

S140

Sistema per scorrevoli - *Sliding doors system*

► Manuale di lavorazioni e assemblaggio
Machinings & assembling manual

REVISIONI / UPDATES

La tabella sotto riportata elenca le ultime modifiche apportate al catalogo.
Eventuali aggiornamenti saranno pubblicati sul sito web.
Scansiona o clicca il QR code per consultare l'ultima versione.



ULTIMA REVISIONE
LATEST UPDATE

The below index show the latest revisions.
Any updates will be published on the website.
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VERSIONE VERSION	REVISIONE REVISION	DATA DATE	DESCRIZIONE DESCRIPTION	PAGINA PAGE
4	A	02.01.2026	Nuovo telaio U10022 (sostituisce il U10020) e modificato U10000 <i>U10022 is the new frame (replaced U10020) and U10000 is updated</i>	Intero manuale <i>Complete manual</i>
3	A	07.04.2025	S140R - Nuova tipologia scorrevole in linea <i>S140R - New inline slider typology</i>	Intero manuale <i>Complete manual</i>
2	E	22.03.2024	Indicato posizionamento tappi per soluzione 3ante, 3vie <i>Indicated positioning of 3 sash/ 3way plugs</i>	10.07
2	D	11.03.2024	Aggiunte note esplicative <i>Explanatory notes added</i>	10.10 - 10.27
		13.03.2024	Inserito indicazioni di indicazioni di sigillatura <i>Inserted indications of sealing</i>	10.03
2	C	21.11.2023	Inserita nota per H10402 <i>Note for H10402 added</i>	10.27
		01.02.2024	Aggiornata posizione del punto di chiusura sulla serratura H40102 <i>Updated locking point position on lock H40102</i>	10.10 - 10.28
2	B	13.10.2023	Inserita sezione per definire le possibili dimensioni del cilindro da utilizzare <i>Inserted section to define possible cylinder sizes to be used</i>	10.27
		16.10.2023	Modificata sezione di drenaggio sotto parte fissa dx, era D-D diventa C-C <i>Modified drainage section under right fixed part, was D-D becomes C-C</i>	09.20
2	A	08.05.2023	Aggiunte attrezzature OXO <i>OXO tools added</i>	9.001
		09.05.2023	Aggiunte tavole di lavorazione soglia e cover OXO e spostate le successive <i>Added threshold and OXO cover machining tables and moved the next ones</i>	9.20 ÷ 9.26
		09.05.2023	Aggiunte pagine con indicazioni di utilizzo dima di foratuta T10082 <i>Added pages with information on the use of T10082 template</i>	9.27 - 9.28
		31.05.2023	Aggiunta nota sulle viti di fissaggio e sulla sigillatura della vaschetta <i>Added note on hardware fixing screws and cup sealing</i>	10.27
		30.06.2023	Inserita nota di possibile lavorazione con tranciante T10061 <i>Inserted note of possible machining with T10061 blanking machine</i>	9.18 - 9.22
		30.06.2023	Sostituito profilo cover anta (era N10900 è N10909) <i>Replaced sash cover profile (was N10900 is N10909)</i>	repp 9 e 10

INDICE

DESCRIZIONE DESCRIPTION	REPERTORIO SECTION
Lavorazioni <i>Machinings</i>	9.00
Assemblaggio <i>Assembling</i>	10.00

2	A	03.07.2023	Tavola di montaggio OXO <i>OXO assembly diagram</i>	10.12
		07.07.2023	Aggiornata posizione valvola di drenaggio + variata la sagoma della cover <i>Updated drain valve position + changed cover shape</i>	10.09
		17.07.2023	Aggiunto montaggio e posizionamento V50051 <i>Added assembly and positioning of V50051</i>	10.24
		19.07.2023	Aggiornata la nota relativa alle viti <i>Note on screws updated</i>	10.21
		24.07.2023	Inserita nota di attenzione nel posizionamento montanti <i>Cautionary note on positioning mullions inserted</i>	9.24 - 9.26
		25.07.2023	Aggiornata la sagoma della soglia OX <i>OX threshold profile updated</i>	repp 9 e 10
1	A	04.11.2022	Prima emissione <i>First issue</i>	Intero manuale <i>Complete manual</i>

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Section 9

Lavorazioni
Machinings

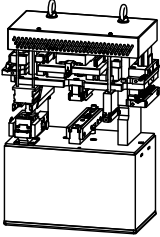
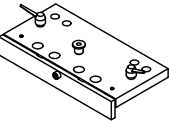
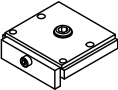
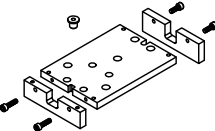
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	T00061	Tranciante <i>Punching machine</i>	-
	T10066	Dima foratura telaio <i>Frame drilling template</i>	-
	T10067	Dima foratura anta <i>Sash drilling template</i>	-
	T10082	Dima foratura telaio OX e OXO <i>OX and OXO Frame drilling template</i>	-

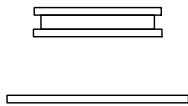
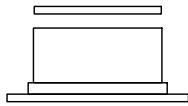
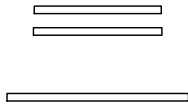
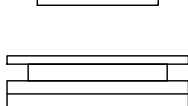
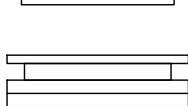
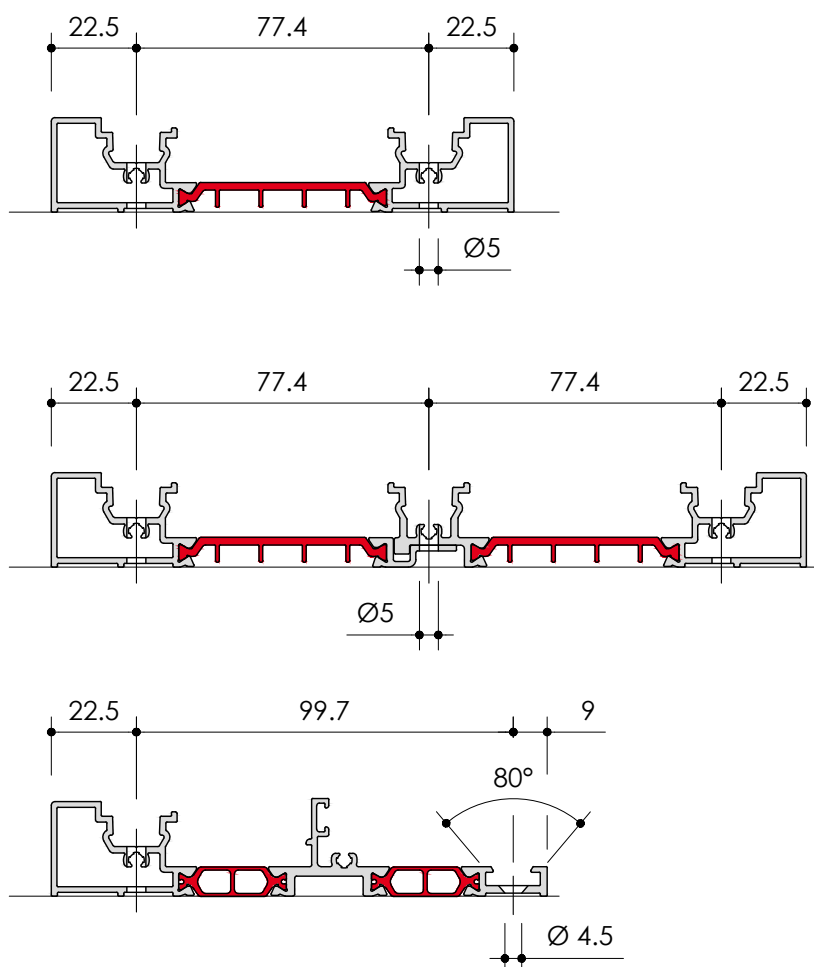
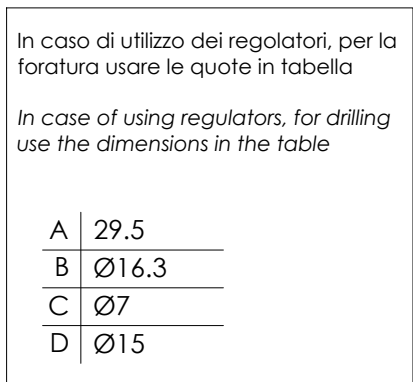
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	909333	Gruppo fresa per drenaggio <i>Milling cutter drain water</i>	-
	T40037	Gruppo fresa montante centrale OX <i>Milling accessory for connection central mullion OX</i>	-
	T40038	Gruppo fresa montante centrale soglia rib. OX <i>Milling accessory for connection central mullion OX with lowered threshold</i>	-
	T40039	Gruppo fresa anta montante slim <i>Milling accessory for connecting slim central mullion</i>	-
	T40046	Gruppo fresa montante centrale OXO <i>Milling accessory for connection central mullion OXO</i>	-
	T40047	Gruppo fresa montante centrale soglia rib. OXO <i>Milling accessory for connection central mullion OXO with lowered threshold</i>	-

IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.

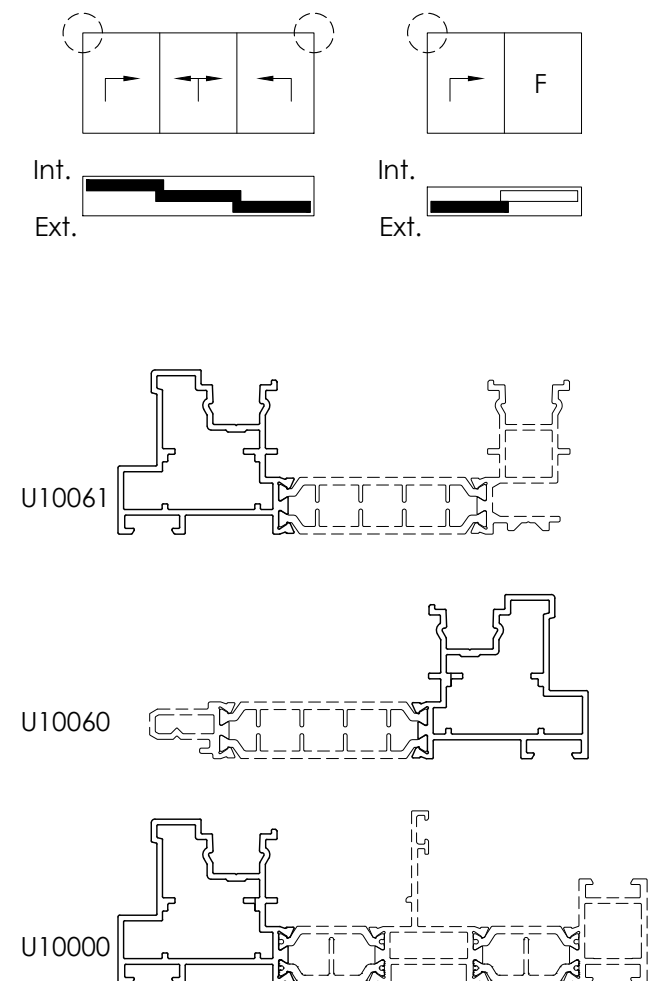
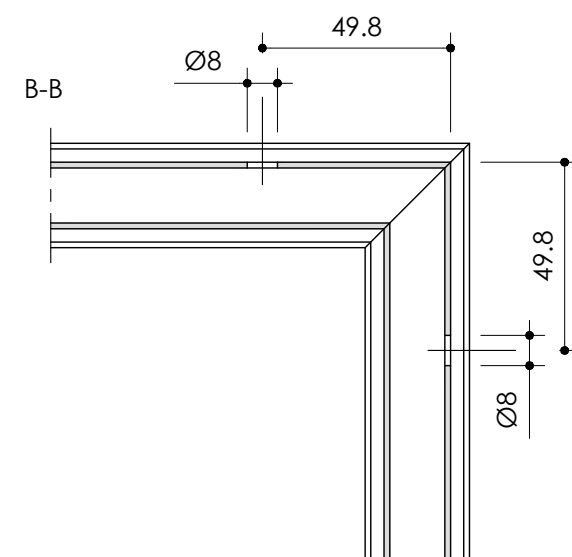
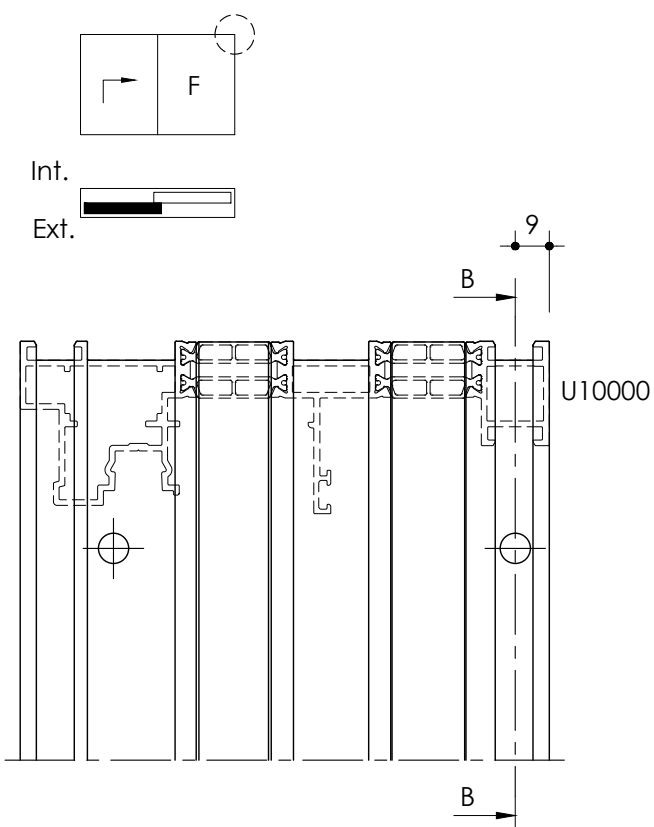
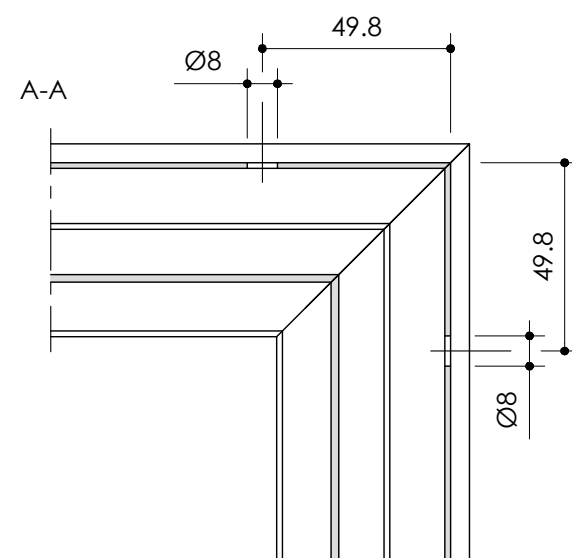
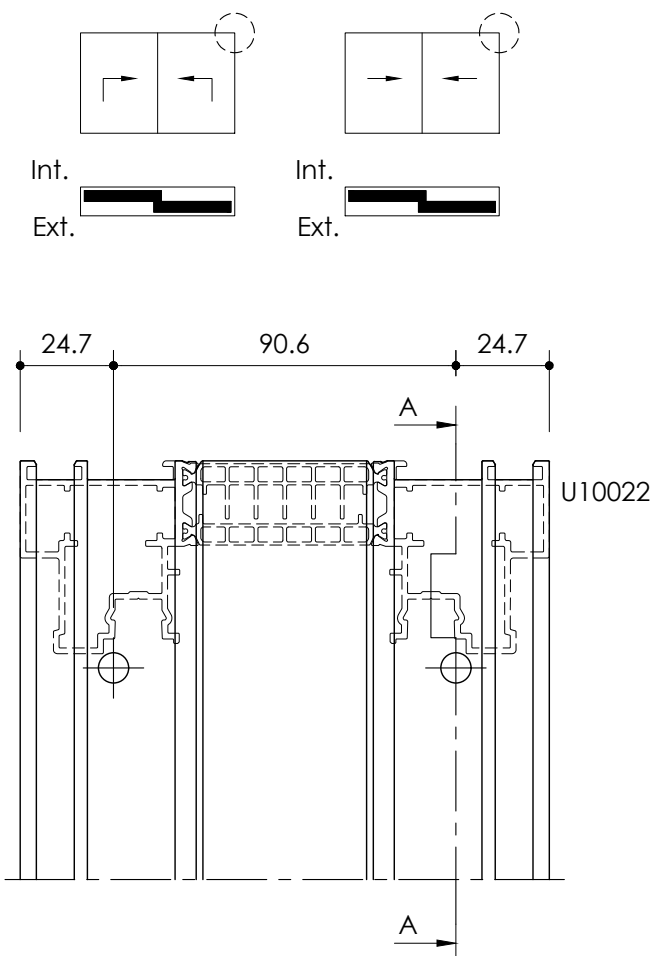
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S140 L&S	S140 R
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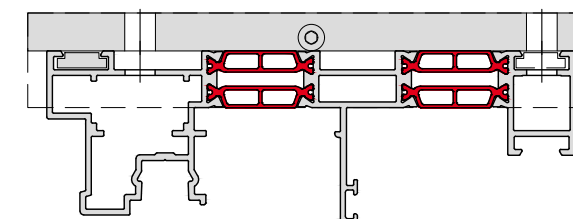
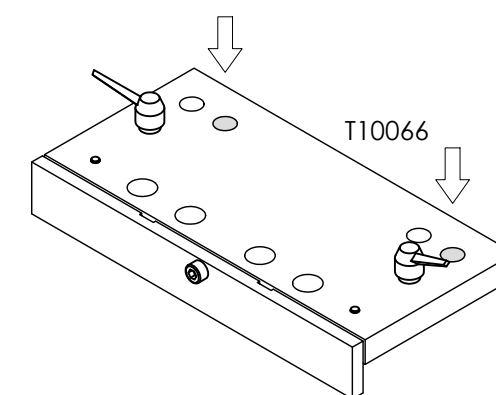
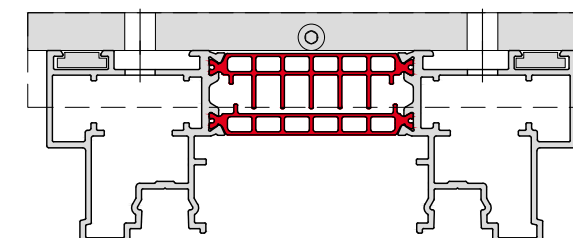
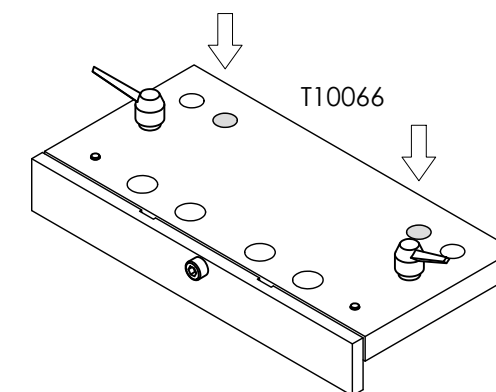
➤ **LAVORAZIONI SQUADRETTA A SPINARE/A VITE PER TELAI**
MACHINING CORNER JOINT TO BE RIVETED/SCREWED FOR FIXED FRAME

S140 L&S	S140 R
●	●



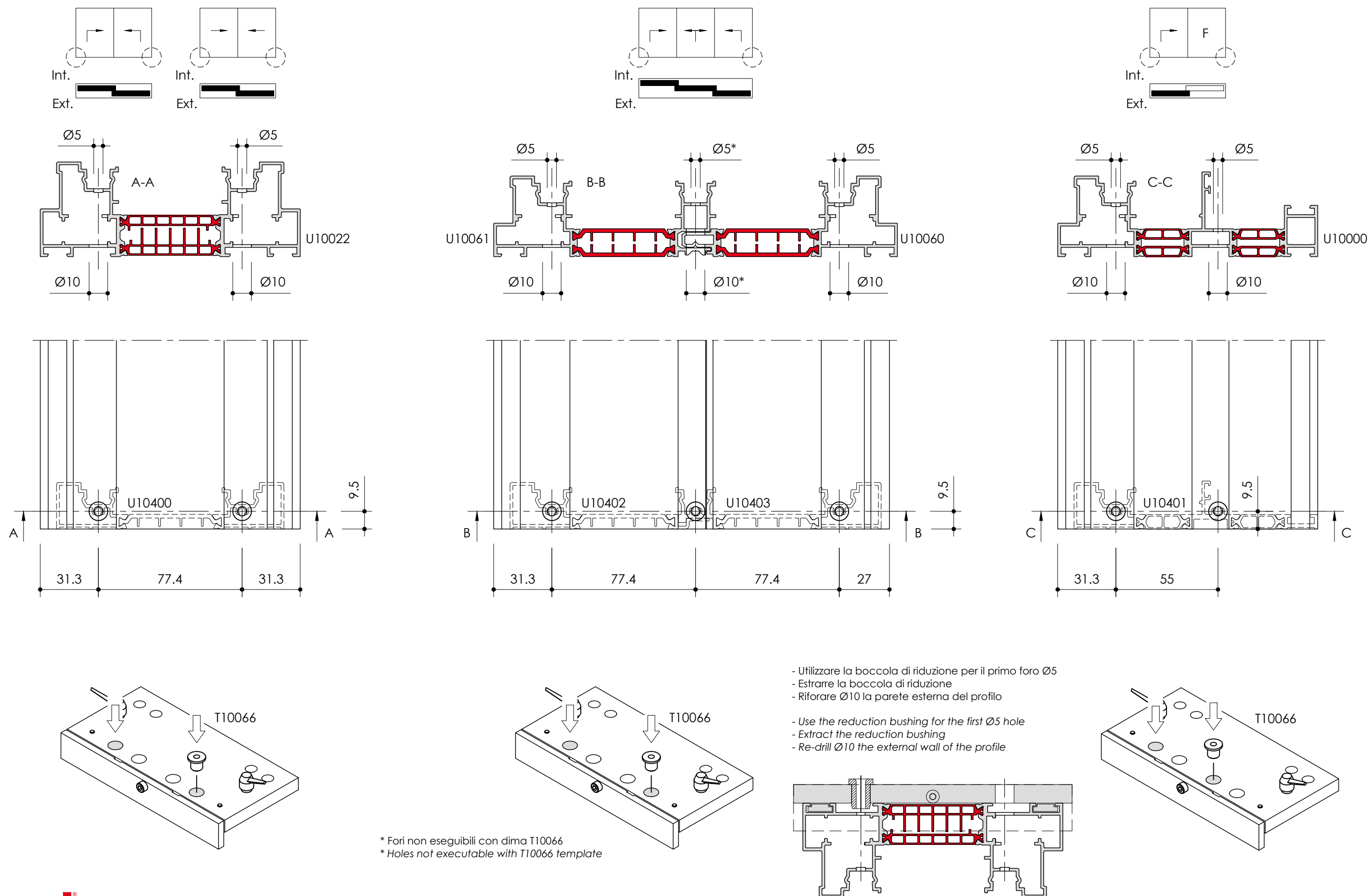
Lavorazioni eseguibili con tranciante T00061
o con dima T10066

Machining executable with T00061 or with
T10066 template

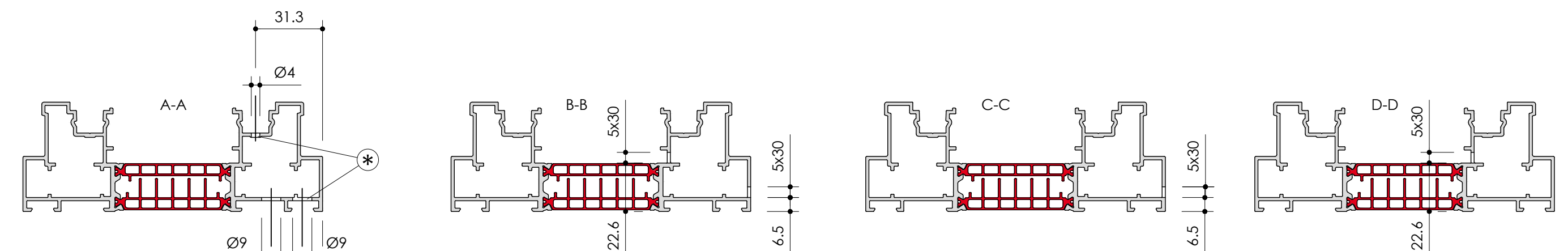
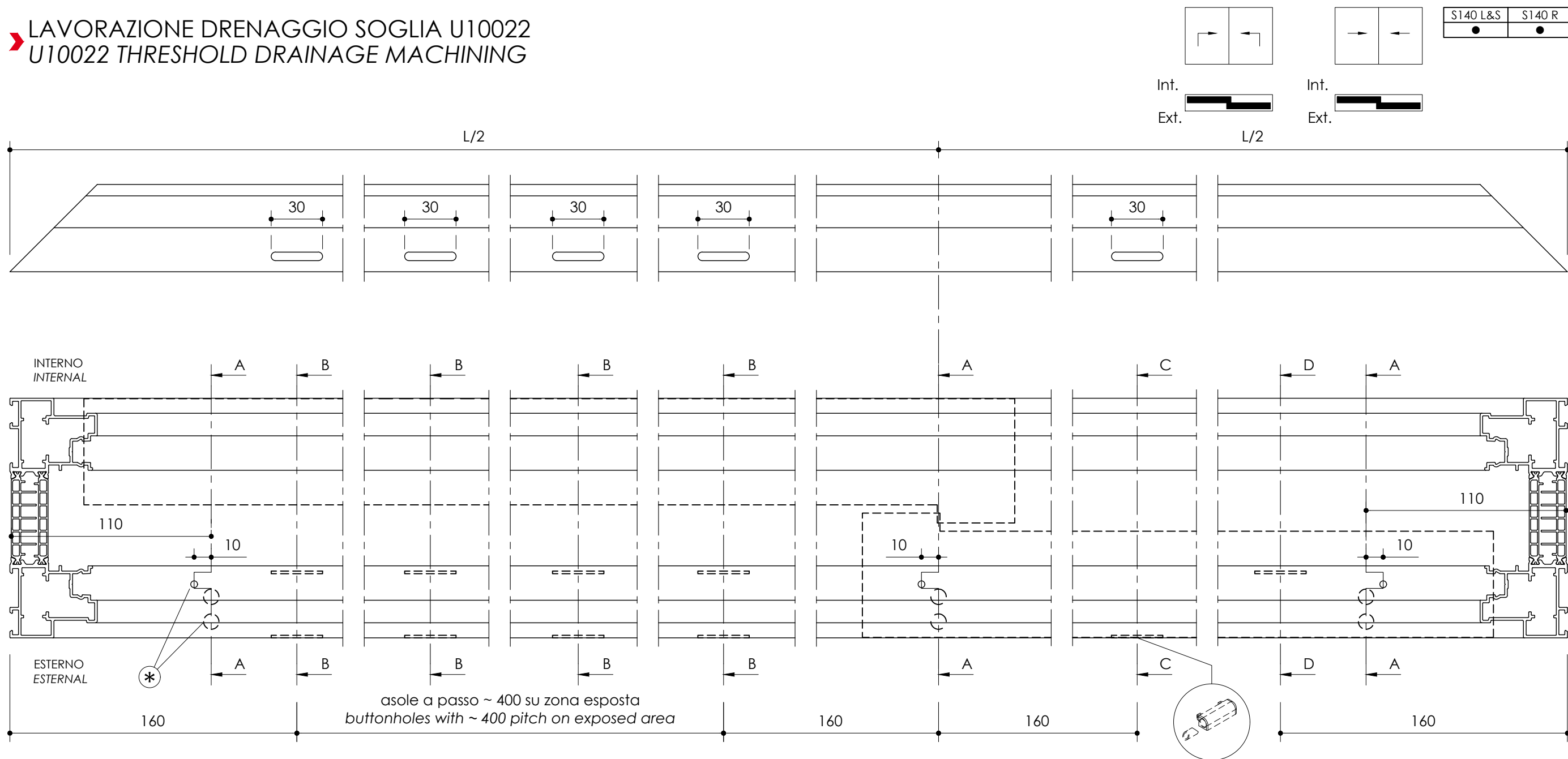


LAVORAZIONE DI FORATURA PER ASSEMBLAGGIO MONTANTE SOGLIA RIBASSATA DRILLING MACHINING FOR FIXED MULLION ASSEMBLING ON THE LOWER THRESHOLD

S140 L&S	S140 R
●	●



LAVORAZIONE DRENAGGIO SOGLIA U10022 U10022 THRESHOLD DRAINAGE MACHINING

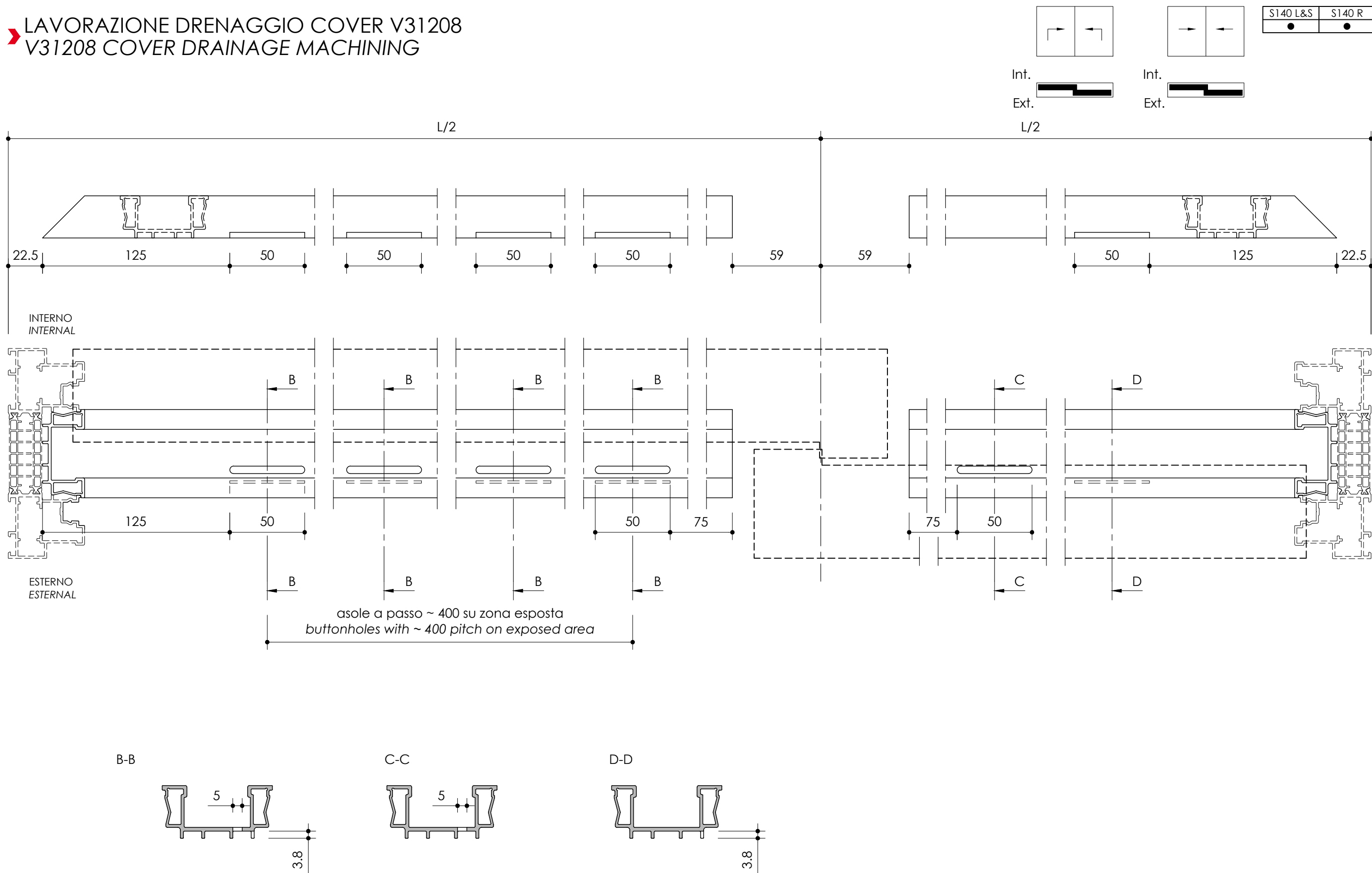


* Fori di iniezione sigillante e fissaggio articolo V55168
Sealant injection and fixing holes for item V55168

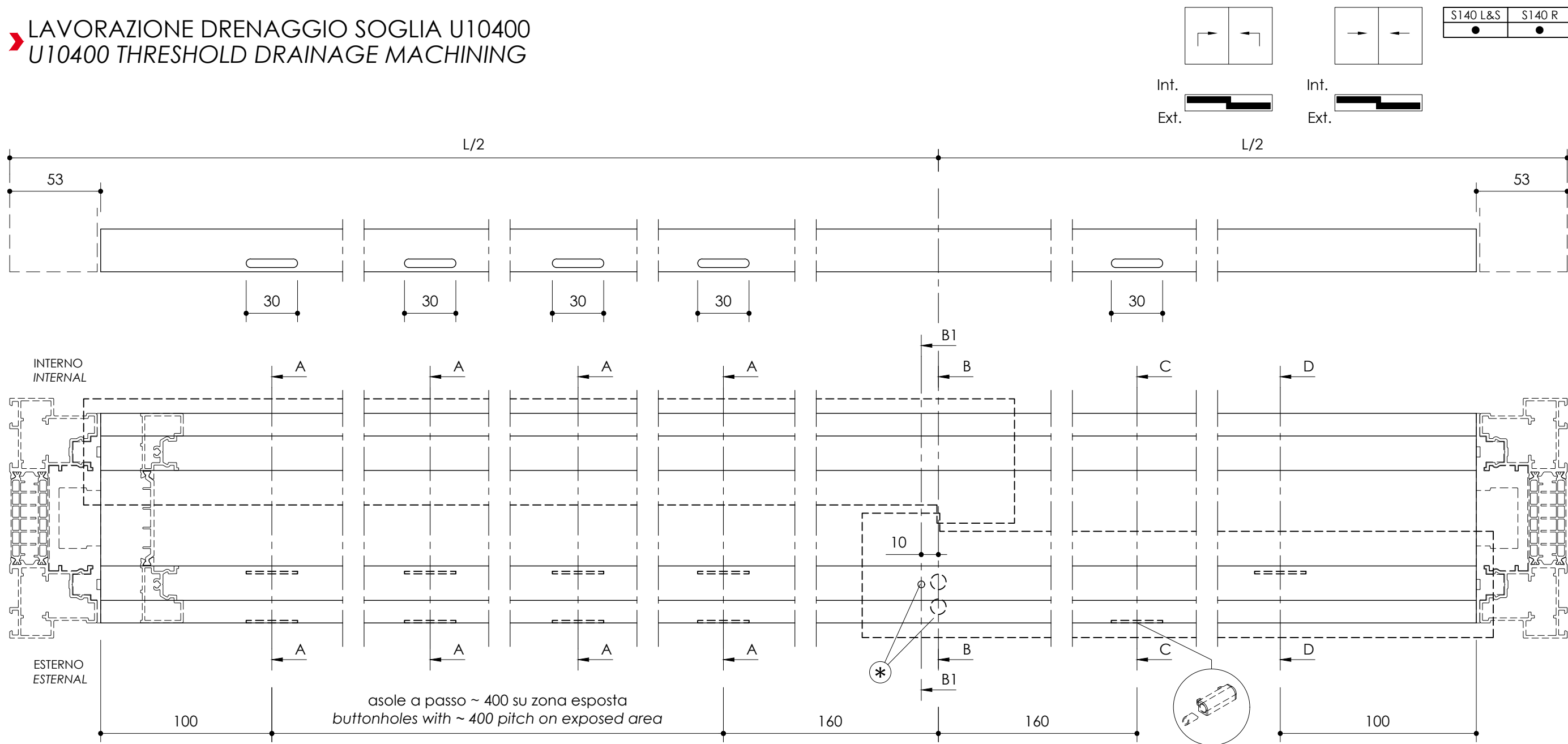
Per le asole interne 5x30
usare fresa 909333

For the 5x30 internal slots use
909333 milling accessory

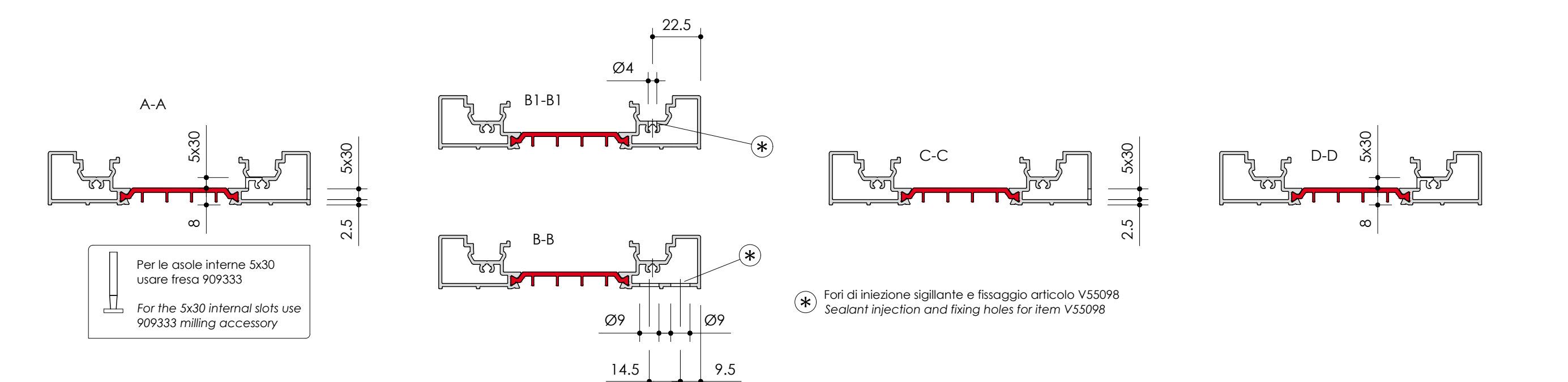
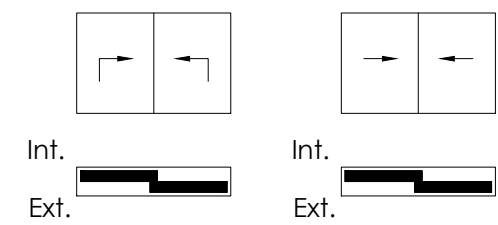
➤ LAVORAZIONE DRENAGGIO COVER V31208
V31208 COVER DRAINAGE MACHINING



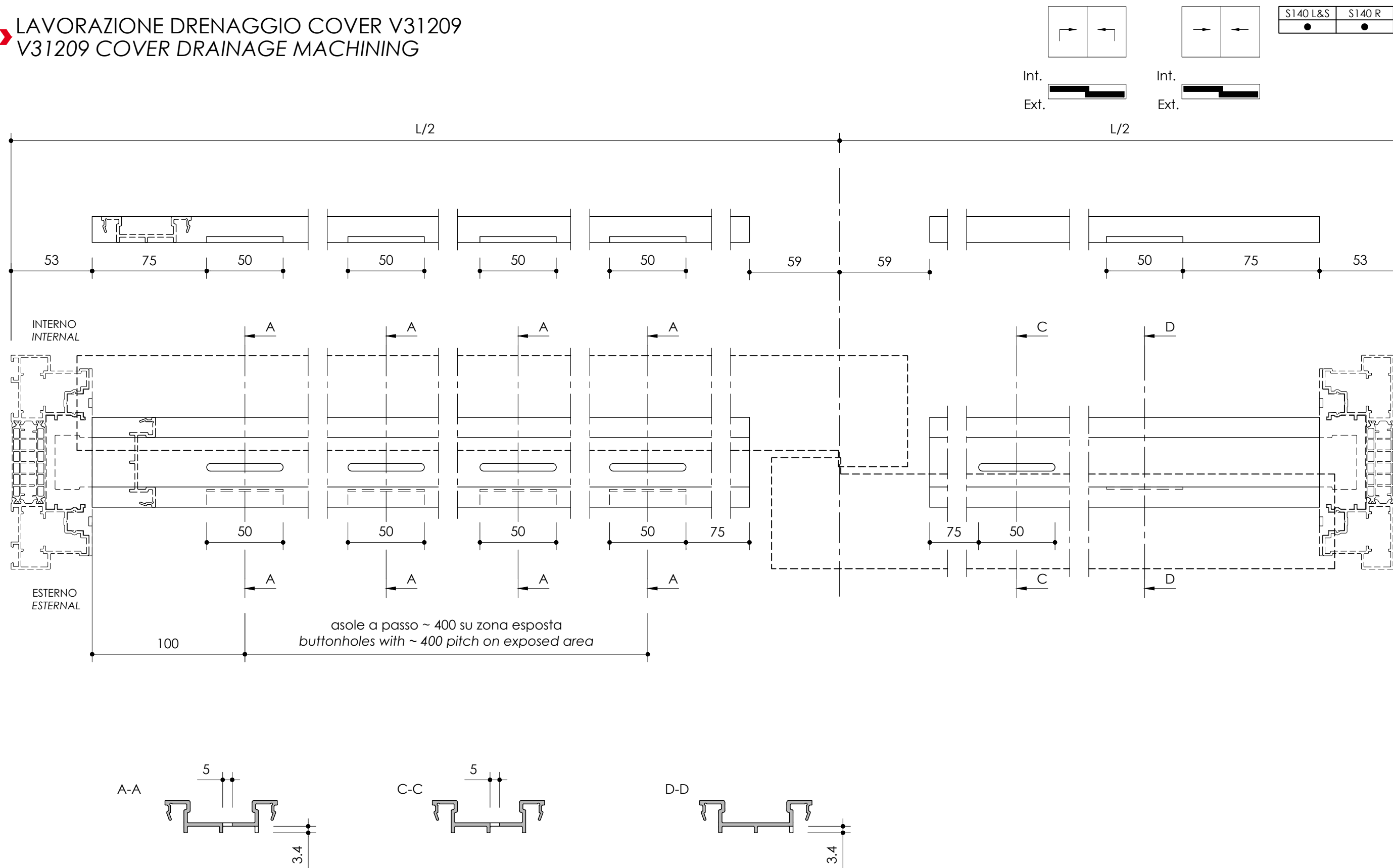
LAVORAZIONE DRENAGGIO SOGLIA U10400 U10400 THRESHOLD DRAINAGE MACHINING

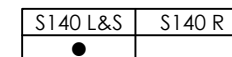


S140 L&S	S140 R
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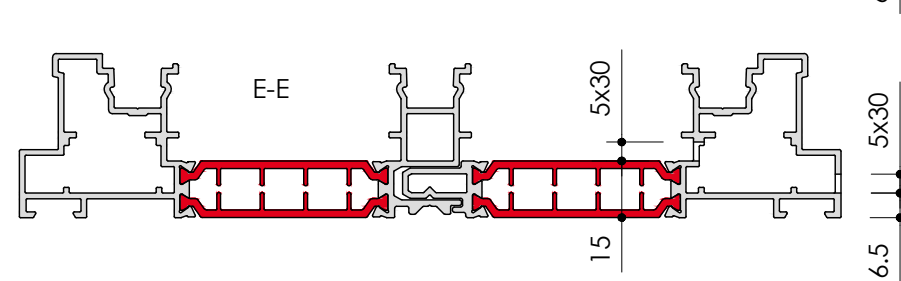
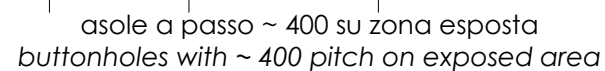


LAVORAZIONE DRENAGGIO COVER V31209
V31209 COVER DRAINAGE MACHINING



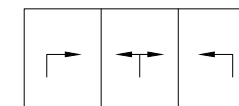


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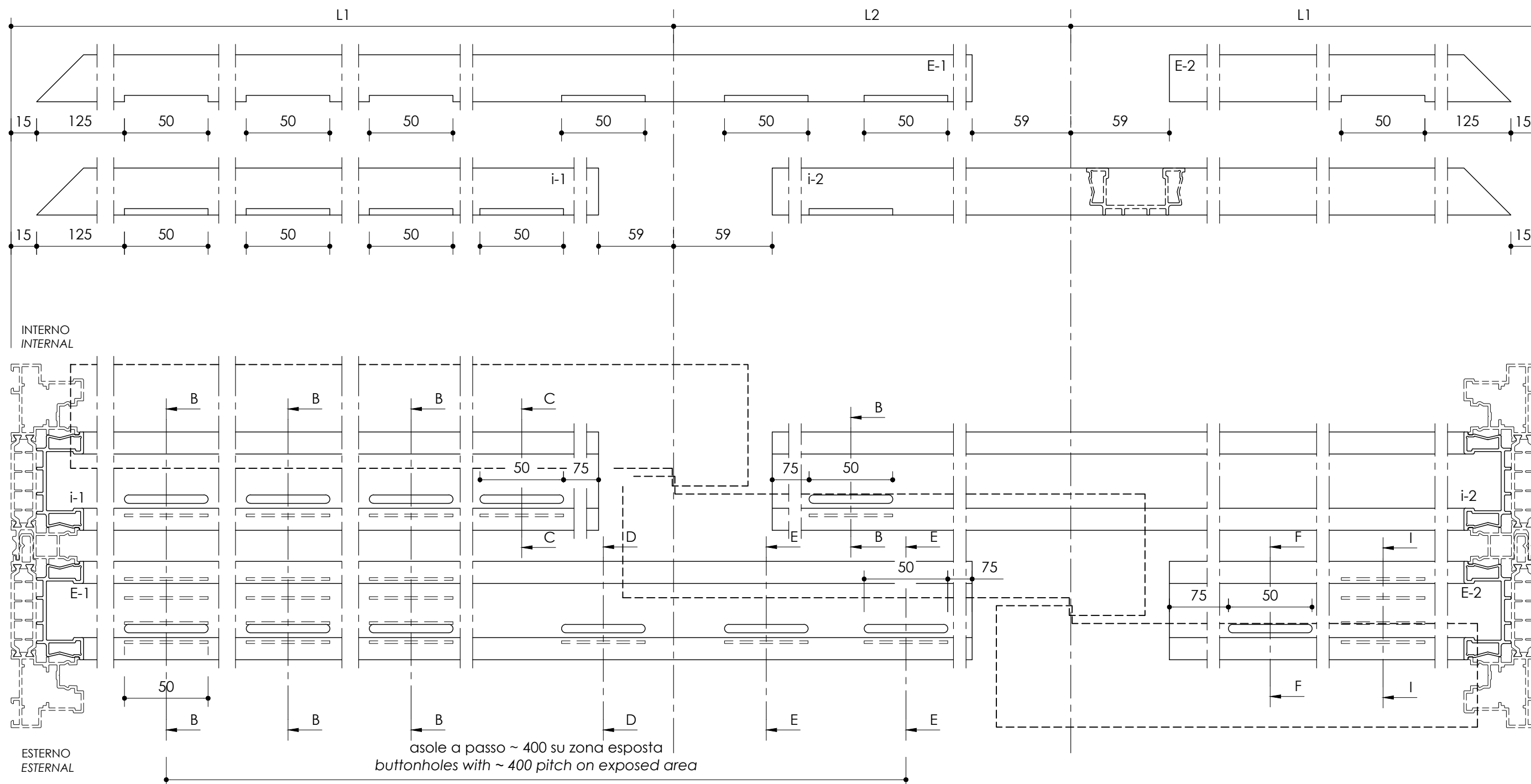


- For the 5x30 internal slots use 909333 milling accessory

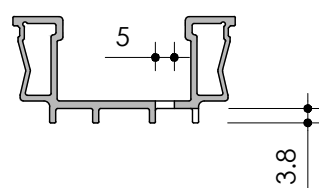
LAVORAZIONE DRENAGGIO COVER V31208
V31208 COVER DRAINAGE MACHINING



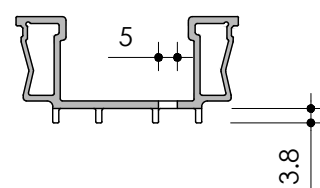
S140 L&S	S140 R
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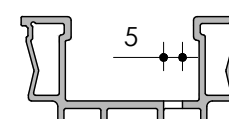
(i1) B-B
(i1) C-C
(E1) D-D
(E1) E-E
(i2) B-B



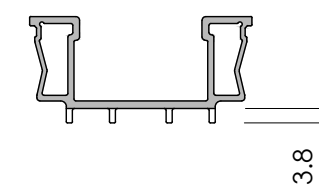
(E1) B-B

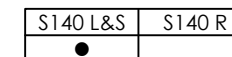


(E-2) F-F



(E-2) I-I



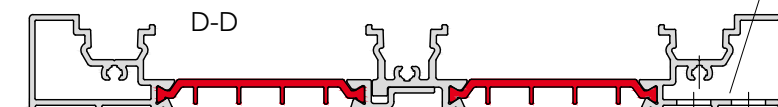
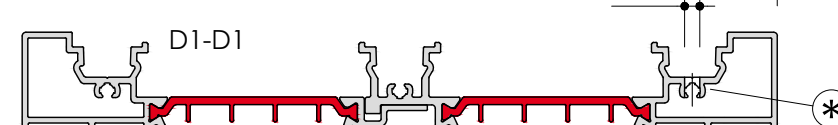
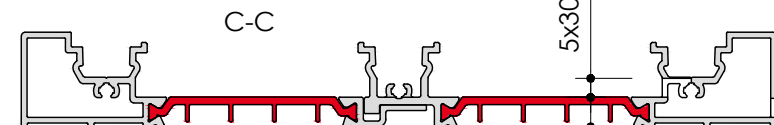


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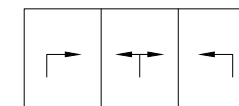
asole a passo ~ 400 su zona esposta
buttonholes with ~ 400 pitch on exposed area



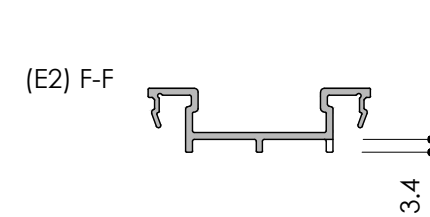
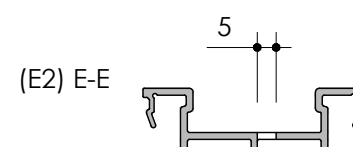
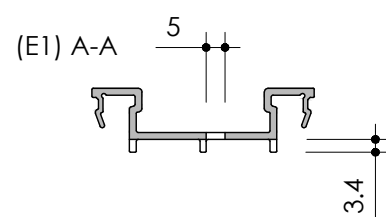
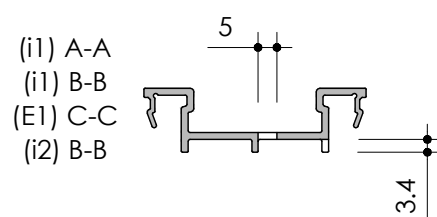
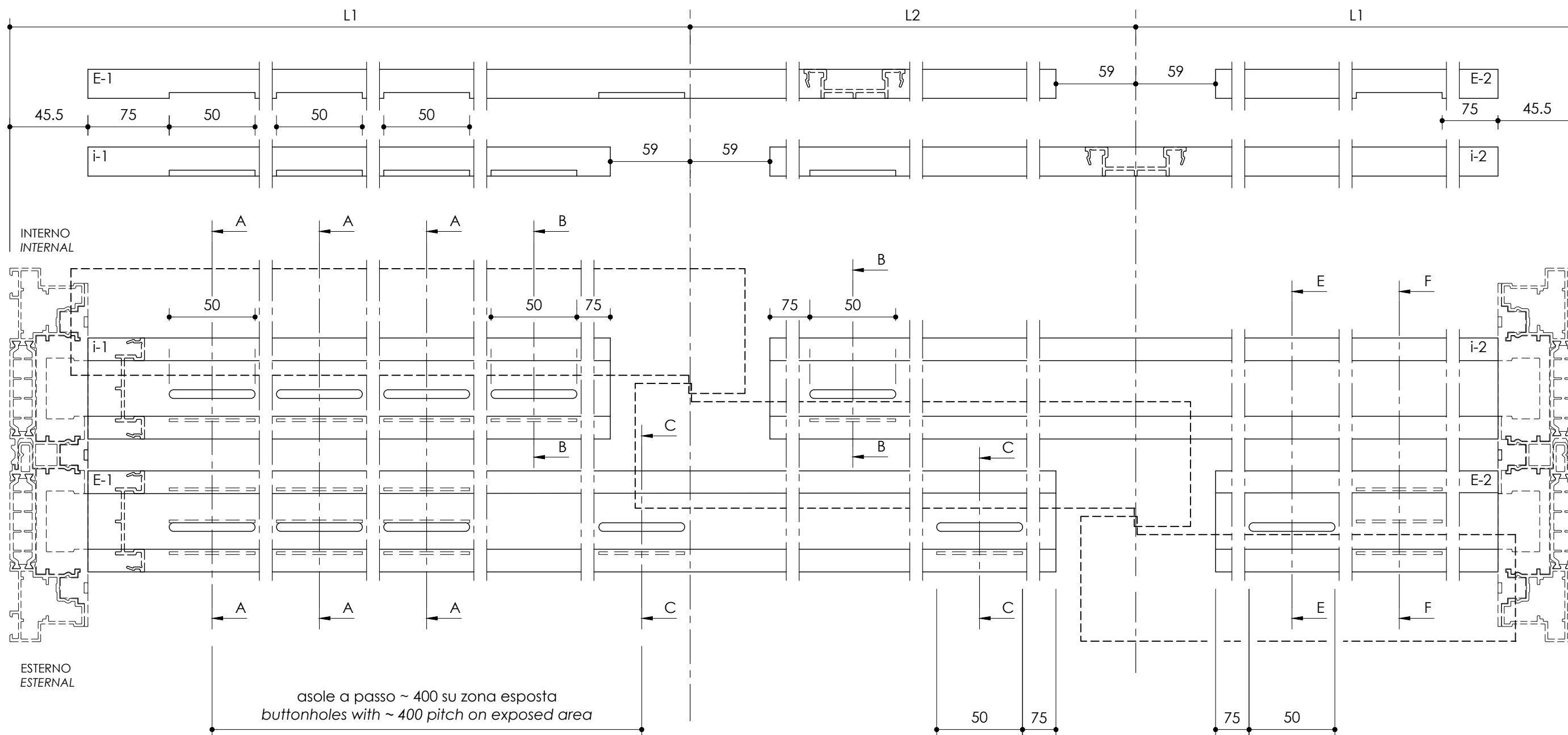
 Per le asole interne 5x30
usare fresa 909333

