

C67K-M infine

Finestre isolate minimali – *Minimal insulated windows*

› 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.

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.



ULTIMA REVISIONE
LATEST UPDATE

VERSIONE VERSION	REVISIONE REVISION	DATA DATE	DESCRIZIONE DESCRIPTION	PAGINA PAGE
2	A	10.12.2024	Tolta ferramenta, vedere catalogo AK PLUS <i>Hardware removed, see AK PLUS catalogue</i>	Intero manuale <i>Complete manual</i>
1	C	18.09.2023	Aggiunto gruppo fresa T40048 <i>T40048 milling accessory added</i>	9.002 - 9.12
		03.10.2023	Aggiunto profilo "inglesina" (N43926) <i>Added "Inglesina" profile (N43926)</i>	10.35
1	B	12.06.2023	Aggiunti profili "inglesina" (N43923/N43924) <i>Added "Inglesina" profiles (N43923/N43924)</i>	10.35
		28.06.2023	Implementate indicazioni sull'utilizzo delle dime di foratura <i>Implemented instructions on the use of drilling templates</i>	rep. 9
1	A	13.04.2023	Prima emissione <i>First issue</i>	Intero manuale <i>Complete manual</i>

INDICE

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

Le informazioni contenute in questi disegni sono di proprietà intellettuale esclusiva di AluK S.A.
Possono essere utilizzate al solo scopo per cui sono state fornite e non devono essere riprodotte, memorizzate o diffuse a terzi in qualsiasi modo o forma senza il permesso scritto di AluK S.A.
La politica AluK S.A. di miglioramento continuo determina il diritto di apportare modifiche senza preavviso.

Information contained in this drawing is the exclusive intellectual property of AluK S.A.
It may only be used for the purpose to which is has been supplied and must not be reproduced, stored or disseminated to third parties in any way or form without the prior written permissions of AluK S.A.

The AluK S.A. policy of continuous improvement determines the right to make the modifications without prior warning.

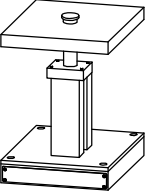
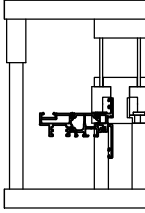
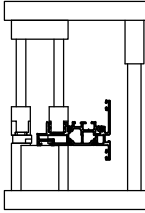
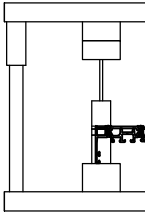
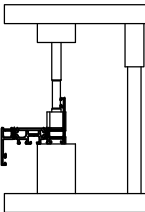
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	901000	Unità di spinta (due stazioni) <i>Push unit (Two station)</i>	-
	T00088	"Cassetto" lavorazione foratura esterno battente <i>"Drawer" machining ext. drilling sash</i>	-
	T00089	"Cassetto" lavorazione foratura interno battente <i>"Drawer" machining int. drilling sash</i>	-
	T00090	"Cassetto" lavorazione foratura esterno stipite <i>"Drawer" machining ext. drilling frame</i>	-
	T00091	"Cassetto" lavorazione foratura interno stipite <i>"Drawer" machining int. drilling frame</i>	-

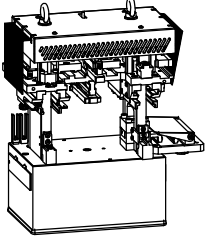
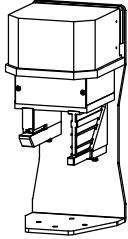
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	909310	Tranciante <i>Punching machine</i>	-
	T00001	Punzonatrice lavorazione squadrette <i>Punching machine for corner cleats</i>	-



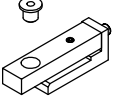
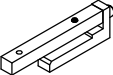
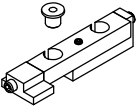
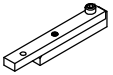
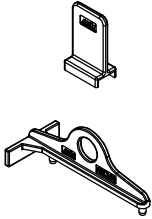
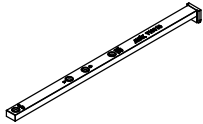
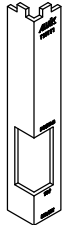
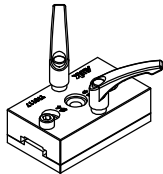
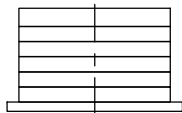
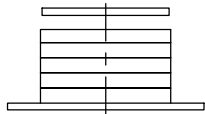
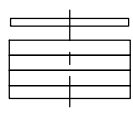
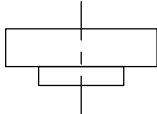
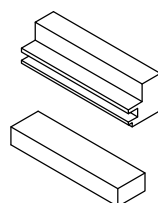
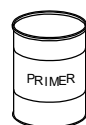
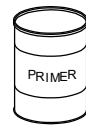
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	T10083	Dima di foratura stipite (profilo interno) <i>Frame drilling template (internal side)</i>	-
	T10084	Dima di foratura stipite (profilo esterno) <i>Frame drilling template (external side)</i>	-
	T10085	Dima di foratura anta (profilo interno) <i>Wing drilling template (internal side)</i>	-
	T10086	Dima di foratura anta (profilo esterno) <i>Wing drilling template (external side)</i>	-
			-

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

➤ GRUPPI FRESA – MILLING ACCESSORY

IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	T40043	Gruppo fresa per lavorazione TZ <i>Milling accessory for TZ profile K series</i>	-
	T40044	Gruppo fresa connessione stipite traverso <i>Milling accessory for connection fixed frame transom</i>	-
	T40045	Gruppo fresa connessione stipite soglia ribassata <i>Milling accessory for connection fixed frame balcony threshold</i>	-
	T40048	Gruppo fresa fermavetro linea "ferro" <i>"Iron" line glazing bead milling</i>	-

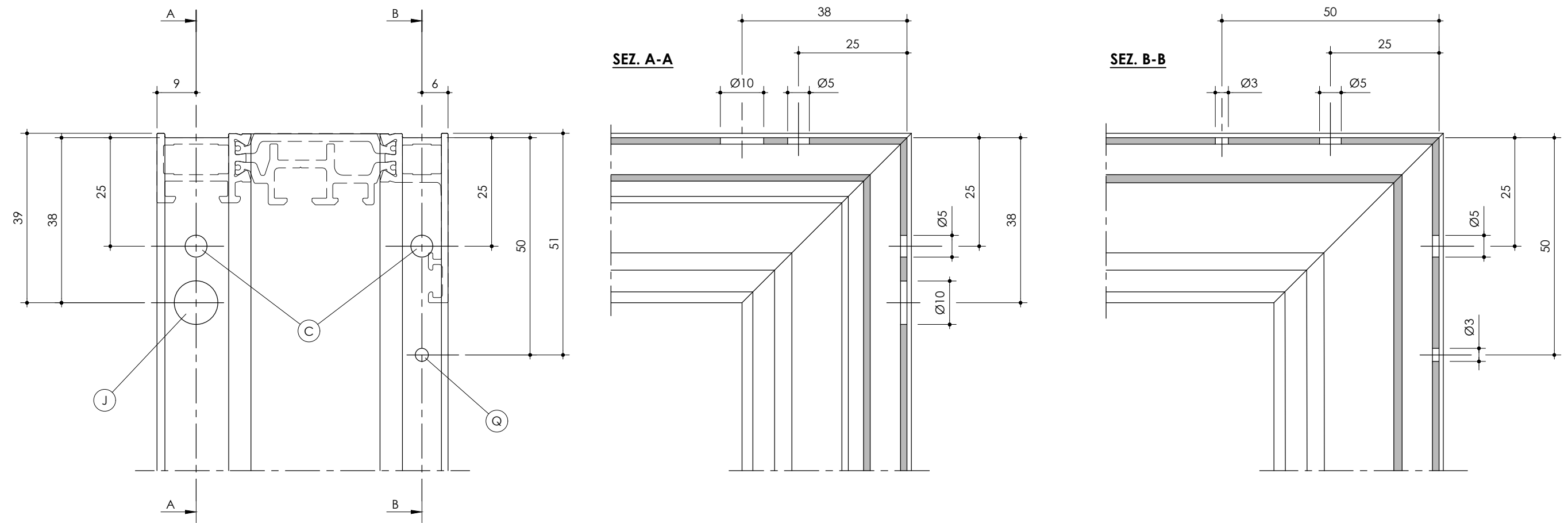
➤ VARIE – OTHERS

IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	T30010	Kit di fissaggio fermavetro linea "ferro" <i>"Iron" line glazing bead fixing kit</i>	
	T50010	Promotore adesione per vetro (1000 ml) <i>Adhesion primer for glass</i>	- U.V. 6
	T50011	Promotore adesione per superfici verniciate (250 ml) <i>Adhesion primer for painted surfaces.</i>	- U.V. 4

Section 9

Lavorazioni
Machinings

PROFILI	SQUADRETTA INTERNA	SQUADRETTA ESTERNA	SQUADRETTA ALLINEAMENTO
U20007	V42049	V41008	-
U20022	V42049	V41008	V46027



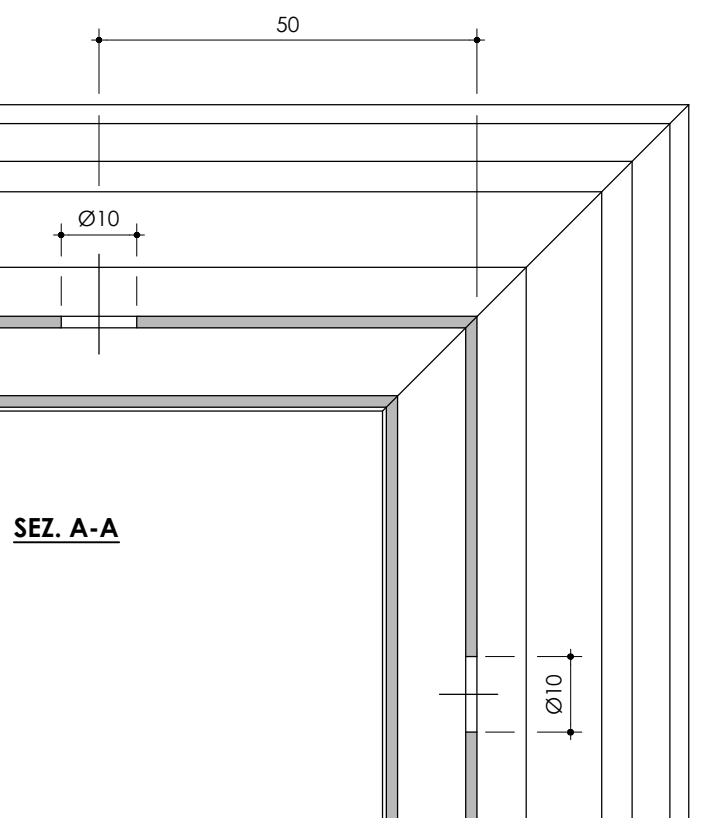
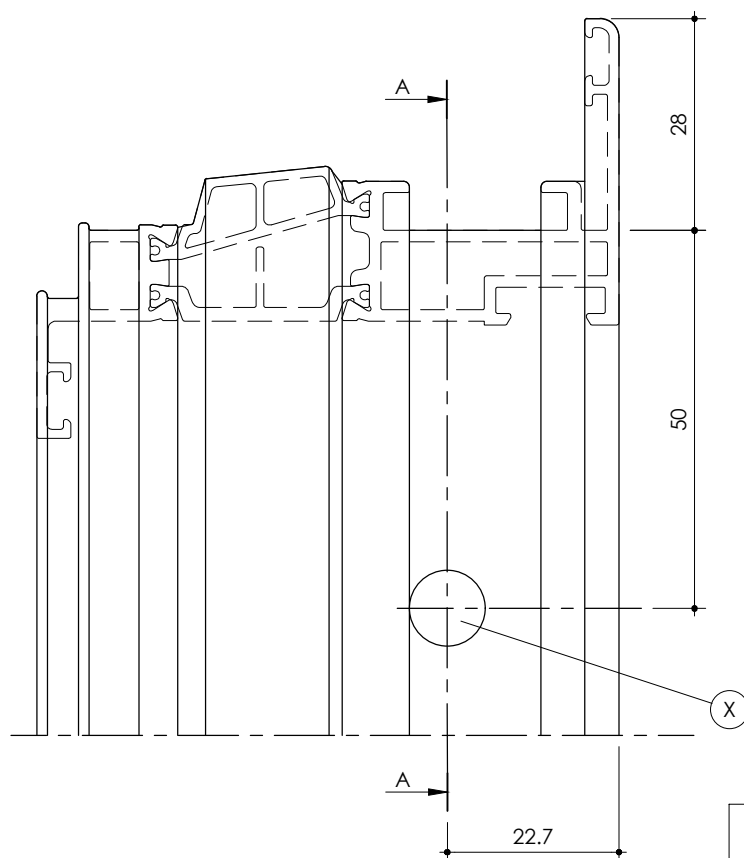
J PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE DIMA ART. T10083
TO EXECUTE THIS DRAINAGE SLOT USE ART. T10083 DRILLING TEMPLATE
IN ALTERNATIVA CON "CASSETTO" T00091 (CON UNITA DI SPINATA DUE STAZIONI 901000)
ALTERNATIVELY WITH "DRAWER" T00091 (WITH TWO-STATION PLUNGER UNIT 901000)

Q PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE DIMA ART. T10084
TO EXECUTE THIS DRAINAGE SLOT USE ART. T10084 DRILLING TEMPLATE
IN ALTERNATIVA CON "CASSETTO" T00090 (CON UNITA DI SPINATA DUE STAZIONI 901000)
ALTERNATIVELY WITH "DRAWER" T00090 (WITH TWO-STATION PLUNGER UNIT 901000)

C IL FORO COLLA VA ESEGUITO A MANO
THE GLUE HOLE BE MADE BY HAND

LAVORAZIONI PER SQUADRETTE BATTENTE MACHINING CORNER JOINTS FOR WING

LAVORAZIONE SQUADRETTA INTERNA MACHINING FOR INTERNAL CORNER JOINT

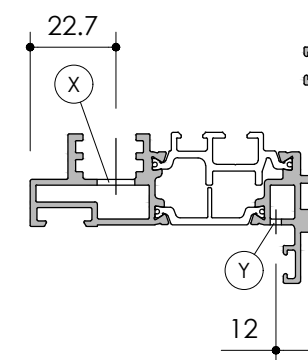
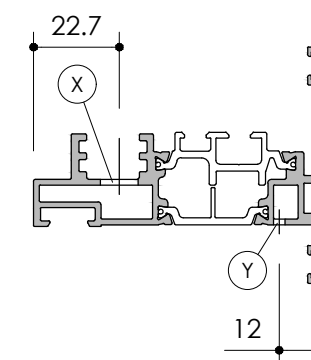


(X)

PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE DIMA ART. T10085
TO EXECUTE THIS DRAINAGE SLOT USE ART. T10085 DRILLING TEMPLATE

IN ALTERNATIVA CON "CASSETTO" T00089 (CON UNITÀ DI SPINATA DUE STAZIONI 901000)
ALTERNATIVELY WITH "DRAWER" T00089 (WITH TWO-STATION PLUNGER UNIT 901000)

LAVORAZIONI PROFILI MONTAGGIO SQUADRETTA PROFILE MACHINING FOR CORNER JOINT ASSEMBLY

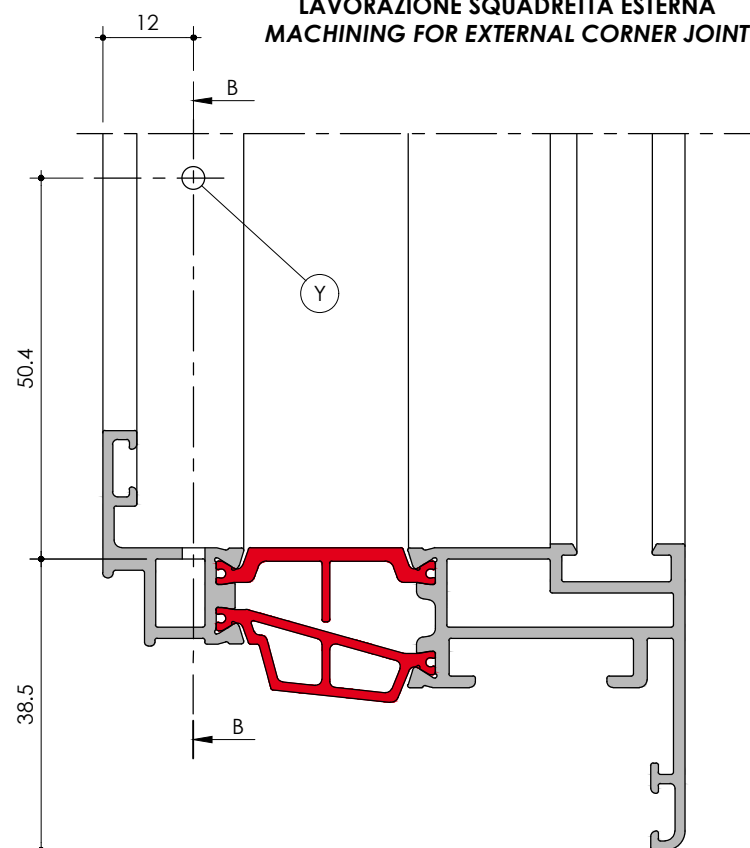


(Y)

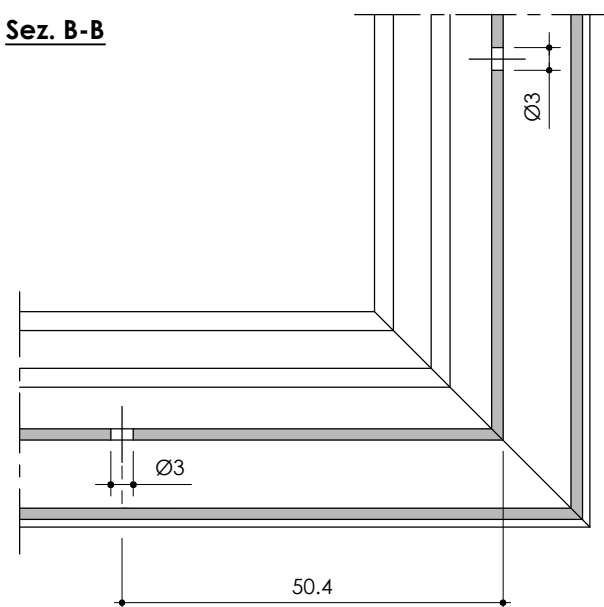
PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE DIMA ART. T10086
TO EXECUTE THIS DRAINAGE SLOT USE ART. T10086 DRILLING TEMPLATE

IN ALTERNATIVA CON "CASSETTO" T00088 (CON UNITÀ DI SPINATA DUE STAZIONI 901000)
ALTERNATIVELY WITH "DRAWER" T00088 (WITH TWO-STATION PLUNGER UNIT 901000)

LAVORAZIONE SQUADRETTA ESTERNA MACHINING FOR EXTERNAL CORNER JOINT

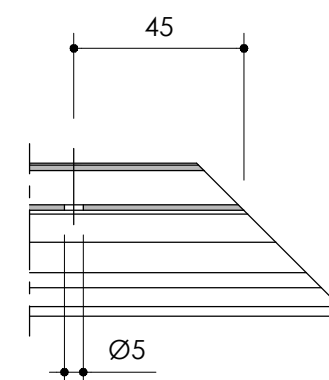
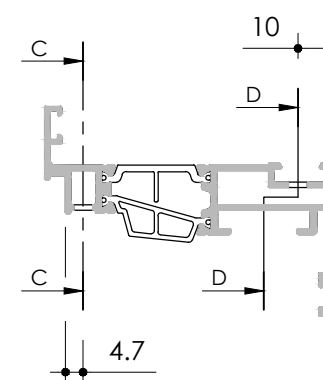


SEZ. B-B

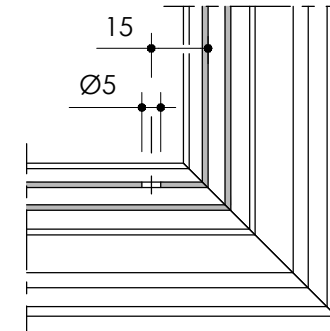


LAVORAZIONE FORO INSERIMENTO COLLA HOLE MACHINING FOR GLUE INSERTION

SEZ. C-C

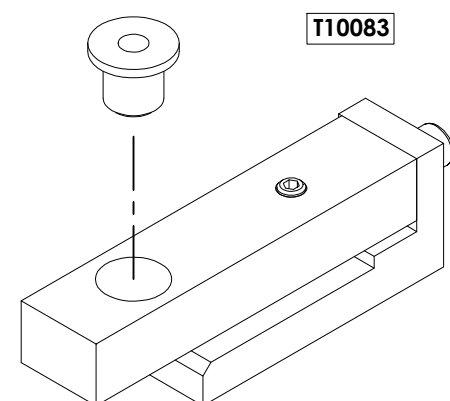


SEZ. D-D



IL FORO COLLA VA ESEGUITO A MANO
THE GLUE HOLE BE MADE BY HAND

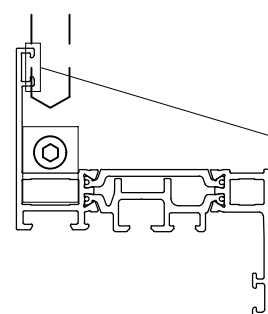
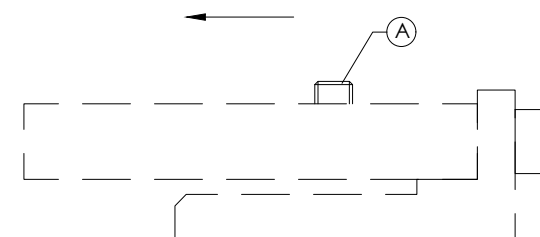
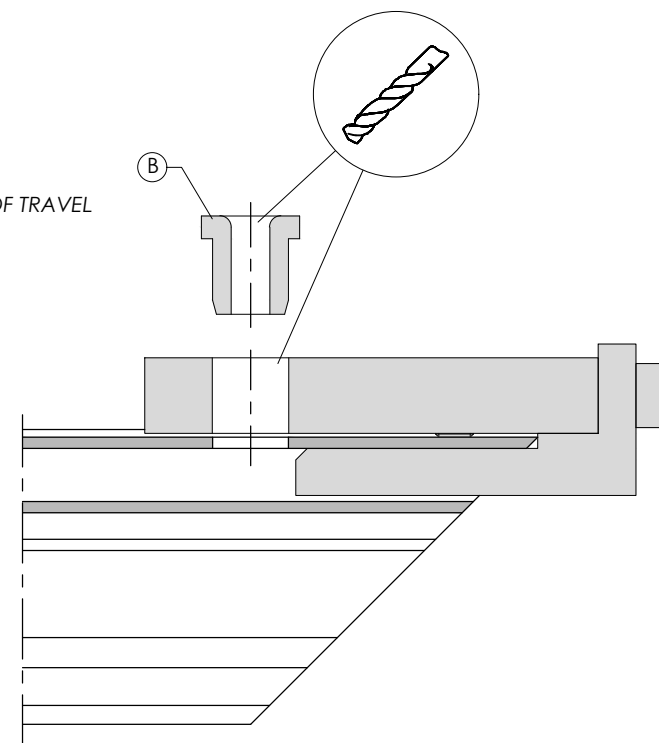
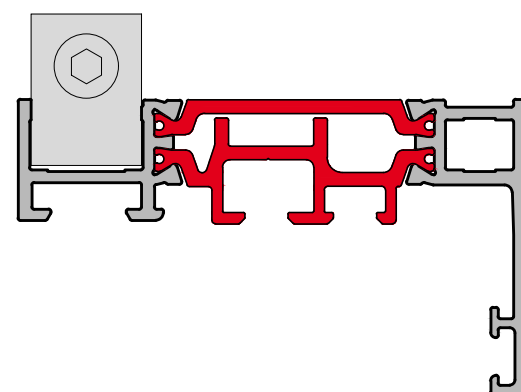
▶ SCHEMA UTILIZZO DIME PER FORATURA STIPITE DIAGRAM FOR USING TEMPLATES FOR FRAME DRILLING



