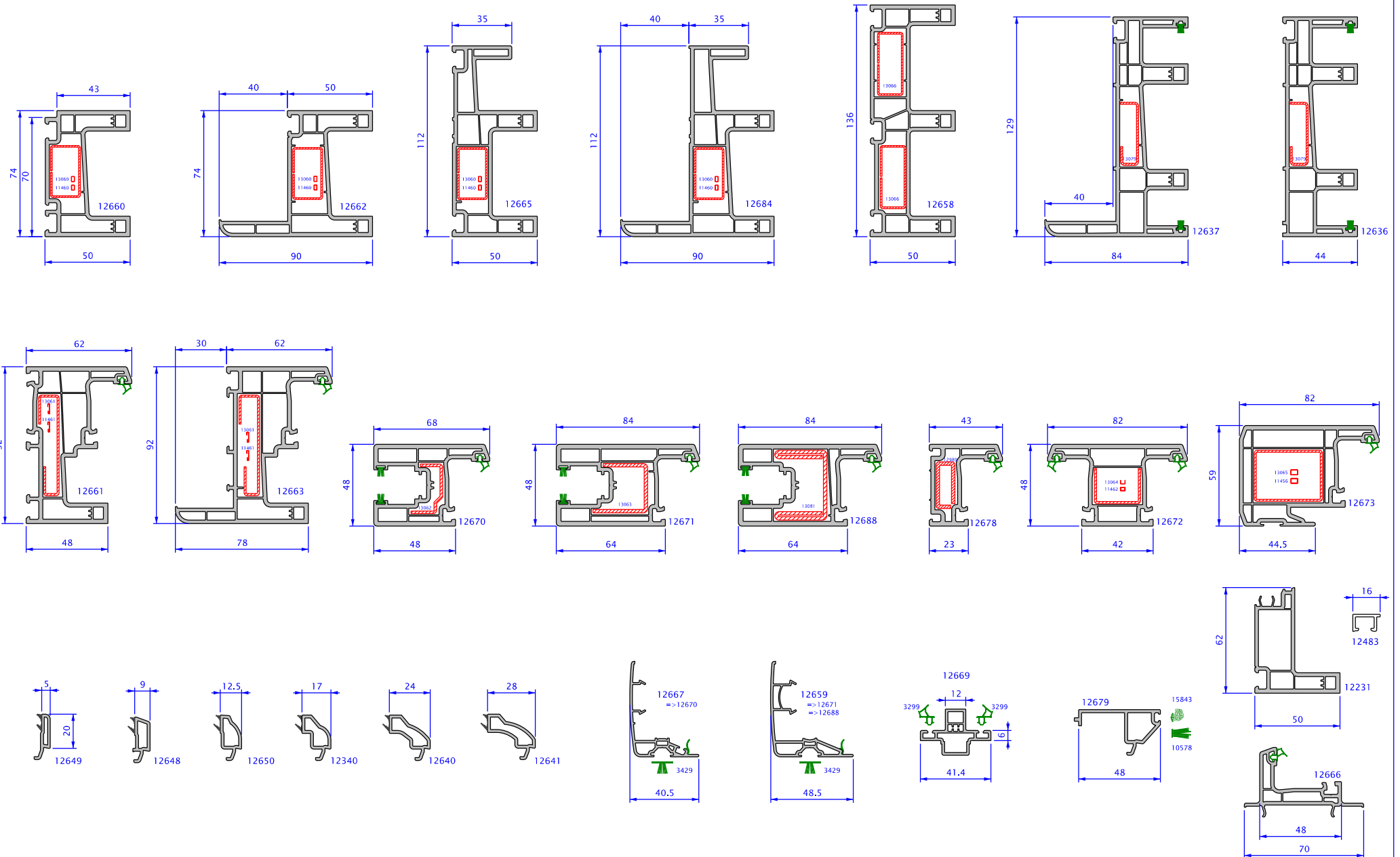


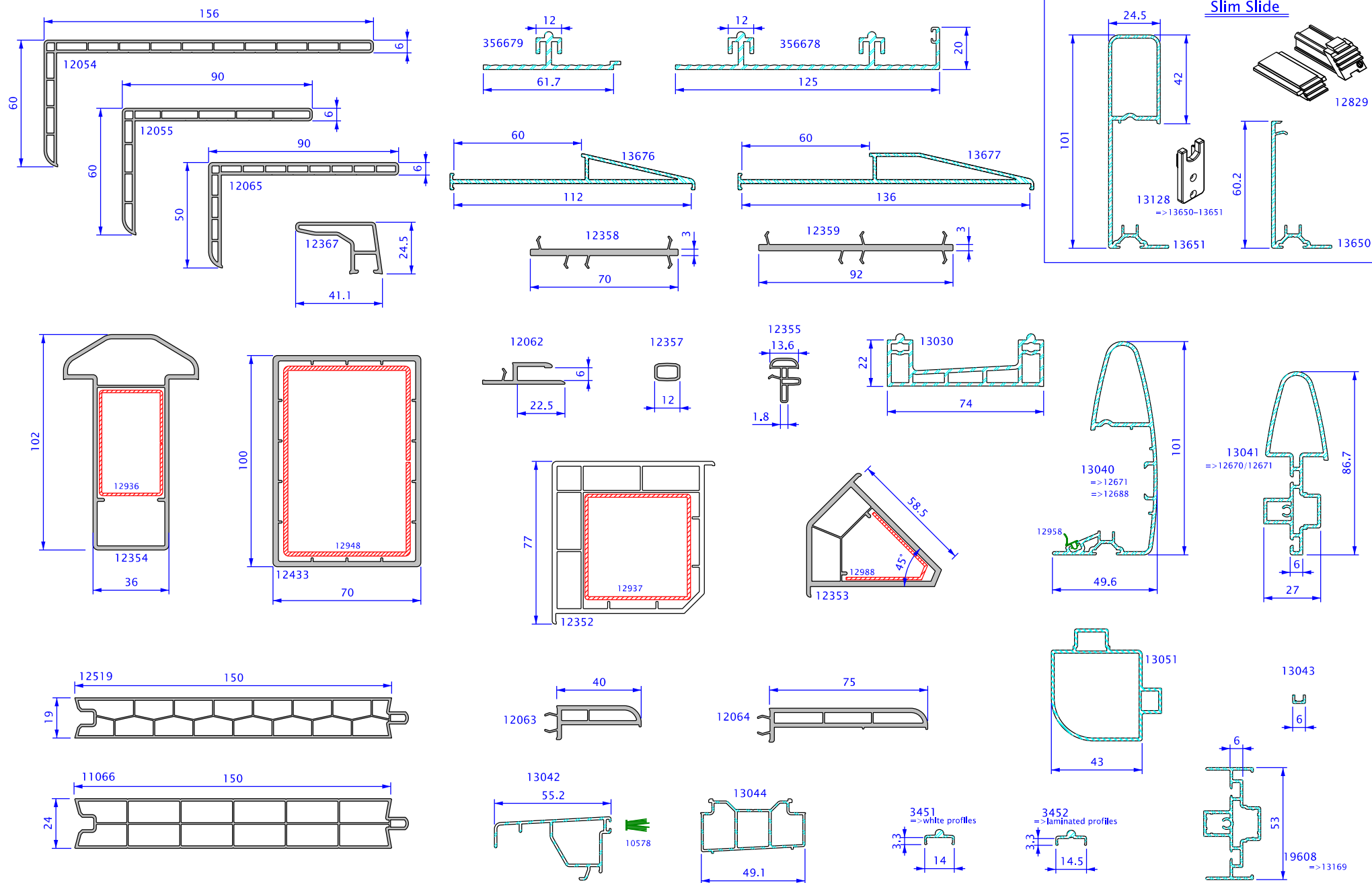
Fabrication Manual

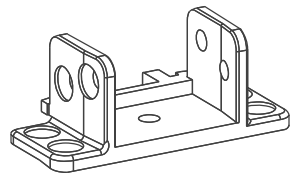


Building a sustainable home

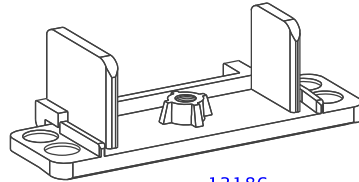
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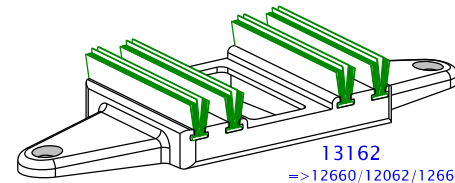




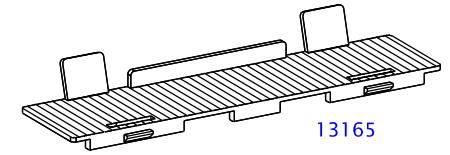
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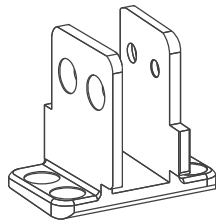
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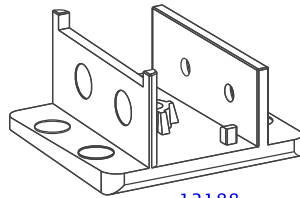
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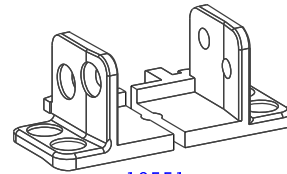
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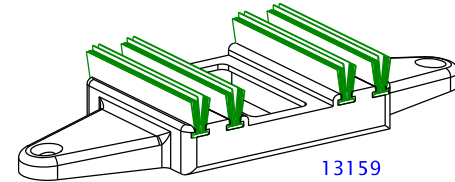
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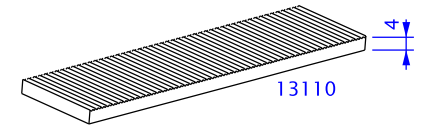
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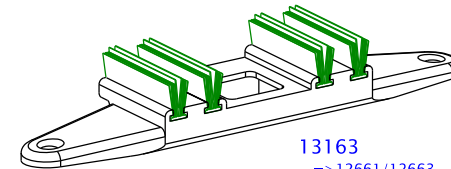
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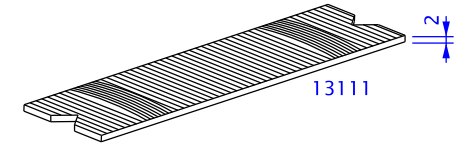
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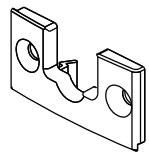


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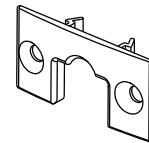
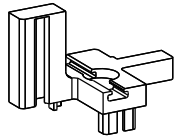


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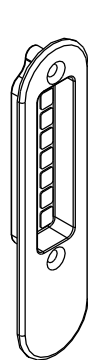
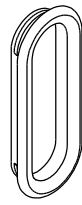
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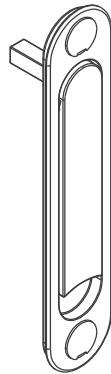
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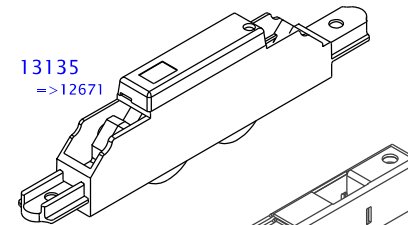
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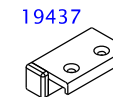
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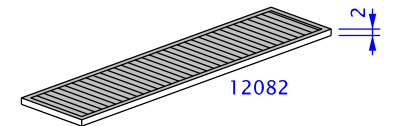
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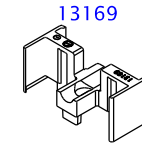
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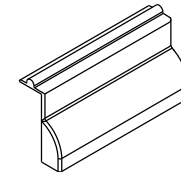
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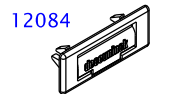
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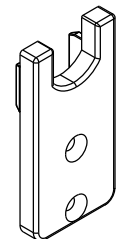
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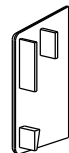
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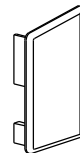
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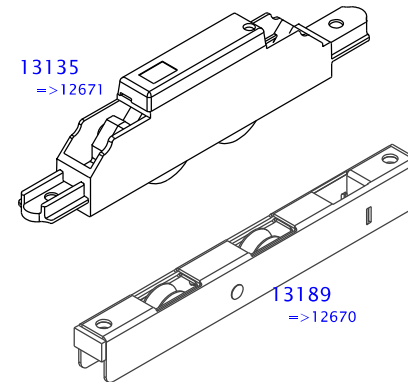
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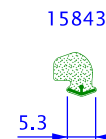
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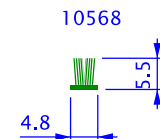
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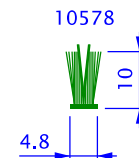
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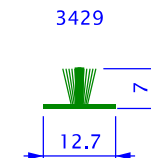
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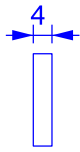
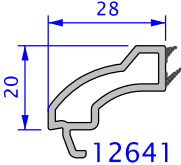
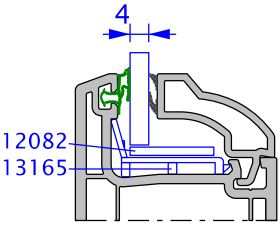
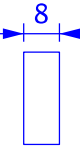
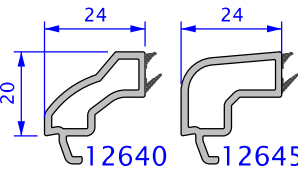
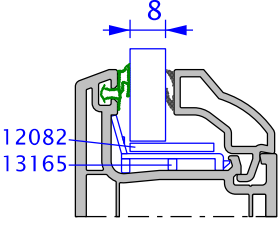
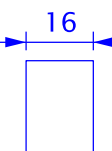
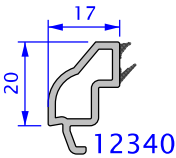
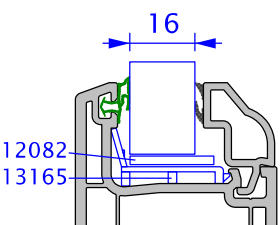
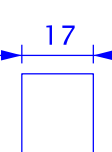
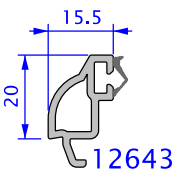
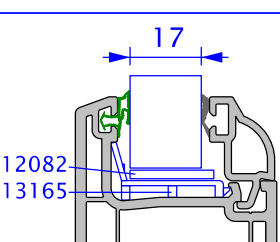
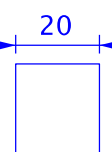
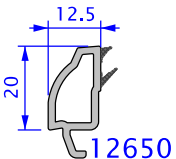
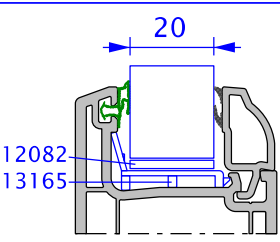
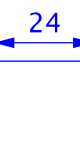
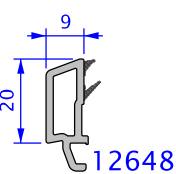
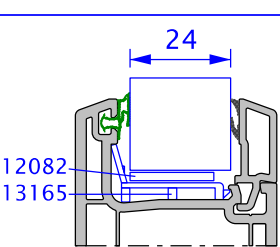
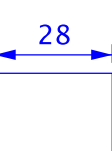
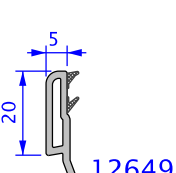
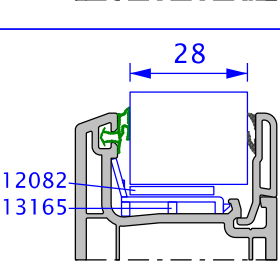
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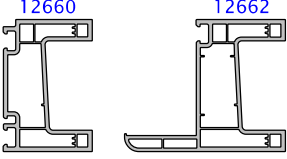
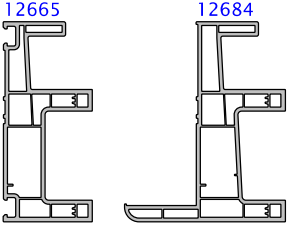


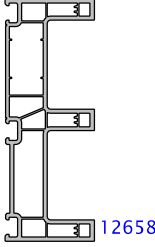

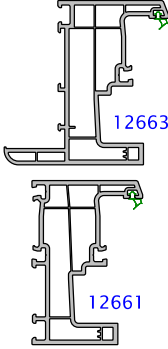


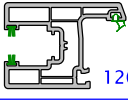

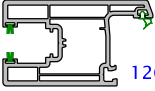

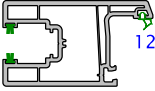

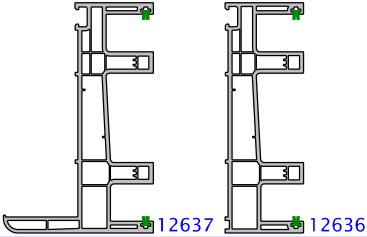





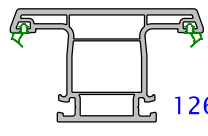


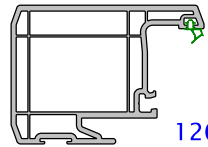


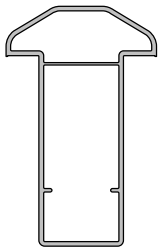

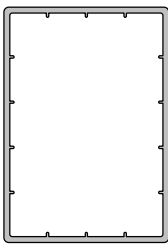
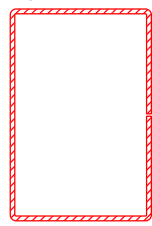
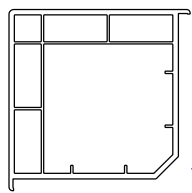
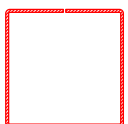
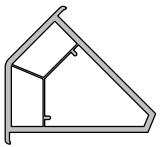
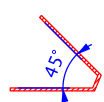
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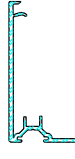
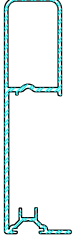
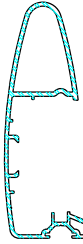
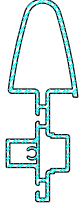
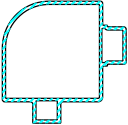
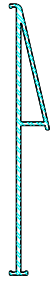




12958

GLAZING THICKNESS (mm)		GLAZING BEADS	DETAILS
4 mm			
8 mm			
16 mm			
17 mm			
20 mm			
24 mm			
28 mm			

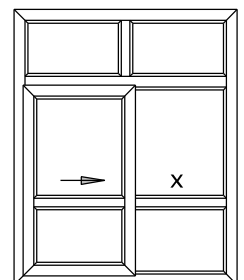
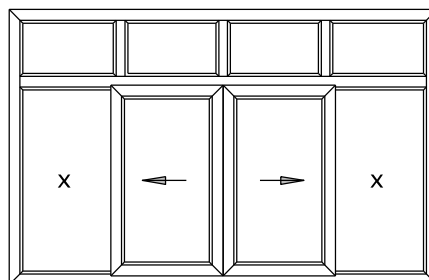
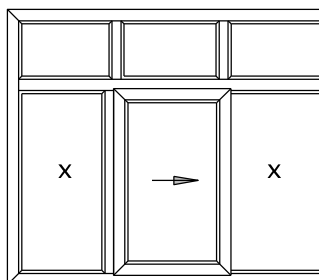
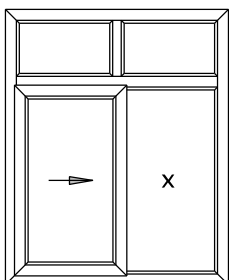
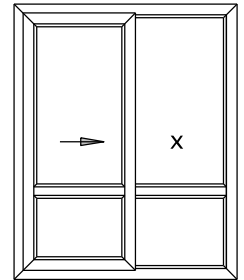
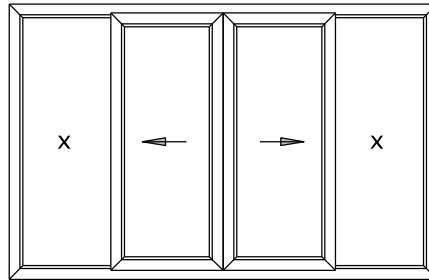
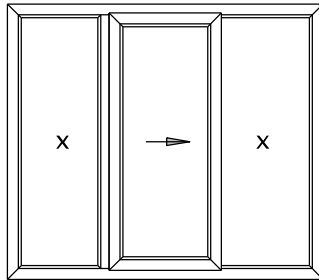
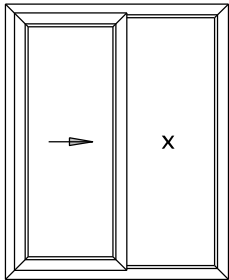
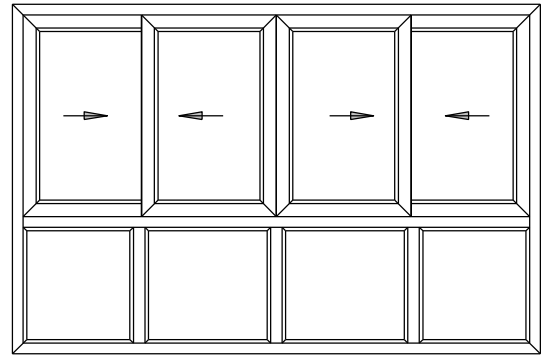
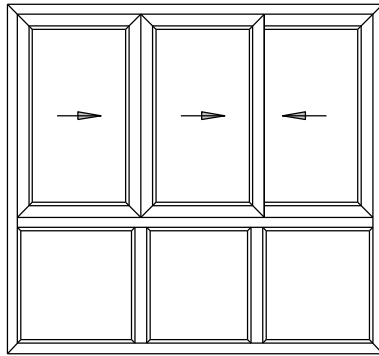
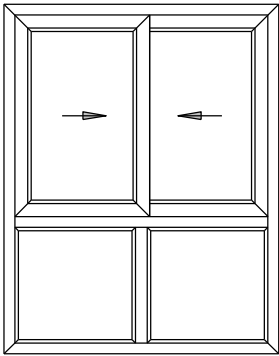
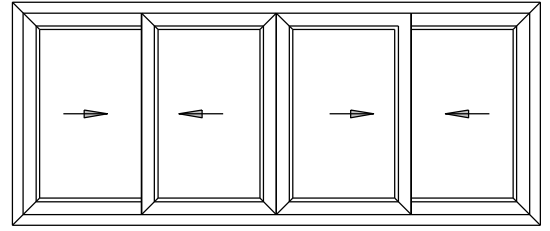
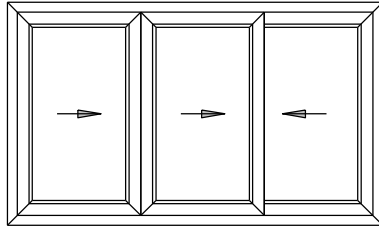
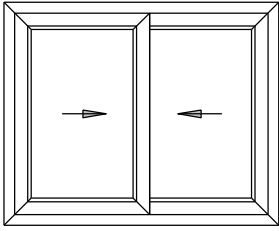
PVC	Reinforcement	Dimension	Ix (cm ⁴)	Iy (cm ⁴)
 	13060  11460 	17.5x30.5x1 89.28 (mm ³) 17.5x30.5x1.5 130.28 (mm ³)	1.11 1.55	0.47 0.64
	13066 	15x37x1 97.28 (mm ³)	1.63	0.40
	13061  11461 	17x12x59x9x17x1.2 128.77 (mm ³) 17x12x59x9x17x1.5 158.78 (mm ³)	5.37 6.52	0.24 0.28
	13062 	13x29x18.5x1.5 81.56 (mm ³)	0.99	0.21
	13063 	26x29x32x2 163.42 (mm ³)	2.31	1.49
	13081 	30.5x41x30.5x5 303.47 (mm ³)	8.38	2.84
	13079 	10.5x37x10.5x11x1.2 76.00 (mm ³)	1.31	0.11
	12989 	11x27.4x2 129.10 (mm ³)	0.99	0.22

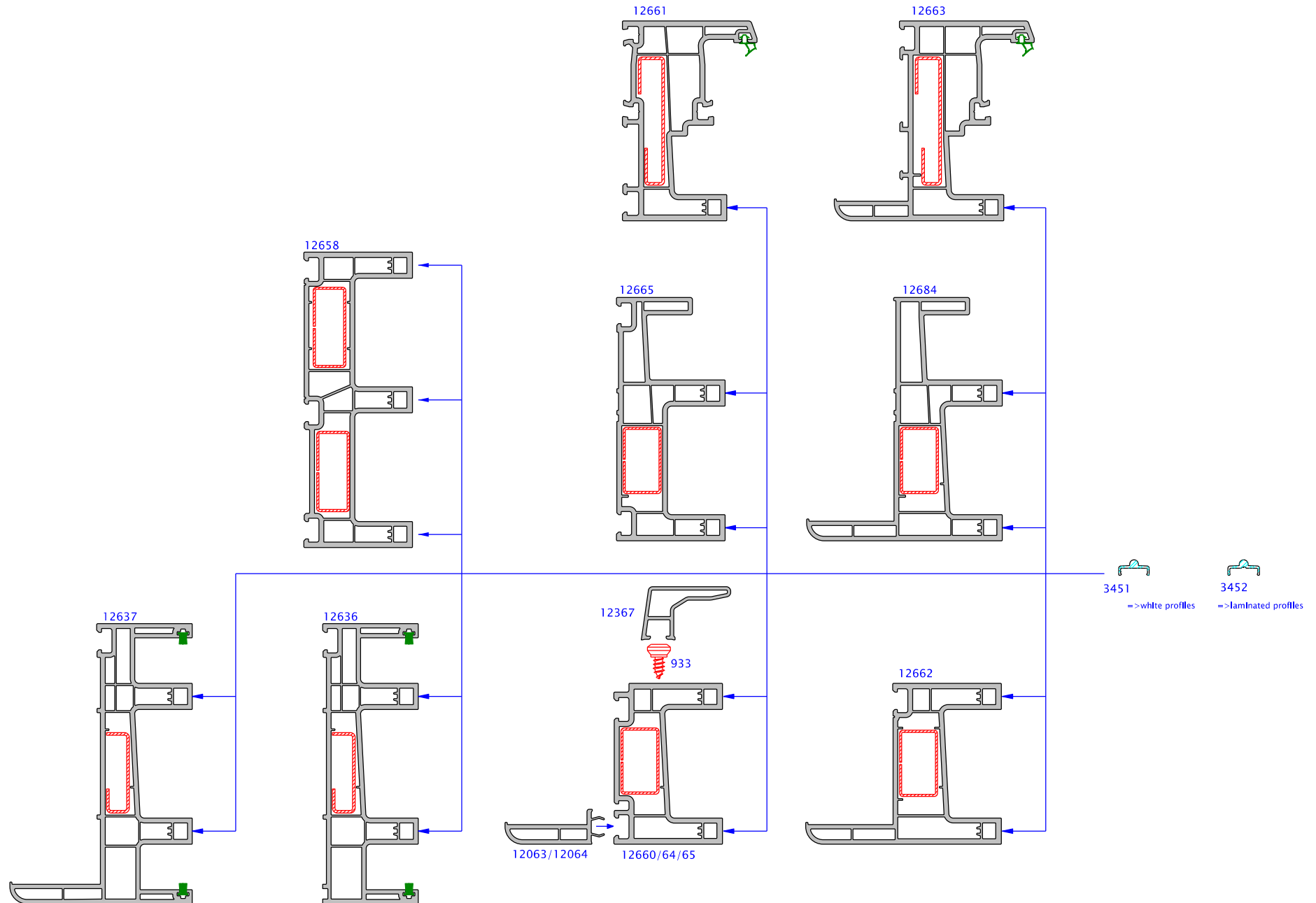
PVC	Reinforcement	Dimension	I _x (cm ⁴)	I _y (cm ⁴)
 12672	13064 	20.5x27x20.5x1.2 77.58 (mm ³)	0.34	0.95
	11462 	20.5x27x1.5 128.78 (mm ³)	0.83	1.29
 12673	13065 	30x40x1.2 159.37 (mm ³)	2.35	3.68
	11456 	30x40x2 256.85 (mm ³)	3.62	5.62
 12354	12936 	50x30x50x14x14x1.2 183.37 (mm ³)	6.31	2.85
 12433	12948 	60x90x60x44x44x2 576.84 (mm ³)	35.69	66.26
 12352	12937 	50x50x50x24.5x24.5x1.2 230.77 (mm ³)	9.09	9.16
 12353	12988 	32x7.2x38.6x1.2 92.70 (mm ³)	0.97	0.95

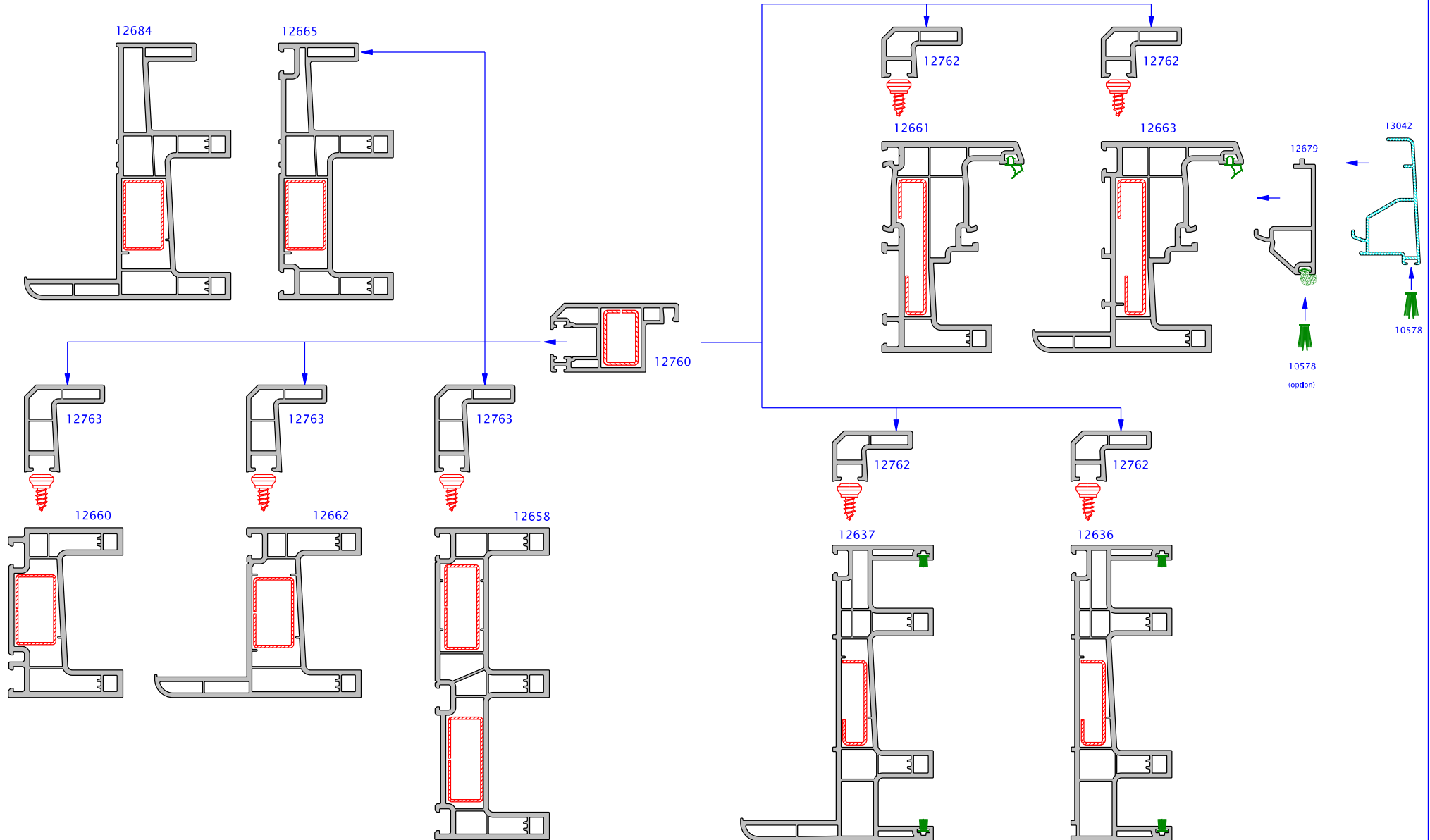
PVC	Dimension	Ix (cm ⁴)	Iy (cm ⁴)
 13650	28.5x60.2x1.8 178.93 (mm ³)	7.09	0.94
 13651	28.5x101x1.8 363.85 (mm ³)	41.48	3.21
 13040	49.6x101x1.5 432.20 (mm ³)	49.84	7.14
 13041	30.53x86.7x1.5 430.83 (mm ³)	25.09	3.03
 13051	53x52.2x1.4 296.97 (mm ³)	8.58	9.00
 13676	17.8x116x1.8 313.85 (mm ³)	34.40	0.40
 13677	17.3x140x1.8 394.19 (mm ³)	60.01	0.82
 19608	27x53x1.2 243.91 (mm ³)	6.17	1.19

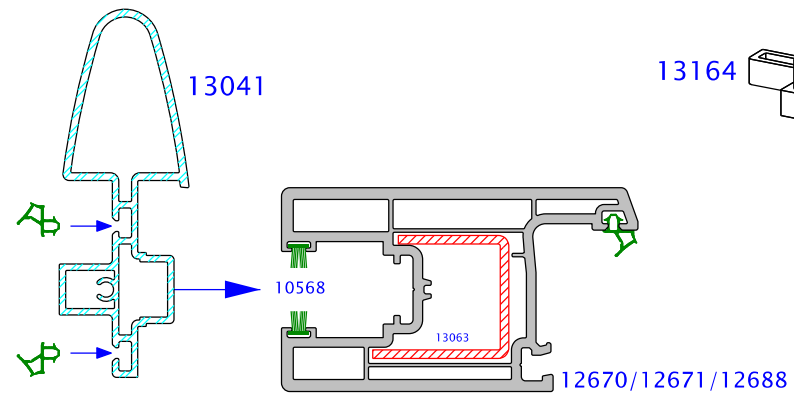
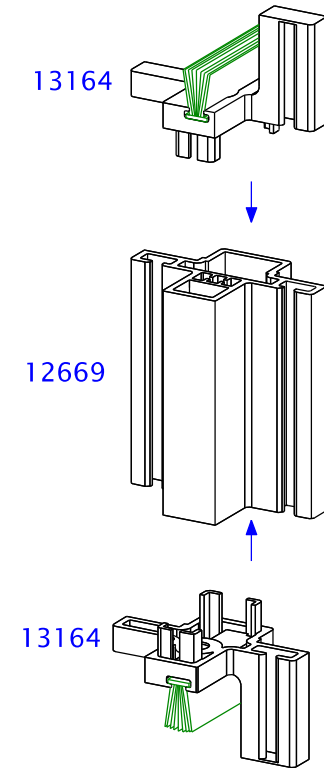
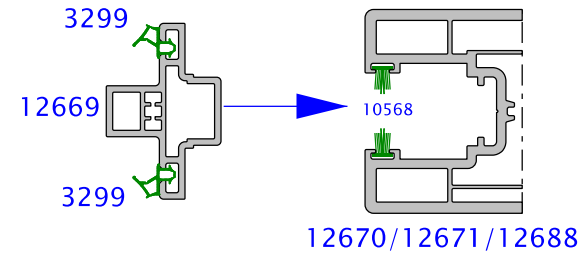
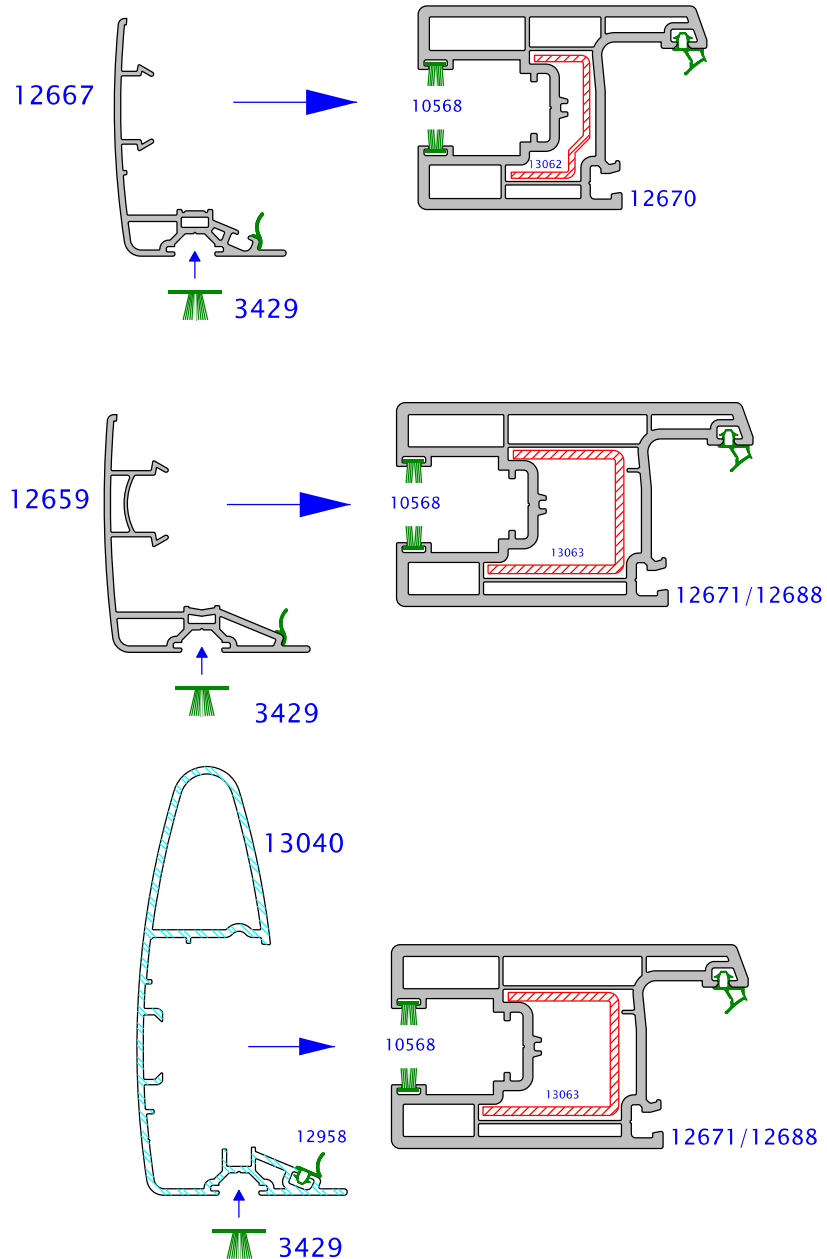
* Sliding door cannot be made with 12670 Sliding Window Sash.

* The frame height of the window made with 12670 Sliding Window Sash is maximum 1500 mm.

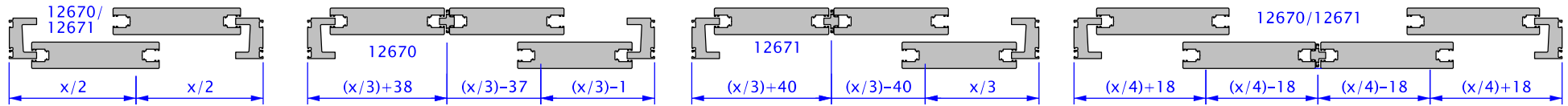








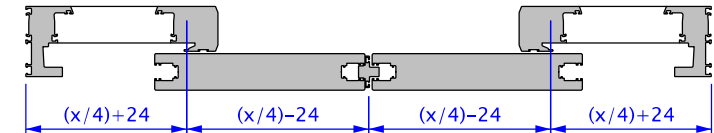
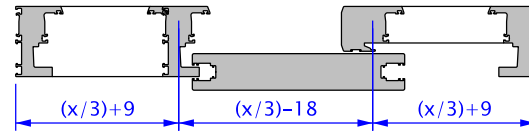
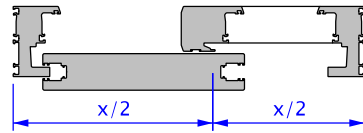
Axe Calculation : In the application of 12660,vertical axes should be determined as shown below.



The sash overlap is 9 mm.

Welding thickness is included	Dimension											
Cutting Sliding Frame	12660	$x+6$	$x+6$	$x+6$	-	-	-	-	-	-	-	-
Cutting Sliding Window Sash	12670	$\frac{x-2}{2}$	$\frac{x-6}{3}$	$\frac{x+68}{4}$	$x-76$	$x-51$	$x-26$	-	-	-	-	-
Glass Sliding Window Sash	12670	$\frac{x-226}{2}$	$\frac{x-342}{3}$	$\frac{x-380}{4}$	$x-188$	$x-163$	$x-138$	-	-	-	-	-
Cutting Sliding Sash	12671	$\frac{x+14}{2}$	$\frac{x+10}{3}$	$\frac{x+100}{4}$	$x-76$	$x-51$	$x-26$	-	-	-	-	-
Glass Sliding Sash	12671	$\frac{x-274}{2}$	$\frac{x-422}{3}$	$\frac{x-476}{4}$	$x-220$	$x-195$	$x-170$	-	-	-	-	-
Cutting Sliding Transom	12672	$\frac{x-206}{2}$	$\frac{x-312}{3}$	$\frac{x-340}{4}$	-	-	-	$x-110$	$x-85$	$x-105$	-	-
Glass Sliding Transom	12672	$\frac{x-226}{2}$	$\frac{x-342}{3}$	$\frac{x-380}{4}$	-	-	-	$x-120$	$x-95$	$x-115$	$x-96$	$x-52$
Cutting Sliding Transom	12672	$\frac{x-254}{2}$	$\frac{x-392}{3}$	$\frac{x-436}{4}$	-	-	-	$x-126$	$x-101$	-	-	-
Glass Sliding Transom	12672	$\frac{x-274}{2}$	$\frac{x-422}{3}$	$\frac{x-476}{4}$	-	-	-	$x-136$	$x-111$	-	-	-
Cutting Sliding Frame(Transom)	12660	-	-	-	$x-60$	-	-	-	-	-	-	-
Glass Sliding Frame(Transom)	12660	-	-	-	$x-140$	-	-	-	-	-	-	-
Cutting Sliding Frame fix Adp.	12666	-	-	-	$x-100$	-	-	-	-	$x-75$	-	-

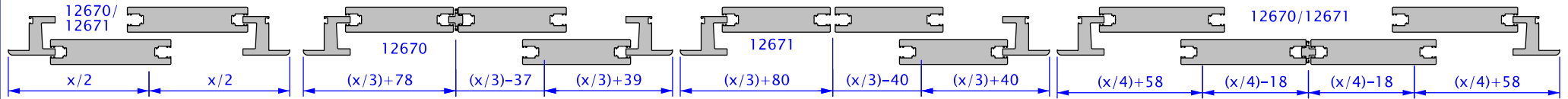
Axe Calculation : In the application of three and four sashes with 12661, vertical axes should be determined as shown below. Then, cutting and glass dimensions are calculated as shown in the table



Note: 12670 Sliding window sash is not used in these applications (12661). The sash overlap is 9 mm.

<div>Welding thickness is included</div> <div>Dimension</div>											
Cutting Fixed Sliding Frame 12661	x_1+6	x_1+6	x_1+6	-	-	-	-	-	-	-	-
Cutting Sliding Sash 12671	$x+9$	$x+30$	$x+43$	$x-72$	$x-51$	-	-	-	-	-	-
Glass Sliding Sash 12671	$x-135$	$x-114$	$x-101$	$x-216$	$x-195$	-	-	-	-	-	-
Cutting Sliding Transom 12672	$x-125$	$x-104$	$x-91$	$x-84$	$x-63$	$x-63$	$x-63$	$x-63$	$x-42$	$x-124$	$x-103$
Glass Sliding Transom 12672	$x-135$	$x-114$	$x-101$	$x-94$	$x-73$	$x-73$	$x-73$	$x-73$	$x-52$	$x-134$	$x-113$
Cutting Sliding Vertical Transom 12673	-	-	-	$x-84$	$x-63$	-	-	-	-	-	-
Glass Sliding Vertical Transom 12673	-	-	-	$x-94$	$x-73$	-	-	-	-	-	-
Cutting Fixed Sli.Frame(Transom) 12661	-	-	-	$x-84$	$x-63$	-	-	-	-	-	-
Glass Fixed Sli.Frame(Transom) 12661	-	-	-	$x-94$	$x-73$	-	-	-	-	-	-
Cutting Glazing Bead 10mm 12648	-	-	-	$x-124$	$x-103$	-	-	-	-	-	-

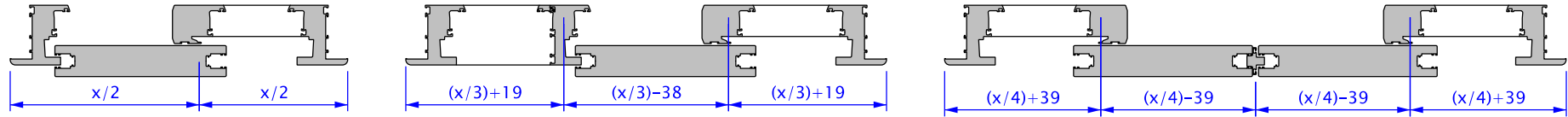
Axe Calculation : Use axe dimensions below to define the axes of vertical mullions if there is any fixed part on the top.



The sash overlap is 9 mm.

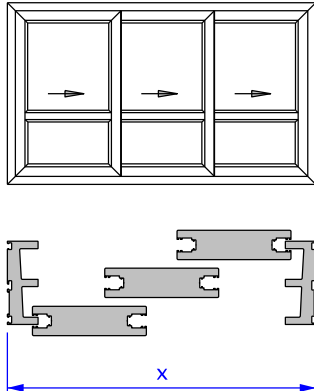
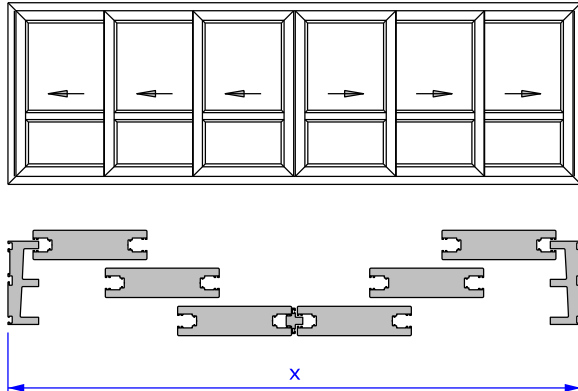
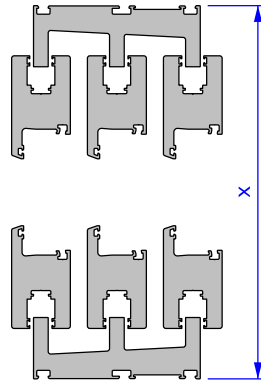
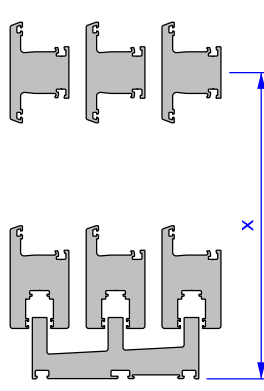
Welding thickness is included	Dimension	Diagram 1	Diagram 2	Diagram 3	Diagram 4	Diagram 5	Diagram 6	Diagram 7	Diagram 8	Diagram 9	Diagram 10	Diagram 11
Cutting Sliding Frame	12660	x+6	x+6	x+6	-	-	-	-	-	-	-	-
Cutting Sliding Window Sash	12670	$\frac{x-82}{2}$	$\frac{x-86}{3}$	$\frac{x-12}{4}$	x-156	x-91	x-26	-	-	-	-	-
Glass Sliding Window Sash	12670	$\frac{x-306}{2}$	$\frac{x-422}{3}$	$\frac{x-460}{4}$	x-268	x-203	x-138	-	-	-	-	-
Cutting Sliding Sash	12671	$\frac{x-66}{2}$	$\frac{x-70}{3}$	$\frac{x+20}{4}$	x-156	x-91	x-26	-	-	-	-	-
Glass Sliding Sash	12671	$\frac{x-354}{2}$	$\frac{x-502}{3}$	$\frac{x-556}{4}$	x-300	x-235	x-170	-	-	-	-	-
Cutting Sliding Transom	12672	$\frac{x-286}{2}$	$\frac{x-392}{3}$	$\frac{x-420}{4}$	-	-	-	x-150	x-85	x-145	-	-
Glass Sliding Transom	12672	$\frac{x-306}{2}$	$\frac{x-422}{3}$	$\frac{x-460}{4}$	-	-	-	x-160	x-95	x-155	x-136	x-52
Cutting Sliding Transom	12672	$\frac{x-334}{2}$	$\frac{x-472}{3}$	$\frac{x-516}{4}$	-	-	-	x-166	x-101	-	-	-
Glass Sliding Transom	12672	$\frac{x-354}{2}$	$\frac{x-502}{3}$	$\frac{x-556}{4}$	-	-	-	x-176	x-111	-	-	-
Cutting Sliding Frame(Transom)	12660	-	-	-	x-140	-	-	-	-	-	-	-
Glass Sliding Frame(Transom)	12660	-	-	-	x-220	-	-	-	-	-	-	-
Cutting Sliding Frame fix Adp.	12666	-	-	-	x-180	-	-	-	-	x-115	-	-

Axe Calculation : In the application of three and four sashes of 12663(Arch.frame),vertical axes should be determined as shown below. Cutting and glass dimensions are calculated as shown in the table

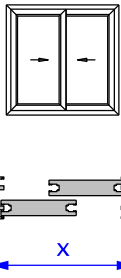
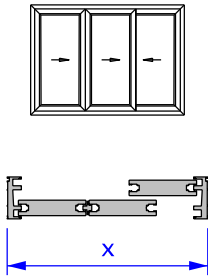
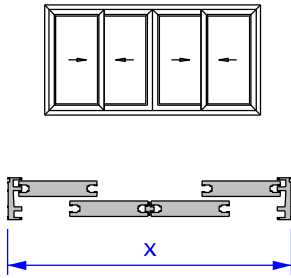
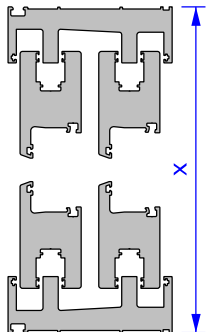
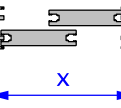
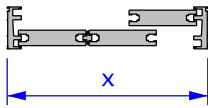
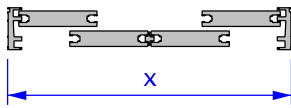
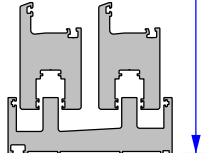


Note : Sliding window sash (12670) is not used in these applications (12663) The sash overlap is 9 mm.

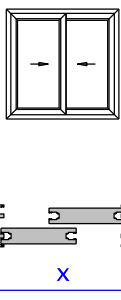
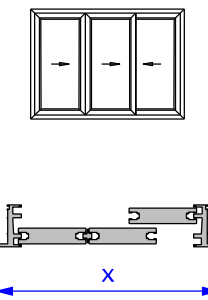
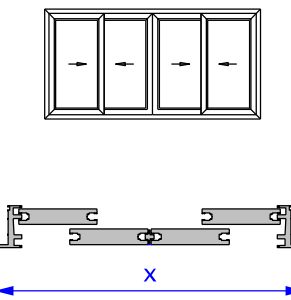
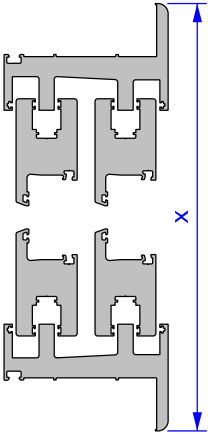
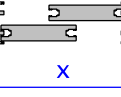
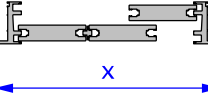
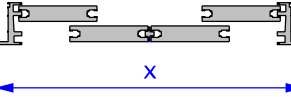
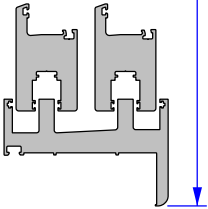
Welding thickness is included	Diagram 1	Diagram 2	Diagram 3	Diagram 4	Diagram 5	Diagram 6	Diagram 7	Diagram 8	Diagram 9	Diagram 10	Diagram 11
Dimension											
Cutting Fixed Sliding Arch. Frame 12663	x_1+6	x_1+6	x_1+6	-	-	-	-	-	-	-	-
Cutting Sliding Sash 12671	$x-21$	$x+30$	$x+43$	$x-132$	$x-81$	-	-	-	-	-	-
Glass Sliding Sash 12671	$x-165$	$x-114$	$x-101$	$x-276$	$x-225$	$x-93$	$x-93$	$x-93$	$x-42$	$x-154$	$x-103$
Cutting Sliding Transom 12672	$x-155$	$x-104$	$x-91$	$x-144$	$x-93$	$x-103$	$x-103$	$x-103$	$x-52$	$x-164$	$x-113$
Glass Sliding Transom 12672	$x-165$	$x-114$	$x-101$	$x-154$	$x-103$	-	-	-	-	-	-
Cutting Sliding Vertical Transom 12673	-	-	-	$x-144$	$x-93$	-	-	-	-	-	-
Glass Sliding Vertical Transom 12673	-	-	-	$x-154$	$x-103$	-	-	-	-	-	-
Cutting Fixed Sliding Frame(Transom) 12661	-	-	-	$x-144$	$x-93$	-	-	-	-	-	-
Glass Fixed Sliding Frame(Transom) 12661	-	-	-	$x-154$	$x-103$	-	-	-	-	-	-
Cutting Glazing Bead 10mm 12648	-	-	-	$x-184$	$x-133$	-	-	-	-	-	-

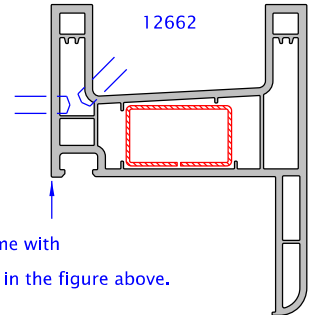
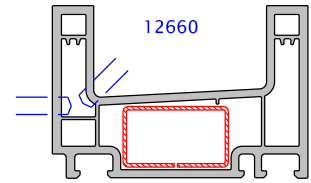
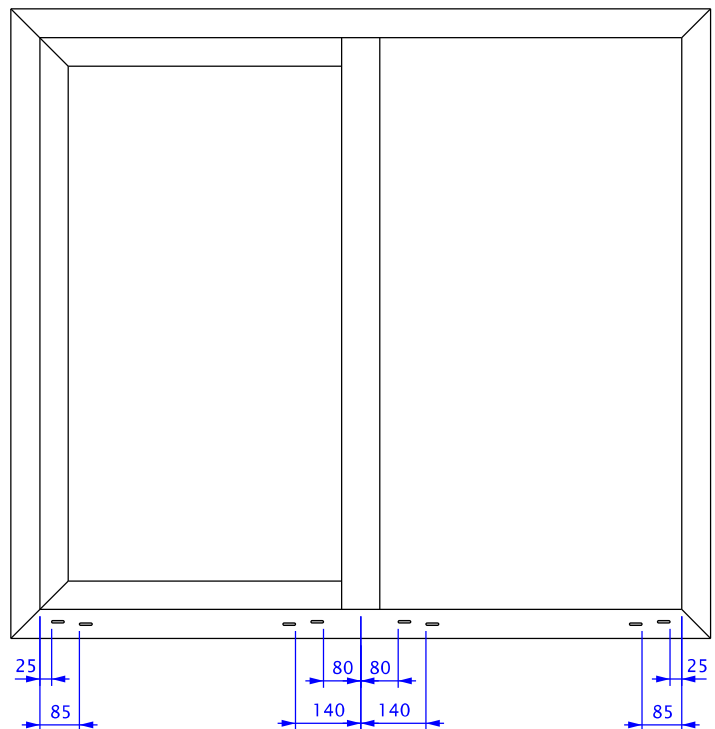
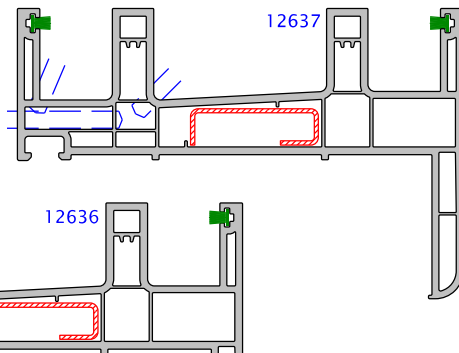
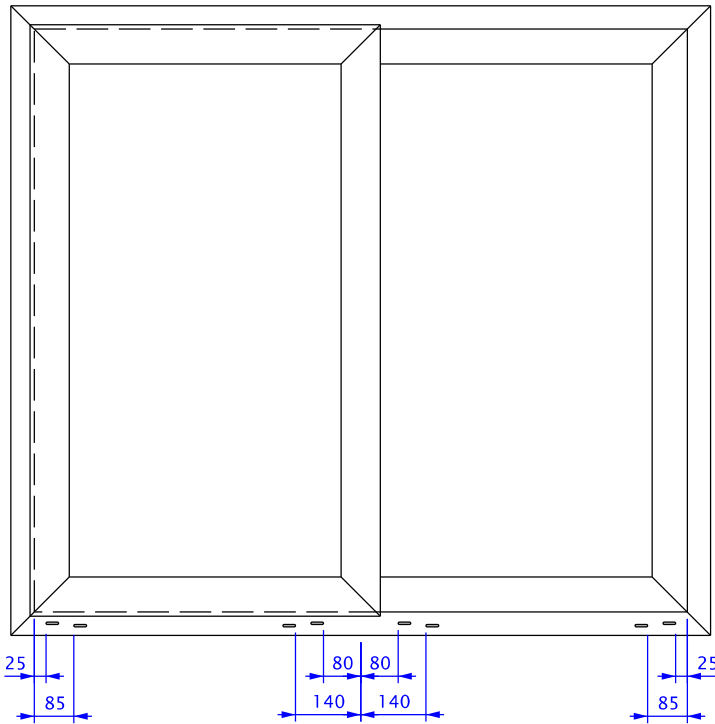
Welding thickness is included								
	Dimension							
Cutting Sliding Frame 12660	x+6		x+6		-		-	
Cutting Sliding Window Sash 12670	$\frac{x+72}{3}$		$\frac{x+216}{6}$		x-76		-	
Glass Sliding Window Sash 12670	$\frac{x-264}{3}$		$\frac{x-456}{6}$		x-188		-	
Cutting Sliding Sash 12671	$\frac{x+104}{3}$		$\frac{x+280}{6}$		x-76		-	
Glass Sliding Sash 12671	$\frac{x-328}{3}$		$\frac{x-584}{6}$		x-220		-	
Cutting Sliding Transom 12672	$\frac{x-234}{3}$		$\frac{x-396}{6}$		-		-	
Glass Sliding Transom 12672	$\frac{x-264}{3}$		$\frac{x-456}{6}$		-		x-120	
Cutting Sliding Transom 12672	$\frac{x-298}{3}$		$\frac{x-524}{6}$		-		-	
Glass Sliding Transom 12672	$\frac{x-328}{3}$		$\frac{x-584}{6}$		-		x-136	

The sash overlap is 9 mm.

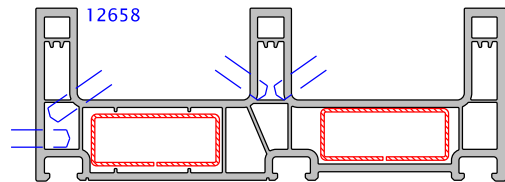
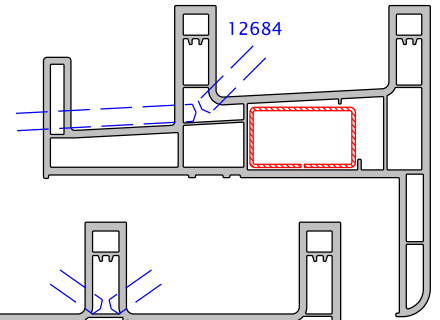
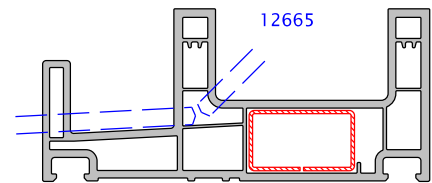
<div>Welding thickness is included</div> <div>Dimension</div>				
				
Cutting Sliding Frame 12636	$x+6$	$x+6$	$x+6$	$x+6$
Cutting Sliding Sash 12671–12688	$\frac{x+26}{2}$	$\frac{x+22}{3}$	$\frac{x+112}{4}$	$x-64$
Glass Sliding Sash 12671–12688	$\frac{x-262}{2}$	$\frac{x-410}{3}$	$\frac{x-464}{4}$	$x-208$

The sash overlap is 9 mm.

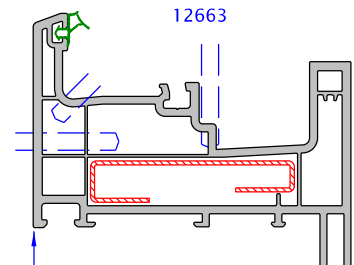
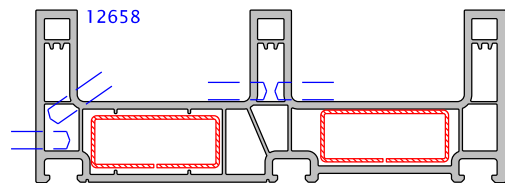
<div>Welding thickness is included</div> <div>Dimension</div>				
				
Cutting Sliding Frame 12637	$x+6$	$x+6$	$x+6$	$x+6$
Cutting Sliding Sash 12671–12688	$\frac{x-54}{2}$	$\frac{x-58}{3}$	$\frac{x+32}{4}$	$x-144$
Glass Sliding Sash 12671–12688	$\frac{x-342}{2}$	$\frac{x-490}{3}$	$\frac{x-544}{4}$	$x-288$



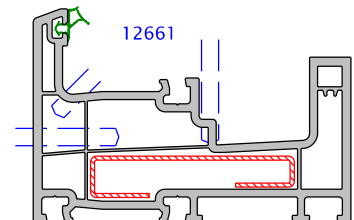
*The drainage area is same with
12661-12663 as shown in the figure above.



Drainage with punching method



*The drainage area is same with
12661-12663 as shown in the figure above.

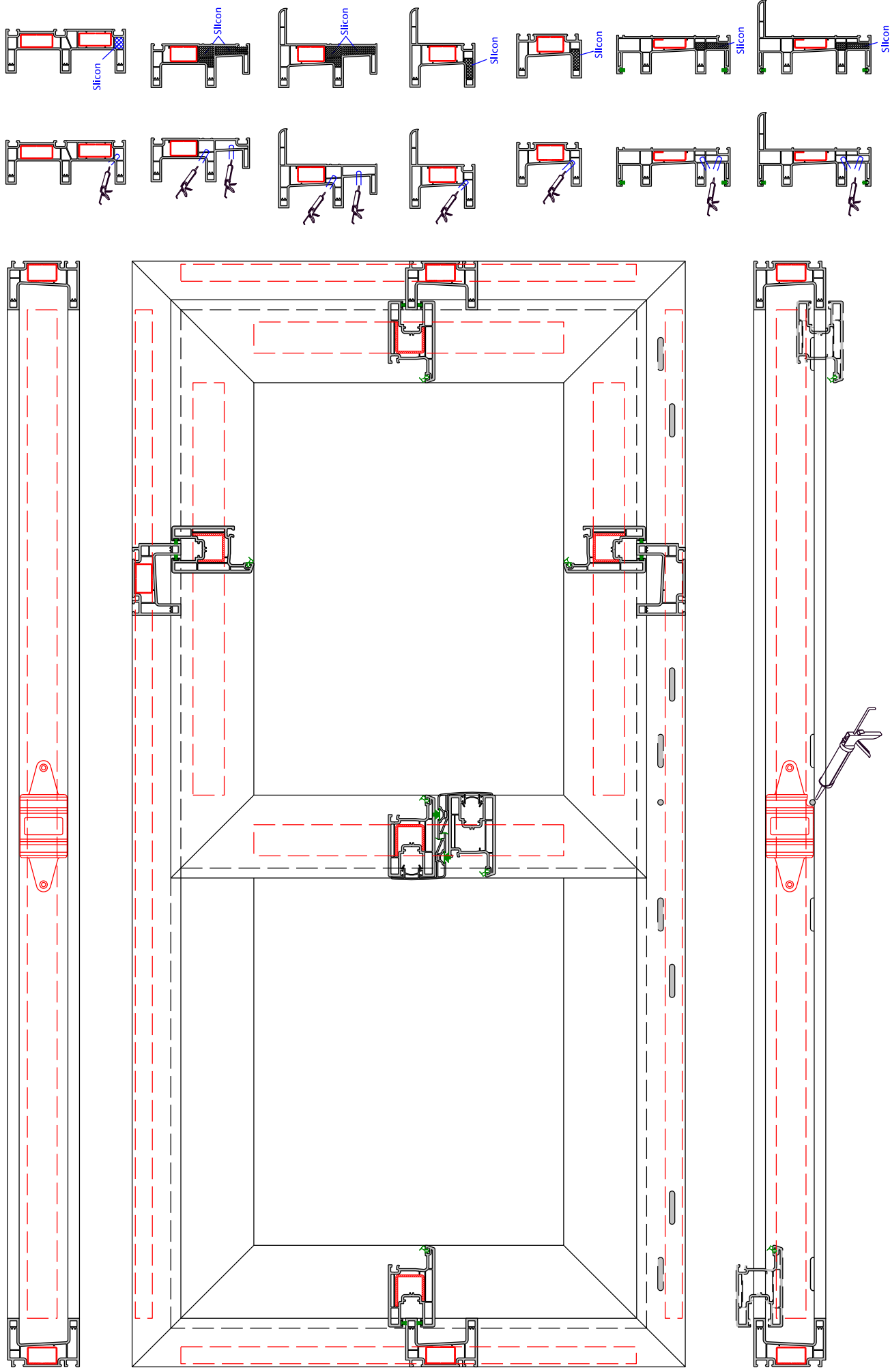




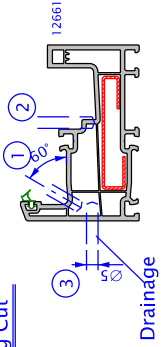
R-R İTHALAT İHRACAT
VE PAZARLAMA A.Ş.

PREPARATION OF PROFILES

Water drainage; method-2

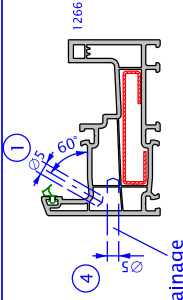


Moving Cut

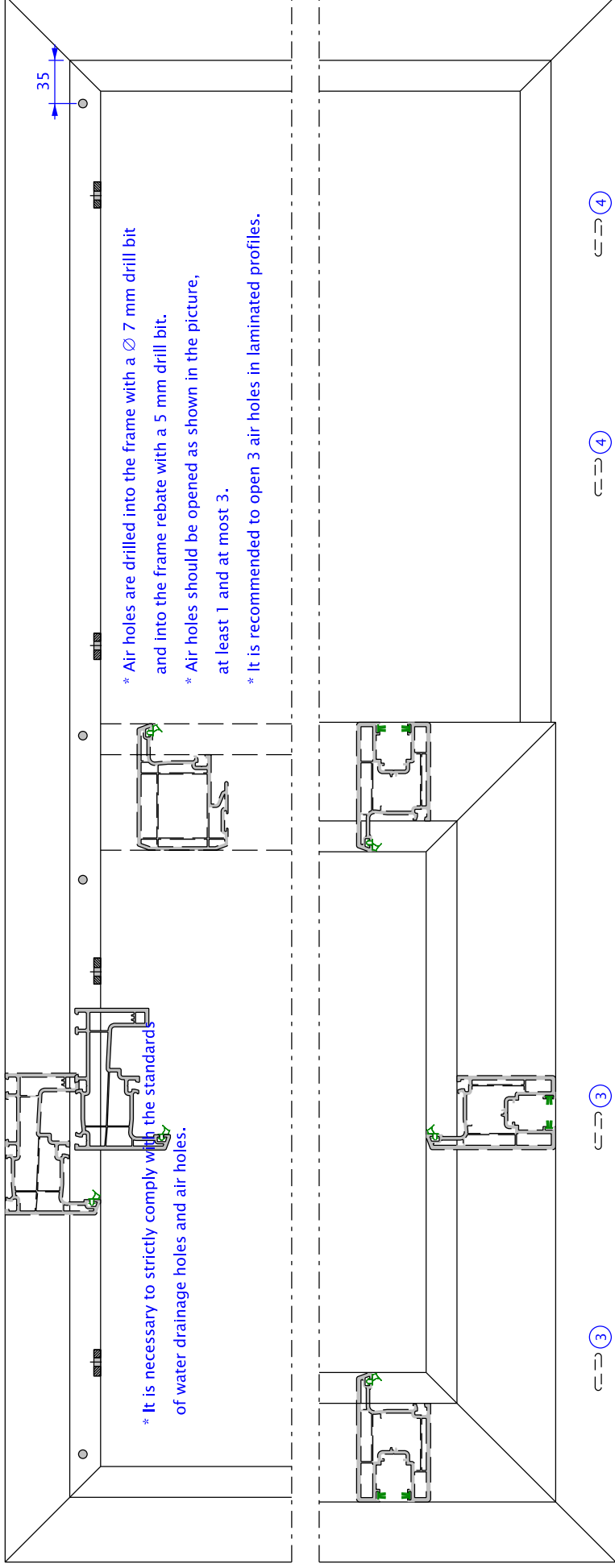
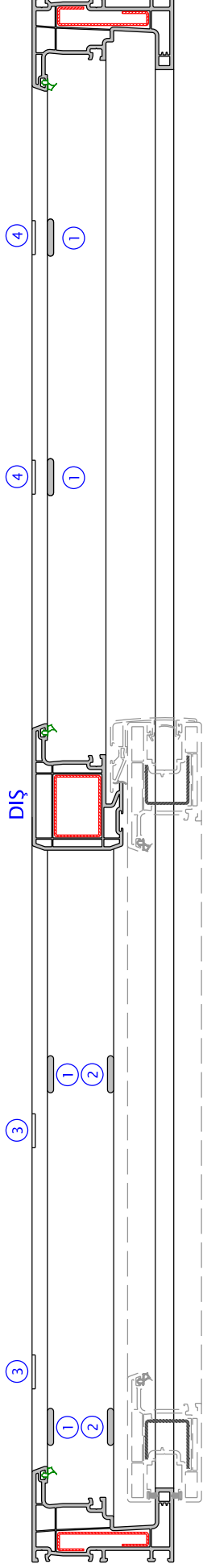


*Water drainage no. 3 (single feder) is drilled on the outside of the frame where the sliding wing is closed.

Fixed Side



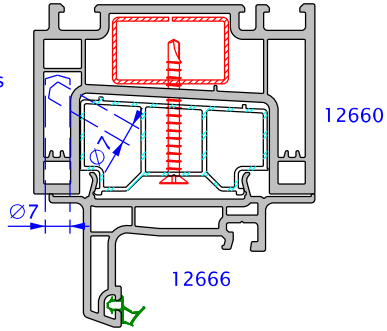
*Water discharge hole no 4 (double feder) is drilled on the outside of the fixed side of the frame.



