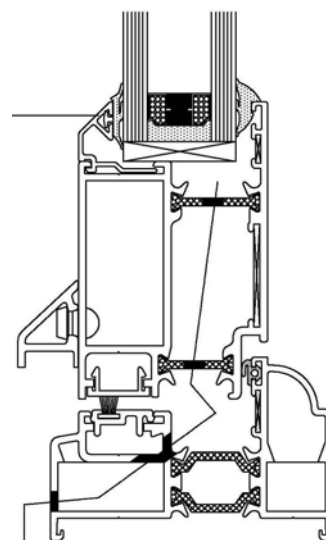


alitherm door

DOORS - 47mm



Smart Architectural Aluminium

Alitherm Door **Technical Manual**

January 2009

For further information visit www.smartsystems.co.uk

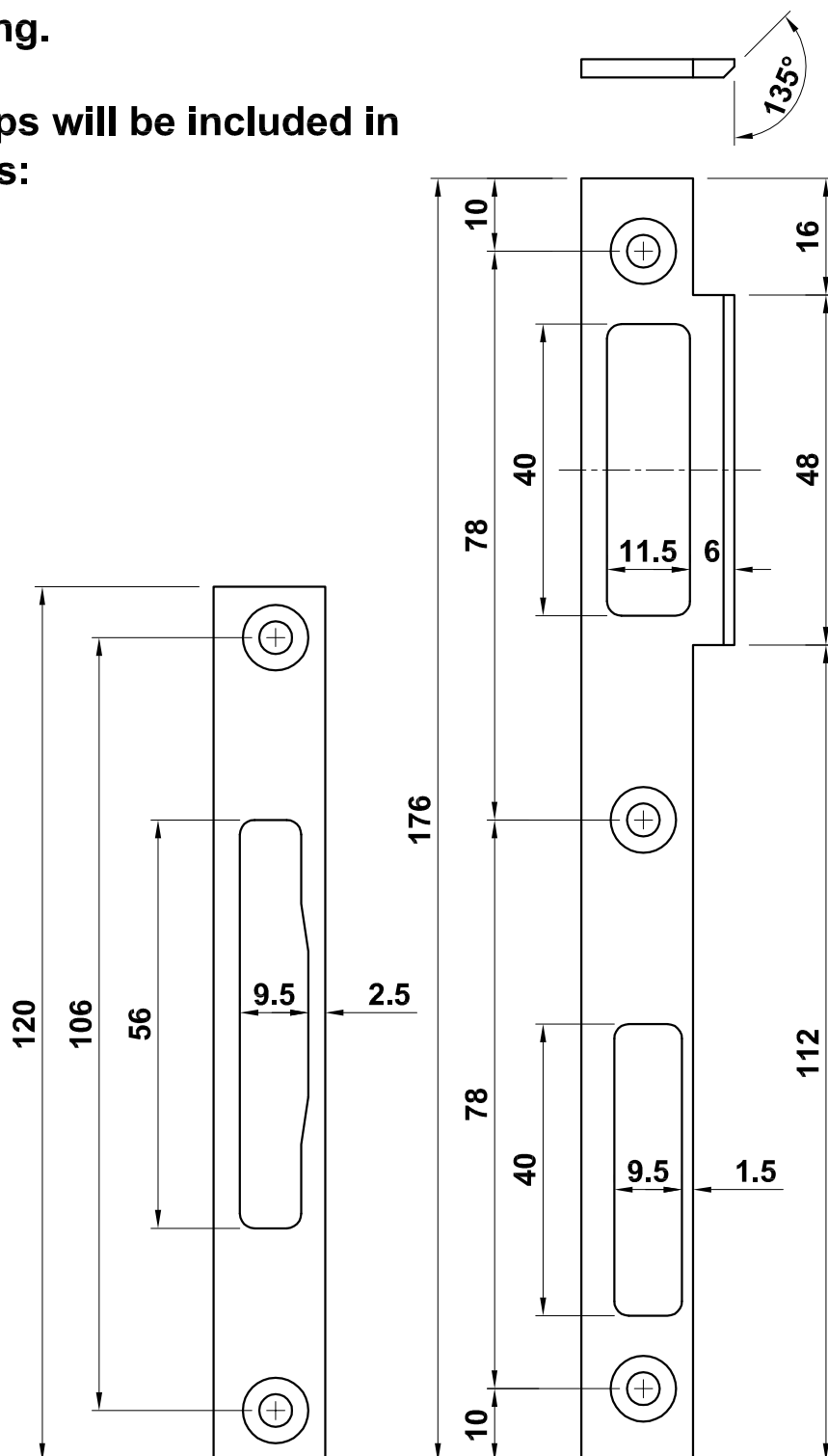
© Smart Systems Ltd 2009

Bulletin

The keeps for Alitherm Door have been modified to allow for smoother locking. Please note the dimensions prior to machining.


The revised keeps will be included in the following kits:

- ACET085
- ACET086
- ACET087
- ACET088
- ACET140
- ACET141
- ACET142
- ACET143



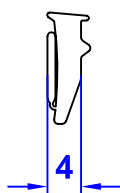
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New

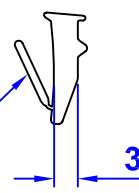
Image	Part Code	Pack	Unit	Application
	ACW20038 4-3mm Tear-away Low-line Wedge Gasket Black Only	200	m	Alitherm series, Evolution

ACW20038

New alternative wedge gasket to ACW20034 with tear-away strip to reduce from a 4mm wedge to 3mm wedge.

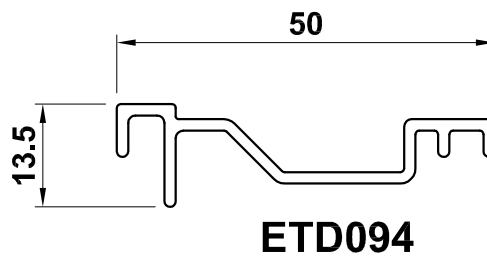


1mm tear-away



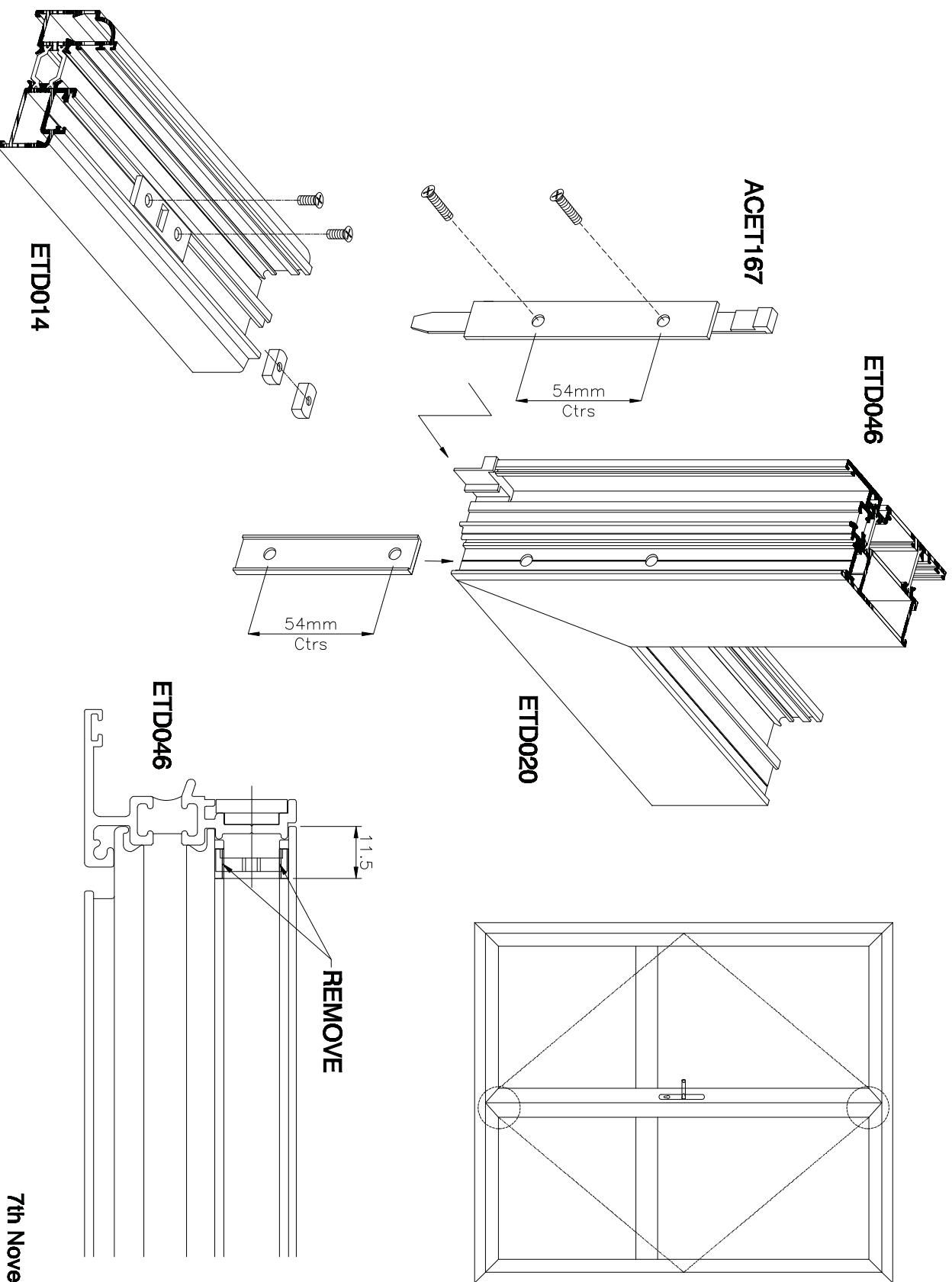
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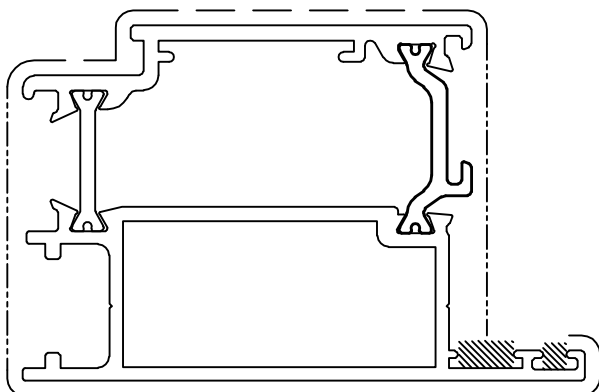
ETD094 is to be put on run-down with immediate effect.



No alternative will be introduced


Note: ACET167 will supersede ACET120 & ACET121 which are now on rundown.

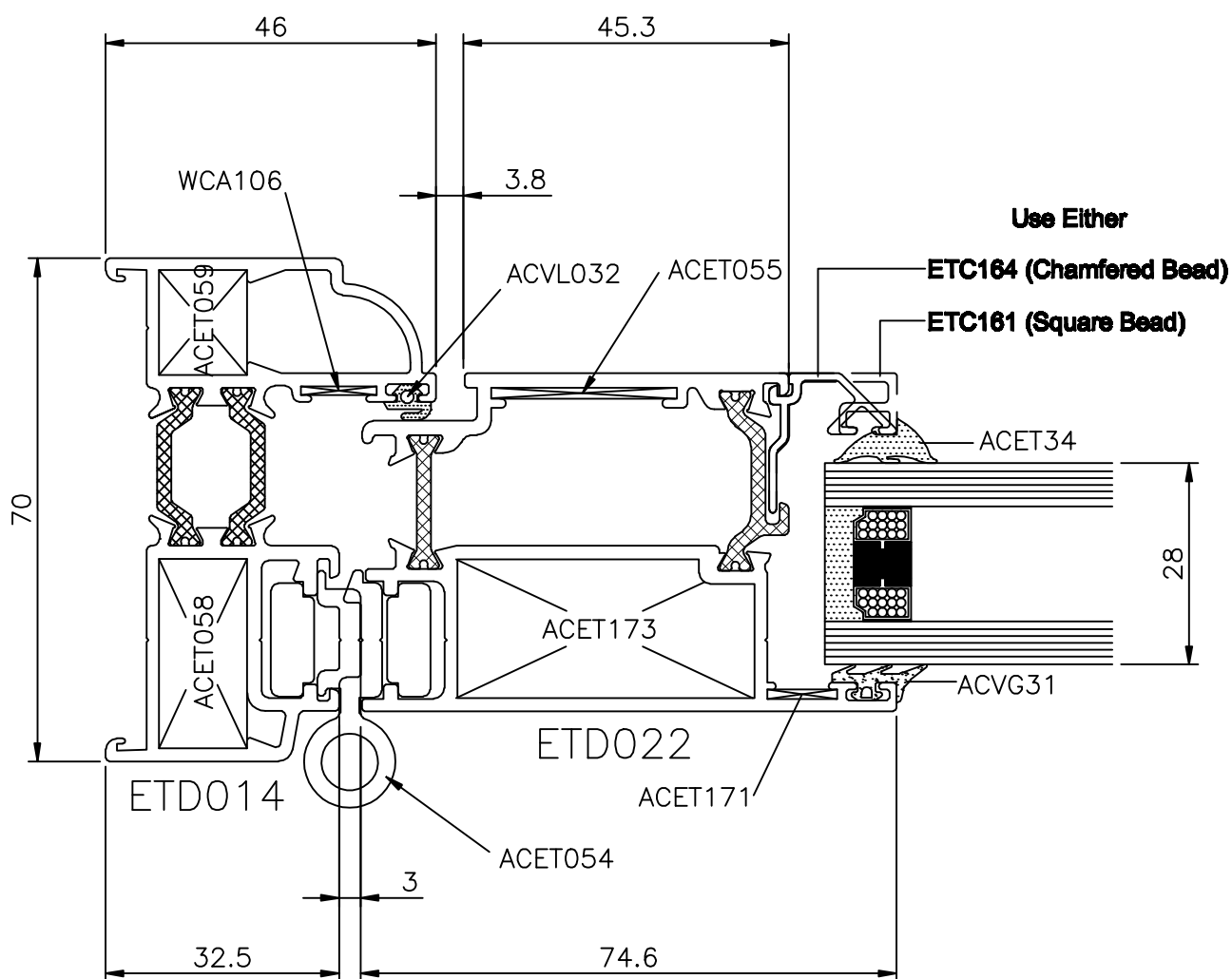


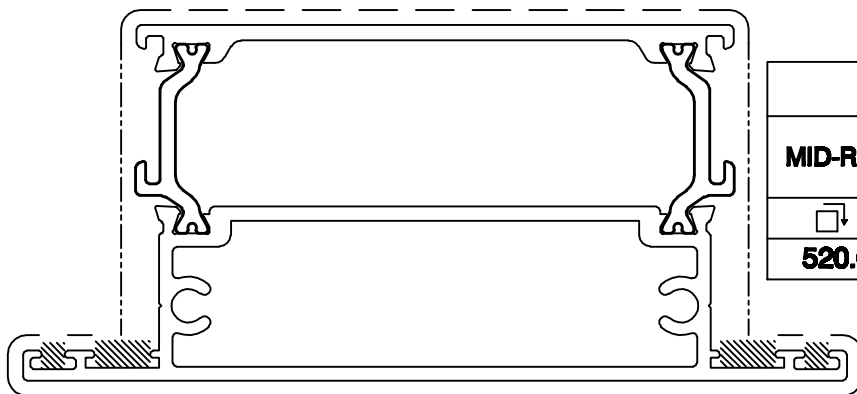


ETD 022

VENT-OPEN OUT INTERNALLY BEADED

	lxx	lyy	L
443.3mm	15.64	20.90	6500mm

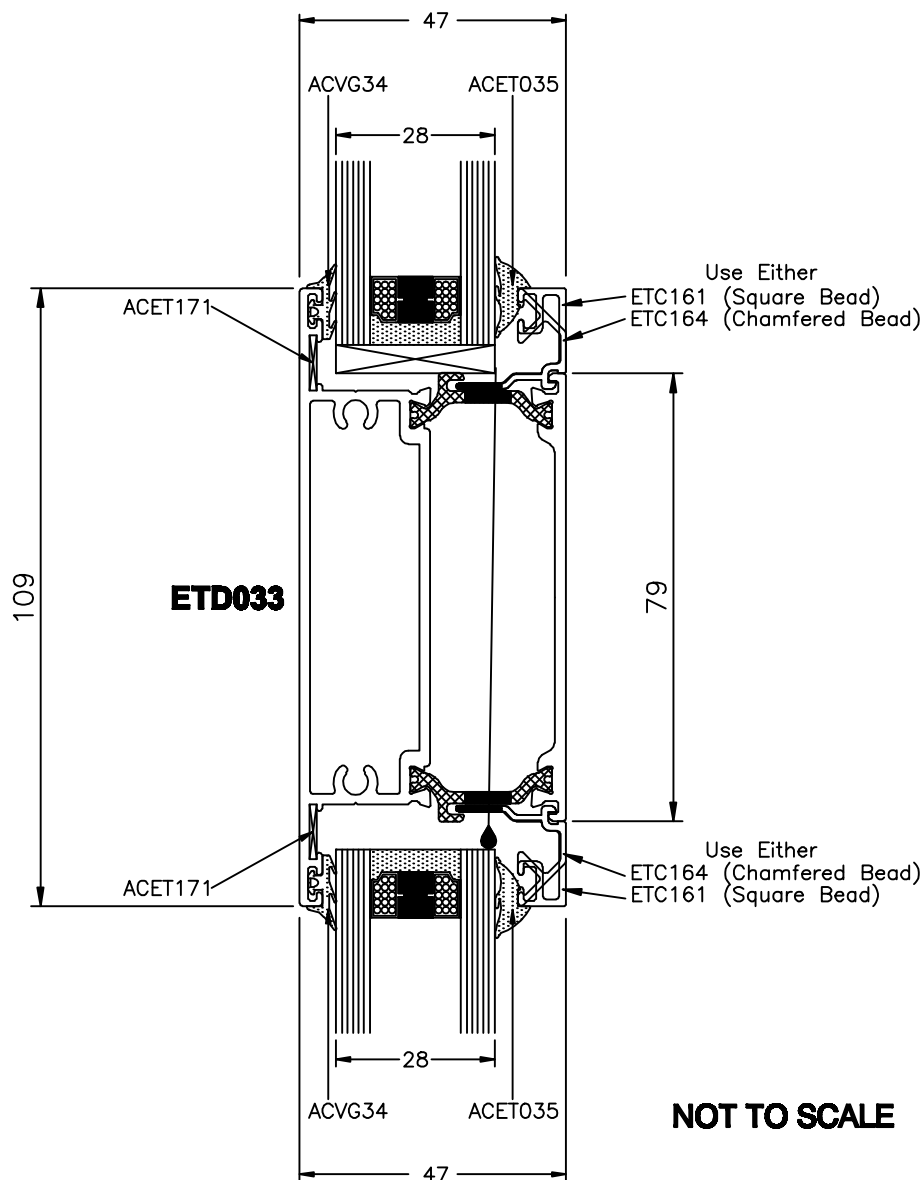




ETD 033

MID-RAIL-OPEN OUT INTERNALLY BEADED

	bx	lyy	L
	520.0	21.6	57.3
			6500mm



Bulletin

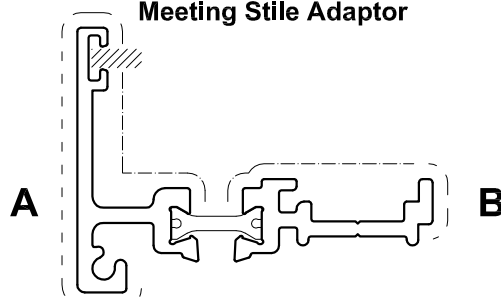
ETD146:

New Meeting Stile Adaptor to replace ETD046 from 1st July 2014

Number	Perim. mm	Mec. mm	lx(cm4) wx(cm3)	ly(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
ETD146	250	52	5.56 ----- 1.82	1.40 ----- 1.19	6.5	1	✓	✓	✓	✓	✓

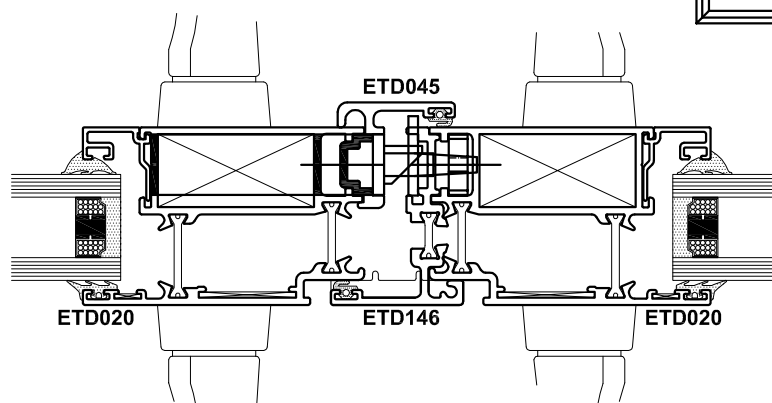
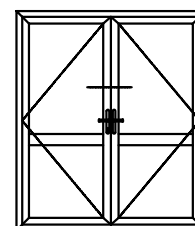
ETD146

Meeting Stile Adaptor



End Cap = ACET053

Note: Deductions are the same as ETD046



ETD Index

Index	Page 01
Blank	Page 02

A ETD

Profiles

Technical Information	Page 03 to 05
Scaled Profile Drawings	Page 06 to 12

B ETD

Accessories

Photos & Drawings	Page 13 to 26
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C ETD

Sections

Open In - Scaled Elevations	Page 27 to 50
Open Out - Scaled Elevations	Page 51 to 76

D ETD

Pas 23/24

Open In	Page 77 to 86
Open Out - Details Not Yet Available	Page 87 to 88

E ETD

Construction Drawings << Open In Index with Open Out Index>>	Page 89 to 90
1 - Corner Jointing	Page 91 to 97
2 - Transom/Mullion Fixings	Page 98 to 101
3 - Stays / Hinges--System Parameters Page 102.....	Page 102 to 102
4 - Locking Hardware--System Parameters Page 103.....	Page 103 to 117
5 - Bead & Glazing	Page 118 to 118
6 - Drainage	Page 119 to 121
7 - Miscellaneous	Page 122 to 124

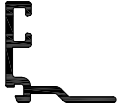




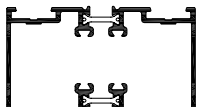
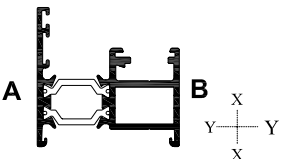
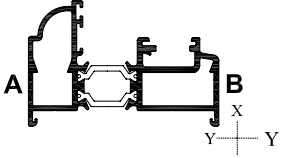
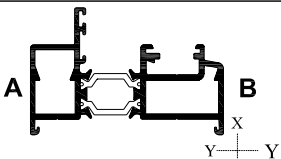
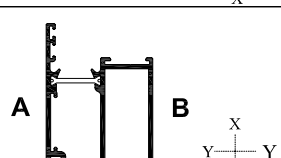
E ETD

Construction Drawings << Open Out Index with Open In Index	Page 125 to 126
1 - Corner Jointing	Page 127 to 133
2 - Transom/Mullion Fixings	Page 134 to 137
3 - Stays / Hinges--System Parameters Page 138.....	Page 138 to 138
4 - Locking Hardware--System Parameters Page 139.....	Page 139 to 153
5 - Bead & Glazing	Page 154 to 154
6 - Drainage	Page 155 to 157
7 - Miscellaneous	Page 158 to 160

F ETD

Sawing Tables << Open In >>	
Cutting Information	Page 161 to 167
Sawing Tables << Open Out >>	
Cutting Information	Page 168 to 172

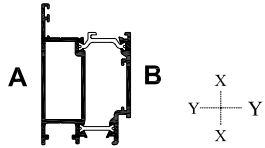
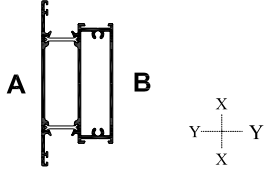
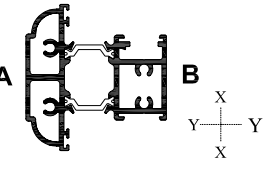
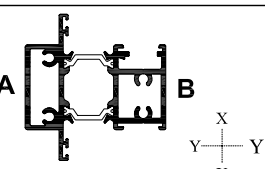
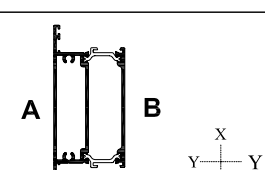
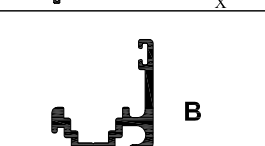
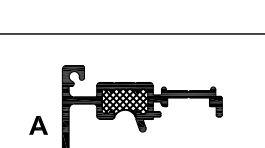
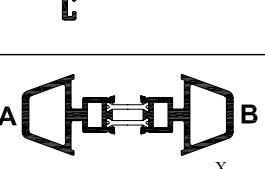
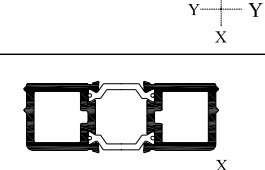
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Number	Picture	Page	Perim. mm	Mec. mm	lxx cm4	lyy cm4	Length	Pack pr.	MF	SA	KL	HP	M
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ETC161		6	115	27	-	-	6.5	1	X	X	X	X	
ETC162		6	123	31	-	-	6.5	1	X	X	X	X	
ETC163		6	106	26	-	-	6.5	1	X	X	X	X	
ETC164		6	103	25	-	-	6.5	1	X	X	X	X	
ETC515		6	631	97	-	-	6.5	1	X	X	X	X	X
ETD010		7	302	89	10.4 4.3	3.9 2.1	6.5	1	X	X	X	X	X
ETD014		7	340	107	26.8 7.3	6.1 3.1	6.5	1	X	X	X	X	X
ETD018		7	345	110	25.8 7.2	5.2 2.7	6.5	1	X	X	X	X	X
ETD020		8	354	151	15.4 6.3	21.4 6.6	6.5	1	X	X	X	X	X

MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

A = Outside
 B = Inside

Number	Picture	Page	Perim. mm	Mec. mm	Ixx cm4	Iyy cm4	Length	Pack pr.	MF	SA	KL	HP	M
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ETD032		9	362	146	27.8 --- 8.7	13 --- 4.1	6.5	1	X	X	X	X	X
ETD033		8	418	203	21.6 --- 8.7	57.3 --- 10.5	6.5	1	X	X	X	X	X
ETD045		9	172	32	-	-	5	1	X	X	X	X	
ETD046		9	239	47	-	-	5	1	X	X	X	X	
ETD051		10	335	140	65.3 --- 14	5.7 --- 3.2	6.5	1	X	X	X	X	X
ETD053		10	175	0	19.4 --- 6.0	2.7 --- 2.3	6.5	1	X				



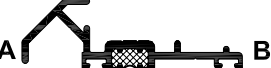

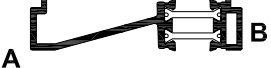

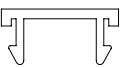


 A = Outside
 B = Inside

 GOZ = Gold
 W = White
 Z = Black

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

Profiles

Drawing Number: aETD-03-00

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ETD093		11	221	70	-	-	5	1	X	X	X	X	
ETD094		11	165	76	-	-	6.5	1	X	X			
ETD095		11	239	29	-	-	6.5	1	X	X	X	X	X
EUD03		11	113	39	-	-	4	1	X	X			
PCX15		11	163	-	-	-	4	1	X				
PCX16		11	45	22	-	-	5	1	X				
VL72		11	101	54	-	-	6.5	1	X	X	X	X	

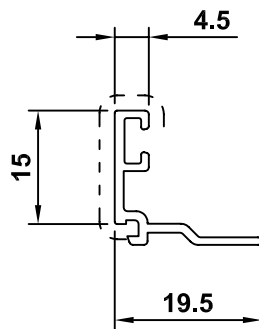
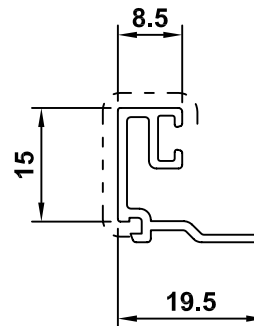
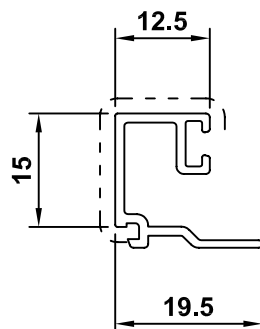
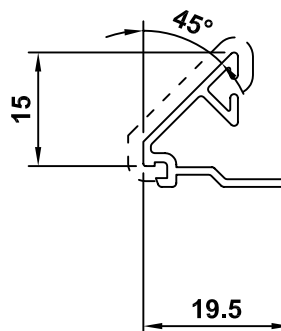
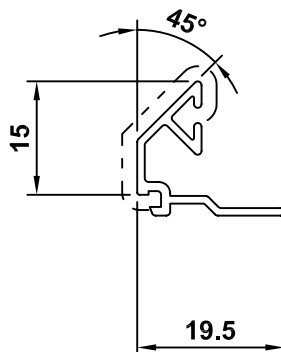
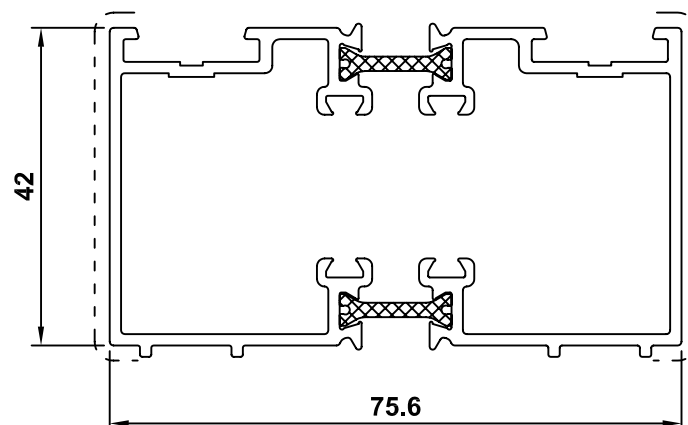
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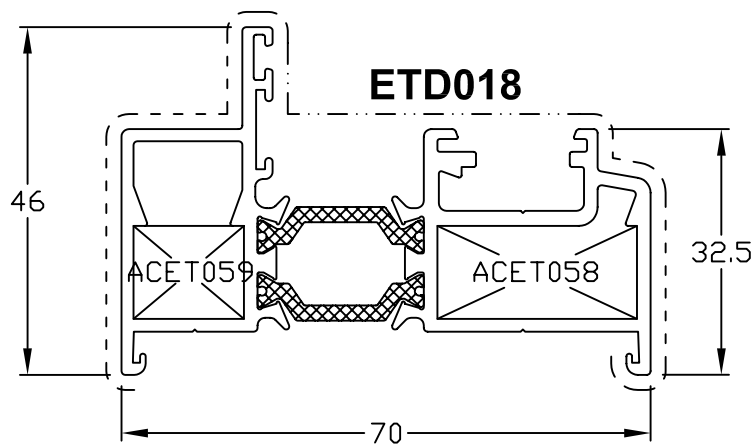
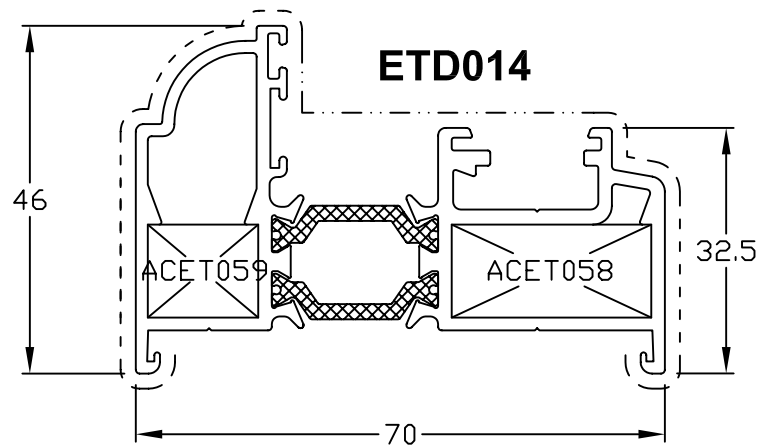
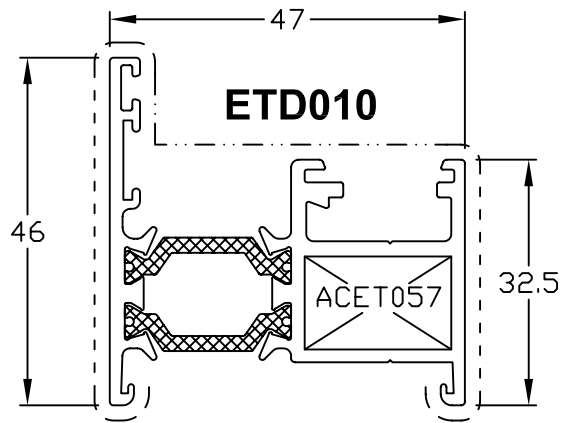
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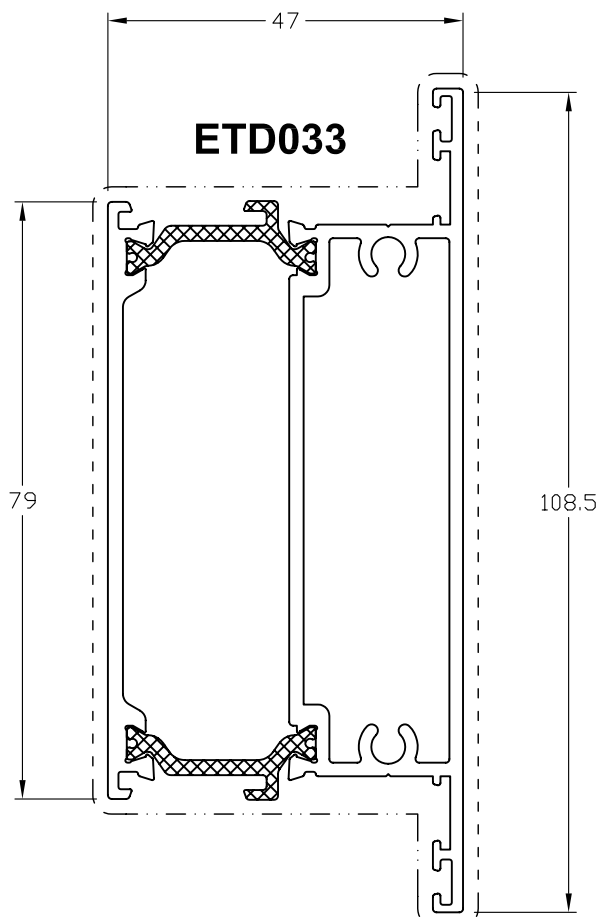
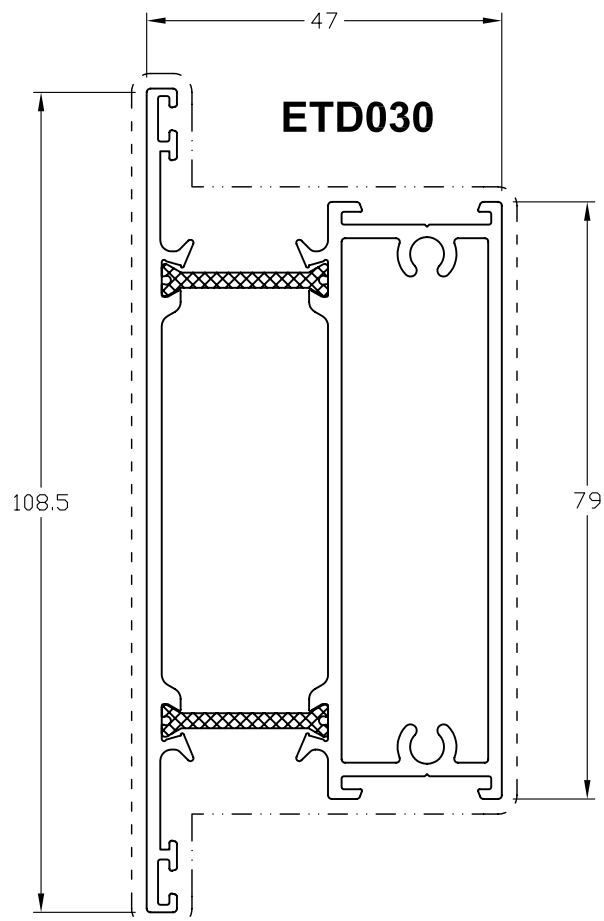
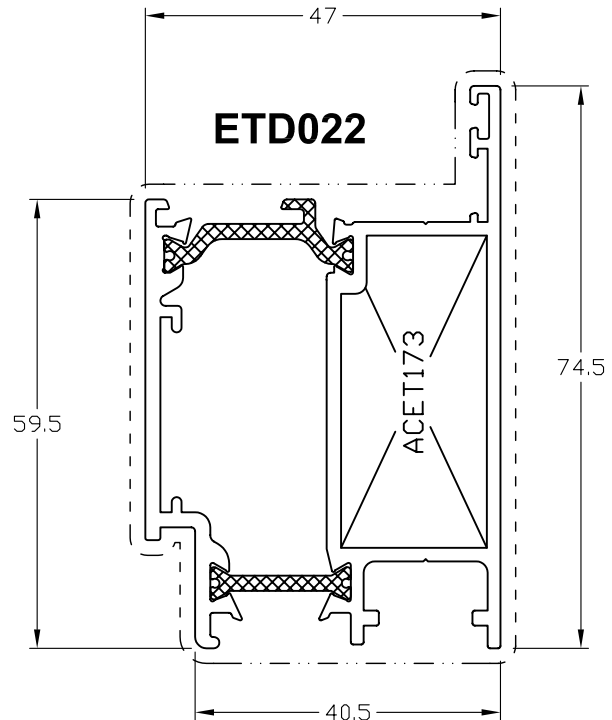
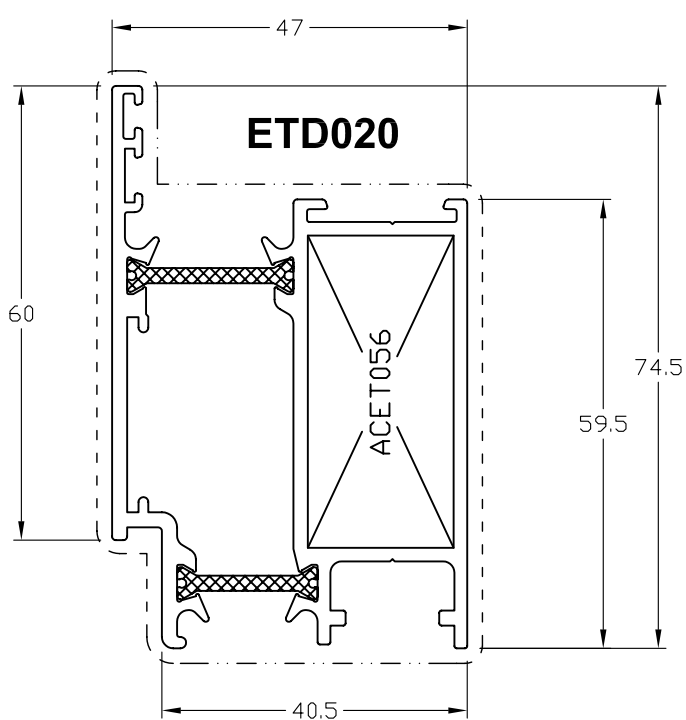
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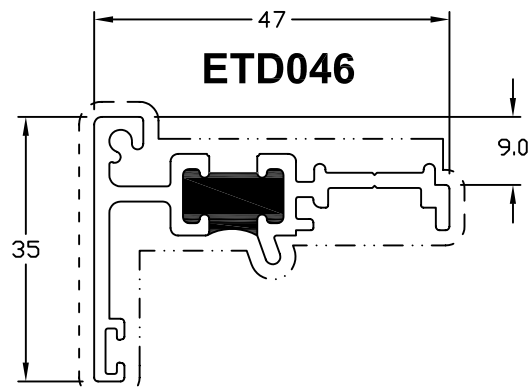
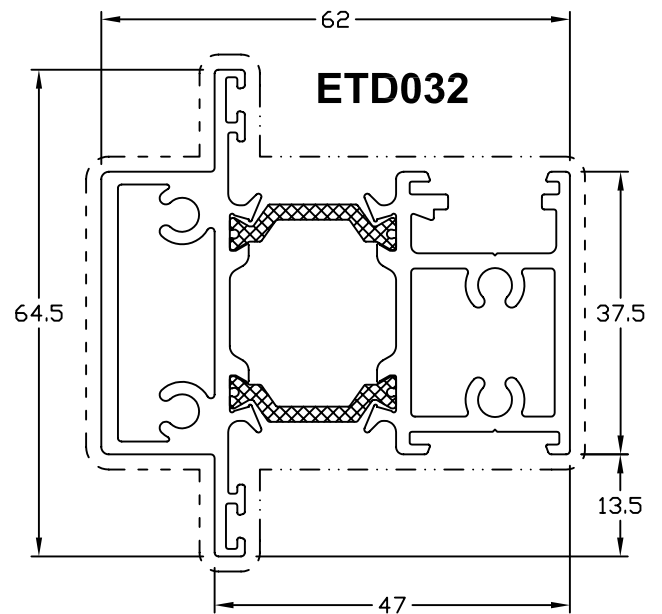
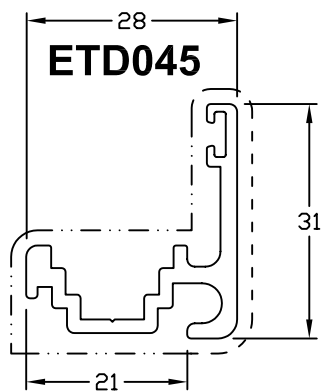
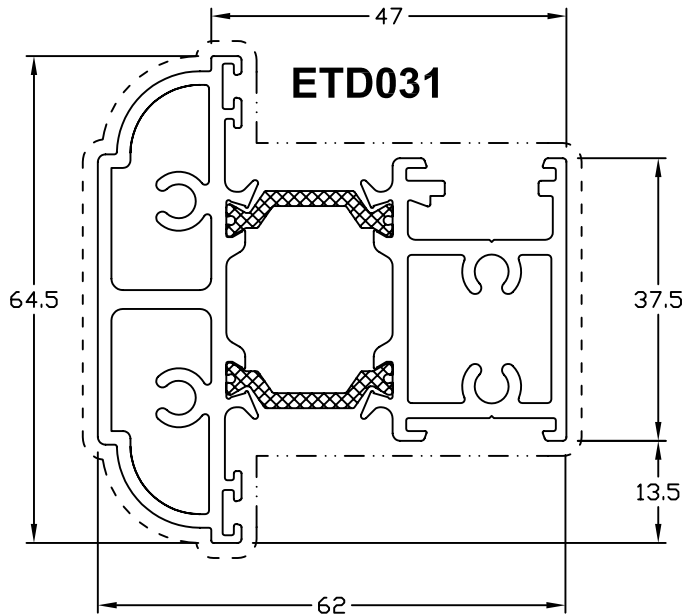
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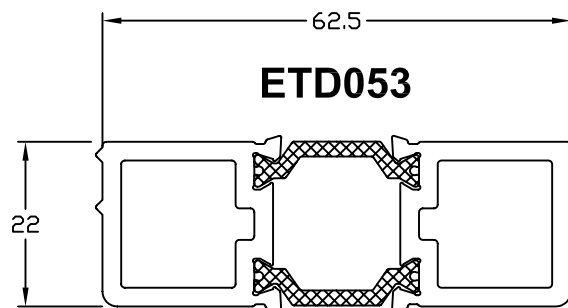
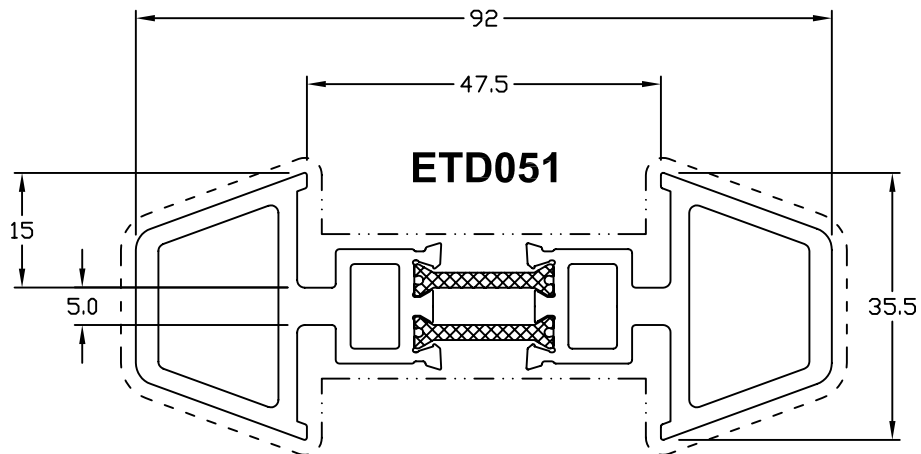
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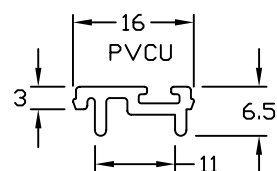
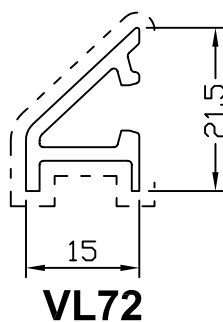
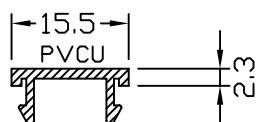
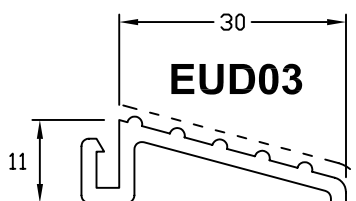
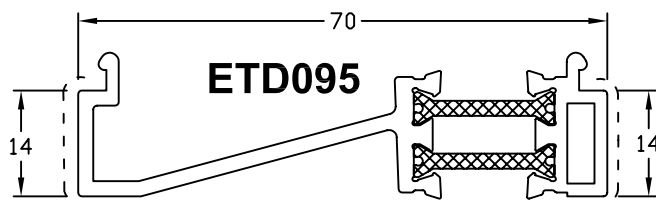
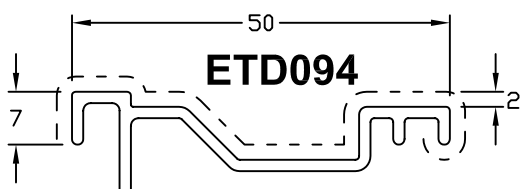
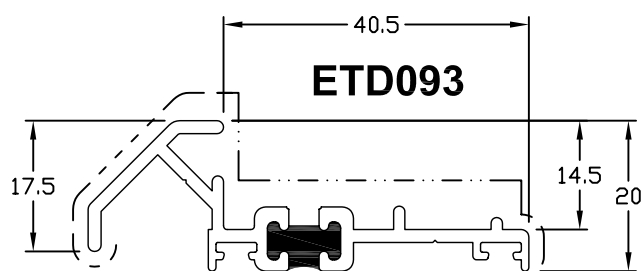
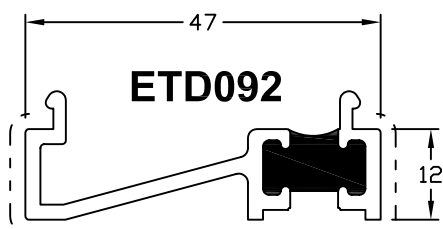
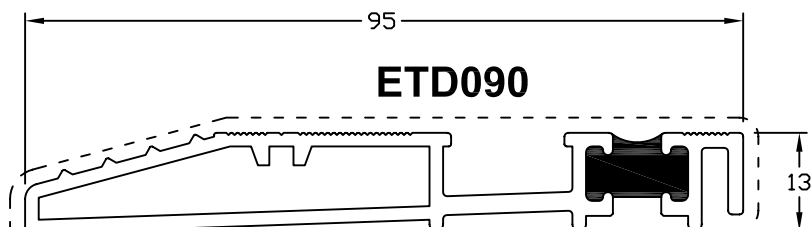
Primary Visible Side

Secondary Visible Side



Primary Visible Side

Secondary Visible Side



Primary Visible Side

Secondary Visible Side


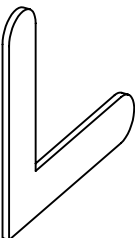
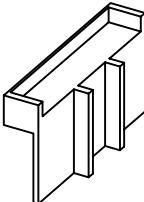
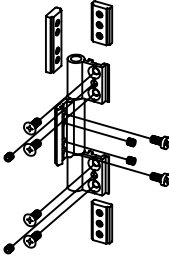
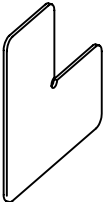
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Accessories

(Accessory Details)

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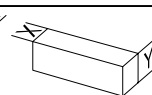
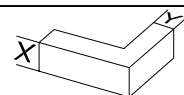
Accessories

Image	Part Code	Pack	Unit	Application	Colour
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					SA
					KL
					HP
					M
					GOZ
					W
					Z X
	ACET045 Chevron	100	Each	ETD020 ETC046	MF X
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACET053 End Cap	10	Each	ETD046	MF
					SA
					KL
					HP
					M
					GOZ
					W X
					Z X
	ACET054 Hinge Kit	3	Each	ETD020 ETD022 Attached to ETD010 ETD014 ETD018 ETD031	MF
					SA X
					KL
					HP
					M
					GOZ X
					W X
					Z X
	ACET055 Chevron	24	Each	ETD020 ETD022	MF X
					SA
					KL
					HP
					M
					GOZ
					W
					Z

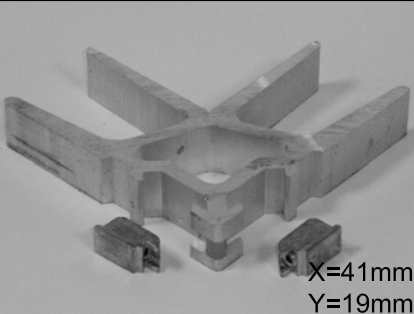
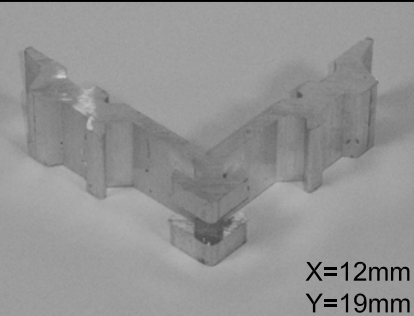
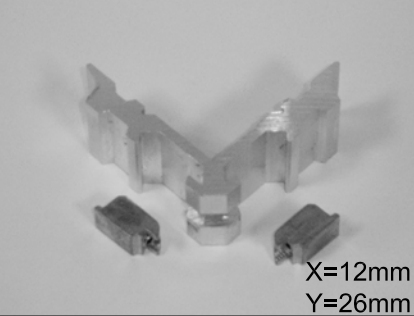
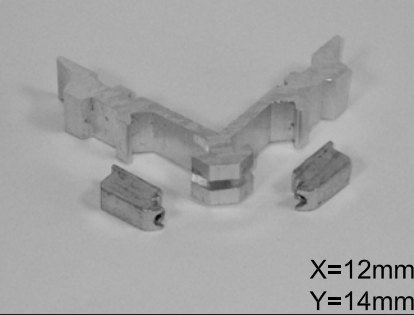
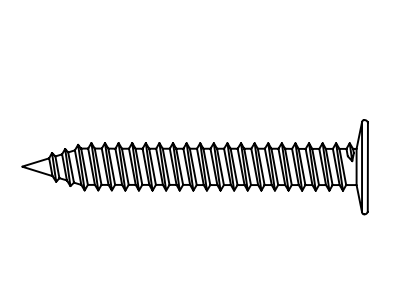

 T-BARS
 ACVG65=2,5mm
 ACVG66=3,0mm
 ACVL150=4,0mm

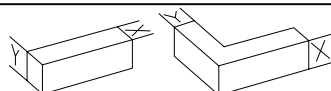

Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

 GOZ = Gold
 W = White
 Z = Black


Accessories

Image	Part Code	Pack	Unit	Application	Colour	
 <div>X=41mm Y=19mm</div>	ACET056 Cleat	24	Pack	ETD020	MF	X
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
 <div>X=12mm Y=19mm</div>	ACET057 Cleat	24	Pack	ETD010	MF	X
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
 <div>X=12mm Y=26mm</div>	ACET058 Cleat	24	Pack	ETD014 ETD018	MF	X
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
 <div>X=12mm Y=14mm</div>	ACET059 Cleat	24	Pack	ETD014 ETD018	MF	X
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
	ACET060 7 X 1" CSK Stainless Steel Self Tapping Screw	100	Pack	ETC046	MF	X
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	



MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

Screw (Grub)






T-BARS
 ACVG65=2,5mm
 ACVG66=3,0mm
 ACVL150=4,0mm



Drawing Number: bETD-03-00

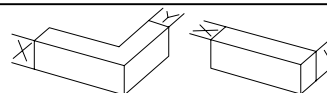
Accessories

Image	Part Code	Pack	Unit	Application	Colour	
	ACET065 No. 8 x 5/8 Pan Head Stainless Steel Self Tapping Screw	200	Pack	ETD014 Attached to ETD090	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
						ACET071 End Cap
SA						
KL						
HP						
M						
GOZ						
W	X					
Z	X					
	ACET079 Pan head screw No. 10 x 2 1/2"	100	Pack	ETD014 Attached to ETD031		
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					Continue on Next Page	
SA						
KL						
HP						
M						
GOZ						
W						
Z						

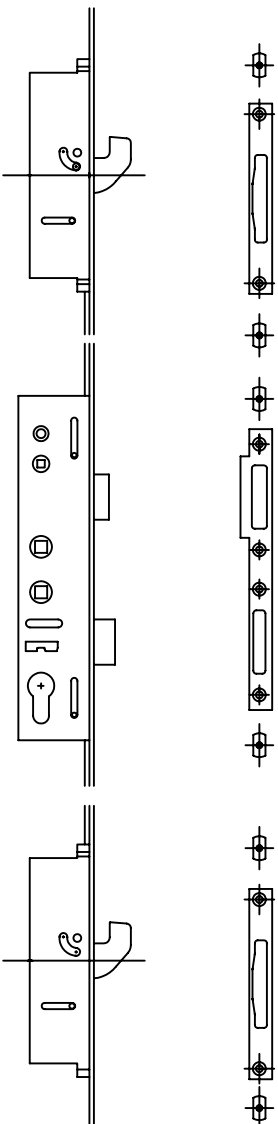
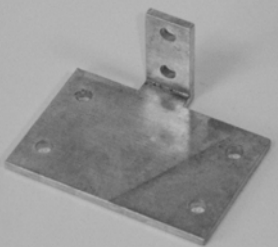

 T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm

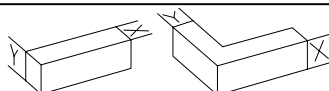

Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

 GOZ = Gold
 W = White
 Z = Black


Accessories

Image	Part Code	Pack	Unit	Application	Colour
35mm Backset 	ACET085 Single Door Lock Kit Single Open- In Left Hand Hung Single Open-Out Right Hand Hung PLK18 Lock PLK375 Right Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF X SA KL HP M GOZ W Z
	ACET086 Single Door Lock Kit Single Open-In Right Hand Hung Single Open-Out Left hand Hung PLK18 Lock PLK374 Left Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF X SA KL HP M GOZ W Z
	ACET087 - Short Lock Single Door Short Lock Kit Single Open-In Left hand Hung Single Open-Out Right Hand Hung PL61 Lock PLK375 Right Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF X SA KL HP M GOZ W Z
	ACET088 - Short Lock Single Door Short Lock Kit Single Open-In Right hand Hung Single Open-Out Left Hand Hung PL61 Lock PLK374 Left Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF X SA KL HP M GOZ W Z
	ACET096 Low Threshold Fixing Bracket	1	Pairs	ETD014 ETD018 ETD090	MF X SA KL HP M GOZ W Z



MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

Screw (Grub)



T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm



Drawing Number: bETD-05-00

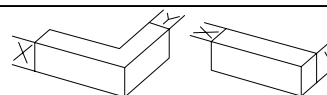
Accessories

Image	Part Code	Pack	Unit	Application	Colour
	ACET098 End Caps	20	Each	ETC157 ETC158 ETD014 ETD031 ETD094	MF
					SA
					KL
					HP
					M
					GOZ
					W X
					Z
	ACET104 Packers	50	Each	ETD010 ETD014 ETD031	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z X
	ACET133 Countersunk head screw M5 x 50	1	Each	ACVL117	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	Continue on Next Page				MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z

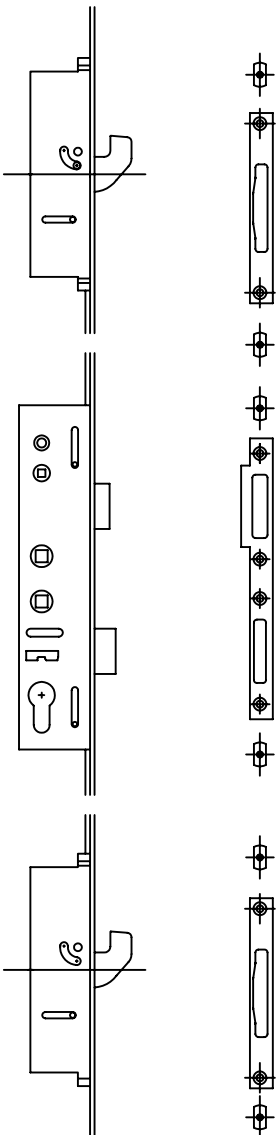


 T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm

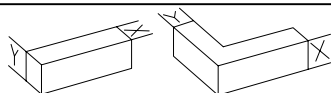

Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

 GOZ = Gold
 W = White
 Z = Black


Accessories

Image	Part Code	Pack	Unit	Application	Colour
45mm Backset 	ACET140 Double Door Lock Kit Double Open Out Right Hand Hung Master Double Open In Left Hand Hung Master PL18/45 PLK375 Right Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF <input checked="" type="checkbox"/> X SA <input type="checkbox"/> KL <input type="checkbox"/> HP <input type="checkbox"/> M <input type="checkbox"/> GOZ <input type="checkbox"/> W <input type="checkbox"/> Z <input type="checkbox"/>
	ACET141 Double Door Lock Kit Double Open Out Left Hand Hung Master Double Open In Right Hand Hung Master PL18/45 PLK374 Left Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF <input checked="" type="checkbox"/> X SA <input type="checkbox"/> KL <input type="checkbox"/> HP <input type="checkbox"/> M <input type="checkbox"/> GOZ <input type="checkbox"/> W <input type="checkbox"/> Z <input type="checkbox"/>
	ACET142 - Short Lock Double Door Short Lock Kit Double Open Out Right Hand Hung Master Double Open In Left Hand Hung Master PL18/45 Elite PLK375 Right Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF <input checked="" type="checkbox"/> X SA <input type="checkbox"/> KL <input type="checkbox"/> HP <input type="checkbox"/> M <input type="checkbox"/> GOZ <input type="checkbox"/> W <input type="checkbox"/> Z <input type="checkbox"/>
	ACET143 - Short Lock Double Door Short Lock Kit Double Open Out Left Hand Hung Master Double Open In Right Hand Hung Master PL18/45 Elite PLK374 Left Hand Keep Set	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022 ETD031 ETD032	MF <input checked="" type="checkbox"/> X SA <input type="checkbox"/> KL <input type="checkbox"/> HP <input type="checkbox"/> M <input type="checkbox"/> GOZ <input type="checkbox"/> W <input type="checkbox"/> Z <input type="checkbox"/>
	ACET149 Slimline Restrictor	1	Each	ETD010 ETD014 ETD018 ETD020 ETD022	MF <input checked="" type="checkbox"/> X SA <input type="checkbox"/> KL <input type="checkbox"/> HP <input type="checkbox"/> M <input type="checkbox"/> GOZ <input type="checkbox"/> W <input type="checkbox"/> Z <input type="checkbox"/>



MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

Screw (Grub)

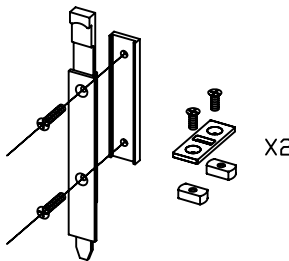
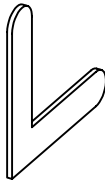
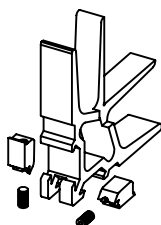




T-BARS
 ACVG65=2,5mm
 ACVG66=3,0mm
 ACVL150=4,0mm



Drawing Number: bETD-07-00

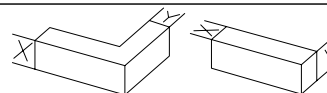
Accessories

Image	Part Code	Pack	Unit	Application	Colour	
	ACET167 Finger Bolt Assembly	1	Each	ETD020 ETD022 ETD046	MF	X
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
						ACET171 Chevron
SA						
KL						
HP						
M						
GOZ						
W						
Z						
	ACET173 Cleat	24	Pack	ETD022		
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
						ACSH471 Letter Plate Set Outside dimensions-265mm x 70mm with brush fitting
SA	X					
KL						
HP						
M						
GOZ	X					
W	X					
Z	X					
	ACMX09700 Alu Polish	1	Each	All Aluminium		
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	







 T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm

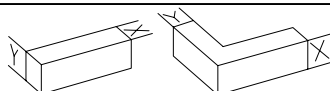

Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

 GOZ = Gold
 W = White
 Z = Black


Accessories

Image	Part Code	Pack	Unit	Application	Colour
	ACMX09761 Maxi-Gloss	1	Each	Gloss Finish Aluminium	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09762 Alu Bright	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09763 Teflon Spray	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09764 Maxi-Clean	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09765 Alu Cleaner	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z



MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

Screw (Grub)



T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm



Drawing Number: bETD-09-00

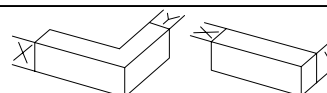
Accessories

Image	Part Code	Pack	Unit	Application	Colour
	ACMX09770 Roll & Wrap 100mm	1	Each		
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09775 Grip Handywrap	1	Each		
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09801 Protective Tape 50mm	1	Each		
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09802 Protective Tape 70mm	1	Each		
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACMX09803 Protective Tape 100mm	1	Each		
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z


 T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm

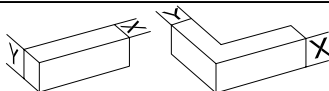

Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

 GOZ = Gold
 W = White
 Z = Black


Accessories

Image	Part Code	Pack	Unit	Application	Colour
	ACMX09830 Gum for EPDM-Rubber	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACSIL04 GW/Z Sealing Glue	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACSIL08 Silicone Gun	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACSIL013 Glue for Mitre	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACSIL014 Anti-Corro / Protection Product	1	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z



MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

Screw (Grub)

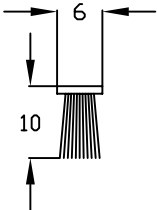
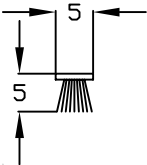





T-BARS
 ACVG65=2,5mm
 ACVG66=3,0mm
 ACVL150=4,0mm



Drawing Number: bETD-11-00

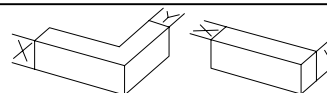
Accessories

Image	Part Code	Pack	Unit	Application	Colour
	ACSH038N Brush Pile	200	Each	ETD093	
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACSH039 Brush Pile	450	Each	PCX16	
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACVG31 Gasket	200	Each	ETC019 ETD010 ETD014 ETD020 ETD030 ETD033 ETD031	
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACVG34 Gasket	100	Each	ETC161 ETC164	
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	ACVL032 Seal	100	Each	ETD010 ETD014 ETD031 ETD045 ETD046	
					MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z



 T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm

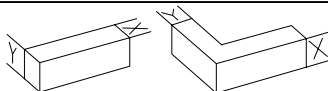

Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

 GOZ = Gold
 W = White
 Z = Black


Accessories

Image	Part Code	Pack	Unit	Application	Colour
	ACVL059 End Cap	1	Pair	VL72	MF
					SA
					KL
					HP
					M
					GOZ
					W X
					Z
	ACVL061 Rivet	100	Pack	VL72	MF
					SA X
					KL
					HP
					M
					GOZ
					W
					Z
 <small>ACET133 Fixing Screw</small>	ACVL117 Euro Cylinder 30/50 Use ACET133 Fixing Screws	1	Each	ETD020 ETD022	MF X
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	PUA056ssz Pan Head Screw No. 10 * 2	100	Each	ETD030 ETD033 Attached to ETD010 ETD020 ETD022	MF X
					SA
					KL
					HP
					M
					GOZ
					W
					Z
	RCA054ssz Countersunk head Self Tapping No. 8 * ¾ Screw	100	Each	ETD046	MF X
					SA
					KL
					HP
					M
					GOZ
					W
					Z



MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

GOZ = Gold
 W = White
 Z = Black

Screw (Grub)



T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm



Drawing Number: bETD-13-00

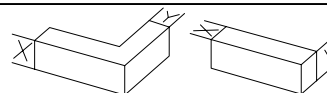
Accessories

Image	Part Code	Pack	Unit	Application	Colour
	RUA090 Lever / Lever handle with Keyhole (1 Spindle) Internally & Externally Locking	1	Each	ETD020 ETD022	MF
					SA X
					KL
					HP
					M
					GOZ X
					W X
					Z X
	RUA091 Lever / Pad Handle with Keyhole (2 Spindles)	1	Each	ETD020 ETD022	MF
					SA X
					KL
					HP
					M
					GOZ X
					W X
					Z X
	RUA092 Lever / Lever Handle without Keyhole	1	Each	ETD020 ETD022	MF
					SA X
					KL
					HP
					M
					GOZ X
					W X
					Z X
	UUA412 Drainage Cowl	20	Each		MF
					SA
					KL
					HP
					M
					GOZ
					W X
					Z X
	WCA106ssz Chevron	50	Each	ETD010 ETD014	MF X
					SA
					KL
					HP
					M
					GOZ
					W
					Z


 T-BARS
 ACVG65=2.5mm
 ACVG66=3.0mm
 ACVL150=4.0mm


Screw (Grub)

 MF = Mill Finish
 SA = Silver Anodised
 KL = Basic Colour
 HP = Special Colour
 M = Dual Colour

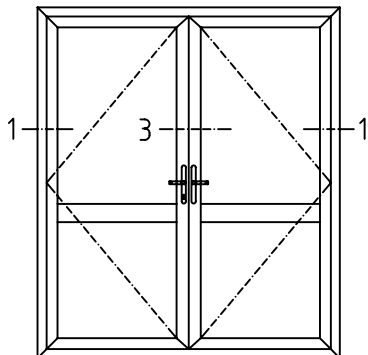
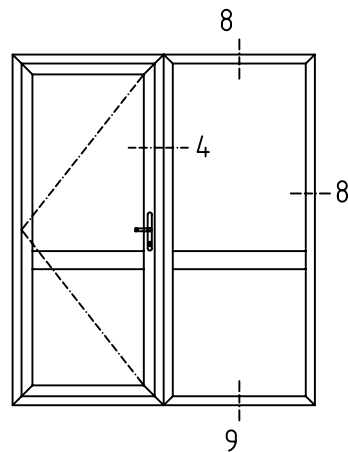
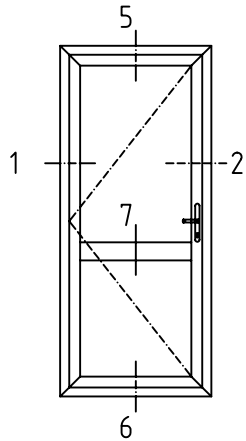
 GOZ = Gold
 W = White
 Z = Black


