

C67K / C77K / C77K-CS

Finestre isolate – *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.



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
4	B	07.02.2025	Modificata nota (asola 7x35 mm) <i>Modified note (slot 7x35 mm)</i>	9.20
		18.03.2025	Aggiunta nota (sigillatura fisso) <i>Added note (fixed sealing)</i>	10.14
			Modificata indicazione di taglio della guarnizione <i>Modified gasket cut indication</i>	10.18
4	A	10.12.2024	Tolta ferramenta, vedere catalogo AK PLUS <i>Hardware removed, see AK PLUS catalogue</i>	Intero manuale <i>Complete manual</i>
3	C	04.03.2024	Inserite indicazioni per il montaggio dell'angolo paraspigolo V54013 <i>Corner protector angle V54013 assembling instructions</i>	10.17 - 10.18
3	B	04.12.2023	Modificata HI min. era 300 - diventa 250 <i>Changed HI min. was 300 - becomes 250</i>	9.23
3	A	10.06.2023	Cambiati tutti i profili d'anta <i>Changed all sash profiles</i>	Intero manuale <i>Complete manual</i>
		25.10.2023	Aggiunti profili "inglesina" (N43923/N43924) <i>Added "inglesina" profiles (N43923/N43924)</i>	10.108
2	E	07.09.2023	Corretta posizione primo foro di fissaggio braccio sull'anta <i>Corrected first hole of arm fixing position on sash</i>	10.93
2	D	09/03/23	Inserita lavorazione drenaggio anta <i>Inserted sash drainage machining</i>	9.31
		09/03/23	Correzione grafica (asola maniglia) <i>Graphic correction (handle slot)</i>	10.94 - 10.95 - 10.96
2	C	26.10.2022	Inserimento valore HI[<i>min</i>], corretta quota X, aggiunto disegno H4851I <i>HI[<i>min</i>] value inserted, X dimension corrected, drawing H4851I added</i>	9.22
		26.10.2022	Inserito (o modificato) il valore HI[<i>min</i>] <i>Inserted (or modified) HI[<i>min</i>] value</i>	9.23 - 9.24 10.20 - 10.21 - 10.64
		18.01.2023	Inserita nota per tranciante T00056 <i>Inserted note for T00056 blanking machine</i>	9.10
		18.01.2023	Inserita nota per drenaggio soglia <i>Note added for threshold drainage</i>	9.13
2	B	14.10.2022	Aggiunta pagina fissaggio N48630 <i>N48630 fixing page added</i>	10.99
2	A	-	Versioni precedenti <i>Previous version</i>	-
1	A	15.09.2017	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

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Section 9

Lavorazioni
Machinings

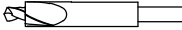
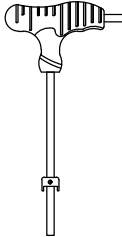
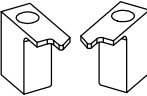
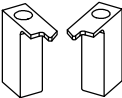
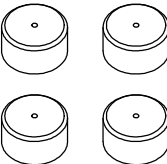
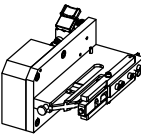
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	900032	Punta due diametri Ø16.3 - Ø9 per regoli nylon Ø16.3 - Ø9 double diameter drill for adjusting blocks C67K C77K C77K-CS	-
	900033	Chiave per regolatori nylon Key for regulation nylon C67K C77K C77K-CS	-
	902001	Cp. coltelli per spinocianfrinatura battenti Riveting-calking machine parts C67K C77K C77K-CS	-
	902003	Cp. coltelli per spinocianfrinatura battenti Riveting-calking machine parts C67K C77K C77K-CS	-
	902017	Kit spessori per spinocianfrinatura battenti Thickness sash for riveting-calking machine C67K C77K C77K-CS	-
	909302	Tranciante Punching machine C67K C77K C77K-CS	-

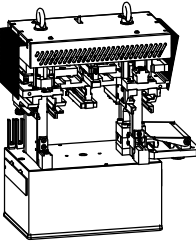
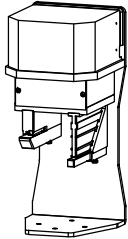
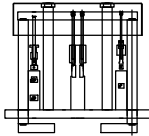
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	909307	Pinza per squadretta 710180 710180 corner joint pliers C67K C77K C77K-CS	-
	909310	Tranciante Punching machine C67K C77K C77K-CS	-
	T00001	Punzonatrice lavorazione squadrette Punching machine for corner cleats C67K C77K C77K-CS	-
	T00056	Punzonatrice Punching machine C67K C77K C77K-CS	-

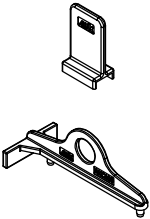
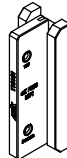
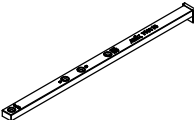
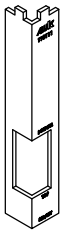
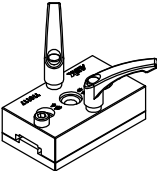
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	T10017	Dima posizionamento braccio cerniera C180 <i>Template arm position for hinge C180</i> C67K C77K C77K-CS ● ● ●	-
	T10099	Dima di foratura cerniere A/R HD <i>Drilling jig for T&T hinge</i> C67K C77K C77K-CS ● ● aK⁺	-
	T10101	Dima di foratura cerniere A/R <i>Drilling jig for T&T hinge</i> C67K C77K C77K-CS ● ● ● aK⁺	-
	T10110	Dima di foratura bracci <i>Arm drilling jig</i> C67K C77K C77K-CS ● ● ● aK⁺	-
	T10111	Dima di montaggio incontri A/R <i>T&T striker positioning jig</i> C67K C77K C77K-CS ● ● ● aK⁺	-
	T10117	Dima di foratura asta <i>Rod drilling jig</i> C67K C77K C77K-CS ● ● ● aK⁺	-

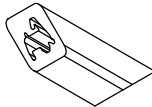
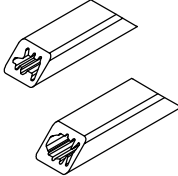
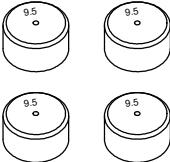
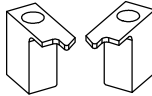
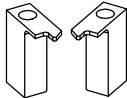
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	T10044	Dima per V02011 giunto aperto sporgere <i>Template for central gasket projecting Windows V02011</i> C67K C77K C77K-CS ●	-
	T10052	Dima per taglio giunto V02014 e battuta centrale V03025 bilico <i>Template kit for cutting V02014 and V03025 gasket</i> C67K C77K C77K-CS ●	-
	T20002	Kit spessori per spinocianfrinatura stipiti <i>Thickness frames for riveting-calking machine</i> C67K C77K C77K-CS ● ●	-
	T20003	Cp. coltelli per spinocianfrinatura stipiti <i>Riveting-calking machine parts</i> C67K C77K C77K-CS ●	-
	T20010	Cp. coltelli per spinocianfrinatura stipiti <i>Riveting-calking machine parts</i> C67K C77K C77K-CS ●	-

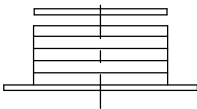
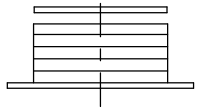
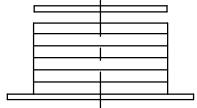
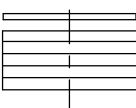
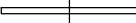
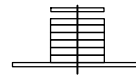
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	T40003	Gruppo fresa connessione stipite traverso <i>Milling accessory for connection fixed frame transom</i> C67K C77K C77K-CS ●	-
	T40004	Gruppo fresa connessione battente raggiato traverso <i>Milling accessory for connection rounded sash transom</i> C67K C77K C77K-CS ●	-
	T40005	Gruppo fresa connessione battente traverso <i>Milling accessory for connection sash transom</i> C67K C77K C77K-CS ●	-
	T40006	Gruppo fresa connessione stipite soglia ribassata <i>Milling accessory for connection fixed frame balcony threshold</i> C67K C77K C77K-CS ●	-
	909364	Gruppo fresa connessione aggiuntivi battente <i>Milling cutter tool</i> C67K C77K C77K-CS ● ●	-
	T40015	Gruppo fresa connessione T fisso stipite <i>Milling cutter tool for fixed T connection</i> C67K C77K C77K-CS ●	-

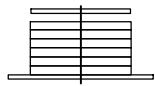
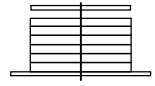
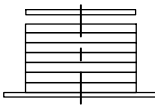
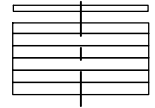
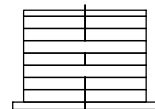
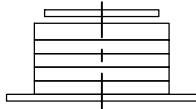
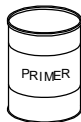
IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.
	T40016	Gruppo fresa connessione stipite traverso <i>Milling accessory for connection fixed frame transom</i> C67K C77K C77K-CS ●	-
	T40017	Gruppo fresa connessione battente raggiato traverso <i>Milling accessory for connection rounded sash transom</i> C67K C77K C77K-CS ●	-
	T40018	Gruppo fresa connessione battente traverso <i>Milling accessory for connection sash transom</i> C67K C77K C77K-CS ●	-
	T40019	Gruppo fresa connessione stipite soglia ribassata <i>Milling accessory for connection fixed frame balcony threshold</i> C67K C77K C77K-CS ● ●	-
	T40025	Gruppo fresa per lavorazione profilo TZ <i>Milling accessory for TZ profile</i> C67K C77K C77K-CS ● ●	-
	T40027	Gruppo fresa per connessione traverso tiravite sporgere <i>Milling accessory for connection T profile by screw</i> C67K C77K C77K-CS ●	-

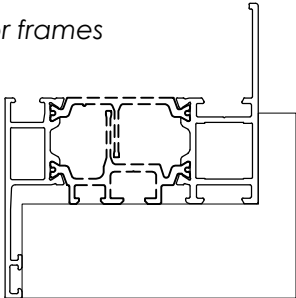
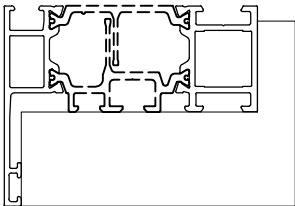


IMMAGINE IMAGE	CODICE CODE	DESCRIZIONE DESCRIPTION	U.V. U.S.						
	T50010	Promotore adesione per vetro (1000 ml) <i>Adhesion primer for glass</i>	- U.V. 6						
		<table><tr><td>C67K</td><td>C77K</td><td>C77K-CS</td></tr><tr><td>●</td><td>●</td><td></td></tr></table>	C67K	C77K	C77K-CS	●	●		
C67K	C77K	C77K-CS							
●	●								
	T50011	Promotore adesione per superfici verniciate (250 ml) <i>Adhesion primer for painted surfaces.</i>	- U.V. 4						
		<table><tr><td>C67K</td><td>C77K</td><td>C77K-CS</td></tr><tr><td>●</td><td>●</td><td></td></tr></table>	C67K	C77K	C77K-CS	●	●		
C67K	C77K	C77K-CS							
●	●								
	T90020	Forcella per lavorazione profilo N48630 <i>Fork for N48630 machining profile</i>	-						
		<table><tr><td>C67K</td><td>C77K</td><td>C77K-CS</td></tr><tr><td>●</td><td></td><td></td></tr></table>	C67K	C77K	C77K-CS	●			
C67K	C77K	C77K-CS							
●									

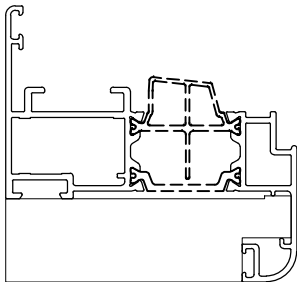
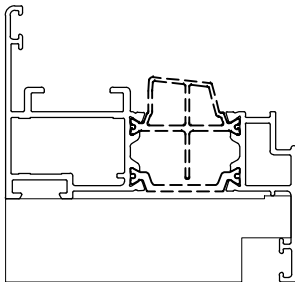
**CONTROSAGOME DA UTILIZZARE PER IL TAGLIO PROFILI
COUNTER-TEMPLATES TO BE USED FOR PROFILE CUTTING**

(Controsagome NON fornite da Aluk)
(Counter templates NOT supplied by Aluk)

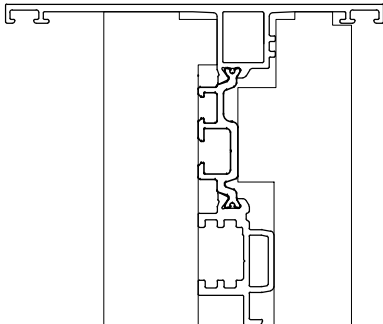
Possibili controsagome telai
Possible counter templates for frames



Possibili controsagome battenti
Possible counter templates for sash



Possibili controsagome profili speciali
Possible special profiles counter templates

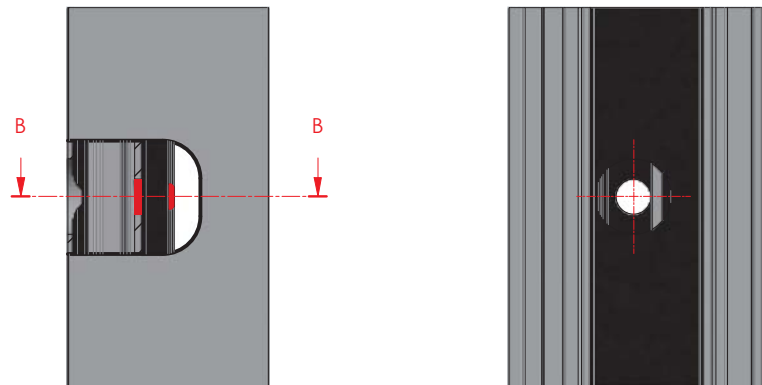


Per il taglio delle barre, si raccomanda l'impiego di apposite controsagome in TEFLON adeguatamente conformate alla sezione del profilo e al tipo di troncatrice utilizzata

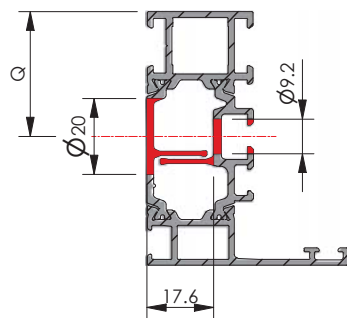
To cut the bars, we recommend the use of special TEFLON counter-templates suitably conformed to the section of the profile and to the type of miter saw used.

C67K	C77K	C77K-CS
●	●	●

LAVORAZIONE PER REGOLATORI V50002
MACHINING FOR V50002 ADJUSTING BLOCK

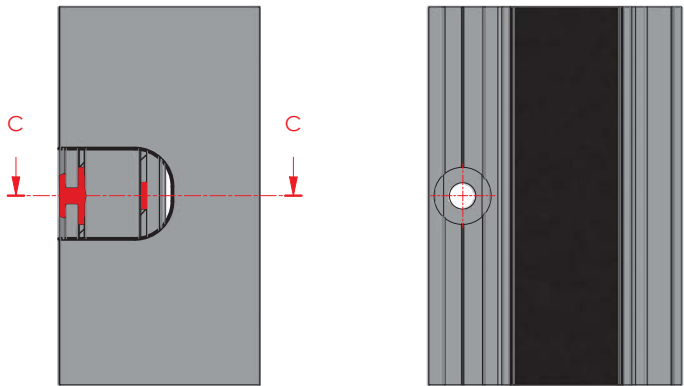


U20000 (1 : 2)

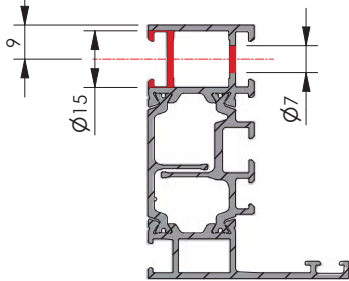


PROFILI - PROFILES		
C67K Q=33 mm	C77K Q=38 mm	C77K-CS Q=38 mm
U20000	U28002	U28001
U20002	U28022	-
U20003	U28023	U28021
U20020	U28024	-
U20040	U28042	-
U20041	U28043	-

LAVORAZIONE PER REGOLATORI V50003
MACHINING FOR V50003 ADJUSTING BLOCK



U20000 (1 : 2)



PROFILI - PROFILES		
C67K	C77K	C77K-CS
U20000	U28002	U28001
U20001	U28003	-
U20040	U28042	-
U20060	U28060	-
U20061	U28061	-
U20605	U28606	-
U20006	-	-
U20021	-	-

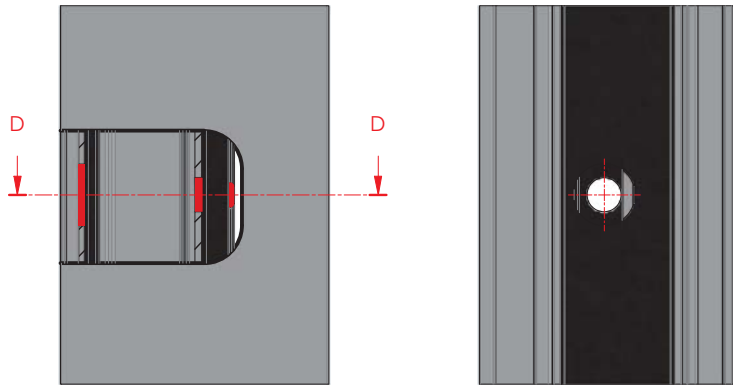
PER LA FORATURA DEL PROFILO UTILIZZARE PUNTA SPECIALE
(A DUE DIAMETRI Ø7 - Ø15, NON FORNITA DA ALUK)

FOR SECTION DRILLING USE SPECIAL DRILL (WITH DOUBLE
DIAMETER Ø7 - Ø15, NOT SUPPLIED BY ALUK)

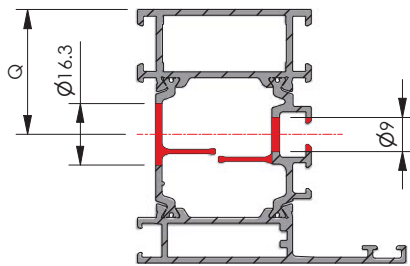
FORARE IN ALTEZZA E IN LARGHEZZA X≤800 mm,
CON PARTENZA A=200 mm

DRILLING IN HEIGHT AND WIDTH X≤800 mm,
STARTING A=200 mm

LAVORAZIONE PER REGOLATORI V50004
MACHINING FOR V50004 ADJUSTING BLOCK



U20001 (1 : 2)



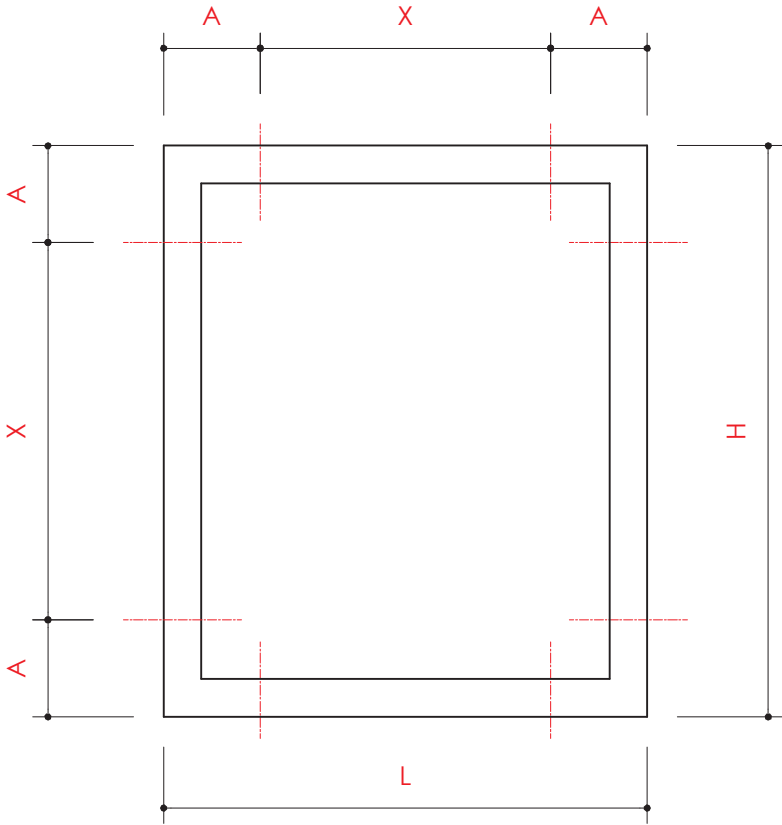
PROFILI - PROFILES	
C67K Q=33 mm	C77K Q=38 mm
U20001	U28003
U20004	U28025
U20005	U28026
U20042	U28044
U20060	U28060
U20061	U28061
U20605	U28606

PER LA FORATURA DEL PROFILO UTILIZZARE PUNTA
SPECIALE (A DUE DIAMETRI Ø9 - Ø16.3) ART. 900032

FOR SECTION DRILLING USE SPECIAL DRILL (WITH DOUBLE
DIAMETER Ø9 - Ø16.3) ART. 900032

PER L'INSERIMENTO DEL REGOLATORE UTILIZZARE LA
CHIAVE ART. 900033

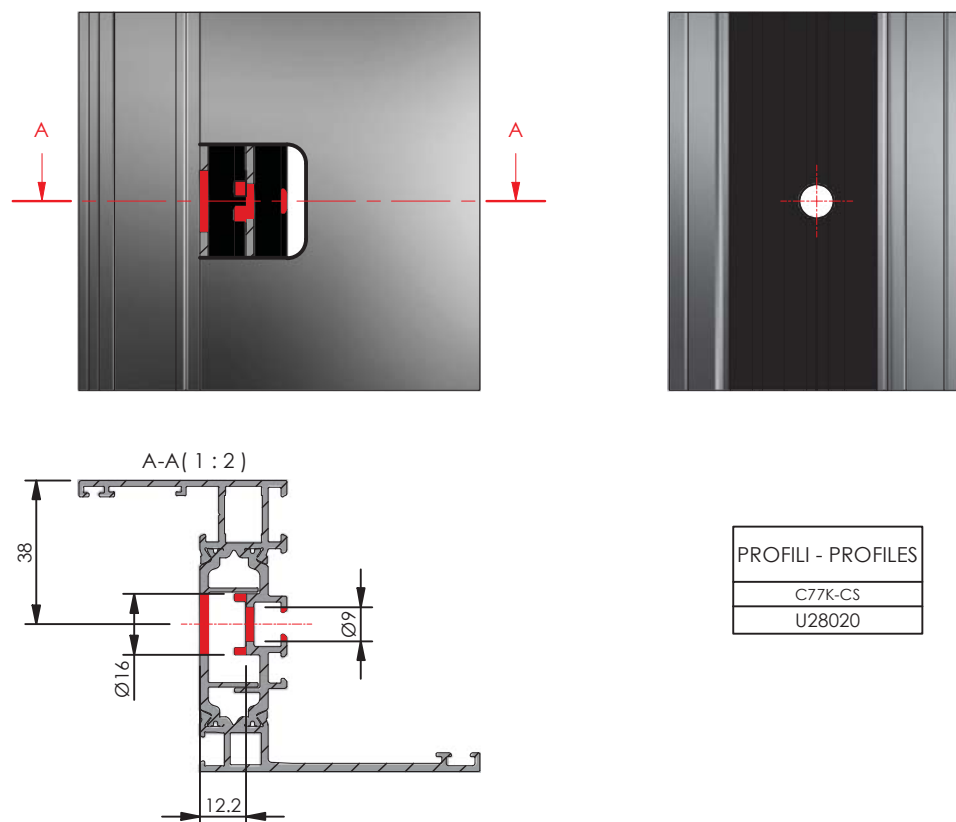
TO INSERT THE ADJUSTING BLOCKS USE TOOL ART. 900033



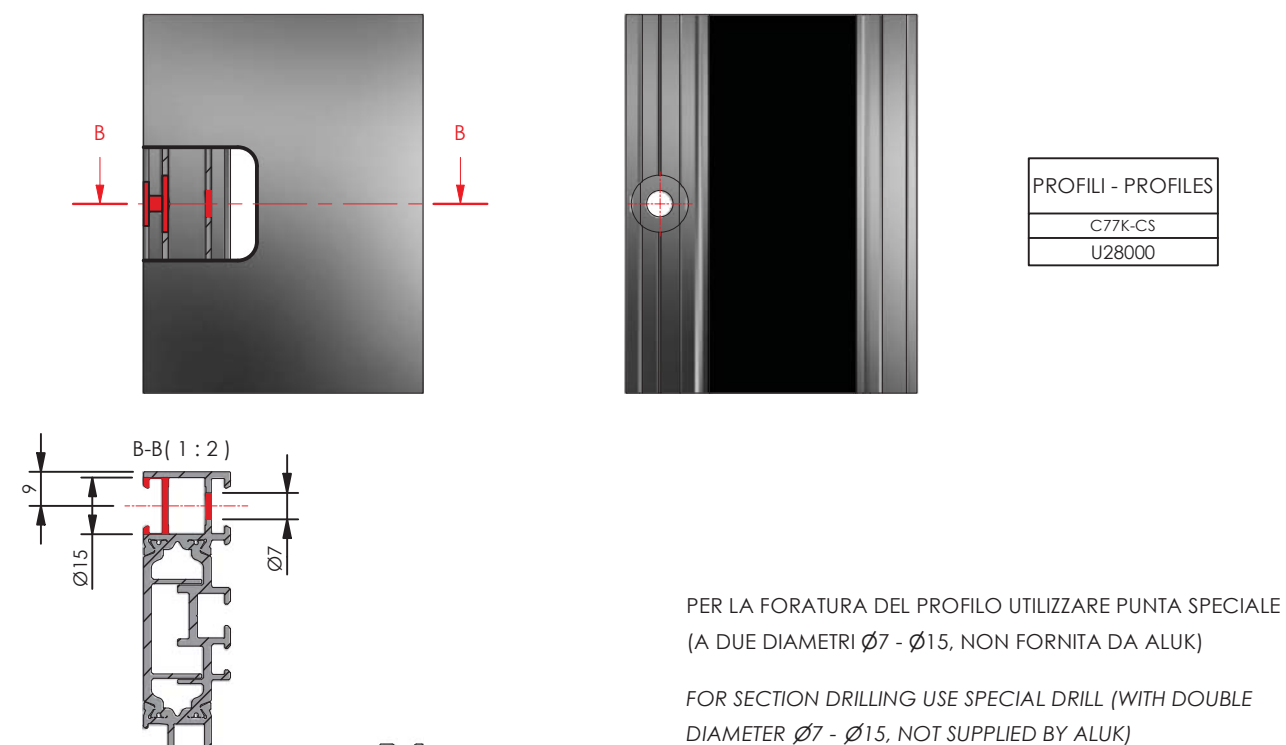
LAVORAZIONE PER MONTAGGIO REGOLATORI MACHINING FOR ADJUSTING BLOCKS

C67K	C77K	C77K-CS
		●

LAVORAZIONE PER REGOLATORI V50026 MACHINING FOR V50026 ADJUSTING BLOCK



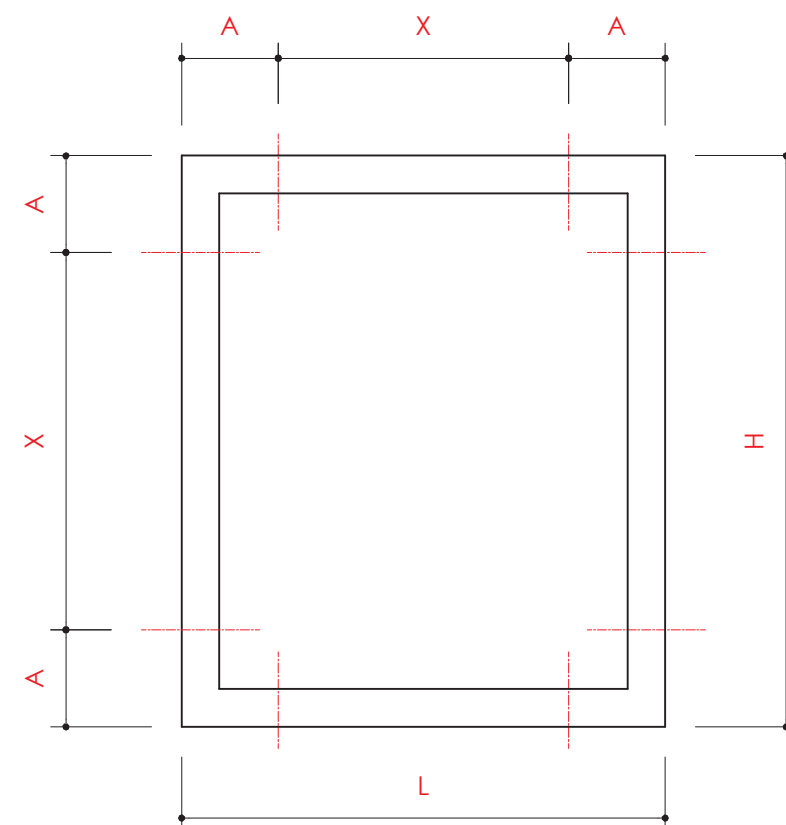
LAVORAZIONE PER REGOLATORI V50025 MACHINING FOR V50025 ADJUSTING BLOCK



PROFI - PROFILES
C77K-CS
U28000

FORARE IN ALTEZZA E IN LARGHEZZA $X \leq 800$ mm,
CON PARTENZA $A=200$ mm

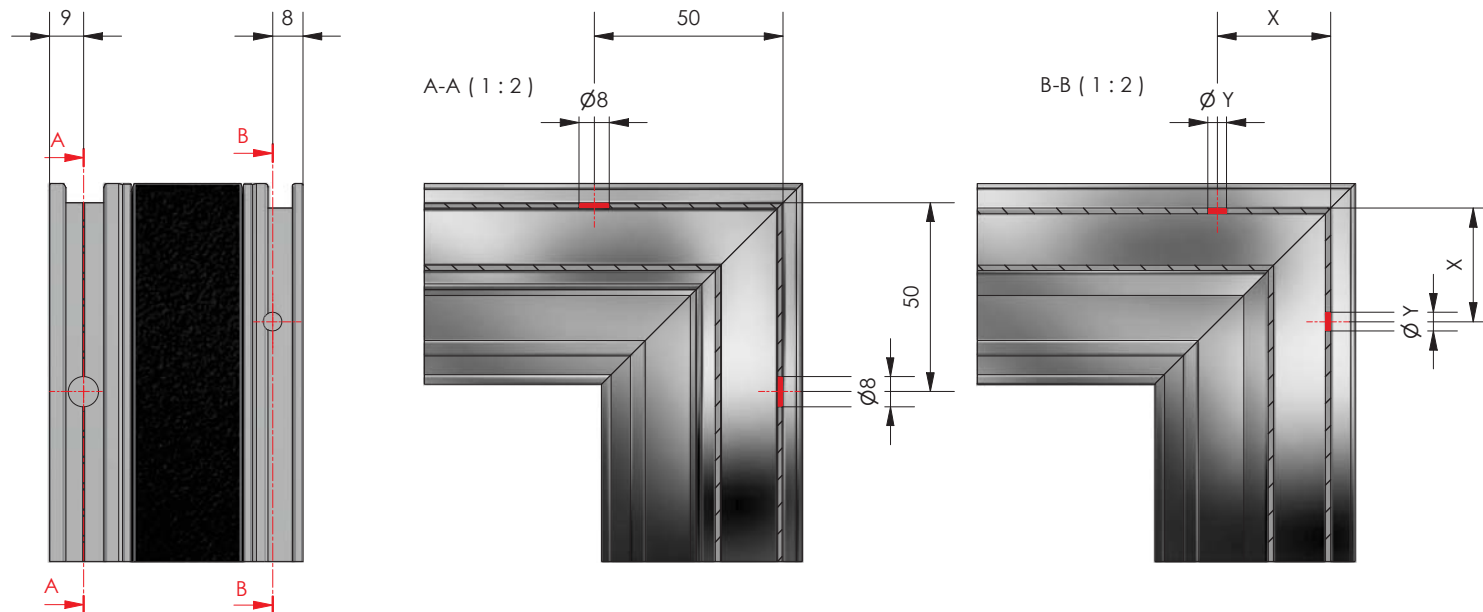
DRILLING IN HEIGHT AND WIDTH $X \leq 800$ mm,
STARTING $A=200$ mm



LAVORAZIONE PER SQUADRETTE STIPITE FIXED FRAME CORNER JOINTS MACHININGS

C67K	C77K	C77K-CS
●	●	●

SQUADRETTE A SPINARE/A VITE CORNER JOINT TO BE RIVETED/SCREWED



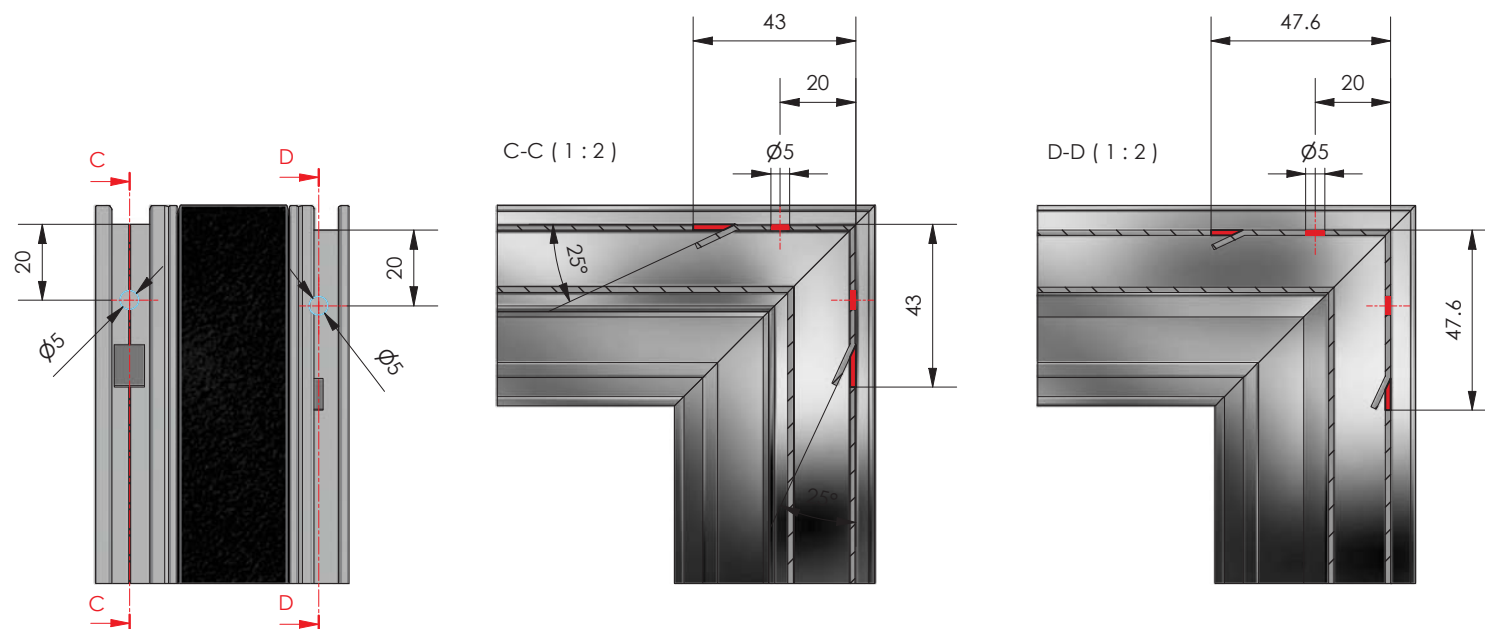
LAVORAZIONE PER SQUADRETTE INTERNE ESEGUIBILE CON
TRANCIANTE T00001

MACHINING FOR INTERNAL CORNER JOINTS EXECUTABLE WITH
T00001 BLANCKING MACHINE

LAVORAZIONE PER SQUADRETTE ESTERNE ESEGUIBILE CON
TRANCIANTE 909310

MACHINING FOR EXTERNAL CORNER JOINTS EXECUTABLE WITH
909310 BLANCKING MACHINE

SQUADRETTE A CIANFRINARE CORNER JOINT TO BE CALKED



NOTA: LE QUOTE DI CIANFRINATURA 43 E 47.6 mm
SONO INDICATIVE

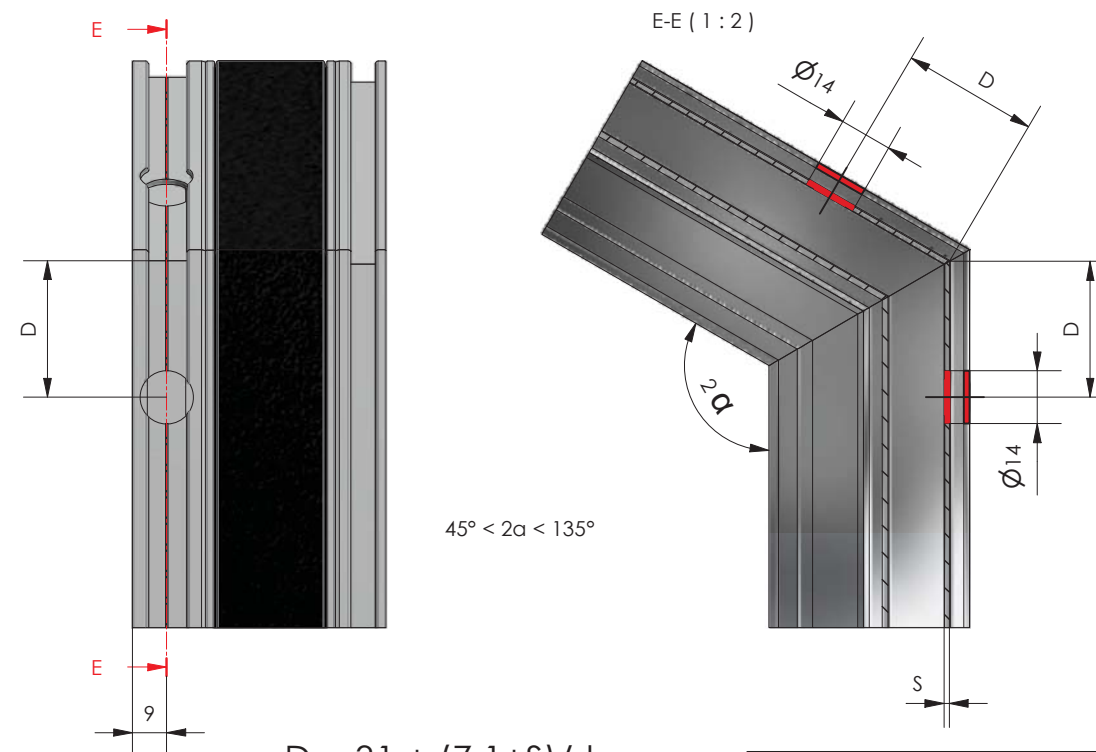
CALKING DIMENSIONS 43 AND 47.6 mm COULD
CHANGE ACCORDING TO SECTION TOLLERANCES

FORI PER APPLICAZIONE COLLA DA ESEGUIRE A MANO

HOLES FOR GLUE APPLICATION TO BE MADE BY HAND

SQUADRETTE AD ANGOLO VARIABILE VARIABLE ANGLE CORNER JOINT

C67K	C77K	C77K-CS
●	●	



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

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.

SQUADRETTE - CORNER JOINTS		
C67K	C77K	α VARIABILE - VARIABLE
U20000	U28002	# V42014
U20001	U28003	-
U20002	U28022	# V42014
U20003	U28023	# V42014
U20004	U28025	-
U20005	U28026	-
U20020	U28024	# V42014
U20040	U28042	# V42014
U20041	U28043	# V42014
U20042	U28044	-

SQUADRETTE - CORNER JOINTS				
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL	X - Y
U20000	U28002	V43000	710411	30 - 5
U20001	U28003	V43001	710410	30 - 5
U20002	U28022	V43000	710411	30 - 5
U20003	U28023	V43000	710411	30 - 5
U20004	U28025	V43001	710410	30 - 5
U20005	U28026	V43001	710410	30 - 5
U20020	U28024	V43000	# 710411	30 - 5
U20040	U28042	V43000	710411	30 - 5
U20041	U28043	V43000	710411	30 - 5
U20042	U28044	V43001	710022	30 - 5
U20006	-	V43000	710411	30 - 5
U20021	-	V43000	710411	30 - 5
U20634	-	V43000	710411	30 - 5

LAVORAZIONE DA ESEGUIRE A MANO
MACHINING TO BE DONE BY HAND

SQUADRETTE - CORNER JOINTS				
C77K-CS	INTERNA - INTERNAL	ESTERNA - EXTERNAL	ESTERNA SPINARE - EXTERNAL RIVETED	X - Y
U28001	V43000	710103	# V43011	33 - 3
U28021	V43000	710103	# V43011	33 - 3
U28027	V43000	710103	# V43011	33 - 3

710103 - SQUADRETTA ESTERNA SOLO A CIANFRINARE
710103 - EXTERNAL CORNER JOINT TO BE CALKED ONLY

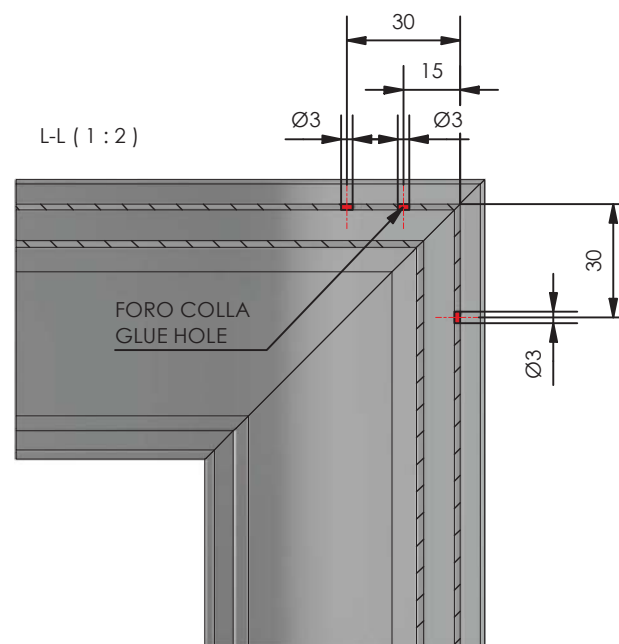
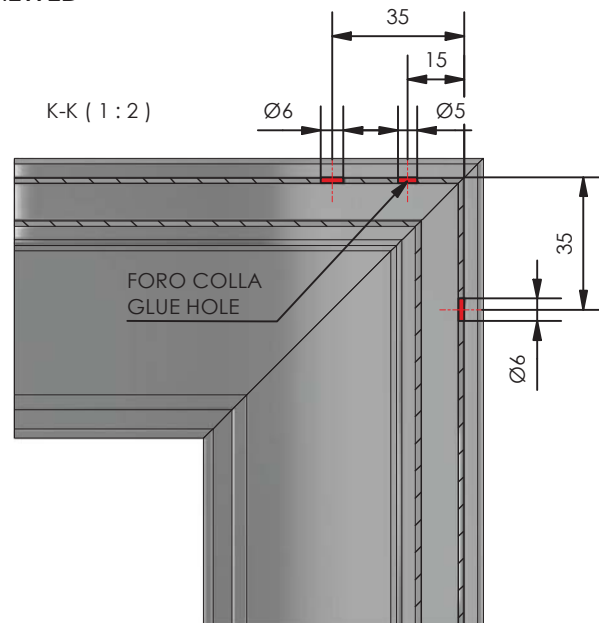
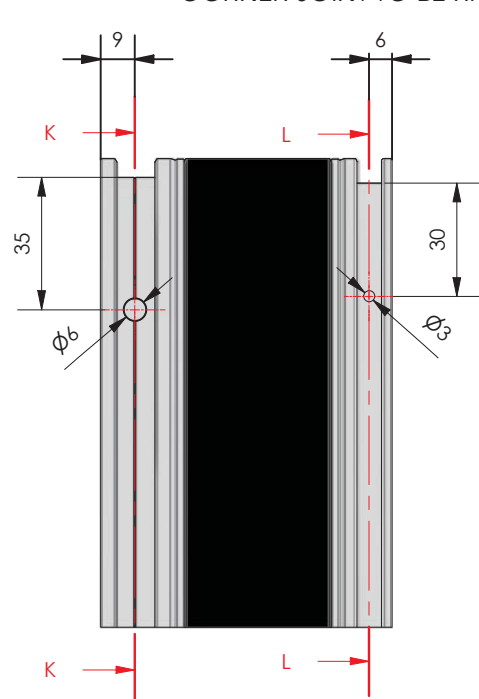
LAVORAZIONE PER SQUADRETTE STIPITE

FIXED FRAME CORNER JOINTS MACHINING

C67K	C77K	C77K-CS
		●

SQUADRETTE A SPINARE/A VITE

CORNER JOINT TO BE RIVETED/SCREWED

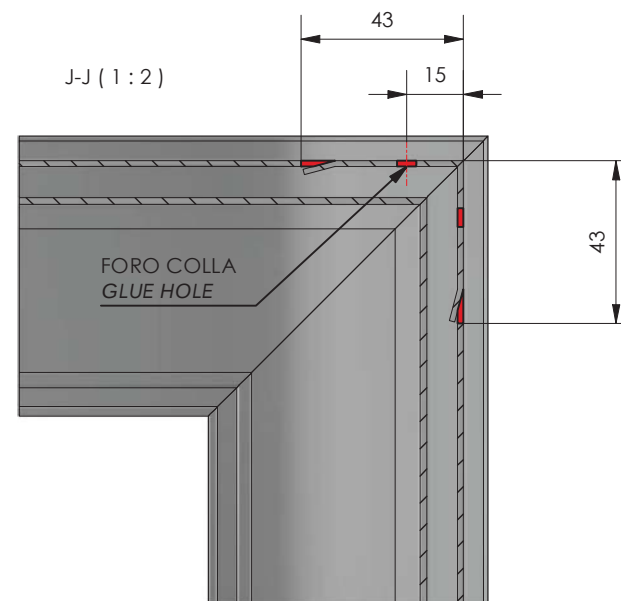
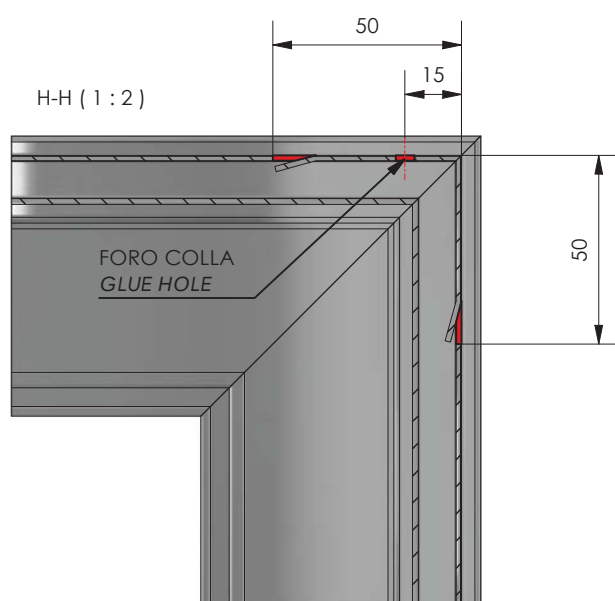
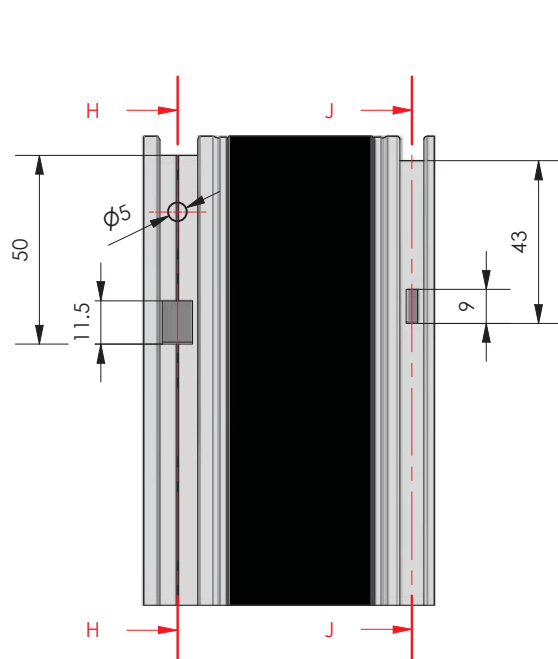


LAVORAZIONI ESEGUIBILI CON TRACIANTE T00056

MACHINING EXECUTABLE WITH T00056 BLANKING MACHINE

SQUADRETTE A CIANFRINARE

CORNER JOINT TO BE CALKED



NOTA: LE QUOTE DI CIANFRINATURA 43 E 50 mm SONO INDICATIVE

CALKING DIMENSIONS 43 AND 50 mm COULD CHANGE ACCORDING TO SECTION TOLLERANCES

FORI PER APPLICAZIONE COLLA DA ESEGUIRE A MANO

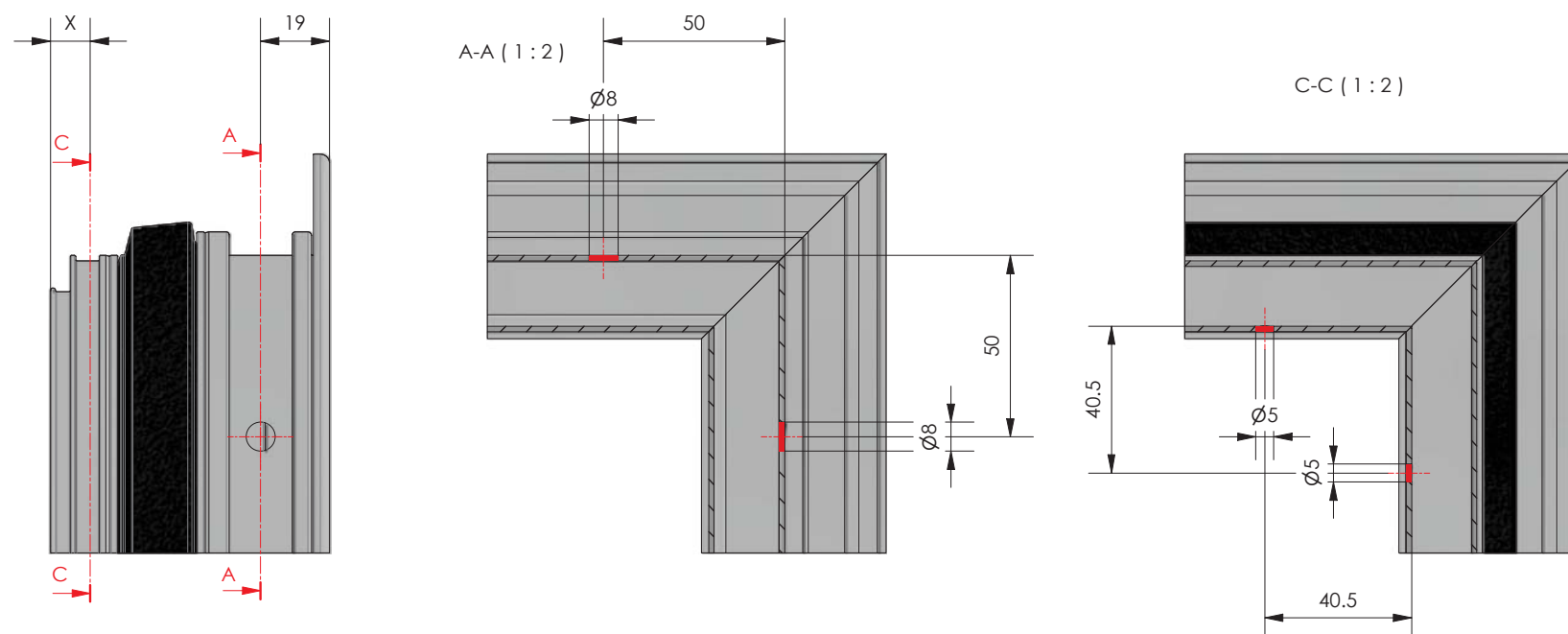
HOLES FOR GLUE APPLICATION TO BE MADE BY HAND

SQUADRETTE - CORNER JOINTS		
C77K-CS	INTERNA - INTERNAL	ESTERNA - EXTERNAL
U28000	V43013	V43014
U28020	V43013	V43014

> LAVORAZIONE PER SQUADRETTE BATTENTI
 MACHINING CORNER JOINTS FOR WINGS

C67K	C77K	C77K-CS
●	●	

SQUADRETTE A SPINARE/A VITE
 CORNER JOINT TO BE RIVETED/SCREWED

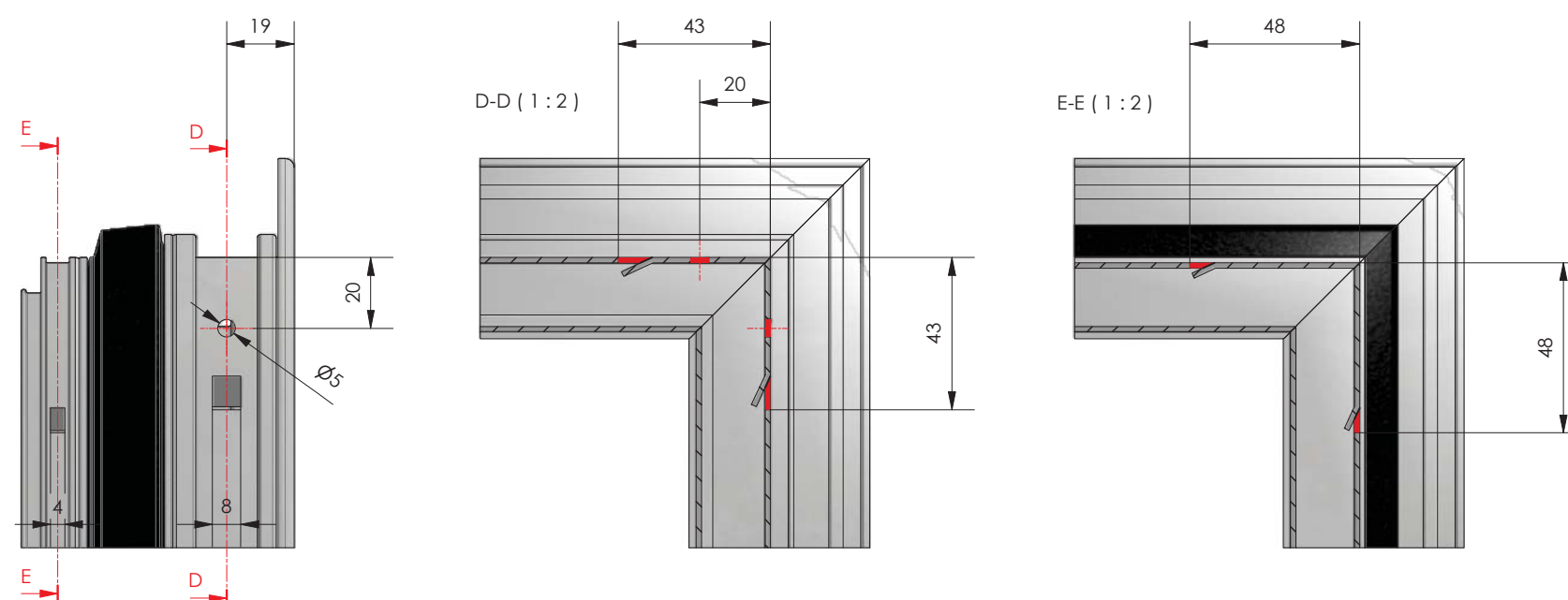


PER ESEGUIRE QUESTE LAVORAZIONI UTILIZZARE TRACIANTE ART. 909310
 TO EXECUTE THESE DRILLINGS USE ART. 909310 BLANKING MACHINE

PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE TRACIANTE ART. 909302 O T00001
 # TO EXECUTE THIS DRILLING USE ART. 909302 BLANKING MACHINE OR T00001

SQUADRETTE - CORNER JOINTS				
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL	QUOTA X - DIMENSION X
U20133 (U20120)	U28129 (U28120)	710408	710023	11
U20135 (U20122)	U28131 (U28121)	710408	710023	11
U20137 (U20124)	U28133 (U28122)	710408	710023	10.5
U20501	U28501	# 710408	710023	11

SQUADRETTE A CIANFRINARE
 CORNER JOINTS TO BE CALKED



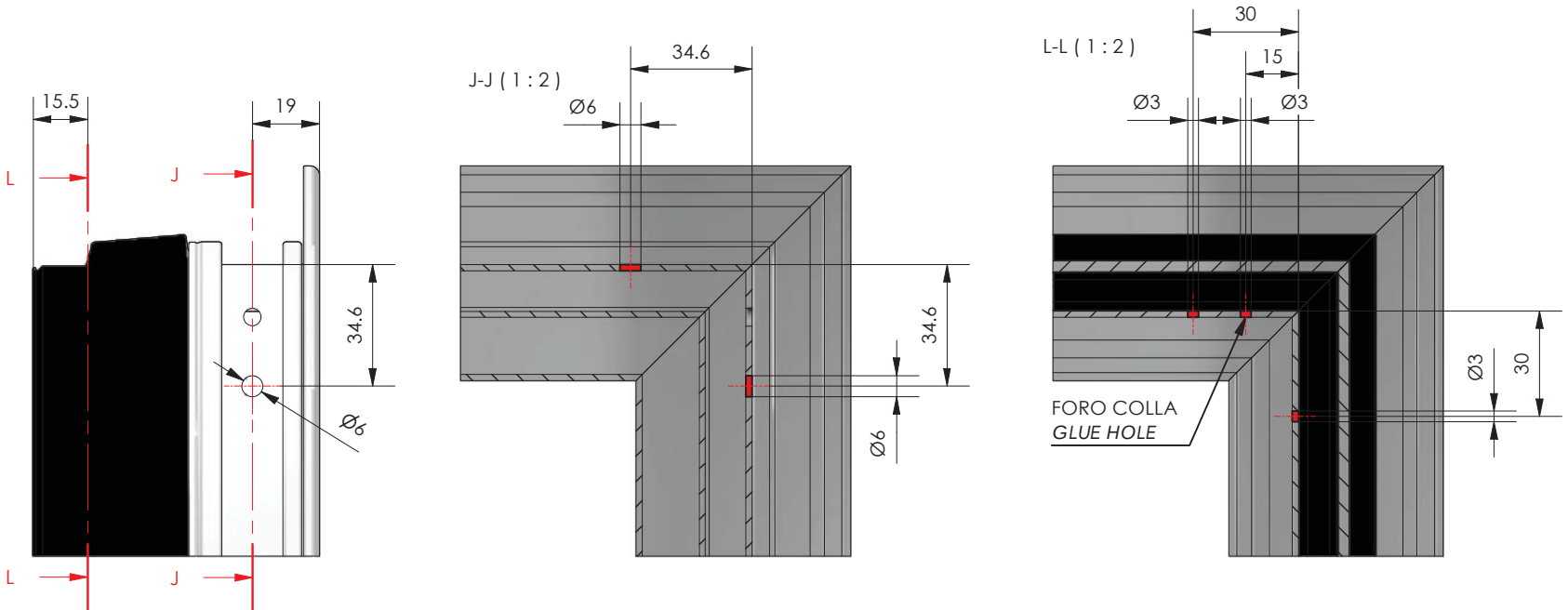
NOTA: LE QUOTE DI CIANFRINATURA 43 E 48 mm SONO INDICATIVE

CALKING DIMENSIONS 43 AND 48 mm COULD CHANGE
 ACCORDING TO SECTION TOLLERANCES

LAVORAZIONE PER SQUADRETTE BATTENTI
MACHINING CORNER JOINTS FOR WINGS

C67K	C77K	C77K-CS
		●

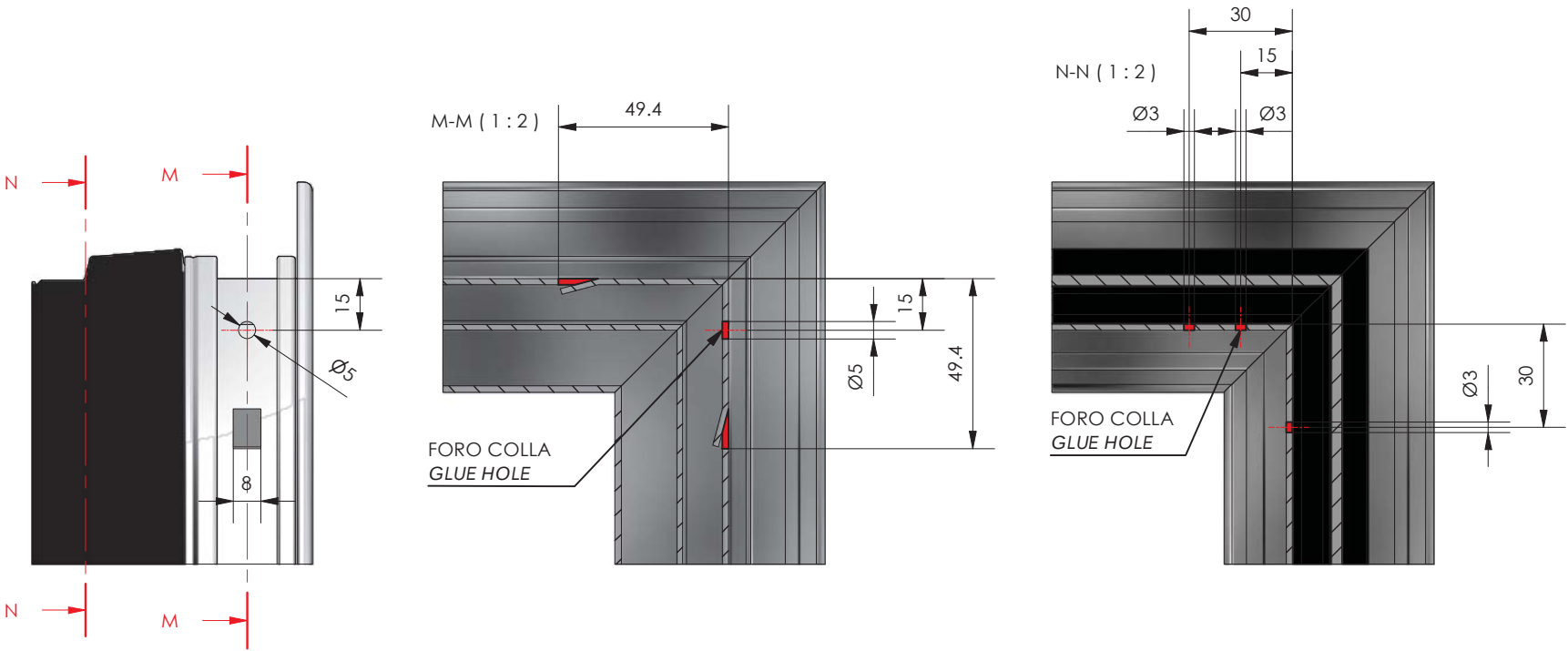
SQUADRETTE A SPINARE/A VITE
CORNER JOINT TO BE RIVETED/SCREWED



PER ESEGUIRE QUESTE LAVORAZIONI UTILIZZARE TRACIANTE ART. T00056
TO EXECUTE THESE DRILLINGS USE ART. T00056 BLANKING MACHINE

SQUADRETTE - CORNER JOINTS		
C77K-CS	INTERNA - INTERNAL	ESTERNA - EXTERNAL
U28160	V43015	V43016
U28161	V43015	V43016
U28162	V43015	V43016
U28163	V43015	V43016

SQUADRETTE A CIANFRINARE
CORNER JOINTS TO BE CALKED

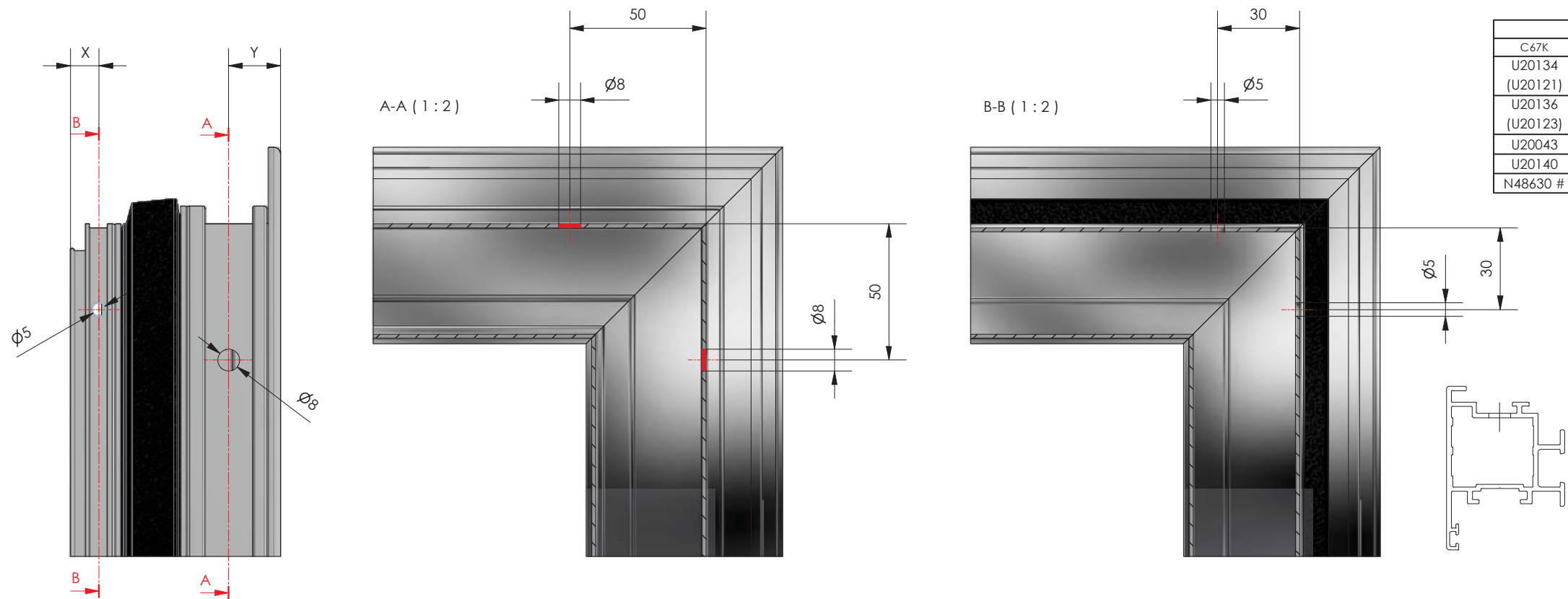


NOTA: LA QUOTE DI CIANFRINATURA 49.4 mm E' INDICATIVA
CALKING DIMENSION 49.4 mm COULD CHANGE ACCORDING TO
SECTION TOLLERANCES

