

C45K-NI / C55K-NI

Finestre e porte non isolate – *Not insulated windows & doors*

- › 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.
Scan or click the QR code to download the latest version.*

VERSIONE VERSION	REVISIONE REVISION	DATA DATE	DESCRIZIONE DESCRIPTION	PAGINA PAGE
1	A	25.02.2025	Prima emissione <i>First issue</i>	Intero manuale <i>Complete manual</i>
1	B	05.05.2025	Corretto il numero dei kit di fissaggio <i>Number of fastening kits corrected</i>	9.17
		06.05.2025	Variata l'indicazione di foratura del profilo N32200 <i>Drilling indication for profile N32200 is changed</i>	9.05
2	A	10.04.2026	Nuove tipologie: Finestre doppio sormonto (apertura interna ed esterna) e porte C45K <i>New solutions: Double-overlap windows (inward and outward opening) and C45K doors</i>	Intero manuale <i>Complete manual</i>
		16.04.2026	Aggiornate le indicazioni di fissaggio telai in conformità alla norma UNI 11673-1 <i>Updated instructions for fixing frames in accordance with the standard</i>	Intero manuale <i>Complete manual</i>
		05.05.2026	Variata vite di fissaggio per squadretta V43039 <i>Changed fixing screw of V43039</i>	Rep.10

INDICE

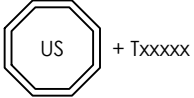
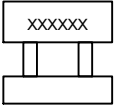


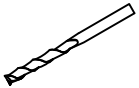

DESCRIZIONE DESCRIPTION	REPERTORIO SECTION
Lavorazioni <i>Machinings</i>	9.00
Assemblaggio <i>Assembling</i>	10.00

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Section 09

Lavorazioni
Machinings

Legenda Attrezzature	
Tools caption	
	Unità di spinta + codice cassetto Pump unit + Punching tool code
	Punzonatrice tradizionale Conventional punching tool
	Kit forcelle Forks kit
	Gruppo fresa Milling accessory
	Fresa a candela Milling cutter
	Forare a mano Drill manually

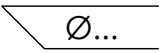
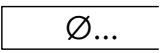


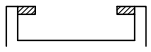

Legenda lavorazioni	
Machinings caption	
	Foro squadretta Corner joint hole
	Foro cavallotto T-joint hole
	Foro colla Glue hole
	Drenaggio Drainage
	Spacco alette End cutting
	Lavorazione cremonese Cremonese machinings

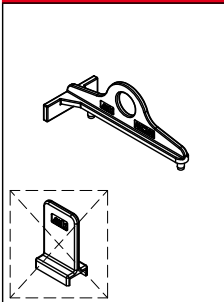
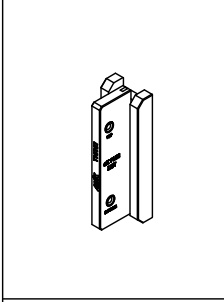
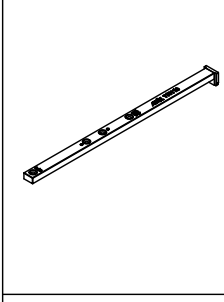
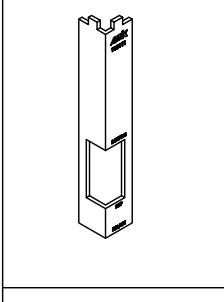
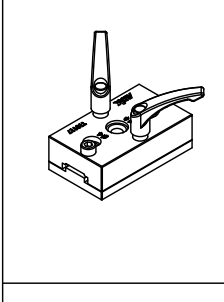
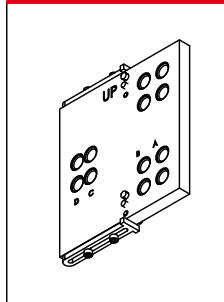
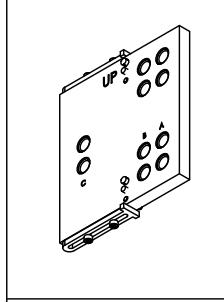
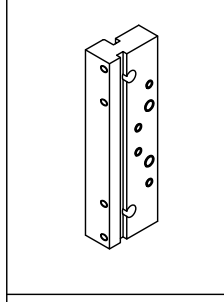
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	C45K-NI	C55K-NI
	T10017	Dima di posizionamento braccio cerniera C180 <i>Template arm position for hinge C180</i>	●	●
		U.V. 1		
	T10101	Dima di foratura cerniere A/R <i>Drilling jig for T&T hinge</i>	●	●
		U.V. 1		
	T10110	Dima di foratura bracci <i>Arm drilling jig</i>	●	●
		U.V. 1		
	T10111	Dima di montaggio incontri A/R <i>T&T striker positioning jig</i>	●	●
		U.V. 1		
	T10117	Dima di foratura asta <i>Rod drilling jig</i>	●	●
		U.V. 1		

IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	C45K-NI	C55K-NI
	T10094	Dima di foratura cerniere per interassi: 62,5 - 78 - 84 - 99,5 <i>Hinge drilling jig</i>		●
		U.V. 1		
	T10095	Dima di foratura cerniere per interassi 70,5 - 92 <i>Hinge drilling jig</i>		●
		U.V. 1		
	T10124	Dima di foratura cerniere V59314 <i>V59314 Hinge drilling jig</i>		●
		U.V. 1		

GRUPPI FRESA
MILLING ACCESSORY

 Disponibile su richiesta
Available on request









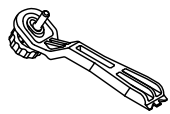
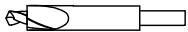
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	C45K-NI	C55K-NI
	T40010	Fresa a candela Ø8 Ø8 Milling cutter U.V. 1	●	●
	T40054	Gruppo fresa - connessione traverso stipite Milling accessory - Fixed frame/Transom connection U.V. 1	●	
	T40055	Gruppo fresa - connessione traverso/battente Milling accessory - Sash/Transom connection U.V. 1	●	
	T40056	Gruppo fresa - connessione traverso/battente Milling accessory - Sash/Transom connection U.V. 1	●	
	T40057	Gruppo fresa - connessione traverso/stipite Milling accessory - Fixed frame/Transom connection U.V. 1		●
	T40058	Gruppo fresa - connessione traverso/battente Milling accessory - Sash/Transom connection U.V. 1		●

IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	C45K-NI	C55K-NI
	T40064	Gruppo fresa - connessione traverso/battente Milling accessory - Sash/Transom connection U.V. 1	●	

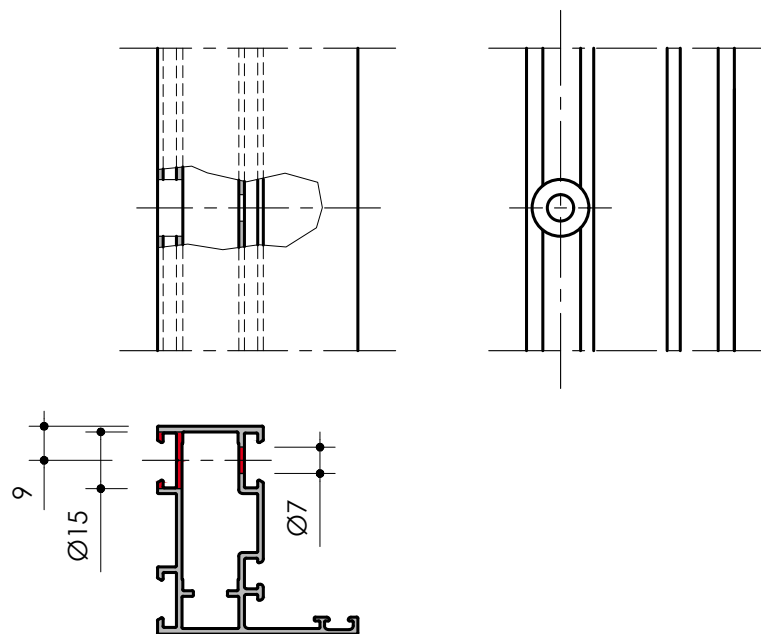
VARIE
OTHER

IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	C45K-NI	C55K-NI
	T50014	Chiave di regolazione <i>Door hinge adjusting key</i>		●
		U.V. 1		
	T50015	Estrattore perno cerniera per porte 3 ali <i>Three wings door hinge pin extractor</i>		●
		U.V. 1		
	900031	Punta speciale a due diametri (Ø10.3 / Ø15) <i>Special two-diameter drill (Ø10.3 / Ø15)</i>		●
		U.V. 1		

SCHEMA DI FISSAGGIO TELAI CON REGOLATORI
FRAMES FASTENING DIAGRAM

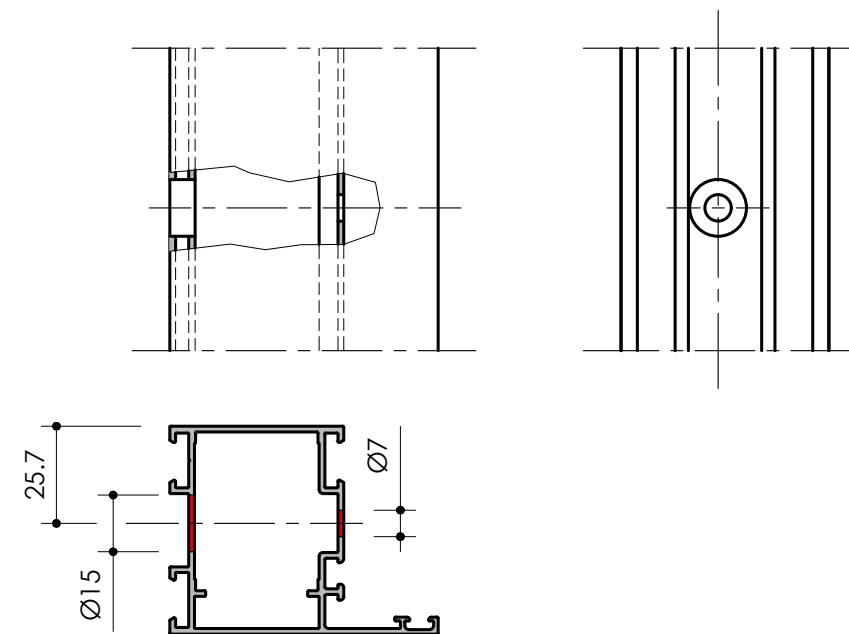
C45K-NI	C55K-NI
●	●

V50003	
C45K	C55K
N31000	N32000
N31001	N32020
N31020	
N31040	
N31002	
N31023	



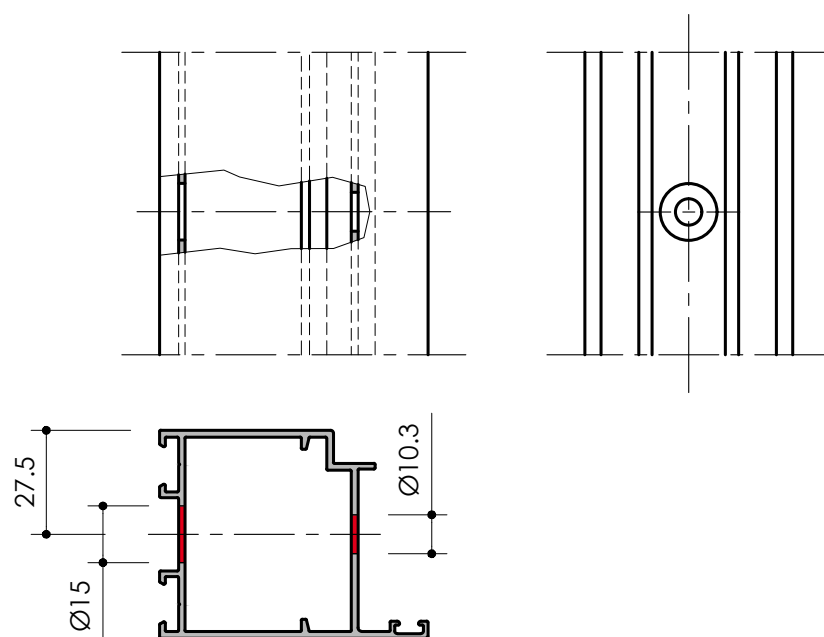
PER LA FORATURA DEL PROFILO UTILIZZARE PUNTA SPECIALE (PUNTA A DUE DIAMETRI Ø7 - Ø15) - NON FORNITA DA ALUK
 FOR PROFILE DRILLING USE SPECIAL DRILLS (WITH DOUBLE DIAMETER Ø7 - Ø15) - NOT SUPPLIED BY ALUK

V50006
C55K
N32001

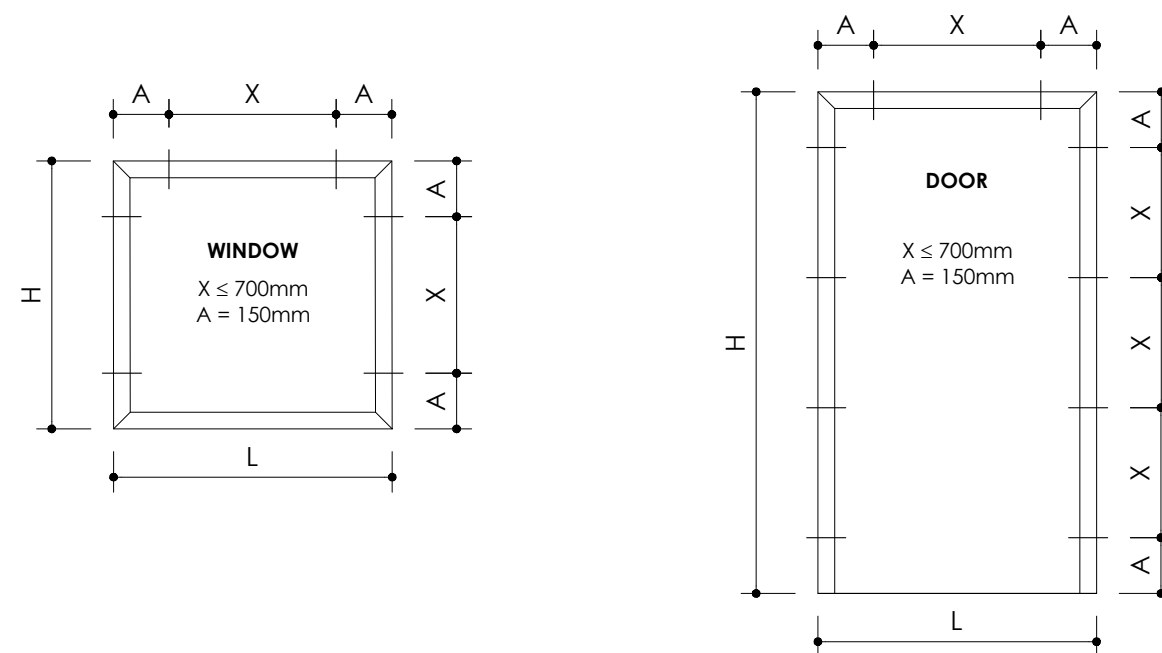


PER LA FORATURA DEL PROFILO UTILIZZARE PUNTA SPECIALE (PUNTA A DUE DIAMETRI Ø7 - Ø15) - NON FORNITA DA ALUK
 FOR PROFILE DRILLING USE SPECIAL DRILLS (WITH DOUBLE DIAMETER Ø7 - Ø15) - NOT SUPPLIED BY ALUK

V50003
C55K
N32200



PER LA FORATURA DEL PROFILO UTILIZZARE PUNTA SPECIALE art. 900031 (A DUE DIAMETRI Ø10.3 - Ø15) O PUNTA DA Ø10.5 mm
 FOR PROFILE DRILLING USE SPECIAL DRILLS art. 900031 (WITH DOUBLE DIAMETER Ø10.3 - Ø15) OR DRILL Ø10.5 mm



PORTE/DOORS
 INTENSIFICARE I FISSAGGI IN CONCOMITANZA DELLE CERNIERE (VEDI PAGINA DEDICATA)
 INCREASE THE FASTENERS NEAR THE HINGES (SEE RELATED DIAGRAMS)

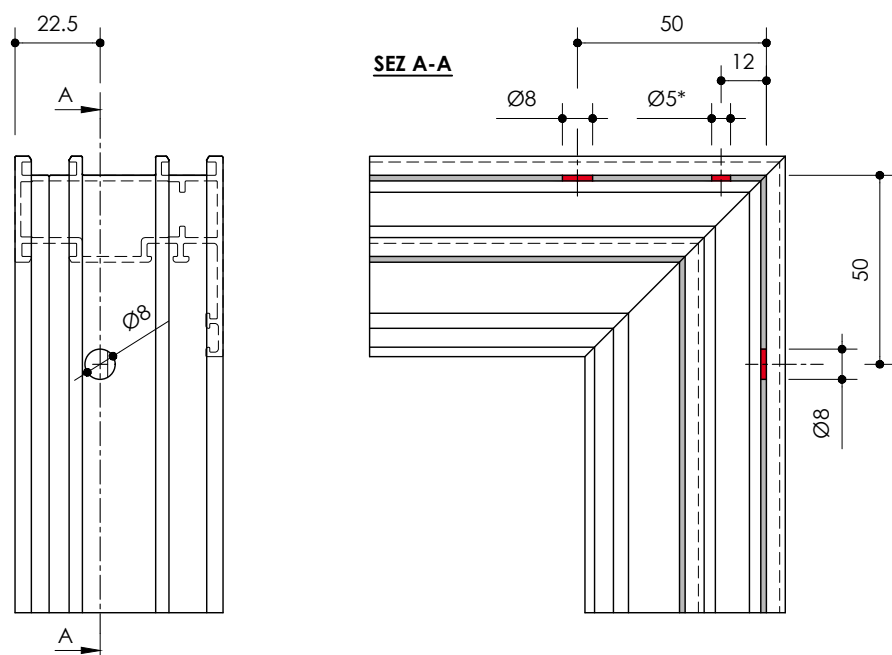
LAVORAZIONE SQUADRETTA A SPINARE/VITE
MACHINING FOR CORNER JOINT TO BE RIVETED/SCREWED

C45K-NI	C55K-NI
●	●

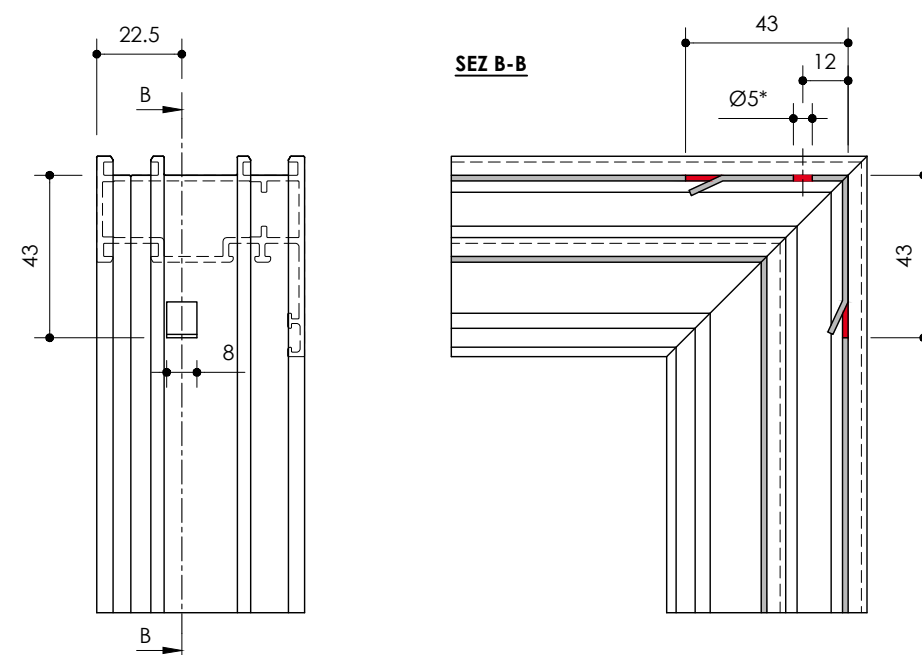
LAVORAZIONE SQUADRETTA A CIANFRINARE
MACHINING FOR CORNER JOINT TO BE CALKED

C45K-NI	C55K-NI
●	●

NOTA: LE QUOTE DI CIANFRINATURA SONO INDICATIVE
 CALKING DIMENSIONS COULD CHANGE ACCORDING TO SECTION TOLLERANCES



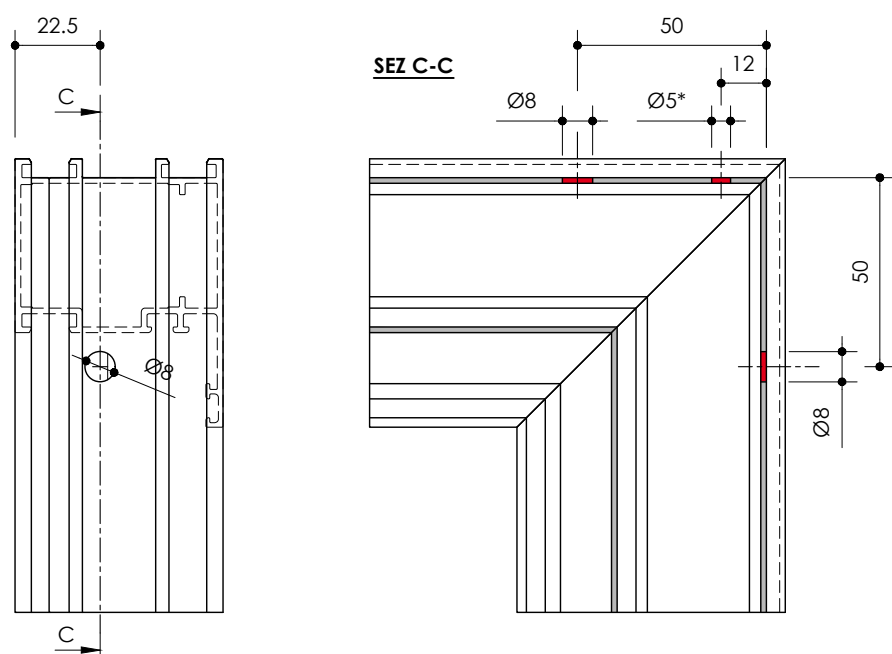
SQUADRETTA CORNER JOINT	PROFILI	
	C45K	C55K
V43038	N31000	N32000
	N31001	N32020
	N31020	
	N31040	



(*) FORO COLLA
GLUE HOLE

(*) FORO COLLA
GLUE HOLE

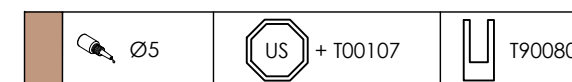
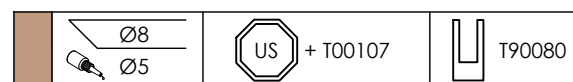
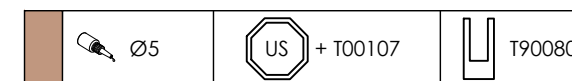
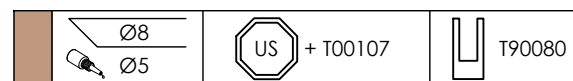
NOTA: LE QUOTE DI CIANFRINATURA SONO INDICATIVE
 CALKING DIMENSIONS COULD CHANGE ACCORDING TO SECTION TOLLERANCES



SQUADRETTA CORNER JOINT	PROFILI	
	C45K	C55K
V43039	N31002	N32001
	N31023	

(*) FORO COLLA
GLUE HOLE

(*) FORO COLLA
GLUE HOLE



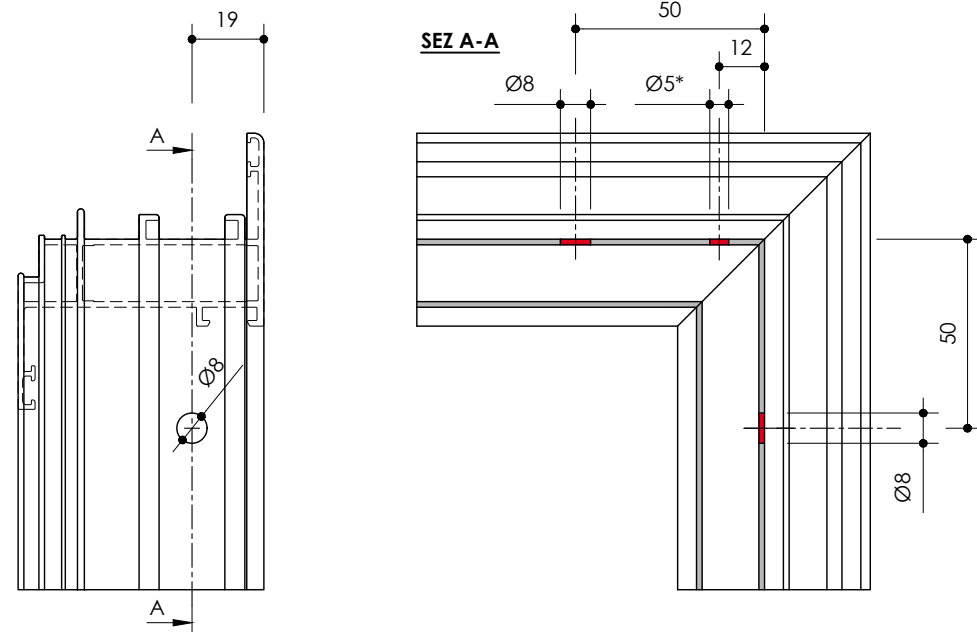
LAVORAZIONE SQUADRETTE A SPINARE/VITE
MACHINING FOR CORNER JOINT TO BE RIVETED/SCREWED

C45K-NI	C55K-NI
●	●

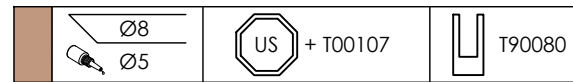
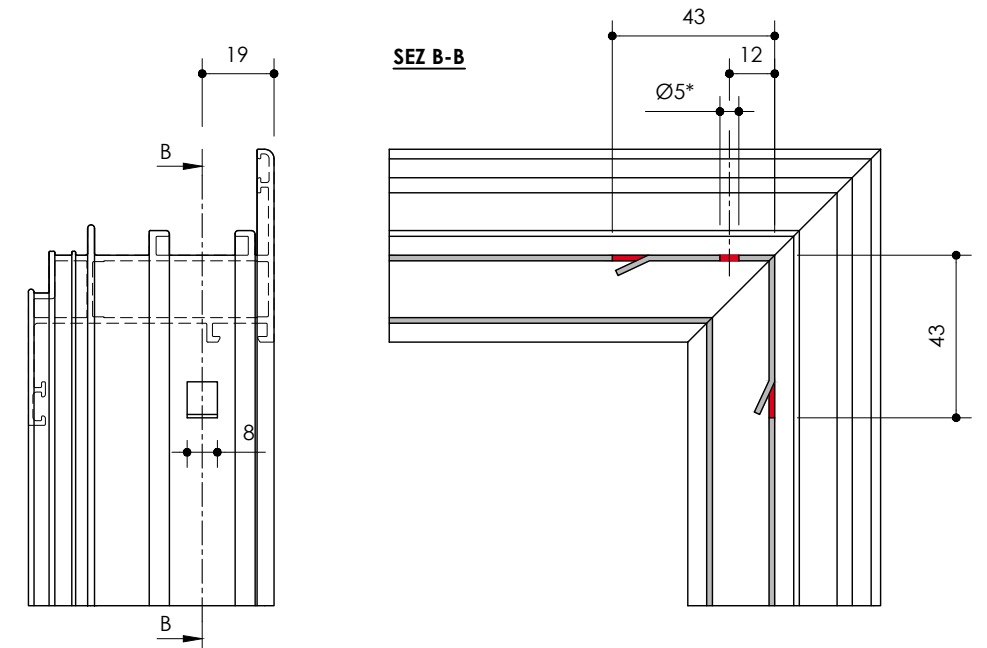
LAVORAZIONE SQUADRETTE A CIANFRINARE
MACHINING FOR CORNER JOINT TO BE CALKED

C45K-NI	C55K-NI
●	●

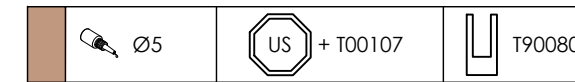
NOTA: LE QUOTE DI CIANFRINATURA SONO INDICATIVE
 CALKING DIMENSIONS COULD CHANGE ACCORDING TO SECTION TOLLERANCES



SQUADRETTA CORNER JOINT	PROFILI	
	C45K	C55K
V43040	N31120	N32120
	N31123	

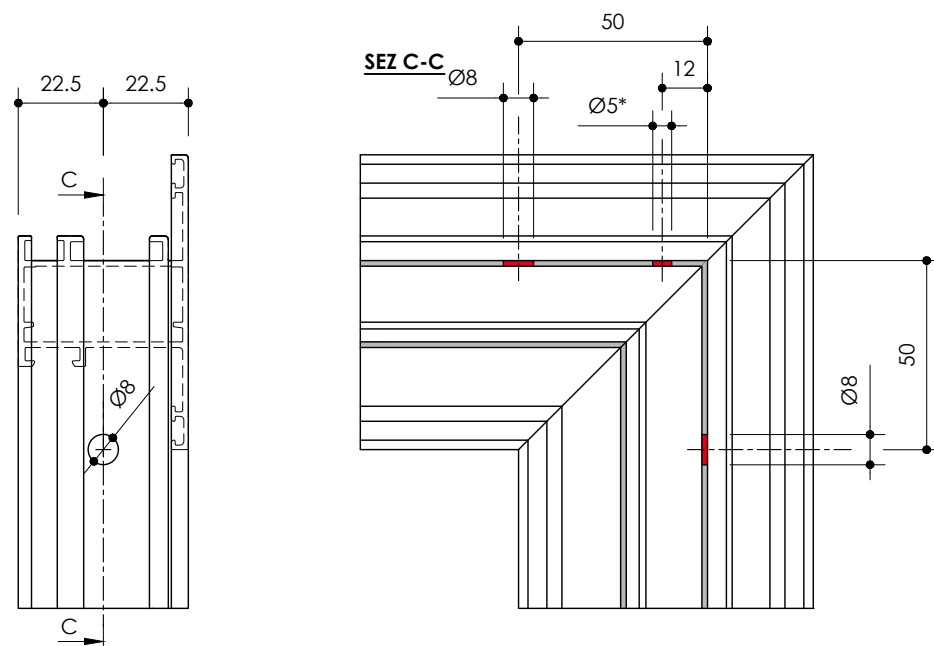


(*) FORO COLLA
GLUE HOLE

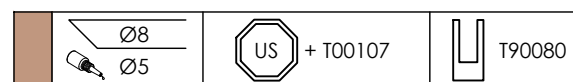
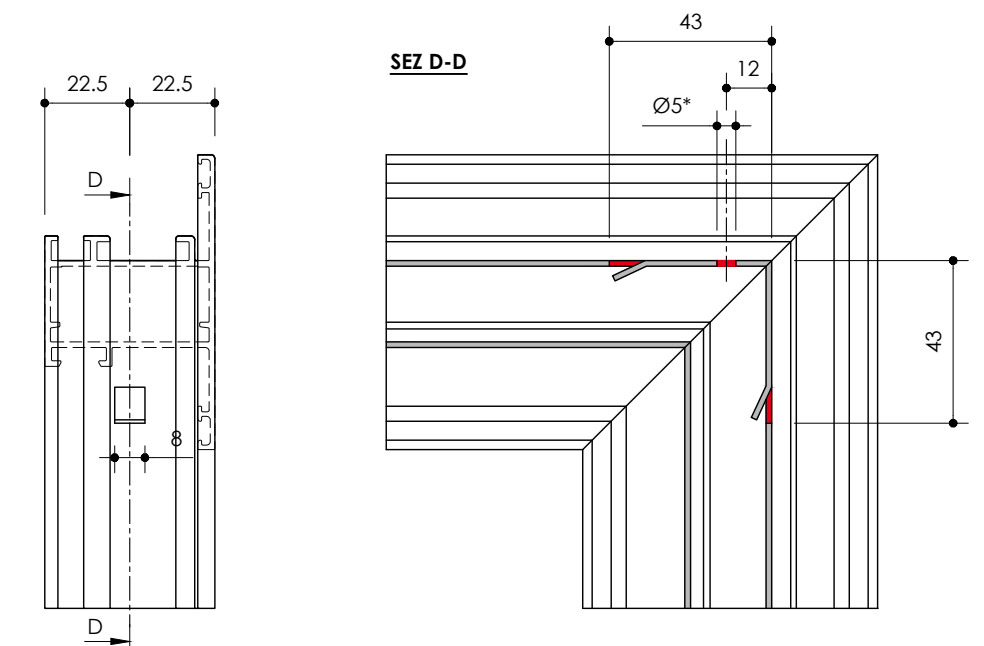


(*) FORO COLLA
GLUE HOLE

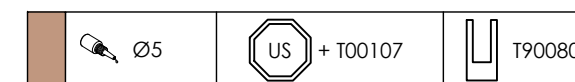
NOTA: LE QUOTE DI CIANFRINATURA SONO INDICATIVE
 CALKING DIMENSIONS COULD CHANGE ACCORDING TO SECTION TOLLERANCES



SQUADRETTA CORNER JOINT	PROFILI	
	C45K	C55K
V43038	N31140	
	N31141	
	N31121	
	N31122	



(*) FORO COLLA
GLUE HOLE

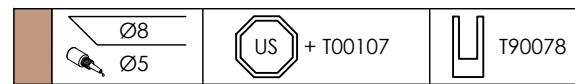
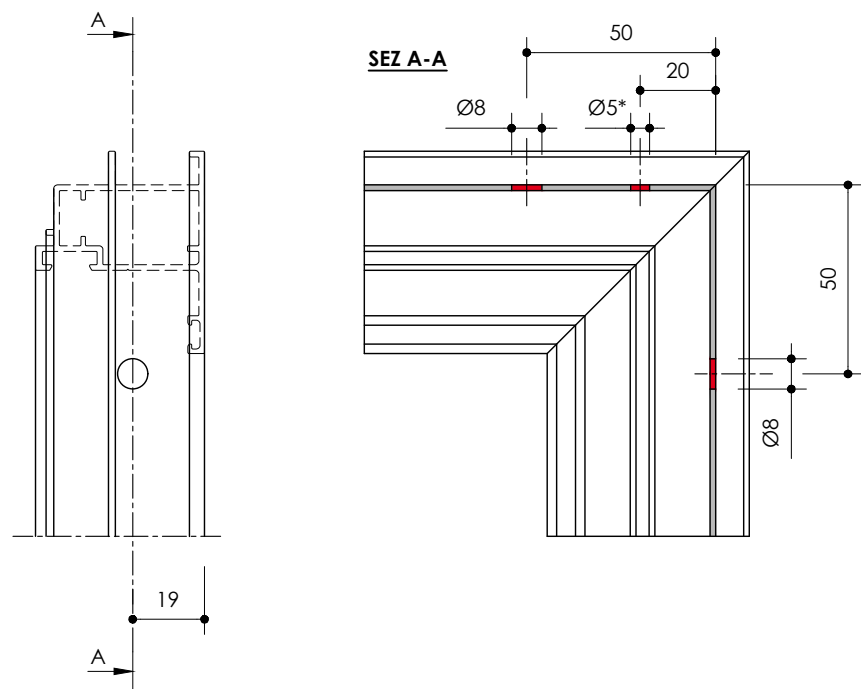


(*) FORO COLLA
GLUE HOLE

LAVORAZIONE SQUADRETTE PER PROFILO DI INVERSIONE
MACHINING OF CORNER JOINT FOR REVERSAL PROFILE

C45K-NI	C55K-NI
●	

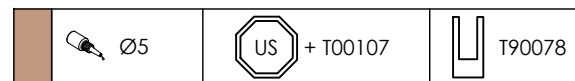
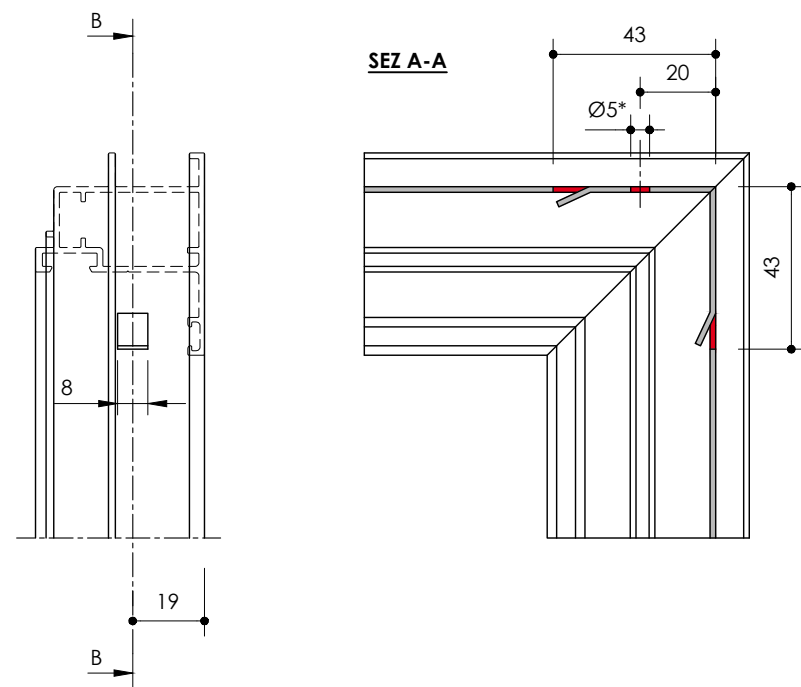
A SPINARE / A VITE
TO BE RIVETED / SCREWED



(*) FORO COLLA
GLUE HOLE

SQUADRETTA CORNER JOINT	PROFILI C45K
710408	N31630

A CIANFRINARE
TO BE CALKED



(*) FORO COLLA
GLUE HOLE

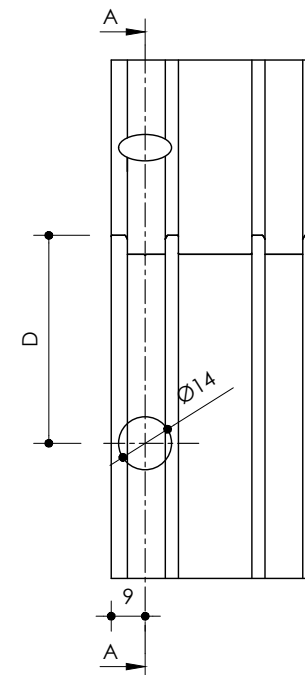
NOTA: LE QUOTE DI CIANFRINATURA SONO INDICATIVE
 CALKING DIMENSIONS COULD CHANGE ACCORDING
 TO SECTION TOLLERANCES

LAVORAZIONE SQUADRETTE AD ANGOLO VARIABILE
MACHINING OF VARIABLE ANGLE CORNER JOINT

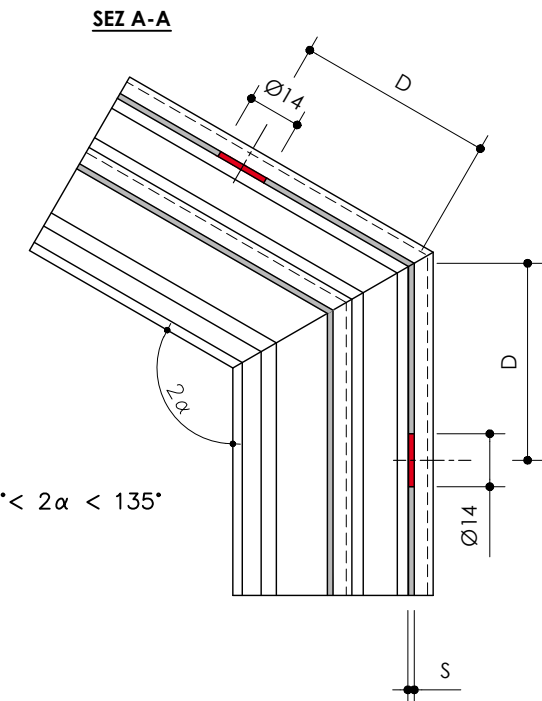
C45K-NI	C55K-NI
●	●

$$D = 31 + (7.1+S) / \tan \alpha$$

SQUADRETTA CORNER JOINT	PROFILI		
	C45K	C55K	
V42067	N31000	N31020	N32000
	N31001	N31040	N32020



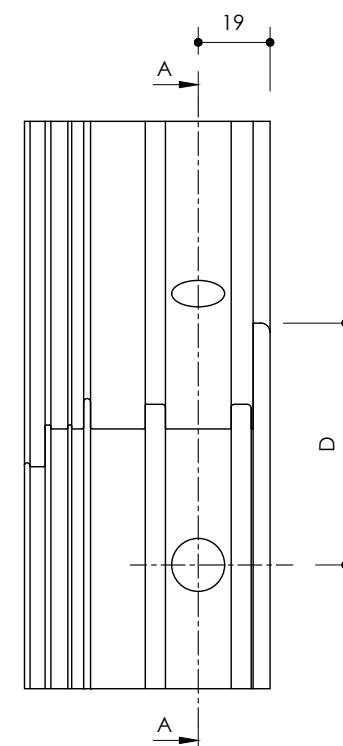
$$45^\circ < 2\alpha < 135^\circ$$



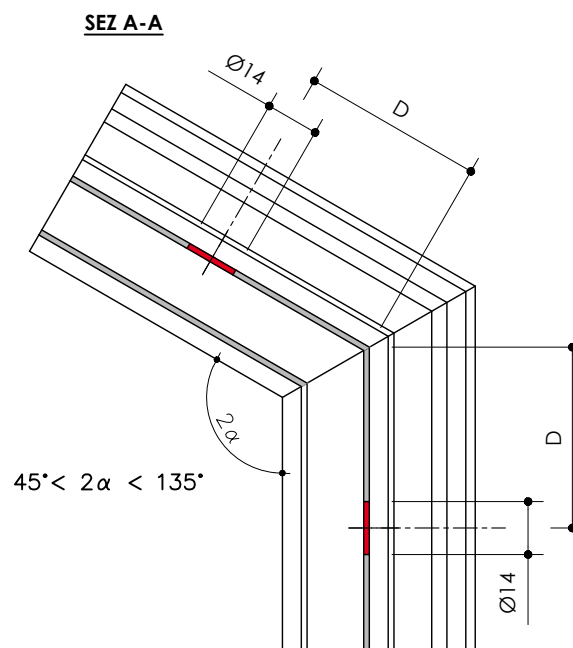
PRESTARE ATTENZIONE AGLI ANGOLI ACUTI: "D" DOVRA' ESSERE AUMENTATA FINO A 3 mm
 SI CONSIGLIA DI ASSEMBLARE UN ANGOLO DI PROVA
 BE CAREFUL WITH ACUTE ANGLES: "D" SHALL BE INCREASED UP TO 3 mm;
 IT IS RECOMMENDED TO ASSEMBLE A SPECIMEN CORNER

SQUADRETTA CORNER JOINT	PROFILI		
	C45K	C55K	
710123	N31120	N31123	N32120

$$D = 31 + 8.8 / \tan \alpha$$

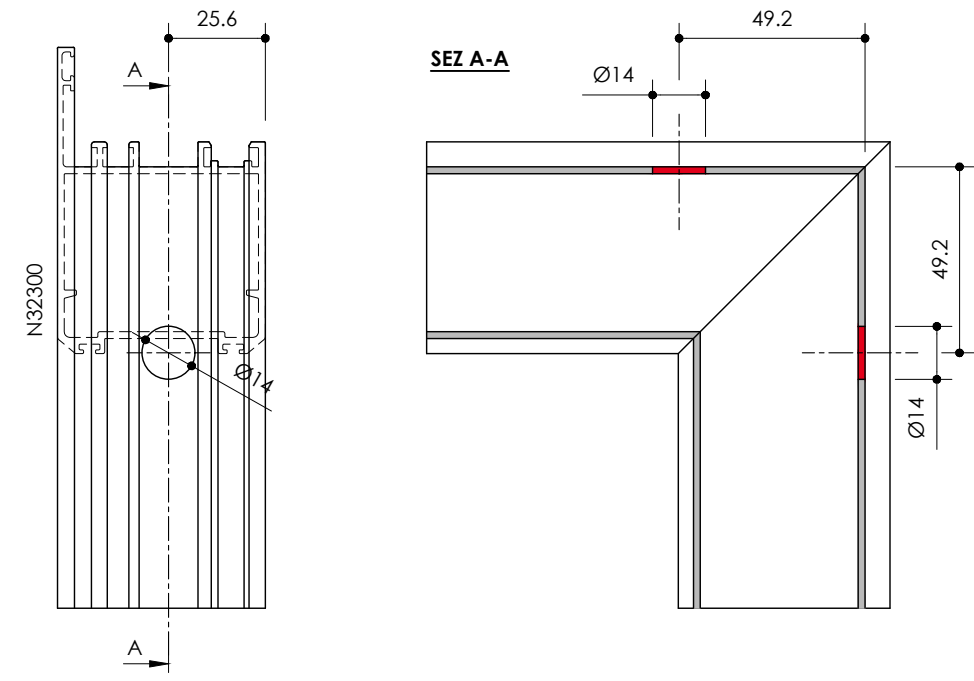
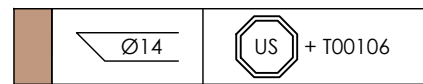
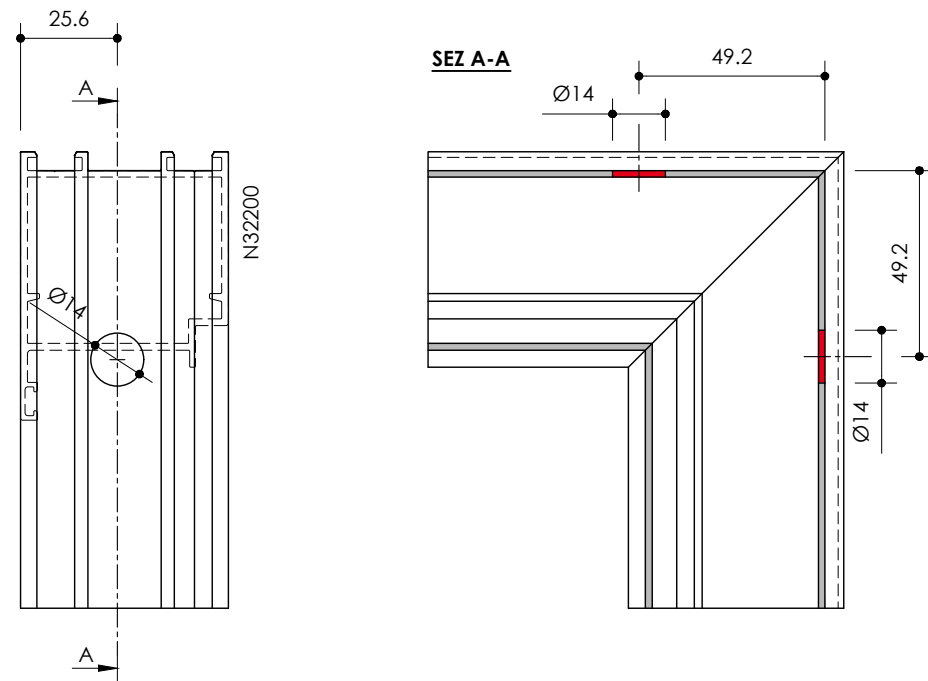


$$45^\circ < 2\alpha < 135^\circ$$

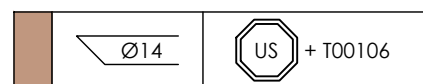
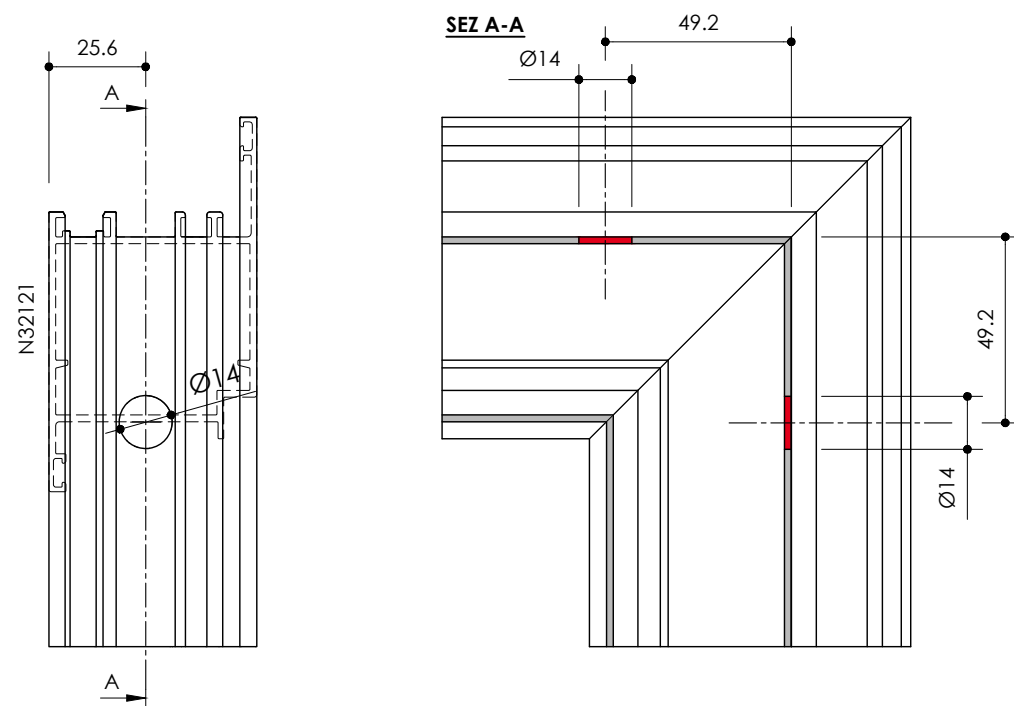


LAVORAZIONE SQUADRETTE PER STIPITI PORTE
MACHINING CORNER JOINT FOR DOORS FIXED FRAMES

C45K-NI	C55K-NI
	●

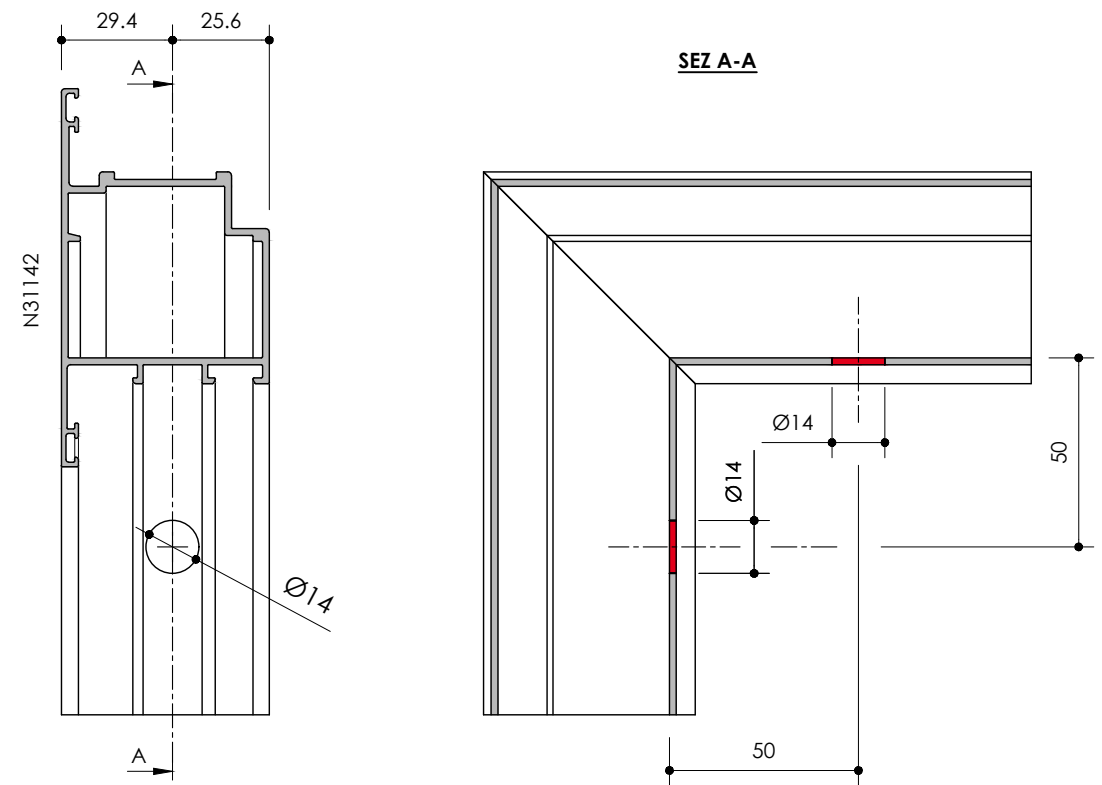
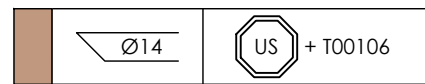
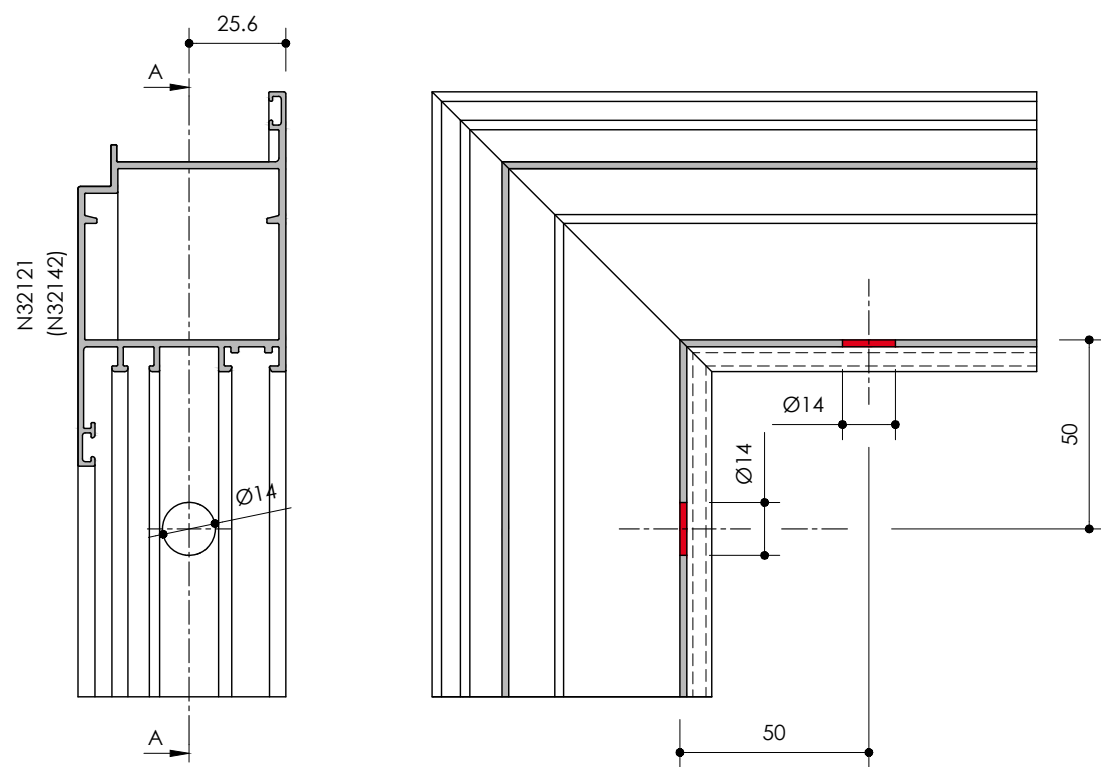


SQUADRETTA
 CORNER JOINT
V42065

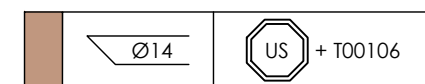
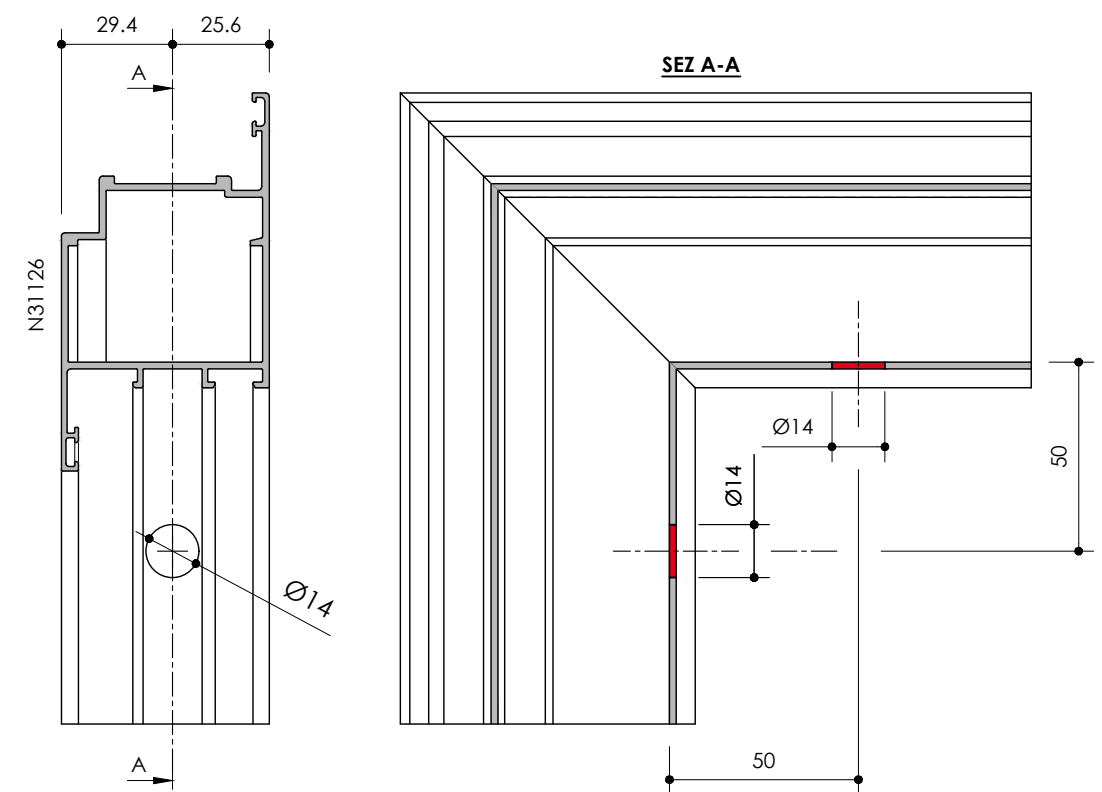
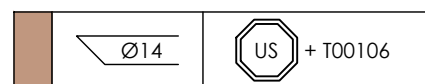
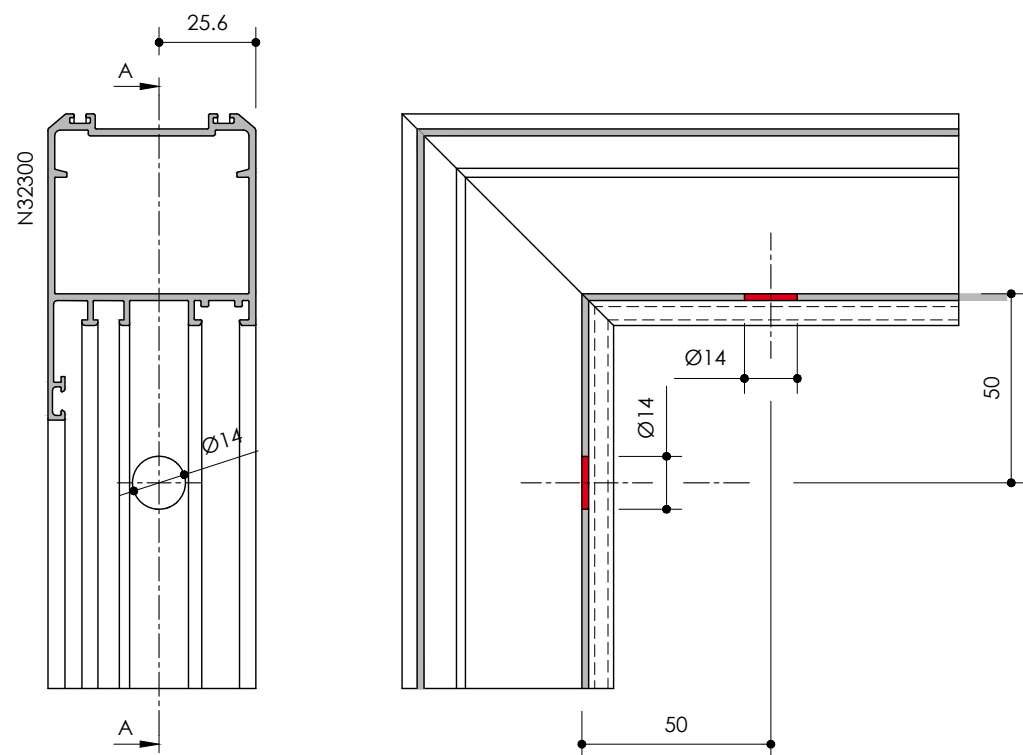