Doors - Open In

Sections

Doors - Open In

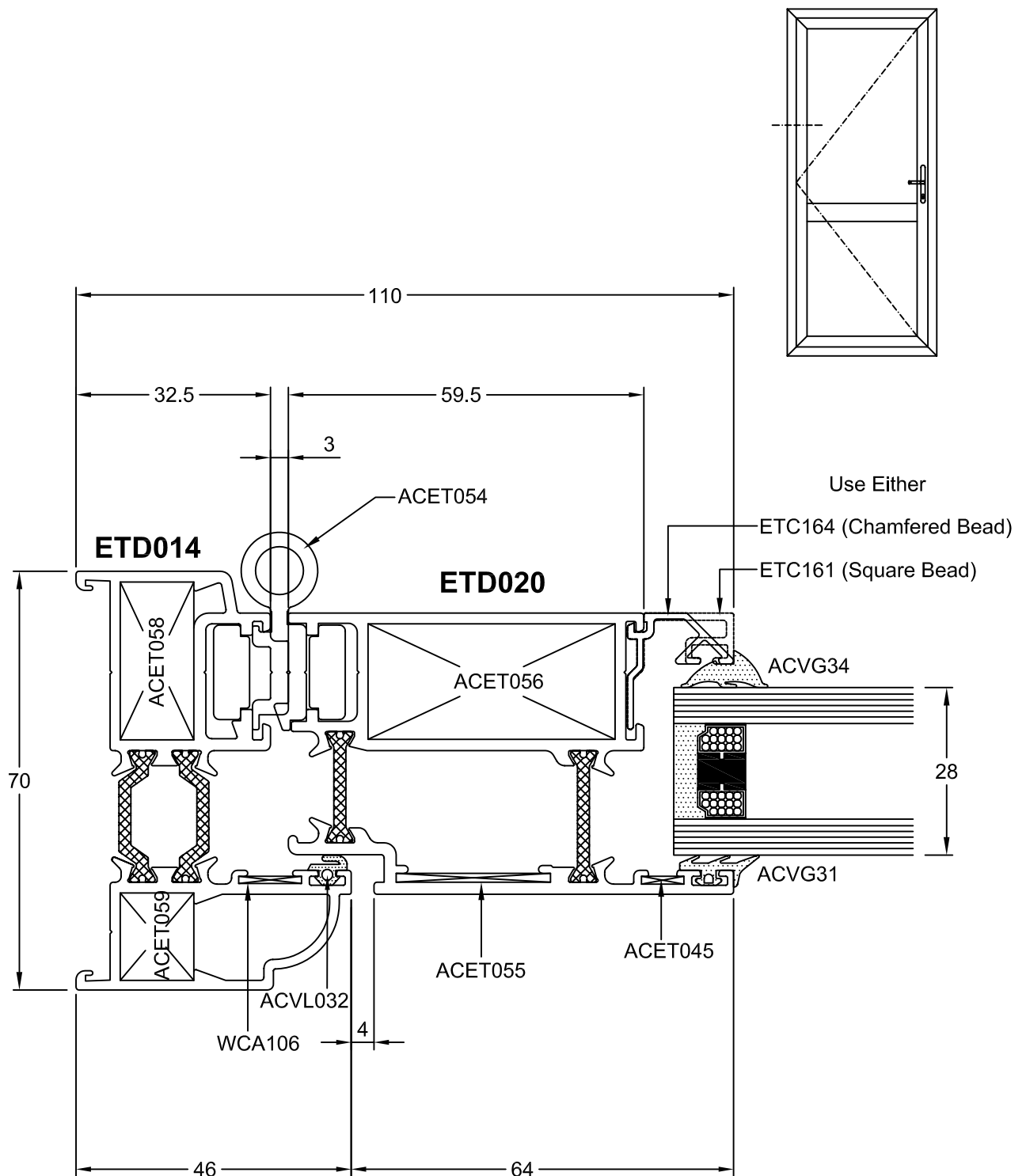
Doors - Open In



Scale 1:1

Doors - Open In

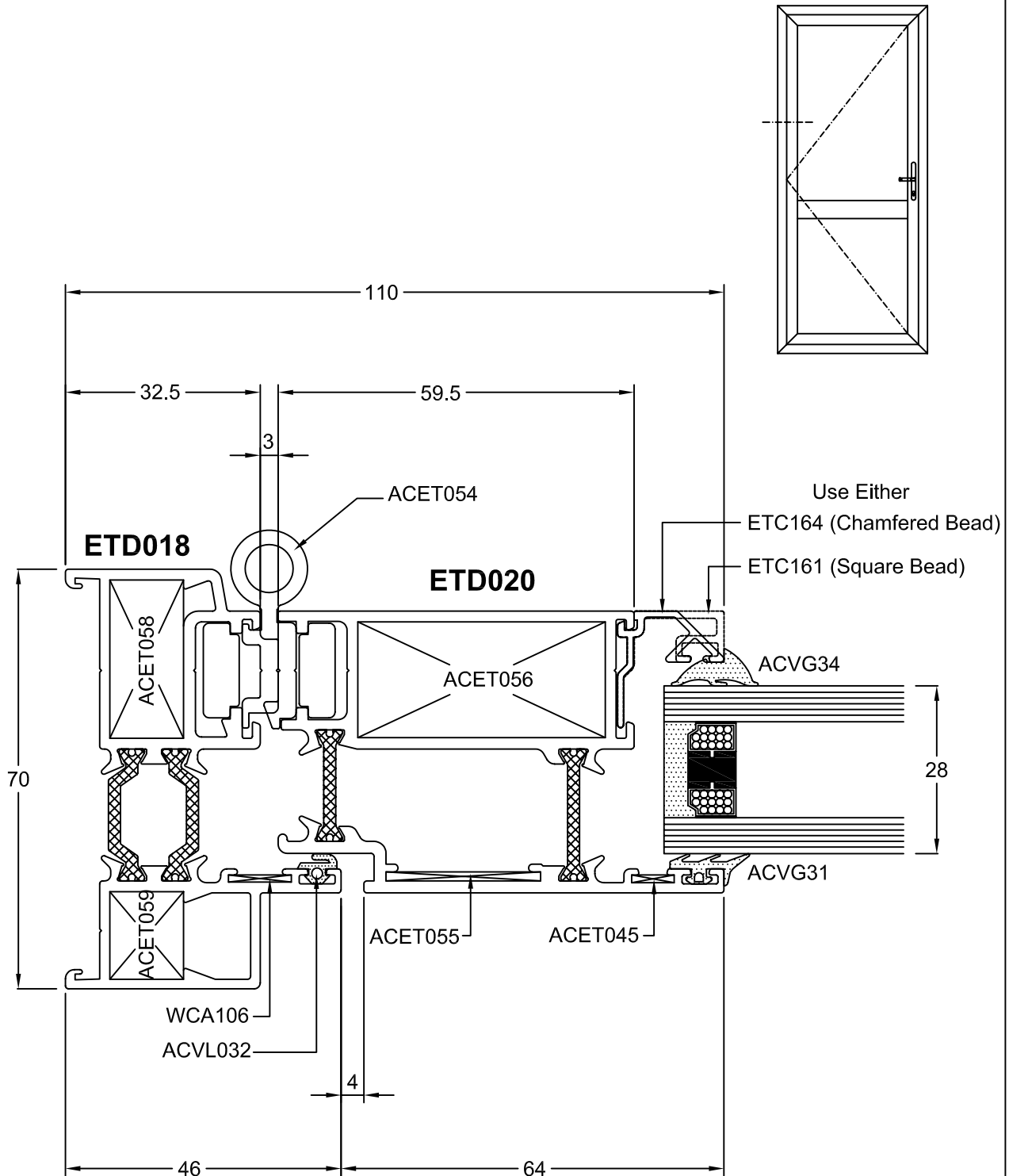
1a



1b

Doors - Open In

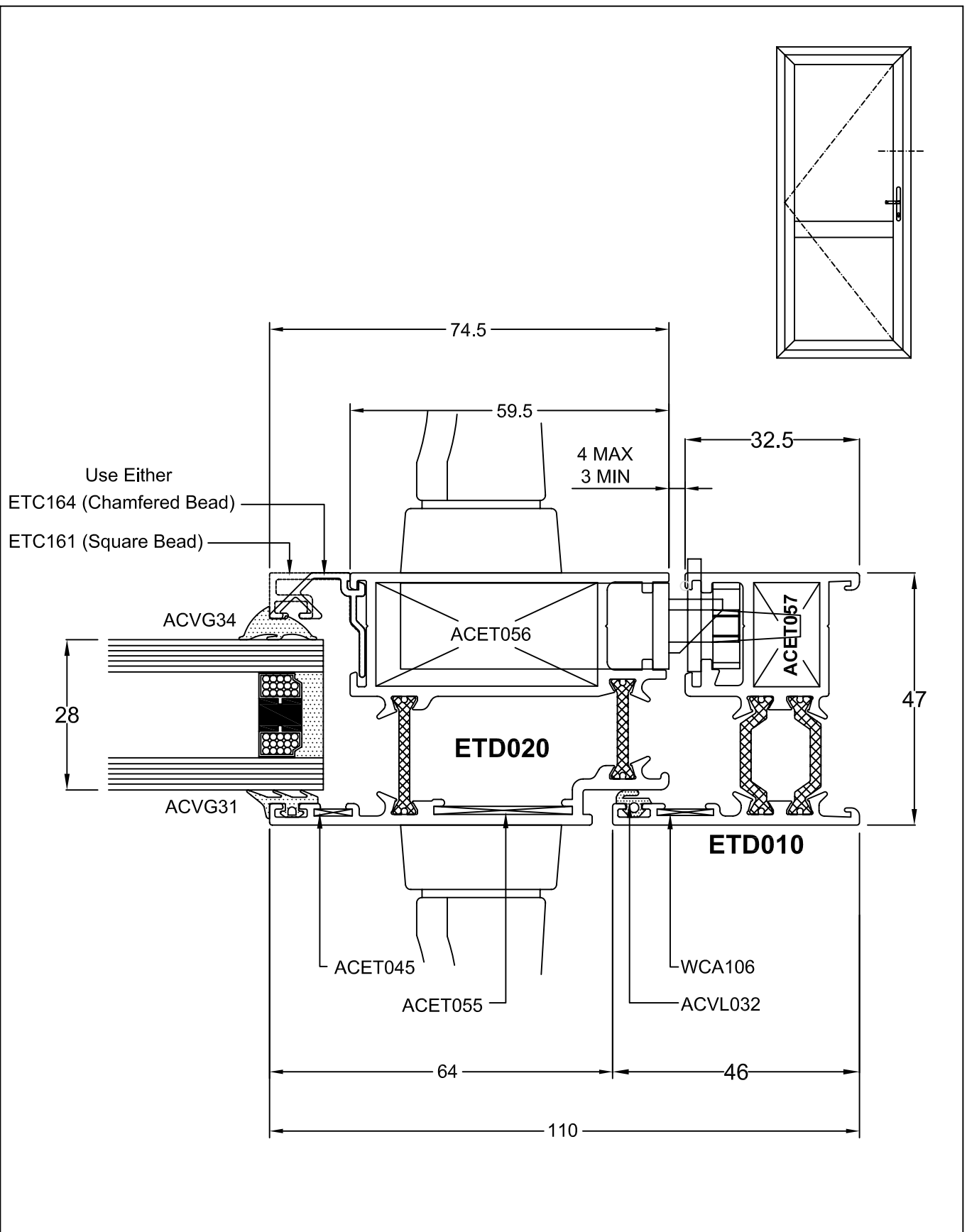
Scale 1:1



Scale 1:1

Doors - Open In

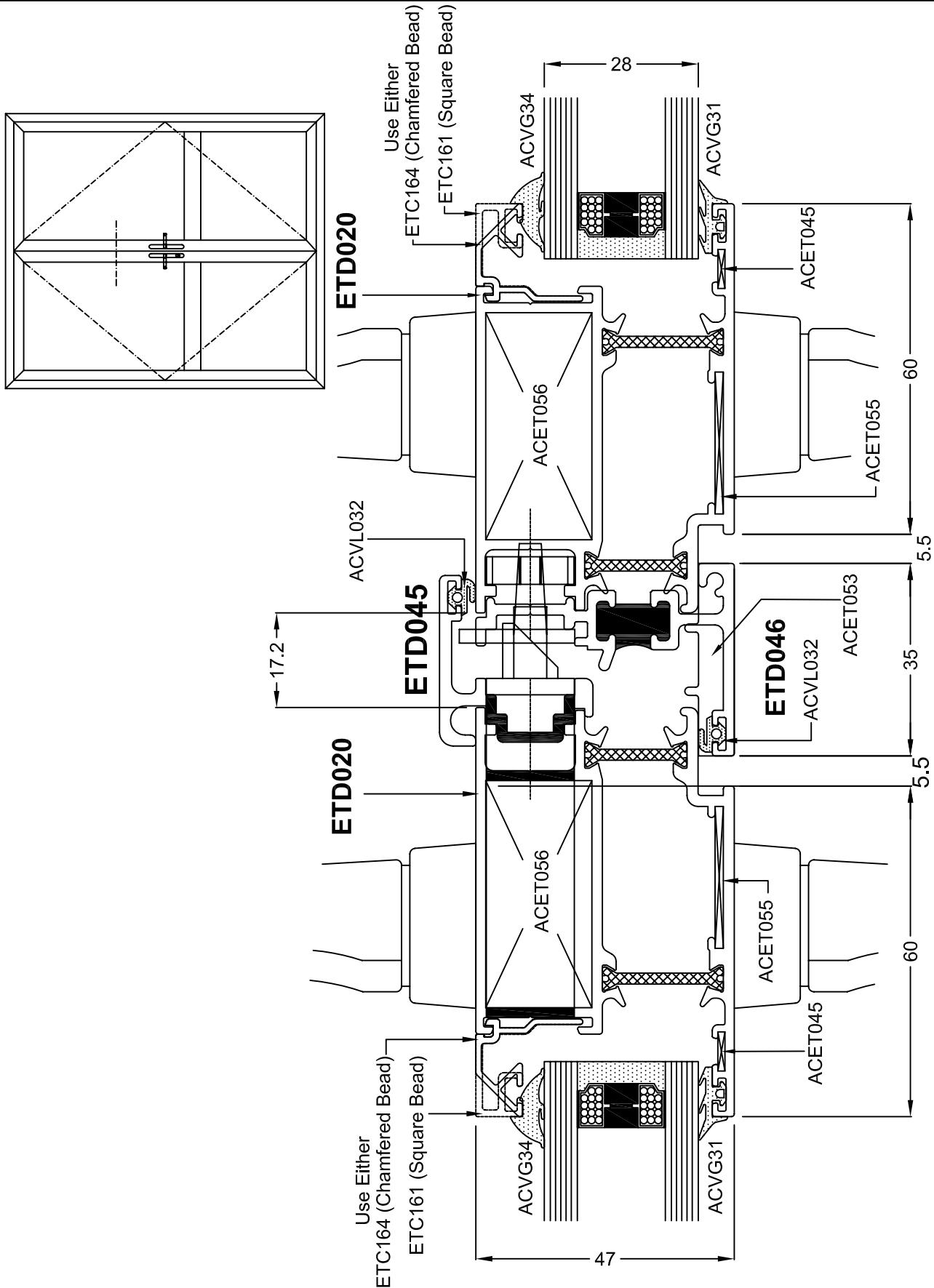
2a



3a

Doors - Open In

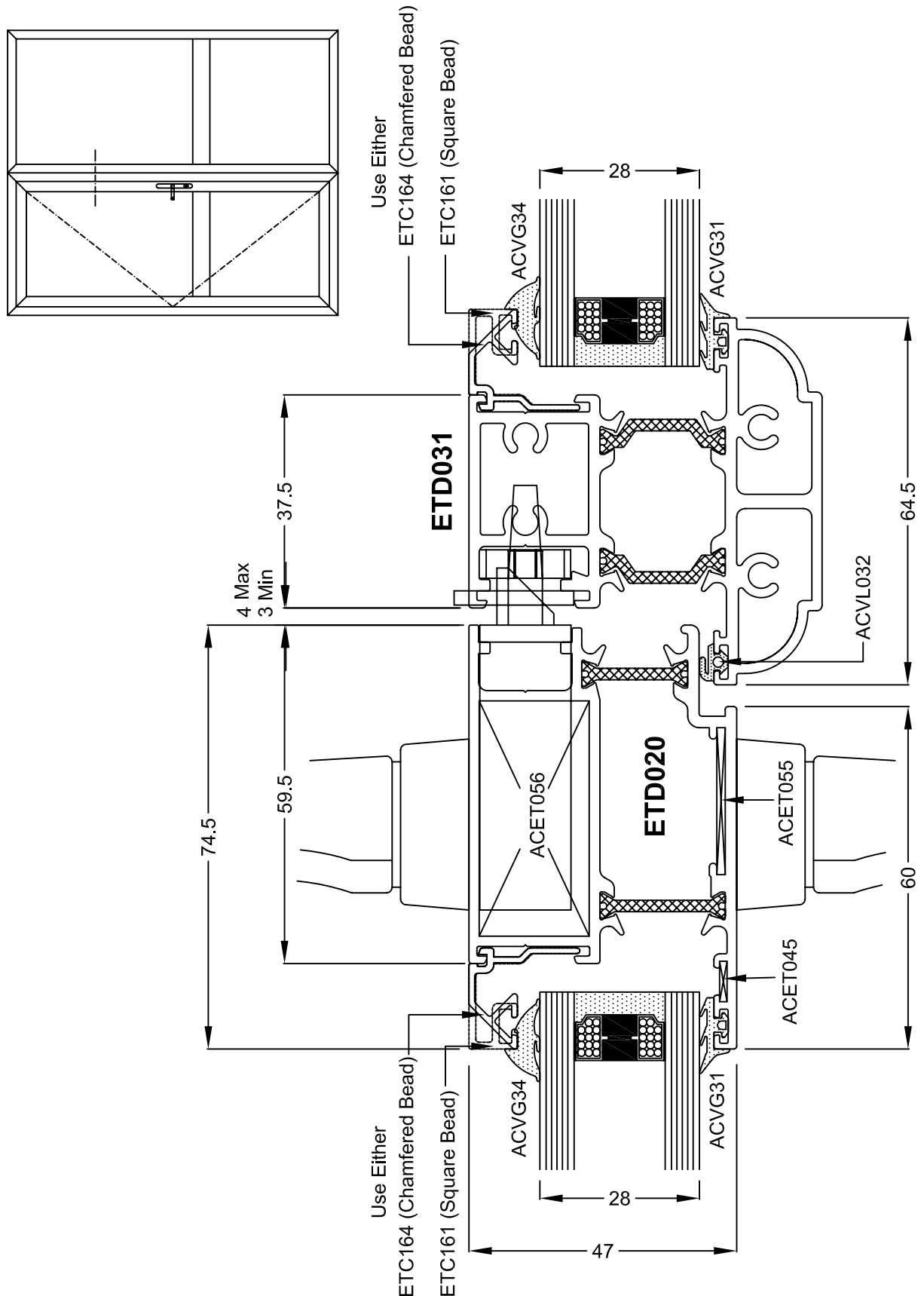
Scale 1:1



Scale 1:1

Doors - Open In

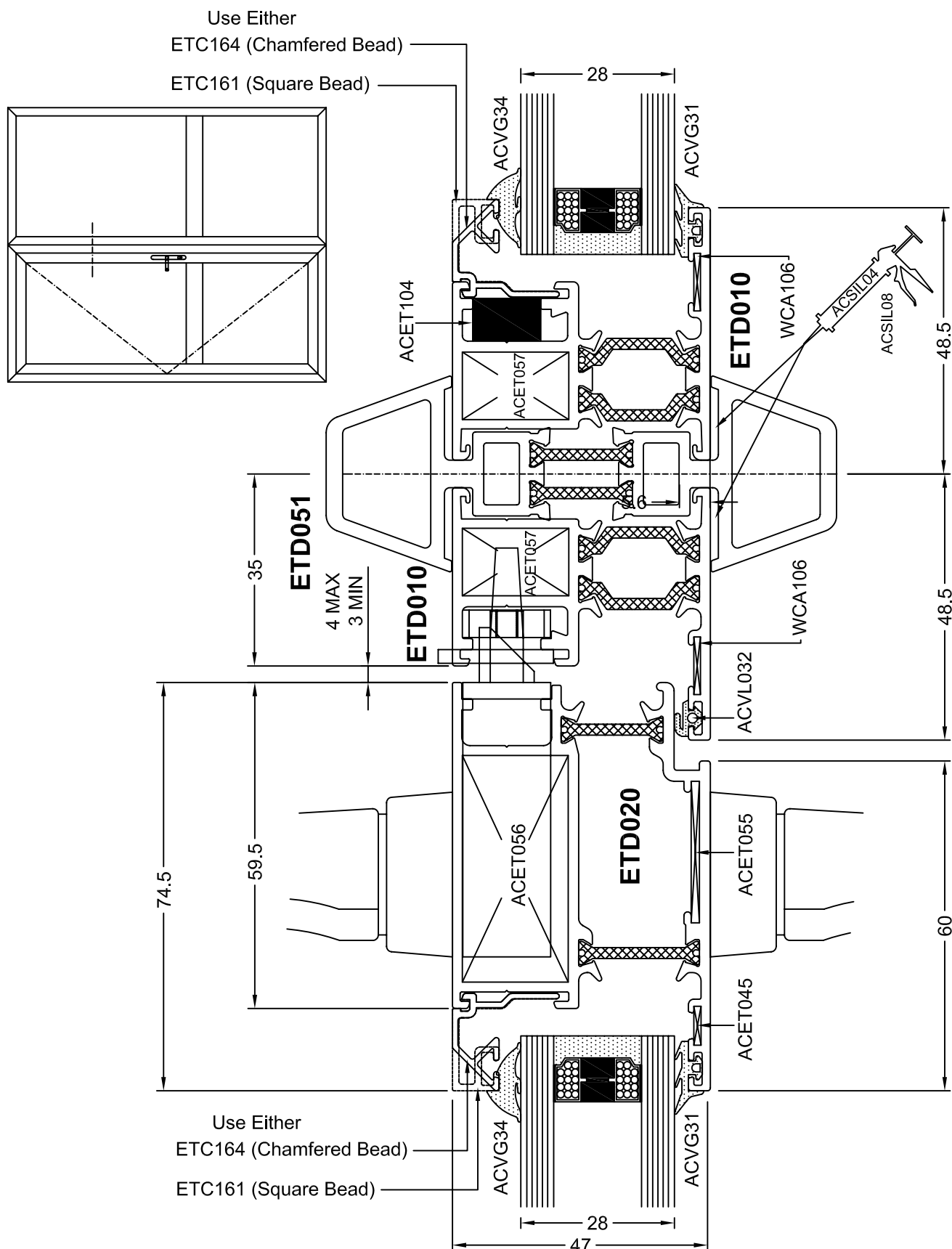
4a



4b

Doors - Open In

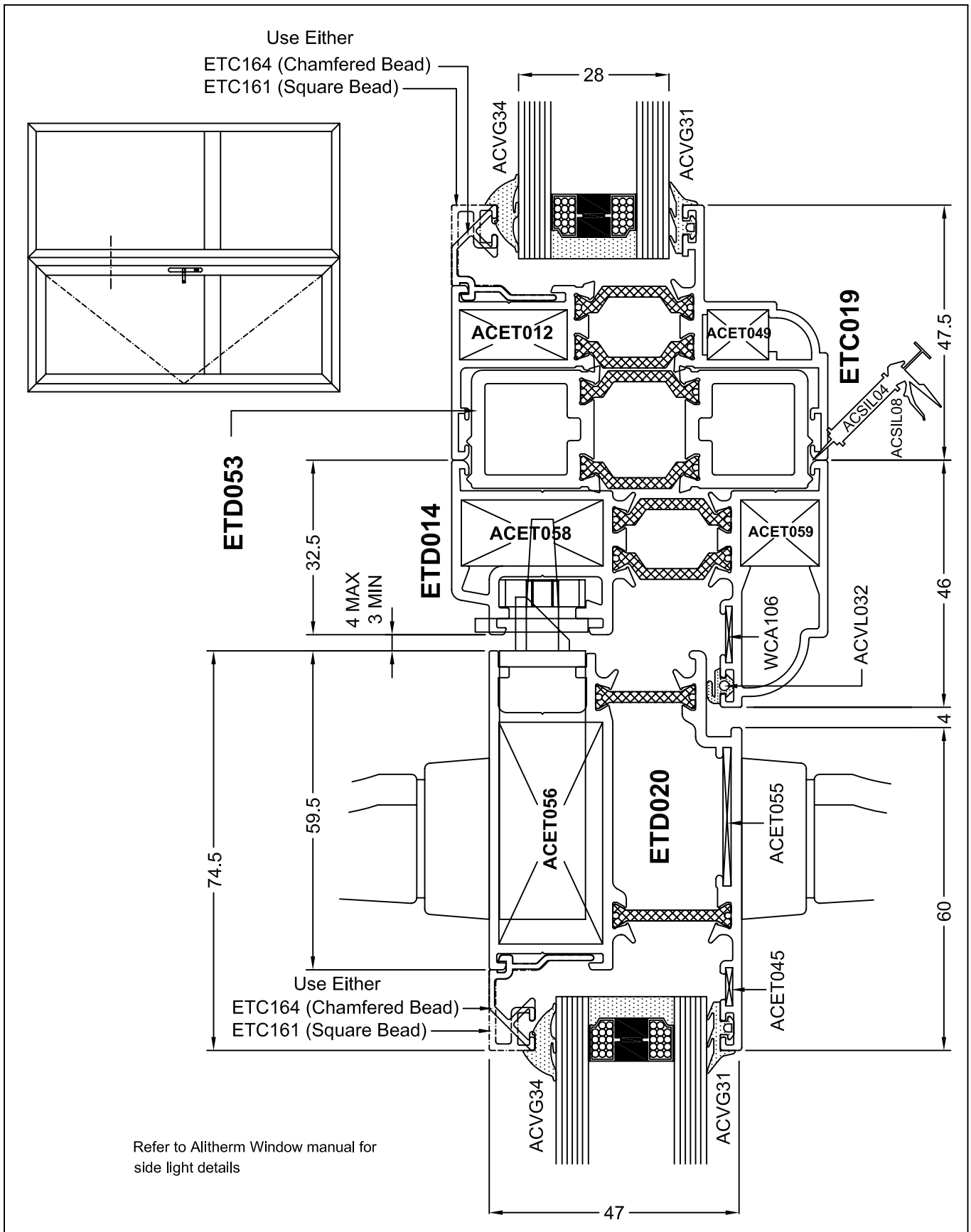
Scale 1:1



Scale 1:1

Doors - Open In

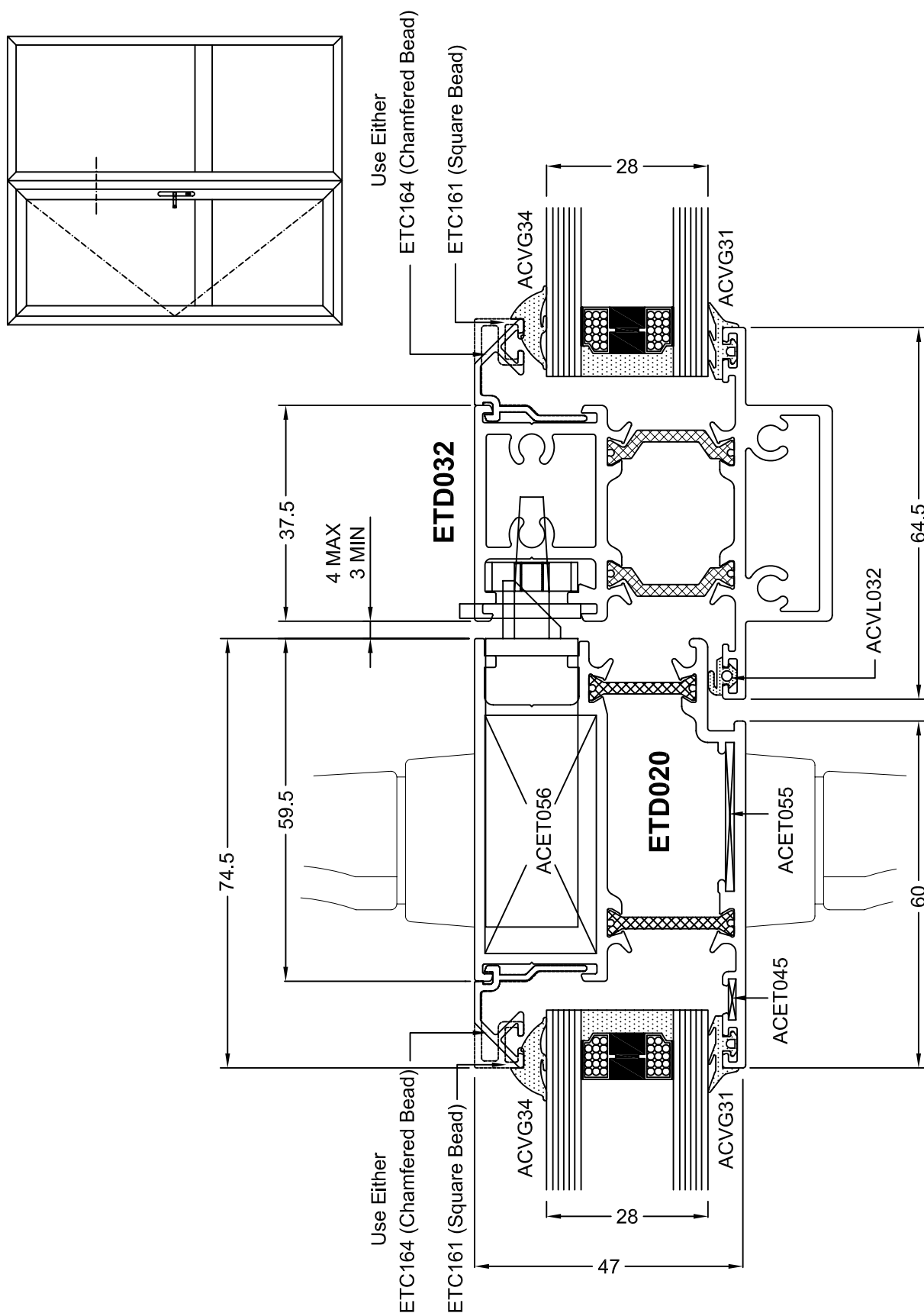
4c



4d

Doors - Open In

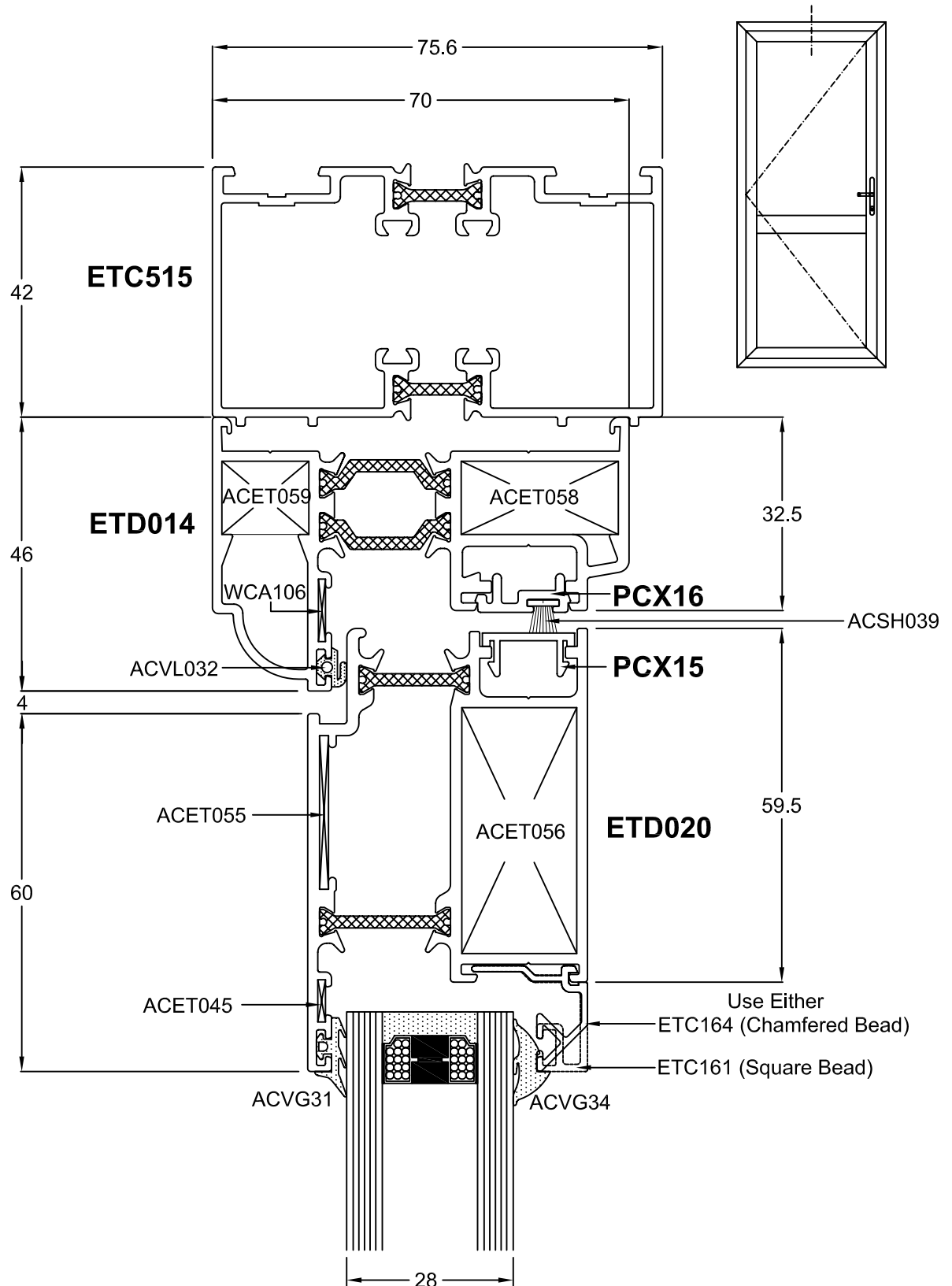
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Scale 1:1

Doors - Open In

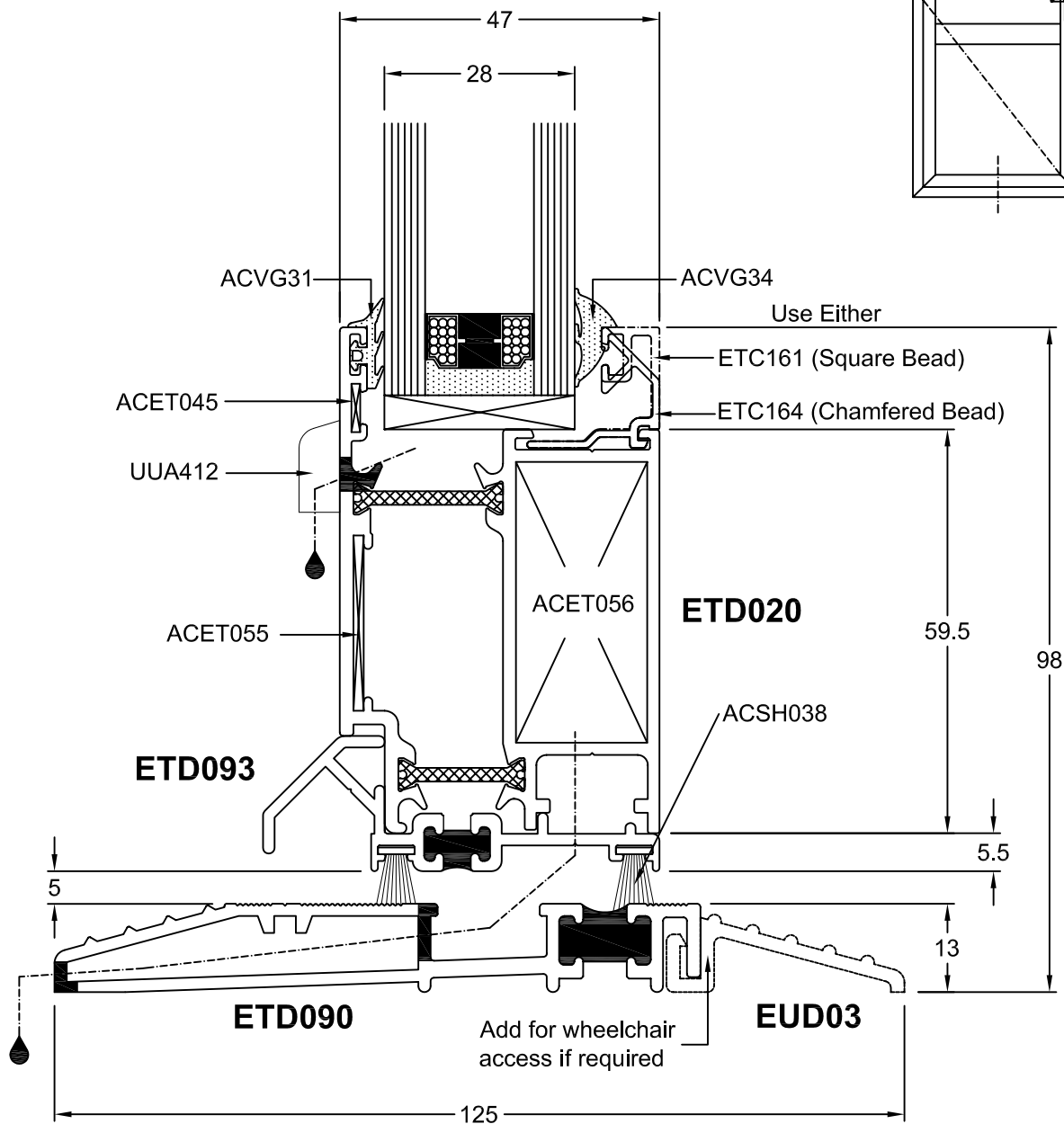
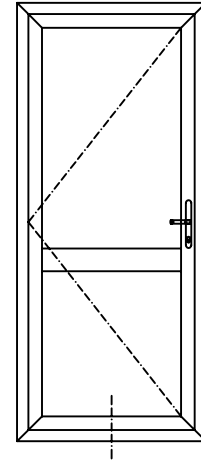
5a



6a

Doors - Open In

Scale 1:1



Scale 1:1

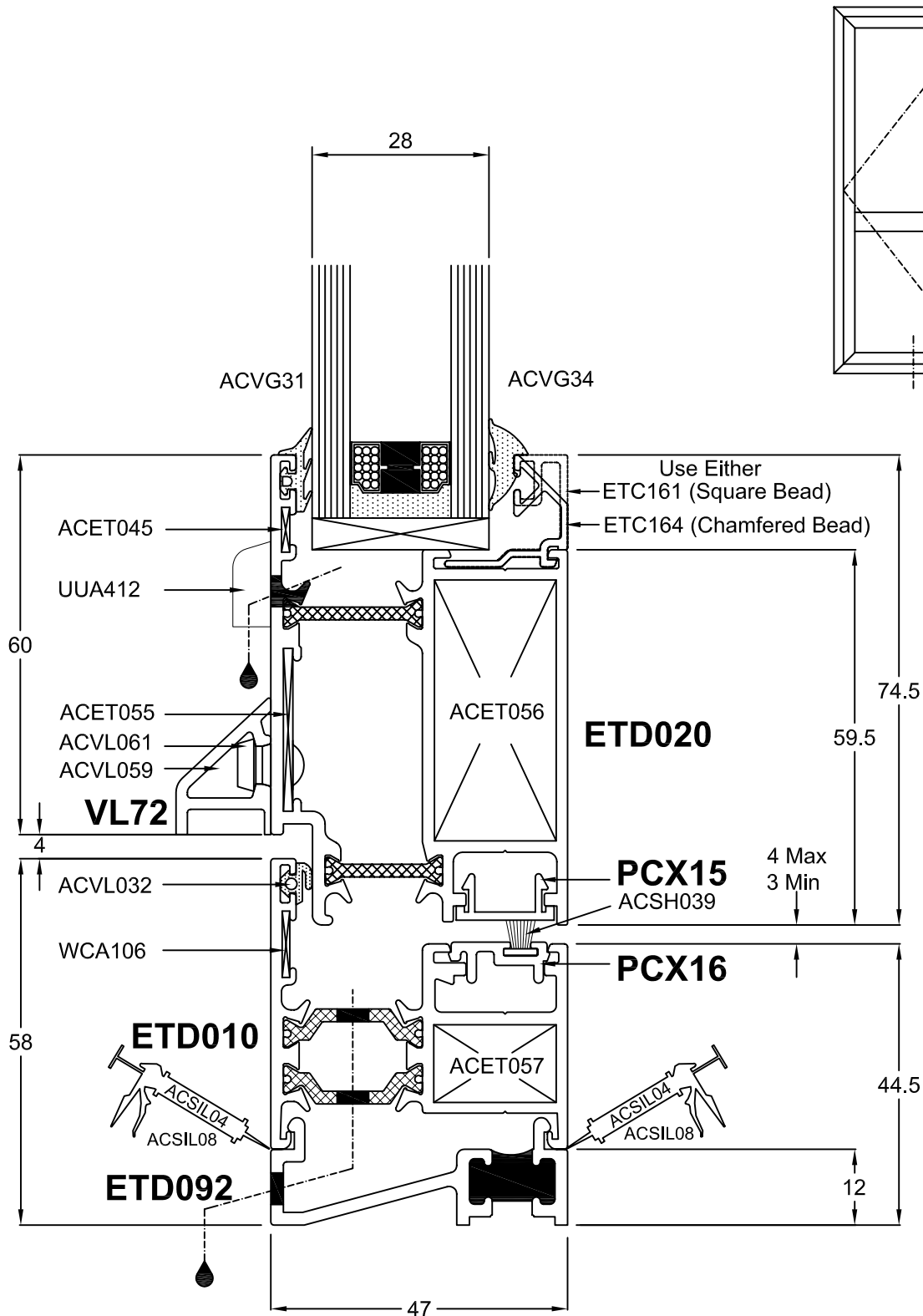
Doors - Open In

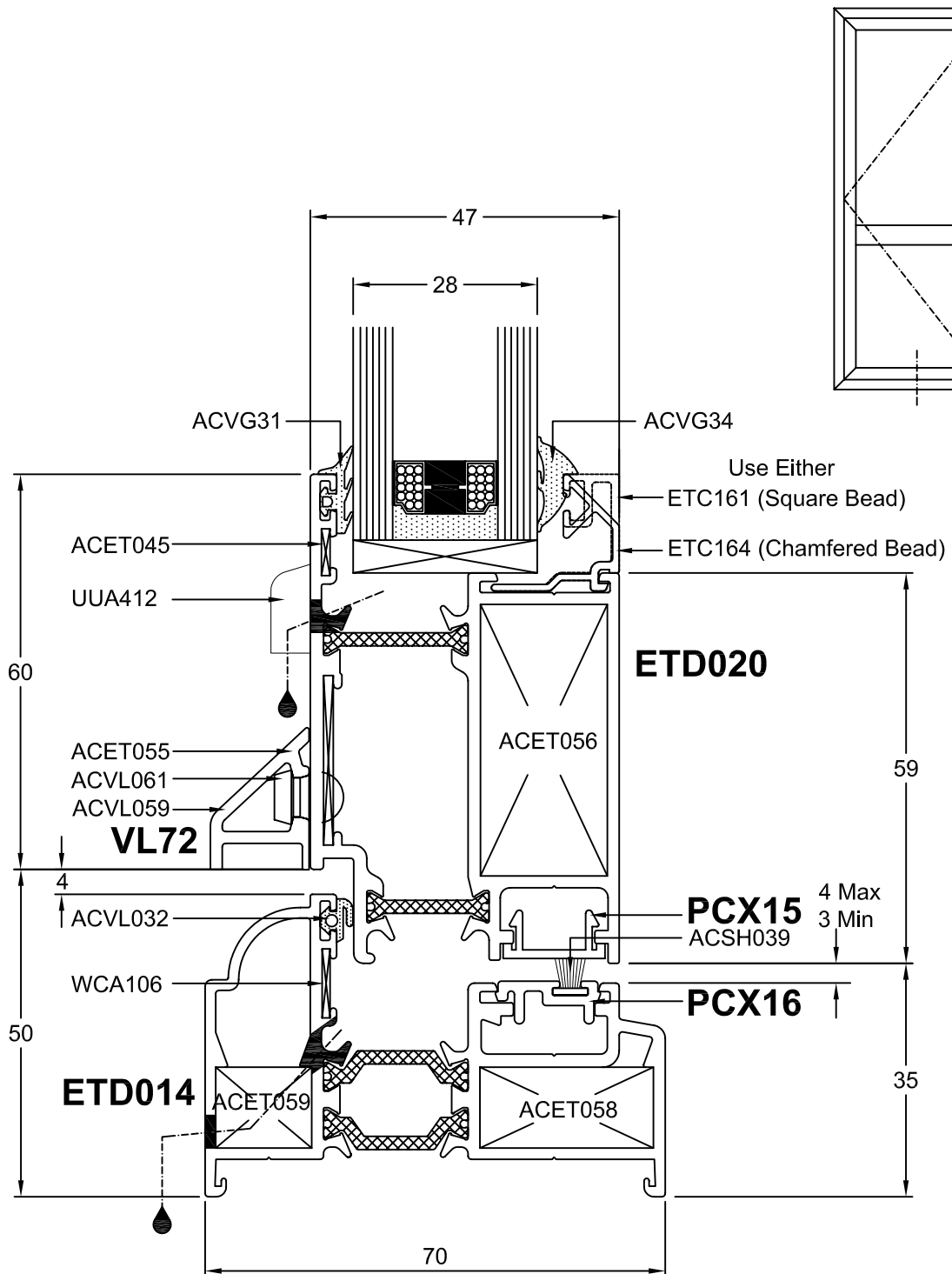
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6c

Doors - Open In

Scale 1:1

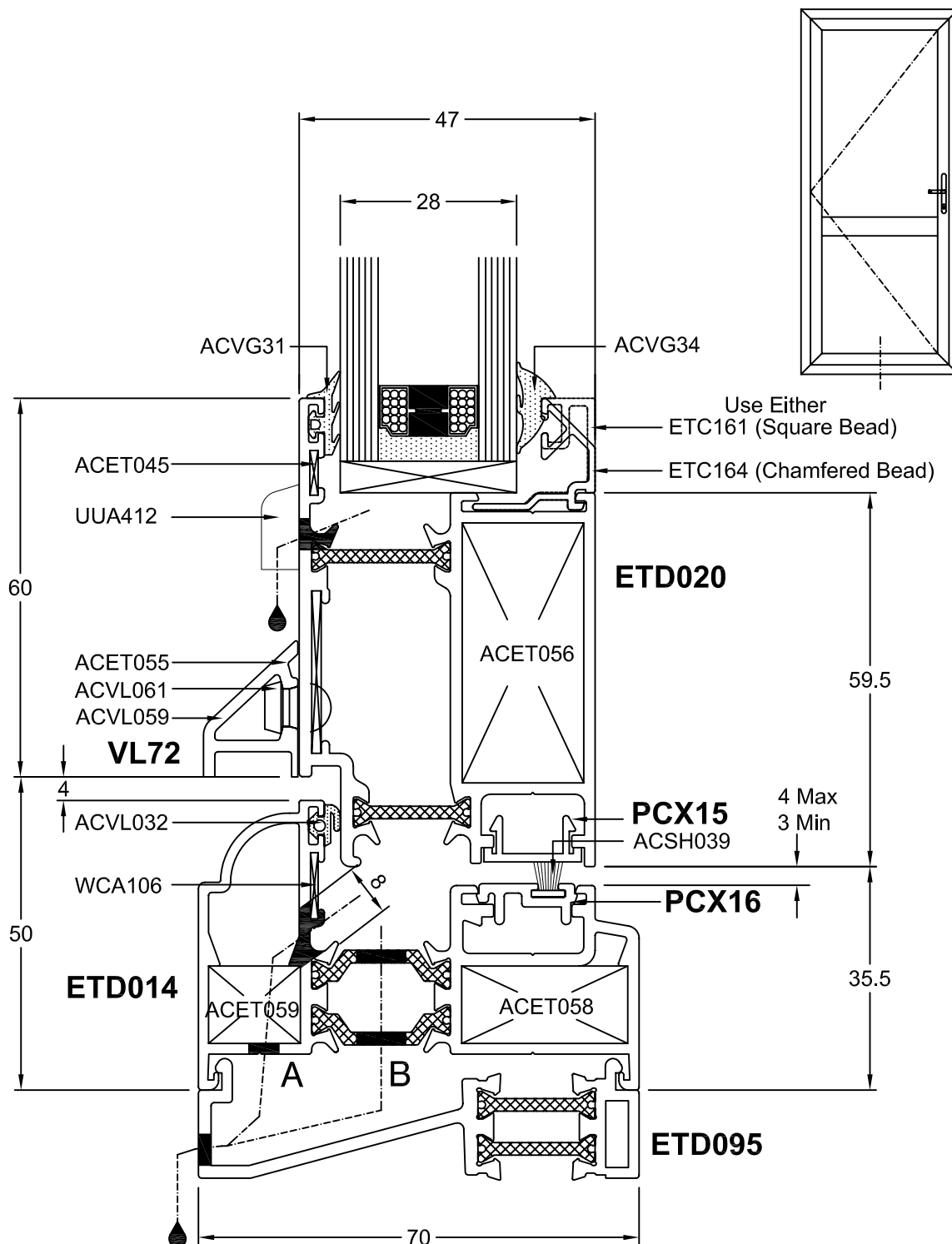




6e

Doors - Open In

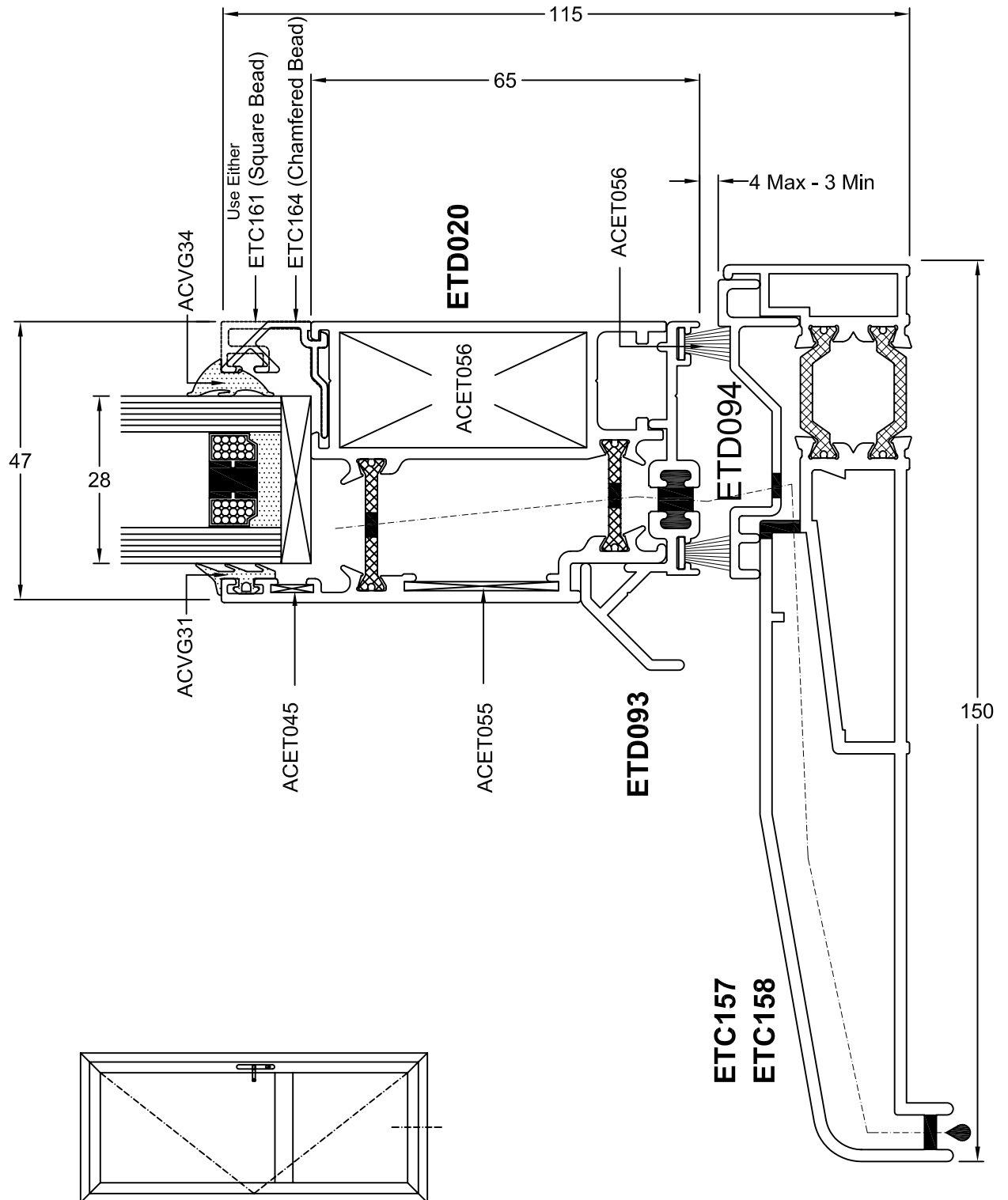
Scale 1:1



Scale 1:1

Doors - Open In

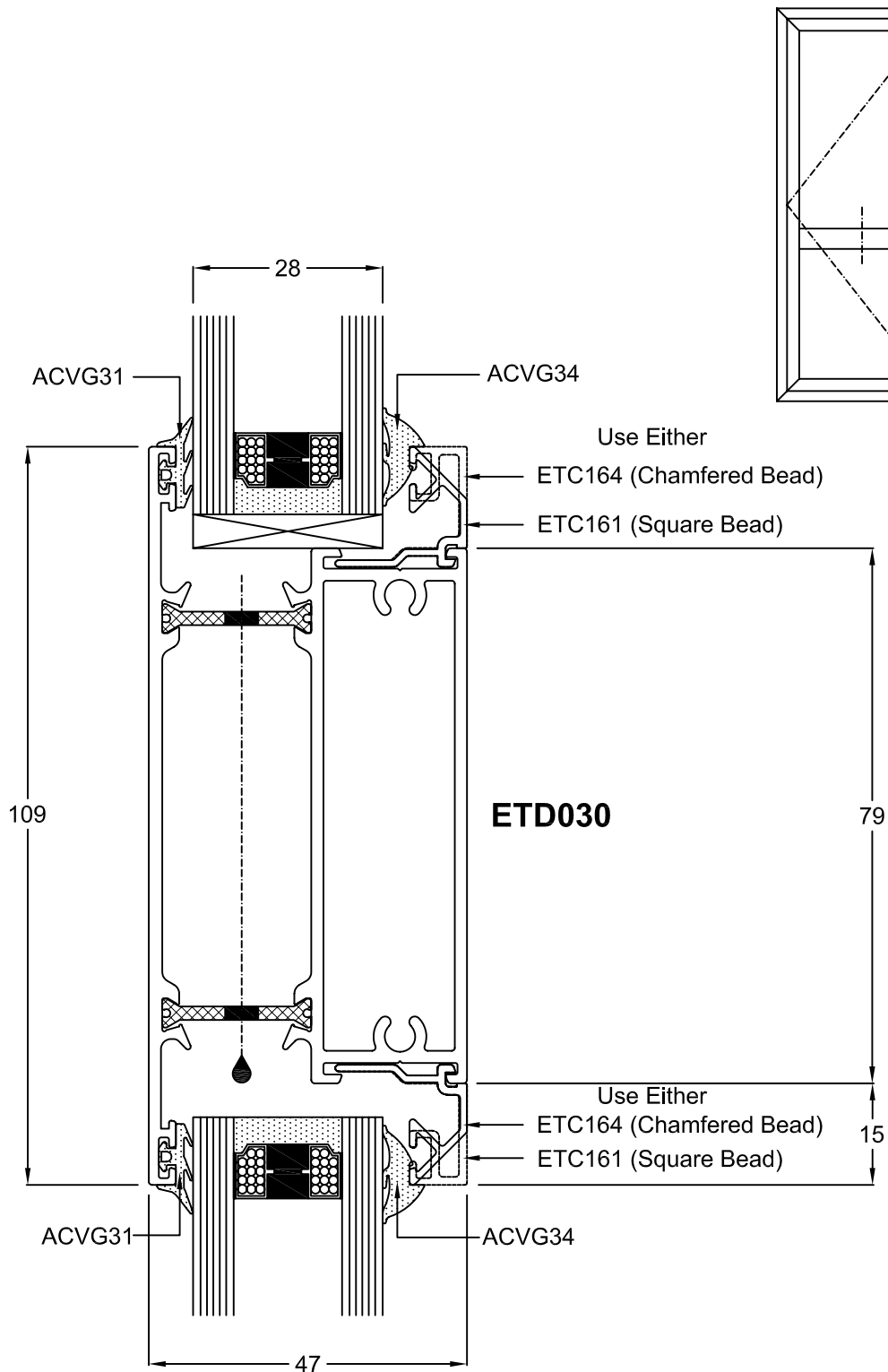
6f

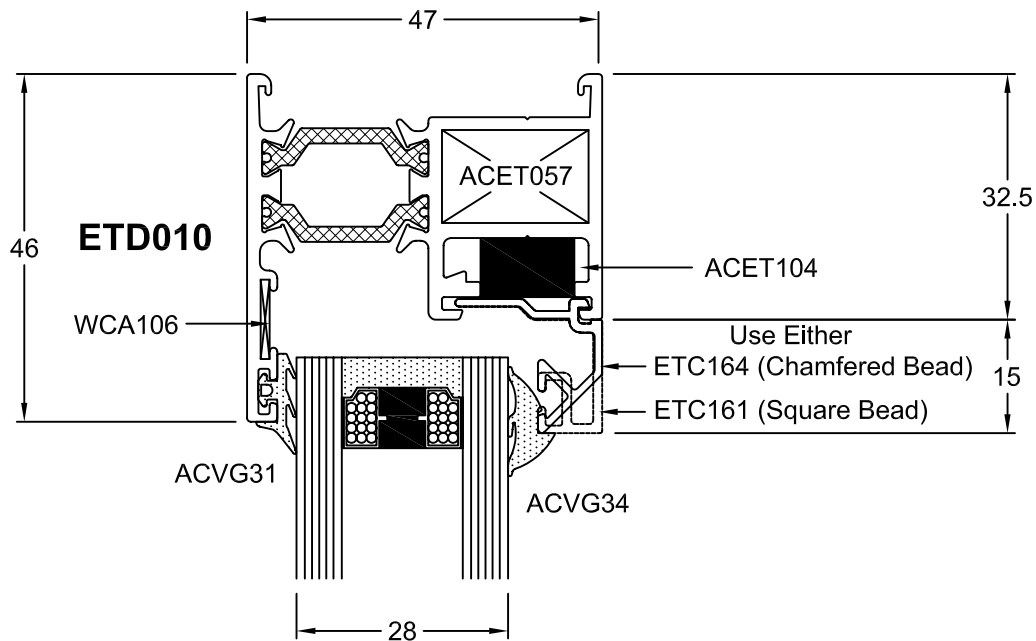
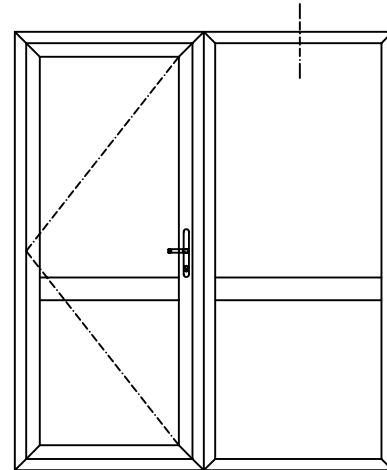


7a

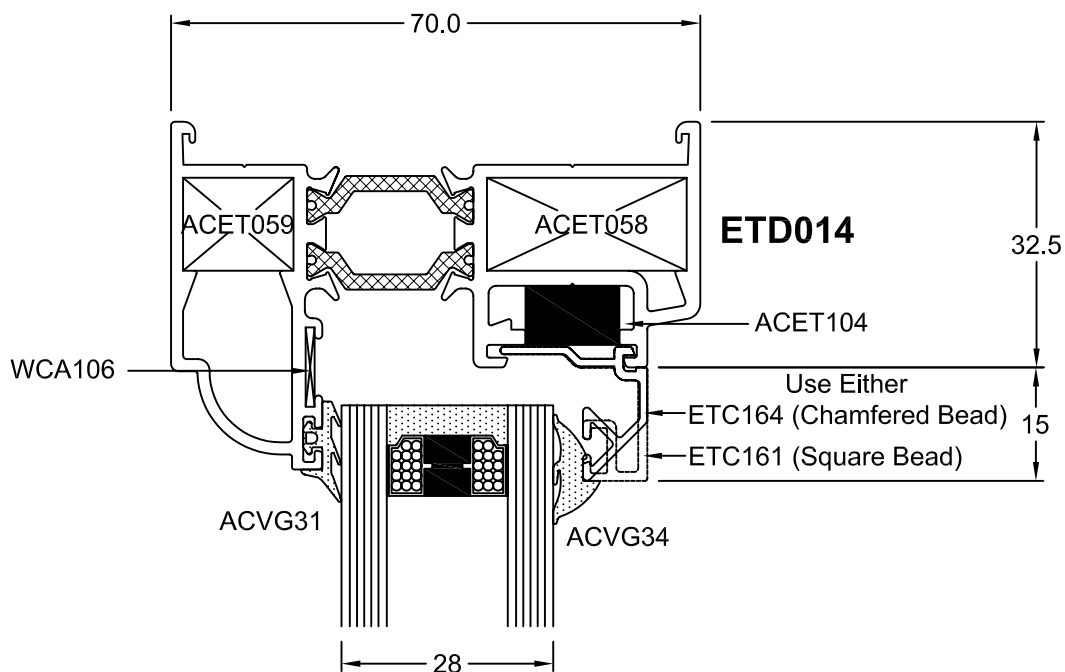
Doors - Open In

Scale 1:1





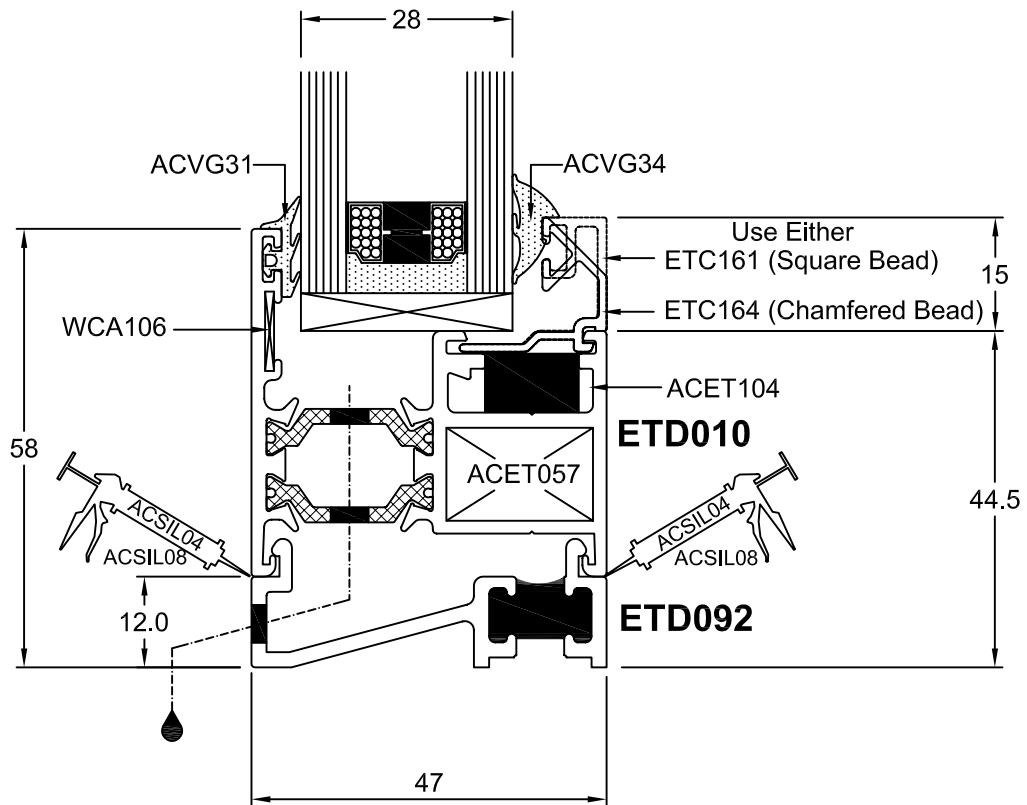
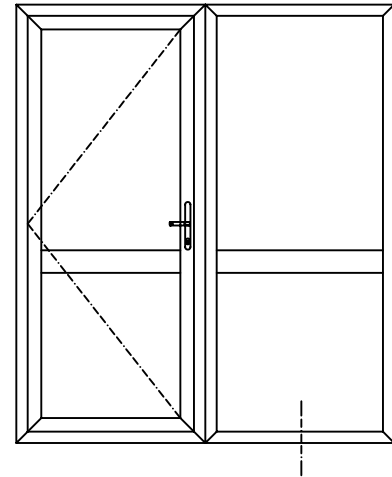
8b Doors - Open In Scale 1:1



Scale 1:1

Doors - Open In

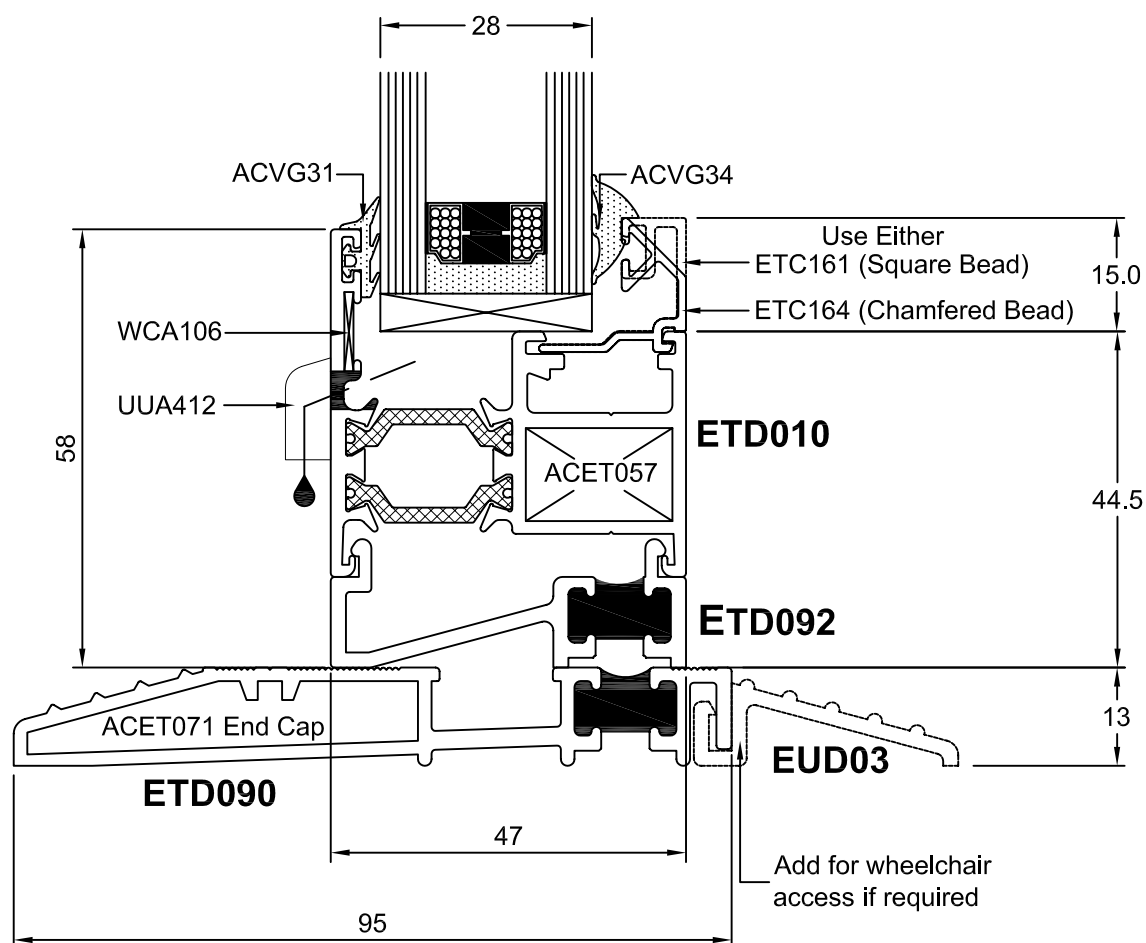
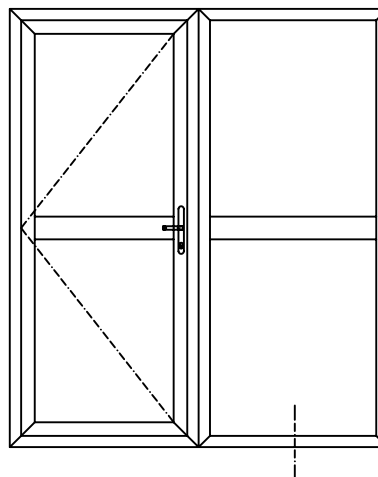
9a

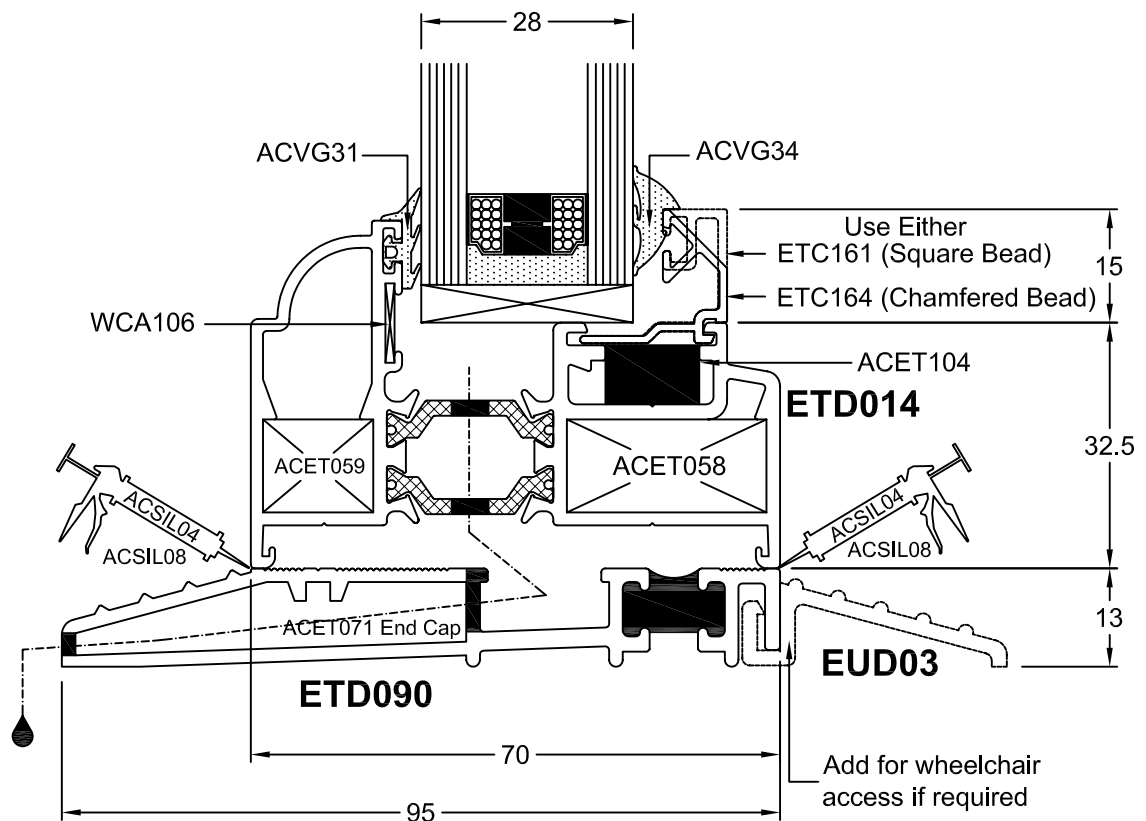
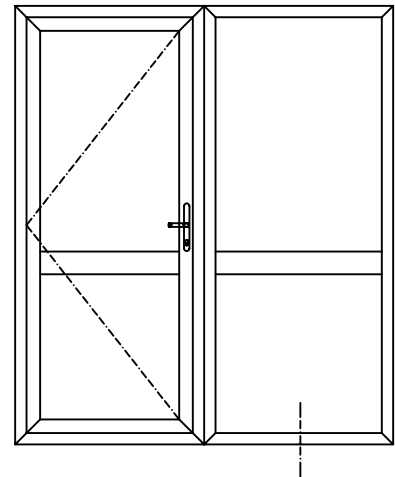


9b

Doors - Open In

Scale 1:1





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Doors - Open Out

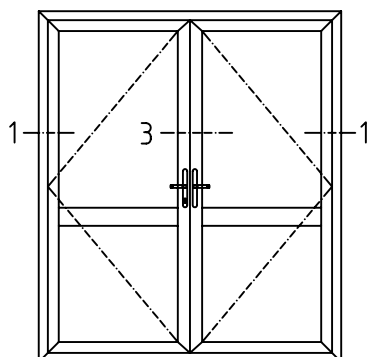
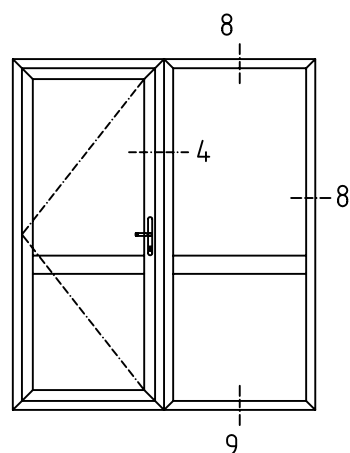
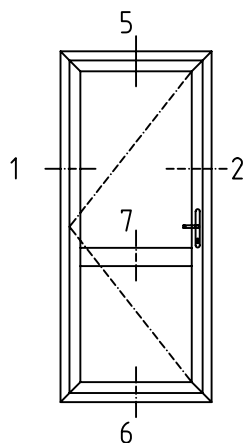
Sections

Doors - Open Out

Doors - Open Out

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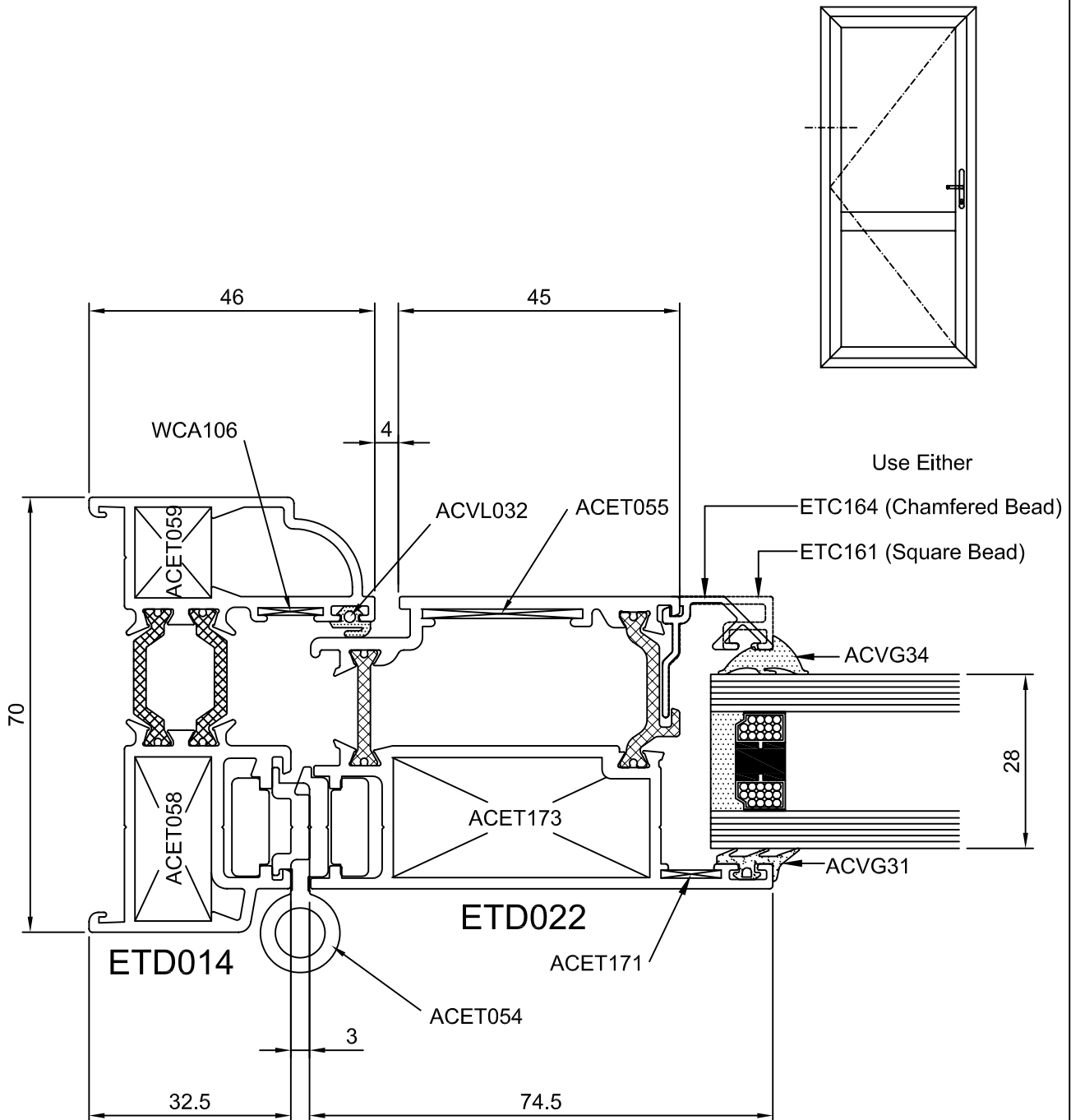
Doors - Open Out



1a

Doors - Open Out

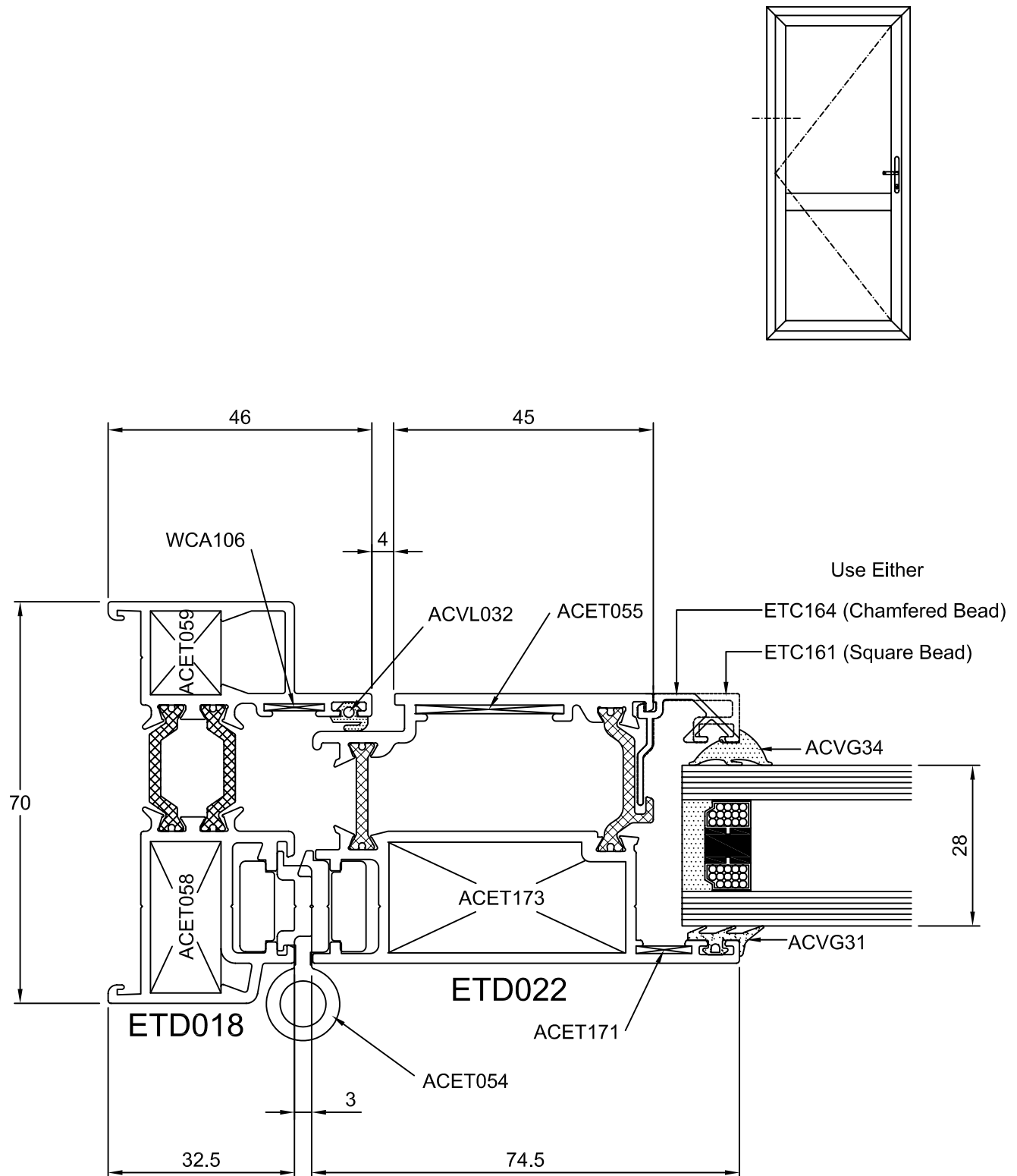
Scale 1:1



Scale 1:1

Doors - Open Out

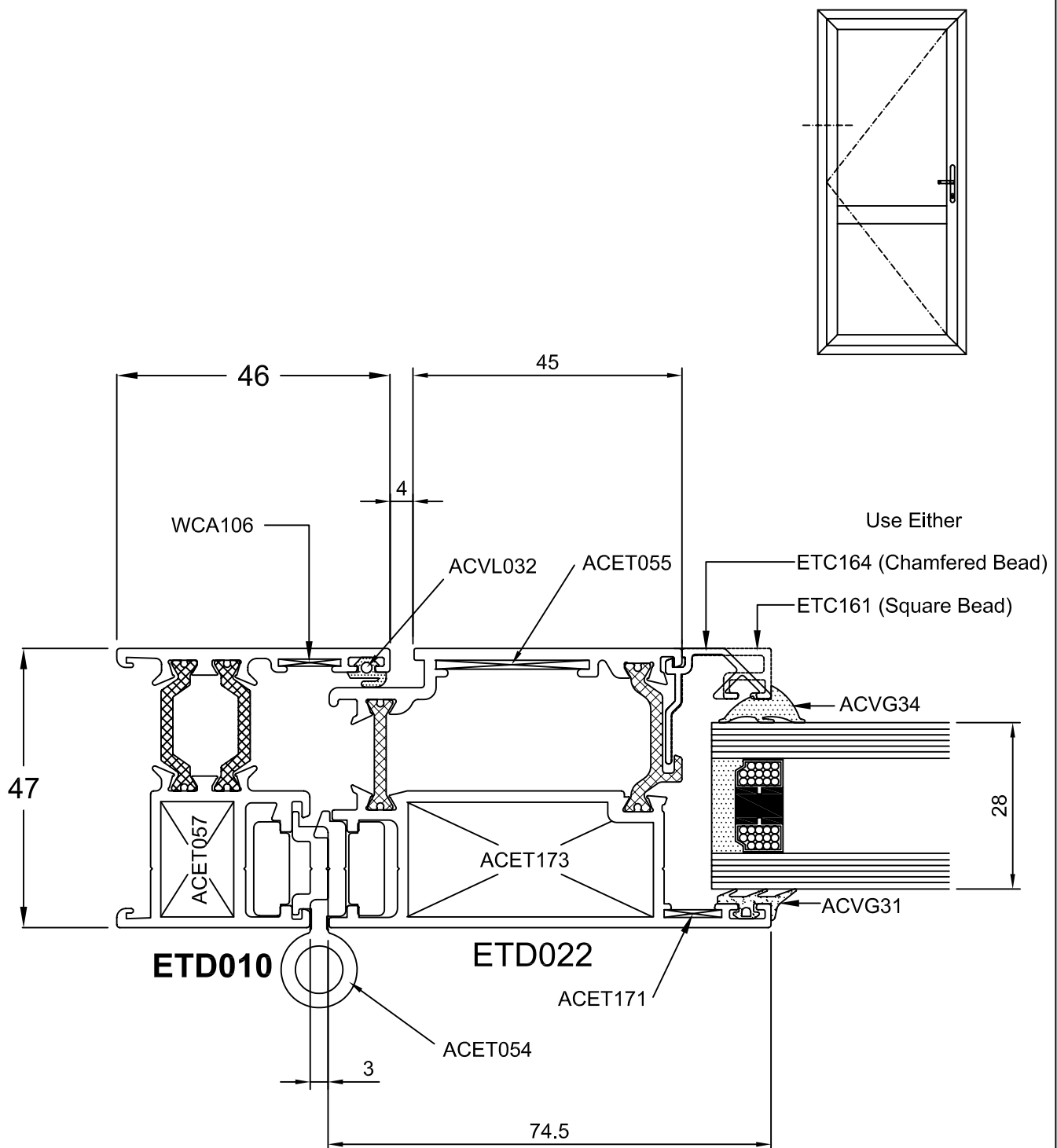
1b



1c

Doors - Open Out

Scale 1:1



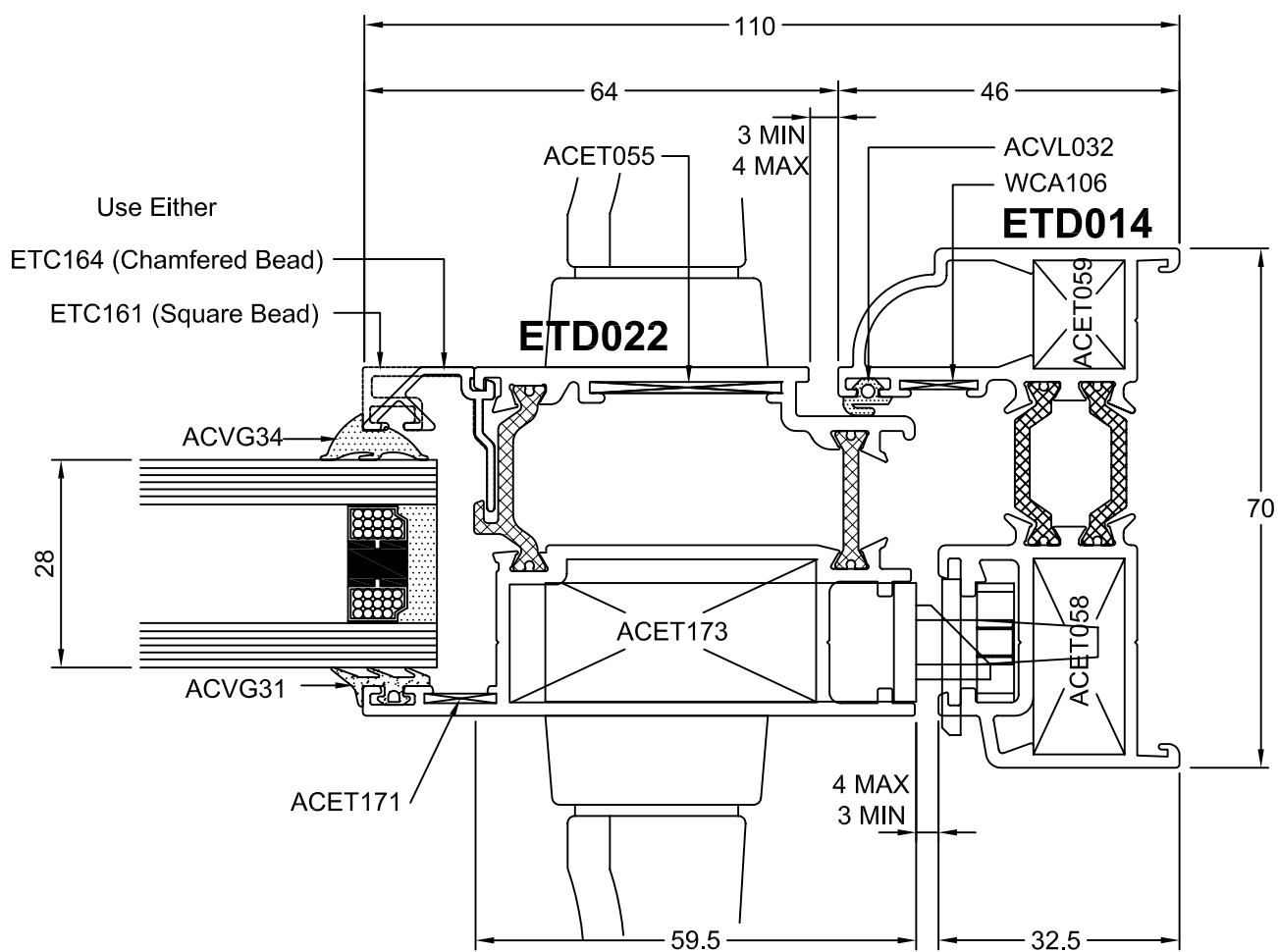
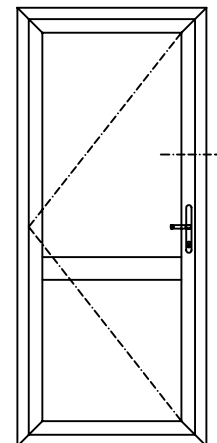
Scale 1:1

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2A

Doors - Open Out

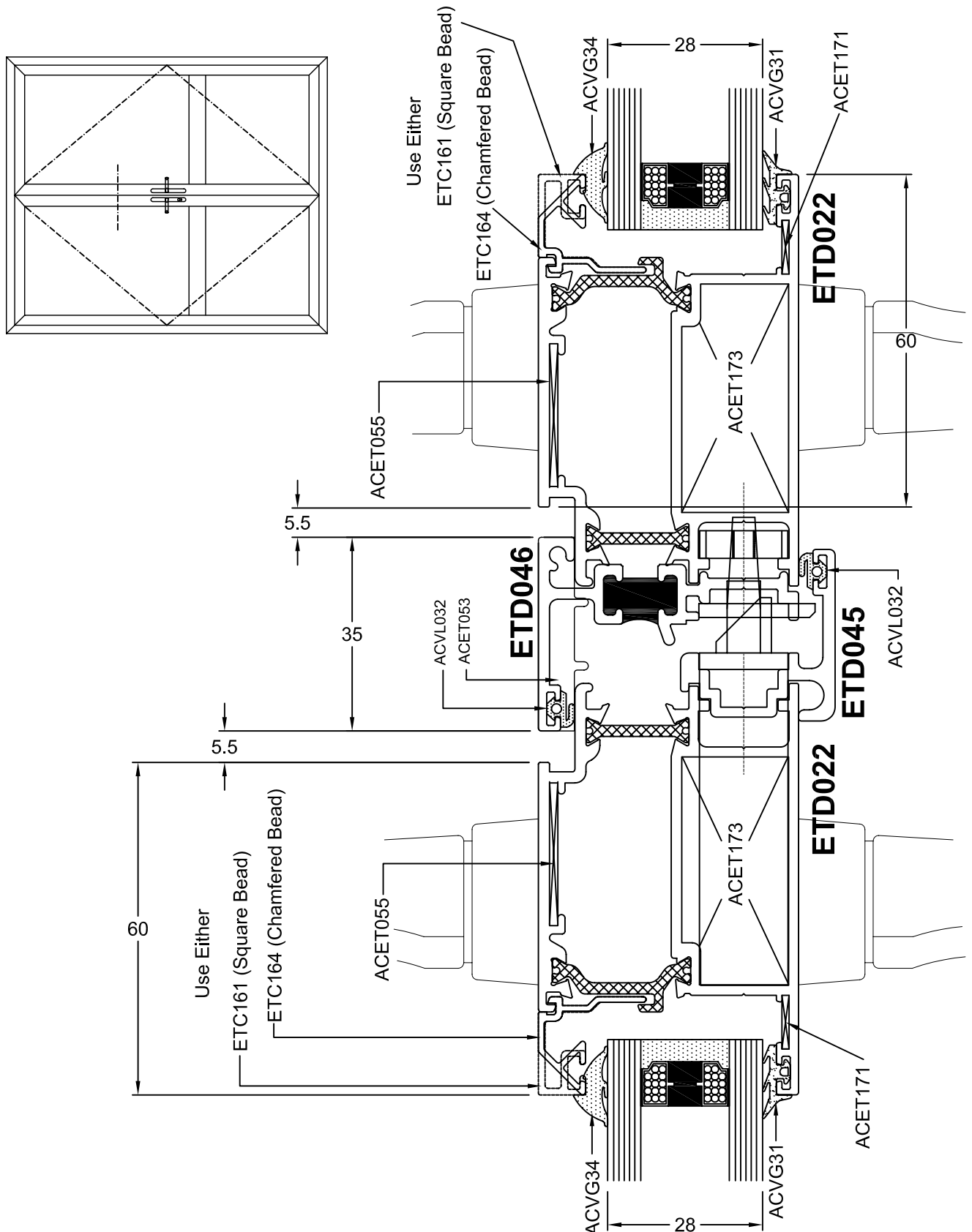
Scale 1:1



Scale 1:1

Doors - Open Out

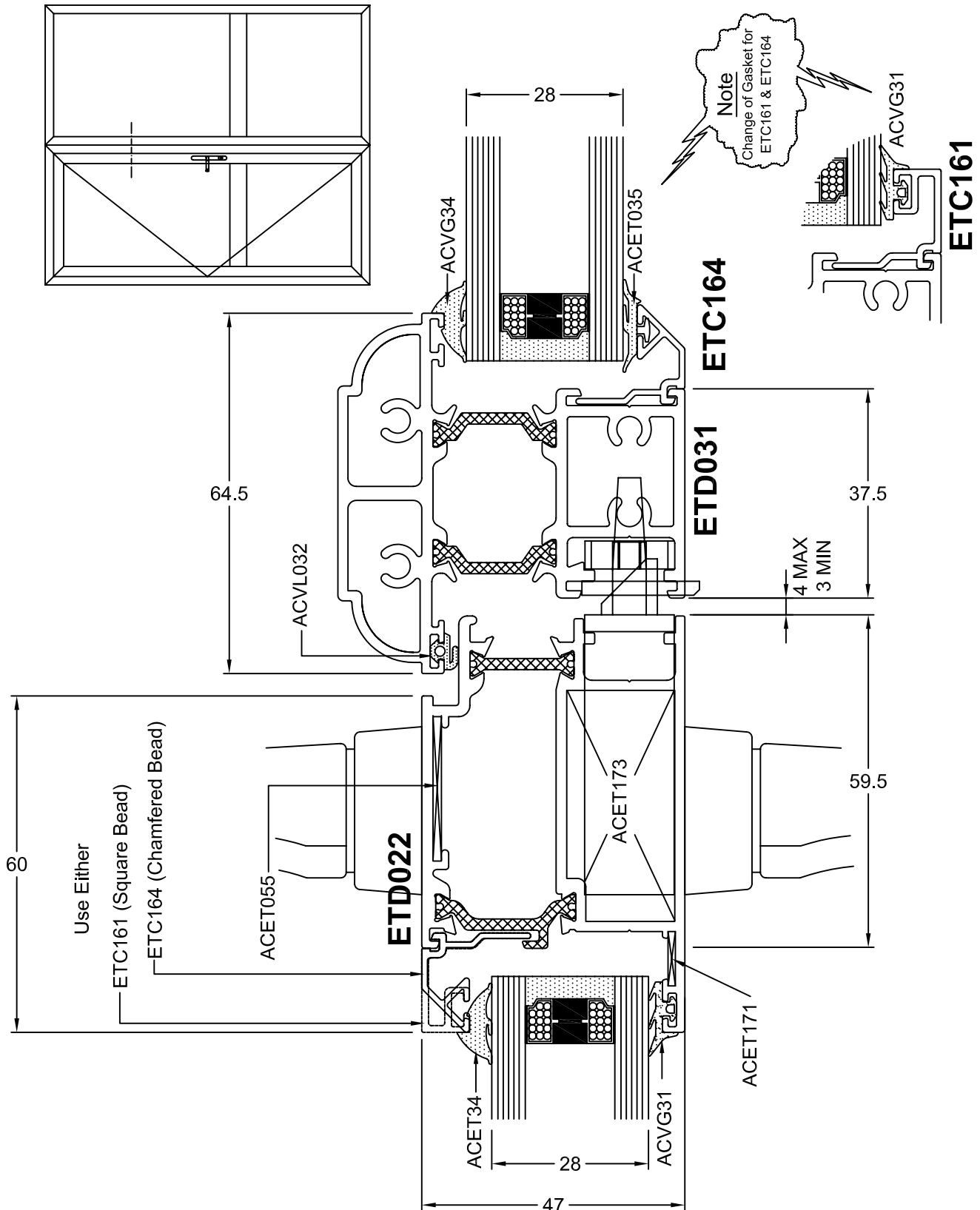
3a



4a

Doors - Open Out

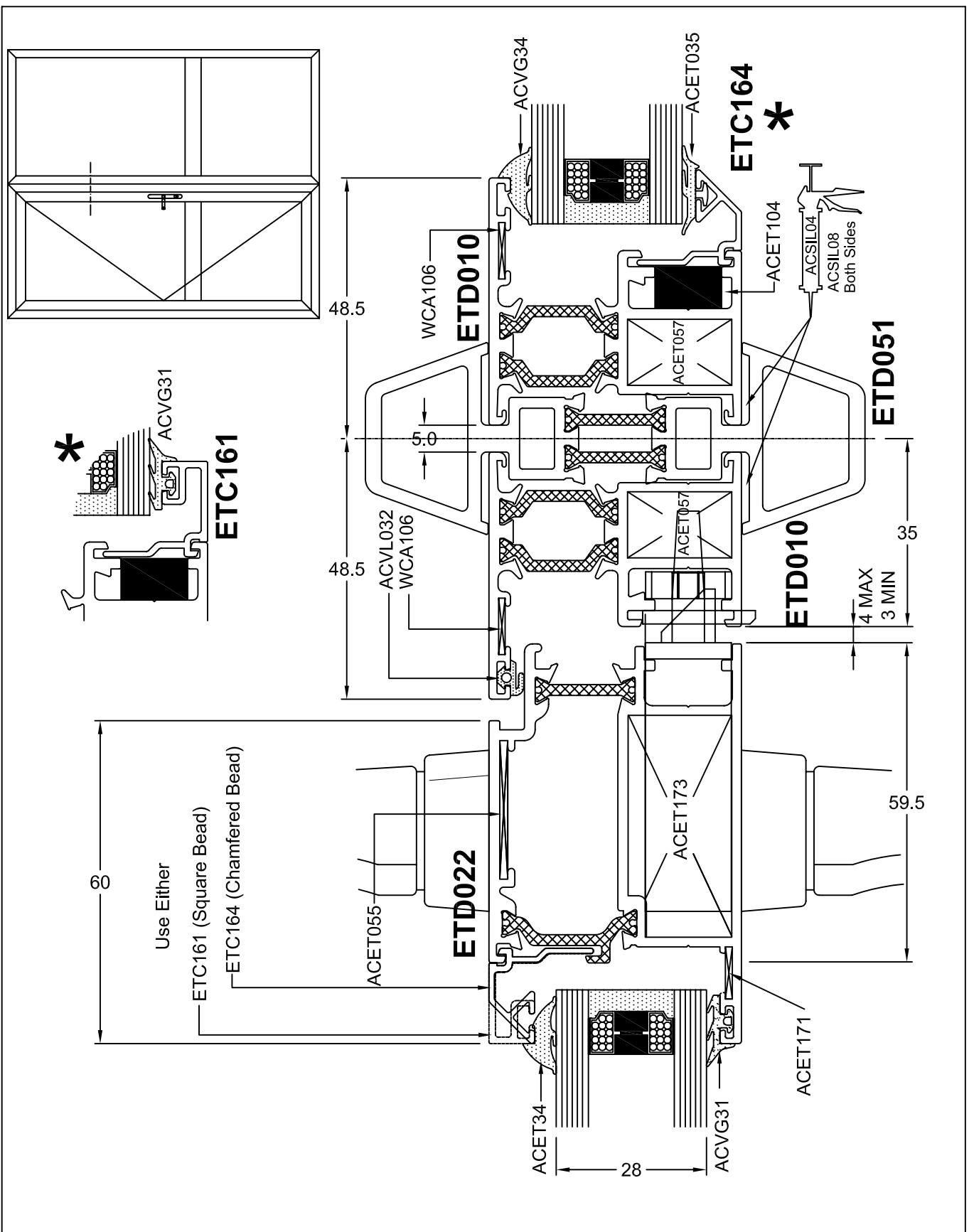
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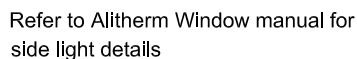
Scale 1:1

