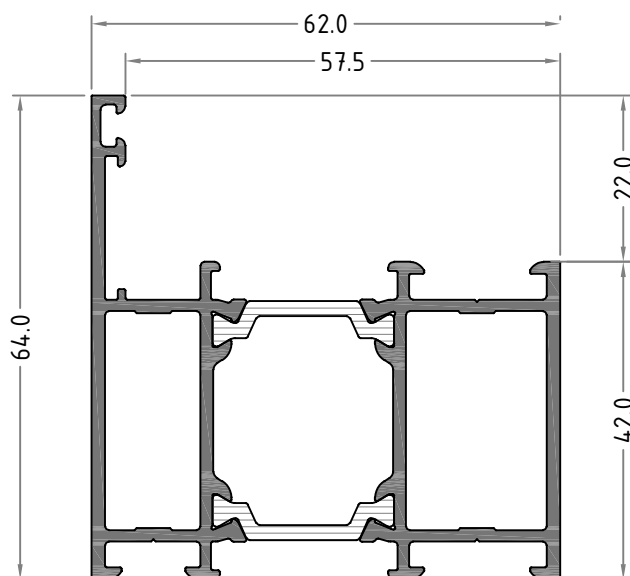
Number	Shape	DESCRIPTION	Quantity
5807100		HV Glazing support	8 per fixed Glazing Panel
5856100		HV Glazing support	2 per sash Glazing
7501062		1000582 End Cap	2 Pieces per 1000582
7501063		1000626 End Cap	2 Pieces per 1000626
7501070		1000771 End Cap	1 Pair per Door adaptor profile
7501071		1000773 End Cap	1 Pair per Door adaptor profile
7501076		2616210 End Cap	1 Pair per Meeting profile
7501079		2616211 End Cap	1 Pair per Meeting profile
7501098		Frame Mullion/Transom connection cap	2 per connection
7501099		Frame HV Mullion/Transom connection cap	2 per connection
7501100		Drain hole cover	1 per Drain hole
7501115		Low Threshold meeting bottom cap	1 per meeting profile
7801106		Corner Gasket . 7001106	4 Pieces per sash
7801010		2616214 End Cap	2 per opening

Gaskets :

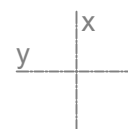
Number	Shape	DESCRIPTION
7001001		Outer glazing gasket
7001062		Inner glazing gasket 9-10mm.
7001002		Inner glazing gasket 7-8mm.
7001005		Inner glazing gasket 5-6mm.
7001034		Inner glazing gasket 3-4mm.
7001040		Stop gasket
7001105		Stop gasket
7001106		Central gasket
7001114		Cover Gasket
7001115		Weather seal gasket
7001051		Threshold gasket
7001116		Outer HV glazing gasket
7001044		Inner glazing gasket 4mm.
7001093		Inner glazing gasket 6mm.
7001117		Inner glazing gasket 8mm.
7001041		Inner glazing gasket 10mm.
7001017		Inner glazing gasket 12mm.
7001118		Inner glazing gasket 14mm.
7001119		Inner glazing gasket 16mm.



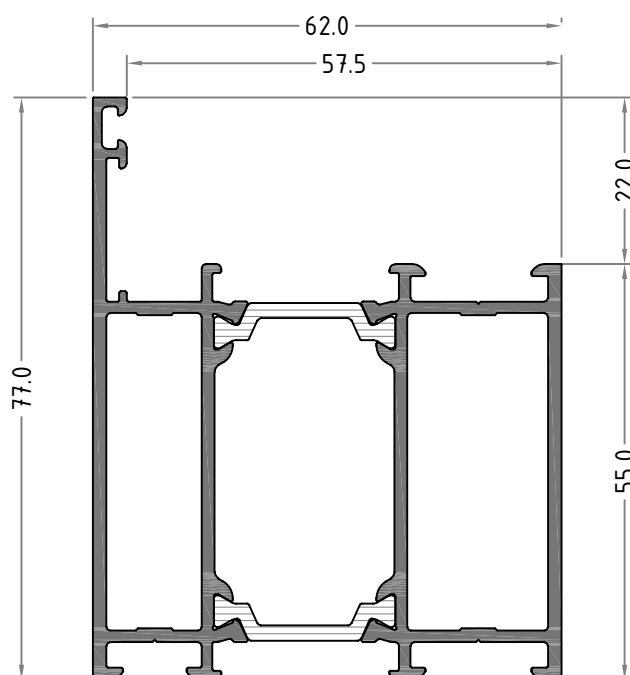
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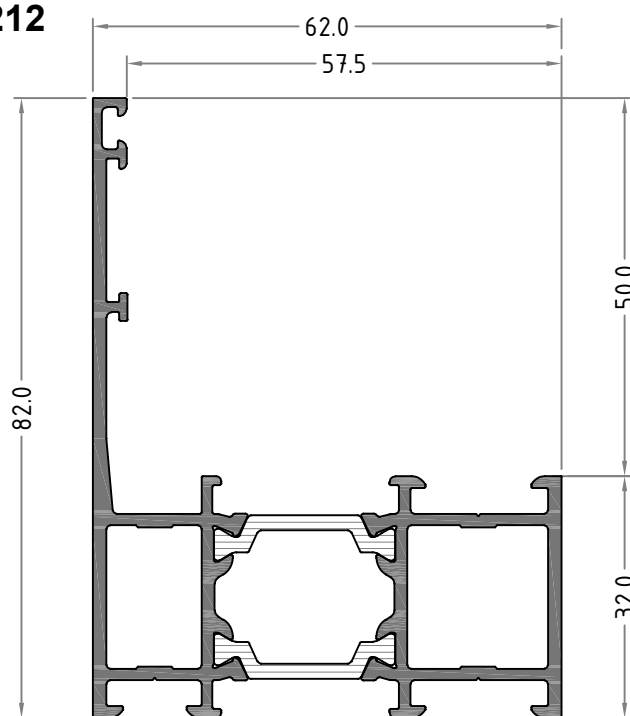
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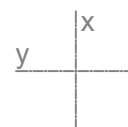
DESCRIPTION	Article Number	I_x eff. cm^4 $L = 3000 \text{ mm}$	$I_y \text{ cm}^4$	Technical information
Frame Profile 54/32	2116210	16.34	7.14	
Frame Profile 64/42	2116211	19.21	13.02	



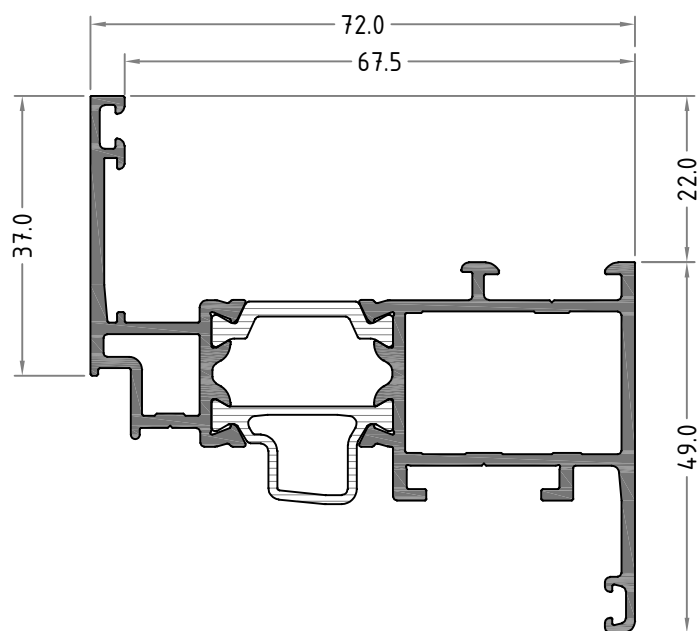
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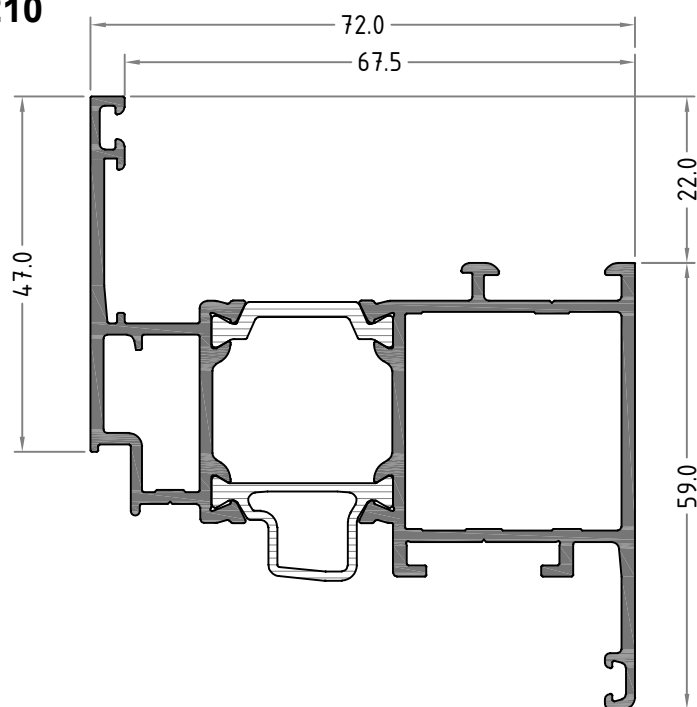
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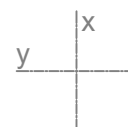
DESCRIPTION	Article Number	I_x eff. cm^4 $L = 3000 \text{ mm}$	I_y cm^4	Technical information
Frame Profile 77/55	2116212	22.92	24.54	
Frame Profile 82/32	2116213	18.91	19.74	



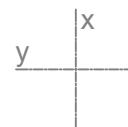
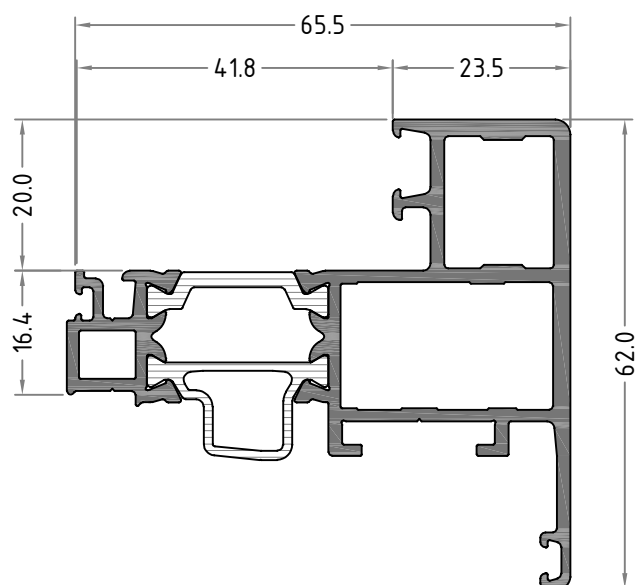
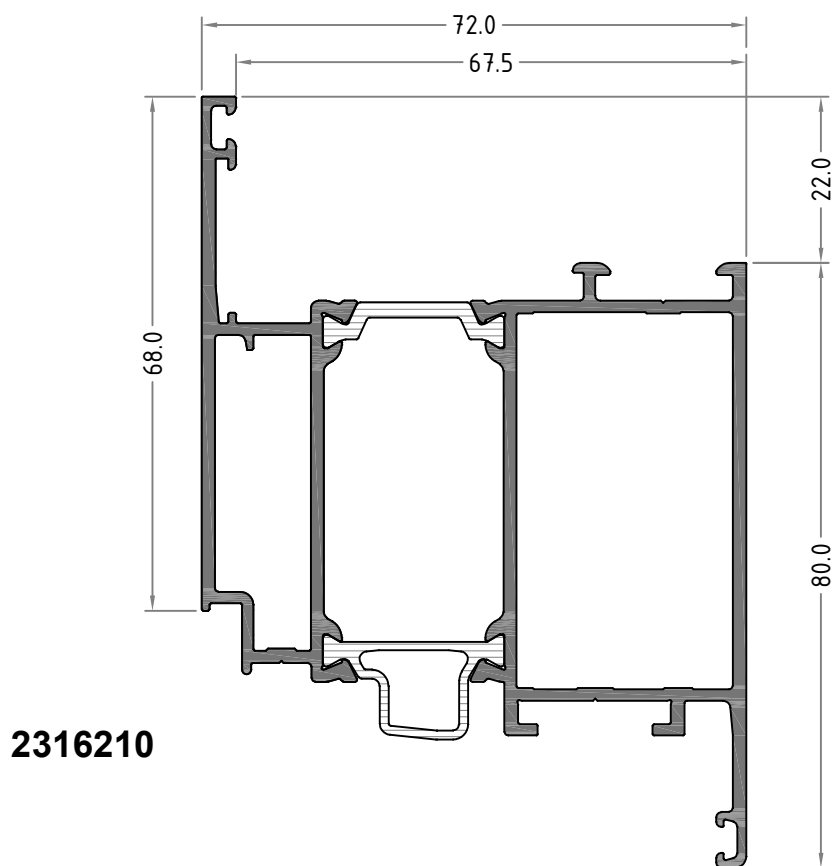
2216210



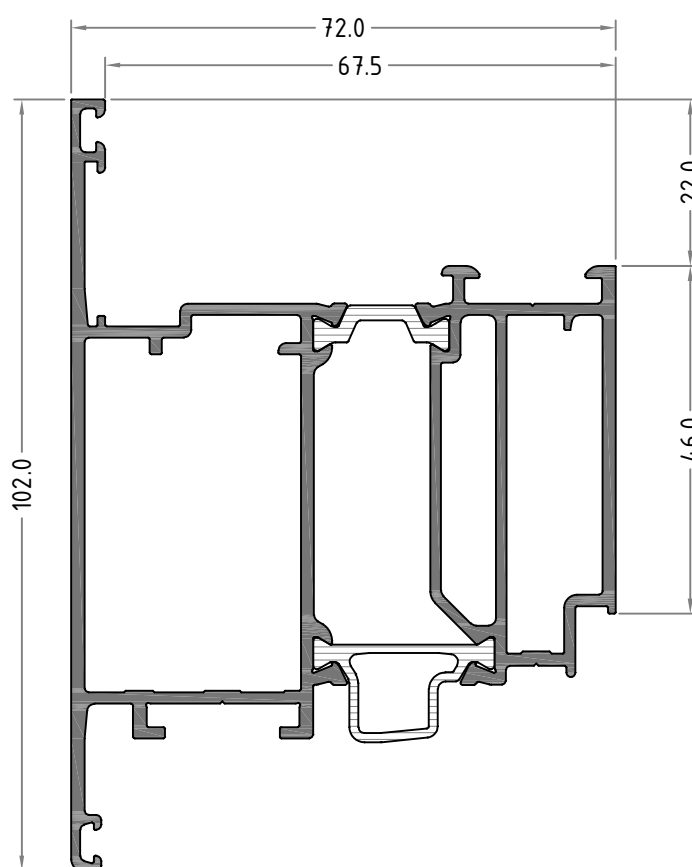
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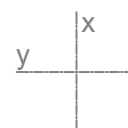
DESCRIPTION	Article Number	I_x eff. cm^4 $L = 3000 \text{ mm}$	$I_y \text{ cm}^4$	Technical information
Sash profile 37/49	2216210	24.44	8.52	
Sash profile 47/59	2216211	28.47	14.84	



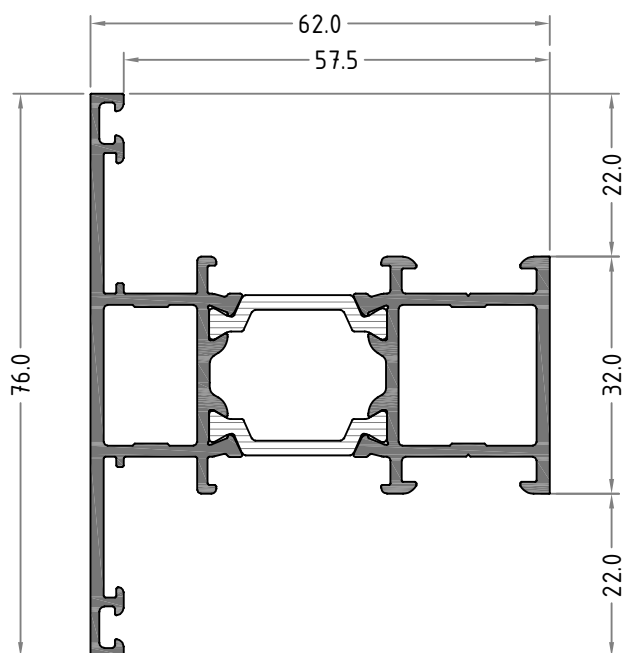
DESCRIPTION	Article Number	I_x eff. cm^4 $L = 3000 \text{ mm}$	$I_y \text{ cm}^4$	Technical information
Sash profile 68/80	2316210	36.59	37.33	
HV Sash profile 16/62	2216212	18.11	10.58	



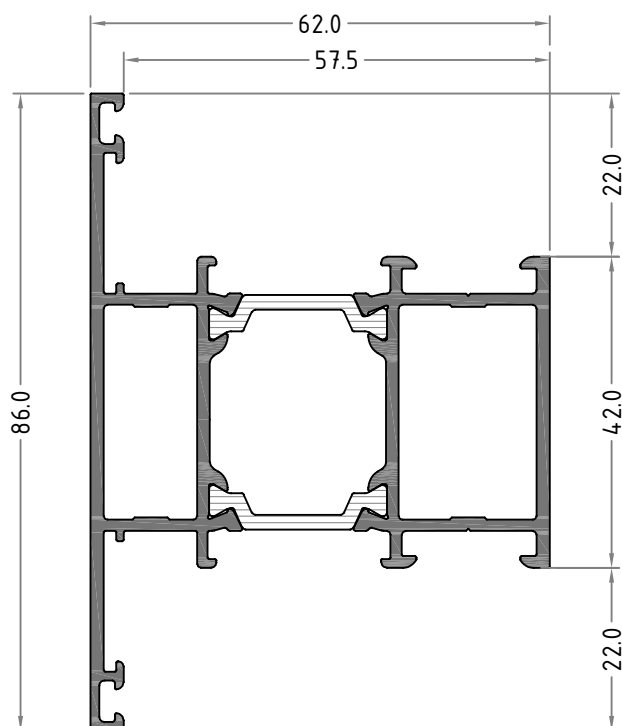
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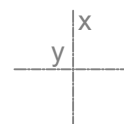
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Sash profile 102/46	2316211	37.36	39.97	



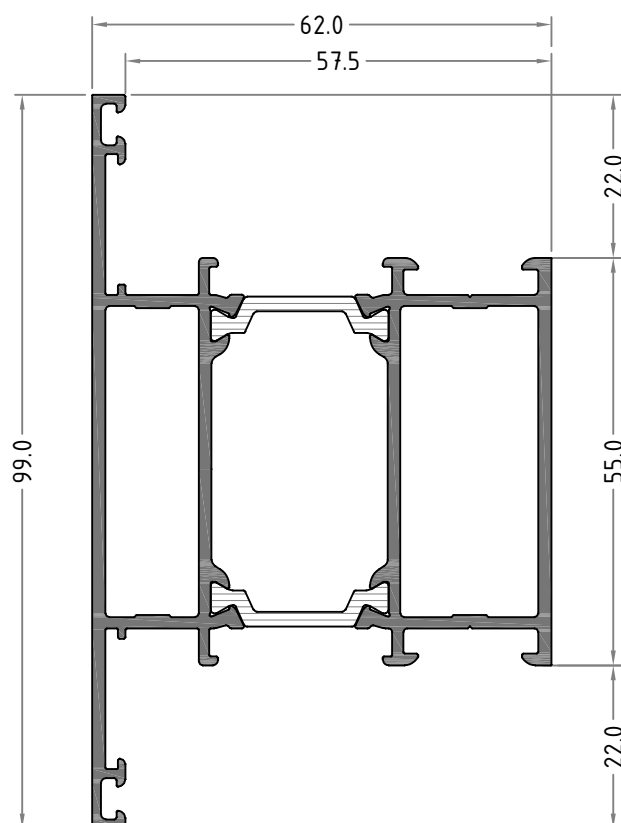
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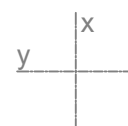
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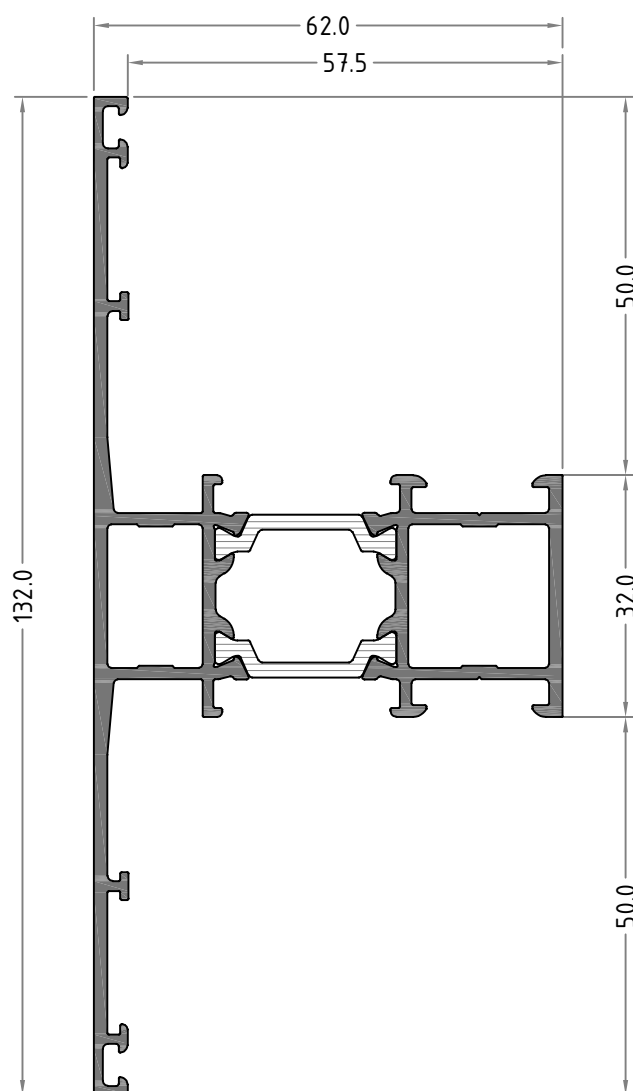
DESCRIPTION	Article Number	I_x eff. cm^4 $L = 3000 \text{ mm}$	I_y cm^4	Technical information
Mullion/Transom Profile 76/32	2416210	18.32	11.31	
Mullion/Transom Profile 86/42	2416211	21.25	18.62	



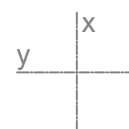
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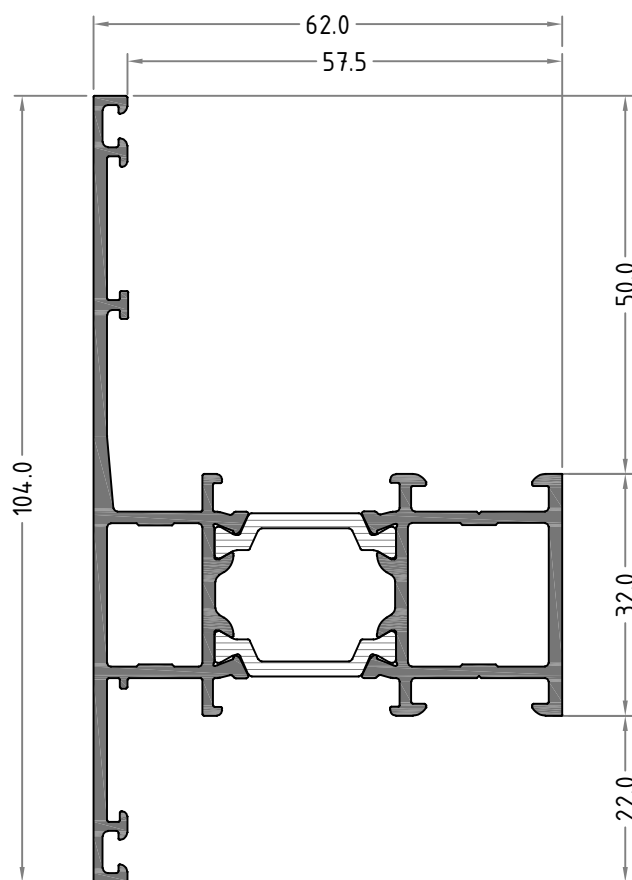
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Mullion/Transom Profile 99/55	2416212	25.03	32.30	



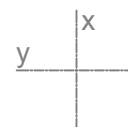
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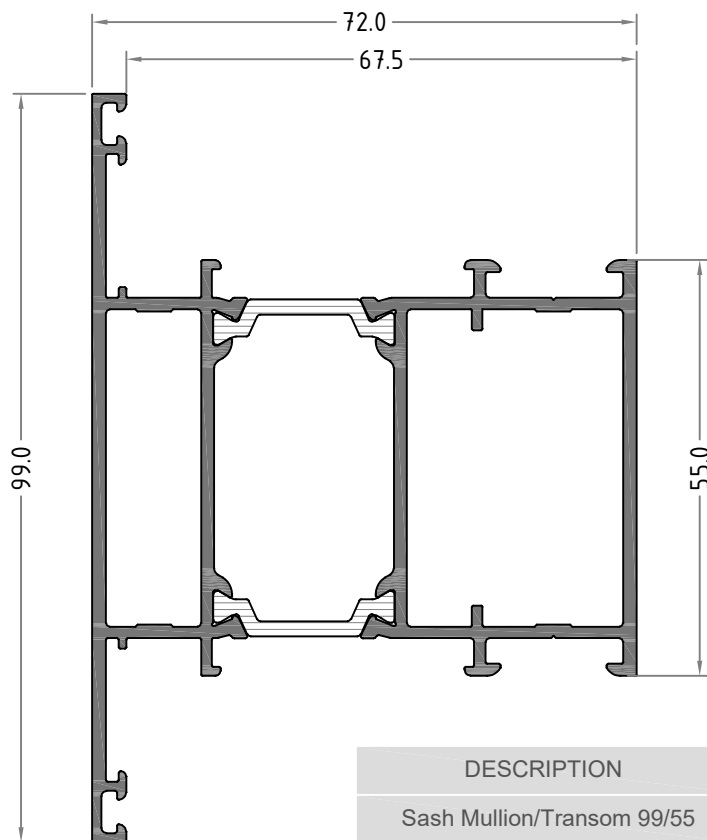
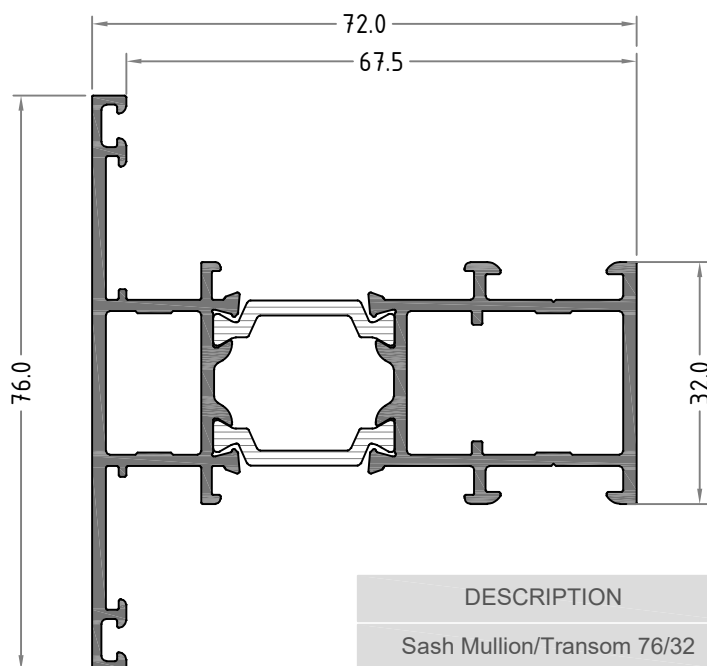
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Mullion/Transom Profile 132/32	2416213	22.19	44.60	

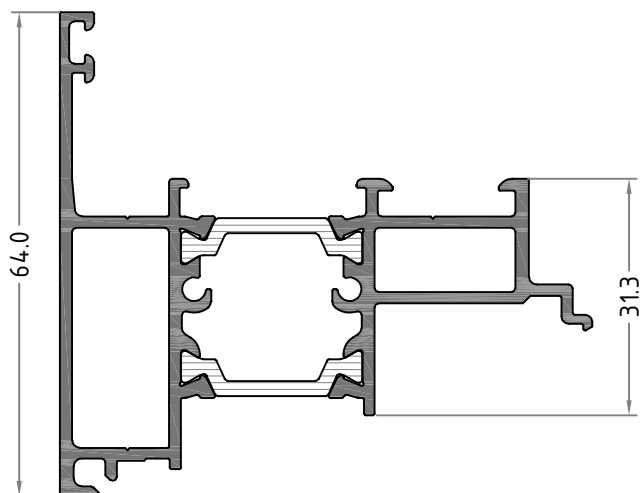


2416214

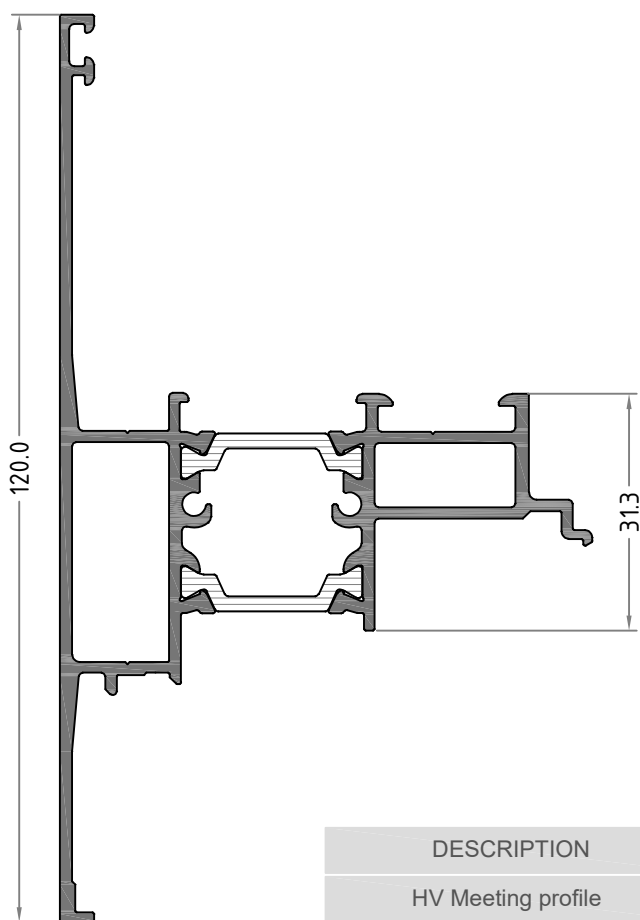


DESCRIPTION	Article Number	I_x eff. cm^4 $L = 3000 \text{ mm}$	$I_y \text{ cm}^4$	Technical information
Mullion/Transom Profile 104/32	2416214	20.47	25.90	

