

OS2 40

CATALOGO

TECNICO

TECHNICAL

CATALOGUE

METALFORM

secco

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Sistema integrato di profili, accessori e guarnizioni con sezione a vista da 47 mm (nodo laterale) e 62 mm (nodo centrale), idoneo per la realizzazione di porte e finestre ad 1 o 2 ante, rettangolari, sagomate o ad arco, con o senza fissi laterali, inferiori o superiori. Sono previsti inoltre profili per la suddivisione delle specchiature vetrate, sia integrali che applicati al vetro, con sezioni in vista da 15 mm.

I **profili** componenti il sistema sono ottenuti tramite profilatura a freddo di nastri in acciaio decapato, dello spessore nominale di 20/10 mm, chiusi mediante saldatura in continuo ad alta frequenza. I profili complementari al sistema sono ottenuti tramite pressopiegatura di lamiere in acciaio decapato dello spessore nominale di 15/10 mm.

La costruzione dei telai prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto. Il sistema permette di alloggiare pannelature cieche o trasparenti con spessore massimo di 26 mm.

Caratteristiche del sistema:

Sormonto interno ed esterno delle ante;
Sistema di doppia guarnizione a giunto chiuso;
Cerniere ad avvitare o a saldare;
Kit serrature;
Chiusura inferiore tramite guarnizione automatica a ghigliottina, guarnizione a pinna o sistema di spazzolini.

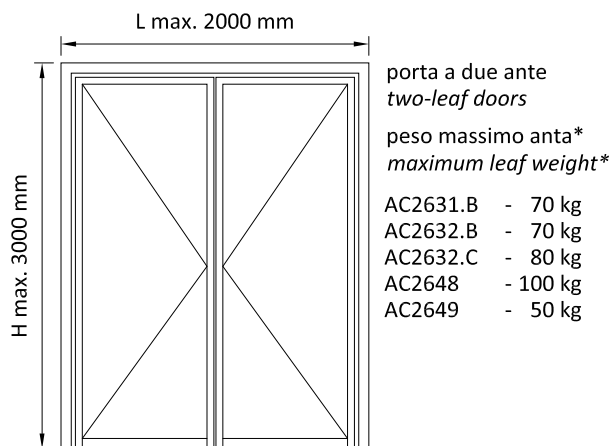
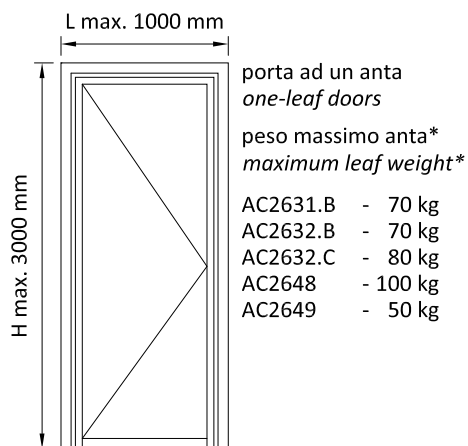
Integrated system of profiles, accessories and gaskets with visible sections from 47 mm (lateral section) and 62 mm (meeting style) for manufacturing rectangular, trapezoidal and arched shaped single or double casement windows and doors, with or without fixed lights. Available also dedicated true and simulated light dividers with visible section down to 15 mm.

The profiles of the system are made by cold-rolling of pickled steel coils, with nominal thickness of 20/10 mm, closed by continuous high frequency welding. Profiles complementary to the system are made by press-bending of pickled steel sheets with nominal thickness of 15/10 mm.

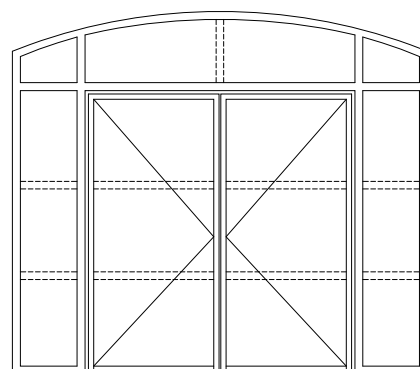
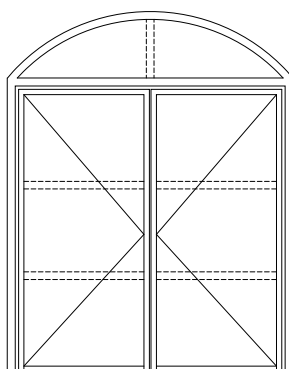
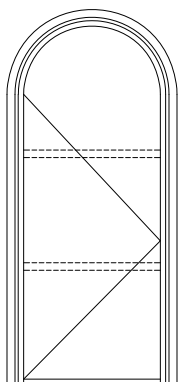
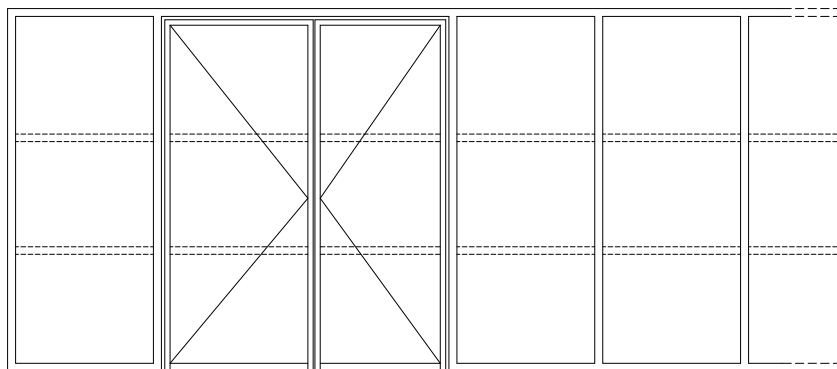
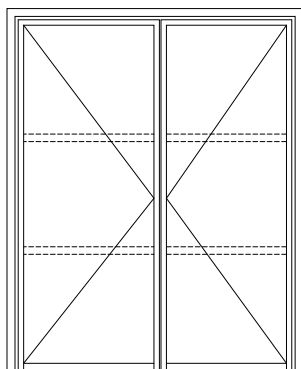
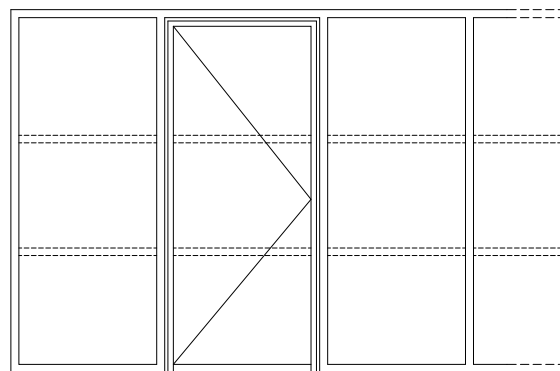
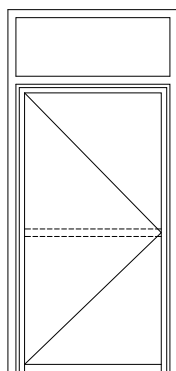
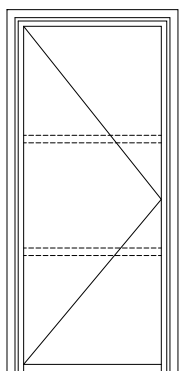
The assembly of the frames involves the welding of the profiles in continuous along the joining lines. The system allows to fit blind or transparent panels with a maximum thickness of 26 mm.

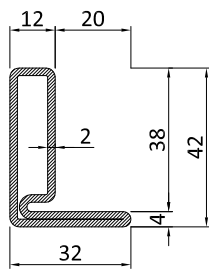
System features:

Rebated sashes in and outside;
Two-level gasket system;
Welded or screwed-on hinges;
Locking kits;
Bottom sealing with automatic drop-down system, flipper gasket or brush system.

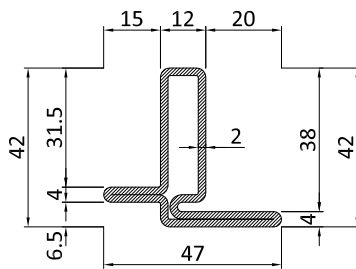
Limiti dimensionali - *Maximum dimension*

* cerniera aggiuntiva per H serramento > 2300 mm

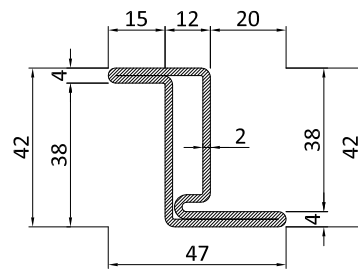
* *additional hinge for doors with height > 2300 mm*Esempi tipologie realizzabili - *Types of door*



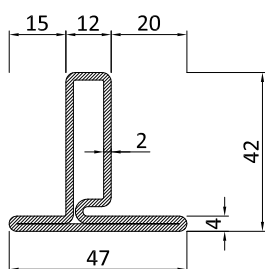
PR2461



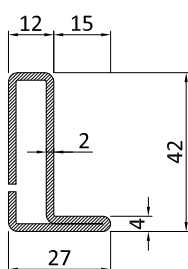
PR2462



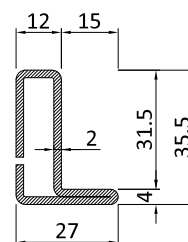
PR2463



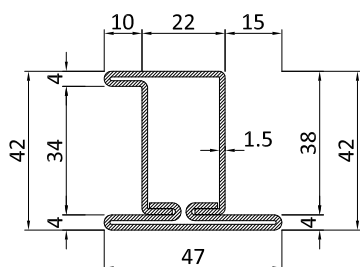
PR2482



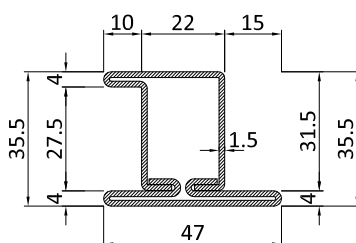
PR2451



PR2471

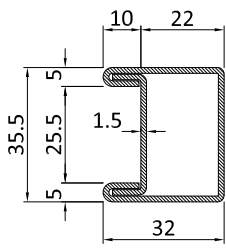


PR2455

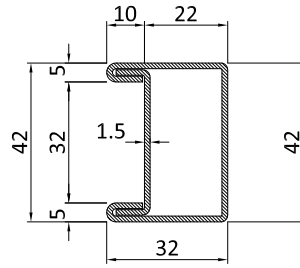


PR2474

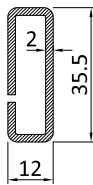
Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
PR2461	2,31	0,16	-	-	6,0	PR2471	1,76	0,12	-	-	4,0
PR2462	2,65	0,18	-	-	6,0	PR2455	2,68	0,20	-	-	4,0
PR2463	2,67	0,19	-	-	6,0	PR2474	2,53	0,19	-	-	4,0
PR2482	2,67	0,19	-	-	6,0						
PR2451	1,95	0,13	-	-	4,0						



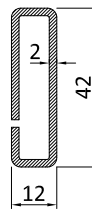
PR2424



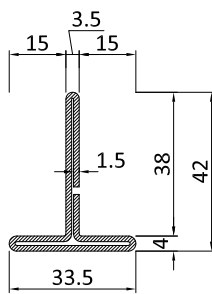
PR2425



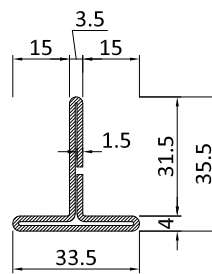
PR2430



PR2431

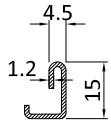


PR2454

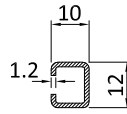


PR2464

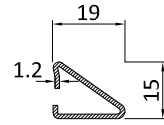
Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
PR2424	1,80	0,16	-	-	4,0	PR2464	1,46	0,13			4,0
PR2425	1,94	0,15	-	-	4,0						
PR2430	1,35	0,09	-	-	4,0						
PR2431	1,55	0,10	-	-	4,0						
PR2454	1,61	0,14			4,0						



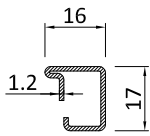
PR2415



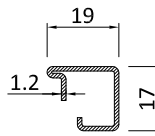
PR2416



PR2429



PR2606 *



PR2607 *

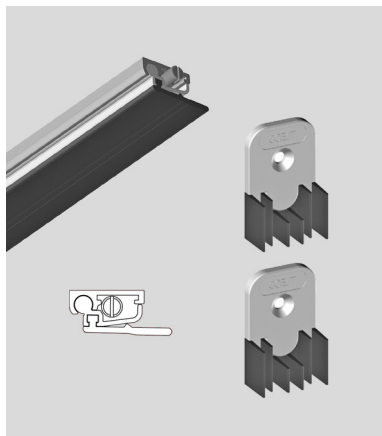
MATERIALE | MATERIAL

PR ____ DC acciaio decapato | *pickled steel*

* solo acciaio zincato | *only galvanized steel*

PR ____ ZN acciaio zincato | *galvanized steel*

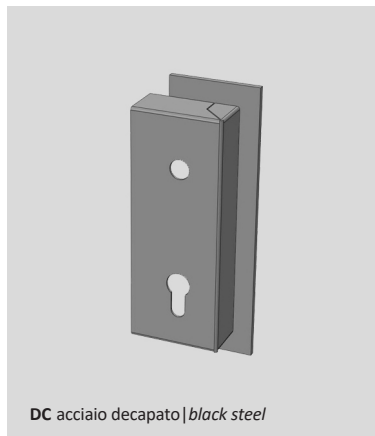
Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
PR2415	0,44	0,04	-	-	6,0						
PR2416	0,41	0,04	-	-	6,0						
PR2429	0,62	0,05	-	-	6,0						
PR2606	0,48	0,52	-	-	6,0						
PR2607	0,51	0,55	-	-	6,0						

**AC 2436.**

Guarnizione automatica di tenuta sotto porta

Automatic bottom seal

AC2436A
lunghezza/length 366 - 586 mm
AC2436B
lunghezza/length 496 - 886 mm
AC2436C
lunghezza/length 696 - 1186 mm

**AC 2496.xx**

Scatola copri serratura per anta con singolo fermavetro
Destra

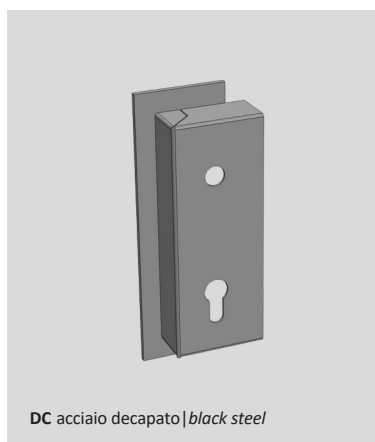
RH lock cover box for leaf with single glazing bead

DC acciaio decapato | black steel

**AC 2440**

Catenaccio 2^a anta a incasso

Second leaf flush bolt for doors

**AC 2497.xx**

Scatola copri serratura per anta con singolo fermavetro
Sinistra

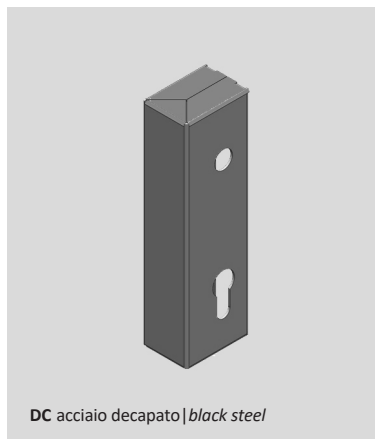
LH lock cover box for leaf with single glazing bead

DC acciaio decapato | black steel

**AC 2493**

Serratura cilindro europeo con incontro magnetico E35 per anta con doppio fermavetro

Euro cylinder lock with magnetic strike E35 for leaf with double glazing beads

**AC 2498.xx**

Scatola copri serratura per anta con doppio fermavetro

Lock cover box for leaf with double glazing beads

DC acciaio decapato | black steel

**AC 2494**

Serratura cilindro europeo con incontro magnetico E50 per anta con singolo fermavetro

Euro cylinder lock with magnetic strike E50 for leaf with single glazing bead

**AC 2621G.B**

Catenaccio 2^a anta per porta
L = 220 mm

*Second leaf flush bolt for doors
L = 220 mm*

**AC 2621G.C**

Catenaccio 2^a anta per porta
L = 650 mm

Second leaf flush bolt for doors
L = 650 mm

**AC 2632.C**

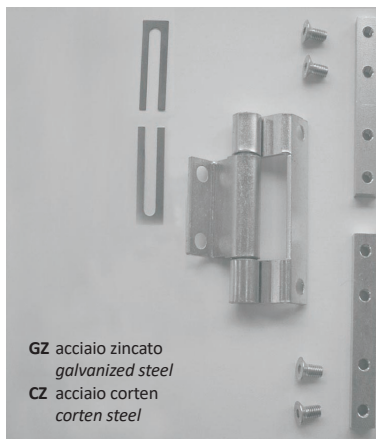
Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 16
Peso max anta 80 kg

*Adjustable weld-on hinge
in galvanised steel | Ø 16
Max leaf weight 80 kg*

**AC 2631.A**

Cerniera a due ali in acciaio
zincato a saldare | Ø 10
Peso max anta 40 kg

*Weld-on hinge in galvanised
steel | Ø 10
Max leaf weight 40 kg*

**AC 2648.xx**

Cerniera a tre ali da avvitare
su PR2463 (apertura interna)
su PR2462 (apertura esterna)
Peso max anta 100 kg

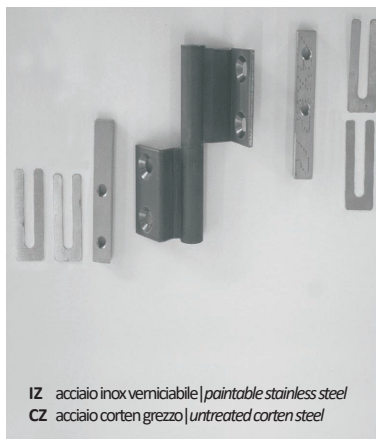
*Three-wing screw-on hinge
on PR2463 (inward opening)
on PR2462 (outward opening)
Max leaf weight 100 kg*

GZ acciaio zincato
galvanized steel
CZ acciaio corten
corten steel

**AC 2631.B**

Cerniera a due ali in acciaio
zincato a saldare | Ø 13
Peso max anta 70 kg

*Weld-on hinge in galvanised
steel | Ø 13
Max leaf weight 70 kg*

**AC 2649.xx.IDES**

Cerniera a due ali da avvitare
Sx su PR2463 (apertura interna)
Dx su PR2462 (apertura esterna)
Peso max anta 50 kg

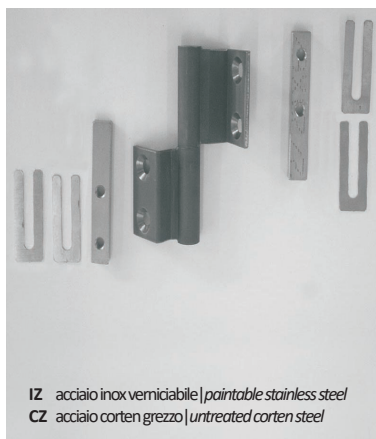
*Two-wing screw-on hinge
LH on PR2463 (inward opening)
RH on PR2462 (outward opening)
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel

**AC 2632.B**

Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 13
Peso max anta 70 kg

*Adjustable weld-on hinge
in galvanised steel | Ø 13
Max leaf weight 70 kg*

**AC 2649.xx.ISED**

Cerniera a due ali da avvitare
Dx su PR2463 (apertura interna)
Sx su PR2462 (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
RH on PR2463 (inward opening)
LH on PR2462 (outward opening)
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel

**AC 2653.xx**

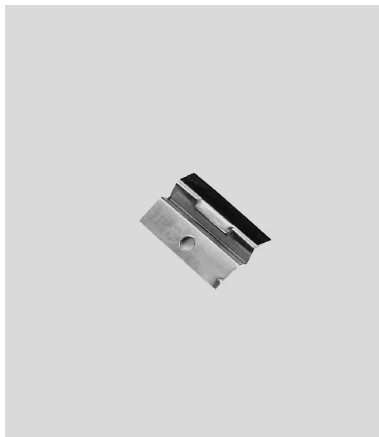
Kit fondini per profili
PR2462 - PR2463

*Fittings kit for profiles
PR2462 - PR2463*

**AC 2654.xx**

Kit fondini per profili
PR2462 - PR2474

*Fittings kit for profiles
PR2462 - PR2474*

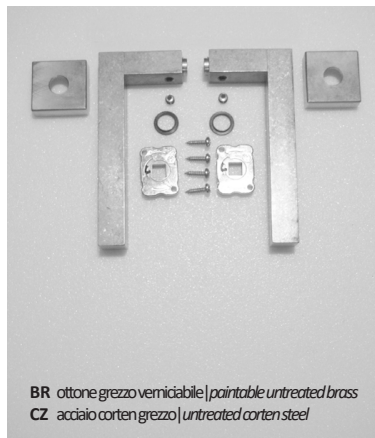
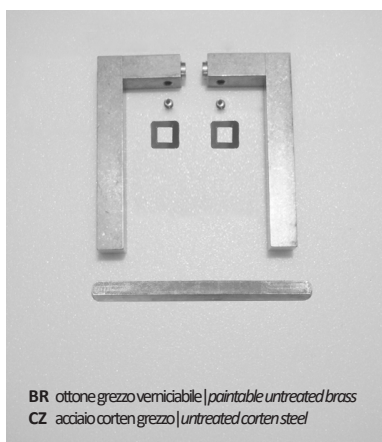
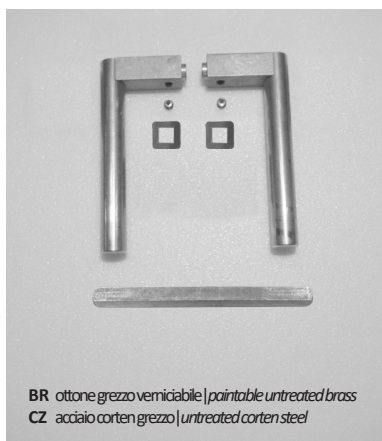
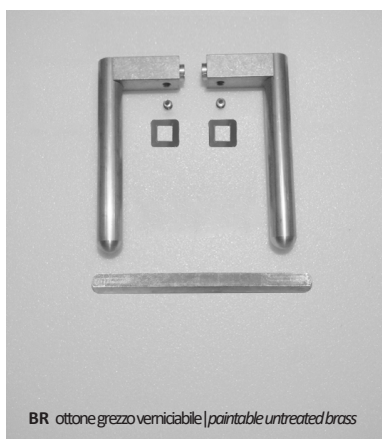
**AC 5023**

Clips per fissaggio fermavetri

Clips for securing

**ACV 040**

Quadro maniglia

Handle spindle bar**ACV 942.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | square | cut*BR ottone grezzo verniciabile | *paintable untreated brass*
CZ acciaio corten grezzo | *untreated corten steel***ACV 902.xx**Coppia maniglie per porta
"VITRUVIO" medium
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
L | square | cut*BR ottone grezzo verniciabile | *paintable untreated brass*
CZ acciaio corten grezzo | *untreated corten steel***ACV 943.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | cut*BR ottone grezzo verniciabile | *paintable untreated brass*
CZ acciaio corten grezzo | *untreated corten steel***ACV 903.xx**Coppia maniglie per porta
"VITRUVIO" medium
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
L | round | cut*BR ottone grezzo verniciabile | *paintable untreated brass*
CZ acciaio corten grezzo | *untreated corten steel***ACV 944.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | sfera*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | sphere*BR ottone grezzo verniciabile | *paintable untreated brass***ACV 904.xx**Coppia maniglie per porta
"VITRUVIO" medium
L | tonda | sfera*Double door handlesets
"VITRUVIO" medium
L | round | sphere*BR ottone grezzo verniciabile | *paintable untreated brass***ACV 952.xx**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | square | cut*BR ottone grezzo verniciabile | *paintable untreated brass*
CZ acciaio corten grezzo | *untreated corten steel*

**ACV 953.xx**

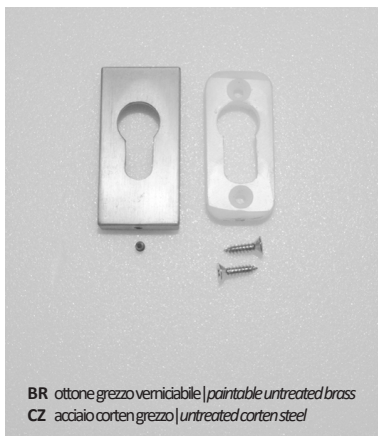
Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | tronca

Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | cut

**ACV 954.xx**

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | sfera

Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | sphere

**ACV 964.xx**

Bocchetta copri cilindro a profilo
europeo

Euro cylinder escutcheon plate

**GE 1011**

Guarnizione interna vetro
spessore 4 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GU 2036**

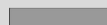
Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

*Soft adhesive shim for
external window joint
12x4 mm*

**GE 2029E**

Guarnizione interna vetro
spessore 2 mm

*Internal weather strip for
glazing bead
2 mm thick*

**GU 2416**

Piattina adesiva morbida
per fondo giunto esterno vetro
10x3 mm su fermavetro PR2416

*Soft adhesive shim for
external window joint
10x3 mm on PR2416
glazing bead*

**GE 2543TT**

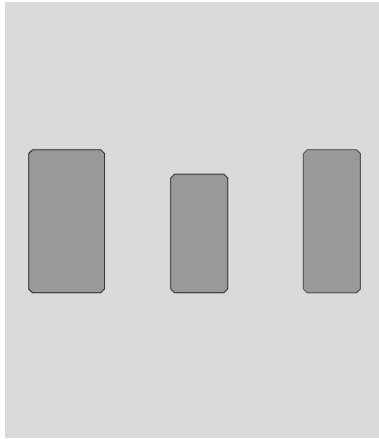
Guarnizione di battuta
interna | esterna su profili
PR2463 | PR2462

*Internal/external weather
strip with
PR2463 | PR2462
profiles*

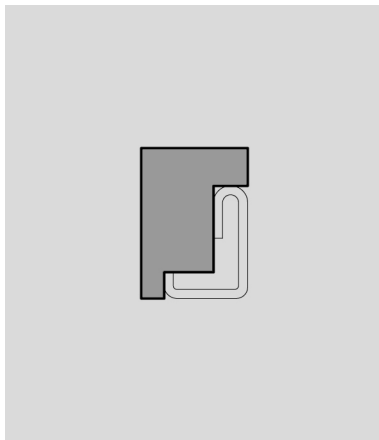
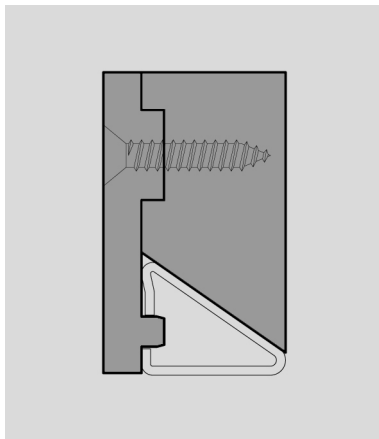
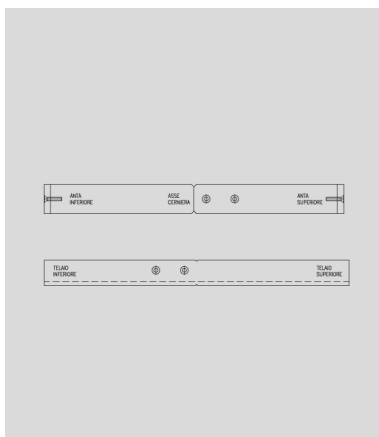
**GP 0095**