T10083

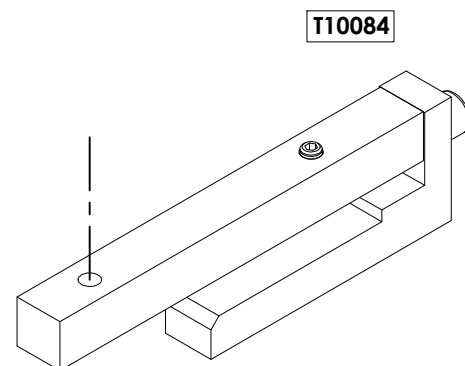
- INSERIRE LA DIMA NELLA TUBULARITA' FINO A FINE CORSA
- BLOCCARE LA DIMA STRINGENDO DEBOLMENTE LA VITE A
- FORARE Ø 5 mm UTILIZZANDO LA BOCCOLA B
- RIMUOVERE LA BOCCOLA B
- FORARE Ø10 mm

- INSERT THE TEMPLATE INTO THE TUBULARITY UP TO THE END OF TRAVEL
- LOCK THE TEMPLATE BY LIGHTLY TIGHTENING THE SCREW A
- DRILL Ø 5 mm USING BUSH B
- REMOVE BUSHING B
- DRILL Ø 10 mm



PORRE ATTENZIONE NEL CASO DI UTILIZZO DEL PROFILO U20022
LEGGERA INTERFERENZA TRA LA PUNTA Ø10 mm E LA CAVA PORTA GUARNIZIONE

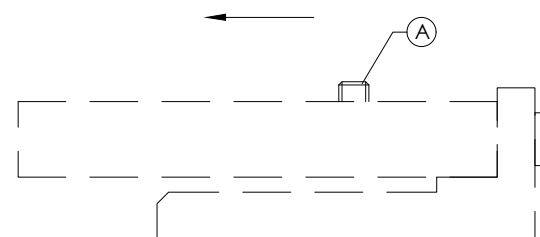
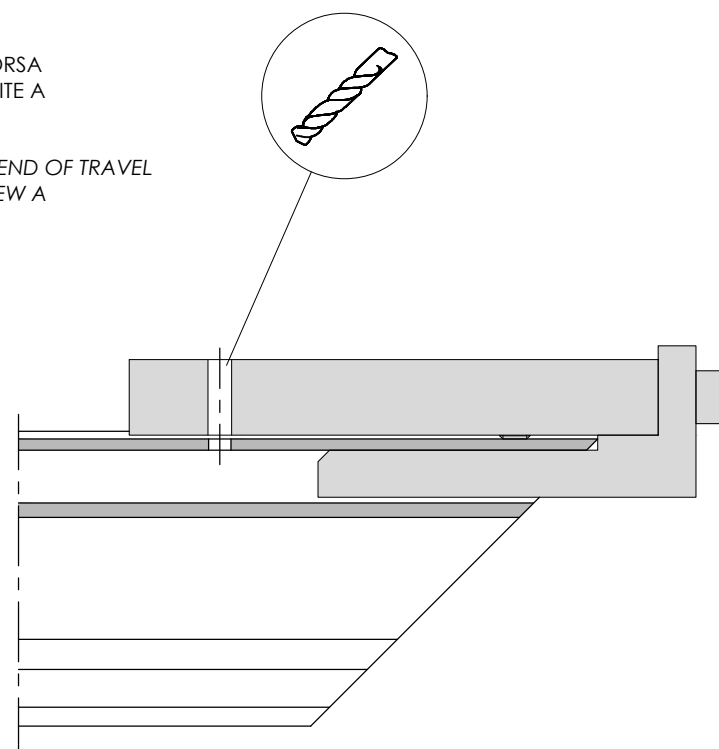
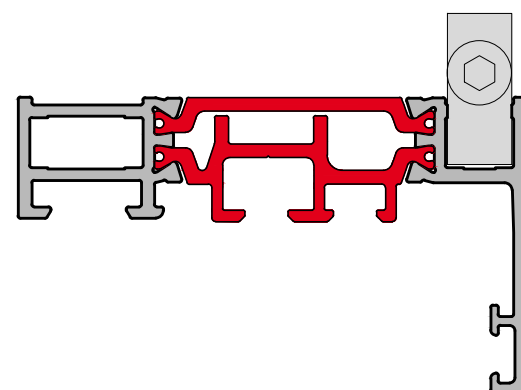
BE CAREFUL IF USING THE U20022 PROFILE
SLIGHT INTERFERENCE BETWEEN THE Ø10 mm DRILL AND THE GASKET HOLDER SLOT



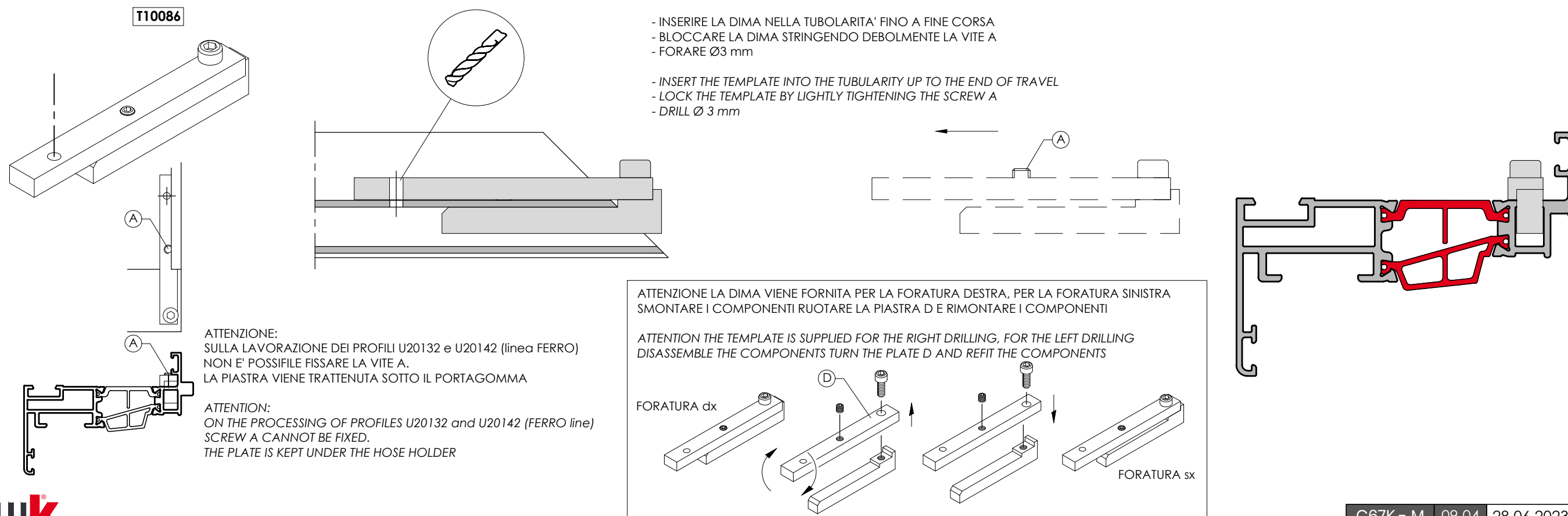
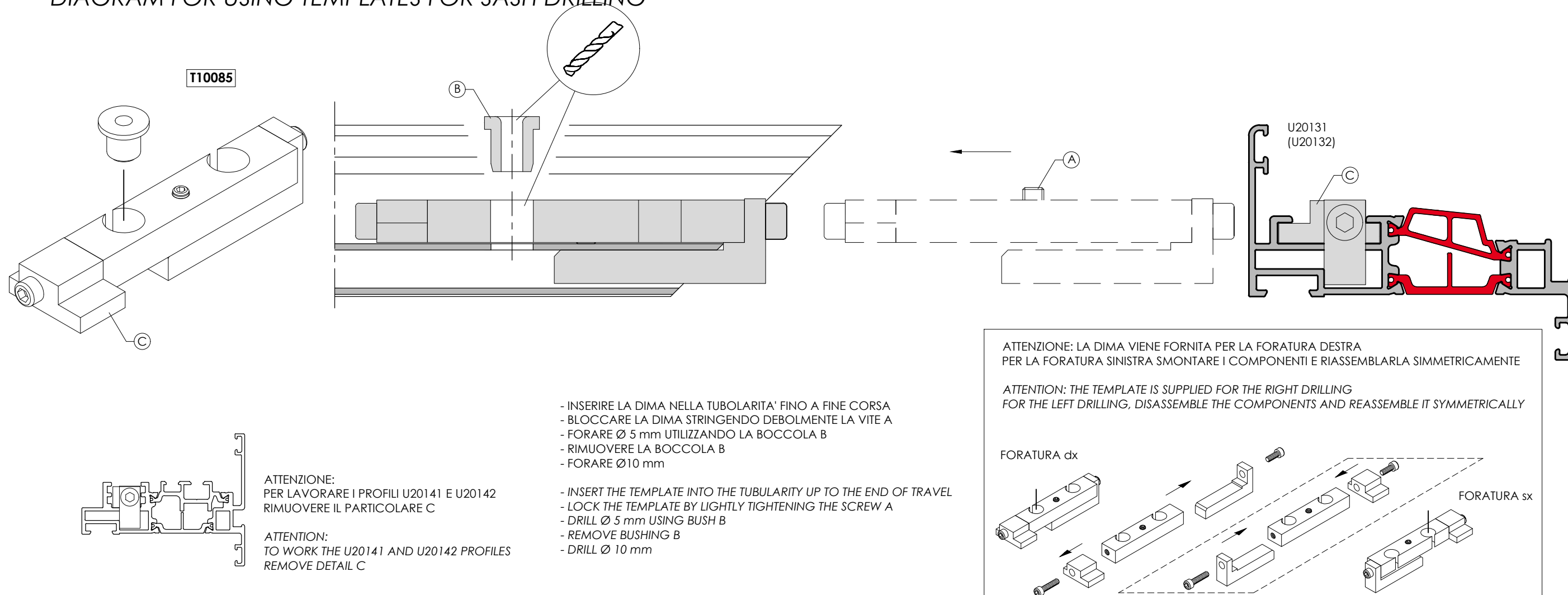
T10084

- INSERIRE LA DIMA NELLA TUBULARITA' FINO A FINE CORSA
- BLOCCARE LA DIMA STRINGENDO DEBOLMENTE LA VITE A
- FORARE Ø3 mm

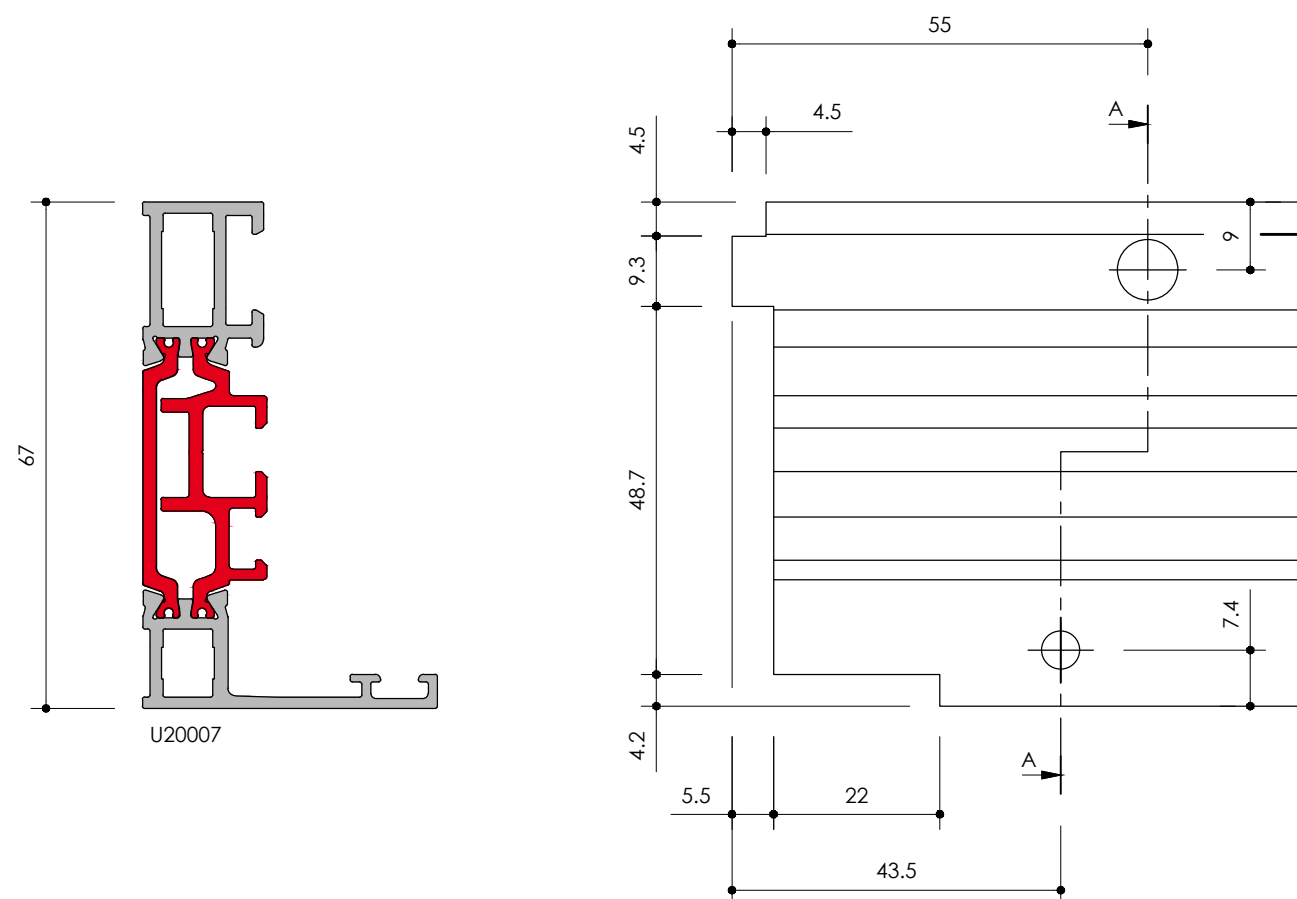
- INSERT THE TEMPLATE INTO THE TUBULARITY UP TO THE END OF TRAVEL
- LOCK THE TEMPLATE BY LIGHTLY TIGHTENING THE SCREW A
- DRILL Ø 3 mm



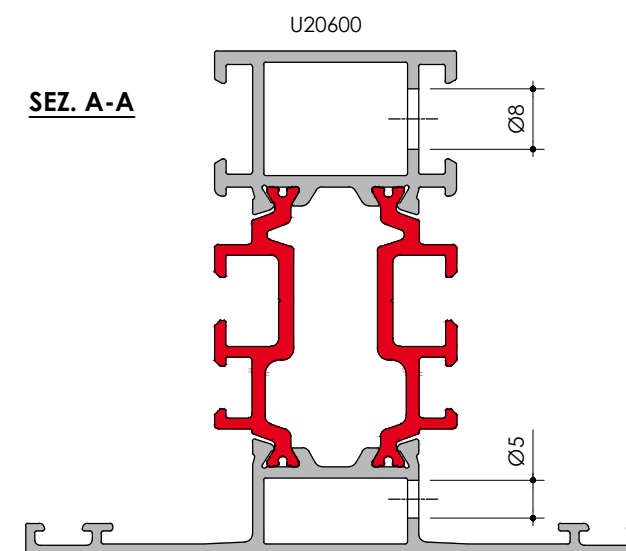
SCHEMA UTILIZZO DIME PER FORATURA BATTENTI DIAGRAM FOR USING TEMPLATES FOR SASH DRILLING



➤ LAVORAZIONE PER CONNESSIONE TRAVERSO STIPITE
FIXED FRAME TRANSOM CONNECTION DIAGRAM



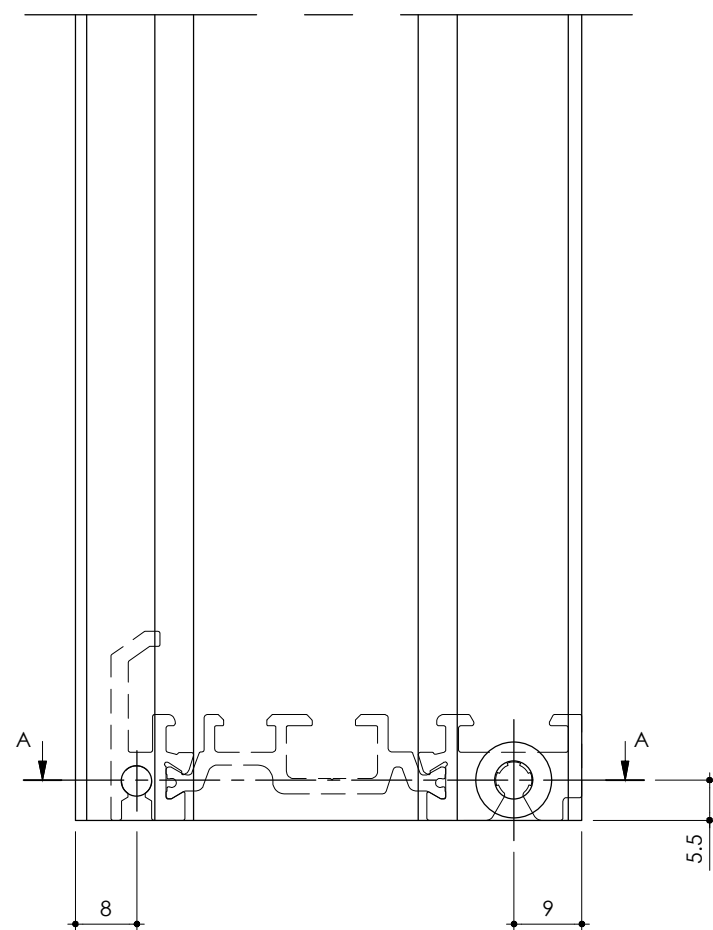
PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA ART. T40044
TO EXECUTE THIS MILLING WORK, USE ART. T40044 MILLING CUTTER



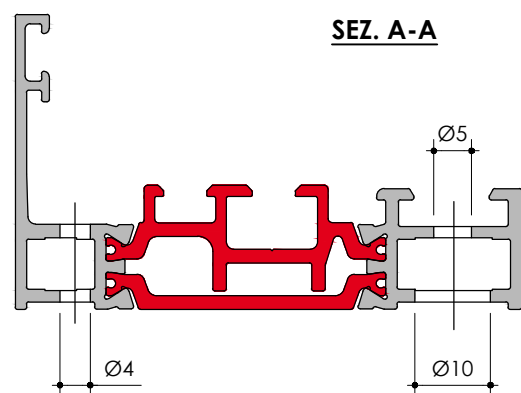
PER ESEGUIRE IL FORO INTERNO UTILIZZARE TRANCIANTE ART. T00001
TO EXECUTE INTERNAL HOLE, USE ART. T00001

IL FORO ESTERNO VA ESEGUITO A MANO
EXTERNAL HOLE BE MADE BY HAND

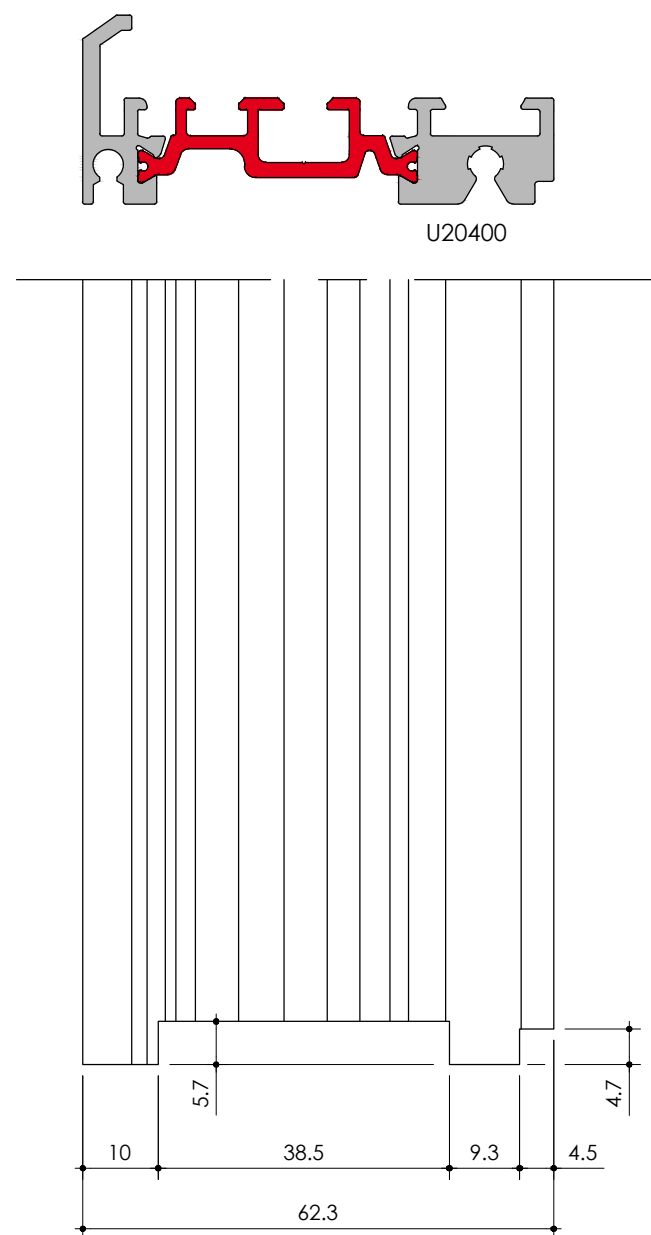
LAVORAZIONE LATO MONTANTE
MULLION SIDE MACHINING



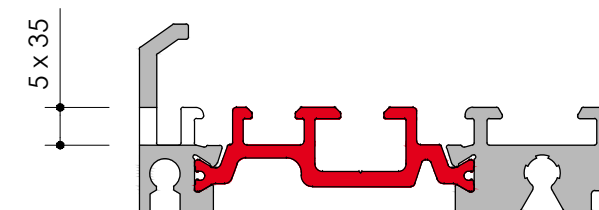
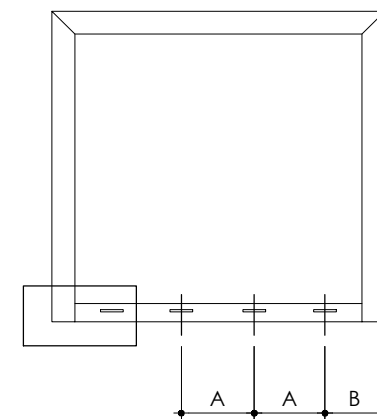
SEZ. A-A



LAVORAZIONE INTESTATURA U20400
U20400 MACHINING



PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA ART. T40045
TO EXECUTE THIS MILLING WORK, USE ART. T40045 MILLING CUTTER