LAVORAZIONI PER SQUADRETTE BATTENTI MACHININGS CORNER JOINTS FOR WING

C67K	C77K	C77K-CS
●	●	

SQUADRETTE BATTENTI MAGGIORATI, SPORGERE E BILICO CORNER JOINTS FOR OVERSIZE WINGS, PROJECTING WINDOWS AND PIVOTING WINDOS



SQUADRETTE - CORNER JOINTS				
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL	X - Y
U20134 (U20121)	U28130 (U28123)	710404	710024	10.5 - 19
U20136 (U20123)	U28132 (U28124)	710404	710024	10.5 - 19
U20043	-	710407	710022	7.5 - 13
U20140	-	710404	710022	7.5 - 19.5
N48630 #	-	710404	-	19.5

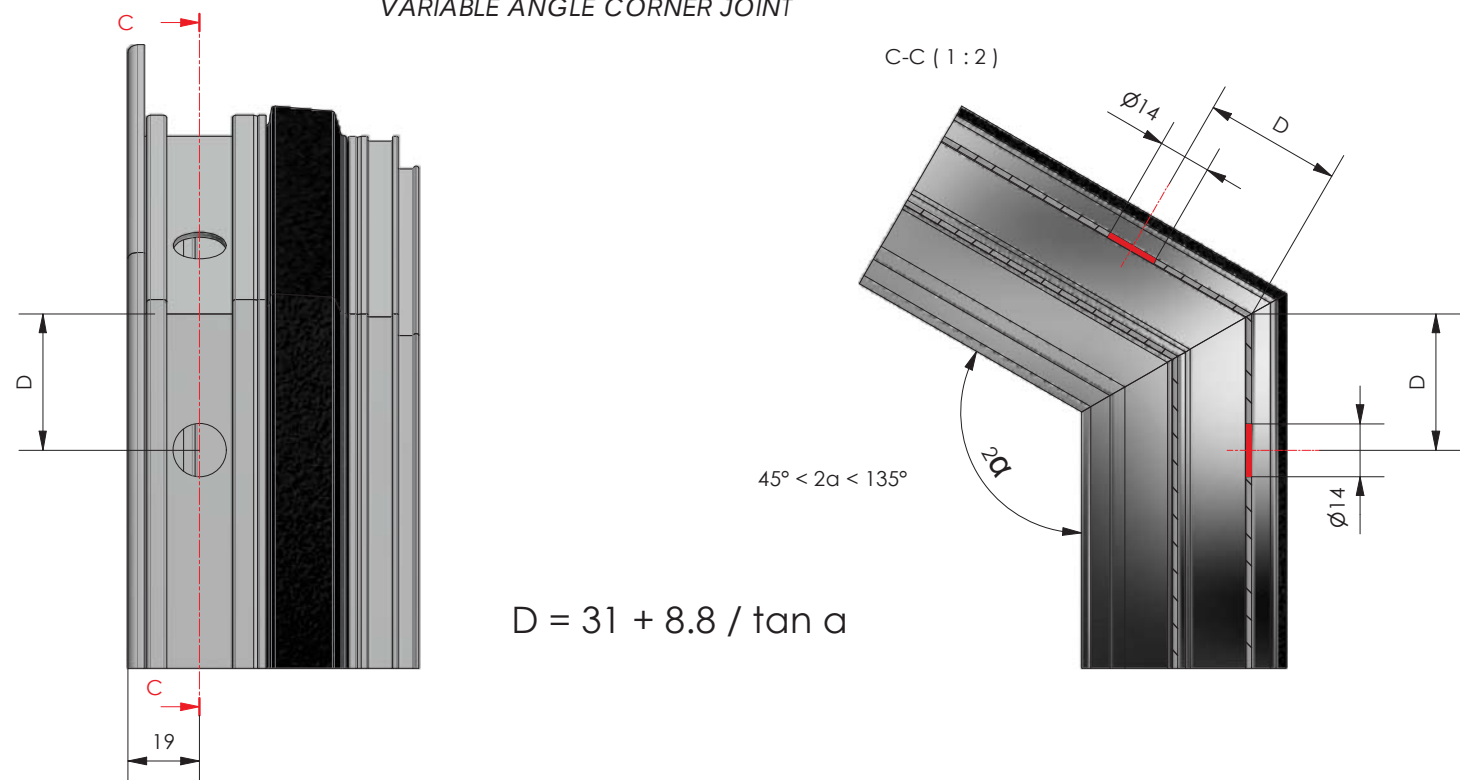
PER ESEGUIRE QUESTE LAVORAZIONI
UTILIZZARE TRANCIANTE ART. 909310

TO EXECUTE THESE MACHININGS USE ART.
909310 BLANCHING MACHINE

PER ESEGUIRE QUESTA LAVORAZIONE
UTILIZZARE IN AGGIUNTA LA FORCELLA T90020

TO EXECUTE THIS MACHINING USE IN
ADDITION THE ART. T90020

SQUADRETTE AD ANGOLO VARIABILE VARIABLE ANGLE CORNER JOINT



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

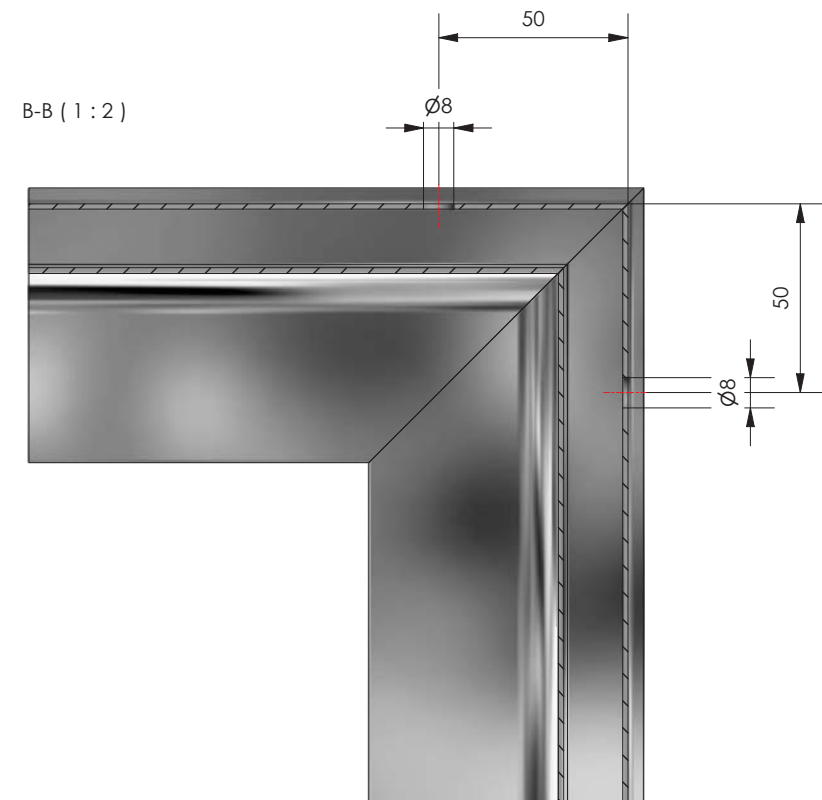
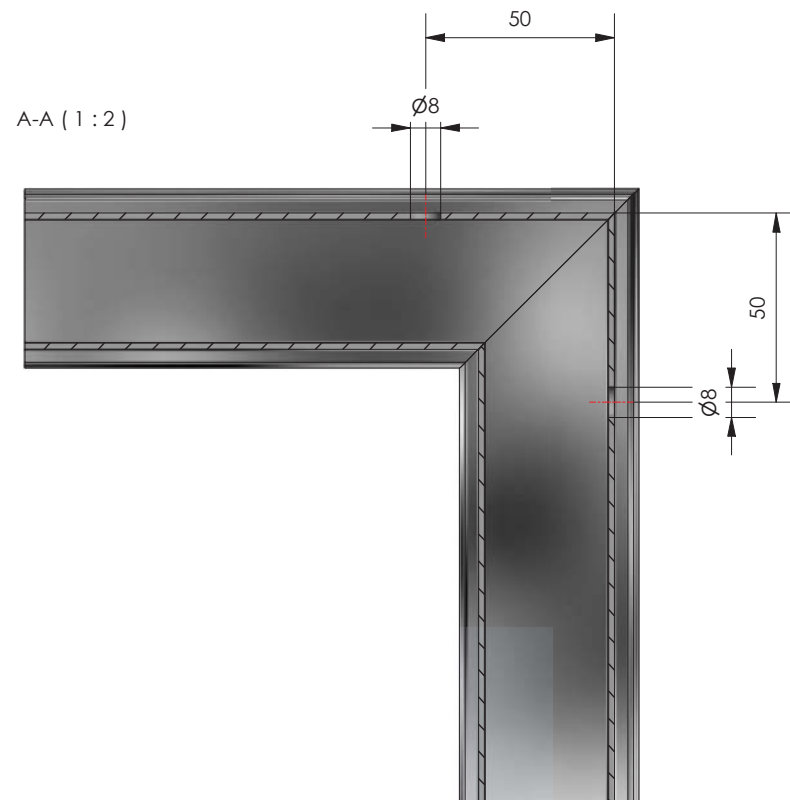
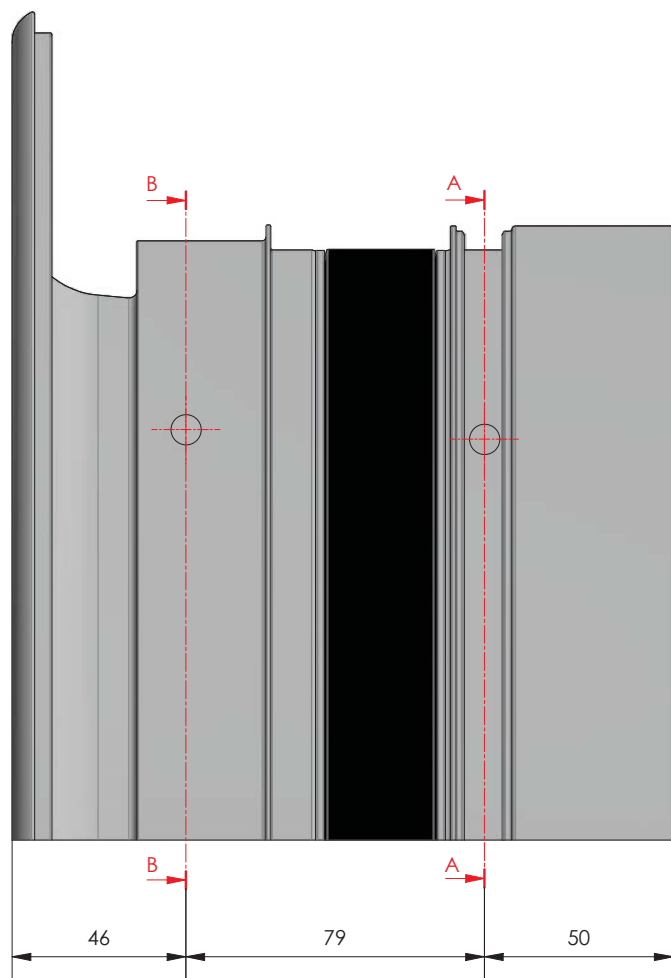
SQUADRETTE - CORNER JOINTS		
C67K	C77K	VARIABILE - VARIABLE
U20133 (U20120)	U28129 (U28120)	710121
U20135 (U20122)	U28131 (U28121)	710121
U20137 (U20124)	U28133 (U28122)	710121

PRESTARE ATTENZIONE AGLI ANGOLI ACUTI: "D" DOVRA' ESSERE AUMENTATA FINO A 3 mm
SI CONSIGLIA DI ASSEMBLARE UN ANGOLO DI PROVA

BE CAREFLU WITH ACUTE ANGLES: "D" SHALL BE INCREASED UP TO 3 mm; IT IS
RECOMMENDED TO ASSEMBLE A SPECIMEN CORNER.

LAVORAZIONI SQUADRETTE PER PROFILI IMBOTTITI
EXTENSIONS CORNER JOINT MACHINING DIAGRAM

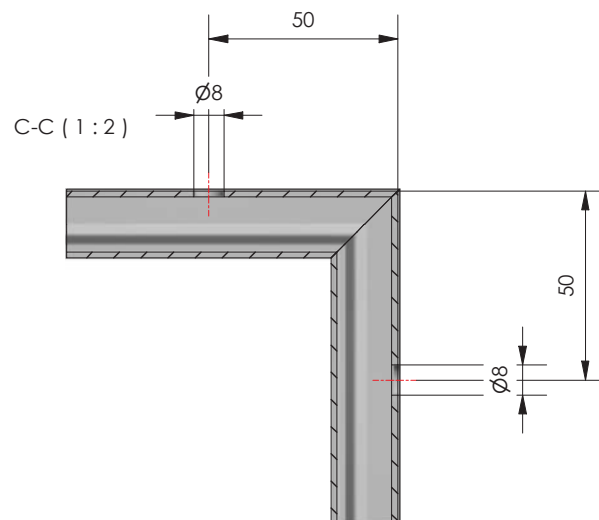
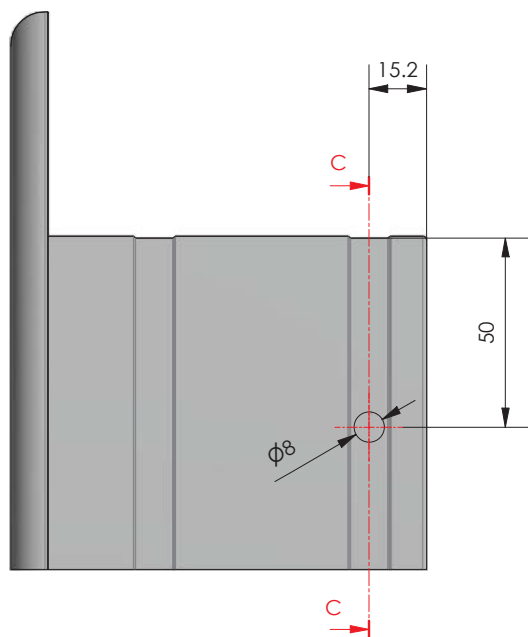
C67K	C77K	C77K-CS
●	●	



LAVORAZIONE PER SQUADRETTE INTERNE ESEGUIBILE CON
TRACIANTE T0001
LAVORAZIONE PER SQUADRETTE ESTERNE ESEGUIBILE CON
TRACIANTE 909302

MACHINING FOT INTERNAL CORNER JOINTS EXECUTABLE
WITH T0001 BLANKING MACHINE
MACHINING FOT EXTERNAL CORNER JOINTS EXECUTABLE
WITH 909302 BLANKING MACHINE

SQUADRETTE - CORNER JOINTS				
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL	ALLINEAMENTO - ALIGNMENT
U20060	U28060	V43001	# 710407	710180
U20061	U28061	V43001	# 710407	710180



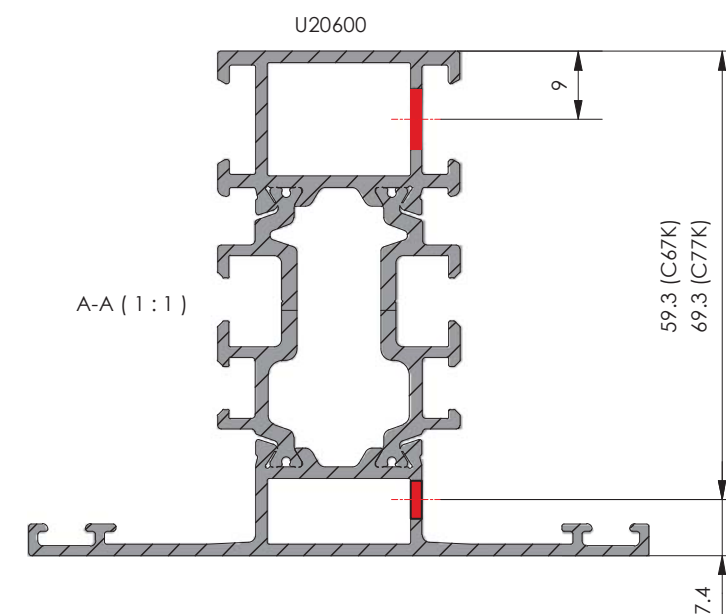
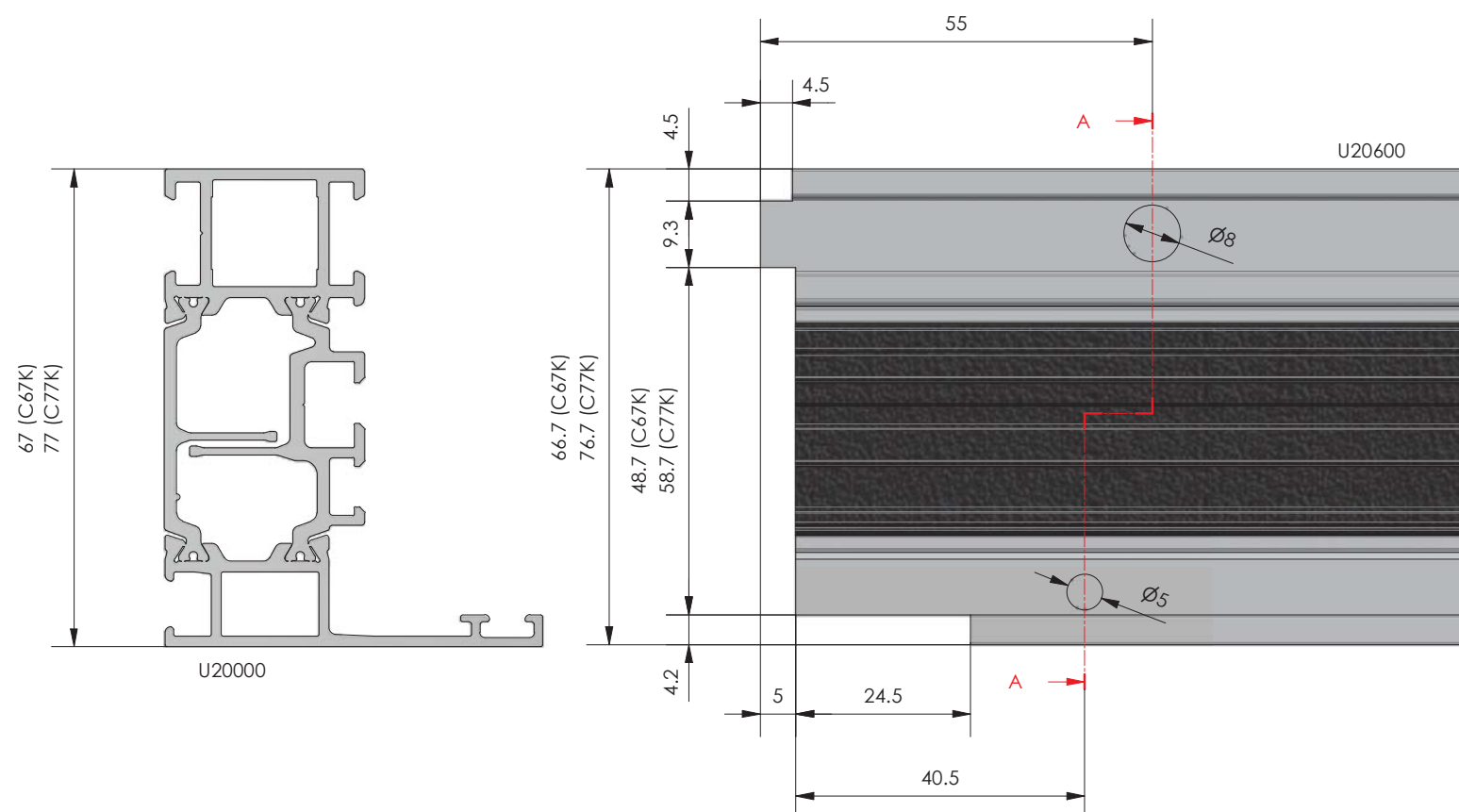
PER ESEGUIRE QUESTE LAVORAZIONI UTILIZZARE
TRACIANTE ART. 909302 E PINZA ART. 909307

TO EXECUTE THESE MACHININGS USE ART. 909302
BLANKING MACHINE AND ART. 909307 PLIERS

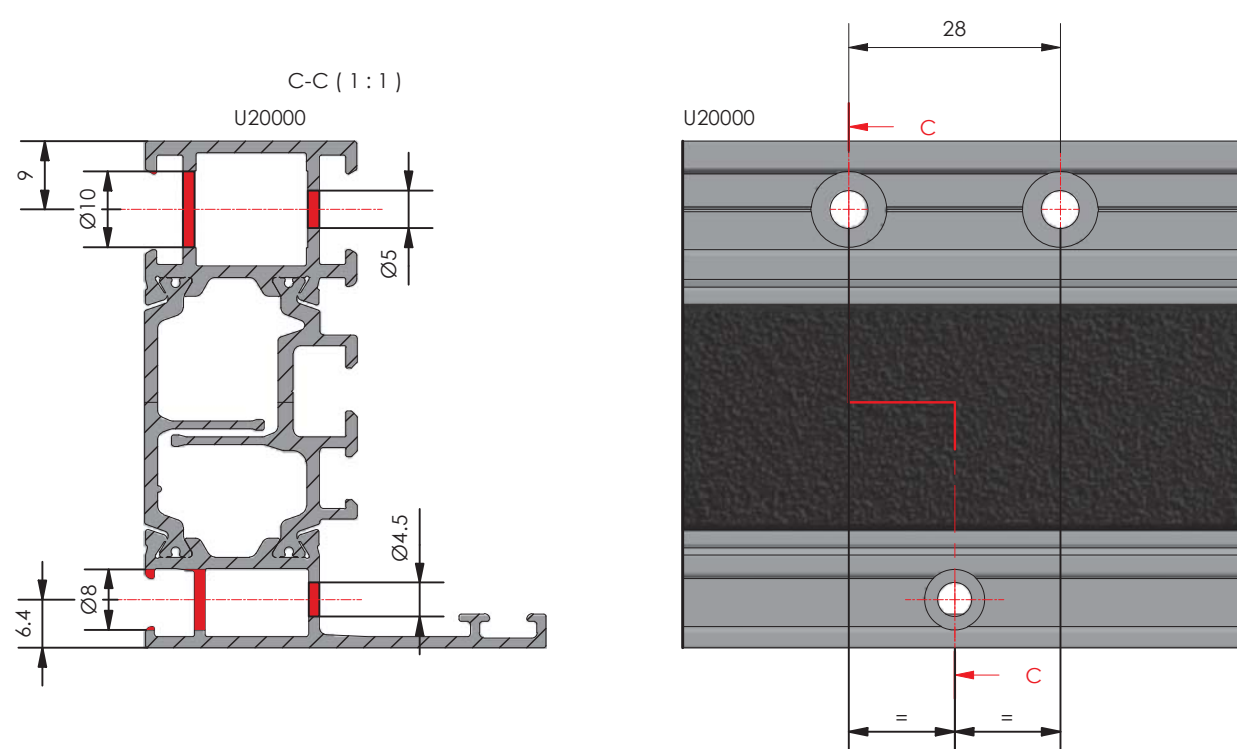
SQUADRETTE - CORNER JOINTS		
PROFILI - PROFILES	INTERNA - INTERNAL	ALLINEAMENTO - ALIGNMENT
K702	710407	710180
K703	710407	710180
K704	710407	710180
K705	710407	710180
K706	710407	710180
K707	710407	-

➤ LAVORAZIONE PER CONNESSIONE TRAVERSO STIPITE
FIXED FRAME TRANSOM CONNECTION DIAGRAM

C67K	C77K	C77K-CS
●	●	



PER IL FORO INTERNO USARE TRACIANTE ART. T00001
PER IL FORO ESTERNO USARE TRACIANTE ART. 909310
TO EXECUTE INTERNAL HOLE, USE ART. T00001
TO EXECUTE EXTERNAL HOLE, USE ART. 909310



CAVALLOTTI - T JOINTS		
C67K	KIT	GUARNIZIONE - GASKET
U20000	V47000	V55028
U20001	V47002	V55026
U20002	V47000	V55028
U20003	V47000	V55028
U20004	V47002	V55026
U20005	V47002	V55026
U20006	V47000	V55028
U20020 #	V47000	V55028
U20021	V47000	V55028
U20040	V47000	V55028
U20041	V47000	V55028
U20042	V47002	V55026
U20600	V47001	V55028
U20601	V47002	V55026
U20602	*	V55026
U20603	V47005 x 2pz + 710219	V55028 x 2 pz
U20630	V47005 x 2pz + 710219	V55028 x 2 pz

PER QUESTA LAVORAZIONE UTILIZZARE
GRUPPO FRESA T40003
TO EXECUTE THIS MILLING WORK,
USE ART. T40003 MILLING CUTTER

CAVALLOTTI - T JOINTS		
C77K	KIT	GUARNIZIONE - GASKET
U28002	V47000	V55077
U28003	V47002	V55064
U28022	V47000	V55077
U28023	V47000	V55077
U28025	V47002	V55064
U28026	V47002	V55064
U28024	V47000	V55077
U28042	V47000	V55077
U28043	V47000	V55077
U28044	V47002	V55064
U28601	V47001	V55077
U28602	V47002	V55064
U28603	*	V55064
U28604	V47005 x 2pz + 710219	V55077 x 2 pz
U28630	V47005 x 2pz + 710219	V55077 x 2 pz

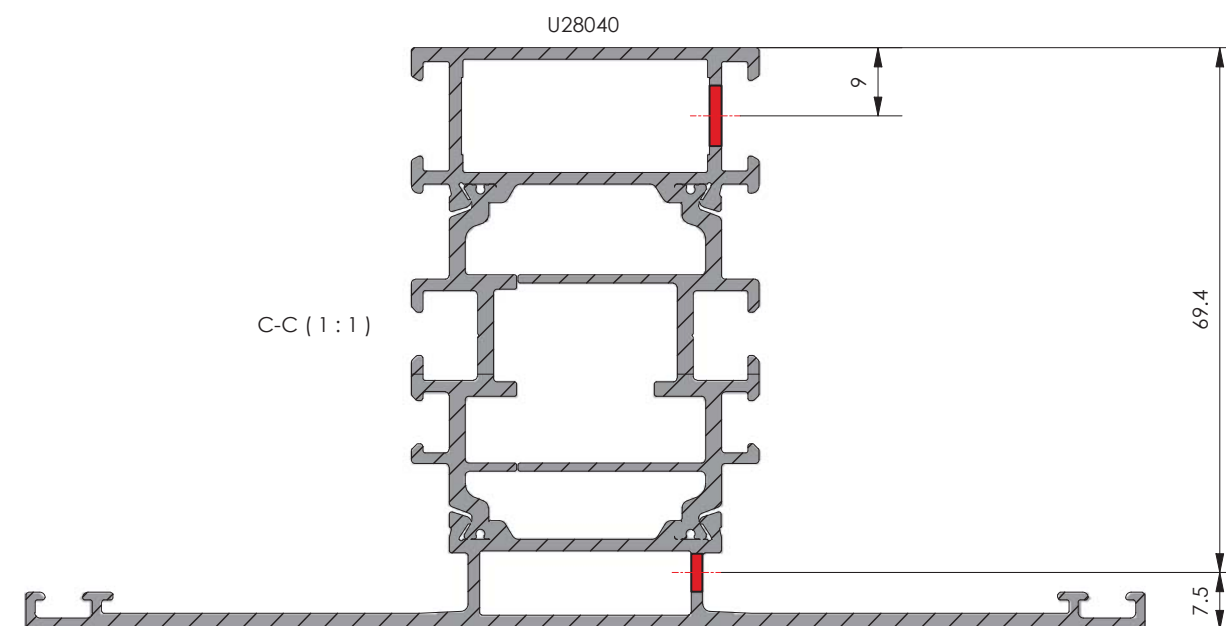
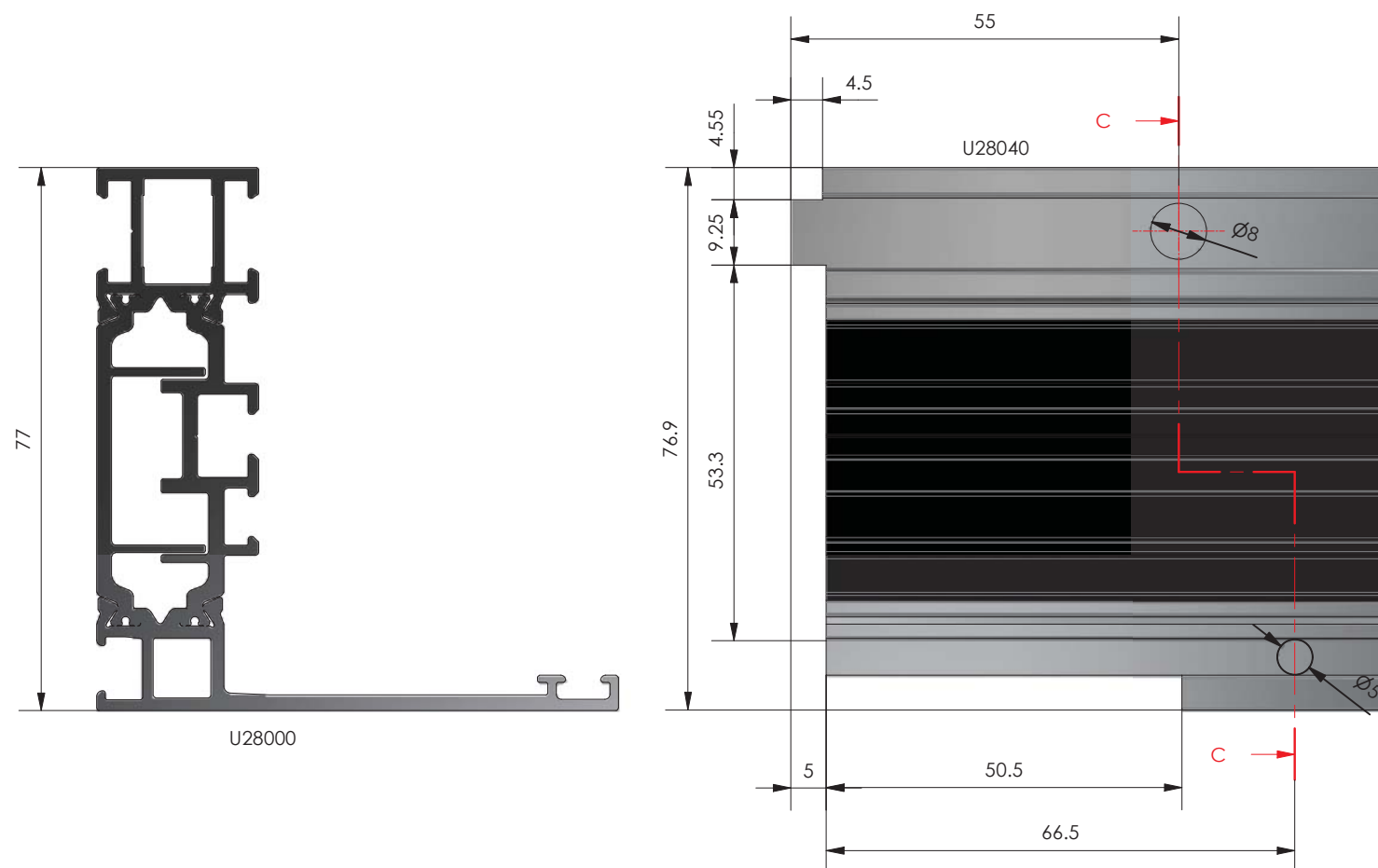
PER QUESTA LAVORAZIONE UTILIZZARE
GRUPPO FRESA T40016
TO EXECUTE THIS MILLING WORK,
USE ART. T40016 MILLING CUTTER

LAVORAZIONE DA ESEGUIRE A MANO
MACHINING BE MADE BY HAND

* NON ESEGUIRE FORI SUL TRAVERSO
* DO NOT DRILL THE TRANSOM

LAVORAZIONE PER CONNESSIONE TRAVERSO STIPITE
 FIXED FRAME TRANSOM CONNECTION DIAGRAM

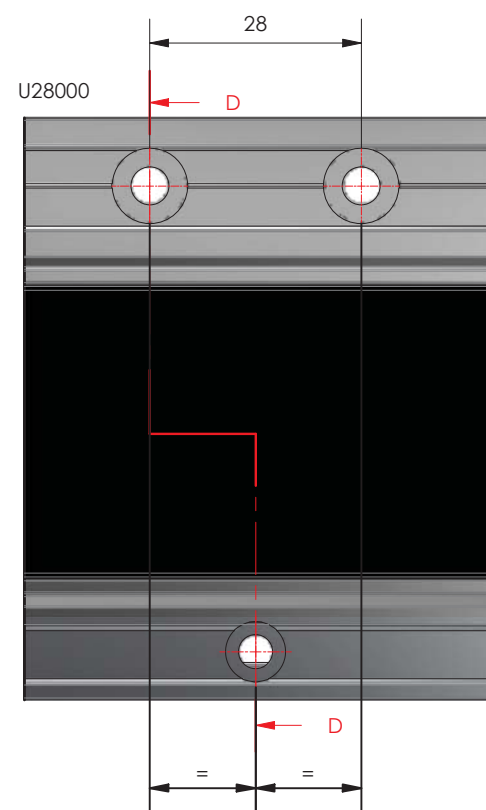
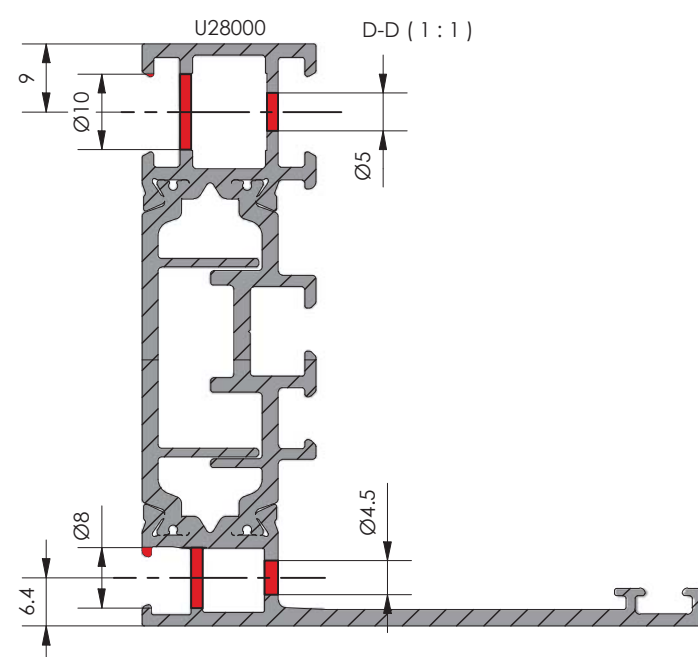
C67K	C77K	C77K-CS
		●



PER IL FORO INTERNO USARE TRACIANTE ART. T00001
 PER IL FORO ESTERNO USARE TRACIANTE ART. T00056 - ESEGUIRE I FORI PRIMA DI FRESARE!

TO EXECUTE INTERNAL HOLE, USE ART. T00001
 TO EXECUTE EXTERNAL HOLE, USE ART. T00056 - DRILL THE HOLES BEFORE MILLING!

SOLO PER CONNESSIONE CON U28603
 ONLY FOR CONNECTION WITH U28603

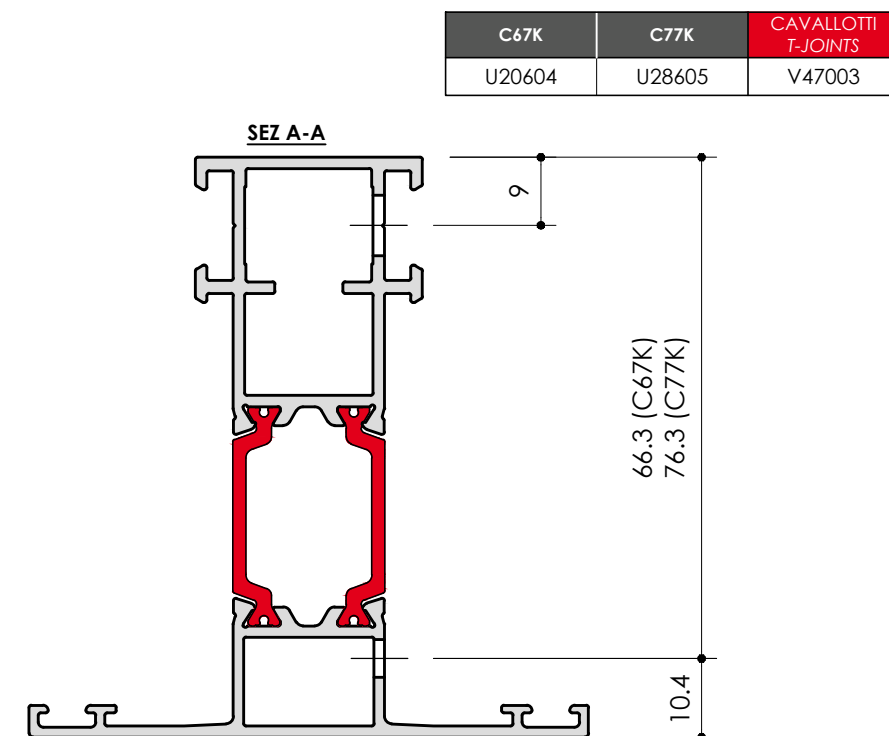
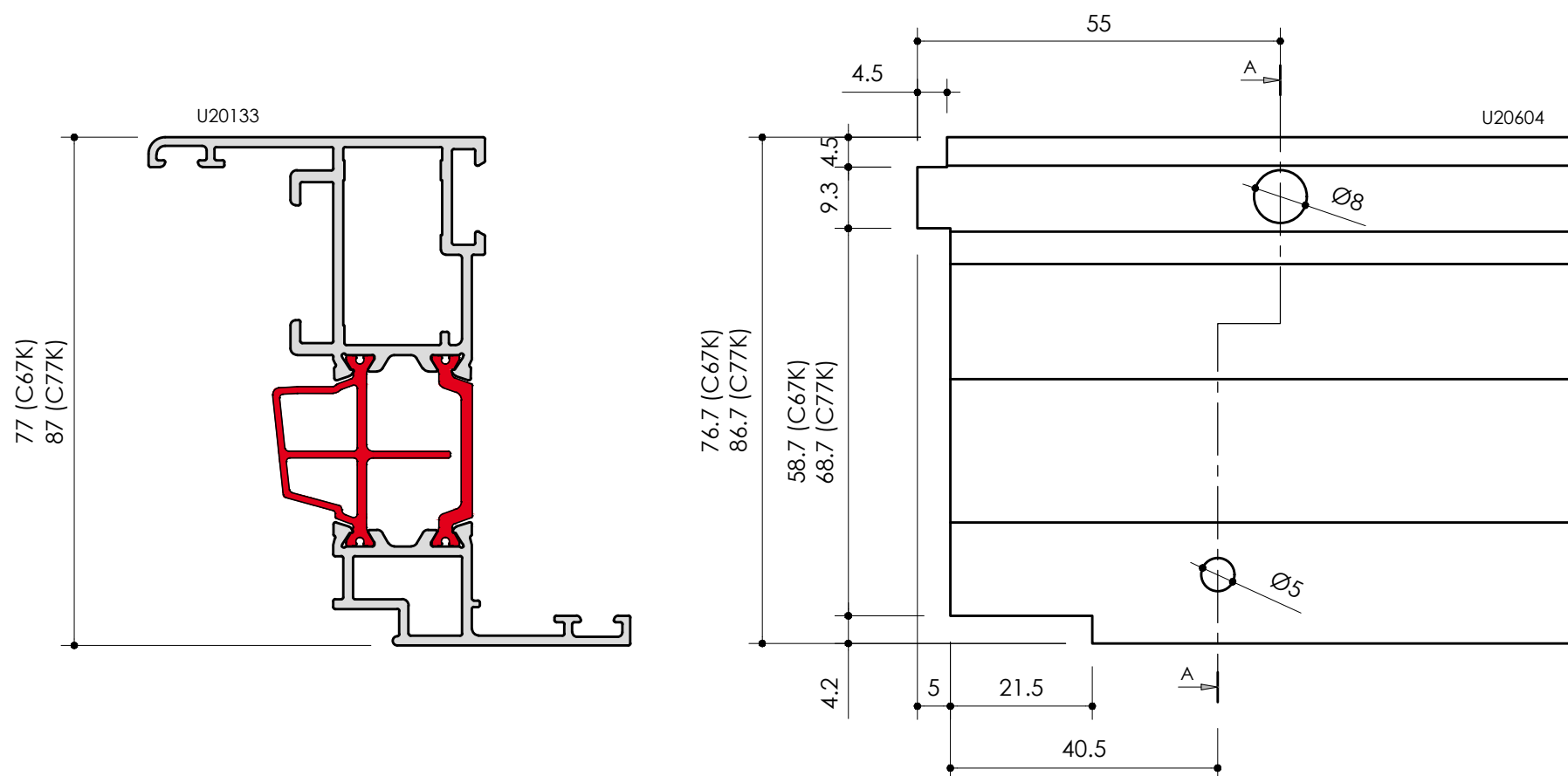


CAVALLOTTI - T JOINTS		
C77K-CS	KIT	GUARNIZIONE - GASKET
U28040	V47034	V55064
U28041	V47034	V55064
U28601	V47001	V55028
U28602	V47002	V55026

PER QUESTA LAVORAZIONE UTILIZZARE
 GRUPPO FRESA T40015
 TO EXECUTE THIS MILLING WORK,
 USE ART. T40015 MILLING CUTTER

➤ LAVORAZIONE PER CONNESSIONE TRAVERSO BATTENTE
WING TRANSOM CONNECTION MACHININGS

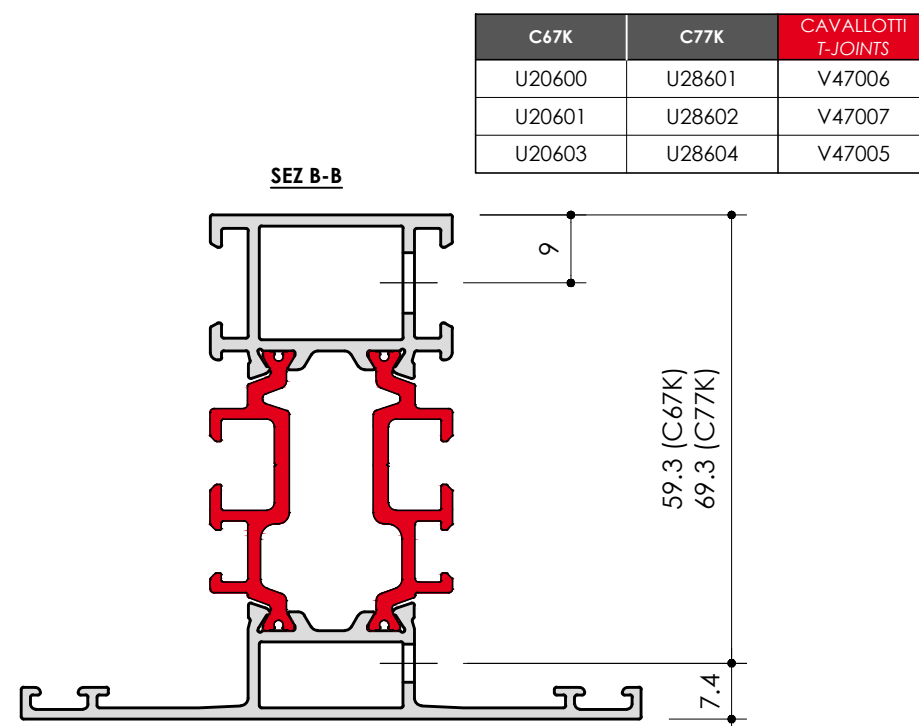
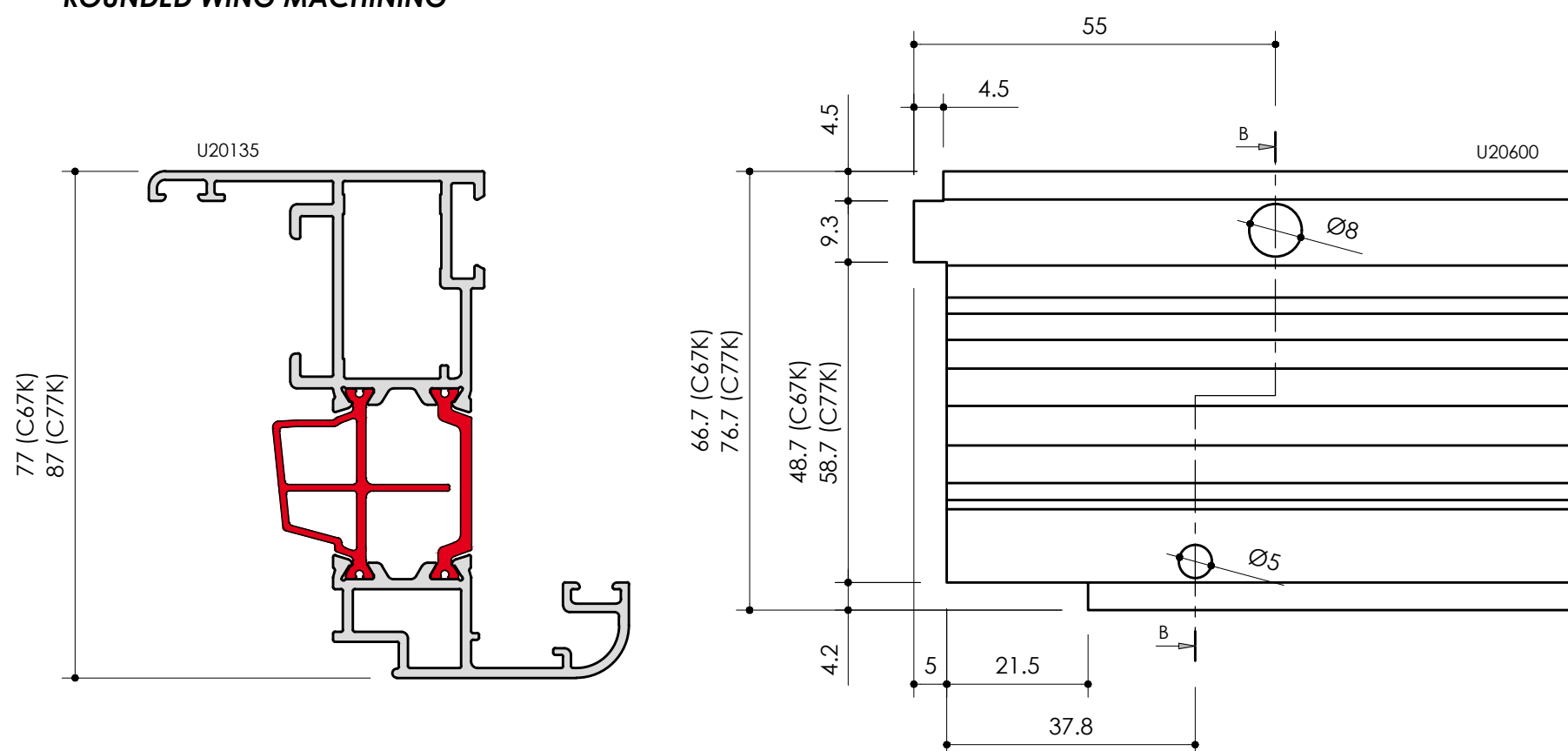
C67K	C77K	C77K-CS
●	●	



PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA T40005 (C67K) O T40018 (C77K)
TO EXECUTE THIS MILLING WORK, USE ART. T40005 (C67K) OR T40018 (C77K) MILLING CUTTER

Per il FORO INTERNO usare tranciante art. T00001
Per il FORO ESTERNO usare tranciante art. 909310
To execute INTERNAL HOLE, use art. T00001
To execute EXTERNAL HOLE, use art. 909310

LAVORAZIONE ANTA STONDATA
ROUNDED WING MACHINING

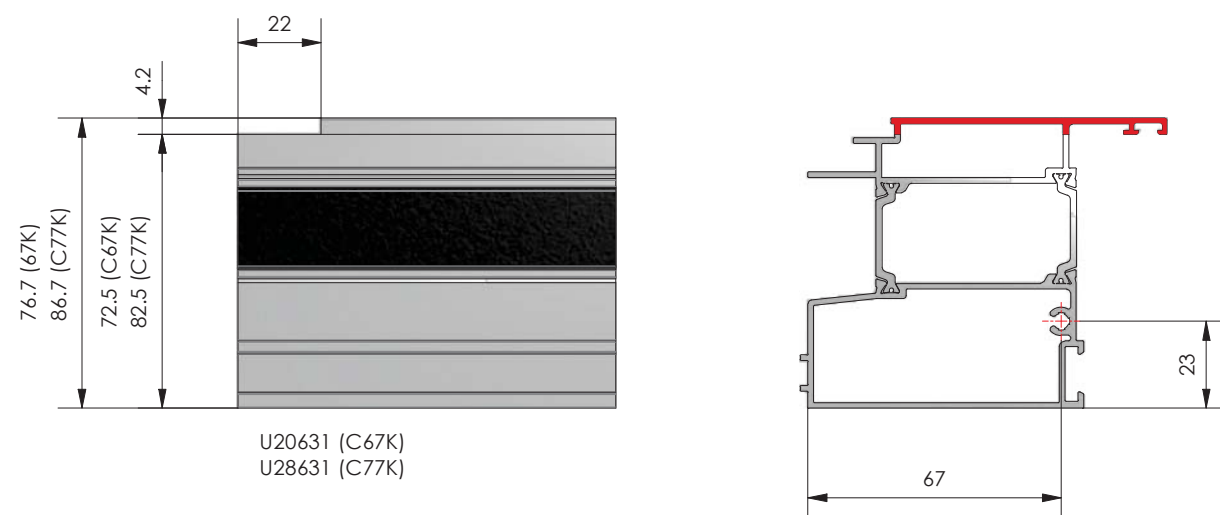


PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA T40004 (C67K) O T40017 (C77K)
TO EXECUTE THIS MILLING WORK, USE ART. T40004 (C67K) O T40017 (C77K) MILLING CUTTER

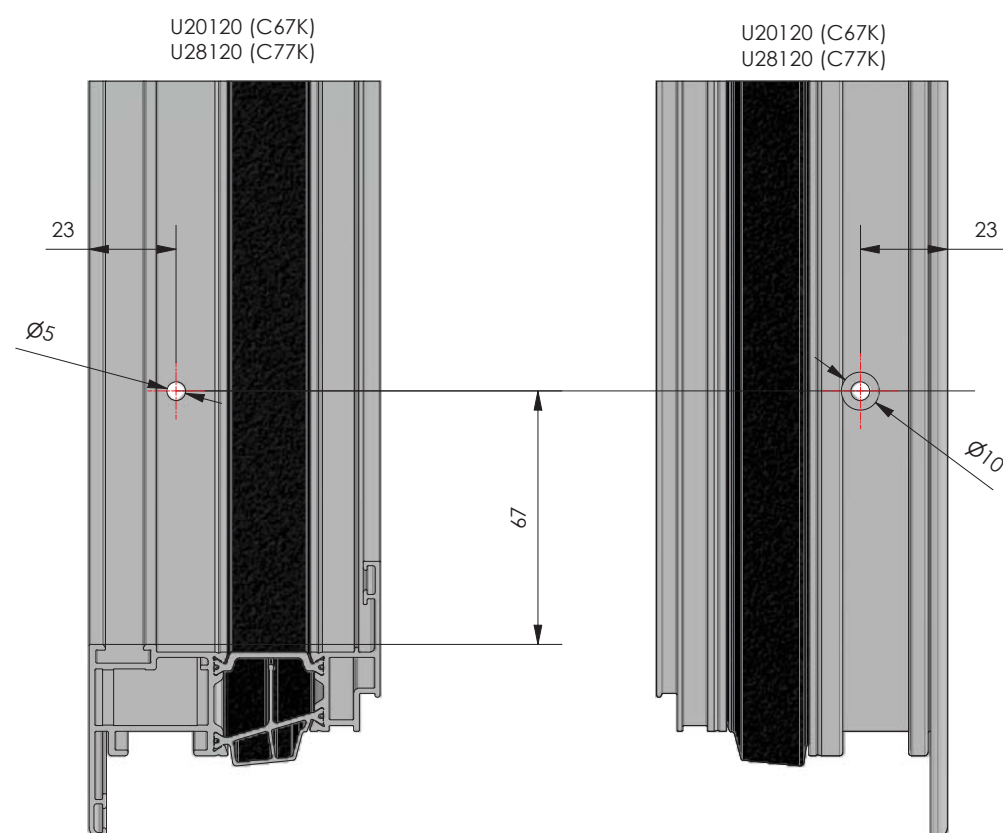
LAVORAZIONE PER CONNESSIONE AGGIUNTIVO BATTENTE WING FRAME TRANSOM BALCONY DOOR CONNECTION DIAGRAM

C67K	C77K	C77K-CS
●	●	

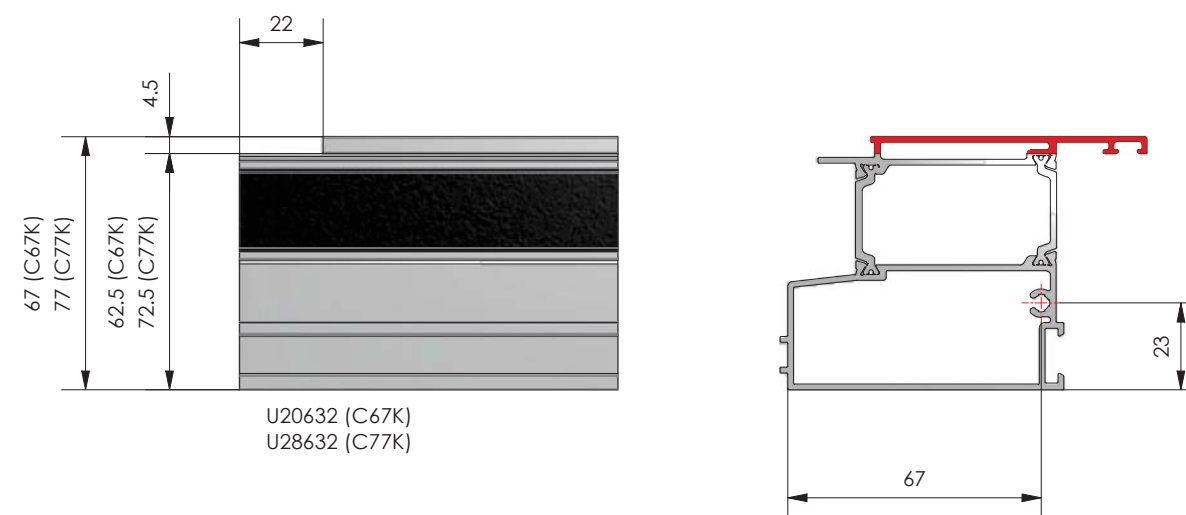
LAVORAZIONI PER ANTE LISCE MACHININGS FOR SMOOTH WINGS



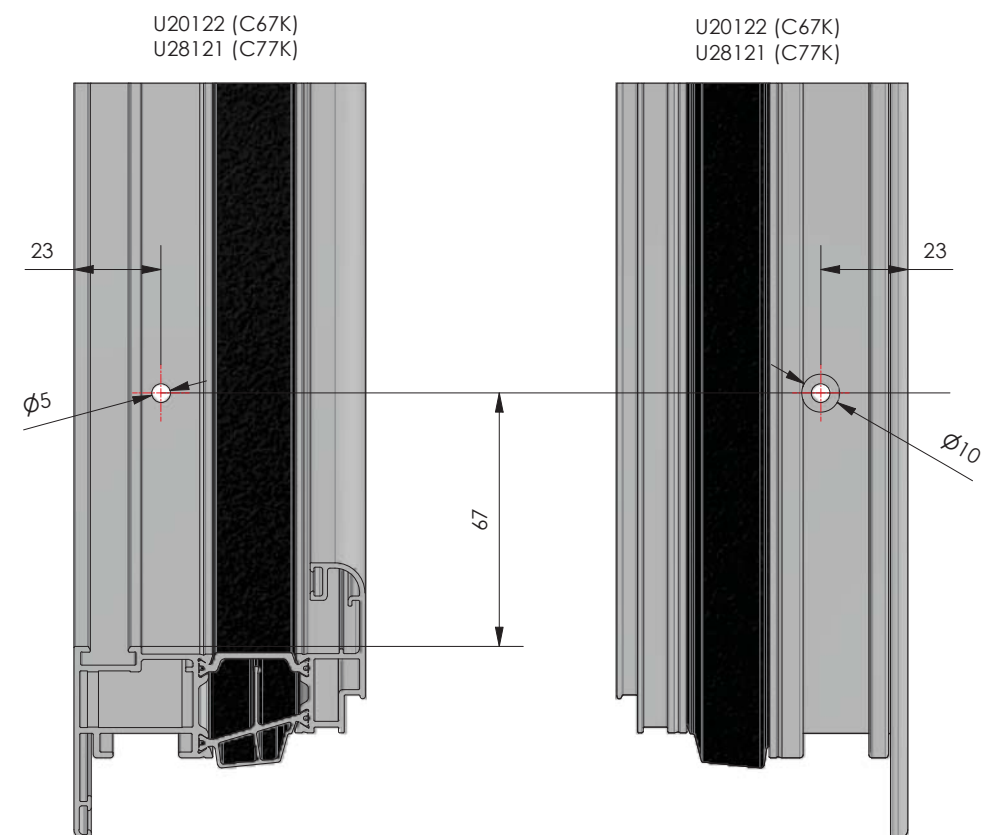
PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA 909364
 TO EXECUTE THIS MILLING WORK, USE ART. 909364 MILLING CUTTER



LAVORAZIONI PER ANTE RAGGiate MACHININGS FOR ROUNDED WINGS



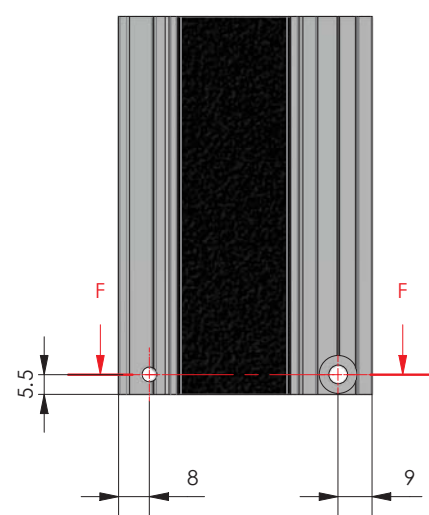
PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA 909364
 TO EXECUTE THIS MILLING WORK, USE ART. 909364 MILLING CUTTER



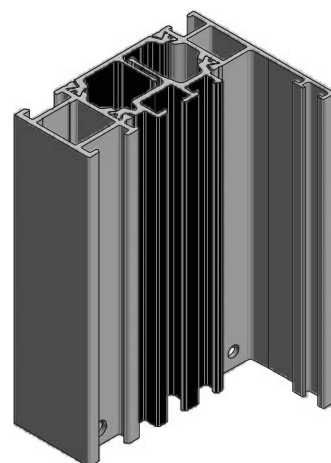
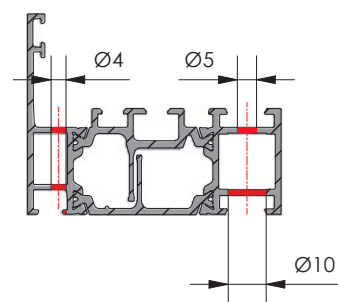
➤ LAVORAZIONE PER MONTAGGIO SOGLIA RIBASSATA
MACHINING FOR U20400 AND U28400 DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	●

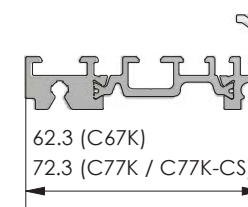
LAVORAZIONE LATO MONTANTE
FIXED FRAME MULLION SIDE MACHINING



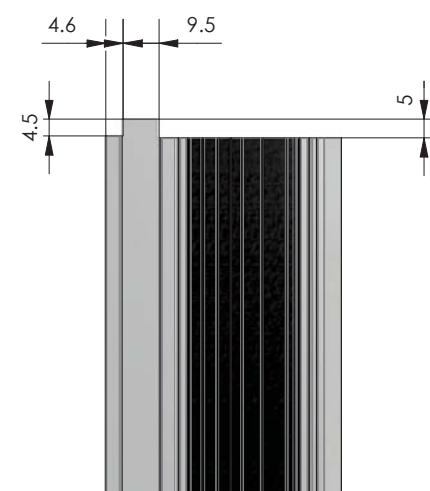
F-F (1:2)



LAVORAZIONE INTESTATURA U20400 E U28400
U20400 MACHINING AND U28400

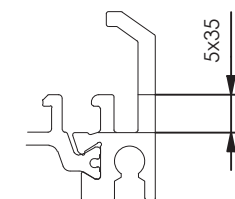
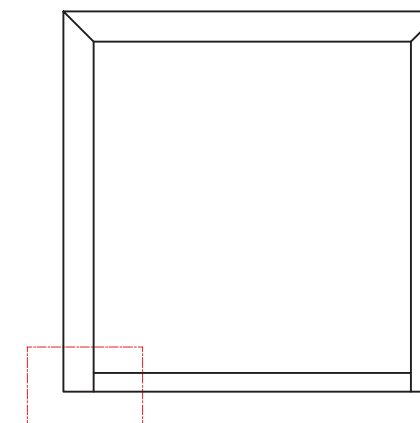


U20400 (C67K)
U28400 (C77K / C77K-CS)



PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA:
- C67K: T40006
- C77K E C77K-CS: T40019

TO EXECUTE THIS MILLING WORK, USE MILLING CUTTER ART.:
- C67K: T40006
- C77K E C77K-CS: T40019



DRENAGGIO SOGLIA OGNI 400 mm
PARTENZA DAL LATO: 100/150 mm

DRAINAGE THRESHOLD EVERY 400 mm
START FROM THE SIDE: 100/150 mm



LAVORAZIONI PER DRENAGGIO SU ELEMENTI FISSI

FIXED FRAMES WATER DRAINAGE SYSTEM

C67K	C77K	C77K-CS
●	●	●

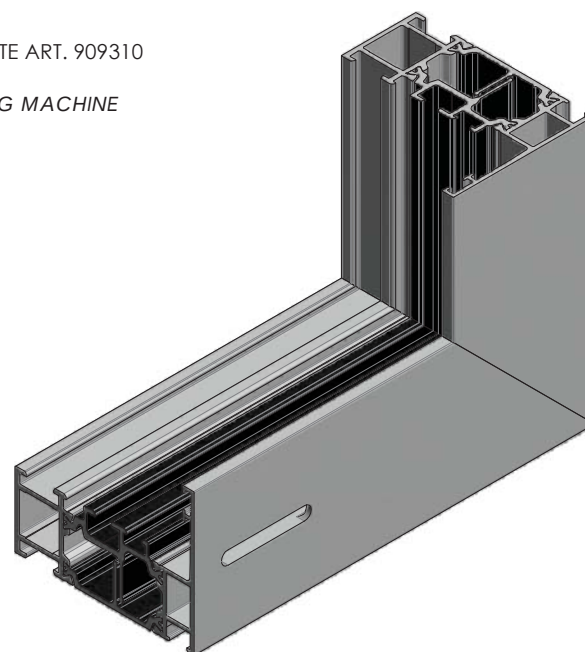
PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE TRACIANTE ART. 909310

TO EXECUTE THIS DRAINAGE SLOT USE ART. 909310 BLANKING MACHINE

DRENAGGIO - DRAINAGE		
C67K	C77K	C77K-CS
U20000	U28002	U28001 *
-	-	U28000 *
U20001	U28003	-
U20002	U28022	-
U20003	U28023	U28021 *
-	-	U28020 *
U20004	U28025	-
U20005	U28026	-
U20020	U28024	-
U20040	U28042	-
U20041	U28043	-
U20042	U28044	-
U20060	U28060	-
U20061	U28061	-