Doors - Open Out

4b



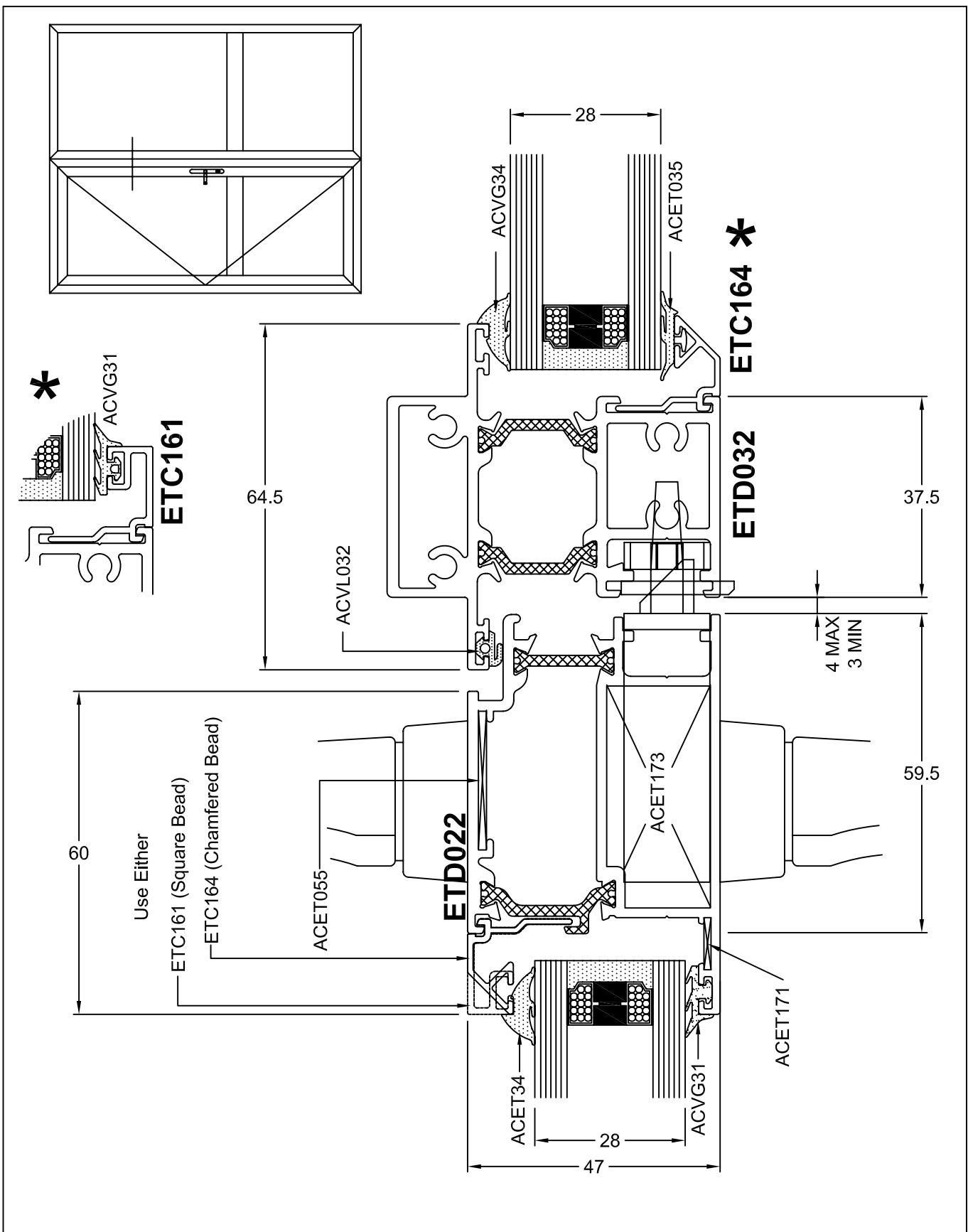
Scale 1:1



Scale 1:1

Doors - Open Out

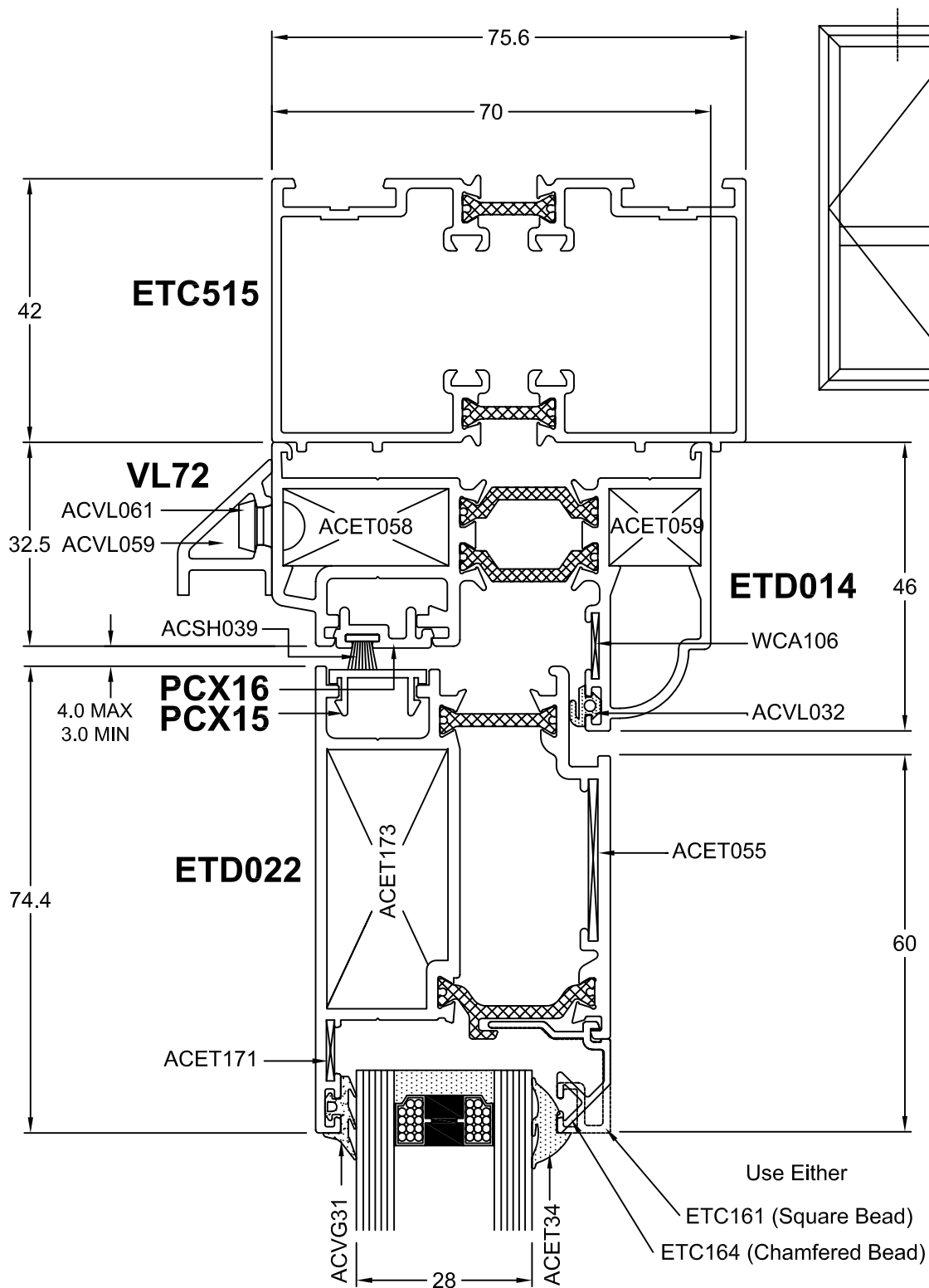
4d

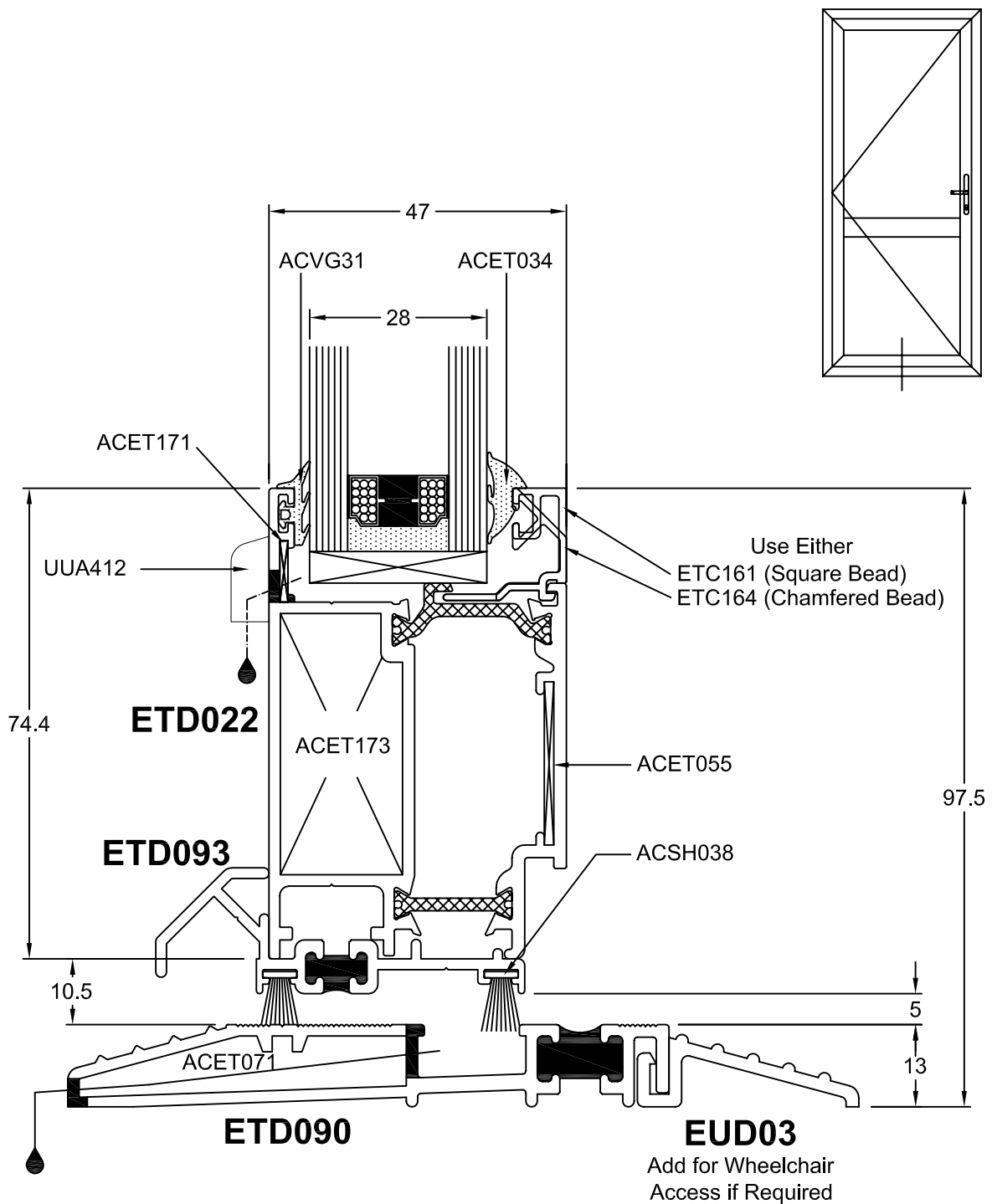


5a

Doors - Open Out

Scale 1:1





6b

Doors - Open Out

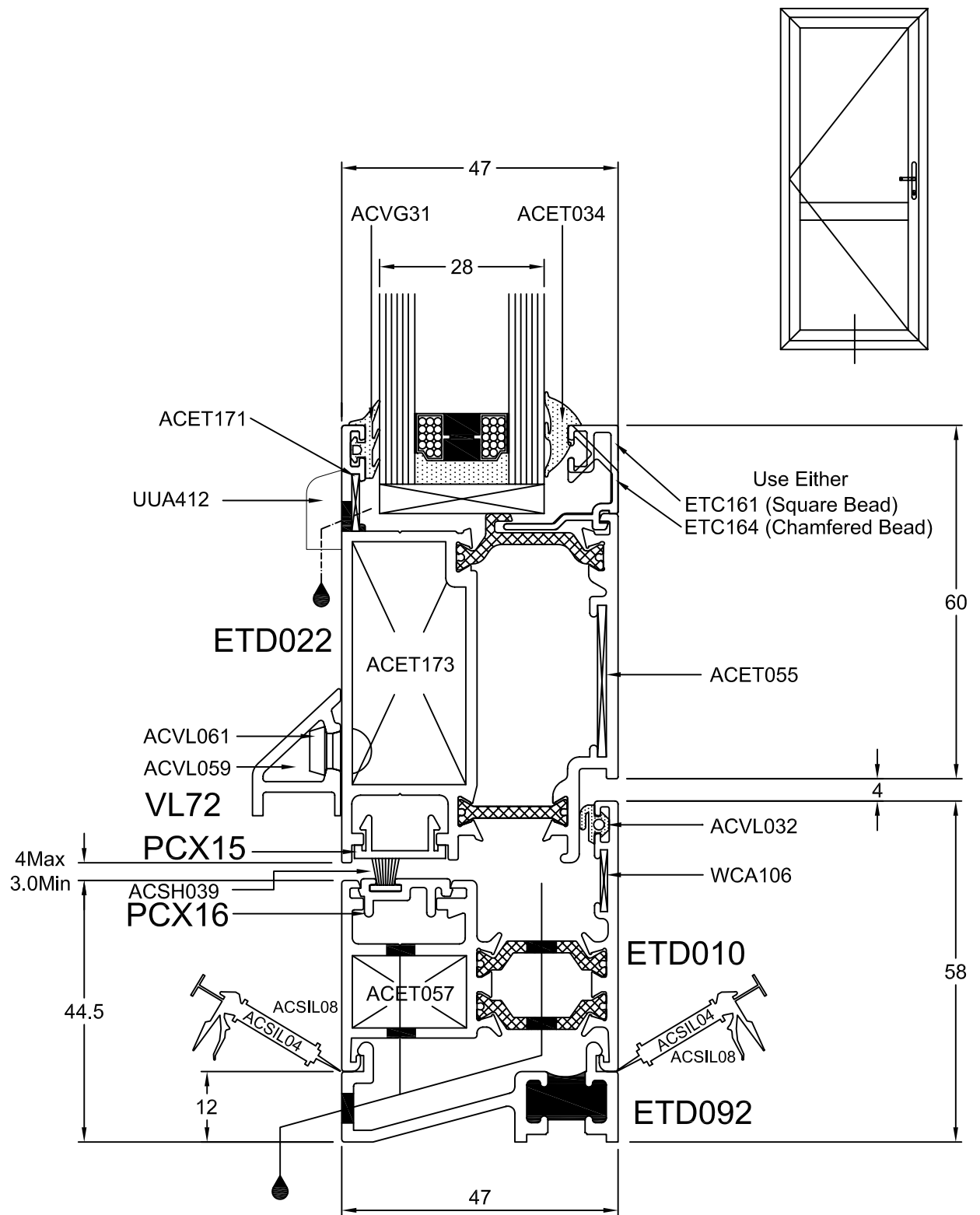
Scale 1:1

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Scale 1:1

Doors - Open Out

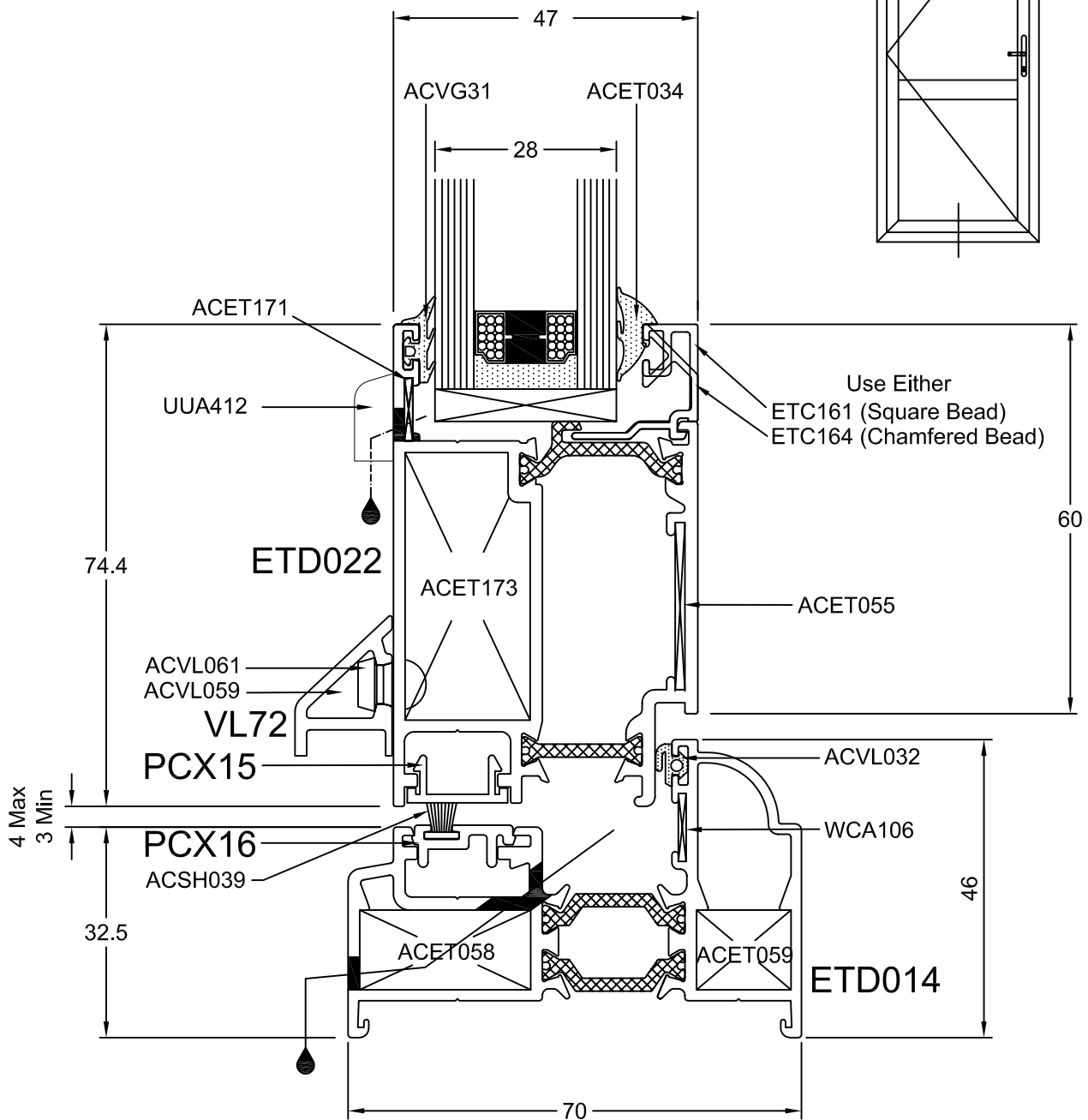
6c



6d

Doors - Open Out

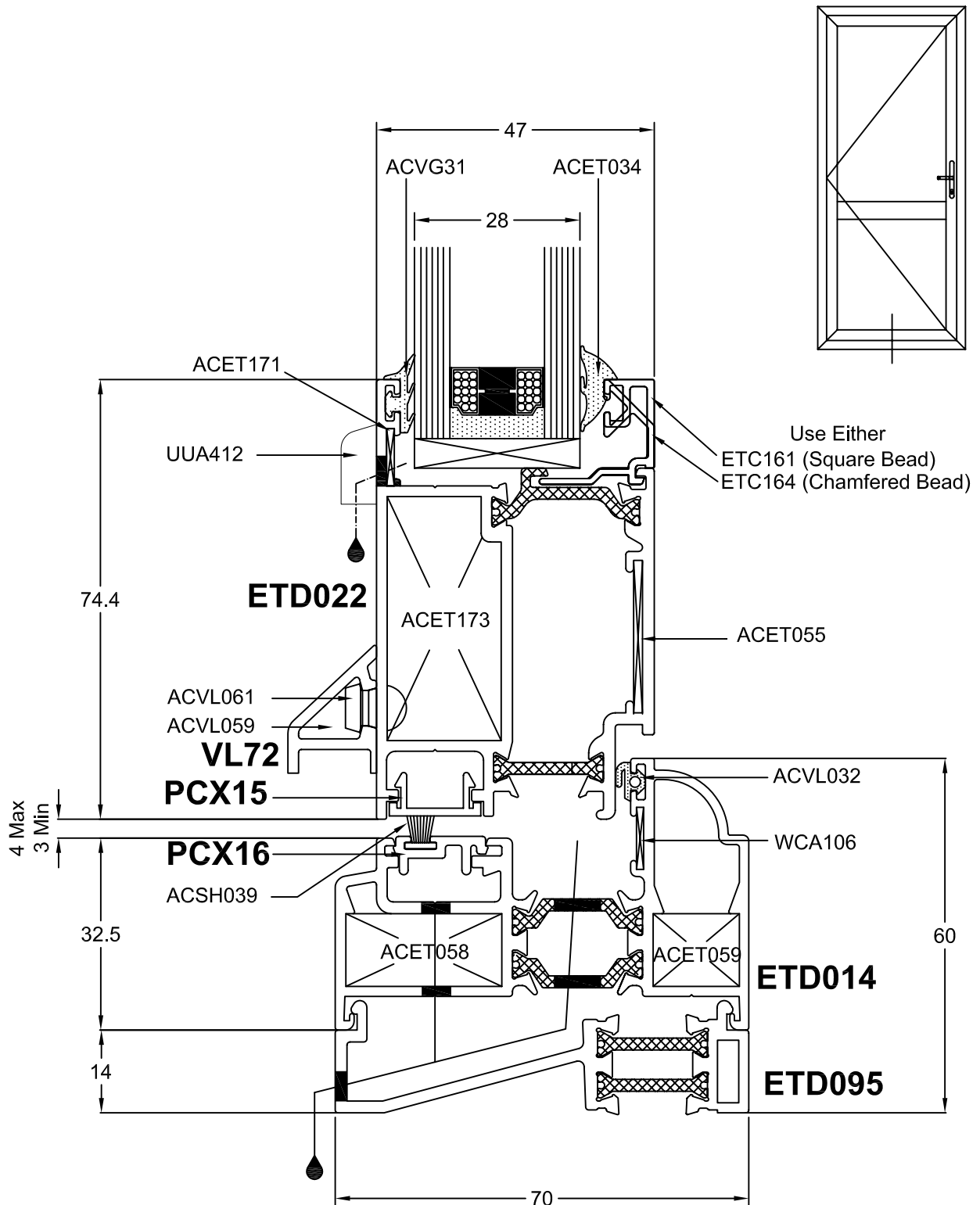
Scale 1:1



Scale 1:1

Doors - Open Out

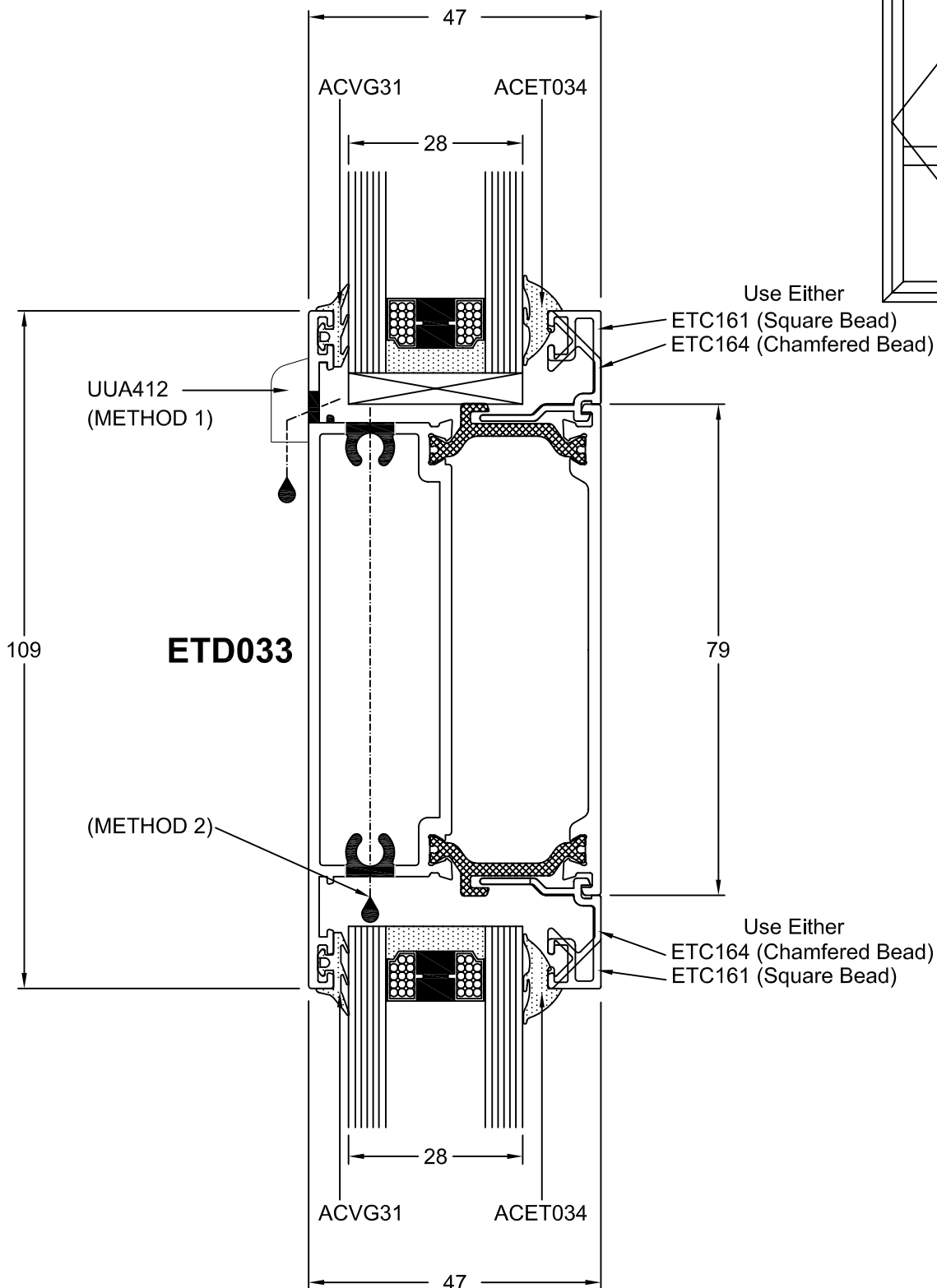
6e

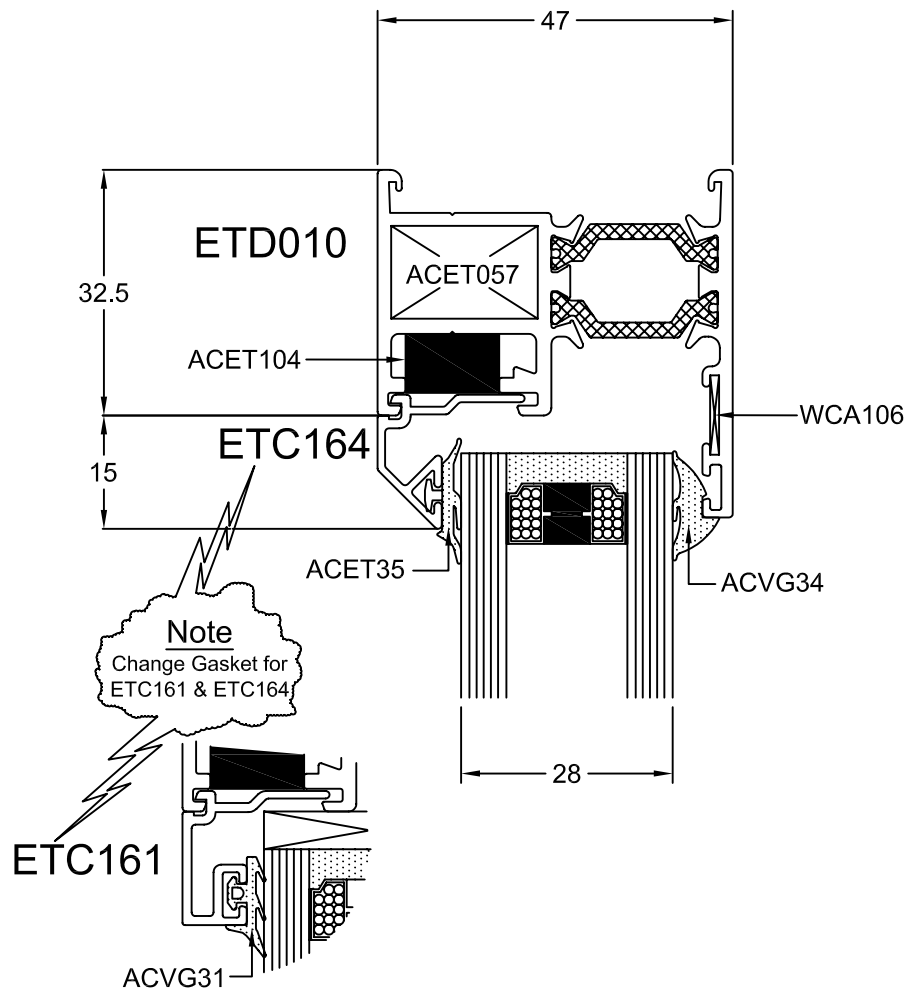
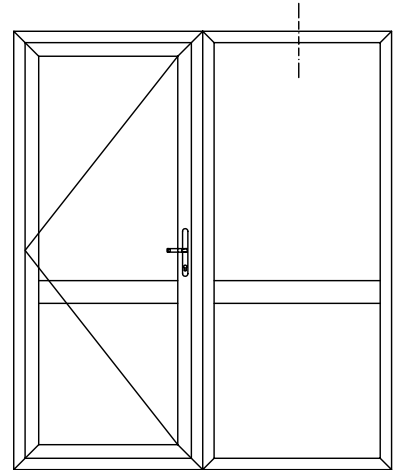


7a

Doors - Open Out

Scale 1:1

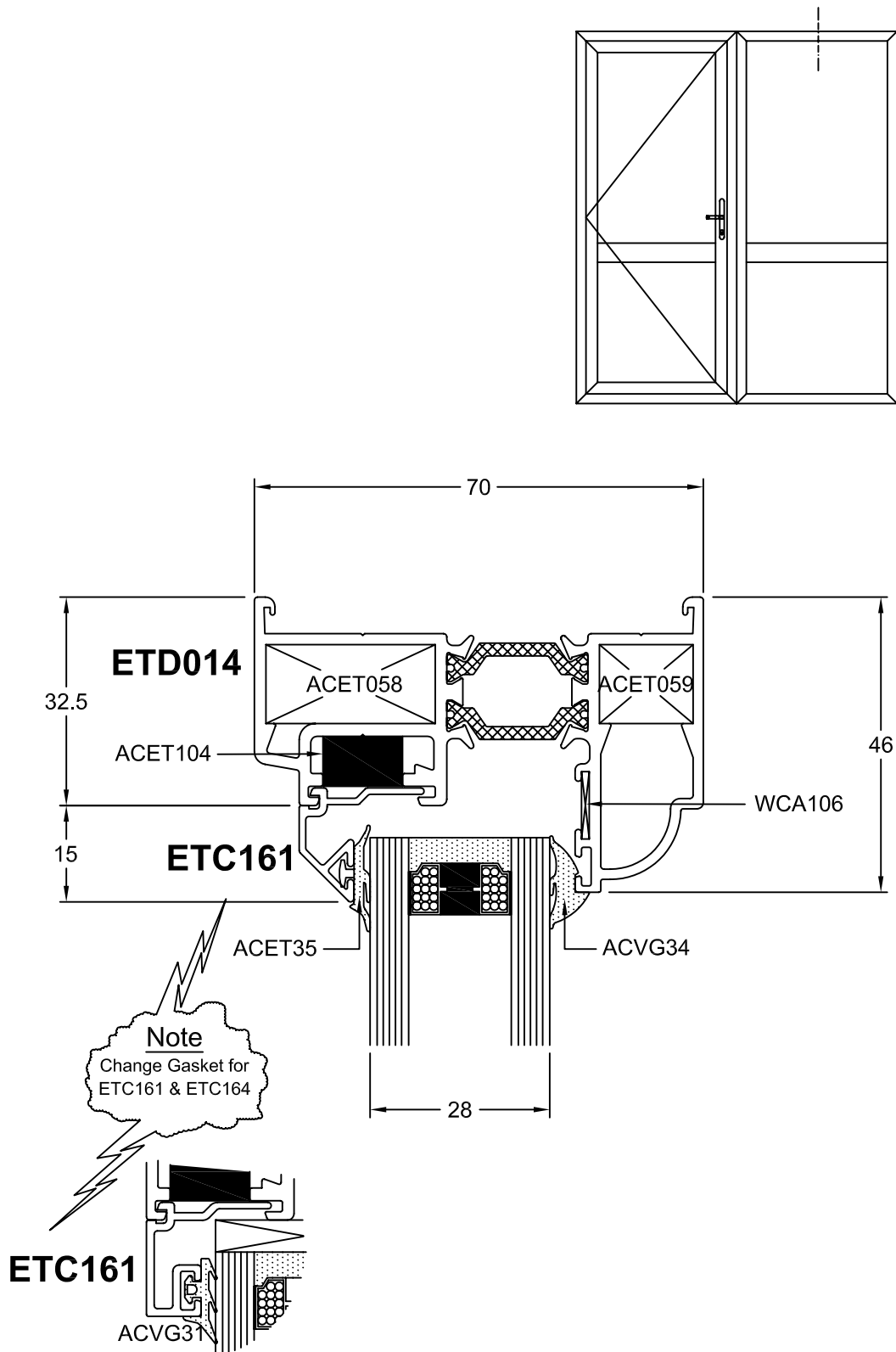


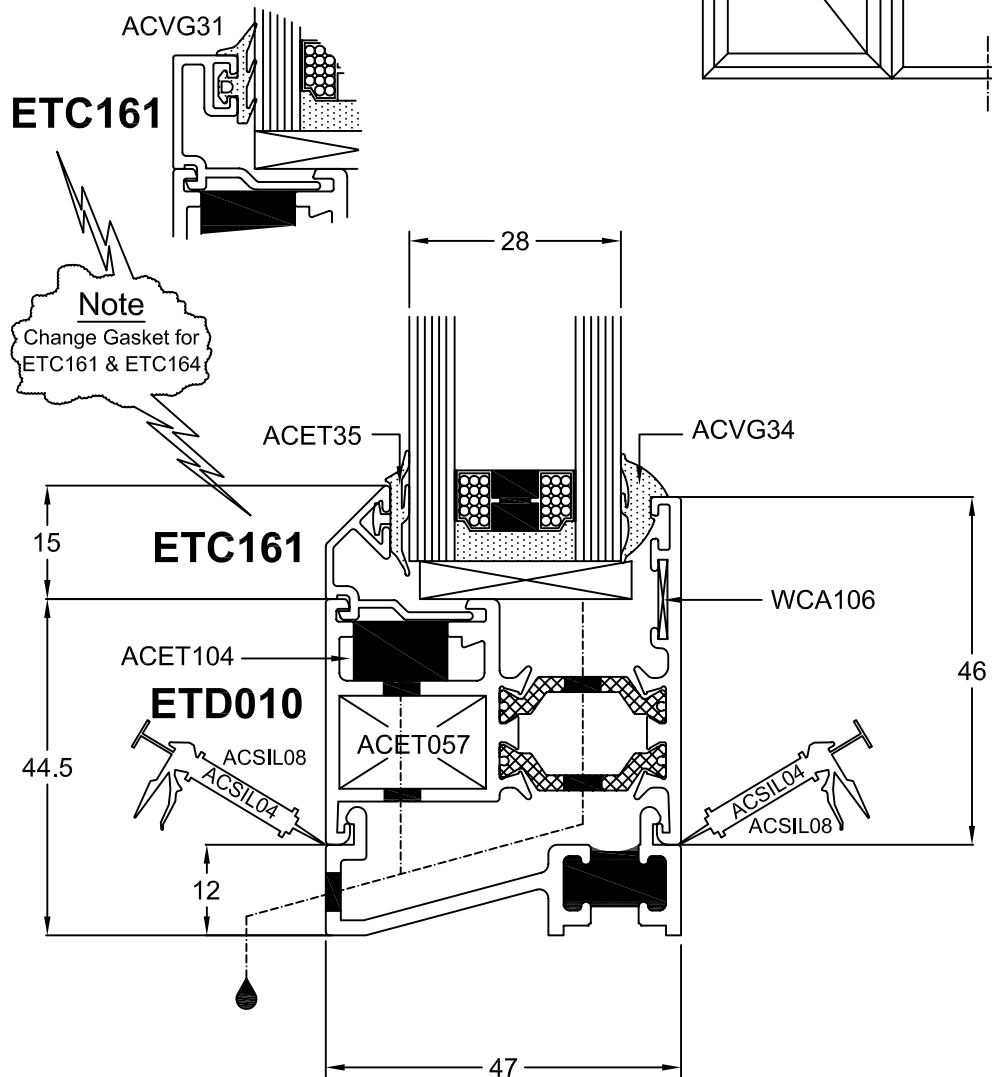


8b

Doors - Open Out

Scale 1:1

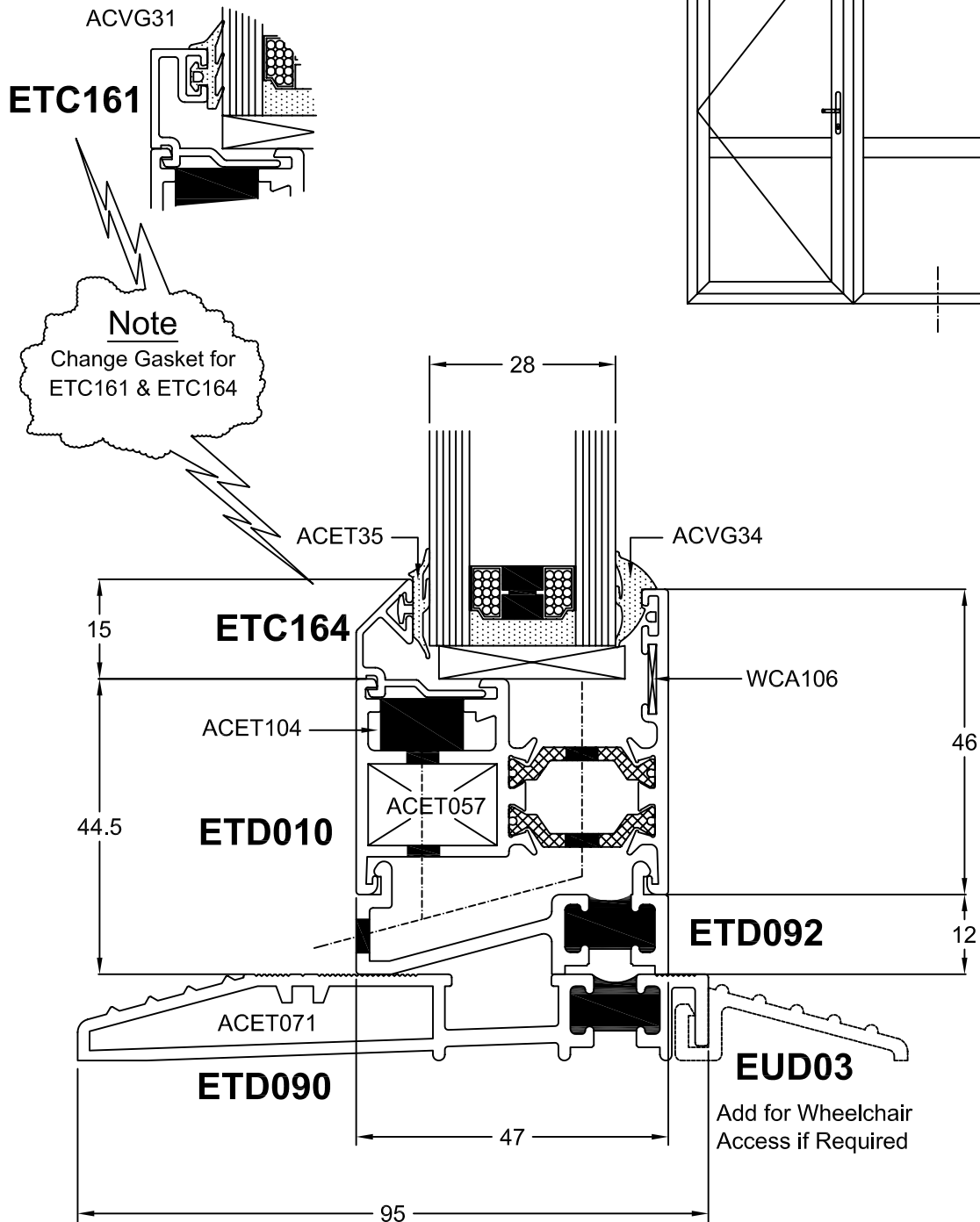




9b

Doors - Open Out

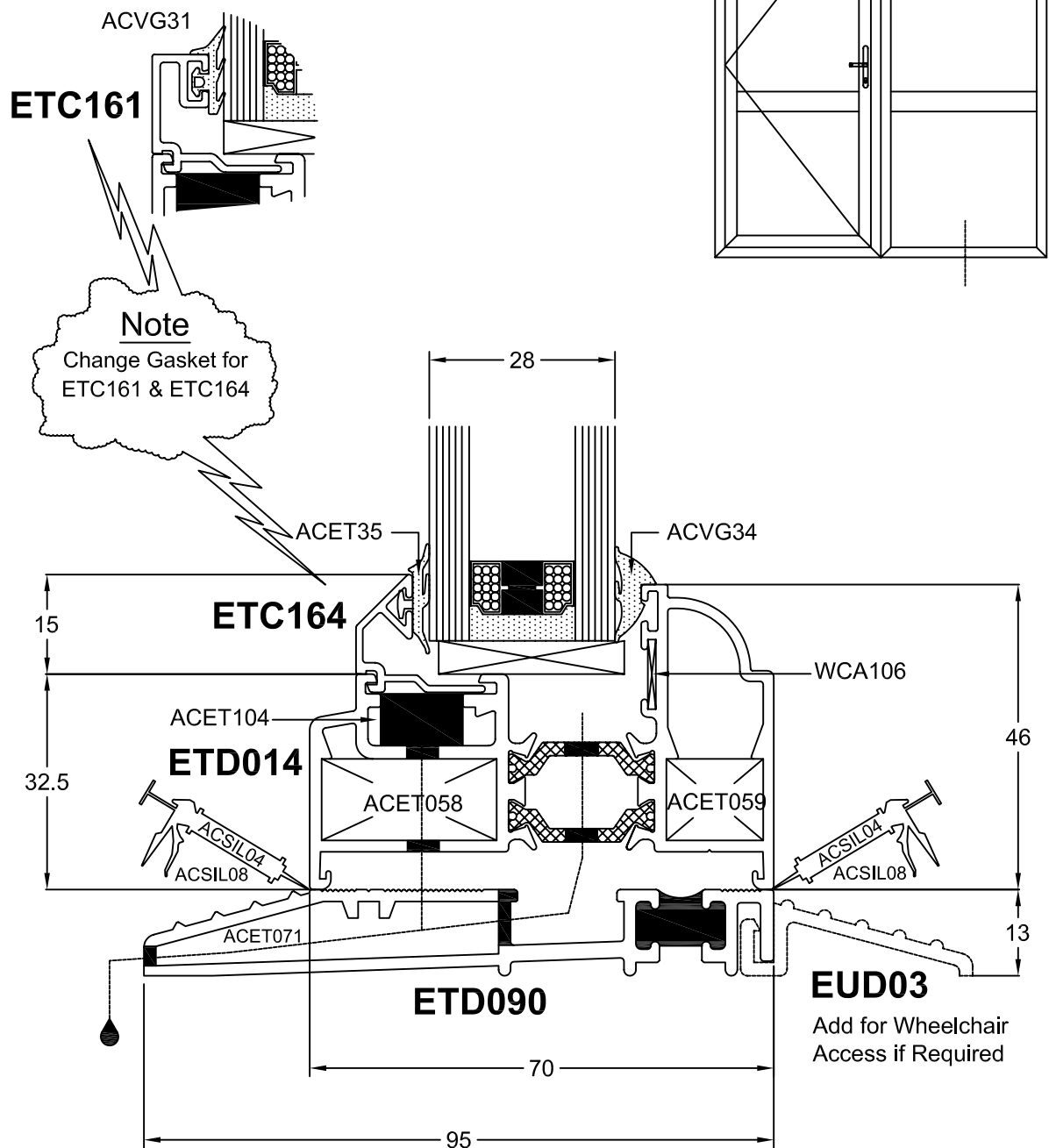
Scale 1:1



Scale 1:1

Doors - Open Out

9c

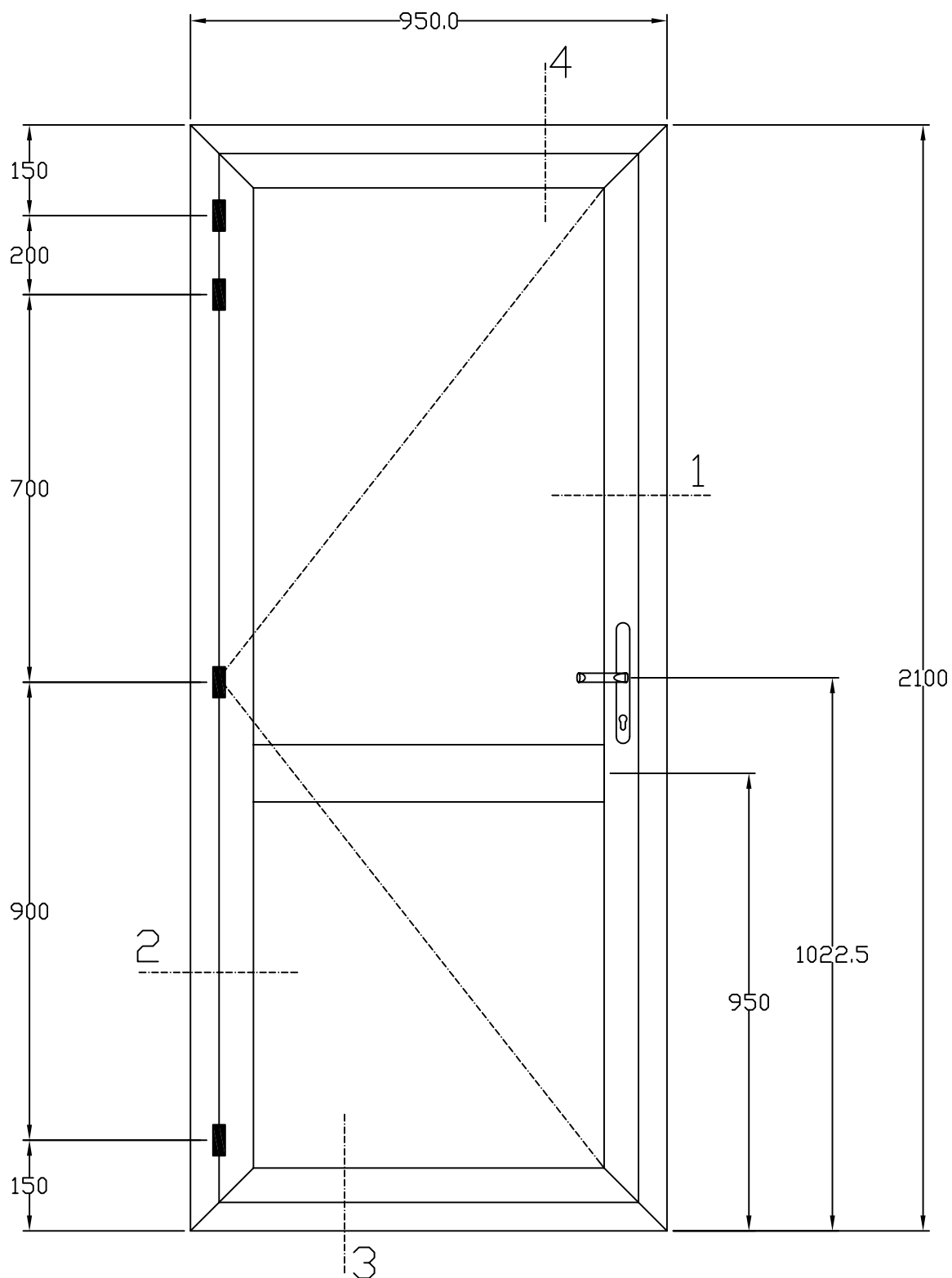


Doors - Open Out

Scale 1:1

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PAS23/24 Doors - Single Open In Only

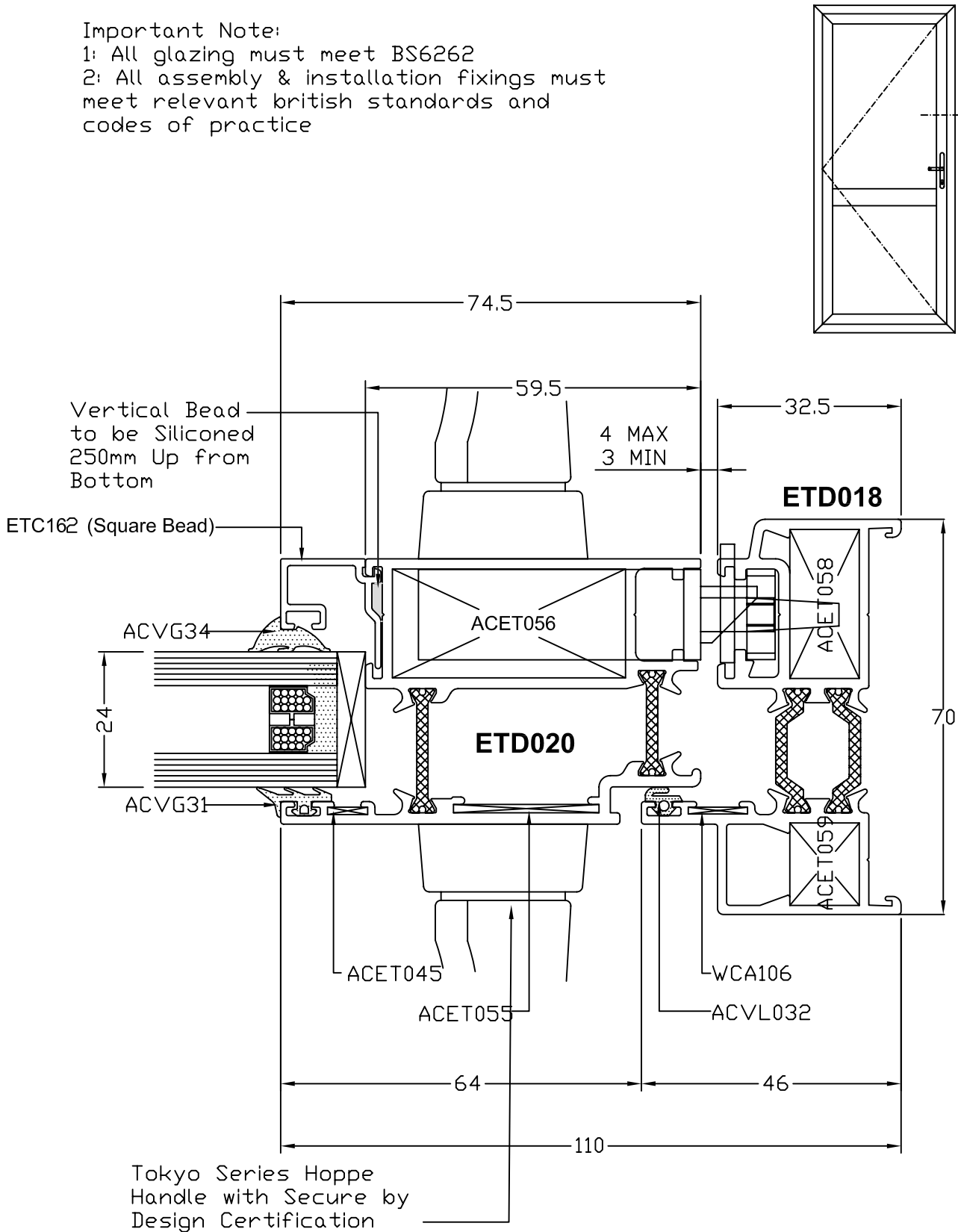


1**PAS23/24 Doors - Single Open In Only**

Scale 1:1

Important Note:

- 1: All glazing must meet BS6262
- 2: All assembly & installation fixings must meet relevant british standards and codes of practice



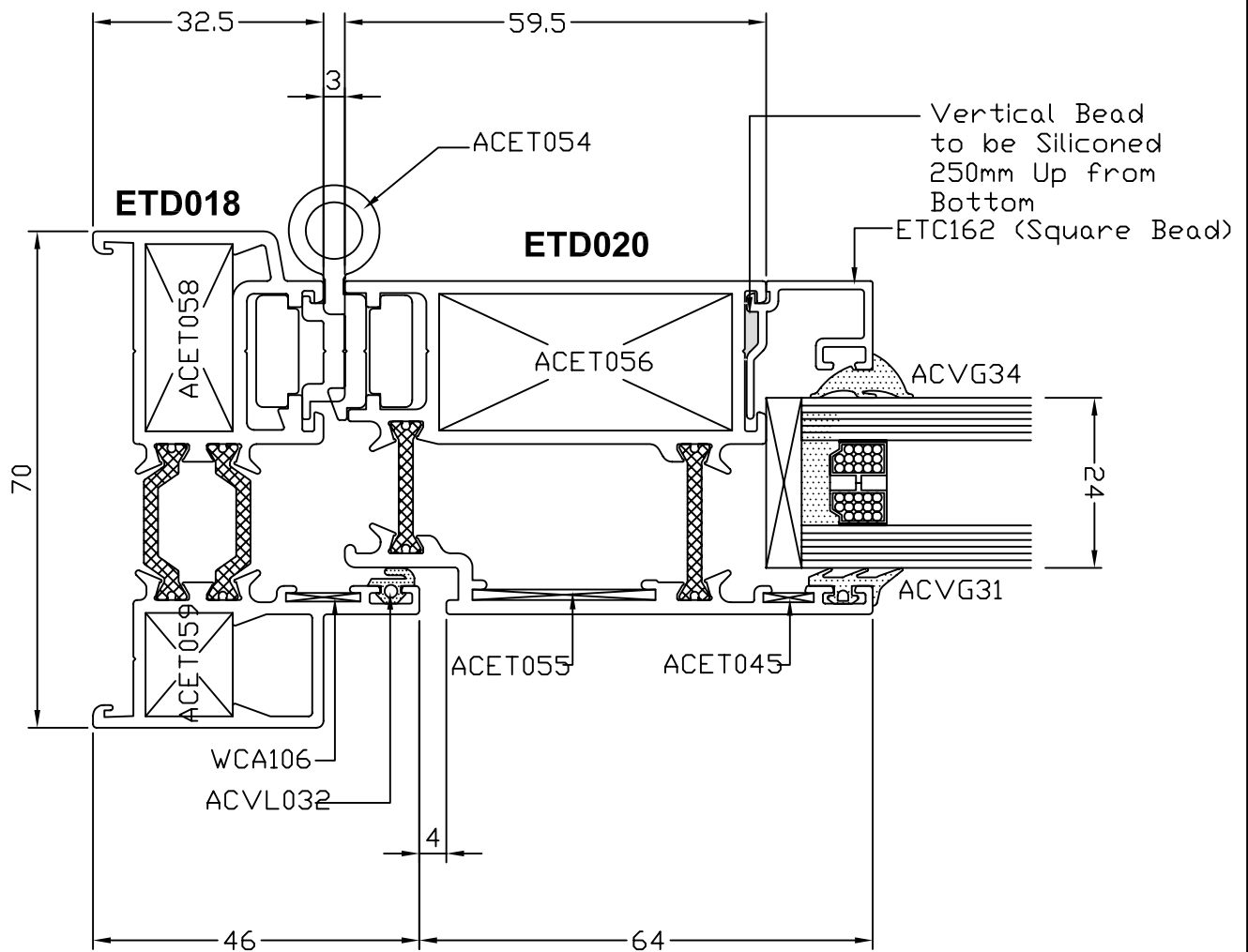
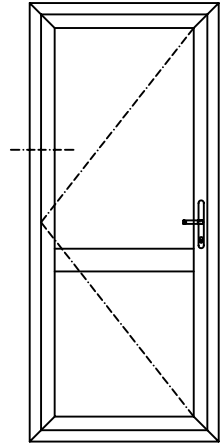
2

PAS23/24 Doors - Single Open In Only

Scale 1:1

Important Note:

- 1: All glazing must meet BS6262
- 2: All assembly & installation fixings must meet relevant british standards and codes of practice

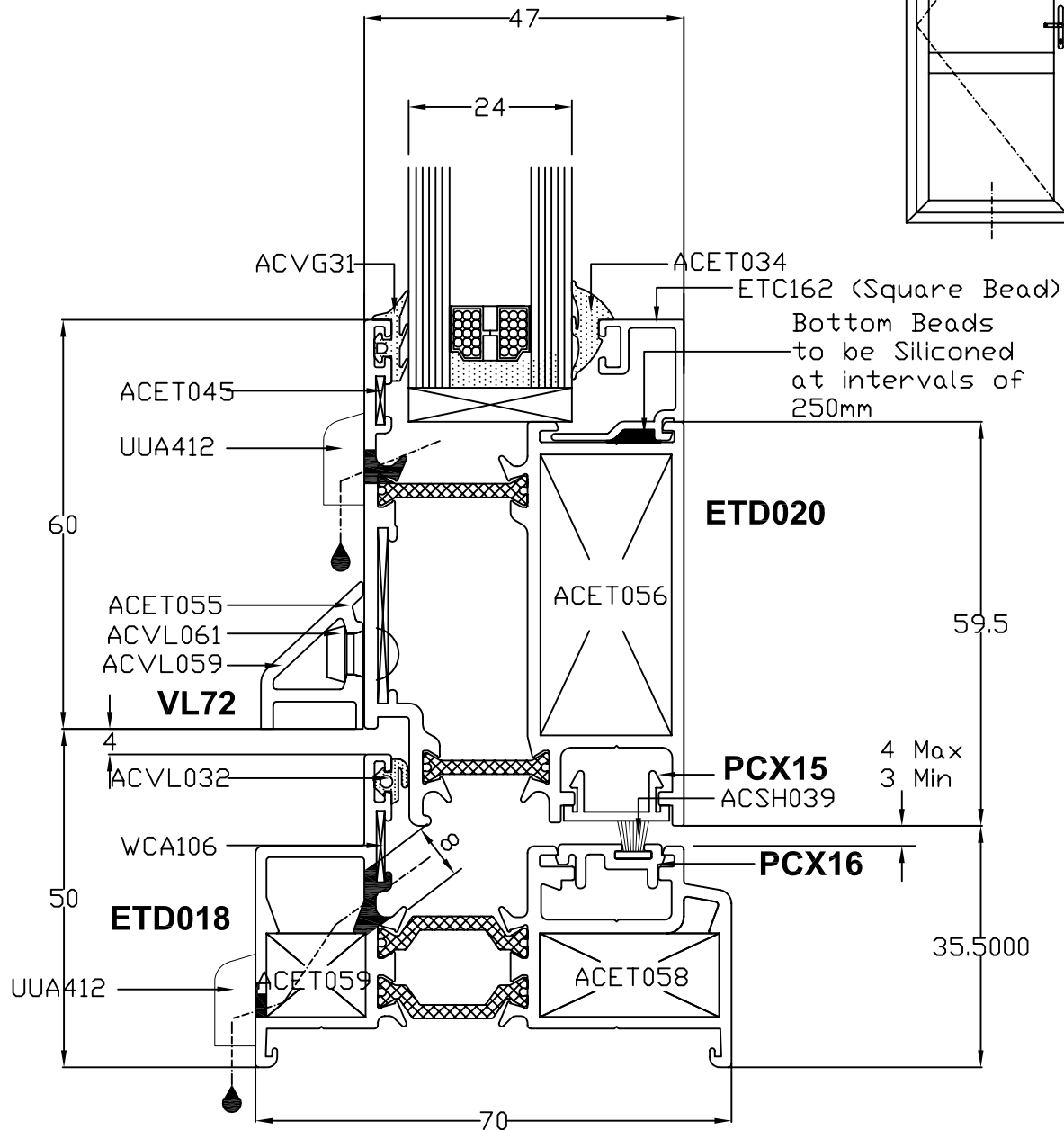


3**PAS23/24 Door-Single Open In Only**

Scale 1:1

Important Note:

- 1: All glazing must meet BS6262
- 2: All assembly & installation fixings must meet relevant british standards and codes of practice



Important Note:

Doors will not comply with PAS 23 & 24 with a low threshold - full frame must be used.

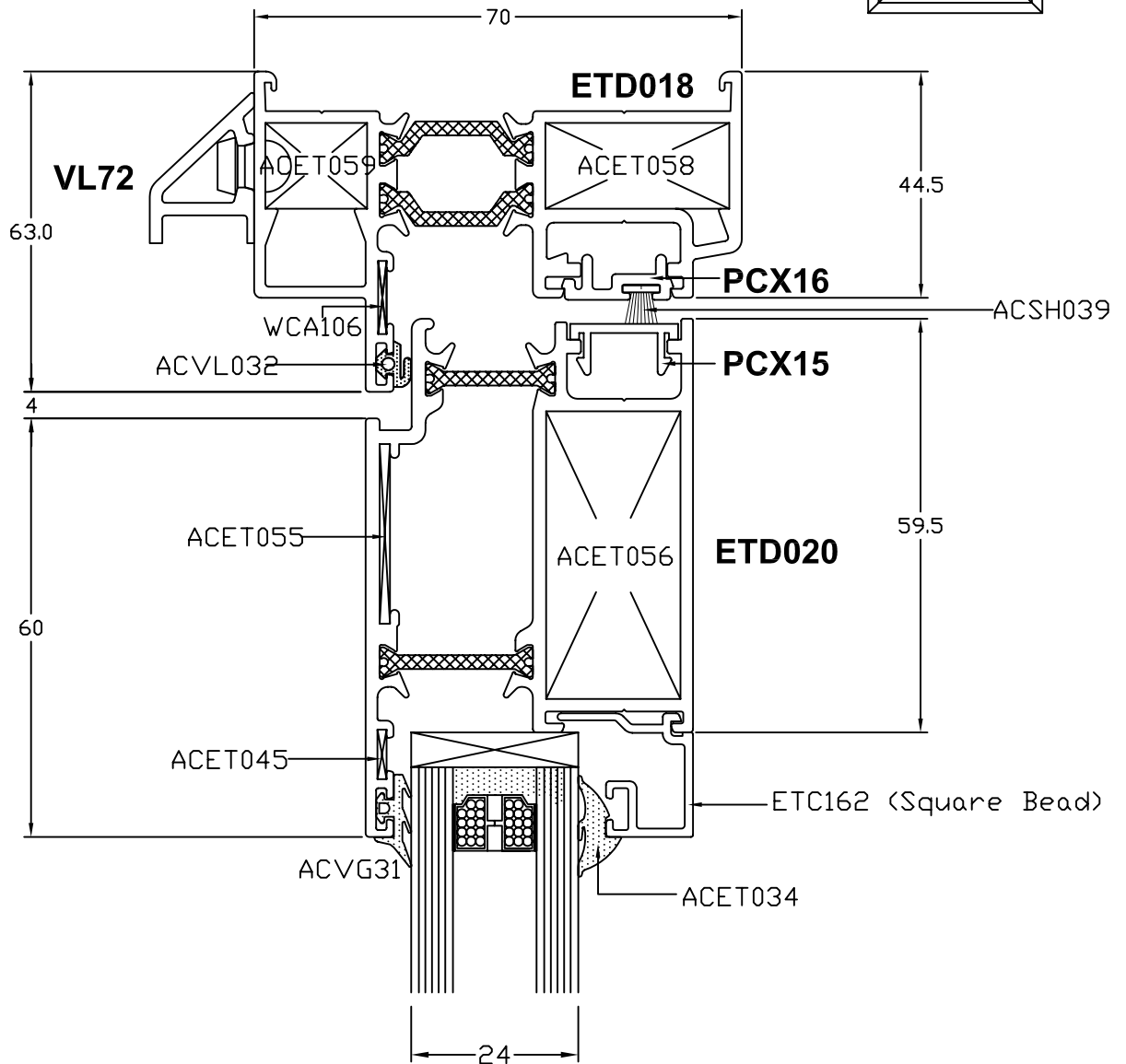
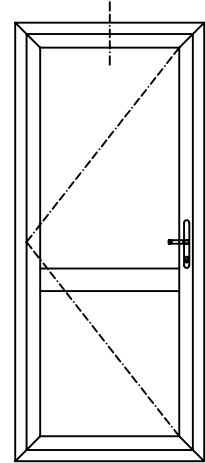
4

PAS23/24 Door-Single Open In Only

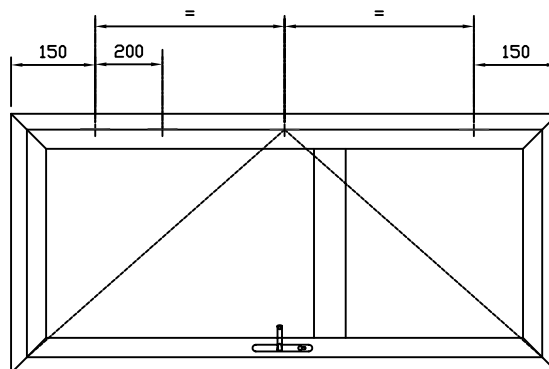
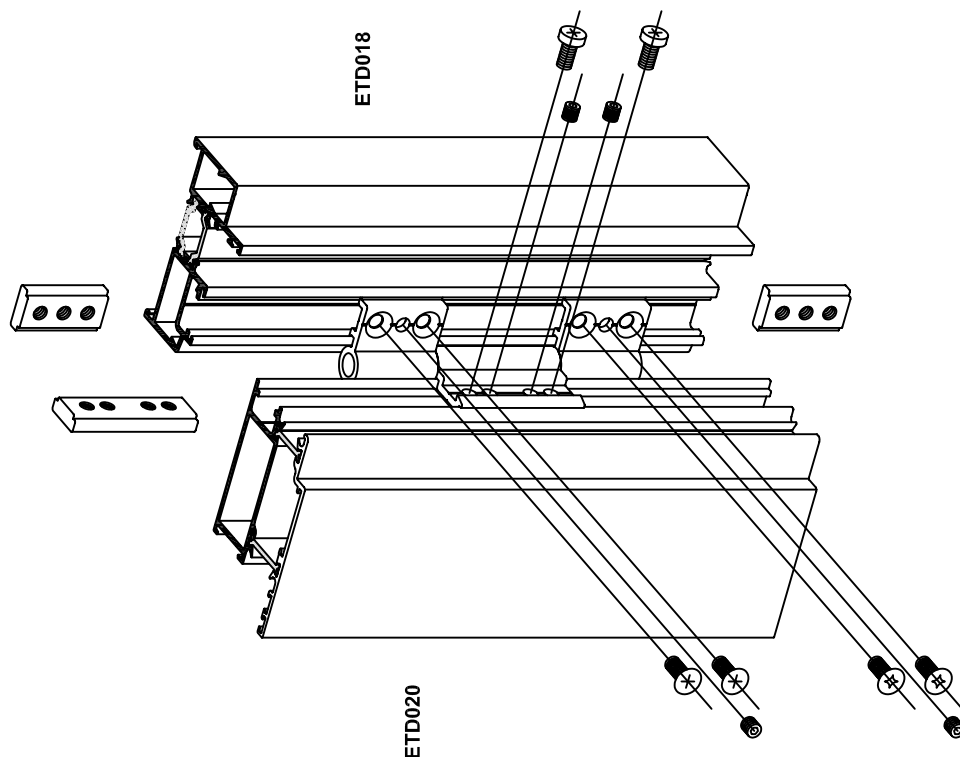
Scale 1:1

Important Note:

- 1: All glazing must meet BS6262
- 2: All assembly & installation fixings must meet relevant british standards and codes of practice



PAS23/24 Door - Single Open In Only



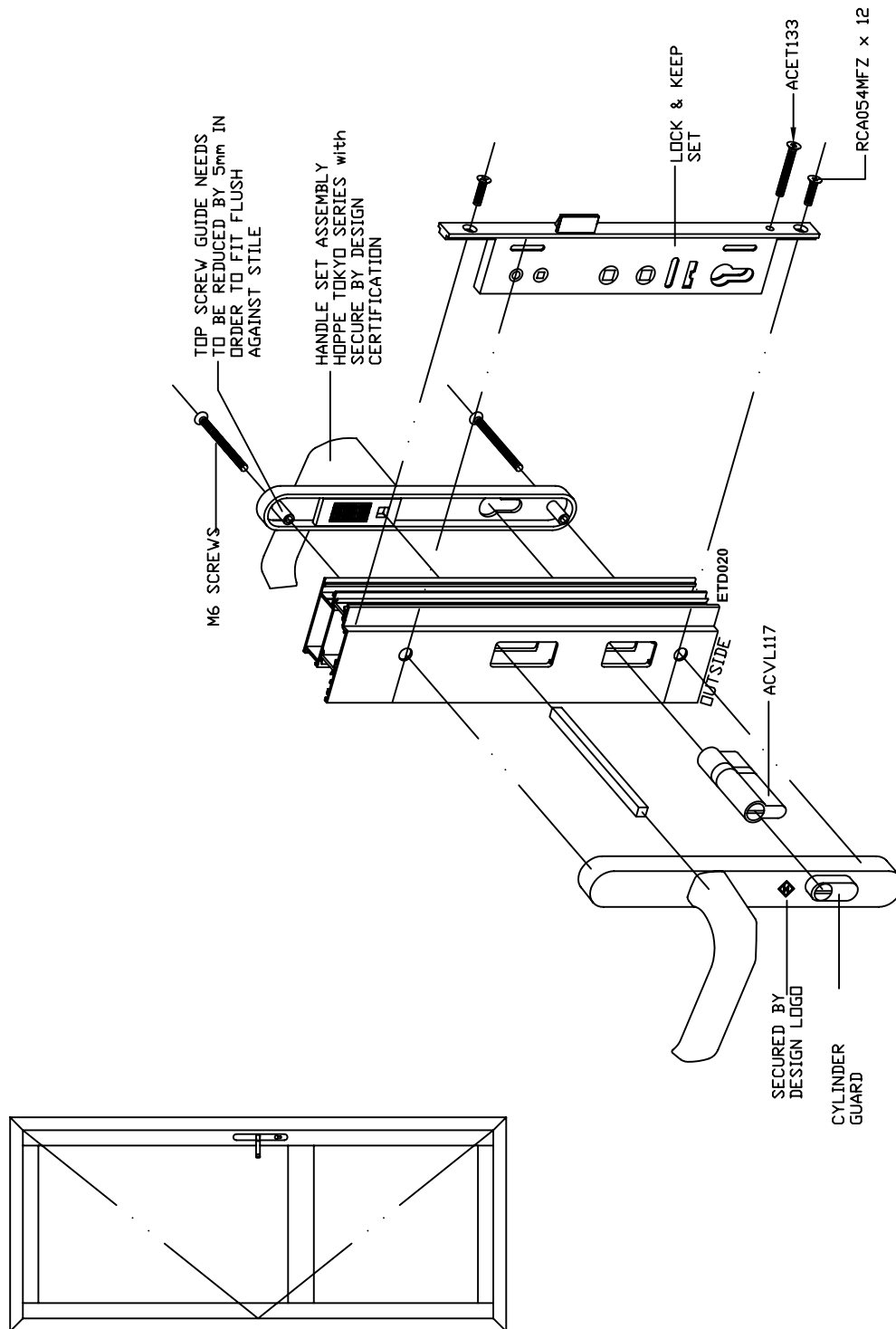
2100 Max Door Leaf >70Kg up to 80Kg Max.

ASSEMBLY INSTRUCTIONS

- 1-Fix 2no M5x10mm grub screws to sash frame clamp plate and slide into sash eurogroove to hinge position.
- 2-Locate hinge and clamp in position using 2no M5x10mm machine screws.
- 3-Fix sash to outer frame using clamp plates and fit M5x15mm c/sk machine screws and adjust for correct operation.
- 4-If the sash requires adjustment after the door has been glazed this can be achieved by loosening the clamp plate machine screws, adjusting the sash height and tightening the clamp plates.
- 5-Once the hinges are in the correct position replace the machine screws with 3/4" size 8 self tapping countersunk stainless steel screw. These should be fixed through the first skin of each section.

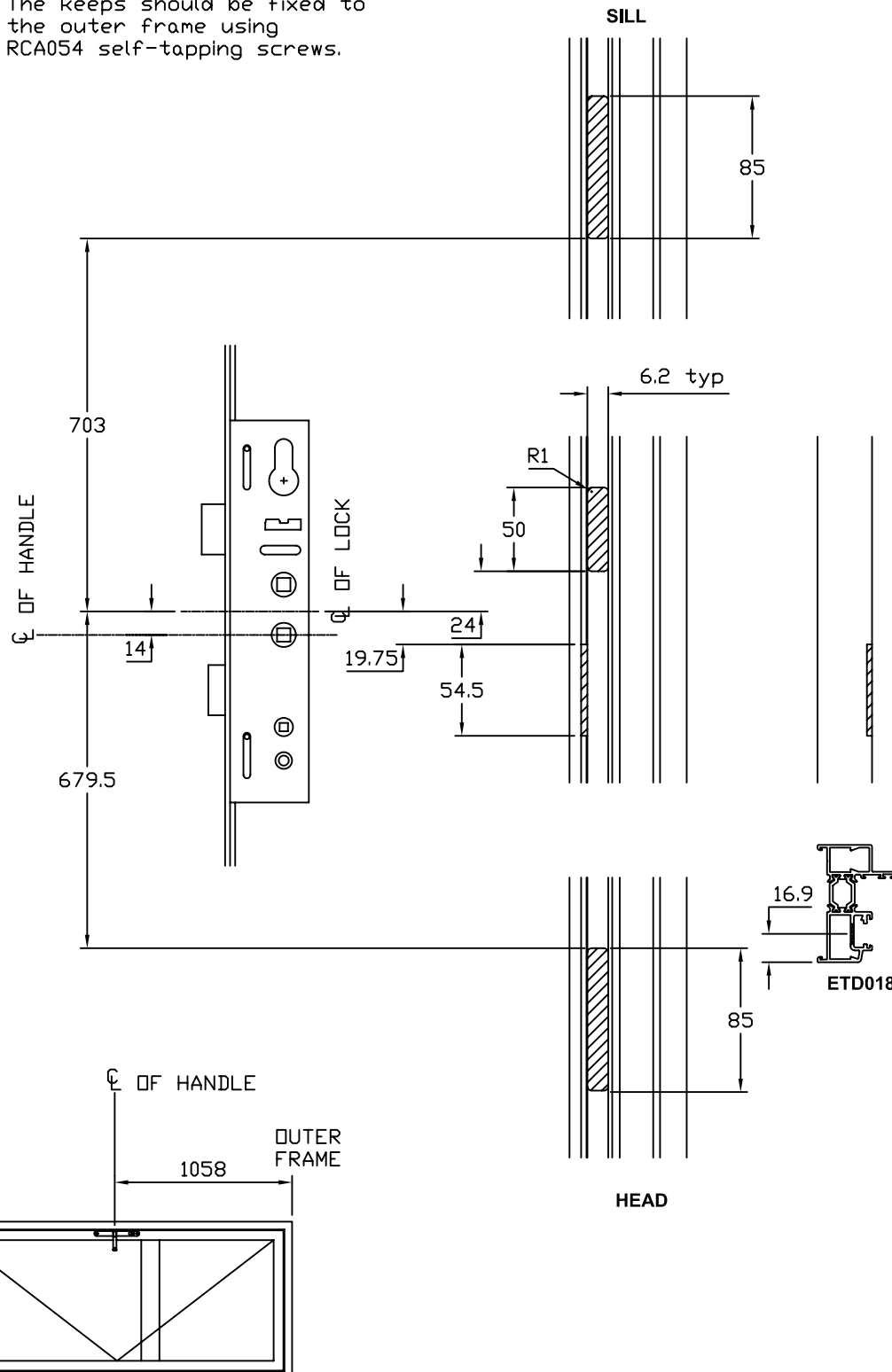
Important Note:
 1: All glazing must meet BS6262
 2: All assembly & installation fixings must meet BS4873
 3: Four hinges must be used to comply with PAS 23 & 24

PAS23/24-Doors Single Open In Only

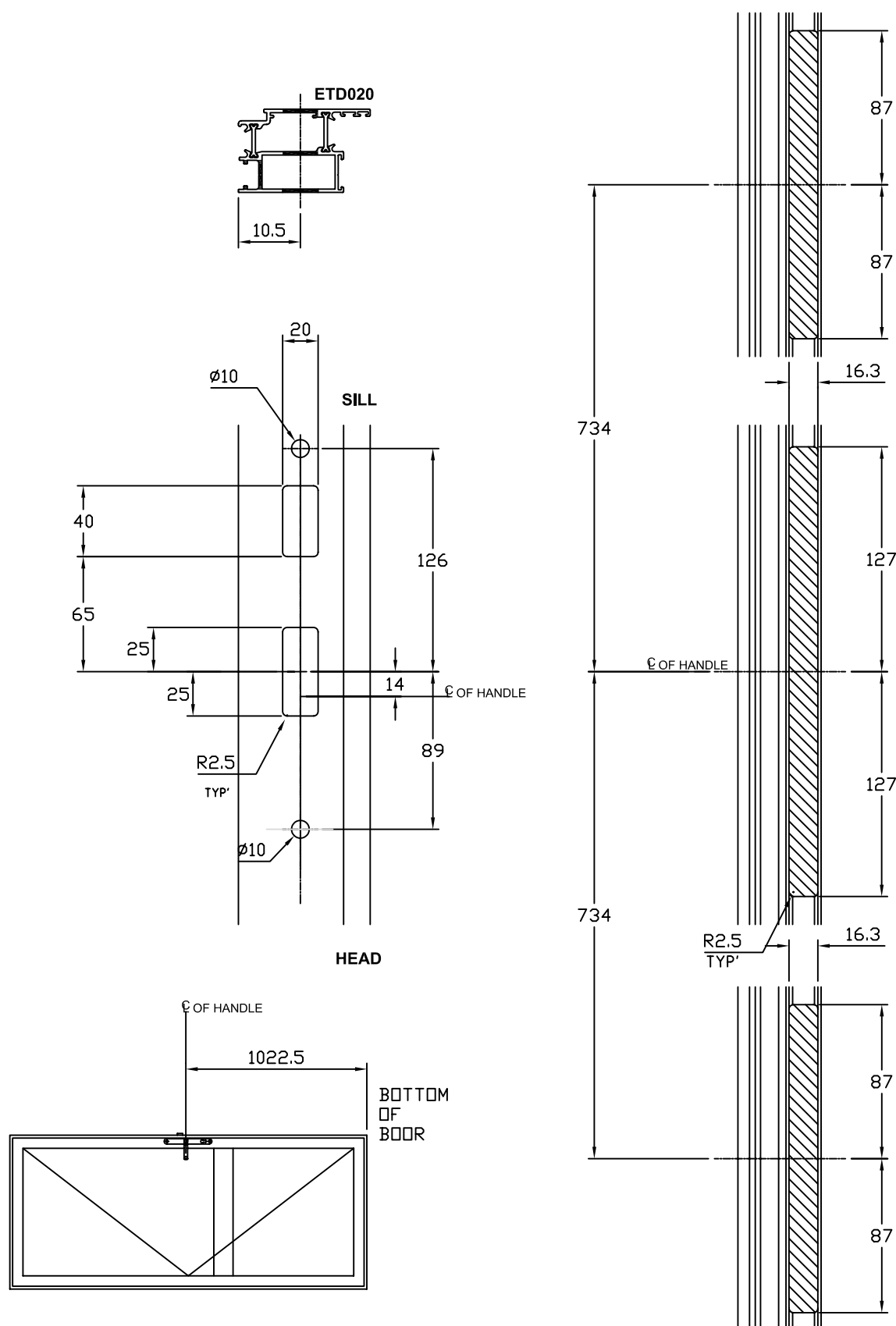


PAS23/24 Doors -Single Open In Only

Important Note:
The keeps should be fixed to
the outer frame using
RCA054 self-tapping screws.



PAS23/24 Door-Single Open In Only (Normal Lock) 35 MM Backset/Door Leaf Preparation



PAS23/24 Doors - Single Open In Only

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PAS23/24 Doors - Single Open Out Only

Not Yet Tested

Drawing Number:dETD-02-00

PAS23/24 Doors - Single Open Out Only

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Cover Sheet

Open In & Open Out

Cover Sheet

Alitherm Door
Open In
Construction Drawings

Index



Construction Drawings << Open In >>



1 - Open In - Corner Jointing Page 127 to 133



2 - Transom/Mullion Fixings Page 134 to 137



3 - Stays / Hinges Page 138 to 138



4 - Locking Hardware Page 139 to 153



5 - Bead & Glazing Page 154 to 154



6 - Drainage Page 155 to 157



7 - Miscellaneous Page 158 to 160

IF IN DOUBT ASK!

Alitherm Door
Open Out
Construction Drawings

Index



Construction Drawings << Open Out >>



1 - Open Out - Corner Jointing Page 91 to 97



2 - Transom/Mullion Fixings Page 98 to 101



3 - Stays / Hinges Page 102 to 102



4 - Locking Hardware Page 103 to 117



5 - Bead & Glazing Page 118 to 118



6 - Drainage Page 119 to 121



7 - Miscellaneous Page 122 to 124

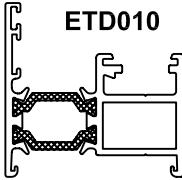
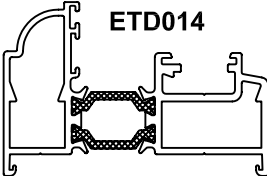
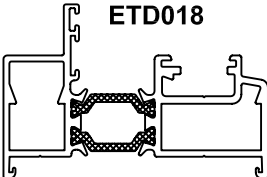
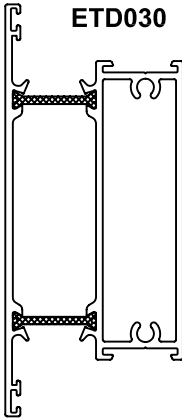
IF IN DOUBT ASK!

