

## Important Information

### Curtain Walling

Curtain walling cannot be treated in the same way as window or door installations. The following points should be taken into consideration when undertaking curtain wall design, fabrication and installation:

1. **Correct profiles need to be identified to suit site conditions. Factors including screen sizes, fixing positions, glass weight, barrier loadings & wind loadings will need to be considered. The design process is also likely to include consideration of thermal, structural and acoustic requirements depending on the individual project.**
2. **Detailed design drawings must be prepared to include all perimeter detailing & fixing/bracket positions. Smart Systems can provide the section drawings only.**
3. **All brackets and fixings must be designed to relevant structural codes. It is recommended that drawings are checked by a qualified engineer for suitability.**

## Bulletin

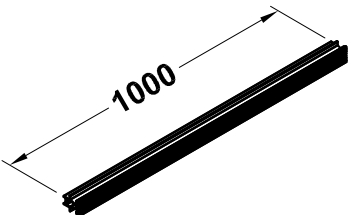
### MC683 is a new sleeve for MC603.

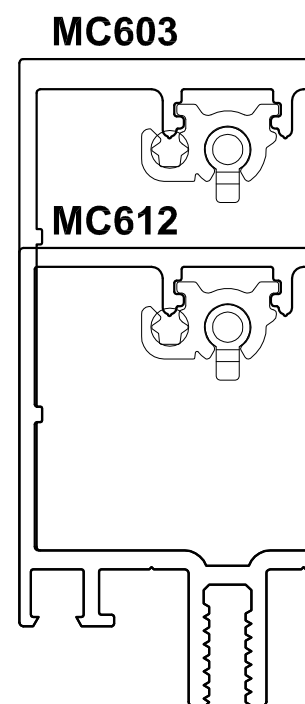
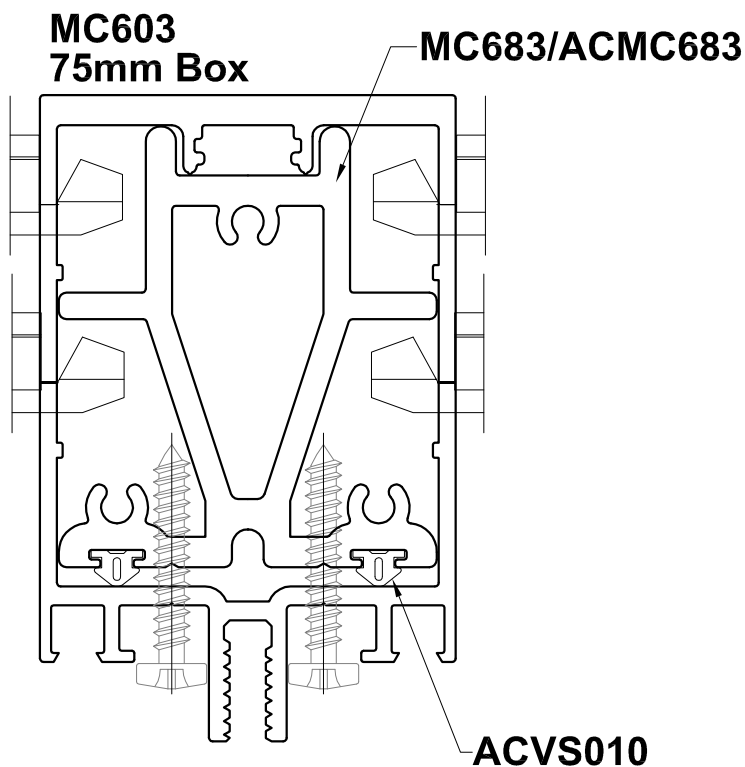
New mullion sleeve designed to accommodate the popular ACMC650 & ACMC651 hooked anti-rotation pins. To be used with ACVS010 PVC inserts to minimise movement. Screw ports accept number 10 screws when used as a top or bottom bracket.

**New**

Number	Perim. mm	Mec. mm	lx(cm4) wx(cm3)	ly(cm4) wy(cm3)	Length	Pack pr.	MF
<b>MC683</b>	352	-	29.25 ----- 8.84	12.97 ----- 5.19	7.0	1	✓

**New**

Image	Part Code	Pack	Unit
	<b>ACMC683</b>  1000mm Sleeve for MC603  Produced from MC683	1	each



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## Specification

### GENERAL DESCRIPTION

MC600 is a new stick build curtain wall system suitable for low to high rise installations in commercial buildings.

Designed for quick and easy workshop preparation and on-site installation, MC600 is a cost effective system which offers a high quality finish.

### PROFILE SPECIFICATION

The sections are constructed of aluminium alloy extrusion to BS EN 755-9 and BS EN 12020, extruded from 6060 T6 alloy.

The aluminium alloy extrusion is pre-treated and finished either:-

- a) Anodised to BS 3987: 1987, grade AA25 to a natural self colour.
- b) Polyester powder organic coating to BS 6496.

### GENERAL MANUFACTURING

After careful inspection of the extrusions, all visible areas shall be taped using our recommended protective tape to help protect against any scratches.

Sections are cut with accurate 90° ends using Tungsten Carbide Tipped Saw Blades, operating at approximately 3000 rpm. The isolator MC601 can be inserted into the mullions/transoms prior to cutting.

The mullions are marked and drilled using the recommended drill jig APMC695.

Transoms are drilled using recommended drill jig APMC691 in preparation for the fixing bracket APMC600 which is secured into position using ACET060 stainless steel self tapping screws.

On polyester powder coated finishes, great care should be taken to avoid getting gap sealer on visible surfaces and should be removed as soon as possible with a clean cloth.

Care should be exercised when using products not supplied by Smart Systems Ltd as no responsibility can be accepted.

## Specification

### DRAINAGE

As with all dry glazed systems, it is recommended that the system is adequately drained and ventilated. Refer to drainage details in manual, if in doubt ask the Technical Department.

### WORKSHOP MANUFACTURING INFORMATION

After careful inspection of the extrusions, all visible areas shall be taped using our recommended protective tape to help protect against any scratches.

Sections are cut with accurate 90° ends using Tungsten Carbide Tipped Saw Blades, operating at approximately 3000 rpm. The isolator MC601 can be inserted into the mullions/transoms prior to cutting.

The mullions are marked to show the centre line of the transoms and are drilled with a 4mm dia. drill bit for the ACMC600 brackets and a 6.5mm dia. drill bit for the ACMC650 anti-rotation spring pin using the recommended drill jig ACMC695.

Transoms are drilled with a 3mm dia. drill bit using recommended drill jig ACMC691 in preparation for the fixing bracket ACMC600 which is secured into position using ACET060 stainless steel self tapping screws. The ACMC650 anti-rotation spring pin is slid into the position and secured by tightening the grub screw.

All gaskets and transom end pads may be fitted in the workshop to save time on site.

### ON SITE ASSEMBLY INFORMATION

After mullions are secured into position, the transoms are inserted between the vertical members until the ACMC650 anti-rotation spring pin engages into the predrilled hole. Care should be taken to ensure the transom end pads are not dislodged at this point. The transom is secured into position via the ACMC600 brackets using PUA028 stainless steel self tapping screws.

Moulded corners shall be fitted between the gaskets and sealed using ACMX09830 EPDM adhesive. ACMC630 glazing supports shall be positioned in preparation for the double glazed units.

### GLAZING

Double glazed units shall be positioned on plastic packers on ACMC630 glazing supports with equal distance on all sides.

Units are secured in position using DK154 with ACDK066 fixing plate held in place by ACMC610 Hex Head Self Tapping Fixing Screw taking care not to exceed torque of 4Nm at the recommended speed of 1500-1800rpm. Stitch plates may be used to secure the units temporarily until all units are in position. Pressure plates shall be fitted at the top first, working downwards to help avoid uneven fixings.

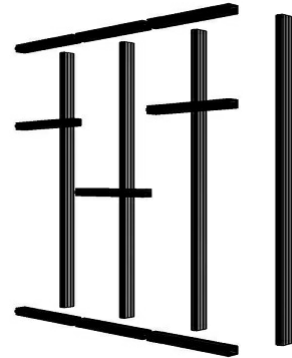
The cover caps are clipped in position using a rubber mallet taking care to strike the corners only to avoid denting the section. Vertical cover caps are fitted first followed by the horizontal caps.

## Specification

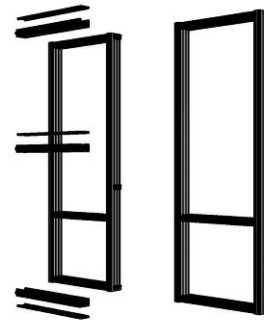
### CONSTRUCTION OPTIONS

The MC600 Curtain Walling System may be installed as a stick, ladder frame or as a screwed system.

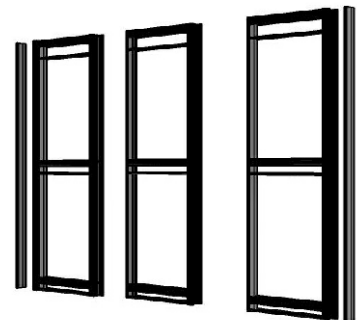
Stick build is a fast method of fabrication and installation. The Curtain Wall is taken to site in stick form and the mullions are first to be assembled - usually from the centre outwards. The transoms are then fitted from the front to form the Curtain Wall. Spring Pins (ACMC650) fixed to the transoms, locate in pre-drilled holes in the mullions and the transoms are then secured using a face mounted bracket - ACMC600.



Where ladder frames are used, Shear Blocks (ACMC602/ACMC603) are fixed to the mullions in the factory and 'ladders' built and taken to site ready assembled. The ladders are connected together on site by placing open sided transoms (MC615/MC617) over the shear blocks, fixing from the front through the transom face, into the shear block screwports. A clip plate (MC650/MC651) is then pushed into place to close the transom.



A final method of construction is to use two part mullions/transoms (MC615/MC650 and/or MC617/MC651) and fix using screws through the mullions into screwports within the transoms.



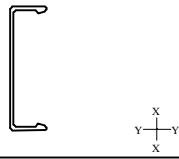
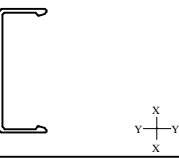
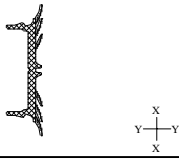
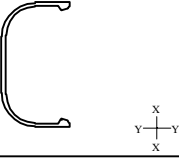
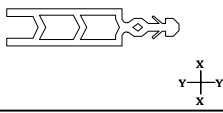
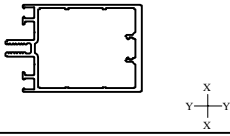
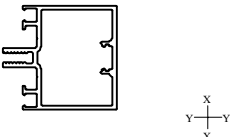
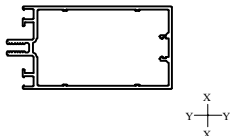
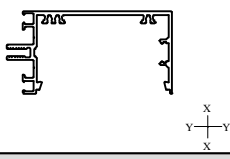
## Specification

### MC600 Weather Performance (BS6375)

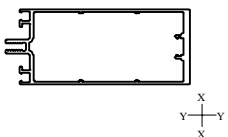
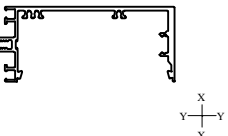
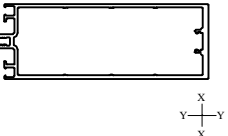
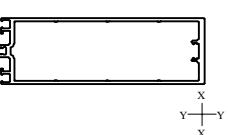
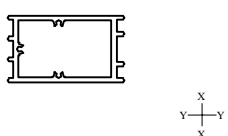
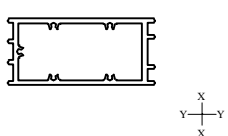
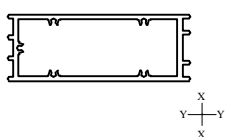
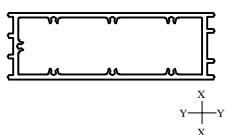
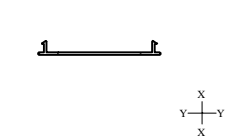
BS EN 1026: 2000 Air Permeability:	Class 4 600Pa
BS EN 1027: 2000 Watertightness	Class 9A 600Pa
BS EN 12211: 2000 Resistance to Wind Load:	Class 3 2400Pa





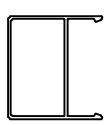





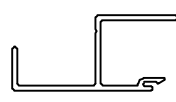

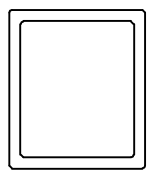

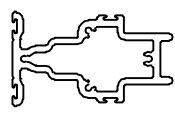

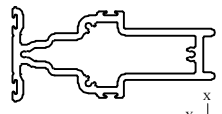

### MC600 Window U Values

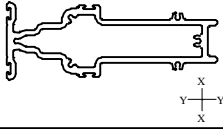
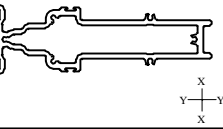
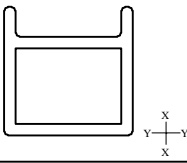
Contact The Technical Department

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<b>DK154</b>		A17	-	-	- ----- -	- ----- -	7	1	✓				
<b>MC050</b>		A15	206	102	- ----- -	- ----- -	7	1	✓	✓	✓	✓	
<b>MC601</b>		A17	-	-	- ----- -	- ----- -	7	1	✓				
<b>MC603</b>		A11	396	205	<b>71.59</b> ----- 14.91	<b>31.68</b> ----- 11.52	7	1	✓	✓	✓	✓	
<b>MC612</b>		A11	346	155	<b>23.54</b> ----- 7.15	<b>20.66</b> ----- 7.51	7	1	✓	✓	✓	✓	
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<b>MC615</b>		A12	657	157	<b>116.94</b> ----- 20.74	<b>22.68</b> ----- 12.38	7	1	✓	✓	✓	✓	
					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				



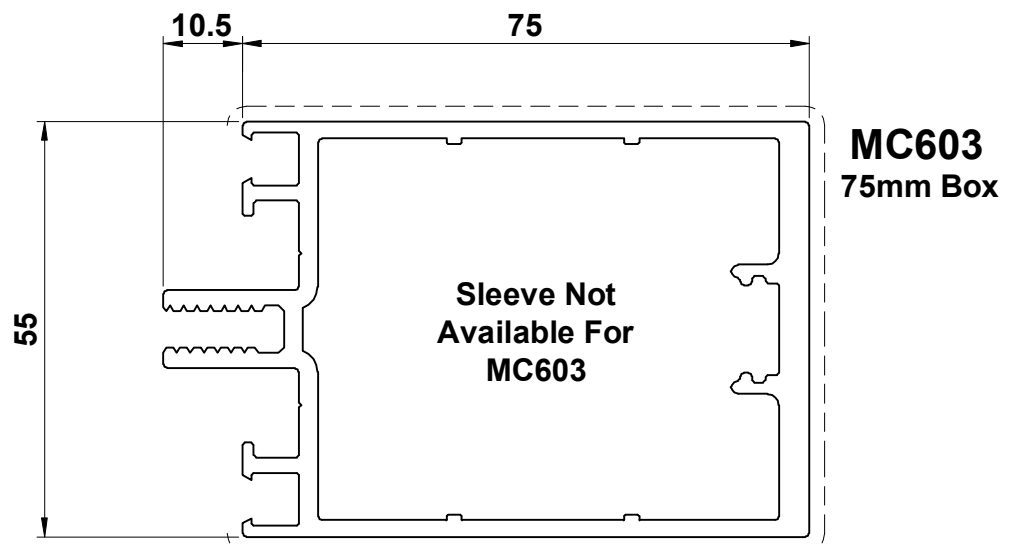
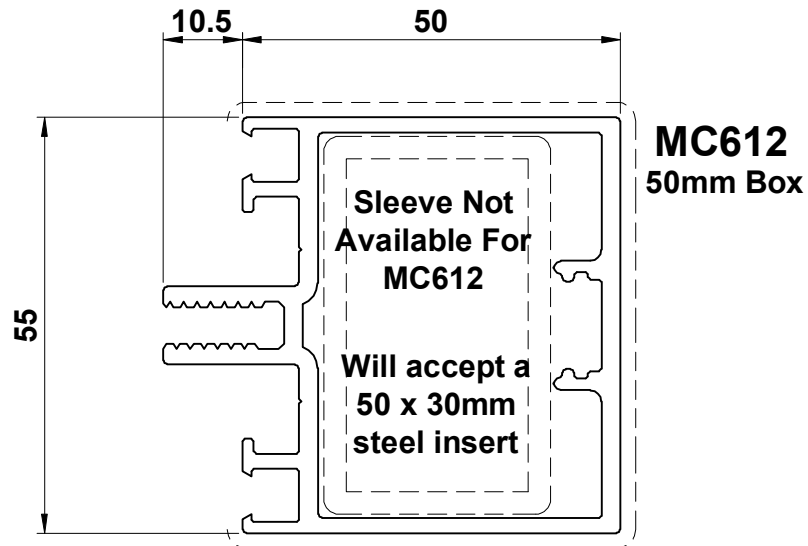
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<b>MC617</b>		A13	705	181	232.25 ----- 32.22	25.79 ----- 14.72	7	1	✓	✓	✓	✓	
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<b>MC649</b>		A18	460	-	416.56 ----- 54.05	63.77 ----- 26.10	7	1	✓				
<b>MC650</b>		A12	221	94	- ----- -	- ----- -	7	1	✓	✓	✓	✓	
					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				

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<b>MC653</b>	 	A15	247	154	- ----- -	- ----- -	7	1	✓	✓	✓	✓	
<b>MC654</b>	 	A15	206	105	- ----- -	- ----- -	7	1	✓	✓	✓	✓	
<b>MC655</b> <b>MC655H</b> <b>MC655V</b>	 	A17 A16 A16	212	-	- ----- -	- ----- -	7	1	✓				
<b>MC663</b>	 	A17	209	42	- ----- -	- ----- -	7	1	✓	✓	✓	✓	
<b>MC665</b>	 	A17	204	39	- ----- -	- ----- -	7	1	✓	✓	✓	✓	
<b>MC684</b>	 	A12	374	-	<b>77.84</b> ----- 17.03	<b>18.35</b> ----- 7.61	6	1	✓				
<b>MC686</b>	 	A13	419	-	<b>139.90</b> ----- 23.87	<b>20.12</b> ----- 8.35	6	1	✓				
								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	

Number	Picture	Page	Perim. mm	Mec. mm	lx(cm4) wx(cm3)	ly(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
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<b>MC689</b>		A14	536	-	396.09 ----- 47.66	33.11 ----- 13.74	6	1	✓				
<b>MC900</b>		A17	74.3	-	- ----- -	- ----- -	6	1	✓	✓	✓	✓	
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Primary Visible Side

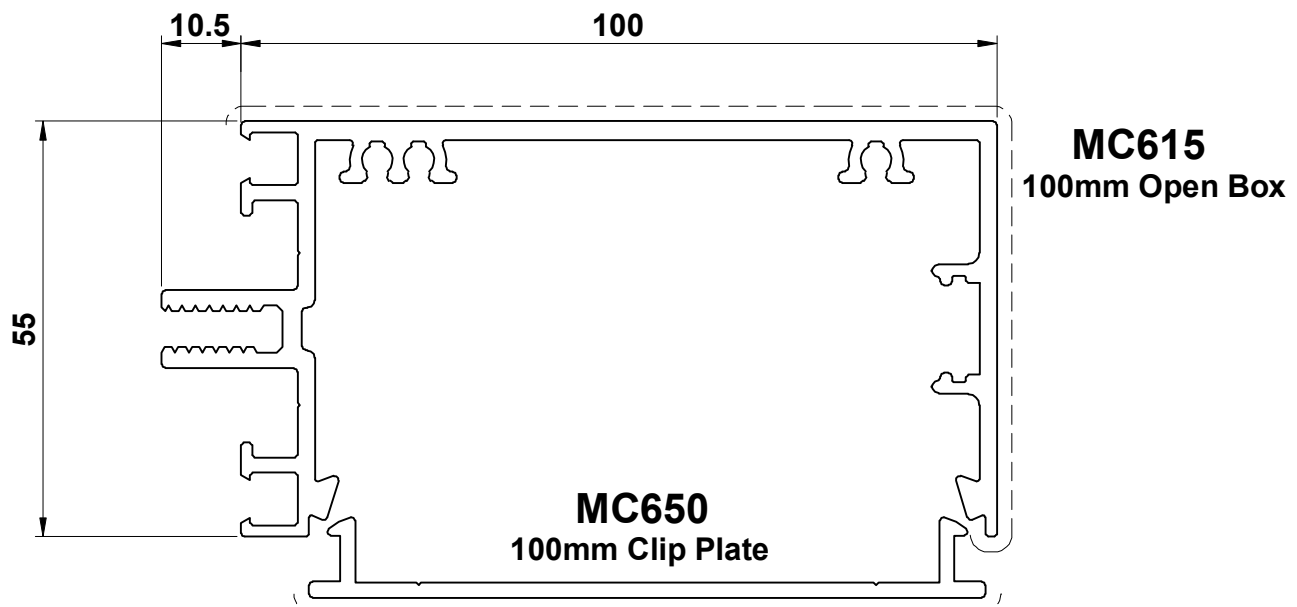
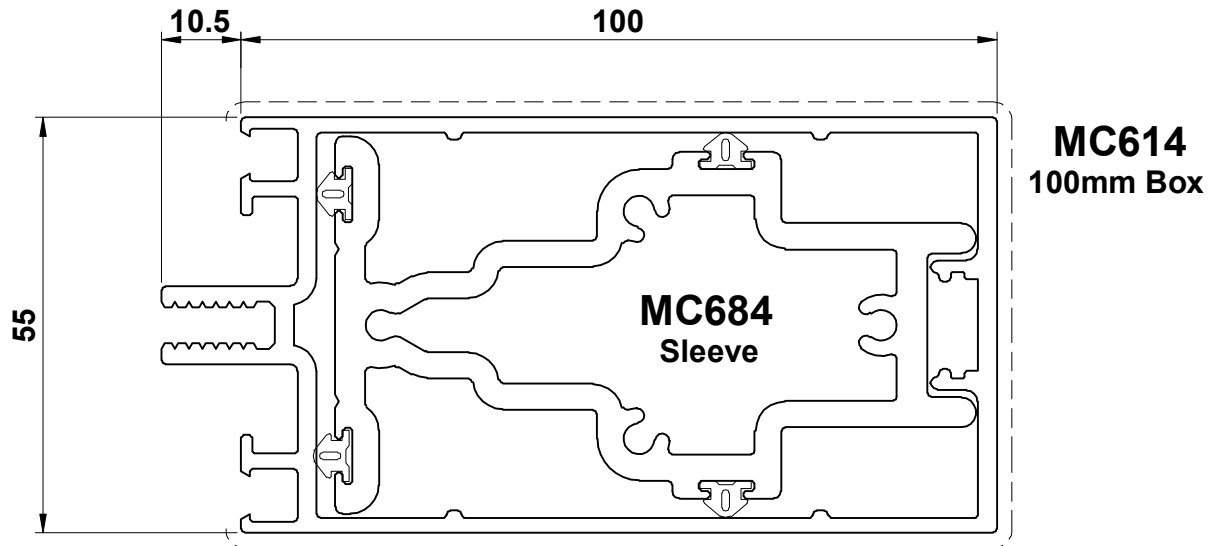
Secondary Visible Side



Scale 1:1

Primary Visible Side

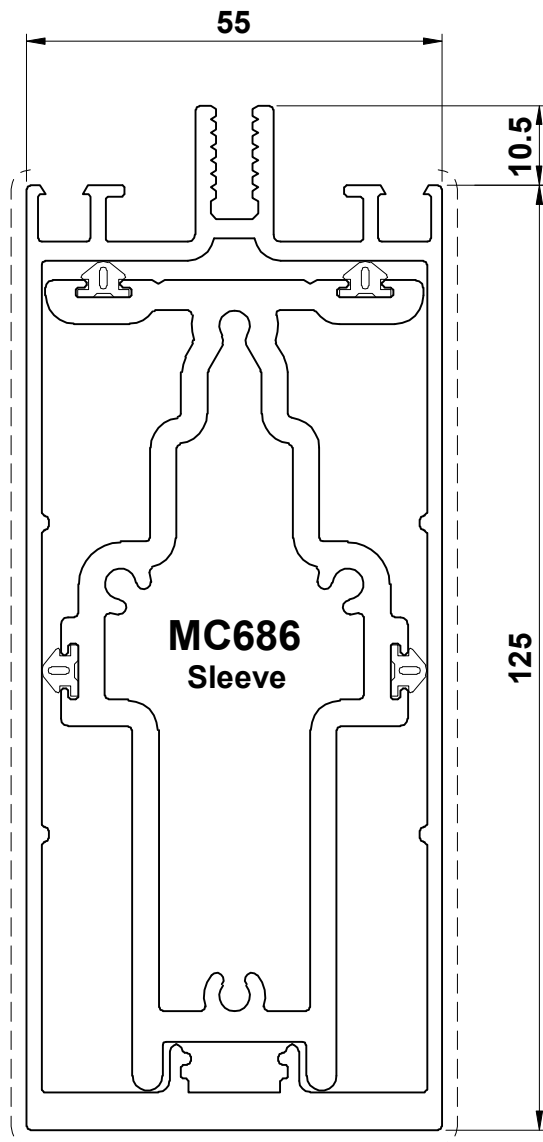
Secondary Visible Side



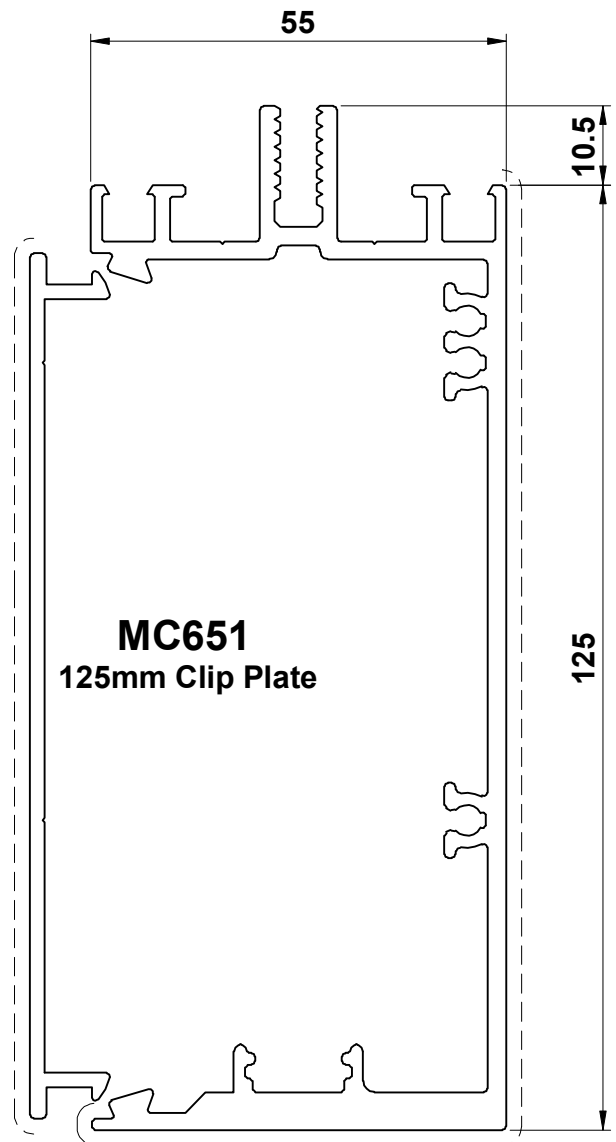
Scale 1:1

Primary Visible Side

Secondary Visible Side



**MC616**  
125mm Box

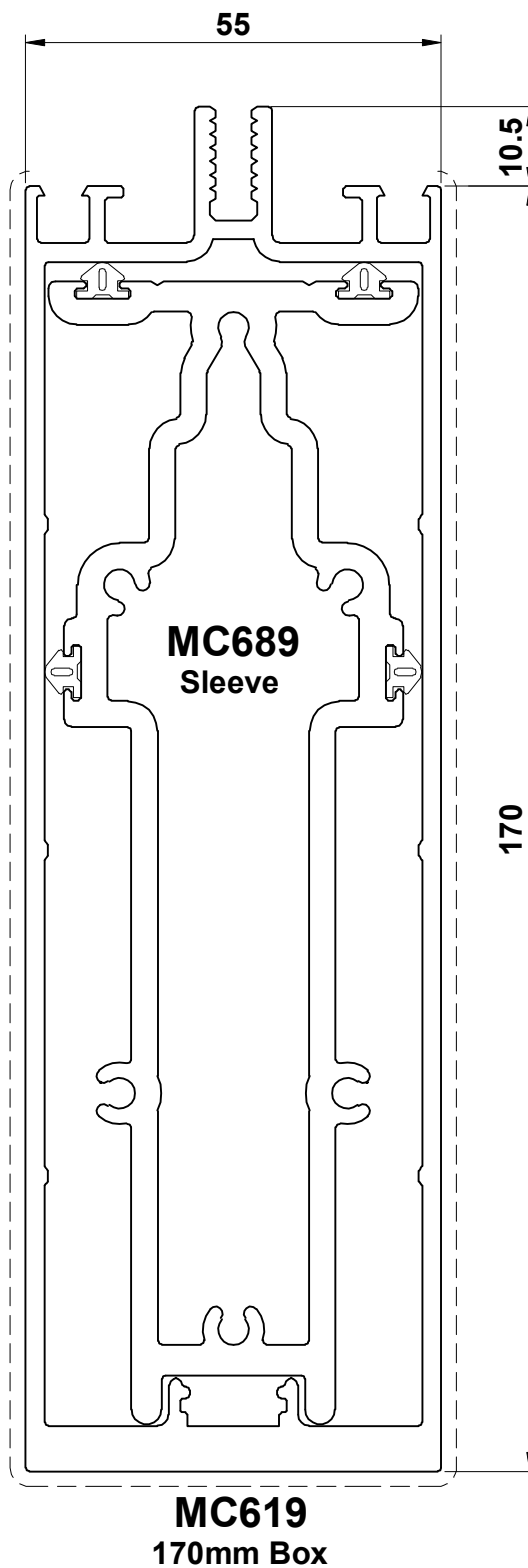
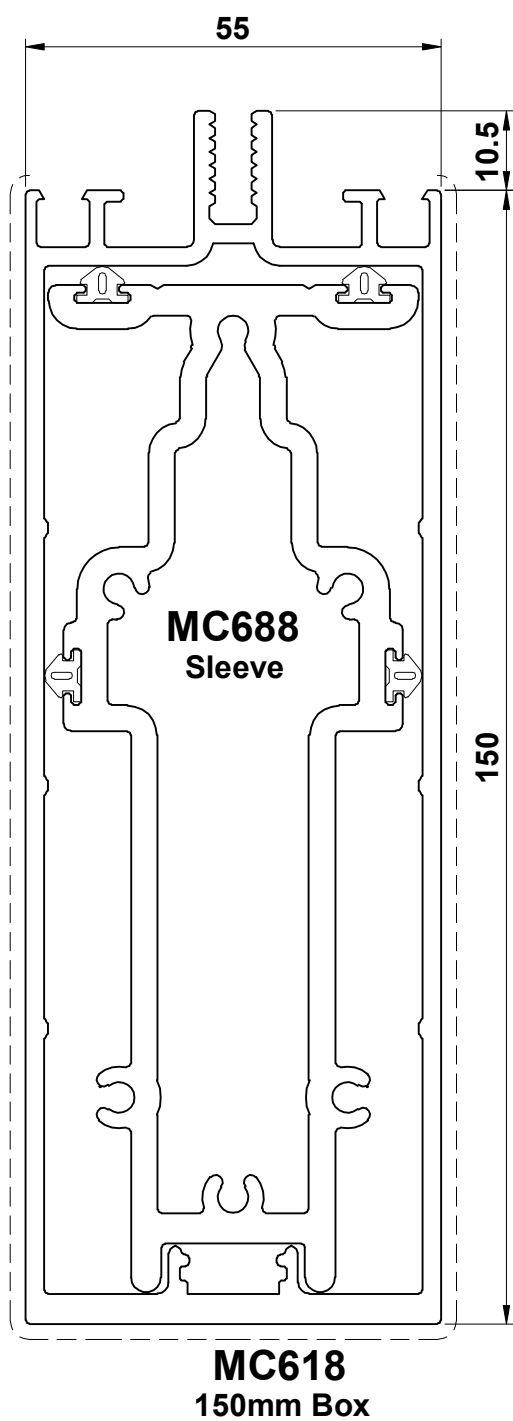