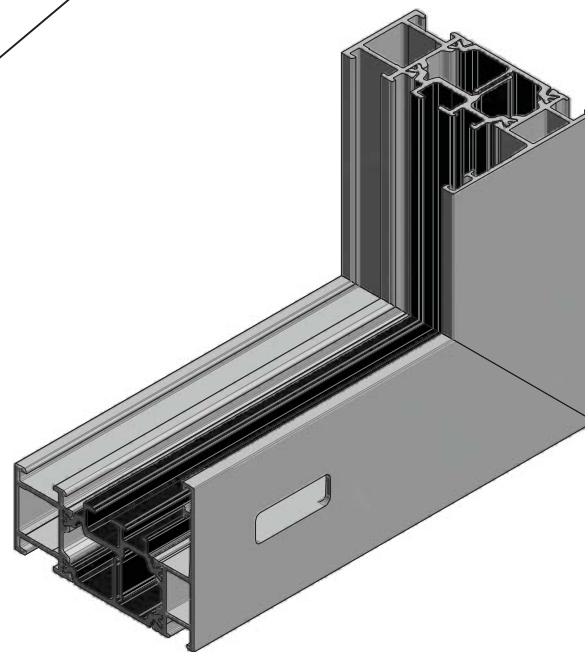
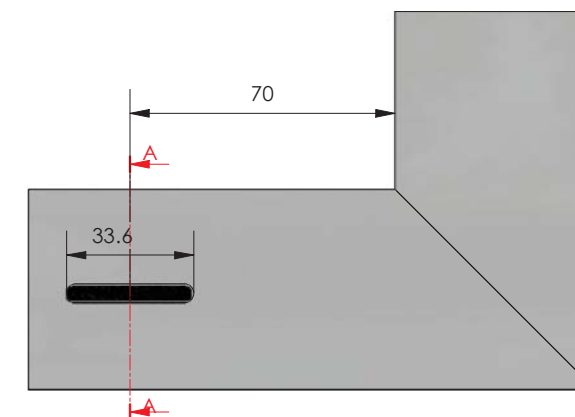
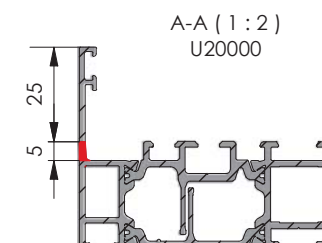
* LAVORAZIONE NON ESEGUIBILE A TRACIANTE

* MACHINING NOT EXECUTABLE BY BLANKING MACHINE



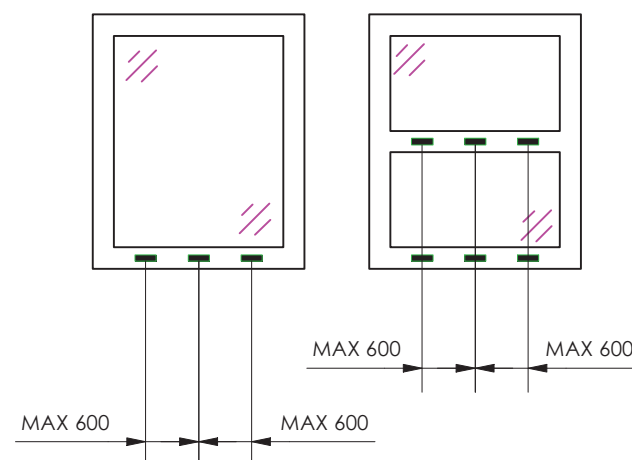
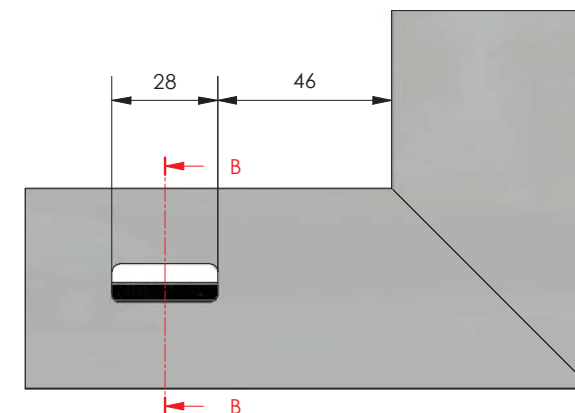
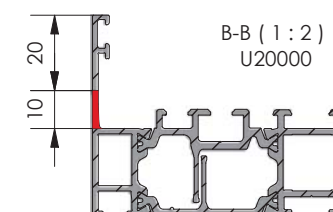
LAVORAZIONE PER ACCESSORI 712005, 712006, 712007, 712008

MACHINING FOR 712005, 712006, 712007, 712008 ACCESSORIES

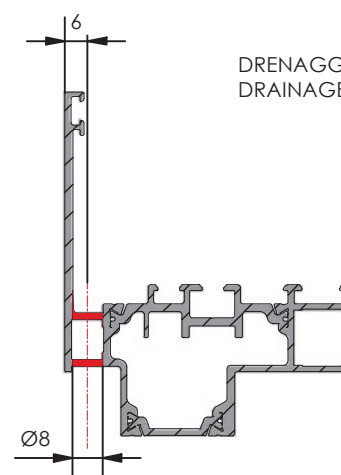


LAVORAZIONE PER ACCESSORIO V51007P

MACHINING FOR V51007P ACCESSORY



LAVORAZIONI NON ESEGUIBILI A TRACIANTE
MACHININGS NOT EXECUTABLE BY BLANKING MACHINE



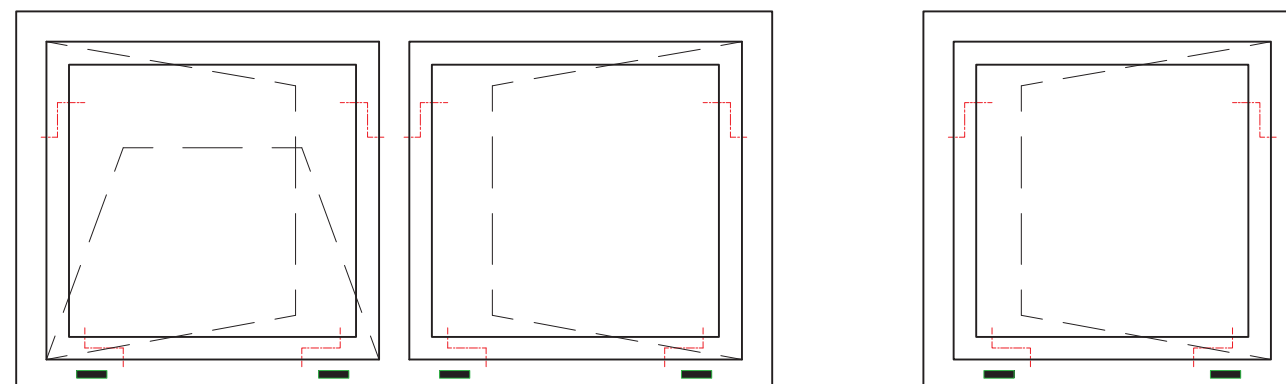
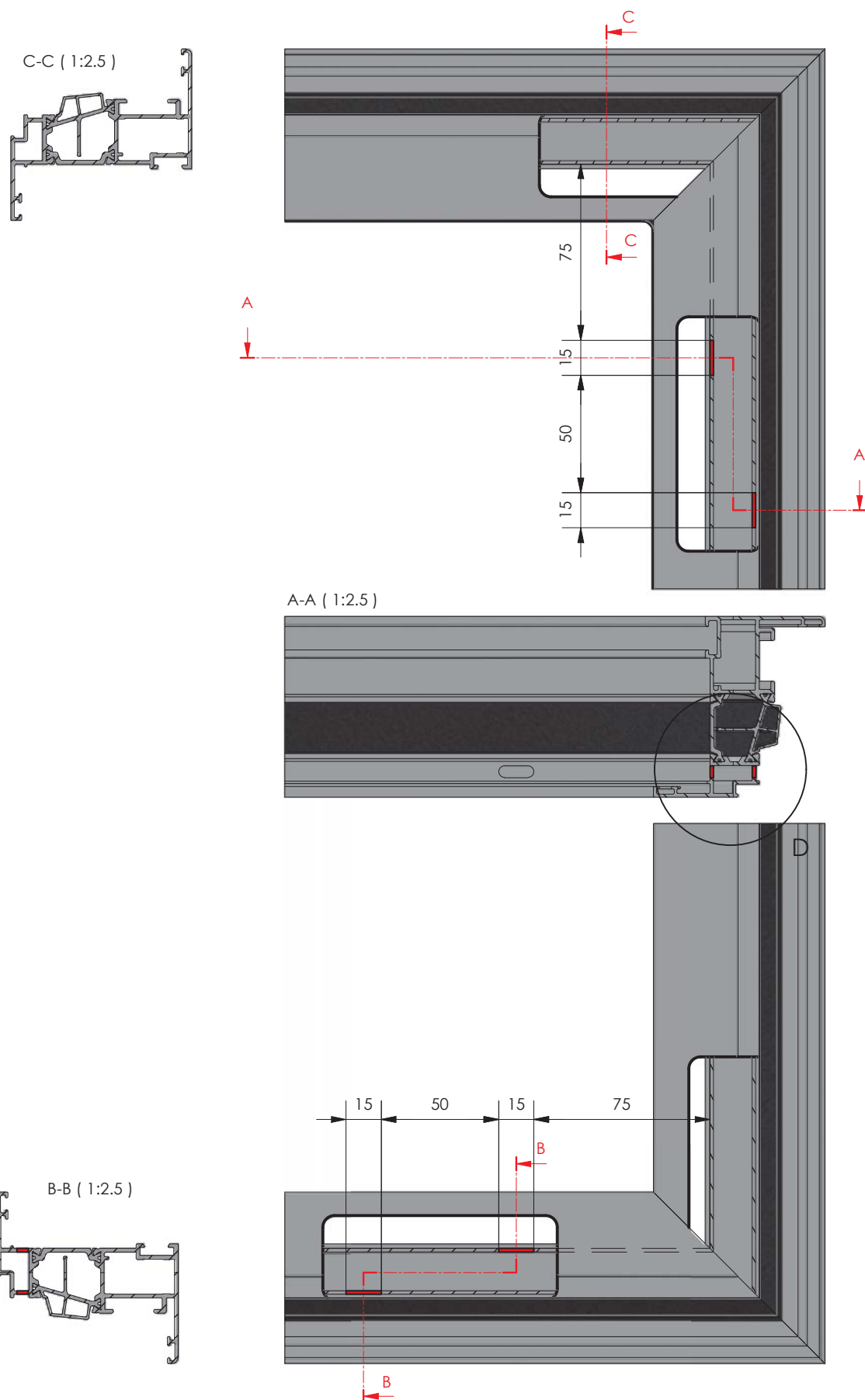
DRENAGGIO SU STIPITE INSERIMENTO IN FACCIA
DRAINAGE ON FIXED FRAME PROFILE INTO FACADE WINDOWS INSERTION

U48060

DRENAGGIO - DRAINAGE		
C67K	C77K	C77K-CS
U20062	U28062	U48060

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

C67K	C77K	C77K-CS
●	●	

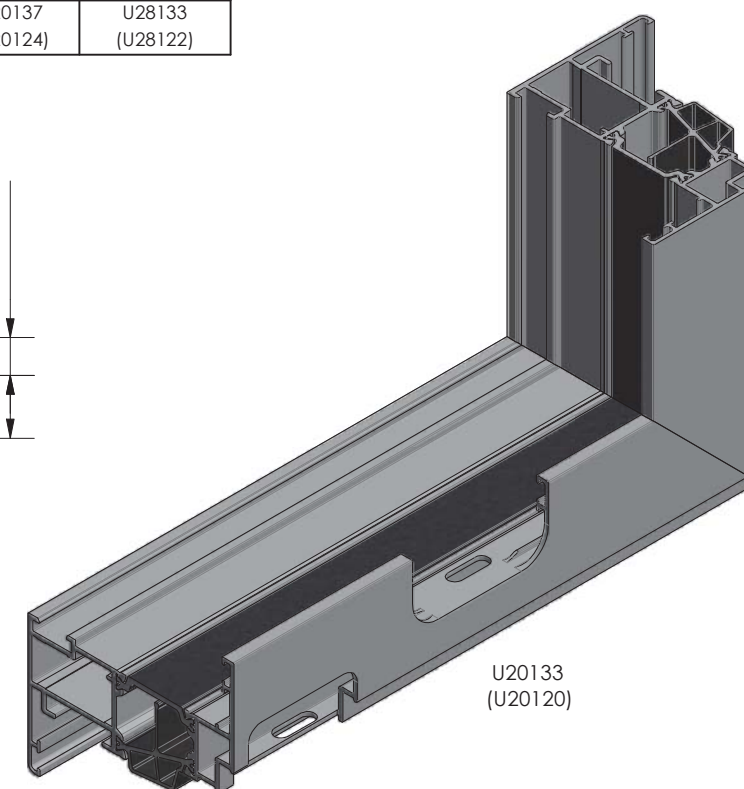
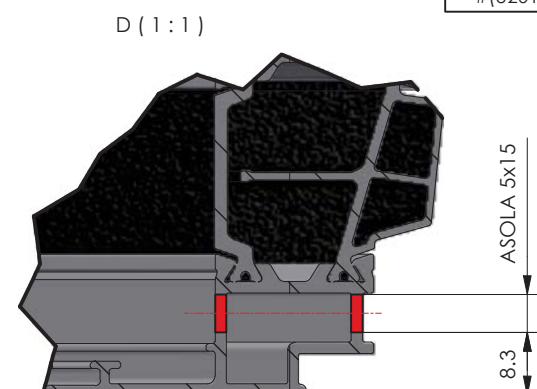


PER ESEGUIRE QUESTA LAVORAZIONE UTILIZZARE TRANCIANTE ART. 909310
TO EXECUTE THIS DRAINAGE SLOT USE ART. 909310 BLANKING MACHINE

DRENAGGI - DRAINAGES	
C67K	C77K
U20133 (U20120)	U28129 (U28120)
U20134 (U20121)	U28130 (U28123)
U20135 (U20122)	U28131 (U28121)
U20136 (U20123)	U28132 (U28124)
#U20137	U28133
#(U20124)	(U28122)

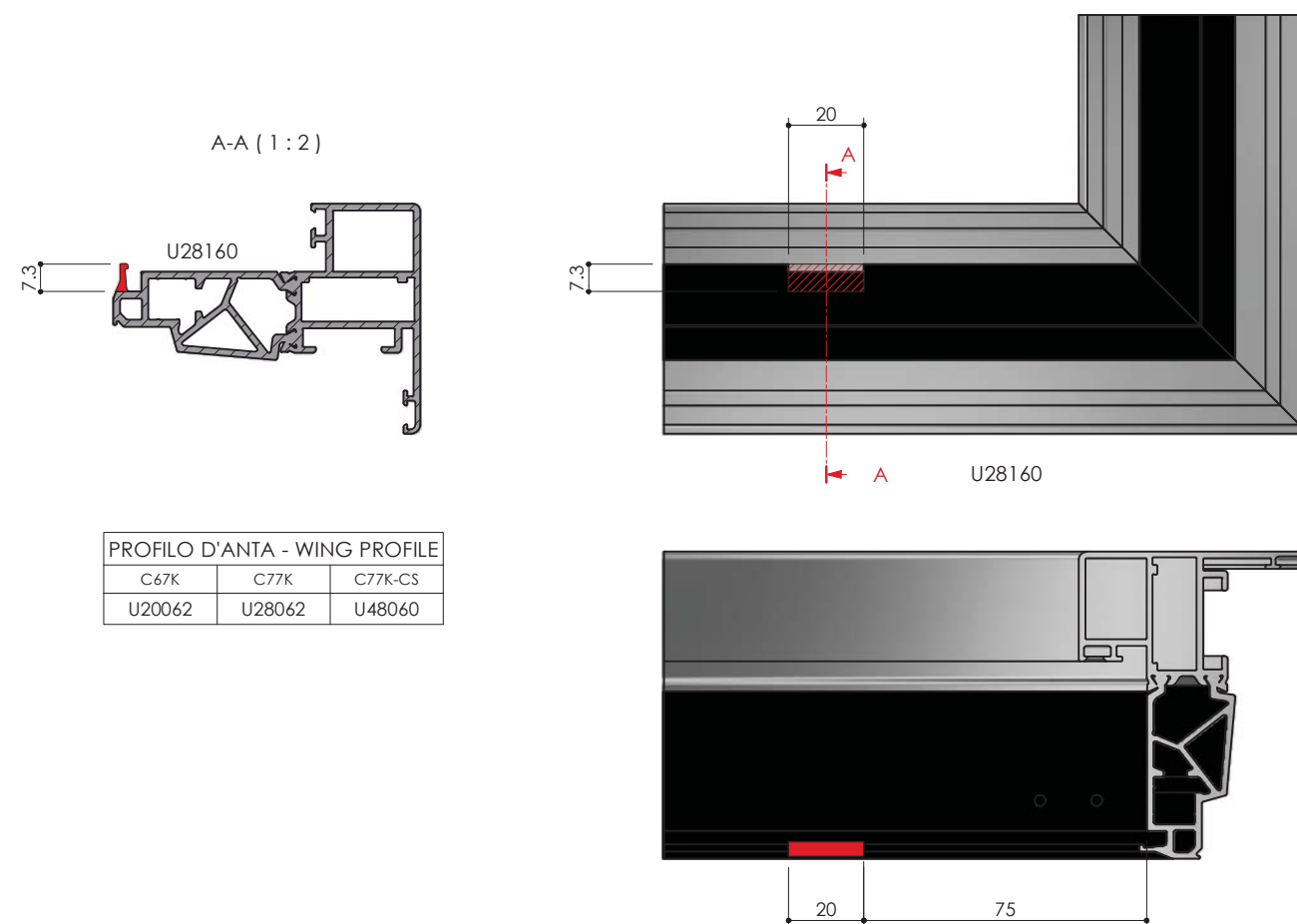
LAVORAZIONE DA ESEGUIRE A MANO

MACHINING BE MADE BY HAND

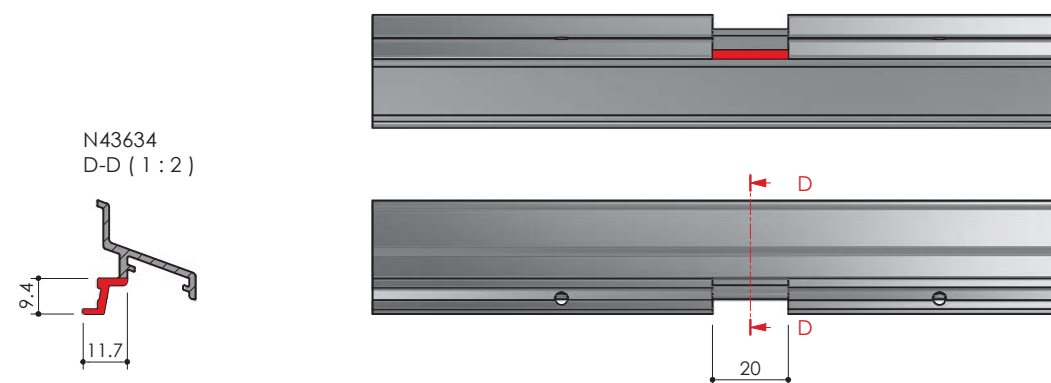


LAVORAZIONE PER DRENAGGIO ACQUA E VENTILAZIONE SU BATTENTI WATER DRAINAGE AND VENTILATION SYSTEM ON WINGS

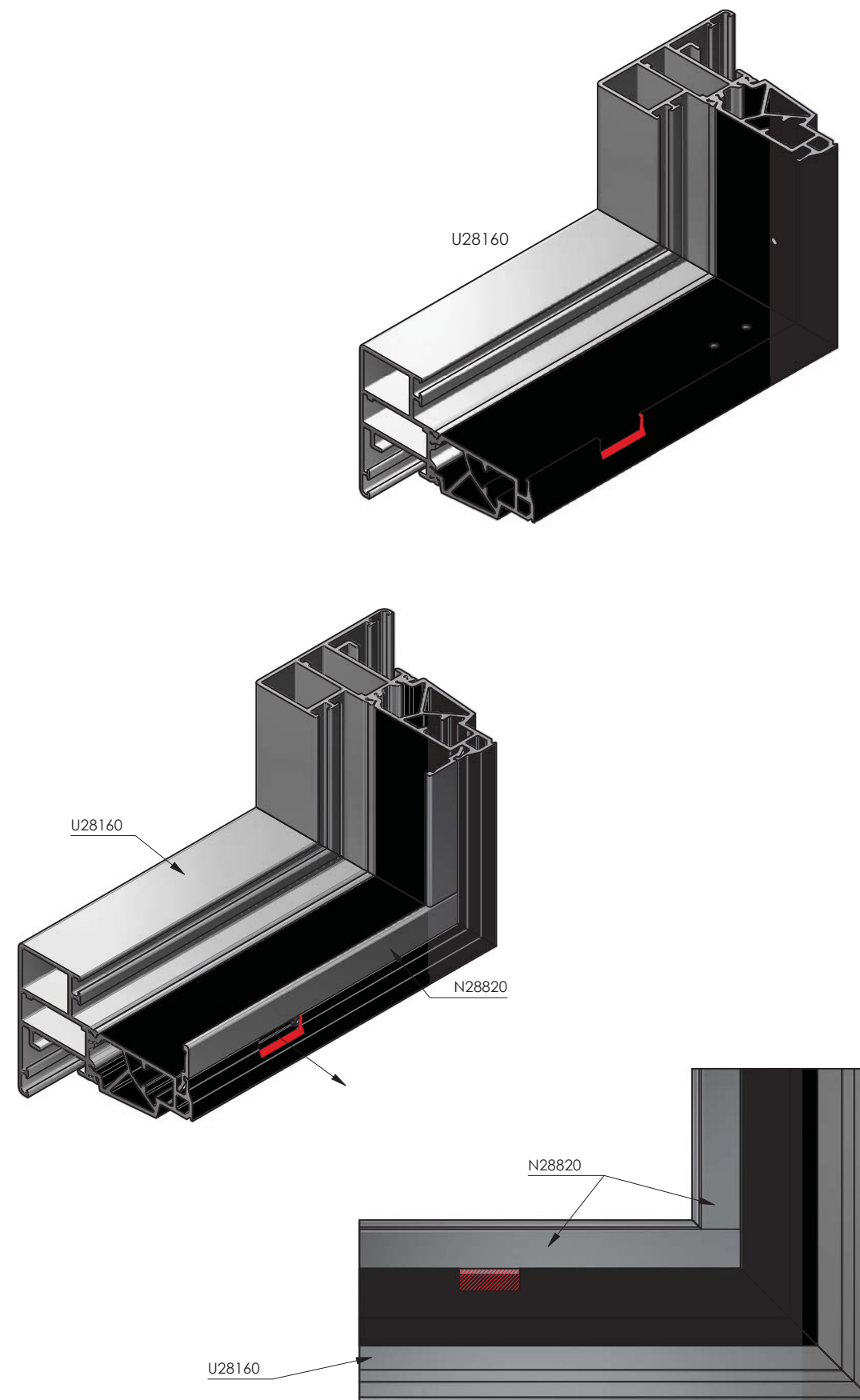
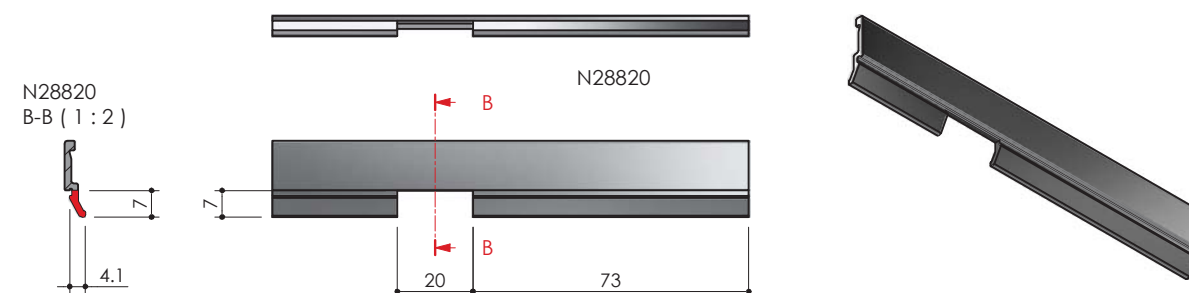
C67K	C77K	C77K-CS
		●



LAVORAZIONE DI DRENAGGIO GOCCIOLATOIO N43634
N43634 DRAINING PROFILE DRAINAGE MACHINING



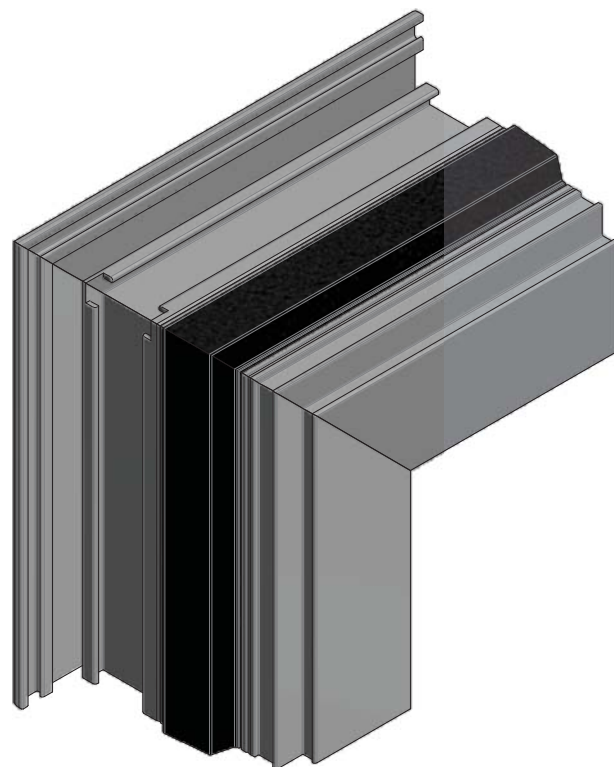
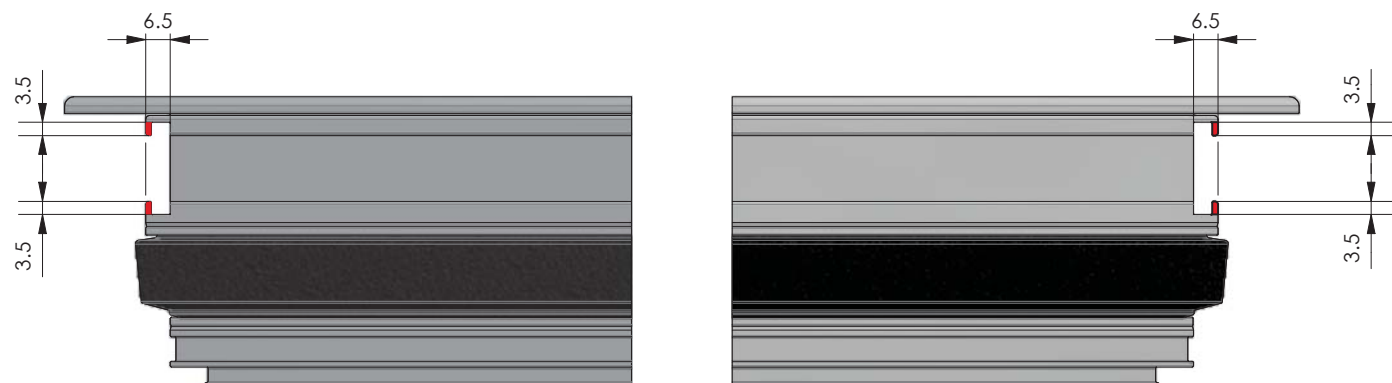
LAVORAZIONE DI DRENAGGIO FERMAVETRO N28820
N28820 GLASS BEAD DRAINAGE MACHINING



LAVORAZIONI BATTENTE WING MACHININGS

C67K	C77K	C77K-CS
●	●	●

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



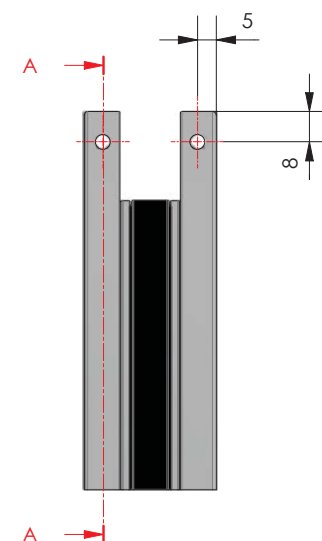
PROFILI - PROFILES		
C67K	C77K	C77K-CS
U20133 (U20120)	U28129 (U28120)	-
U20134 (U20121)	U28130 (U28123)	-
U20135 (U20122)	U28131 (U28121)	-
U20136 (U20123)	U28132 (U28124)	-
U20137 (U20124)	U28133 (U28122)	-
-	-	U28160
-	-	U28161
-	-	U28162
-	-	U28163
U20043	-	-
N48630	-	-

PER ESEGUIRE QUESTE LAVORAZIONI UTILIZZARE TRANCIANTE ART. 909310
TO EXECUTE THIS CUTTING OUT USE ART. 909310 BLANKING MACHINE

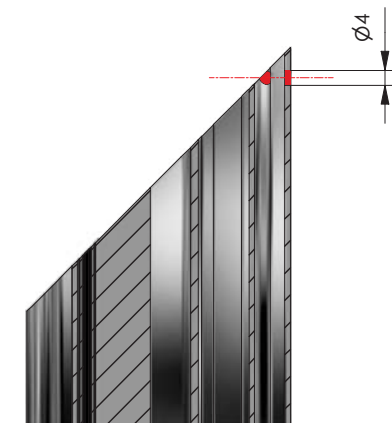
Articolo in esaurimento / Until stock is finished

C67K	C77K	C77K-CS
●	●	

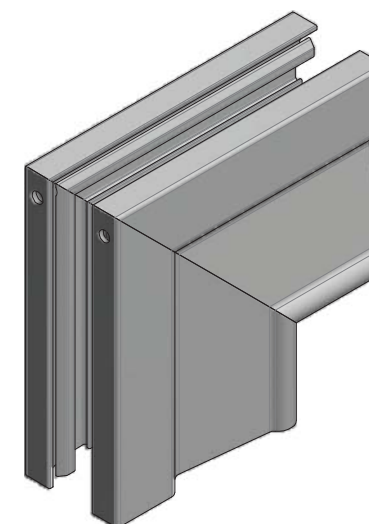
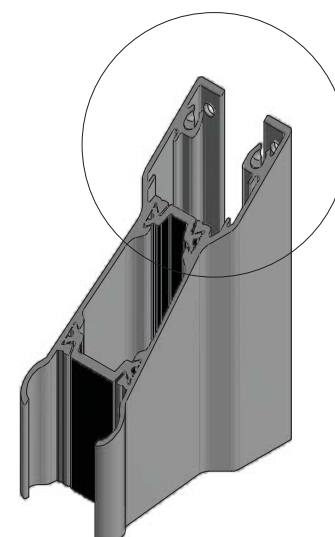
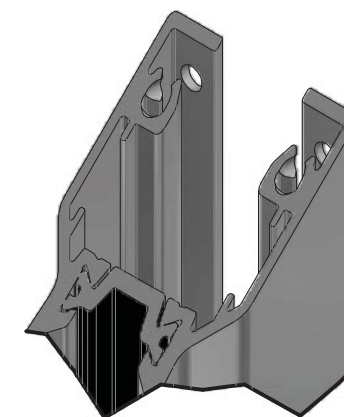
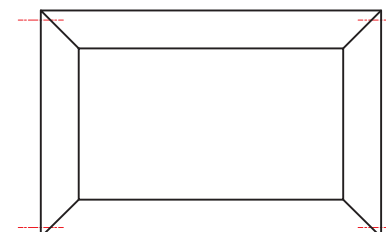
LAVORAZIONE PER CHIUSURA PROFILO K1481
MACHINING FOR K1481 ASSEMBLING



A-A (1:2)

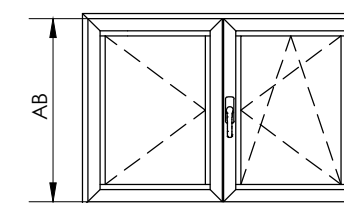
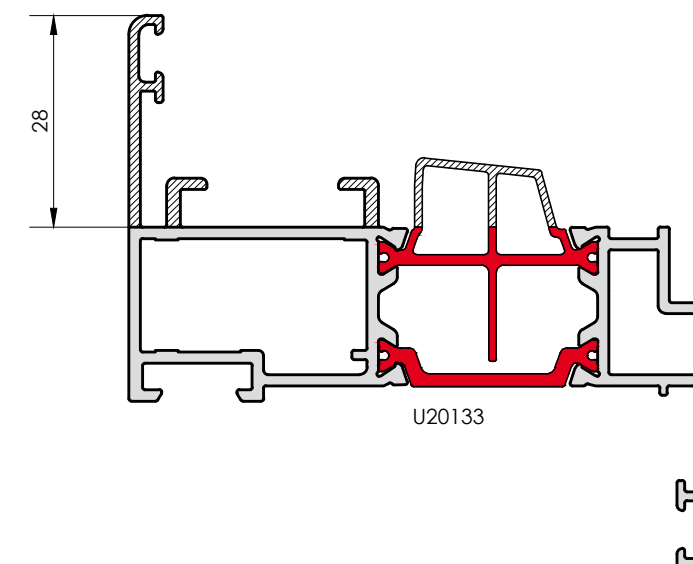
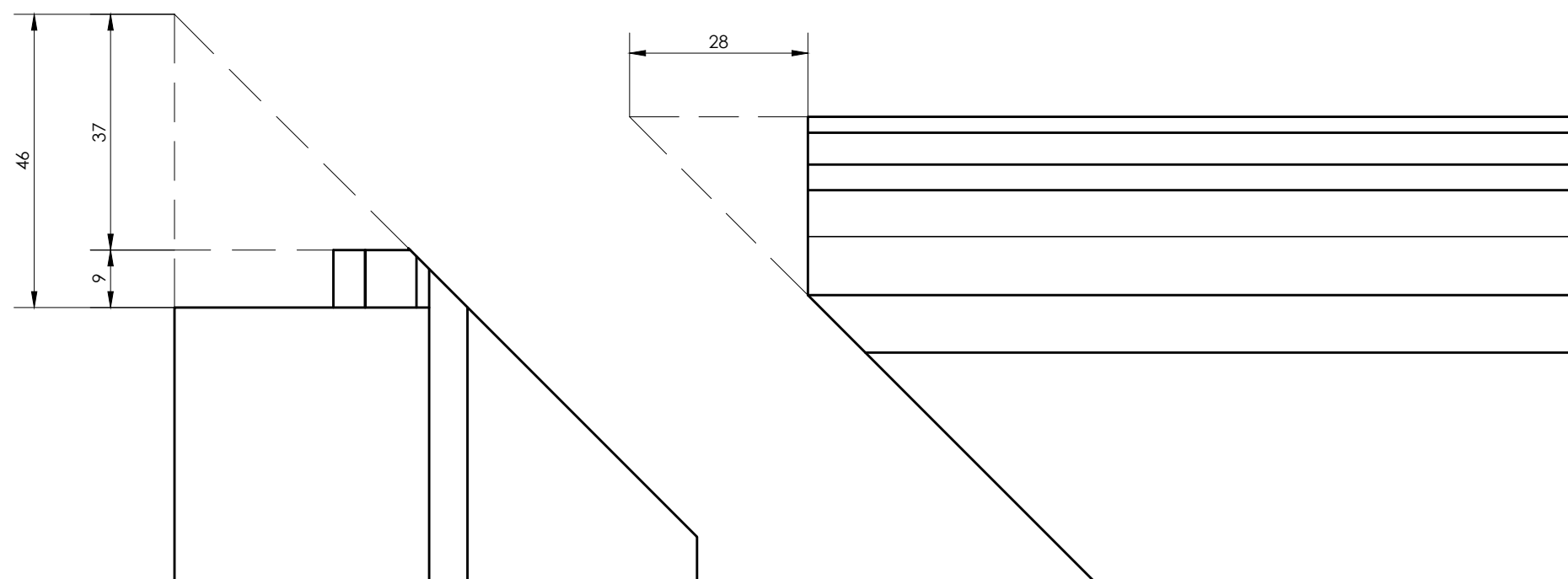


SCHEMA LATO DA FORARE
DIAGRAM PROFILES WITH HOLE

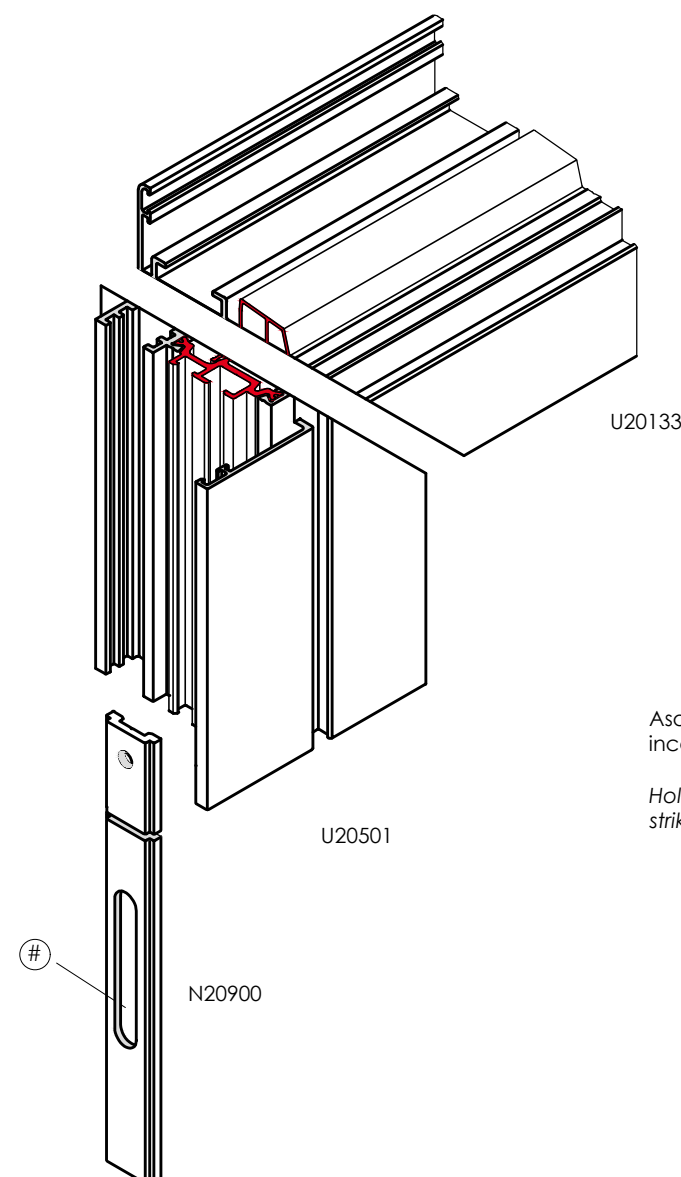
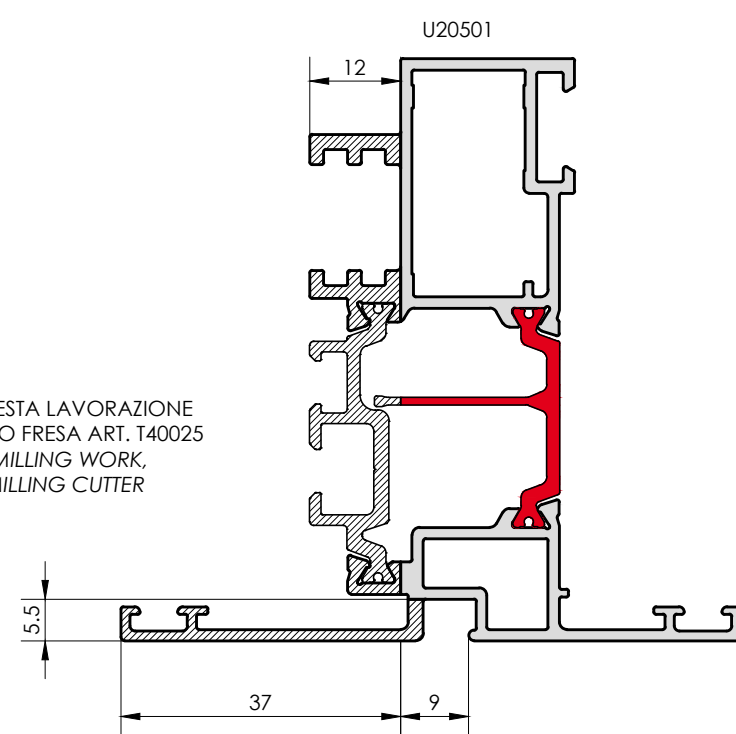


➤ LAVORAZIONE MONTANTE CENTRALE BATTENTE / TZ E FORATURA ASTA N20900
TWO-WINGS WINDOW CENTRAL SEALING PLUG MACHINING

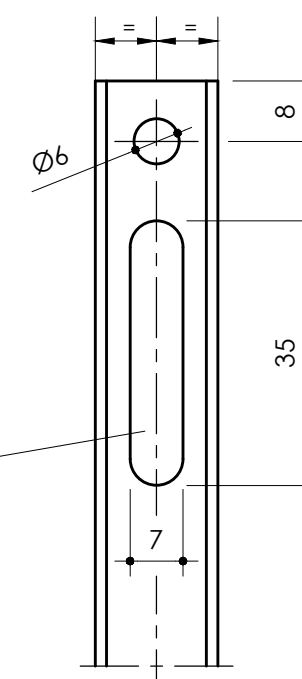
C67K	C77K	C77K-CS
●	●	



PER ESEGUIRE QUESTA LAVORAZIONE
UTILIZZARE GRUPPO FRESA ART. T40025
TO EXECUTE THIS MILLING WORK,
USE ART. T40025 MILLING CUTTER



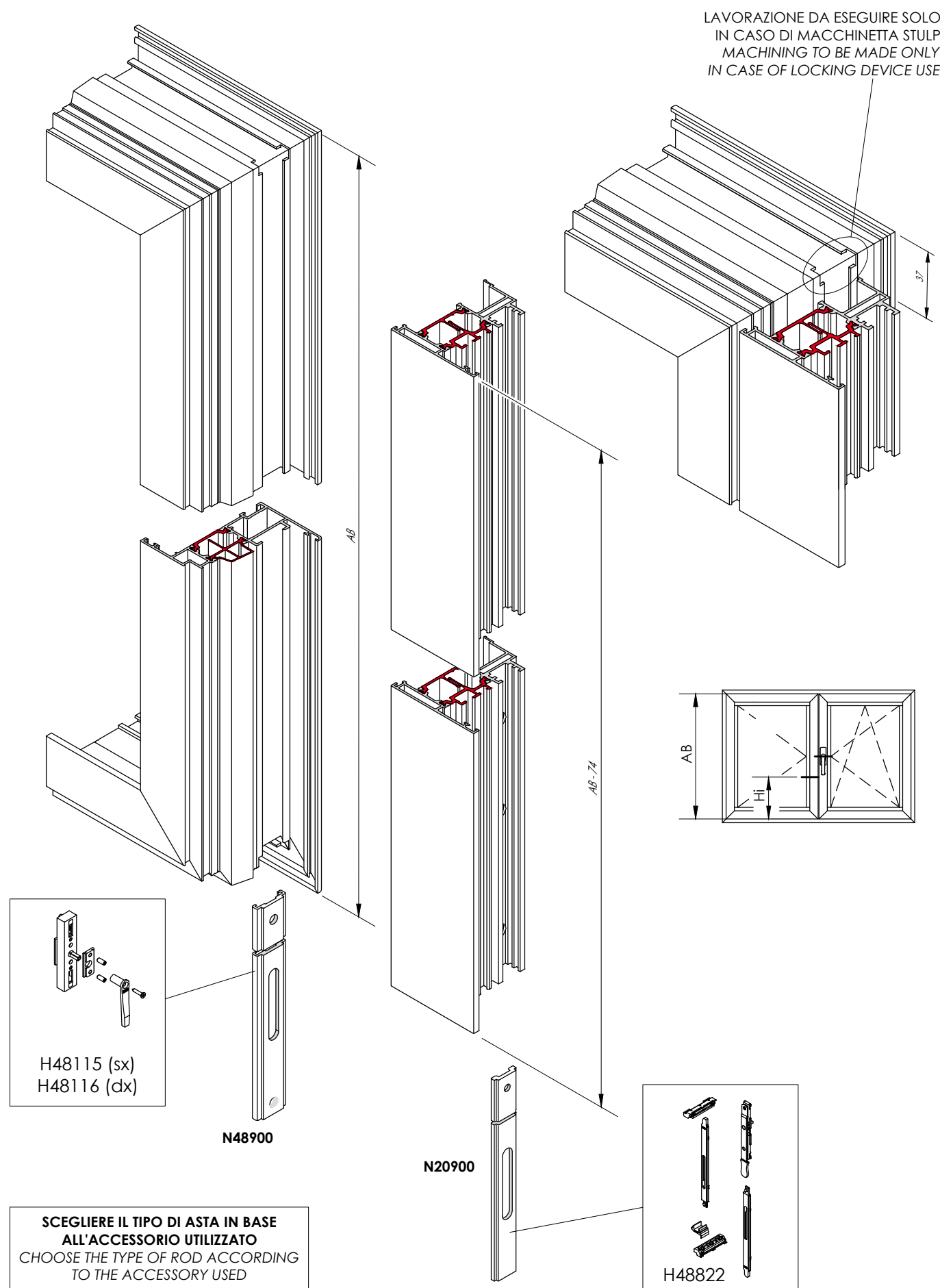
Asola da eseguire in caso di montaggio
incontro intermedio sulla cava centrale
Hole to be made in case of assembly of
strikers meeting on the central groove



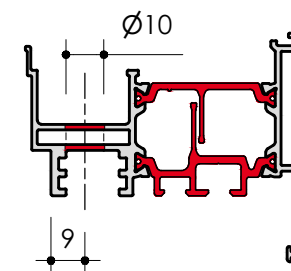
FORARE LE ESTREMITA' DELL'ASTA N20900
UTILIZZANDO TRACIANTE ART. 909310
TO EXECUTE THIS DRAINAGE SLOT USE
ART. 909310 BLANKING MACHINE

LAVORAZIONE MONTANTE CENTRALE BATTENTE "STULP" "STULP" CENTRAL MULLION WING PROFILE MACHINING

C67K	C77K	C77K-CS
●	●	

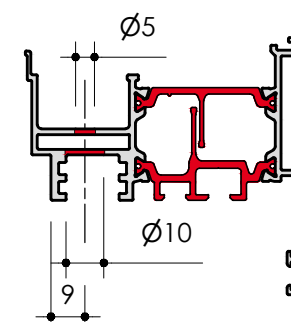


SEZ A-A



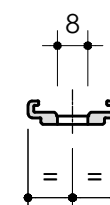
LAVORAZIONE DA FARE SOLO IN CASO DI MACCHINETTA STULP
MACHINING TO BE MADE ONLY IN CASE OF LOCKING DEVICE USE

SEZ B-B



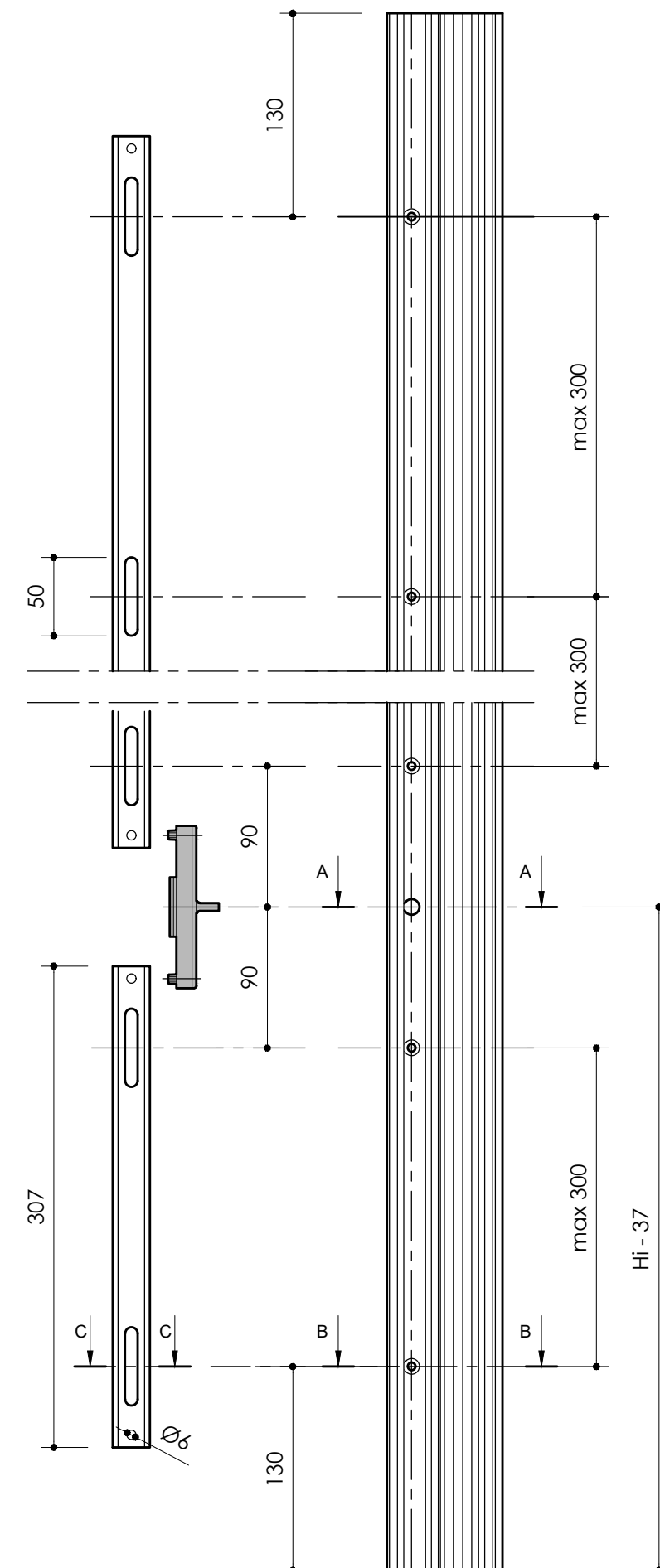
LAVORAZIONE FISSAGGIO PROFILO STULP (DA ESEGUIRE A PASSO 250 mm)
MACHINING FIXING STULP PROFILE (TO EXECUTE EVERY 250 mm)

SEZ C-C

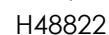


Lavorazione da eseguire in corrispondenza dei fissaggi profilo stulp

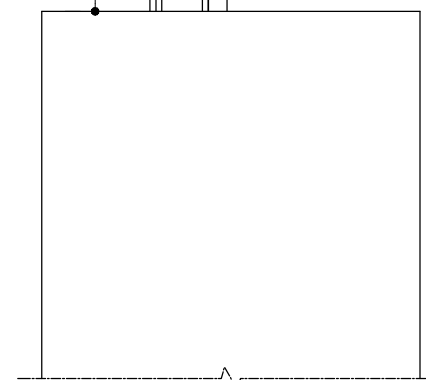
Machining to be made at the stulp profile fixings



C67K	C77K	C77K-CS
		●



28.5 |



(TO EXECUTE EVERY 250 mm)



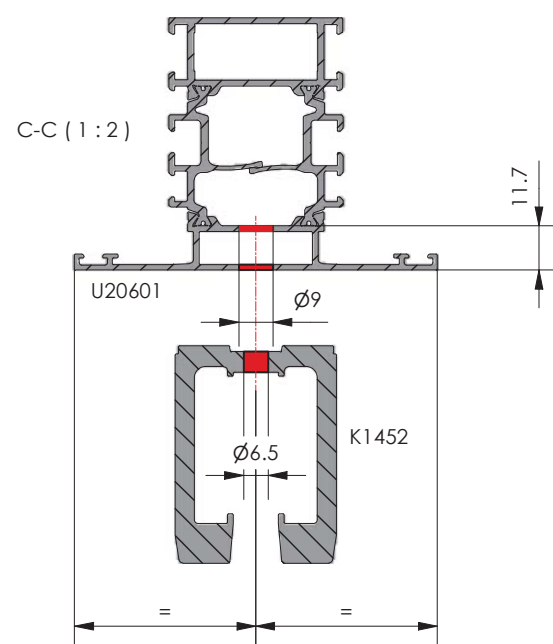
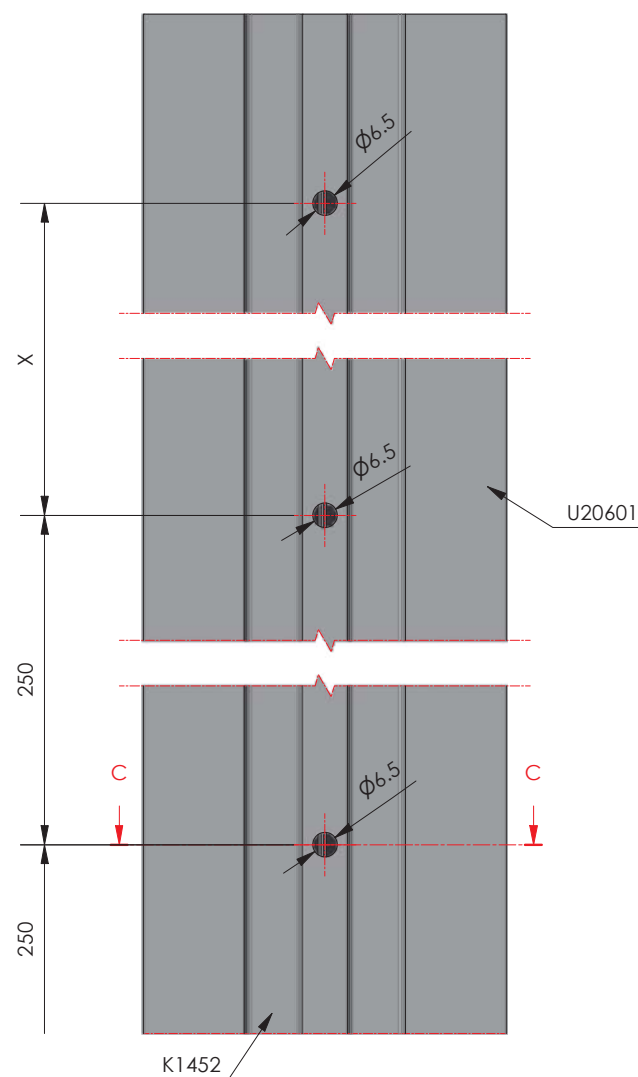
4.5



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

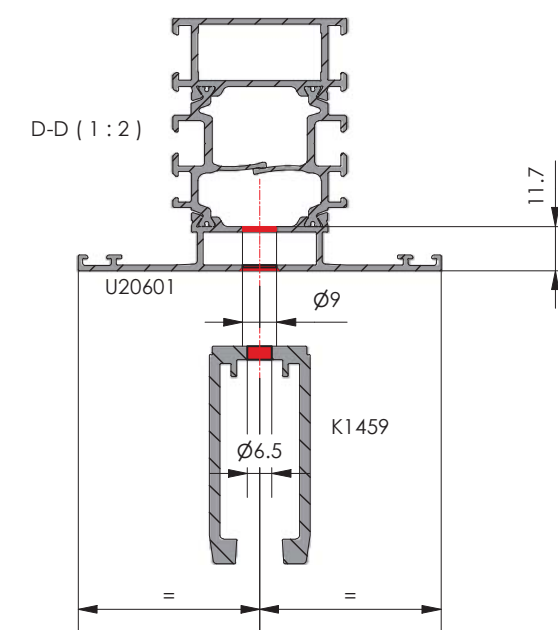
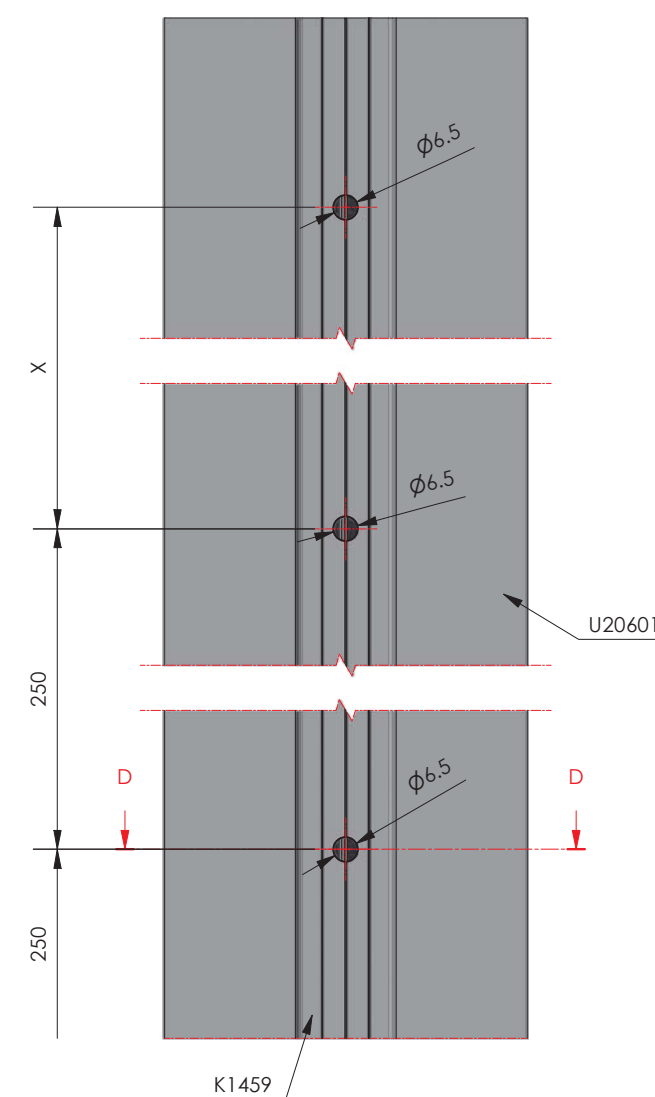
C67K	C77K	C77K-CS
●	●	●

RINFORZO COLONNINA K1452
 K1452 COLUMN REINFORCEMENT



X - AUMENTARE LA FREQUENZA DELLE VITI NEI
 TRATTI TERMINALI
 X - INCREASE THE FREQUENCY OF THE SCREWS
 NEAR THE ENDS OF THE PROFILES

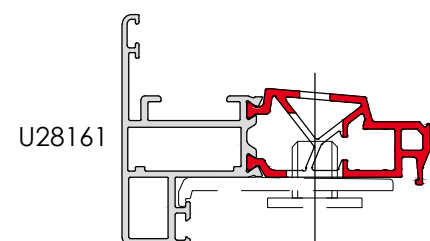
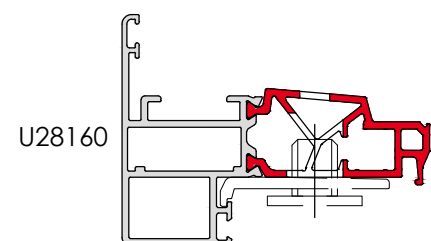
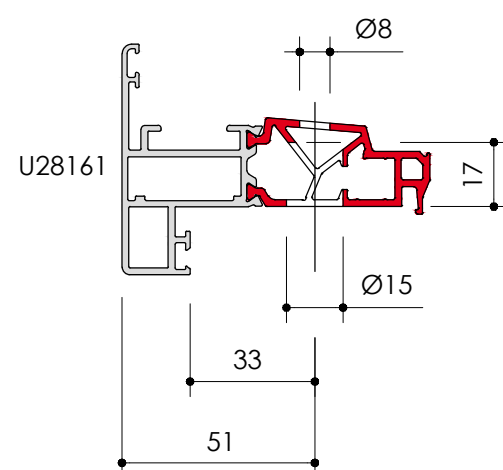
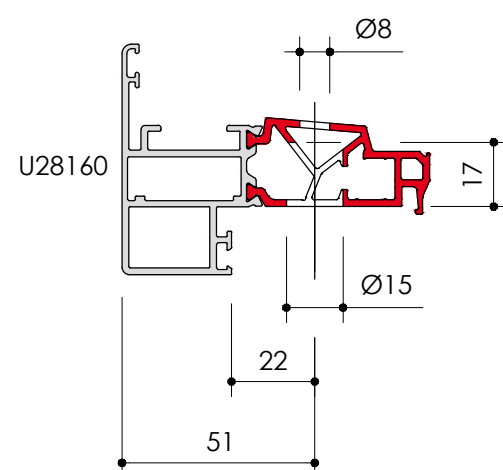
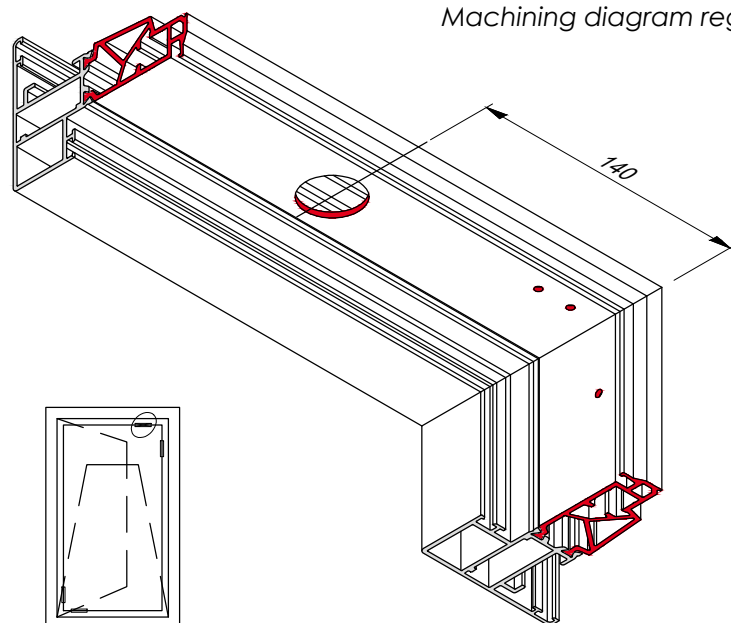
RINFORZO COLONNINA K1459
 K1459 COLUMN REINFORCEMENT



➤ LAVORAZIONE PER TASSELLO REGOLATORE E PROFILO GOCCIOLATOIO
REGULATOR CLEAT AND WEATHER BAR MACHININGS DIAGRAM

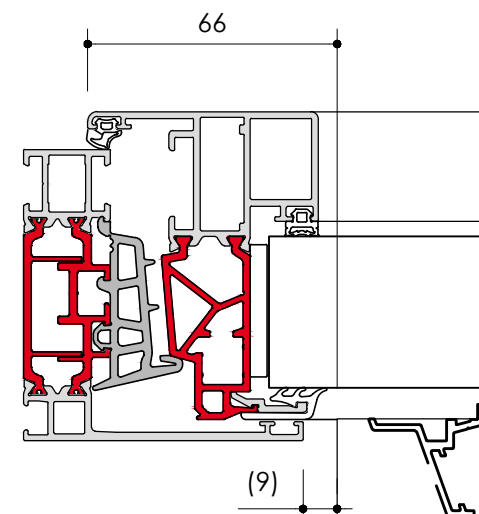
C67K	C77K	C77K-CS
		●

Lavorazione per montaggio
tassello regolatore
Machining diagram regulator cleats

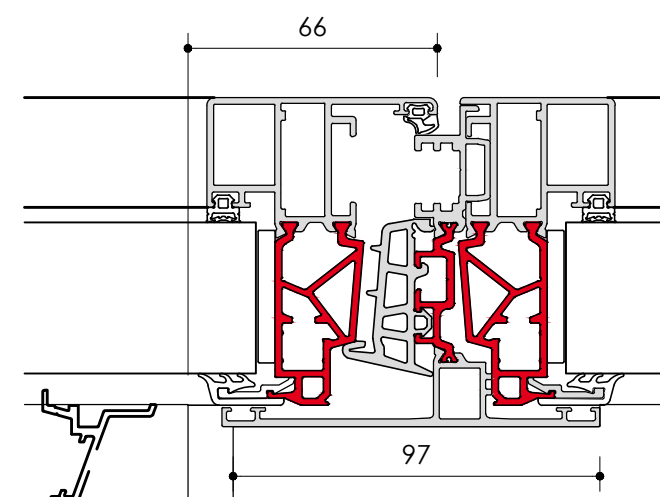


Lavorazione gocciolatoio
Machining weather bar

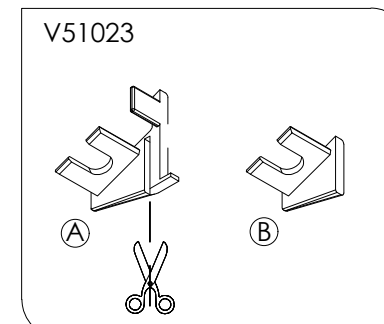
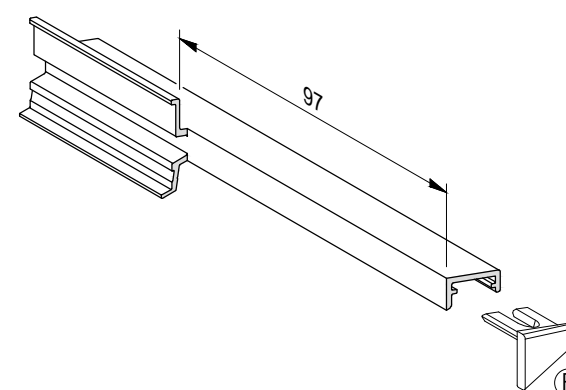
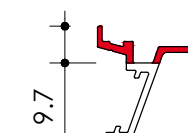
Lato stipite
Frame side