*For the 5x30 internal slots use
909333 milling accessory*

LAVORAZIONE DRENAGGIO COVER V31209
V31209 COVER DRAINAGE MACHINING

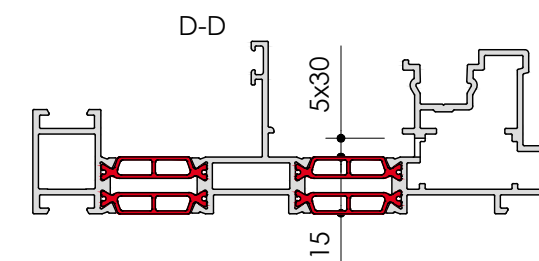
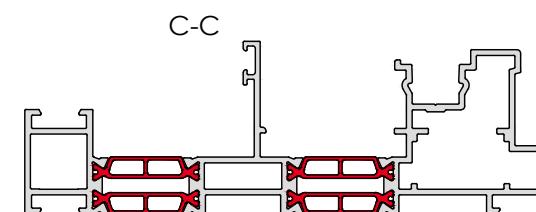
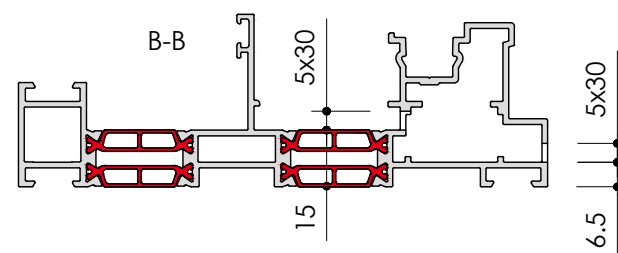
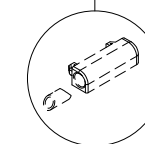


S140 L&S	S140 R



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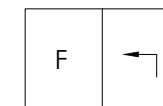
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 Per le asole interne 5x30
usare fresa 909333

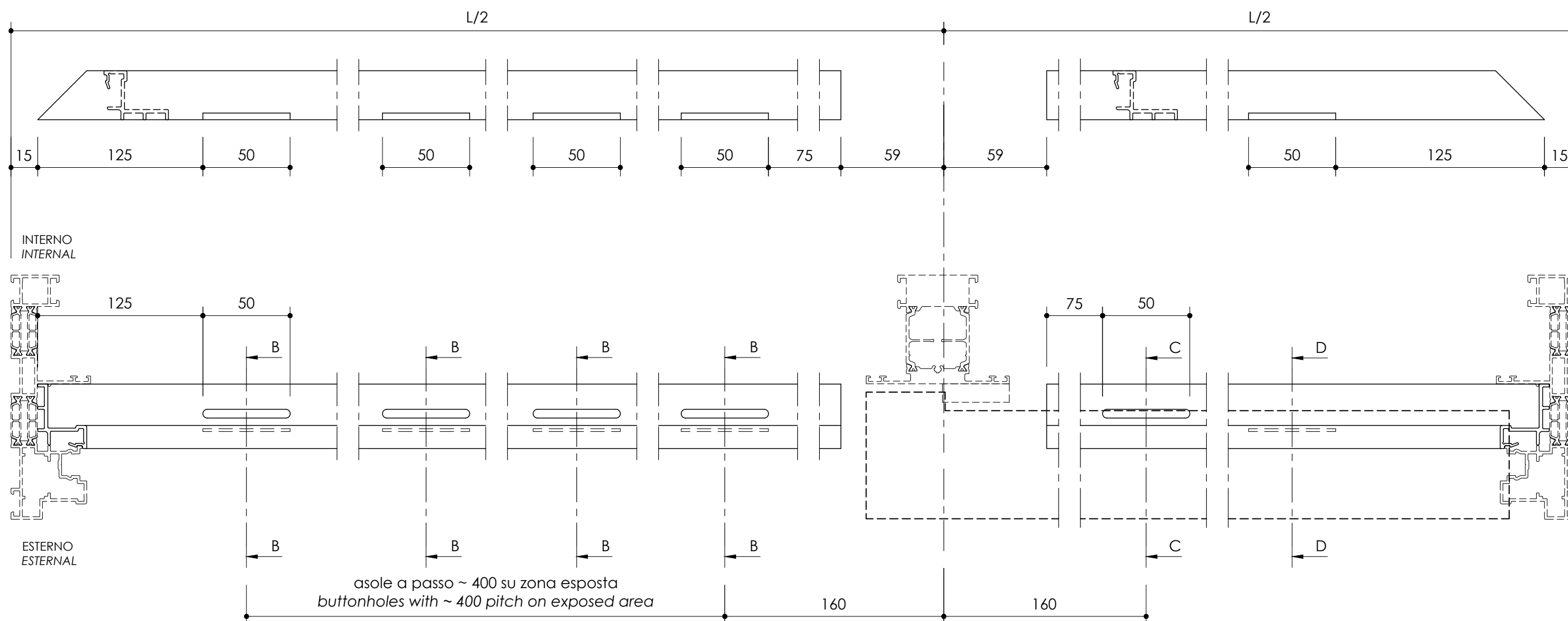
*For the 5x30 internal slots use
909333 milling accessory*

▶ LAVORAZIONE DRENAGGIO COVER V31212
V31212 COVER DRAINAGE MACHINING

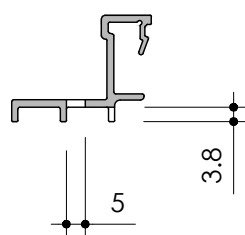


S140 L&S	S140 R
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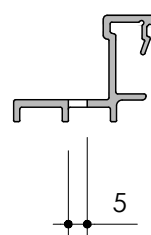
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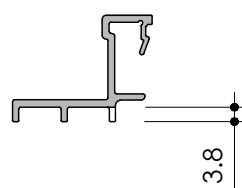
B-B



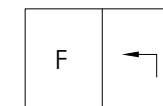
C-C



D-D

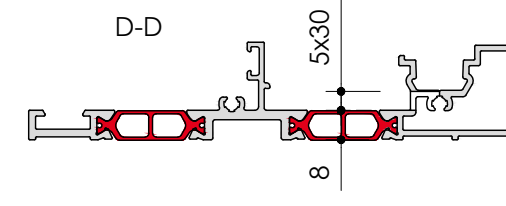
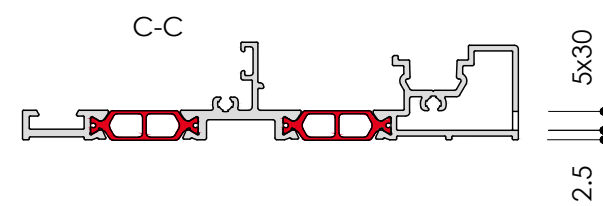
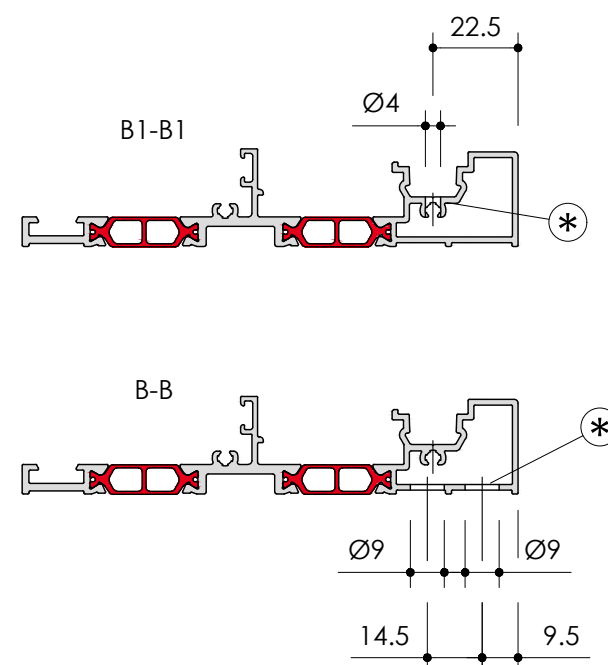
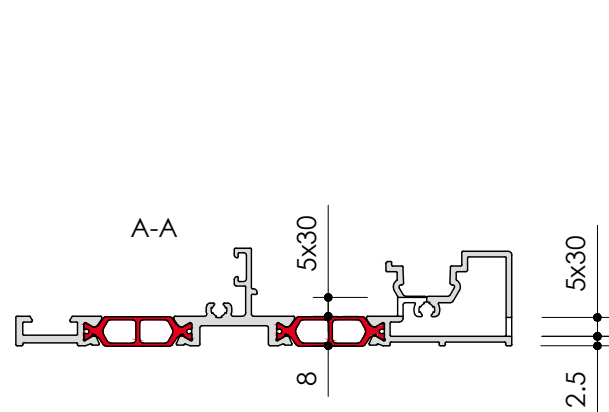
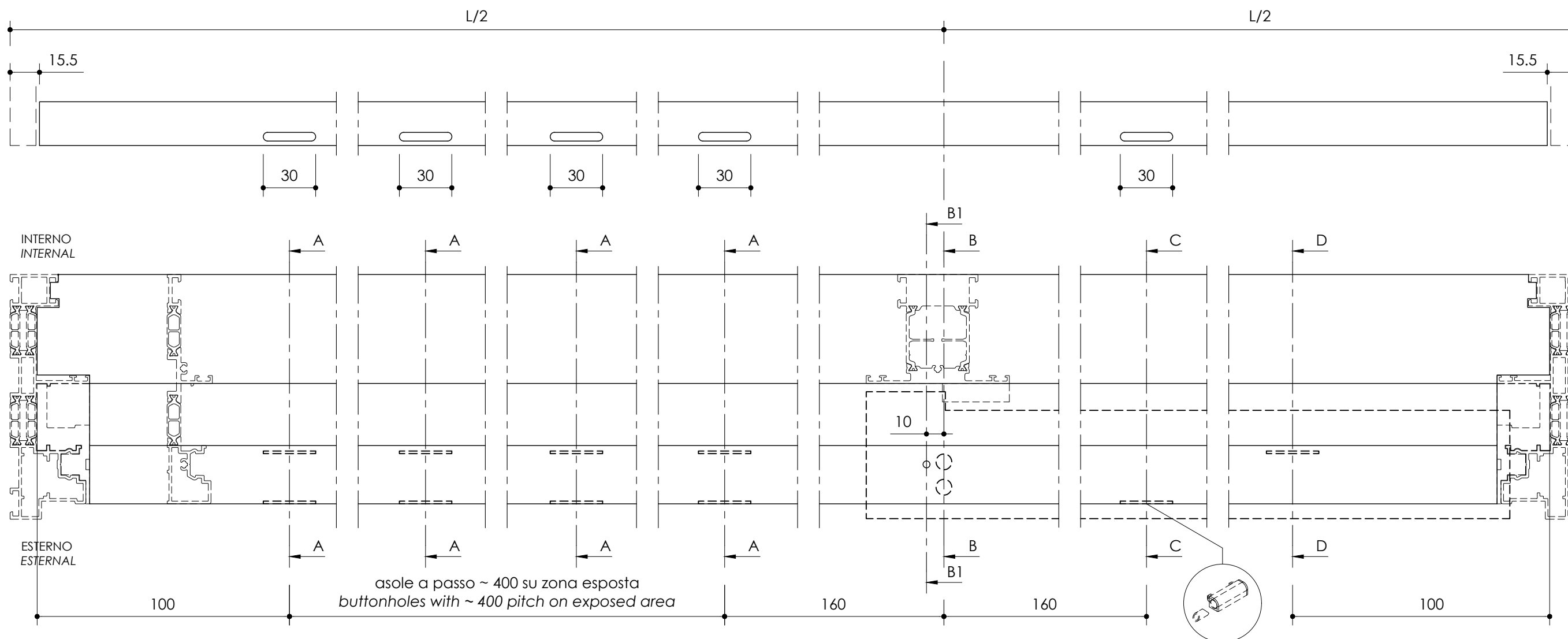


LAVORAZIONE DRENAGGIO SOGLIA U10401 U10401 THRESHOLD DRAINAGE MACHINING



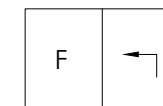
S140 L&S	S140 R
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Int.
Ext.



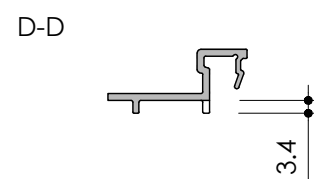
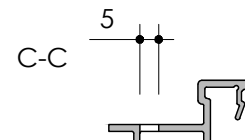
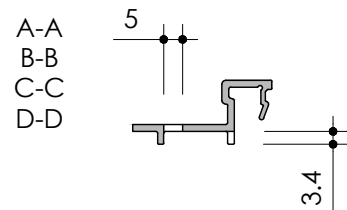
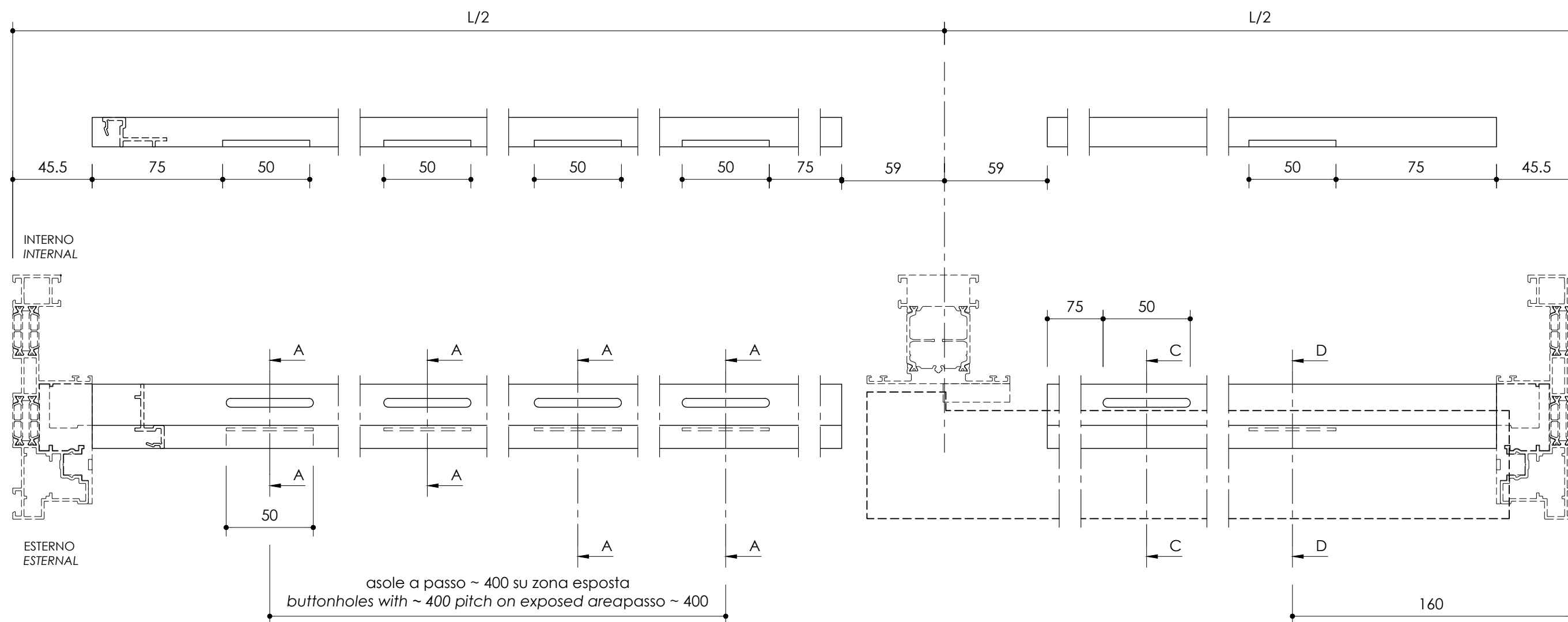
* Fori di iniezione sigillante e fissaggio articolo V55098
Sealant injection and fixing holes for item V55098

LAVORAZIONE DRENAGGIO COVER V31211
V31211 COVER DRAINAGE MACHINING



S140 L&S	S140 R
●	

Int.
Ext.



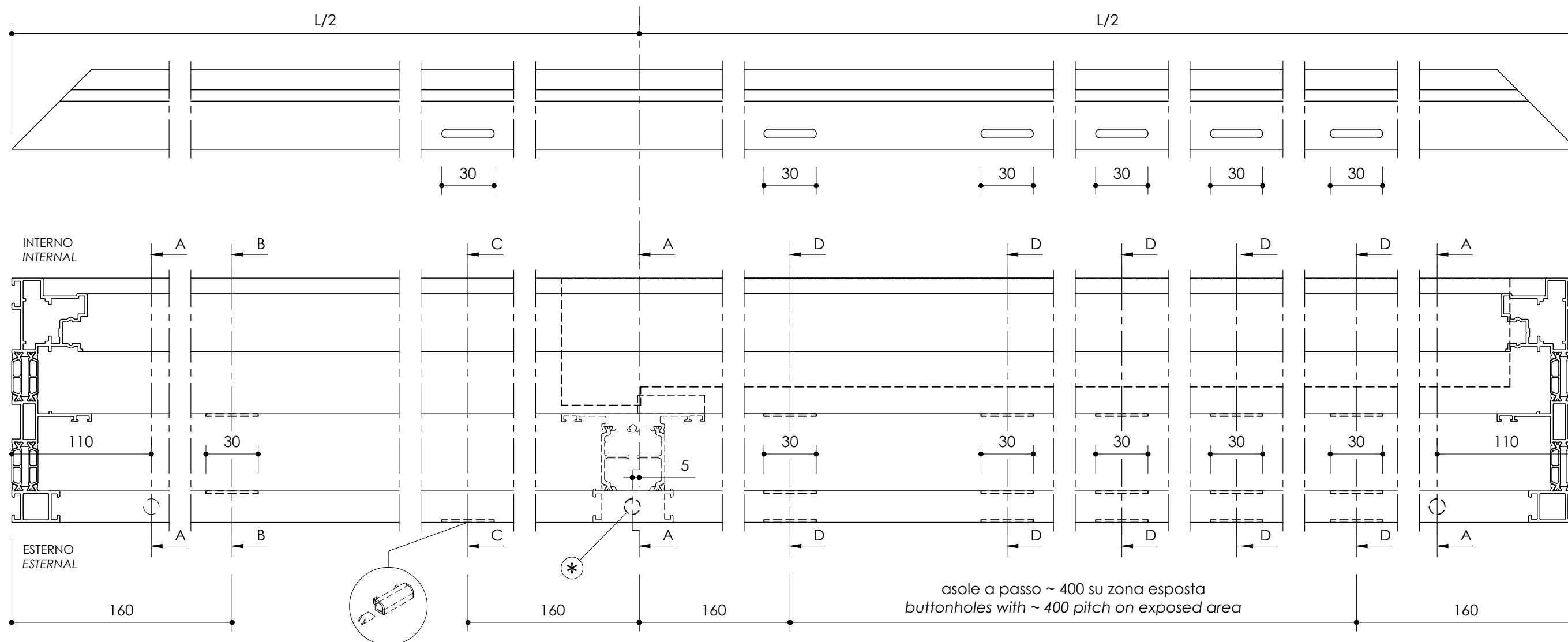
LAVORAZIONE DRENAGGIO SOGLIA U10000 CON ANTA INTERNA

U10000 THRESHOLD DRAINAGE MACHINING WITH INTERNAL SASH

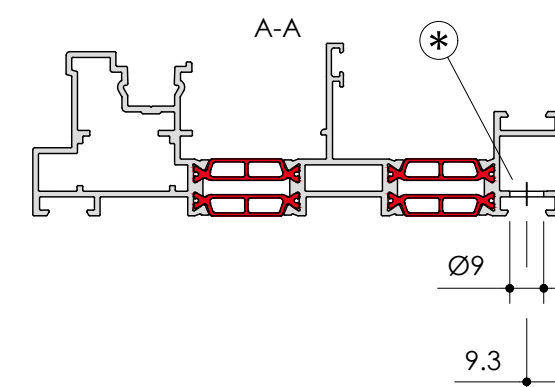
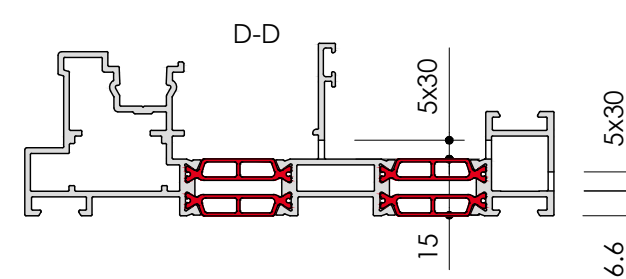
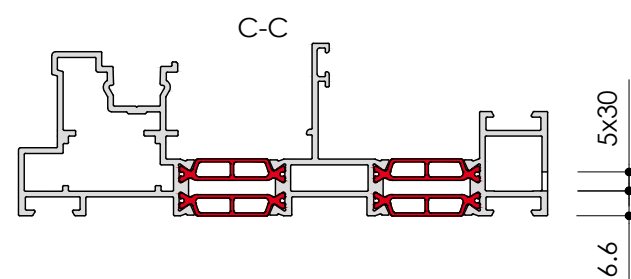
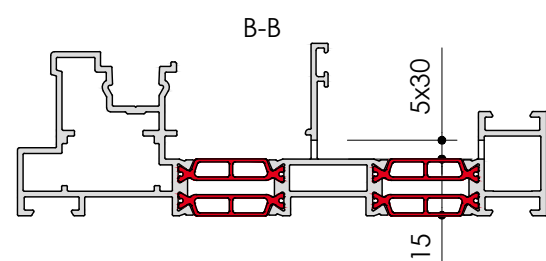
S140 L&S	S140 R

Int.

Ext.



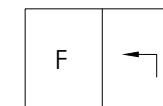
* Fori di iniezione sigillante
Sealant injection holes



Per le asole interne 5x30
usare fresa 909333

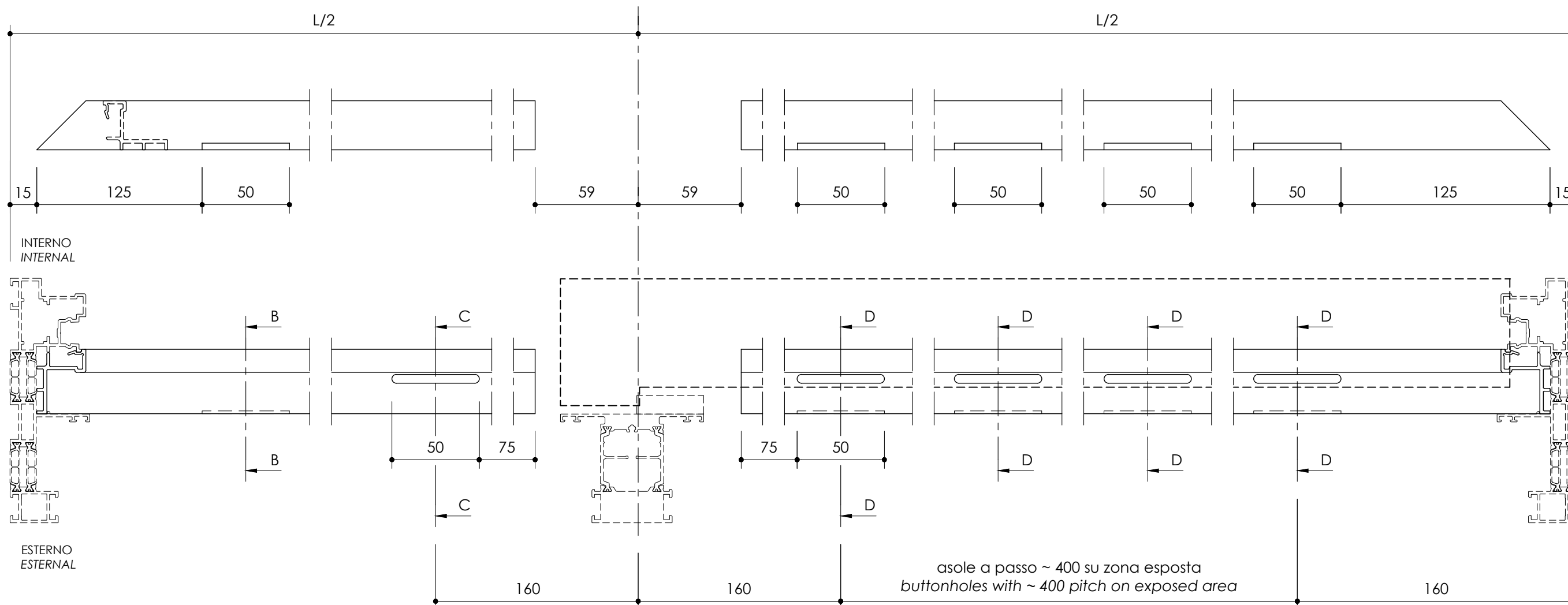
For the 5x30 internal slots use
909333 milling accessory

➤ LAVORAZIONE DRENAGGIO COVER V31212 CON ANTA INTERNA
V31212 COVER DRAINAGE MACHINING WITH INTERNAL SASH

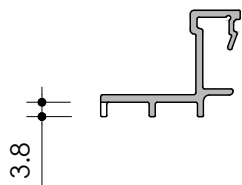


S140 L&S	S140 R
●	

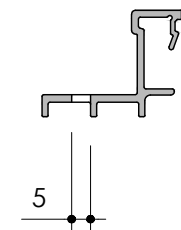
Int.
Ext.



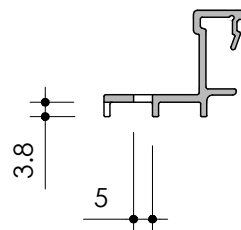
B-B



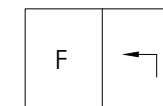
C-C



D-D

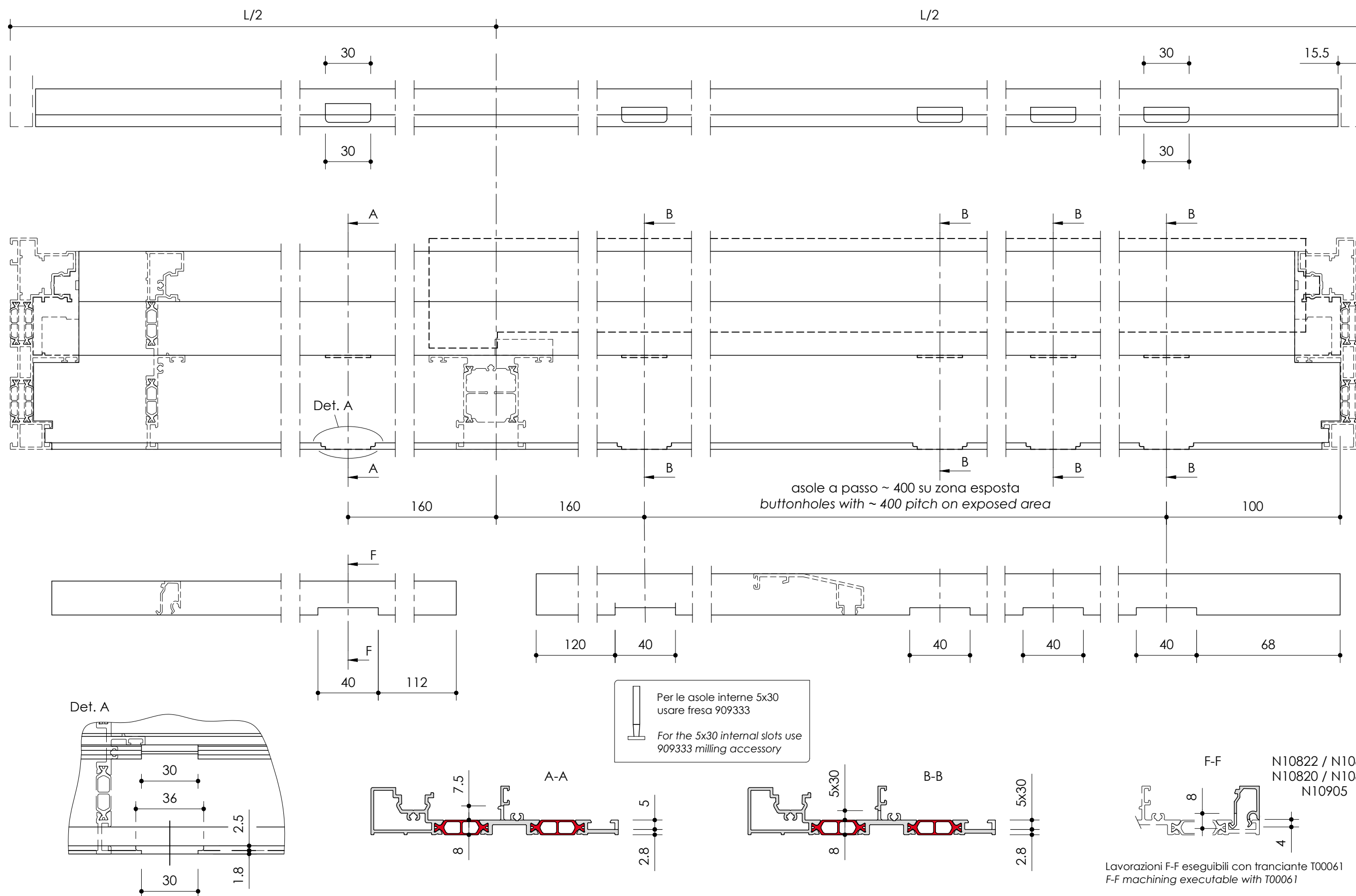


➤ LAVORAZIONE DRENAGGIO SOGLIA U10401 CON ANTA INTERNA E RELATIVI FERMAVETRI
U10401 THRESHOLD DRAINAGE MACHINING WITH INTERNAL DOOR AND RELATIVE GLASS HOLDERS



S140 L&S	S140 R
●	

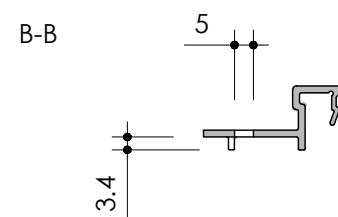
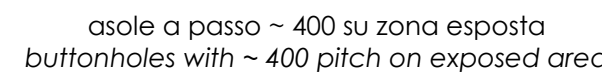
Int.
Ext.



F	
---	---

[illegible]

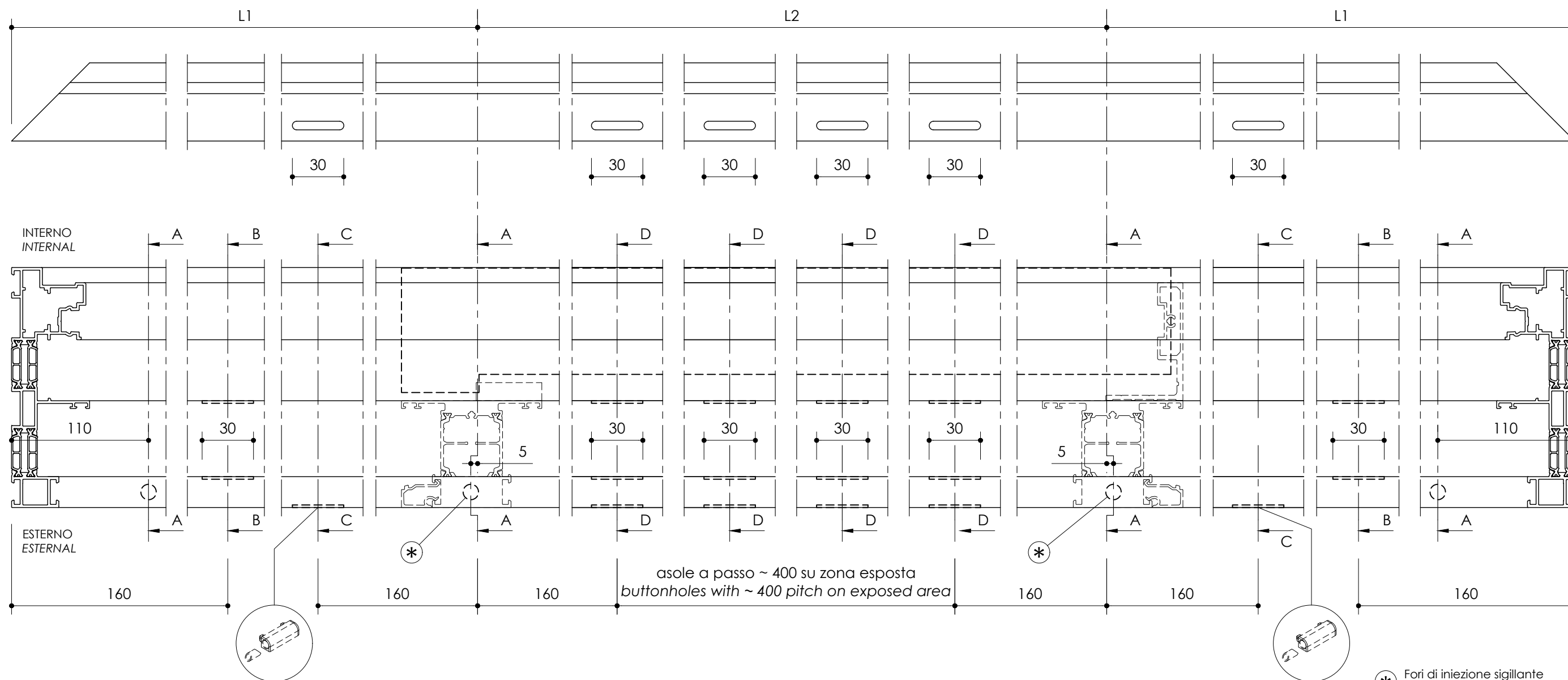
Ext. _____



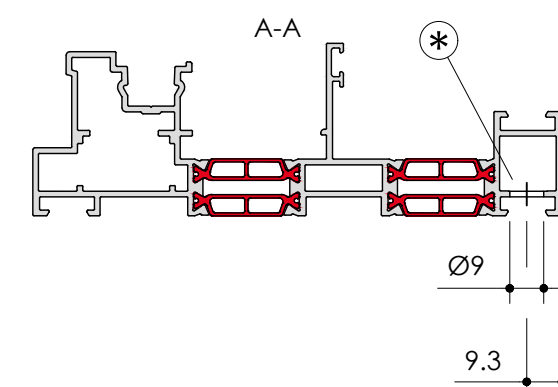
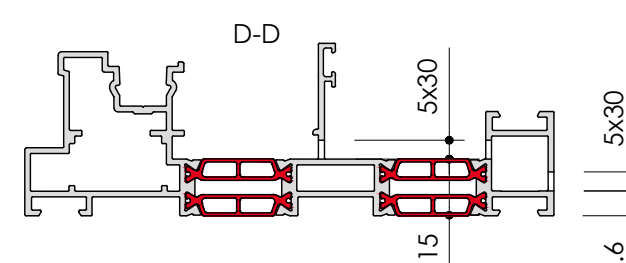
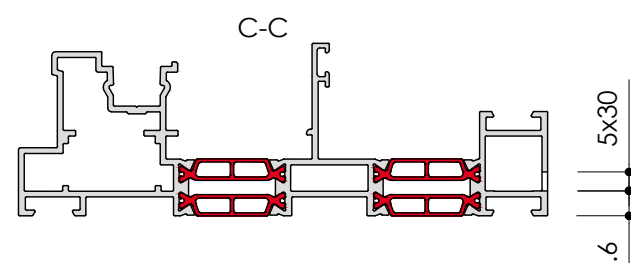
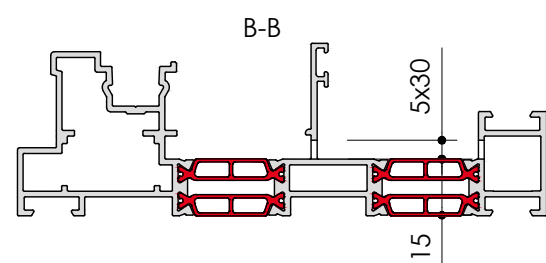
➤ LAVORAZIONE DRENAGGIO SOGLIA U10000 SOLUZIONE OXO
U10000 THRESHOLD DRAINAGE MACHINING OXO SOLUTION

F	↶	F
S140 L&S	●	S140 R

Int.
Ext.



* Fori di iniezione sigillante
Sealant injection holes

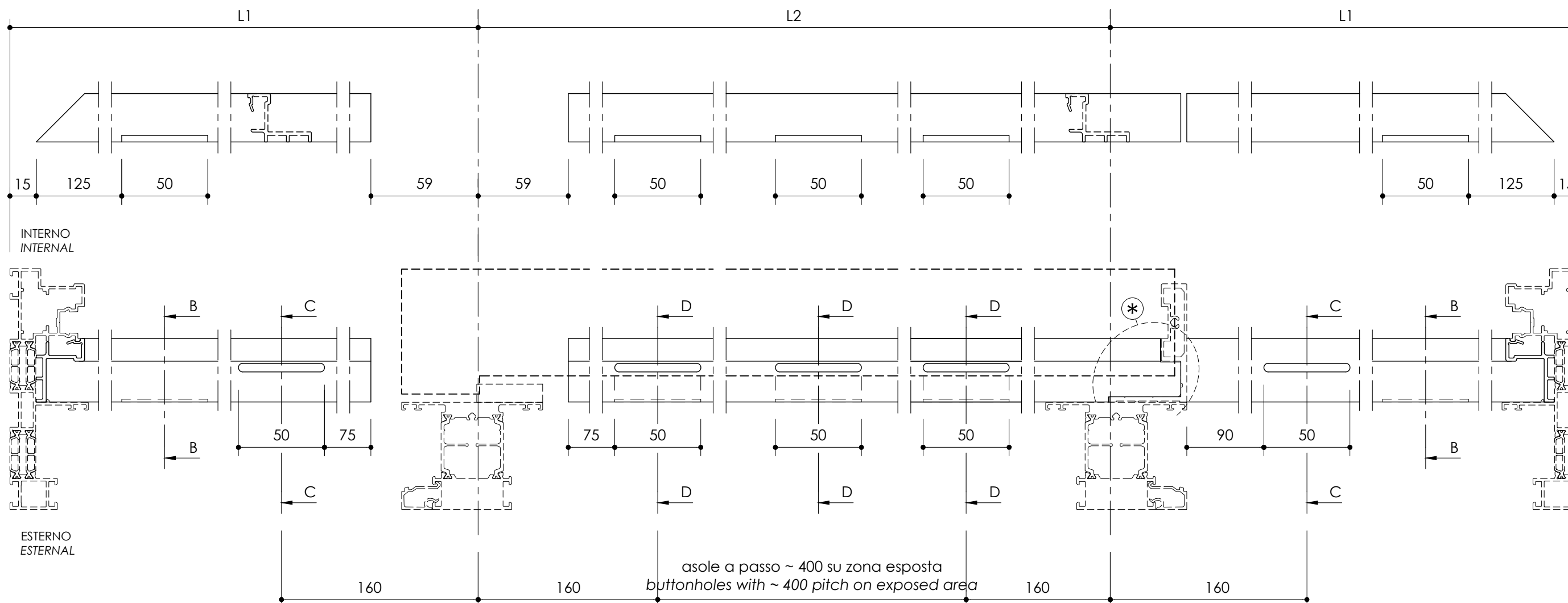


Per le asole interne 5x30
usare fresa 909333
For the 5x30 internal slots use
909333 milling accessory

LAVORAZIONE DRENAGGIO COVER V31212 SOLUZIONE OXO V31212 COVER DRAINAGE MACHINING OXO SOLUTION

F	←	F
S140 L&S	●	S140 R

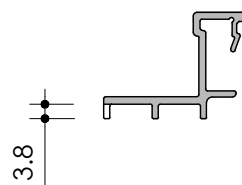
Int.
Ext.



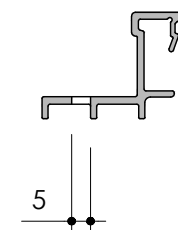
* Per lavorazione intestatura cover vedere pagina dedicata

For cover butting machining, see the dedicated page

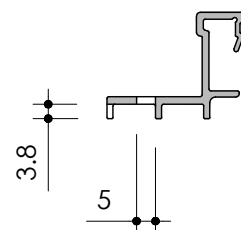
B-B



C-C

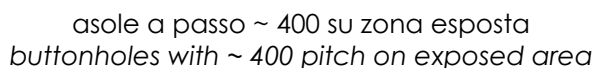


D-D



F	←	F
---	---	---

Ext.



Per le asole interne 5x30
usare fresa 909333

*For the 5x30 internal slots use
909333 milling accessory*

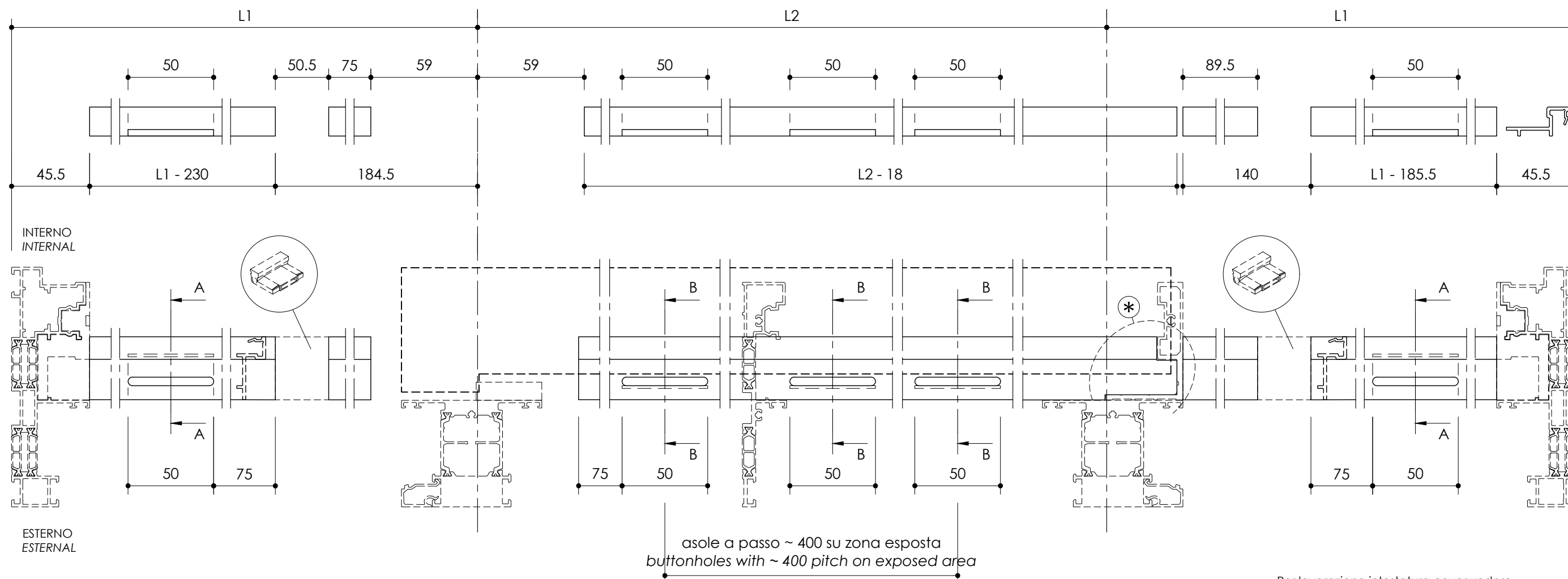
F-F N10822 / N10823
N10820 / N10821
N10905

Lavorazioni F-F eseguibili con tranciante T0061
F-F machining executable with T0061

LAVORAZIONE DRENAGGIO COVER V31211 SOLUZIONE OXO V31211 COVER DRAINAGE MACHINING OXO SOLUTION

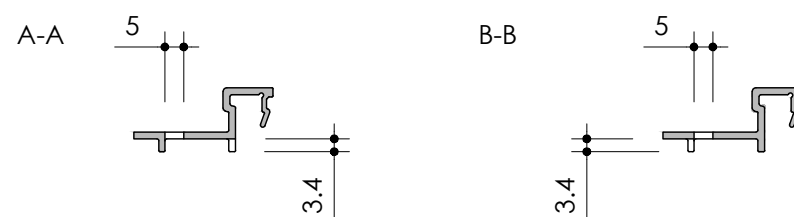
F	←	F
S140 L&S	●	S140 R

Int.
Ext.

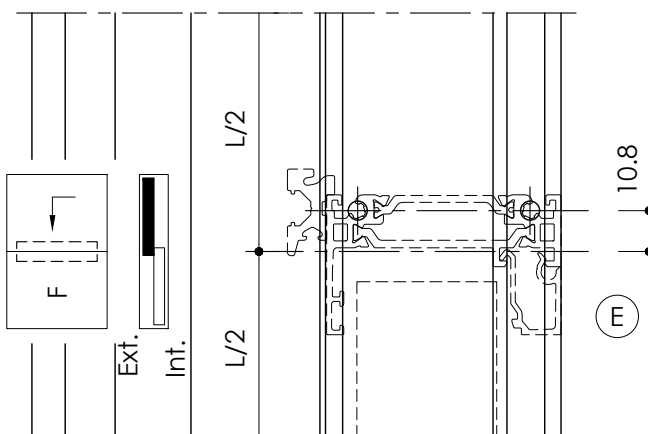
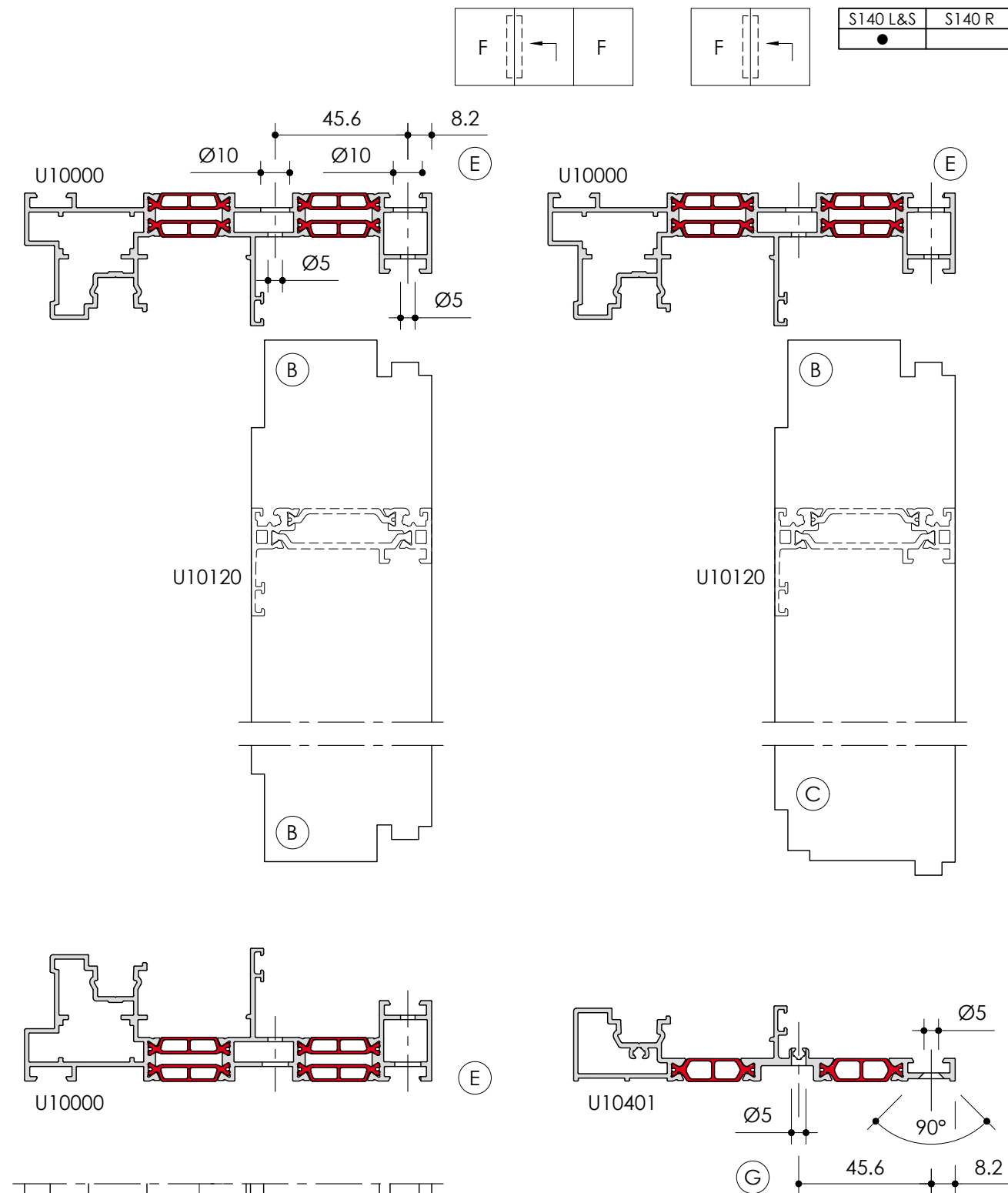
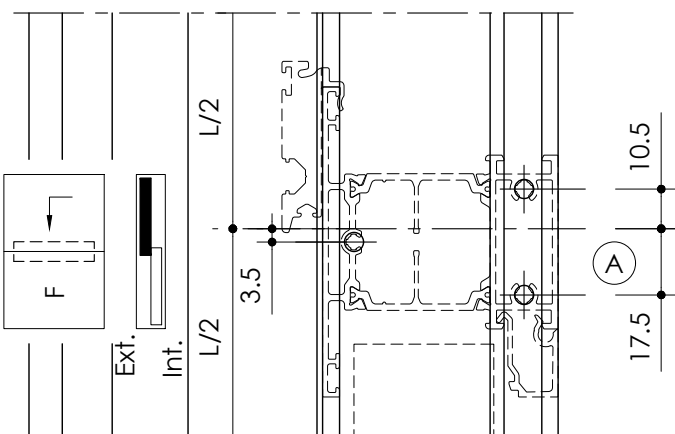
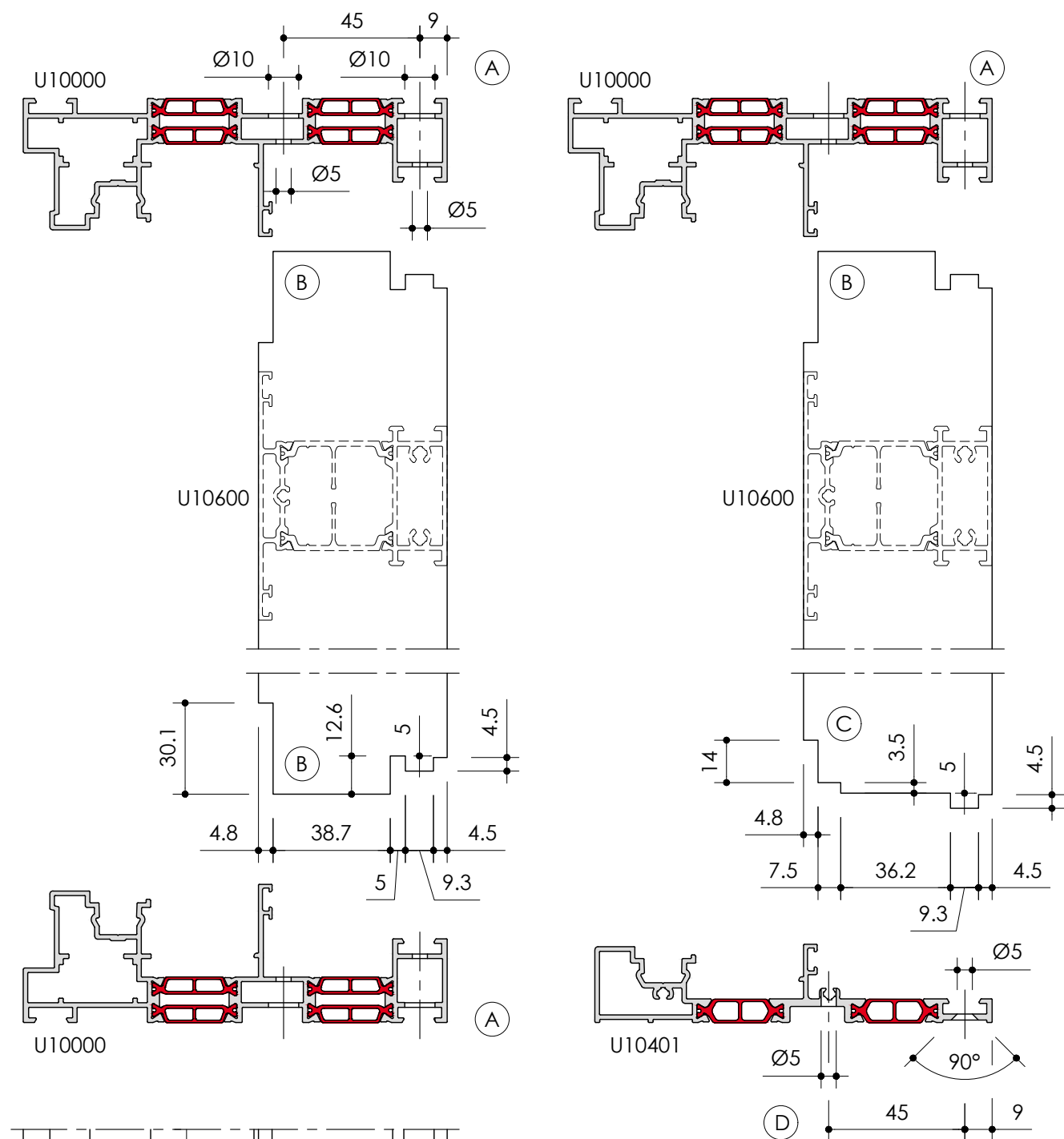


* Per lavorazione intestatura cover vedere pagina dedicata

For cover butting machining, see the dedicated page



▶ LAVORAZIONE PER ASSEMBLAGGIO MONTANTE CENTRALE OX E OXO MACHINING FOR THE CENTRAL MULLION OX AND OXO ASSEMBLING

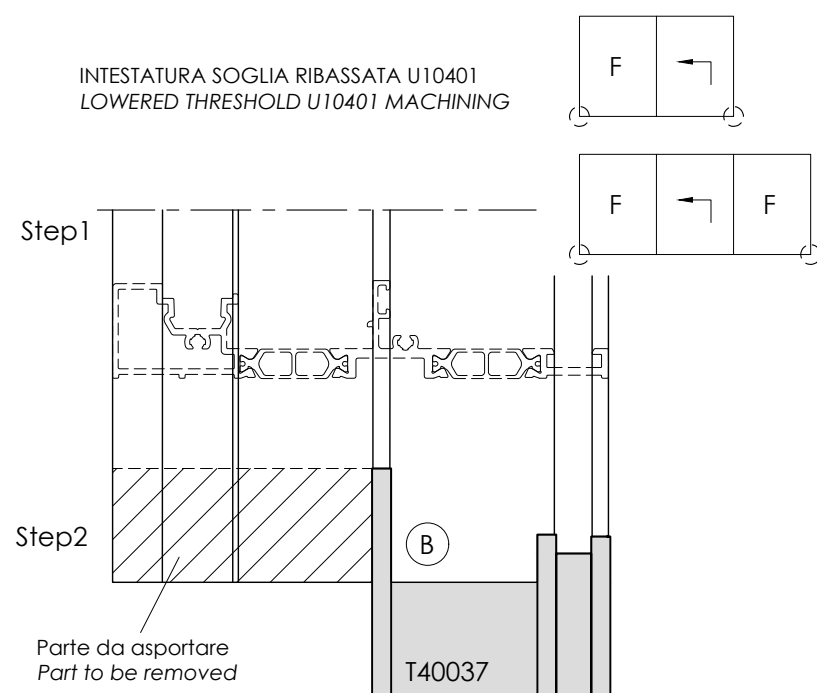


⚠
 Attenzione alla corretta posizione dei montanti,
 questo per garantire la corretta tenuta dei labirinti.
 Attention to the correct position of the mullion,
 this is to guarantee the correct tightness of the interlock.