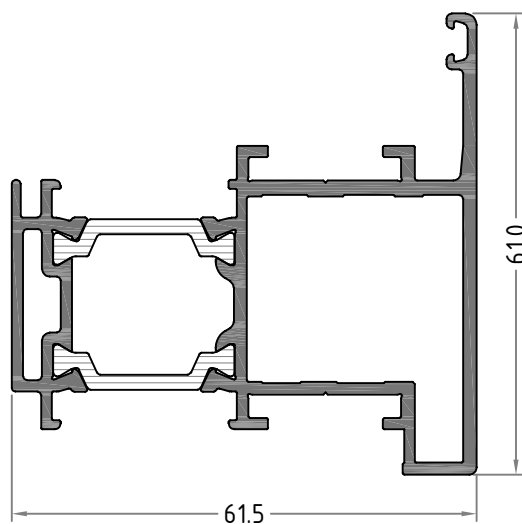




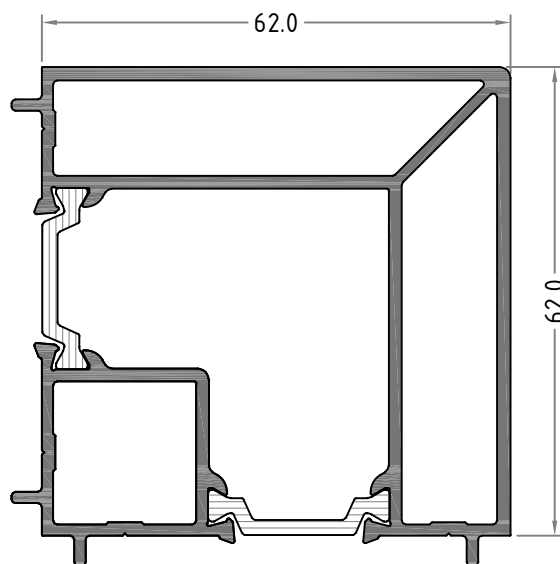
DESCRIPTION	Number
Meeting profile	2616210



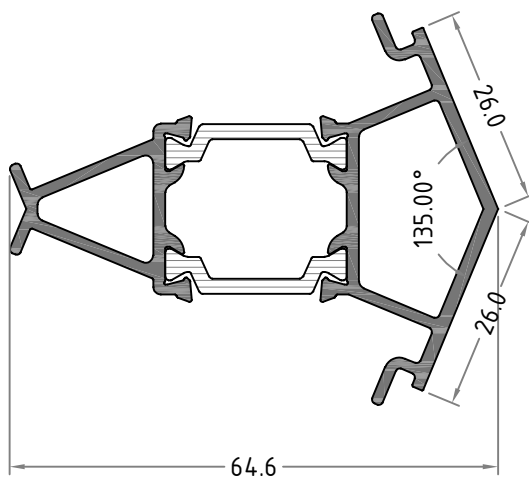
DESCRIPTION	Number
HV Meeting profile	2616211



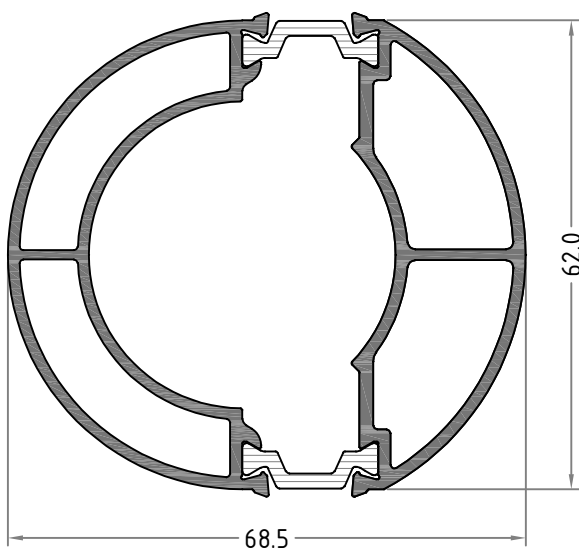
DESCRIPTION	Number
Pivot sash adaptor	2616212



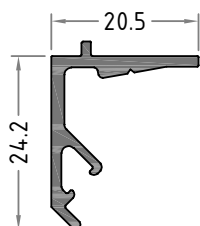
DESCRIPTION	Number
90 Degree Coupling	2616215



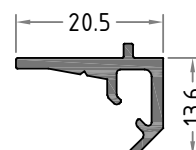
DESCRIPTION	Number
135 Degree Coupling	2616216



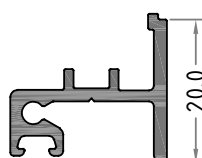
DESCRIPTION	Number
Round Coupling	2616217



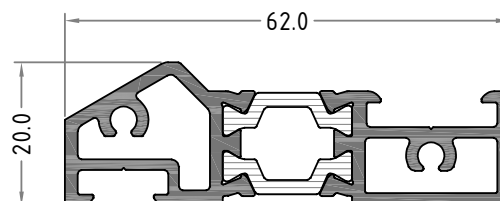
DESCRIPTION	Number
Round Coupling Adaptor	1000760



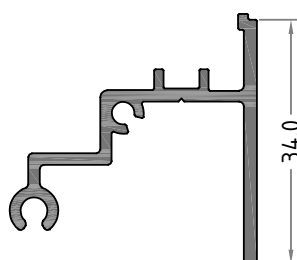
DESCRIPTION	Number
Round Coupling Adaptor	1000761



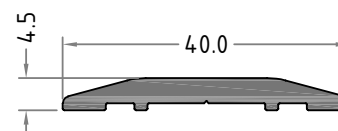
DESCRIPTION	Number
Door adaptor profile	1000771



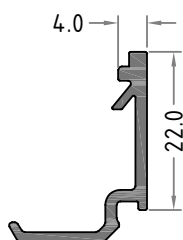
DESCRIPTION	Number
Threshold profile	2616214



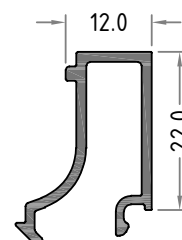
DESCRIPTION	Number
Door adaptor profile	1000773



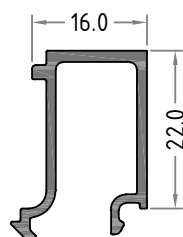
DESCRIPTION	Number
Door adaptor profile	1000774



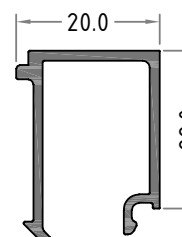
DESCRIPTION	Number
Glazing bead 4 mm	1000466



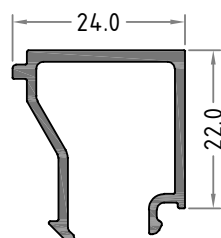
DESCRIPTION	Number
Glazing bead 12 mm	1000409



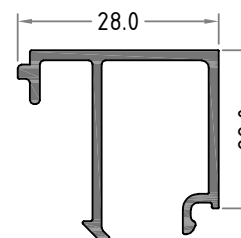
DESCRIPTION	Number
Glazing bead 16 mm	1000840



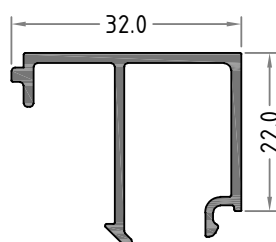
DESCRIPTION	Number
Glazing bead 20 mm	1000405



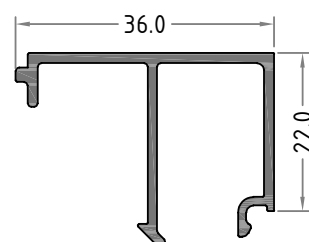
DESCRIPTION	Number
Glazing bead 24 mm	1000841



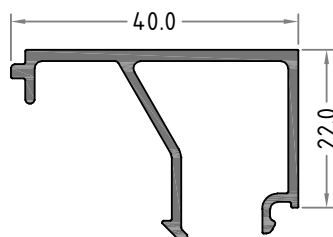
DESCRIPTION	Number
Glazing bead 28 mm	1000414



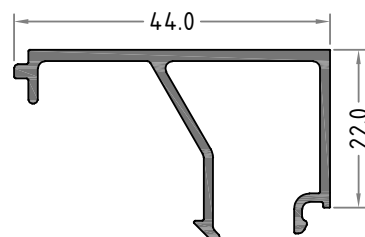
DESCRIPTION	Number
Glazing bead 32mm	1000749



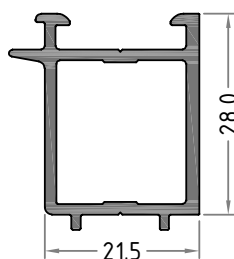
DESCRIPTION	Number
Glazing bead 36mm	1000467



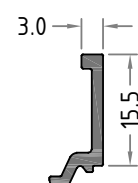
DESCRIPTION	Number
Glazing bead 40mm	1000750



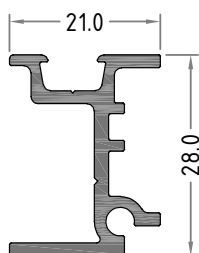
DESCRIPTION	Number
Glazing bead 44mm	1000842



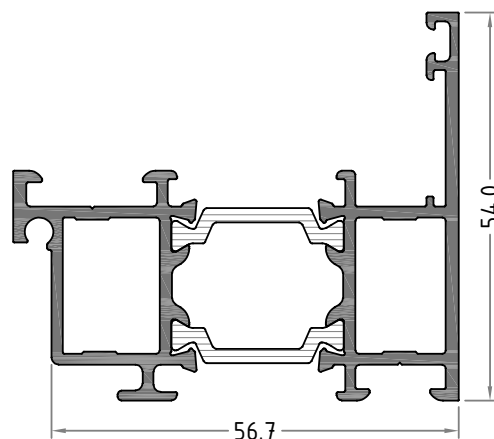
DESCRIPTION	Number
Glazing convertor	1000831



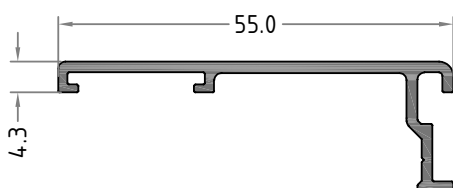
DESCRIPTION	Number
HV Sash Glazing bead	1000822



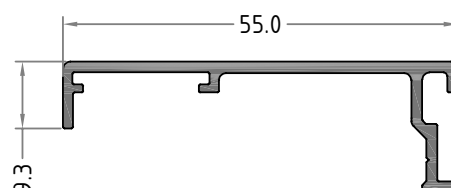
DESCRIPTION	Number
Curtain wall adaptor	1000876



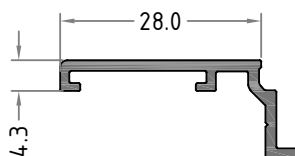
DESCRIPTION	Number
Outward adaptor Profile	2616213



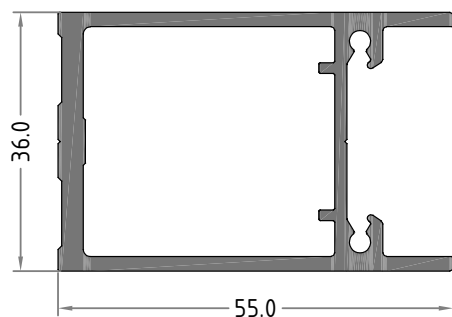
DESCRIPTION	Number
Architrave Profile 55mm / 4.3	1000488



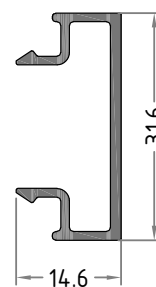
DESCRIPTION	Number
Architrave Profile 55mm / 9.3	1000612



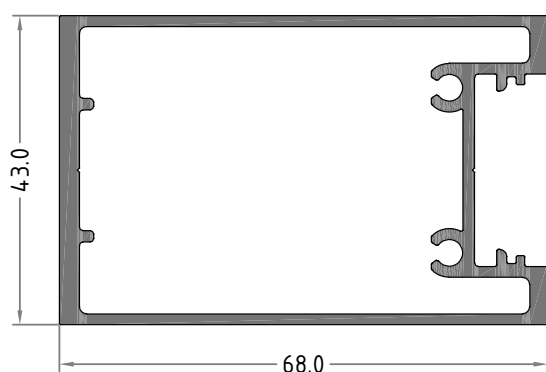
DESCRIPTION	Number
Add on Profile	1000501



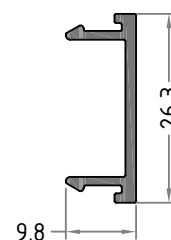
DESCRIPTION	Number
Reinforce profile	1000582



DESCRIPTION	Number
Cover profile	1000200



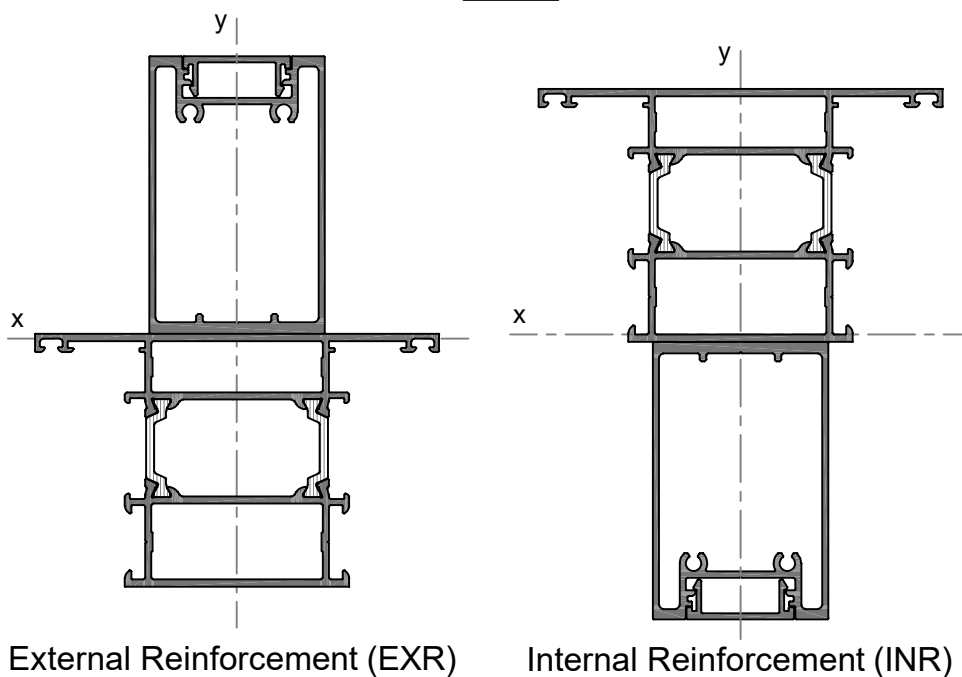
DESCRIPTION	Number
Reinforce profile	1000626



DESCRIPTION	Number
Cover profile	1000456

MULLION / TRANSOM PROPERTIES

GC62

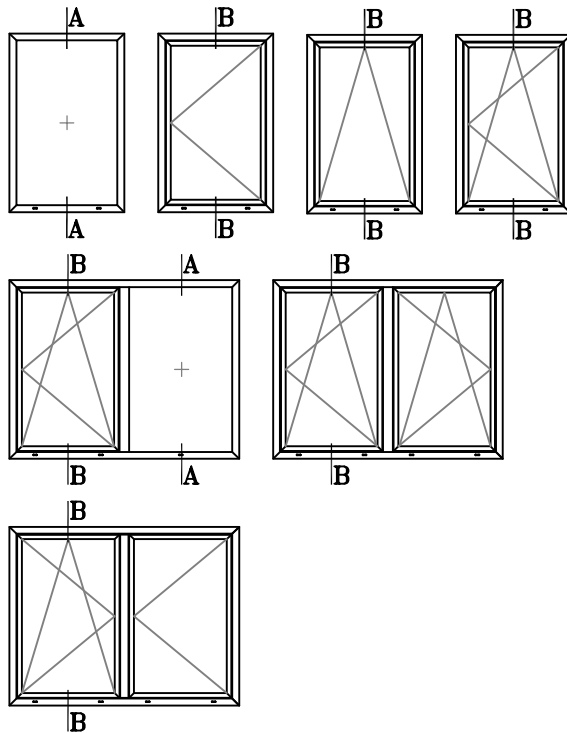


Article Number	Article Description	Add On Reinforcement	Internal Or External	Eff. I_x cm ⁴	I_y cm ⁴
2416210	Mullion/Transom 76/32	1000582 + 1000200	EXR	73.90	19.87
2416210	Mullion/Transom 76/32	1000626 + 1000456	EXR	114.70	24.00
2416211	Mullion/Transom 86/42	1000582 + 1000200	EXR	80.46	26.96
2416211	Mullion/Transom 86/42	1000626 + 1000456	EXR	123.38	31.28
2416211	Mullion/Transom 86/42	1000582 + 1000200	INR	100.87	26.96
2416212	Mullion/Transom 99/55	1000582 + 1000200	EXR	88.32	40.61
2416212	Mullion/Transom 99/55	1000626 + 1000456	EXR	133.61	44.90
2416212	Mullion/Transom 99/55	1000582 + 1000200	INR	108.00	40.61
2416212	Mullion/Transom 99/55	1000626 + 1000456	INR	158.21	44.90
2416213	Mullion/Transom 132/32	1000582 + 1000200	EXR	74.39	53.01
2416213	Mullion/Transom 132/32	1000626 + 1000456	EXR	116.12	57.00
2416214	Mullion/Transom 104/32	1000582 + 1000200	EXR	74.15	35.32
2416214	Mullion/Transom 104/32	1000626 + 1000456	EXR	115.46	39.66

Effective I_x calculated in accordance with EN 14024-2004

SECTIONS

GC62 Casement System

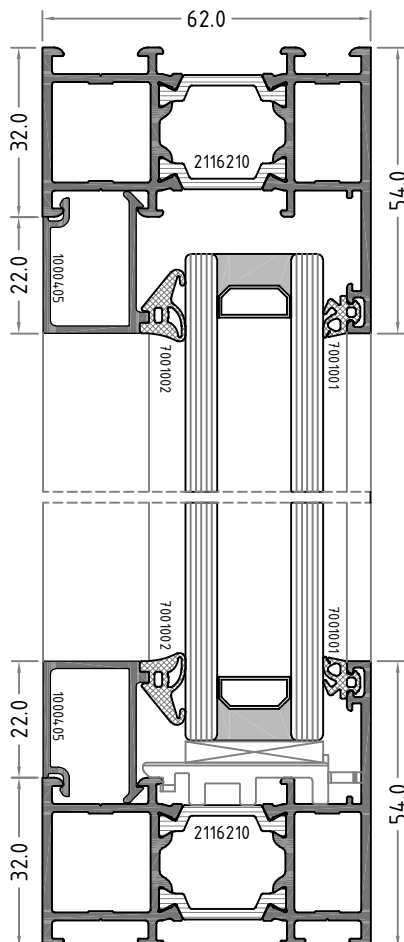


Usable Frames :

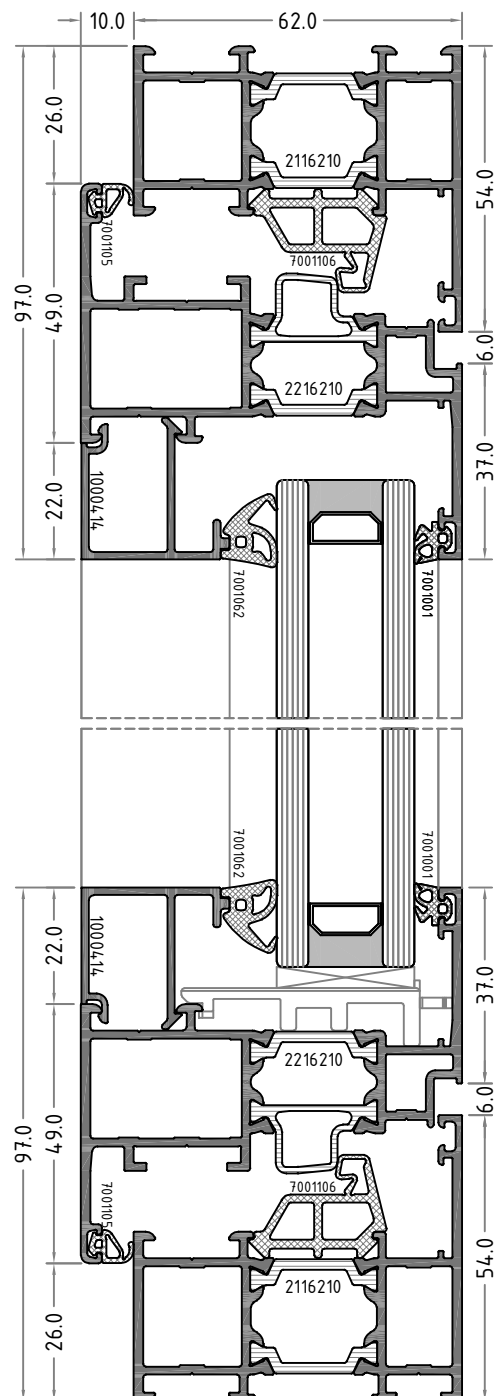
2116210 - 2116211 - 2116212

Usable Sashes :

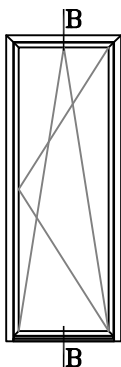
2216210 - 2216211 - 2316210



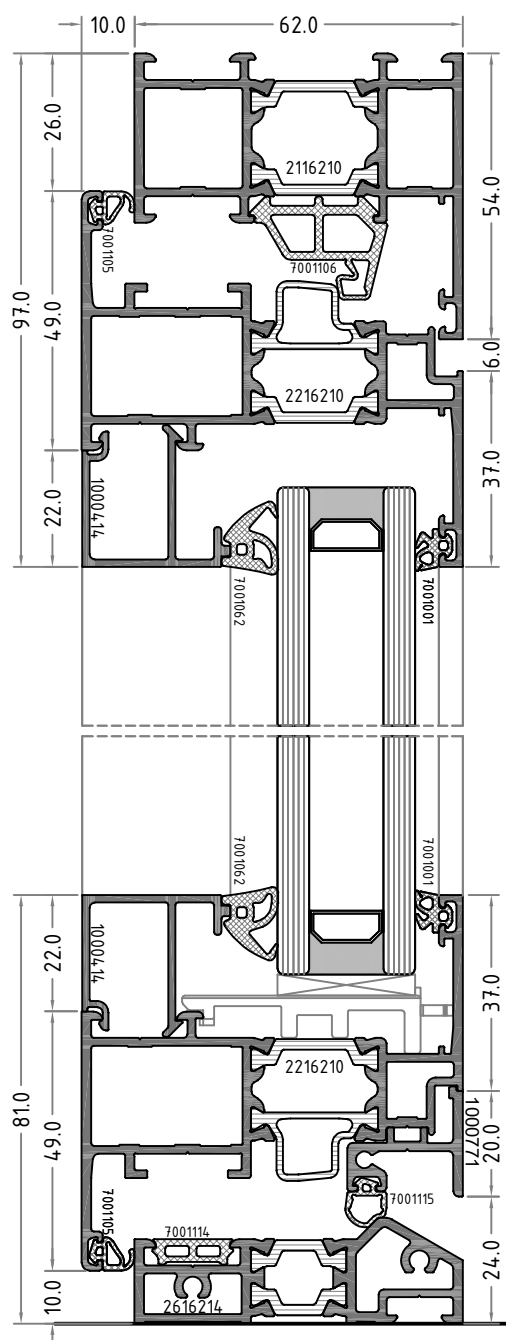
Section A-A



Section B-B



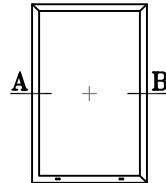
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sashes :
2216210 - 2216211 - 2316210



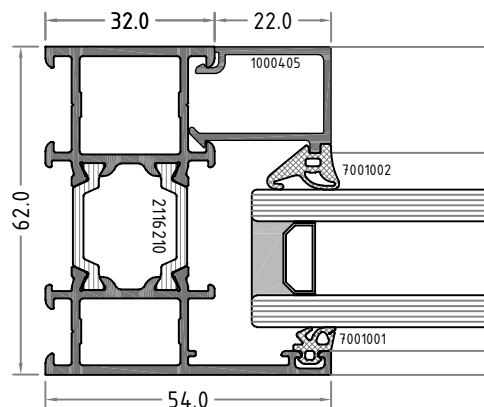
Section B-B

SECTIONS

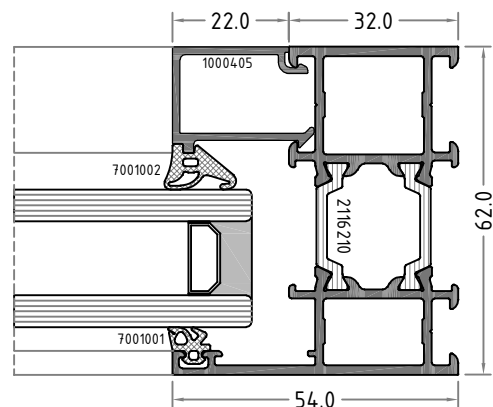
GC62 Casement System



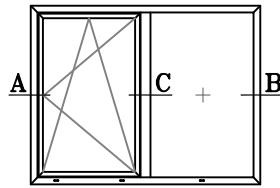
Usable Frames :
2116210 - 2116211 - 2116212



Section A



Section B



Usable Frames :

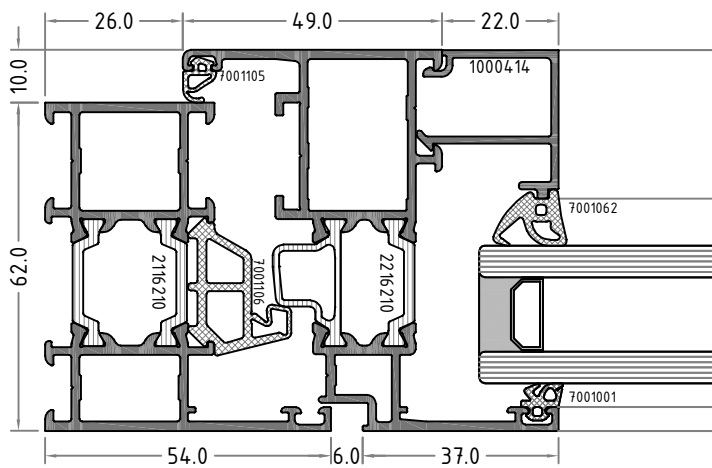
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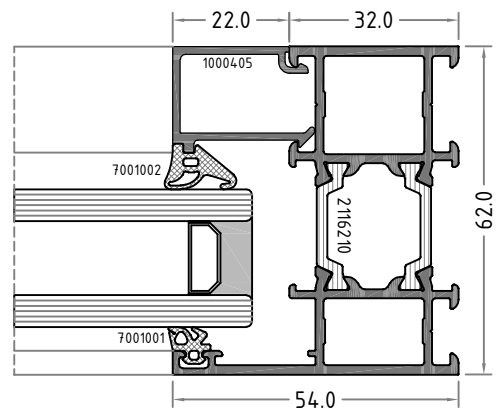
2216210 - 2216211 - 2316210

Usable Frame Mullion Transom :

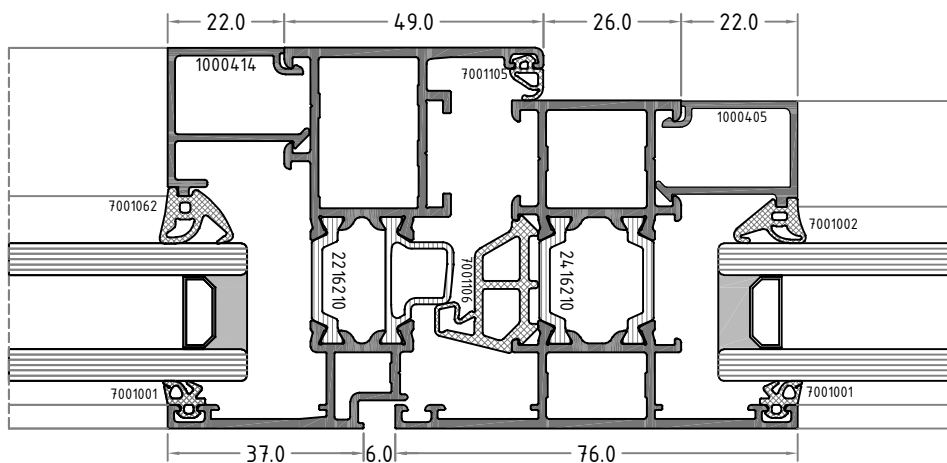
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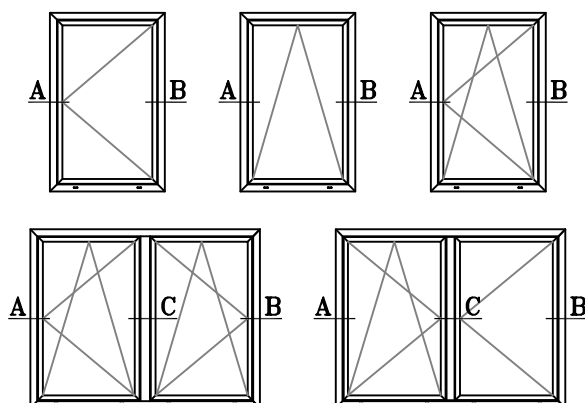
Section A



Section B



Section C

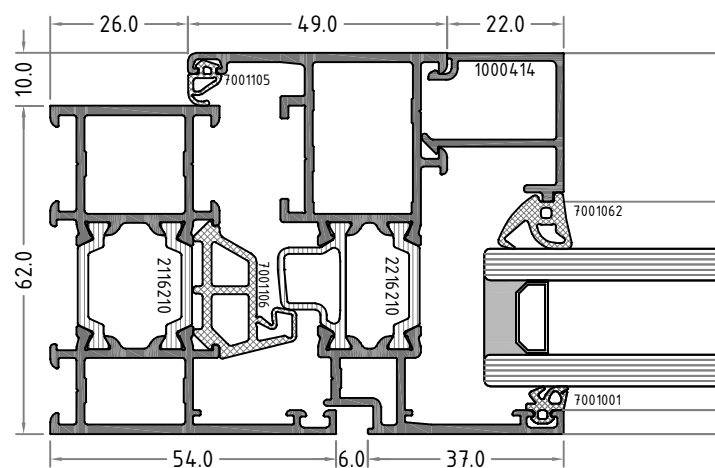


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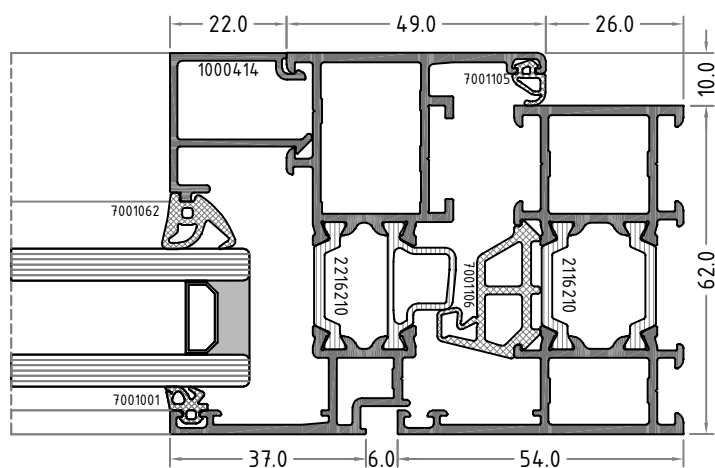
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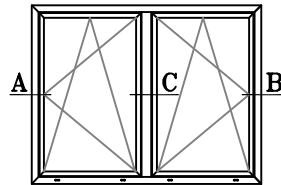
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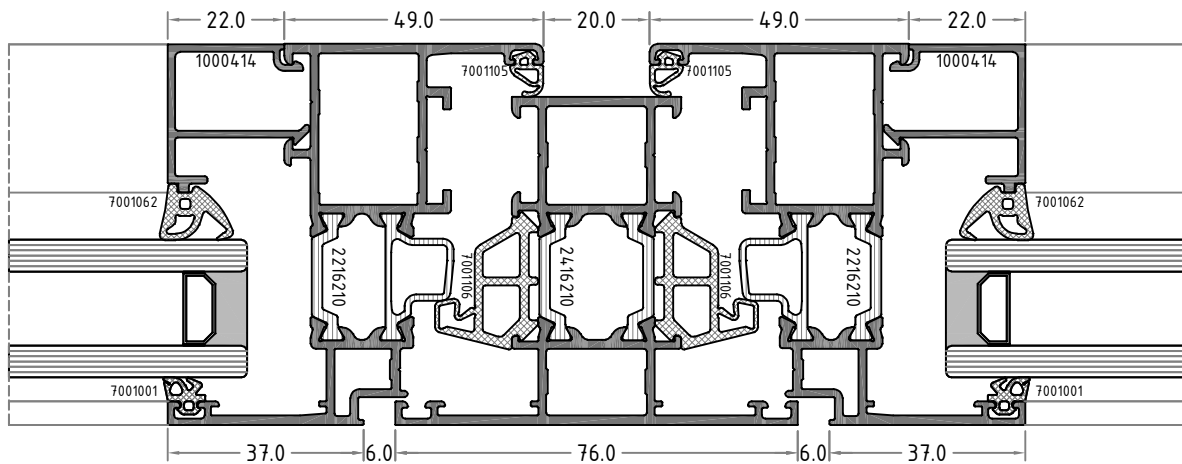
Section A