LAVORAZIONE SQUADRETTE PER ANTA PORTE
MACHINING CORNER JOINT FOR DOORS WINGS

C45K-NI	C55K-NI
●	●



SQUADRETTA
 CORNER JOINT
V42065

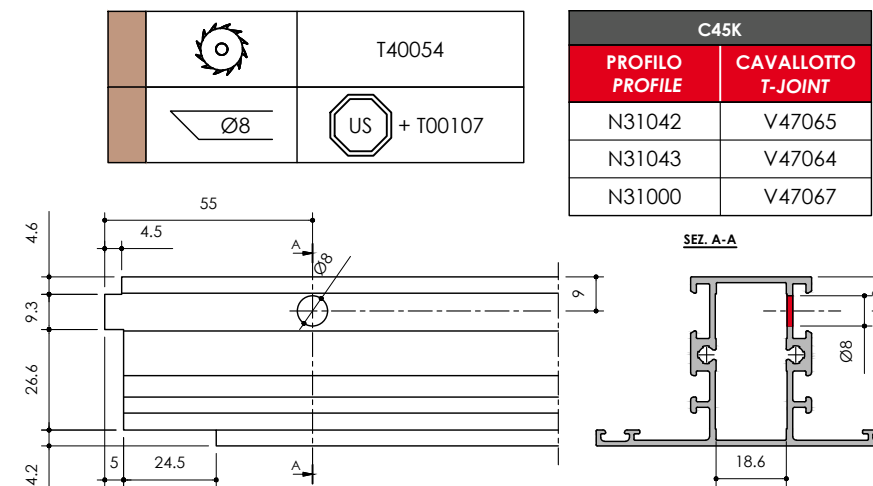
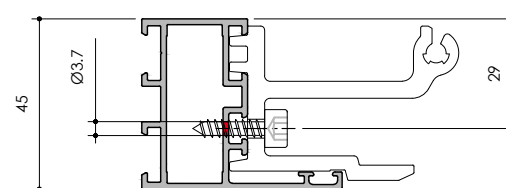
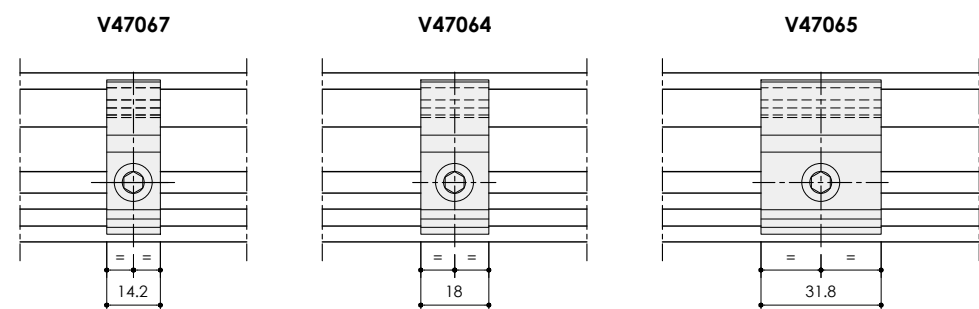


LAVORAZIONE PER CONNESSIONE TRAVERSI, CON CAVALLOTTI
MACHINING FOR TRANSOM CONNECTION, WITH T-JOINTS

C45K-NI	C55K-NI
●	

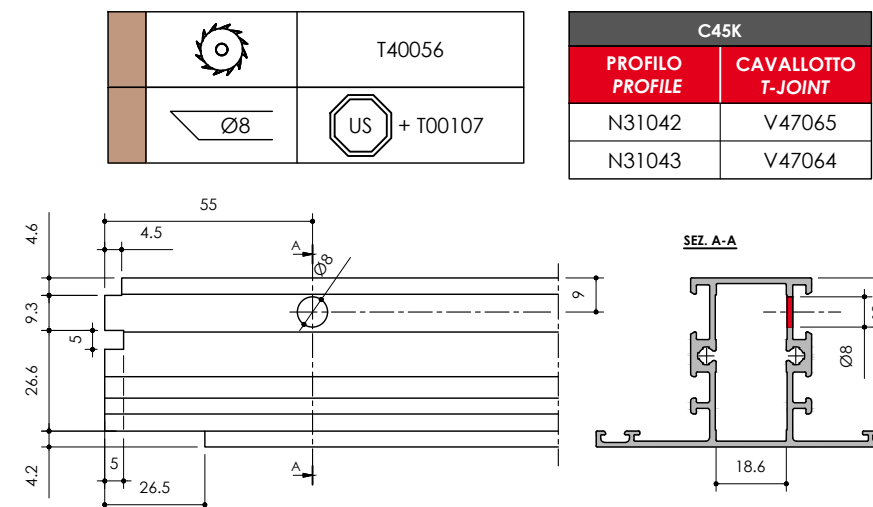
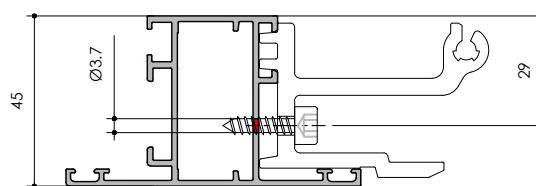
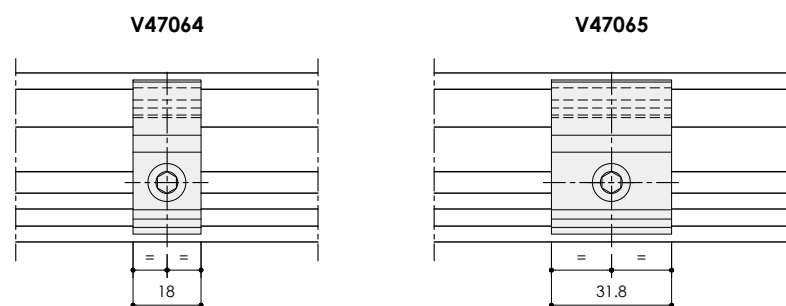
APPLICABILE AI PROFILI
APPLICABLE TO PROFILES

C45K	
N31000	N31001
N31002	N31020
N31023	N31040



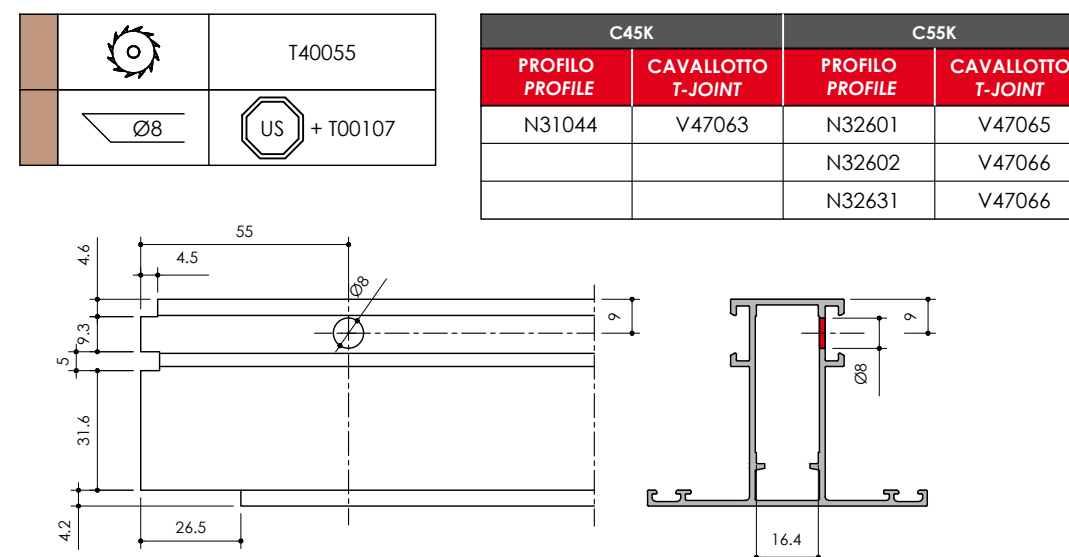
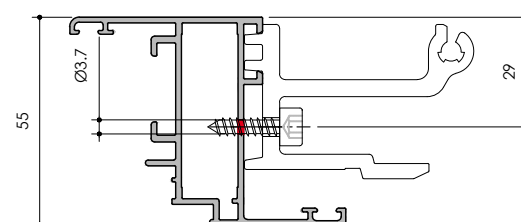
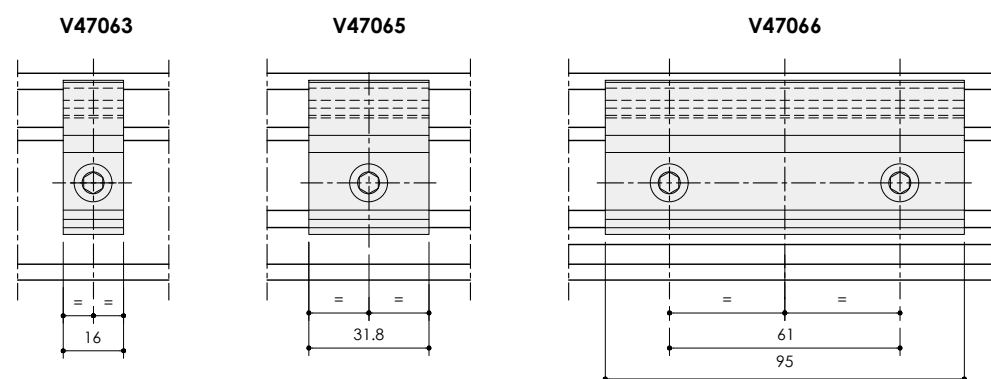
APPLICABILE AI PROFILI
APPLICABLE TO PROFILES

C45K	
N31140	N31141
N31123	



APPLICABILE AI PROFILI
APPLICABLE TO PROFILES

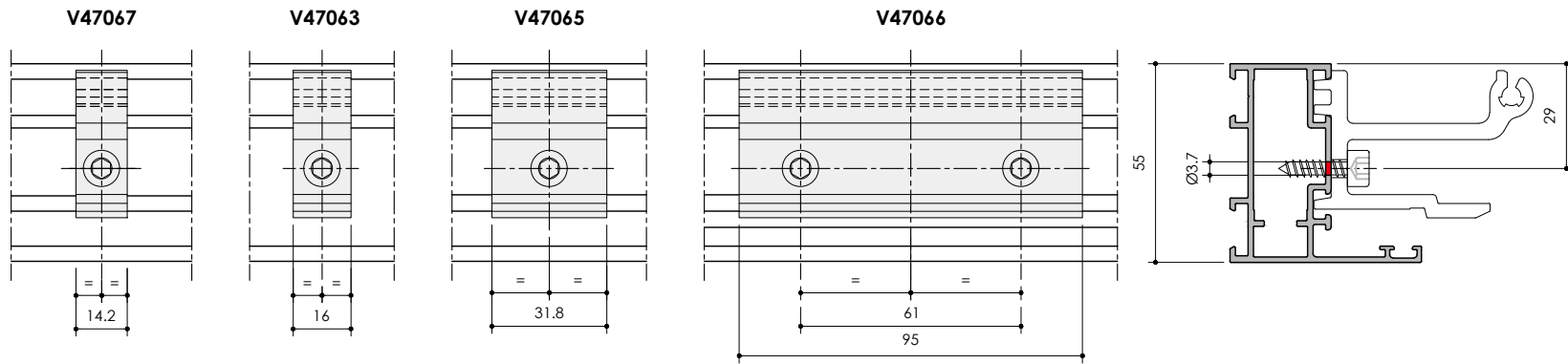
C45K	
N31120	



LAVORAZIONE PER CONNESSIONE TRAVERSI, CON CAVALLOTTI
MACHINING FOR TRANSOM CONNECTION, WITH T-JOINTS

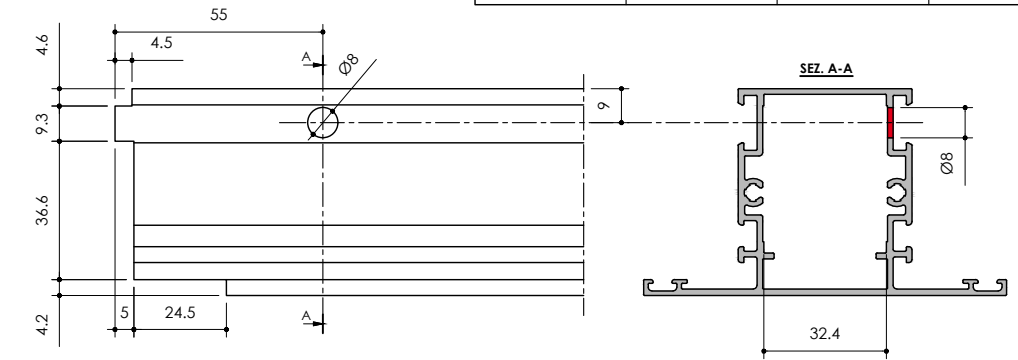
C45K-NI	C55K-NI
●	●

APPLICABILE AI PROFILI APPLICABLE TO PROFILES	
C55K	
N32000	N32001
N32020	

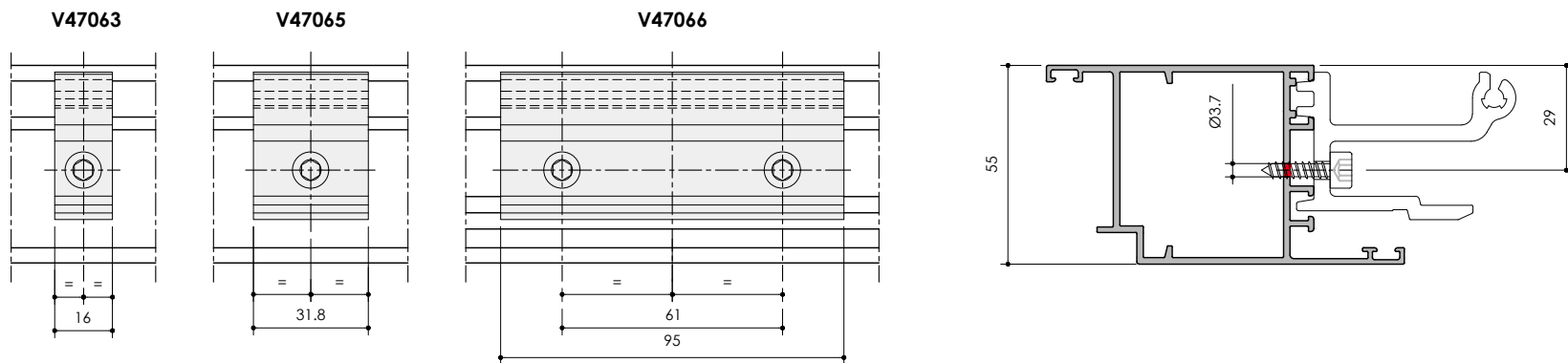


	T40057
Ø8	+ T00107

C45K		C55K	
PROFILO PROFILE	CAVALLOTTO T-JOINT	PROFILO PROFILE	CAVALLOTTO T-JOINT
N31044	V47063	N32601	V47065
N31000	V47067	N32602	V47066
		N32631	V47066

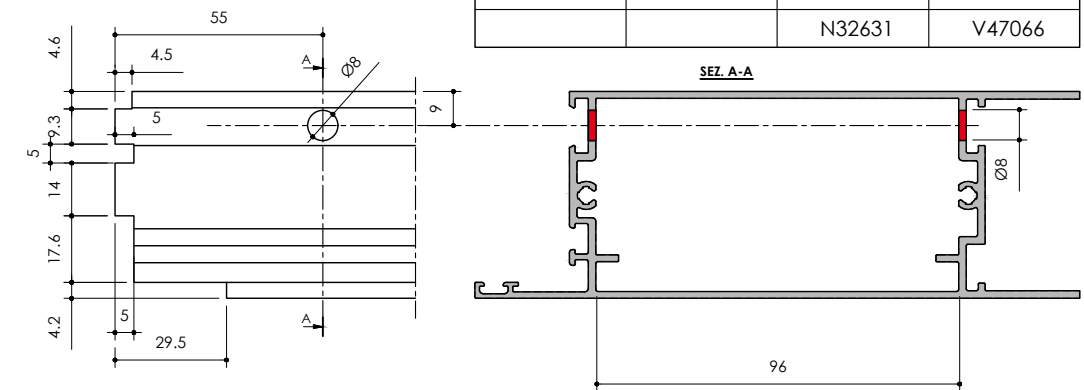


APPLICABILE AI PROFILI APPLICABLE TO PROFILES	
C55K	
N32121	N32142
N32300	

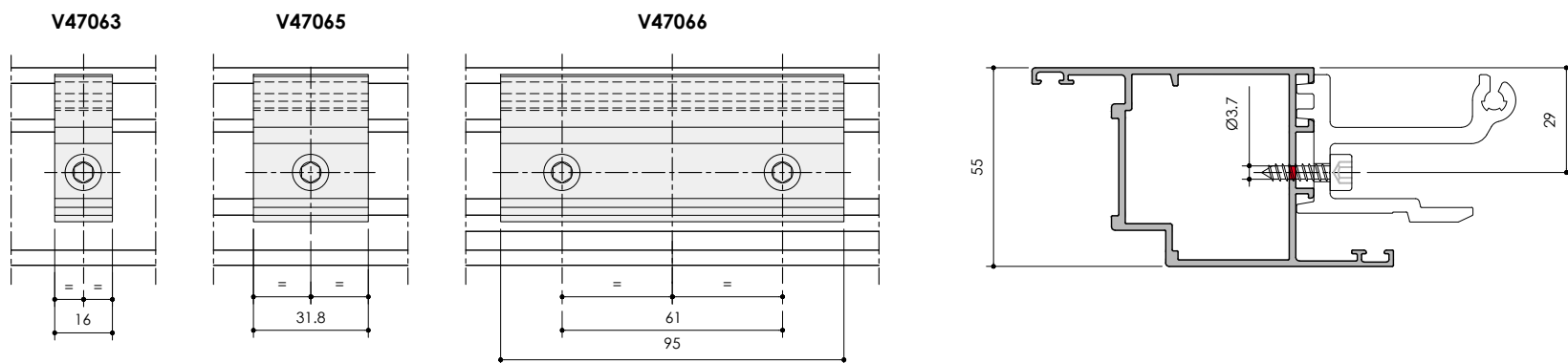


	T40058
Ø8	+ T00107

C45K		C55K	
PROFILO PROFILE	CAVALLOTTO T-JOINT	PROFILO PROFILE	CAVALLOTTO T-JOINT
N31044	V47063	N32601	V47065
		N32602	V47066
		N32631	V47066

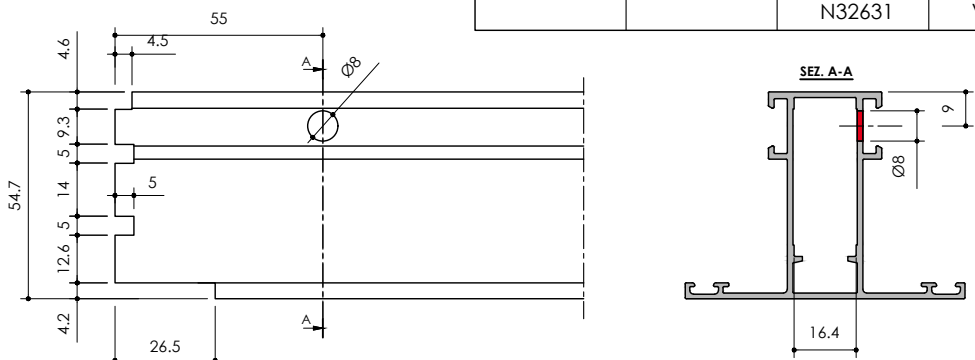


APPLICABILE AI PROFILI APPLICABLE TO PROFILES	
C45K	
N31126	
N31142	



	T40064
Ø8	+ T00107

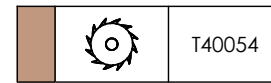
C45K		C55K	
PROFILO PROFILE	CAVALLOTTO T-JOINT	PROFILO PROFILE	CAVALLOTTO T-JOINT
N31044	V47063	N32601	V47065
		N32602	V47066
		N32631	V47066



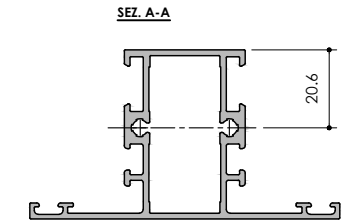
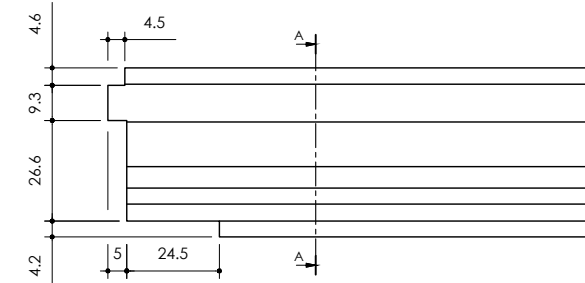
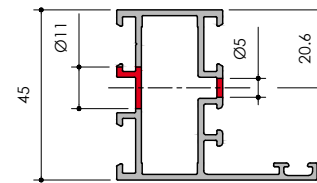
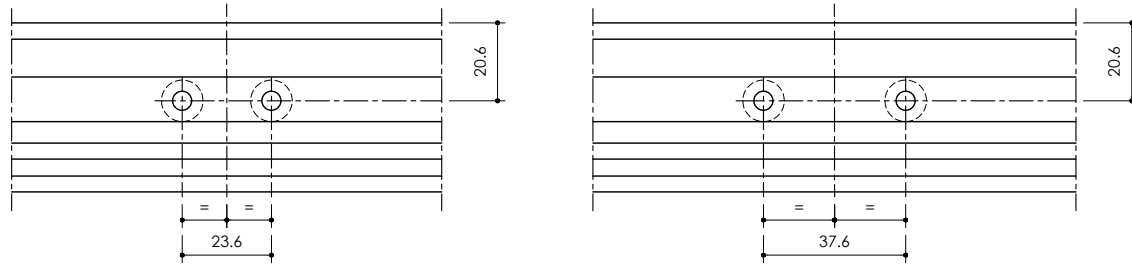
LAVORAZIONE PER CONNESSIONE TRAVERSI, CON VITI
MACHINING FOR TRANSOM CONNECTION, WITH SCREWS

C45K-NI	C55K-NI
●	●

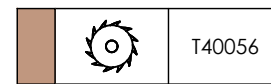
APPLICABILE AI PROFILI APPLICABLE TO PROFILES	
C45K	
N31000	N31001
N31002	N31020
N31023	N31040



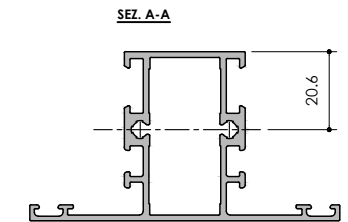
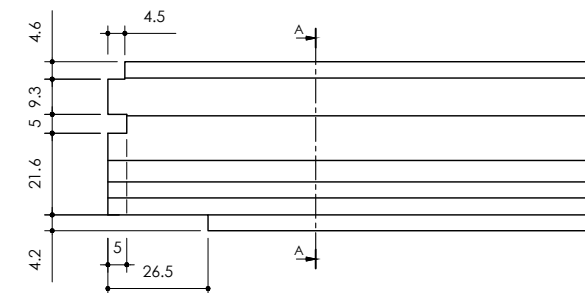
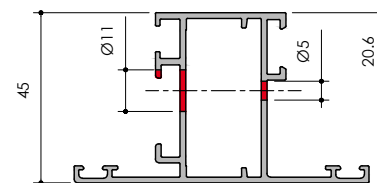
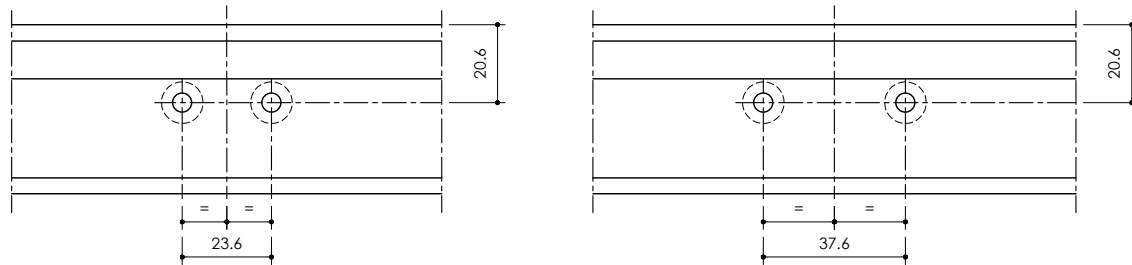
PROFILI PROFILES
C45K
N31042
N31043



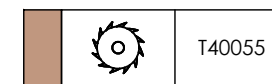
PROFILI PROFILES
C45K
N31123
N31140
N31141



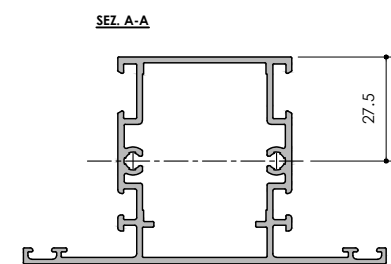
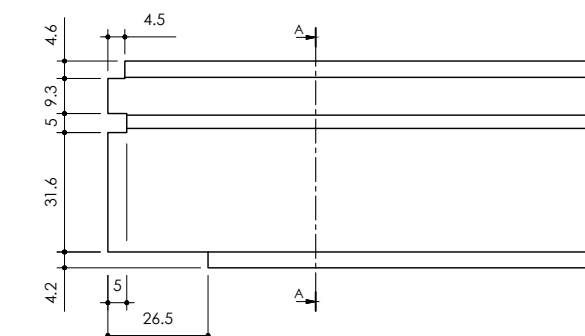
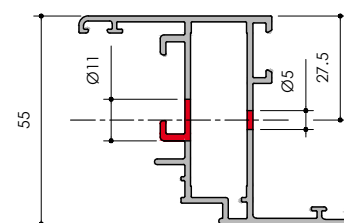
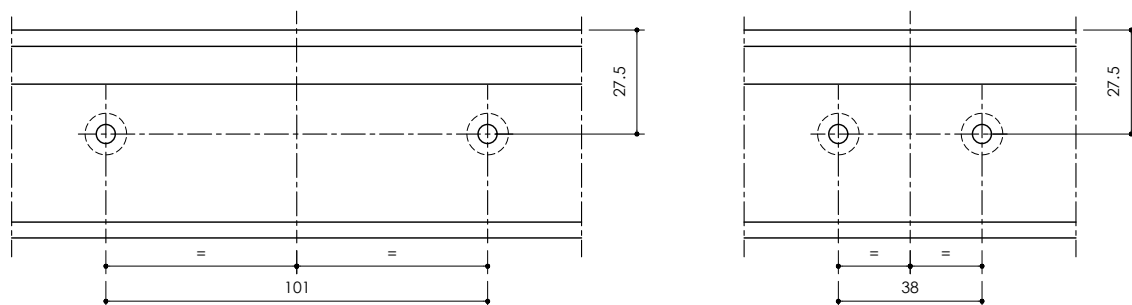
PROFILI PROFILES
C45K
N31042
N31043



PROFILI PROFILES
C45K
N31120



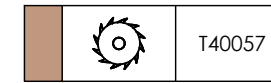
PROFILI PROFILES	
C45K	C55K
N31044	N32601
	N32602
	N32631



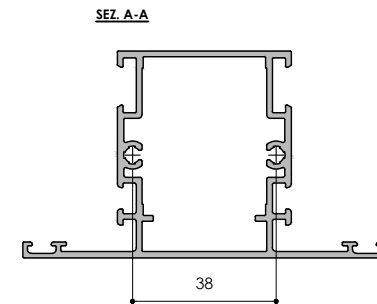
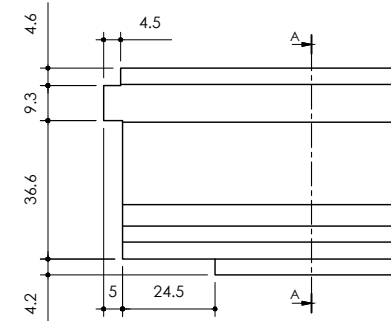
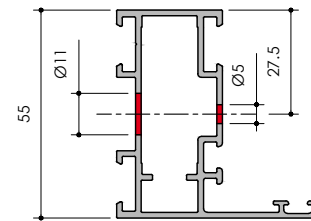
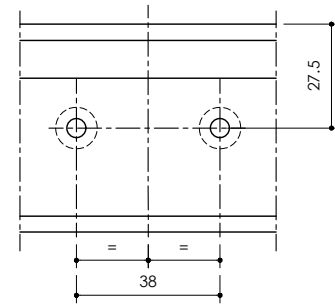
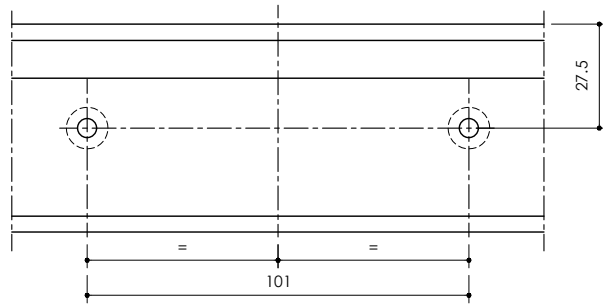
LAVORAZIONE PER CONNESSIONE TRAVERSI, CON VITI
MACHINING FOR TRANSOM CONNECTION, WITH SCREWS

C45K-NI	C55K-NI
●	●

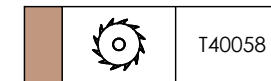
PROFILI PROFILES
C55K
N32000
N32001
N32020



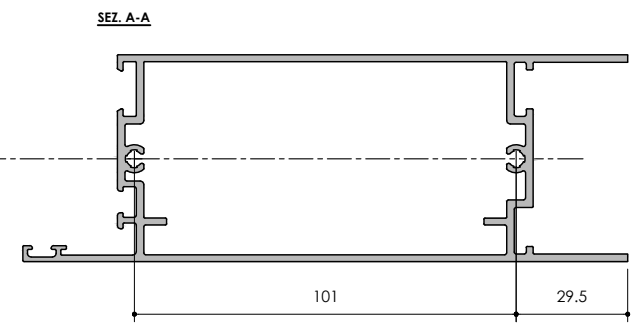
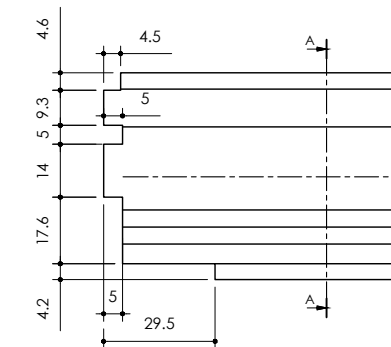
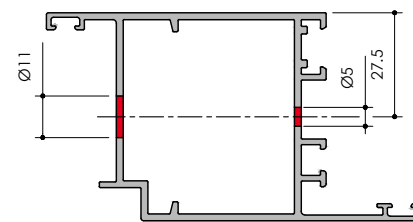
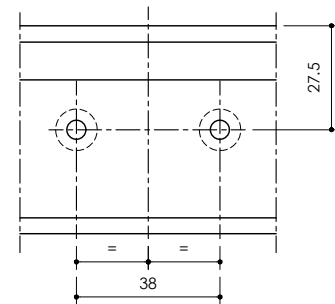
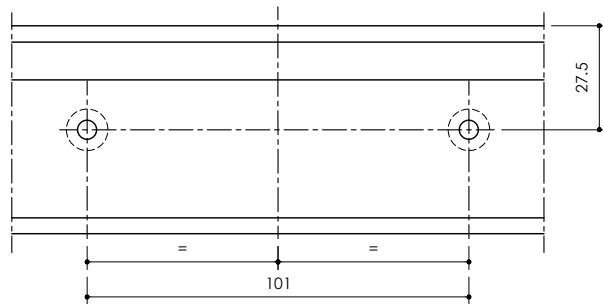
PROFILI PROFILES
C55K
N32601
N32602
N32631



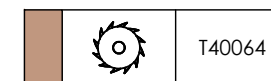
PROFILI PROFILES
C55K
N32121
N32142
N32300



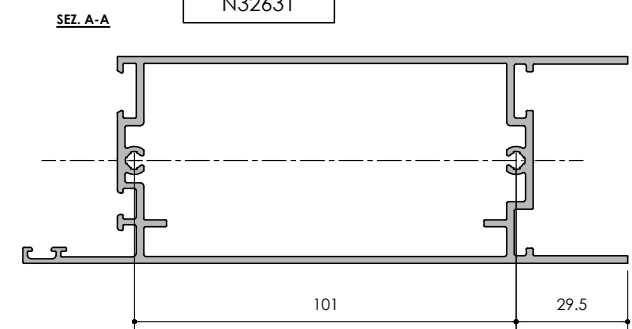
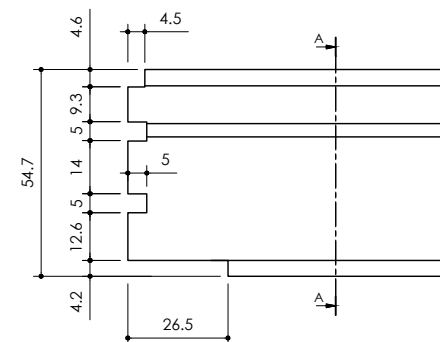
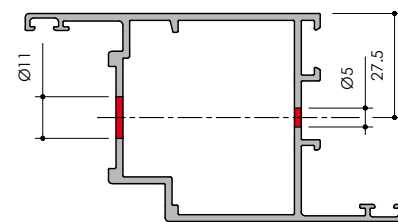
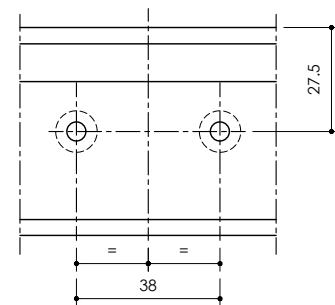
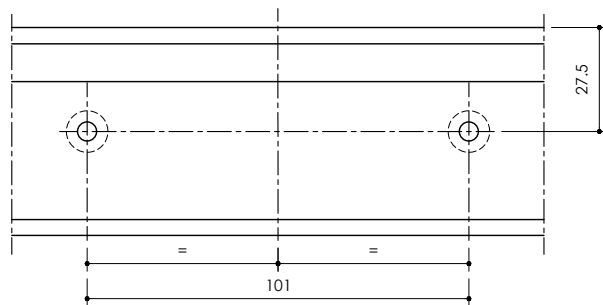
PROFILI PROFILES
C55K
N32601
N32602
N32631



PROFILI PROFILES
C45K
N31126
N31142



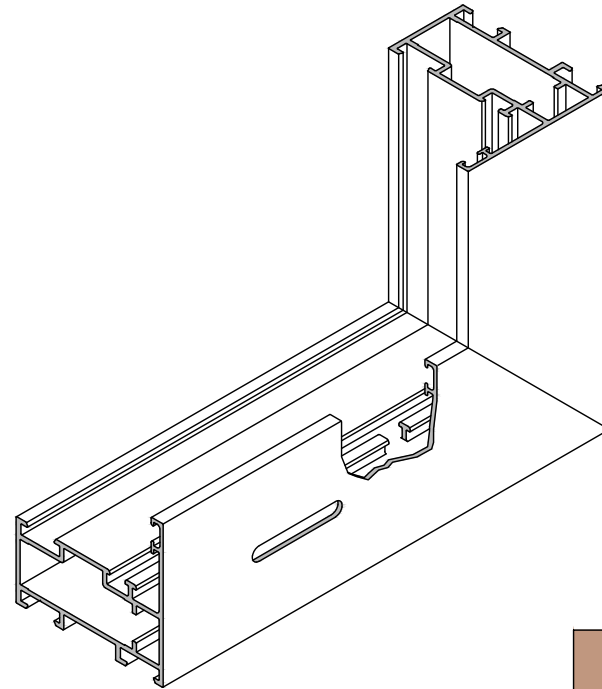
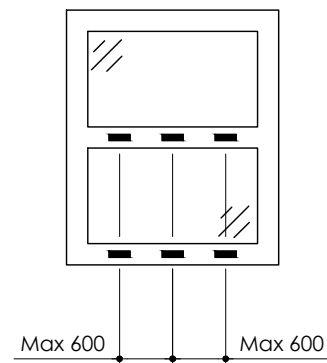
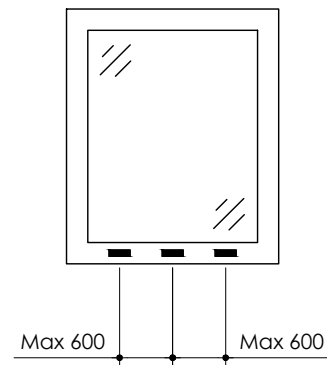
PROFILI PROFILES
C45K
N32601
N32602
N32631



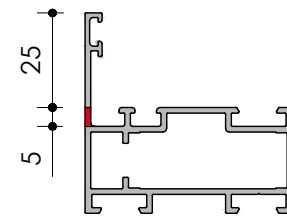
LAVORAZIONI PER DRENAGGIO ACQUA E VENTILAZIONE SU ELEMENTI FISSI
FIXED FRAMES WATER DRAINAGE AND VENTILATION SYSTEM

APPLICABILE AI PROFILI APPLICABLE TO PROFILES	
C45K	C55K
N31000	N32000
N31001	N32001
N31002	N32020
N31020	
N31023	
N31040	

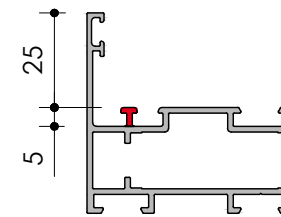
LAVORAZIONE PER ACCESSORI 712005, 712006, 712007, 712008
MACHINING FOR 712005, 712006, 712007, 712008 ACCESSORIES



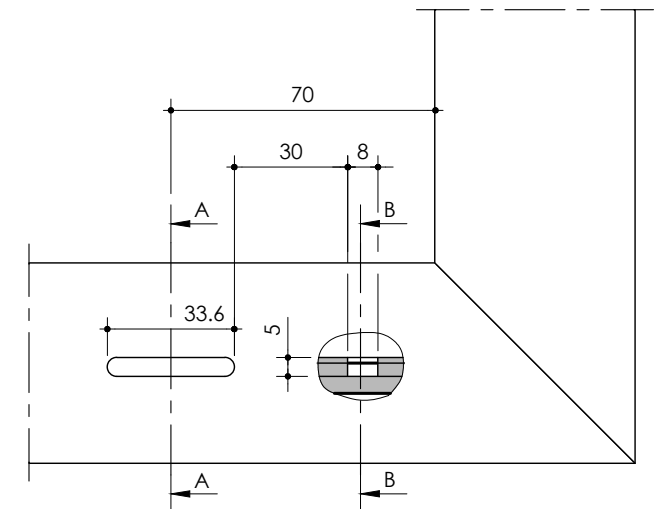
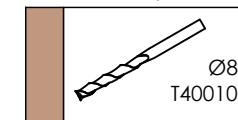
SEZ. A-A



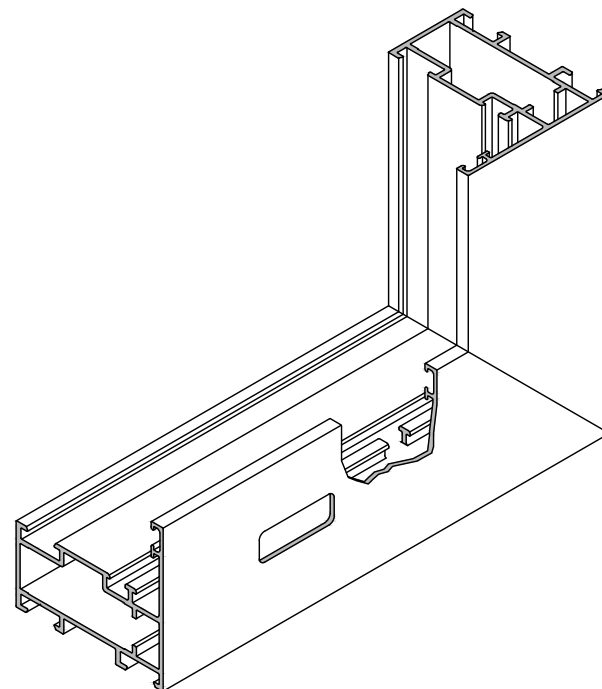
SEZ. B-B



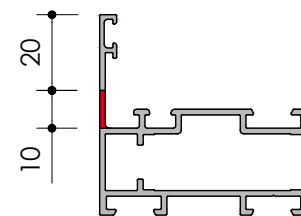
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	Opt.2	909310



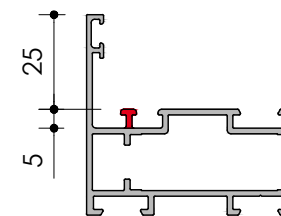
LAVORAZIONE PER ACCESSORIO V51007P
MACHINING FOR V51007P ACCESSORY



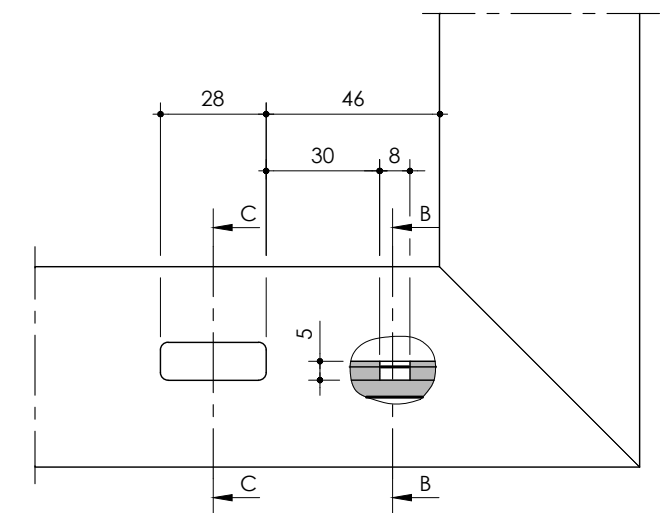
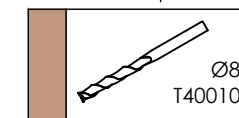
SEZ. C-C



SEZ. B-B

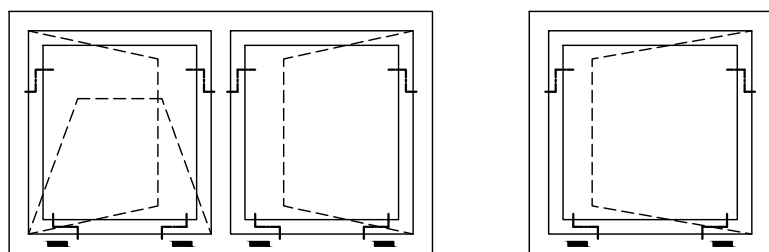


LAVORAZIONE NON ESEGUIBILE
A TRACIANTE
MACHINING NOT EXECUTABLE
BY BLANKING MACHINE

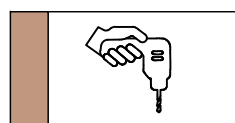
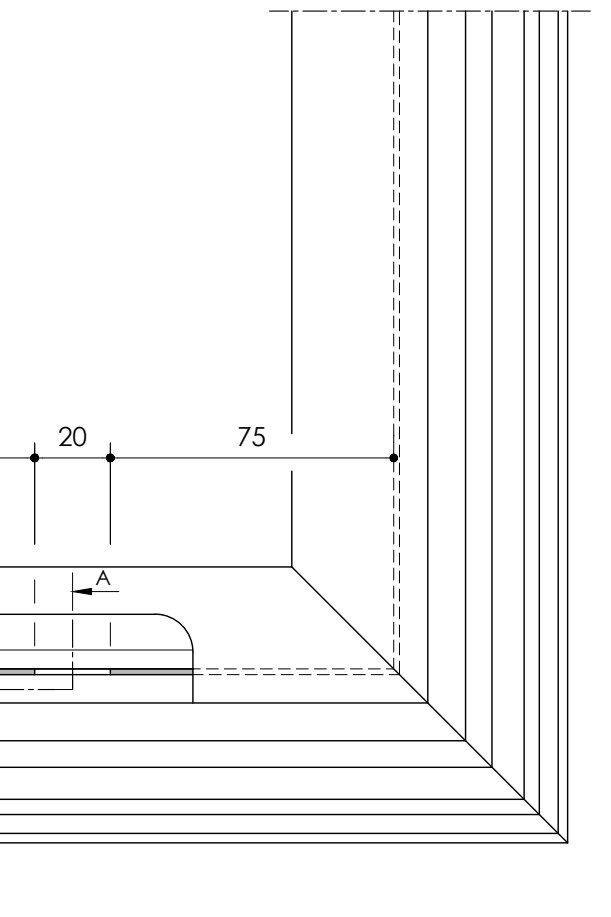
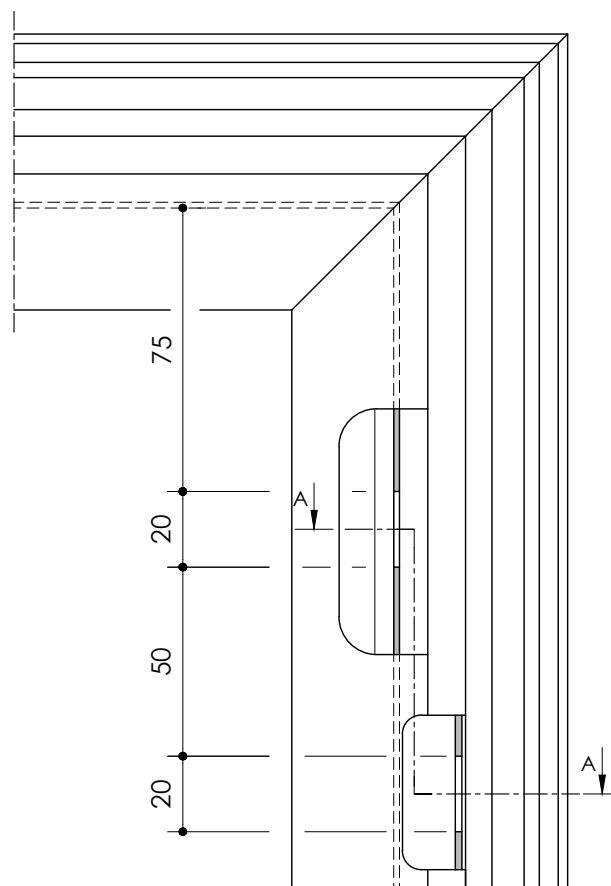
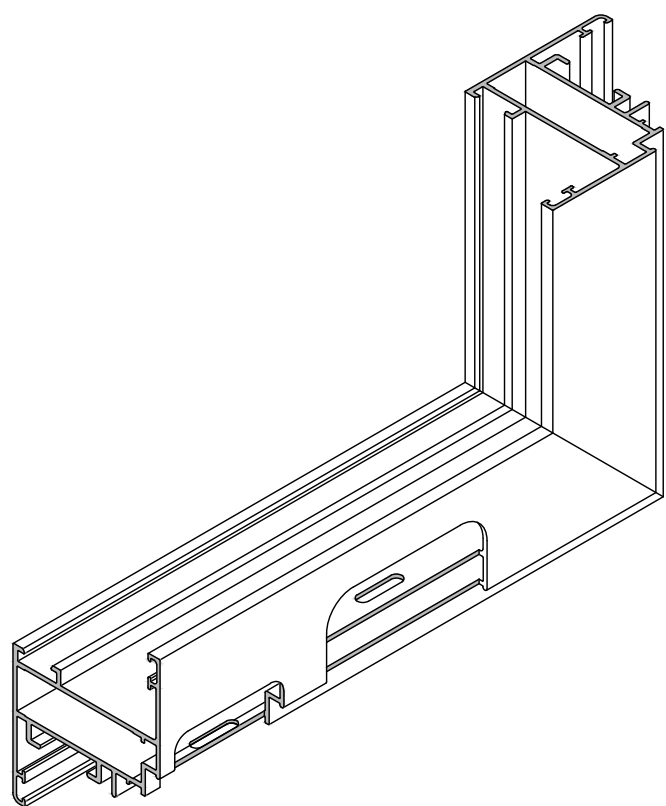


LAVORAZIONI PER DRENAGGIO ACQUA E VENTILAZIONE SU ELEMENTI APRIBILI
OPENING WATER DRAINAGE AND VENTILATION SYSTEM

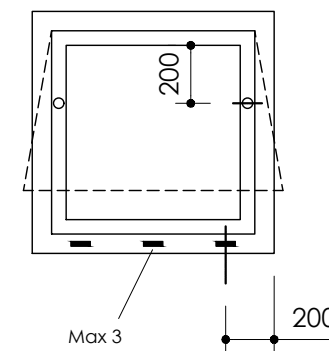
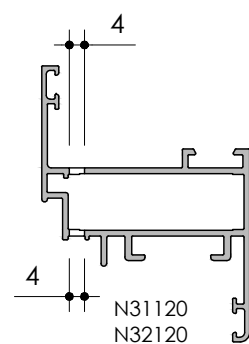
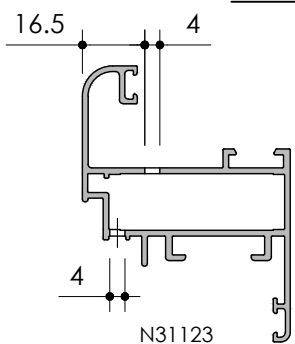
C45K-NI C55K-NI



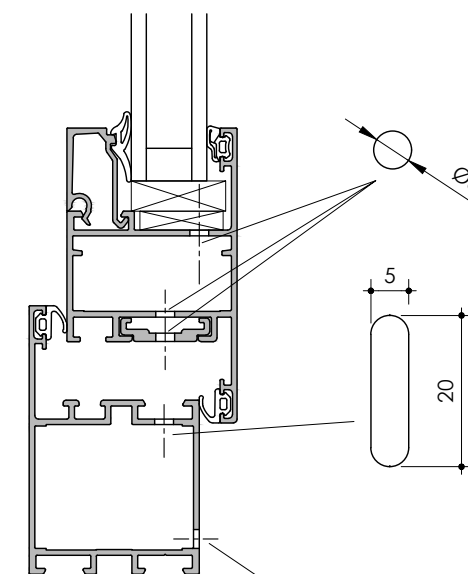
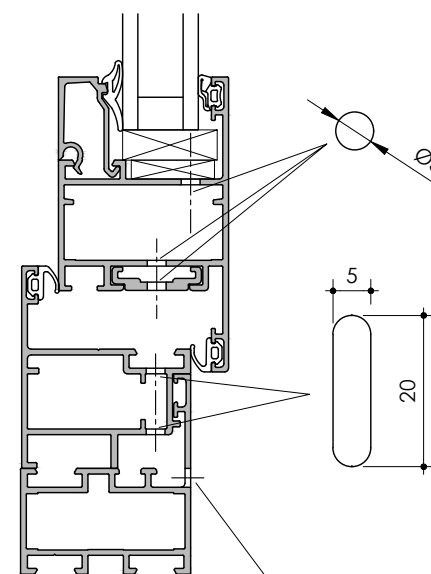
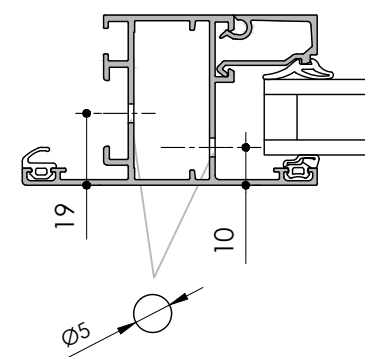
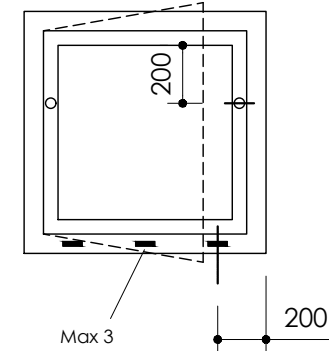
Eeguire le lavorazioni di ventilazione solo in caso di vetri con camera
 Execute this machining only for double glass



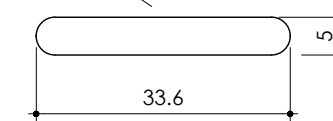
SEZ. A-A



DRENAGGIO E VENTILAZIONE SPORGERE e DOPPIO SORMONTO
 PROJECTING WINDOW and DOUBLE OVERLAP DRAINAGE AND VENTILATION

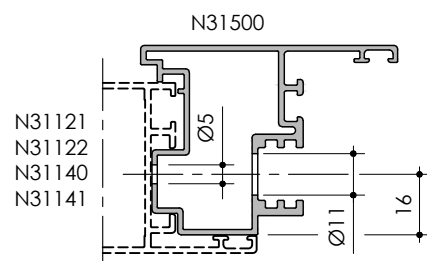
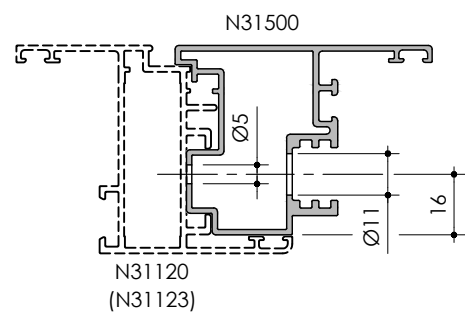
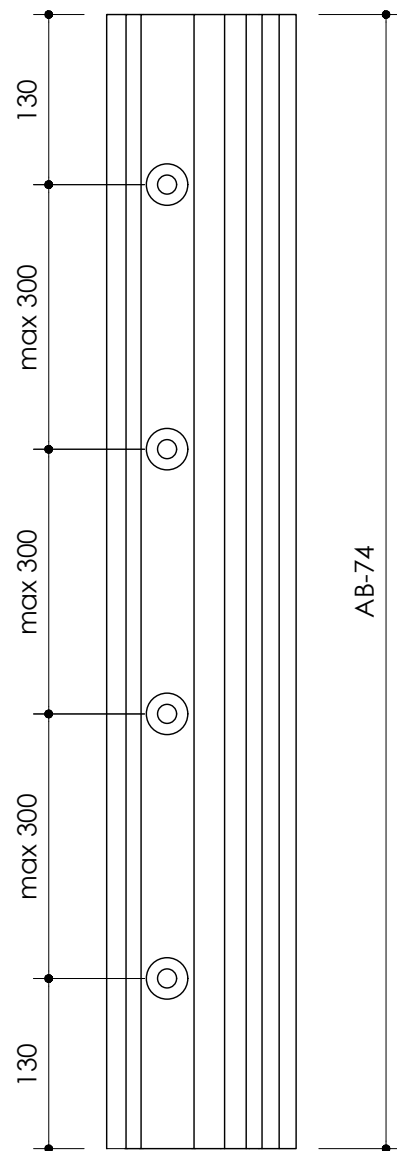
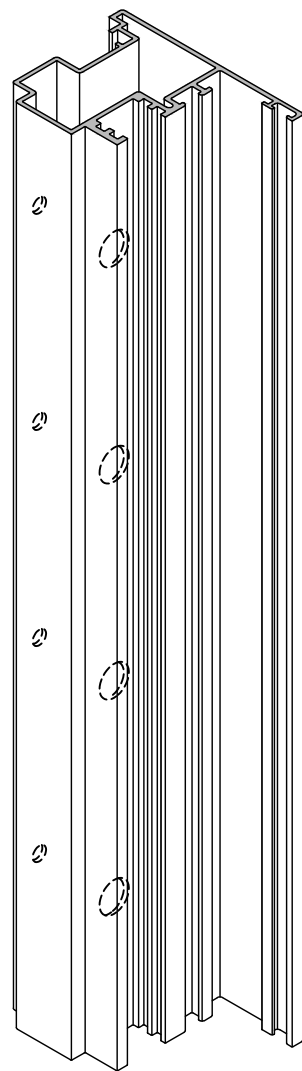


5 x 33.6	Opt.1	US + T00114
	Opt.2	909310



LAVORAZIONE PROFILO N31500
MACHINING N31500 PROFILE

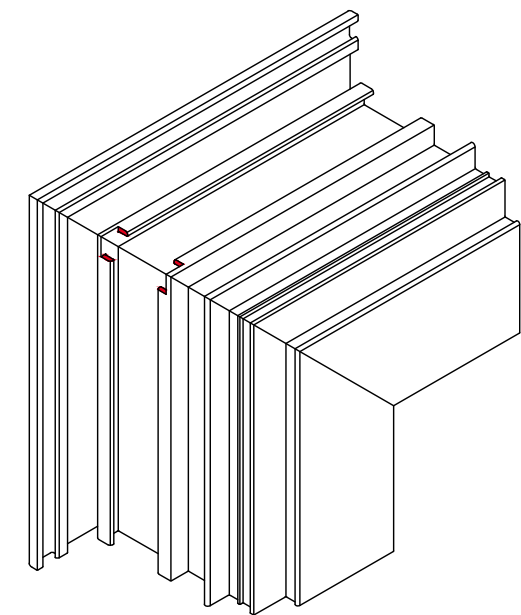
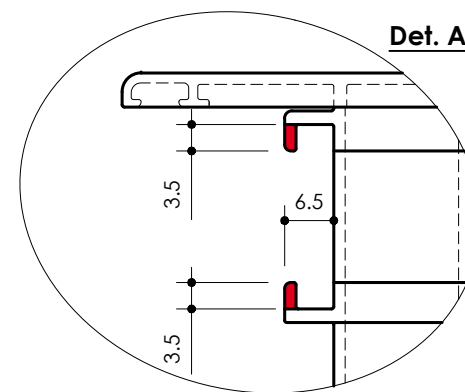
C45K-NI	C55K-NI
●	