DRENAGGIO SOGLIA OGNI 400 mm (A)
PARTENZA DAL LATO: 100/150 mm (B)

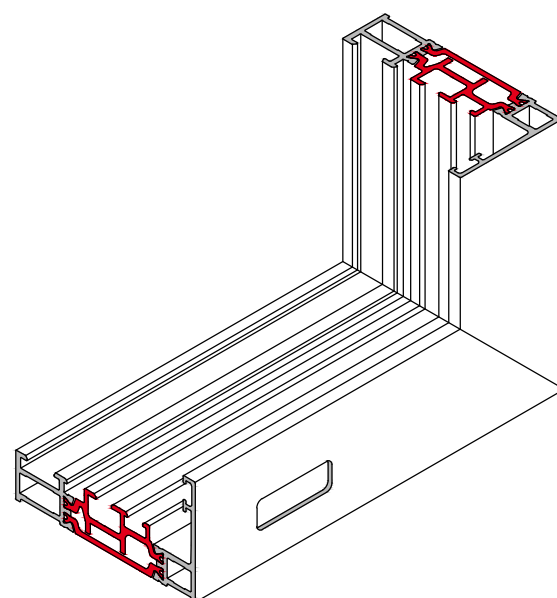
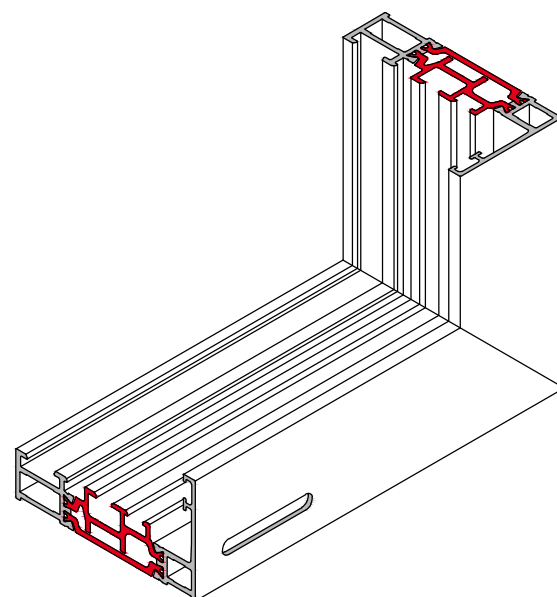
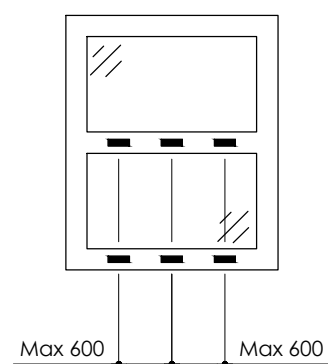
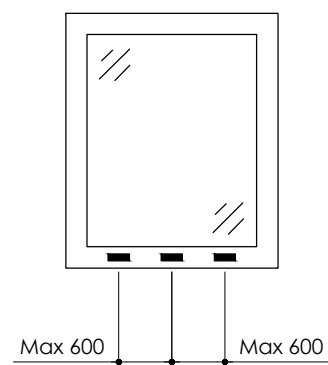
THRESHOLD DRAINAGE EVERY 400 mm (A)
START FROM THE SIDE: 100/150 mm (B)

LAVORAZIONI PER DRENAGGIO SU ELEMENTI FISSI FIXED FRAMES WATER DRAINAGE SYSTEM

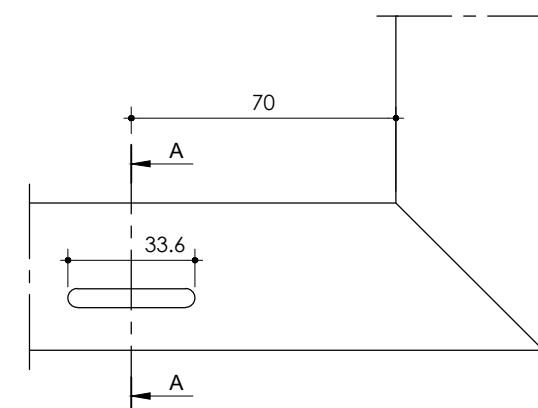
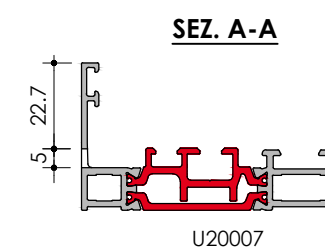
APPLICABILE AI PROFILI
APPLICABLE TO PROFILES

U20007

U20022

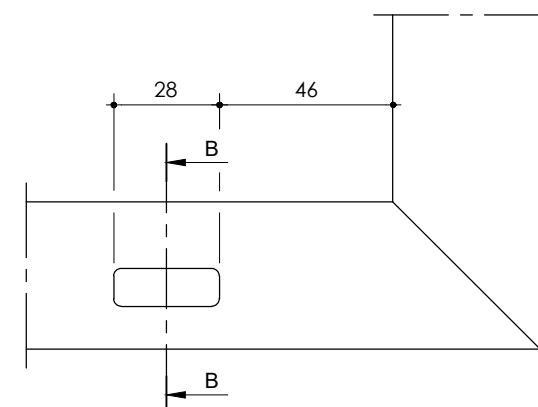
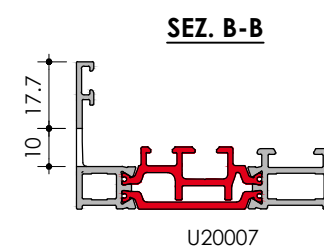


LAVORAZIONE PER ACCESSORI 712005, 712006, 712007, 712008 MACHINING FOR 712005, 712006, 712007, 712008 ACCESSORIES



PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE TRANCIANTE ART. 909310
TO EXECUTE THIS DRAINAGE SLOT USE ART. 909310 BLANKING MACHINE

LAVORAZIONE PER ACCESSORIO V51007P MACHINING FOR V51007P ACCESSORY



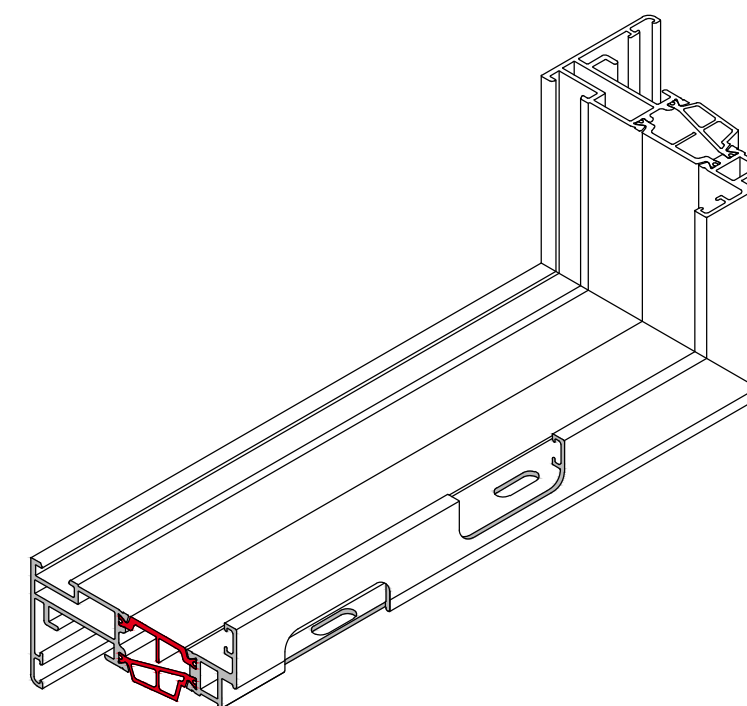
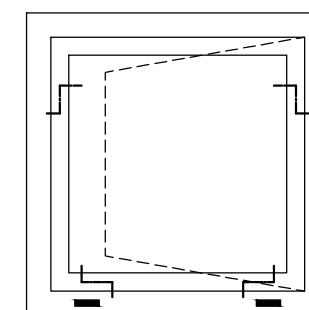
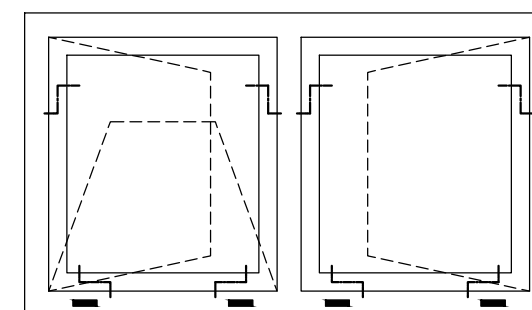
LAVORAZIONE NON ESEGUIBILE A TRANCIANTE
MACHINING NOT EXECUTABLE BY BLANKING MACHINE

➤ LAVORAZIONE PER DRENAGGIO ACQUA E VENTILAZIONE SU BATTENTI
WATER DRAINAGE AND VENTILATION SYSTEM ON WING

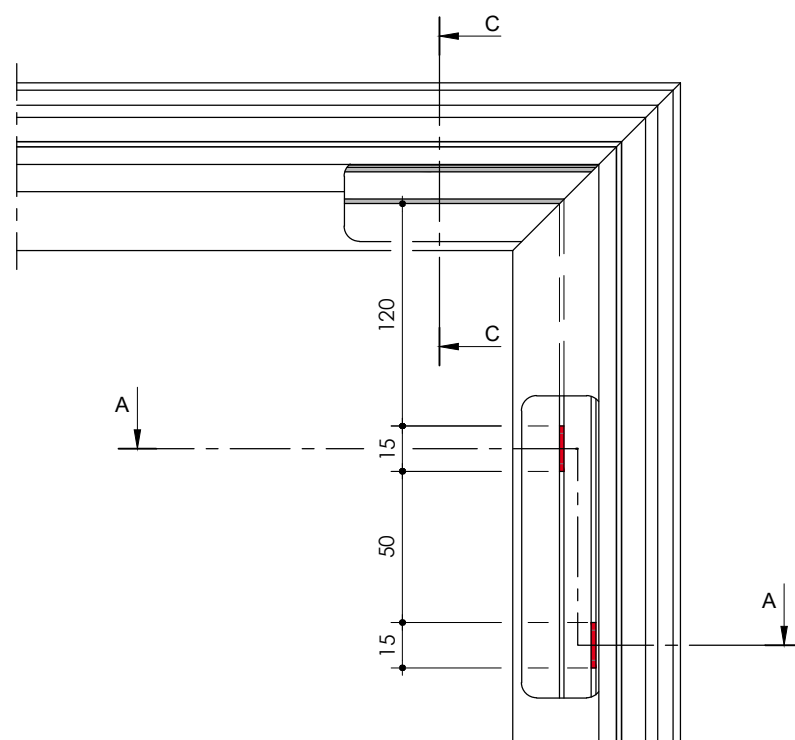
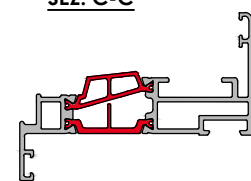
APPLICABILE AI PROFILI
APPLICABLE TO PROFILES

U20131

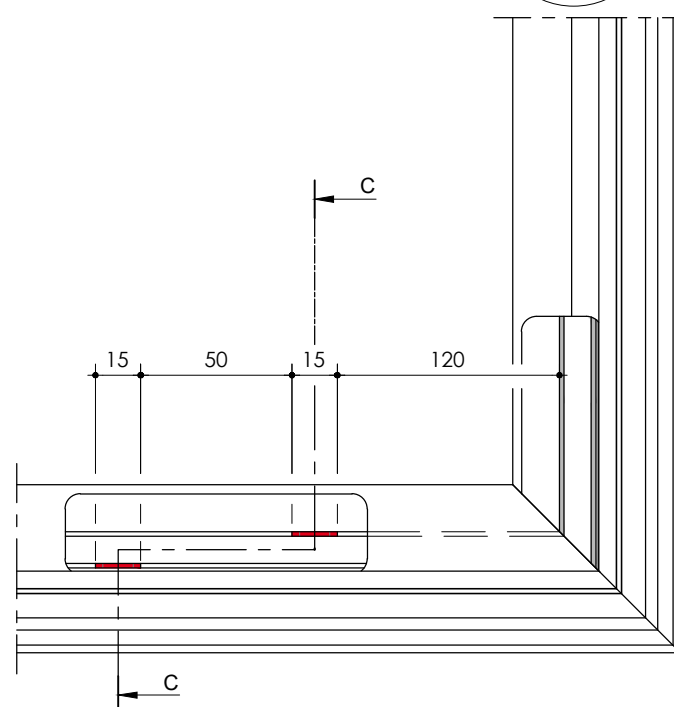
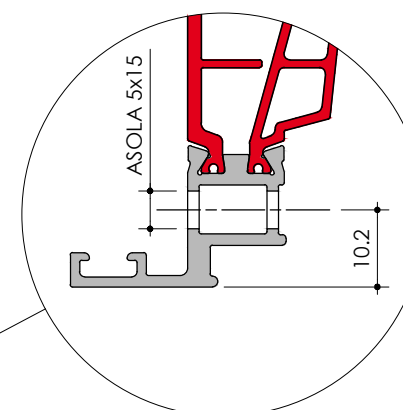
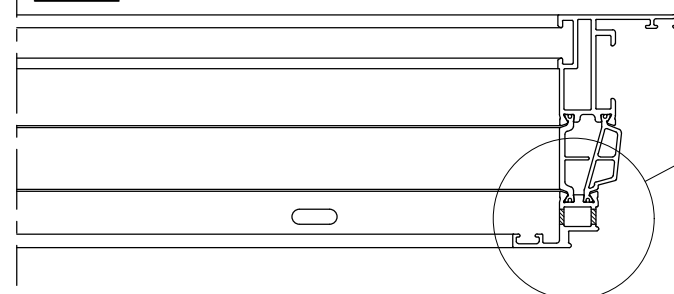
U20132



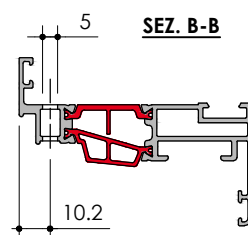
SEZ. C-C



SEZ. A-A

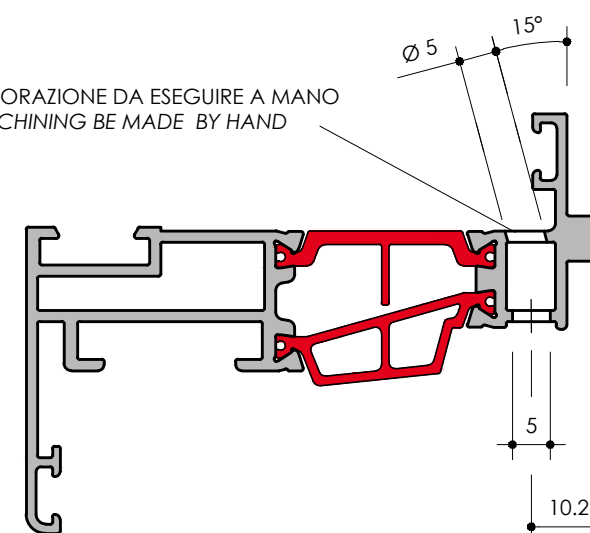


SEZ. B-B

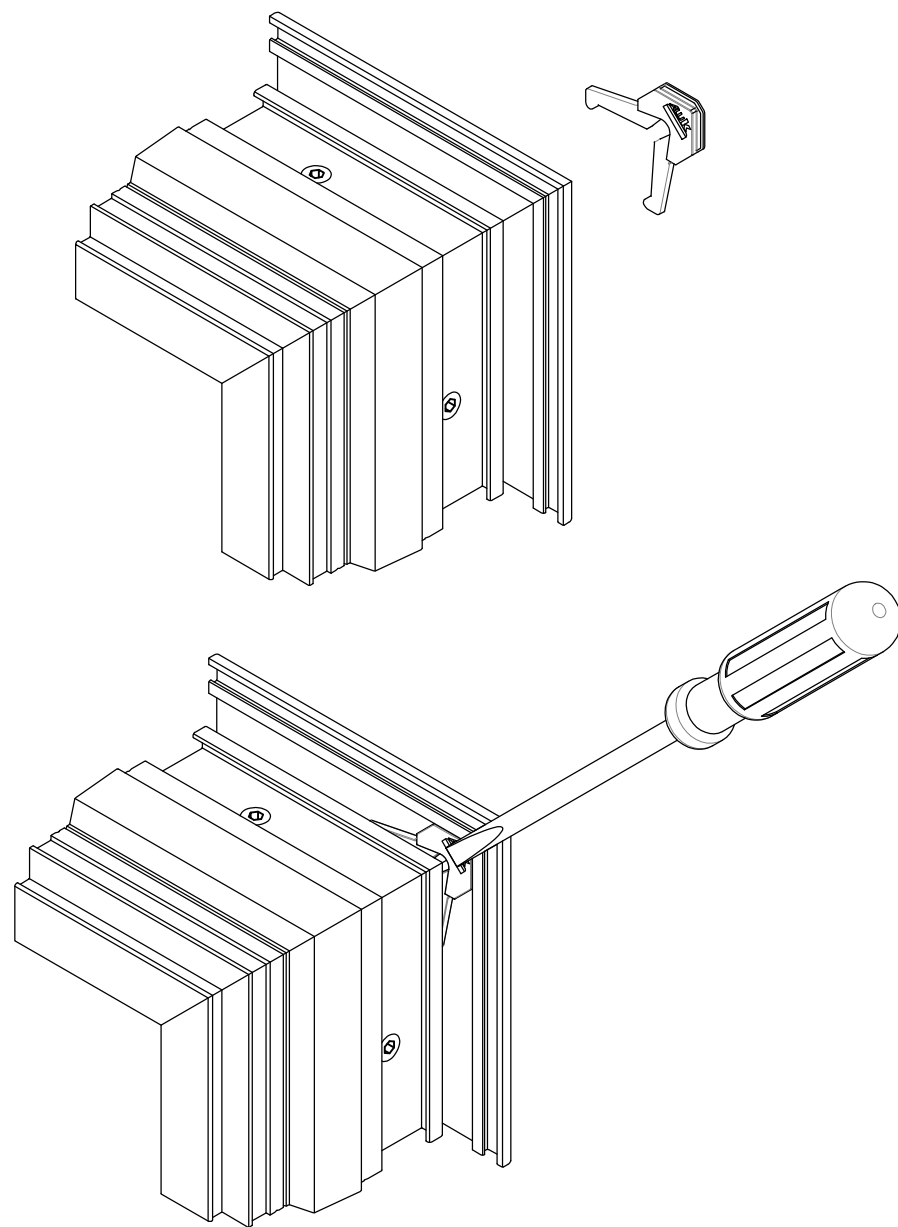


LINEA FERRO

LAVORAZIONE DA ESEGUIRE A MANO
MACHINING BE MADE BY HAND

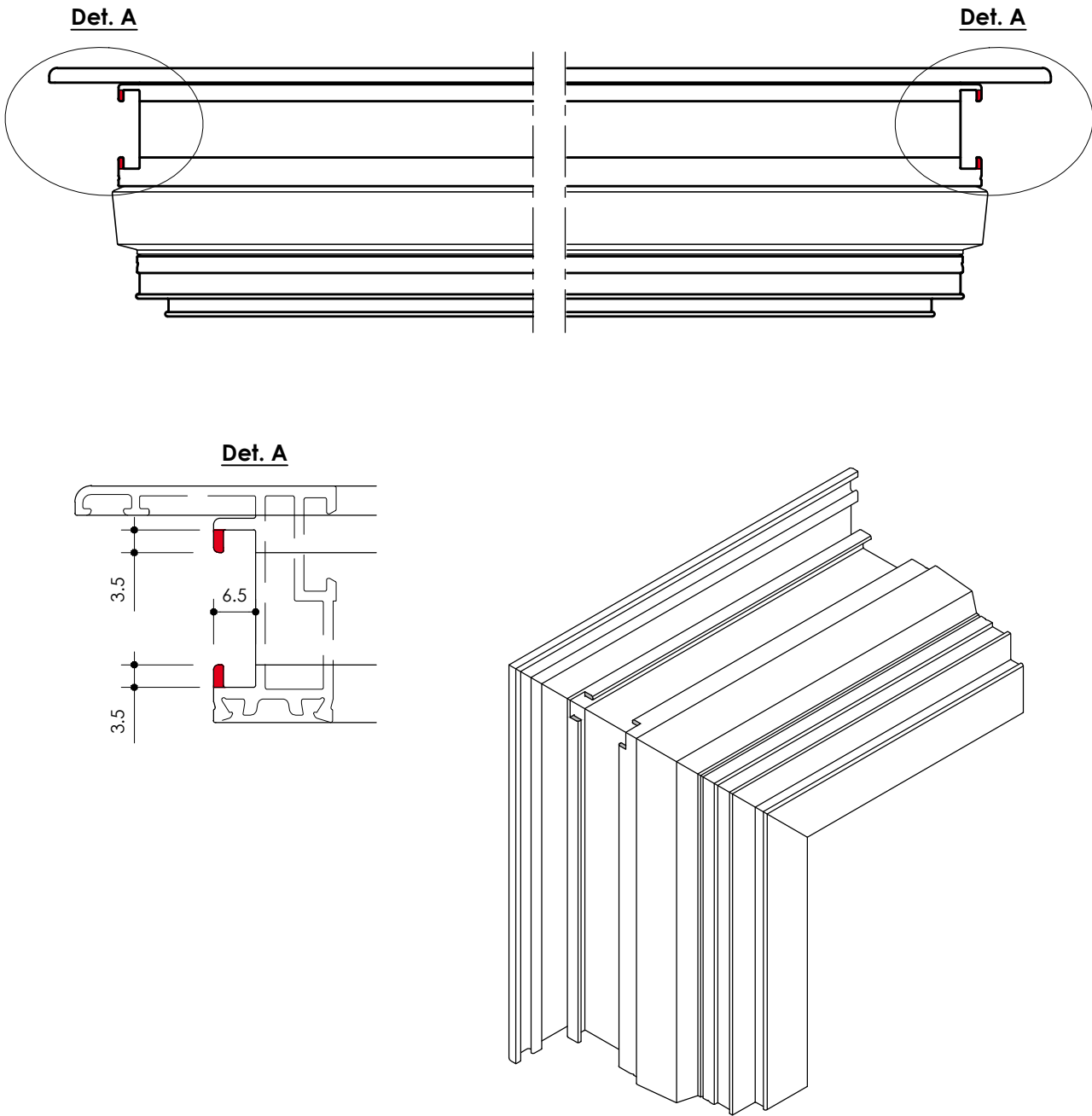


SCHEMA DI MONTAGGIO SQUADRETTA DI ALLINEAMENTO INTERNA BATTENTE
INTERNAL WING ALIGNMENT CORNER JOINT ASSEMBLING DIAGRAM



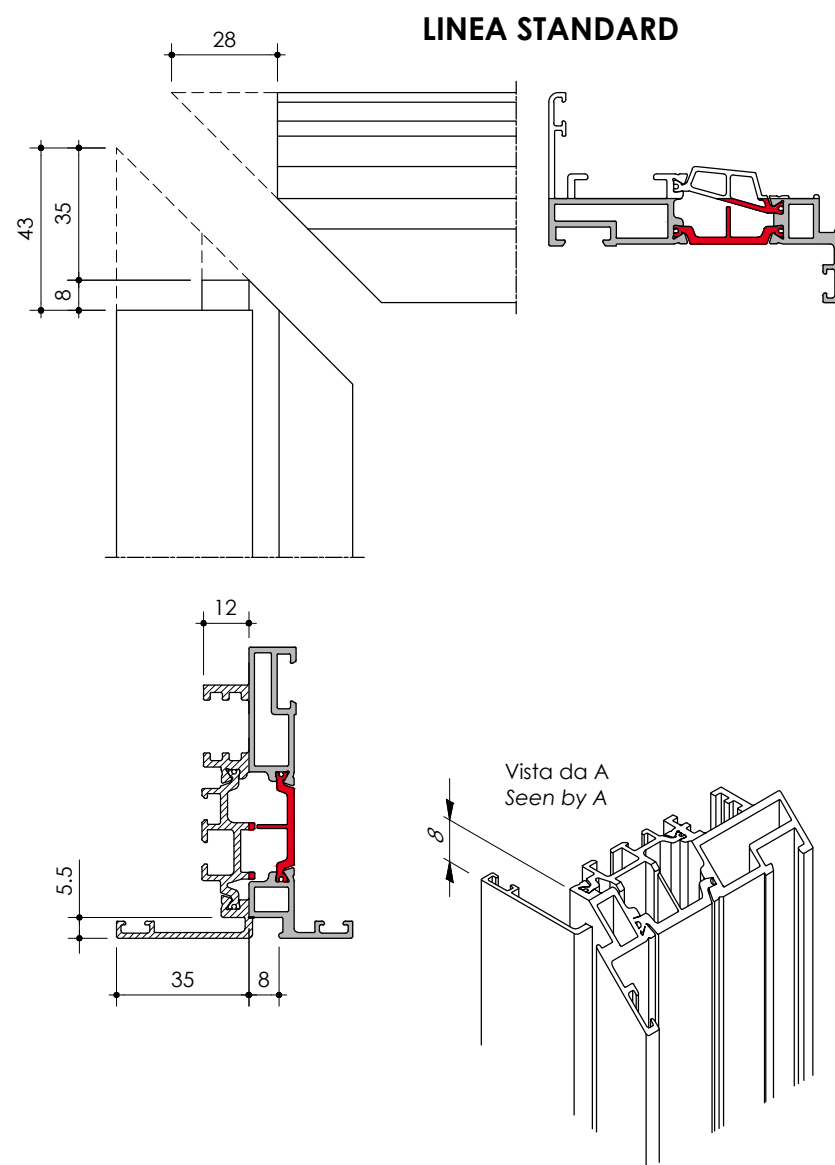
	PROFILI	SQUADRETTA ALLINEAMENTO
LINEA STANDARD	U20131	710041
LINEA FERRO	U20132	710041