Section B



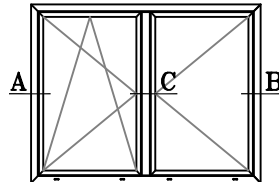
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sashes :
2216210 - 2216211 - 2316210
Usable Frame Mullion Transom :
2416210 - 2416211 - 2416212



Section C

SECTIONS

GC62 Casement System

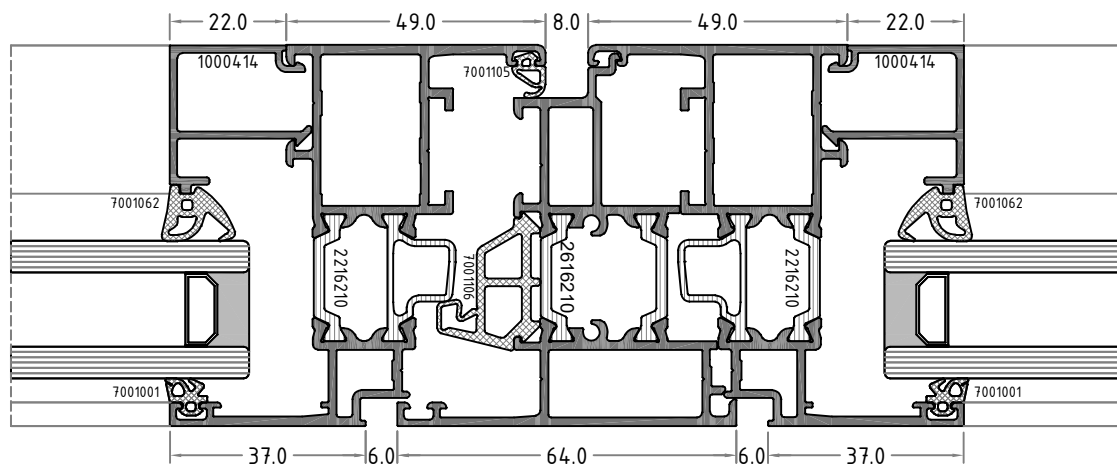


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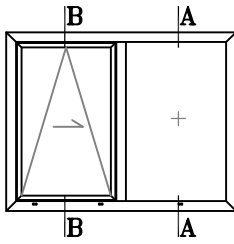
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Usable Sashes :

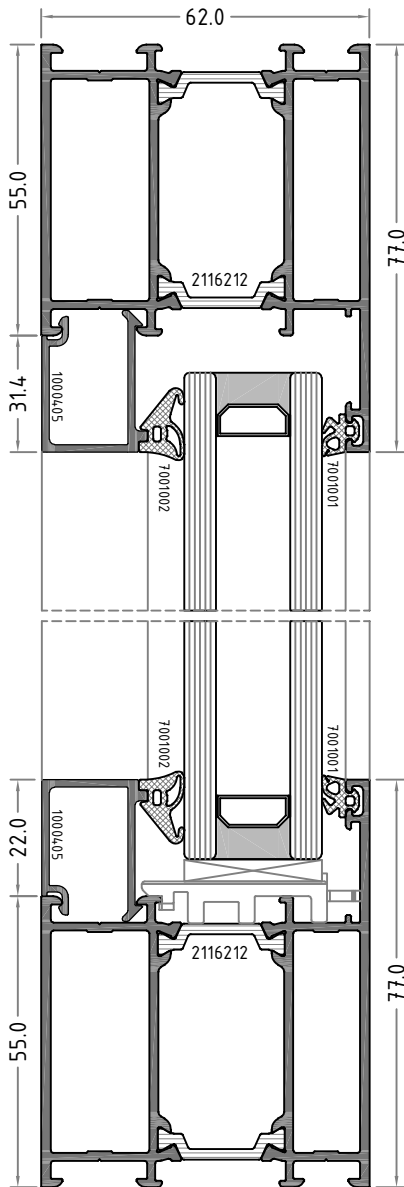
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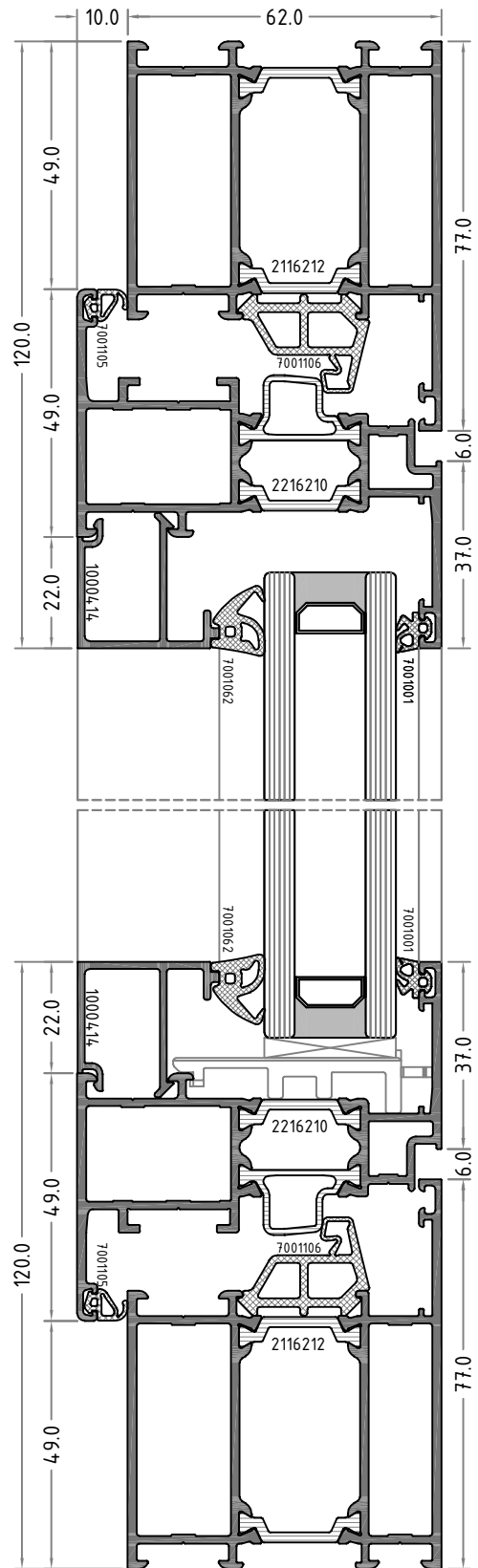
Section C



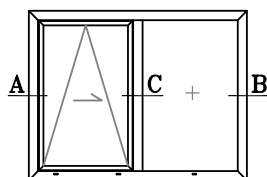
Usable Frame :
2116212
Usable Sashes :
2216210 - 2216211 - 2316210



Section A-A



Section B-B



Usable Frame :

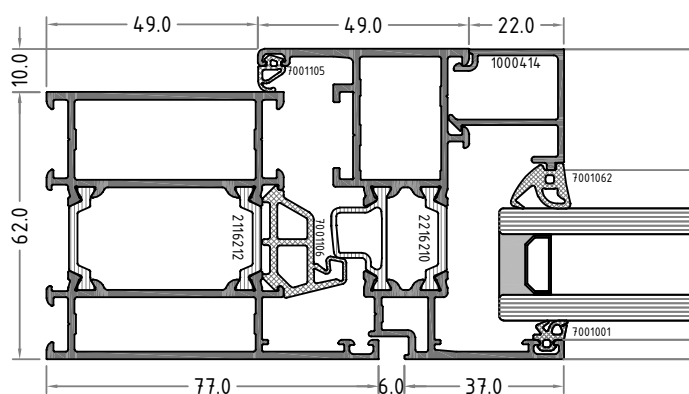
2116212

Usable Sashes :

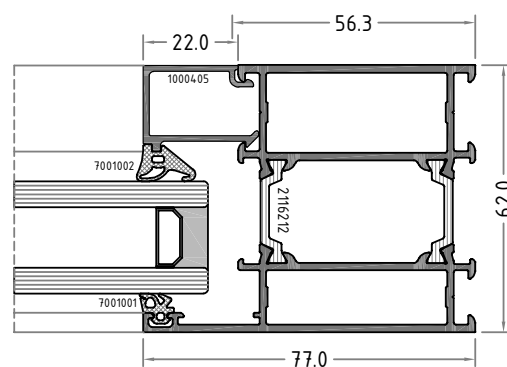
2216210 - 2216211 - 2316210

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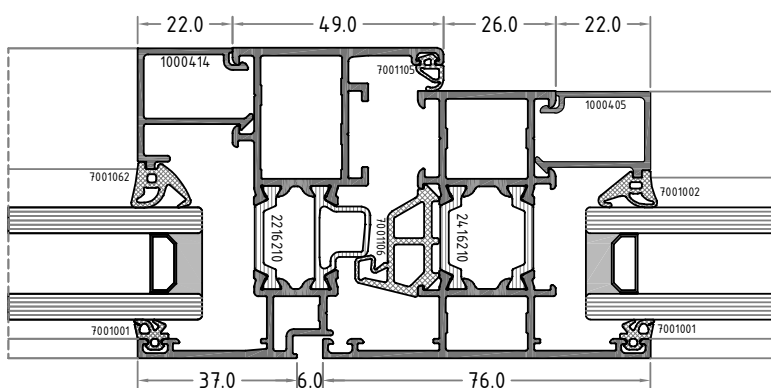
2416210 - 2416211 - 2416212



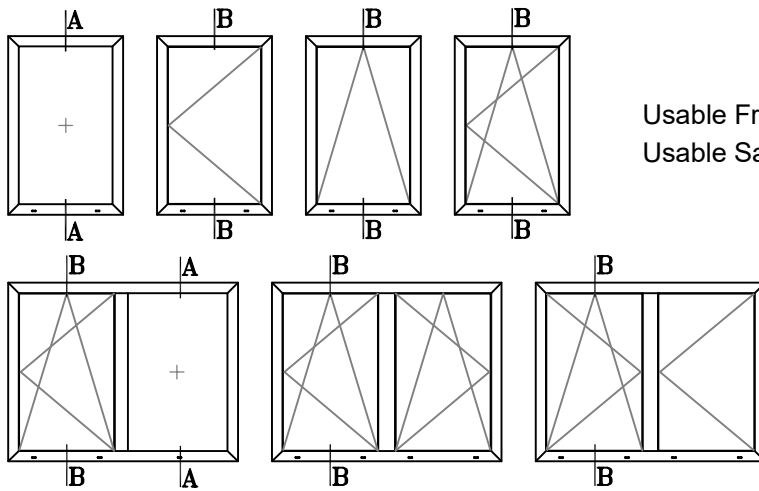
Section A



Section B

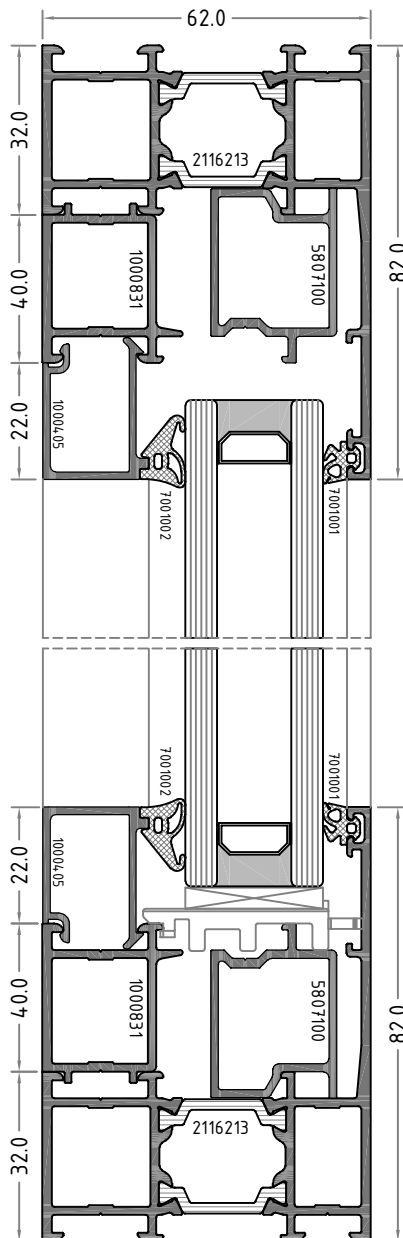


Section C

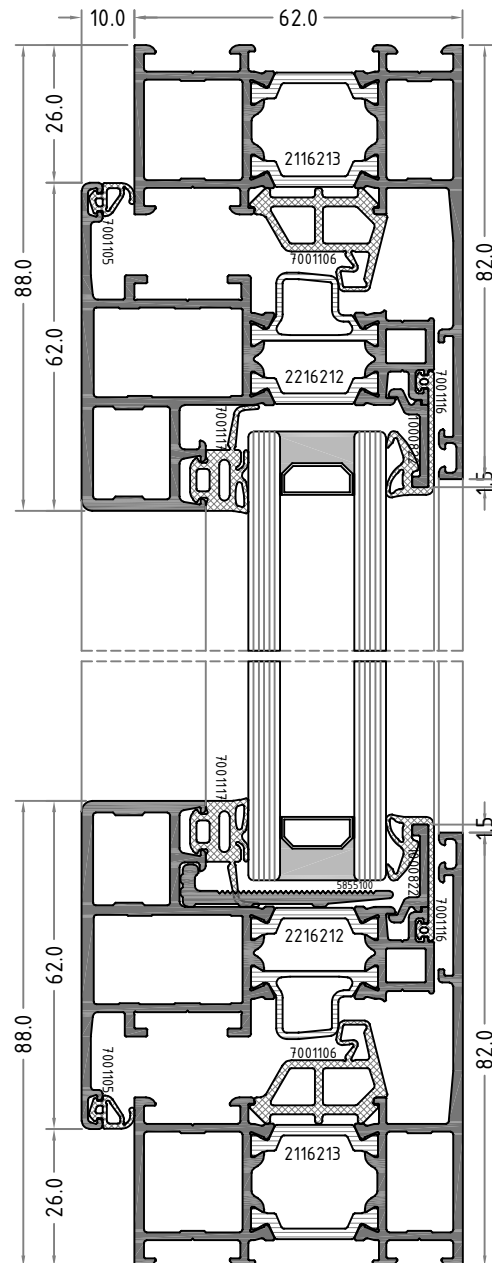


Usable Frame : 2116213

Usable Sash : 2216212



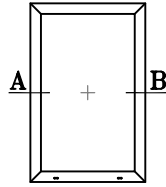
Section A-A



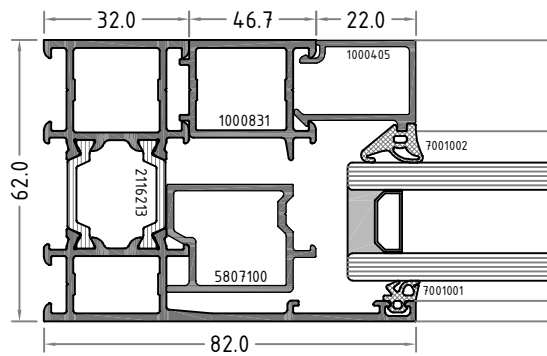
Section B-B

SECTIONS

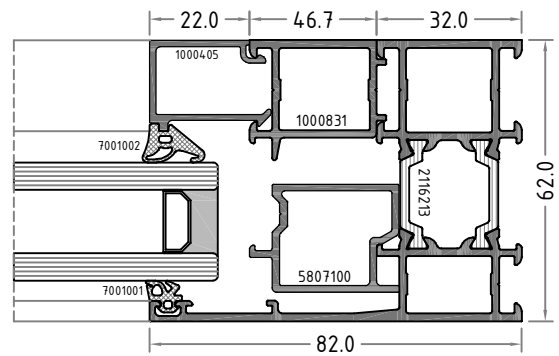
GC62 Casement System



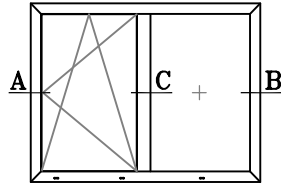
Usable Frame : 2116213



Section A



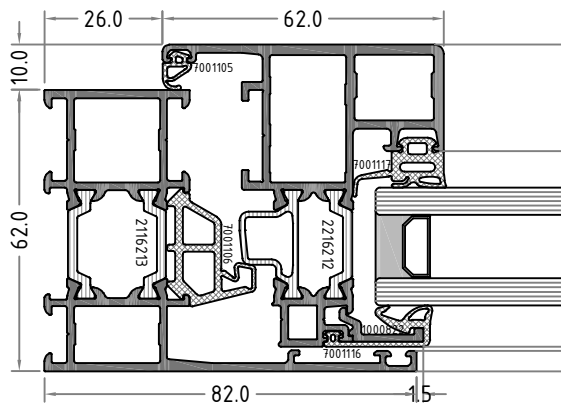
Section B



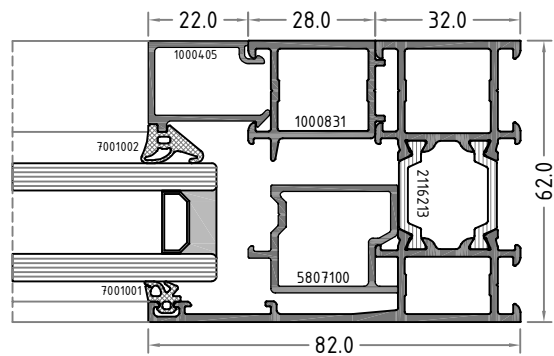
Usable Frame : 2116213

Usable Sash : 2216212

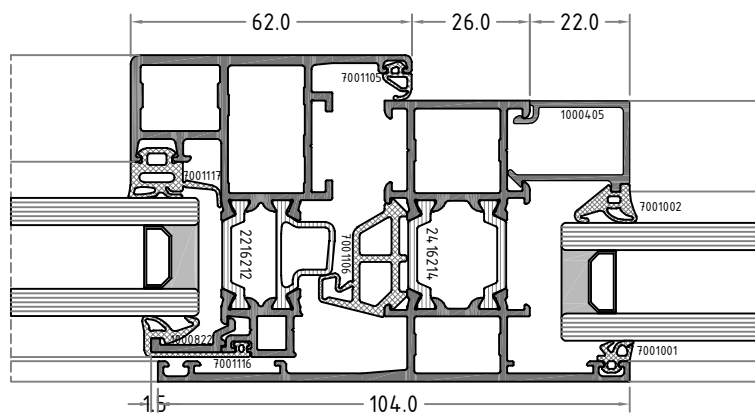
Usable Frame Mullion Transom : 2416214 - 2416215



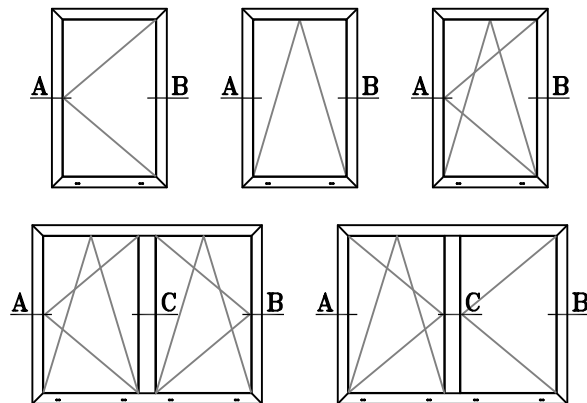
Section A



Section B

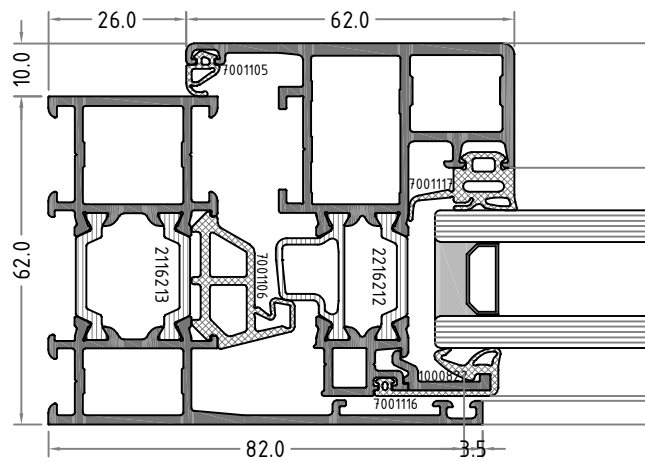


Section C

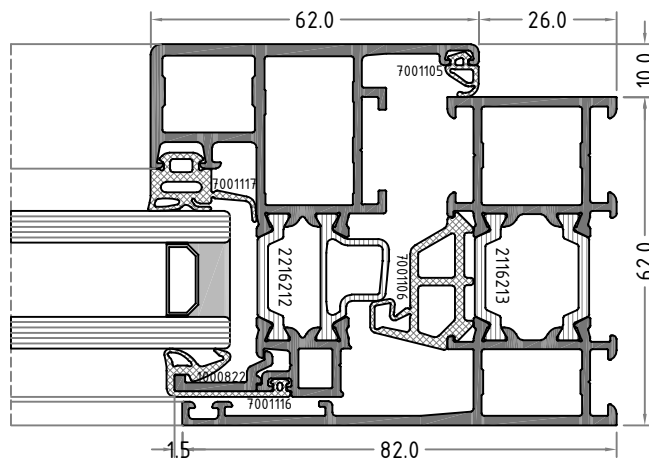


Usable Frame : 2116213

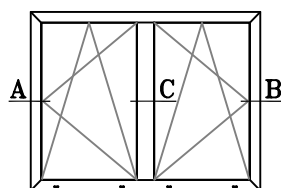
Usable Sash : 2216212



Section A



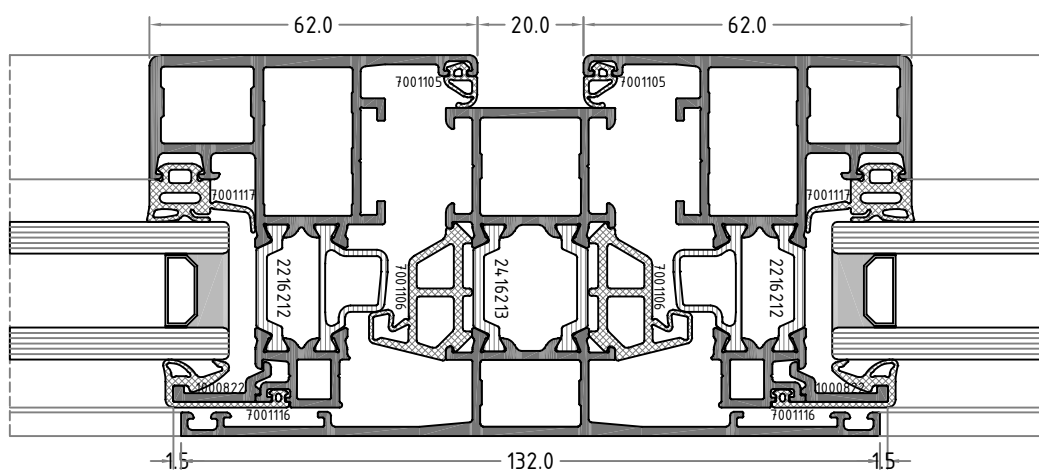
Section B



Usable Frame : 2116213

Usable Sash : 2216212

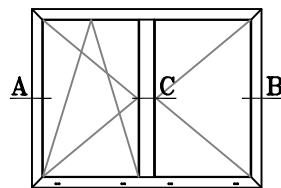
Usable Frame Mullion Transom : 2416213



Section C

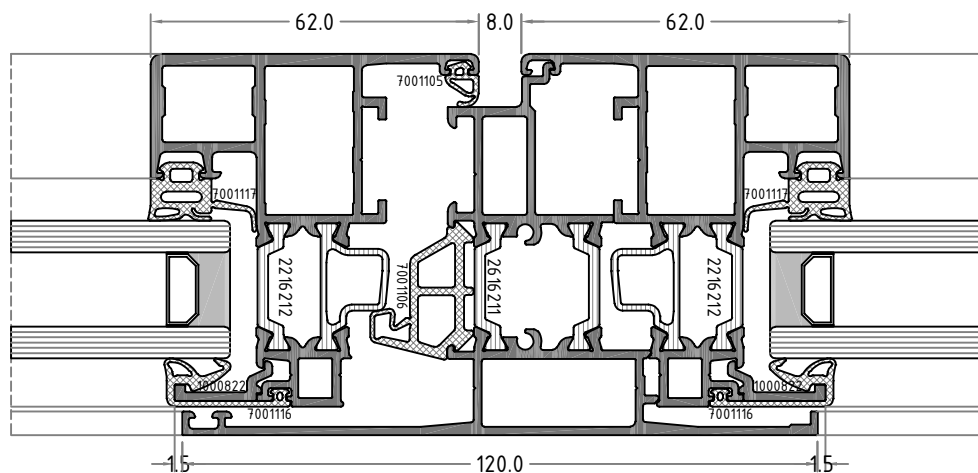
SECTIONS

GC62 Casement System

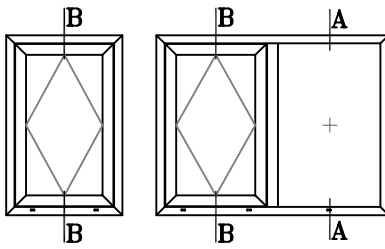


Usable Frame : 2116213

Usable Sash : 2216212



Section C

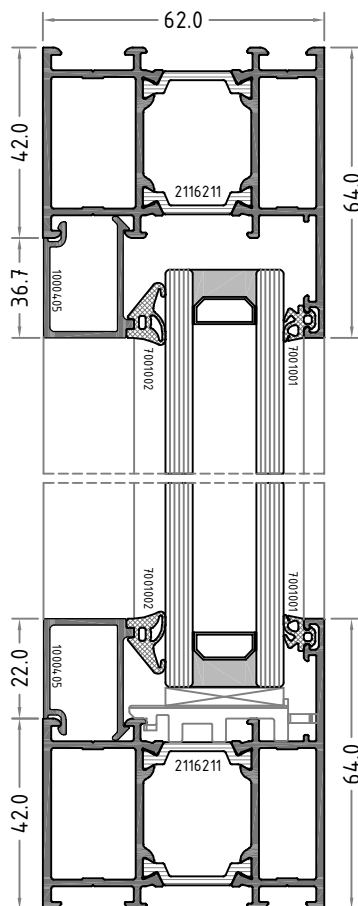


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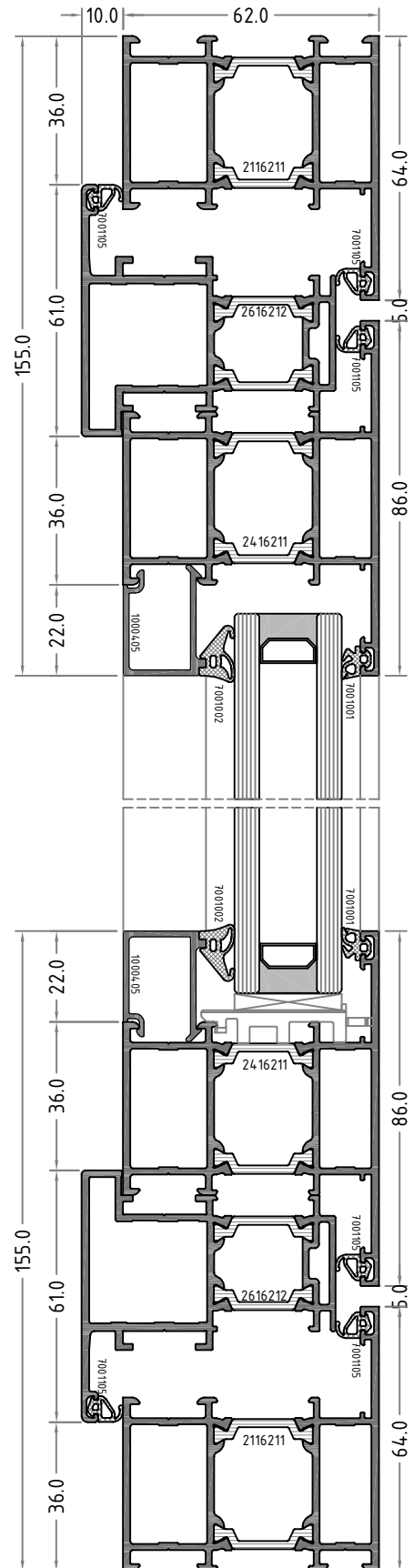
2116210 - 2116211 - 2116212

Usable Sashes :

2416210 - 2416211 - 2416212



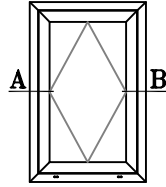
Section A-A



Section B-B

SECTIONS

GC62 Casement System

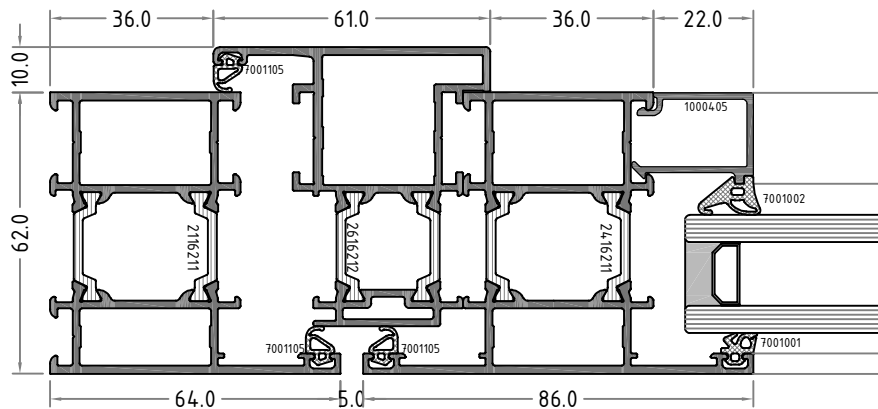


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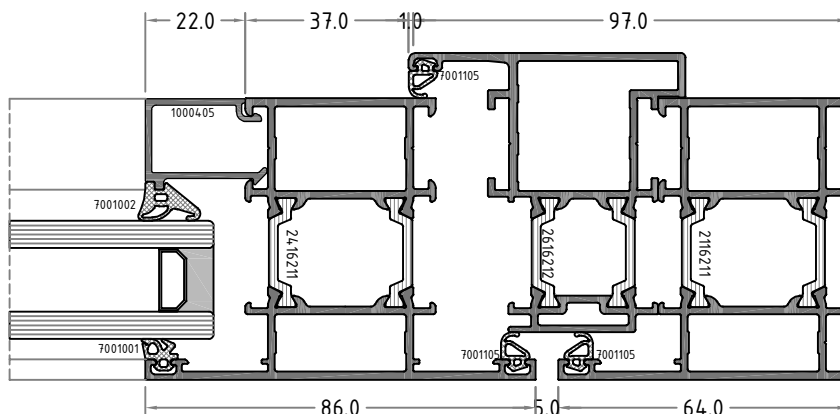
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Usable Sashes :