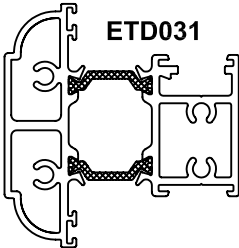
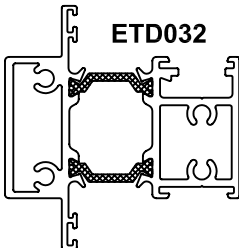
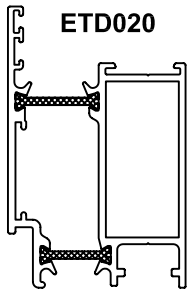
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1a

Open In - Door Profiles

1a

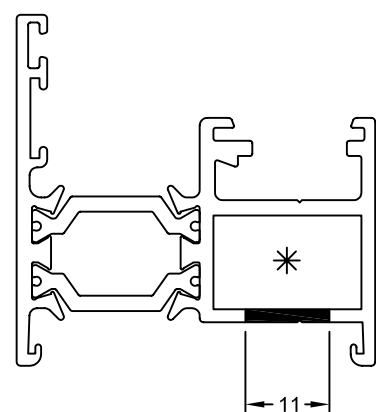
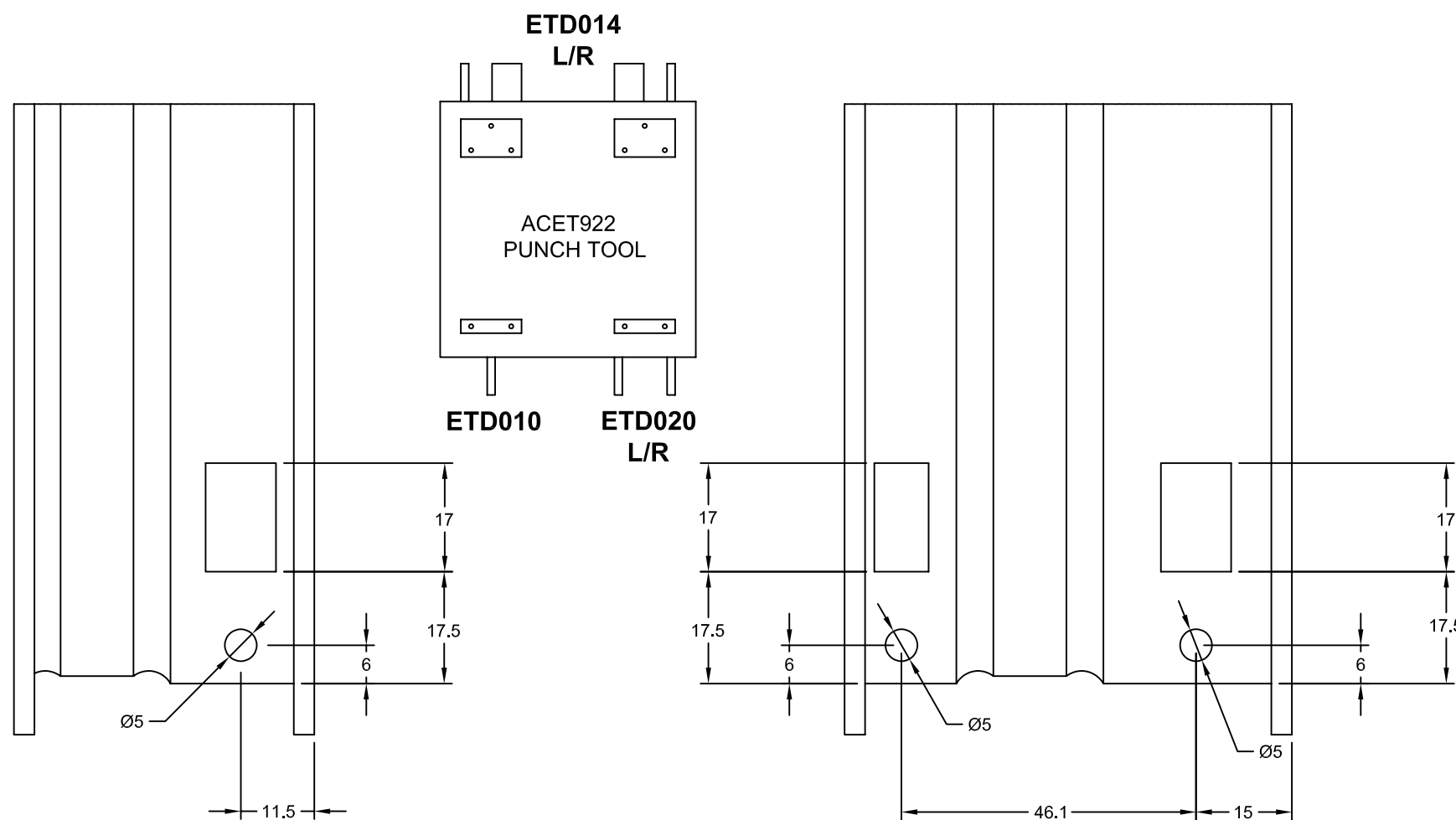
Profiles	Tooling / Components
 ETD010	Corner Chevron - WCA106 Mechanical cleat - ACET057 Tooling - ACET922
 ETD014  ETD018	Corner Chevron - WCA106 Mechanical Cleat - ACET058 Mechanical Cleat - ACET059 Tooling - ACET922
 ETD030	Core Screw - PUA056ssz Drill Jig - ACET923

Profiles	Tooling / Components
 ETD031  ETD032	Core Screw - ACET079 Drill Jig - ACET916
 ETD020	Corner Chevron - ACET045 Corner Chevron - ACET055 Mechanical Cleat - ACET056 Tooling - ACET922

1b

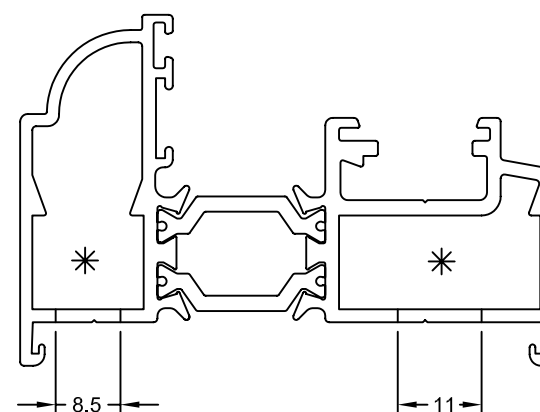
Open In - Corner Cleat

1b



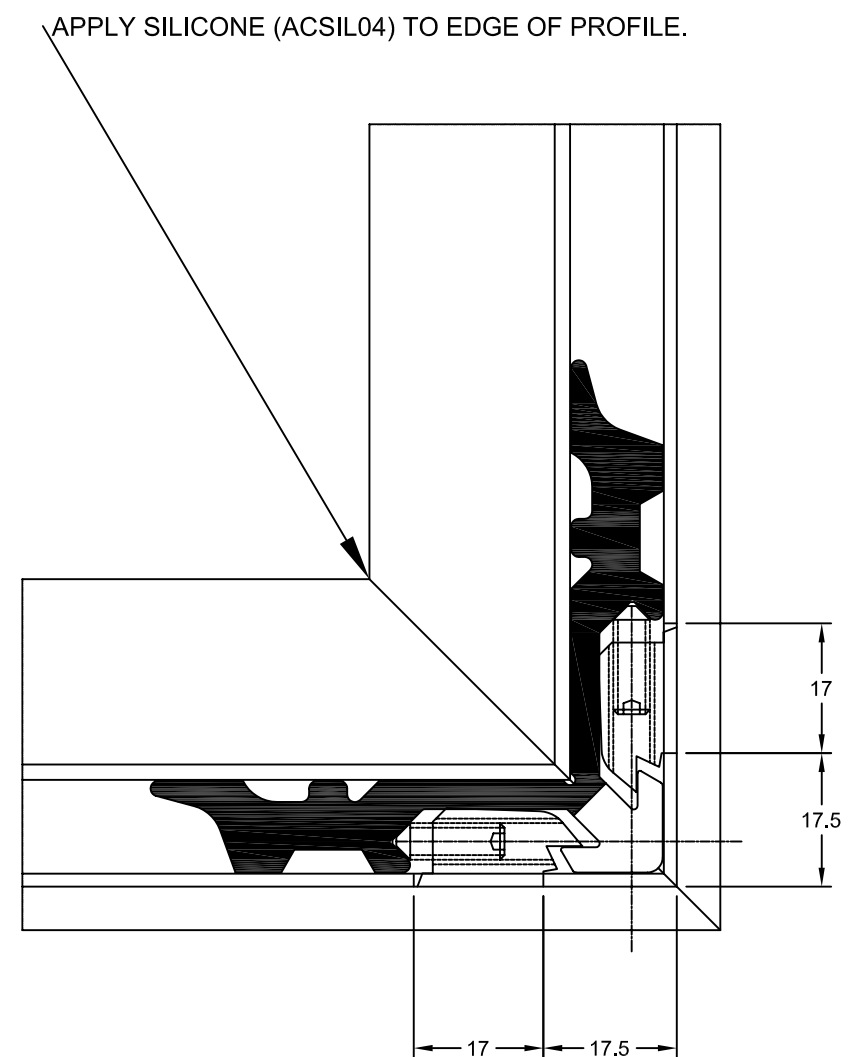
ETD010

CORNER CLEAT-ACET057



ETD014

CORNER CLEAT-ACET058 & 059

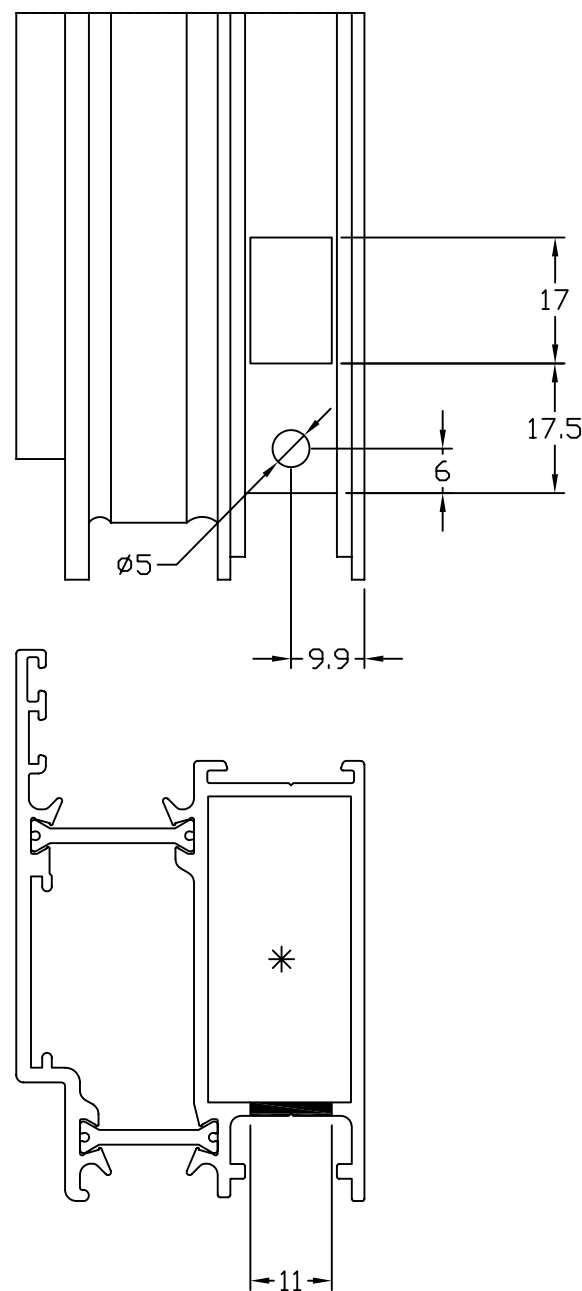


APPLY GLUE (ACSIL013) TO CLEAT APERTURE MARKED *

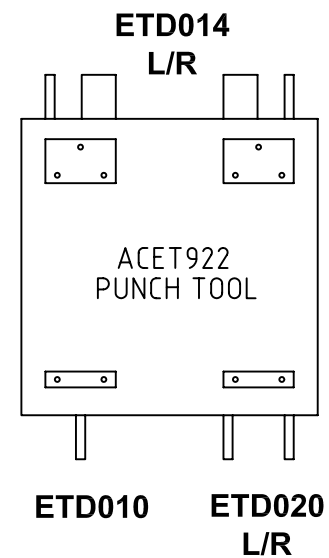
1c

Open In - Corner Cleat

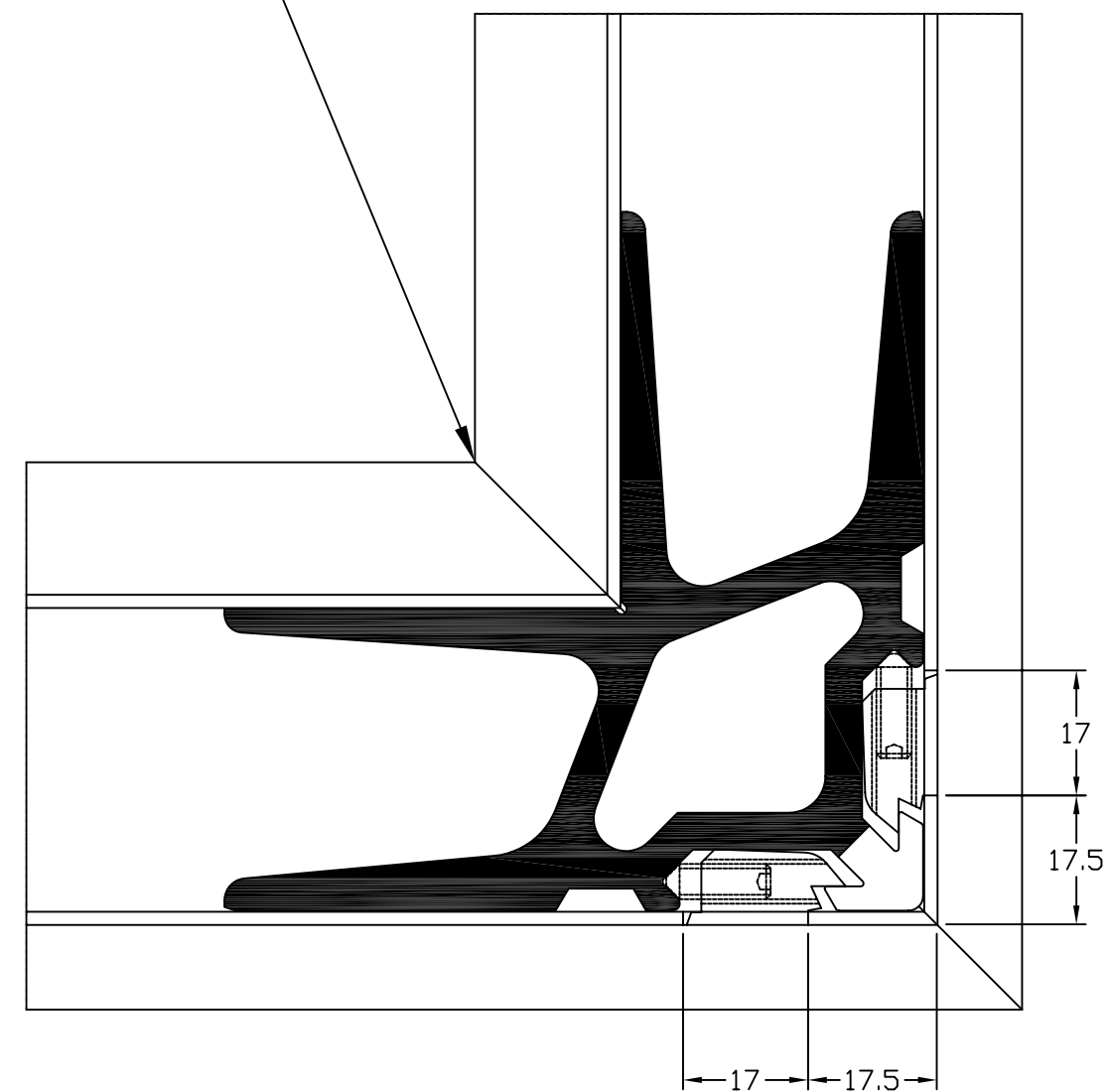
1c



ETD020
Corner Cleat - ACET056



Apply Silicone (ACSIL04) to Edge of Profile

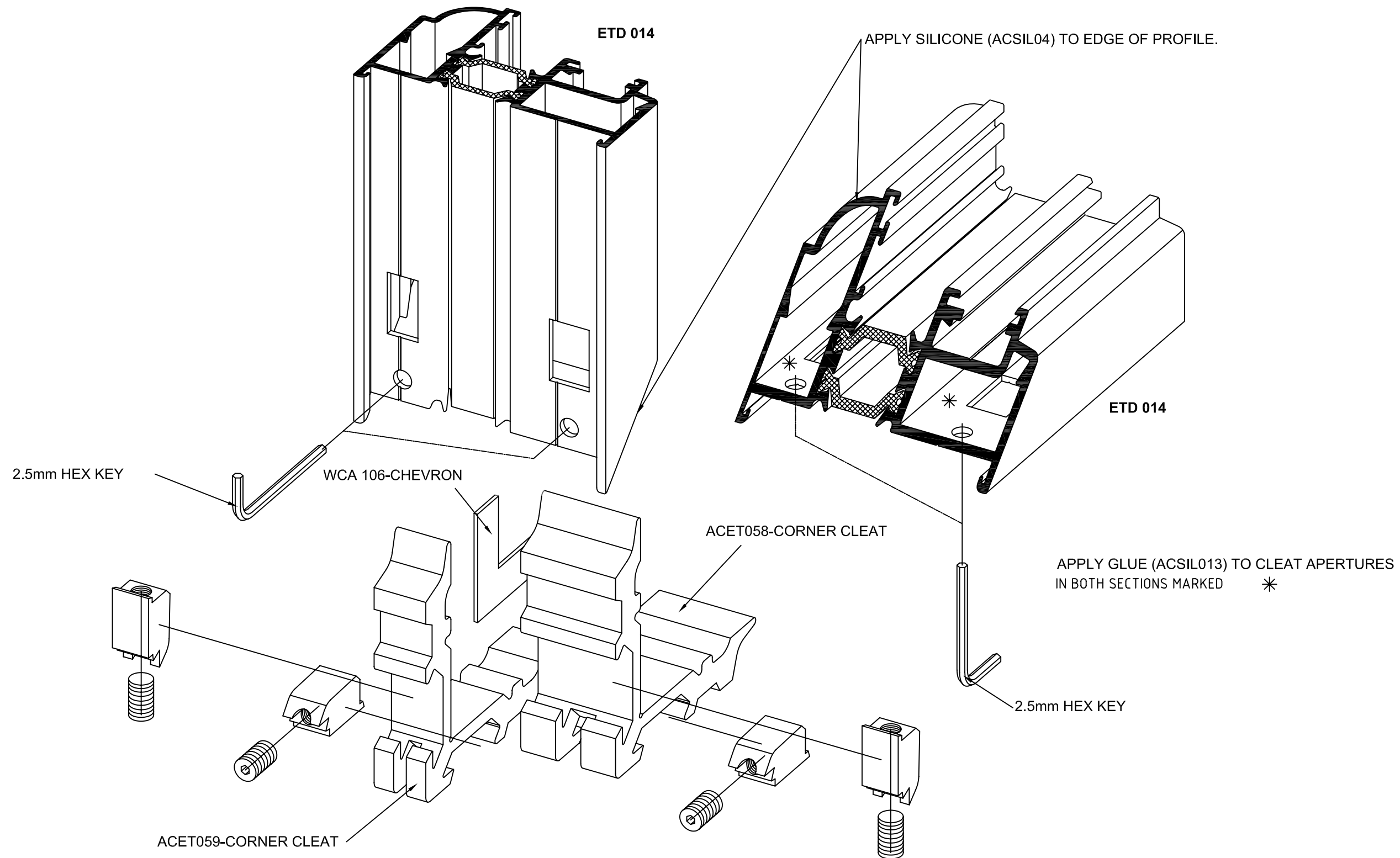


Apply Glue (ACSIL013) to Cleat Aperture Marked *

1d

Open In - Corner Cleat

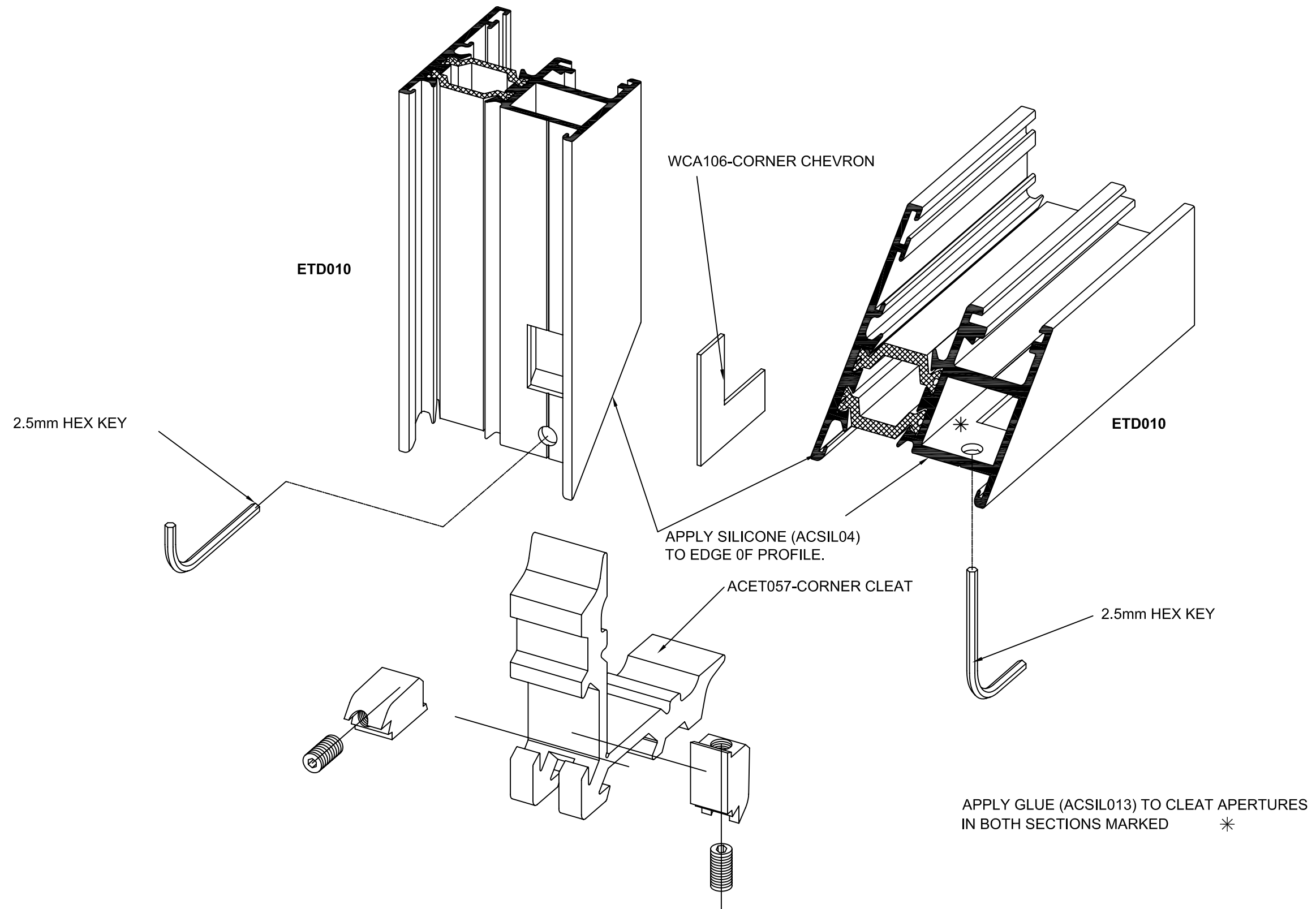
1d



1e

Open In - Montage Square Coupling Joint

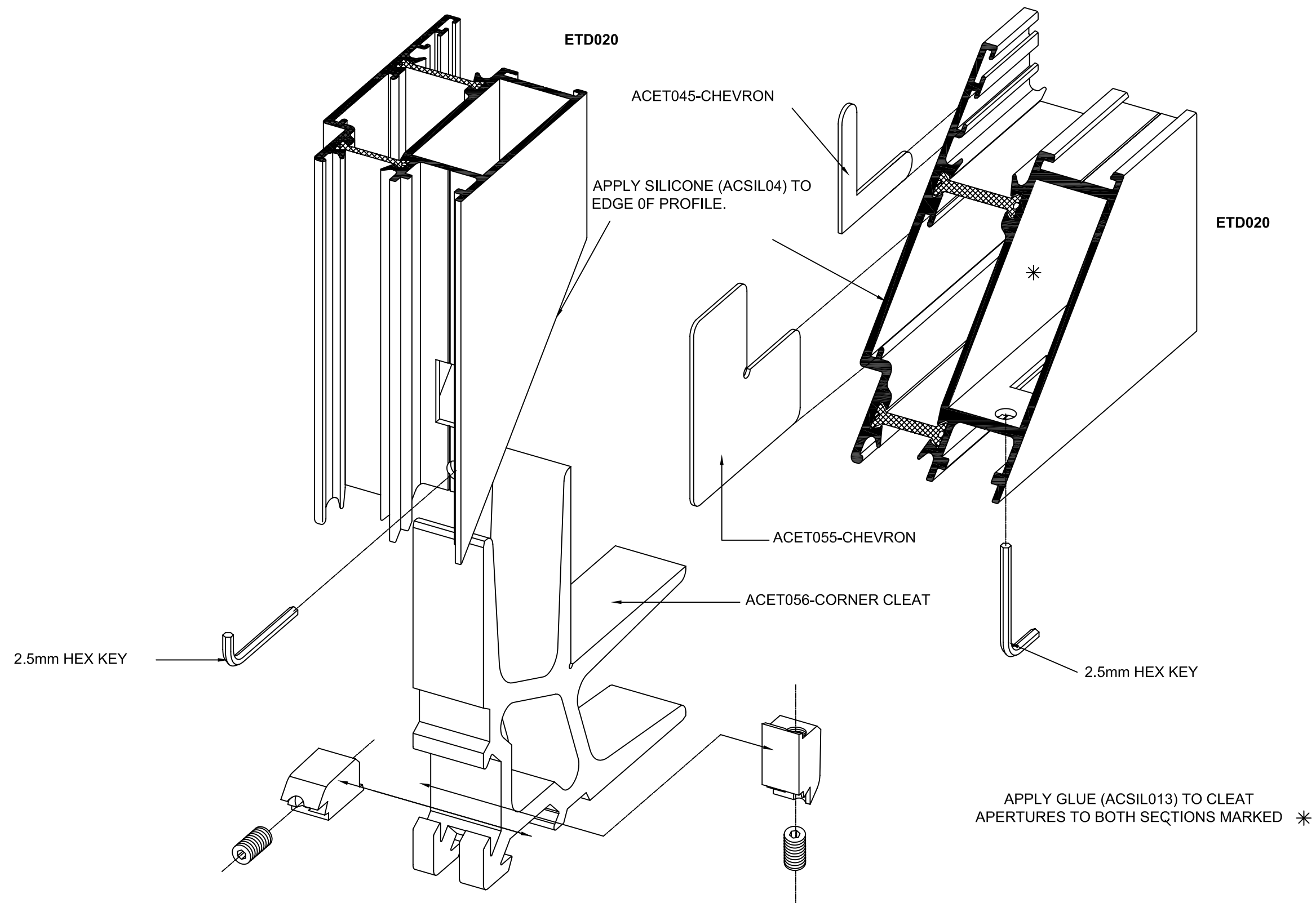
1e



1f

Open In - Montage Square Coupling Joint

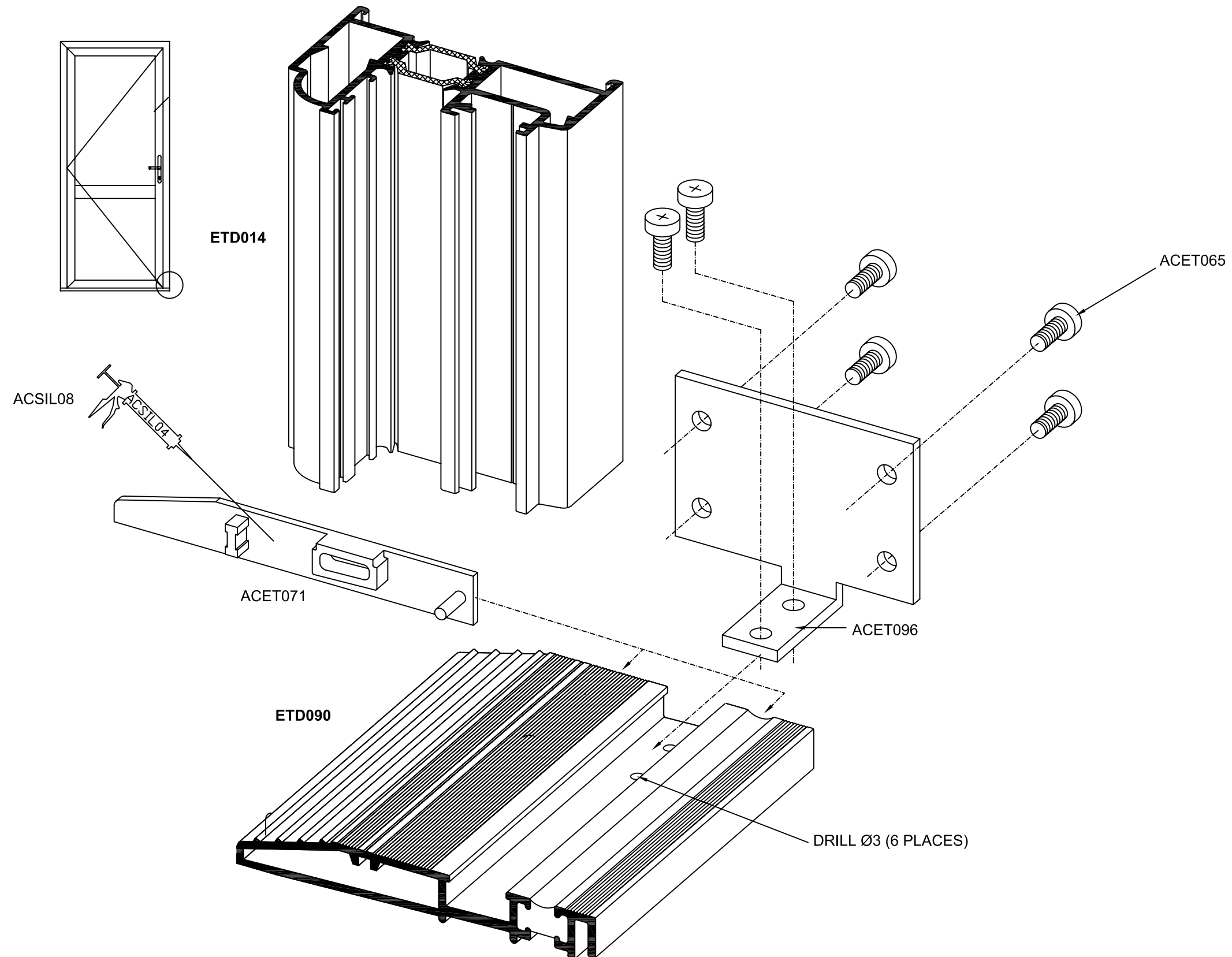
1f



1g

Open In - Low Threshold Corner Joint

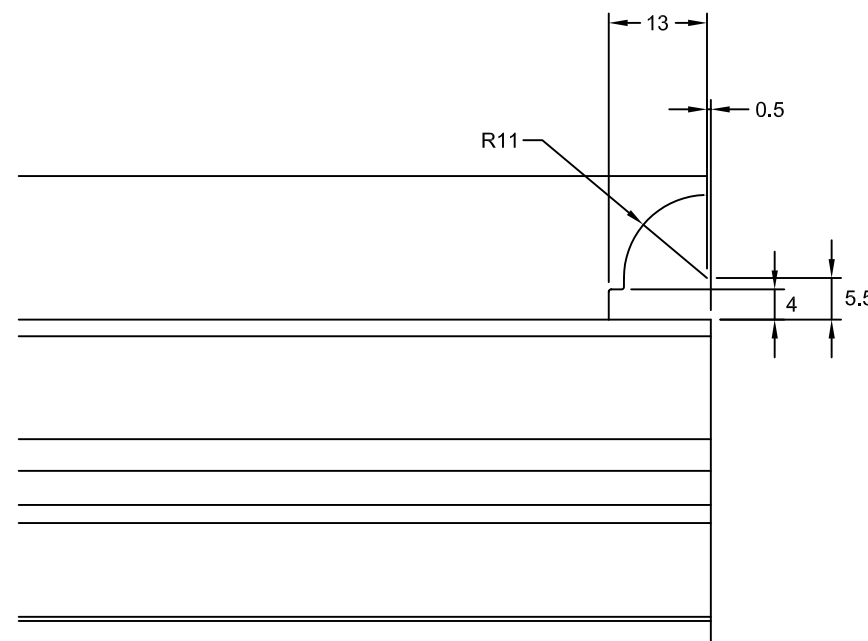
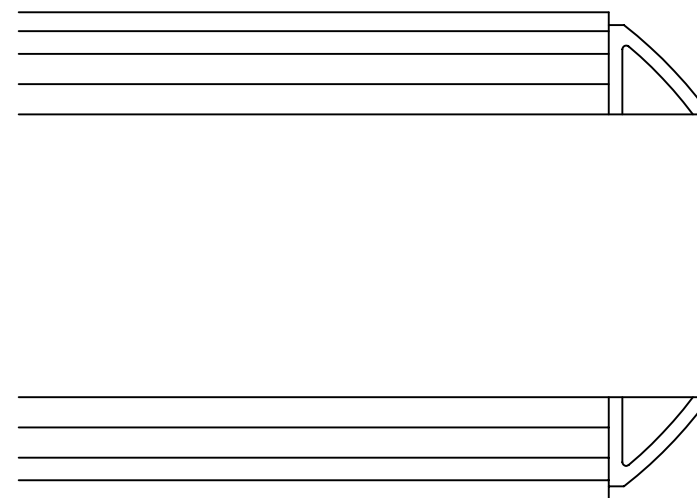
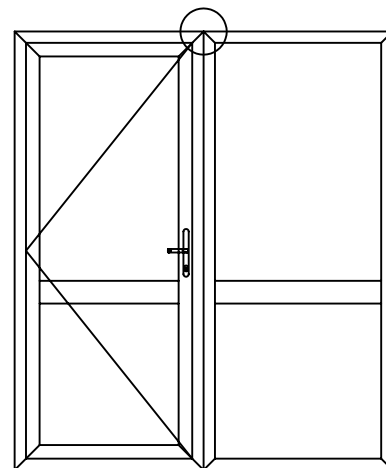
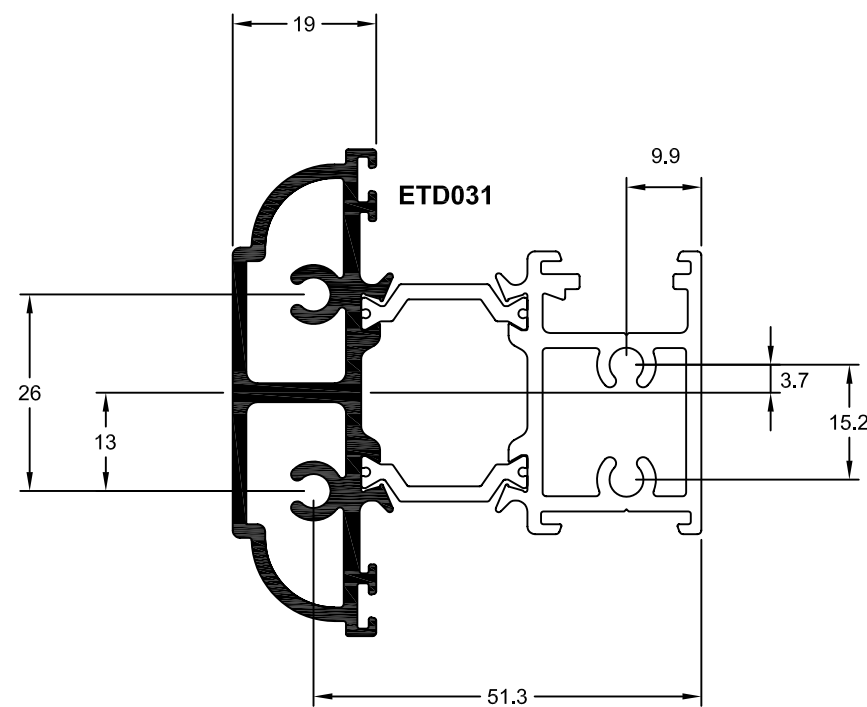
1g



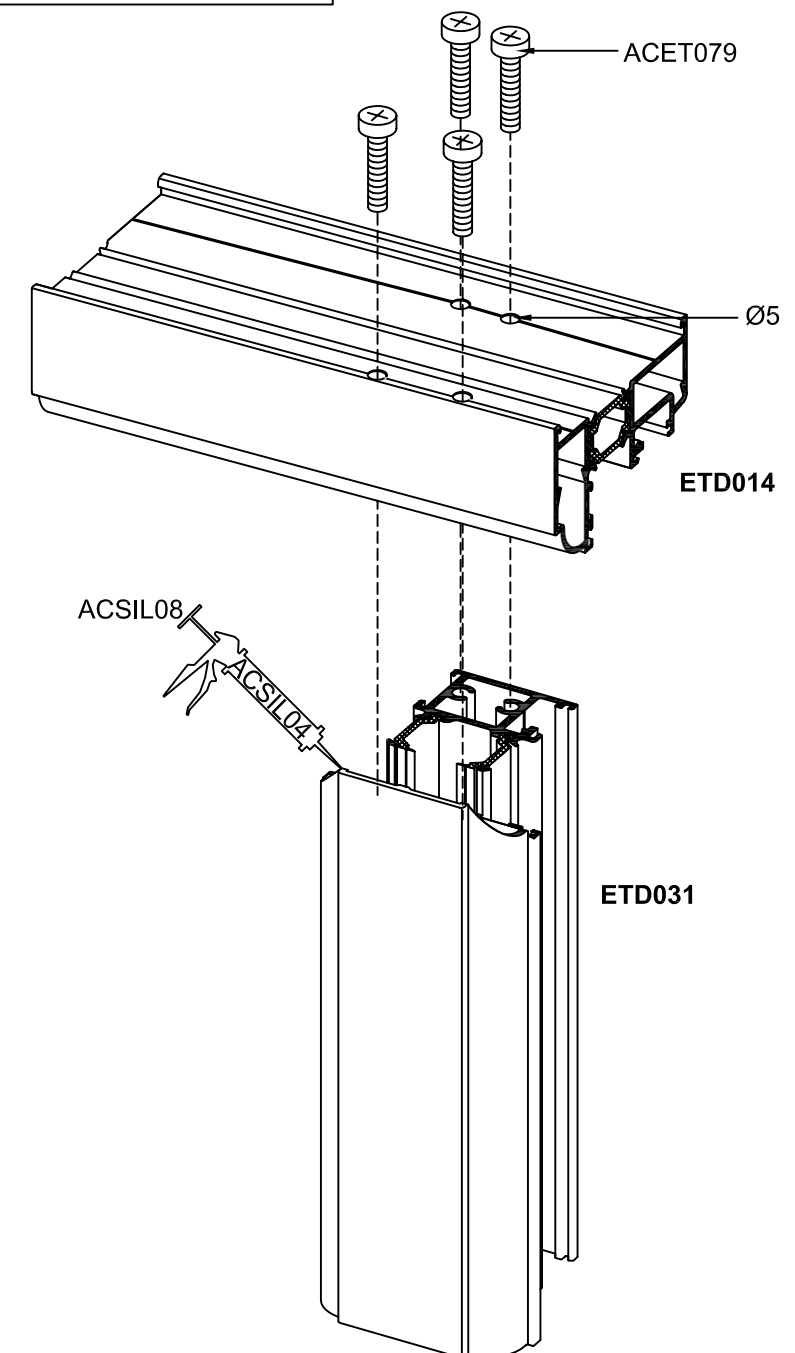
2a

Open In - Integral Mullion - 70mm Ovolo Outerframe

2a



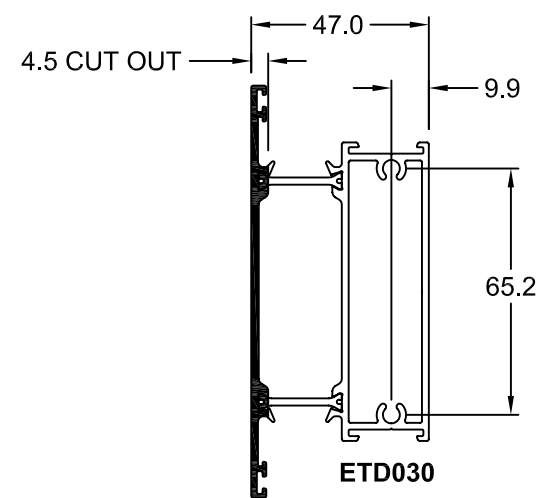
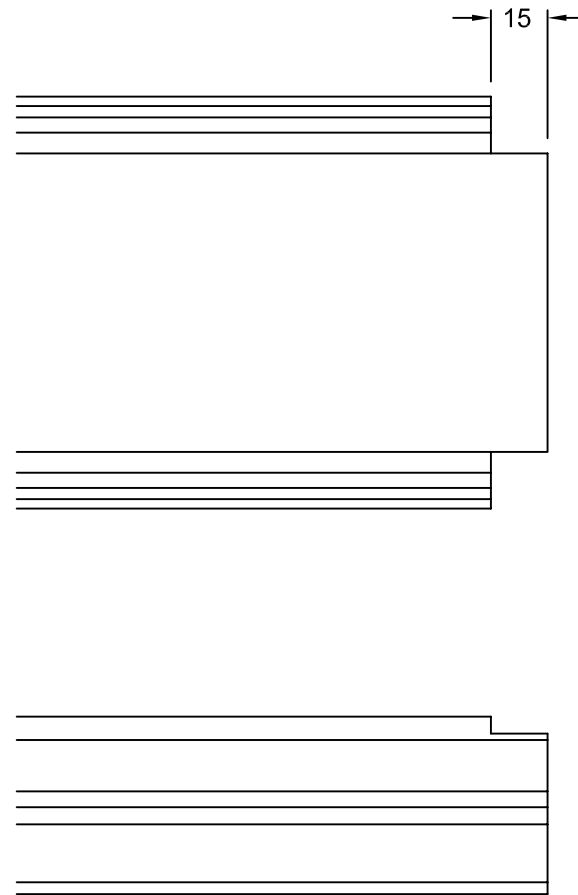
To ensure accuracy use
recommended drill
jig-ACET916



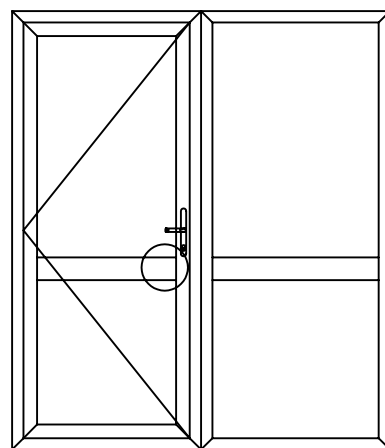
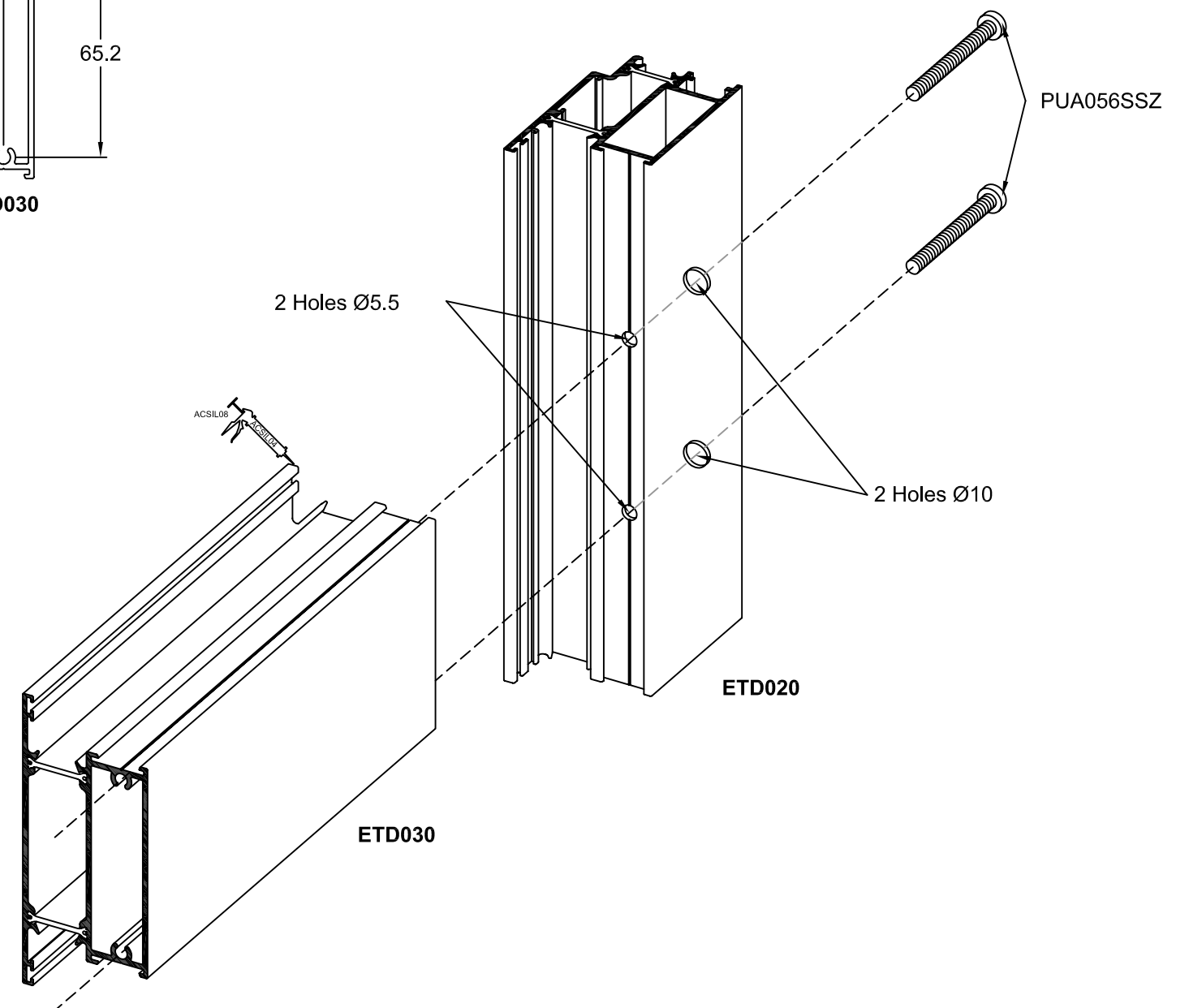
2b

Open In - Middle / Deep Rail Leaf Stile

2b



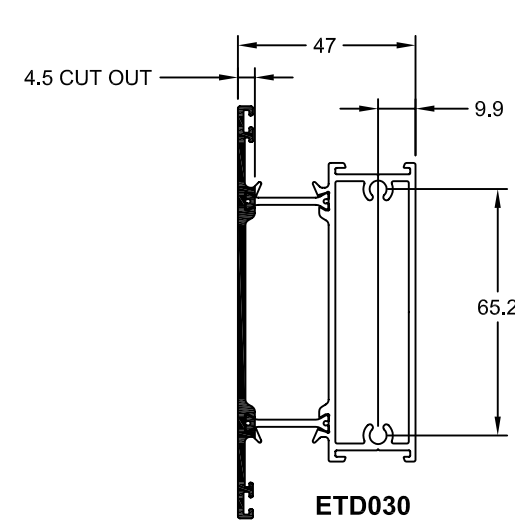
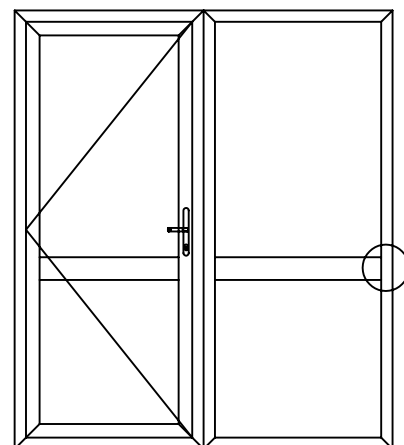
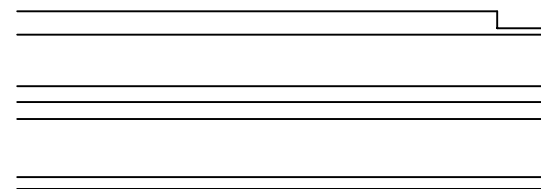
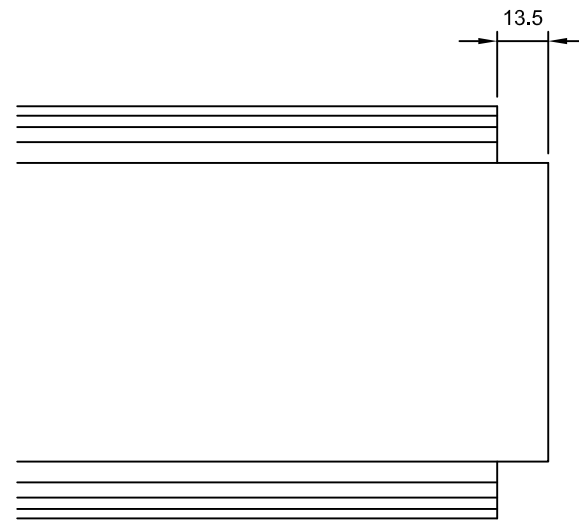
To Ensure Accuracy
Use recommended
Drill Jig - ACET923



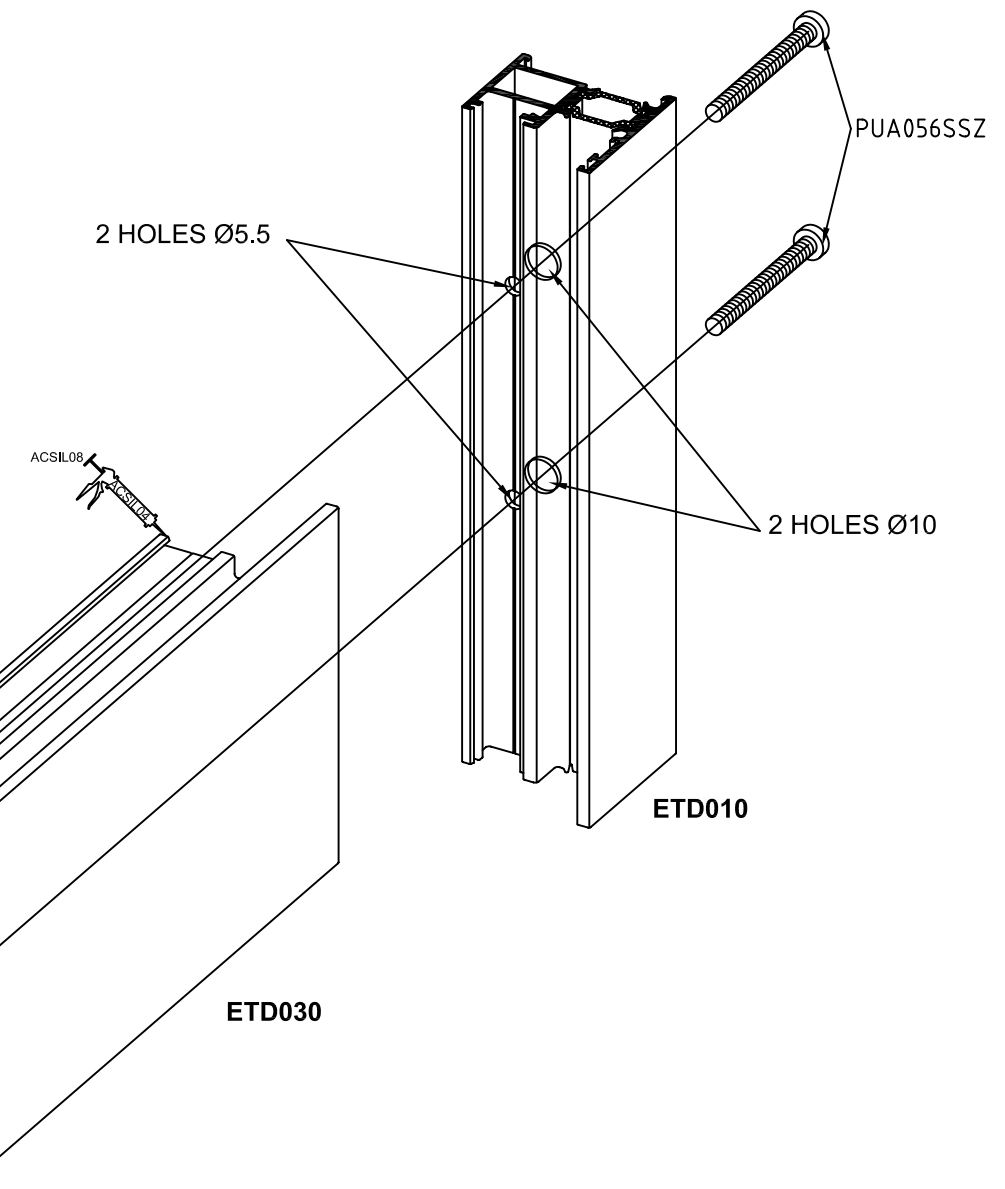
2c

Open In - Middle / Deep Rail 47mm Outerframe

2c



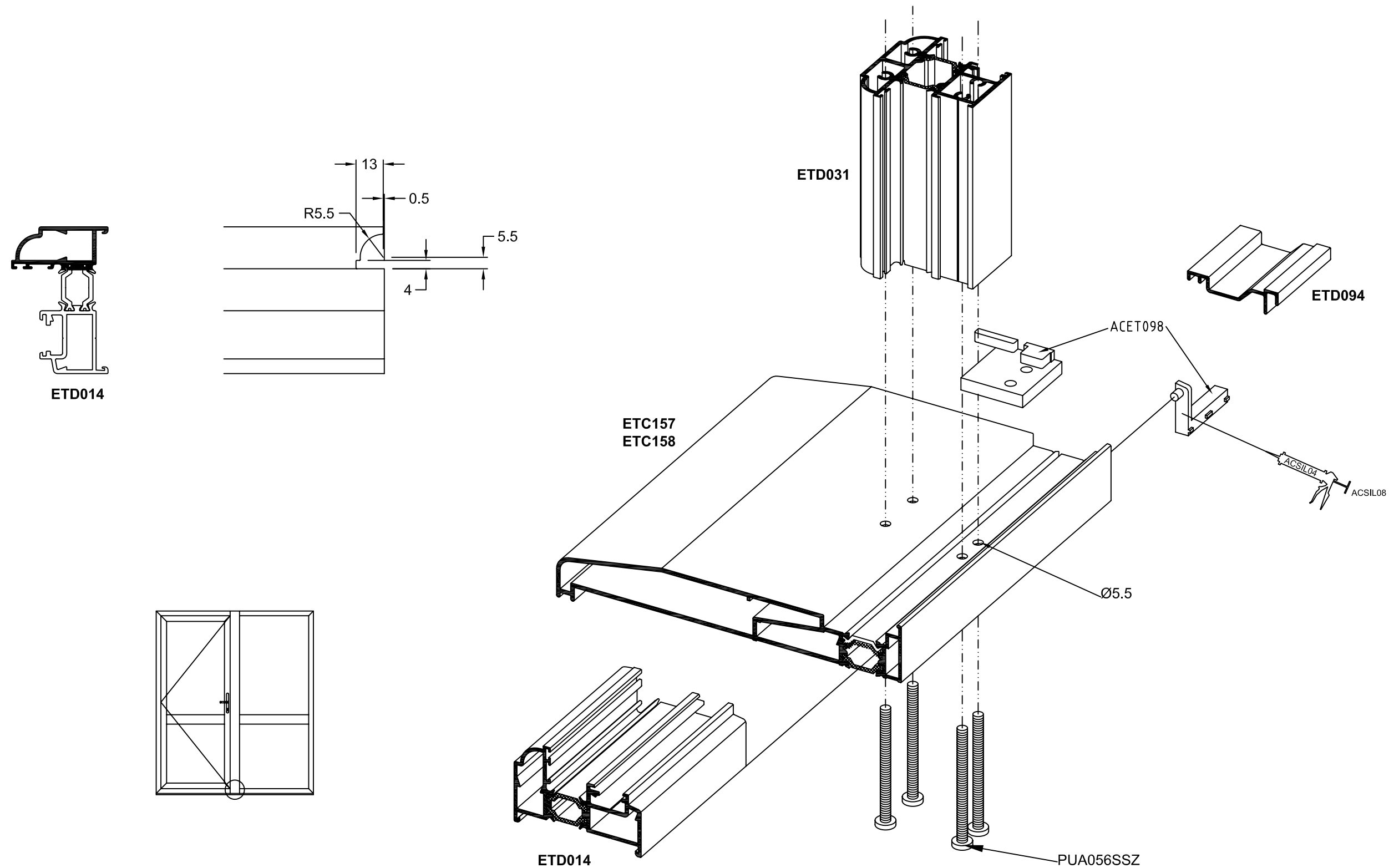
To Ensure Accuracy
Use recommended
Drill Jig - ACET916



2d

Open In - Only with Integral Mullion

2d



3a

Open In - Montage ETD014 / ETD020

3a

ASSEMBLY INSTRUCTIONS

1-Fix 2no M5x10mm grub screws to sash frame clamp plate and slide into sash eurogroove to hinge position.

2-Locate hinge and clamp in position using 2no M5x10mm machine screws.

3-Fix sash to outer frame using clamp plates and fit M5 x 15mm c/sk machine screws and adjust for correct operation.

4-If the sash requires adjustment after the door has been glazed this can be achieved by loosening the clamp plate machine screws, adjusting the sash height and tightening the clamp plates.

Notes:

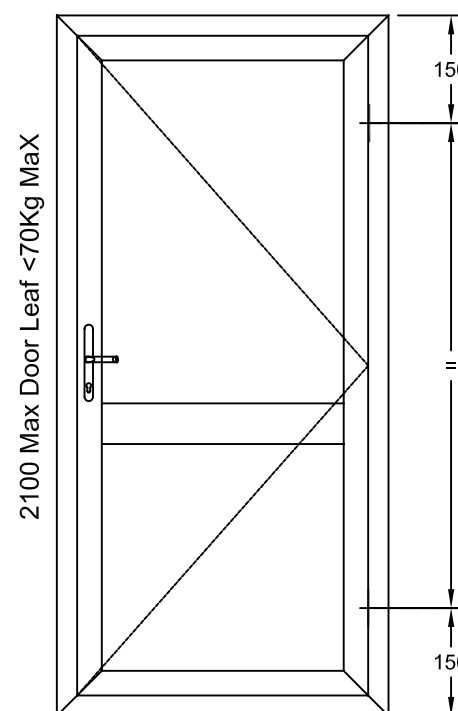
1-Maximum Door Weight-Polyamide Profile

Domestic Houses-70Kg based on 2no. hinges(1 top, 1 bottom).
with 3no. hinges(2 top, 1 bottom) 10Kg can be added to the above weight limits.

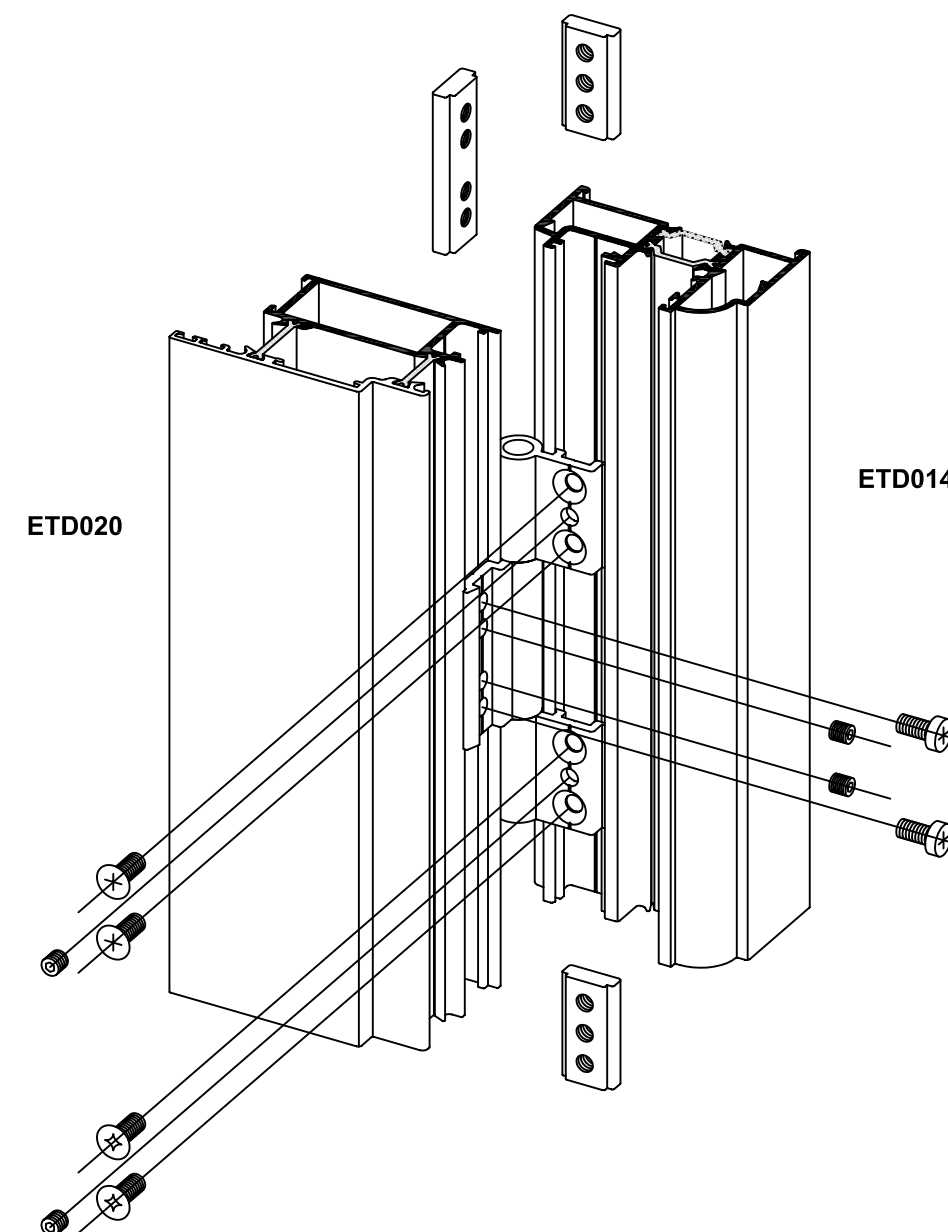
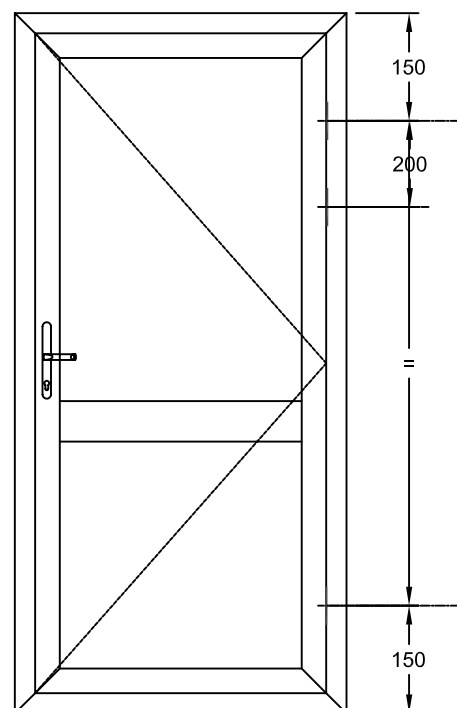
2-Door Leaf Limits

Double door 1800 mm max.

UP TO 900 DOOR LEAF



2100-2400 Max Door Leaf > 70Kg up to 80Kg Max.

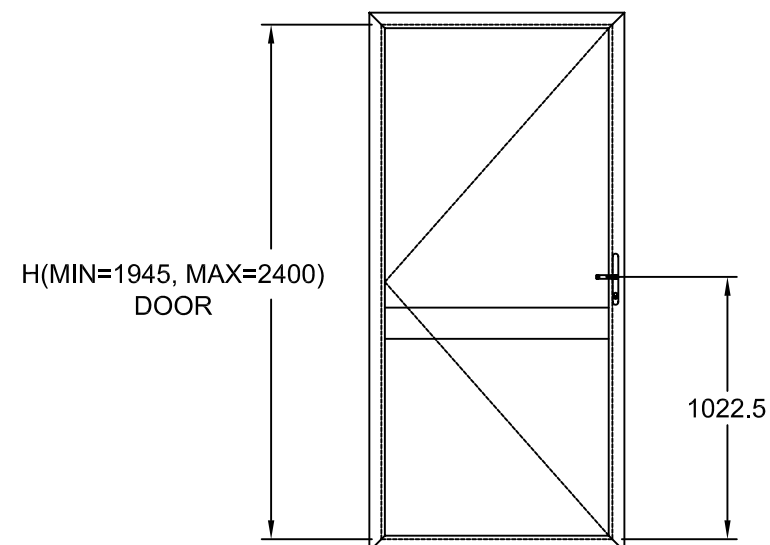


4a

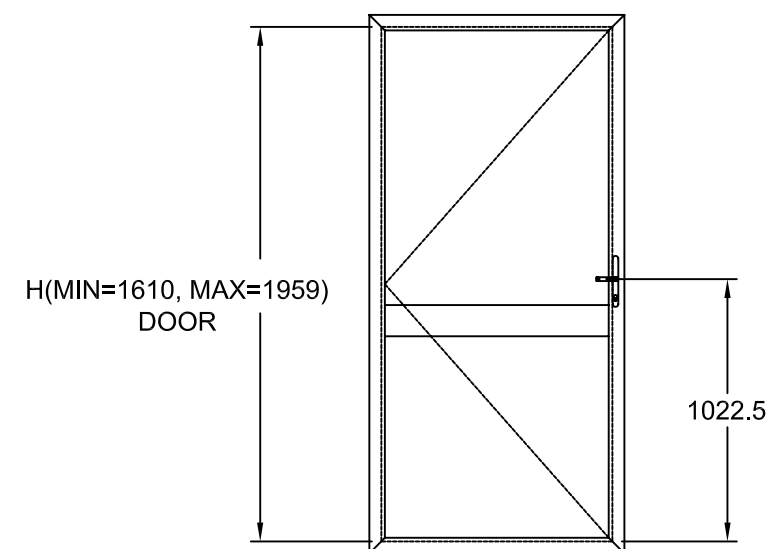
Open In - Min / Max Door Height

4a

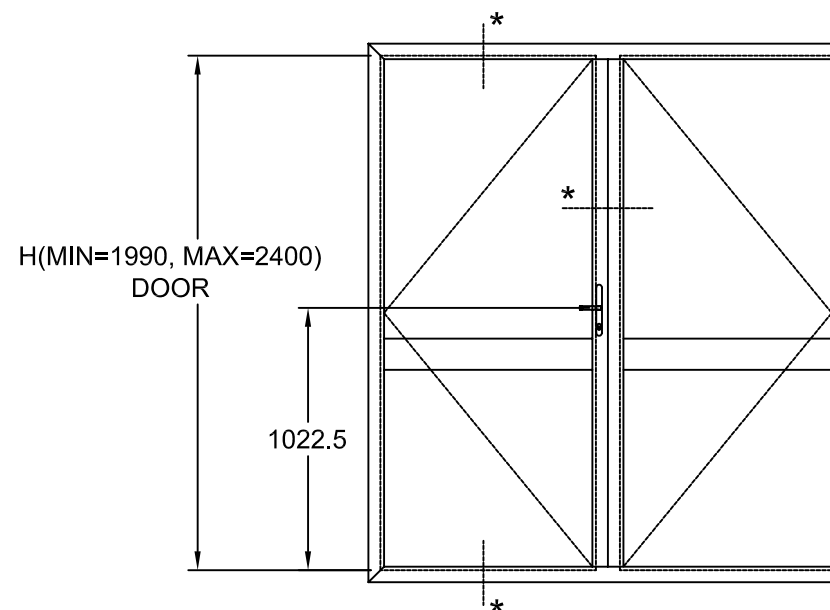
SINGLE DOOR
NORMAL LOCK-ACET085 & ACET086



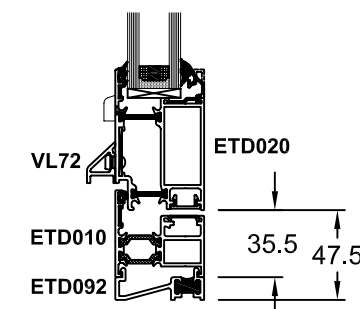
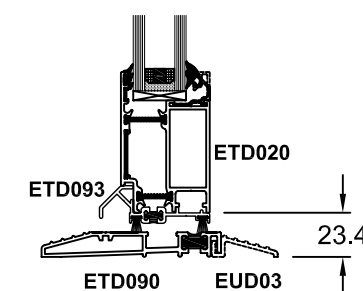
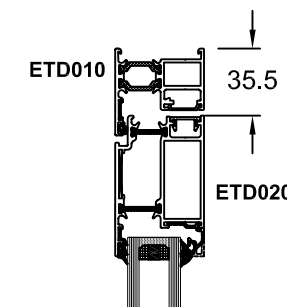
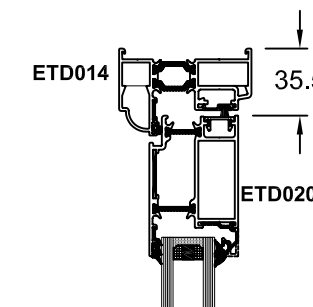
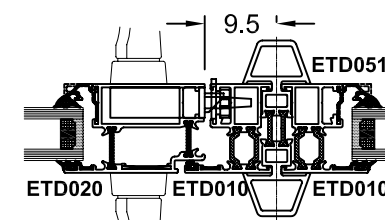
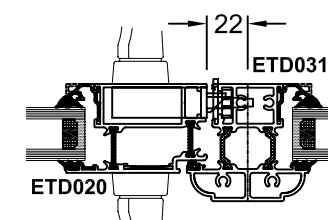
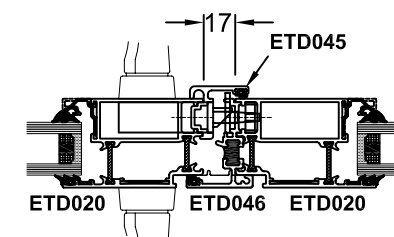
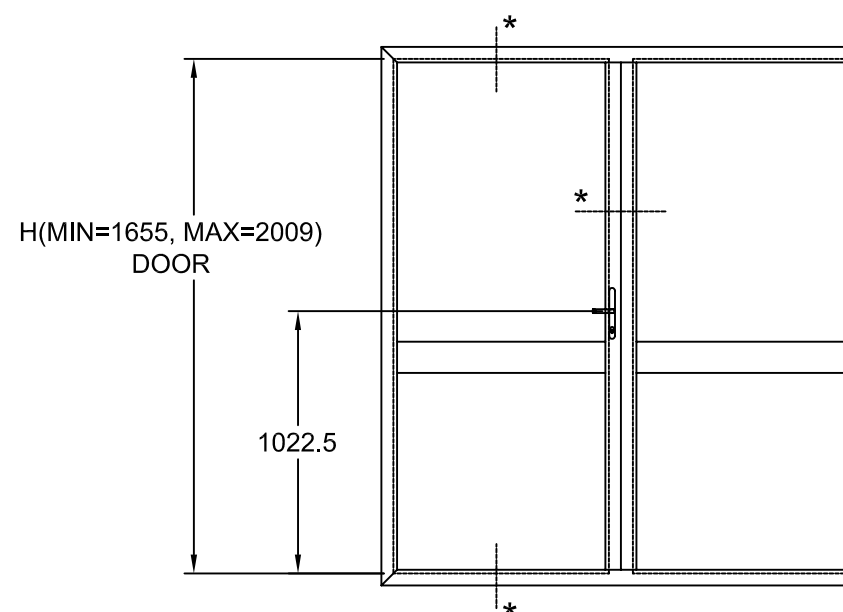
SMALL LOCK-ACET087 & ACET088



DOUBLE DOOR
NORMAL LOCK-ACET140 & ACET141



SMALL LOCK-ACET142 & ACET143

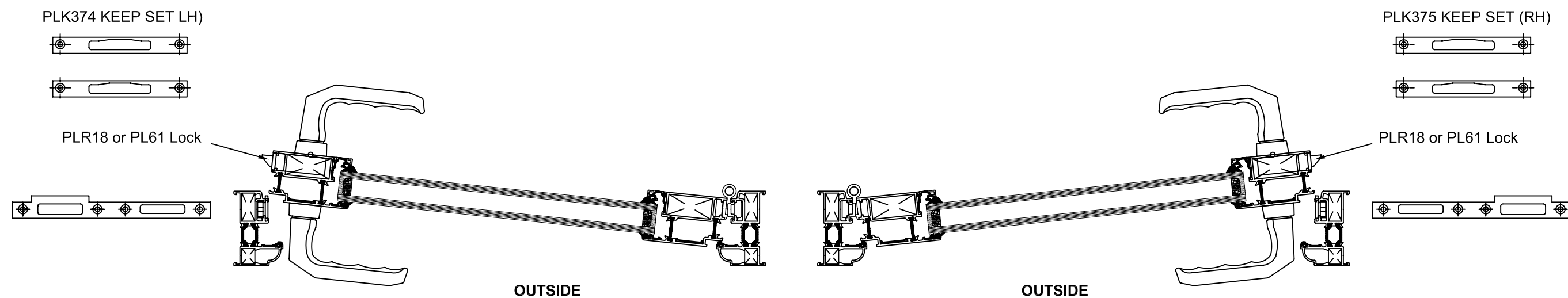
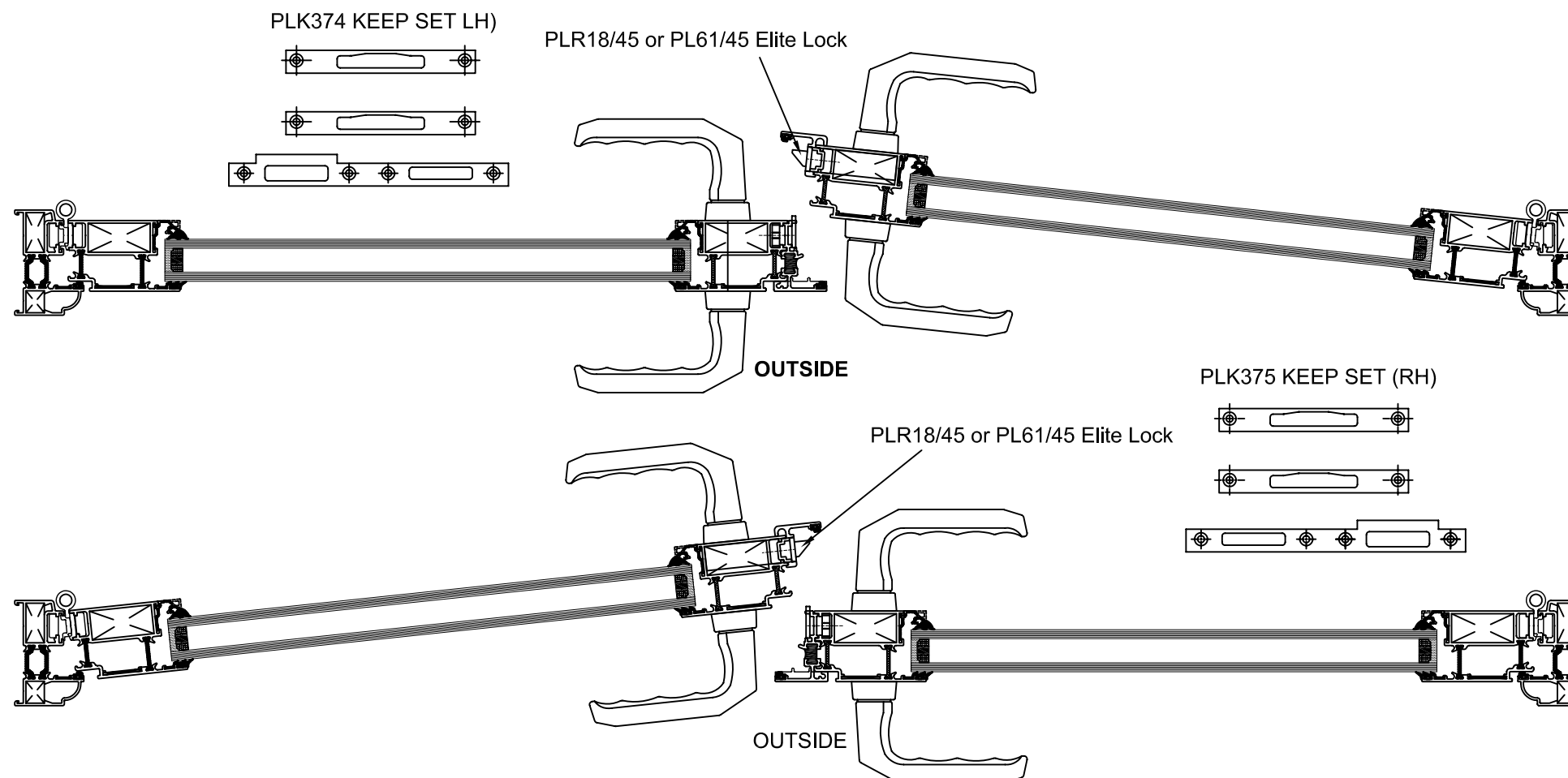