LAVORAZIONE ALETTE DI ESTREMITA' CAVA ACCESSORI
END CUTTING FOR ROD INSERTION AND HARDWARE ASSEMBLY

	Opt.1	
	Opt.2	

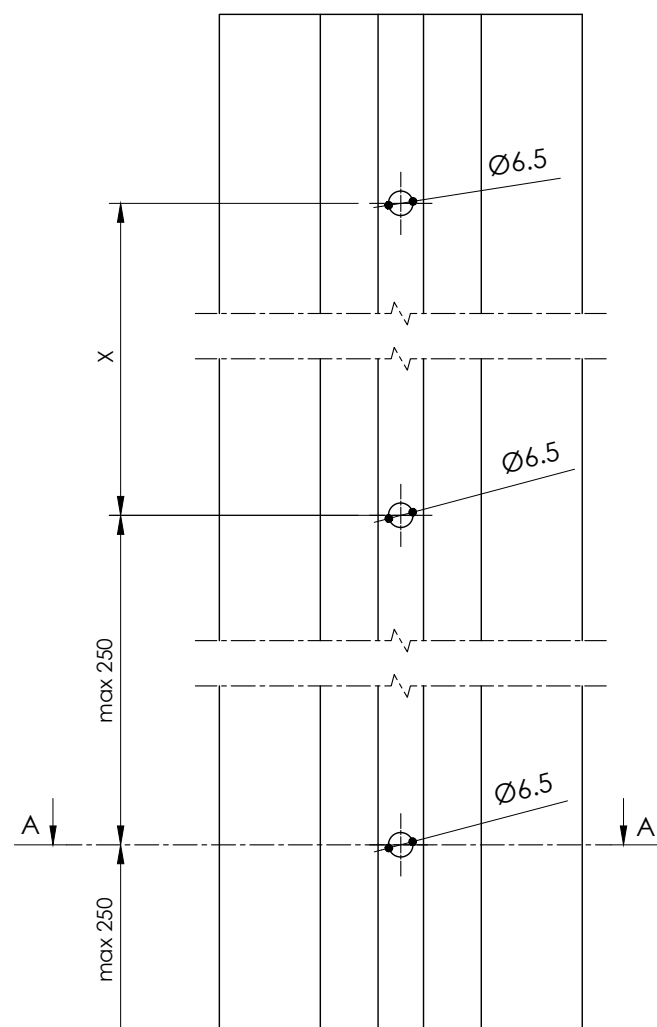
PROFILI		
C45K	N31121	C55K
N31120	N31121	N32120
N31123	N31122	
	N31140	
	N31141	



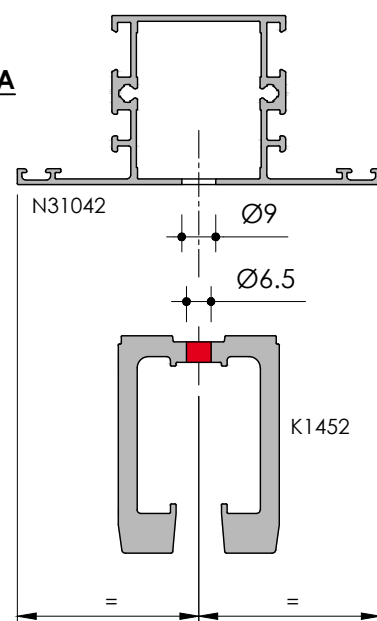
LAVORAZIONE DI FORATURA PER MONTAGGIO COLONNINA DI RINFORZO
MACHINING DIAGRAM FOR COLUMN FIXING REINFORCEMENT

C45K-NI	C55K-NI
●	●

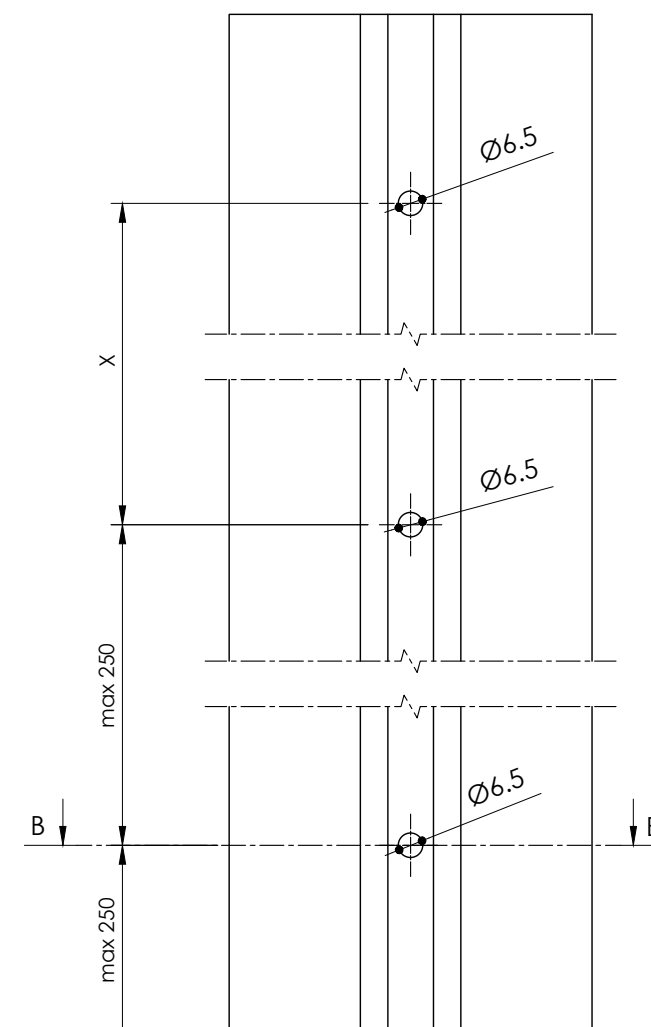
RINFORZO COLONNINA K1452
K1452 COLUMN



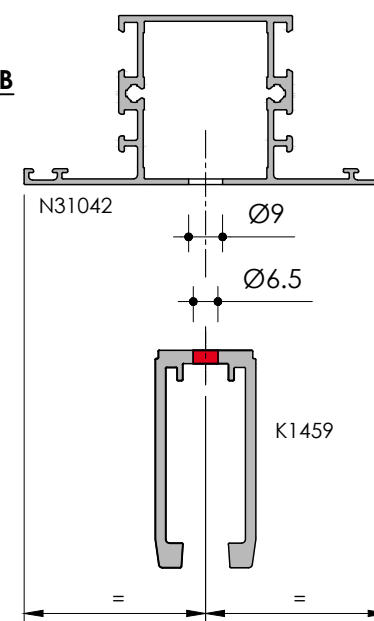
SEZ A-A



RINFORZO COLONNINA K1459
K1459 COLUMN



SEZ B-B



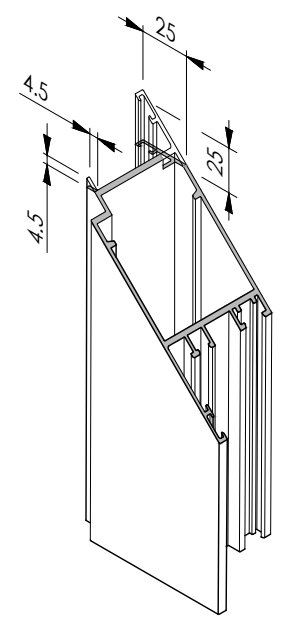
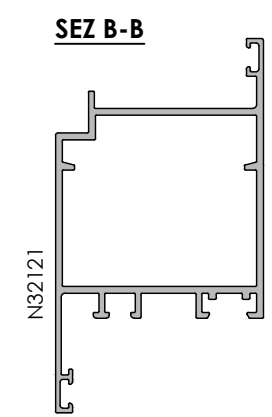
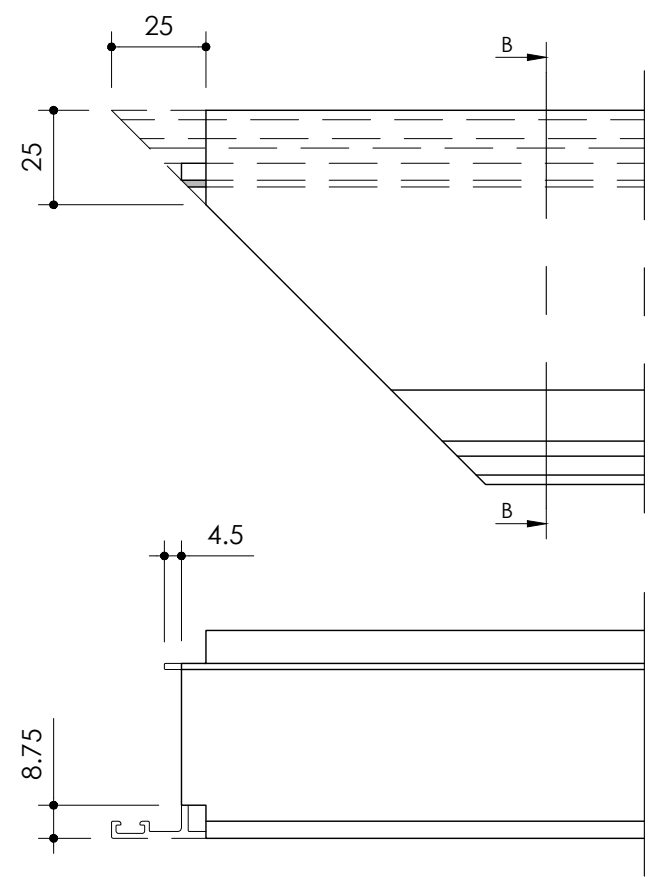
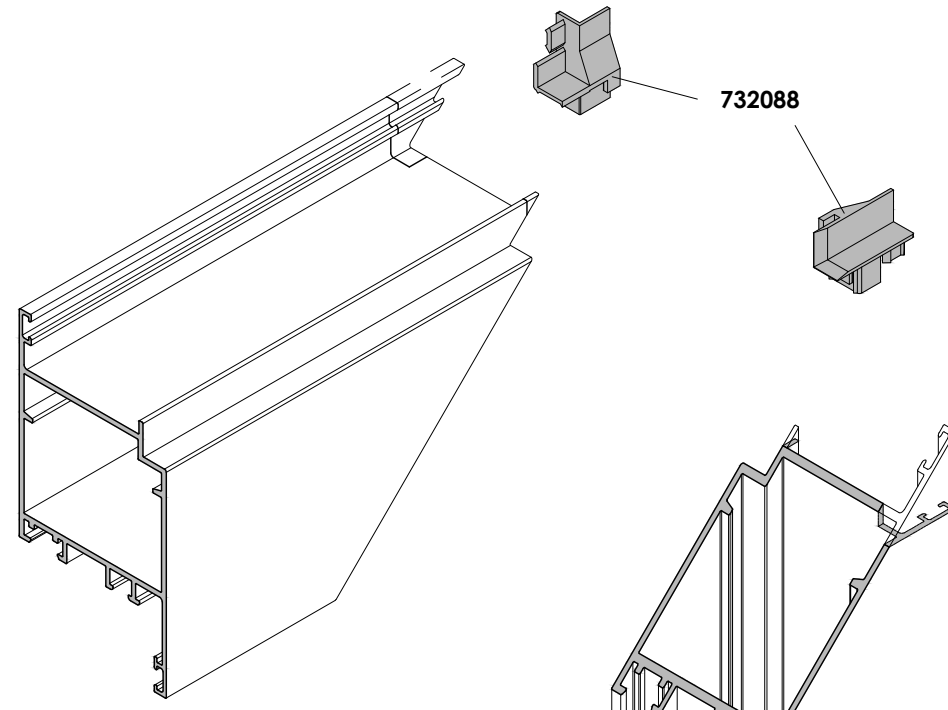
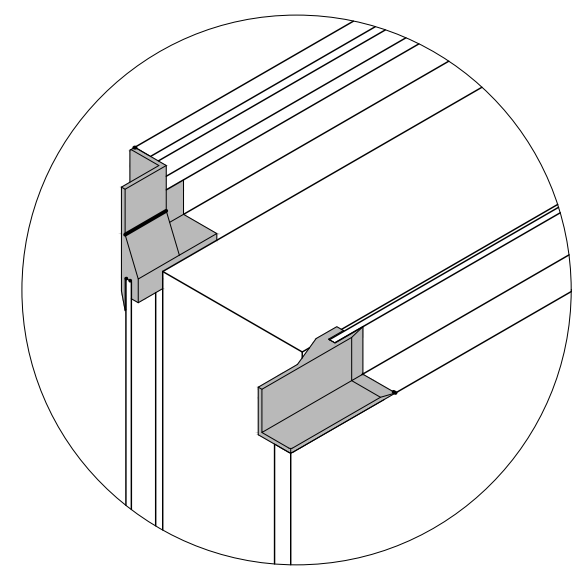
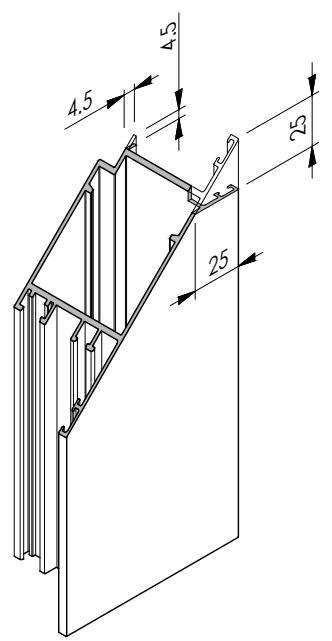
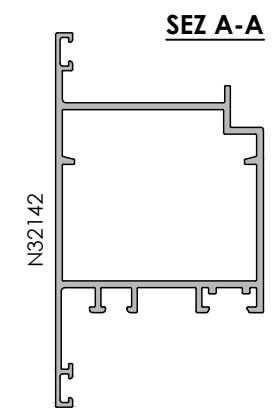
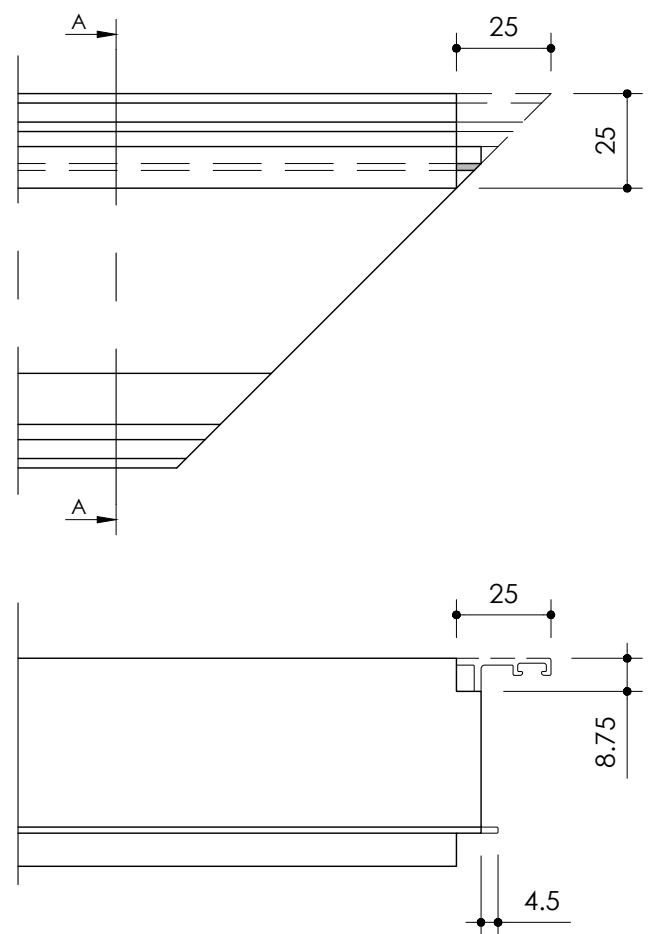
PROFILI	
C45K	C55K
N31042	N32601
N31043	

X - IL PASSO DELLE VITI VA VERIFICATO IN FUNZIONE DEI CARICHI APPLICATI E DELLE DIMENSIONI DEL SERRAMENTO, IN OGNI CASO AUMENTARE LA FREQUENZA DELLE VITI NEI TRATTI TERMINALI

X - THE SCREW PITCH MUST BE CHECKED ACCORDING TO THE LOADS APPLIED AND THE DIMENSIONS OF THE WINDOW, IN ANY CASE INCREASE THE FREQUENCY OF SCREWS IN THE END SECTIONS

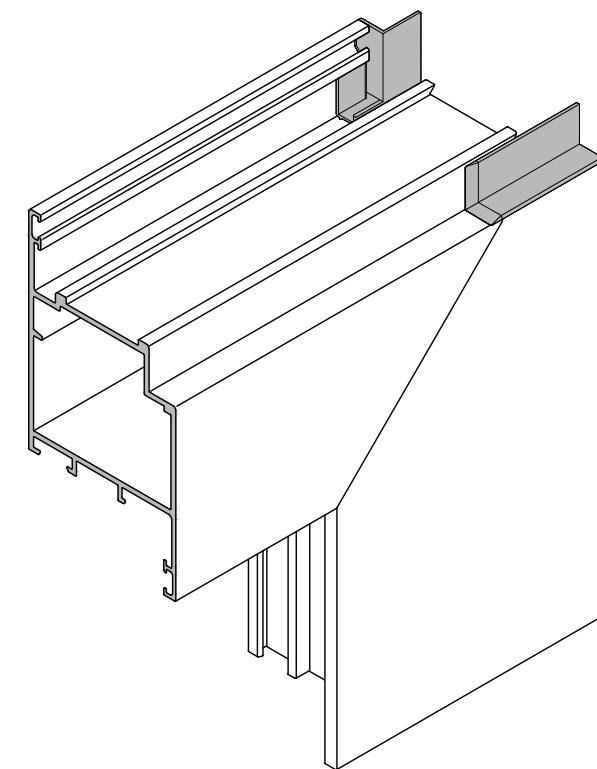
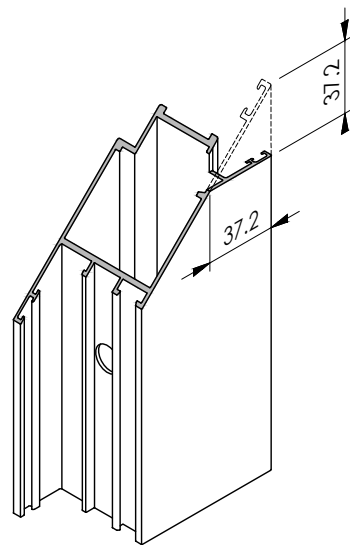
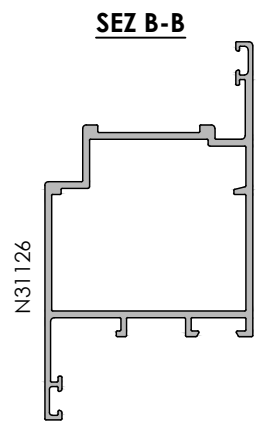
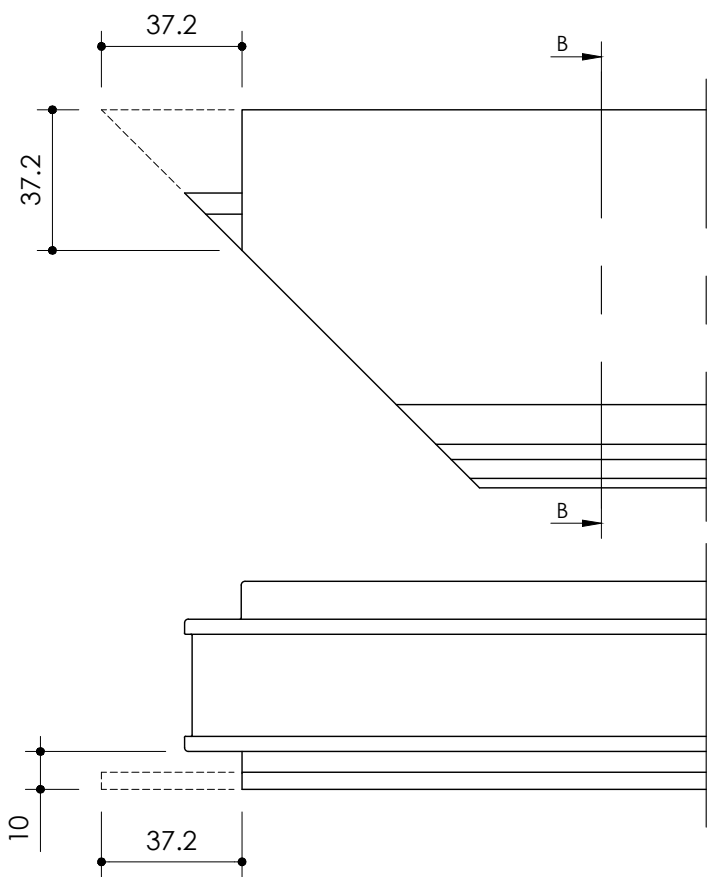
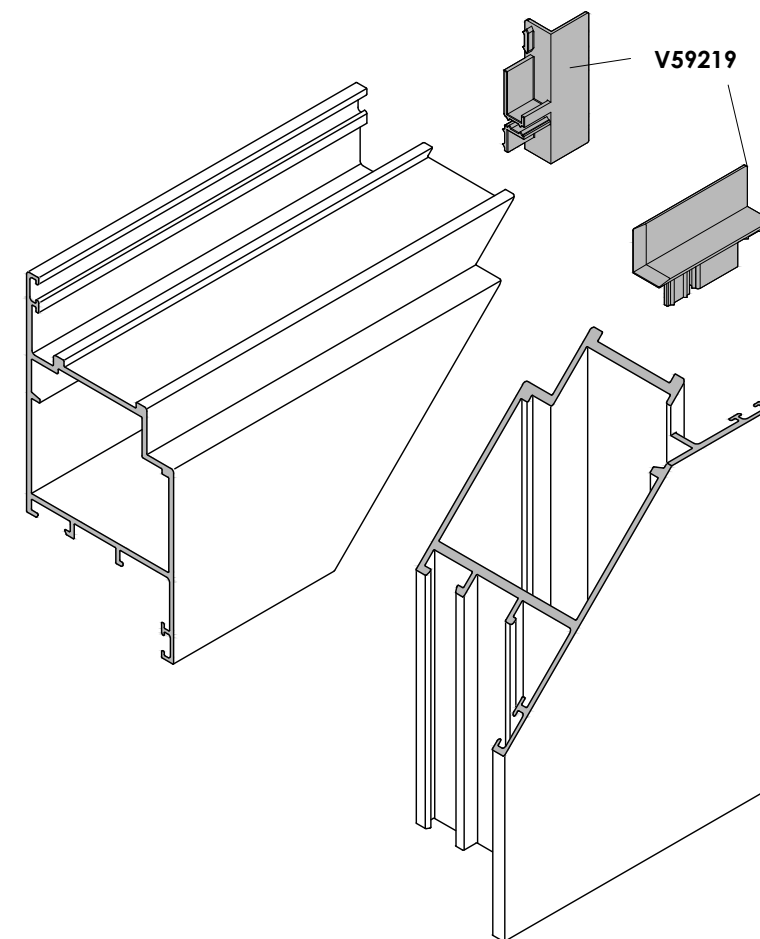
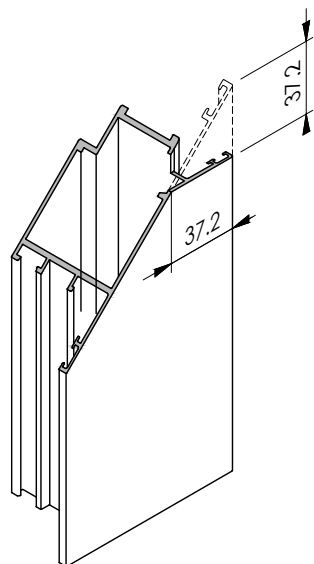
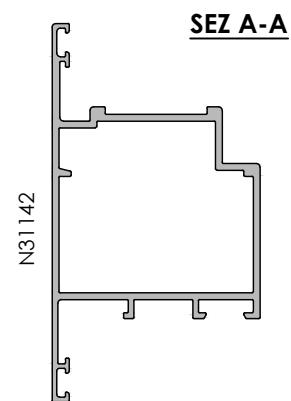
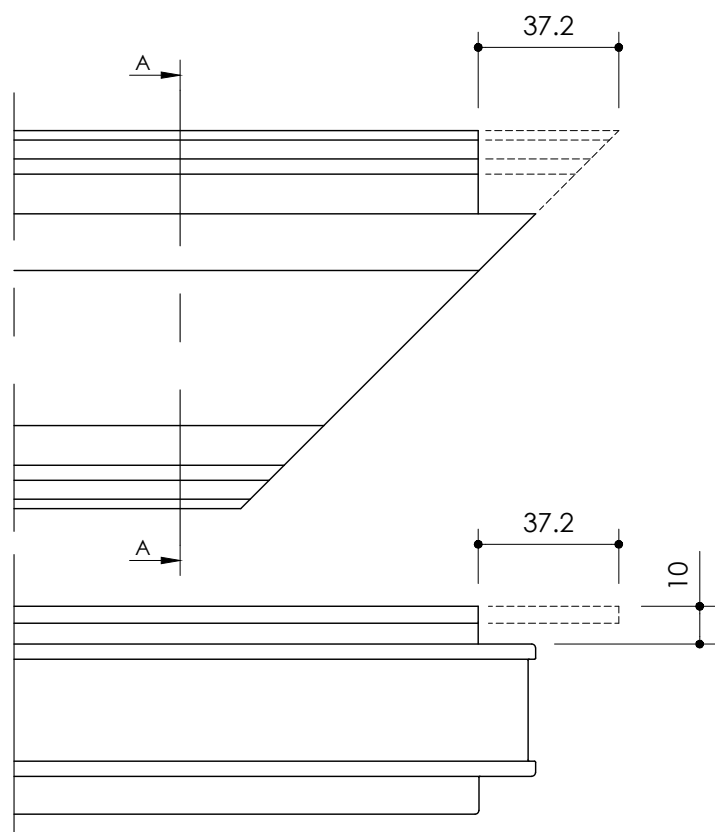
SCHEMA DI LAVORAZIONE E DI MONTAGGIO PER TAPPO TENUTA CENTRALE PORTE DUE ANTE
 MACHINING AND ASSEMBLING DIAGRAM FOR DOUBLE WING CENTRAL SEALING PLUG

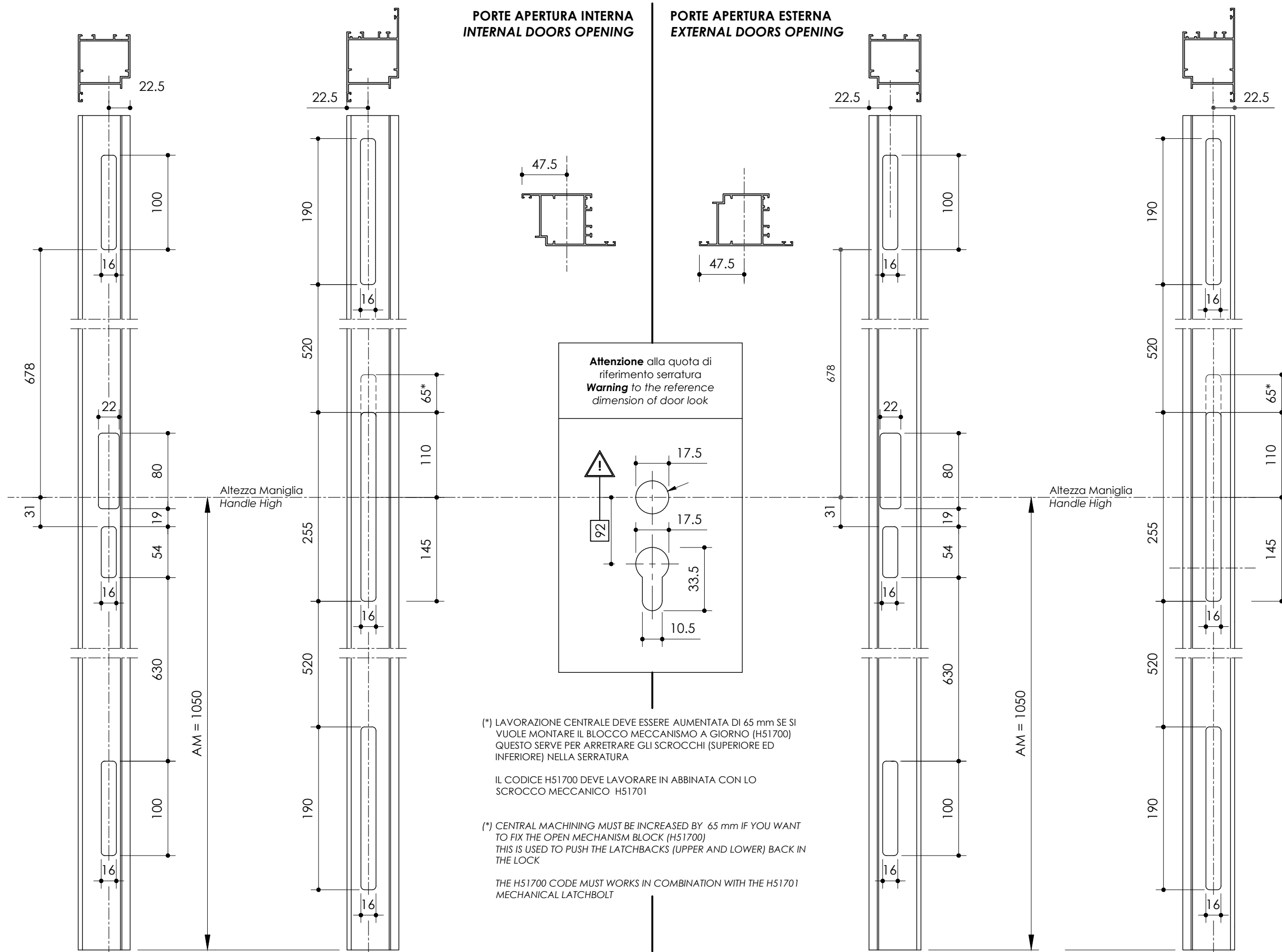
C45K-NI	C55K-NI
	●

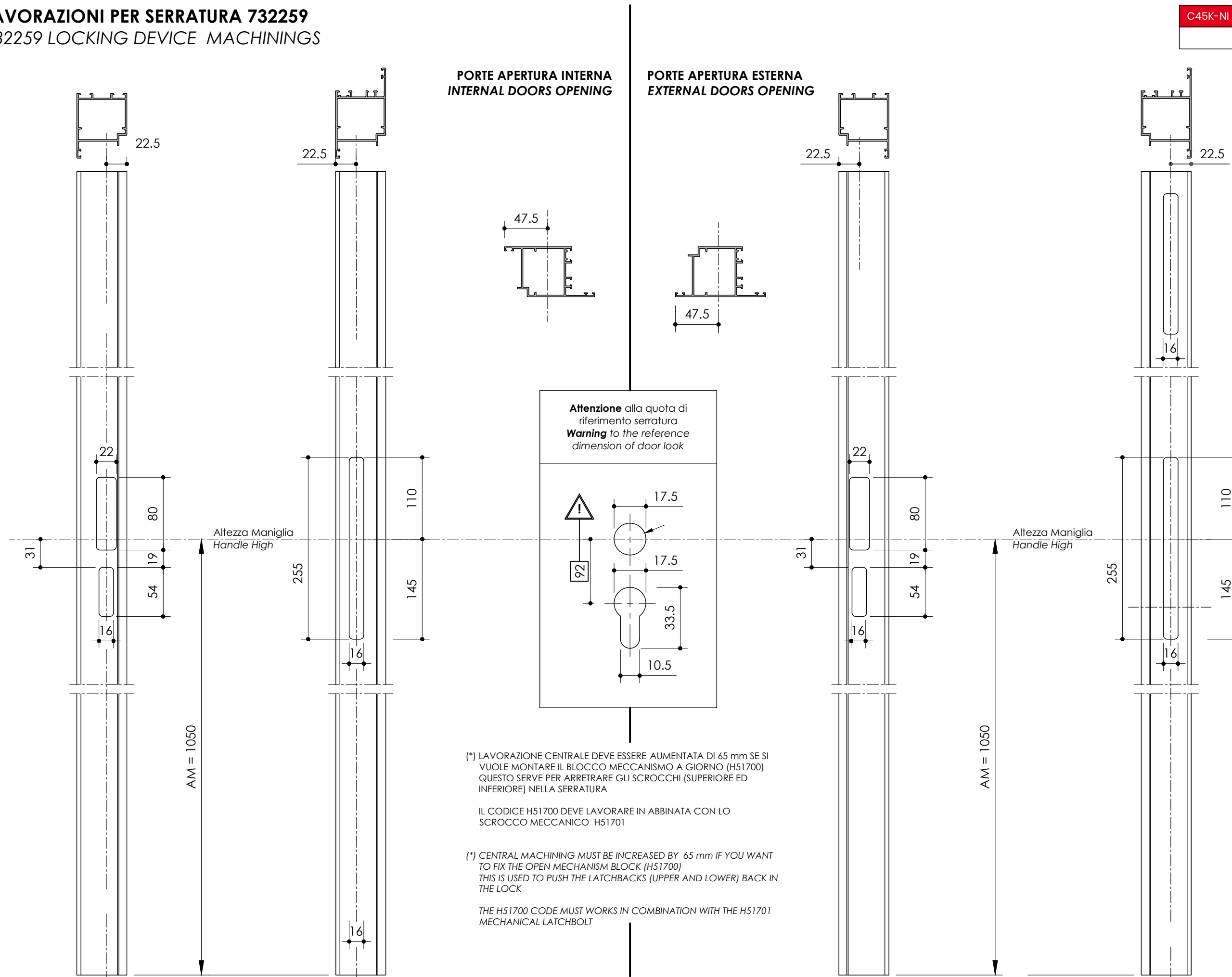


SCHEMA DI LAVORAZIONE E DI MONTAGGIO PER TAPPO TENUTA CENTRALE PORTE DUE ANTE
MACHINING AND ASSEMBLING DIAGRAM FOR DOUBLE WING CENTRAL SEALING PLUG

C45K-NI	C55K-NI
●	







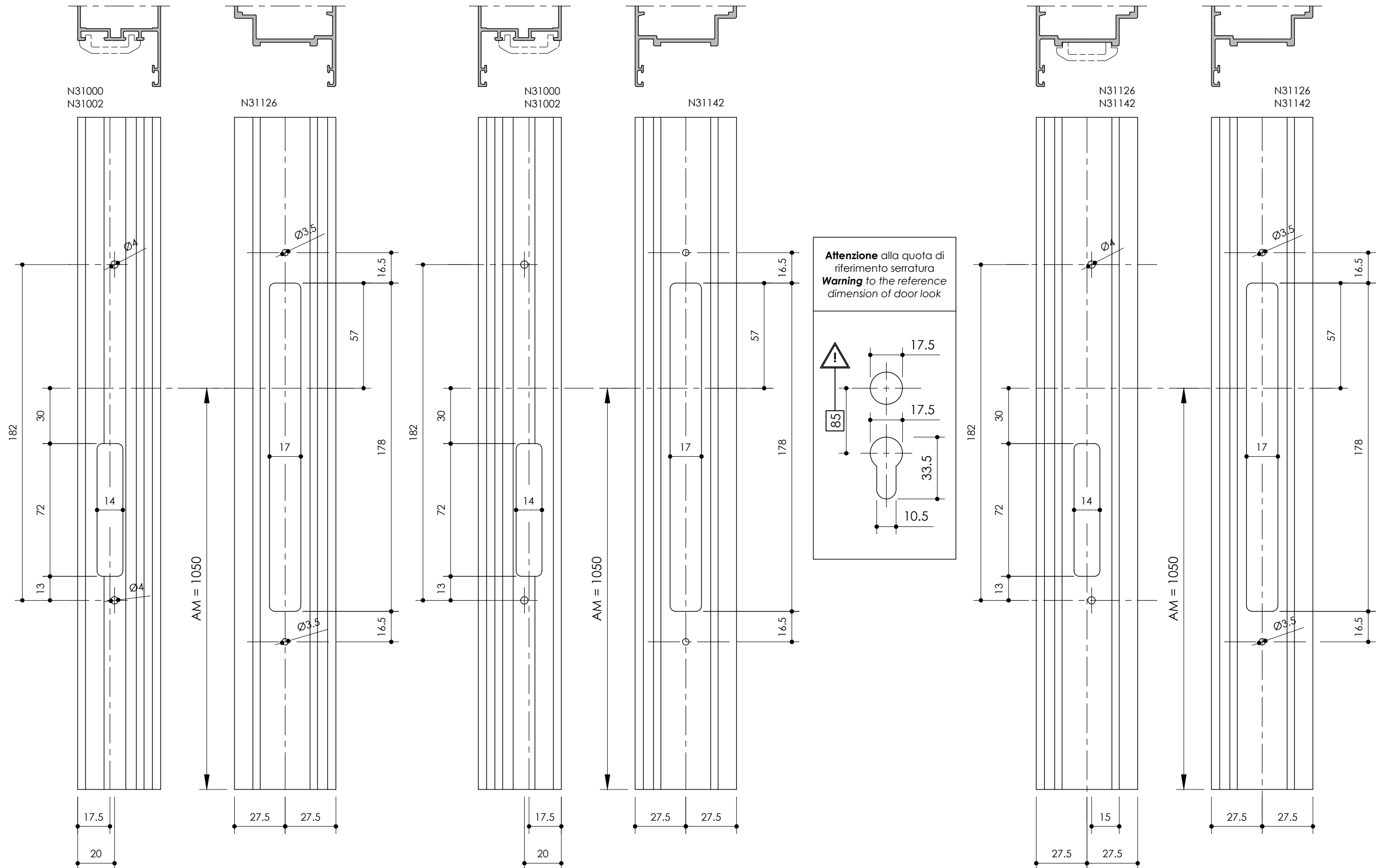
LAVORAZIONI PER SERRATURA 732300 - PORTE DOPPIO SORMONTO
732300 LOCKING DEVICE MACHININGS - DOUBLE OVERLAP DOORS

C45K-NI	C55K-NI
●	

PORTE APERTURA INTERNA
INTERNAL DOORS OPENING

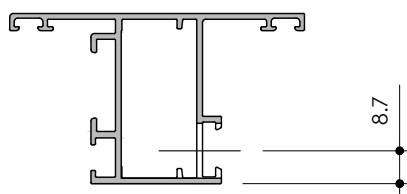
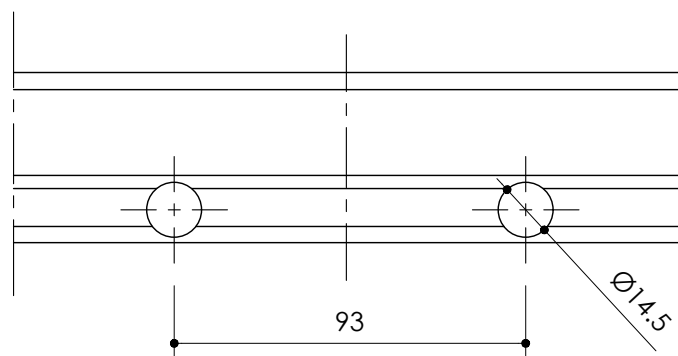
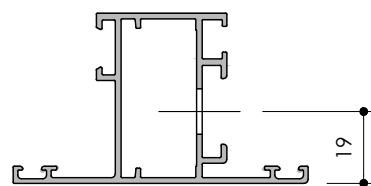
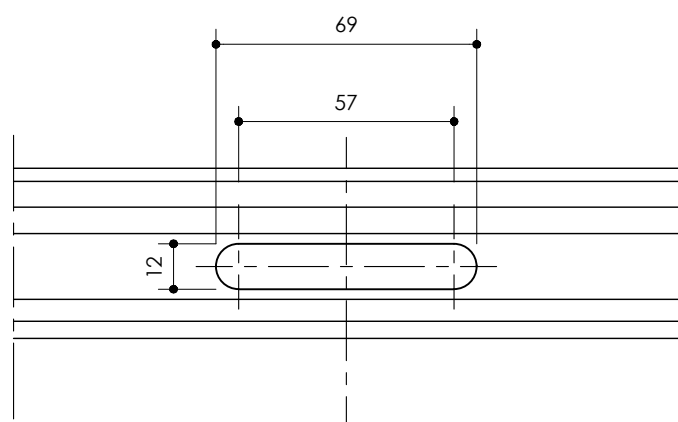
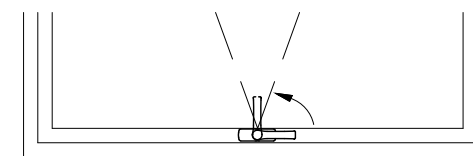
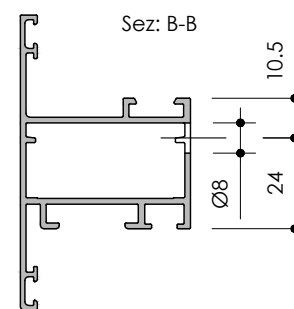
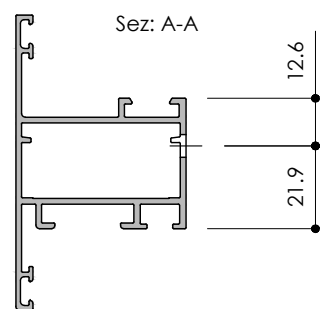
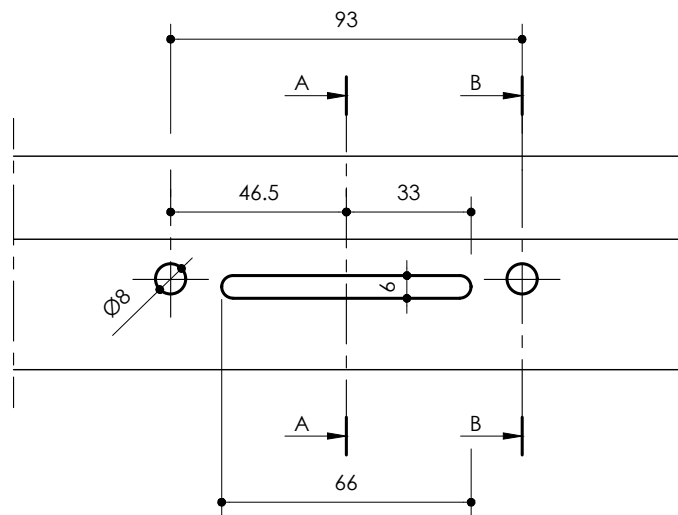
PORTE APERTURA ESTERNA
EXTERNAL DOORS OPENING

NODO CENTRALE
CENTRAL SECTION



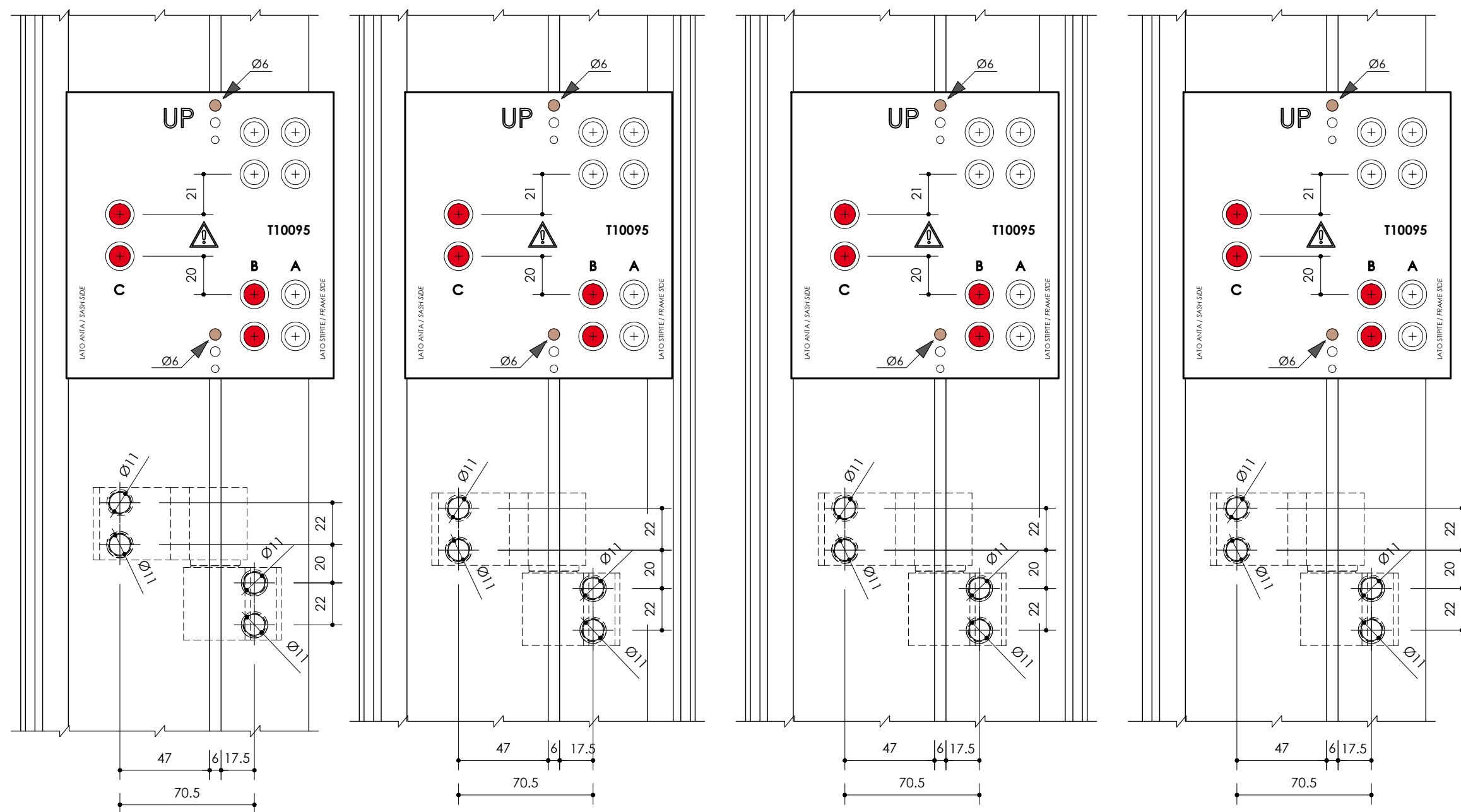
LAVORAZIONI PER CREMONESE H48030
H48030 HANDLE MACHININGS

C45K-NI	C55K-NI
●	



FORATURA PER MONTAGGIO CERNIERE DUE ALI, APERTURA INTERNA
DRILLING FOR TWO WINGS HINGE ASSEMBLING DIAGRAM, INWARD OPENING

C45K-NI C55K-NI

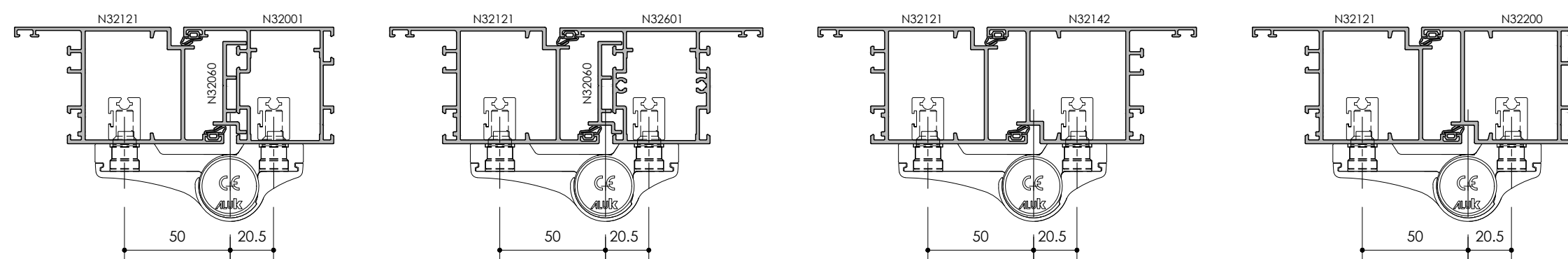


← POSIZIONAMENTO DIMA
 JIG POSITIONING

Per il montaggio delle cerniere sulle porte si dovranno praticare fori Ø11mm utilizzando la dima "T10095".

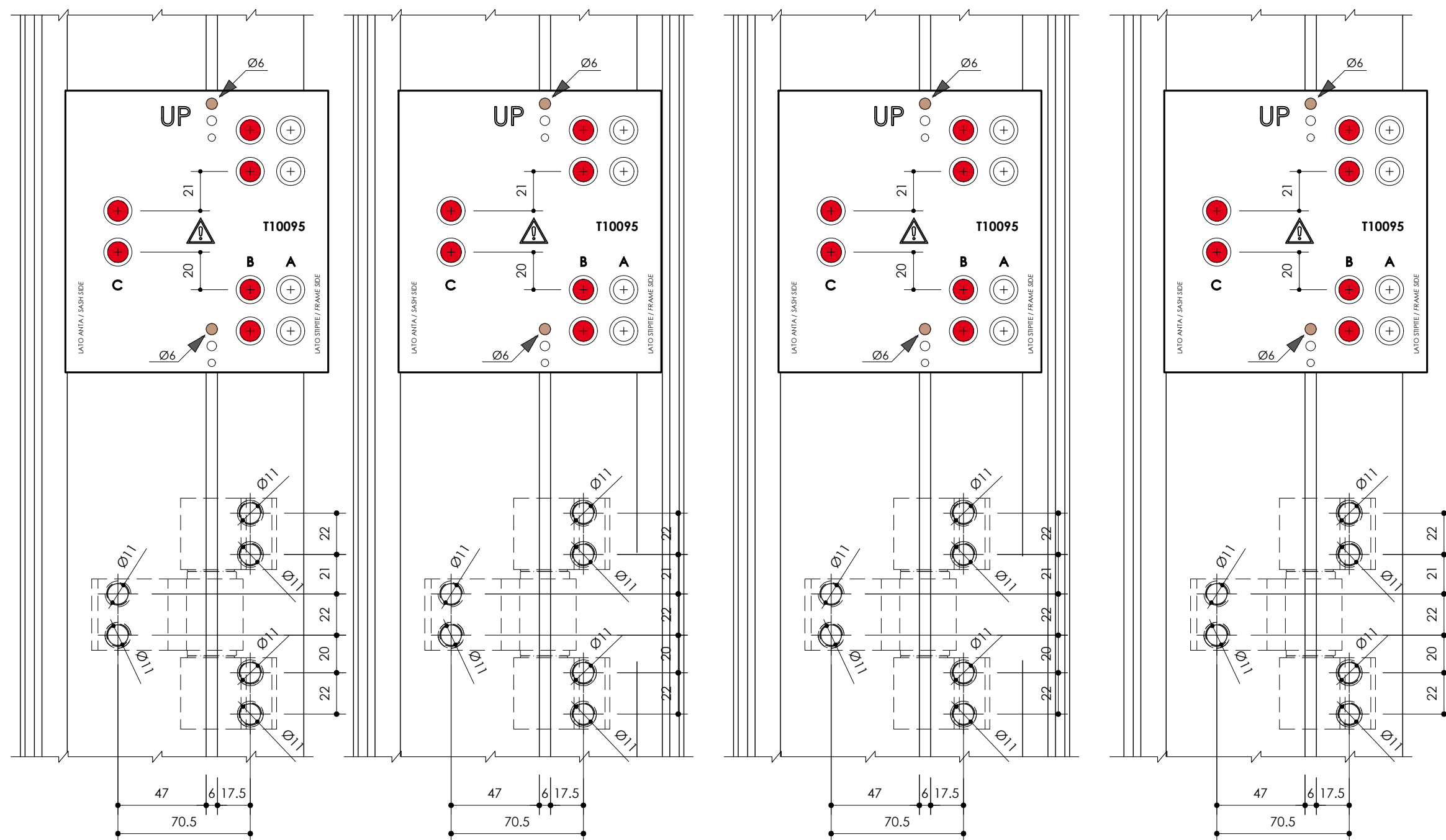
To install the hinges on doors make Ø11mm holes using the template "T10095".

Pz	art.	Descrizione / Description
1	H43306(-..)	CERNIERA DUE ALI / TWO WINGS HINGE
1	H43605	KIT DI FISSAGGIO CERNIERA DUE ALI / TWO WINGS HINGE FIXING KIT



FORATURA PER MONTAGGIO CERNIERE TRE ALI, APERTURA INTERNA
DRILLING FOR THREE WINGS HINGE ASSEMBLING DIAGRAM, INWARD OPENING

C45K-NI C55K-NI

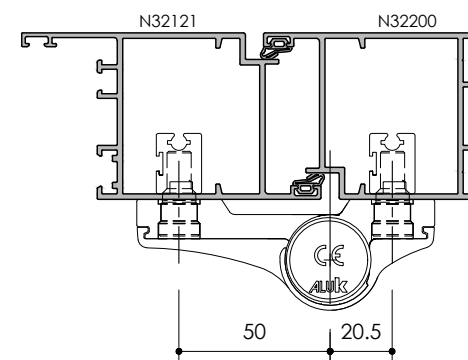
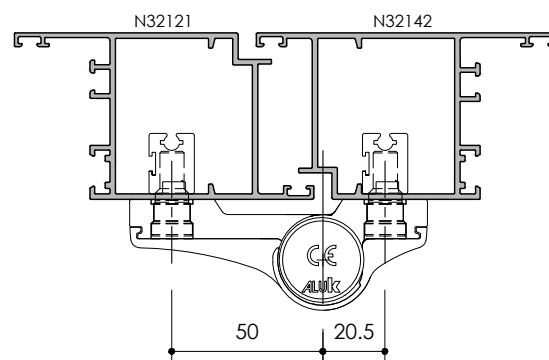
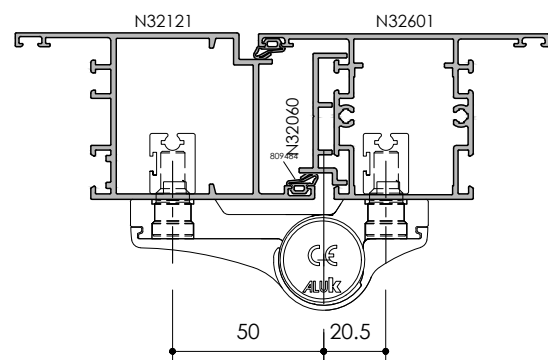
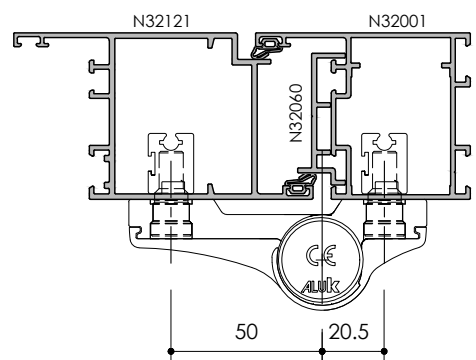


← POSIZIONAMENTO DIMA
 JIG POSITIONING

Per il montaggio delle cerniere sulle porte si dovranno praticare fori Ø11mm utilizzando la dima "T10095".

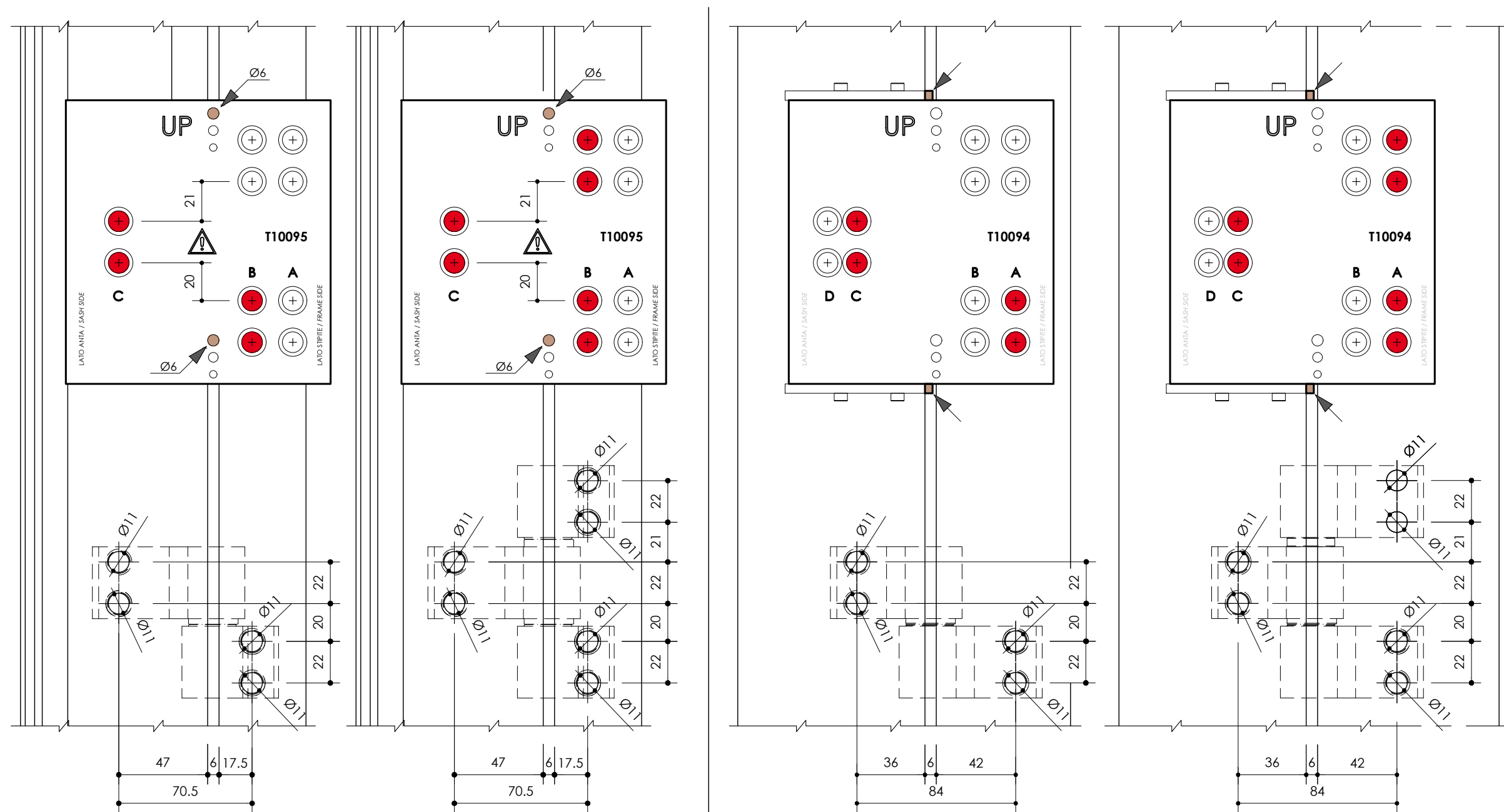
To install the hinges on doors make Ø11mm holes using the template "T10095".

Pz	art.	Descrizione / Description
1	H43307(-..)	CERNIERA TRE ALI / THREE WINGS HINGE
1	H43606	KIT DI FISSAGGIO CERNIERA TRE ALI / THREE WINGS HINGE FIXING KIT



FORATURA PER MONTAGGIO CERNIERE A DUE E TRE ALI, APERTURA ESTERNA
DRILLING FOR TWO AND THREE WINGS HINGE ASSEMBLING DIAGRAM, OUTWARD OPENING

C45K-NI	C55K-NI
	●



← POSIZIONAMENTO DIMA
 JIG POSITIONING

Per il montaggio delle cerniere sulle porte si dovranno praticare fori Ø11 mm utilizzando le dime "T10094" o "T10095".