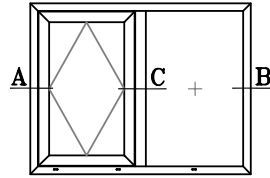
2416210 - 2416211 - 2416212



Section A



Section B



Usable Frames :

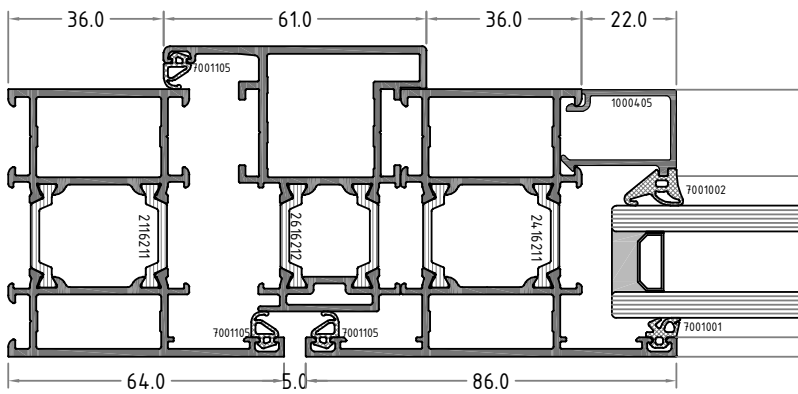
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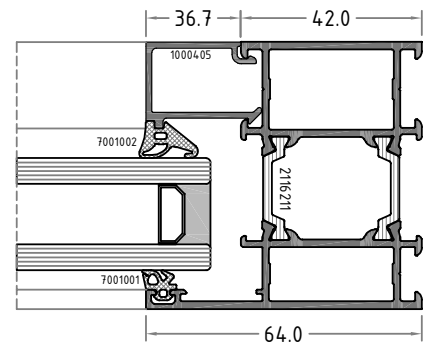
2416210 - 2416211 - 2416212

Usable Frame Mullion Transom :

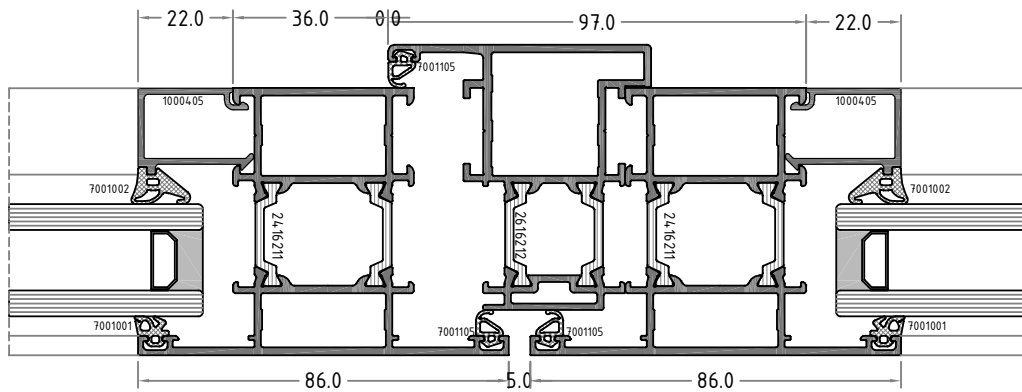
2416210 - 2416211 - 2416212



Section A



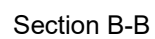
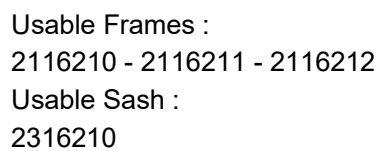
Section B



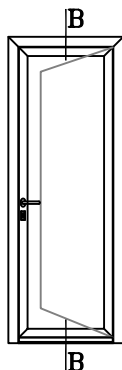
Section C

GC62 Casement System

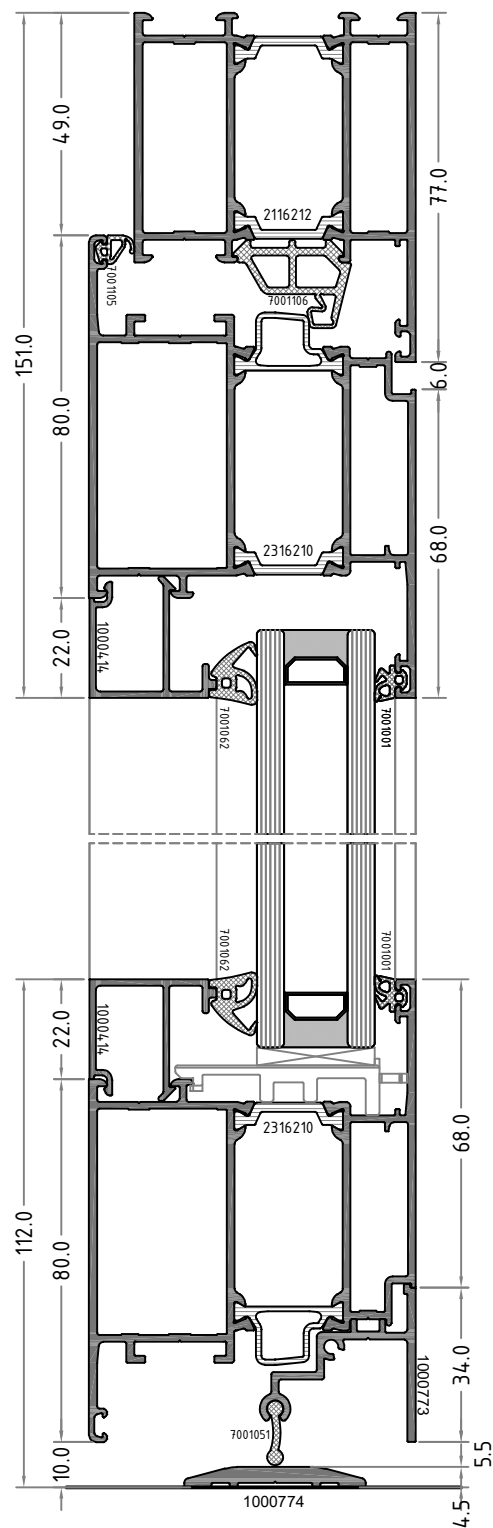




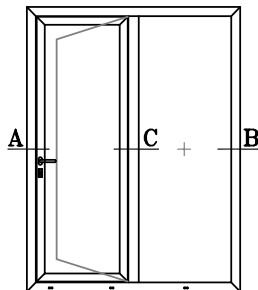
GC62 Casement System



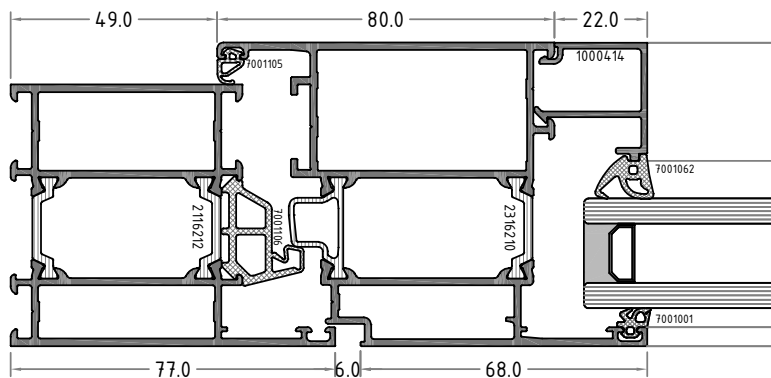
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316210



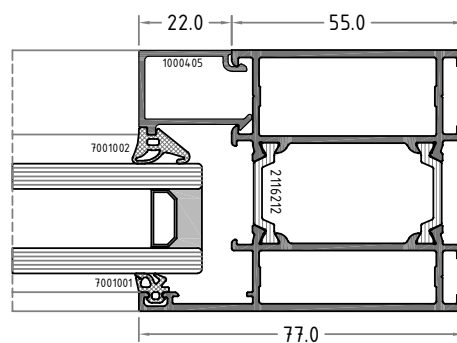
Section B-B



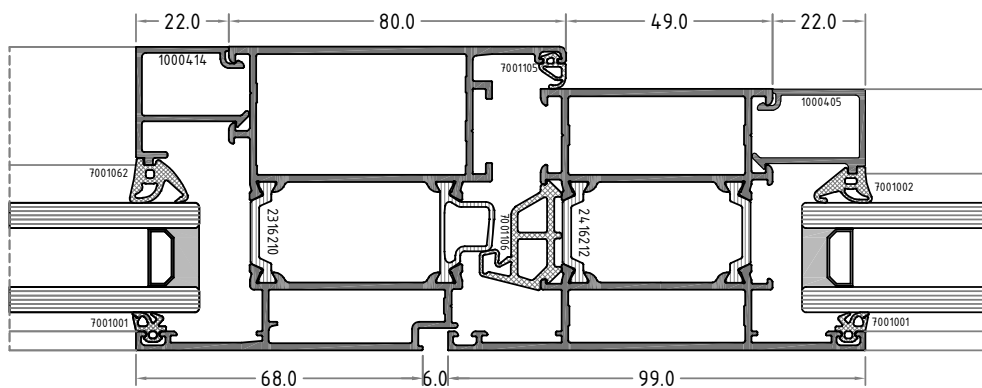
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316210
Usable Frame Mullion Transom :
2416210 - 2416211 - 2416212



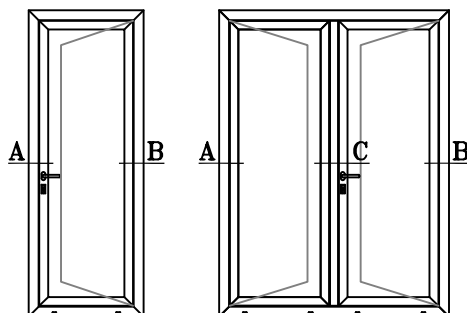
Section A



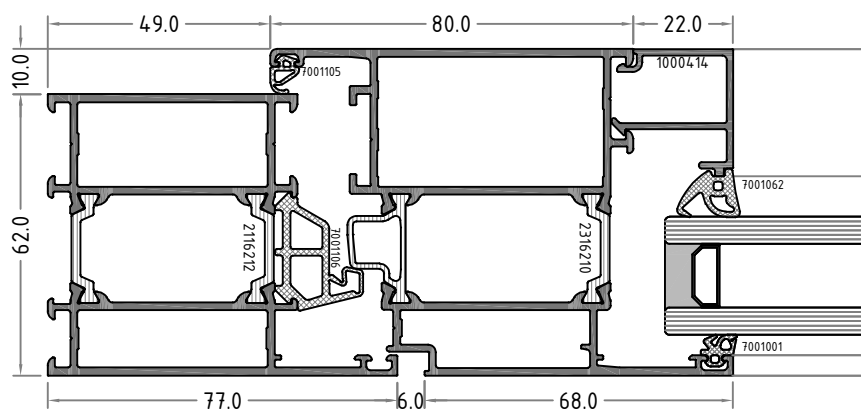
Section B



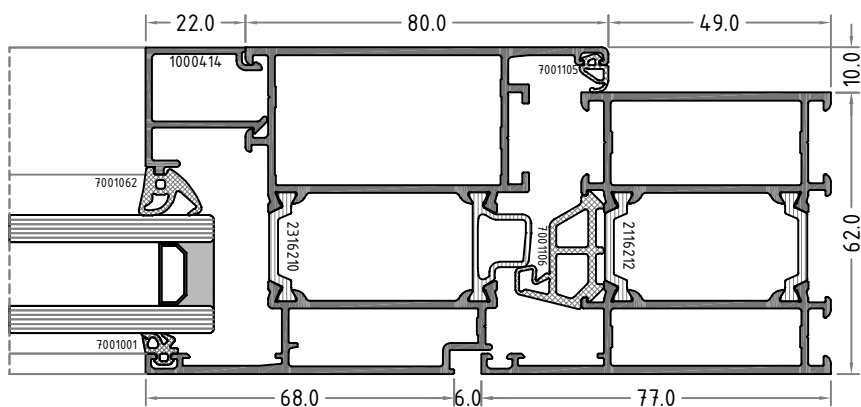
Section C



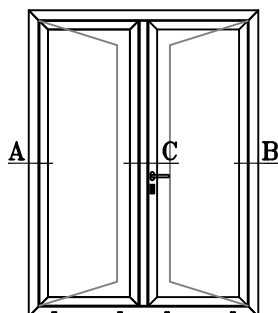
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316210



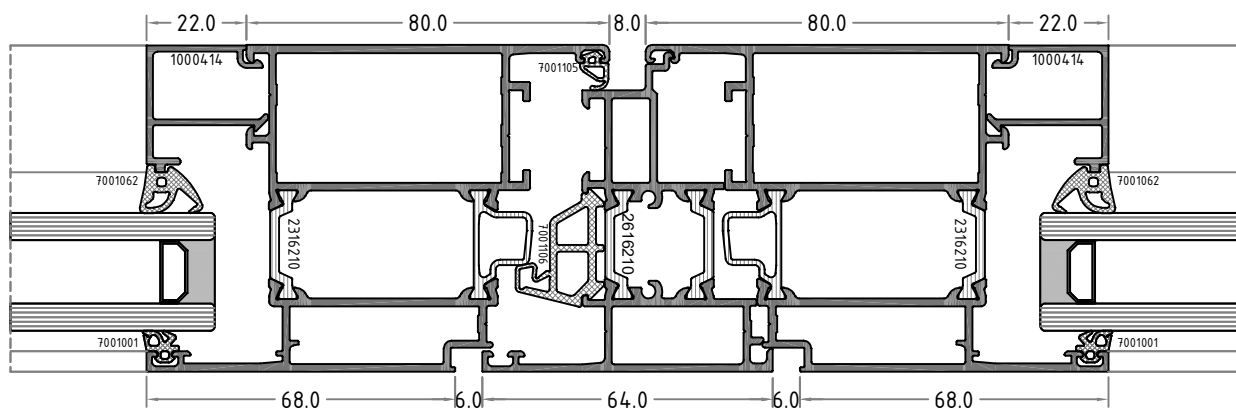
Section A



Section B



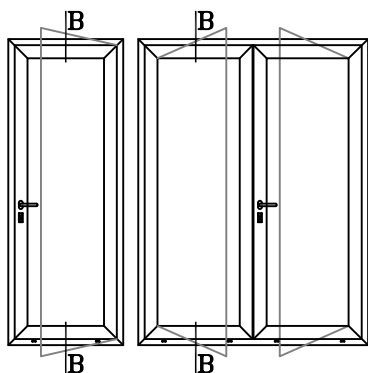
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316210



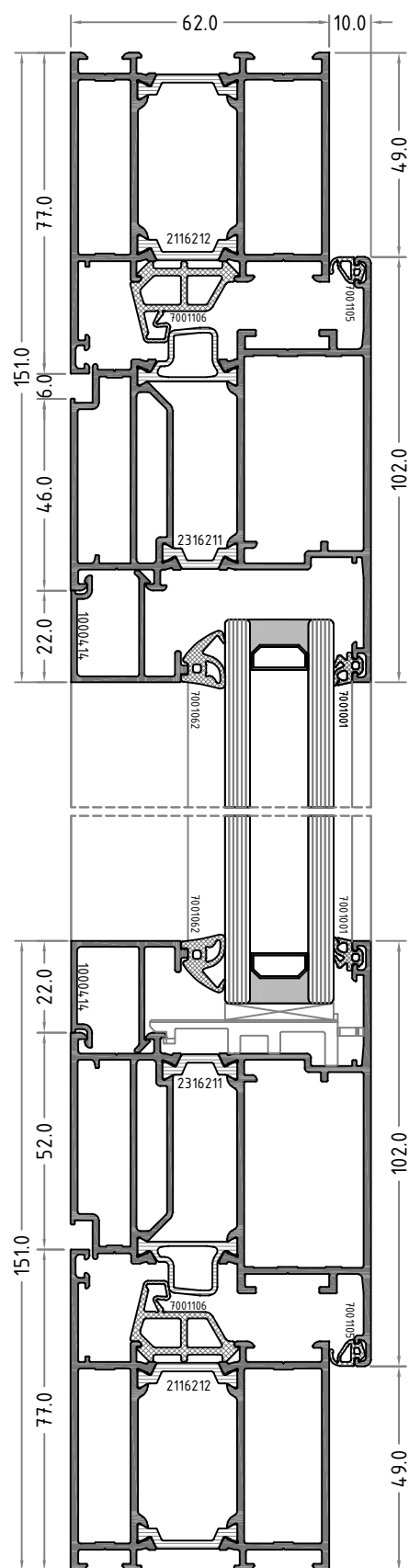
Section C

SECTIONS

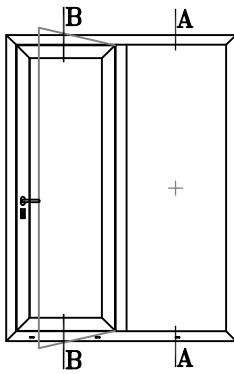
GC62 Casement System



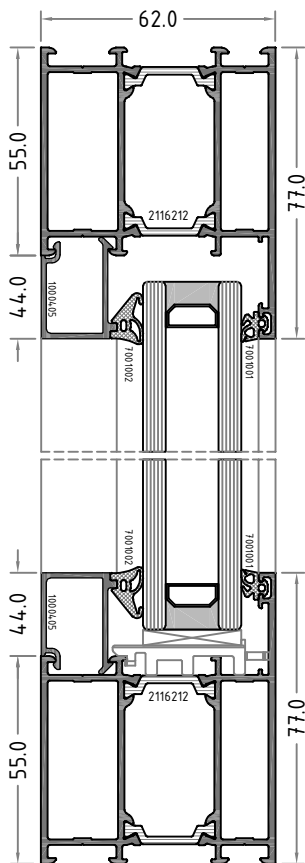
Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316211



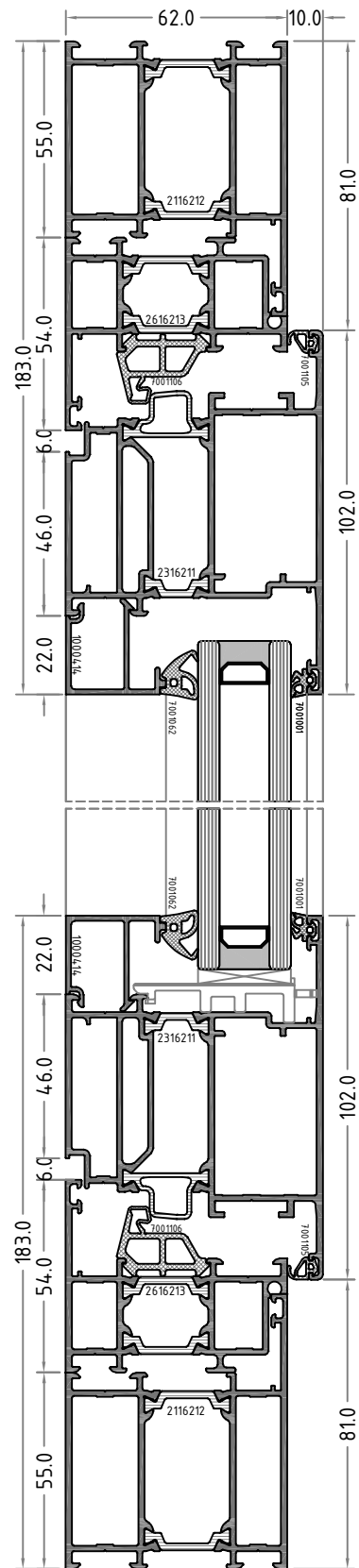
Section B-B



Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316211



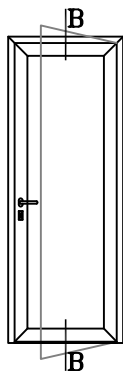
Section A-A



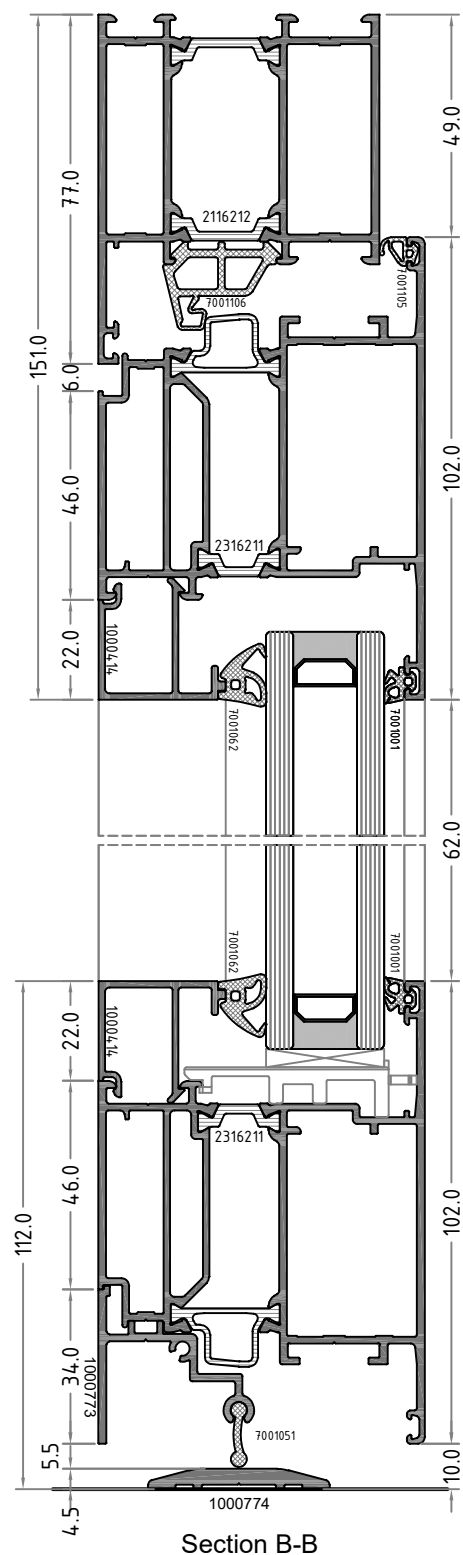
Section B-B

GC62 Casement System



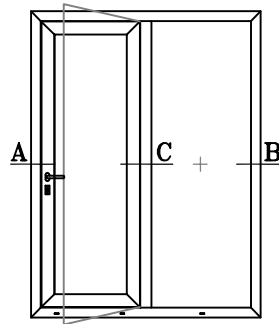


Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316211



SECTIONS

GC62 Casement System



Usable Frames :

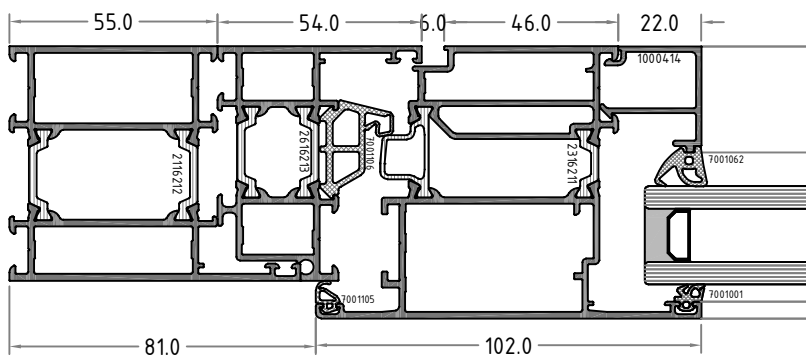
2116210 - 2116211 - 2116212

Usable Sash :

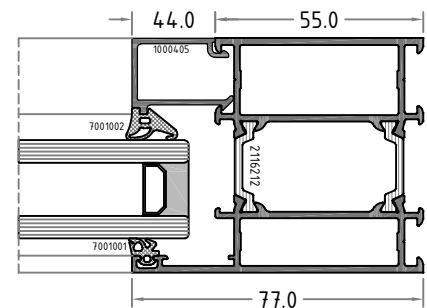
2316211

Usable Frame Mullion Transom :

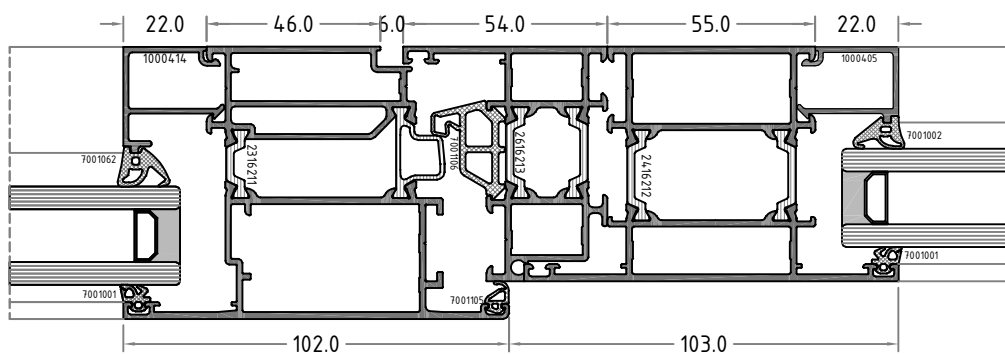
2416210 - 2416211 - 2416212



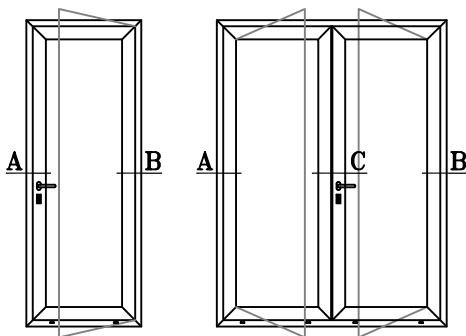
Section A



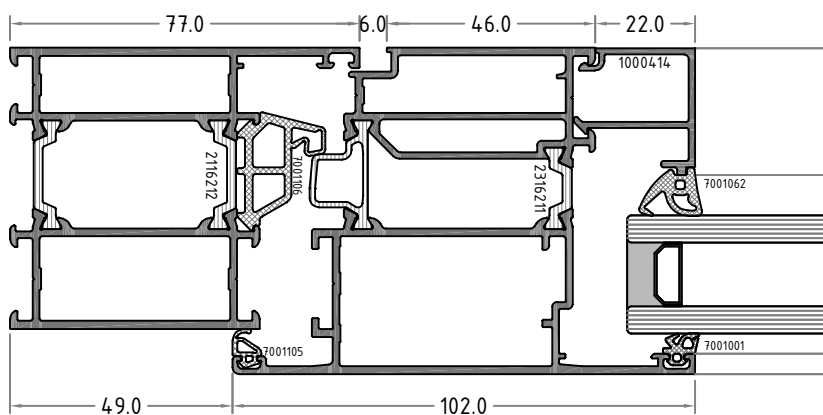
Section B



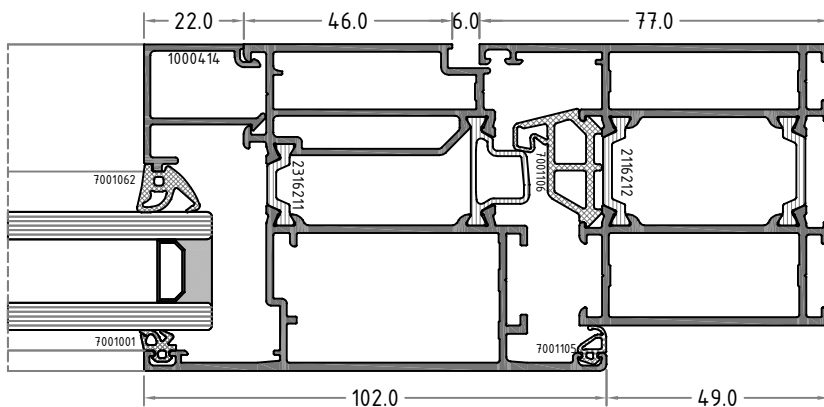
Section C



Usable Frames :
2116210 - 2116211 - 2116212
Usable Sash :
2316211



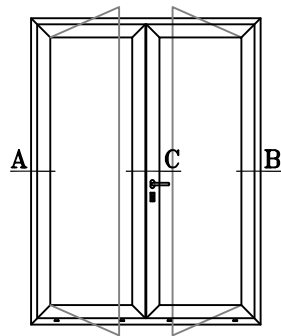
Section A



Section B

SECTIONS

GC62 Casement System

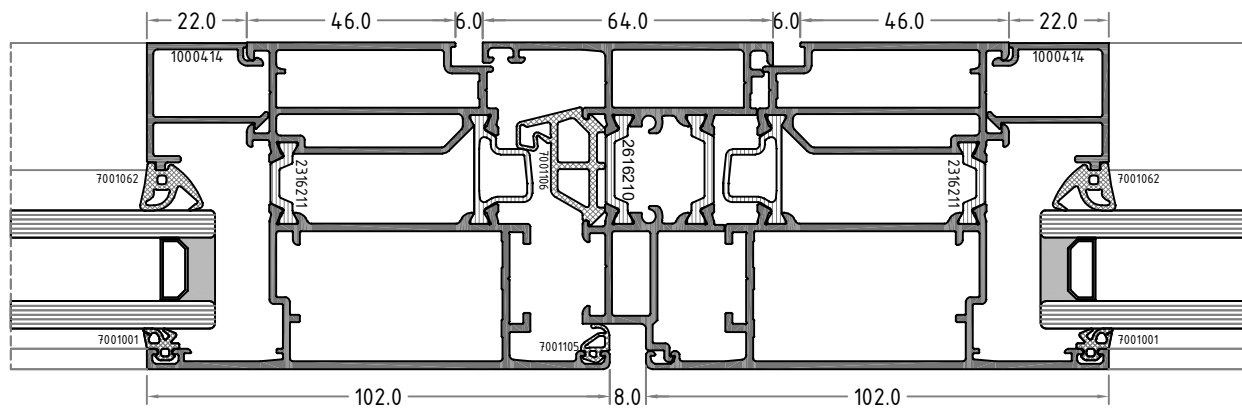


Usable Frames :