Additions *

4b

Open In - Configuration

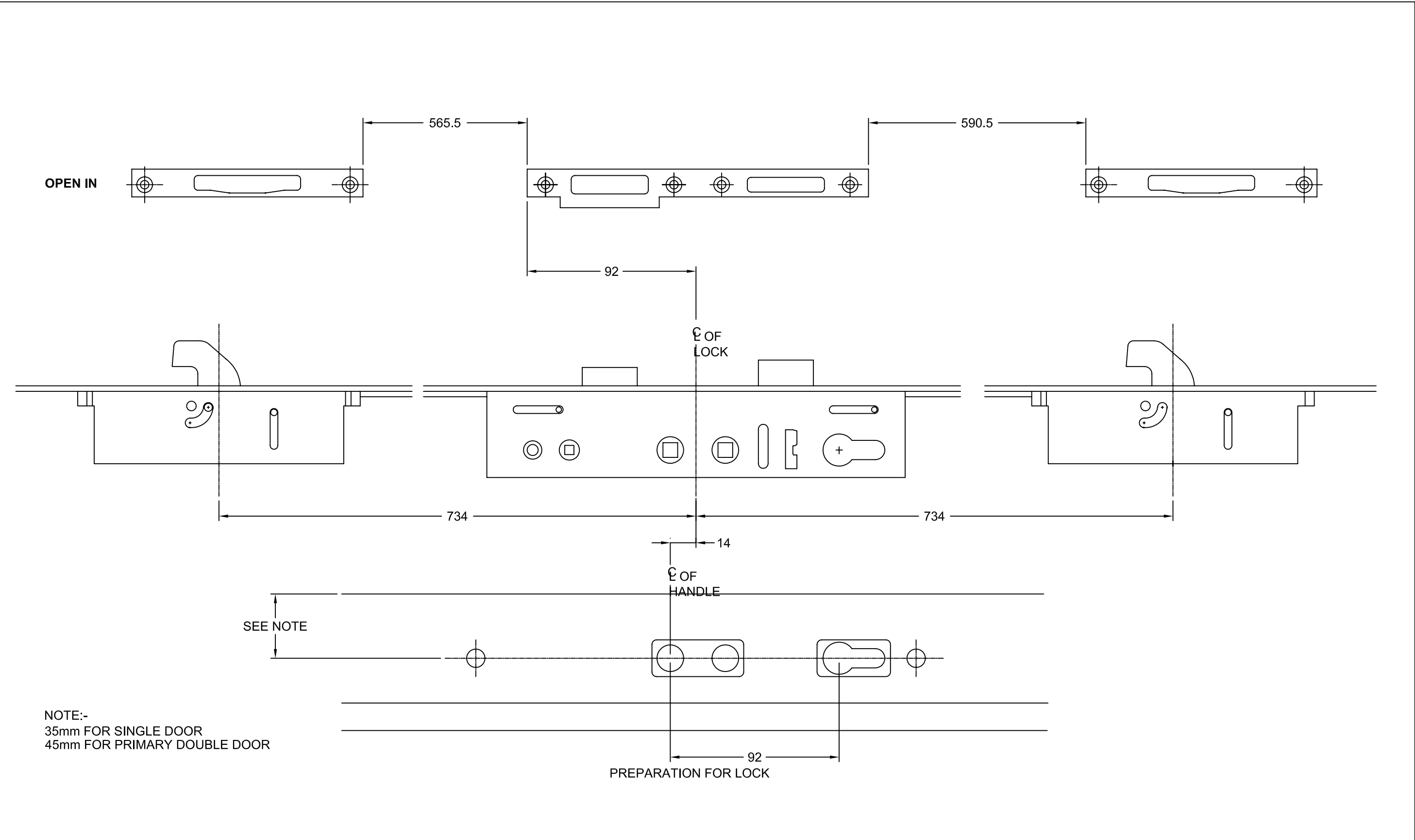
4b



4c

Open In - Normal Lock

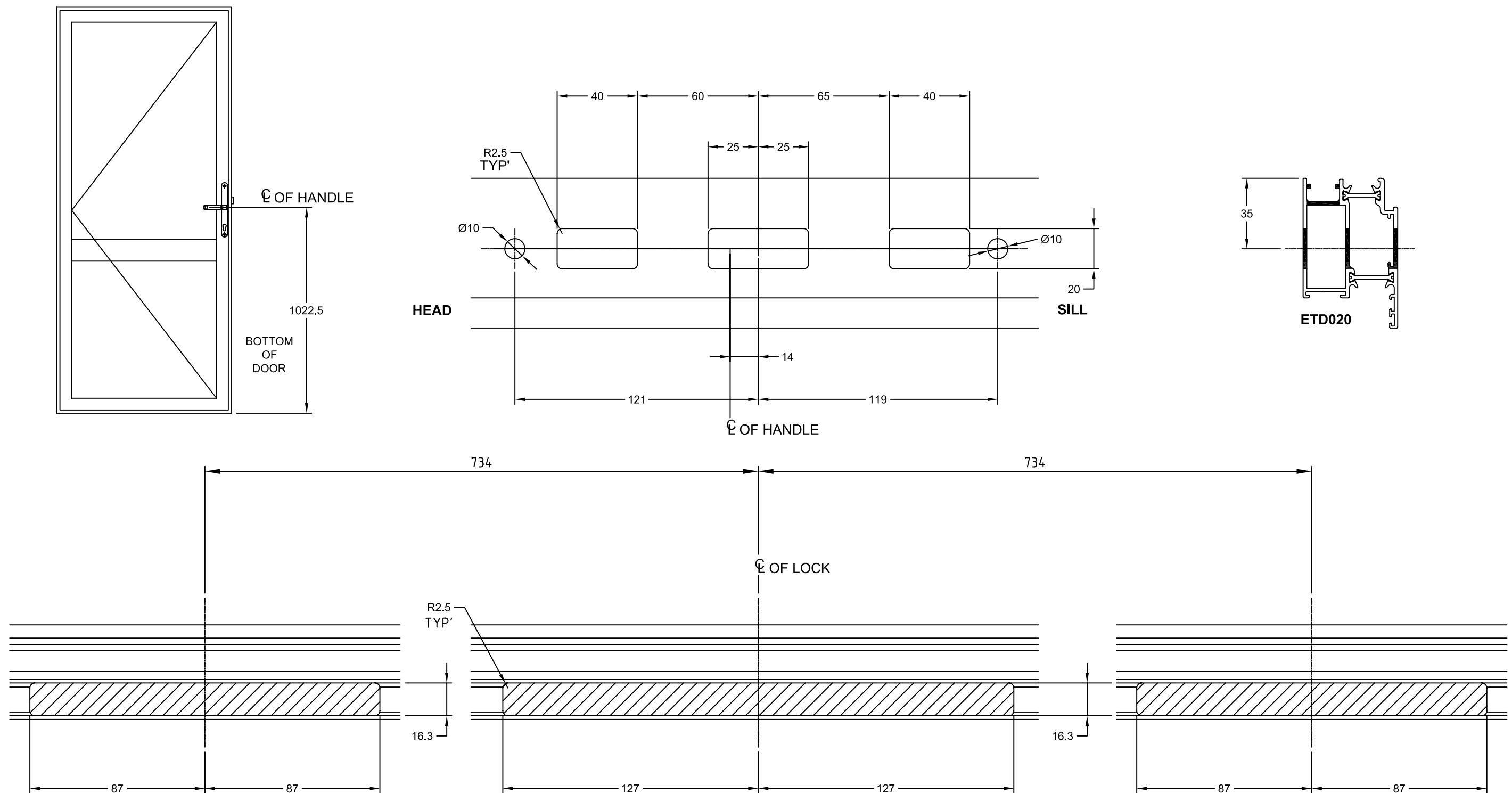
4c



4d

Open In - Single Door (Normal Lock) 35mm backset / Door Leaf Preparation

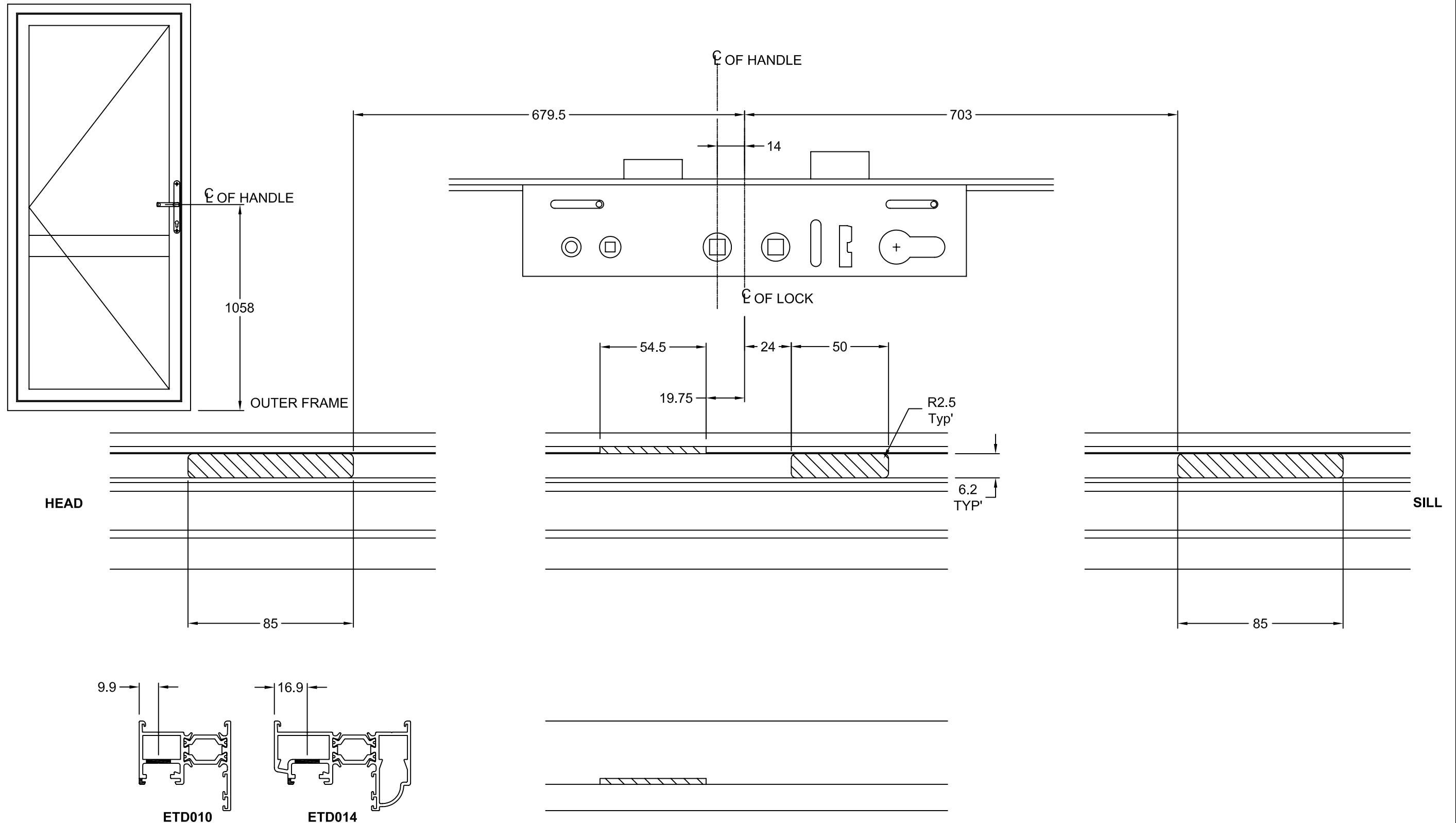
4d



4e

Open In - Single Door (Normal Lock) 35mm Backset / Outerframe Preparation

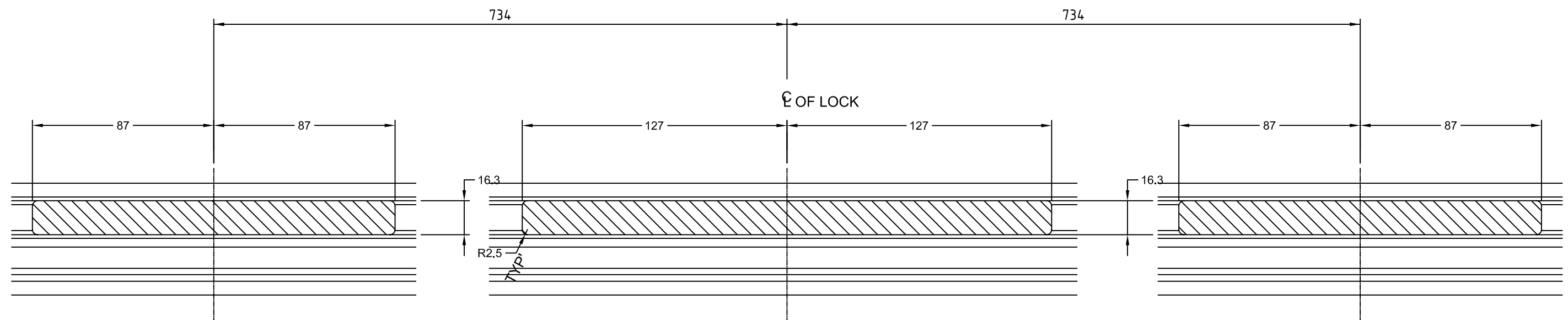
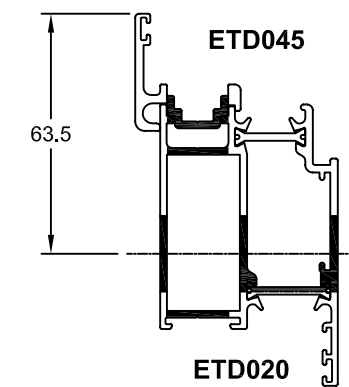
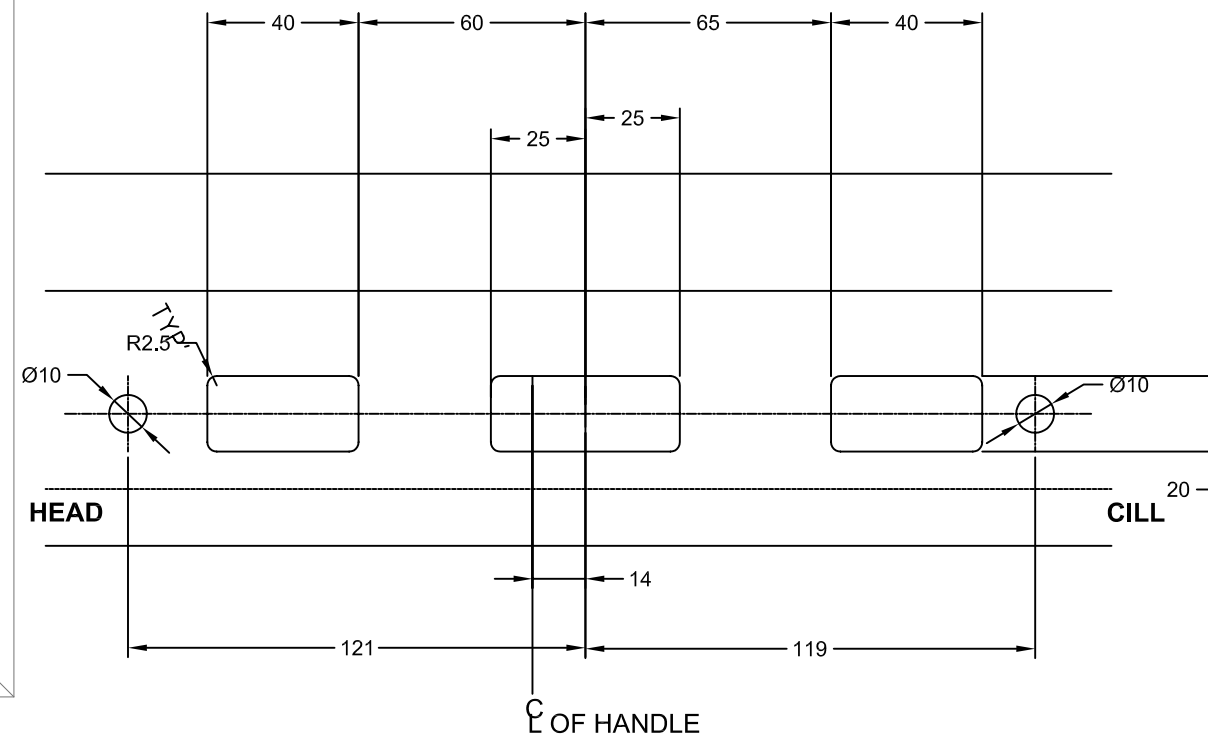
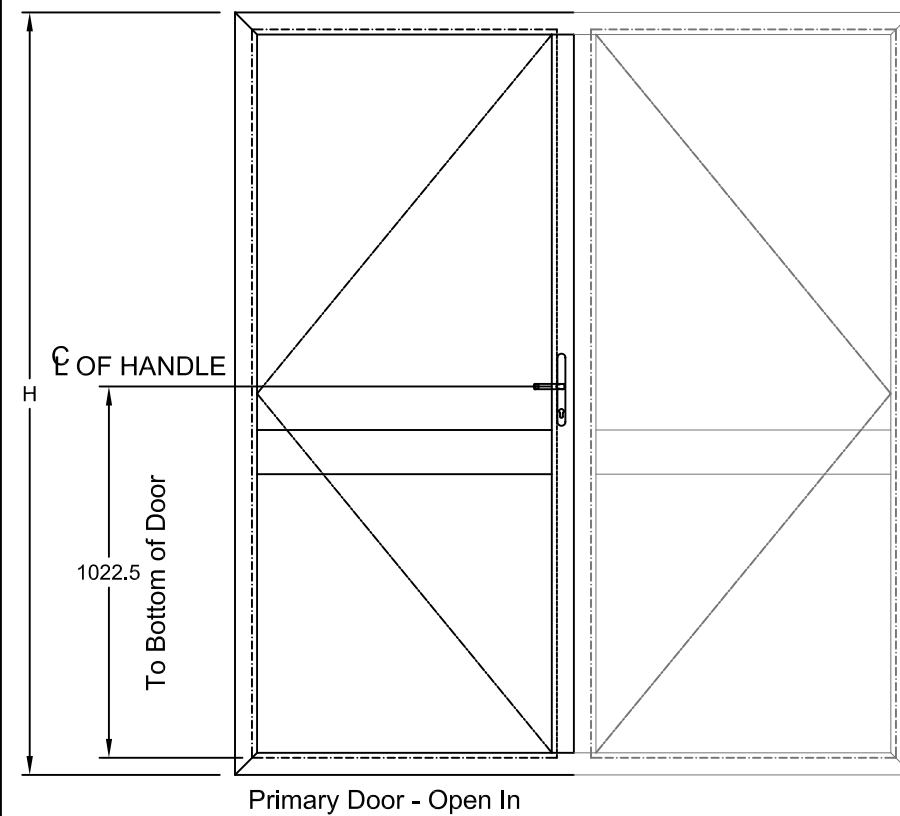
4e



4f

Open In - Double Door Primary (Normal Lock) 45mm Backset / Door Leaf Preparation

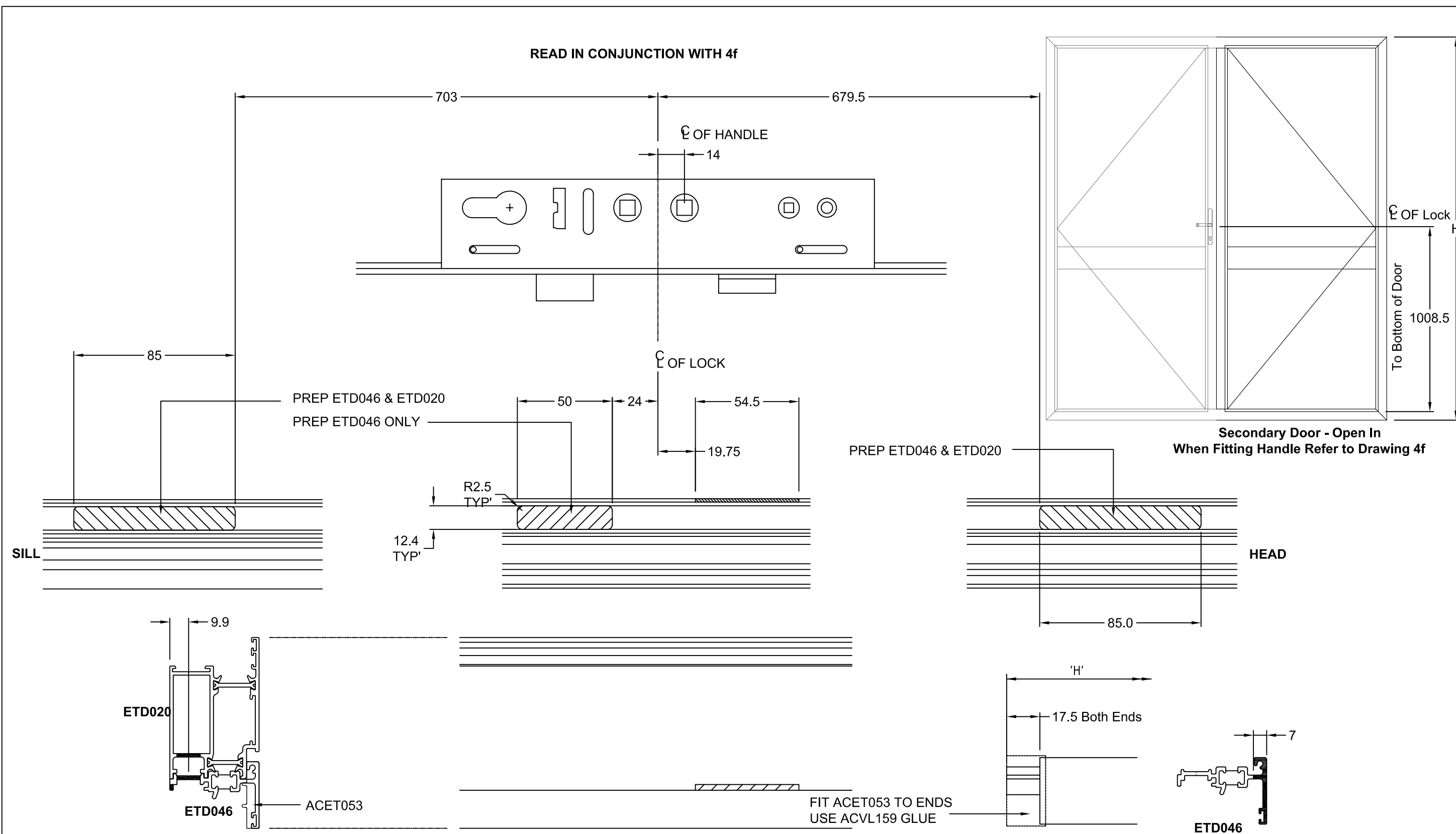
4f



4g

Open In - Double Door Secondary (Normal Lock) 45mm Backset / Door Leaf Preparation

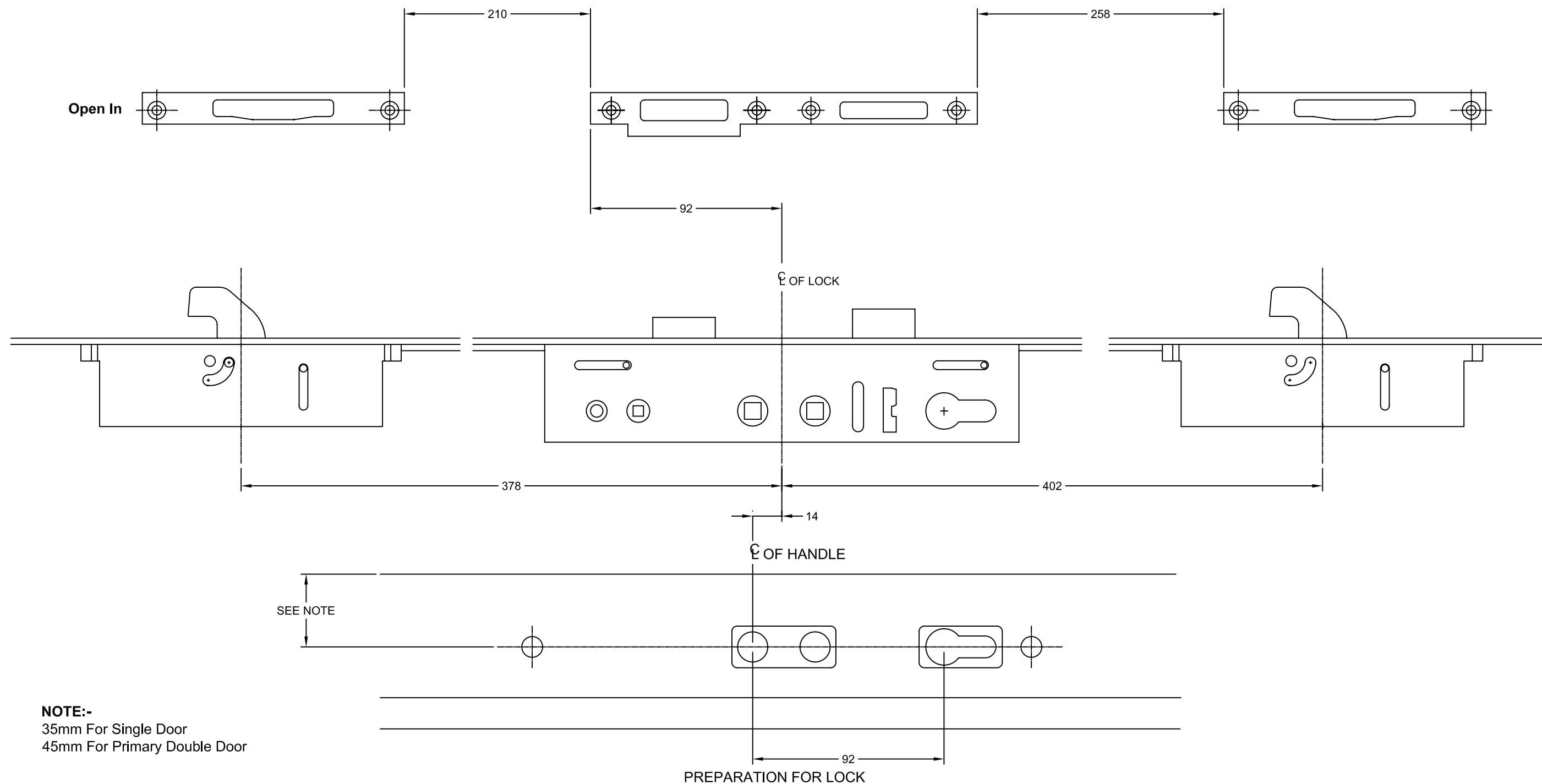
4g



4h

Open In - Short Lock

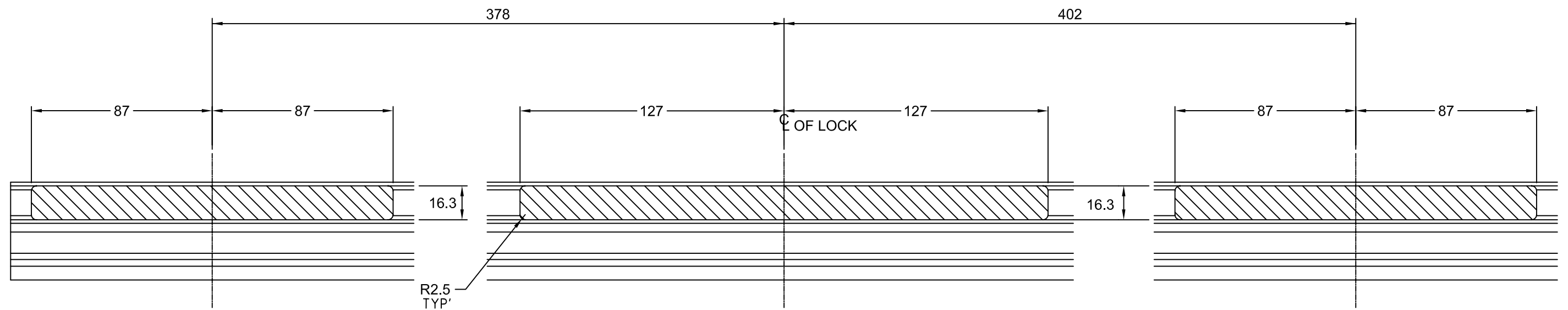
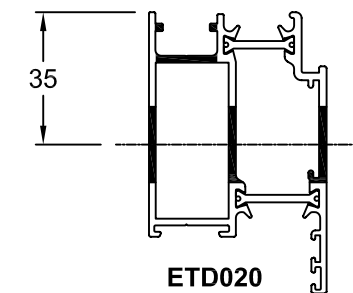
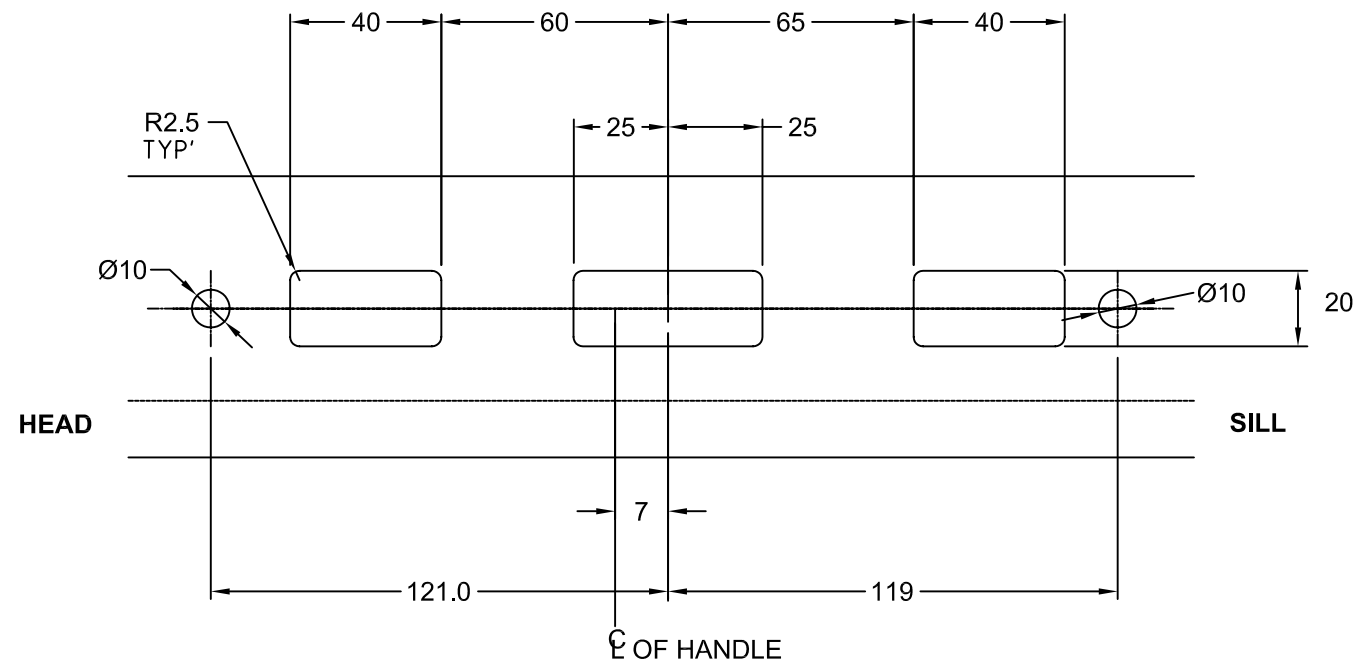
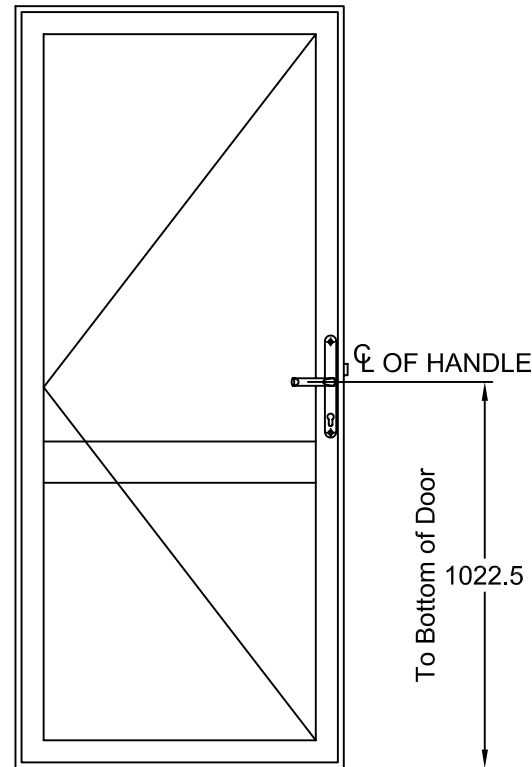
4h



4j

Open In - Single Door (Short Lock) 35mm Backset Door Leaf Preparation

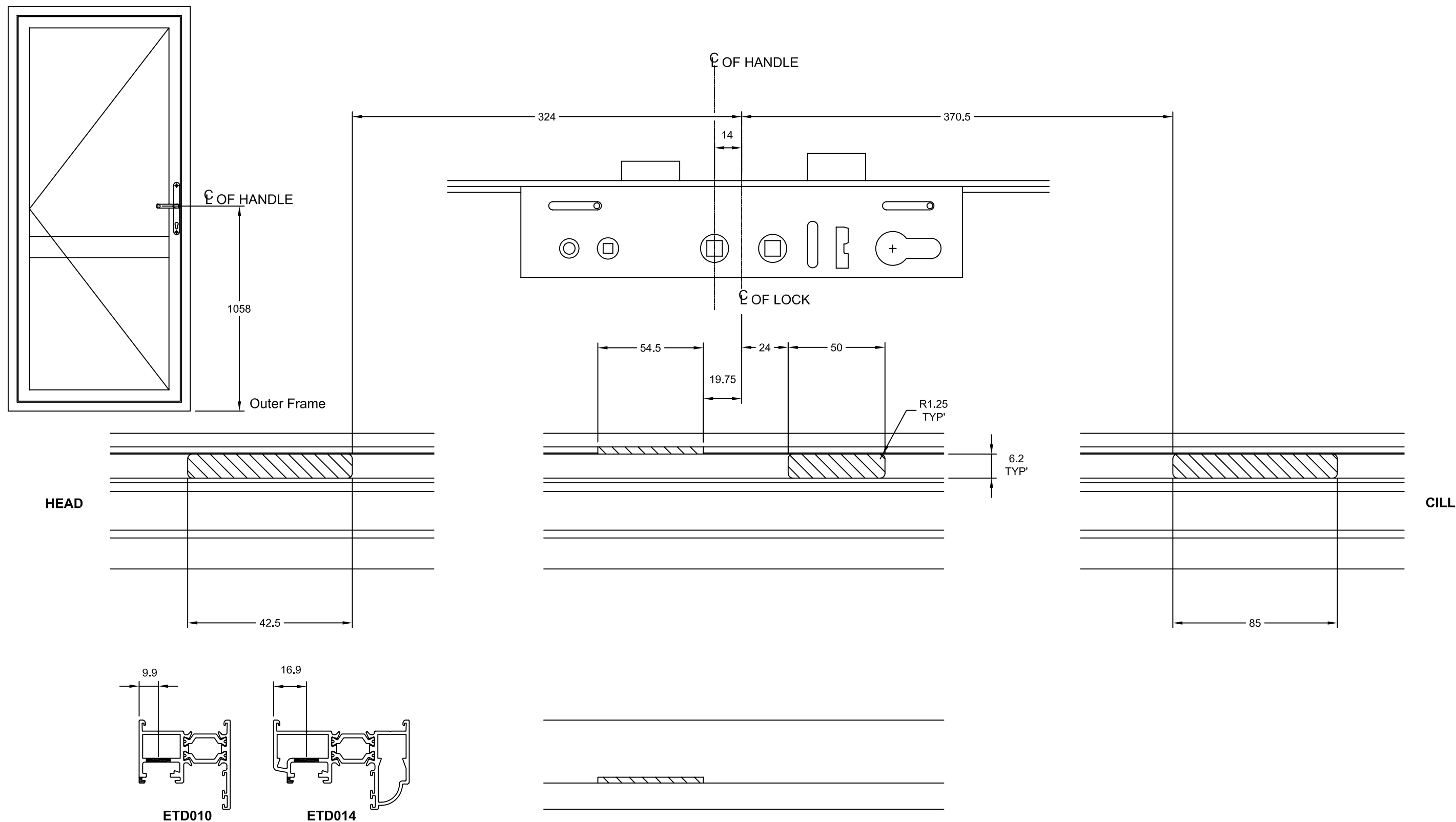
4j



4k

Open In - Single Door (Short Lock) 35mm Backset Outerframe Preparation

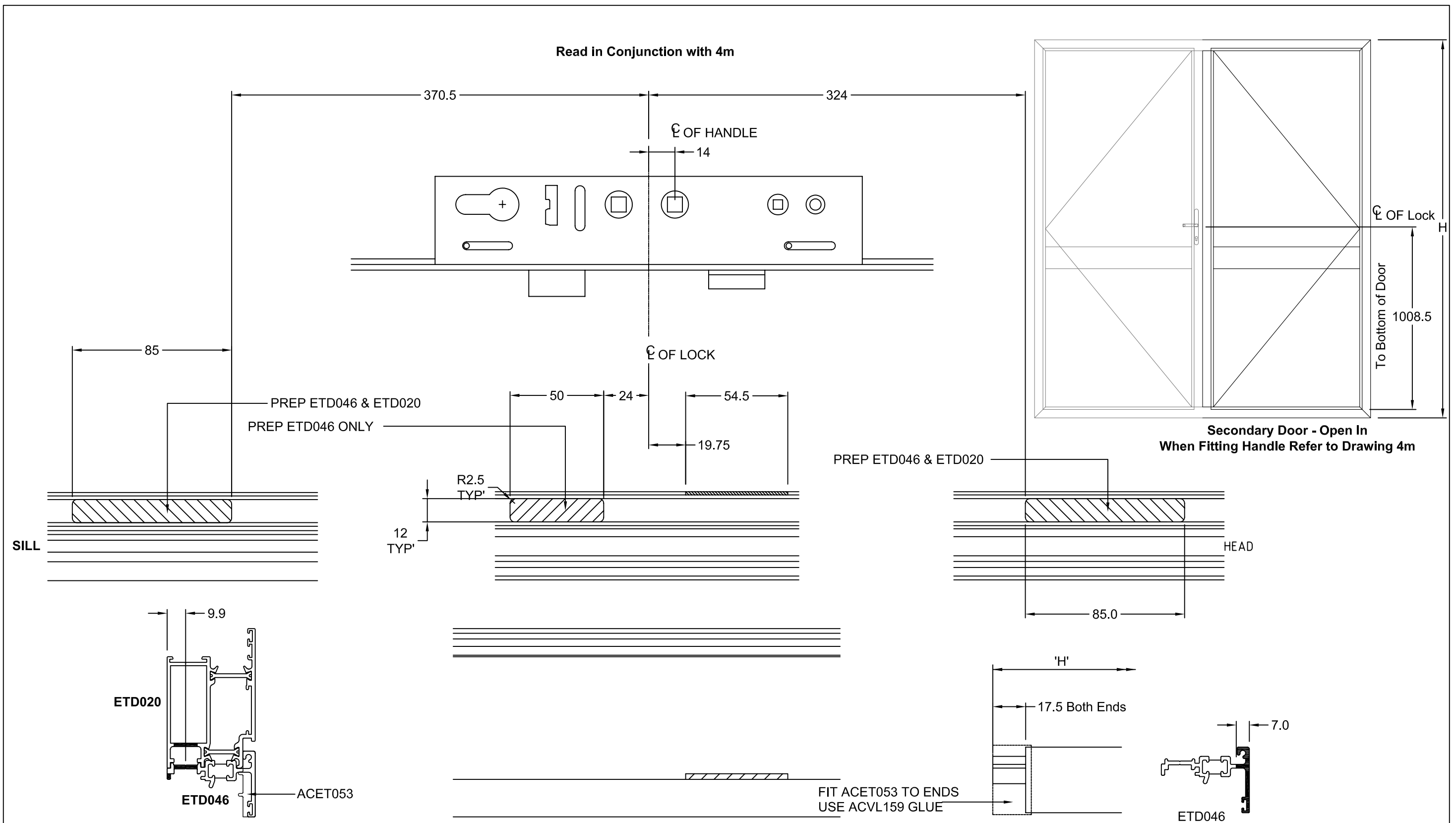
4k



4L

Open In - Double Door Secondary (Short Lock) 45mm Backset / Door Leaf Preparation

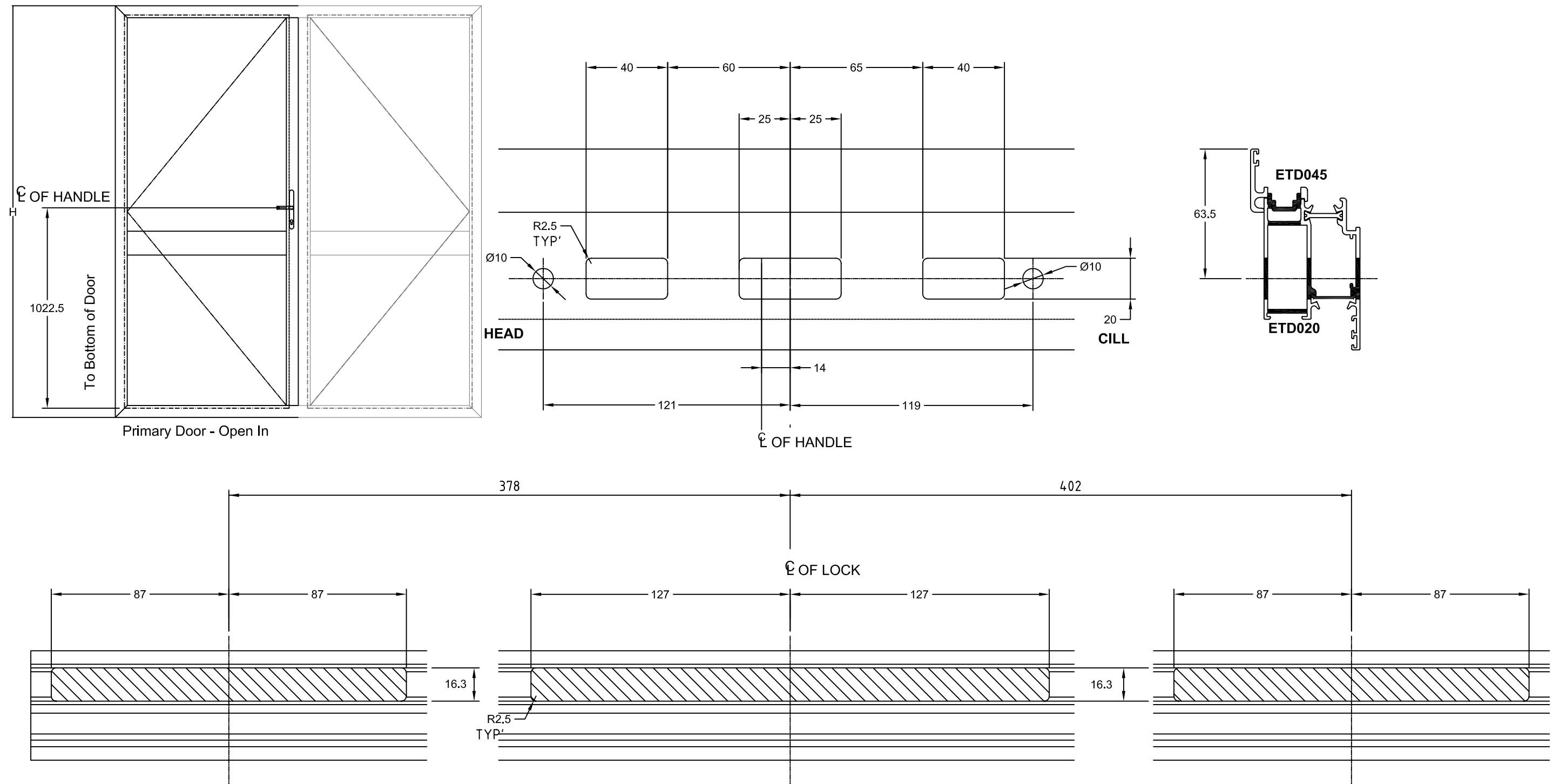
4L



4m

Open In - Double Door Primary (Short Lock) 45mm Backset / Door Leaf Preparation

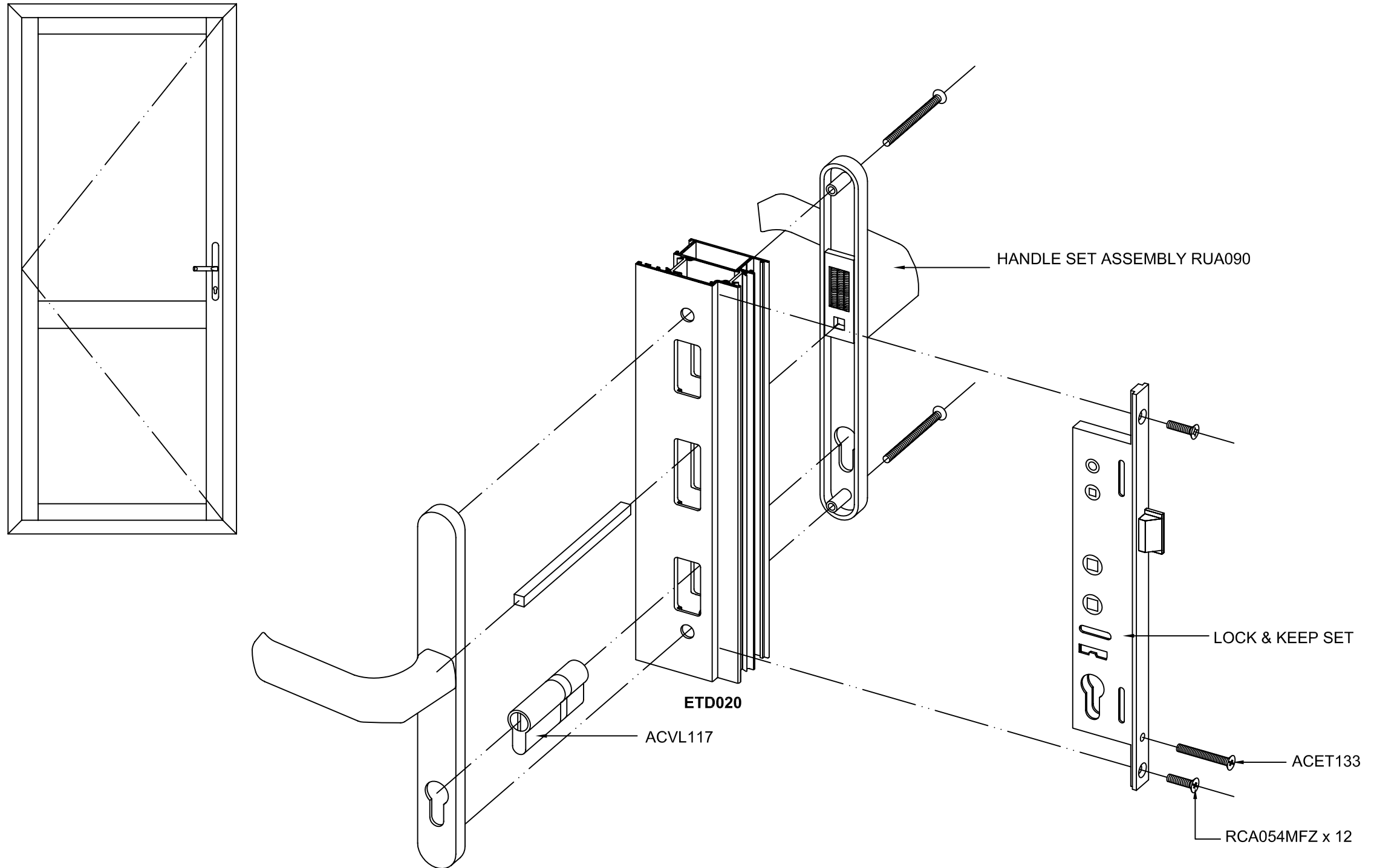
4m



4n

Open In - Lock & Keep Set

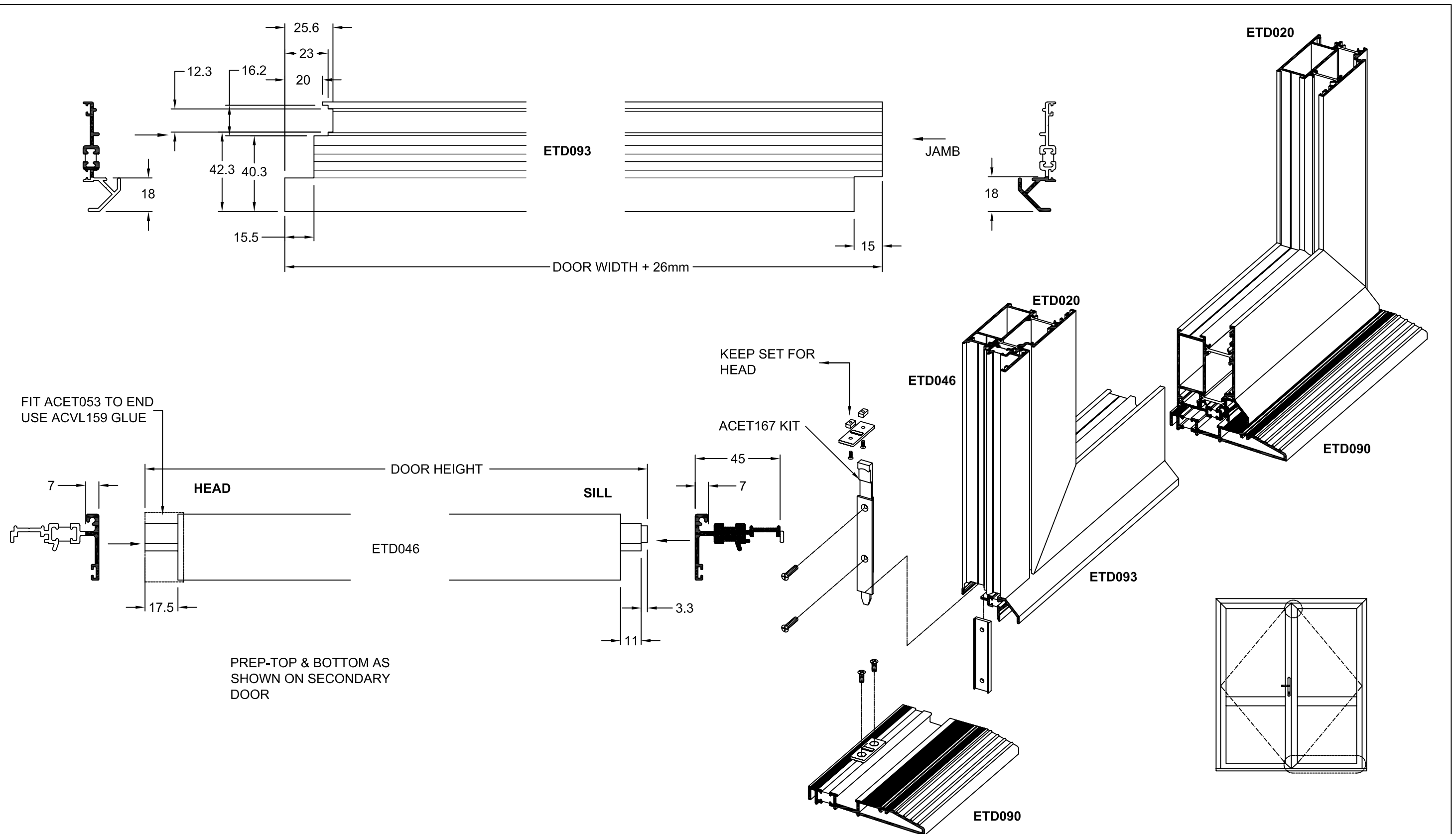
4n



4p

Open In - Double Door Secondary (Low Threshold)

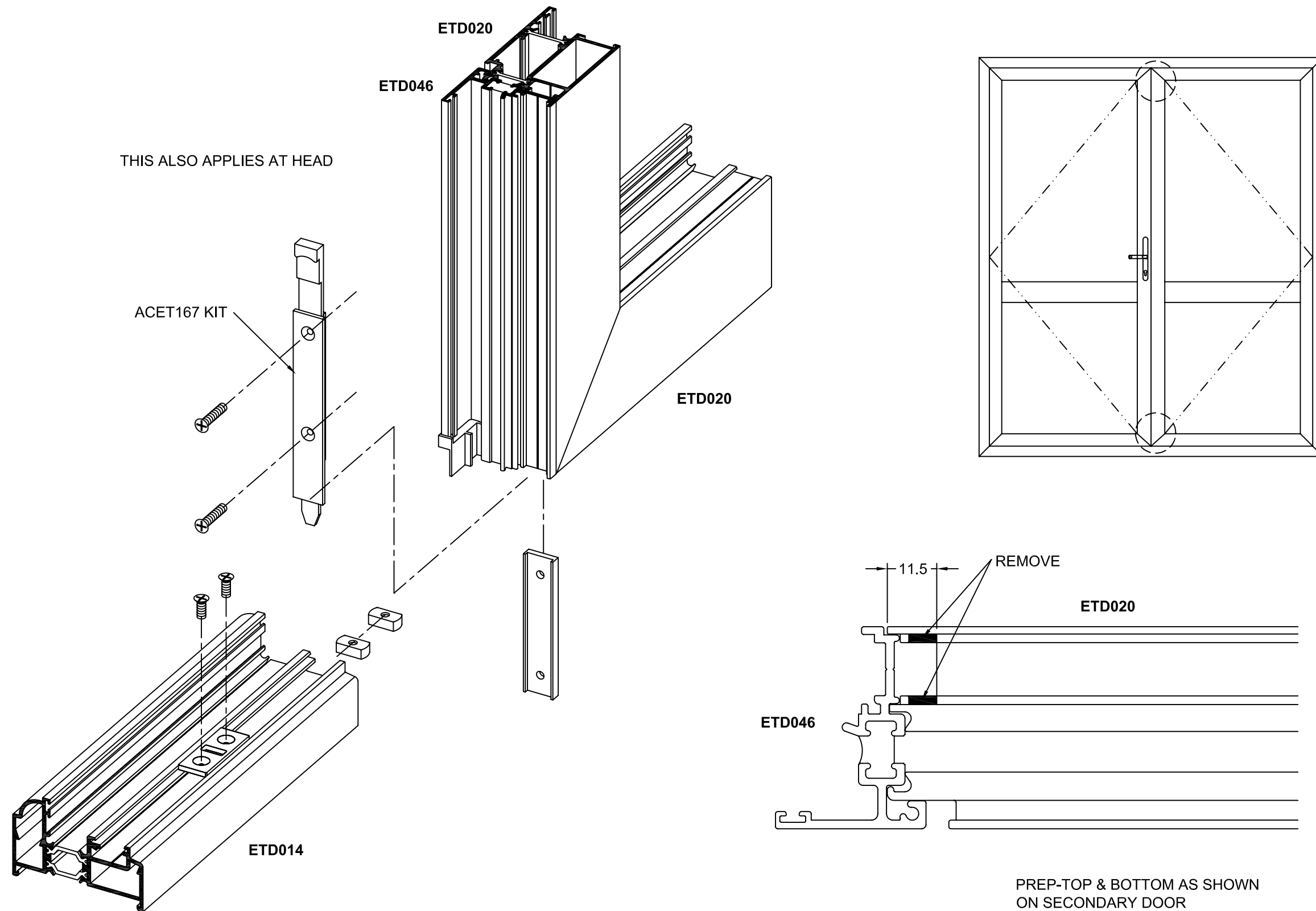
4p



4q

Open In - Double Door Prep Top & Bottom as Shown on Secondary Door

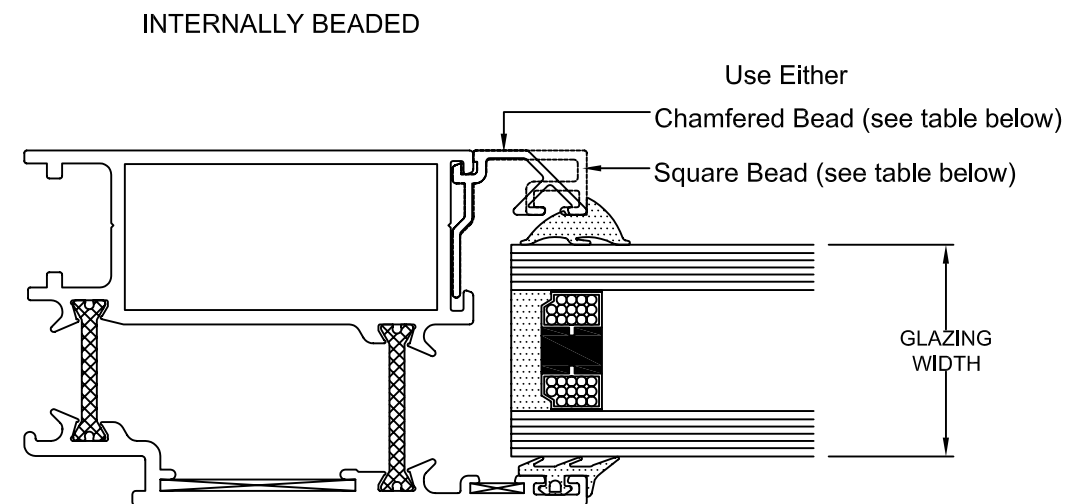
4q



5a

Open In - Glazing Preparation

5a



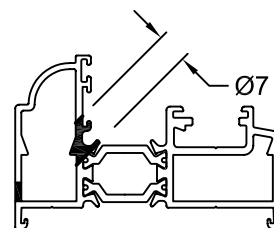
Internally Glazed					
24mm		28mm		32mm	
Beads	Gasket	Beads	Gasket	Beads	Gasket
ETC162	ACVG31 ACVG34	ETC161	ACVG31 ACVG34	ETC160	ACVG31 ACVG34
ETC163	ACVG31 ACVG34	ETC164	ACVG31 ACVG34		

6a

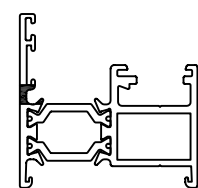
Open In - Drainage

6a

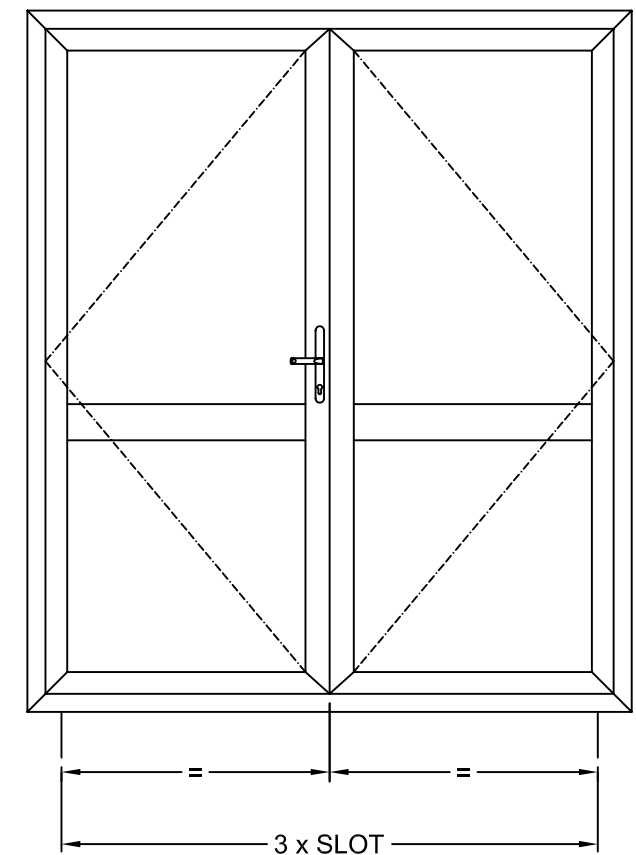
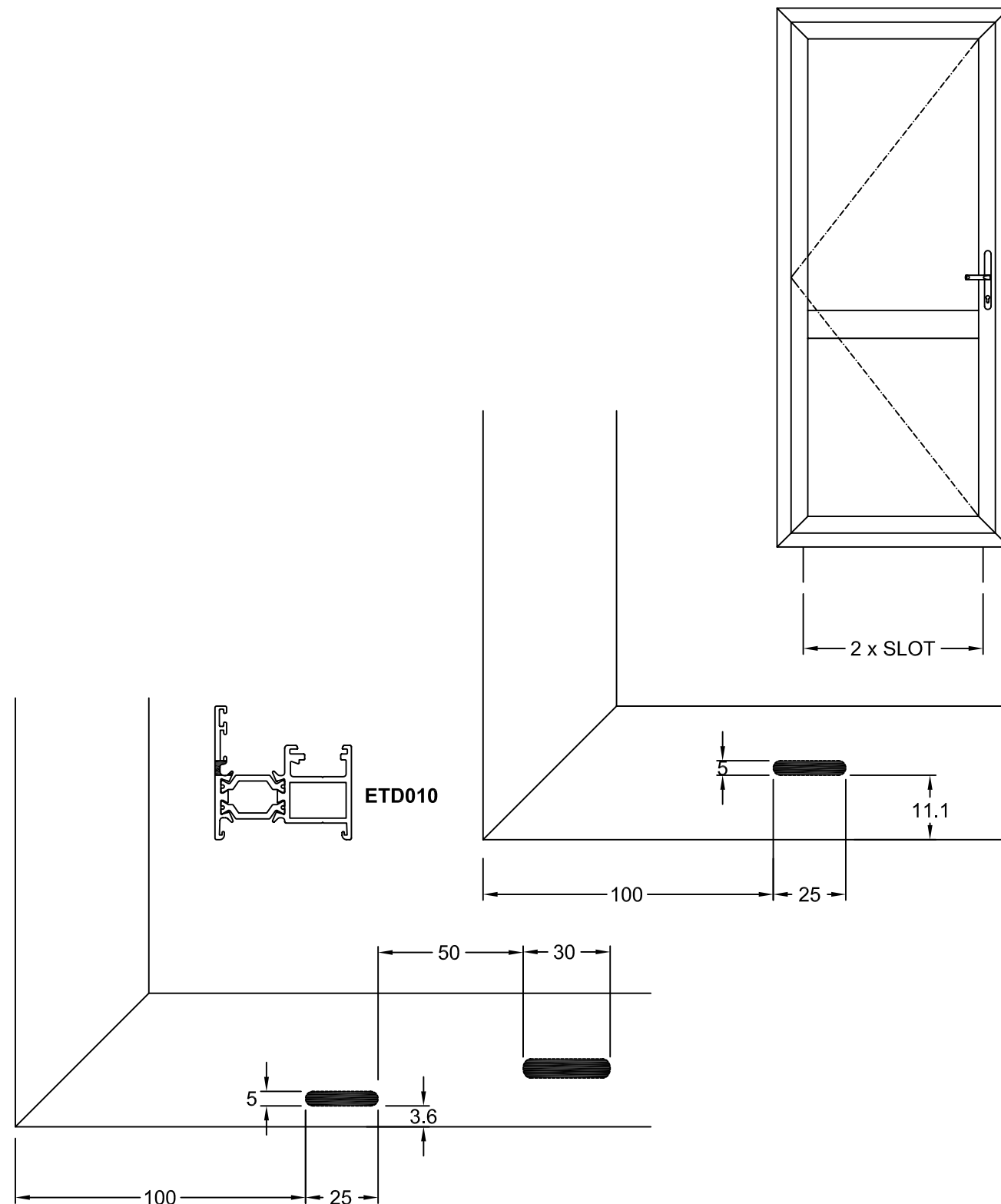
To ensure accuracy use
recommended
Drill Jig - ACET935



ETD014



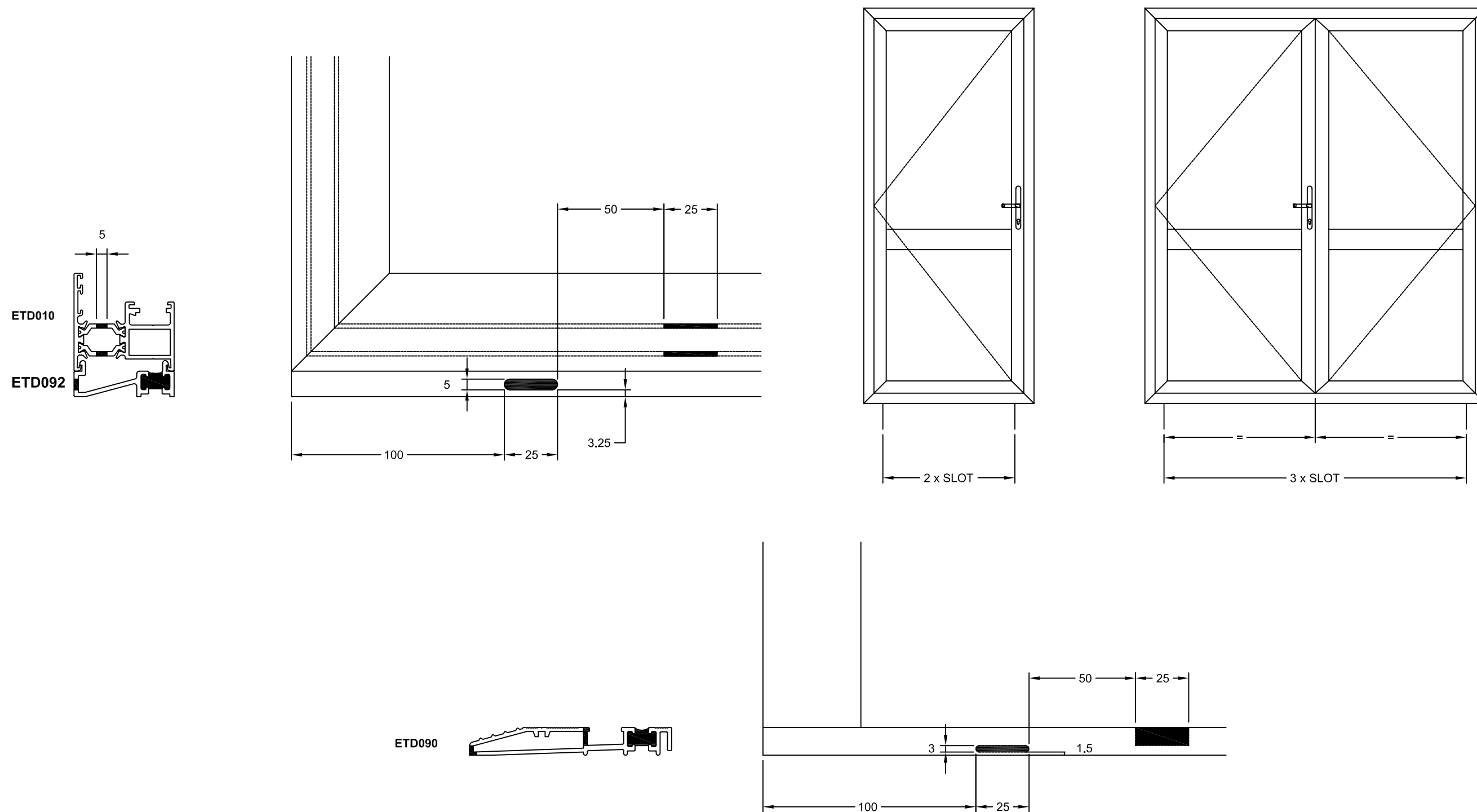
ETD010

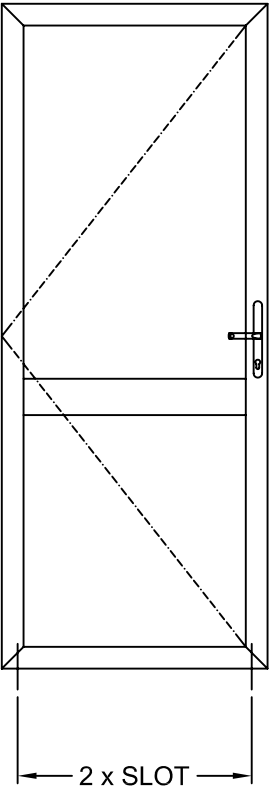
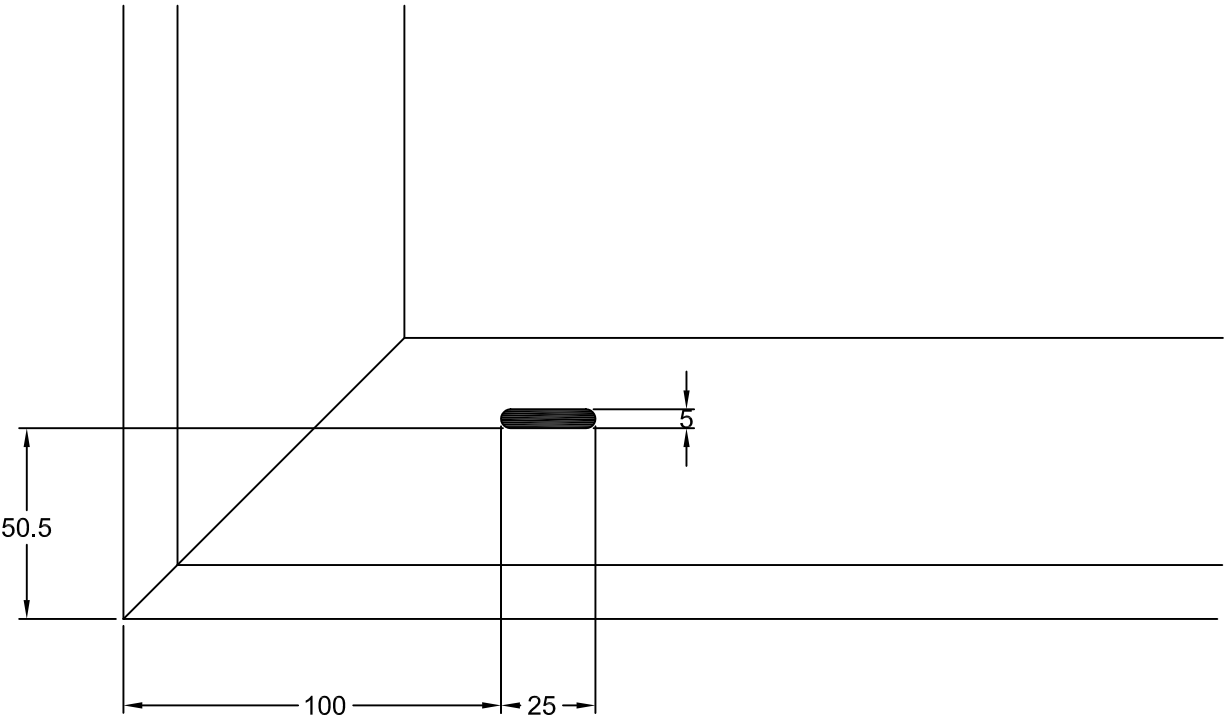
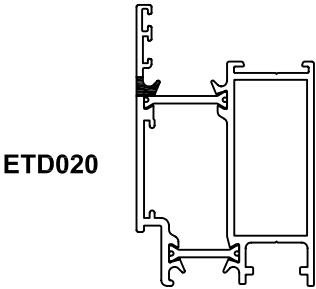
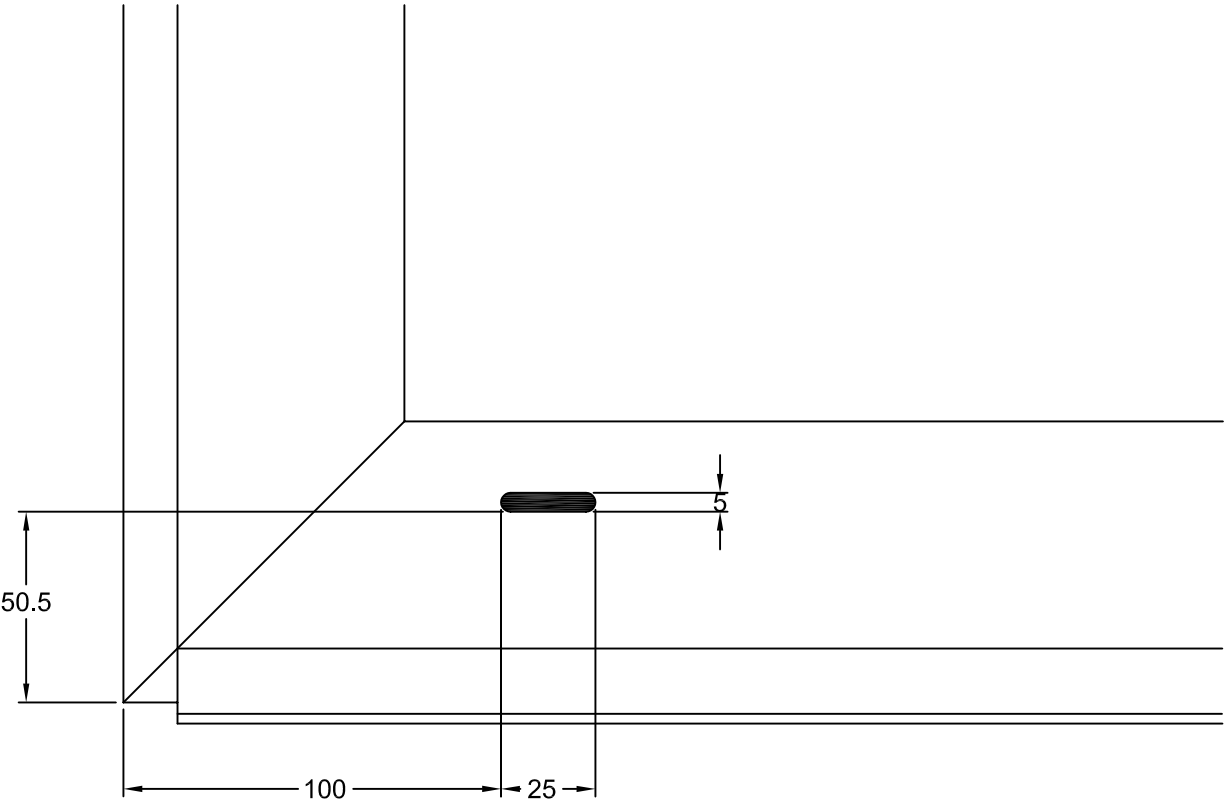
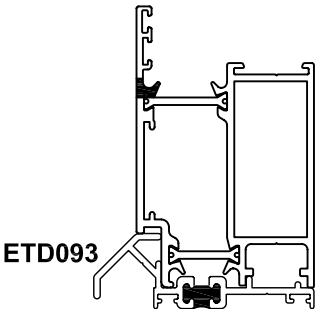


6b

Open In - Drainage

6b

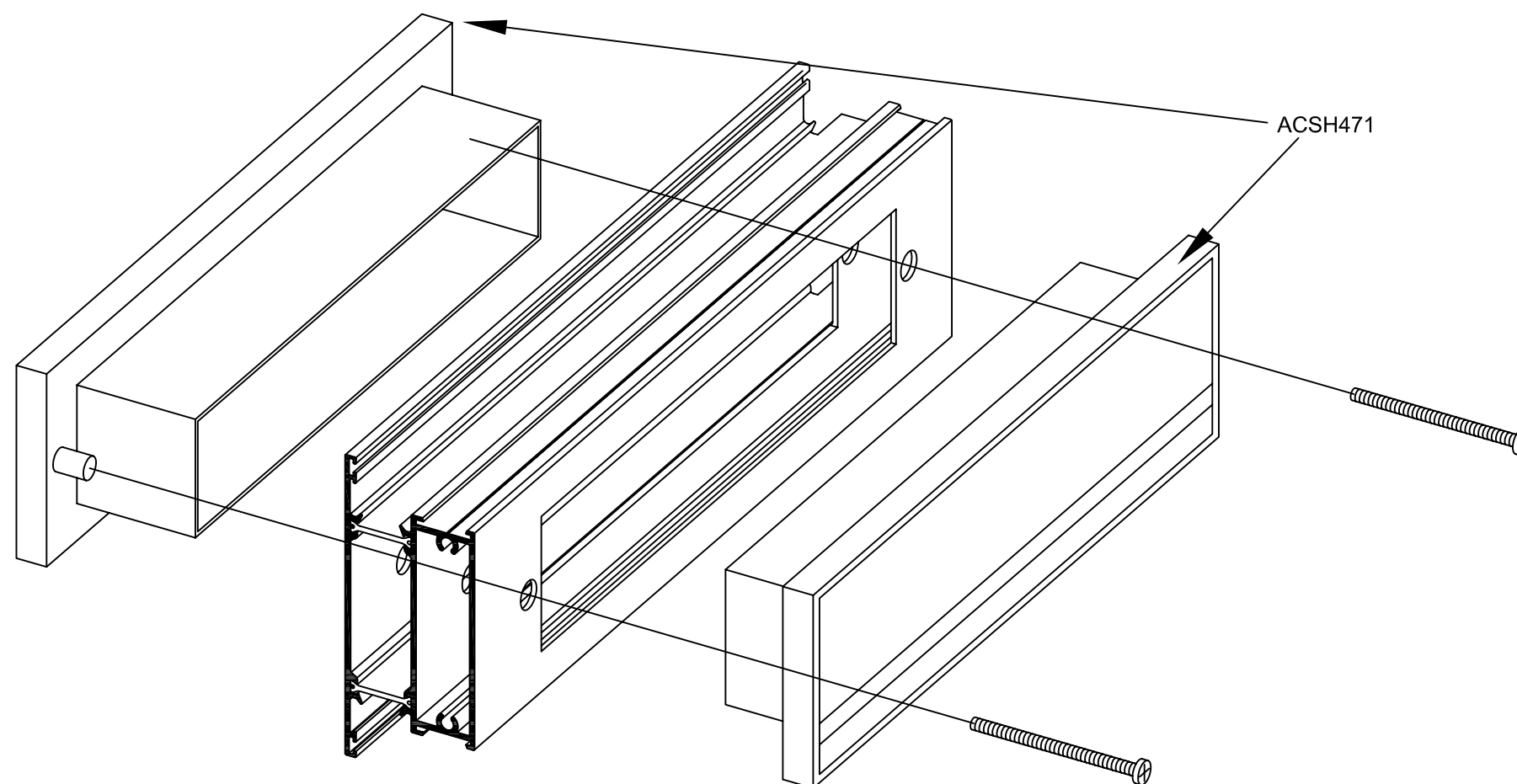
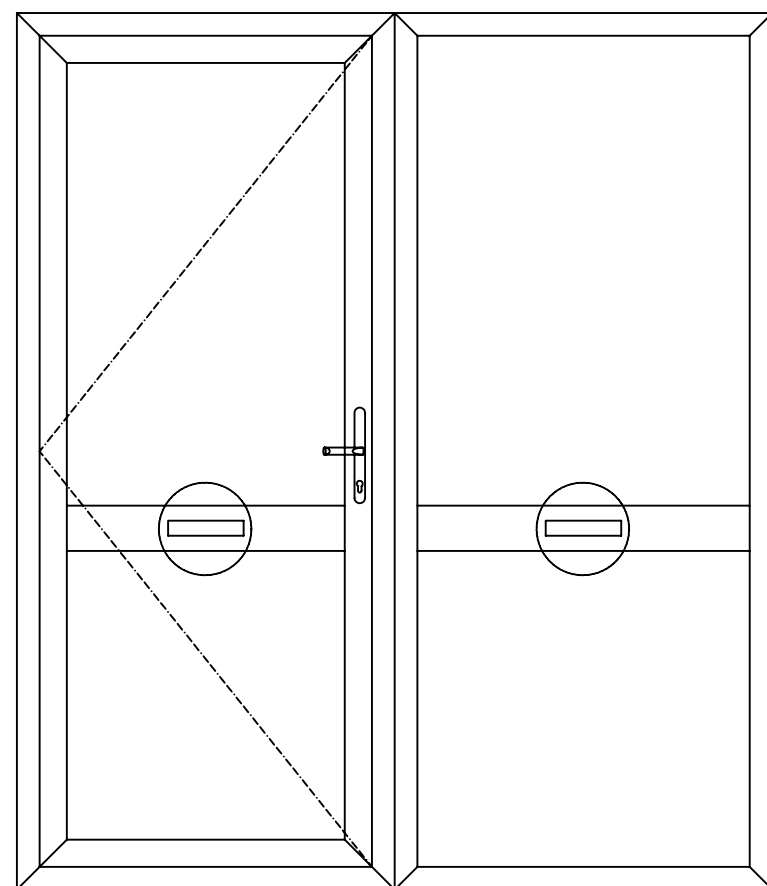
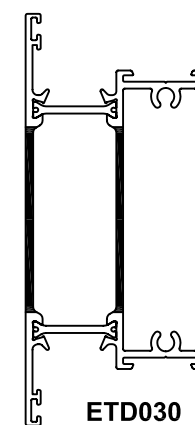
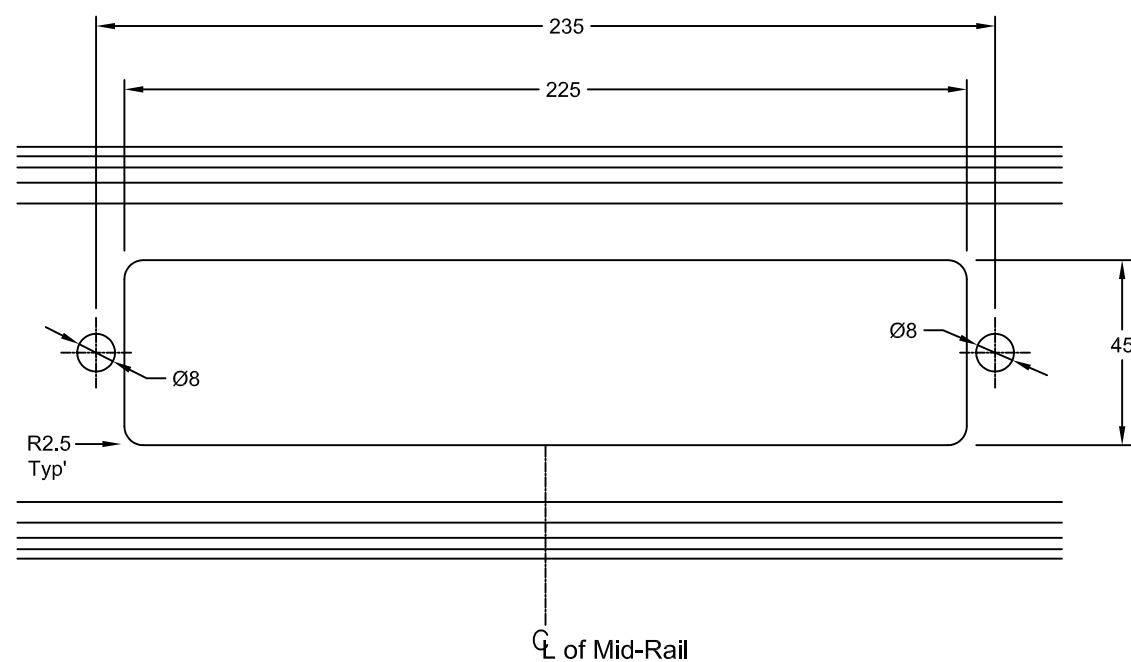




7a

Open In - Letter Plate Set

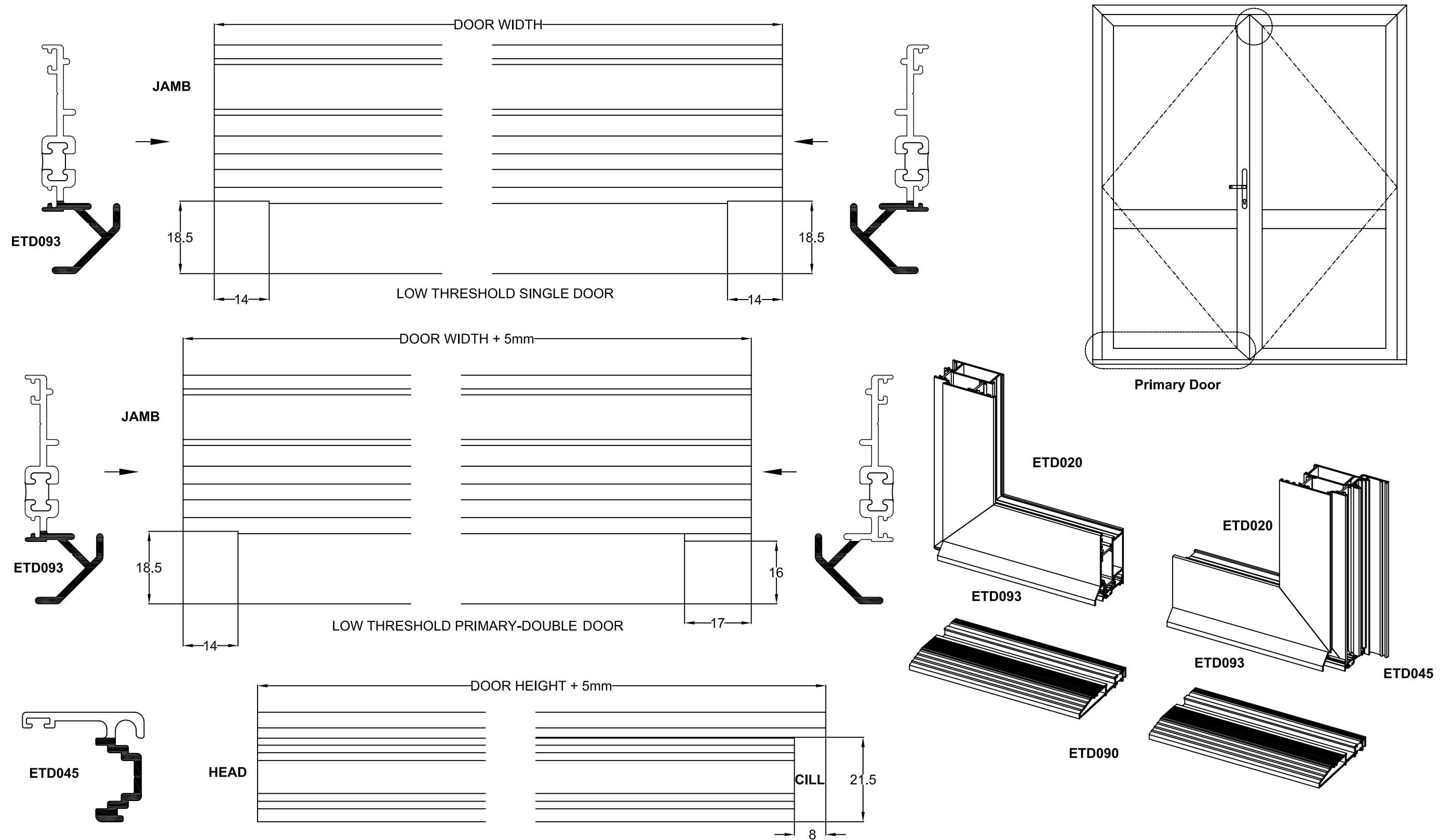
7a



7b

Open In - Single / Double Door Primary (Low Threshold)

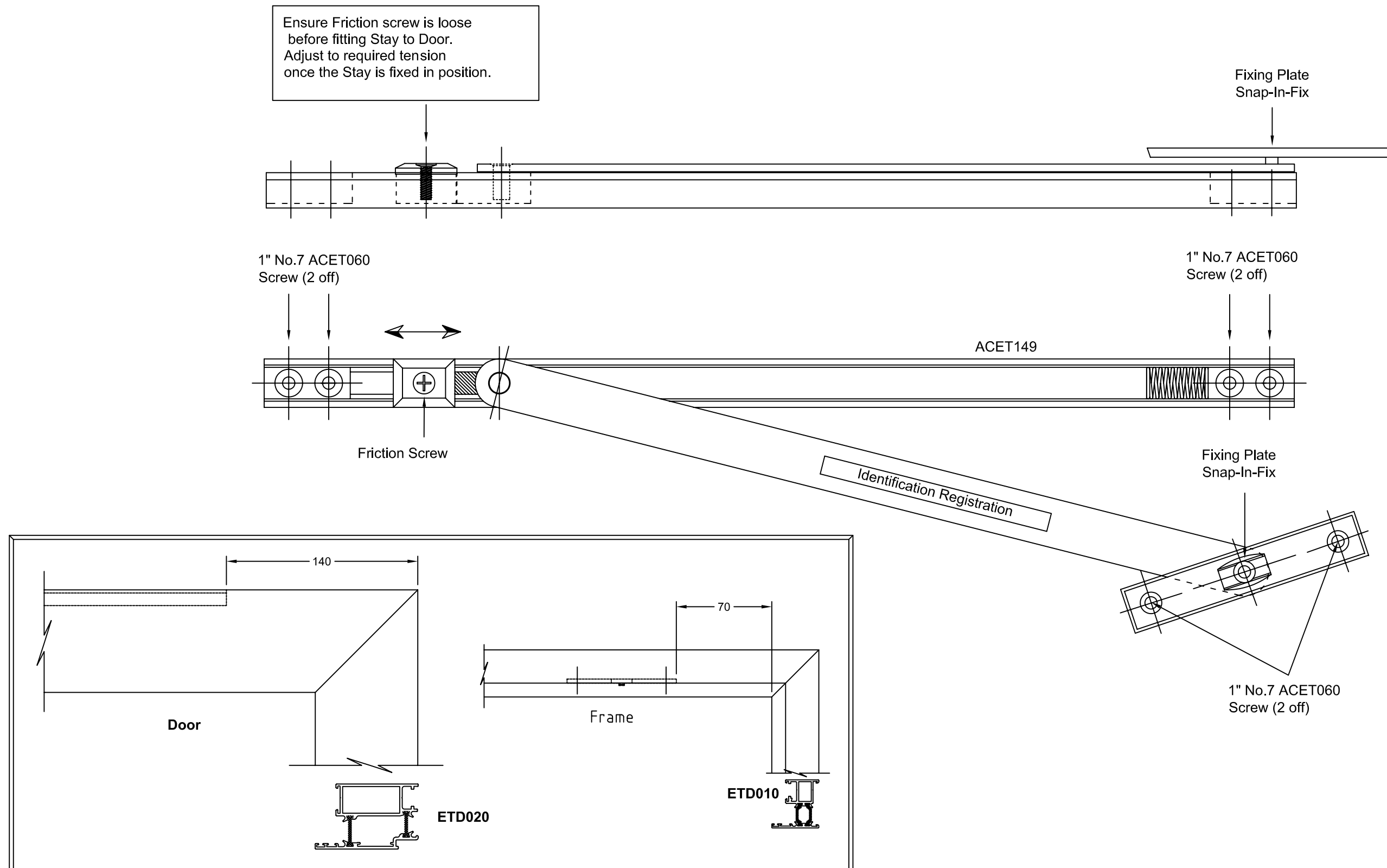
7b



7c

Open In - Slimline Restrictor

7c



**Alitherm Door
Open Out
Construction Drawings**

Index



Construction Drawings << Open Out >>



1 - Open In - Corner Jointing Page 127 to 133



2 - Transom/Mullion Fixings Page 134 to 137



3 - Stays / Hinges Page 138 to 138



4 - Locking Hardware Page 139 to 153



5 - Bead & Glazing Page 154 to 154



6 - Drainage Page 155 to 157



7 - Miscellaneous Page 158 to 160

IF IN DOUBT ASK!