LAVORAZIONI VARIE PROFILI SOLUZIONE OX E OXO VARIOUS SOLUTION OX AND OXO PROFILES MACHININGS

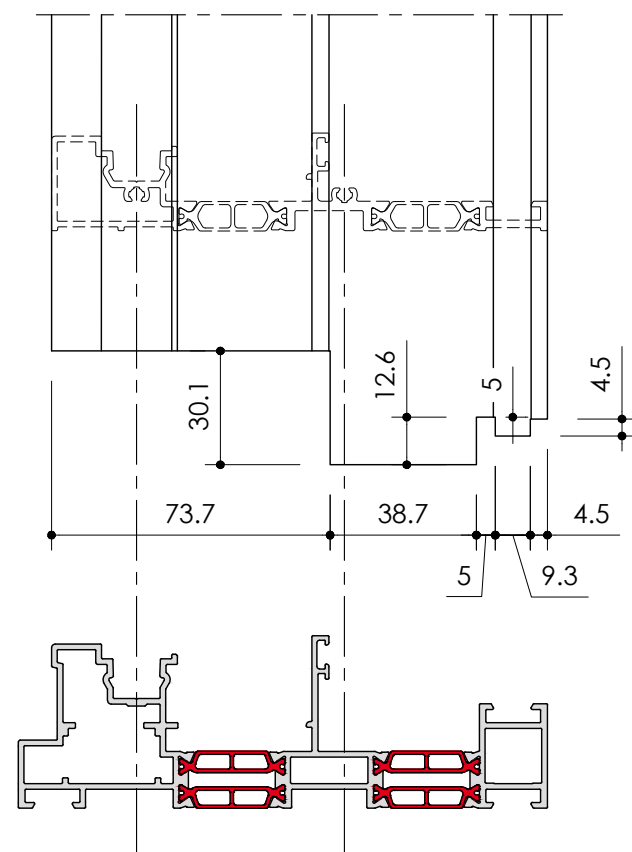
S140 L&S	S140 R
●	

INTESTATURA SOGLIA RIBASSATA U10401
LOWERED THRESHOLD U10401 MACHINING

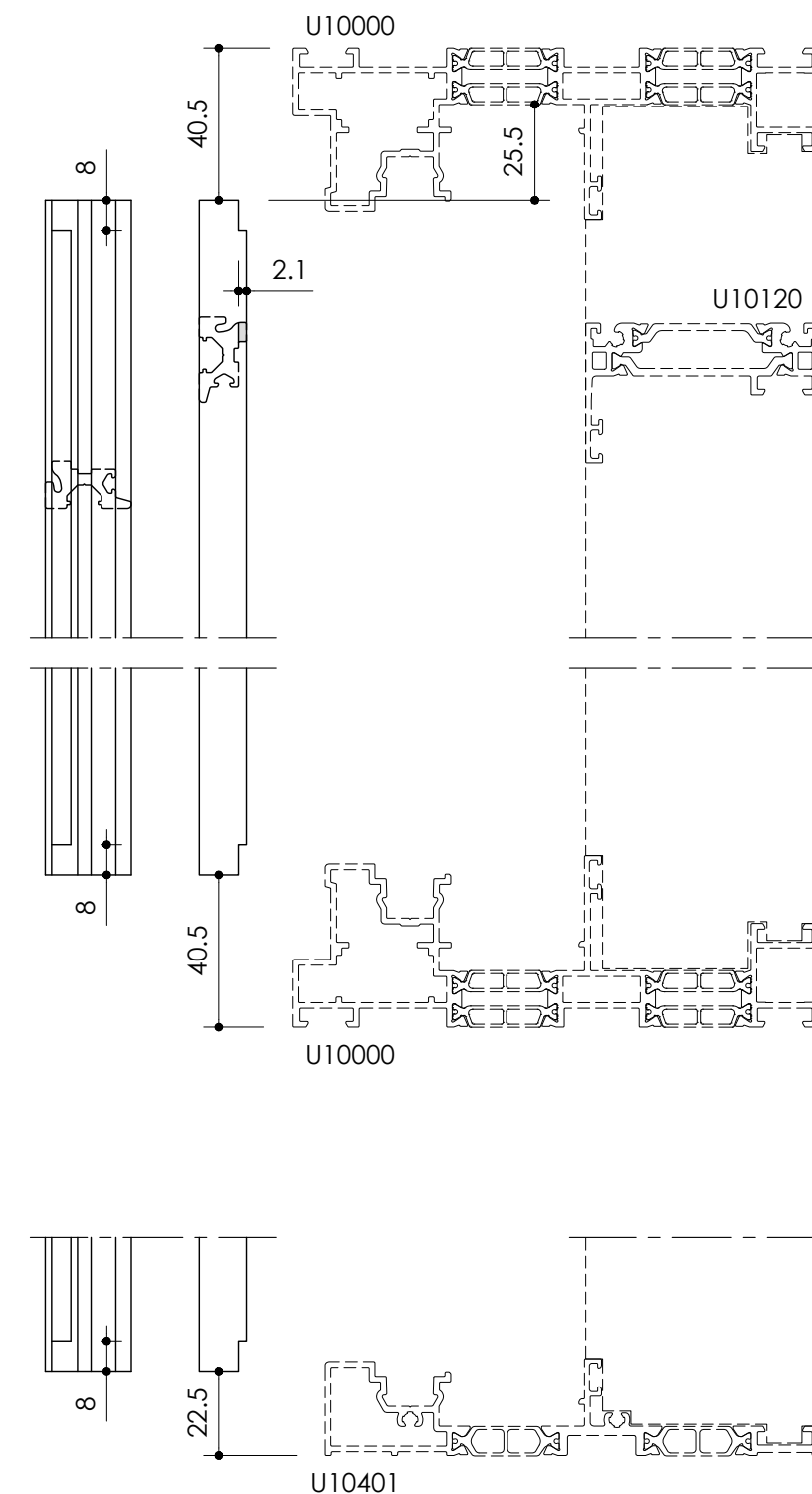
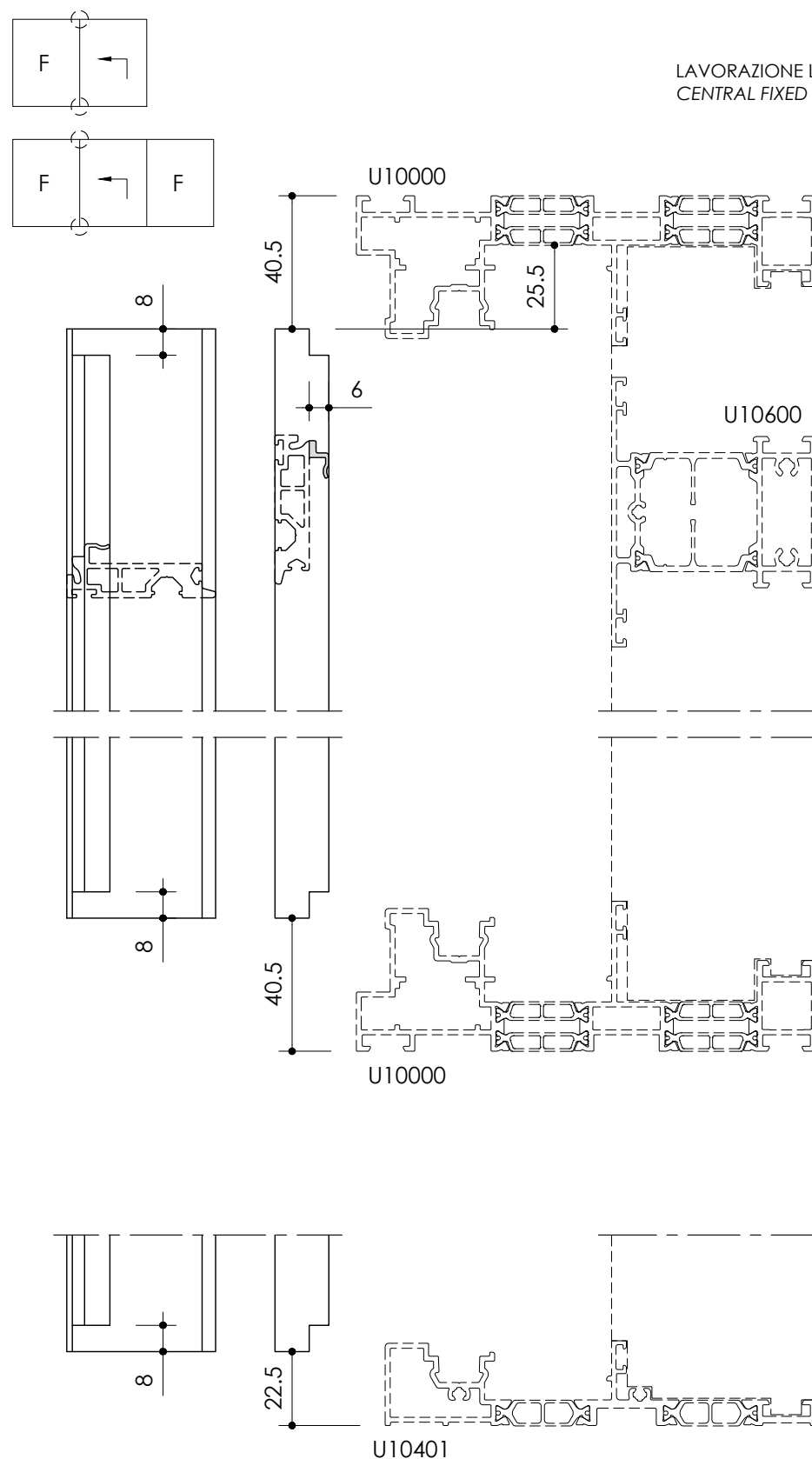


Step1 - Lavorazione B eseguibile con gruppo fresa T40037
Step2 - Asportare parte esterna

Step1 - Machining B can be performed with the T40037 milling accessory
Step2 - Remove the external part

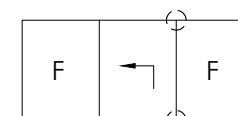
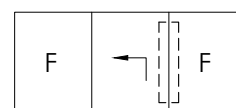
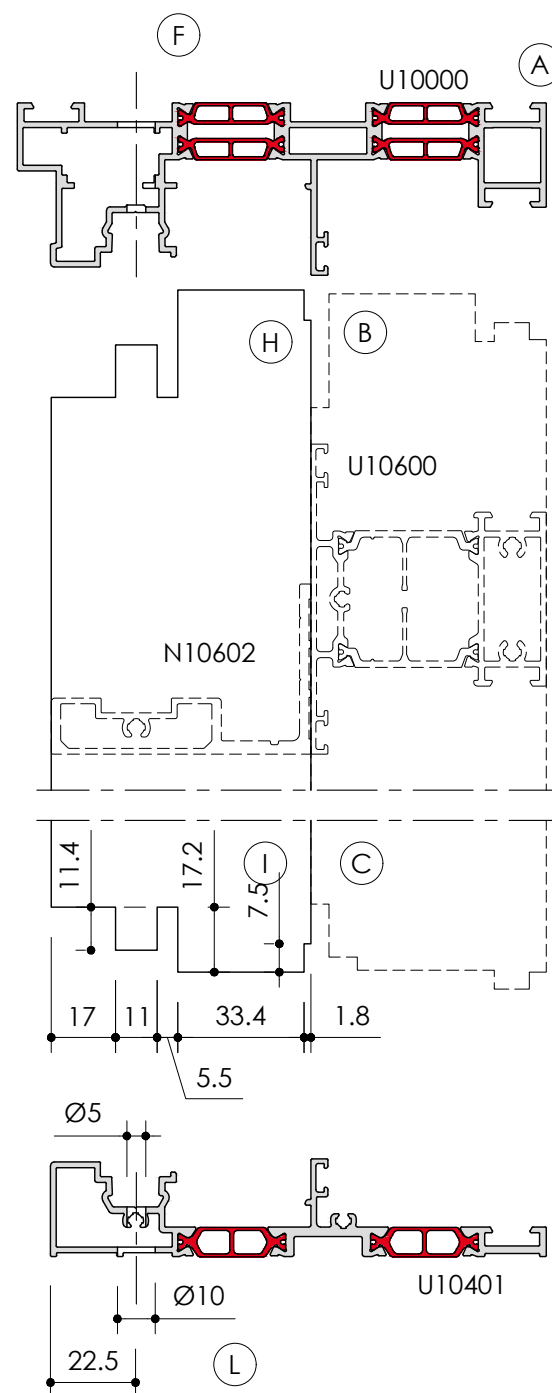
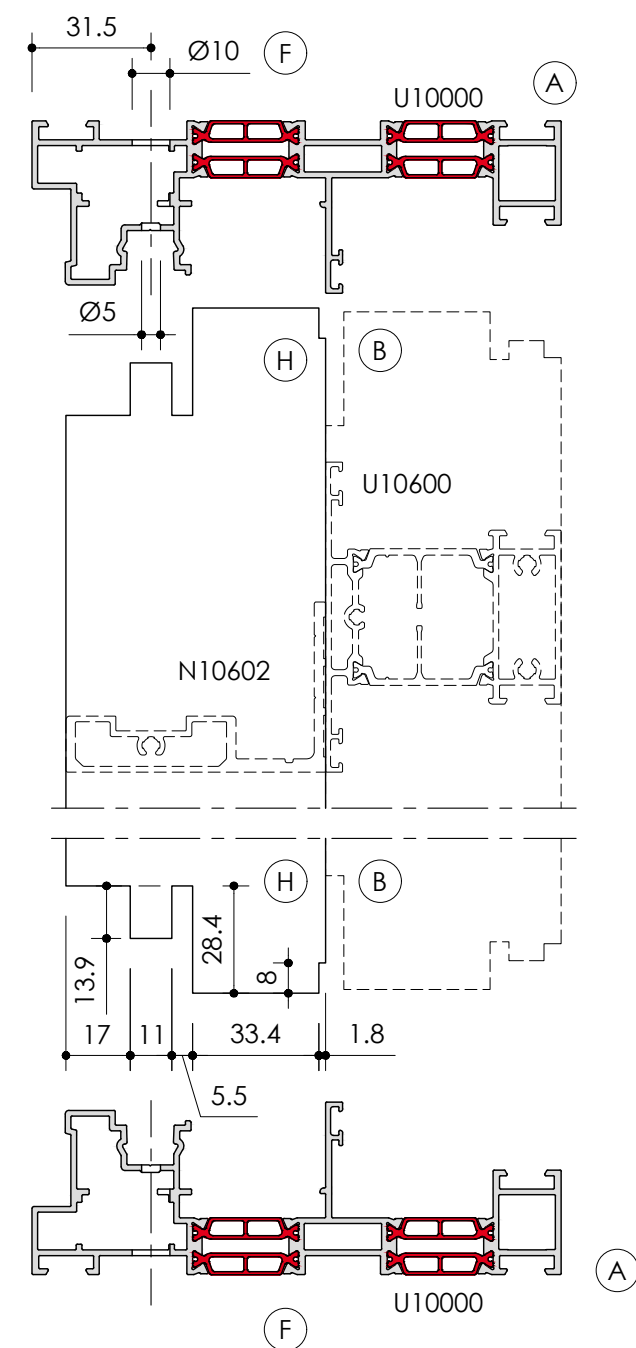


LAVORAZIONE LABIRINTO MONTANTE CENTRALE
CENTRAL FIXED MULLION INTERLOCK MACHINING

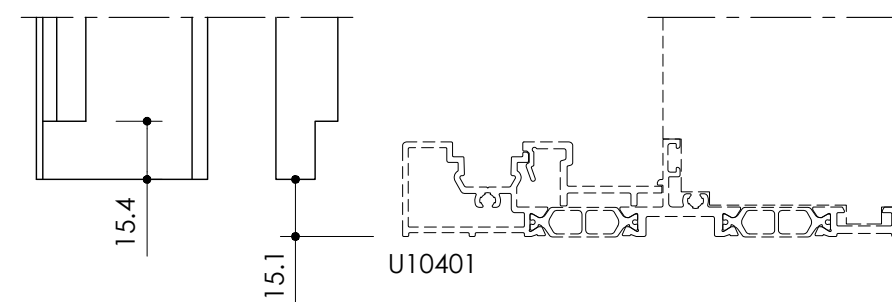
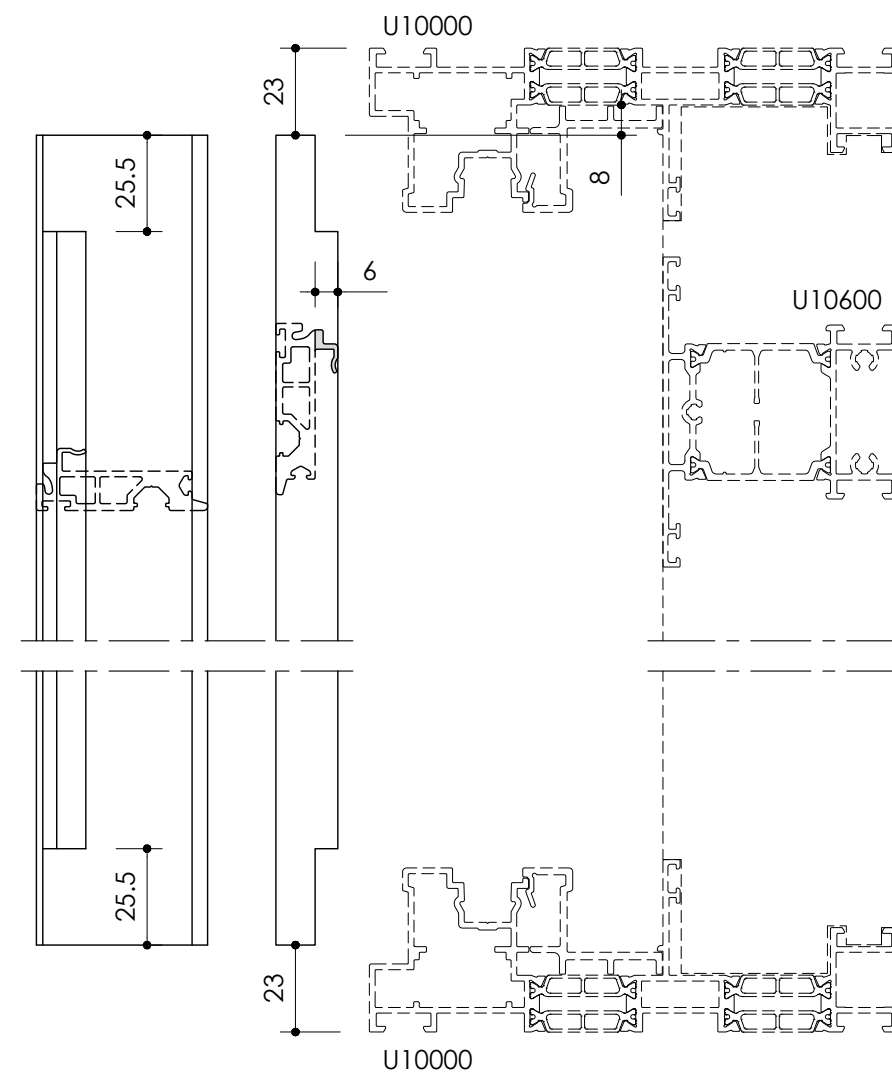


LAVORAZIONE PER ASSEMBLAGGIO MONTANTE CENTRALE OXO MACHINING FOR THE CENTRAL MULLION OXO ASSEMBLING

S140 L&S	S140 R
●	



LAVORAZIONE LABIRINTO MONTANTE CENTRALE
 CENTRAL FIXED MULLION INTERLOCK MACHINING



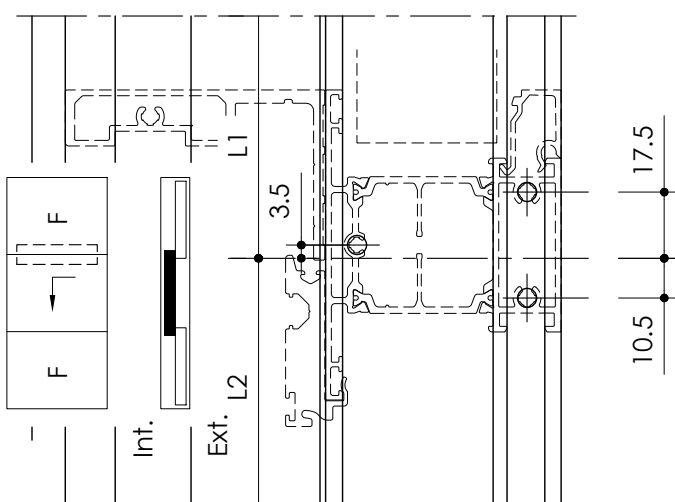
Lavorazione H eseguibile con gruppo fresa T10046
 Lavorazione I eseguibile con gruppo fresa T10047
 Lavorazione F, L, eseguibile con dima T10082

Machining H can be performed with the T10046 milling accessory
 Machining I can be performed with the T10047 milling accessory
 Machining F, L, executable with T10082 template



Attenzione alla corretta posizione dei montanti,
 questo per garantire la corretta tenuta dei labirinti.

Attention to the correct position of the mullion,
 this is to guarantee the correct tightness of the interlock.

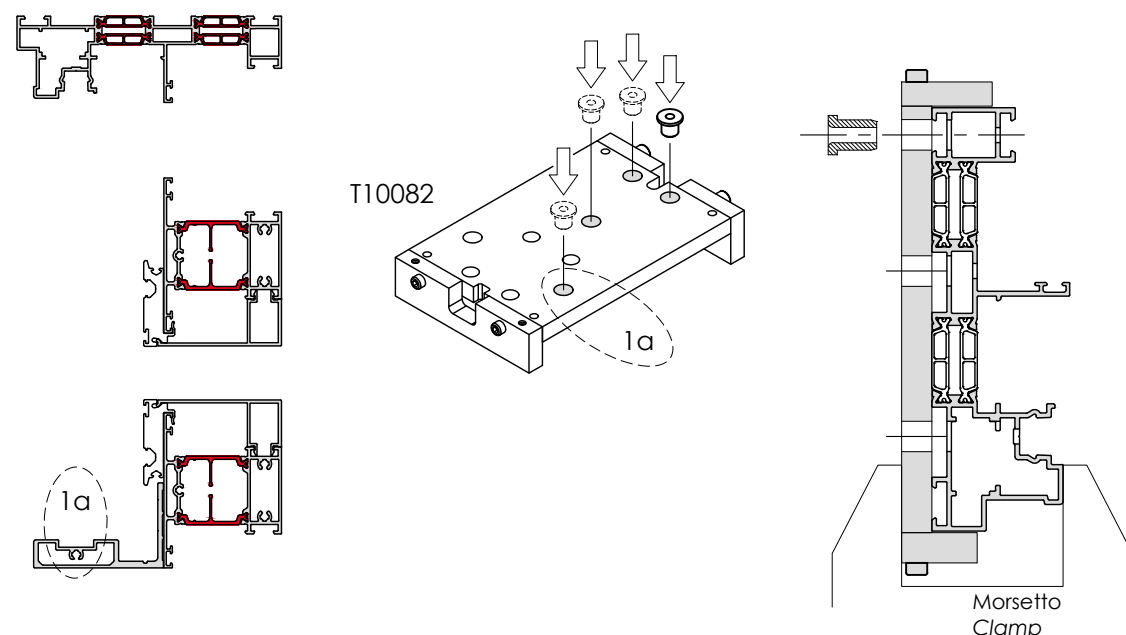


LAVORAZIONE DI FORATURA PER ASSEMBLAGGIO TELAIO OX E OXO PROFILO MONTANTE U10600

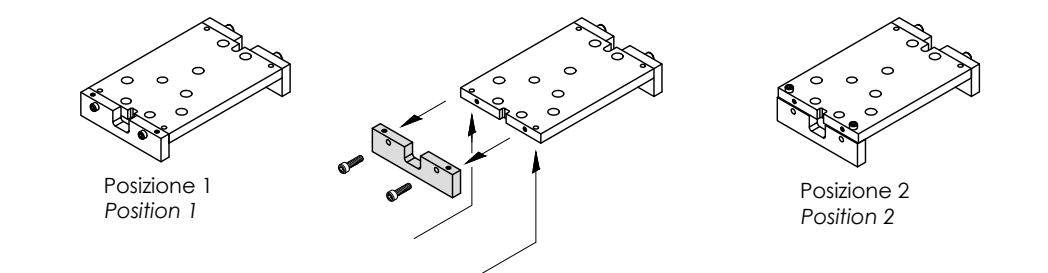
DRILLING MACHINING FOR ASSEMBLING OX FRAME AND OXO MULLION PROFILE U10600

S140 L&S	S140 R
●	

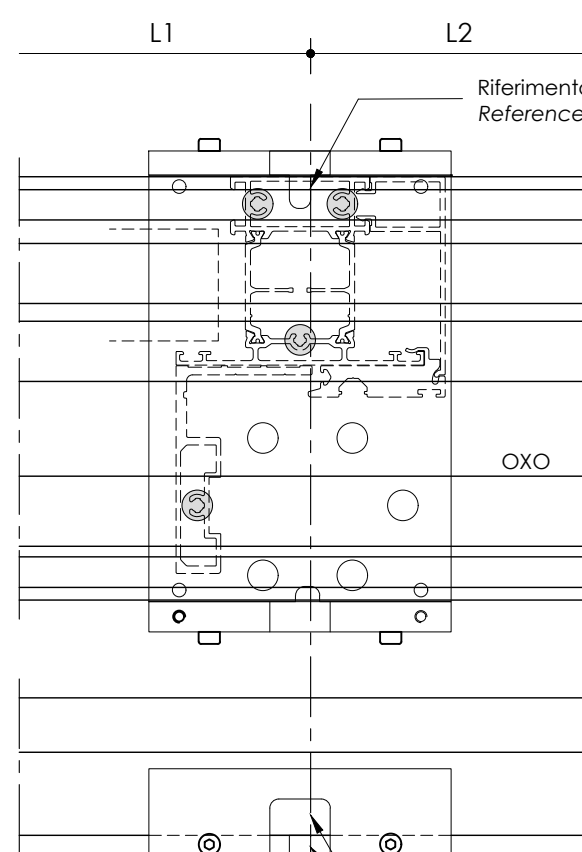
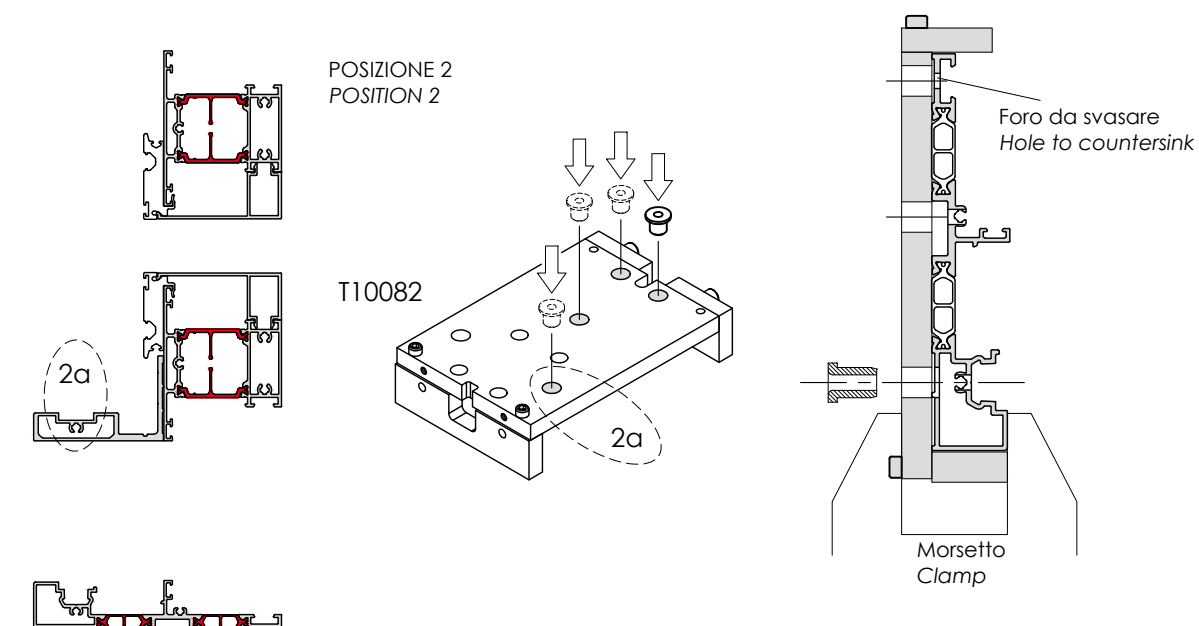
POSIZIONE 1
POSITION 1



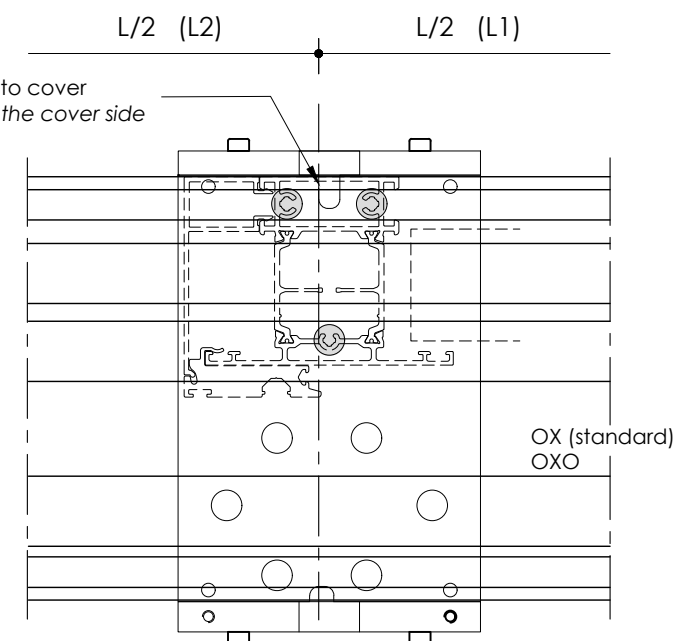
MONTAGGIO DIMA PER LAVORAZIONE U10600 E N10602
TEMPLATE ASSEMBLY FOR U10600 AND N10602 MACHINING



POSIZIONE 2
POSITION 2

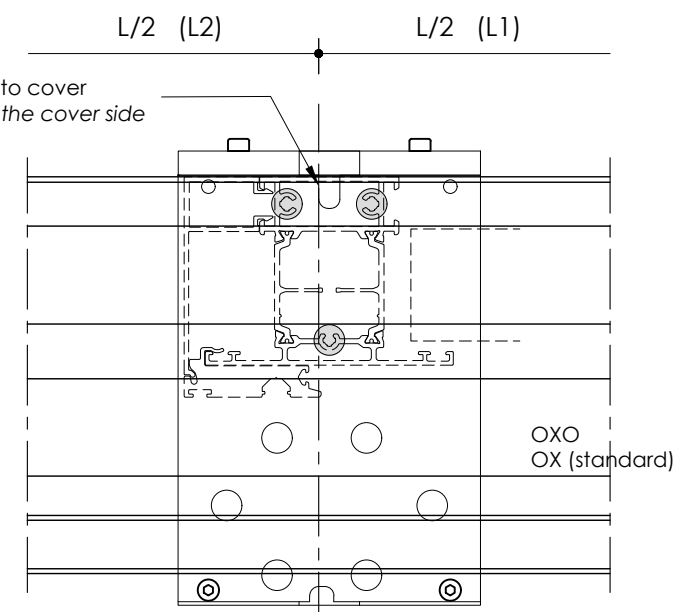
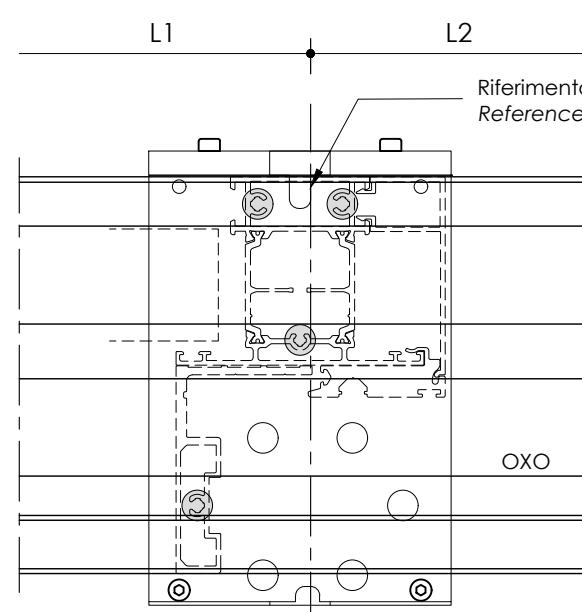


Si consiglia di segnare L/2 o L1 sul fianco ed allinare con lo spigolo della piastra
It is advisable to mark L/2 or L1 on the side and align with the edge of the plate



Step1 - Allineare la dima con il riferimento L/2 o L1
Step2 - Fissare la dima al profilo mediante "morsetto"
Step3 - Eseguire i fori

Step1 - Align the template with the L/2 or L1 mark
Step2 - Fix the template to the profile using a "clamp"
Step3 - Drill the holes



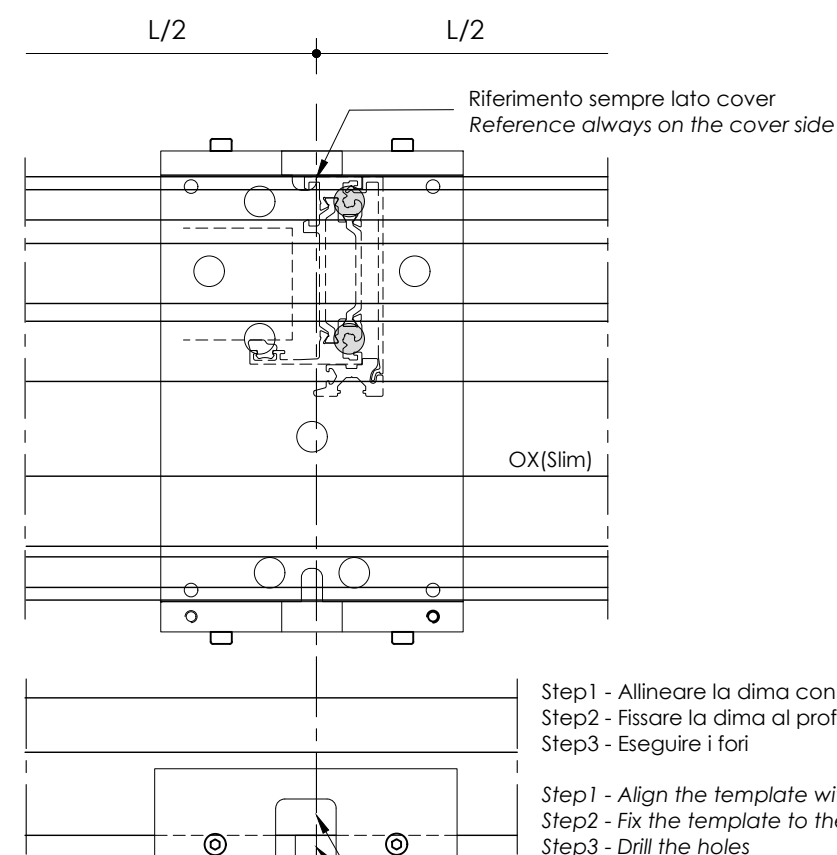
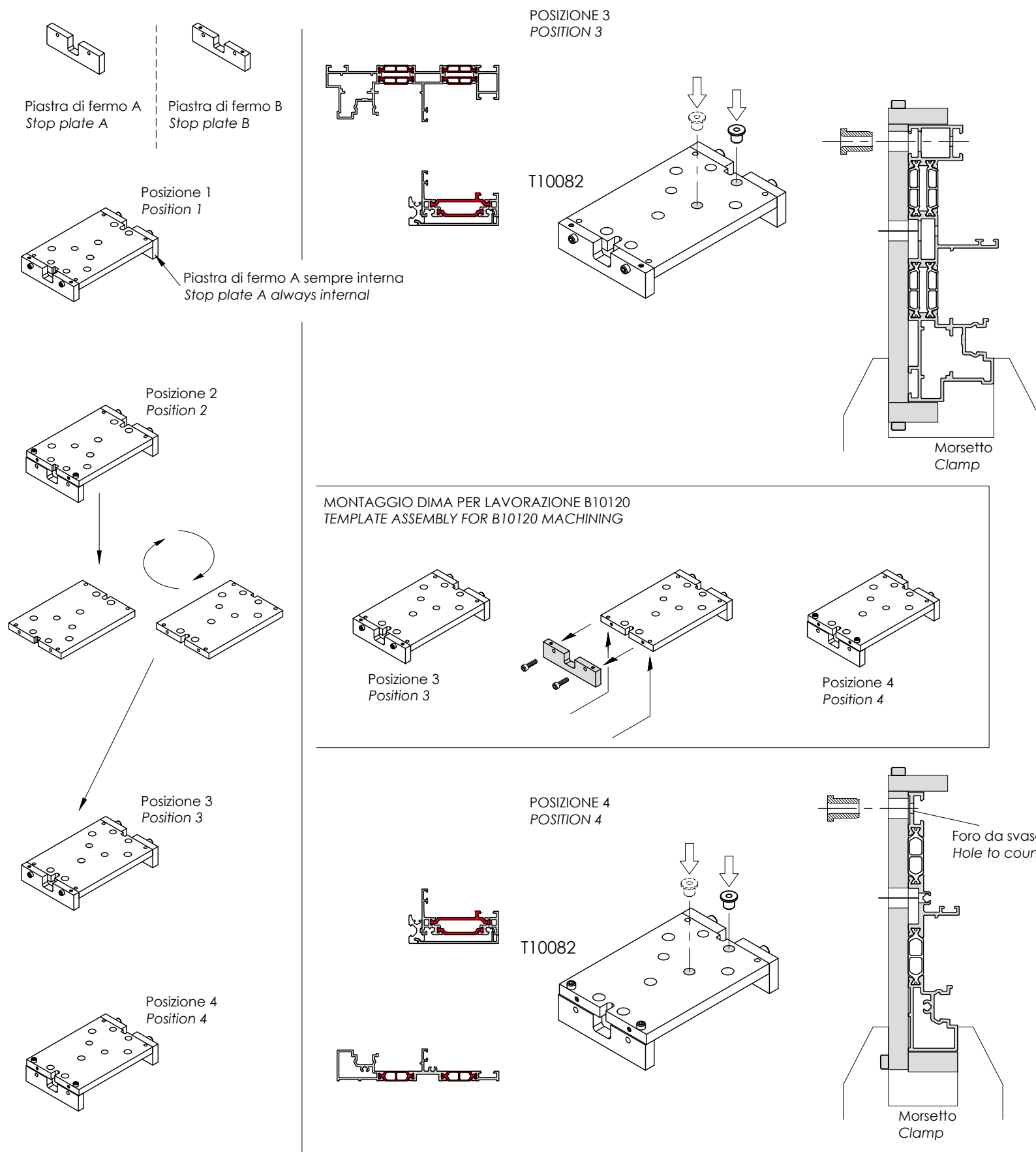
△ Controllare il verso della lavorazione in funzione della tipologia di apertura

Check the machining direction according to the type of opening

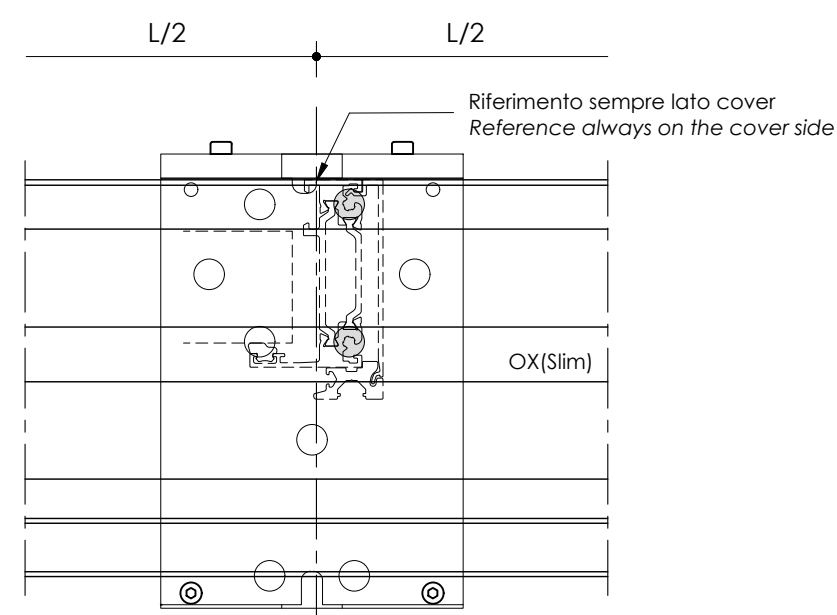
LAVORAZIONE DI FORATURA PER ASSEMBLAGGIO TELAIO OX CON PROFILO MONTANTE U10120

DRILLING MACHINING FOR ASSEMBLING OX FRAME MULLION PROFILE U10120

S140 L&S	S140 R
●	



Si consiglia di segnare L/2 sul fianco ed allinare con lo spigolo della piastra
It is advisable to mark L/2 on the side and align with the edge of the plate

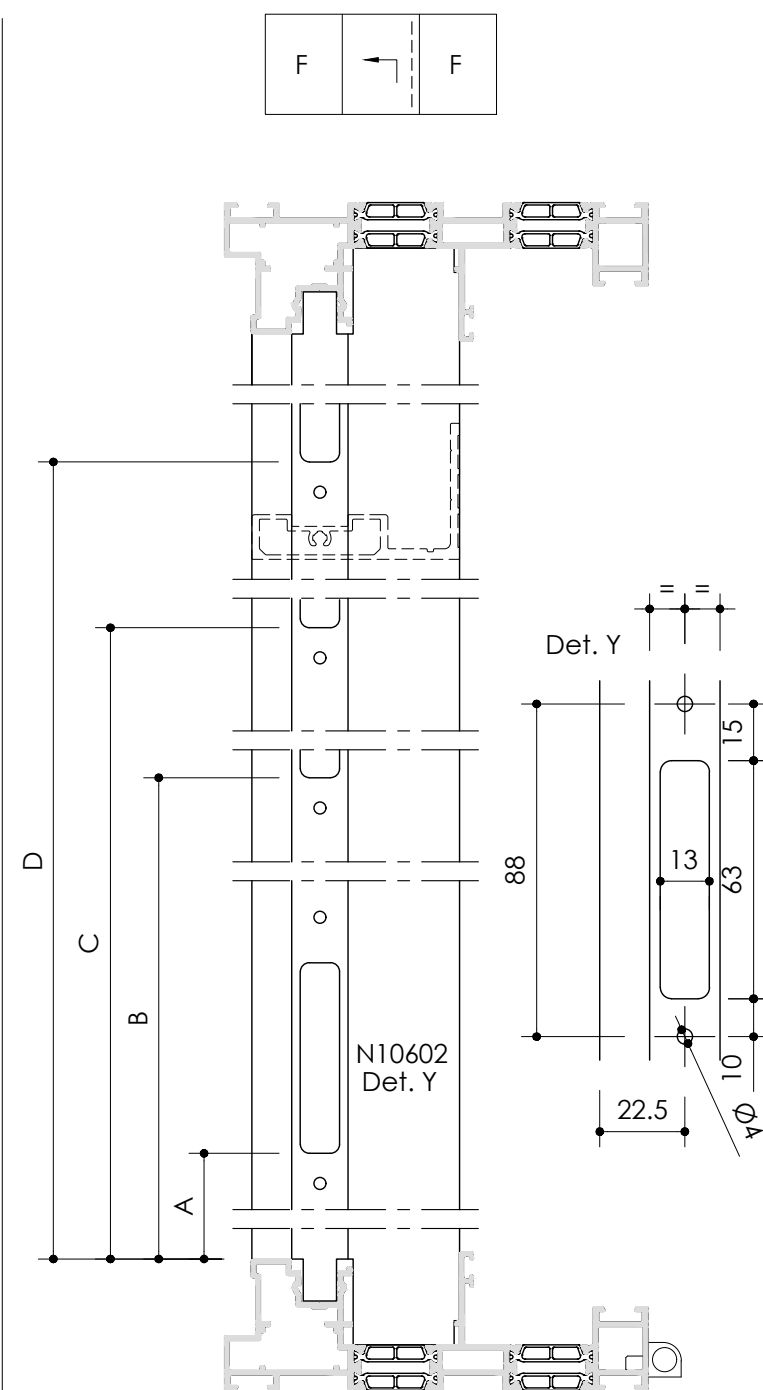
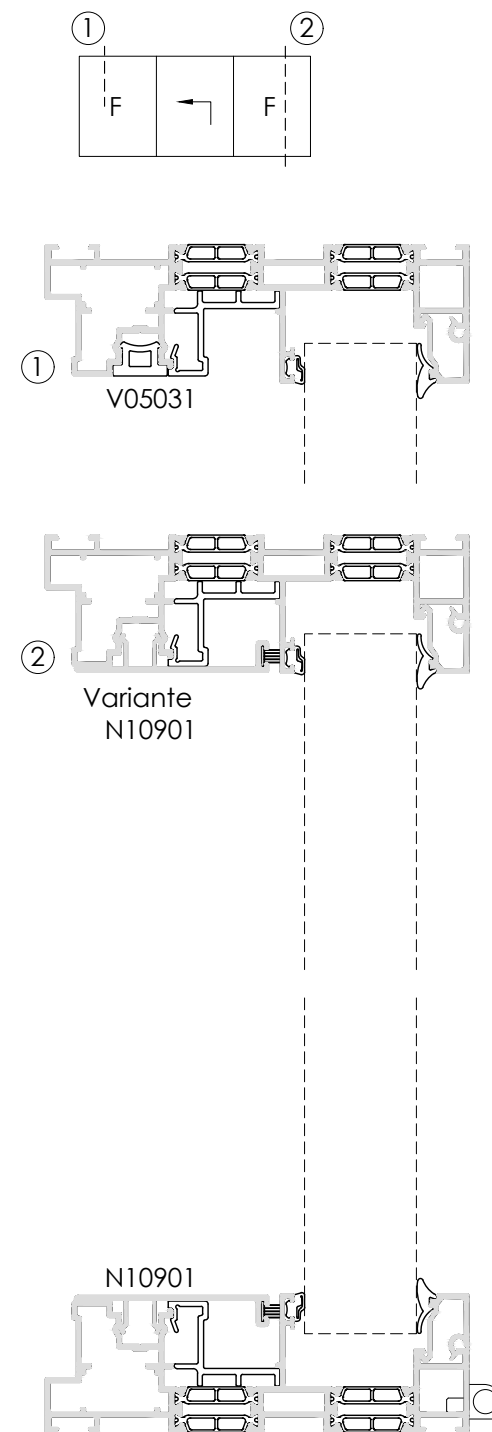
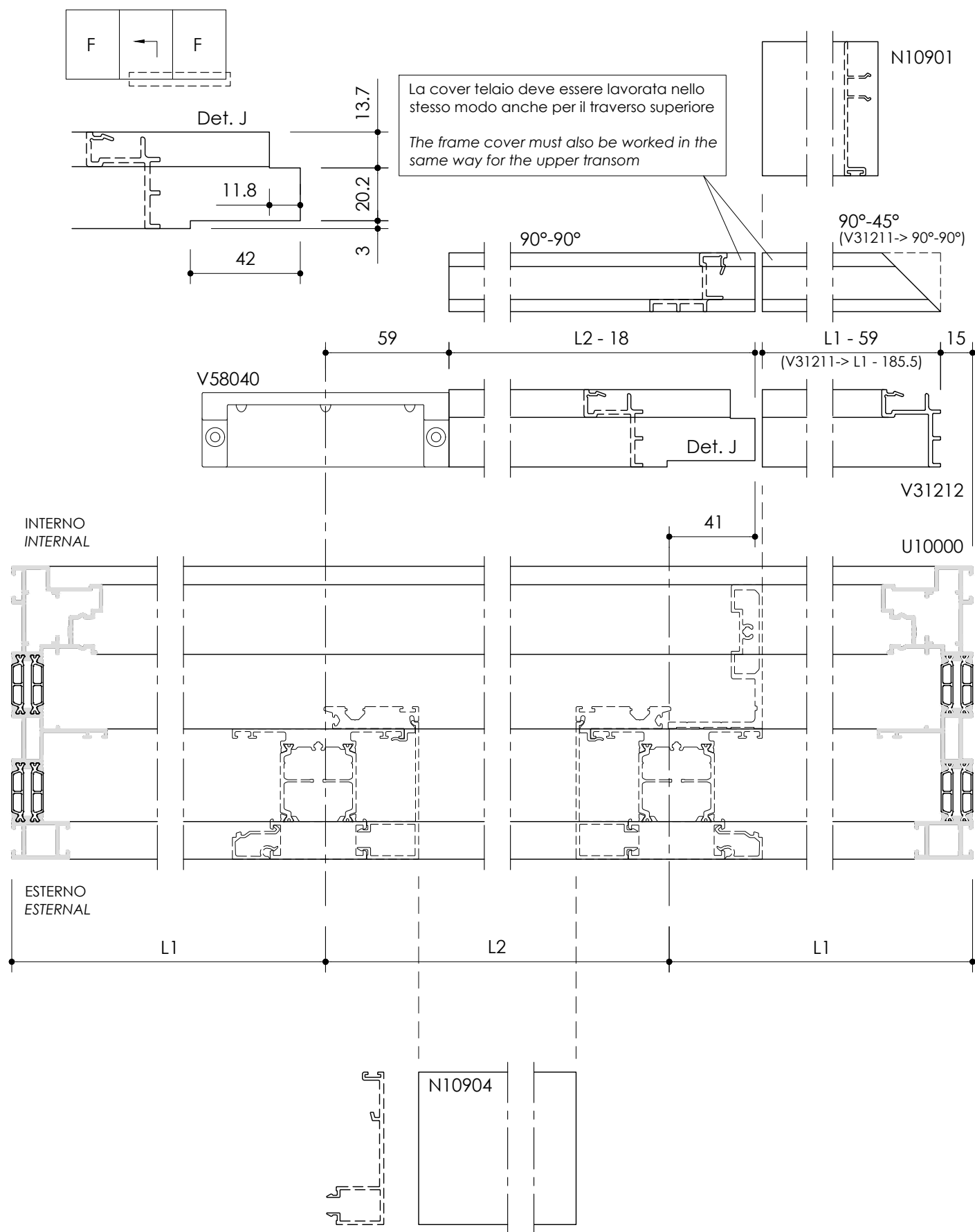