Nodo centrale
Central node

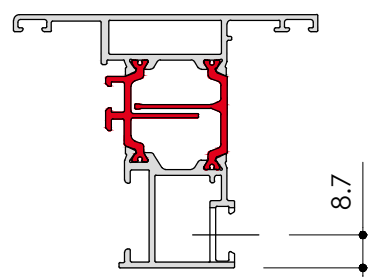
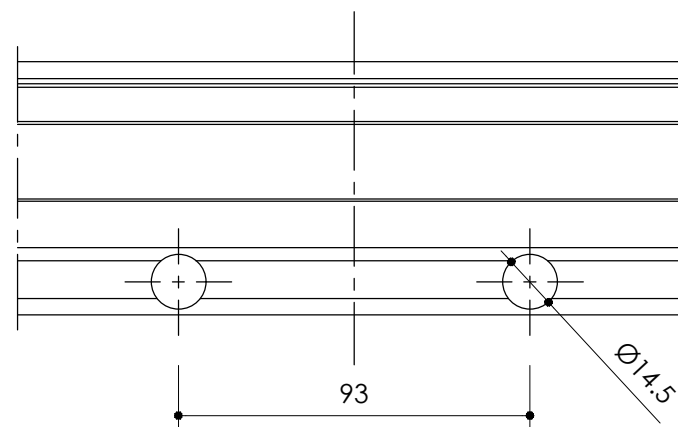
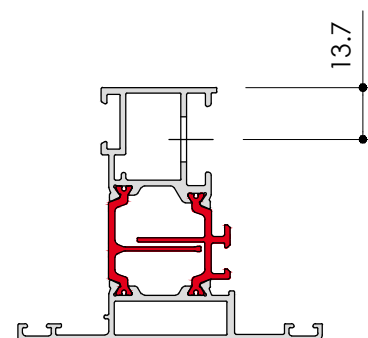
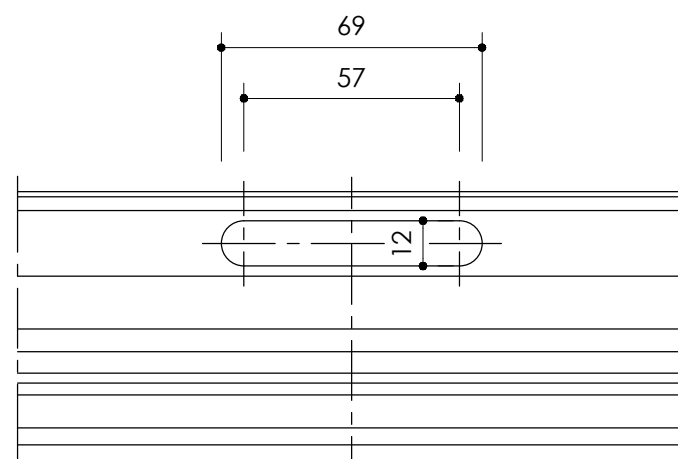
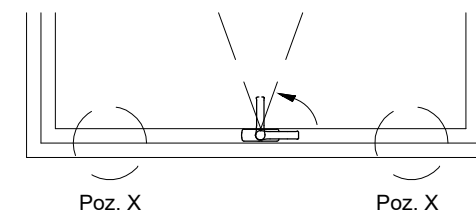
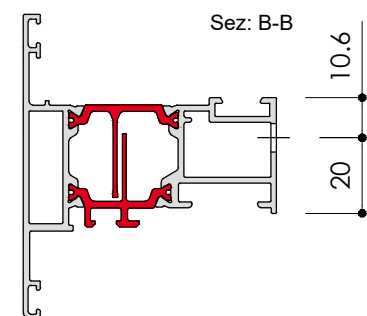
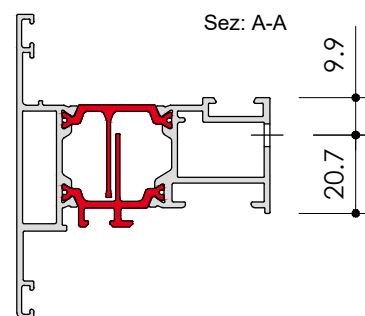
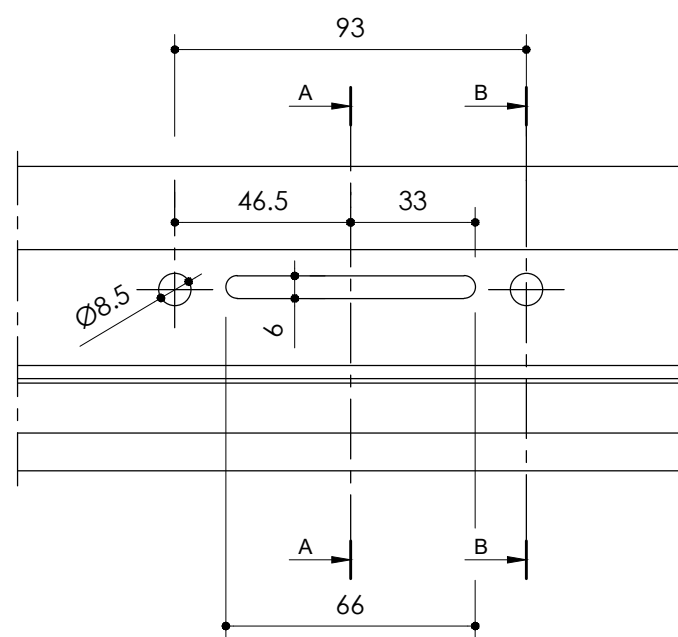


Parte da asportare
Part to be removed

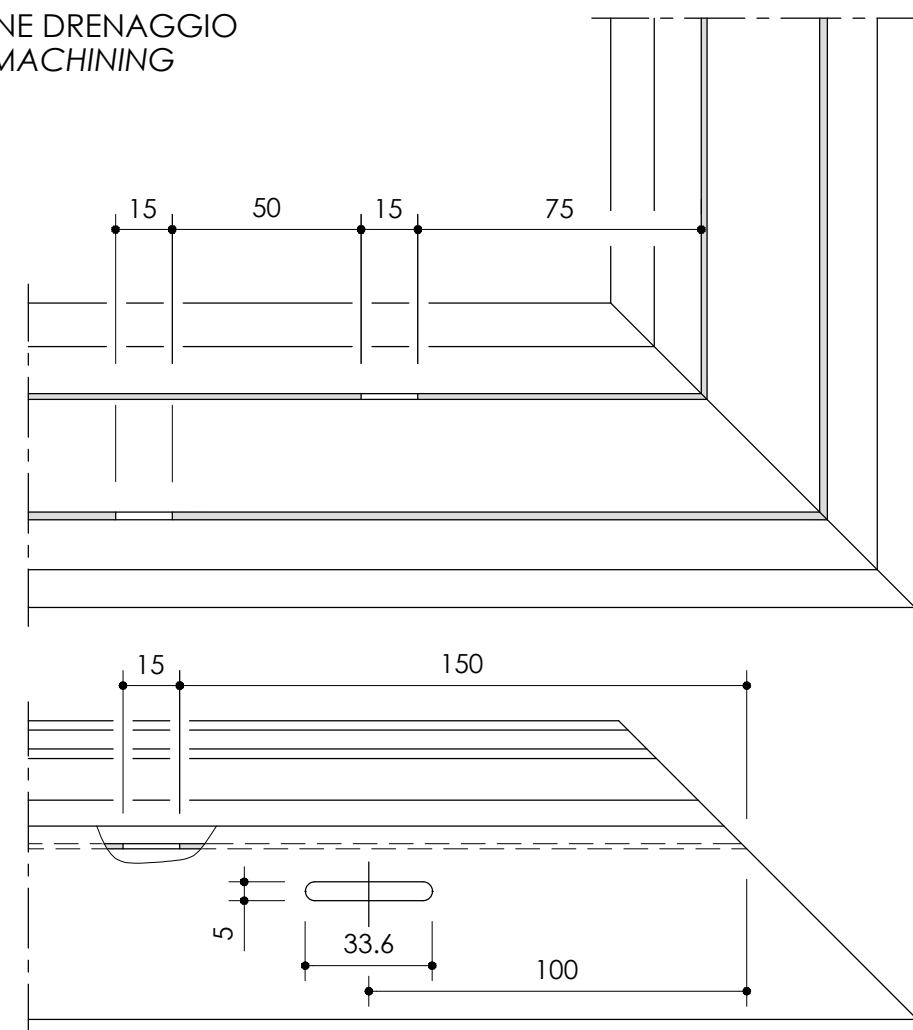
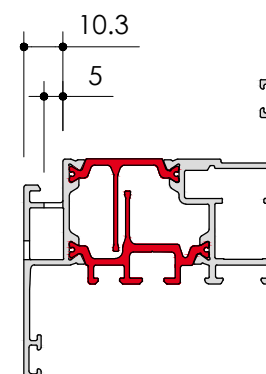
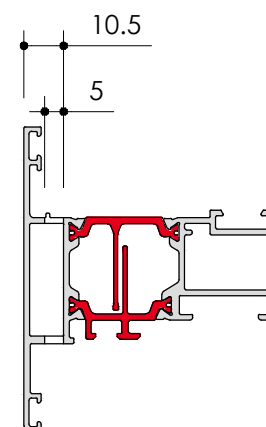


LAVORAZIONE PER MONTAGGIO CREMONESE SPORGERE
MACHINING FOR HANDLE PROJECTING WINDOW

C67K	C77K	C77K-CS
●		

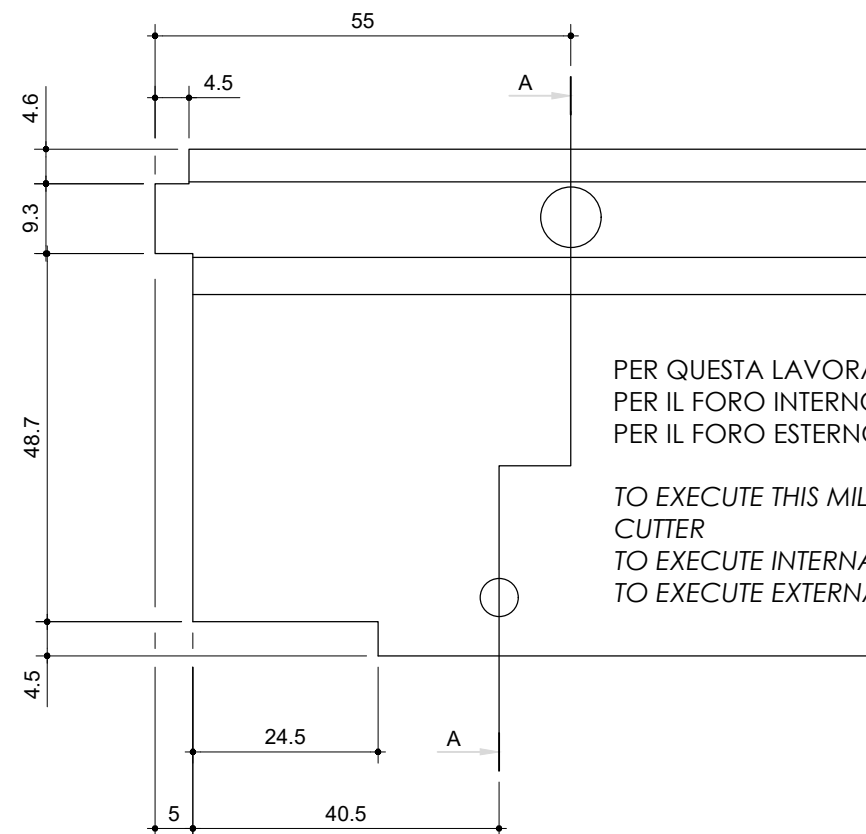
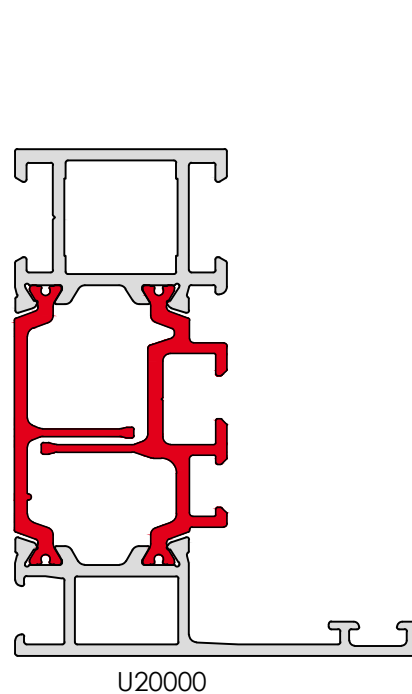


POS. X - LAVORAZIONE DRENAGGIO
 POS. X - DRAINAGE MACHINING



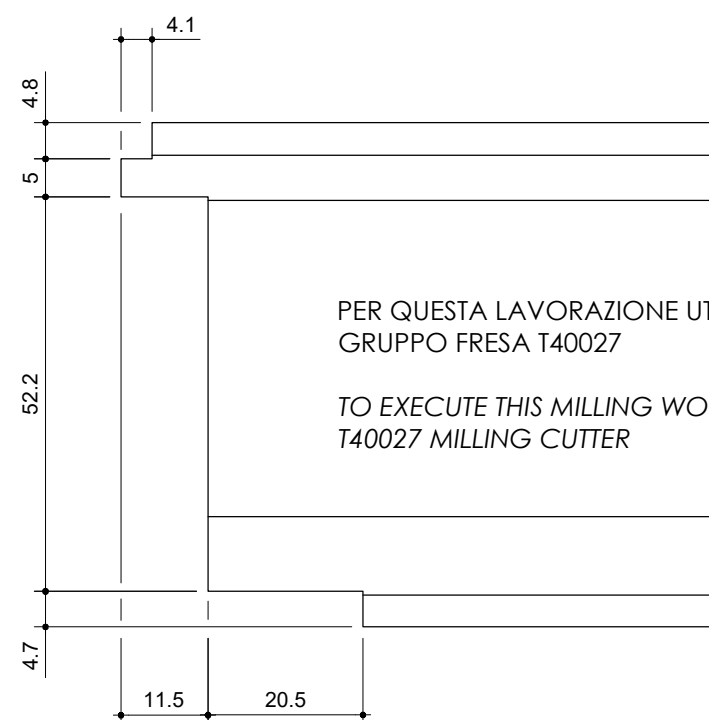
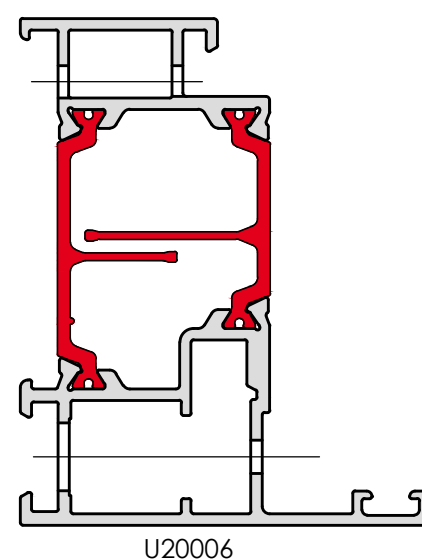
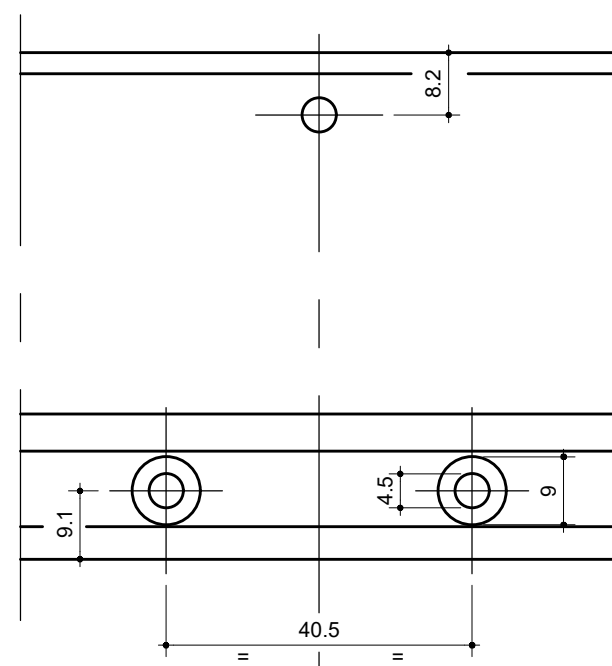
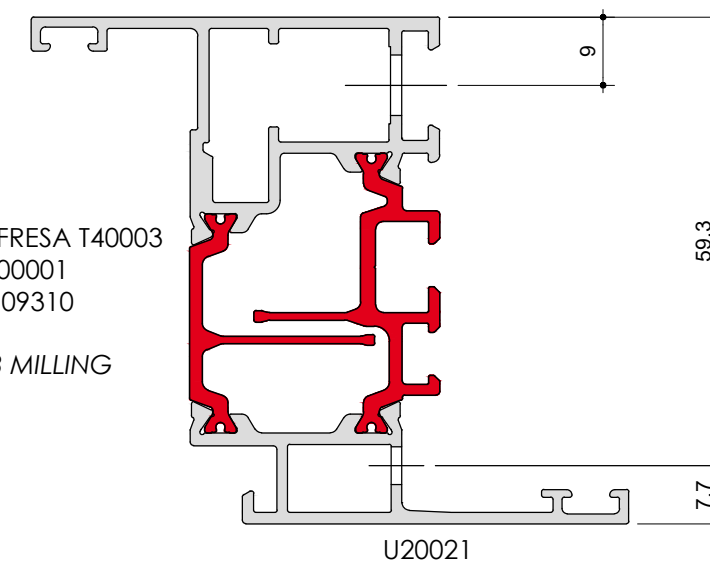
➤ LAVORAZIONE PER CONNESSIONE TRAVESO STIPITE SPORGERE
FIXED FRAME AND TRANSOM CONNECTION DIAGRAM

C67K	C77K	C77K-CS
●		



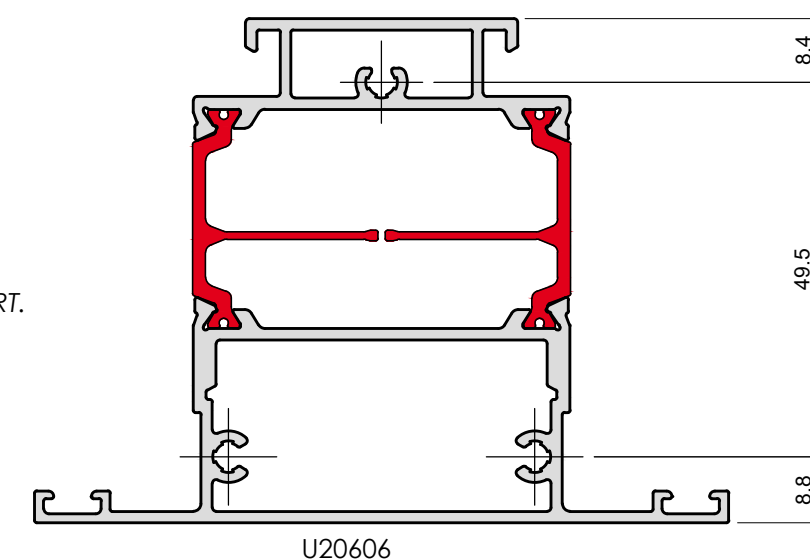
PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA T40003
PER IL FORO INTERNO USARE TRANCIANTE ART. T00001
PER IL FORO ESTERNO USARE TRANCIANTE ART. 909310

TO EXECUTE THIS MILLING WORK USE ART. T40003 MILLING CUTTER
TO EXECUTE INTERNAL HOLE USE ART. T00001
TO EXECUTE EXTERNAL HOLE USE ART. 909310



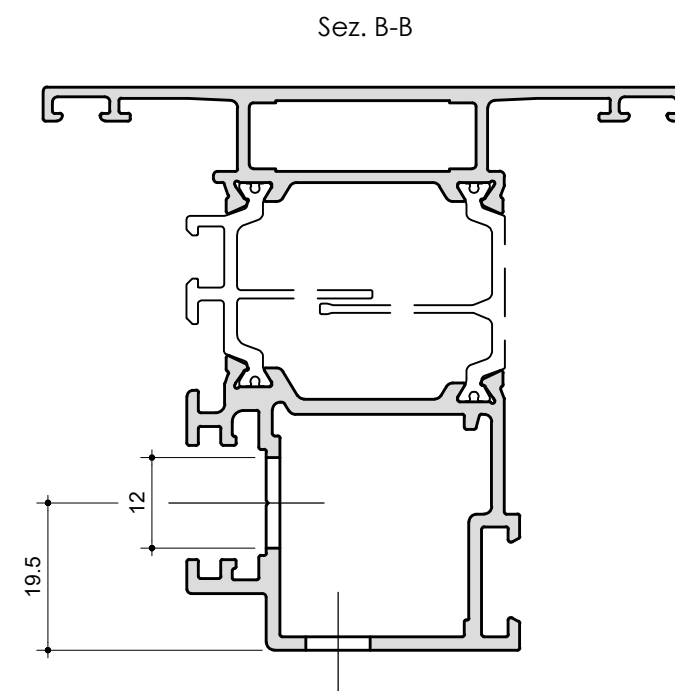
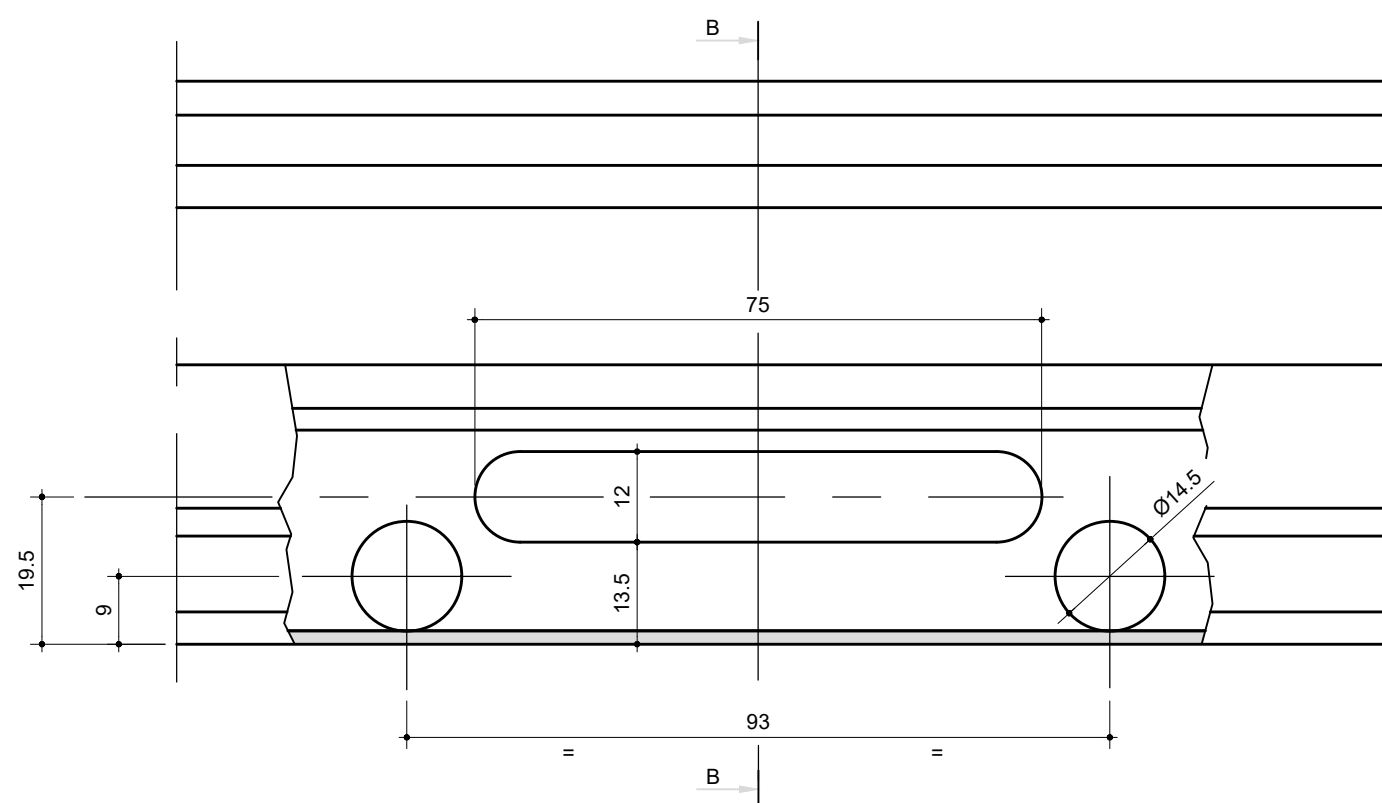
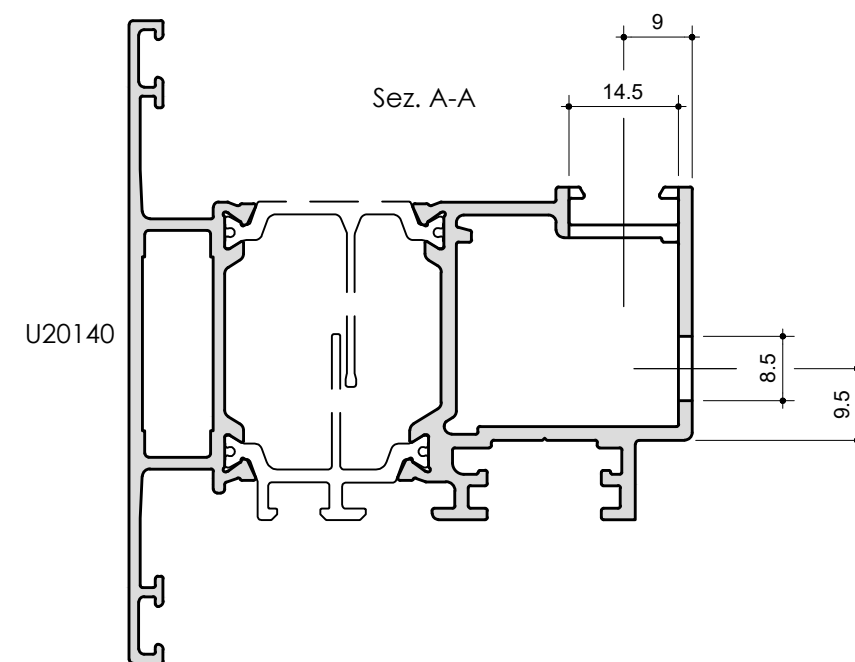
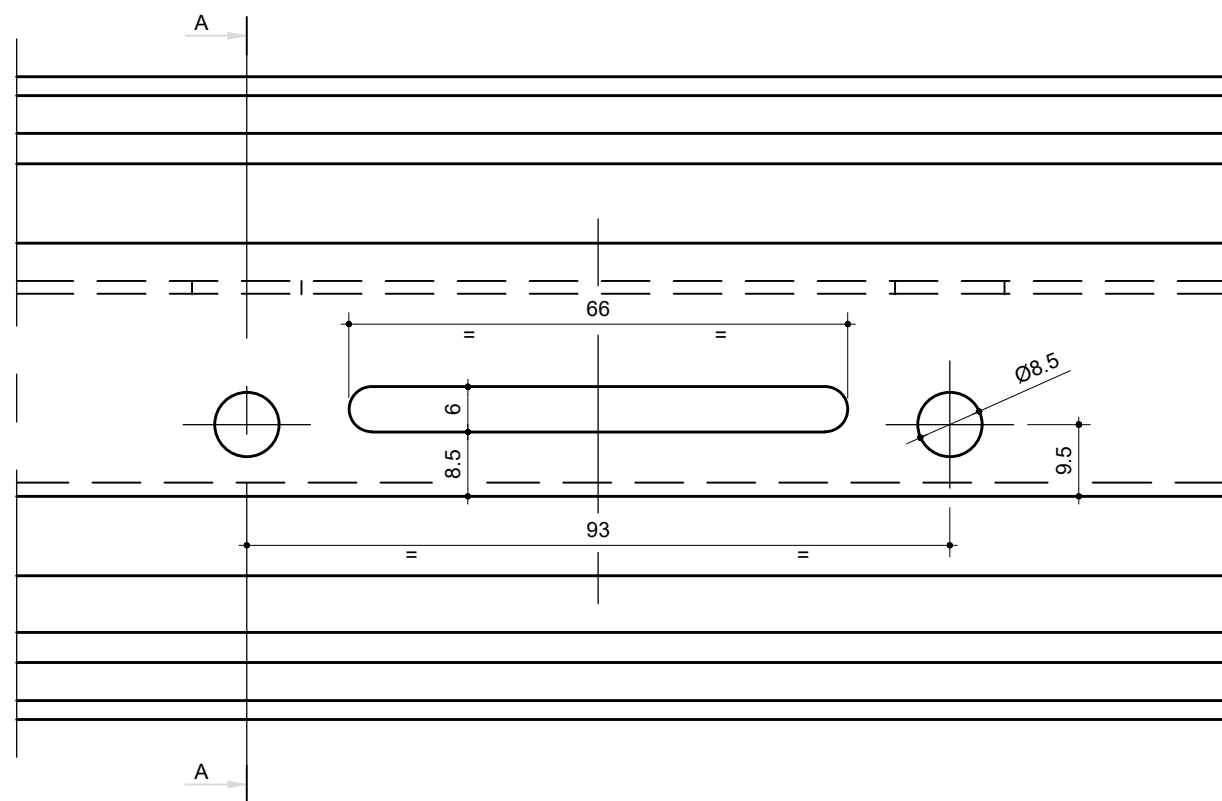
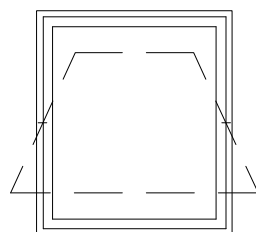
PER QUESTA LAVORAZIONE UTILIZZARE GRUPPO FRESA T40027

TO EXECUTE THIS MILLING WORK USE ART. T40027 MILLING CUTTER



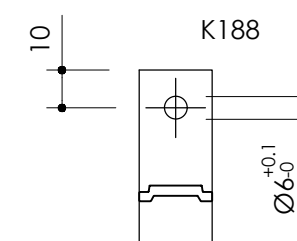
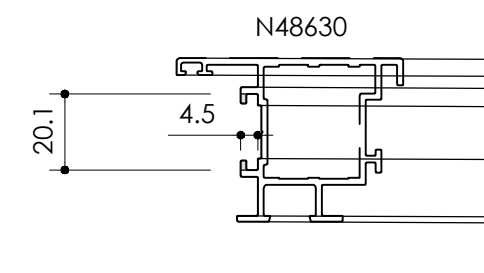
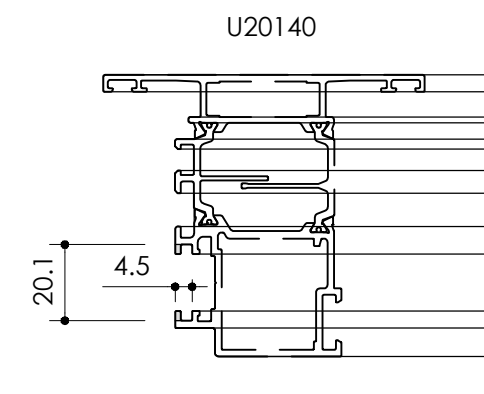
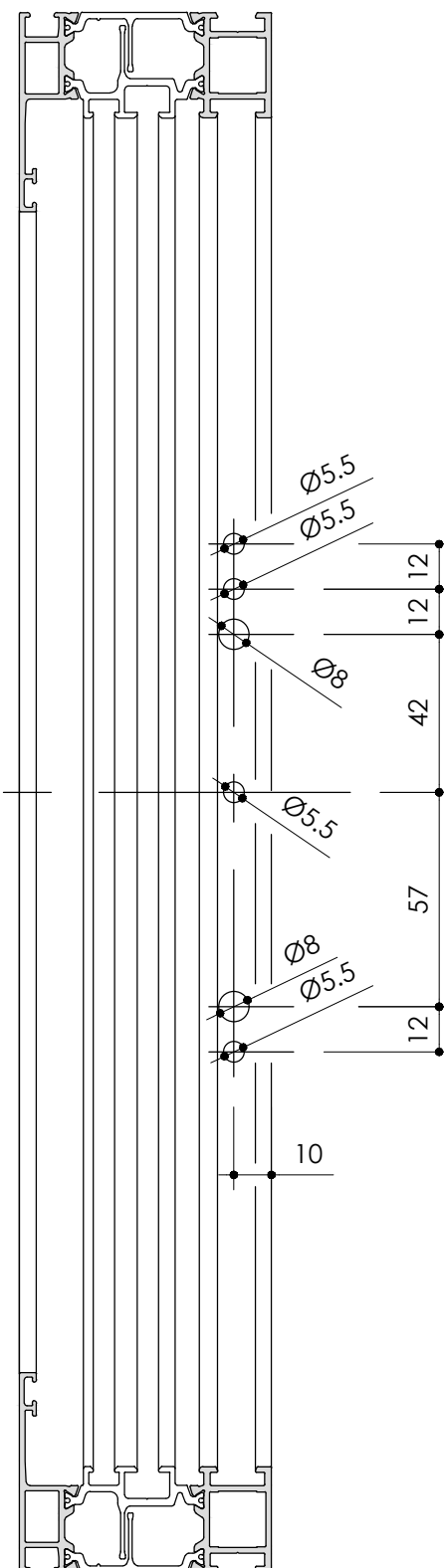
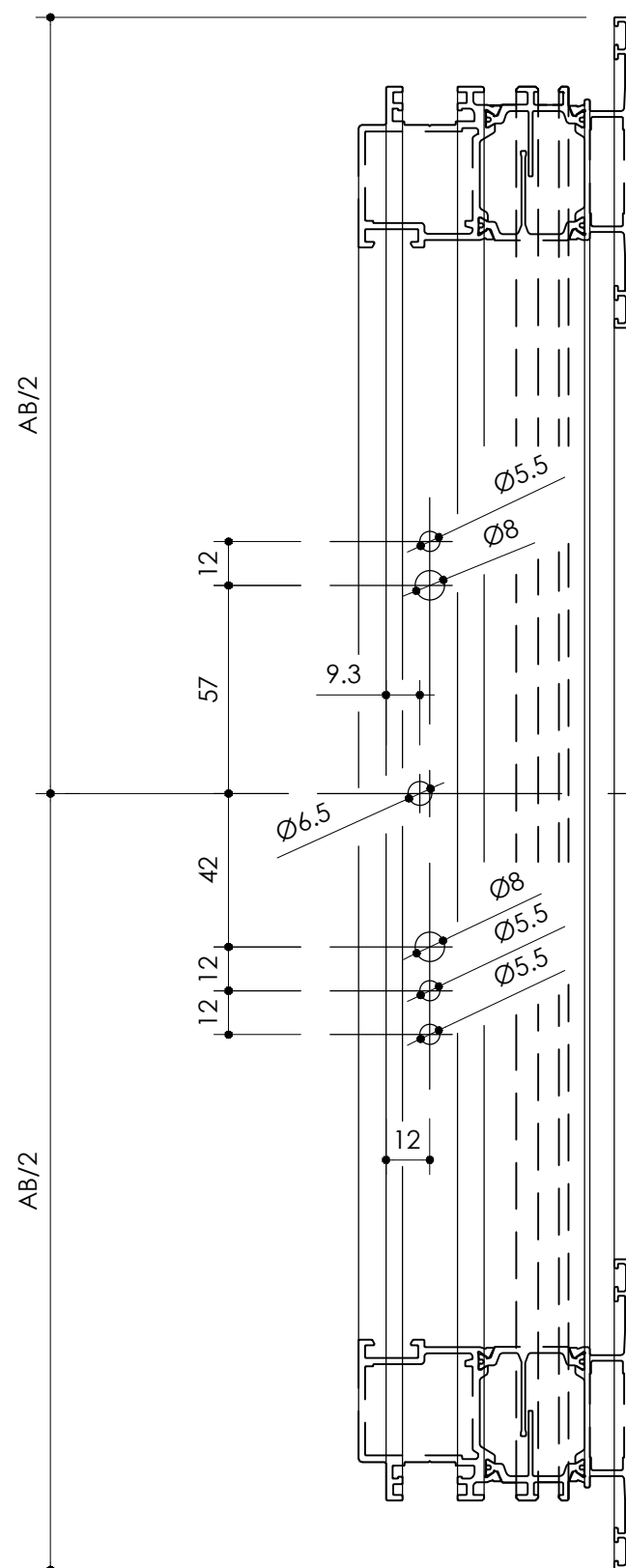
LAVORAZIONE PER MONTAGGIO MANIGLIA PER BILICO ORIZZONTALE
MACHINING FOR HANDLE ASSEMBLY FOR HORIZONTAL PIVOT WINDOW

C67K	C77K	C77K-CS
●		



LAVORAZIONI MONTAGGIO FRIZIONI ART. 71912X PER BILICO ORIZZONTALE
 HORIZONTAL PIVOTING WINDOW COD. 71912X PIVOT COUPLE MACHINING ASSEMBLING

C67K	C77K	C77K-CS
●		

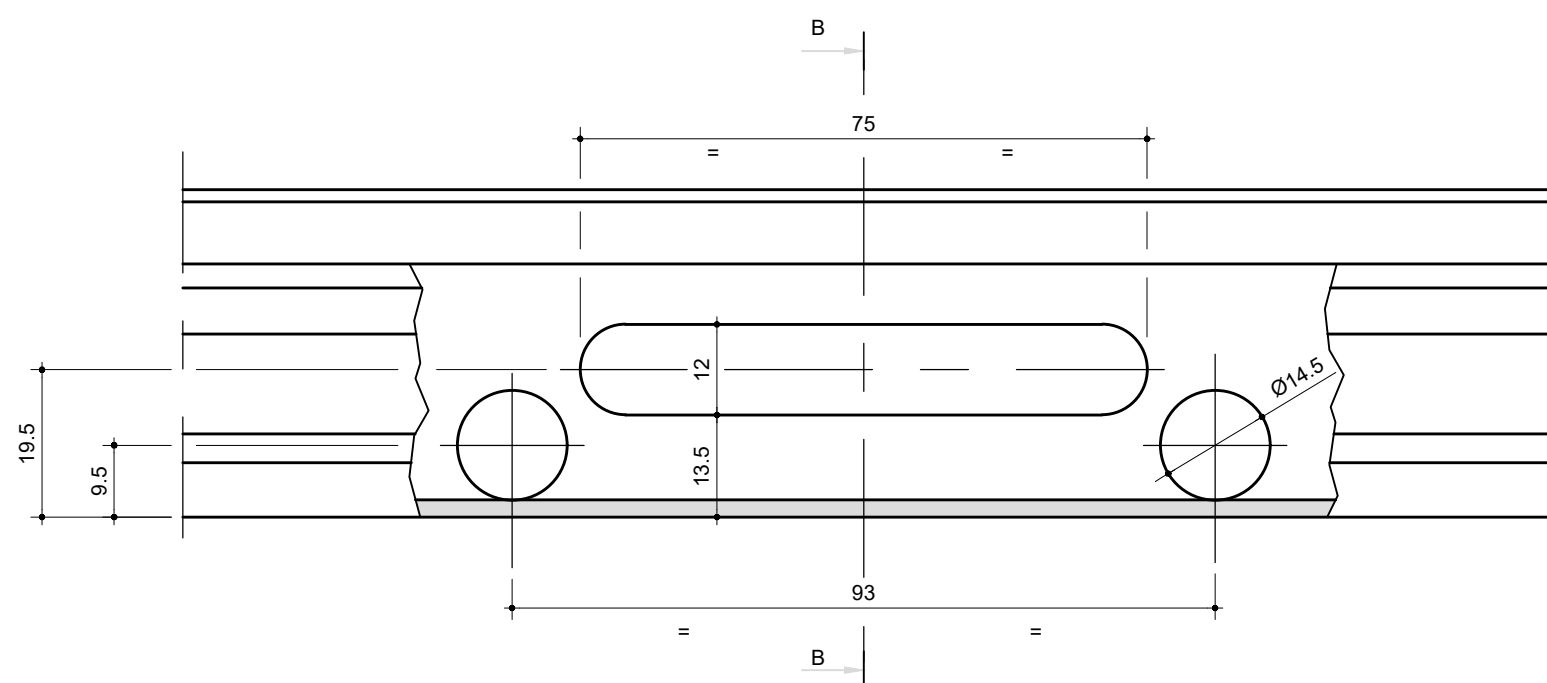
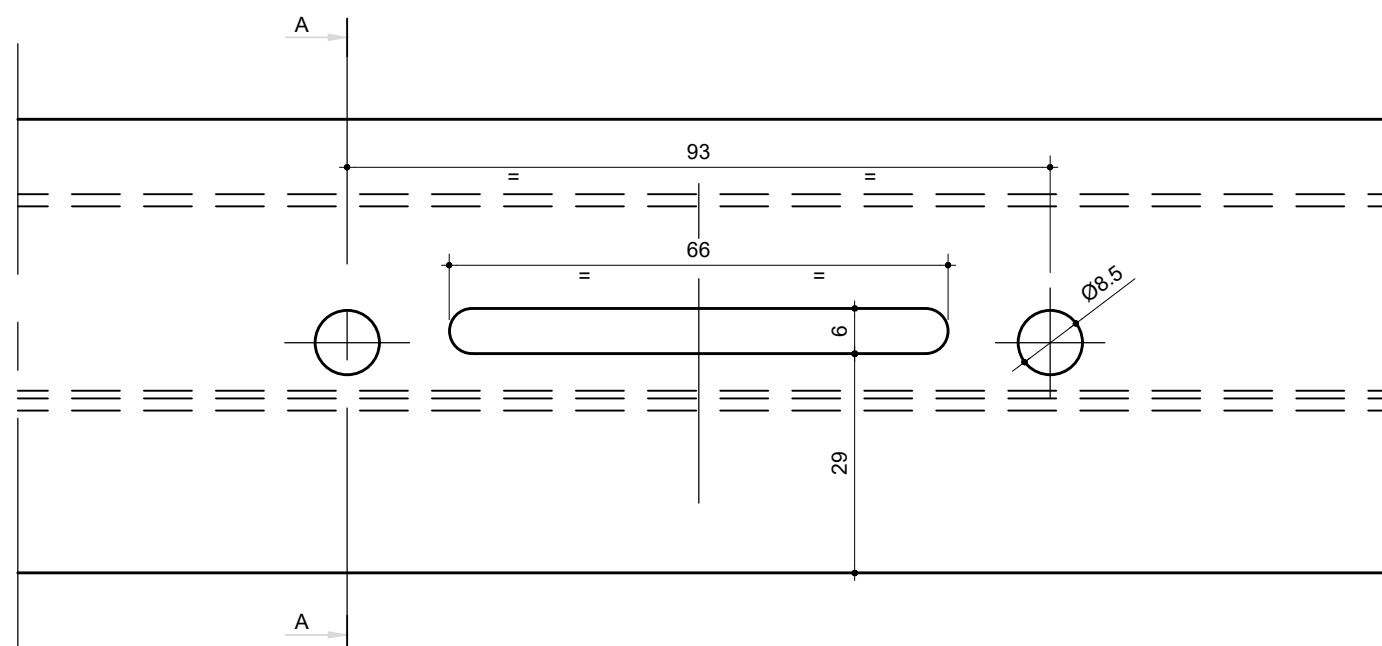
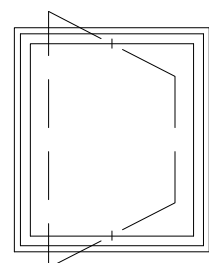


PER ESEGUIRE QUESTE LAVORAZIONI UTILIZZARE
TRANCIANTE ART. 909310

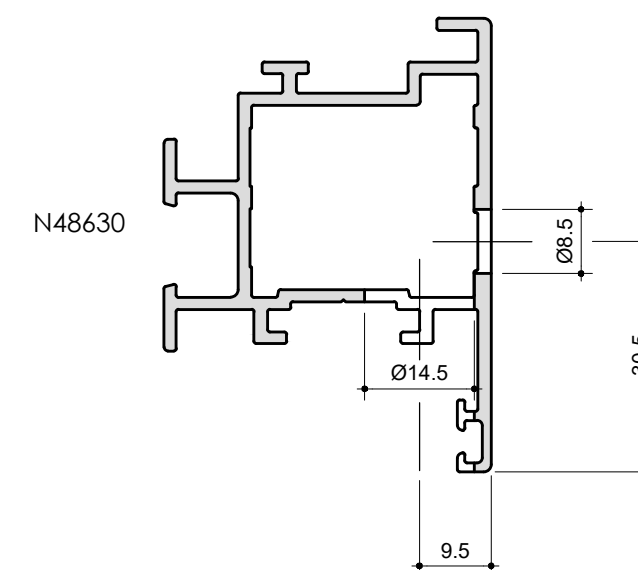
TO EXECUTE THIS CUTTING OUT USE ART. 909310
BLANKING MACHINE

▶ LAVORAZIONE PER MONTAGGIO MANIGLIA PER BILICO VERTICALE
 MACHINING FOR HANDLE ASSEMBLY FOR VERTICAL PIVOT WINDOW

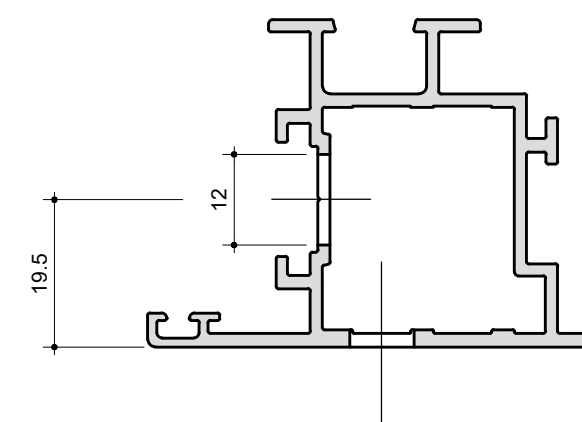
C67K	C77K	C77K-CS
●		



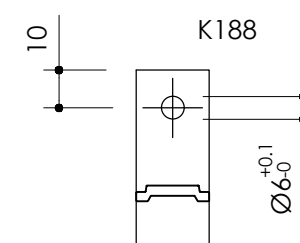
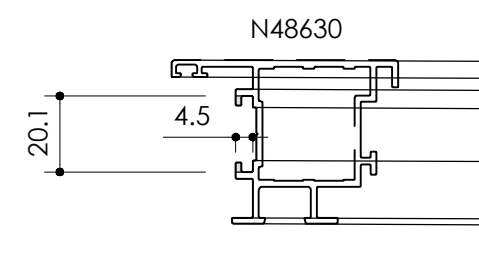
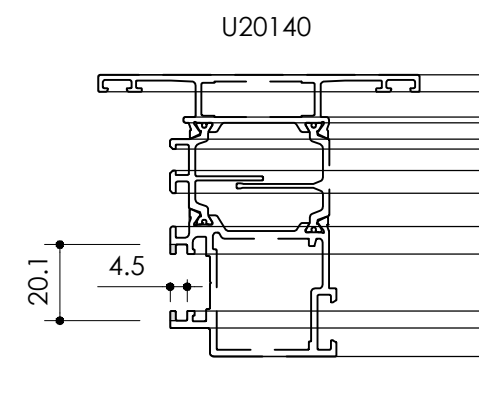
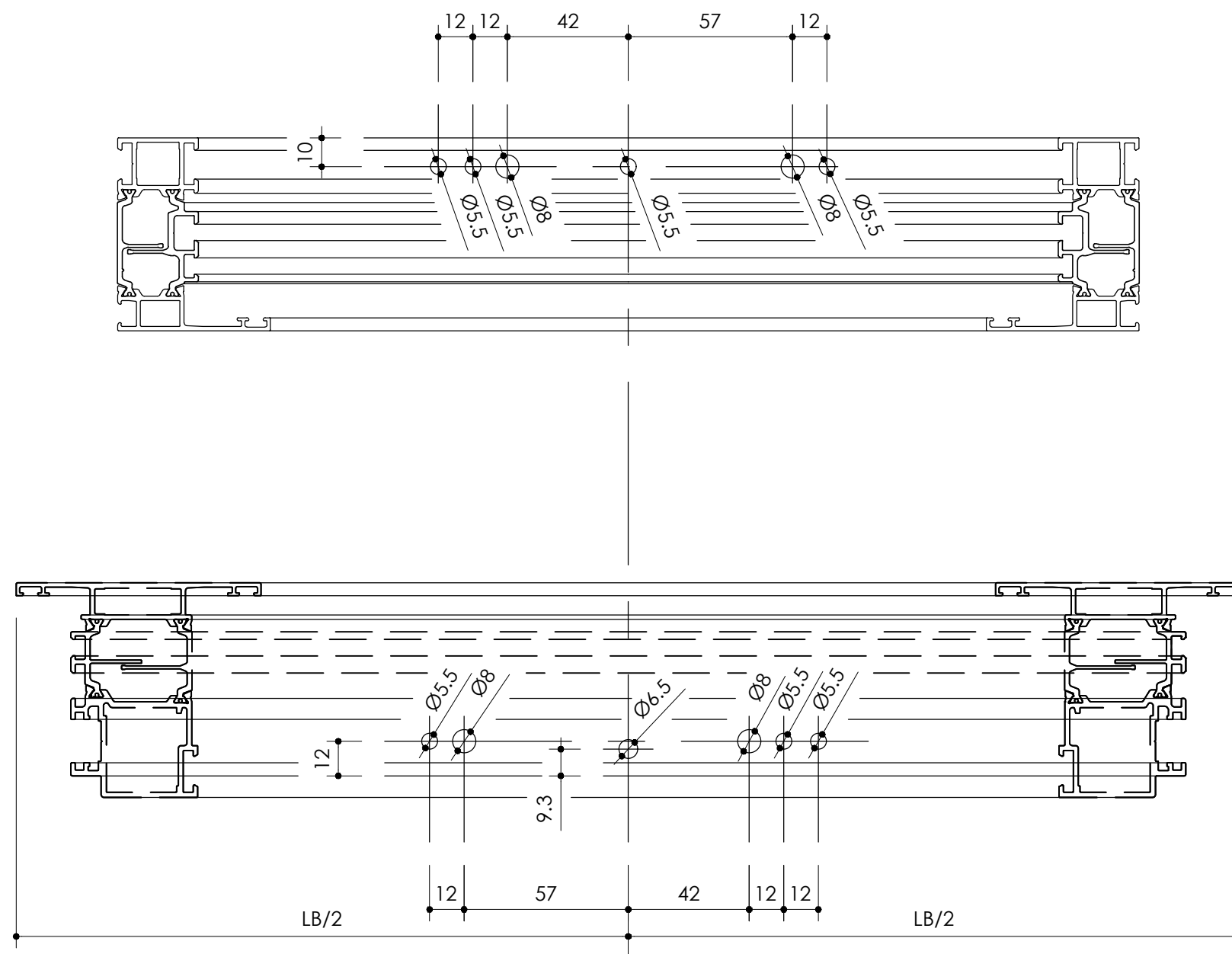
Sez. A-A



Sez. B-B



▶ LAVORAZIONI MONTAGGIO FRIZIONI ART. 71914X PER BILICO VERTICALE
 VERTICAL PIVOTING WINDOW COD. 71914X PIVOT COUPLE MACHINING DIAGRAM

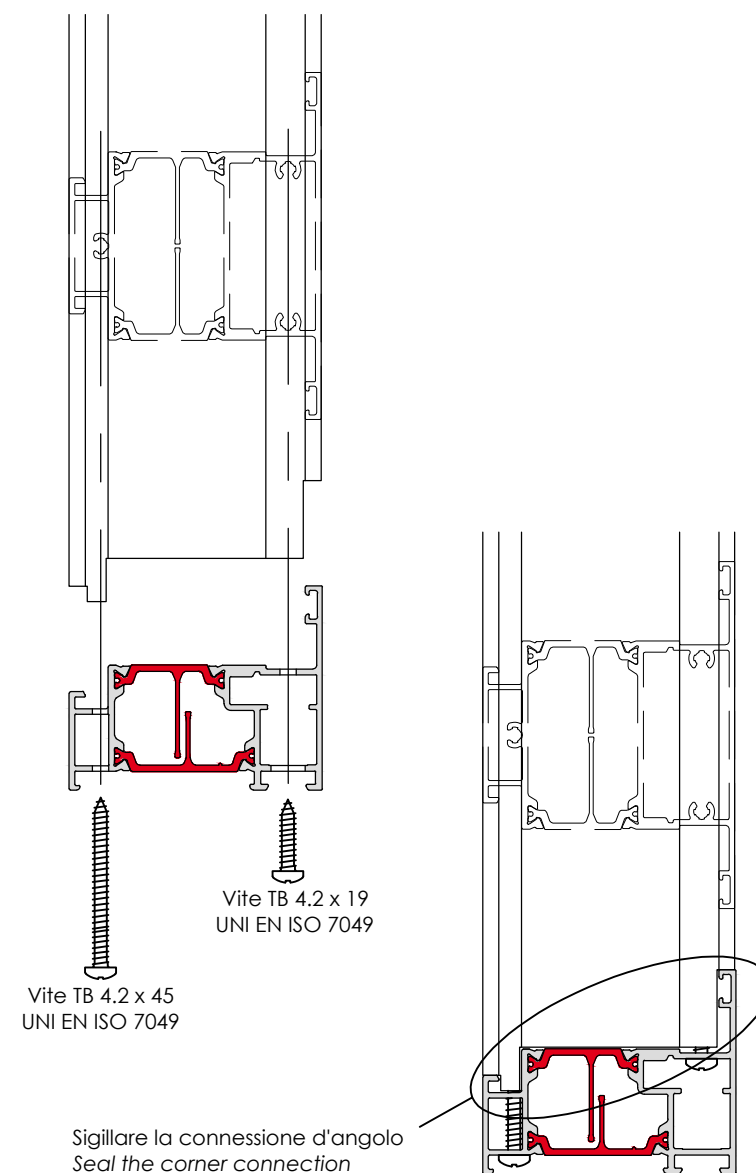
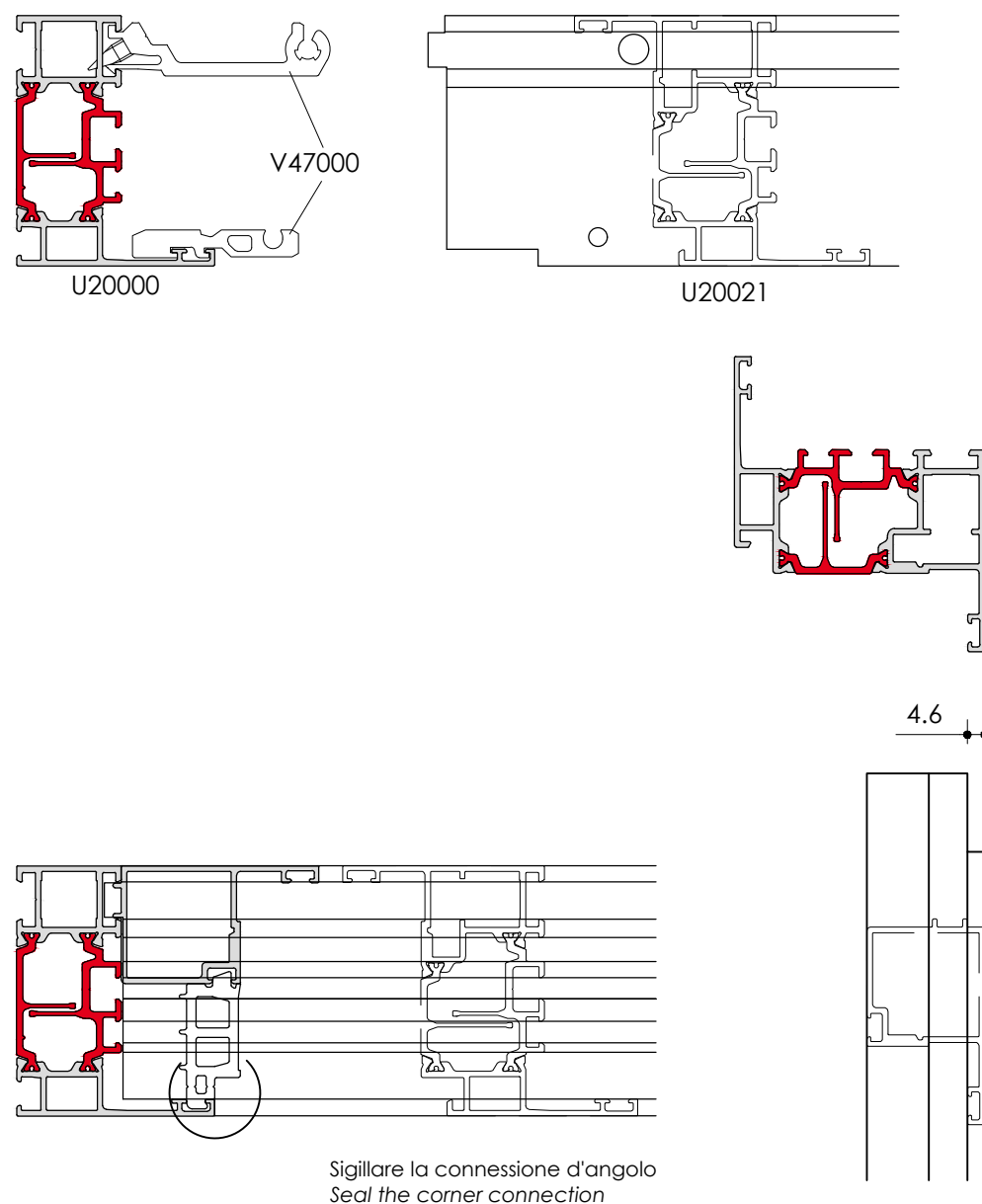
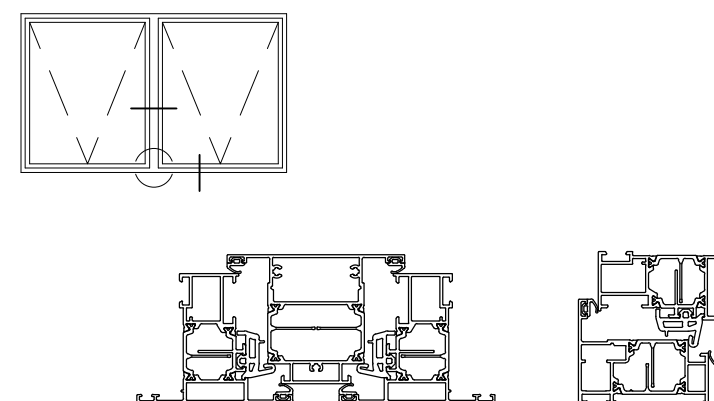
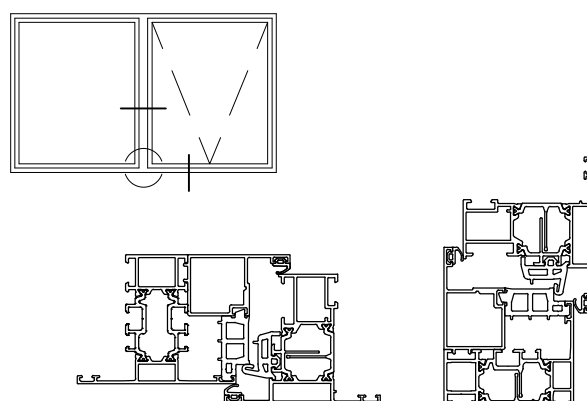
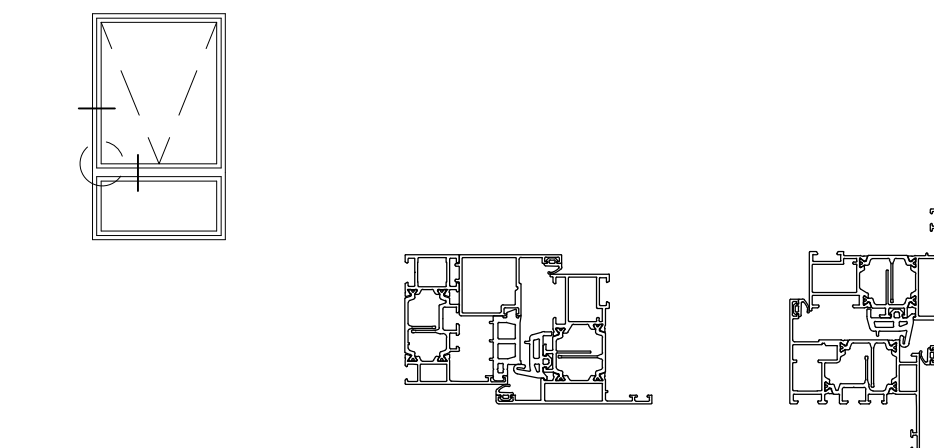


PER ESEGUIRE QUESTE LAVORAZIONI UTILIZZARE
 TRACIANTE ART. 909310

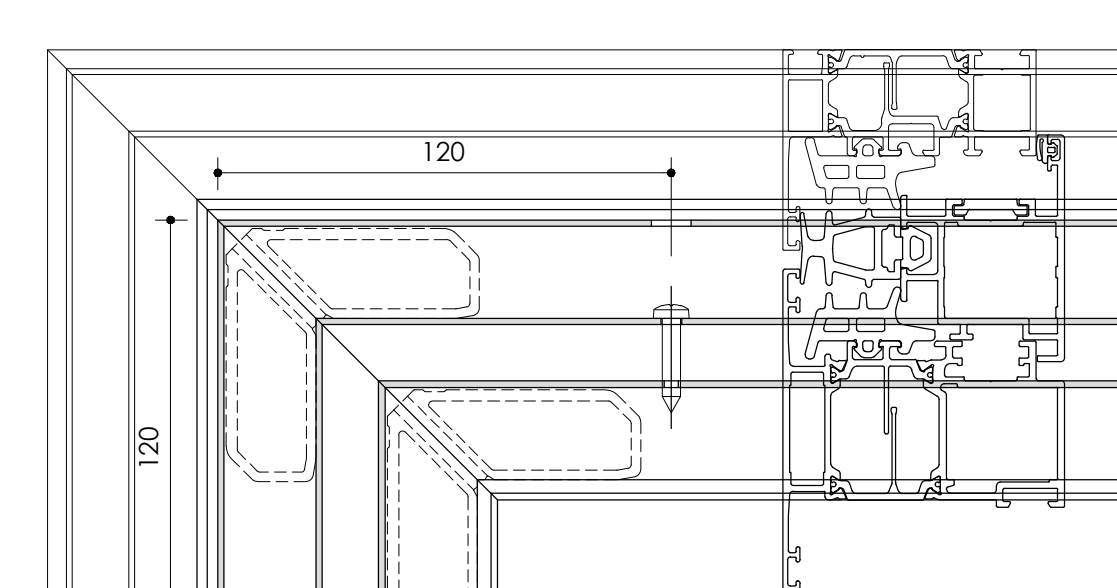
TO EXECUTE THIS CUTTING OUT USE ART. 909310
 BLANKING MACHINE

➤ SCHEMA DI MONTAGGIO PER CONNESSIONE TRAVERSO STIPITE
ASSEMBLY DIAGRAM FOR CONNECTION OF THE CROSS JAMB

C67K	C77K	C77K-CS
●		

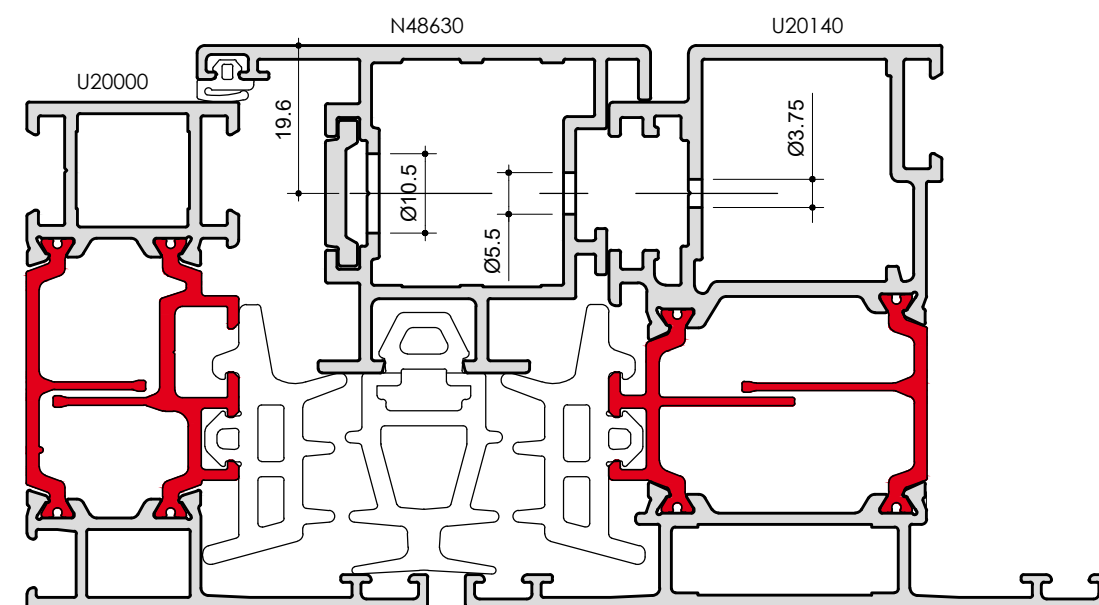
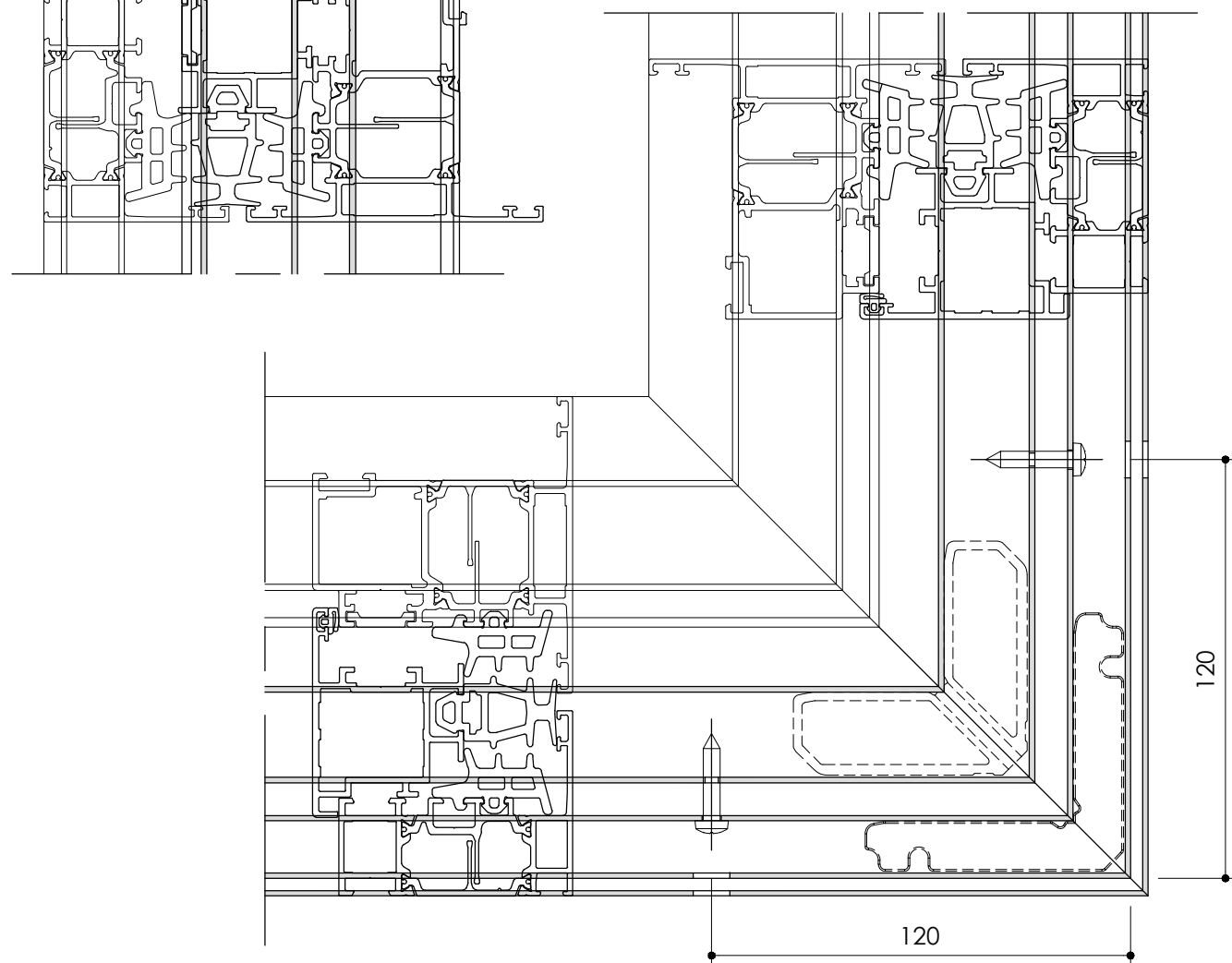