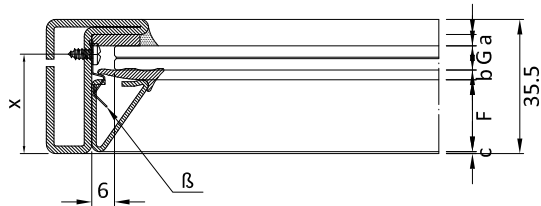
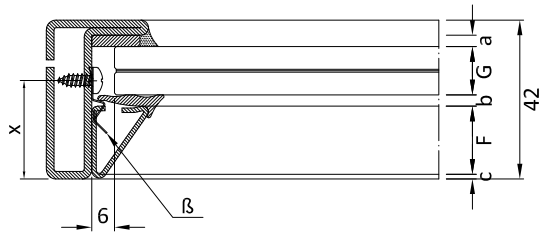
Guarnizione interna vetro
spessore 3mm

*Internal weather strip for
glazing bead
3 mm thick*

**AT 2400**

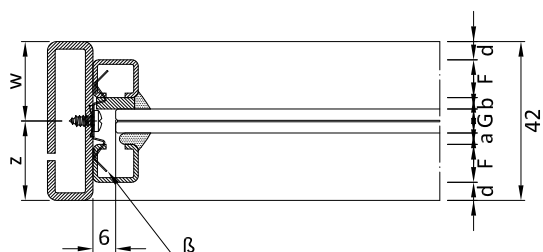
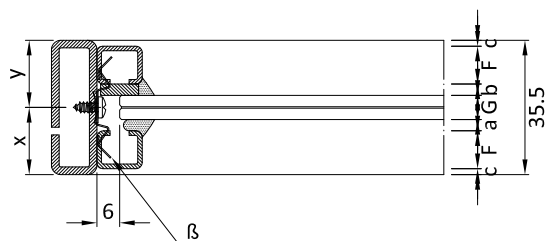
Kit ganasce di taglio



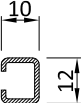
Kit of cutting jaws for profiles**AT 2415**Ganasce di taglio per
fermavetro PR2415*Kit of cutting jaws
for glazin bead PR2415***AT 2429**Ganasce di taglio per
fermavetro PR2429*Kit of cutting jaws
for glazin bead PR2429***AT 2629**Maschera per esecuzione
fori fissaggio cerniere
AC2649-AC2650*Drill jig for
AC2649-AC2650 hinges*



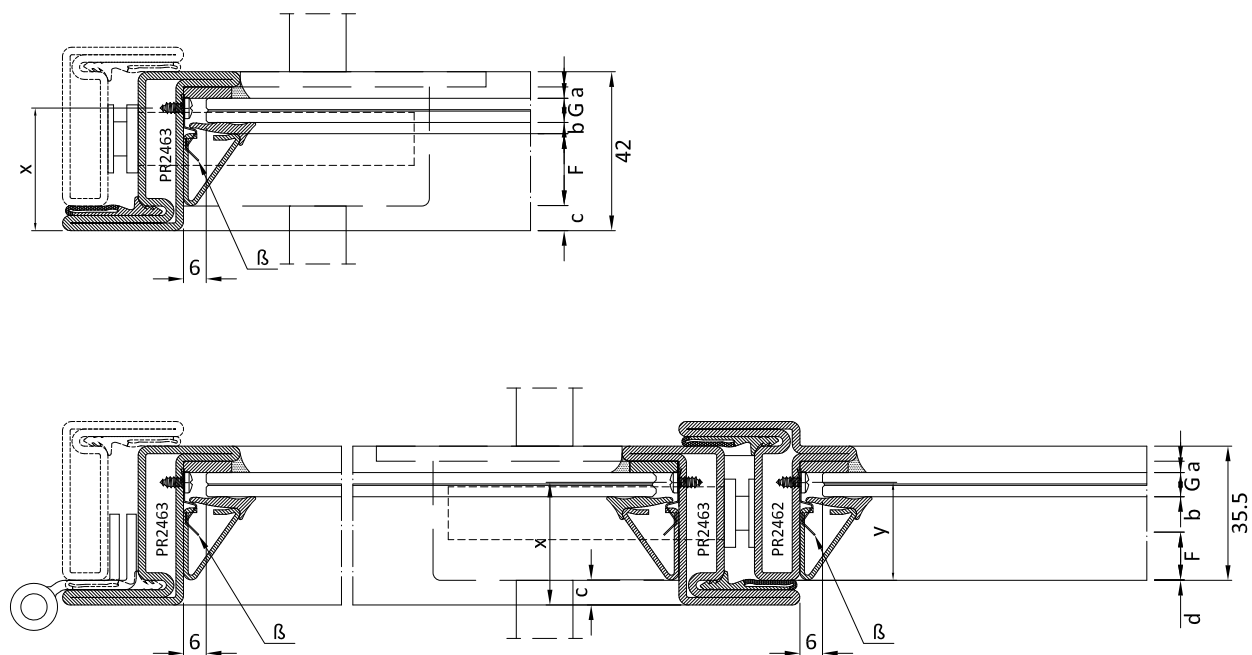
F	G		Guarnizioni - gasket						
	spessore vetro glass thickness		GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice Code	mm		a	b	x		c		β
	Fisso 42 Fix 42	Fisso 35.5 Fix 35.5			Fisso 42 Fix 42	Fisso 35.5 Fix 35.5	Fisso 42 Fix 42	Fisso 35.5 Fix 35.5	
PR2415	12.5 - 27.5	12.5 - 21	3	3	33 - 17.5	26.5 - 17.5	15 - 0	8.5 - 0	AC5023
PR2416	6.5 - 22	6.5 - 15.5			32.5 - 16.5	26 - 16.5	15.5 - 0	9 - 0	AC5023
PR2429	6.5 - 13	6.5			32.5 - 25.5	26	6.5 - 0	0	AC5023
PR2606	6.5 - 16	6.5 - 9.5			27.5 - 18	21 - 18	9.5 - 0	3 - 0	AC5023
PR2607	6.5 - 13	6.5			24.5 - 18	18	6.5 - 0	0	AC5023

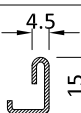
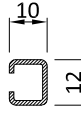
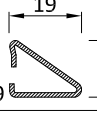

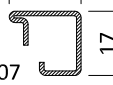
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied



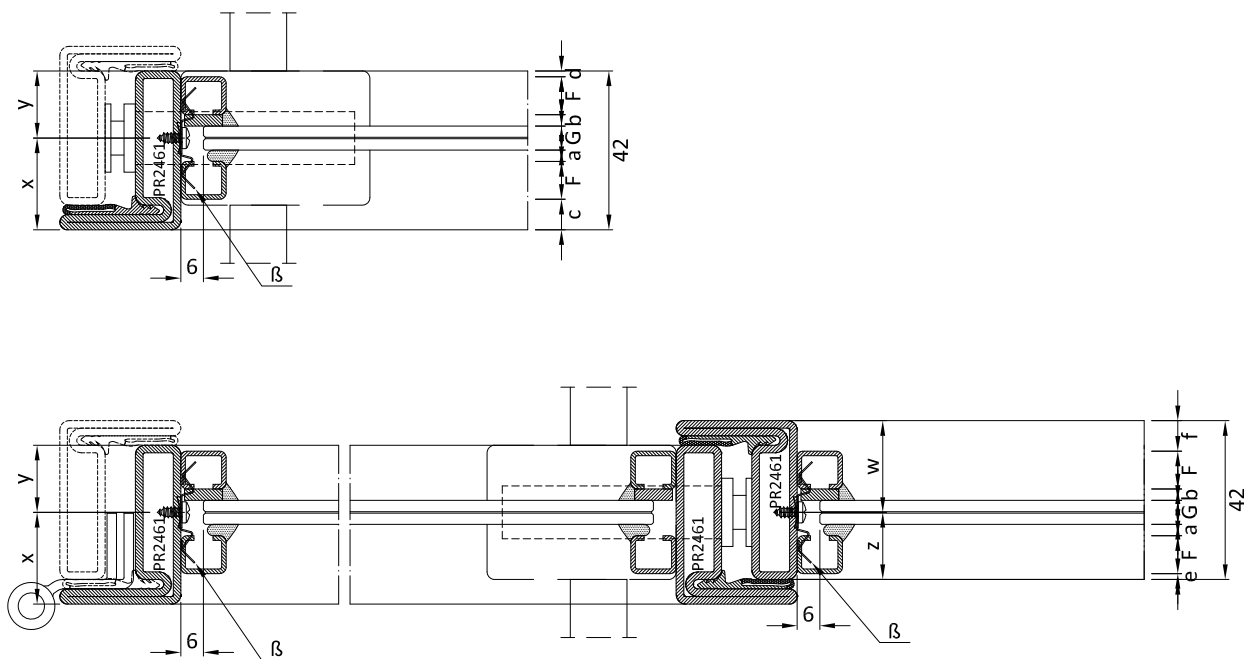
F	G		Guarnizioni - gasket								
fermavetro glazing beads	spessore vetro glass thickness		3 mm  sigillatura seal	GU2416 3 mm  + sigillatura + seal	asse fissaggio viti fermavetro glazing beads securing axis				rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice Code	mm		a	b	Fisso 35.5		Fisso 42		Fisso 35.5	Fisso 42	β
	Fix 35.5	Fix 42			x	y	z	w	c	d	
PR2416 	6.5 - 9.5	6.5 - 16	3±0.5	3±0.5	17.8	17.8	21	21	1	4.5	AC5023

vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied



F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
		GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	x	y	c	d	
fermavetro glazing beads	spessore vetro glass thickness	a	b					β
codice Code	mm							
PR2415 	12.5 - 21	3	3	24.5 - 33	26.5 - 18	15 - 6.5	8.5 - 0	AC5023
PR2416 	6.5 - 15.5			23.5 - 32.5	17 - 26	15.5 - 6.5	9 - 0	AC5023
PR2429 	6.5			32.5	26	6.5	0	AC5023
PR2606 	6.5 - 16			27.5 - 18	21 - 18	9.5 - 0	3 - 0	AC5023
PR2607 	6.5 - 13			24.5 - 18	15	6.5 - 0	0	AC5023

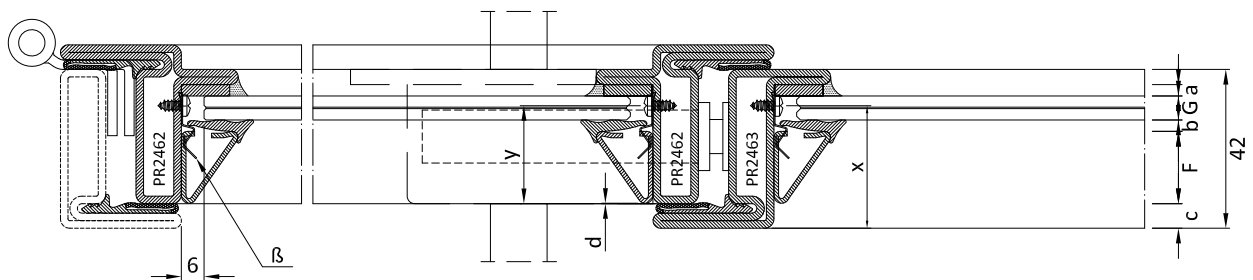
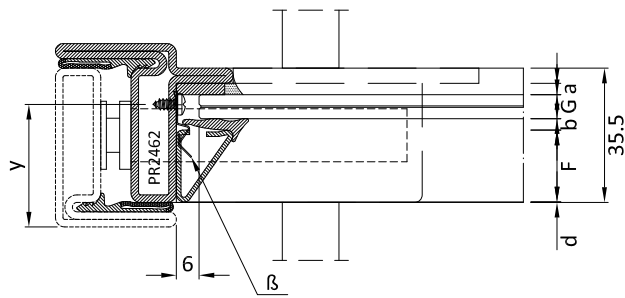
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied

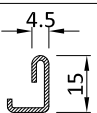
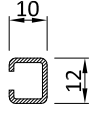
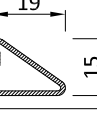
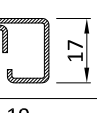



F		G		Guarnizioni - gasket										
fermavetro glazing beads		spessore vetro glass thickness		3 mm sigillatura seal	GU2416 3 mm + sigillatura + seal	asse fissaggio viti fermavetro glazing beads securing axis				rientro fermavetro glazing beads gap				clips fissaggio fermavetro glazing beads securing clips
codice Code	mm		a	b	1^ anta 1 st leaf		2^ anta 2 nd leaf		1^ anta 1 st leaf		2^ anta 2 nd leaf		β	
	x	y			z	w	c	d	e	f				
PR2416	10	12	3±0.5	3±0.5	24.5	17.5	17.5	24.5	7.5	1	1	7.5	AC5023	

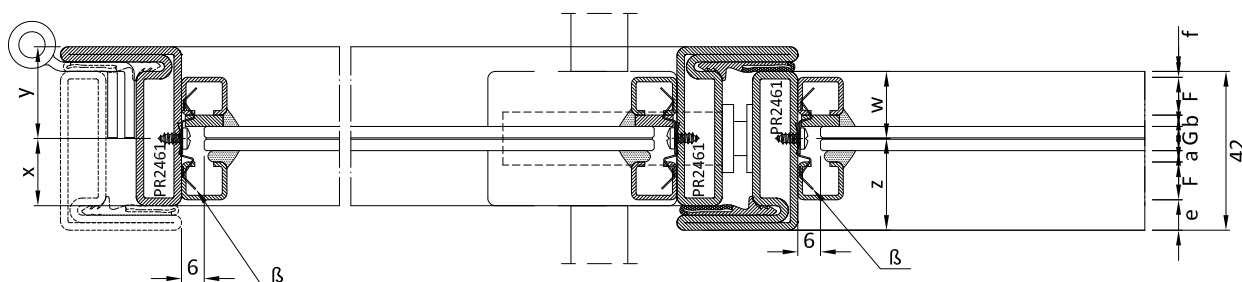
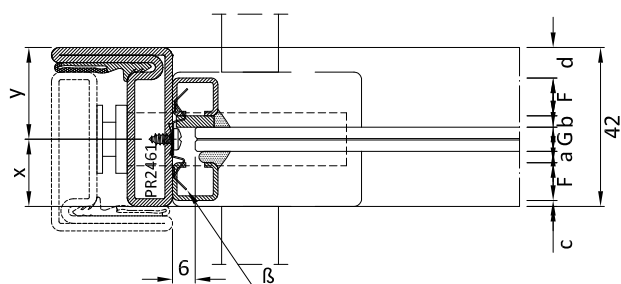
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied

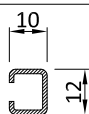




F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
		GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	x	y	c	d	
fermavetro glazing beads	spessore vetro glass thickness	a	b					β
codice Code	mm							
PR2415 	12.5 - 21	3	3	24.5 - 33	26.5 - 18	15 - 6.5	8.5 - 0	AC5023
PR2416 	6.5 - 15.5			23.5 - 32.5	17 - 26	15.5 - 6.5	9 - 0	AC5023
PR2429 	6.5			32.5	26	6.5	0	AC5023
PR2606 	6.5 - 9			27.5 - 24.5	21 - 18	9.5 - 6.5	3 - 0	AC5023
PR2607 	6.5			24.5	18	6.5	0	AC5023

vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied

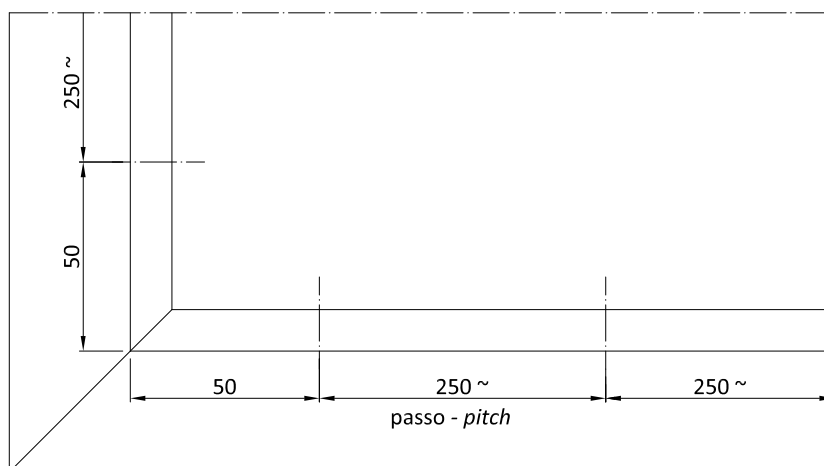


F	G		Guarnizioni - gasket										
	spessore vetro glass thickness		3 mm sigillatura seal	GU2416 3 mm + sigillatura + seal	asse fissaggio viti fermavetro glazing beads securing axis				rientro fermavetro glazing beads gap				clips fissaggio fermavetro glazing beads securing clips
codice Code	mm		a	b	1^ anta 1 st leaf		2^ anta 2 nd leaf		1^ anta 1 st leaf		2^ anta 2 nd leaf		β
	x	y			z	w	c	d	e	f			
PR2416 	6.5 - 8.5	6.5 - 8.5	3±0.5	3±0.5	17.5	24.5	24.5	17.5	1	7.5	7.5	1	AC5023

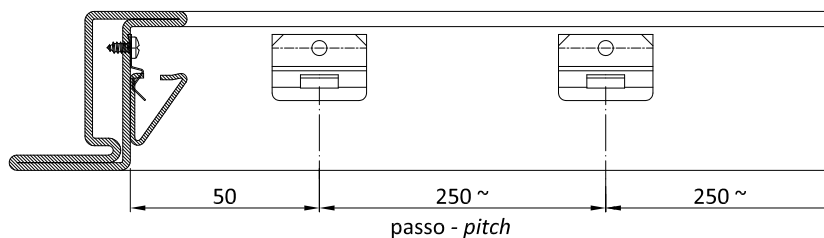
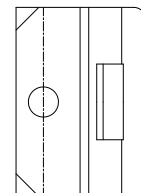
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied

Passo clips fissaggio fermavetri
Clip pitch for glazing beads securing

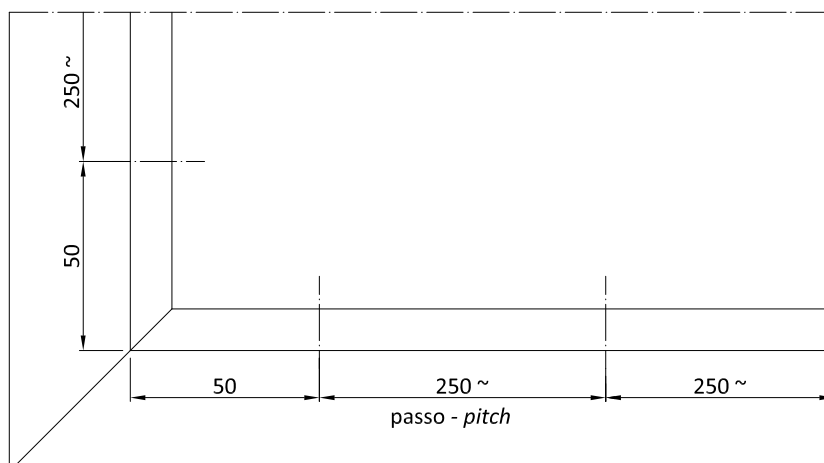
Fissaggio fermavetri PR2415 - PR2416 - PR2429: clip AC5023 con vite TC 3.5 x 9.5 (non fornite)
Glazing beads fixing PR2415 - PR2416 - PR2429: clip AC5023 with screw TC 3.5 x 9.5 (not included)



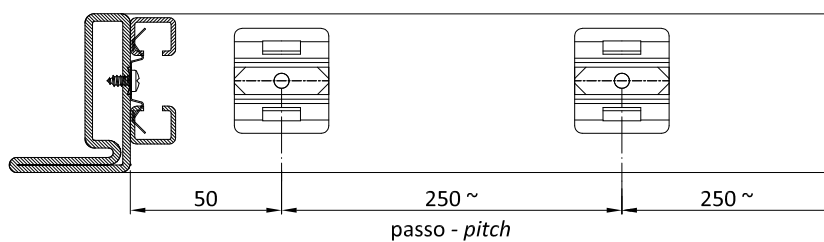
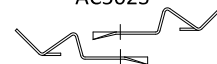
AC5023

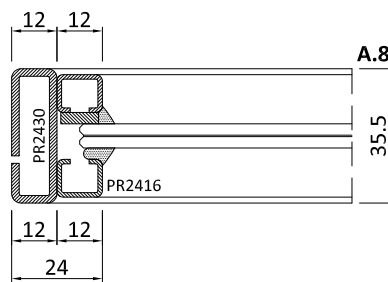
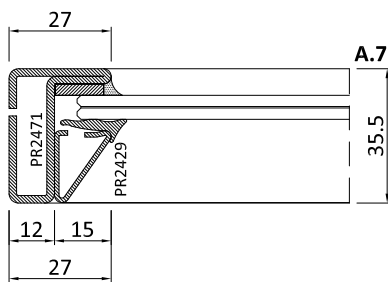
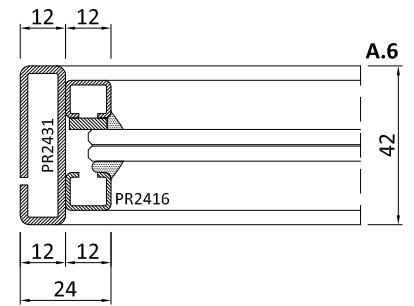
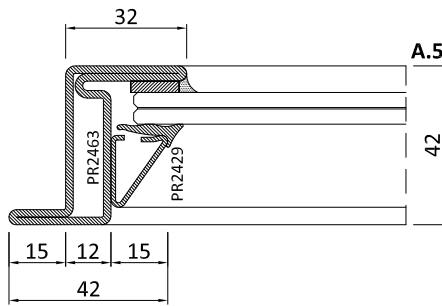
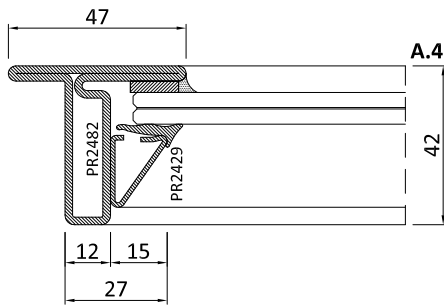
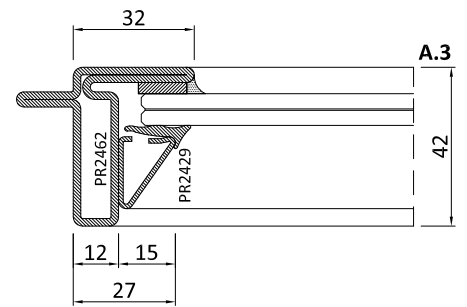
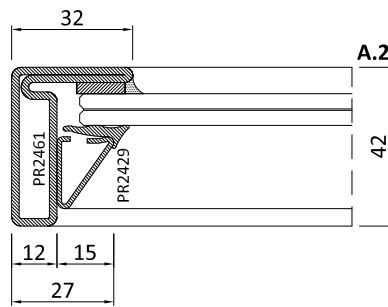
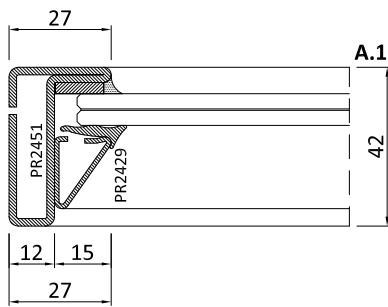
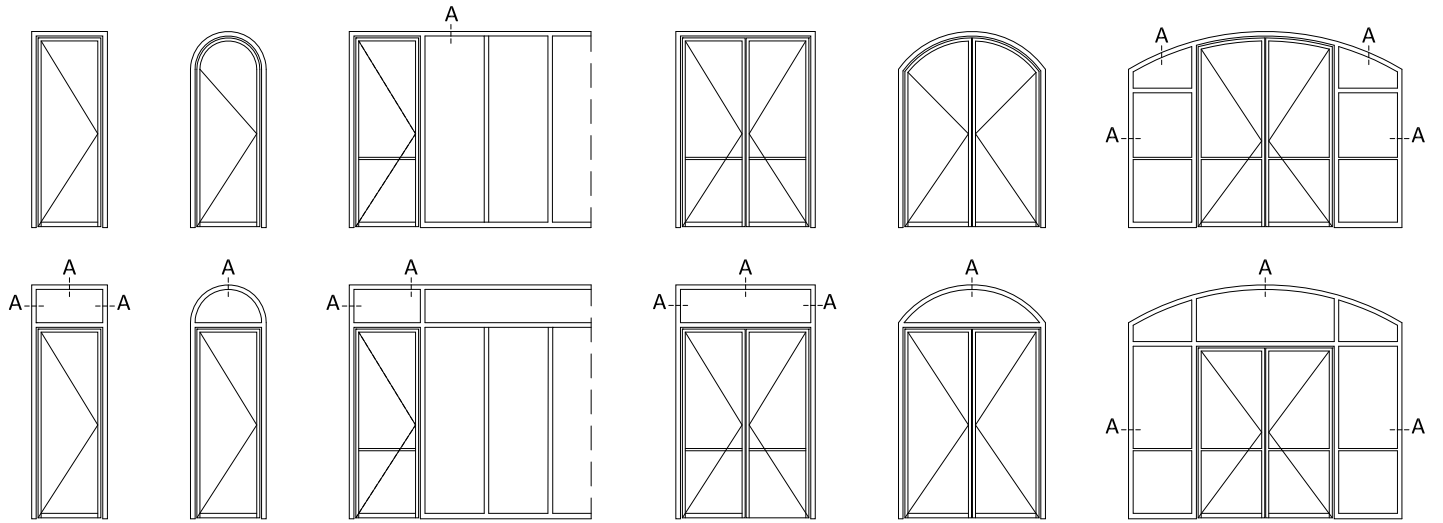