△ Controllare il verso della lavorazione in funzione della tipologia di apertura

Check the machining direction according to the type of opening

LAVORAZIONI VARIE PROFILI SOLUZIONE OXO
VARIOUS SOLUTION OXO PROFILES MACHININGS

S140 L&S	S140 R
●	

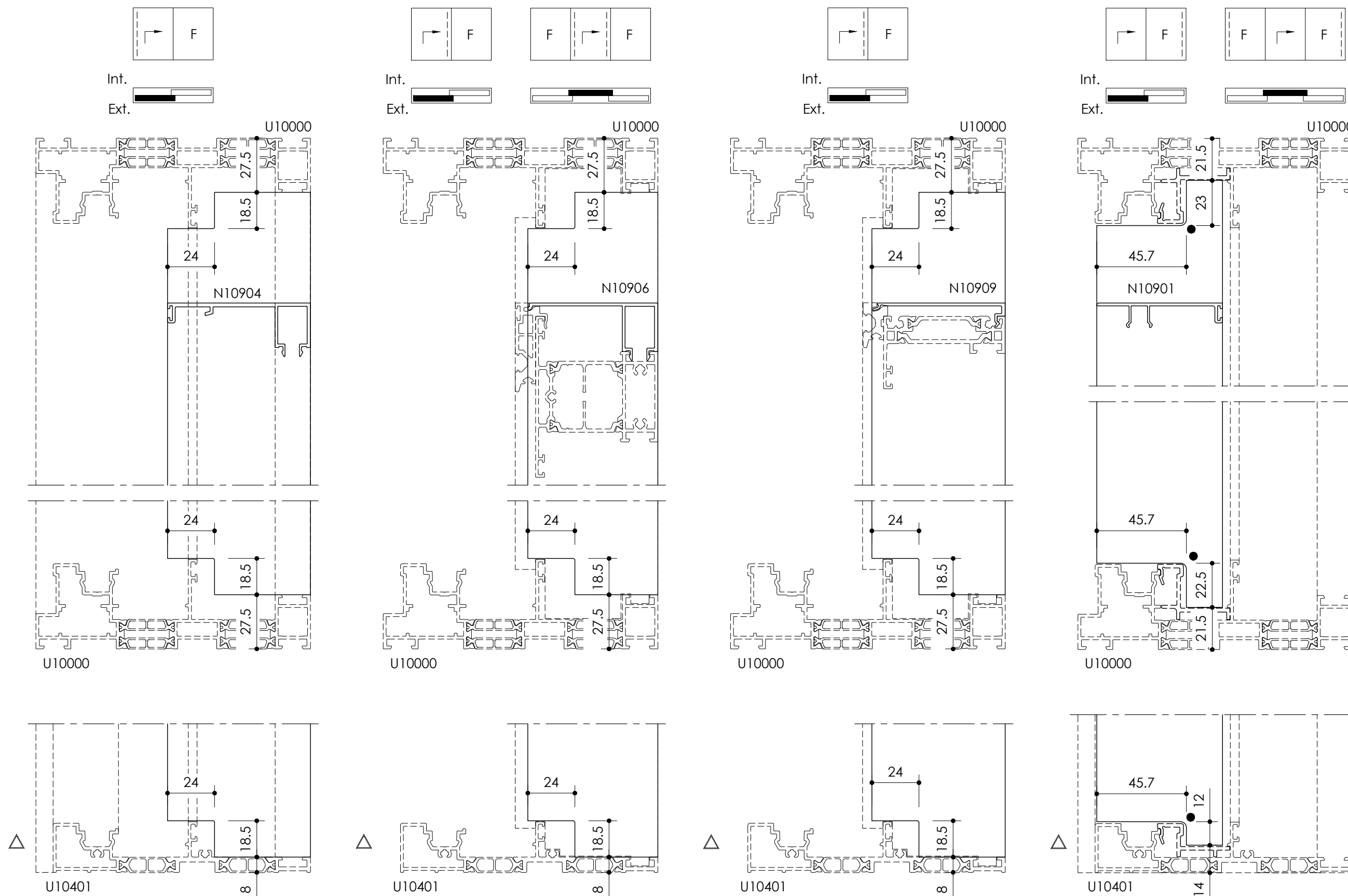


Acc	A	B	C	D
H10402	-	576	976	-
H10403	226	726*	1176*	1576
H10404	226	726*	1176*	1876
H10405	226	726*	1176*	2176

*Incontri opzionali , punto di chiusura aggiuntivo cod. H10400
*Optional counterplate, additional closing point cod. H10400

➤ LAVORAZIONI PROFILI COVER OX N10900 N10901 N10904 e N10906
N10900, N10901, N10904 AND N10906 OX COVER PROFILES MACHININGS

S140 L&S	S140 R
●	

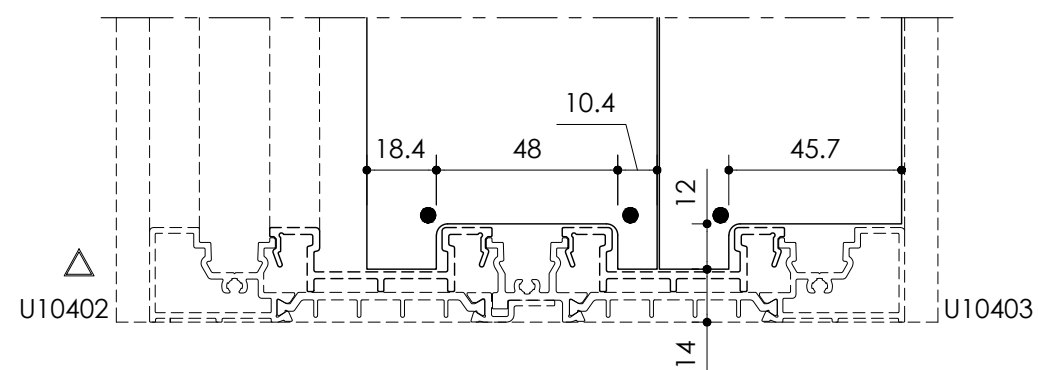
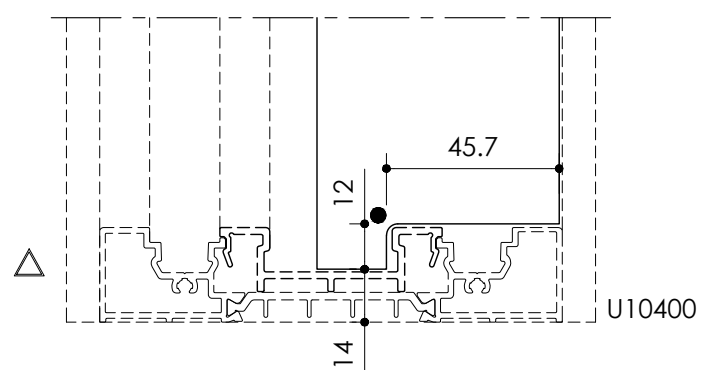
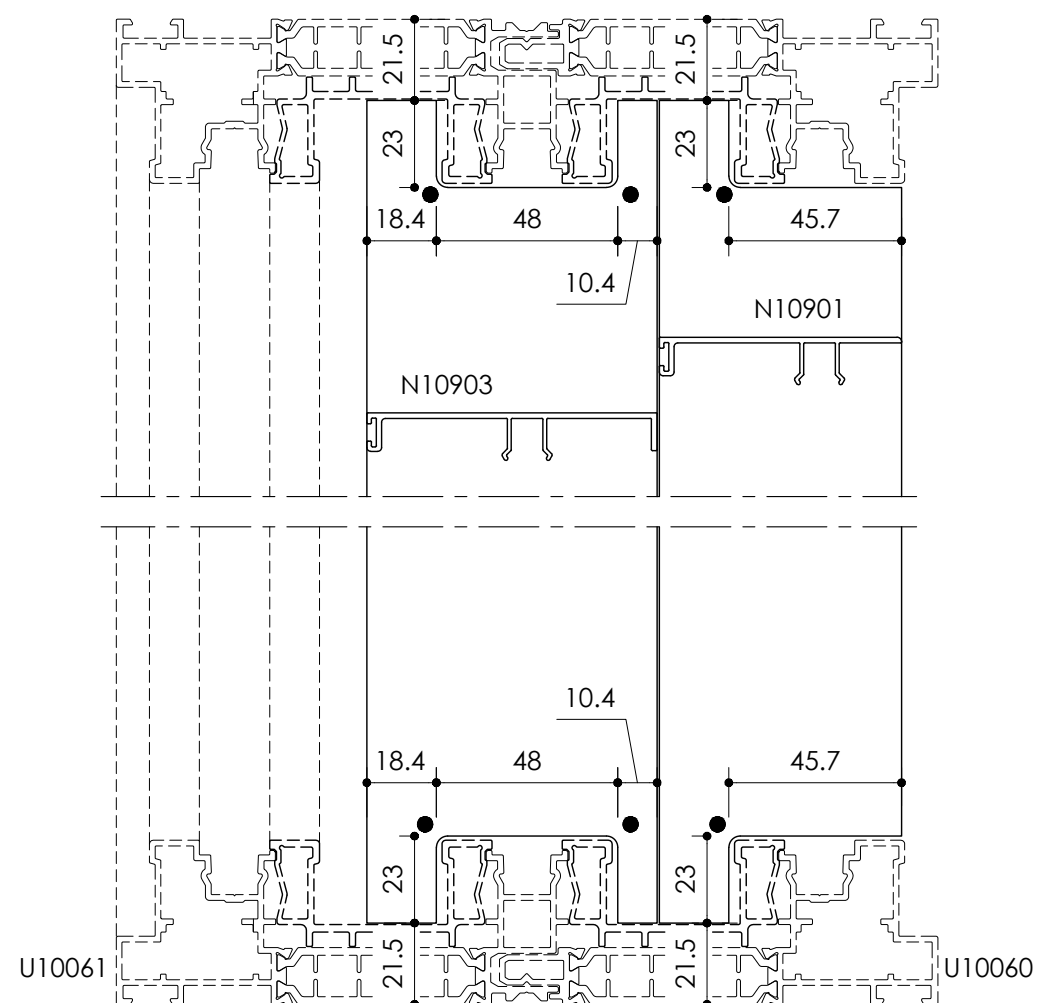
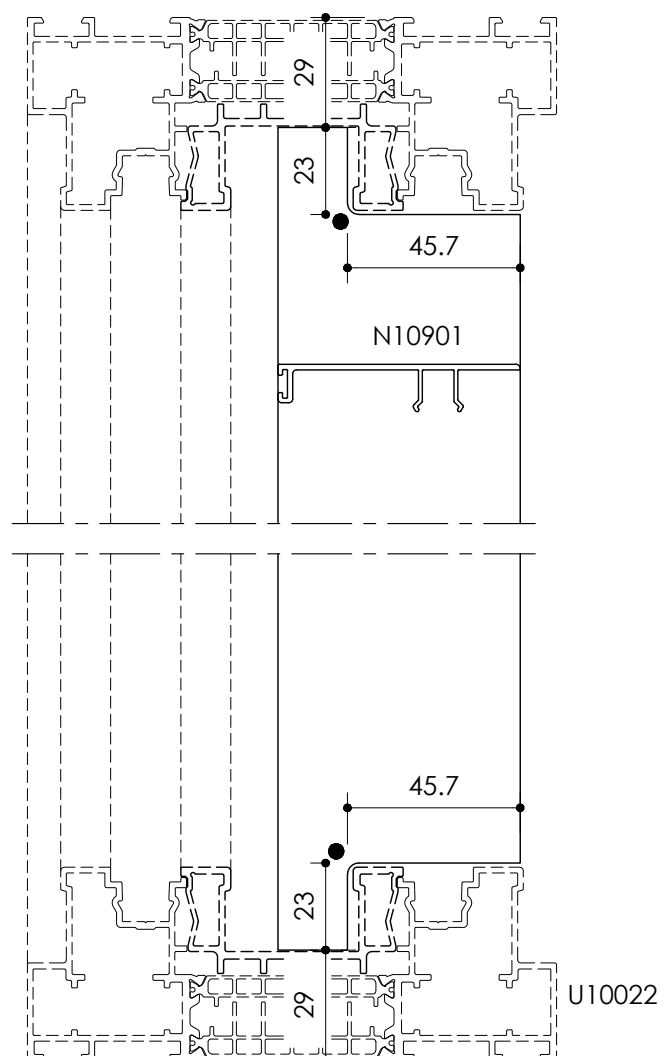
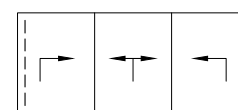
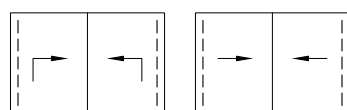


● R=2 mm
Lavorazioni eseguibili con tranciante T00061
Machining executable with T00061 punching tool

△ Controllare il verso della lavorazione in funzione della tipologia di apertura
Check the machining direction according to the type of opening

➤ LAVORAZIONI PROFILI COVER N10901 e N10903
N10901 AND N10903 COVER PROFILES MACHININGS

S140 L&S	S140 R
●	●

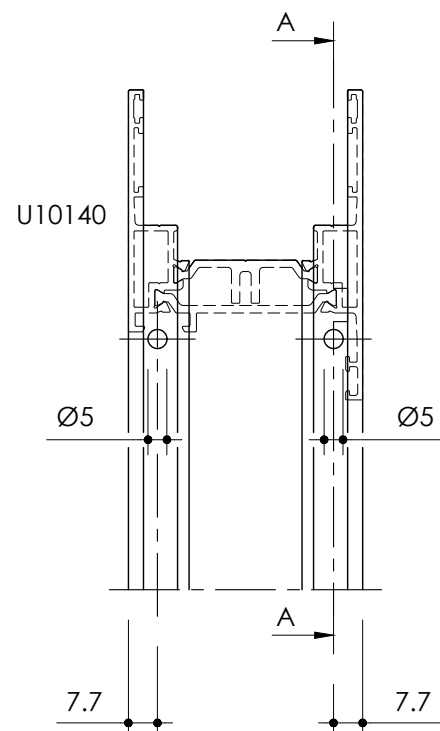
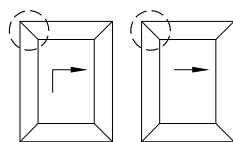


● R=2 mm
Lavorazioni eseguibili con tranciante T00061
Machining executable with T00061 punching tool

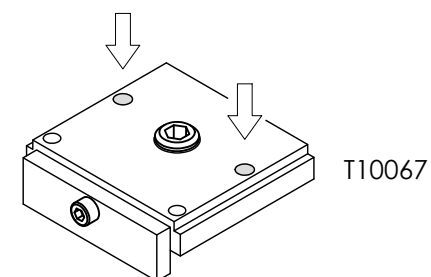
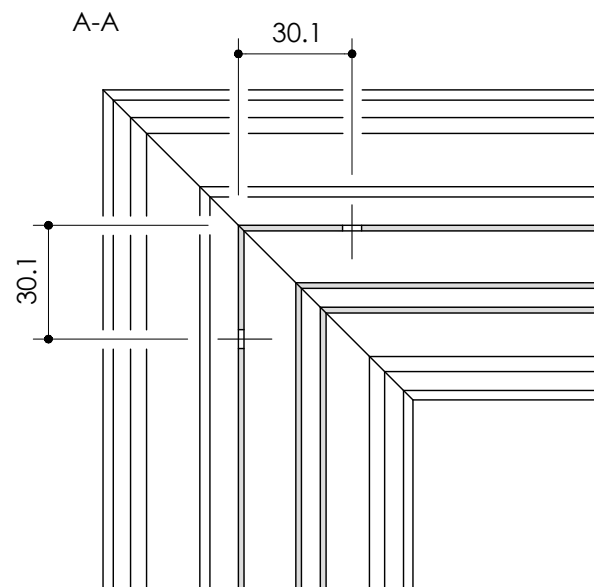
△ Controllare il verso della lavorazione in
funzione della tipologia di apertura
Check the processing direction according
to the type of opening

LAVORAZIONI SQUADRETTA A SPINARE PER ANTA e LAVORAZIONI PER PROFILO MONTANTE CENTRALE ANTA SLIM MACHINING CORNER JOINT TO BE RIVETED FOR SASH WITH SLIM CENTRAL MULLION

S140 L&S	S140 R
●	●

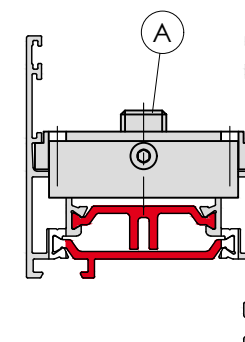


LAVORAZIONE PER SQUADRETTA ANTA
SASH CORNER JOINT MACHINING



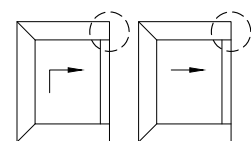
Lavorazioni eseguibili con tranciante T00061
o con dima T10067

Machining executable with T00061
or with T10067 template



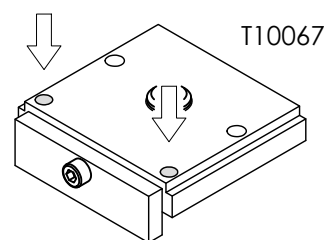
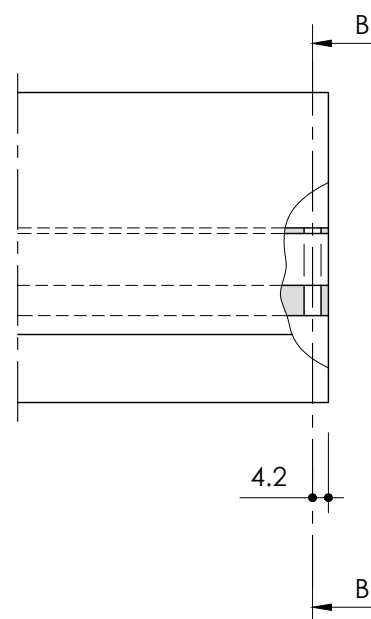
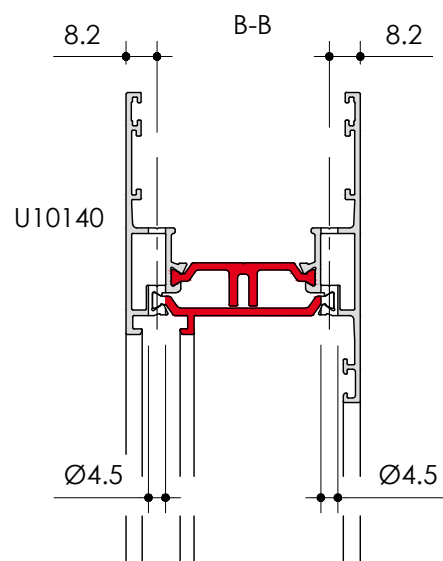
- Inserire la dima nel profilo, fino alla piastra d'arresto
- Bloccare la dima puntando leggermente la vite A
- Forare secondo la tipologia d'utilizzo

- Insert the template into the profile, up to the stop plate
- Lock the template by lightly aiming the A screw
- Drill according to the type of use



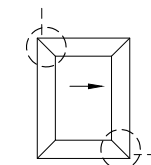
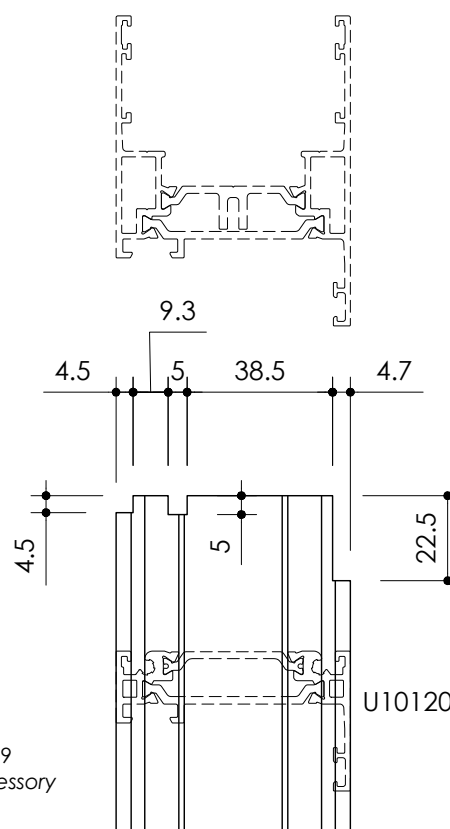
LAVORAZIONE PER MONTAGGIO MONTANTE SLIM CENTRALE
MACHINING FOR SLIM CENTRAL MULLION ASSEMBLING

LAVORAZIONE MONTANTE SLIM CENTRALE
SLIM CENTRAL MULLION MACHINING



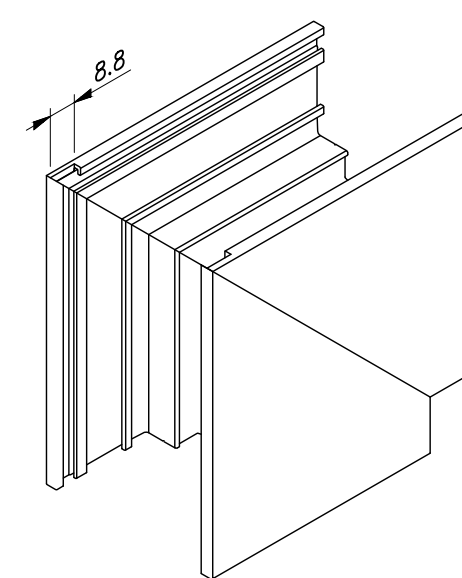
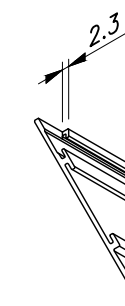
Lavorazioni eseguibili con dima T10067
Machining executable with T10067 template

Lavorazione eseguibile con gruppo fresa T40039
Machining executable with T40039 milling accessory

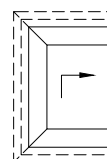


Lavorazione da eseguire per
eventuale inserimento/sostituzione
spazzolino

Machining to do for possible brush
insertion/replacement



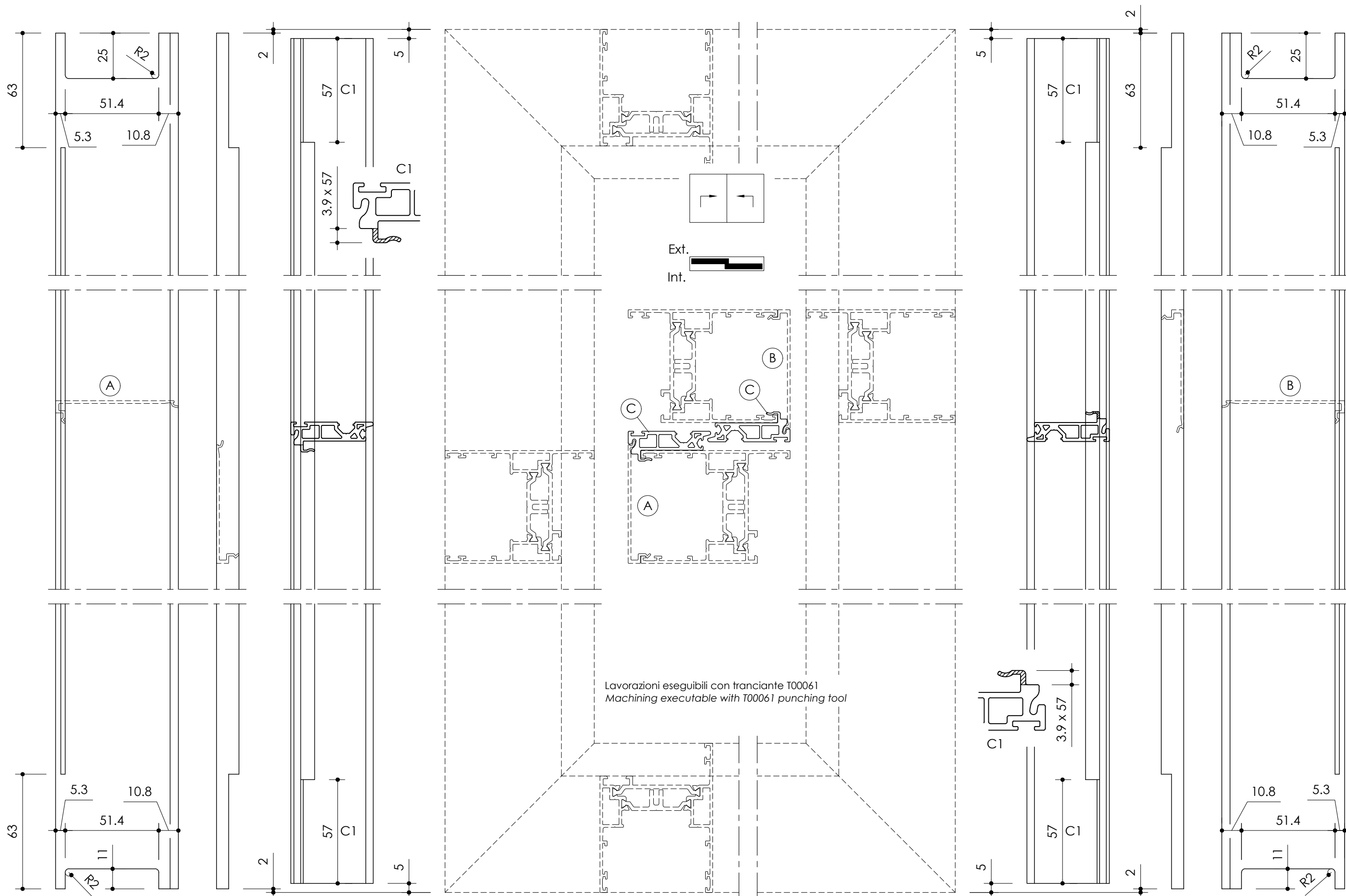
S140 L&S	S140 R
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It is advisable to carry out the machinings of the profile and the cover simultaneously, fixing the PVC element to the profile with two screws

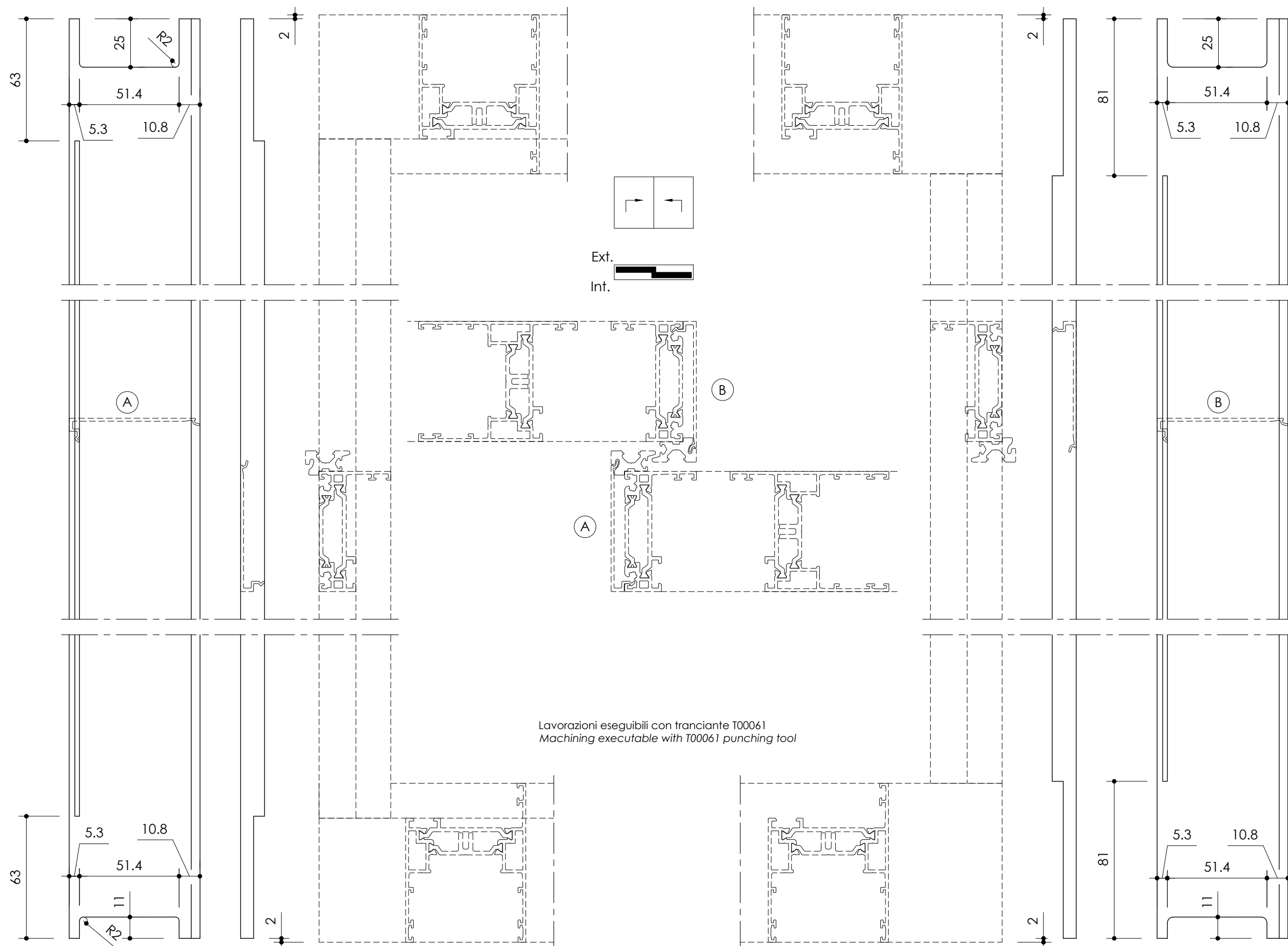
LAVORAZIONI COVER ANTA N10900 e LABIRINTO V31013
N10900 COVER PROFILE AND V31013 INTERLOCK MACHININGS

S140 L&S	S140 R
●	



LAVORAZIONI COVER ANTA SLIM N10900
N10900 COVER PROFILE MACHININGS FOR SLIM SASH

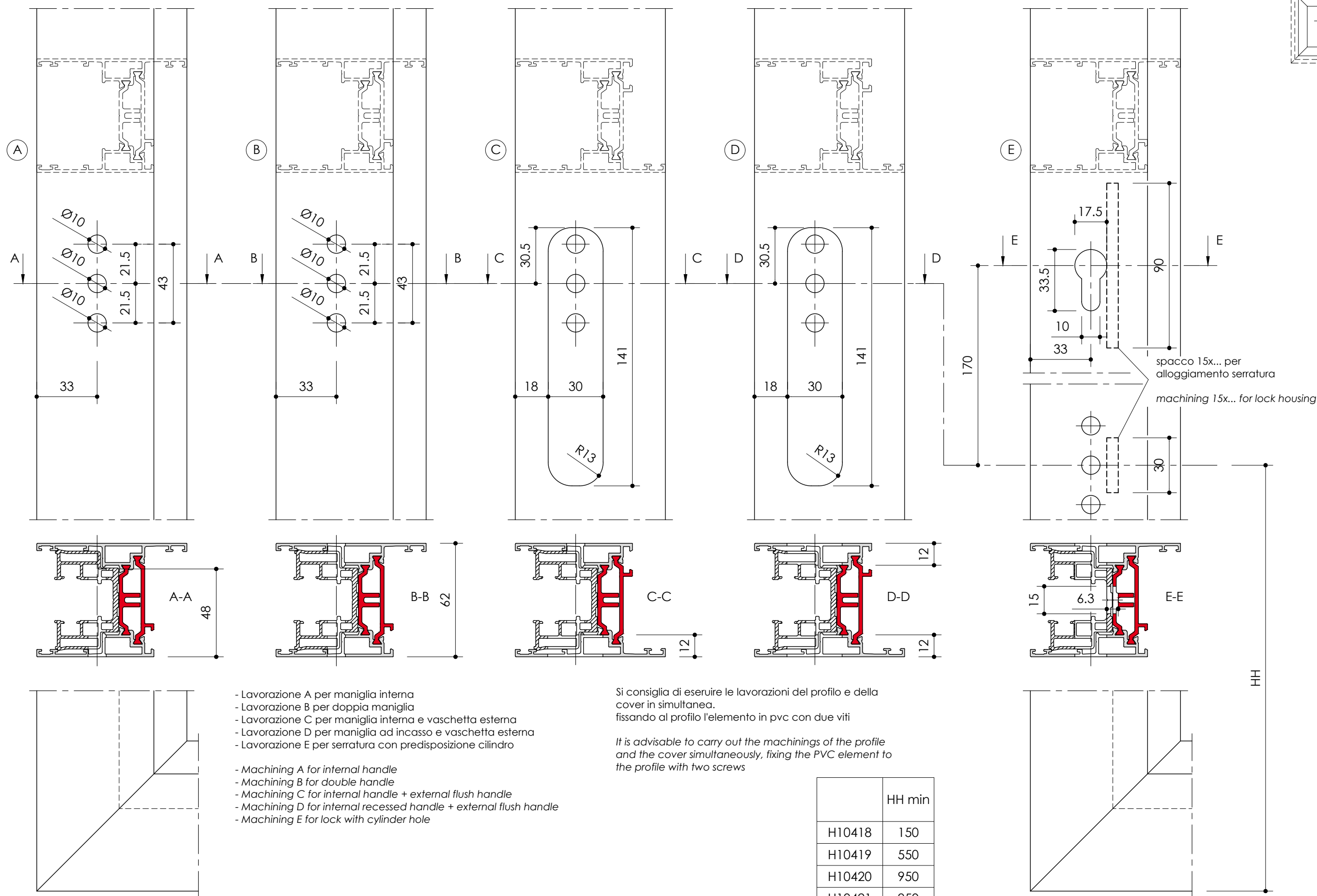
S140 L&S	S140 R
●	



Lavorazioni eseguibili con tranciante T00061
Machining executable with T00061 punching tool

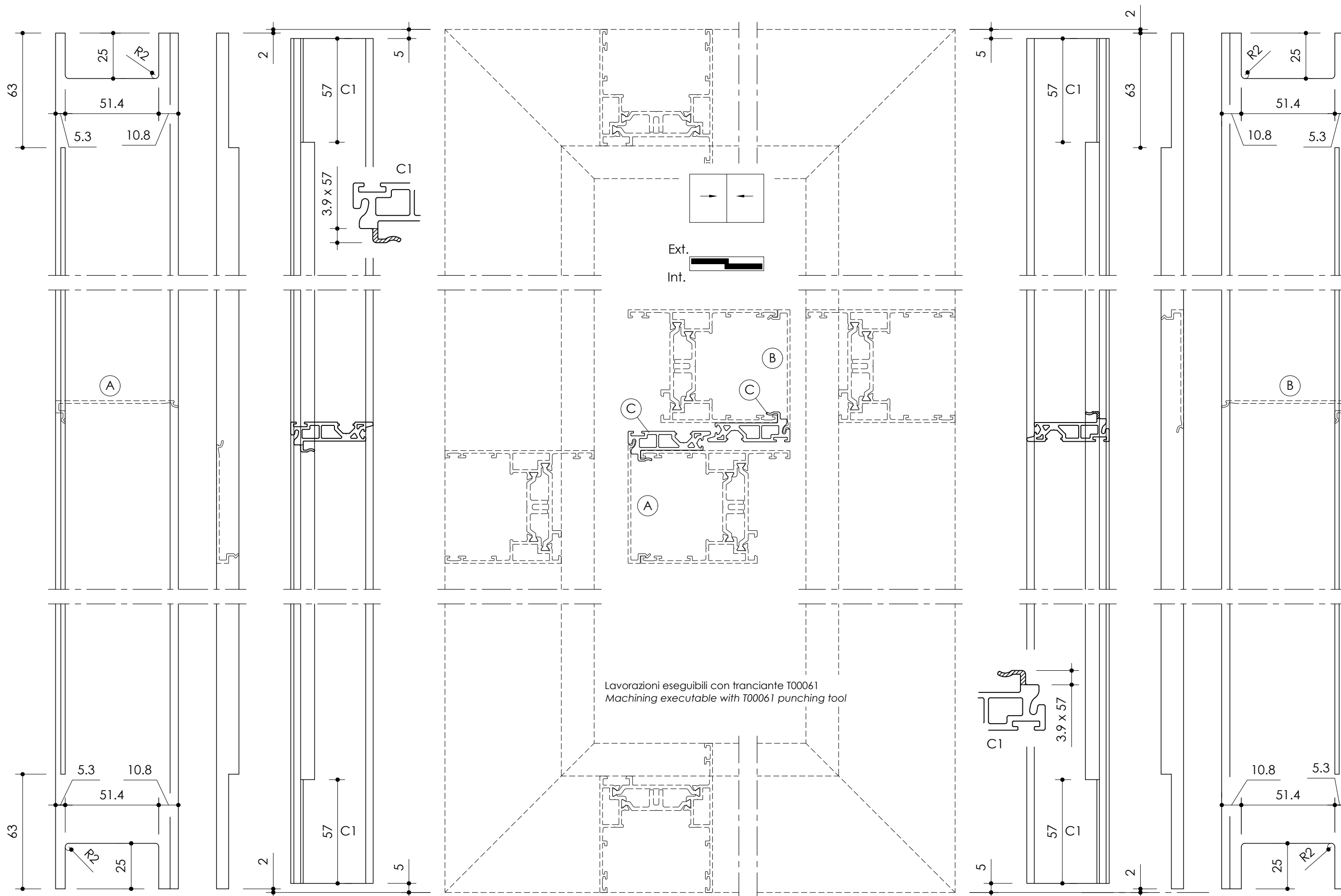
LAVORAZIONI PER MONTAGGIO SERRATURA SCORREVOLE MACHINING FOR SLIDING LOCK ASSEMBLY

S140 L&S	S140 R
	●



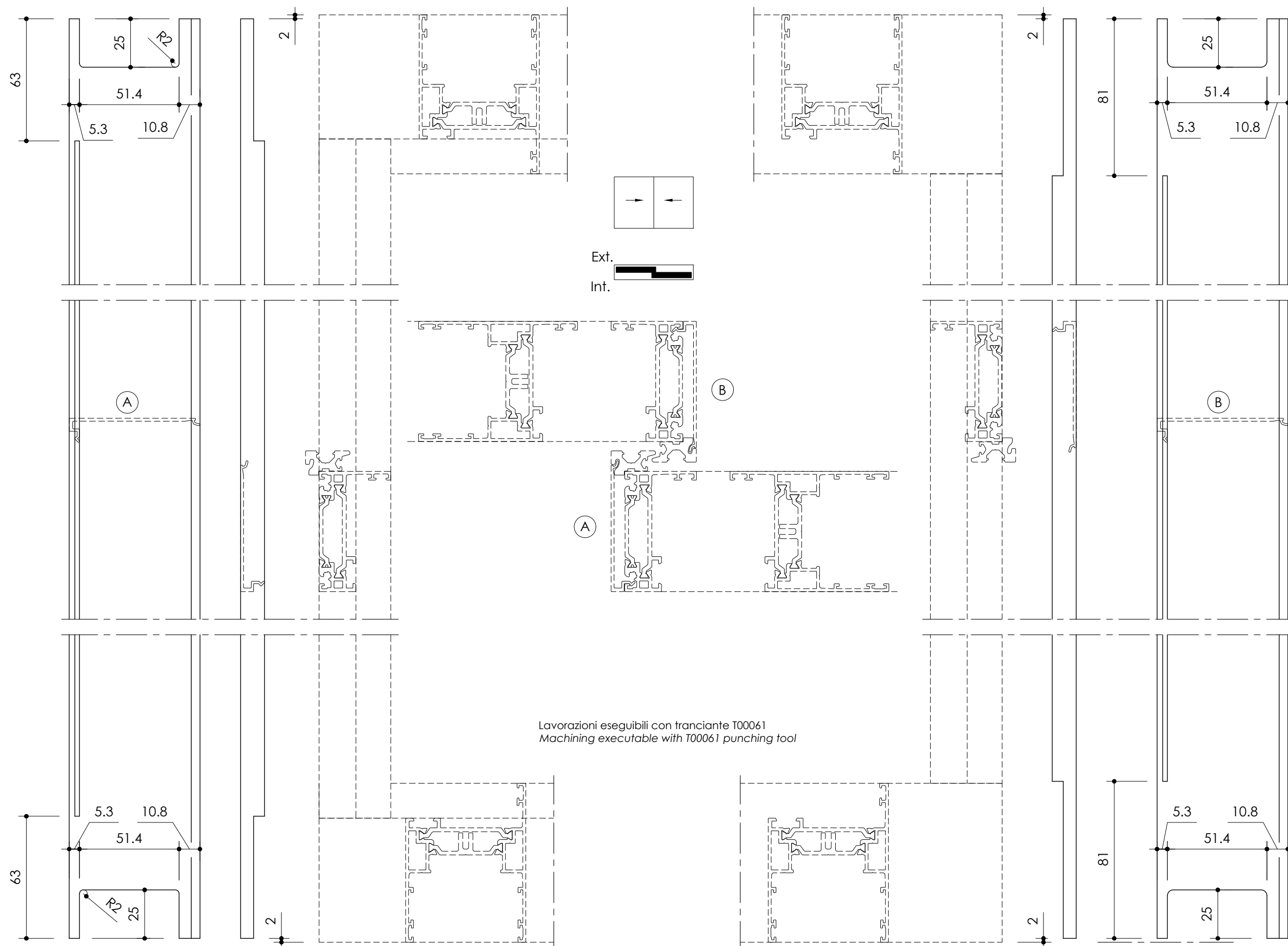
LAVORAZIONI COVER ANTA N10900 e LABIRINTO V31013
N10900 COVER PROFILE AND V31013 INTERLOCK MACHININGS

S140 L&S	S140 R
	●



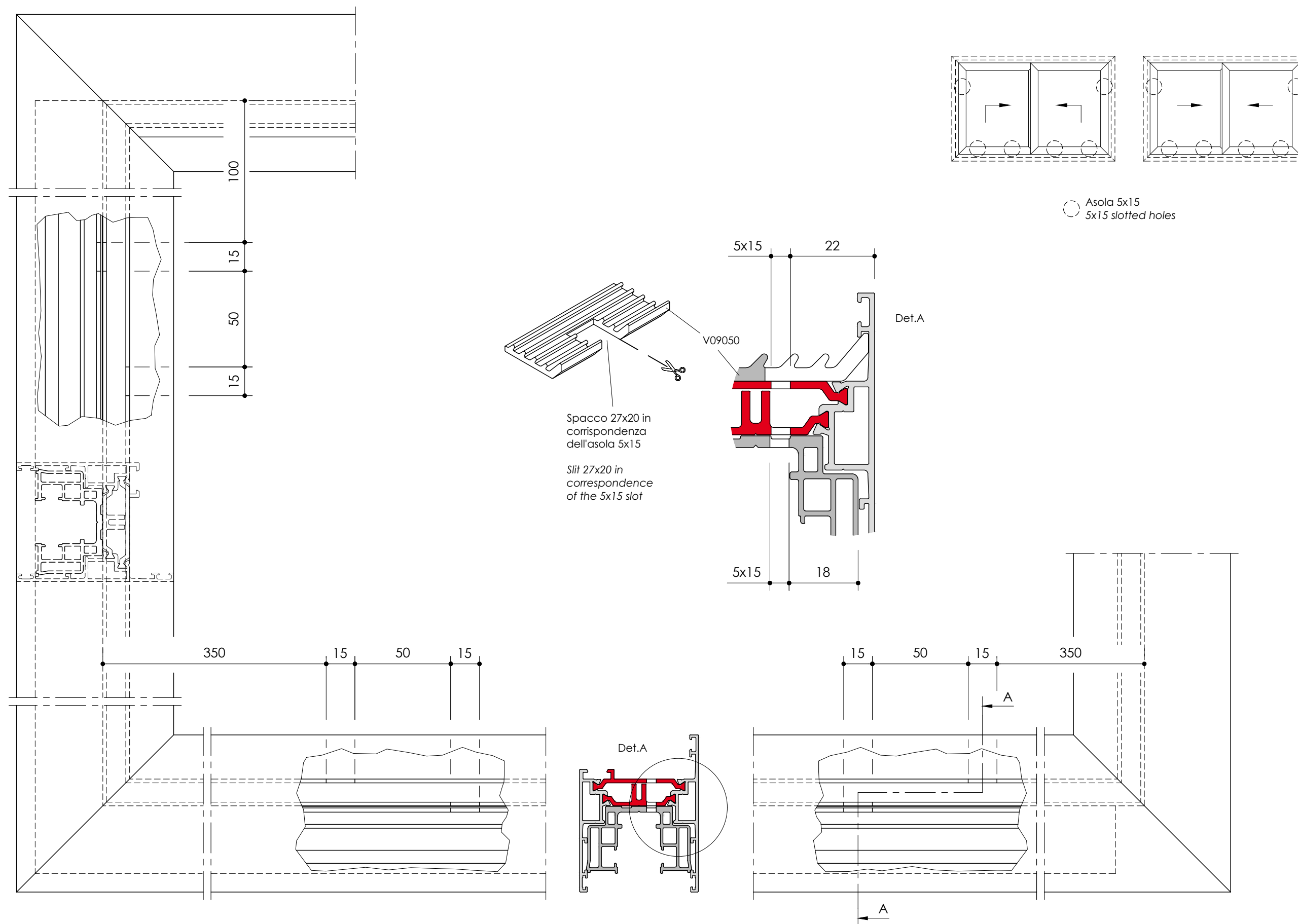
LAVORAZIONI COVER ANTA SLIM N10900
 N10900 COVER PROFILE MACHININGS FOR SLIM SASH

S140 L&S	S140 R
	●



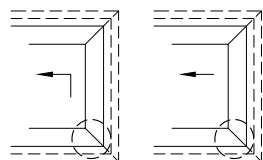
LAVORAZIONI PER DRENAGGIO E VENTILAZIONE SU ELEMENTI APRIBILI
MACHININGS FOR DRAINAGE AND VENTILATION ON OPENABLE ELEMENTS

S140 L&S	S140 R
●	●



LAVORAZIONI PER MONTAGGIO PARACOLPO E COLONNINA K1459 MACHININGS FOR BUMPERS AND COLUMNS K1459 ASSEMBLING

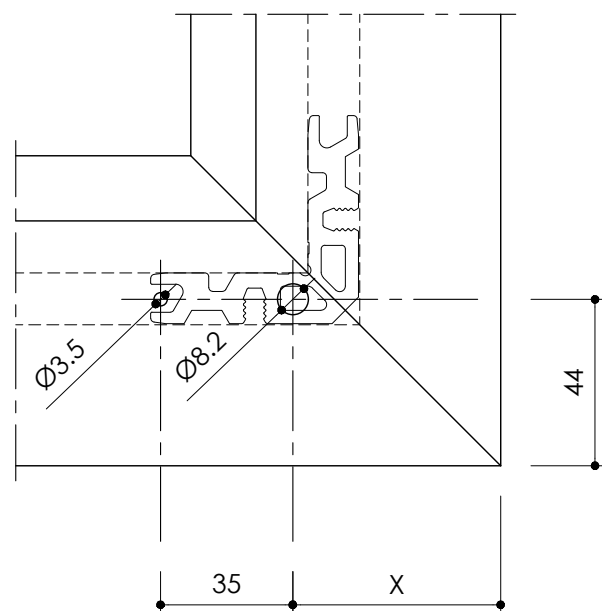
S140 L&S	S140 R
●	●



Ext. S140 L&S
Int. S140 R

Ext. S140 L&S
Int. S140 R

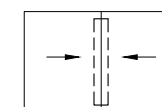
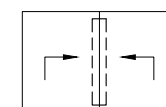
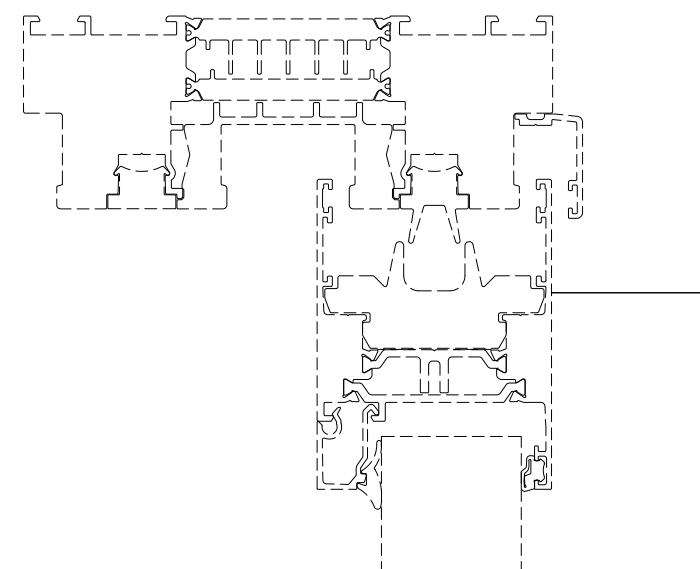
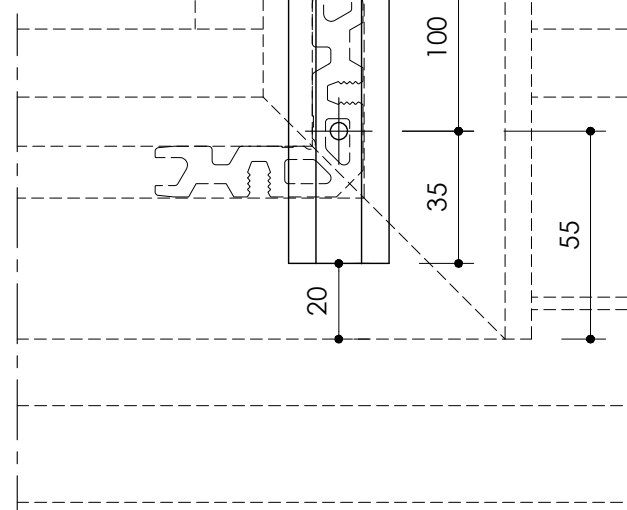
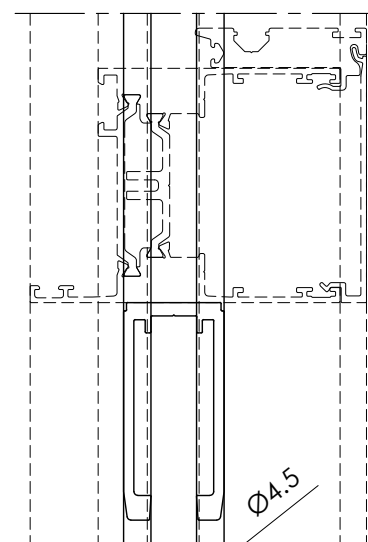
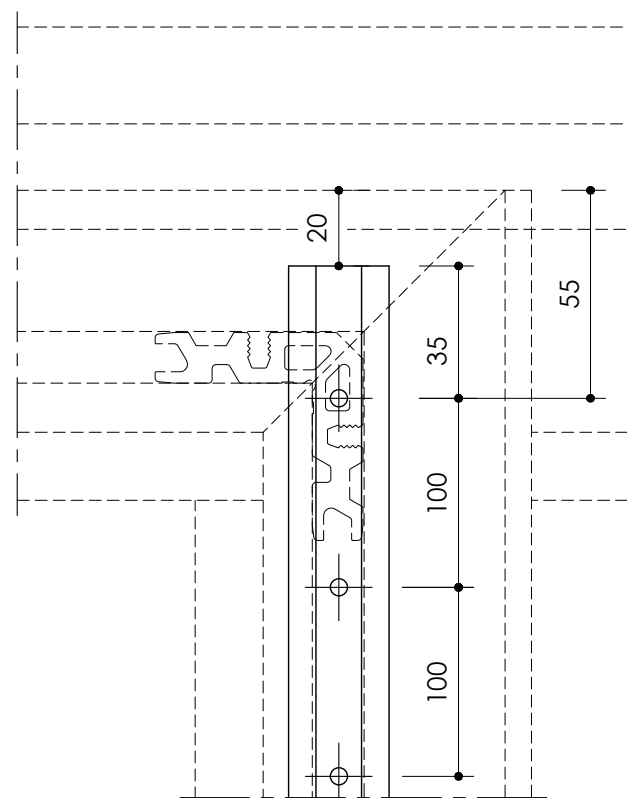
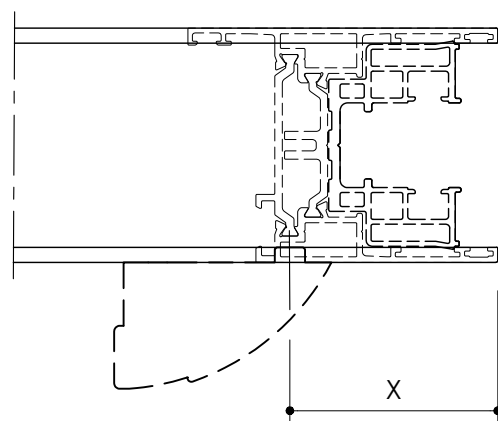
Ext. S140 L&S
Int. S140 L&S



S140 L&S - Eseguire la foratura dopo aver chiuso l'angolo.
Per l'inserimento del tappo paracolpo, deve essere lavorata anche parte della squadretta.
S140R - Eseguire la foratura a 120 mm causa maniglia in posizione di apertura

S140L&S - Drill the hole after closing the corner.
To insert the bumper accessory, part of the corner joint must also be machined.
S140R - Drill at 120 mm due to handle in open position

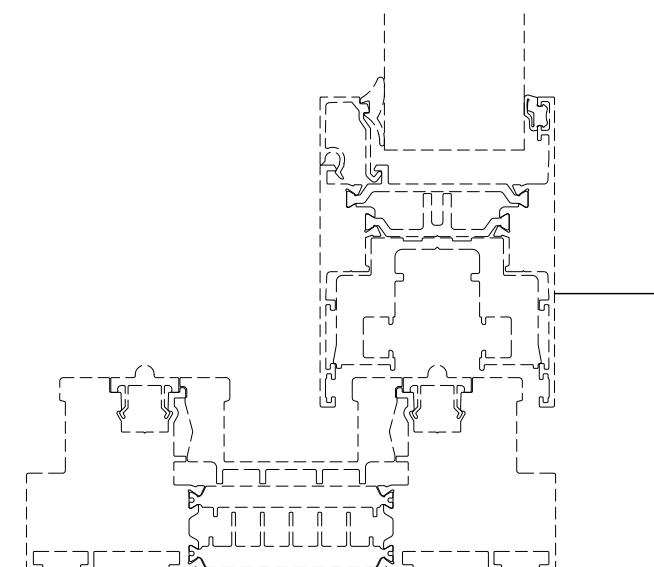
	X
S140 L&S	55
S140 R	120



Ext.
Int.