➤ SCHEMA DI FISSAGGIO PROFILO AGGIUNTIVO N48630
N48630 ADDITIONAL PROFILE FIXING DIAGRAM



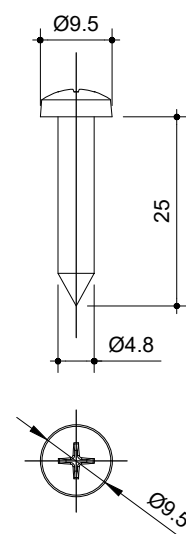
SCALA 1:2
SCALE 1:2

INTERASSE FISSAGGI OGNI 250 mm
DISTANCE OF FIXINGS EVERY 250 mm

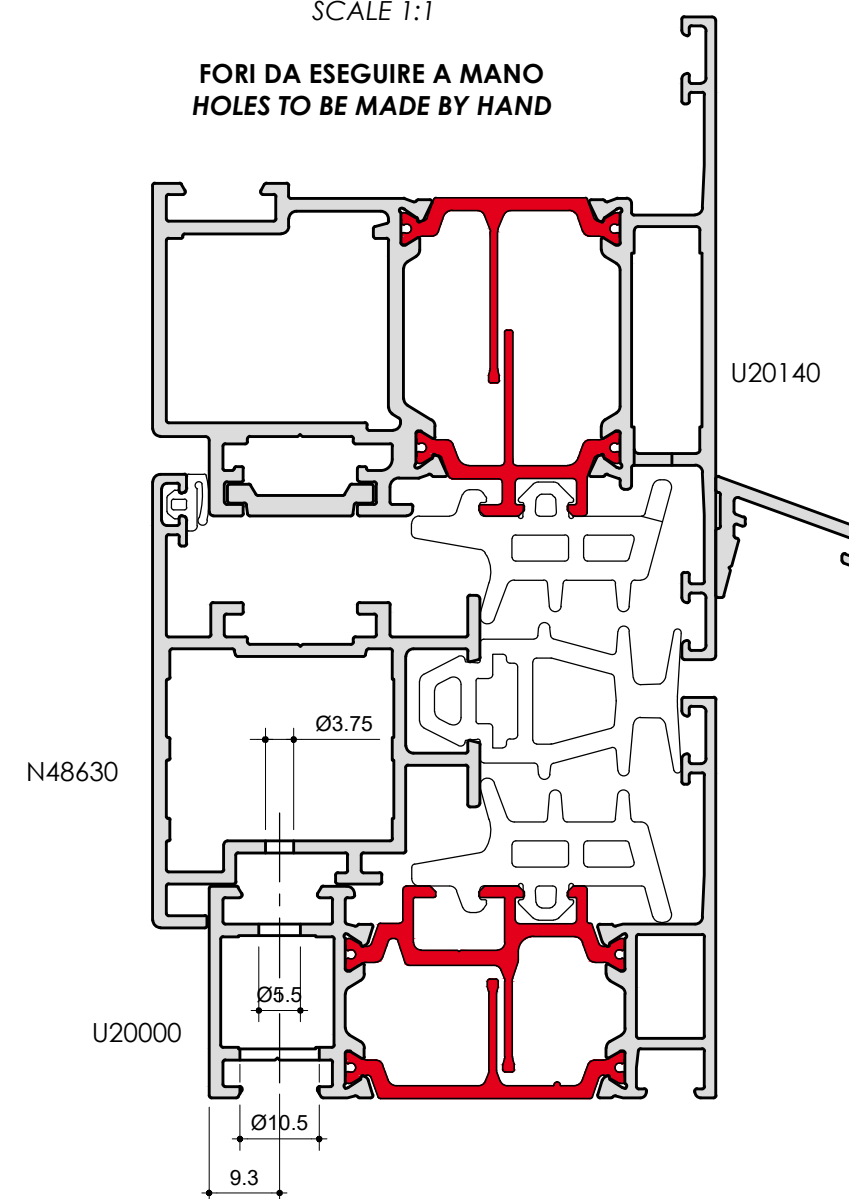


SCALA 1:1
SCALE 1:1

VITE 4.8x25
UNI EN ISO 7049



FORI DA ESEGUIRE A MANO
HOLES TO BE MADE BY HAND



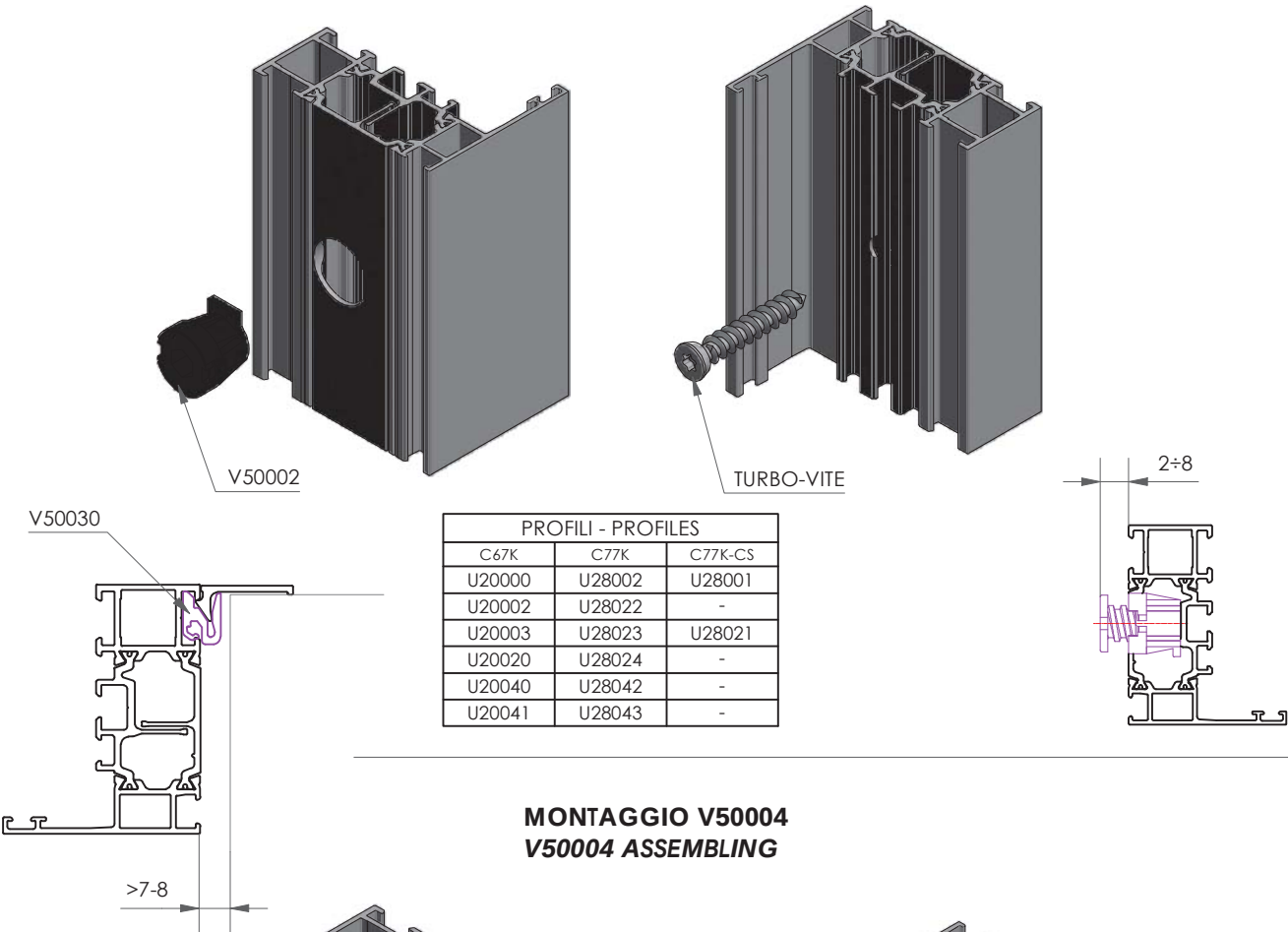
Section 10

Assemblaggio

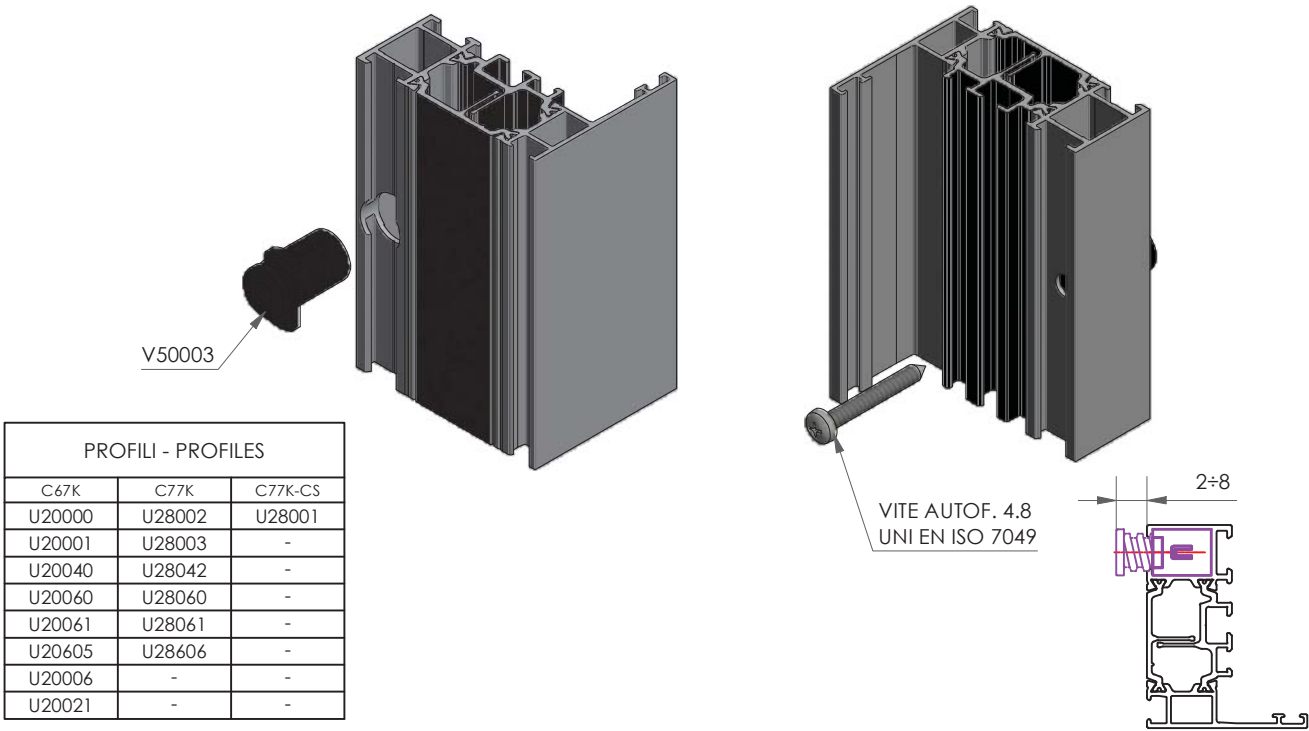
Assembly

C67K	C77K	C77K-CS
●	●	●

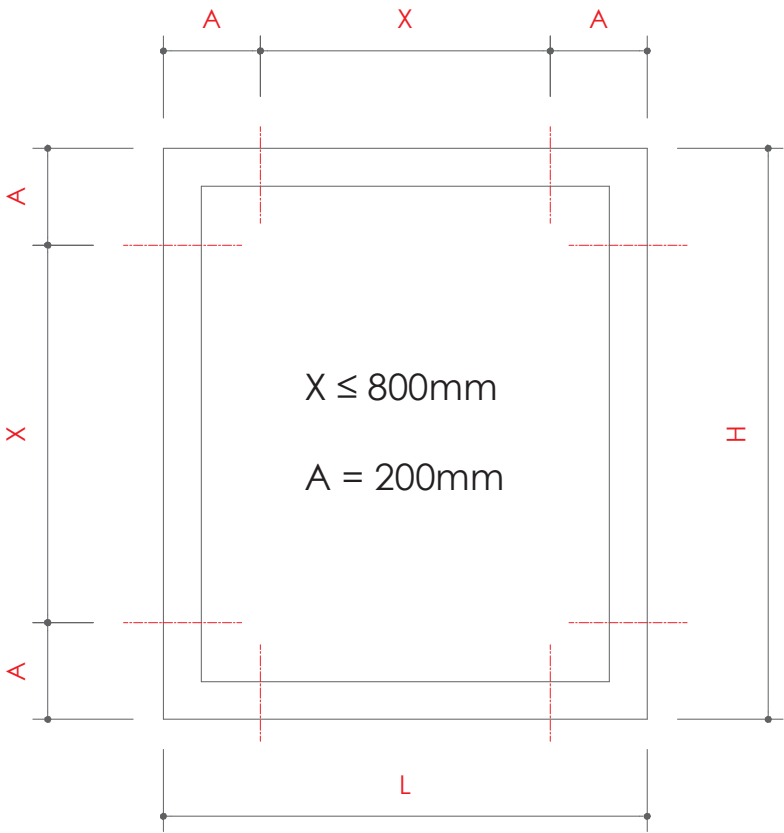
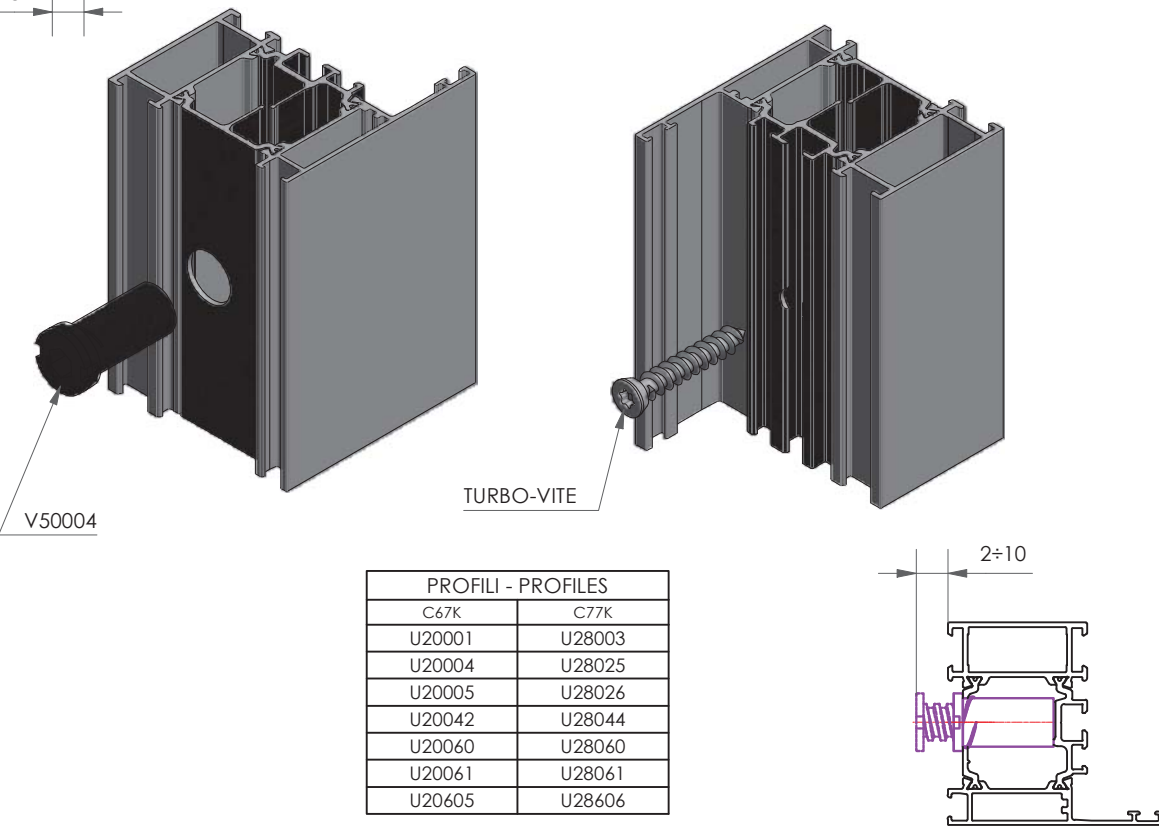
MONTAGGIO V50002
V50002 ASSEMBLING



MONTAGGIO V50003
V50003 ASSEMBLING



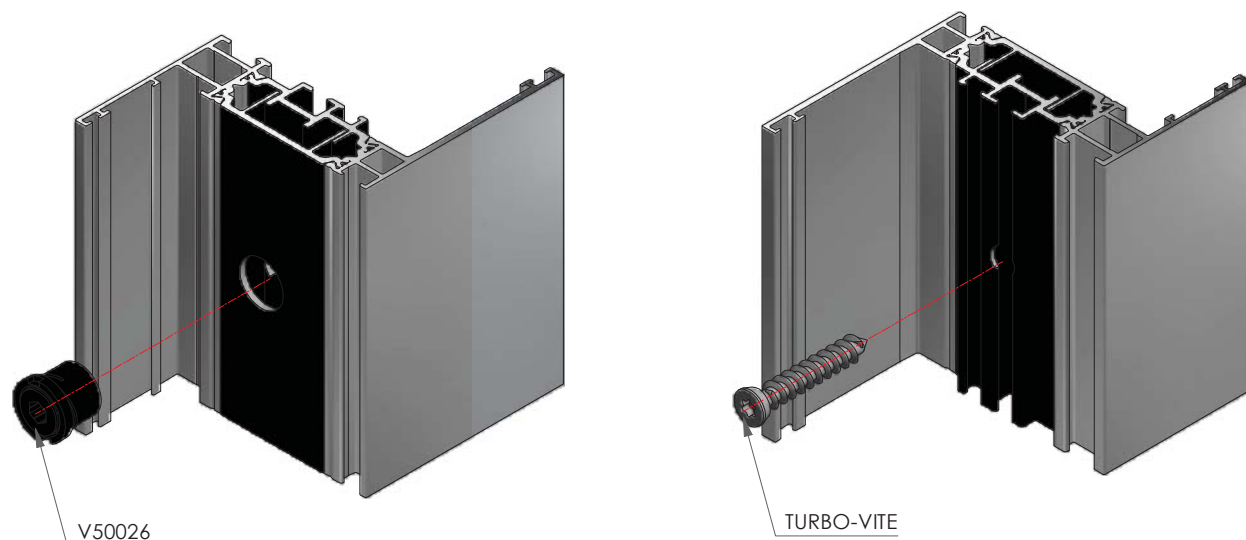
MONTAGGIO V50004
V50004 ASSEMBLING



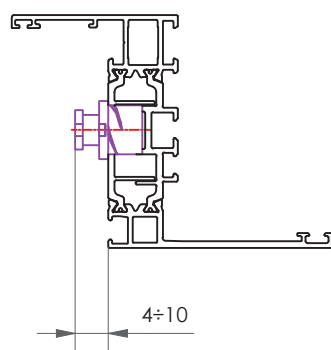
▶ SCHEMA DI MONTAGGIO REGOLATORI ADJUSTING BLOCK ASSEMBLING

C67K	C77K	C77K-CS
		●

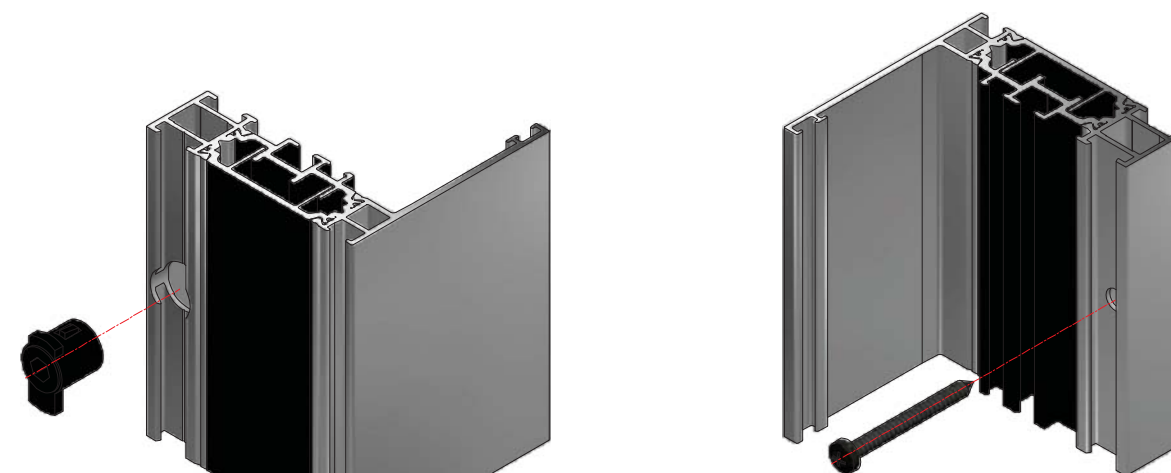
MONTAGGIO V50026
 V50026 ASSEMBLING



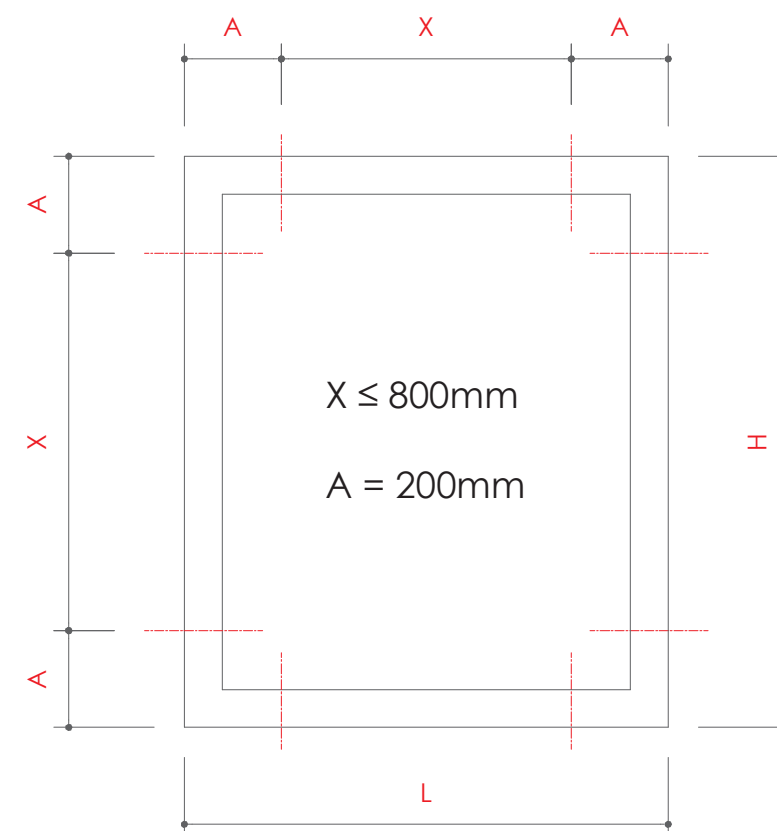
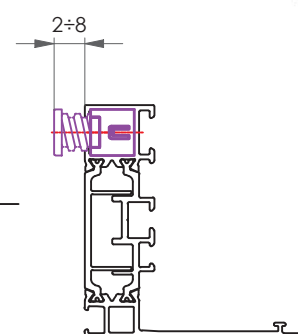
PROFILI - PROFILES
C77K-CS
U28020
U28000



MONTAGGIO V50025
 V50025 ASSEMBLING

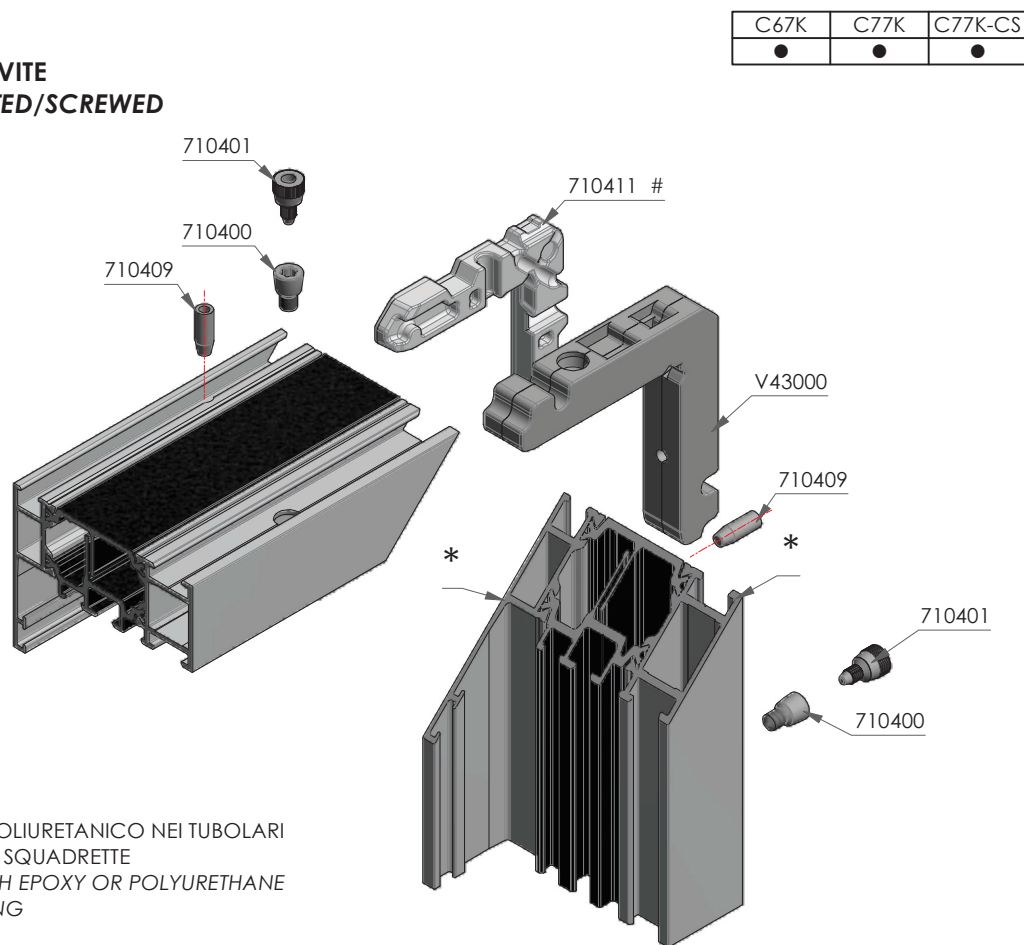


PROFILI - PROFILES
C77K-CS
U28000



▶ SCHEMA DI MONTAGGIO SQUADRETTE STIPITE FIXED FRAME CORNER JOINTS ASSEMBLY

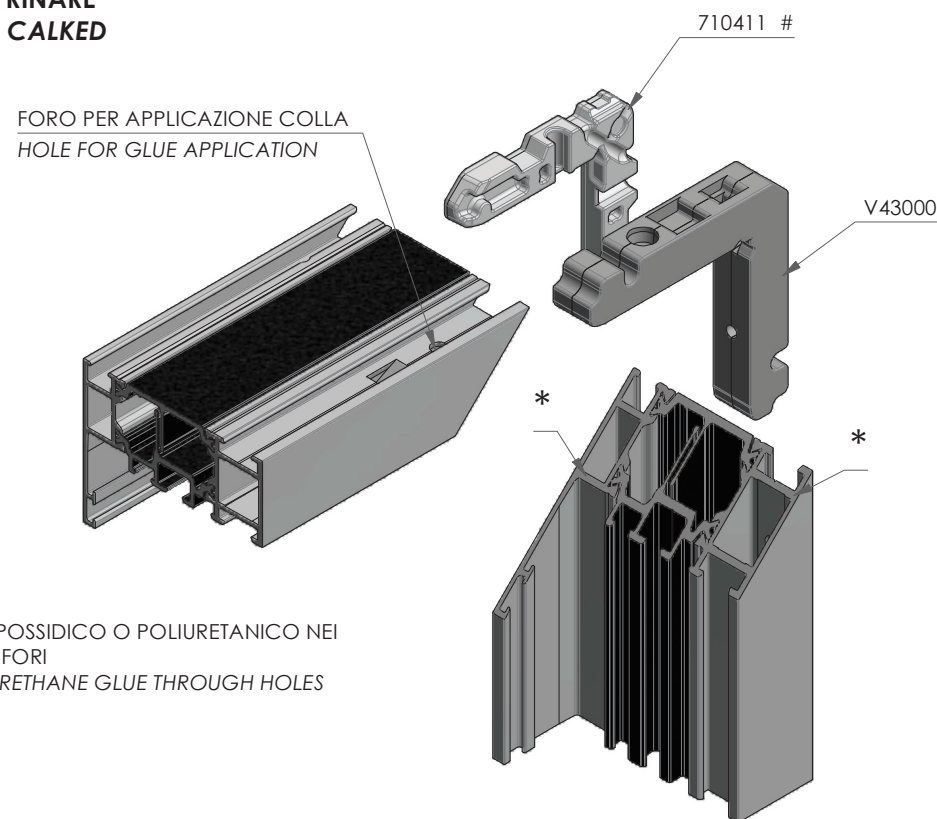
SQUADRETTE A SPINARE/A VITE CORNER JOINT TO BE RIVETED/SCREWED



C67K	C77K	C77K-CS
●	●	●

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

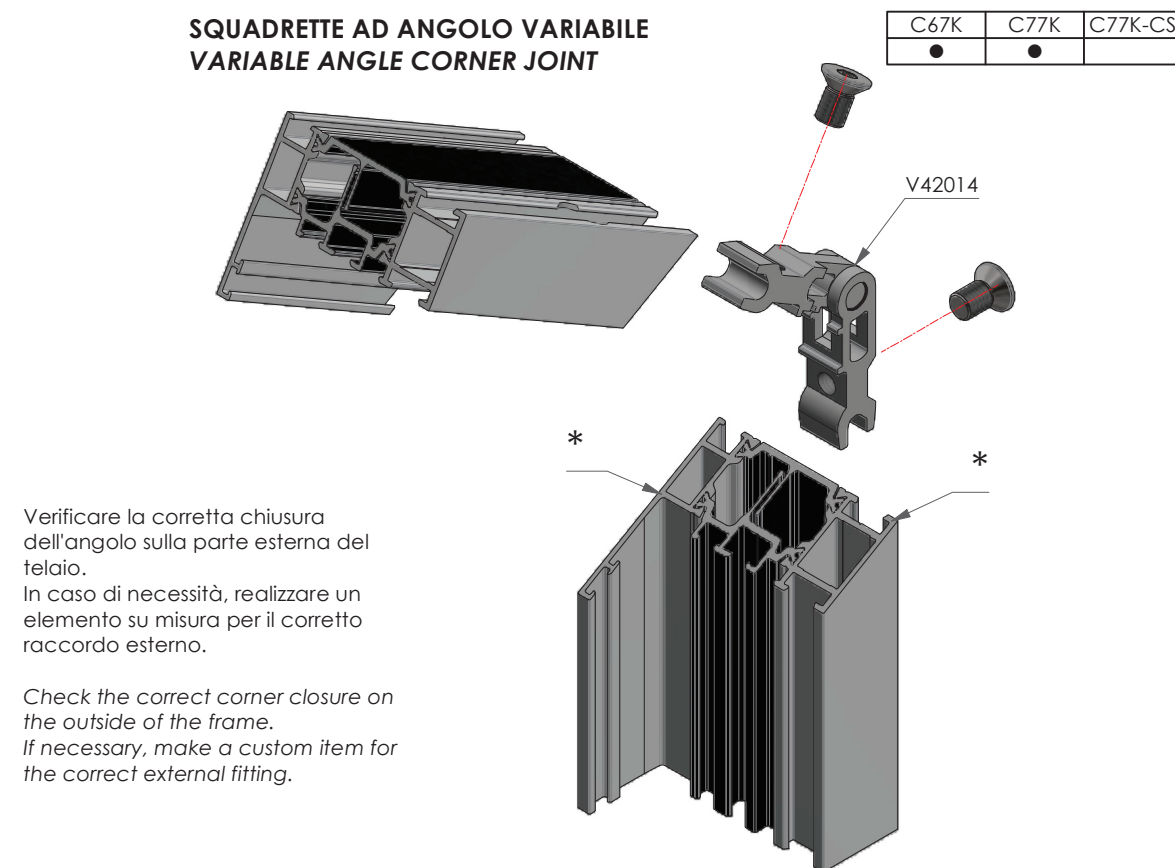
SQUADRETTE A CIANFRINARE CORNER JOINT TO BE CALKED



APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
 TUBOLARI ATTRAVERSO I FORI
 APPLY EPOXY OR POLYURETHANE GLUE THROUGH HOLES

ATTENZIONE AL SENSO DI MONTAGGIO DELLE SQUADRETTE ESTERNE
 #ATTENTION TO THE DIRECTION OF INSTALLATION OF EXTERNAL CORNER JOINTS

SQUADRETTE AD ANGOLO VARIABILE VARIABLE ANGLE CORNER JOINT



C67K	C77K	C77K-CS
●	●	

Verificare la corretta chiusura
 dell'angolo sulla parte esterna del
 telaio.

In caso di necessità, realizzare un
 elemento su misura per il corretto
 raccordo esterno.

Check the correct corner closure on
 the outside of the frame.
 If necessary, make a custom item for
 the correct external fitting.

SQUADRETTE - CORNER JOINTS			
C67K	C77K	C77K-CS	VARIABILE - VARIABLE
U20000	U28002	U28001	V42014
U20001	U28003	-	-
U20002	U28022	-	V42014
U20003	U28023	U28021	V42014
U20004	U28025	-	-
U20005	U28026	-	-
U20020	U28024	-	V42014
U20040	U28042	-	V42014
U20041	U28043	-	V42014
U20042	U28044	-	-

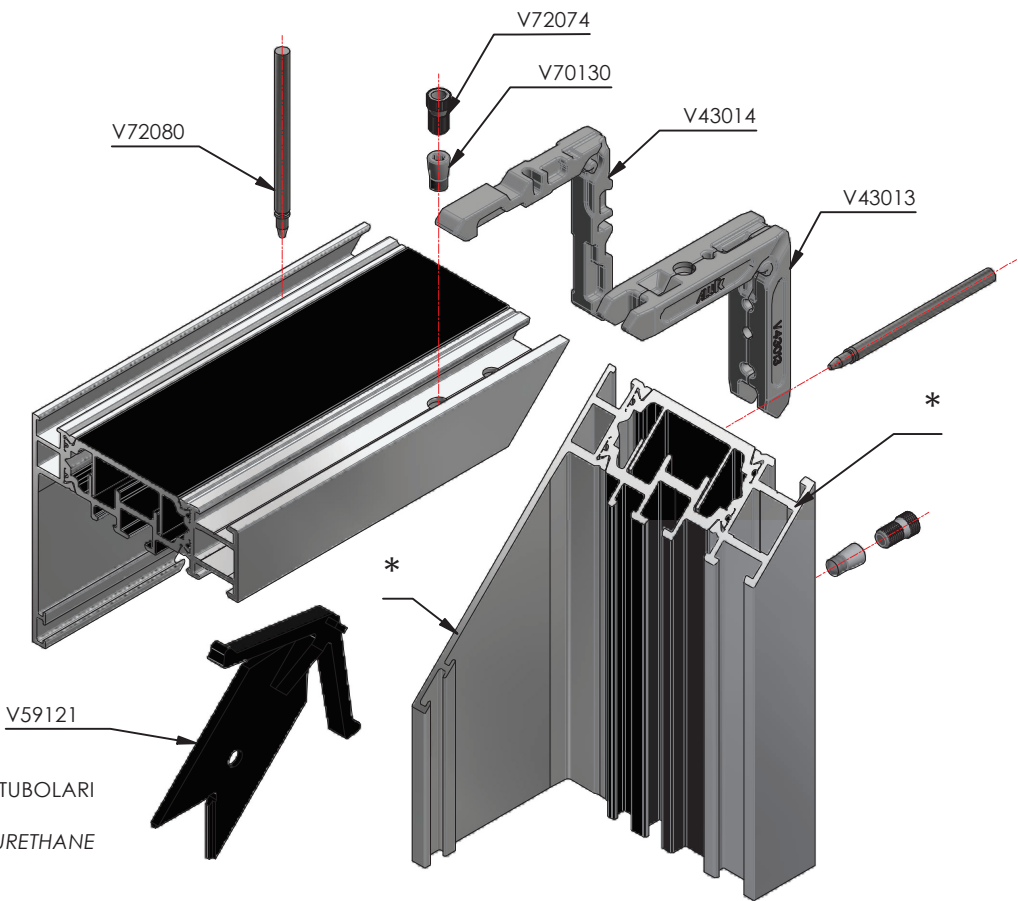
SQUADRETTE - CORNER JOINTS					
C67K	C77K	C77K-CS	INTERNA - INTERNAL	ESTERNA - EXTERNAL	ALLINEAMENTO - ALIGNMENT
U20000	U28002	-	V43000	710411	-
-	-	U28001	V43000	710103 / V43011	V46027
U20001	U28003	-	V43001	710410	-
U20002	U28022	-	V43000	710411	-
-	-	U28028	V43000	710103 / V43011	V46027
U20003	U28023	-	V43000	710411	700151
-	-	U28021	V43000	710103 / V43011	V46027
U20004	U28025	-	V43001	710410	-
U20005	U28026	-	V43001	710410	700151
U20020	U28024	-	V43000	710411	700151
-	-	U28027	V43000	710103 / V43011	V46027
U20021	-	-	V43000	710411	-
U20040	U28042	-	V43000	710411	-
U20041	U28043	-	V43000	710411	-
U20042	U28044	-	V43001	710022	-

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

SCHEMA DI MONTAGGIO SQUADRETTE STIPITE
FIXED FRAME CORNER JOINTS ASSEMBLY

C67K	C77K	C77K-CS
		●

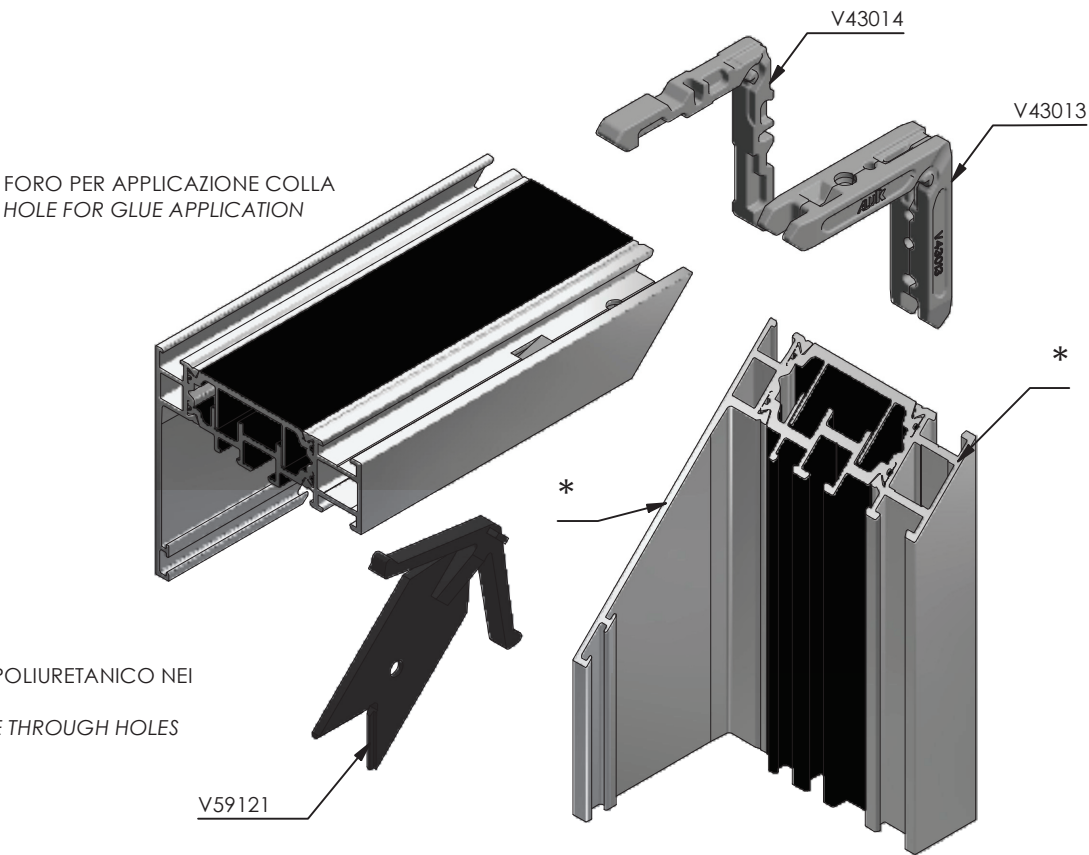
SQUADRETTE A SPINARE/A VITE
CORNER JOINT TO BE RIVETED/SCREWED



V59121
Coprigiunti per connessione stipite
Joint cover for frame connection

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

SQUADRETTE A CIANFRINARE
CORNER JOINT TO BE CALKED



APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
TUBOLARI ATTRAVERSO I FORI
APPLY EPOXY OR POLYURETHANE GLUE THROUGH HOLES

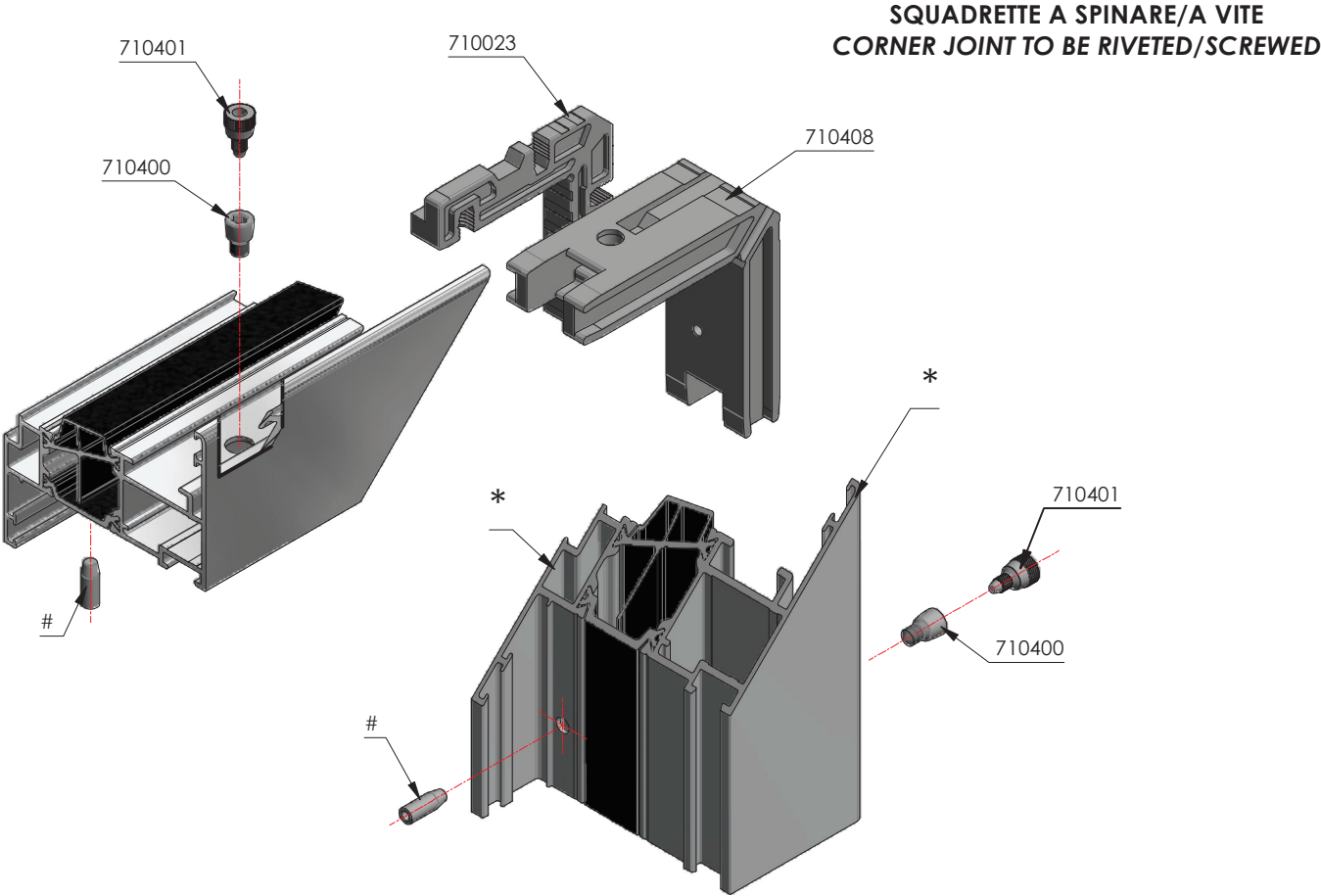
SQUADRETTE - CORNER JOINTS			
C77K-CS	INTERNA - INTERNAL	ESTERNA - EXTERNAL	ALLINEAMENTO - ALIGNMENT
U28000	V43013	V43014	V46027
U28020	V43013	V43014	V46027

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

ATTENZIONE AL SENSO DI MONTAGGIO DELLE SQUADRETTE ESTERNE
ATTENTION TO THE DIRECTION OF INSTALLATION OF EXTERNAL CORNER JOINTS

SCHEMA DI MONTAGGIO SQUADRETTE PER BATTENTI
WINGS CORNER JOINTS ASSEMBLING DIAGRAM

C67K	C77K	C77K-CS
●	●	

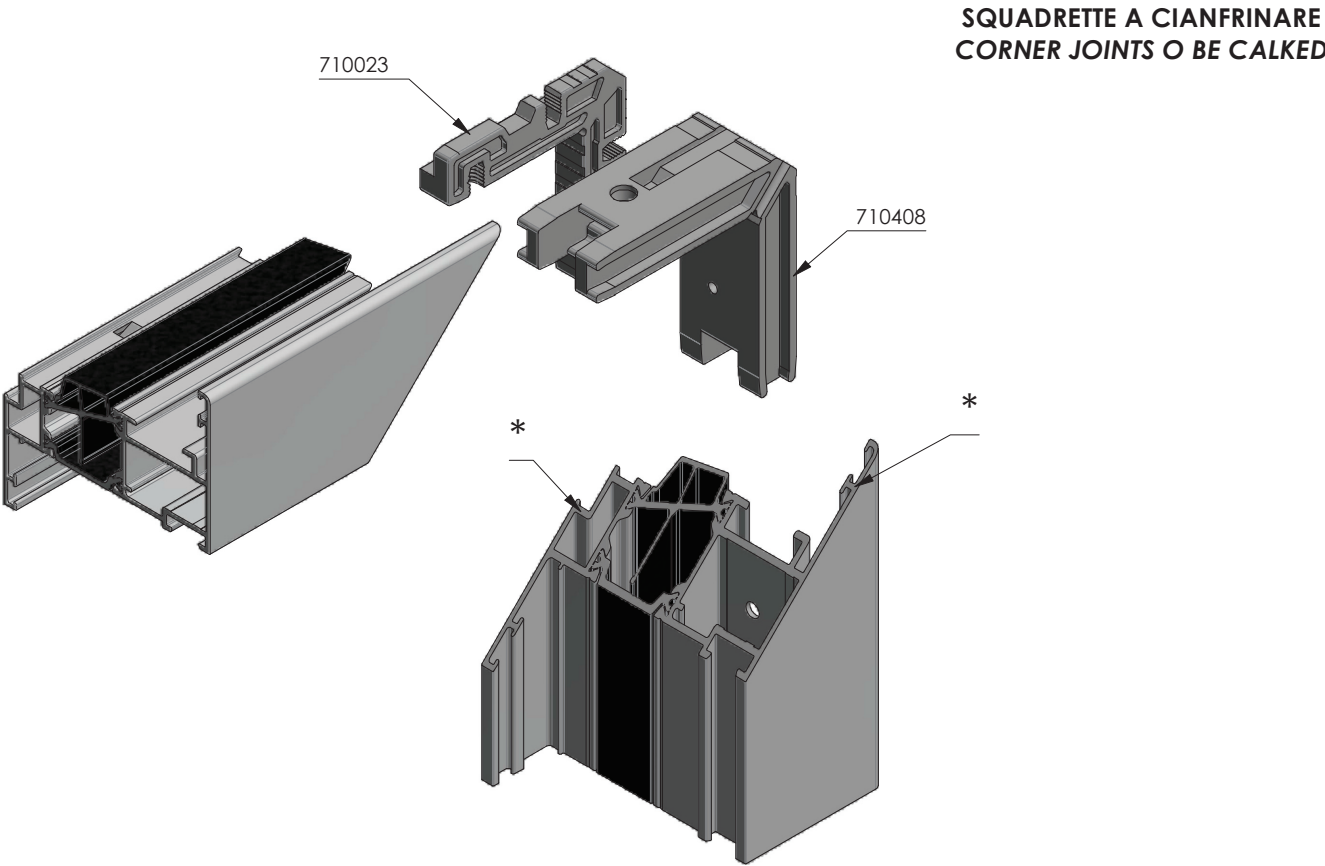


APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI TUBOLARI
ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY OR POLYURETHANE
GLUE BEFORE CORNER JOINT ASSEMBLING

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

E' possibile utilizzare anche: 710409 (h=14)
You can also use: 710409 (h=14)

SQUADRETTE - CORNER JOINTS			
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL
U20133 (U20120)	U28129 (U28120)	710408	710023
U20135 (U20122)	U28131 (U28121)	710408	710023
U20137 (U20124)	U28133 (U28122)	710408	710023
U20501	U28501	710408	710023



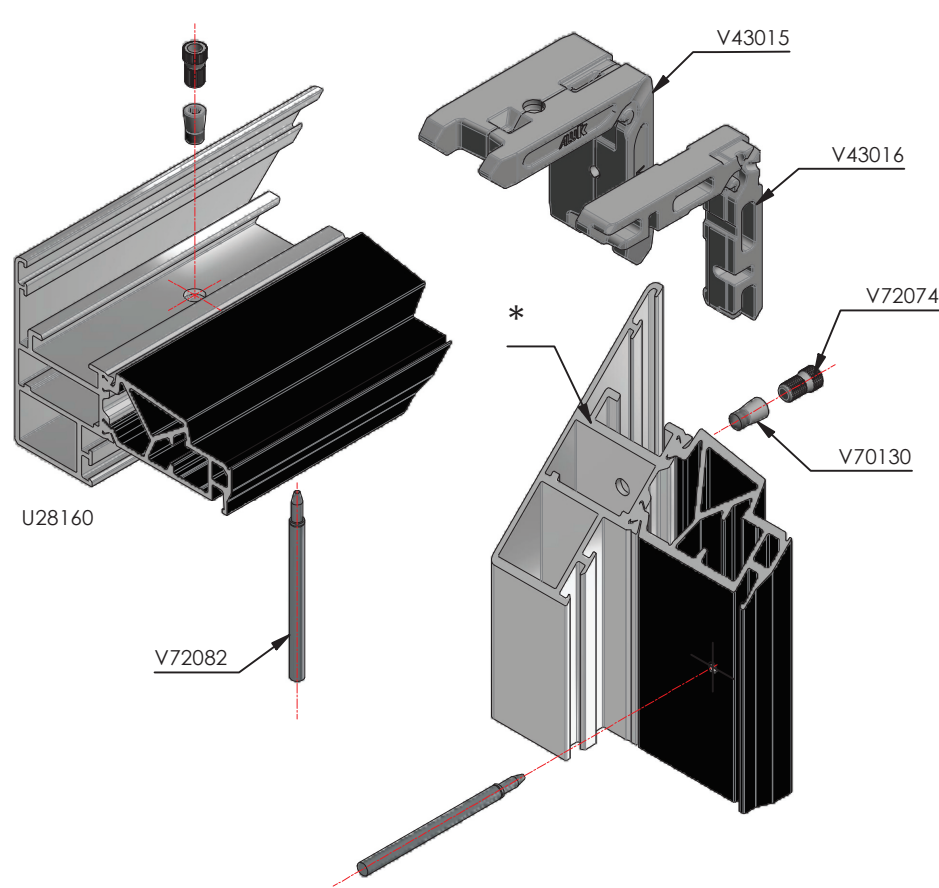
APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
TUBOLARI ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY OR
POLYURETHANE GLUE BEFORE CORNER JOINT ASSEMBLING

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

APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
TUBOLARI ATTRAVERSO I FORI
APPLY EPOXY OR POLYURETHANE GLUE THROUGH HOLES

SCHEMA DI MONTAGGIO SQUADRETTE PER BATTENTI
WINGS CORNER JOINTS ASSEMBLING DIAGRAM

C67K	C77K	C77K-CS
		●



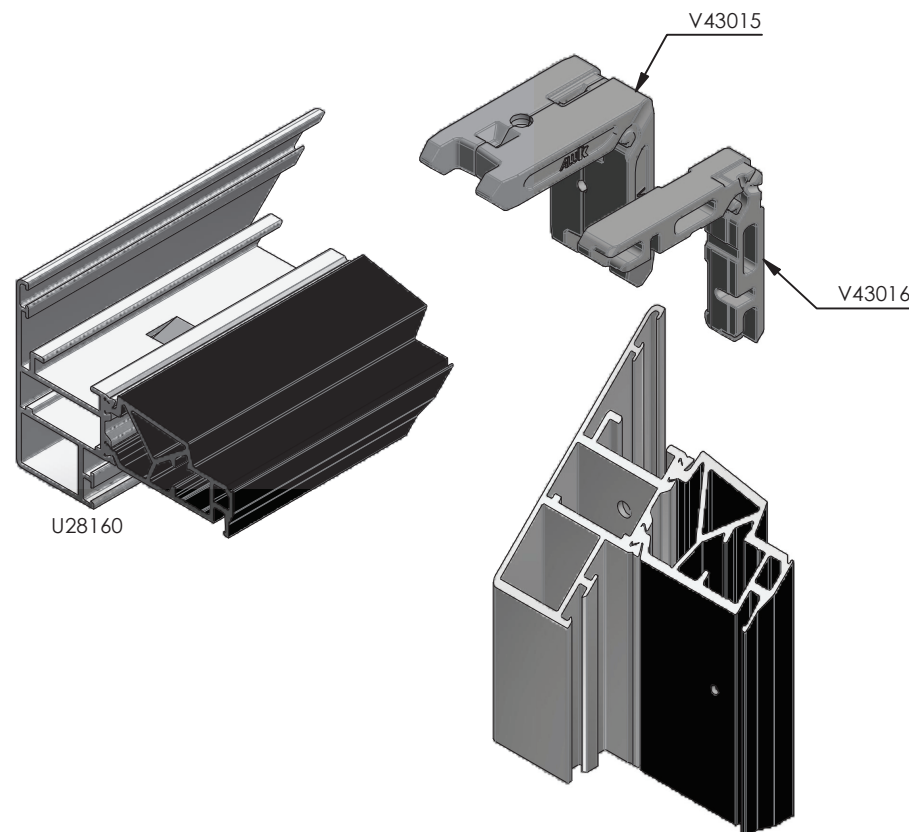
SQUADRETTE A SPINARE/A VITE
CORNER JOINT TO BE RIVETED/SCREWED

APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI TUBOLARI
ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY OR POLYURETHANE
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

SQUADRETTE - CORNER JOINTS			
C77K-CS	INTERNA - INTERNAL	ESTERNA - EXTERNAL	ALLINEAMENTO - ALIGNMENT
U28160	V43015	V43016	710041
U28161	V43015	V43016	710041
U28162	V43015	V43016	-
U28163	V43015	V43016	-

SQUADRETTE A CIANFRINARE
CORNER JOINTS TO BE CALKED



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

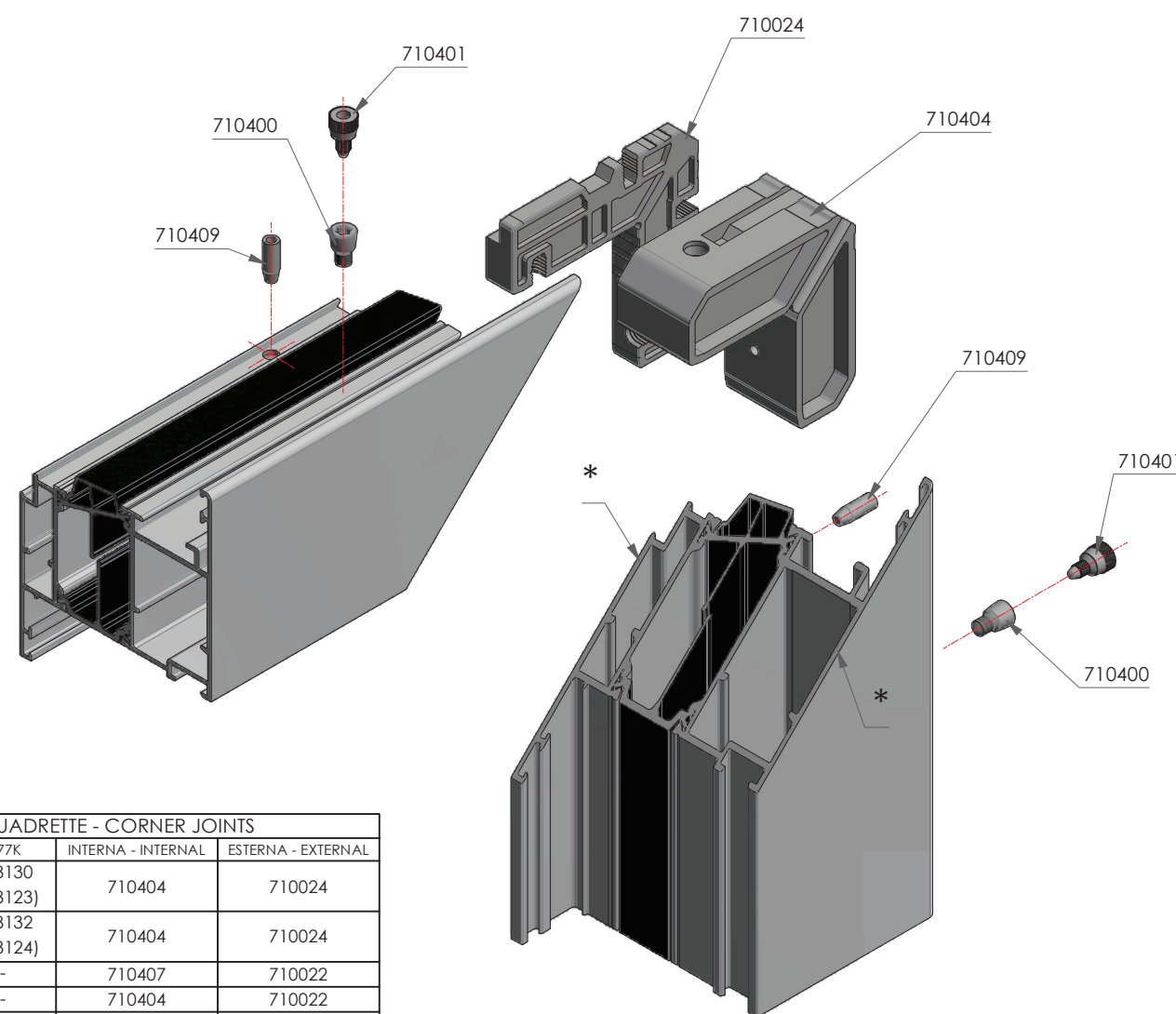
- * APPLICARE SIGILLANTE SILICONICO SULLE SUPERFICI DI
CONNESSIONE DELL'ANGOLO PRIMA DELL'UNIONE A TELAIO
- * APPLY SILICONE SEALING ON CONNECTION CORNER SURFACES
BEFORE FRAME ASSEMBLING

APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
TUBOLARI ATTRAVERSO I FORI
APPLY EPOXY OR POLYURETHANE GLUE THROUGH HOLES

SCHEMA DI MONTAGGIO SQUADRETTE PER BATTENTI
WINGS CORNER JOINTS ASSEMBLING DIAGRAM

C67K	C77K	C77K-CS
●	●	

SQUADRETTE PER BATTENTI MAGGIORATI, SPORGERE E BILICO
CORNER JOINTS FOR OVERSIZE WINGS, PROJECTING WINDOWS AND PIVOTING WINDOWS

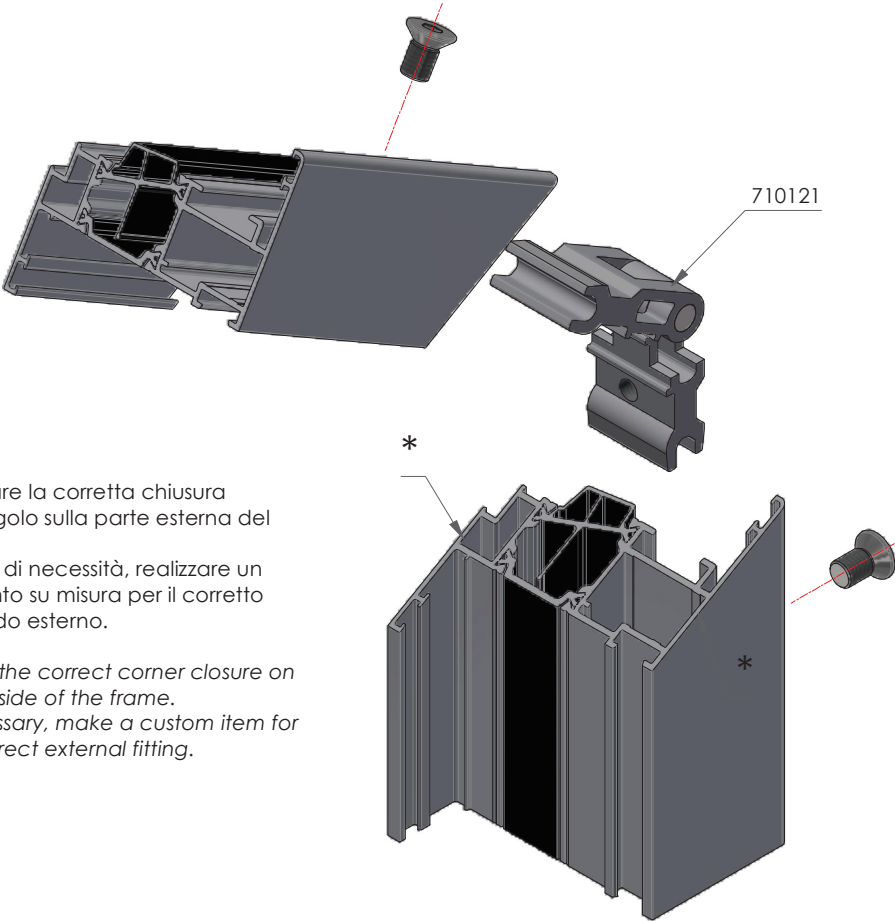


SQUADRETTE - CORNER JOINTS			
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL
U20134 (U20121)	U28130 (U28123)	710404	710024
U20136 (U20123)	U28132 (U28124)	710404	710024
U20043	-	710407	710022
U20140	-	710404	710022
N48630	-	710404	-

APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
TUBOLARI ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY OR
POLYURETHANE 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

SQUADRETTE AD ANGOLO VARIABILE
VARIABLE ANGLE CORNER JOINT



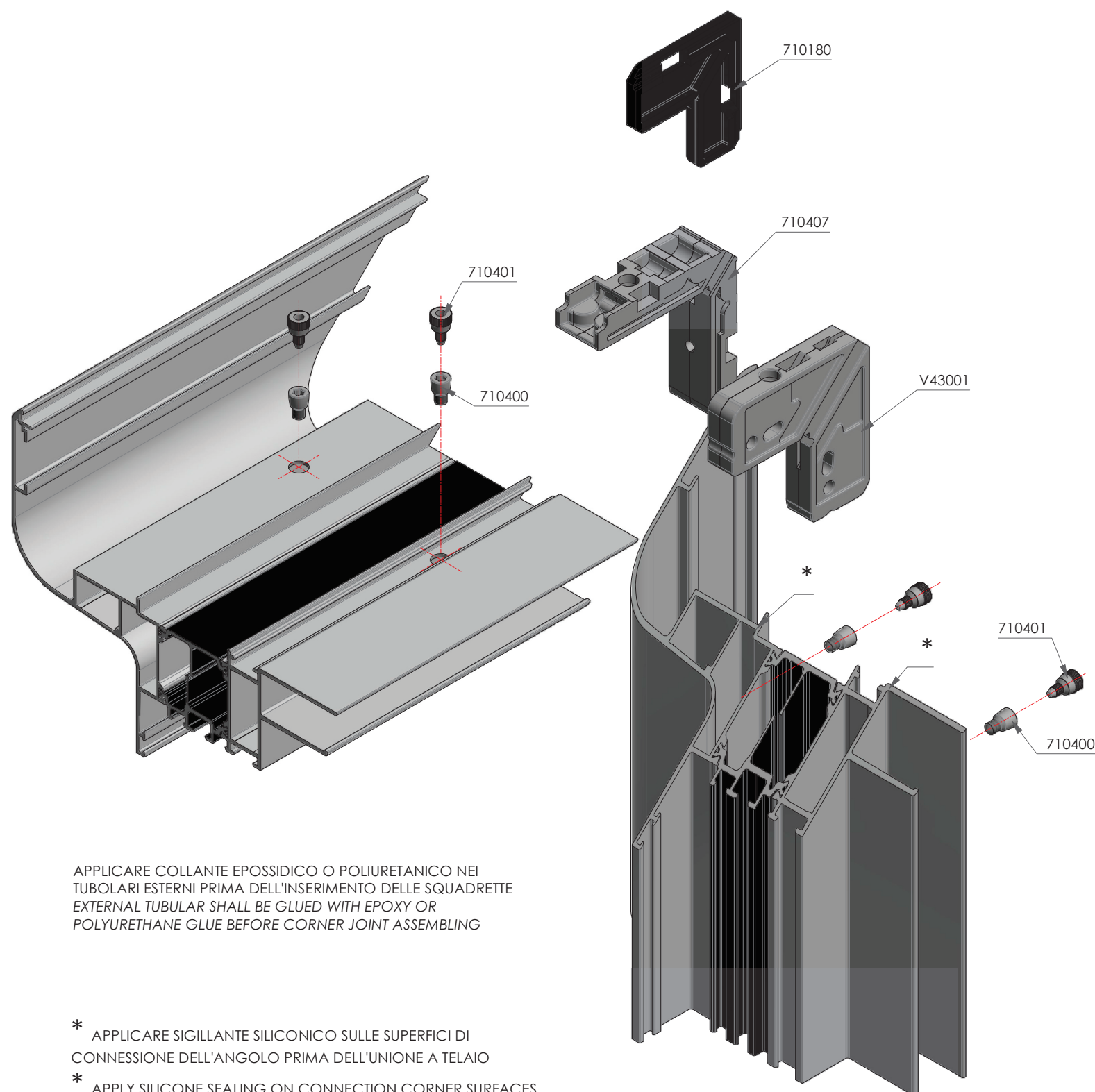
Verificare la corretta chiusura
dell'angolo sulla parte esterna del
telaio.
In caso di necessità, realizzare un
elemento su misura per il corretto
raccordo esterno.