LAVORAZIONE "ALETTE" CAVA BATTENTE PER INSERIMENTO ACCESSORI
TIPS CUTTING OUT FOR ROD INSERTION AND ACCESSORIES ASSEMBLING

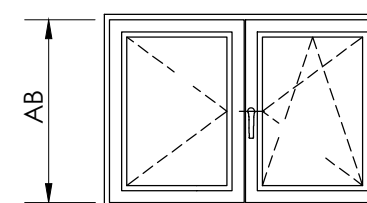
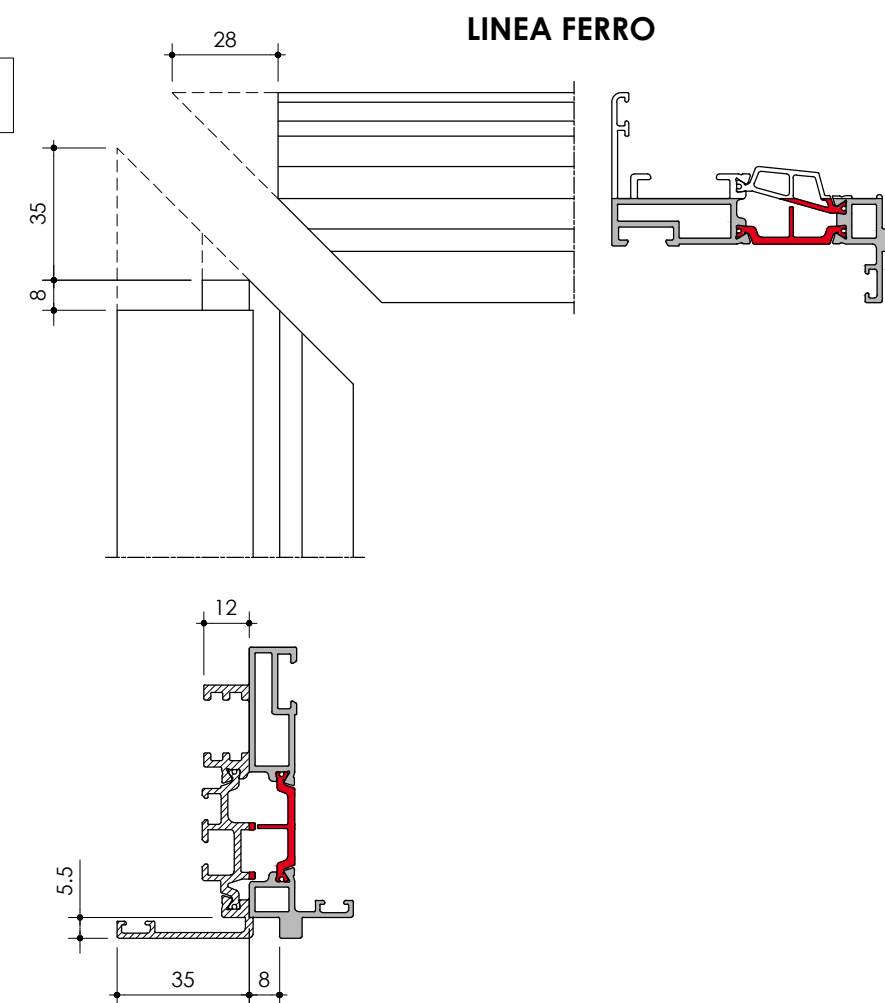
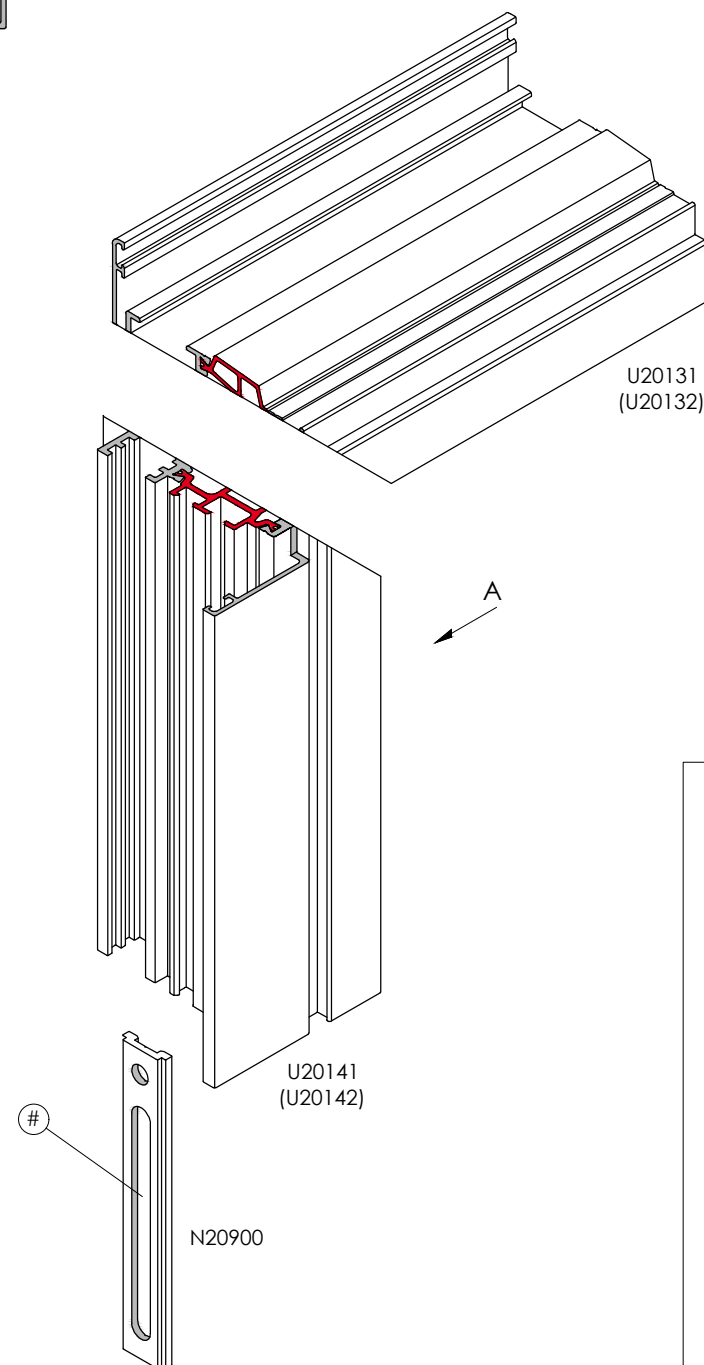


PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE TRACCIANTE ART. 909310
TO EXECUTE THIS CUTTING OUT USE ART. 909310 BLANKING MACHINE

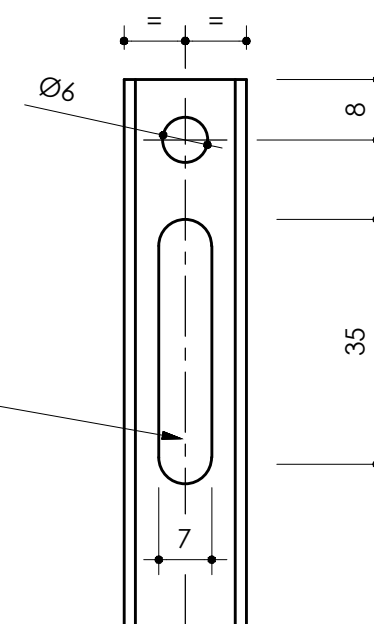
LAVORAZIONE MONTANTE CENTRALE BATTENTE / TZ E FORATURA ASTA N20900 ANTA TWO-WINGS WINDOW CENTRAL SEALING PLUG MACHINING



PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA ART. T40043
TO EXECUTE THIS MILLING WORK USE ART. T40043 MILLING CUTTER

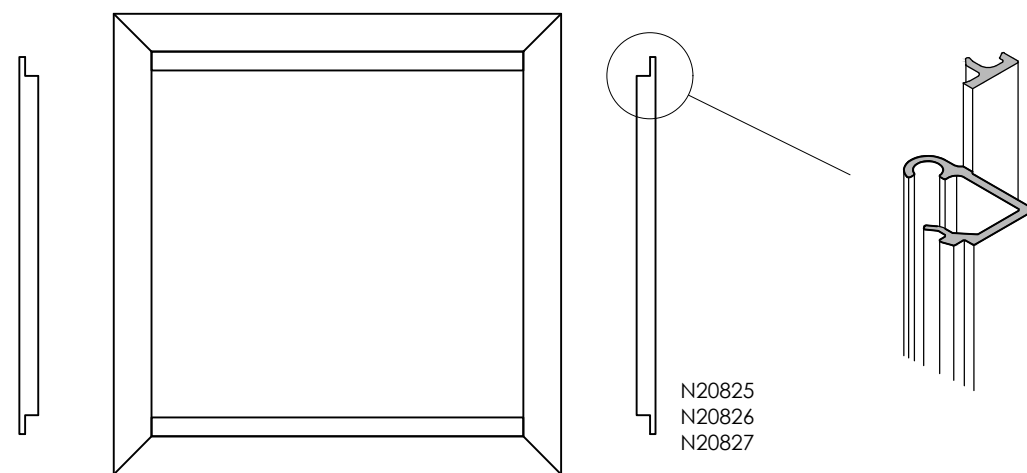


ASOLA 7x35 mm DA ESEGUIRE IN CASO
DI UTILIZZO DELL'ARTICOLO H48790
EXECUTE A 7x35 mm BUTTONHOLE
IF YOU USE THE H48790 ACCESSORY



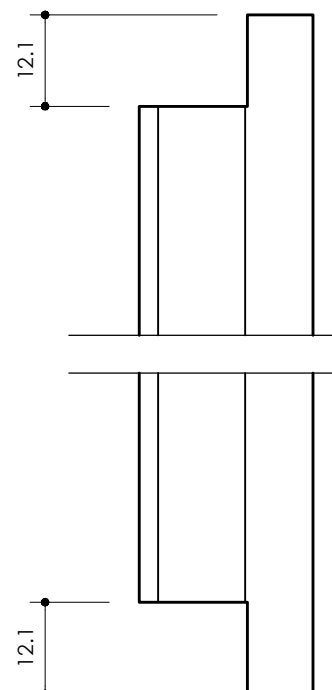
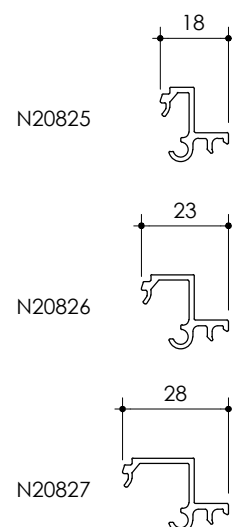
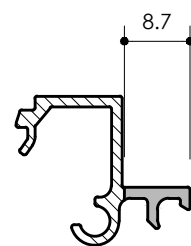
FORARE ALLE ESTREMITÀ DELL'ASTA N20900
UTILIZZANDO TRANCIANTE ART. 909310
TO EXECUTE THIS DRAINAGE SLOT USE
ART. 909310 BLANKING MACHINE

LAVORAZIONI FERMAVETRO "LINEA FERRO" "FERRO LINE" GLAZING BEAD MACHINING

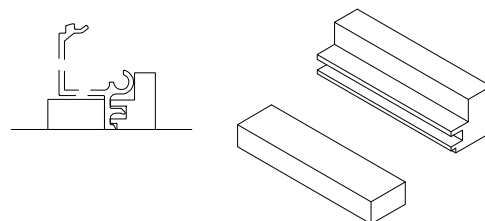


MONTARE PRIMA I FERMAVETRI ORIZZONTALI
FIRST ASSEMBLE THE HORIZONTAL GLASS BEAD

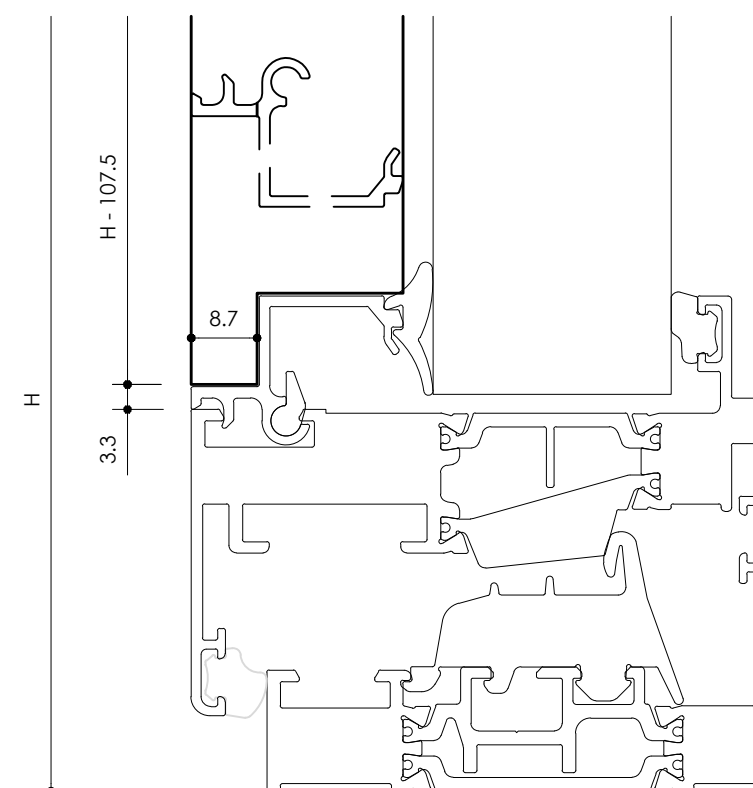
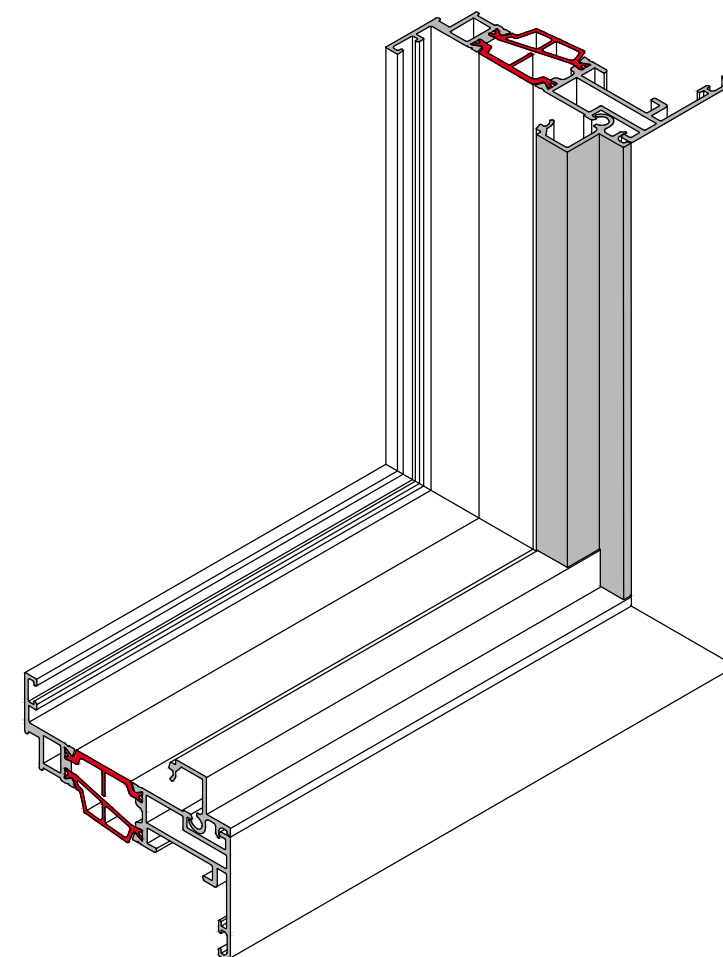
ESEGUIRE QUESTA LAVORAZIONE SOLO SUI FERMAVETRI VERTICALI
ONLY VERTICAL GLAZING BEAD MUST BE MACHINING



UTILIZZARE IL KIT DI FISSAGGIO T30010
USE ART. T30010 FIXING KIT



PER QUESTA LAVORAZIONE UTILIZZARE IL GRUPPO
FRESE Ø100 mm (T40048)
TO EXECUTE THIS MILLING WORK, USE ITEM (T40048)
Ø100 mm MILLING CUTTER