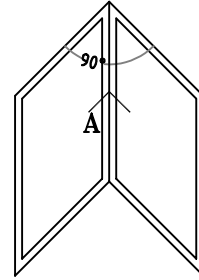
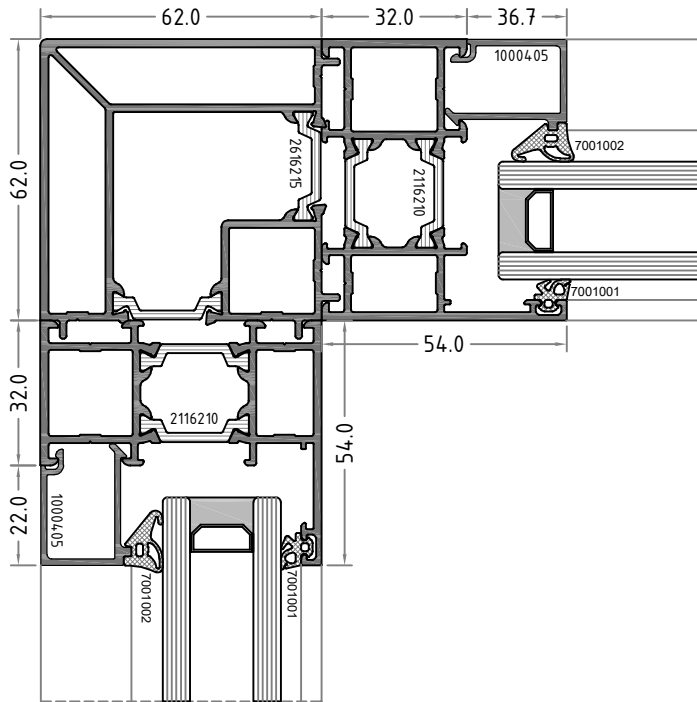
2116210 - 2116211 - 2116212

Usable Sash :

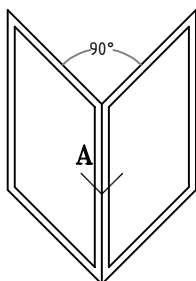
2316211



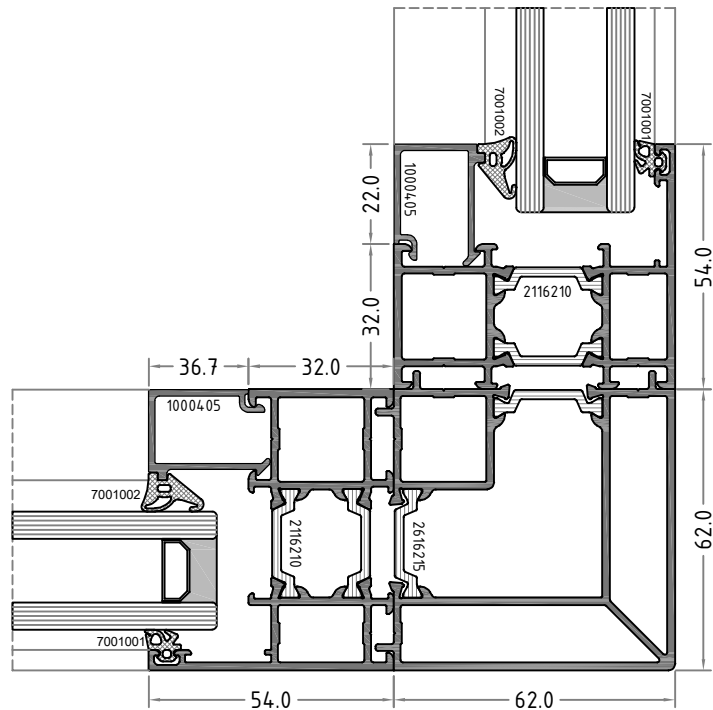
Section C

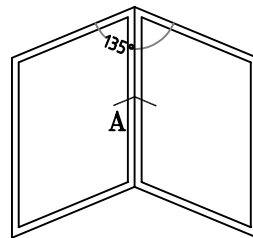


Inner 90 Degree Coupling

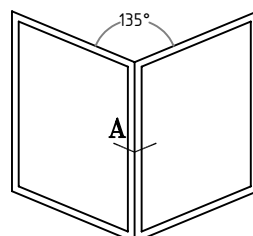
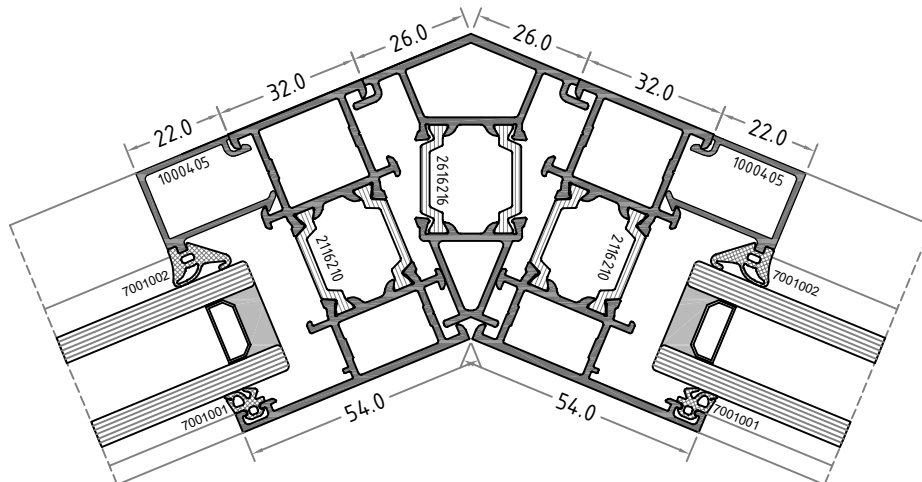


Outer 90 Degree Coupling

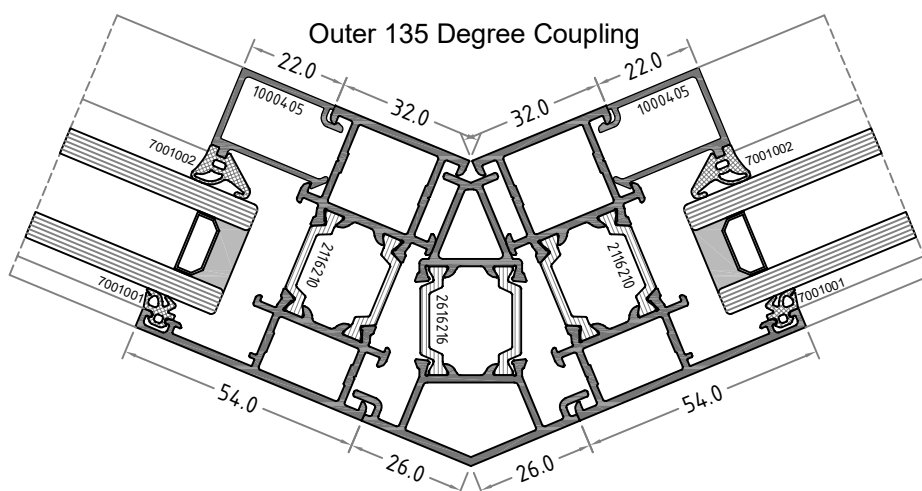


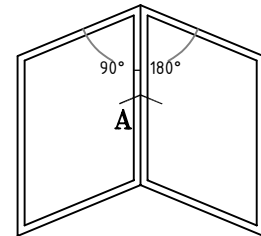
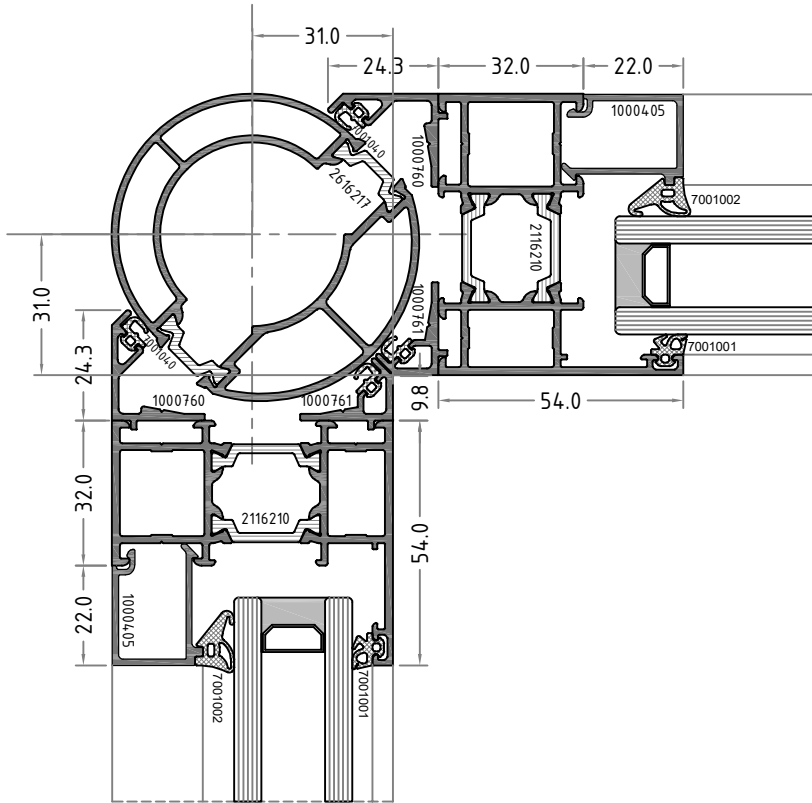


Inner 135 Degree Coupling

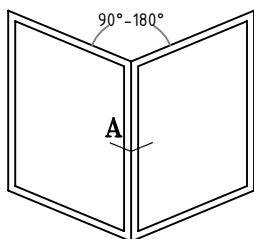


Outer 135 Degree Coupling

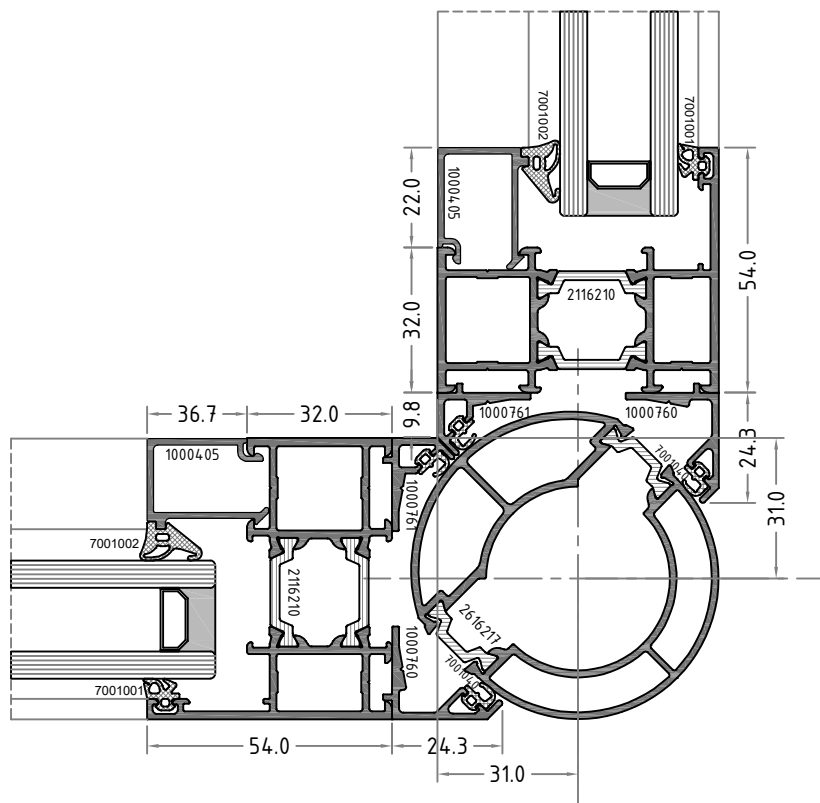




Inner Round Coupling



Outer Round Coupling



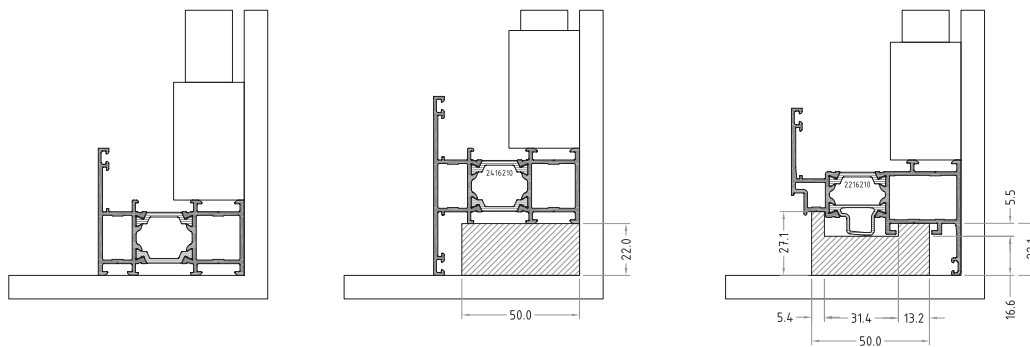
PROCESSING DATA

GC62

I. FABRICATION

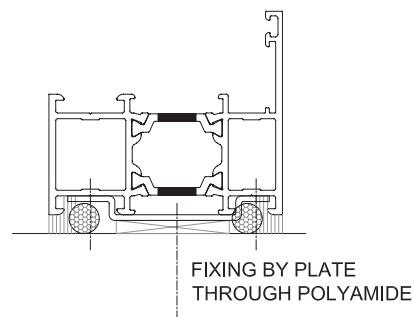
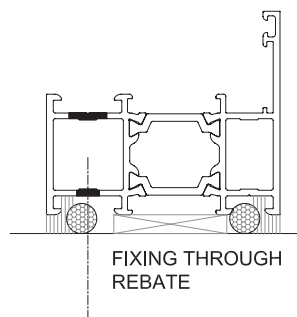
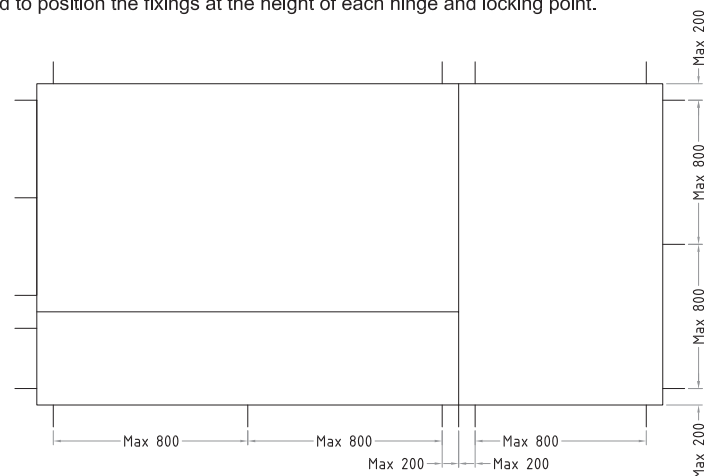
In order to have an acceptable and proper end products the processes should comply with the following guidelines

1. Removing dust and saw-dust for all mechanical operations such as sawing, milling, drilling, etc. For painted profiles it is essential that the paint coatings do not come off on the edges during these operations
2. The saw blades and metal-removing tools are appropriate and sufficiently sharp
3. The cooling agents and lubricants should be used sufficiently and correctly prescribed by the machine suppliers.
4. The correct clamp blocks are used



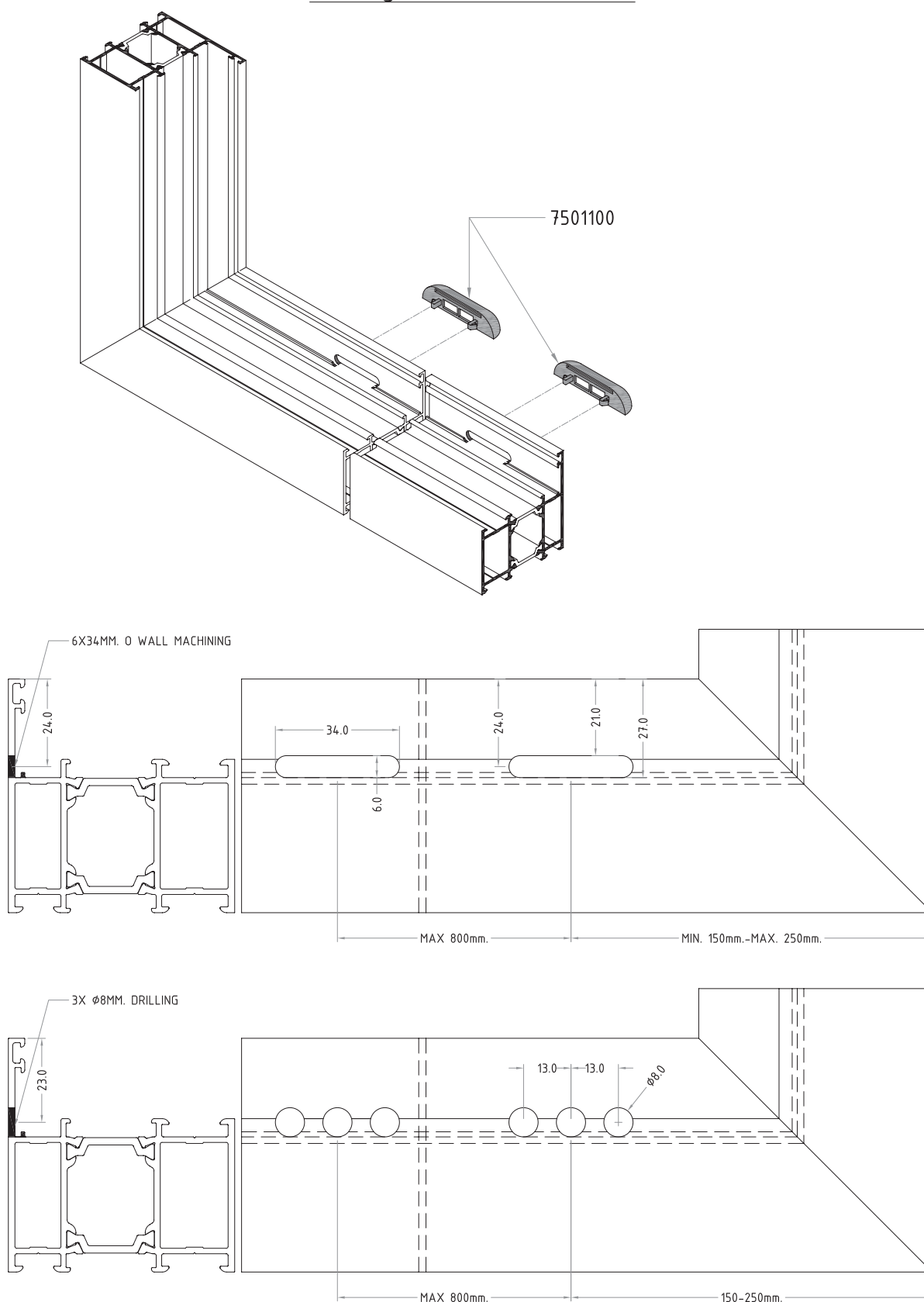
II. Installation

1. The fixing to the structural work is done either directly through the rebate of the profiles with stainless steel screws, or by means of fixing plates- The fixings may not be applied less than 40 mm from the edge of the wall of the structural work if there is no sub-frame.
2. All anchoring, as far as they are not made of aluminum or stainless steel, should be adequately corrosion protected and may not attack the aluminum themselves.
3. We recommend to position the fixings at the height of each hinge and locking point.



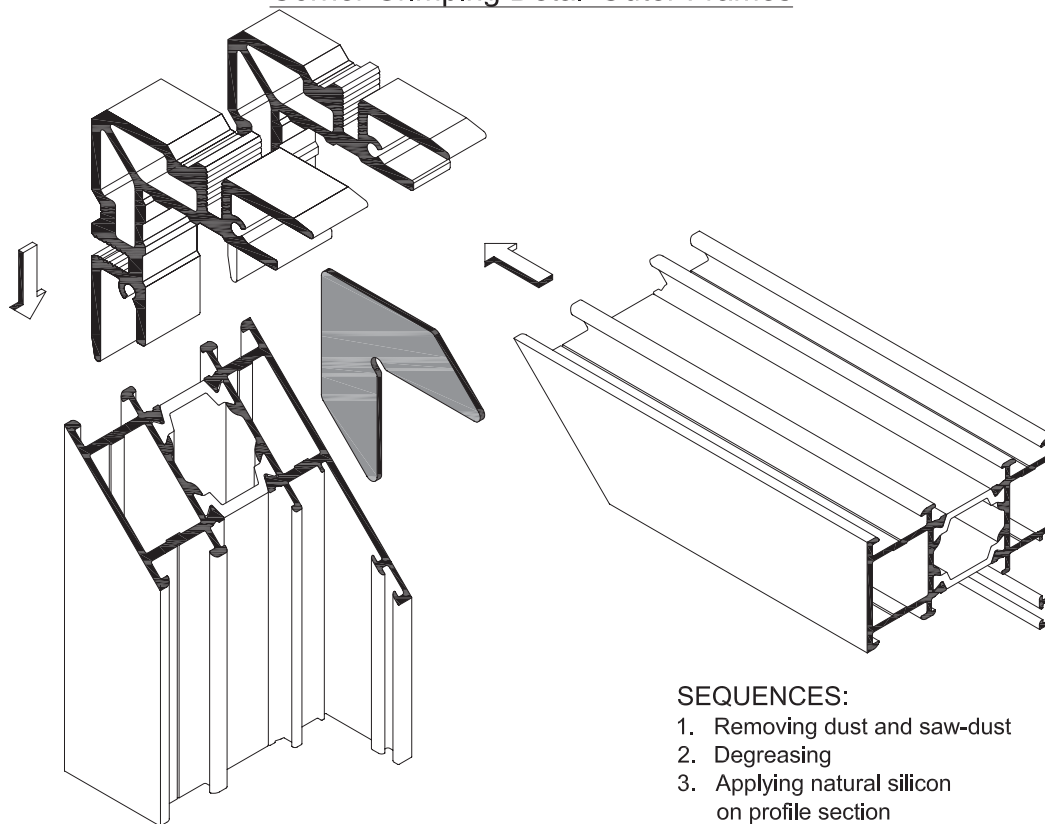
PROCESSING DATA

Drainage Detail Outer Frames



PROCESSING DATA

Corner Crimping Detail Outer Frames

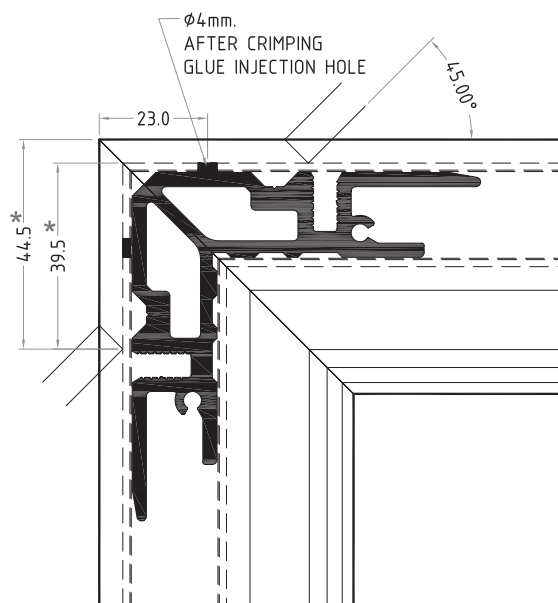
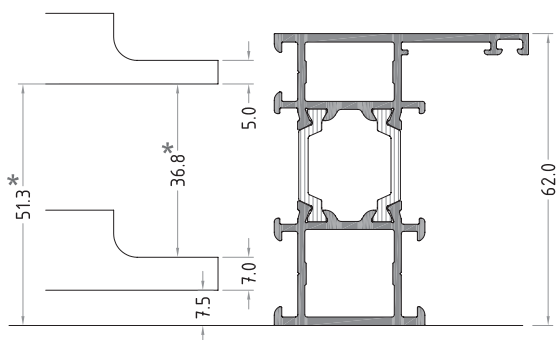


Outer Frame Number	Inner Corner Crimp	Outer Corner Crimp	Corner Alignment
2116210	5767182	5767122	7501020
2116211	5195182	5195122	7501020
2116212	5236182	5236122	7501020
2116213	5767182	5767122	7501020
2416210 *	5767182	5767122	7501020
2416211 *	5195182	5195122	7501020
2416212 *	5236182	5236122	7501020

* While using as pivot sash

SEQUENCES:

1. Removing dust and saw-dust
2. Degreasing
3. Applying natural silicon on profile section
4. Glue Injection
E.g. SikaForce®-479 L45
 - in the profile chamber
 - After crimping through injection hole
5. Assembling and crimping
6. Cleaning visible surfaces

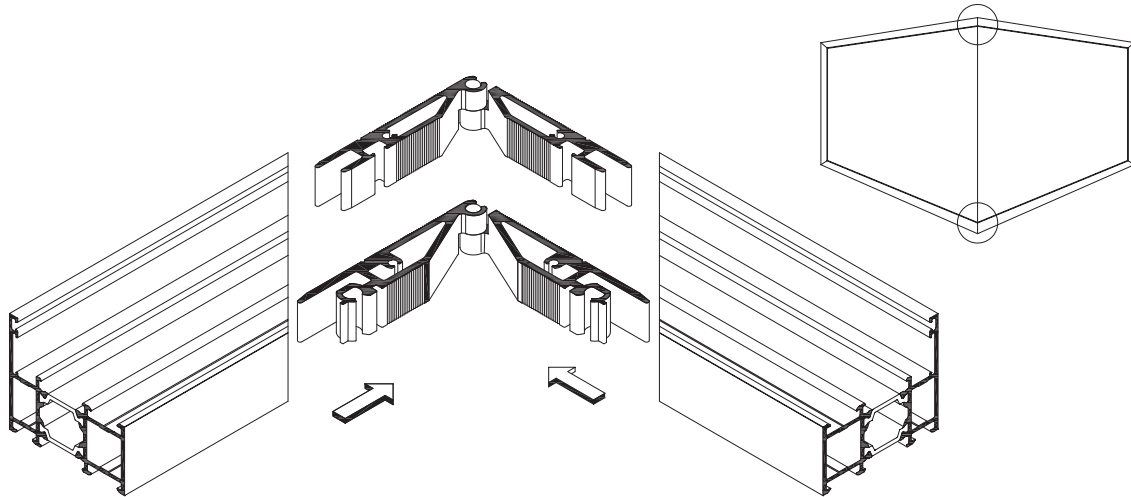


* Given dimensions is same for all the frames.

PROCESSING DATA

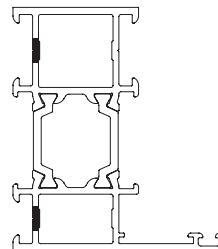
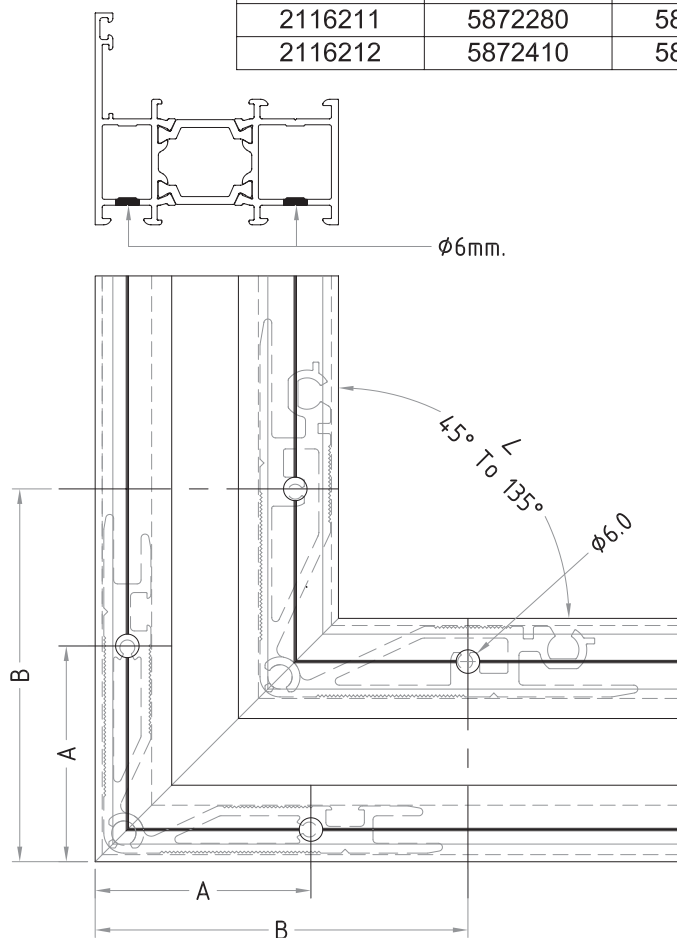
Glass joint corner assembly details

Inner corner



Frame Number	Inner Corner Joint	Outer Corner Joint
2116210	5872180	5871180
2116211	5872280	5871280
2116212	5872410	5871410

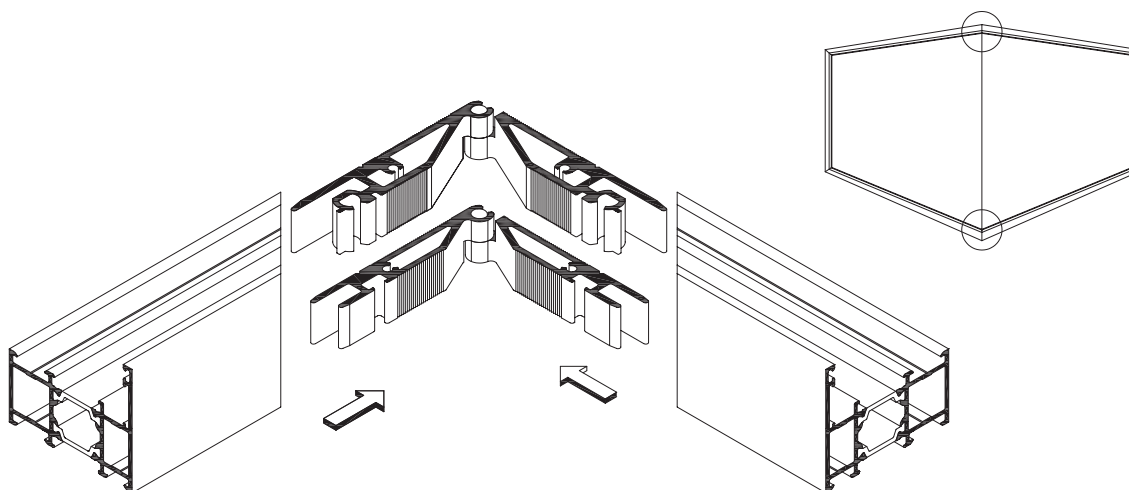
Angle	A	B
45	65.3	161.6
50	63.3	148.9
55	61.7	138.4
60	60.3	129.5
65	59.2	121.8
70	58.1	115.2
75	57.2	109.3
80	56.0	104.0
85	55.6	99.3
90	55.0	95.0
95	54.4	91.0
100	53.8	87.4
105	53.3	84.0
110	52.8	80.9
115	52.3	77.9
120	51.9	75.1
125	51.5	72.4
130	51.1	69.9
135	50.7	67.4