Check the correct corner closure on
the outside of the frame.
If necessary, make a custom item for
the correct external fitting.

SQUADRETTE - CORNER JOINTS		
C67K	C77K	VARIABILE - VARIABLE
U20133 (U20120)	U28129 (U28120)	710121
U20135 (U20122)	U28131 (U28121)	710121
U20137 (U20124)	U28133 (U28122)	710121

▶ SCHEMA DI MONTAGGIO SQUADRETTE SU PROFILI IMBOTTITI
 FIXED FRAME EXTENSIONS CORNER JOINTS ASSEMBLING DIAGRAM

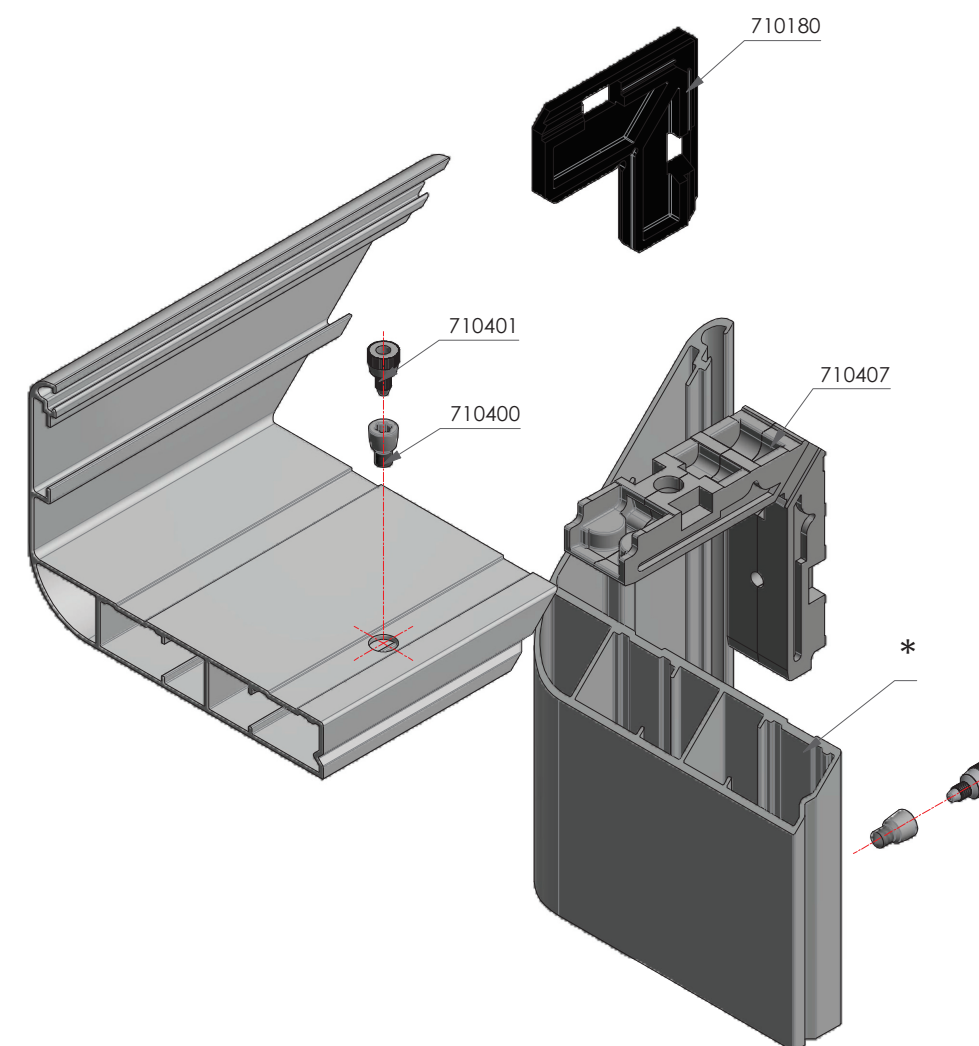
C67K	C77K	C77K-CS
●	●	



APPLICARE COLLANTE EPOSSIDICO O POLIURETANICO NEI
 TUBOLARI ESTERNI PRIMA DELL'INSERIMENTO DELLE SQUADRETTE
 EXTERNAL TUBULAR SHALL BE GLUED WITH EPOXY OR
 POLYURETHANE 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

SQUADRETTE - CORNER JOINTS				
C67K	C77K	INTERNA - INTERNAL	ESTERNA - EXTERNAL	ALLINEAMENTO - ALIGNMENT
U20060	U28060	V43001	710407	710180
U20061	U28061	V43001	710407	710180



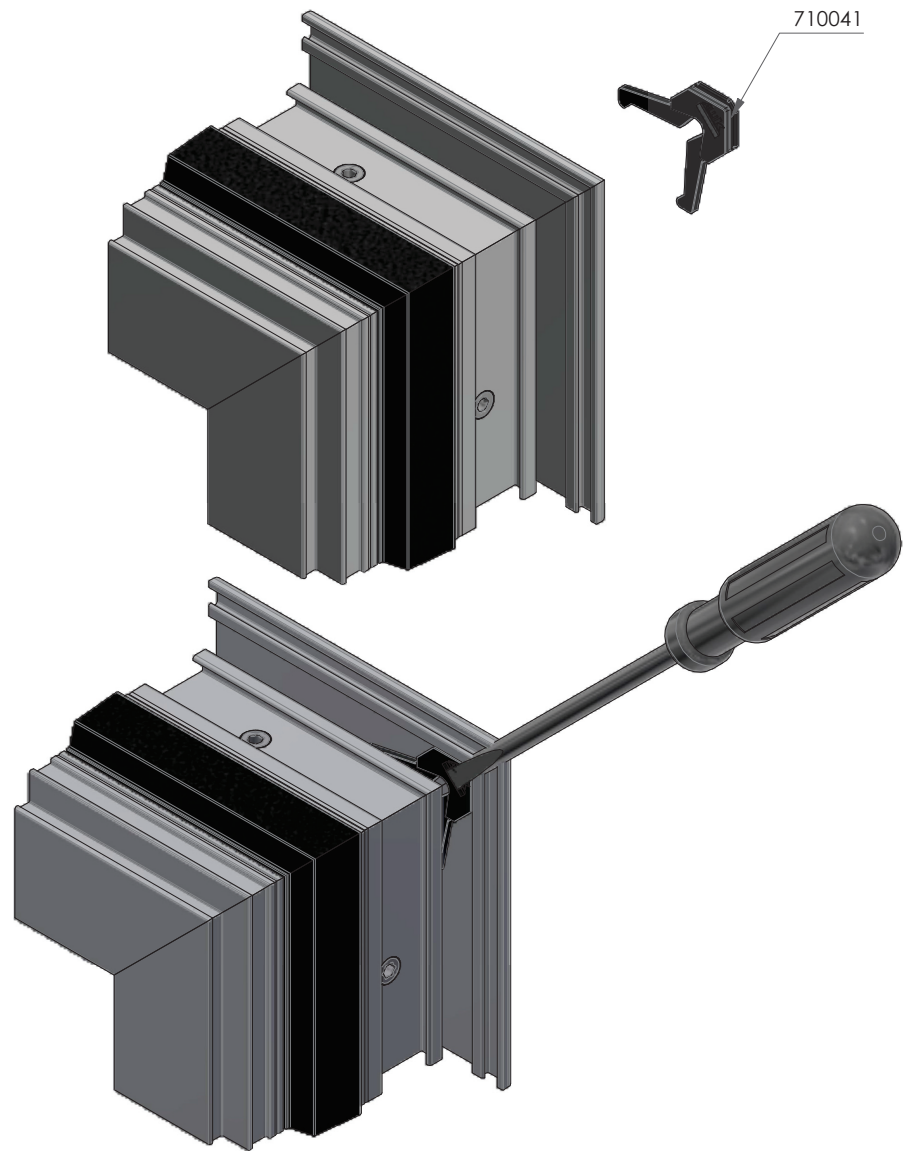
- * APPLICARE SIGILLANTE SILICONICO SULLE SUPERFICI DI
CONNESSIONE DELL'ANGOLO PRIMA DELL'UNIONE A TELAIO
- * APPLY SILICONE SEALING ON CONNECTION CORNER SURFACES
BEFORE FRAME ASSEMBLING

SQUADRETTE - CORNER JOINTS		
PROFILI - PROFILES	INTERNA - INTERNAL	ALLINEAMENTO - ALIGNMENT
K702	710407	710180
K703	710407	710180
K704	710407	710180
K705	710407	710180
K706	710407	710180
K707	710407	-

> SCHEMA DI MONTAGGIO SQUADRETTE DI ALLINEAMENTO BATTENTE
 WING ALIGNMENT CORNER JOINT ASSEMBLING DIAGRAM

C67K	C77K	C77K-CS
●	●	●

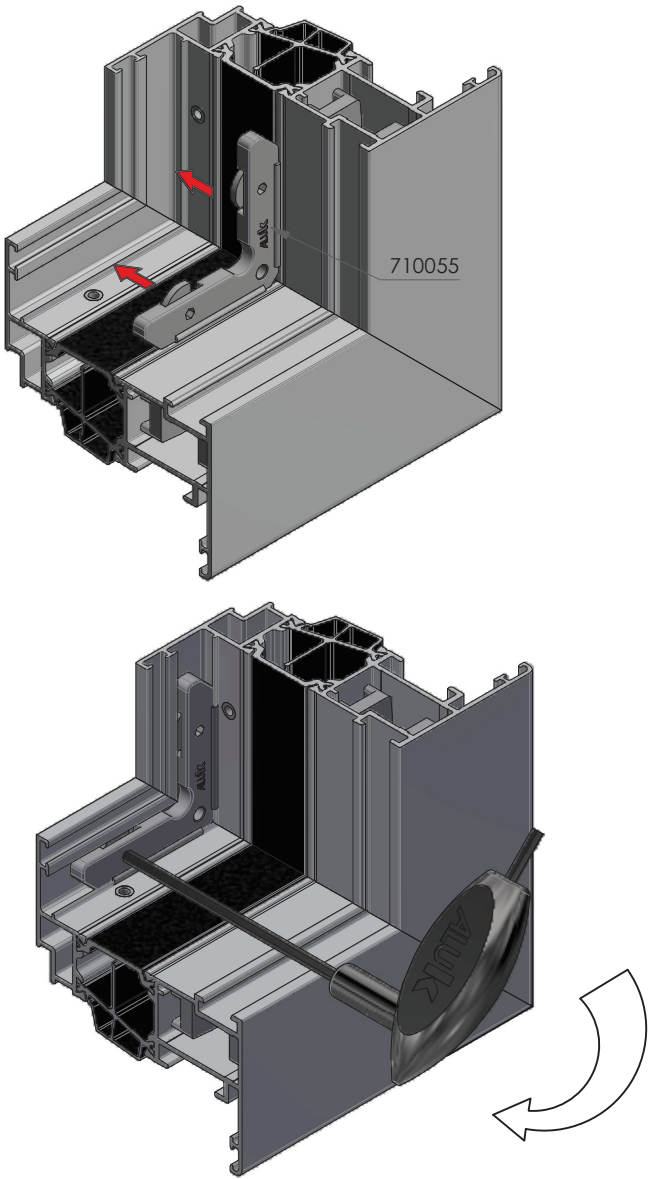
SCHEMA DI MONTAGGIO SQUADRETTA DI ALLINEAMENTO INTERNA BATTENTE
 INTERNAL WING ALIGNMENT CORNER JOINT ASSEMBLING DIAGRAM



SQUADRETTE - CORNER JOINTS			
C67K	C77K	C77K-CS	ALLINEAMENTO - ALIGNMENT
U20133 (U20120)	U28129 (U28120)	-	710041
U20134 (U20121)	U28130 (U28123)	-	710041
U20135 (U20122)	U28131 (U28121)	-	710041
U20136 (U20123)	U28132 (U28124)	-	710041
U20137 (U20124)	U28133 (U28122)	-	710041
-	-	U28160	710041
-	-	U28161	710041

C67K	C77K	C77K-CS
●	●	

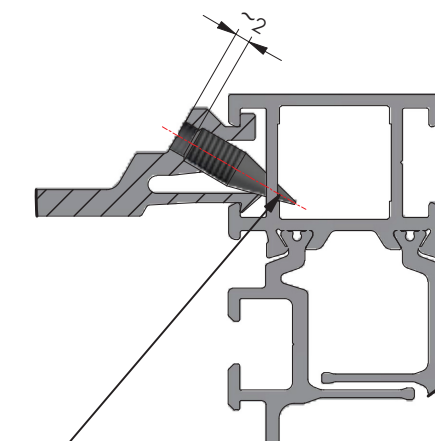
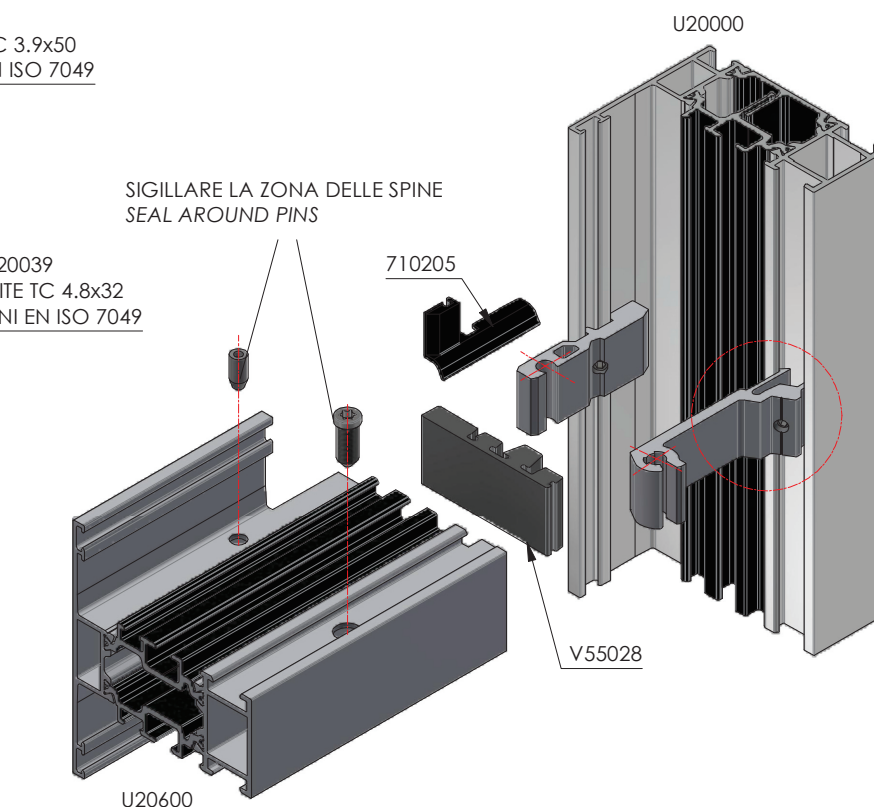
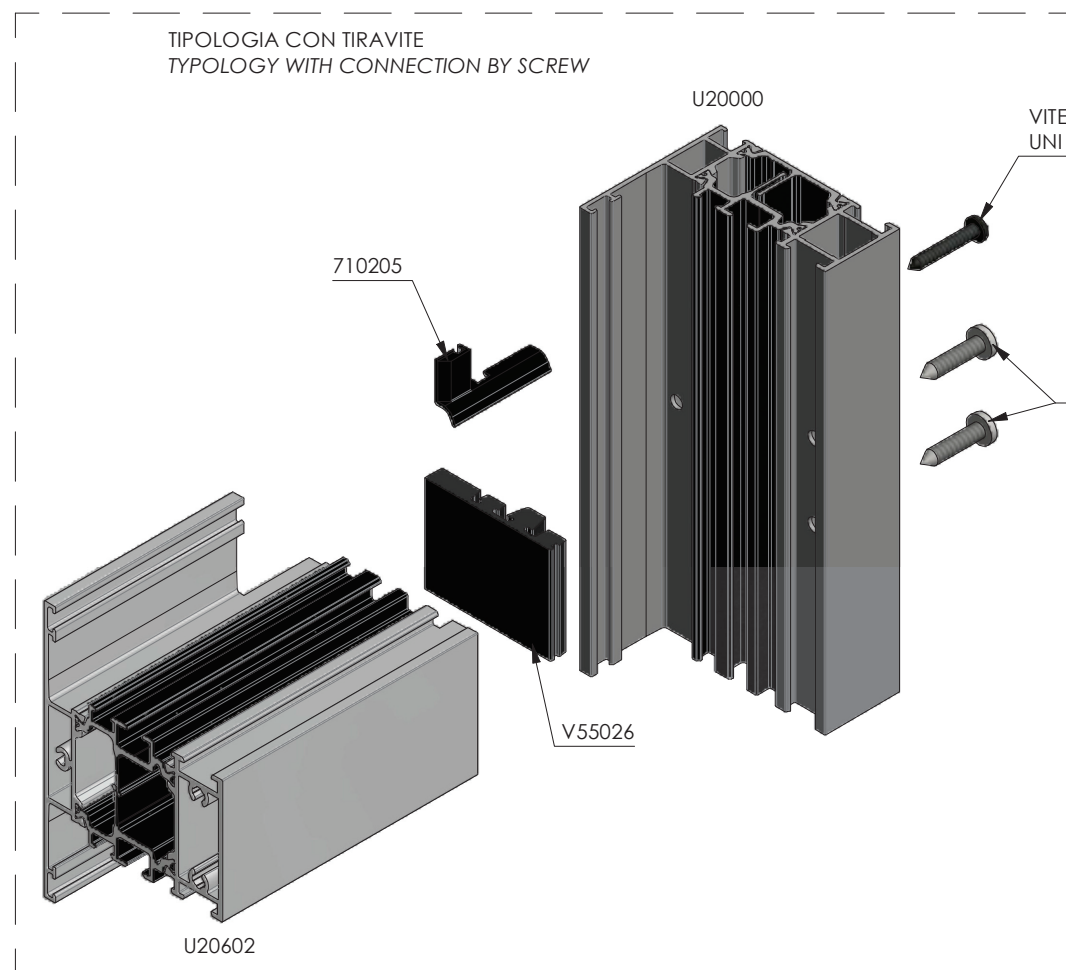
SCHEMA DI MONTAGGIO SQUADRETTA DI ALLINEAMENTO BATTENTE ART. 710055
 ART. 710055 WING ALIGNMENT CORNER JOINT ASSEMBLING DIAGRAM



SQUADRETTE - CORNER JOINTS		
C67K	C77K	ALLINEAMENTO - ALIGNMENT
U20133 (U20120)	U28129 (U28120)	710055
U20134 (U20121)	U28130 (U28123)	710055
U20135 (U20122)	U28131 (U28121)	710055
U20136 (U20123)	U28132 (U28124)	710055
U20501	U28501	710055

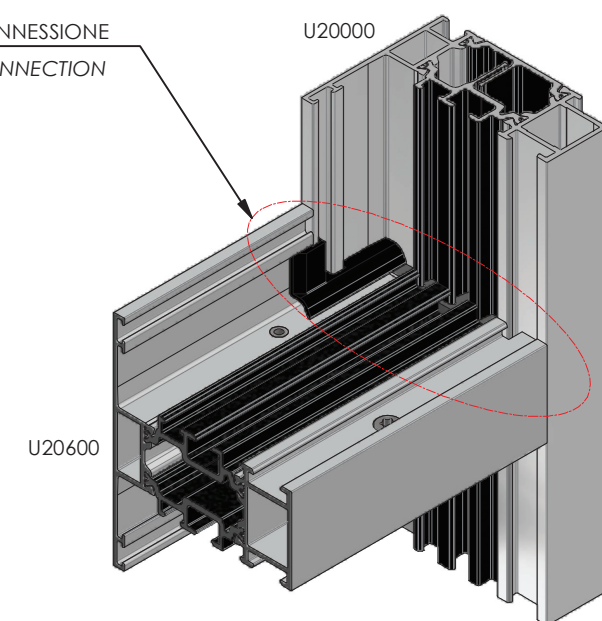
SCHEMA DI CONNESSIONE TRAVERSO STIPITE FIXED FRAME TRANSOM DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	



FORARE IL PROFILO CON LA VITE SPECIALE
DRILL THE PROFILE WITH THE SPECIAL SCREW

SIGILLARE LA ZONA DELLA CONNESSIONE
SEAL THE CONNECTION

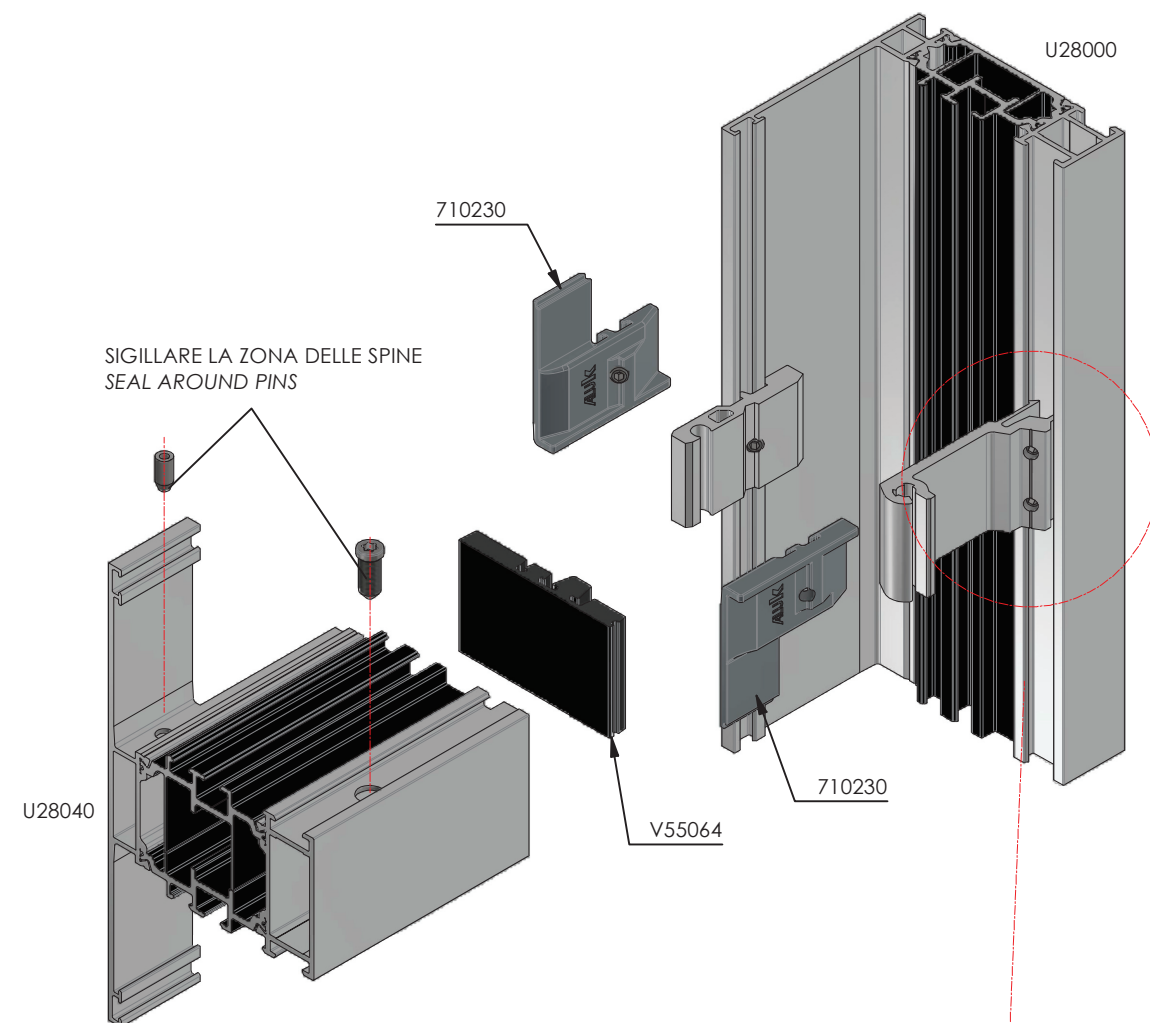
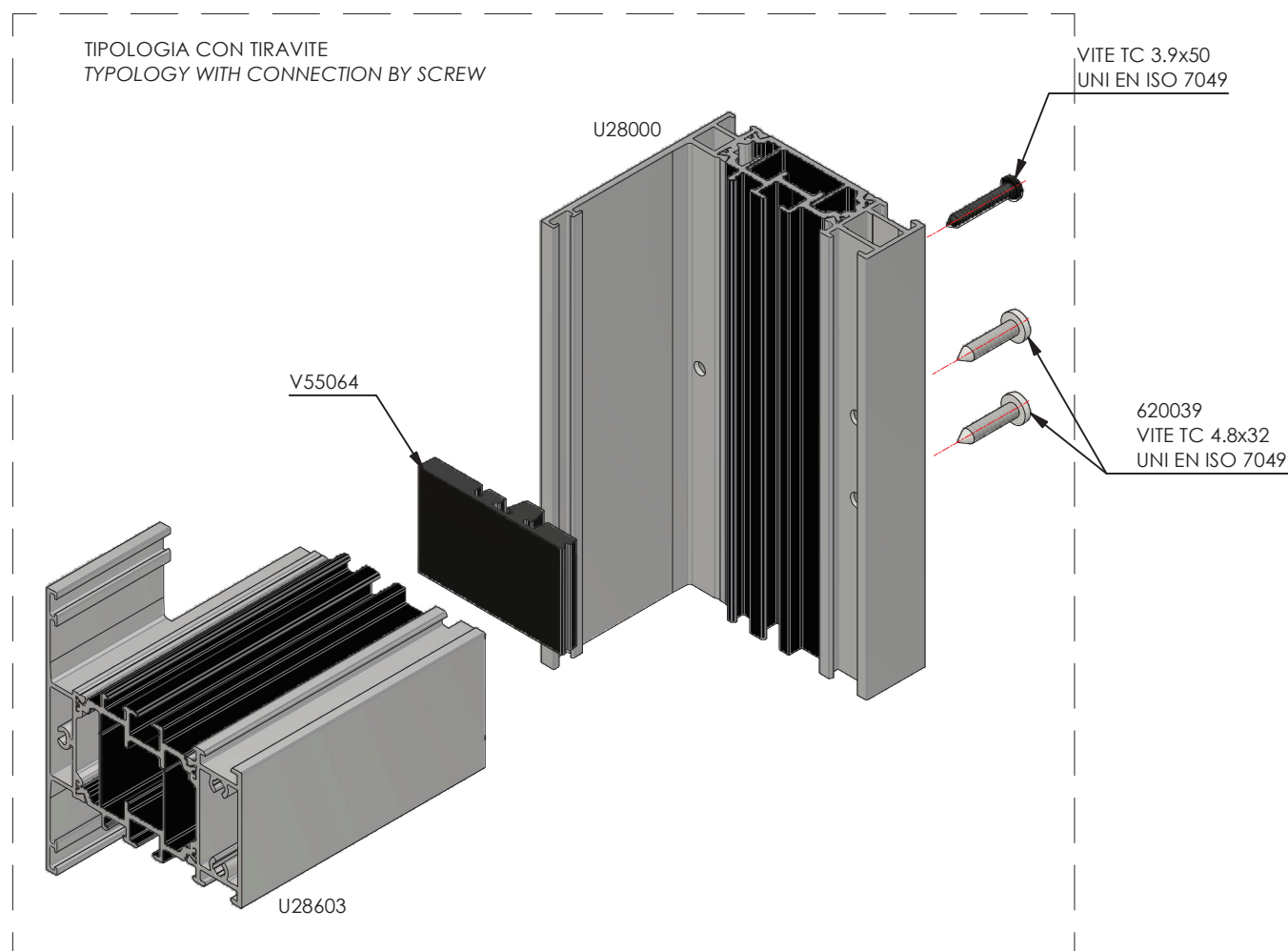


CAVALLOTTI - T JOINTS			
C67K	KIT	GUARNIZIONE - GASKET	PORTATA - TRANSOM LOAD
U20000	V47000	V55028	80 kg
U20001	V47002	V55026	120 kg
U20002	V47000	V55028	80 kg
U20003	V47000	V55028	80 kg
U20004	V47002	V55026	120 kg
U20005	V47002	V55026	120 kg
U20020	V47000	V55028	80 kg
U20021	V47000	V55028	80 kg
U20040	V47000	V55028	80 kg
U20041	V47000	V55028	80 kg
U20042	V47002	V55026	120 kg
U20600	V47001	V55028	80 kg
U20601	V47002	V55026	120 kg
U20602	-	V55026	-
U20603	V47005 x 2pz + 710219	V55028 x 2pz	120 kg
U20630	V47005 x 2pz + 710219	V55028 x 2pz	120 kg

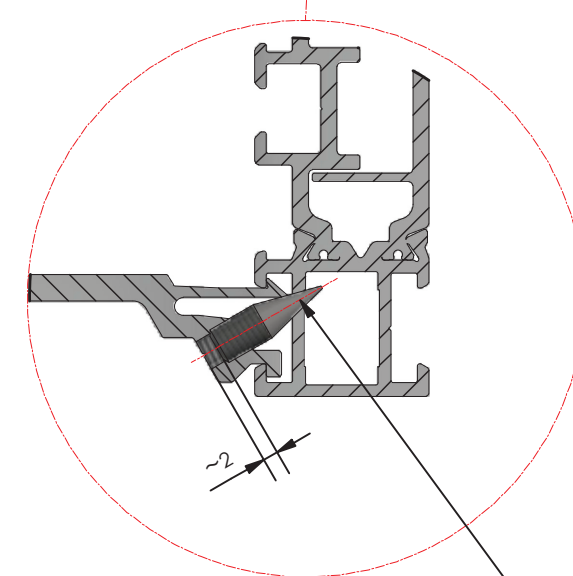
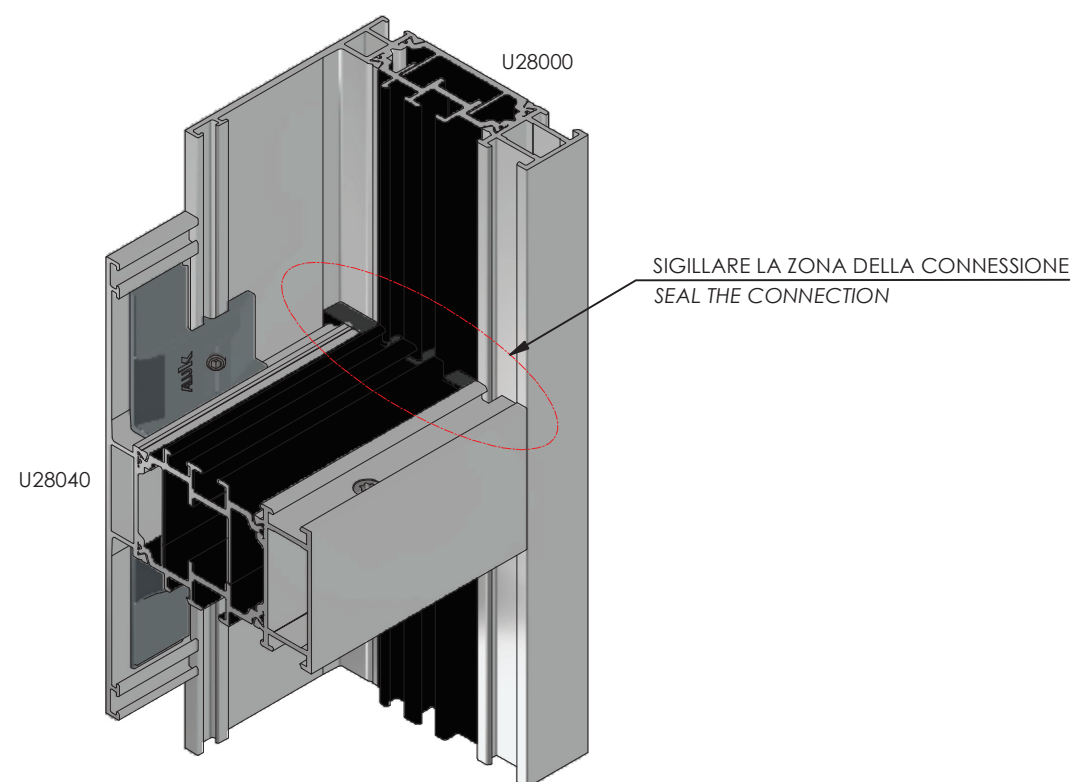
CAVALLOTTI - T JOINTS			
C77K	KIT	GUARNIZIONE - GASKET	PORTATA - TRANSOM LOAD
U28002	V47000	V55077	80 kg
U28003	V47002	V55064	120 kg
U28022	V47000	V55077	80 kg
U28023	V47000	V55077	80 kg
U28025	V47002	V55064	120 kg
U28026	V47002	V55064	120 kg
U28024	V47000	V55077	80 kg
U28042	V47000	V55077	80 kg
U28043	V47000	V55077	80 kg
U28044	V47002	V55064	120 kg
U28601	V47001	V55077	80 kg
U28602	V47002	V55064	120 kg
U28603	-	V55064	-
U28604	V47005 x 2pz + 710219	V55077 x 2pz	120 kg
U28630	V47005 x 2pz + 710219	V55077 x 2pz	120 kg

► SCHEMA DI CONNESSIONE TRAVERSO STIPITE
FIXING FRAME TRANSOM DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
		●

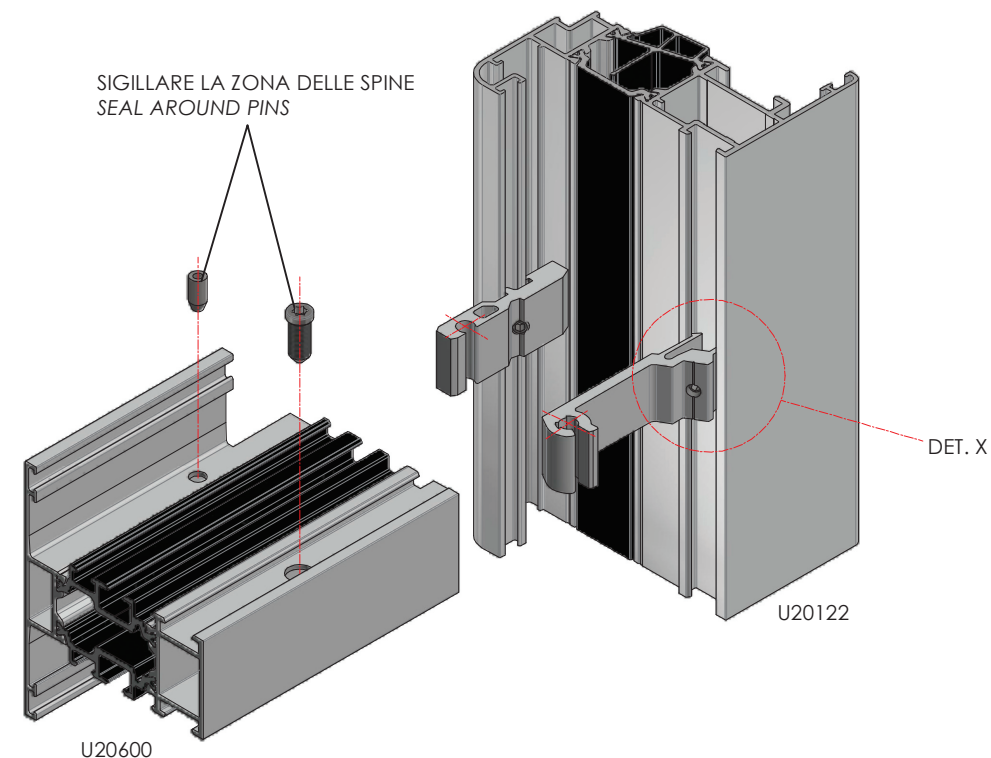
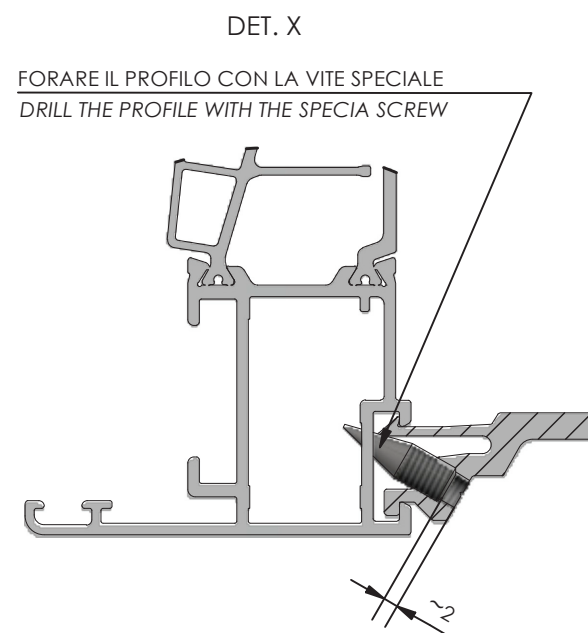
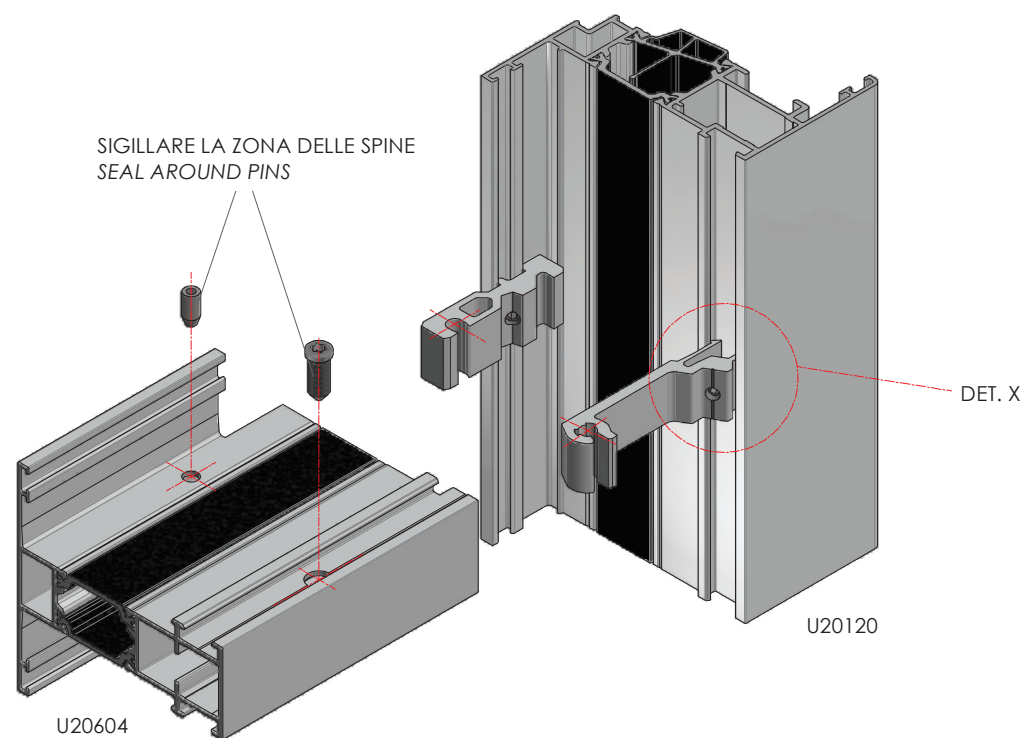


CAVALLOTTI - T JOINTS			
C77K-CS	KIT	GUARNIZIONE - GASKET	PORTATA - TRANSOM LOAD
U28000	V47034	V55077	80 kg
U28001	V47034	V55064	120 kg
U28020	V47034	V55077	80 kg
U28021	V47034	V55077	80 kg
U28601	V47001	V55028	120 kg
U28602	V47002	V55026	120 kg
U28603	-	V55026	80 kg



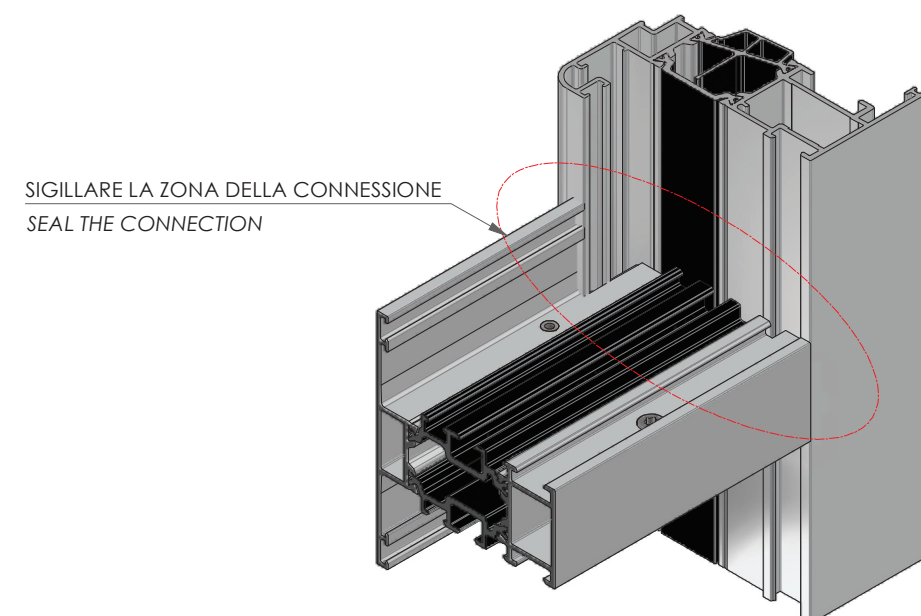
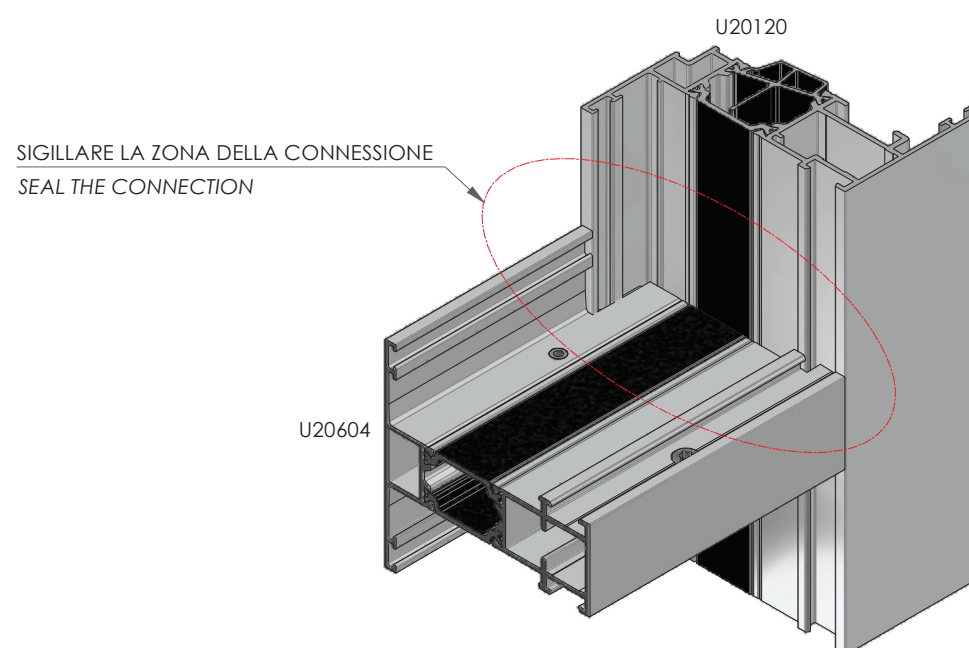
➤ SCHEMA DI CONNESSIONE TRAVERSI BATTENTE
 WING TRANSOM DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	



CAVALLOTTI - T JOINTS			
C67K	C77K	KIT	PORTATA - TRANSOM LOAD
U20604	U28605	V47003	80 kg

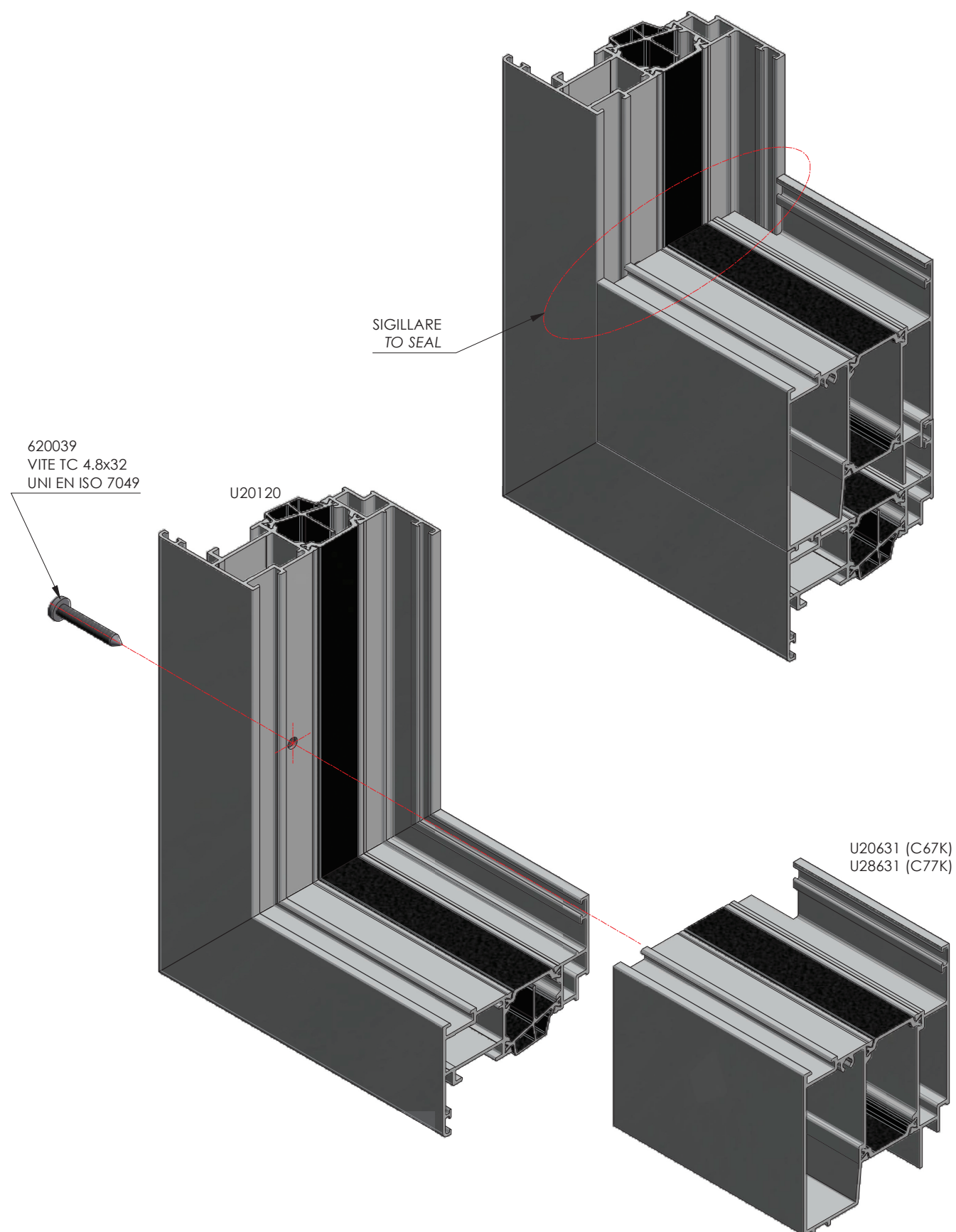
CAVALLOTTI - T JOINTS			
C67K	C77K	KIT	PORTATA - TRANSOM LOAD
U20600	U28601	V47006	80 kg
U20601	U28602	V47007	120 kg
U20603	U28604	V47005	80 kg



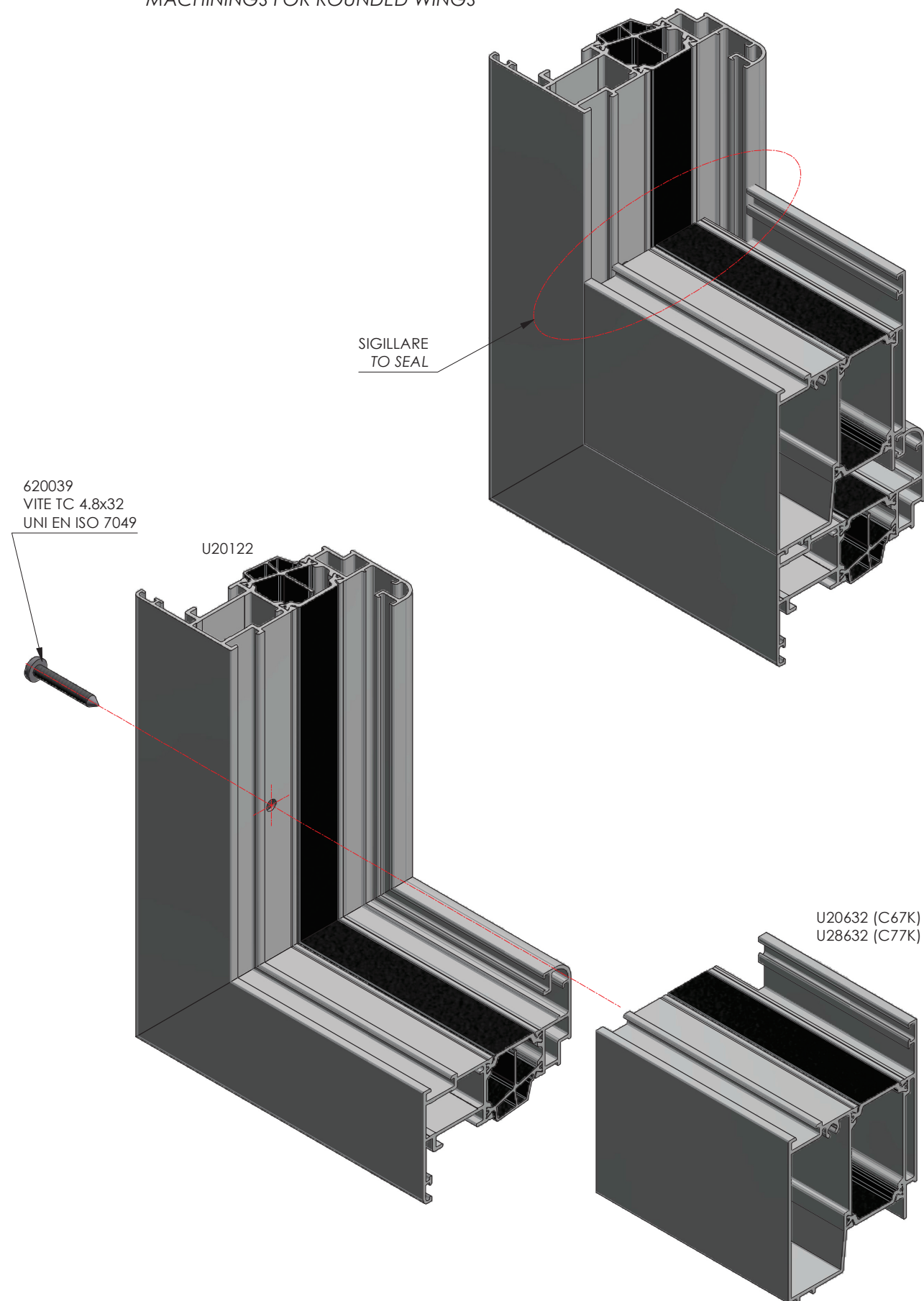
➤ SCHEMA DI CONNESSIONE AGGIUNTIVO BATTENTE
WING FRAME TRANSOM BALCONY DOOR CONNECTION DIAGRAM

C67K	C77K	C77K-CS
●	●	

LAVORAZIONI PER ANTE LISCE
MACHININGS FOR SMOOTH WINGS

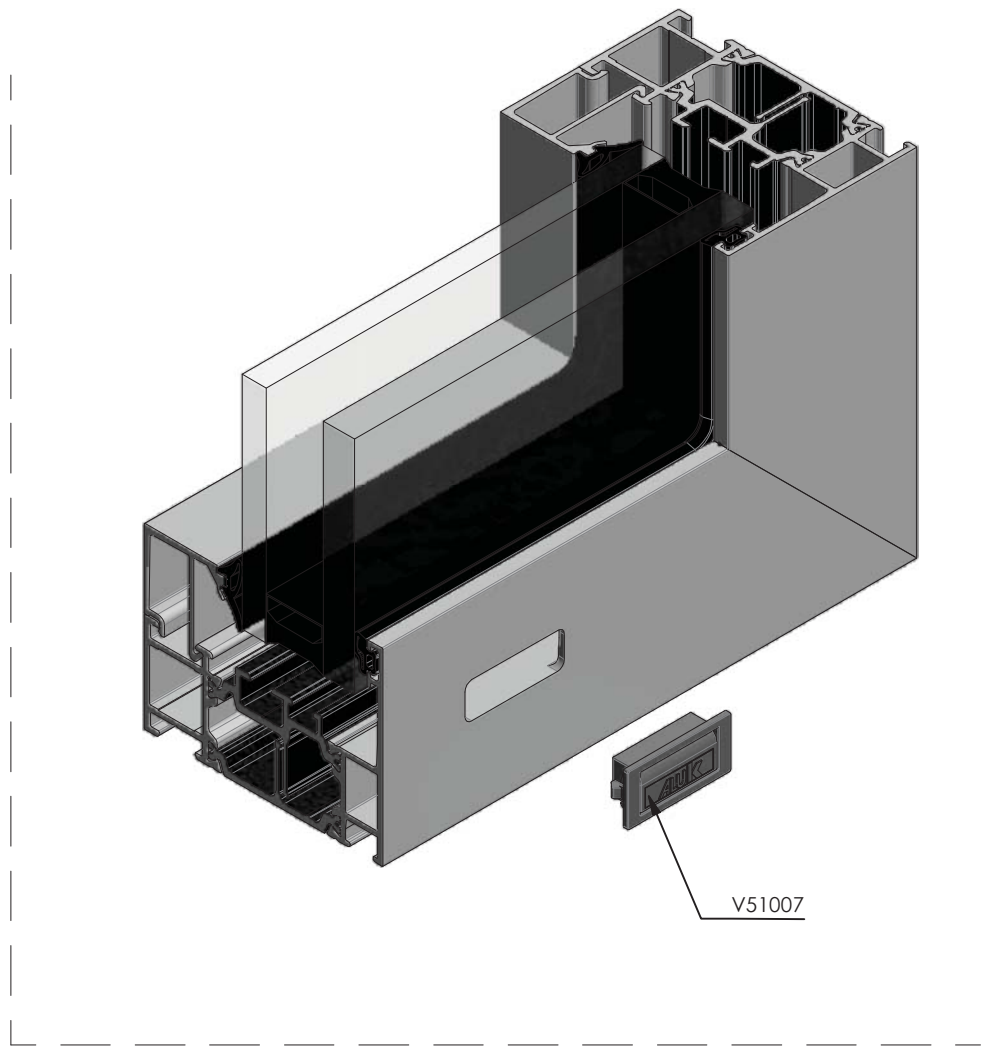
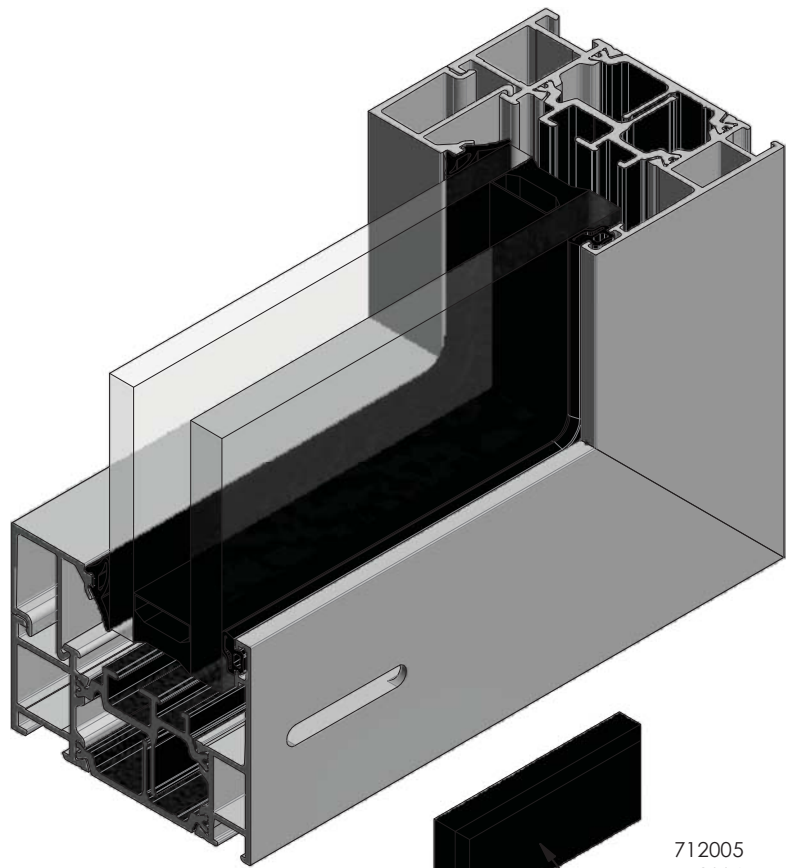
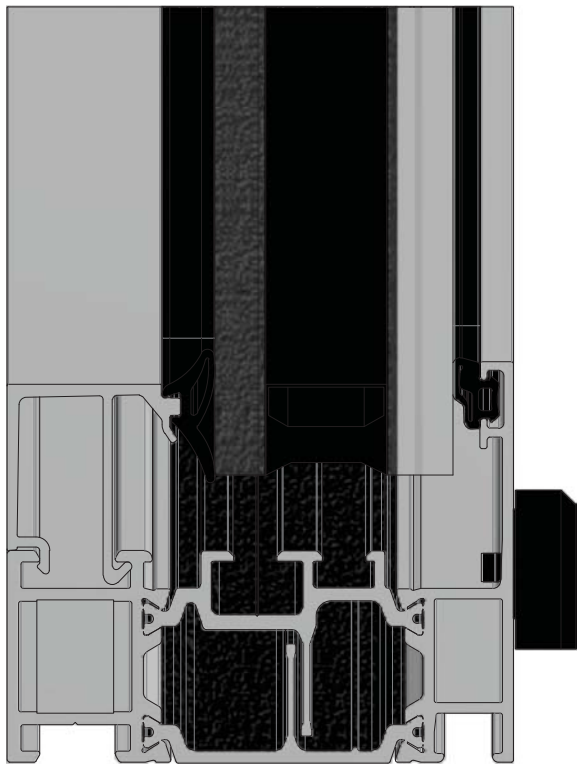


LAVORAZIONI PER ANTE RAGGIATE
MACHININGS FOR ROUNDED WINGS



SCHEMA DI MONTAGGIO ACCESSORI DI DRENAGGIO
WATER DRAIN CAPS DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	●



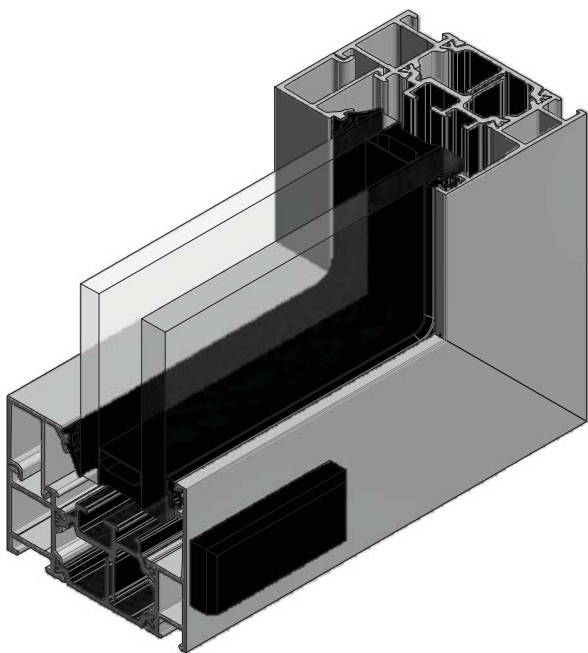
DRENAGGIO - DRAINAGE		
C67K	C77K	C77K-CS
U20000	U28002	U28001
-	-	U28000
U20001	U28003	-
U20002	U28022	-
U20003	U28023	U28021
-	-	U28020
U20004	U28025	-
U20005	U28026	-
U20020	U28024	-
U20040	U28042	-
U20041	U28043	-
U20042	U28044	-

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

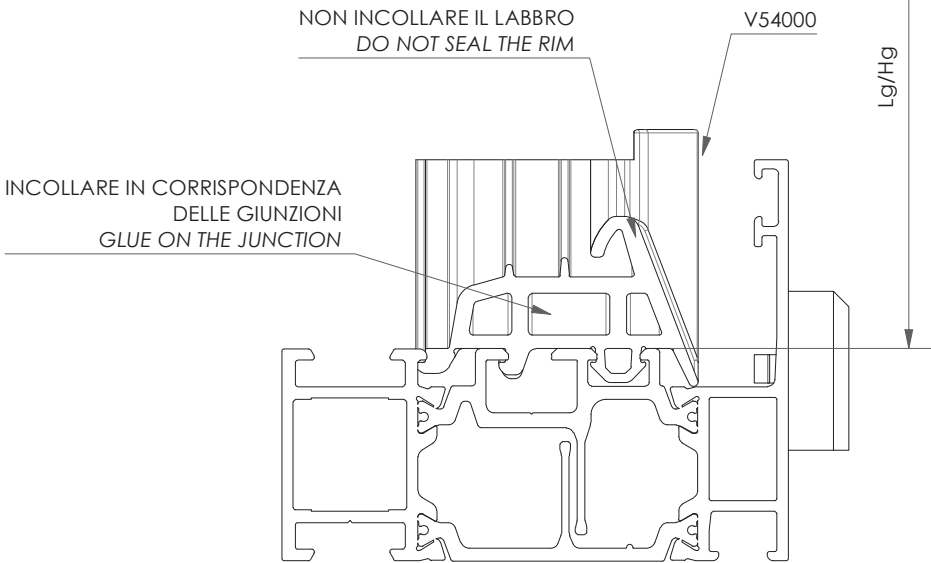
N.B. SI CONSIGLIA IL MONTAGGIO DELLE MASCHERINE CON VALVOLA NEI SITI ESPOSTI AD ELEVATI CARICHI DI VENTO.
N.B. IT'S ADVISABLE TO ASSEMBLE THE WATER DRAIN CAP WITH VALVE IN CASE OF HIGHER WIND LOADS.