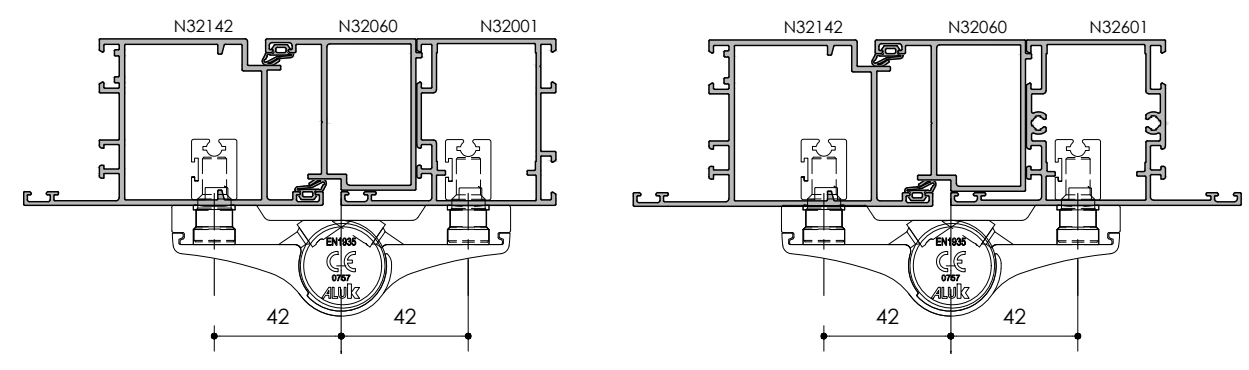
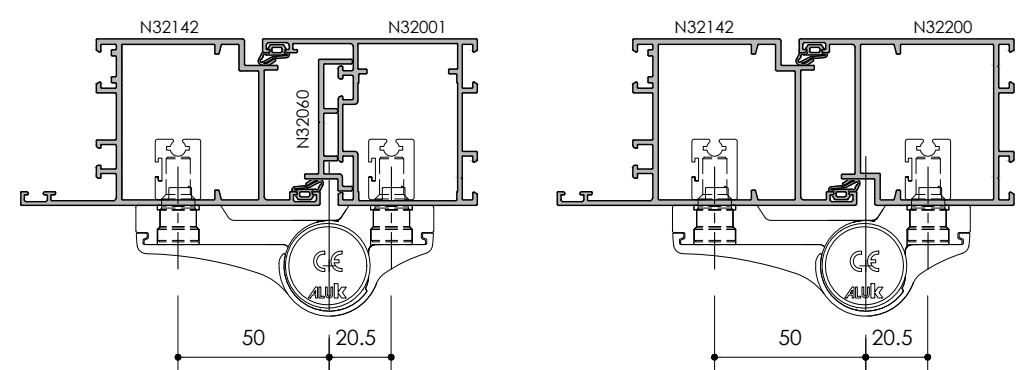
To install the hinges on doors make Ø11 mm holes using the templates "T10094" or "T10095".

Pz	art.	Descrizione / Description
1	H43306(-..)	CERNIERA DUE ALI / TWO WINGS HINGE
1	H43605	KIT DI FISSAGGIO CERNIERE DUE ALI / TWO WINGS HINGES FIXING KIT

Pz	art.	Descrizione / Description
1	H43310(-..)	CERNIERA DUE ALI / TWO WINGS HINGE
1	H43605	KIT DI FISSAGGIO CERNIERE DUE ALI / TWO WINGS HINGES FIXING KIT

Pz	art.	Descrizione / Description
1	H43307(-..)	CERNIERA TRE ALI / THREE WINGS HINGE
1	H43606	KIT DI FISSAGGIO CERNIERE TRE ALI / THREE WINGS HINGES FIXING KIT

Pz	art.	Descrizione / Description
1	H43311(-..)	CERNIERA TRE ALI / THREE WINGS HINGE
1	H43606	KIT DI FISSAGGIO CERNIERE TRE ALI / THREE WINGS HINGES FIXING KIT

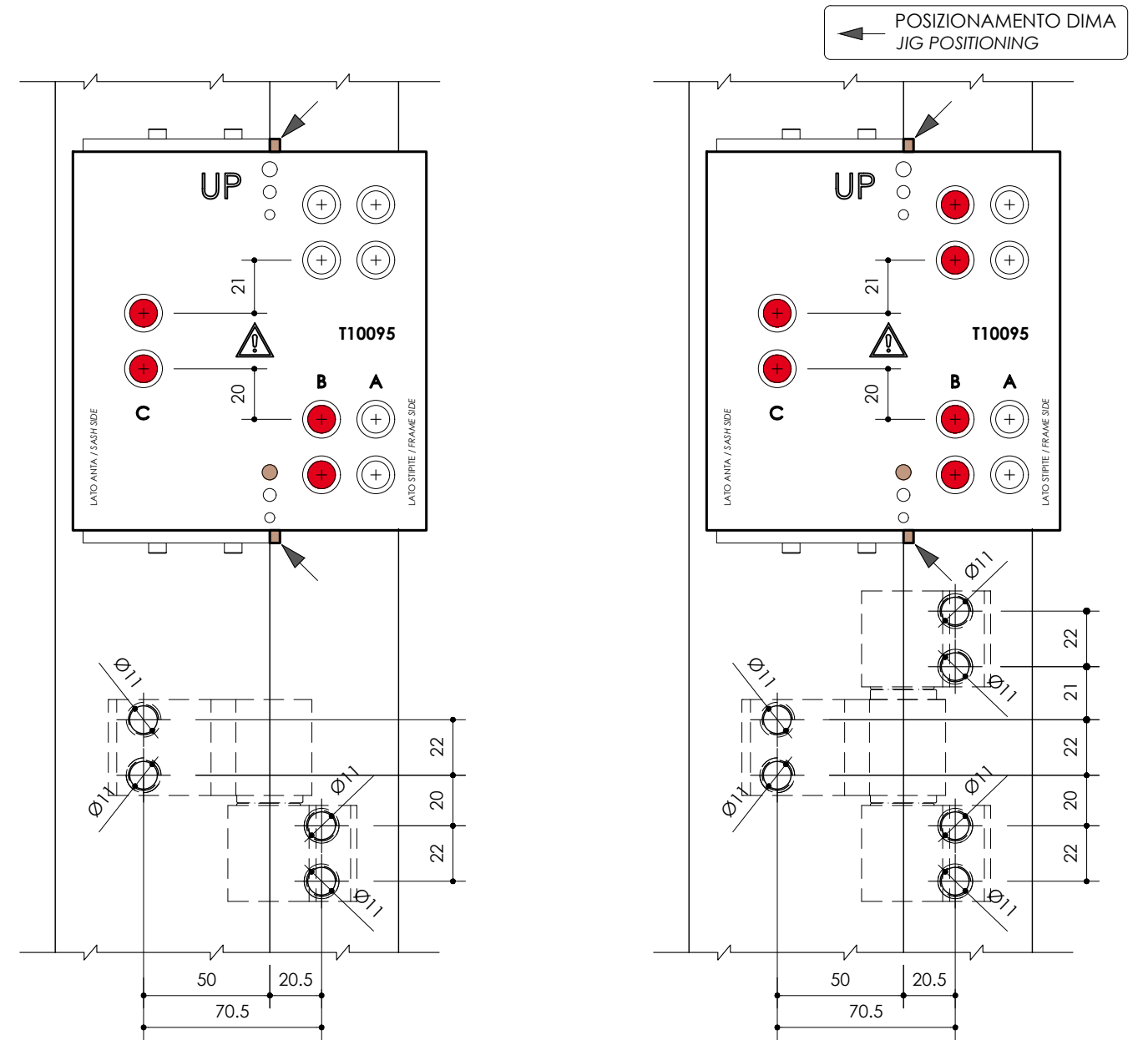
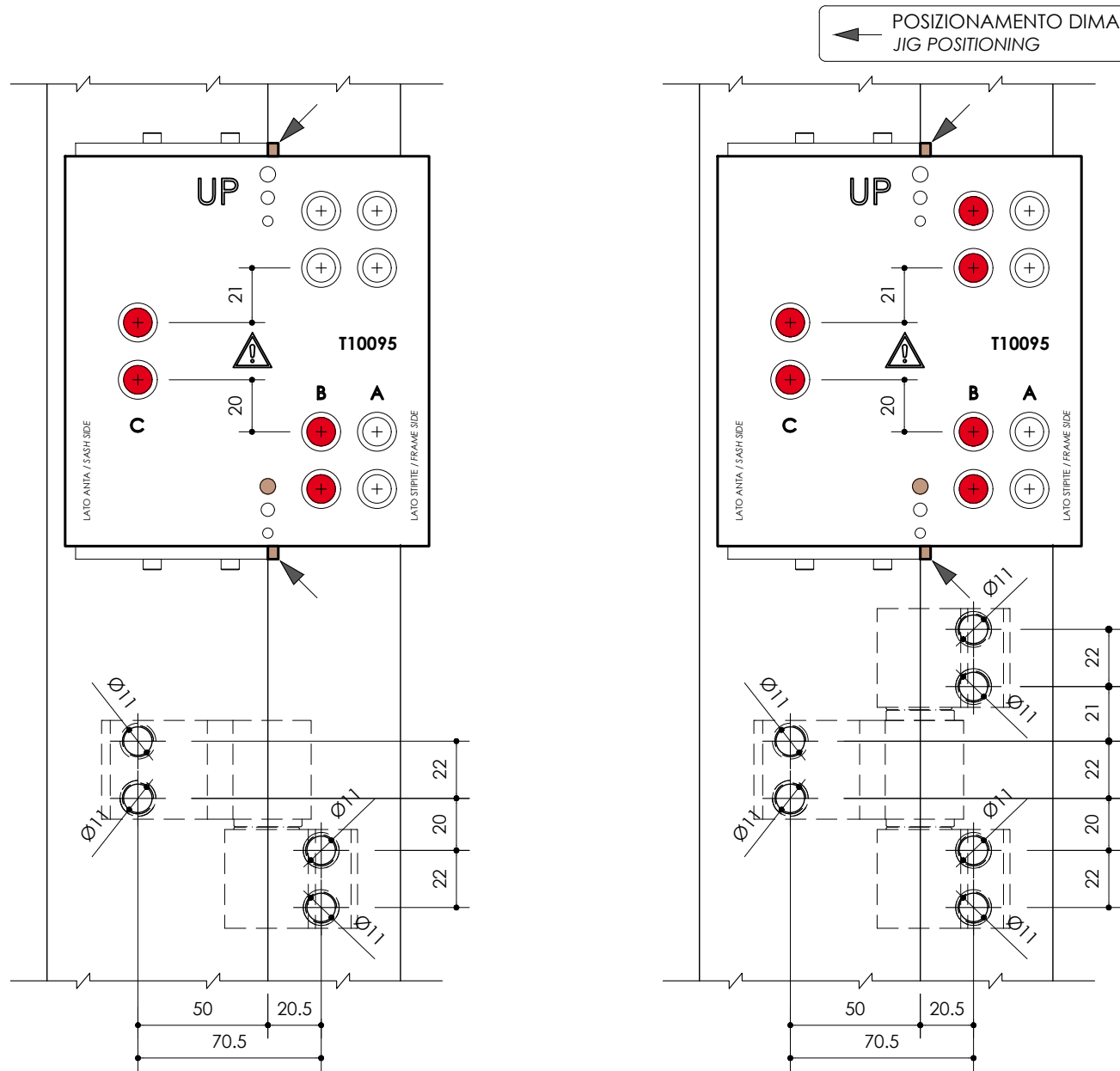


MONTAGGIO CERNIERE, APERTURA INTERNA
HINGE ASSEMBLING DIAGRAM, INTERNAL OPENING

C45K-NI C55K-NI

MONTAGGIO CERNIERE, APERTURA ESTERNA
HINGE ASSEMBLING DIAGRAM, EXTERNAL OPENING

C45K-NI C55K-NI

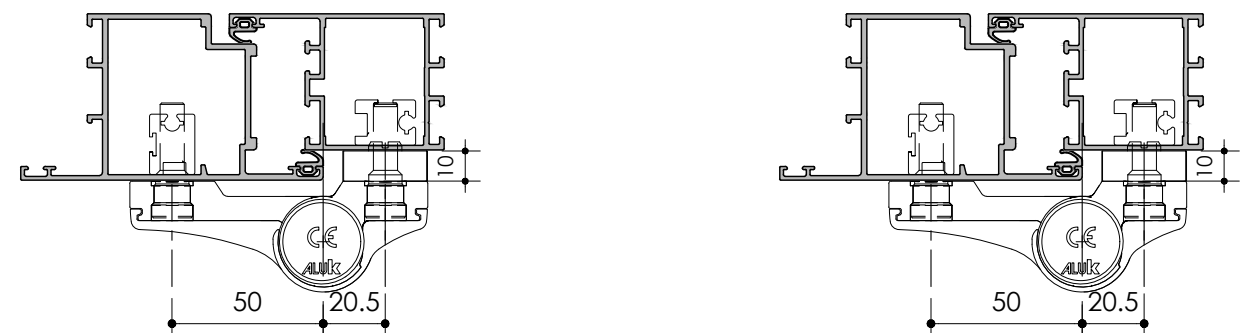
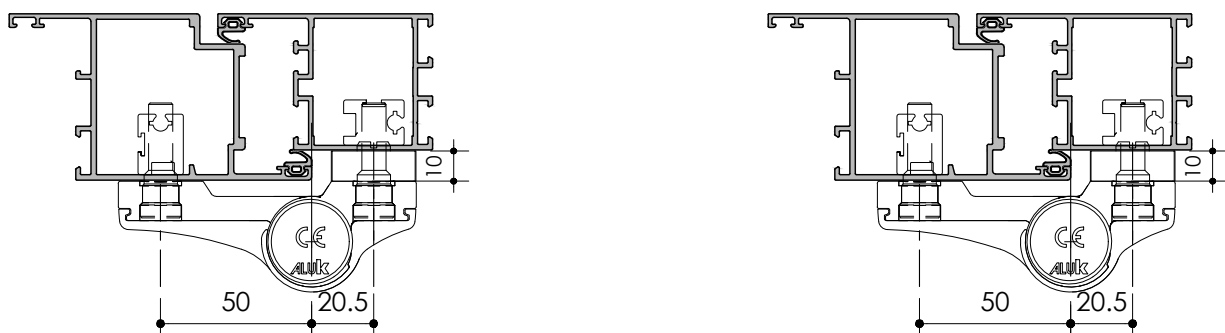


Pz	art.	Descrizione / Description
1	H43306(-..)	CERNIERA DUE ALI / TWO WINGS HINGE
1	H43605	KIT DI FISSAGGIO CERNIERA DUE ALI / TWO WINGS HINGE FIXING KIT
1	H43909(-..)	SPESSORE 10 mm / THK 10 mm SPACER

Pz	art.	Descrizione / Description
1	H43306(-..)	CERNIERA DUE ALI / TWO WINGS HINGE
1	H43605	KIT DI FISSAGGIO CERNIERA DUE ALI / TWO WINGS HINGE FIXING KIT
1	H43909(-..)	SPESSORE 10 mm / THK 10 mm SPACER

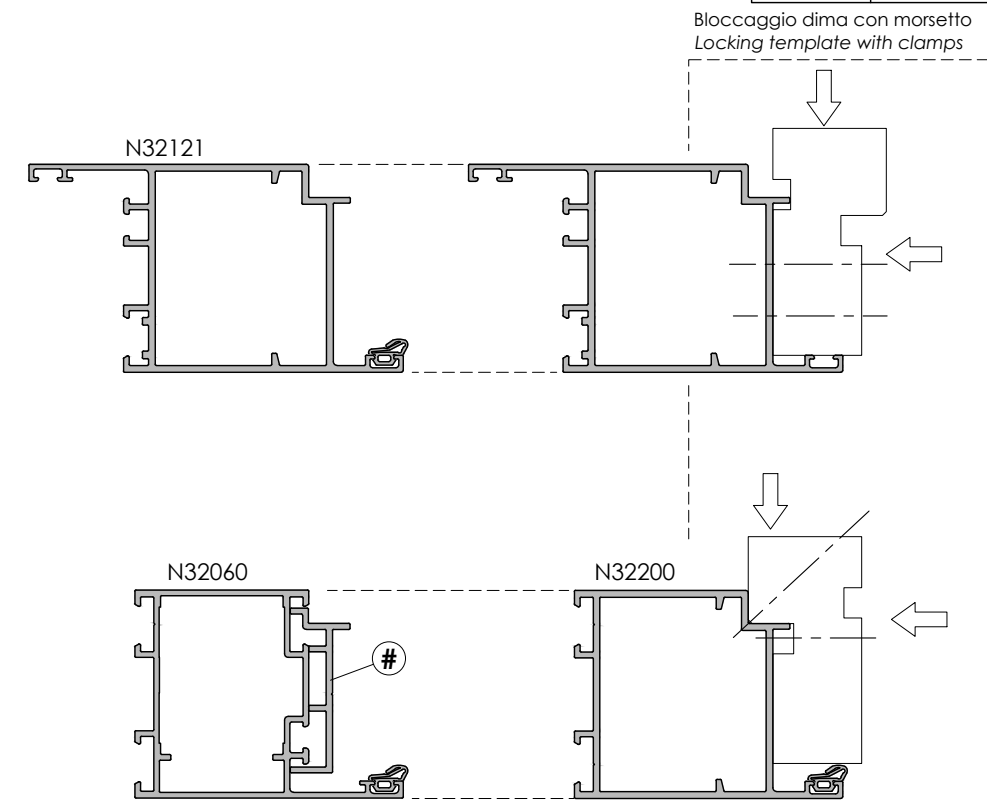
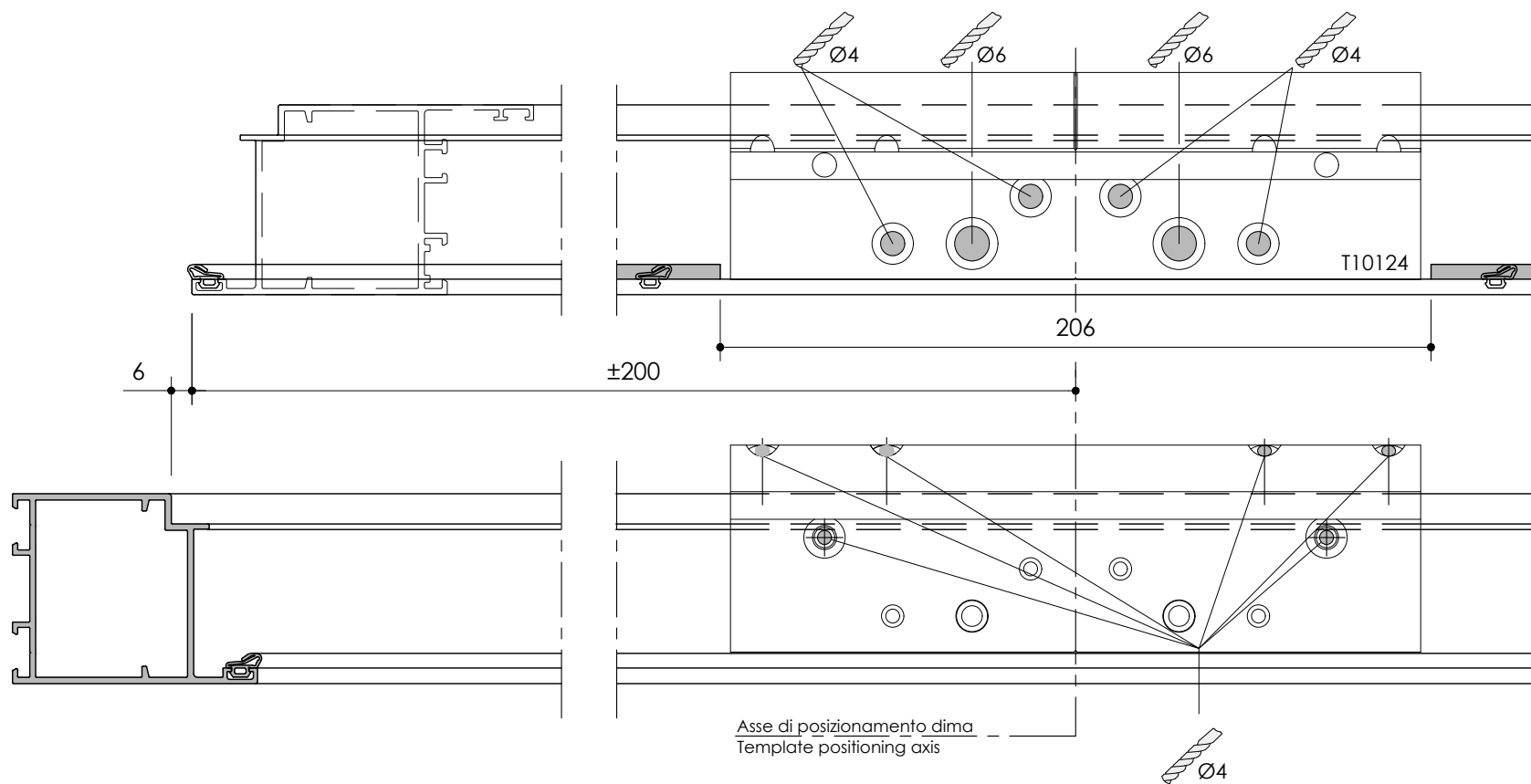
Pz	art.	Descrizione / Description
1	H43307(-..)	CERNIERA TRE ALI / THREE WINGS HINGE
1	H43606	KIT DI FISSAGGIO CERNIERA TRE ALI / THREE WINGS HINGE FIXING KIT
2	H43909(-..)	SPESSORE 10 mm / THK 10 mm SPACER

Pz	art.	Descrizione / Description
1	H43307(-..)	CERNIERA TRE ALI / THREE WINGS HINGE
1	H43606	KIT DI FISSAGGIO CERNIERA TRE ALI / THREE WINGS HINGE FIXING KIT
2	H43909(-..)	SPESSORE 10 mm / THK 10 mm SPACER



SCHEMA MONTAGGIO CERNIERE A STELO art. H59314 - APERTURA INTERNA
BUTT HINGE art. H59314 ASSEMBLING DIAGRAM - INWARD OPENING

C45K-NI	C55K-NI
	●

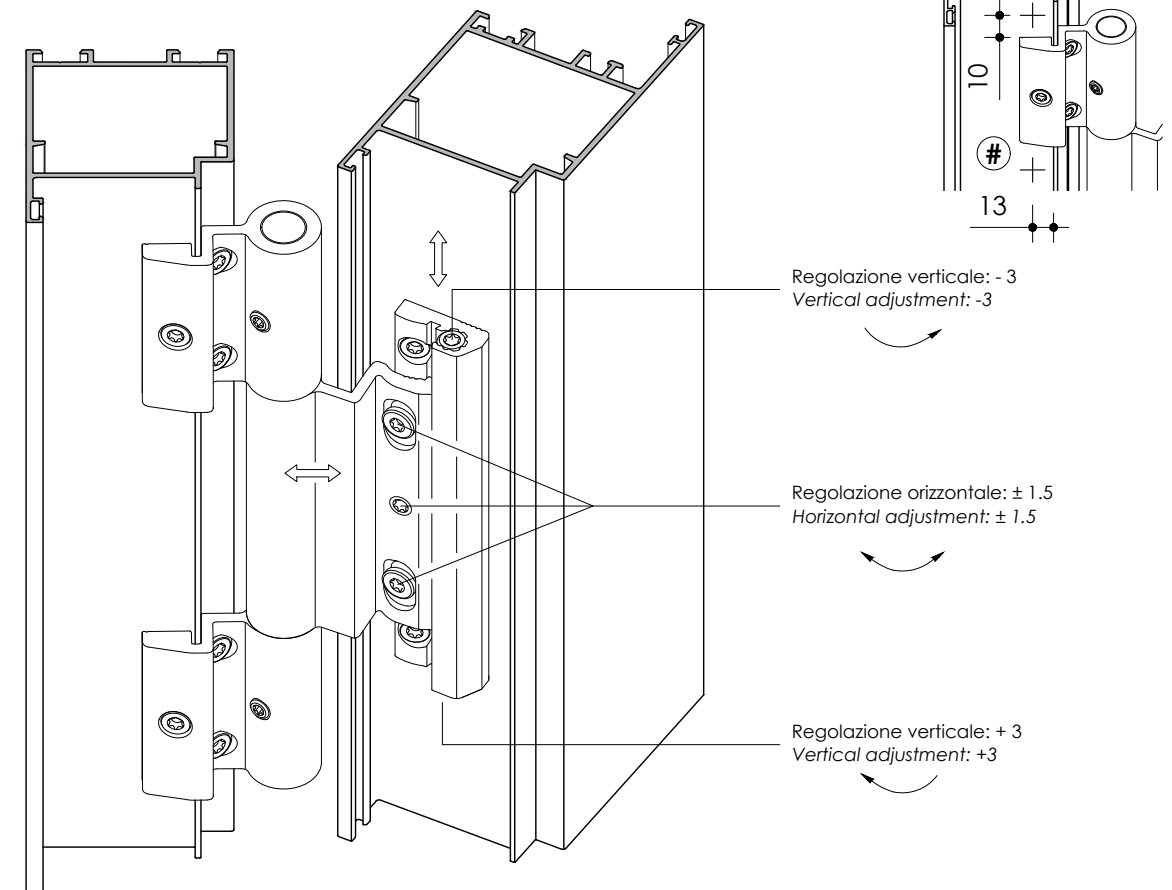
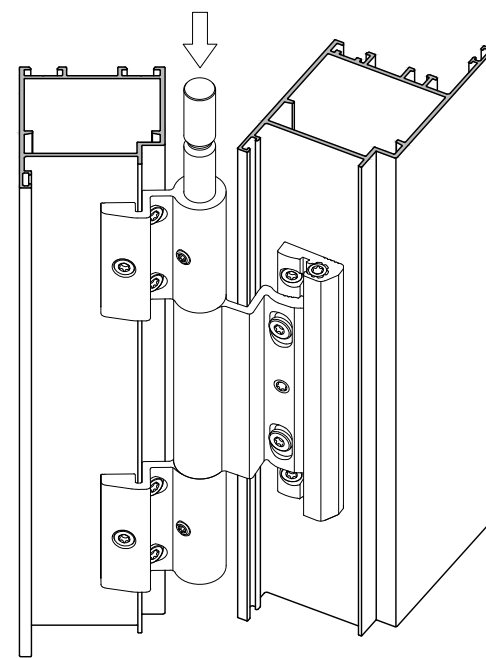
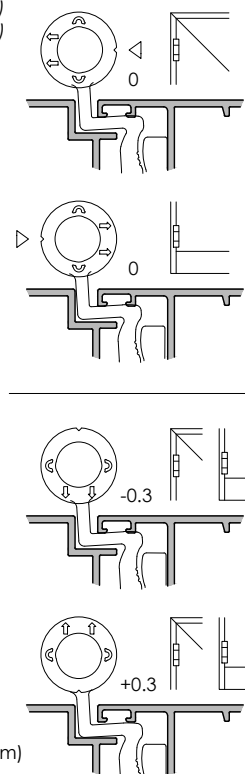
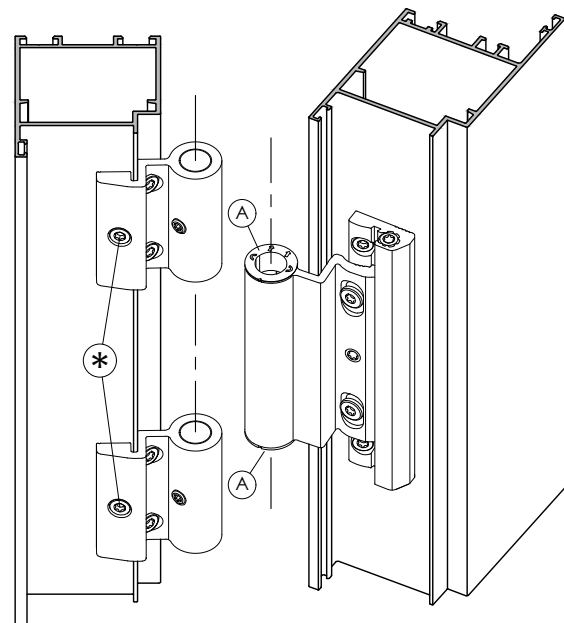


In prossimità della cerniera si raccomanda di intensificare i fissaggi del profilo aggiuntivo
 In the vicinity of the hinge it is recommended to intensify the fixing of the additional profile

MONTAGGIO CERNIERA - HINGE ASSEMBLY

- 1 - Montare la semicerniera stipite fissando le viti (coppia serraggio 2-3 Nm)
 - 2 - Montare la semicerniera battente fissando le viti (coppia serraggio 2-3 Nm)
 - 3 - Regolare mediante le boccole A la pressione di battuta
- 1 - Fit the jamb half-hinge by fixing the screws (tightening torque 2-3 Nm)
 2 - Fit the wing half-hinge by fixing the screws (tightening torque 2-3 Nm)
 3 - Use the bushes A to adjust the stop pressure

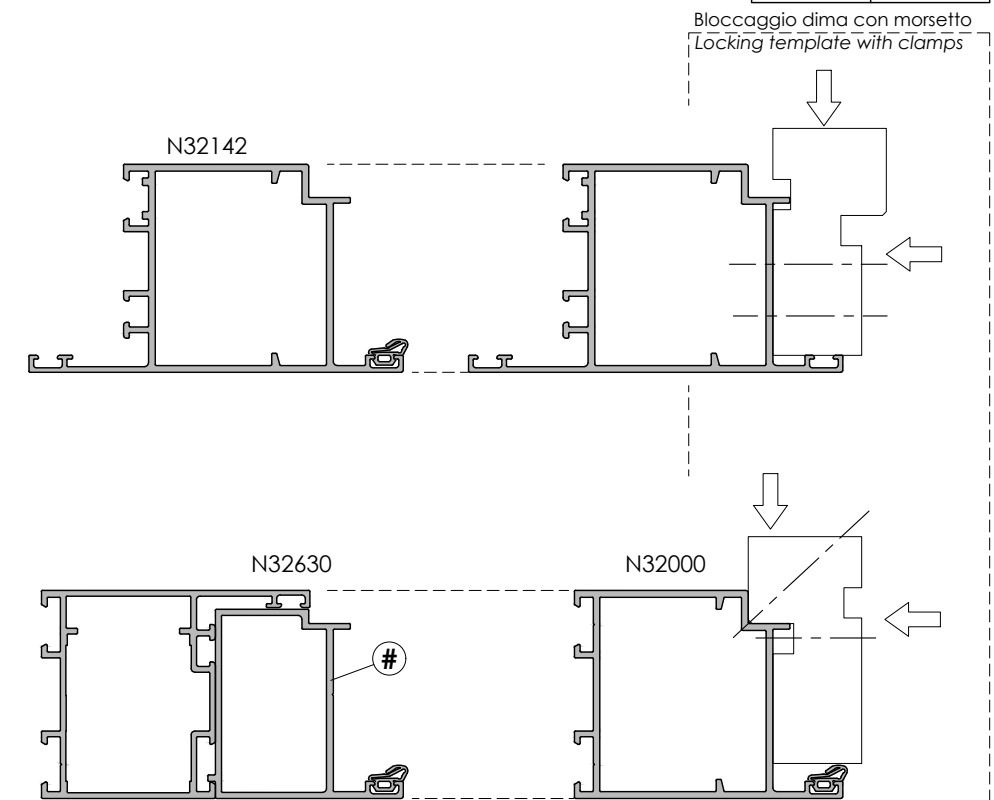
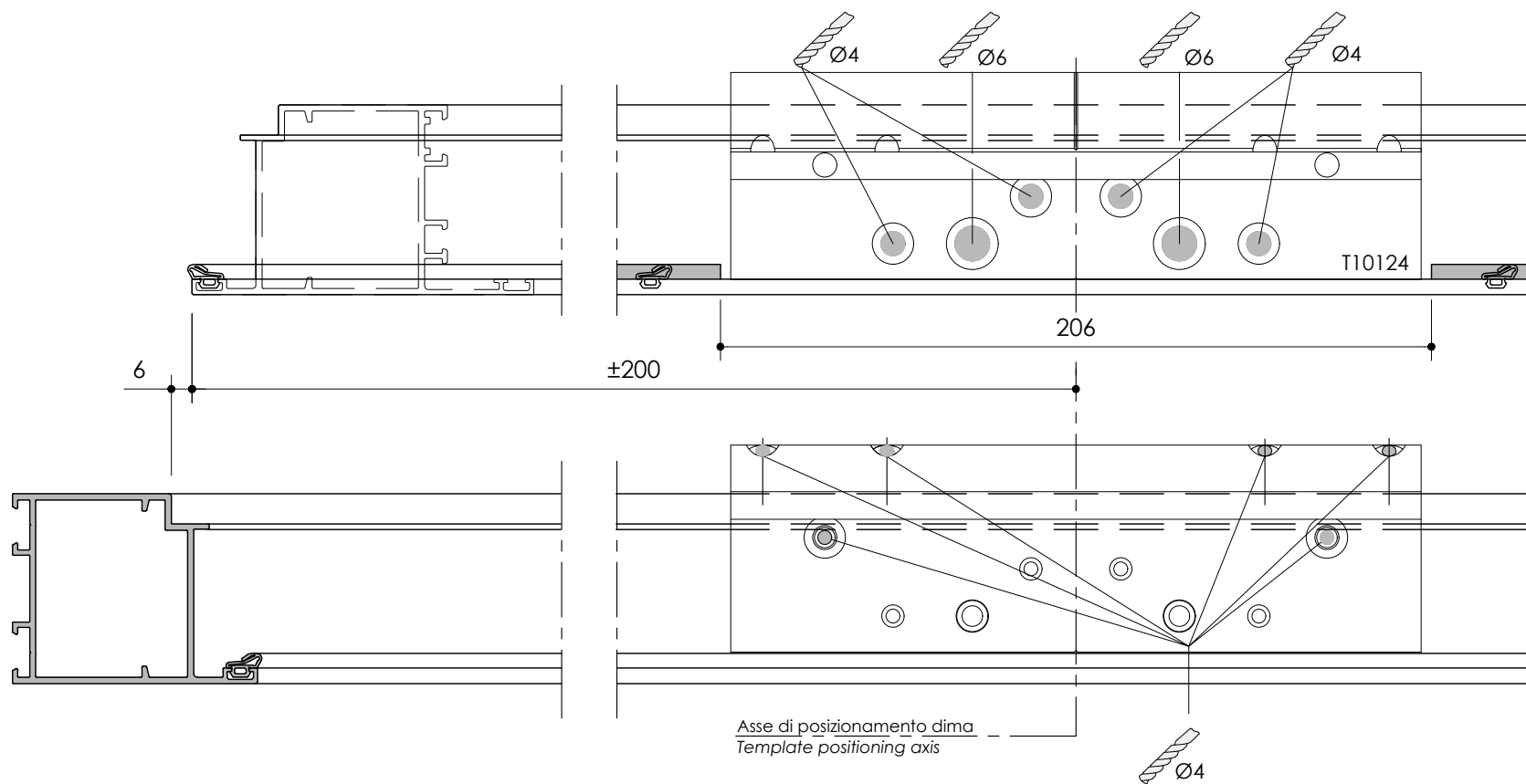
- 3 - Accostare le semicerniere, inserire il perno
 - 4 - Fissare il perno con il grano
- 3 - Pull the half-hinges together, insert the pin
 4 - Fix the pin with the screw



* Utilizzare le viti più lunghe presenti nel kit (coppia serraggio 4-5 Nm)
 Use the longer screws in the kit (tightening torque 4-5 Nm)

SCHEMA MONTAGGIO CERNIERE A STELO art. H59314 - APERTURA ESTERNA
BUTT HINGE art. H59314 ASSEMBLING DIAGRAM - OUTWARD OPENING

C45K-NI	C55K-NI
	●



In prossimità della cerniera si raccomanda di intensificare i fissaggi del profilo aggiuntivo
 In the vicinity of the hinge it is recommended to intensify the fixing of the additional profile

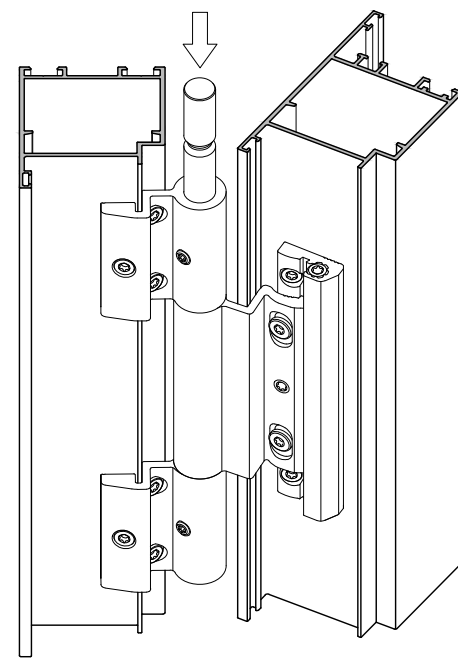
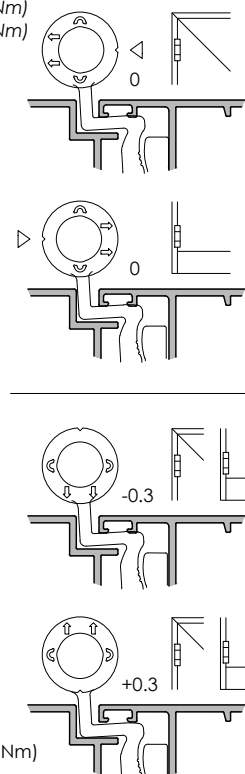
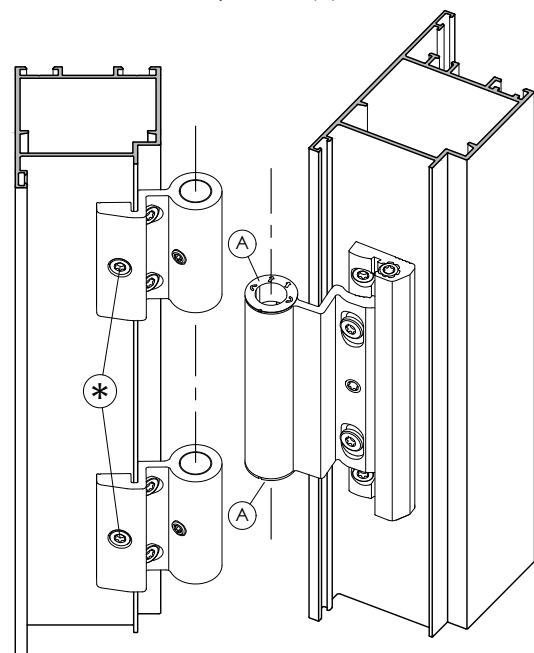
MONTAGGIO CERNIERA - HINGE ASSEMBLY

- 1 - Montare la semicerniera stipite fissando le viti (coppia serraggio 2-3 Nm)
- 2 - Montare la semicerniera battente fissando le viti (coppia serraggio 2-3 Nm)
- 3 - Regolare mediante le boccole A la pressione di battuta

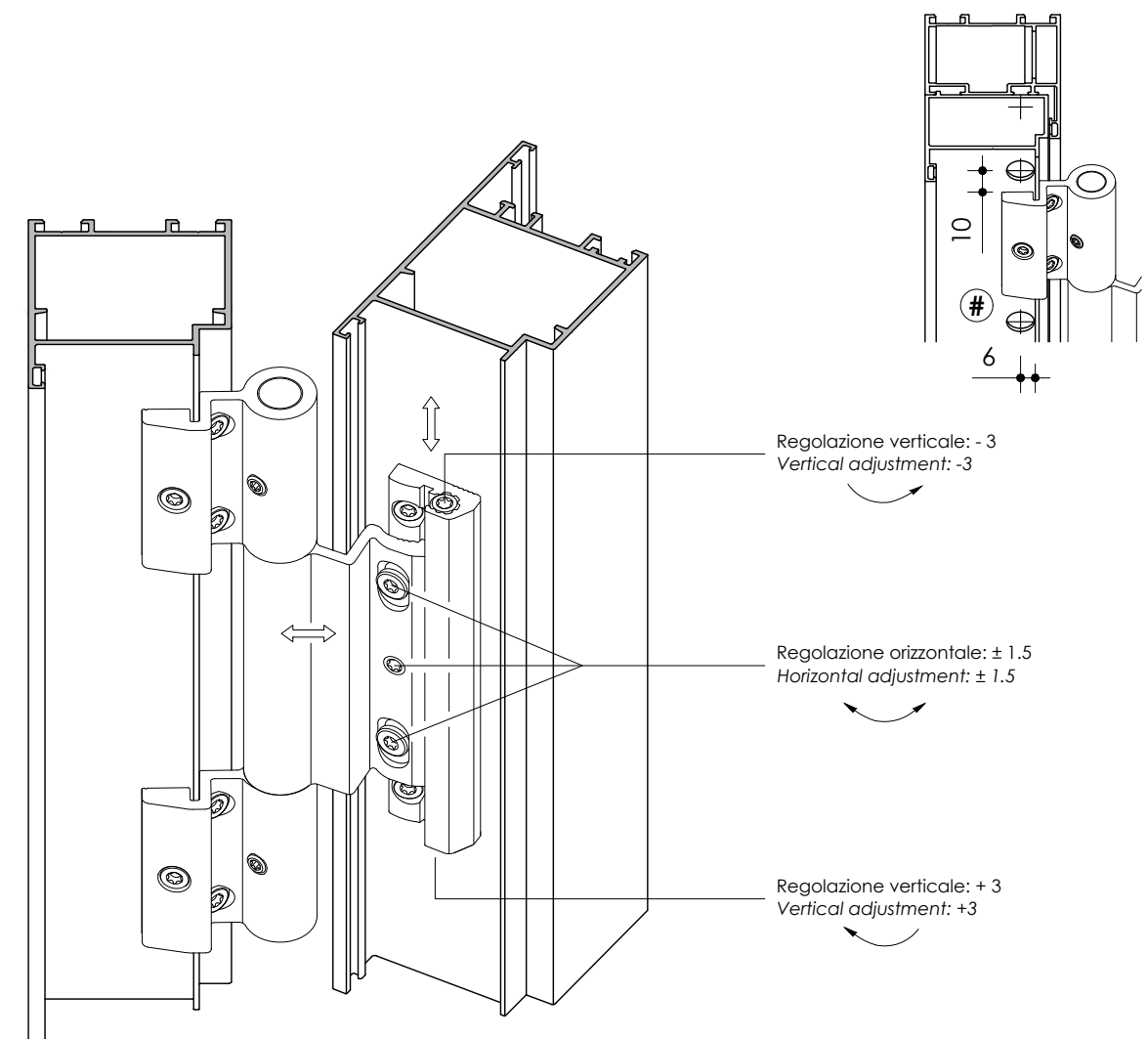
- 1 - Fit the jamb half-hinge by fixing the screws (tightening torque 2-3 Nm)
- 2 - Fit the wing half-hinge by fixing the screws (tightening torque 2-3 Nm)
- 3 - Use the bushes A to adjust the stop pressure

- 3 - Accostare le semicerniere, inserire il perno
- 4 - Fissare il perno con il grano

- 3 - Pull the half-hinges together, insert the pin
- 4 - Fix the pin with the screw



* Utilizzare le viti più lunghe presenti nel kit (coppia serraggio 4-5 Nm)
 Use the longer screws in the kit (tightening torque 4-5 Nm)



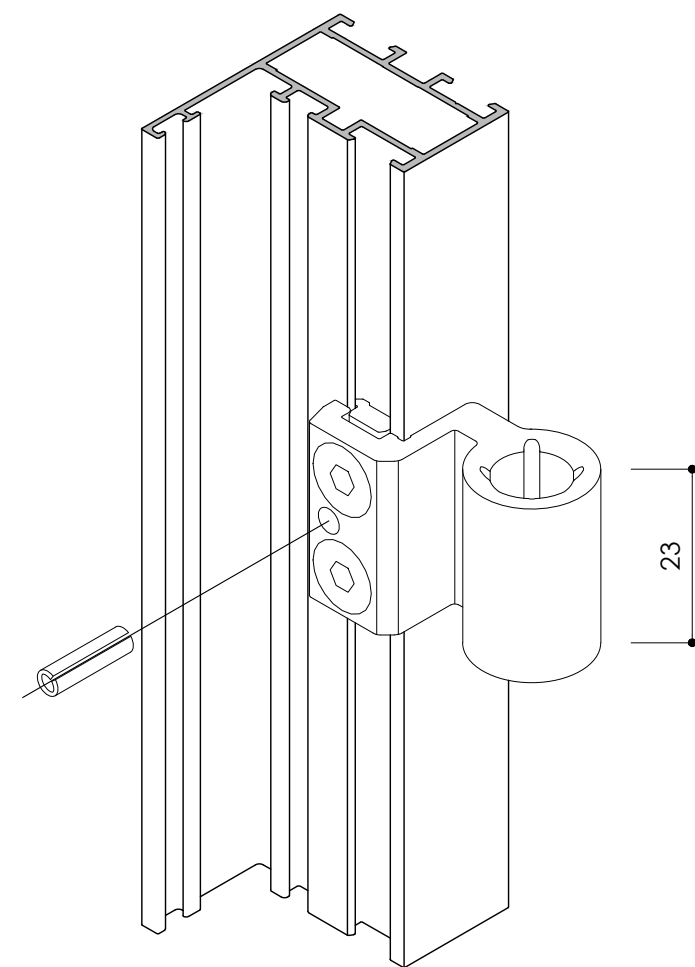
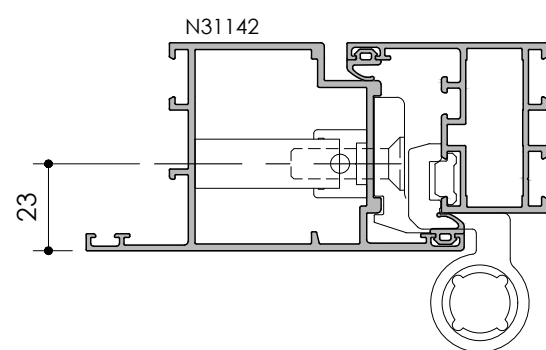
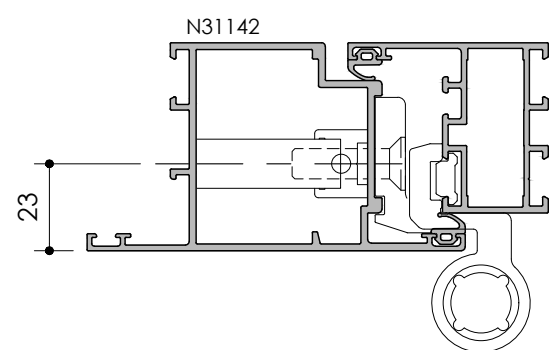
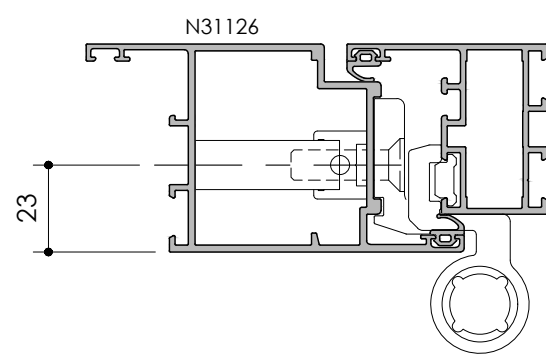
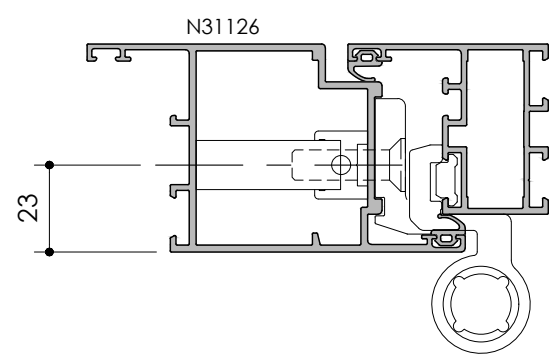
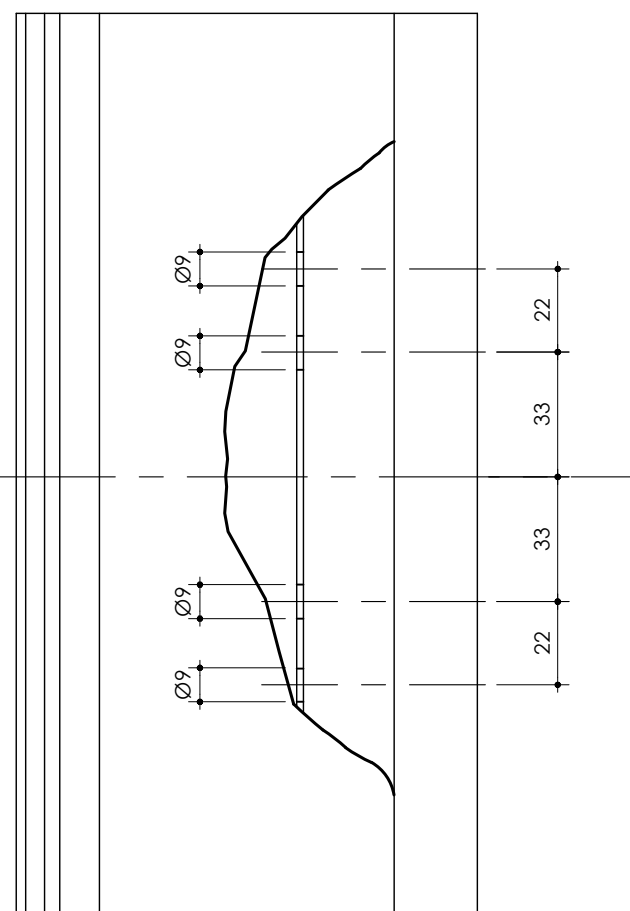
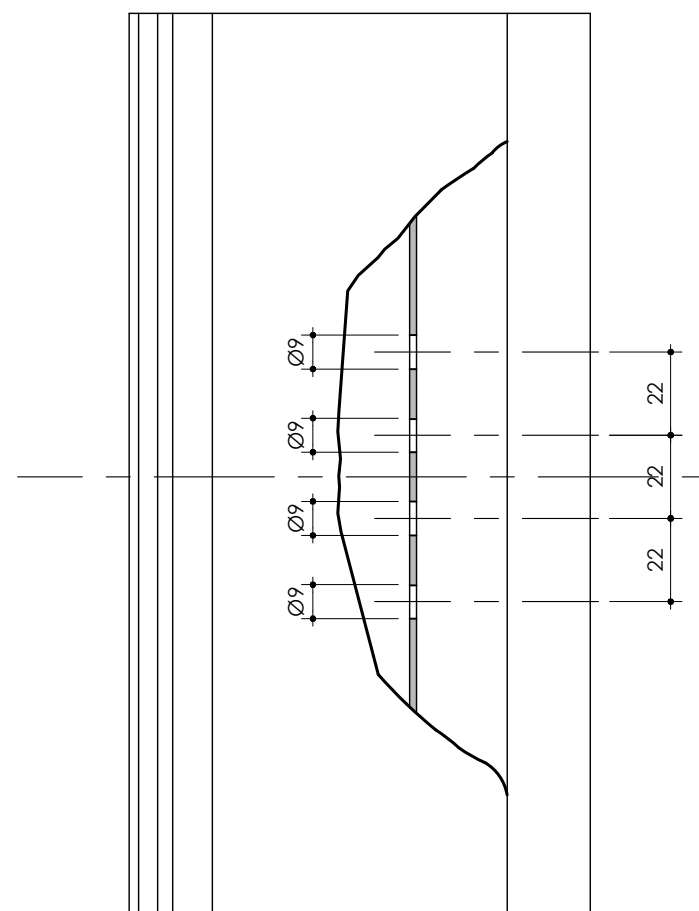
Regolazione verticale: -3
 Vertical adjustment: -3

Regolazione orizzontale: ± 1.5
 Horizontal adjustment: ± 1.5

Regolazione verticale: +3
 Vertical adjustment: +3

H48357 CERNIERA A DUE ALI
 DOUBLE WING HINGE

H48358 CERNIERA A TRE ALI
 THREE WING HINGE



ESEGUIRE UN FORO Ø5 SULLO STIPITE ED INSERIRE LA SPINA ELASTICA IN DOTAZIONE.
 MAKE AN HOLE Ø5 ON THE FIXED FRAME SECTION AND INSERT THE ELASTIC PIN ON EQUIPMENT.

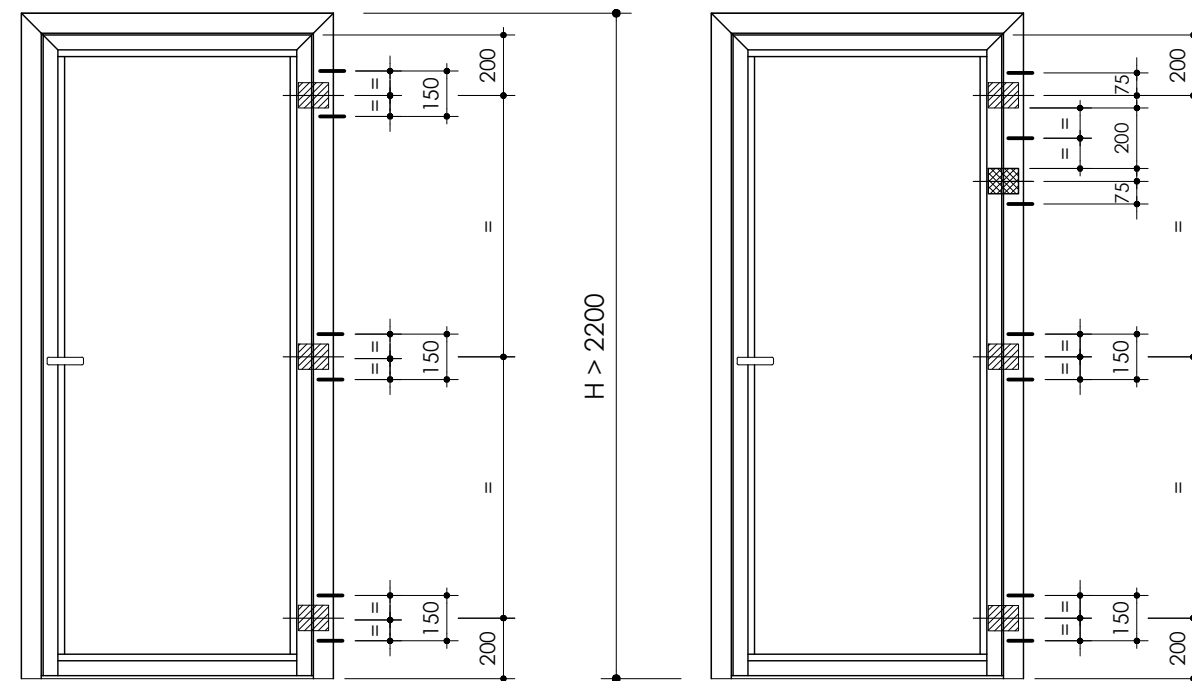
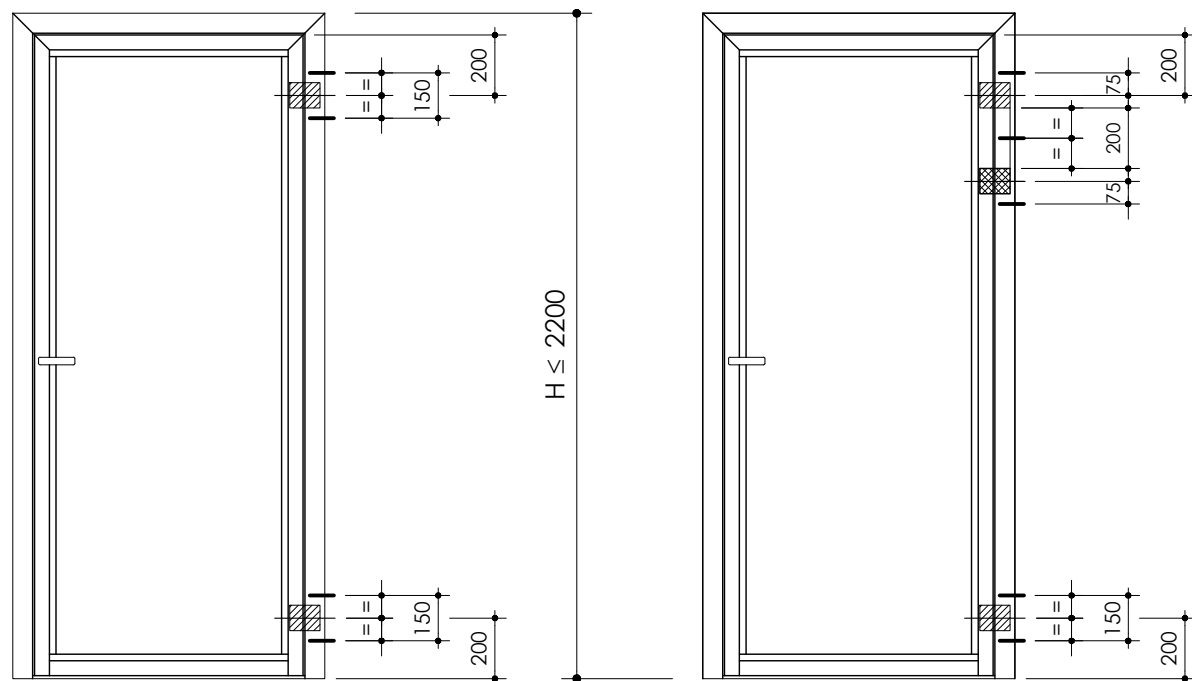
SCHEMI DI FISSAGGIO PORTE, LATO CERNIERE
DOOR FIXING DIAGRAMS, HINGE SIDE

Scegliere la tipologia di porta/configurazione di cerniere da utilizzare, consultando repertorio 1 del catalogo tecnico (dimensioni e portate).

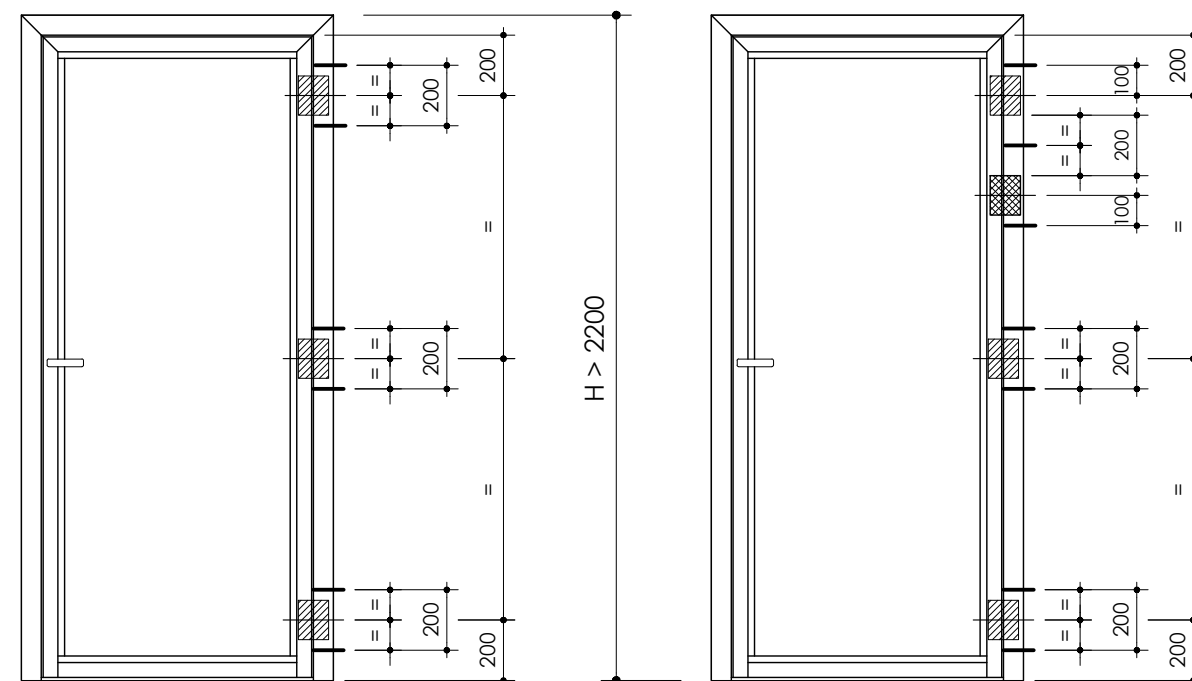
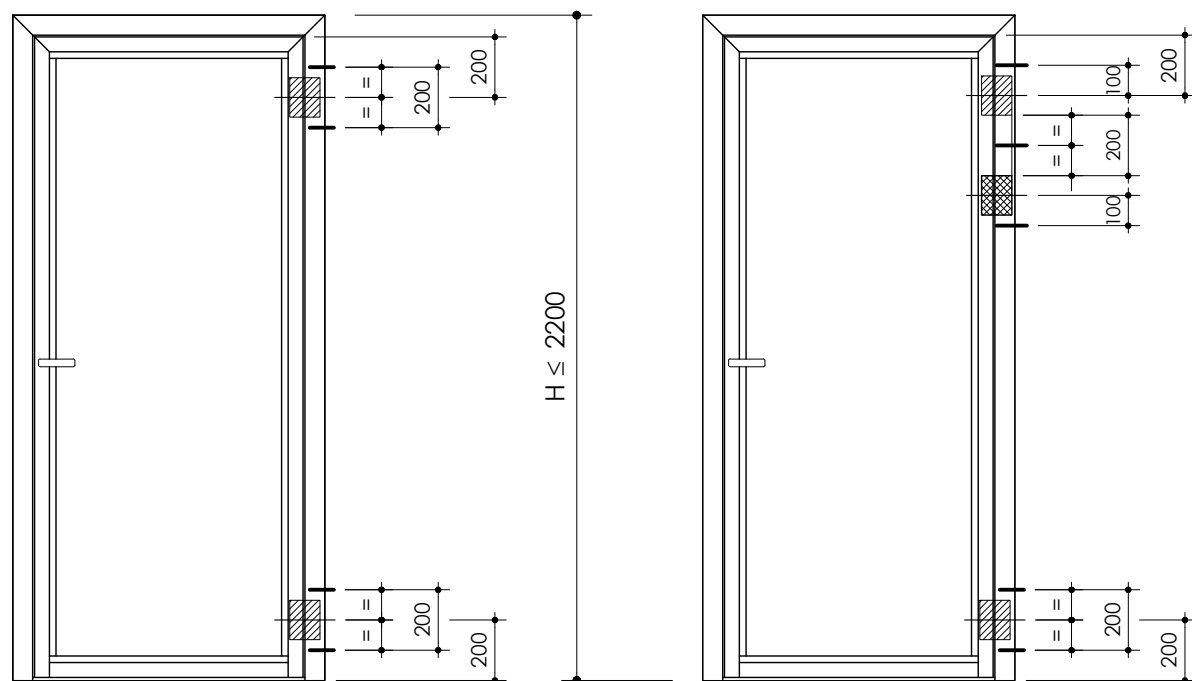
Select the type of door & hinge configuration to be used, by consulting section 1 of the technical catalogue (dimensions and load capacities).