Ext.
Int.

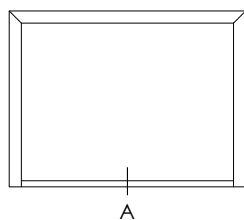
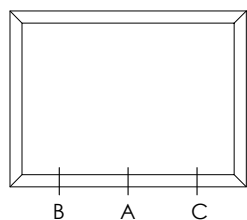
- Foratura Ø4.5
- I primi 5 fori superiori e inferiori devono essere a passo 100 mm
- I restanti, in zona centrale, a passo 250 mm
- La collonina sul lato interno può essere tagliata a filo anta
- Drilling Ø4.5
- The first 5 upper and lower holes must be at 100 mm interaxes
- The rest, in the central area, at 250 mm interaxes
- The reinforcement mullion on the internal side can be cut flush with the door



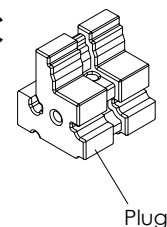
Section 10

Assemblaggio

Assembly



C

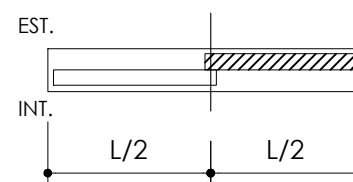


TAPPI CHIUSURA TUBOLARE TUBULAR CLOSING PLUGS	
Prof.	Plug
U10022	V55168
U10400	V55098
U10060 + U10061	V55097
U10402 + U10403	V55098
U10000	V55097
U10401	V55098

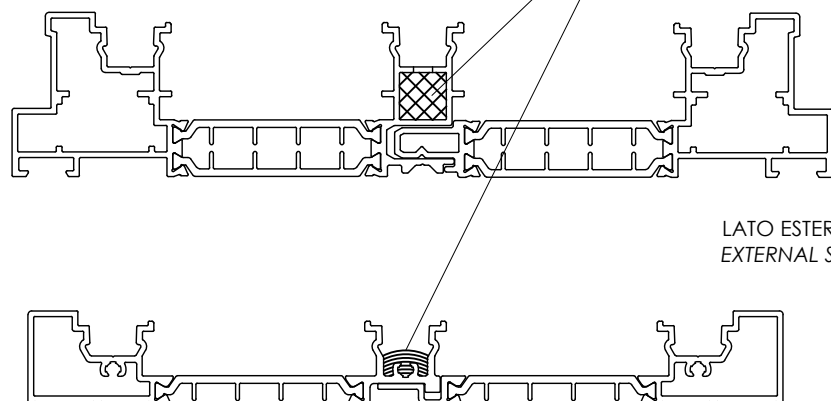
LATO INTERNO
INTERNAL SIDE

LATO ESTERNO
EXTERNAL SIDE

Prof



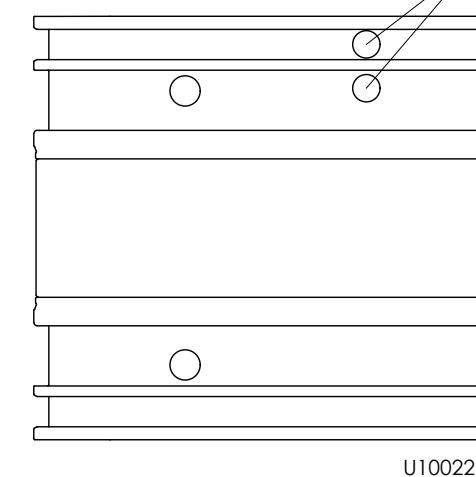
LATO ESTERNO
EXTERNAL SIDE



LATO ESTERNO
EXTERNAL SIDE

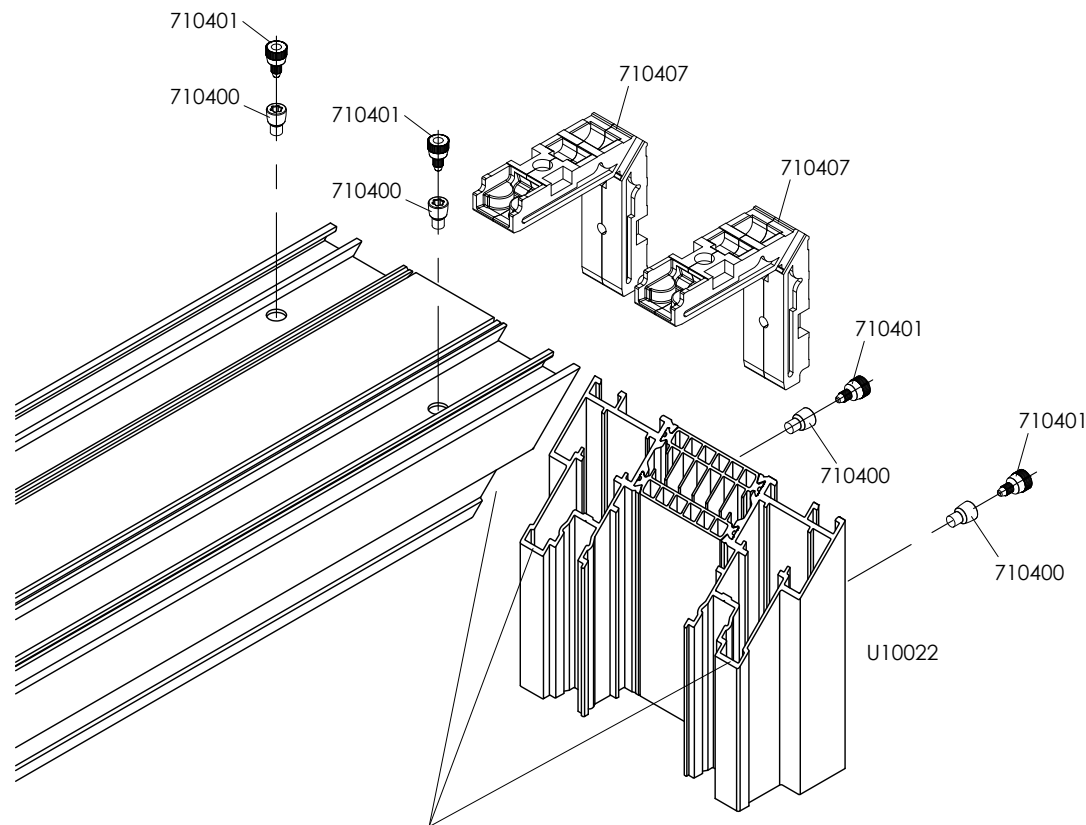
LATO ESTERNO
EXTERNAL SIDE

Fori applicazione sigillante
Sealant application holes

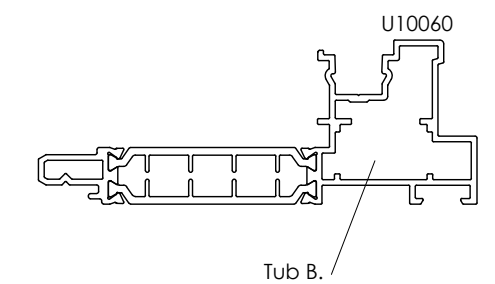
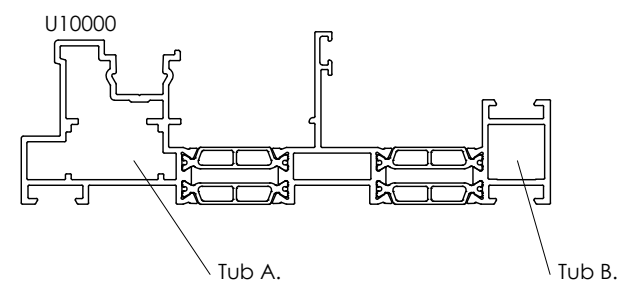
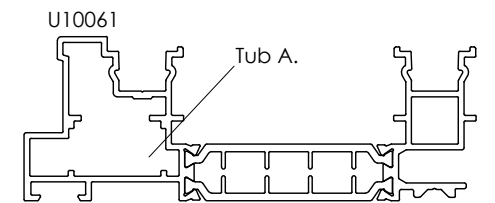
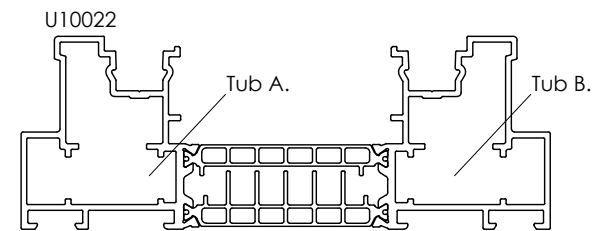


U10022

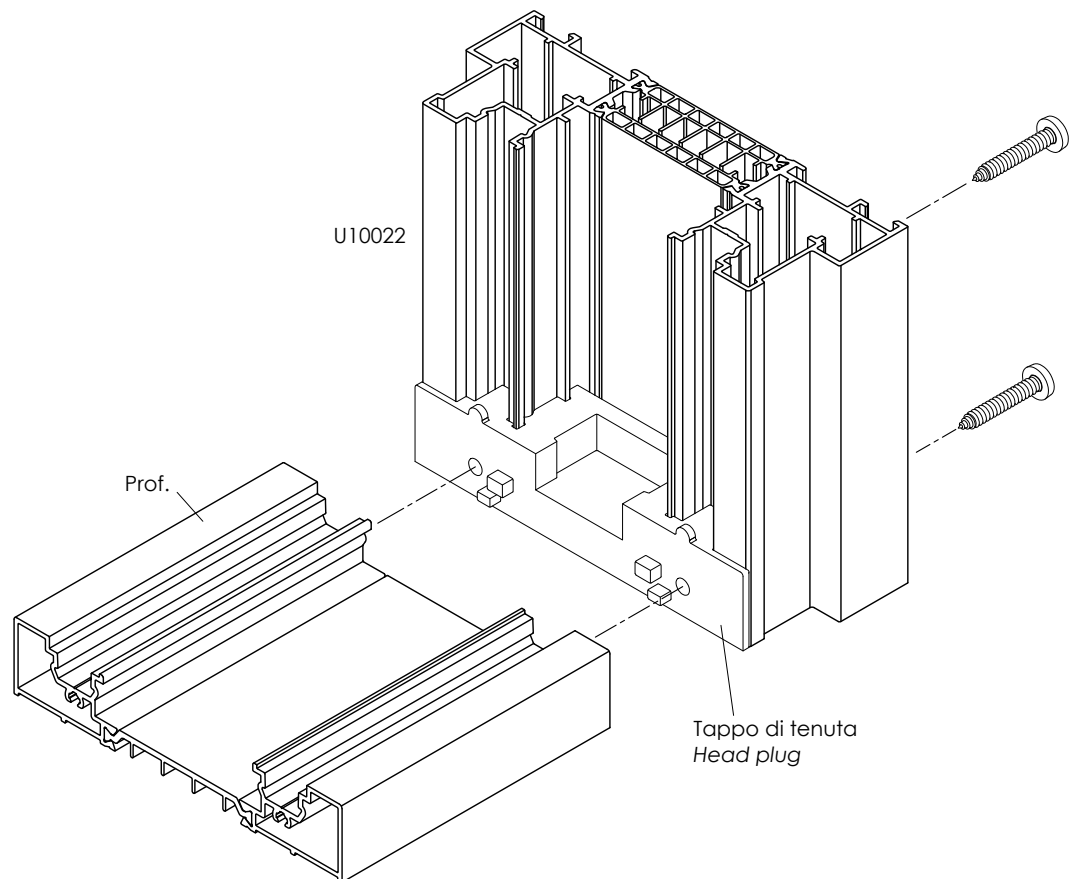
SCHEMA DI ASSEMBLAGGIO TELAIO
FIXED FRAME ASSEMBLY DIAGRAM



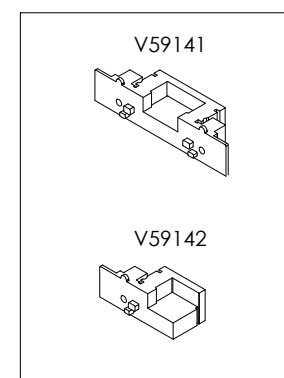
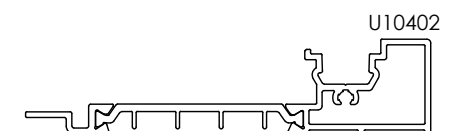
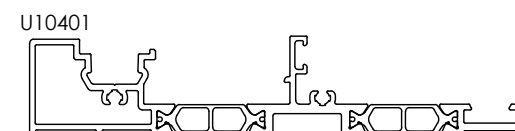
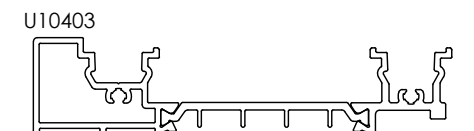
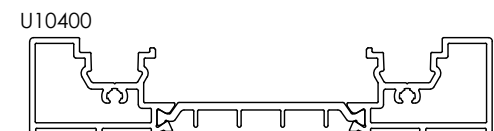
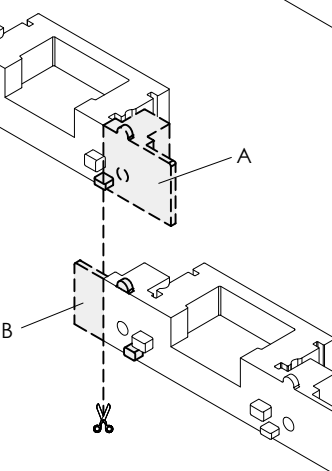
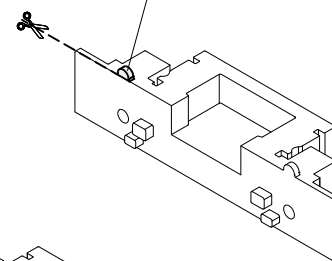
APPLICARE SIGILLANTE SILICONICO SULLE SUPERFICI DI CONNESSIONE PRIMA DELL'UNIONE A TELAIO
APPLY SILICONE SEALING ON CONNECTION CORNER SURF ACES BEFORE ASSEMBLING



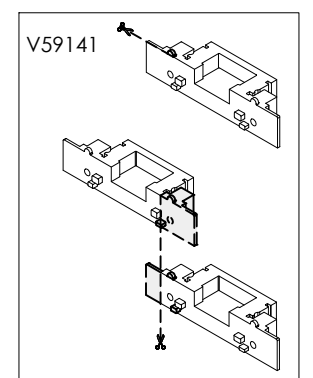
SQUADRETTE CORNER JOINTS		
Prof.	Tub A	Tub B
U10022	710407	710407
U10000	710407	V43000
U10060	-	710407
U10061	710407	-



Parte da asportare in presenza della cover
Part to be removed in the presence of the cover



TAPPO DI TESTA HEAD PLUG	
Prof.	Plug
U10400	V59141
U10401	V59142
U10402	V59141 (A)
U10403	V59141 (B)



▶ MONTAGGIO COVER TELAIO E TAPPI TENUTA CENTRALE ASSEMBLY OF COVER AND CENTRAL SEALING PLUG

PROFILO / COVER PROFILE / COVER	
Prof.	Cover
U10022	V31208
U10400	V31209
U10060 - U10061	V31208
U10402 - U10403	V31209
U10000	V31212
U10401	V31211

Sigillare per un minimo tratto (qualche mm) sotto la cover nella zona centrale

Seal for a minimum section (a few mm) under the cover in the central area

Foro applicazione sigillante

Sealant application hole

TAPPI TENUTA CENTRALE VERSIONE L&S
CENTRAL SEALNG PLUG L&S VERSION

Prof.	Tip A	Tip B
U10022	V58031	V58037
U10400	V58031	V58038
U10060 - U10061	V58036	V58037
U10402 - U10403	V58036	V58038
U10000	V58039	V58040
U10401	V58039	V58041

TAPPI TENUTA CENTRALE VERSIONE "inline"
CENTRAL SEALNG PLUG "inline" VERSION

Prof.	Tip A	Tip B
U10022	V58055	V53059
U10400	V58055	V53077

TAGLIO SPUGNA TAPPO CENTRALE
CENTRAL CAP SOPNGE CUT

Tappo	Montante	Spessore	L
V58037	U10140	V59161	64 mm
V58037	U10120	V59162	22 mm
V58038	U10140	V59161	64 mm
V58038	U10120	V59162	22 mm
V58040	U10140	V59163	64 mm
V58040	U10120	V59164	22 mm
V58041	U10140	V59163	64 mm
V58041	U10120	V59164	22 mm

Sigillare anche gli elementi verticali (2) per 300mm

Also seal the vertical elements (2) for 300mm

VALIDA PER TUTTE LE TIPOLOGIE
VALID FOR ALL TYPES

Sigillare Seal

Posizionare il tappo e sigillarlo utilizzando gli appositi canali

Position the plug and seal it using the appropriate channels

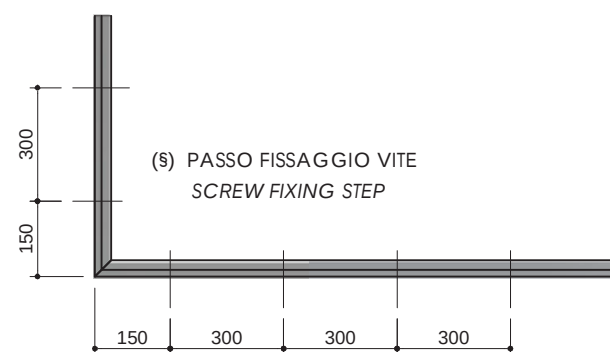
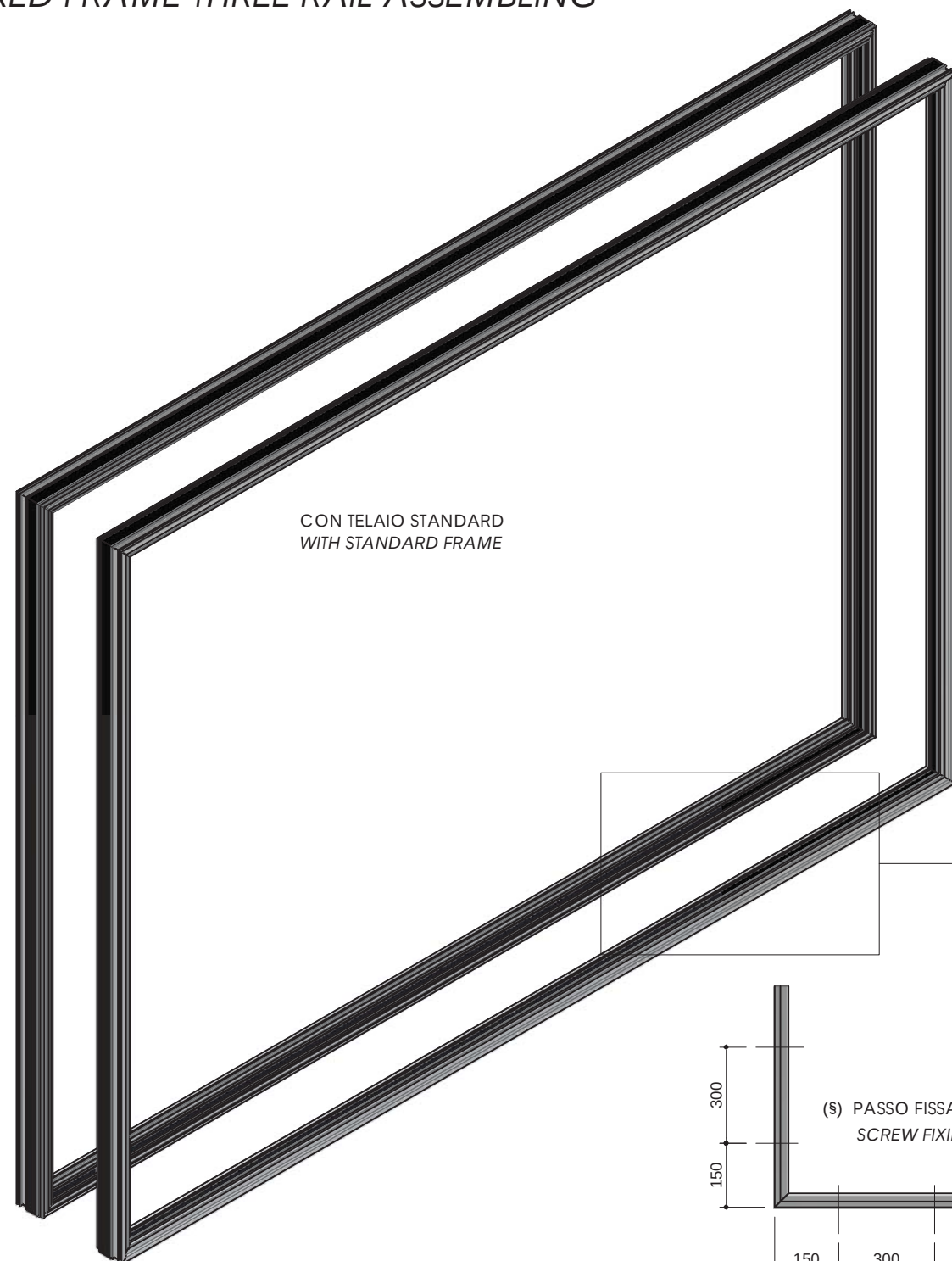
Prima di inserirlo in posizione sigillare il lato del tappo

Before inserting it into position seal the side of the plug

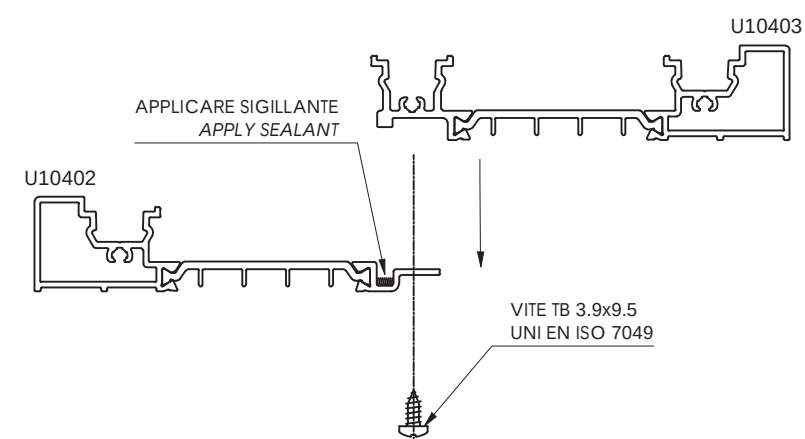
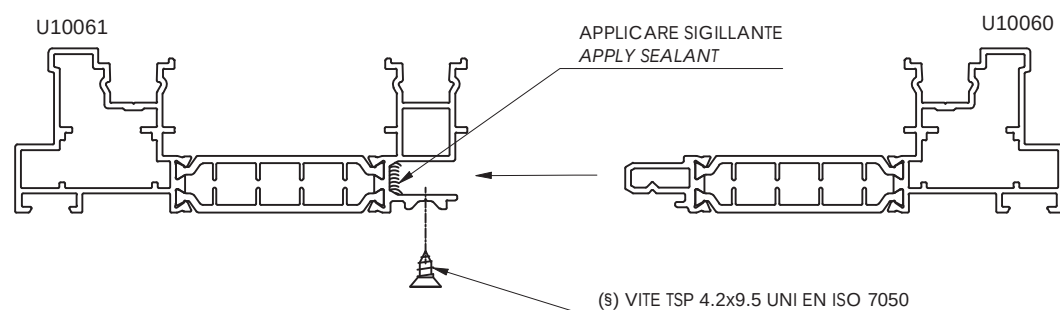
Incollare i bordi della guarnizione

Gule the edges of the gasket

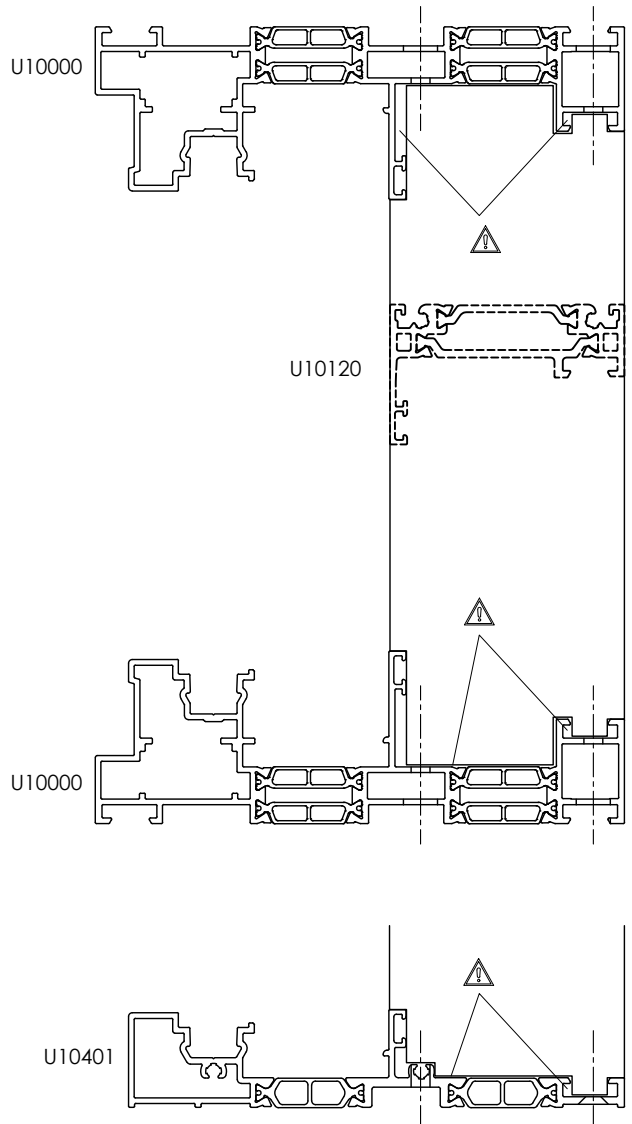
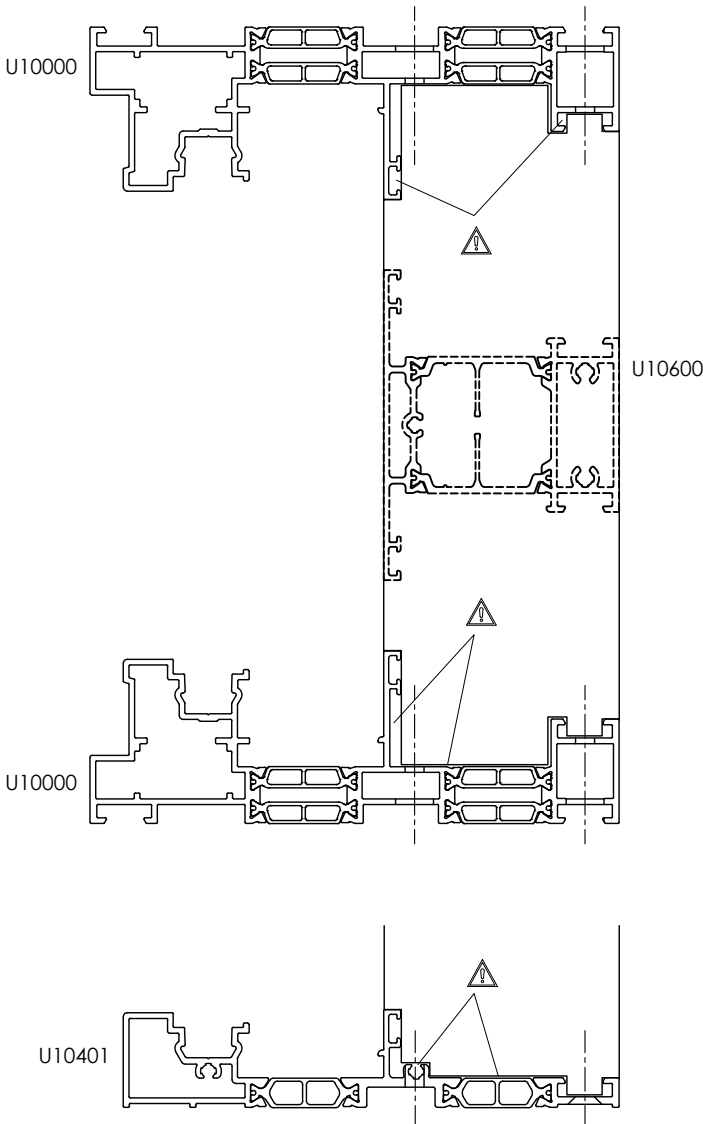
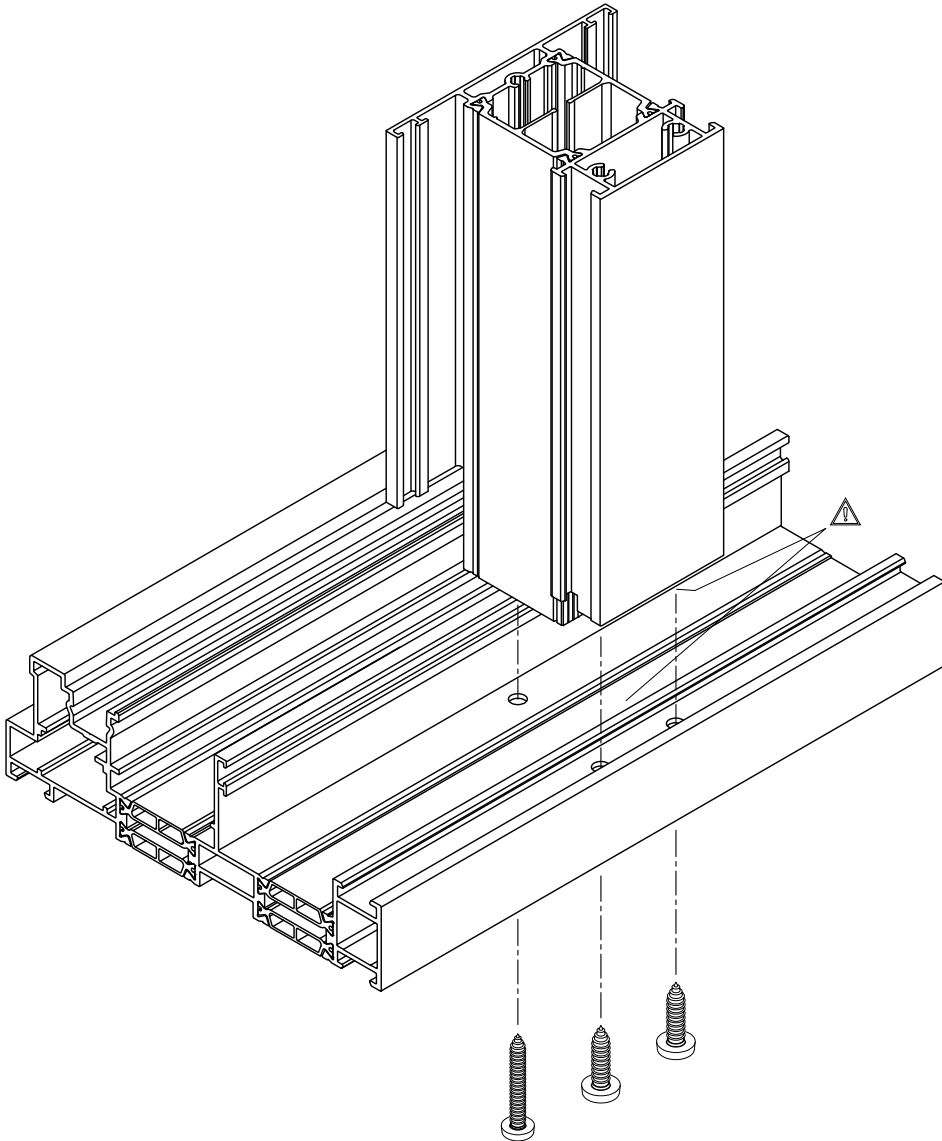
➤ MONTAGGIO TELAIO TRE VIE
FIXED FRAME THREE RAIL ASSEMBLING



VARIANTE CON SOGLIA RIBASSATA
VARIANT WITH LOWERED THRESHOLD

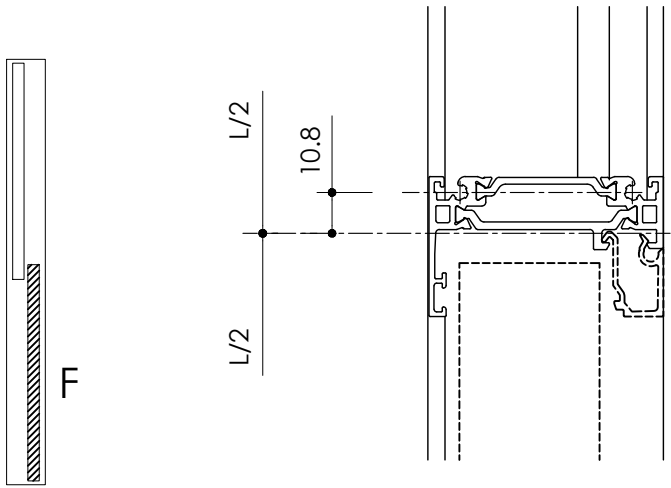
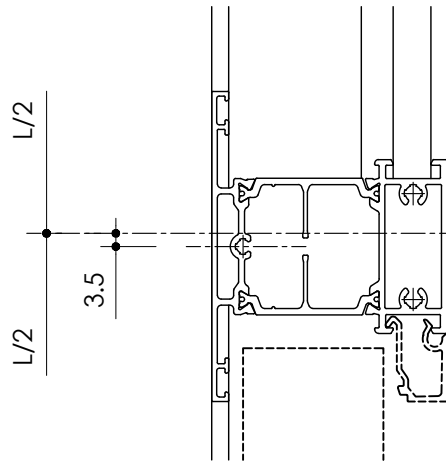


▶ MONTAGGIO MONTANTE CENTRALE TELAIO OX
 OX CENTRAL FIXED FRAME MULLION ASSEMBLING

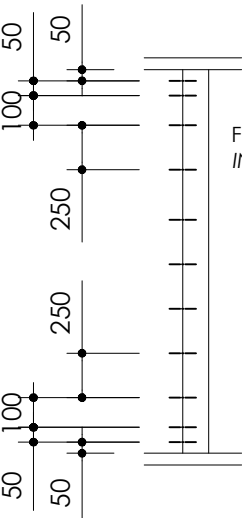
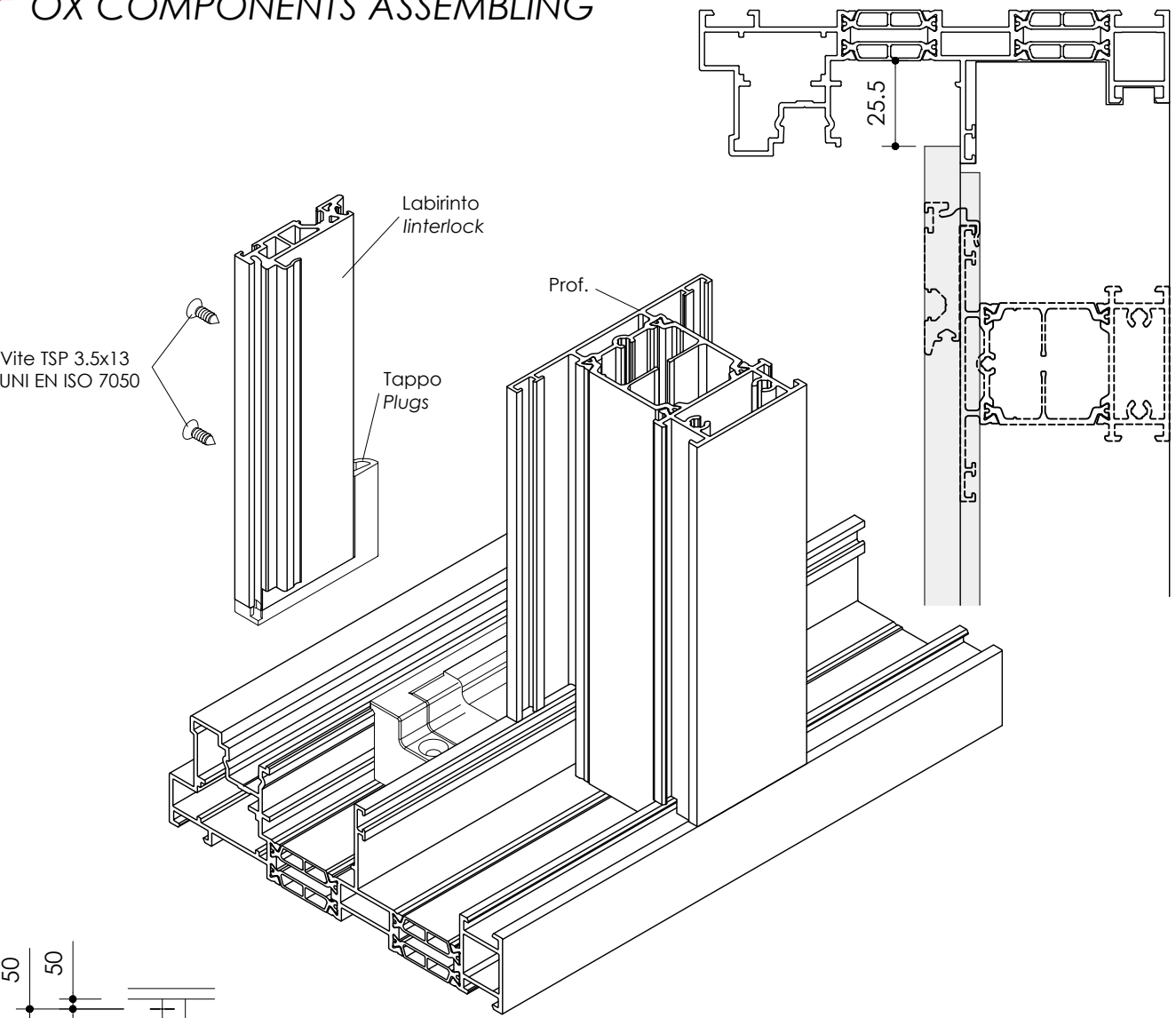


⚠ Sigillare accuratamente le superfici di connessione telaio/montante
 Carefully seal the fixed frame / fixed mullion connection surfaces

VITI DI FISSAGGIO PER PROFILO MONTANTE FIXED FRAME MULLION SCREWS		
Telaio	Montante	Viti
U10000	U10600	(2pz) TB 4.8x22 UNI EN ISO 7049 + (1pz) TB 4.2x32 UNI EN ISO 7049
U10401	U10600	(2pz) TSP 4.8x25 UNI EN ISO 7050 + (1pz) TB 4.2x32 UNI EN ISO 7049
U10000	U10120	(2pz) TB 4.2x32 UNI EN ISO 7049
U10401	U10120	(2pz) TSP 4.2x25 UNI EN ISO 7050 + (1pz) TB 4.2x32 UNI EN ISO 7049



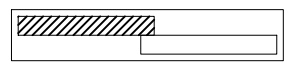
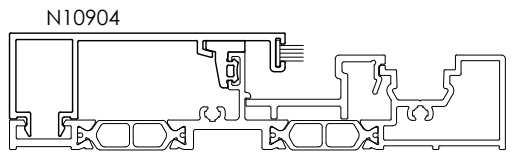
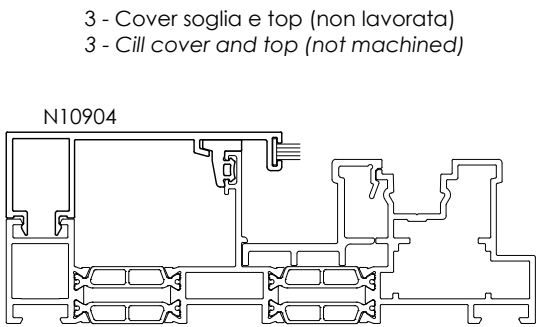
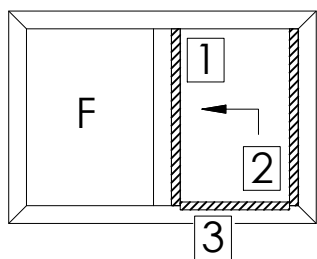
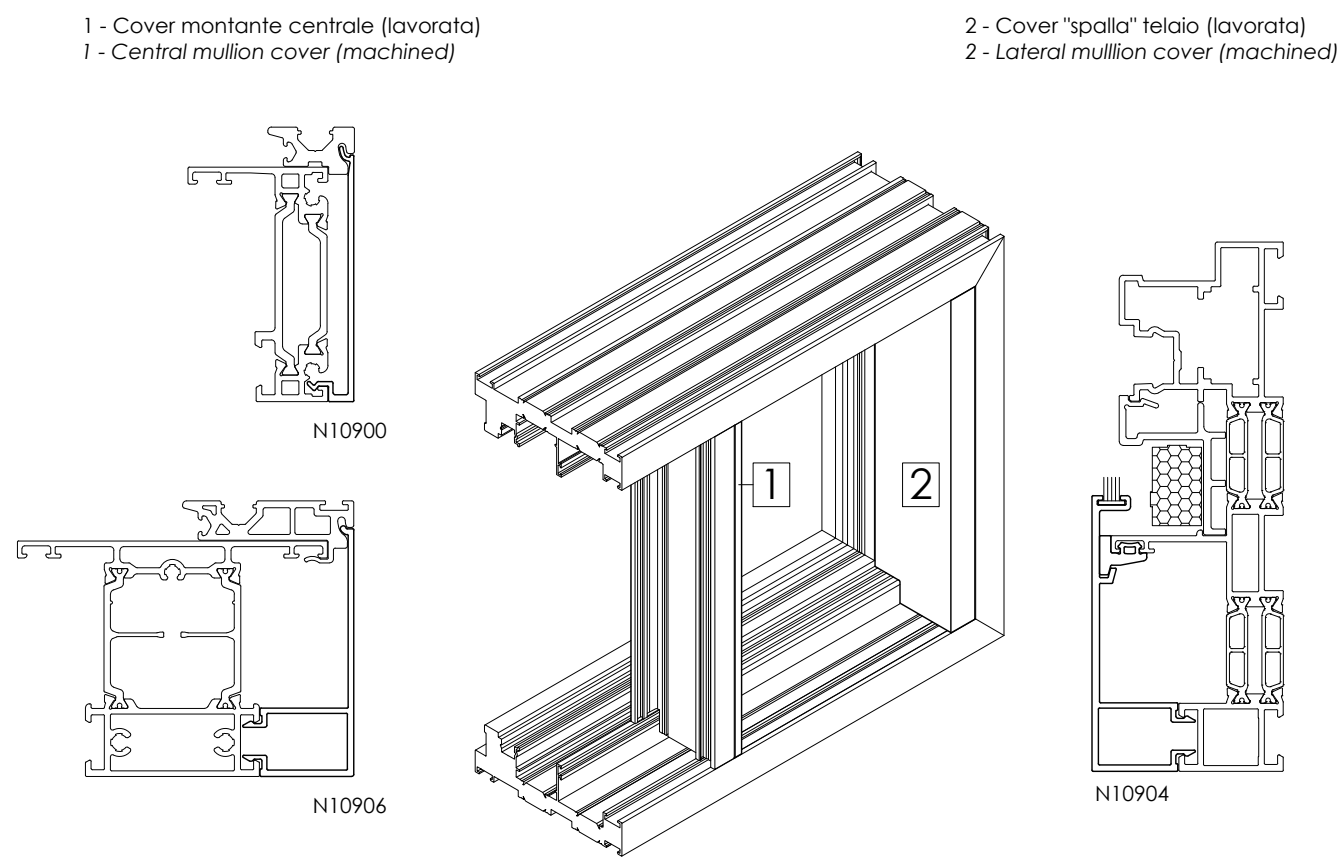
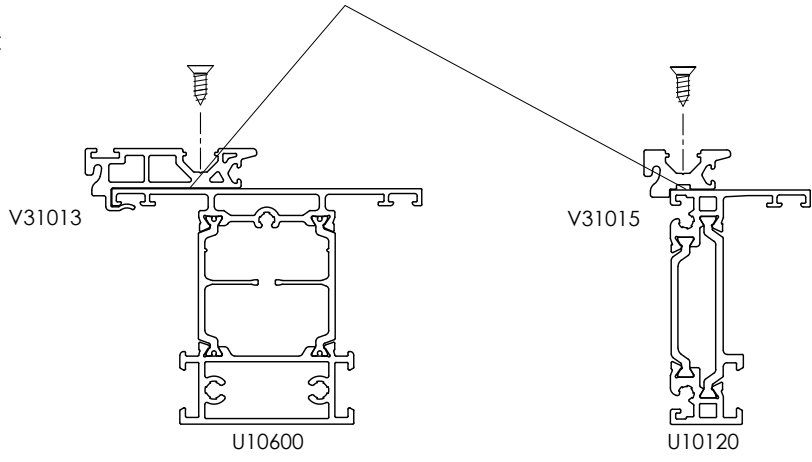
▶ ASSEMBLAGGIO COMPONENTI OX OX COMPONENTS ASSEMBLING



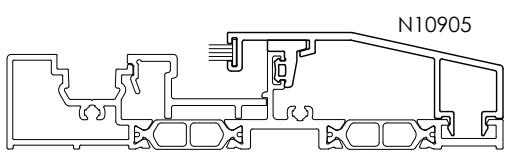
FISSAGGIO LABIRINTO
INTERLOCK FIXING

LABIRINTO - TAPPI LABIRINTO TENUTA CENTRALE INTERLOCK - CENTRAL INTERLOCK SEALNG PLUG		
Prof.	Labirinto	Tappi - Plugs
U10600	V31013	V53054
U10120	V31015	V58055