**MC617**  
125mm Open Box

Scale 1:1

Primary Visible Side

Secondary Visible Side

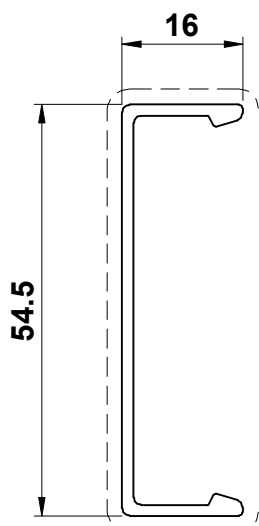


Scale 1:1

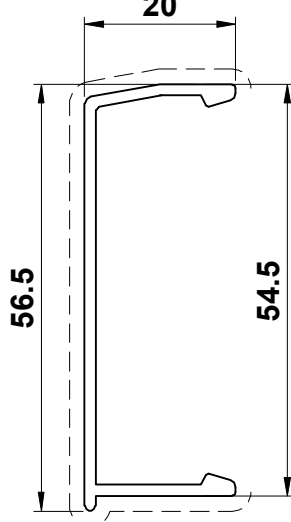
Primary Visible Side

Secondary Visible Side

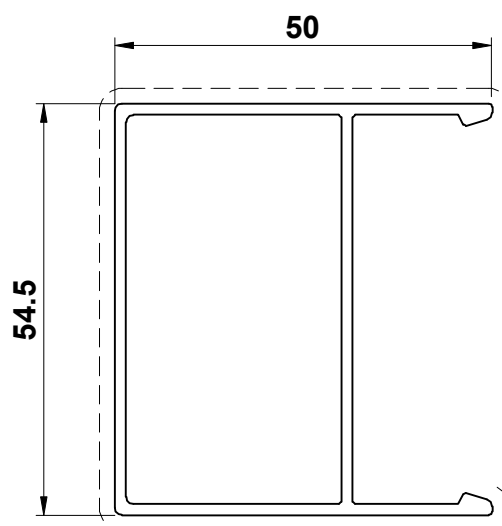
**DK052**  
Horizontal  
Capping



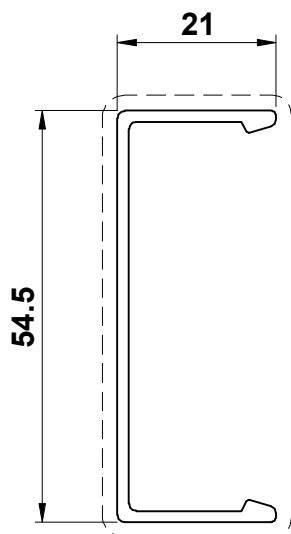
**MC652**  
Horizontal  
Capping with  
Drip



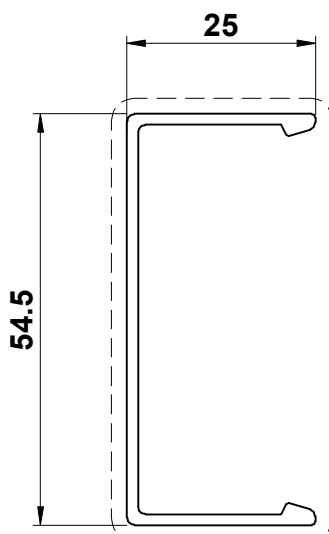
**MC653**  
50mm Vertical  
Capping



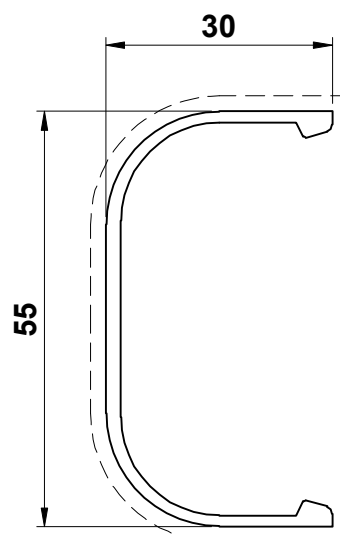
**DK053**  
Vertical  
Capping



**MC654**  
Vertical  
Capping



**MC050**  
Vertical  
Capping

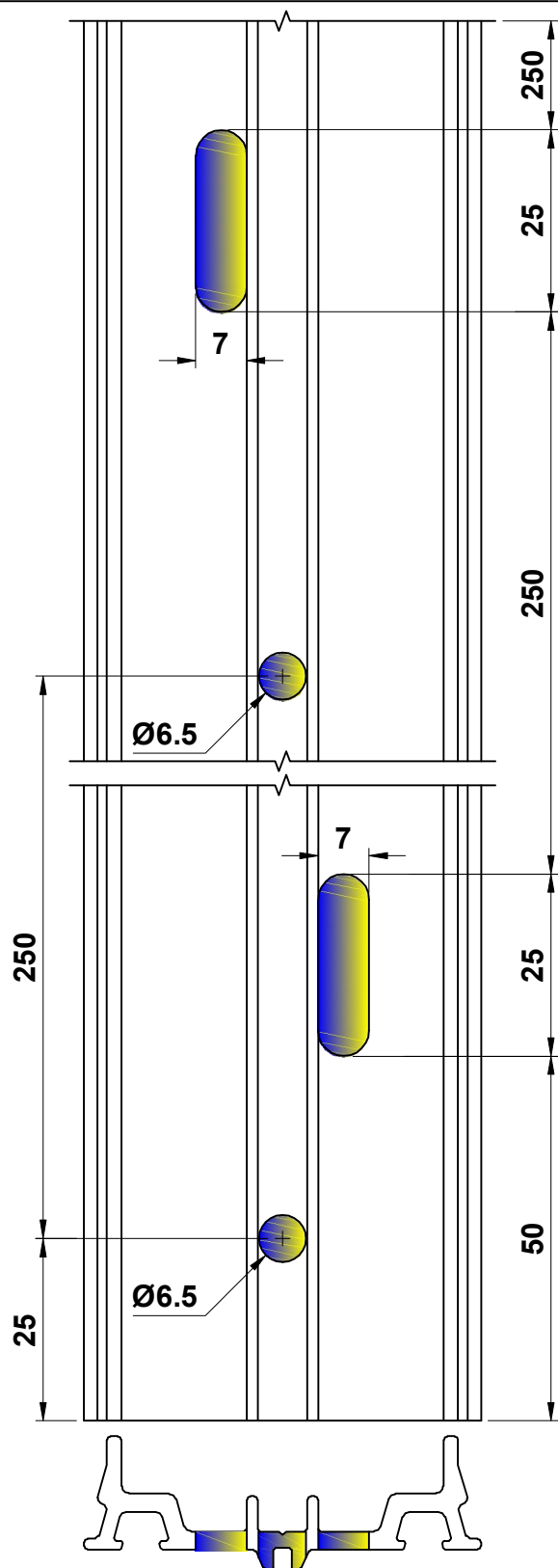


Scale 1:1



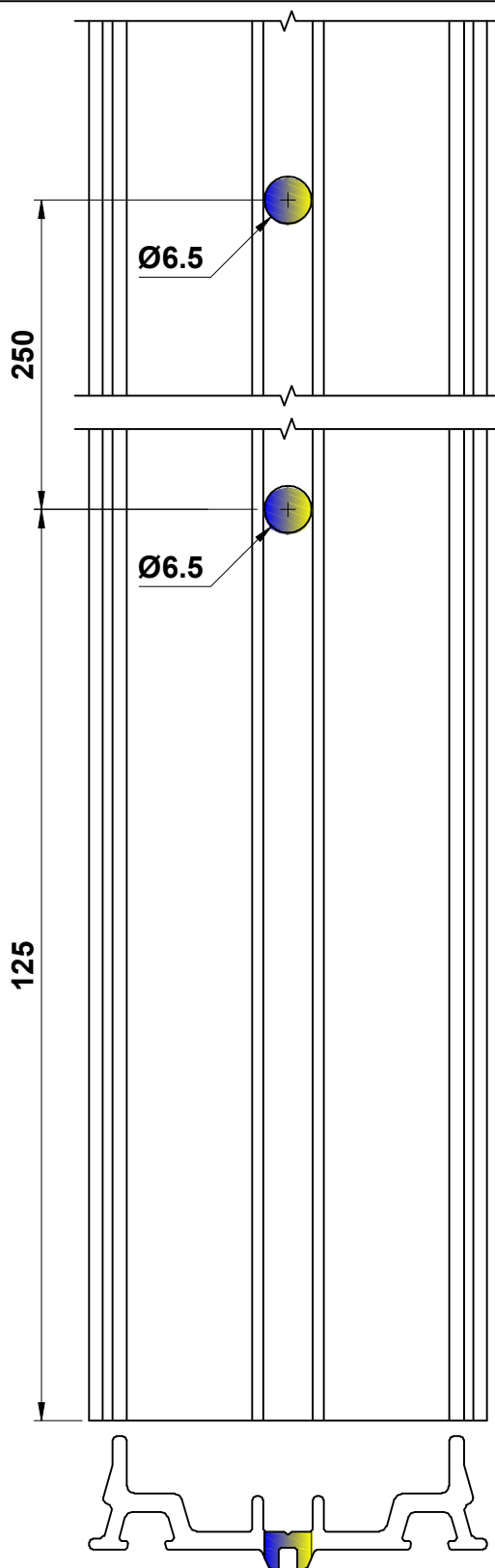
Primary Visible Side

Secondary Visible Side



**MC655H**

Pre-prepped Horizontal Pressure Plate



**MC655V**

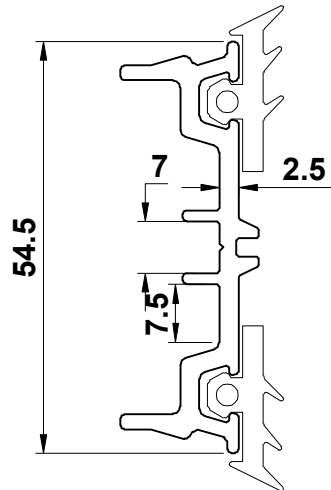
Pre-prepped Vertical Pressure Plate

Scale 1:1

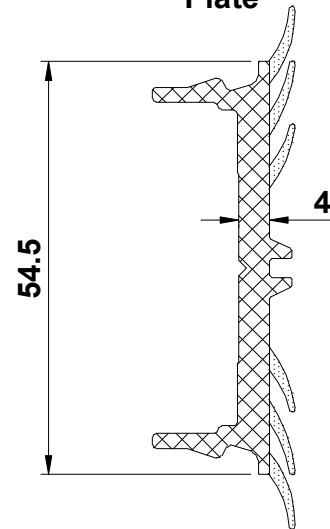
Primary Visible Side

Secondary Visible Side

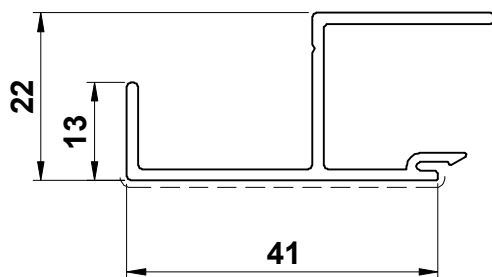
**MC655**  
Aluminium  
Pressure Plate



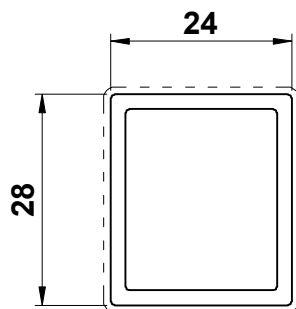
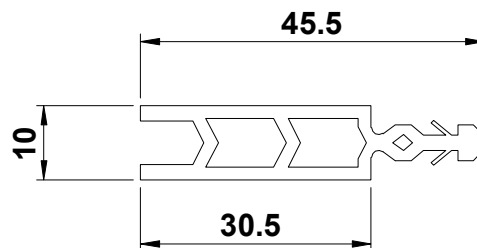
**DK154**  
PVC  
Pressure  
Plate



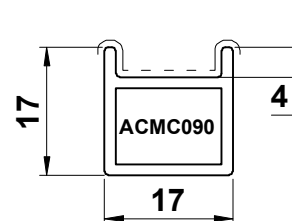
**MC663**  
Infill



**MC601**  
Insulator

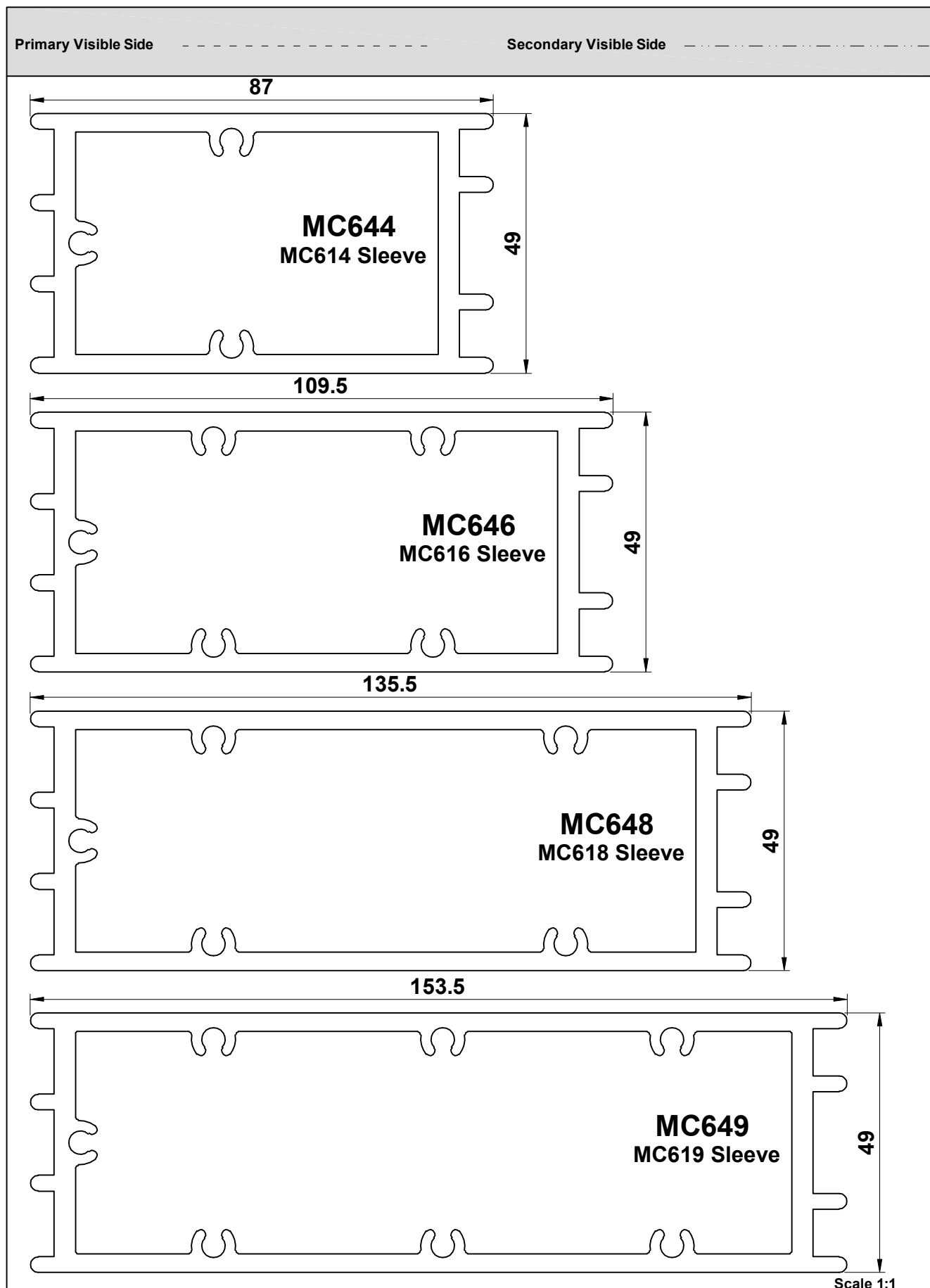


**MC665**  
Infill



**MC900**  
Glazing Reducer

Scale 1:1



**Section B**


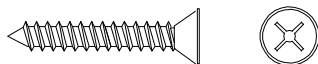
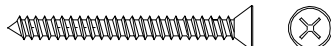
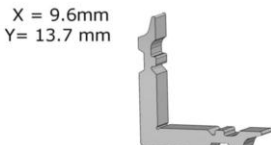
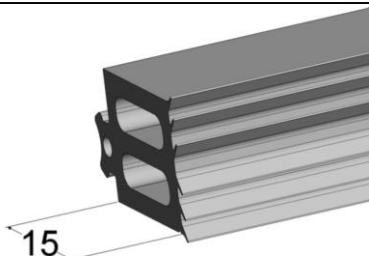


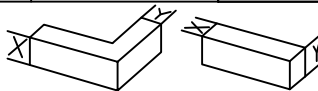
Image	Part Code	Pack	Unit	Application	Colour	
	<b>ACDK066</b>  Fixing Plate for DK154	1	each	<b>DK154</b>	MF	✓
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACET060</b>  No. 7 x 1" CSK S/S Self Tapper	100	pack	<b>ACMC600</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACET062</b>  No. 10 x 2" CSK S/S Self Tapper	100	pack	<b>UTL057</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
 X = 9.6mm Y = 13.7 mm	<b>ACMC090</b> Cleat for Single Glazing Adapter	1	each	<b>MC900</b>	MF	✓
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
 15	<b>ACMC115</b> Gasket for 24mm Glazing	100	m	<b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	✓
					PC	
 T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACV/L150=4.0mm	 Screw (Grub)	<b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome		<b>GOZ</b> = Gold <b>W</b> = White <b>Z</b> = Black		

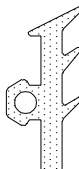
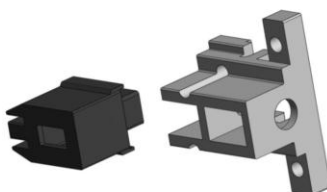
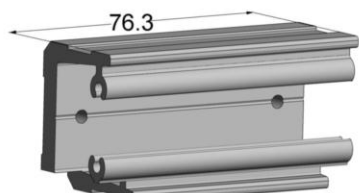
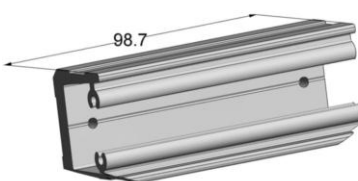
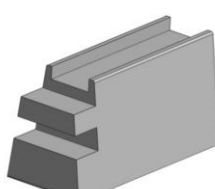



Image	Part Code	Pack	Unit	Application	Colour	
	<b>ACMC150</b>  Gasket for MC150	<b>100</b>	<b>m</b>	<b>MC150</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMC600</b>  Transom Bracket	<b>10</b>	<b>pack</b>	<b>MC613</b> <b>MC614</b> <b>MC616</b> <b>MC618</b> <b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMC602</b>  Shear Block for MC615	<b>20</b>	<b>pack</b>	<b>MC615</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMC603</b>  Shear Block for MC617	<b>20</b>	<b>pack</b>	<b>MC617</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMC604</b>  Transom End Block	<b>20</b>	<b>pack</b>	<b>MC615</b> <b>MC617</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
 <div>T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACV/L150=4.0mm</div>		 <div>Screw (Grub)</div>		<b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome	<b>GOZ</b> = Gold <b>W</b> = White <b>Z</b> = Black	<b>100 pack</b> 

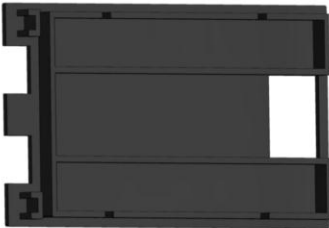
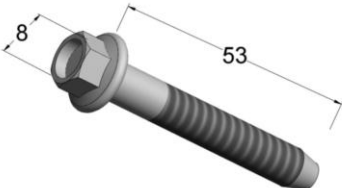
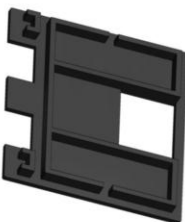




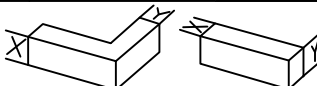
Image	Part Code	Pack	Unit	Application	Colour
	<b>ACMC606</b>  Transom End Pad for MC603	<b>50</b>	<b>pack</b>	<b>MC603</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC610</b>  6.3 x 53mm Hex Head Self Tapper	<b>100</b>	<b>pack</b>	<b>ACDK066 DK154</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC613</b>  Transom End Pad for MC613	<b>50</b>	<b>pack</b>	<b>MC613</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC614</b>  Transom End Pad for MC614	<b>50</b>	<b>pack</b>	<b>MC614</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC616</b>  Transom End Pad for MC616	<b>50</b>	<b>pack</b>	<b>MC616</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
 T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACV/L150=4.0mm	 Screw (Grub)	<b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome		<b>GOZ</b> = Gold <b>W</b> = White <b>Z</b> = Black	




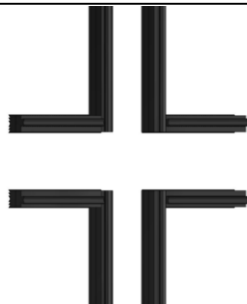
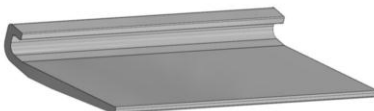


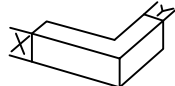
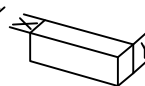
Image	Part Code	Pack	Unit	Application	Colour	
	<b>ACMC618</b>  Transom End Pad for MC618	<b>50</b>	<b>pack</b>	<b>MC618</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	✓
					PC	
	<b>ACMC619</b>  Transom End Pad for MC619	<b>50</b>	<b>pack</b>	<b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	✓
					PC	
	<b>ACMC624</b>  Moulded Corner Gasket for 24mm Units	<b>20</b>	<b>pack</b>	<b>ACMC115</b> <b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	✓
					PC	
	<b>ACMC628</b>  Moulded Corner Gasket for 28mm Units	<b>20</b>	<b>pack</b>	<b>ACSC212</b> <b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	✓
					PC	
	<b>ACMC630</b>  Glazing Support (100mm)	<b>20</b>	<b>pack</b>	<b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	✓
					GOZ	
					W	
					Z	
					PC	
 T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACVL150=4.0mm	 Screw (Grub)	<b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome		<b>GOZ</b> = Gold <b>W</b> = White <b>Z</b> = Black		
		 				



Image	Part Code	Pack	Unit	Application	Colour	
	<b>ACMC632</b>  <b>Moulded Corner Gasket for 32mm Units</b>	<b>20</b>	<b>pack</b>	<b>ACSC208</b> <b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	✓
					PC	
					<div>X = 23.7 mm Y = 7.5 mm</div> 	<b>ACMC641</b>  <b>Cleat</b>
SA						
KL						
HP						
M						
GOZ						
W						
Z						
PC						
	<b>ACMC644</b>  <b>Cover Cap for Splice Joints</b>	<b>10</b>	<b>pack</b>	<b>ACSC208</b> <b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>		
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
						<b>ACMC650</b>  <b>Spring Pin with Hook</b>
SA						
KL						
HP						
M						
GOZ						
W						
Z	✓					
PC						
	<b>ACMC651</b>  <b>Fixed Anti-Rotation Pin with Hook</b>	<b>1</b>	<b>each</b>	<b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>		
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
					 <div>T-BARS ACV065=2.5mm ACV066=3.0mm ACVL150=4.0mm</div>  <div>Screw (Grub)</div>	<div><b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome</div> <div><b>GOZ</b> = Gold <b>W</b> = White <b>Z</b> = Black</div>

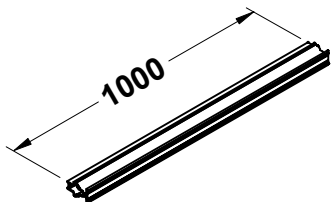
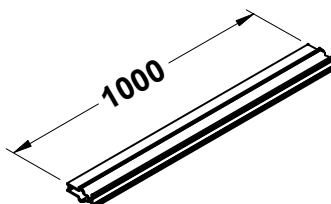
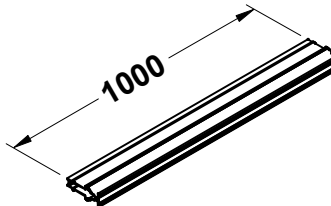
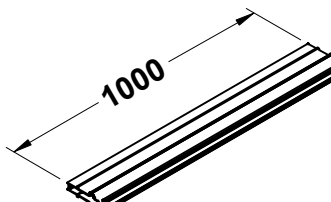
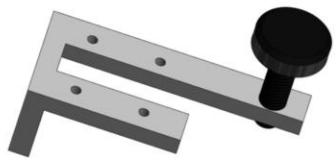


Image	Part Code	Pack	Unit	Application	Colour
	<b>ACMC684</b>  1000mm Sleeve for MC614 with ACVS010 inserts  Produced from MC684	1	each	<b>MC614</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC686</b>  1000mm Sleeve for MC616 with ACVS010 inserts  Produced from MC686	1	each	<b>MC616</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC688</b>  1000mm Sleeve for MC618 with ACVS010 inserts  Produced from MC688	1	each	<b>MC618</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC689</b>  1000mm Sleeve for MC619 with ACVS010 inserts  Produced from MC689	1	each	<b>MC619</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC691</b>  Transom Drill Jig - Dual Purpose for Transom Brackets and Shear blocks	1	each	<b>MC613</b> <b>MC614</b> <b>MC616</b> <b>MC618</b> <b>MC619</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
 T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACV/L150=4.0mm	 Screw (Grub)	<b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome	<b>GOZ</b> = Gold <b>W</b> = White <b>Z</b> = Black		

Image	Part Code	Pack	Unit	Application	Colour
	<b>ACMC692</b>  Mullion Drill Jig for Shear Block	1	each	<b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMC695</b>  Mullion Drill Jig for ACMC650 & ACMC651	1	each	<b>MC613</b> <b>MC614</b> <b>MC616</b> <b>MC618</b> <b>MC619</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACSC208</b>  Gasket for 32mm Glazing	100	m	<b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACSC212</b>  Gasket for 28mm Glazing	100	m	<b>MC613</b> <b>MC614</b> <b>MC615</b> <b>MC616</b> <b>MC617</b> <b>MC618</b> <b>MC619</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>PUA028</b>  No. 10 x 1" P/H Self Tapper	100	pack	<b>ACMC600</b>	MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
 T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACVL150=4.0mm	 Screw (Grub)	<b>MF</b> = Mill Finish <b>SA</b> = Silver Anodised <b>KL</b> = Basic Colour <b>HP</b> = Special Colour <b>M</b> = Dual Colour <b>PC</b> = Polished Chrome	GOZ = Gold W = White Z = Black		





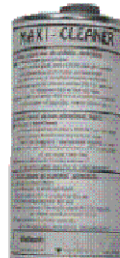


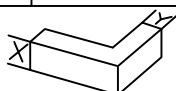

Image	Part Code	Pack	Unit	Application	Colour	
	<b>ACMX09700</b>  <b>Alu. Polish</b>	<b>1</b>	<b>each</b>		MF	✓
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMX09761</b>  <b>Maxi Gloss</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMX09762</b>  <b>Alu. Bright</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMX09763</b>  <b>Teflon Spray</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMX09764</b>  <b>Maxi Clean</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
 T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACV/L150=4.0mm	 Screw (Gnub)	<b>MF = Mill Finish</b> <b>SA = Silver Anodised</b> <b>KL = Basic Colour</b> <b>HP = Special Colour</b>		<b>M = Dual Colour</b> <b>GOZ = Gold</b> <b>W = White</b> <b>Z = Black</b>	 	

Image	Part Code	Pack	Unit	Application	Colour
	<b>ACMX09765</b>  <b>Alu. Cleaner</b>	<b>1</b>	<b>each</b>		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMX09770</b>  <b>Roll &amp; Wrap 100mm</b>	<b>1</b>	<b>each</b>		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMX09775</b>  <b>Grip Handwrap</b>	<b>1</b>	<b>each</b>		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMX09801</b>  <b>Protective Tape 50mm</b>	<b>1</b>	<b>each</b>		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
	<b>ACMX09802</b>  <b>Protective Tape 70mm</b>	<b>1</b>	<b>each</b>		MF
					SA
					KL
					HP
					M
					GOZ
					W
					Z
					PC
 T-BARS ACVGB5=2.5mm ACVGB6=3.0mm ACVL150=4.0mm	 Screw (Grub)	<b>MF = Mill Finish</b> <b>SA = Silver Anodised</b> <b>KL = Basic Colour</b> <b>HP = Special Colour</b>		<b>M = Dual Colour</b> <b>GOZ = Gold</b> <b>W = White</b> <b>Z = Black</b>	 