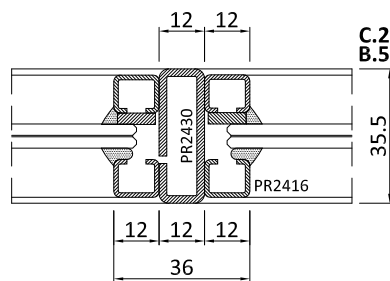
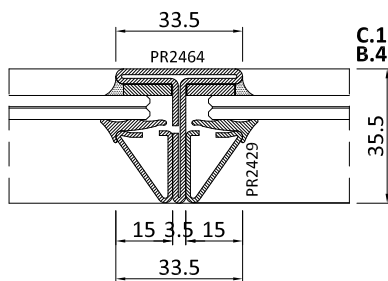
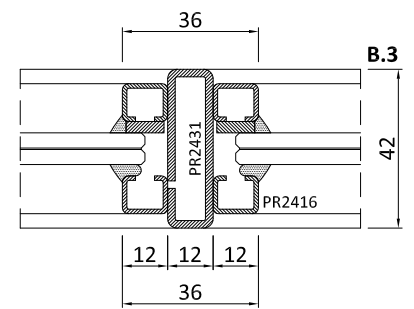
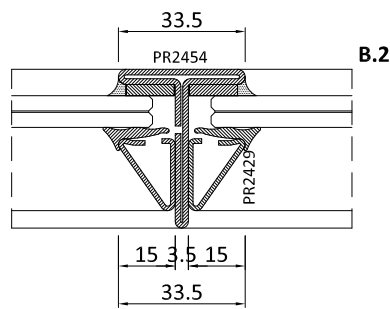
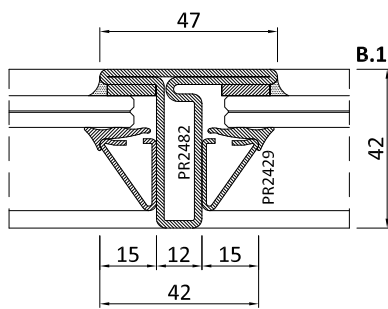
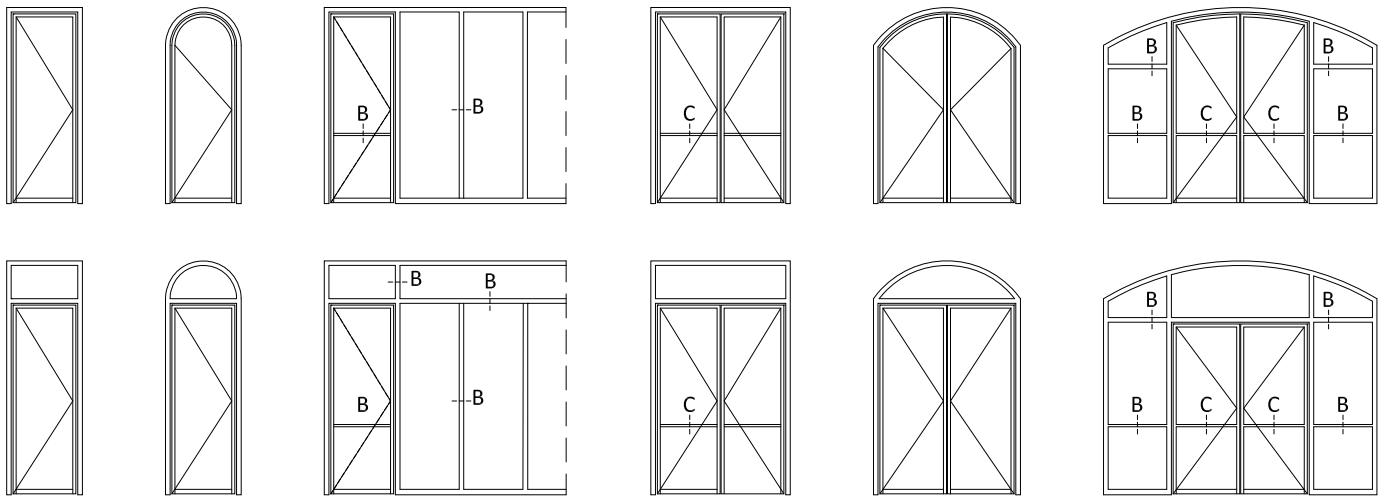
Fissaggio fermavetri PR2416: clip AC5023 con vite TC 3.5 x 9.5 (non fornite)
Glazing beads fixing PR2416: clip AC5023 with screw TC 3.5 x 9.5 (not included)

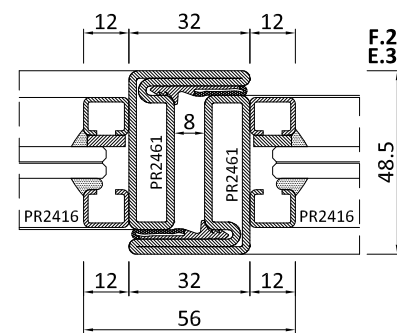
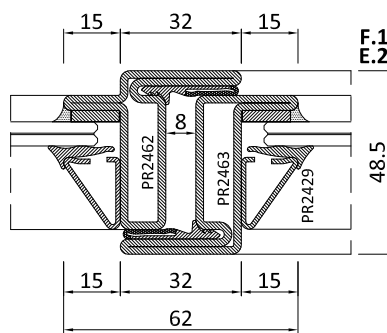
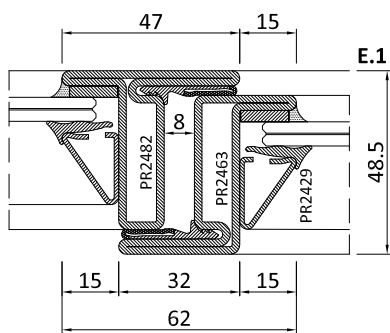
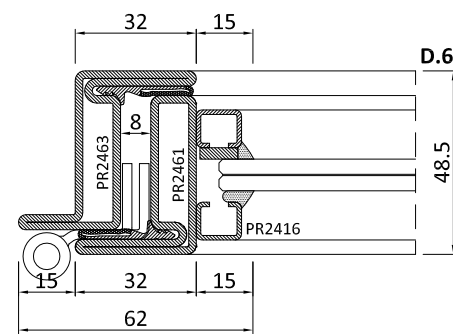
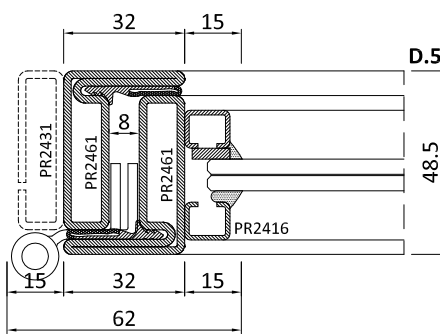
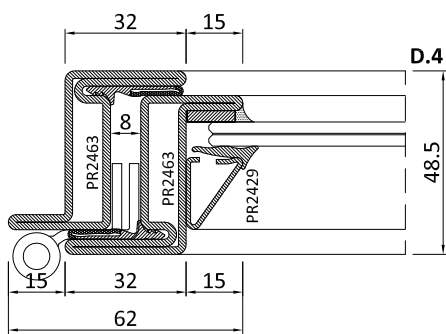
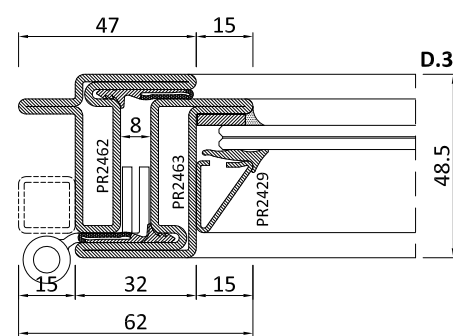
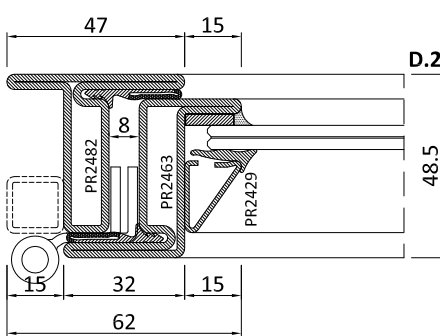
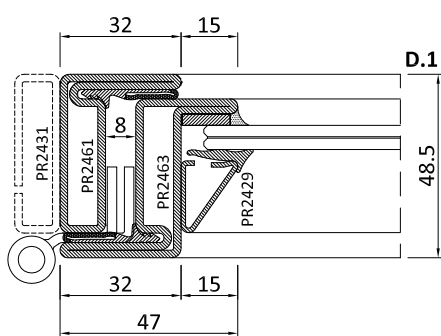
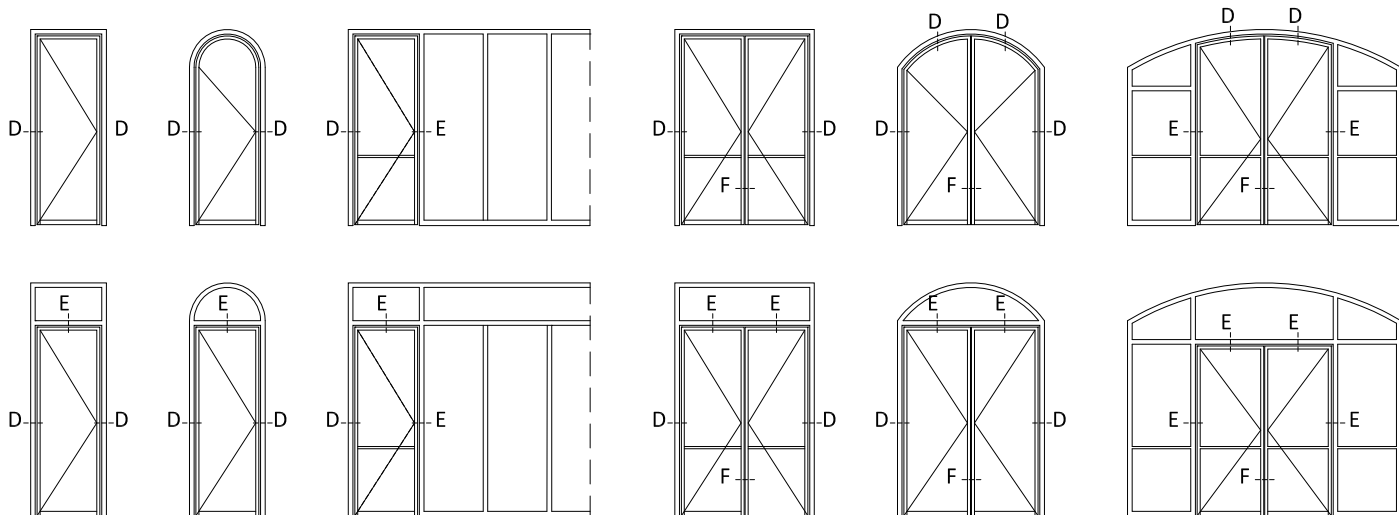


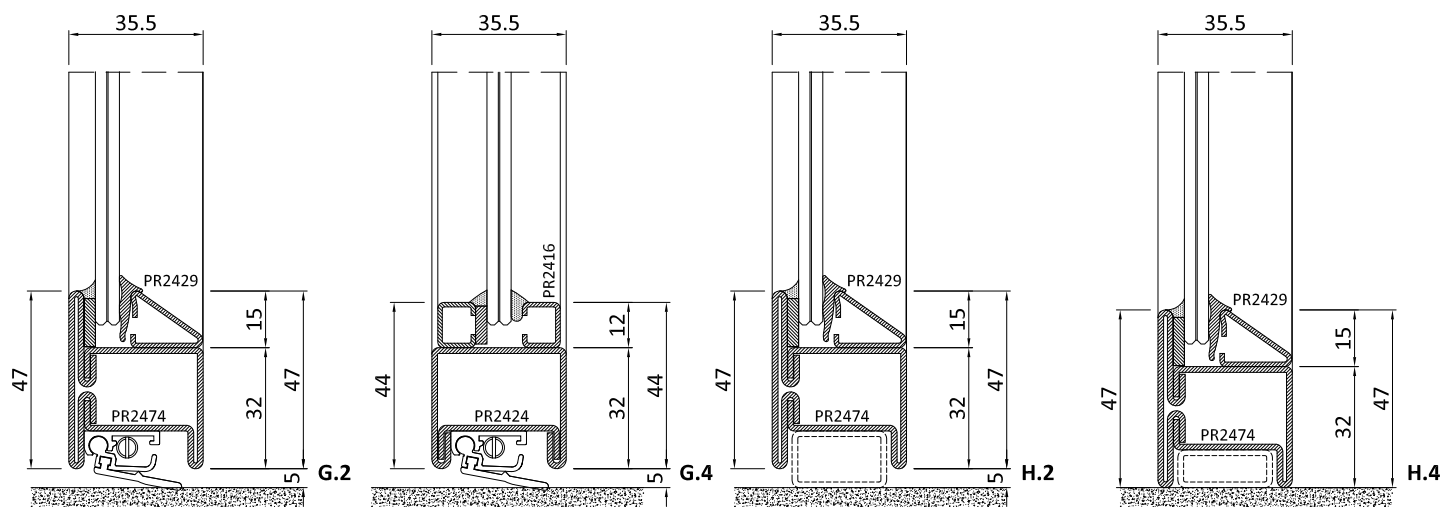
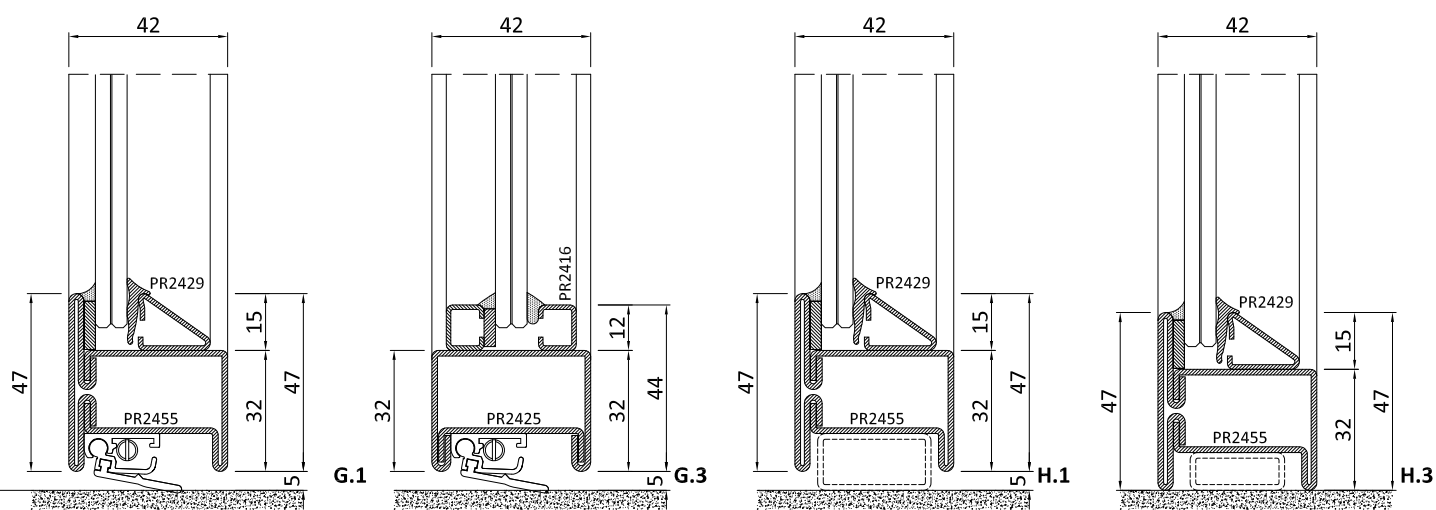
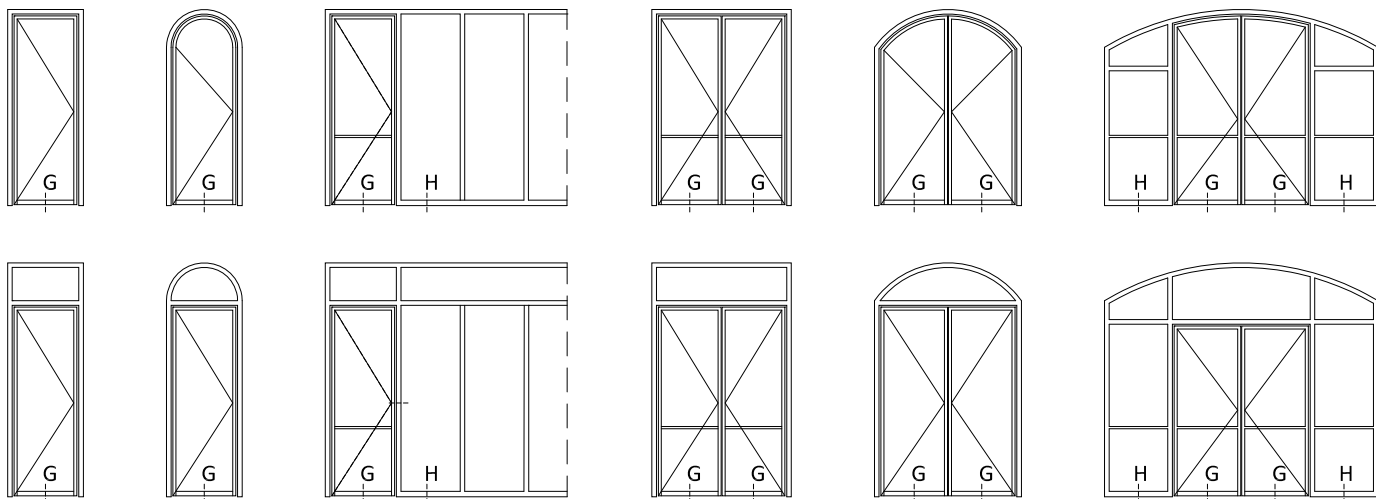
AC5023

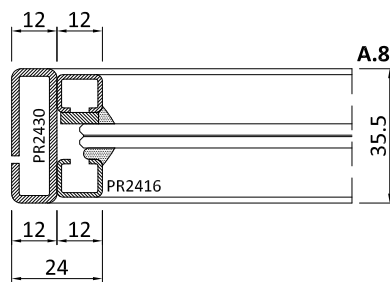
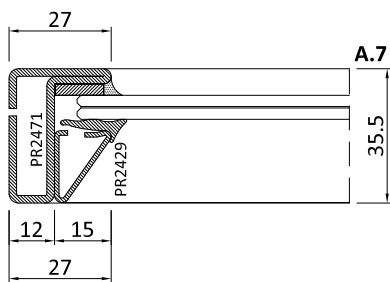
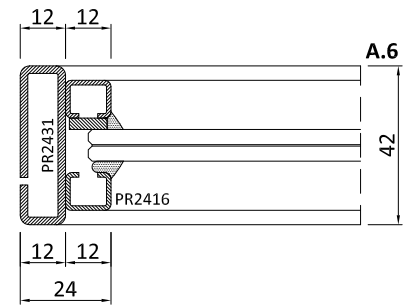
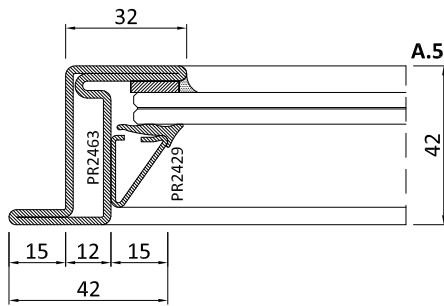
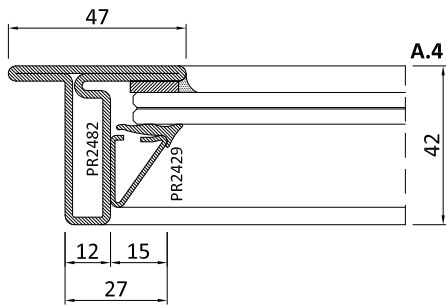
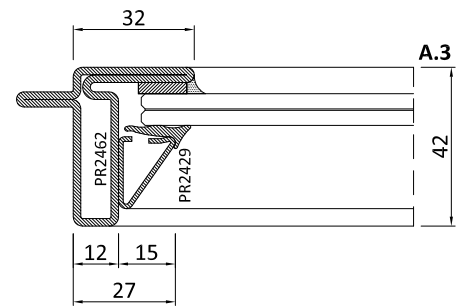
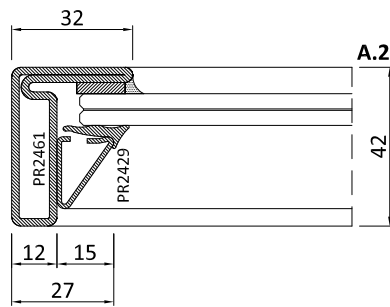
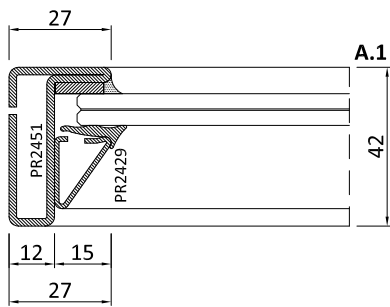
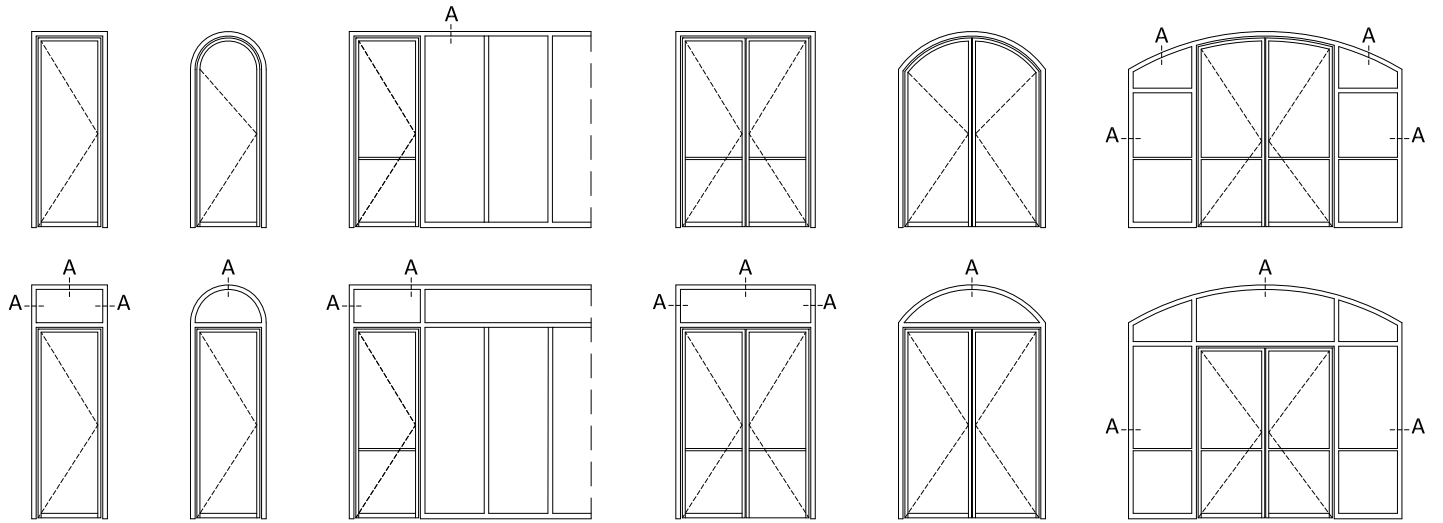


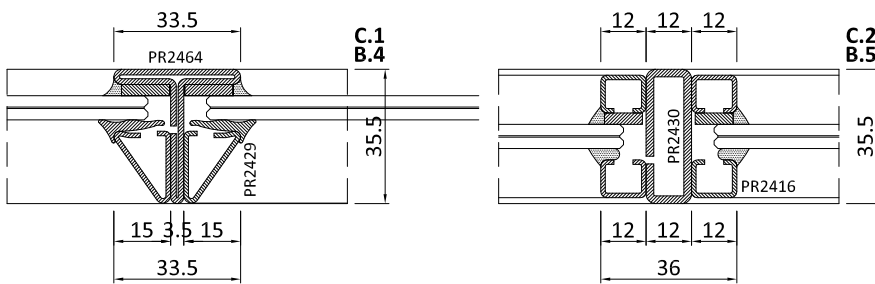
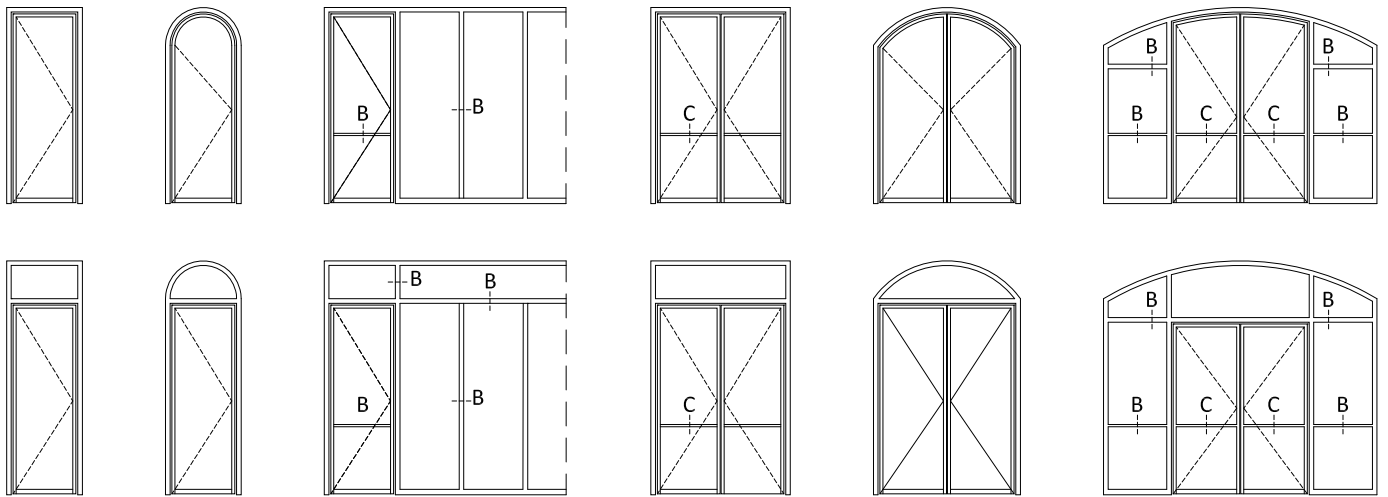