	C45K	C55K
2 ALI	H43306	H43306
	H48357	H43310
3 ALI	H43307	H43307
	H48358	H43311

DUE ALI



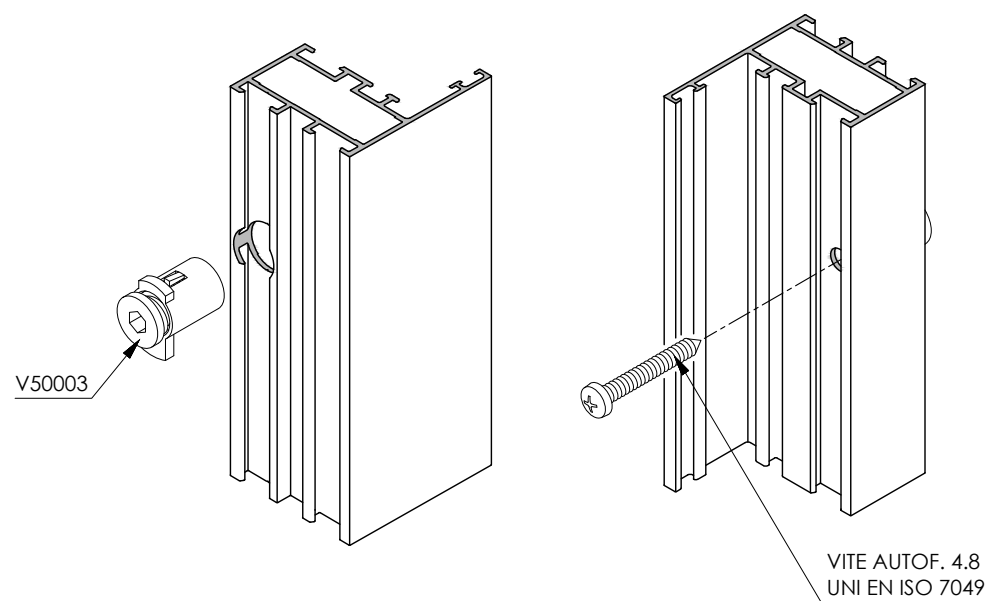
TRE ALI



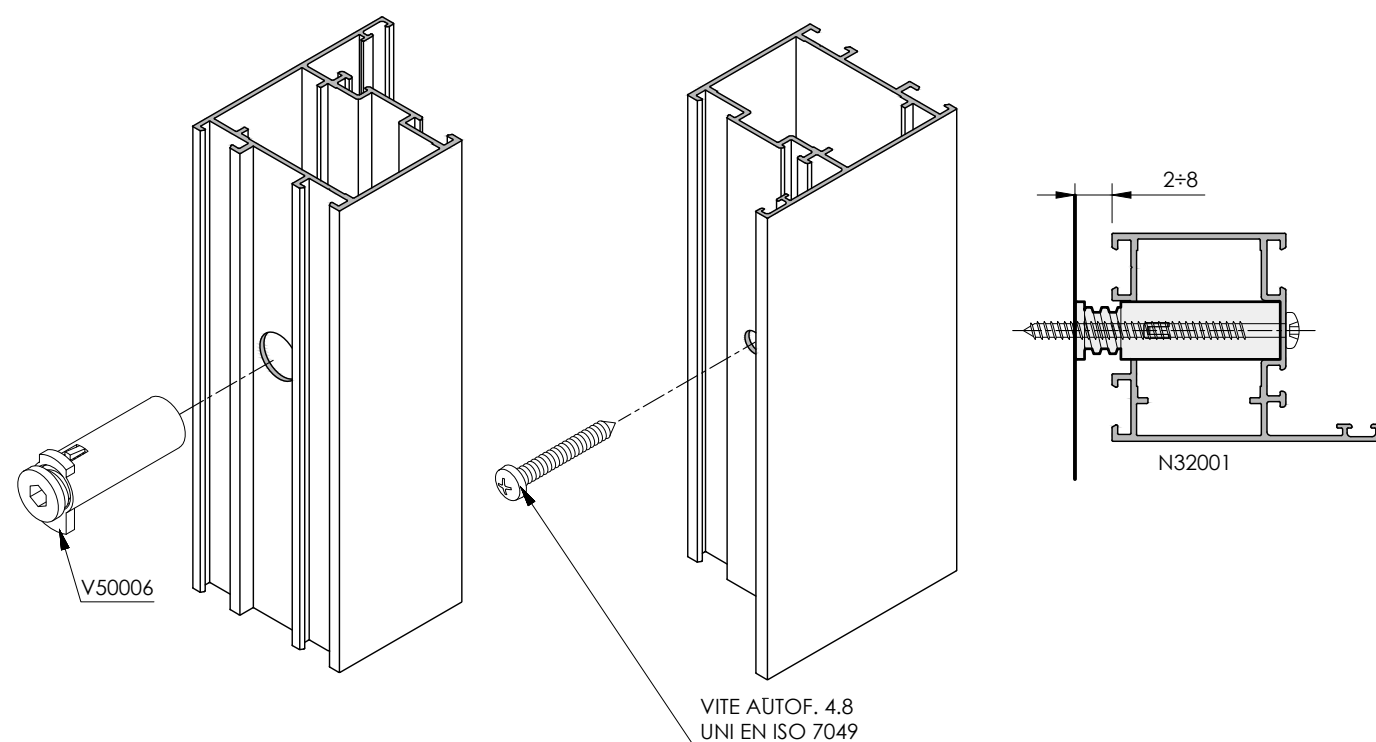
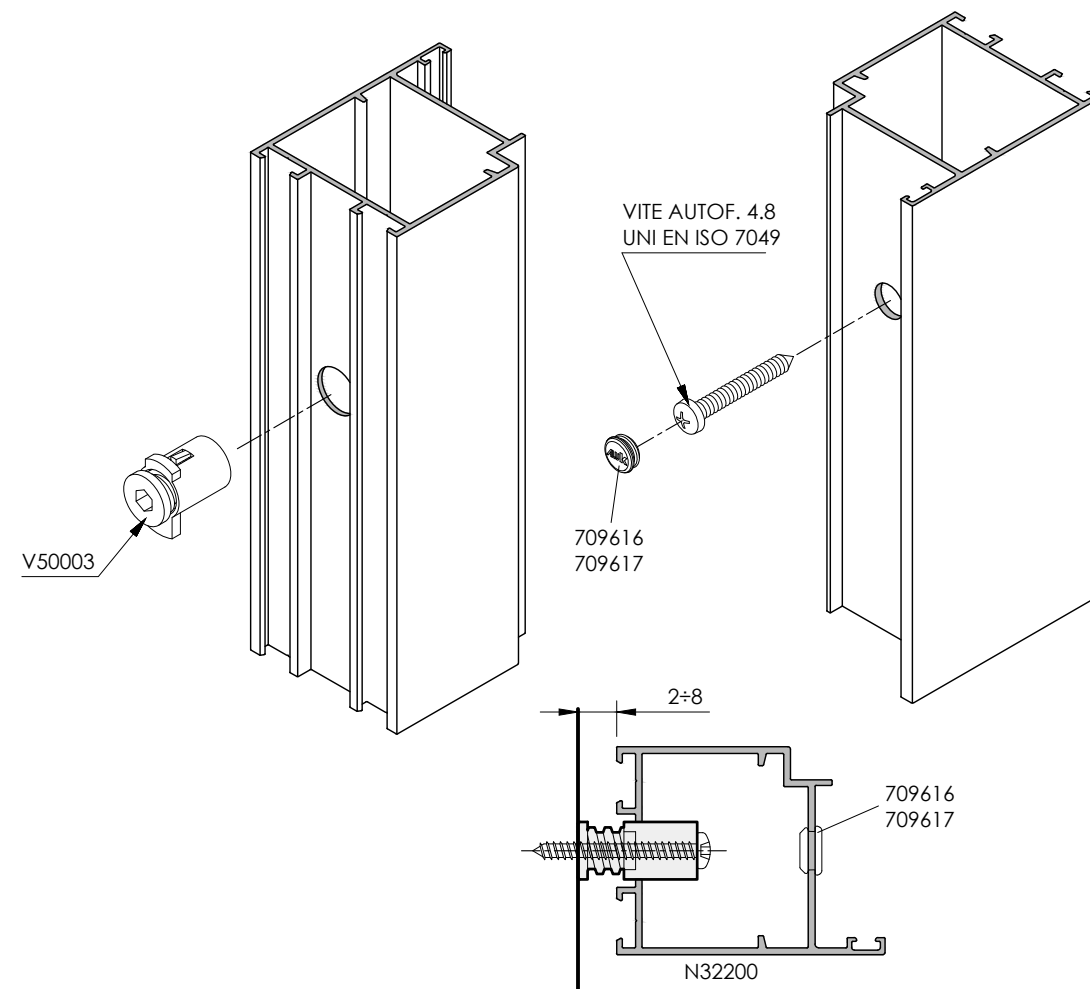
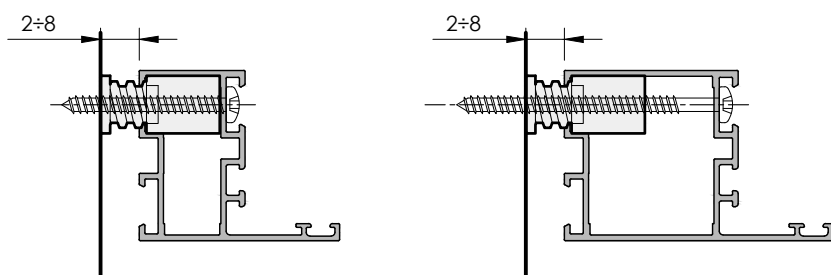
Section 10

Assemblaggio
Assembly

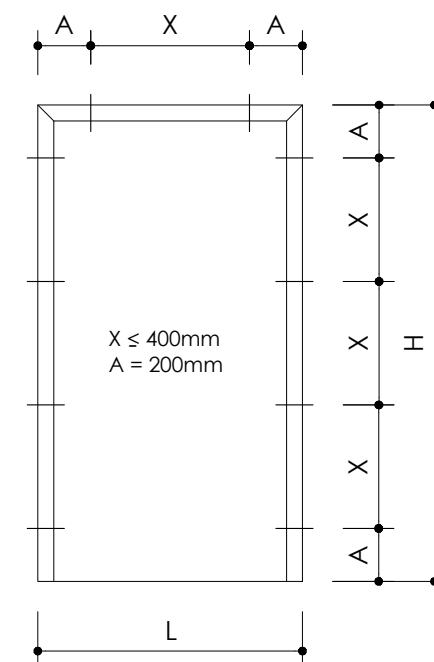
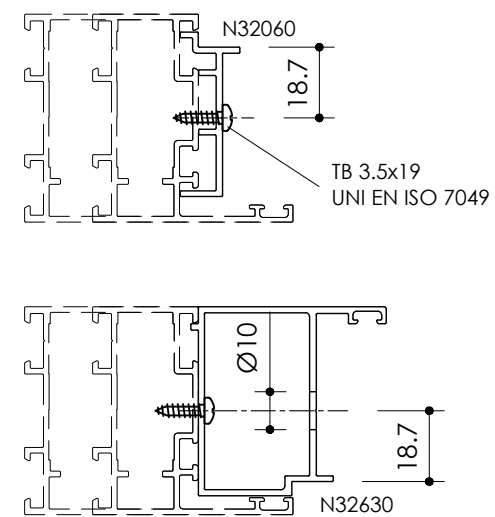
MONTAGGIO REGOLATORI STIPITE
FRAME ADJUSTING BLOCK ASSEMBLING



PROFILI		
C45K	C55K	
N31000	N31040	N32000
N31001	N31002	N32020
N31020	N31023	



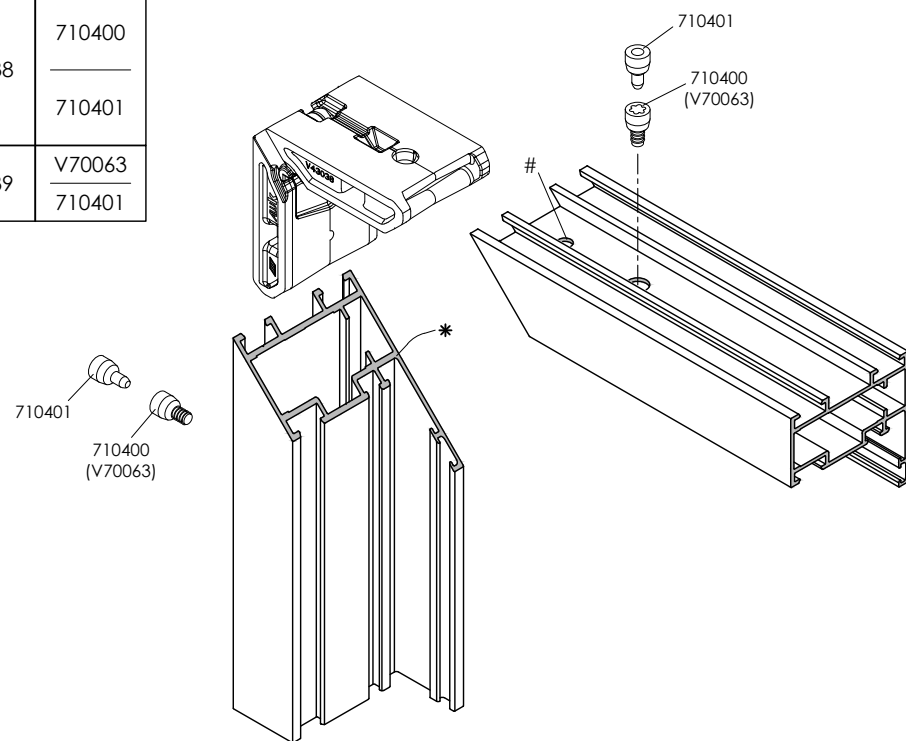
FISSAGGIO PROFILI AGGIUNTIVI
KIXING ADDITIONAL PROFILES



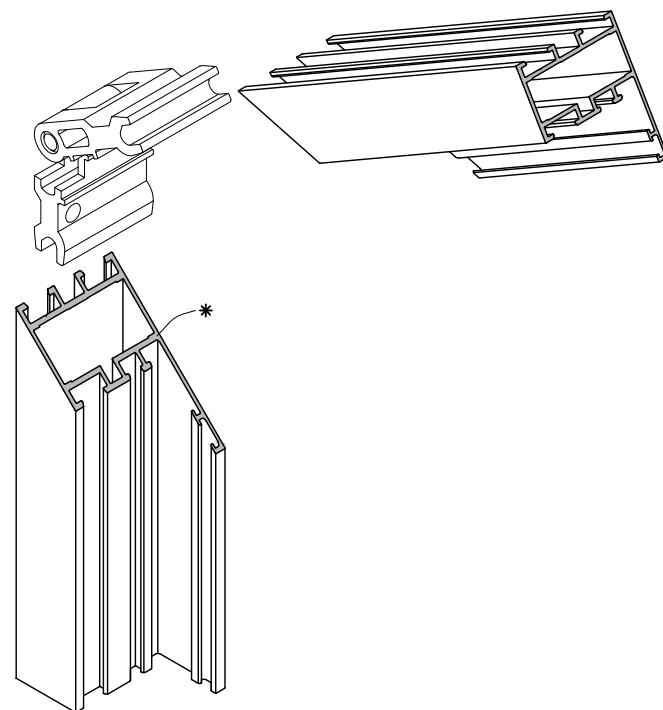
PORTE/DOORS
 INTENSIFICARE I FISSAGGI IN PROSSIMITA' DELLE CERNIERE (VEDI SCHEMI APPLICATIVI CERNIERE)
 INCREASE THE FASTENERS NEAR THE HINGES (SEE HINGES FIXING DIAGRAMS)

ASSEMBLAGGIO SQUADRETTE STIPITE FRAME CORNER JOINT ASSEMBLING

APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT	
C45K	C55K		
N31000	N32000	V43038	710400
N31001	N32020		710401
N31020			
N31040		V43039	V70063
N31002	N32001		710401
N31023			

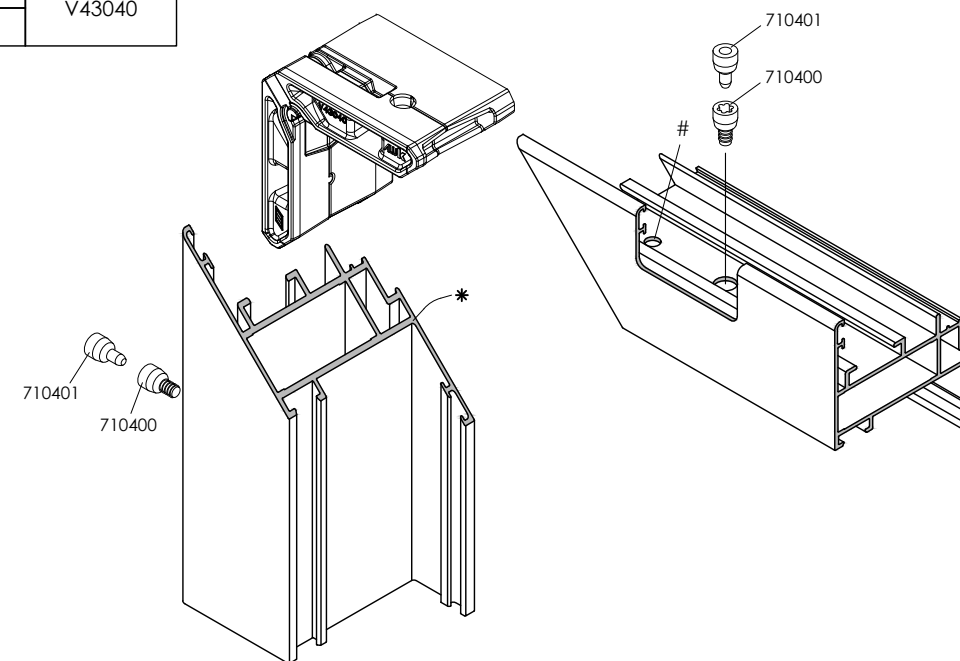


APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT	
C45K	C55K		
N31000	N32000	V42067	
N31001	N32020		
N31020			
N31040			

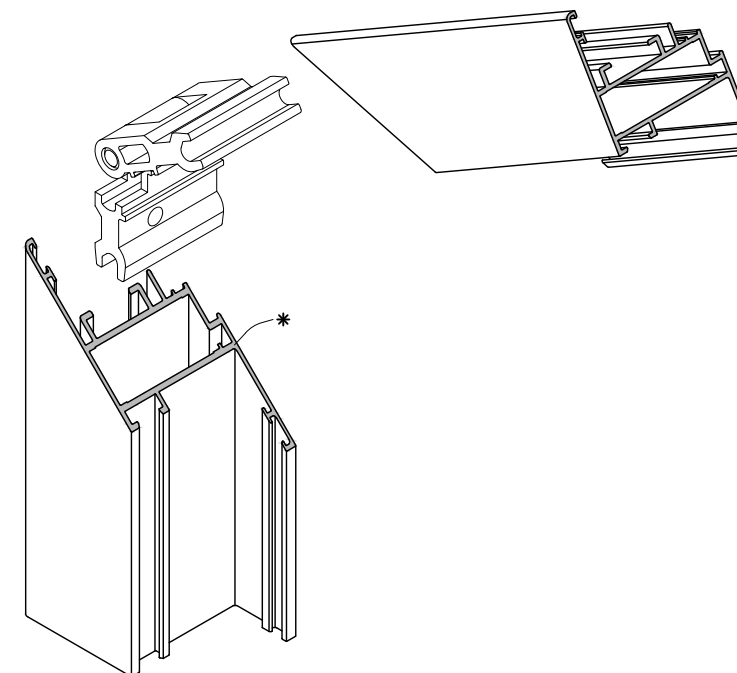


ASSEMBLAGGIO SQUADRETTE PER ANTA SASH CORNER JOINT ASSEMBLING

APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT	
C45K	C55K		
N31120	N32120	V43040	
N31123			



APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT	
C45K	C55K		
N31120	N32120	710123	
N31123			

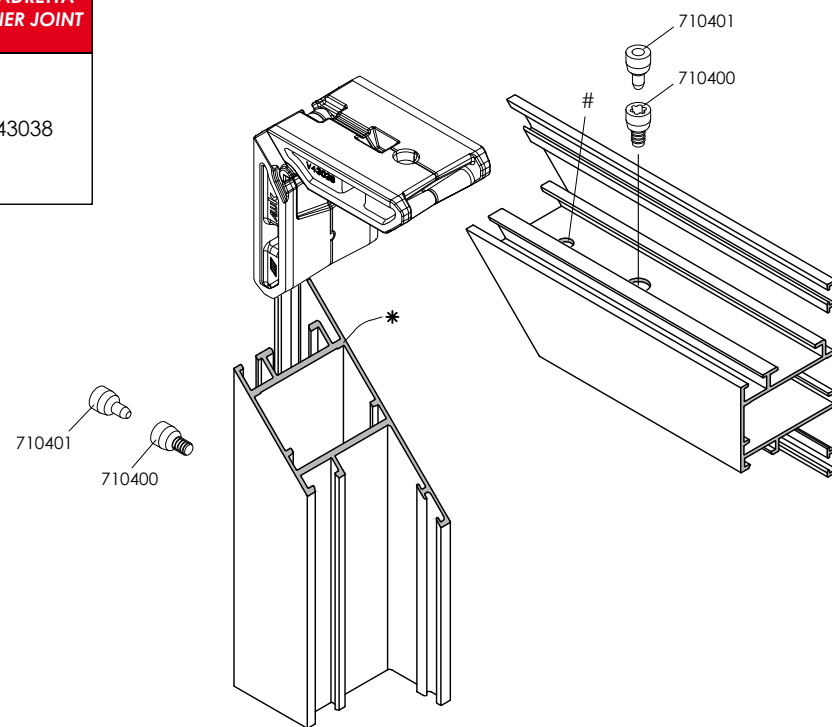


* APPLICARE SIGILLANTE SILICONICO SULLE SUPERFICI DI CONNESSIONE DELL'ANGOLO PRIMA DELL'UNIONE A TELAIO.
APPLY SILICONE SEALING ON CONNECTION CORNER SURFACES BEFORE FRAME ASSEMBLING.

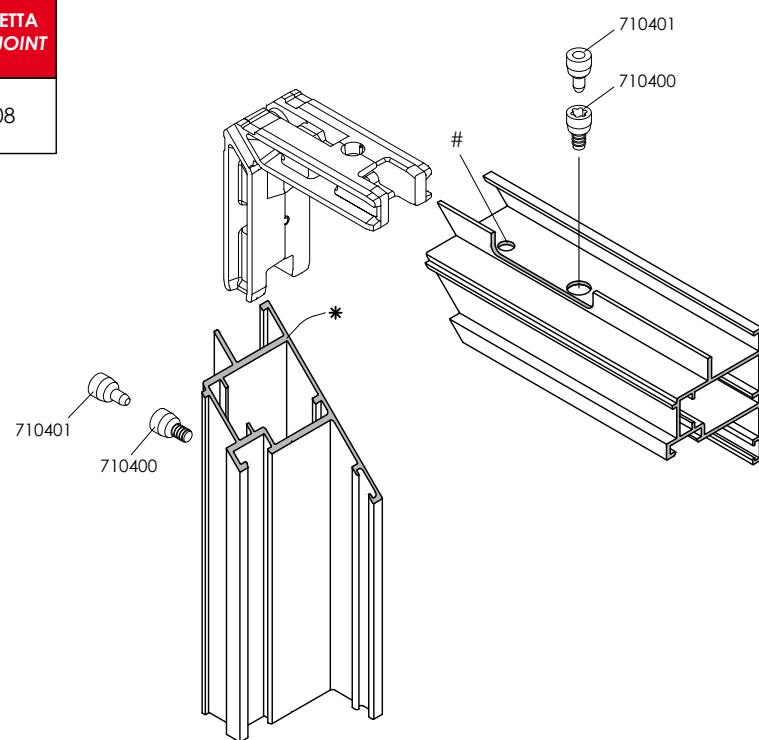
APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI TUBOLARI ATTRAVERSO IL "FORO COLLA"
APPLY EPOXY OR POLYURETHANE GLUE THROUGH "GLUE HOLE"

ASSEMBLAGGIO SQUADRETTE PER ANTA
SASH CORNER JOINT ASSEMBLING

APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT
C45K	C55K	
N31140		V43038
N31141		
N31121		
N31122		

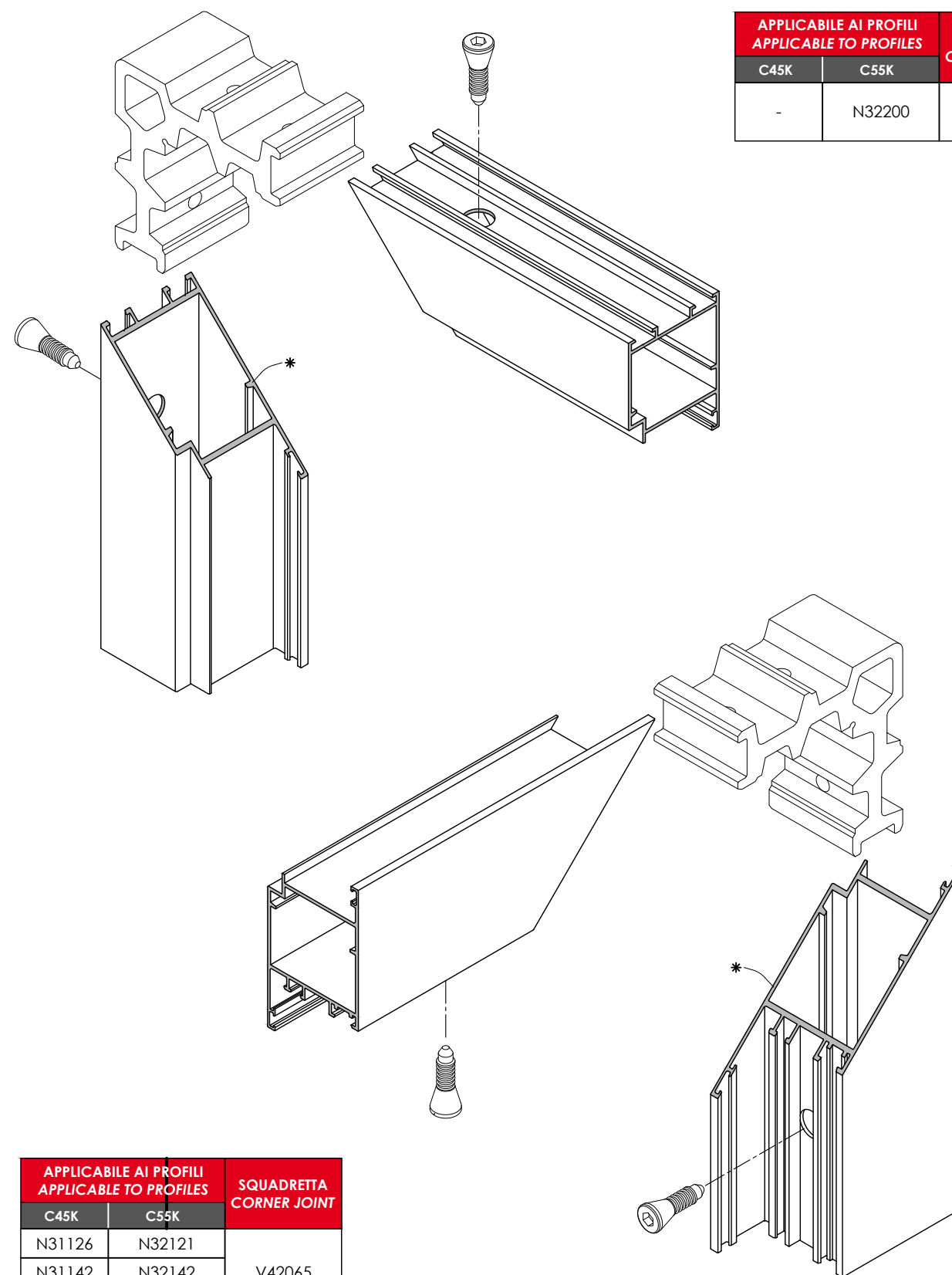


APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT
C45K	C55K	
N31630	-	710408



ASSEMBLAGGIO SQUADRETTE PORTE
DOORS CORNER JOINT ASSEMBLING

APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT
C45K	C55K	
-	N32200	V42065



APPLICABILE AI PROFILI APPLICABLE TO PROFILES		SQUADRETTA CORNER JOINT
C45K	C55K	
N31126	N32121	V42065
N31142	N32142	
	N32300	

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

APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI TUBOLARI ATTRAVERSO IL "FORO COLLA"
APPLY EPOXY OR POLYURETHANE GLUE THROUGH "GLUE HOLE"

CONNESSIONE TRAVERSO, CON STIPITE E BATTENTE
TRANSOM CONNECTION, WITH FRAME AND SASH

Fissaggio con viti
Fixing with screws

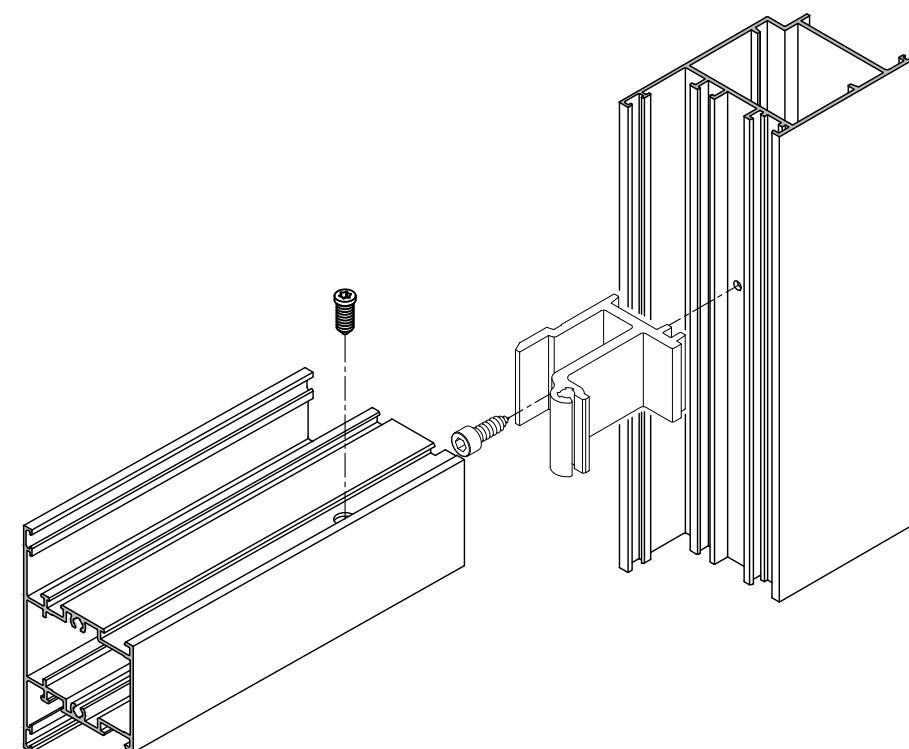
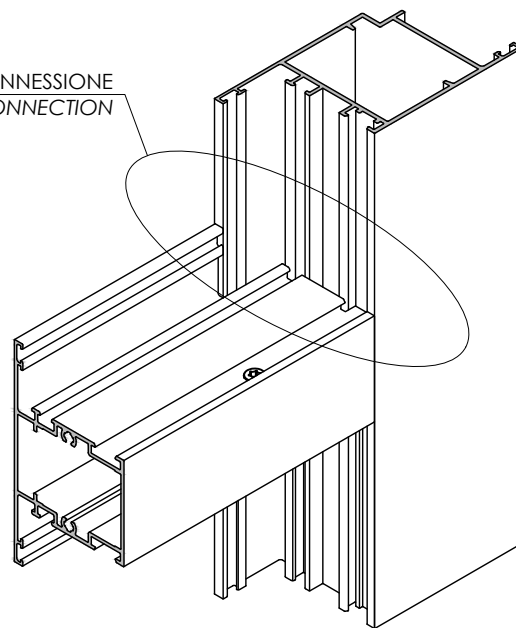
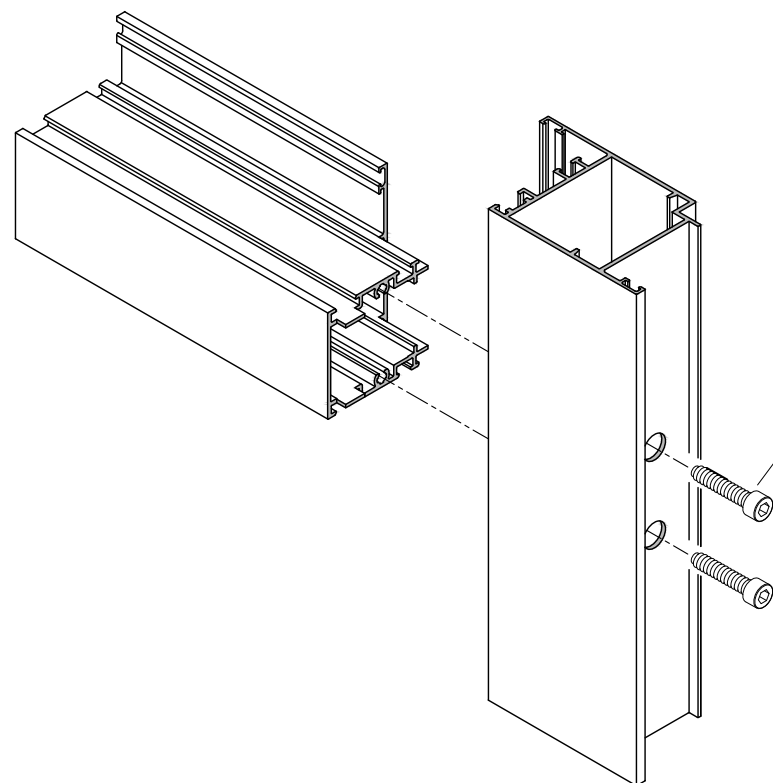
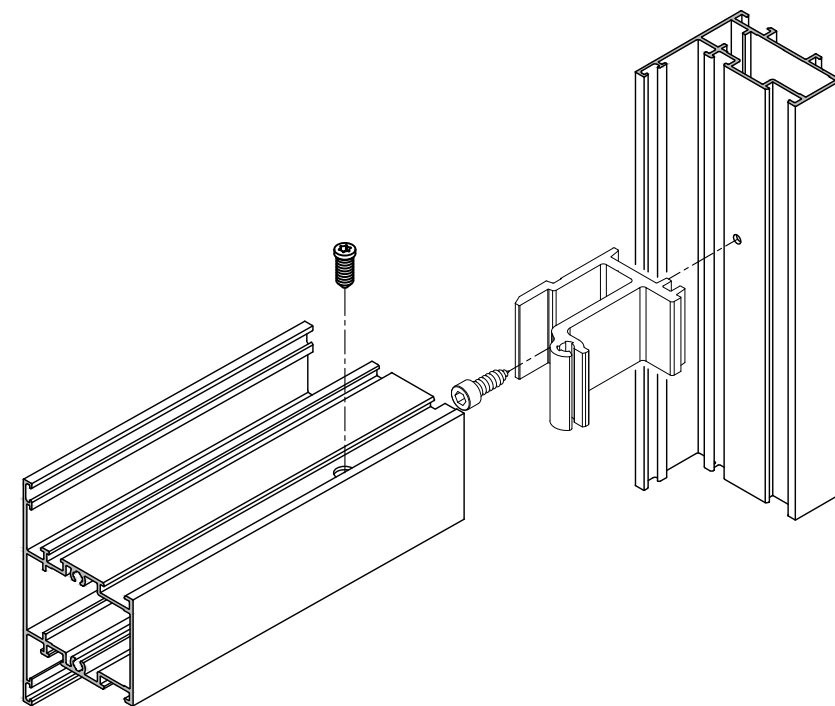
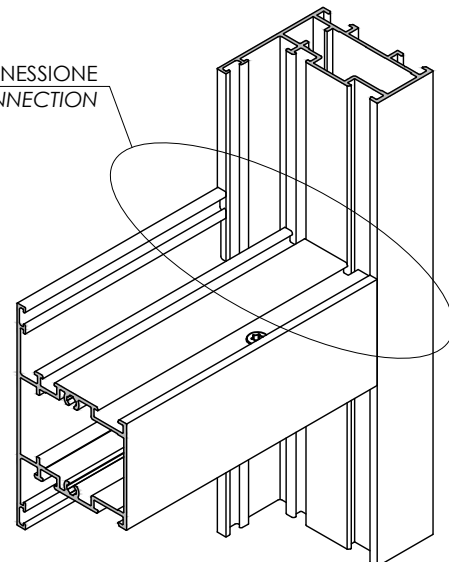
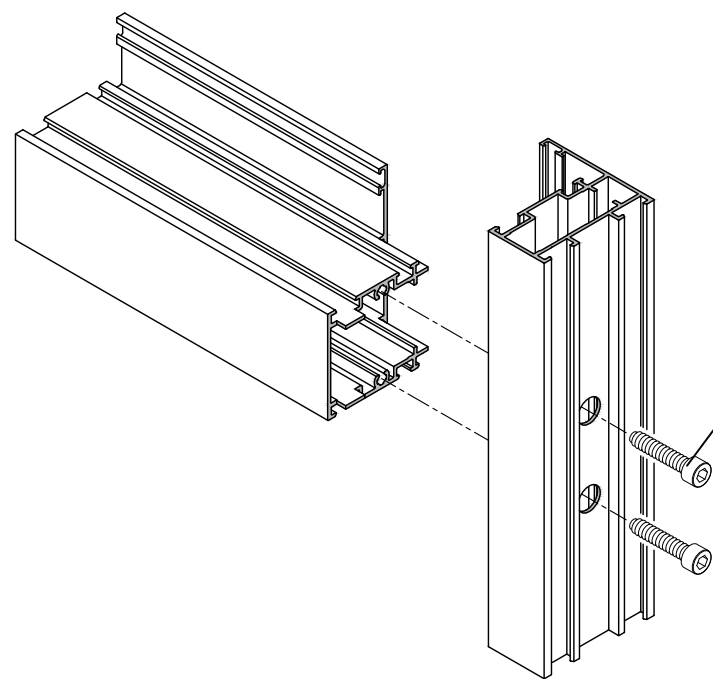
Fissaggio con cavallotti
Fixing with T-joints

SIGILLARE LA ZONA DI CONNESSIONE
 SEAL THE CONNECTION

Vite 4.8x45
 TCEI autofilettante
 4.8x45 mm
 TCEI self-tapping screw

SIGILLARE LA ZONA DI CONNESSIONE
 SEAL THE CONNECTION

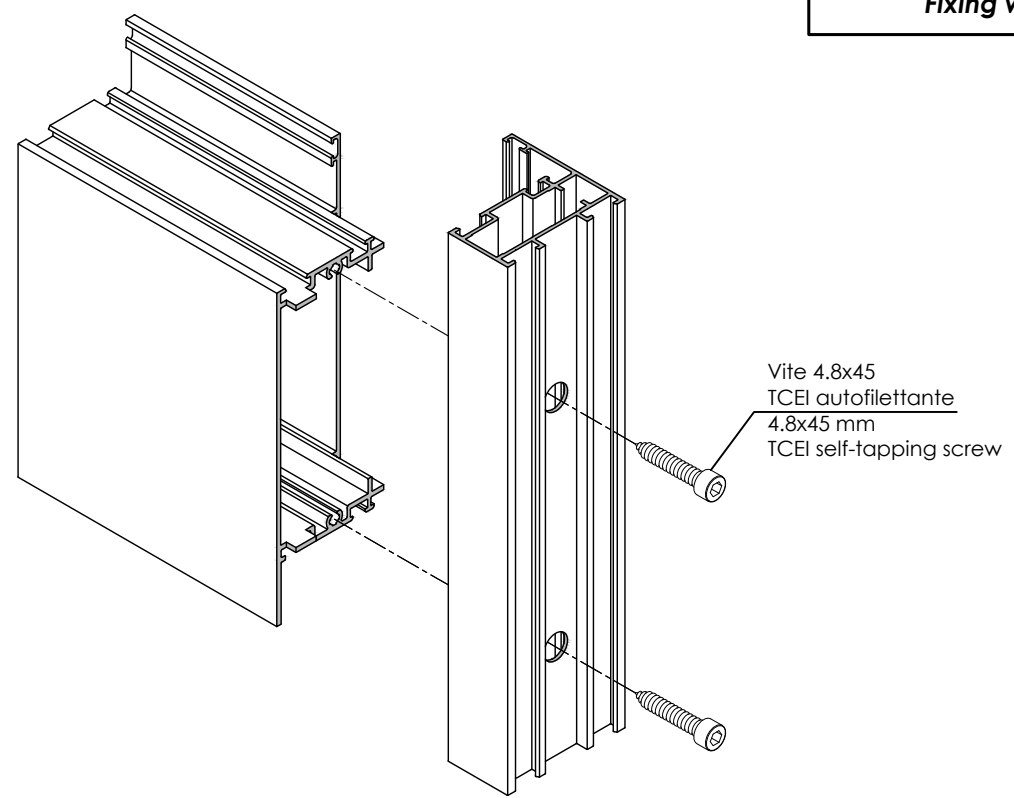
Vite 4.8x45
 TCEI autofilettante
 4.8x45 mm
 TCEI self-tapping screw



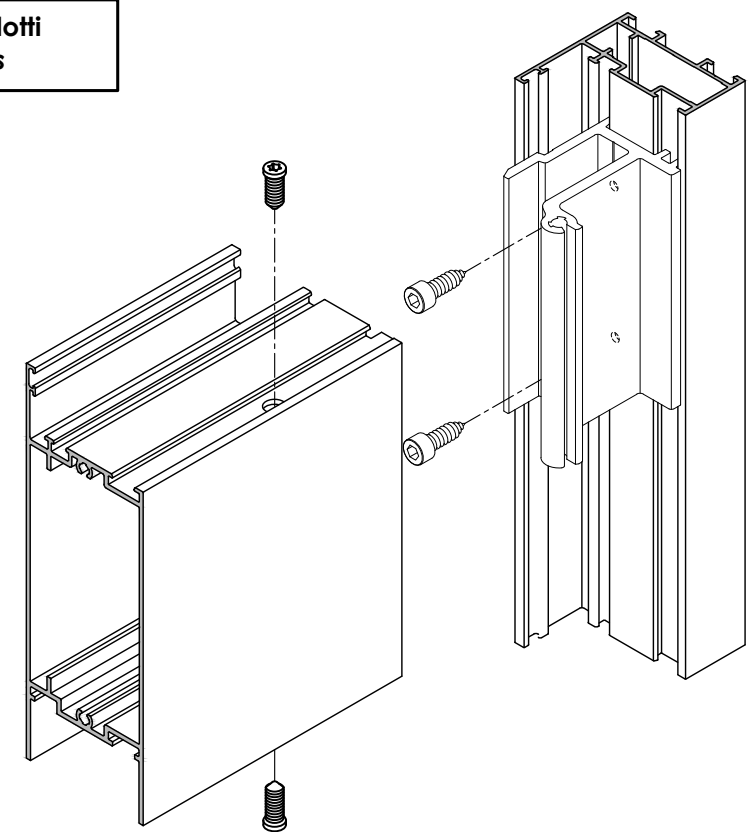
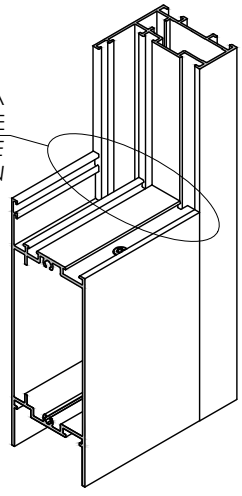
CONNESSIONE FASCIA E ZOCCOLO
MID-RAIL AND BOTTOM-RAIL CONNECTION

Fissaggio con viti
Fixing with screws

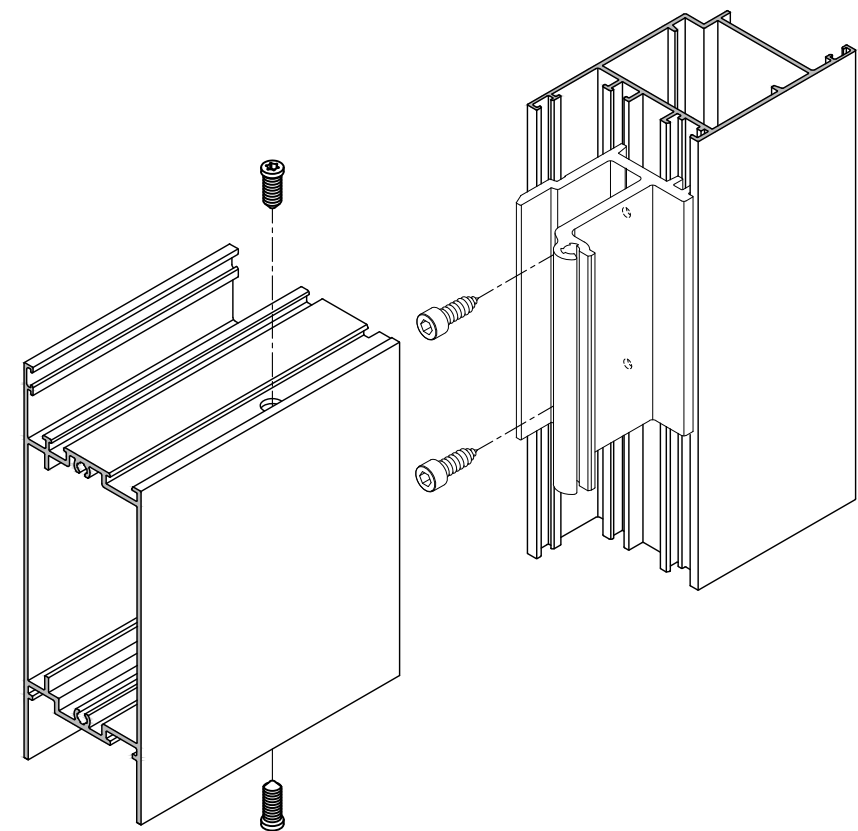
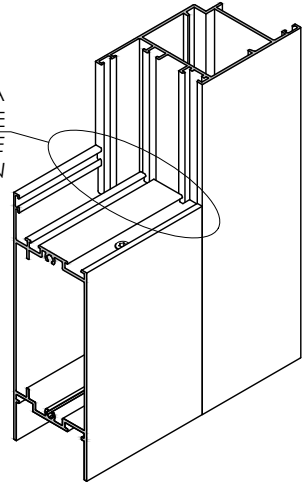
Fissaggio con cavallotti
Fixing with T-joints



SIGILLARE LA ZONA
 DI CONNESSIONE
 SEAL THE
 CONNECTION

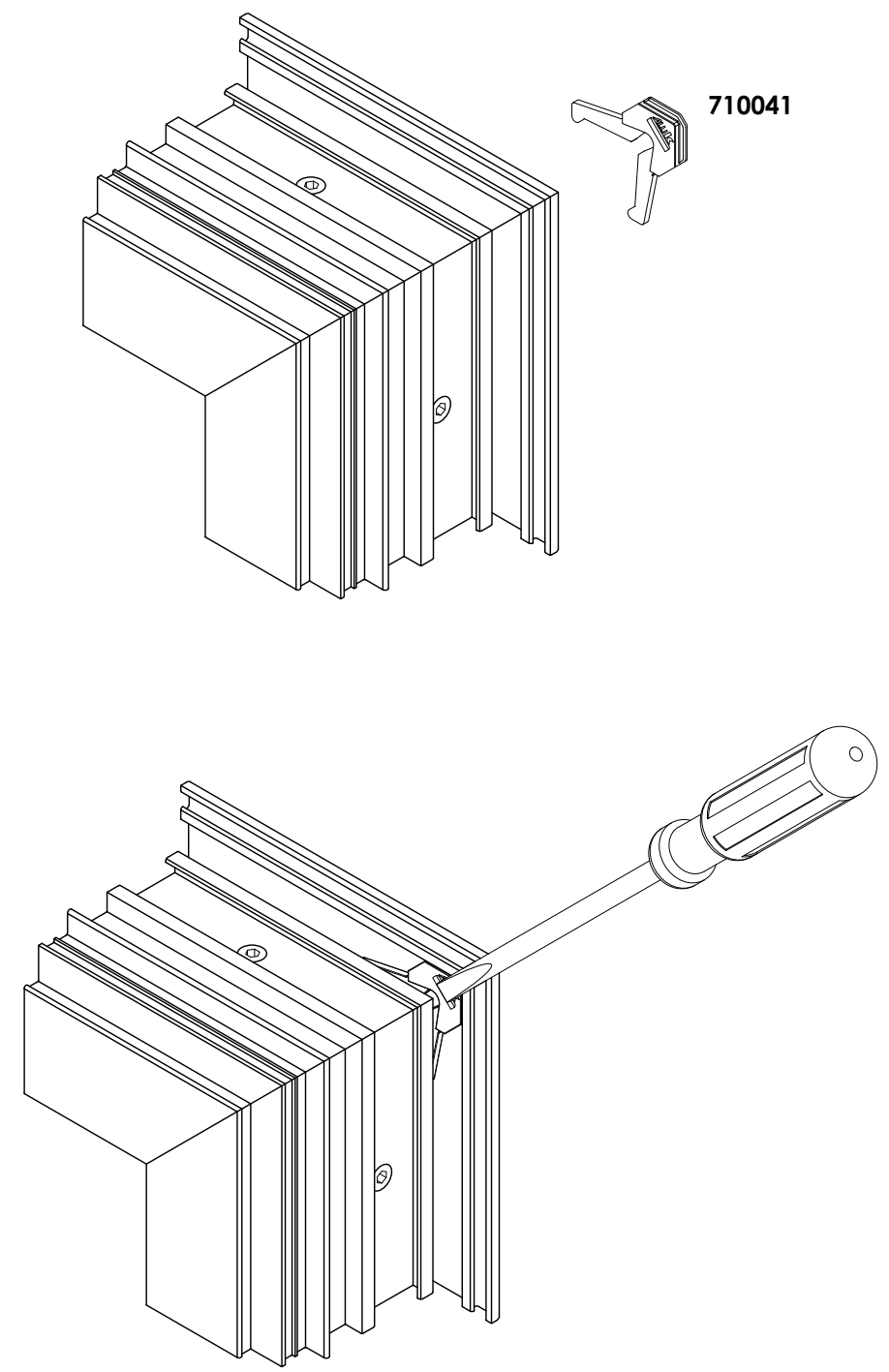
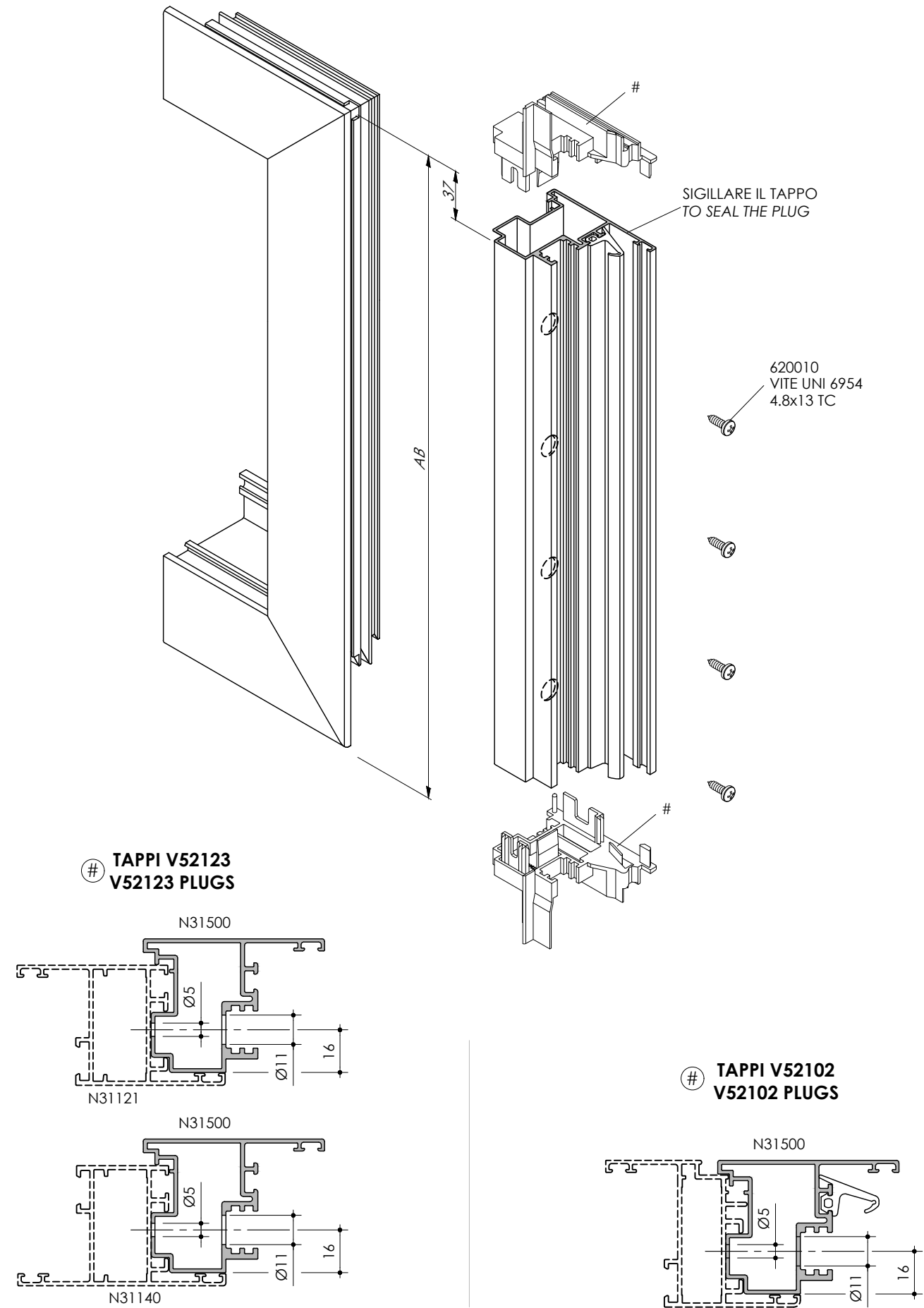


SIGILLARE LA ZONA
 DI CONNESSIONE
 SEAL THE
 CONNECTION



MONTAGGIO PROFILO STULP E RELATIVI TAPPI
ASSEMBLING OF STULP PROFILE WITH ITS PLUGS

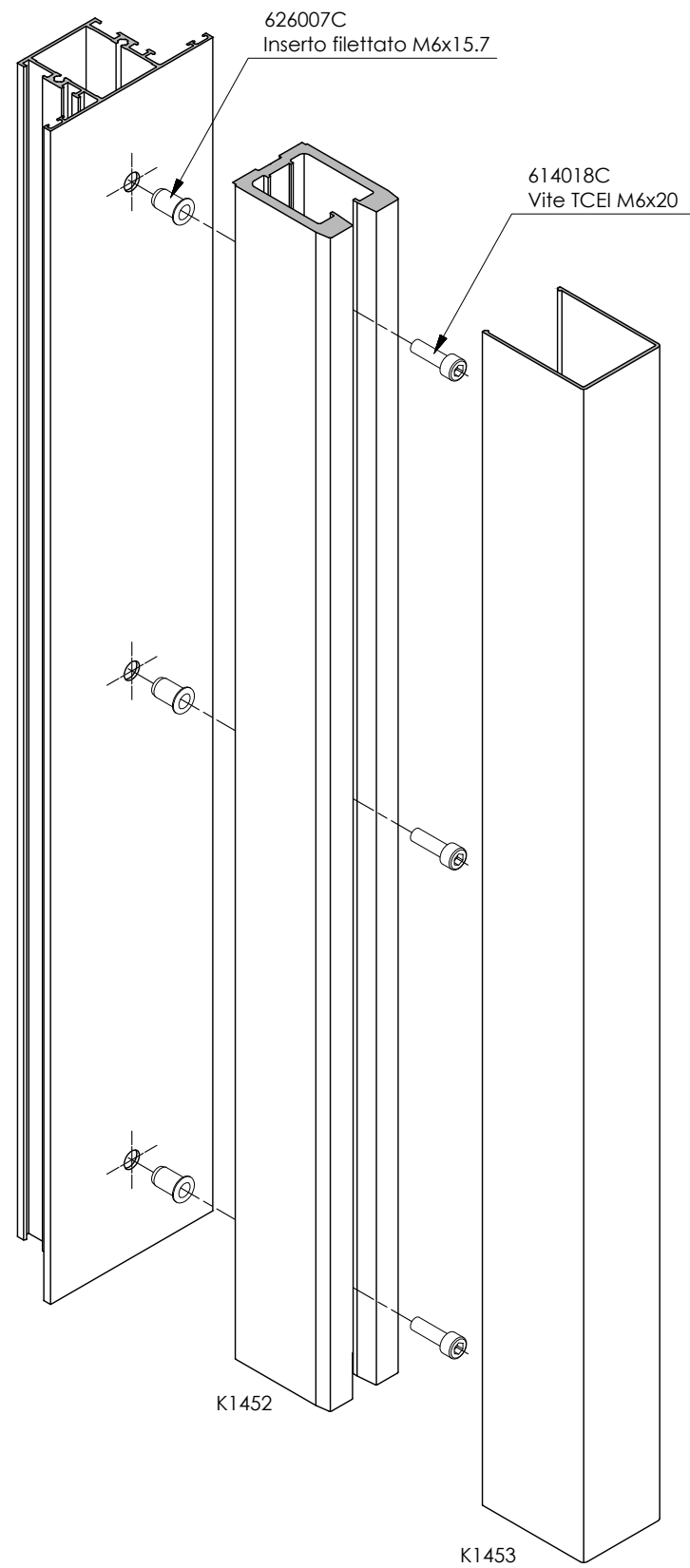
MONTAGGIO SQUADR. DI ALLINEAM. INTERNA BATTENTE
INTERNAL WING ALIGNMENT CORNER JOINT ASSEMBLING DIAGRAM