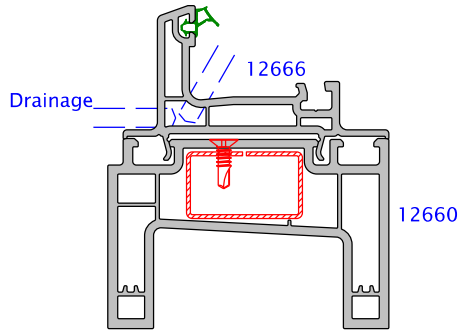
13001
3.9*13



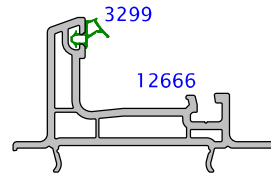
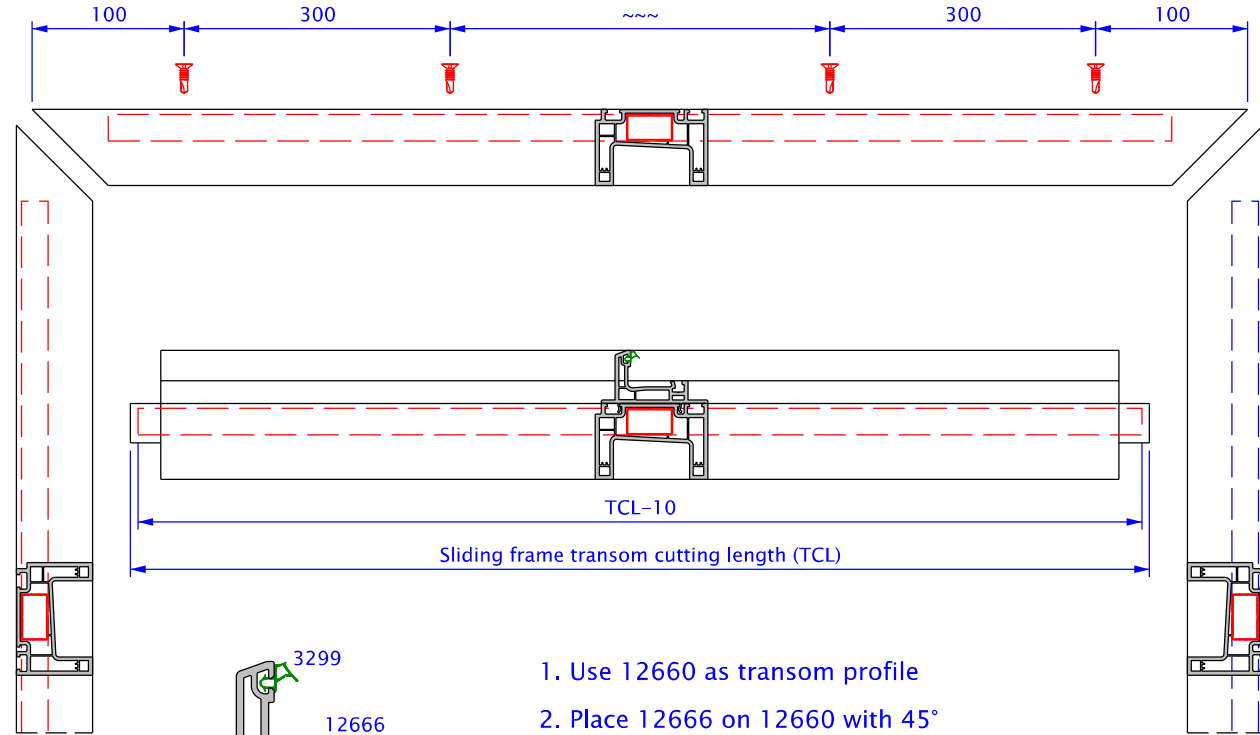
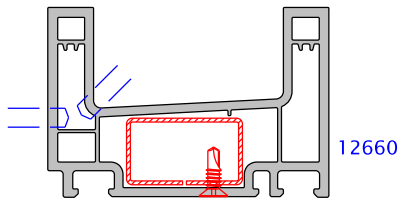
Air holes



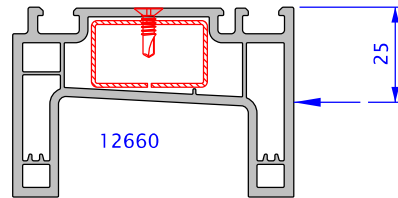
Ø7
Air hole



Drainage

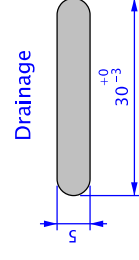
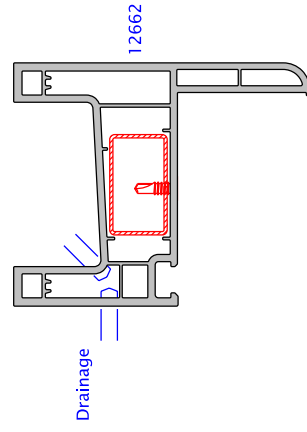


1. Use 12660 as transom profile
2. Place 12666 on 12660 with 45°
3. Place 3299 seal on 12666

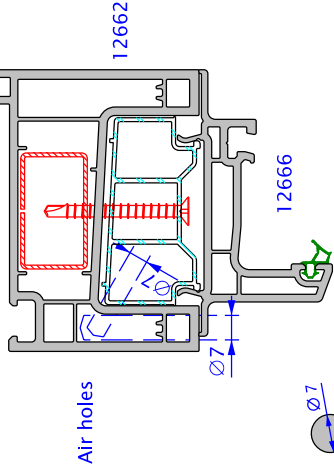


25 Transom axe dimension (If this profile is used as transom)

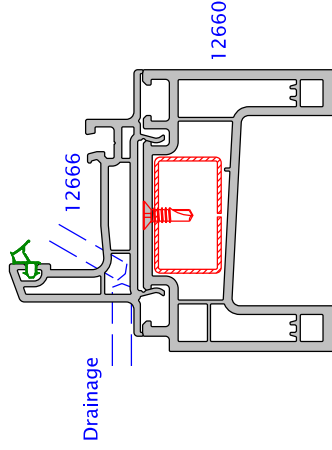
Cutting of reinforcement (12662) & Drainage-decompression



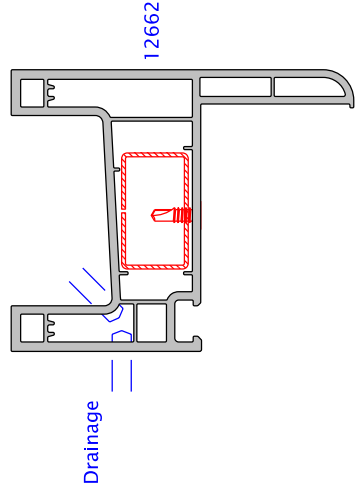
13001
3.9*13



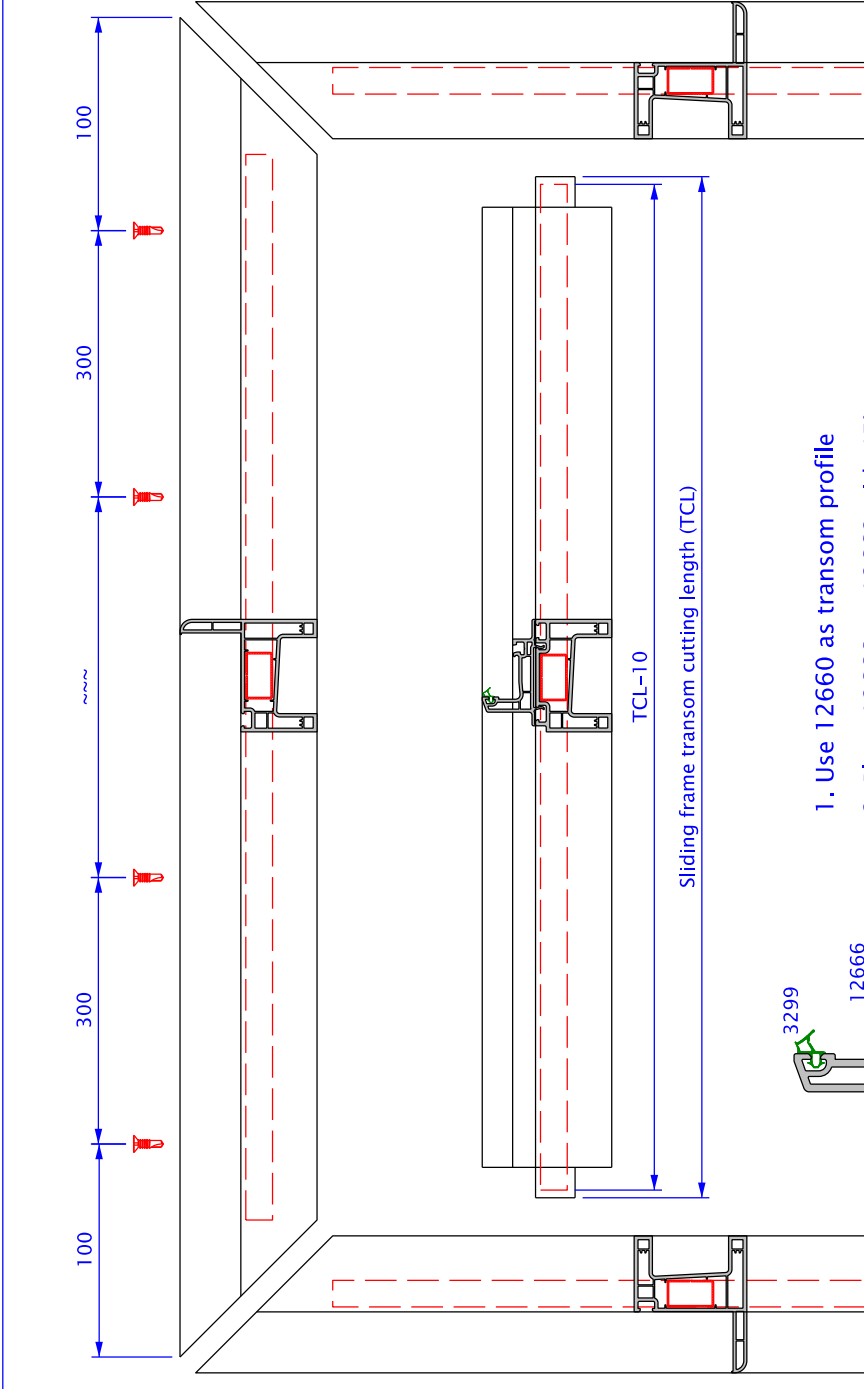
Air holes
(air holes can be milled as slots)



Drainage



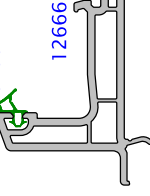
Drainage



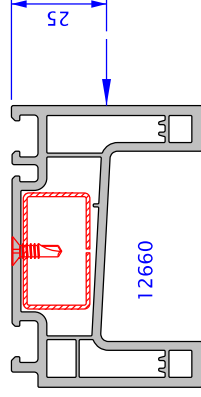
TCL-10

Sliding frame transom cutting length (TCL)

3299



1. Use 12660 as transom profile
2. Place 12666 on 12662 with 45°
3. Place 3299 seal on 12666

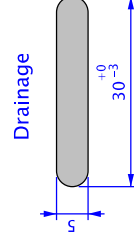


Transom axle dimension (in the case of profile is used as transom)

Cutting of reinforcement & Drainage-decompression (12665)



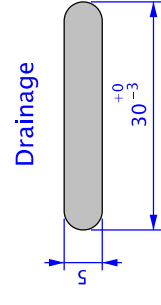
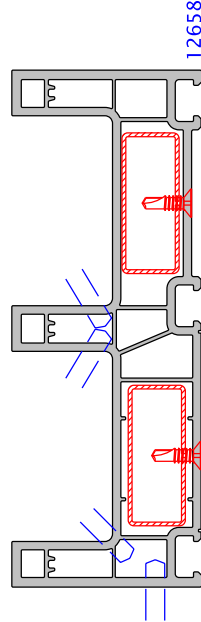
Cutting of reinforcement (12684) & Drainage-decompression



Cutting of reinforcement (12658) & Drainage-decompression



Drainage



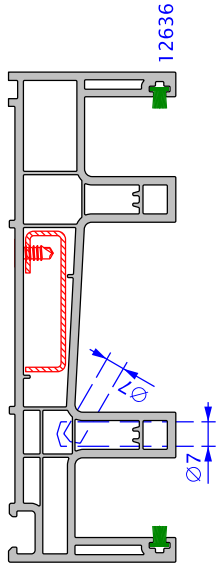
PREPARATION of PROFILES

Cutting of reinforcement (12636) & Drainage-decompression

13001
3.9*13

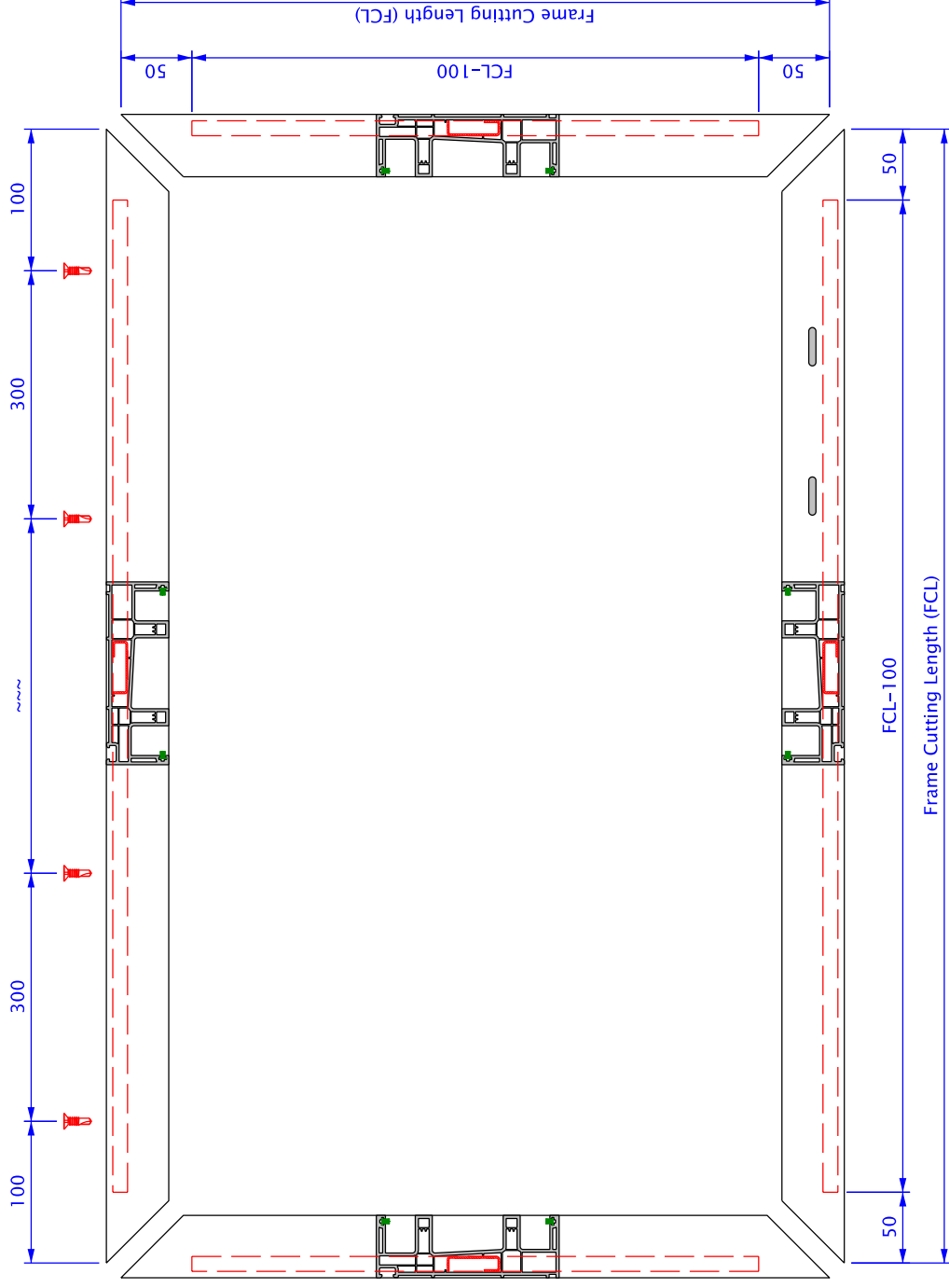
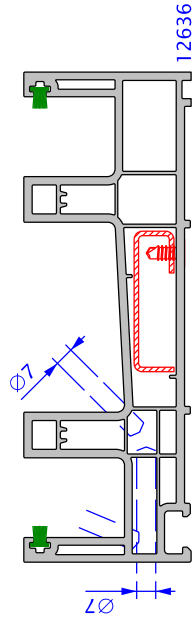


Air holes

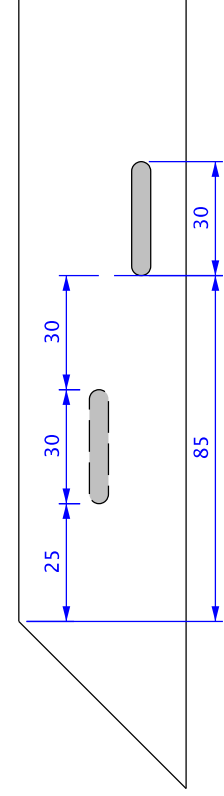
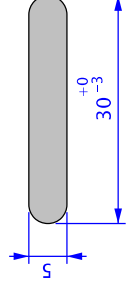


Air holes
(air holes can be milled as slots)

Drainage



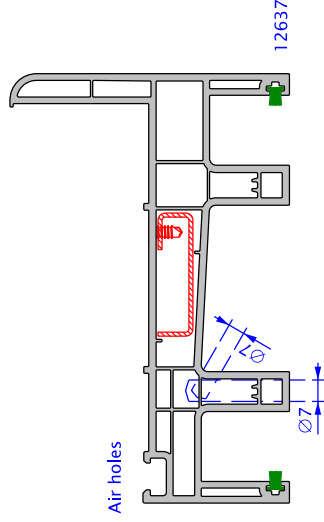
Drainage



PREPARATION of PROFILES

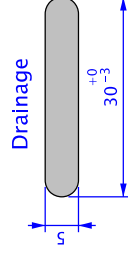
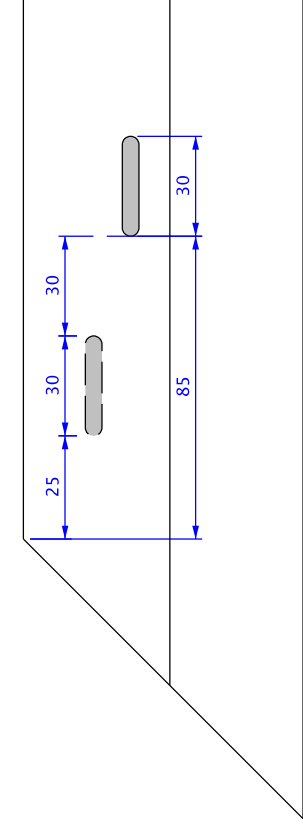
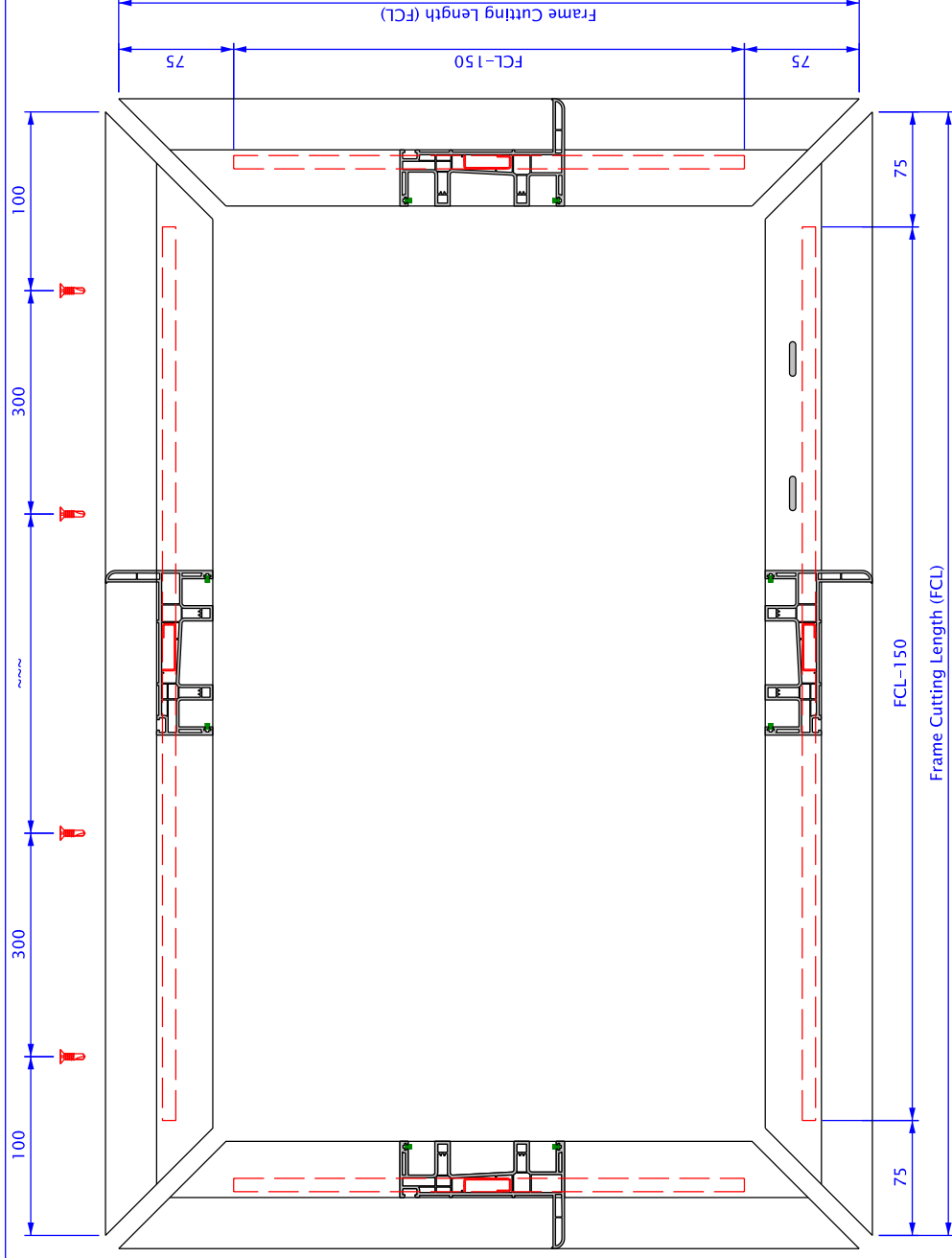
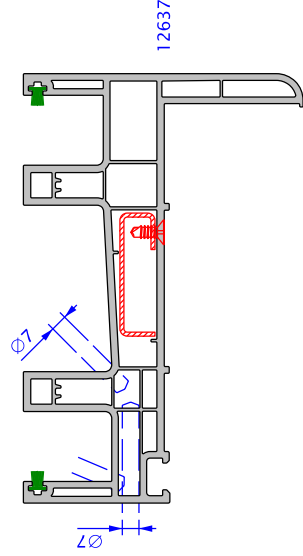
Cutting of reinforcement (12637) & Drainage-decompression

13001
3.9*13



Air holes
(air holes can be milled as slots)

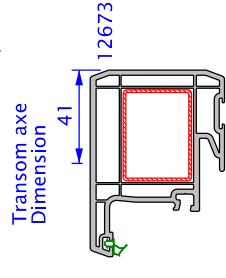
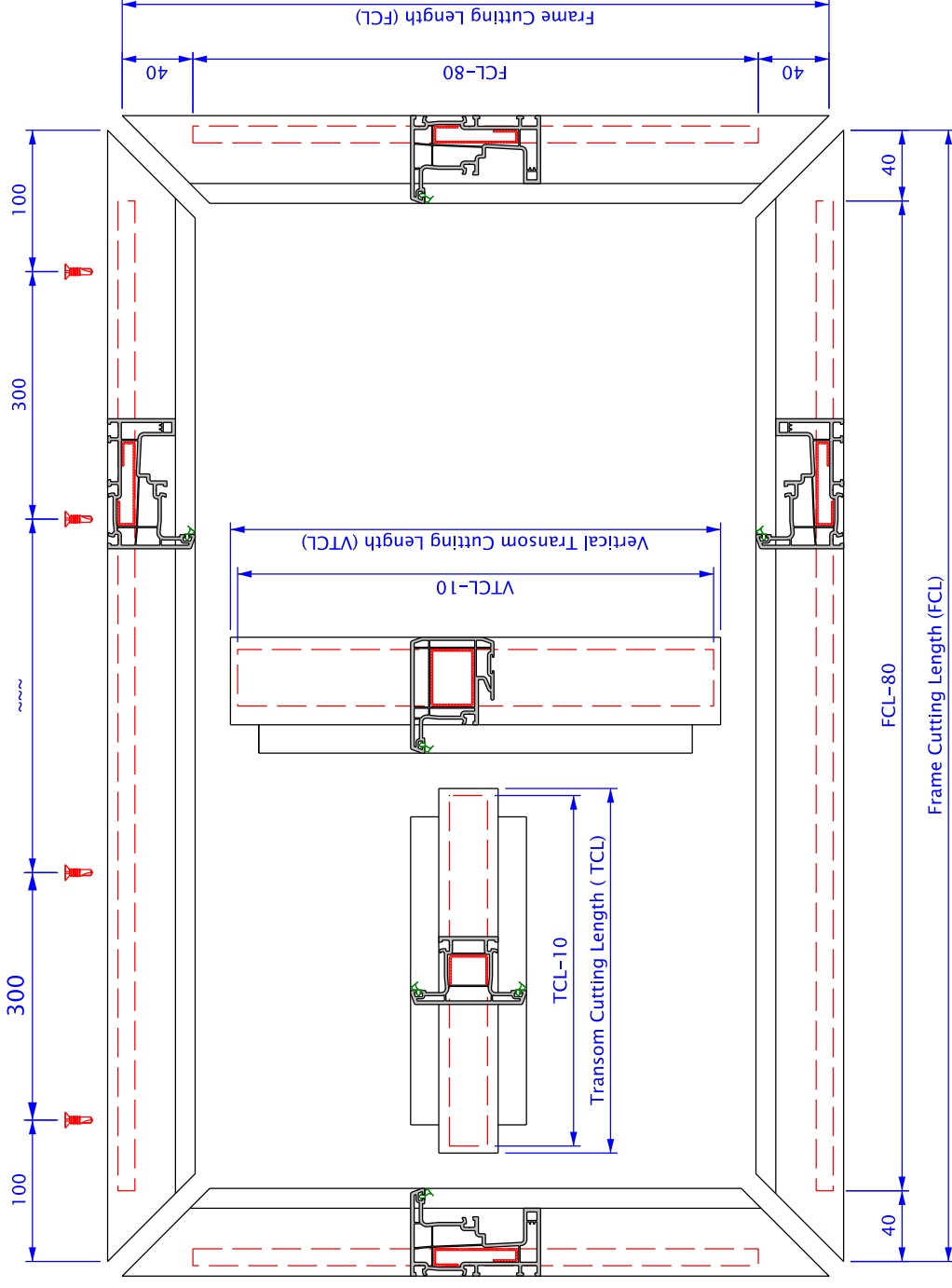
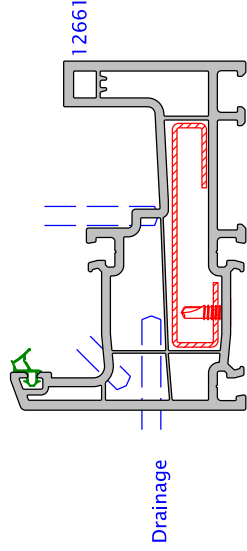
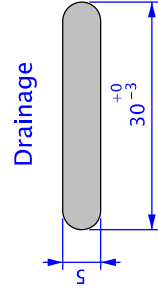
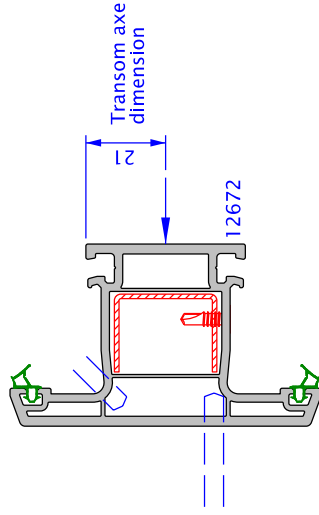
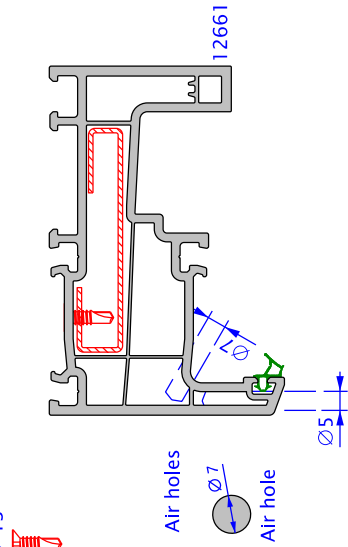
Drainage



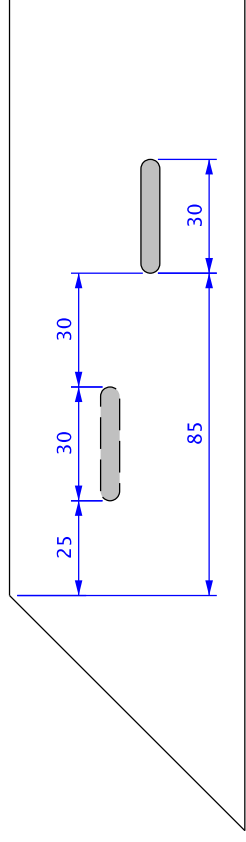
PREPARATION of PROFILES

Cutting of reinforcement (12661/12672/12673) & Drainage – decompression

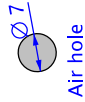
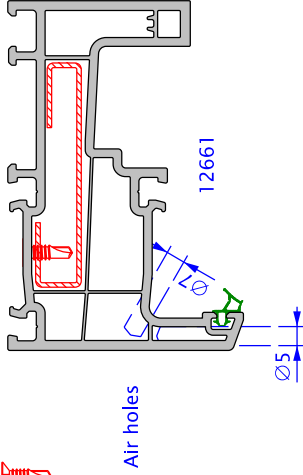
13001
3.9*13



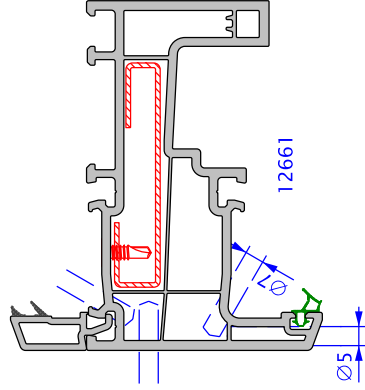
During the installation of vertical mullion to fixed-sliding frame, it should be placed as upside-down.



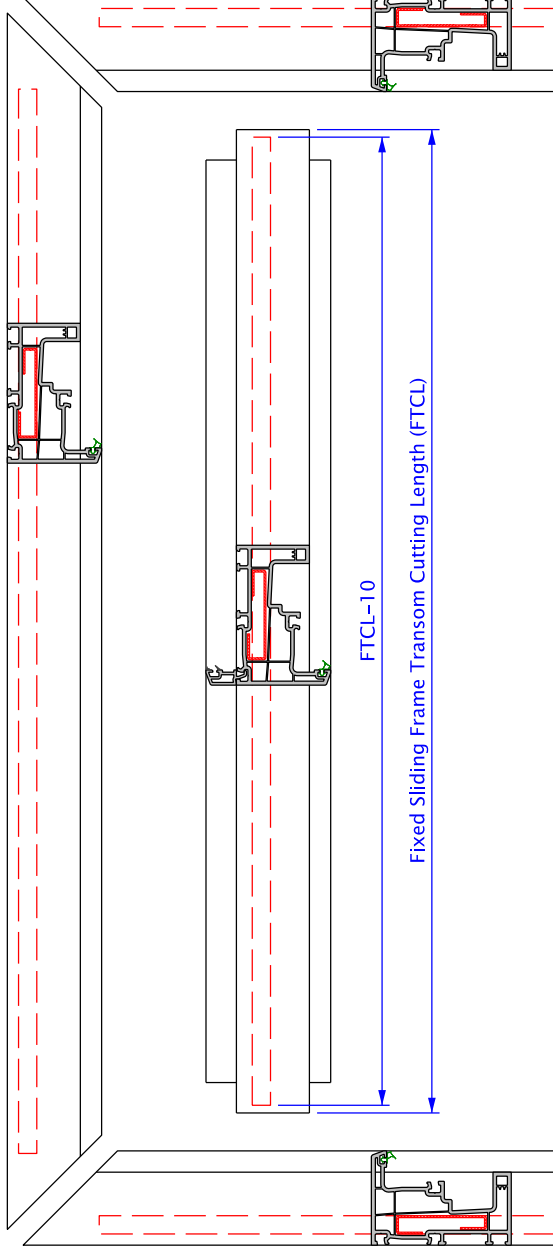
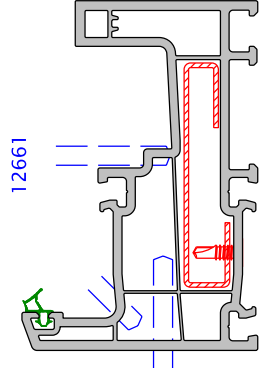
13001
3.9*13



Air hole



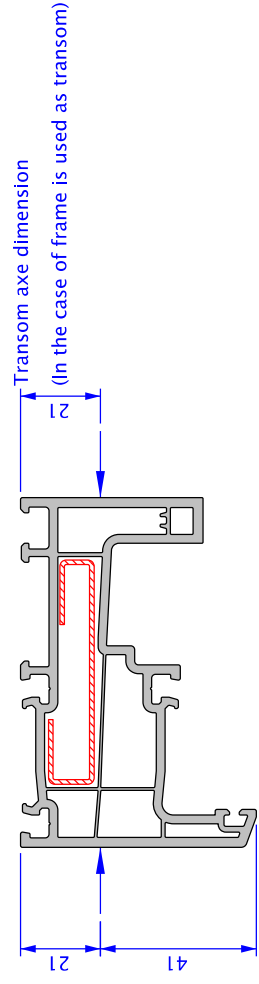
Drainage



Preparing Transom with Glazing Bead

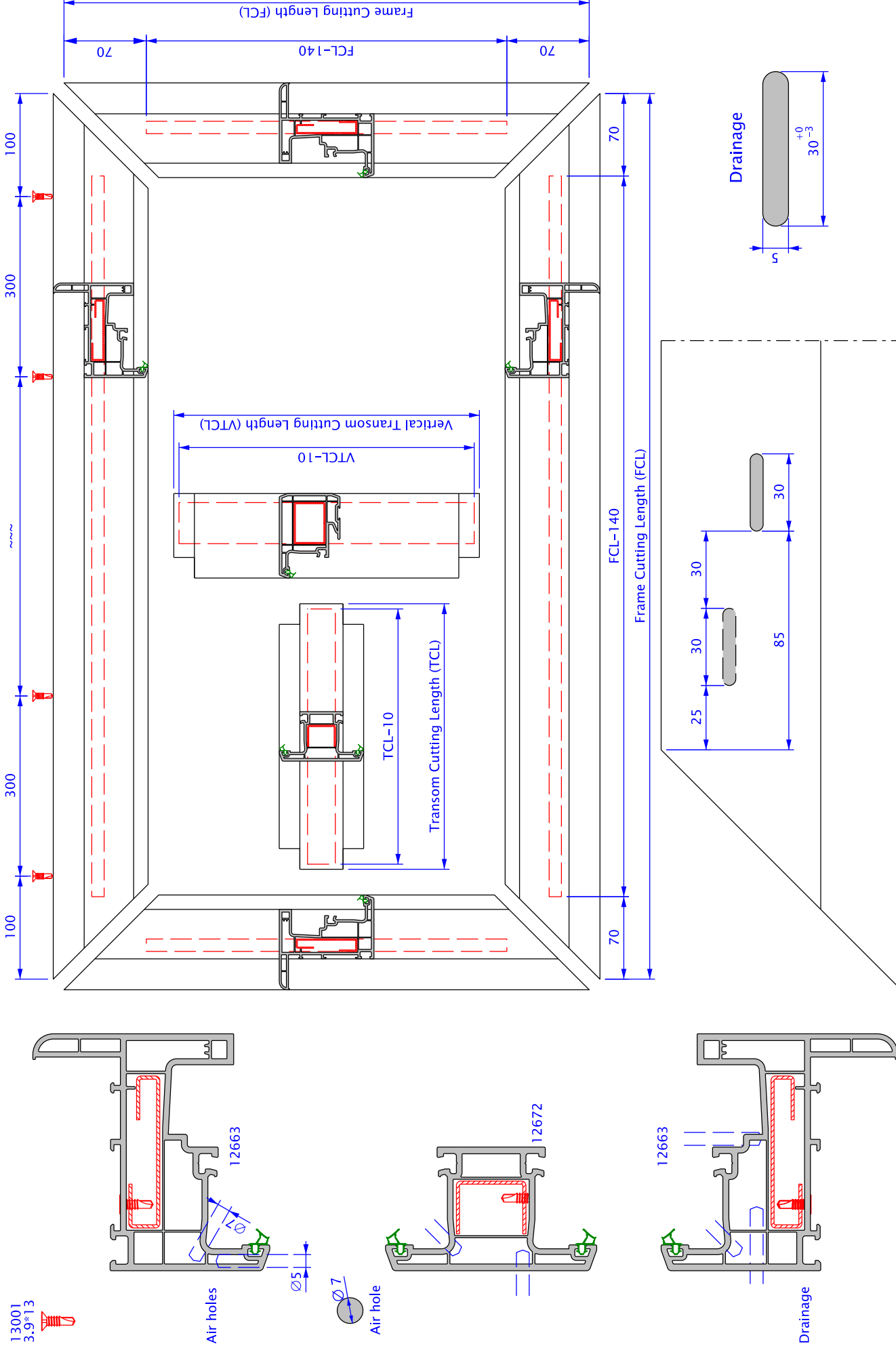
Alternative 1: After the placing the endmilled fixed sliding frame as transom glazing bead can be inserted.

Alternative 2: Glue together the glazing bead with fixed sliding frame as a transom and endmill them together. In this way, the glazing bead is also ready to size.



PREPARATION OF PROFILES

Cutting of reinforcement (12663/12672/12673) & Drainage – decompression

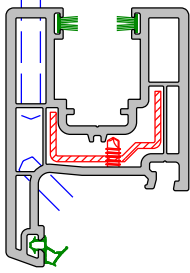


13001
3.9*13

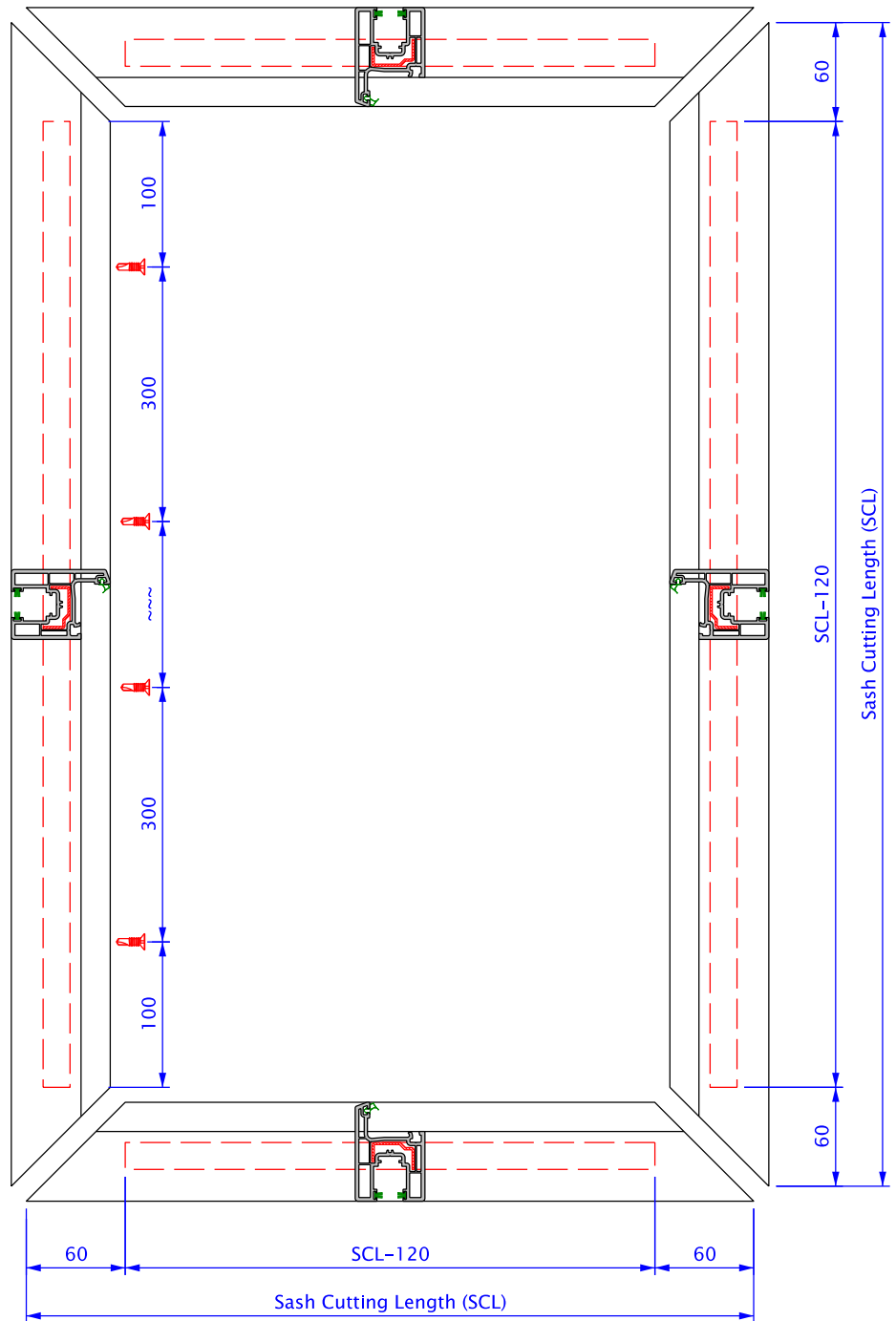


air holes
(air holes can be milled as slot)

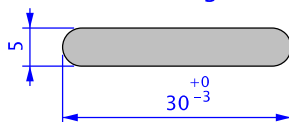
Air holes



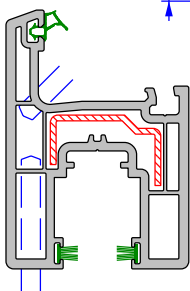
12670



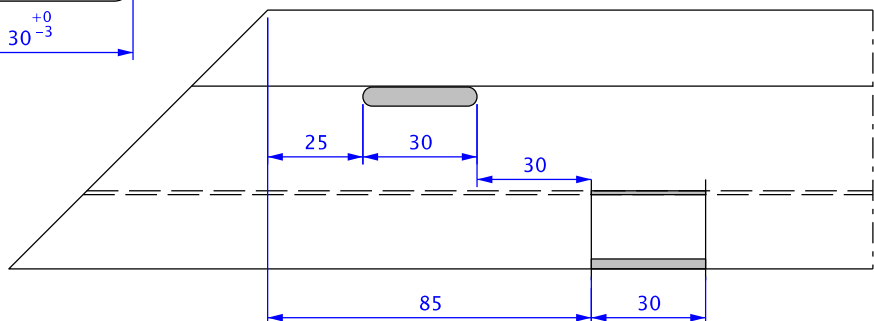
Drainage



Drainage



12670

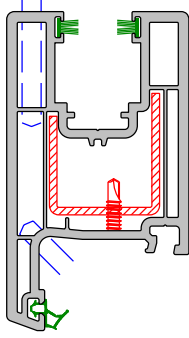


13000
3.9*16

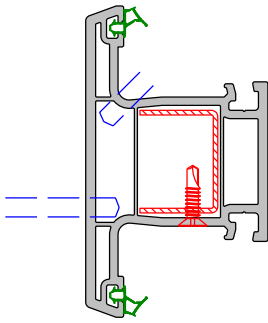


air holes
(air holes can be milled as slot)

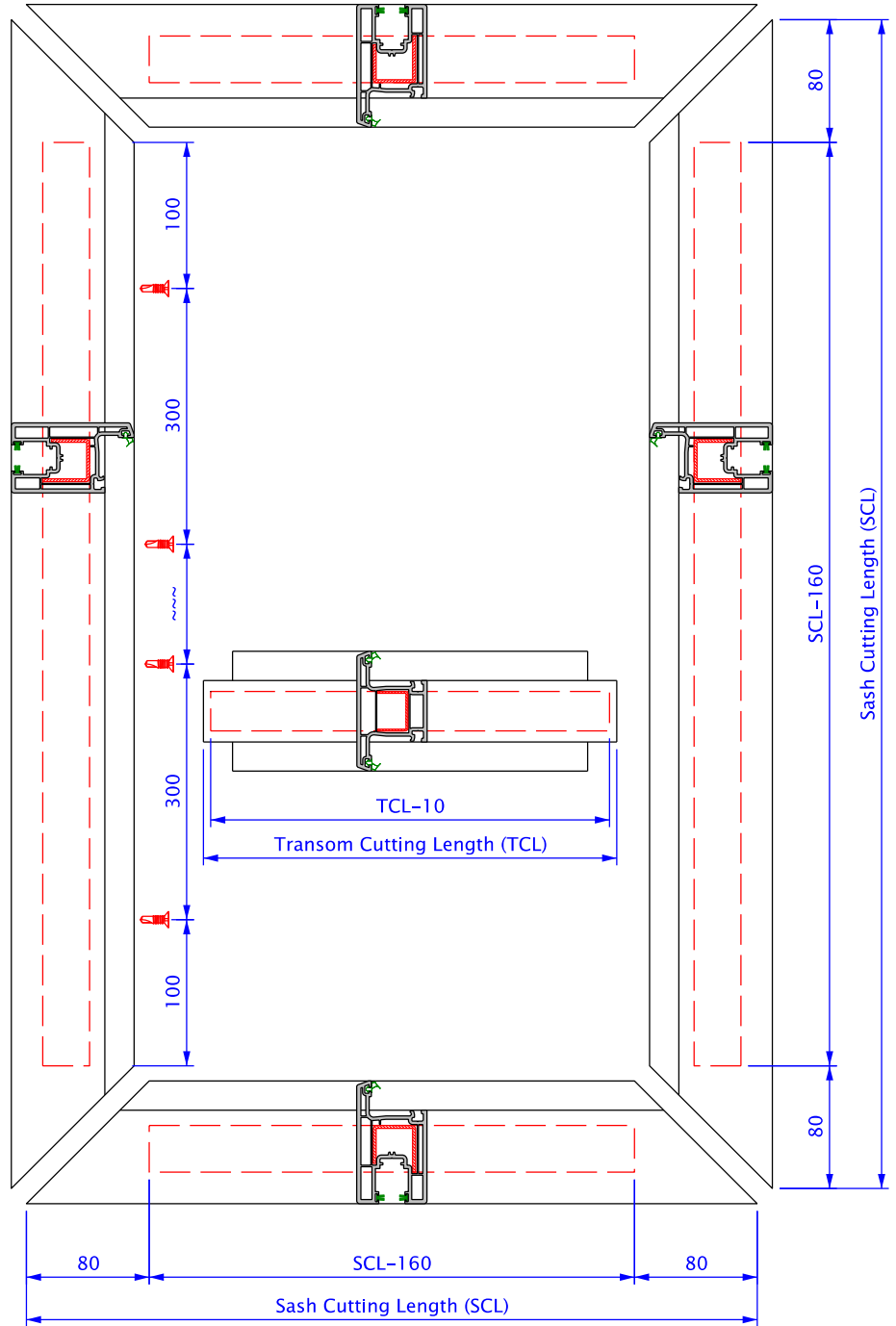
Air holes



12671

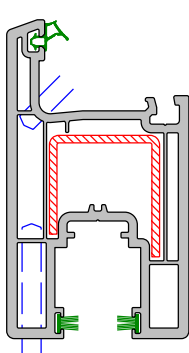


12672

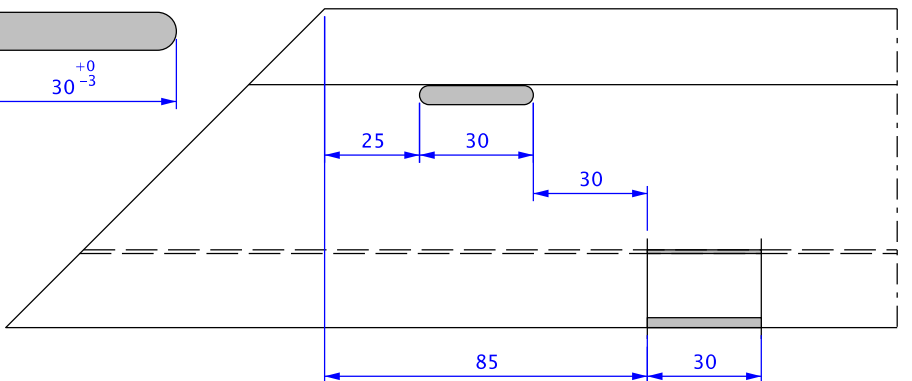
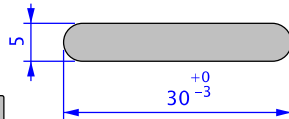


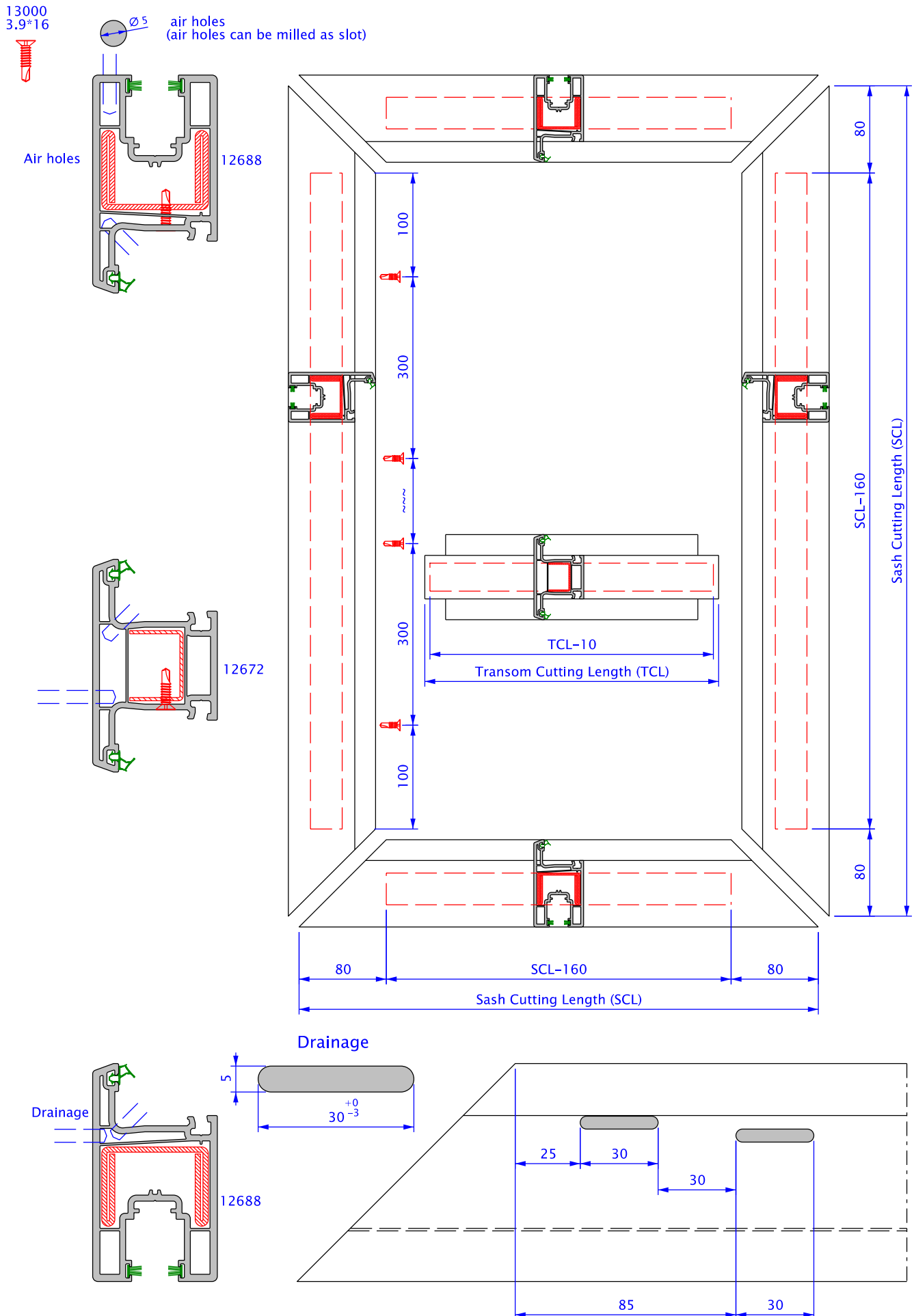
Drainage

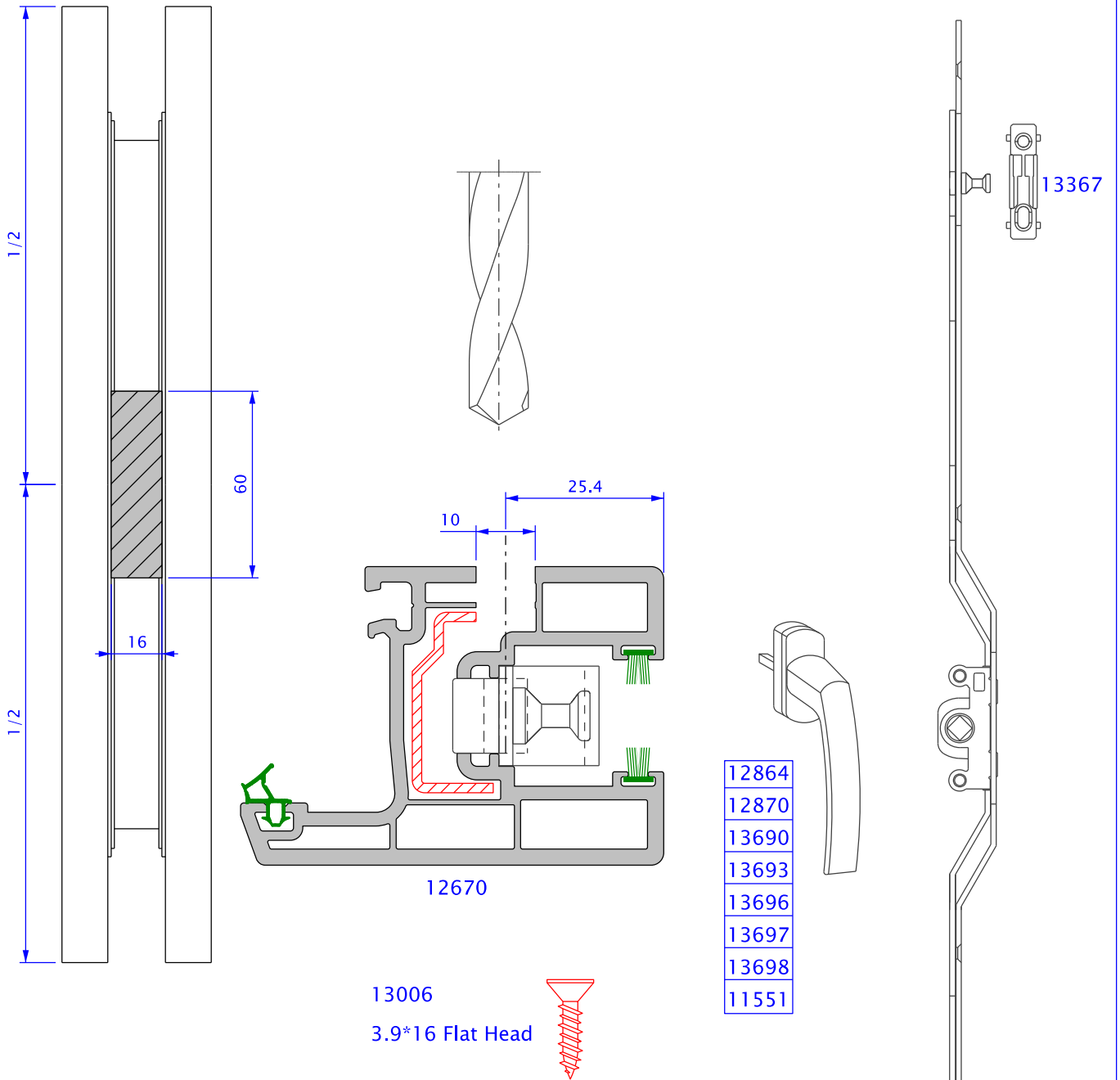
Drainage



12671





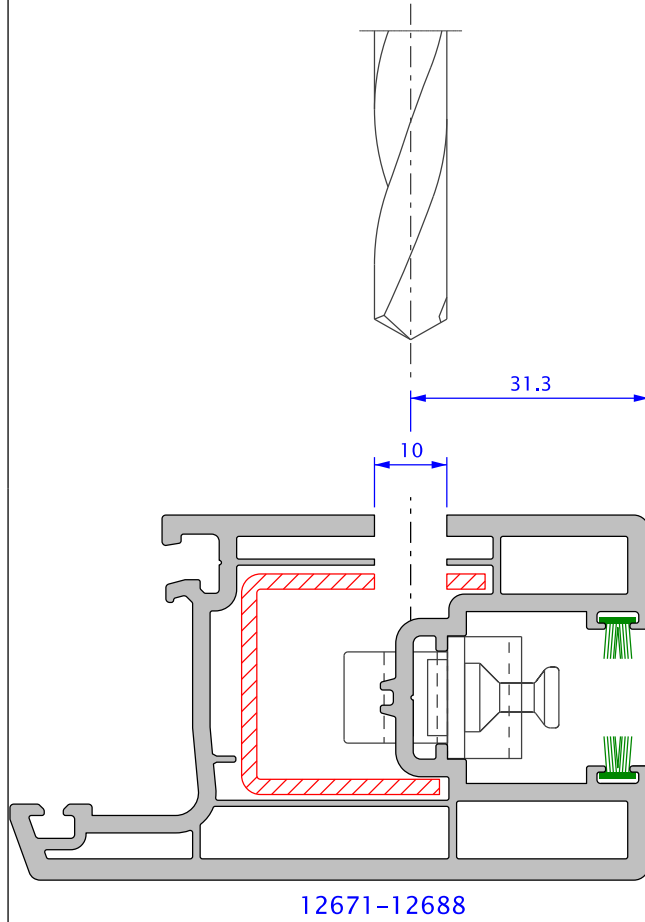
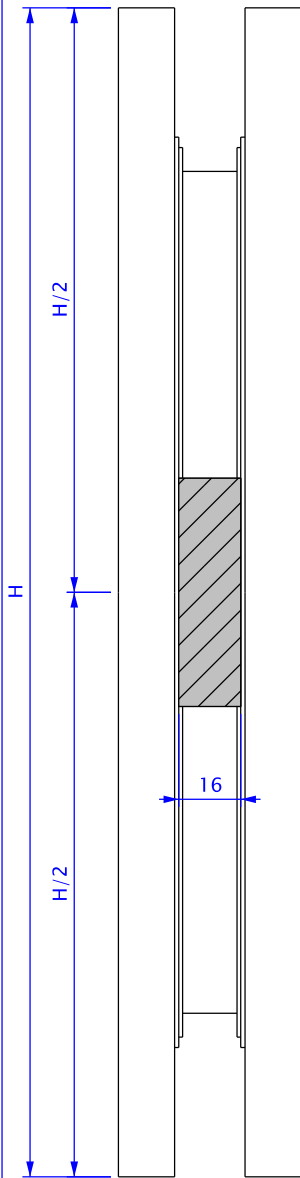


* Sliding window sash(12670) is drilled
for hardware as shown above,

* Screw 3.9x16 (flat head) is used to fix
the espagnolette to profile

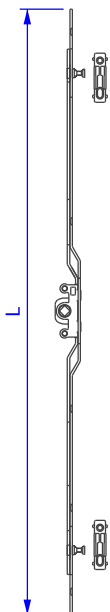
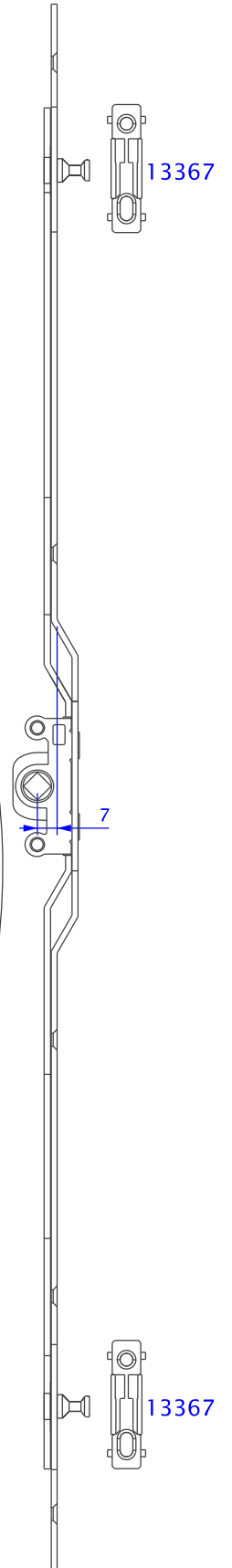
Sliding Window Espagnolettes

P number	Length (L)	# of Striker
13316	40 cm	2
13317	60 cm	2
13318	100 cm	2
13319	140 cm	3



- * Sliding Sash(12671-12688) is drilled for hardware as shown above
- * Screw 3.9x22 (Flat head) is used to fix the espagnolette to profile

12864
12870
13690
13693
13696
13697
13698
11551

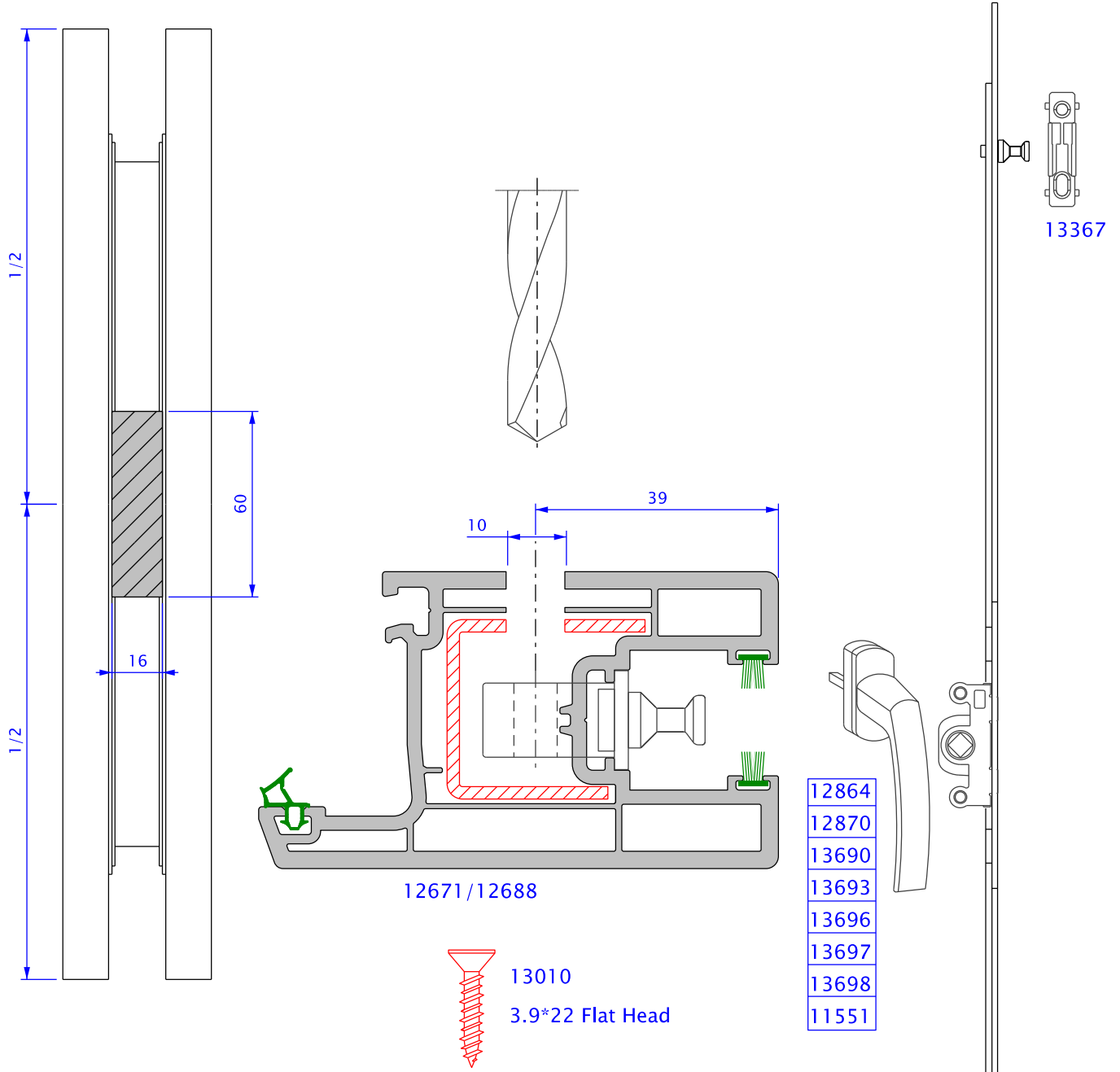


13010
3.9*22 Flat Head



Sliding Window Espagnolettes

P number	Length (L)	# of Striker
13368	40 cm	2
13369	60 cm	2
13370	100 cm	2
13371	140 cm	3

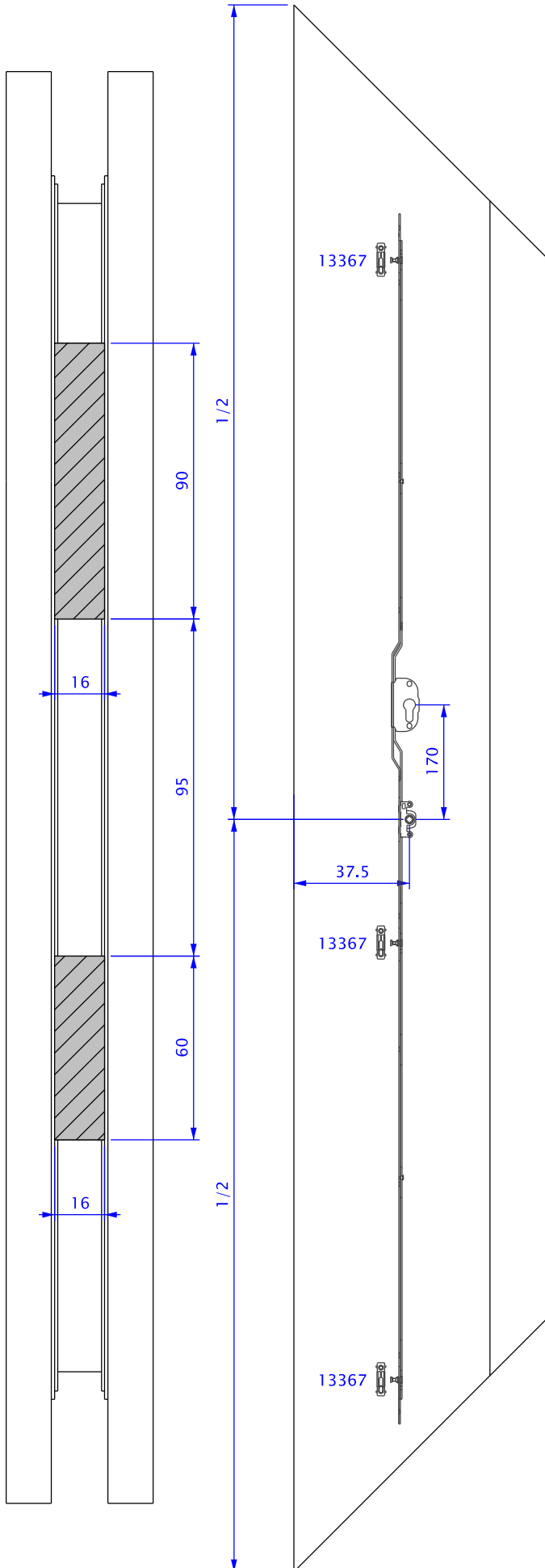


* Sliding Sash(12671–12688) is drilled for hardware as shown above

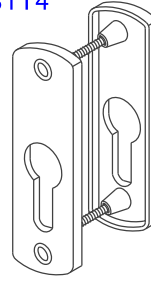
* Screw 3.9x16 (Flat head) is used to fix the espagnolette to profile

Sliding Espagnolettes

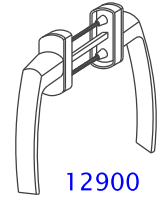
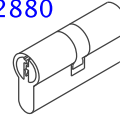
P number	Length (L)	# of Striker
13390	60 cm	2
13391	100 cm	2
13392	140 cm	3
13393	180 cm	3
13394	200 cm	4



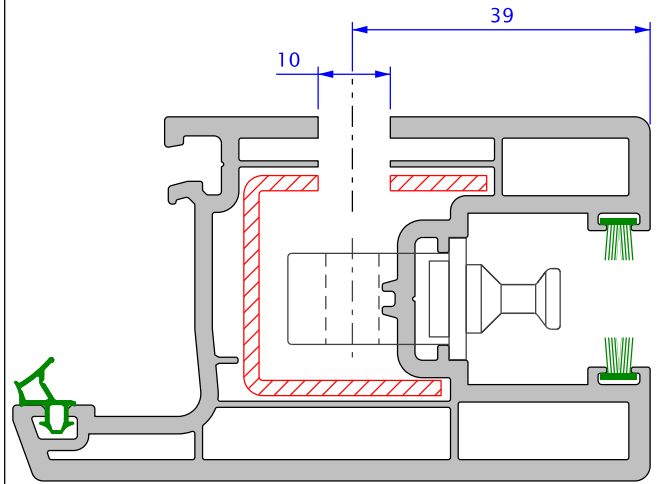
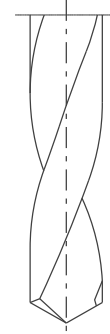
13114