SCHEMA DI MONTAGGIO GUARNIZIONI DI GIUNTO APERTO FITTING OF THE CENTRAL GASKET

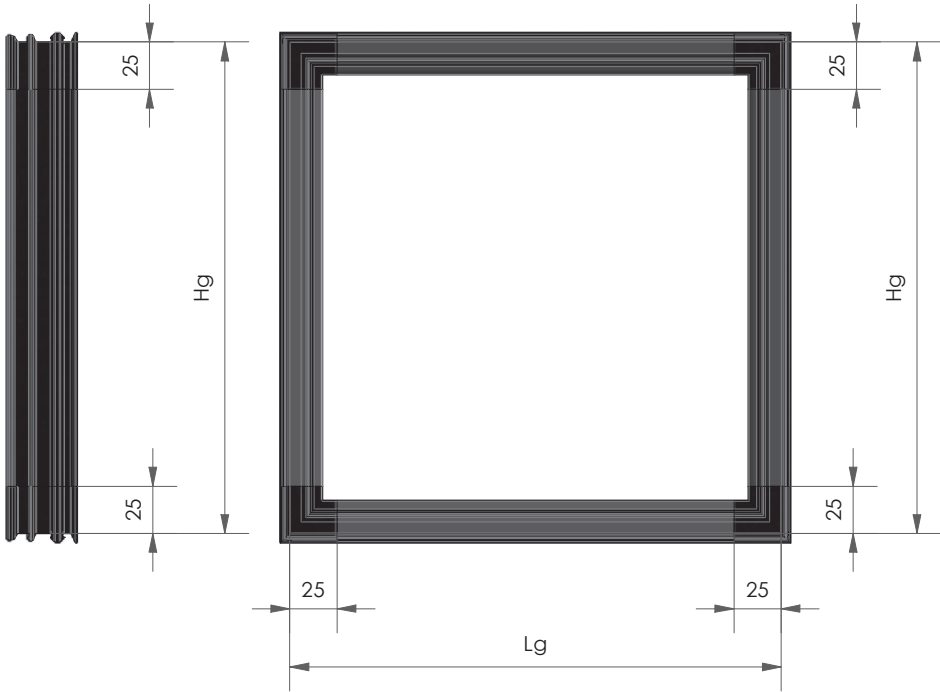
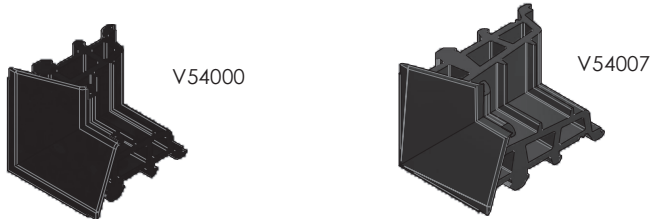
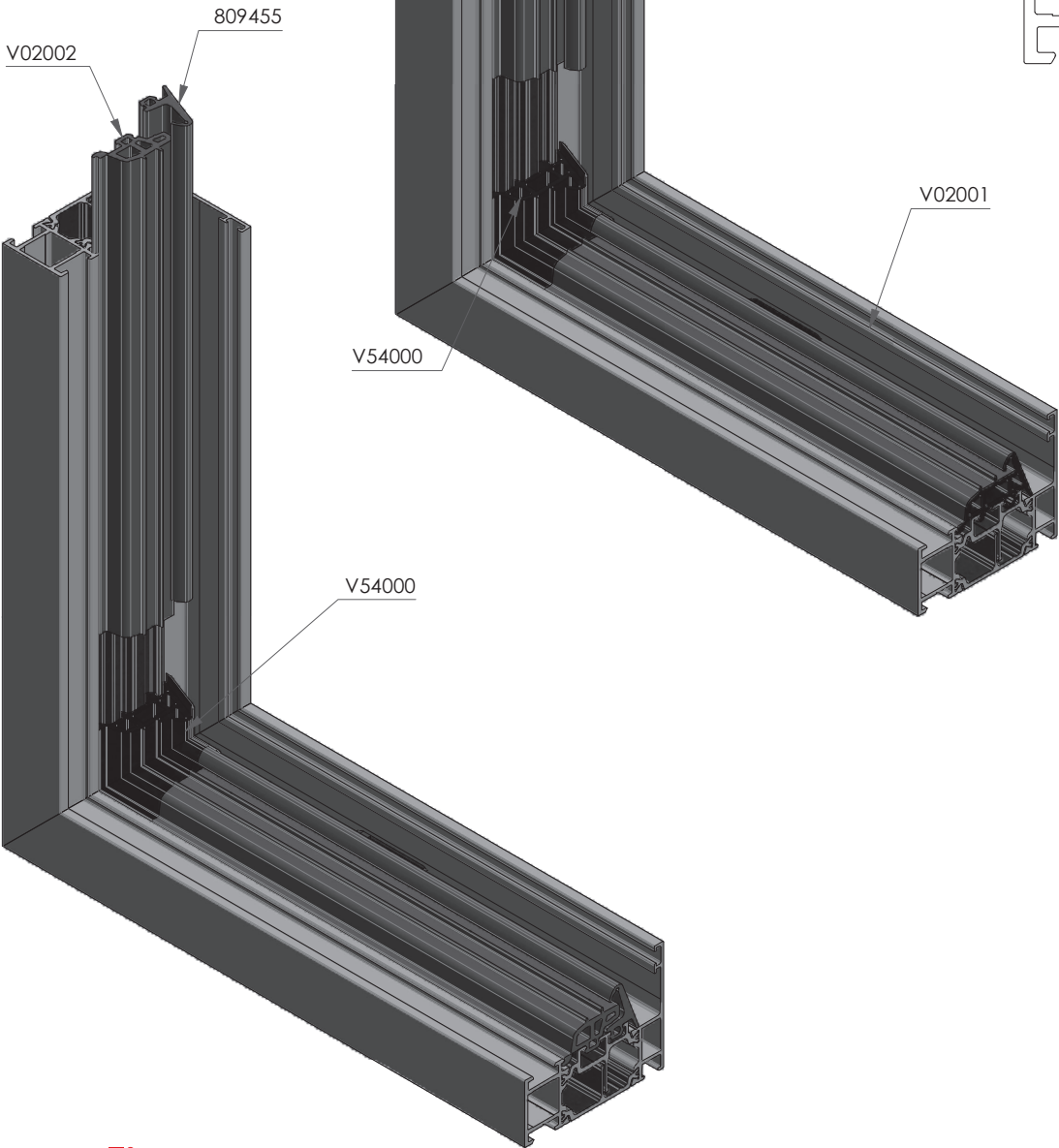
C67K	C77K	C77K-CS
●	●	●

GIUNTO APERTO - CENTRAL GASKET		
SERIE - SERIES	GUARNIZIONE - GASKET	ANGOLO VULCANIZZATO - VULCANIZED CORNER
C67K	V02001	V54000
C77K	V02024	V54007
C77K-CS	V02024	V54007



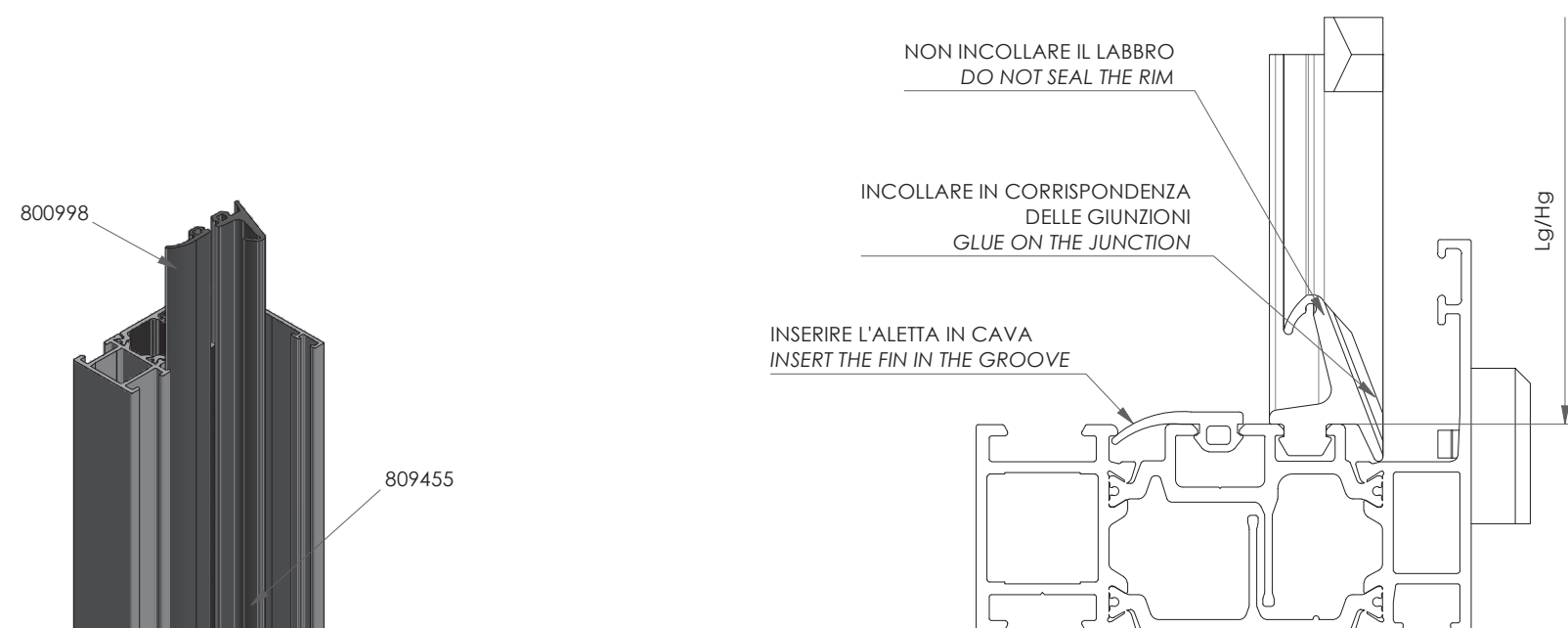
- TAGLIARE LA GUARNIZIONE NEL MODO SEGUENTE:
PER DIMENSIONI CON Lg/Hg SOTTO I 1000 mm = (Lg/Hg-50)+1%
PER DIMENSIONI CON Lg/Hg SOPRA I 1000 mm = (Lg/Hg-50)+0.5%
- SGRASSARE LA ZONA DI INCOLLAGGIO DELLA GUARNIZIONE E DEGLI ANGOLI VULCANIZZATI
- FORMARE CON LA GUARNIZIONE E GLI ANGOLI VULCANIZZATI UN TELAIO 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

SOLUZIONE PER SOLA C67K
SOLUTION FOR C67K ONLY



SCHEMA DI MONTAGGIO GUARNIZIONE DI GIUNTO APERTO 712150 FITTING OF THE 712150 CENTRAL GASKET

C67K	C77K	C77K-CS
●		



- 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

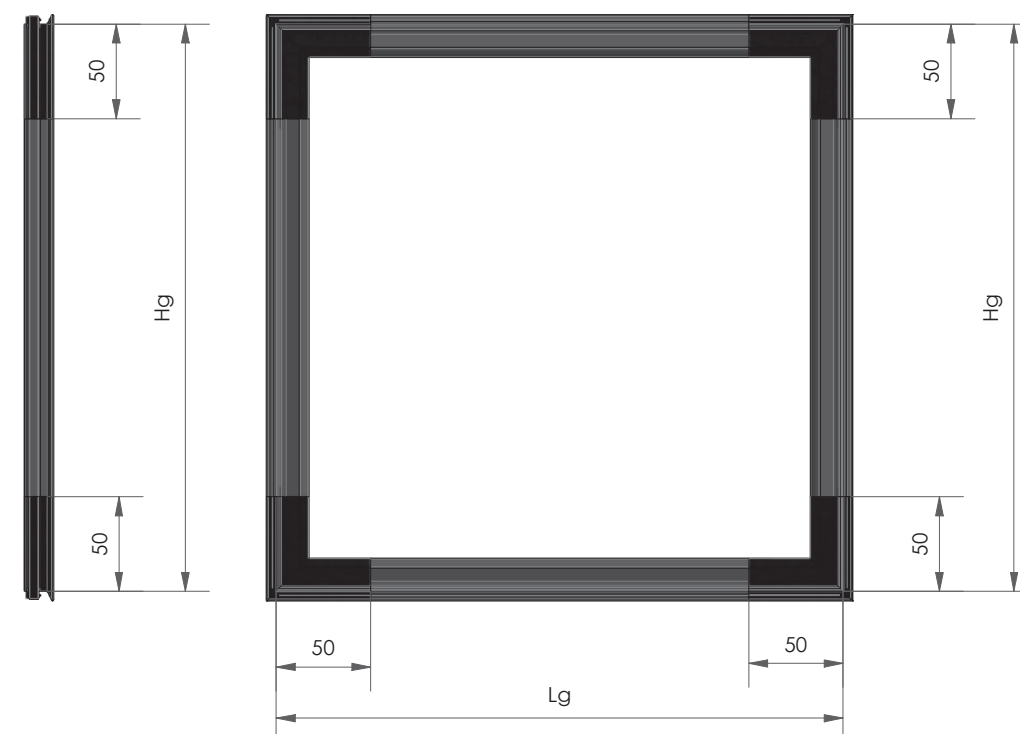
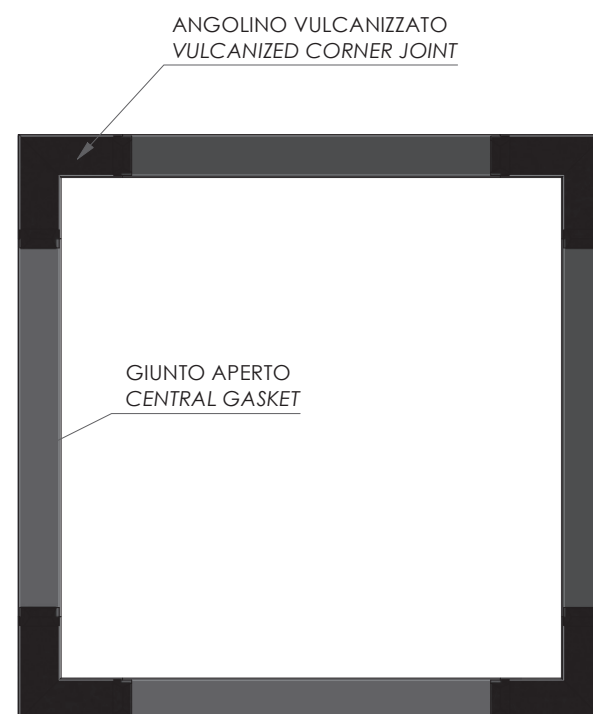
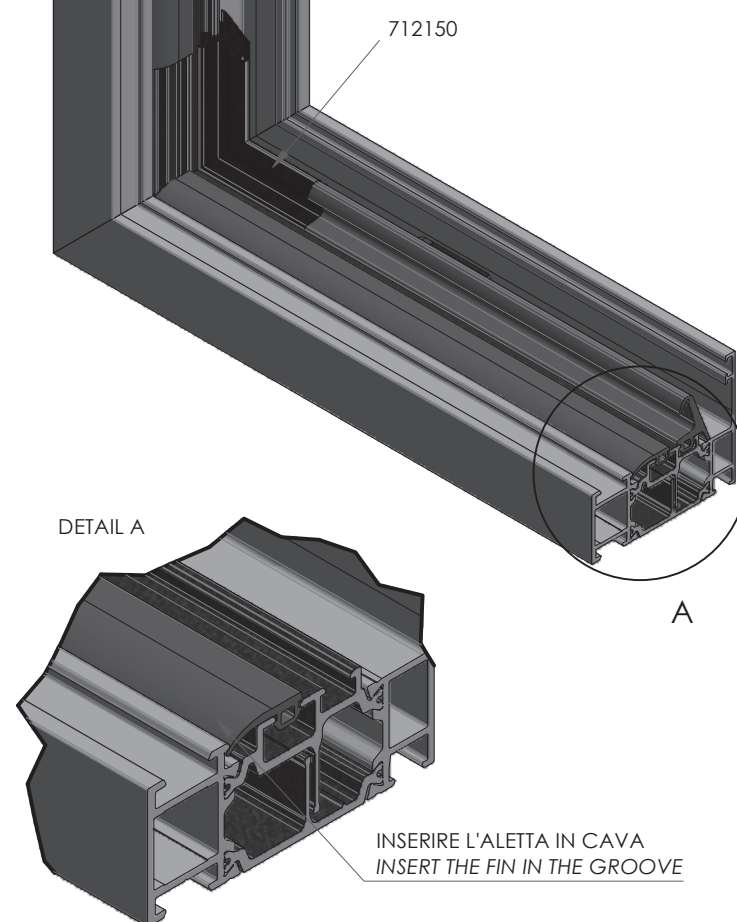
- SIGILLARE LA SEDE DELLA GUARNIZIONE IN CORRISPONDENZA DELL'ANGOLO

- 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

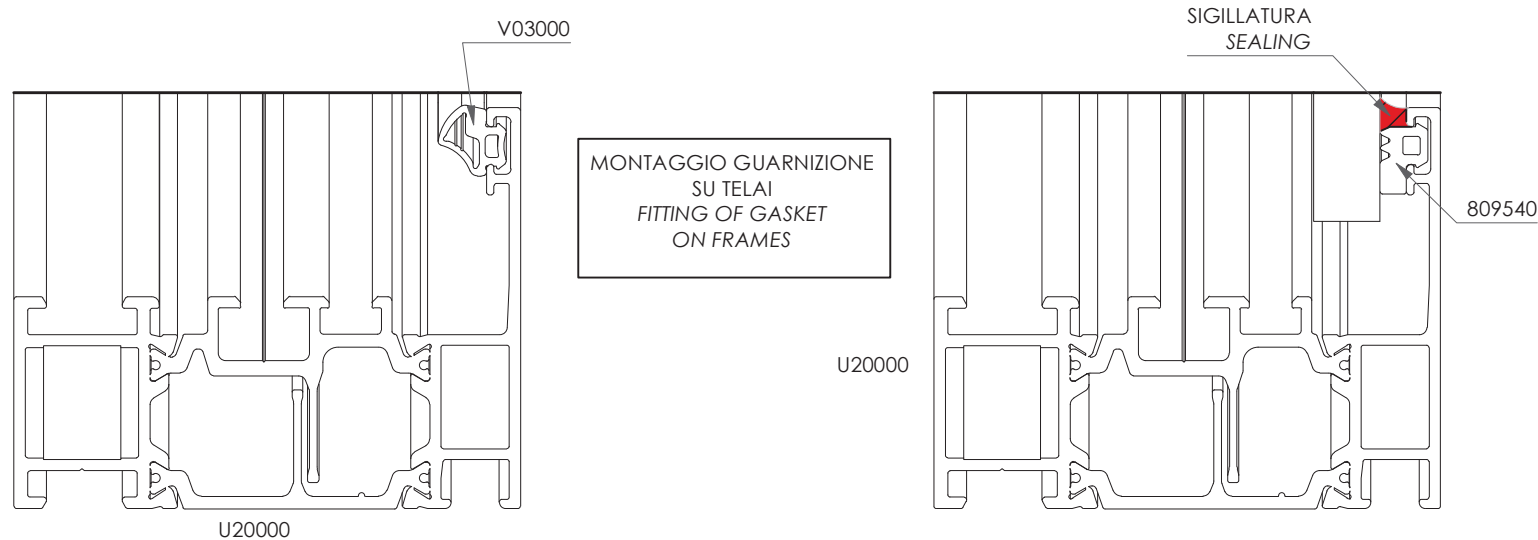
- SEAL THE GASKET SEATING IN CONNECTION WITH CORNER JOINT



SCHEMA DI MONTAGGIO GUARNIZIONI FITTING OF GLAZING GASKET

C67K	C77K	C77K-CS
●	●	

MONTAGGIO GUARNIZIONE ESTERNA VETRO V03000
FITTING OF EXTERNAL GLAZING GASKET V03000



MONTAGGIO GUARNIZIONE
SU TELAI
FITTING OF GASKET
ON FRAMES

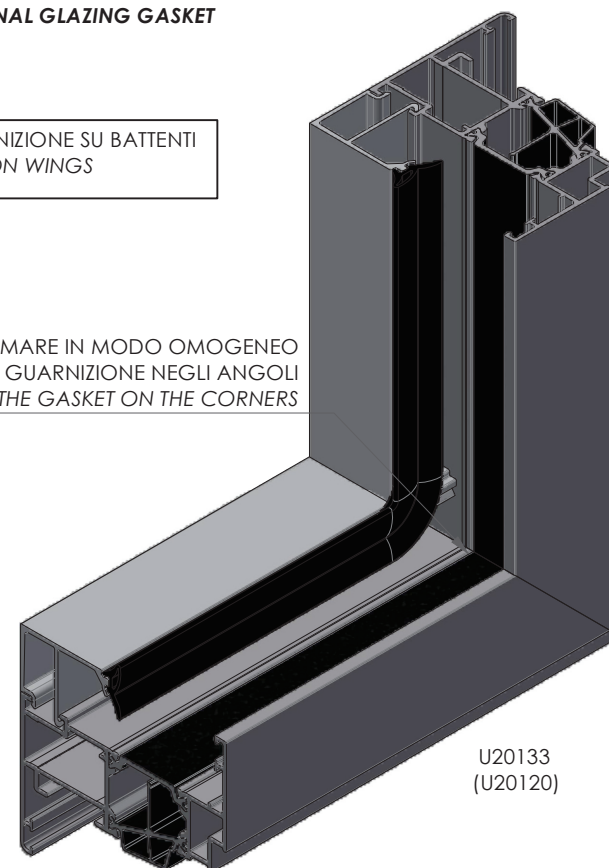
U20000

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

MONTAGGIO GUARNIZIONE INTERNA VETRO
FITTING OF INTERNAL GLAZING GASKET

MONTAGGIO GUARNIZIONE SU BATTENTI
FITTING OF GASKET ON WINGS

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



U20133
(U20120)

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

U20000

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

U20133
(U20120)

MONTAGGIO GUARNIZIONE V03000
SU BATTUTA INTERNA ANTE
FITTING OF V03000 GASKET ON
WING INTERNAL REBATE

ANGOLO PARASPIGOLO OPZIONALE V54013
OPTIONAL CORNER PROTECTOR V54013

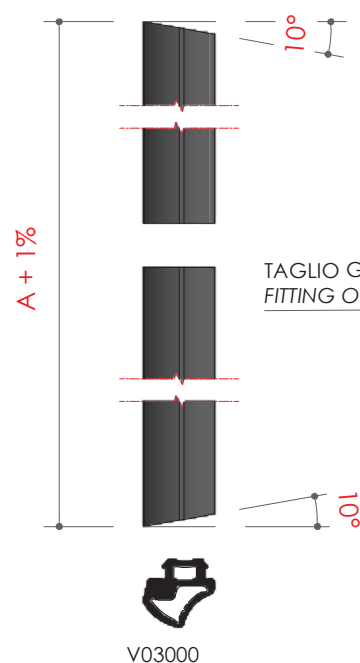
V03000 TAGLIATA A 45°
V03000 45° CUTTED

MONTAGGIO GUARNIZIONE
SU GIUNZIONE A T
FITTING OF GASKET ON T-JOINTS

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

809119 *
809120
809121
809122

* LA GUARNIZIONE 809119 NON
E' MICROTAGLIATA
809119 GASKET NOT CARVED

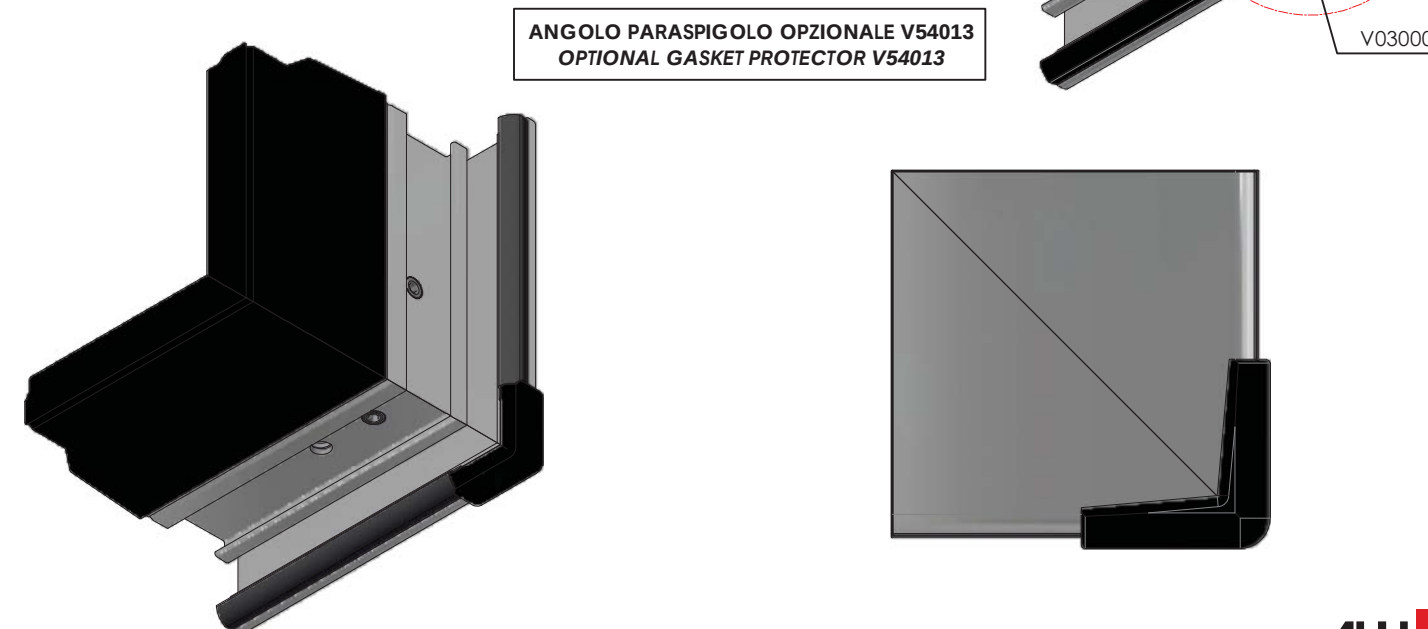
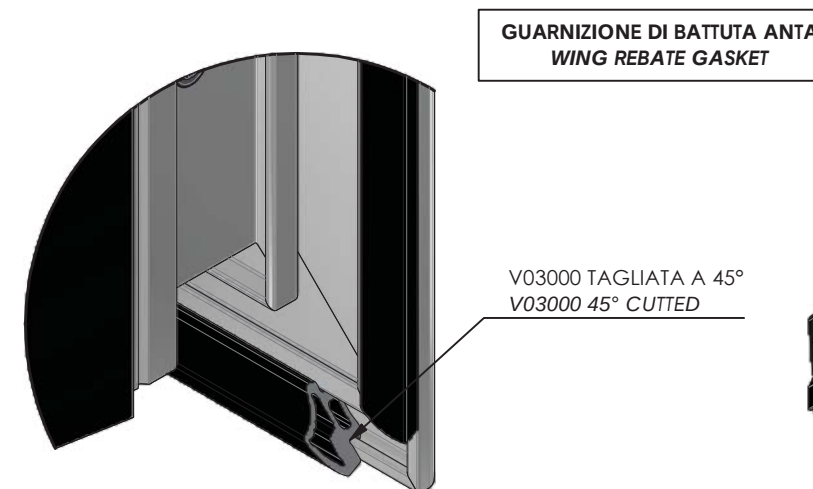
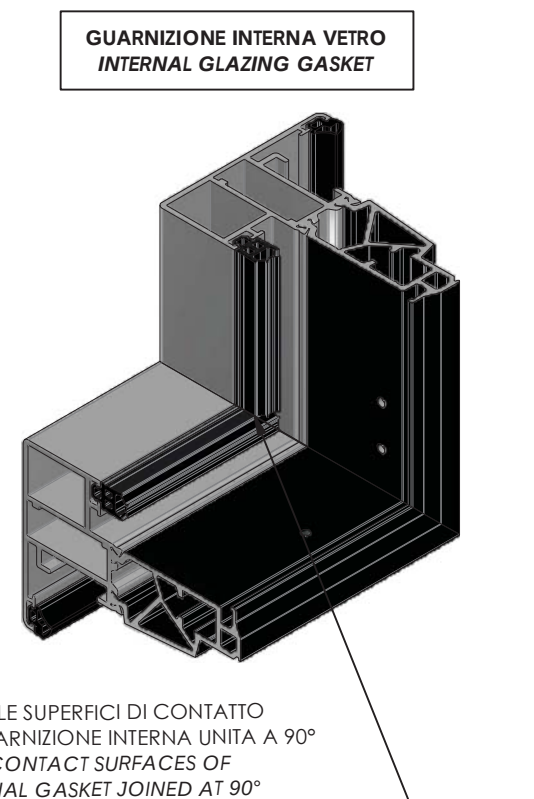
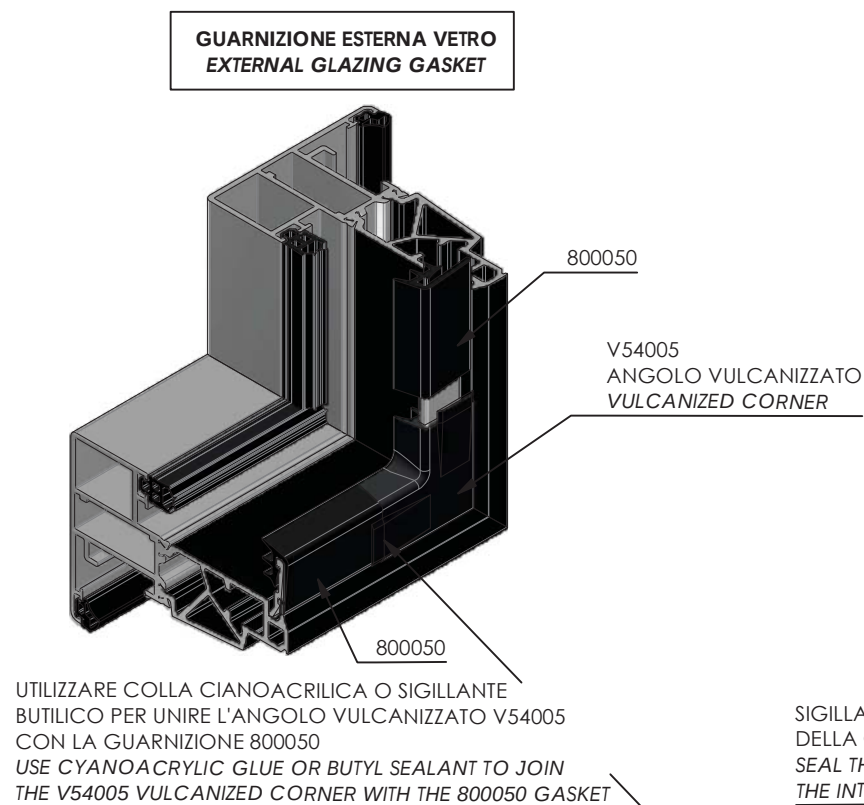
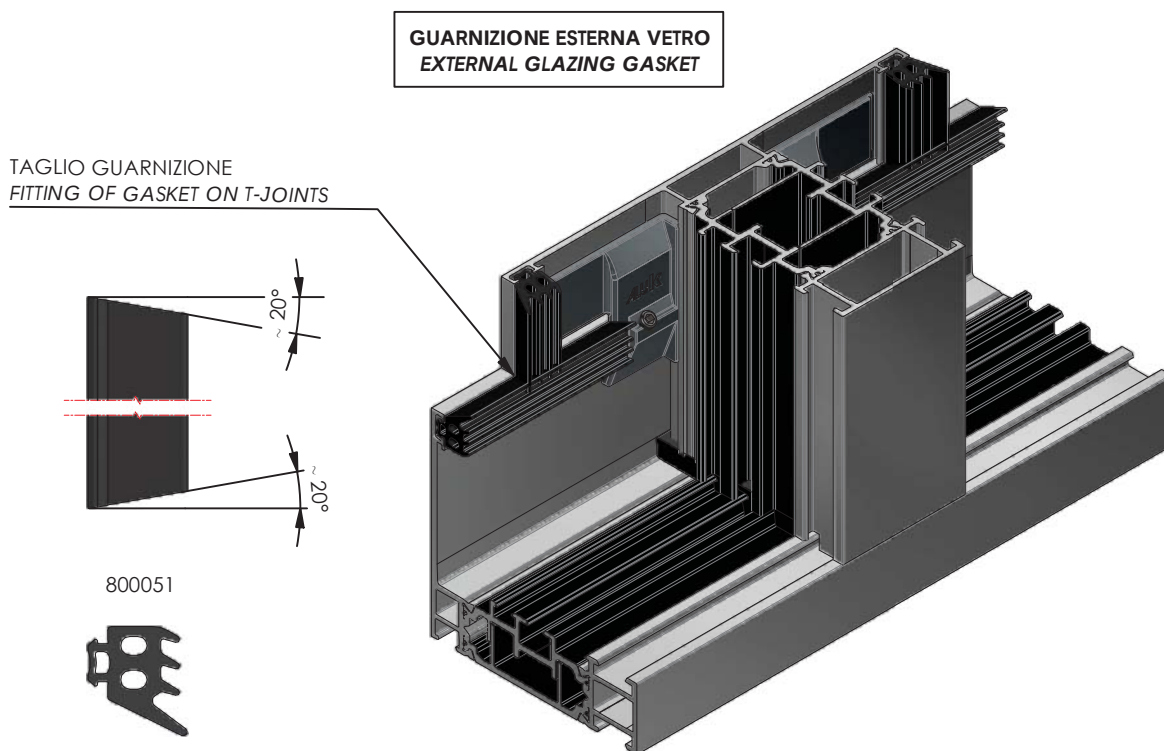
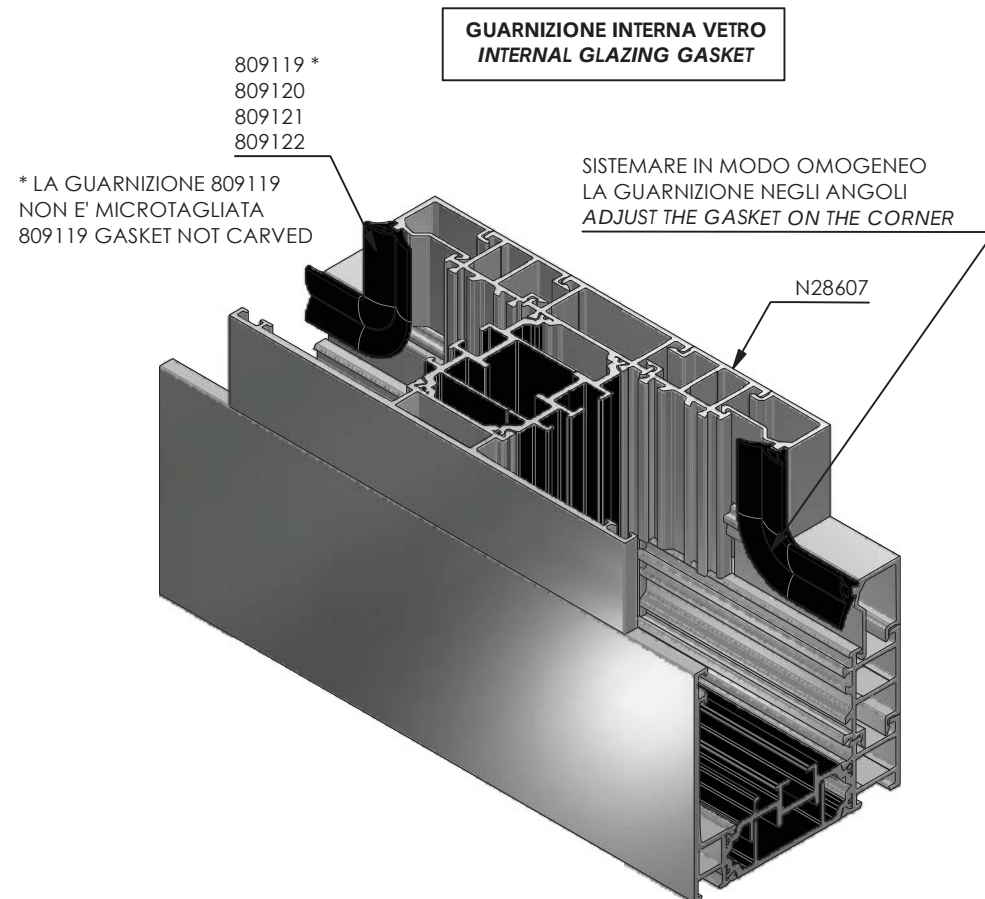


TAGLIO GUARNIZIONE
FITTING OF GASKET ON T-JOINTS

V03000

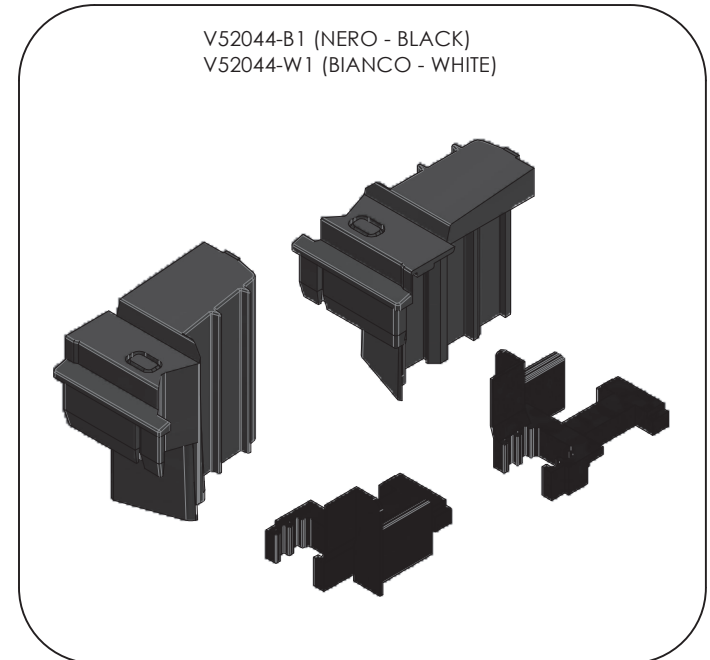
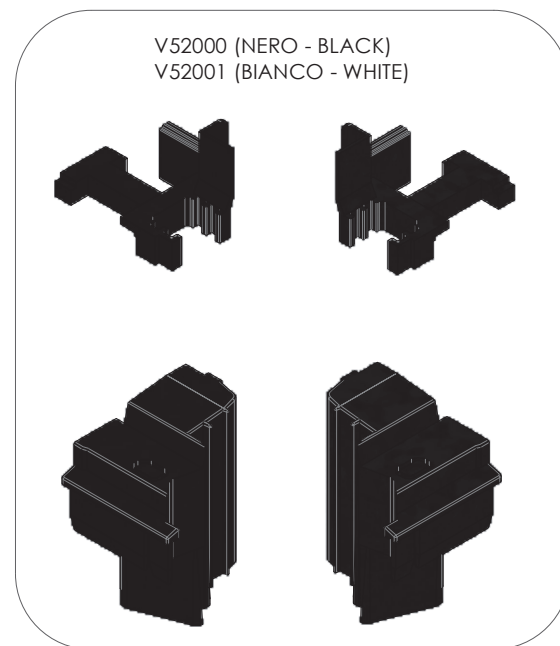
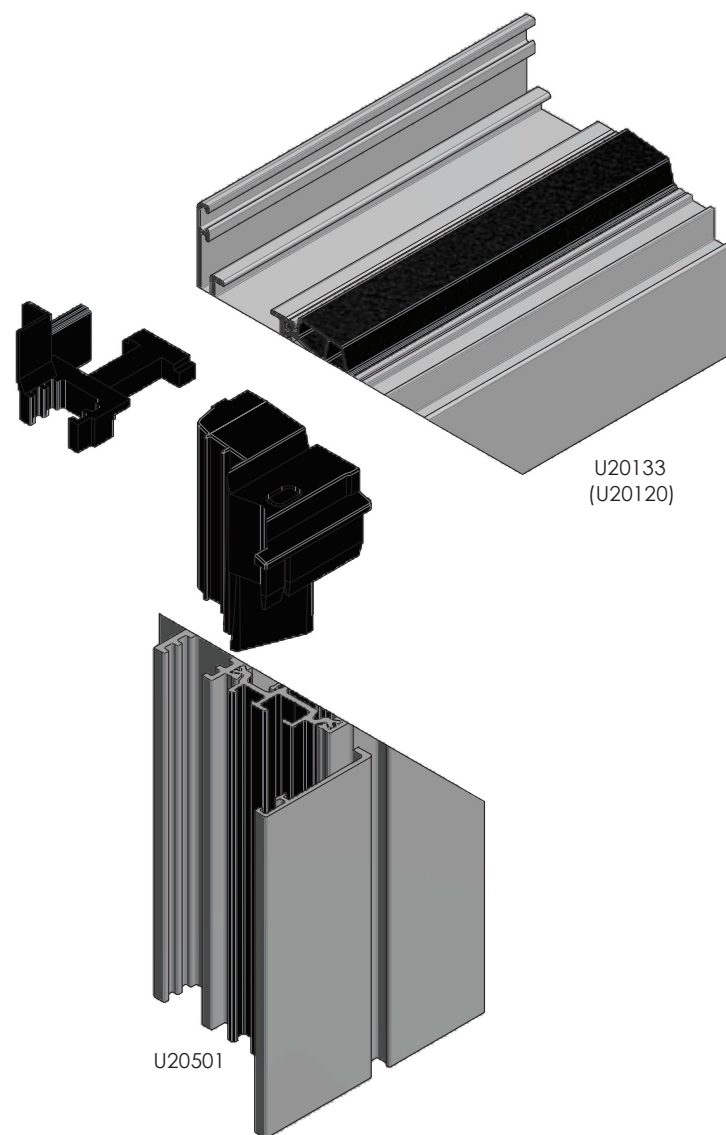
SCHEMA DI MONTAGGIO GUARNIZIONI FITTING OF GLAZING GASKET

C67K	C77K	C77K-CS
		●

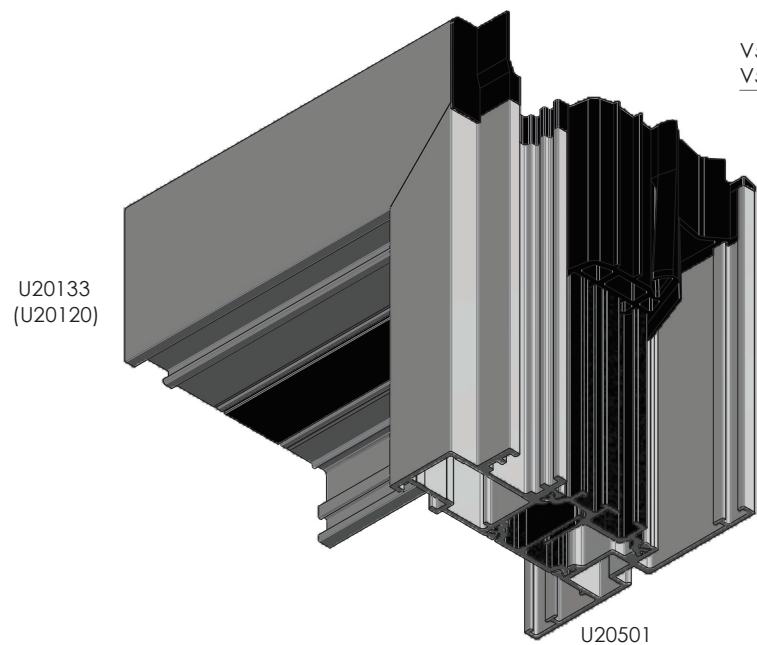
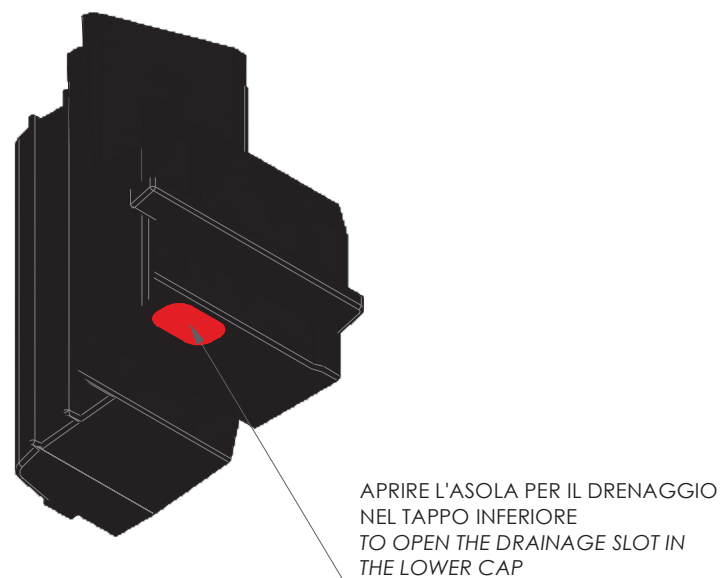


▶ SCHEMA DI MONTAGGIO TAPPI CENTRALI DUE ANTE TZ
 TWO-WINGS WINDOW CENTRAL SEALING PLUGS ASSEMBLING DIAGRAM

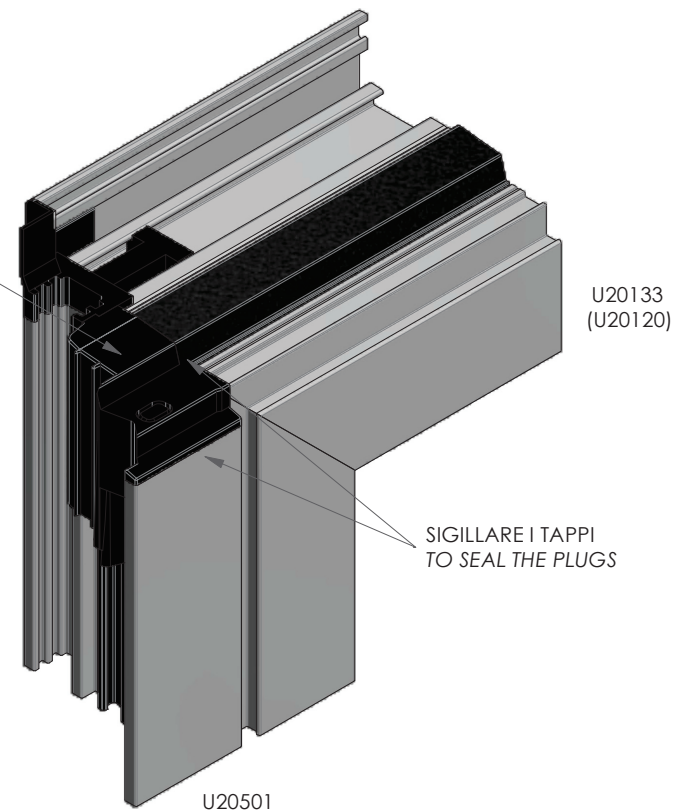
C67K	C77K	C77K-CS
●	●	



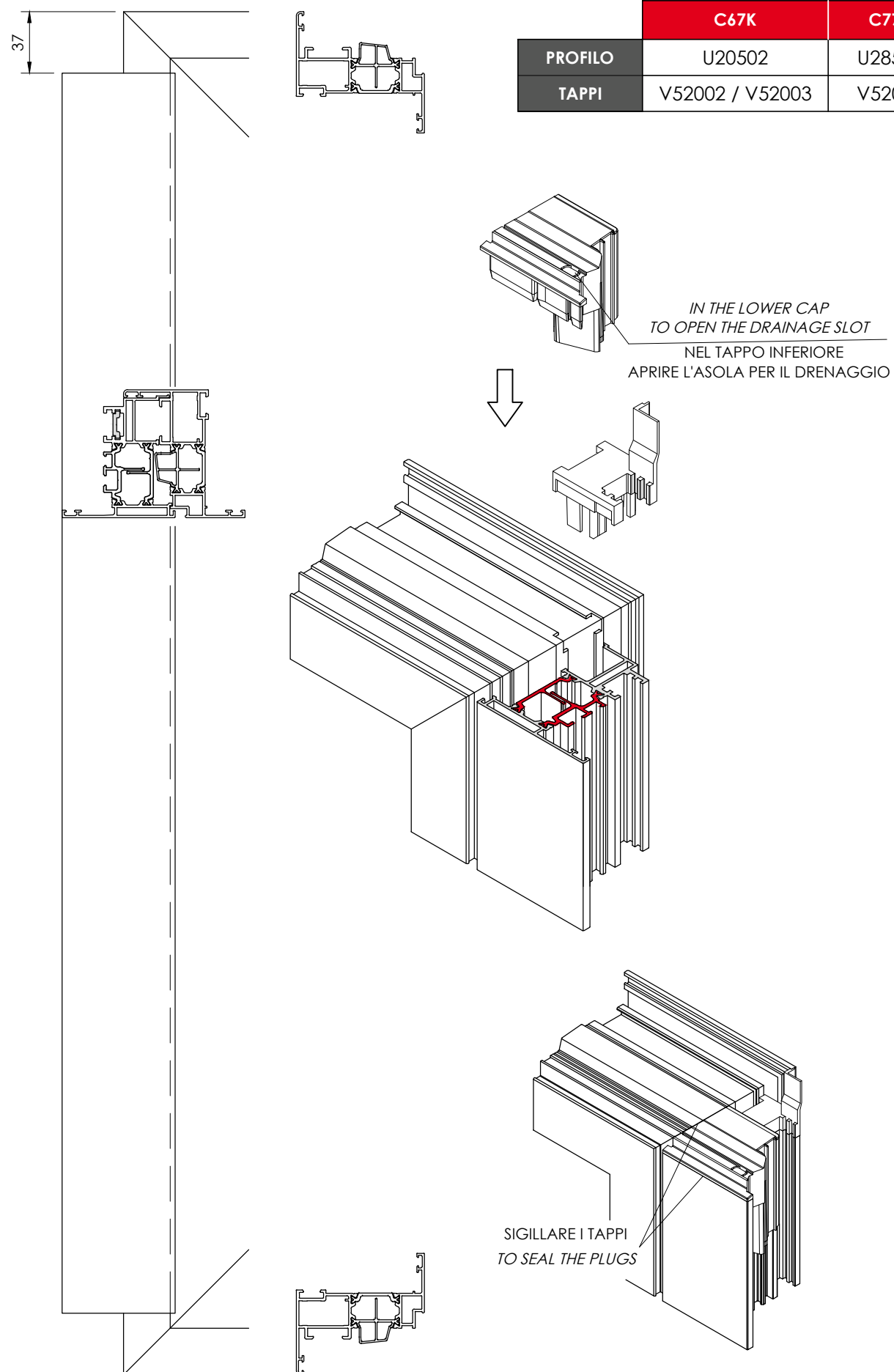
TAPPI STULP - "STULP" PLUGS		
SERIE - SERIES	PROFILI - PROFILES	KIT TAPPI - PLUGS KIT
C67K	U20501	V52000
C77K	U28501	V52044



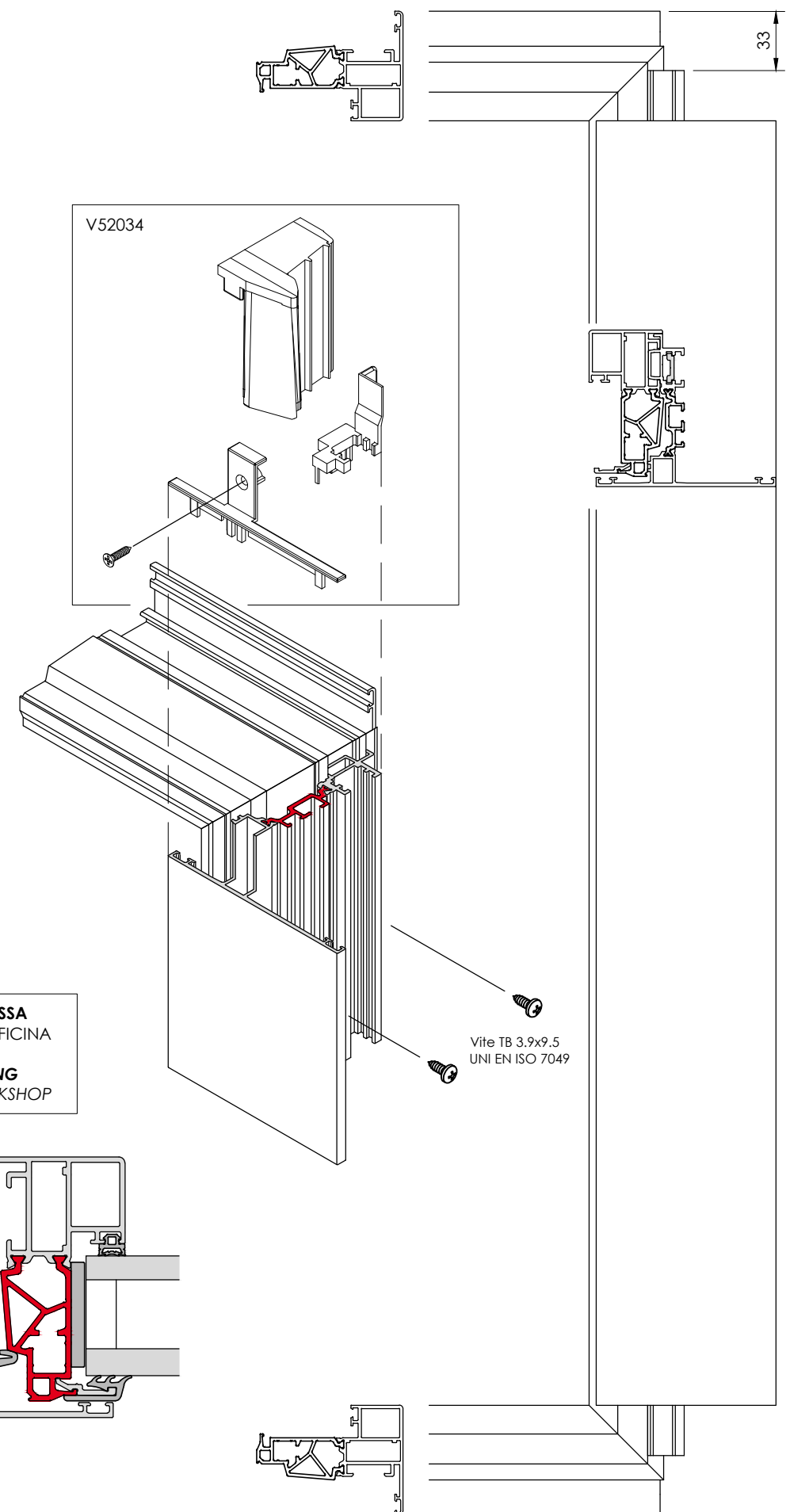
V52000 (C67K)
V52044 (C77K)



▶ SCHEMA DI MONTAGGIO TAPPI STULP STULP PLUGS DIAGRAM ASSEMBLING

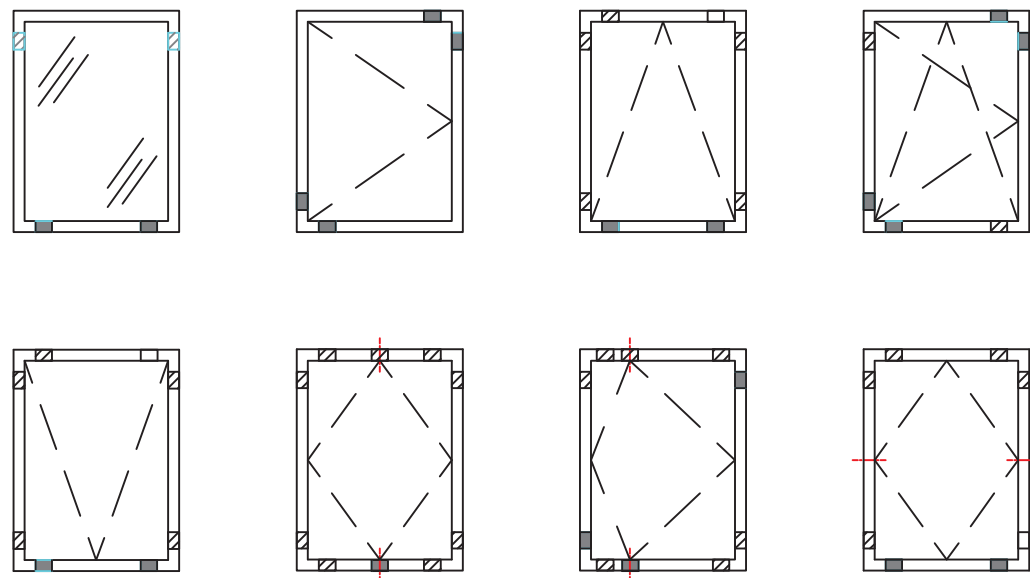


C77K-CS	PROFILO
U28500	
TAPPI	
V52034	



SCHEMA DI MONTAGGIO TASSELLI VETRO GLASS CLEATS DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	

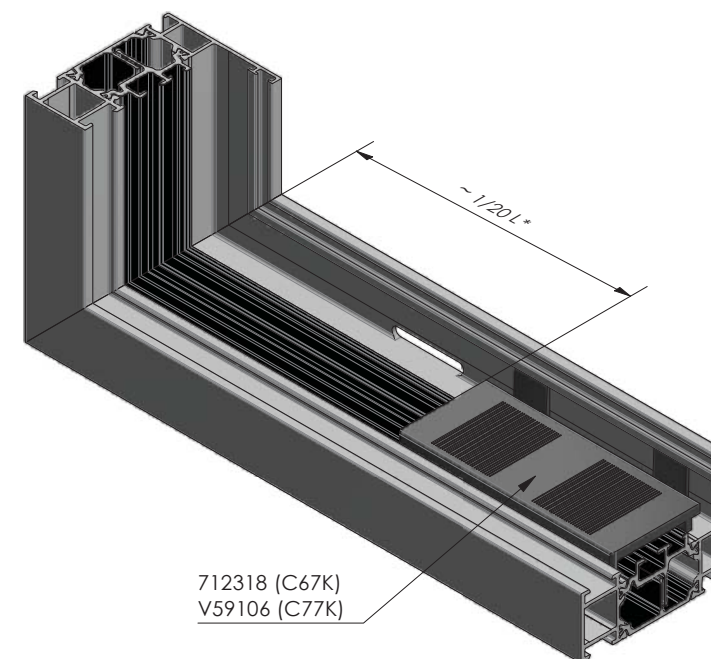
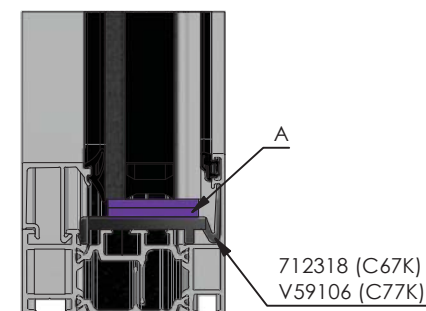


- TASSELLI DI APPOGGIO - I tasselli di appoggio devono essere disposti secondo gli schemi sopra indicati ad una distanza dal bordo esterno del vetro fra $\frac{1}{10}$ e $\frac{1}{20}$ della larghezza del vetro.
- ☑ TASSELLI PERIFERICI - I tasselli periferici assicurano il posizionamento del vetro. Detti tasselli devono essere inseriti, senza forzare, fra il vetro ed il telaio in modo da assicurare la stabilità del vetro.

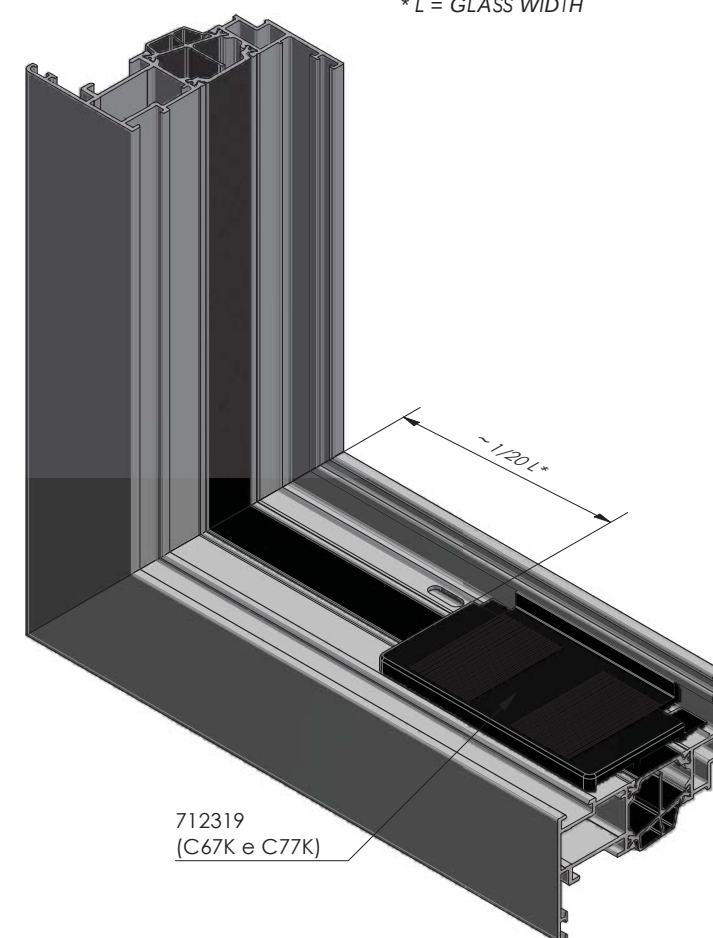
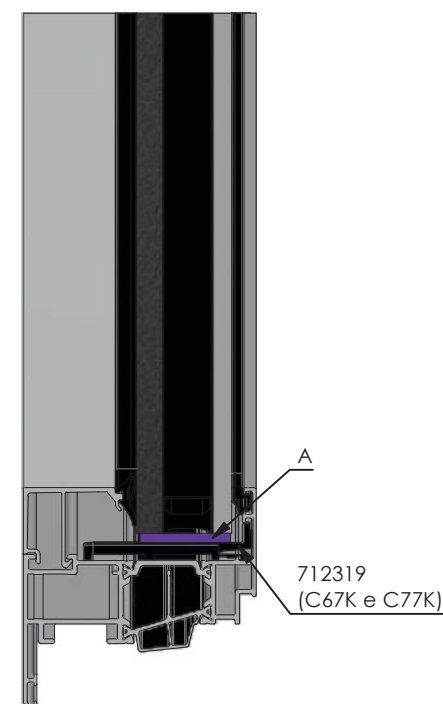
A Per la vetratura di dovranno utilizzare tasselli di spessore adeguato.