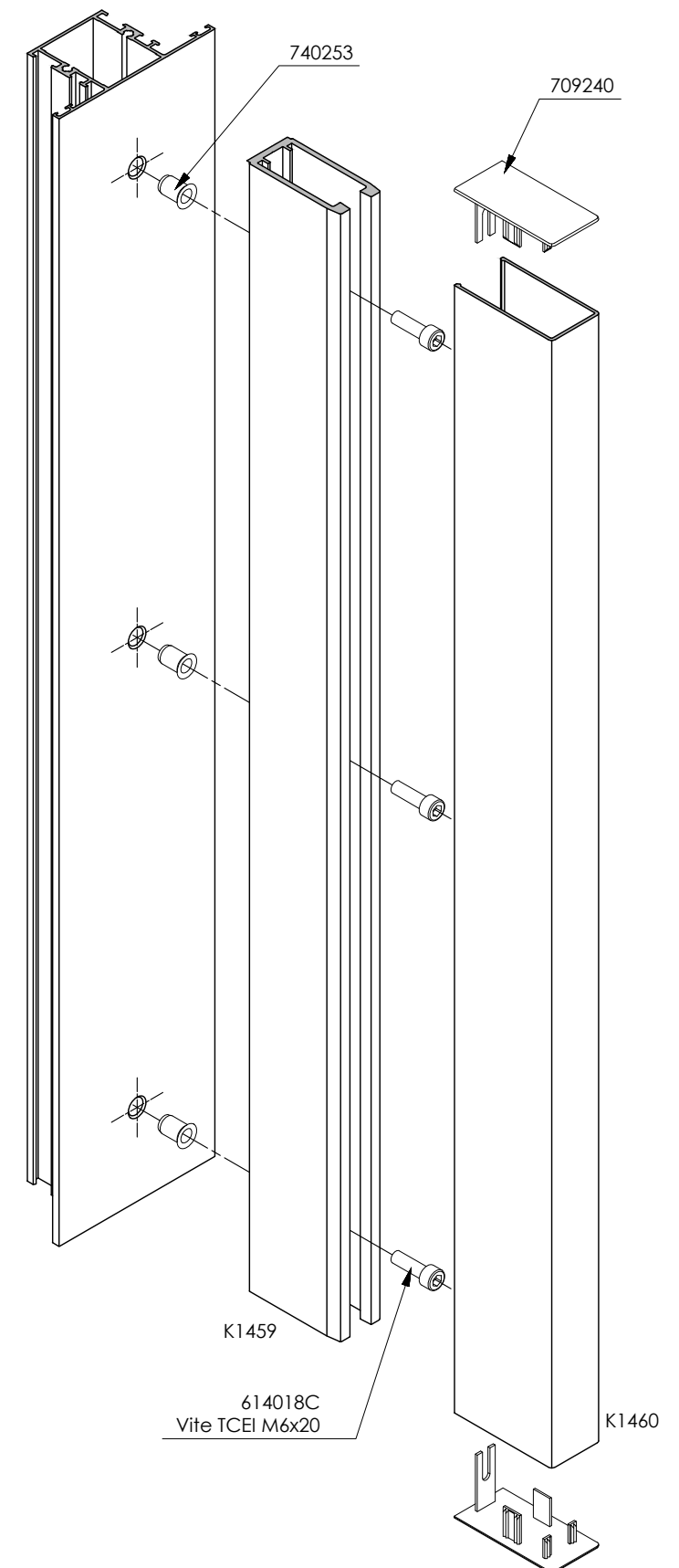
PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE TRANCIANTE ART. 909310
 TO EXECUTE THIS CUTTING OUT USE ART. 909310 BLANKING MACHINE

MONTAGGIO PROFILO DI RINFORZO
ASSEMBLING OF REINFORCEMENT PROFILE

RINFORZO COLONNINA K1452
K1452 COLUMN

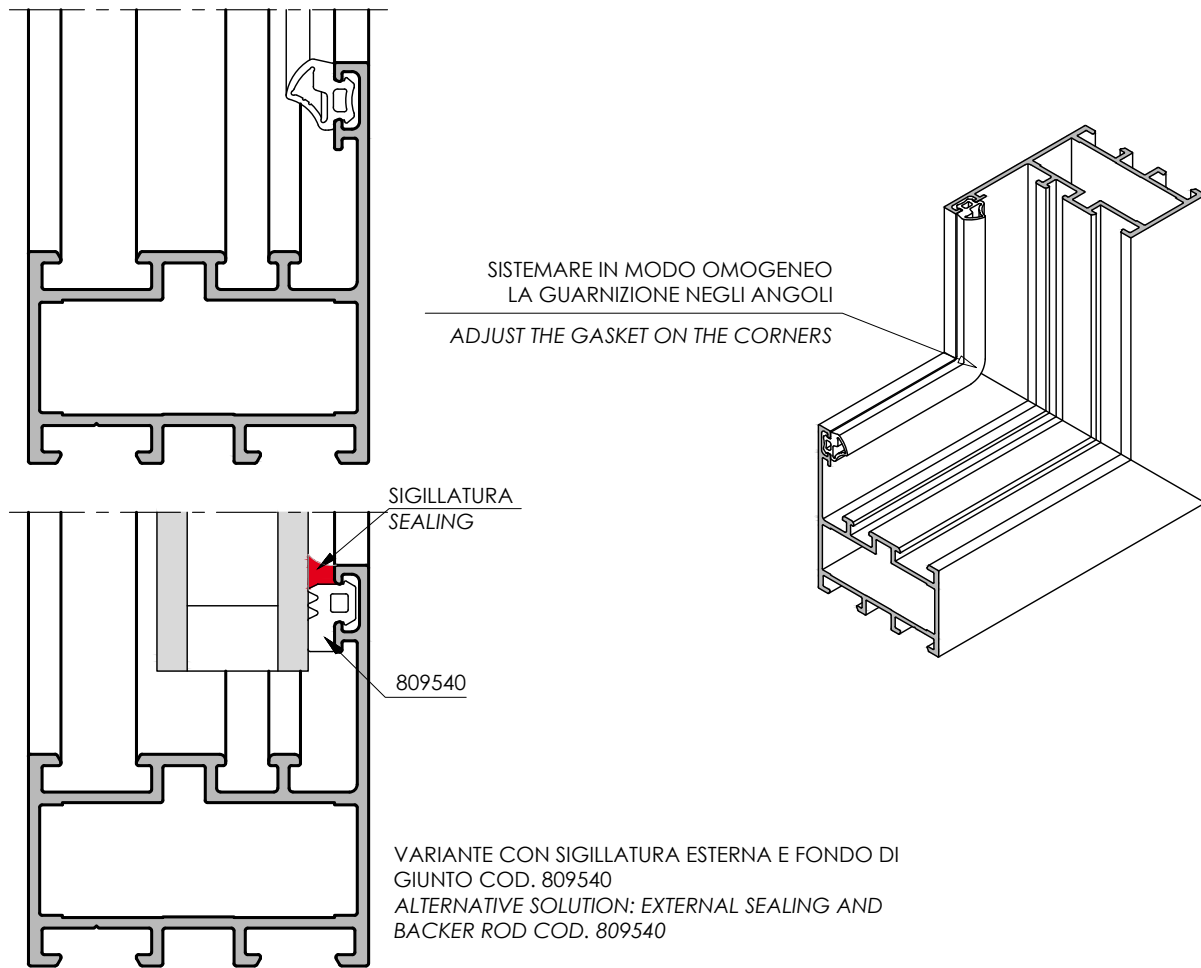


RINFORZO COLONNINA K1459
K1459 COLUMN

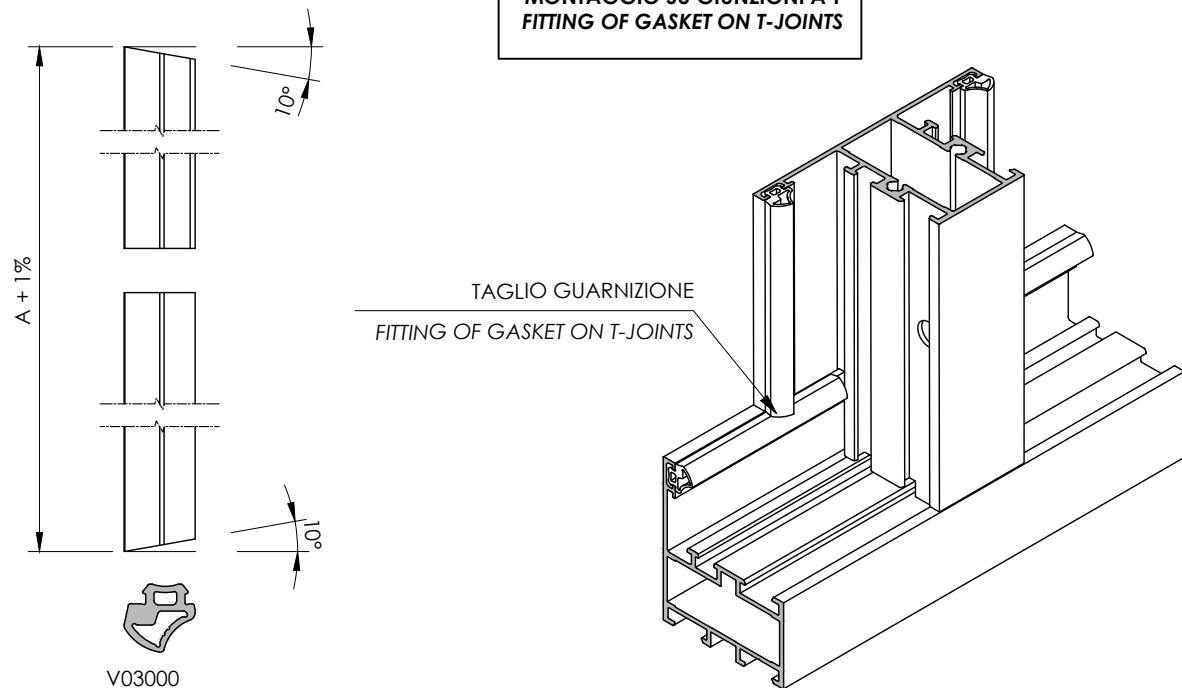


SCHEMA DI MONTAGGIO GUARNIZIONI
FITTINGS OF GLAZING GASKETS

MONTAGGIO GUARNIZIONE ESTERNA VETRO V03000 SU TELAI
FITTING OF EXTERNAL GLAZING GASKET V03000 ON FRAMES



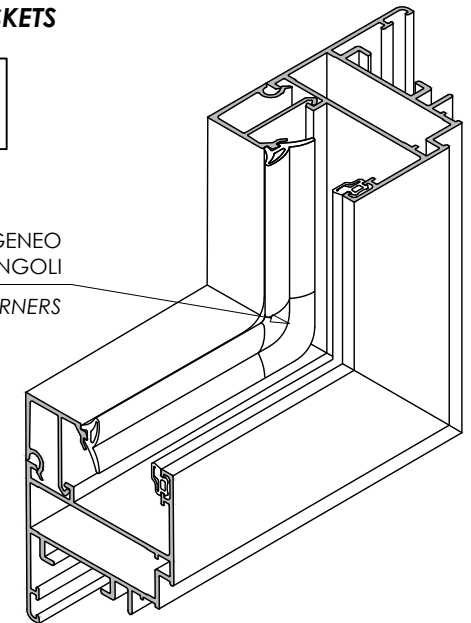
MONTAGGIO SU GIUNZIONI A T
FITTING OF GASKET ON T-JOINTS



MONTAGGIO GUARNIZIONI BATTENTE
FITTING OF WING GASKETS

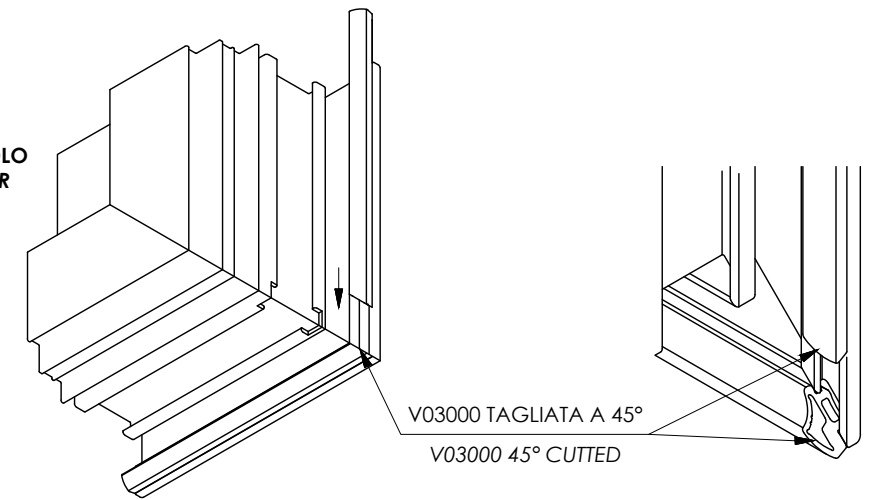
GUARNIZIONE INTERNA VETRO
INTERNAL GLAZING GASKET

SISTEMARE IN MODO OMOGENEO LA GUARNIZIONE NEGLI ANGOLI
 ADJUST THE GASKET ON THE CORNERS

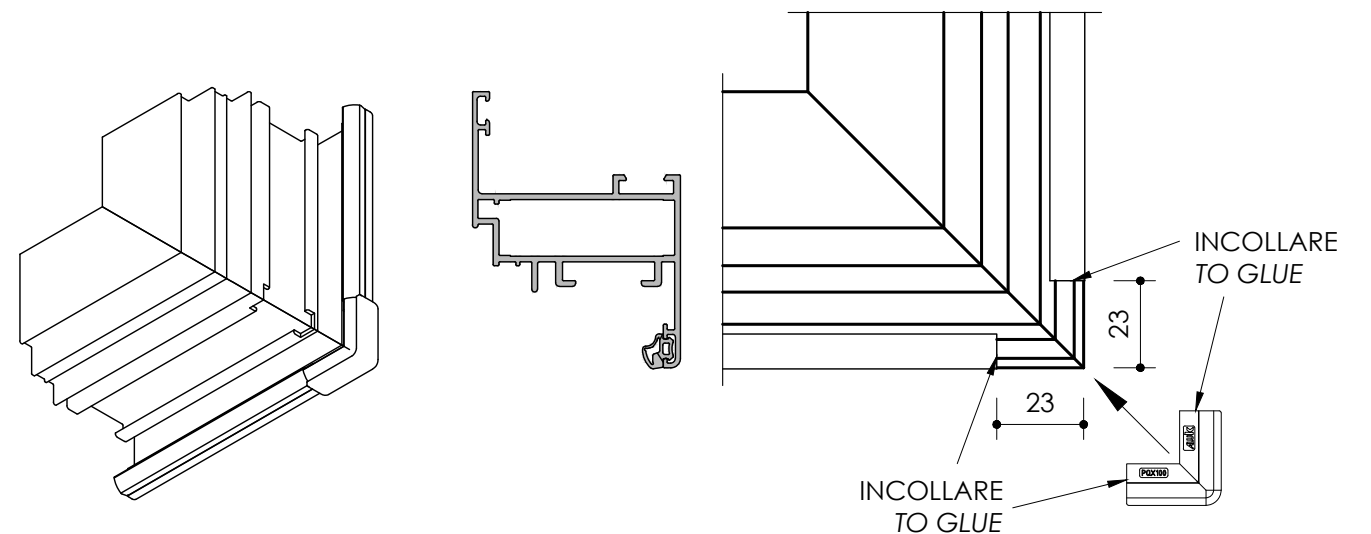


GUARNIZIONE V03000 SU BATTUTA INTERNA ANTE
V03000 GASKET ON WING INTERNAL REBATE

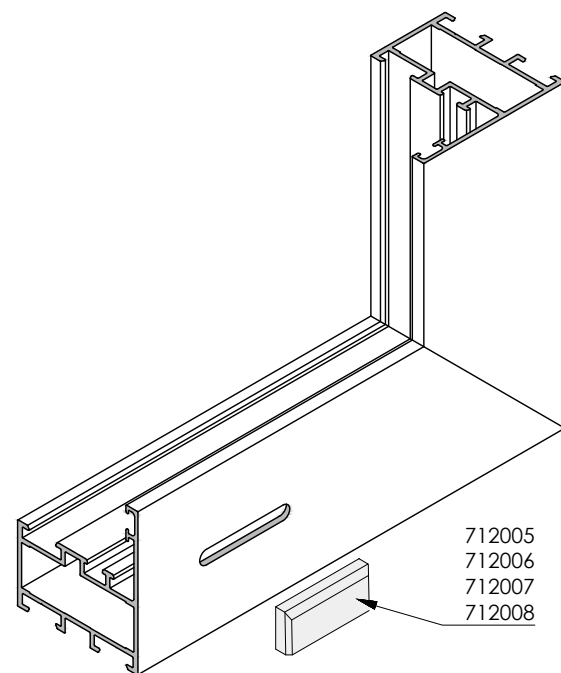
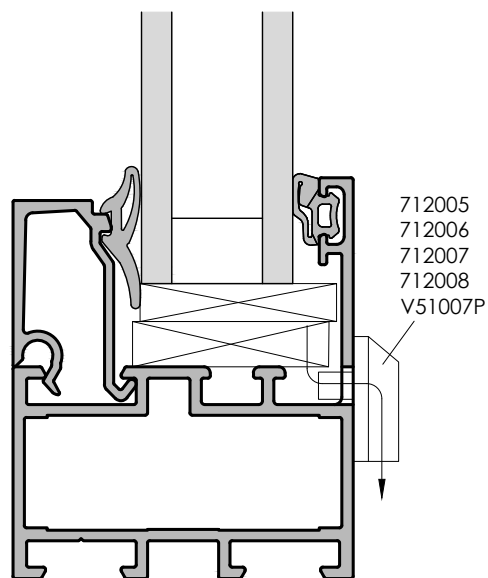
SENZA ANGOLINO PARASPIGOLO
WITHOUT CORNER PROTECTOR



CON ANGOLINO PARASPIGOLO V54013
WITH V54013 CORNER PROTECTOR



SCHEMA DI MONTAGGIO ACCESSORI DI DRENAGGIO
WATER DRAIN CAPS DIAGRAM ASSEMBLING

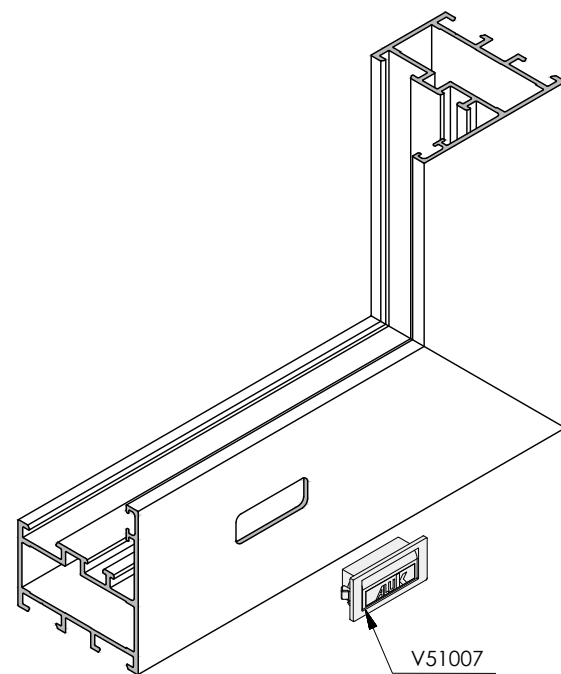


SIGILLARE IL BORDO INFERIORE DEL VETRO AL TELAIO, QUESTA SIGILLATURA ANDRA' ESTESA IN VERTICALE PER 150 mm SUI DUE MONTANTI.
 SEAL THE GLASS TO THE FRAME ALL AROUND THE LOWER EDGE, THIS SEALING SHALL VERTICALLY OVERLAP ON THE TWO ENDS FOR AT LEAST 150 mm

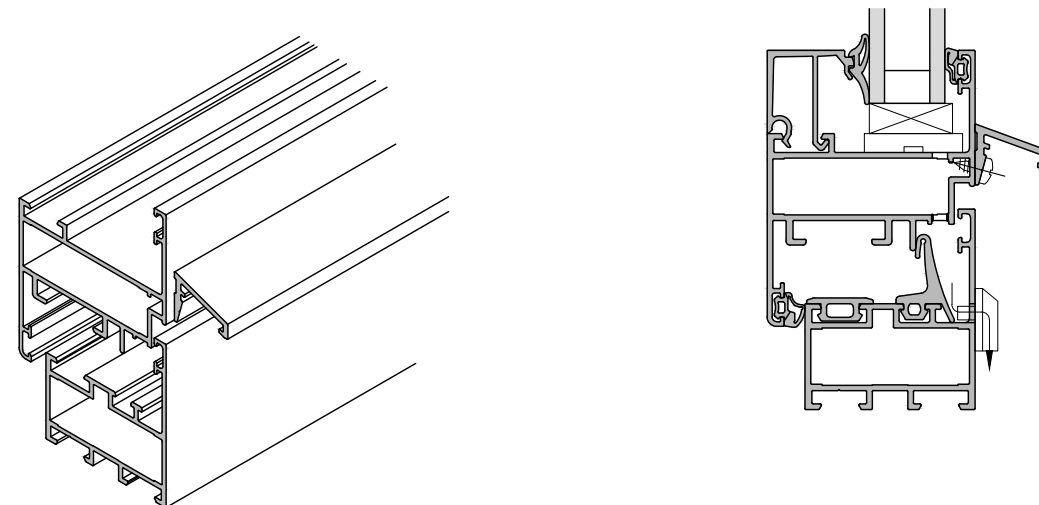
MASCHERINE DI DRENAGGIO WATER DRAIN CAP		
CODICE CODE	NOTA NOTE	COLORE COLOR
712005	Senza valvola Without valve	NERA BLACK
712006	Senza valvola Without valve	BIANCA WHITE
712007	Con valvola With valve	NERA BLACK
712008	Con valvola With valve	BIANCA WHITE
V51007P	Con valvola With valve	NERA BLACK

N.B. SI CONSIGLIA IL MONTAGGIO DELLE MASCHERINE CON VALVOLA NEI SITI ESPOSTI AD ELEVATI CARICHI DI VENTO.

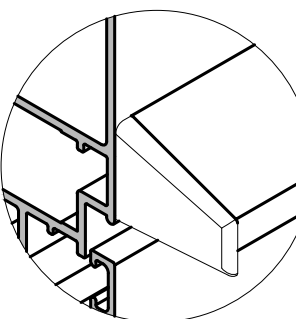
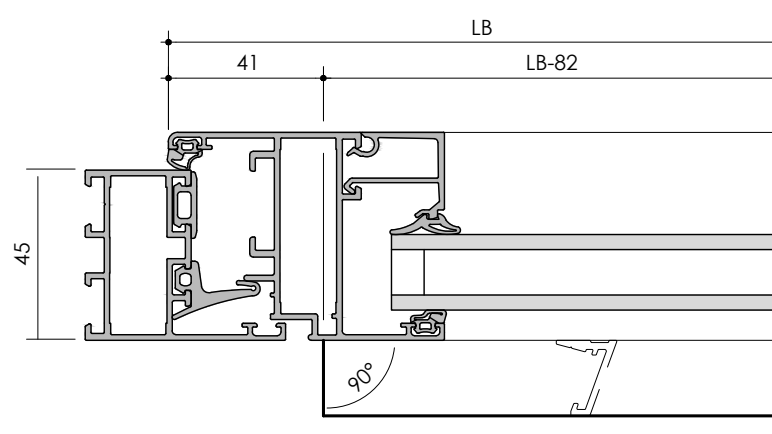
N.B. IT'S ADVISABLE TO ASSEMBLE THE WATER DRAIN CAP WITH VALVE IN CASE OF HIGHER WIND LOADS.



SCHEMA DI MONTAGGIO TAPPI GOCCIOLATOIO
DRIP PLUG DIAGRAM ASSEMBLING



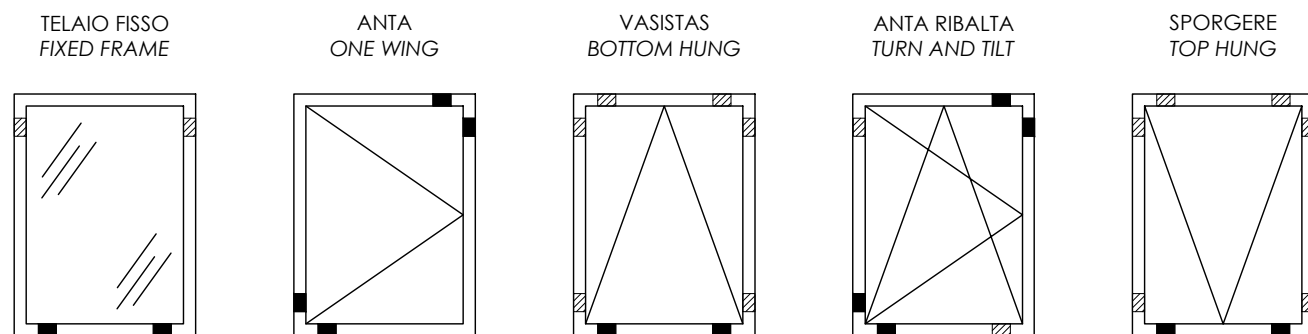
PARTE DA ASPORTARE
 PORTION TO CUT



PER IL MONTAGGIO DEL TAPPO GOCCIOLATOIO RIFILARE A 90° IL PROFILO K50

CUT AT 90° K50 SECTION TO ASSEMBLE THE PLUG

SCHEMA DI MONTAGGIO TASSELLI VETRO GLASS CLEATS ASSEMBLING DIAGRAM



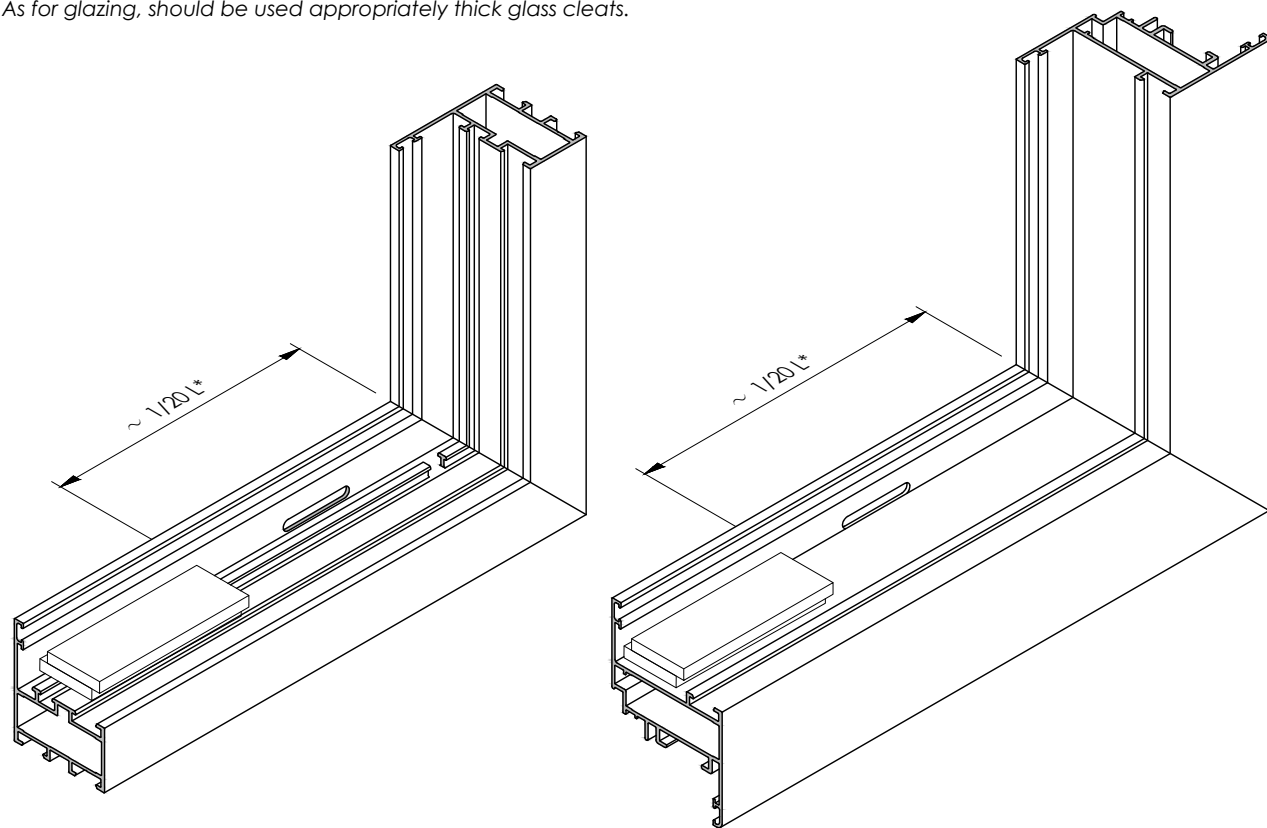
■ **TASSELLI DI APPOGGIO** - I tasselli di appoggio devono essere disposti secondo gli schemi sopra indicati ad una distanza dal bordo esterno del vetro fra 1/10 e 1/20 della larghezza del vetro.

■ **BEARING CLEATS** - Bearing cleats must be installed according to the sketches drawn above. Their distance from the glass external edge must be between 1/10th and 1/20th the width of the glass.

▣ **TASSELLI PERIFERICI** - I tasselli periferici assicurano il posizionamento del vetro. Detti tasselli devono essere inseriti, senza forzare, fra il vetro e il telaio in modo da assicurare la stabilità del vetro.

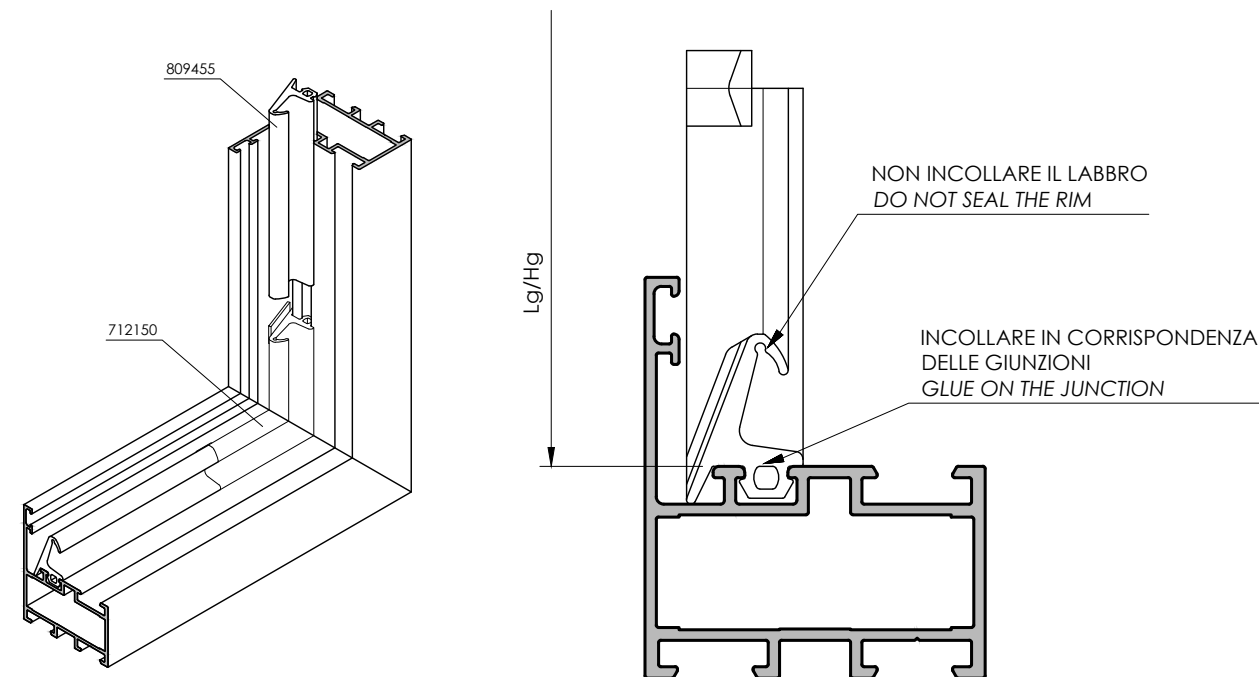
▣ **SIDE SETTING CLEATS** - Side setting cleats hold the glass pane in position. These cleats must be inserted without forcing them, between the glass and the frame in order to be sure that the glass is stable.

Per la vetratura si dovranno utilizzare tasselli di spessore adeguato.
As for glazing, should be used appropriately thick glass cleats.



* L = LARGHEZZA VETRO
* L = GLASS WIDTH

APPLICAZIONE DELLA GUARNIZIONE GIUNTO APERTO FITTING OF THE CENTRAL GASKET



- TAGLIARE LA GUARNIZIONE NEL MODO SEGUENTE:
PER DIMENSIONI CON Lg/Hg SOTTO I 1000 mm = $(Lg/Hg-100)+1\%$
PER DIMENSIONI CON Lg/Hg SOPRA I 1000 mm = $(Lg/Hg-100)+0.5\%$

- SGRASSARE LA ZONA DI INCOLLAGGIO DELLA GUARNIZIONE E DEGLI ANGOLI VULCANIZZATI

- FORMARE CON LA GUARNIZIONE E GLI ANGOLI VULCANIZZATI UN TELAIO UTILIZZANDO COLLANTE CIANOACRILICO

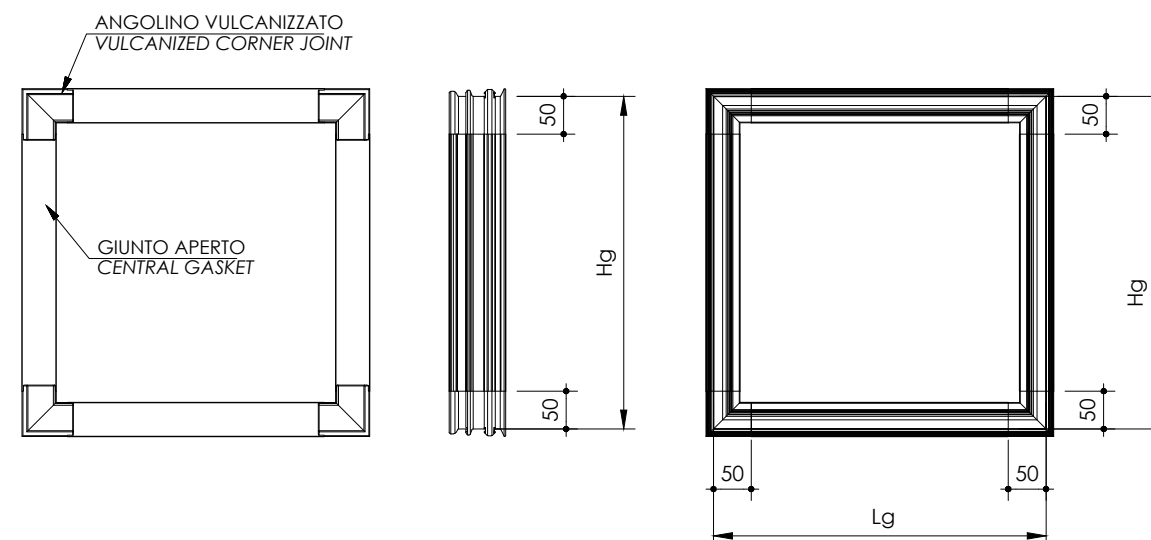
- SIGILLARE LA SEDE DELLA GUARNIZIONE IN CORRISPONDENZA DELL'ANGOLO

- CUT THE GASKET AS FOLLOWS:
WITH DIMENSION Lg/Hg UNDER 1000 mm = $(Lg/Hg-100)+1\%$
WITH DIMENSION Lg/Hg OVER 1000 mm = $(Lg/Hg-100)+0.5\%$

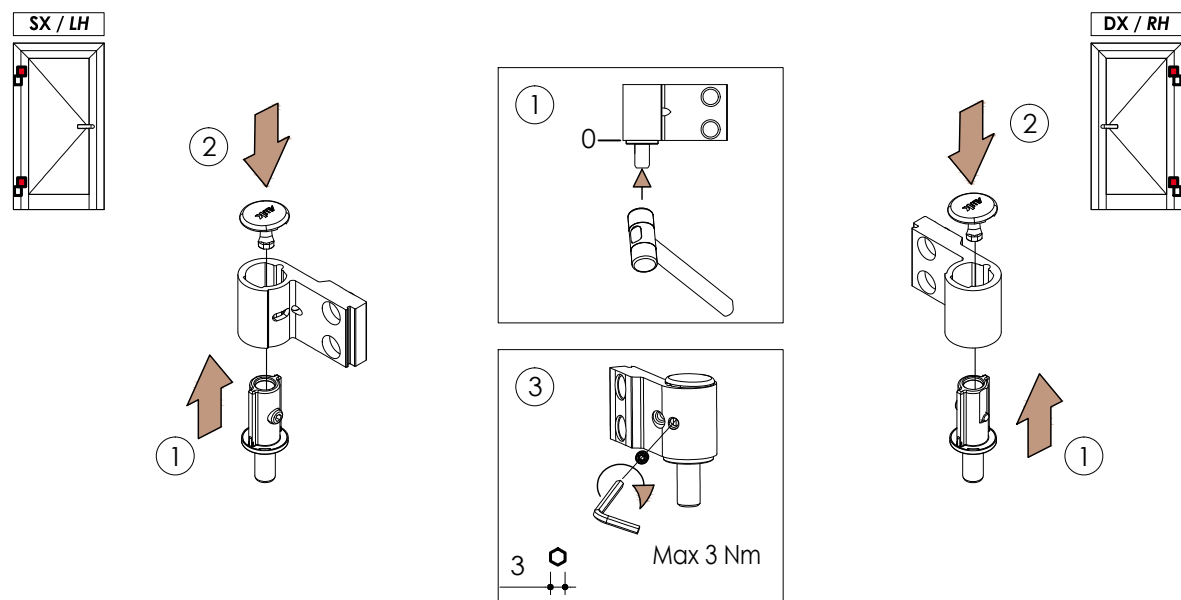
- DEGREASE THE AREA WHERE THE GASKET AND THE VULCANIZED CORNER JOINTS ARE TO BE FIXED

- USE A CYANOACRYLIC GLUE TO FORM A FRAME WITH GASKET AND VULCANIZED CORNER JOINTS

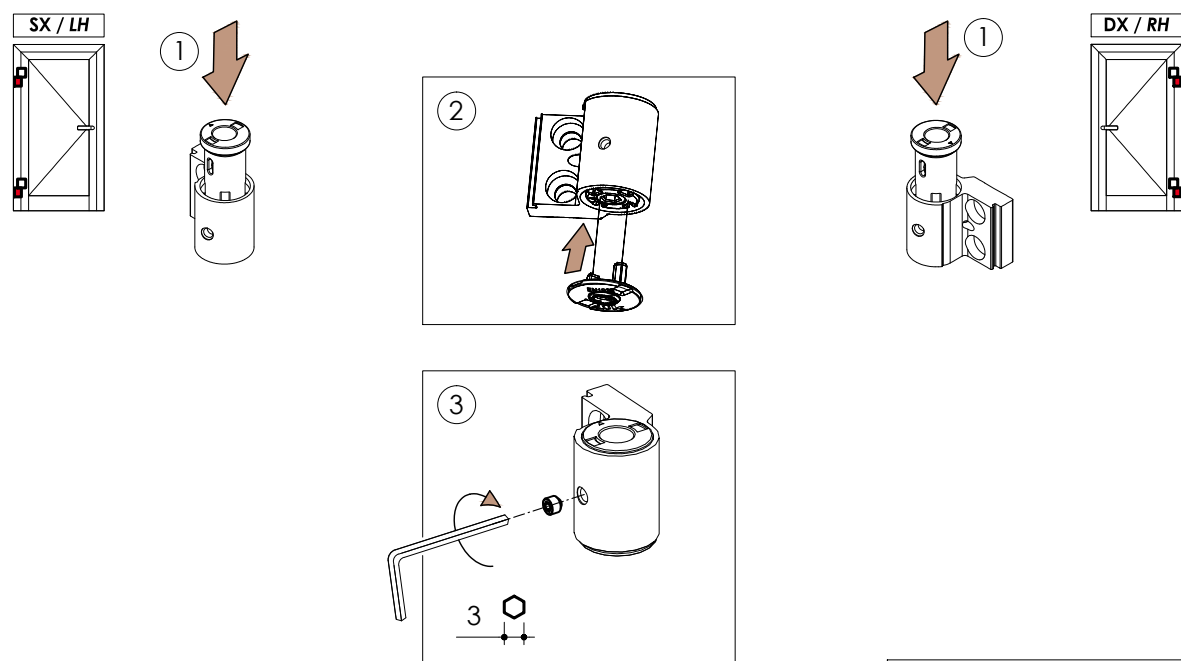
- SEAL THE GASKET SEATING IN CONNECTION WITH CORNER JOINT



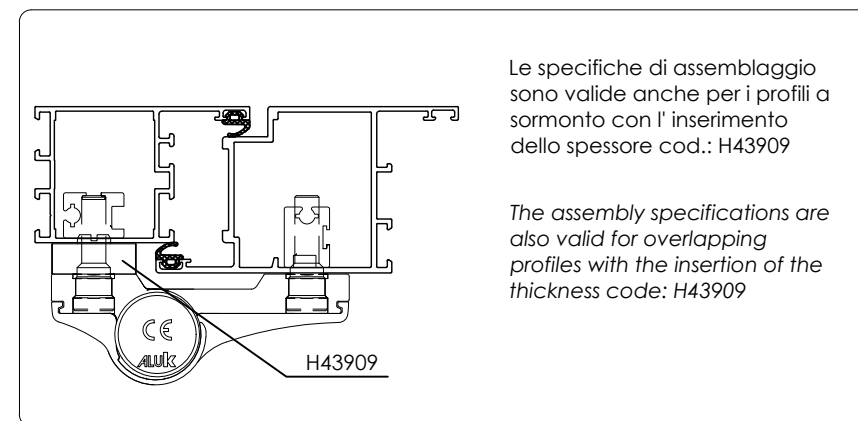
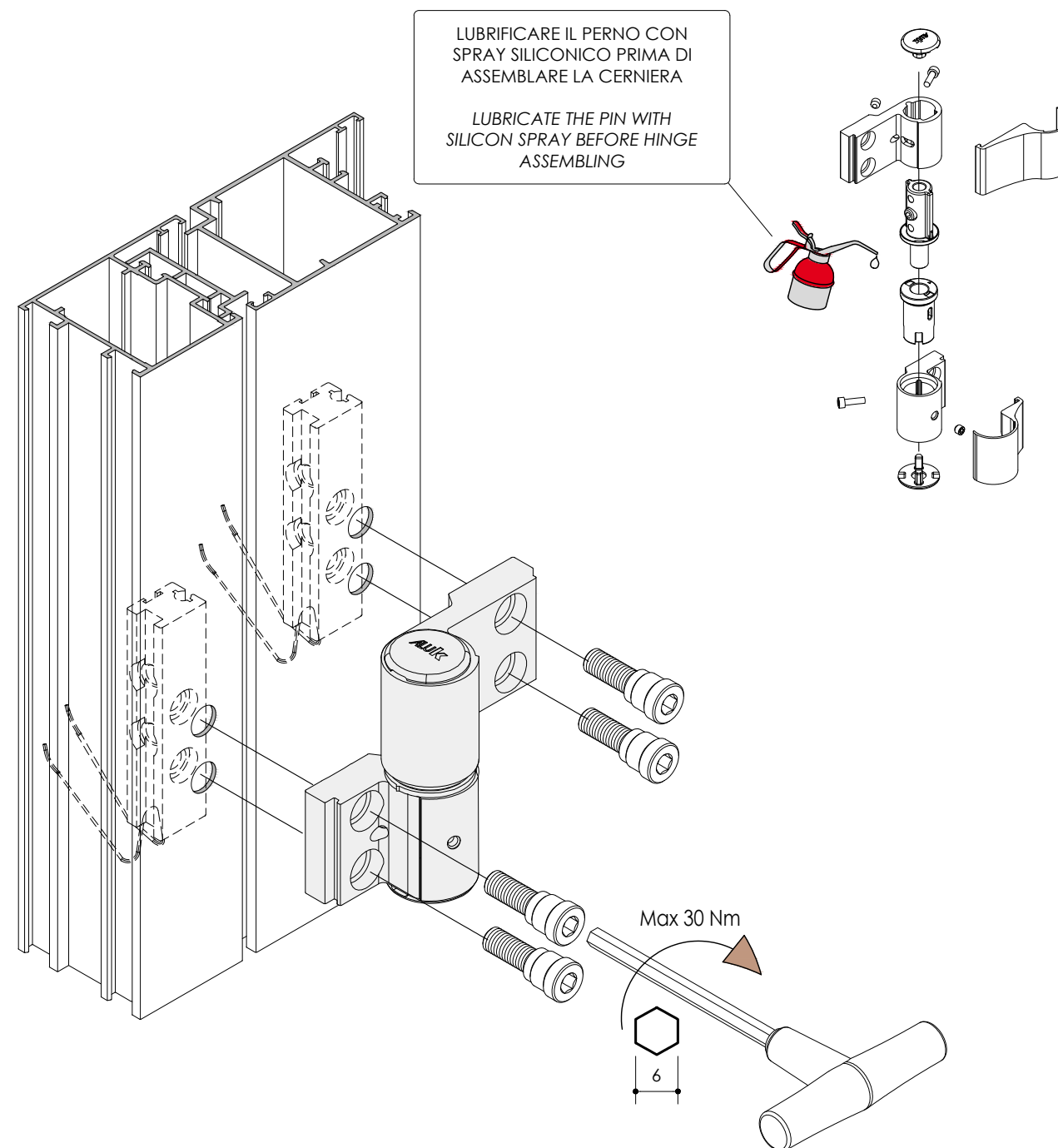
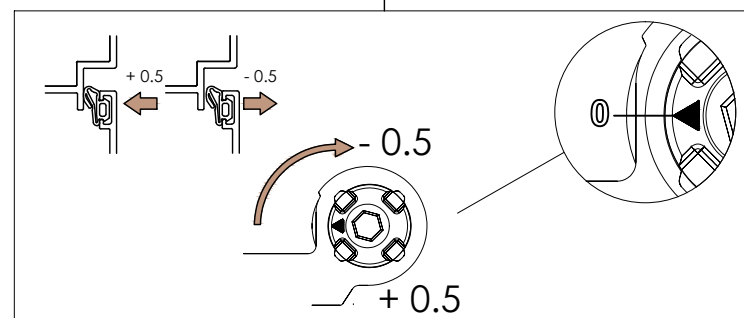
SCHEMA DI ASSEMBLAGGIO CERNIERE A 2 ALI
TWO WINGS HINGES ASSEMBLING DIAGRAM



- ① Inserire il perno nella boccia
Insert the pivot in to the bush
- ② Inserire la boccia e il tappo nella semi-cerniera superiore
Insert the bush and the cup in to the upper hinge
- ③ Inserire il grano di fissaggio, con chiave esagonale 3 mm
Insert the screw to fix, use Allen key 3 mm

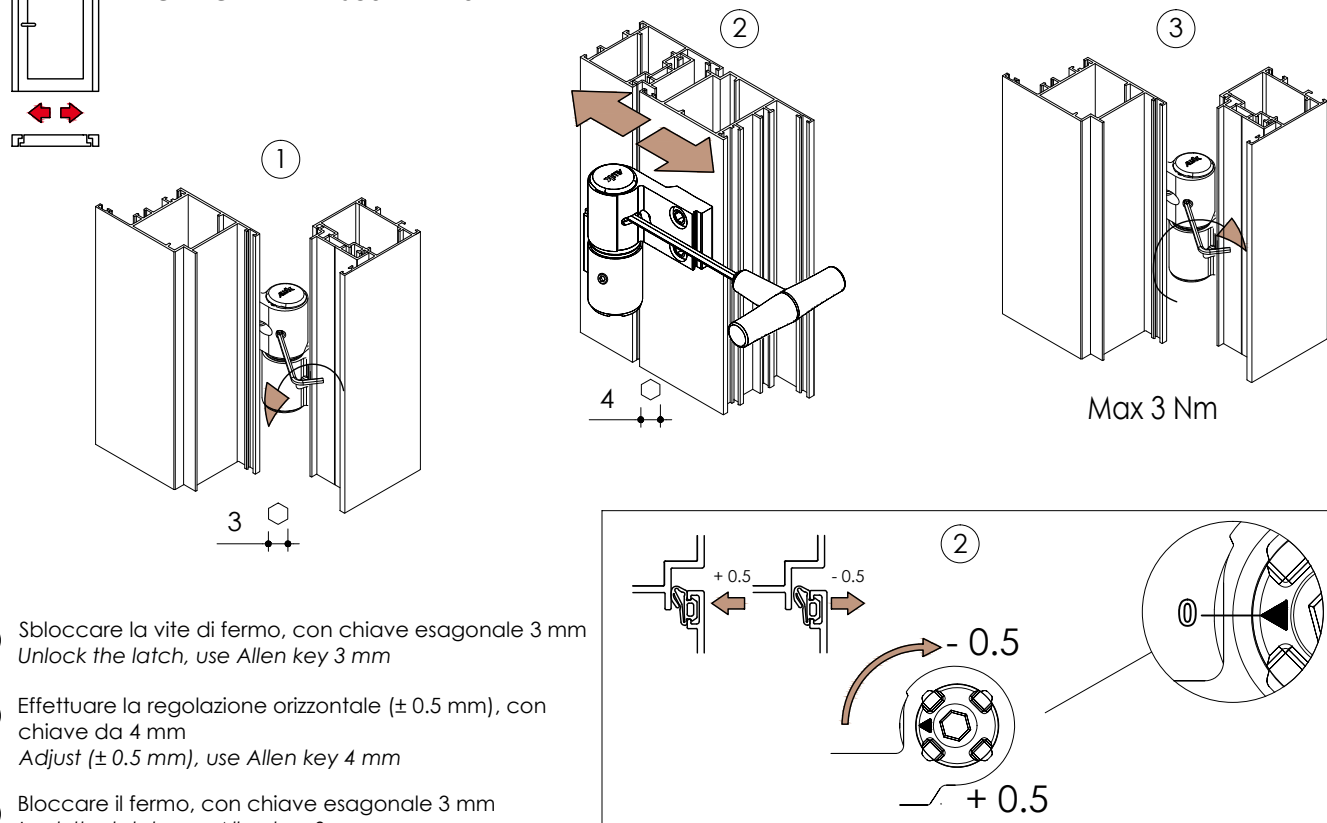


- ① Inserire il perno nella boccia
Insert the pivot in to the bush
- ② Inserire la boccia e il tappo nella semi-cerniera inferiore
Insert the bush and the cup in to the lower hinge
- ③ Inserire il grano di fissaggio, con chiave esagonale 3 mm
Insert the screw to fix, use Allen key 3 mm



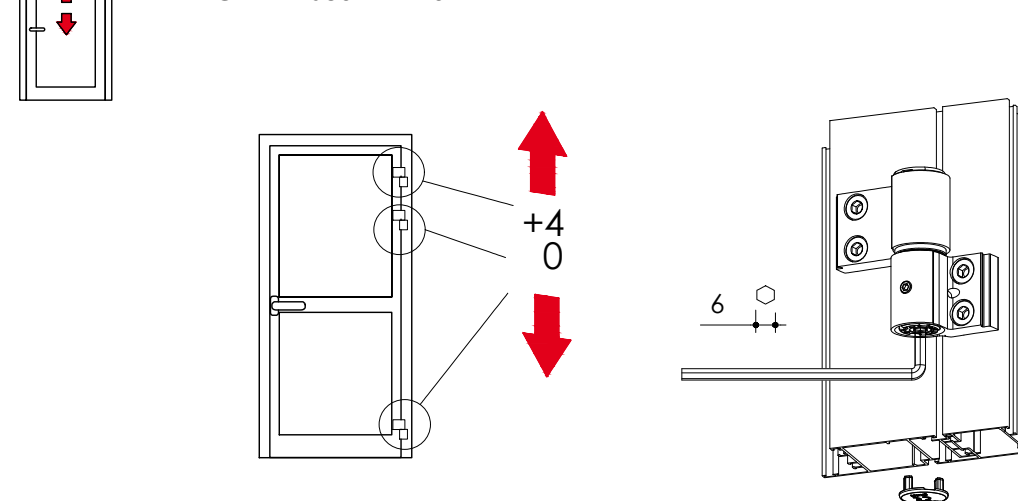
SCHEMA DI REGOLAZIONE CERNIERE 2 ALI DOUBLE WING HINGES SETTING DIAGRAM

REGOLAZIONE ORIZZONTALE HORIZONTAL ADJUSTMENTS



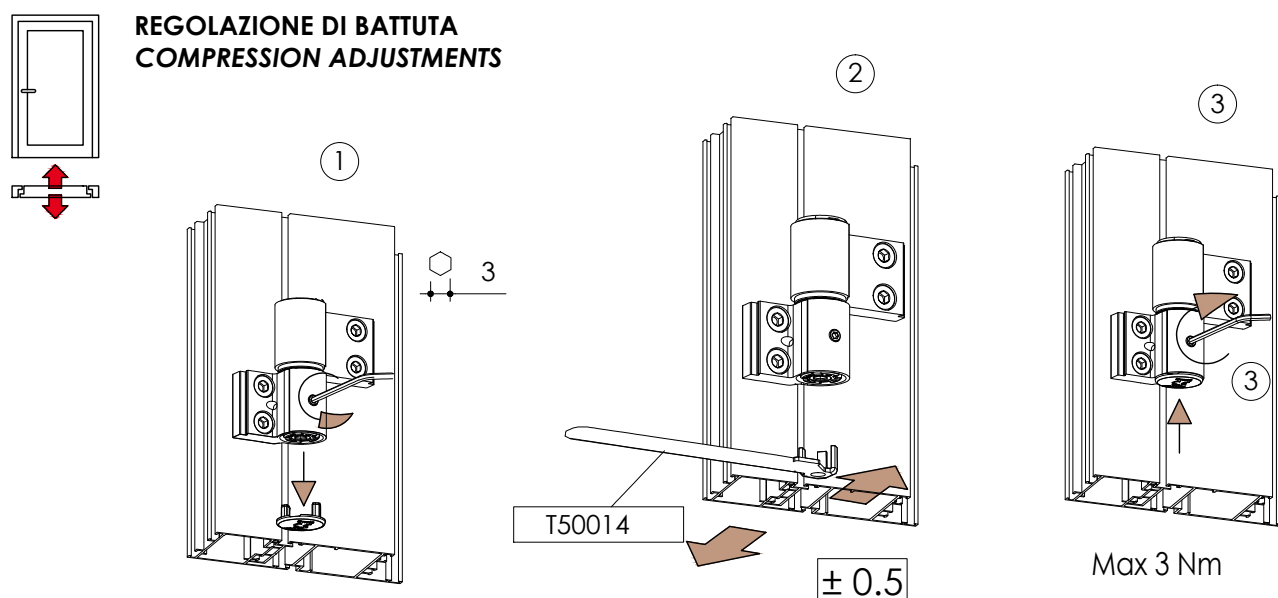
- 1 Sbloccare la vite di fermo, con chiave esagonale 3 mm
Unlock the latch, use Allen key 3 mm
- 2 Effettuare la regolazione orizzontale (± 0.5 mm), con chiave da 4 mm
Adjust (± 0.5 mm), use Allen key 4 mm
- 3 Bloccare il fermo, con chiave esagonale 3 mm
Lock the latch, use Allen key 3mm

REGOLAZIONE VERTICALE VERTICAL ADJUSTMENTS



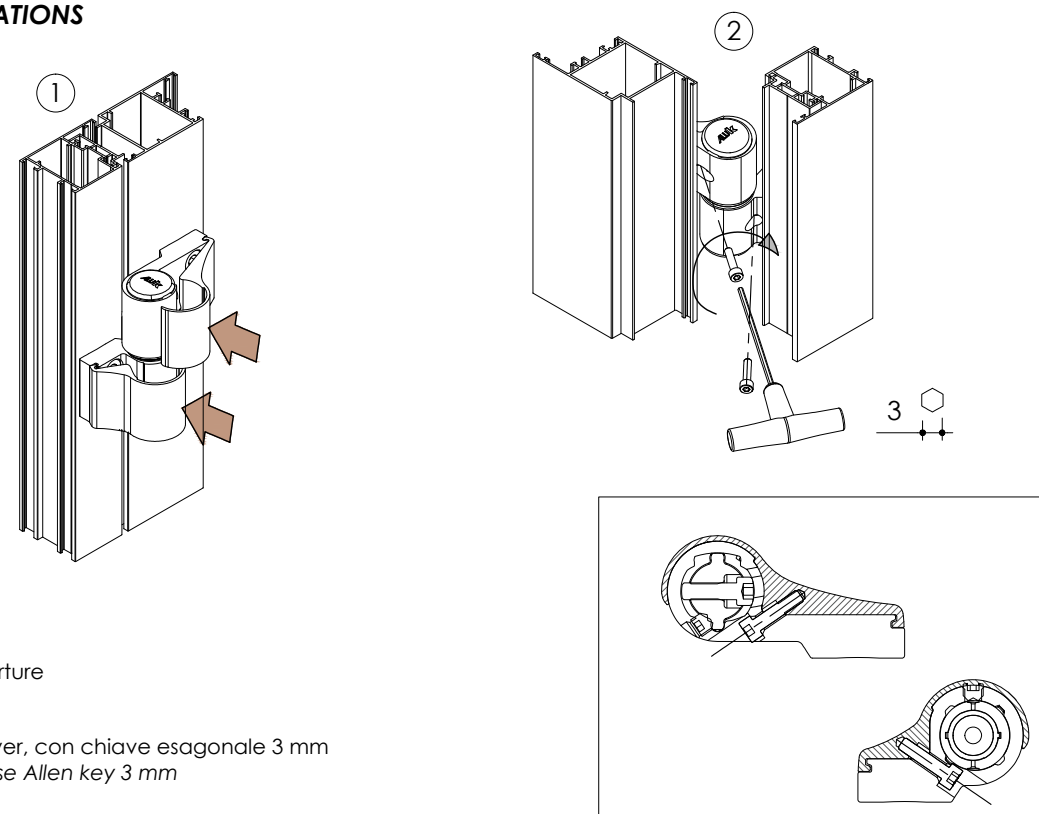
- 1 Rimuovere il tappo
Remove the plug
- 2 Effettuare la regolazione (+ 4 mm/ 0), con chiave da 6 mm
Adjust (+ 4 mm/ 0), use hex key 6mm