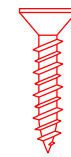
12880



12900



12671/12688



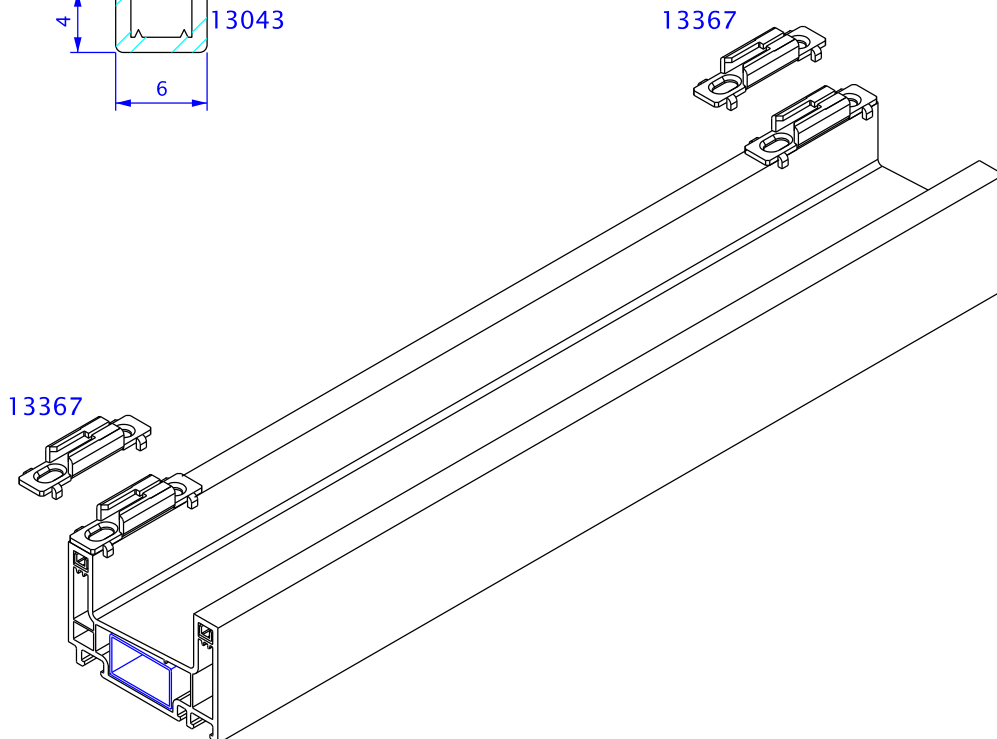
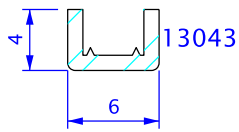
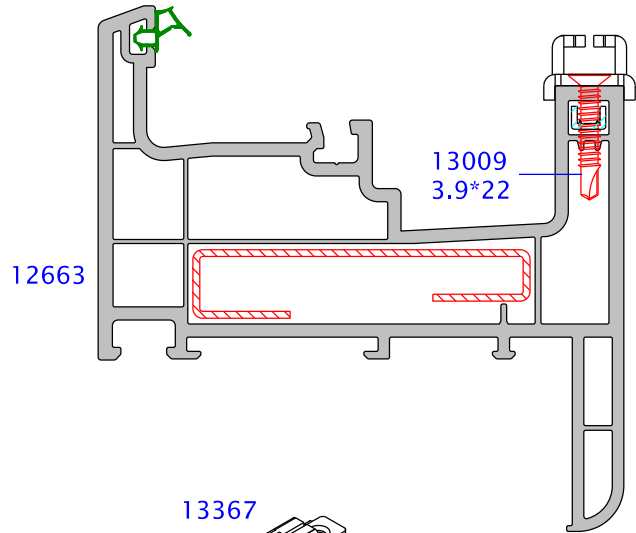
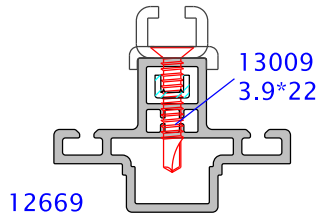
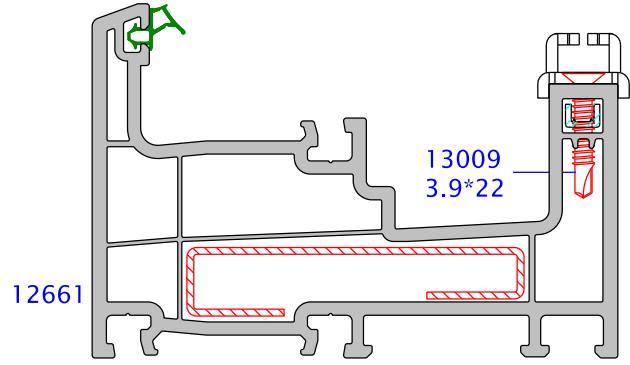
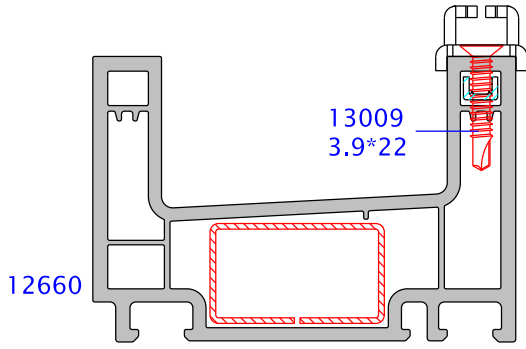
13010

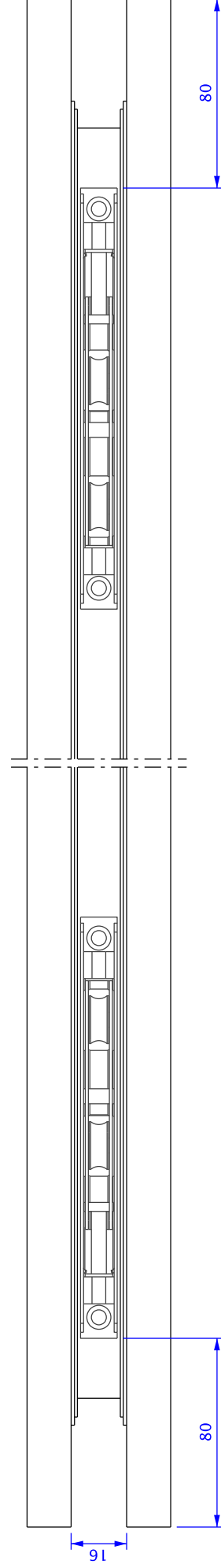
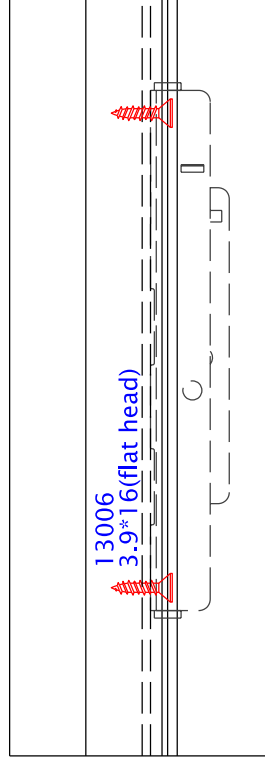
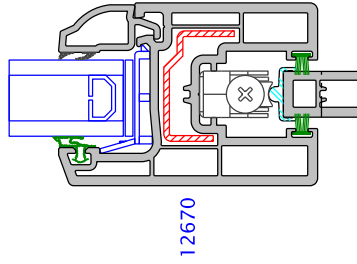
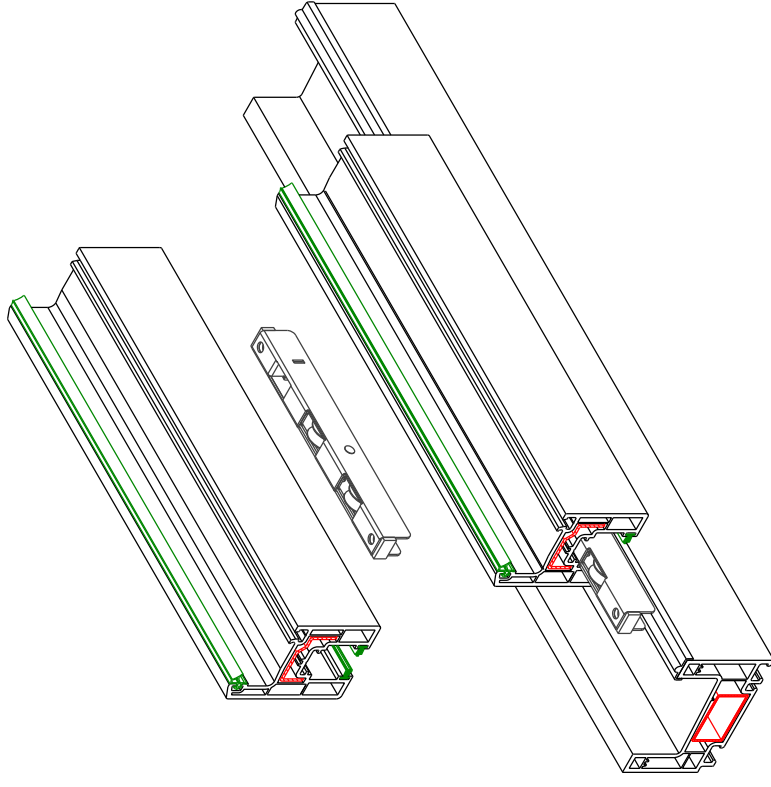
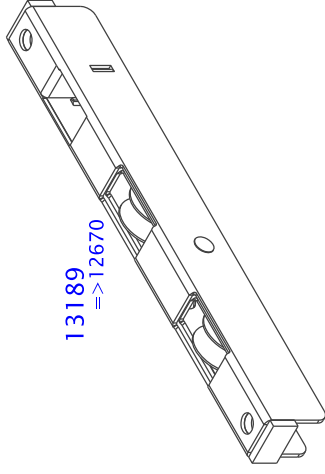
3.9*22 Flat Head

Sliding Locked Espagnolettes

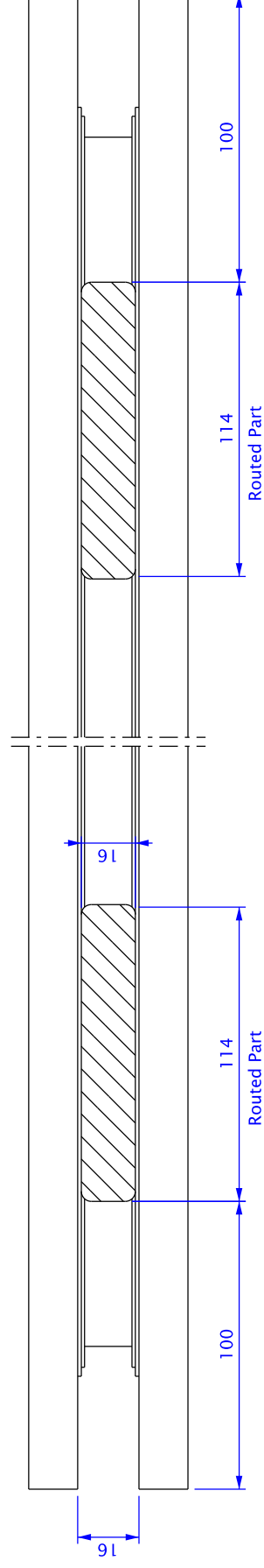
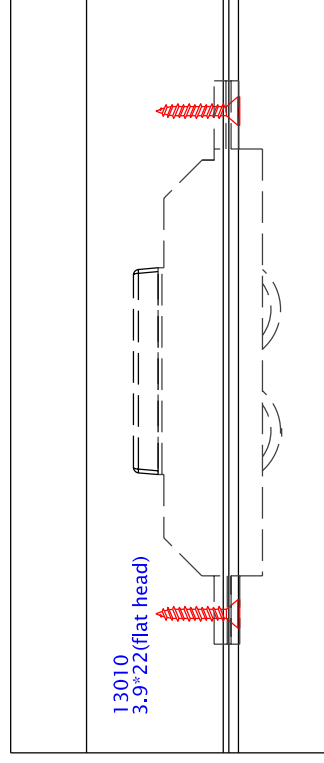
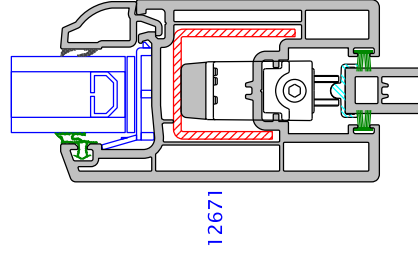
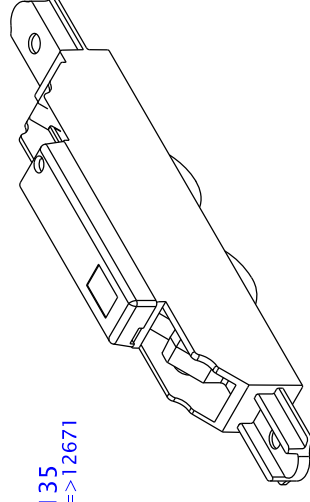
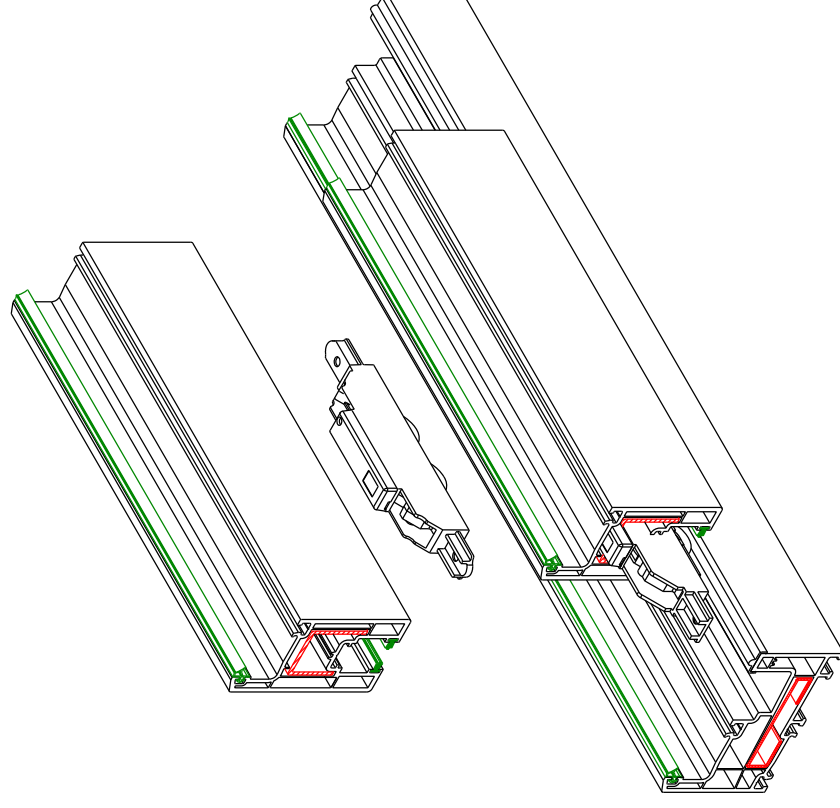
P number	Length (L)	# of Striker
13349	160 cm	2
12857	180 cm	3

1. Insert the aluminium support profile before welding,
2. Sliding strikers and anti-lift pieces which should be fixed through aluminium profile (13043)
3. 13043 (aluminium support) are fixed to frame with screw 3.9x22 (13009) (flat head).



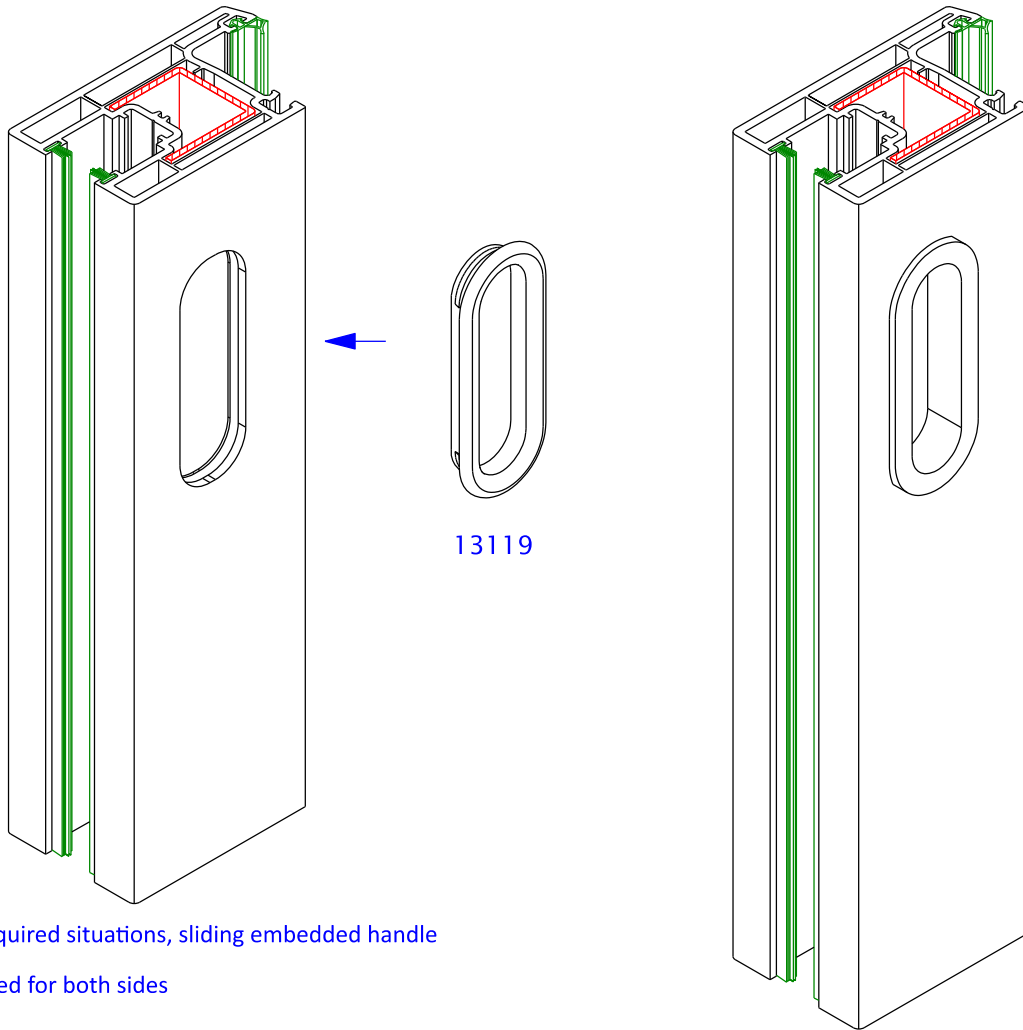


- * There is no need to mill the sash (12670) for installation of sliding roller (13189).
- * Sliding window sash roller (13189) must be installed as shown in the picture above.
- * Sliding roller (13189) can not be used in the application of sliding door sash (12671).

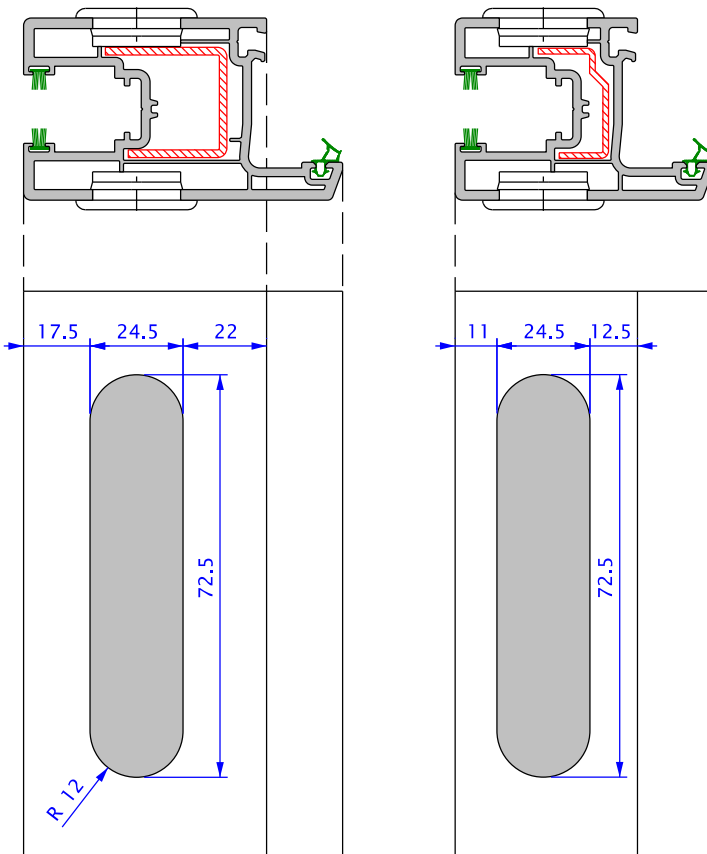


* Sliding Sash (12671) should be freezed to install the roller (13135) as shown in the picture above

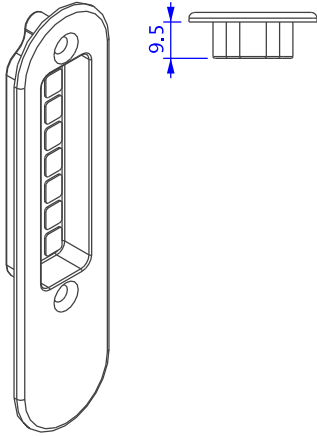
* Sliding roller (13135) should be installed in the espagnolette groove on sash. It is fixed with screw 13010(3.9x22 flathead)



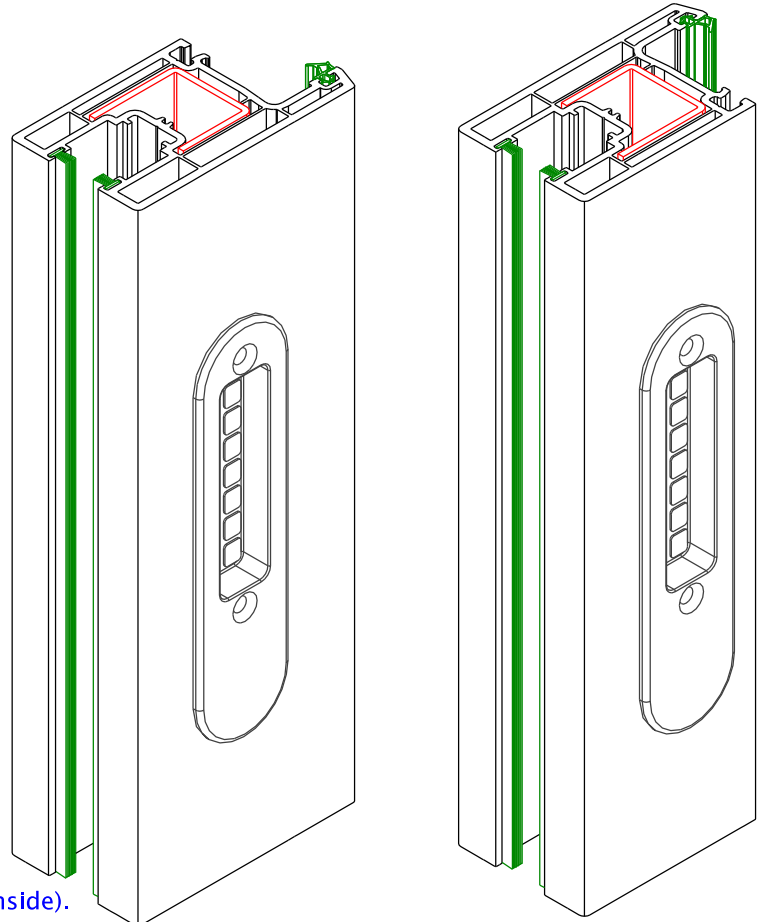
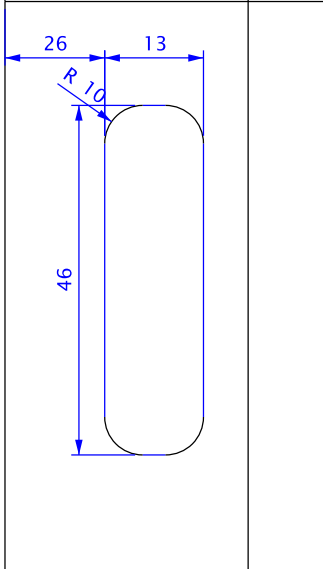
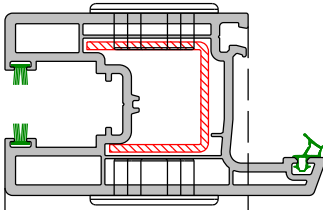
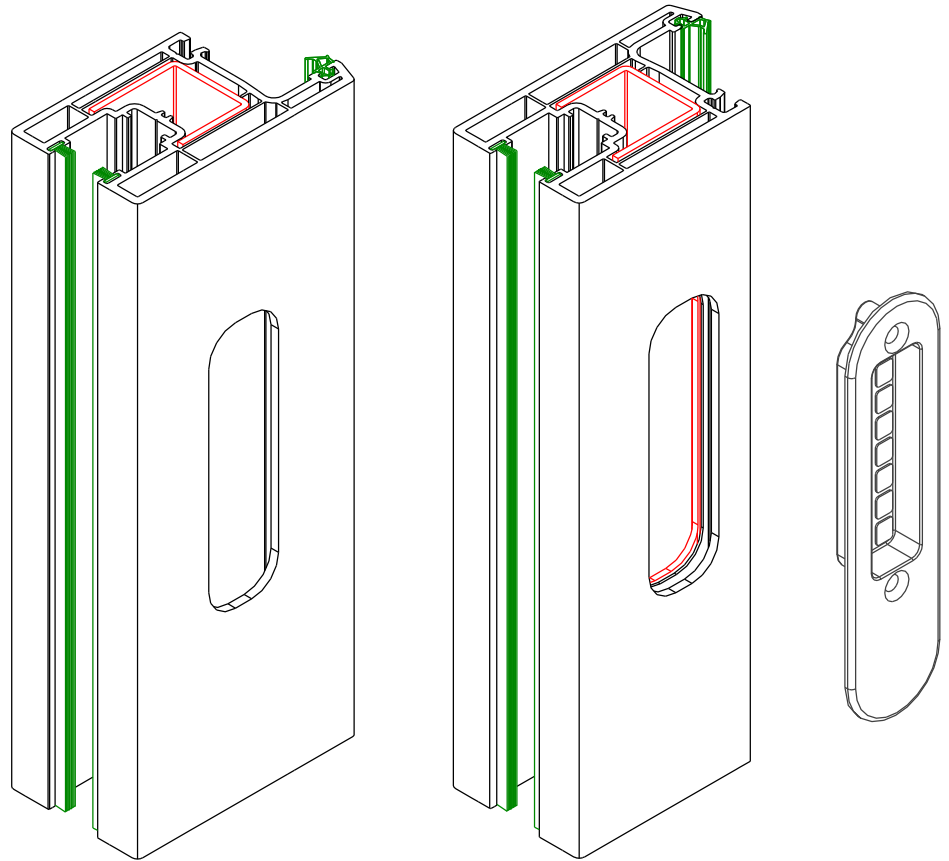
*When required situations, sliding embedded handle can be used for both sides



- * Sliding embedded handle (13119) can be used in both sash profile(12670/12671),
- * for windows :
13119 is used on only one side (inside)
- for doors :
It can be used on both sides(inside+outside),
- * Sash profiles should be routed for 13119 as shown left side.

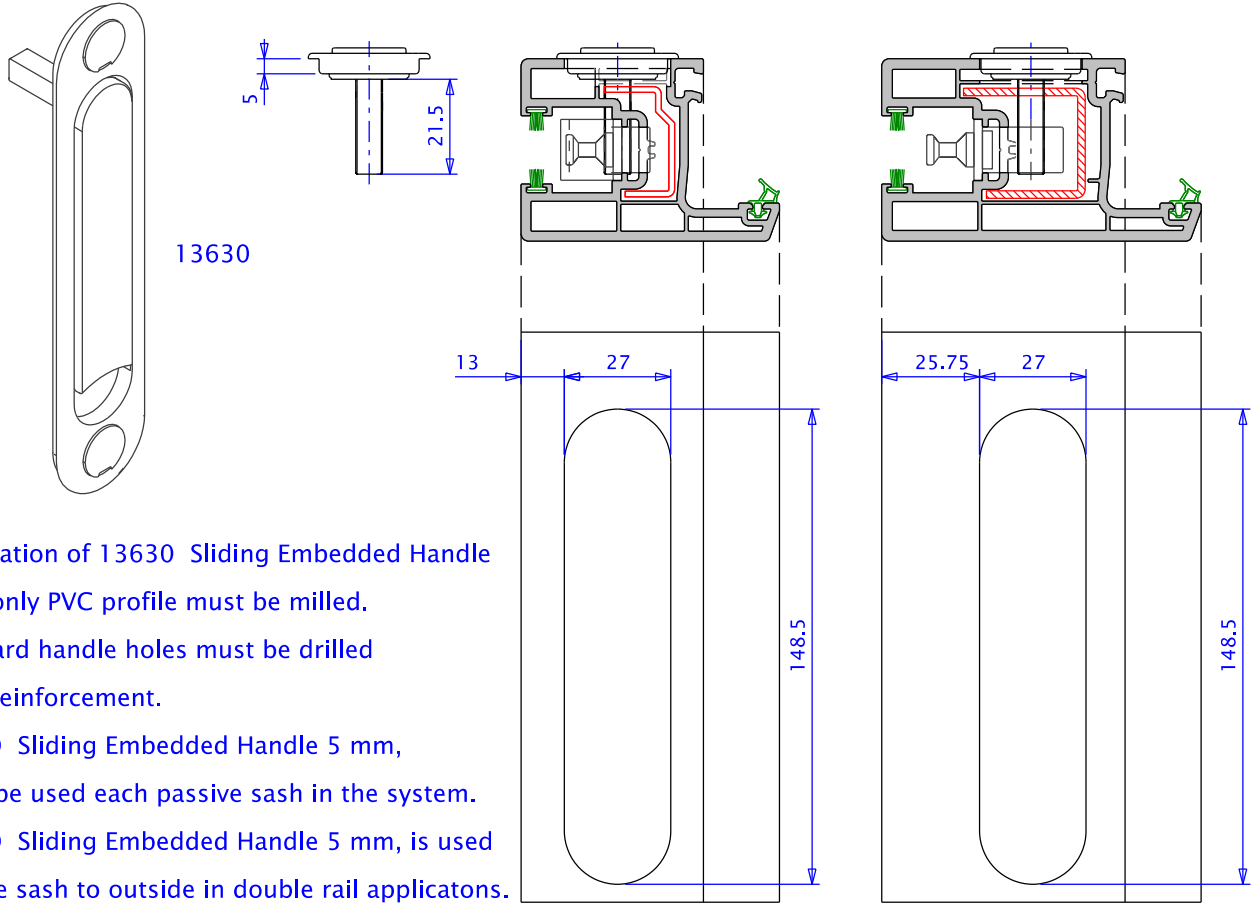


13689

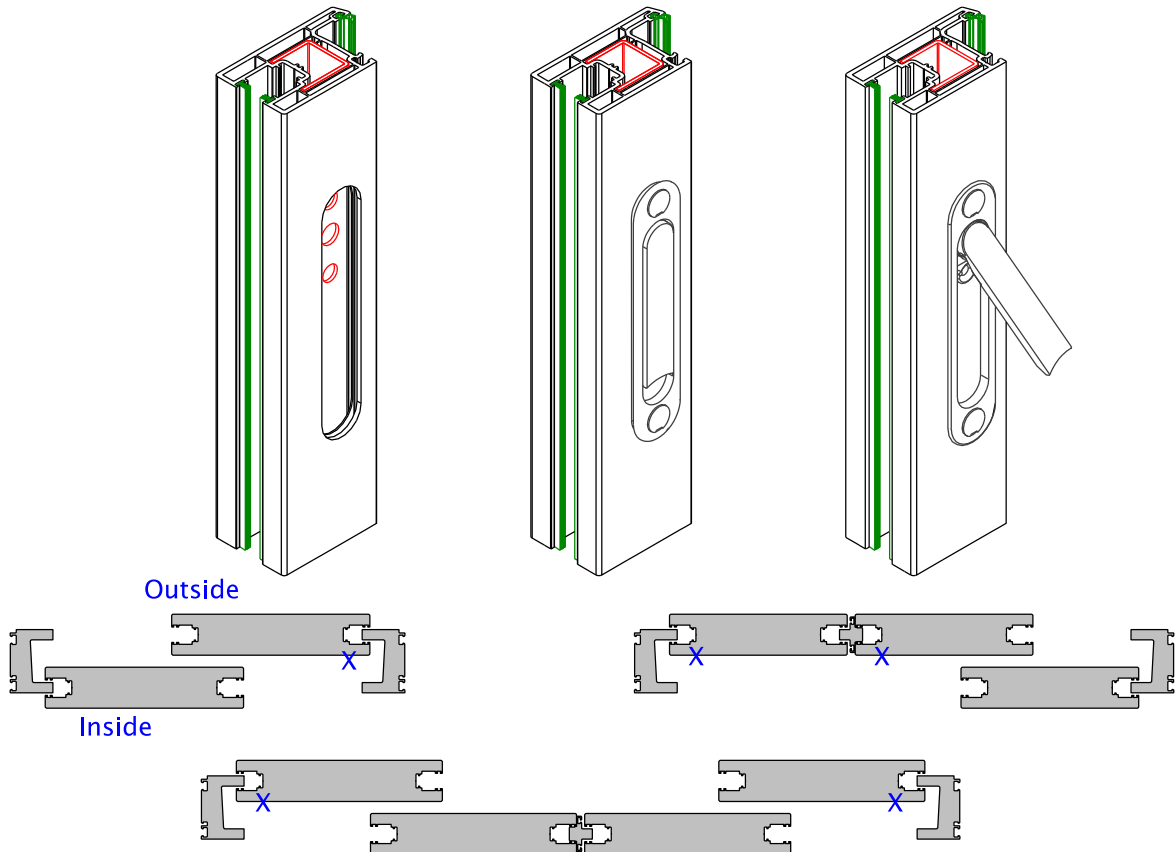


* 13689 – Sliding Alum. Concealed Handle can be used with double side for doors (inside & outside), one side for windows (only inside).

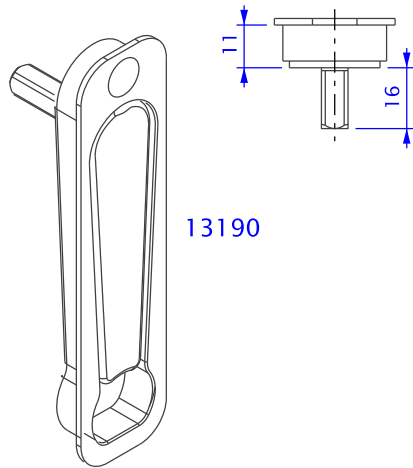
* Location of the 13689 Sliding Alum Concealed Handle on the sash must be milled according to given dimensions.



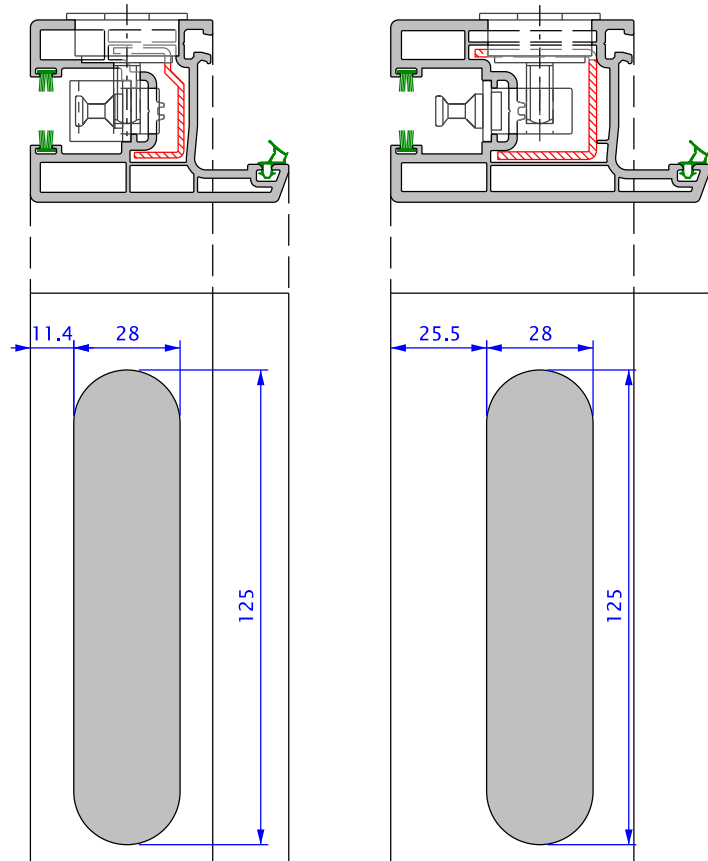
- * Application of 13630 Sliding Embedded Handle 5 mm, only PVC profile must be milled.
- * Standard handle holes must be drilled on the reinforcement.
- * 13630 Sliding Embedded Handle 5 mm, should be used each passive sash in the system.
- * 13630 Sliding Embedded Handle 5 mm, is used for close sash to outside in double rail applications.



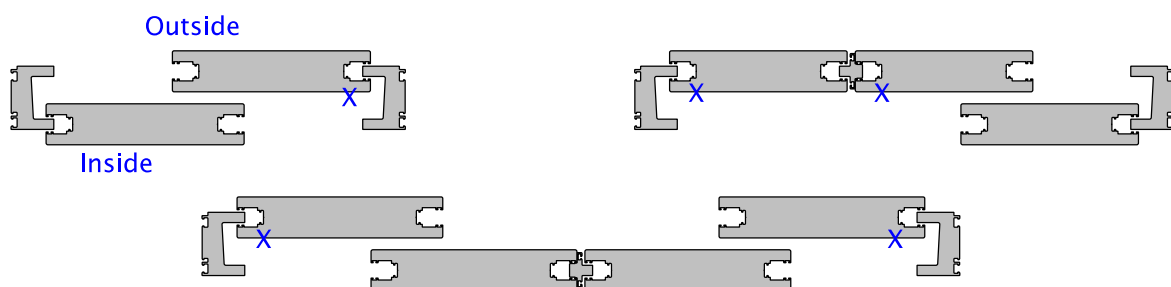
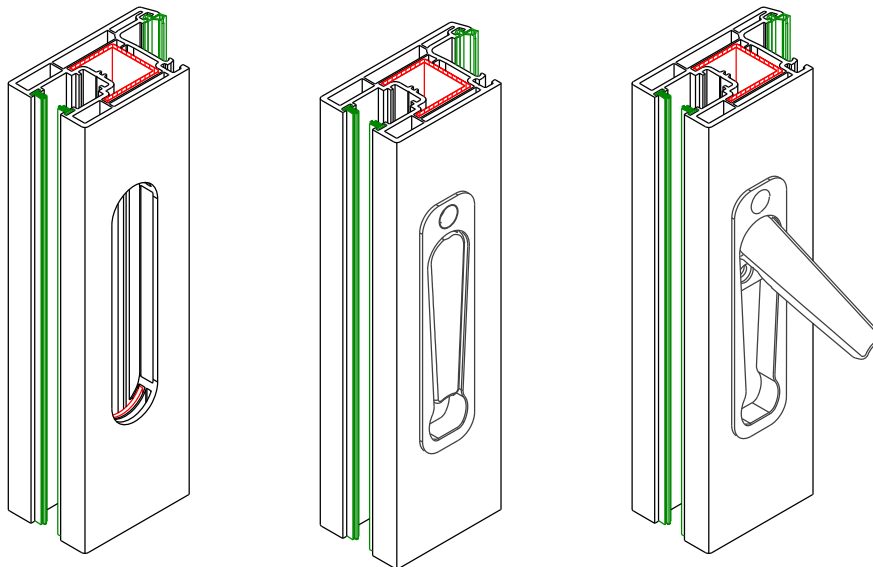
Note: X label indicates where the sliding embedded handle can be used



13190



- * Sliding handle(13190) can be used in both sash profiles (12670/12671),
- * This handle must be used on the outside sash that is sliding on external rail. It can also be used as an alternative handle for the internal rail.



Note: X label indicates where the sliding embedded handle can be used

To achieve best welding results, please observe the following :

1. The temperature of profile must be $> 15^{\circ}\text{C}$. (Store at room temperature of at least 15°C)
2. The cutting angle variation must not exceed 0.5°
3. The welding surface must be free of dirty, grease hand sweat, material chips, moisture and protective foils.
4. The welding parameter must be adjusted according to the following criteria.




4.1. Welding plate

Welding Plate Temperature $240^{\circ}\text{--}250^{\circ}\text{C}$,  \rightarrow verification with measuring device on welding plate

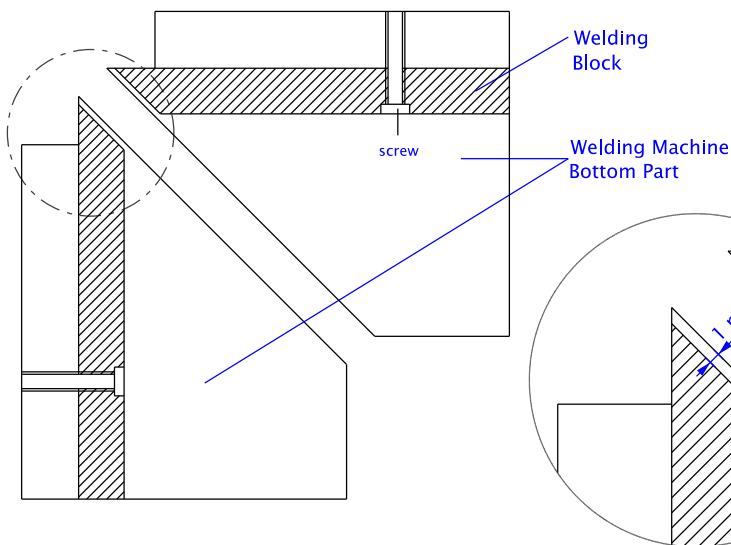
4.2 Welding times

- Heating time – a minimum of 15 seconds
- Change-over time as short as possible, maximum of 2 seconds
- Cooling time – a minimum of 30 seconds
- No accelerated cooling (by the use of compressed air)

4.3 Welding pressure:

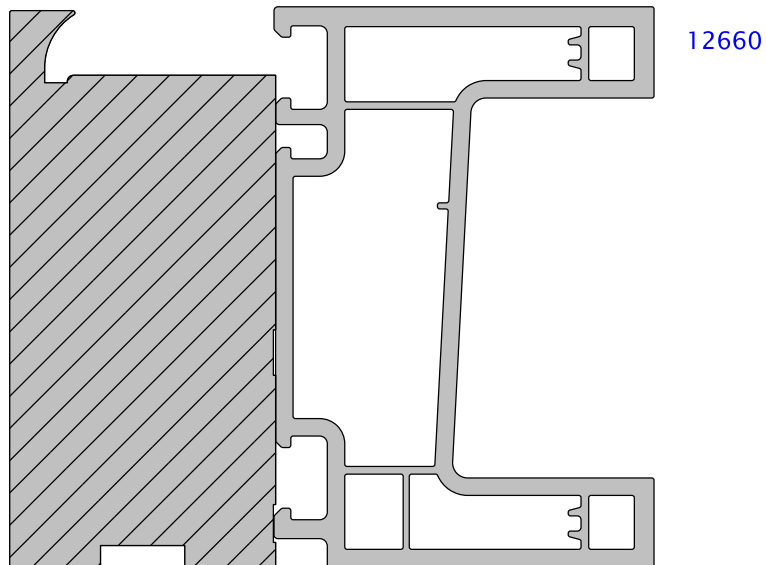
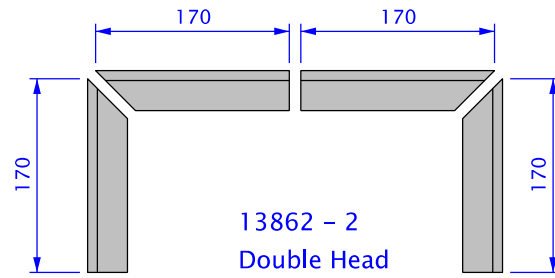
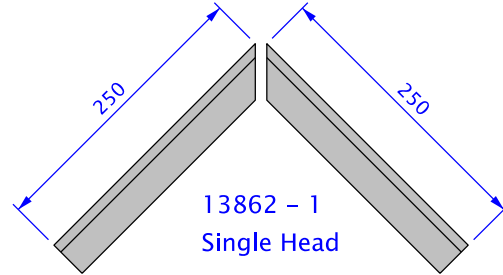
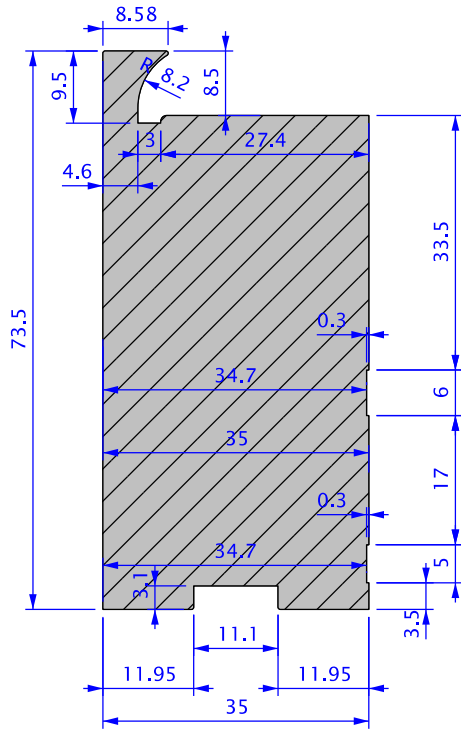
- Clamping pressure 6 bar 
- Adjusting pressure 2.5–3 bar 
- Welding pressure 6 bar 

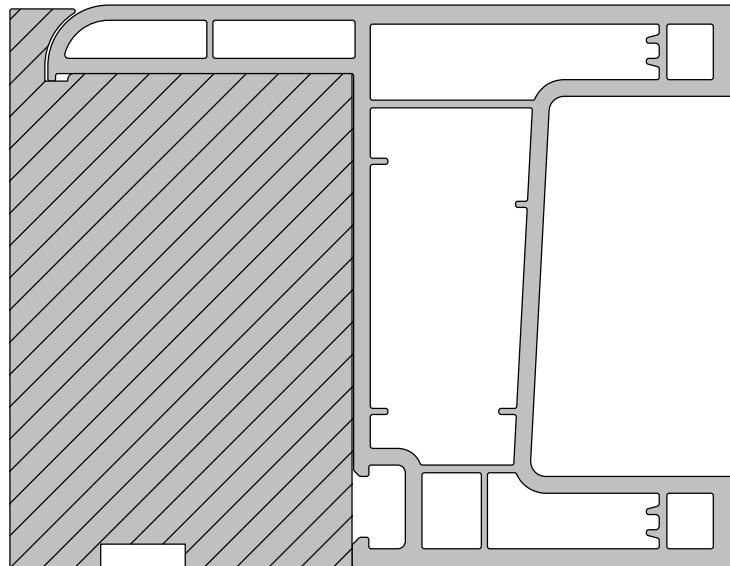
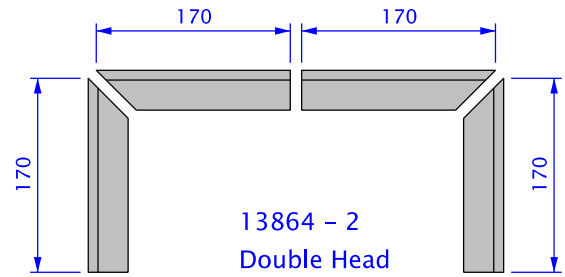
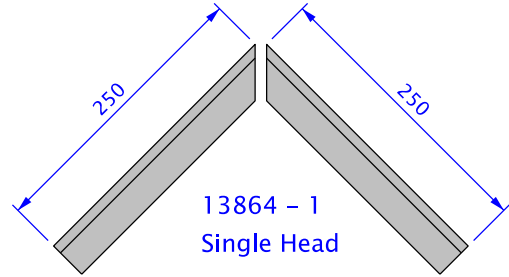
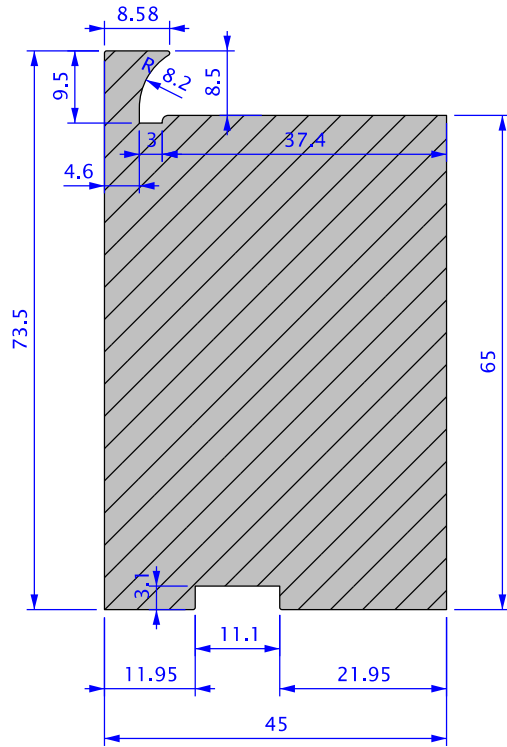
5. The welding support blocks must be used,



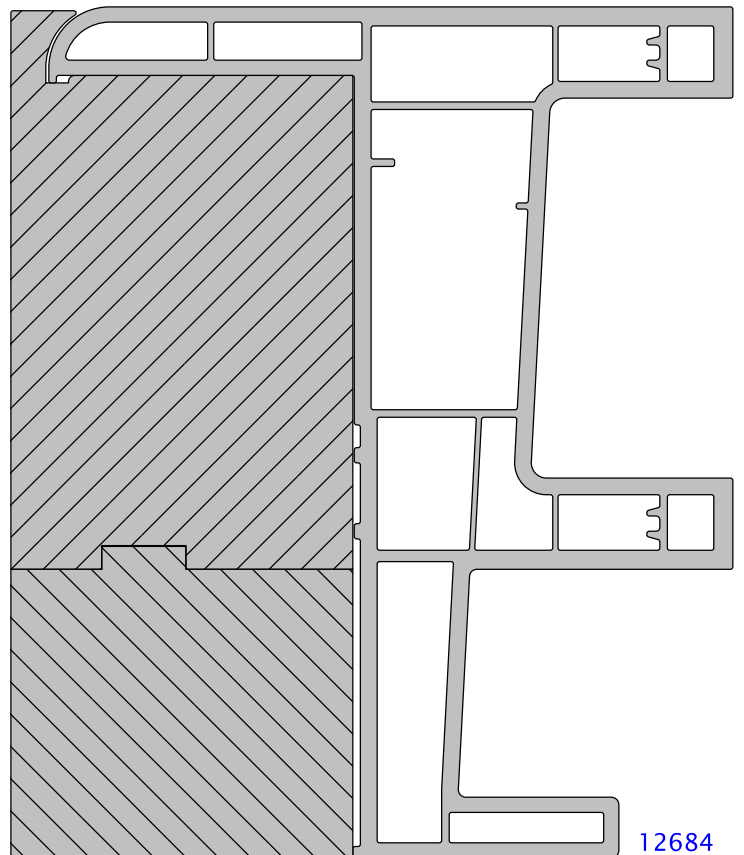
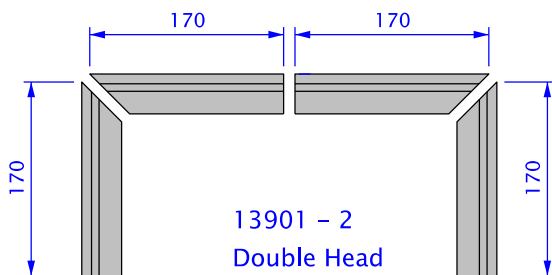
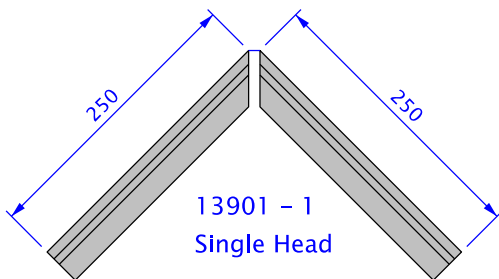
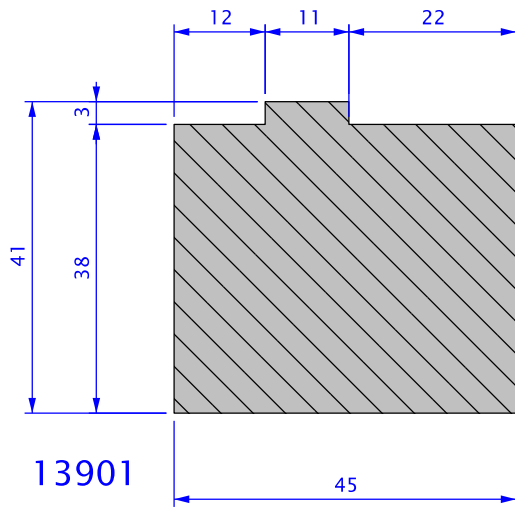
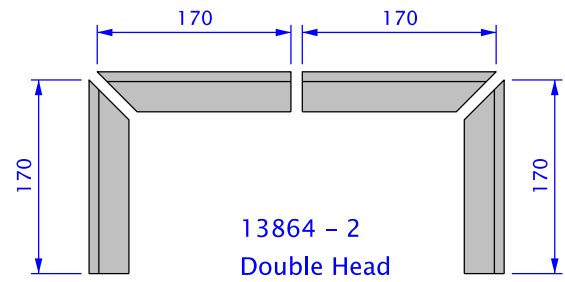
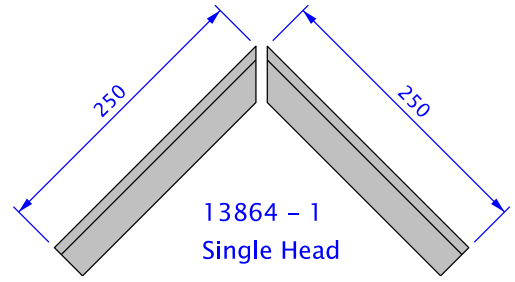
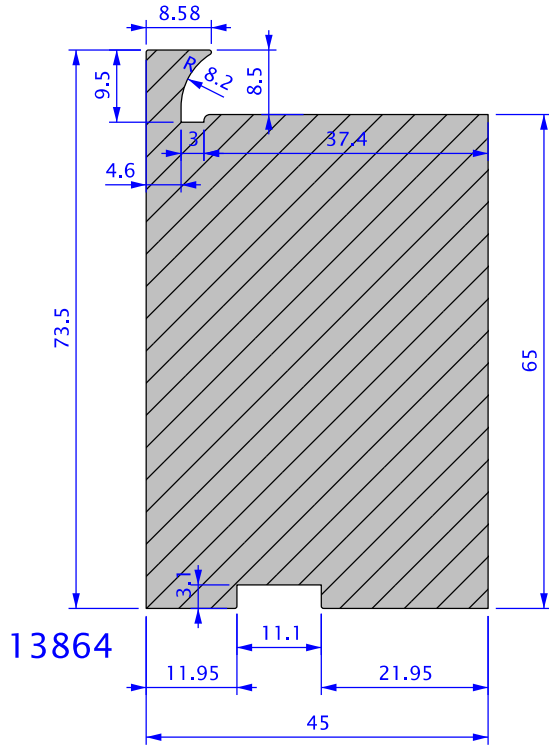
Important !
Welding support blocks must be fixed with 1 mm distance

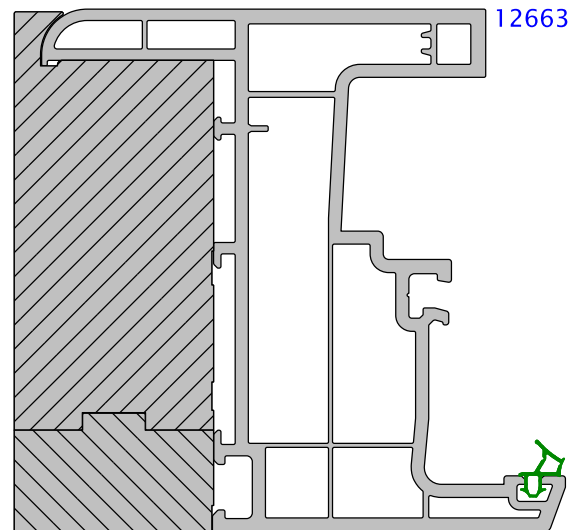
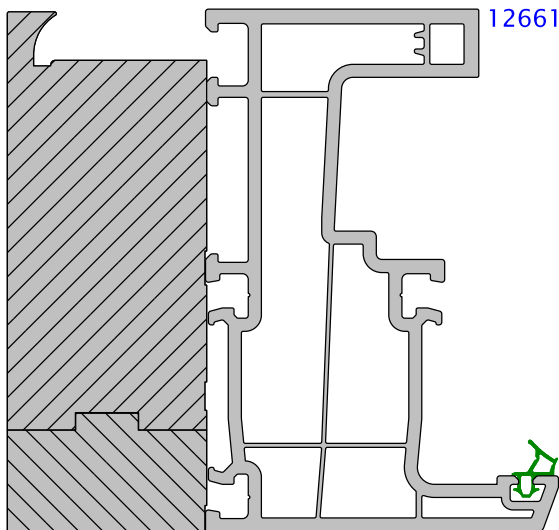
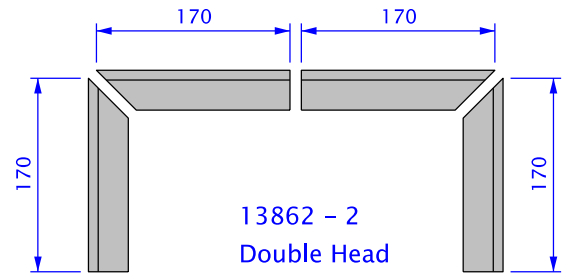
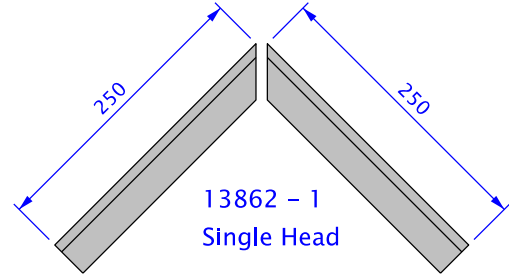
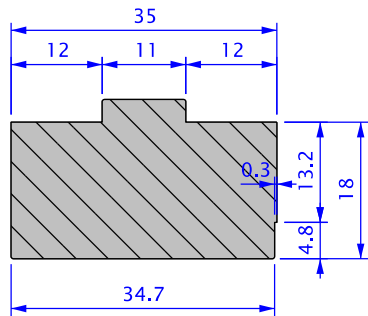
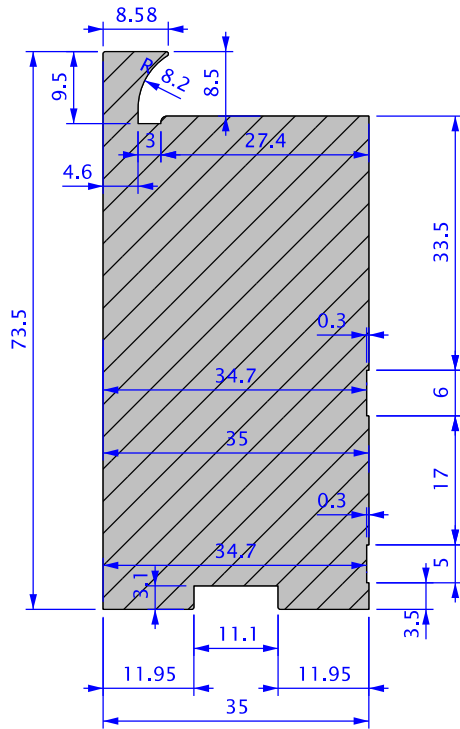
6. Top and bottom pieces of welding support blocks must be parallel to each other
7. Welding thickness must be 3 mm

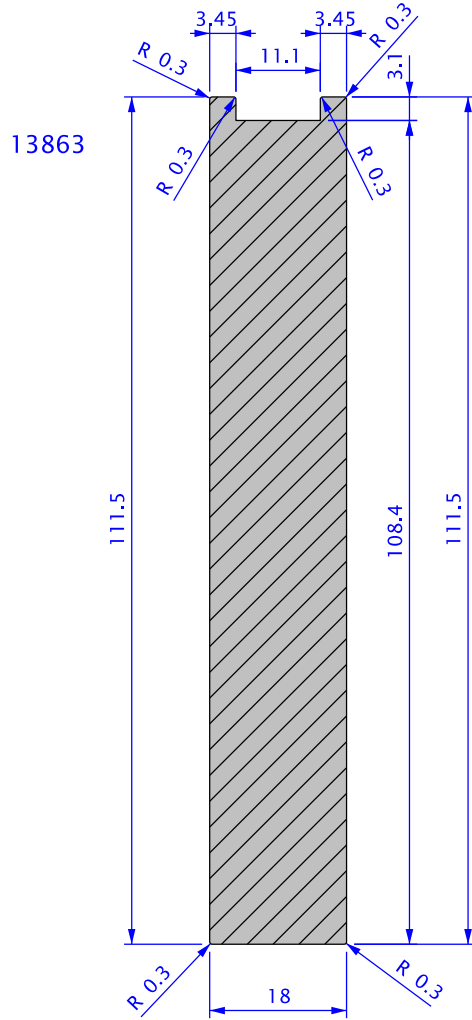




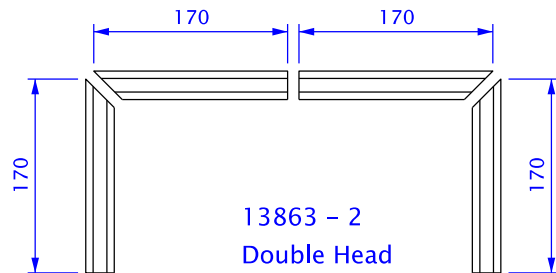
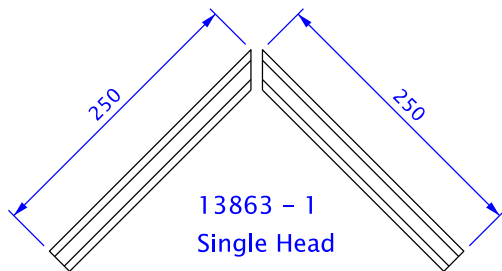
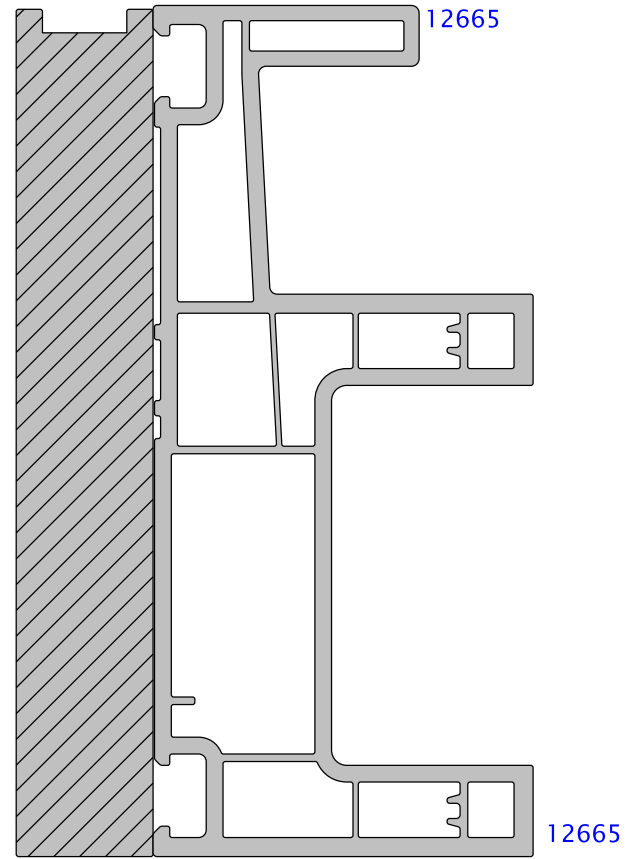
12662

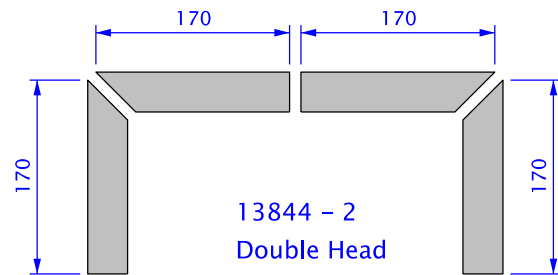
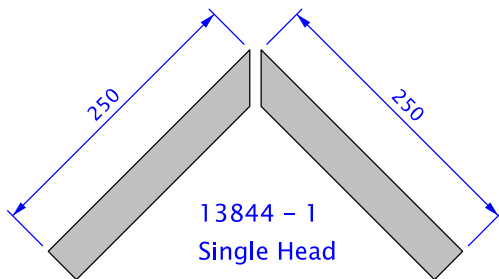
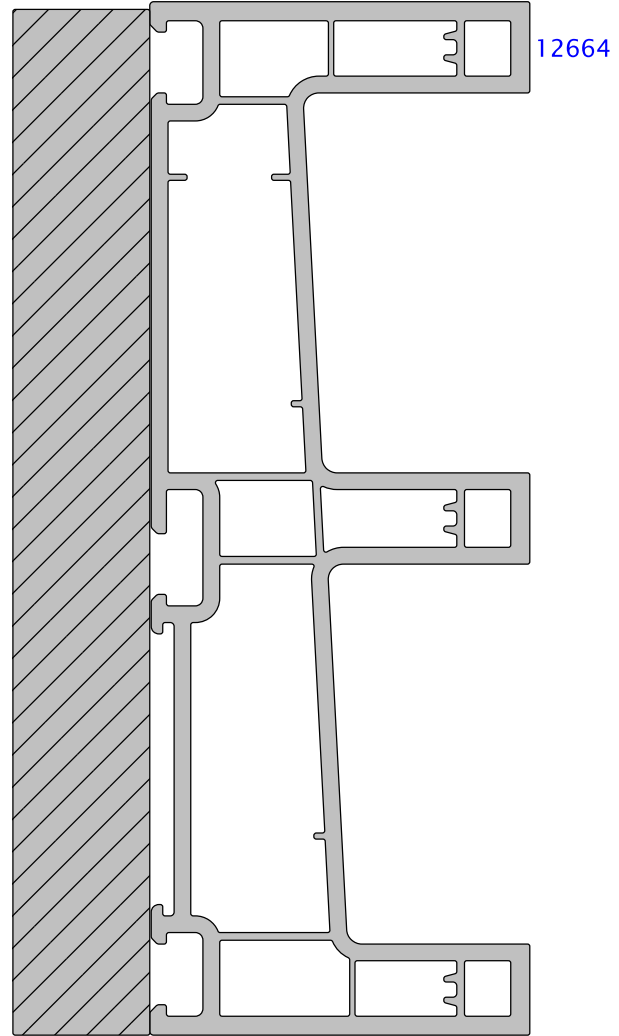
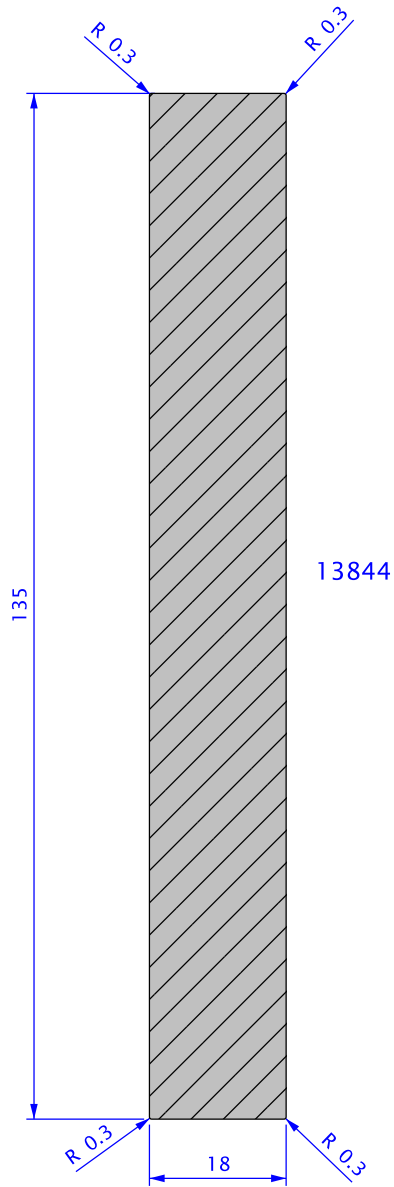


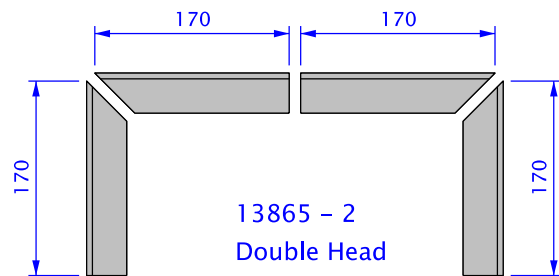
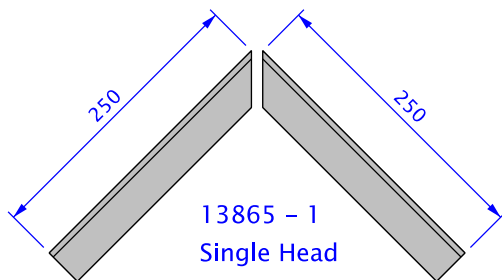
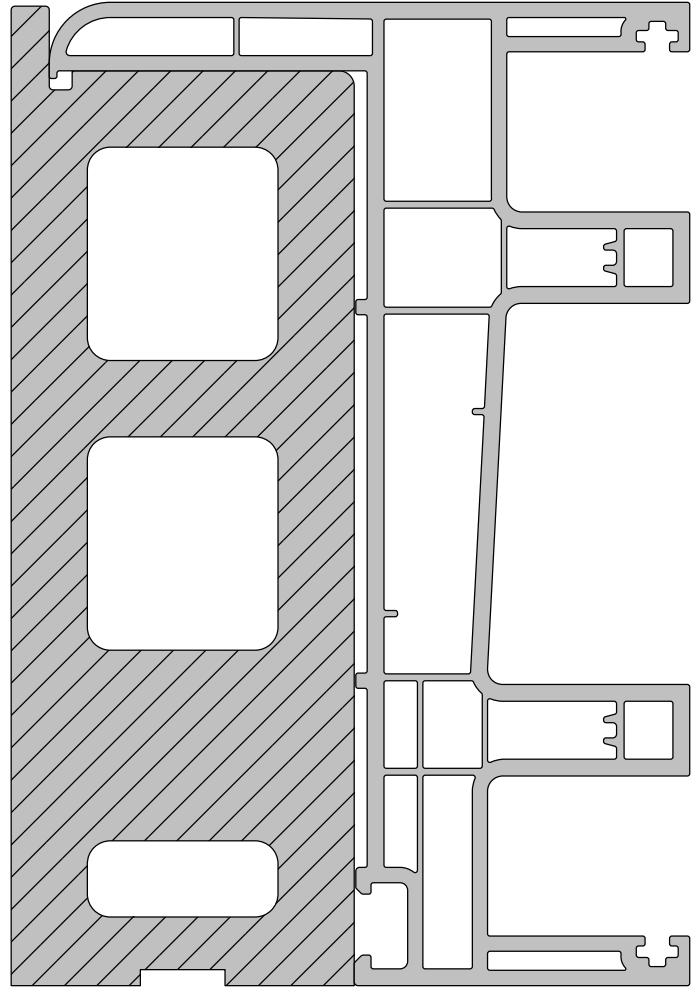
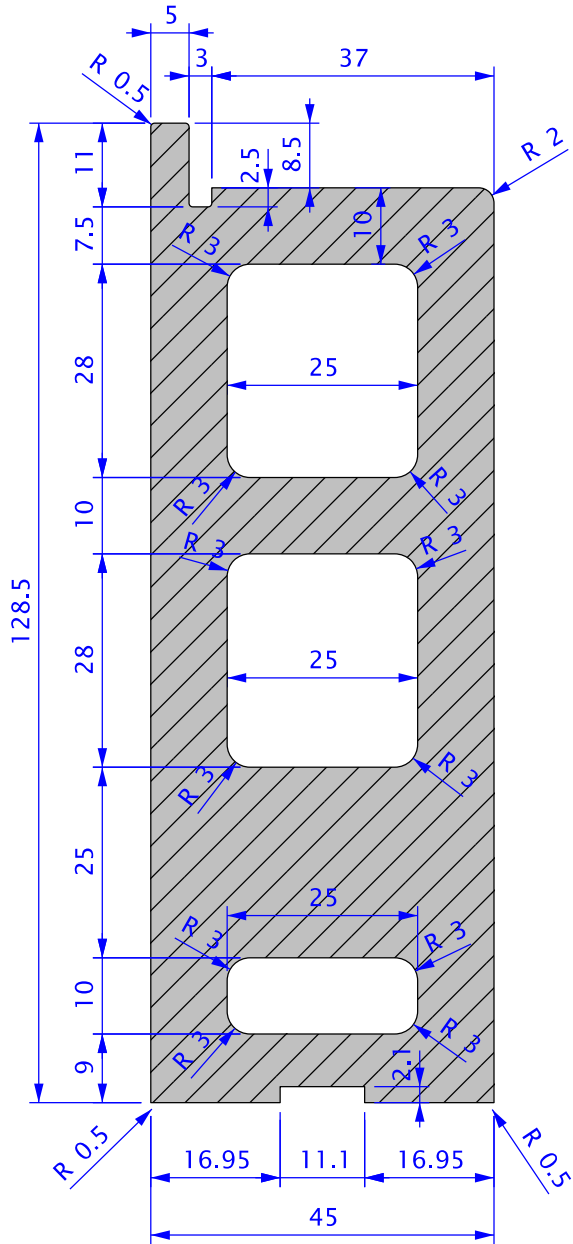