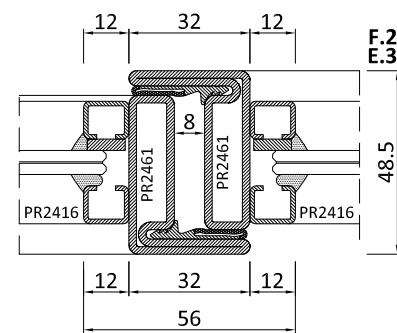
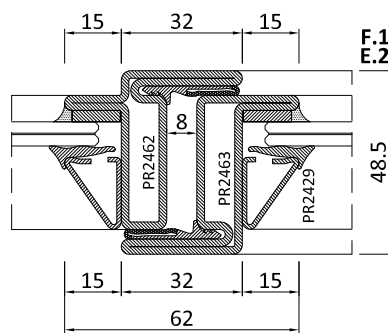
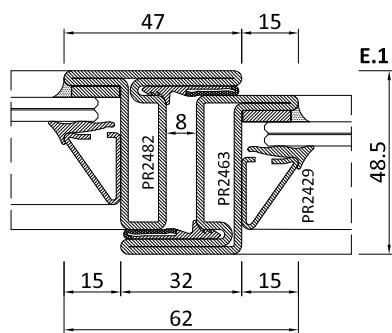
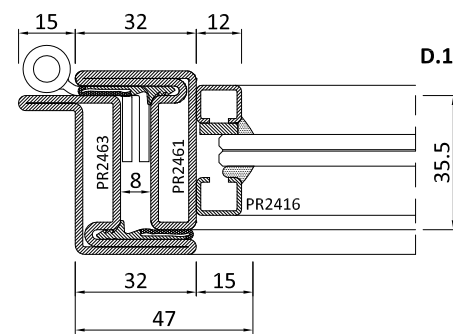
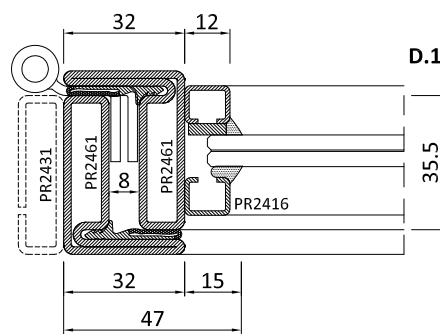
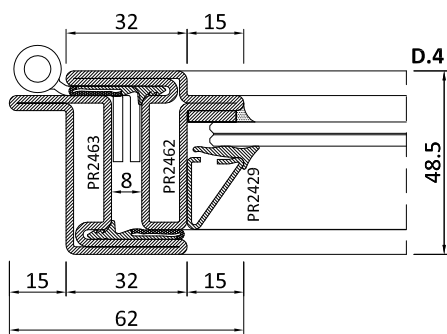
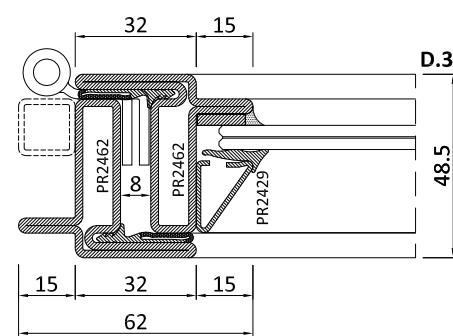
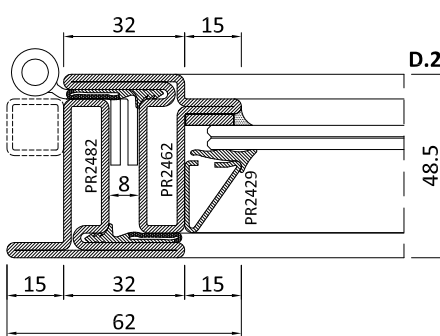
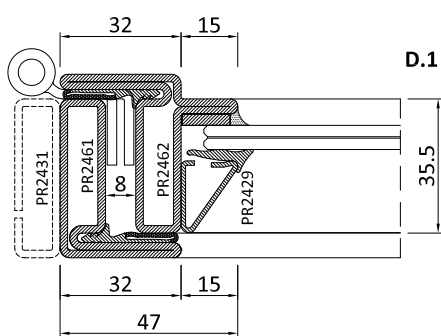
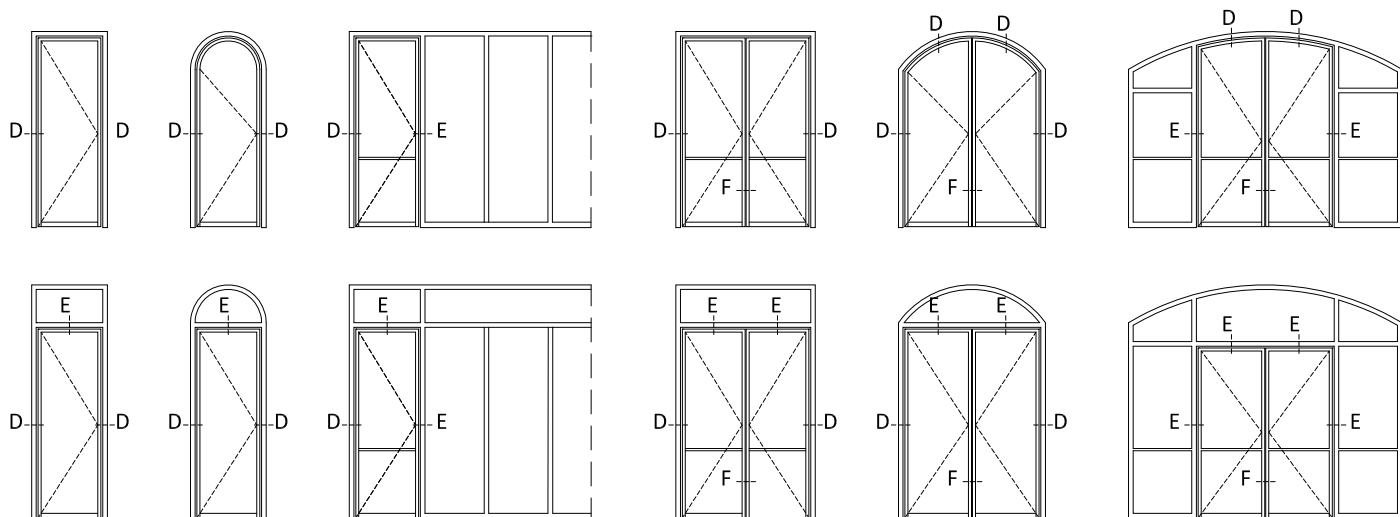


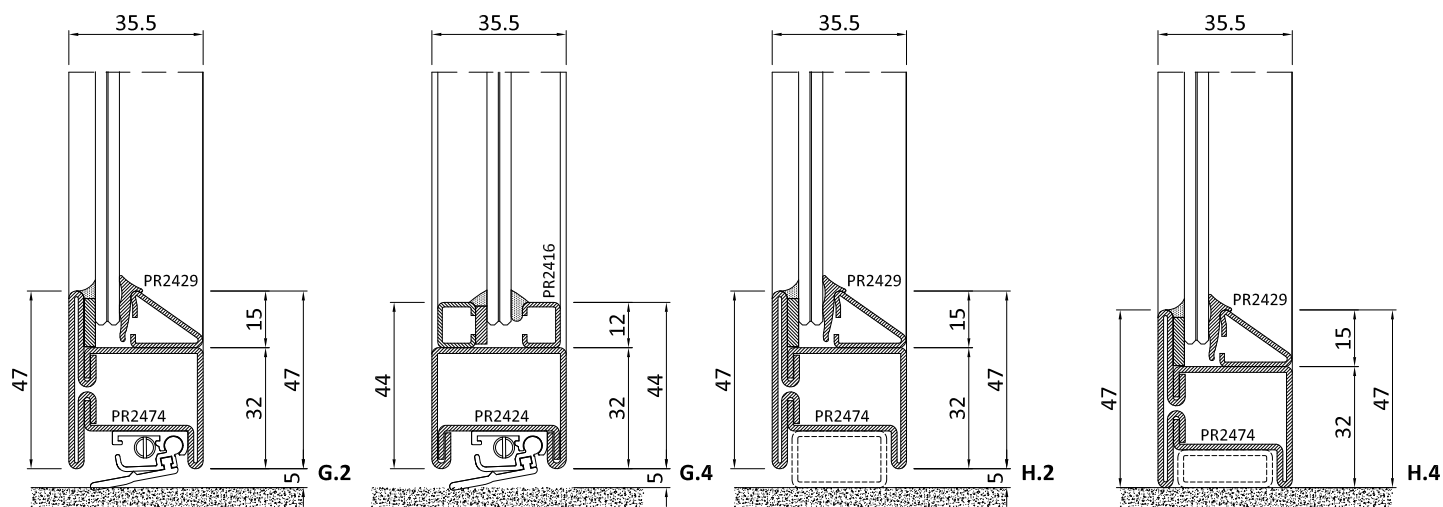
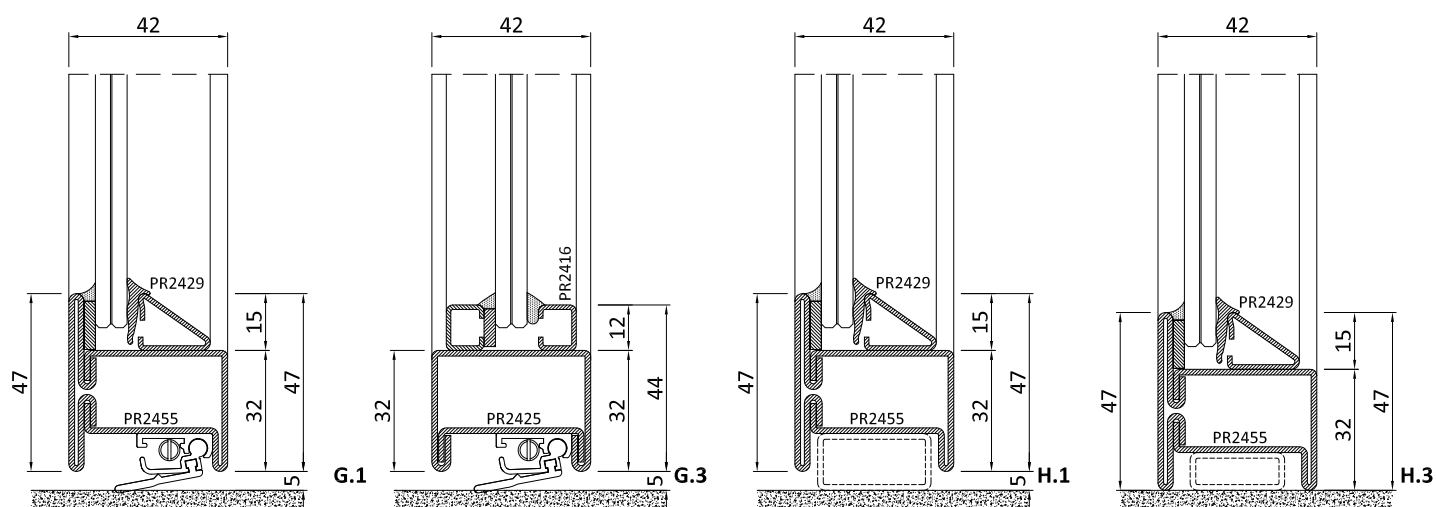
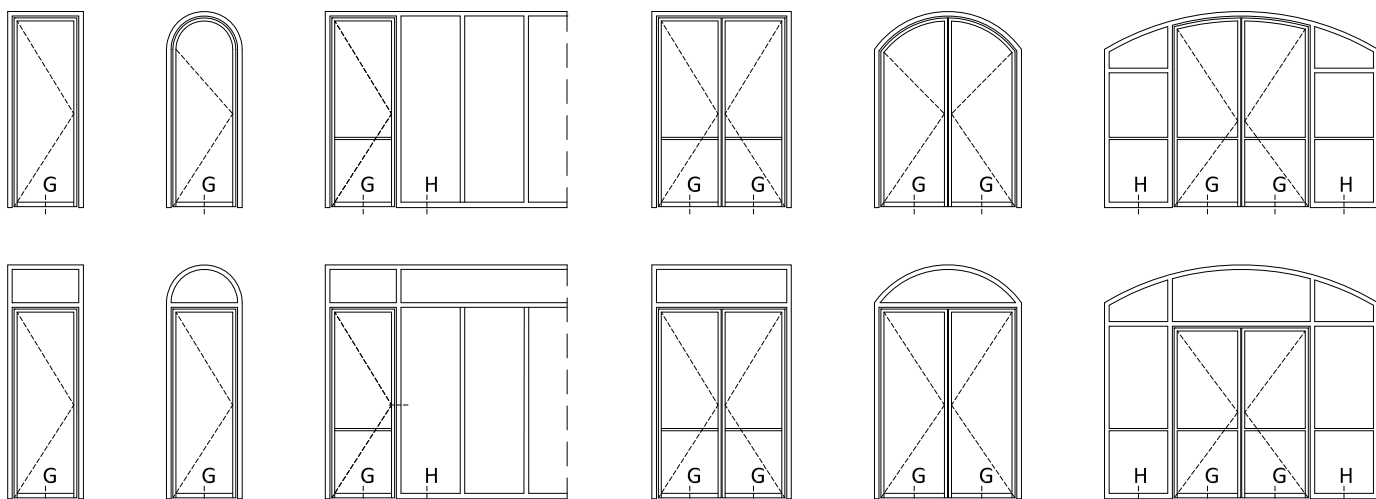


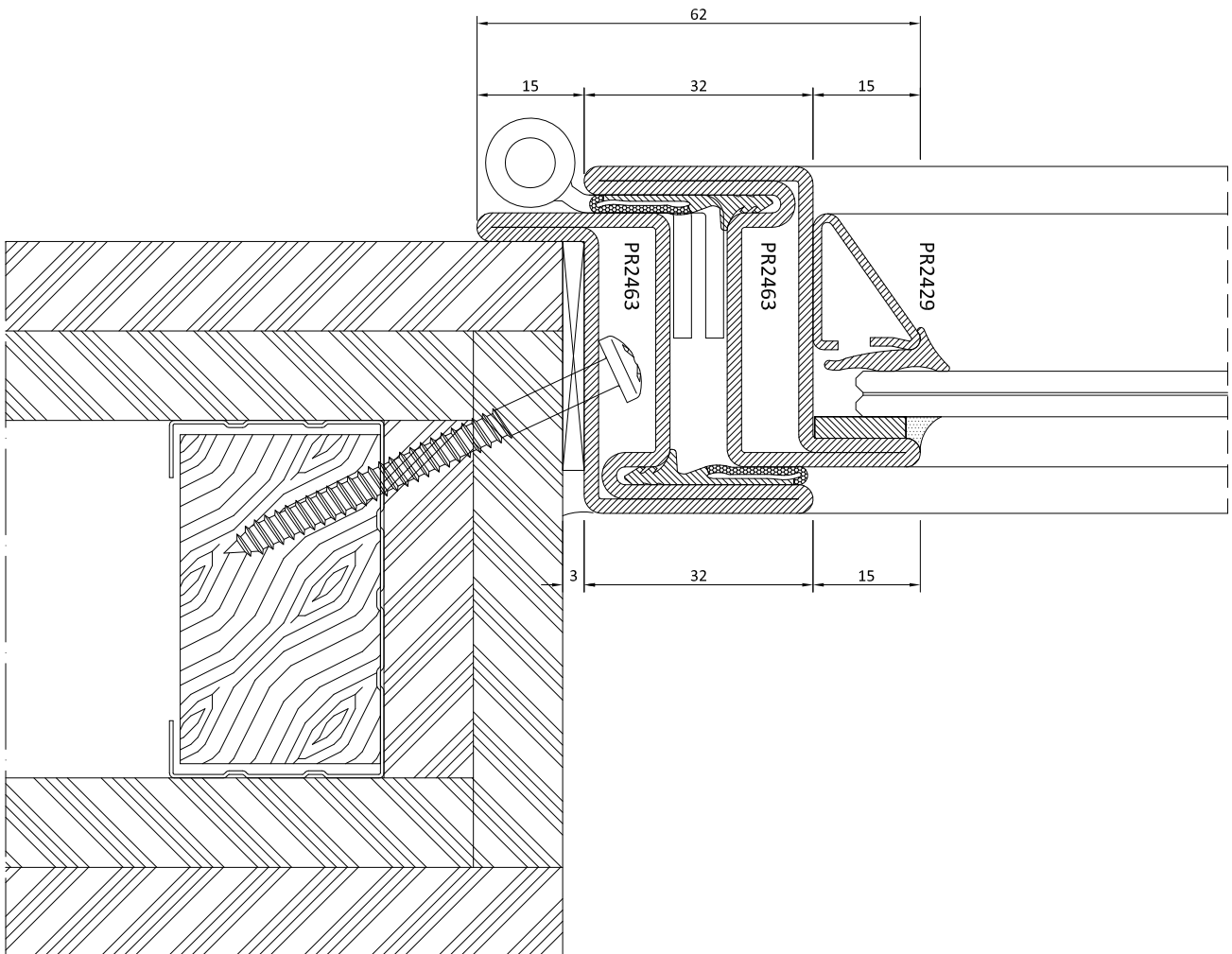
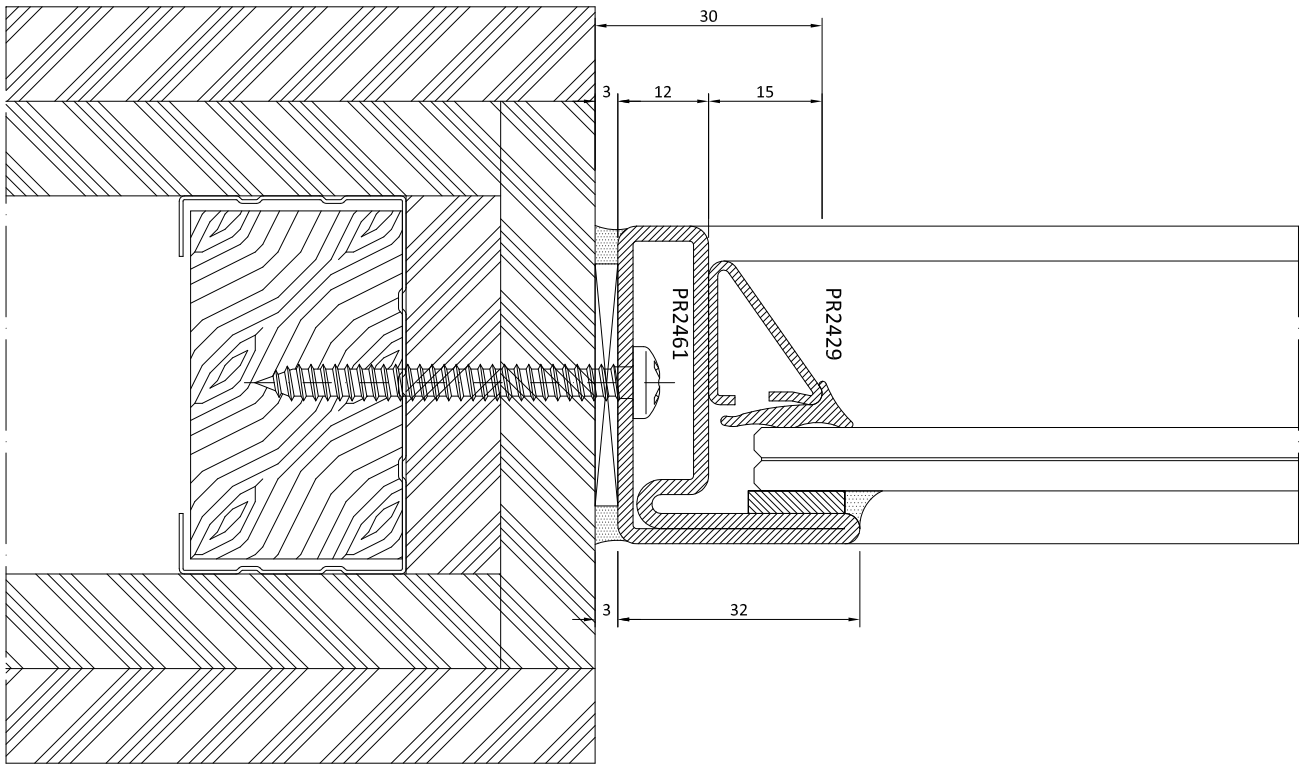


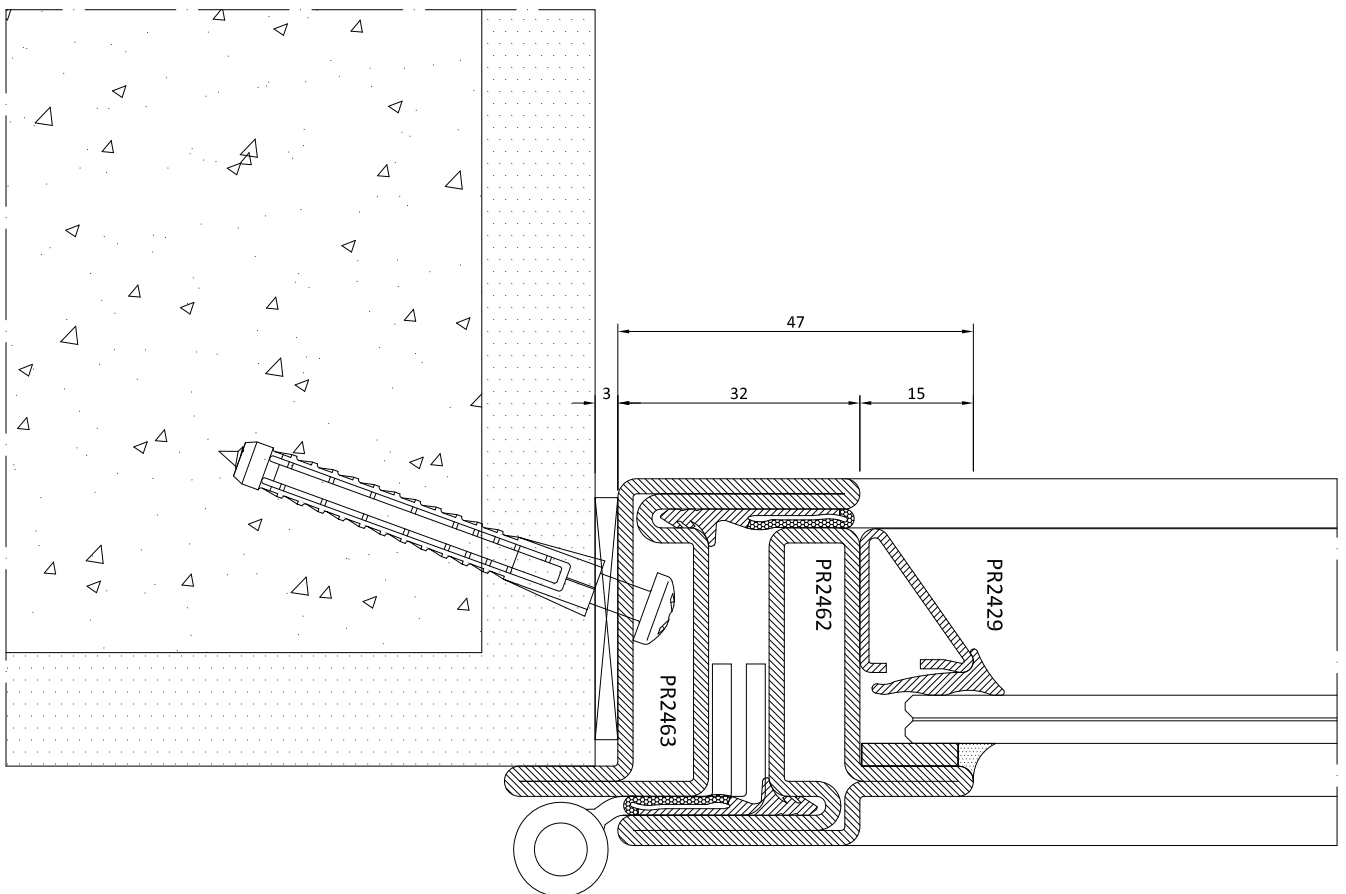
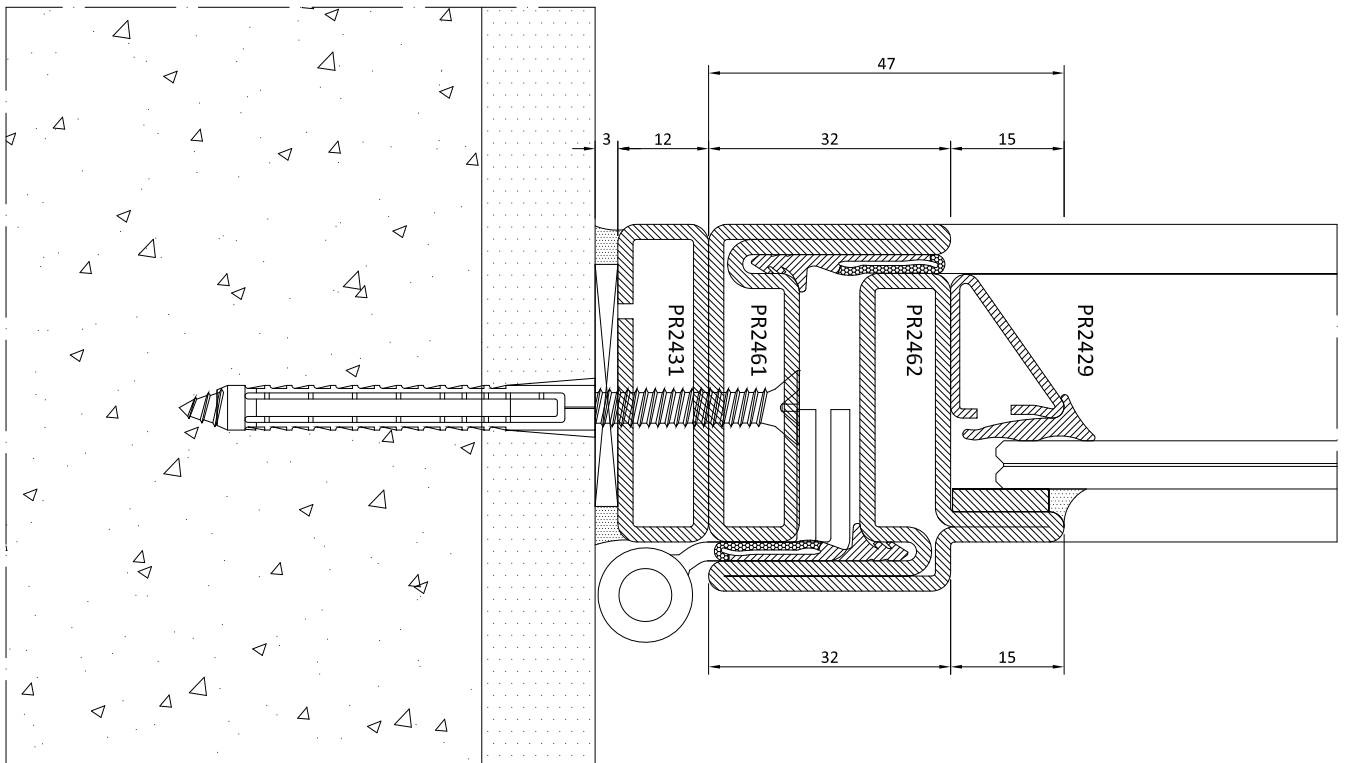