PROCESSING DATA

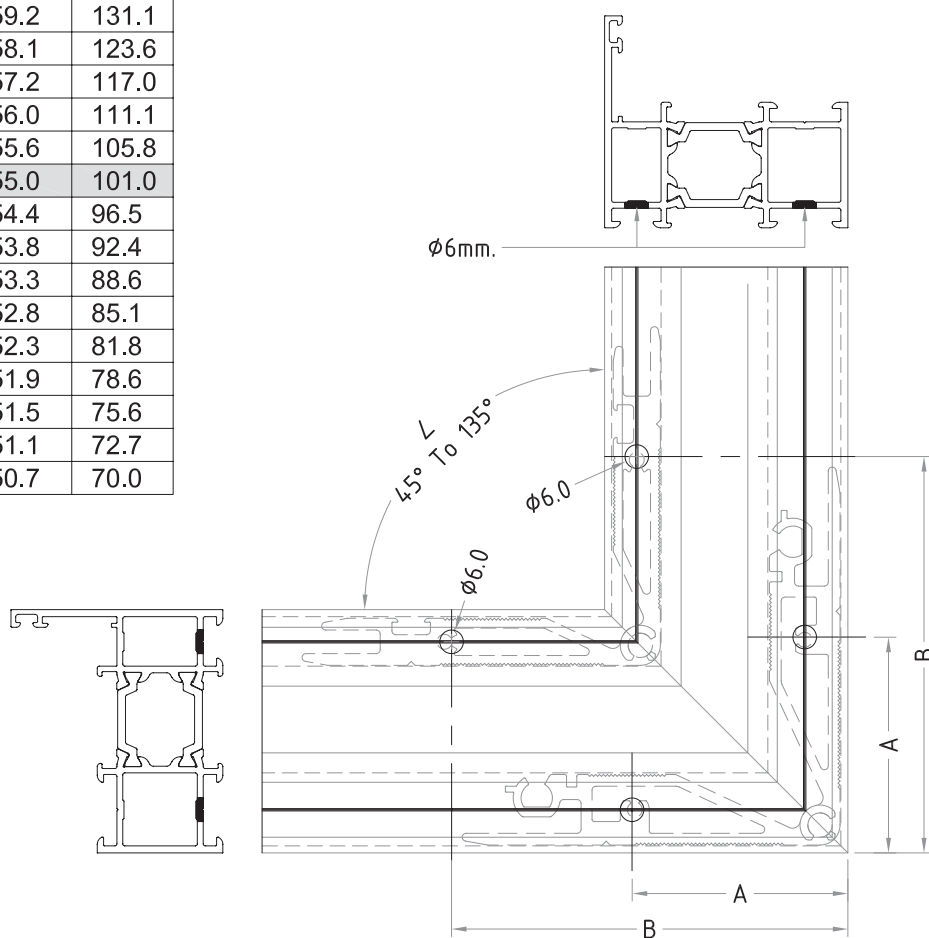
Glass joint corner assembly detail

Outer corner



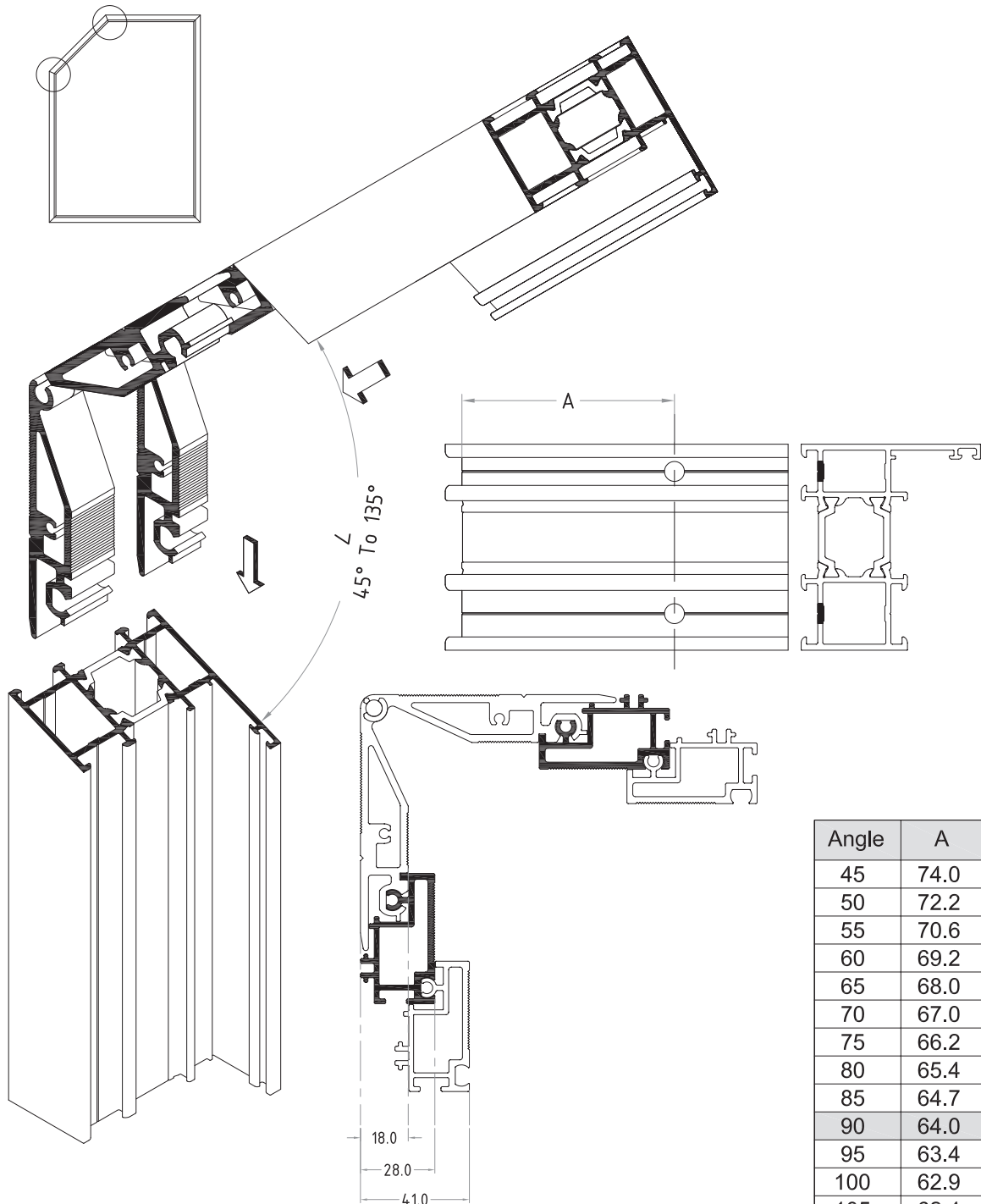
Angle	A	B
45	65.3	175.8
50	63.3	161.4
55	61.7	149.7
60	60.3	139.7
65	59.2	131.1
70	58.1	123.6
75	57.2	117.0
80	56.0	111.1
85	55.6	105.8
90	55.0	101.0
95	54.4	96.5
100	53.8	92.4
105	53.3	88.6
110	52.8	85.1
115	52.3	81.8
120	51.9	78.6
125	51.5	75.6
130	51.1	72.7
135	50.7	70.0

Frame Number	Inner Corner Joint	Outer Corner Joint
2116210	5872180	5871180
2116211	5872280	5871280
2116212	5872410	5871410



PROCESSING DATA

Angular corner
Outer frames



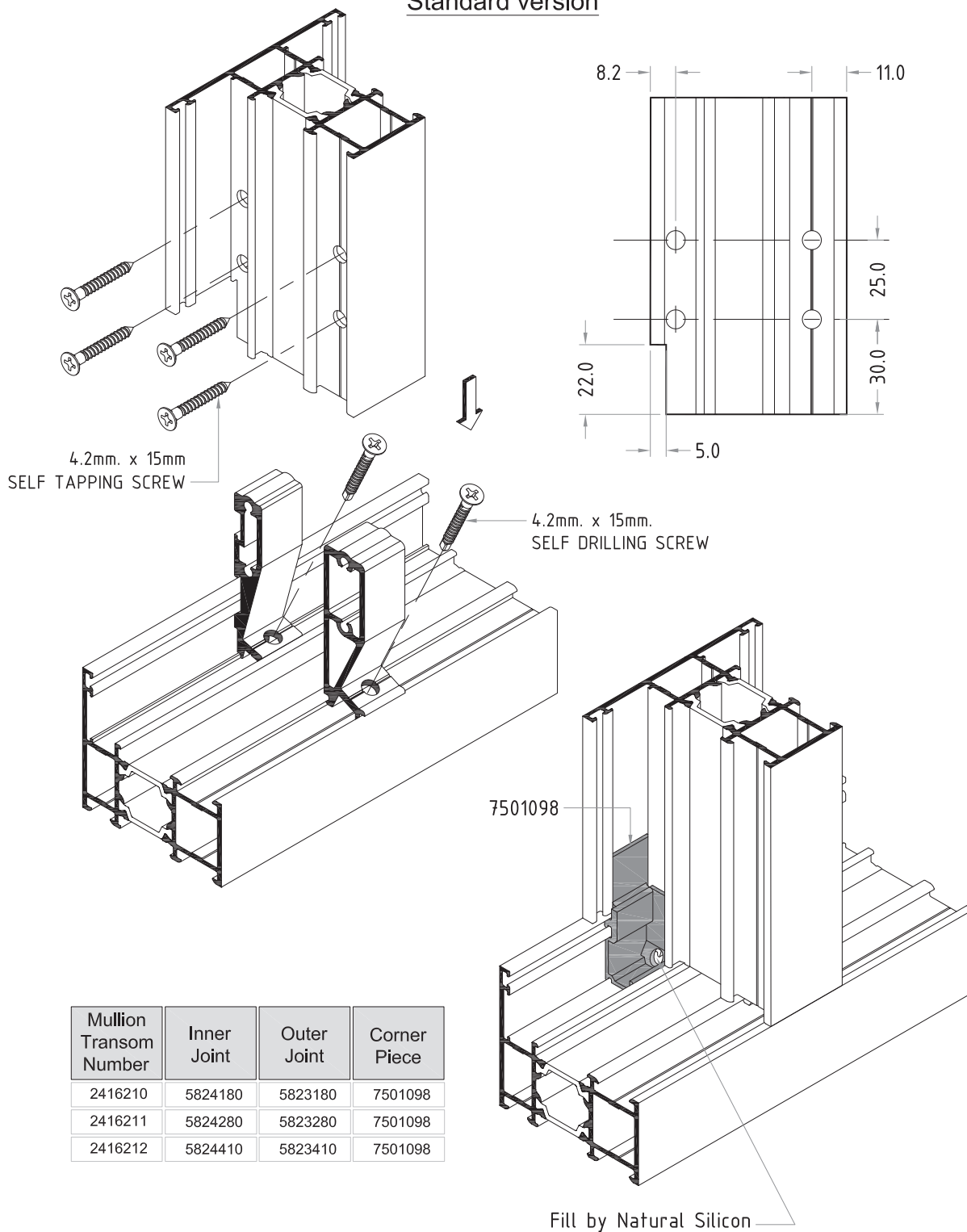
Frame Number	Inner Corner Joint	Outer Corner Joint
2116210	5872180	5872120
2116211	5872180 + 2 x (5873180)	5872120 + 2 x (5873120)
2116212	5872180 + 4 x (5873180)	5872120 + 4 x (5873120)

Angle	A
45	74.0
50	72.2
55	70.6
60	69.2
65	68.0
70	67.0
75	66.2
80	65.4
85	64.7
90	64.0
95	63.4
100	62.9
105	62.4
110	61.9
115	61.4
120	61.0
125	60.6
130	60.2
135	59.8

Processing Data

Mullion/Transom Connection detail

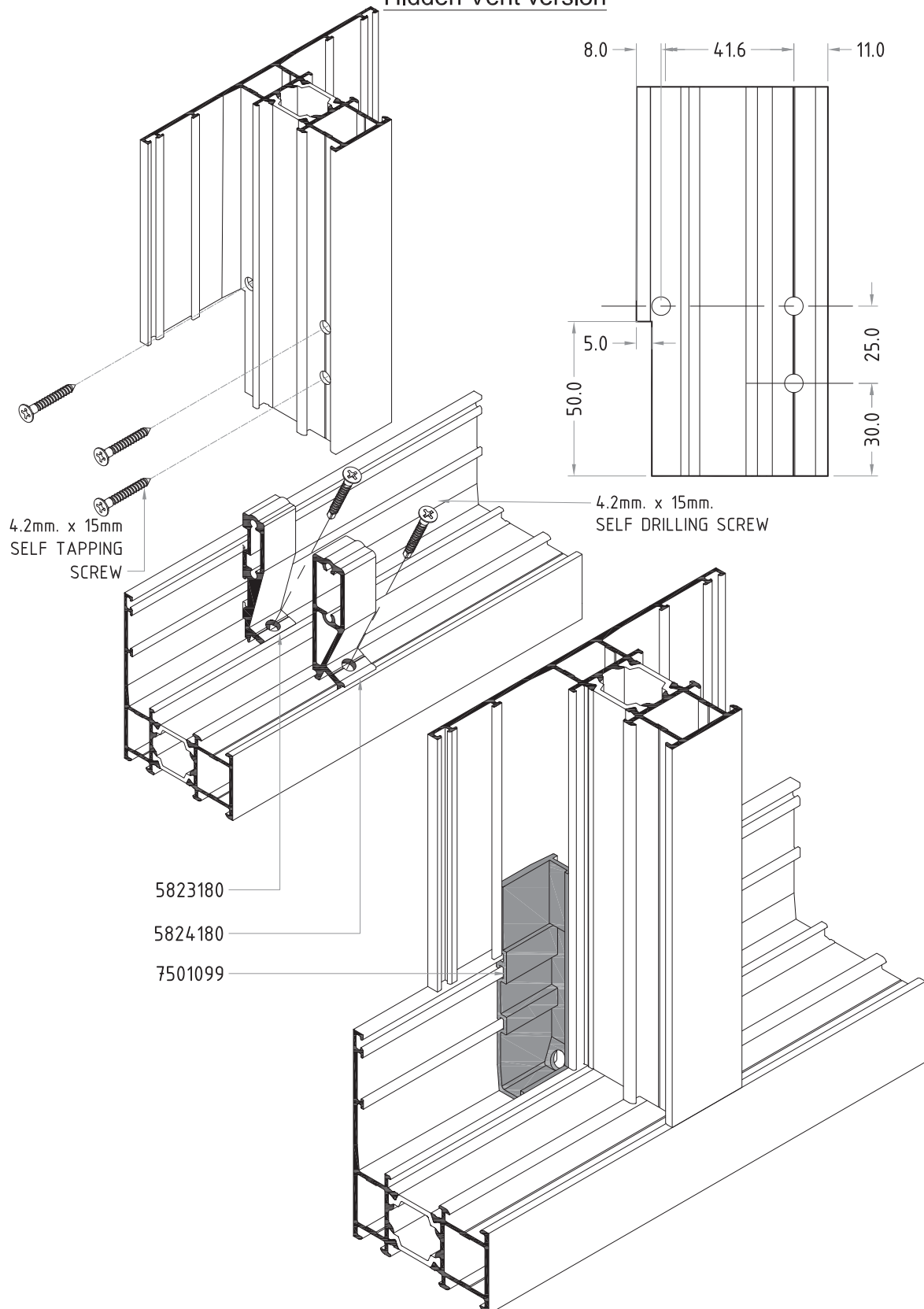
Standard version



Processing Data

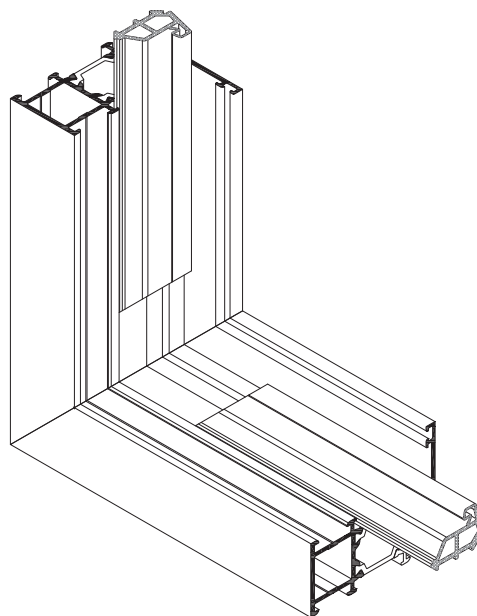
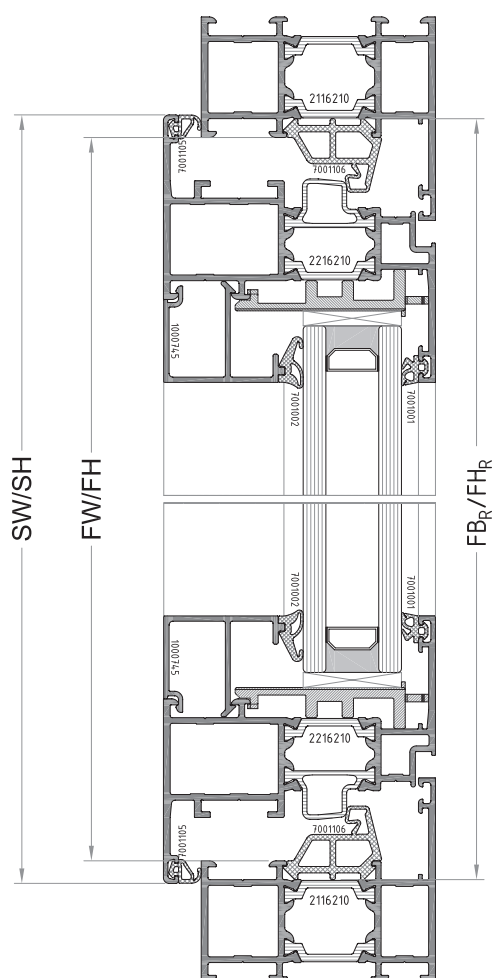
Mullion/Transom Connection detail

Hidden Vent version



PROCESSING DATA

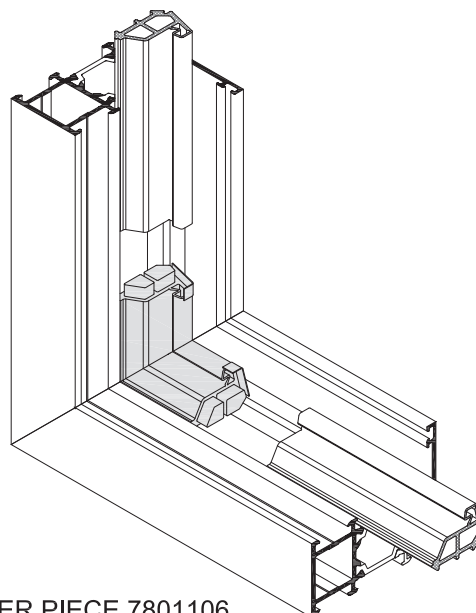
GC62 CENTRAL GASKET



MITER CUT

$$FB_R/FH_R = (SW/SH - 2mm.) \times 1.003$$

$$FB_R/FH_R = (FW/FH + 8mm.) \times 1.003$$



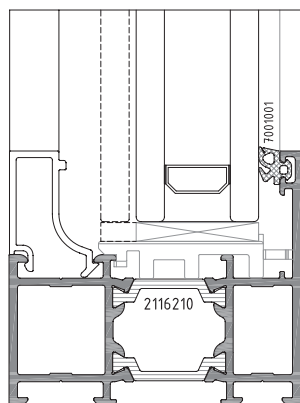
USING CORNER PIECE 7801106

$$FB_R/FH_R = (SW/SH - 42mm.) \times 1.003$$

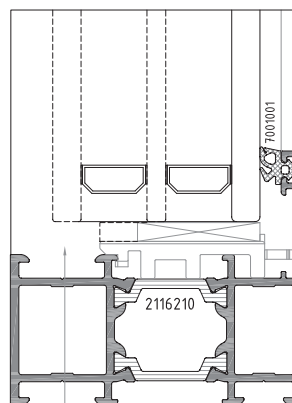
$$FB_R/FH_R = (SW/SH - 32mm.) \times 1.003$$

PROCESSING DATA

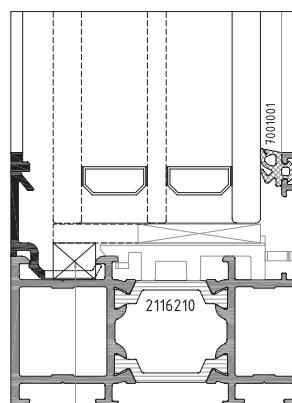
Additional glazing support



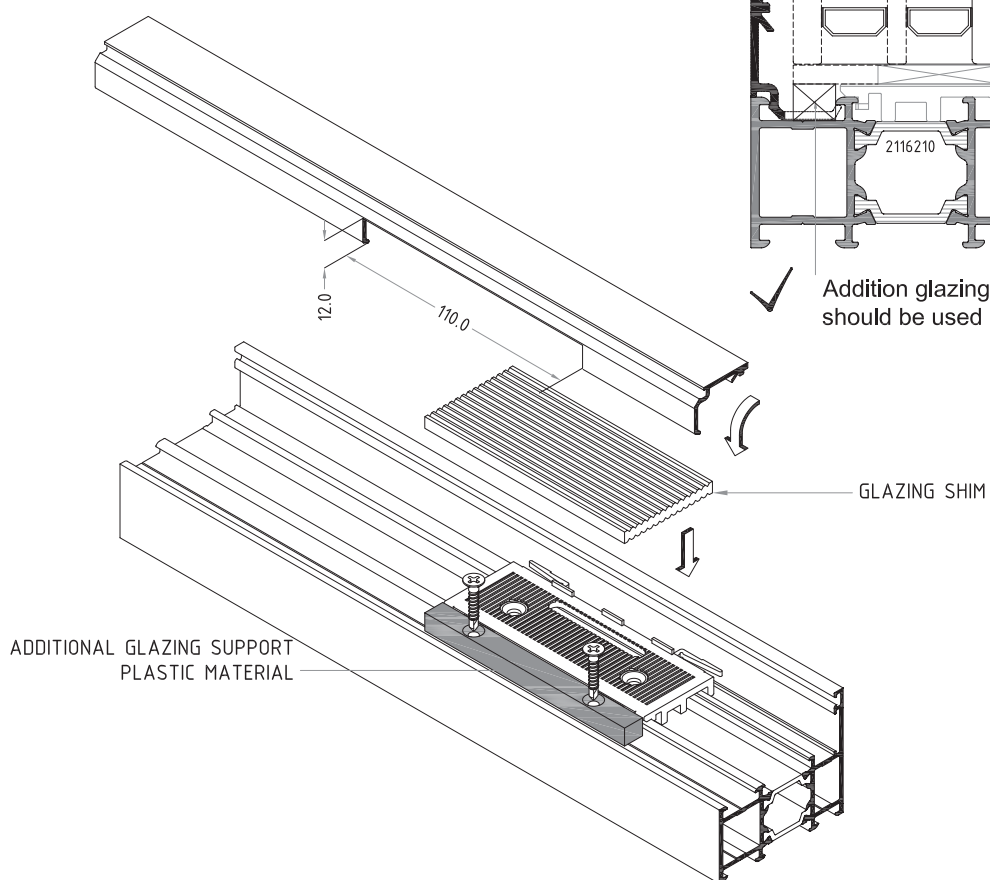
✓ Up to 34mm. glazing



✗ Full depth of glazing must be supported

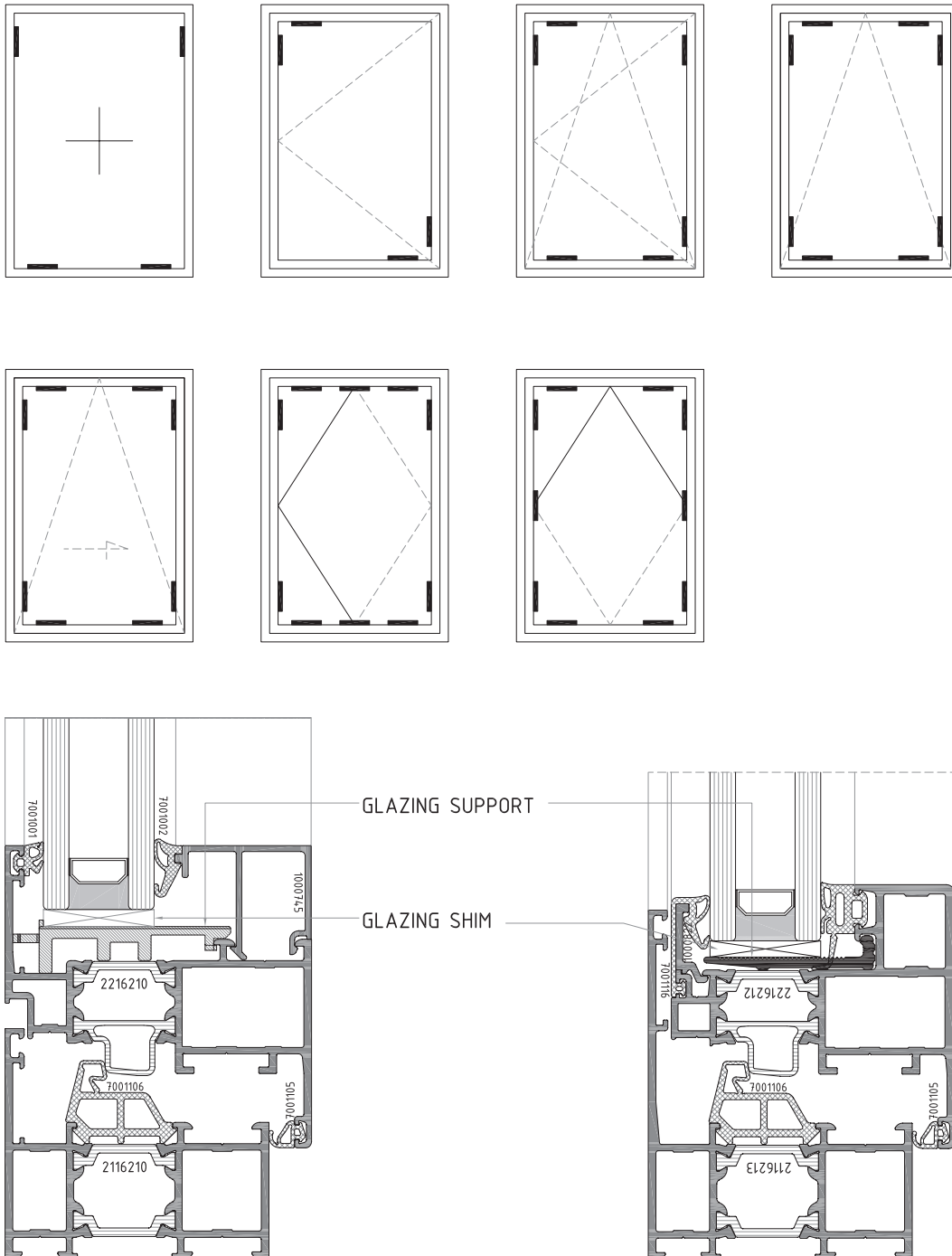


✓ Addition glazing support should be used



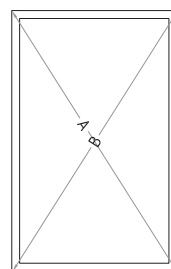
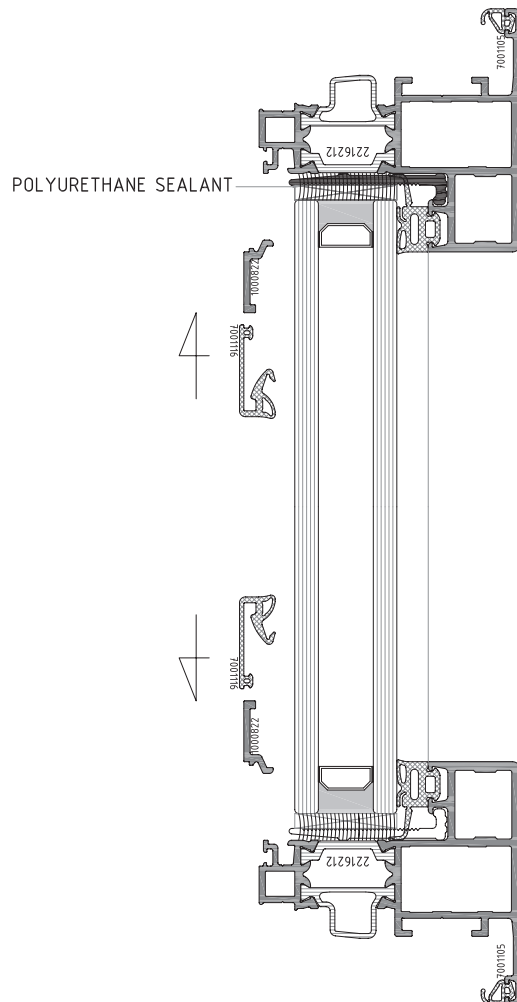
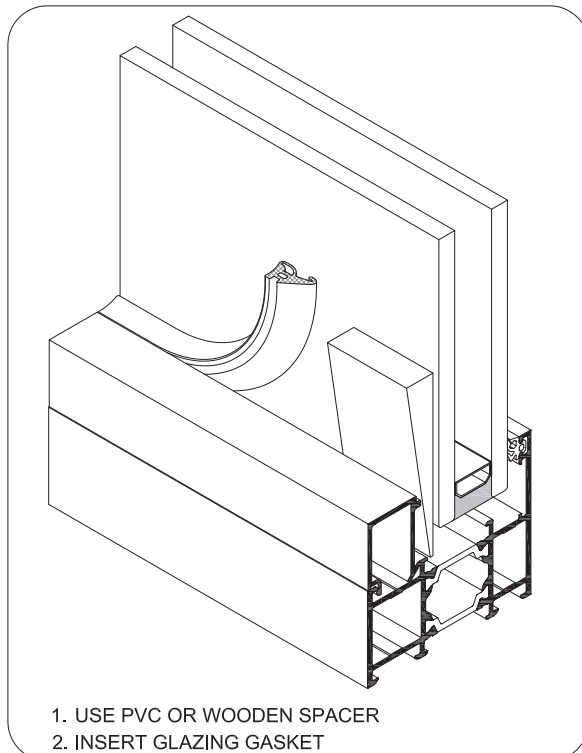
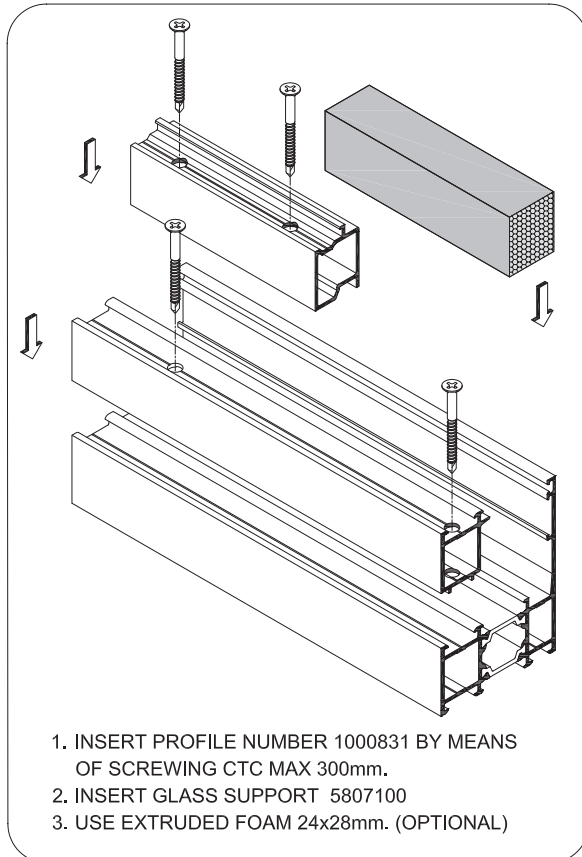
PROCESSING DATA

Glazing support-shim positions

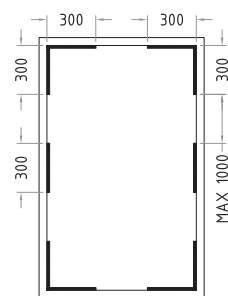


PROCESSING DATA

Glazing Methods



CHECK DIAGONAL
SIZE
A - B = MAX 2mm.