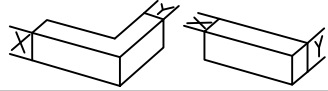


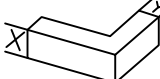
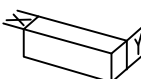
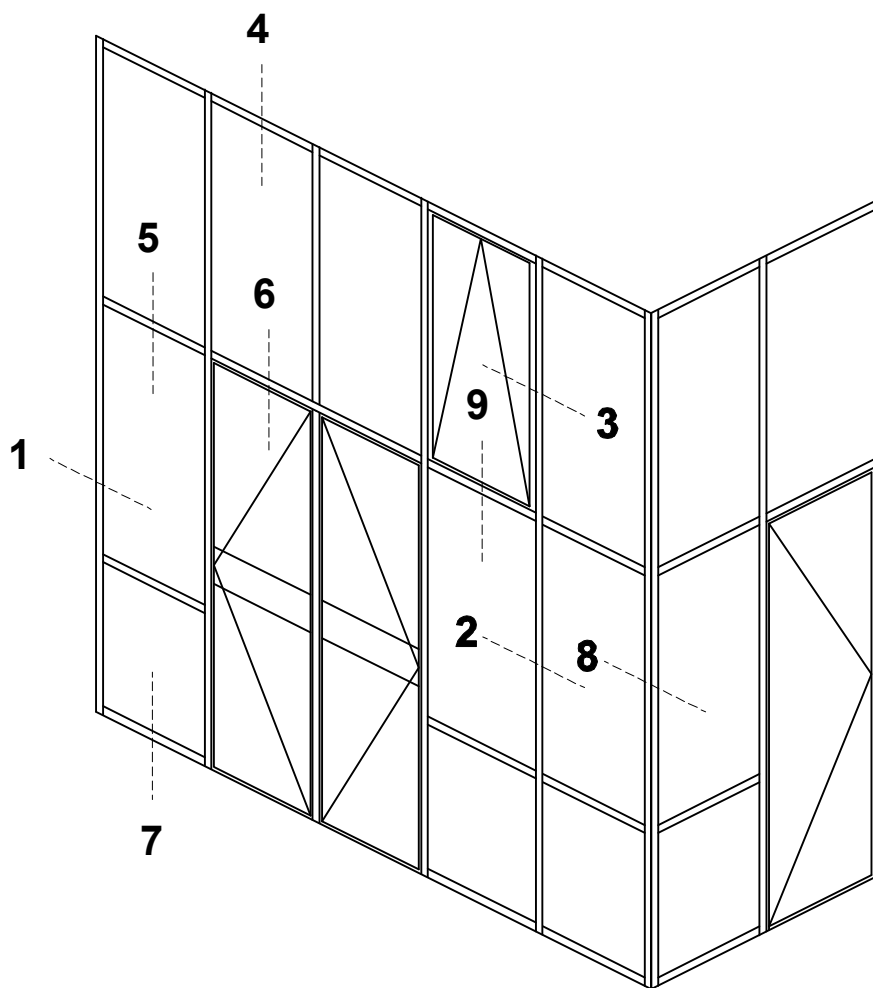
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					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACMX09830</b>  <b>Rubber Sealant</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACSIL04</b>  <b>Sealing Glue</b> <b>Order with suffix of KL</b> <b>colour (eg.ACSIL04KL005)</b> <b>or BL=Black/WP=White/</b> <b>CL=Clear</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	✓
					HP	
					M	
					GOZ	
					W	✓
					Z	✓
					PC	
	<b>ACSIL08</b>  <b>Silicon Gun</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
	<b>ACSIL013</b>  <b>Glue for Mitre</b>	<b>1</b>	<b>each</b>		MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
 T-BARS ACV065=2.5mm ACV066=3.0mm ACVL150=4.0mm	 Screw (Grub)	<b>MF = Mill Finish</b> <b>SA = Silver Anodised</b> <b>KL = Basic Colour</b> <b>HP = Special Colour</b>		<b>M = Dual Colour</b> <b>GOZ = Gold</b> <b>W = White</b> <b>Z = Black</b>		

Image	Part Code	Pack	Unit	Application	Colour	
					MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
					MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
					MF	
					SA	
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					HP	
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					Z	
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					PC	
					MF	
					SA	
					KL	
					HP	
					M	
					GOZ	
					W	
					Z	
					PC	
<div><div><p>T-BARS ACV/G65=2.5mm ACV/G66=3.0mm ACV/L150=4.0mm</p></div><div><p>Screw (Grub)</p></div></div>	<div><div><b>MF = Mill Finish</b> <b>SA = Silver Anodised</b> <b>KL = Basic Colour</b> <b>HP = Special Colour</b></div><div><b>M = Dual Colour</b> <b>GOZ = Gold</b> <b>W = White</b> <b>Z = Black</b></div></div>	<div><div></div><div></div></div>				

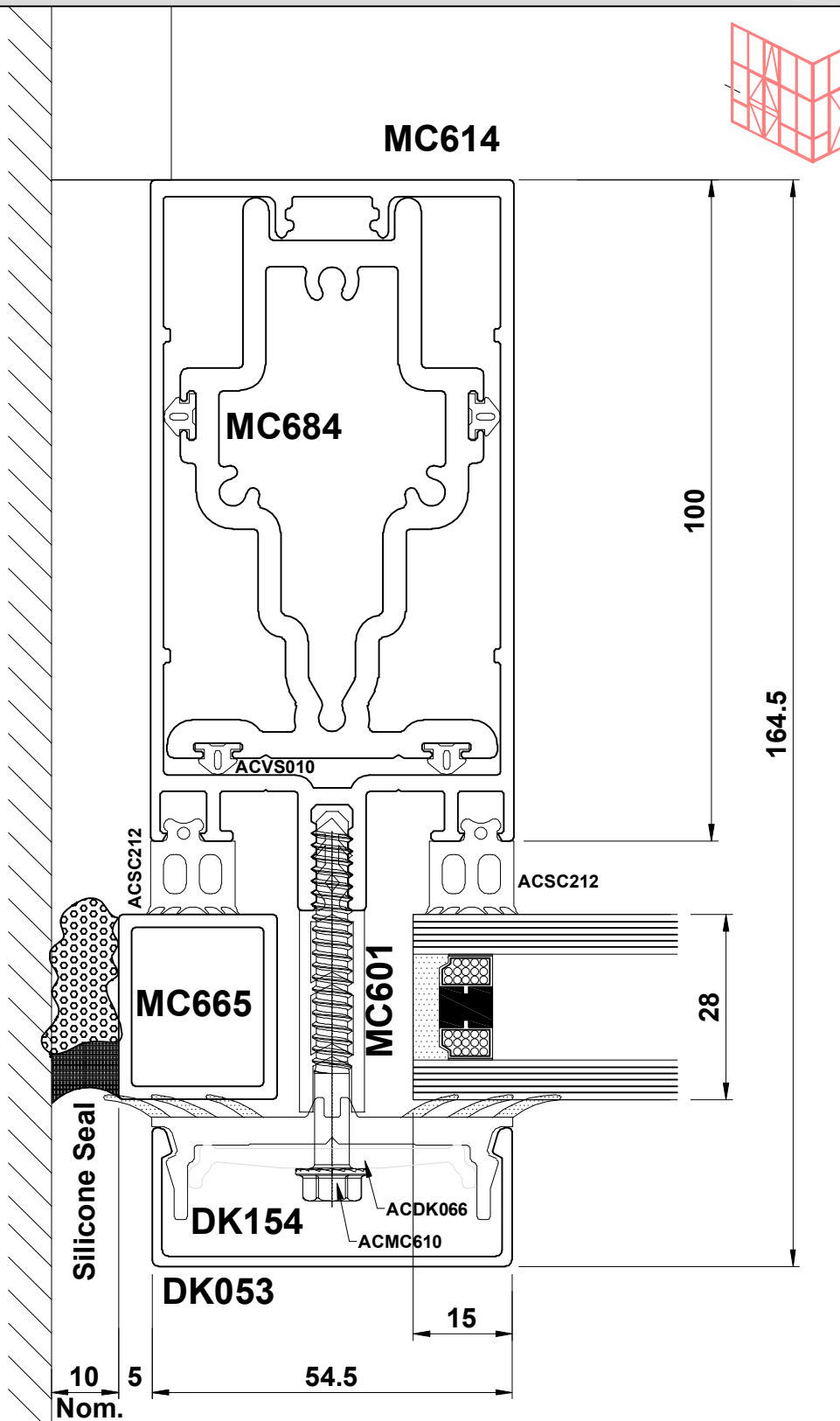
**Section C**





**End Mullion**

**Detail 1a**

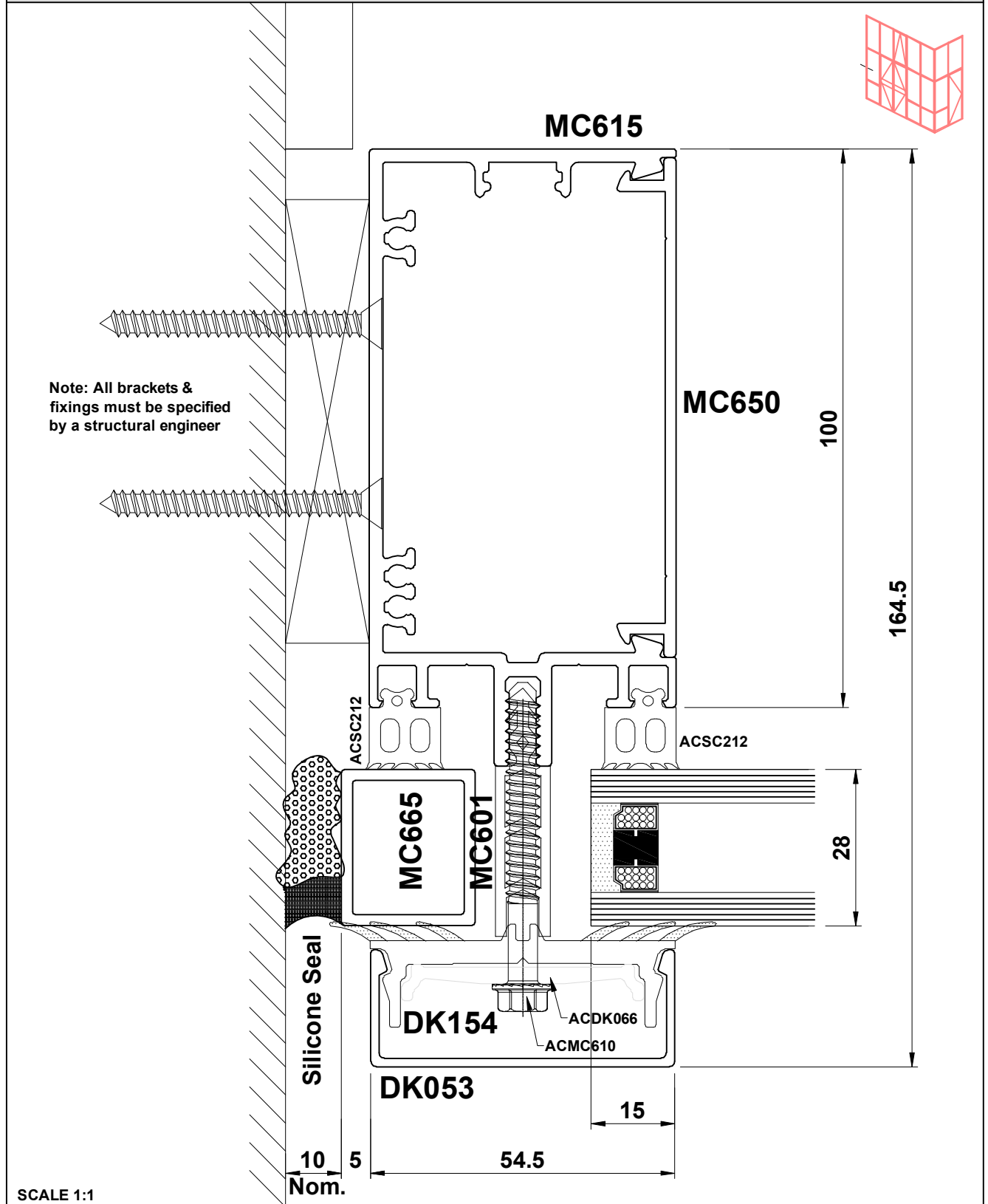


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**Do Not Scale From This Drawing**

Open Box Mullion

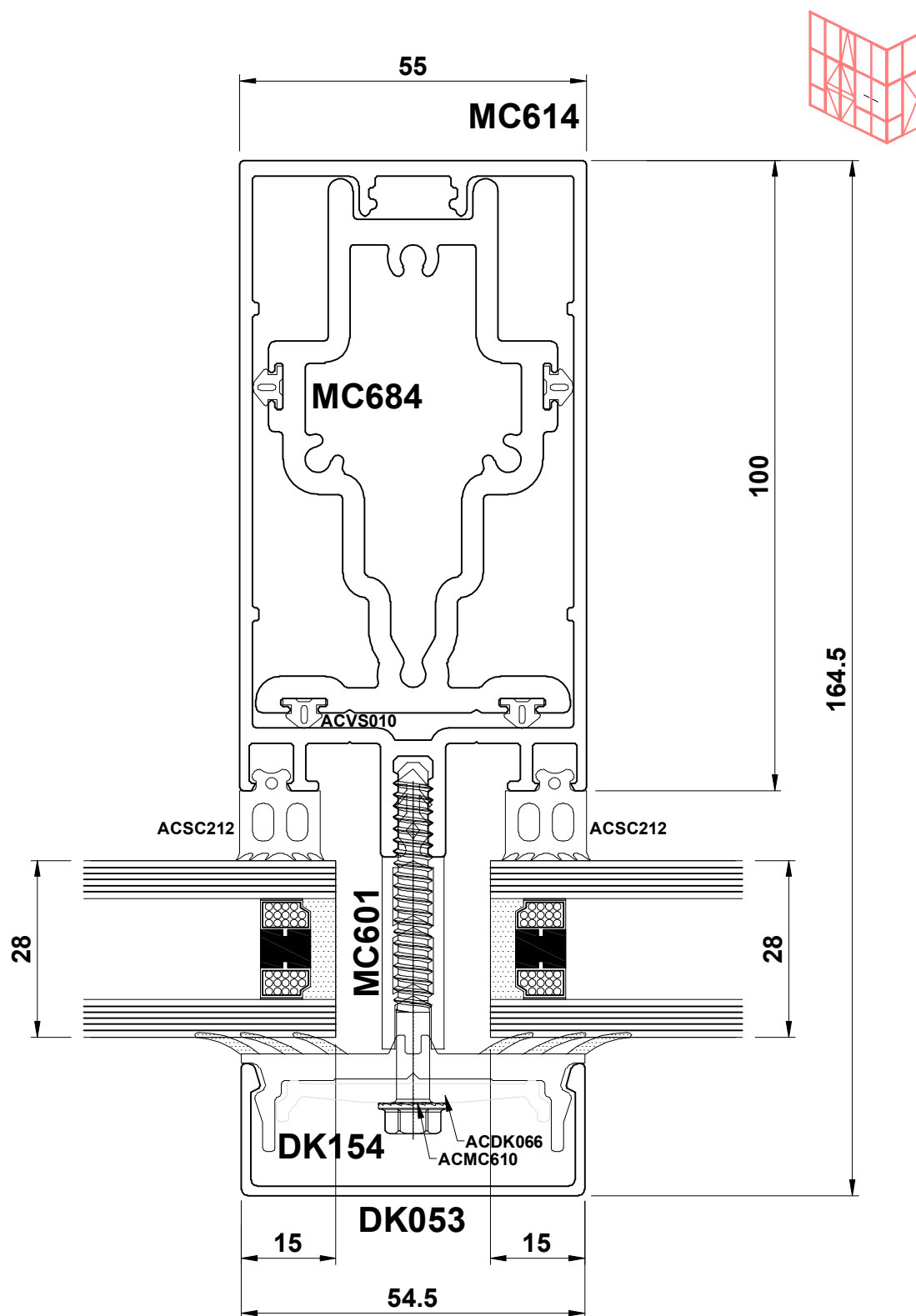
Detail 1b



Do Not Scale From This Drawing

**Mullion Detail**

**Detail 2a**

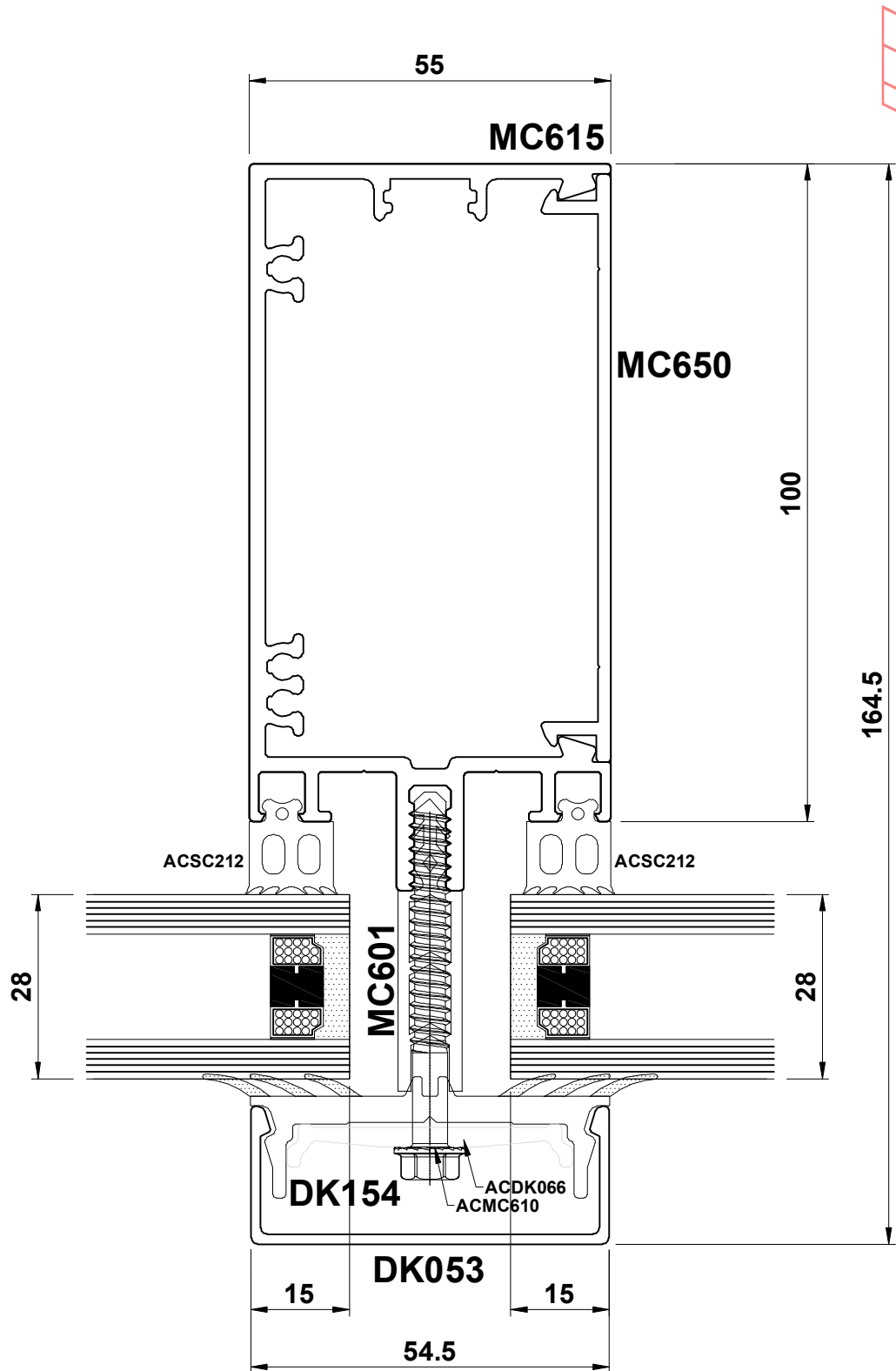


SCALE 1:1

**Do Not Scale From This Drawing**

**Open Box Mullion**

**Detail 2b**

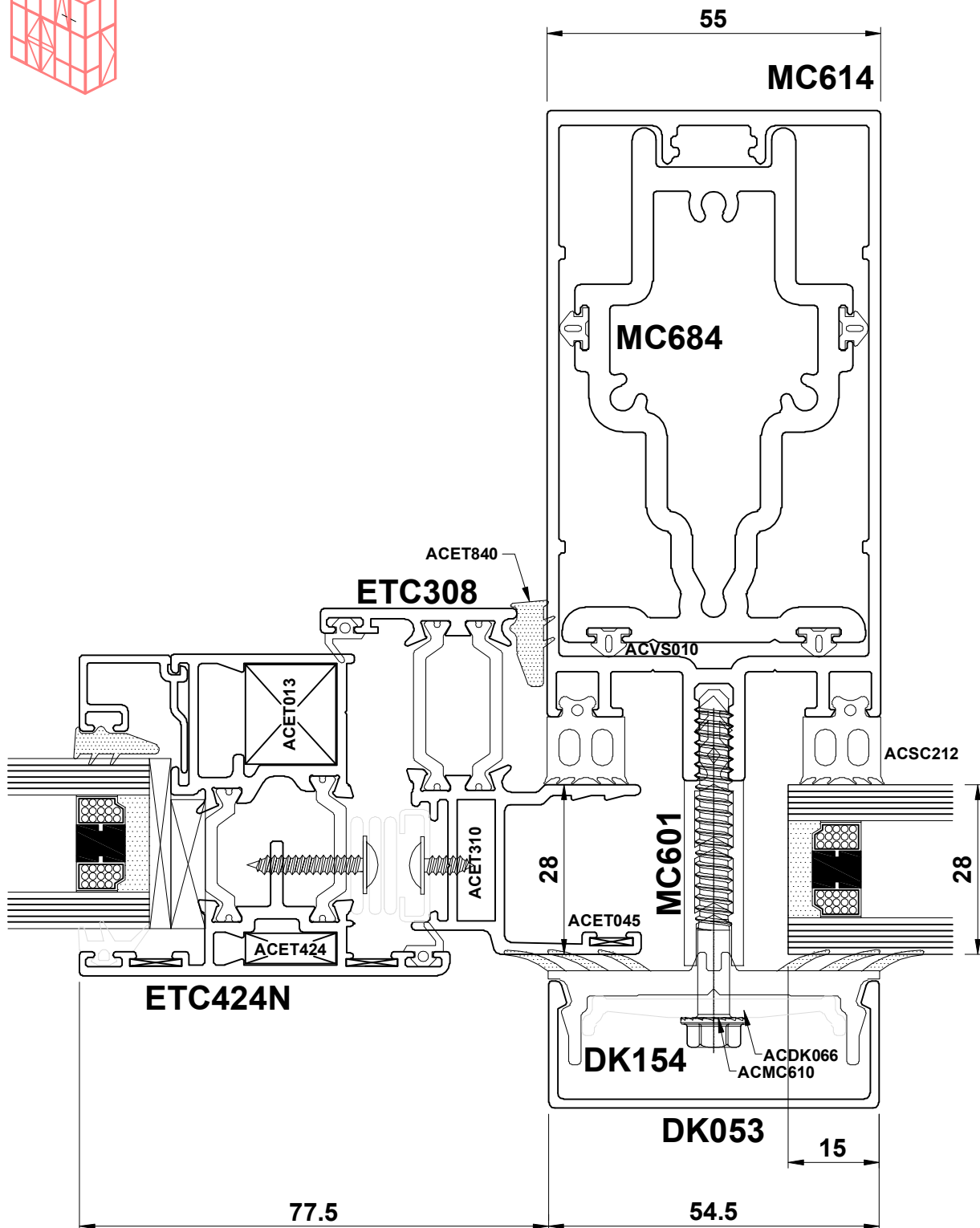
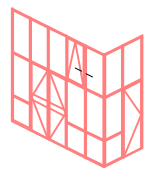


SCALE 1:1

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**Mullion Detail**

**Detail 3a**

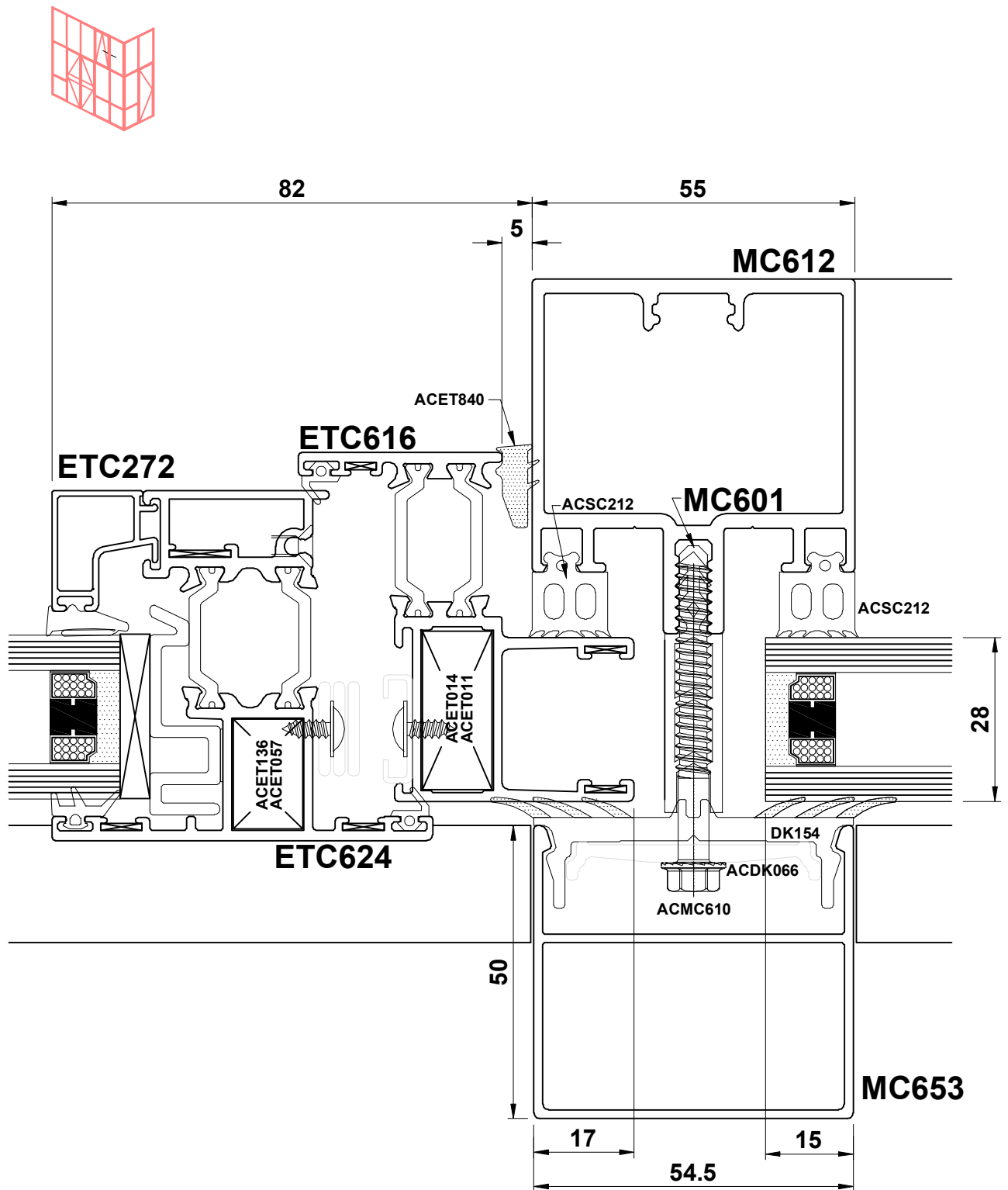


SCALE 1:1

**Do Not Scale From This Drawing**

**Mullion Detail**

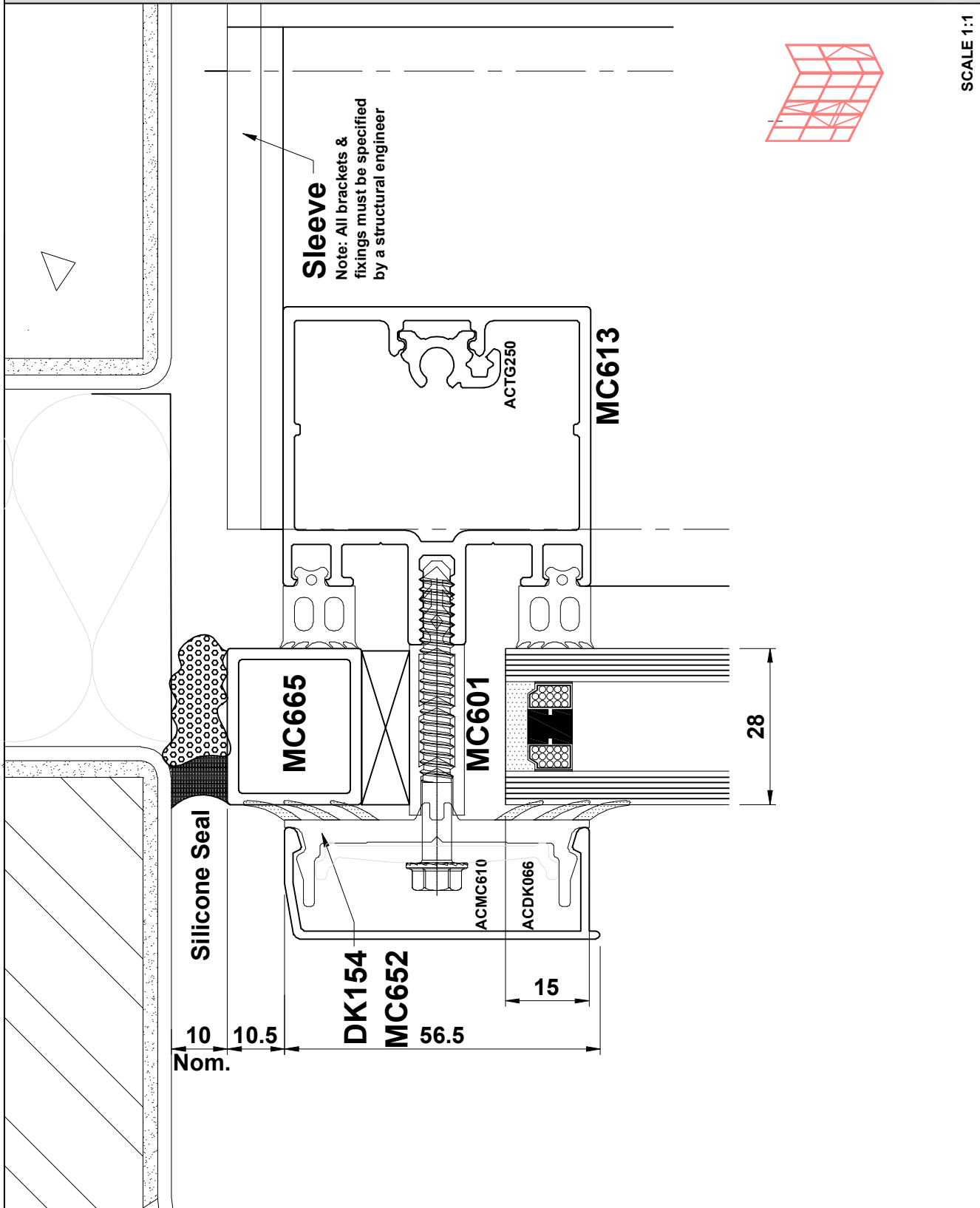
**Detail 3b**



**Do Not Scale From This Drawing**

**Top Transom**

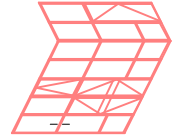
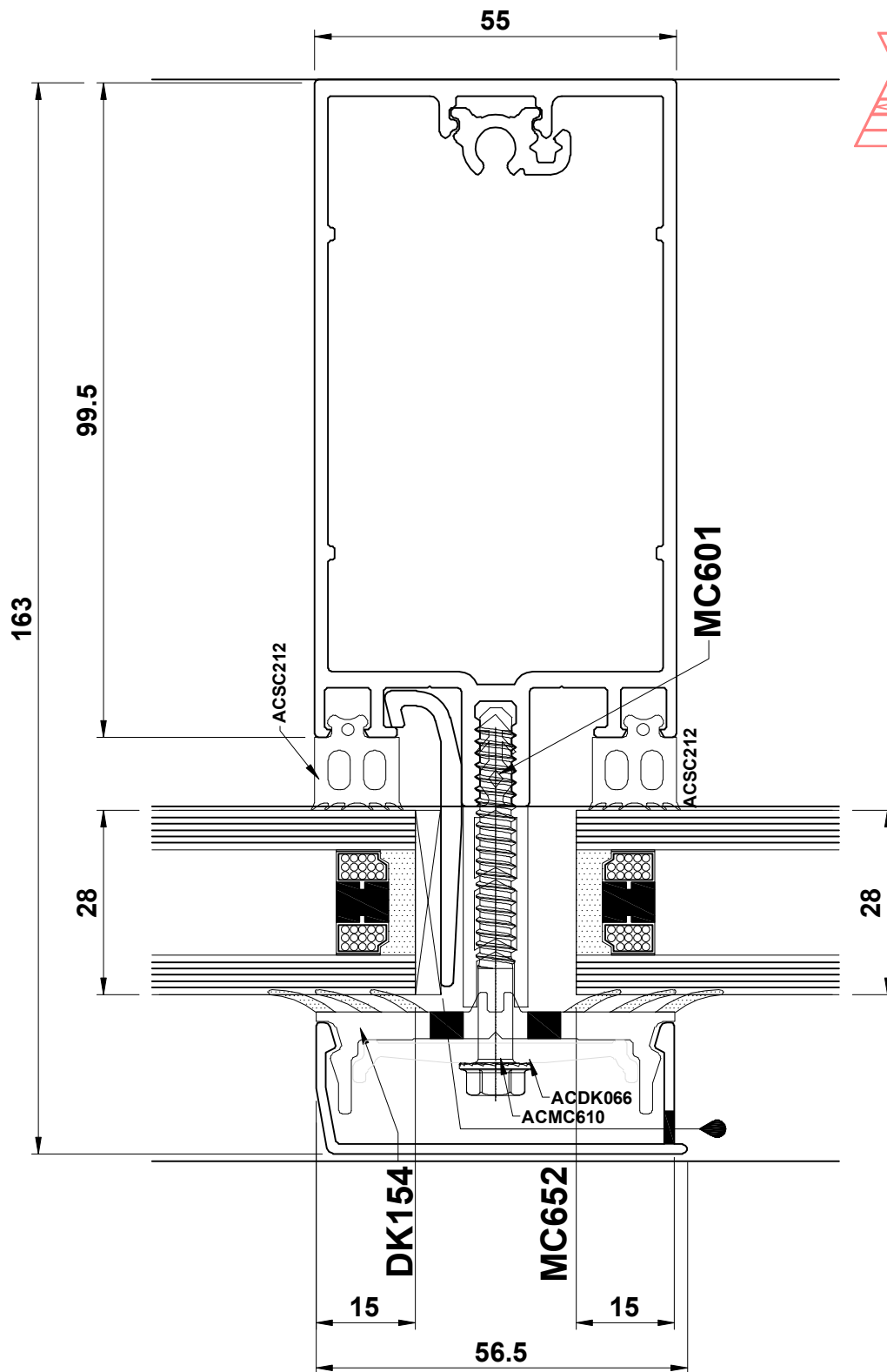
**Detail 4**