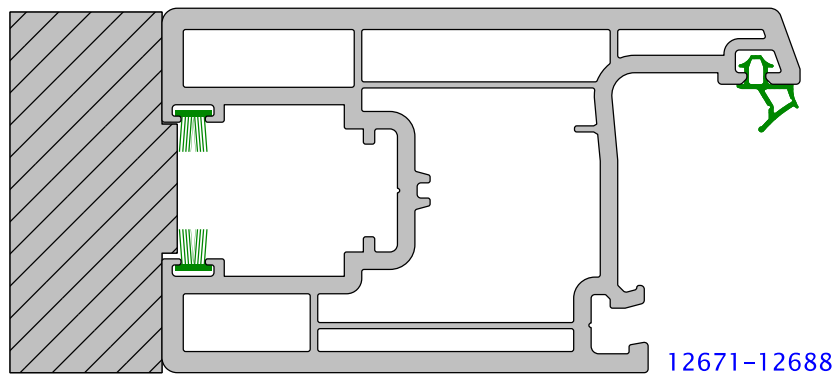
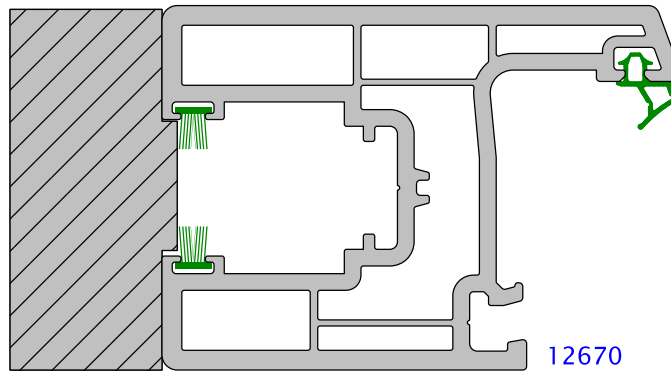
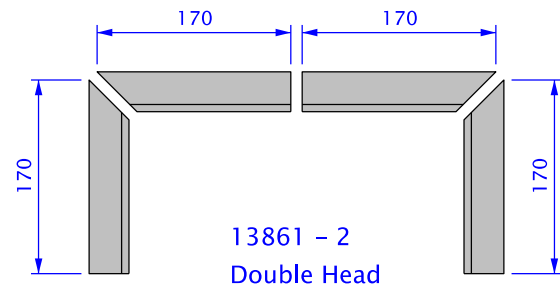
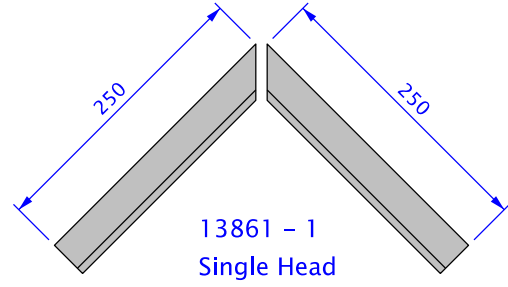
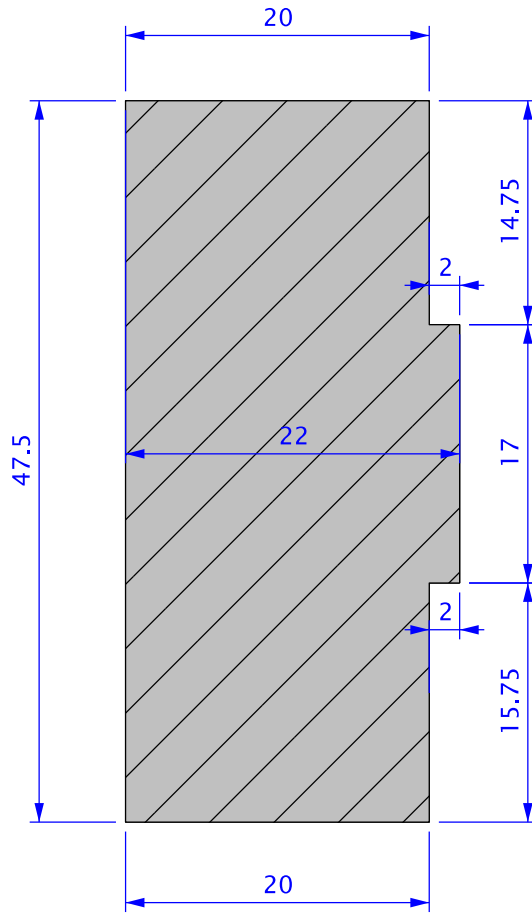


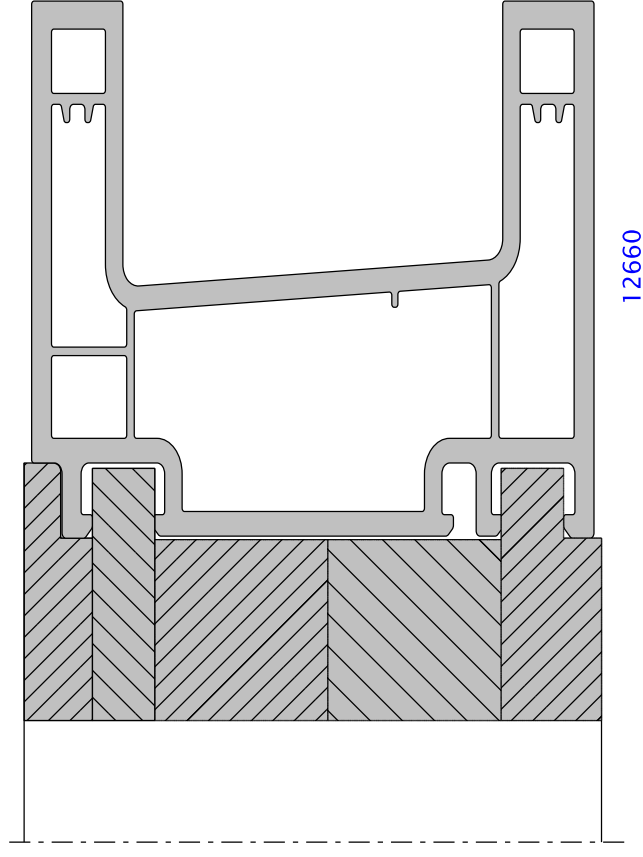
Welding
Blocks

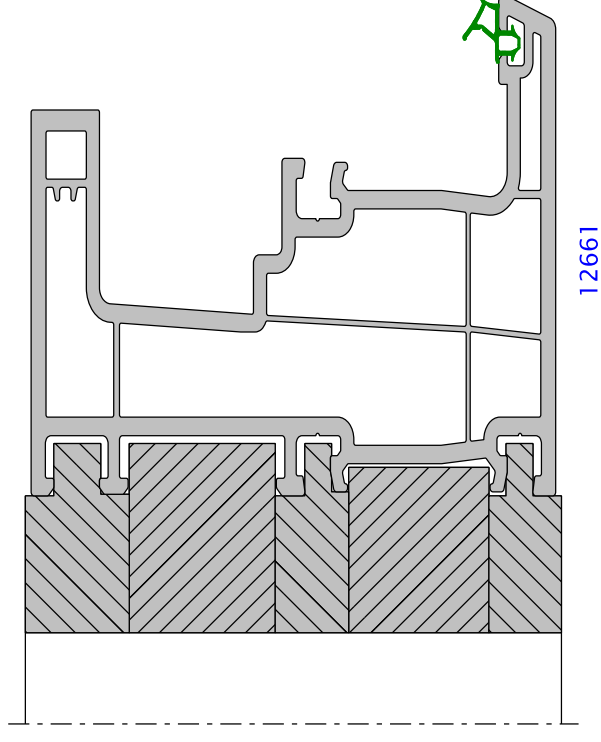
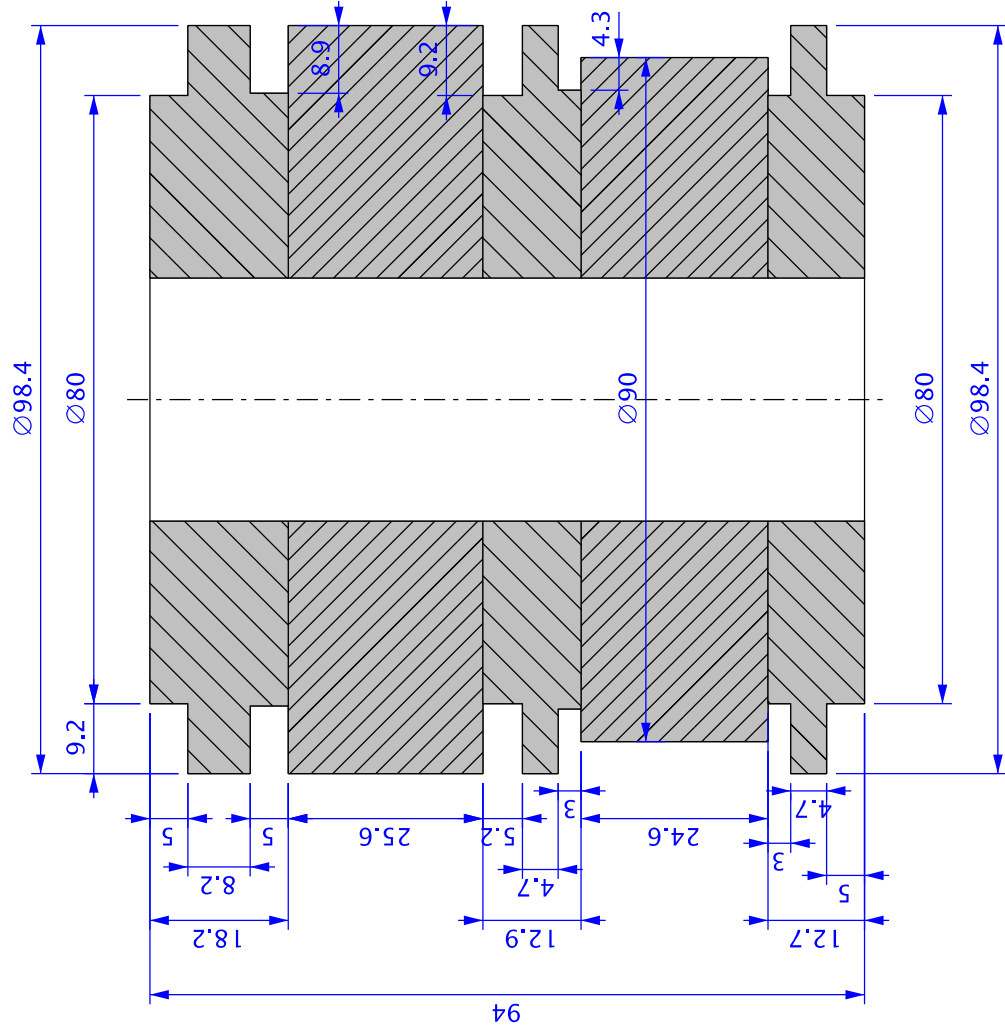


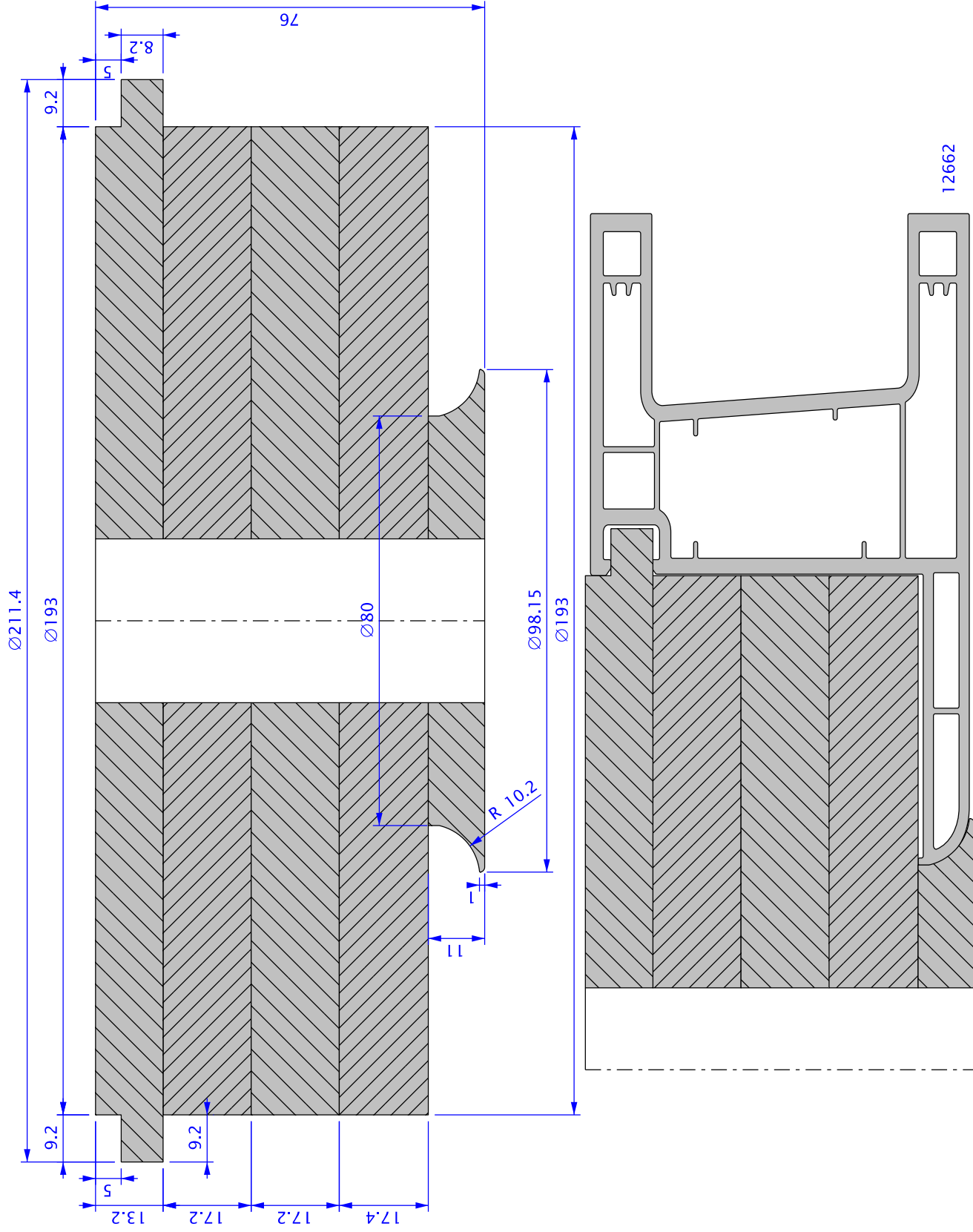


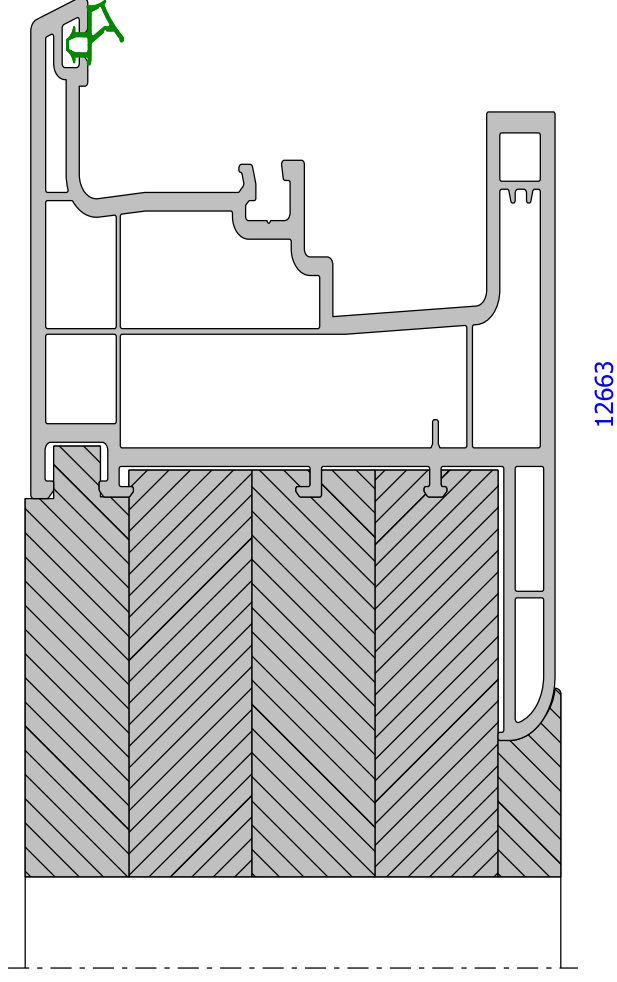
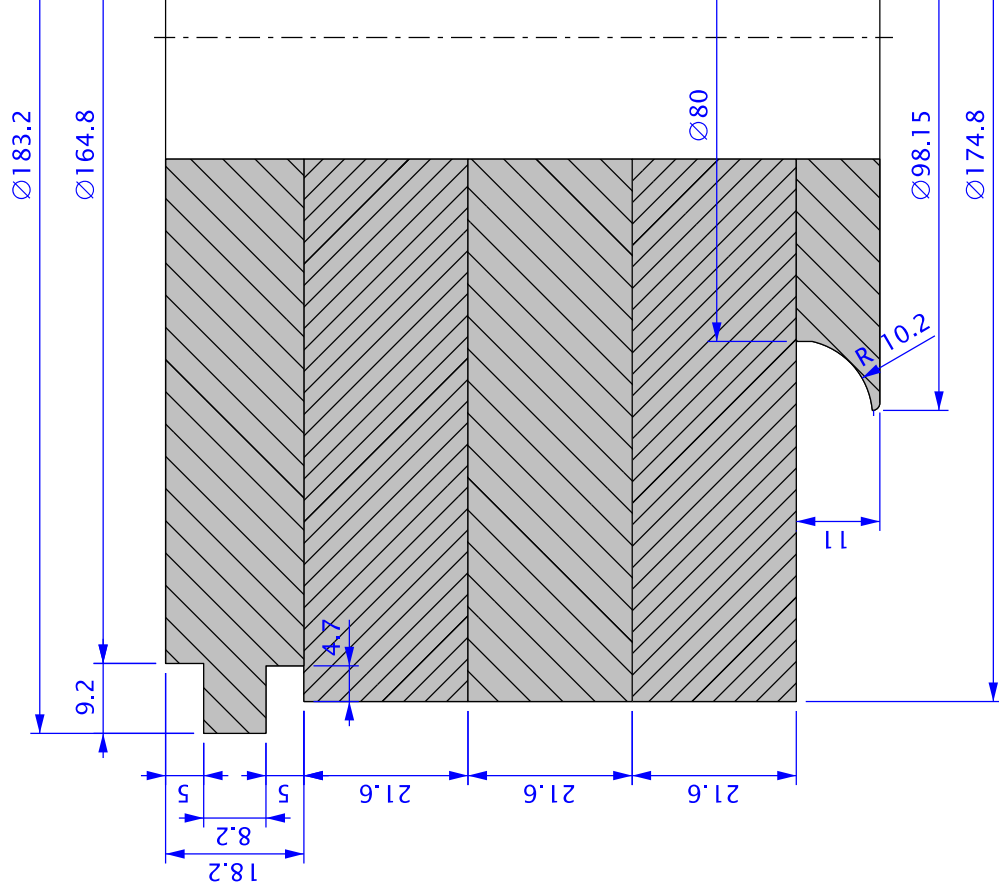


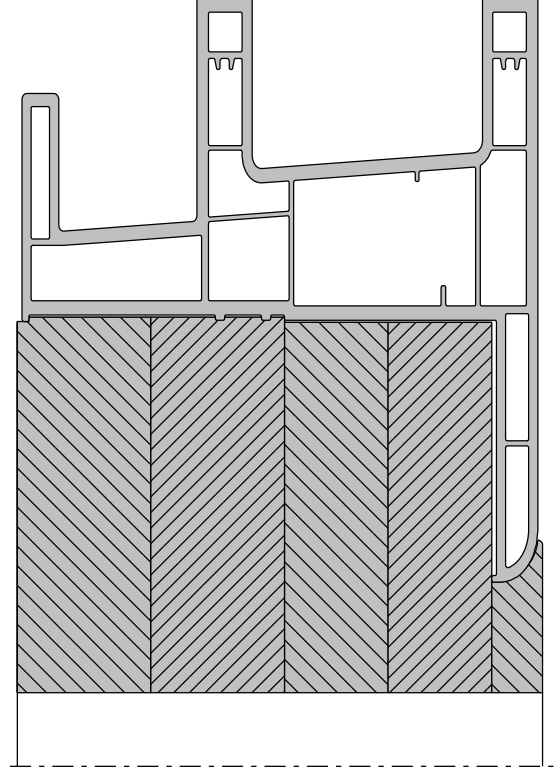


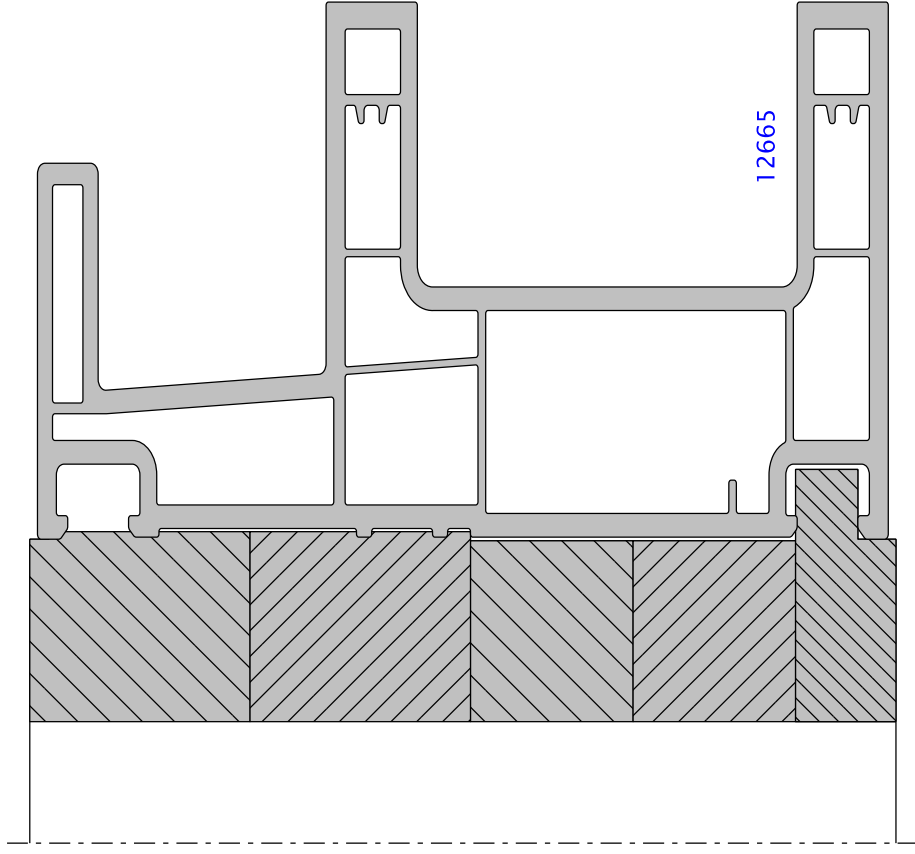
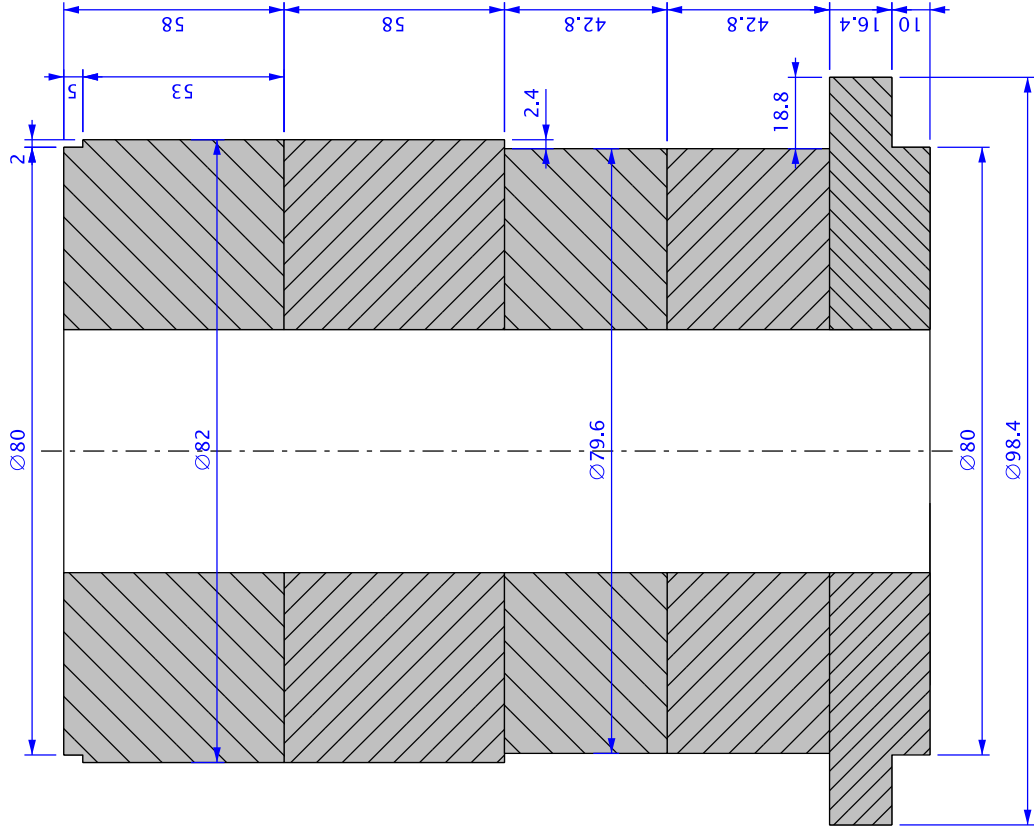


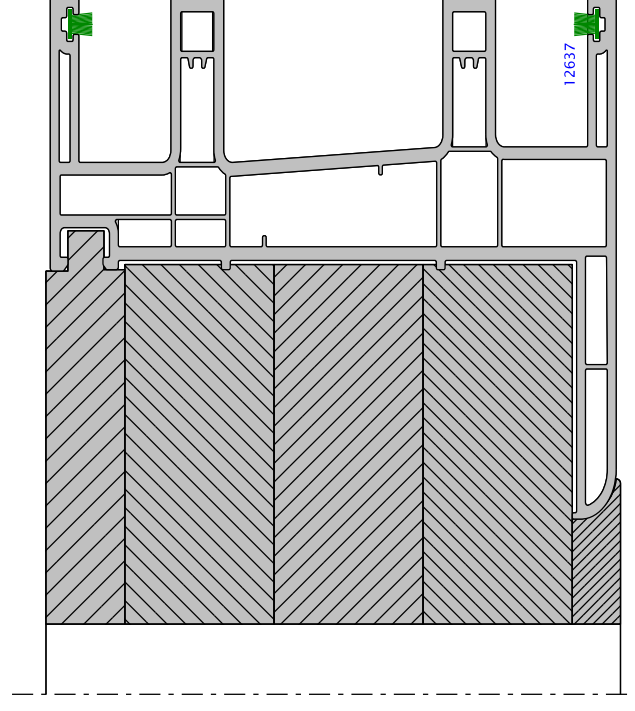


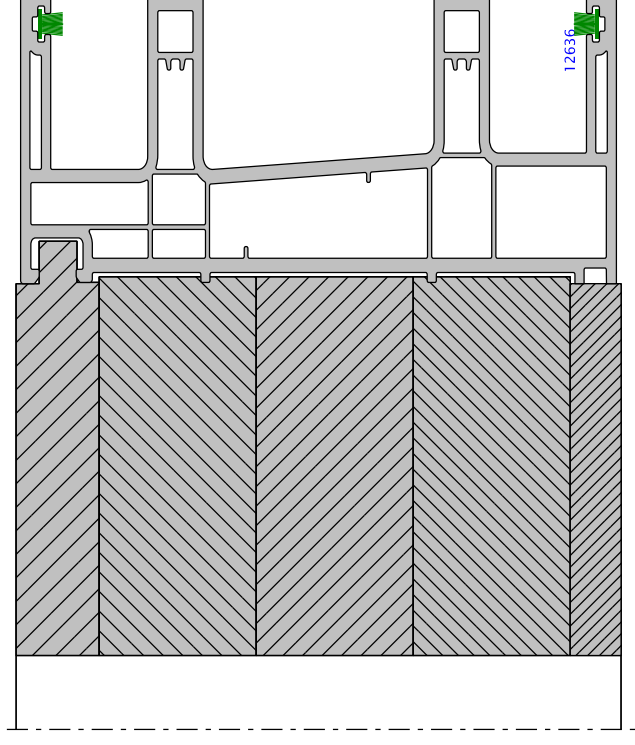


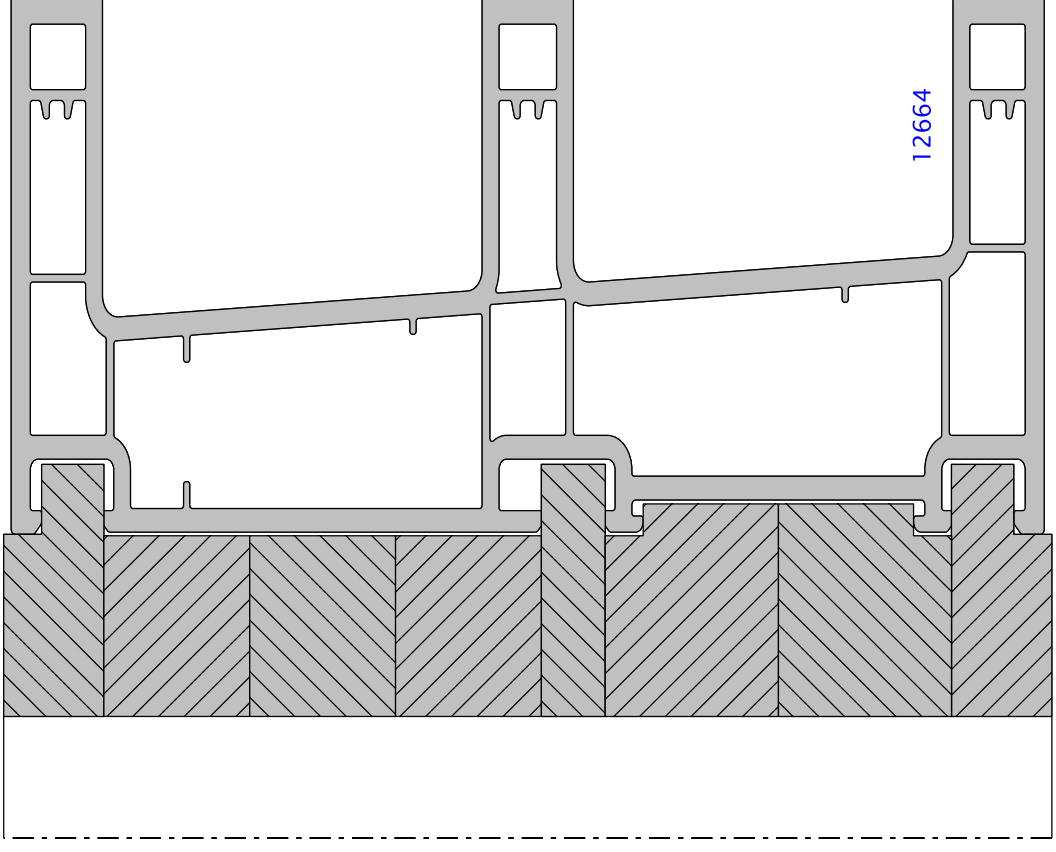
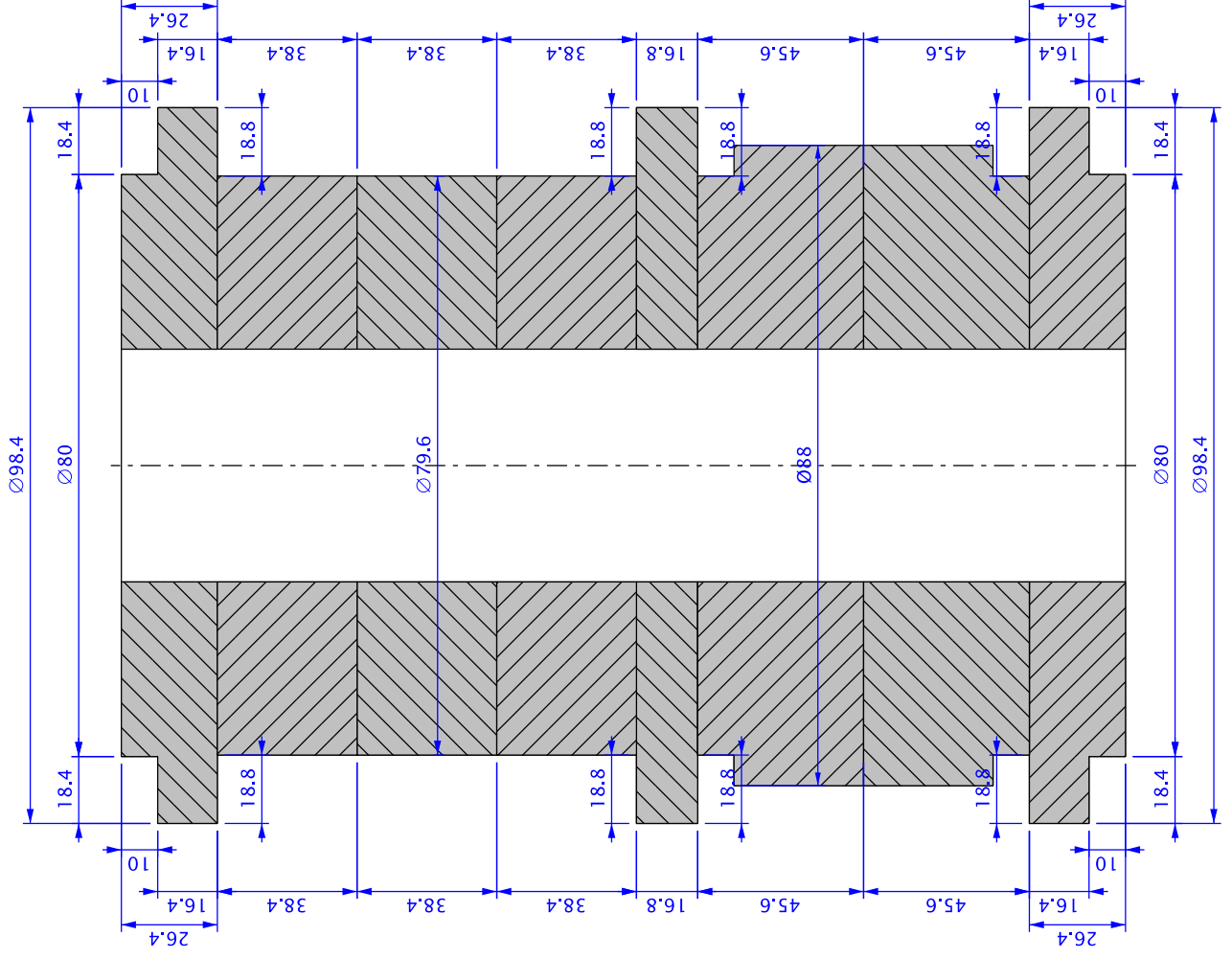










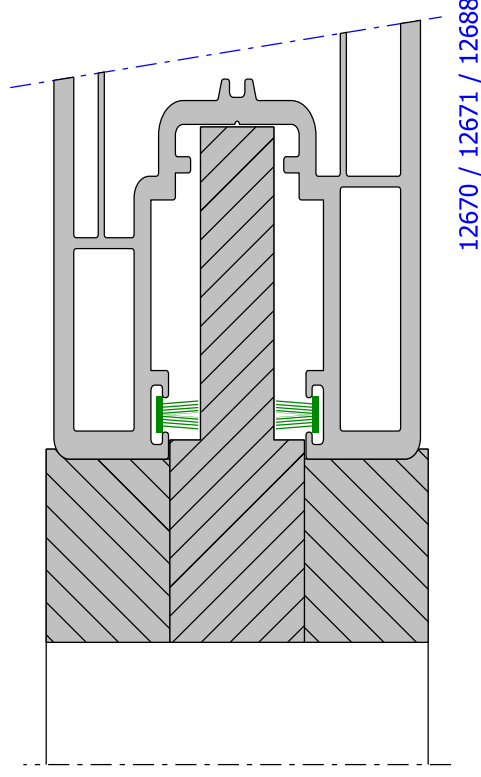
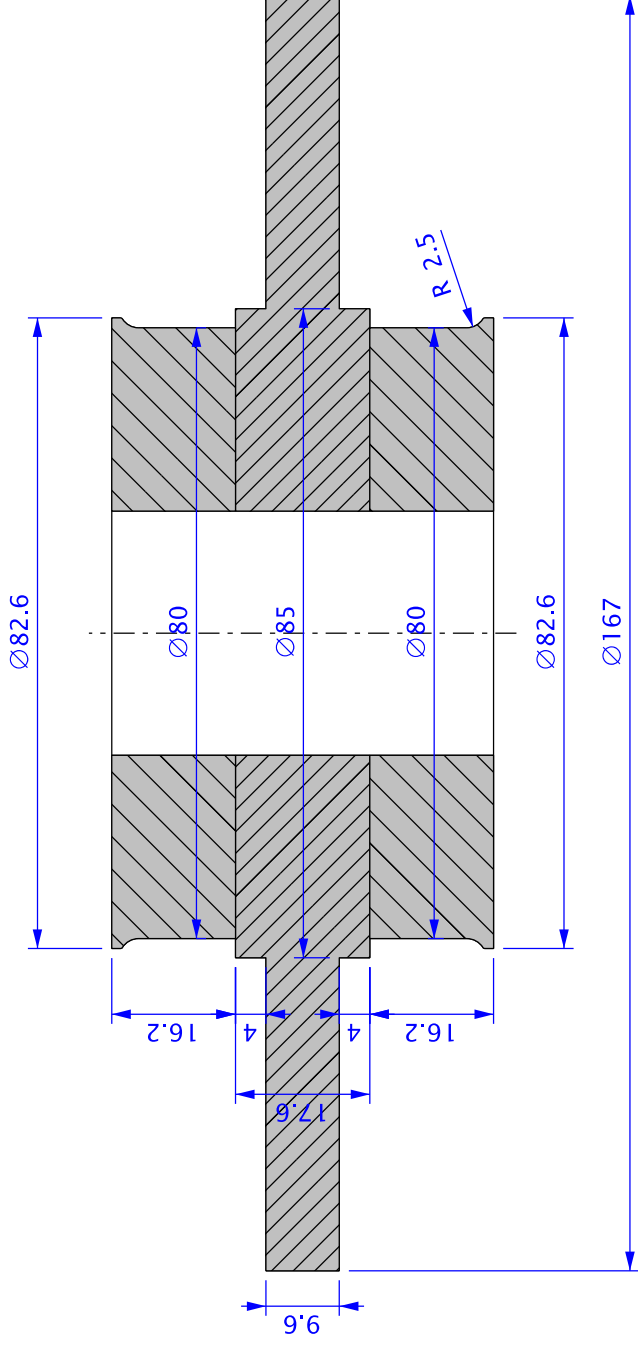




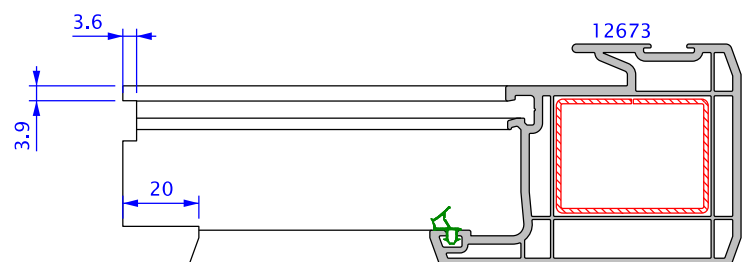
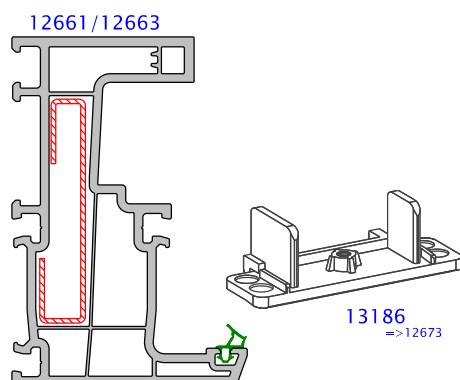
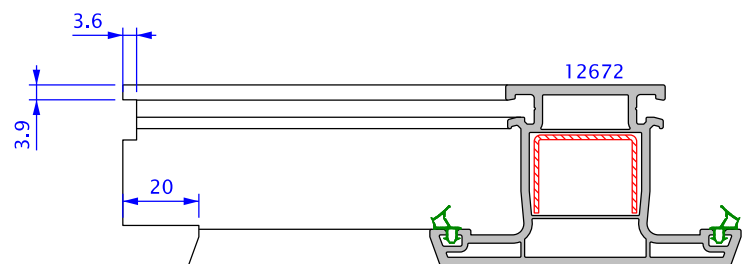
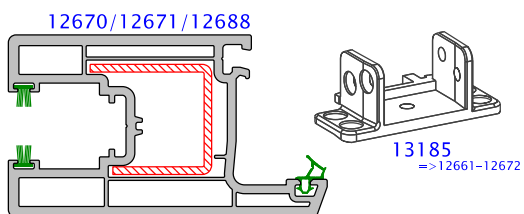
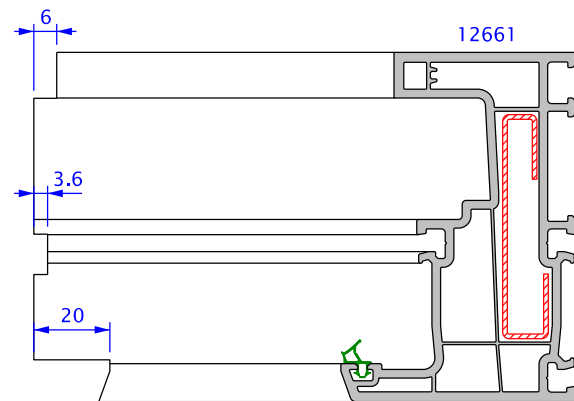
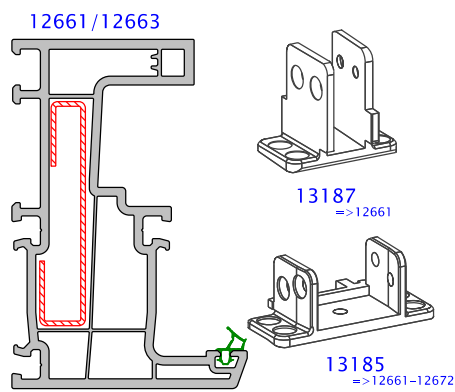
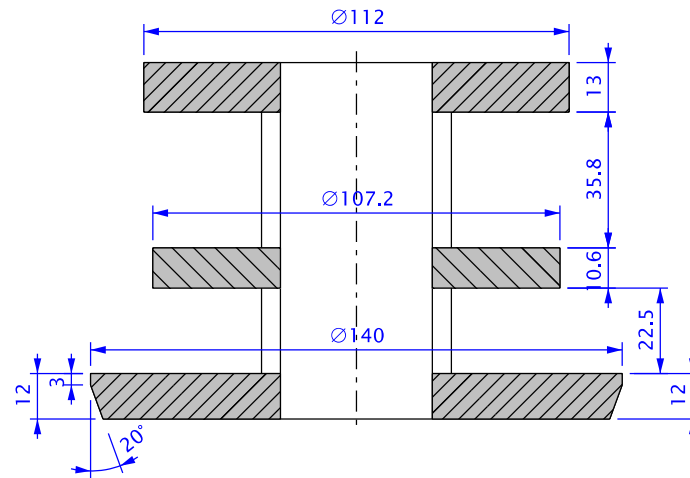
R-R İTHALAT İHRACAT
VE PAZARLAMA A.Ş.

WELDING&CORNER CLEANING

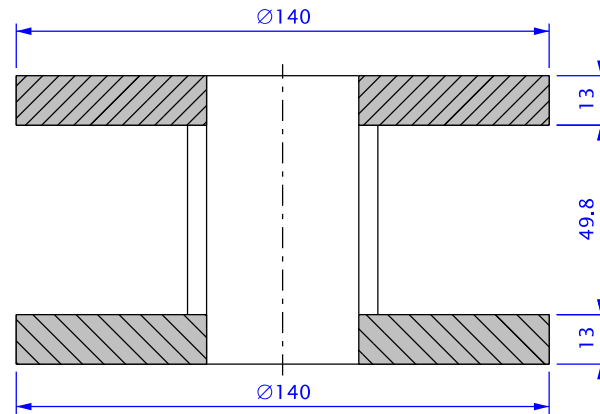
1 3794–Corner Cleaning for Sliding Sashes 12670/12671/12688



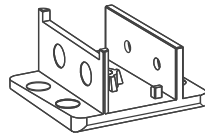
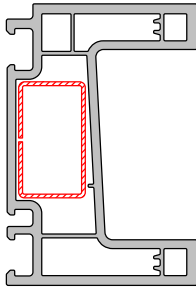
13795-End milling of sliding transom



13796-End milling sliding of frame transom

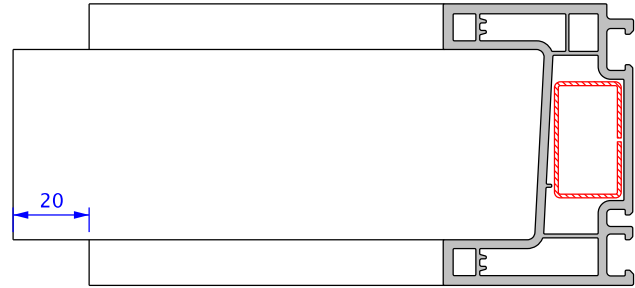


12660 - 12662 - 12665

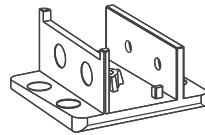
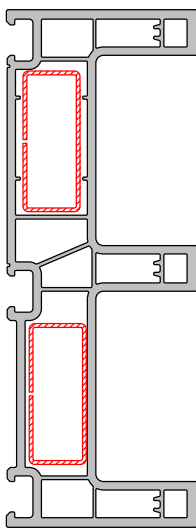


13188
=> 12660

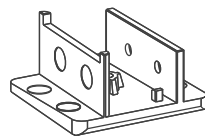
12660



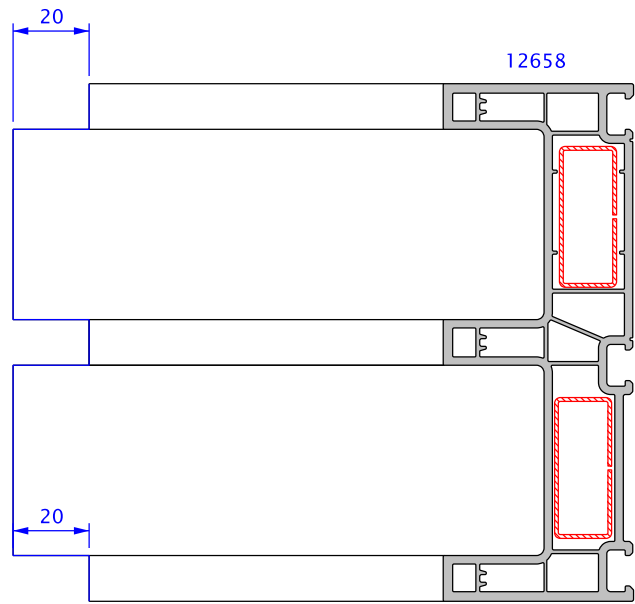
12658



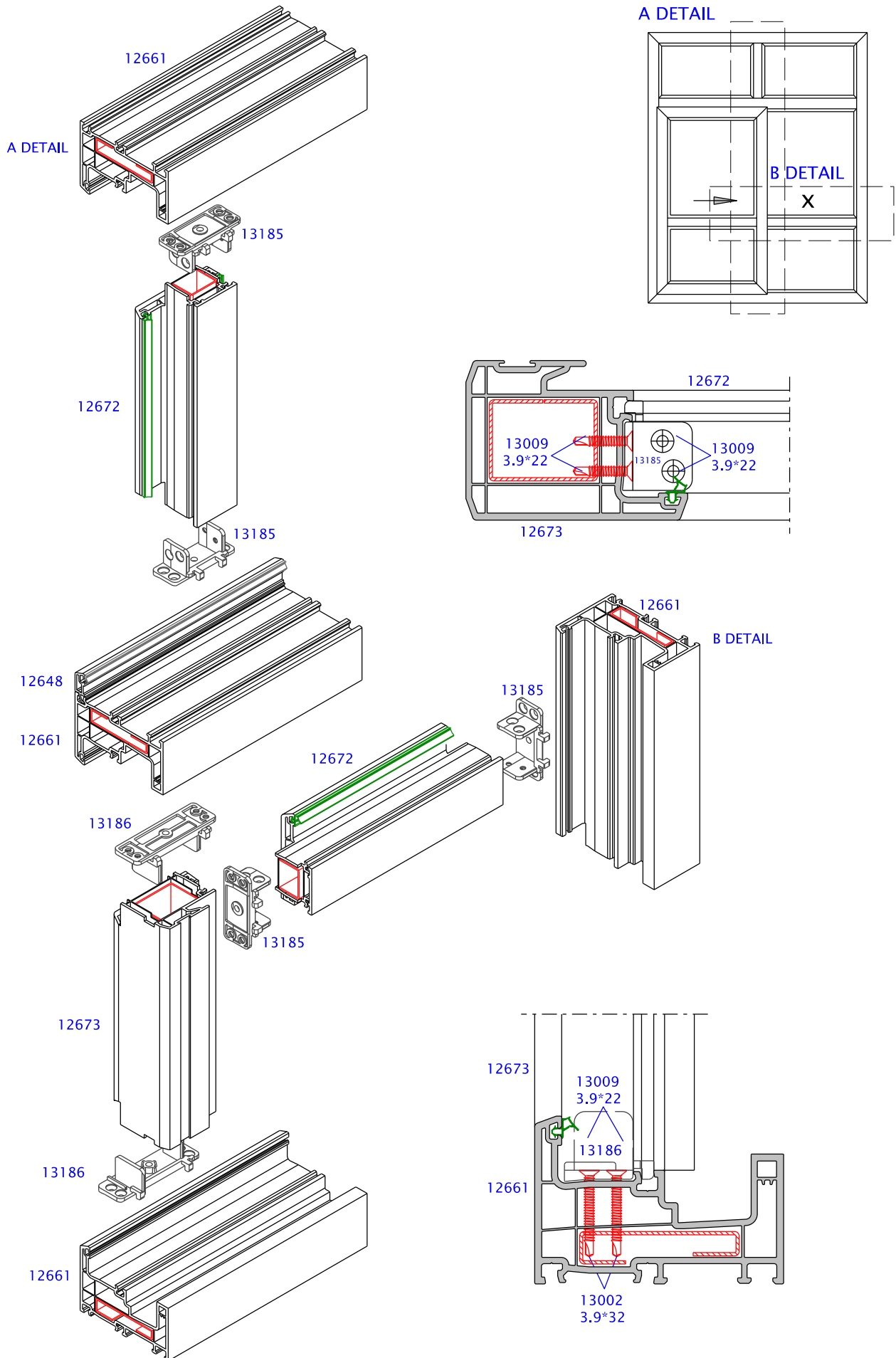
13188
=> 12660

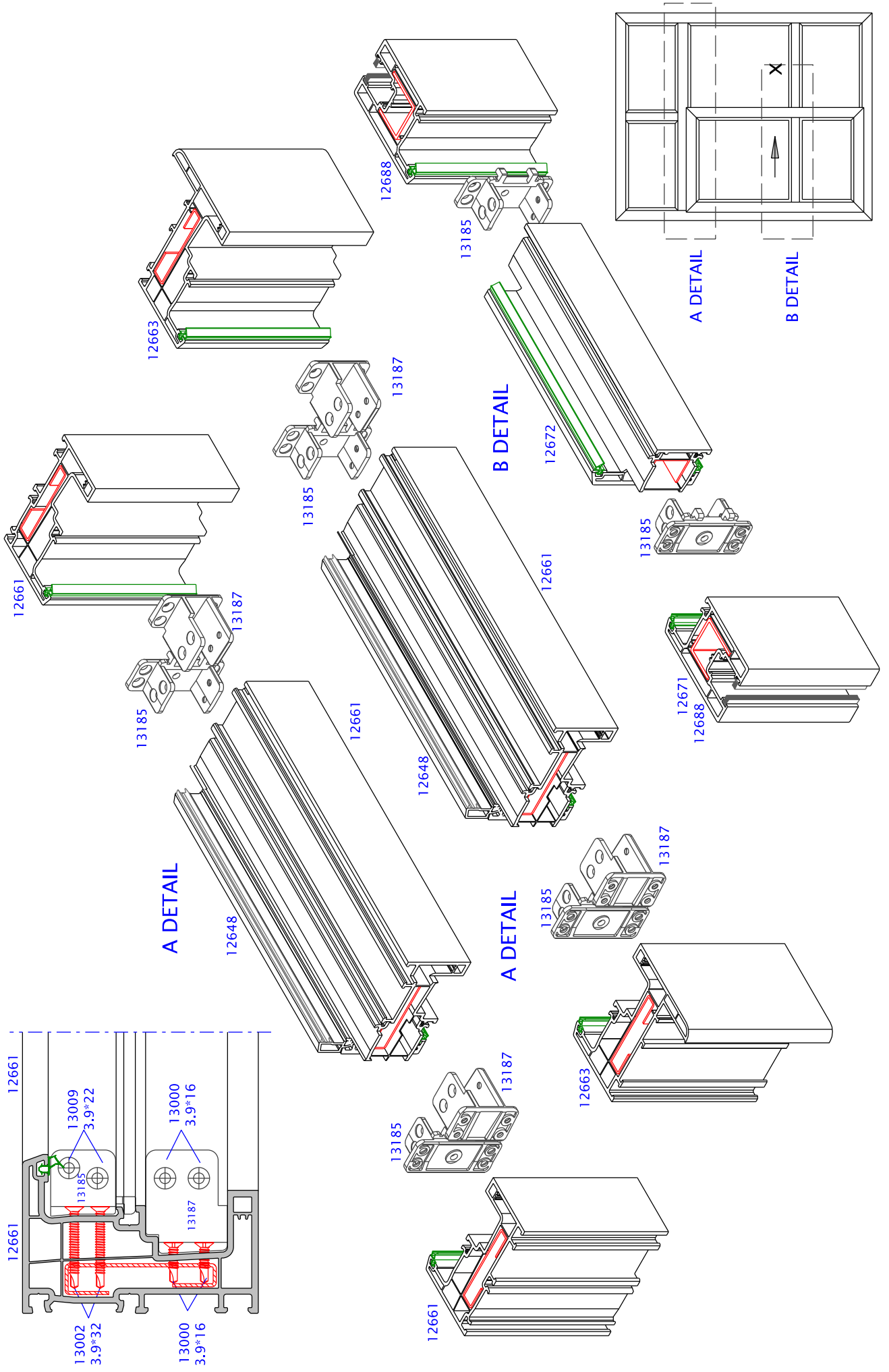


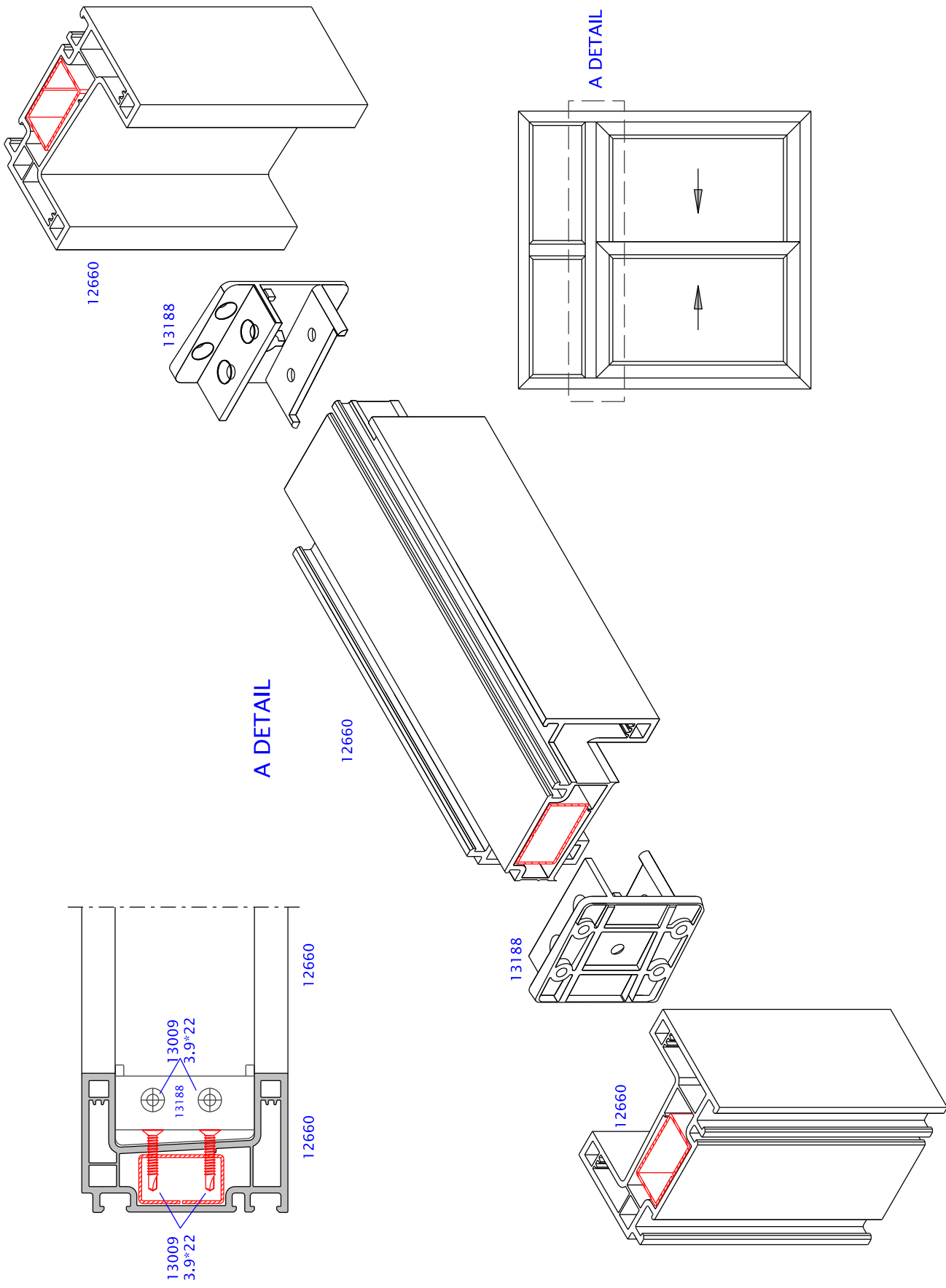
12658

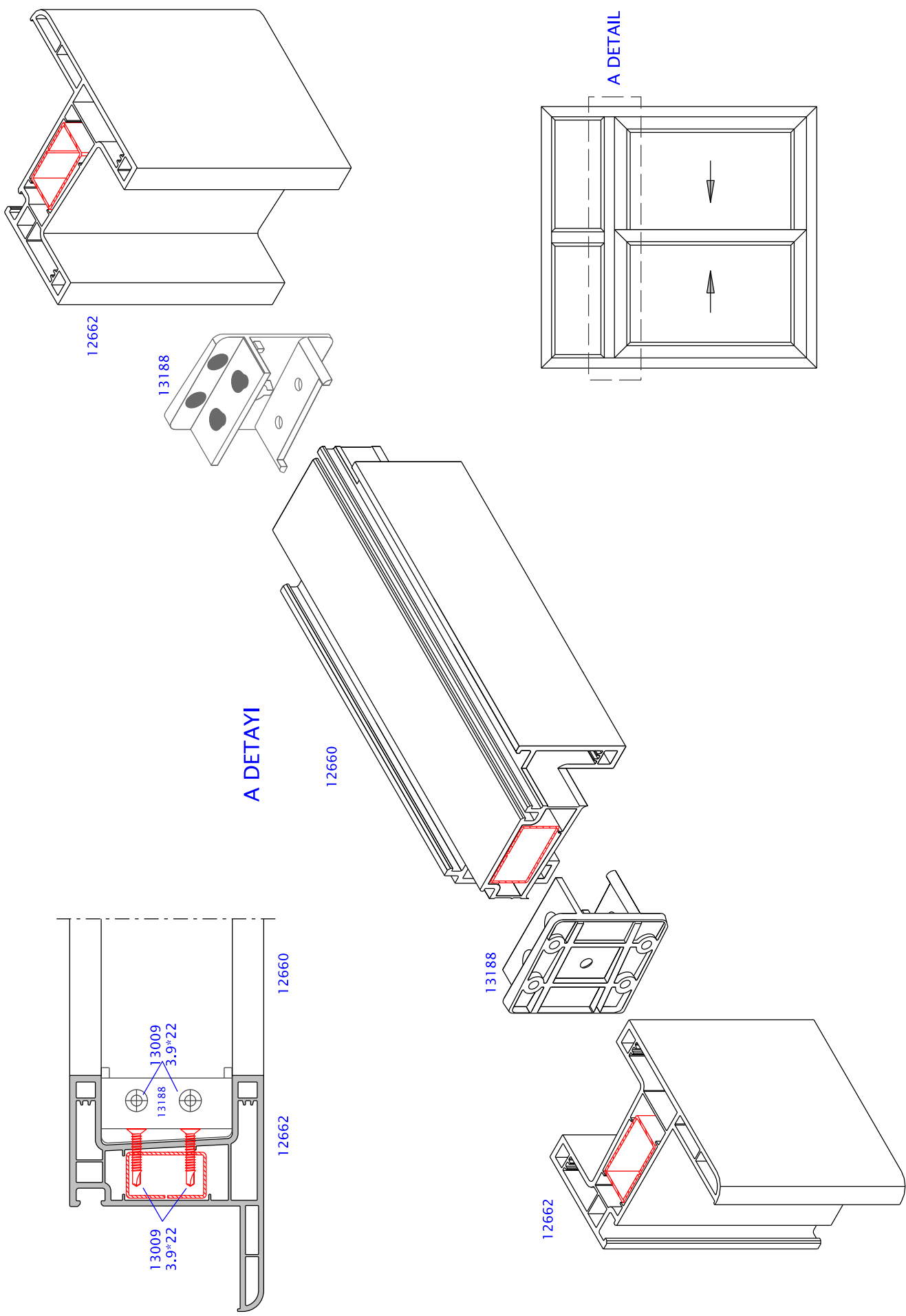


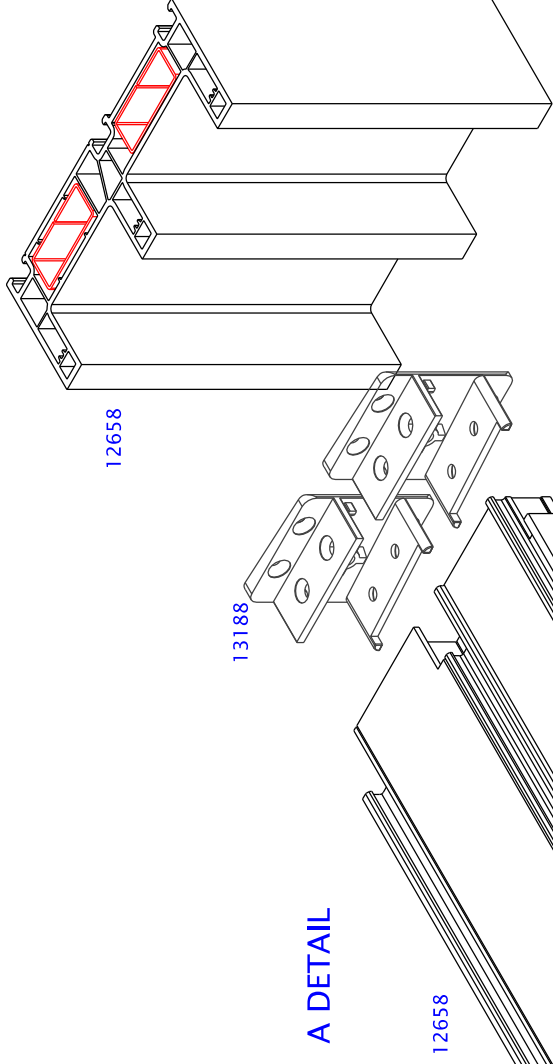
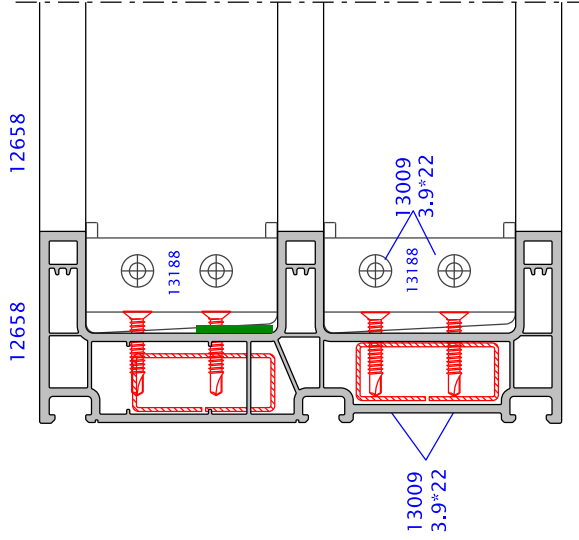
Ps: In the case of transom application of sliding 3 tracks frame, profile should be upside down on the plate.