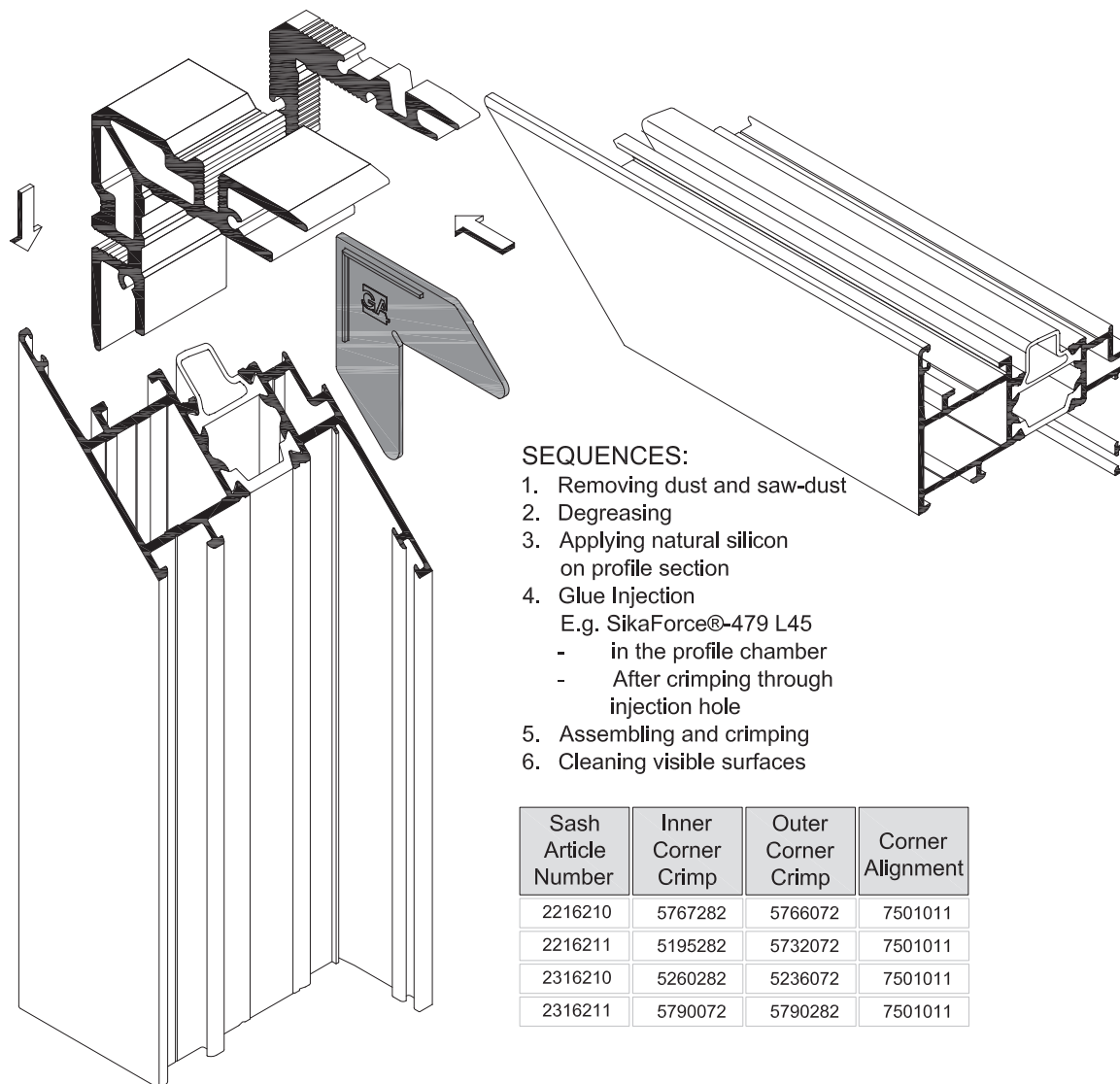


SCHEMATIC VIEW
OF ADHESIVE
APPLICATION

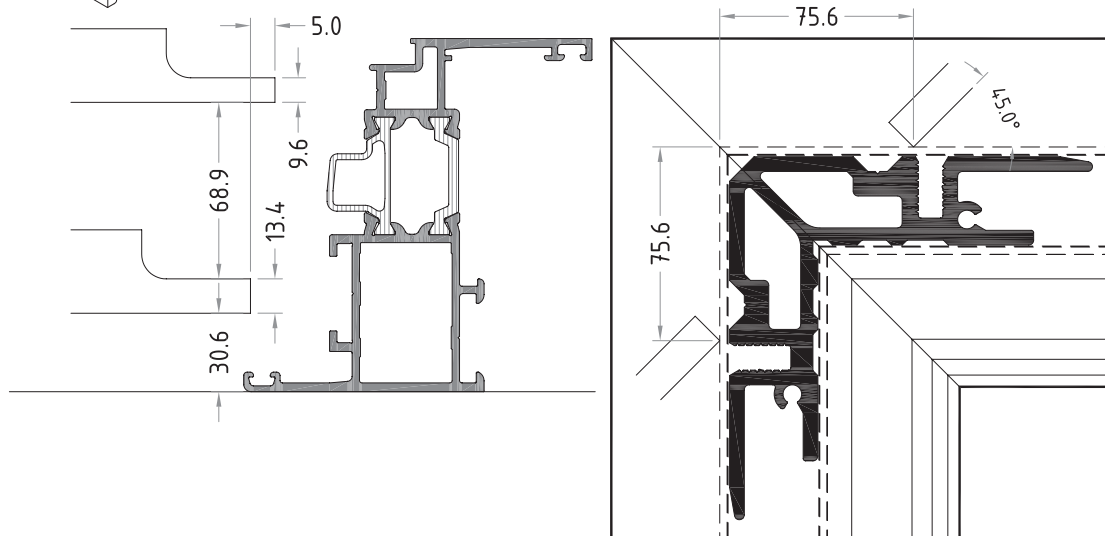
24h Curing Time

PROCESSING DATA

SASH CORNER CRIMPING DETAIL

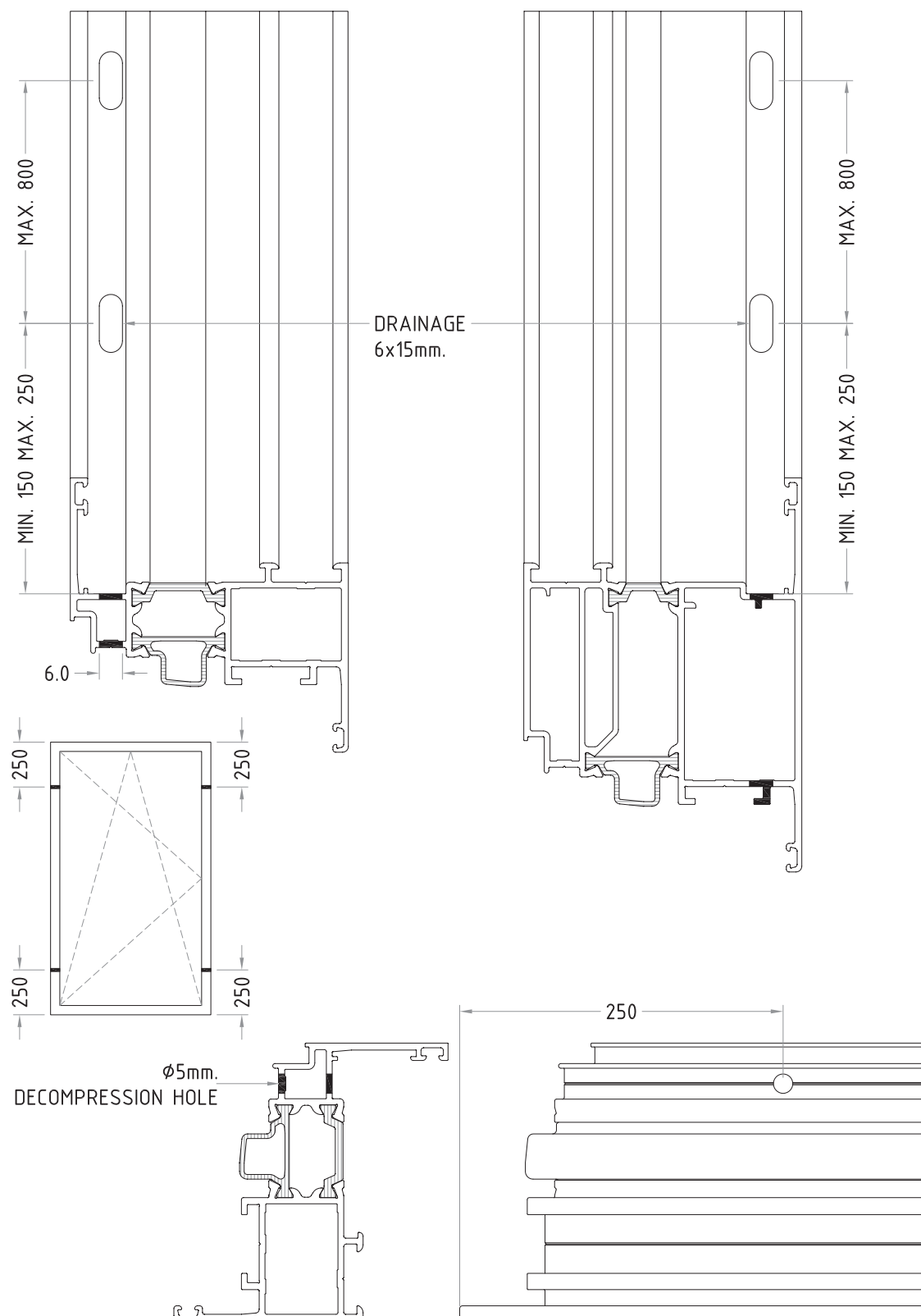


Sash Article Number	Inner Corner Crimp	Outer Corner Crimp	Corner Alignment
2216210	5767282	5766072	7501011
2216211	5195282	5732072	7501011
2316210	5260282	5236072	7501011
2316211	5790072	5790282	7501011



PROCESSING DATA

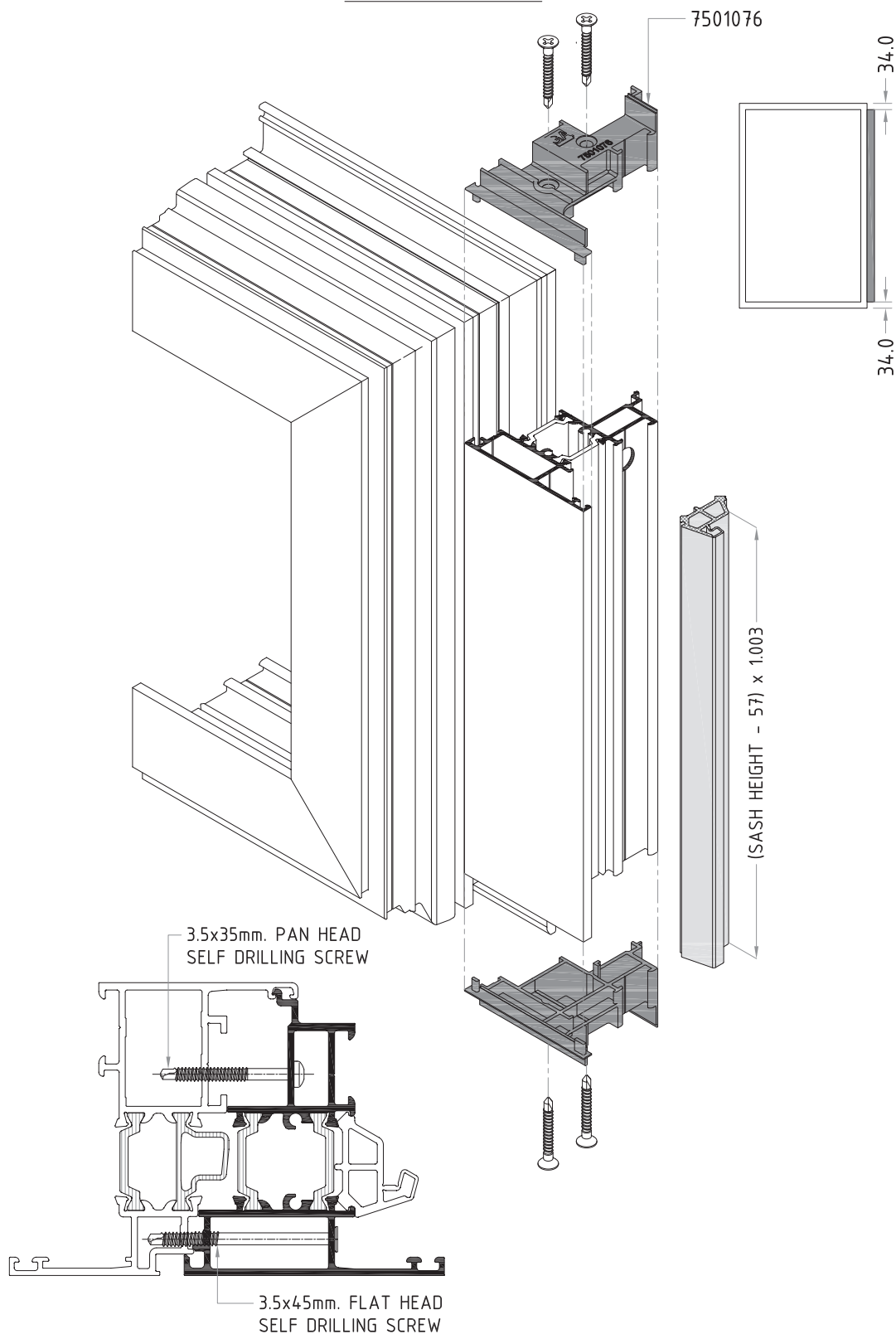
Sash drainage, Decompression hole



PROCESSING DATA

French window meeting profile

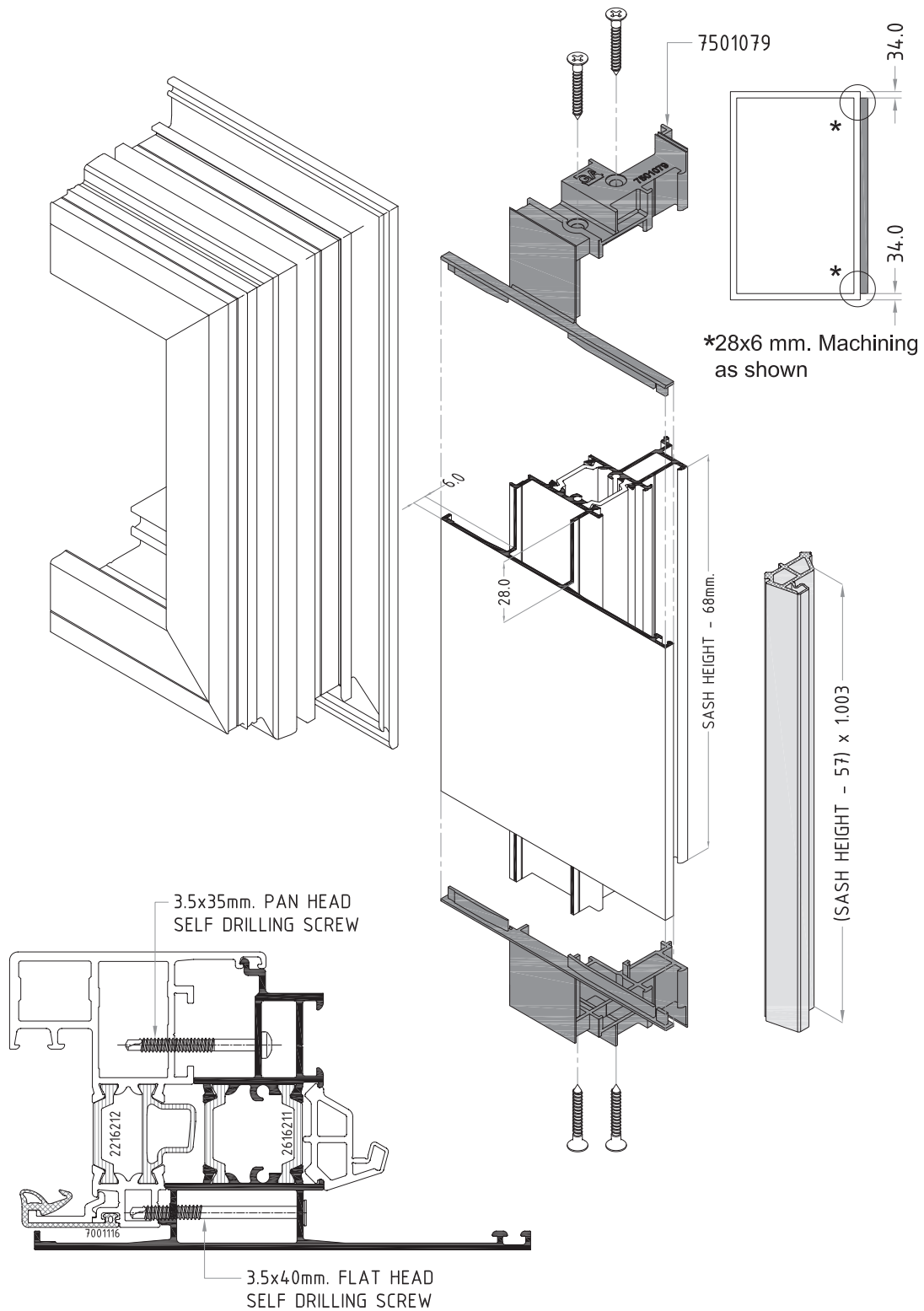
Standard version



PROCESSING DATA

French window meeting profile

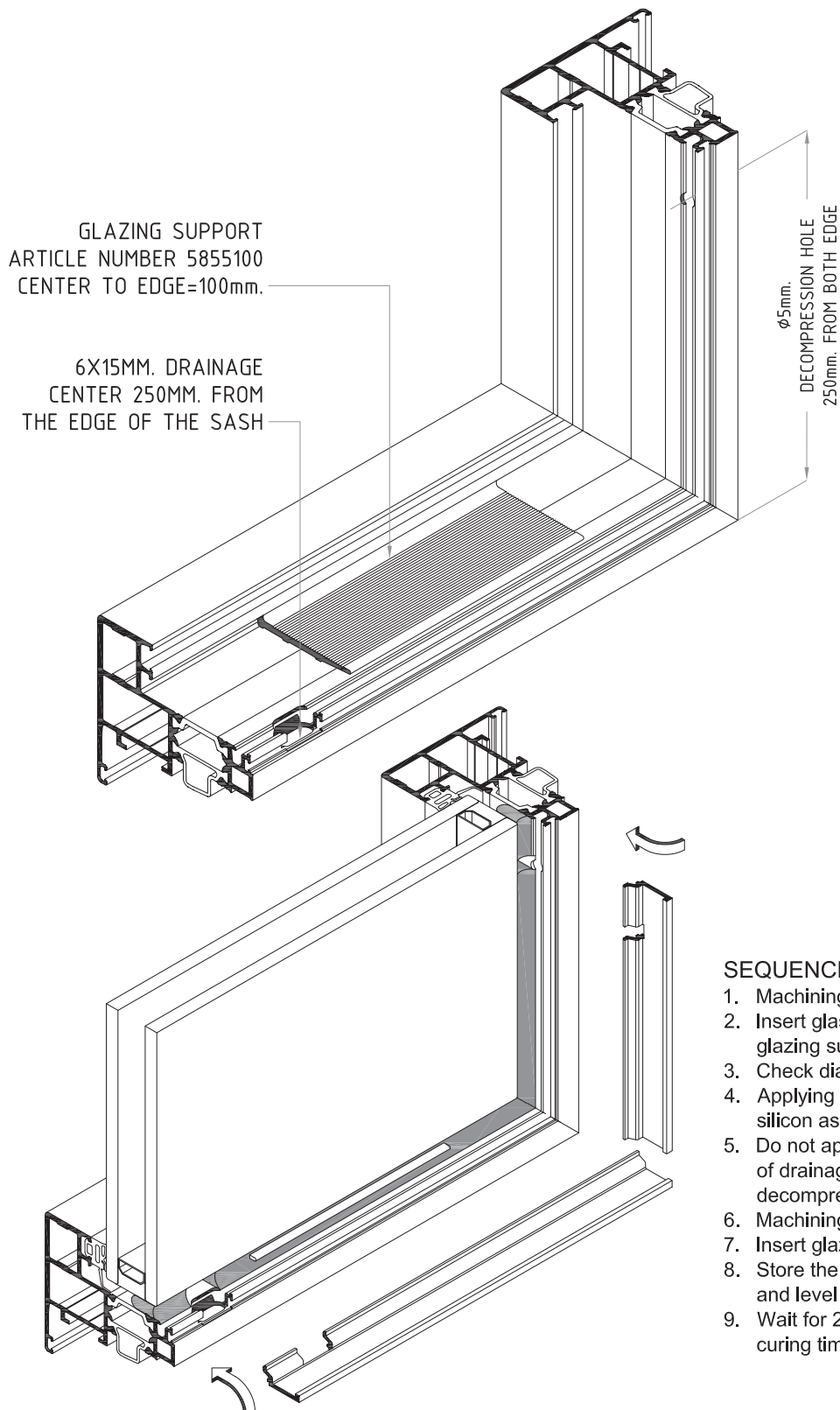
Hidden vent version



PROCESSING DATA

Hidden vent version glazing detail

Decompression hole

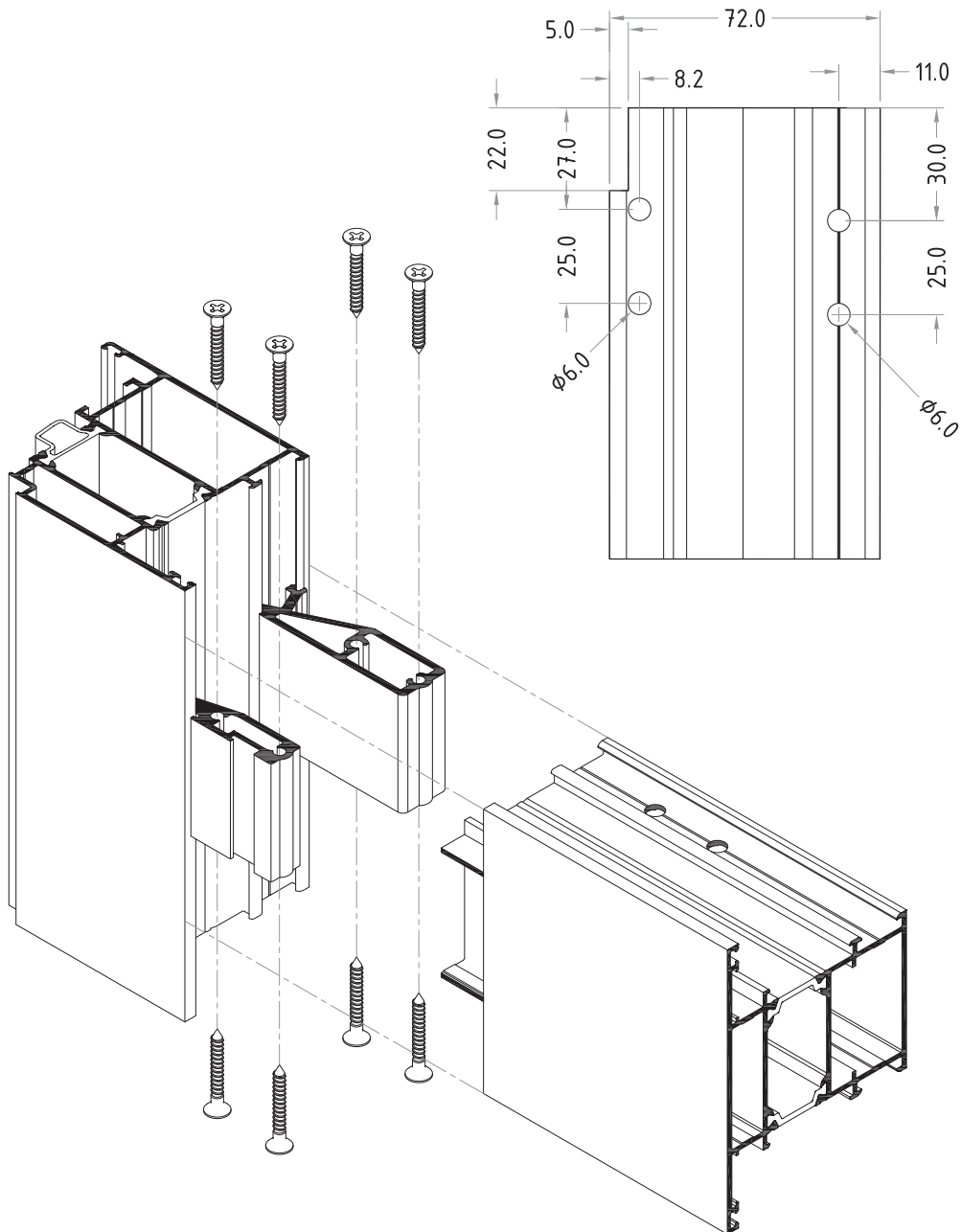


SEQUENCES:

1. Machining as details
2. Insert glass support as glazing support-shim detail
3. Check diagonals
4. Applying polyurethane silicon as detail
5. Do not apply silicon in front of drainage and decompression holes
6. Machining the glazing bead
7. Insert glazing beads
8. Store the sash in secure and level place .
9. Wait for 24 hours (silicon curing time)

PROCESSING DATA

Sash mullion/transom connection detail

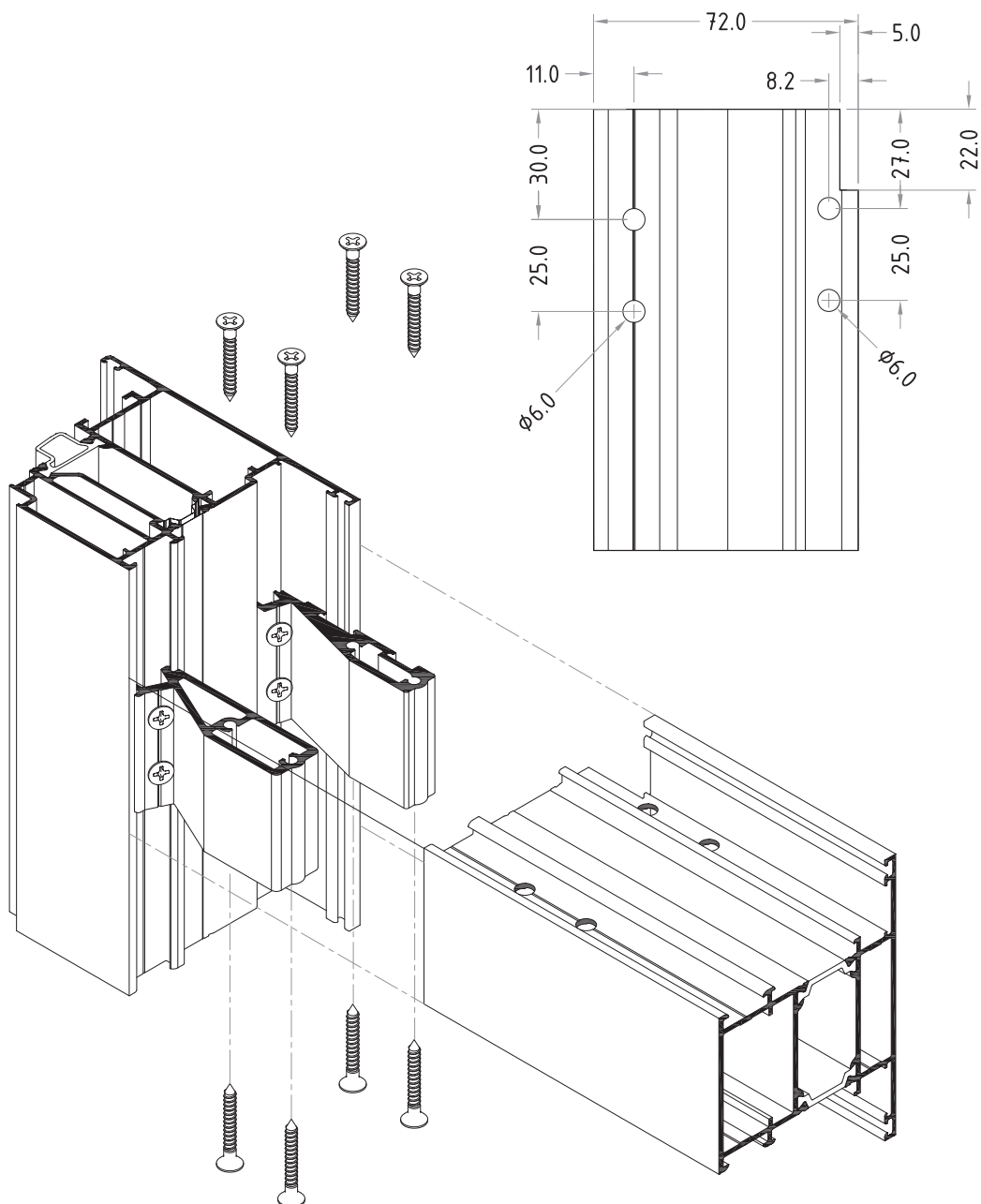


Mullion Transom Number	Inner Joint	Outer Joint	Connection Screws	Screw Type	Screw Quantity
2416215	5824180	5823180	4.2 x 10 mm.	Flat head self tapping	8 Pcs.
2416216	5824410	5823410	4.2 x 20 mm.	Flat head self tapping	8 Pcs.