**Alitherm Door
Open In
Construction Drawings**

Index



Construction Drawings << Open In >>



1 - Open In - Corner Jointing Page 91 to 97



2 - Transom/Mullion Fixings Page 98 to 101



3 - Stays / Hinges Page 102 to 102



4 - Locking Hardware Page 103 to 117



5 - Bead & Glazing Page 118 to 118



6 - Drainage Page 119 to 121



7 - Miscellaneous Page 122 to 124

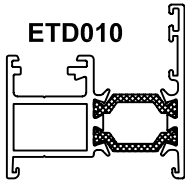
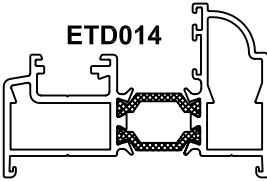
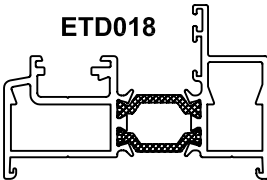
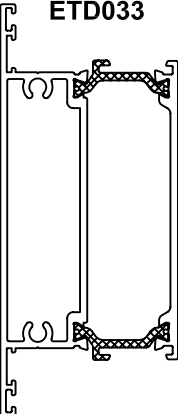
IF IN DOUBT ASK!

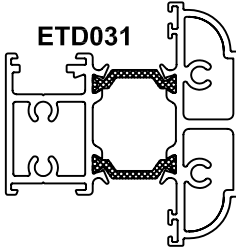
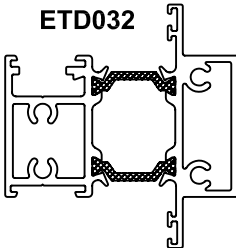
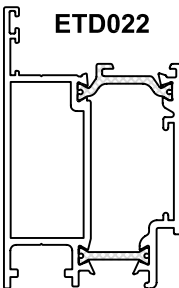
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1a

Open Out - Door Profiles

1a

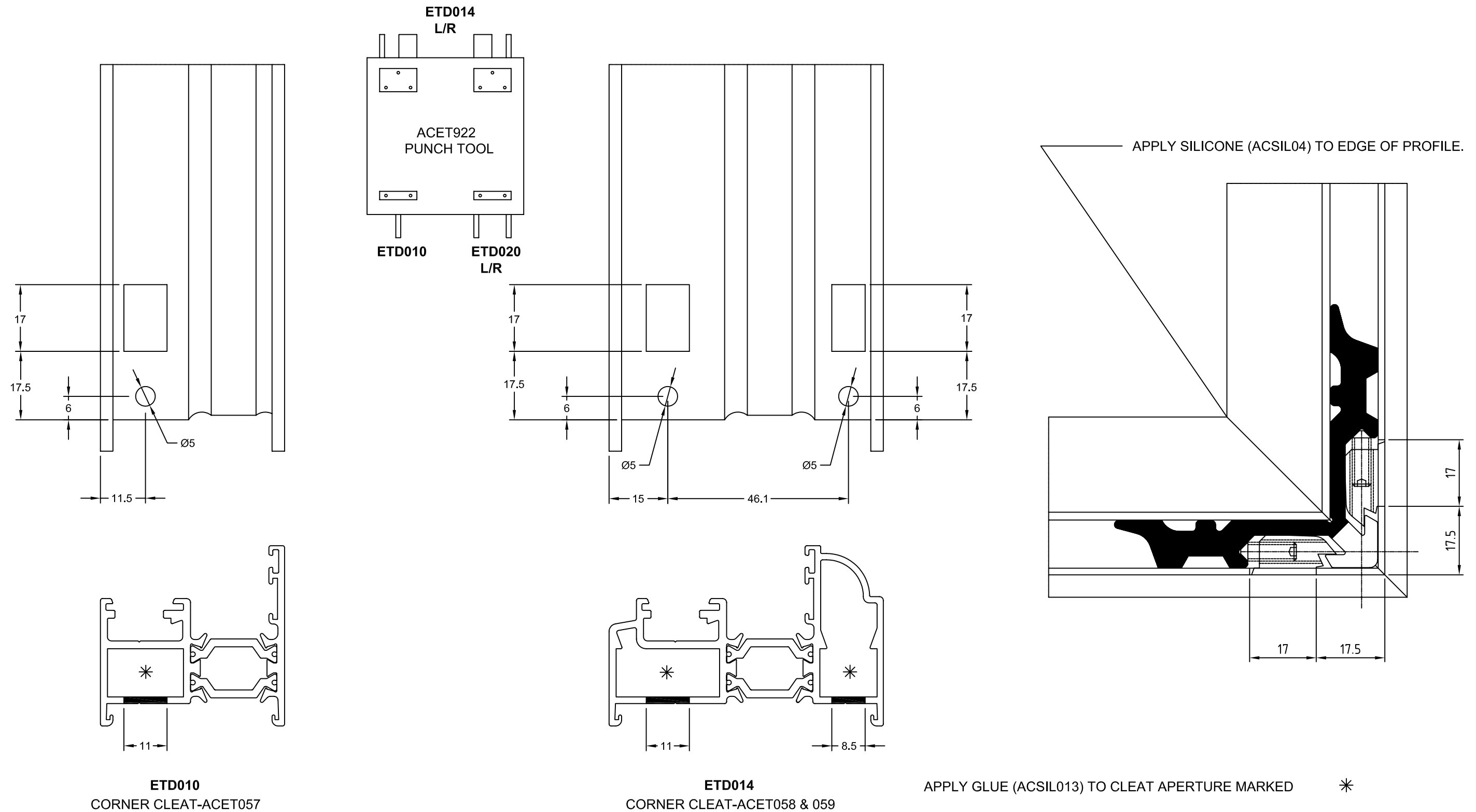
Profiles	Tooling / Components
<div>ETD010</div> 	<div> <div>Corner Chevron</div> <div>Mechanical cleat</div> <div>Tooling</div> </div> <div> <div>- WCA106</div> <div>- ACET057</div> <div>- ACET922</div> </div>
<div>ETD014</div>  <div>ETD018</div> 	<div> <div>Corner Chevron</div> <div>Mechanical Cleat</div> <div>Mechanical Cleat</div> <div>Tooling</div> </div> <div> <div>- WCA106</div> <div>- ACET058</div> <div>- ACET059</div> <div>- ACET922</div> </div>
<div>ETD033</div> 	<div> <div>Core Screw</div> <div>Drill Jig</div> </div> <div> <div>- PUA056ssz</div> <div>- ACET***</div> </div>

Profiles	Tooling / Components
<div>ETD031</div>  <div>ETD032</div> 	<div> <div>Core Screw</div> <div>Drill Jig</div> </div> <div> <div>- ACET079</div> <div>- ETD031</div> <div>- ACET916</div> </div>
<div>ETD022</div> 	<div> <div>Corner Chevron</div> <div>Corner Chevron</div> <div>Mechanical Cleat</div> <div>Tooling</div> </div> <div> <div>- ACET171</div> <div>- ACET055</div> <div>- ACET173</div> <div>- ACET922</div> </div>

1b

Open Out - Corner Cleat

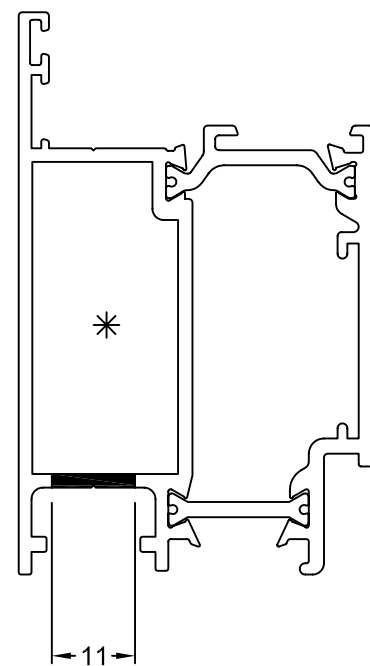
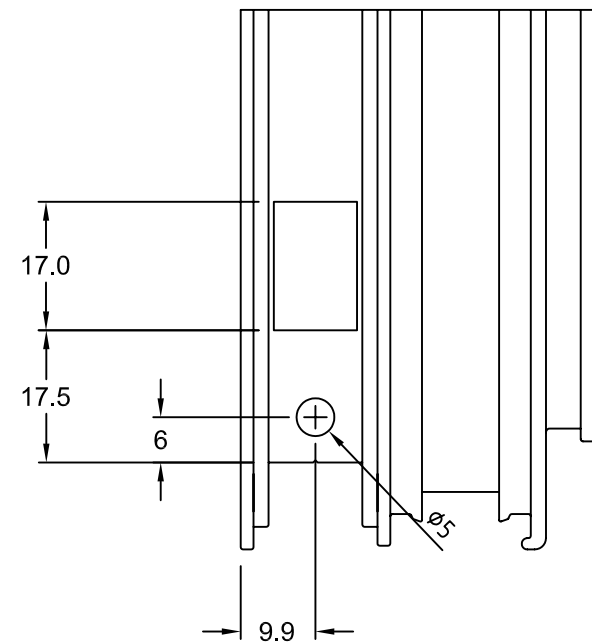
1b



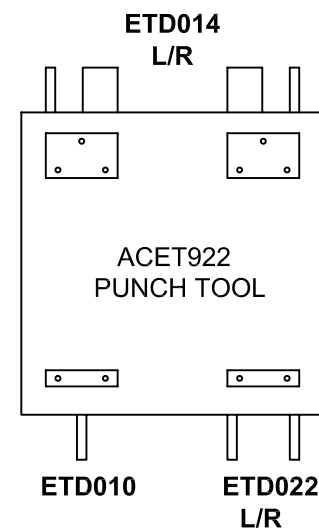
1c

Open Out - Corner Cleat

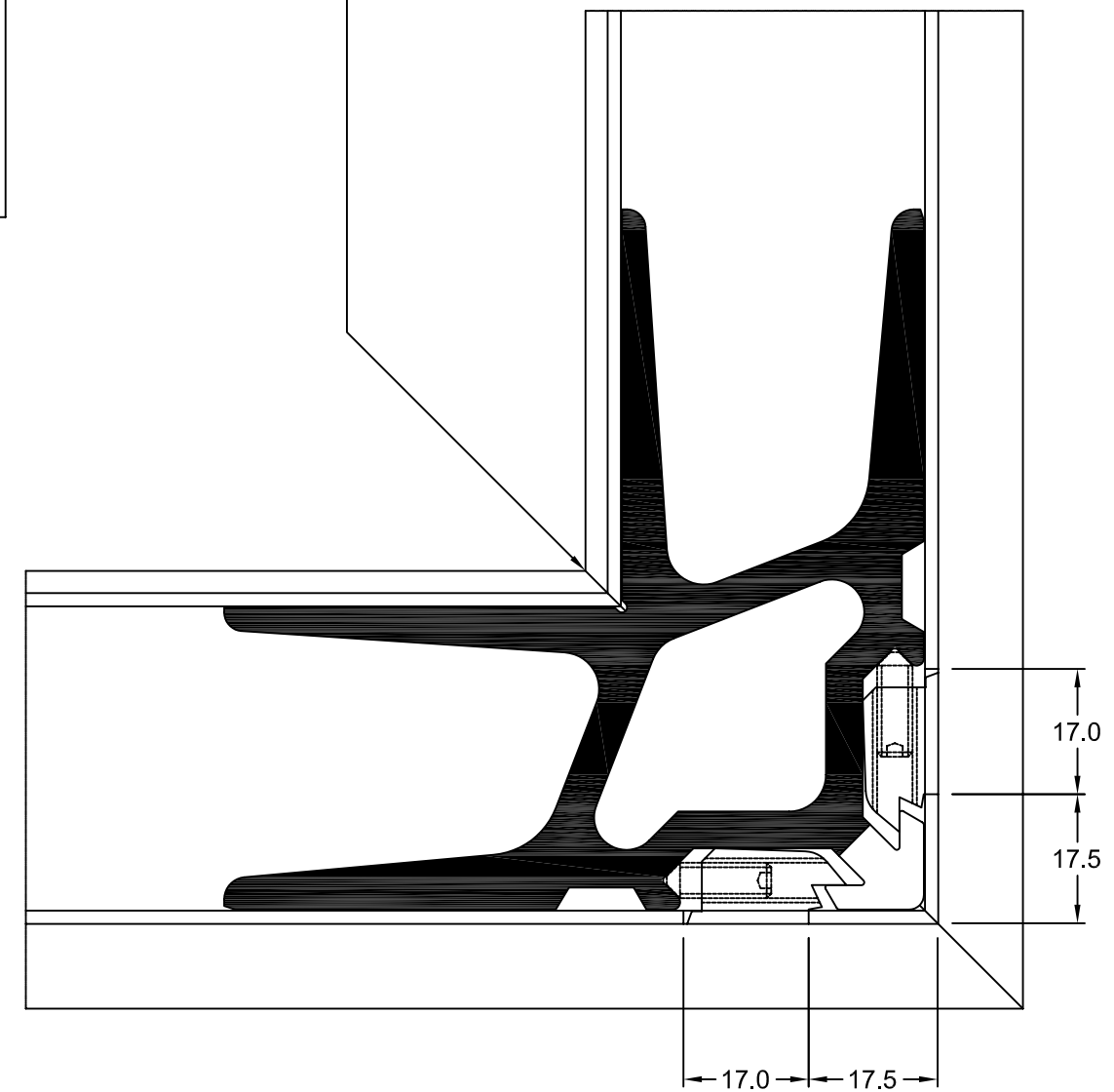
1c



ETD022
CORNER CLEAT-ACET056



APPLY SILICONE (ACSIL04) TO EDGE OF PROFILE.

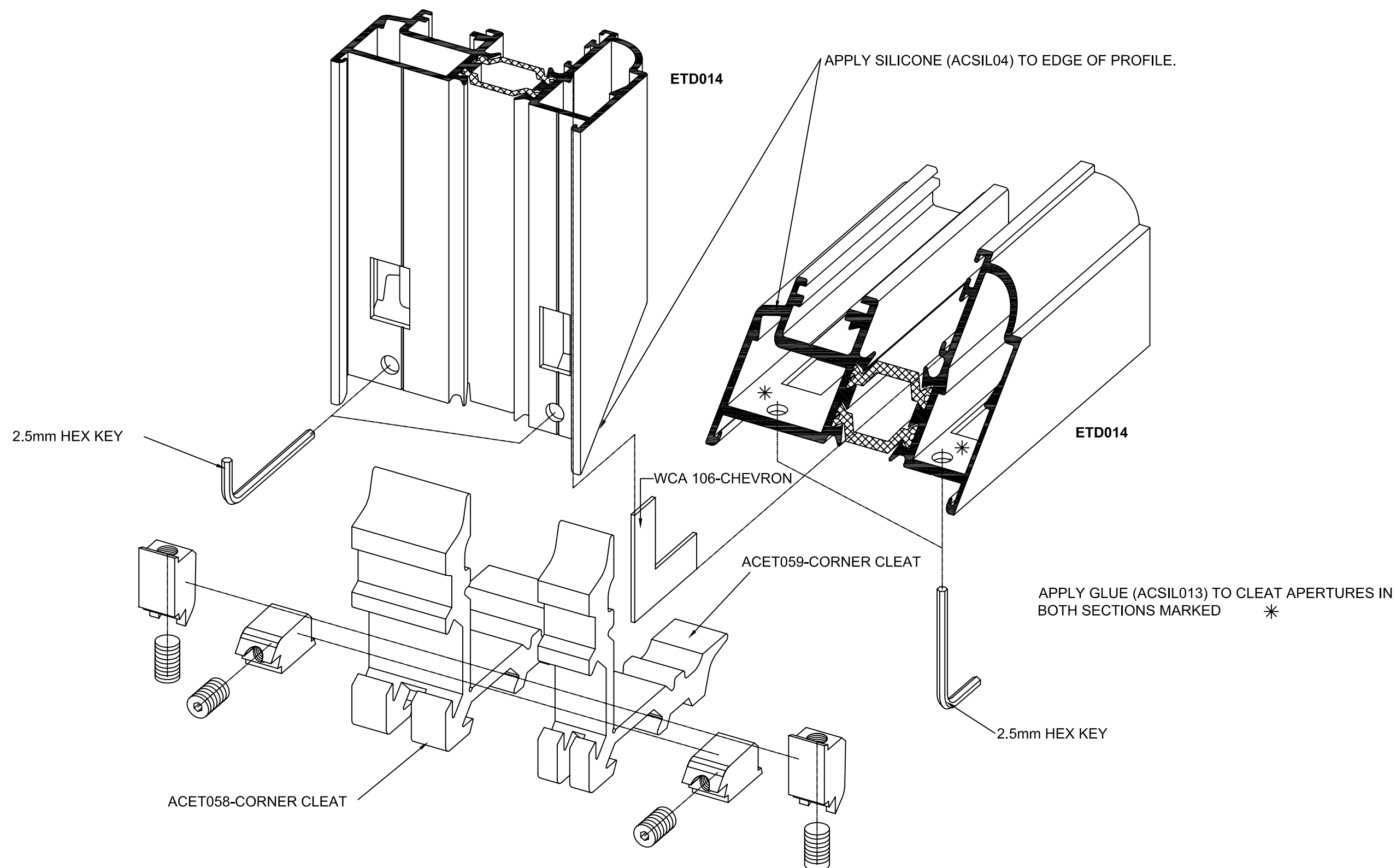


APPLY GLUE (ACSIL013) TO CLEAT APERTURE MARKED *

1d

Open Out - Montage Square Coupling Joint

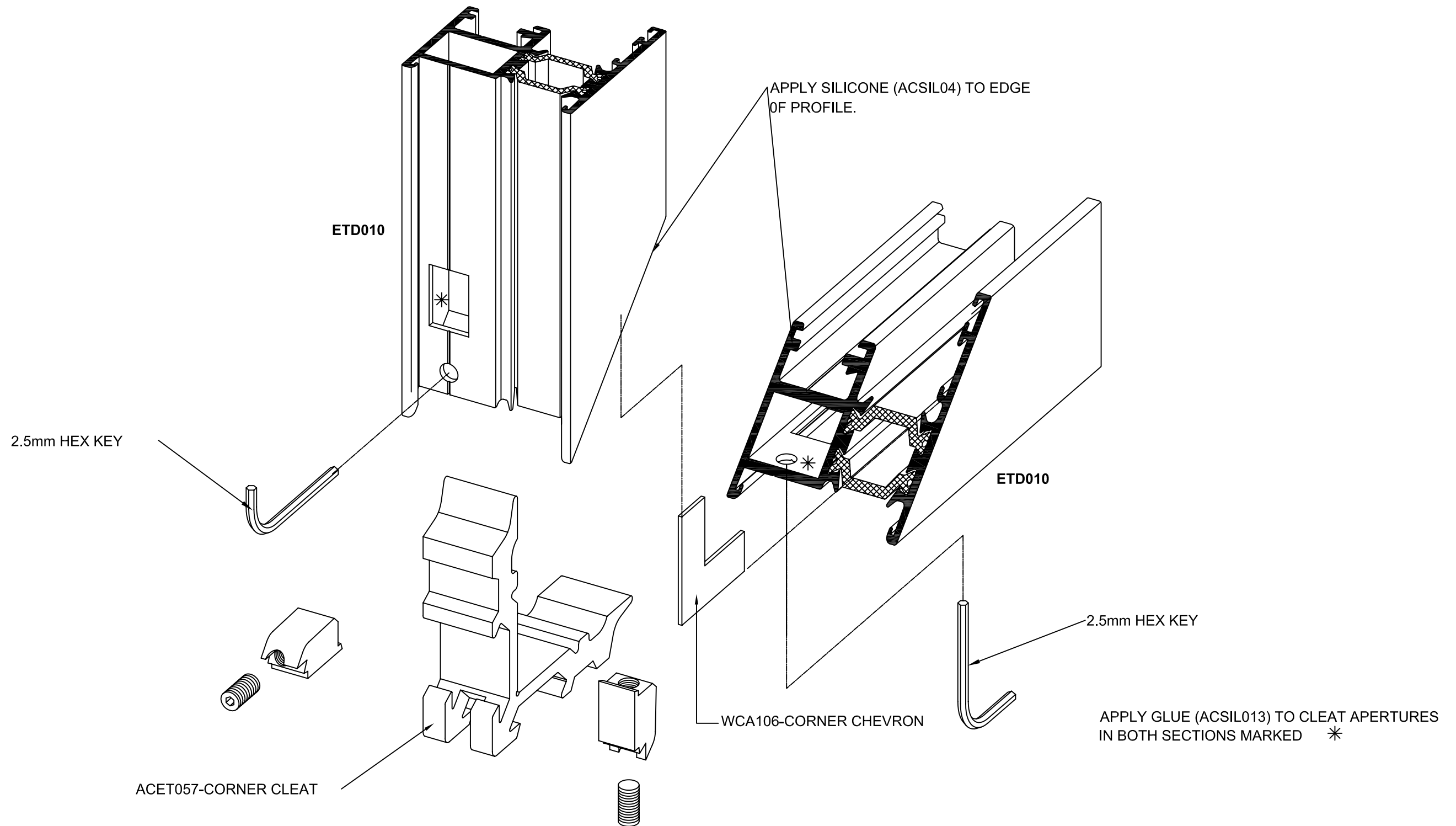
1d



1e

Open Out - Montage Square Coupling Joint

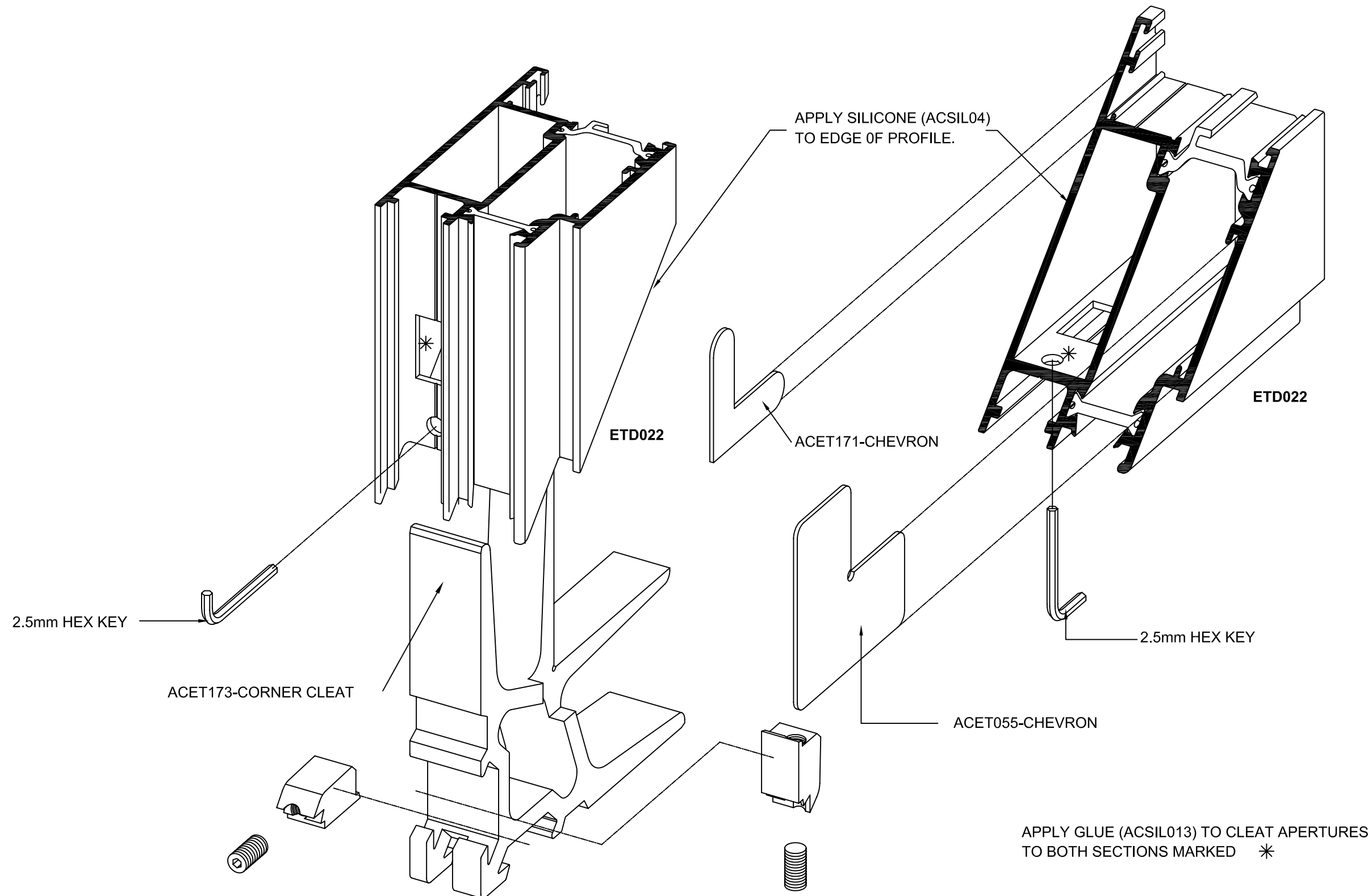
1e



1f

Open Out - Montage Square Coupling Joint

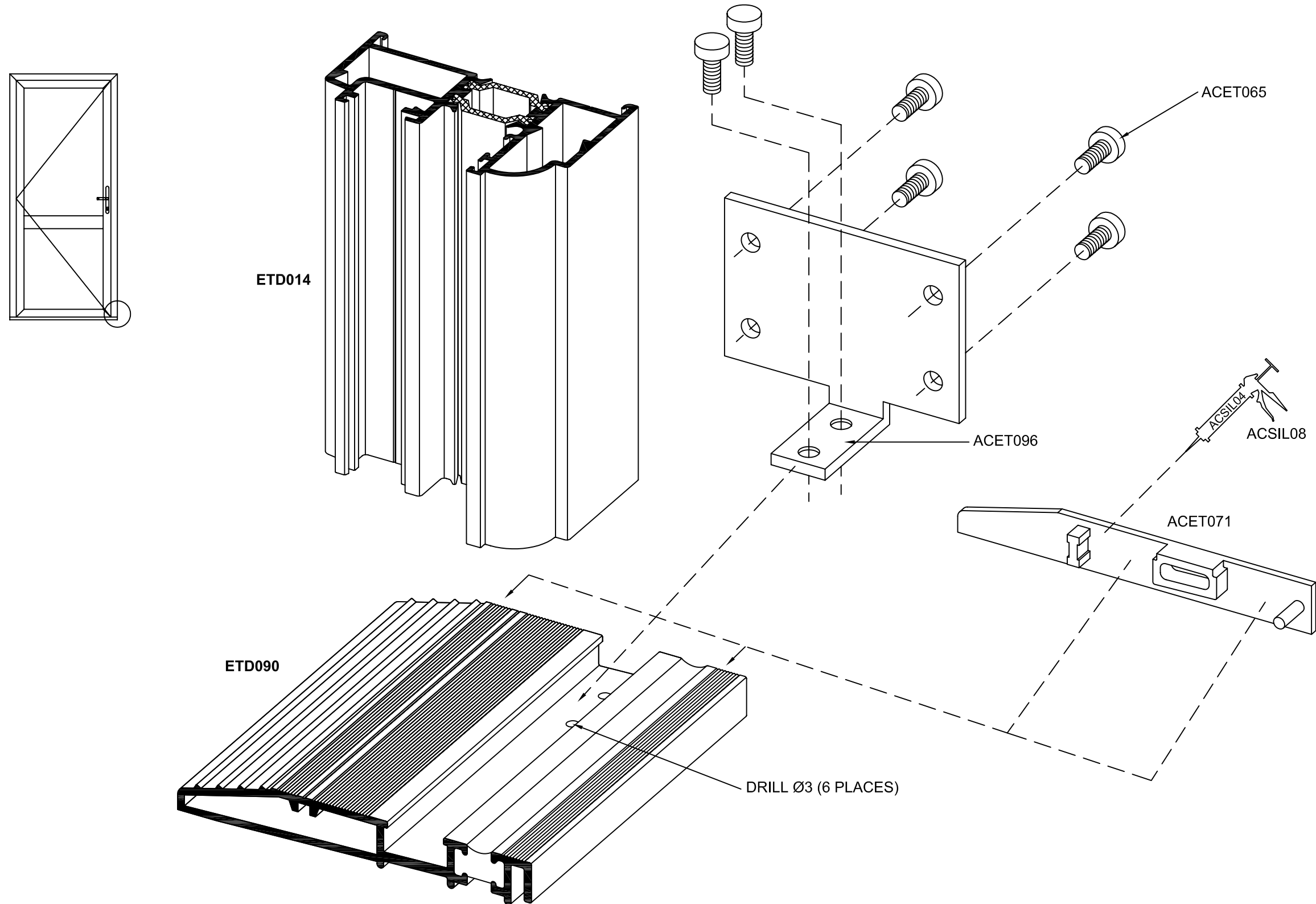
1f



1g

Open Out -Low Threshold Corner Joint

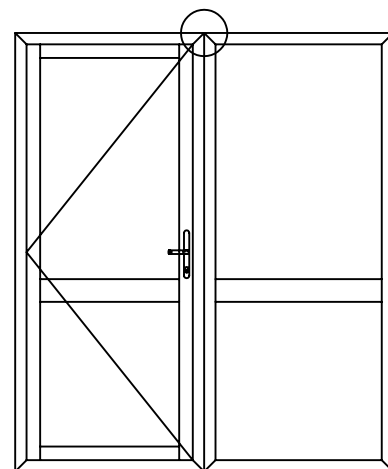
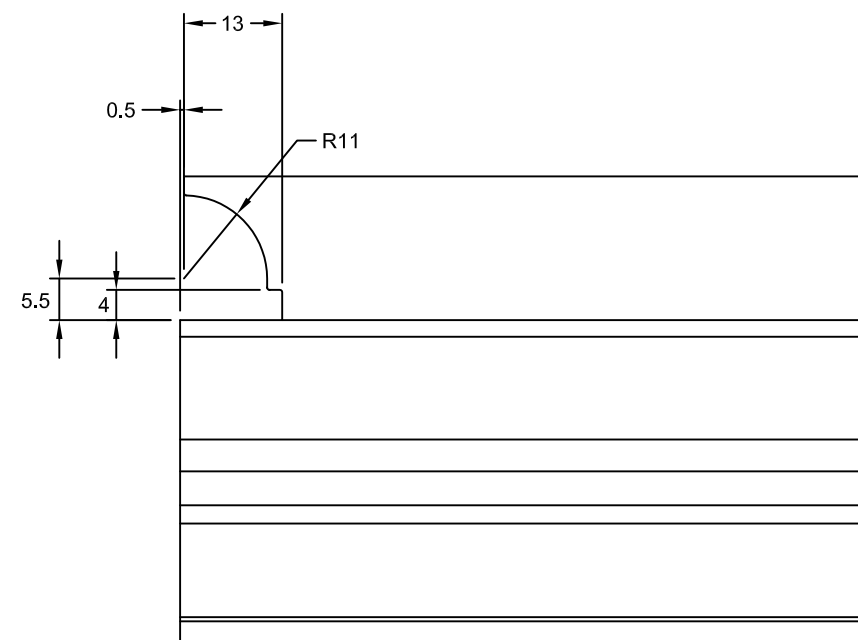
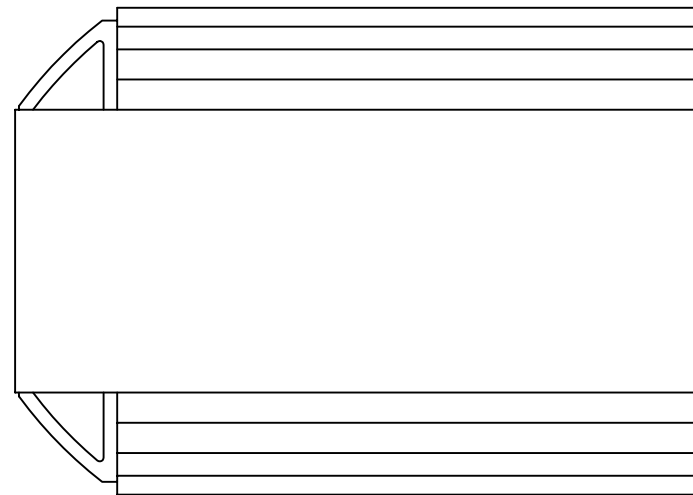
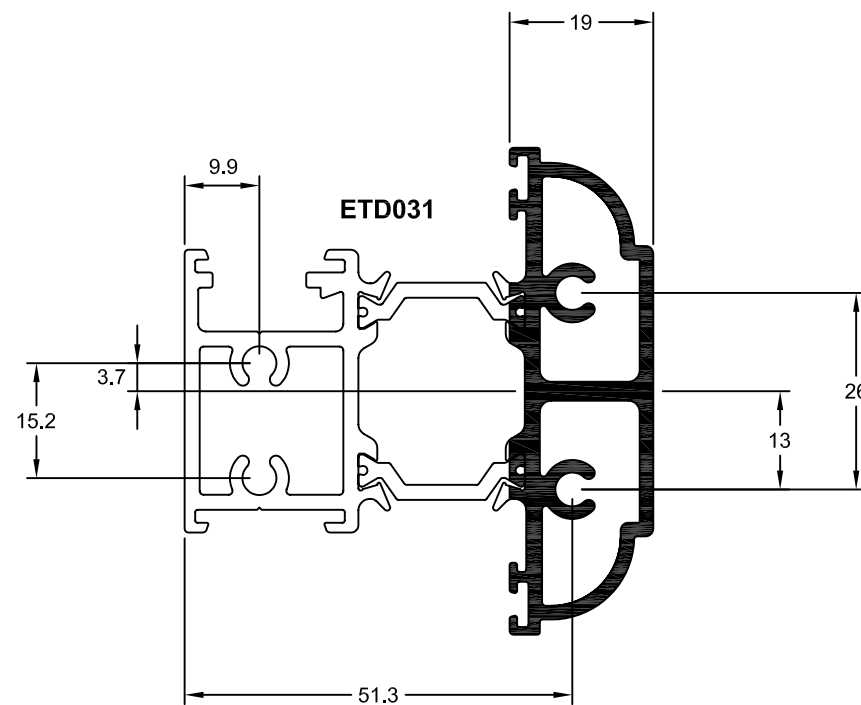
1g



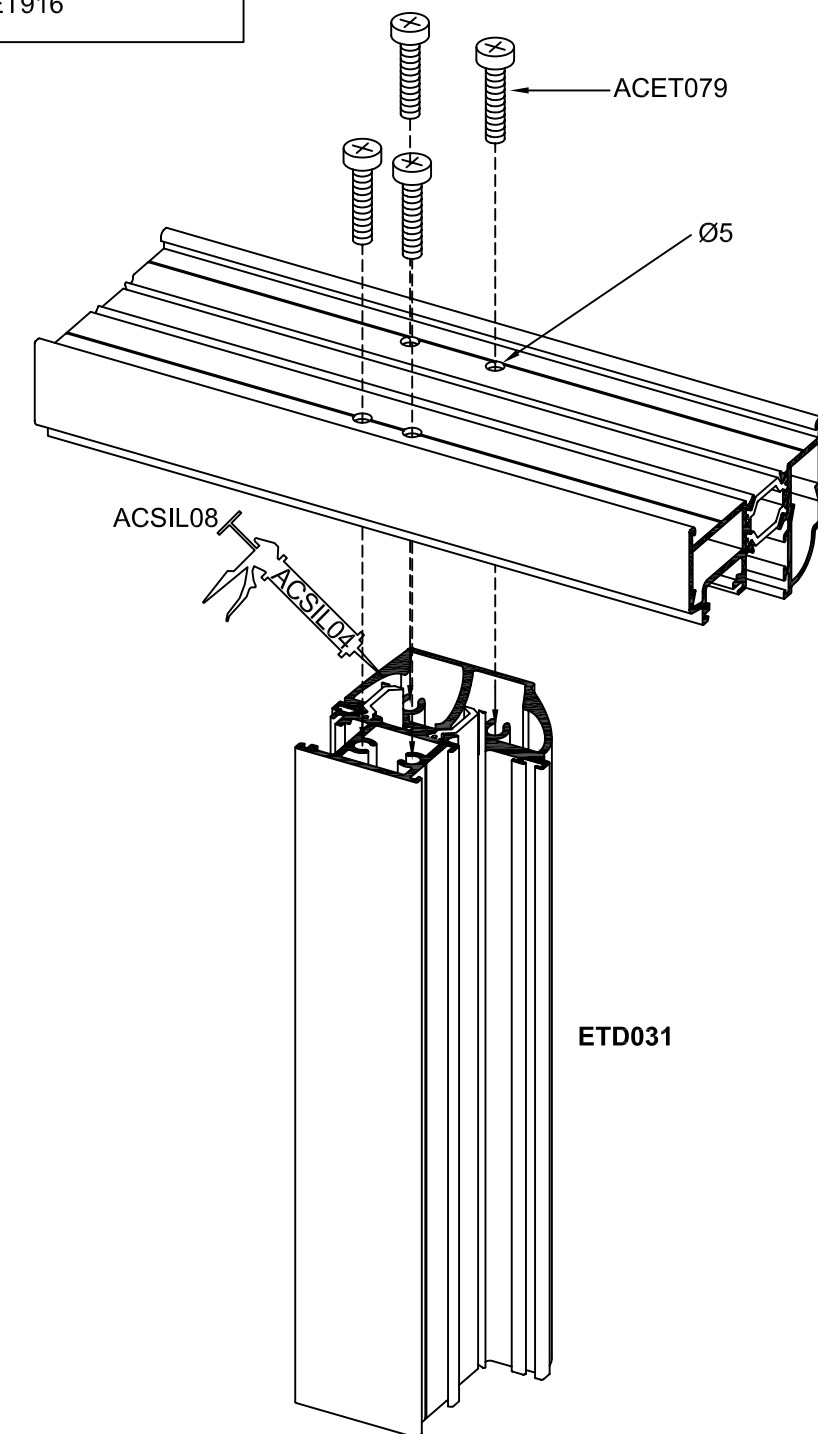
2a

Open Out - Integral Mullion-70mm Ovolo Outerframe

2a



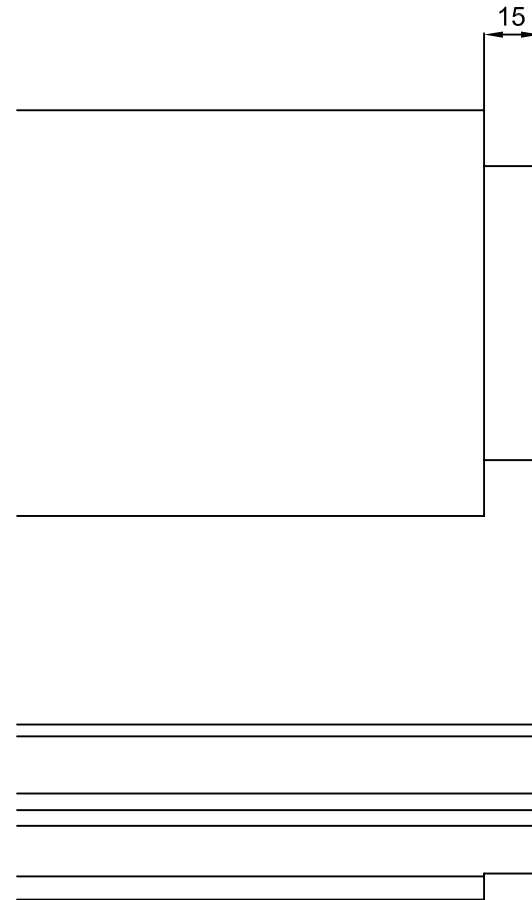
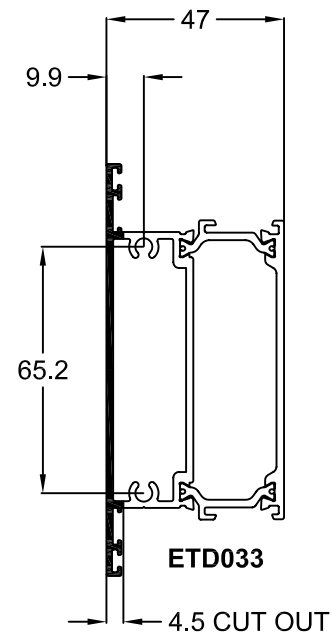
To ensure accuracy use
recommended Drill
jig-ACET916



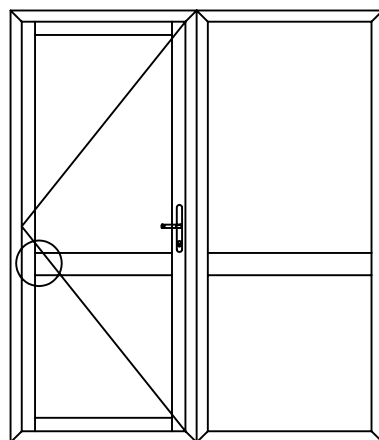
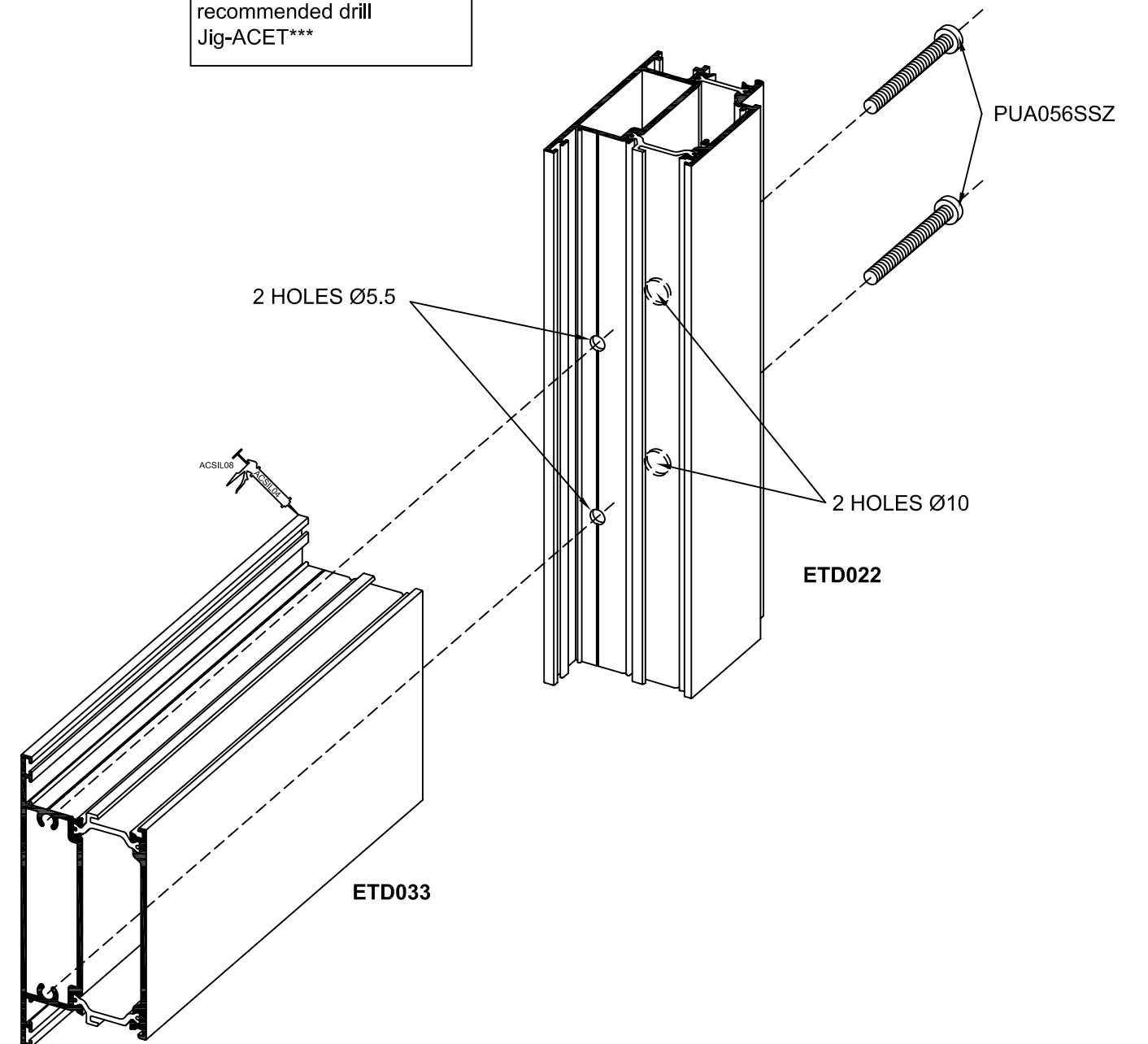
2b

Open Out - Middle/Deep Rail with Leaf Stile

2b



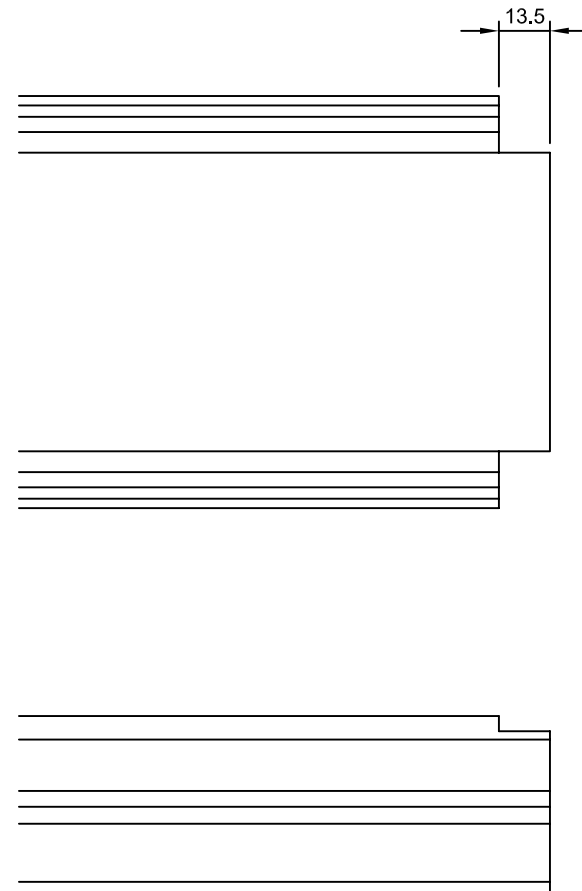
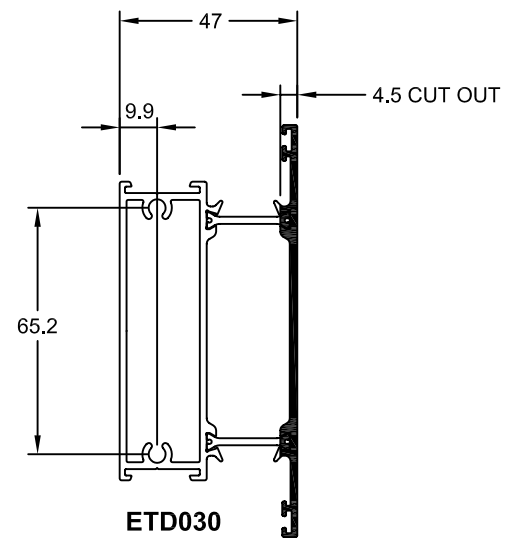
To ensure accuracy use
recommended drill
Jig-ACET***



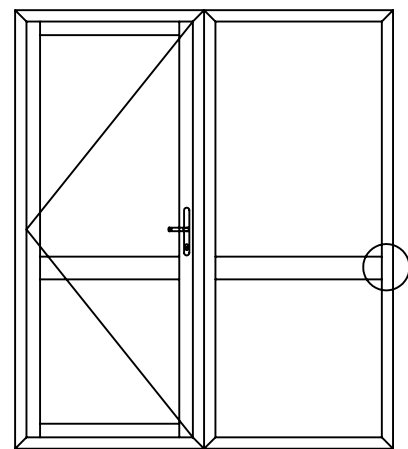
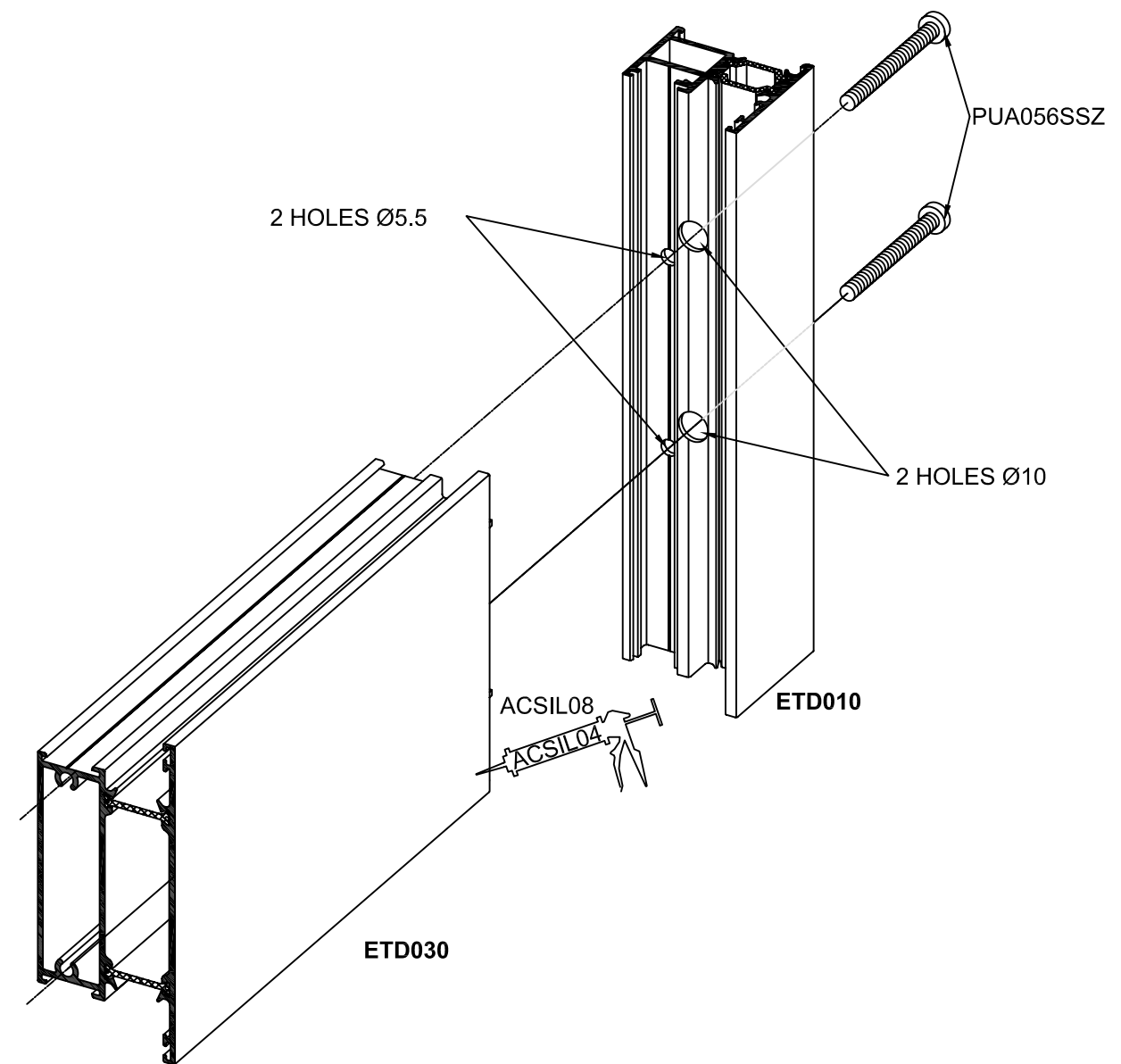
2c

Open Out - Middle / Deep Rail 47mm Outerframe

2c



To ensure accuracy use
recommended drill
Jig-ACET916



	Section 'E'	Alitherm Door	Section 'E'	
Construction Drawing			Drawing Number: eETD-47-11-00	
2d	Open Out - Cill / Mullion Joint (Not Applicable)			2d
<div>This Page Left Blank Intentionally</div>				
Release Date:-January 2009		Do Not Scale from this Drawing		Page 137

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3a

Open Out - Hinge Assembly ETD014 / ETD020

3a

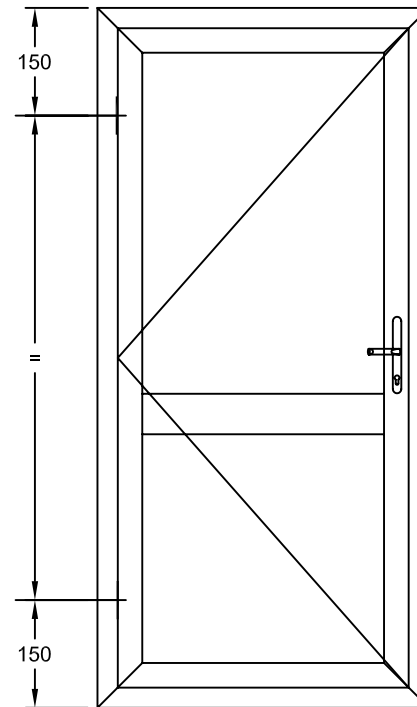
ASSEMBLY INSTRUCTIONS

- 1-Fix 2no M5x10mm grub screws to sash frame clamp plate and slide into sash eurogroove to hinge position.
- 2-Locate hinge and clamp in position using 2no M5x10mm machine screws.
- 3-Fix sash to outer frame using clamp plates and fit M5 x 15mm c/sk machine screws and adjust for correct operation.
- 4-If the sash requires adjustment after the door has been glazed this can be achieved by loosening the clamp plate machine screws, adjusting the sash height and tightening the clamp plates.

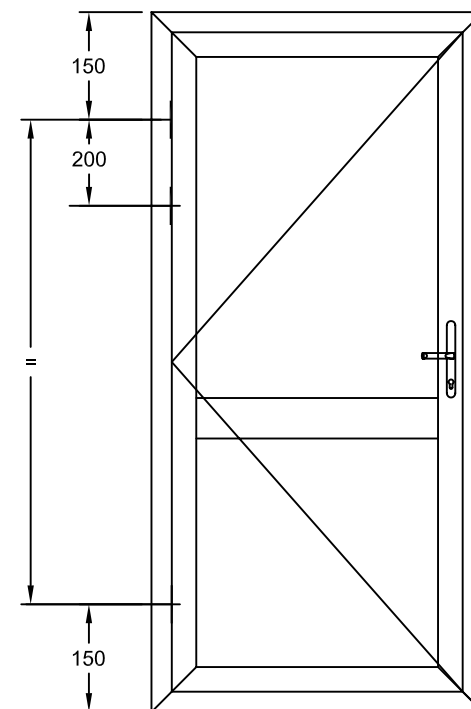
Notes:

1-Maximum Door Weight-Polyamide Profile
Domestic Houses-70Kg based on 2no hinges(1 top,1 bottom).
with 3no hinges(2 top,1 bottom) 10Kg can be added to the above weight limits.

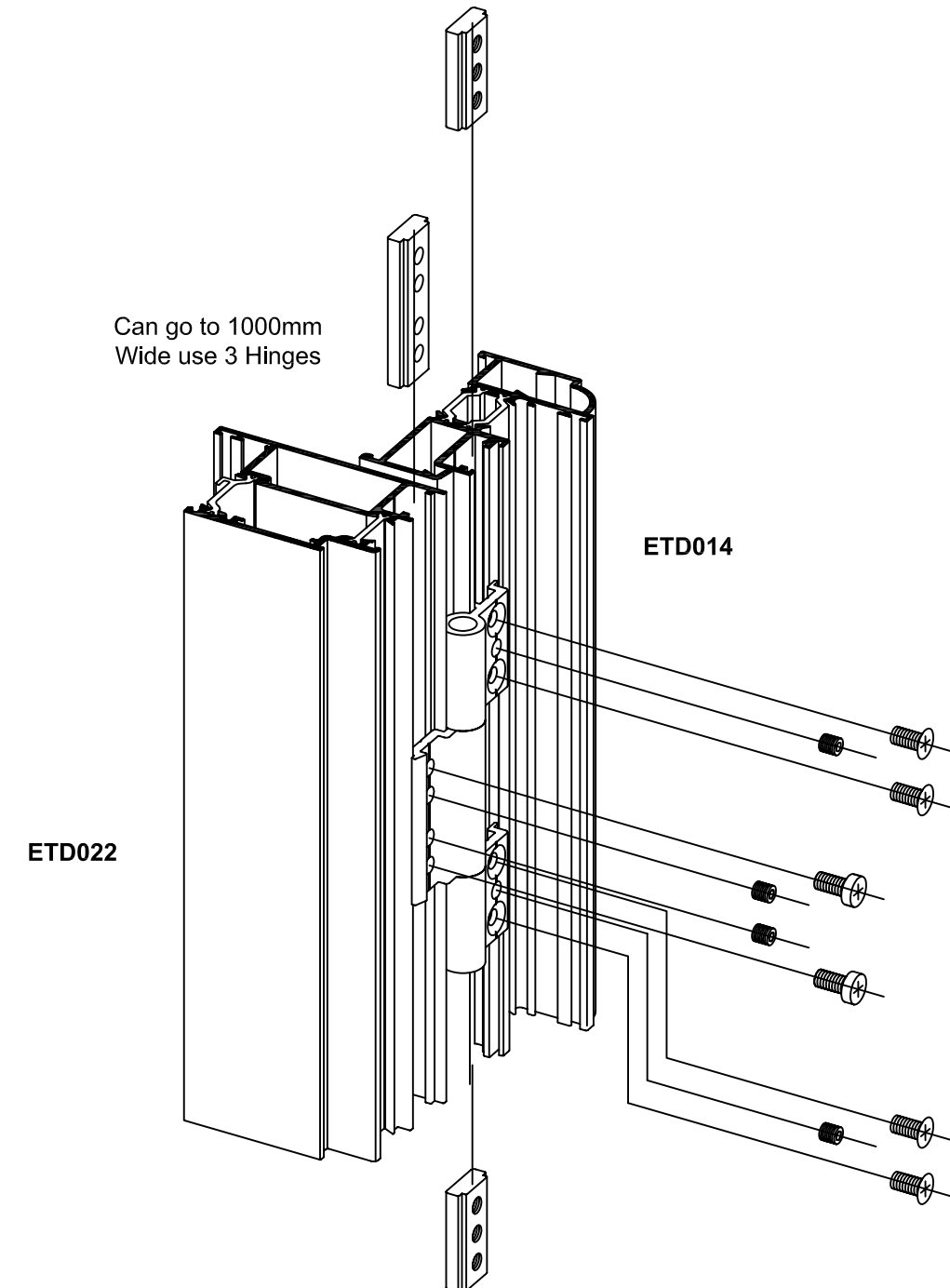
2-Door Leaf Limits
Double door 1800 mm max (wide)

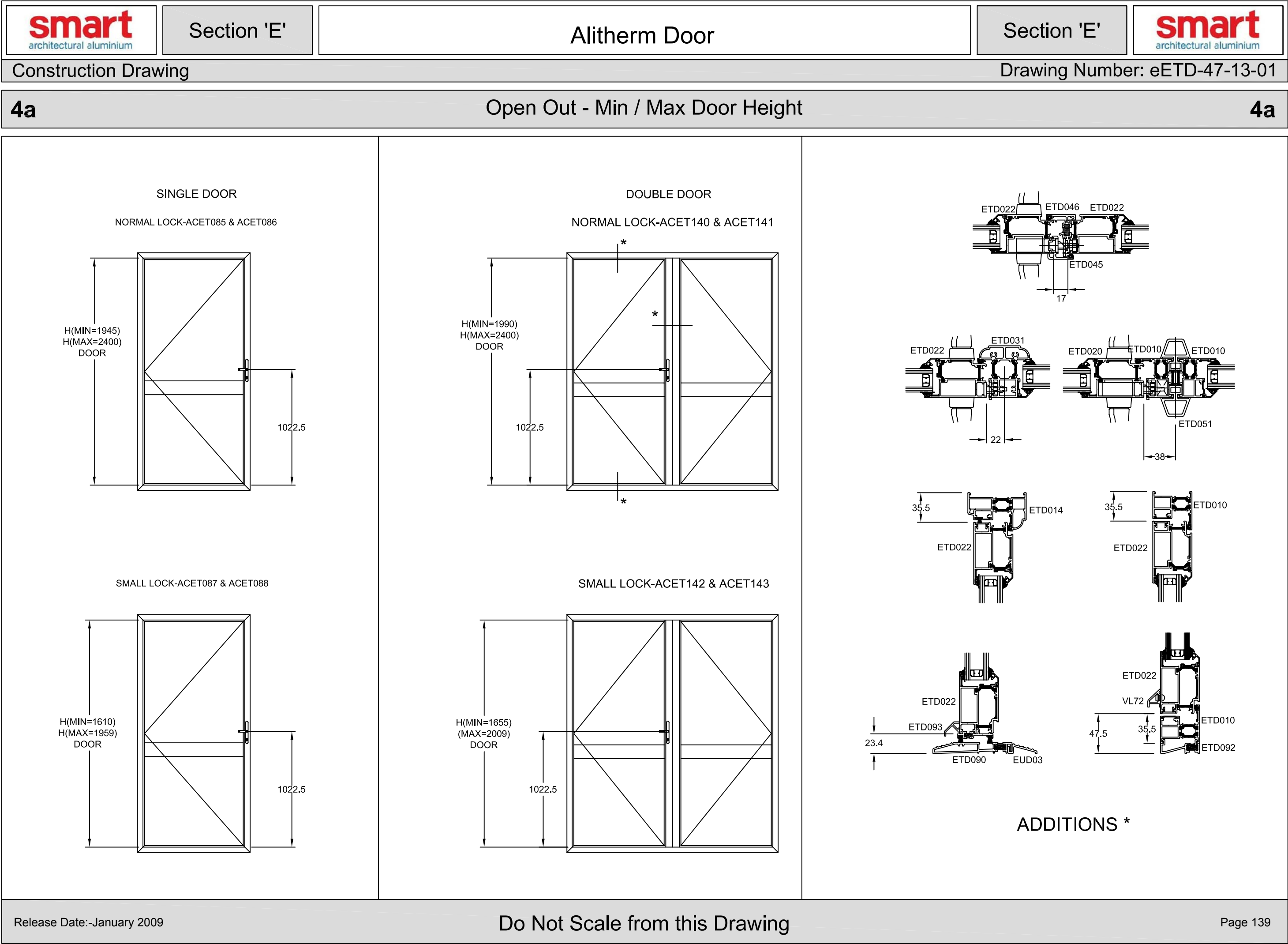


2100 MAX DOOR LEAF <70Kg MAX



2100-2400 MAX DOOR LEAF >70Kg UPTO 80Kg max.

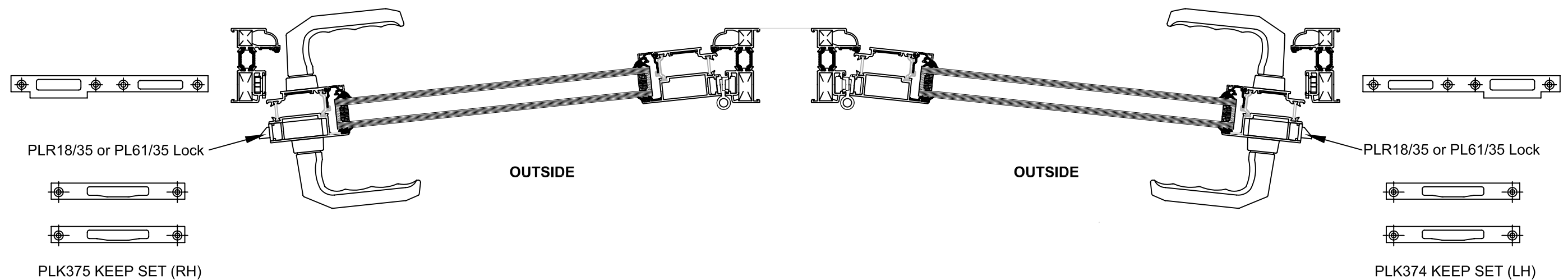
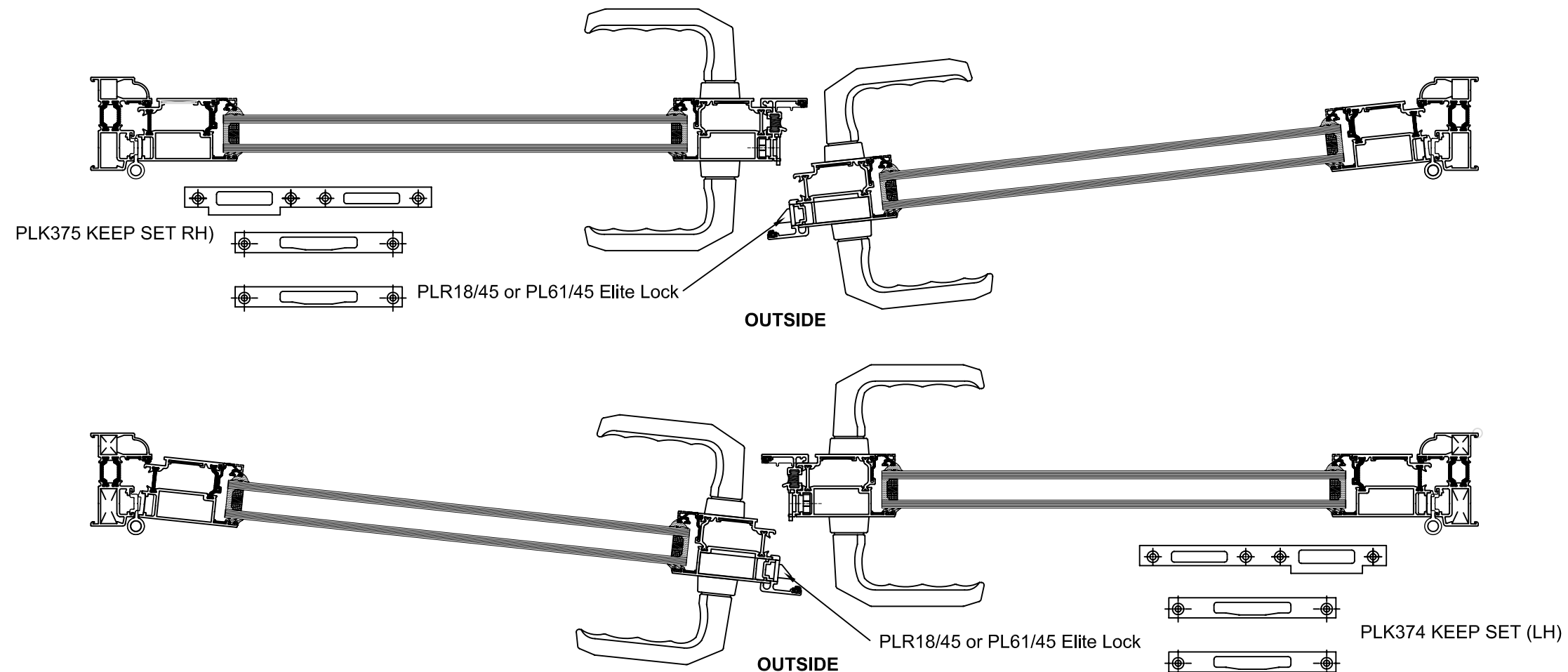


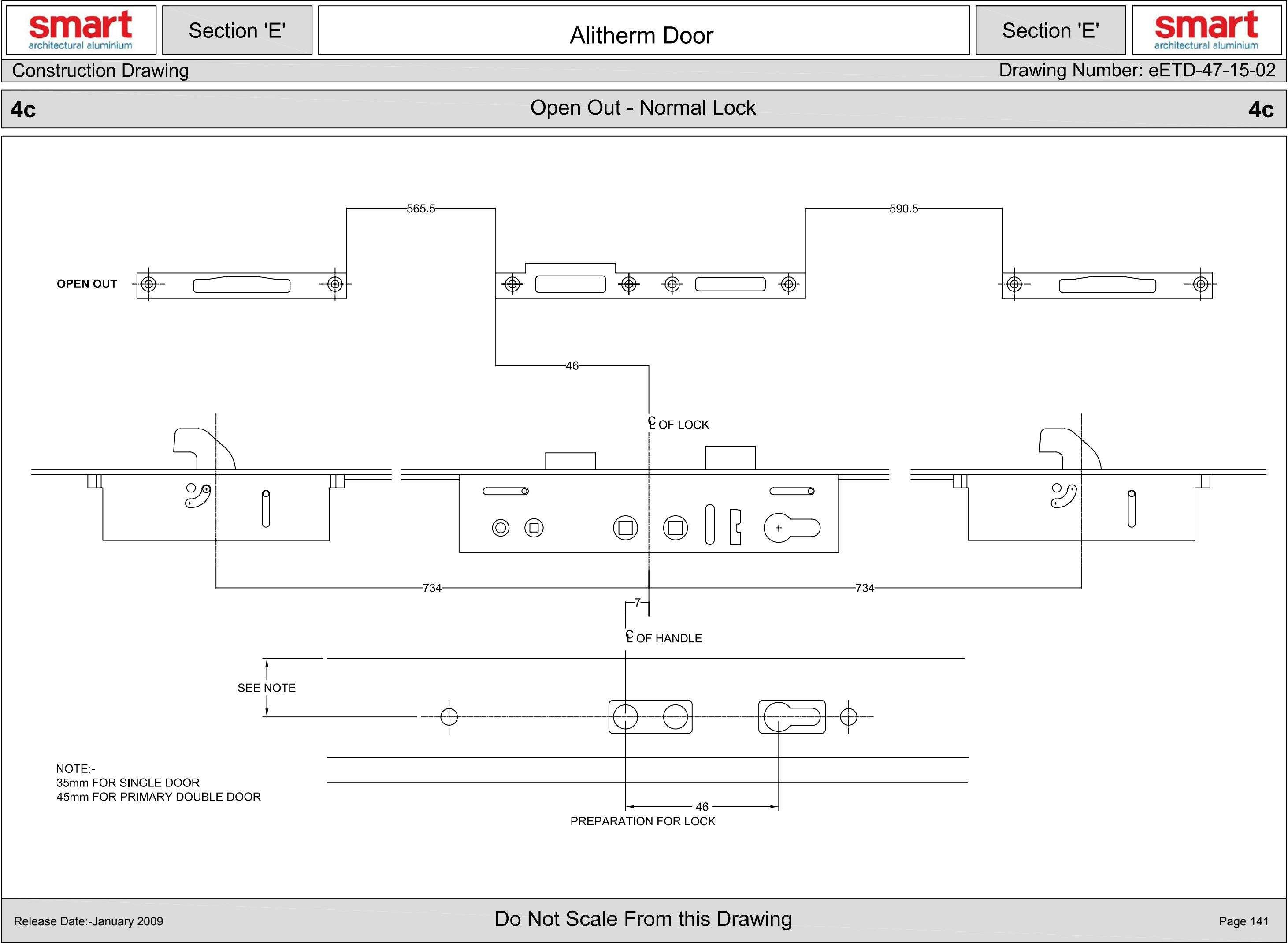


4b

Open Out - Configuration

4b

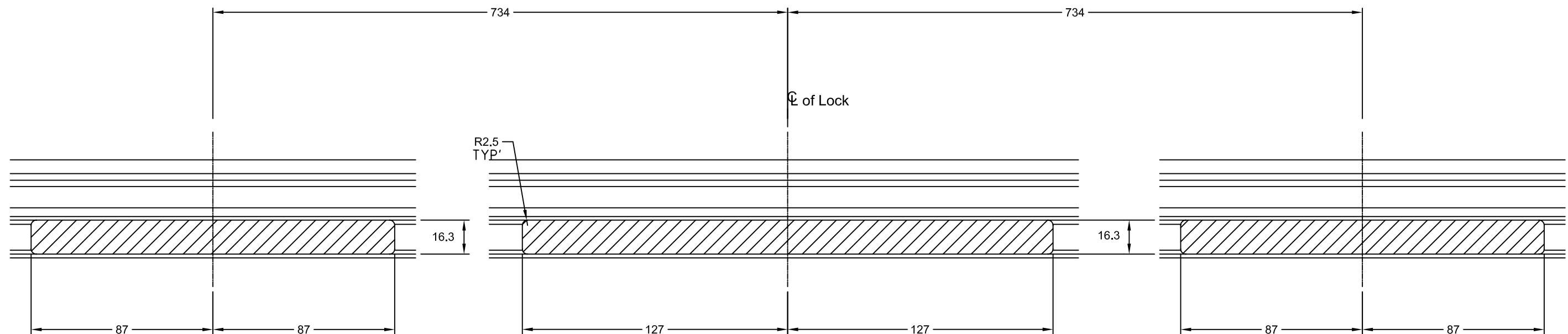
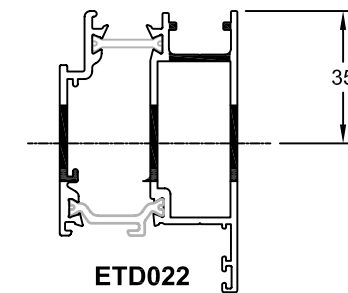
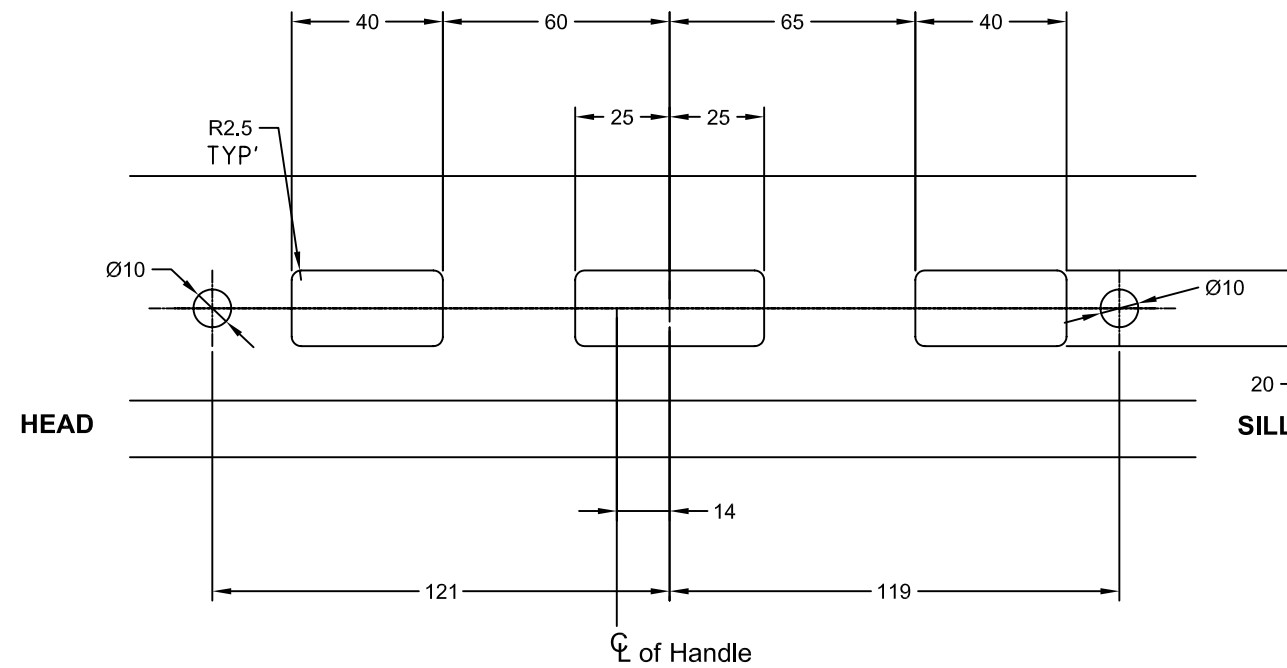
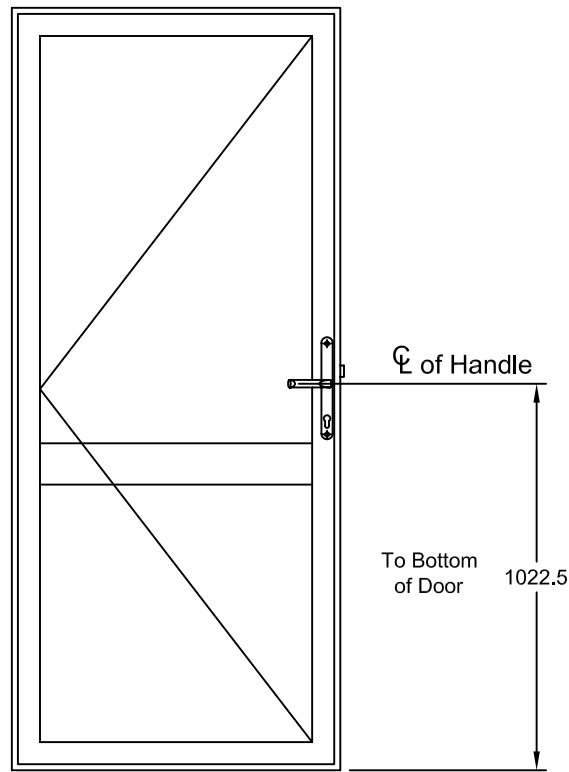




4d

Open Out - Single Door (Normal Lock) 35mm Backset / Door Leaf Preparation

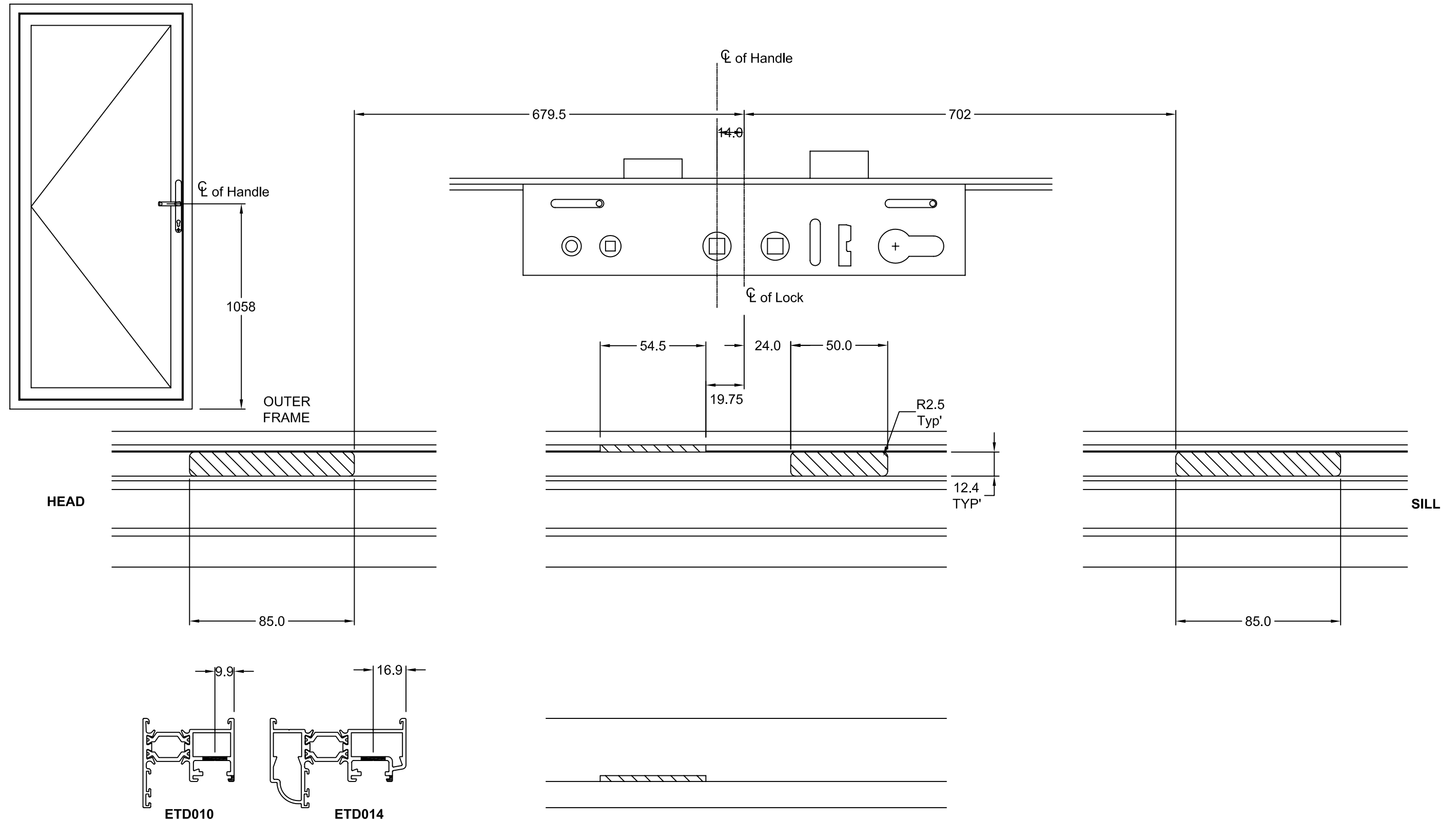
4d



4e

Open Out - Single Door (Normal Lock) 35mm Backset / Outerframe Preparation

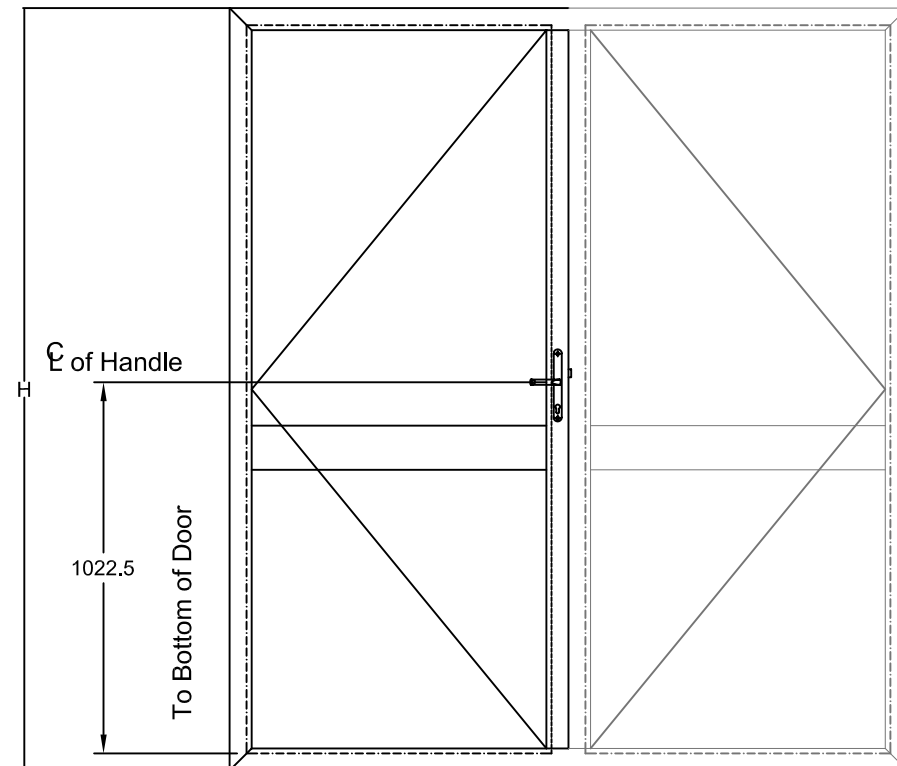
4e



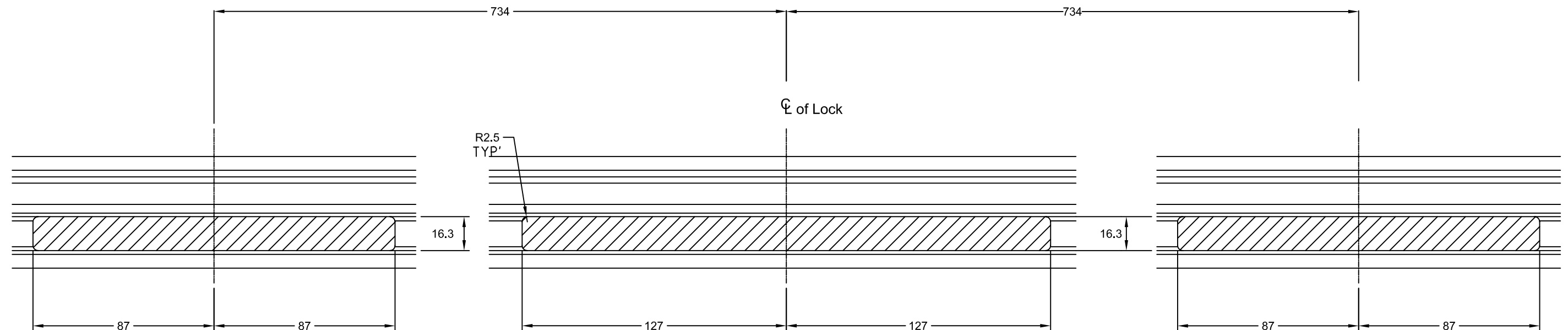
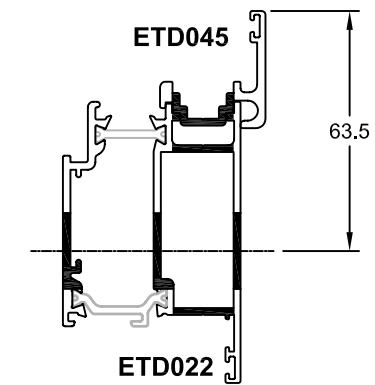
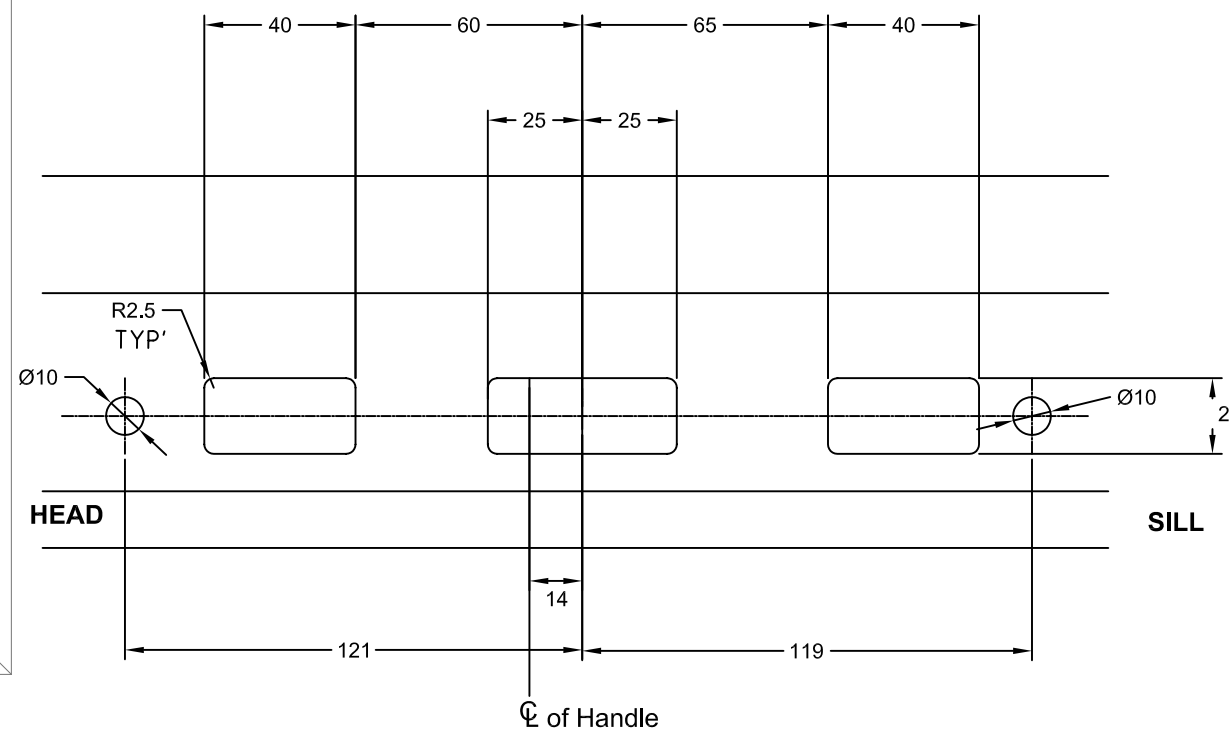
4f