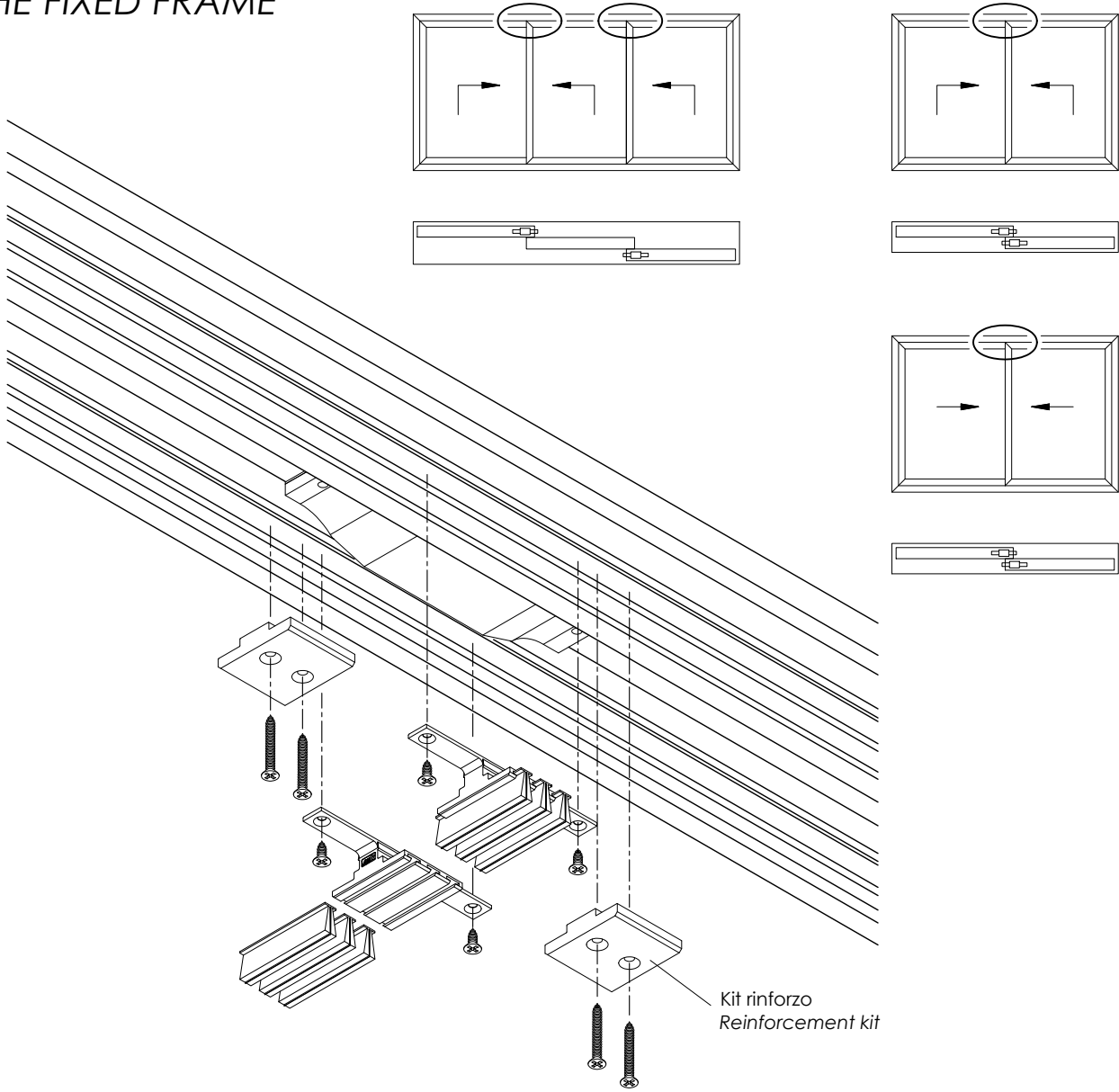
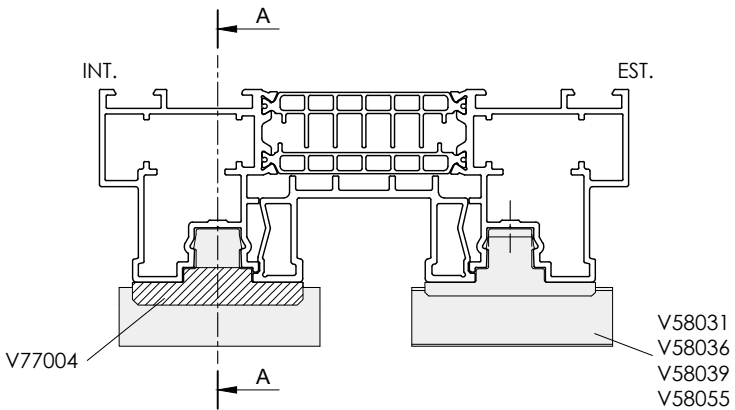
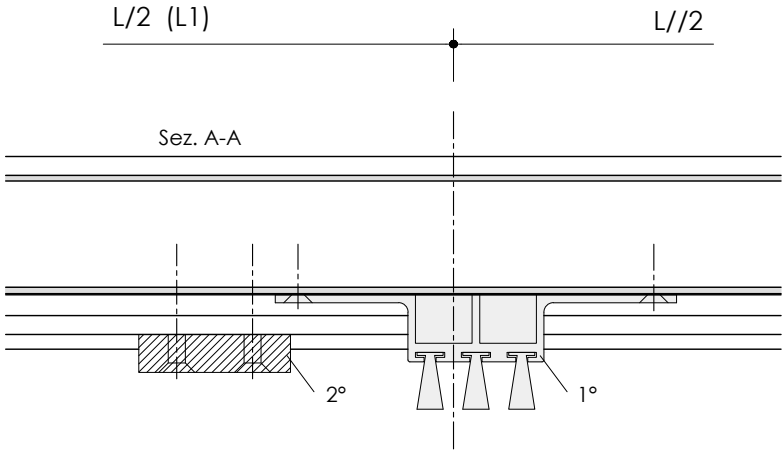
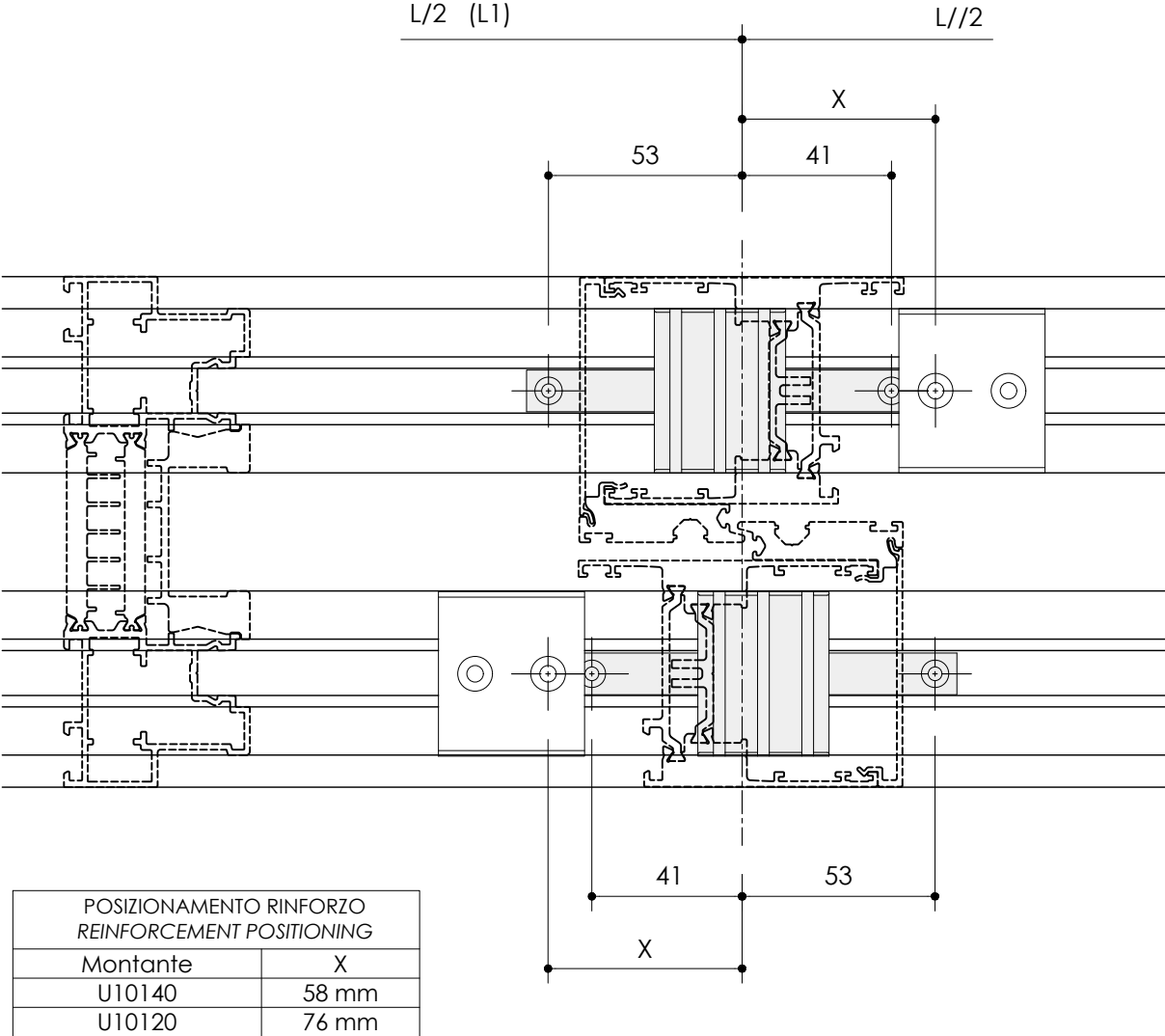
Sigillare sotto il labirinto per tutta l'altezza
Seal under the interlock for the whole height



3 - Cover soglia (non lavorata)
3 - Cill cover (not machined)



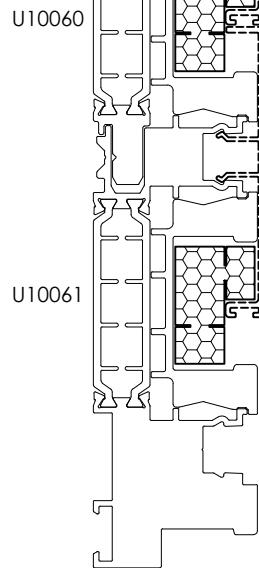
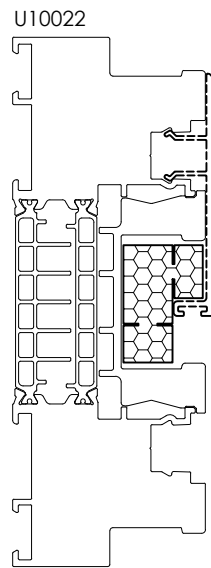
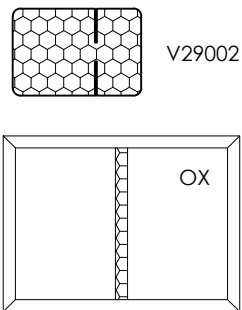
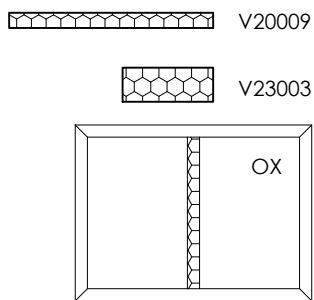
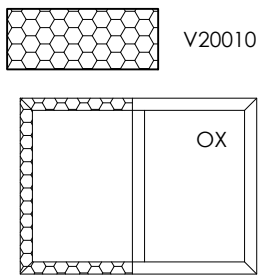
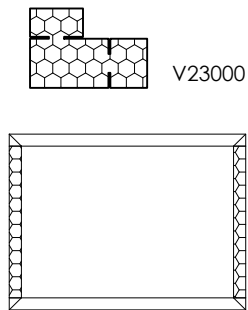
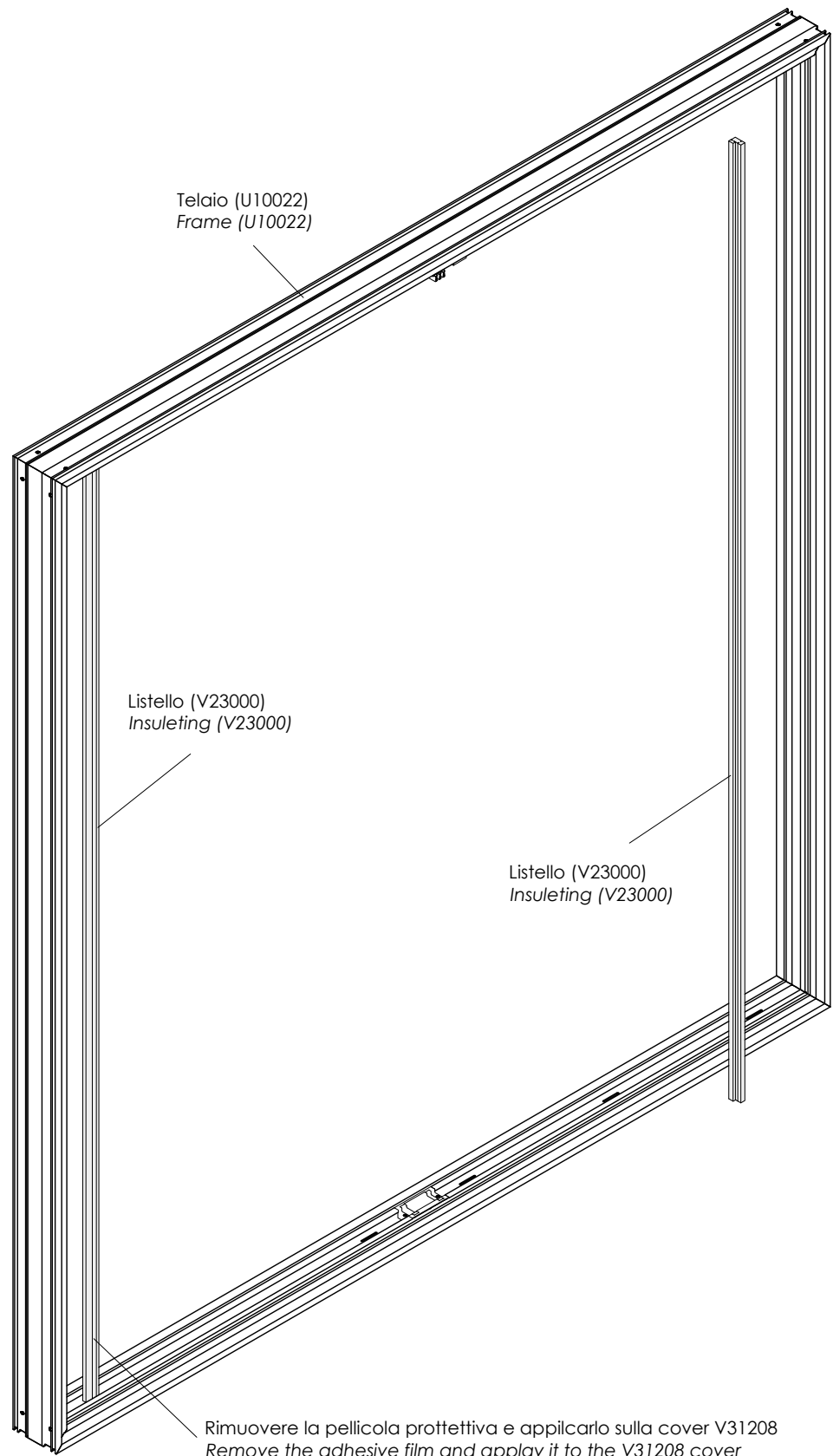
▶ MONTAGGIO SUL TELAIO DEL KIT RINFORZO ANTA E TAPPI PORTA SPAZZOLINI
 DOOR REINFORCEMENT KIT AND BRUSH HOLDER CAPS ASSEMBLING ON THE FIXED FRAME



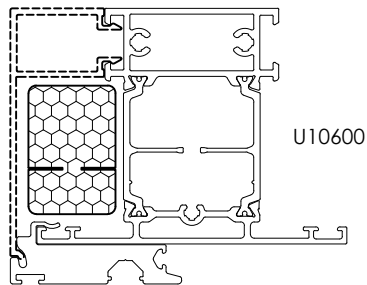
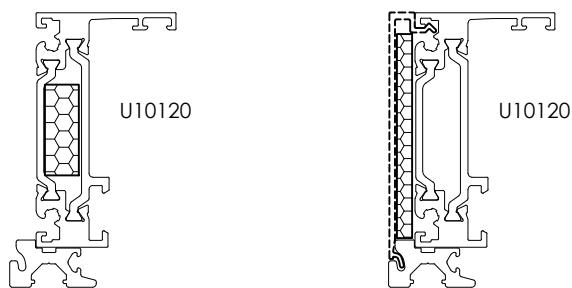
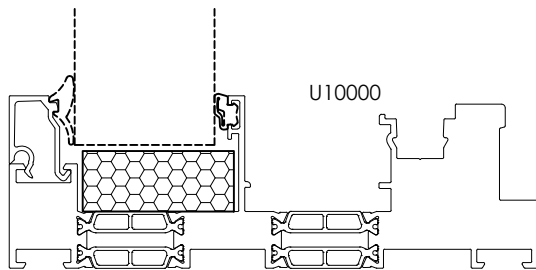
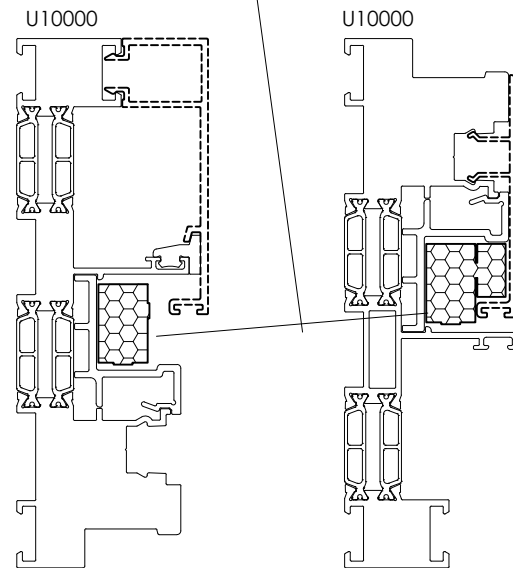
TELAIO / ACCESSORI versione L&S FIXED FRAME / ACCESSORIES L&S version				
Prof.	Kit base	pz	kit rinforzo	pz
U10022	V58031	1	V78004	2
U10400	V58031	1	V78004	2
U10000	V58039	1	V78004	1
U10401	V58039	1	V78004	1
U10060 - U10061	V58036	1	V78004	2
U10402 - U10403	V58036	1	V78004	2

TELAIO / ACCESSORI versione "inline" FIXED FRAME / ACCESSORIES "inline" version				
Prof.	Kit base	pz	kit rinforzo	pz
U10022	V58055	1	V78004	2
U10400	V58055	1	V78004	2

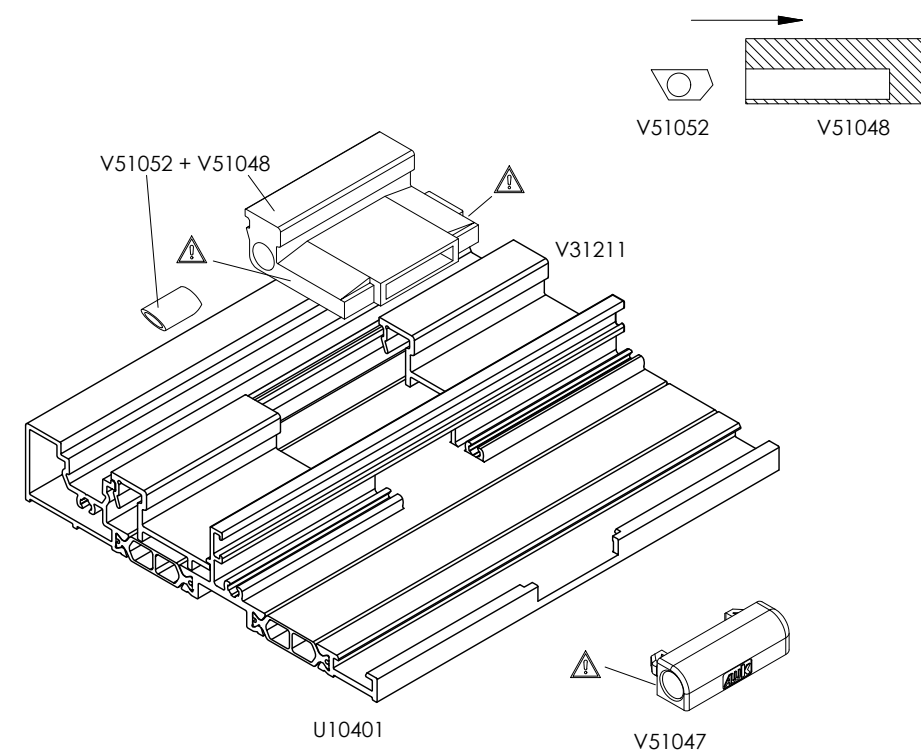
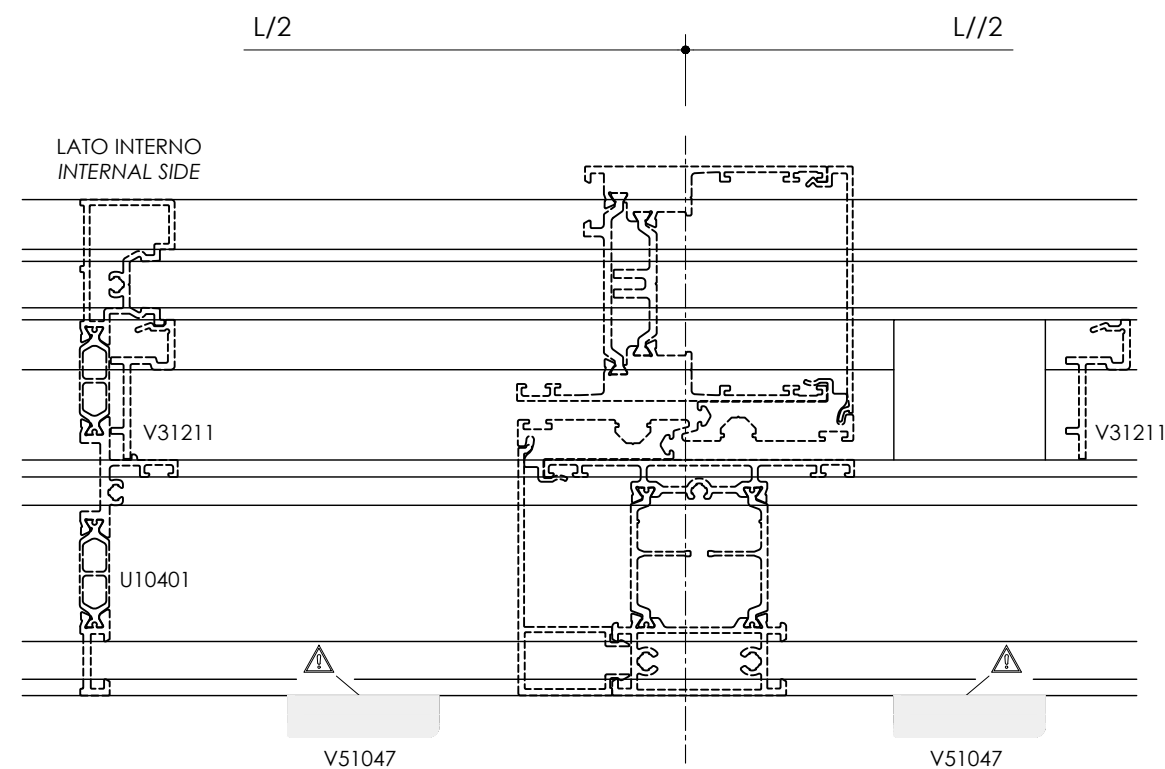
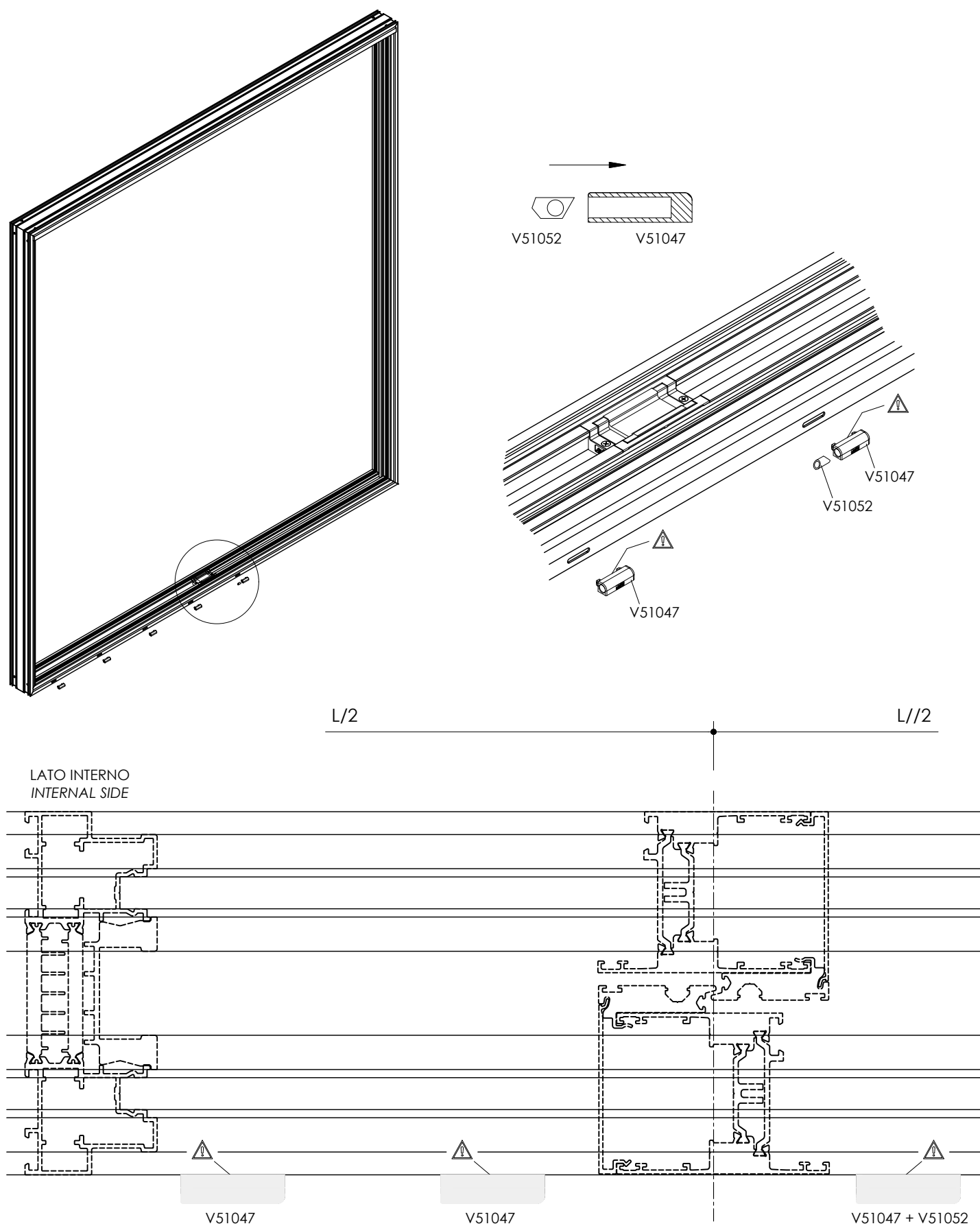
▶ MONTAGGIO LISTELLI ISOLANTI TELAIO
 FRAME INSULATING STRIP ASSEMBLY



Asportare parte del listello seguendo la traccia
 Remove part of the strip following the track

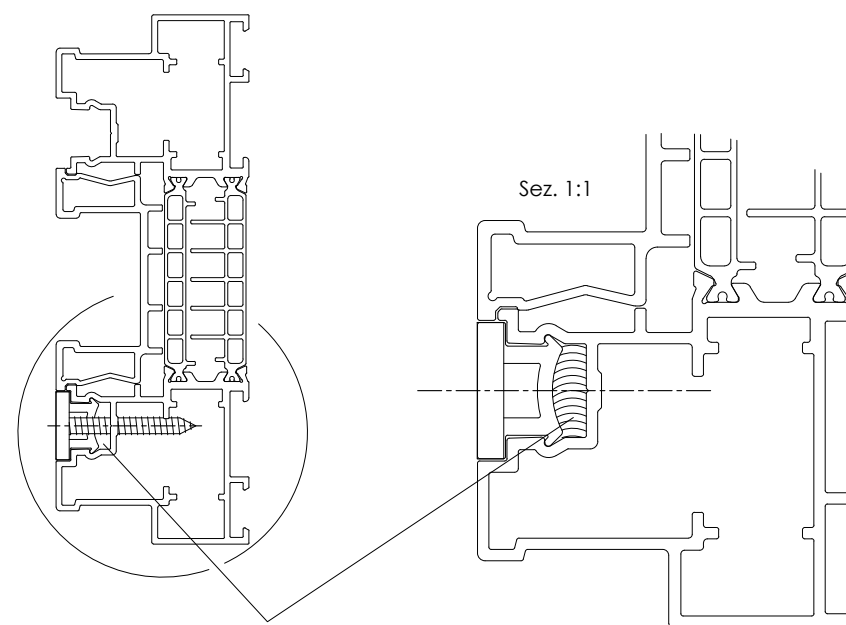
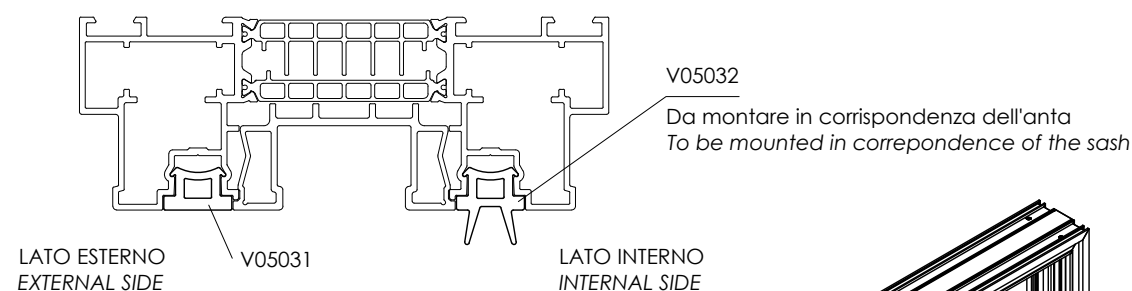


➤ MONTAGGIO ACCESSORI DRENAGGIO TELAIO
FEME DRAINAGE ACCESSORIES ASSEMBLY

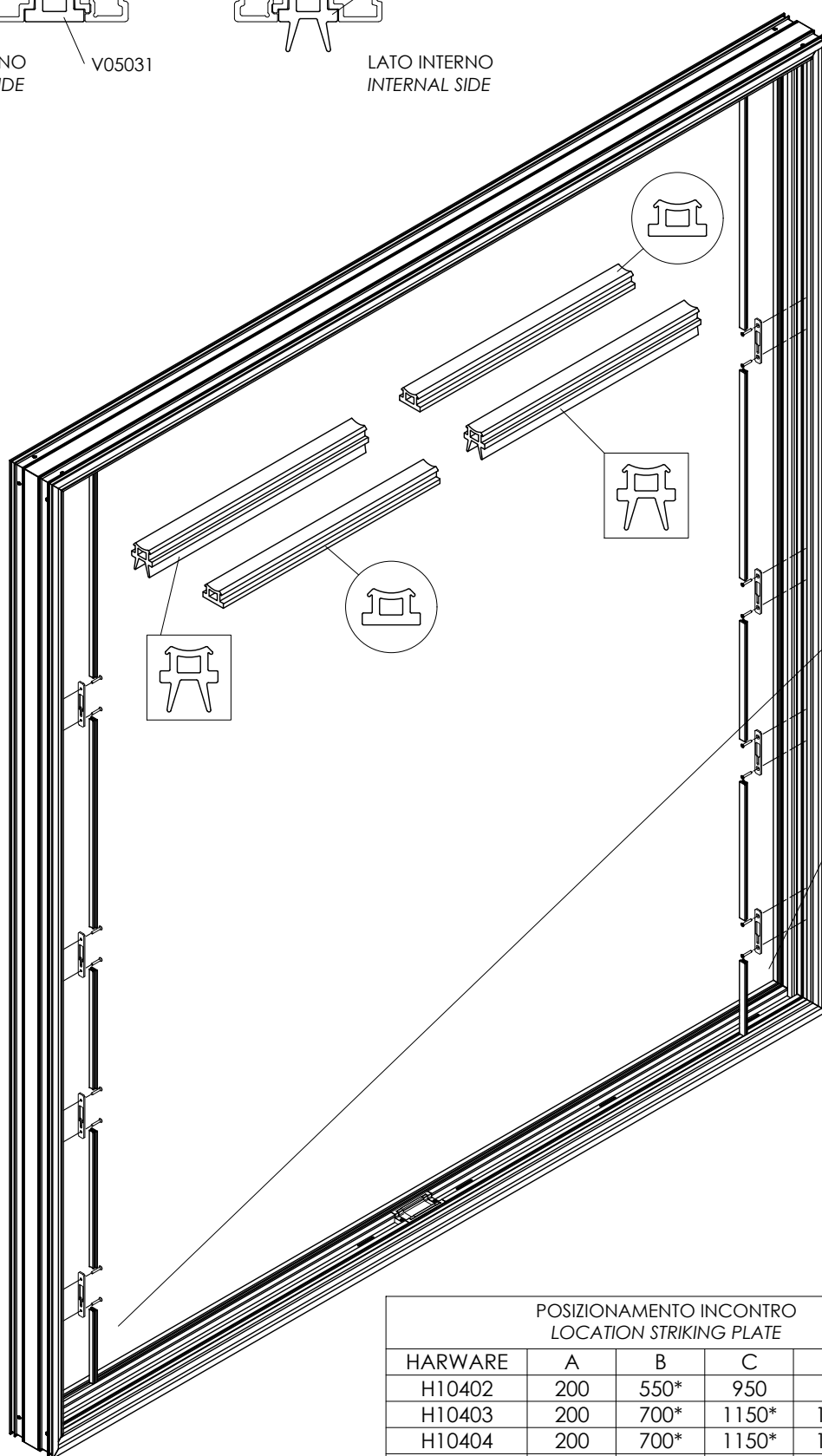


⚠ Applicare sigillante sulle superfici dell'accessorio prima dell'assemblaggio con il telaio
Apply sealant on the surfaces of the accessory before assembling with the frame

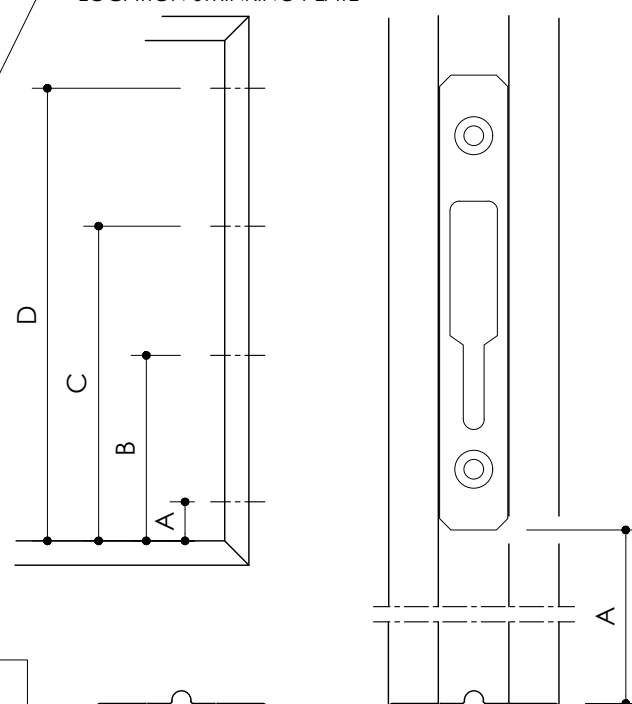
MONTAGGIO GUARNIZIONI E FERRAMENTA TELAIO GASKET AND FRAME HARDWARE ASSEMBLING



Sigillare sotto la guarnizione (e sotto l'incontro) fino ad una altezza di 250 mm
Seal under the gasket (and counterplate) up to a height of 250 mm



POSIZIONI INCONTRO
LOCATION STRIKING PLATE

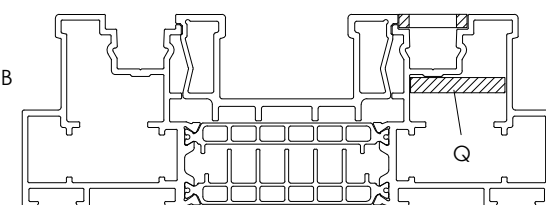


POSIZIONAMENTO INCONTRO LOCATION STRIKING PLATE				
HARWARE	A	B	C	D
H10402	200	550*	950	-
H10403	200	700*	1150*	1550
H10404	200	700*	1150*	1850
H10405	200	700*	1150*	2150

*Incontri opzionali, punto di chiusura aggiuntivo cod. H10400

*Optional counterplate, additional closing point cod. H10400

Sez. B-B

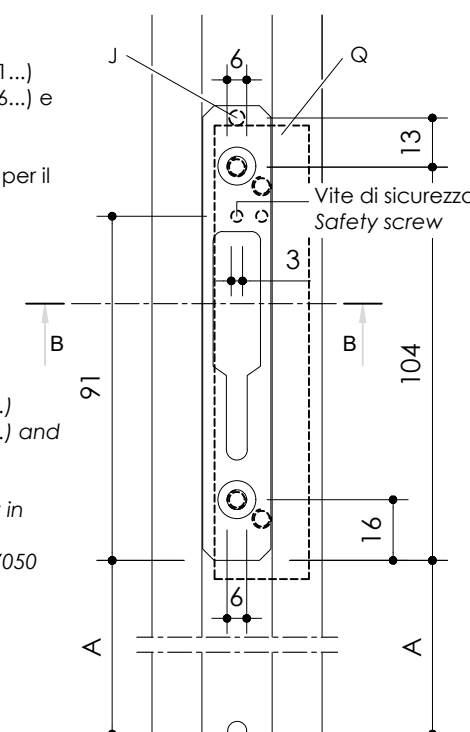


FISSAGGIO DI SICUREZZA (opzionale)

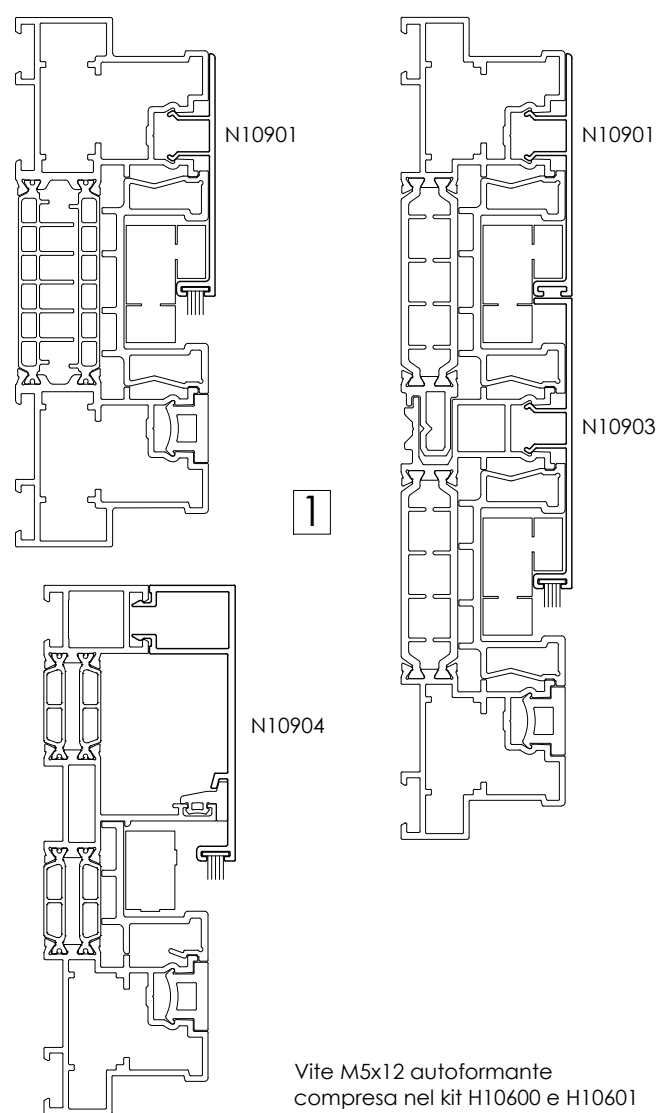
- Forare Ø3 nelle varie posizioni (A+91.... B+91...)
- Forare Ø6 nelle varie posizioni (A+16.... B+16...) e (A+104.... B+104...)
- Inserire la piastrina (Q) H10401 nel telaio
Si consiglia di inserire la vite 3.9x13 nel foro J per il corretto posizionamento della piastrina
- Fissare con vite di sicurezza TB 3.9x9.5 UNI EN ISO 7050
- Fissare l'incontro alla piastrina con le viti M5x20 UNI EN SO 7046

SAFETY FIXING (optional)

- Drill Ø3 in the various position (A+91.... B+91...)
- Drill Ø6 in the various position (A+16.... B+16...) and (A+104.... B+104...)
- Insert the plate (Q) H10401 into the frame
it is recommended to insert the 3.9x13 screw in hole J for correct positioning of the plate
- Fix with safety screw TB 3.9x9.5 UNI EN ISO 7050
- Fix the counterplate to the plate with the M5x20 UNI EN SIO 7046 screws

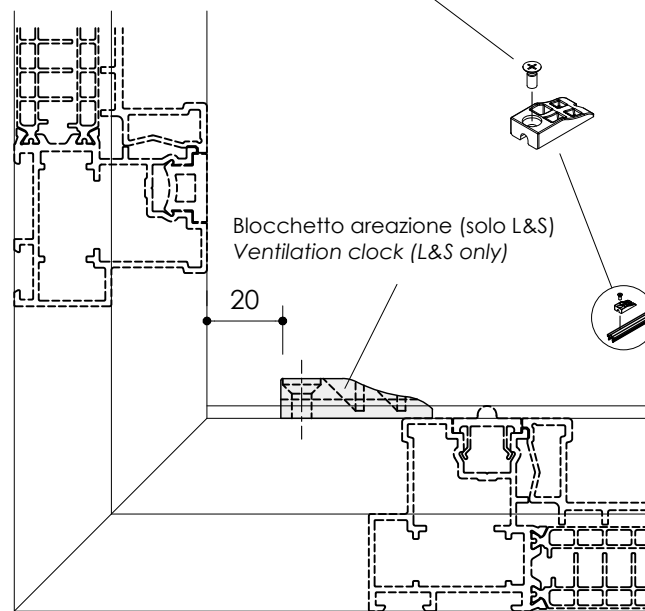


▶ ASSEMBLAGGIO COVER, BINARIO E GOCCIOLATOIO ASSEMBLY OF COVER, RAIL AND DRIP PROFILE



Vite M5x12 autoformante
compresa nel kit H10600 e H10601

Screw M5x12 self-forming
included in the H10600 and
H10601 kit

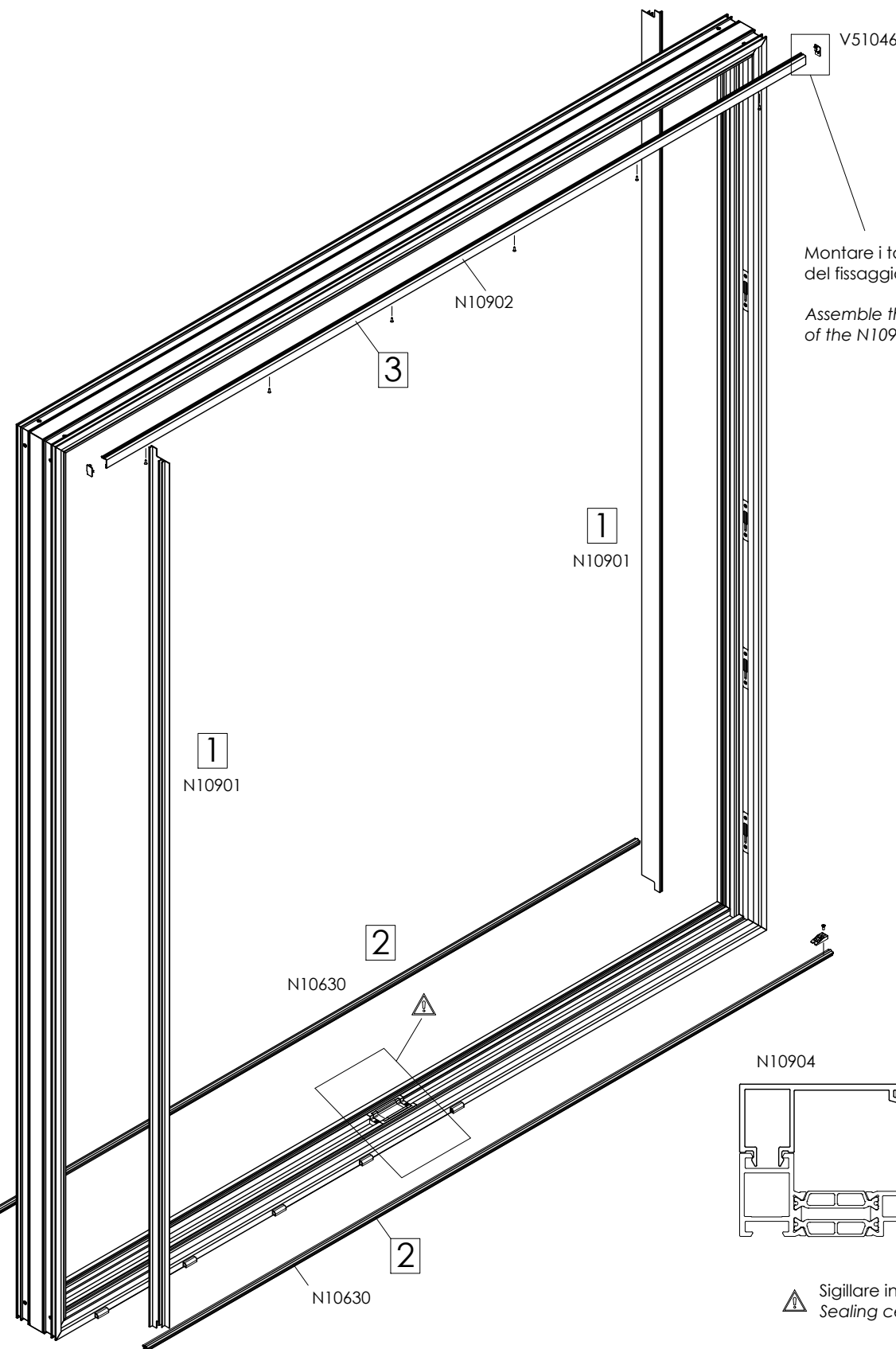


Blocchetto areazione (solo L&S)
Ventilation clock (L&S only)

20

Forare Ø4.5 mm il binario N10630
utilizzando il blocchetto di
areazione come dima

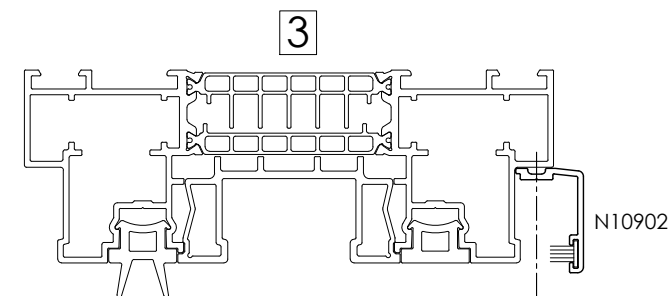
Drill Ø4.5 mm hte N10630 track
using the ventilation block as a
template



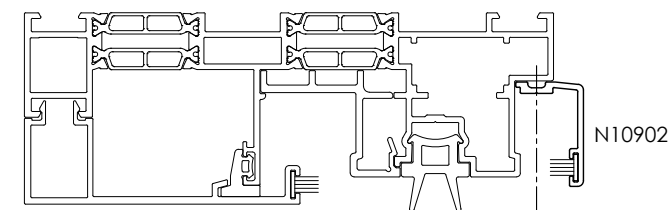
V51046

Montare i tappi terminali V51046 prima
del fissaggio del gocciolatoio N10902

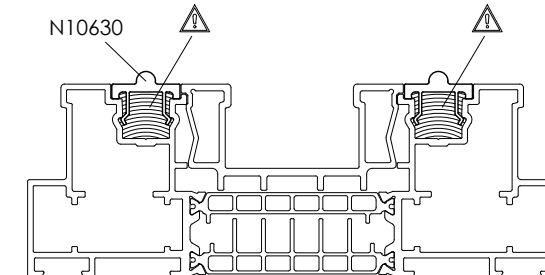
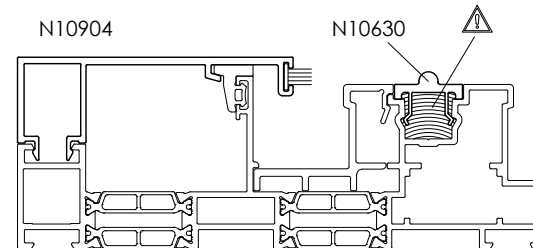
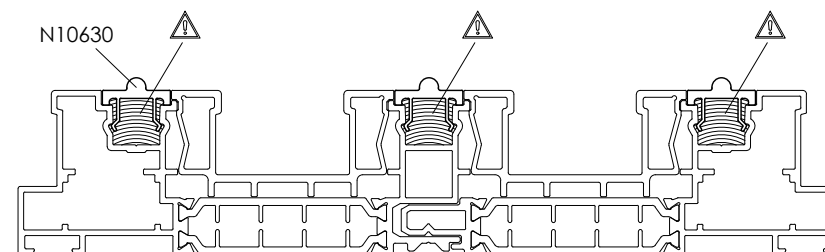
Assemble the V51046 end caps before
of the N10902 drip profile fixing



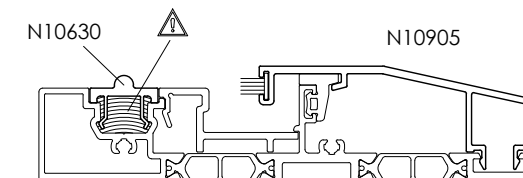
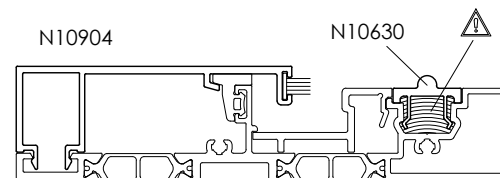
Utilizzare una vite ogni 500 mm
Use one screw every 500 mm

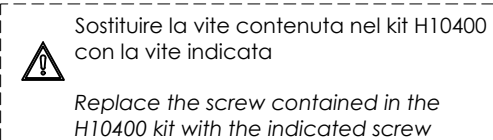
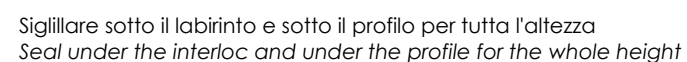
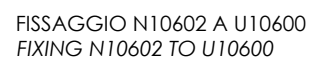


Vite TB 4.2x13
UNI EN ISO ISO 7049



⚠ Sigillare in zona centrale
Sealing central zone



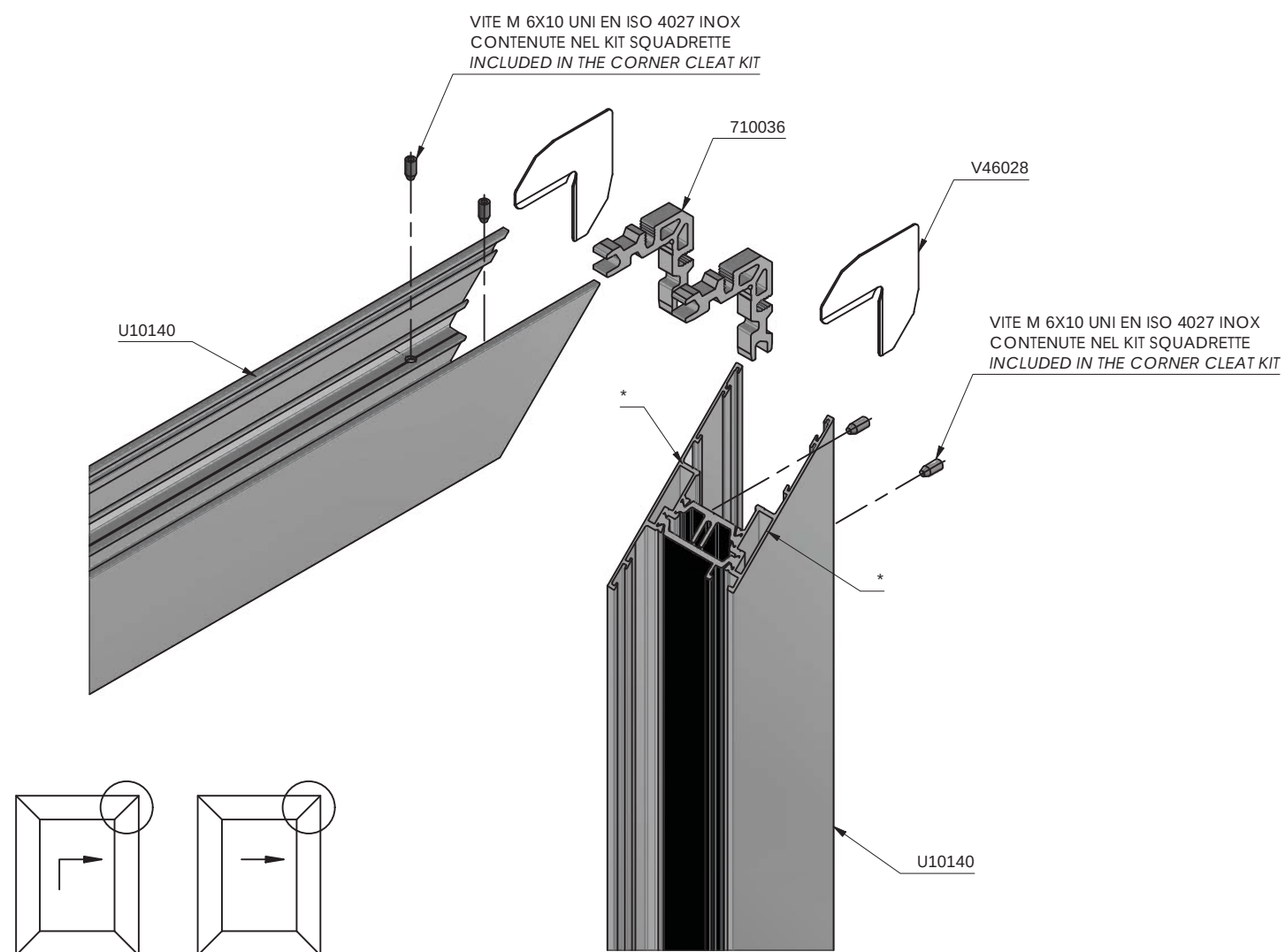


L'assemblaggio di questo montante non varia rispetto la tipologia OX

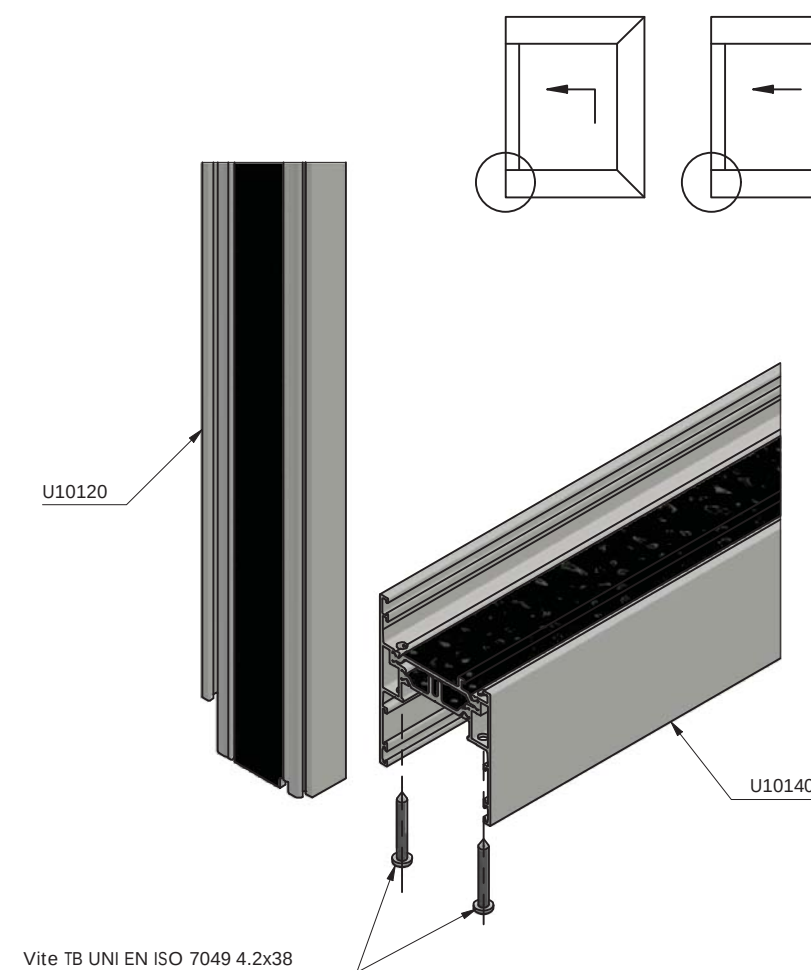
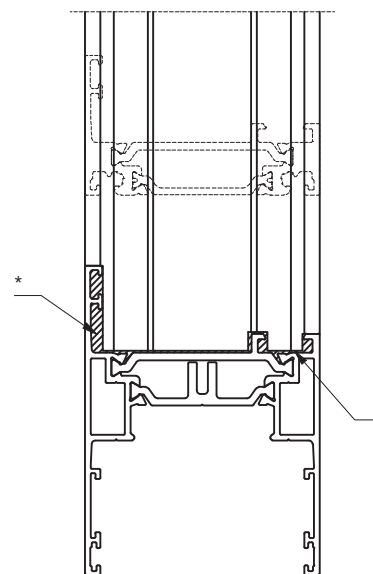
The assembly of this upright does not vary from the OX type