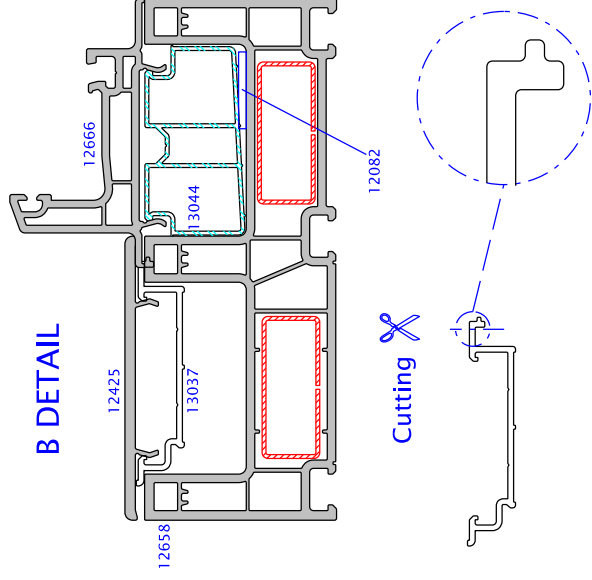






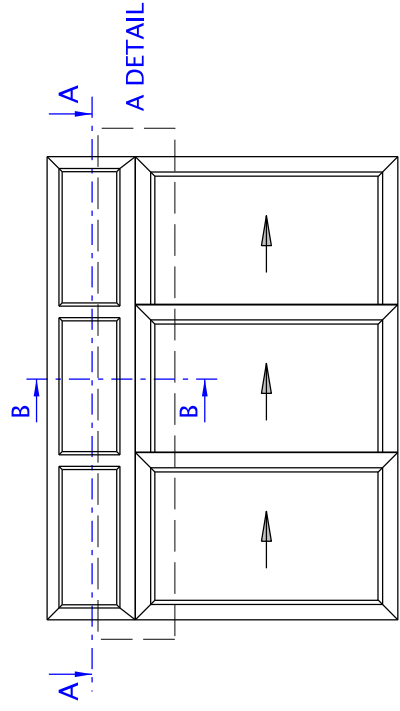


A DETAIL

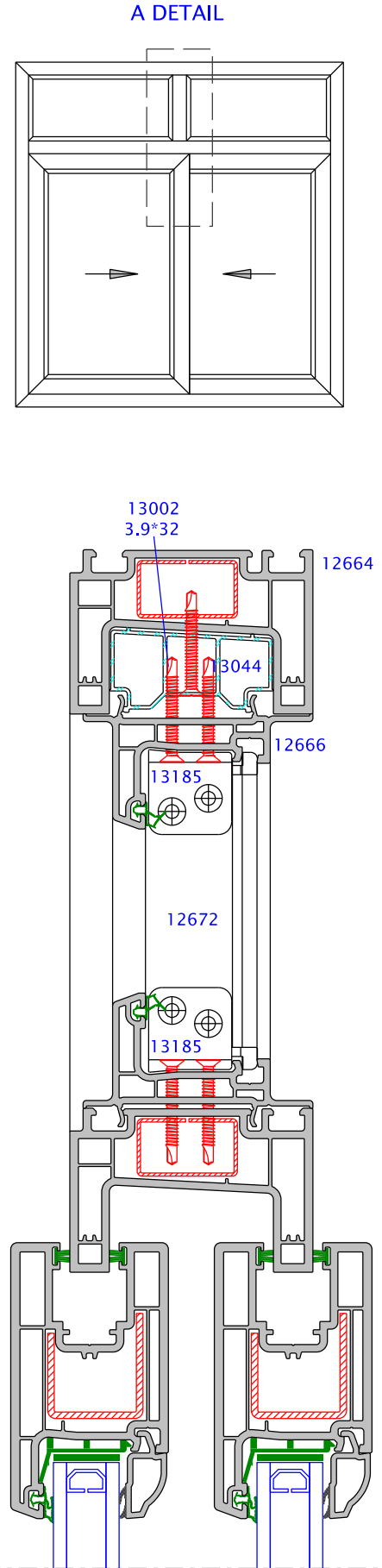
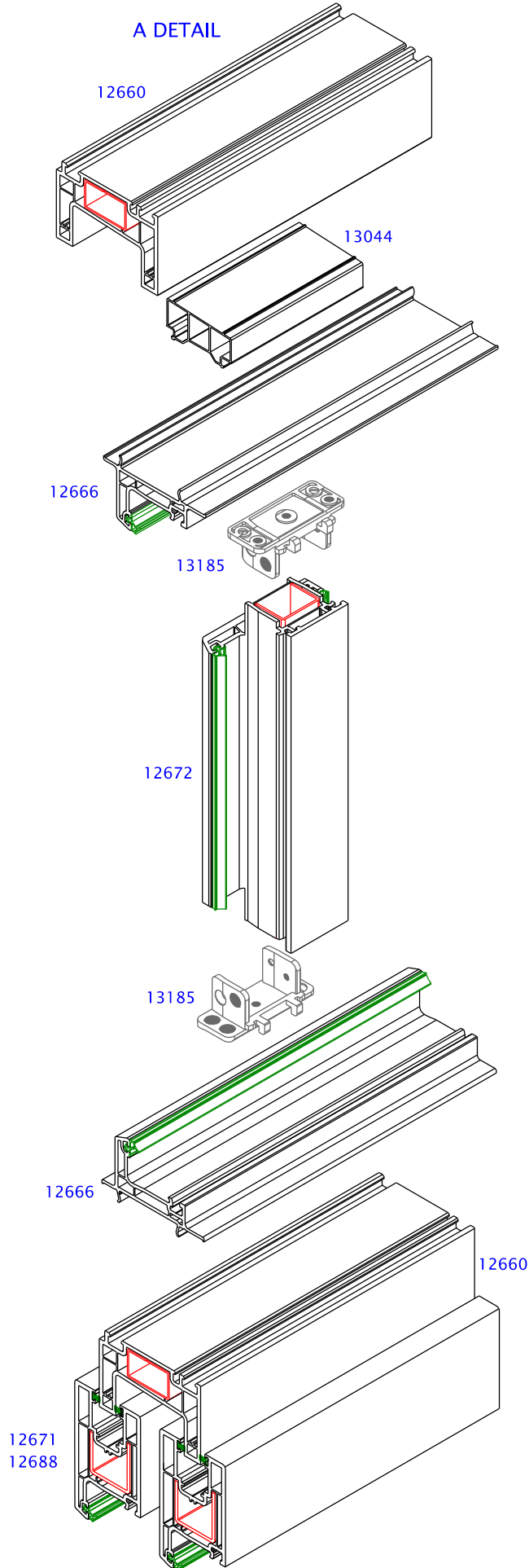


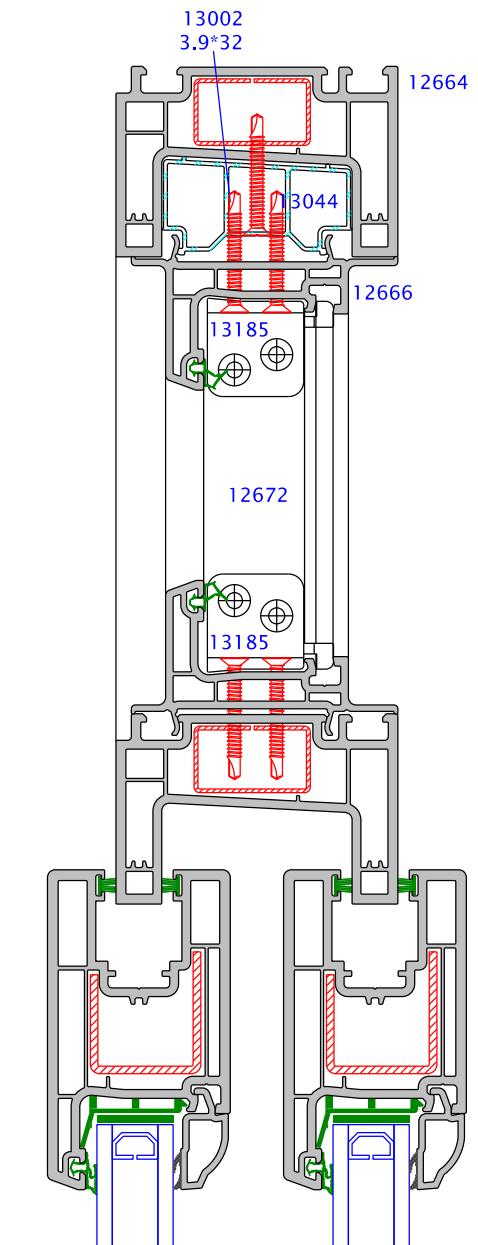
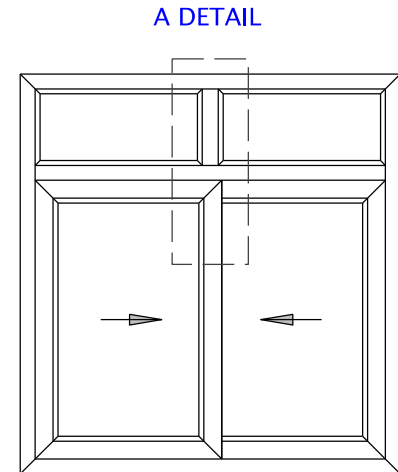
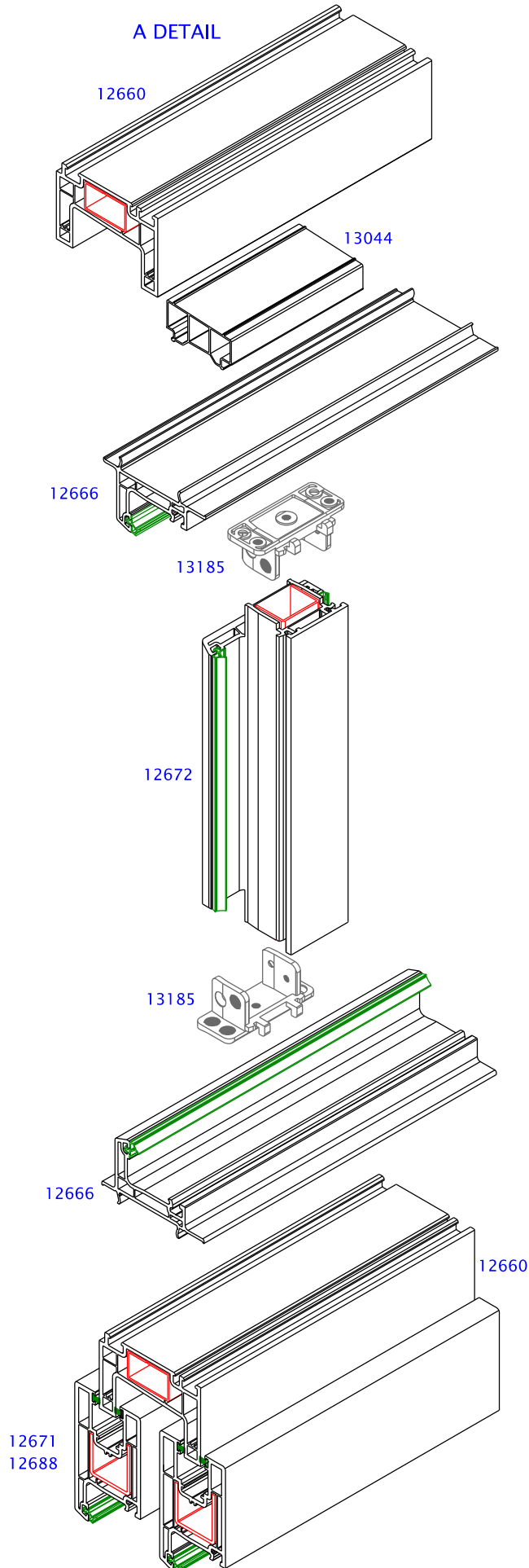
B DETAIL

Cutting

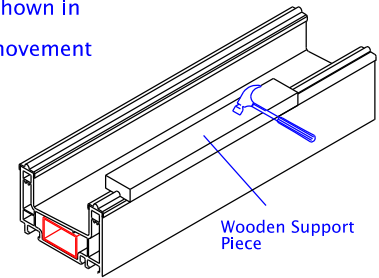


A DETAIL





* It is advised that sliding aluminium rails must be installed by using wood support pieces as shown in the picture. If the rail is hammered directly, aluminium profile can be deformed and it effects the movement of sashes negatively.



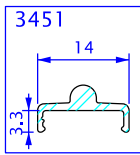
* 12660, 12661 and 12663 (for white colours) => Sliding rail 14mm (3451) is used

* 12660, 12661, and 12663 (for laminated colours) => Sliding rail 14,5mm (3452) is used

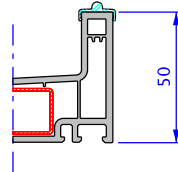
* Sliding frames (12660) which has laminated one side (1XXX or 2XXX) both rails can be used (for the white side, 3451; laminated side 3452)

* 3451 and 3452 have very similar designs. Sliding rail 14.5 (3452) which is used with laminated colored profile has a groove at bottom.

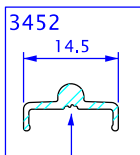
=> for white profiles



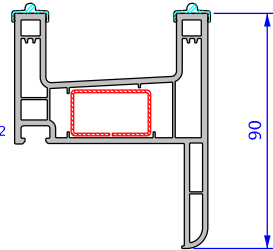
12660
12658
12665
12684



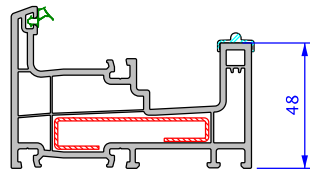
=> for laminated profiles



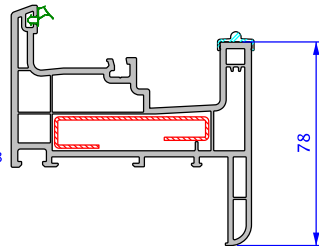
12662



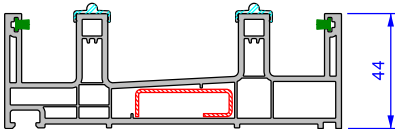
12661



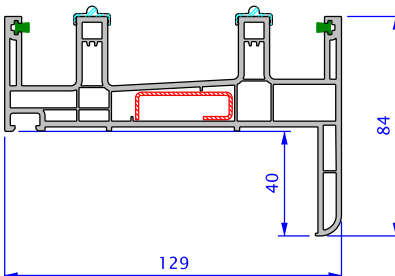
12663



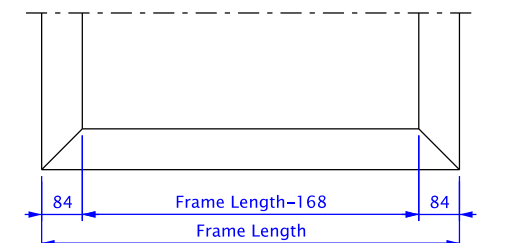
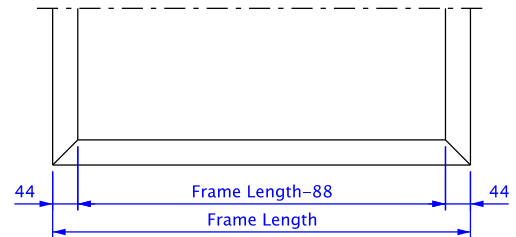
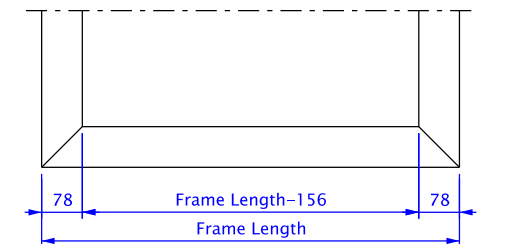
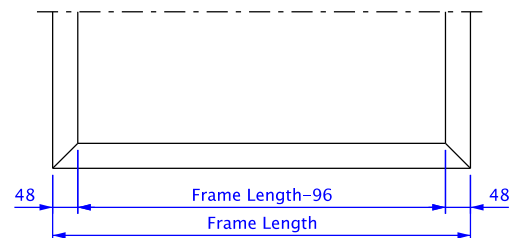
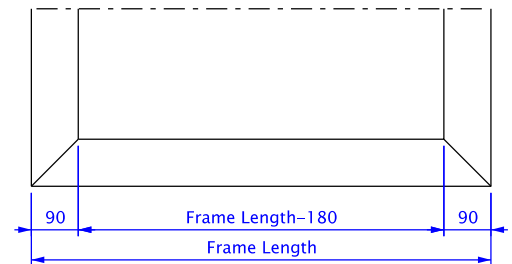
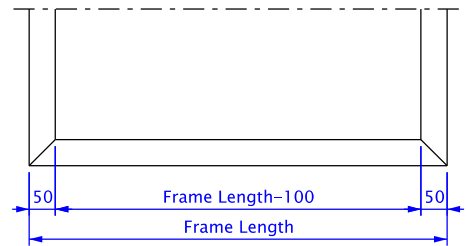
12636



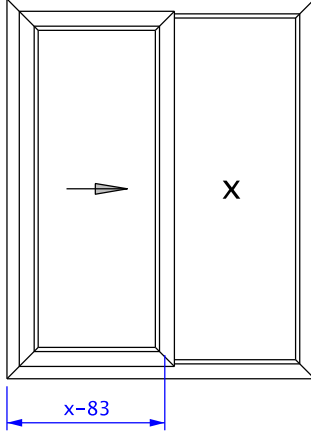
12637



CUTTING SIZE of SLIDING RAIL



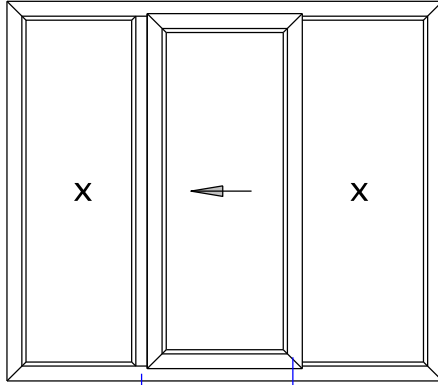
- * Cutting length of aluminium threshold (13042) is calculated from the axe points.
- * Aluminium threshold is endmilled , then brush (10578) which has the dimension of 48x1000 is inserted on the aluminium profile
- * Endmilled aluminium profile is clipped on frame.



Sample 1 :

Axe point: 1000mm

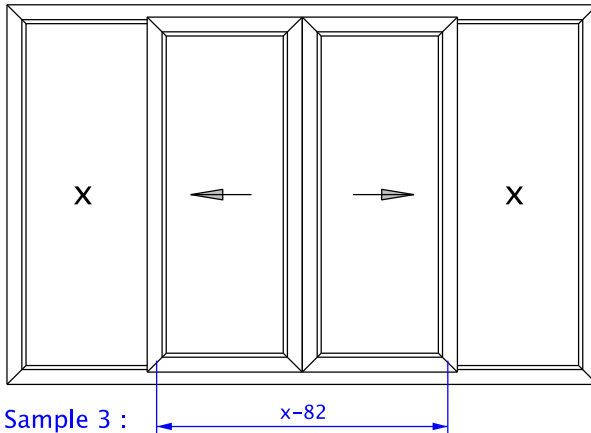
$$1000-83= 917\text{mm}$$



Sample 2 :

Axe point: 1000 mm

$$1000-62= 938 \text{ mm}$$



Sample 3 :

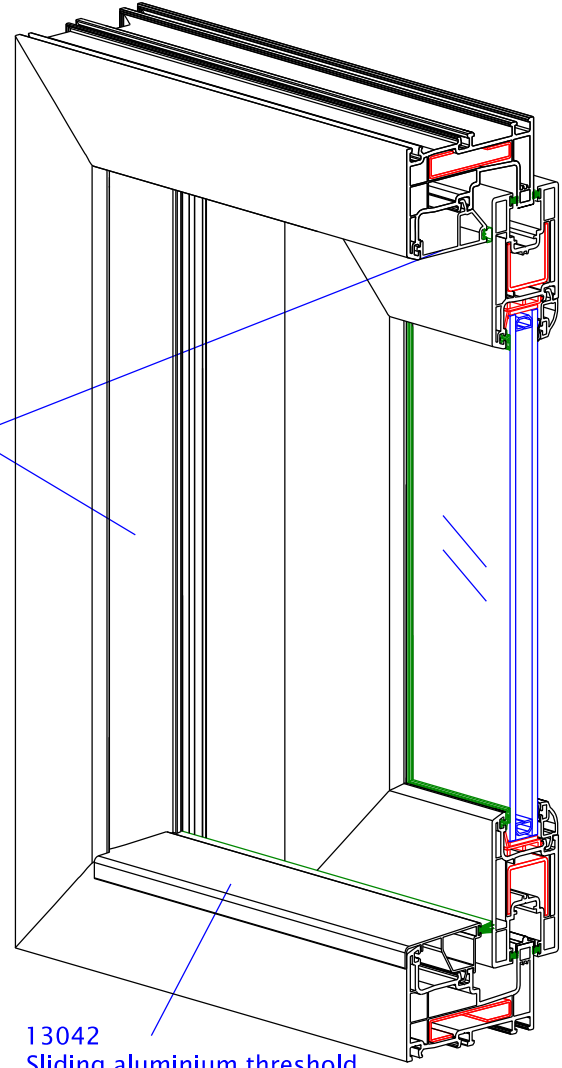
Axe point: 2000 mm

$$2000-82= 1918 \text{ mm}$$

* After the aluminium threshold is mounted on frame

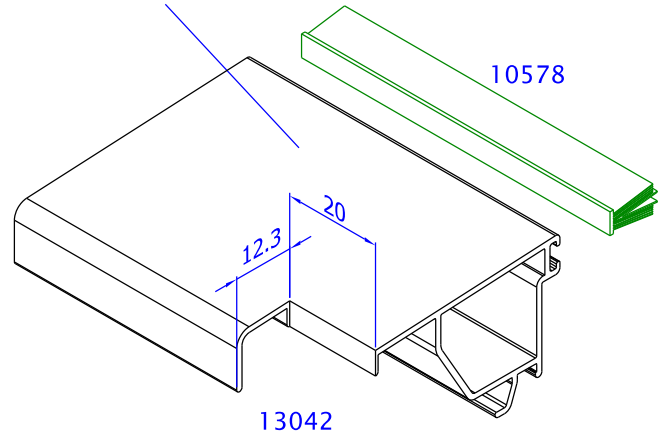
* Sliding closing (12679) is placed on sides and top of frame

Sliding closing



13042
Sliding aluminium threshold

10578

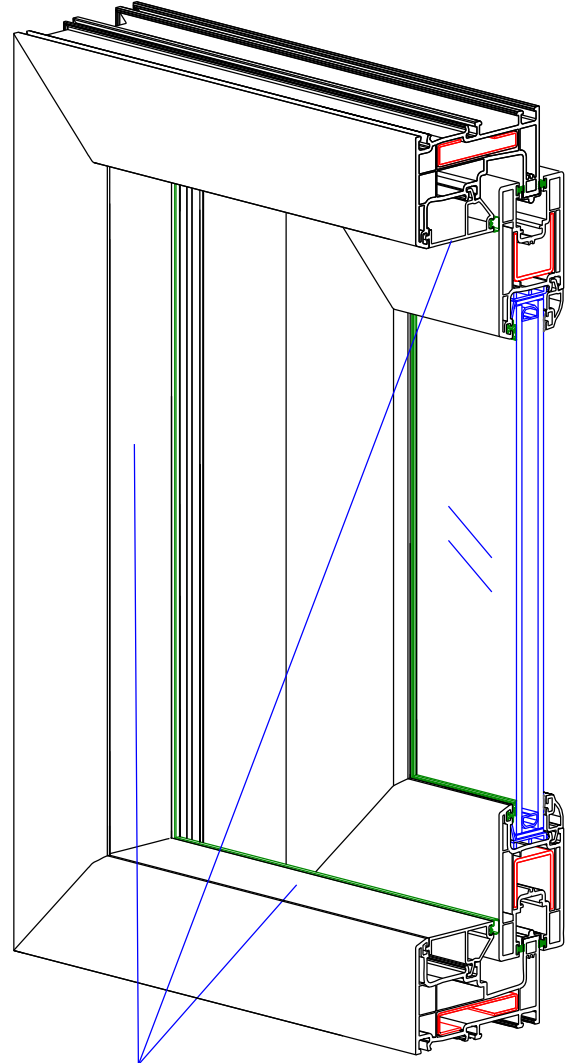
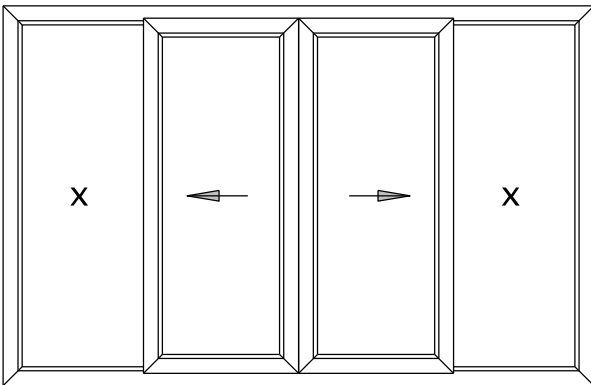
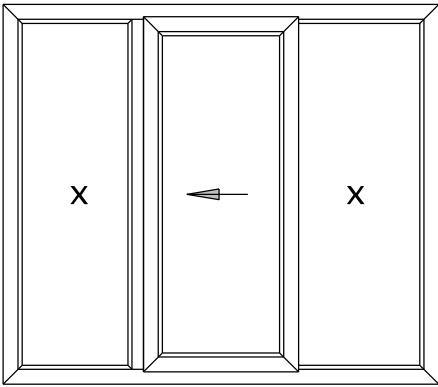
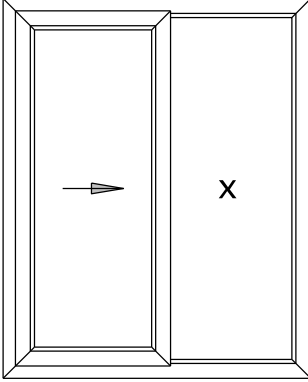


13042

Note : In this type of sliding windows (Sample 3) there is no need to endmilling the aluminium threshold.

* In the application of fixed-sliding frames , sliding closing (12679) profiles are used on back sides of movable sashes as 2 pieces horizontal and one piece as vertically.

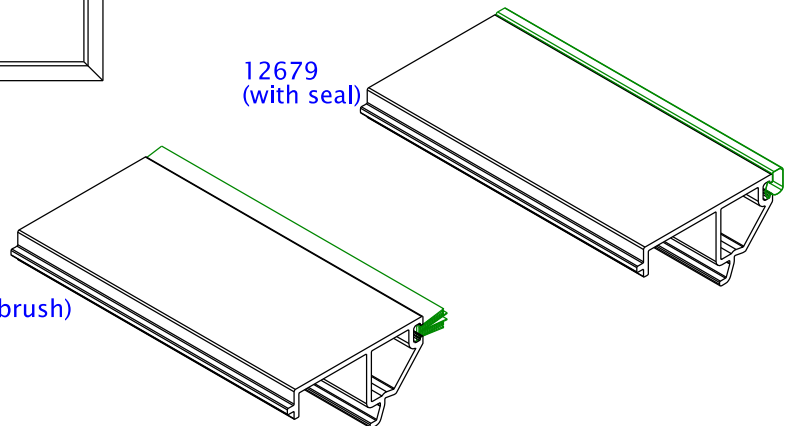
Profile should be cut 45° on corners.It can include seal or brush according to the application.

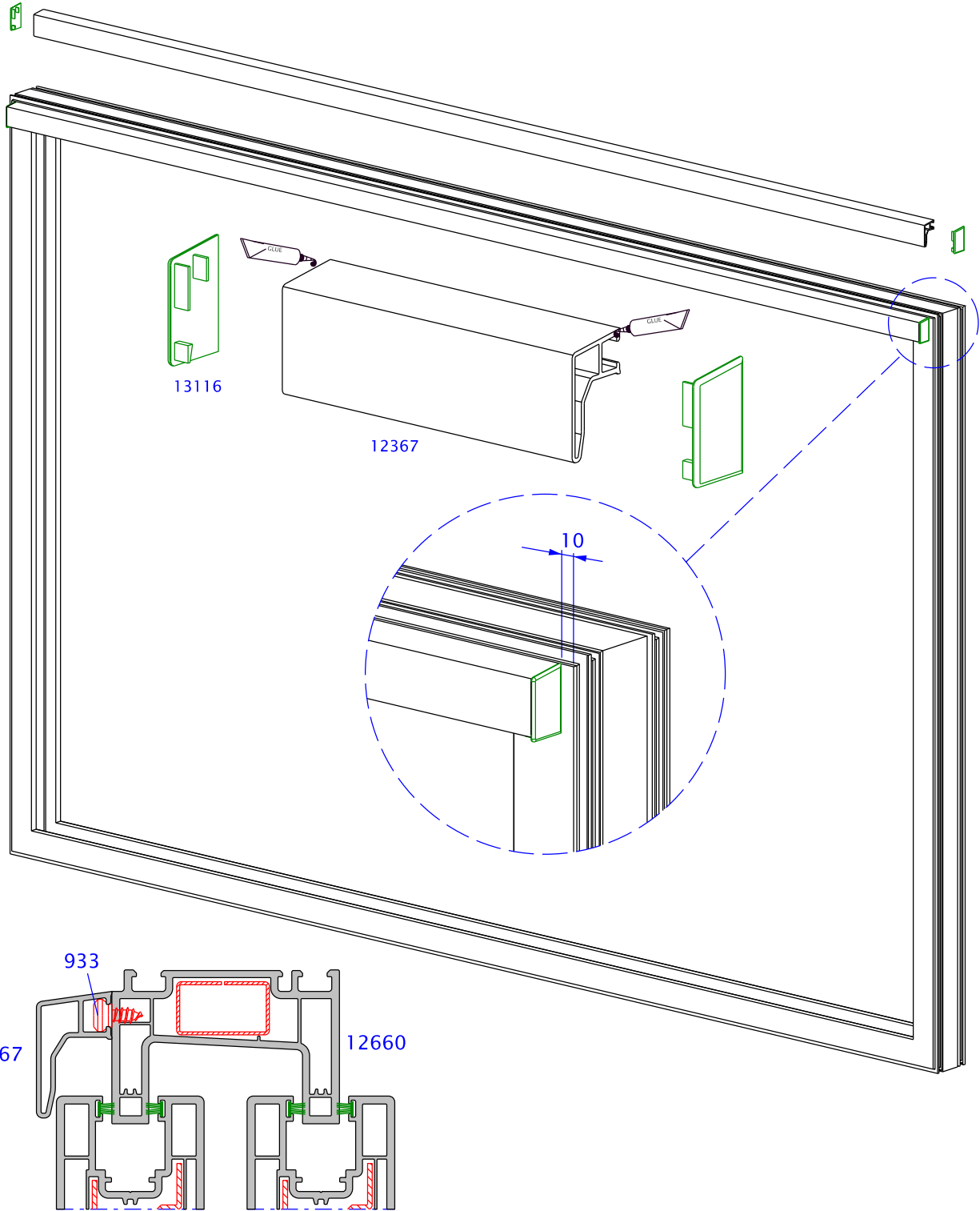


12679
Sliding closing

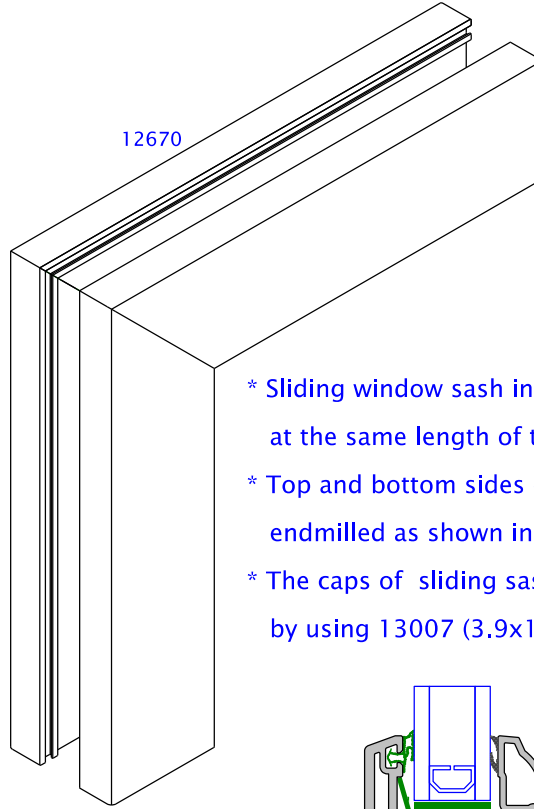
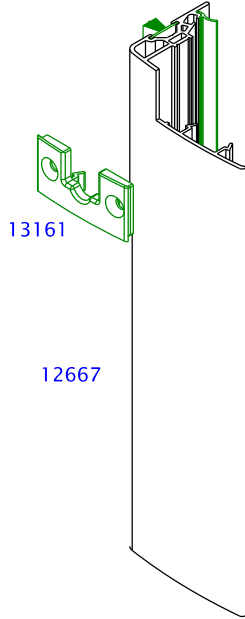
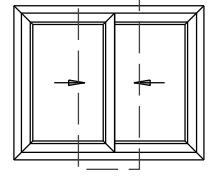
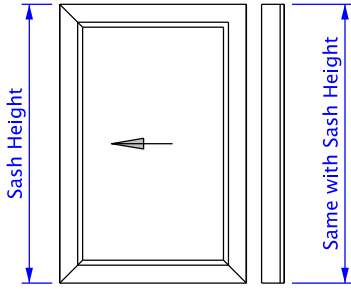
12679
(with seal)

12679
(48x1000 brush)

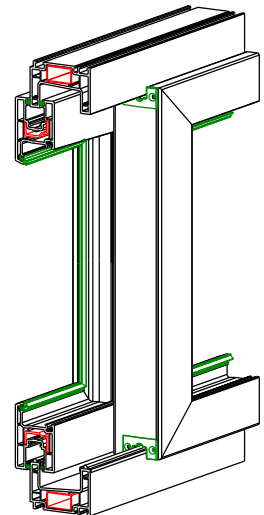
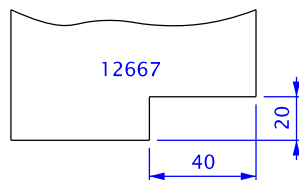
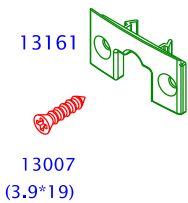
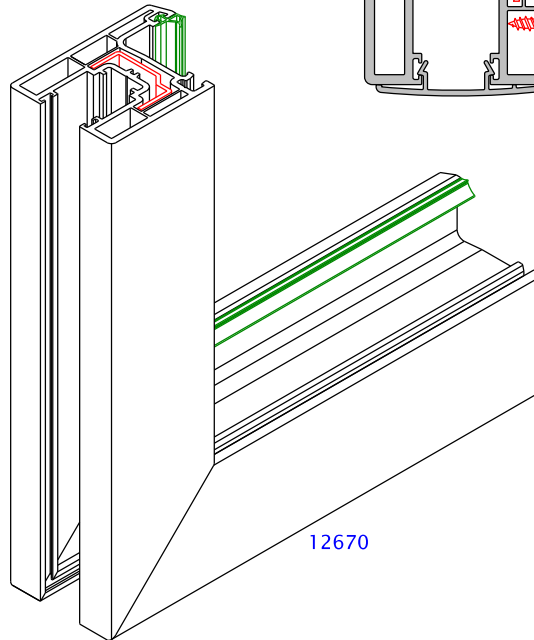
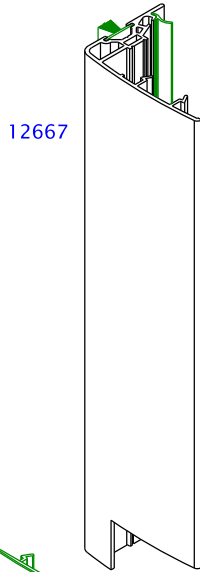
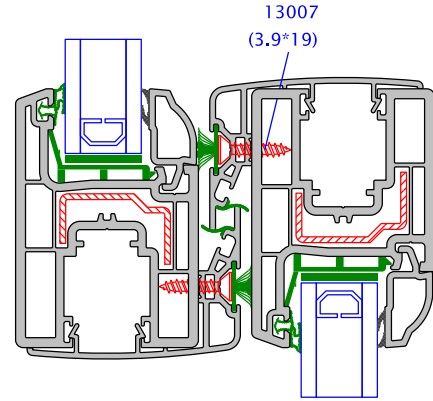


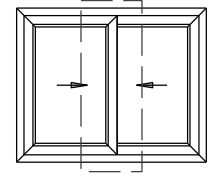
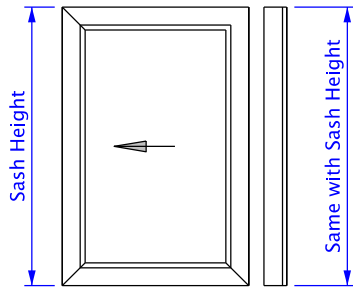


- * Sliding recess profile blocks the water that falling down directly to outside of sliding sash,
- * Clip screw(933) is fixed on the top-outside of the frame horizontally,
- * Sliding recess profile (12367) is hammered on these screws using plastic malet,
- * Bonding of end caps should carefully be carried out using glue. (e.g. loctite). Bonding surfaces must be clean, dry and free from grease.
- * Sliding recess endcap (13116) is used to cover the sides of the profile,
- * This profile is not used with sliding flyscreen , roller shutter and stor flyscreen
- * For the frames (12661/12663),since the sashes are moving on internal rail, therefore there is no need to use recess profile.

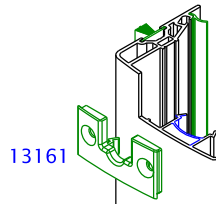


- * Sliding window sash interlock (12667) should be cut at the same length of the sash.
- * Top and bottom sides of profile are endmilled as shown in the picture.
- * The caps of sliding sash interlock (13161) is fixed by using 13007 (3.9x19-flathead) screw





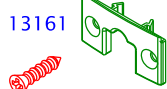
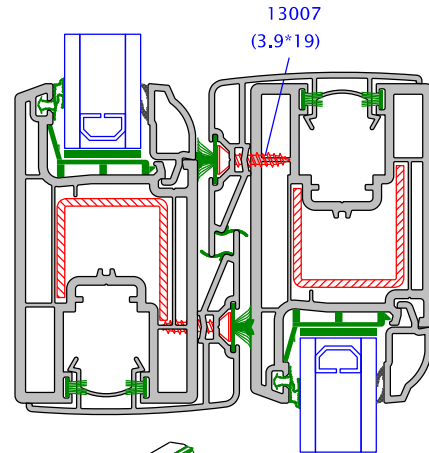
12671-12688



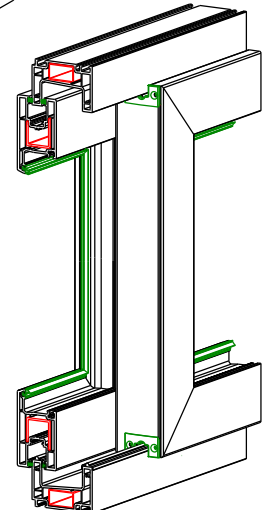
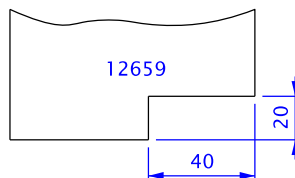
12659

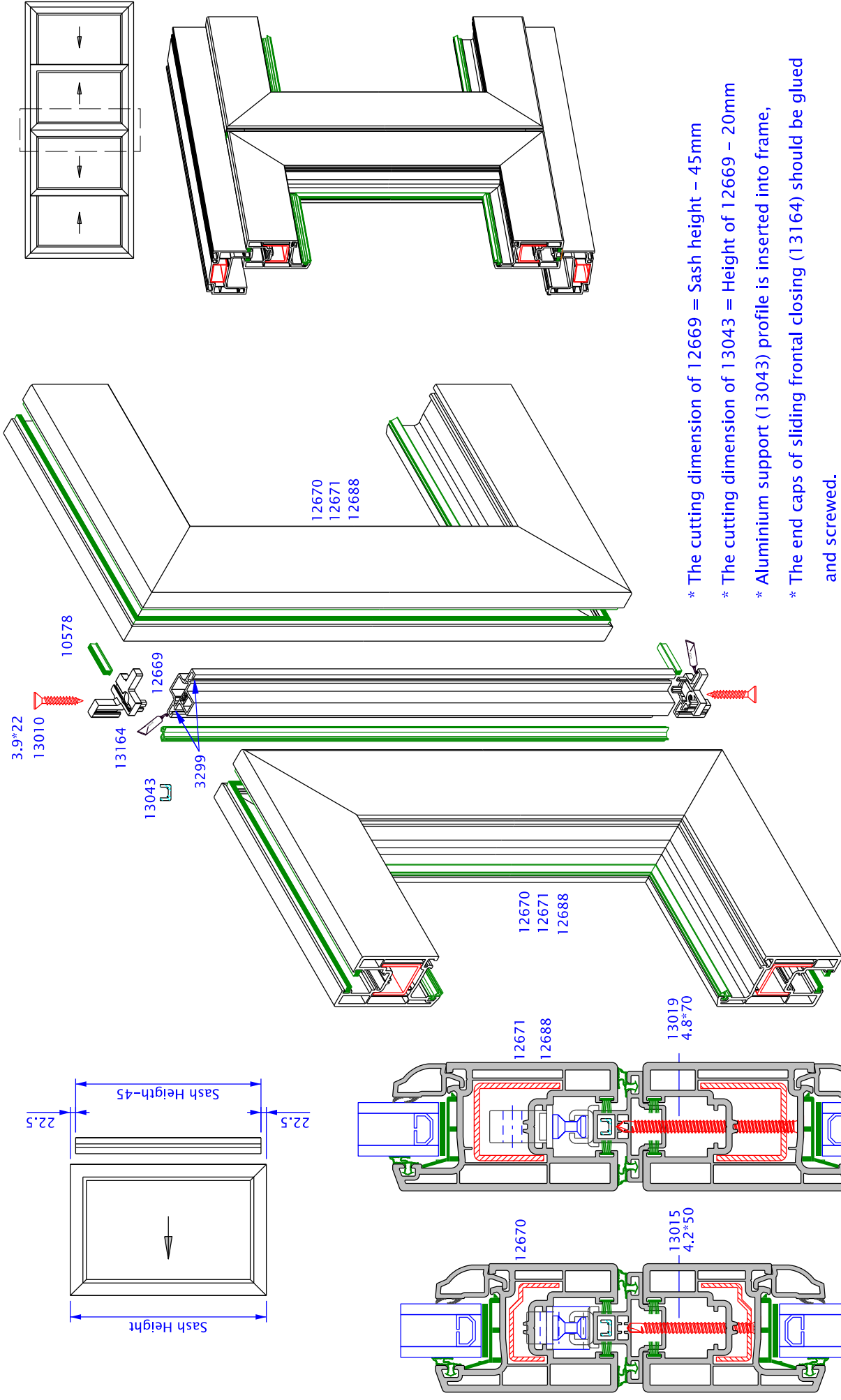
12659

- * Sliding sash interlock (12659) should be cut at the same length of sash profile,
- * Top and bottom sides of profile (12659) are endmilled as shown in the picture,
- * The caps of sliding sash interlock (13161) are fixed by using 13007 (3.9x19 flat-head) screw.



13007
(3.9*19)





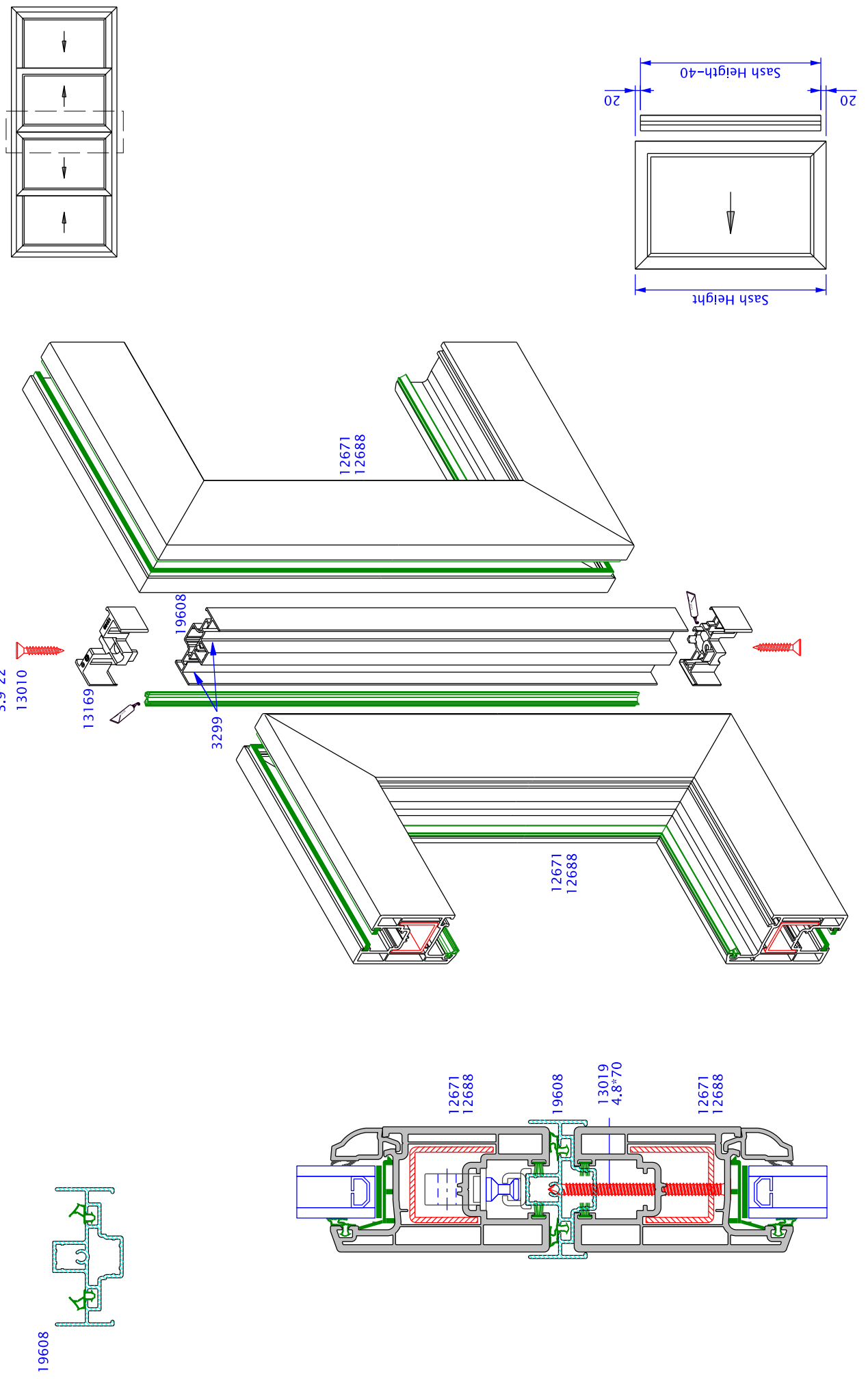
* The cutting dimension of 12669 = Sash height – 45mm

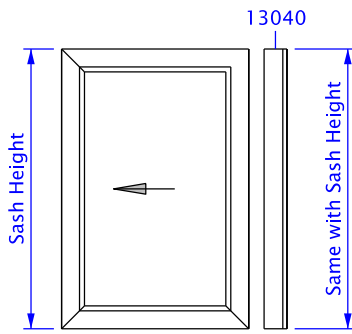
* The cutting dimension of 13043 = Height of 12669 – 20mm

* Aluminium support (13043) profile is inserted into frame,

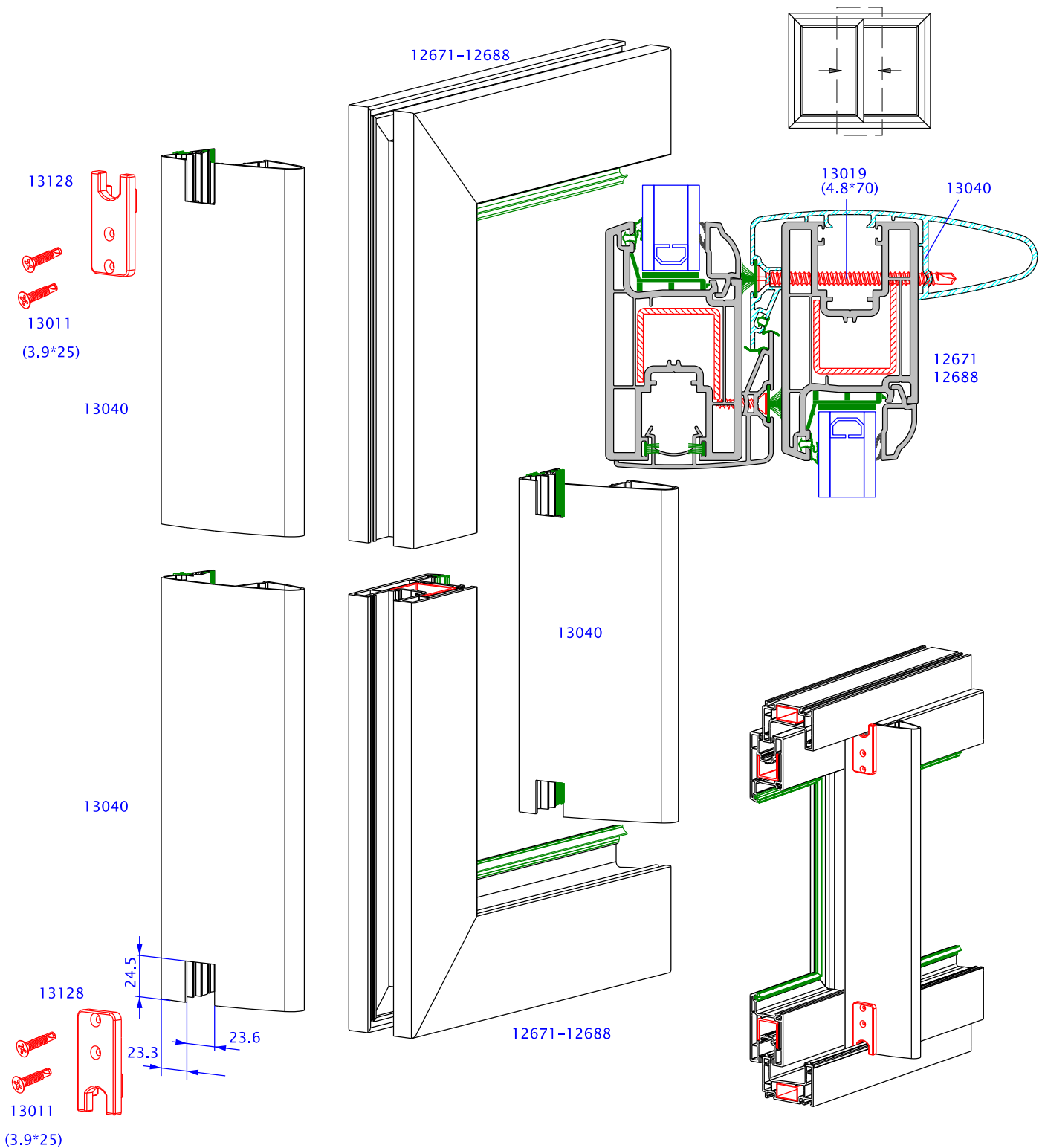
* The end caps of sliding frontal closing (13164) should be glued and screwed.

Then the brush (10578) which has the dimension of 48x1000 is inserted,
* 3299 TPE seal is inserted on the 12669.





- * Sliding sash aluminium interlock should be cut (13040) at the same length of sash profile,
- * Top and bottom sides of profile are endmilled,
- * The endcaps of sliding interlock (13161) are fixed with the screw 13128 (3.9x25 flathead).
- * 13040 which gives more strength to window can be applied from inside/ outside or both.
- * 13040 is used only with 12671–12688.

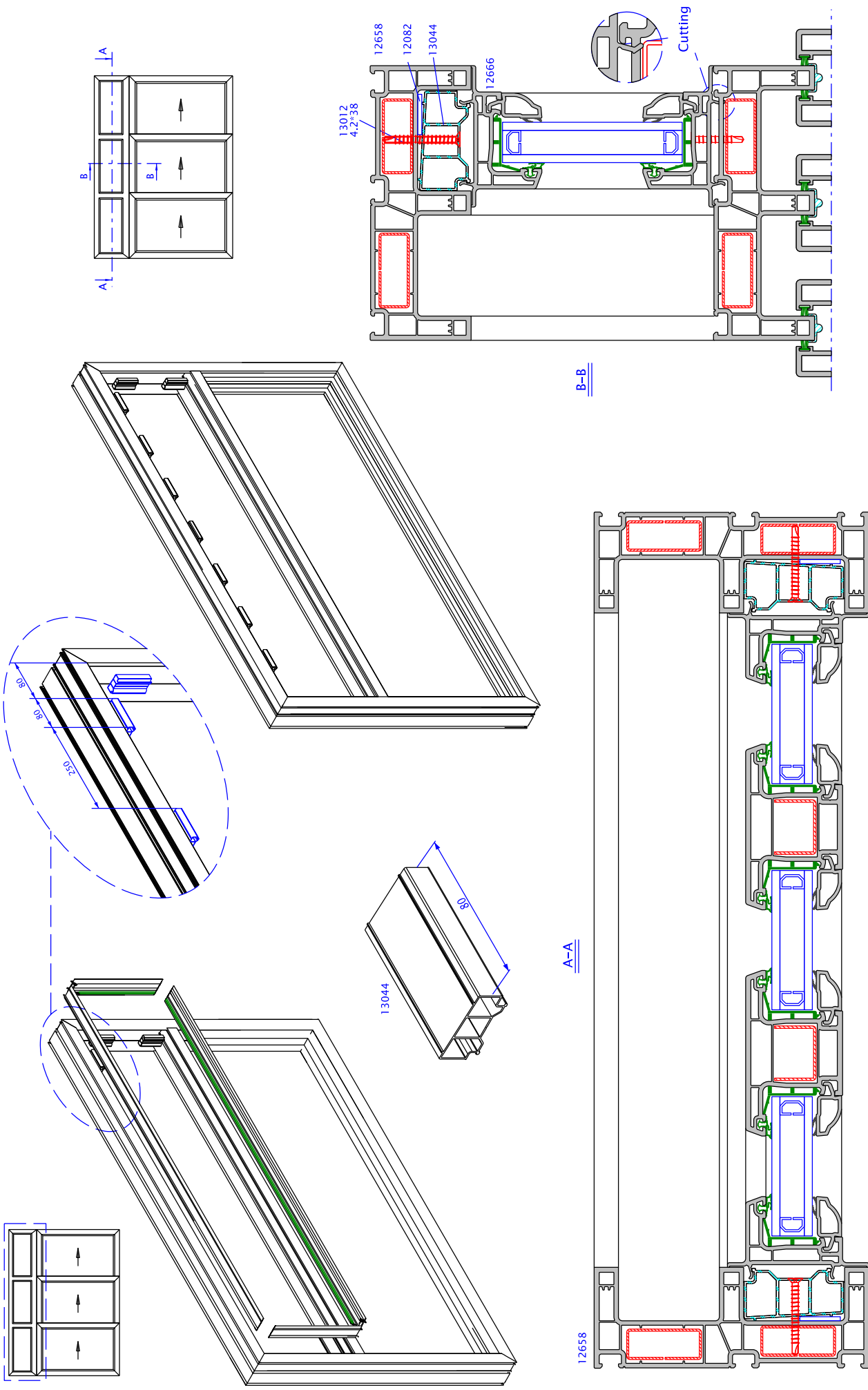


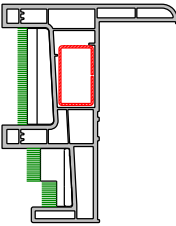
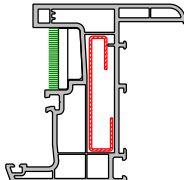


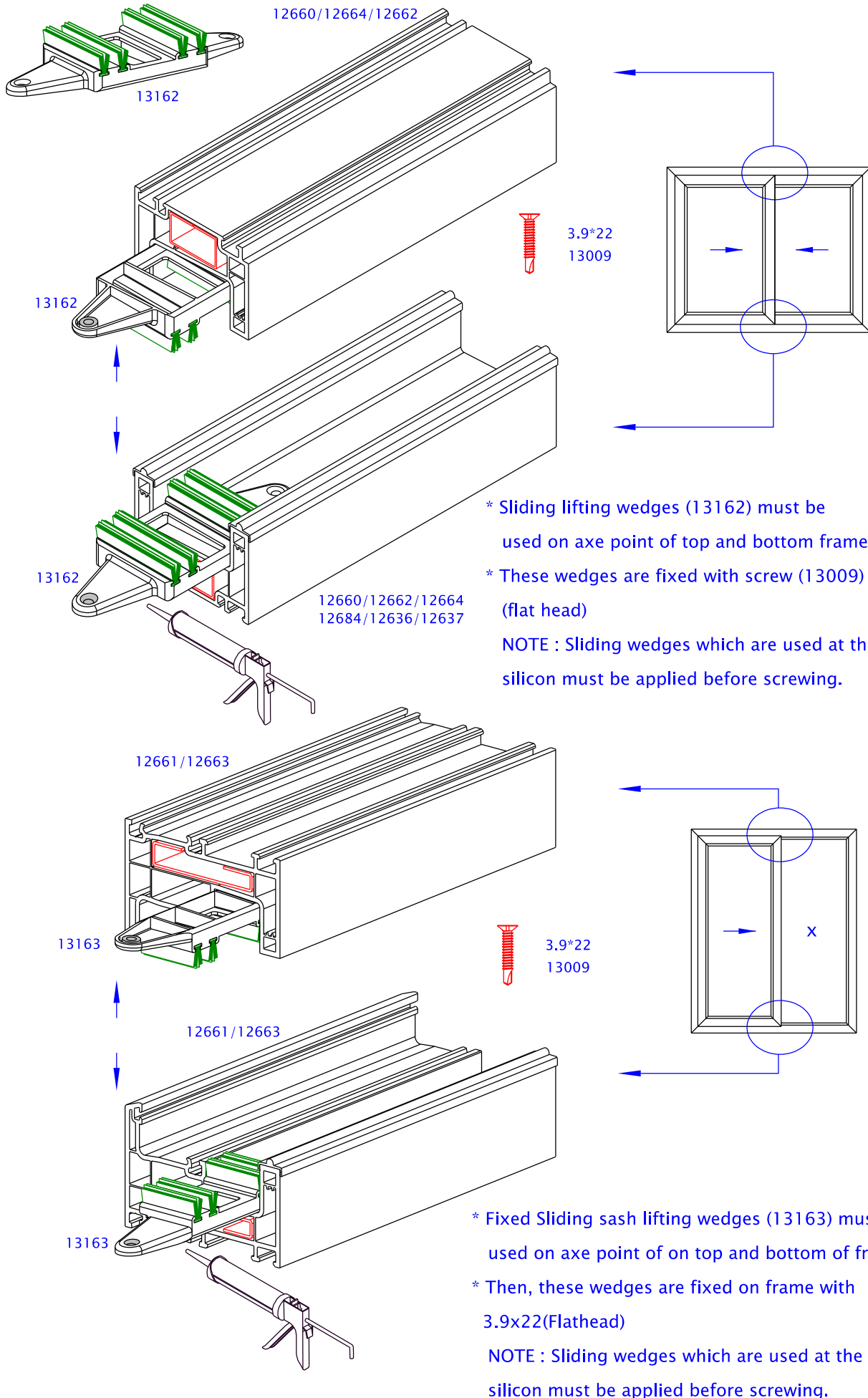
88

APPLICATION OF ACCESSORY PRODUCTS

Sliding fix panel aluminium adaptor (13044) / Sliding fix. adapt. (12666)



Sliding Frames	Sash Lifting Wedges	Application
 <p>12660</p>  <p>12662</p>	 <p>13162</p>	 
 <p>12658</p>	 <p>13159</p>	
 <p>12684</p>	 <p>13162</p>  <p>13131</p>	
 <p>12665</p>	 <p>13159</p>  <p>13131</p>	
 <p>12661</p>		
 <p>12663</p>	 <p>13163</p>	
 <p>12637</p>  <p>12636</p>	 <p>13162</p>	 



* Sliding lifting wedges (13162) must be used on axe point of top and bottom frames.

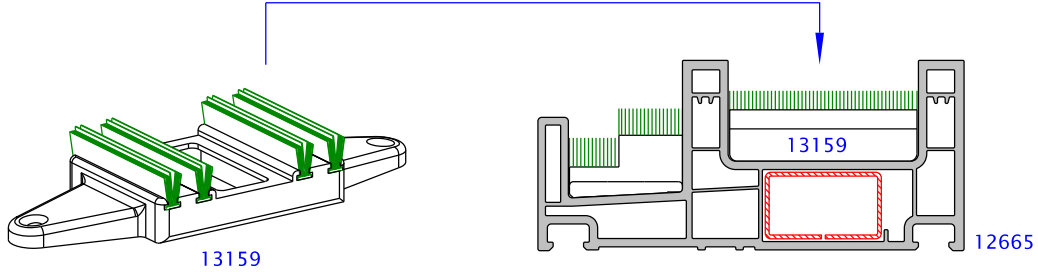
* These wedges are fixed with screw (13009) 3.9x22 (flat head)

NOTE : Sliding wedges which are used at the bottom, silicon must be applied before screwing.

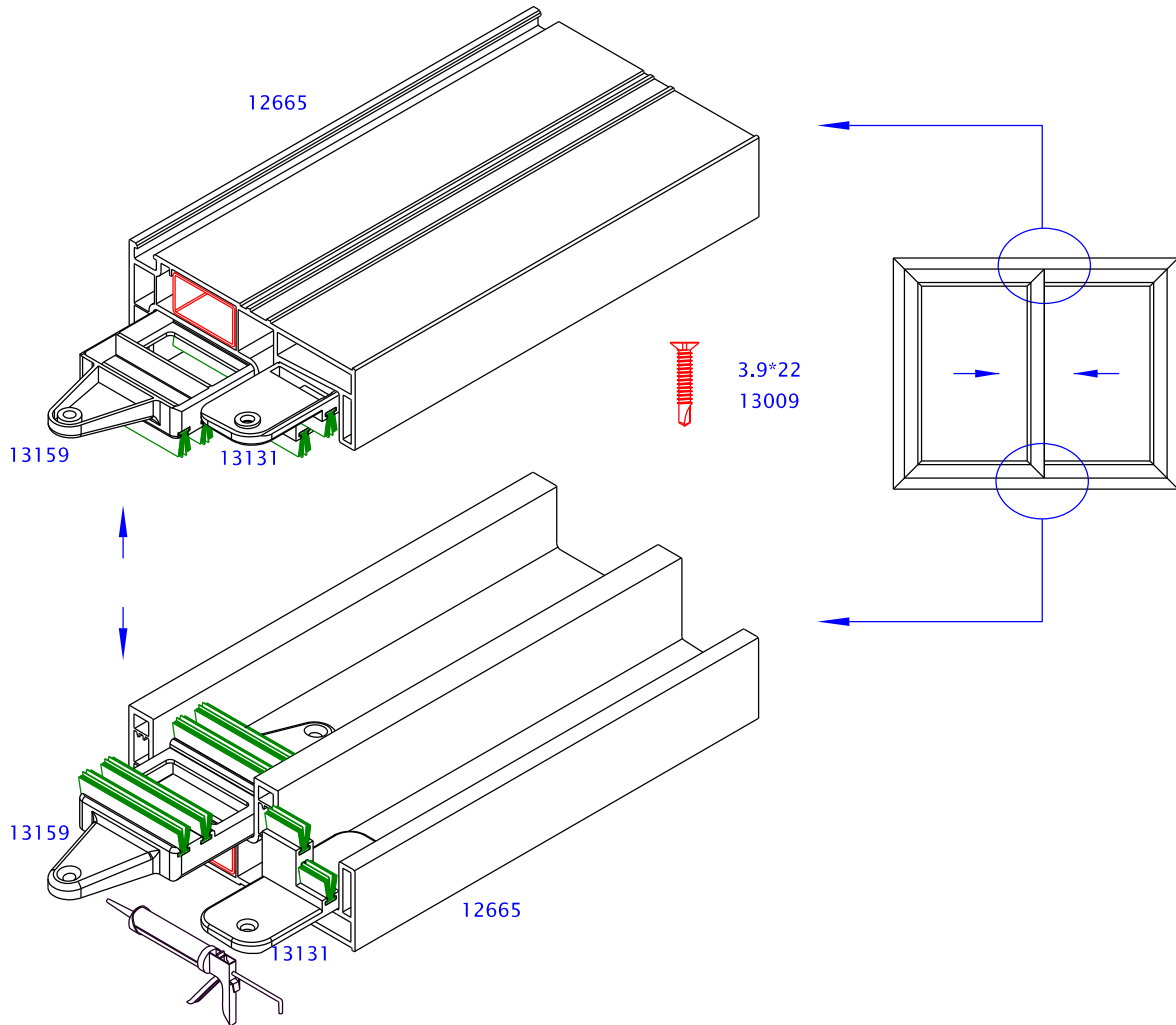
* Fixed Sliding sash lifting wedges (13163) must be used on axe point of on top and bottom of frames.

* Then, these wedges are fixed on frame with 3.9x22(Flathead)

NOTE : Sliding wedges which are used at the bottom, silicon must be applied before screwing.

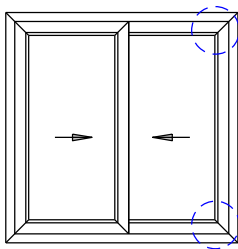
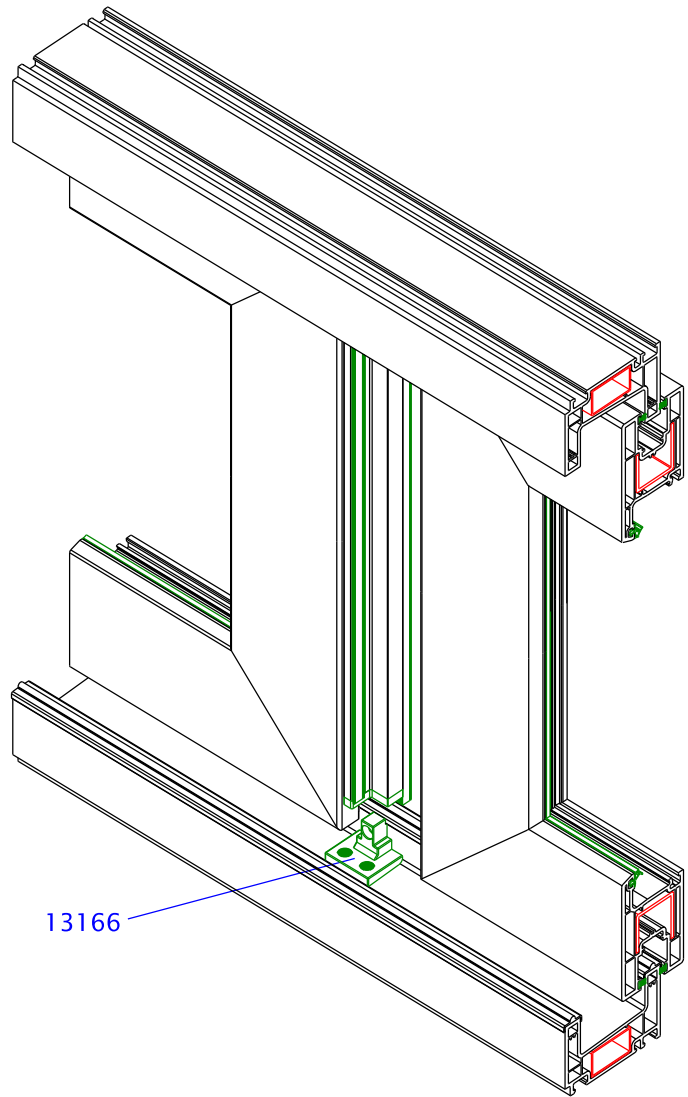
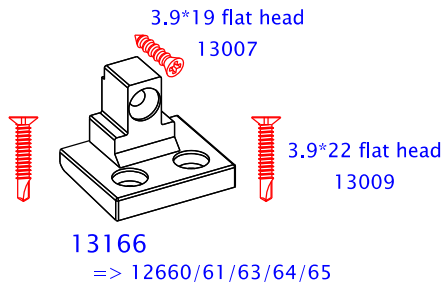


P13159 which is designed for the sliding frame with flyscreen has the flat bottom plate.
Therefore, the lifting wedge of 12660 can not be used in 12665.

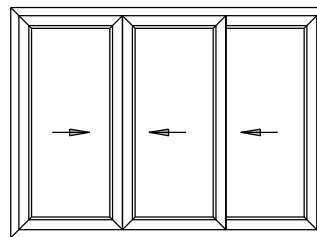


The Sash lifting wedge of 12665 must be screwed on the central of two sashes.
(with 3.9*22 screw) as shown in figure.

NOTE : It is advised to isolate with silicon for the bottom wedge before screwing.

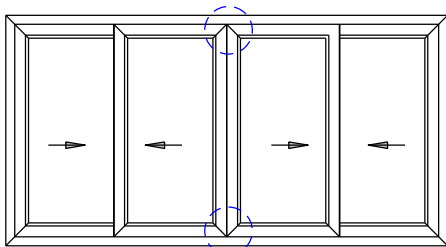


13166 is used
(Frame : 12660)

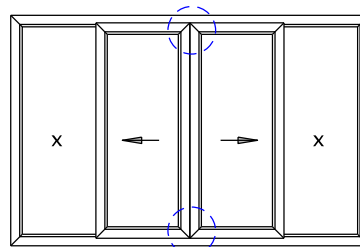


13166 can not be used
(Frame : 12660)

In the case of locking espagnolette applications, stopping piece (13166) is used to prevent the striking of door handle to other sash.

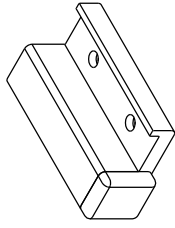


13166 is used
(Frame : 12660)

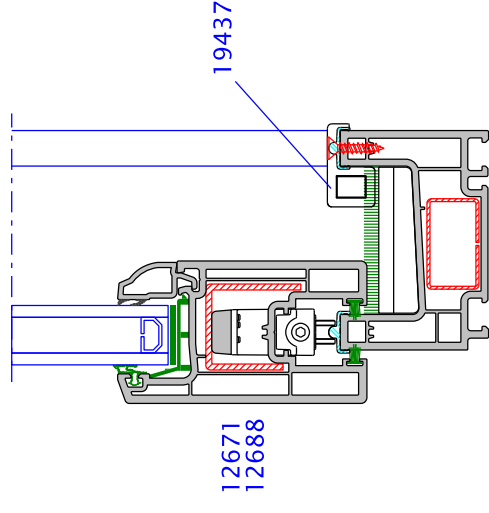
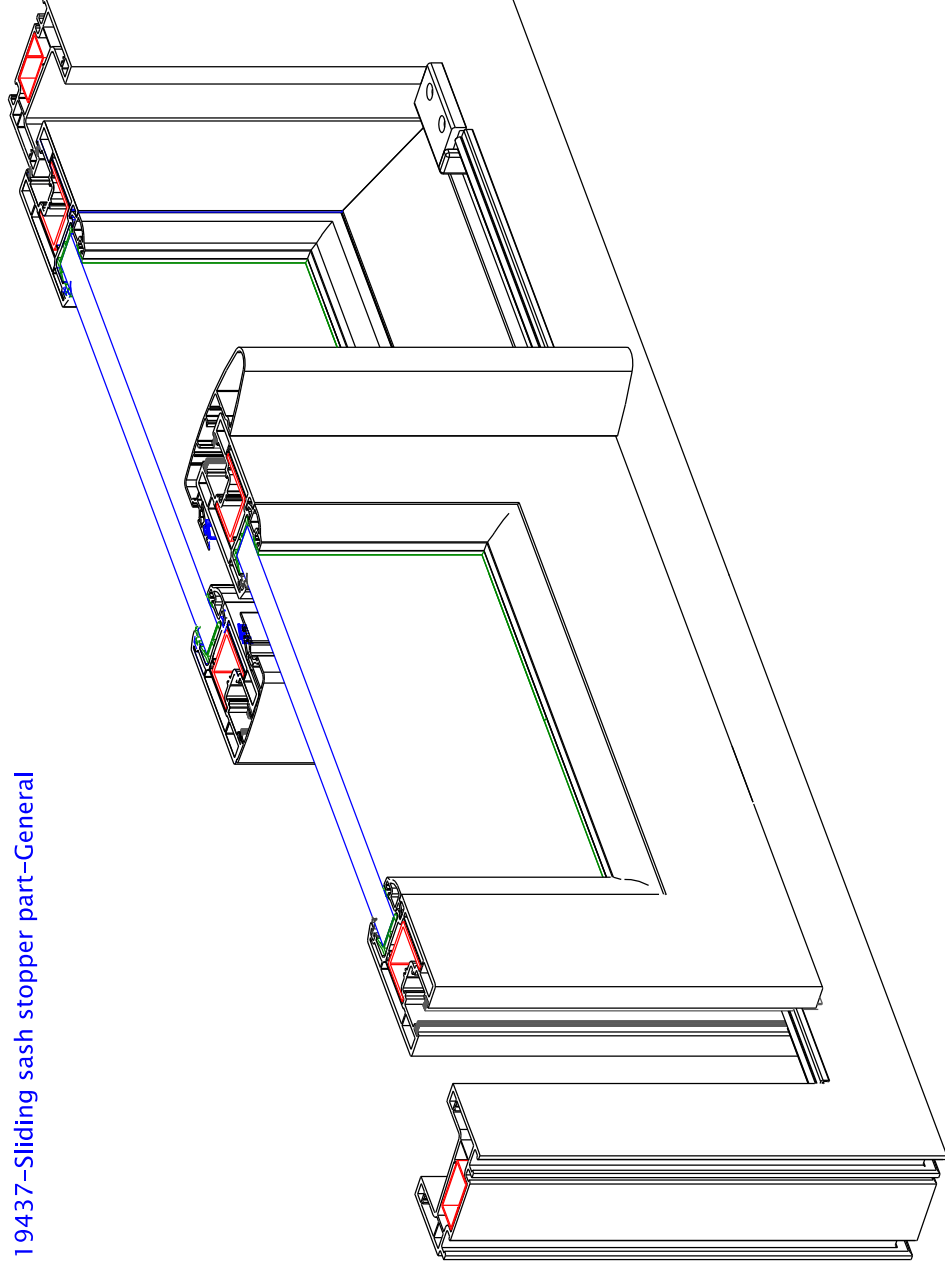


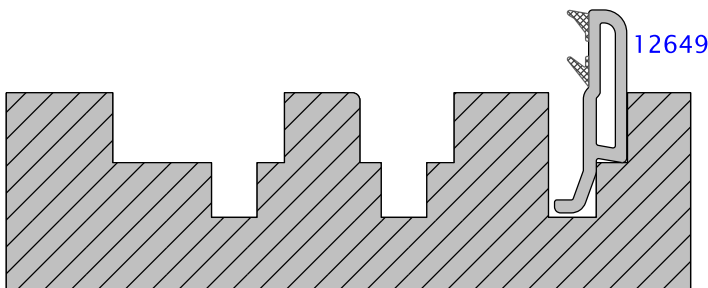
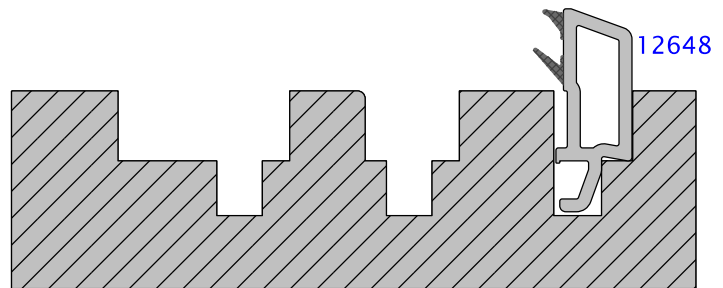
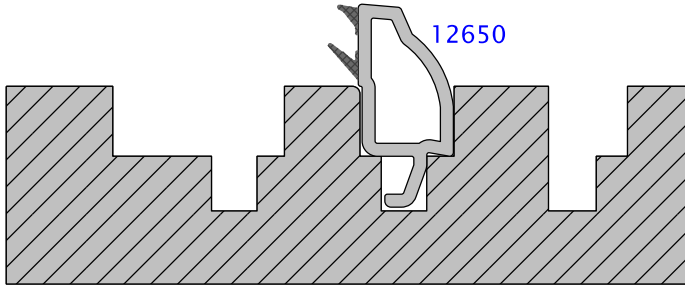
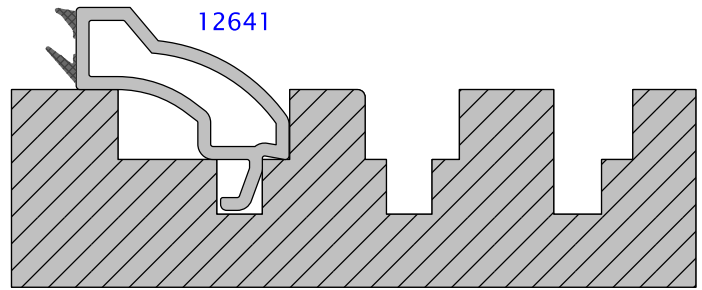
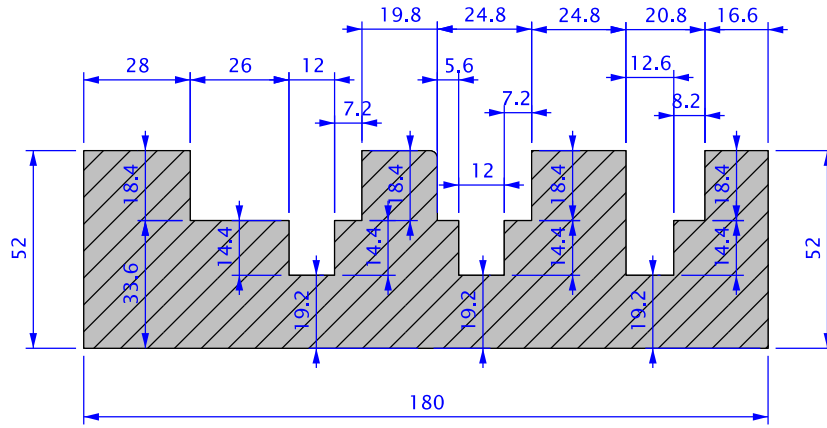
13166 is used
(Frame : 12661/12663)

Stopping piece (13166) is used in the sliding that includes 4 parts as shown above.