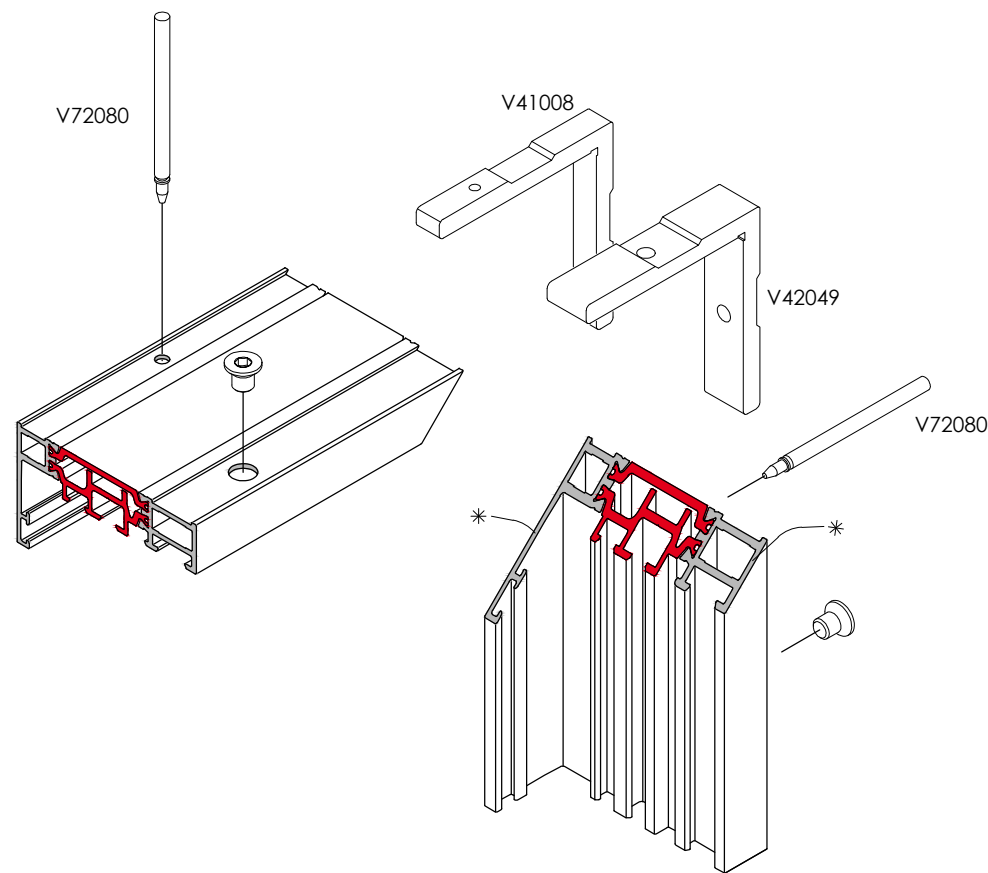
Section 10

Assemblaggio

Assembly

▶ SCHEMA DI MONTAGGIO STIPITE FIXED FRAME ASSEMBLING

MONTAGGIO SQUADRETTE CORNER JOINT ASSEMBLING

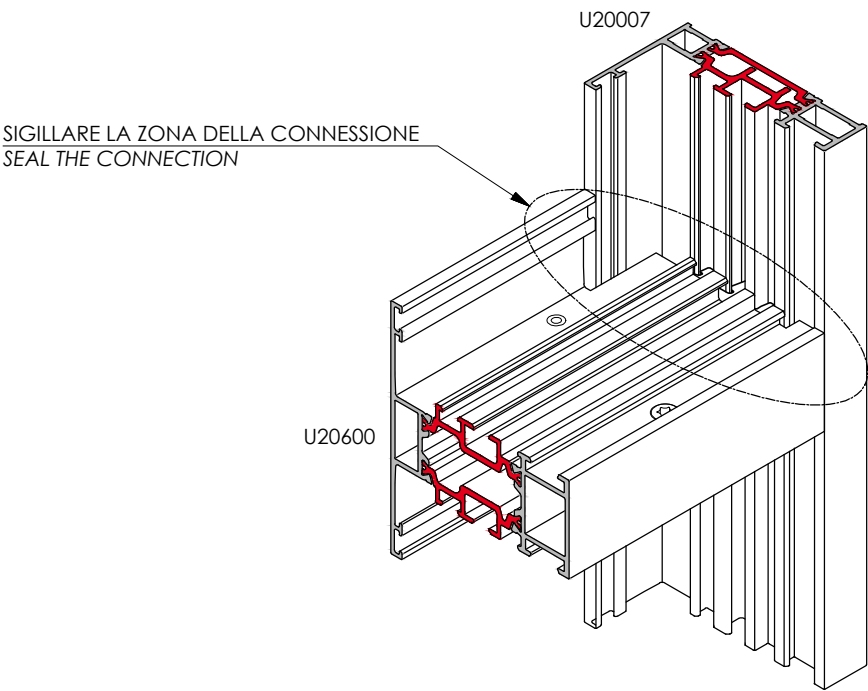
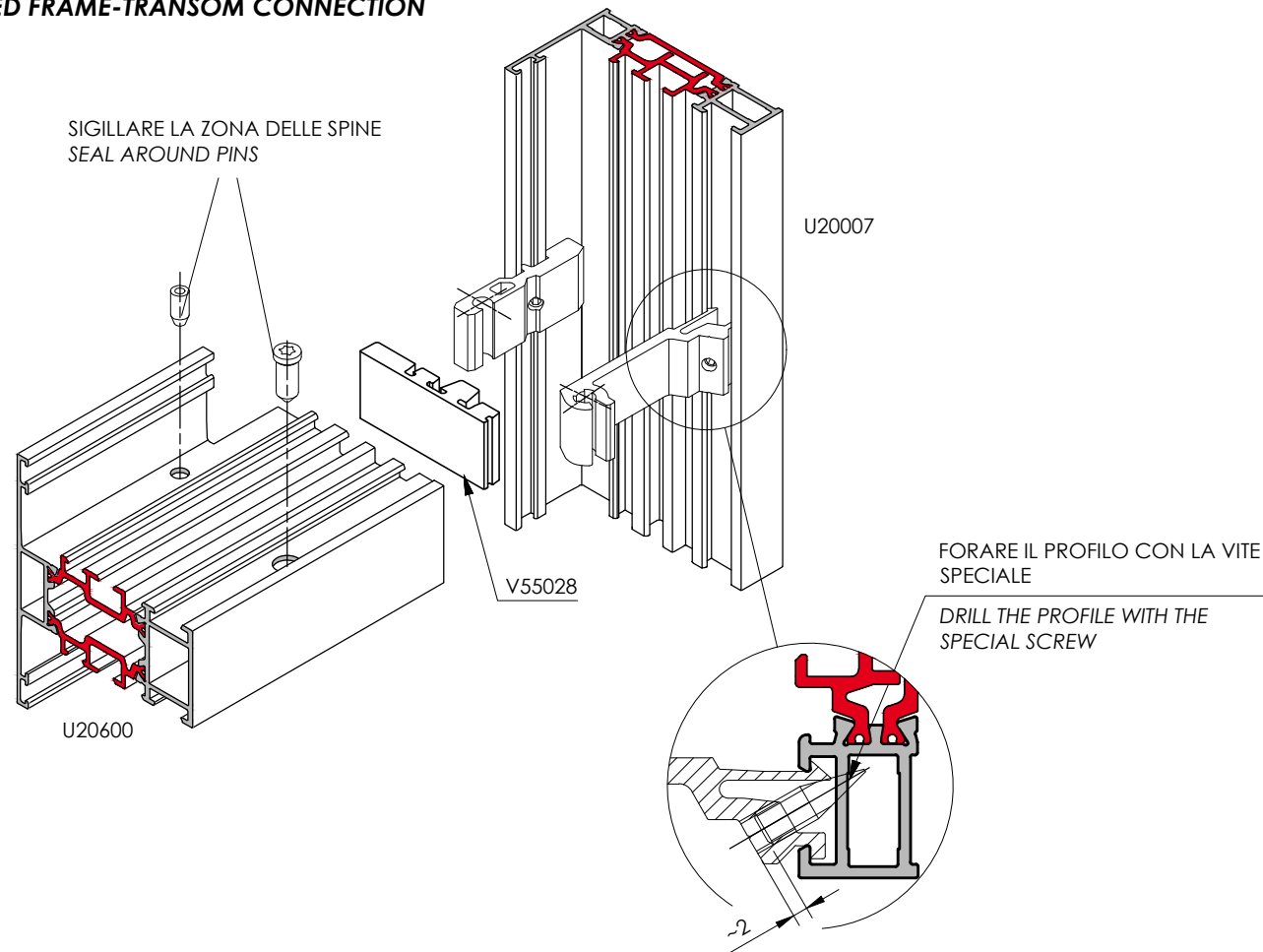


PROFILI	SQUADRETTA INTERNA	SQUADRETTA ESTERNA	SQUADRETTA ALLINEAMENTO
U20007	V42049	V41008	-
U20022	V42049	V41008	V46027

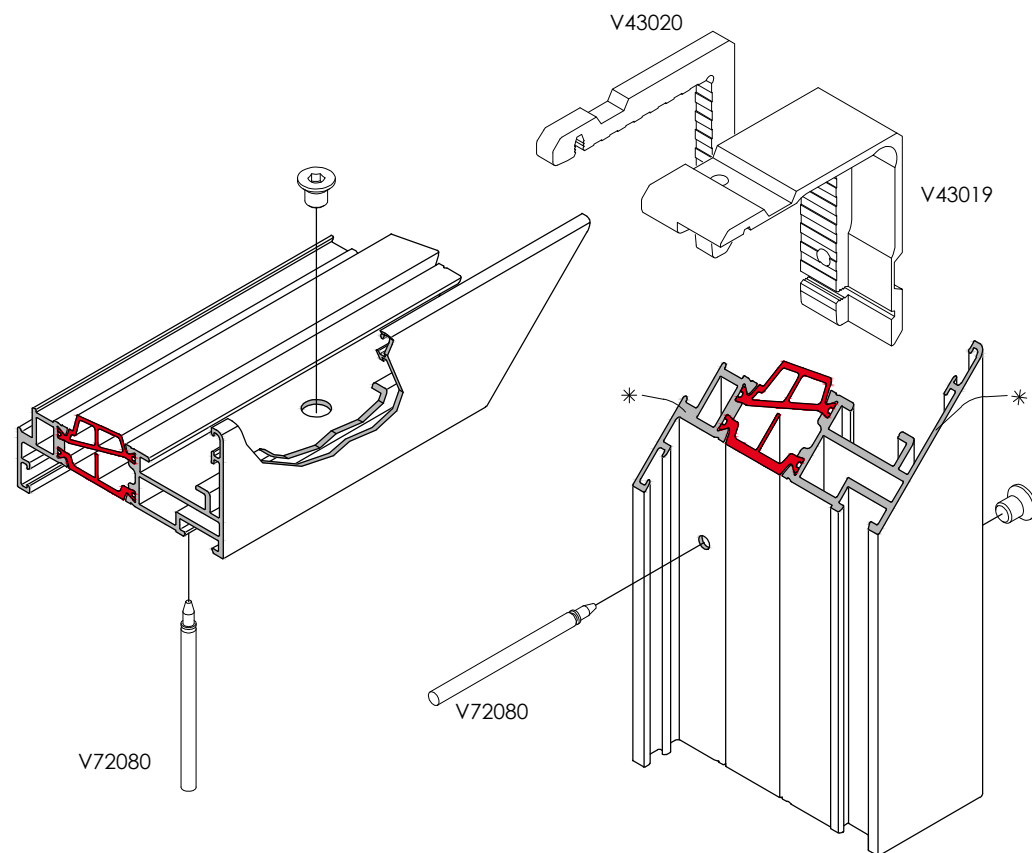
APPLICARE COLLANTE EPOSSIDICO NEI TUBOLARI ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
 EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY GLUE BEFORE CORNER JOINT ASSEMBLING

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

CONNESSIONE TRAVERSO-STIPITE FIXED FRAME-TRANSOM CONNECTION



▶ SCHEMA DI MONTAGGIO SQUADRETTE ANTA WING CORNER JOINTS ASSEMBLING DIAGRAM



SEQUENZA DI INSERIMENTO VITI:

- PUNTARE TUTTE LE VITI DEI QUATTRO ANGOLI SENZA SERRARE;
- SERRARE GRADUALMENTE LA COPPIA DI VITI PER CIASCUNA SQUADRETTA.

SEQUENCE OF SCREW INSERTION:

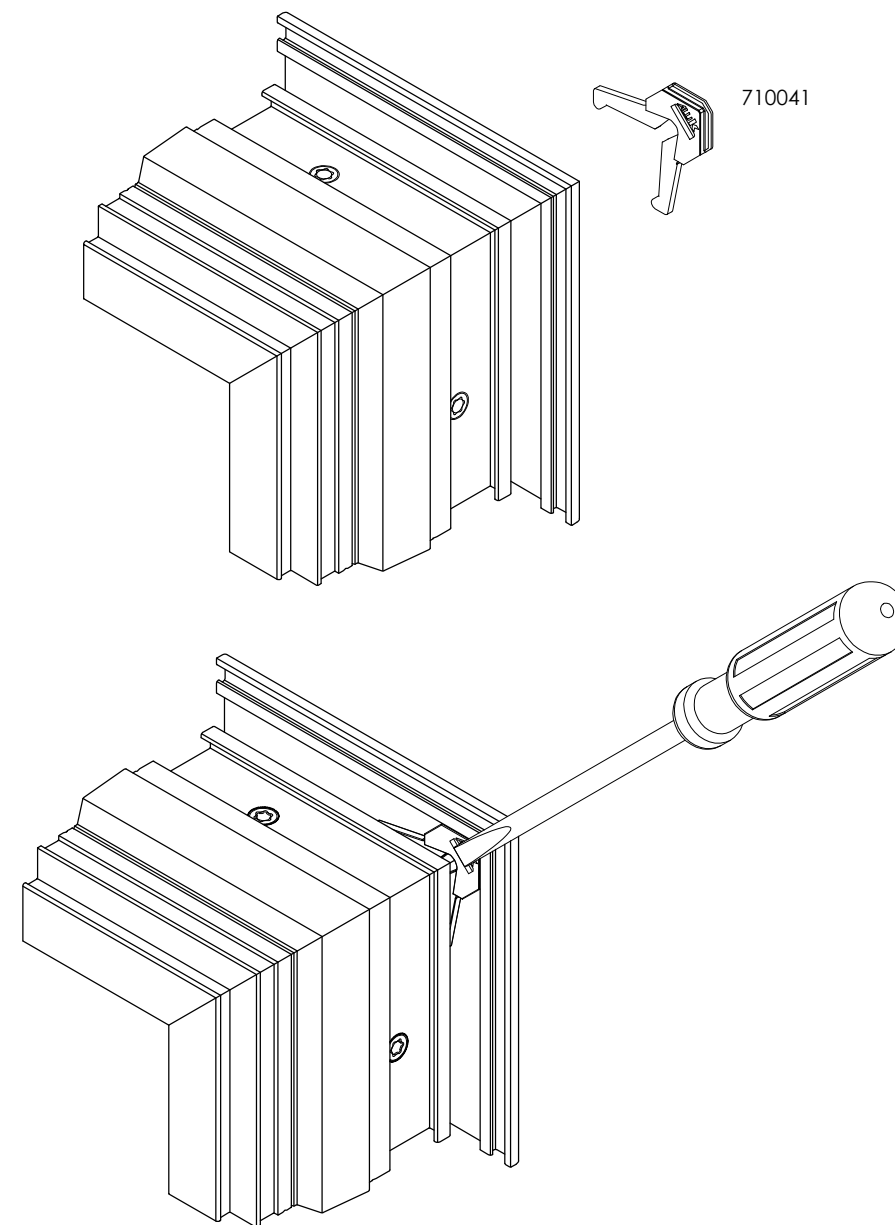
- POINT ALL FOUR CORNER SCREWS WITHOUT TIGHTENING;
- GRADUALLY TIGHTEN THE SCREW TORQUE FOR EACH BRACKET.

	PROFILI	SQUADRETTA INTERNA	SQUADRETTA ESTERNA
LINEA STANDARD	U20131	V42049	V41008
	U20141		
LINEA FERRO	U20132	V42049	V41008
	U20142		

APPLICARE COLLANTE EPOSSIDICO NEI TUBOLARI ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
 EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY GLUE BEFORE CORNER JOINT ASSEMBLING

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

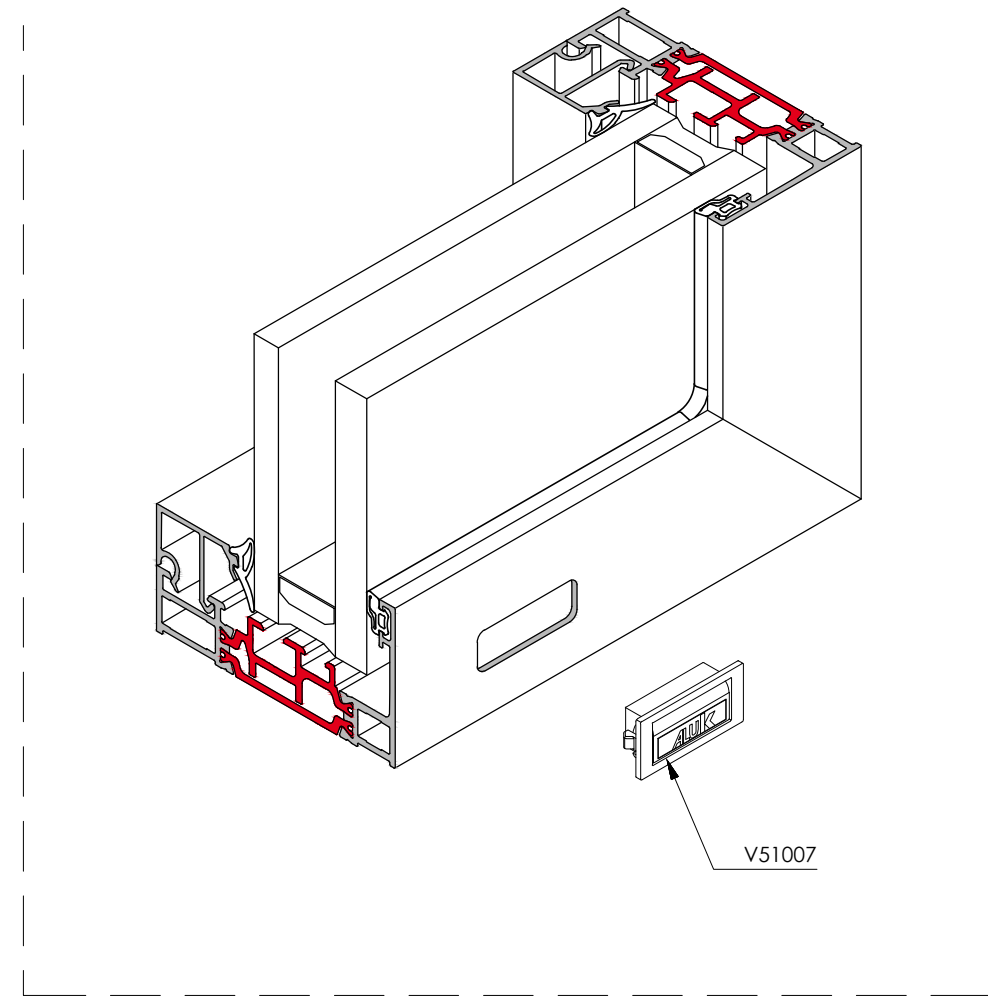
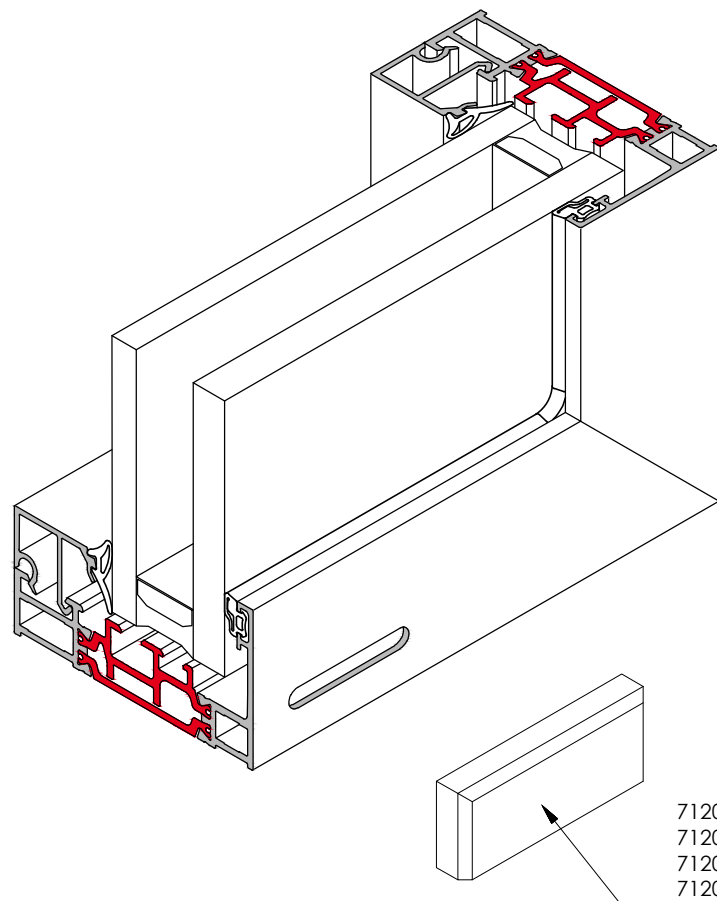
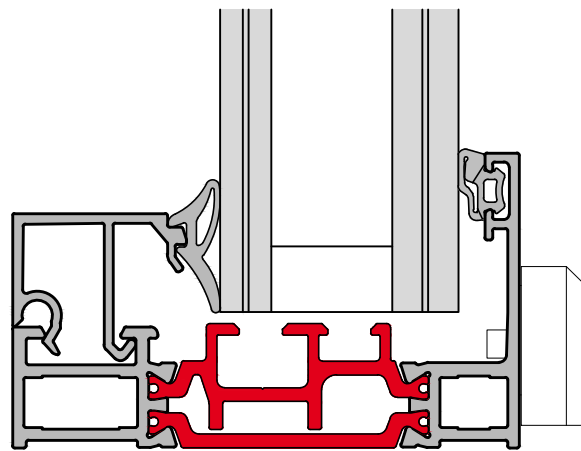
SQUADRETTA D'ALLINEAMENTO ALIGNMENT CORNER JOINT



	PROFILI	SQUADRETTA ALLINEAMENTO
LINEA STANDARD	U20131	710041
LINEA FERRO	U20132	710041

> SCHEMA DI MONTAGGIO ACCESSORI DI DRENAGGIO
 WATER DRAIN CAPS DIAGRAM ASSEMBLING

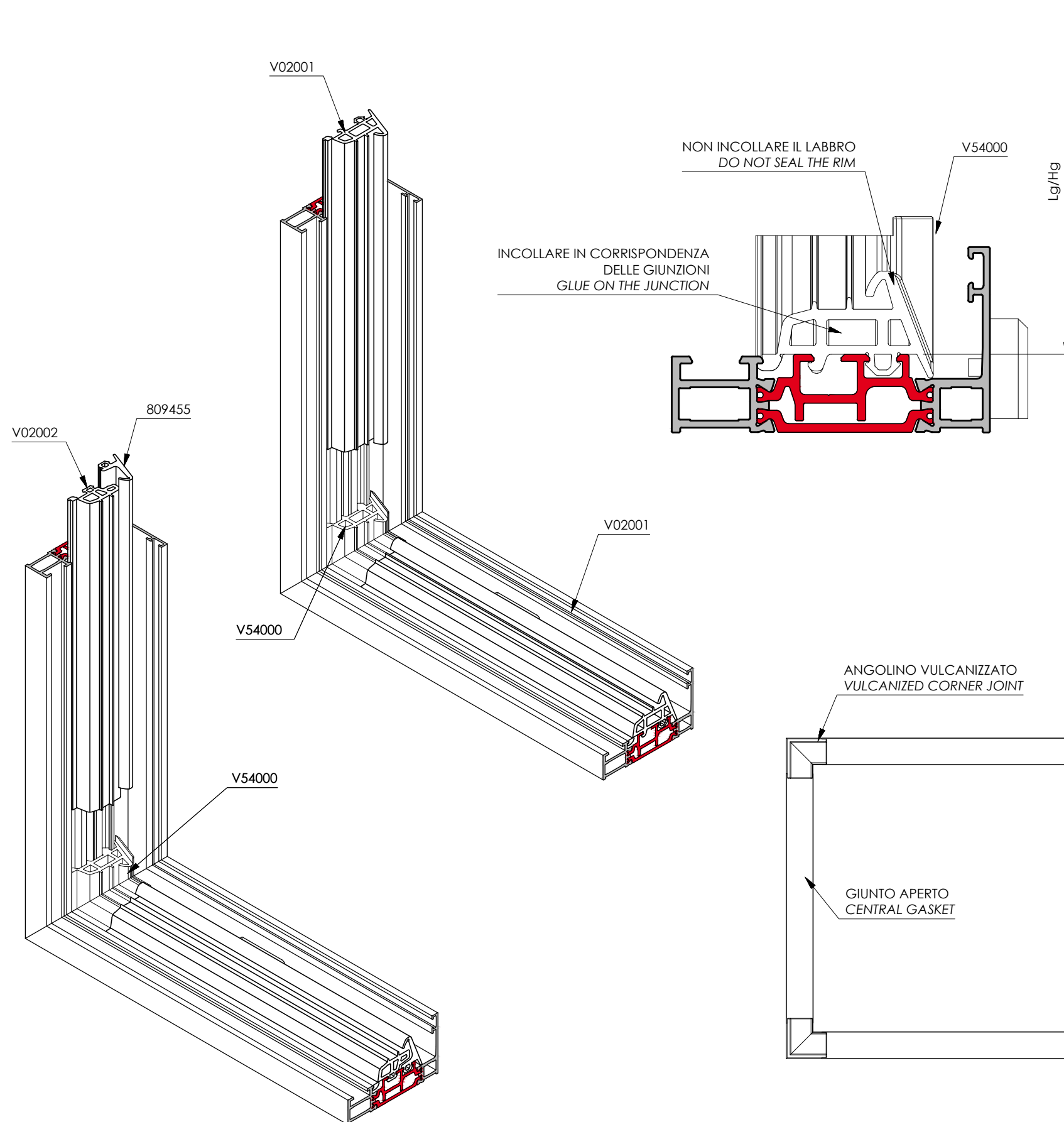
APPLICABILE AI PROFILI APPLICABLE TO PROFILES	
U20007	U20022



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 GUARNIZIONI DI GIUNTO APERTO FITTING OF THE CENTRAL GASKET



- TAGLIARE LA GUARNIZIONE NEL MODO SEGUENTE:
PER DIMENSIONI CON Lg/Hg SOTTO I 1000 mm = $(Lg/Hg-50)+1\%$
PER DIMENSIONI CON Lg/Hg SOPRA I 1000 mm = $(Lg/Hg-50)+0.5\%$