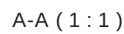


▶ ASSEMBLAGGIO ANTA SASH ASSEMBLING

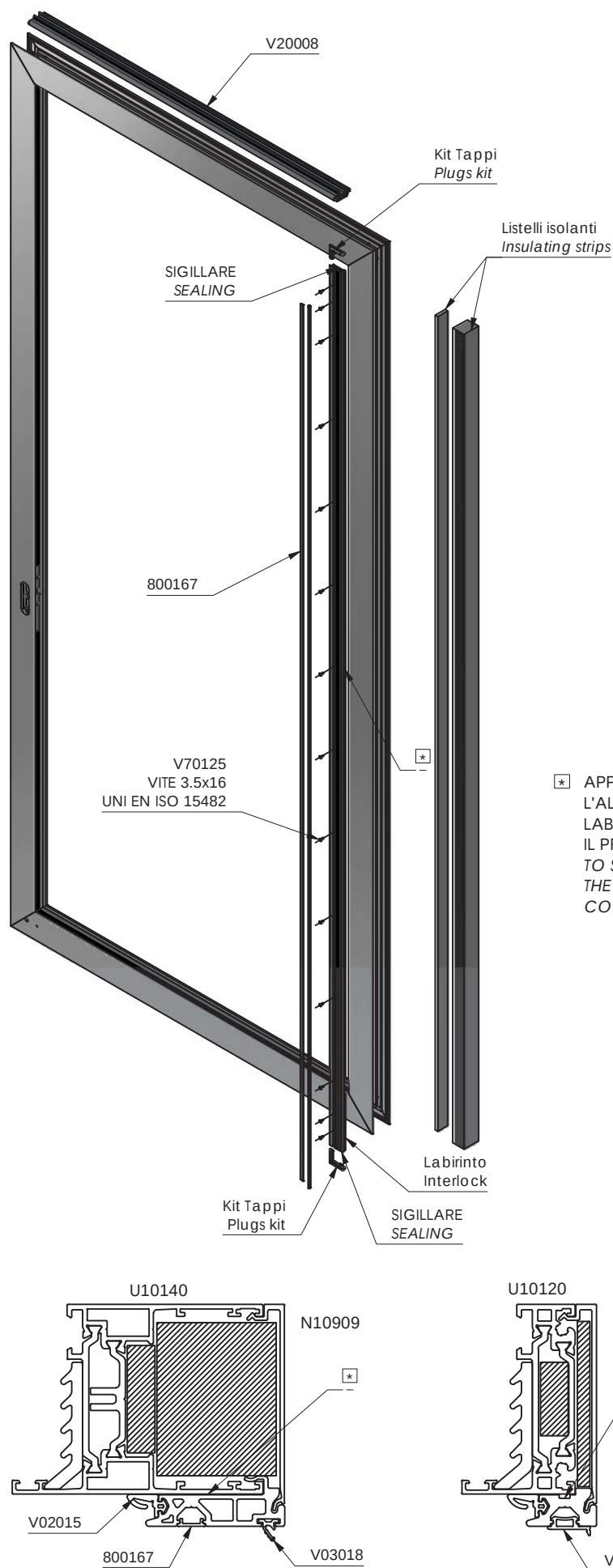
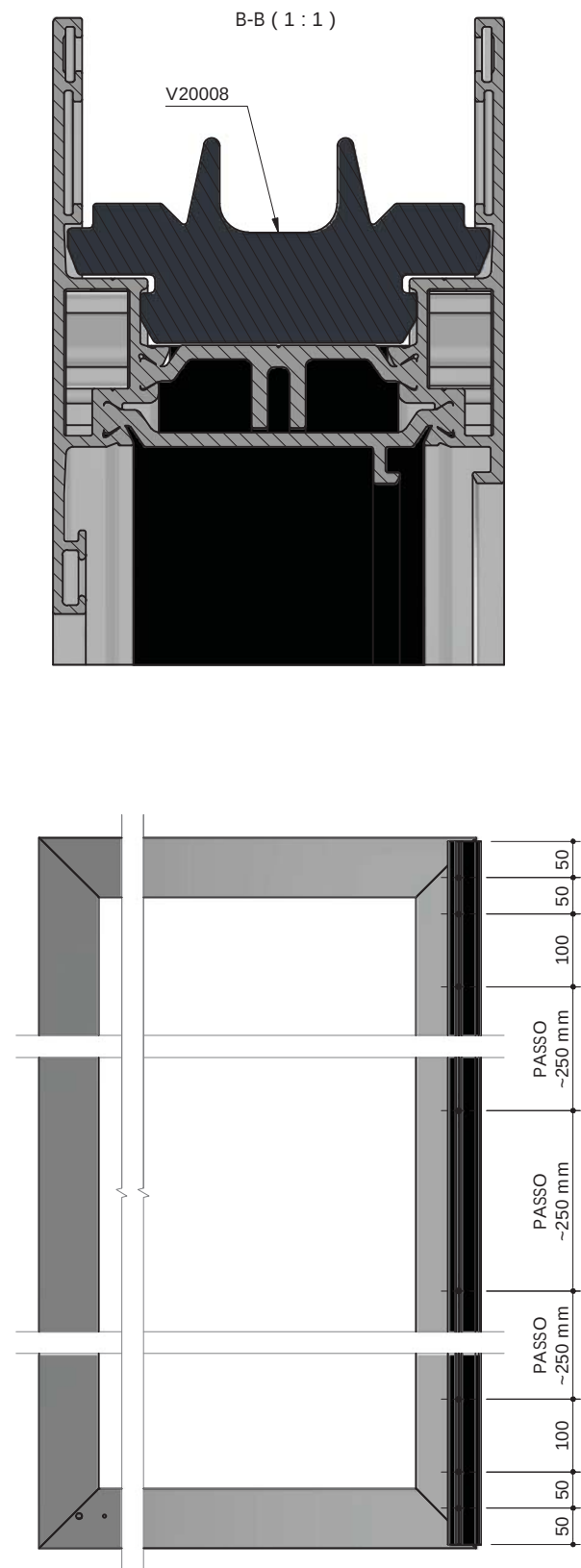


* APPLICARE SIGILLANTE SILICONICO SULLE SUPERFICI DI CONNESSIONE PRIMA DELL'UNIONE A TELAIO
 * APPLY SILICONE SEALING ON CONNECTION CORNER SURFACES BEFORE FRAME ASSEMBLING

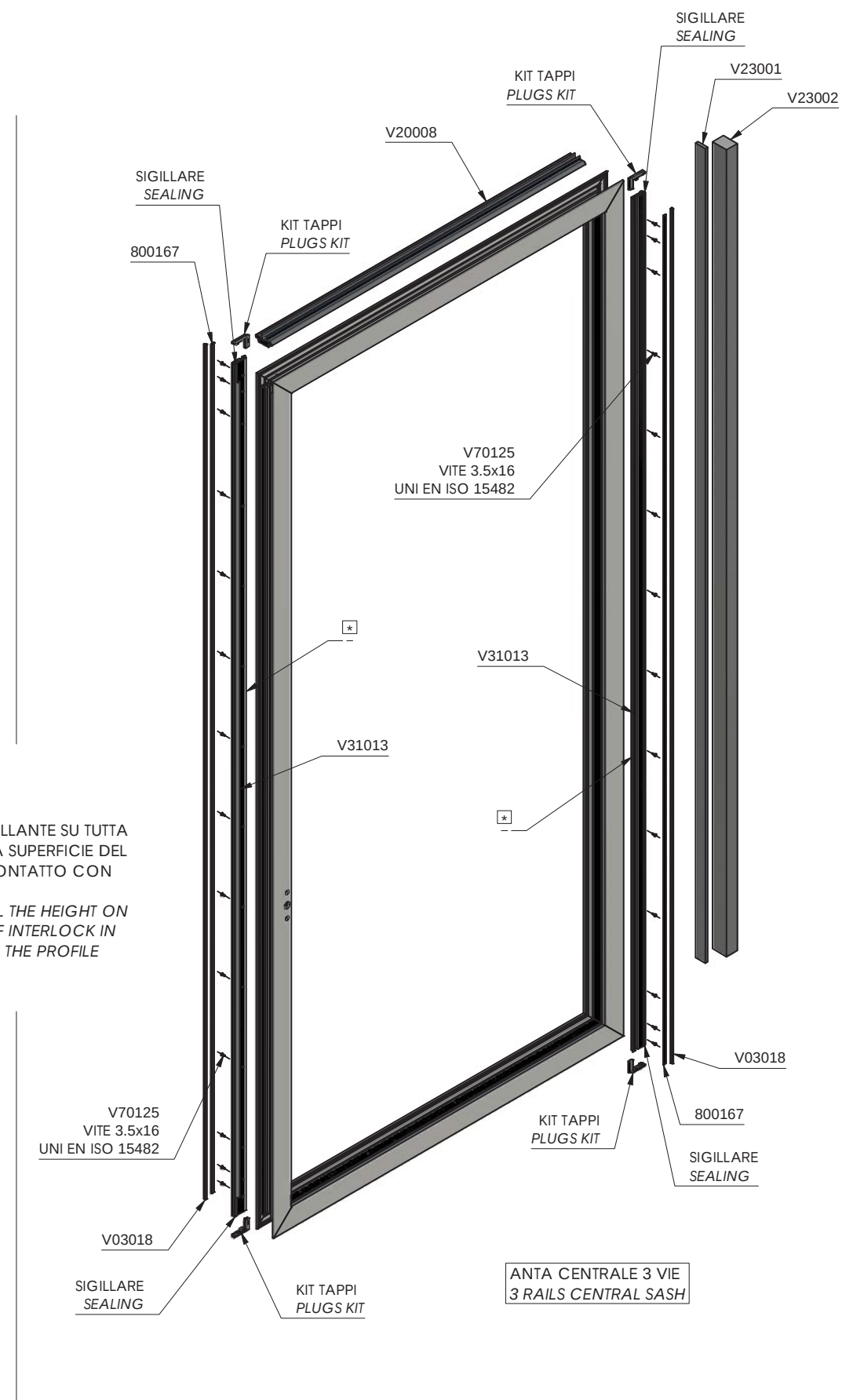




▶ MONTAGGIO LABIRINTO E LISTELLI ISOLANTI ANTA INTERLOCK AND SASH INSULATING STRIPS ASSEMBLING



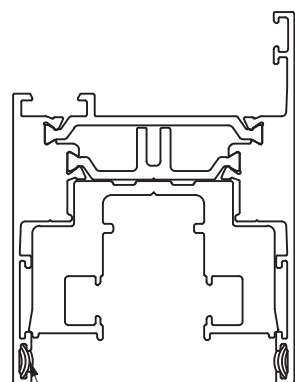
* APPLICARE SIGILLANTE SU TUTTA L'ALTEZZA SULLA SUPERFICIE DEL LABIRINTO A CONTATTO CON IL PROFILO
 TO SEAL ON ALL THE HEIGHT ON THE SURFACE OF INTERLOCK IN CONTACT WITH THE PROFILE



LABIRINTO / KIT TAPPI / LISTELLI - INTERLOCK / PLUGS KIT / INSULATING STRIPS			
Prof.	Labirinto - Interlock	Kit tappi - Plugs kit	Listelli - Insulating strips
U10140	V31013	V53054	V23001 + V23002
U10120	V31015	V53055	V23003 + V20009

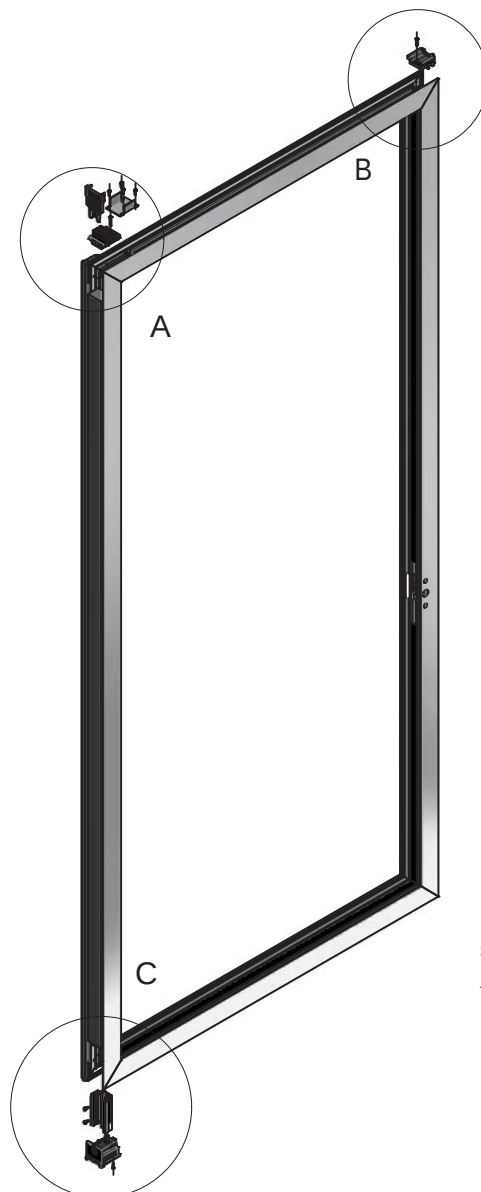
▶ ASSEMBLAGGIO TAPPI ANTA U10140 U10140 SASH PLUGS ASSEMBLING

C - ANGOLO INFERIORE CENTRALE
C - LOWER CENTRAL SECTION



NELLA ZONA D'ANGOLO
SIGILLARE DENTRO LA CAVA
IN THE CORNER SECTION
TO SEAL INTO THE GROOVE

SIGILLARE TRA TAPPO E COVER IN PCV
TO SEAL BETWEEN PLUG AND PVC COVER



B - ANGOLO SUPERIORE LATO MANIGLIA
B - UPPER SECTION HANDLE SIDE

A - ANGOLO SUPERIORE LATO CENTRALE
A - UPPER CENTRAL SECTION

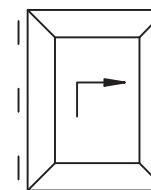
SIGILLARE SEAL

SIGILLARE SEAL

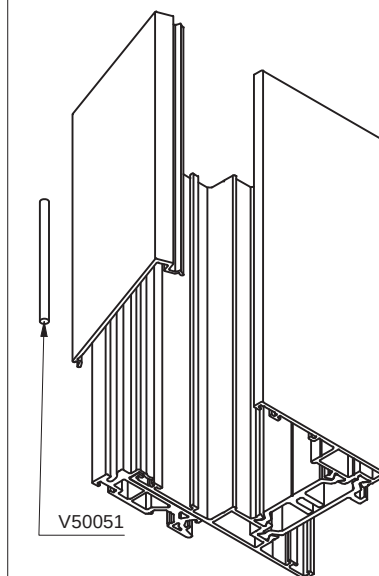
SIGILLARE SEAL

SIGILLARE SEAL

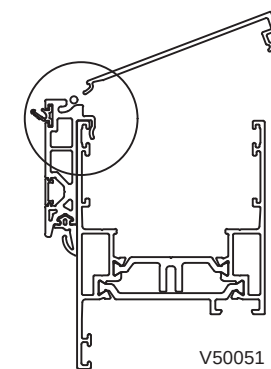
- MONTAGGIO E POSIZIONAMENTO V50051
- INSSEMBLY AND POSITIONING V50051



- TRE PEZZI PER ANTA
IL PRIMO A 200 MM DALL'ANGOLO
- THREE PIECES PER SASH
THE FIRST 200 MM FROM THE CORNER



V50051



V50051

V31013

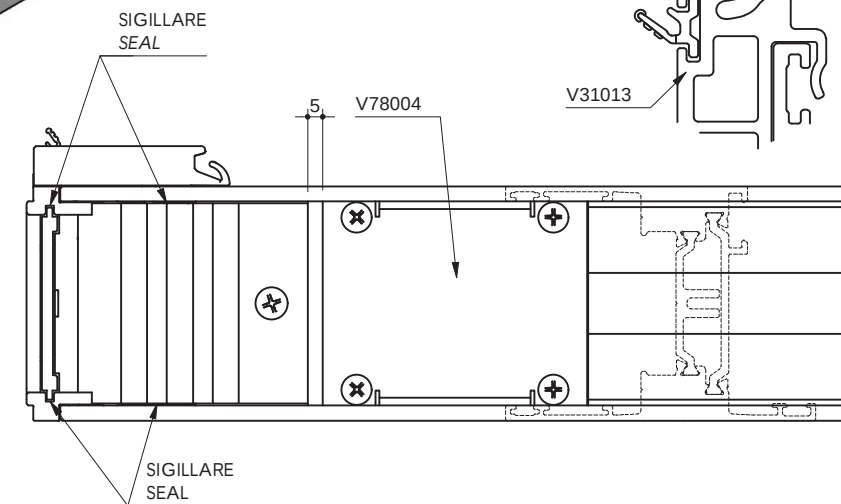
- INSERIRE NELLA COVER IN PVC INFERIORE L'ACCESSORIO V59140 (Det.Y)
- ALLENTARE LE VITI DI FISSAGGIO LABIRINTO (f)
- FAR SCORRERE NELL'ANTA L'ACCESSORIO V58045
- FISSARE IN POSIZIONE CON LA VITE (g) IL TAPPO INFERIORE
- FARE ADERIRE TAPPO INFERIORE E ACCESSORIO V58045
- FISSARE L'ACCESSORIO V58045

- INSERT THE V59140 ACCESSORY IN THE LOWER PVC COVER (Det.Y)
- LOOSEN THE LABYRINTH FIXING SCREWS (f)
- SLIDE THE V58045 ACCESSORY INTO THE SASH
- FIX THE BOTTOM CAP IN POSITION WITH THE SCREW (g)
- ADHES THE LOWER CAP AND V58045 ACCESSORY
- FIX THE V58045 ACCESSORY

(Det.Y)

V59140

PER LA CORRETTA POSIZIONE VEDERE PAGINA DEDICATA (10.27)
FOR THE CORRECT POSITION SEE RELATED PAGE (10.27)



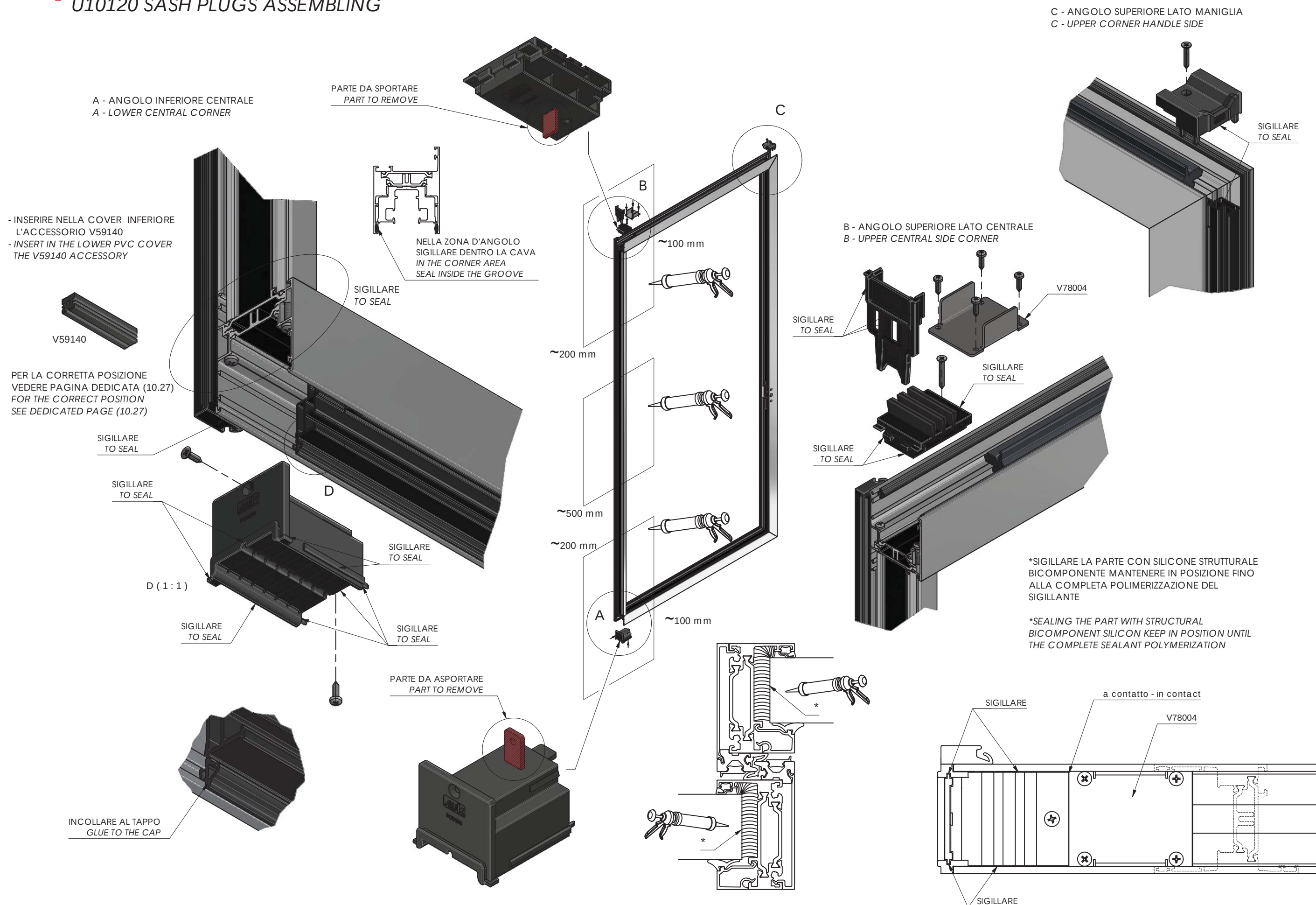
SIGILLARE SEAL

5

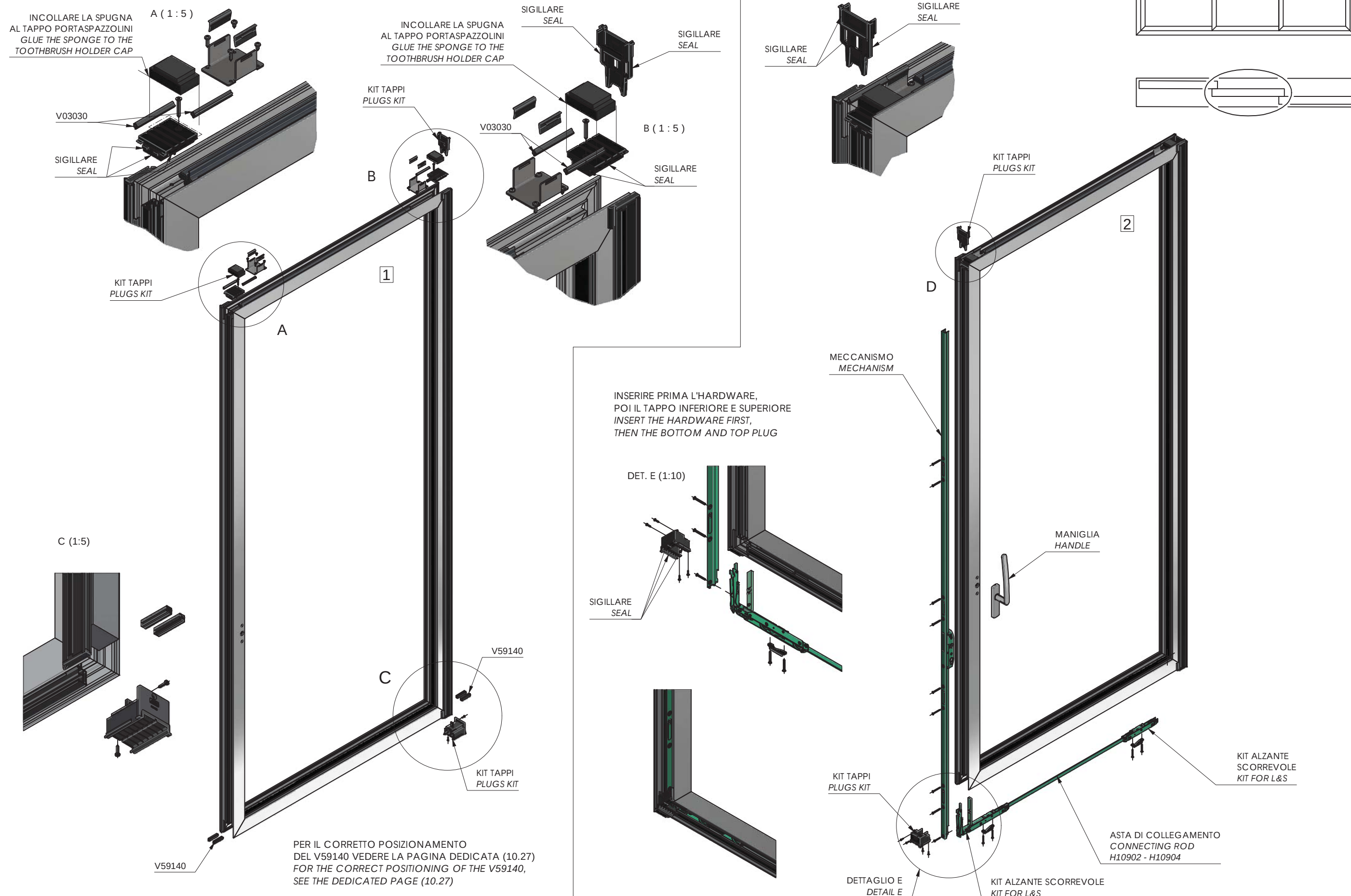
V78004

SIGILLARE SEAL

▶ ASSEMBLAGGIO TAPPI ANTA SLIM U10120 U10120 SASH PLUGS ASSEMBLING



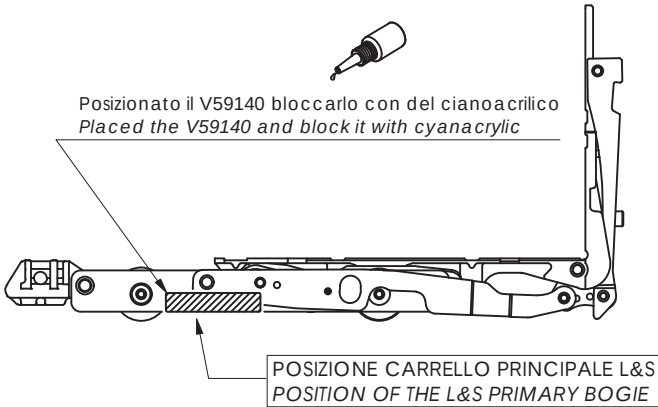
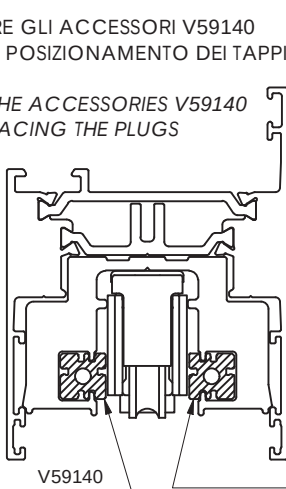
ASSEMBLAGGIO TAPPI E FERRAMENTA ANTA CENTRALE 3 VIE 3 RAILS CENTRAL DOOR PLUGS AND MECHANISM ASSEMBLY



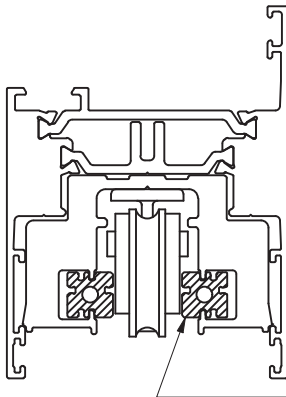
MONTAGGIO FERRAMENTA HARDWARE ASSEMBLY

PREINFILARE GLI ACCESSORI V59140
PRIMA DEL POSIZIONAMENTO DEI TAPPI

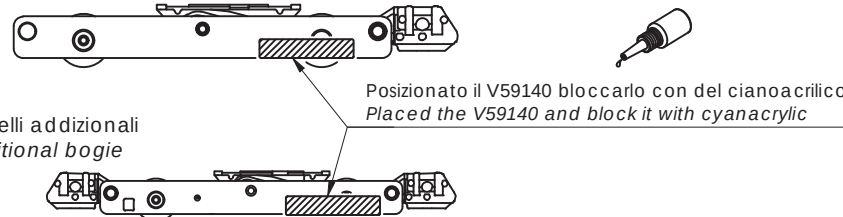
PRE-PULL THE ACCESSORIES V59140
BEFORE PLACING THE PLUGS



Lato piccolo, una gola verso il carrello
Small side, one groove towards the bogie



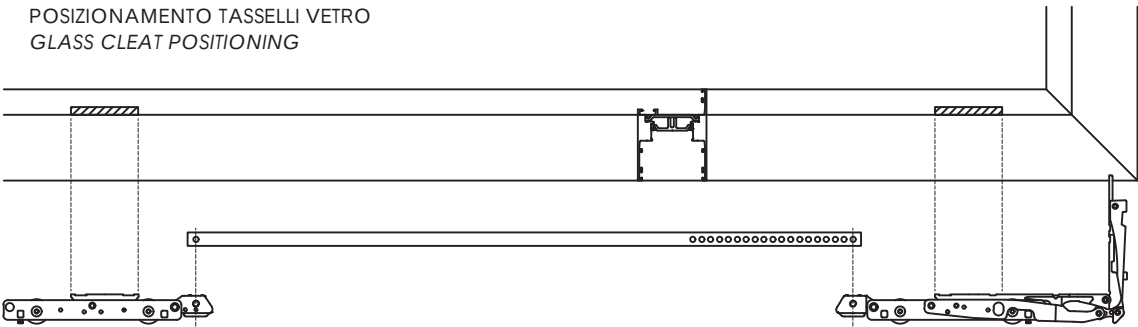
POSIZIONE PER CARRELLO SECONDARIO L&S
POSITION OF THE L&S SECONDARY BOGIE



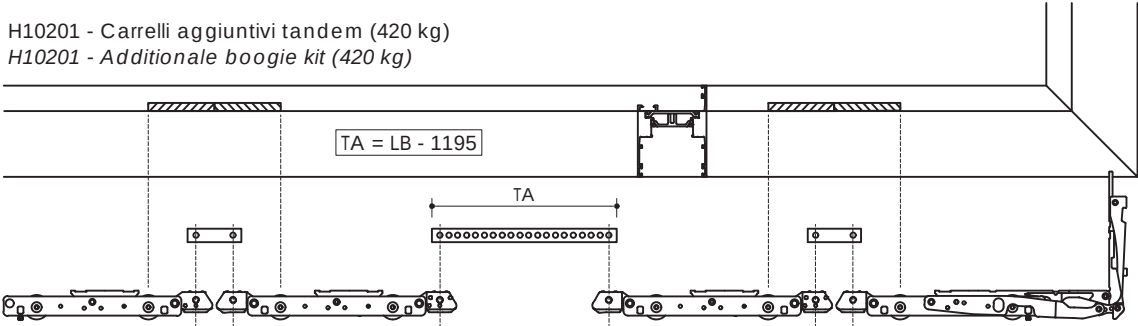
Carrelli aggiuntivi
Additional bogie

lato grosso, una gola verso il carrello
Big side, one groove towards the bogie

POSIZIONAMENTO TASSELLI VETRO
GLASS CLEAT POSITIONING



H10201 - Carrelli aggiuntivi tandem (420 kg)
H10201 - Additional bogie kit (420 kg)



ASTA DI COLLEGAMENTO -
CONNECTING ROD

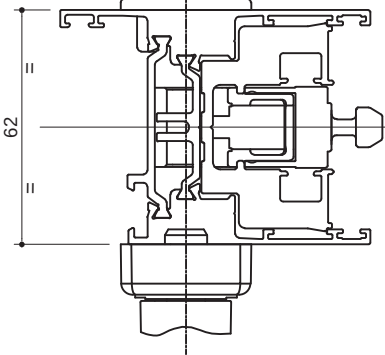
Cod.	Range [mm]
H10902	730÷2000
H10904	2001÷3240

ASTA DI COLLEGAMENTO
CONNECTING ROD
TA = LB - 646.5 mm

KIT alzante scorrevole
Kit for L&S

LB (min 730mm)

HA



MANIGLIA
HANDLE

LATO INTERNO
INTERNAL SIDE

Cover finitura meccanismo
(L=600 mm)
Mechanism cover profile
(L=600 mm)

LATO ESTERNO
EXTERNAL SIDE

Spessore da utilizzare
per diminuire la pressione
dell'anta in chiusura
Thickness to use
to decrease the pressure
of the closing wing

MECCANISMI - MECHANISM	
Cod.	HA
H10402*	1370 - 1970
H10403	1971 - 2270
H10404	2271 - 2570
H10405	2571 - 2870

* Rifilabile 1200 mm
* Trimmed 1200 mm

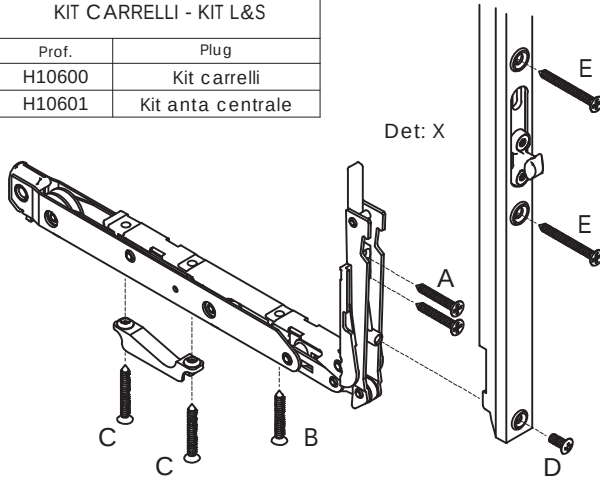
OPZIONALE (SIGILLARE LA SEDE DELLA VASCHETTA)
OPTIONAL (SEAL THE BASE OF THE MORTISE)

VITE - SCREW	
Pos.	VITE
A	4x35 (DIN 7502-A)
B	5x35 (DIN 7505-A)
C	5x40 (DIN 7505-A)
D	M5x10 (ISO 7046)
E	5x45 (DIN 7505-A)

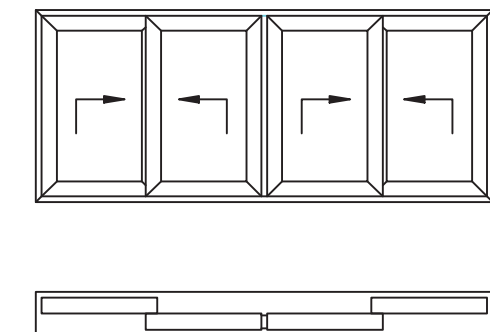
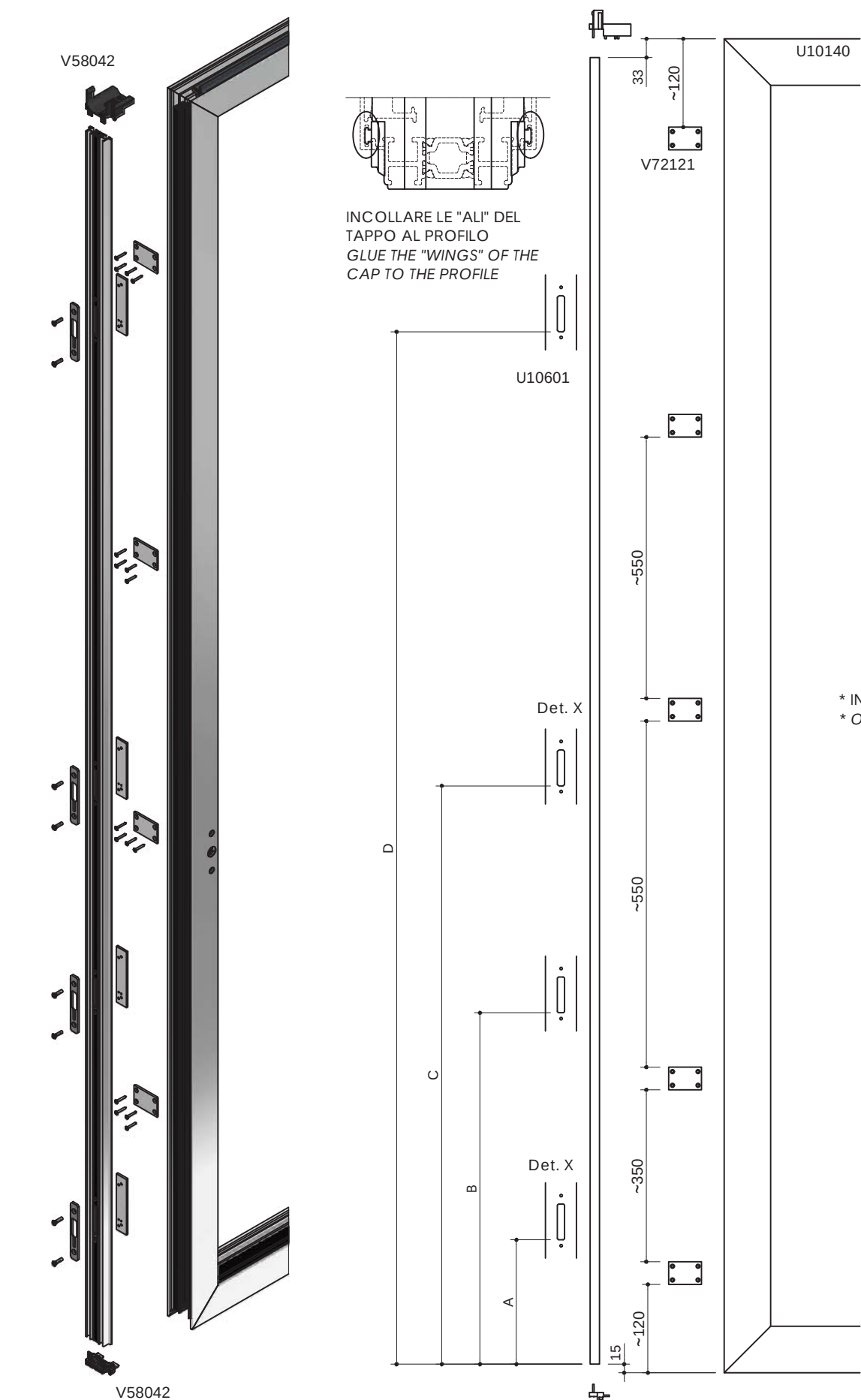
KIT CARRELLI - KIT L&S

Prof.	Plug
H10600	Kit carrelli
H10601	Kit anta centrale

Det: X

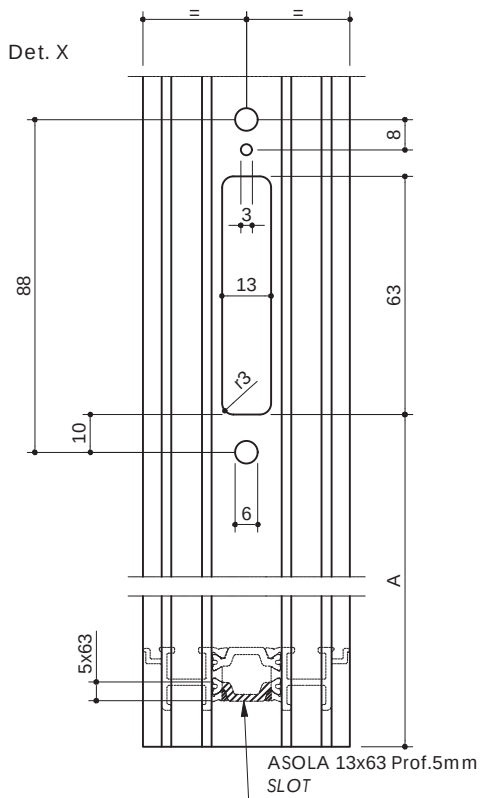


MONTAGGIO SOLUZIONE ANTE IN LINEA ASSEMBLY OF THE IN-LINE DOOR SOLUTION

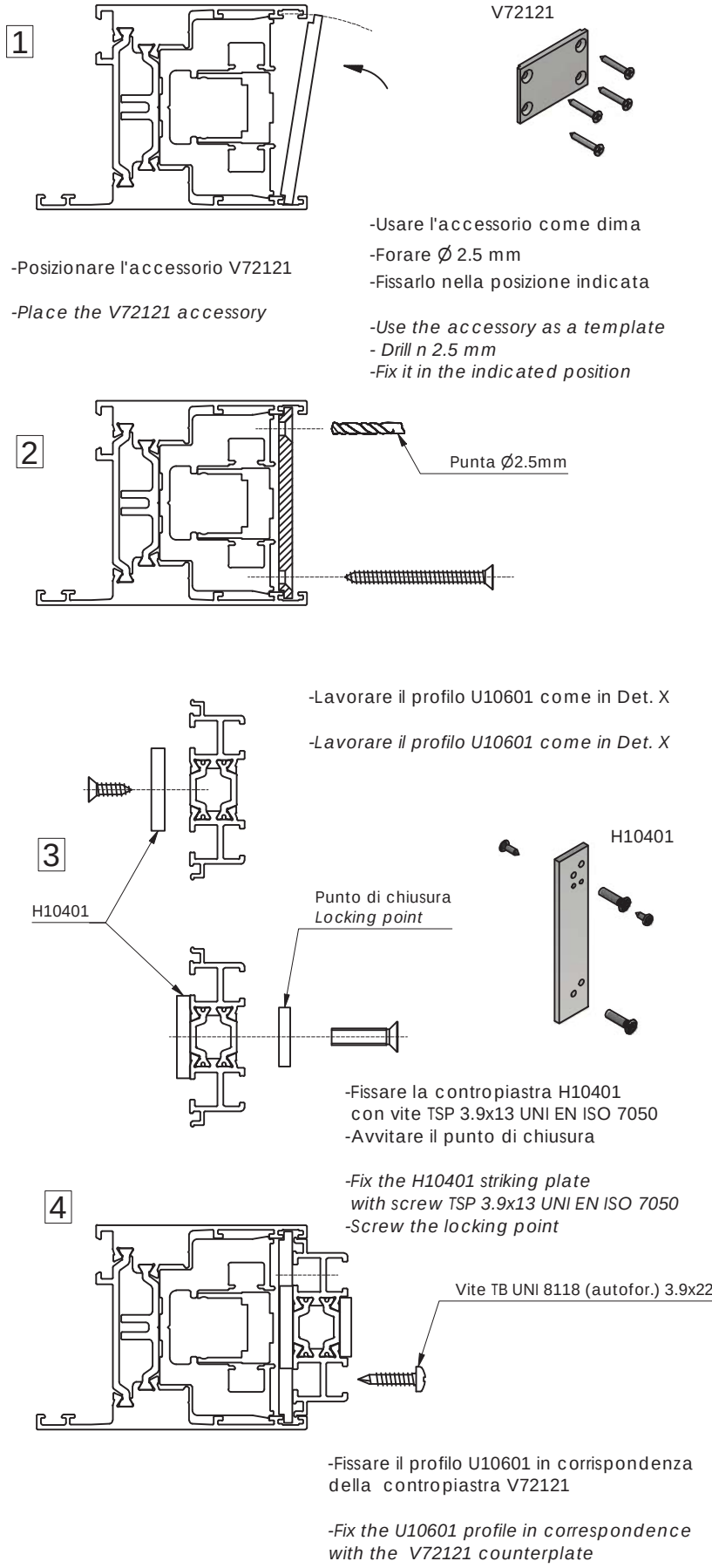


POSIZIONAMENTO INCONTRI - COUNTERPLATE POSITIONING				
Prof.	A	B	C	D
H10402	219	569*	969	-
H10403	219	719*	1169*	1569
H10404	219	719*	1169*	1869
H10405	219	719*	1169*	2169

* INCONTRI OPZIONALI, PUNTO DI CHUSURA AGGIUNTIVO COD. H10400
* OPTIONAL COUNTERPLATE, ADDITIONAL CLOSING POINT COD. H10400

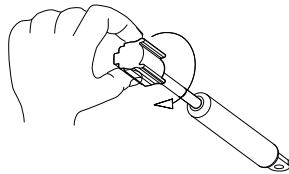
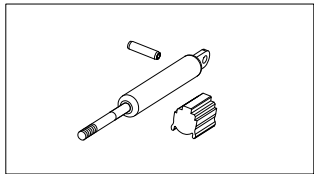


SEQUENZA MONTAGGIO PROFILO U10601 PROFILE ASSEMBLY SEQUENCE U10601

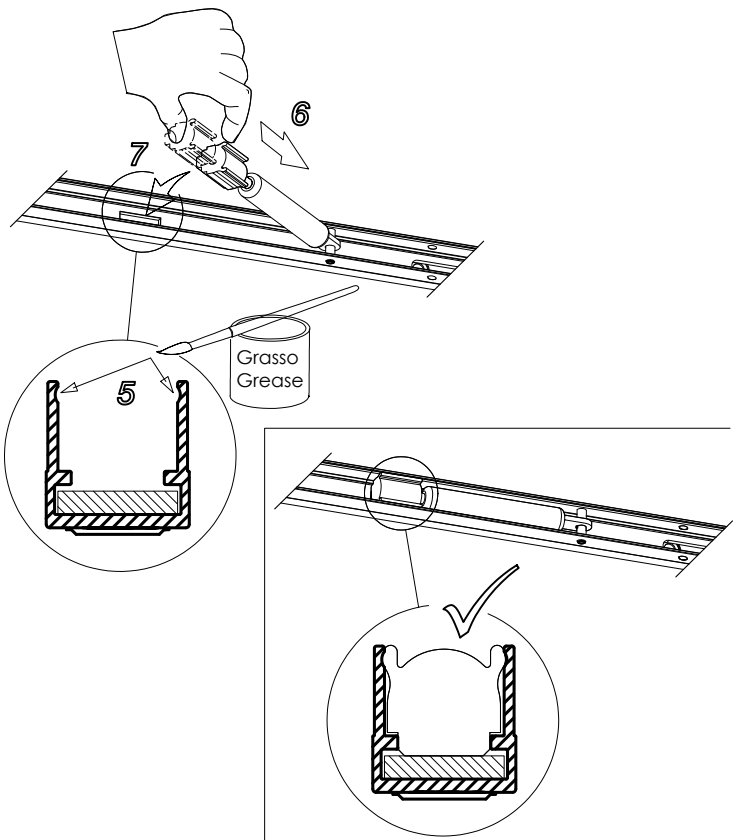
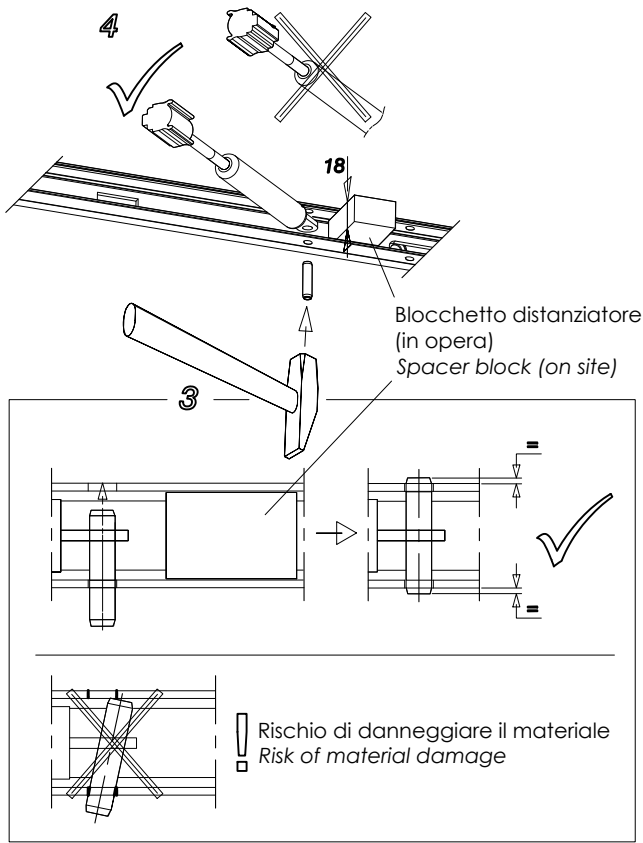
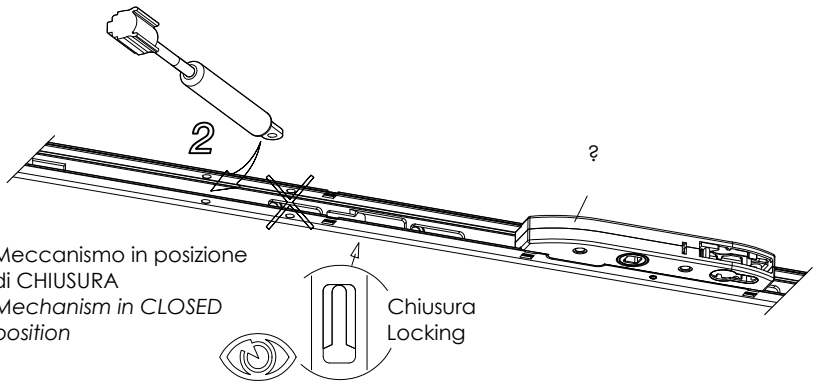


ASSEMBLAGGIO AMMORTIZZATORE DI SICUREZZA V69052 PER MANIGLIA
V69052 HANDLE SAFETY SHOCK ABSORBER ASSEMBLY

DA UTILIZZARE SU ANTE A PARTIRE DAI 150 kg
TO BE USED ON SASH STARTING FROM 150 kg



1 Avvitare fino a fine corsa
Turn up to the stop



➤ ASSEMBLAGGIO DEL SUPPORTO DI SOLLEVAMENTO NEL MECCANISMO SASH LIFTING SUPPORT WITHIN THE MECHANISM ASSEMBLING

DA UTILIZZARE SU ANTE A PARTIRE DAI 150 kg
TO BE USED ON SASH STARTING FROM 150 kg

- A** Portare il meccanismo in posizione sollevata (A.1/A.2)
- B** Inserire il perno di riferimento
- C** Posizionare la molla di tensione all'interno del meccanismo
- D** Tirare l'estremità della molla di trazione sopra la punteria sull'asta di comando (mediante un cacciavite) (D.1/D.2)
- E** Supporto per il sollevamento dell'anta montato correttamente