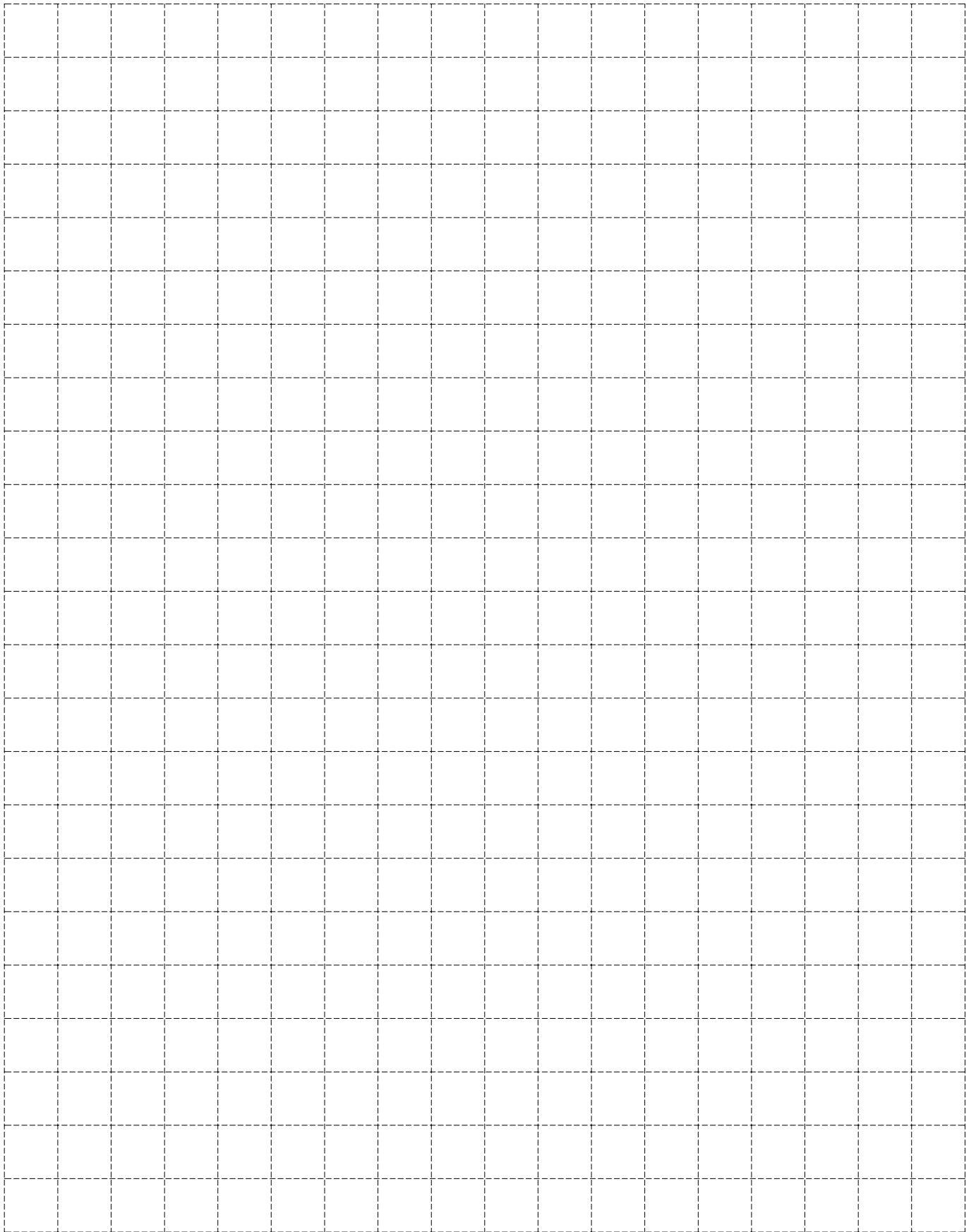


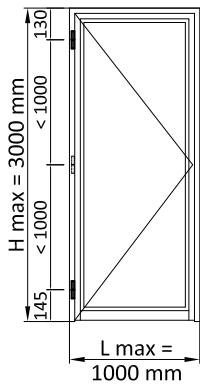








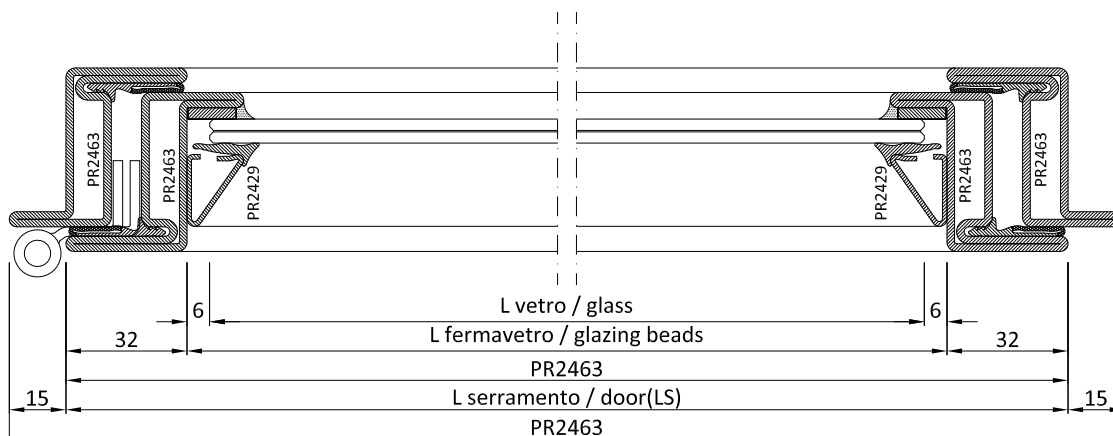
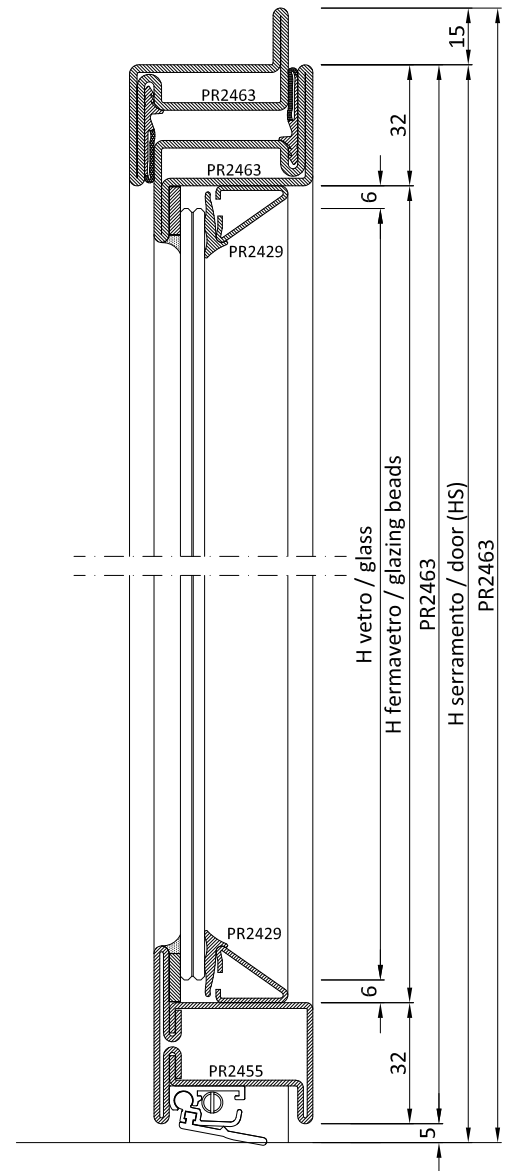


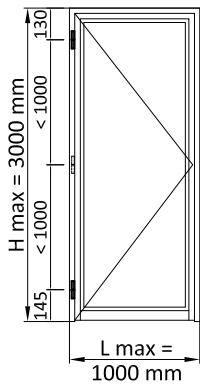


PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio					
Frame					
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta					
Leaf					
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	LS	45° 45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45° 90°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2455	Profilo Zoccolo	Socle profile	1	LS-64	90° 90°
Fermavetri					
Glazing beads					
PR2429	Profilo fermavetro	Glazing bead profile	2	LS-64	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	2	HS-69	45° 45°
Vetri					
Glass unit					
-	Vetro	Insulated glass	1	LS-76 x HS-81	

ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2436.	Guarnizione automatica	Automatic underdoor seal gasket	1
AC2494	Serratura	Lock	1
AC2496/97	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro Maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS

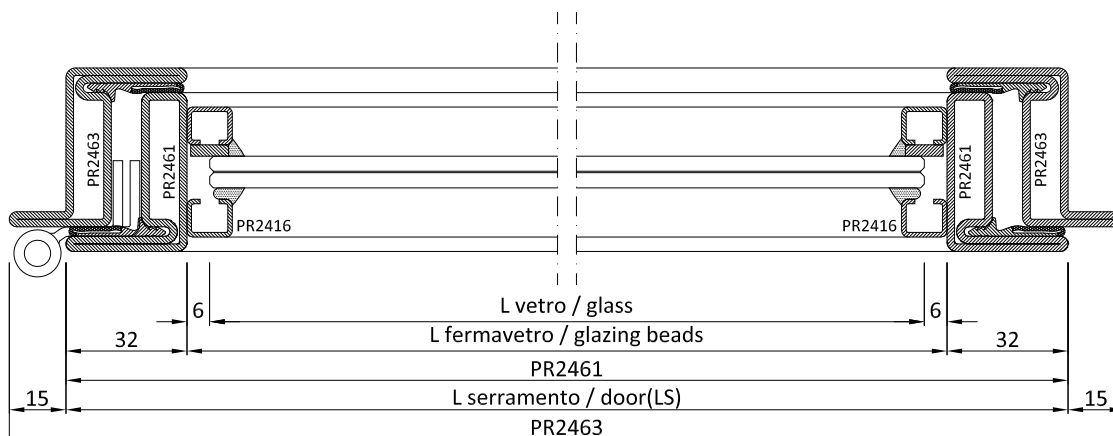
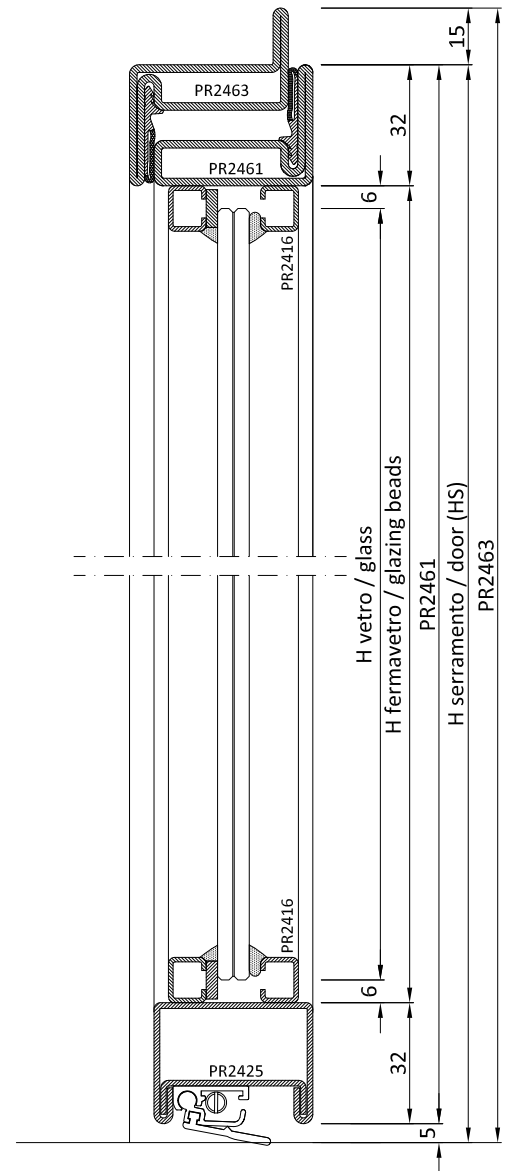


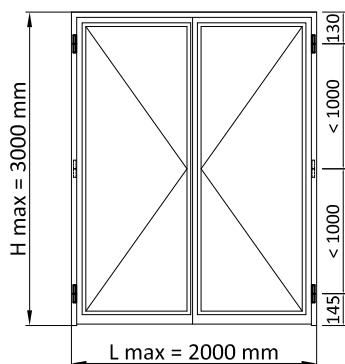


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	LS	45°	45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45°	90°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90°	45°
PR2425	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	4	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

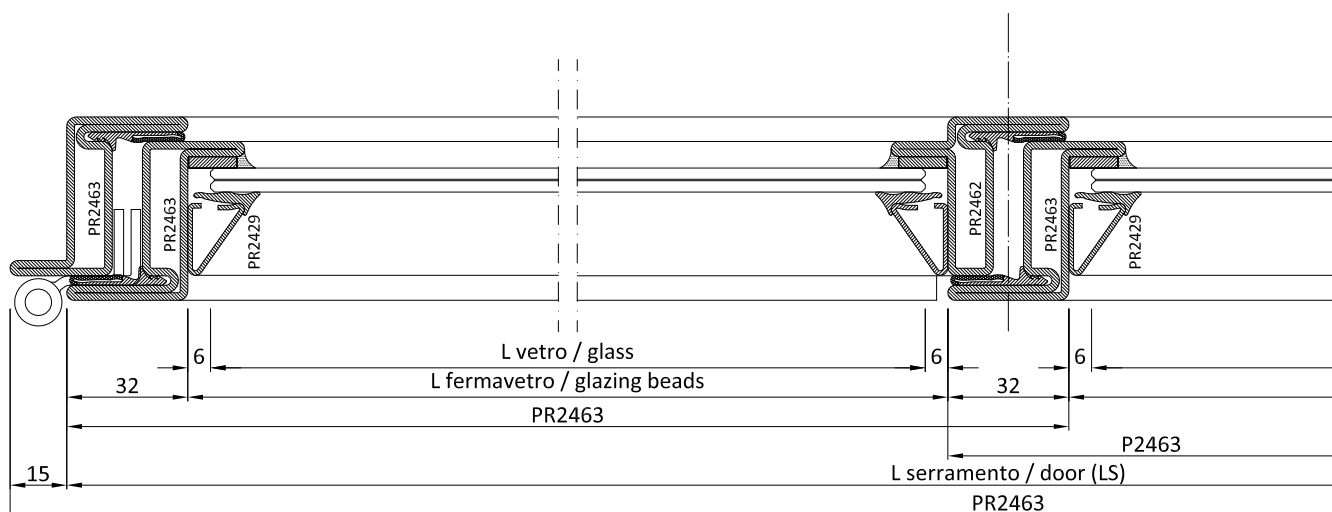
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2436.	Guarnizione automatica	Automatic underdoor seal gasket	1
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro Maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS



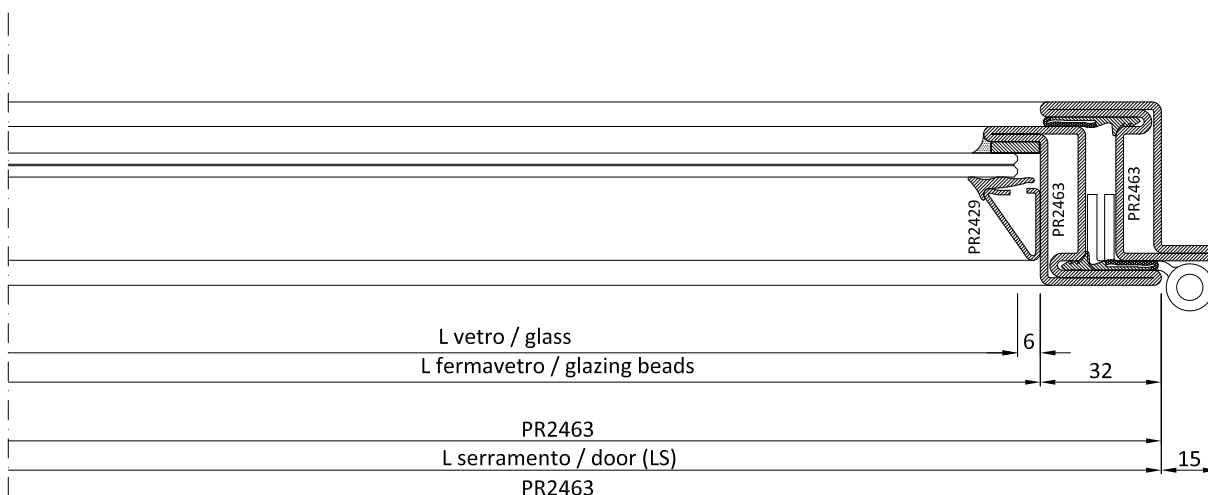
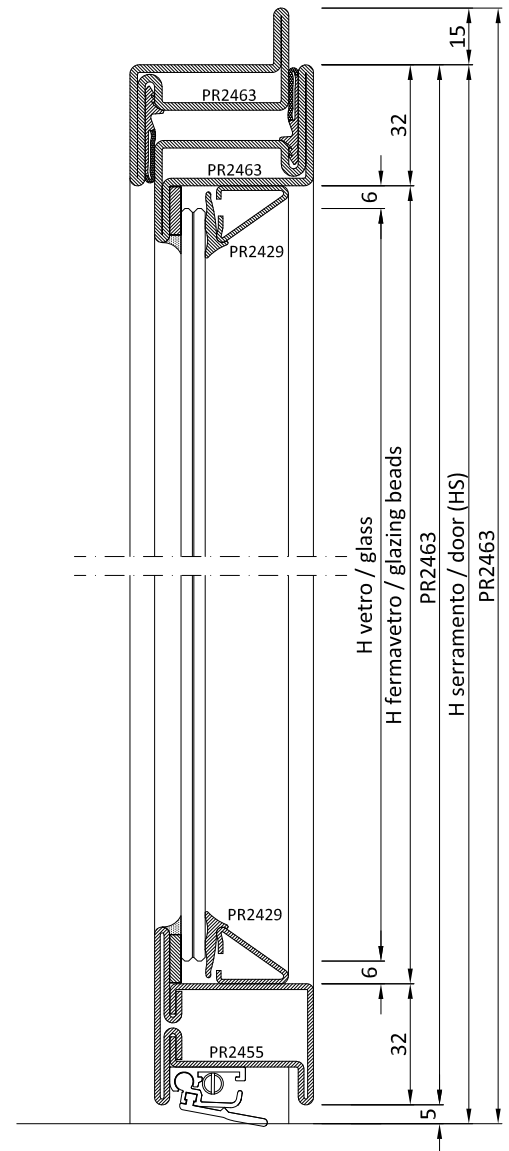


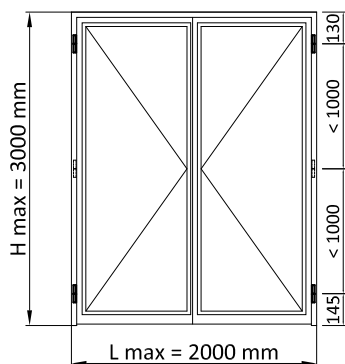
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2463	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+16	45° 45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	2	HS-5	45° 90°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	90° 45°
PR2455	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2429	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	



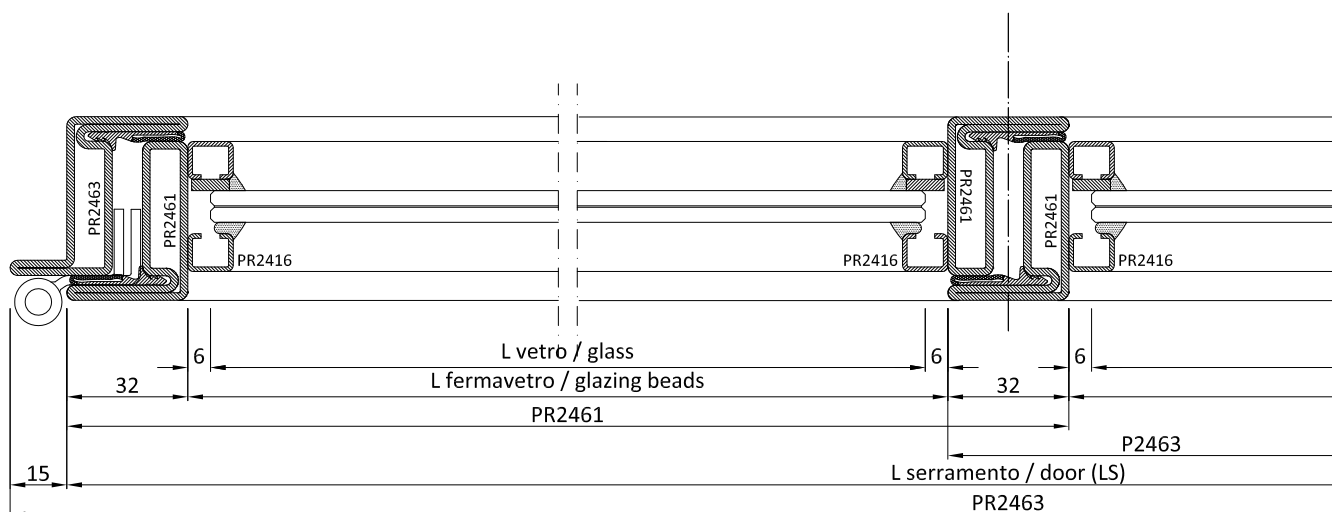
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2^ anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436.	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2^ anta	Botton plate for second leaf	2
AC2654	Fondino per zoccolo	Botton plate for socle	1
AC2494	Serratura	Lock	1
AC2496/97	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+6HS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+4xHS



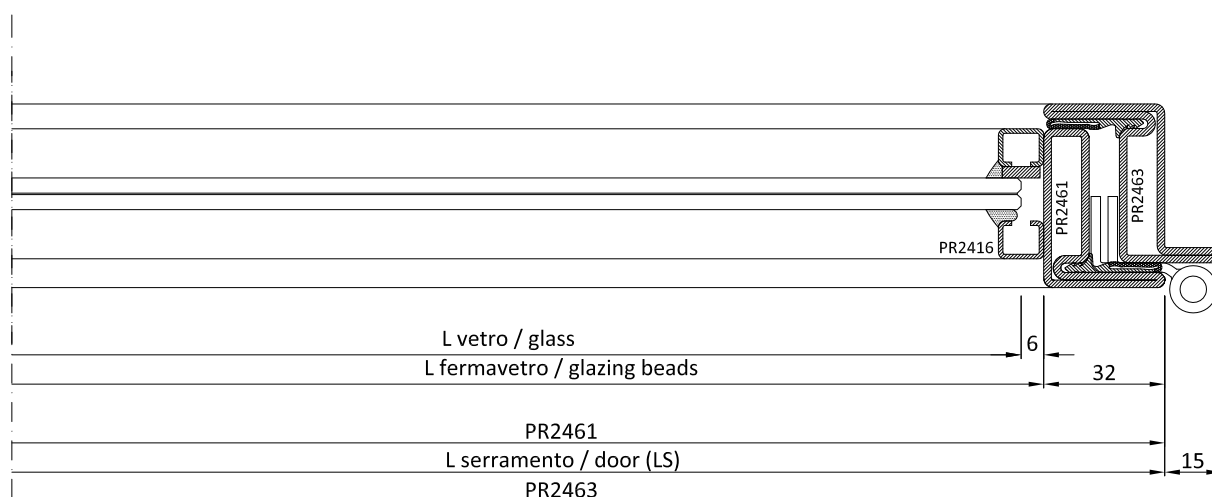
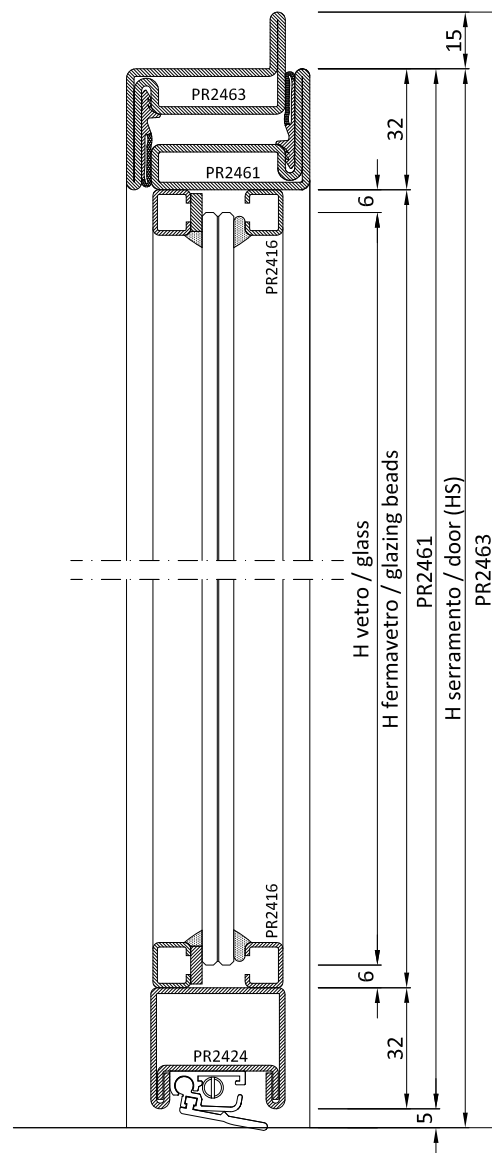


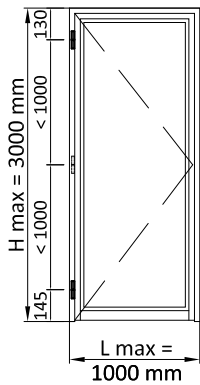
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2461	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+16	45° 45°
PR2461	Profilo a "Z" anta	"Z" profile leaf	3	HS-5	45° 90°
PR2461	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2424	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2429	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	



ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2 ^a anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436..	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2 ^a anta	Botton plate for second leaf	2
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+6HS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+4xHS

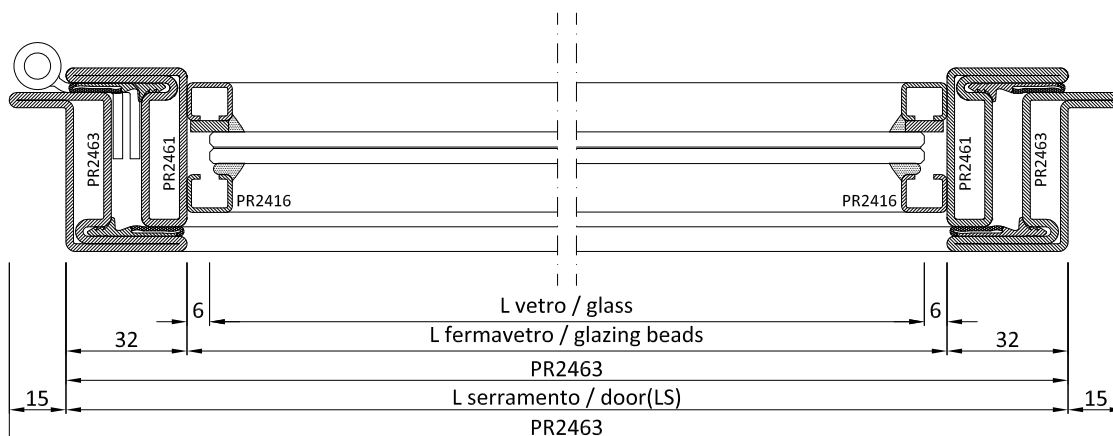
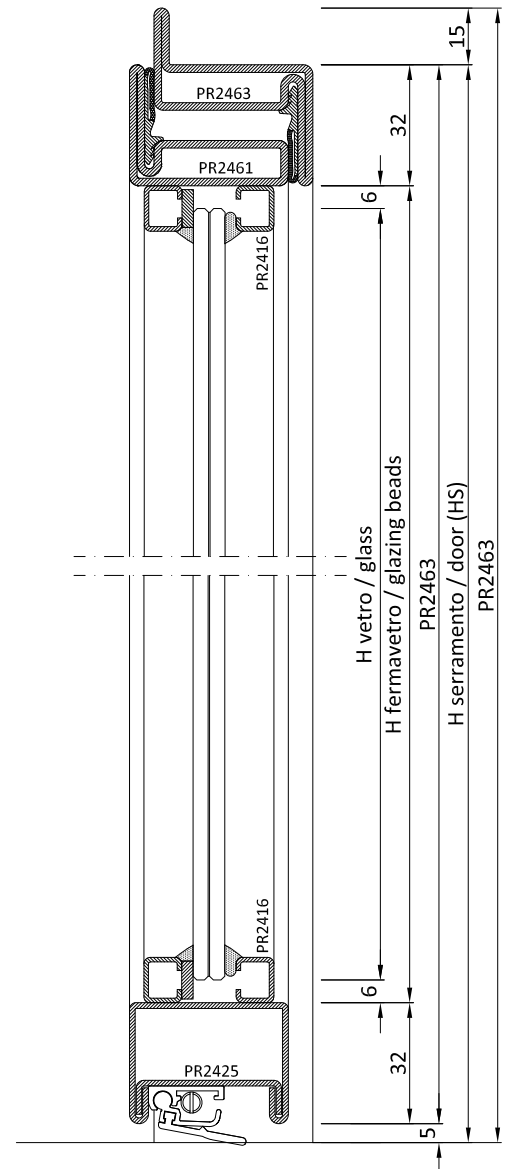


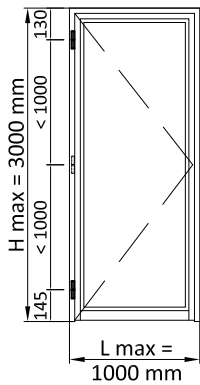


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting	
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2461	Profilo a "L" anta	"L" profile leaf	1	LS	45°	45°
PR2461	Profilo a "L" anta	"L" profile leaf	1	HS-5	45°	90°
PR2461	Profilo a "L" anta	"L" profile leaf	1	HS-5	90°	45°
PR2425	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	4	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2436.	Guarnizione automatica	Automatic underdoor seal gasket	1
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro Maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS

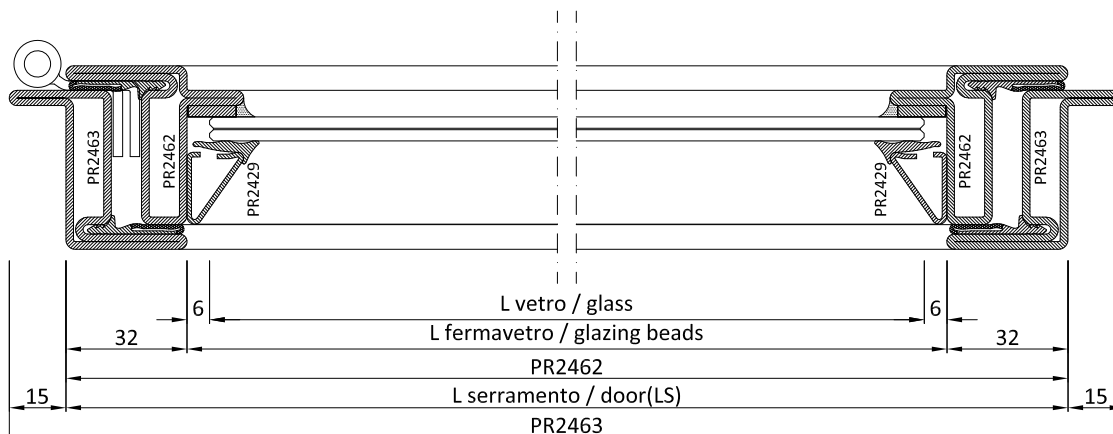
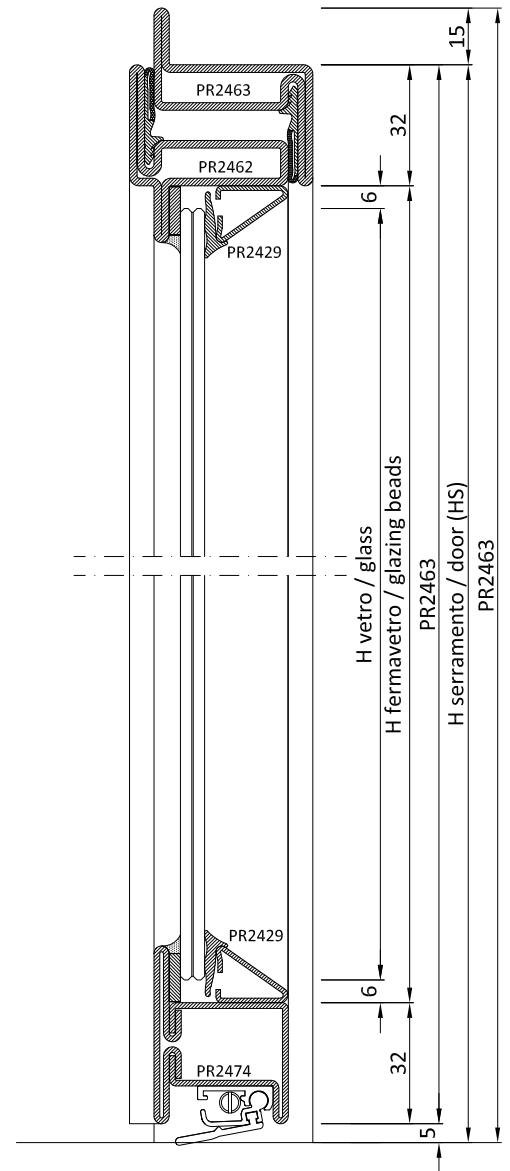


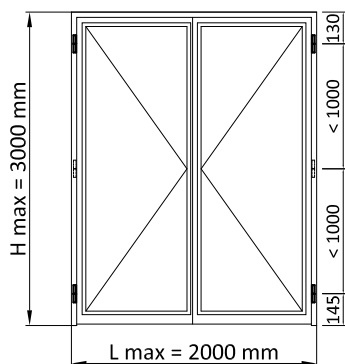


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting	
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2462	Profilo a "T" anta	"T" profile leaf	1	LS	45°	45°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	45°	90°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	90°	45°
PR2474	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

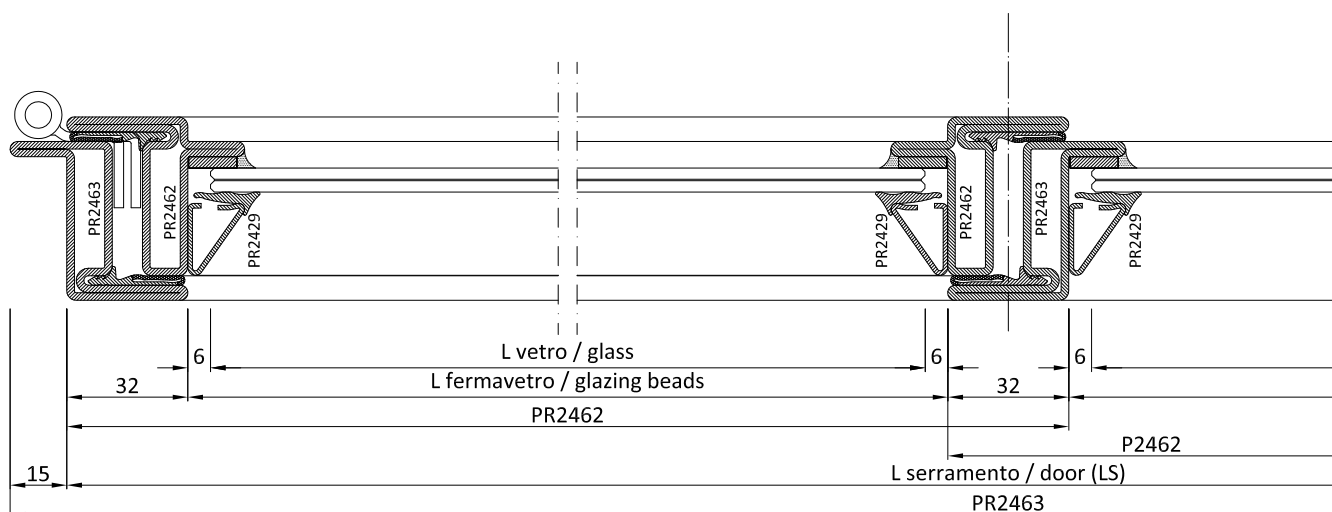
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2436.	Guarnizione automatica	Automatic underdoor seal gasket	1
AC2494	Serratura	Lock	1
AC2496/97	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro Maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS



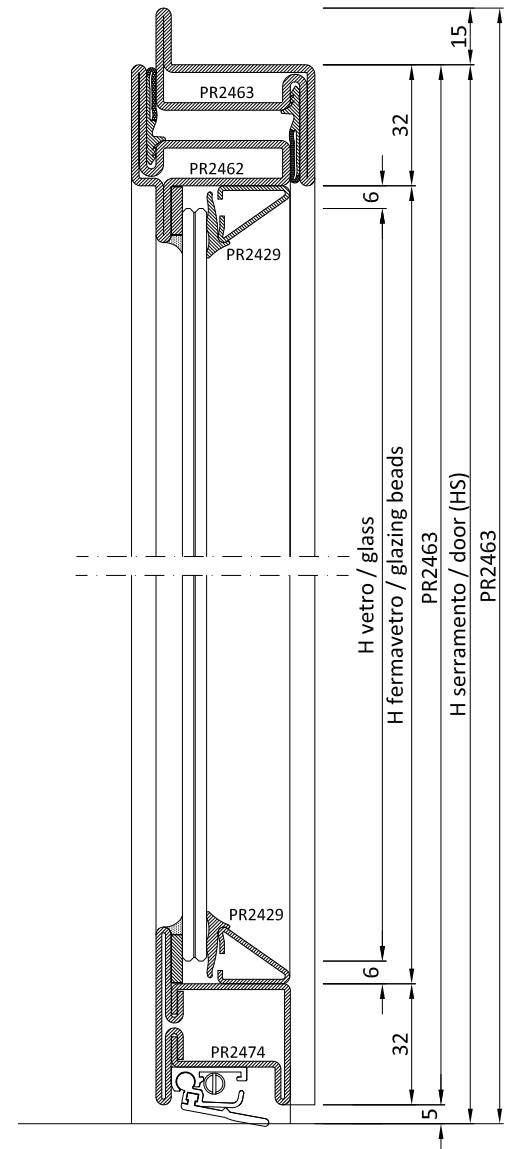


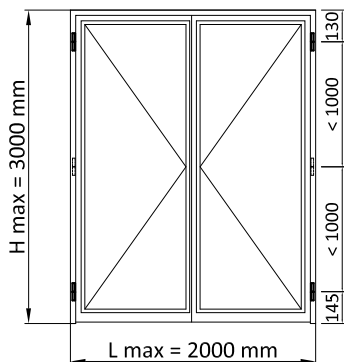
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2462	Profilo a "T" anta	"T" profile leaf	2	LS/2+16	45° 45°
PR2462	Profilo a "T" anta	"T" profile leaf	2	HS-5	45° 90°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	90° 45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2474	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2429	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	



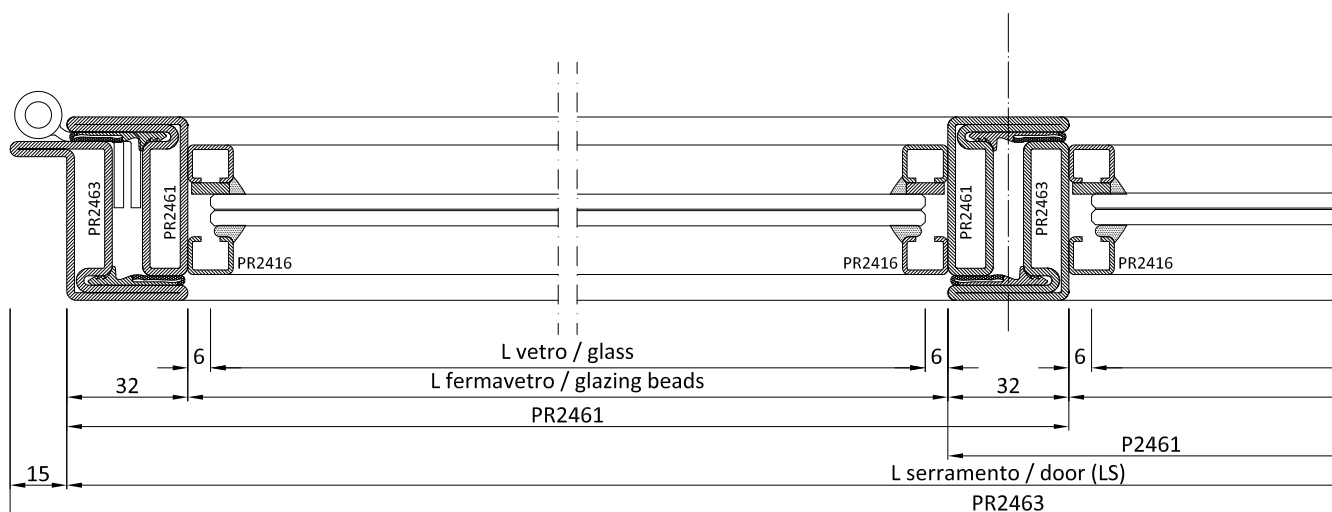
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2 ^a anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436..	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2 ^a anta	Bottom plate for second leaf	2
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+6HS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS



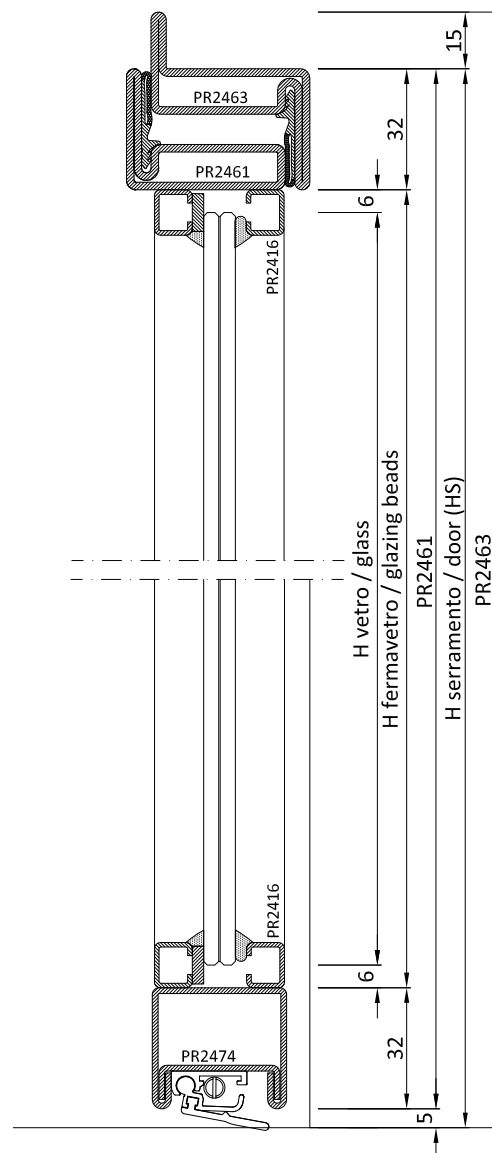


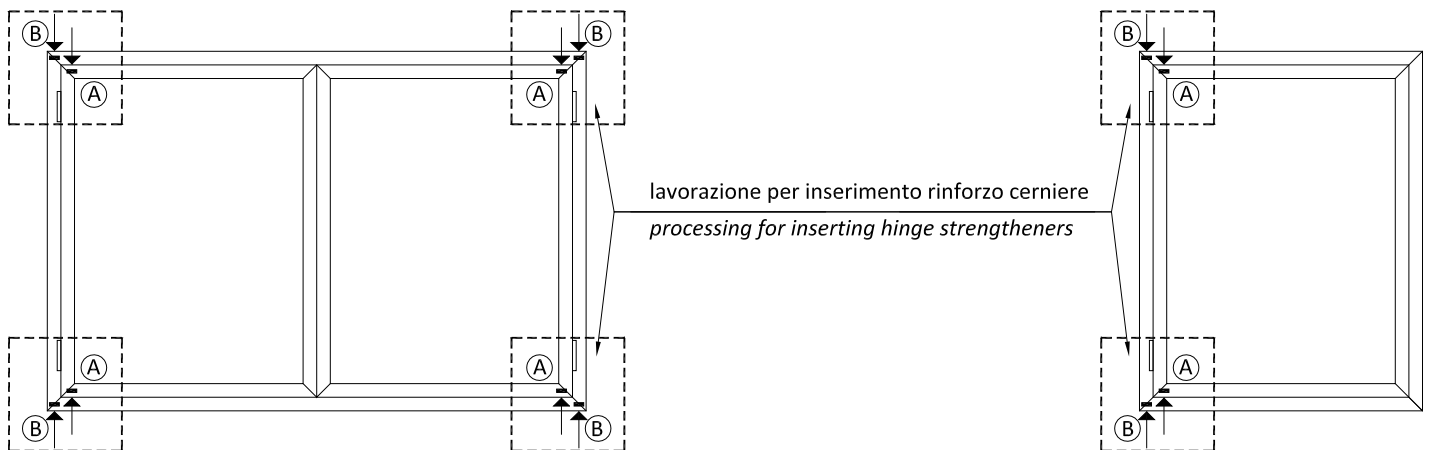
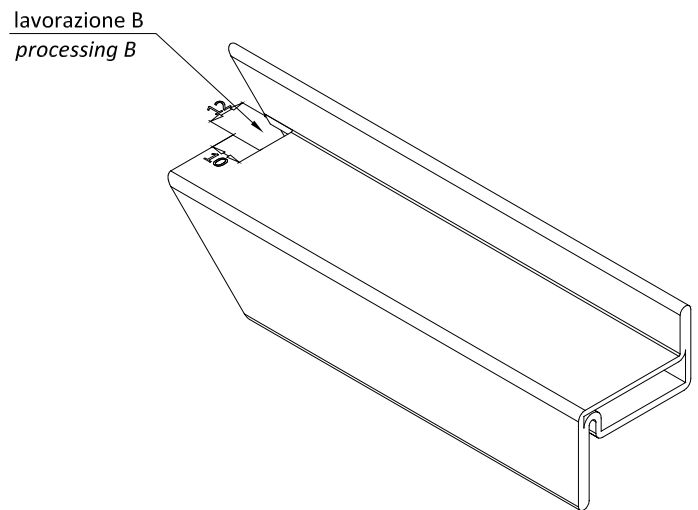
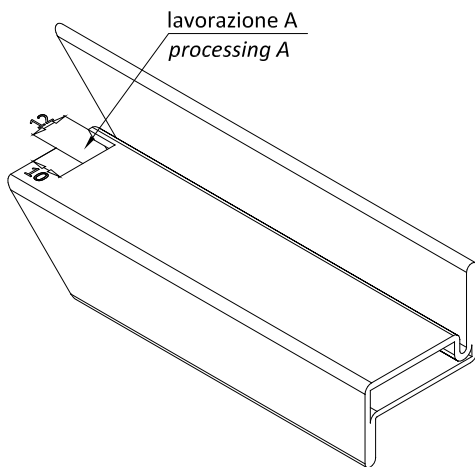
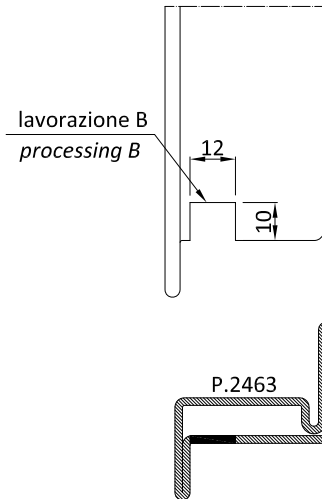
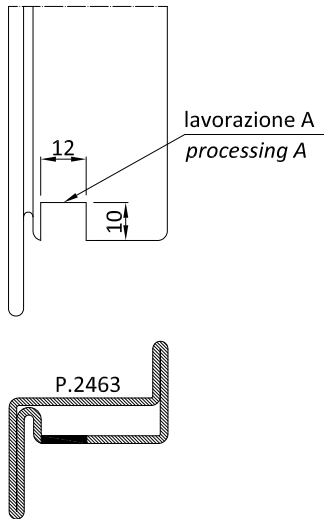
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2461	Profilo a "L" anta	"L" profile leaf	2	LS/2+16	45° 45°
PR2461	Profilo a "L" anta	"L" profile leaf	3	HS-5	45° 90°
PR2461	Profilo a "L" anta	"L" profile leaf	1	HS-5	90° 45°
PR2474	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2416	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2416	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	

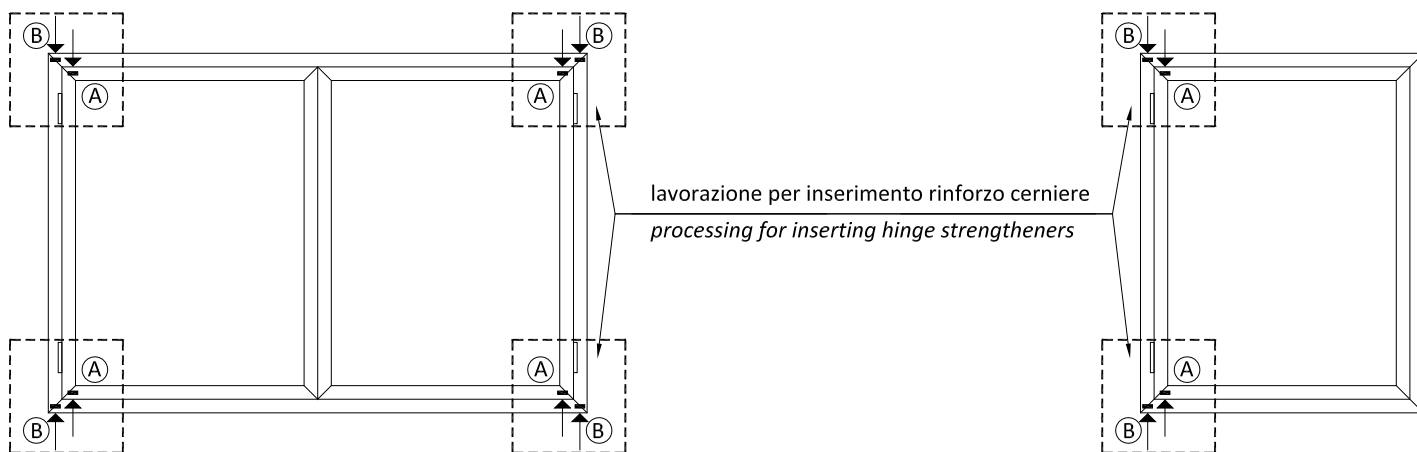
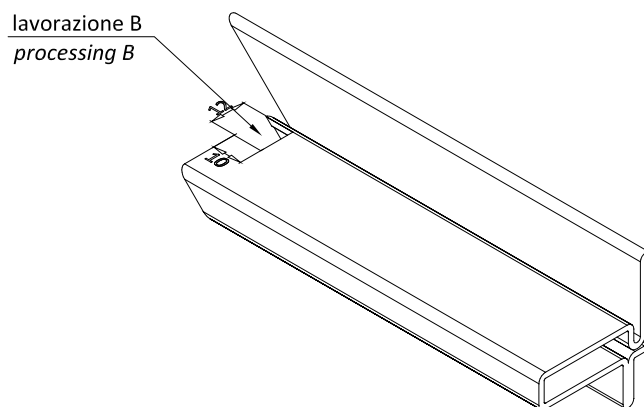
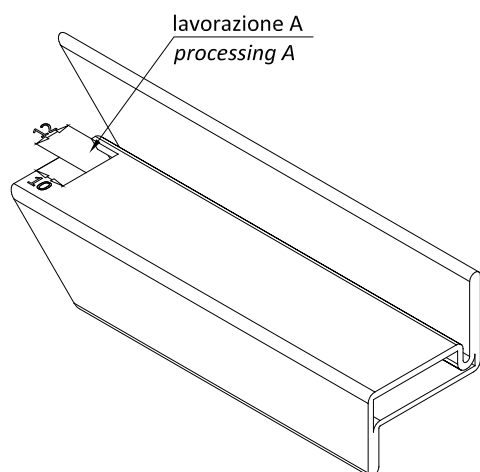
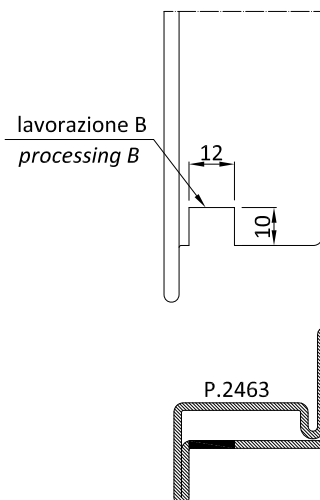
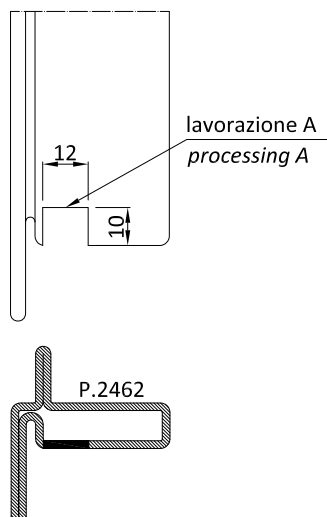


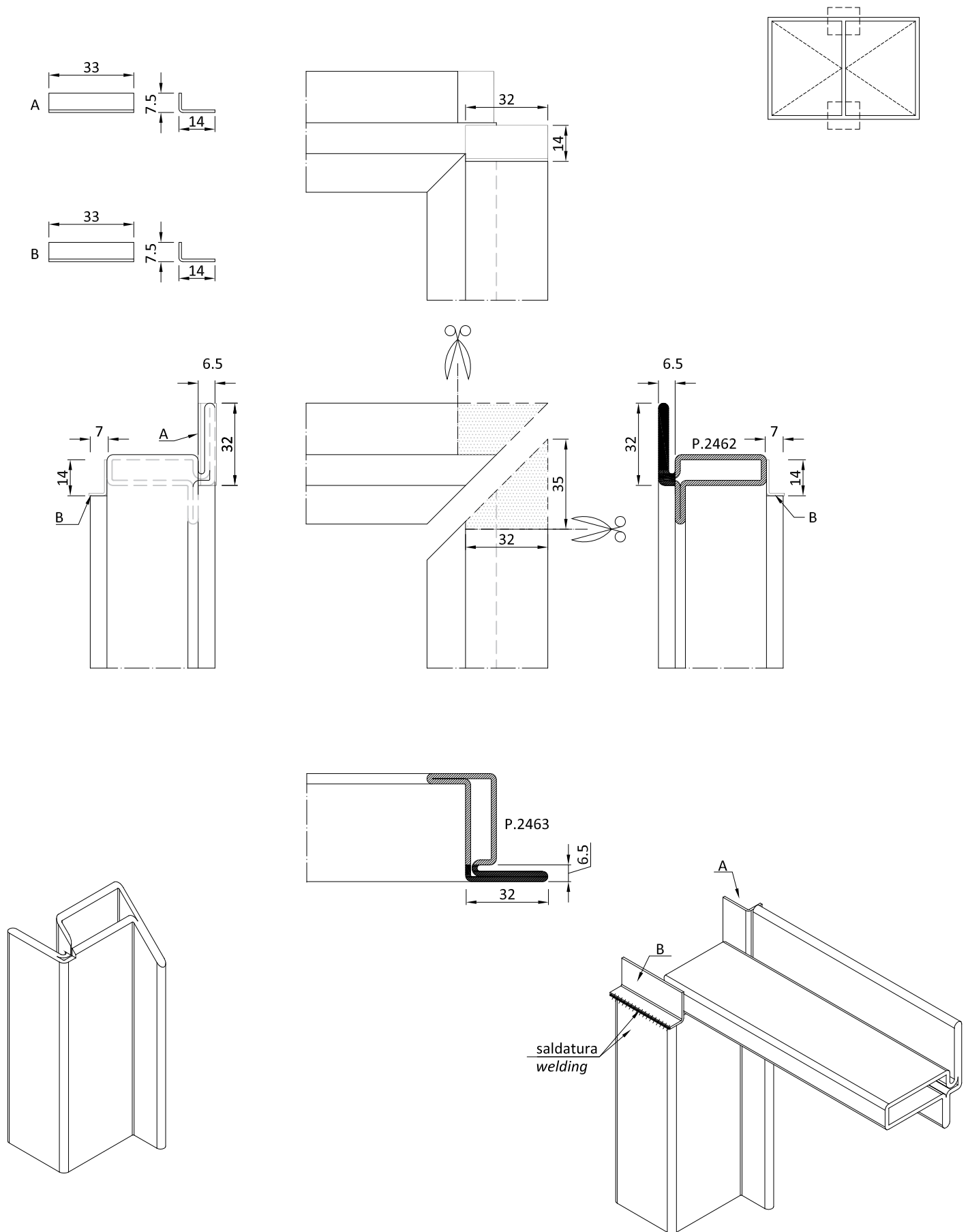
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
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GUARNIZIONI		GASKETS		
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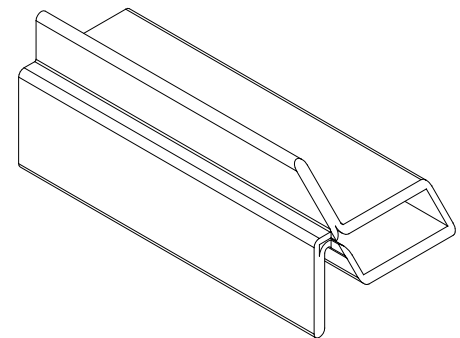
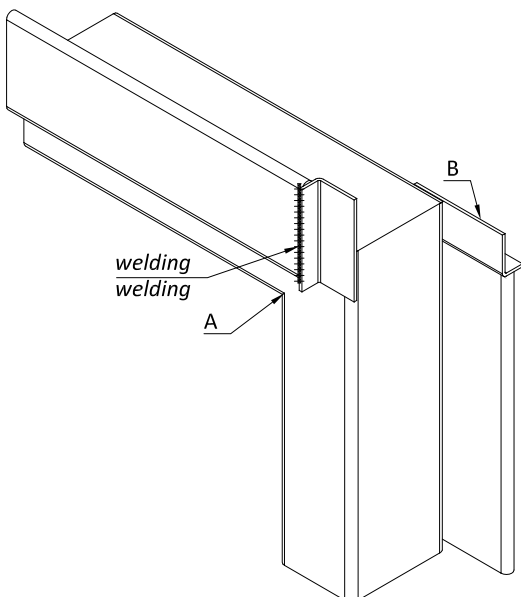
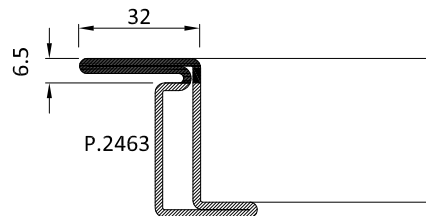
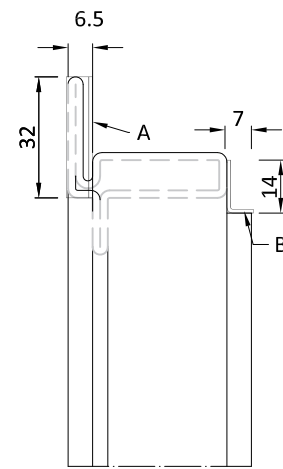
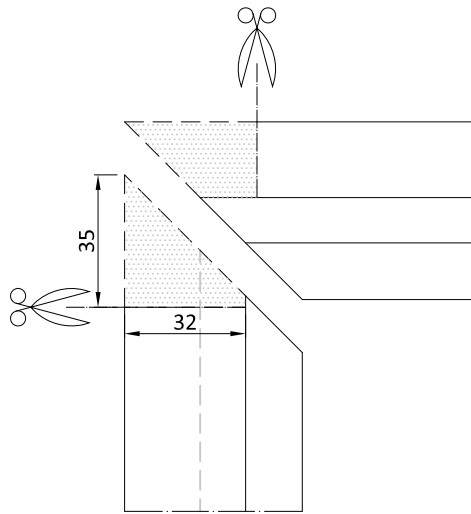
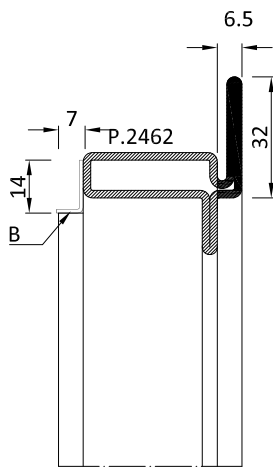
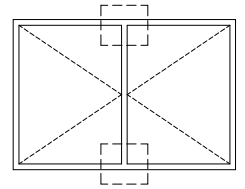
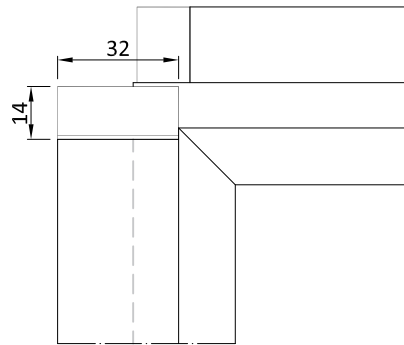
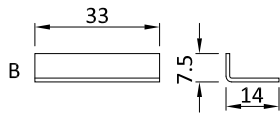
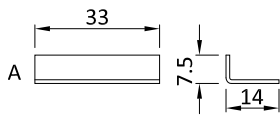