**Do Not Scale From This Drawing**

**Transom**

**Detail 5a**



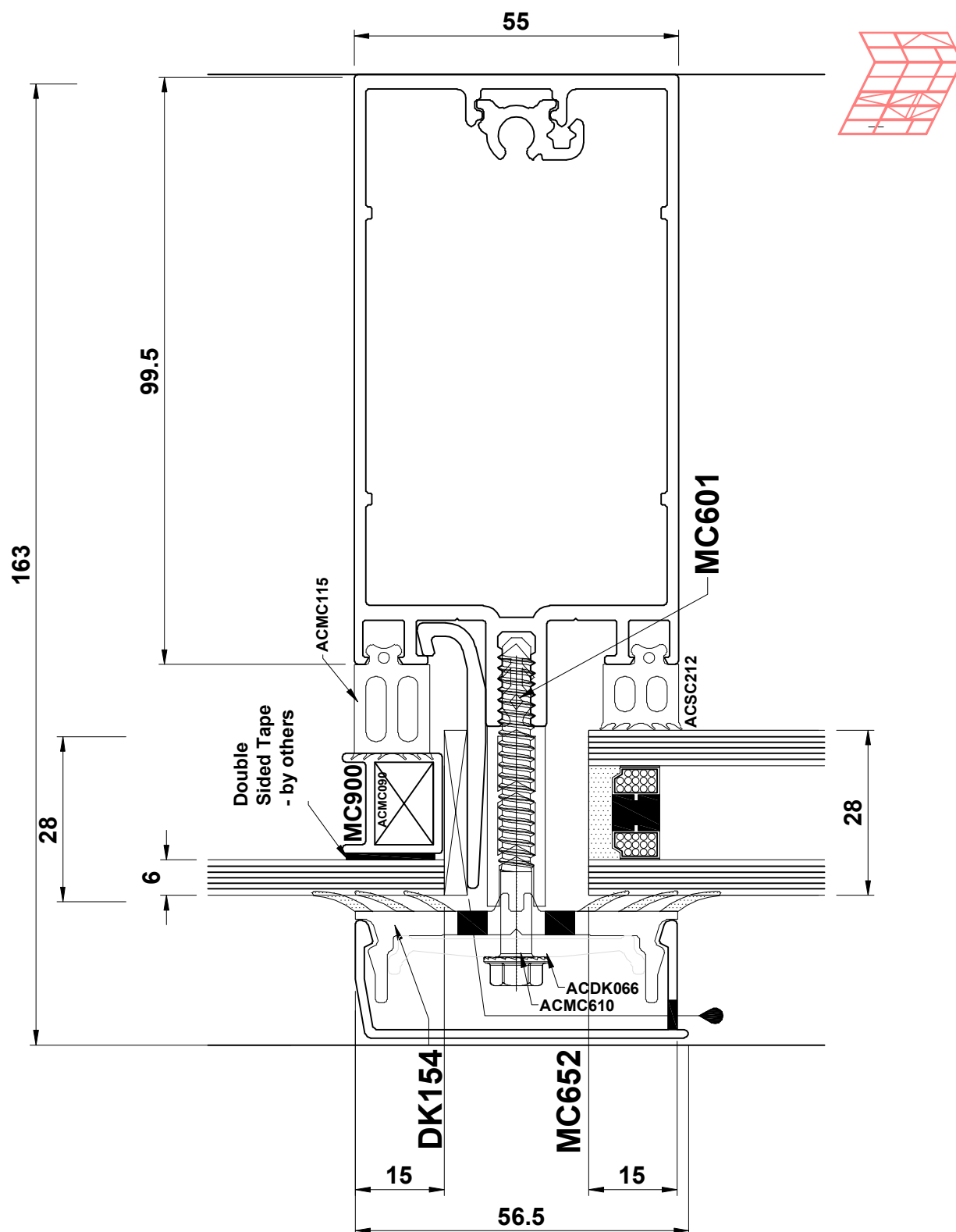
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**Do Not Scale From This Drawing**



**Transom**

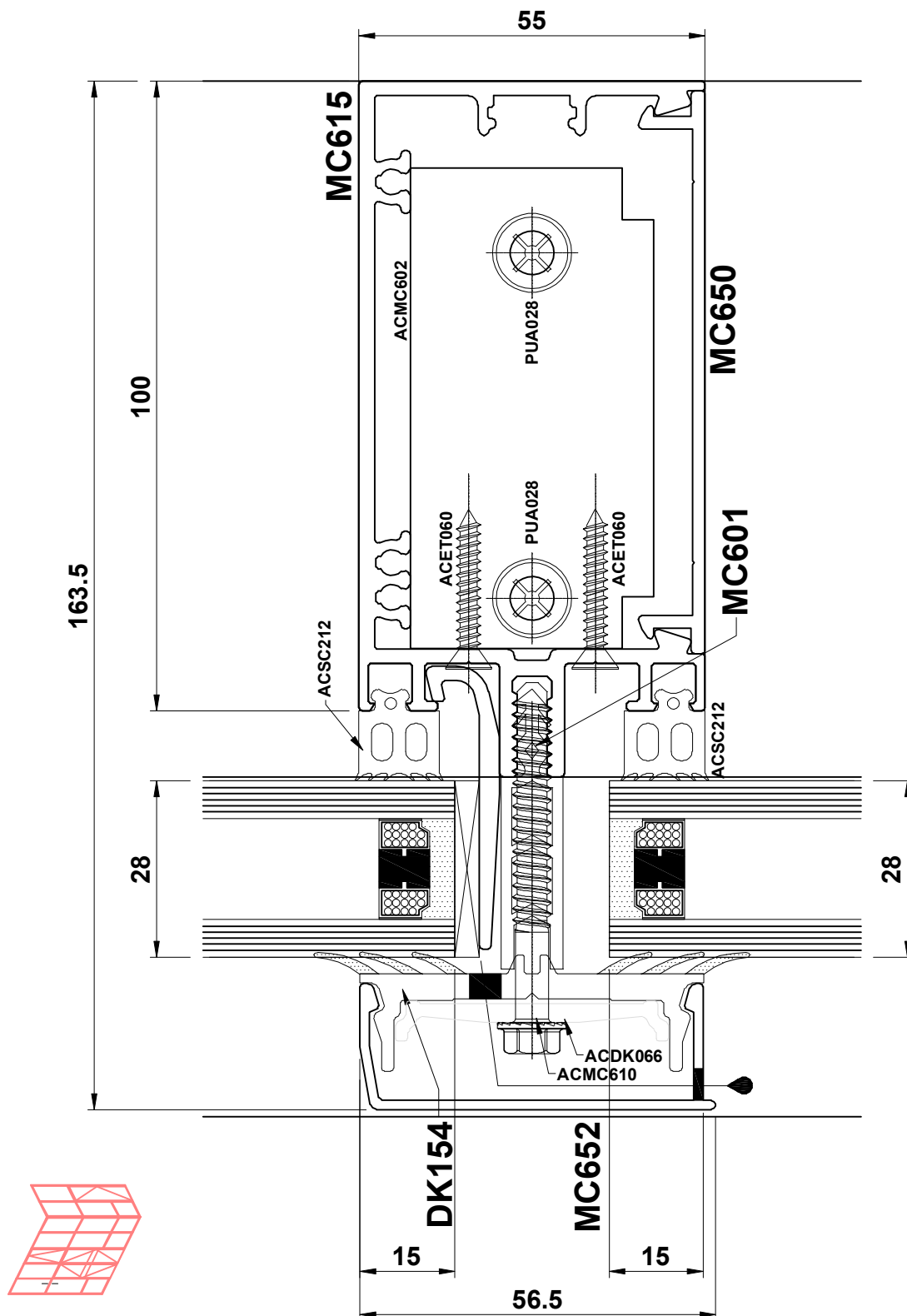
**Detail 5b**



**Do Not Scale From This Drawing**

**Open Box Transom**

**Detail 5c**

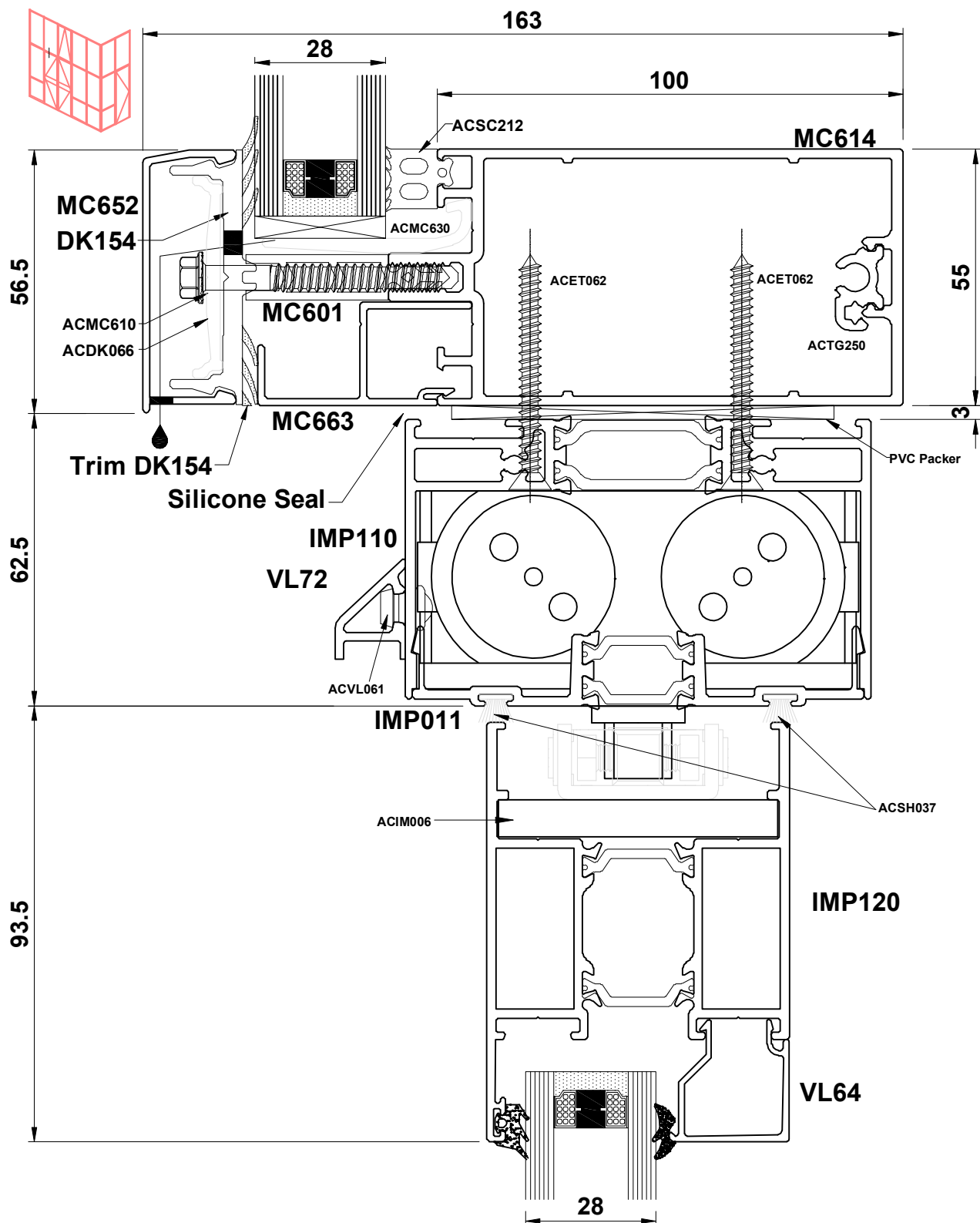


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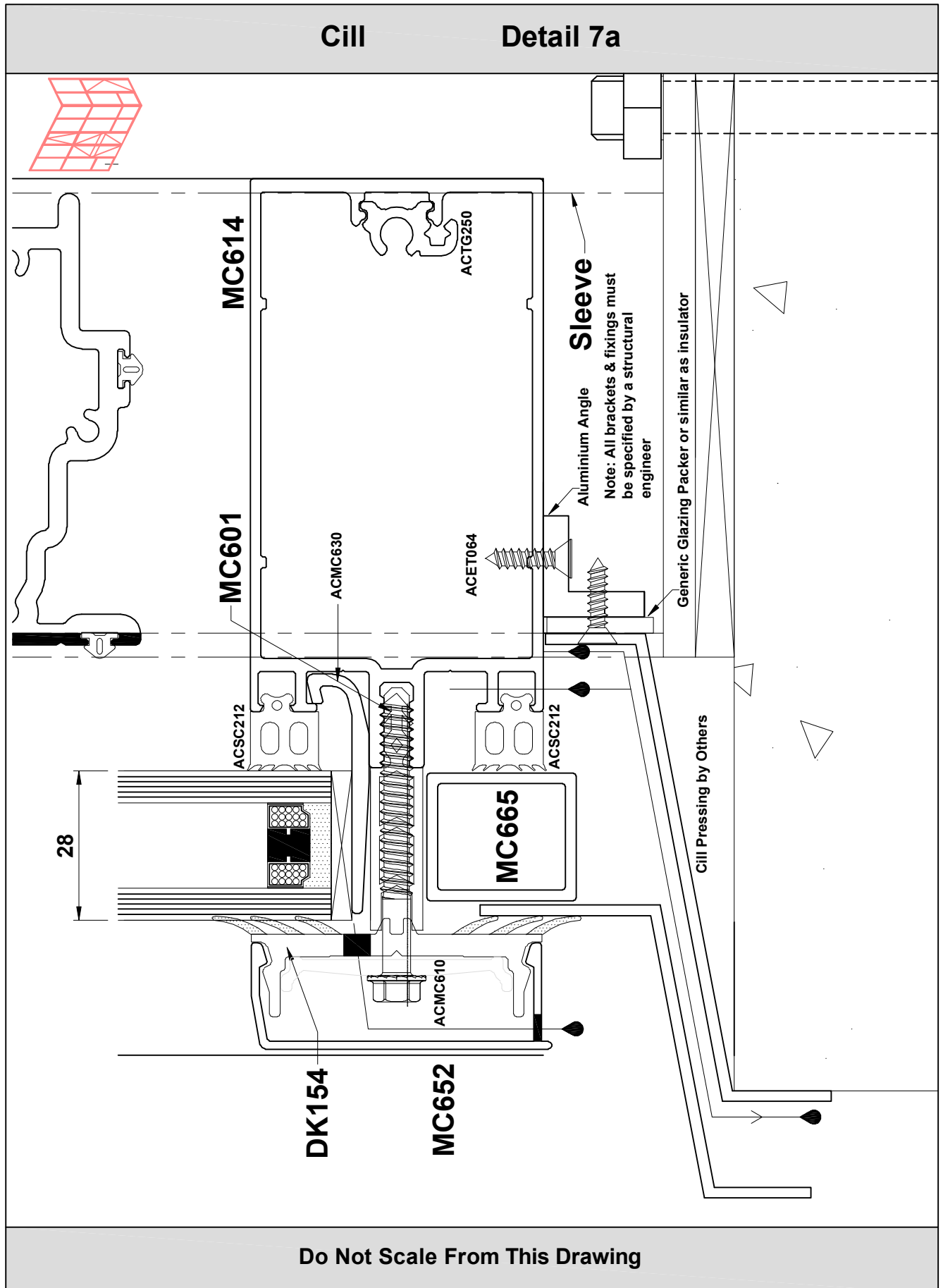
**Transom Above Door**