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

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

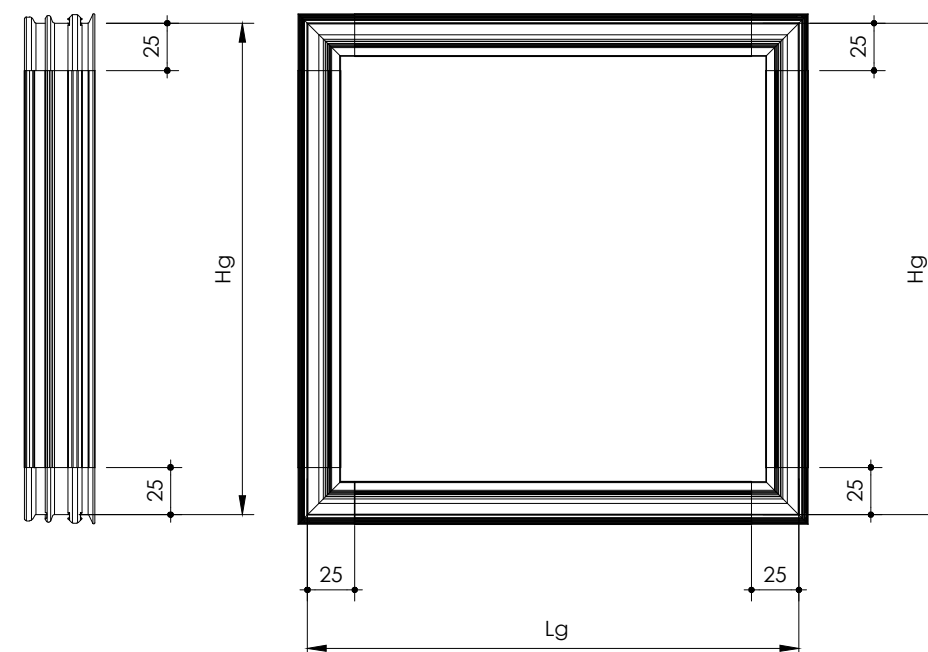
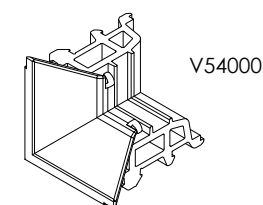
- SIGILLARE LA SEDE DELLA GUARNIZIONE IN CORRISPONDENZA DELL'ANGOLO

- CUT THE GASKET AS FOLLOWS:
WITH DIMENSION Lg/Hg UNDER 1000 mm = $(Lg/Hg-50)+1\%$
WITH DIMENSION Lg/Hg OVER 1000 mm = $(Lg/Hg-50)+0.5\%$

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

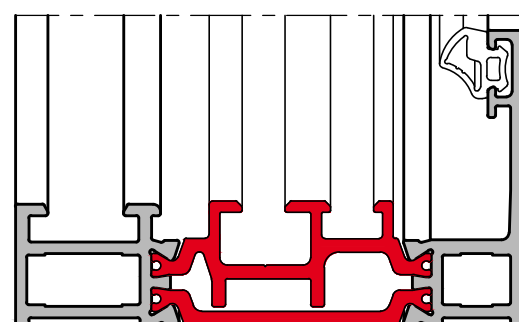
- USE A CYANOACRYLIC GLUE TO FORM A FRAME WITH GASKET AND VULCANIZED CORNER JOINTS

- SEAL THE GASKET SEATING IN CONNECTION WITH CORNER JOINT



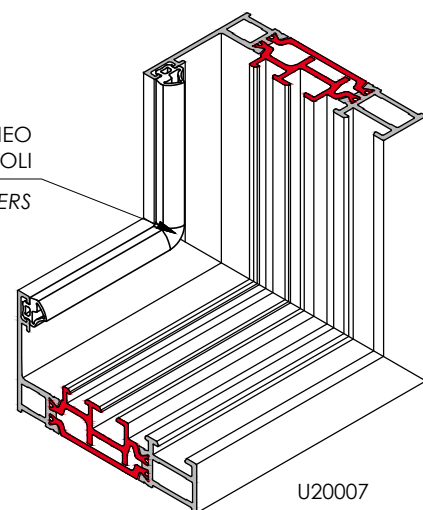
SCHEMA DI MONTAGGIO GUARNIZIONI FITTING OF GLAZING GASKET

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

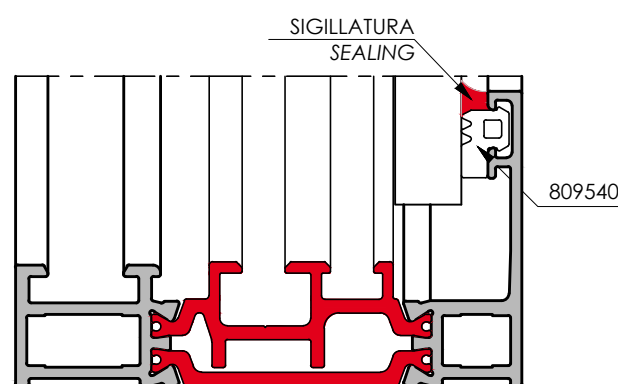


U20007

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

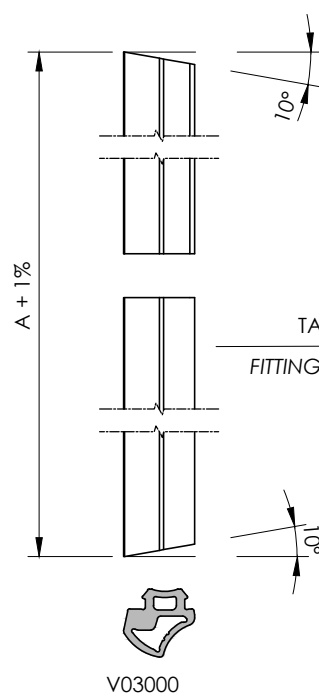


U20007

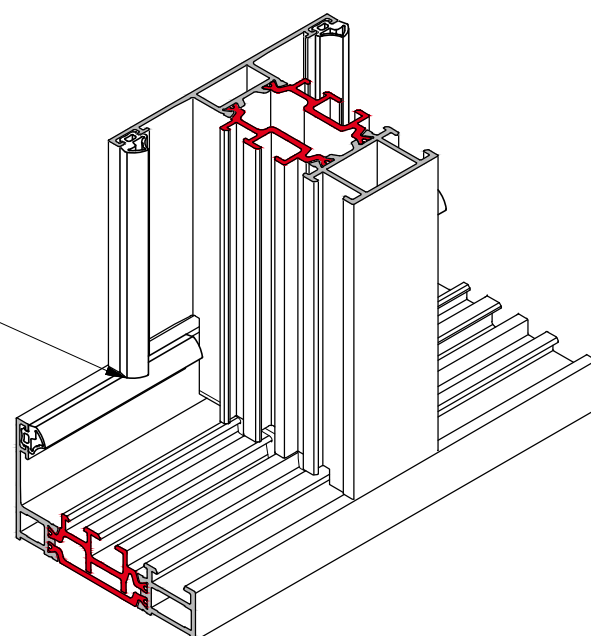


VARIANTE CON SIGILLATURA ESTERNA E FONDO DI GIUNTO
COD. 809540
ALTERNATIVE SOLUTION: EXTERNAL SEALING AND BACKER
ROD COD. 809540

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



TAGLIO GUARNIZIONE
FITTING OF GASKET ON T-JOINTS

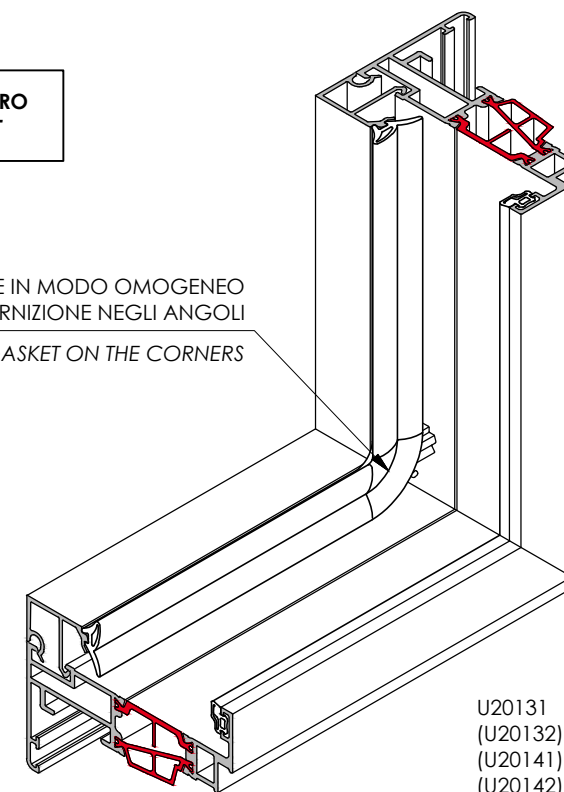


V03000

MONTAGGIO GUARNIZIONI BATTENTE FITTING OF WING GASKETS

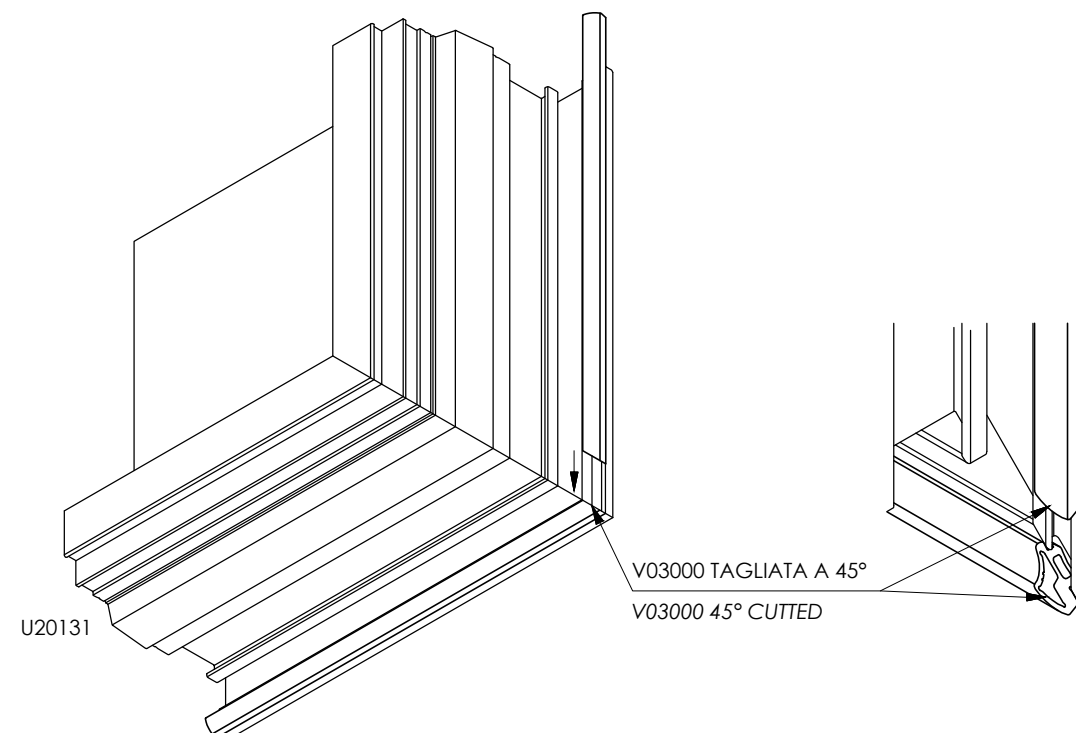
GUARNIZIONE INTERNA VETRO INTERNAL GLAZING GASKET

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



U20131
(U20132)
(U20141)
(U20142)

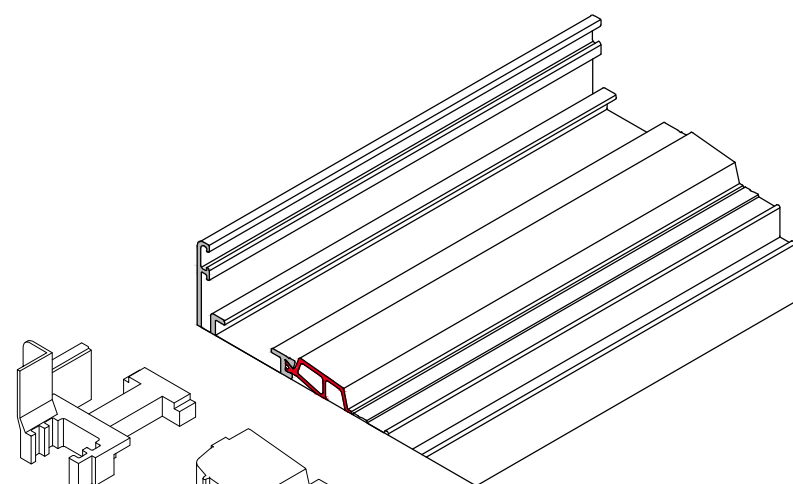
GUARNIZIONE V03000 SU BATTUTA INTERNA ANTE V03000 GASKET ON WING INTERNAL REBATE



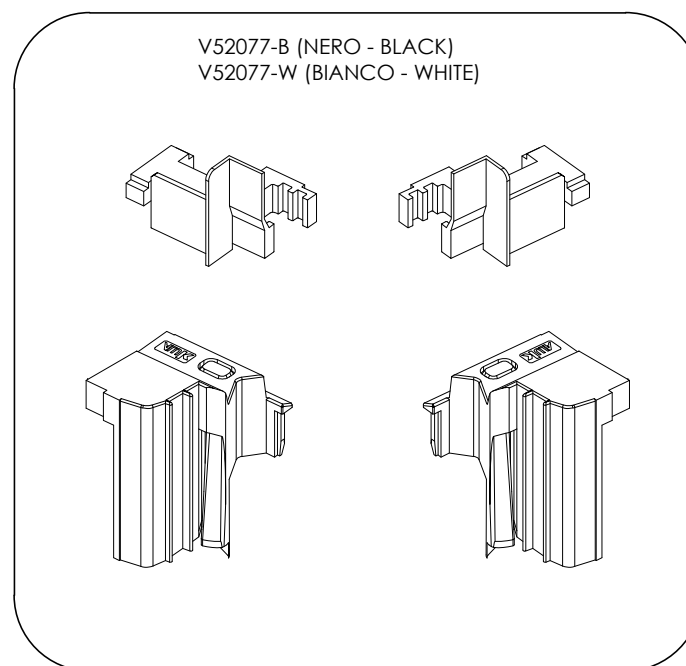
U20131

V03000 TAGLIATA A 45°
V03000 45° CUTTED

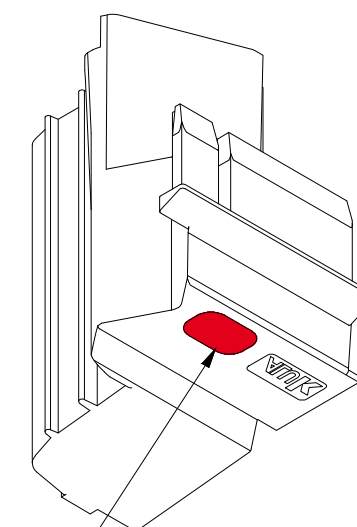
SCHEMA DI MONTAGGIO TAPPI CENTRALI DUE ANTE TZ
TWO-WINGS WINDOW CENTRAL SEALING PLUGS ASSEMBLING DIAGRAM



U20131
(U20132)

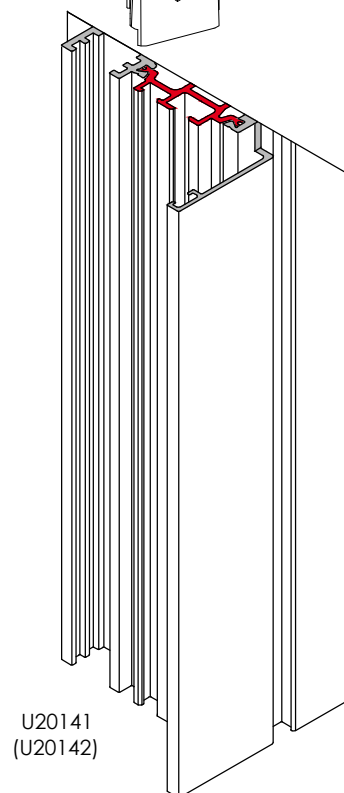


V52077-B (NERO - BLACK)
V52077-W (BIANCO - WHITE)

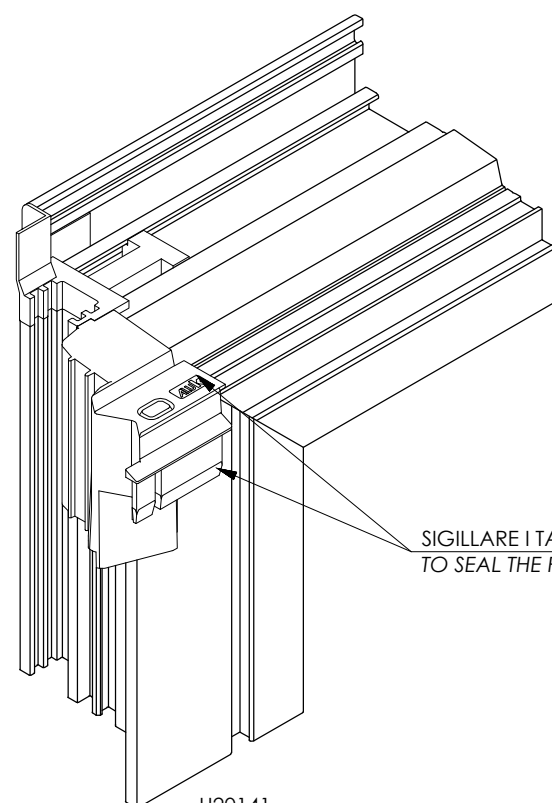


APRIRE L'ASOLA PER IL DRENAGGIO
NEL TAPPO INFERIORE

TO OPEN THE DRAINAGE SLOT IN THE LOWER CAP



U20141
(U20142)

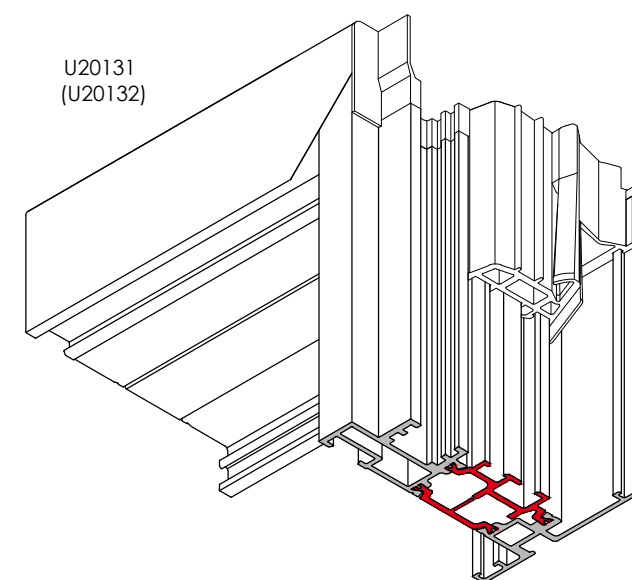


U20131
(U20132)

U20131
(U20142)

SIGILLARE I TAPPI
TO SEAL THE PLUGS

U20141
(U20142)

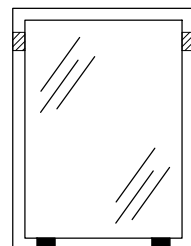


U20131
(U20132)

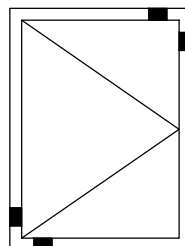
U20141
(U20142)

SCHEMA DI MONTAGGIO TASSELLI VETRO E SIGILLATURA VETRO GLASS CLEATS AND SEALING GLASS DIAGRAM ASSEMBLING

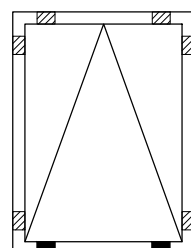
TELAIO FISSO
FIXED FRAME



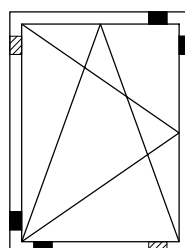
ANTA
ONE WING



VASISTAS
BOTTOM HUNG



ANTA RIBALTA
TURN AND TILT



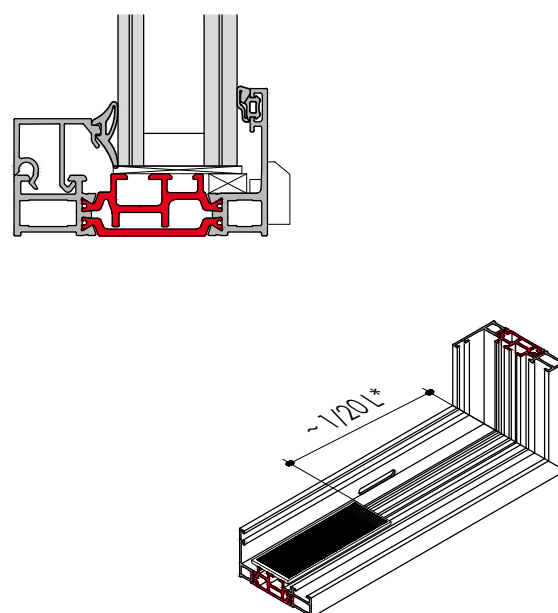
■ TASSELLI DI APPOGGIO - I tasselli di appoggio devono essere disposti secondo gli schemi sopra indicati ad una distanza dal bordo esterno del vetro fra 1/10 e 1/20 della larghezza del vetro.

■ 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.

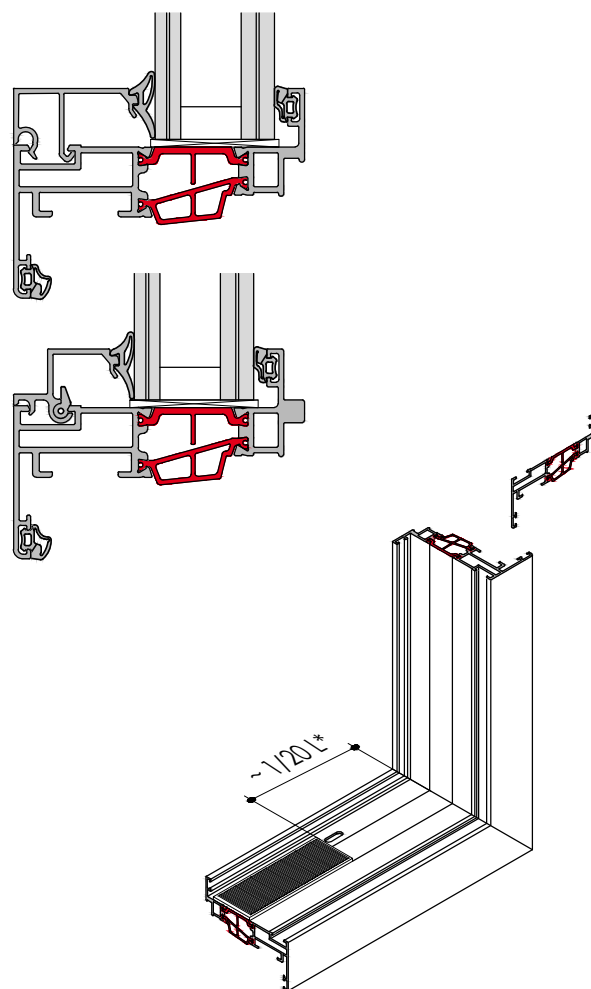
☑ TASSELLI PERIFERICI - I tasselli periferici assicurano il posizionamento del vetro. Detti tasselli devono essere inseriti, senza forzare, fra il vetro e il telaio in modo da assicurare la stabilità del vetro.

☑ 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.