REGOLAZIONE DI BATTUTA COMPRESSION ADJUSTMENTS



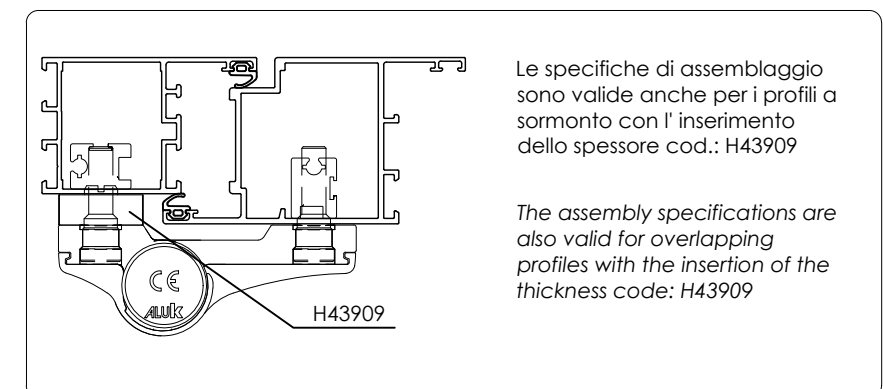
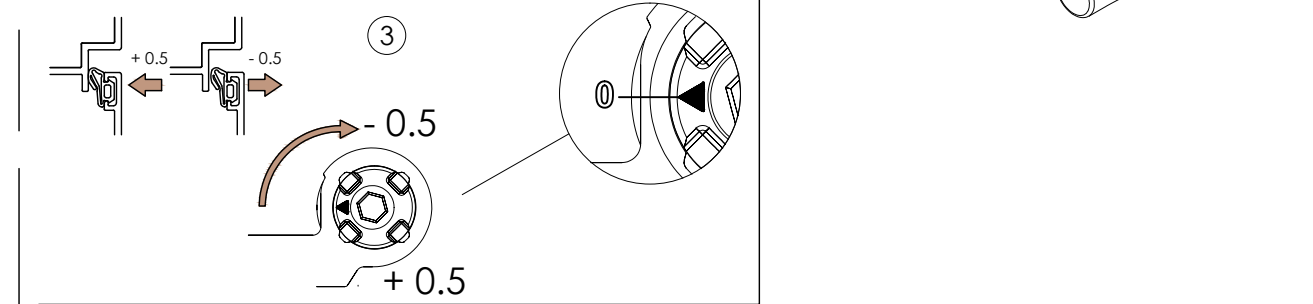
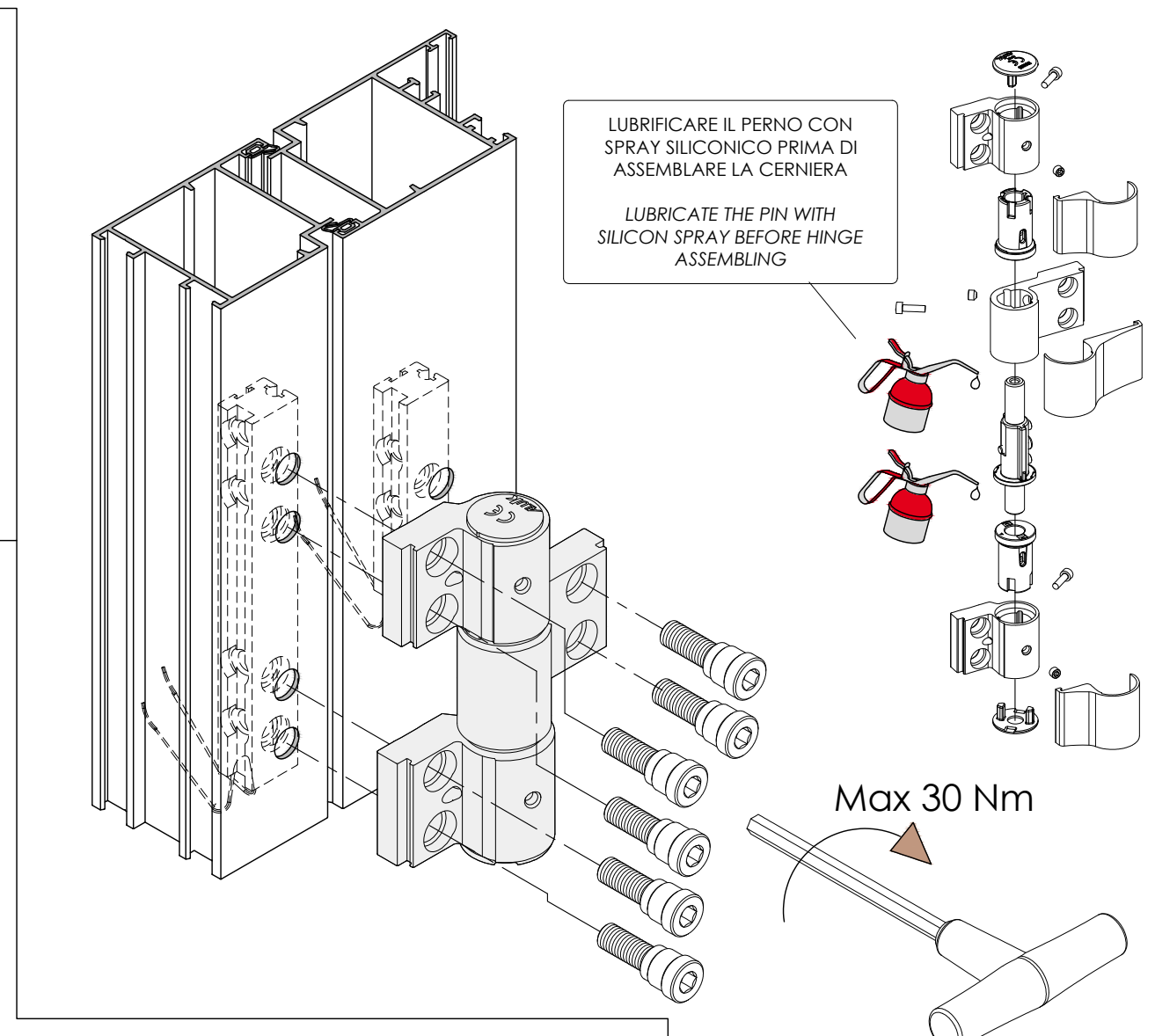
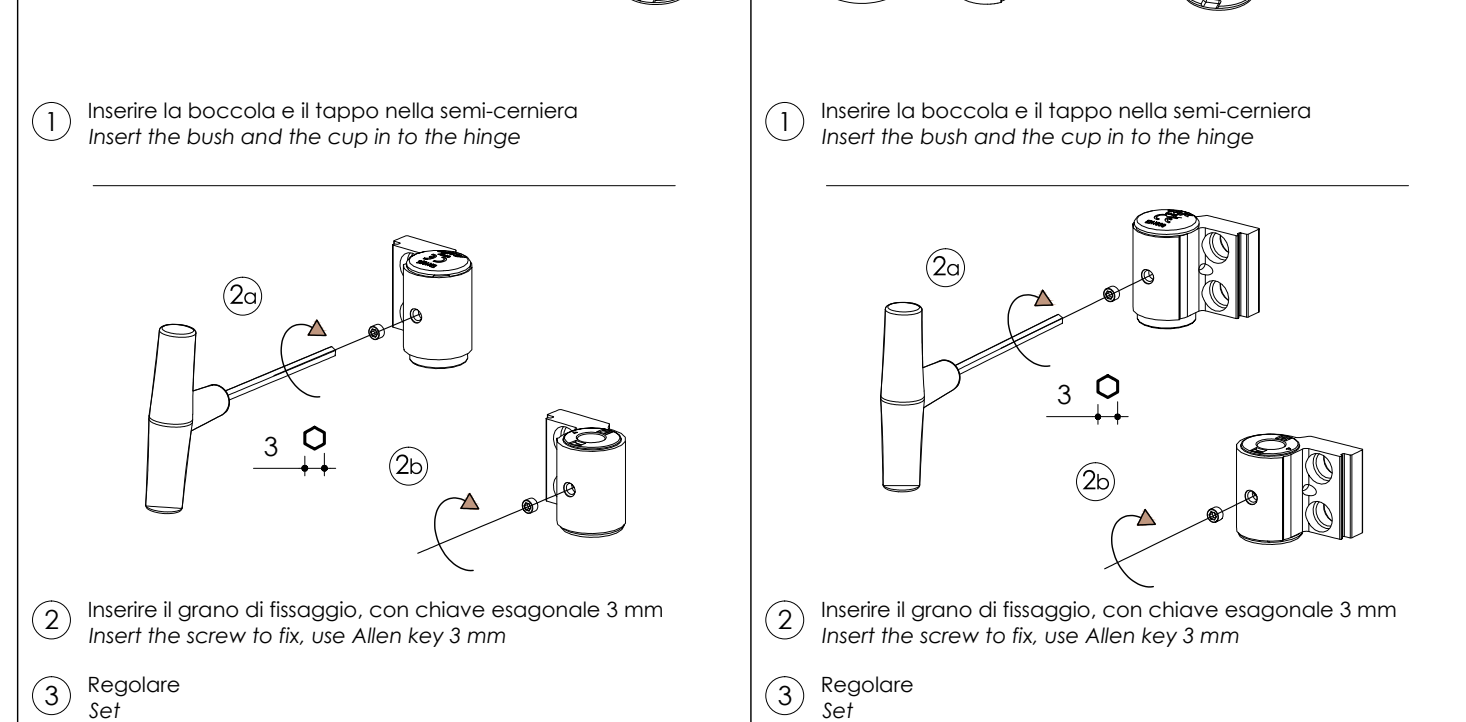
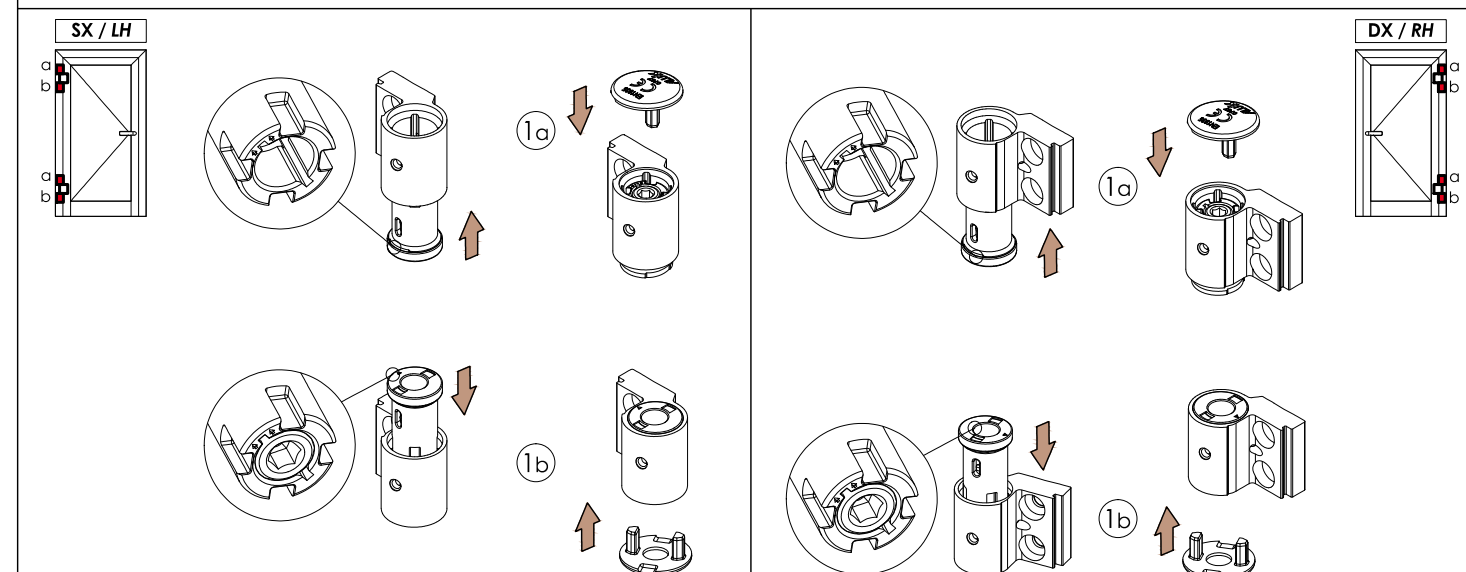
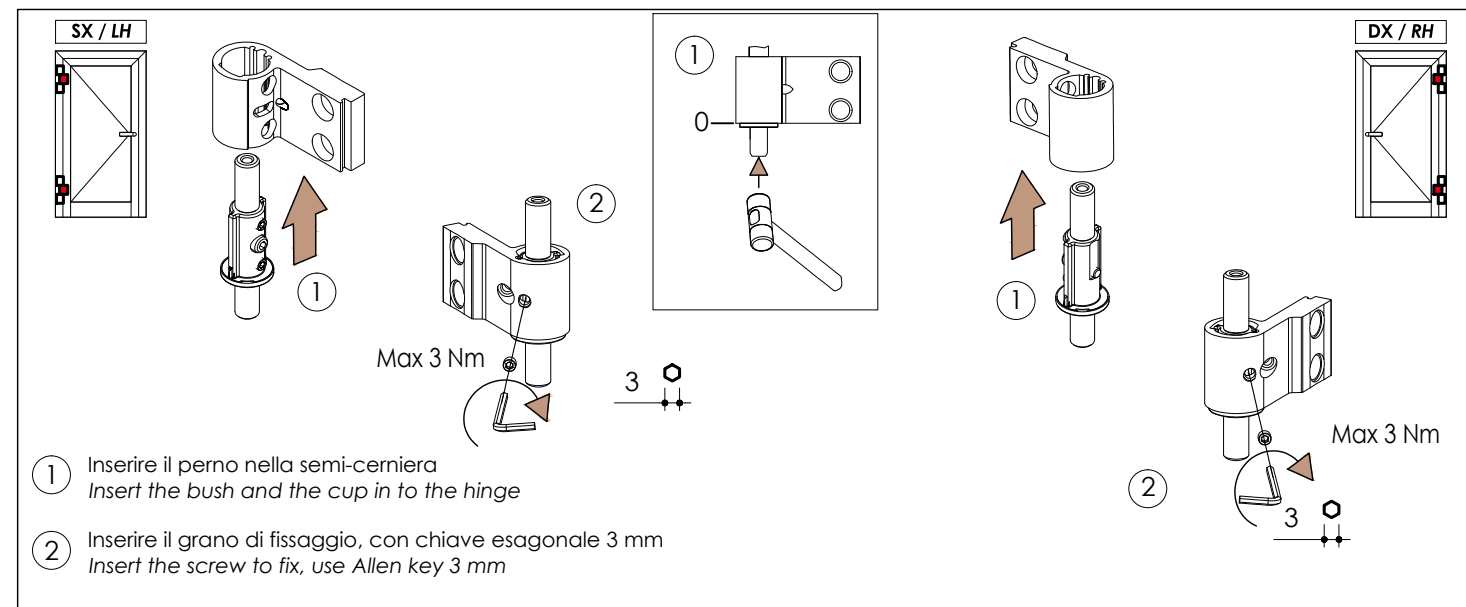
- 1 Sbloccare la vite di fermo, con chiave esagonale 3 mm , e togliere il tappo
Unlock the latch, use hex key 3 mm , and remove the plug
- 2 Effettuare la regolazione (± 0.5 mm), con chiave speciale T50014
Use T50014 to adjustment (± 0.5 mm)
- 3 Inserire il tappo e bloccare il fermo, con chiave esagonale 3 mm
Insert the plug and lock the latch, use Allen key 3mm

OPERAZIONI FINALI FINAL OPERATIONS



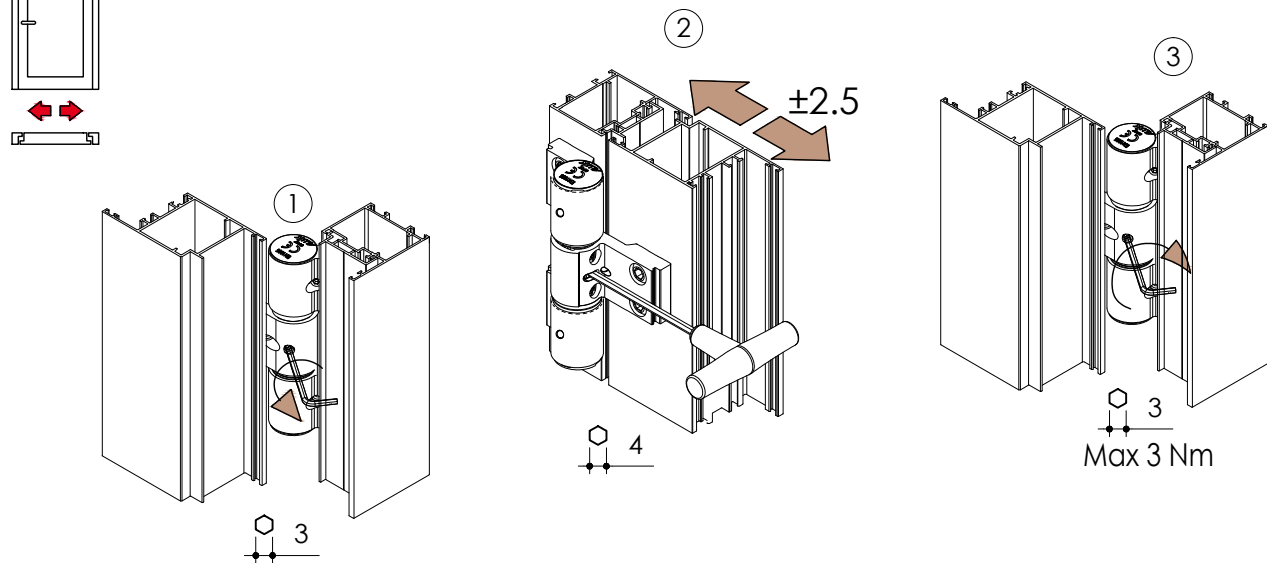
- 1 Inserire le coperture
Insert covers
- 2 Bloccare le cover, con chiave esagonale 3 mm
Block covers, use Allen key 3 mm

SCHEMA DI ASSEMBLAGGIO E MONTAGGIO CERNIERE A 3 ALI
THREE WINGS HINGES ASSEMBLING DIAGRAM



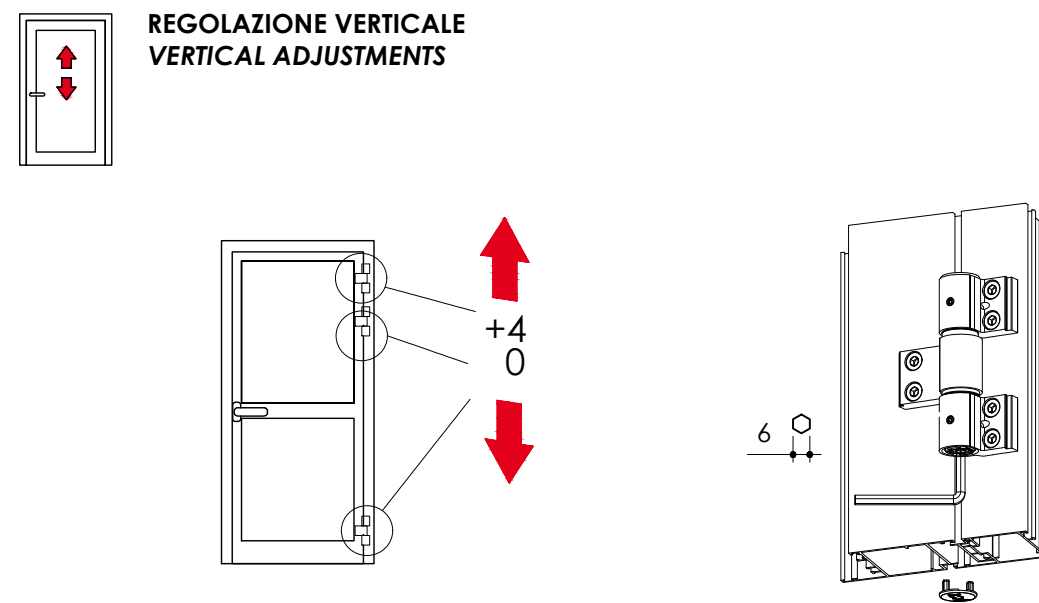
SCHEMA DI REGOLAZIONE CERNIERE 3 ALI THREE WINGS HINGES SETTING DIAGRAM

REGOLAZIONE ORIZZONTALE HORIZONTAL ADJUSTMENTS



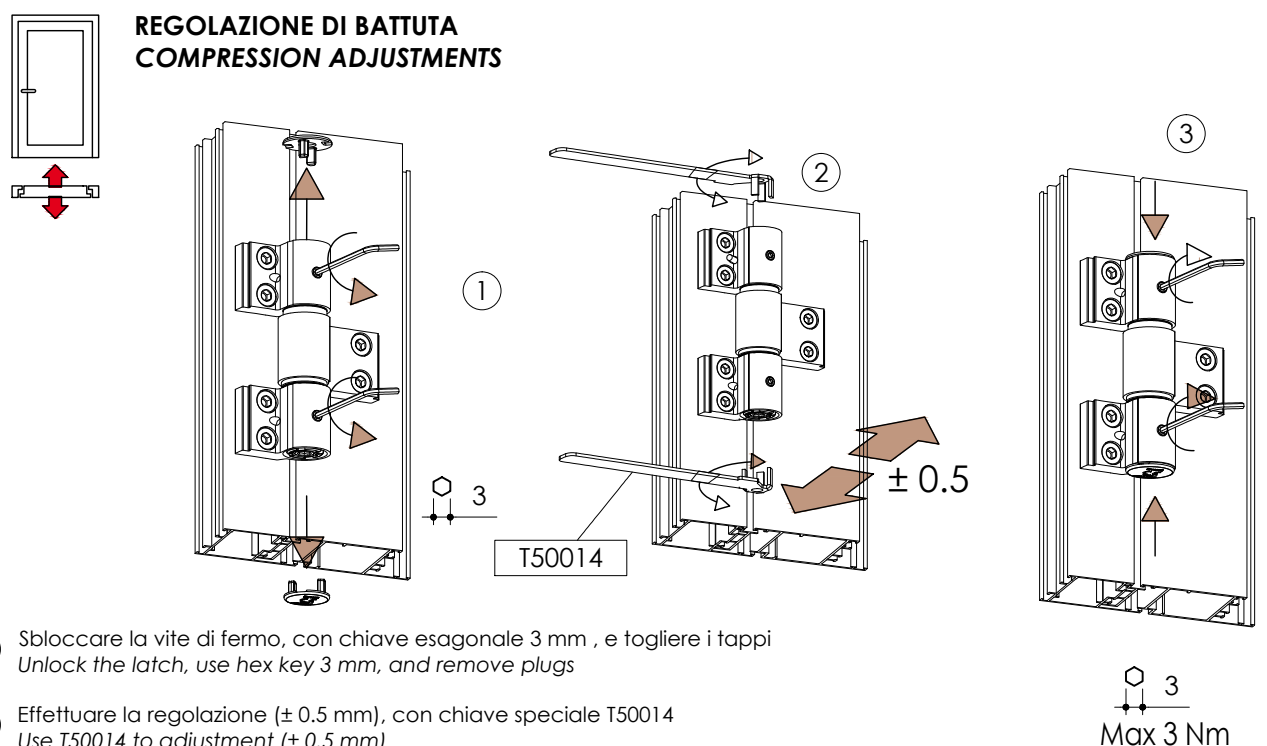
- ① Sbloccare la vite di fermo, con chiave esagonale 3 mm
Unlock the latch, use Allen key 3 mm
- ② Effettuare la regolazione orizzontale (± 0.5 mm), con chiave da 4 mm
Adjust (± 0.5 mm), use Allen key 4 mm
- ③ Bloccare il fermo, con chiave esagonale 3 mm
Lock the latch, use Allen key 3mm

REGOLAZIONE VERTICALE VERTICAL ADJUSTMENTS



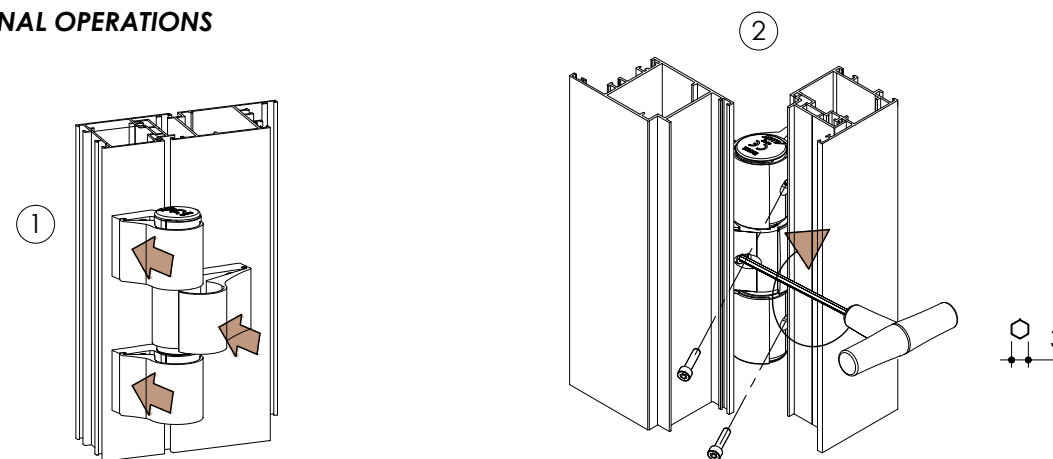
- ① Rimuovere il tappo
Remove the plug
- ② Effettuare la regolazione (+ 4 mm/ 0), con chiave da 6 mm
Adjust (+ 4 mm/ 0), use hex key 6mm

REGOLAZIONE DI BATTUTA COMPRESSION ADJUSTMENTS

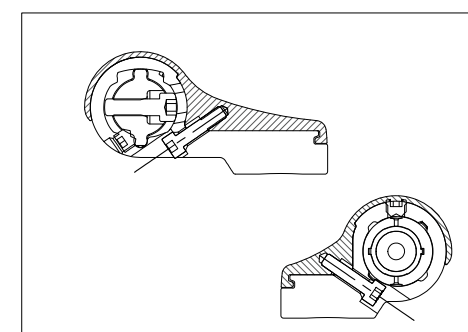


- ① Sbloccare la vite di fermo, con chiave esagonale 3 mm, e togliere i tappi
Unlock the latch, use hex key 3 mm, and remove plugs
- ② Effettuare la regolazione (± 0.5 mm), con chiave speciale T50014
Use T50014 to adjustment (± 0.5 mm)
- ③ Inserire i tappi e bloccare il fermo, con chiave esagonale 3 mm
Insert plugs and lock the latch, use Allen key 3mm

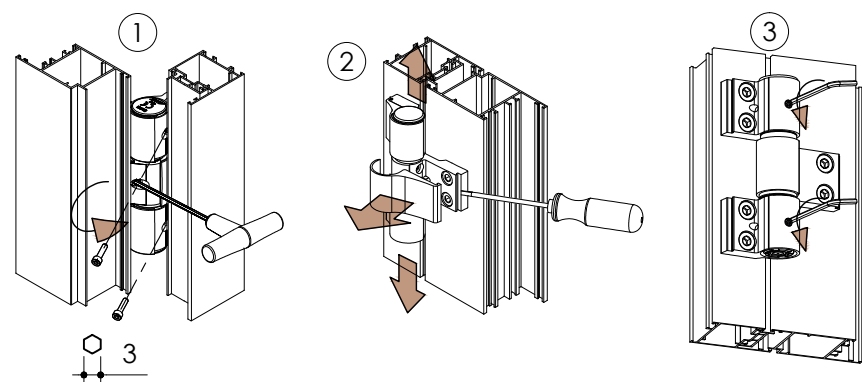
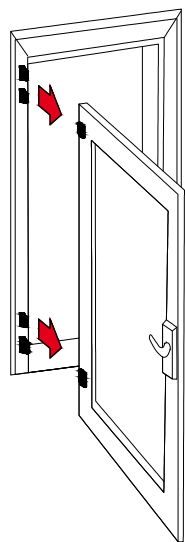
OPERAZIONI FINALI FINAL OPERATIONS



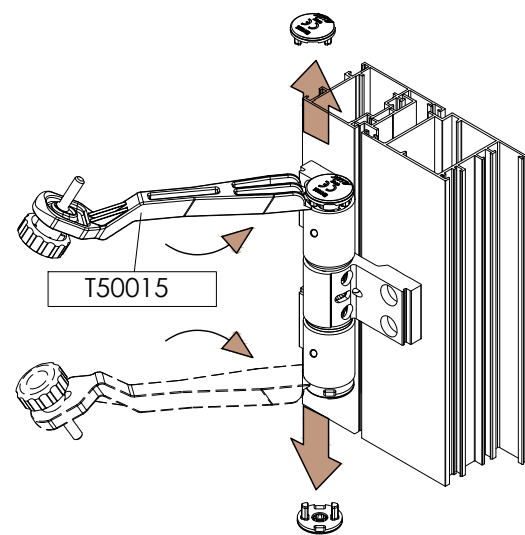
- ① Inserire le coperture
Insert covers
- ② Bloccare le cover, con chiave esagonale 3 mm
Block covers, use Allen key 3 mm



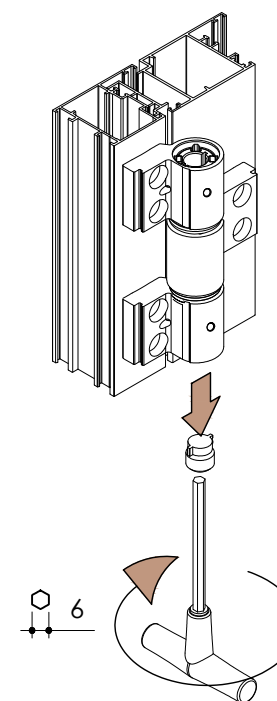
SCHEMA DI SMONTAGGIO CERNIERE 3 ALI
THREE WING HINGES DISASSEMBLING DIAGRAM



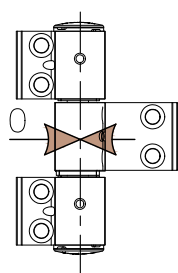
- ① Sbloccare le viti che fissano le cover, con chiave esagonale 3 mm
Unlock the covers fixing screws, use Allen key 3 mm
- ② Rimuovere le cover
Remove covers
- ③ Rimuovere il grano di fissaggio boccola, con chiave esagonale 3 mm
Remove the set screw, use Allen key 3mm



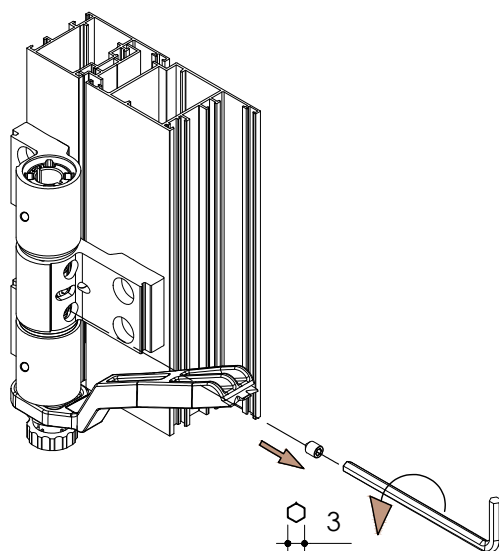
- Rimuovere i tappi, con attrezzo speciale T50015
Remove the plugs, use T50015 tool



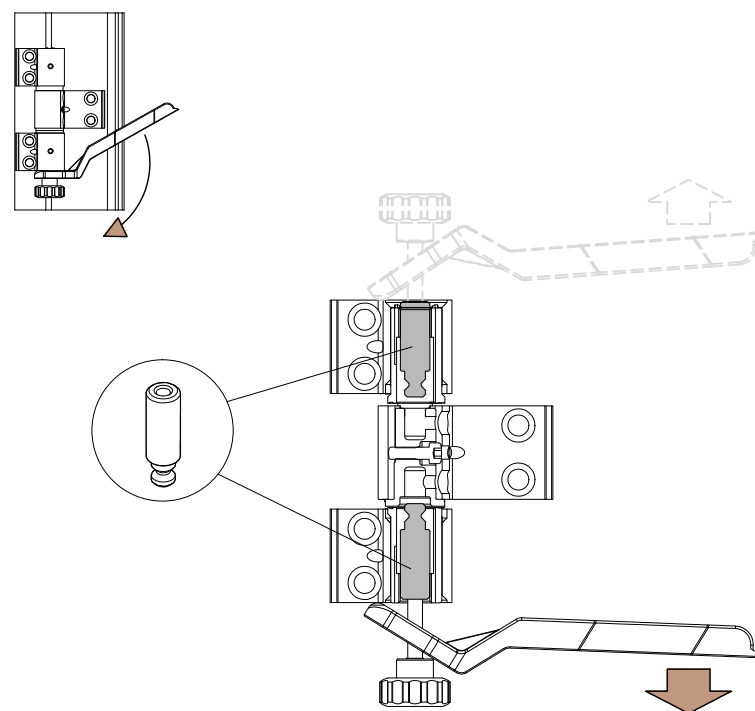
- Svitare la vite di regolazione verticale
Unscrew the vertical adjusting screw



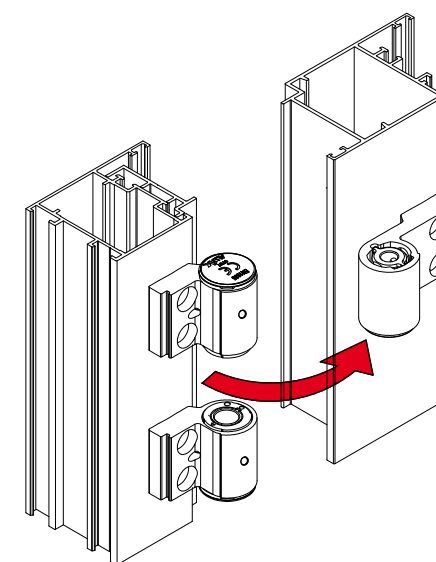
⚠ La cerniera dev'essere regolata a 0
The hinge has to be in "0" position



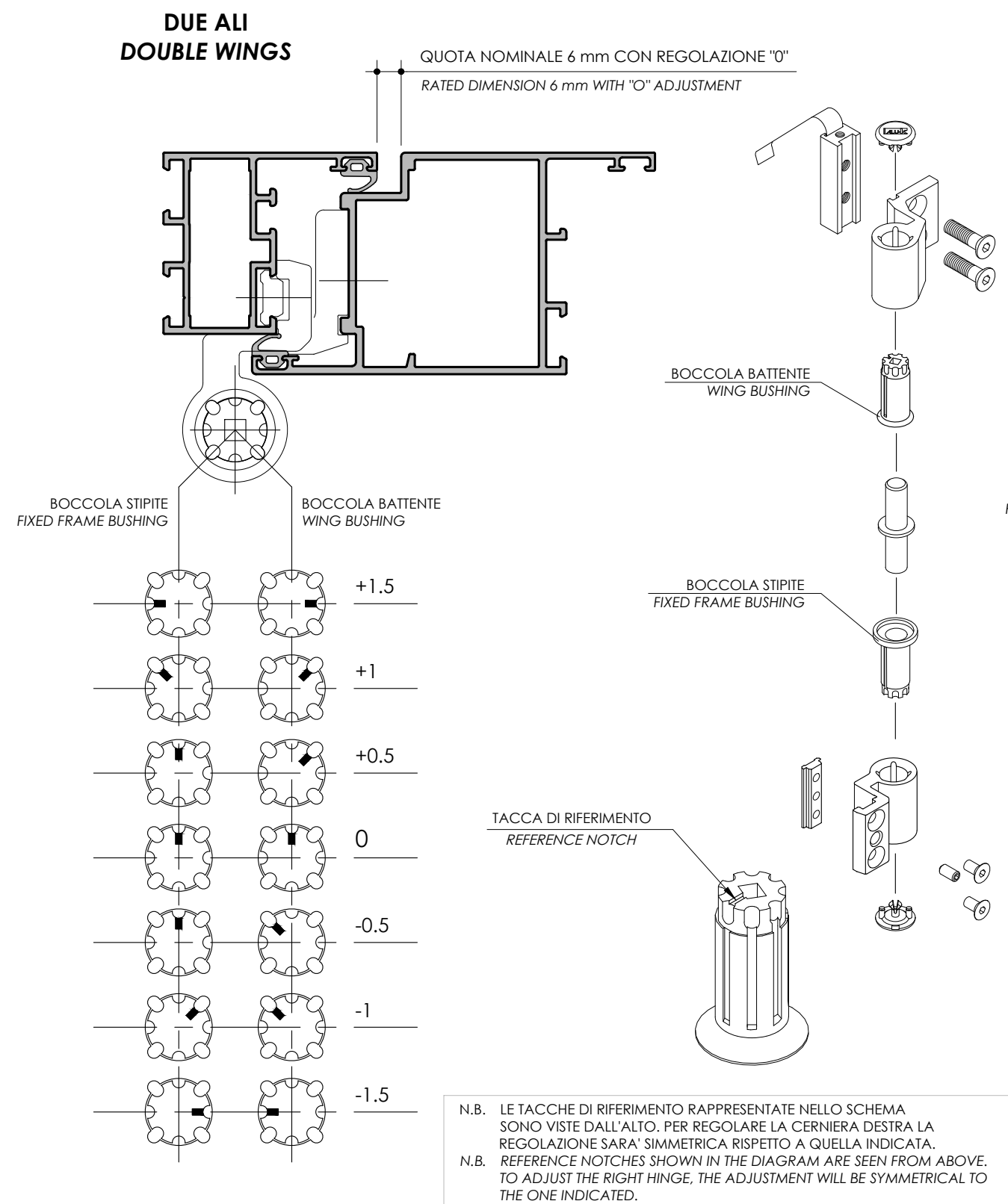
- Avvitare estrattore perno art. T50015
Tighten art. T50015
- Rimuovere il grano di fissaggio perno
Remove the pin fixing screw
- Ripetere l'operazione con la semicerniera superiore
Repeat the operation with the upper half hinge



- Sfilare il perno
Remove the pin
- Ripetere l'operazione con la semicerniera superiore
Repeat the operation with the upper half hinge

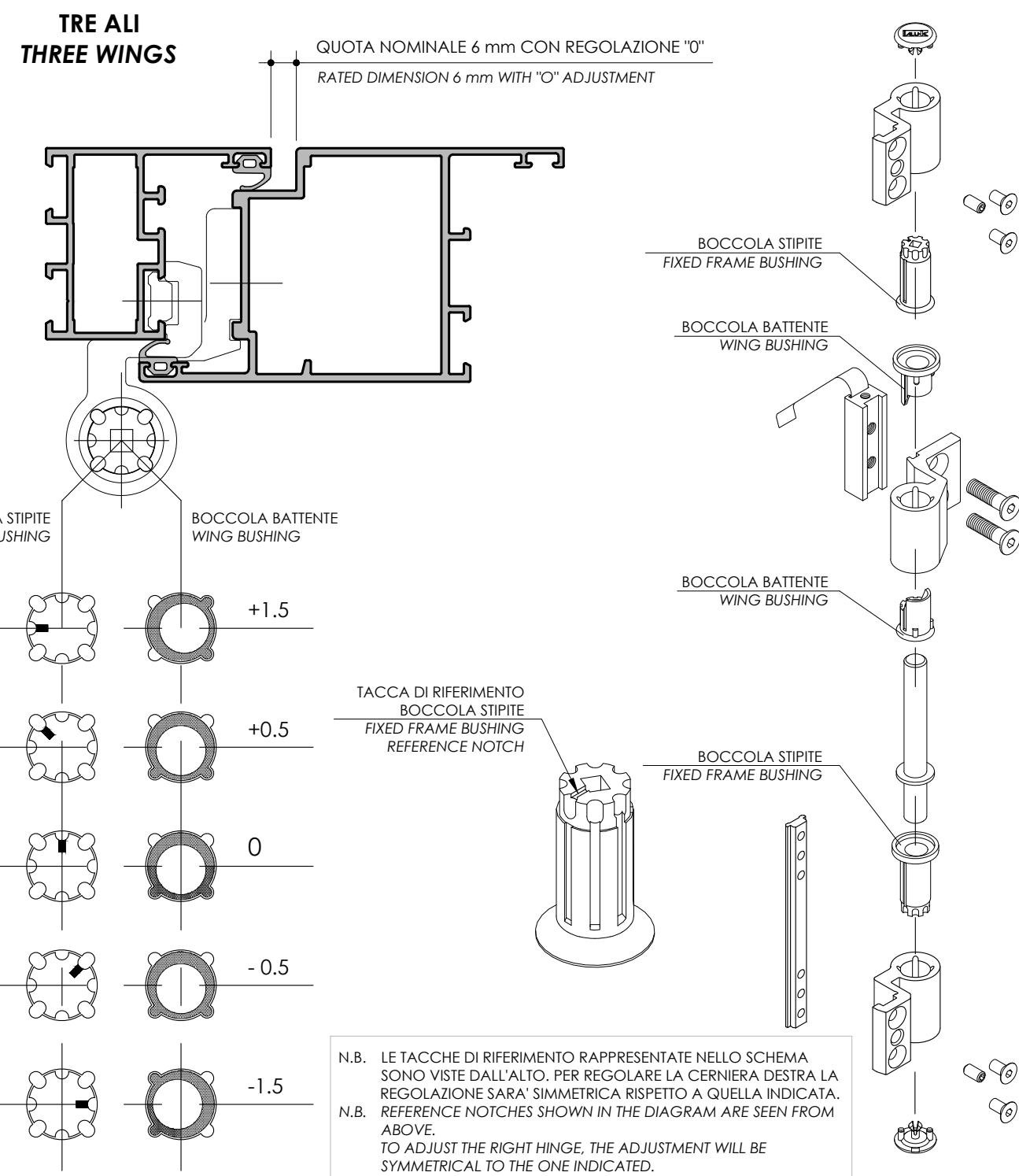


SCHEMA DI REGOLAZIONE CERNIERA A CONTRASTO PER PORTE A SORMONTO OVERLAP DOORS CONTRAST HINGES SETTING DIAGRAM



PER LA REGOLAZIONE DELLE CERNIERE SI DOVRA' AGIRE RUOTANDO LE BOCCOLE SECONDO LO SCHEMA QUI SOPRA ILLUSTRATO. PER REGISTRARE LE CERNIERE DI UNA PORTA GIA' INSTALLATA SI DOVRA' ALLEGGERIRE IL BATTENTE INSERENDO UNA ZEPPA A CUNEO TRA PAVIMENTO E BATTENTE STESSO, OPPURE UTILIZZANDO L'APPOSITO ATTREZZO A PEDALE. UNA VOLTA RUOTATE LE BOCCOLE NELLA POSIZIONE DESIDERATA SI DOVRANNO INSERIRE I RELATIVI TAPPI D'ARRESTO.

FOR HINGES SETTING, A BUSHING ROTATION MUST BE DONE ACCORDING TO THE DIAGRAM SHOWN ABOVE. TO SET HINGES OF AN ALREADY INSTALLED DOOR, MUST BE LIGHTEN THE SHUTTER BY INSERTING A WEDGE BETWEEN THE FLOOR AND THE SAME SHUTTER, OR TO USE THE SUITABLE PEDAL DEVICE. ONCE ROTATED THE BUSHING INTO THE RIGHT POSITION, THE STOP-PLUGS MUST BE INSERTED.

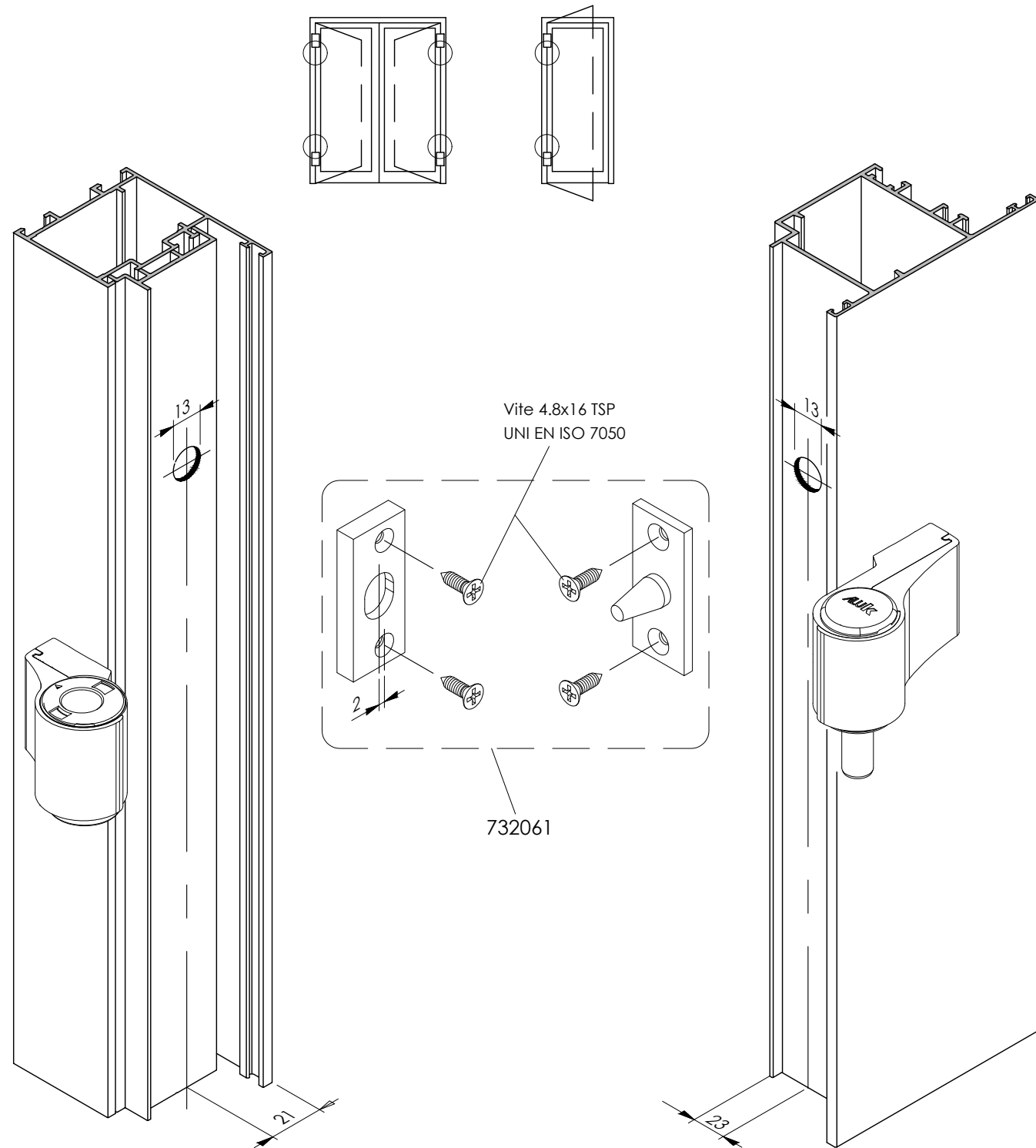


LA REGOLAZIONE DELLA CERNIERA A TRE ALI DEVE ESSERE ESEGUITA IN OFFICINA POSIZIONANDO LE BOCCOLE DELLA CERNIERA BATTENTE SECONDO LO SCHEMA ILLUSTRATO. E' COMUNQUE POSSIBILE UN PICCOLO AGGIUSTAGGIO A PORTA GIA' INSTALLATA (± 0.5 mm) SENZA SMONTARE LE CERNIERE DELLO STIPITE. PER REGOLAZIONI PIU' IMPORTANTI SI DOVRANNO SMONTARE LE DUE CERNIERE DI STIPITE, AVENDO CURA DI NON FAR CADERE LE CONTROPIASTRE INTERNE AL TUBOLARE; QUINDI SI DOVRA' SFILARE IL PERNO E RIPOSIZIONARE LE DUE BOCCOLE DELLA CERNIERA BATTENTE SECONDO LO SCHEMA. LA REGOLAZIONE DOVRA' ESSERE ESEGUITA RUOTANDO LE DUE CHIAVI CONTEMPORANEAMENTE.

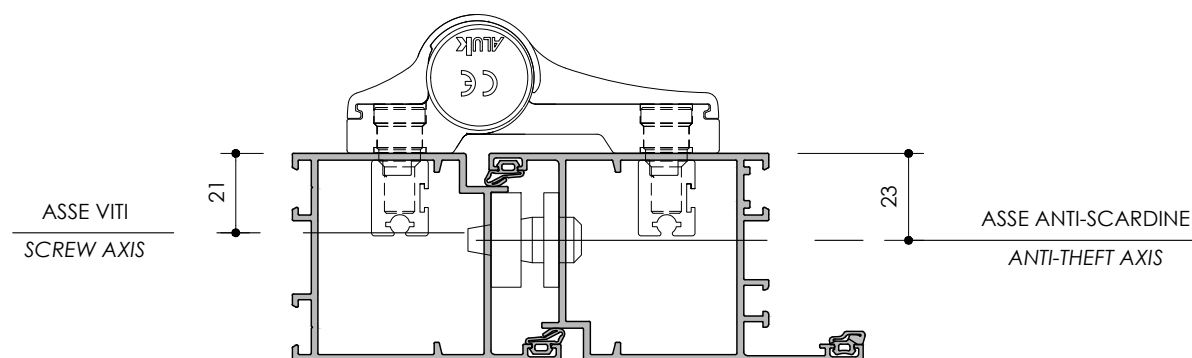
THE THREE-WING HINGES ADJUSTMENT MUST BE DONE IN THE WORKSHOP, POSITIONING SASH HINGE BUSHING ACCORDING TO THE DIAGRAM SHOWN ABOVE. IN ANY CASE, A SMALL ADJUSTMENT OF AN ALREADY INSTALLED DOOR IS ALWAYS POSSIBLE, WITHOUT DISASSEMBLING THE FIXED FRAME HINGES. FOR BIGGER ADJUSTMENTS, THE TWO FIXED FRAME HINGES MUST BE UNSET, TAKING CARE NOT TO LET FALL THE COUNTERPLATES INSIDE THE TUBULAR SECTION. ANSET THEN THE PIN AND REPLACE THE TWO WING HINGE BUSHING AS SHOWN IN THE DIAGRAM. SETTING MUST BE DONE ROTATING THE TWO WRENCHES AT THE SAME TIME.

SCHEMA DI MONTAGGIO KIT ANTISCARDINE PER PORTE
ASSEMBLY DIAGRAM FOR ANTI-THEFT DEVICE ON DOORS

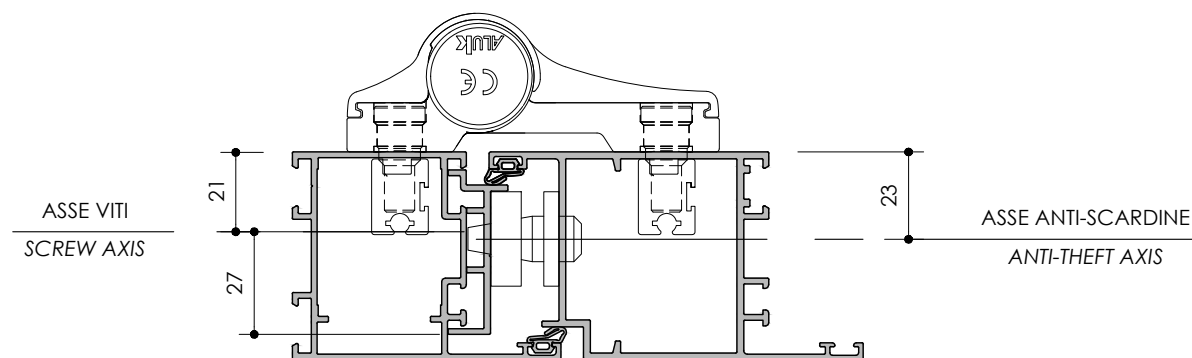
POSIZIONAMENTO DISPOSITIVO ANTISCARDINE
ANTI-THEFT DEVICE POSITION



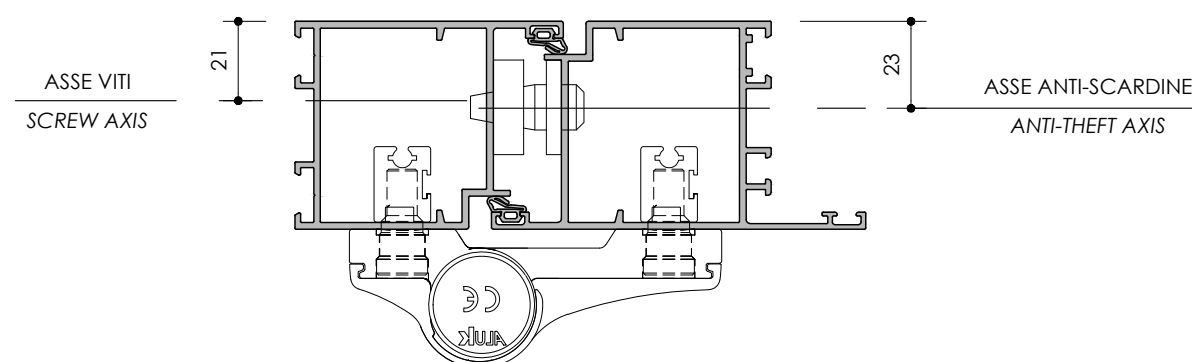
APERTURA INTERNA - INWARD OPENING



APERTURA INTERNA - INWARD OPENING

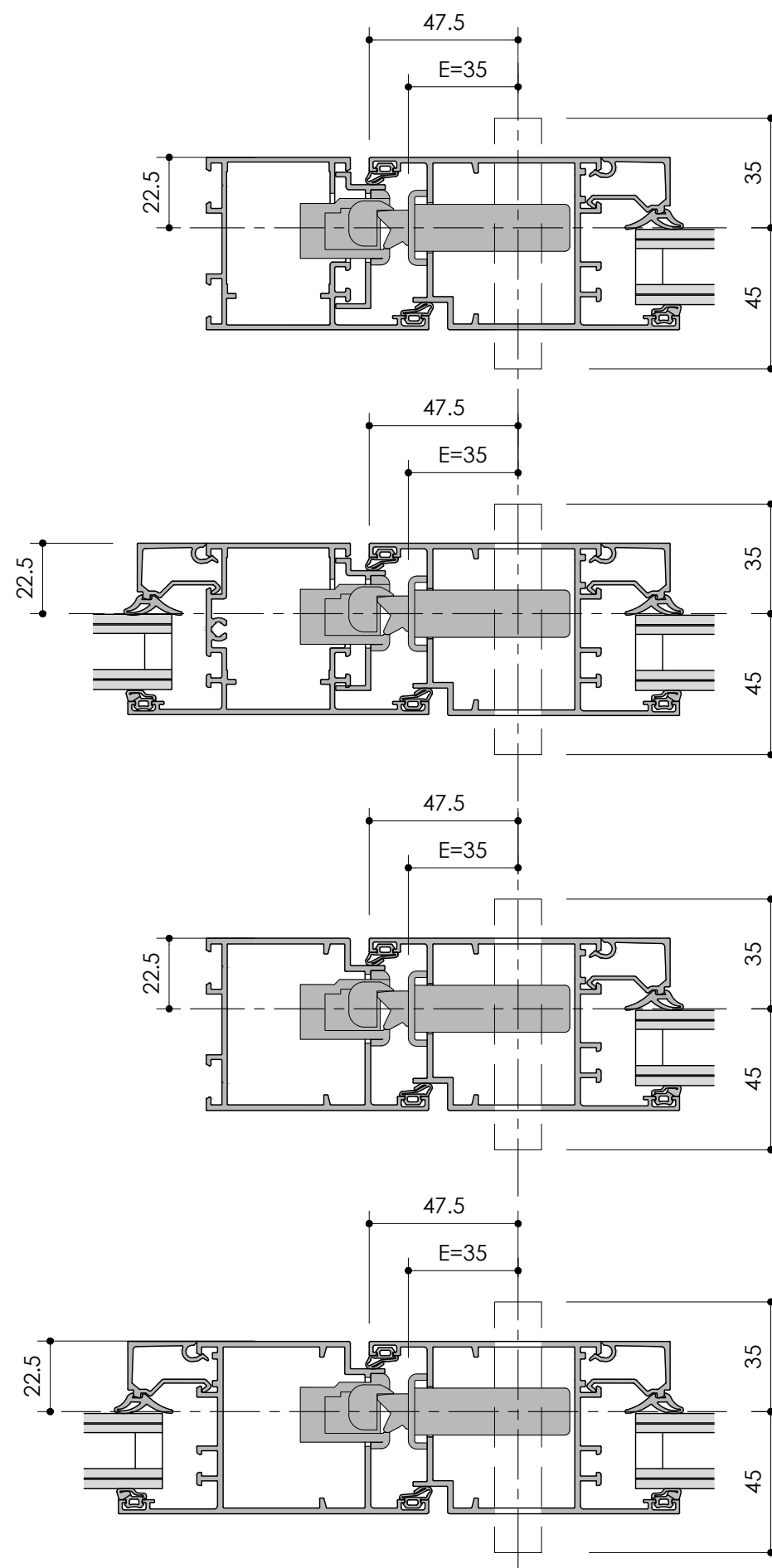
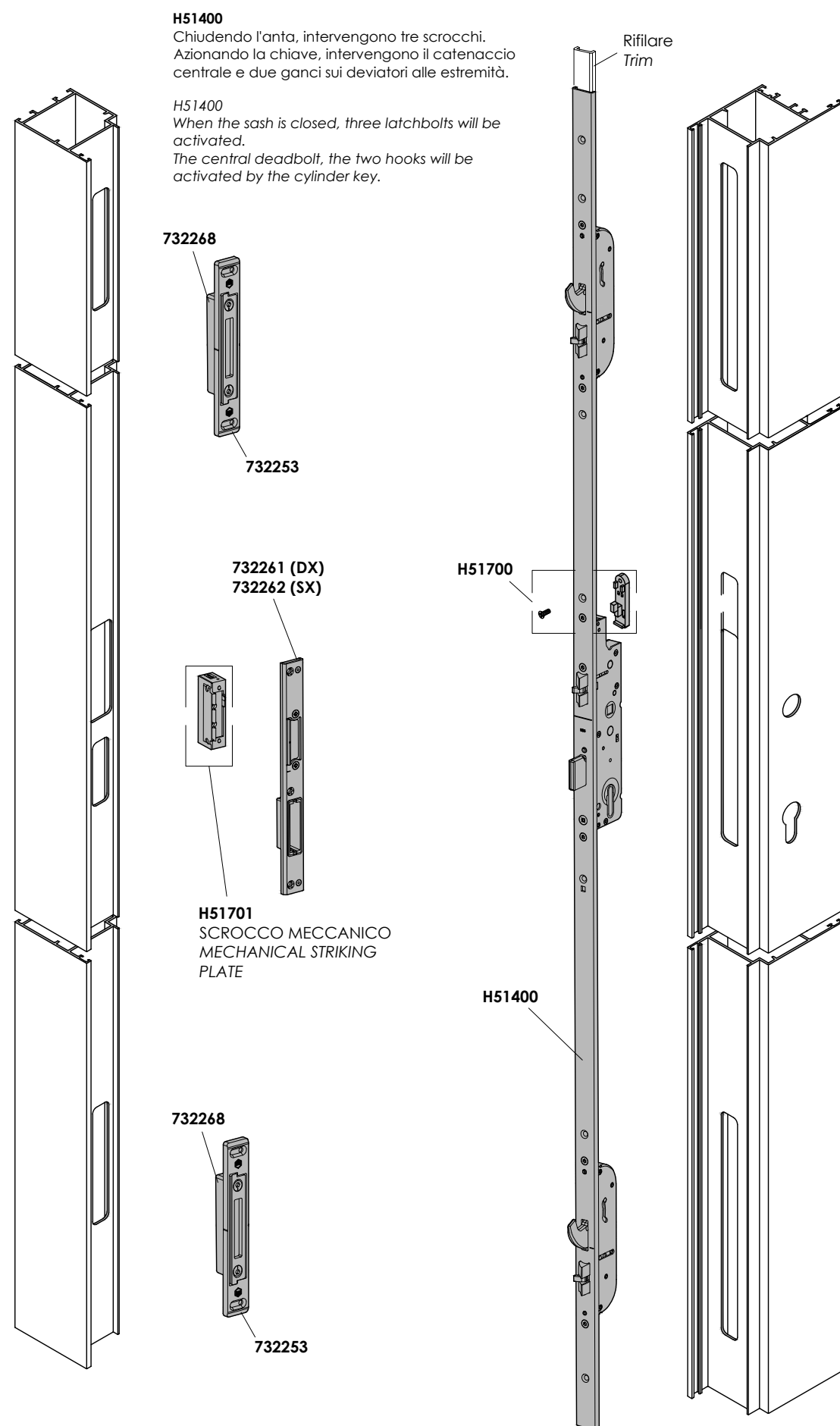