**Detail 6**



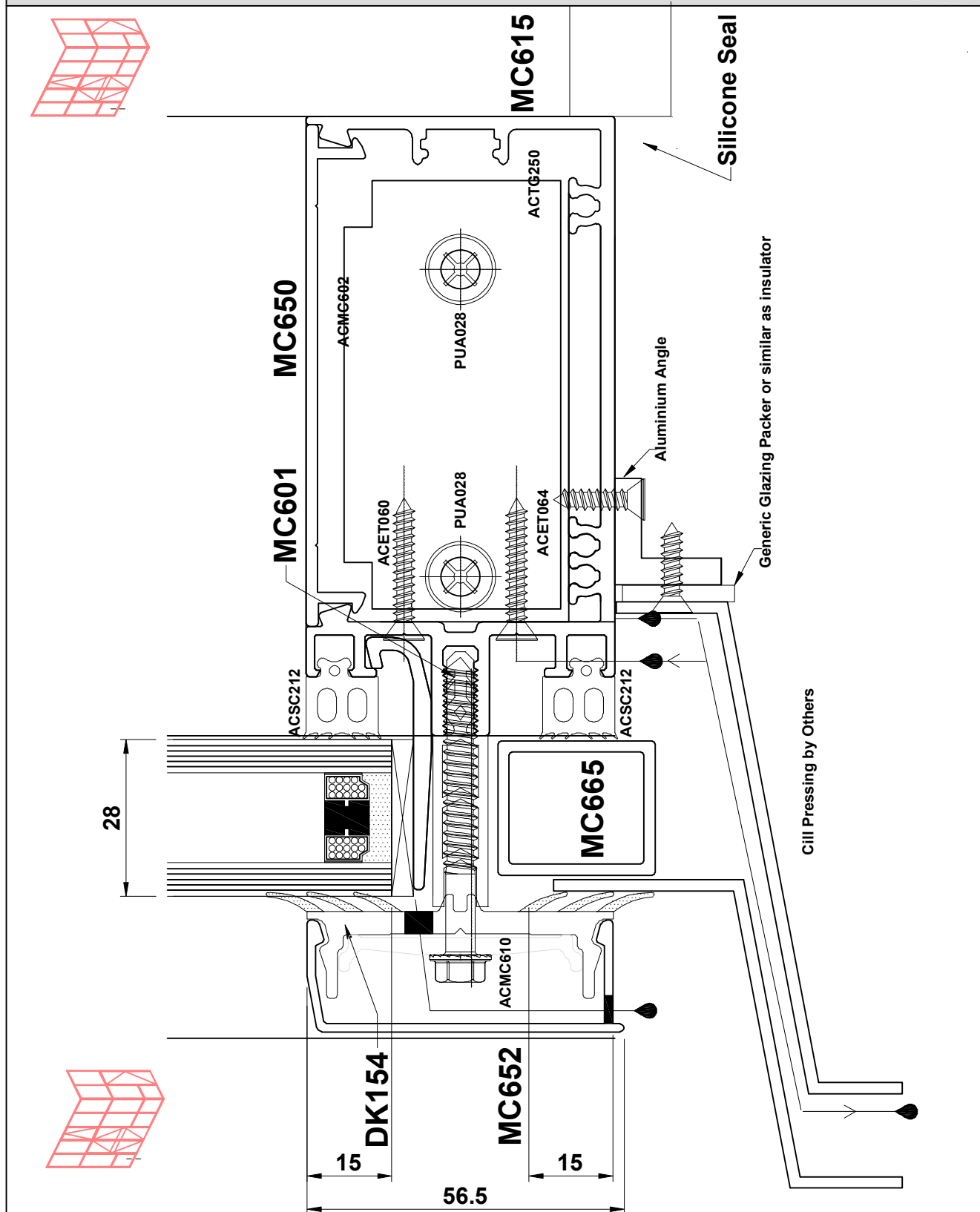
SCALED TO FIT

**Do Not Scale From This Drawing**



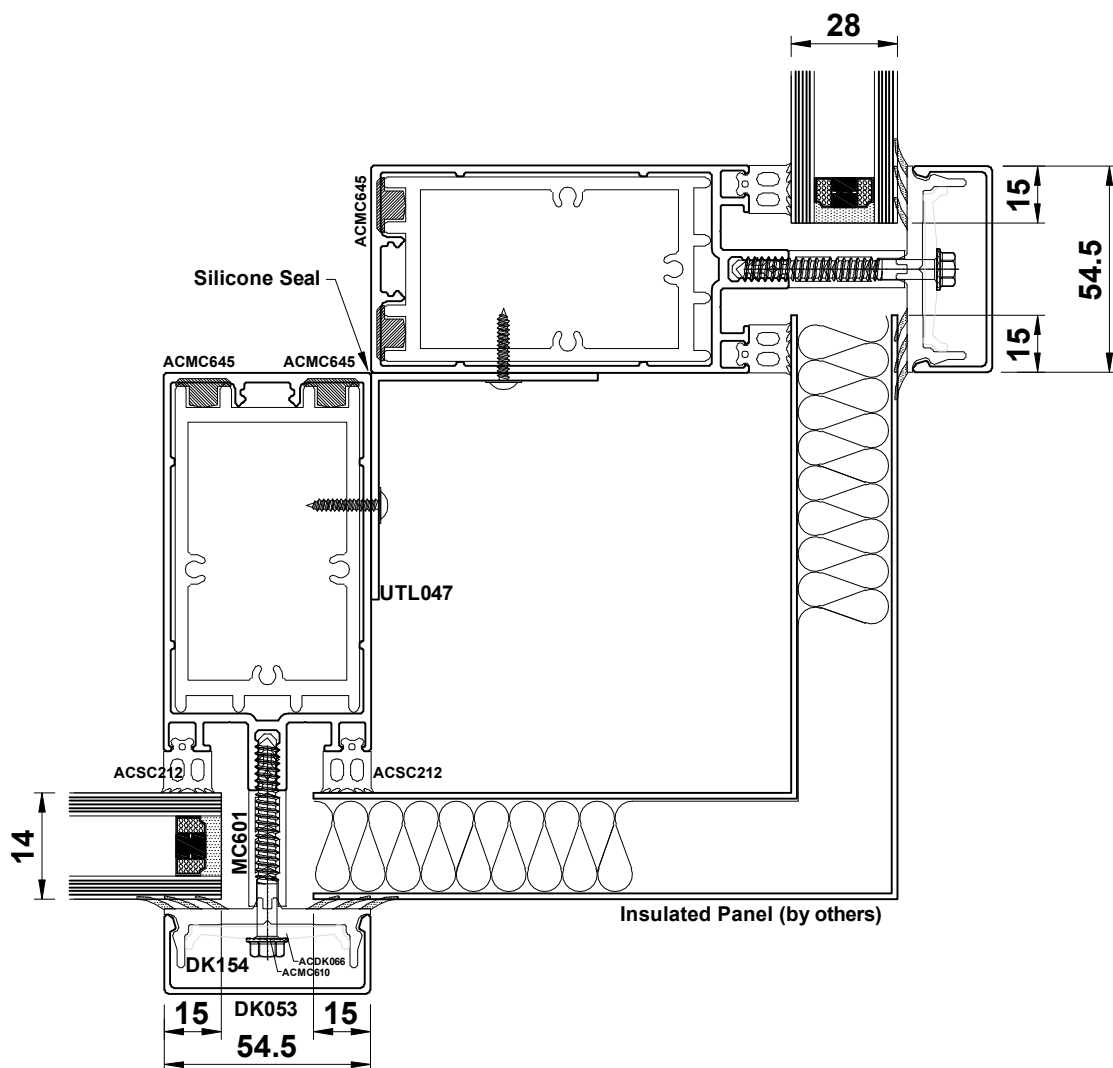
Open Box Cill

Detail 7b



Do Not Scale From This Drawing

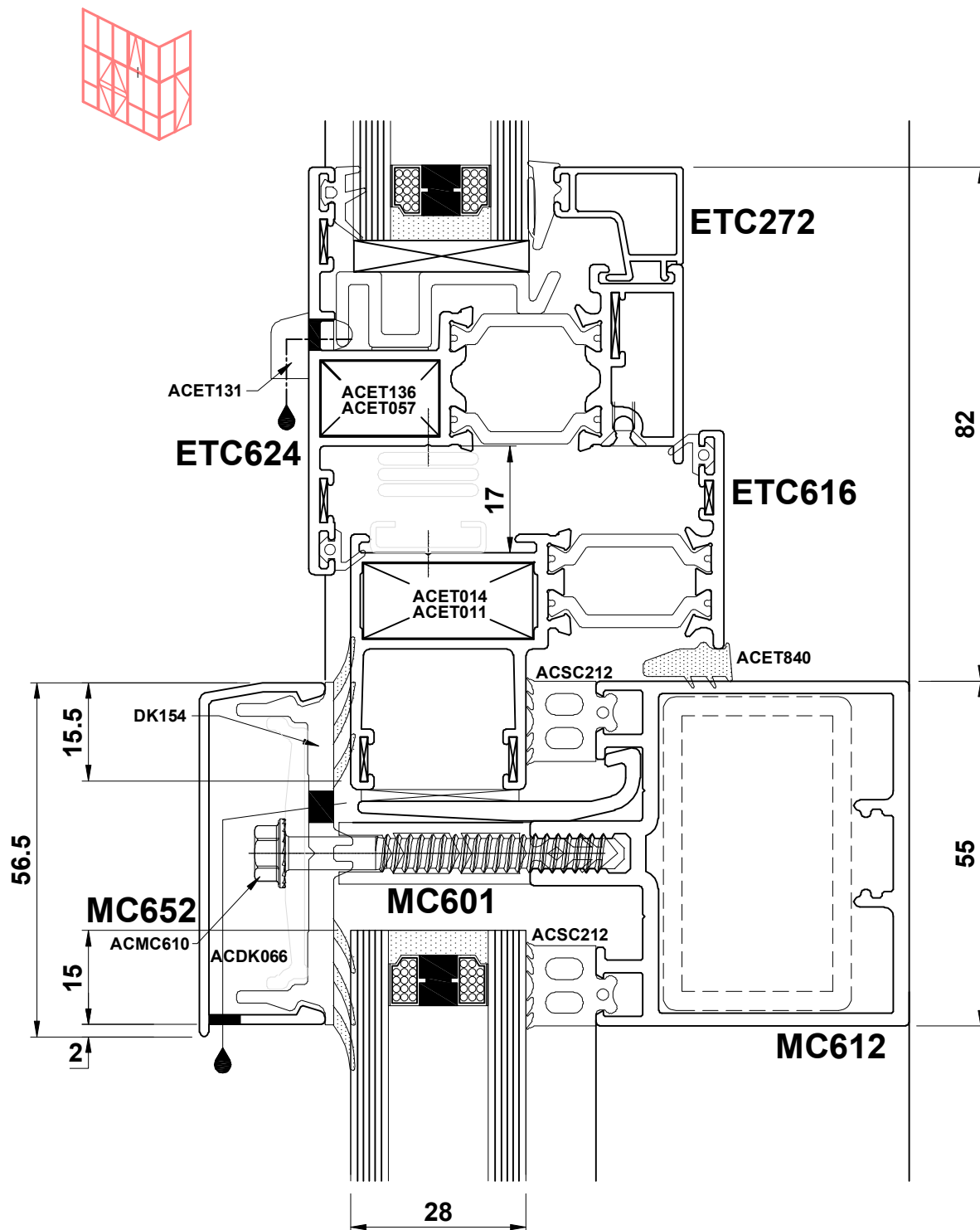
## Corner Pressing Detail 8



**Do Not Scale From This Drawing**

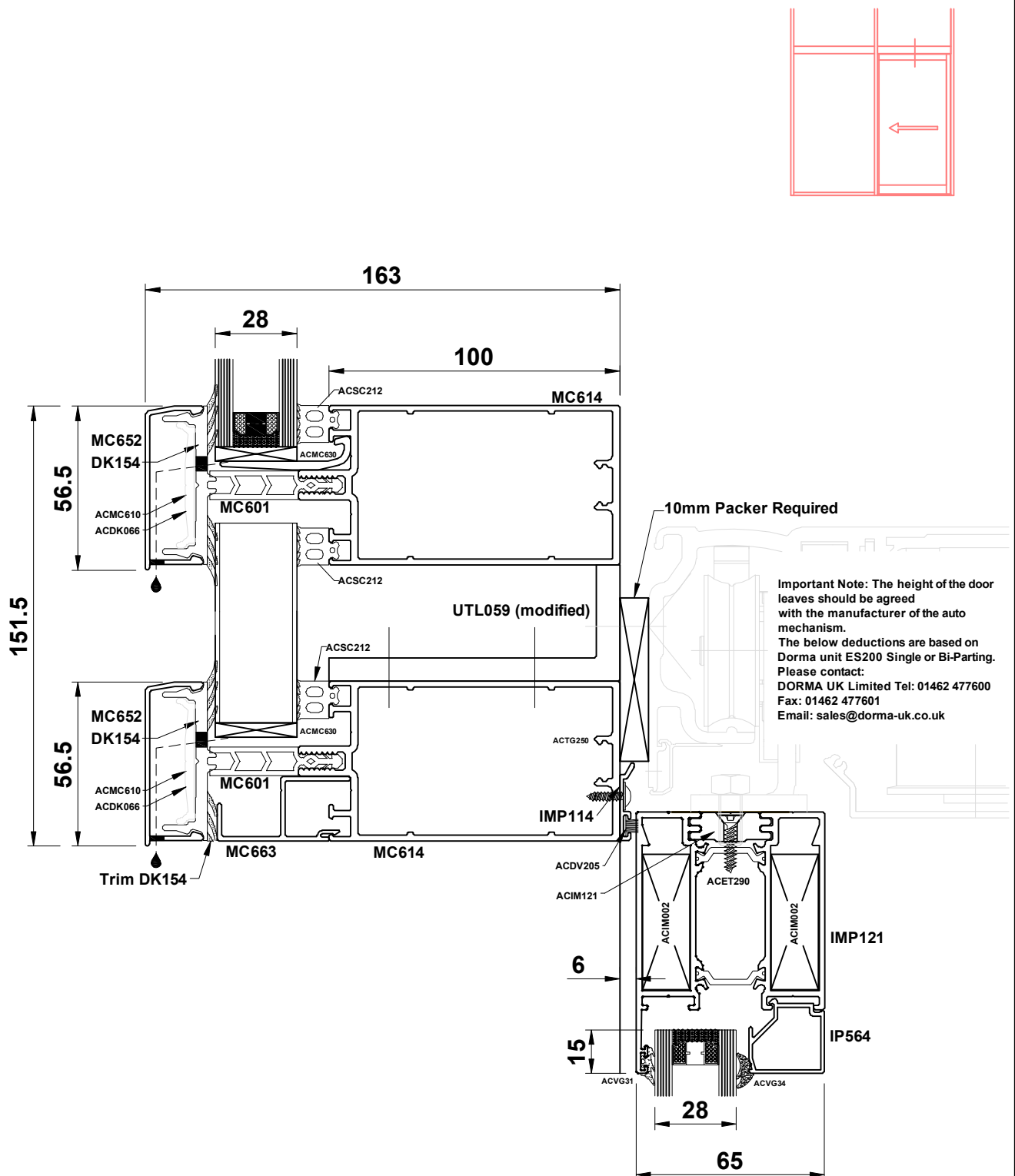
**Opening Vent to Transom**

**Detail 9**



**Do Not Scale From This Drawing**

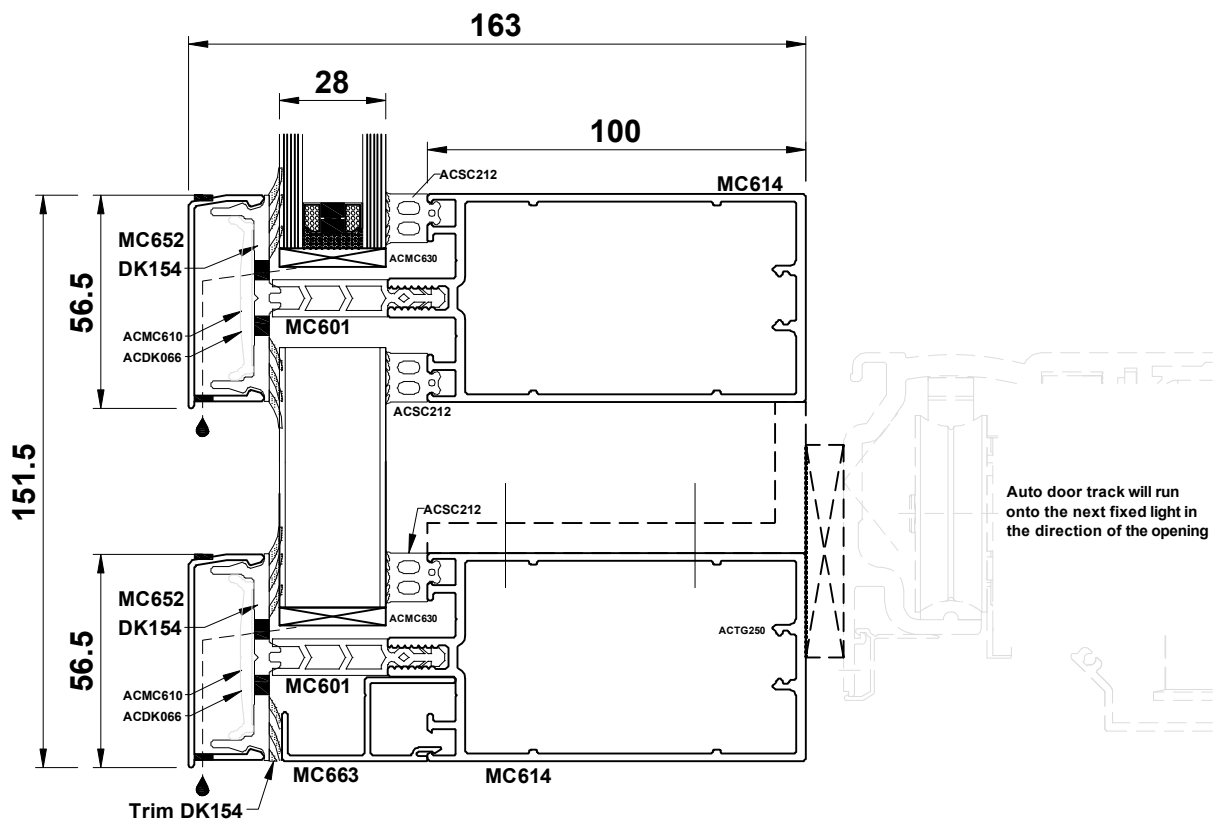
## Auto Sliding Door - Head



Do Not Scale From This Drawing

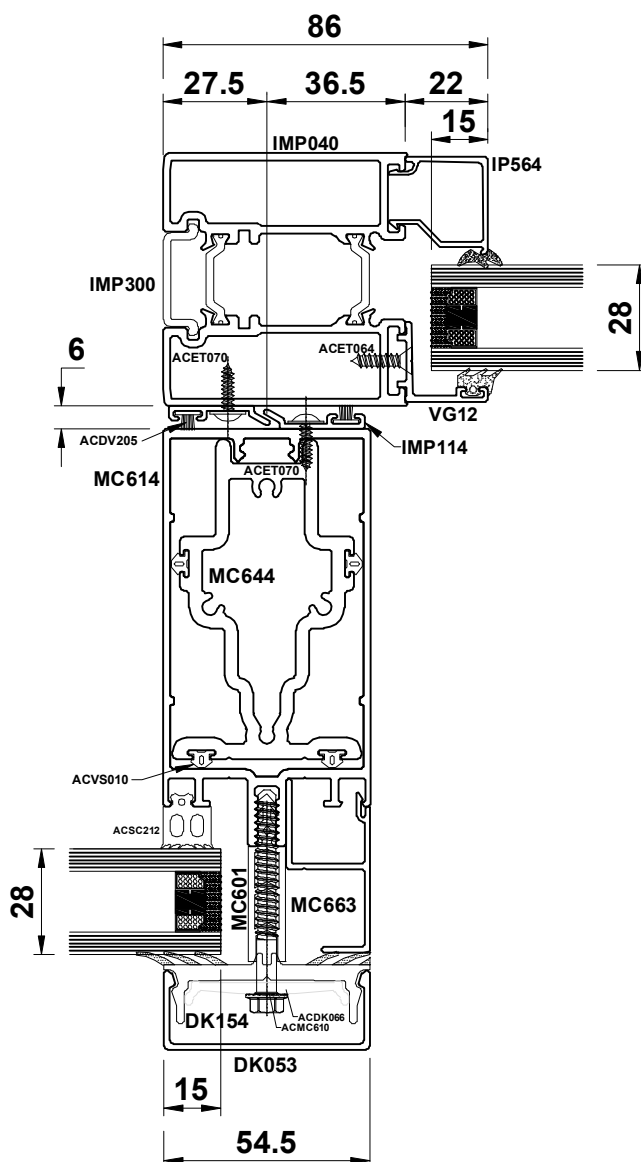
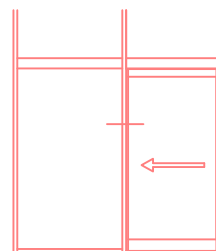


## Auto Sliding Door - Adjacent Head



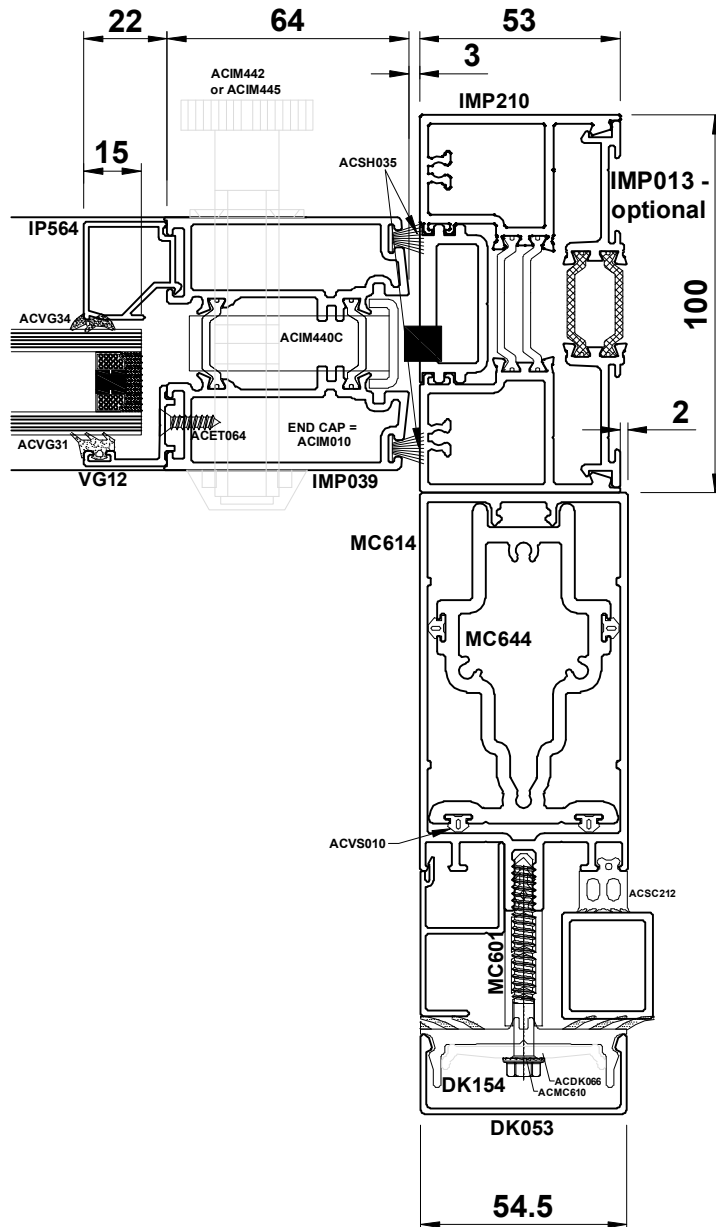
**Do Not Scale From This Drawing**

## Auto Sliding Door- Stile



**Do Not Scale From This Drawing**

## Auto Sliding Door- Stile



**Do Not Scale From This Drawing**

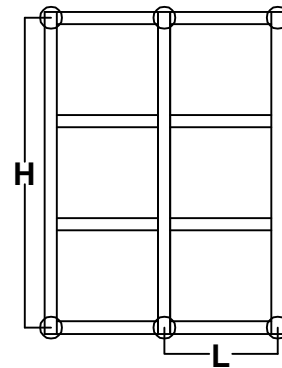
**Section D**

**Statics**

**The selection of suitable mullions and transoms should be based on the design wind load of the structure based on criteria including location; exposure; average wind speeds etc. The following pages will assist with the selection of suitable mullions and transoms. For specific details regarding wind loading limitations or further advice, please contact our Technical Department.**

**Do Not Scale From This Drawing**

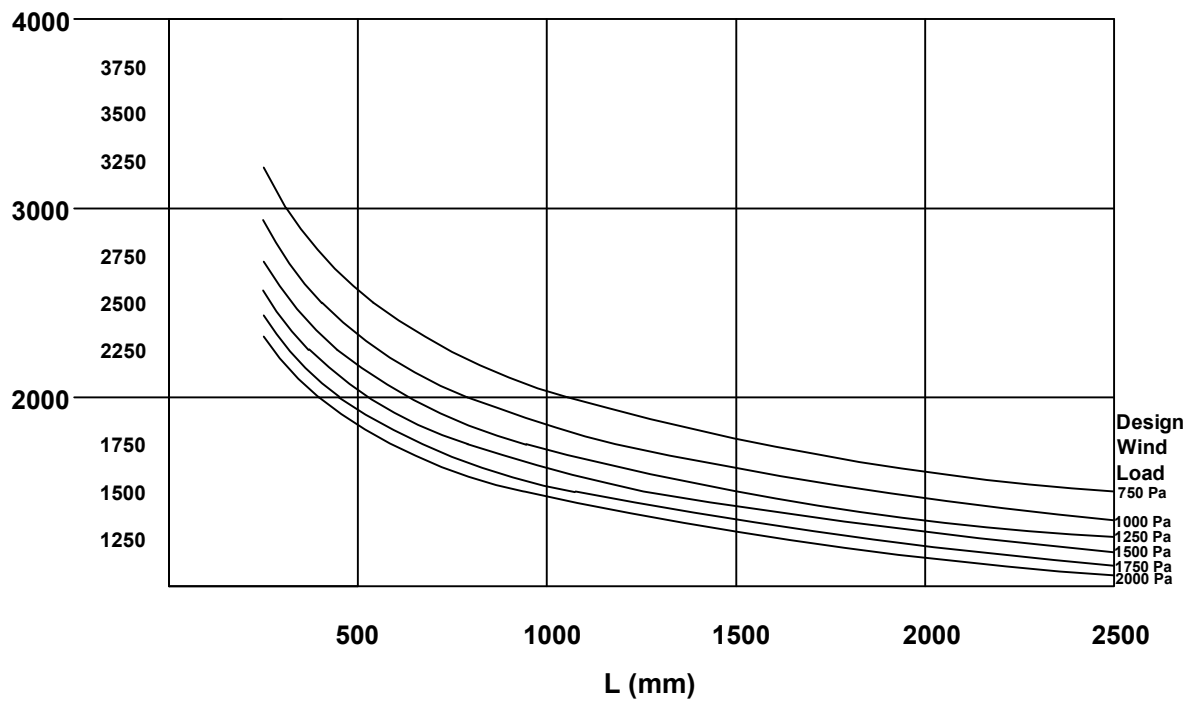
## MC612 Technical Specification



- = Fixing Bracket
- H** = Unsupported Span
- L** = Transom Centres

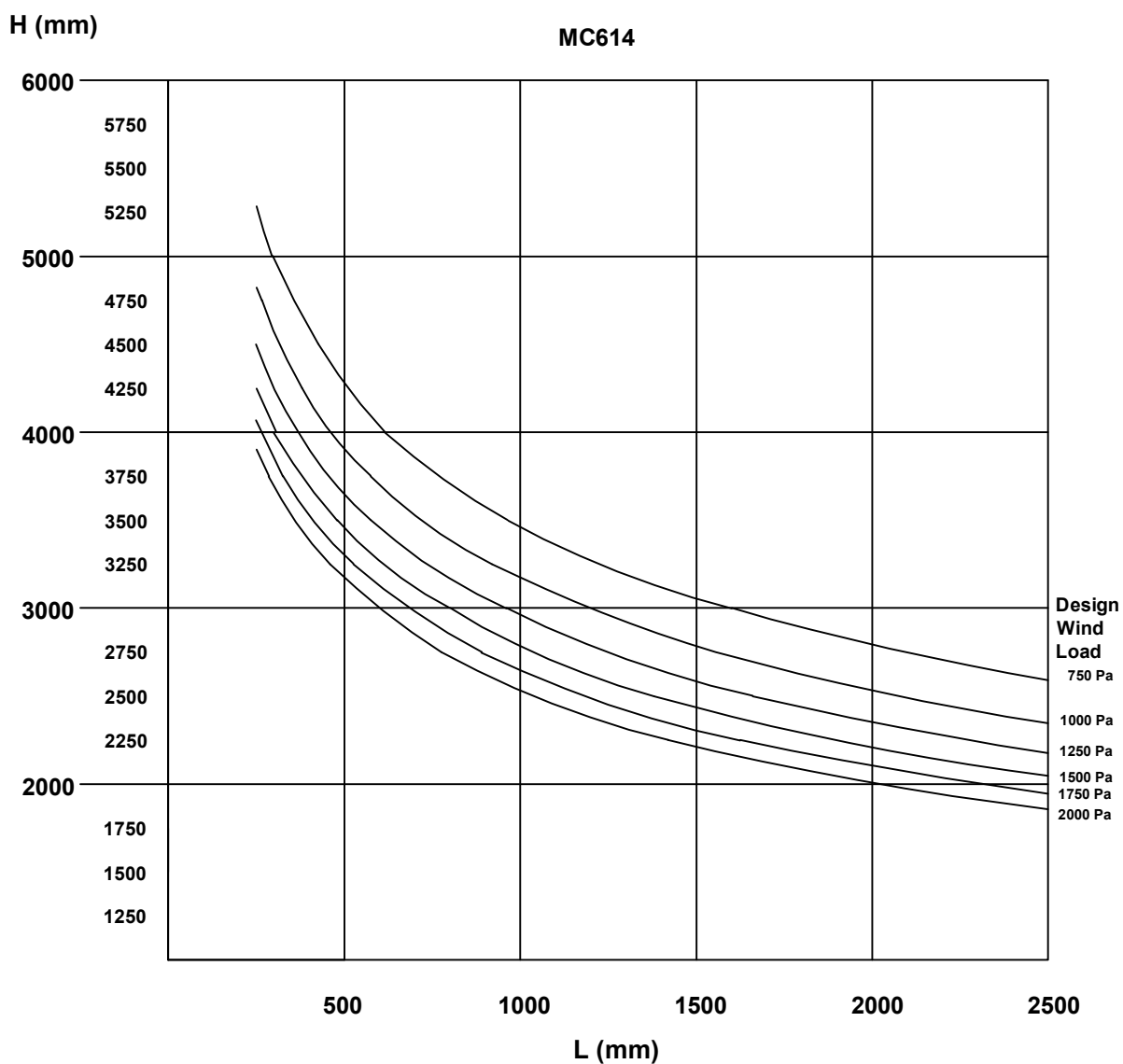
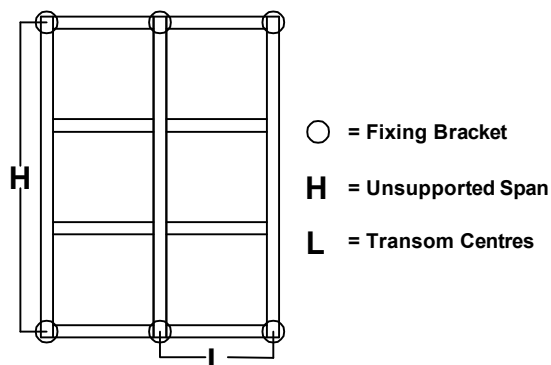
**H (mm)**

**MC612 MC613**



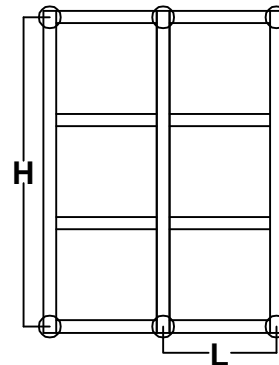
**Do Not Scale From This Drawing**

## MC614 Technical Specification



**Do Not Scale From This Drawing**

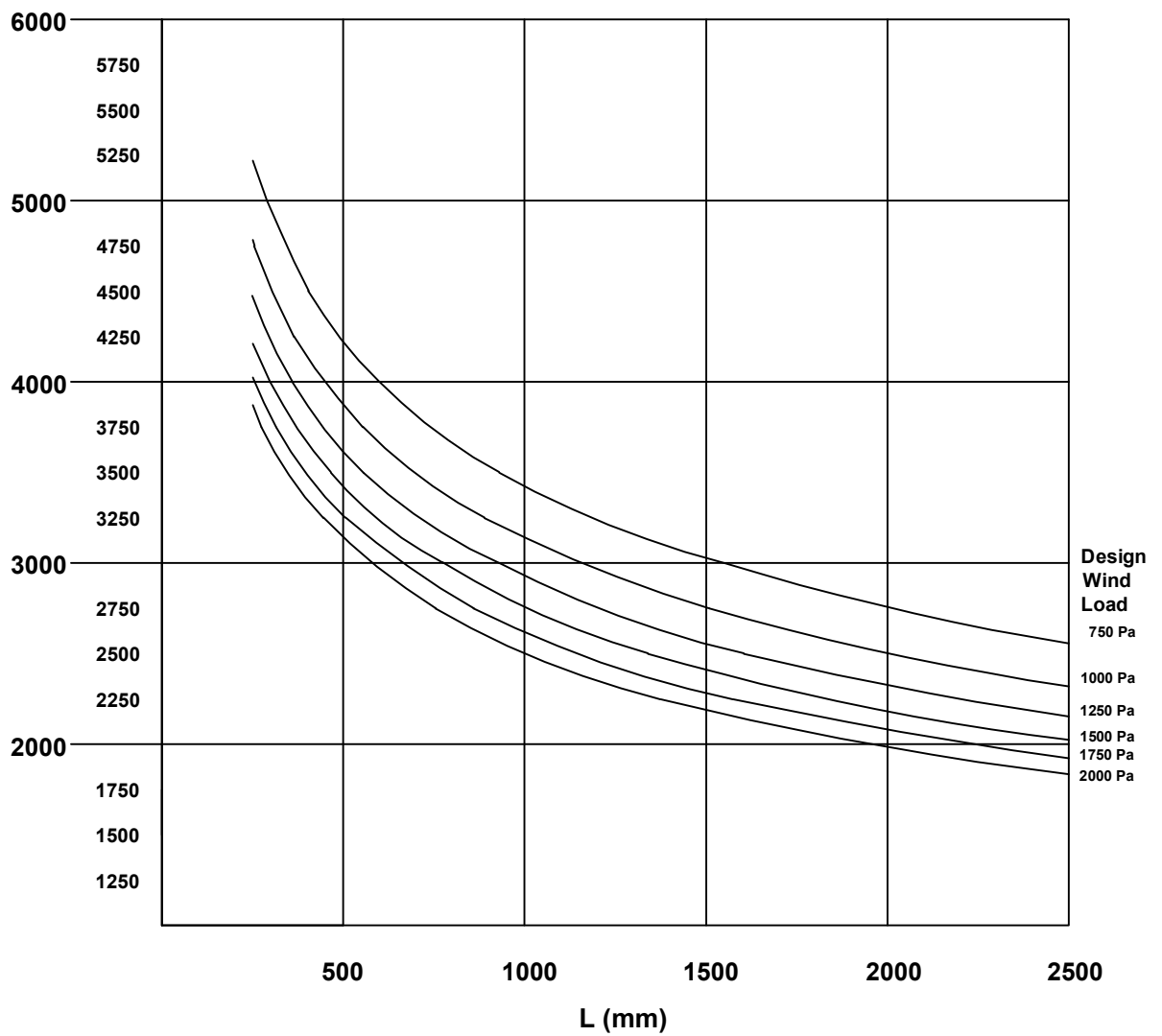
## MC615 Technical Specification



- = Fixing Bracket
- H** = Unsupported Span
- L** = Transom Centres

**H (mm)**

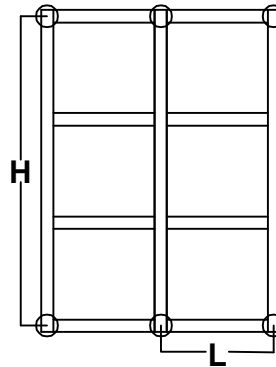
**MU615**



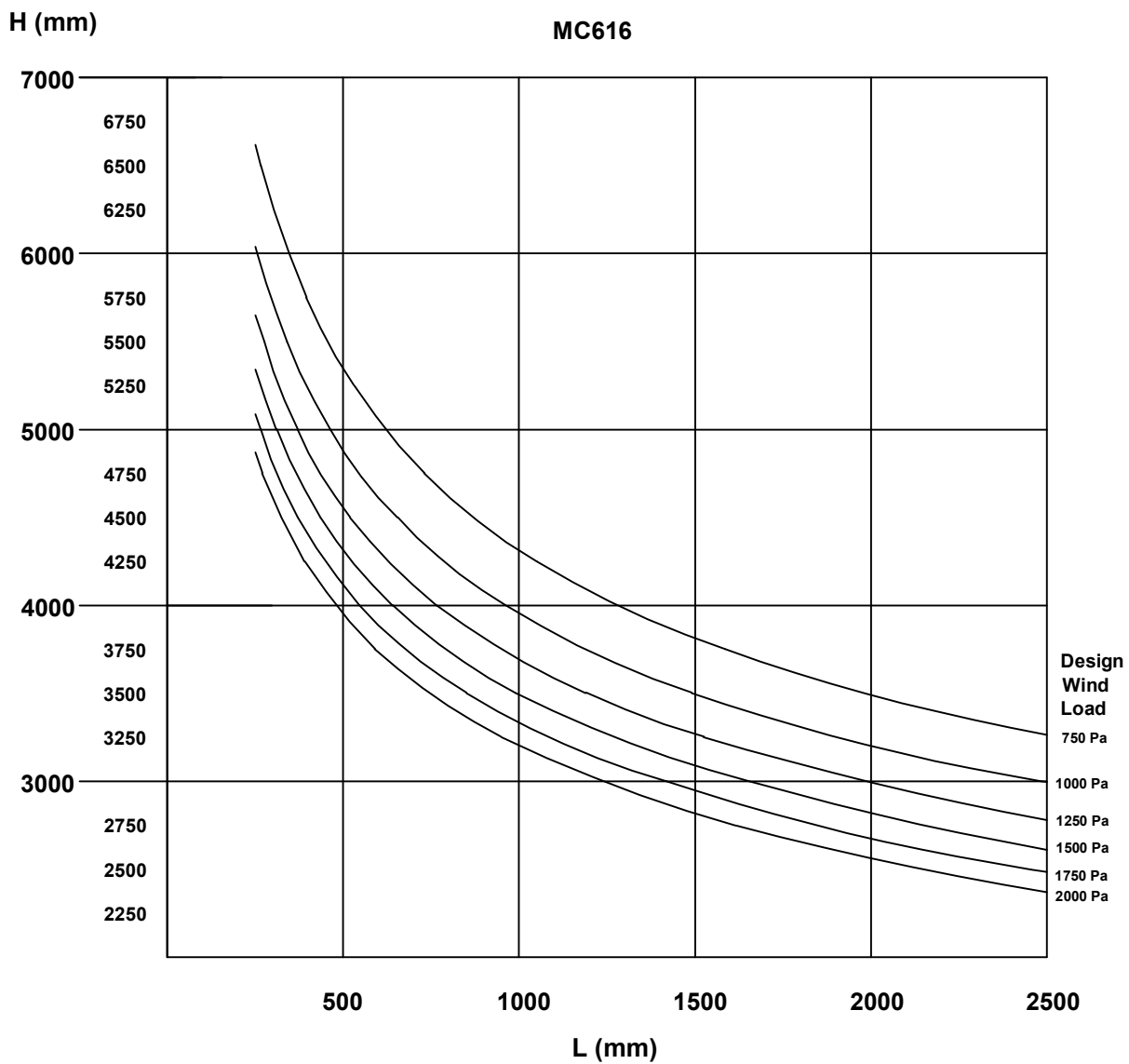
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## MC616 Technical Specification