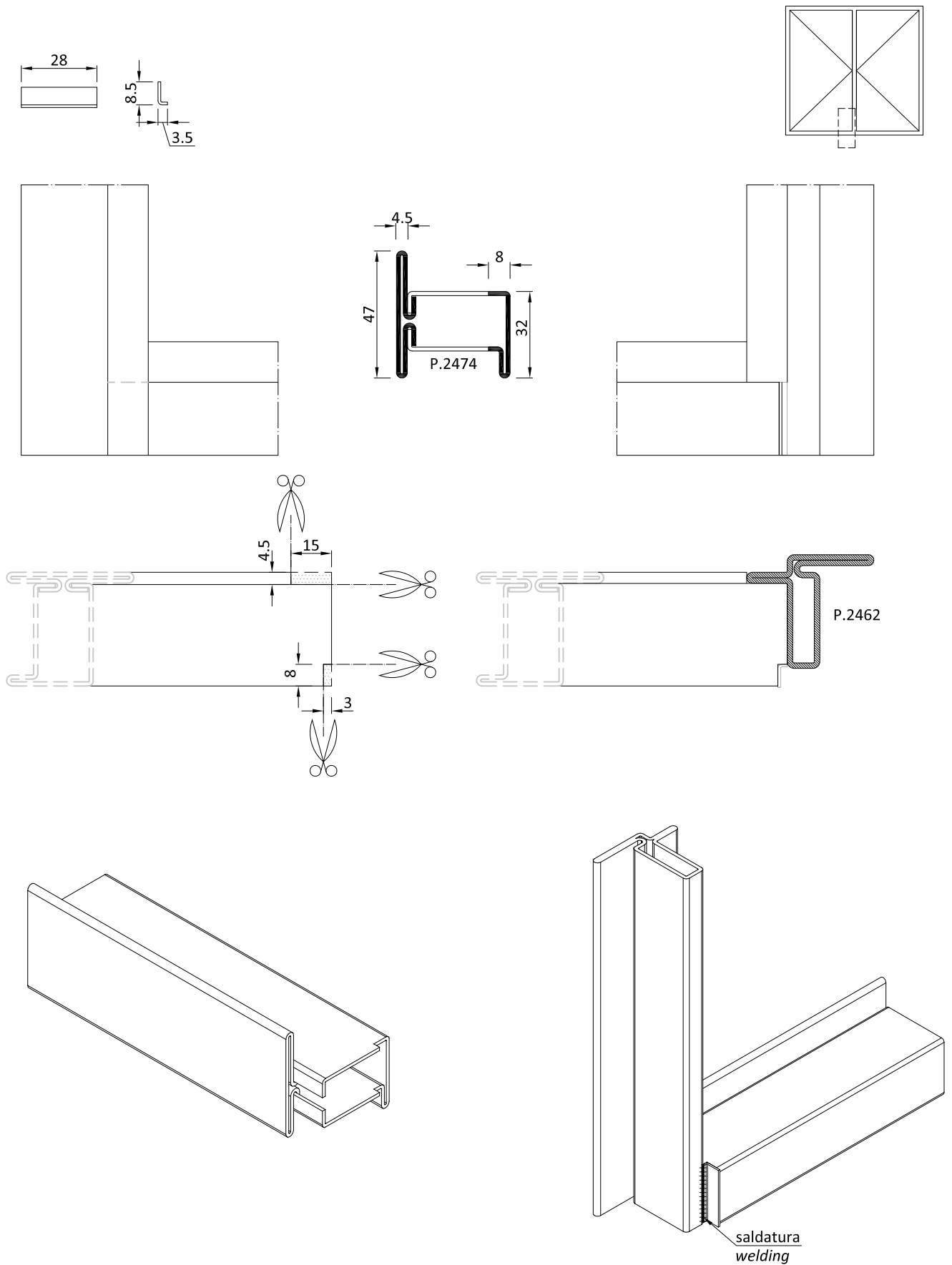




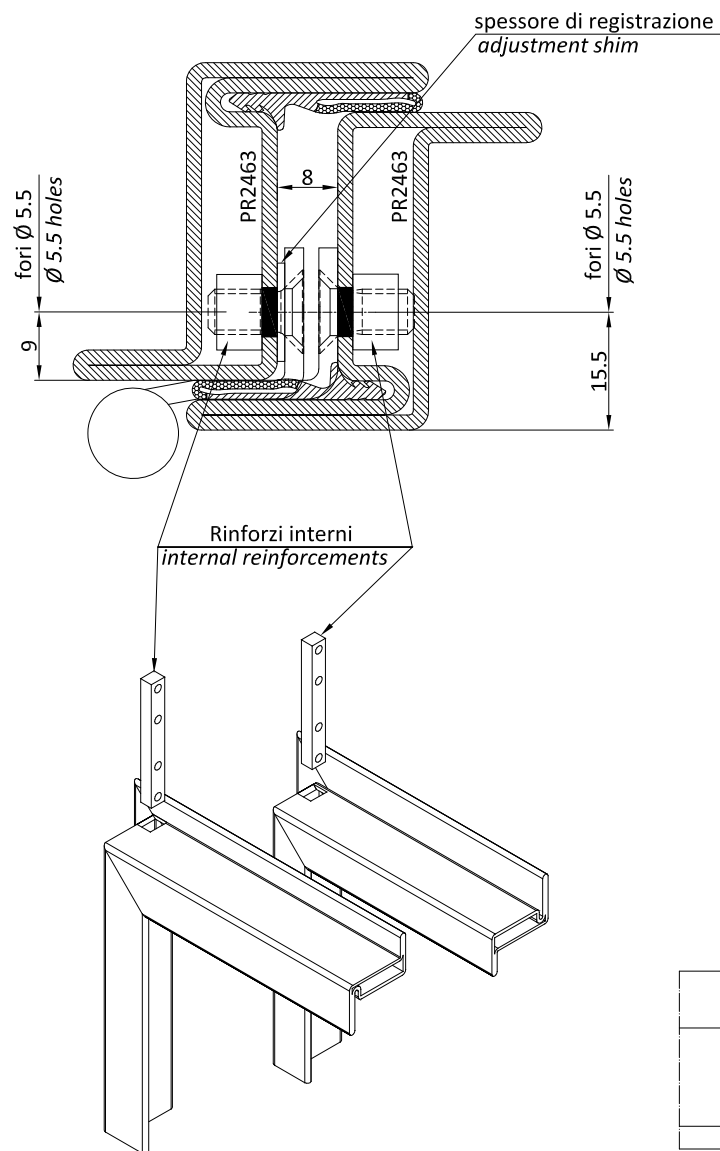
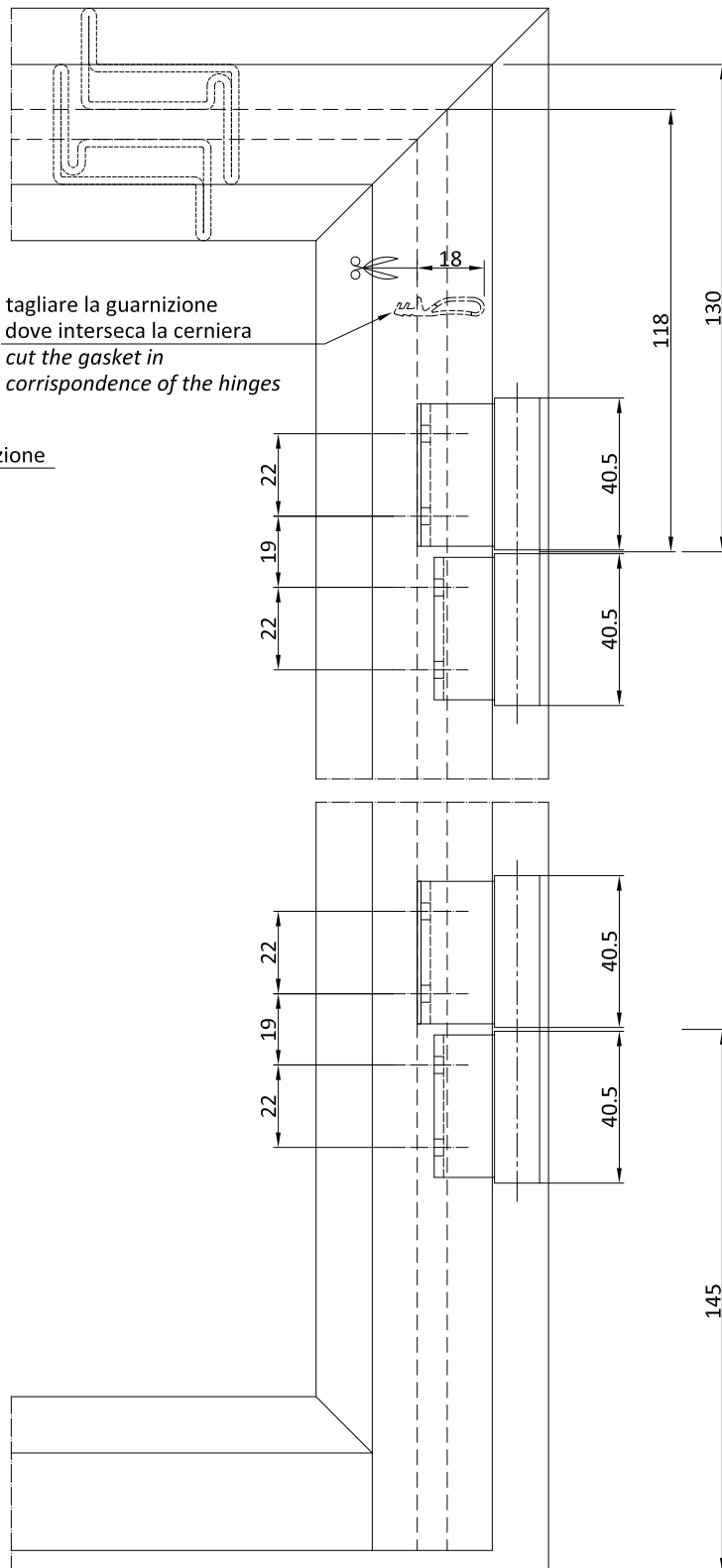
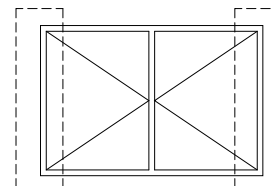
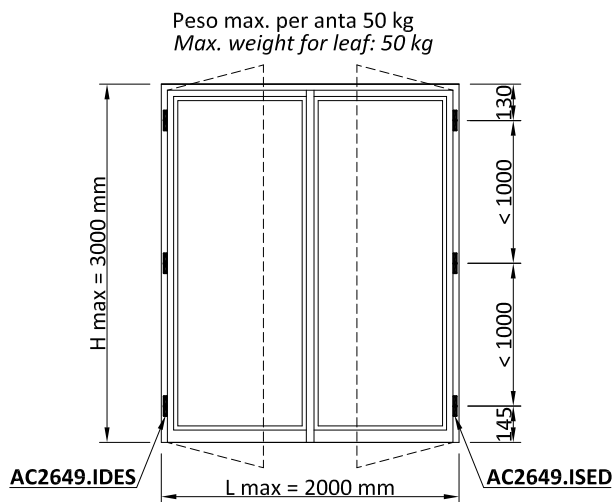
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fittings are provided larger by trimming after welding



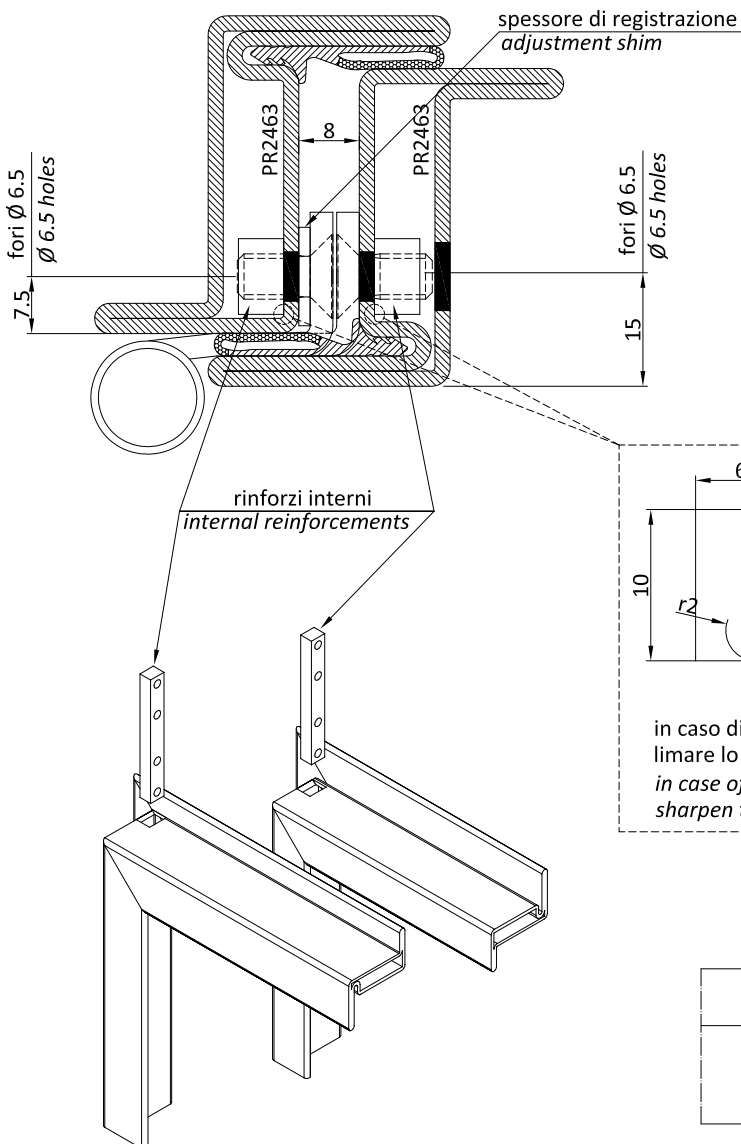
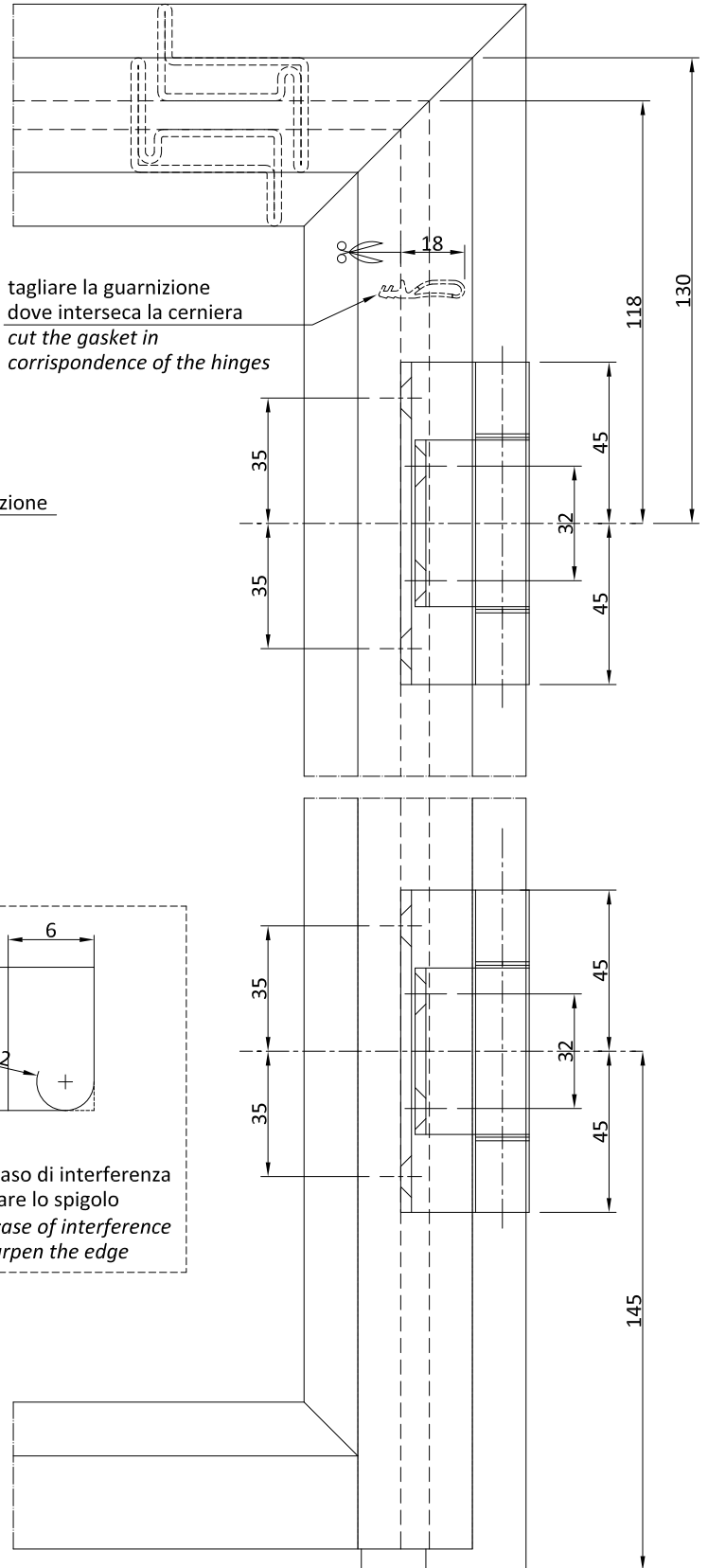
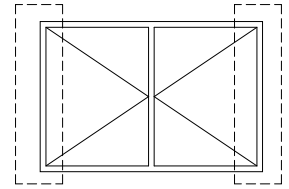
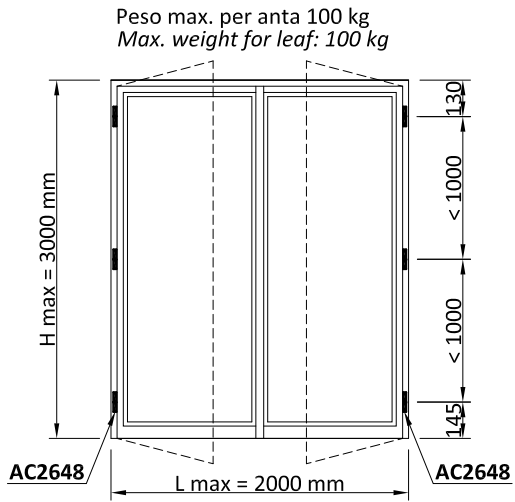
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
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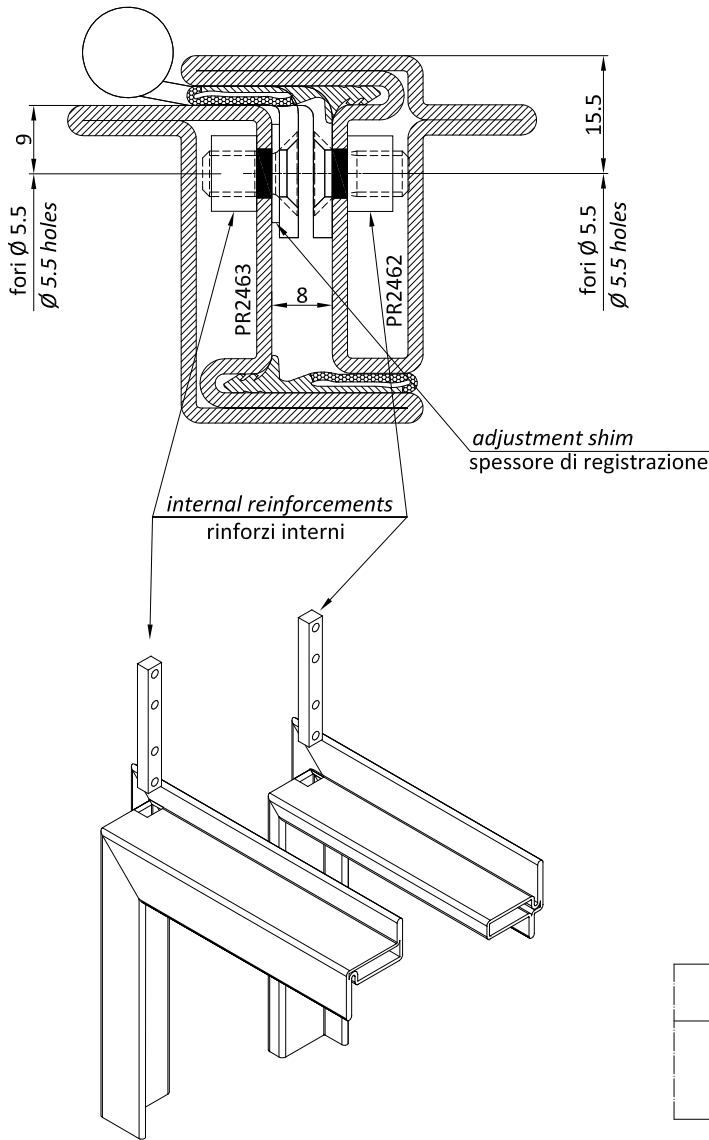
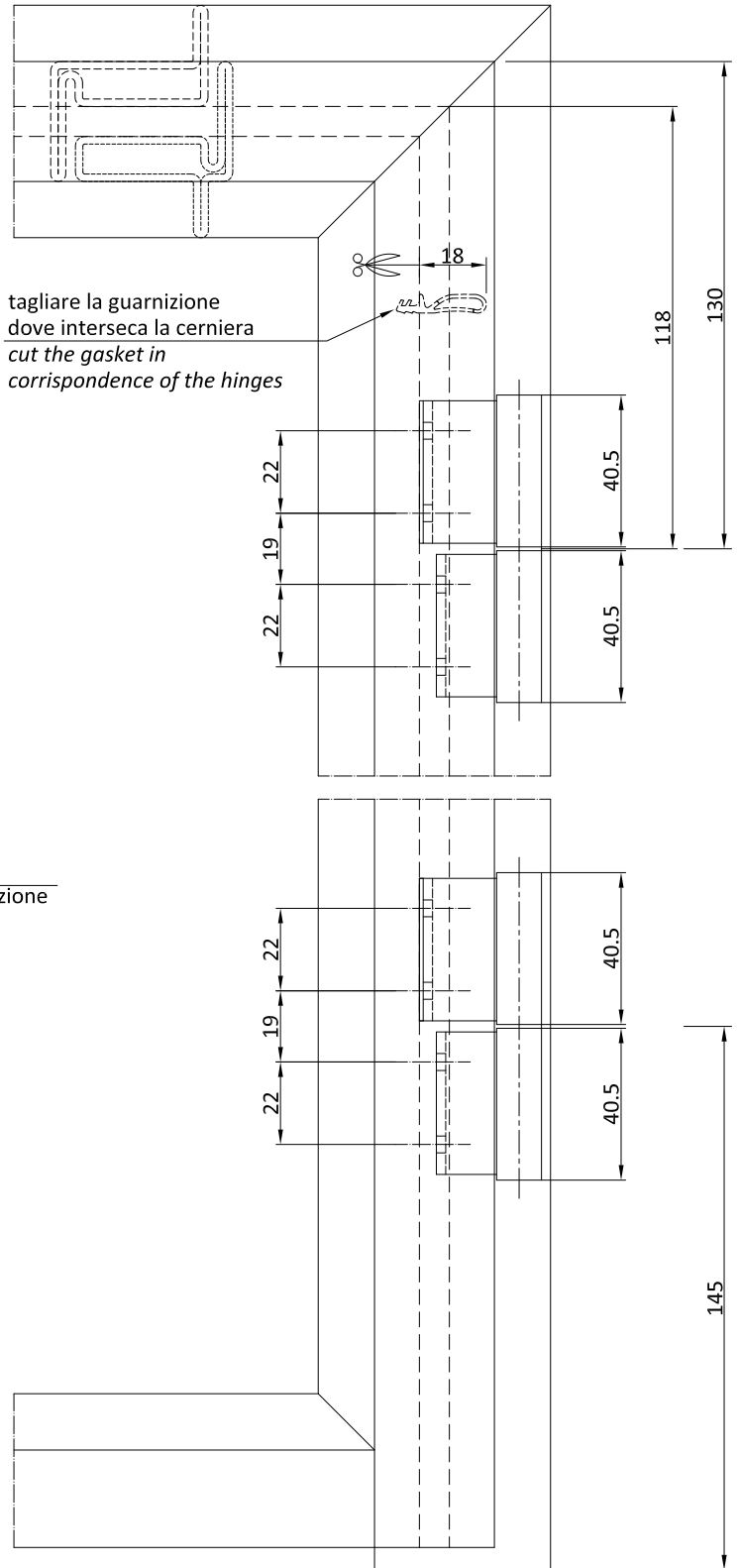
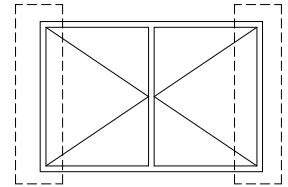
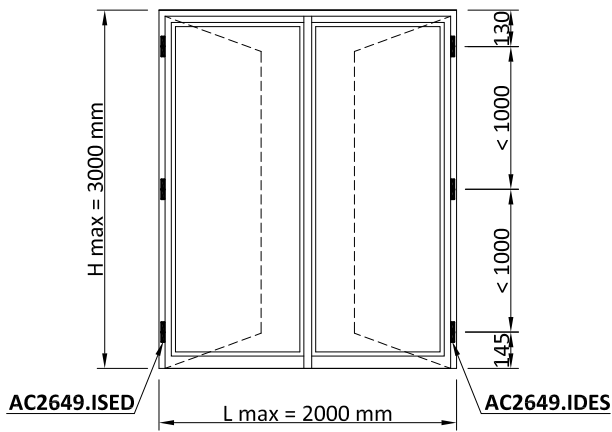
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fittings are provided larger by trimming after welding