Open Out -Double Door Primary (Normal Lock) 45mm Backset / Door Leaf Preparation

4f



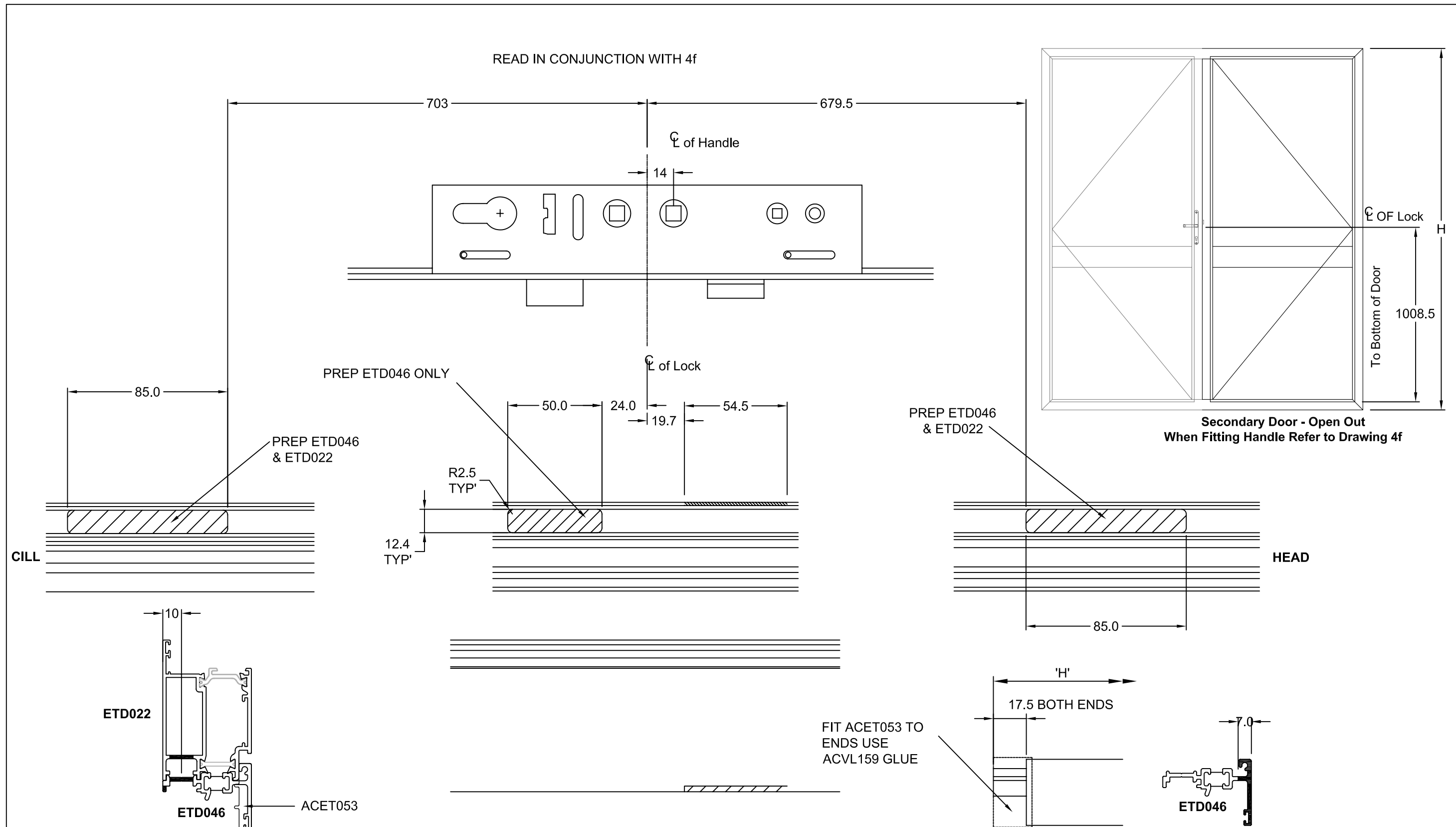
Primary Door - Open Out



4g

Open Out - Double Door Secondary (Normal Lock) 45mm Backset/Door Leaf Preparation

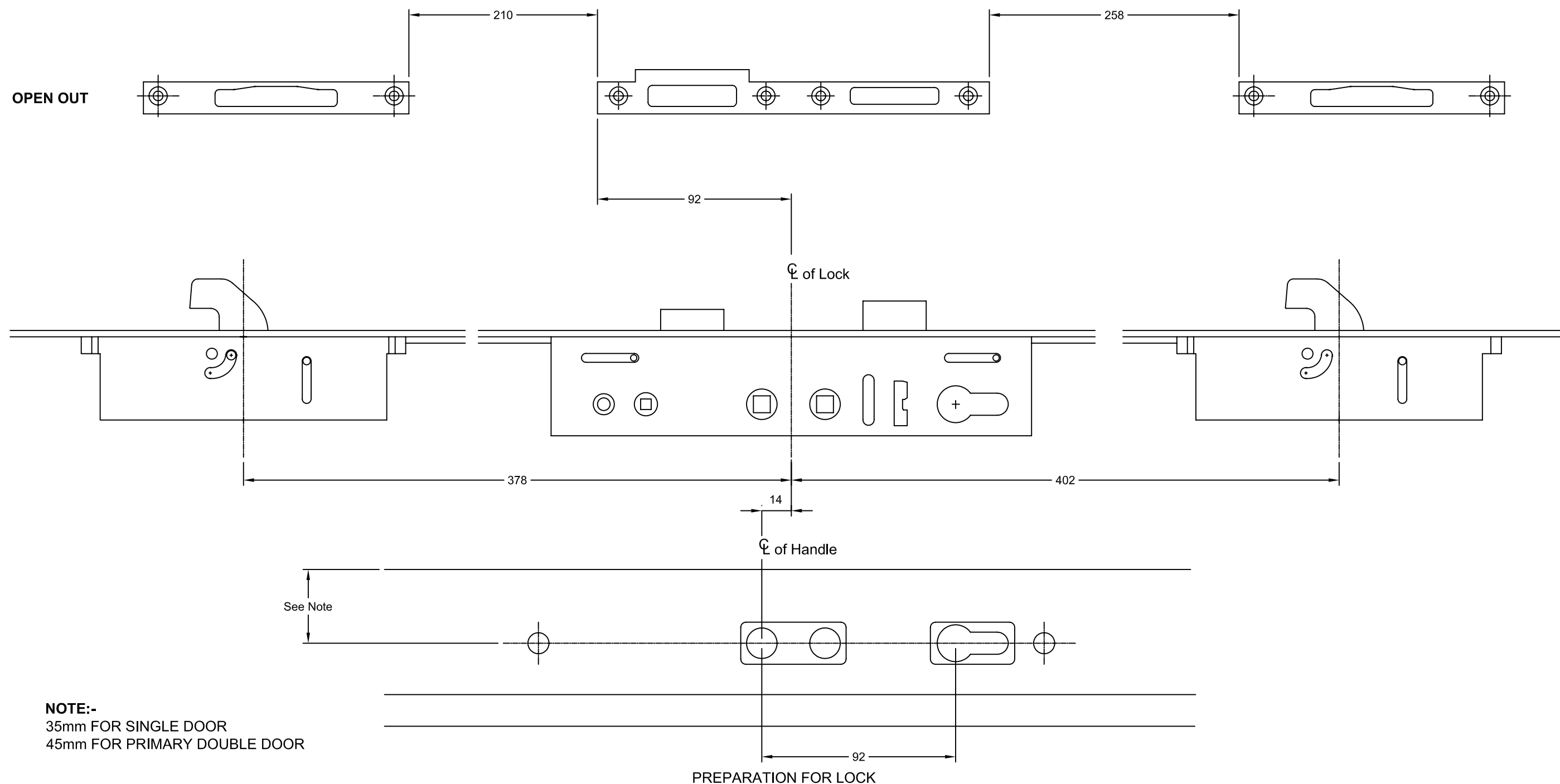
4g



4h

Open Out - Short Lock

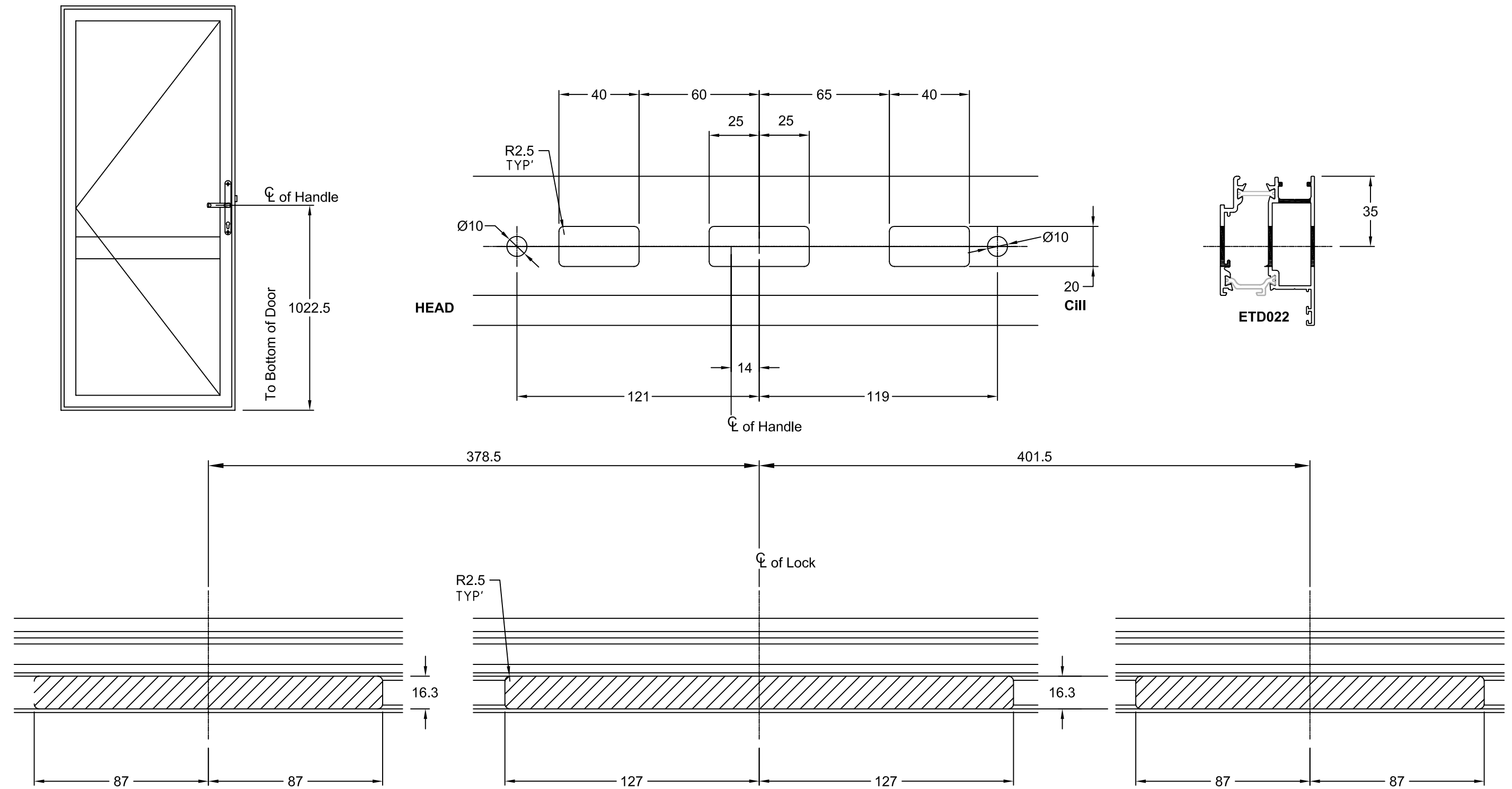
4h



4j

Open Out - Single Door (Short Lock) 35mm Backset Door Leaf Preparation

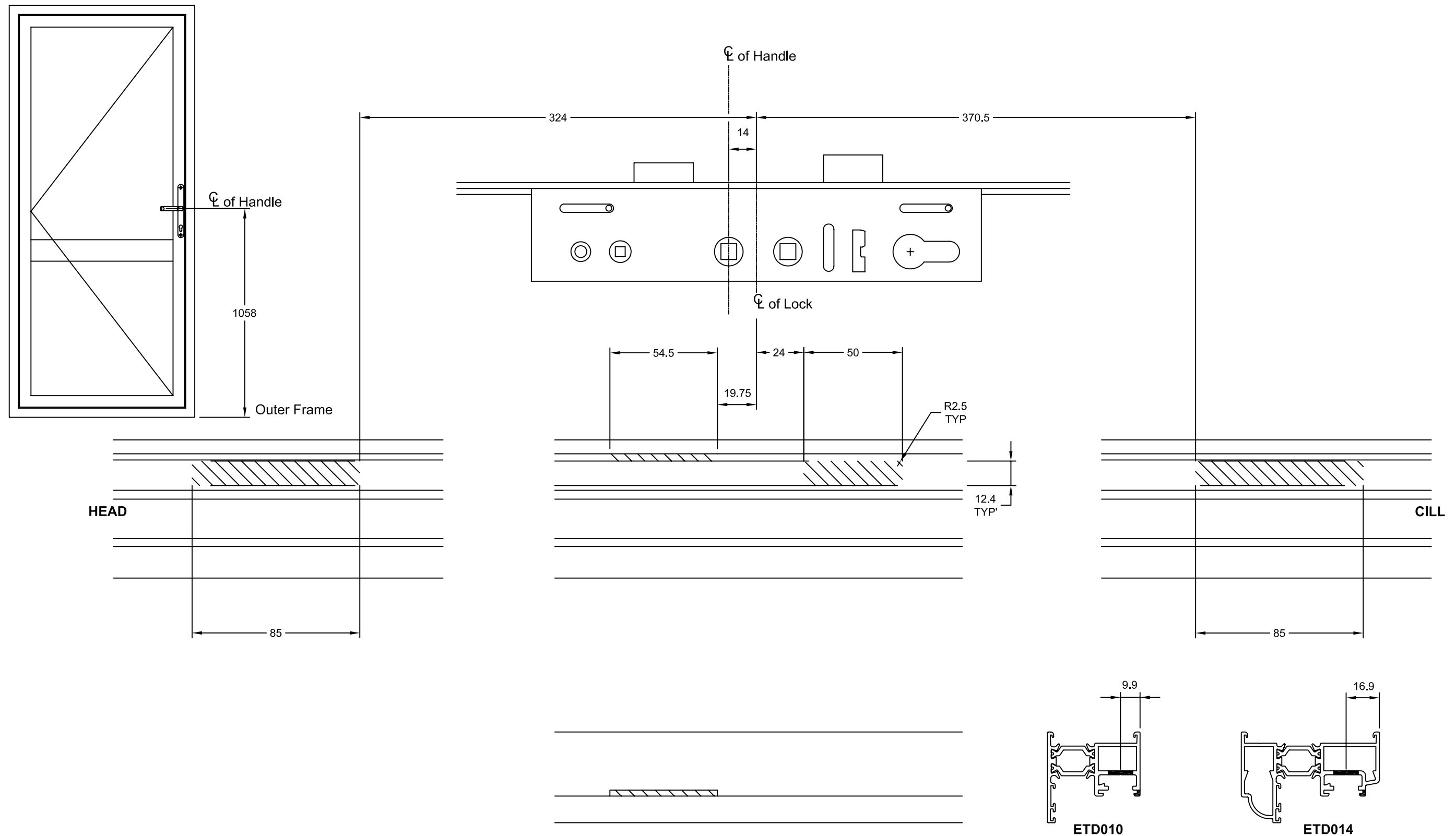
4j



4k

Open Out - Single Door (Short Lock) 35mm Backset/Outerframe Preparation

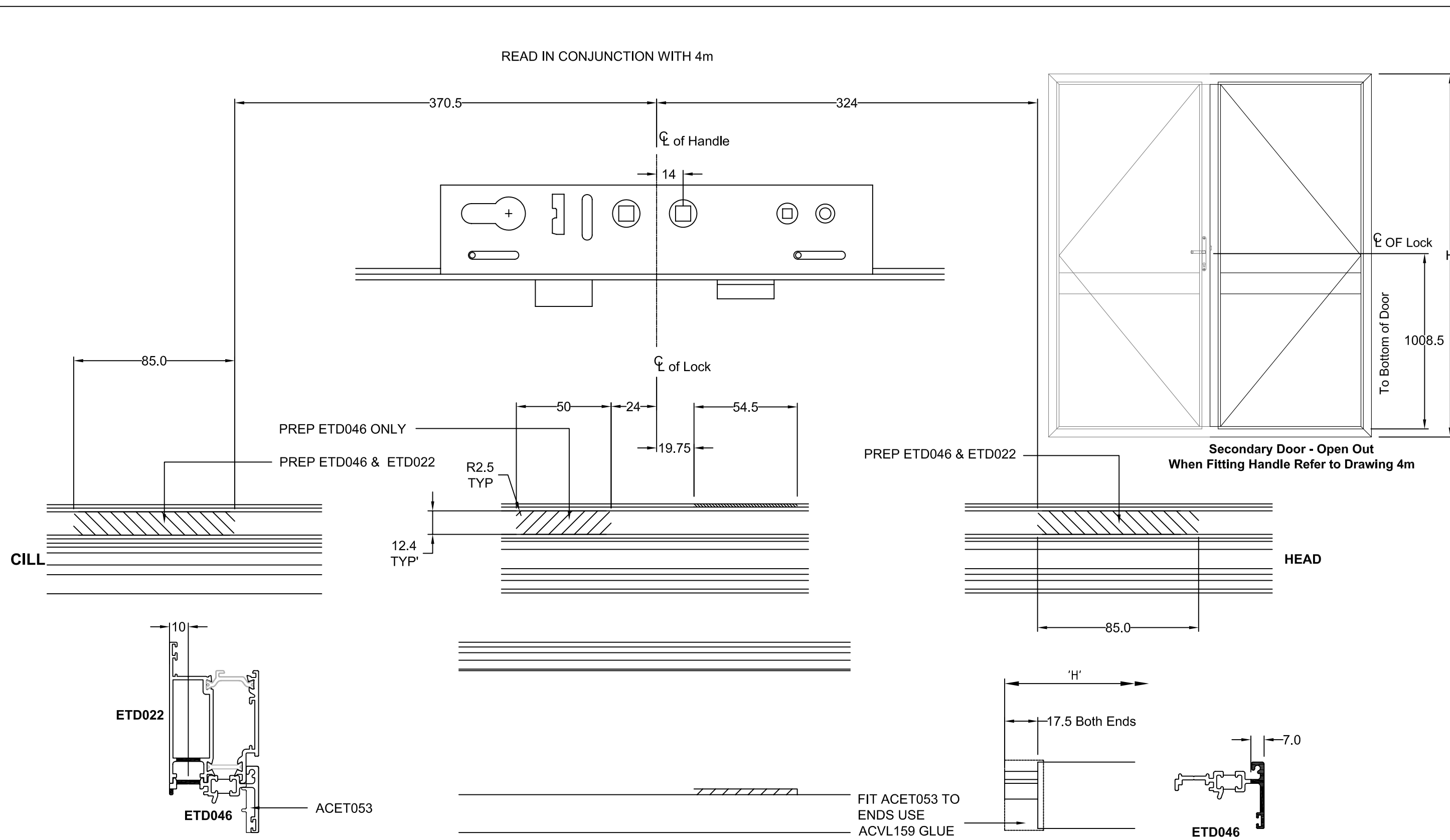
4k



4L

Open Out - Double Door Secondary (Short Lock) 45mm backset / Door Leaf Preparation

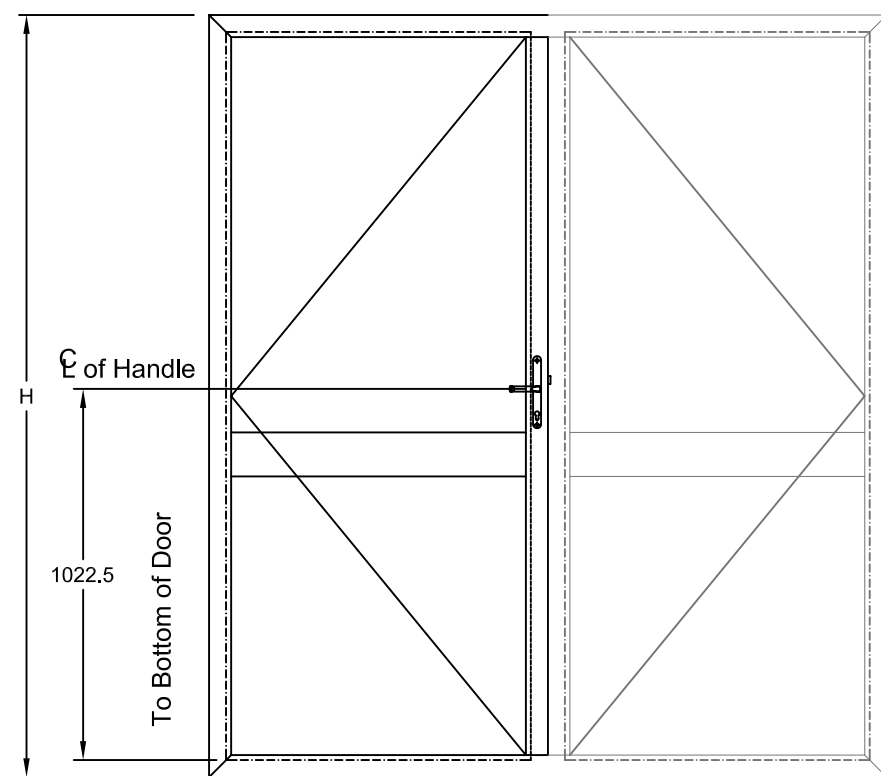
4L



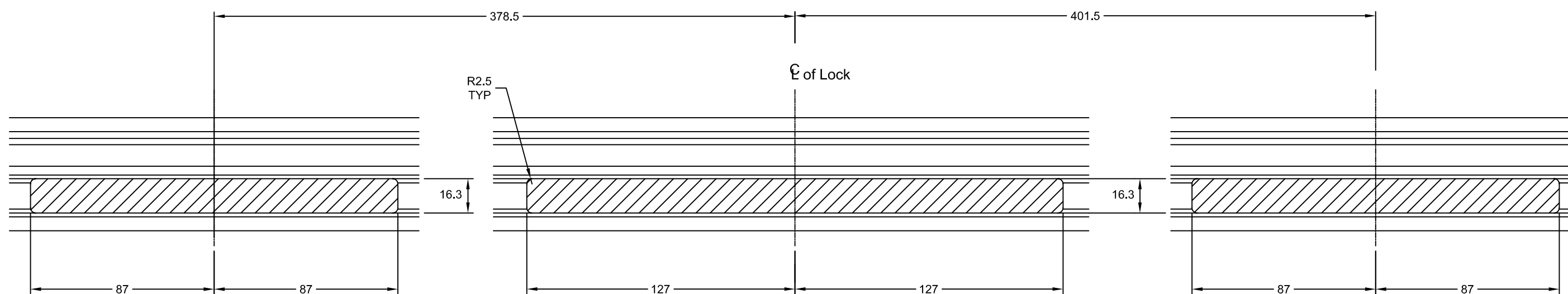
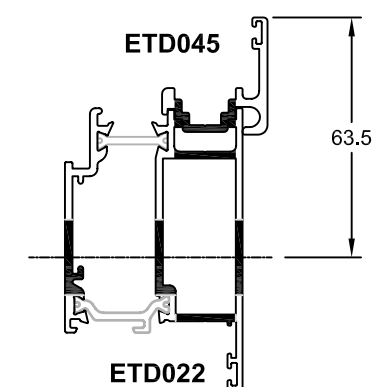
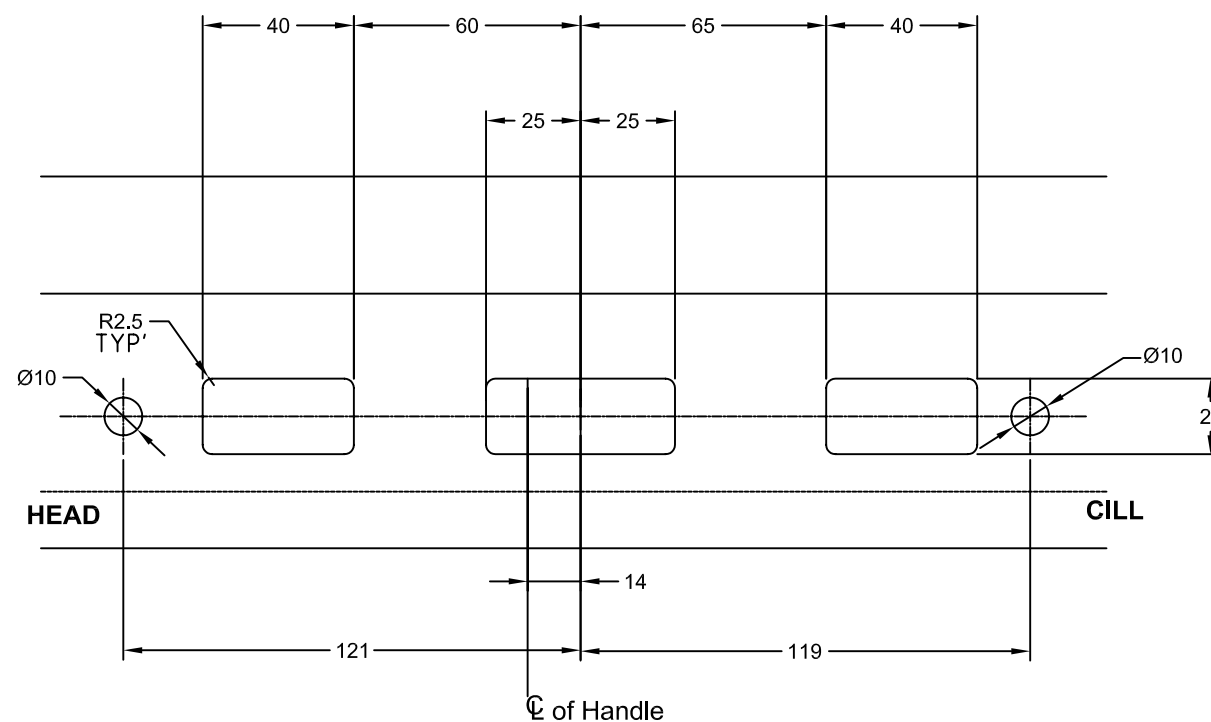
4m

Open Out - Double Door Primary (Short Lock) 45mm Backset / Door Leaf Preparation

4m



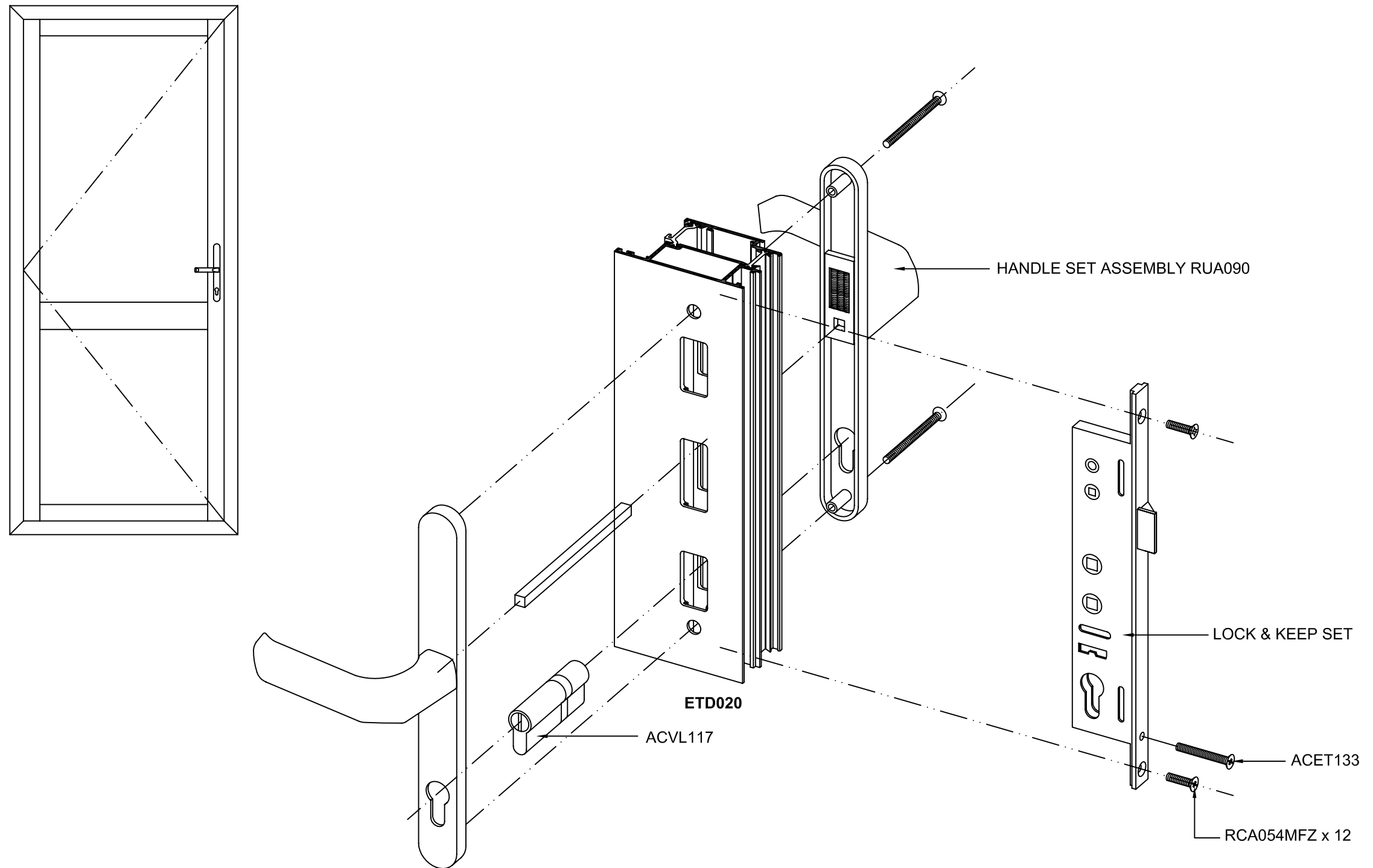
Primary Door - Open Out



4n

Open Out - Lock & Keep Set

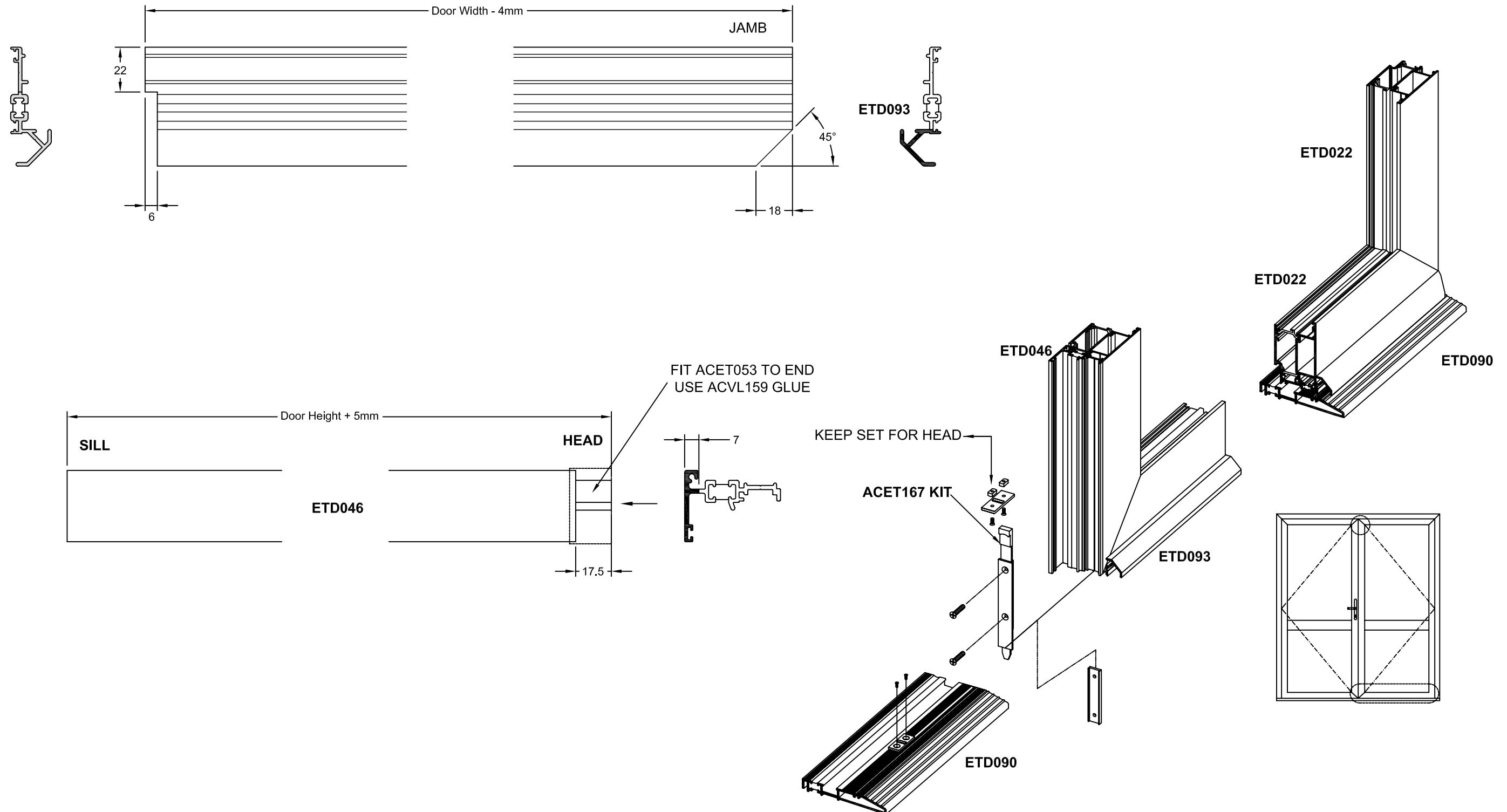
4n



4p

Open Out - Secondary Door (Low Threshold)

4p

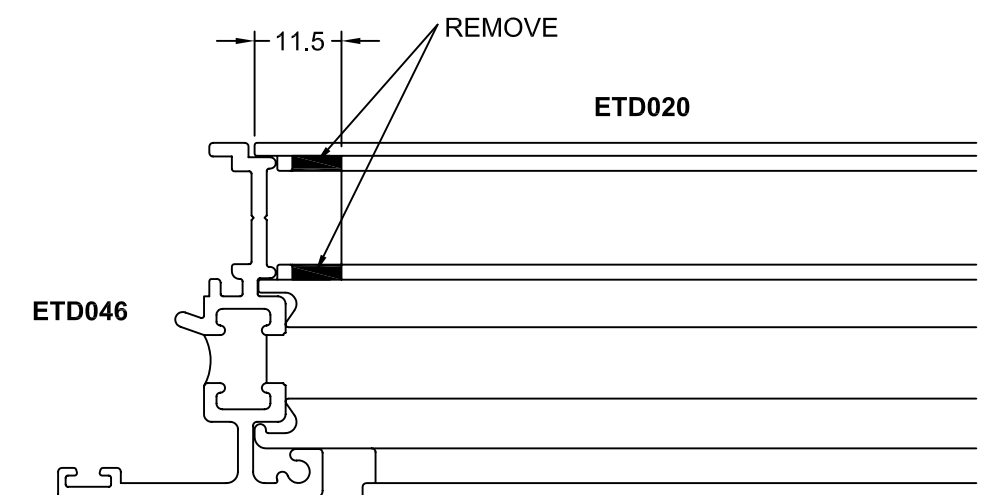
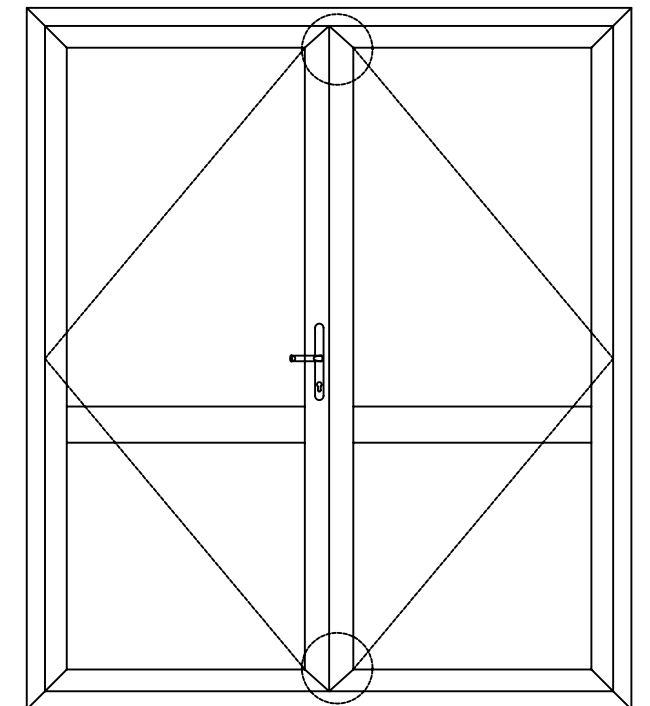
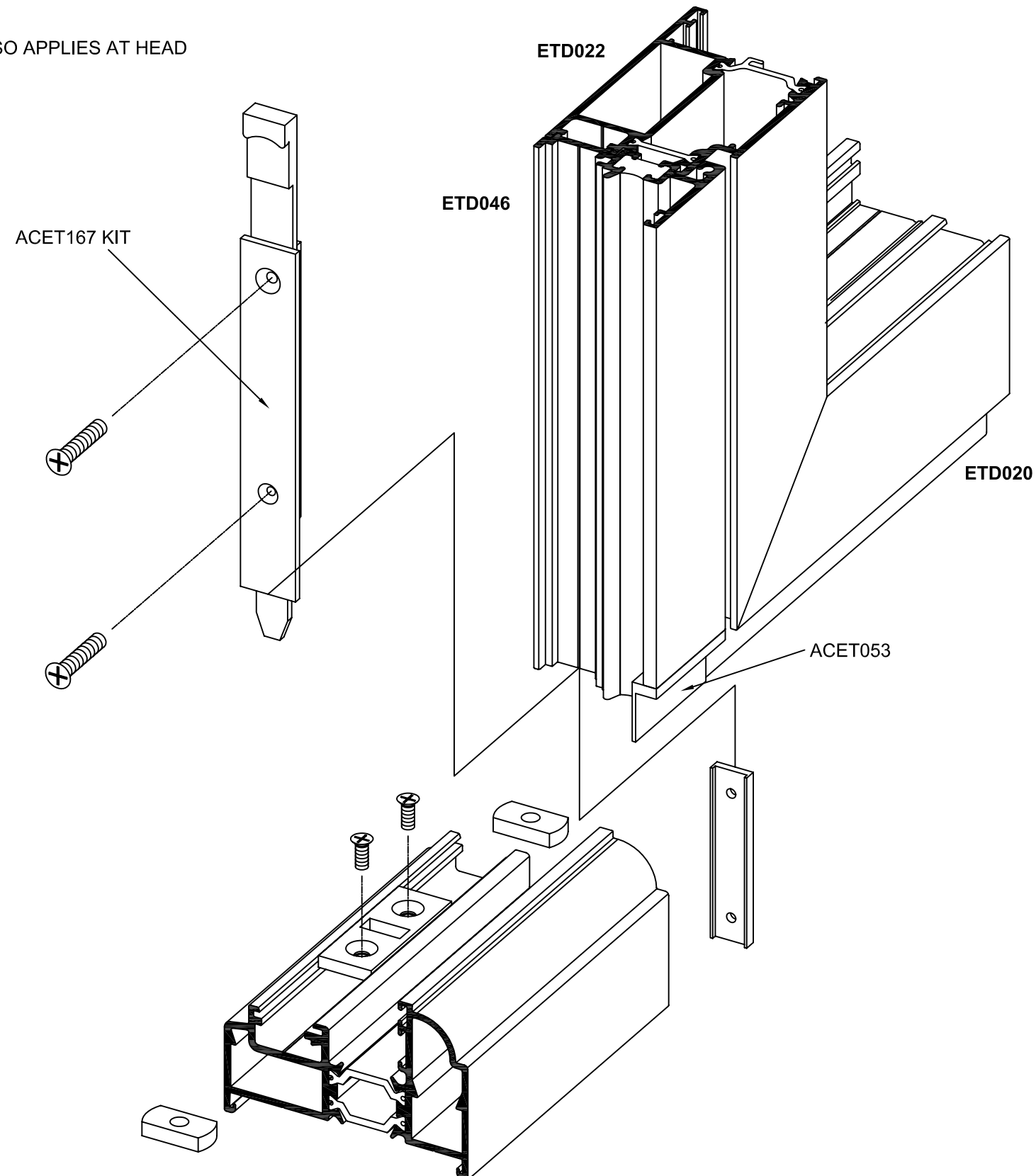


4q

Open Out - Double Door Secondary - Prep Top & Bottom as Shown on Secondary Door

4q

THIS ALSO APPLIES AT HEAD

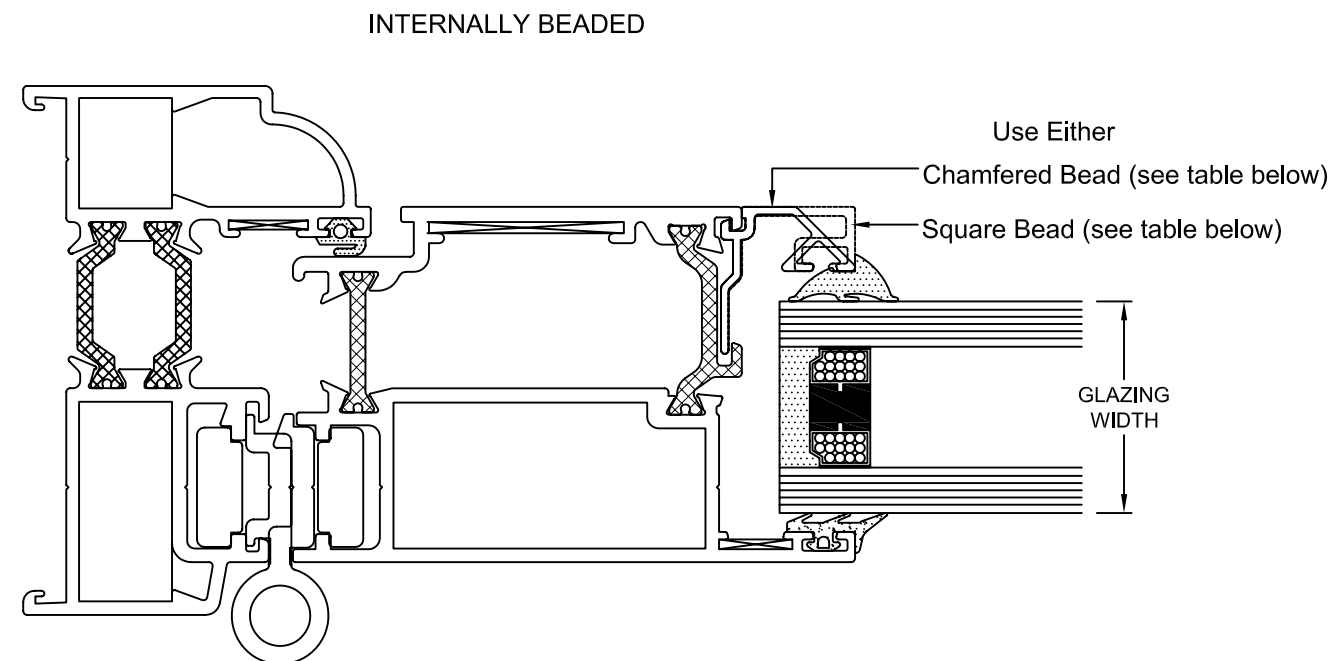


PREP-TOP & BOTTOM AS SHOWN
ON SECONDARY DOOR

5a

Open Out - Glazing Preparation

5a



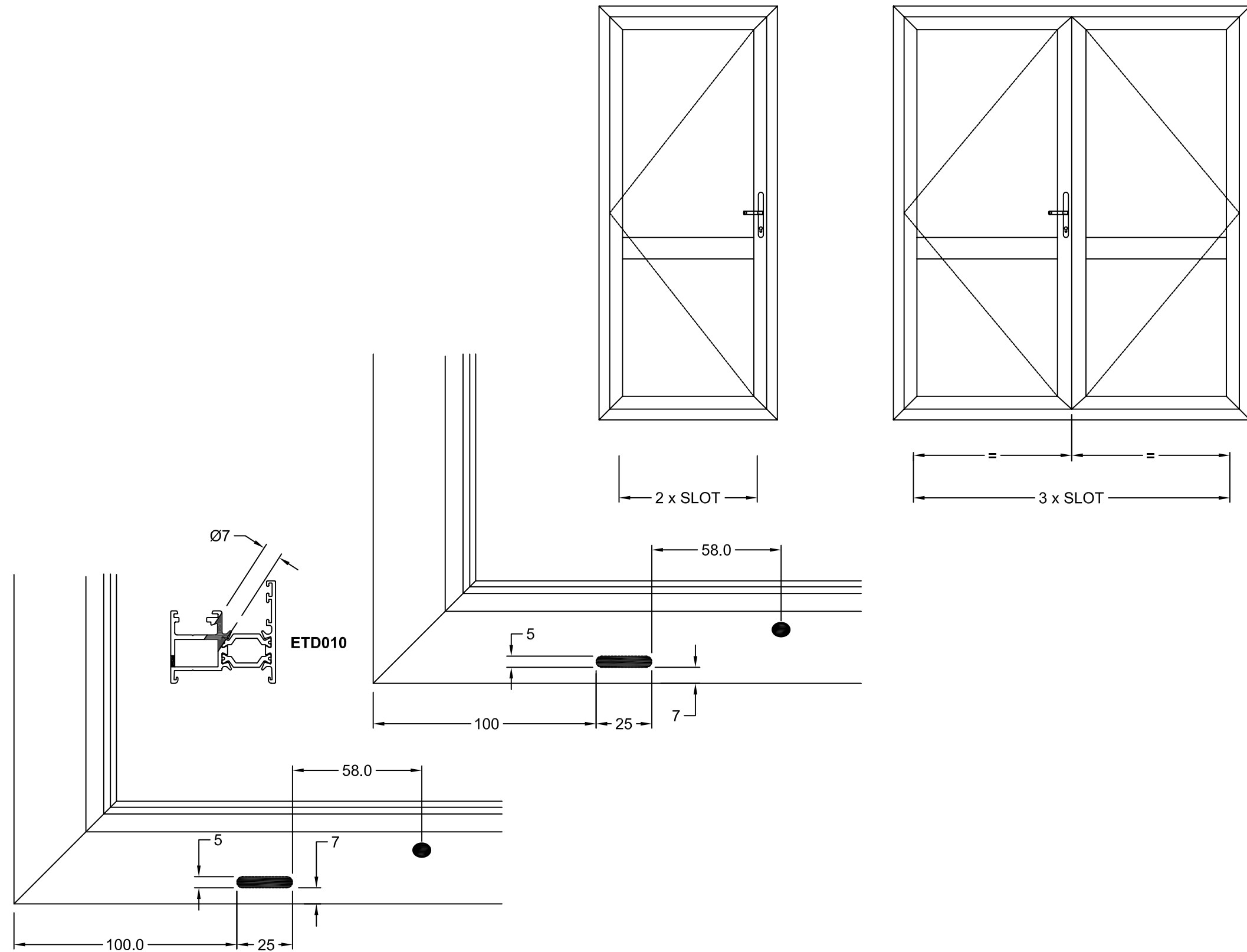
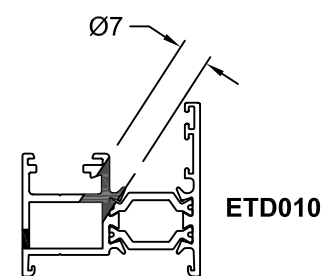
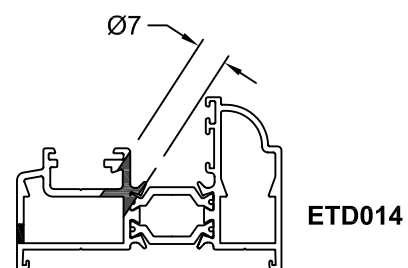
24mm		28mm		32mm	
BEADS	GASKET	BEADS	GASKET	BEADS	GASKET
ETC162	ACVG31 ACVG34	ETC161	ACVG31 ACVG34	ETC160	ACVG31 ACVG34
ETC163	ACVG31 ACVG34	ETC164	ACVG31 ACVG34		

6a

Open Out - Drainage

6a

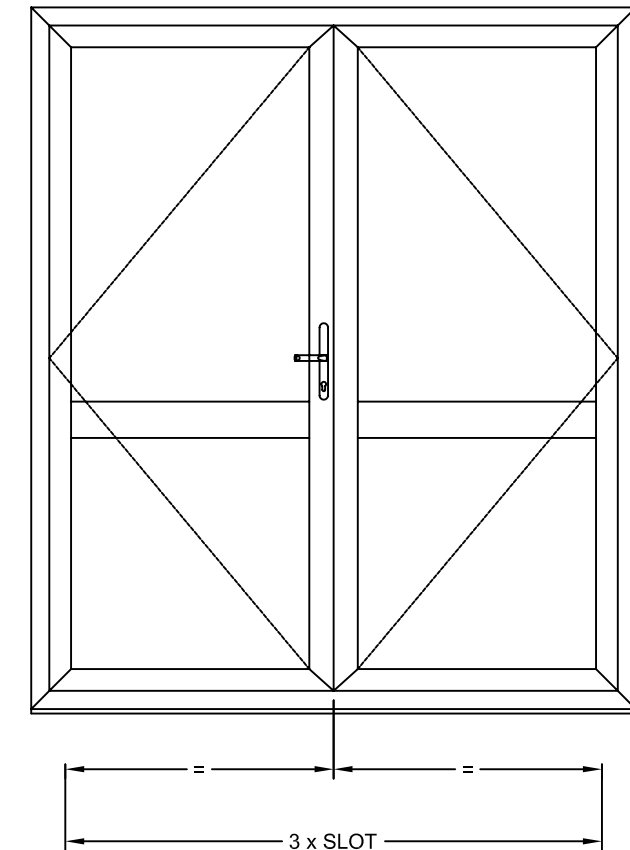
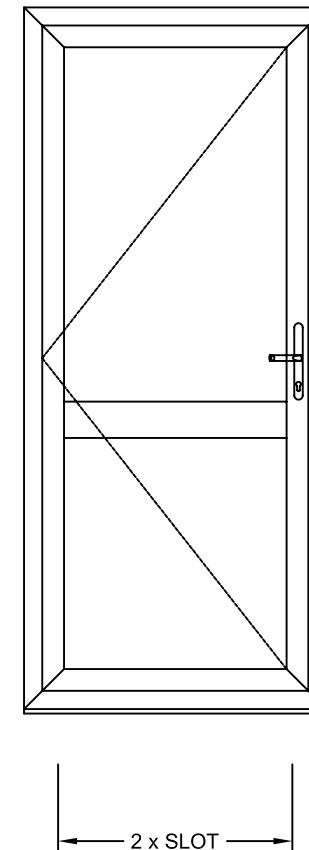
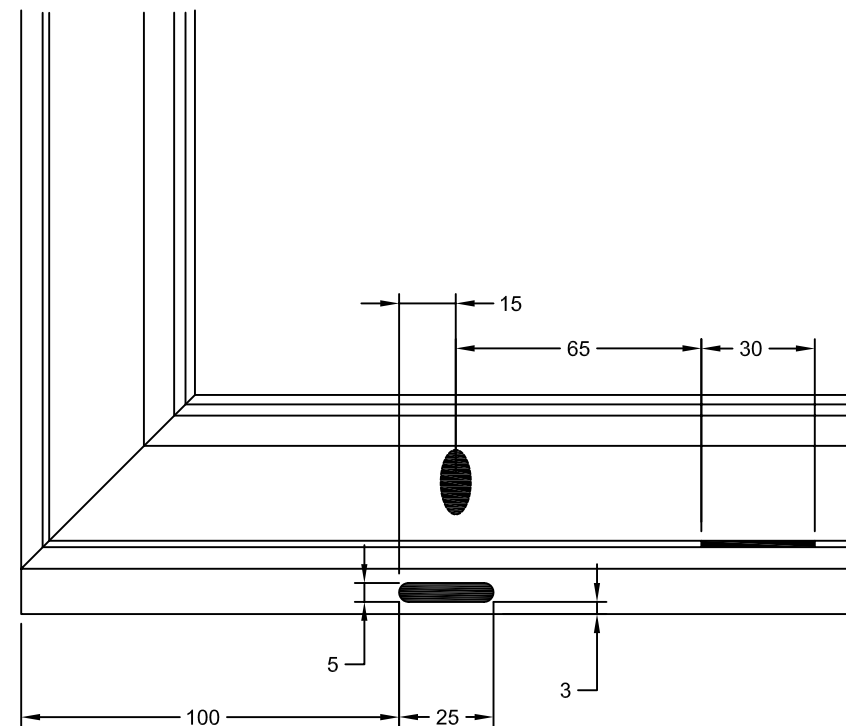
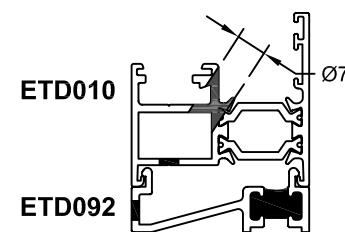
To ensure accuracy use
recommended
Drill Jig - ACET939



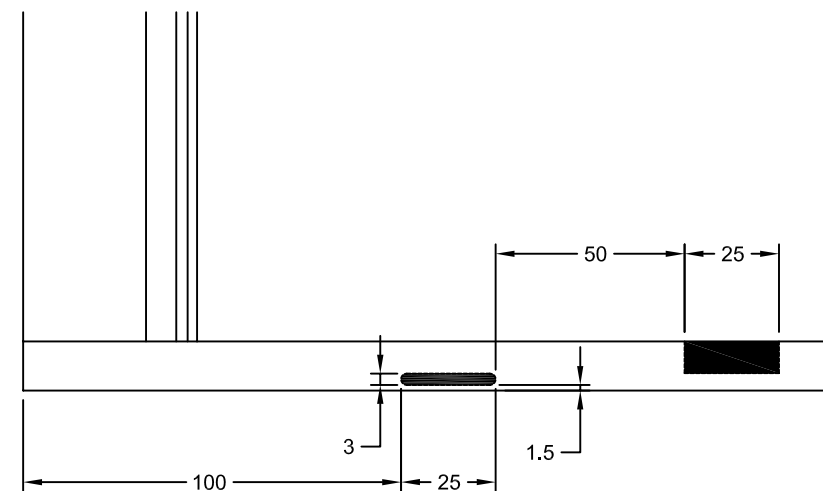
6b

Open Out - Drainage

6b



PLEASE ENSURE THIS OPERATION IS DONE BEFORE
ASSEMBLING OUTER FRAME



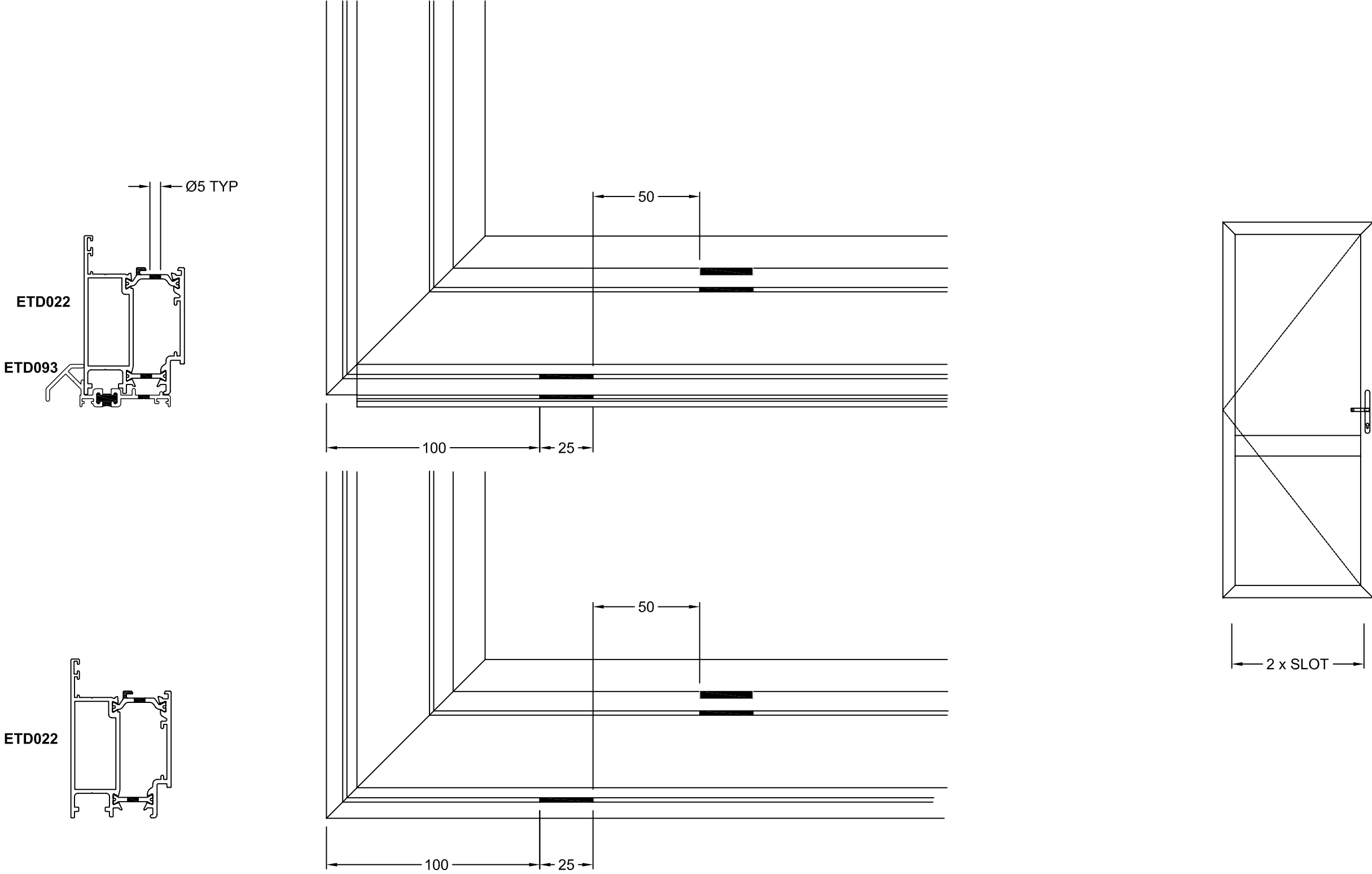
Construction Drawing

Drawing Number: eETD-47-31-00

6c

Open Out - Drainage

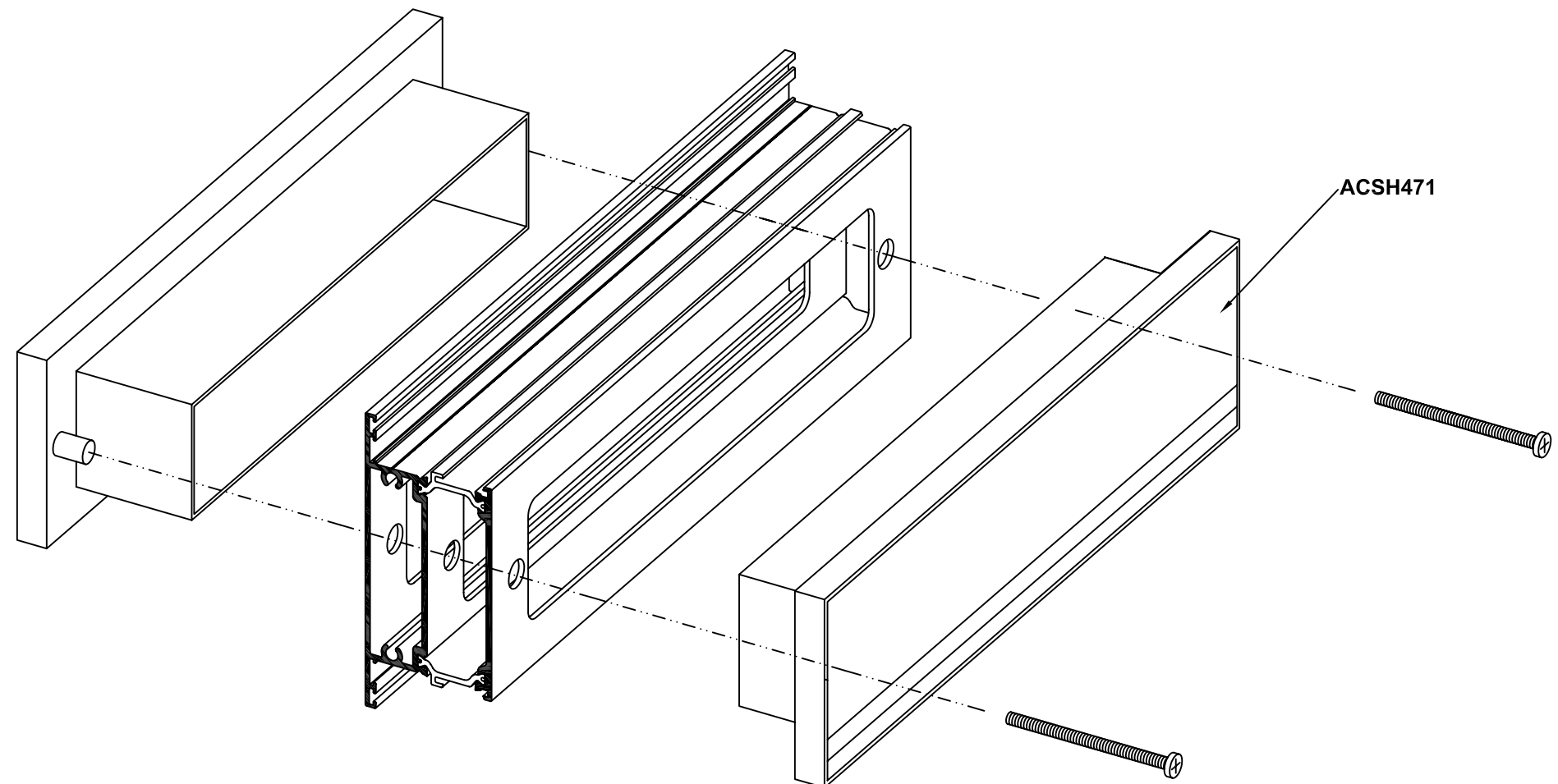
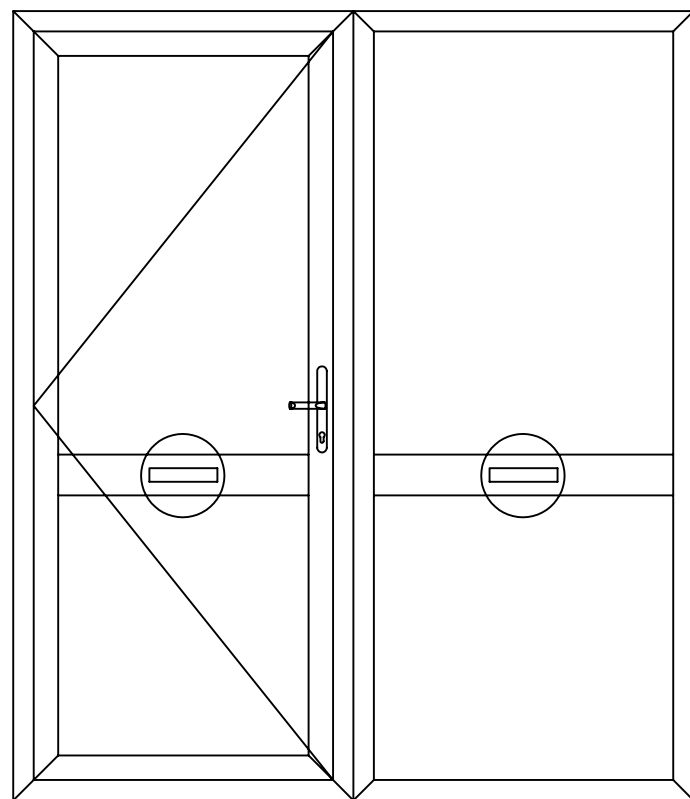
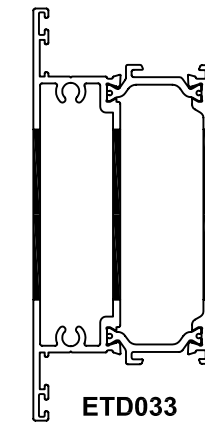
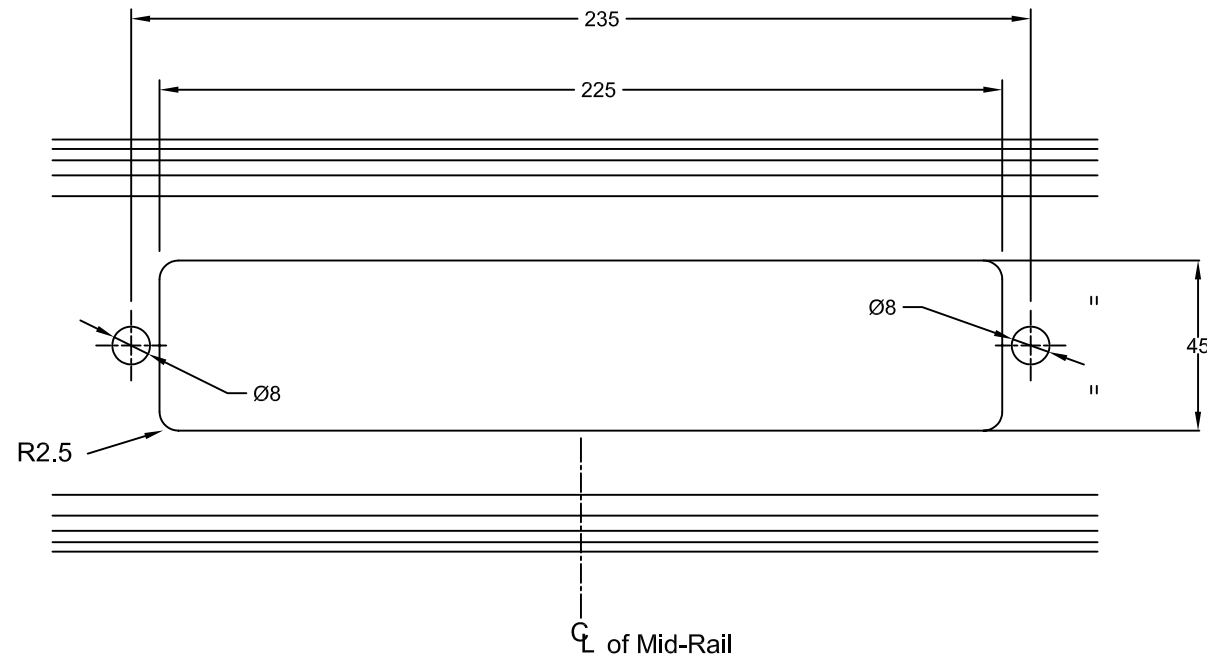
6c



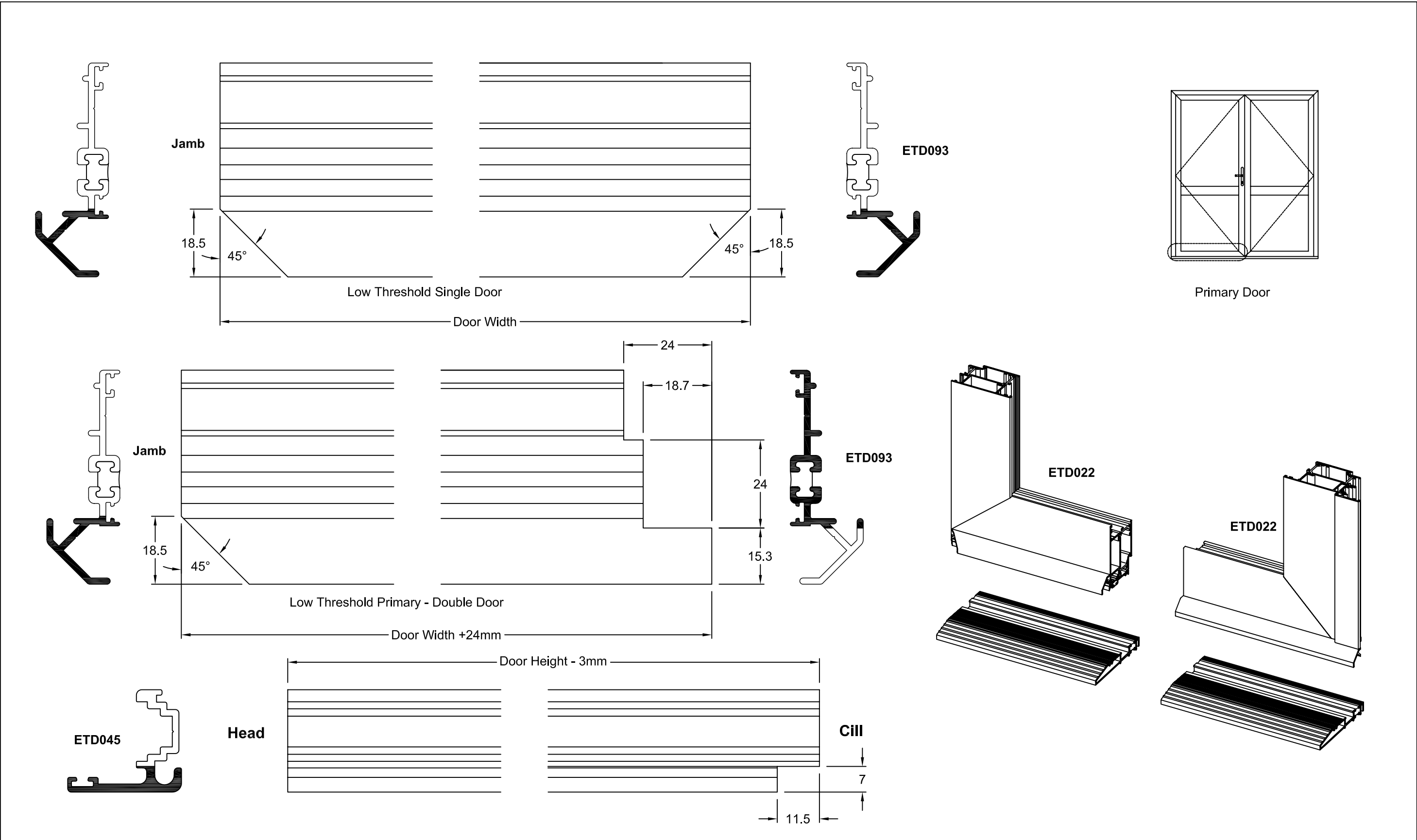
7a

Open Out - Letter Plate Set

7a



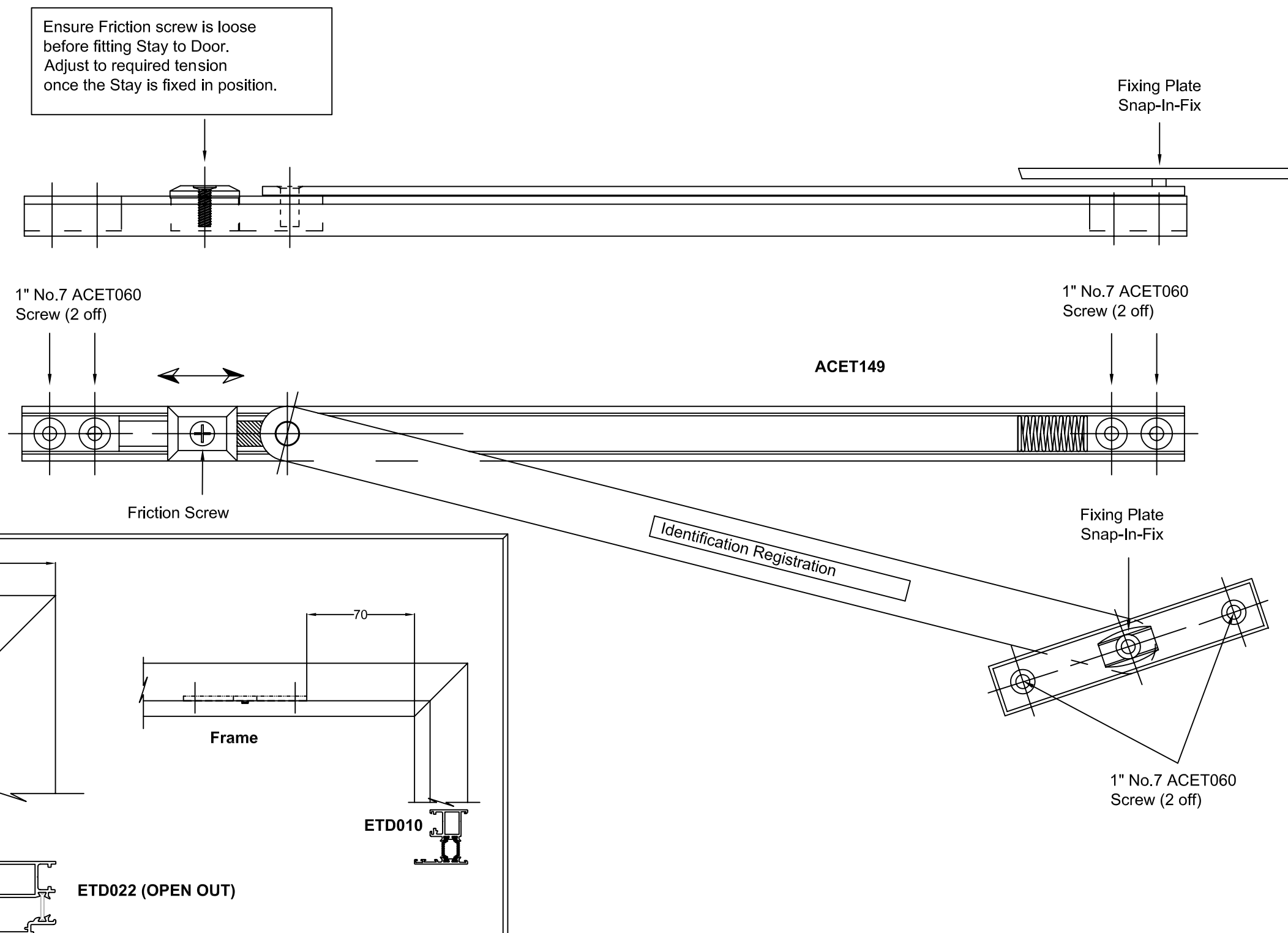
7b	Open Out - Single / Primary Double Door (Low Threshold)	7b
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7c

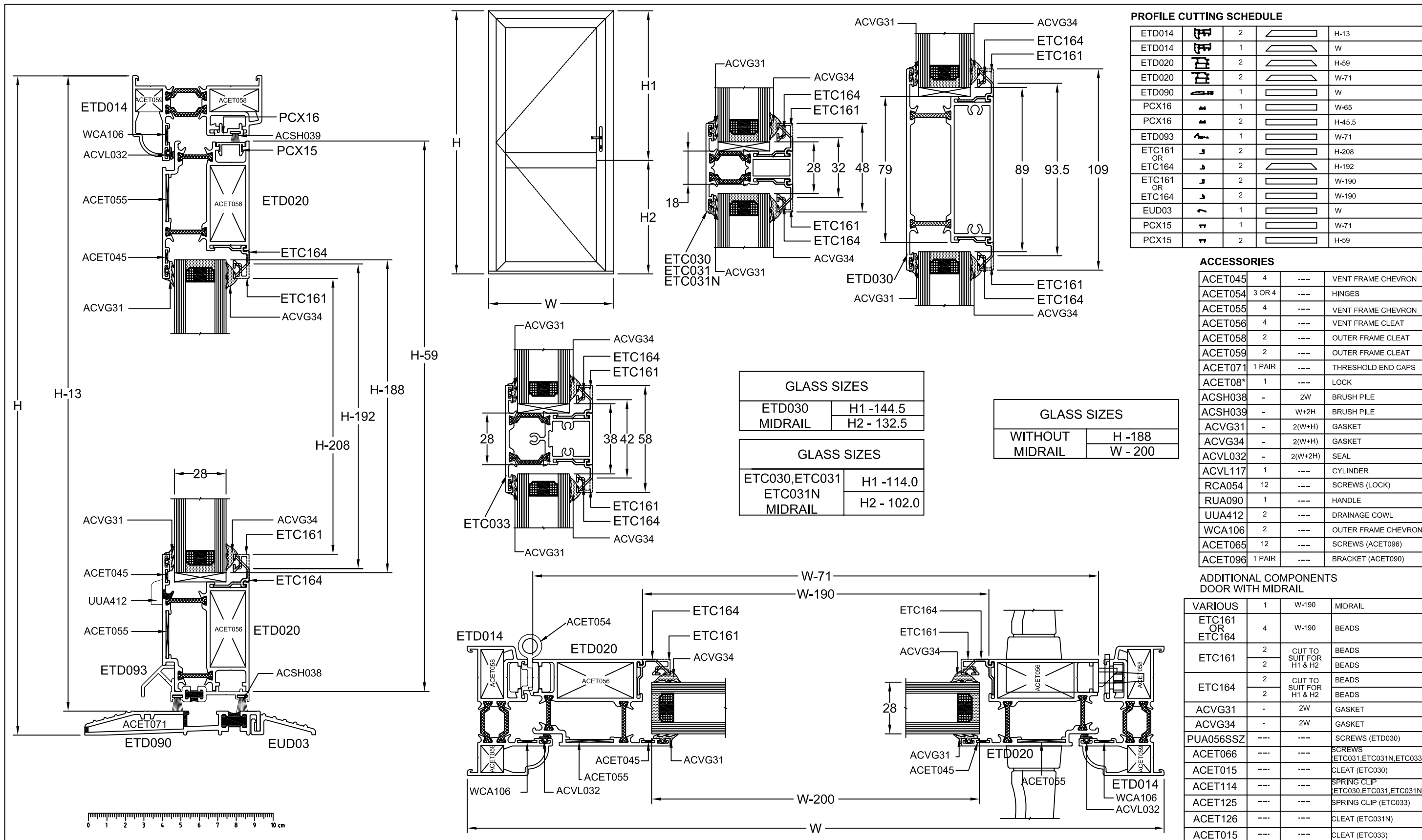
Open Out - Slimline Restrictor

7c



1a

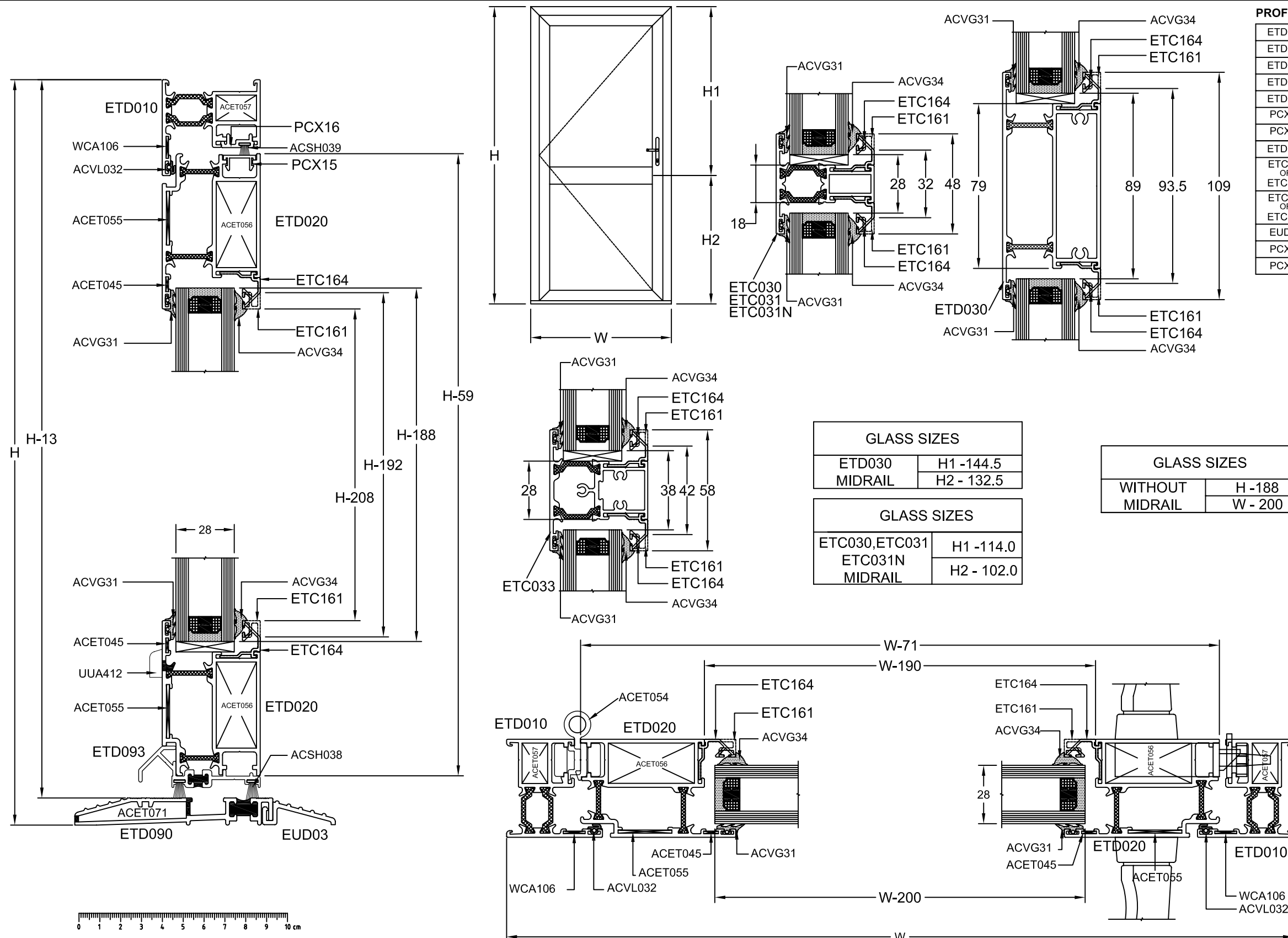
Open In (Low Threshold) 1a



2a

Open In (Low Threshold)