PROCESSING DATA

Sash mullion/transom connection detail

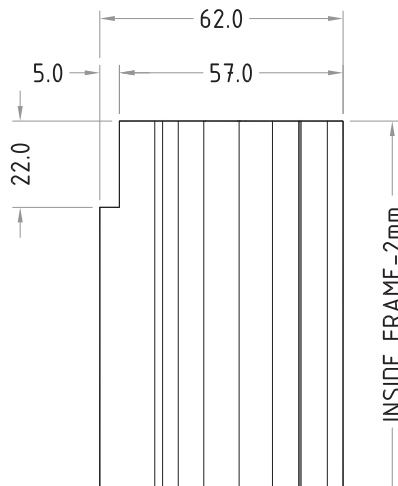
Outward opening sash



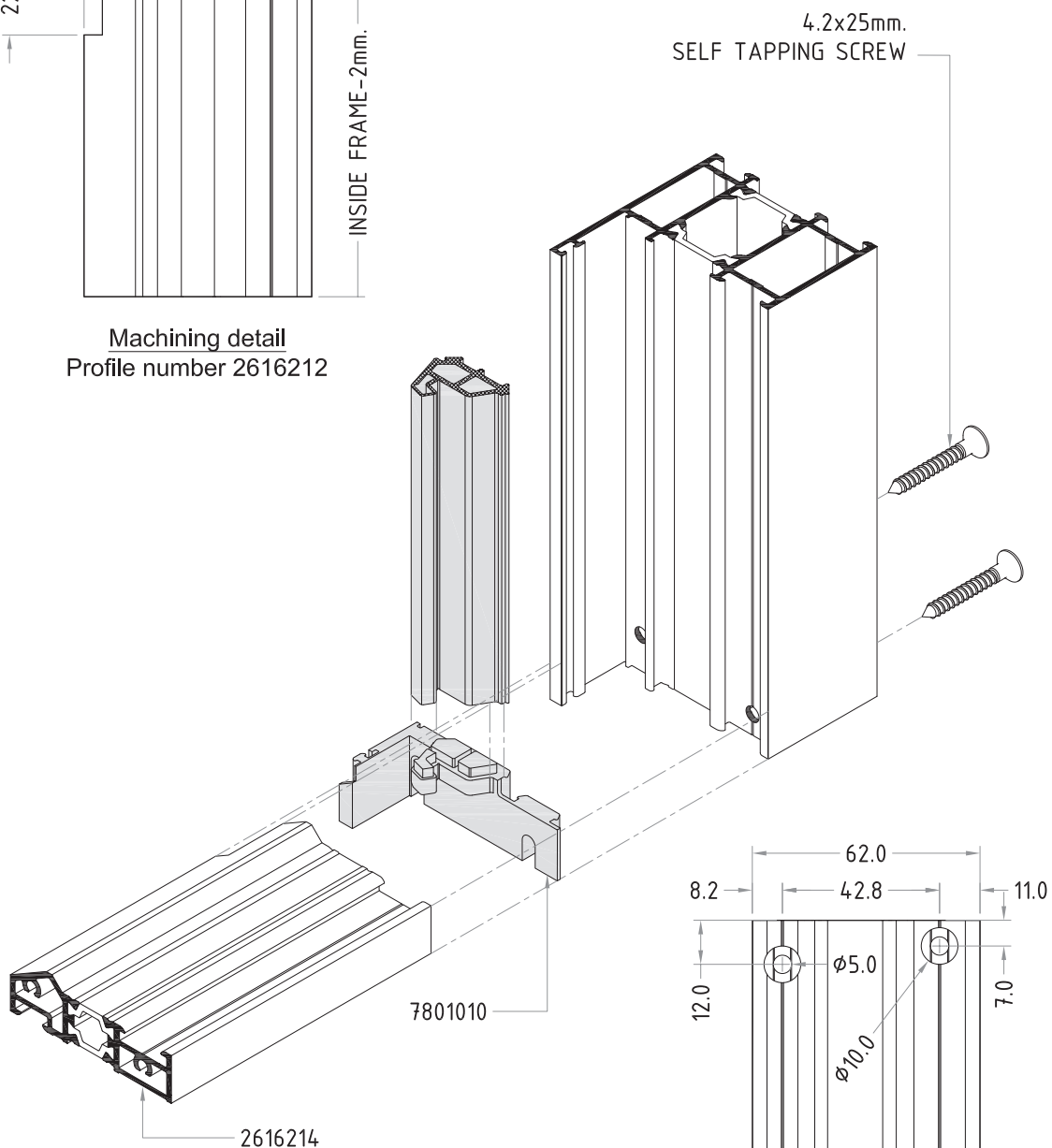
Mullion Transom Number	Inner Joint	Outer Joint	Connection Screws	Screw Type	Screw Quantity
2416215	5824180	5823180	4.2 x 10 mm.	Flat head self tapping	8 Pcs.
2416216	5824410	5823410	4.2 x 20 mm.	Flat head self tapping	8 Pcs.

PROCESSING DATA

Low threshold balcony doors



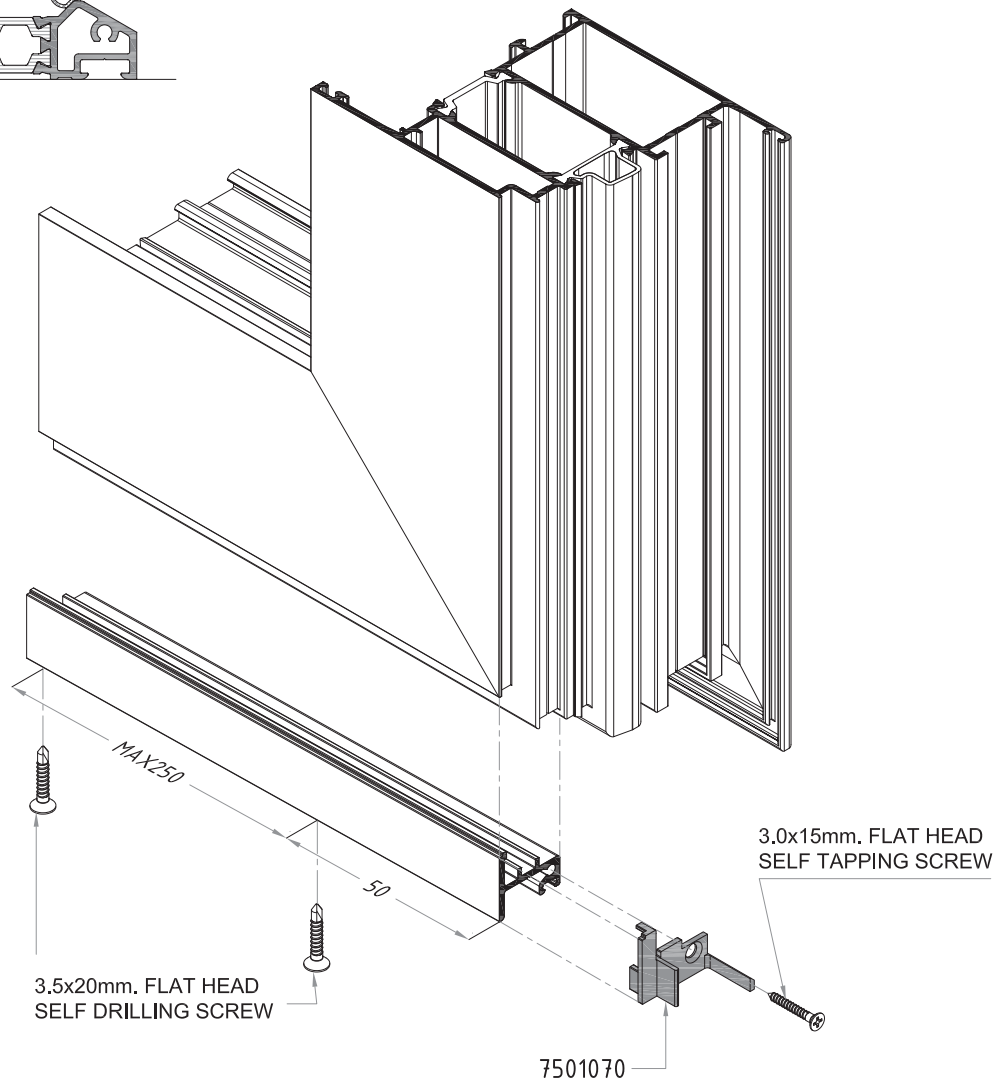
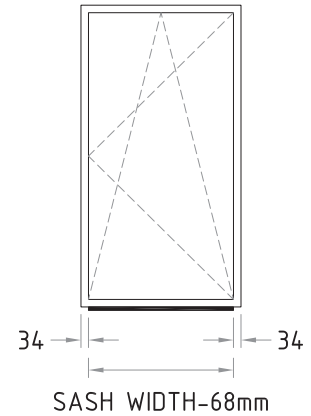
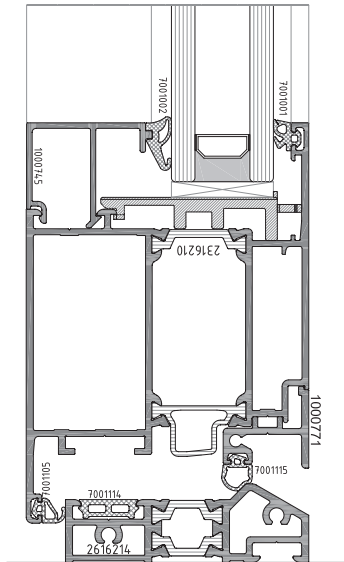
Machining detail
Profile number 2616212



Frame drilling detail

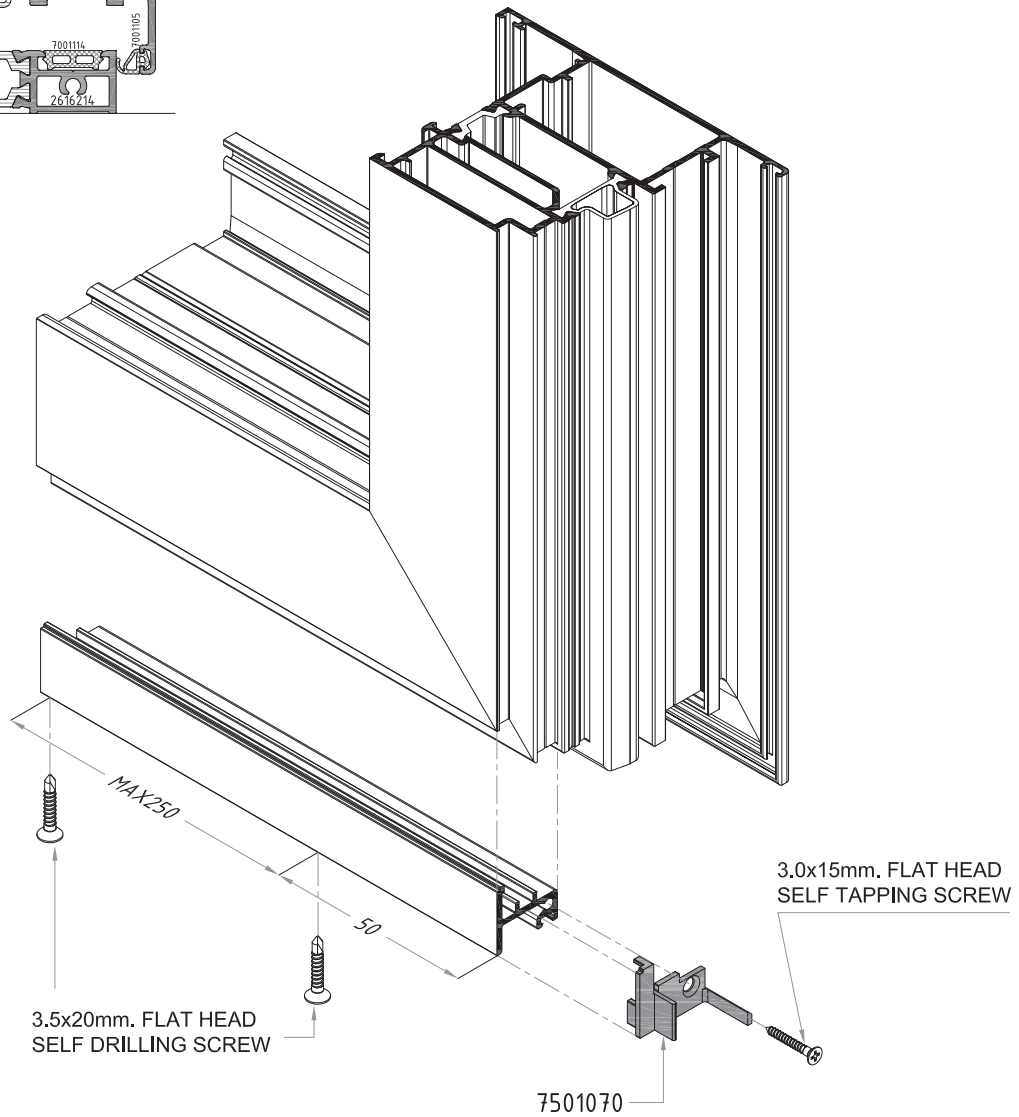
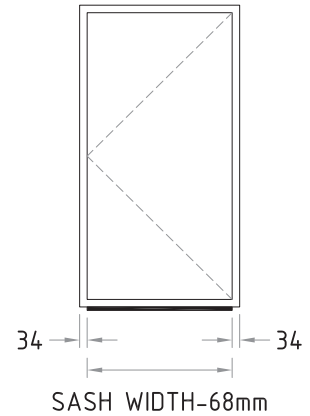
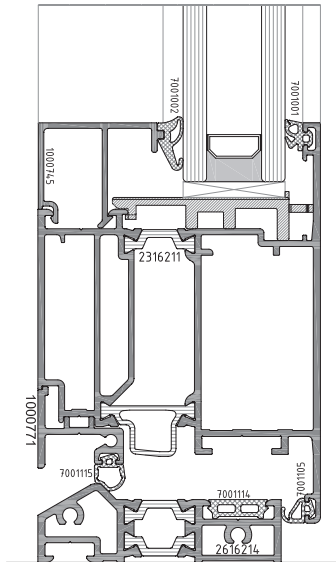
PROCESSING DATA

Low threshold balcony doors



PROCESSING DATA

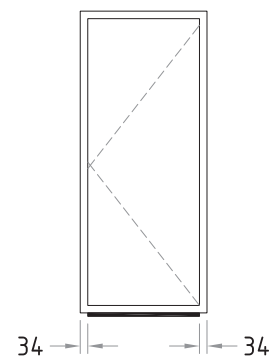
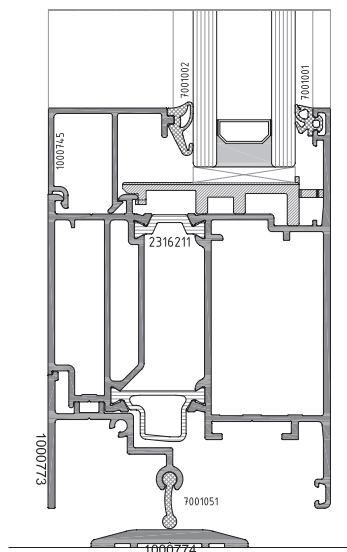
Low threshold balcony doors



PROCESSING DATA

Zero threshold entrance doors

Outward Opening



PROFILE NUMBER 1000774
SASH WIDTH - 68mm.

GASKET NUMBER 7001051
SASH WIDTH - 24mm.

3.5x20mm. FLAT HEAD
SELF DRILLING SCREW

PROFILE NUMBER 1000774
SASH WIDTH - 6mm.

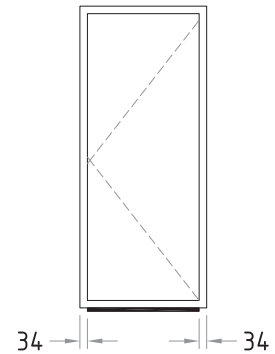
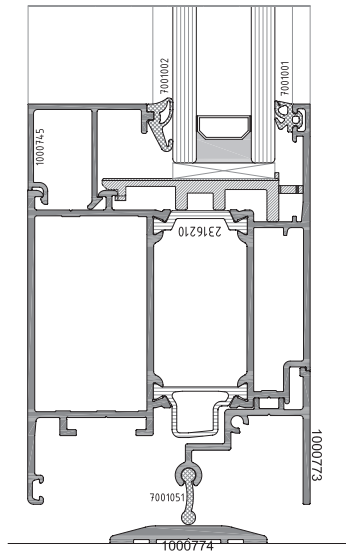
7501071

3.0x15mm. FLAT HEAD
SELF TAPPING SCREW

PROCESSING DATA

Zero threshold entrance doors

Inward Opening



PROFILE NUMBER 1000774
SASH WIDTH - 68mm.

GASKET NUMBER 7001051
SASH WIDTH - 24mm.

3.5x20mm. FLAT HEAD
SELF DRILLING SCREW

PROFILE NUMBER 1000774
SASH WIDTH - 6mm.

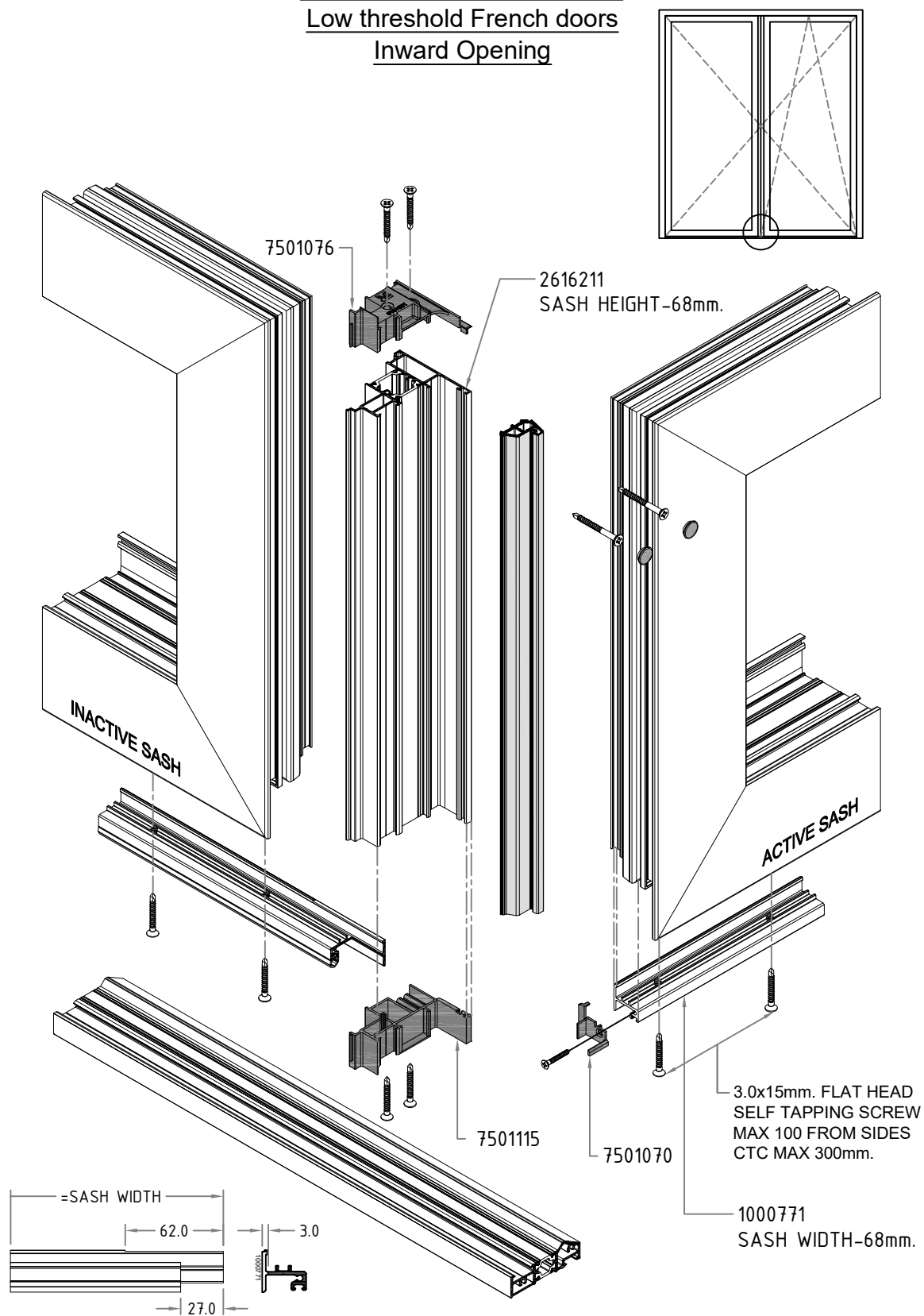
3.0x15mm. FLAT HEAD
SELF TAPPING SCREW

7501071

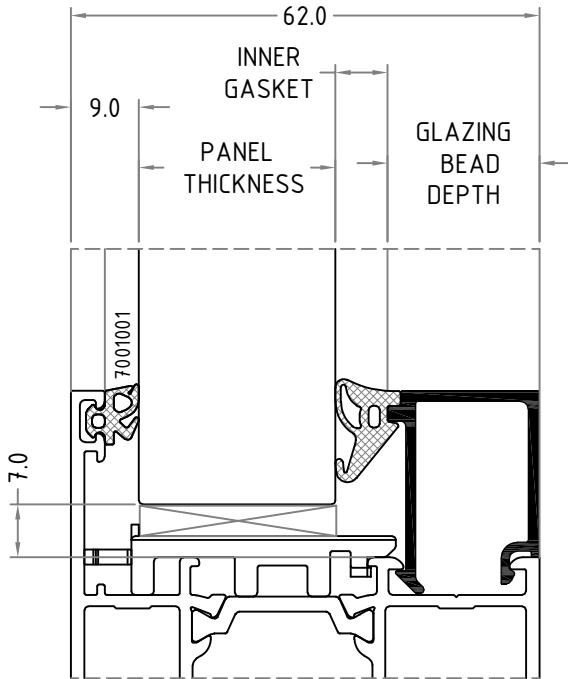
PROCESSING DATA

Low threshold French doors

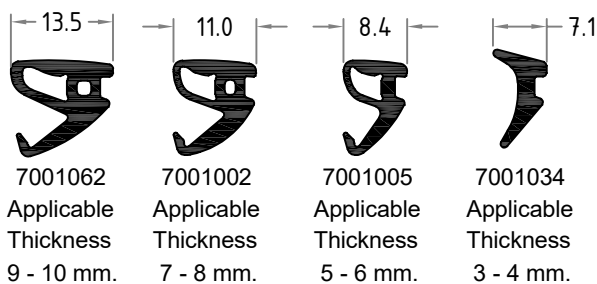
Inward Opening



GC 62 Glazing Table
Frames / Mullions / Transoms

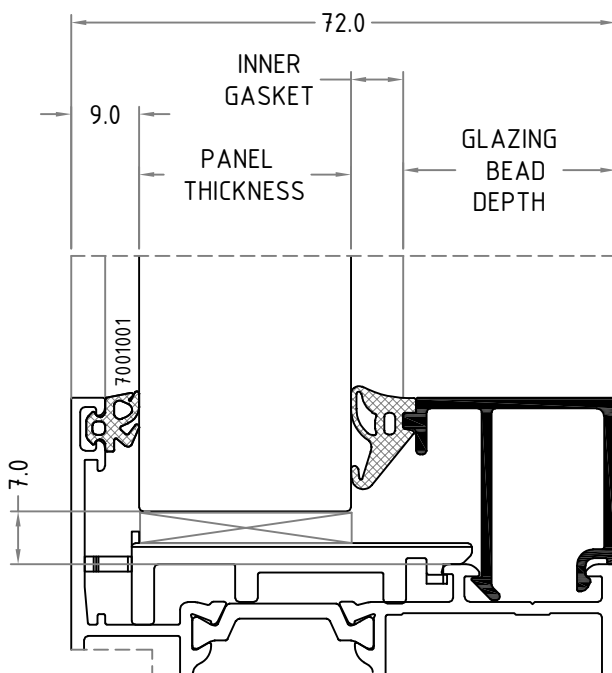


Panel Thickness	Inner Gasket Number	Inner Gasket Thickness	Inner Glazing Profile	Inner Glazing Depth
4 mm.	7001005	5 mm.	1000842	44 mm.
6 mm.	7001002	7 mm.	1000750	40 mm.
8 mm.	7001005	5 mm.	1000750	40 mm.
10 mm.	7001002	7 mm.	1000467	36 mm.
12 mm.	7001005	5 mm.	1000467	36 mm.
14 mm.	7001002	7 mm.	1000749	32 mm.
16 mm.	7001005	5 mm.	1000749	32 mm.
18 mm.	7001002	7 mm.	1000414	28 mm.
20 mm.	7001005	5 mm.	1000414	28 mm.
22 mm.	7001002	7 mm.	1000841	24 mm.
24 mm.	7001005	5 mm.	1000841	24 mm.
26 mm.	7001002	7 mm.	1000405	20 mm.
28 mm.	7001005	5 mm.	1000405	20 mm.
30 mm.	7001002	7 mm.	1000840	16 mm.
32 mm.	7001005	5 mm.	1000840	16 mm.
34 mm.	7001002	7 mm.	1000409	12 mm.
36 mm.	7001005	5 mm.	1000409	12 mm.
38 mm.	7001034	3 mm.	1000409	12 mm.
40 mm.	7001062	9 mm.	1000466	4 mm.
42 mm.	7001002	7 mm.	1000466	4 mm.
44 mm.	7001005	5 mm.	1000466	4 mm.

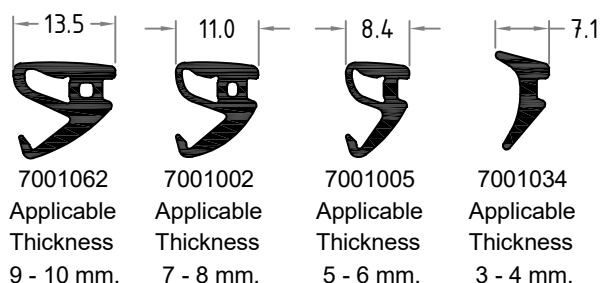


NOTE:
Tolerance of configurations is ± 1 mm.

GC 62 Glazing Table
Inside opening sashes / Insertion Mullion Transom

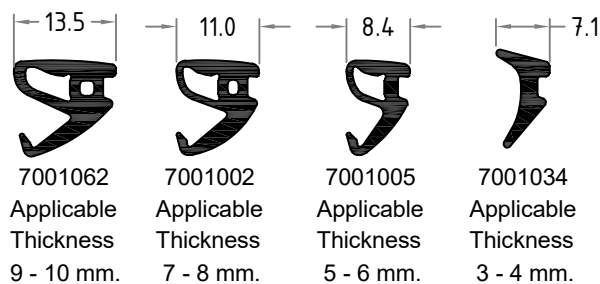
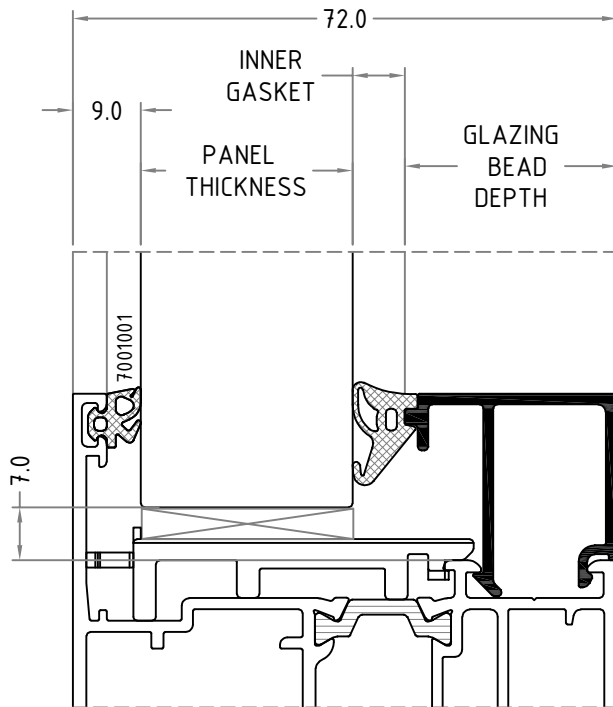


Panel Thickness	Inner Gasket Number	Inner Gasket Thickness	Inner Glazing Profile	Inner Glazing Depth
10 mm.	7001062	9 mm.	1000842	44 mm.
12 mm.	7001002	7 mm.	1000842	44 mm.
14 mm.	7001062	9 mm.	1000750	40 mm.
16 mm.	7001002	7 mm.	1000750	40 mm.
18 mm.	7001062	9 mm.	1000467	36 mm.
20 mm.	7001002	7 mm.	1000467	36 mm.
22 mm.	7001062	9 mm.	1000749	32 mm.
24 mm.	7001002	7 mm.	1000749	32 mm.
26 mm.	7001062	9 mm.	1000414	28 mm.
28 mm.	7001002	7 mm.	1000414	28 mm.
30 mm.	7001062	9 mm.	1000841	24 mm.
32 mm.	7001002	7 mm.	1000841	24 mm.
34 mm.	7001062	9 mm.	1000405	20 mm.
36 mm.	7001002	7 mm.	1000405	20 mm.
38 mm.	7001062	9 mm.	1000840	16 mm.
40 mm.	7001002	7 mm.	1000840	16 mm.
42 mm.	7001005	5 mm.	1000840	16 mm.
44 mm.	7001034	3 mm.	1000840	16 mm.
46 mm.	7001005	5 mm.	1000409	12 mm.
48 mm.	7001034	3 mm.	1000409	12 mm.
50 mm.	7001062	9 mm.	1000466	4 mm.
52 mm.	7001002	7 mm.	1000466	4 mm.
54 mm.	7001005	5 mm.	1000466	4 mm.
56 mm.	7001034	3 mm.	1000466	4 mm.



NOTE:
Tolerance of configurations is ± 1 mm.

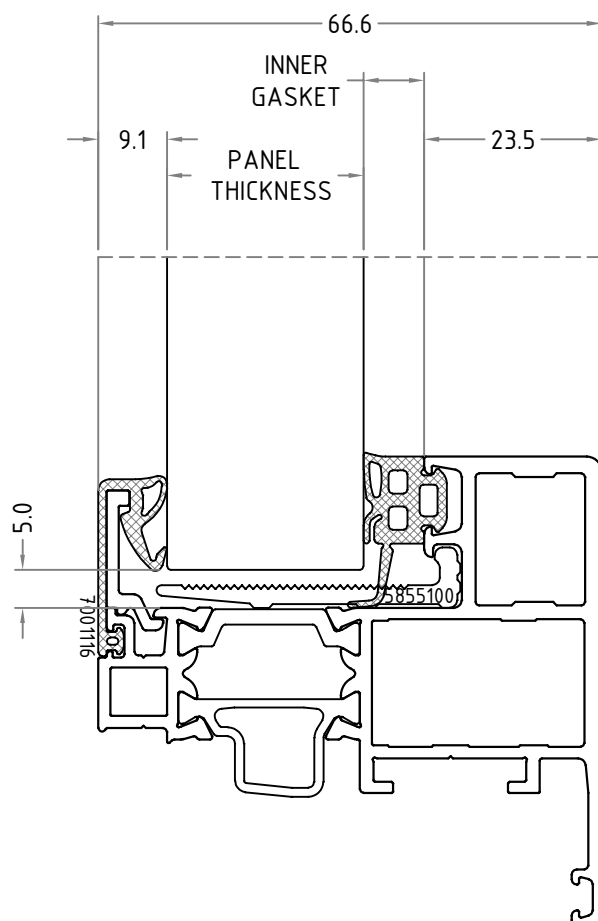
GC 62 Glazing Table
Outside opening sash / Insertion Mullion Transom



Panel Thickness	Inner Gasket Number	Inner Gasket Thickness	Inner Glazing Profile	Inner Glazing Depth
10 mm.	7001062	9 mm.	1000842	44 mm.
12 mm.	7001002	7 mm.	1000842	44 mm.
14 mm.	7001062	9 mm.	1000750	40 mm.
16 mm.	7001002	7 mm.	1000750	40 mm.
18 mm.	7001062	9 mm.	1000467	36 mm.
20 mm.	7001002	7 mm.	1000467	36 mm.
22 mm.	7001062	9 mm.	1000749	32 mm.
24 mm.	7001002	7 mm.	1000749	32 mm.
26 mm.	7001062	9 mm.	1000414	28 mm.
28 mm.	7001002	7 mm.	1000414	28 mm.
30 mm.	7001062	9 mm.	1000841	24 mm.
32 mm.	7001002	7 mm.	1000841	24 mm.
34 mm.	7001062	9 mm.	1000405	20 mm.
36 mm.	7001002	7 mm.	1000405	20 mm.
38 mm.	7001062	9 mm.	1000840	16 mm.
40 mm.	7001002	7 mm.	1000840	16 mm.
42 mm.	7001005	5 mm.	1000840	16 mm.
44 mm.	7001034	3 mm.	1000840	16 mm.
46 mm.	7001005	5 mm.	1000409	12 mm.
48 mm.	7001034	3 mm.	1000409	12 mm.
50 mm.	7001062	9 mm.	1000466	4 mm.
52 mm.	7001002	7 mm.	1000466	4 mm.
54 mm.	7001005	5 mm.	1000466	4 mm.
56 mm.	7001034	3 mm.	1000466	4 mm.

NOTE:
Tolerance of configurations is ± 1 mm.

GC 62 Glazing Table
Hidden Vent Sash



Panel Thickness	Inner Gasket Number	Inner Gasket Thickness
22 mm.	7001017	12 mm.
24 mm.	7001041	10 mm.
26 mm.	7001117	8 mm.
28 mm.	7001093	6 mm.
30 mm.	7001044	4 mm.

NOTE:
Tolerance of configurations is ± 1 mm.