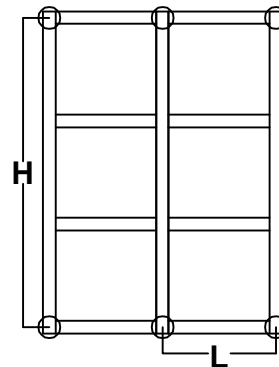


- = Fixing Bracket
- H** = Unsupported Span
- L** = Transom Centres

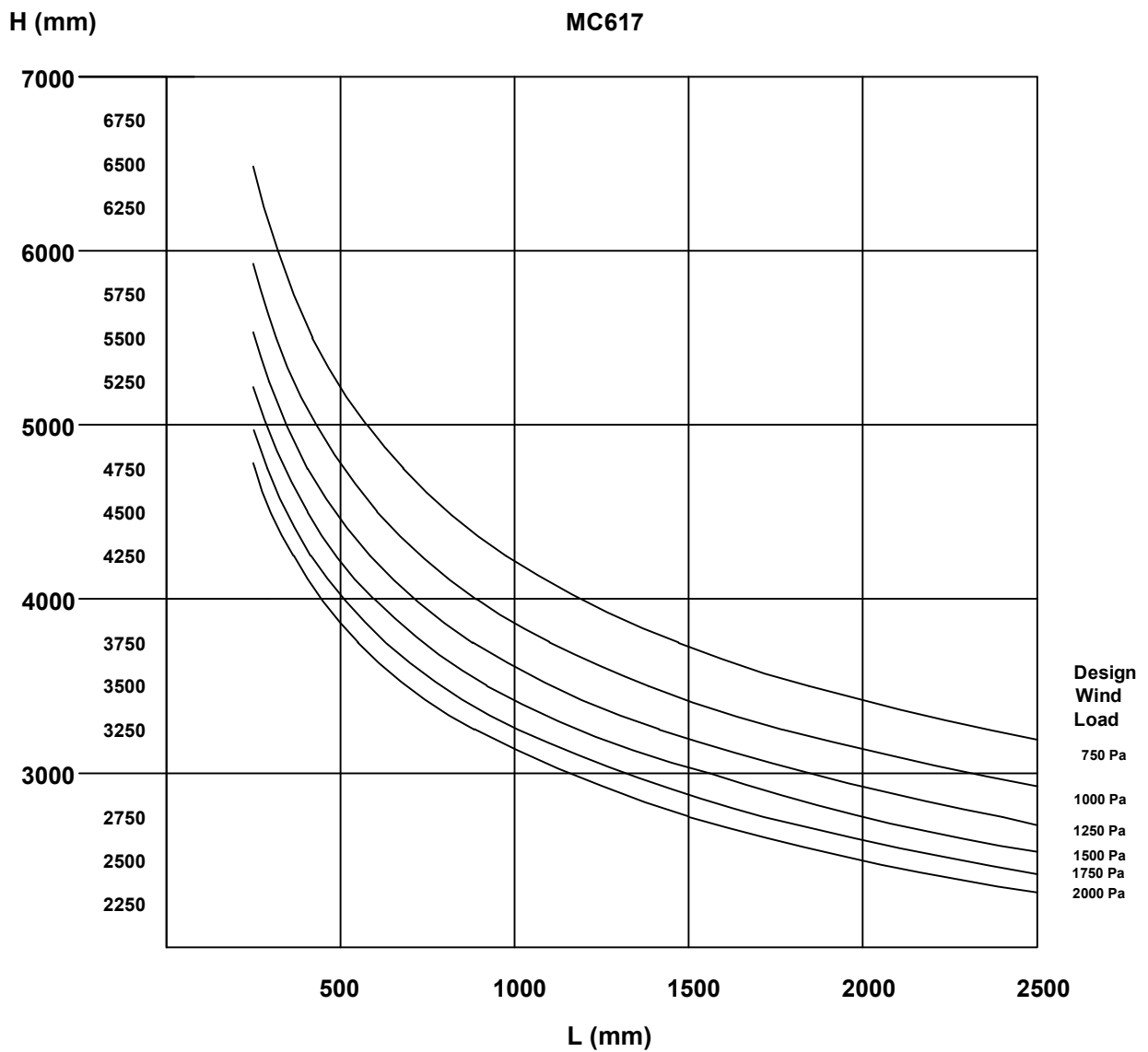


**Do Not Scale From This Drawing**

## MC617 Technical Specification

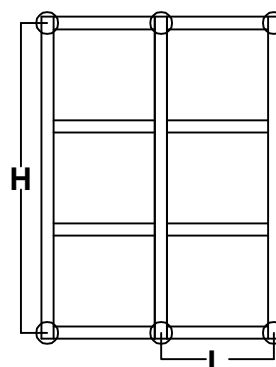


- = Fixing Bracket
- H** = Unsupported Span
- L** = Transom Centres

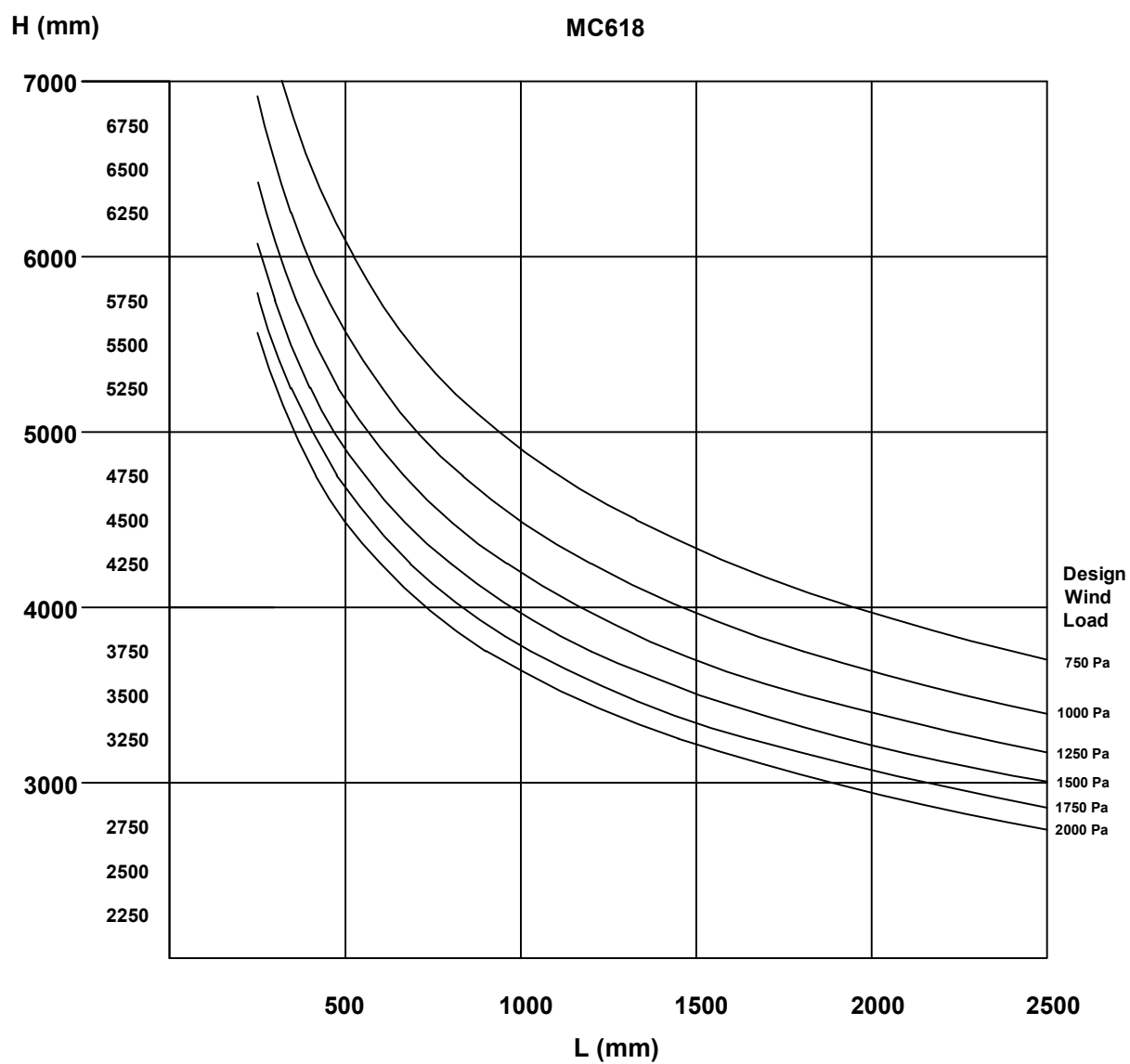


**Do Not Scale From This Drawing**

## MC618 Technical Specification

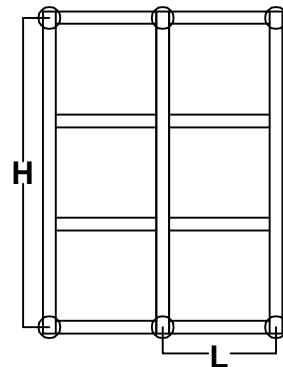


- = Fixing Bracket
- H** = Unsupported Span
- L** = Transom Centres

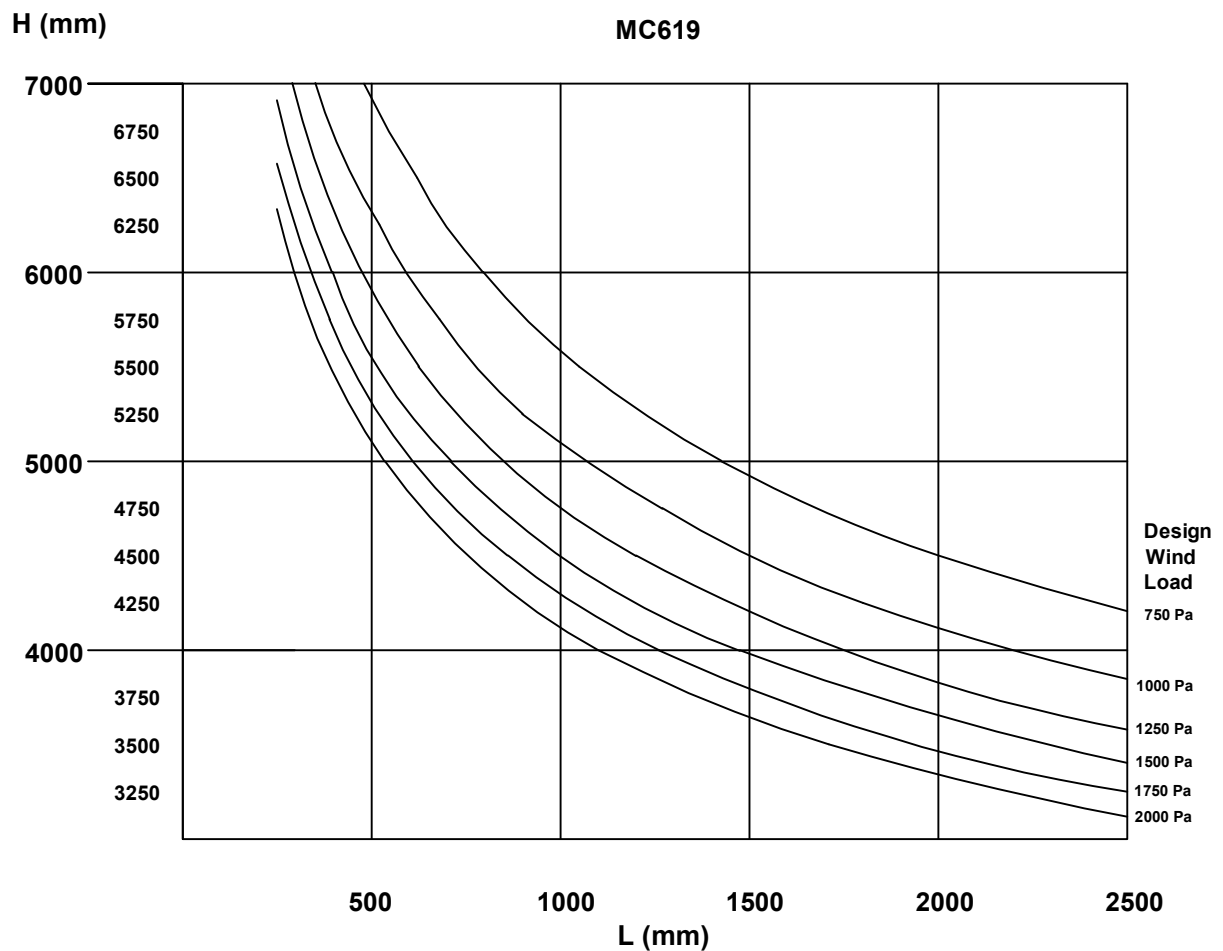


**Do Not Scale From This Drawing**

## MC619 Technical Specification



- = Fixing Bracket
- H** = Unsupported Span
- L** = Transom Centres



**Do Not Scale From This Drawing**

Section E

<b>Construction Drawings</b>	
Bracket requirement Guide .....	Page E02
Deductions .....	Page E03
Mullion Preparation - Stick Build with Spring-Pin and Casting .....	Page E04
Transom Preparation - Stick Build with Spring-Pin and Casting ...	Page E05
Stick Build and Ladder Frame with Shear Blocks .....	Page E06
Stick Build and Ladder Frame with Shear Blocks .....	Page E07
Ladder Frame assembly using Screw Ports .....	Page E08
Drainage and Pressure Equalisation .....	Page E09
Sleeve Detail .....	Page E10
Splice Joint .....	Page E11
Glazing .....	Page E12

## Bracket Requirement Guide

### Structural Curtain Wall Brackets

**Brackets form the link between the curtain wall and the structure. These are critically important to the safety and serviceability of the wall.**

Brackets need to be designed to transfer all the loads from the curtain wall to the structure safely, whilst accommodate tolerances and movement. The screen will depend on the availability of a suitable support structure (tie back positions).

The loads will vary on the size of the screen and the location of the building. Brackets need to be designed to interface with a suitable support structure/building frame. Detail drawings will be required to identify the location and position of any brackets.

**Dead loads - Support**

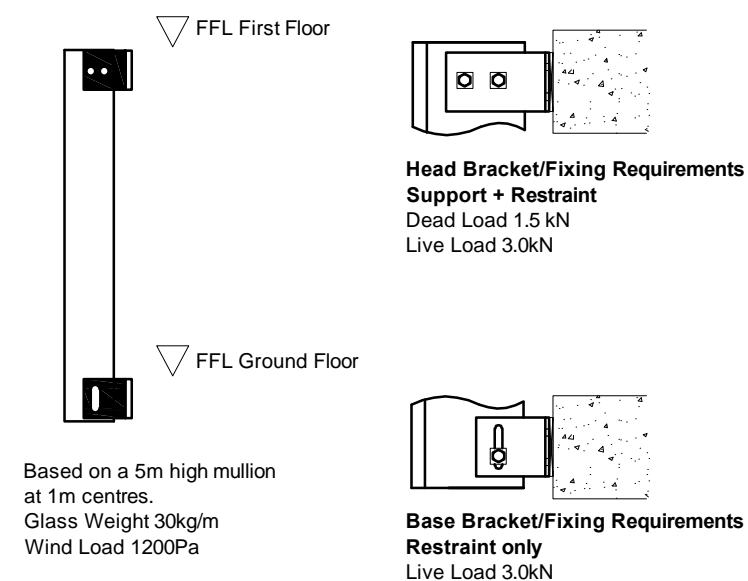
The weight of the curtain wall needs to be transferred to the structure.

**Live Loads - Restraint**

Wind loads in the form of negative (suction) or positive pressures are usually the dominant load case.

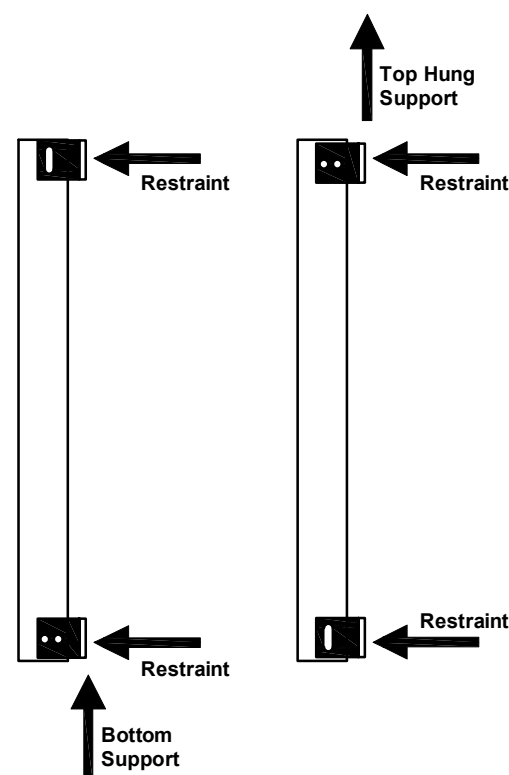
Brackets and fixings on curtain wall are structural and must be designed to relevant structural codes.  
BS8118. Structural Use of Aluminium

### Typical Load Requirements



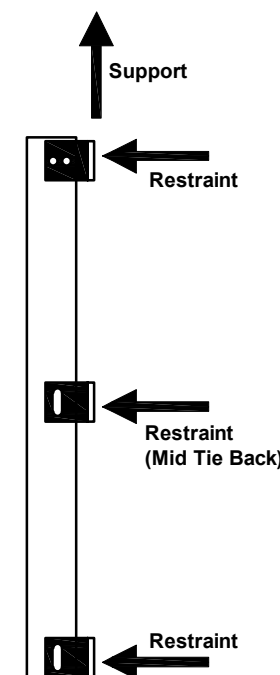
### Single Span

For single span there are two possible arrangements of these fixings for a single storey mullion. The top hung arrangement is more common but the bottom supported arrangement may be used, particularly for low rise construction.



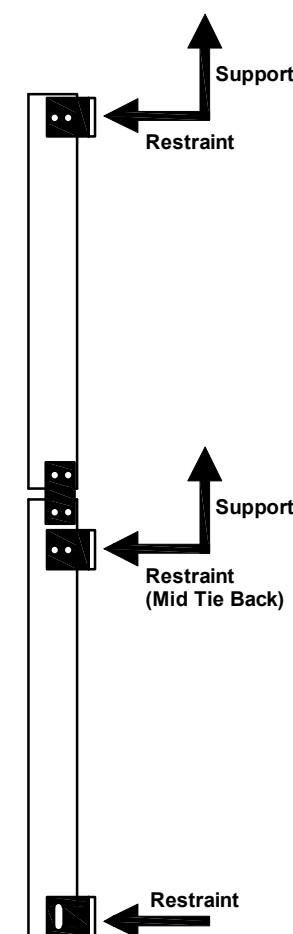
### Multiple Tie Back

Where mullions span more than one storey, restraint fixings are usually provided at intermediate floors. By providing mid point tie back restraints the required mullion strength may be reduced.



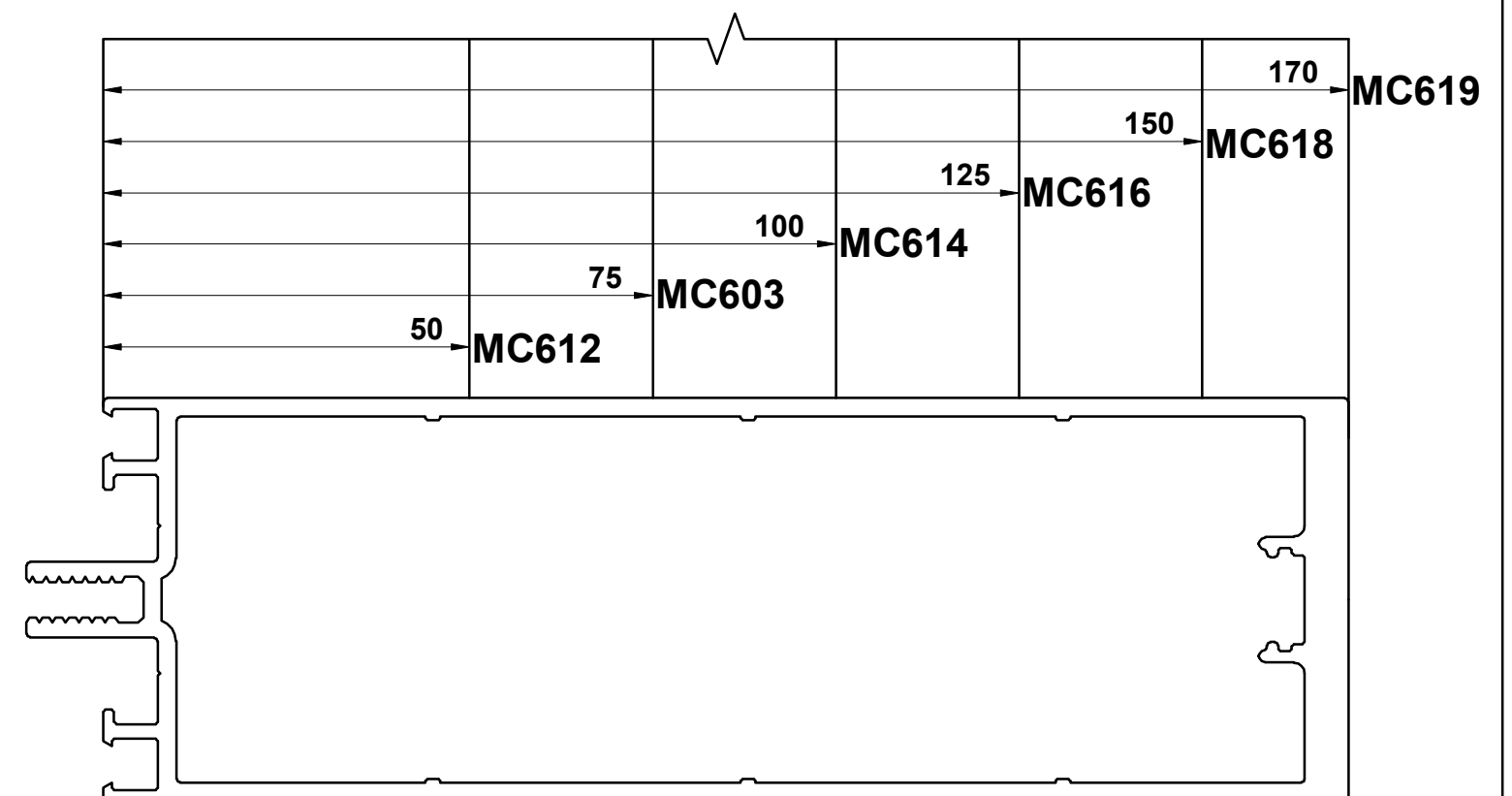
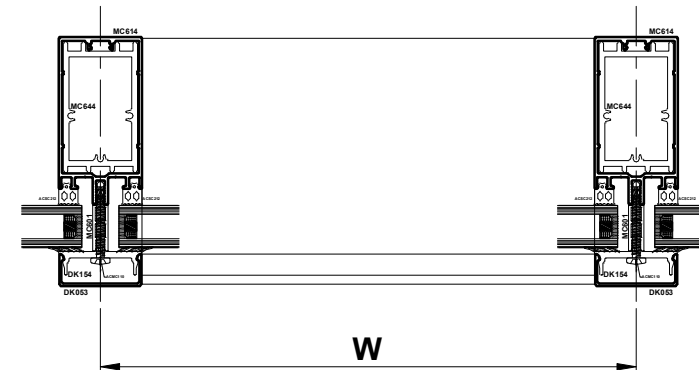
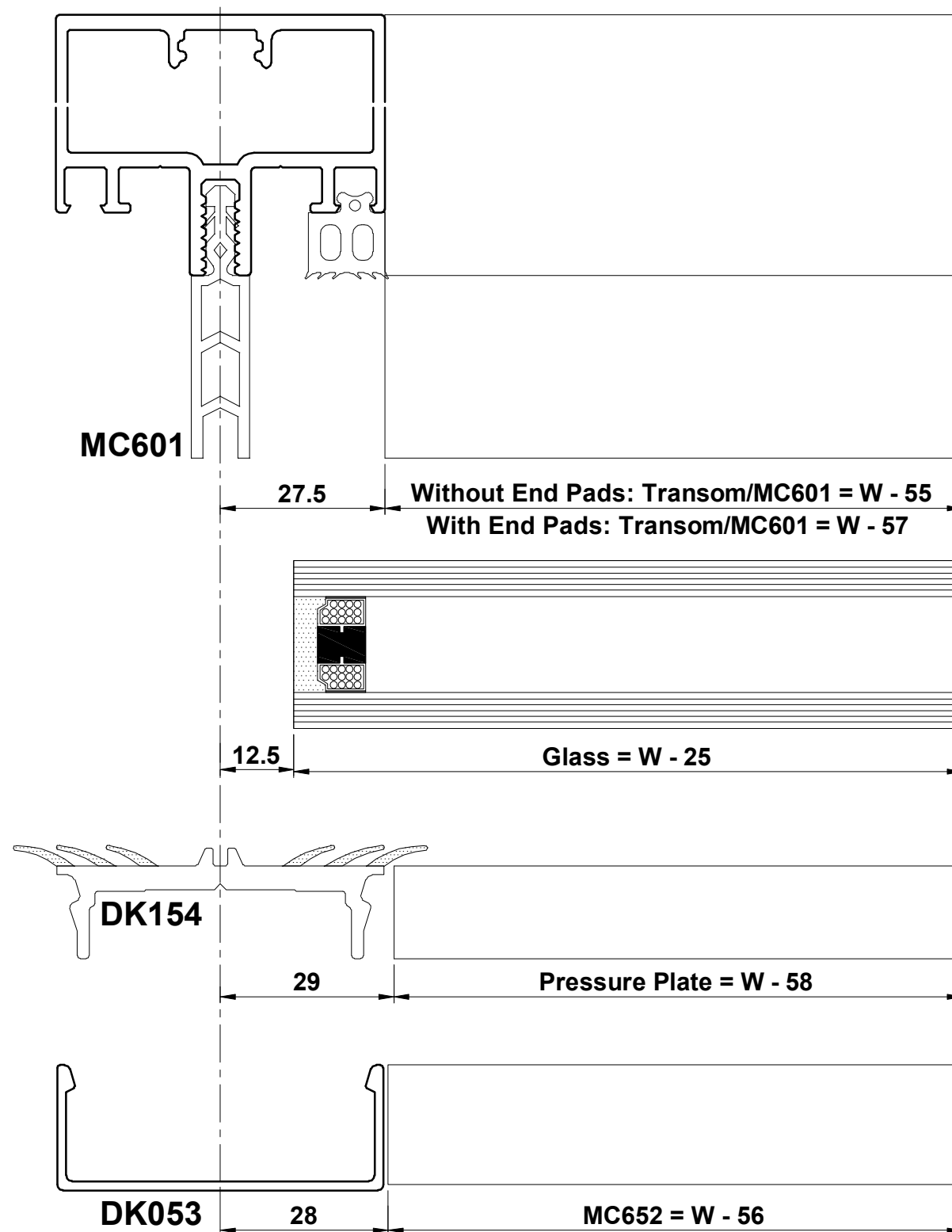
### Multiple Span

Where mullions span more than one mullion length (typically 7m). A Splice Joint will be required to join mullions. Each length will require one support fixing for dead load transfer.



**Do Not Scale From This Drawing**

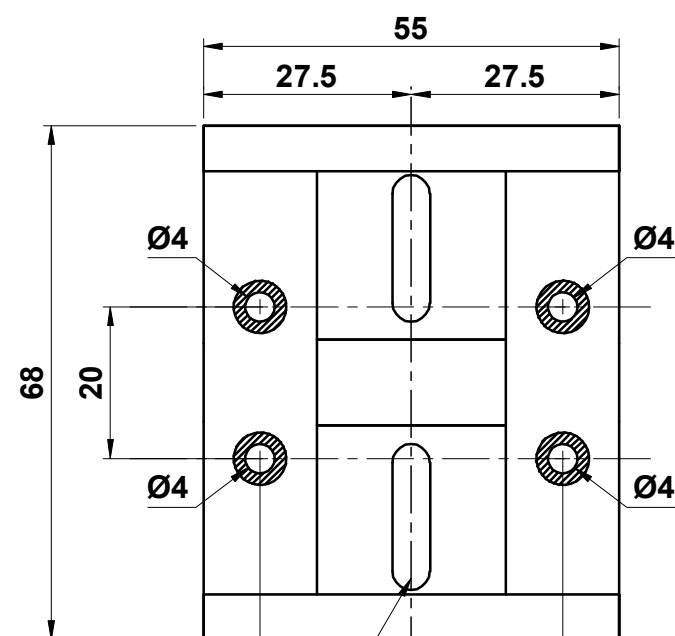
## Deductions



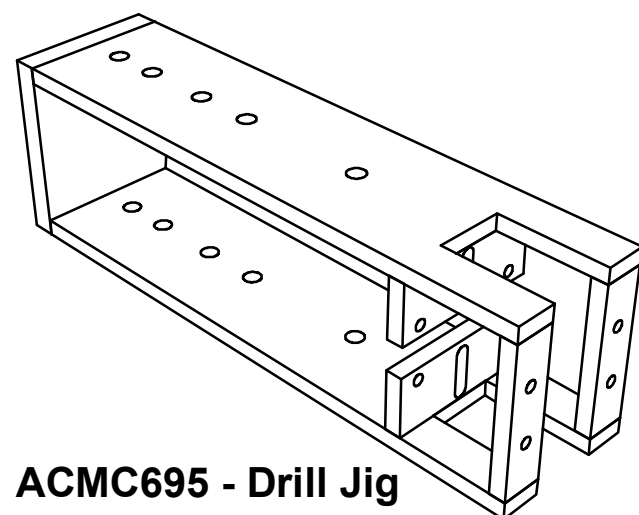
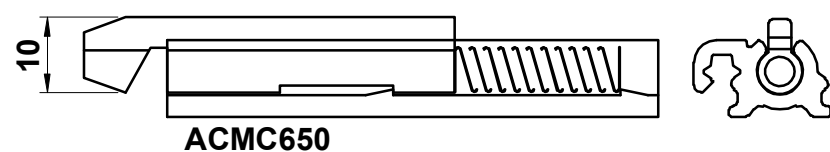
Do Not Scale From This Drawing