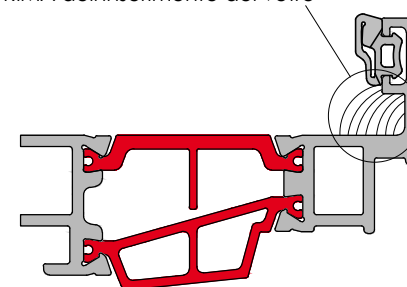


* L = LARGHEZZA VETRO
* L = GLASS WIDTH

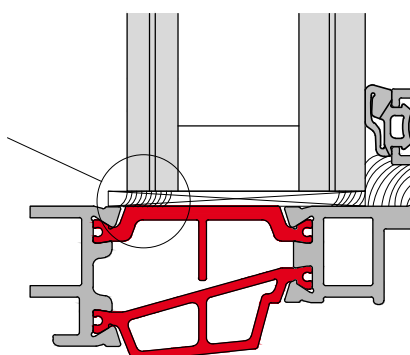


* L = LARGHEZZA VETRO
* L = GLASS WIDTH

Tratti di sigillante da applicare
PRIMA dell'inserimento del vetro



Tratti di sigillante da applicare
DOPO l'inserimento del vetro



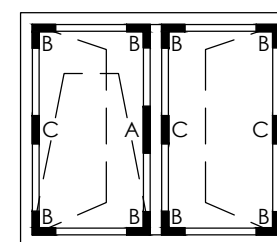
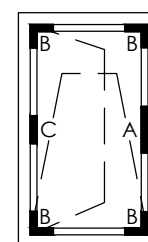
ATTENZIONE: dopo la sigillatura dei vetri, non sarà possibile effettuare le abituali compensazioni mediante i tasselli di appoggio del vetro.

WARNING: after the glass has been sealing, it will not be possible to adjust the position of the glass pane by using the glass packer.

- Utilizzare sigillante bicomponente del tipo Sika WT66 o similare, dopo accurata pulizia delle superfici e trattamento con primer.
- Accertarsi di lasciare libere le asole di ventilazione dell'anta.
- Si suggerisce di precaricare leggermente la posizione dell'anta secondaria per compensare la deformazione sotto carico.

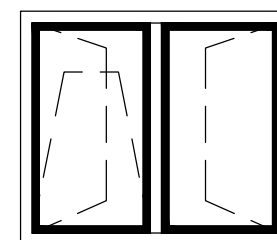
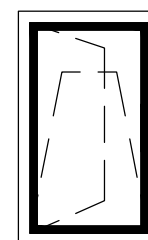
- Use two-component sealant (Sika WT66 or similar), after cleaning of surfaces and treatment with primer.
- Be sure to leave the ventilation slots of the sash free.
- It is suggested to slightly preload the position of the secondary sash to compensate for deformation under load

Ante di dimensione inferiore a 600 mm x 1400 mm e peso inferiore a 70 kg.
Sashes smaller than 600 mm x 1400 mm and weight less than 70 kg.



- (A) Sigillare L= 250 mm, in corrispondenza della maniglia
(B) Sigillare gli angoli del vetro per un tratto da 100 +100 mm circa.
(C) Sigillare in mezzeria dei montanti L=150 mm
(A) L= 250 mm sealant, at the handle position
(B) To seal the corners of the glass for about 100 +100 mm.
(C) To seal in the middle of the mullions with L= 150 mm

Ante di dimensione superiore a 600 mm x 1400 mm o peso superiore a 70 kg.
Sashes larger than 600 mm x 1400 mm or weight more than 70 kg.

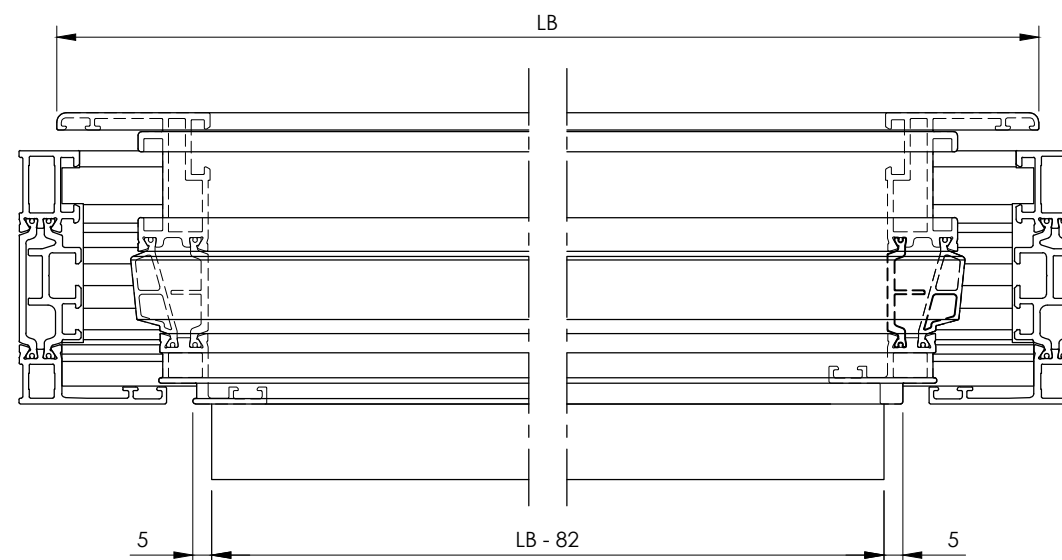
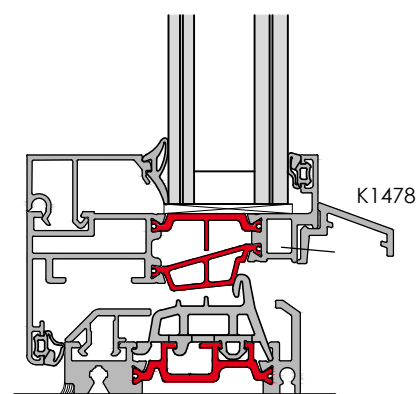


Sigillare l'intero perimetro del vetro

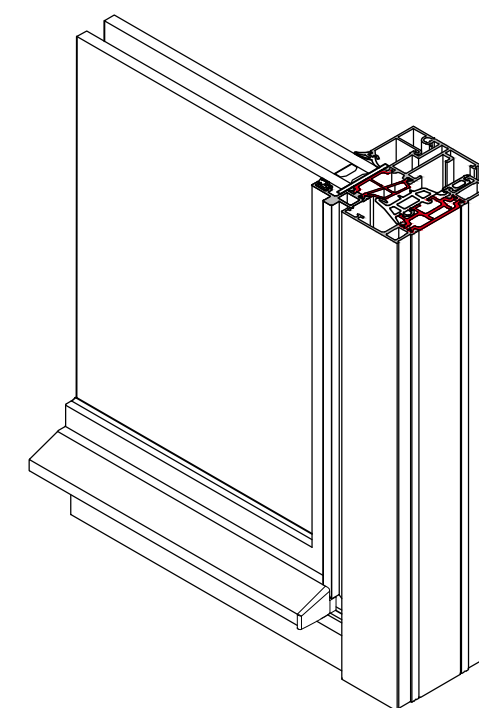
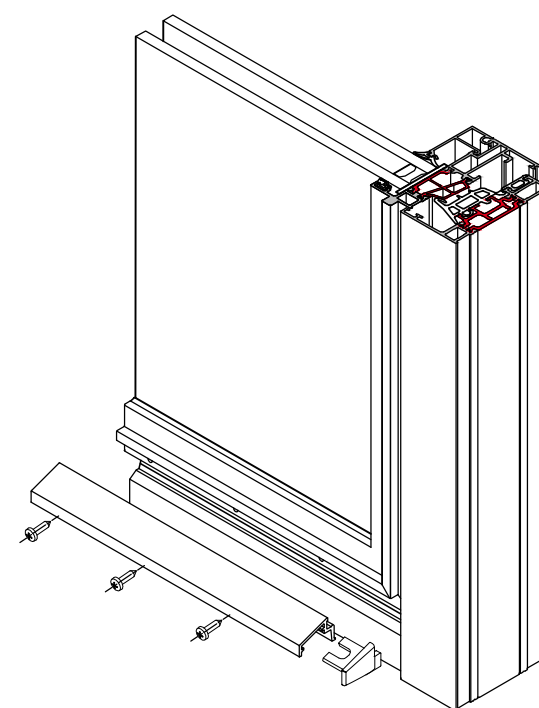
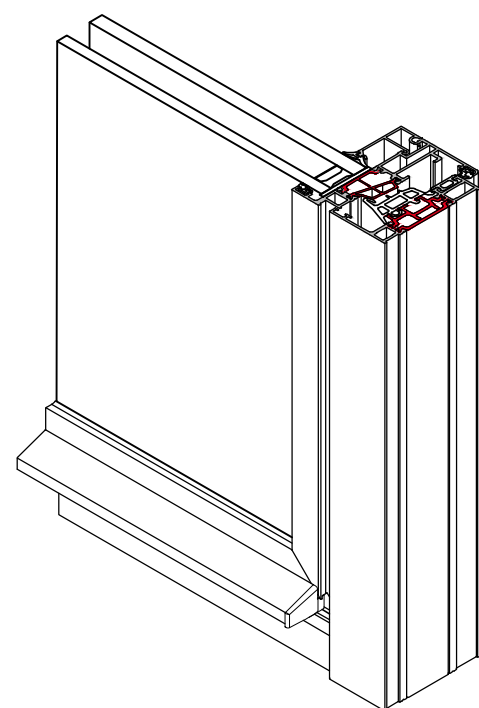
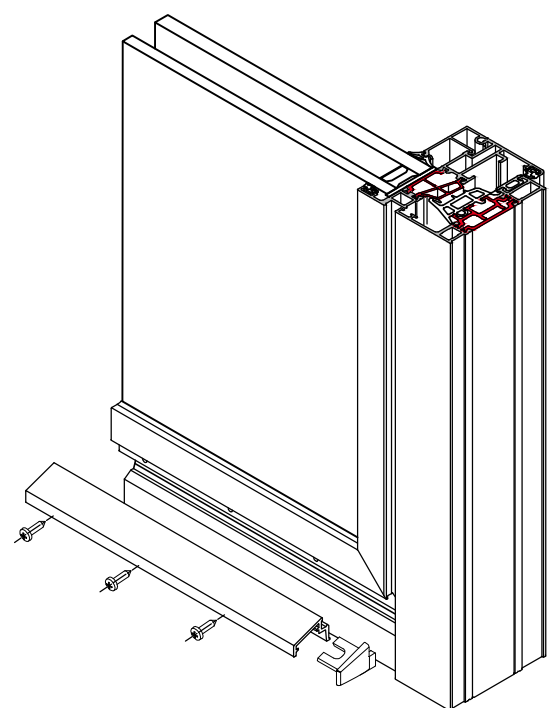
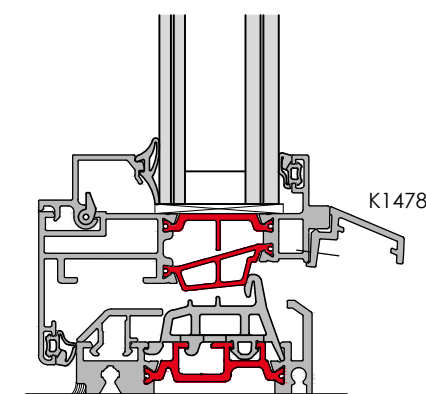
To seal the entire perimeter of the glass pane

➤ SCHEMA DI MONTAGGIO TAPPI 712010 SU GOCCIOLATOIO K1478
712010 PLUGS ASSEMBLING DIAGRAM ON K1478

LINEA STANDARD

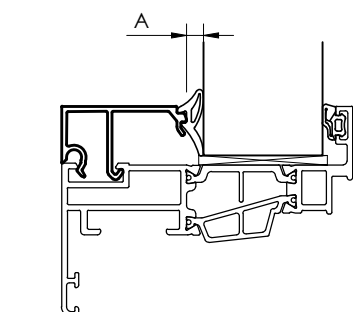
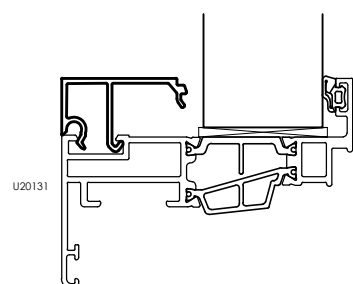
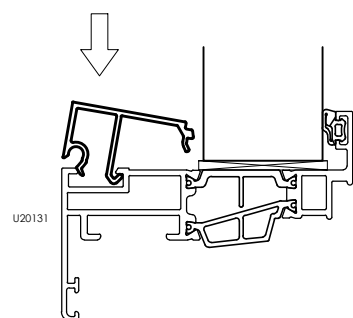
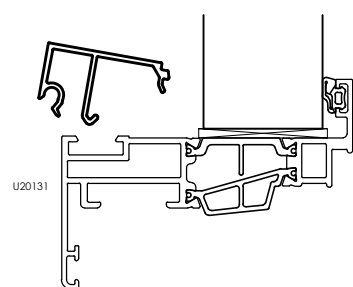


LINEA FERRO

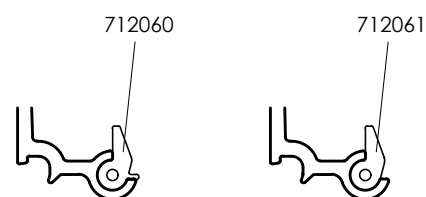


▶ SCHEMA DI MONTAGGIO E SMONTAGGIO FERMAVETRI GLAZING BEAD ASSEMBLING AND REMOVING DIAGRAM

LINEA STANDARD **STANDARD LINE**

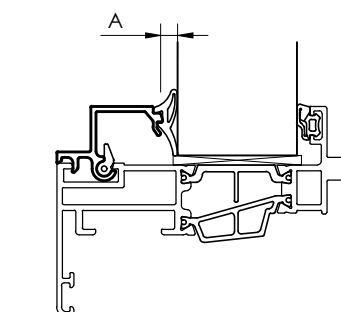
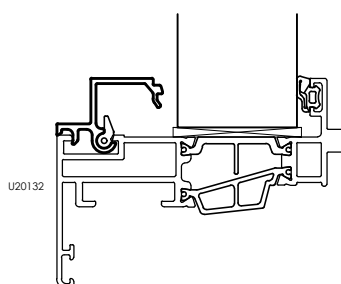
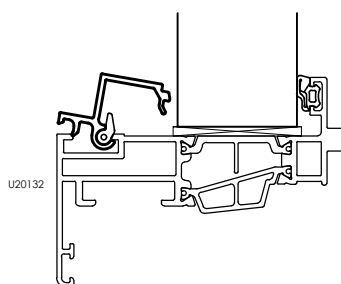


LINEA FERRO **FERRO LINE**

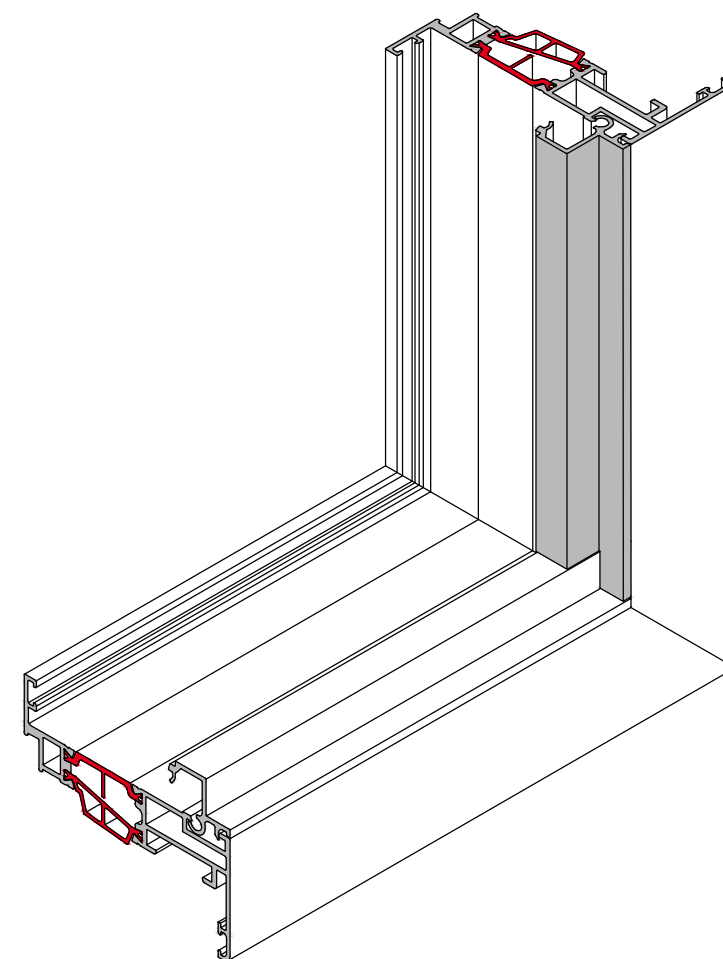


POSIZIONARE LE GUARNIZIONI A PASSO DI 400-500 mm
 THE GASKETS COULD BE POSITIONED BY STEP OF 400-500 mm

RITEGNO 712060 PER FINITURE ANODIZZATE
 712060 GLAZING BEAD SHIM FOR ANODIZED FINISH

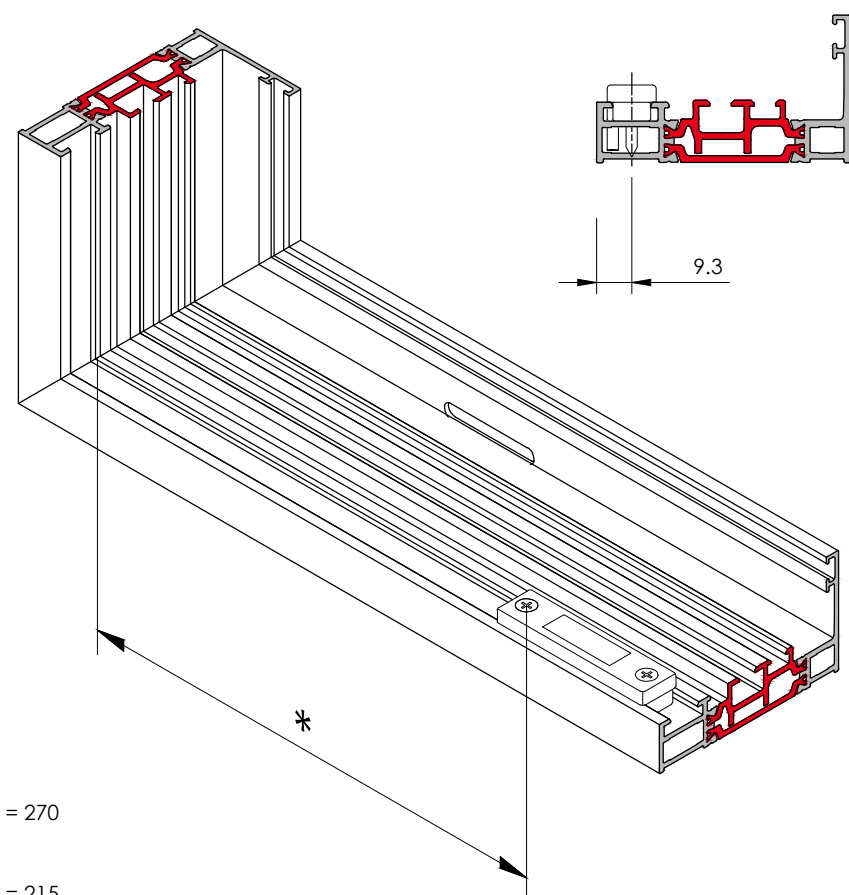
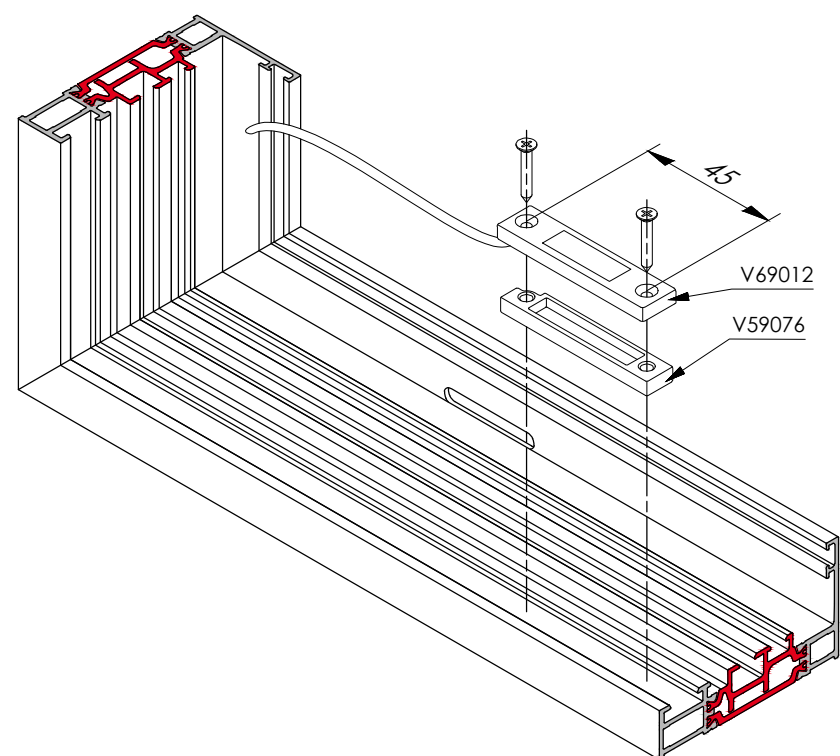