2a



PROFILE CUTTING SCHEDULE

ETD010		2		H-13
ETD010		1		W
ETD020		2		H-59
ETD020		2		W-71
ETD090		1		W
PCX16		1		W-65
PCX16		2		H-45.5
ETD093		1		W-71
ETC161 OR ETC164		2		H-208
ETC161 OR ETC164		2		H-192
ETC161 OR ETC164		2		W-190
ETC161 OR ETC164		2		W-190
EUD03		1		W
PCX15		1		W-71
PCX15		2		H-59

ACCESSORIES

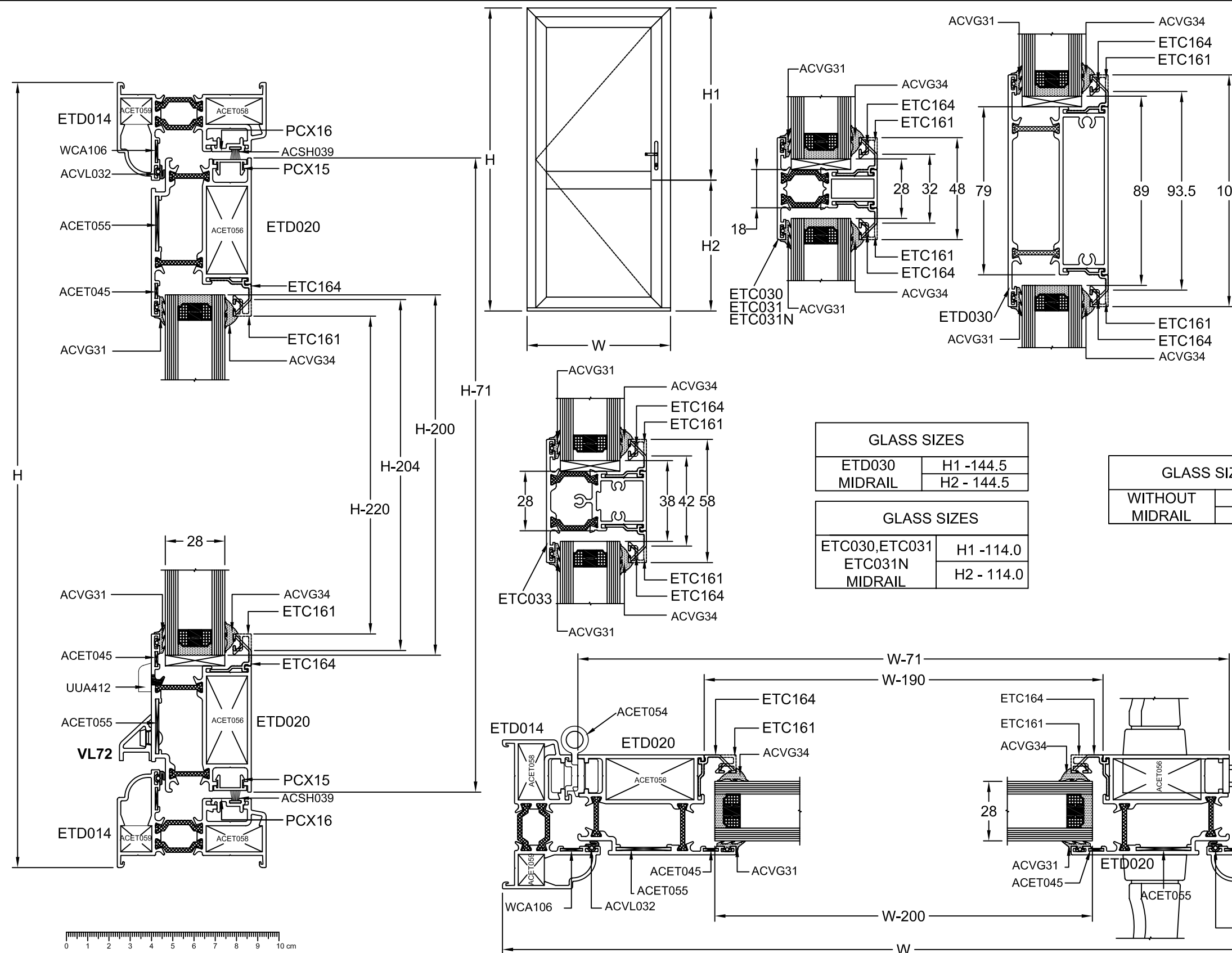
ACET045	4	----	VENT FRAME CHEVRON
ACET054	3 OR 4	----	HINGES
ACET055	4	----	VENT FRAME CHEVRON
ACET056	4	----	VENT FRAME CLEAT
ACET057	2	----	OUTER FRAME CLEAT
ACET071	1 PAIR	----	THRESHOLD END CAPS
ACET08*	1	----	LOCK
ACSH038	-	2W	BRUSH PILE
ACSH039	-	W+2H	BRUSH PILE
ACVG31	-	2(W+H)	GASKET
ACVG34	-	2(W+H)	GASKET
ACVL032	-	2(W+2H)	SEAL
ACVL117	1	----	CYLINDER
RCA054	12	----	SCREWS (LOCK)
RUA090	1	----	HANDLE
UUA412	2	----	DRAINAGE COWL
WCA106	2	----	OUTER FRAME CHEVRON
ACET065	12	----	SCREWS (ACET096)
ACET096	1 PAIR	----	BRACKET (ACET090)

ADDITIONAL COMPONENTS
DOOR WITH MIDRAIL

VARIOUS	---	W-190	MIDRAIL
ETC161 OR ETC164	4	W-190	BEADS
ETC161	2	CUT TO SUIT FOR H1 & H2	BEADS
	2		BEADS
ETC164	2	CUT TO SUIT FOR H1 & H2	BEADS
	2		BEADS
ACVG31	-	2W	GASKET
ACVG34	-	2W	GASKET
PUA056SSZ	----	----	SCREWS (ETD030)
ACET066	----	----	SCREWS (ETC031, ETC031N, ETC033)
ACET015	----	----	CLEAT (ETC030)
ACET114	----	----	SPRING CLIP (ETC030, ETC031, ETC031N)
ACET125	----	----	SPRING CLIP (ETC033)
ACET126	----	----	CLEAT (ETC031N)
ACET015	----	----	CLEAT (ETC033)

3a

Open In (Frame All Round) **3a**



PROFILE CUTTING SCHEDULE

ETD014		2		H
ETD014		2		W
ETD020		2		H-71
ETD020		2		W-71
PCX16		2		W-65
PCX16		2		H-65
VL72		1		W-106
ETC161 OR ETC164		2		H-220
ETC161 OR ETC164		2		H-204
ETC161 OR ETC164		2		W-190
ETC161 OR ETC164		2		W-190
PCX15		2		W-71
PCX15		2		H-71
VL72		1		W-110

ACCESSORIES

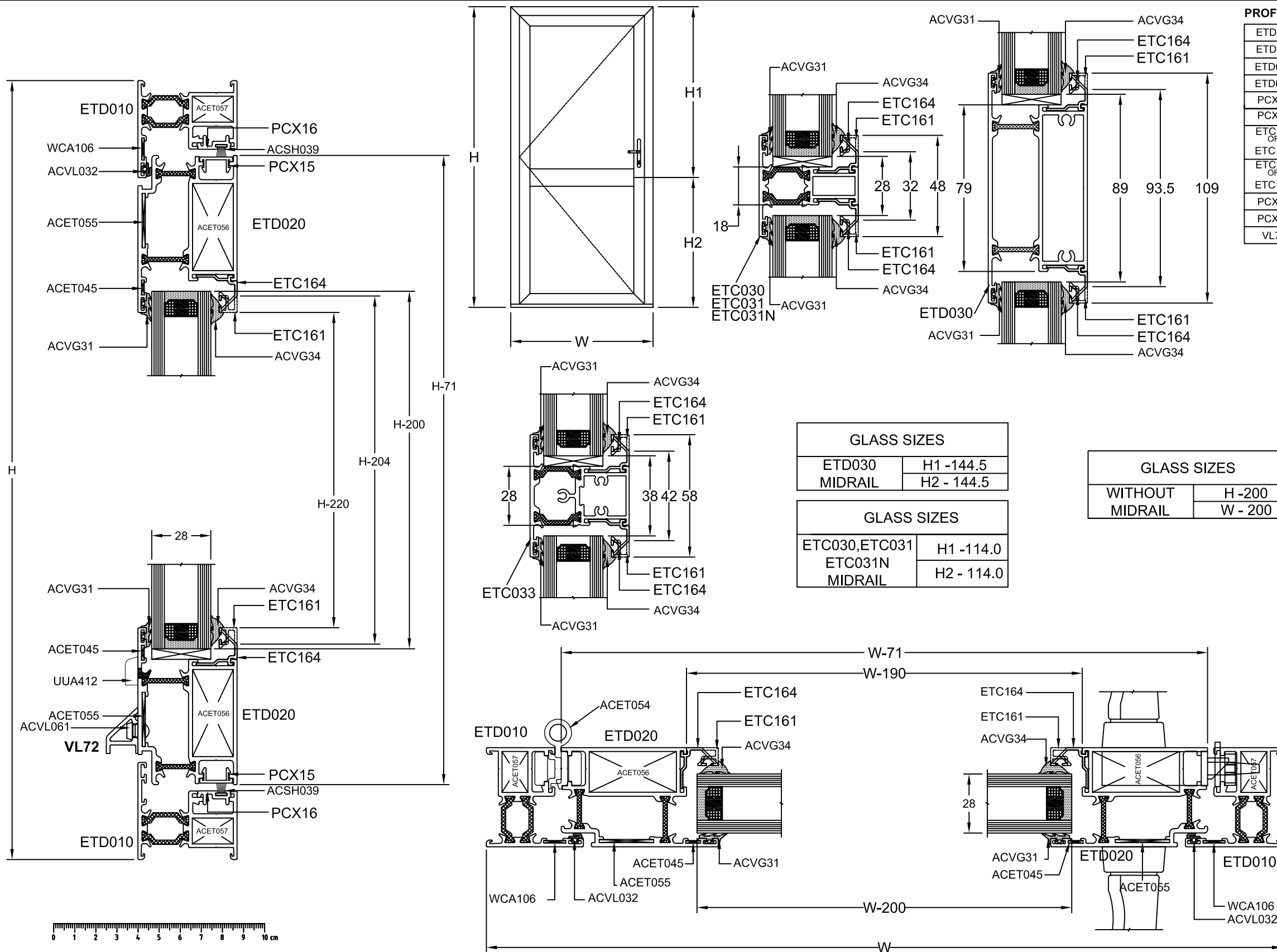
ACET045	4	----	VENT FRAME CHEVRON
ACET054	3 OR 4	----	HINGES
ACET055	4	----	VENT FRAME CHEVRON
ACET056	4	----	VENT FRAME CLEAT
ACET058	4	----	OUTER FRAME CLEAT
ACET059	4	----	OUTER FRAME CLEAT
ACET08*	1	----	LOCK
ACSH039	-	2(W+H)	BRUSH PILE
ACVG31	-	2(W+H)	GASKET
ACVG34	-	2(W+H)	GASKET
ACVL032	-	2(W+H)	SEAL
ACVL059	1 Pair	----	END CAP
ACVL061	-	W/300	RIVETS
ACVL117	1	----	CYLINDER
RCA054	12	----	SCREWS
RUA090	1	----	HANDLE
UUA412	2	----	DRAINAGE COWL
WCA106	4	----	OUTER FRAME CHEVRON

ADDITIONAL COMPONENTS DOOR WITH MIDRAIL			
VARIOUS	---	W-190	MIDRAIL
ETC161 OR ETC164	4	W-190	BEADS
ETC161	2	CUT TO SUIT FOR H1 & H2	BEADS
	2		BEADS
ETC164	2	CUT TO SUIT FOR H1 & H2	BEADS
	2		BEADS
ACVG31	-	2W	GASKET
ACVG34	-	2W	GASKET
PUA056SSZ	----	----	SCREWS (ETD030)
ACET066	----	----	SCREWS (ETC031,ETC031N,ETC033)
ACET015	----	----	CLEAT (ETC030)
ACET114	----	----	SPRING CLIP (ETC030,ETC031,ETC031N)
ACET125	----	----	SPRING CLIP (ETC033)
ACET126	----	----	CLEAT (ETC031N)
ACET015	----	----	CLEAT (ETC033)

4a

Open In (Frame All Round)

4a



PROFILE CUTTING SCHEDULE

ETD010		2		H
ETD010		2		W
ETD020		2		H-71
ETD020		2		W-71
PCX16		2		W-65
PCX16		2		H-65
ETC161 OR ETC164		2		H-220
ETC161 OR ETC164		2		H-204
ETC161 OR ETC164		2		W-190
ETC161 OR ETC164		2		W-190
PCX15		2		W-71
PCX15		2		H-71
VL72		1		W-110

ACCESSORIES

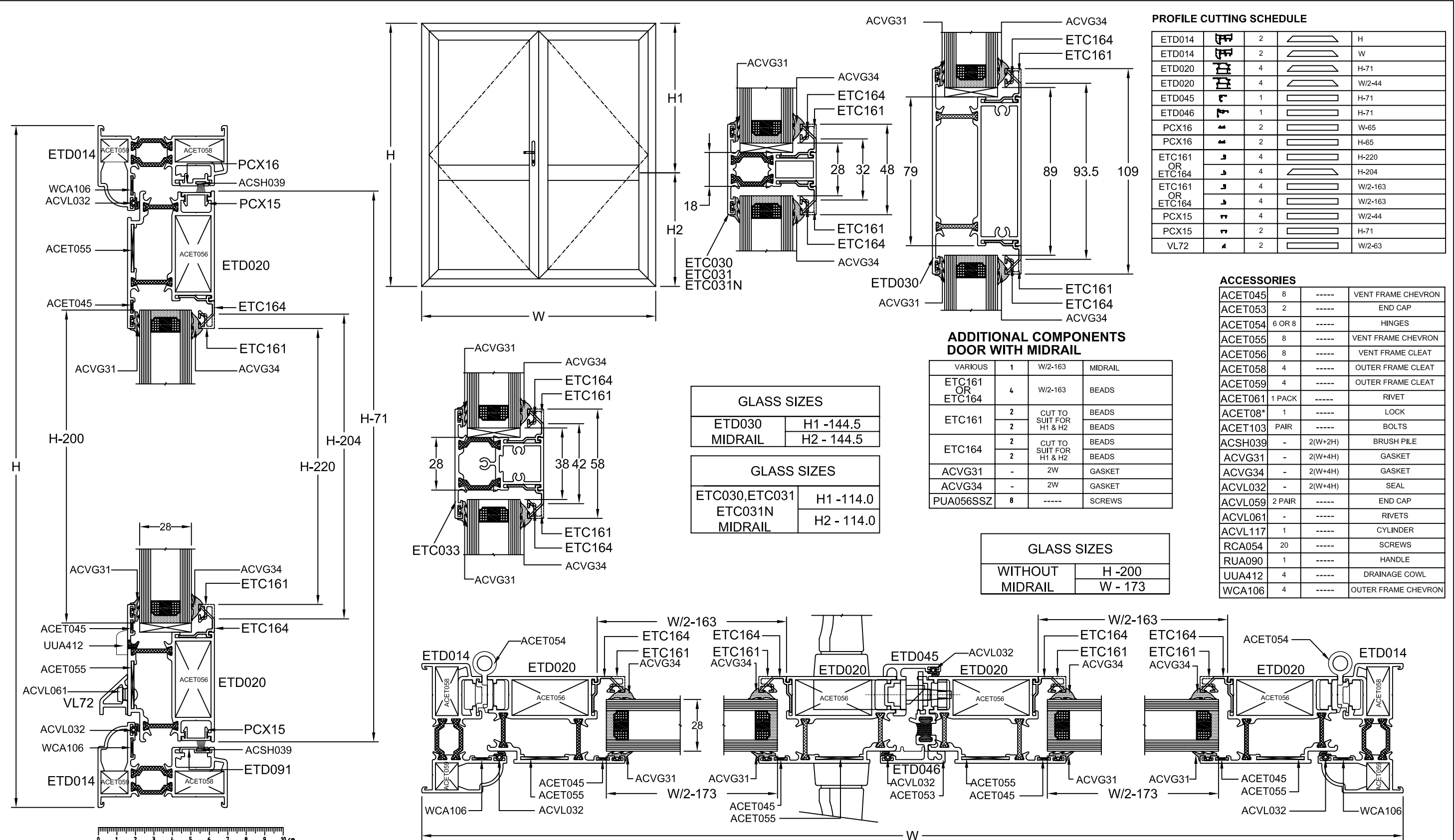
ACET045	4	----	VENT FRAME CHEVRON
ACET054	3 OR 4	----	HINGES
ACET055	4	----	VENT FRAME CHEVRON
ACET056	4	----	VENT FRAME CLEAT
ACET057	2	----	OUTER FRAME CLEAT
ACET08*	1	----	LOCK
ACSH039	-	W+2H	BRUSH FILE
ACVG31	-	2(W+H)	GASKET
ACVG34	-	2(W+H)	GASKET
ACVL032	-	2(W+2H)	SEAL
ACVL117	1	----	CYLINDER
RCA054	12	----	SCREWS (LOCK)
RUA090	1	----	HANDLE
UUA412	2	----	DRAINAGE COWL
WCA106	2	----	OUTER FRAME CHEVRON
ACET065	12	----	SCREWS (ACET096)
ACET096	1 PAIR	----	BRACKET (ACET090)
ACVL059	1 PAIR	----	END CAPS (VL72)
ACVL061	-	----	RIVETS

ADDITIONAL COMPONENTS
DOOR WITH MIDRAIL

VARIOUS	---	W-190	MIDRAIL
ETC161 OR ETC164	4	W-190	BEADS
ETC161	2	CUT TO SUIT FOR H1 & H2	BEADS
	2		BEADS
ETC164	2	CUT TO SUIT FOR H1 & H2	BEADS
	2		BEADS
ACVG31	-	2W	GASKET
ACVG34	-	2W	GASKET
PUA056SSZ	----	----	SCREWS (ETD030)
ACET066	----	----	SCREWS (ETC031, ETC031N, ETC033)
ACET015	----	----	CLEAT (ETC030)
ACET114	----	----	SPRING CLIP (ETC030, ETC031, ETC031N)
ACET125	----	----	SPRING CLIP (ETC033)
ACET126	----	----	CLEAT (ETC031N)
ACET015	----	----	CLEAT (ETC033)

5a

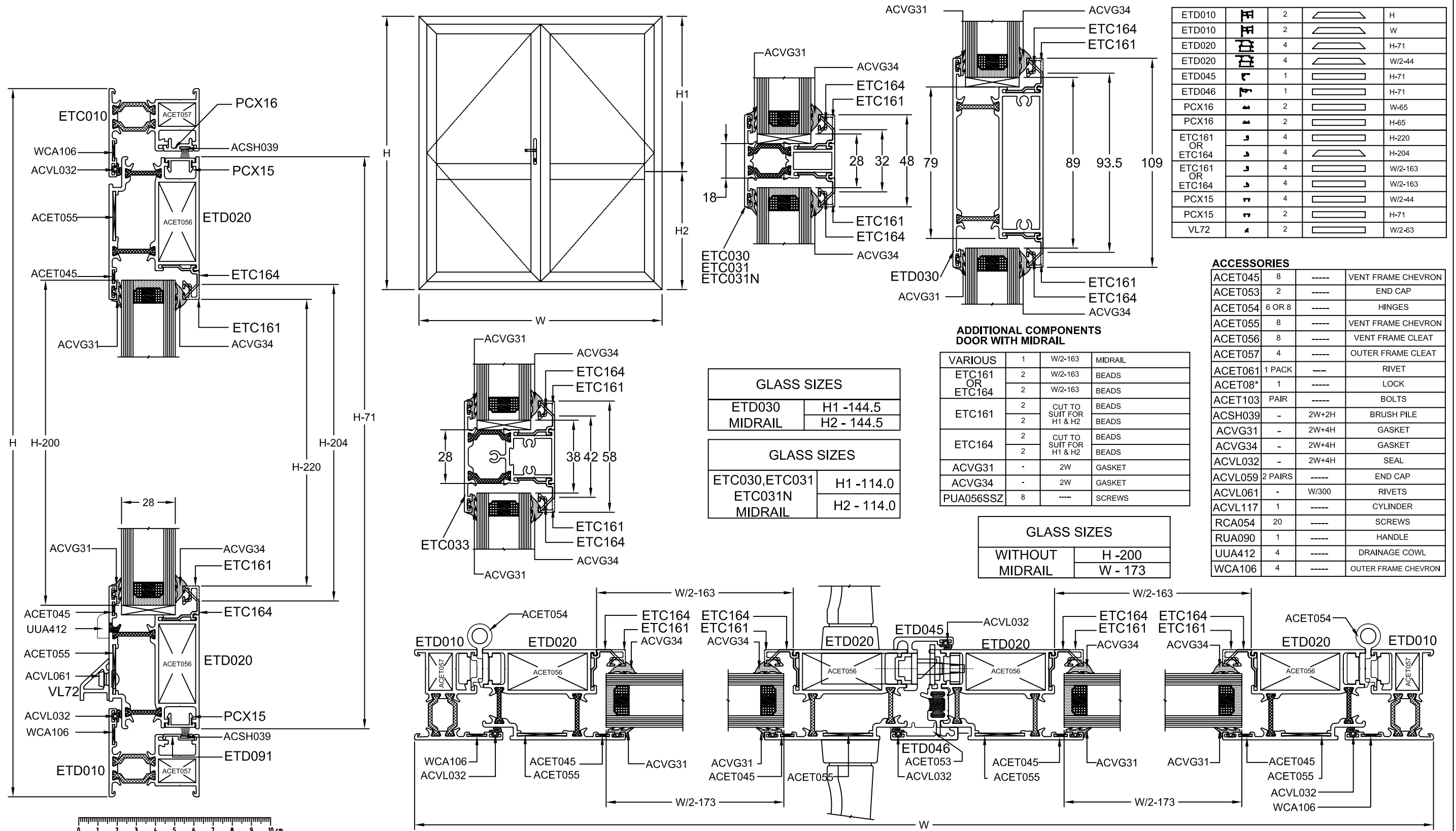
Open In (Frame All Round) 5a

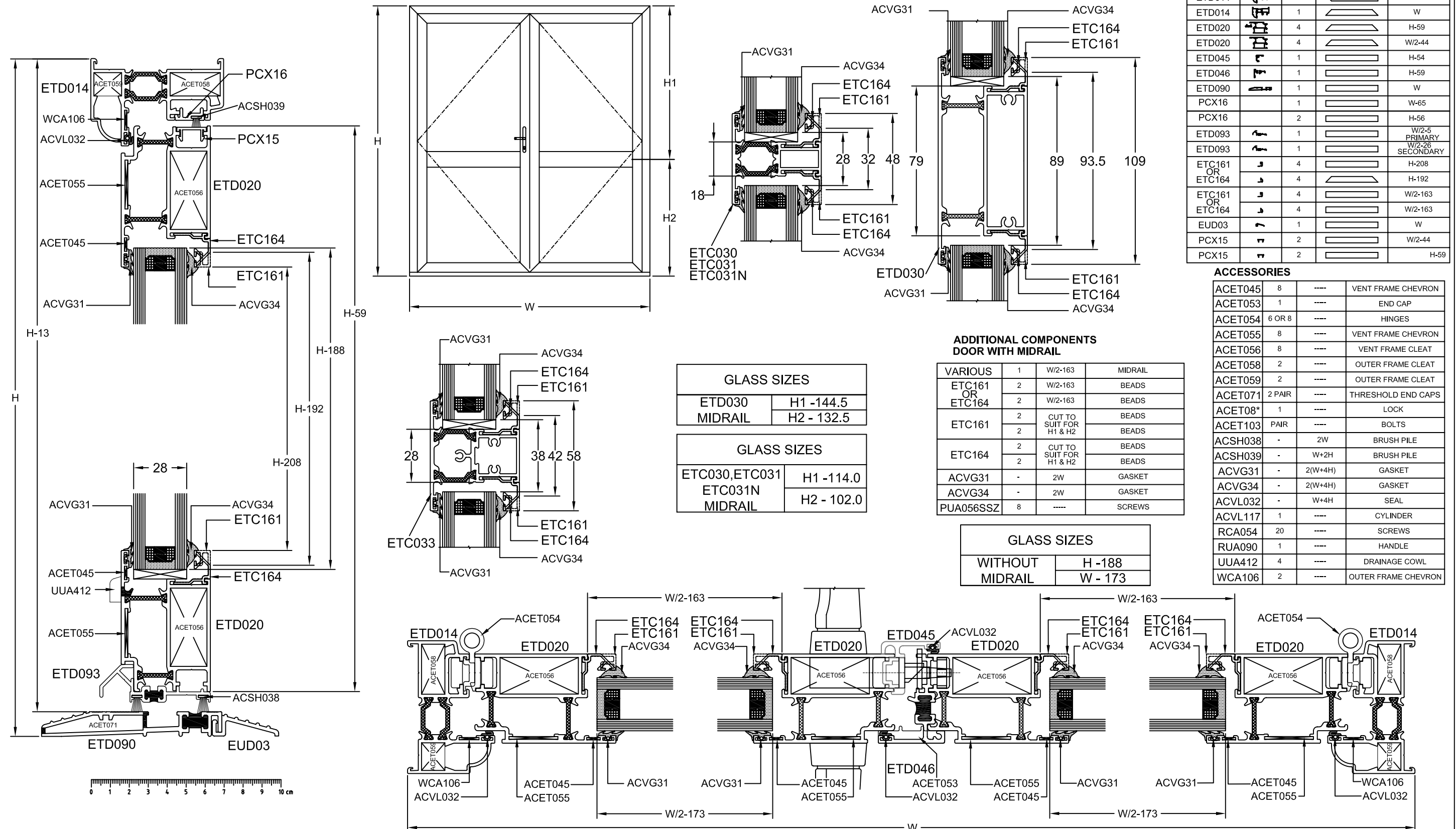


6a

Open In (Frame All Round)

6a

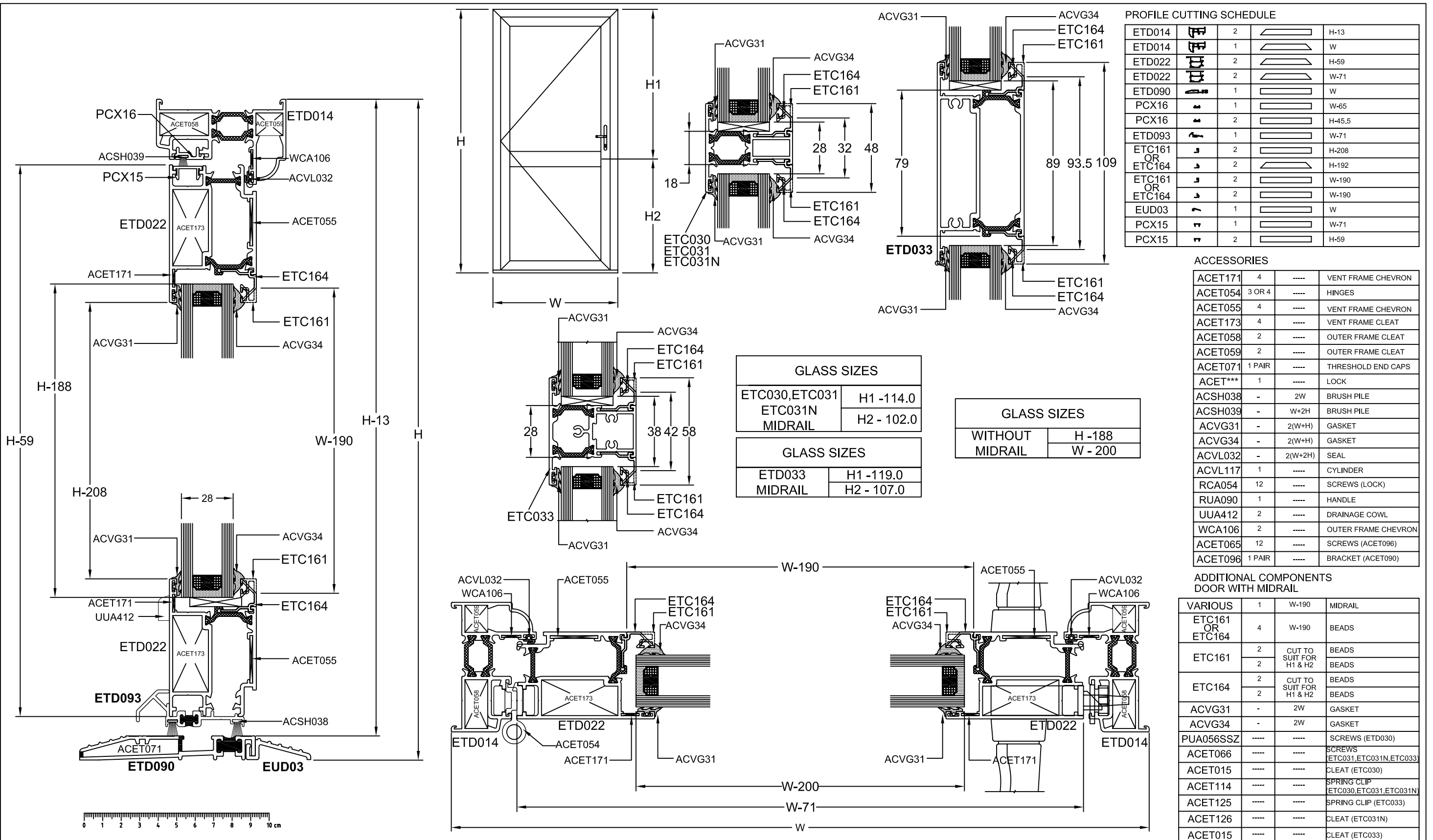




1a

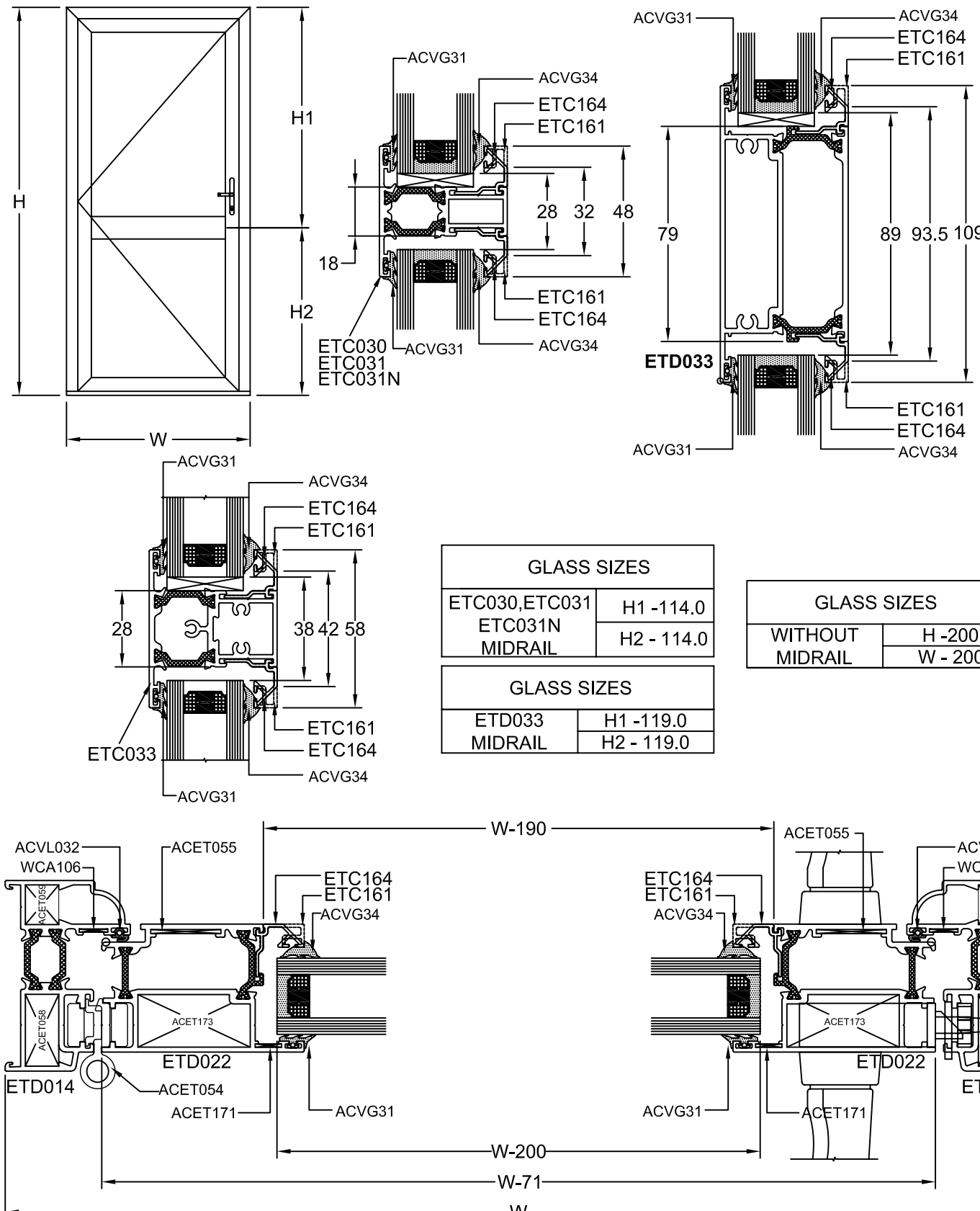
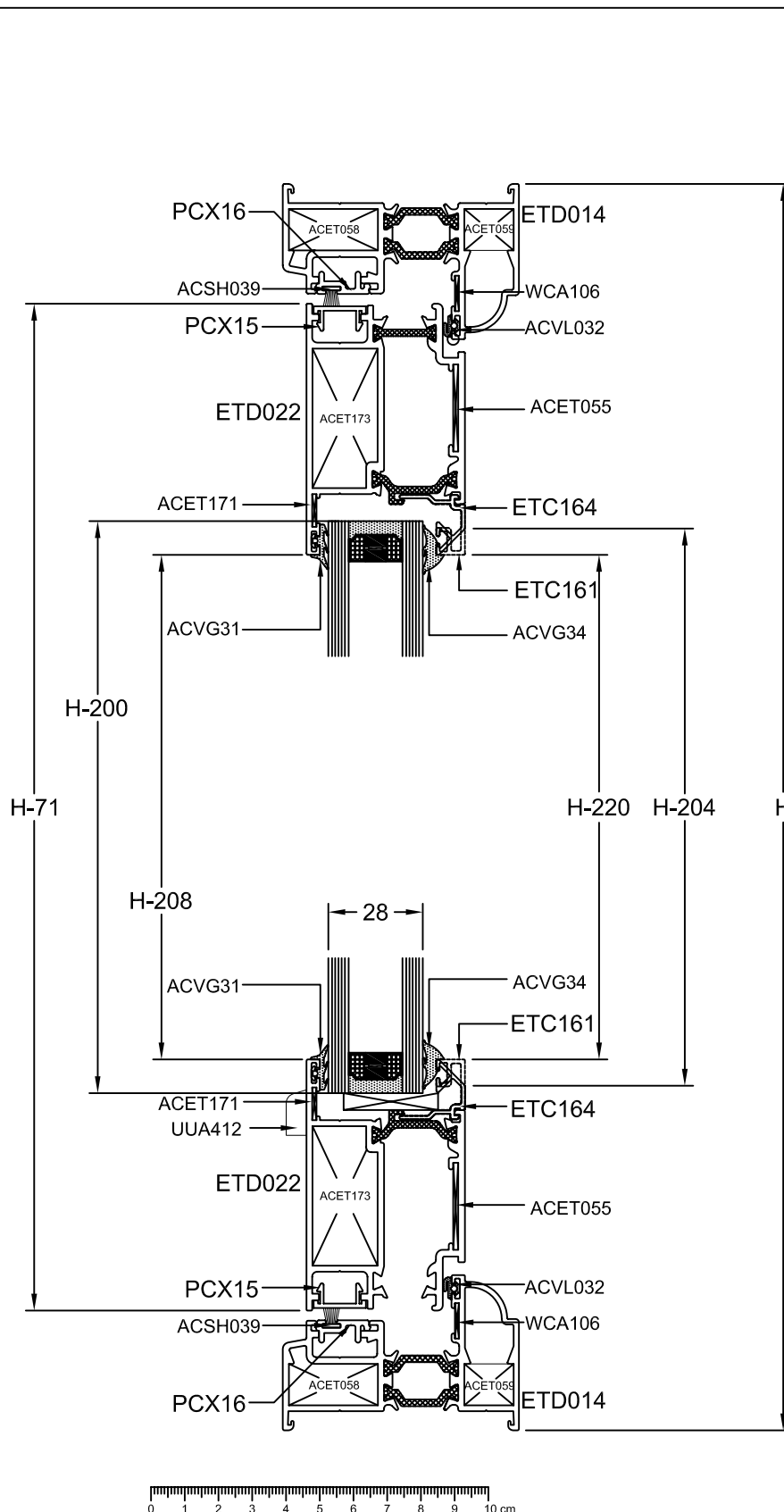
Open Out (Low Threshold)

1a



2a

Open Out (Frame All Round) 2a



PROFILE CUTTING SCHEDULE

ETD014	2		H
ETD014	2		W
ETD022	2		H-71
ETD022	2		W-71
PCX16	1		W-65
PCX16	2		H-65
PCX15	1		W-71
PCX15	2		H-71
ETC161	2		H-220
ETC161	2		H-204
ETC161	2		W-190
ETC161	2		W-190

ACCESSORIES

ACET171	4	----	VENT FRAME CHEVRON
ACET054	3 OR 4	----	HINGES
ACET055	4	----	VENT FRAME CHEVRON
ACET173	4	----	VENT FRAME CLEAT
ACET058	4	----	OUTER FRAME CLEAT
ACET059	4	----	OUTER FRAME CLEAT
ACET071	1 PAIR	----	THRESHOLD END CAPS
ACET08*	1	----	LOCK
ACSH038	-	2W	BRUSH PILE
ACSH039	-	W+2H	BRUSH PILE
ACVG31	-	2(W+H)	GASKET
ACVG34	-	2(W+H)	GASKET
ACVL032	-	2(W+2H)	SEAL
ACVL117	1	----	CYLINDER
RCA054	12	----	SCREWS (LOCK)
RUA090	1	----	HANDLE
UUA412	2	----	DRAINAGE COWL
WCA106	2	----	OUTER FRAME CHEVRON

GLASS SIZES	
ETC030,ETC031	H1 -114.0
ETC031N	H2 - 114.0
MIDRAIL	
GLASS SIZES	
ETD033	H1 -119.0
MIDRAIL	H2 - 119.0

GLASS SIZES	
WITHOUT	H -200
MIDRAIL	W - 200

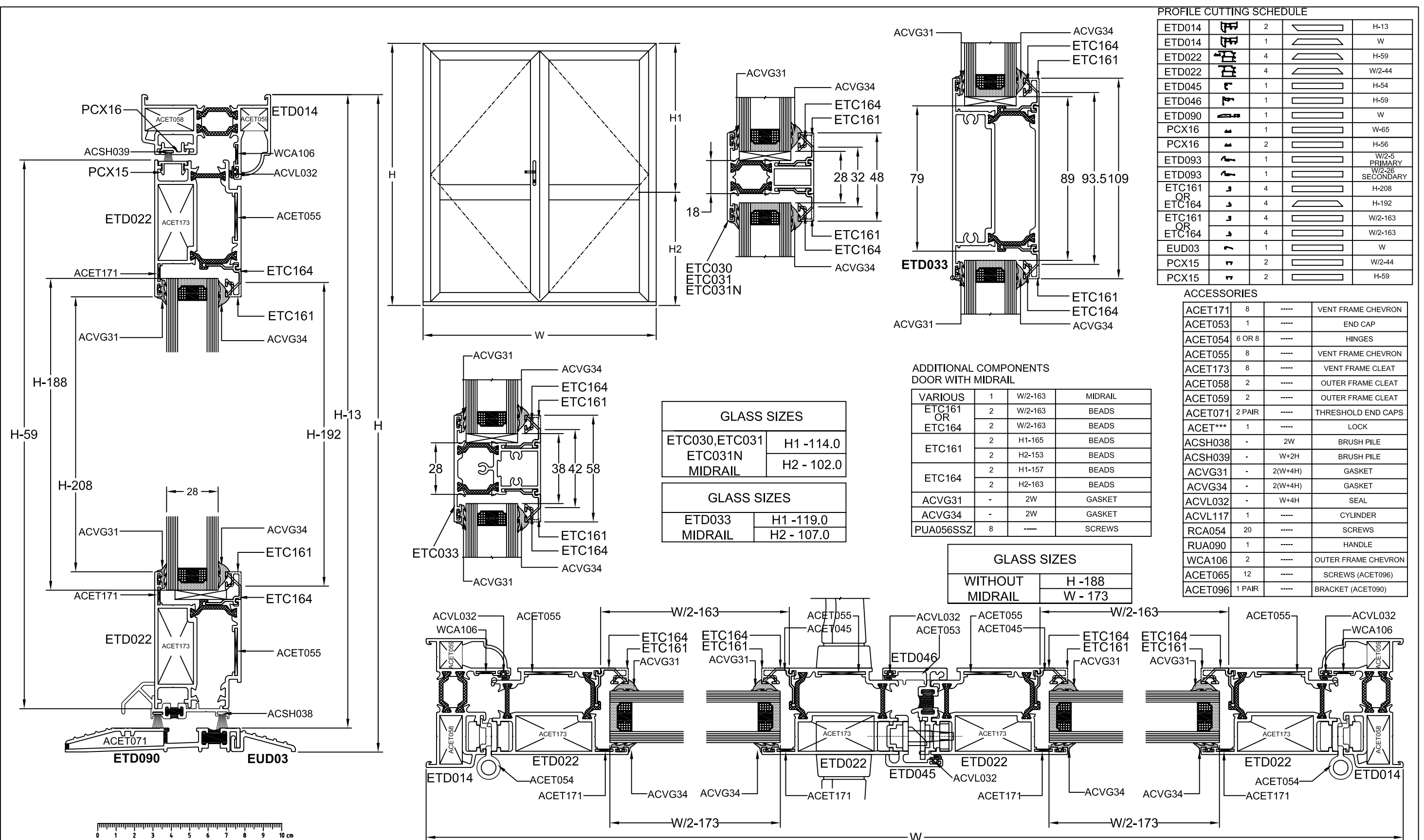
ADDITIONAL COMPONENTS
DOOR WITH MIDRAIL

VARIOUS	1	W-190	MIDRAIL
ETC161	4	W-190	BEADS
ETC161	2	CUT TO SUIT FOR H1 & H2	BEADS
ETC161	2	CUT TO SUIT FOR H1 & H2	BEADS
ETC164	2	CUT TO SUIT FOR H1 & H2	BEADS
ACVG31	-	2W	GASKET
ACVG34	-	2W	GASKET
PUA056SSZ	----	----	SCREWS (ETD030)
ACET066	----	----	SCREWS (ETC031,ETC031N,ETC033)
ACET015	----	----	CLEAT (ETC030)
ACET114	----	----	SPRING CLIP (ETC030,ETC031,ETC031N)
ACET125	----	----	SPRING CLIP (ETC033)
ACET126	----	----	CLEAT (ETC031N)
ACET015	----	----	CLEAT (ETC033)

3a

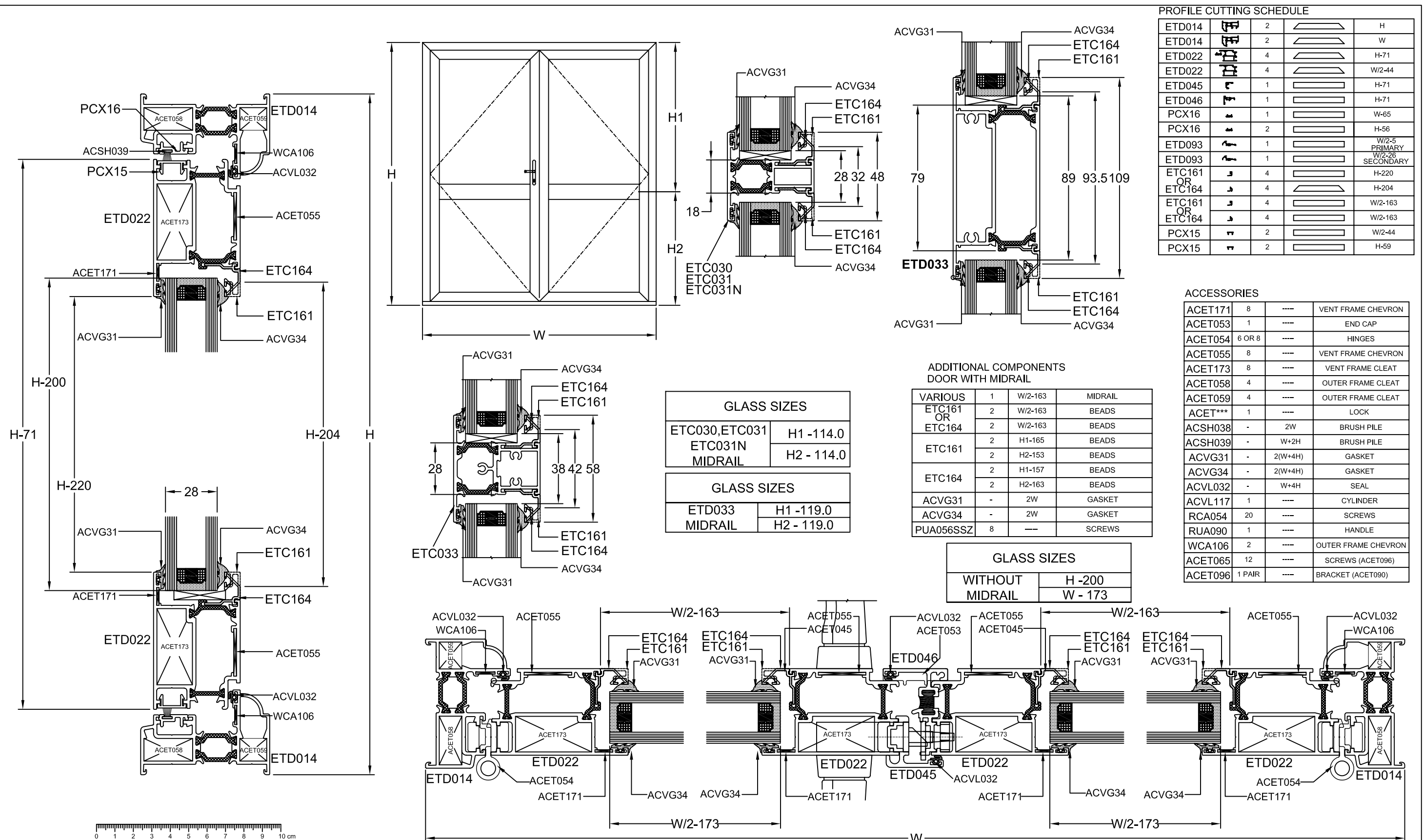
Open Out (Low Threshold)

3a



4a

Open Out (Frame All Round) 4a

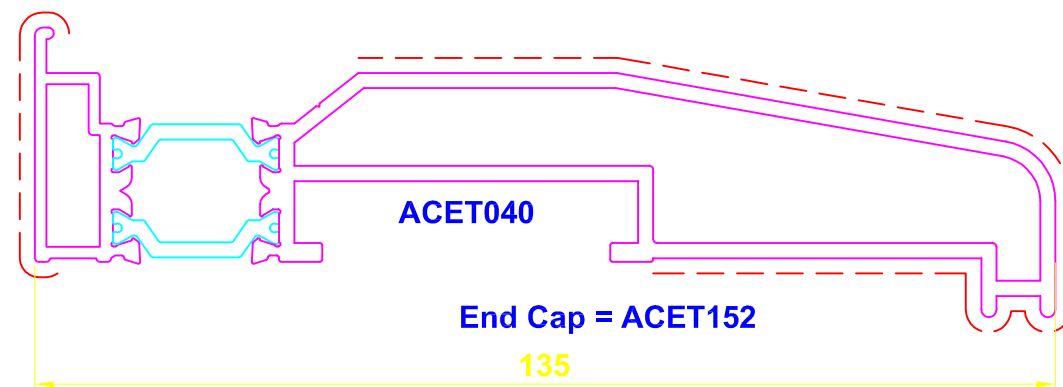


Drawing Number: fETD-47-12-00

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Bulletin

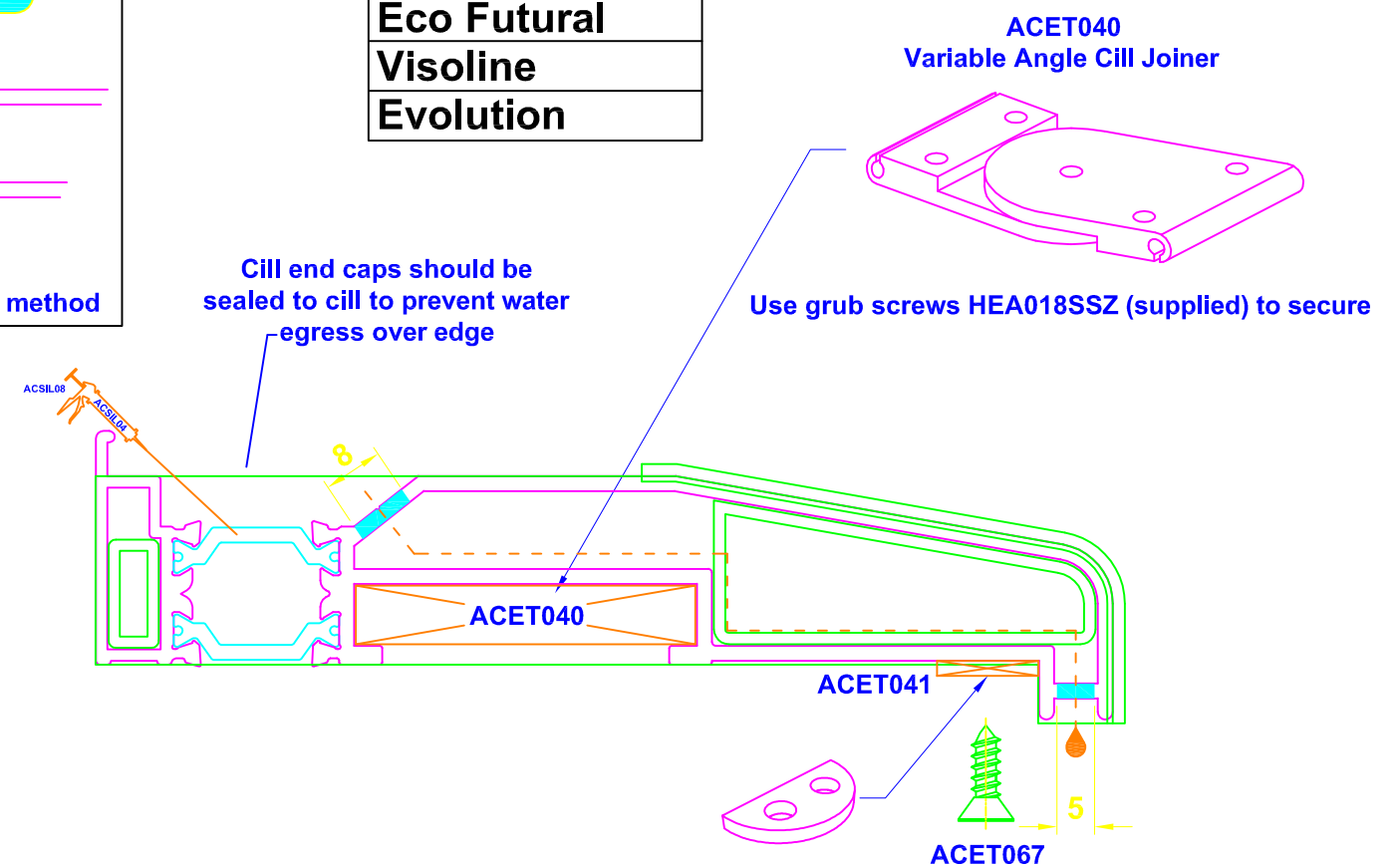
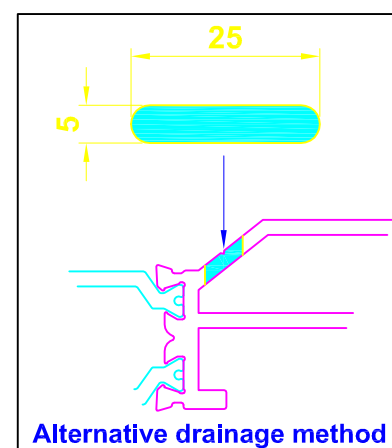
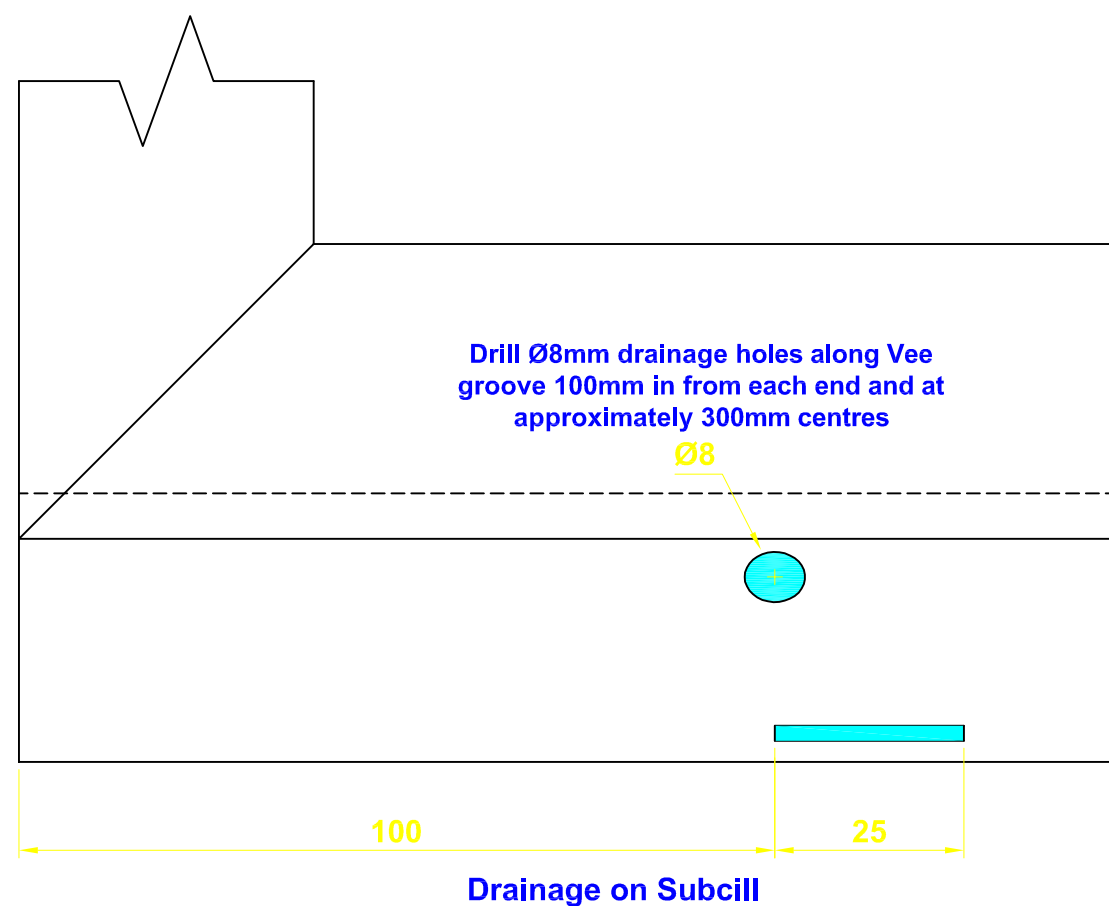
ETC152 - New 135mm Cill



Number	Perim. mm	Mec. mm	lx(cm4) wx(cm3)	ly(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
ETC152	672	214	- ---	- ---	6.5	1	X	X	X	X	X

Suitable for use on window and door profiles up to 74.5mm wide. Anything deeper will need to have the legs packed out.

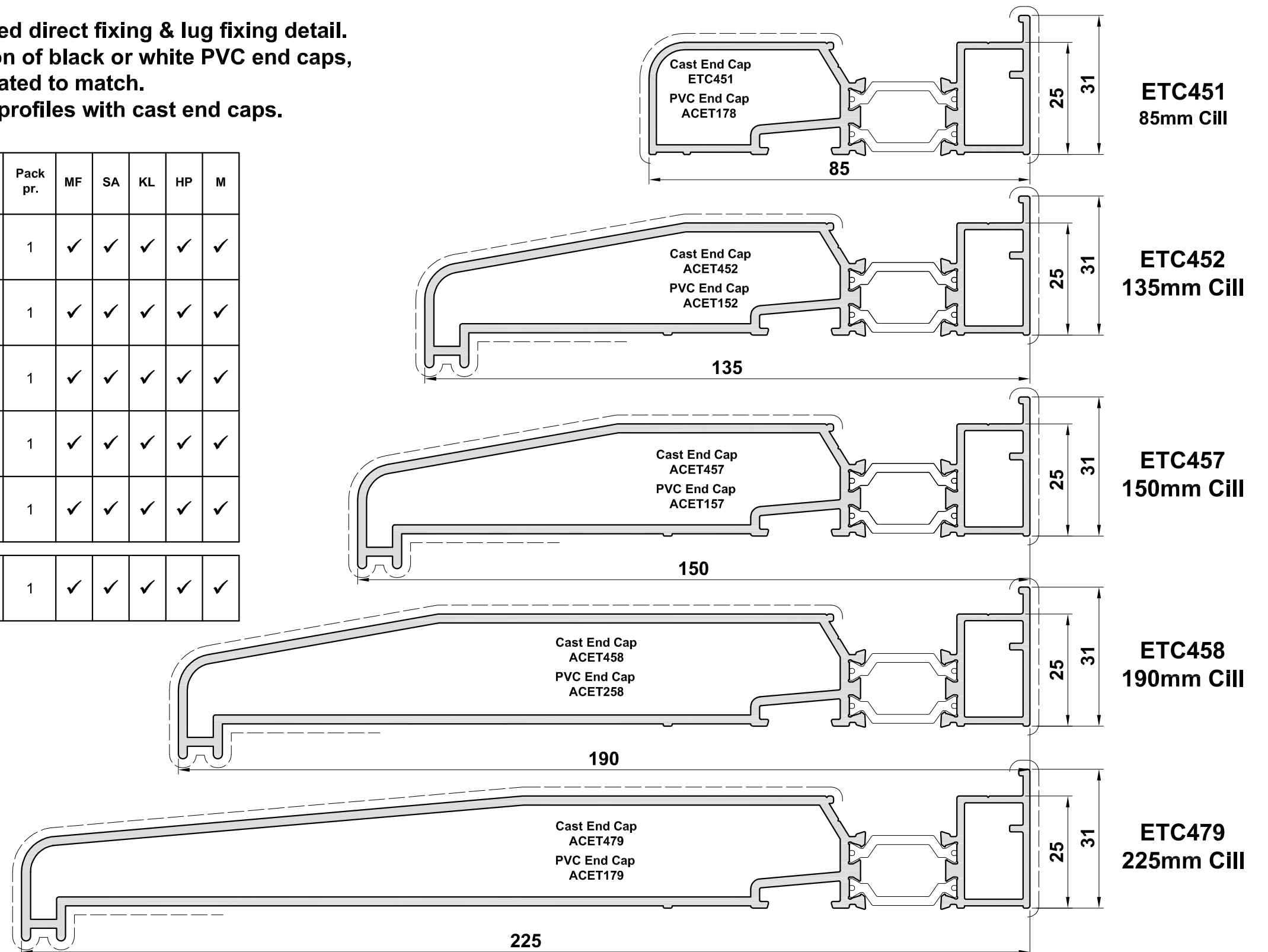
Suitable For
Alitherm Series
Visofold Series
Eco Futural
Visoline
Evolution



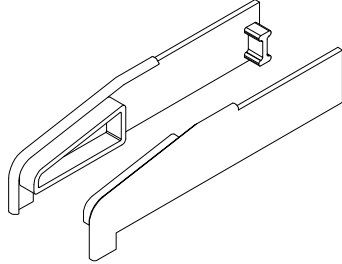
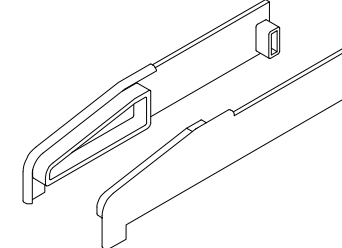
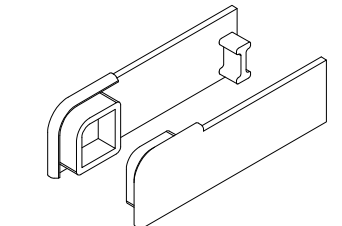
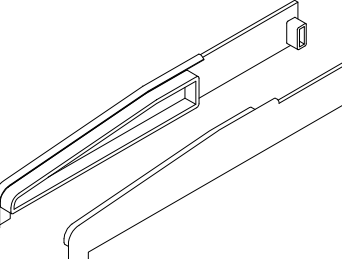
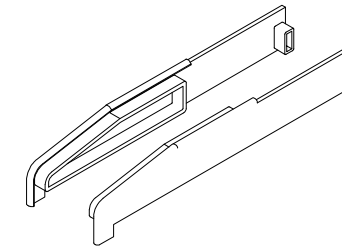
Do Not Scale From This Drawing

New sub cills designed to allow an improved direct fixing & lug fixing detail.
ETC451, 452, 457, 458 & 479 offer the option of black or white PVC end caps,
or cast end caps which may be powder coated to match.
ETC478 is a new 300mm sub cill for wider profiles with cast end caps.

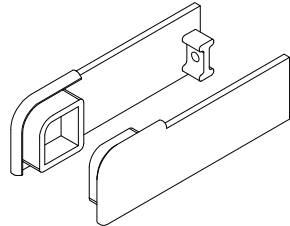
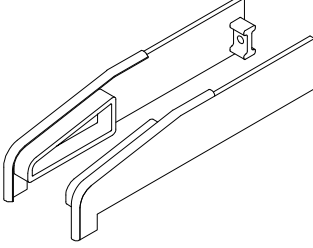
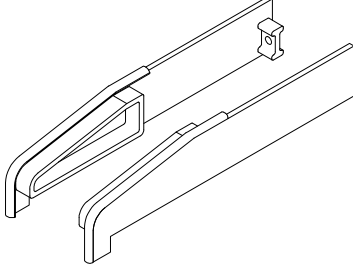
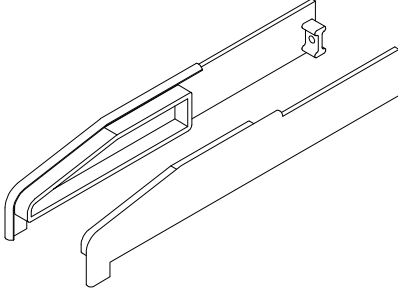
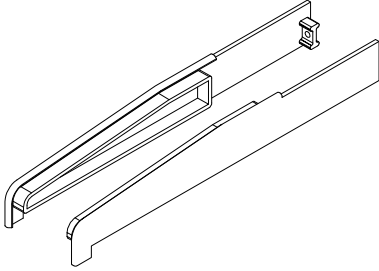
	Number	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
New	ETC451	304	109	32.44 ----- 7.29	3.46 ----- 2.79	6.5	1	✓	✓	✓	✓	✓
New	ETC452	414	197	122.46 ----- 18.03	6.01 ----- 3.34	6.5	1	✓	✓	✓	✓	✓
New	ETC457	444	212	163.27 ----- 21.60	6.79 ----- 3.73	6.5	1	✓	✓	✓	✓	✓
New	ETC458	524	252	313.62 ----- 32.63	8.87 ----- 4.79	6.5	1	✓	✓	✓	✓	✓
New	ETC479	594	287	501.64 ----- 44.04	9.72 ----- 5.34	6.5	1	✓	✓	✓	✓	✓
Available Soon	ETC478	736	314	1410.74 ----- 87.73	16.30 ----- 8.62	5	1	✓	✓	✓	✓	✓



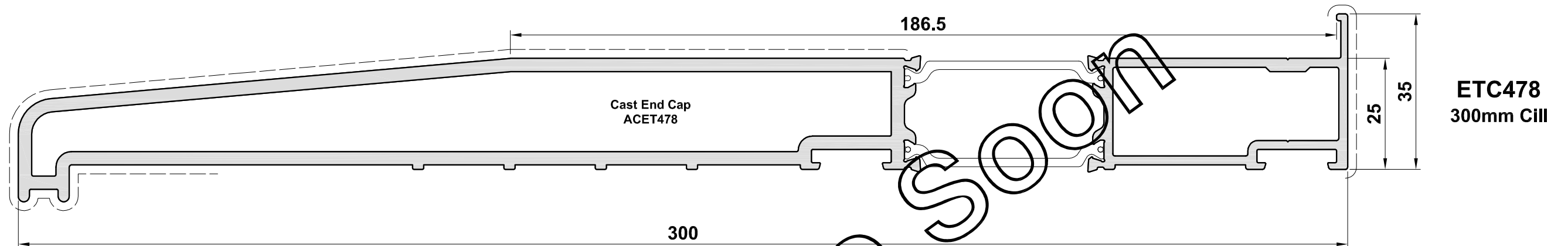
PVC End Caps

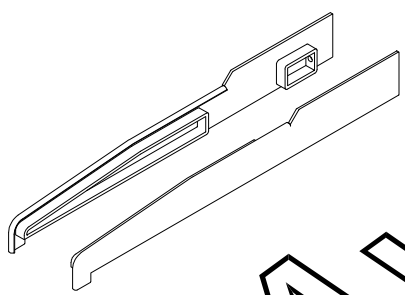
	ACET152 PVC Cill End Cap	10	pairs	ETC452	MF	
					KL	
					HP	
					W	✓
					Z	✓
	ACET157 PVC Cill End Cap	10	pairs	ETC457	MF	
					KL	
					HP	
					W	✓
					Z	✓
	ACET178 PVC Cill End Cap	10	pairs	ETC451	MF	
					KL	
					HP	
					W	✓
					Z	✓
	ACET179 PVC Cill End Cap	10	pairs	ETC479	MF	
					KL	
					HP	
					W	✓
					Z	✓
	ACET258 PVC Cill End Cap	10	pairs	ETC458	MF	
					KL	
					HP	
					W	✓
					Z	✓

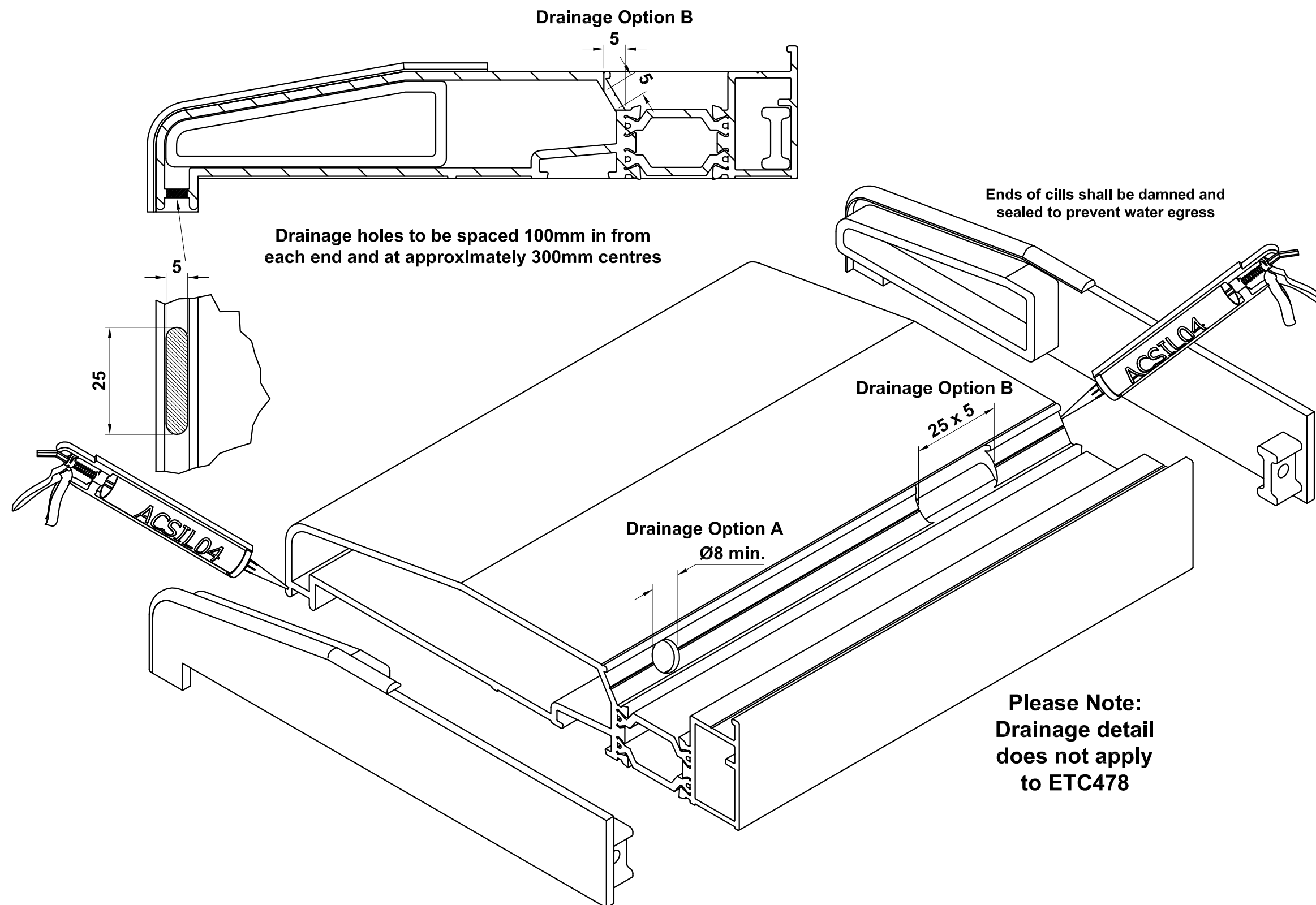
Cast End Caps

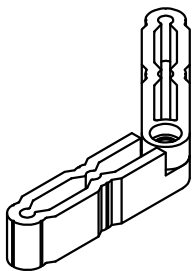
	ACET451 Cast Cill End Caps	1	pair	ETC451	MF	✓
					KL	✓
					HP	✓
					W	✓
					Z	✓
	ACET452 Cast Cill End Caps	1	pair	ETC452	MF	✓
					KL	✓
					HP	✓
					W	✓
					Z	✓
	ACET457 Cast Cill End Caps	1	pair	ETC457	MF	✓
					KL	✓
					HP	✓
					W	✓
					Z	✓
	ACET458 Cast Cill End Caps	1	pair	ETC458	MF	✓
					KL	✓
					HP	✓
					W	✓
					Z	✓
	ACET479 Cast Cill End Caps	1	pair	ETC479	MF	✓
					KL	✓
					HP	✓
					W	✓
					Z	✓

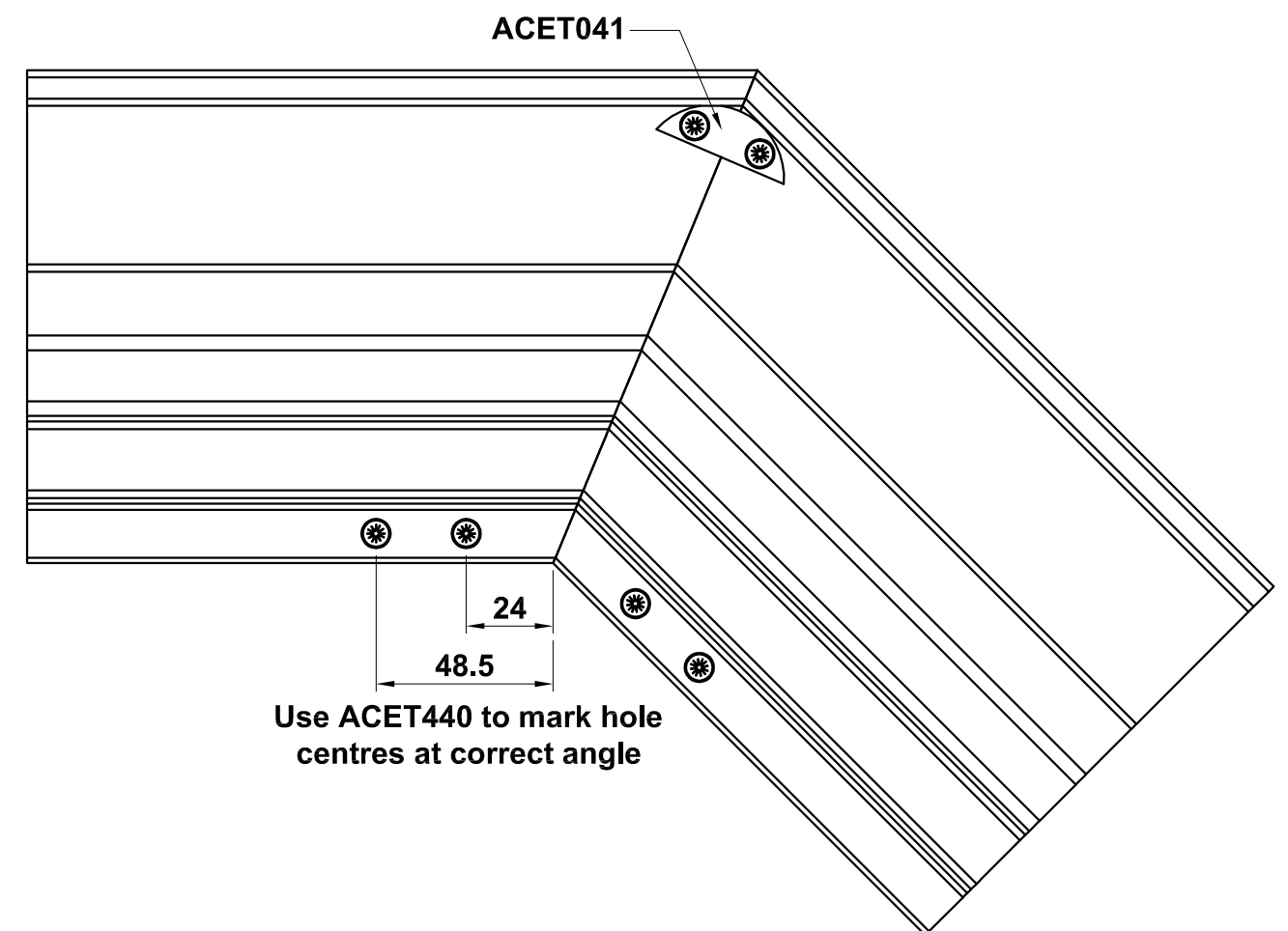
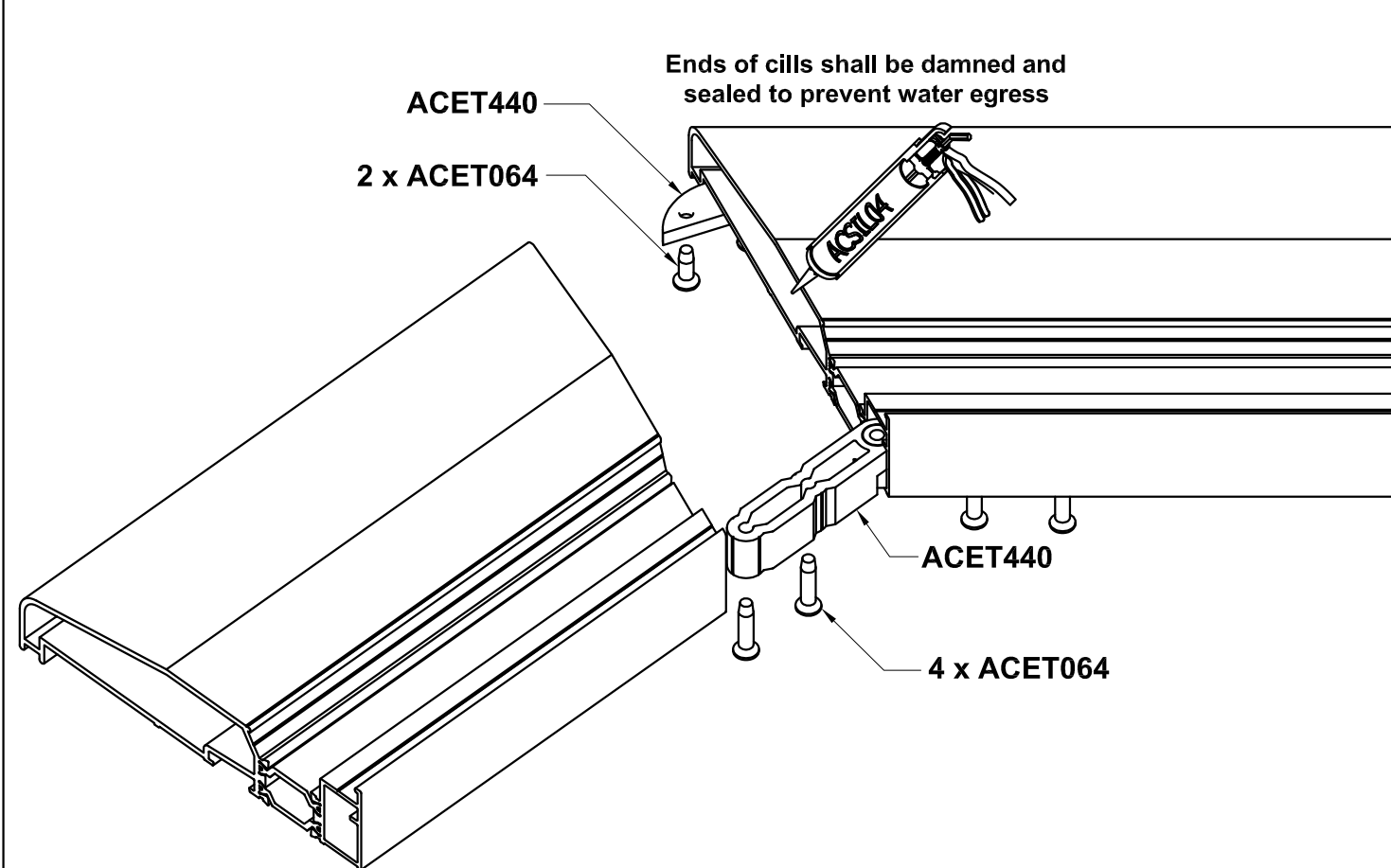
Note: ETC478 is not designed for
concealed drainage



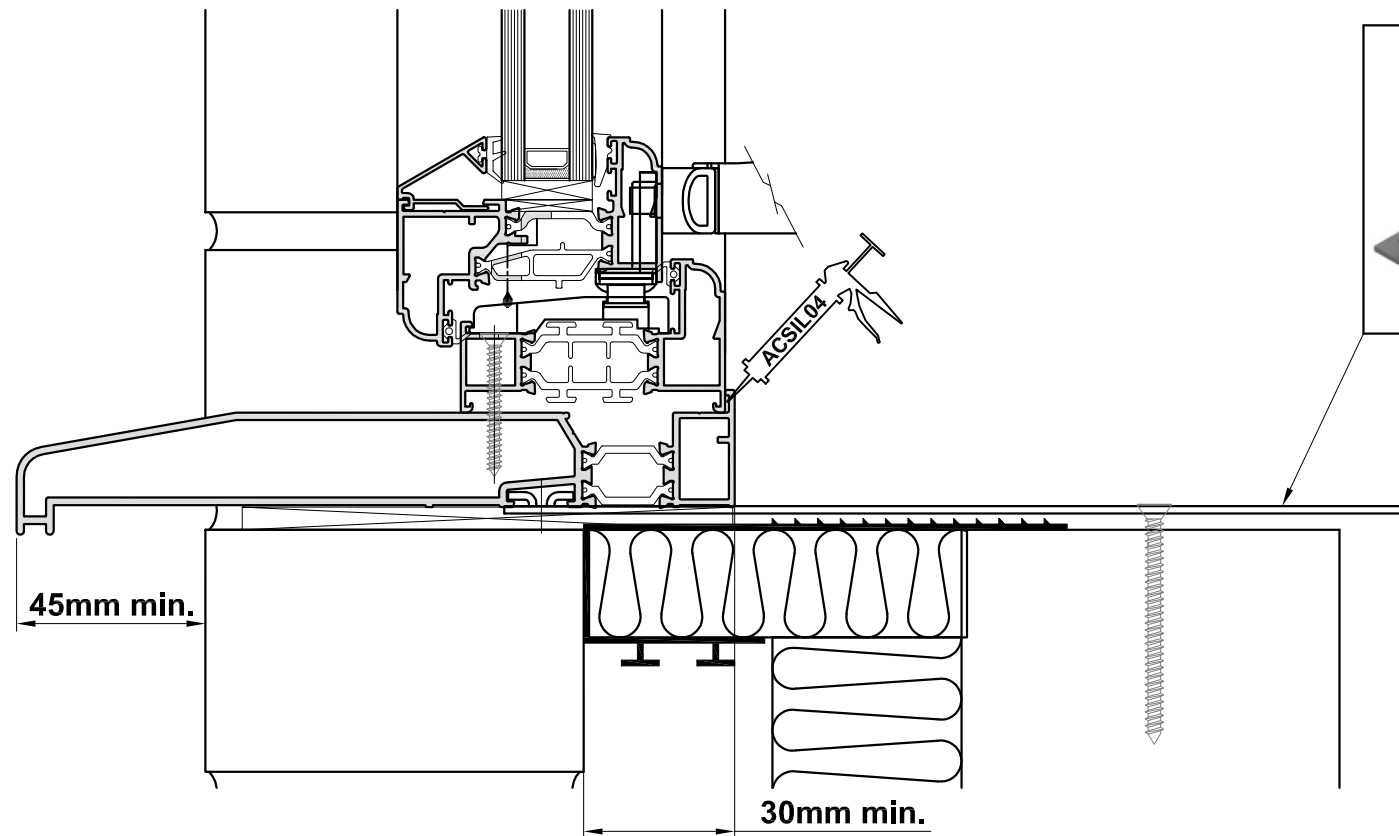
	ACET478	1	pair	ETC478	MF	✓
	Cast Cill End Cap				KL	✓
					HP	✓
					W	✓
					Z	✓




	ACET440	10	pack	ETC451 ETC452 ETC457 ETC458 ETC479	MF	✓
	90°-180° Variable angle bracket				KL	
					HP	
					W	
					Z	



Example Lug Fixing Detail



	ACUN23X	100	Pack	ETC451	MF	✓
	Screw Fixing Lug			ETC452	KL	
	ACUN230: B = 160MM			ETC457	HP	
	ACUN232: B = 240MM			ETC458	W	
	ACUN233: B = 280MM			ETC478	Z	
				ETC479		

Example Direct Fixing Detail