Mullion Preparation - Stick Build with Spring Pin and Casting

ACMC695 - Drill Jig

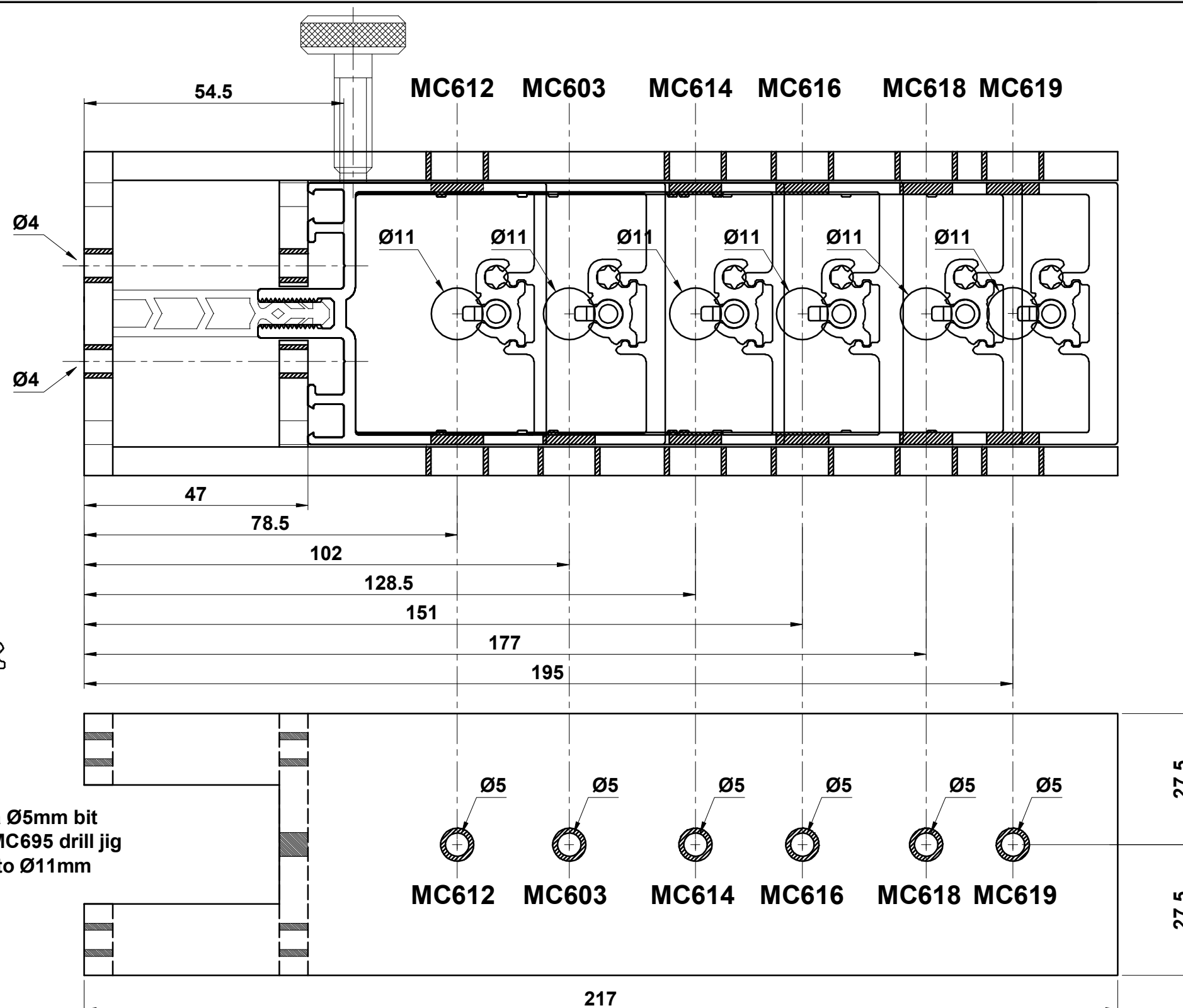


Align drill jig over  
centre line and  
clamp in position



ACMC695 - Drill Jig

Drill with a Ø5mm bit  
using ACMC695 drill jig  
and open to Ø11mm

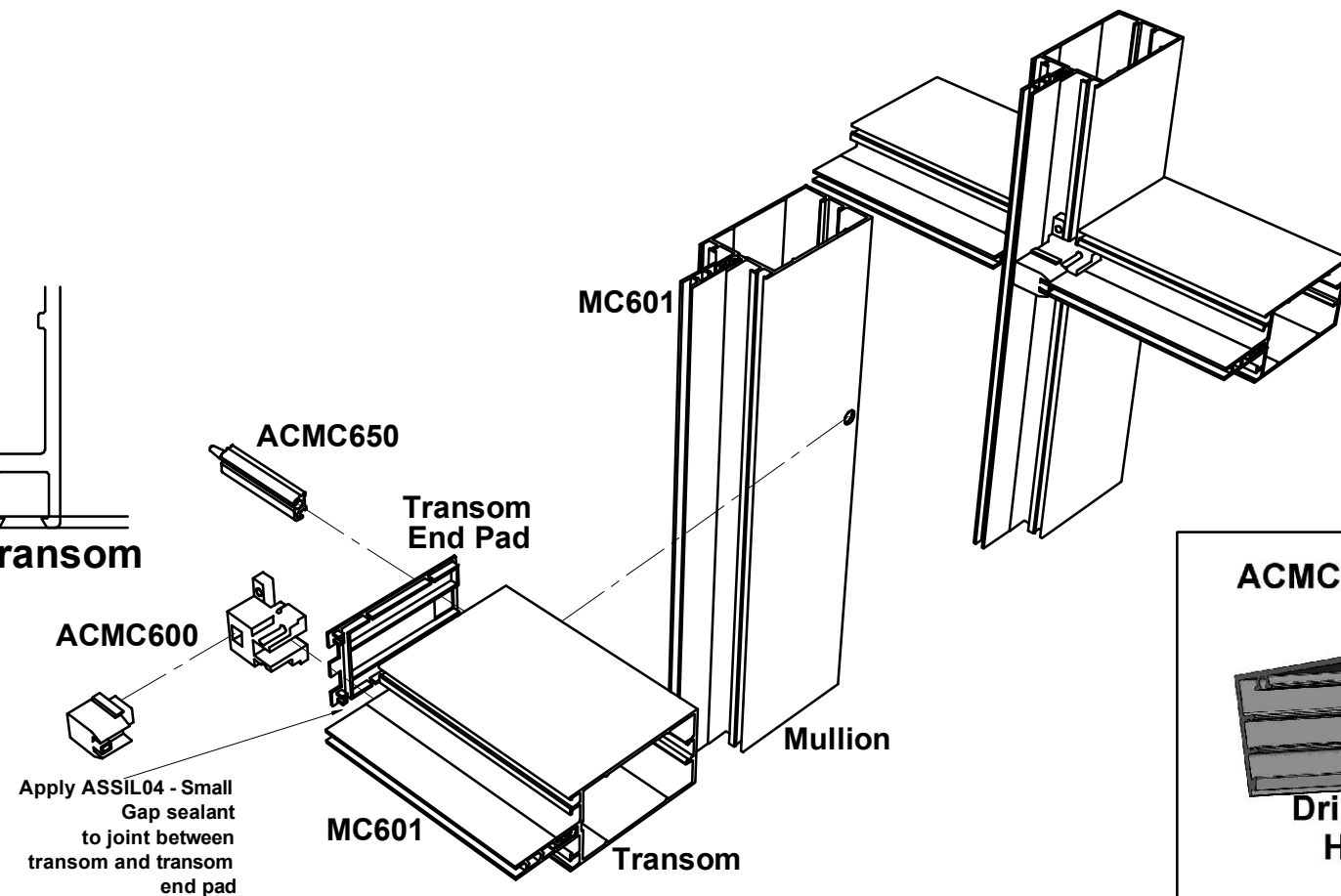
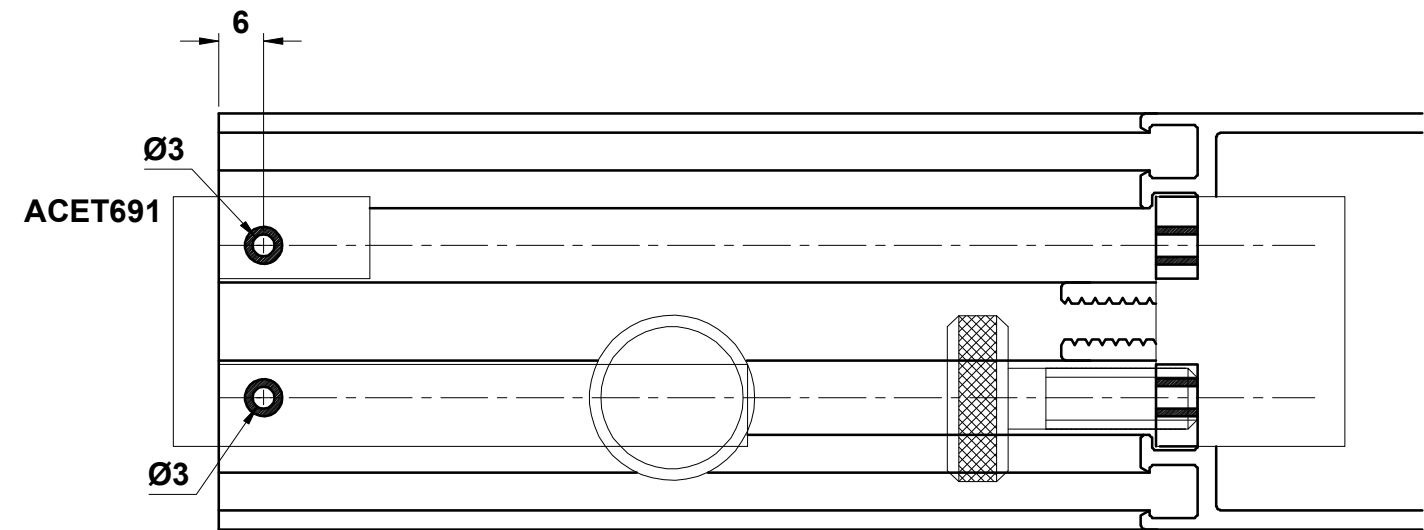
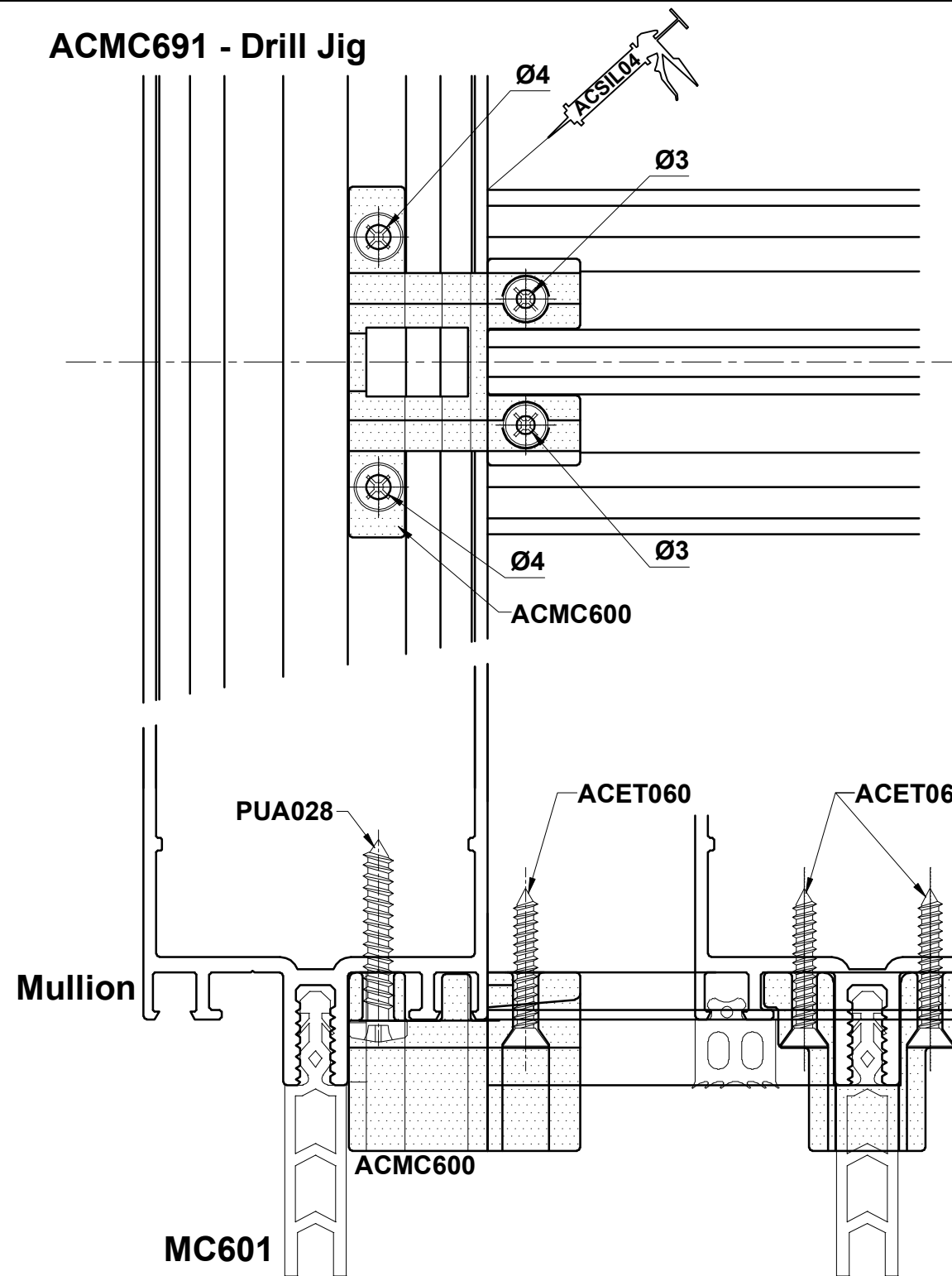


Do Not Scale From This Drawing

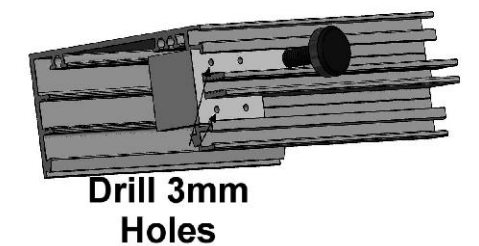


## Transom Preparation - Stick Build with Spring Pin and Casting

**ACMC691 - Drill Jig**

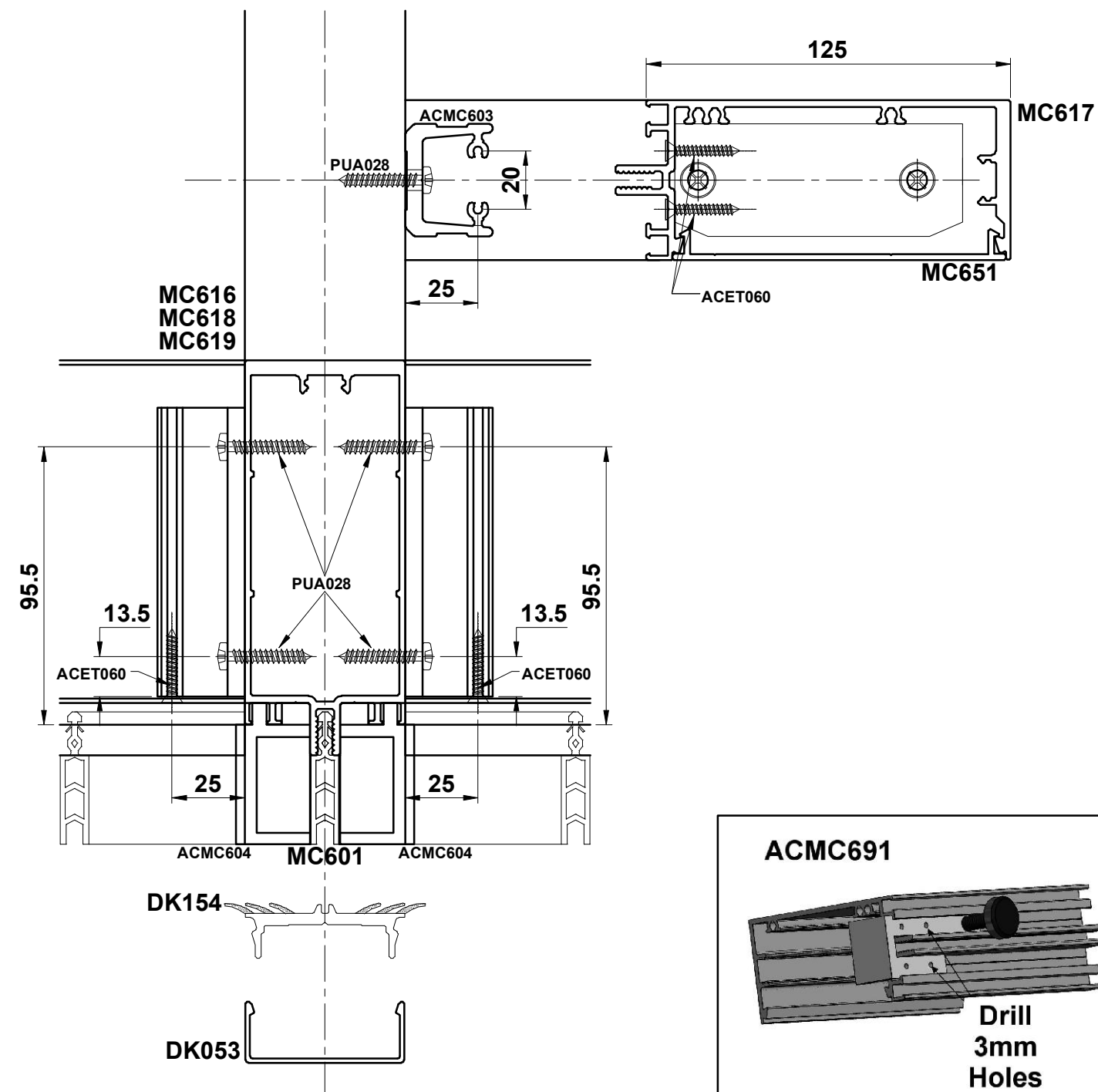
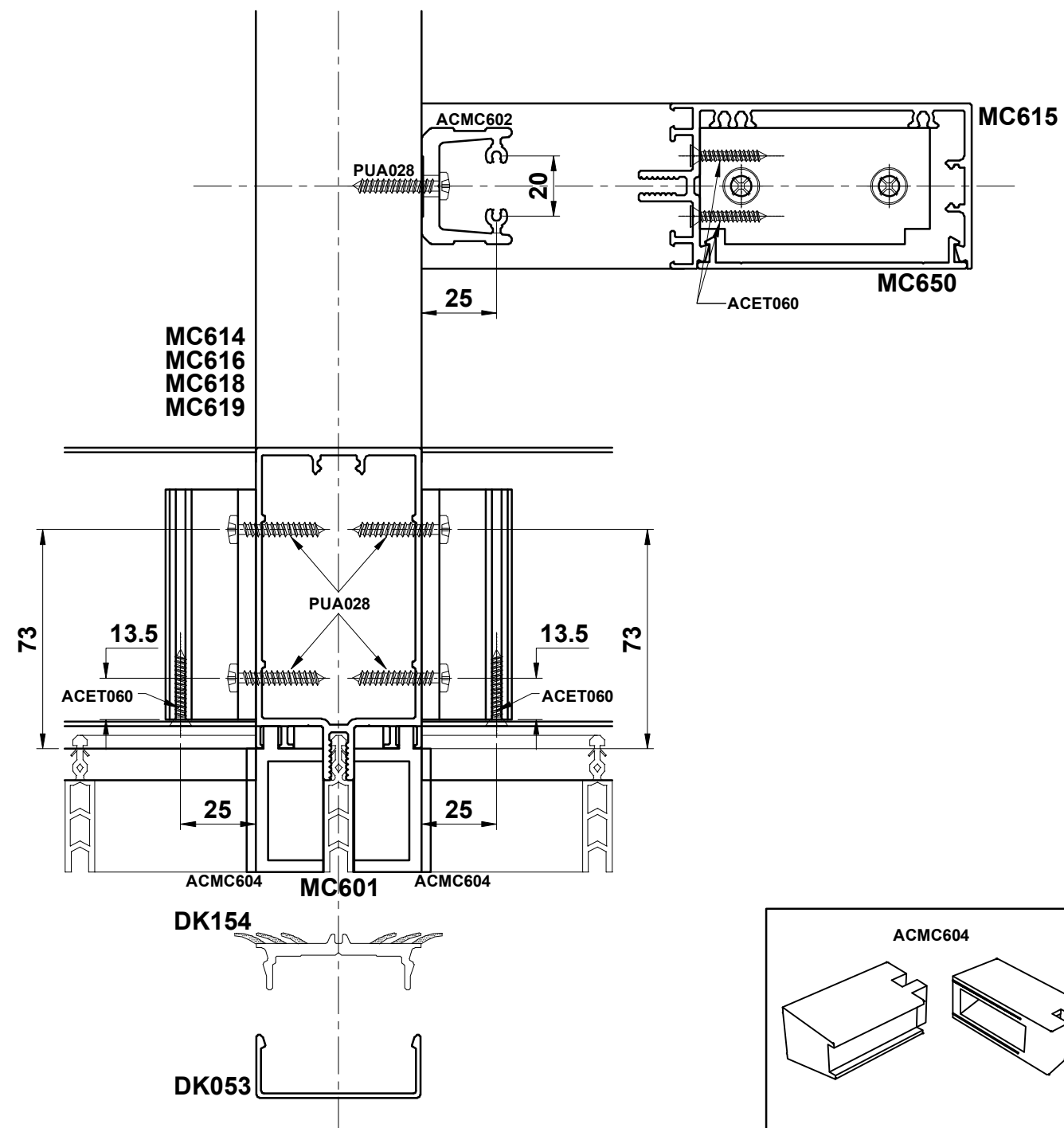


**ACMC691**

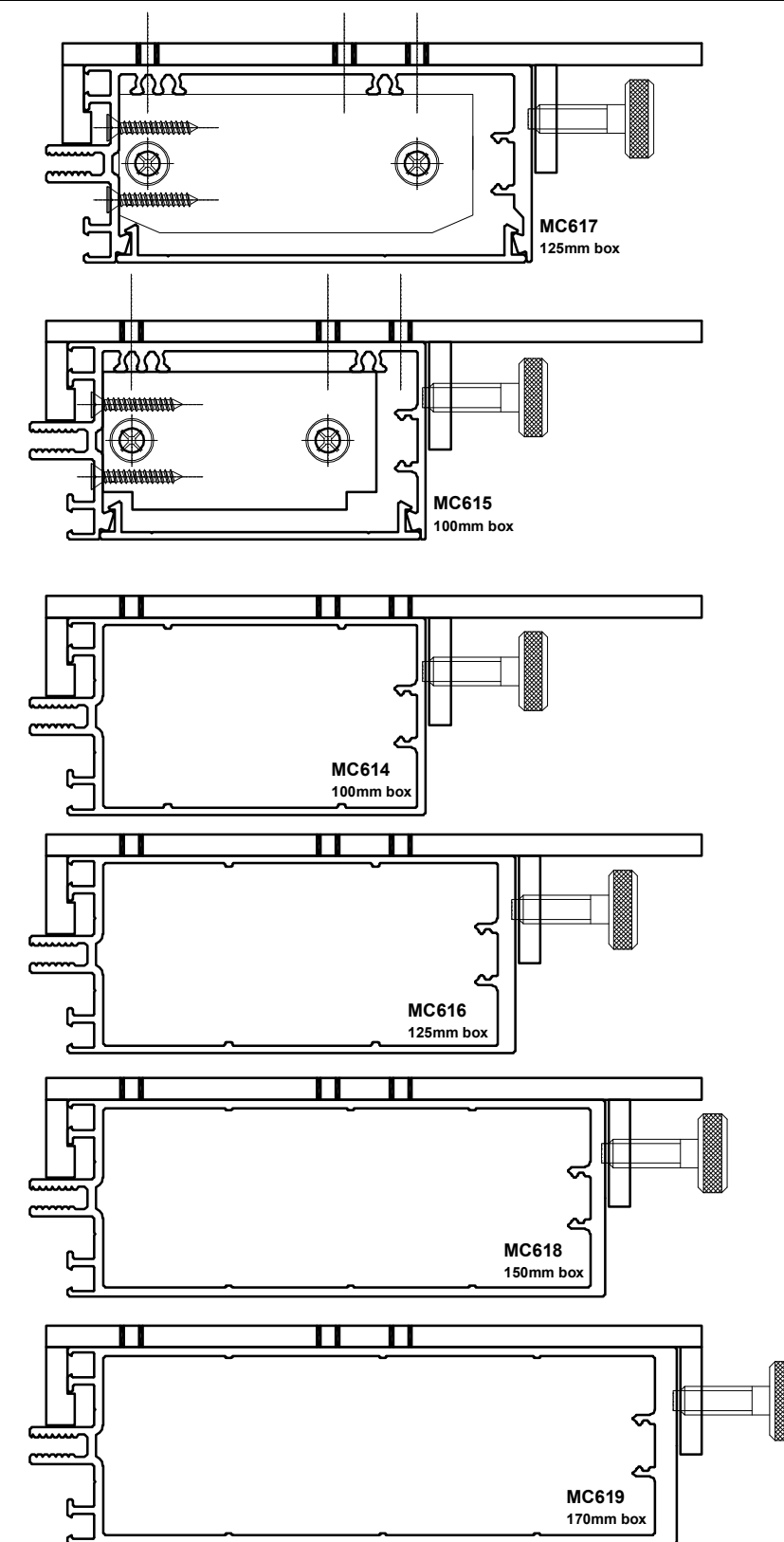
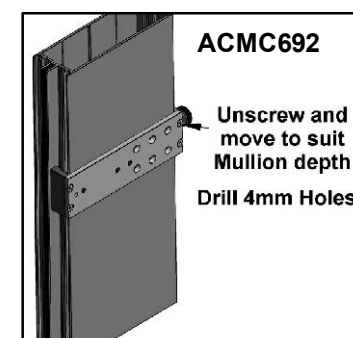
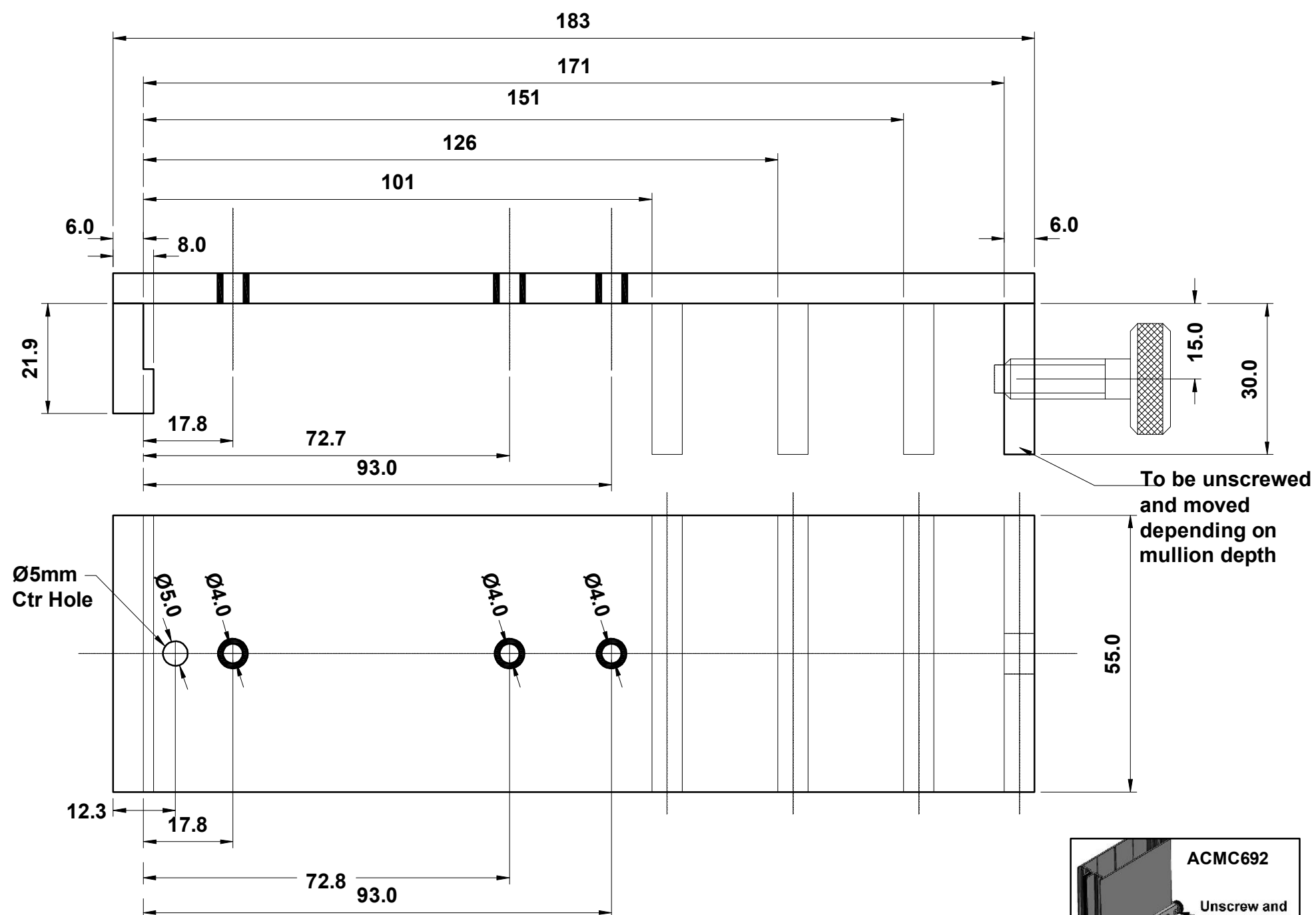