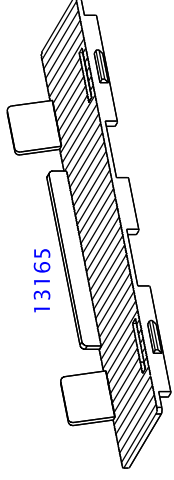


19437-Sliding sash stopper part-General

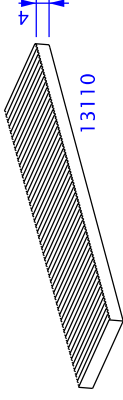




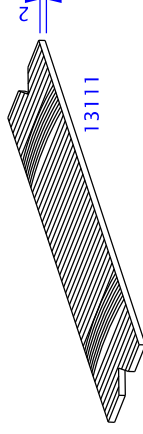
Note : The drawing shows the dimensions of cutting tool sample for glazing beads. These dimensions can be change due to the machine types.



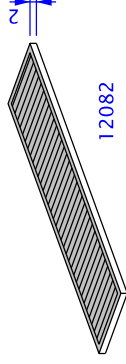
13165



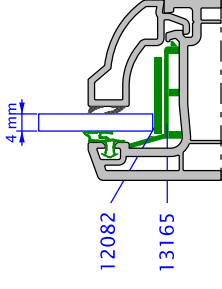
13110



13111

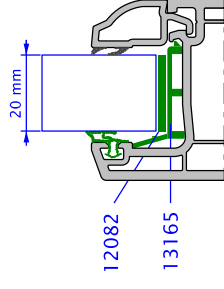


12082



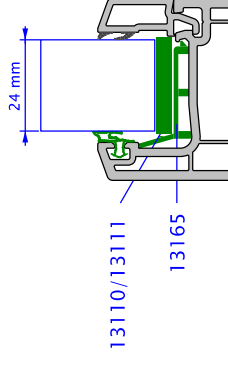
12082

13165



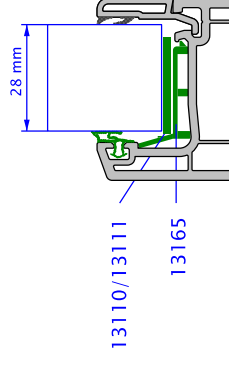
12082

13165



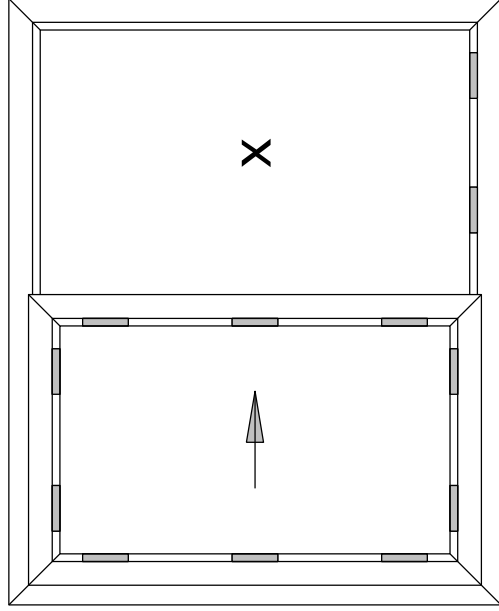
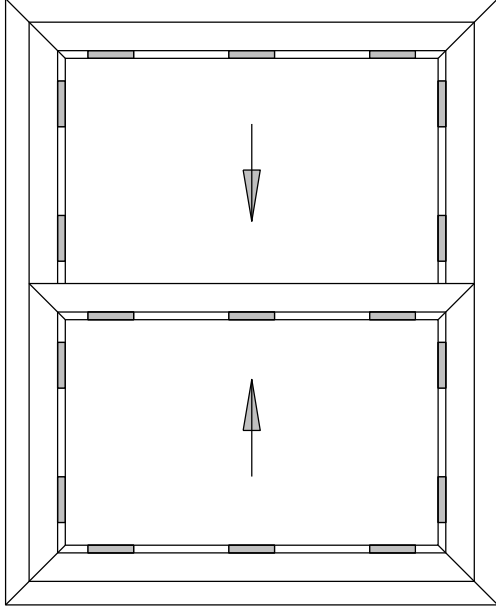
13110/13111

13165



13110/13111

13165



* Sliding glazing wedge (13165) is placed in the movable sliding sashes,

* In the application of sliding doors filler wedges(13110/13111/12082) must be used,

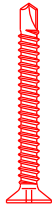
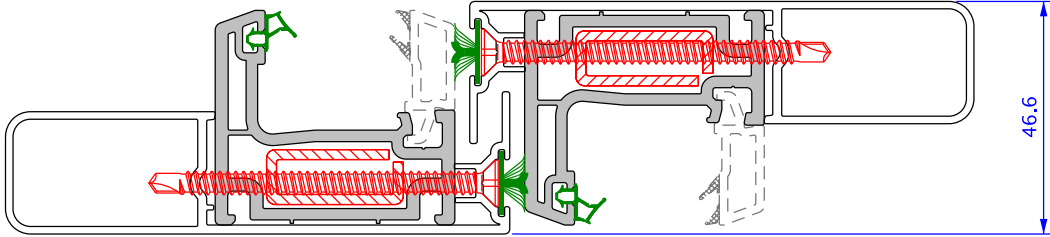
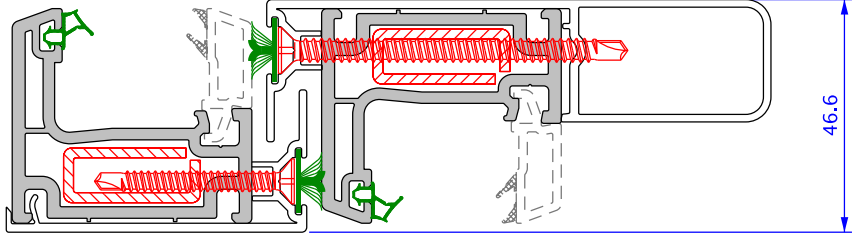
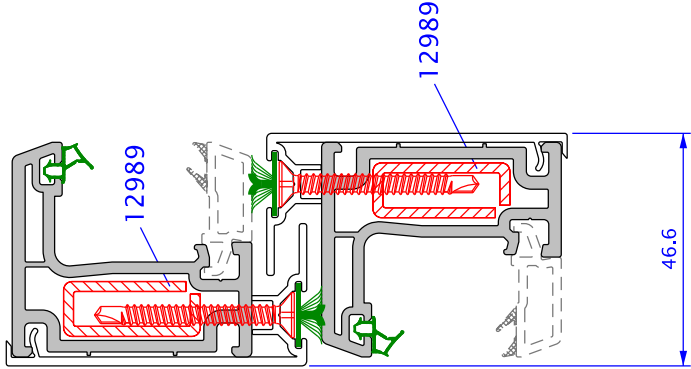
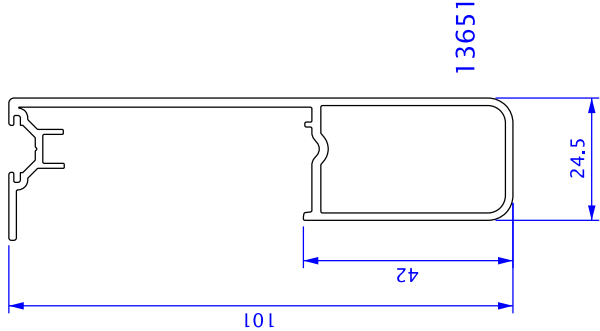
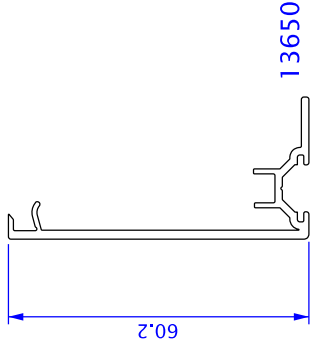
* Glazing wedges and filler wedges are glued with silicone on the vertical sides and top sides.

* Glazing beads are placed on the bottom frames, the silicone is not applied,

Glazing wedges should not be placed on drainage area at bottom. Because, it can block the water drainage.

According to the application types, interlocks are applied as in the drawing.

Only 12648 glazing bead-9 mm is used in Slim Slide applications.

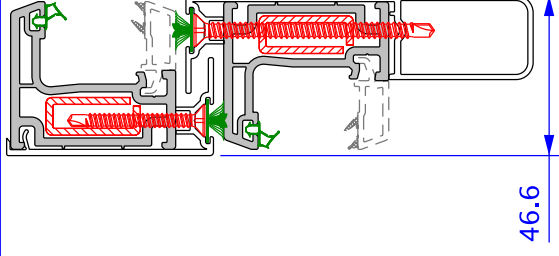
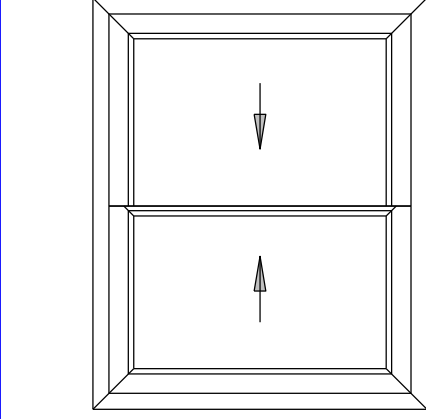




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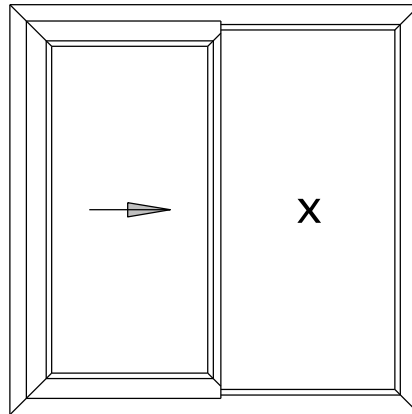
SLIM SLIDE

Cutting Sizes – Double sashes



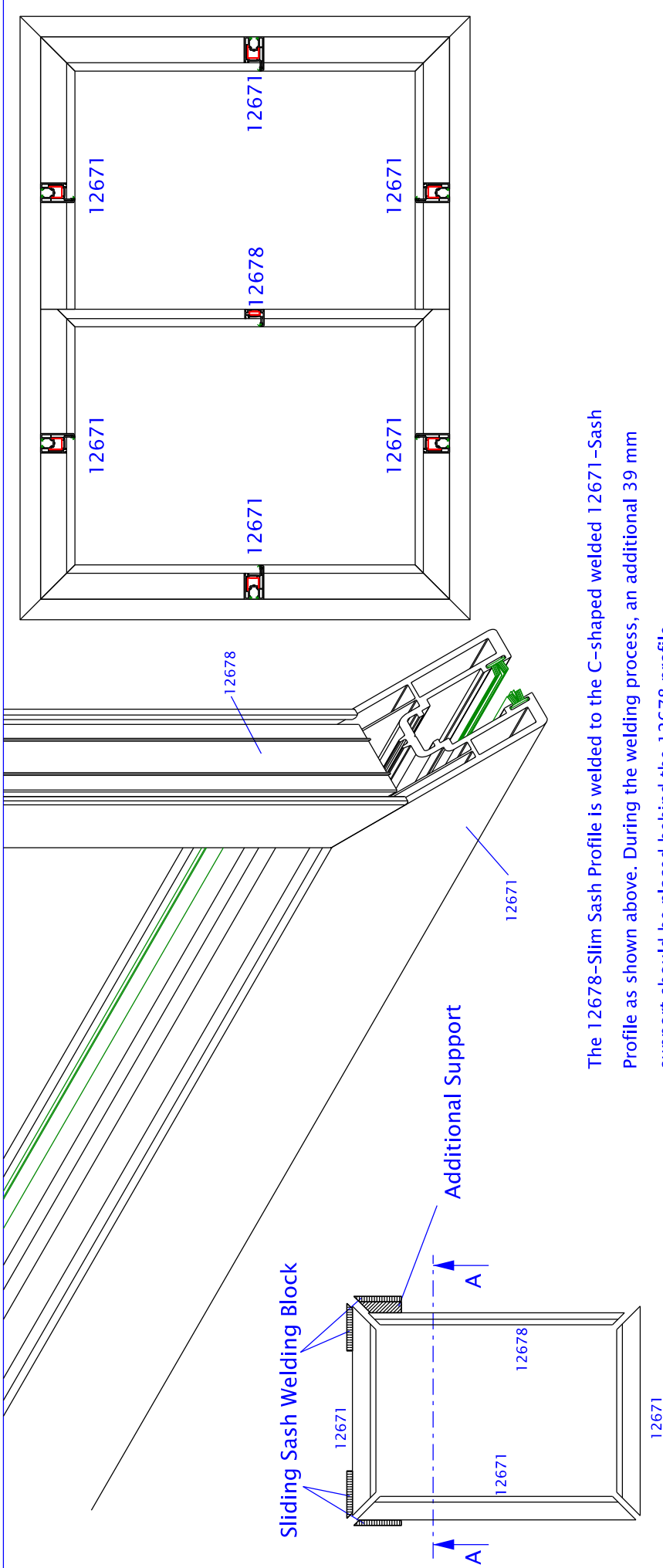
The sash overlap is 9 mm.

Dimension Cutting Sliding Frame	12660-Horizontal	12660-Vertical	12662-Horizontal	12662-Vertical	12664-Horizontal	12664-Vertical	12636-Horizontal	12636-Vertical	12637-Horizontal	12637-Vertical
Cutting Sliding Sash	X+6	X-76	X-26	X-156	X+6	X-76	X+66	X-64	X+6	X-144
Cutting Sliding Slim Sash	—	X-158	—	X-238	—	X-158	—	X-146	—	X-224
Glass Sliding Sash	$\frac{X-234}{2}$	X-220	$\frac{X-314}{2}$	X-156	$\frac{X-248}{3}$	X-220	$\frac{X-222}{2}$	X-208	$\frac{X-302}{2}$	X-288



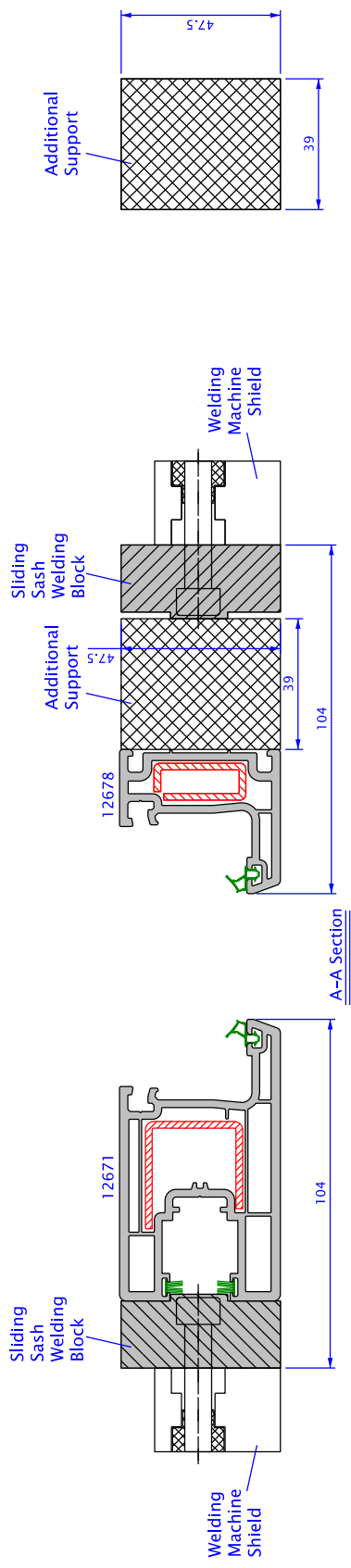
The sash overlap is 9 mm.

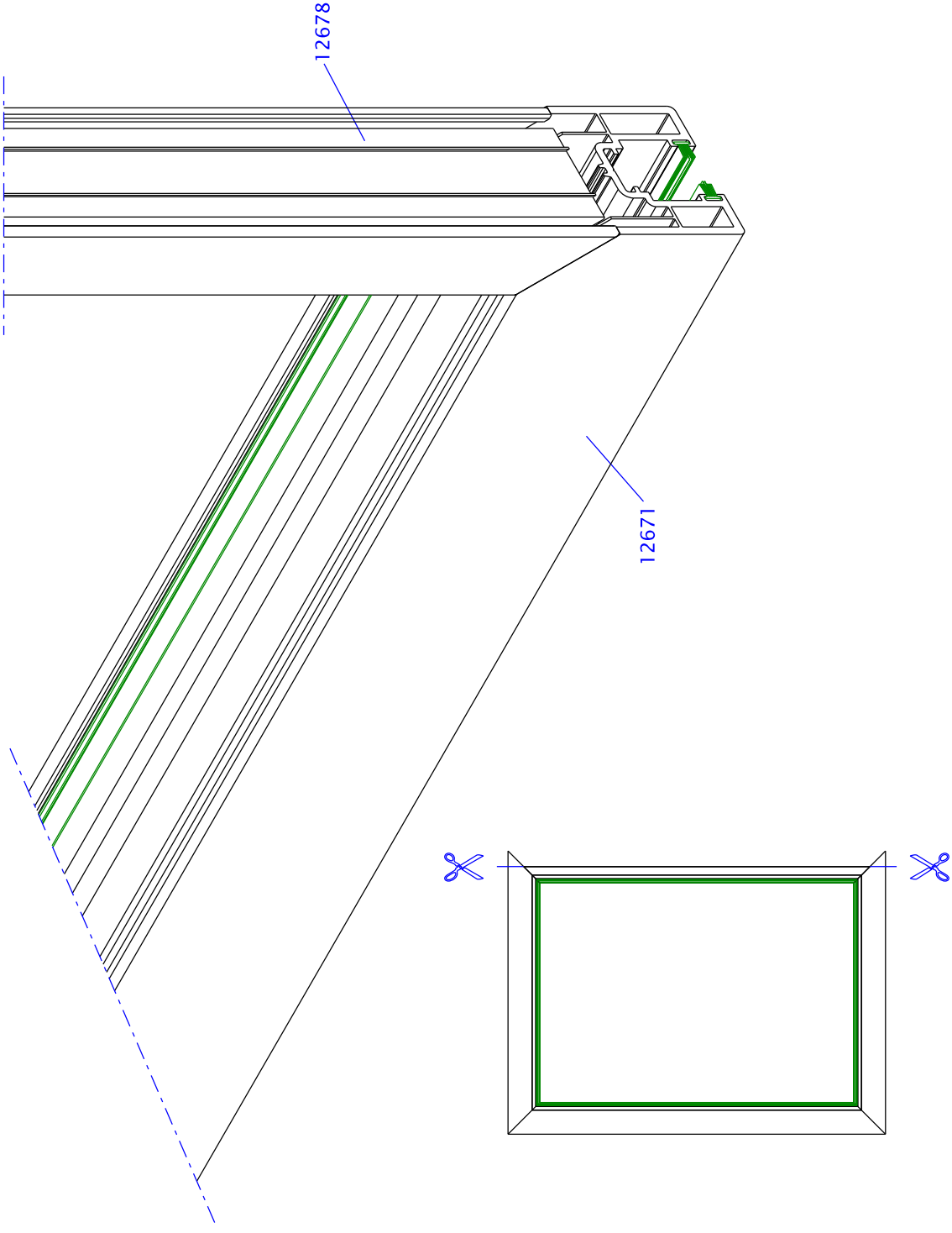
<div>Welding thickness is included</div> <div>Dimension</div>	 12661– Horizontal	 12661–Vertical	 12663–Horizontal	 12663–Vertical
	12661– Horizontal	12661–Vertical	12663–Horizontal	12663–Vertical
Cutting Sliding Frame	X_1+6	X_1+6	X_1+6	X_1+6
Cutting Sliding Sash 12671	$X+29$	$X-72$	$X-1$	$X-132$
Cutting Sliding Slim Sash 12678	—	$X-154$	—	$X-214$
Glass Sliding Sash 12671	X_2-115	$X-216$	X_2-145	$X-276$
Glass Fixed Sliding Fix Glass	X_2-54	$X-94$	X_2-84	$X-154$
Sliding Fix Transom 12678	—	$X-84$	—	$X-144$



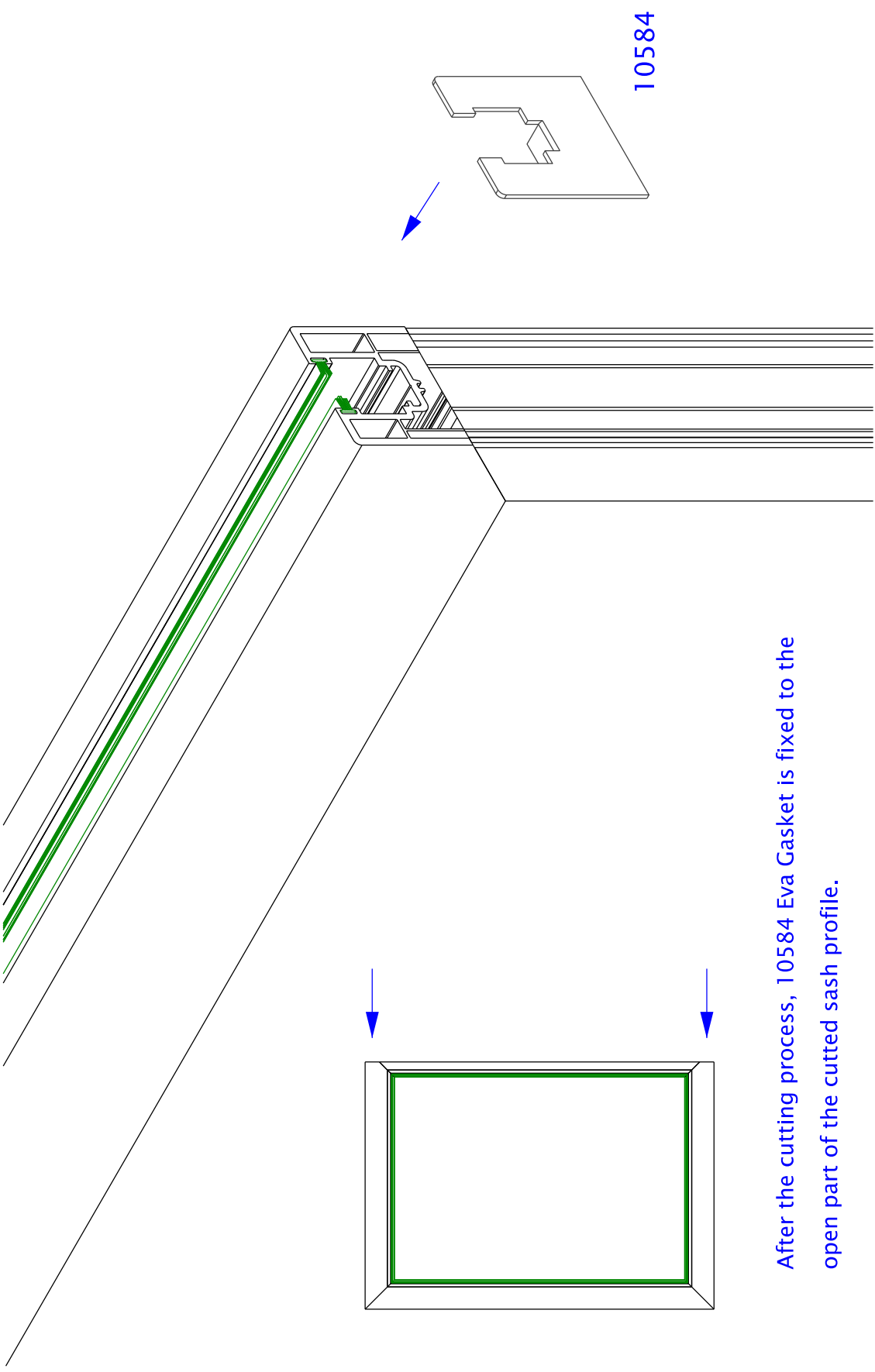
The 12678-Slim Sash Profile is welded to the C-shaped welded 12671-Sash Profile as shown above. During the welding process, an additional 39 mm support should be placed behind the 12678 profile.

The welded corner of 12671 and 12678 can be cleaned with a 39 mm support.

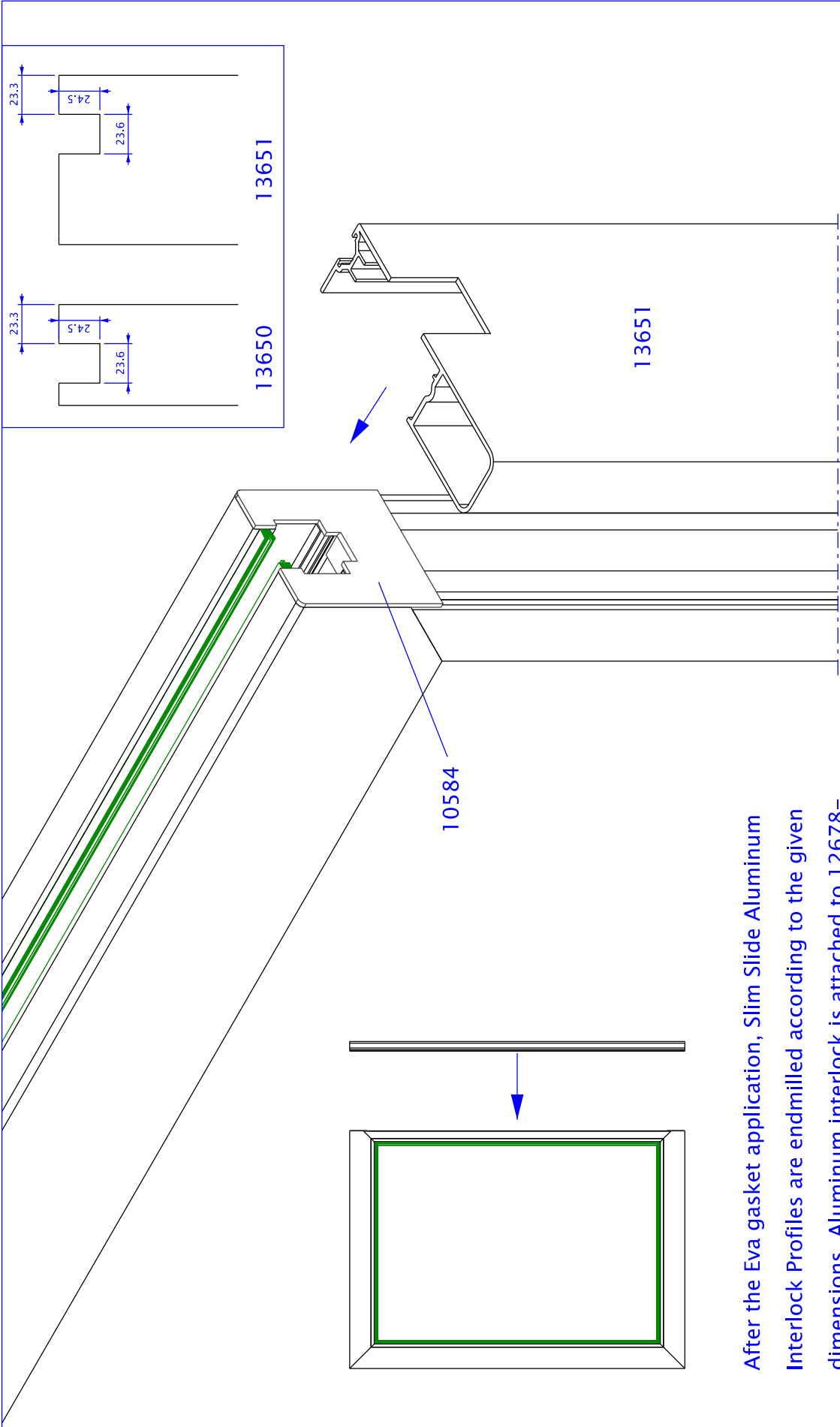




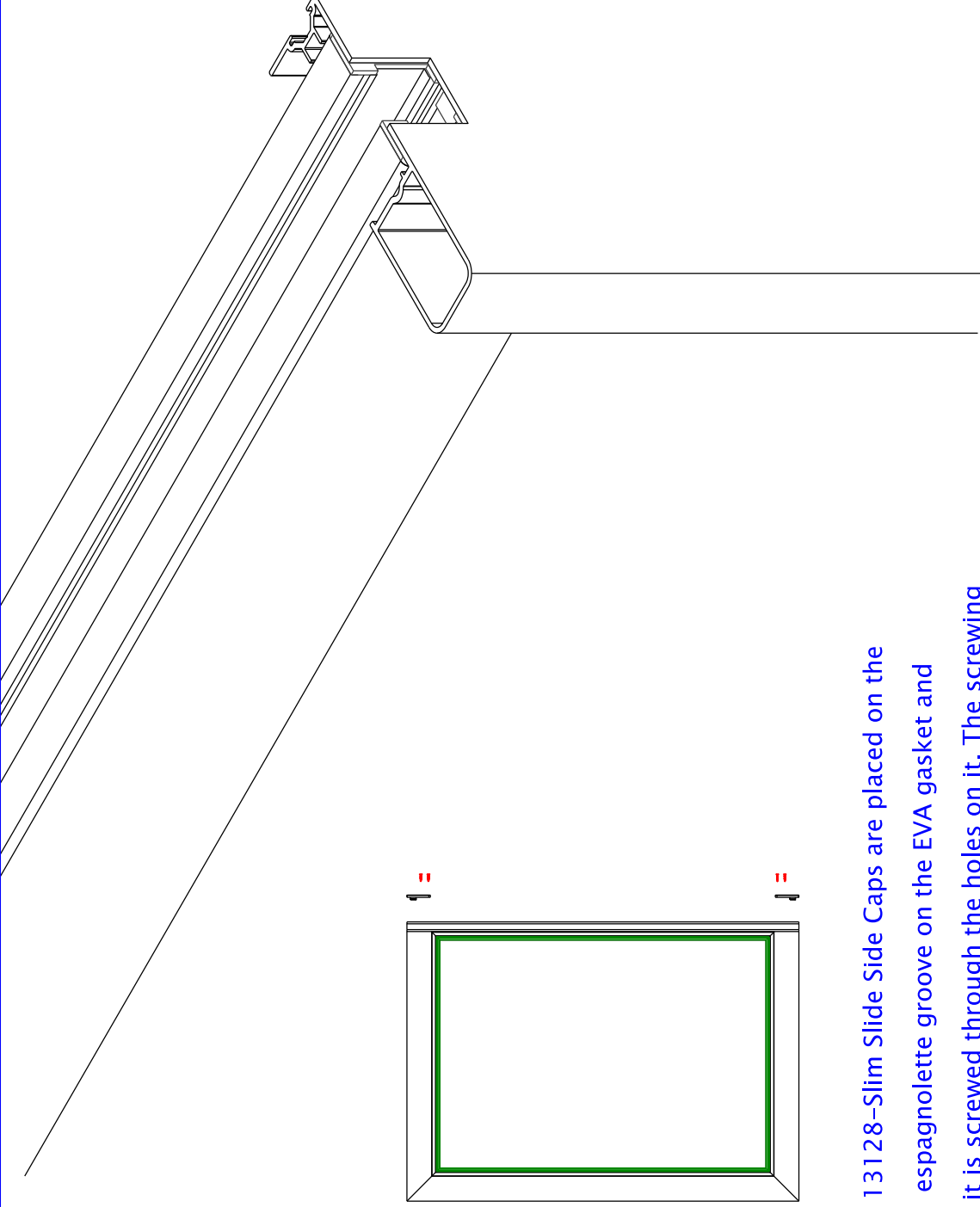
After the welding process, the excess parts of the sash profiles are cut off.



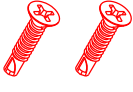
After the cutting process, 10584 Eva Gasket is fixed to the open part of the cutted sash profile.



After the Eva gasket application, Slim Slide Aluminum Interlock Profiles are endmilled according to the given dimensions. Aluminum interlock is attached to 12678-Slim Sash Profile as shown.

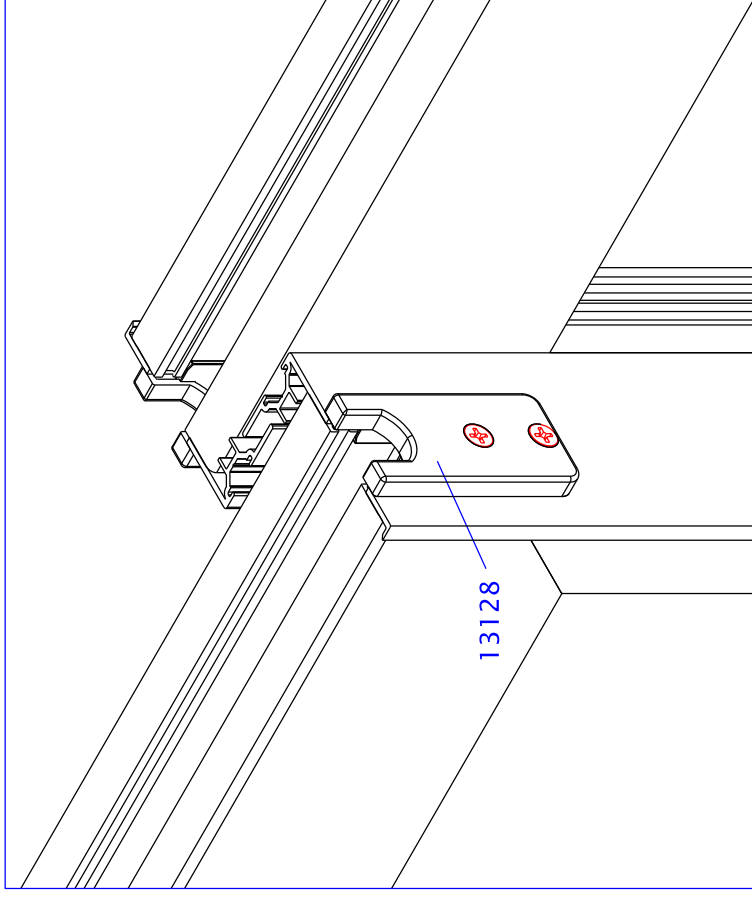
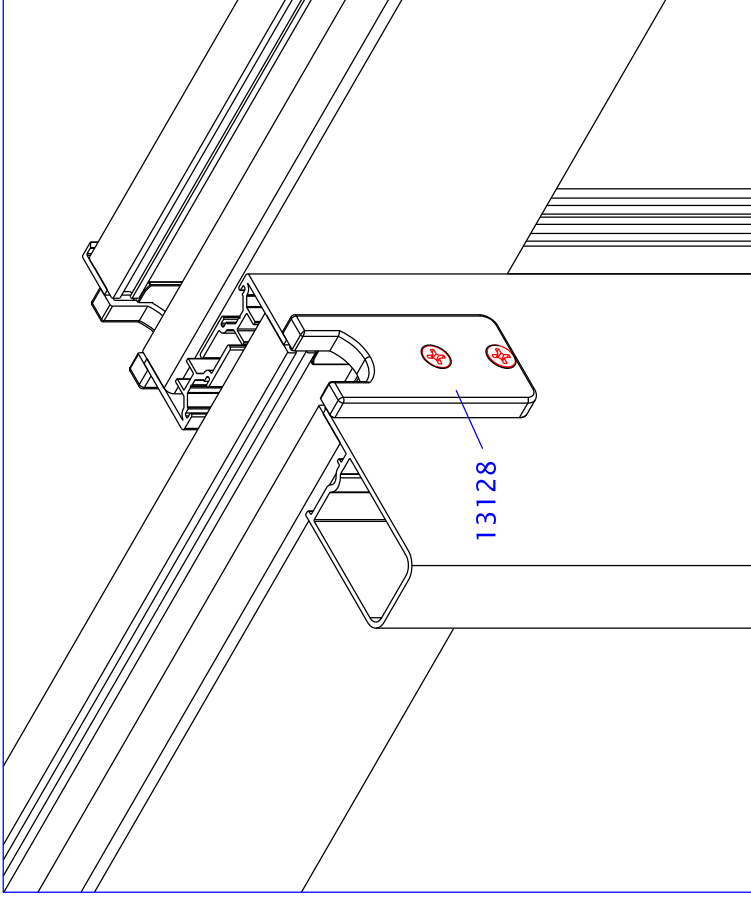


13128

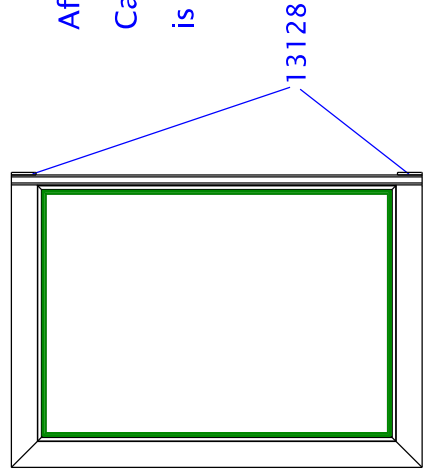


13011
3.9*25

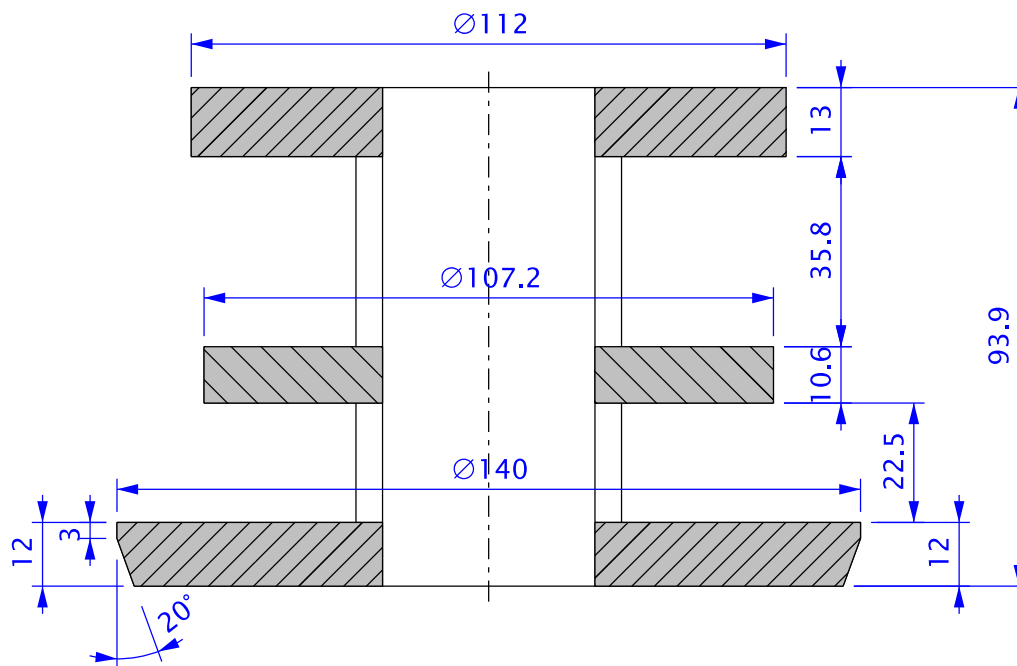
13128-Slim Slide Side Caps are placed on the espagnolette groove on the EVA gasket and it is screwed through the holes on it. The screwing process also fixes the aluminum interlock profiles on the 12678 profile.



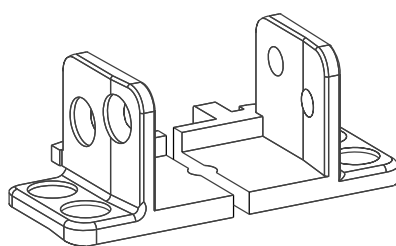
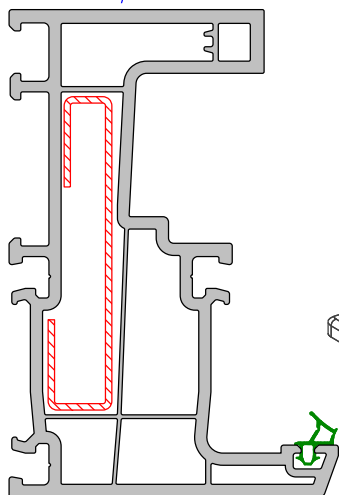
After the 13128-Slim Slide Side
Caps are attached, the production
is completed.



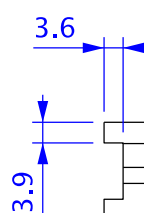
13795-Endmilling of Sliding Transom



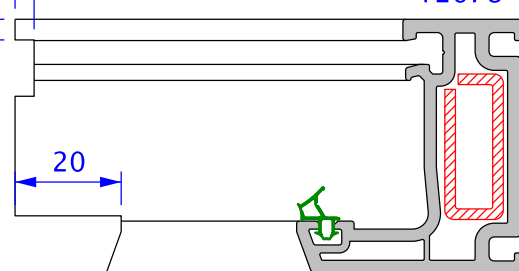
12661/12663

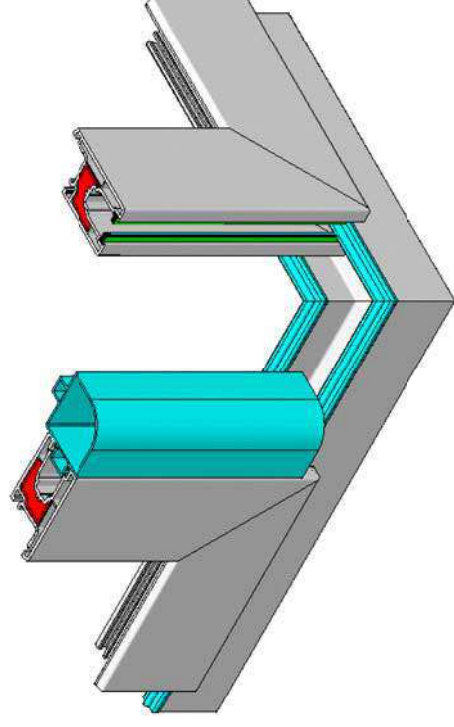
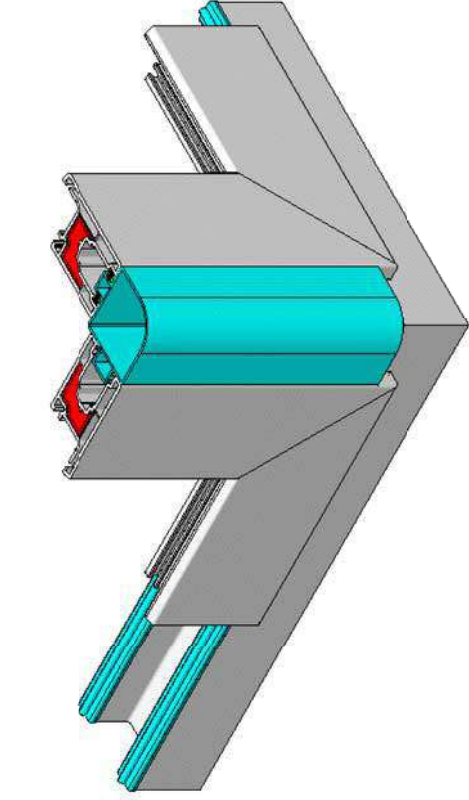
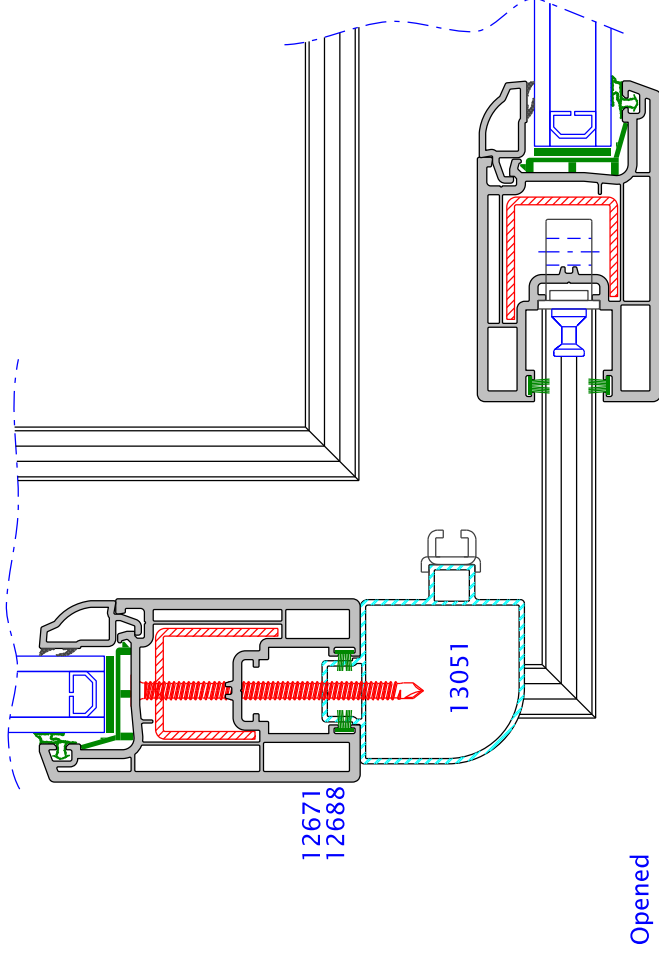
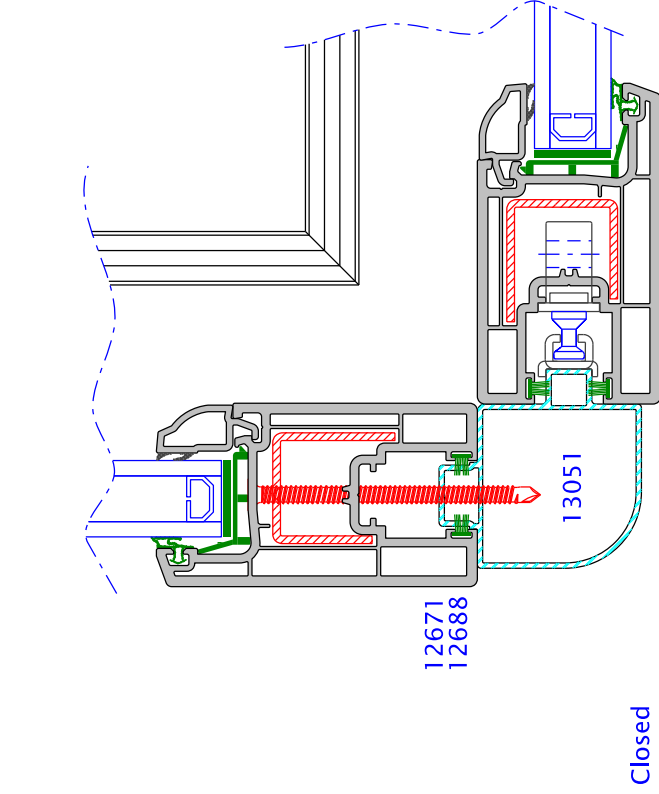


10551
=>12678



12678

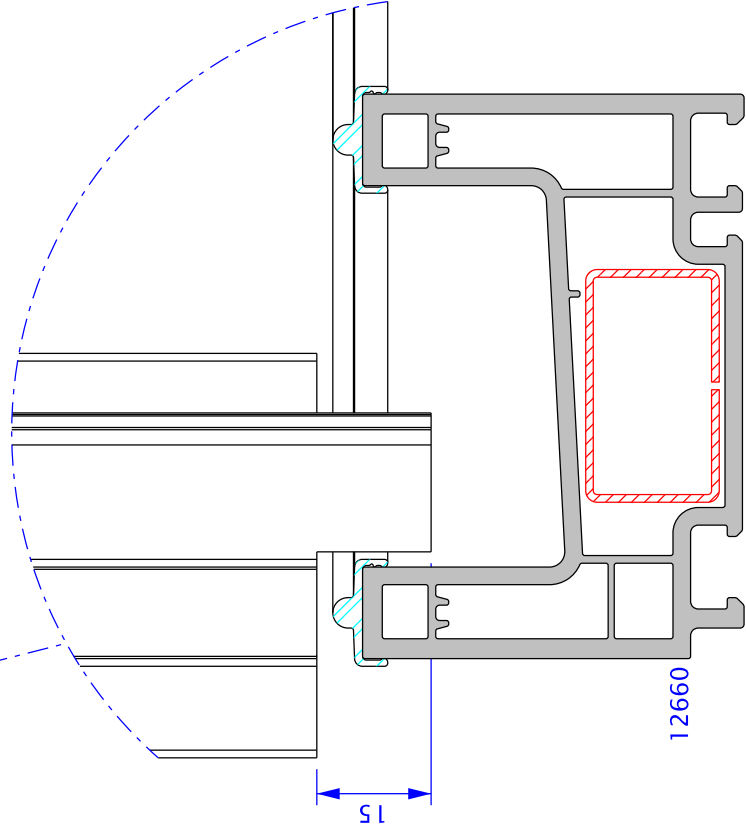
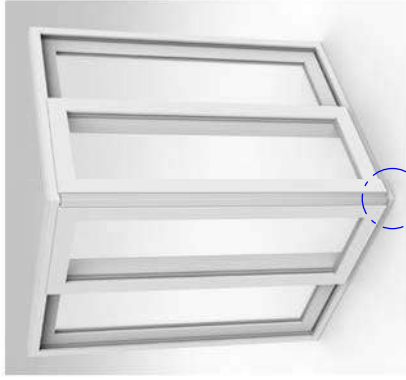




* In the case of Alfresco sliding applications , aluminium sliding 90° (13051) can be used on corners as vertically,

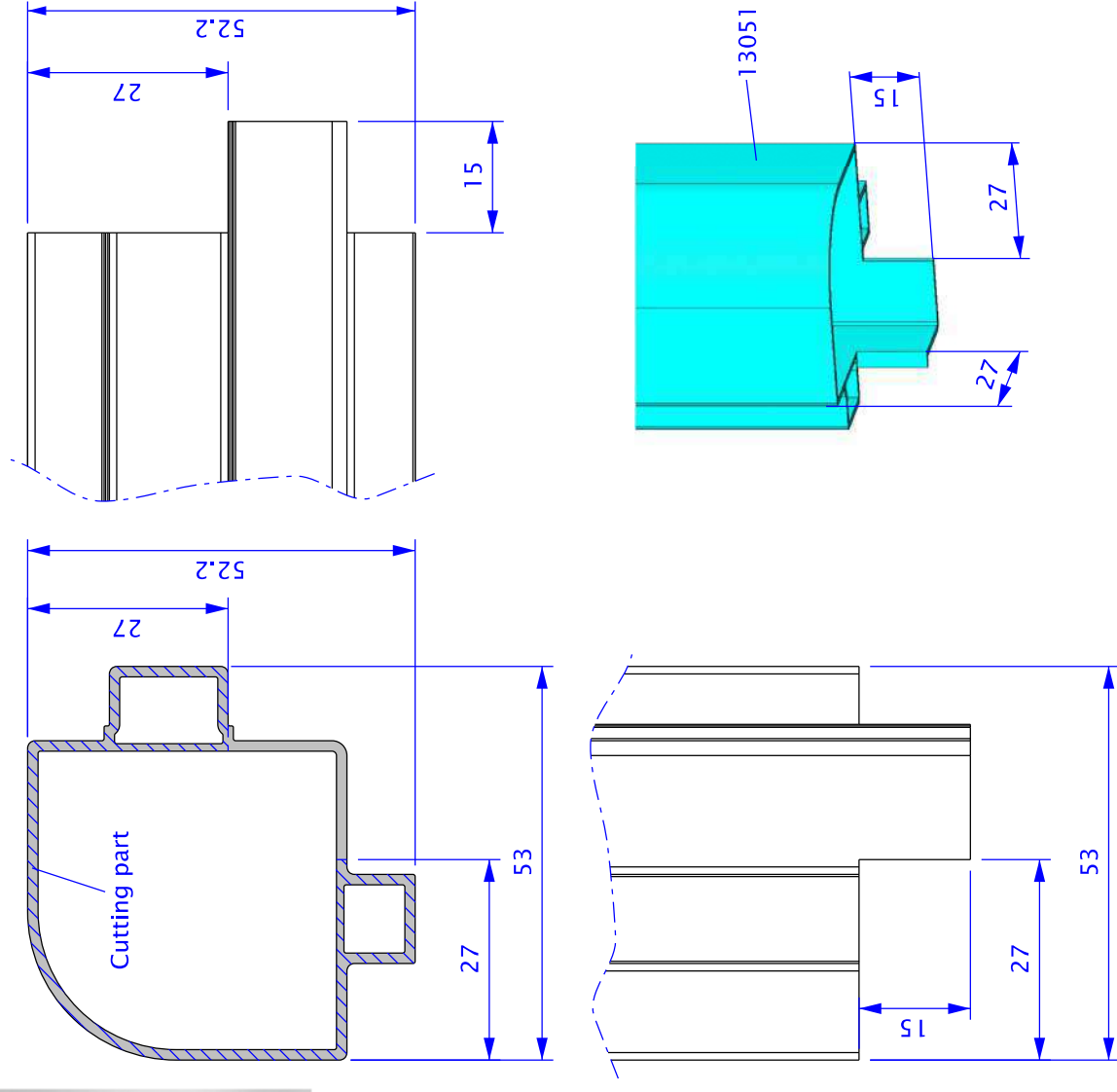
* There is no vertical sliding frame on the corner in this application, 13051 which is fixed on other sliding sash profile on the corner.

* Sliding strikers are fixed on 13051.



*The drawing shows bottom side of the aluminium profile ,

*The horizontal mirror of freed dimensions are also used on top part .

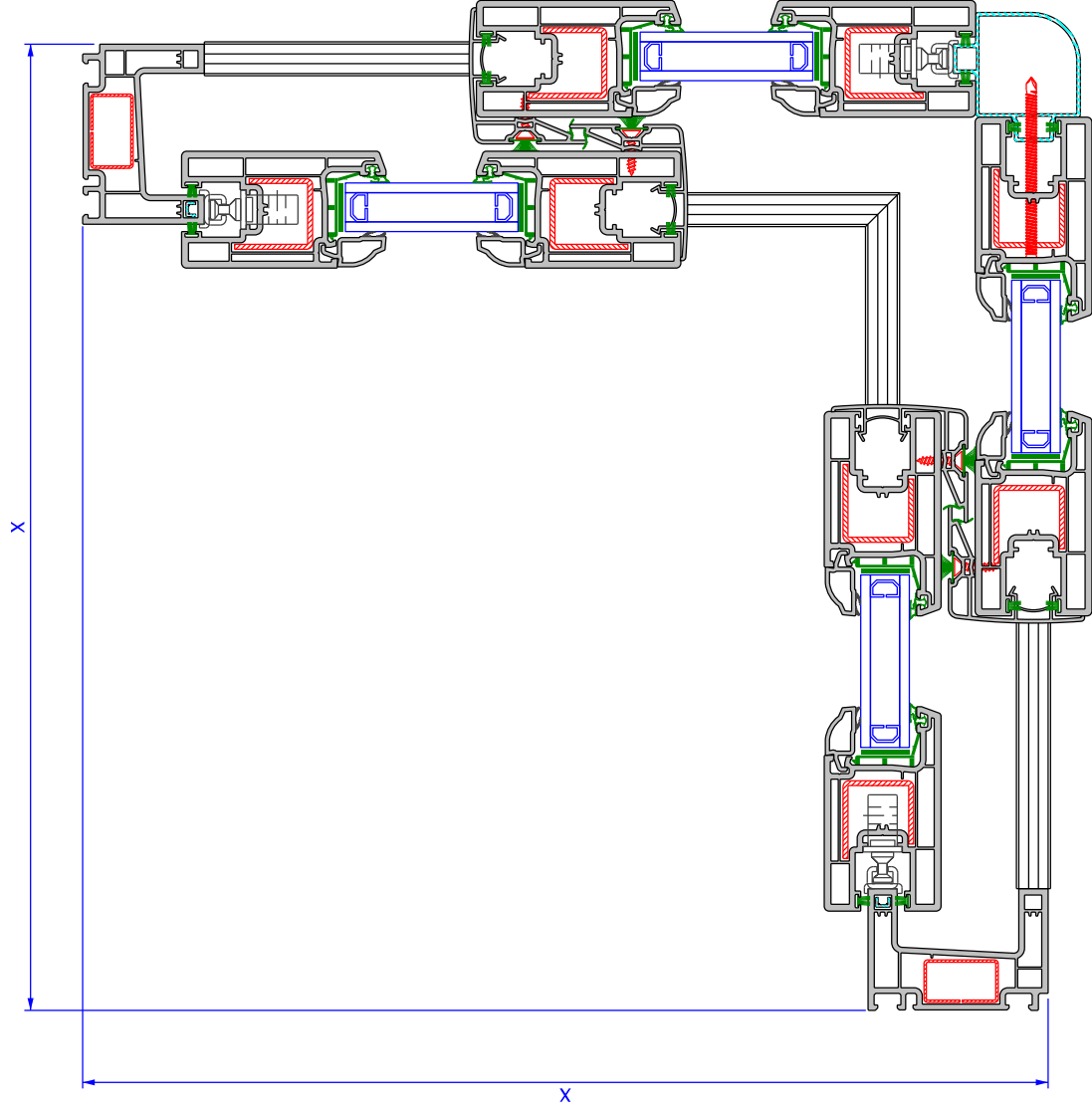




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DIFFERENT SLIDING APPLICATION

Alfresco – Sash locking outside (2 tracks frame)



	Width	Height 12660 Sliding Frame	Height 13030 Alu. Frame
12670 Sliding Window Sash	$\frac{X+9}{2}$	X-76	X-48
12671 12688 Sliding Sash	$\frac{X+25}{2}$	X-76	X-48

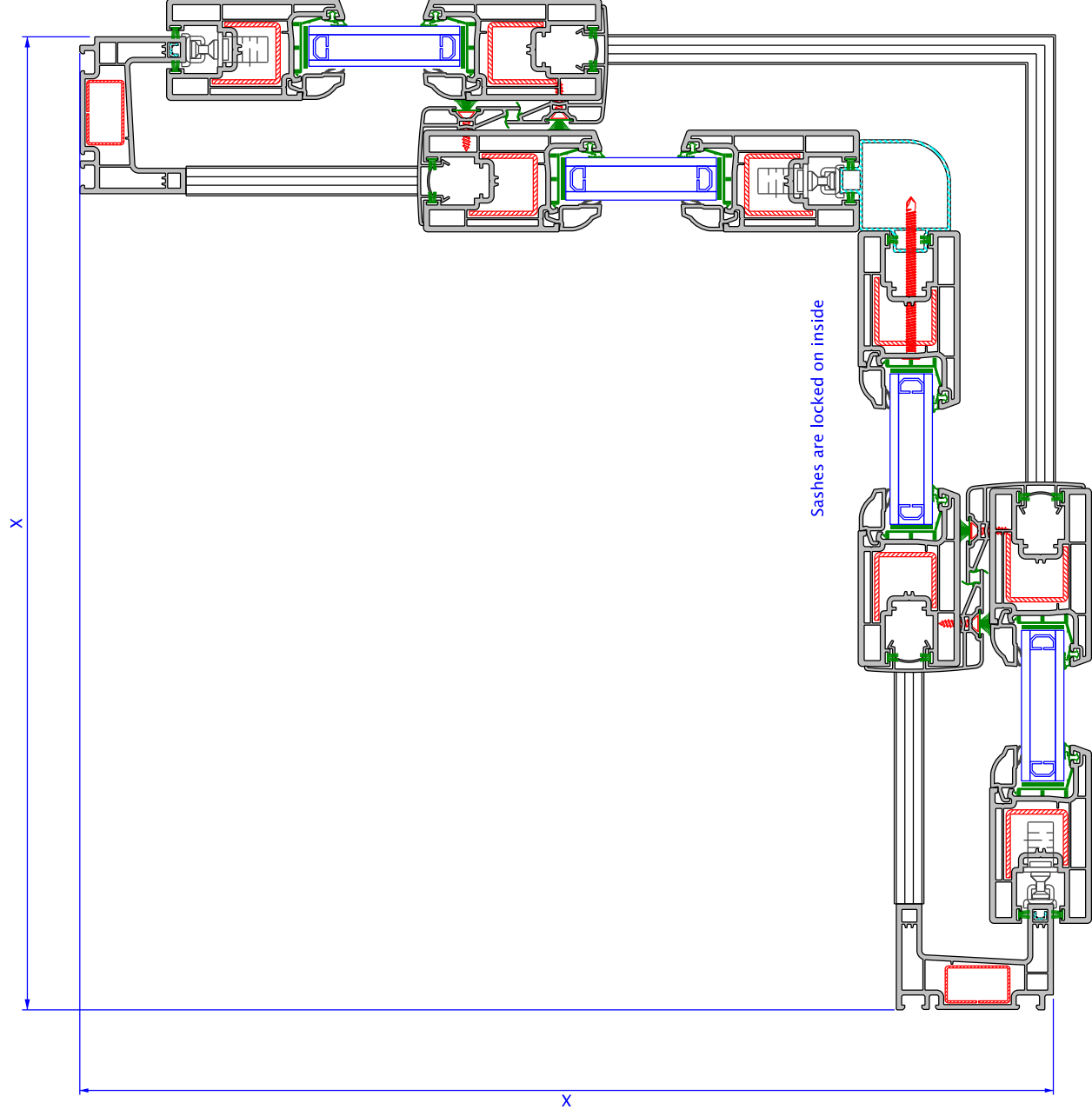
*Welding thickness is included.



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VE PAZARLAMA A.Ş.

DIFFERENT SLIDING APPLICATION

Alfresco – Sash locking inside (2 tracks frame)



	Width	Height 12660 Sliding Frame	Height 13030 Alu. Frame
12670 Sliding Window Sash	$\frac{X-53}{2}$	X-76	X-48
12671 12688 Sliding Sash	$\frac{X-37}{2}$	X-76	X-48

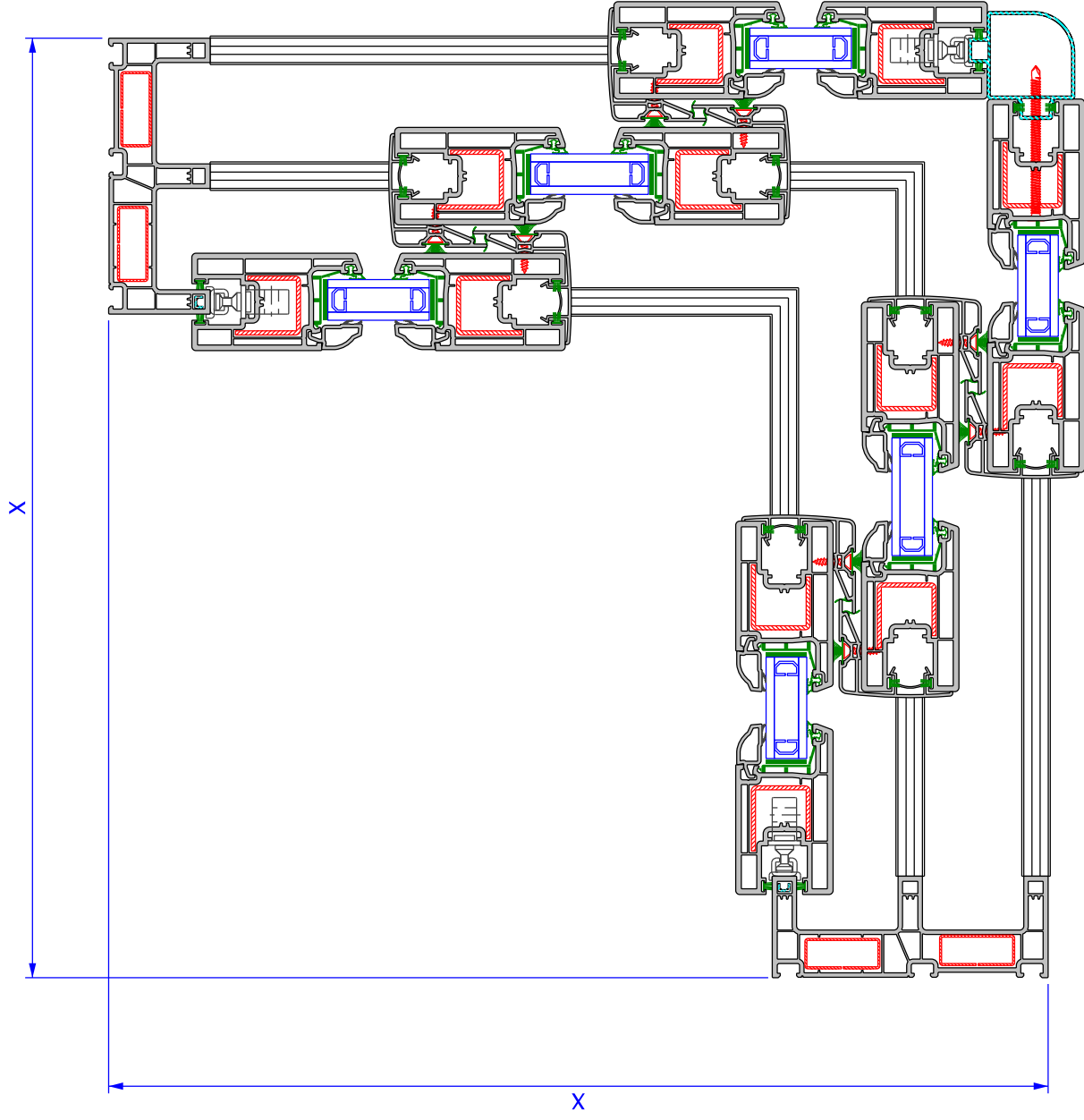
*Welding thickness is included.

DIFFERENT SLIDING APPLICATION

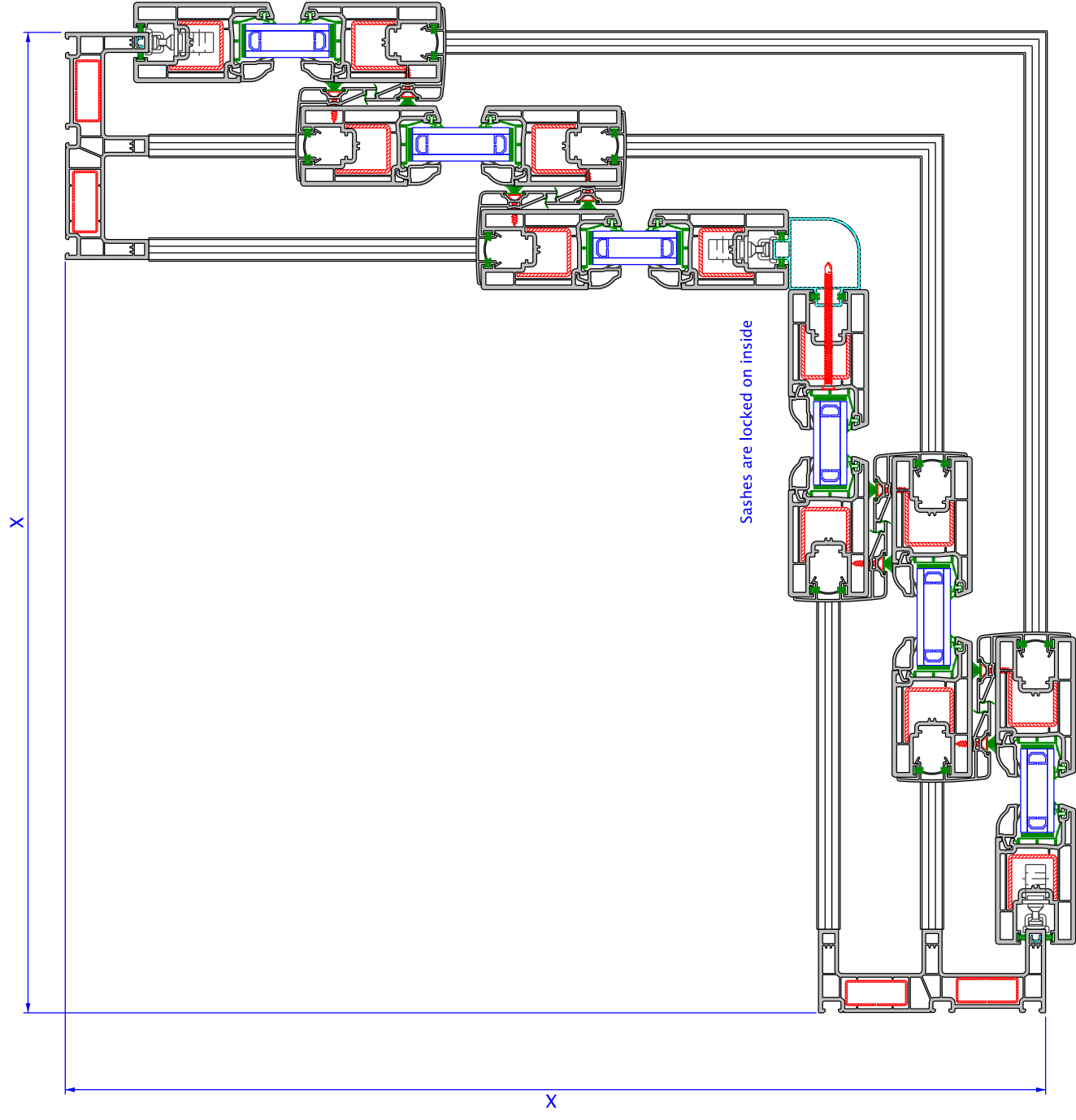
Alfresco – Sash locking outside (3 tracks frame)

	Width	Height
12670 Sliding Window Sash	$\frac{X+83}{3}$	12664 Sliding 3 tracks Frame
12671 12688 Sliding Sash	$\frac{X+115}{3}$	X-76

*Welding thickness is included.