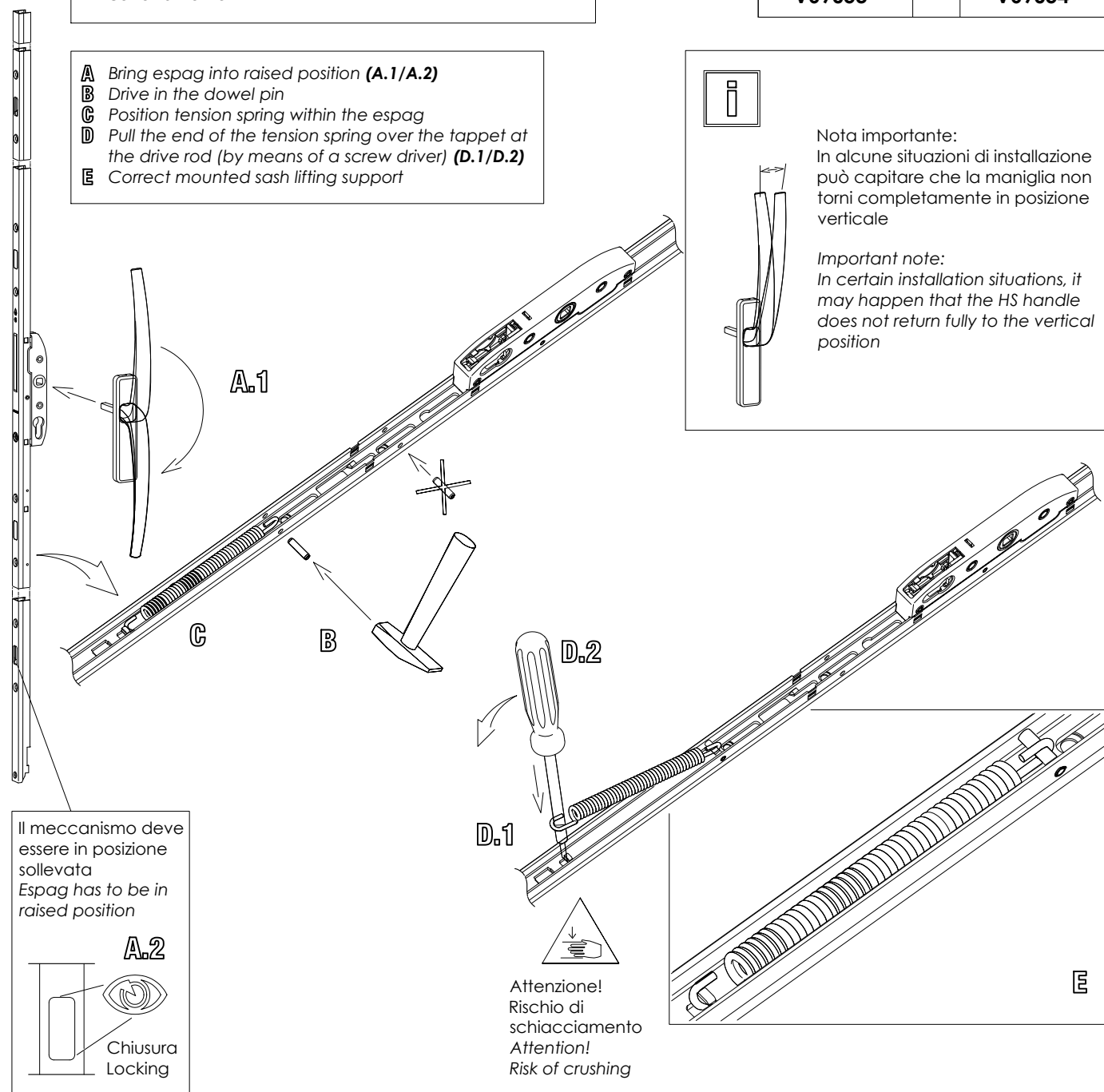
- A** Bring espag into raised position (A.1/A.2)
- B** Drive in the dowel pin
- C** Position tension spring within the espag
- D** Pull the end of the tension spring over the tappet at the drive rod (by means of a screw driver) (D.1/D.2)
- E** Correct mounted sash lifting support

UTILIZZO CONSIGLIATO RECOMMENDED USE	
Accessori per ante di peso.. Accessories for sash weight..	
≤ 200 kg	> 200 kg
	
V69053	V69054



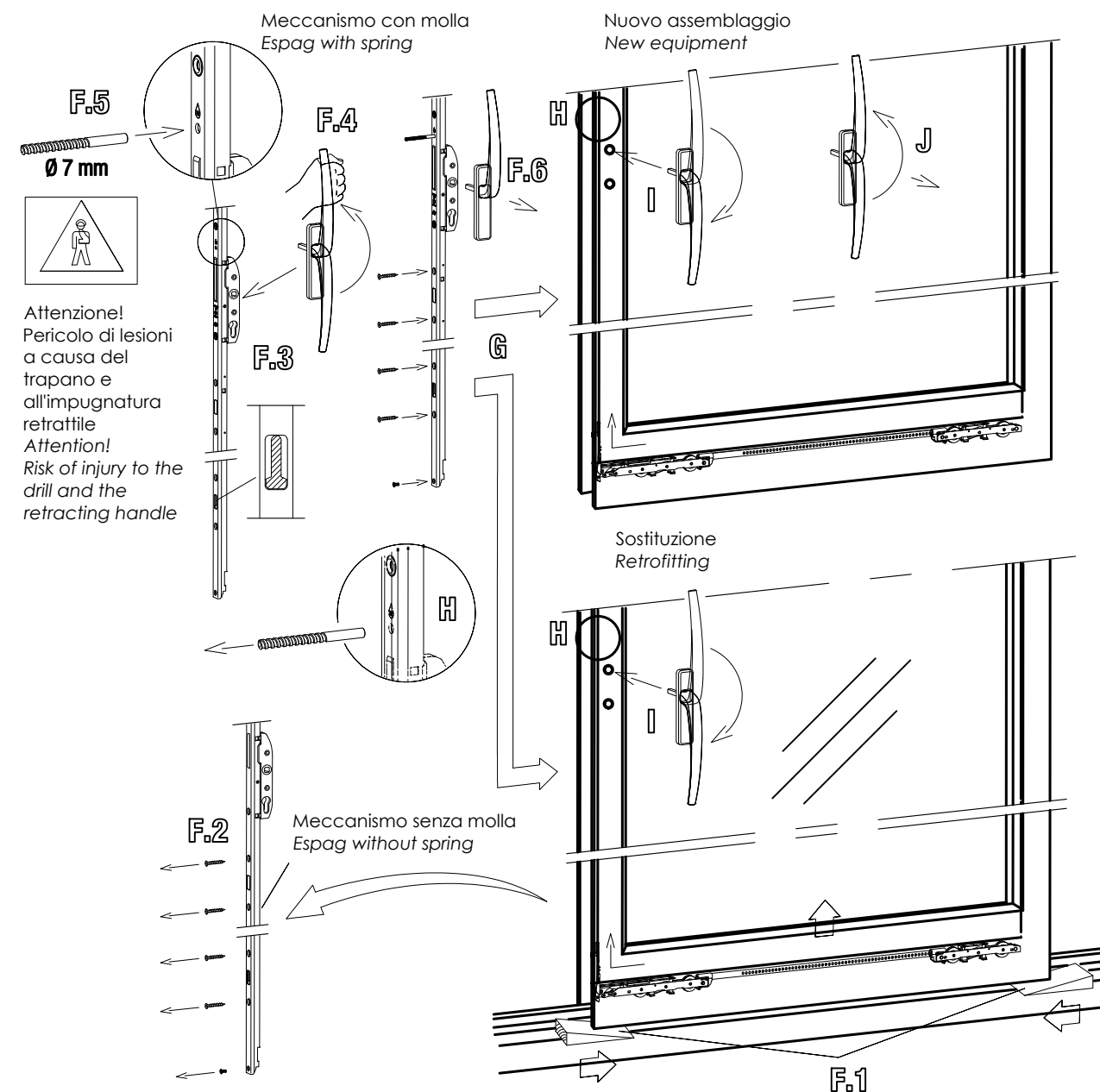
Nota importante:
In alcune situazioni di installazione può capitare che la maniglia non torni completamente in posizione verticale

Important note:
In certain installation situations, it may happen that the HS handle does not return fully to the vertical position



- F** In caso di sostituzione, solo:
- fornire cunei di legno per sostenere l'anta (F.1)
- smontare la maniglia
- rimuovere il meccanismo senza il supporto sollevamento anta (F.2)
- In caso di nuova attrezzatura / sostituzione:
- portare il meccanismo (con supporto sollevamento anta) tramite la maniglia in posizione abbassata (F.3)
- **attenzione: pericolo di lesioni!**
- Tenendo il meccanismo in posizione abbassata tramite l'impugnatura (F.4), inserire il trapano con diametro 7 mm sotto il simbolo "goccia d'olio" attraverso l'asta di trascinamento per bloccare il meccanismo (F.5). Rimuovere la maniglia (F.6)
- G** Montaggio del meccanismo (i dettagli si riferiscono alle istruzioni generali di montaggio)
- H** Rimuovere il trapano
- I** Portare l'anta in posizione sollevata tramite la maniglia
- J** In caso di attrezzatura nuova: portare l'anta in posizione abbassata tramite la maniglia. Rimuovere la maniglia fino al montaggio finale dell'anta.
In caso di sostituzione: montare completamente la maniglia (nessuna figura, fare riferimento alle istruzioni generali di montaggio)

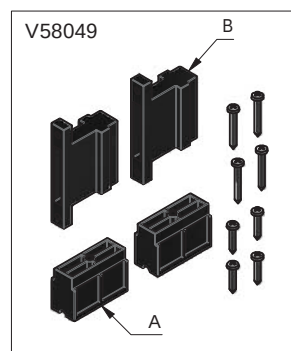
- F** In case of retrofitting, only:
- provide timber wedges to support sash (F.1)
- dismantle the handle
- remove espag without sash lifting support (F.2)
- In case of new equipment / retrofitting:
- bring espag (with sash lifting support) by means of the handle into lowered position (F.3)
- **Caution: risk of injury!**
- While holding the espag in lowered position by means of the handle (F.4), insert the drill with diameter 7 mm below the symbol "oil drop" through the drive rod to lock the espag (F.5). Remove the handle (F.6)
- G** Mounting of the espag (details refer to general mounting instructions)
- H** Remove drill
- I** Bring sash into raised position by means of the handle
- J** In case of new equipment: bring sash into lowered position by means of the handle. Remove handle until final mounting of the sash.
In case of retrofitting: mount the handle completely (no figure, refer to general mounting instructions)



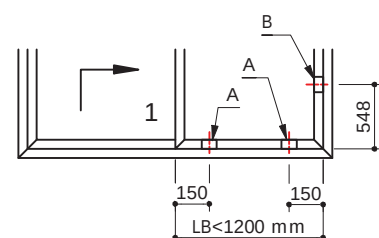
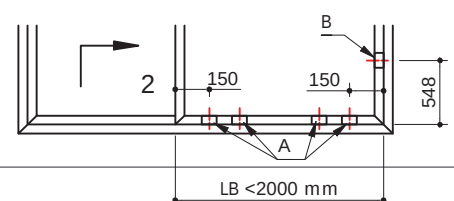
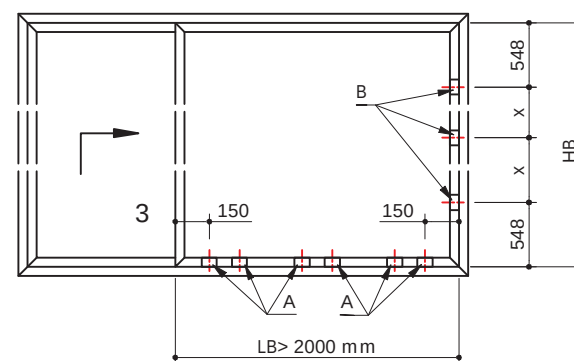
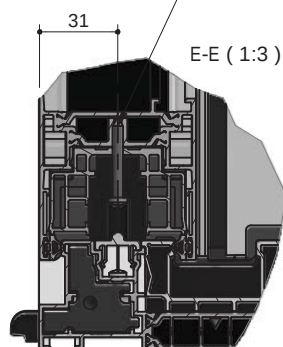


➤ **ASSEMBLAGGIO KIT PER FISSAGGIO ANTA FISSA SU TELAIO**
KIT FOR FIXED SASH FASTENING ASSEMBLING

ANTA MOBILE
MOVABLE SASH



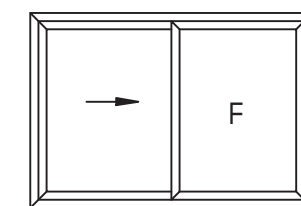
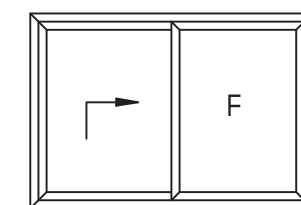
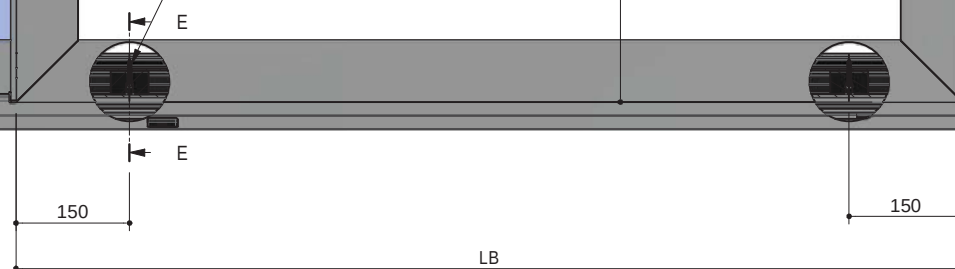
VITE 4.2x32
UNI EN ISO 7049



ANTA FISSA
FIXED SASH

VITE 4.2x32
UNI EN ISO 7049

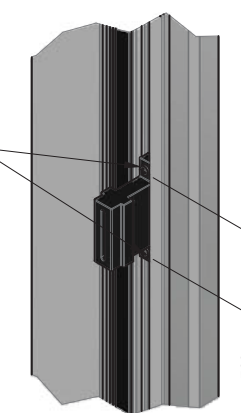
VITE 4.2x32
UNI EN ISO 7049



TELAIO
FIXED FRAME

C (1:5)

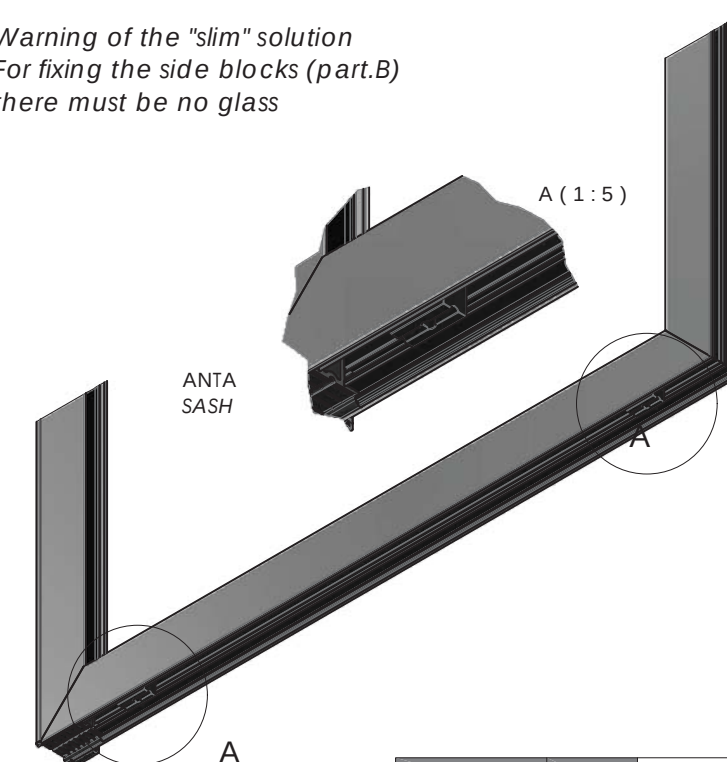
VITE 4.2x22
UNI EN ISO 7049



Attenzione alla soluzione "slim"
Per il fissaggio dei blocchetti laterali (part.B)
non deve essere presente il vetro

Warning of the "slim" solution
For fixing the side blocks (part.B)
there must be no glass

A (1:5)



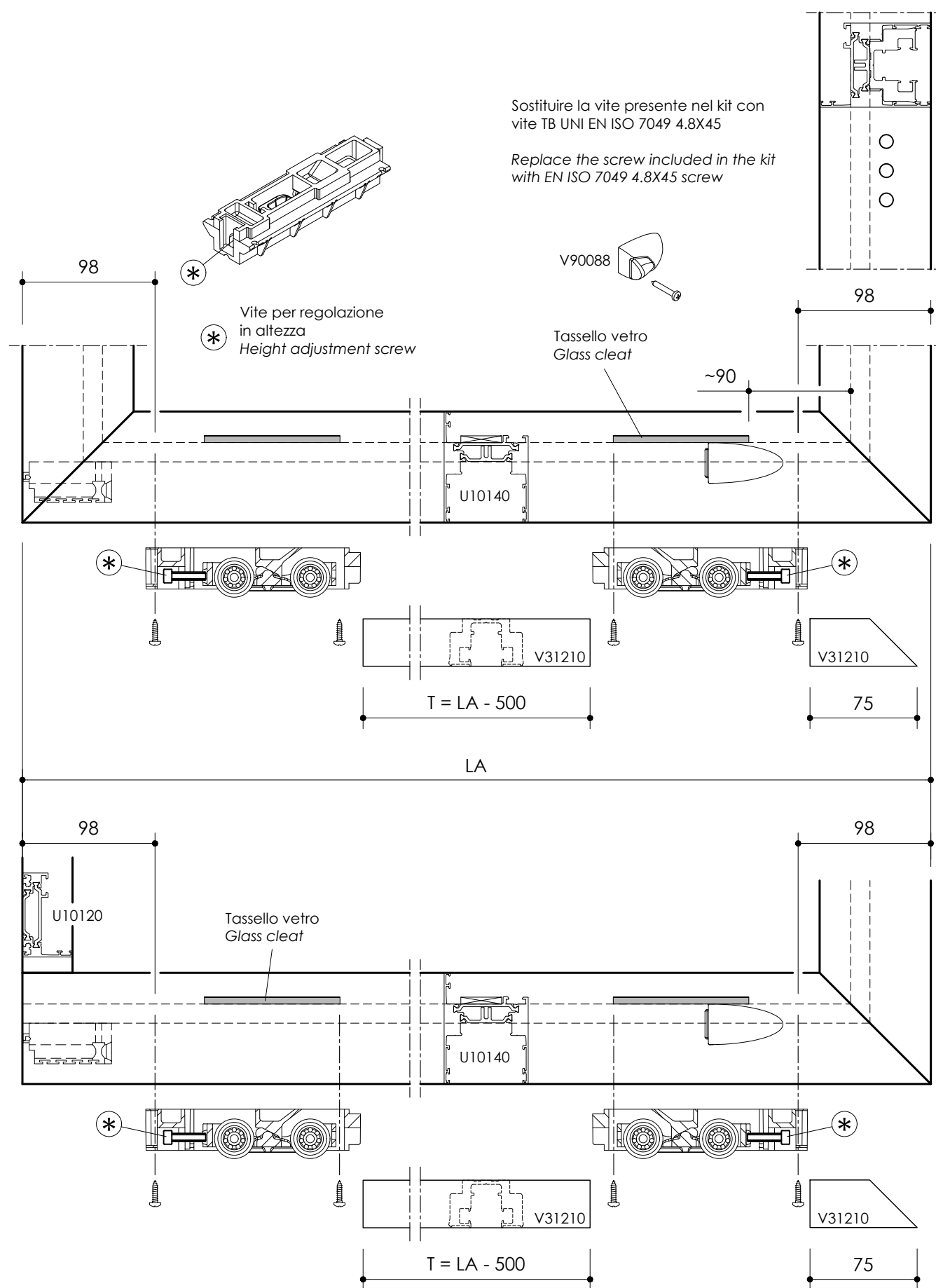
- 1 - Utilizzare V58049 per ante fino a 1200 mm e al di sotto dei 100 kg.
- 2 - Utilizzare N°2 V58049 per ante fino a 2000 mm di larghezza e superiori a 100 kg.
- 3 - Per ante superiori a 2000 mm utilizzare N°3 V58049, di cui 2 componenti A nella parte centrale dell'antra,

- 1 - Use V58049 for sash up to 1200 mm and lighter than 100 kg.
- 2 - Use N°2 V58049 for sash up to 2000 mm of width and superior of 100 kg.
- 3 - For sash larger than 2000 mm use N°3 V58049, of which N° 2 in centre of the sash.

D-D (1:3)



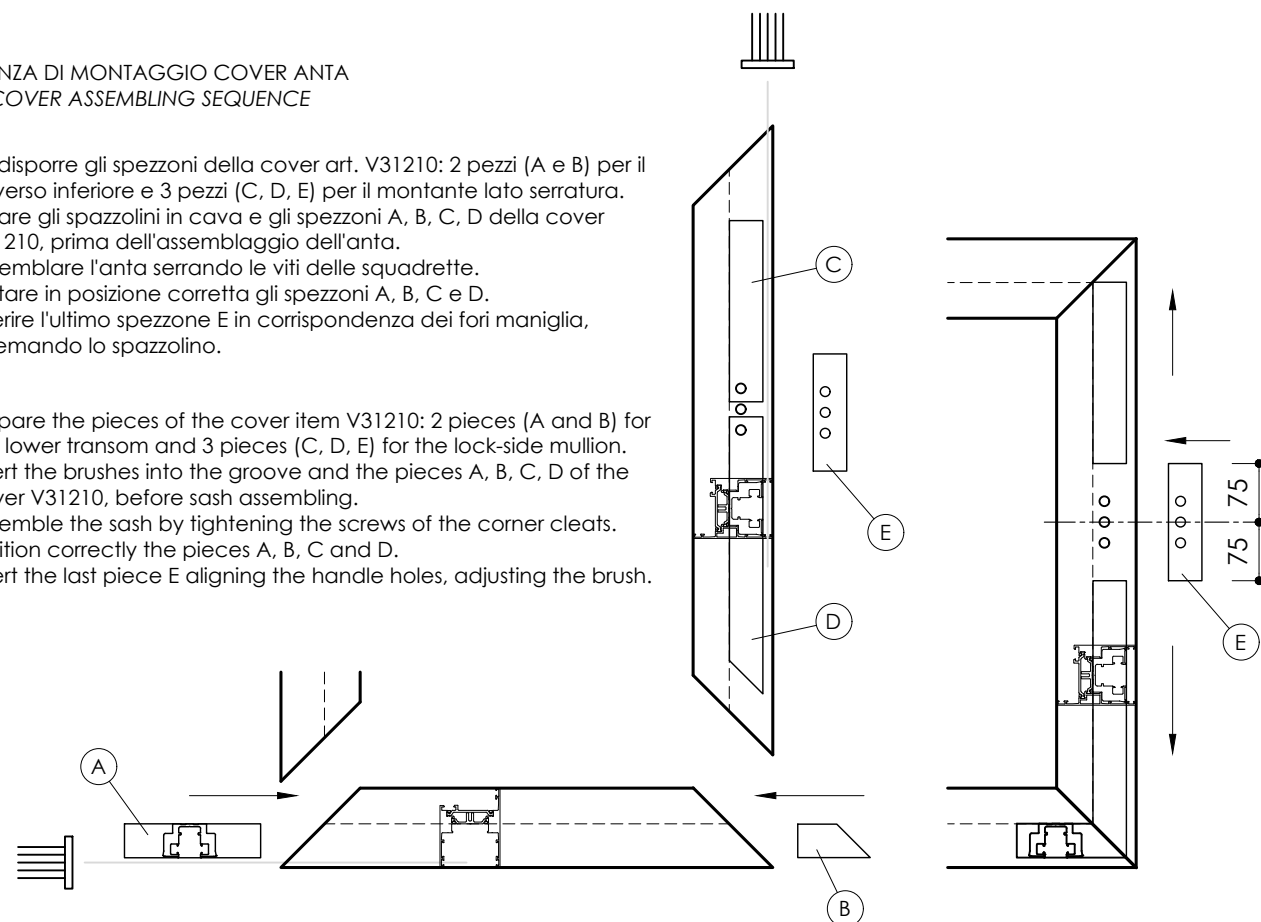
➤ **S140R - ASSEMBLAGGIO COVER, SPAZZOLINO E CARRELLI** **S140R - COVER, BRUSH AND BOGIES ASSEMBLING**



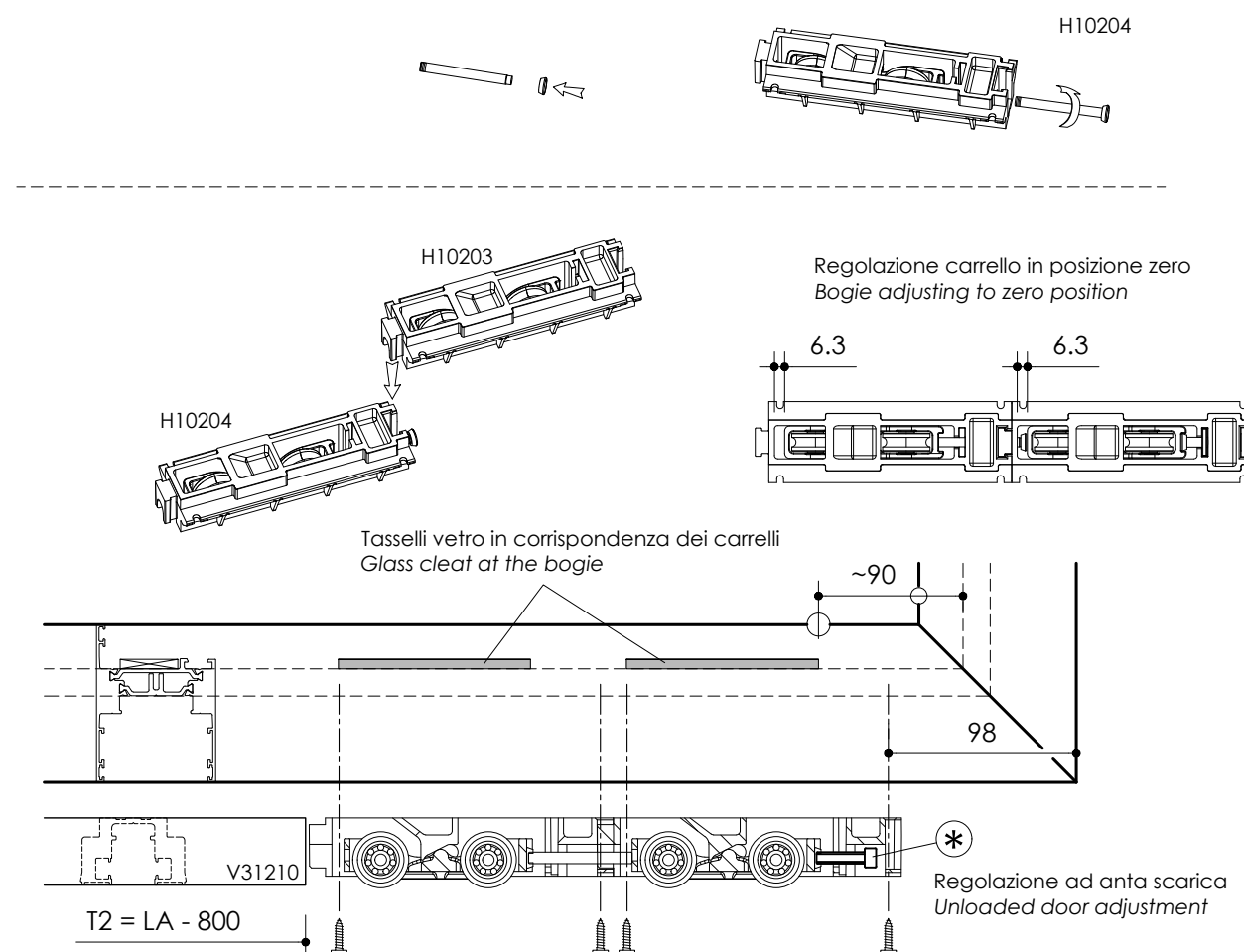
SEQUENZA DI MONTAGGIO COVER ANTA SASH COVER ASSEMBLING SEQUENCE

Predisporre gli spezzoni della cover art. V31210: 2 pezzi (A e B) per il traverso inferiore e 3 pezzi (C, D, E) per il montante lato serratura. Infilare gli spazzolini in cava e gli spezzoni A, B, C, D della cover V31210, prima dell'assemblaggio dell'anta. Assemblare l'anta serrando le viti delle squadrette. Portare in posizione corretta gli spezzoni A, B, C e D. Inserire l'ultimo spezzone E in corrispondenza dei fori maniglia, sistemando lo spazzolino.

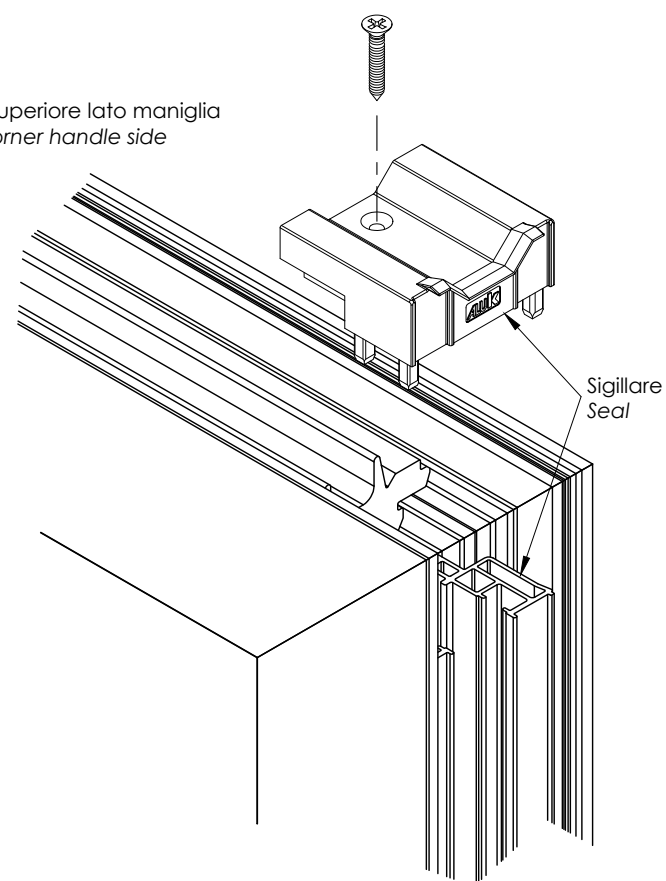
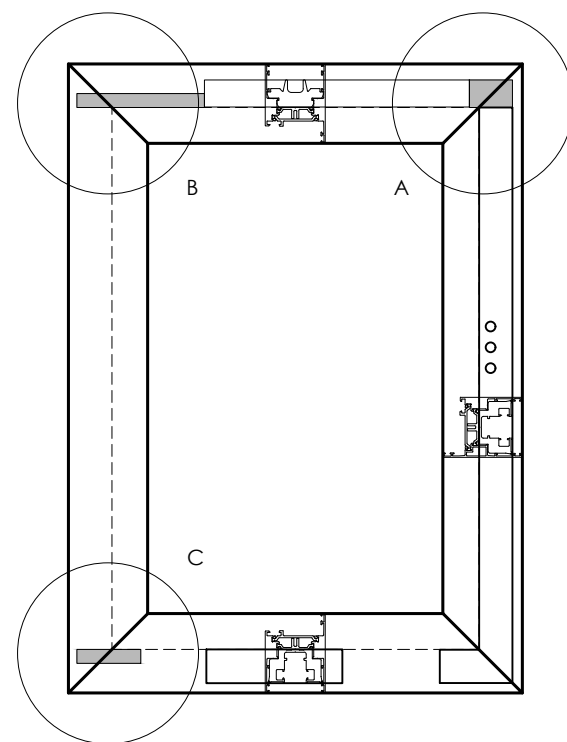
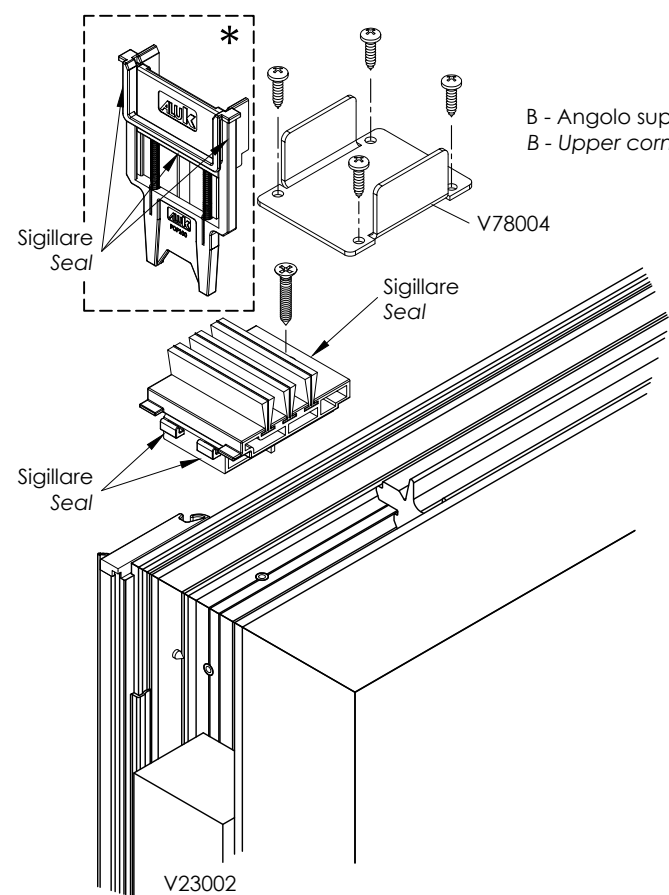
Prepare the pieces of the cover item V31210: 2 pieces (A and B) for the lower transom and 3 pieces (C, D, E) for the lock-side mullion. Insert the brushes into the groove and the pieces A, B, C, D of the cover V31210, before sash assembling. Assemble the sash by tightening the screws of the corner cleats. Position correctly the pieces A, B, C and D. Insert the last piece E aligning the handle holes, adjusting the brush.



SEQUENZA DI MONTAGGIO CARRELLI ADDIZIONALI ADDITIONAL ROLLERS ASSEMBLING

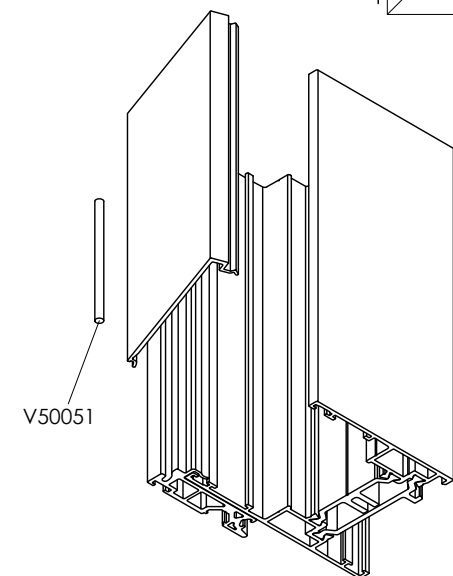
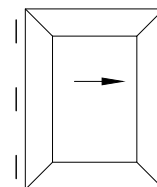


➤ **S140R** - ASSEMBLAGGIO TAPPI ANTA U10140
S140R - U10140 SASH PLUG ASSEMBLING

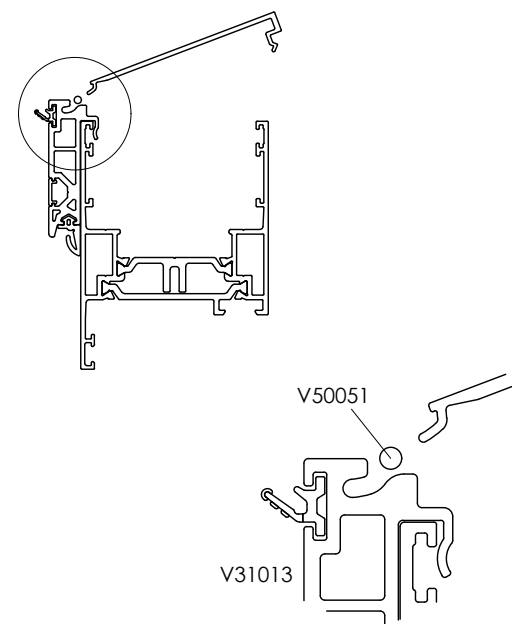
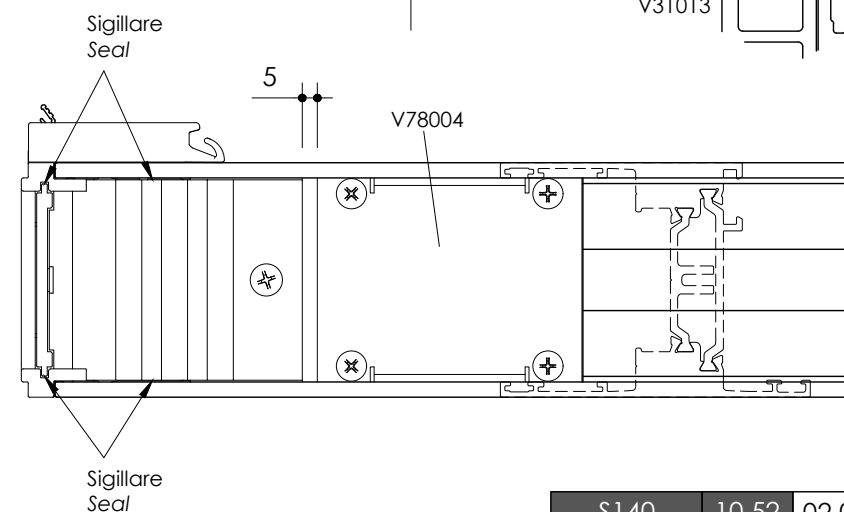
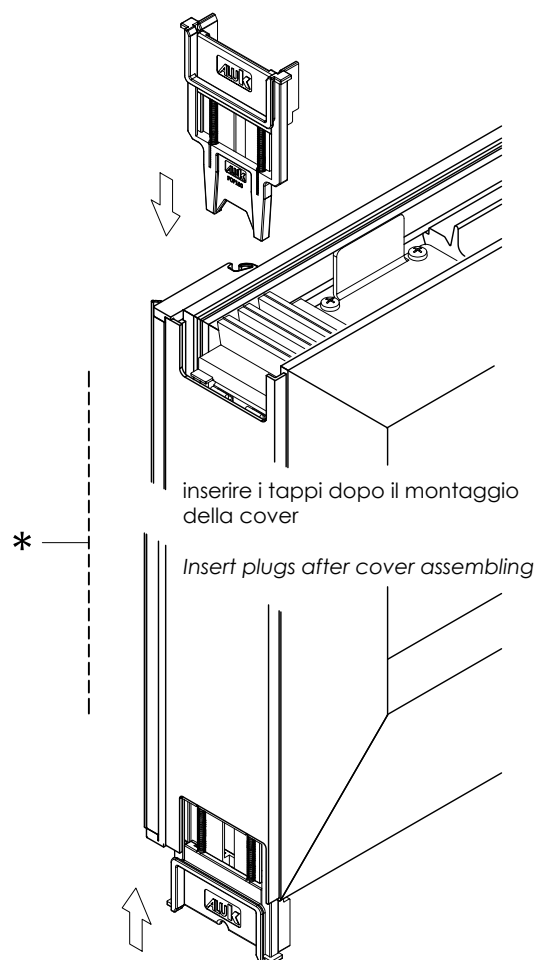
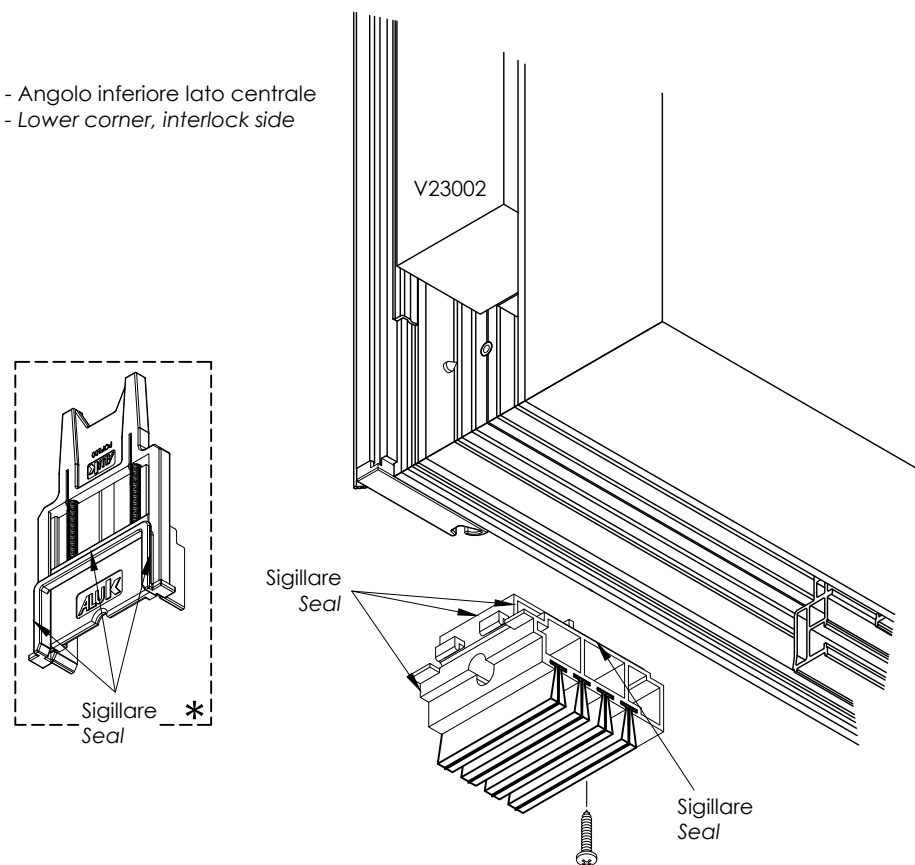


Montaggio e posizionamento V50051
 Assembly and positioning V50051

- Tre pezzi per anta
 il primo a 200 mm dall'angolo
 - Three pieces for sash
 the first 200 mm from the corner



C - Angolo inferiore lato centrale
 C - Lower corner, interlock side





B - Angolo superiore lato centrale
B - Upper corner, interlock side

Parte da asportare
Part to remove



~500mm

...

100mm



C - Angolo inferiore lato centrale
C - Lower corner, interlock side



Sigillare

Sigillare

Parte da asportare
Part to remove



inserire i tappi dopo il montaggio della cover

Insert plugs after cover assembling



A - Upper corner, handle side



Seal the joint with structural bi-component sealant, keep in position until the complete polymerization

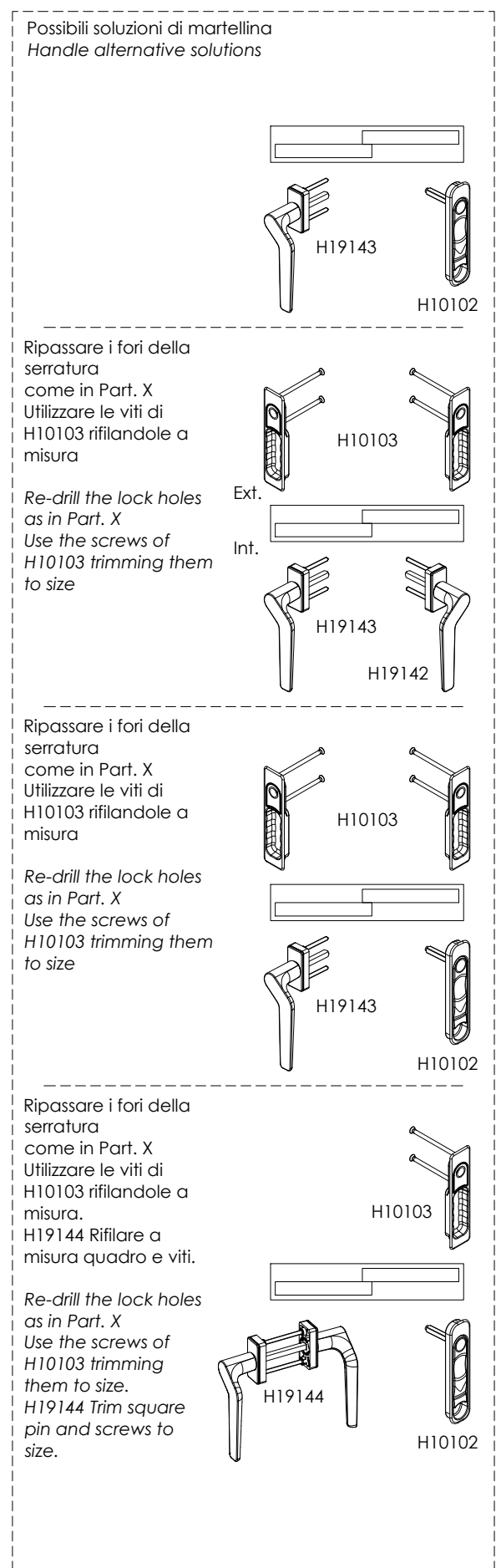
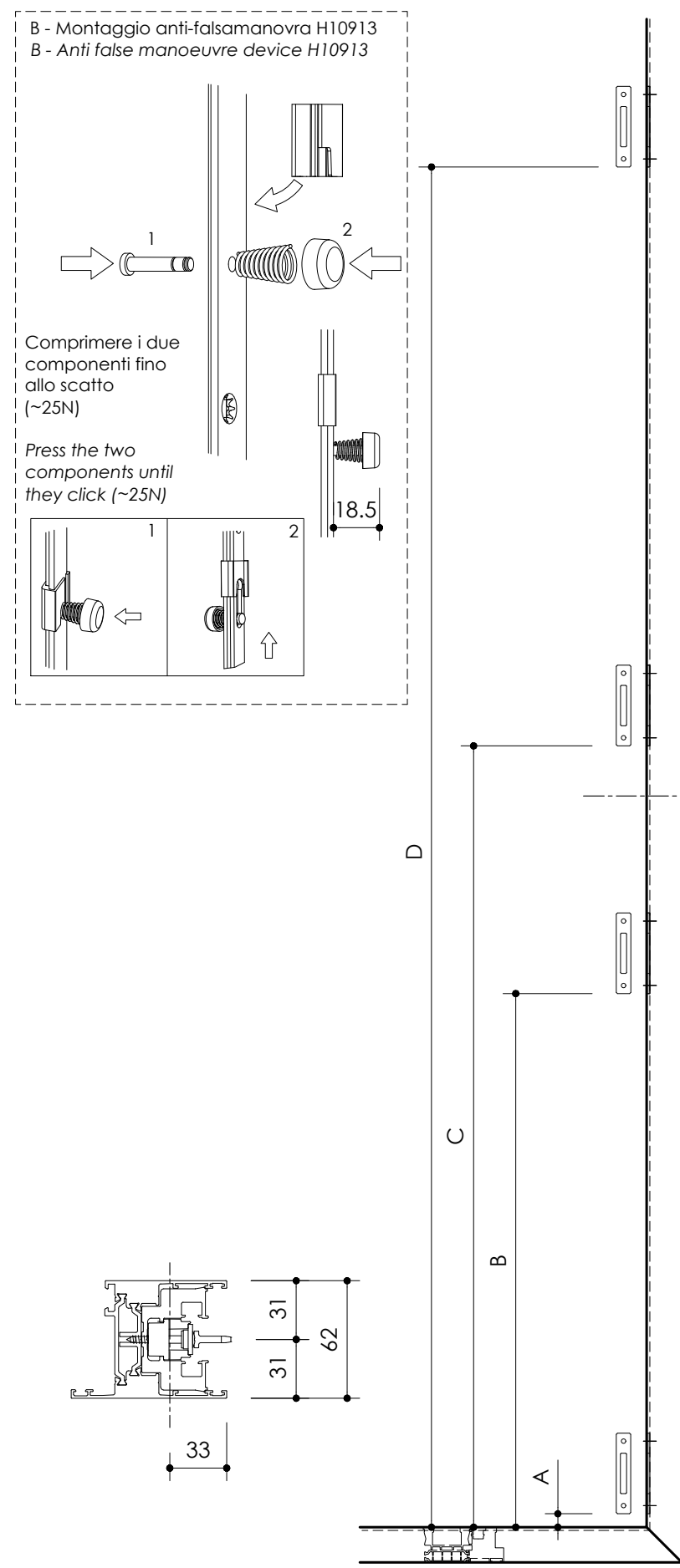
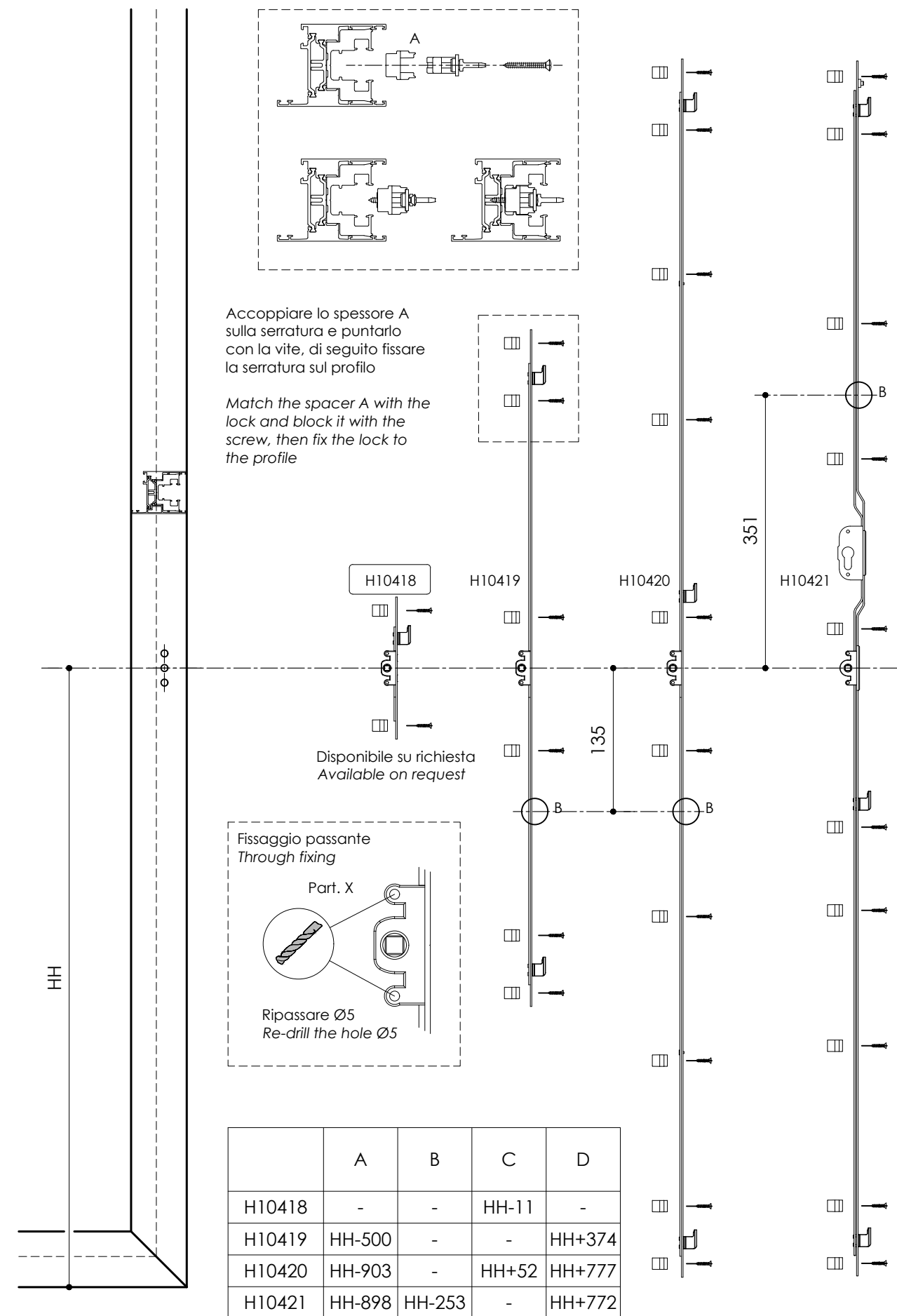


a contatto
| *in contact*

V78004

Sigillare
Seal

S140R - ASSEMBLAGGIO SERRATURA E INCONTRI
S140R - LOCK AND STRIKERS ASSEMBLING



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