Stick Build and Ladder Frame with Shear Blocks

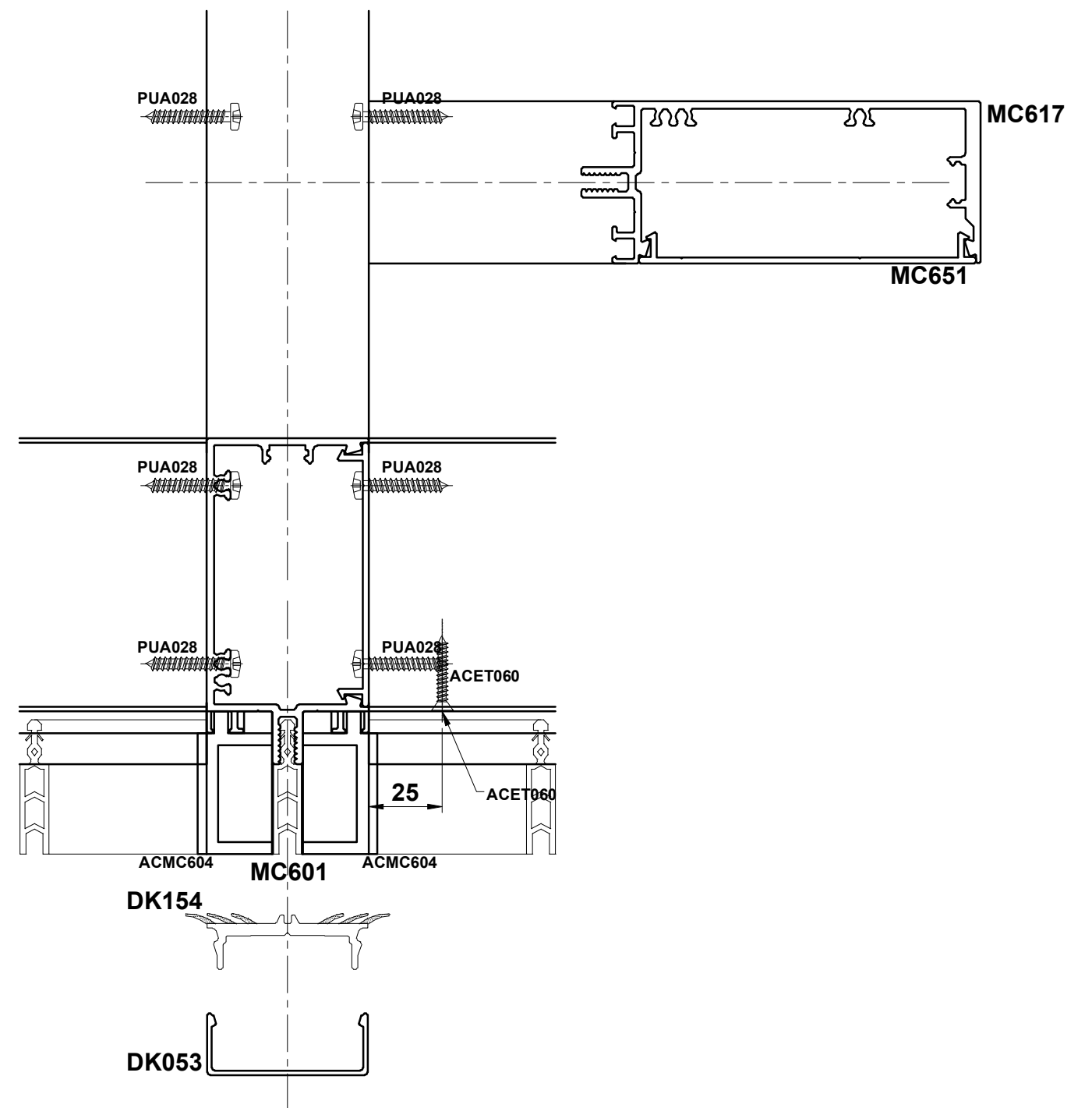
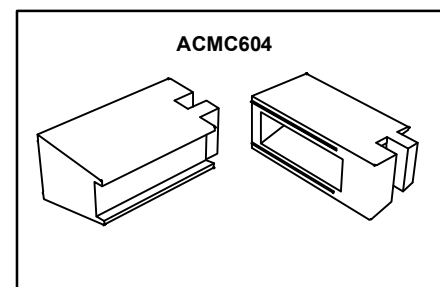
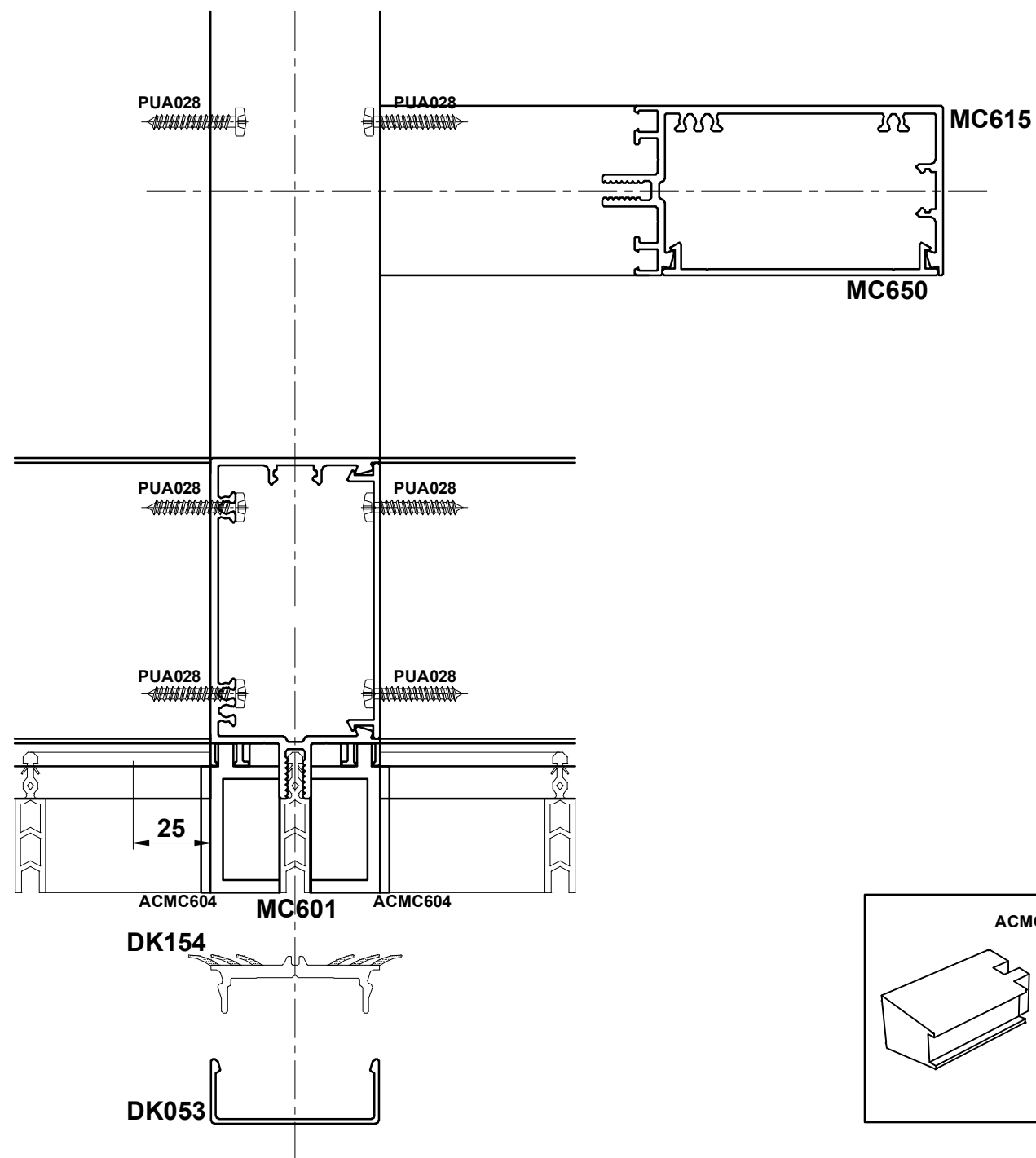
ACMC691 - Transom Drill Jig  
ACMC692 - Shear Block Drill Jig



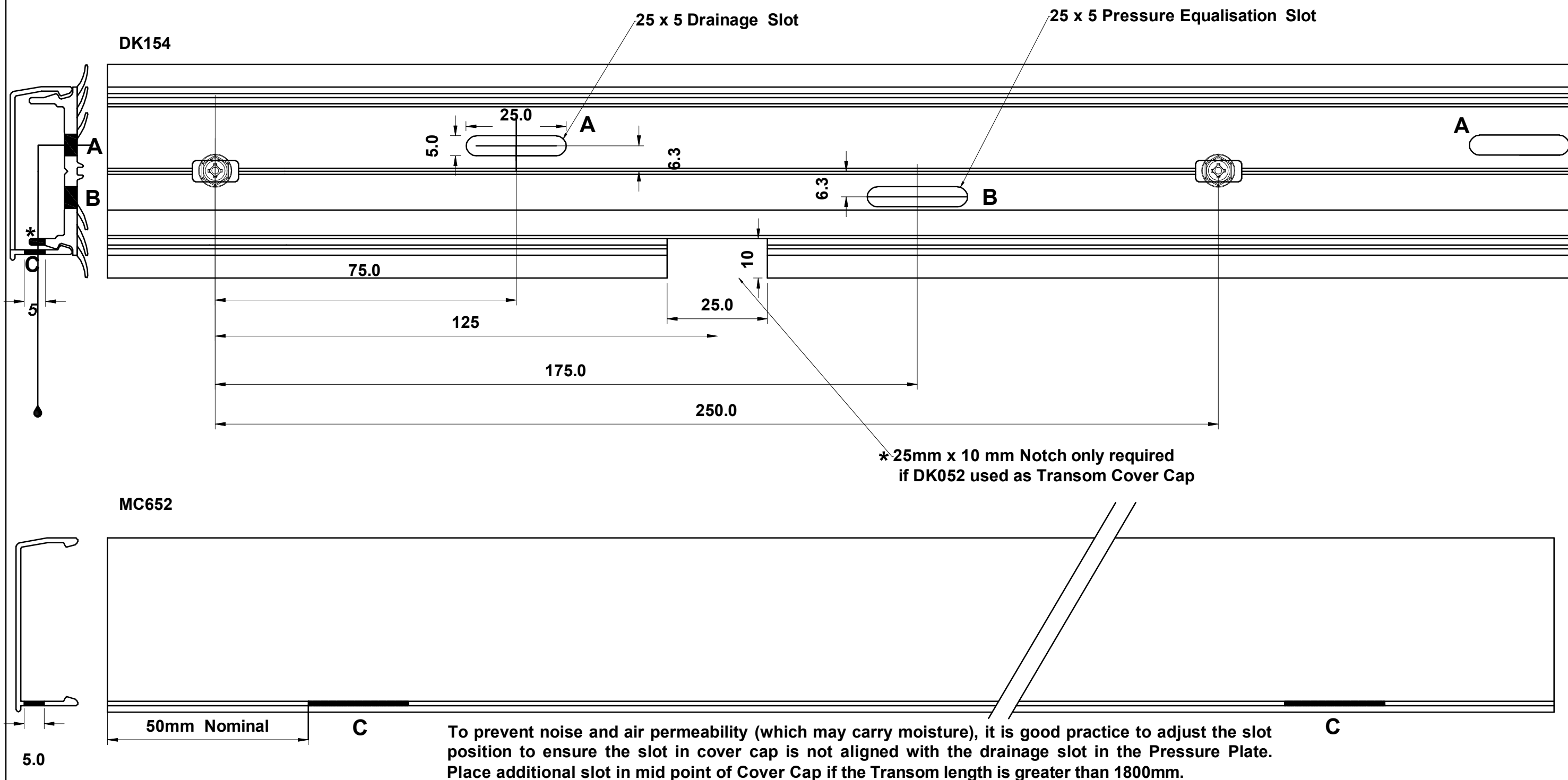
## Stick Build and Ladder Frame with Shear Blocks



## Ladder Frame Assembly - Using Screwports

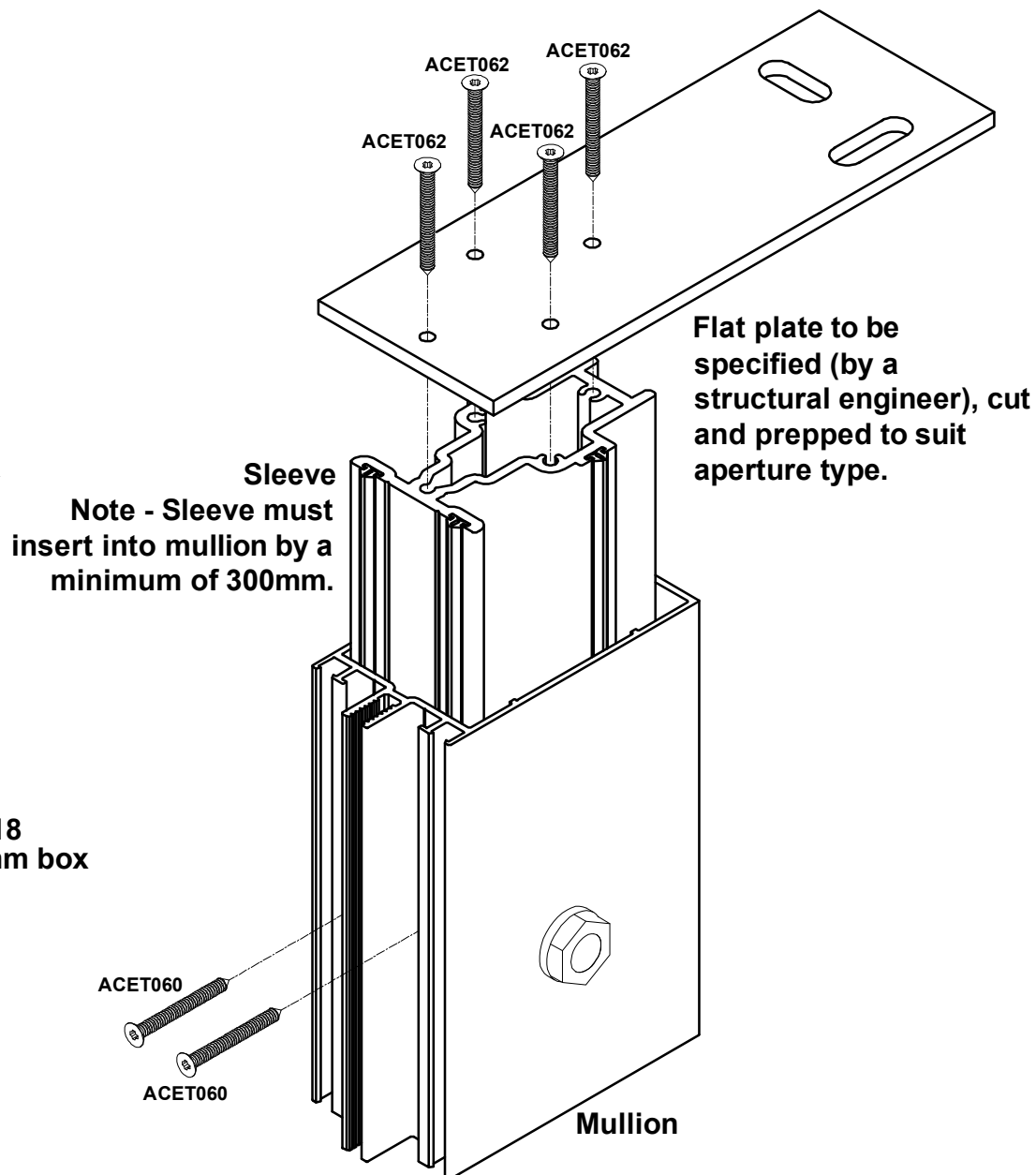
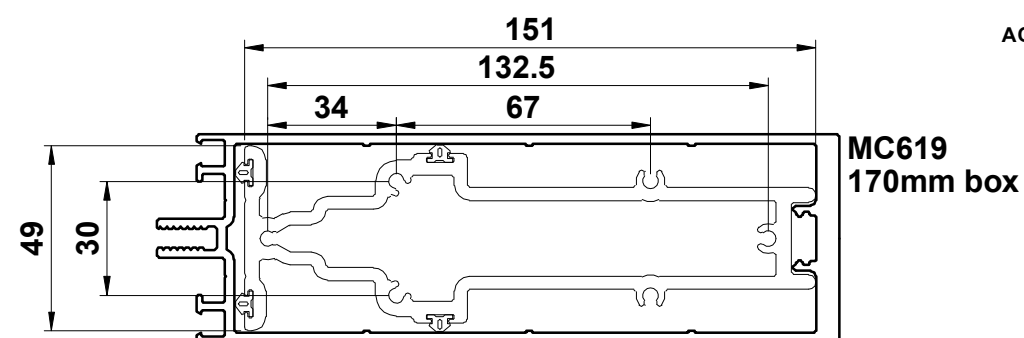
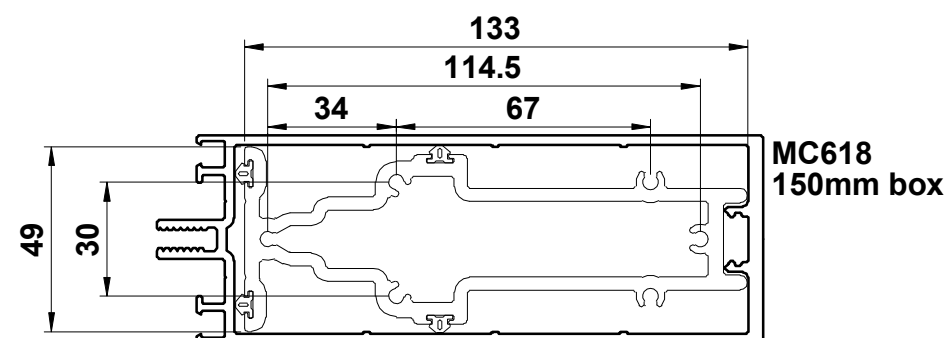
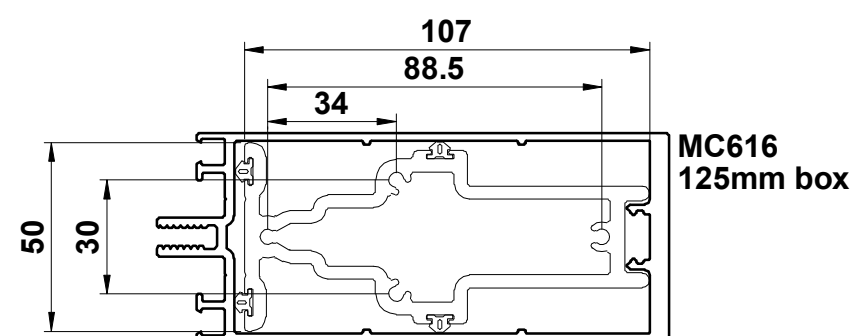
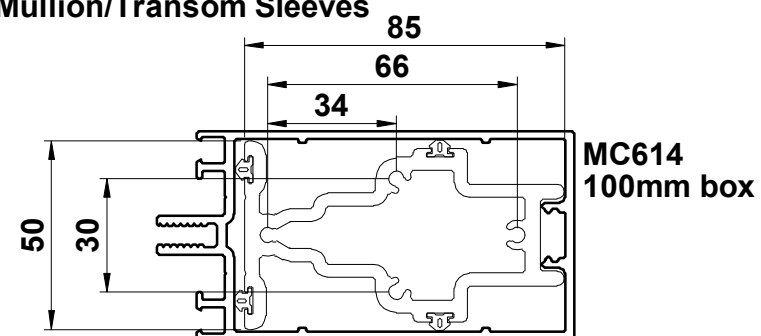


## Drainage and Pressure Equalisation

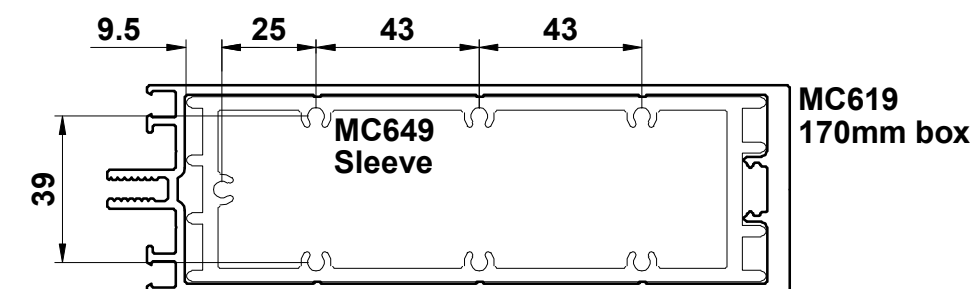
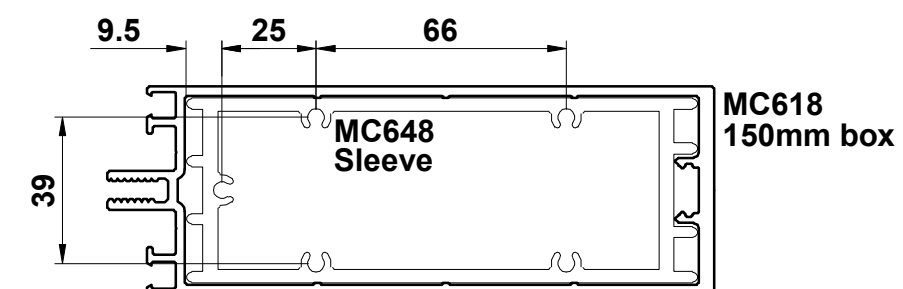
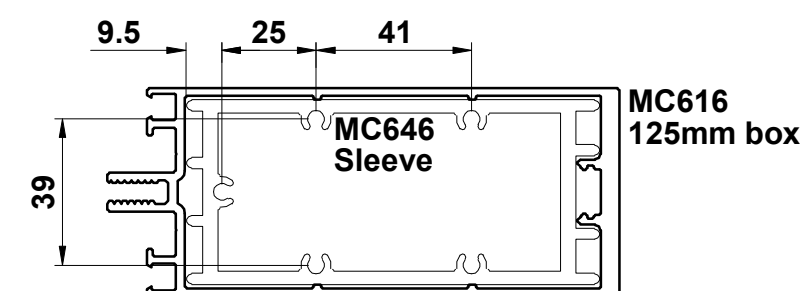
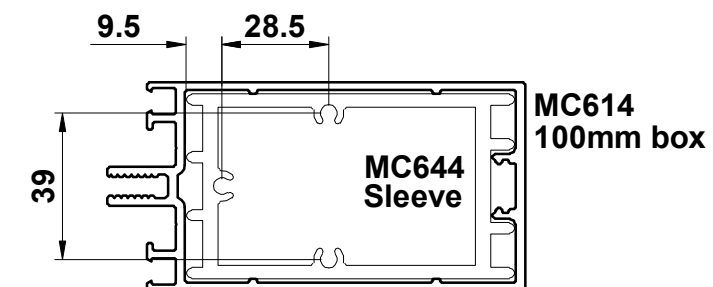


## Sleeve Details

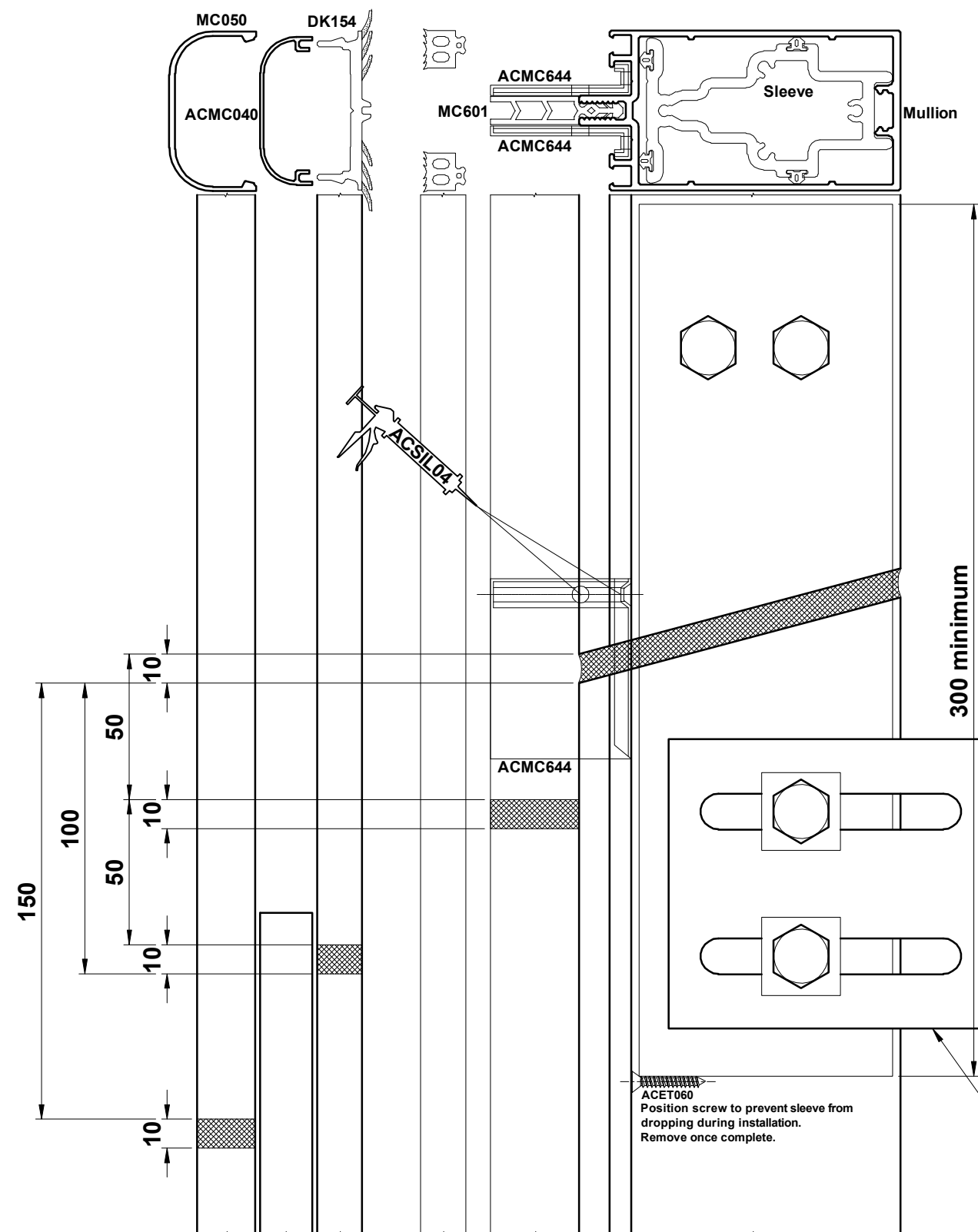
### Mullion/Transom Sleeves



### Transom Sleeves



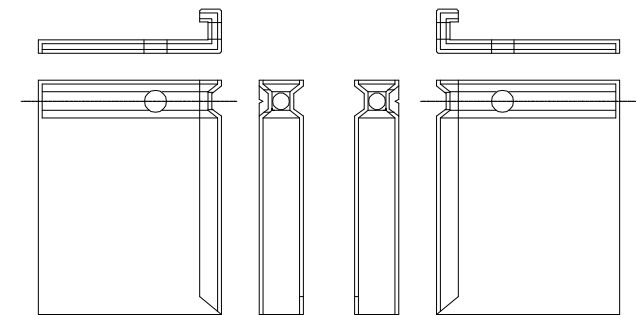
## Splice Joint



Bracket by others

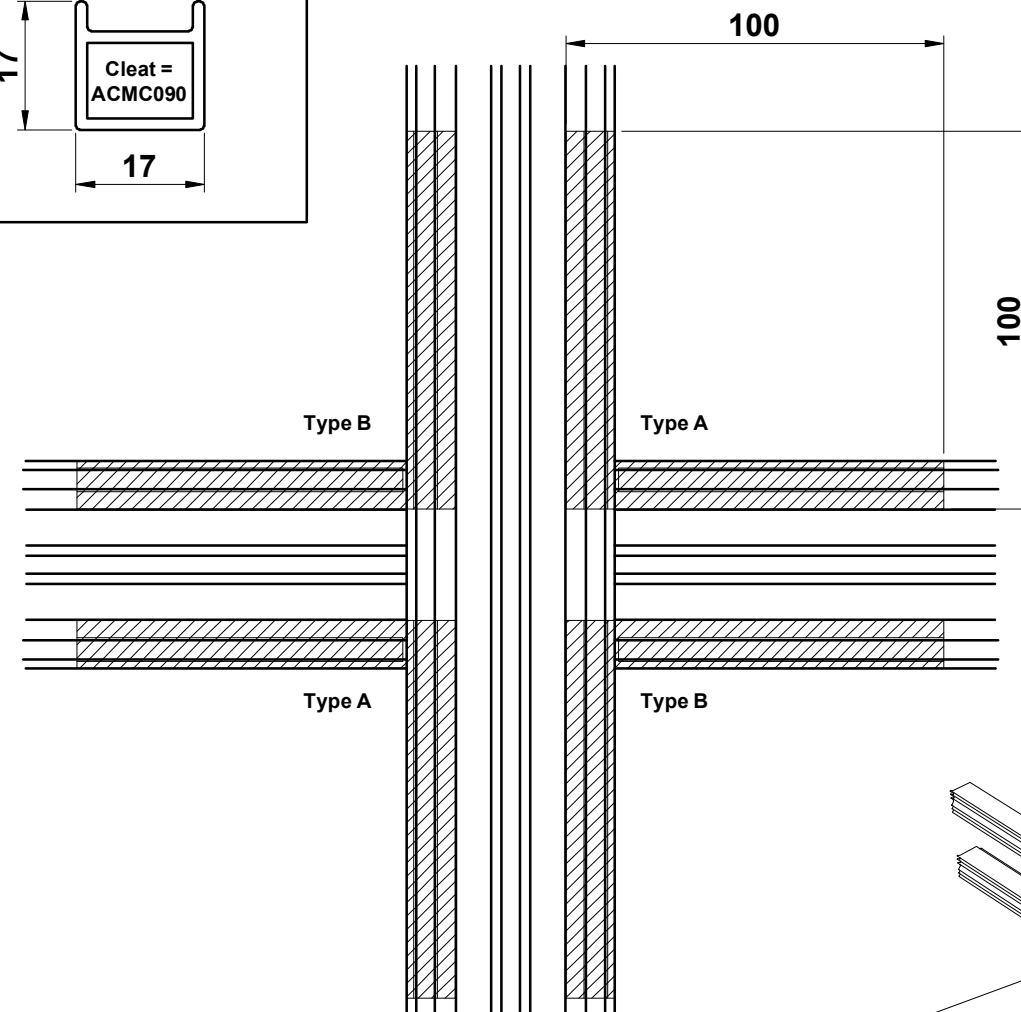
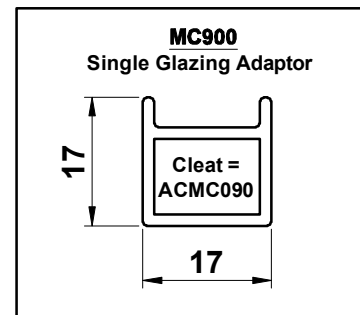
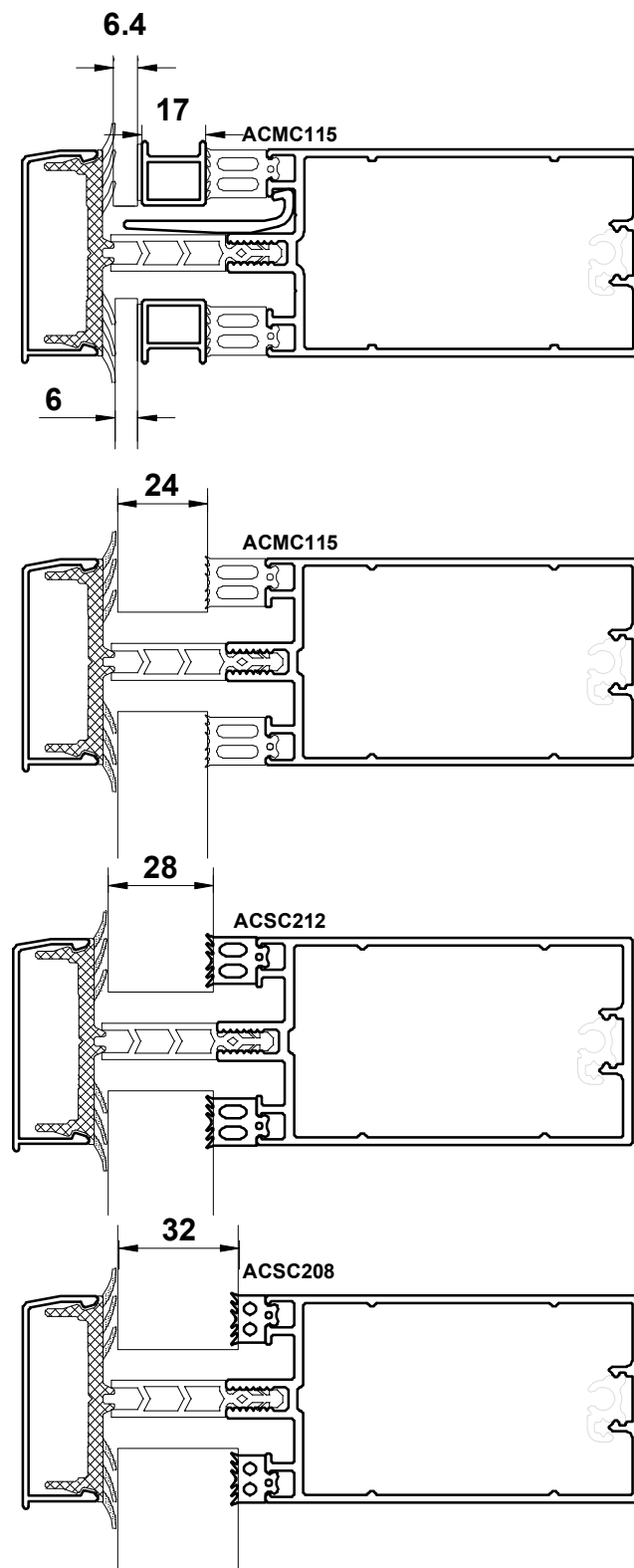
All brackets & fixings must be specified  
by a structural engineer

ACMC644





## Glazing



### Corner Gaskets

#### Single Glazing:

- ACMC624 - 6 mm Glazing (24.4mm total 17-1-6.4)
- ACMC628 - 10 mm Glazing (28.8mm total 17-1-10.8)
- ACMC632 - 14 mm Glazing (32mm total 17-1-14)

#### Double glazing:

- ACMC624 - 24mm Glazing
- ACMC628 - 28mm Glazing
- ACMC632 - 32mm Glazing

Use ACMX09830 EPDM  
Gasket Sealant  
to join corner gasket to  
standard gasket