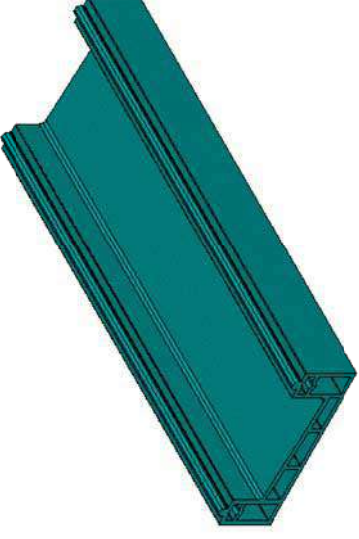
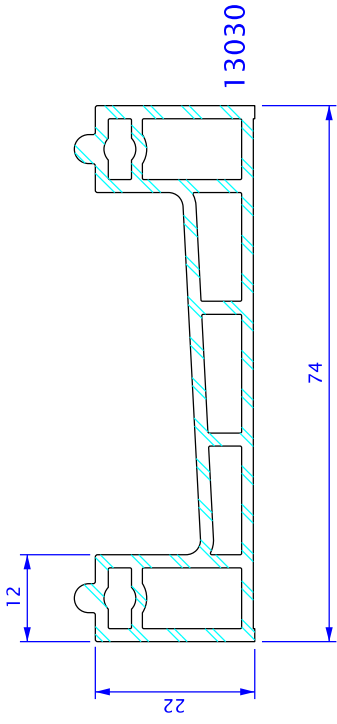


Sashes are locked on outside



	Width	Height
12670 Sliding Window Sash	$\frac{X-41}{3}$	12664 Sliding 3 tracks Frame
12671 12688 Sliding Sash	$\frac{X-9}{3}$	X-76

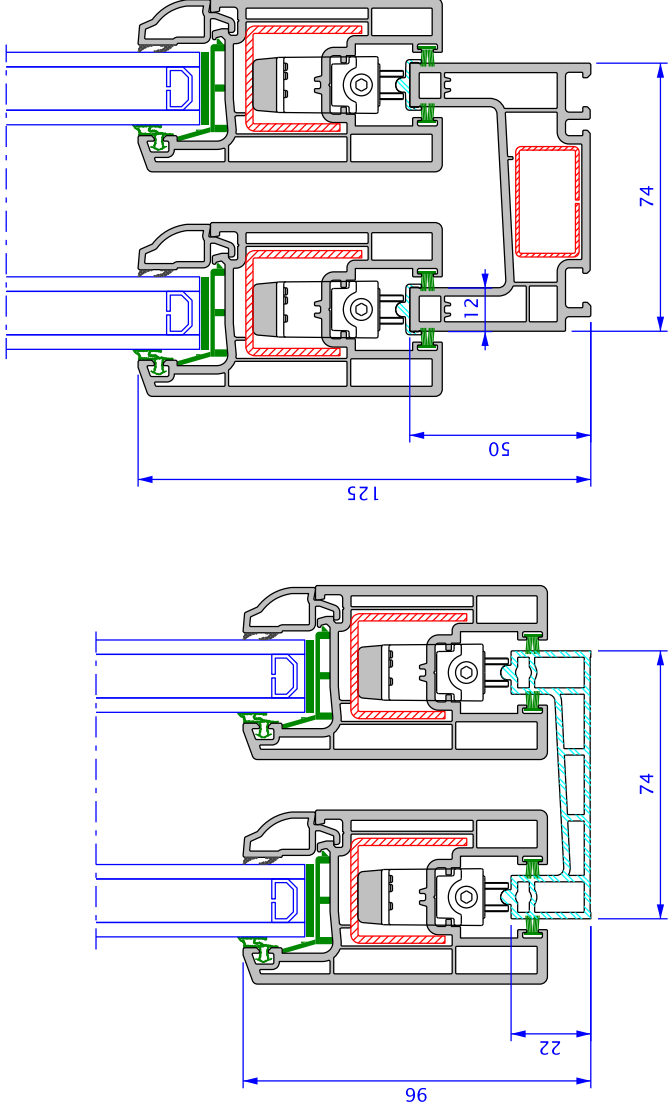
*Welding thickness is included.



*Sliding aluminium bottom frame has 22 mm height that is lower than 12660 (50 mm).It has an advantage with low threshold as visually at the bottom

*Since the bottom frame material is aluminium, the sash works stable although there is any ground disorder.

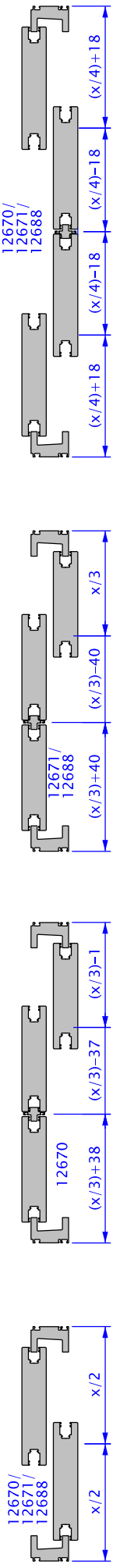
*The design of aluminium frame includes aluminium rail. Therefore , there is no need to use additional rails.



DIFFERENT SLIDING APPLICATION

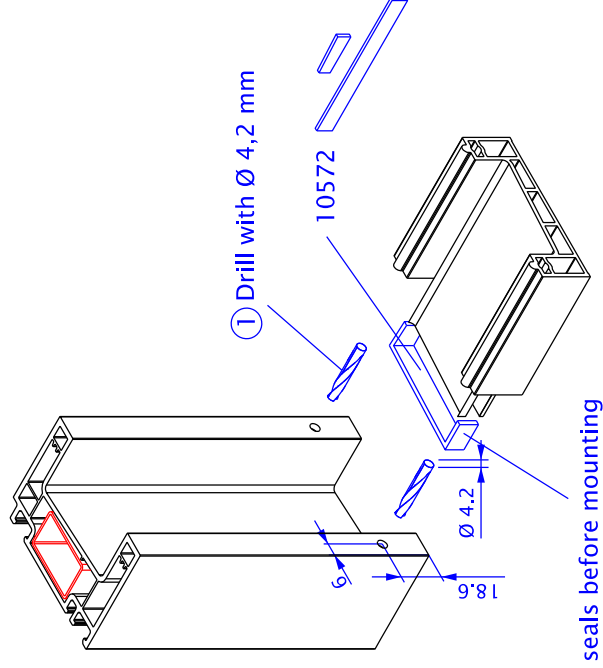
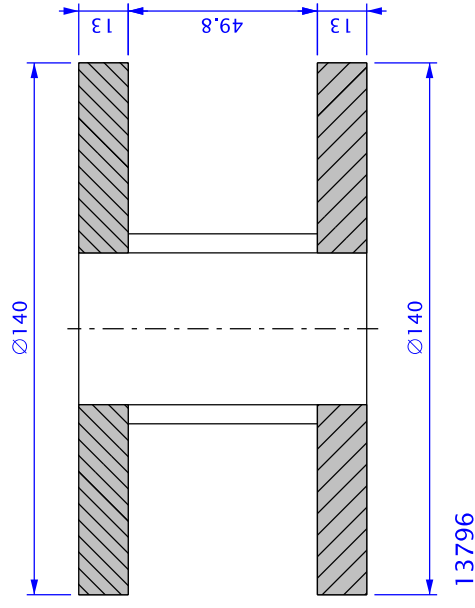
Cutting Sizes of 13030–Sliding Aluminium Frame / 12660–Sliding Frame

Axe Calculation : In the application of 12660,vertical axes should be determined as shown below.

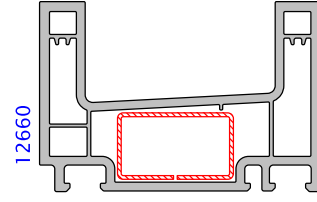


The sash overlap is 9 mm.

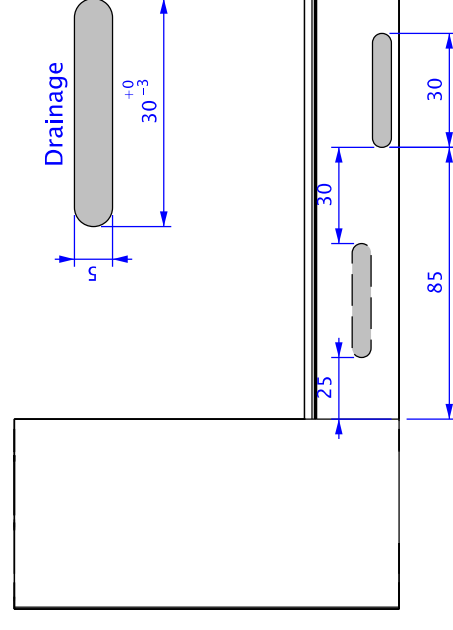
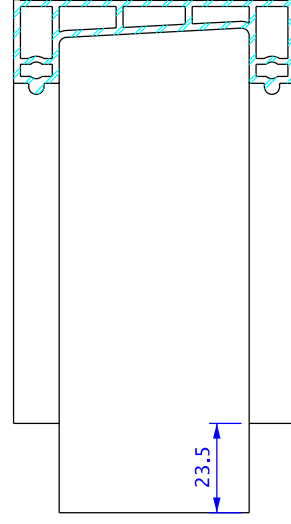
Welding thickness is included		Dimension																																																																																																																																																	
Cutting Sliding Frame	12660		X+6 (45°)		X+6 (45°)	X+3 (45°-90°)																																																																																																																																													



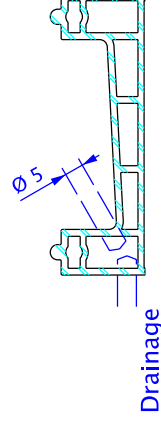
④ Use the seals before mounting frame.

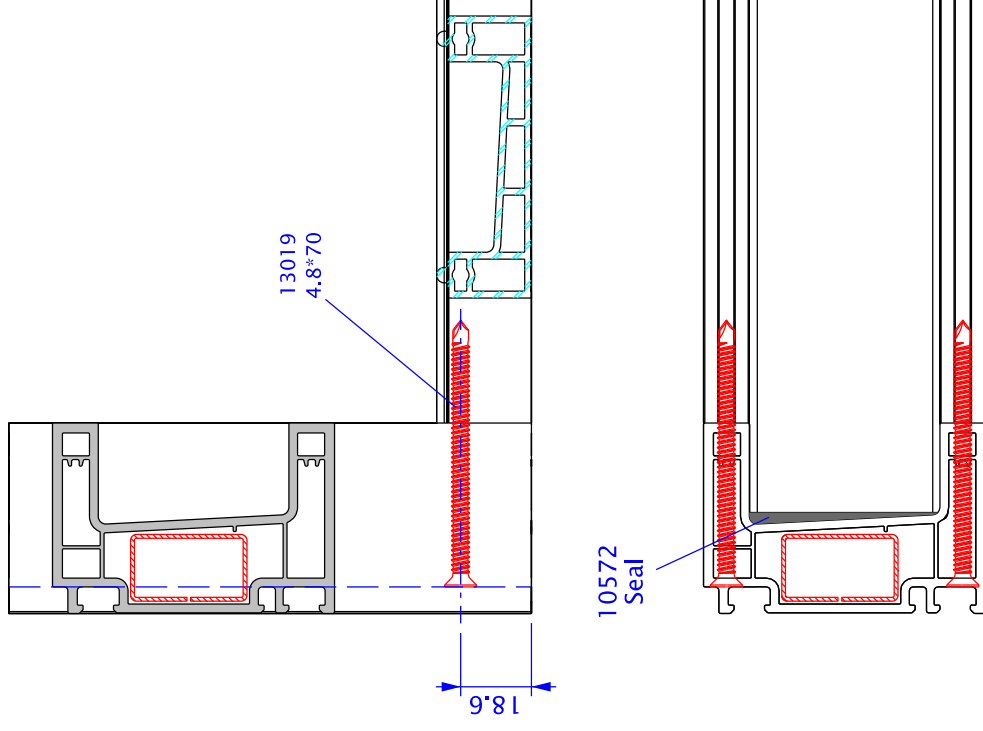
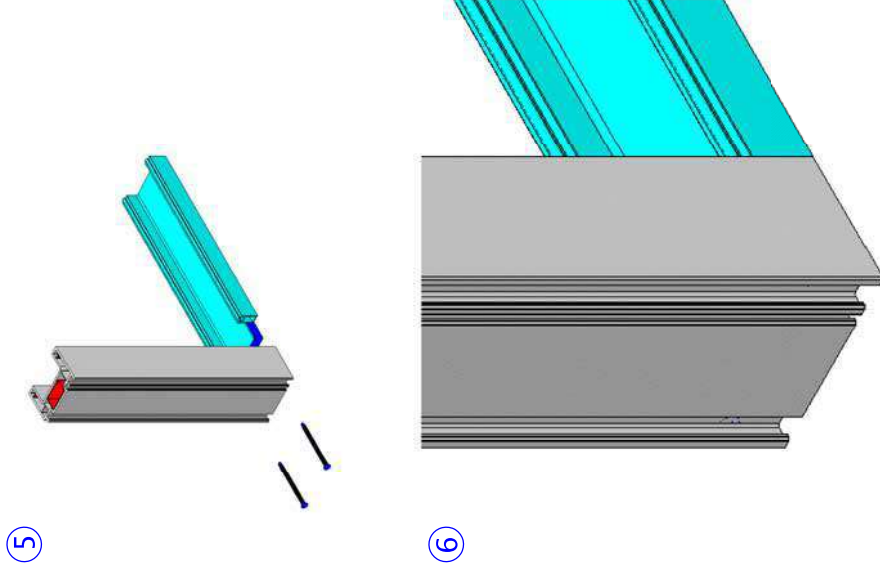
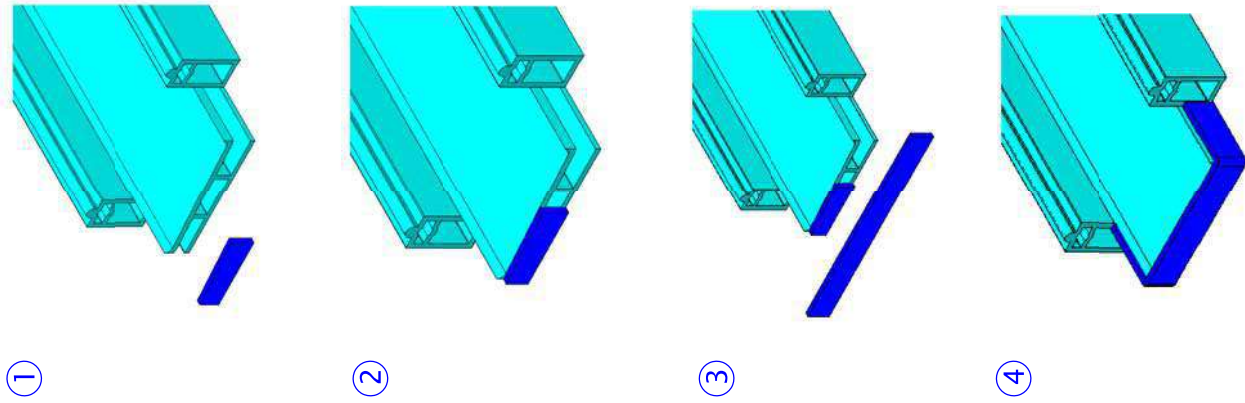


② 13030 Is end-milled with 13796

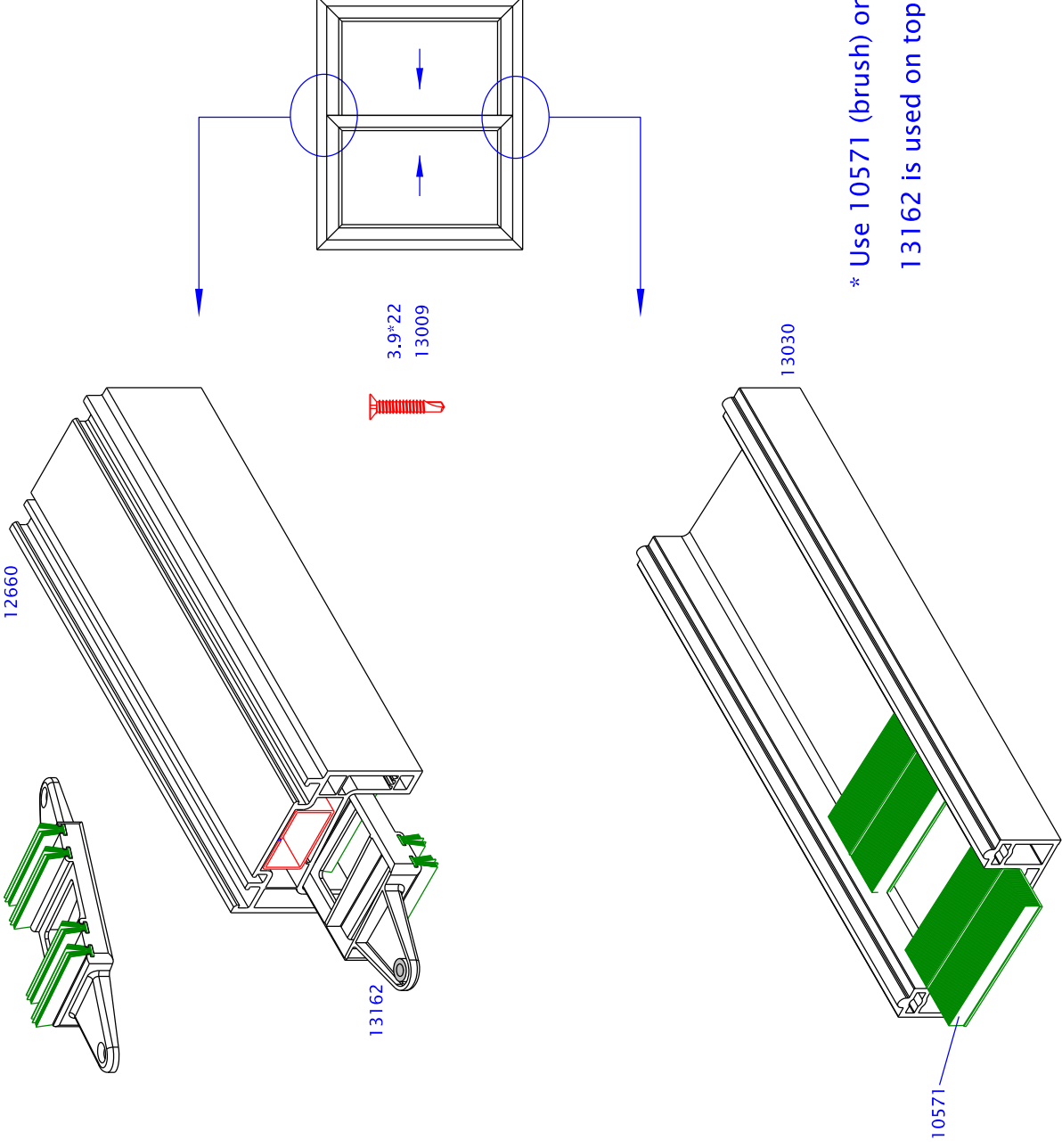


③ Open the drainage holes.



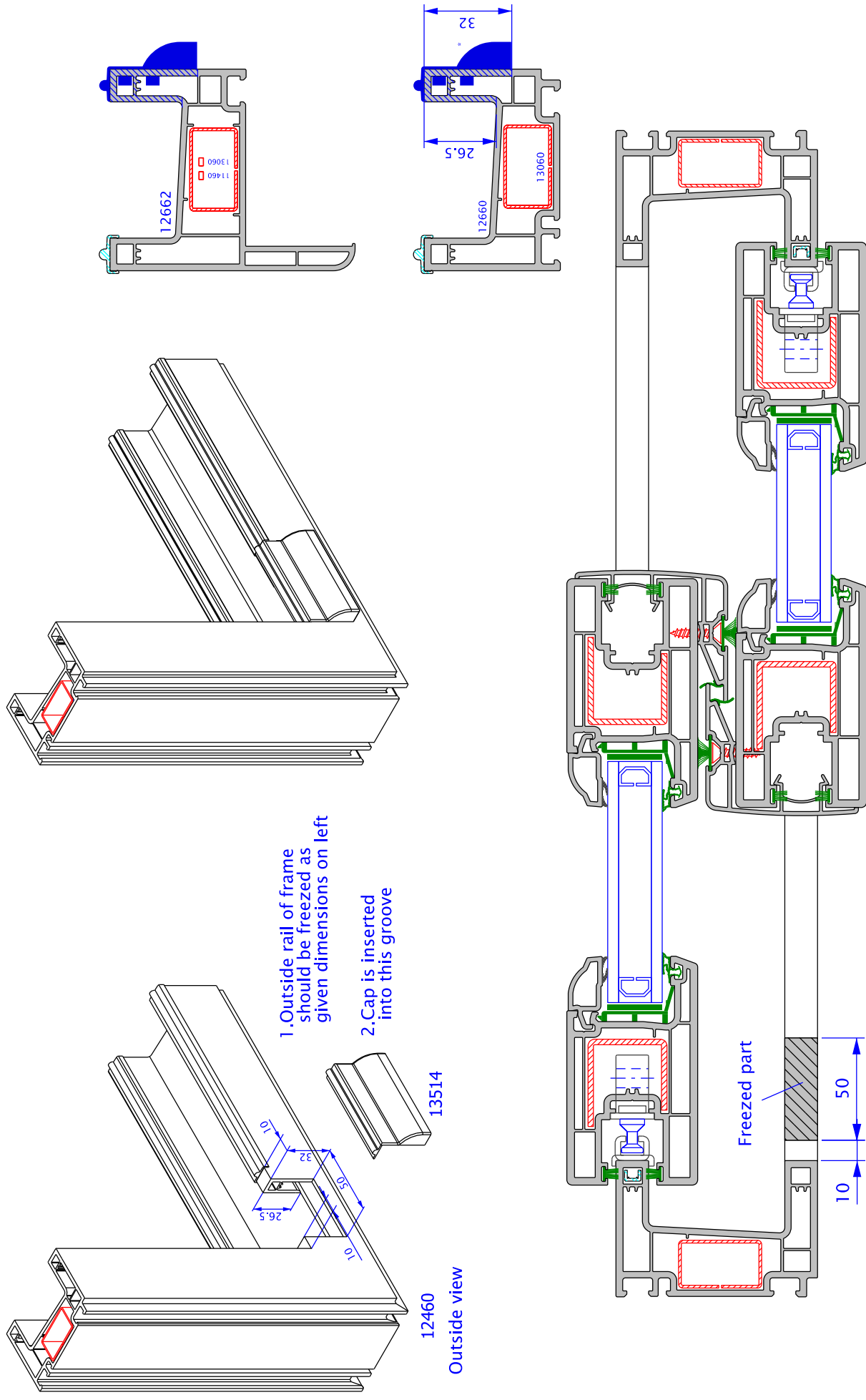


* After the end-milling is finished, seals are bonded to the frame on both sides.
Then , the aluminium profile is fixed to vertical sliding frames from outside.



* Use 10571 (brush) on aluminium frame at the bottom.
13162 is used on top side of frame as standart.

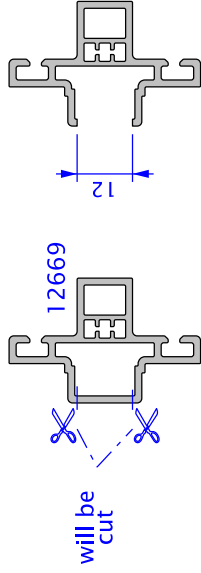
In sliding windows/doors , 13514-sliding water drainage cap can be used to have advantage of faster water discharge.



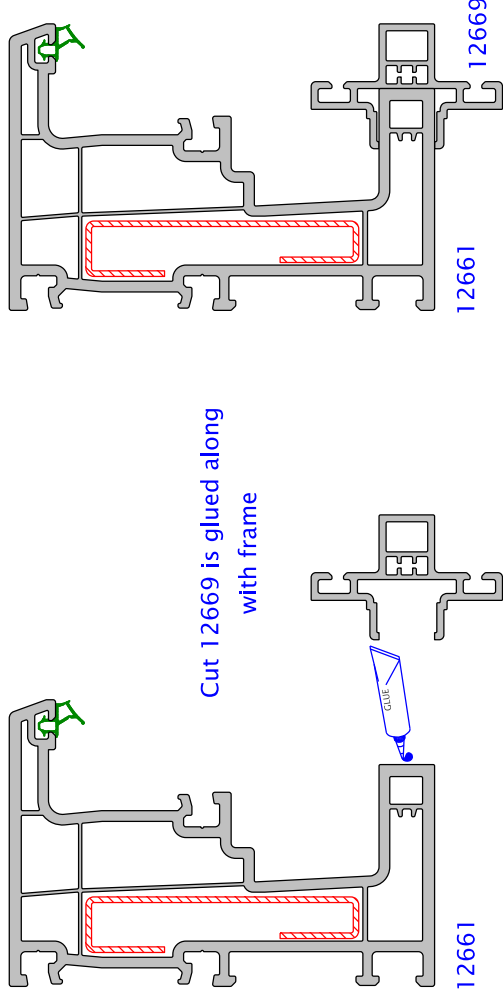
DIFFERENT SLIDING APPLICATION

Locking Esp. Applications with 12669

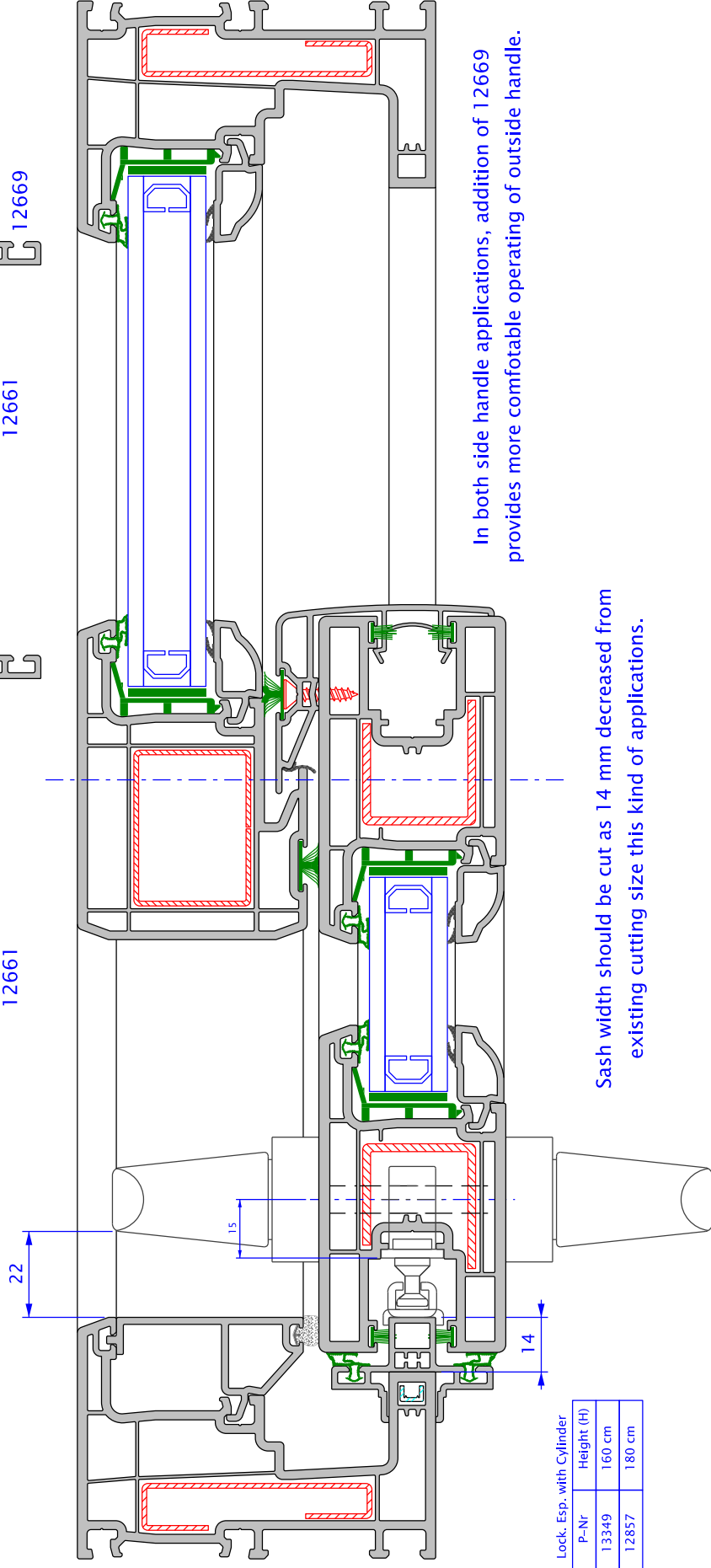
12669–Sliding Sash Coupling profile is cut as 96 mm decreased from 12661 height and 156 mm from 12663, according to frame options.



Cut 12669 is glued along with frame

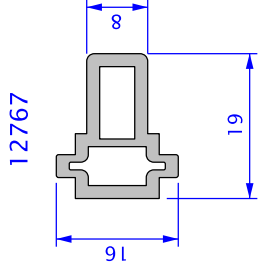
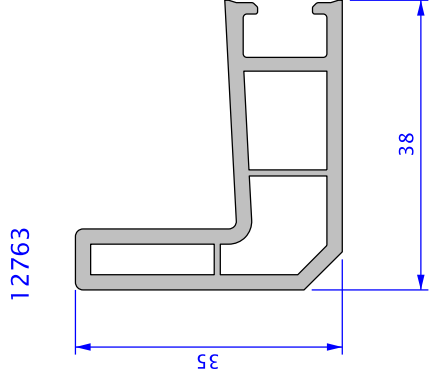
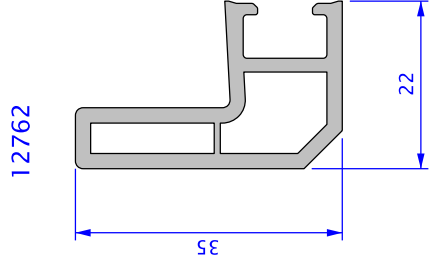
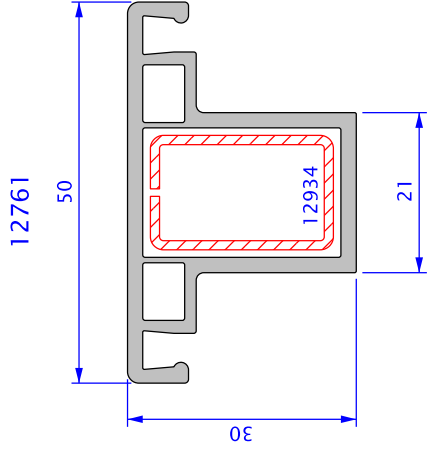
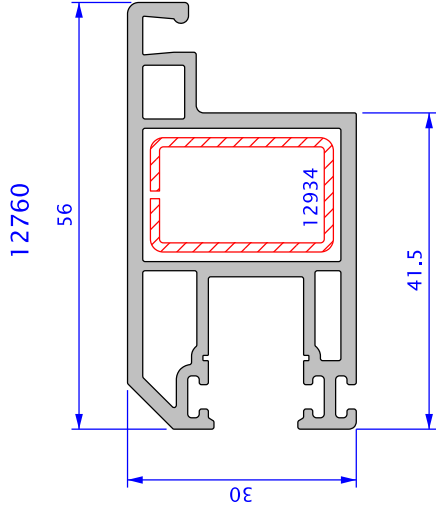


12669 sash coupling profile is cut as given in the figure

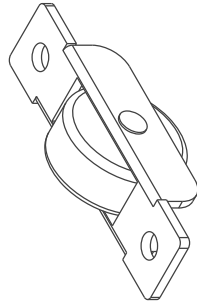


Lock. Esp. with Cylinder

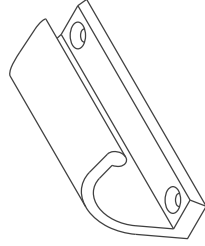
P-Nr	Height (H)
13349	160 cm
12857	180 cm



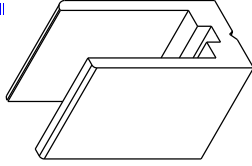
13132



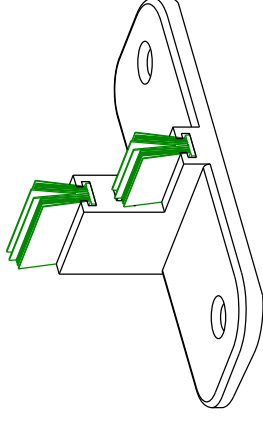
12866



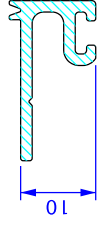
12973
=> 12671



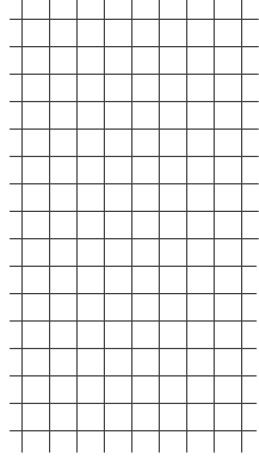
13131



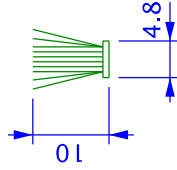
11529
=> 12760



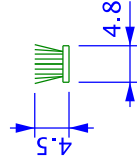
12820



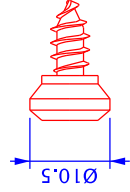
13133



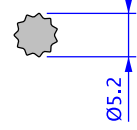
841



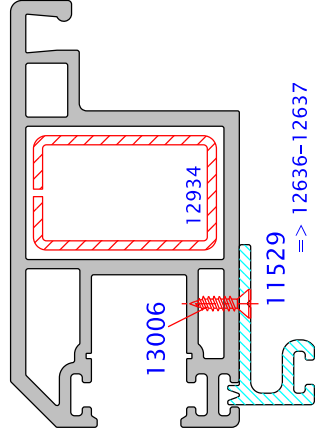
933



12965



12760

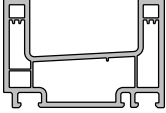

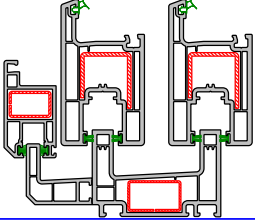
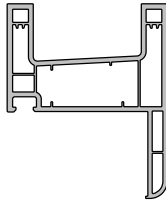

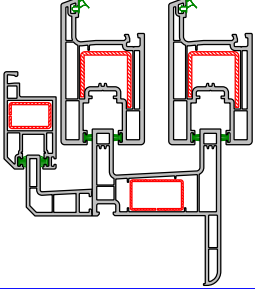
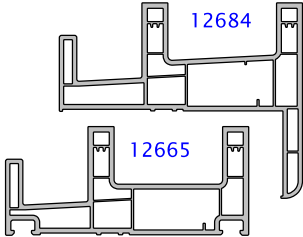
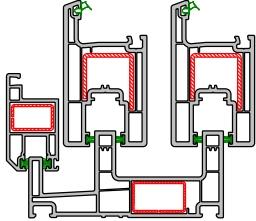
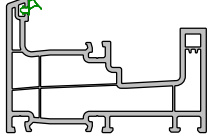

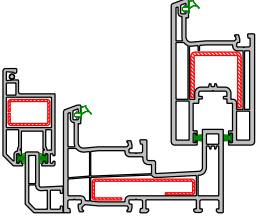
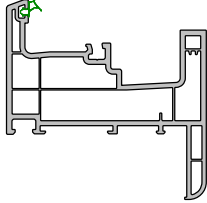

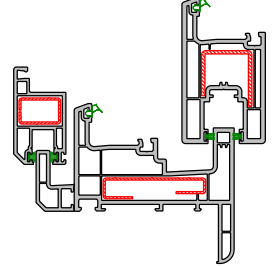
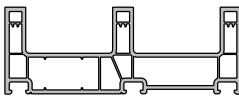

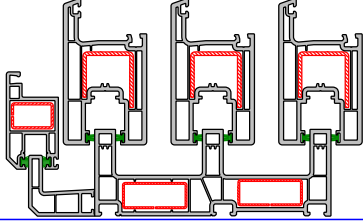
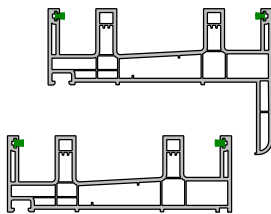

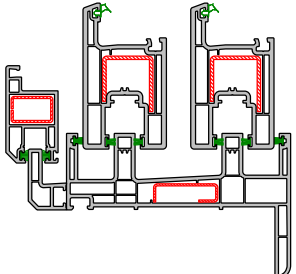


Sliding flyscreen rail must be chosen depending on the sliding frame.

There are 2 types of sliding flyscreen rails :

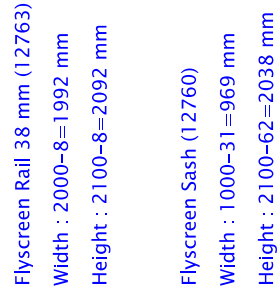
* Sliding flyscreen 22 mm

* Sliding flyscreen 38 mm

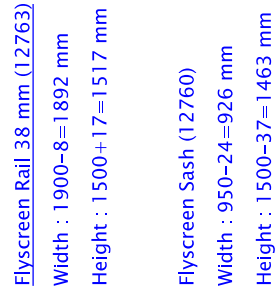
PVC	Flyscreen Rail	Application
12660 	12763 	
12662 	12763 	
12684 12665 	Flyscreen Rail is existing on the frame profile	
12661 	12762 	
12663 	12762 	
12658 	12763 	
	12762 	

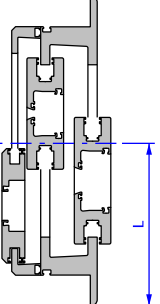
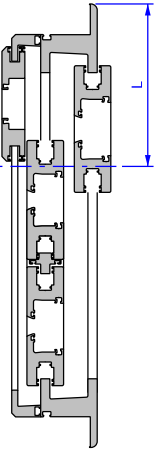
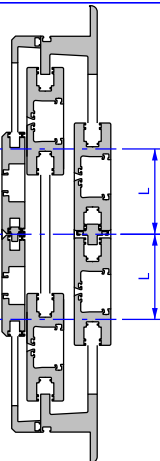
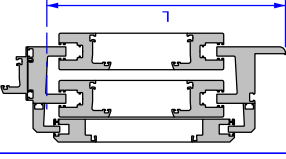
SLIDING FLYSCREEN CALCULATION :

Sliding Frame (12660), Sliding Sash (12671)



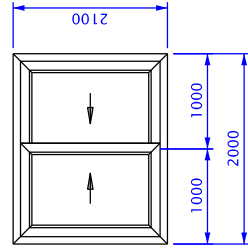
Sliding Frame (12660) , Sliding Window Sash (12670)



Welding thickness is included in sash calculations.	WIDTH			Transom to Transom
	Dimension			
				
12763 Flyscreen Rail 38mm			Width and Height $L - 8$	Width and Height $L + 17$ L + 42
SLIDING FLYSCREEN CALCULATION :				
12670 Sliding Window Sash	L - 71	L - 71	L - 128	Height L - 12
12671 Sliding Door Sash	L - 78	L - 78	L - 128	Height L - 12

EXAMPLE :

Sliding Architrave Frame (12662) , Sliding Door Sash (12671)

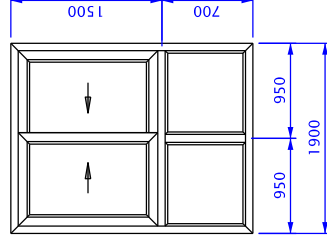


Flyscreen Rail 38 mm (12763)
Width : 2000-74=1926 mm
Height : 2100-74=1926 mm

Flyscreen Sash (12760)
Width : 1000-78=922 mm
Height : 2100-128=1972 mm

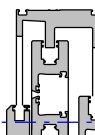
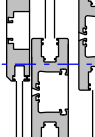
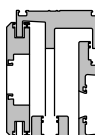
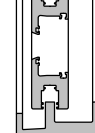

EXAMPLE :

Sliding Architrave Frame (12662) , Sliding Window Sash (12670)



Flyscreen Rail 38 mm (12763)
Width : 1900-74=1826 mm
Height : 1500-16=1484 mm

Flyscreen Sash (12760)
Width : 950-71=879 mm
Height : 1500-70=1430 mm

<div> <div>Welding thickness is included in the calculations</div> <div>Dimension</div> </div>	WIDTH				<div>HEIGHT (Frame to Frame)</div>
					

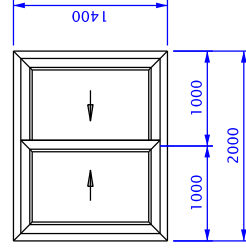
Cutting sizes of flyscreen sash :				Height
12670 Sliding Window Sash	L - 10	L - 10	L - 2	L - 48
12671 Sliding Sash	L - 17	L - 17	L - 9	L - 48

EXAMPLE :

Calculations are based on Sliding window sash (12670)

Frame : Sliding Frame with of Screen (12665)

Sash : Sliding Window Sash (12670)



Flyscreen Sash (12760)

Width : 1000-10=990 mm

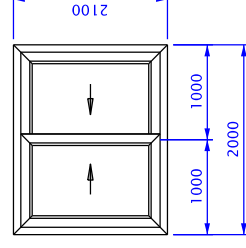
Height : $1400 - 48 = 1352$ mm

EXAMPLE :

Calculations are based on Sliding window sash (12671)

Frame : Sliding Frame with of Screen (12665)

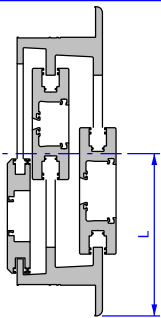
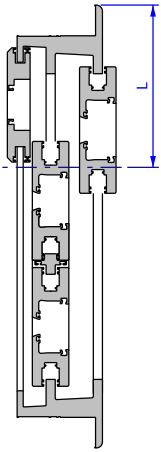
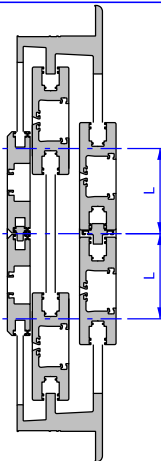
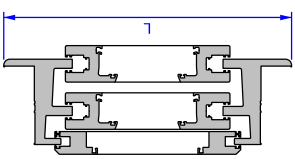
Sash : Sliding Sash (12671)



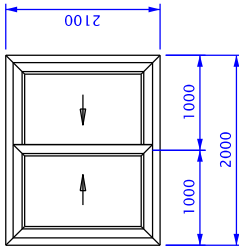
Flyscreen Sash (12760)

Width : $1000 - 17 = 983$ mm

Height : $2100 - 48 = 2052$ mm

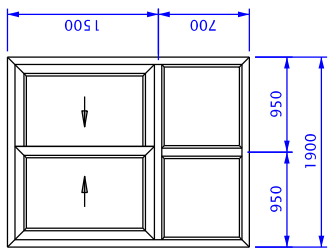
Welding thickness is included in the calculations		WIDTH			HEIGHT (Frame to Frame)
Dimension					
Cutting sizes of flyscreen sash :					
12670 Sliding Window Sash	L - 71	L - 71	L - 2	Height	
12671 Sliding Sash	L - 78	L - 78	L - 9	L - 128	

EXAMPLE :
Sliding Arc. Frame with Flyscreen (12684) , Sliding Door Sash (12671)

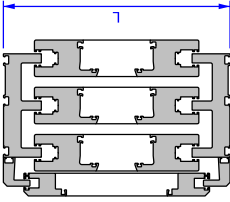
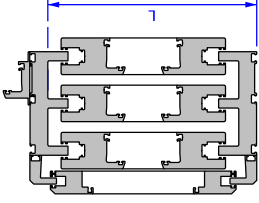
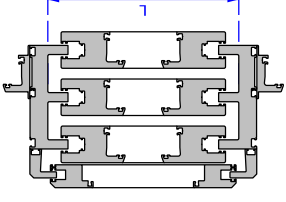
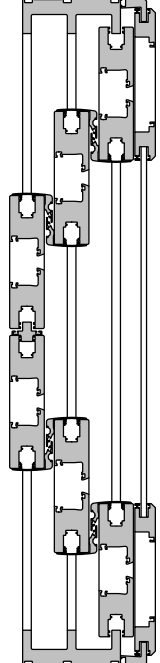
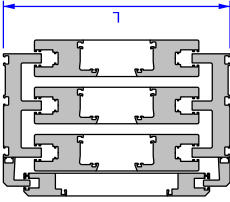
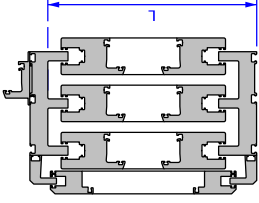
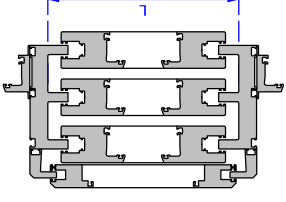
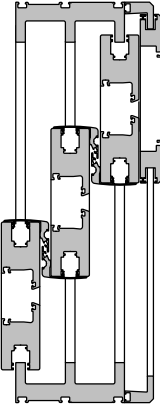
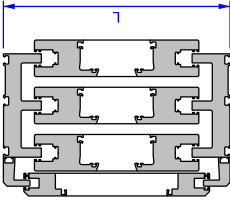
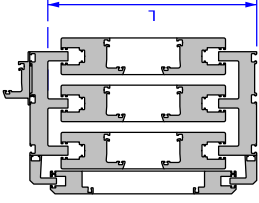
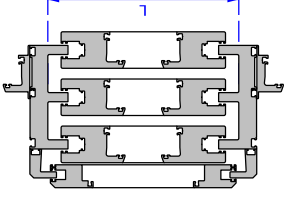


Flyscreen Sash (12760)
Width : 1000-78=922 mm
Height : 2100-128=1972 mm

EXAMPLE :
Sliding Arc. Frame with Flyscreen (12684) , Sliding Window Sash (12670)

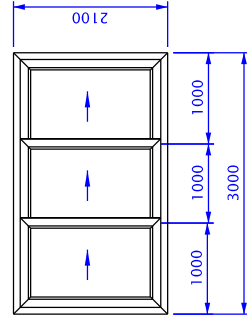


Flyscreen Sash (12760)
Width : 950-71=879 mm
Height : 1500-70=1430 mm

Welding thickness is included in sash calculations.	WIDTH	Frame to Frame	Frame to Transom	Transom to Transom
				
Dimension				
				
12763 Flyscreen Rail 38mm		Width and Height L + 6	Width and Height L + 31	Width and Height L + 56
SLIDING FLYSCREEN CALCULATION :				
12670 Sliding Window Sash	L - 17	Height L - 48	Height L - 23	Height L + 2
12671 Sliding Door Sash	L - 24	Height L - 48	Height L - 23	Height L + 2

EXAMPLE :

Sliding frame 3 rails (12664) , Sliding Door Sash (12671)

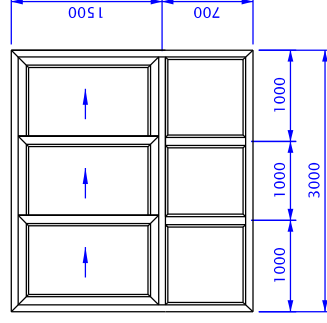


Flyscreen Rail 38 mm (12763)
Width : 3000+6=3006 mm
Height : 2100+6=2106 mm

Flyscreen Sash (12760)
Width : 1000-24=976 mm
Height : 2100-48=2052 mm

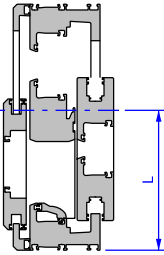
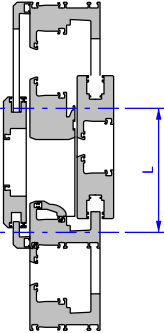
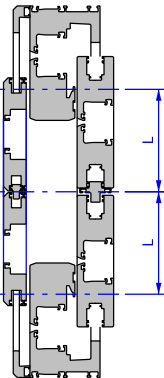
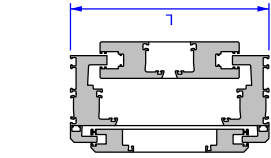
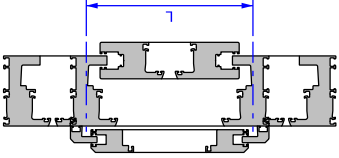
EXAMPLE :

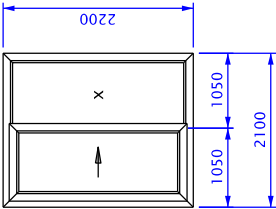
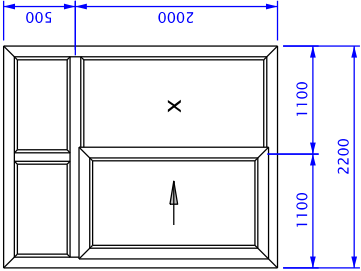
Sliding frame 3 rails (12664) , Sliding Window Sash (12670)

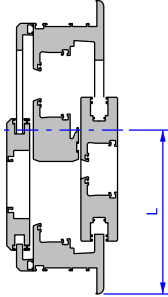
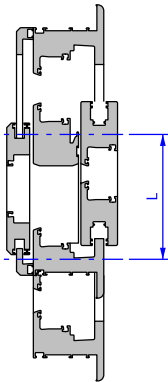
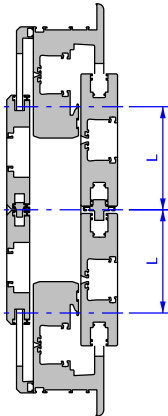
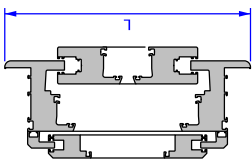
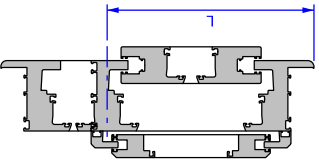
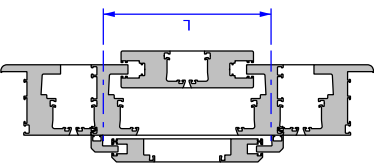
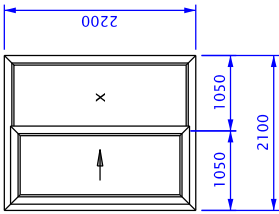
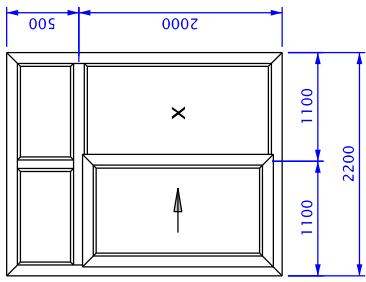


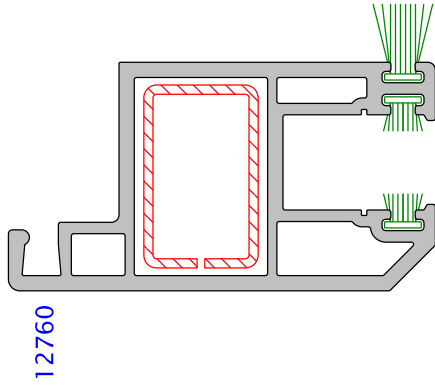
Flyscreen Rail 38 mm (12763)
Width : 3000+6=3006 mm
Height : 1500+31=1531 mm

Sürme Sineklik Kanat (12760)
Width : 1000-17=983 mm
Height : 1500-23=1477 mm

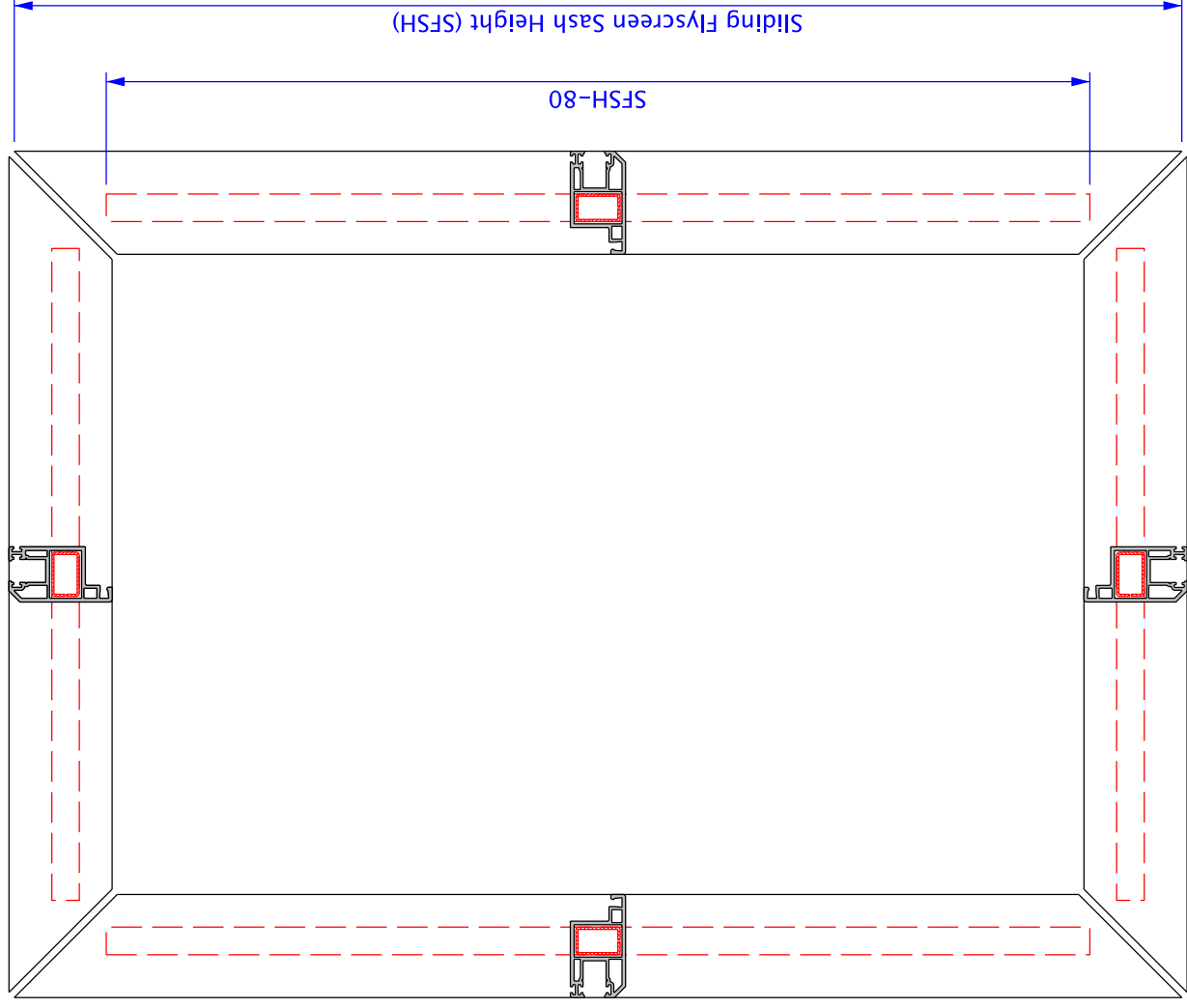
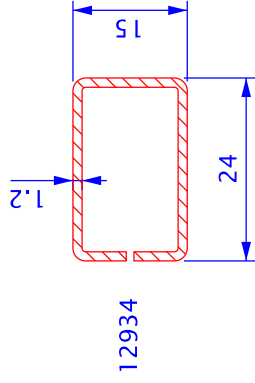
Welding thickness is included in sash calculations.	WIDTH			Transom to Transom	Frame to Transom	Transom to Transom
	Dimension					
12762 Flyscreen Rail 22 mm				Width and Height $L + 6$	Width and Height $L + 27$	Width and Height $L + 48$
SLIDING FLYSCREEN CALCULATION :						
12671 Sliding Door Sash	$L - 5$	$L + 16$	$L + 10$	Height $L - 48$	Height $L - 27$	Height $L - 6$

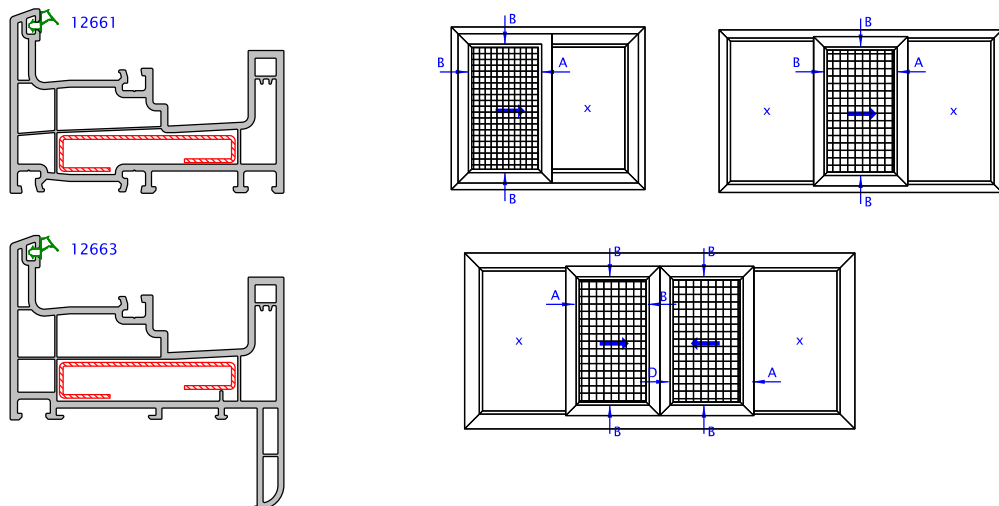
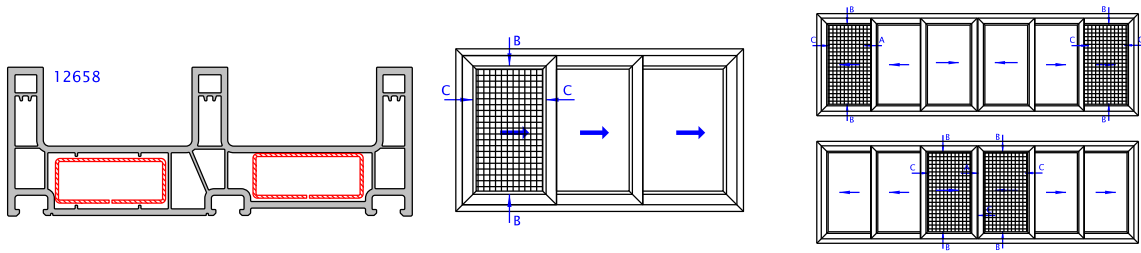
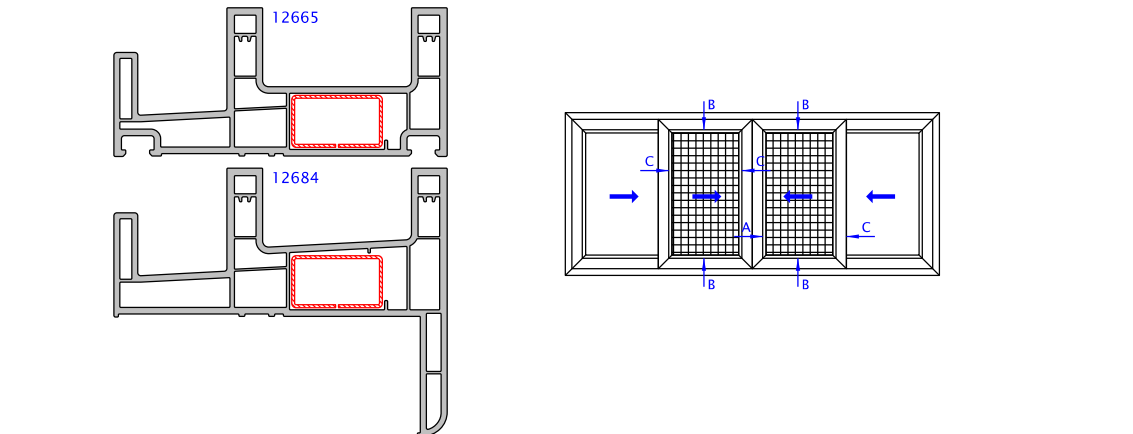
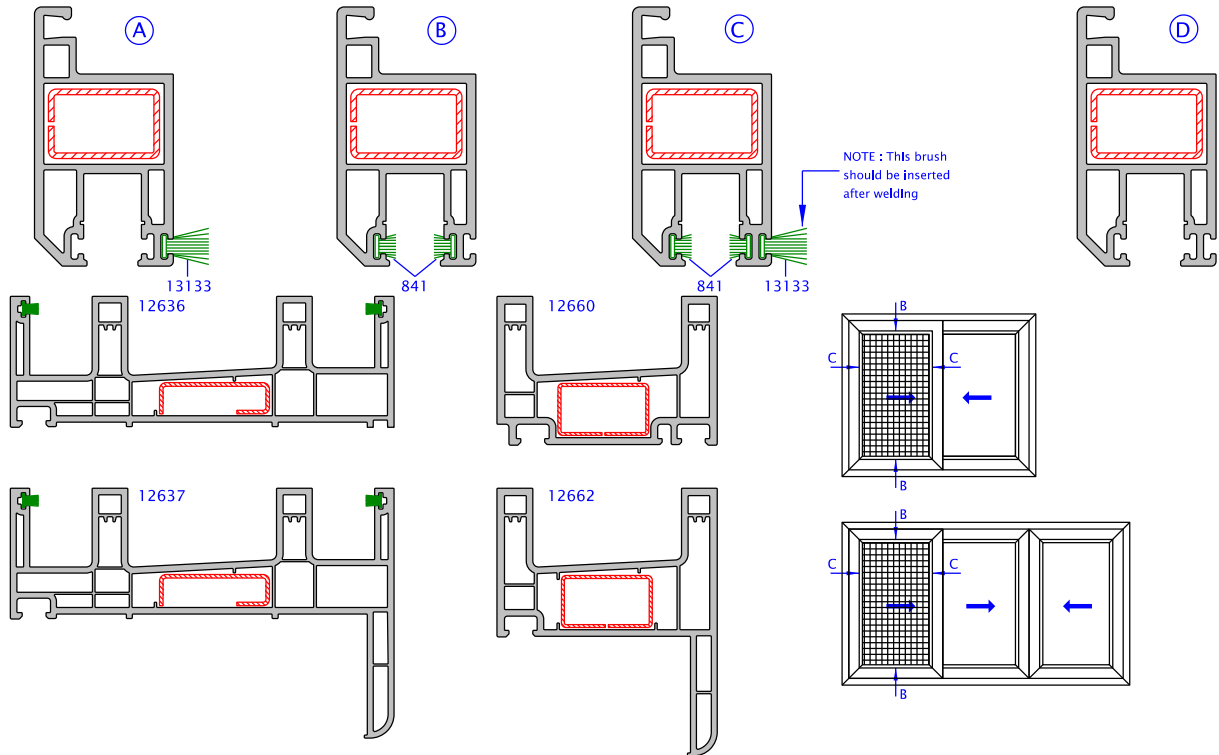
<p>EXAMPLE : Sliding Fixed Frame (12661) , Sliding Door Sash (12671)</p>  <p>Flyscreen Rail 22 mm (12762) Width : $2100 + 6 = 2106$ mm Height : $2200 + 6 = 2206$ mm</p> <p>Flyscreen Sash (12760) Width : $1050 - 5 = 1045$ mm Height : $2200 - 48 = 2152$ mm</p>	<p>EXAMPLE : Sliding Fixed Frame (12661) , Sliding Door Sash (12671)</p>  <p>Flyscreen Rail 22 mm (12762) Width : $2200 + 6 = 2206$ mm Height : $2000 + 27 = 2027$ mm</p> <p>Flyscreen Sash (12760) Width : $1100 - 5 = 1095$ mm Height : $2000 - 27 = 1973$ mm</p>
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<div> <div>Welding thickness is included in sash calculations.</div> <div>Dimension</div> </div>	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
						
12762 Flyscreen Rail 22 mm				Width and Height $L - 54$	Width and Height $L - 3$	Width and Height $L + 48$
SLIDING FLYSCREEN CALCULATION :						
12671 Sliding Door Sash	$L - 35$	$L + 16$	$L + 10$	Height $L - 108$	Height $L - 57$	Height $L - 6$
<div> <div>EXAMPLE :</div> <div>Fixed Sliding Architrave Frame (12663) , Sliding Door Sash (12671)</div> <div>  <p> Flyscreen Rail 22 mm (12762) Width : 2100-54=2046 mm Height : 2200-54=2146 mm Flyscreen Sash (12760) Width : 1050-35=1015 mm Height : 2200-108=2092 mm </p> </div> <div> <div>EXAMPLE :</div> <div>Fixed Sliding Architrave Frame (12663) , Sliding Door Sash (12671)</div> <div>  <p> Flyscreen Rail 22 mm (12762) Width : 2200-54=2146 mm Height : 2000-3=1997 mm Flyscreen Sash (12760) Width : 1100-35=1065 mm Height : 2000-57=1943 mm </p> </div> </div> </div>						

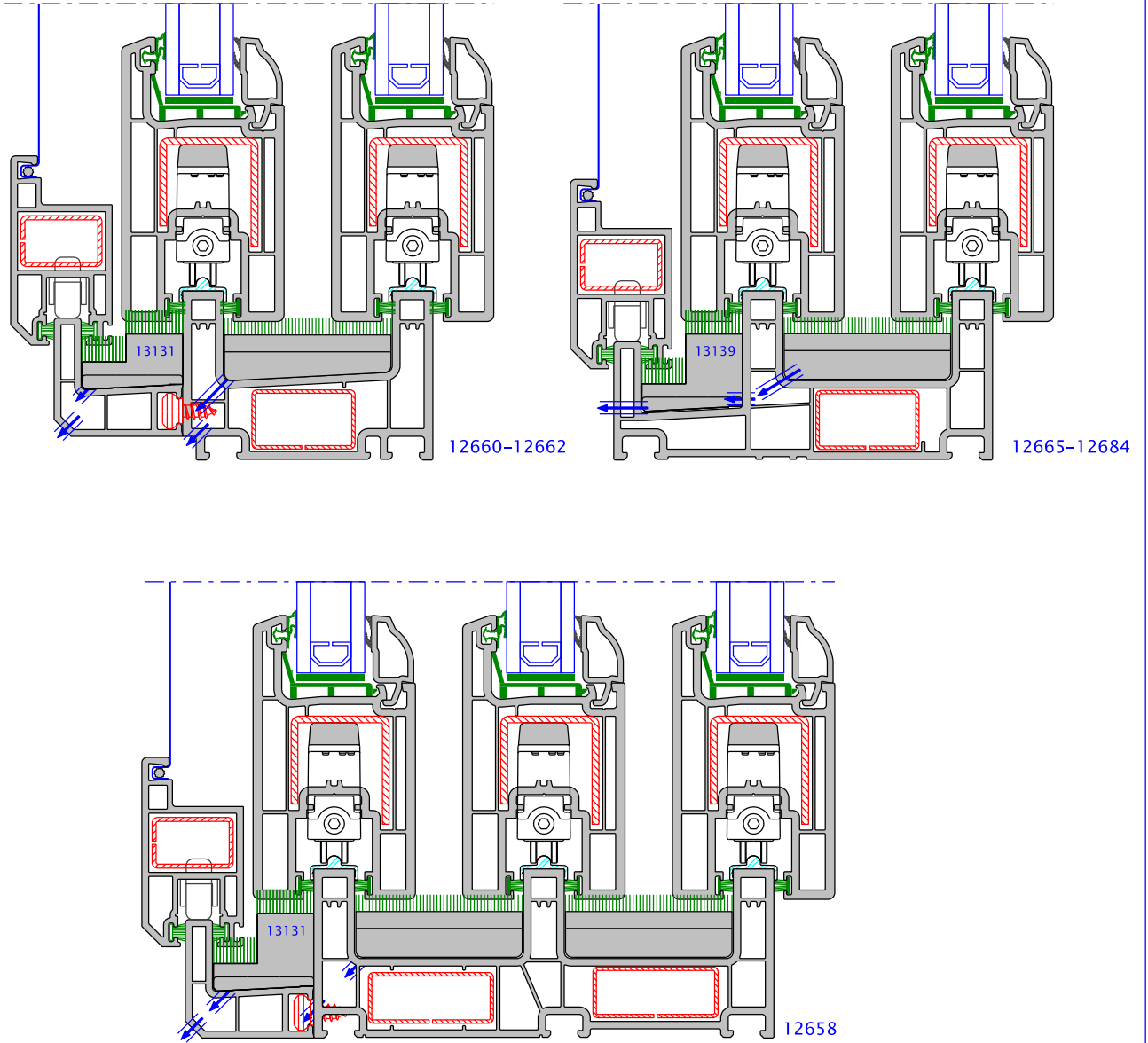


* Brushes (841 and 13133) are inserted before welding.





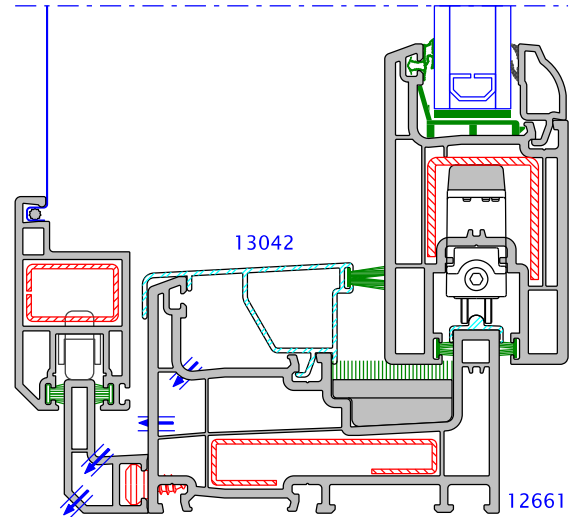
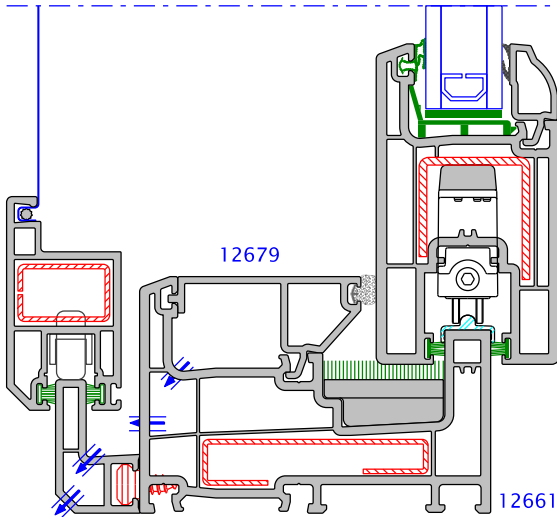
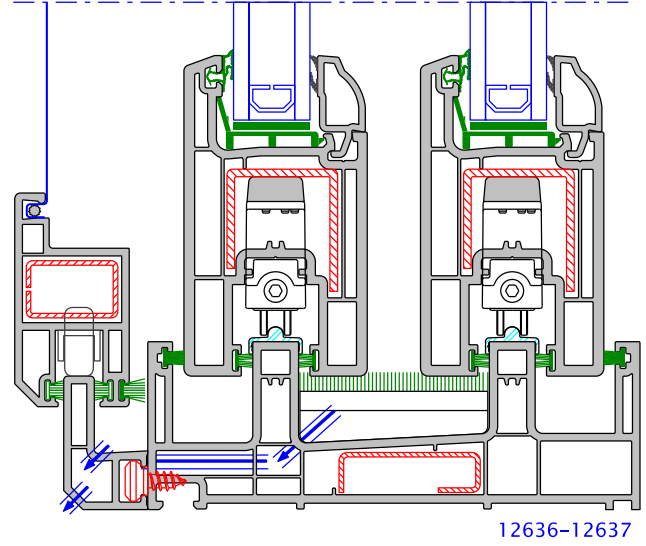
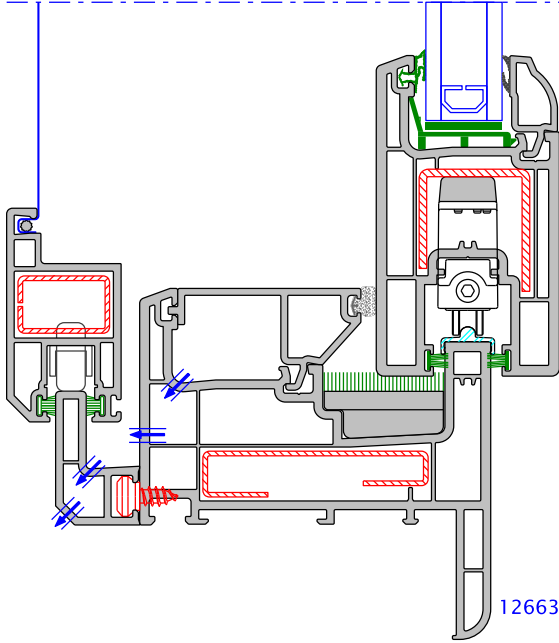
In the case of sliding frames (12660,12665 and 12664) since it is not possible to install drainage caps , water slots should be drilled also on flyscreen rails.The numbers of water discharge slots for flyscreen rails should be equal to sliding frame.Please find the application on the drawing below.