INSERIRE PRIMA IL FERMAVETRO VERTICALE
 FIRST INSERT VERTICAL GLAZING BEAD



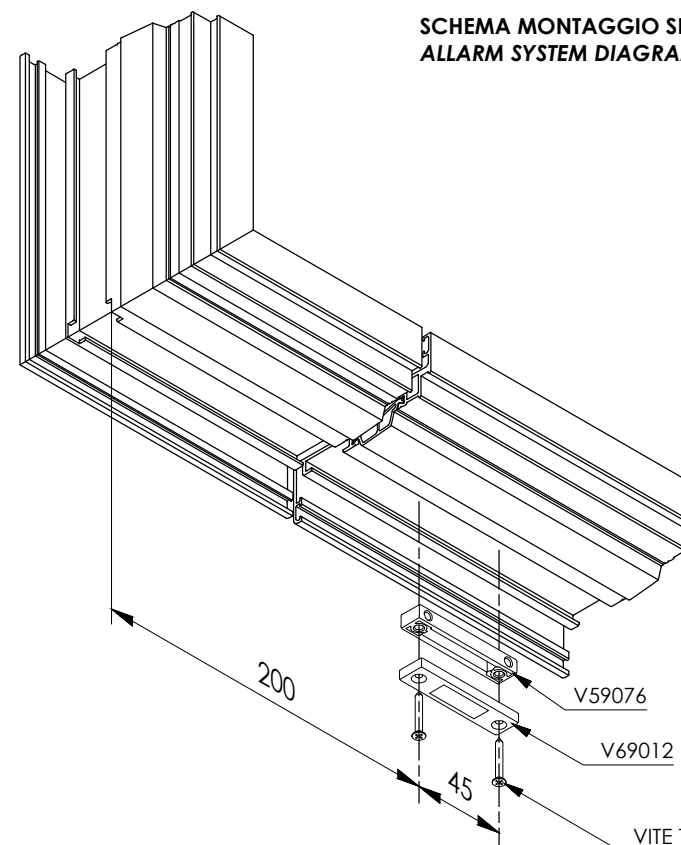
SCHEMA DI MONTAGGIO SENSORE ALLARME ALARM SYSTEM DIAGRAM ASSEMBLING

SCHEMA MONTAGGIO SENSORE ALLARME LATO STIPITE
 ALLARM SYSTEM DIAGRAM ASSEMBLING FIXED FRAME SIDE

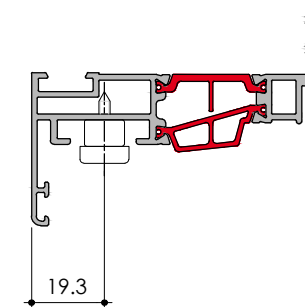


* = 270
 * = 215

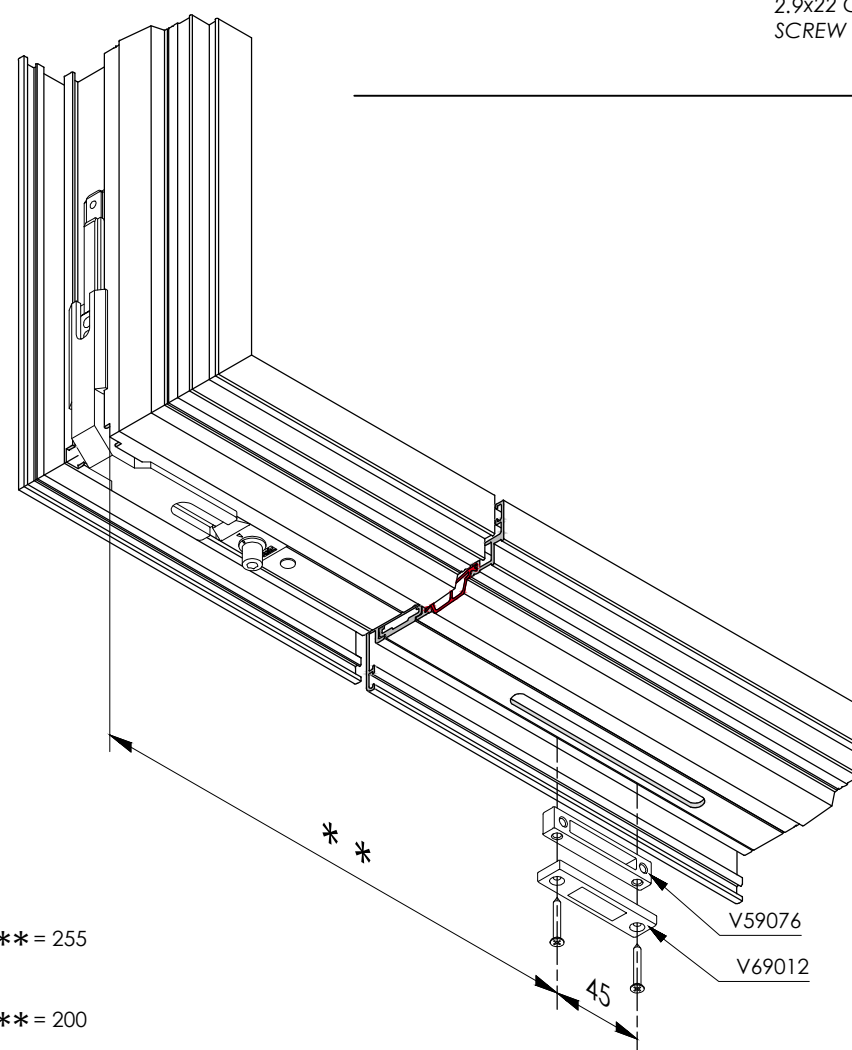
SCHEMA MONTAGGIO SENSORE ALLARME LATO BATTENTE
 ALLARM SYSTEM DIAGRAM ASSEMBLING SASH SIDE



SENZA ASTA
 WITHOUT ROD

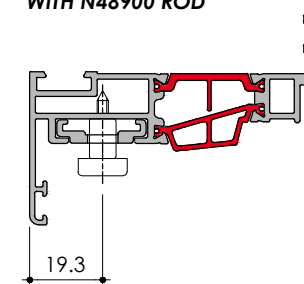


VITE TSP 2.9x22 UNI EN ISO 7050
 2.9x22 COUNTERSUNK HEAD TAPPING
 SCREW UNI EN ISO 7050

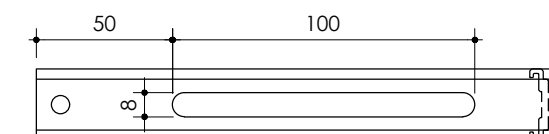


** = 255
 ** = 200

CON ASTA N48900
 WITH N48900 ROD

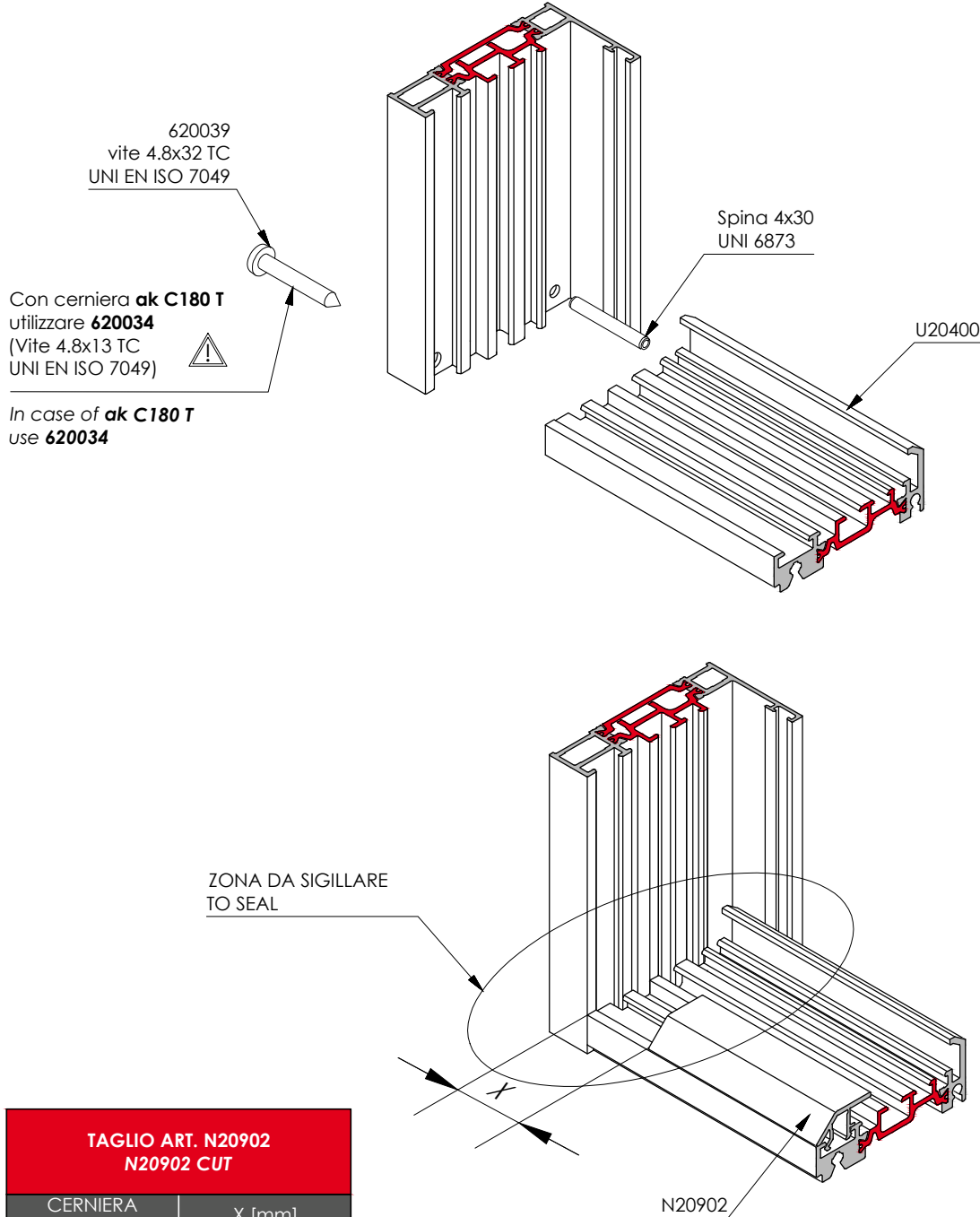


LAVORAZIONE ASTA N48900
 N48900 ROD MACHINING



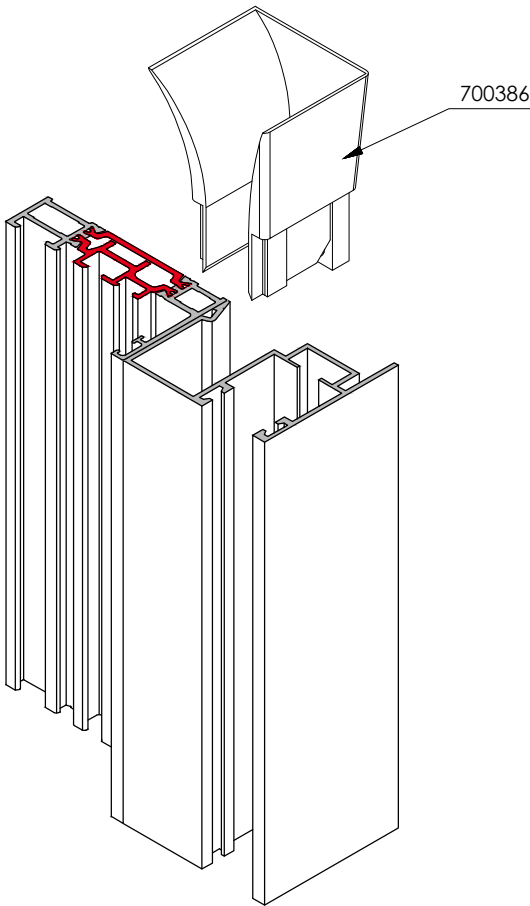
SCHEMA DI MONTAGGIO SOGLIA RIBASSATA E TAPPO GUIDA TAPPARELLA
BALCONY DOOR AND ROLLER SHUTTER GUIDE PLUG DIAGRAM ASSEMBLING

SCHEMA DI MONTAGGIO SOGLIA RIBASSATA
LOWERED THRESHOLD SECTION ASSEMBLING DIAGRAM

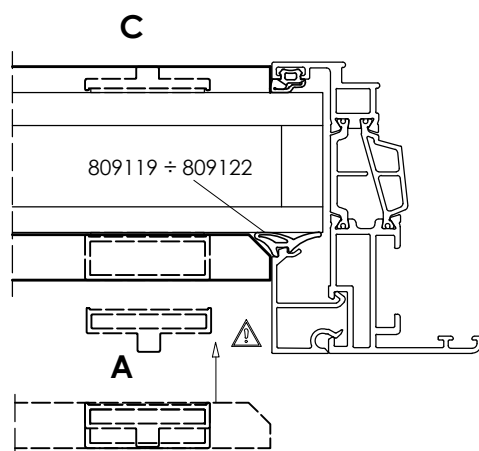
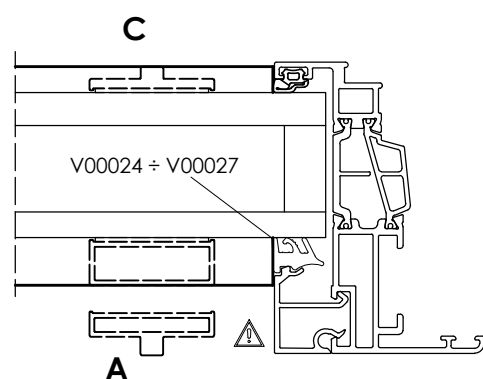
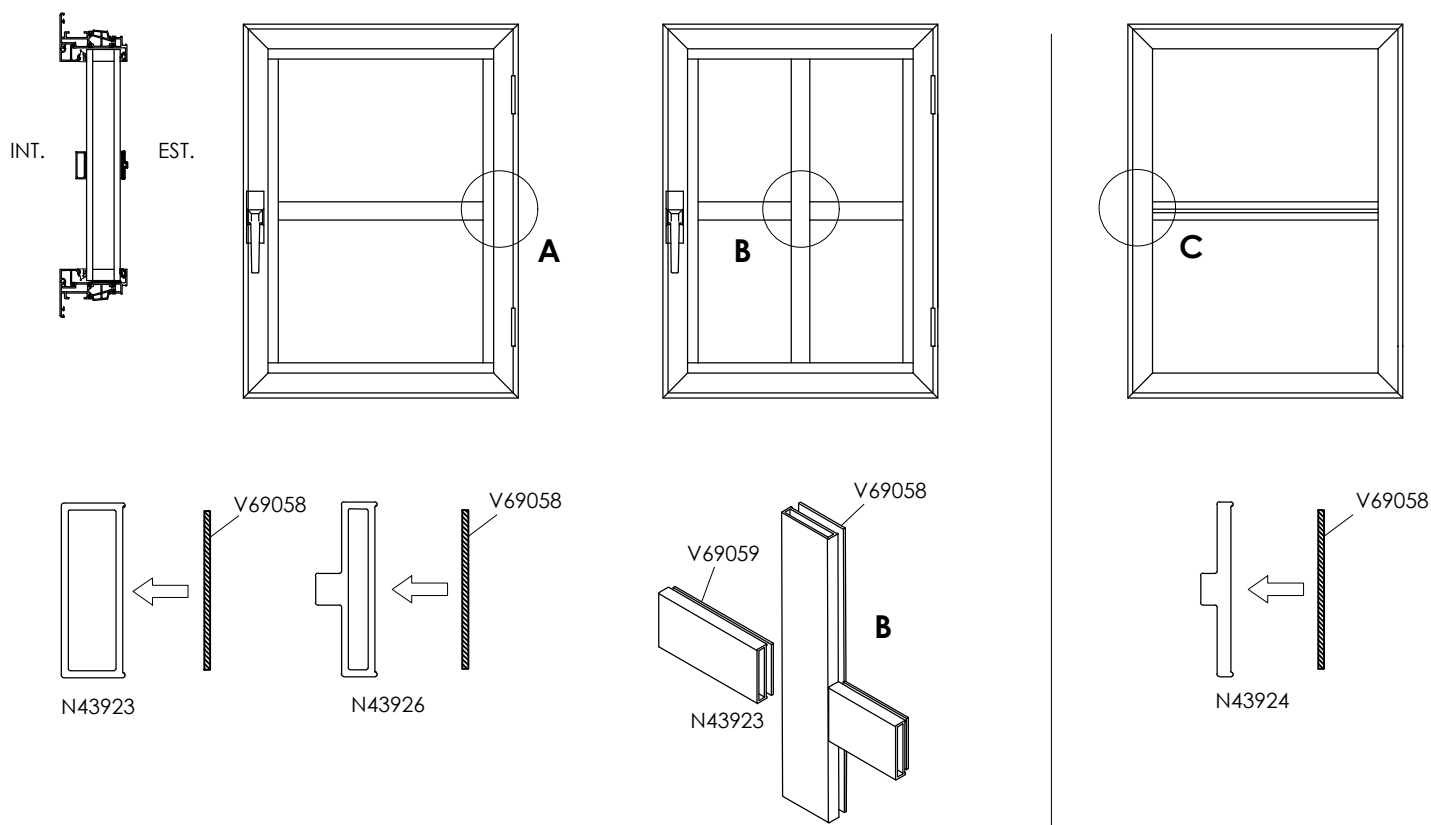


TAGLIO ART. N20902 N20902 CUT	
CERNIERA HINGE	X [mm]
ak C110 T	232
ak C180 T	274

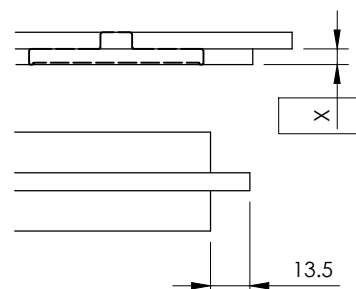
SCHEMA DI MONTAGGIO TAPPO GUIDA TAPPARELLA
ROLLER SHUTTER GUIDE PLUG ASSEMBLING DIAGRAM



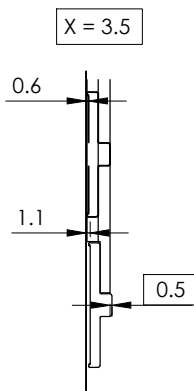
LAVORAZIONI E MONTAGGIO PROFILI "INGLESINA" MACHINING AND ASSEMBLY OF "INGLESINA" PROFILES



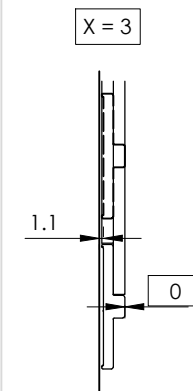
LAVORAZIONE N43924 MACHINING N43924



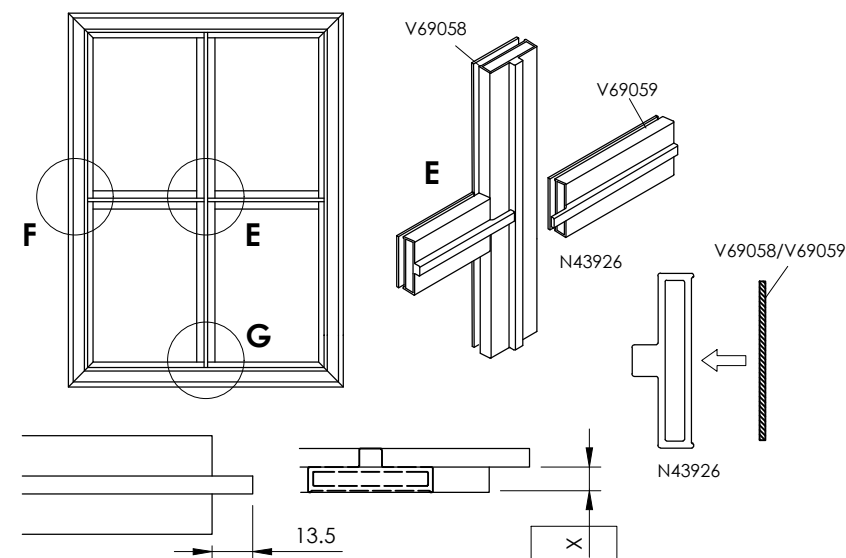
**OPZIONE 1
OPTION 1**
NASTRI - TAPES
- V69058 (SP 1,1 mm)
- V69059 (SP 0,6 mm)



**OPZIONE 2
OPTION 2**
NASTRO - TAPE
V69058 (SP 1,1 mm)

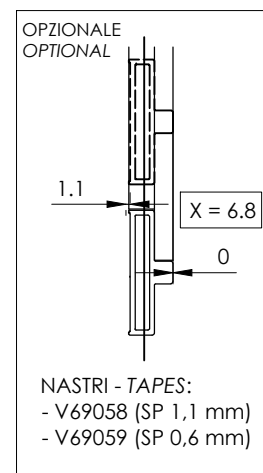
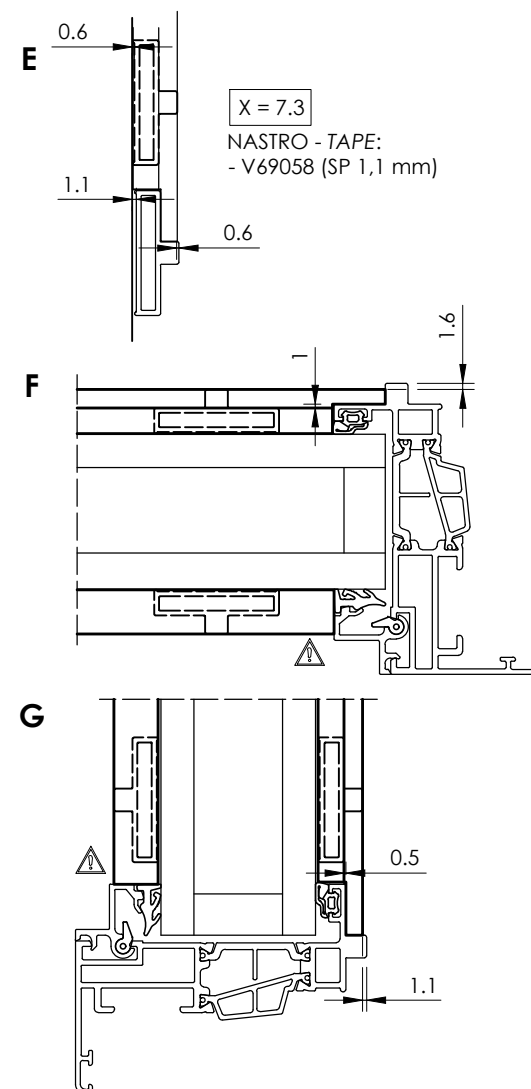


LINEA FERRO "STEEL" LINE



ATTENZIONE!
Le quote di fresatura "X" indicate valgono per la compressione nominale della guarnizione esterna V03000 pari a 3.5 mm.
A installazione del vetro avvenuta, prima di procedere con la fresatura verificare l'effettiva misura "X".

PAY ATTENTION!
The dimension "X" of the milling is valid only for the theoretical compression of the external glazing gasket V03000, equal to 3.5 mm. Once the glass has been installed, before proceeding with the milling, verify the actual measurement "X".

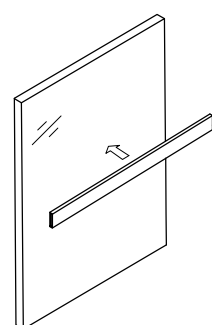


X = 7.8
NASTRO - TAPE:
- V69058 (SP 1,1 mm)
- V69059 (SP 0,6 mm)

X = 7.3
NASTRO - TAPE:
- V69058 (SP 1,1 mm)

PRESTARE ATTENZIONE ALLA MISURA MINIMA DEL FERMAVETRO
PAY ATTENTION TO THE MINIMUM MEASUREMENT OF GLAZING BEAD

PROCEDURA DI INCOLLAGGIO INGLESINA "INGLESINA" BONDING PROCEDURE



- 1 - PULIRE ACCURATAMENTE CON ALCOOL ISOPROPILICO O ACETONE ENTRAMBE LE SUPERFICI SOGGETTE AD INCOLLAGGIO DEL NASTRO (INGLESINE E VETRO).
CLEAN WITH ISOPROPYL ALCOHOL OR ACETONE BOTH THE SURFACES SUBJECT BONDING OF THE TAPE ("INGLESINE" AND GLASS PANEL).
- 2 - APPLICARE UN SOTTILE STRATO DI PRIMER T50011 (PER SUP. VERNICIATE) MEDIANTE L'USO DI UN PANNI PULITO SULL'INGLESINA.
APPLY A THIN LAYER OF PRIMER T50011 (FOR PAINTED SURFACES) THROUGH THE USE OF A CLEAN CLOTH ON THE "INGLESINA" PROFILE.
- 3 - APPLICARE IL NASTRO PERMANENTE V69058 AL PROFILO MEDIANTE L'UTILIZZO DI UNA DIMA.
APPLY THE PERMANENT TAPE V69058 TO THE PROFILE THROUGH THE USE OF A JIG.
- 4 - APPLICARE UN SOTTILE STRATO DI PRIMER T50010 (PER VETRO) MEDIANTE L'USO DI UN PANNI PULITO SUL VETRO.
APPLY A THIN LAYER OF PRIMER T50010 (FOR GLASS) THROUGH THE USE OF A CLEAN CLOTH ON THE GLASS SURFACE.
- 5 - PIEGARE UNA PARTE DI NASTRO PER POTERLO SFILARE APPENA APPOGGIATA L'INGLESINA AL VETRO.
BEND A PORTION OF THE FILM OF THE TAPE SO AS TO BE ABLE TO REMOVE IT ONCE THE "INGLESINA" IS POSED IN PLACE.

AluK (IT)

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

T: +39 045 9696611
F: +39 045 9696610
info.it@aluk.com