APERTURA ESTERNA - OUTWARD OPENING



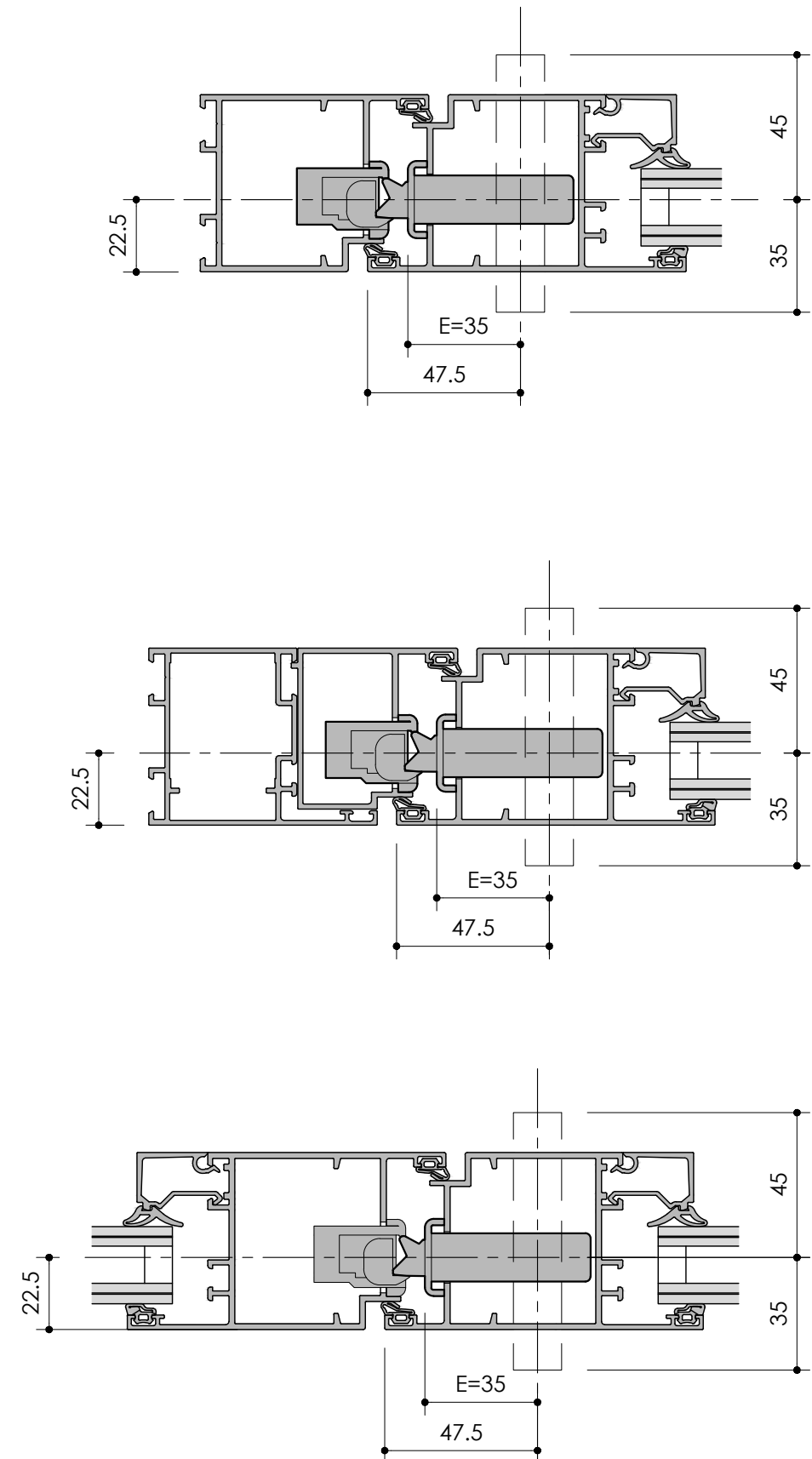
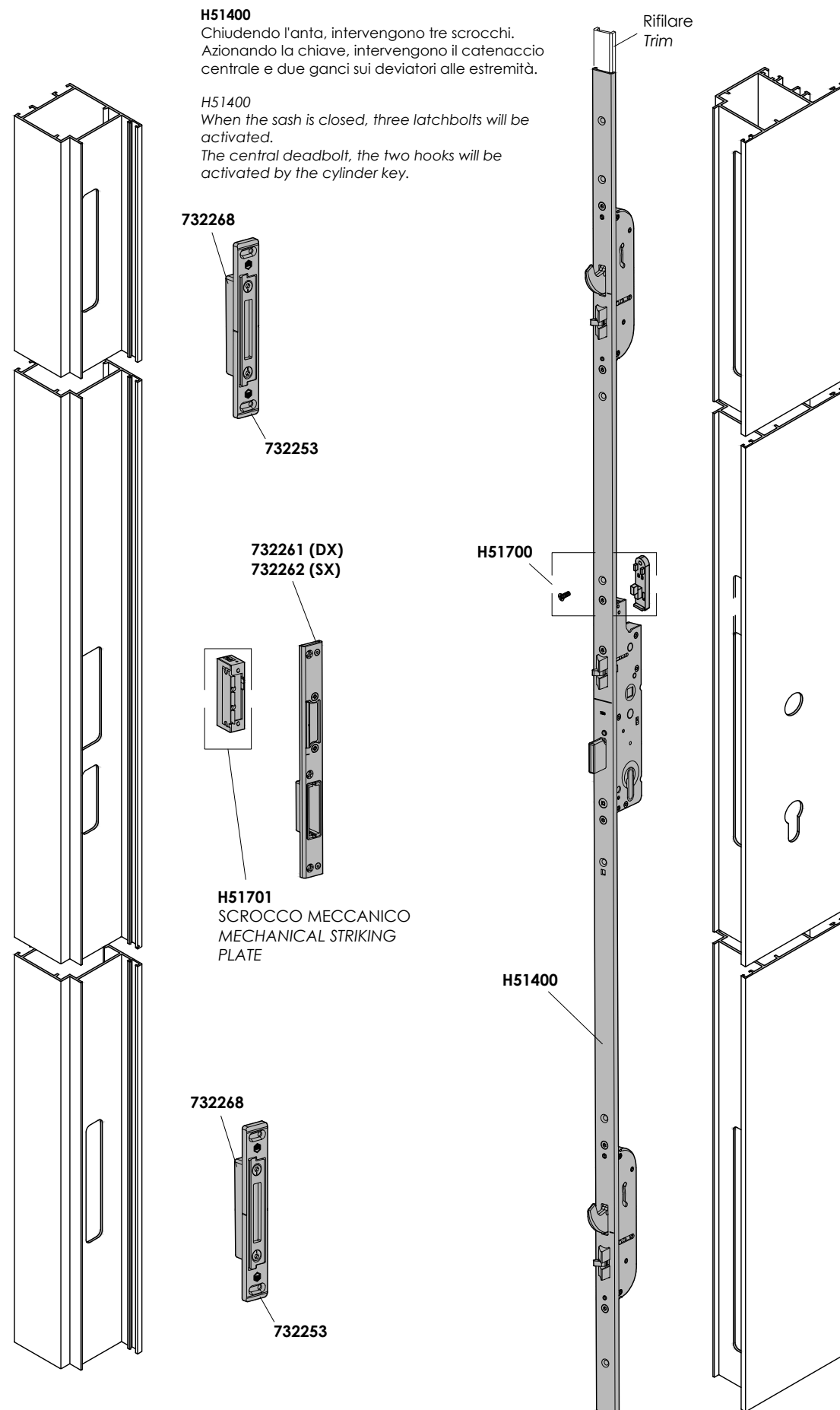
PORTE APERTURA INTERNA, MONTAGGIO SERRATURA H51400 CON SCROCCHI, PUNZONI E RELATIVI INCONTRI
INTERNAL DOORS OPENING, ASSEMBLY LOCKING DEVICE H51400 WITH LATCH, PUNCH AND RELATED STRIKING PLATE

C45K-NI	C55K-NI
	●

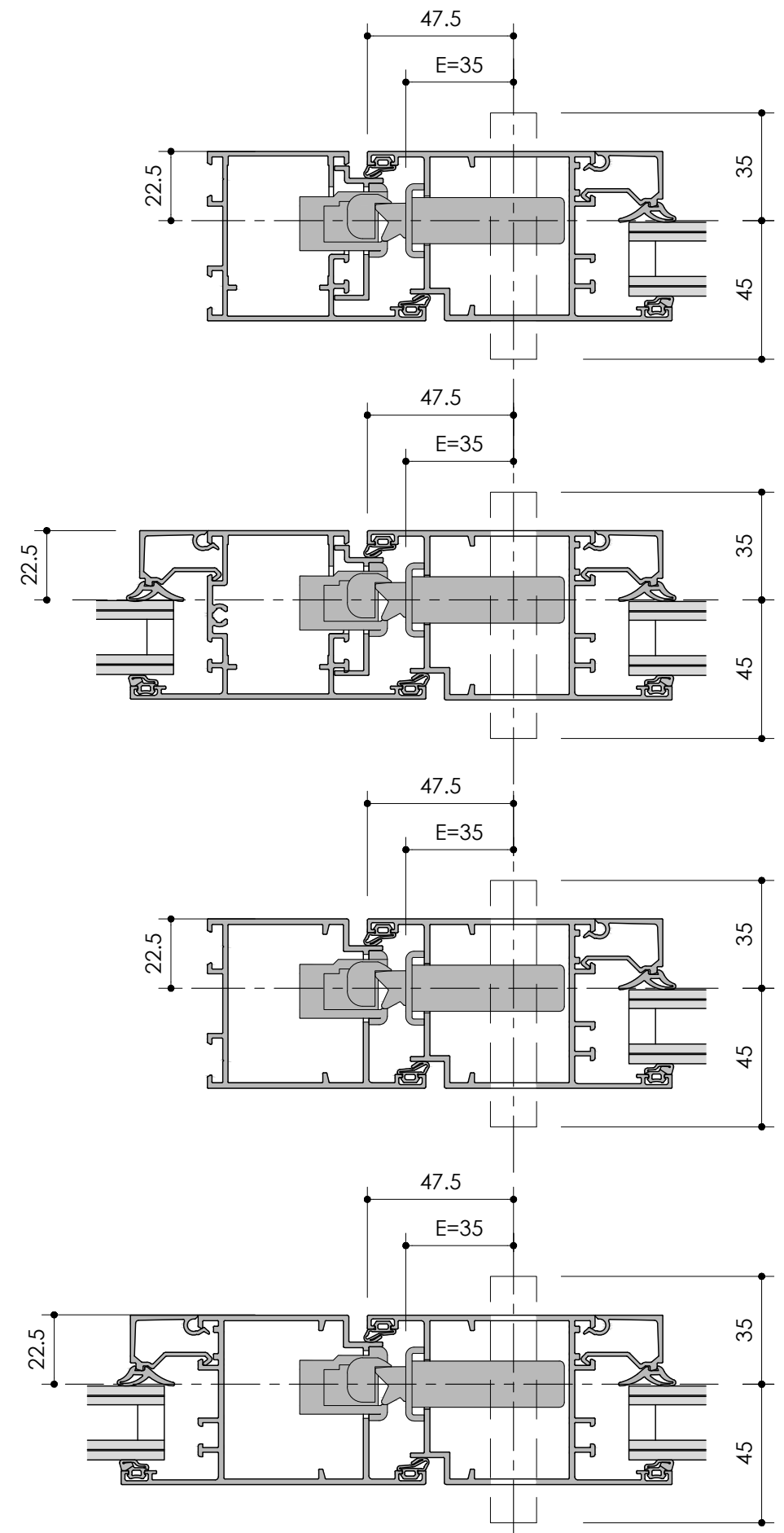
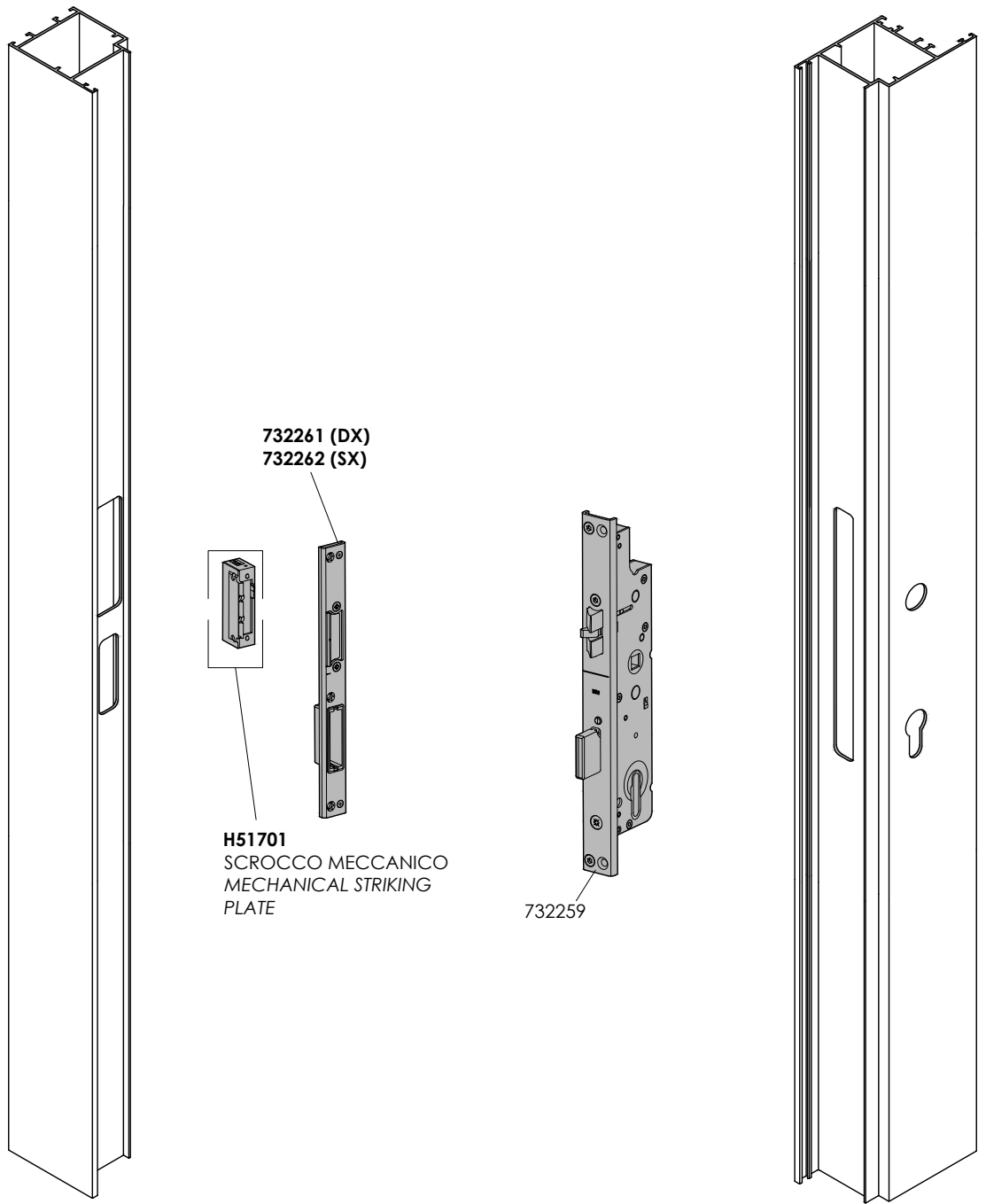


PORTE APERTURA ESTERNA, MONTAGGIO SERRATURA H51400 CON SCROCCHI, PUNZONI E RELATIVI INCONTRI
EXTERNAL DOORS OPENING, ASSEMBLY LOCKING DEVICE H51400 WITH LATCH, PUNCH AND RELATED STRIKING PLATE

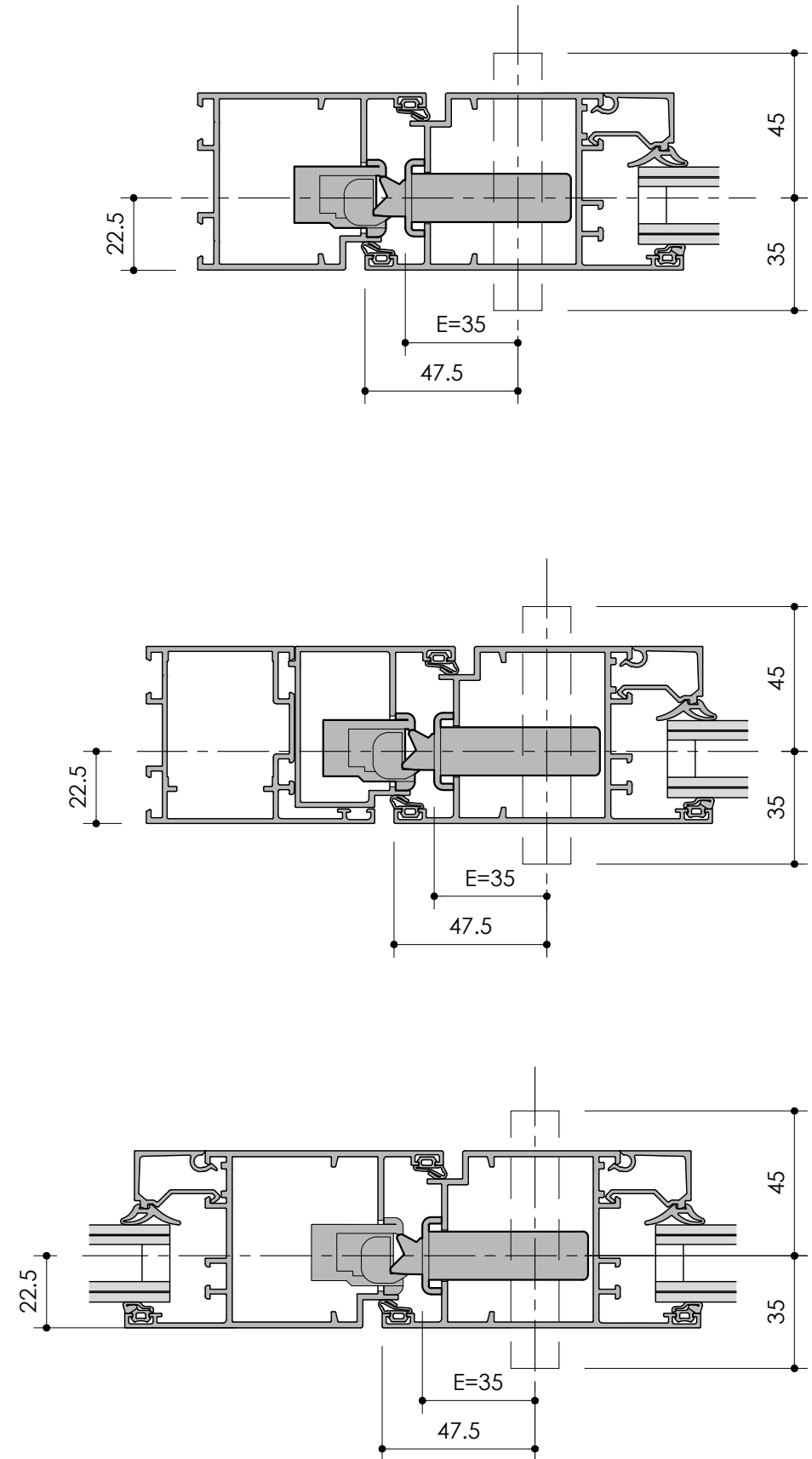
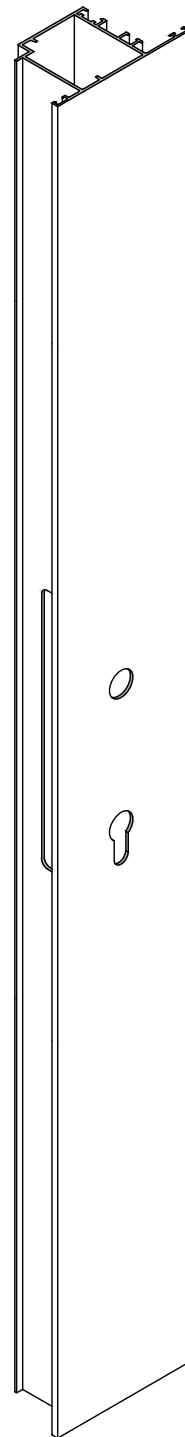
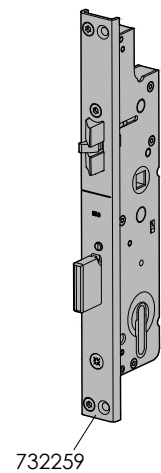
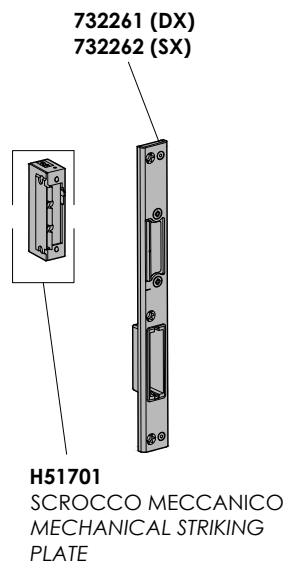
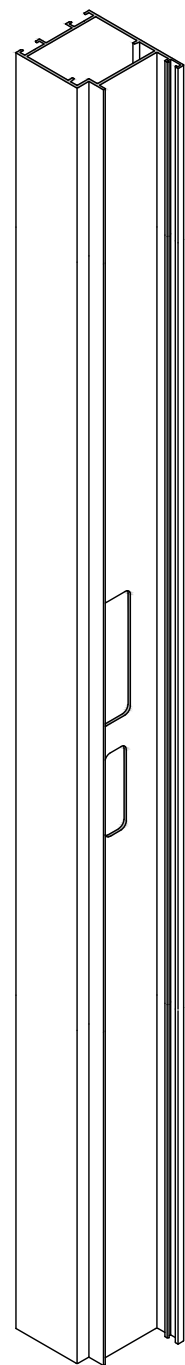
C45K-NI	C55K-NI
	●



▶ PORTE APERTURA INTERNA, MONTAGGIO SERRATURA 732259 CON SCROCCO E RELATIVI INCONTRI
INTERNAL DOORS OPENING, ASSEMBLY LOCKING DEVICE 732259 WITH LATCH AND RELATED STRIKING PLATE

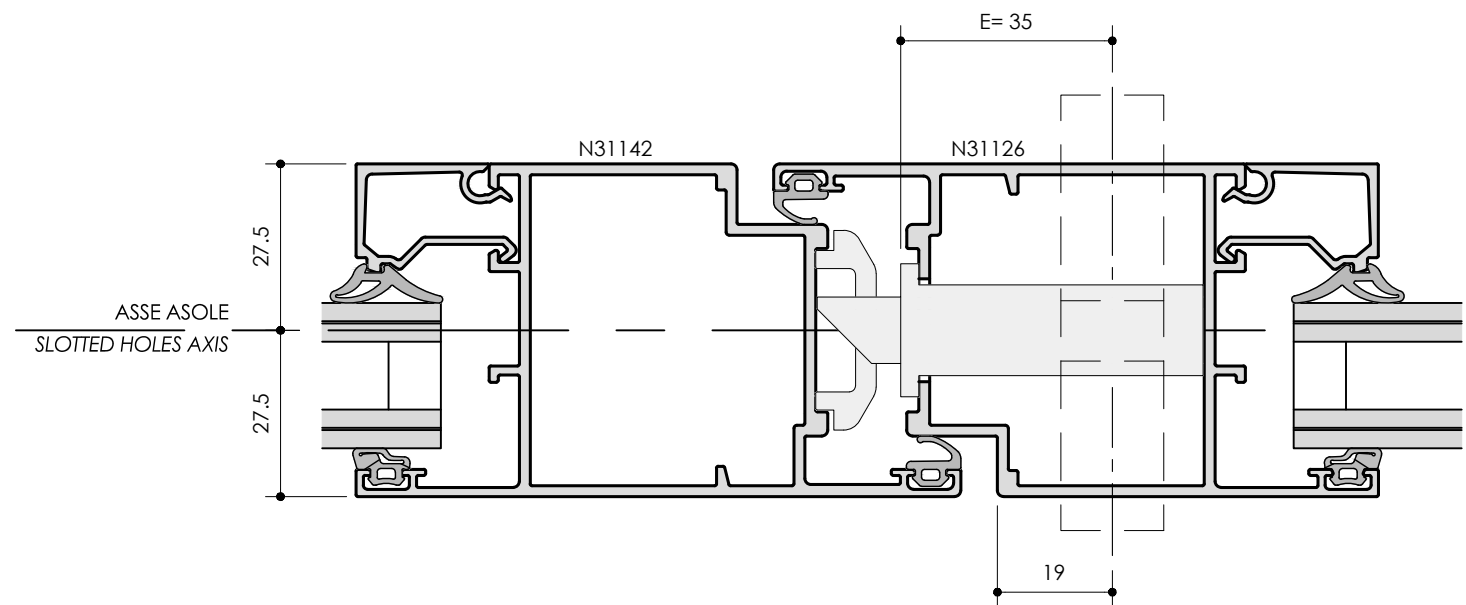
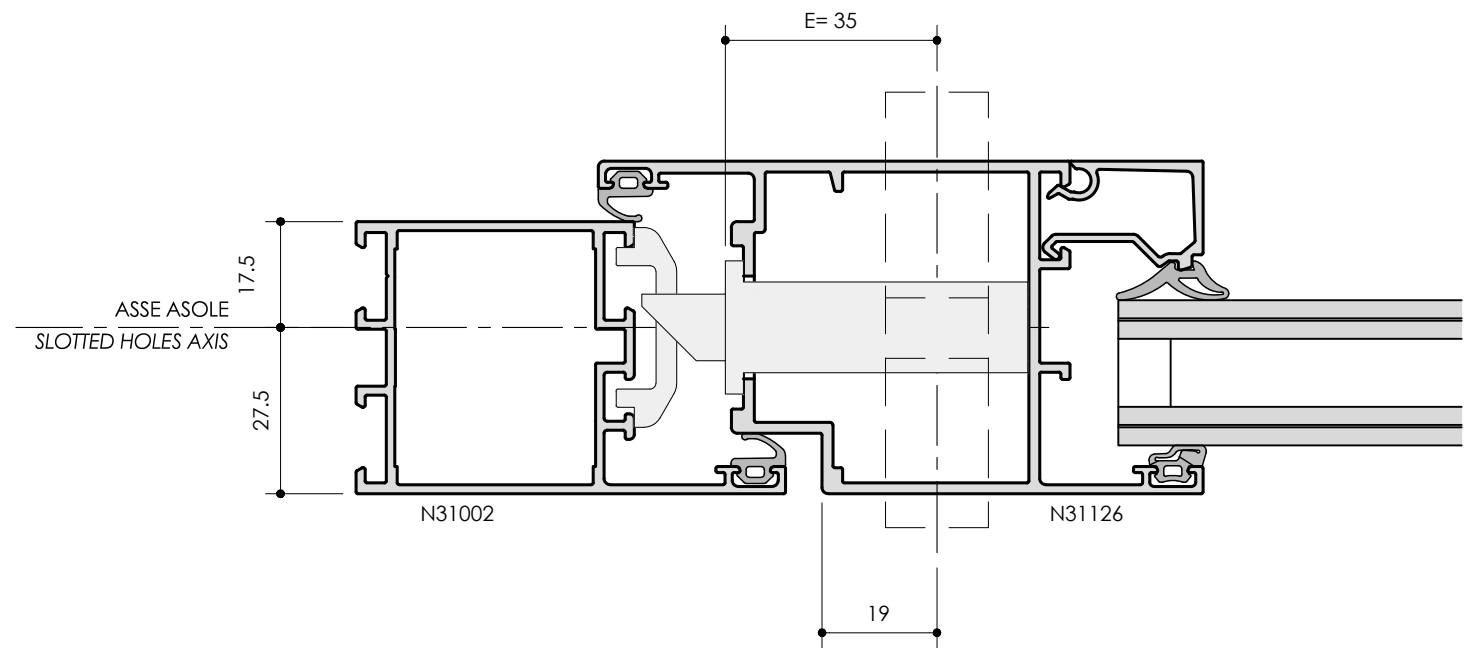
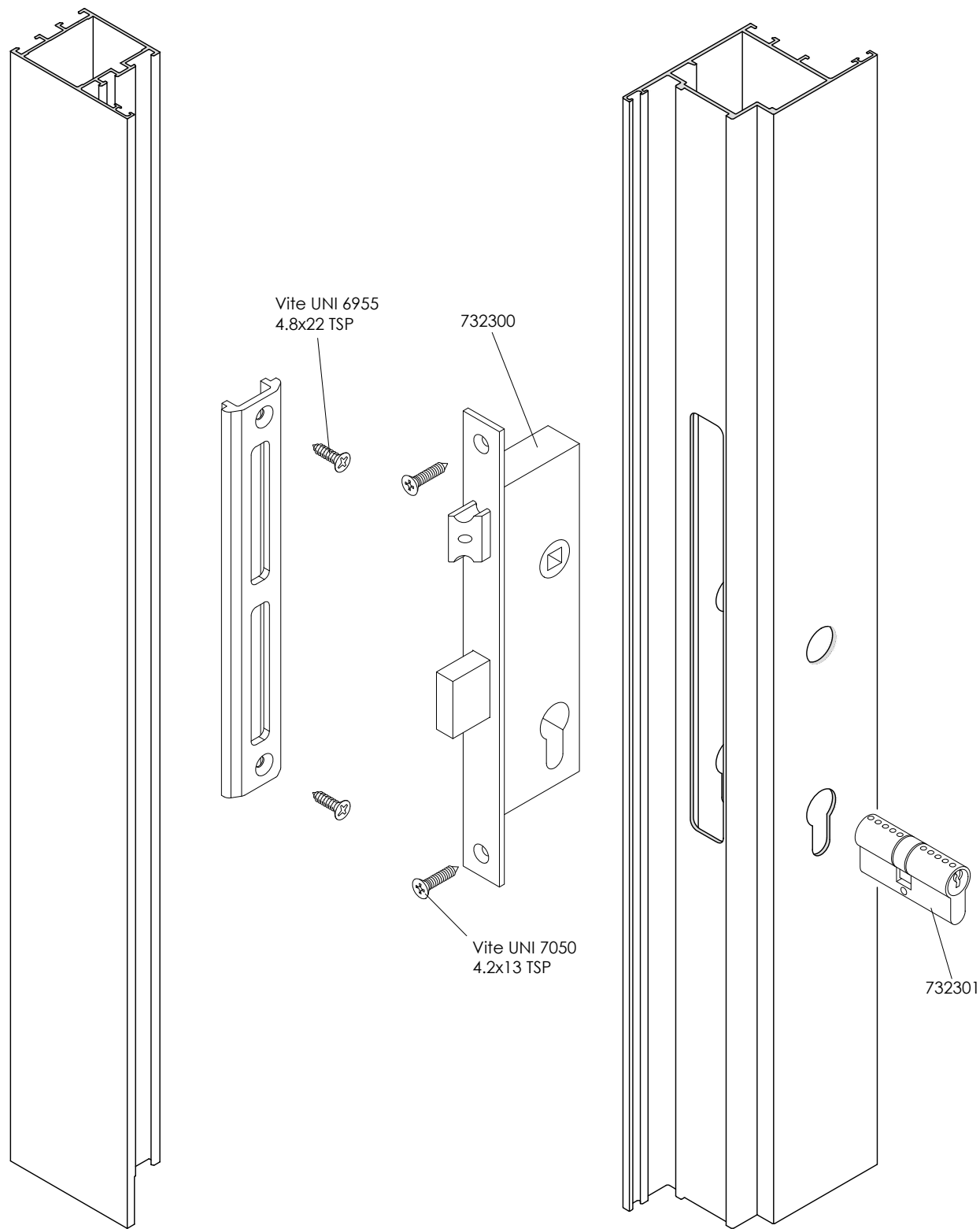


▶ **PORTE APERTURA ESTERNA, MONTAGGIO SERRATURA 732259 CON SCROCCO E RELATIVI INCONTRI**
EXTERNAL DOORS OPENING, ASSEMBLY LOCKING DEVICE 732259 WITH LATCH AND RELATED STRIKING PLATE



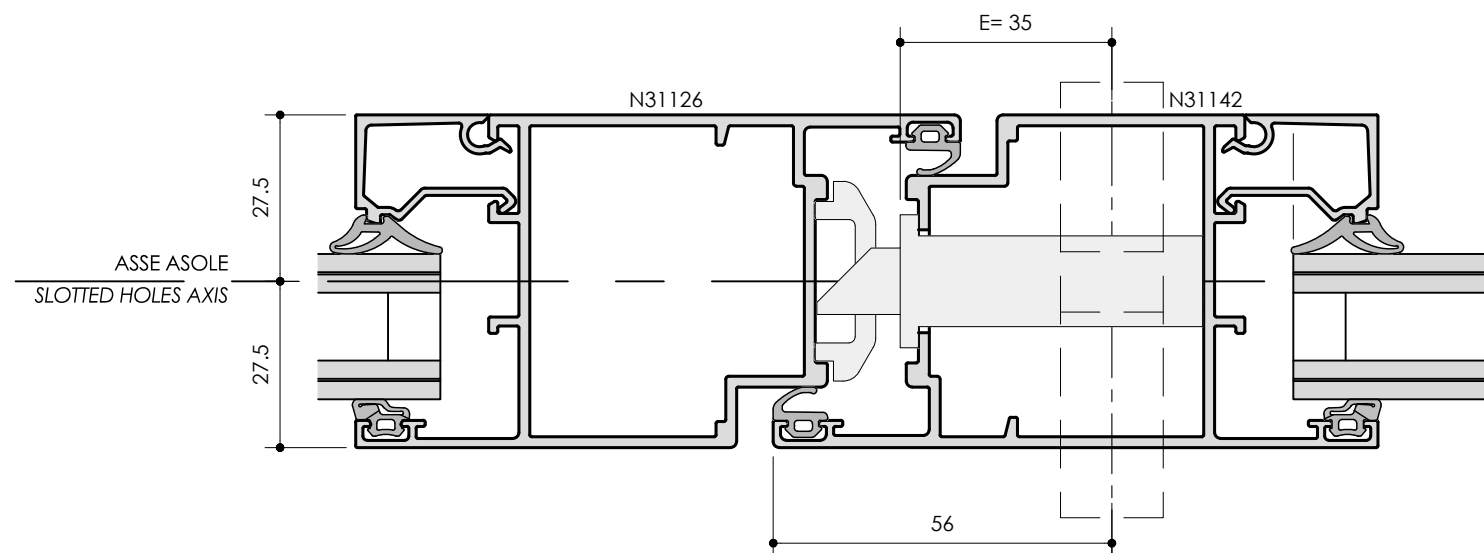
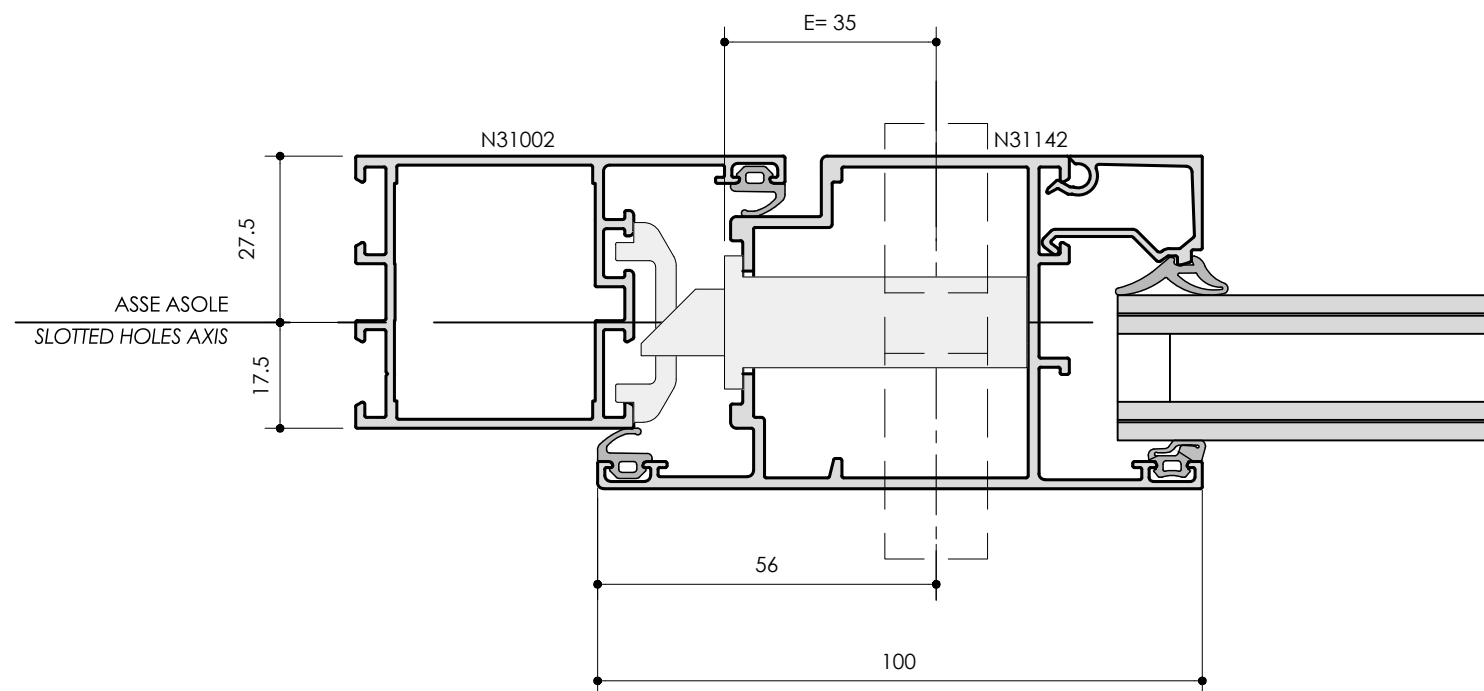
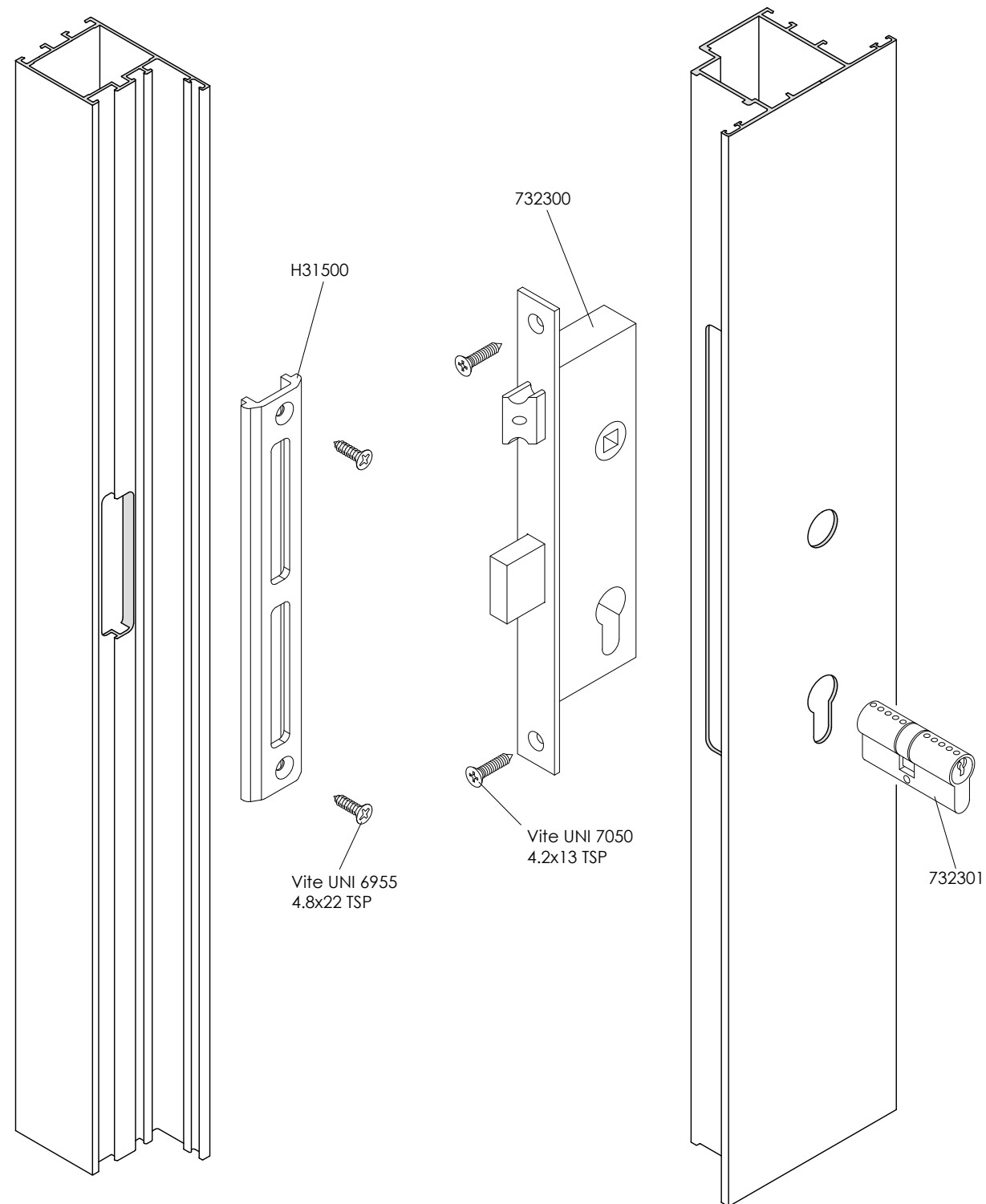
ASSEMBLAGGIO SERRATURA 732300 PORTE DOPPIO SORMONTO - APERTURA INTERNA
732300 DOUBLE OVERLAP DOORS LOCKING DEVICE ASSEMBLING - INWARD OPENING

C45K-NI	C55K-NI
●	



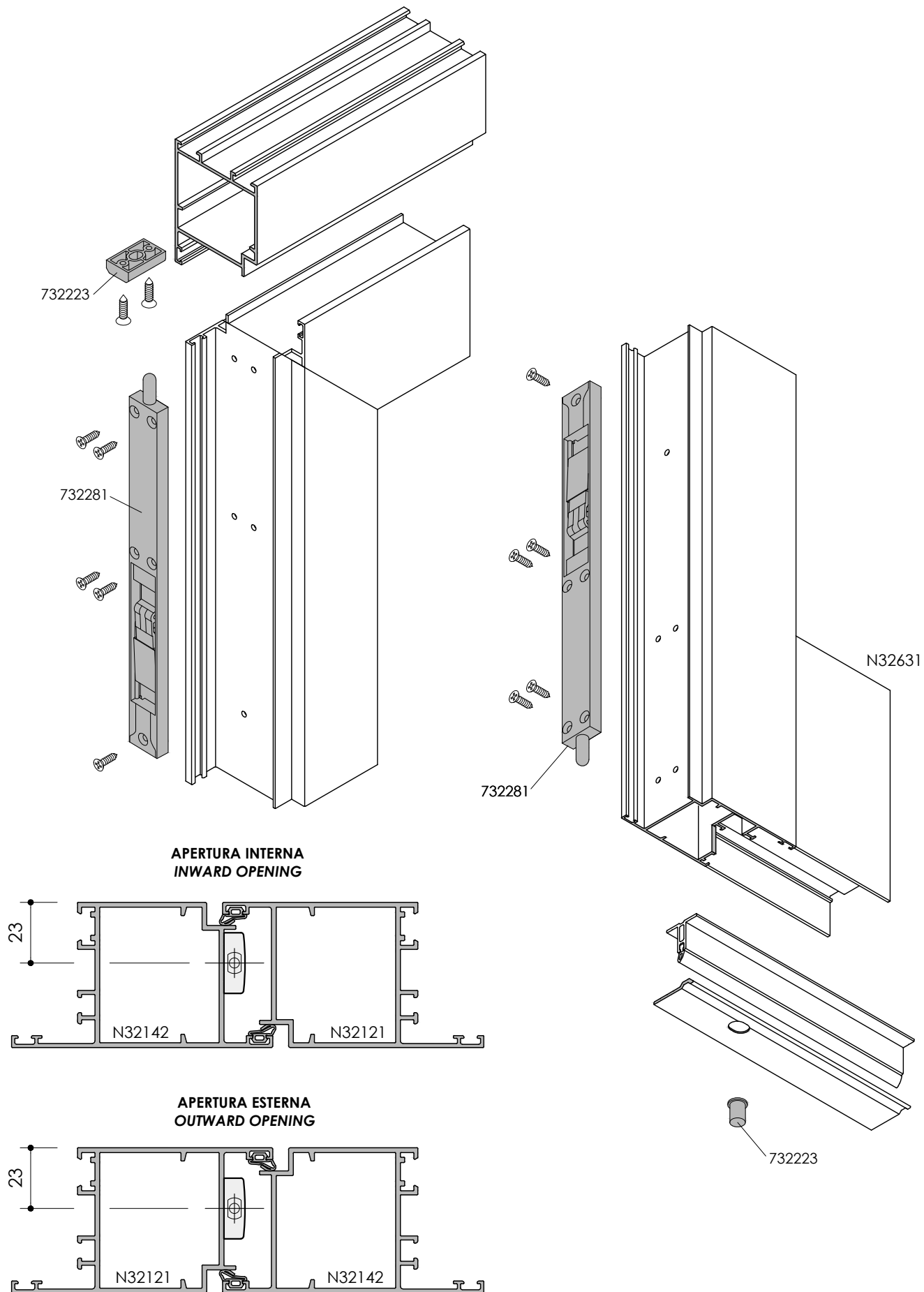
➤ **ASSEMBLAGGIO SERRATURA 732300 PORTE DOPPIO SORMONTO - APERTURA ESTERNA**
732300 DOUBLE OVERLAP DOORS LOCKING DEVICE ASSEMBLING - OUTWARD OPENING

C45K-NI	C55K-NI
●	

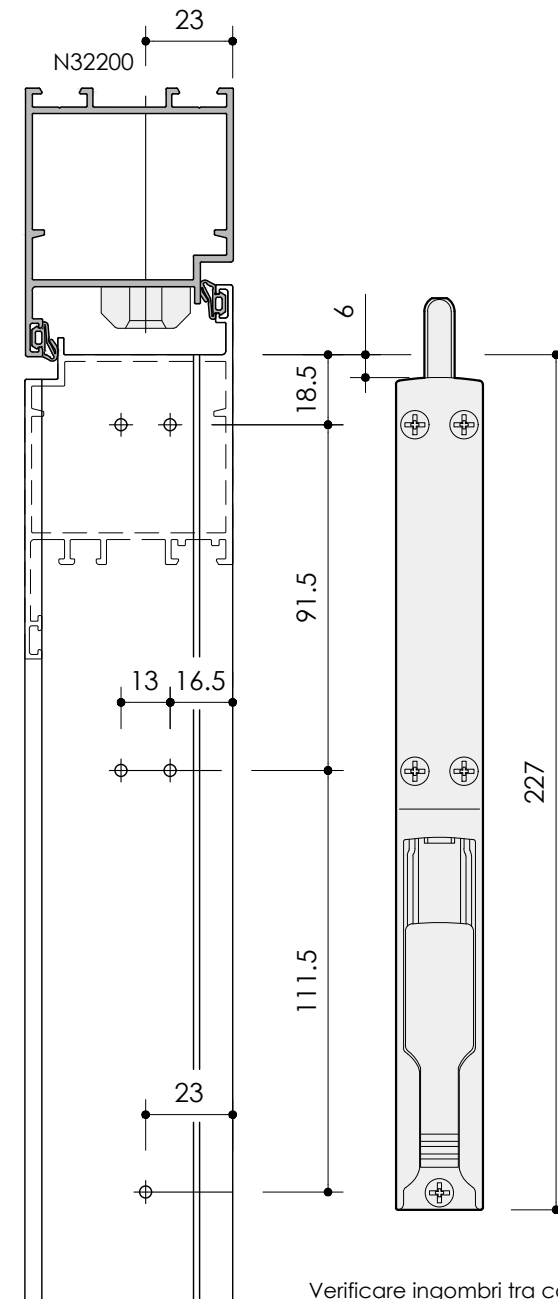


MONTAGGIO CATENACCI COD. 732281 SU ANTA SEMIFISSA
SEMIFIXED WING BOLT KIT COD. 732281 ASSEMBLY DIAGRAM

C45K-NI	C55K-NI
	●

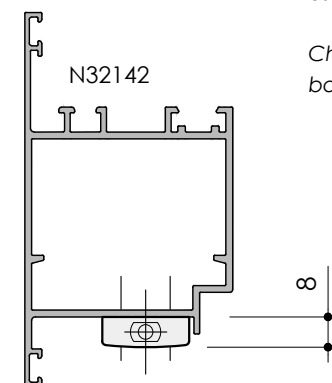


APERTURA INTERNA INWARD OPENING

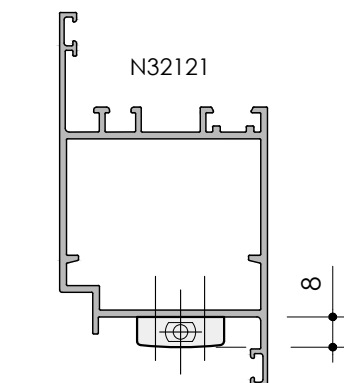
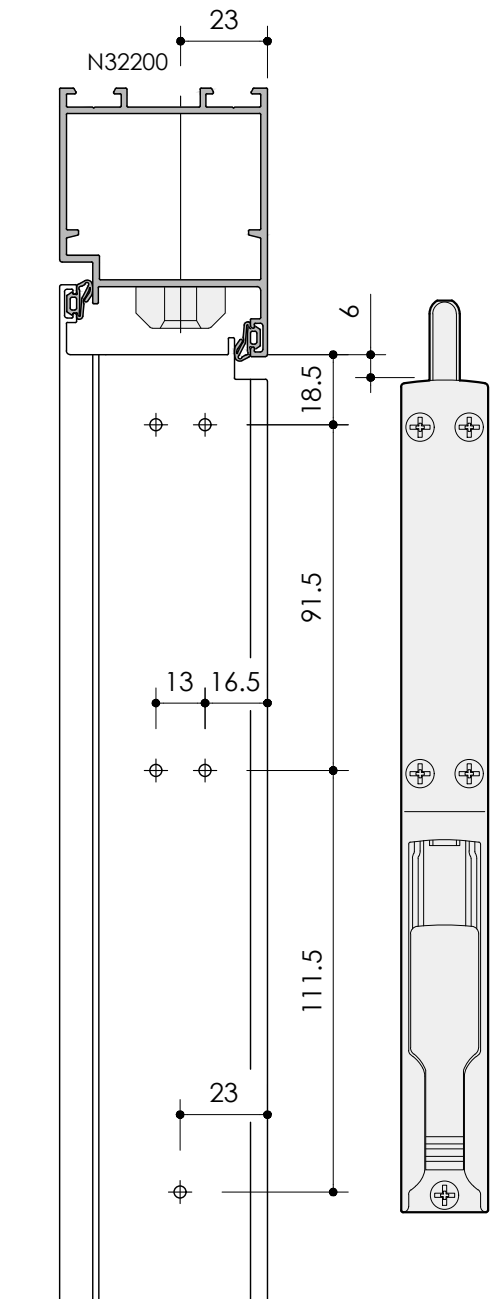


Verificare ingombri tra catenaccio esterno e incontri superiore/inferiore

Check clearances between external bolt and upper/lower strikers

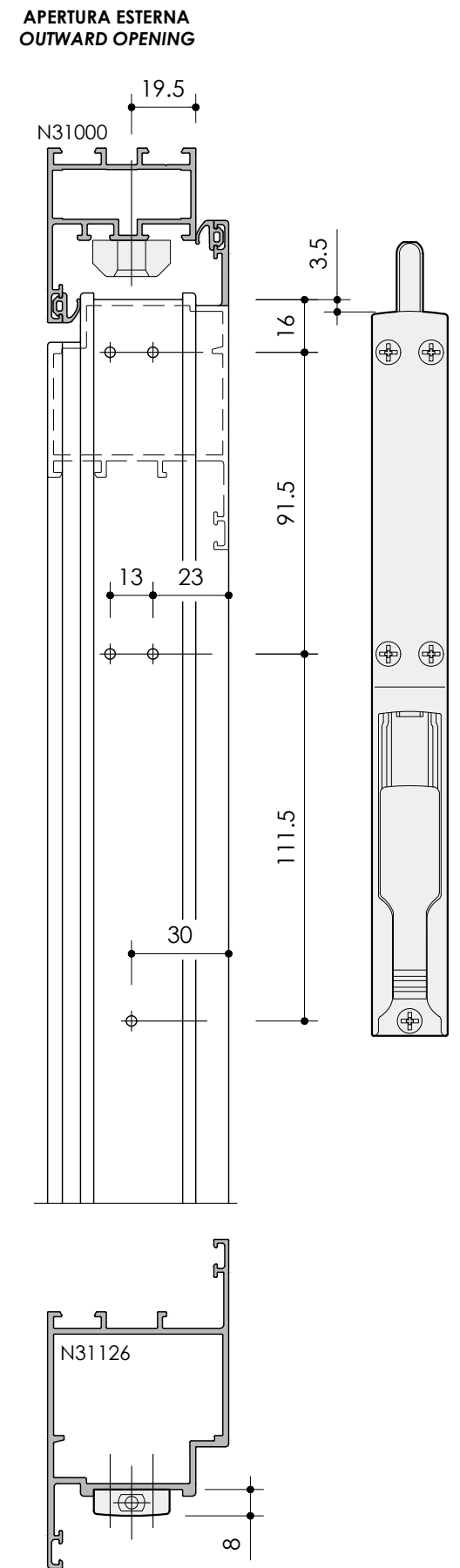
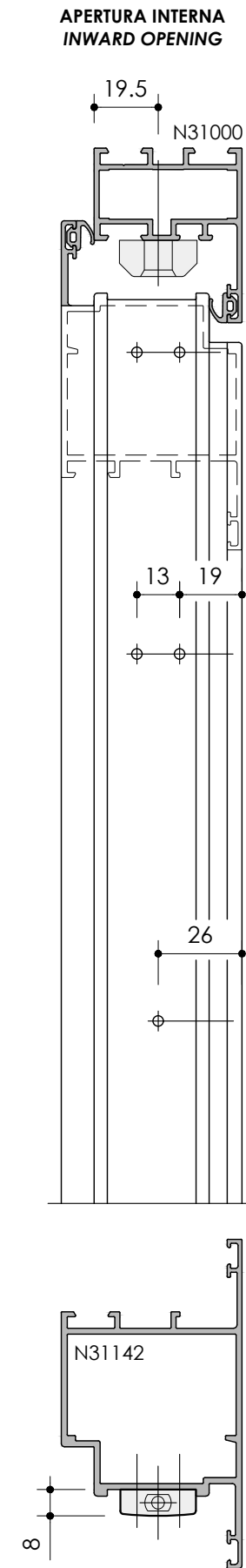
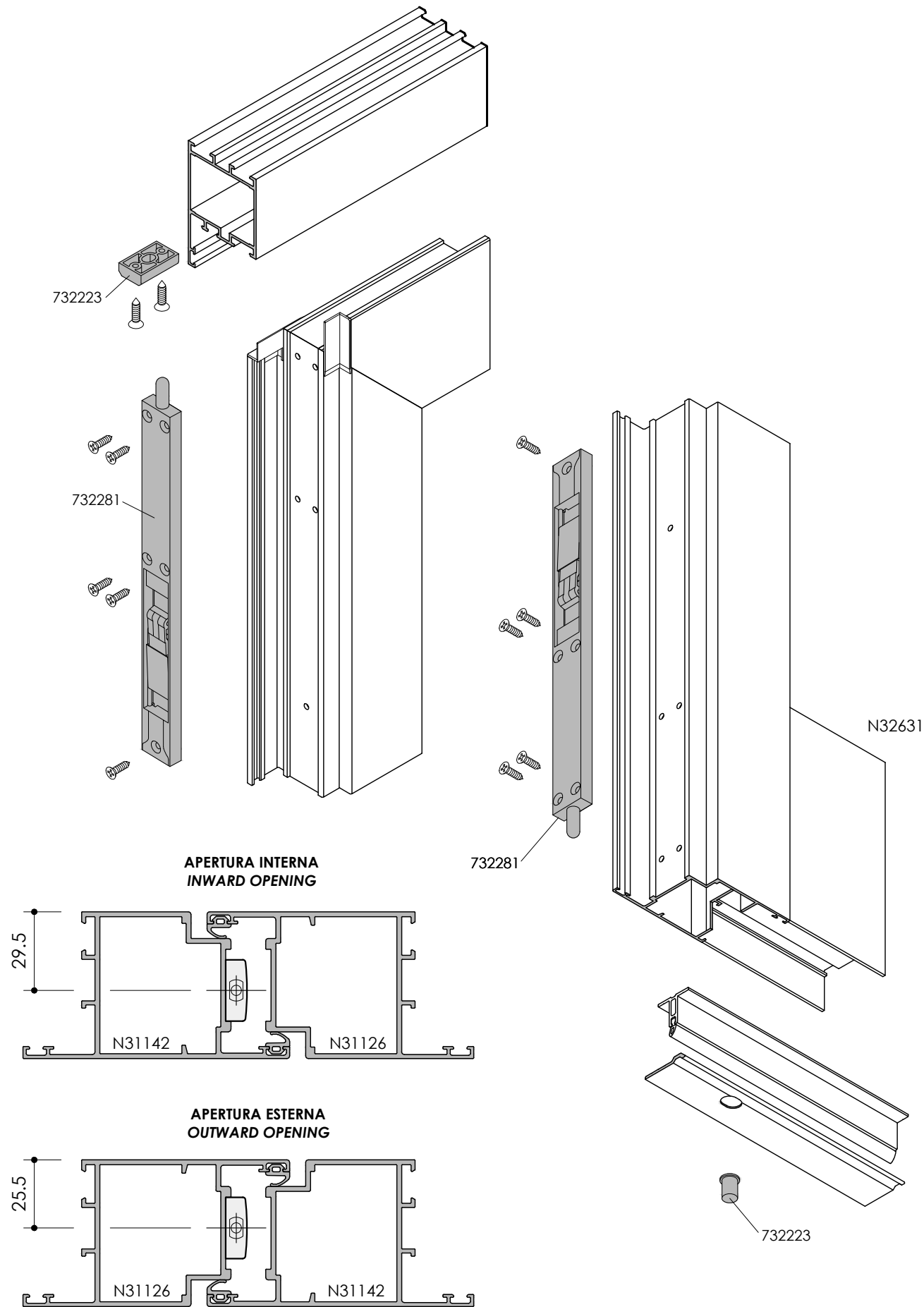


APERTURA ESTERNA OUTWARD OPENING



MONTAGGIO CATENACCI COD. 732281 SU ANTA SEMIFISSA
SEMIFIXED WING BOLT KIT COD. 732281 ASSEMBLY DIAGRAM

C45K-NI	C55K-NI
●	



Verificare ingombri tra catenaccio esterno e incontri superiore/inferiore
 Check clearances between external bolt and upper/lower strikers

AluK (IT)

Via Monte Amiata, 3/a
37057 - S. Giovanni Lupatoto
Verona - ITALY

T:+39 045 9696611
info.it@aluk.com