WELDING :

- * Flyscreen rails are welded and corner cleanings are done.
- * Brushes which are used inside of flyscreen sash, are inserted before welding.
- * After corner cleaning process, the brush that has the dimension as 48x1000 is inserted on outside of flyscreen sash according to the detail.

Other sliding frame applications are shown in the figure below. Drainage holes should be opened on both frame and flyscreen rails.



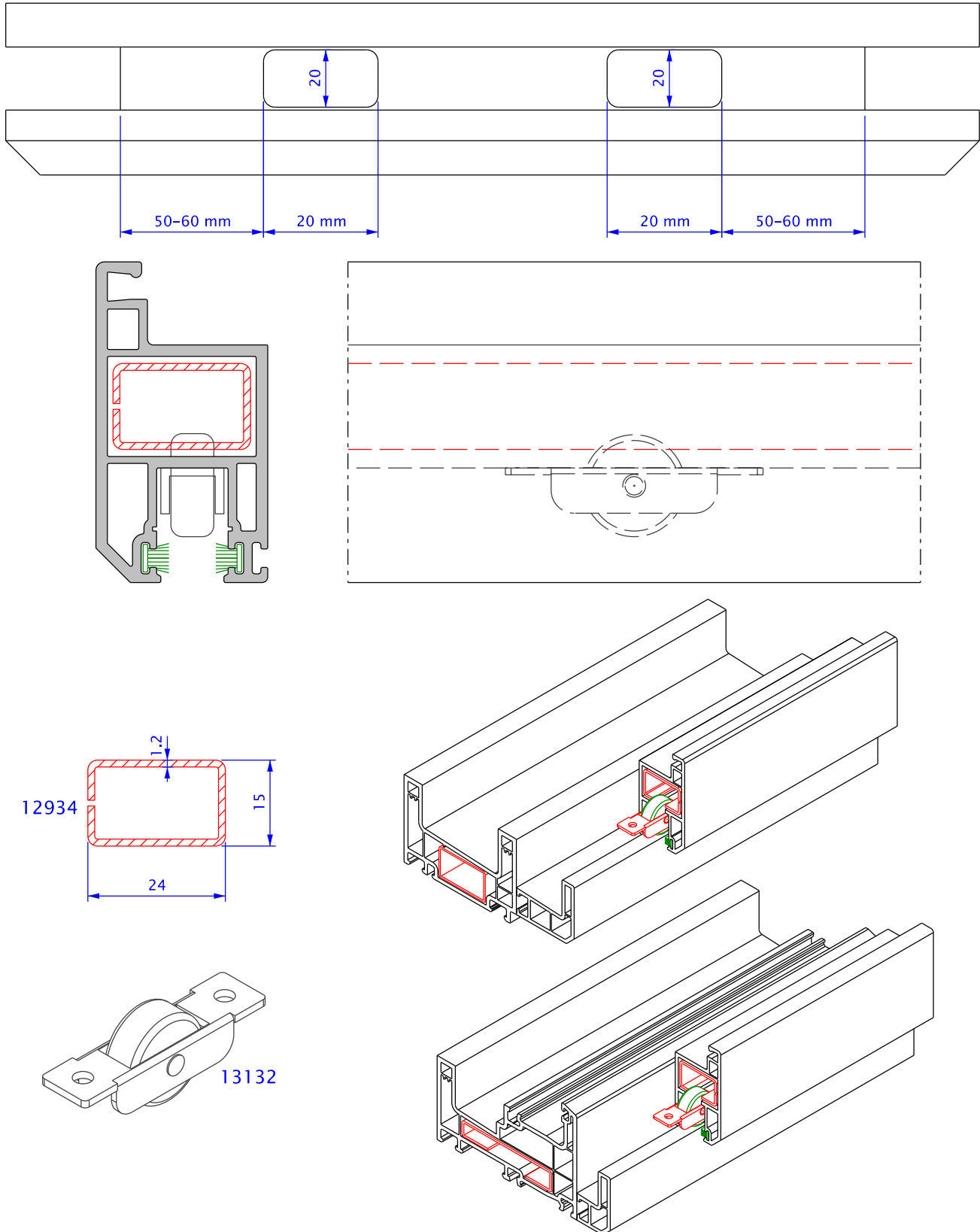
WELDING :

- * Flyscreen rails are welded and corner cleanings are done.
- * Brushes which are used inside of flyscreen sash, are inserted before welding.
- * After corner cleaning process, the brush that has the dimension as 48x1000 is inserted on outside of flyscreen sash according to the detail.

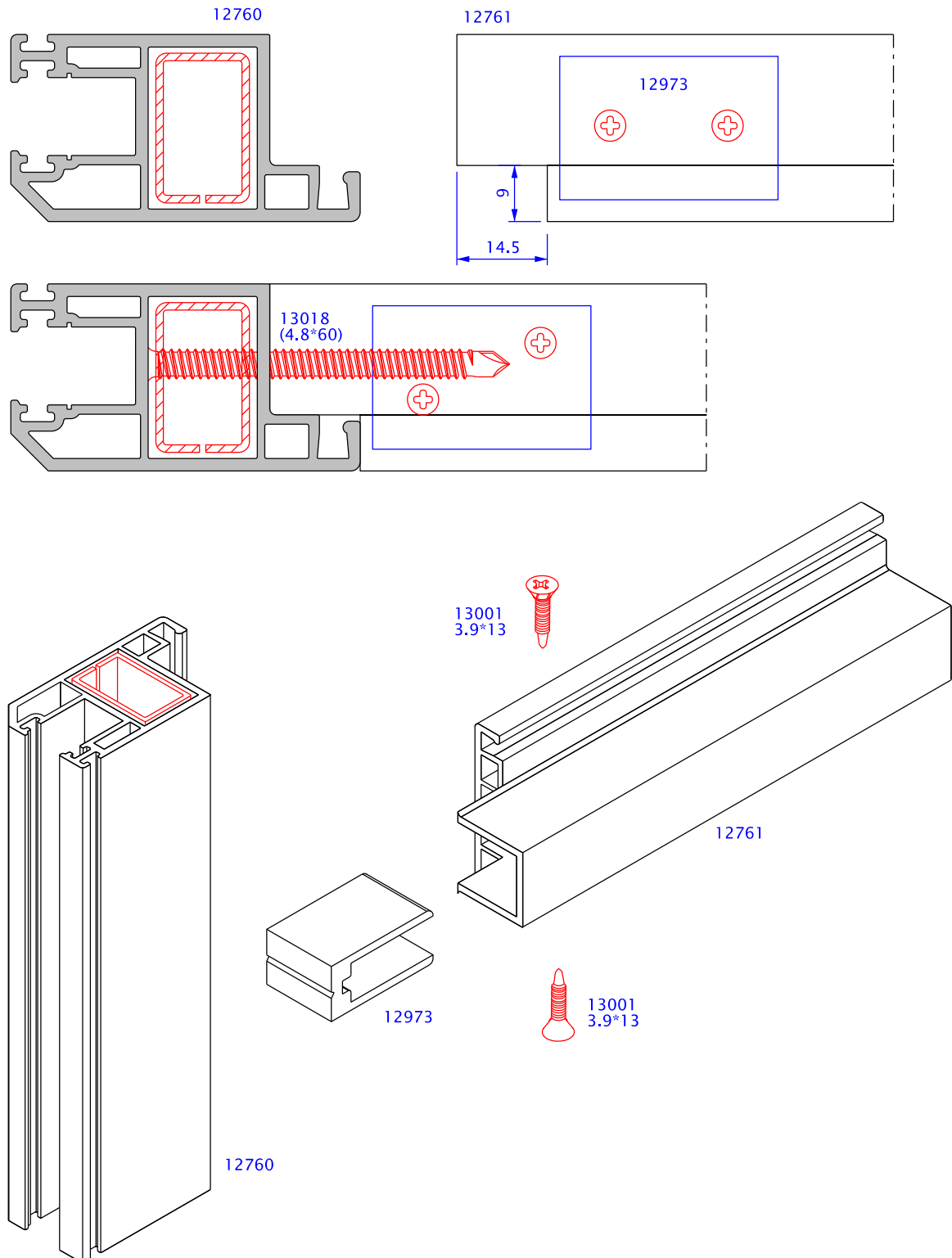
- * Reinforcement 15x24 mm (12934) is used in the sliding flyscreen sash (12760) and sliding flyscreen transom (12761) profiles,
- * The screw 3.9x16 cylindrical head must be used as 3 pieces/m

Flyscreen Roller (13132):

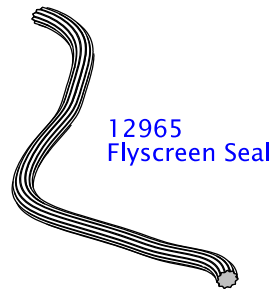
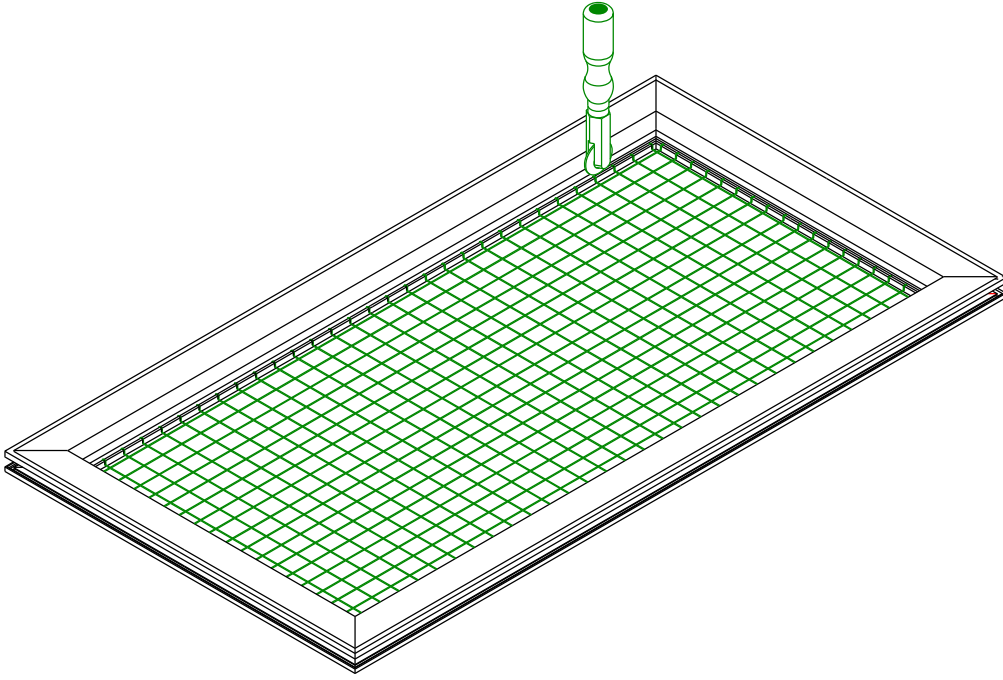
Flyscreen rollers (13132) can be mounted before welding of sash profiles.



- * Flyscreen transom profile is end milled,
- * Mechanical joint (12973) is fixed from the both side of flyscreen transom with screws that has the dimensions of 3.9x22.
- * The transom profile is mounted into the flyscreen sash. Profile by using screw 4.8x60 (flat head or cylindrical)
- * It is adviced to use transom profile when the sash length exceeds 1m.



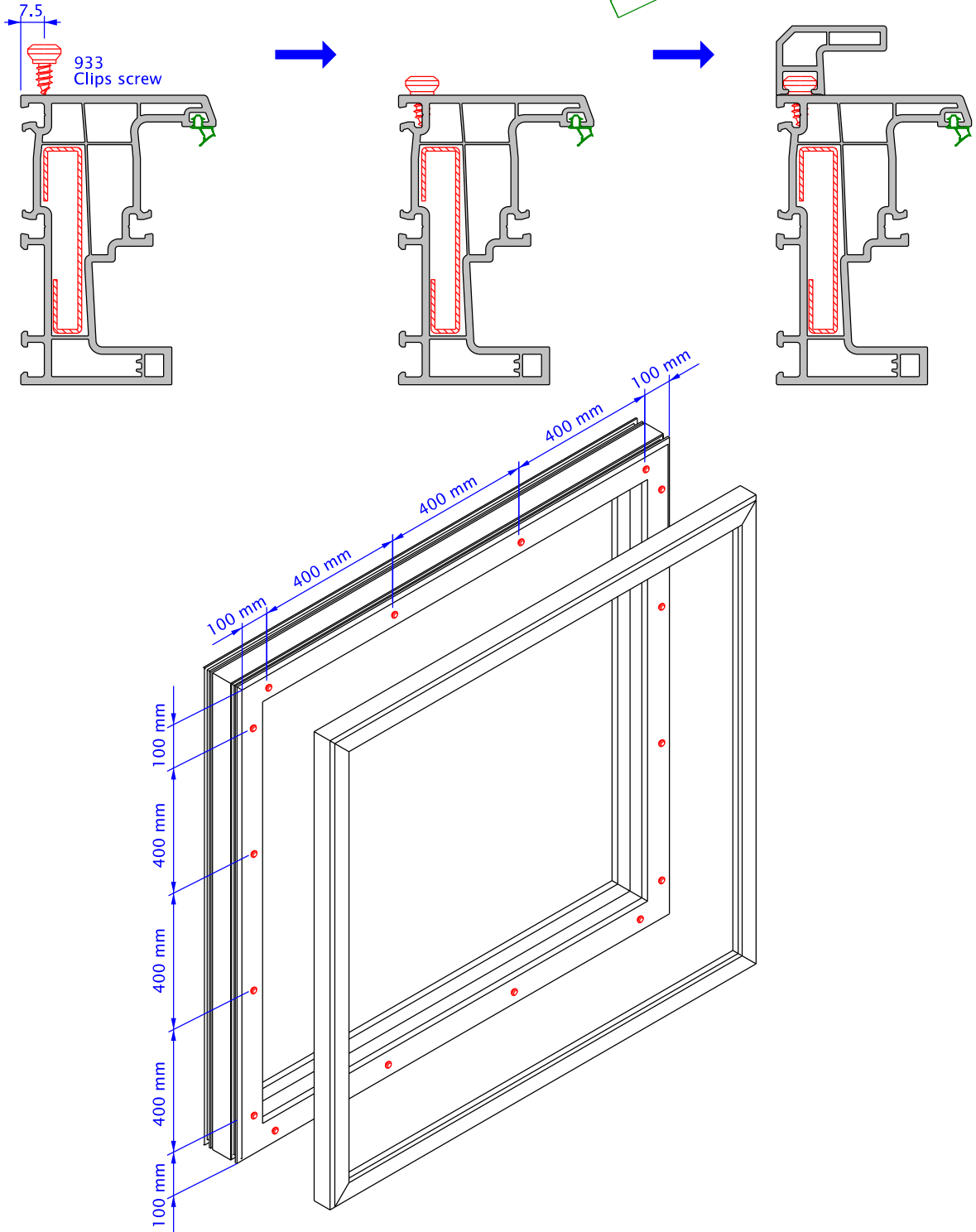
- * The flyscreen mesh is prepared by cutting 2–3 cm more than inside dimensions of flyscreen sash.
- * The mesh must be installed from the top corner,
- * The extensions of flyscreen mesh is cut after installation.



After the welding of flyscreen rails,

- * Clip screws are used on the outside of sliding frames (12660, 12661, 12663)
- * Sliding flyscreen rail can be bonded with glue (e.g. loctite) before hammering.
(Bonding surfaces must be clean, dry and free from grease on clip screw (933))
- * Flyscreen rails are installed on sliding windows by using hammer.

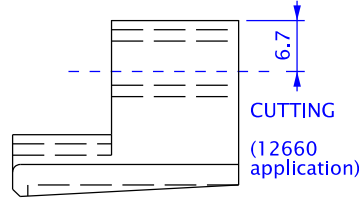
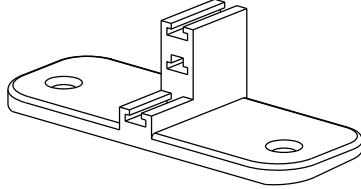
Clip screws should be used as shown in the picture below.



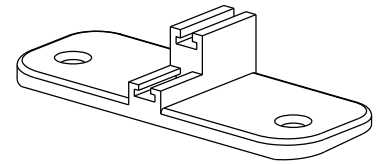
In the application of sliding frames (12660) flyscreen rail 38 mm is used. The flyscreen wedge (13131) is used at top and bottom. The brush (13133) that has the dimensions 048x1000 mm is inserted into flyscreen wedge (13131).

In the application of 12660, flyscreen wedge (13131) must be cut as shown below.

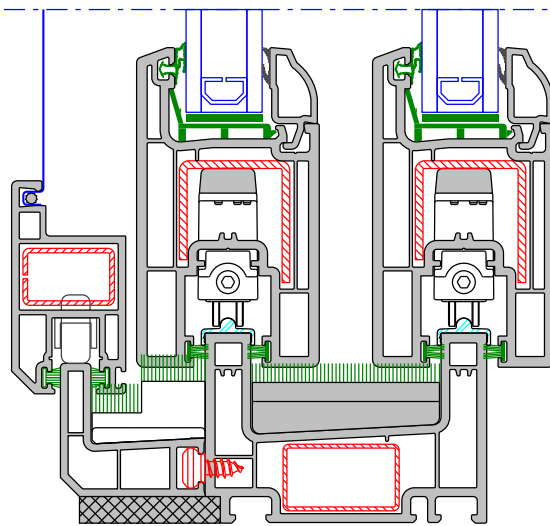
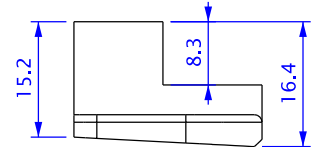
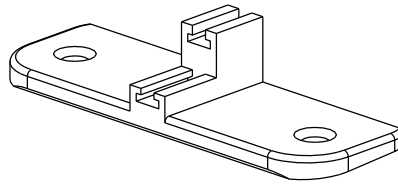
13131
=>12662-12658



13131
=>12660

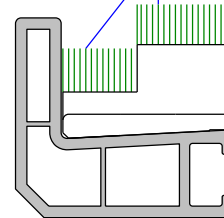


13139
=>12665-12684



Wooden Wedge

13133 (048x1000)

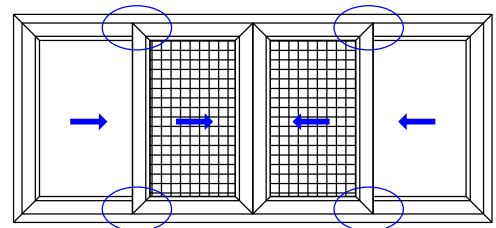
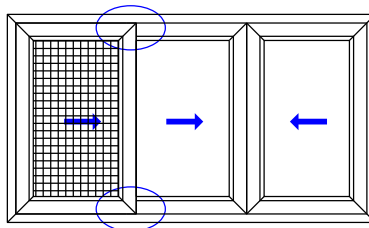
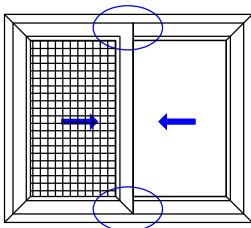


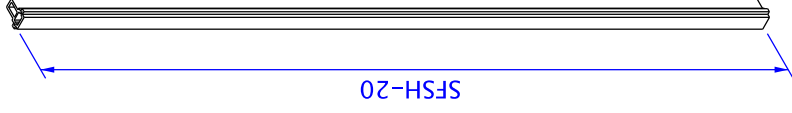
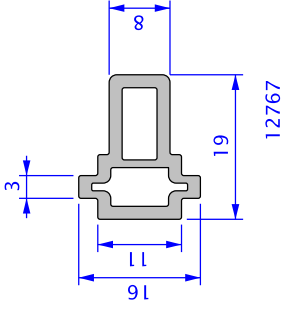
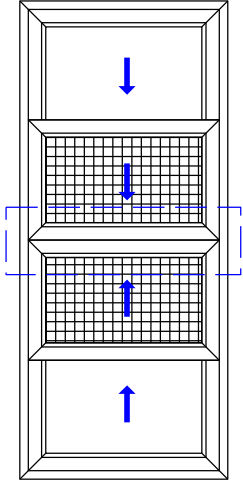
NOTE : Plastic or wooden wedges can be used to fill the empty area at the bottom of rail.

Flyscreen Wedge Applications :

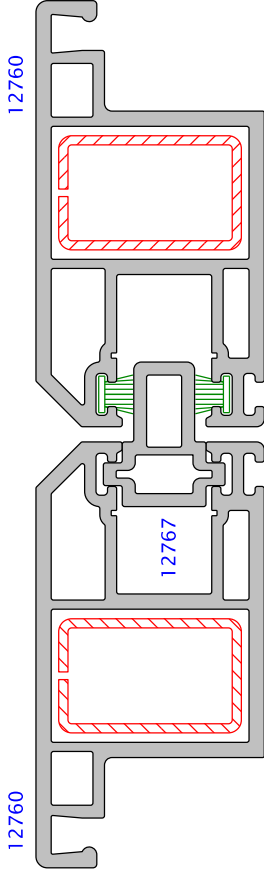
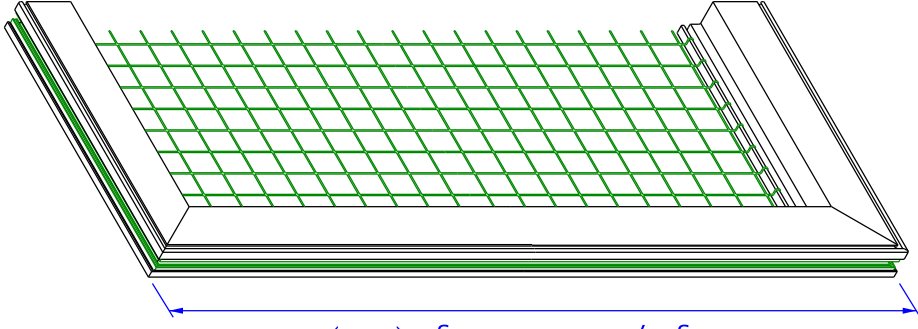
SLIDING FRAME (12660/12665)

Flyscreen wedge must be used on the window where it has been shown below with circle.





Sliding Flyscreen Sash Height (SFSH)

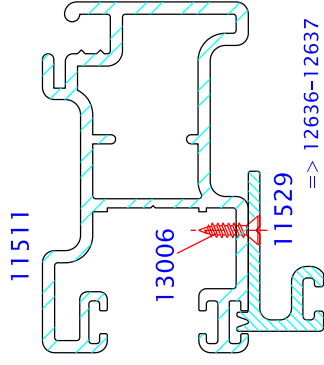
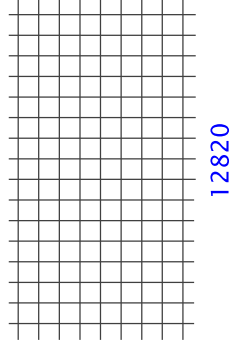
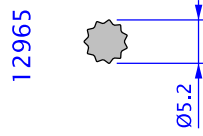
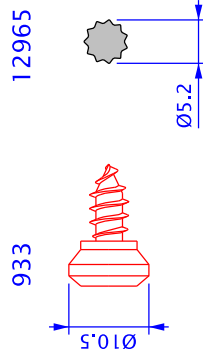
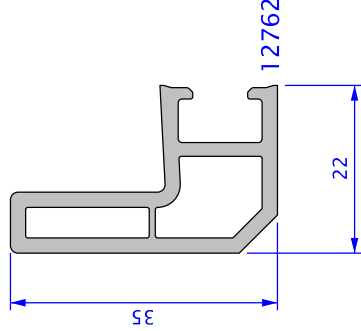
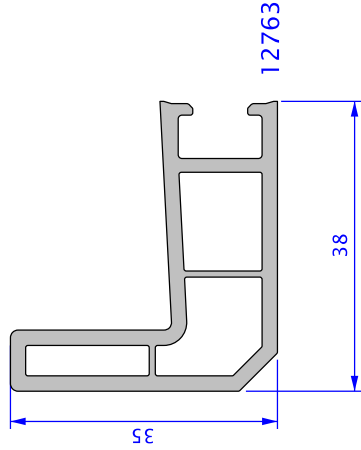
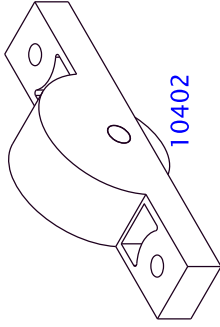
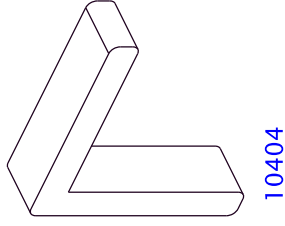
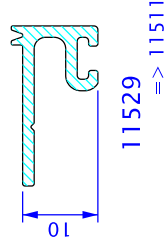
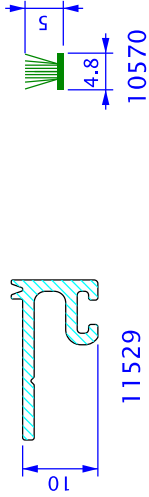
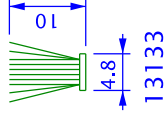
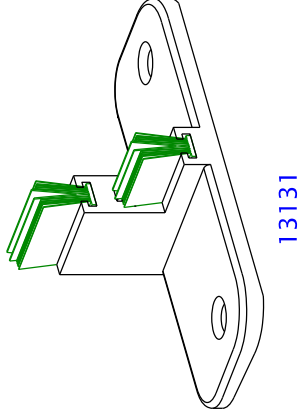
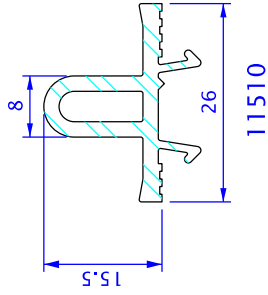
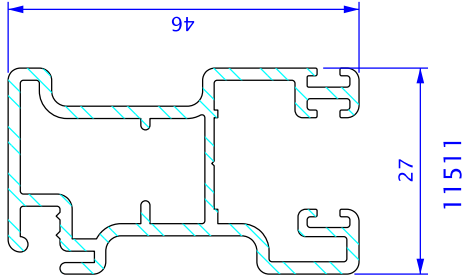




R-R İTHALAT İHRACAT
VE PAZARLAMA A.Ş.

SYSTEM OVERVIEW

Main Profiles

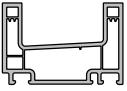

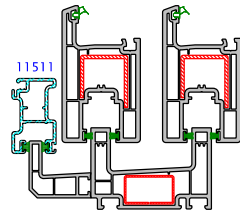
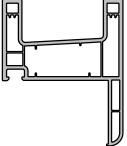

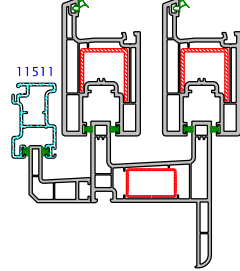
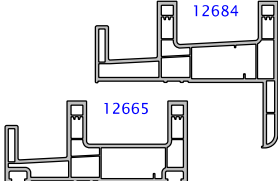
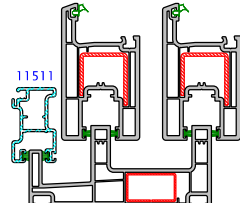
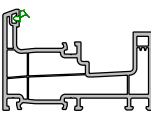

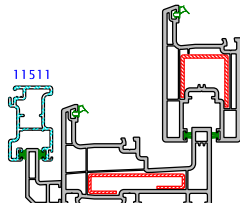
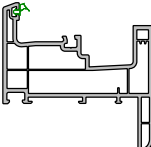

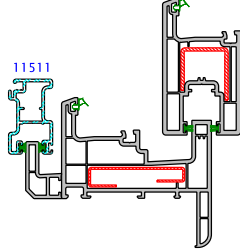
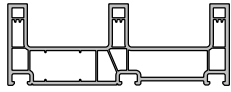

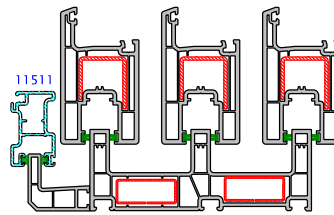
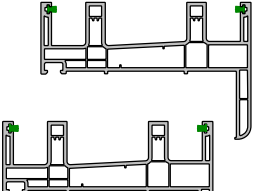

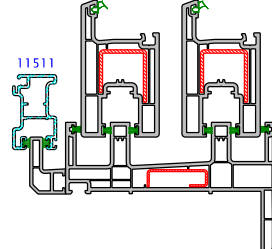


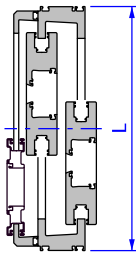
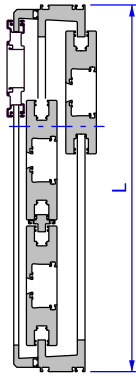
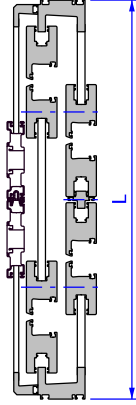
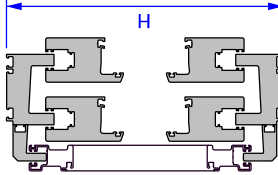
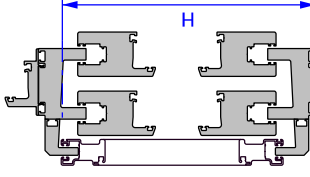
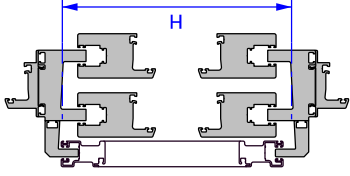
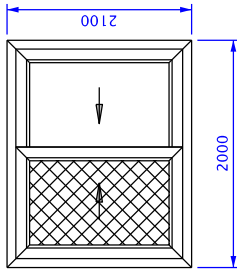
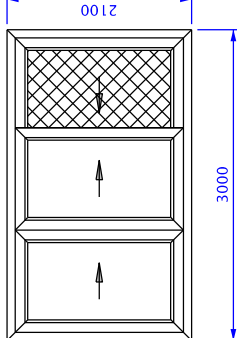
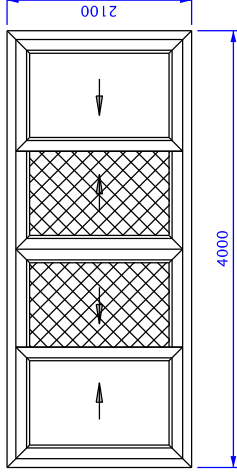
Sliding flyscreen rails should be chosen according to the sliding frame.

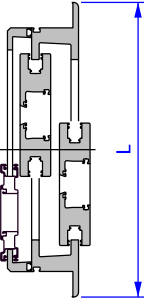
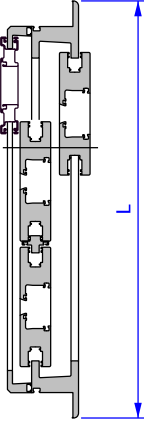
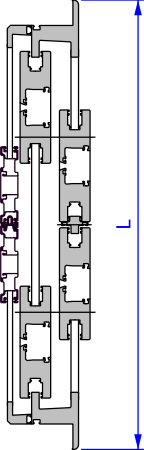
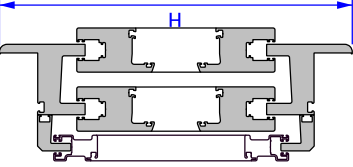
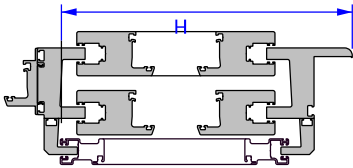
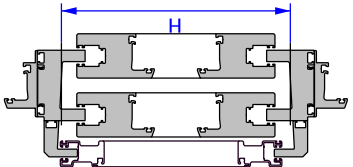
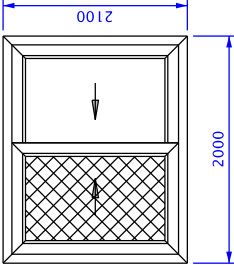
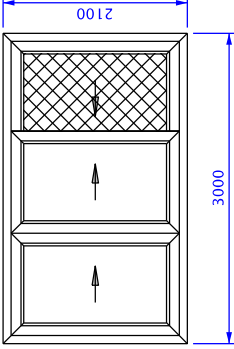
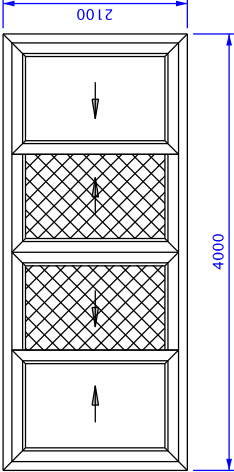
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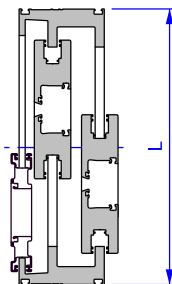
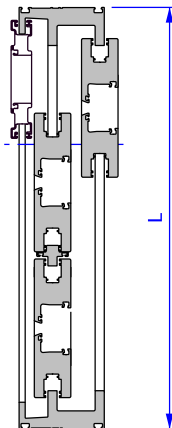
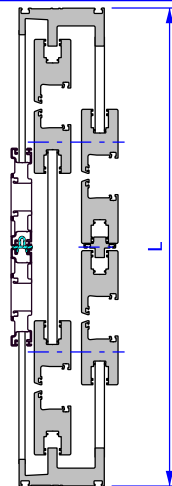
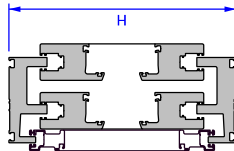
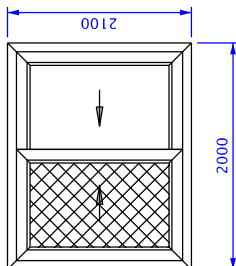
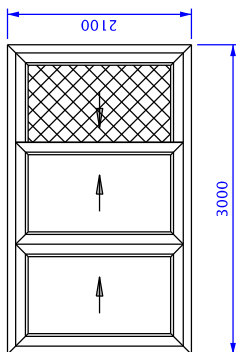
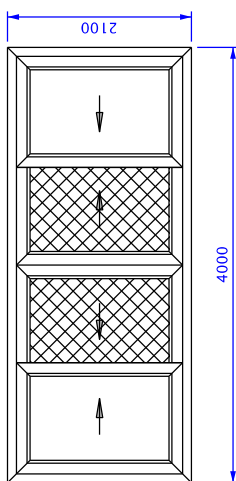
* Sliding flyscreen 22 mm

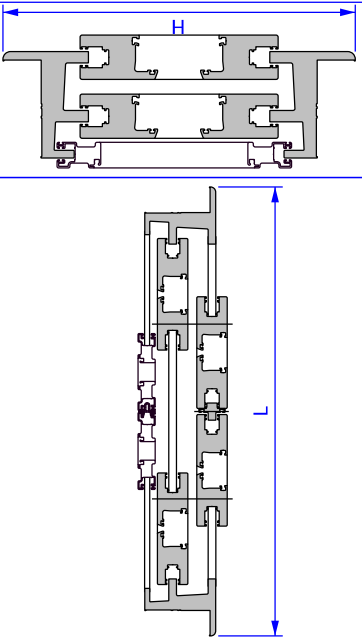
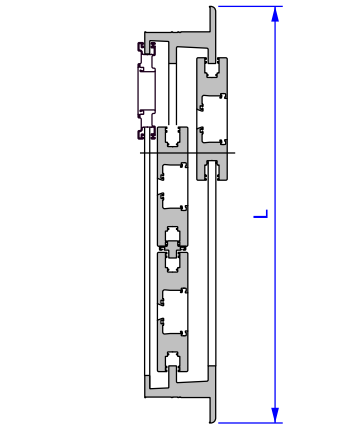
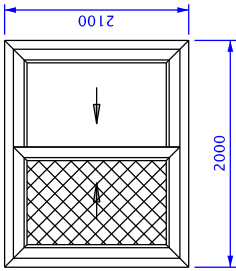
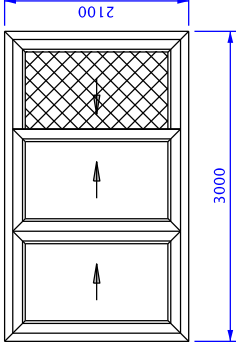
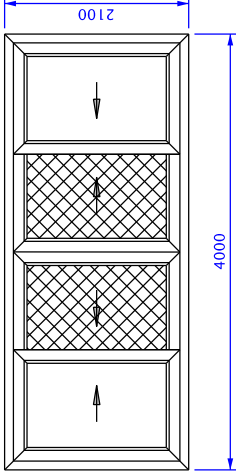
* Sliding flyscreen 38 mm

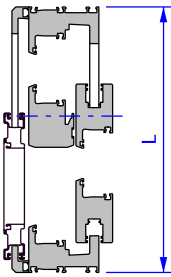
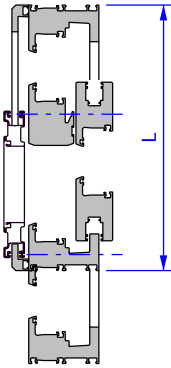
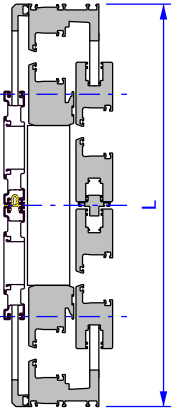
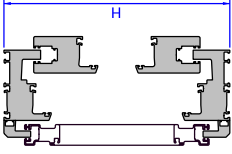
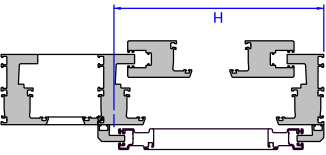
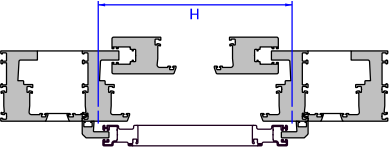
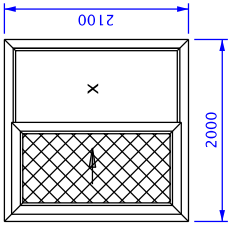
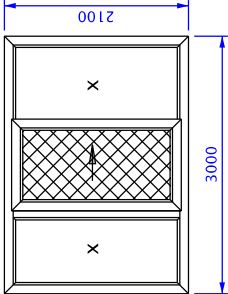
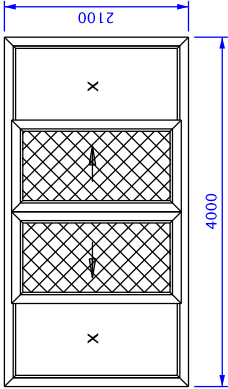
PVC	Flyscreen Rail	Application
12660 	12763 	
12662 	12763 	
 12684 12665	Sineklik rayı profil üzerinde bulunmaktadır.	
12661 	12762 	12660 
12663 	12762 	12660 
	12763 	
	12762 	

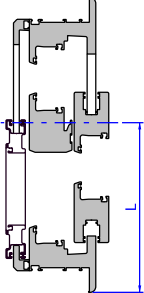
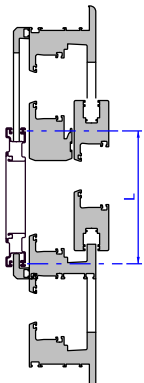
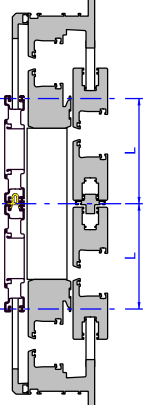
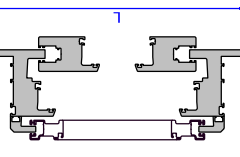
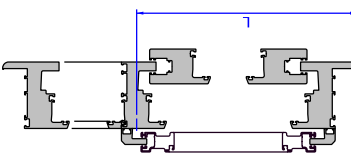
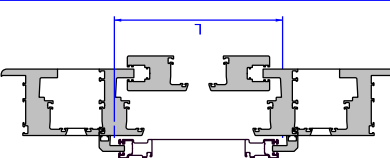
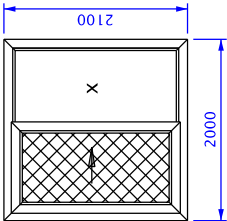
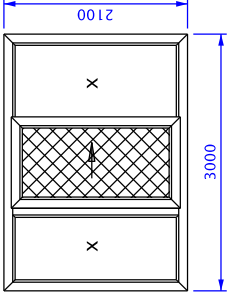
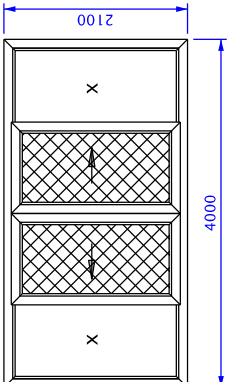
<div> <div> Welding thickness is included in sash calculations. </div> <div> Dimension </div> </div>	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
						
12763 Flyscreen Rail 38mm				Width and Height H – 8	Width and Height H + 17	Width and Height H + 42
L : Frame Width H : Height						
11511 Aluminium sliding flyscreen	L / 2 – 33	L / 3 – 33	L / 4 – 29	Height H – 68	Height H – 43	Height H – 18
EXAMPLE : Sliding Frame (12660)						
 Flyscreen Rail 38 mm (12763) Width : 2000–8=1992 mm Height : 2100–8=2092 mm						
Aluminium sliding flyscreen sash (11511) Width : 2000 / 2=1000 mm Height : 1000–33=967 mm						
 Flyscreen Rail 38 mm (12763) Width : 3000–8=2992 mm Height : 2100–8=2092 mm						
Aluminium sliding flyscreen sash (11511) Width : 3000 / 3=1000 mm Height : 1000–33=967 mm						
 Flyscreen Rail 38 mm (12763) Width : 4000–8=3992 mm Height : 2100–8=2092 mm						
Aluminium sliding flyscreen sash (11511) Width : 4000 / 4=1000 mm Height : 1000–29=971 mm						

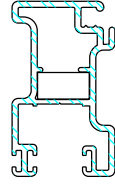
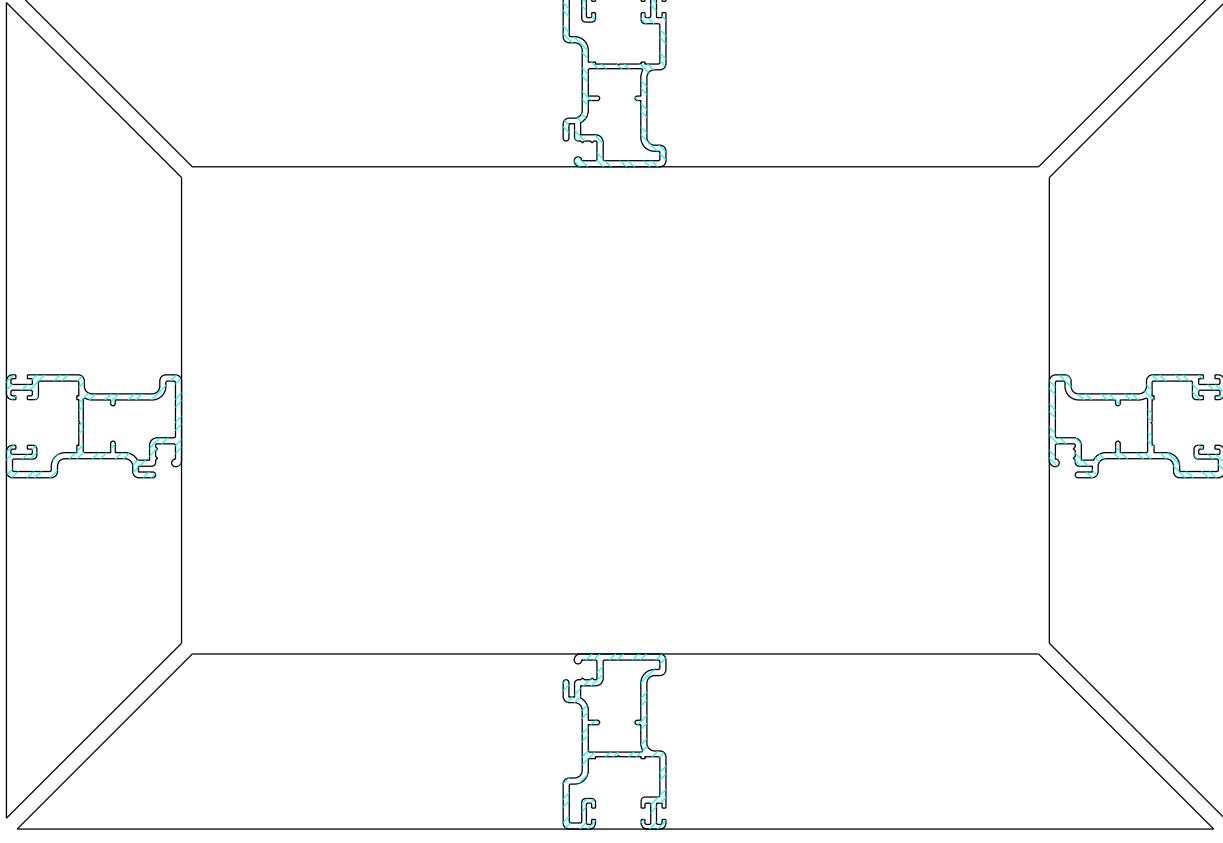
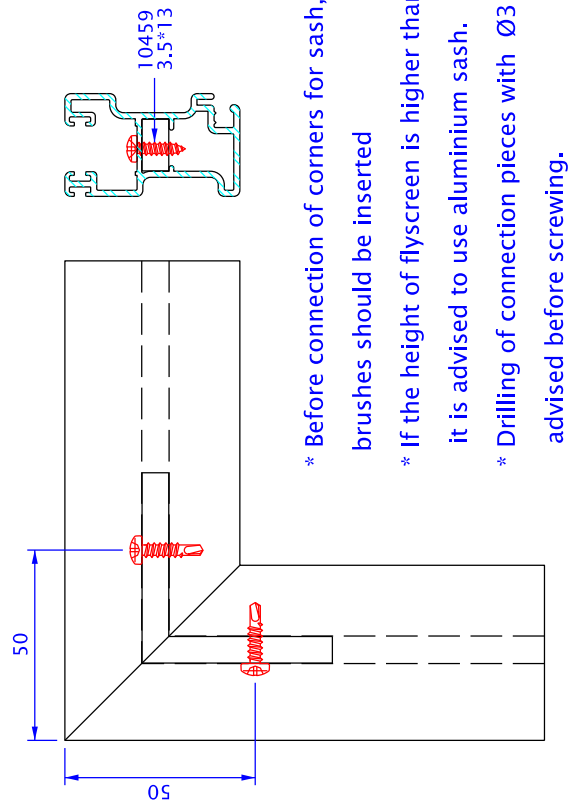
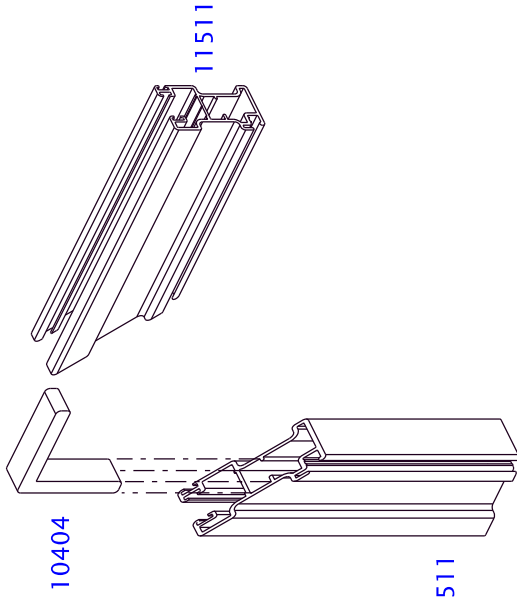
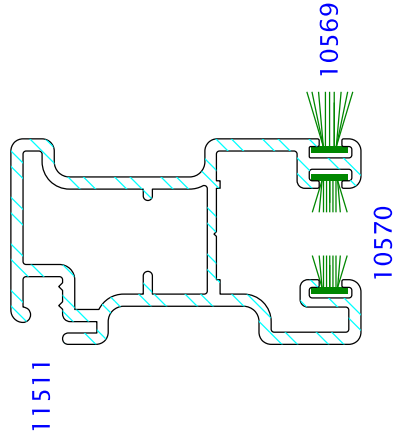
		WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
							
<div>Welding thickness is included in sash calculations.</div> <div>Dimension</div>	12763 Flyscreen Rail 38mm				Width and Height $H - 74$	Width and Height $H - 16$	Width and Height $H + 42$
	L : Frame Width H : Height				Height $H - 74$	Height $H - 16$	Height $H + 42$
11511 Aluminium sliding flyscreen	- 66	- 66	- 66	- 49	Height $H - 134$	Height $H - 76$	Height $H - 18$
EXAMPLE : Sliding Architrave Frame (12662)		 <p>Flyscreen Rail 38 mm (12763) Width : 2000-74=1926 mm Height : 2100-74=2026 mm</p>	 <p>Flyscreen Rail 38 mm (12763) Width : 3000-74=2926 mm Height : 2100-74=2026 mm</p>	 <p>Flyscreen Rail 38 mm (12763) Width : 4000-74=3926 mm Height : 2100-74=2026 mm</p>			
Aluminium sliding flyscreen sash (11511)		Aluminium sliding flyscreen sash (11511)			Aluminium sliding flyscreen sash (11511)		
Width : 2000 / 2=1000 mm		Width : 3000 / 3=1000 mm			Width : 4000 / 4=1000 mm		
Height : 1000-66=934 mm		Height : 1000-66=934 mm			Height : 1000-49=951 mm		

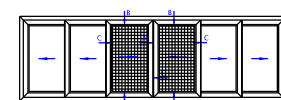
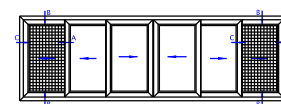
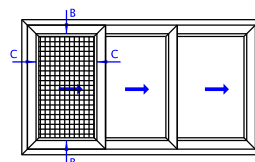
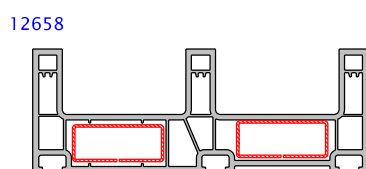
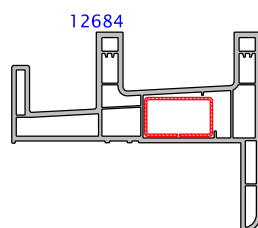
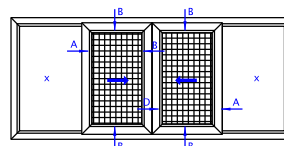
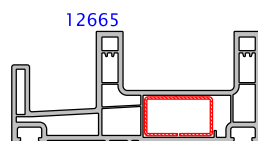
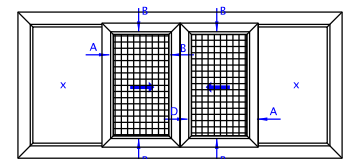
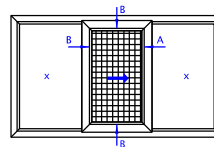
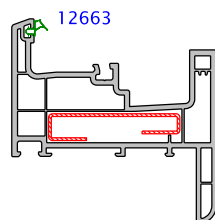
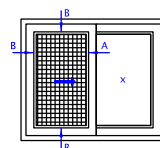
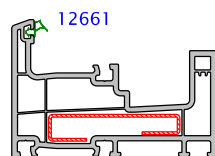
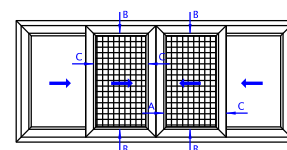
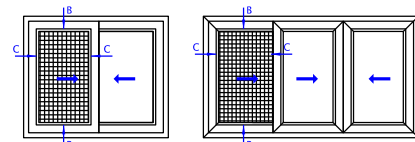
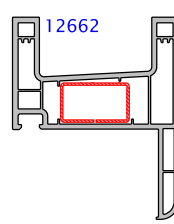
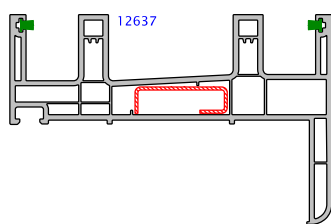
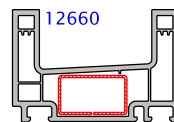
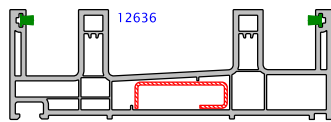
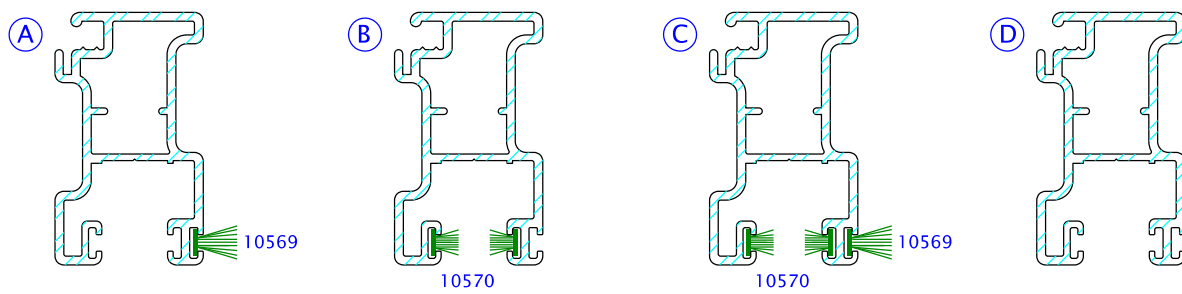
<div>Welding thickness is included in the calculations</div> <div>Dimension</div>		WIDTH			HEIGHT (Frame to Frame)
					
L : Frame Width H : Height		L / 2 – 26	L / 3 – 26	L / 4 – 29	L – 54
11511 Aluminium sliding flyscreen					<div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 4000 / 4=1000 mm</div> <div>Height : 1000–29=971 mm</div>
EXAMPLE : Sliding Frame with Flyscreen (12665)		<div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 2000 / 2=1000 mm</div> <div>Height : 1000–26=974 mm</div>	<div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 3000 / 3=1000 mm</div> <div>Height : 1000–26=974 mm</div>	<div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 4000 / 4=1000 mm</div> <div>Height : 1000–29=971 mm</div>	

<div> <div> <div>Welding thickness is included in the calculations</div> <div>Dimension</div> </div> <div> <div>WIDTH</div> <div>HEIGHT (Frame to Frame)</div> </div> </div>			
			
<div> <div>L: Frame Width</div> <div>H: Height</div> </div>		<div> <div>Height</div> <div>H – 134</div> </div>	
<div> <div>11511 Aluminium sliding flyscreen</div> </div>		<div> <div>– 66</div> <div>– 49</div> <div>– 66</div> </div>	
<div> <div>EXAMPLE :</div> <div>Sliding Arc. Frame with Flyscreen (12684)</div> </div>		<div> <div>  <div> <div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 2000 / 2=1000 mm</div> <div>Height : 1000-66=934 mm</div> </div> </div> <div> <div>  <div> <div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 3000 / 3=1000 mm</div> <div>Height : 1000-66=934 mm</div> </div> </div> <div> <div>  <div> <div>Aluminium sliding flyscreen sash (11511)</div> <div>Width : 4000 / 4=1000 mm</div> <div>Height : 1000-49=951 mm</div> </div> </div> </div> </div></div>	

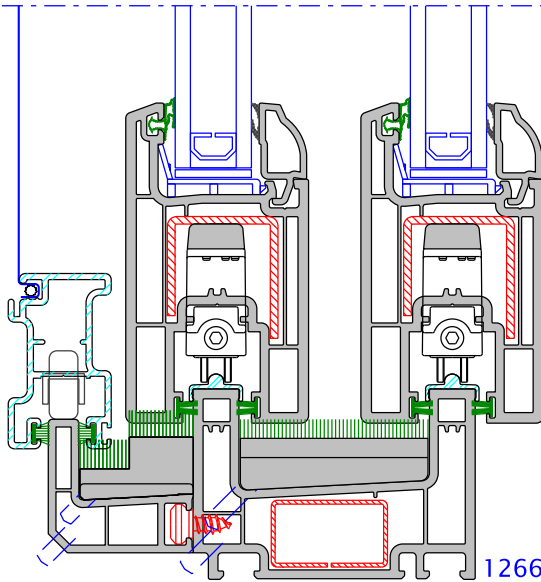
<div> <div>Welding thickness is included in sash calculations.</div> <div>Dimension</div> </div>	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
						
<div> <div>L : Frame Width</div> <div>H : Height</div> </div>	12762 Flyscreen Rail 22 mm	$L + 6$	$\frac{L}{3} \times 2 + 6$	$L + 6$	$H + 27$	$H + 48$
	11511 Aluminium sliding flyscreen	-13	-10	$\frac{L}{4} - 22$	$H - 54$	$H - 12$
<div> <div>EXAMPLE :</div> <div>Sliding Fixed Frame (12661)</div> </div>						
						
Flyscreen Rail 38 mm (12763) Width : 2000+6=2006 mm Height : 2100+6=2106 mm Aluminium sliding flyscreen sash (11511) Width : 2000 / 2=1000 mm Height : 1000-13=987 mm		Flyscreen Rail 38 mm (12763) Width : 3000 / 3 = 1000 mm 1000 x 2 = 2000 mm 2000 + 6 = 2006 mm Height : 2100 + 6 = 2106 mm Aluminium sliding flyscreen sash (11511) Width : 3000 / 3=1000 mm Height : 1000 - 10 = 990 mm		Flyscreen Rail 38 mm (12763) Width : 4000+6=4006 mm Height : 2100+6=2106 mm Aluminium sliding flyscreen sash (11511) Width : 4000 / 4=1000 mm Height : 1000-22=978 mm		

<div> <div>Welding thickness is included in sash calculations.</div> <div>Dimension</div> </div>	WIDTH			Frame to Frame	Frame to Transom	Transom to Transom
						
L : Frame Width H : Height	12762 Flyscreen Rail 22 mm	$L - 54$	$\frac{L}{3} \times 2 - 22$	$L - 54$	$L - 3$	$L + 48$
	11511 Aluminium sliding flyscreen	-43	$\frac{L}{3} - 30$	$\frac{L}{4} - 37$	$L - 63$	$L - 12$
<div> <div> <div>  <p>2100</p> <p>2000</p> <p>Flyscreen Rail 38 mm (12763)</p> <p>Width : 2000-54=1946 mm</p> <p>Height : 2100-54=2046 mm</p> </div> <div> <p>EXAMPLE :</p> <p>Fixed Sliding Architrave Frame (12663)</p> </div> </div> <div> <div>  <p>2100</p> <p>3000</p> <p>Flyscreen Rail 38 mm (12763)</p> <p>Width : 3000 / 3 = 1000 mm</p> <p>1000 x 2 = 2000 mm</p> <p>2000 - 22 = 1978 mm</p> </div> <div> <p>Aluminium sliding flyscreen sash (11511)</p> <p>Width : 2100 - 54 = 2046 mm</p> <p>Aluminium sliding flyscreen sash (11511)</p> <p>Width : 3000 / 3 = 1000 mm</p> <p>Height : 1000 - 43 = 957 mm</p> </div> </div> <div> <div>  <p>2100</p> <p>4000</p> <p>Flyscreen Rail 38 mm (12763)</p> <p>Width : 4000-54=3946 mm</p> <p>Height : 2100-54=2046 mm</p> </div> <div> <p>Aluminium sliding flyscreen sash (11511)</p> <p>Width : 4000 / 4 = 1000 mm</p> <p>Height : 1000-37=963 mm</p> </div> </div> </div>						

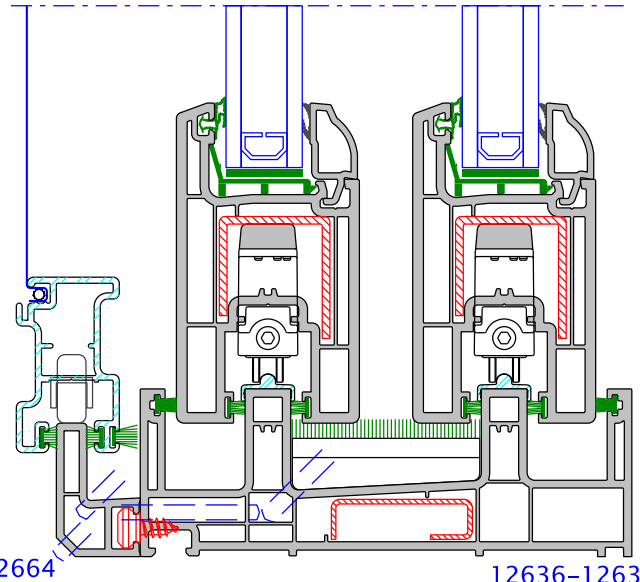




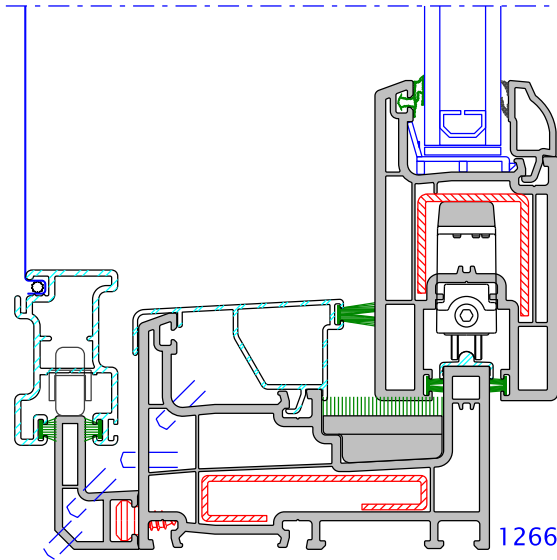
In the case of sliding frames (12660,12662,12664,12661 and 12663) since it is not possible to install drainage caps , water slots should be drilled also on flyscreen rails.The numbers of water discharge slots for flyscreen rails should be equal to sliding frame.Please find the application on the drawing below.



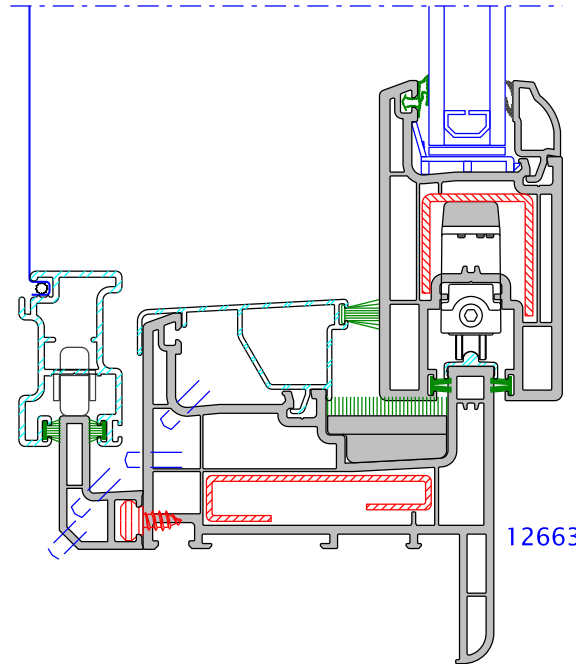
12660/12662/12664



12636-12637



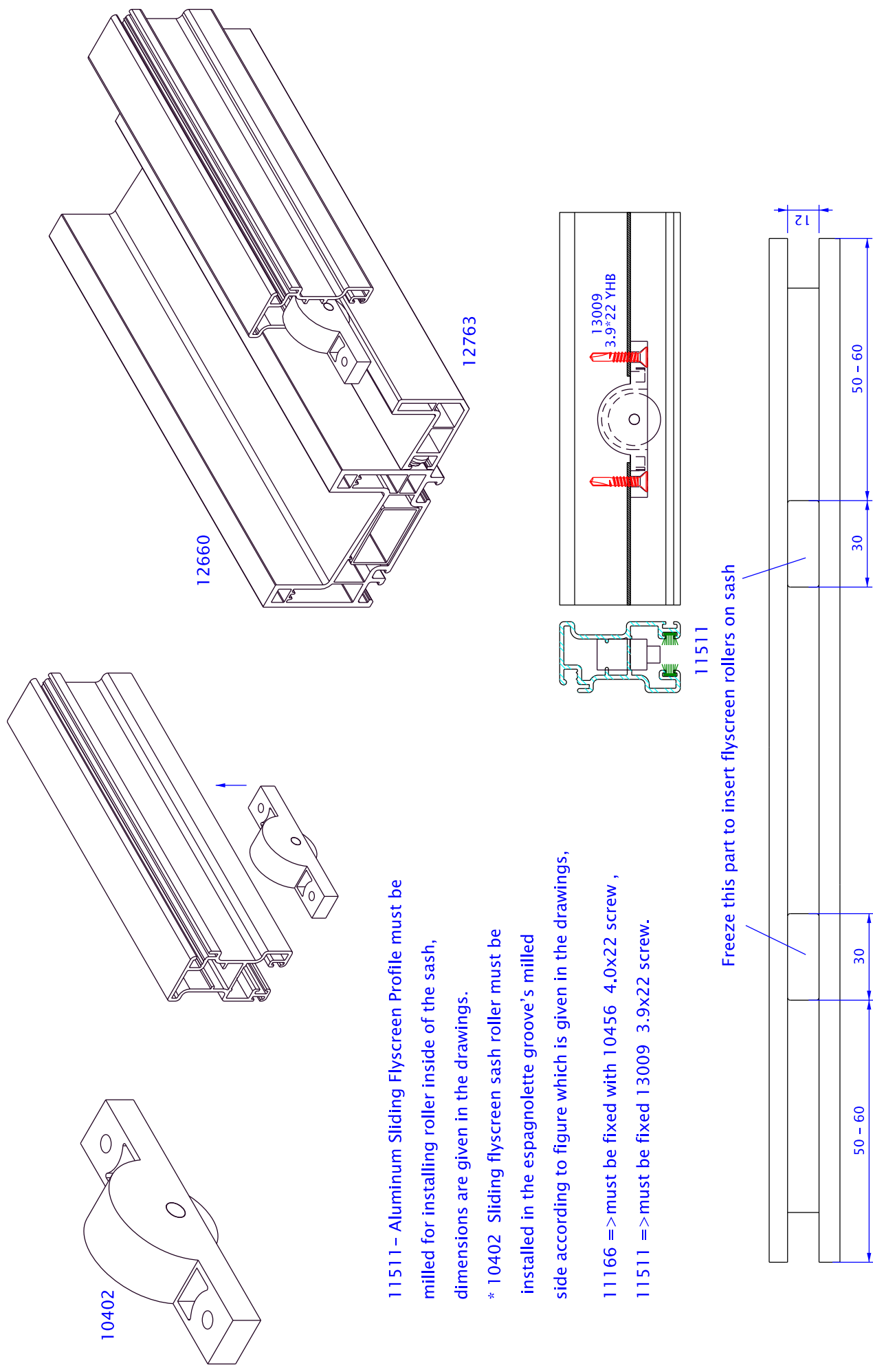
12661



12663

WELDING :

- * Flyscreen rails are welded and corner cleanings are done.
- * Brushes which are used inside of flyscreen sash, are inserted before welding.
- * After corner cleaning process, the brush that has the dimension as 48x1000 is inserted on outside of flyscreen sash according to the detail.

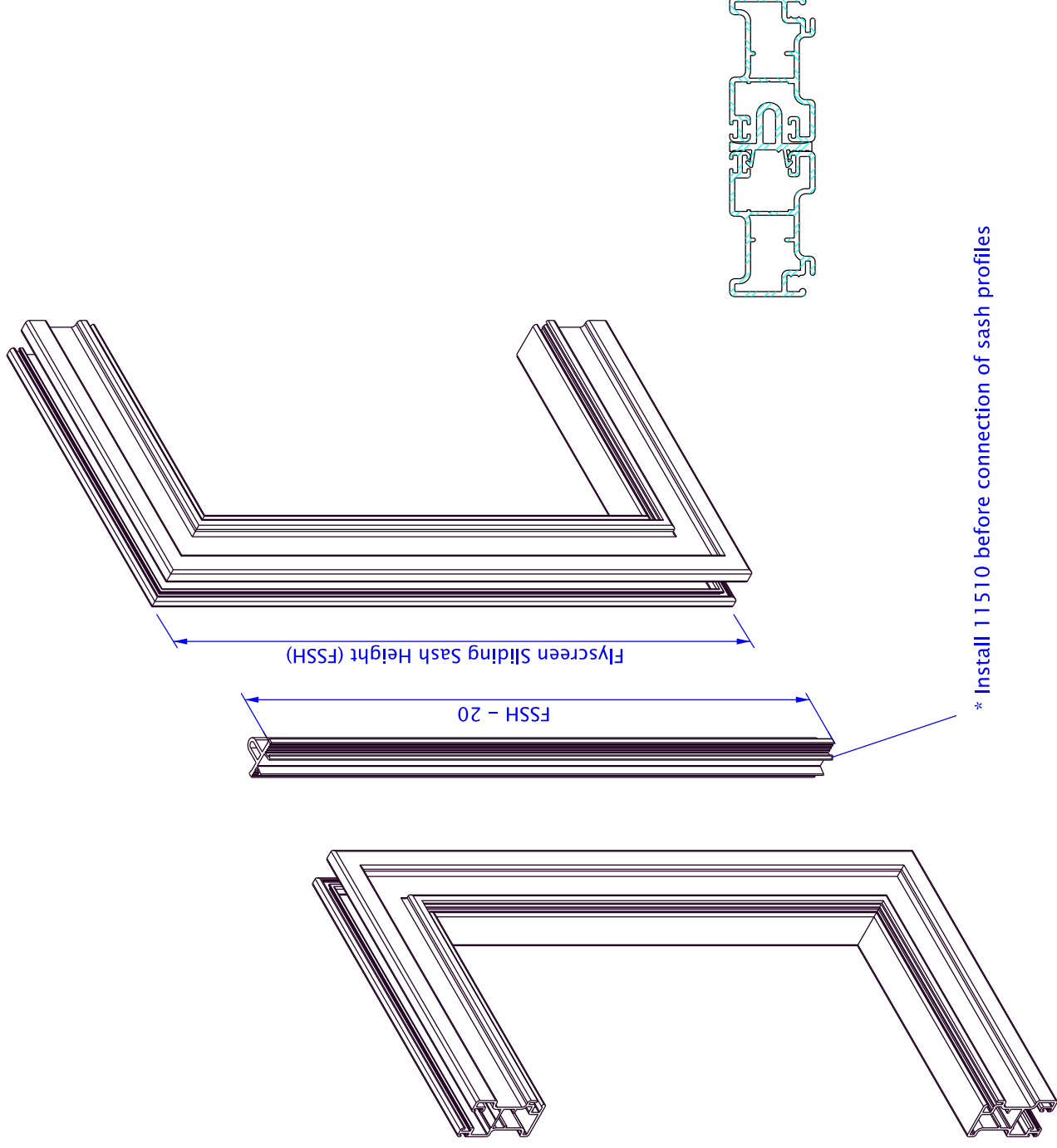
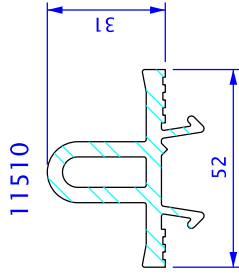


11511 – Aluminum Sliding Flyscreen Profile must be milled for installing roller inside of the sash, dimensions are given in the drawings.

* 10402 Sliding flyscreen sash roller must be installed in the espagnolette groove's milled side according to figure which is given in the drawings,

11166 => must be fixed with 10456 4.0x22 screw ,

11511 => must be fixed 13009 3.9x22 screw.



* Install 11510 before connection of sash profiles