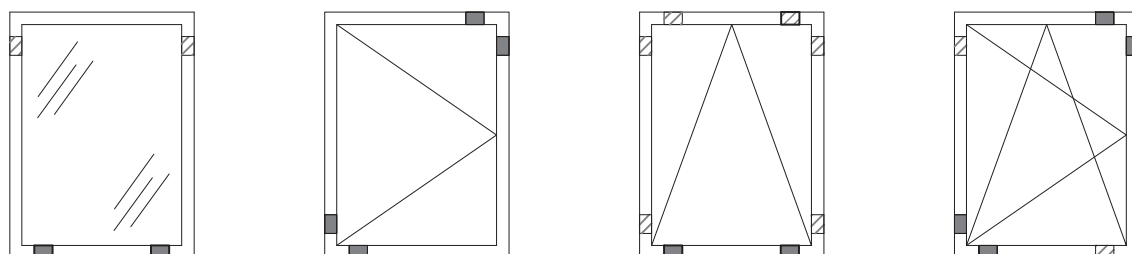
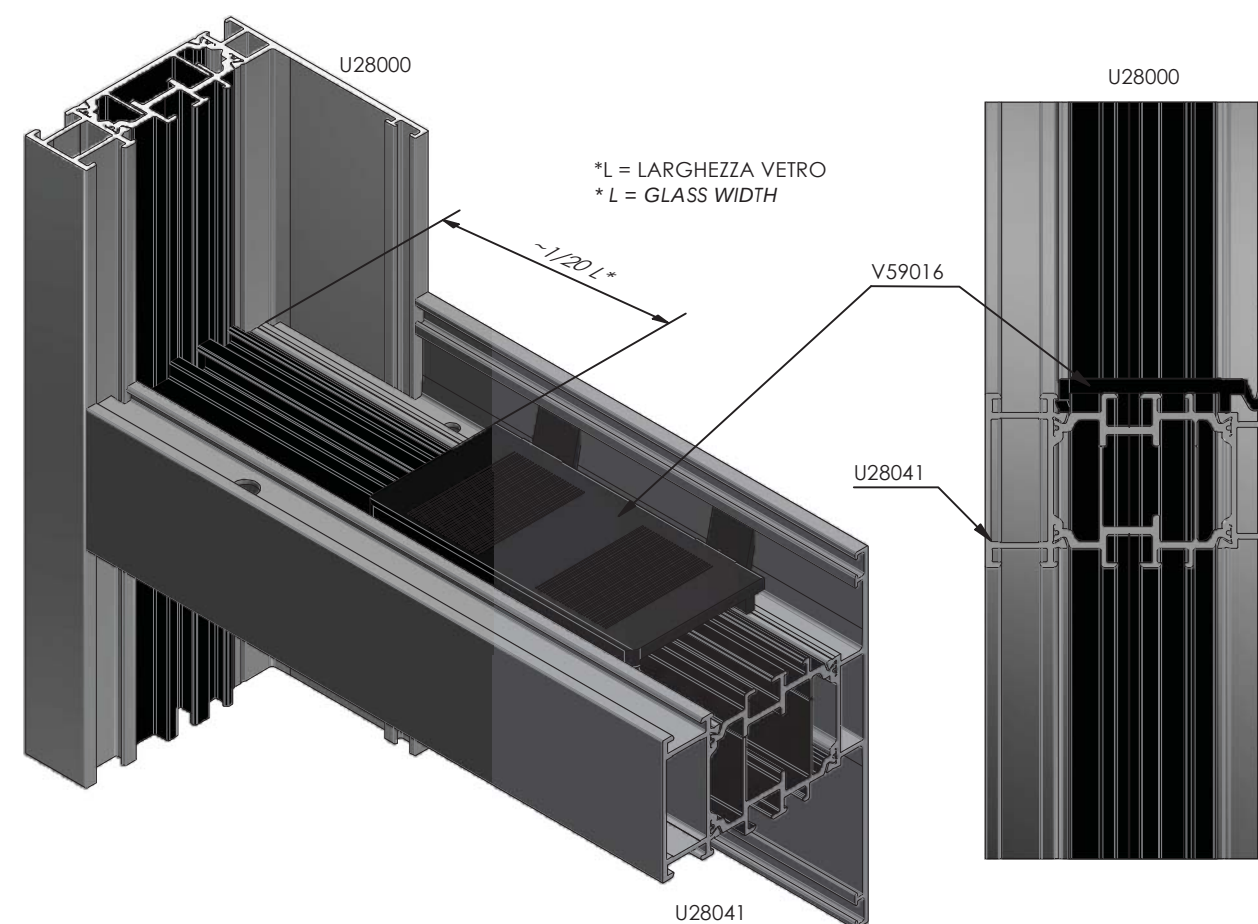
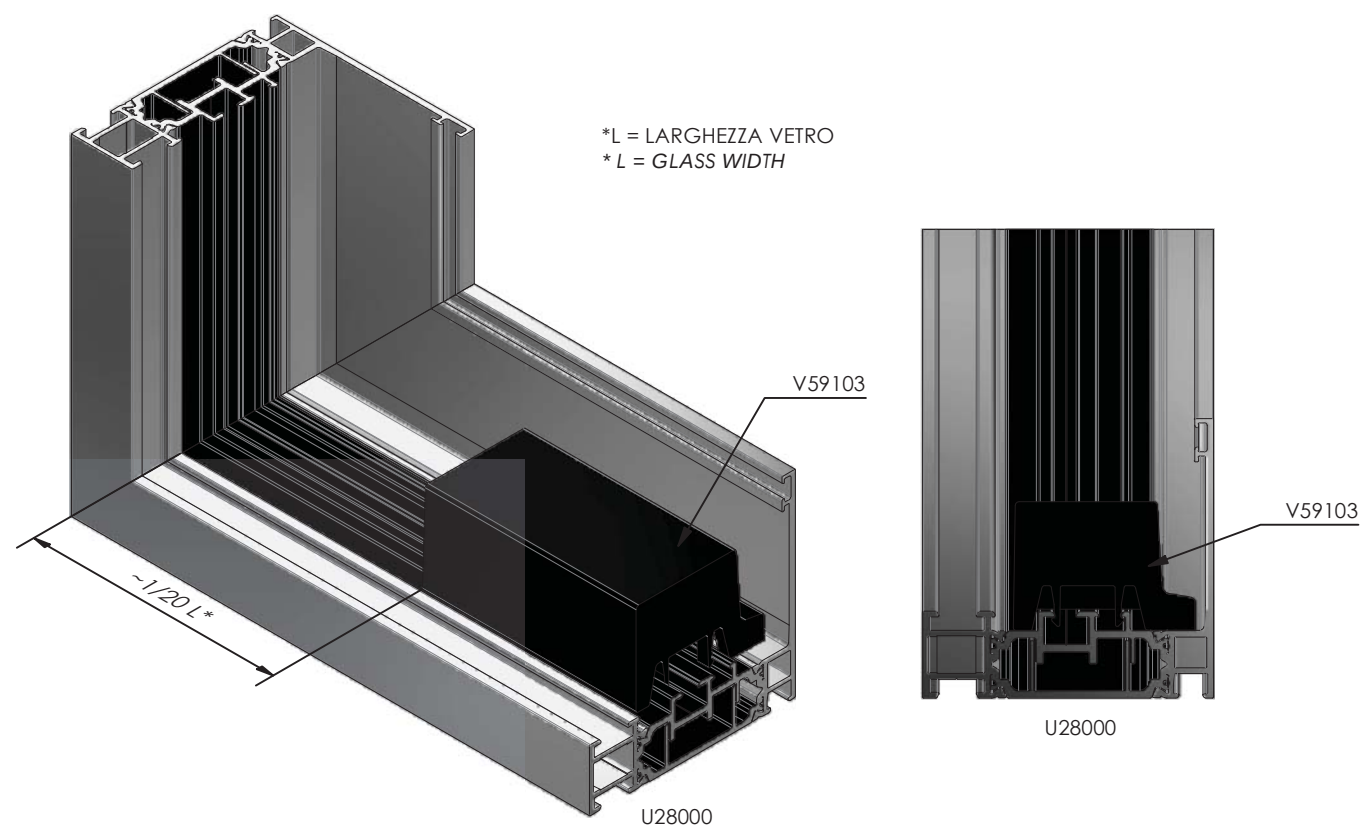
- BEARING CLEATS - Bearing cleats must be installed according to the sketches drawn above. Their distance from the glass external edge must be between $\frac{1}{10}$ th and $\frac{1}{20}$ th the width of the glass.
- ☑ SIDE SETTING CLEATS - Side setting cleats hold the glass pane in position. These cleats must be inserted without forcing them, between the glass and the frame in order to be sure that the glass is stable.

A As for glazing, should be used appropriately thick glass cleats.



*L = LARGHEZZA VETRO
* L = GLASS WIDTH





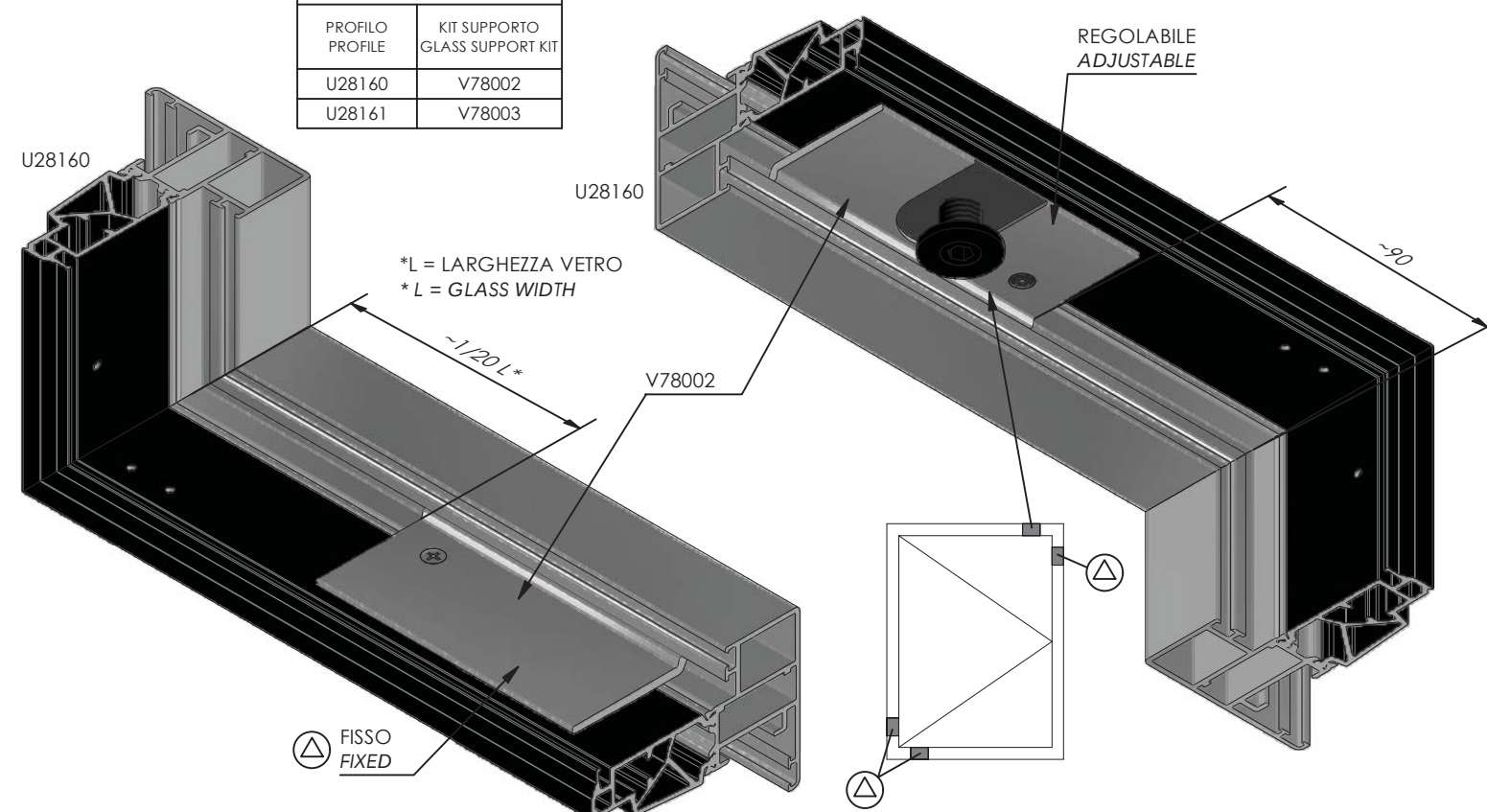
- ☐ **TASSELLI DI APPOGGIO** - I tasselli di appoggio devono essere disposti secondo gli schemi sopra disegnati ad una distanza dal bordo esterno del vetro fra $\frac{1}{10}$ e $\frac{1}{20}$ della larghezza del vetro.
- ☒ **TASSELLI PERIFERICI** - I tasselli periferici assicurano il posizionamento del vetro. Detti tasselli devono essere inseriti, senza forzare, fra il vetro ed il telaio in modo da assicurare la stabilità del vetro.

A Per la vetratura di dovranno utilizzare i tasselli art. 712320÷712334, impiegati secondo necessità.

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

A As for glazing, specific cleats must be used the flats art. 712320÷712334 shall be used are required.

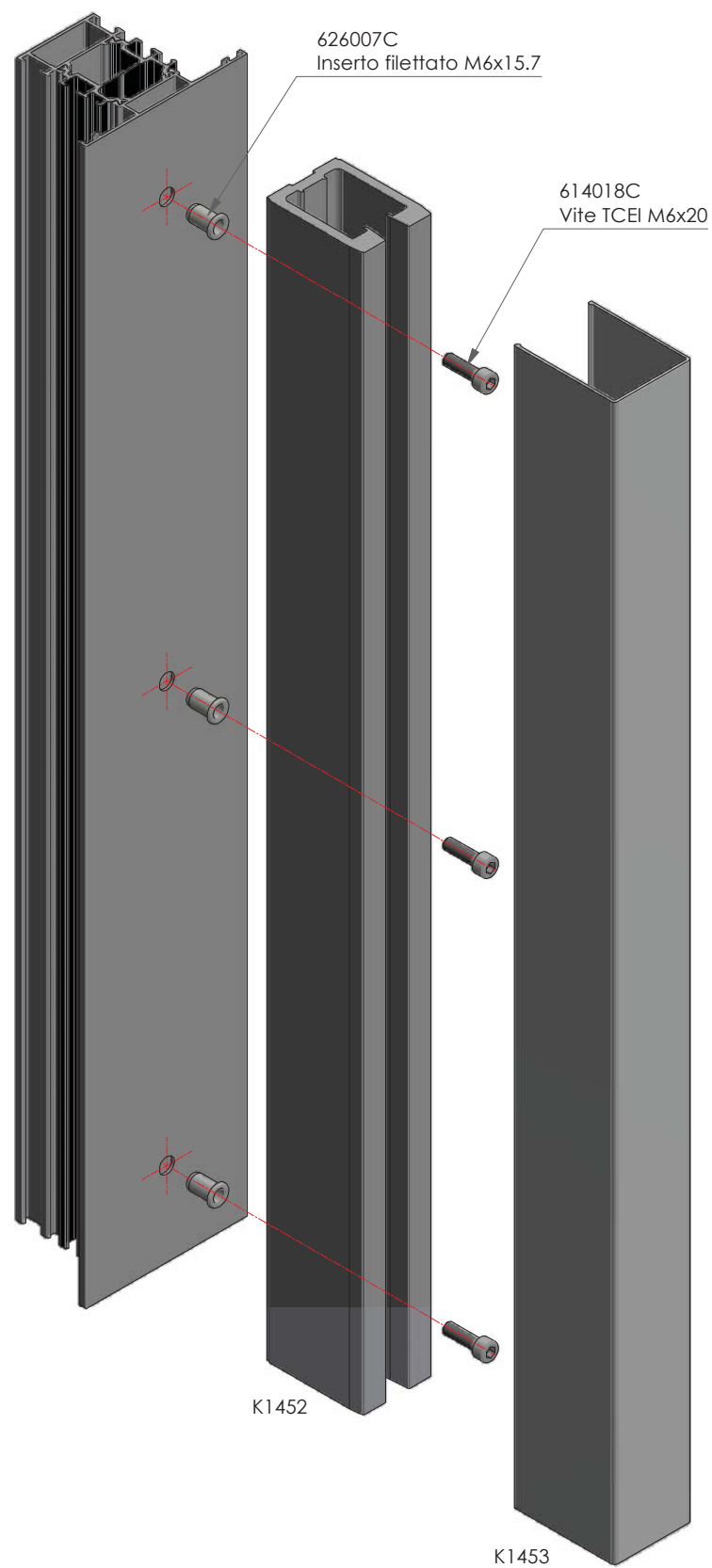
TABLE	
PROFILO PROFILE	KIT SUPPORTO GLASS SUPPORT KIT
U28160	V78002
U28161	V78003



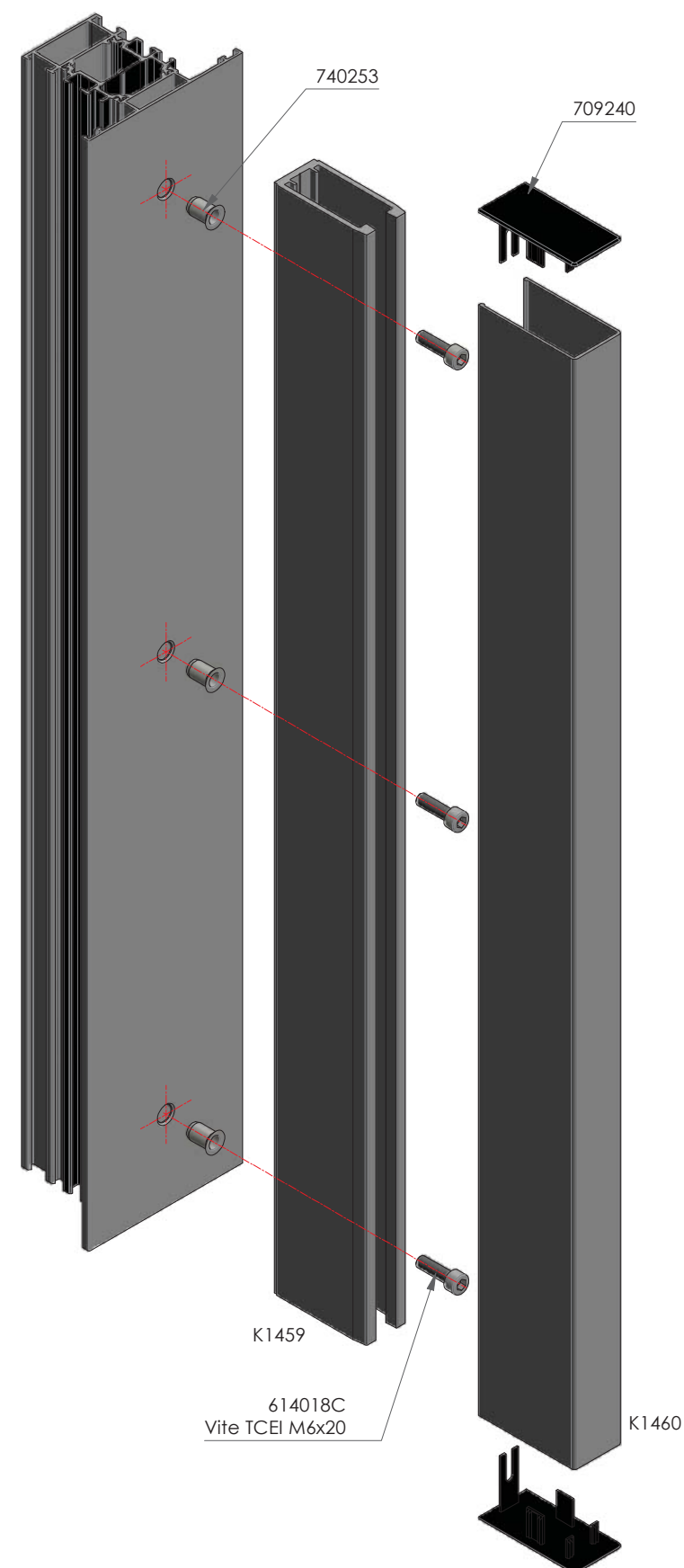
> SCHEMA DI MONTAGGIO RINFORZO STIPITE
 FIXED FRAME COLUMN REINFORCEMENT DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	●

RINFORZO COLONNINA K1452
 K1452 COLUMN REINFORCEMENT



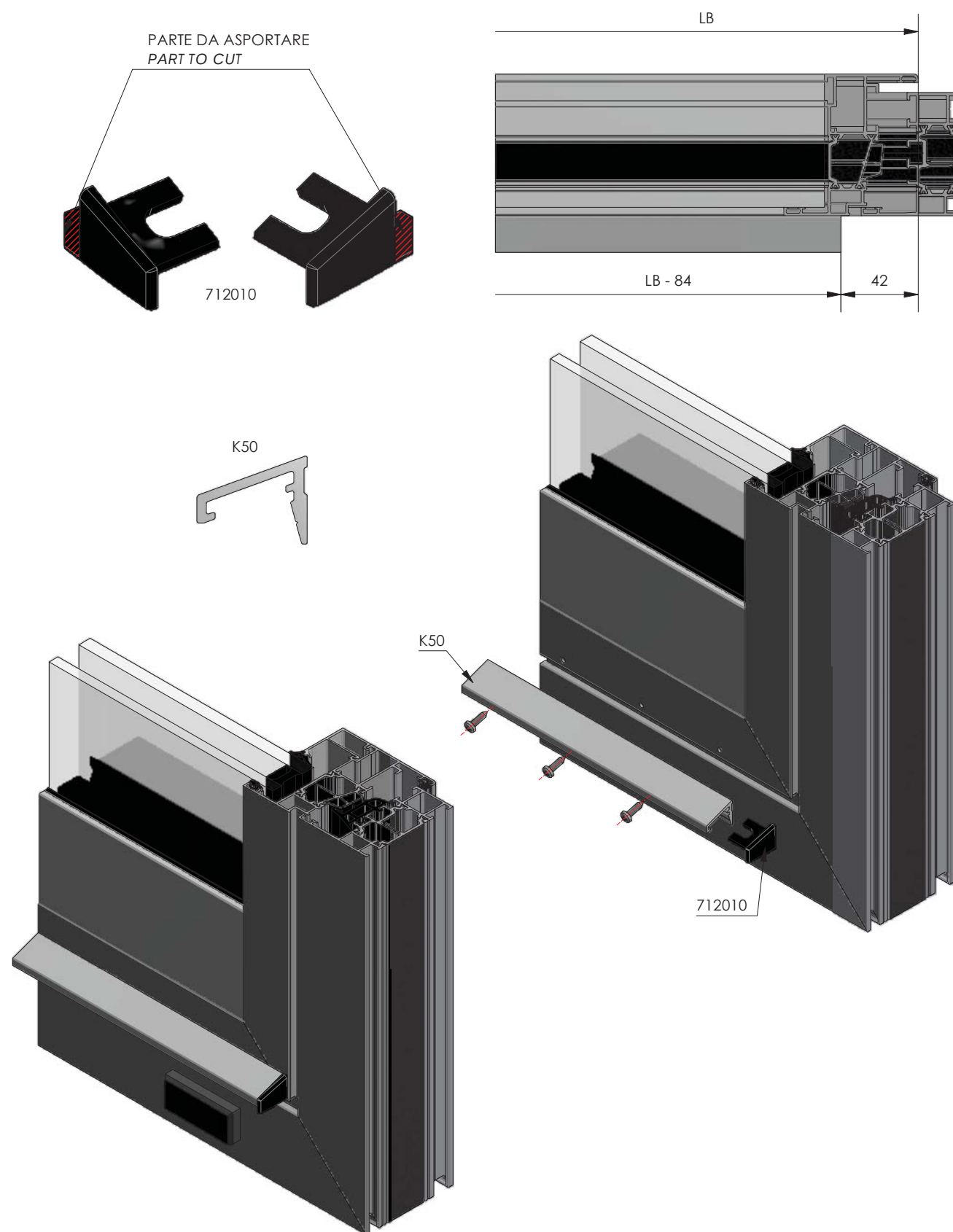
RINFORZO COLONNINA K1459
 K1459 COLUMN REINFORCEMENT



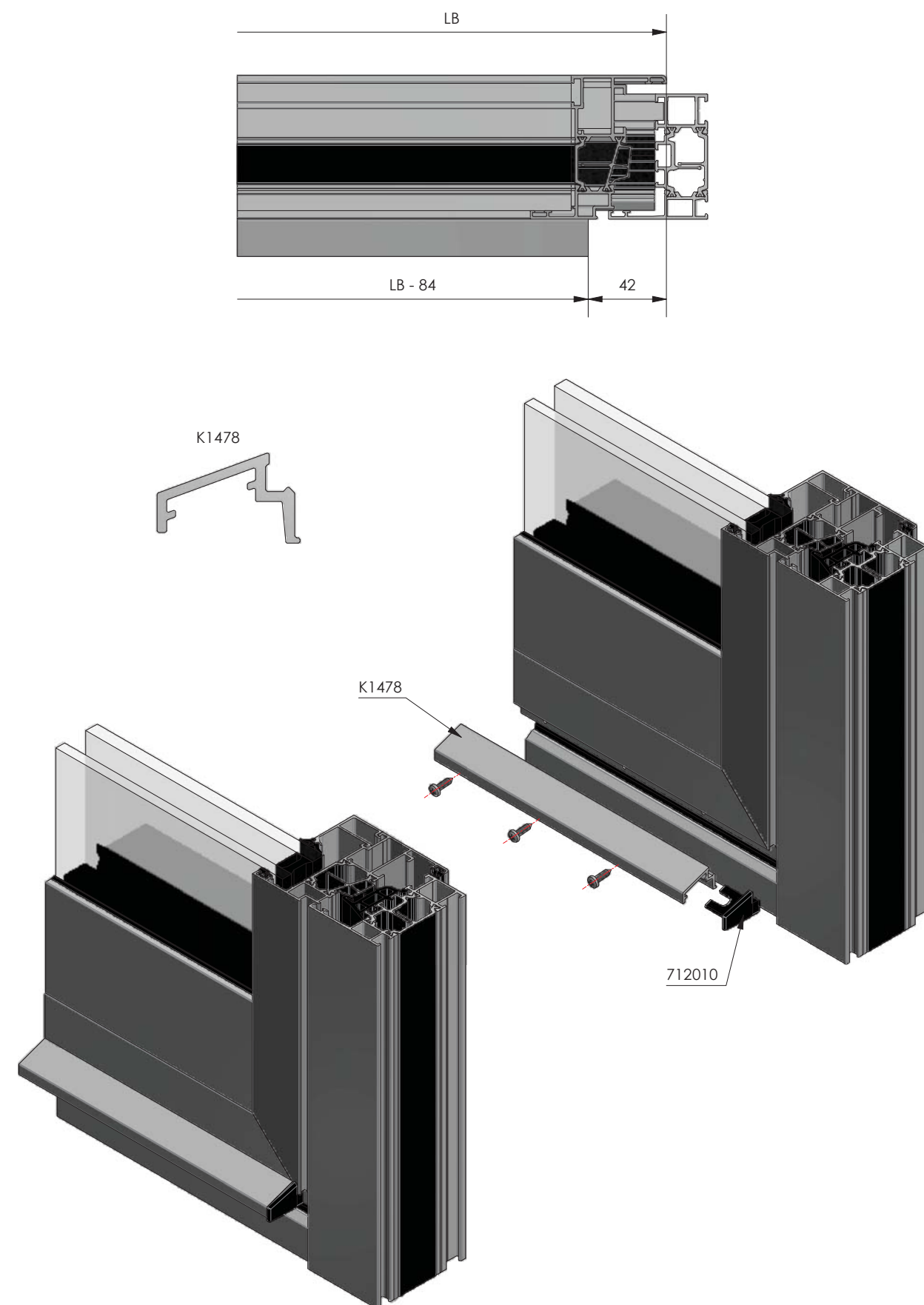
SCHEMA DI MONTAGGIO TAPPI GOCCIOLATOIO **DRIP PLUGS DIAGRAM ASSEMBLING**

C67K	C77K	C77K-CS
●	●	

SCHEMA MONTAGGIO TAPPI 712010 SU GOCCIOLATOIO K50
712010 PLUGS ASSEMBLING DIAGRAM ON K50



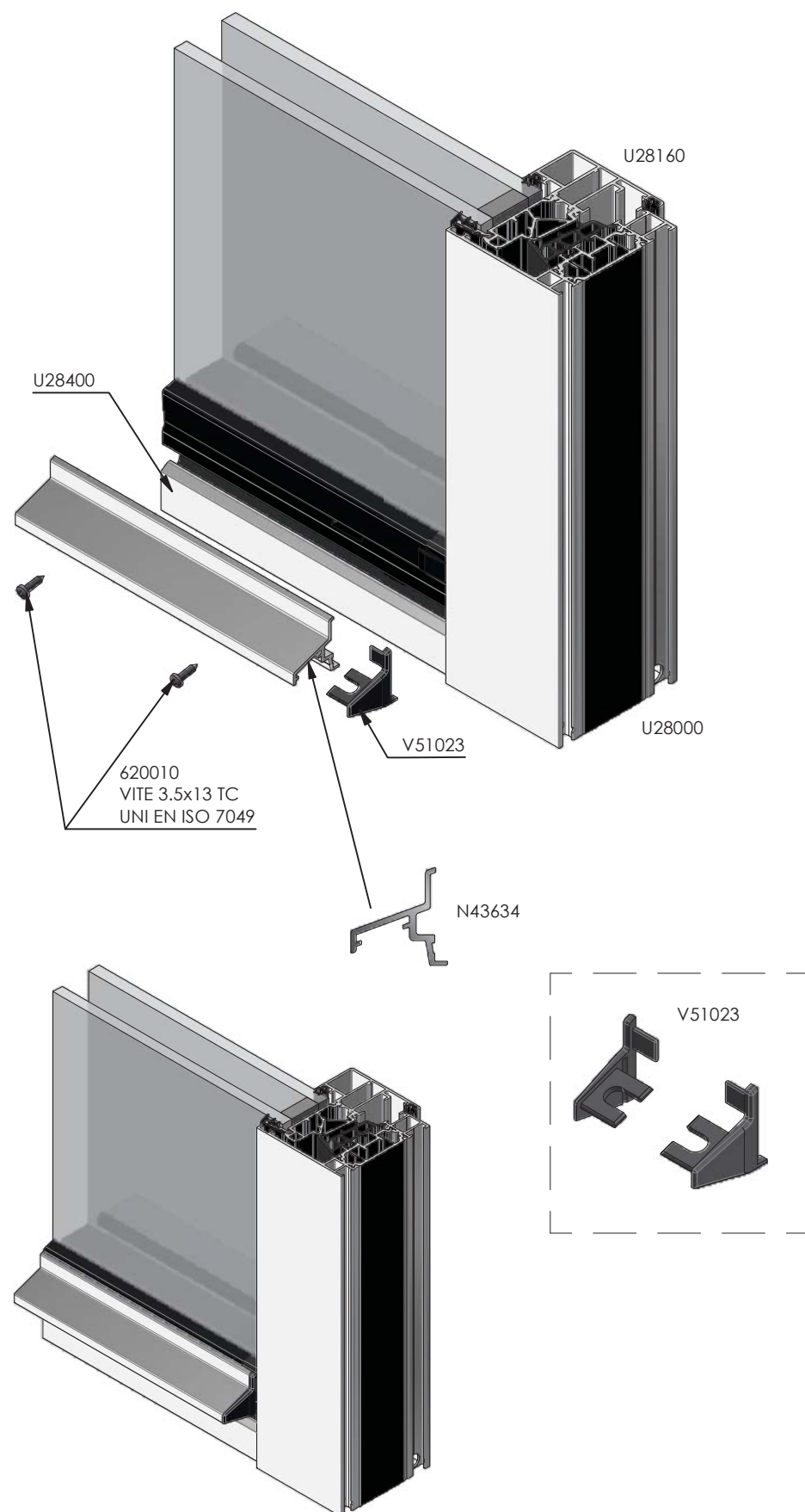
SCHEMA MONTAGGIO TAPPI 712010 SU GOCCIOLATOIO K1478
712010 PLUGS ASSEMBLING DIAGRAM ON K1478



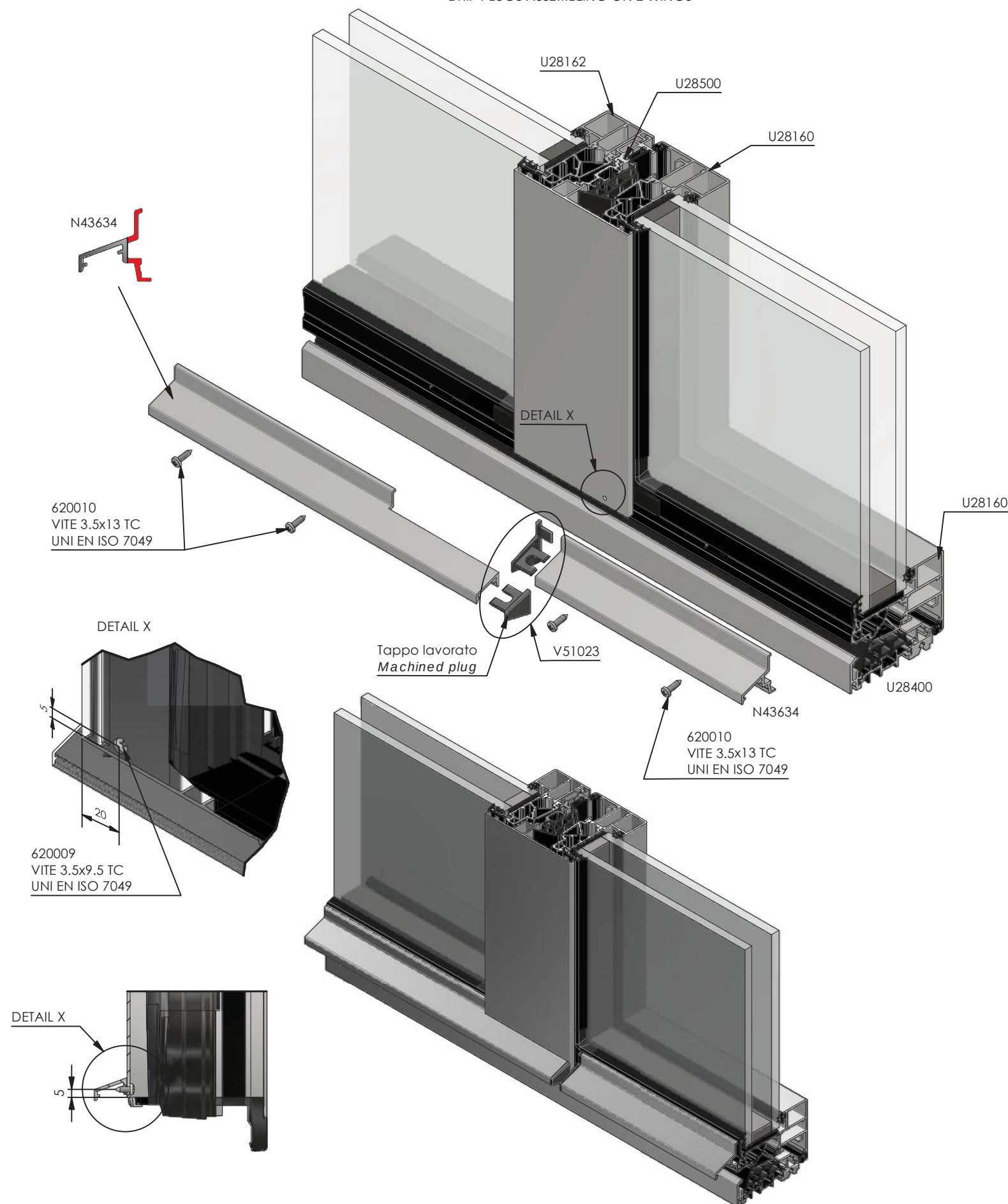
SCHEMA DI MONTAGGIO TAPPI GOCCIOLATOIO DRIP PLUGS DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
		●

MONTAGGIO TAPPI GOCCIOLATOIO SU 1 ANTA
DRIP PLUGS ASSEMBLING ON 1 WING



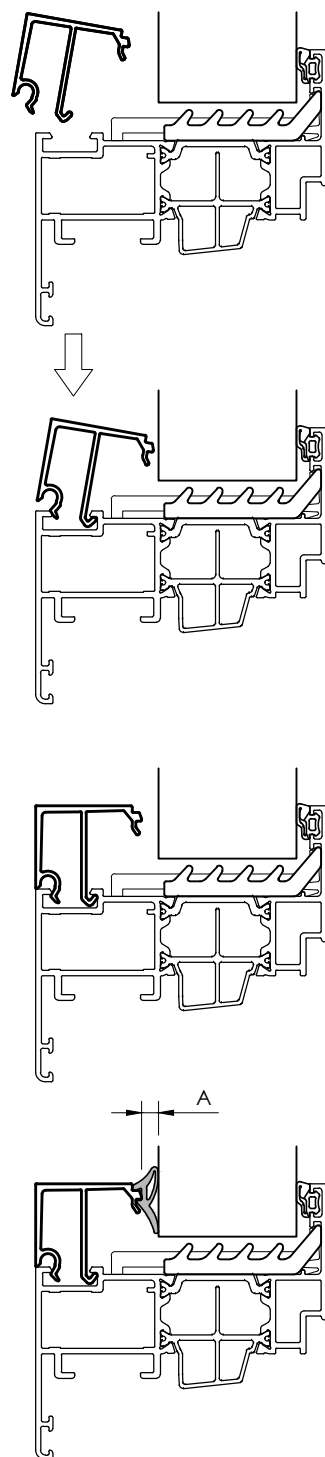
MONTAGGIO TAPPI GOCCIOLATOIO SU 2 ANTE
DRIP PLUGS ASSEMBLING ON 2 WINGS



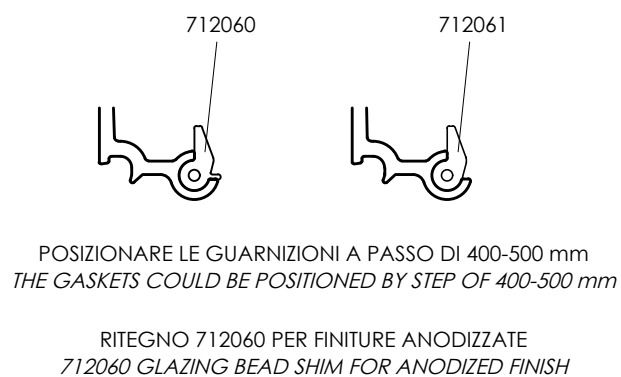
SCHEMA DI MONTAGGIO E SMONTAGGIO FERMAVETRI GLAZING BEAD ASSEMBLING AND REMOVING DIAGRAM

C67K	C77K	C77K-CS
●	●	●

SQUADRATI
SQUARED

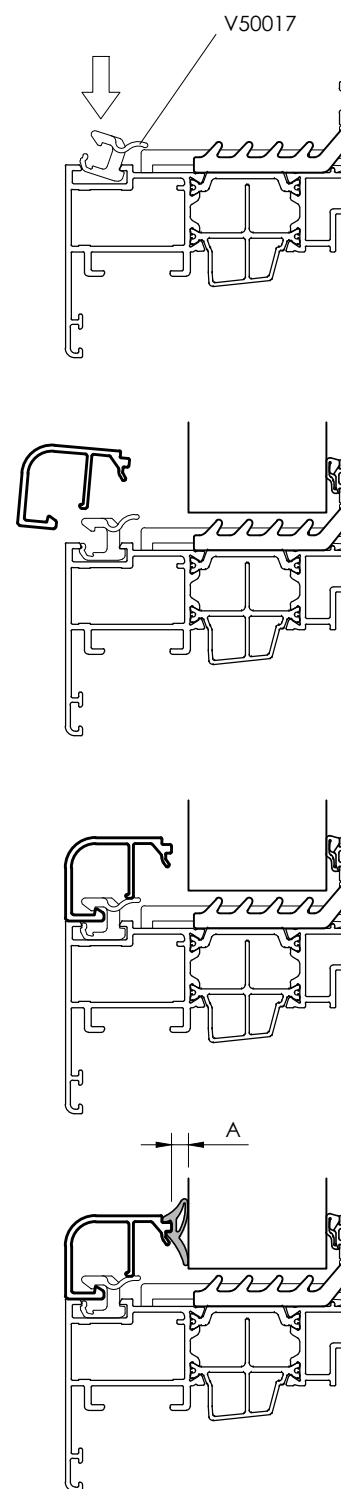


TUBOLARI
TUBULAR

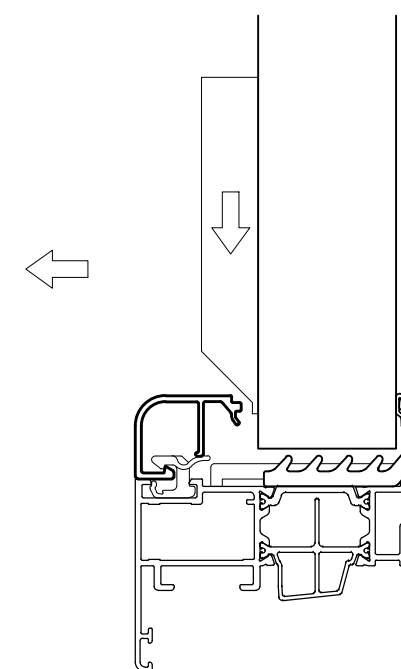


STONDATI
RADIAL

MONTARE N° 1 CLIPS ART. V50017 OGNI 250 mm
INSERT N° 1 CLIPS ART. V50017 BY STEP OF 250 mm



SMONTAGGIO
REMOVING

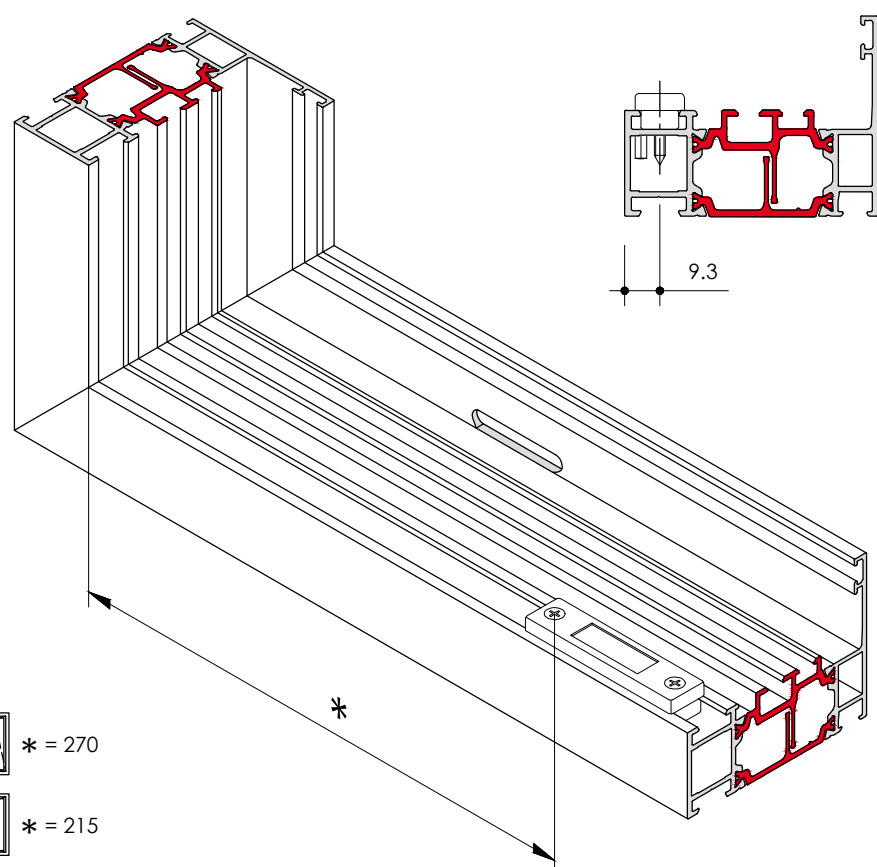
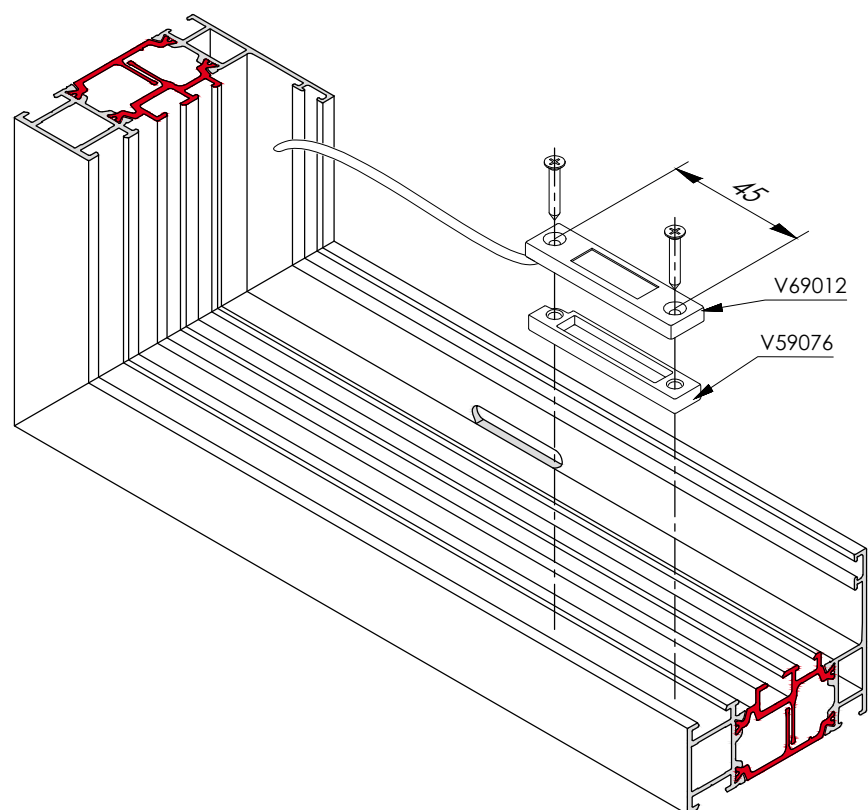


- Per consentire l'inserimento o la rimozione dei fermavetri a scatto, la misura "A" non deve scendere sotto i 4 mm.
- L'impiego di fermavetri con clips consente di scendere sotto tale valore, ma l'eventuale rimozione può risultare difficoltosa.
- To allow the insertion or removal of the snap-on glazing beads, the measurement "A" must not drop below 4 mm.
- The use of glazing beads with clips allows you to drop below this value, but any removal can be difficult.

SCHEMA DI MONTAGGIO SENSORE ALLARME ALARM SYSTEM DIAGRAM ASSEMBLING

C67K	C77K	C77K-CS
●	●	●

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



* = 270

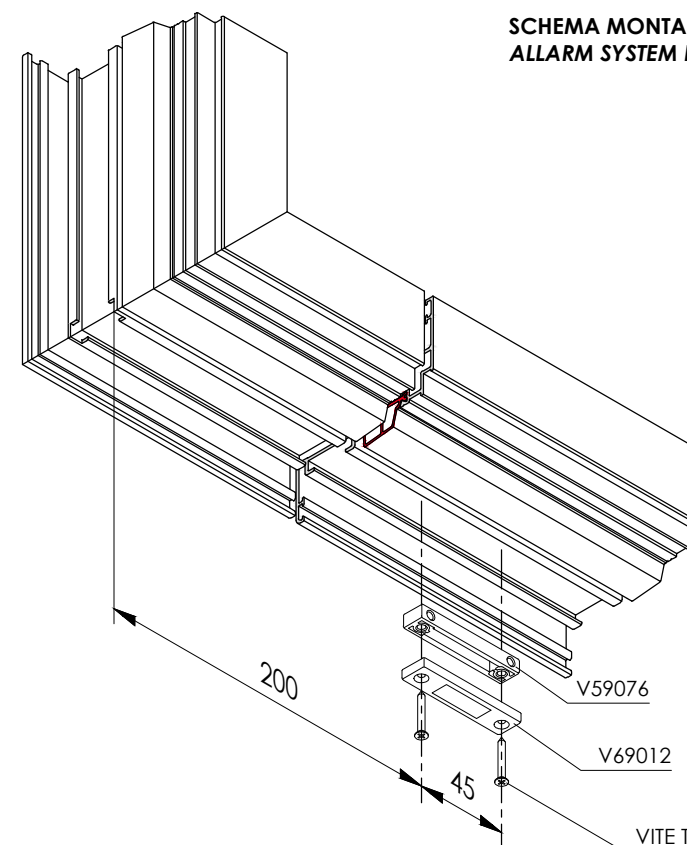


* = 215

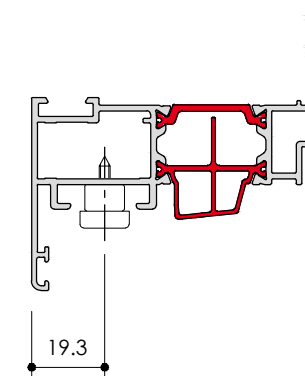
ALUK

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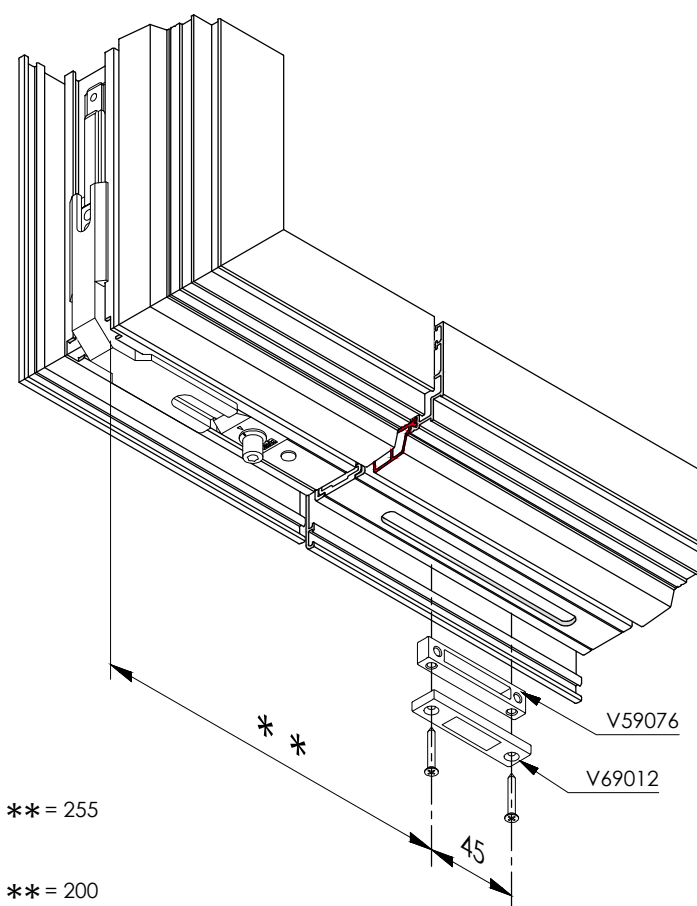
SCHEMA MONTAGGIO SENSORE ALLARME LATO BATTENTE
ALLARM SYSTEM DIAGRAM ASSEMBLING SASH SIDE



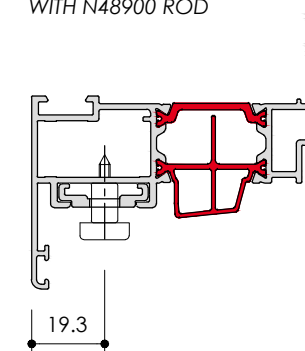
SENZA ASTA
WITHOUT ROD



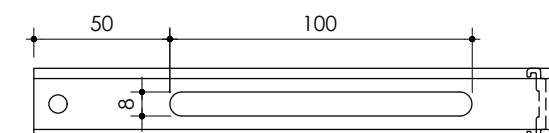
VITE TSP 2.9x22 UNI EN ISO 7050
2.9x22 COUNTERSUNK HEAD TAPPING
SCREW UNI EN ISO 7050



CON ASTA N48900
WITH N48900 ROD



LAVORAZIONE ASTA N48900
N48900 ROD MACHINING



** = 255

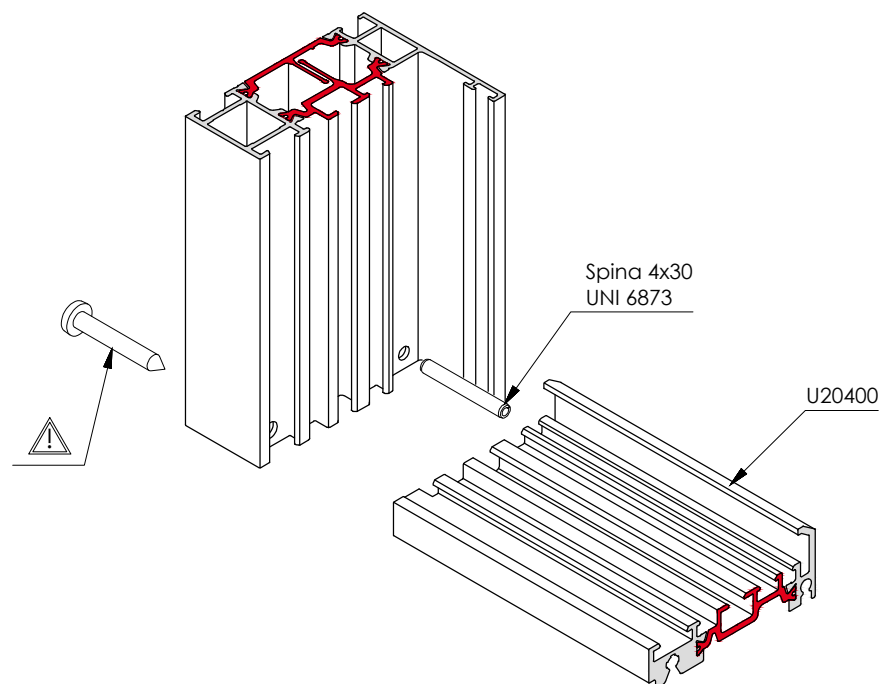


** = 200

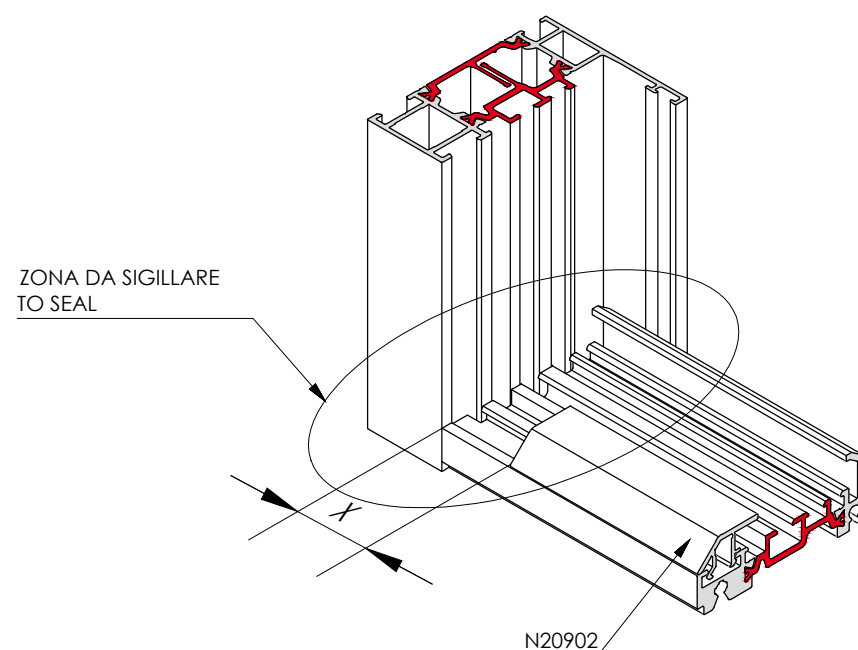
SCHEMA DI MONTAGGIO SOGLIA RIBASSATA
BALCONY DOOR ASSEMBLING DIAGRAM

C67K	C77K	C77K-CS
●	●	●

SCHEMA DI MONTAGGIO SOGLIA RIBASSATA
LOWERED THRESHOLD SECTION ASSEMBLING DIAGRAM



⚠	CERNIERA VISIBILE VISIBLE HINGE	620039	Vite 4.8 x 32 TC - UNI EN ISO 7049
	CERNIERA NASCOSTA HIDDEN HINGE	620034	Vite 4.8 x 13 TC - UNI EN ISO 7049

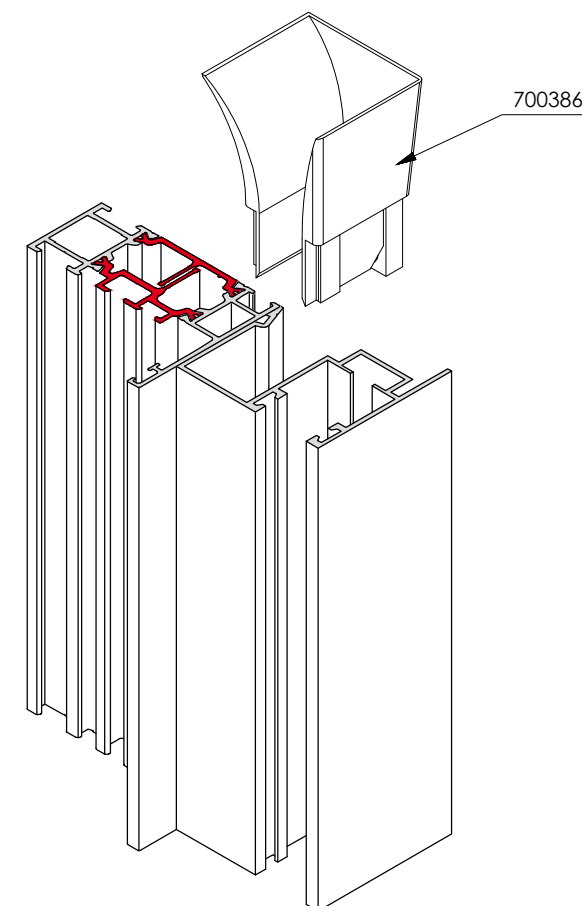


TAGLIO ART. N20902 N20902 CUT	
CERNIERA VISIBILE VISIBLE HINGE	X = 8 mm
CERNIERA NASCOSTA HIDDEN HINGE	X = 157 mm

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

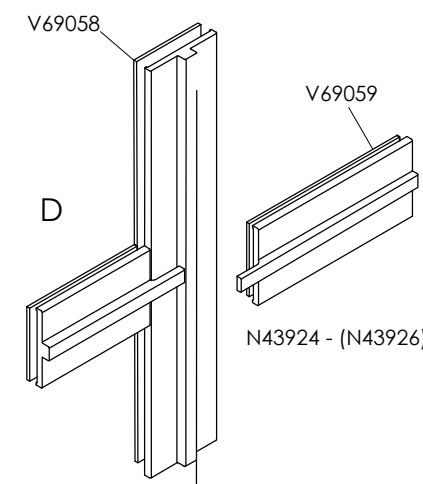
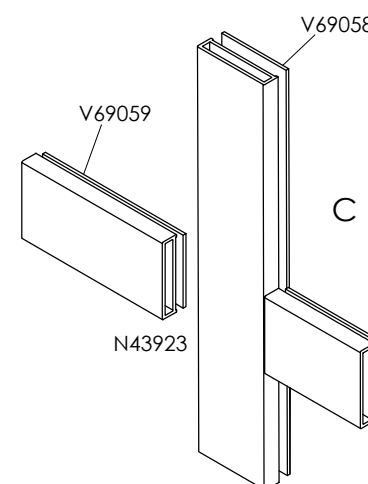
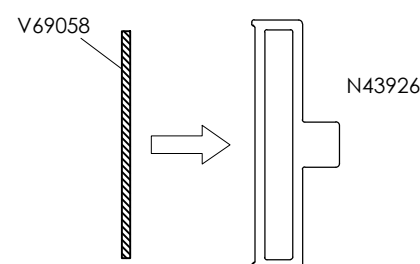
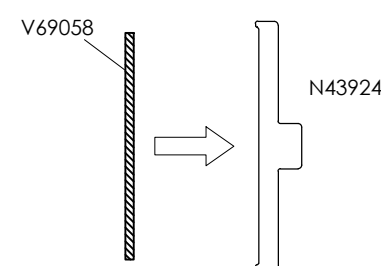
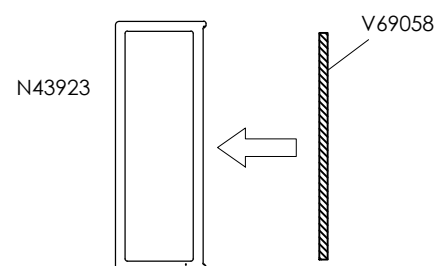
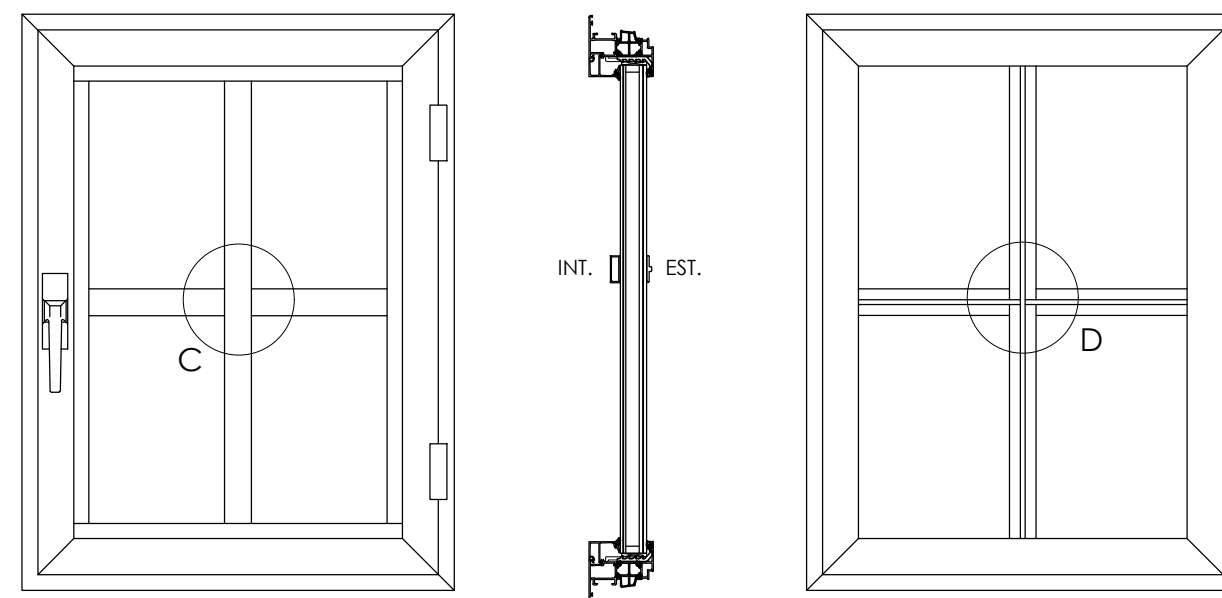
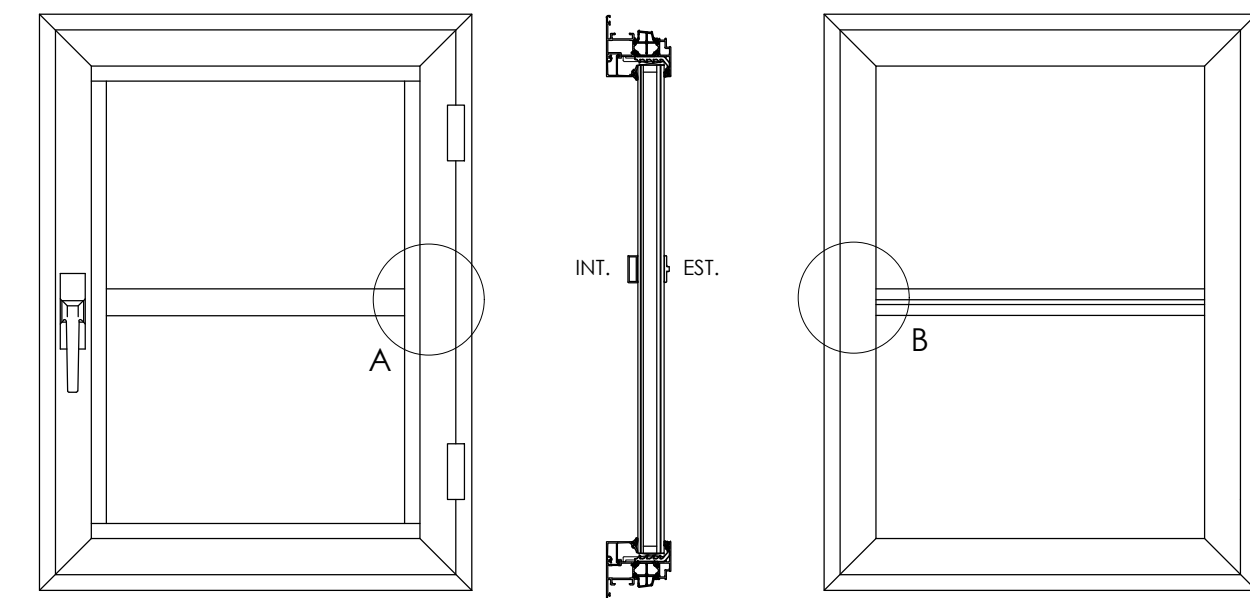
C67K	C77K	C77K-CS
●	●	

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

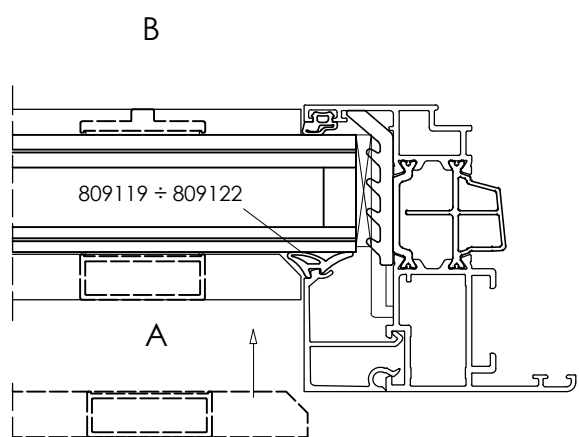
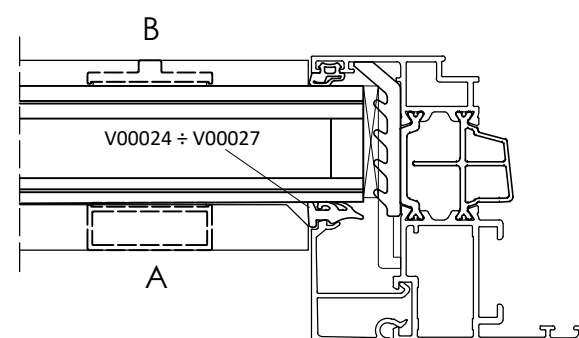
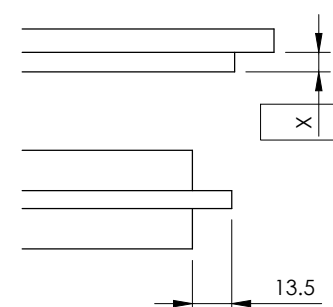


LAVORAZIONI E MONTAGGIO PROFILI "INGLESINA" MACHINING AND ASSEMBLY OF "INGLESINA" PROFILES

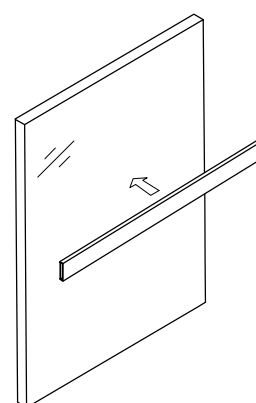
C67K	C77K	C77K-CS
●	●	



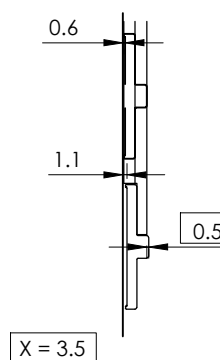
LAVORAZIONE N43924 MACHINING N43924



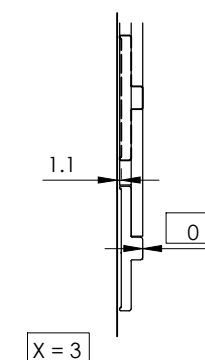
PROCEDURA DI INCOLLAGGIO INGLESINA "INGLESINA" BONDING PROCEDURE



- 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.



X = 3.5
NASTRI - TAPES:
- V69058 (SP 1,1 mm)
- V69059 (SP 0,6 mm)



X = 3
NASTRO - TAPE:
- V69058 (SP 1,1 mm)

AluK (IT)

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Verona - ITALY

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