Per l'applicazione delle cerniere AC2649 utilizzare maschera AT2629
For the installation of hinges AC2649 please use the jig AT2629



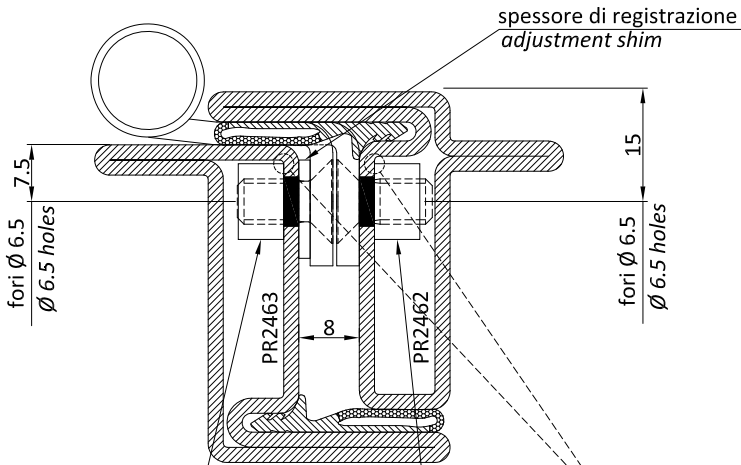
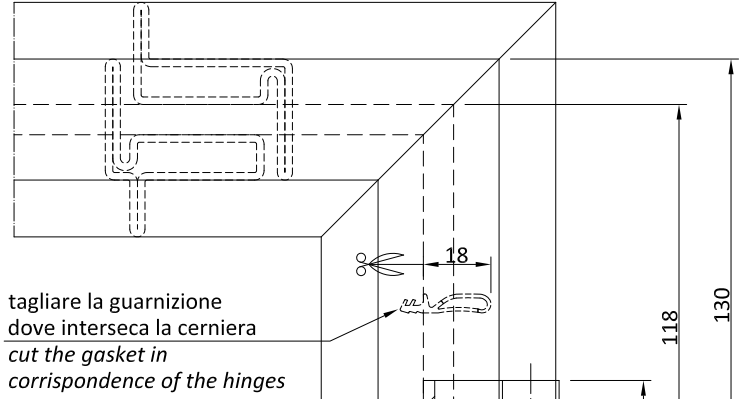
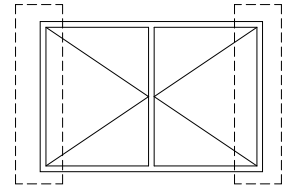
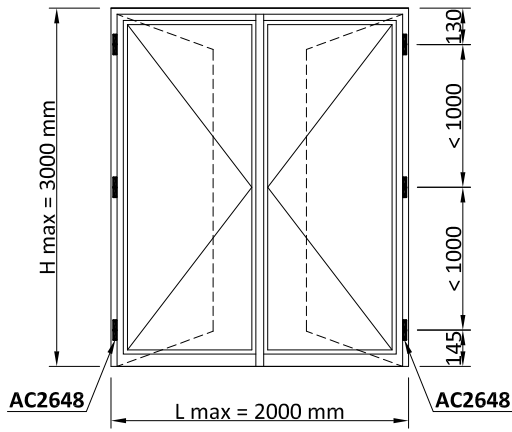
Peso max. per anta 50 kg
Max. weight for leaf: 50 kg



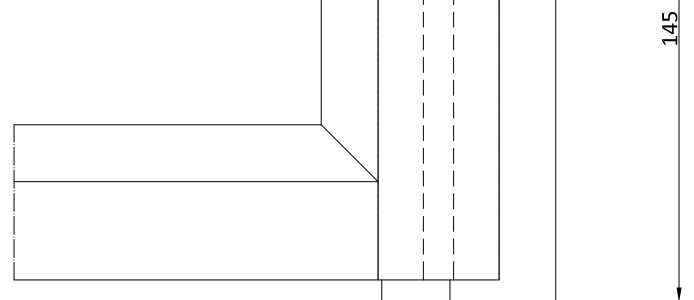
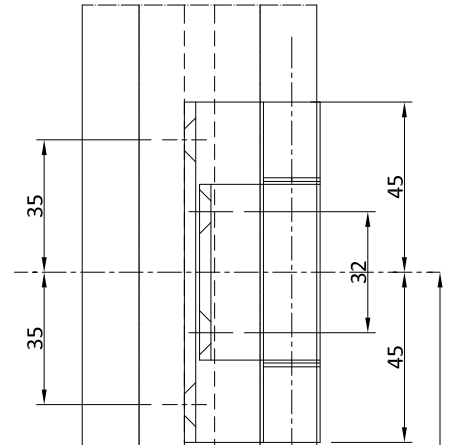
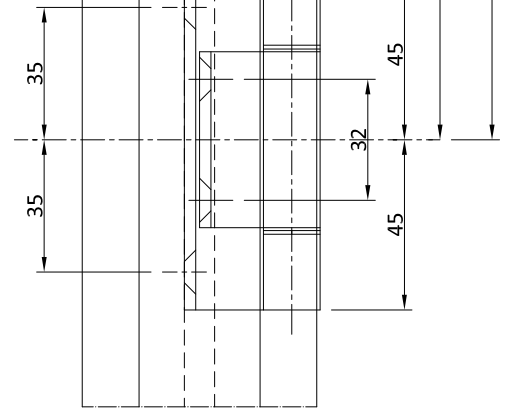
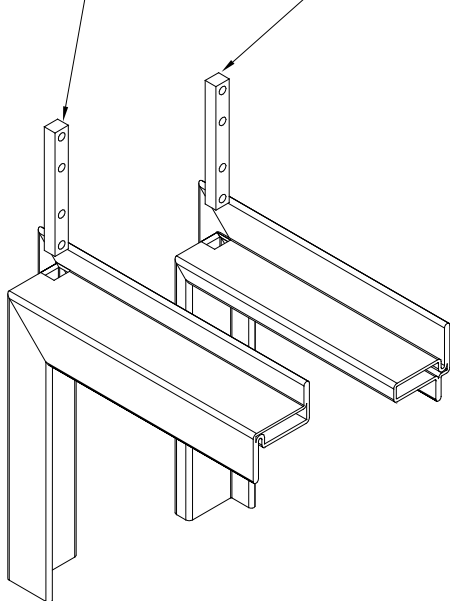
Per l'applicazione delle cerniere AC2649 utilizzare maschera AT2629
For the installation of hinges AC2649 please use the jig AT2629

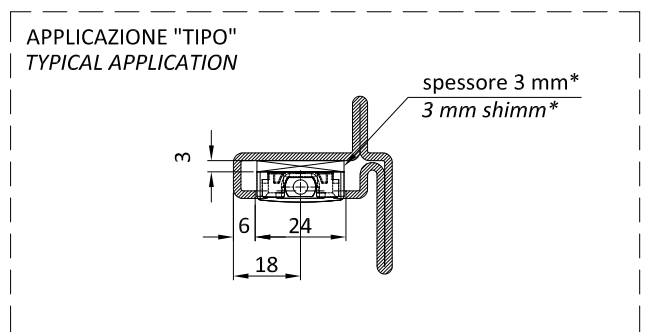
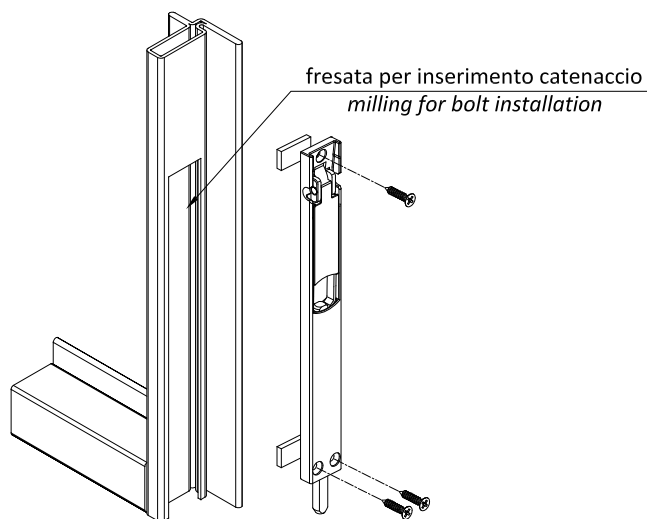
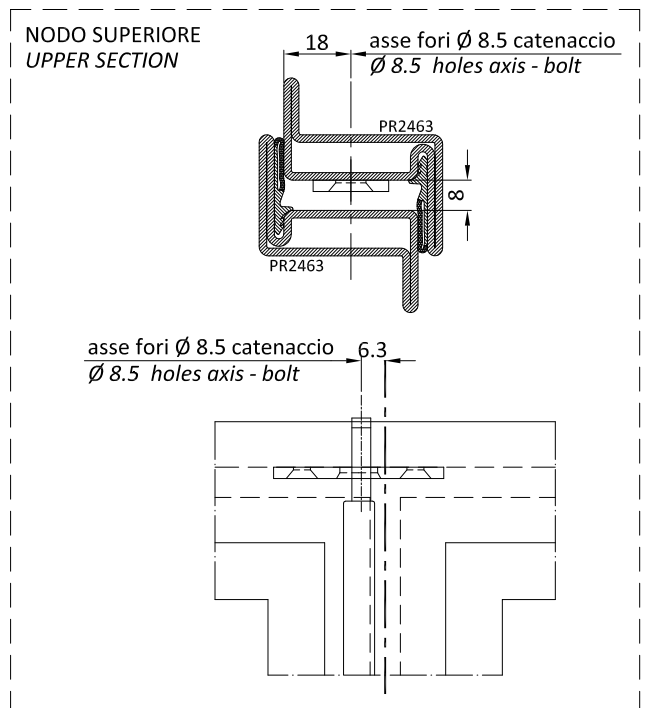
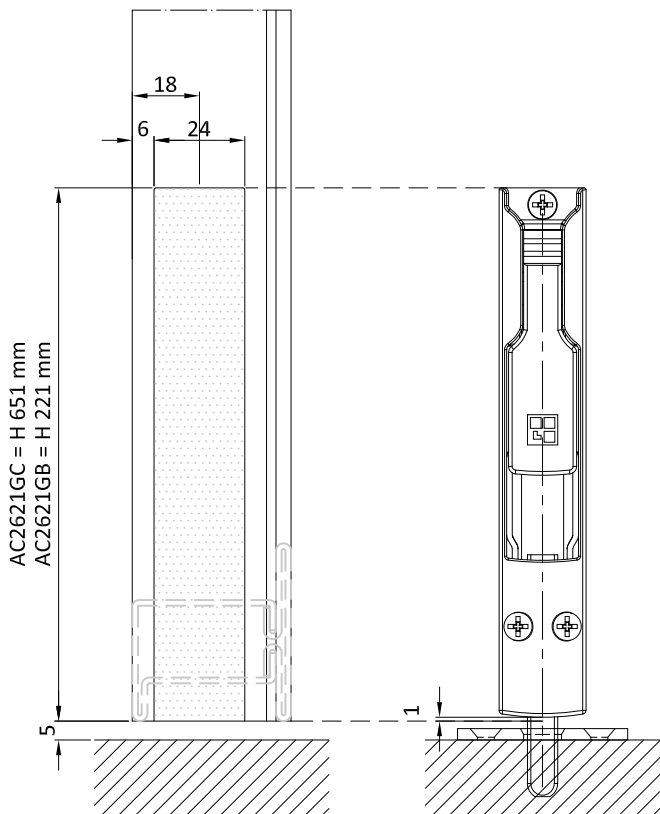
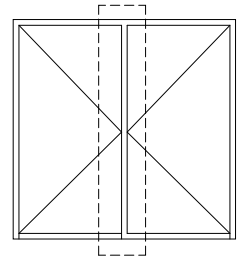
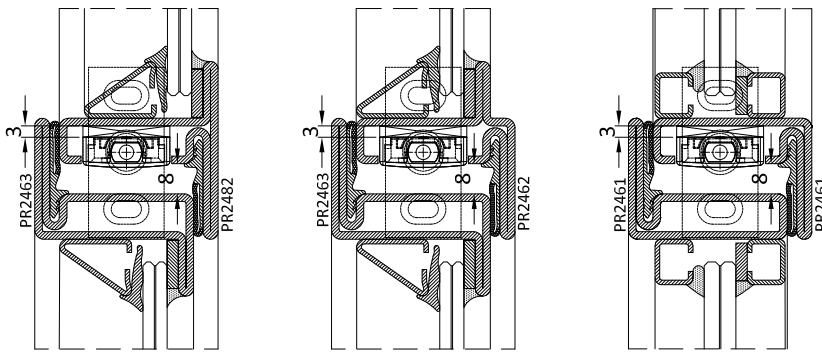


Peso max. per anta 100 kg
Max. weight for leaf: 100 kg

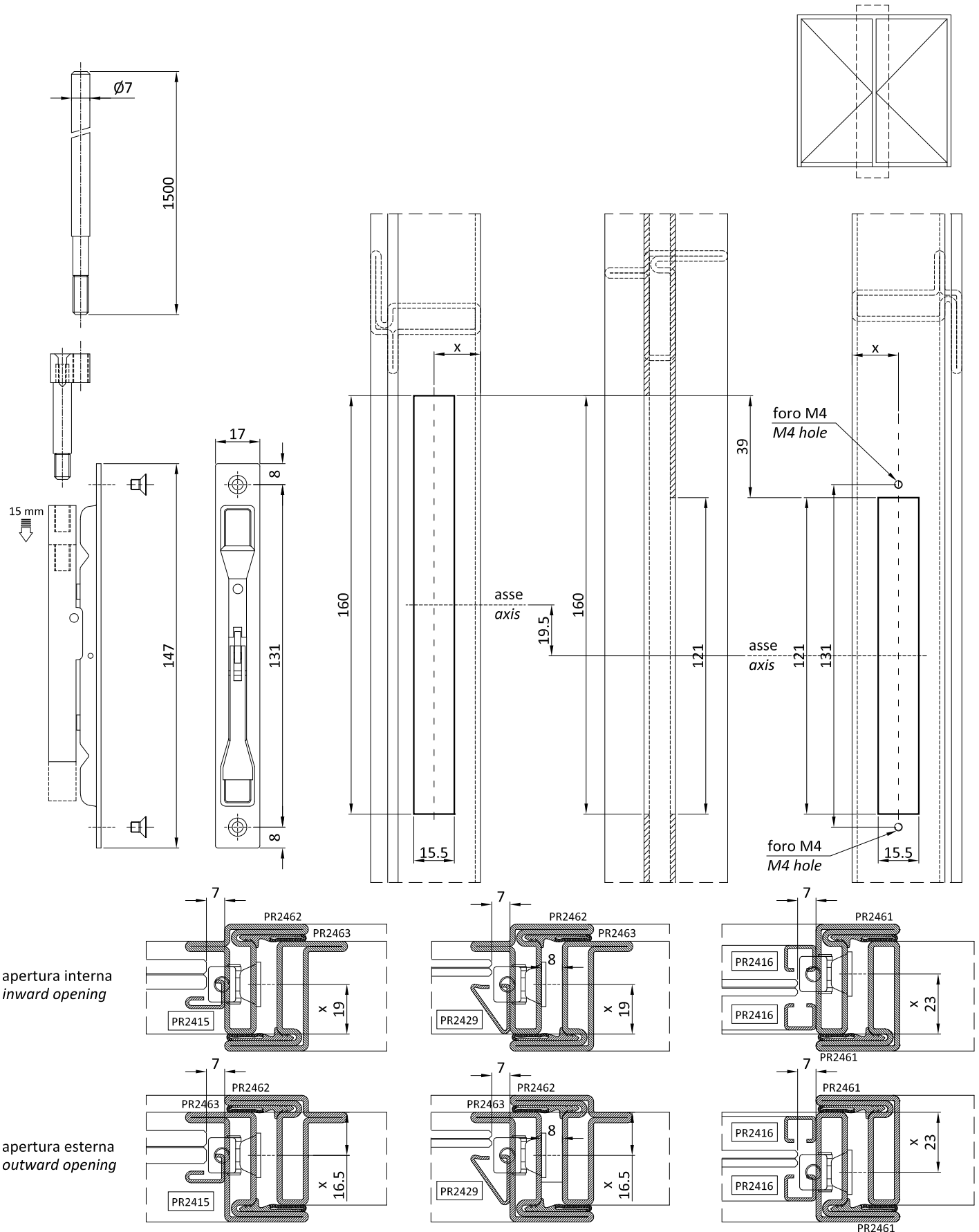


rinforzi interni
internal reinforcements



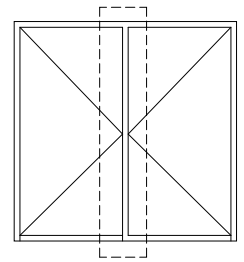
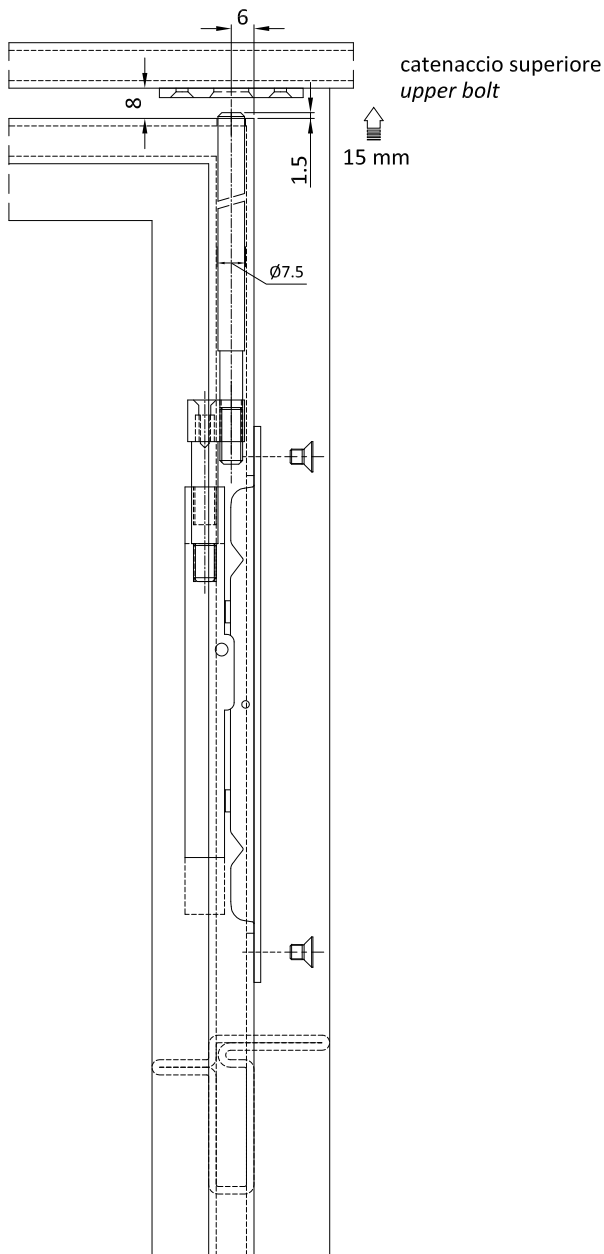
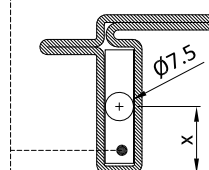
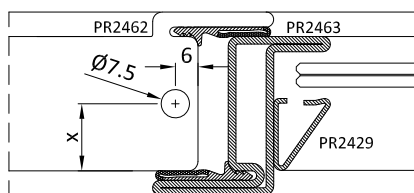
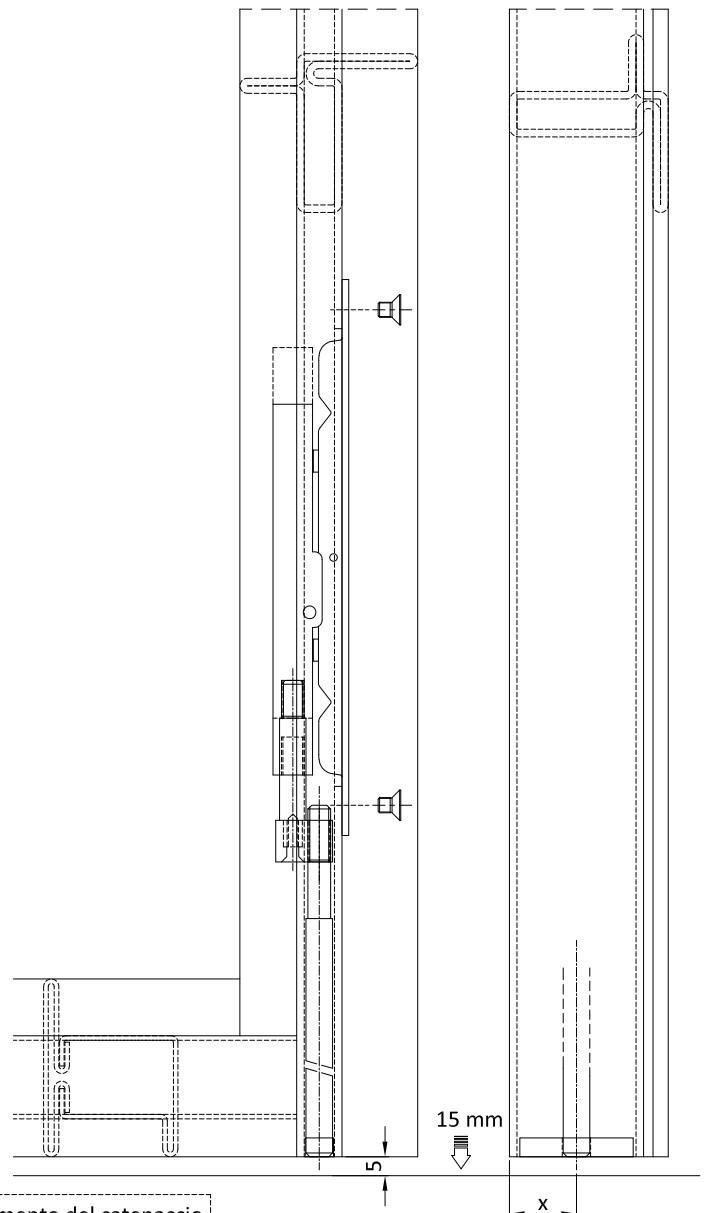


* spessore 3 mm non fornito | 3 mm shim not supplied



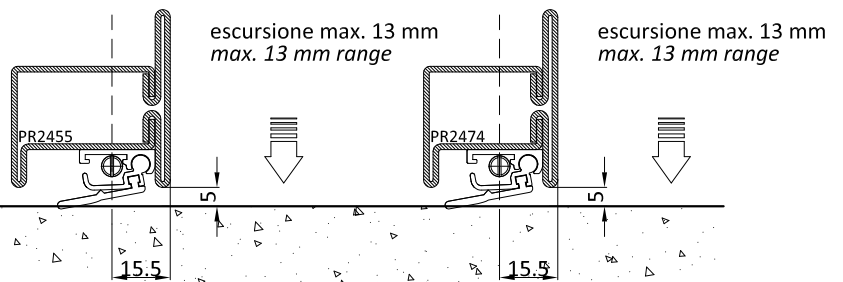
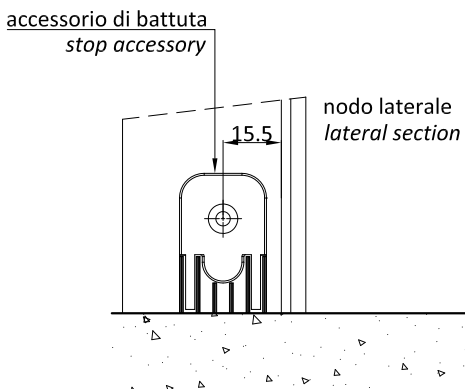
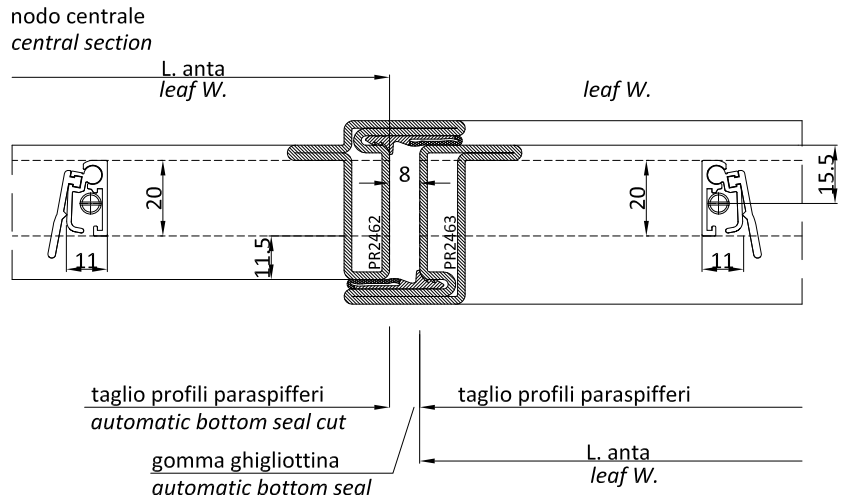
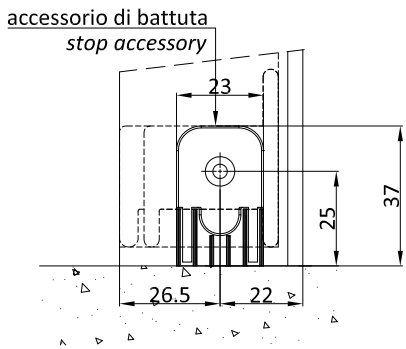
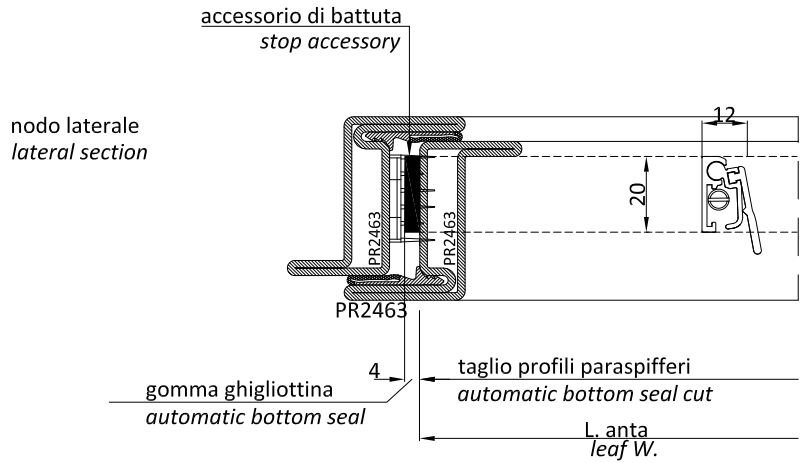
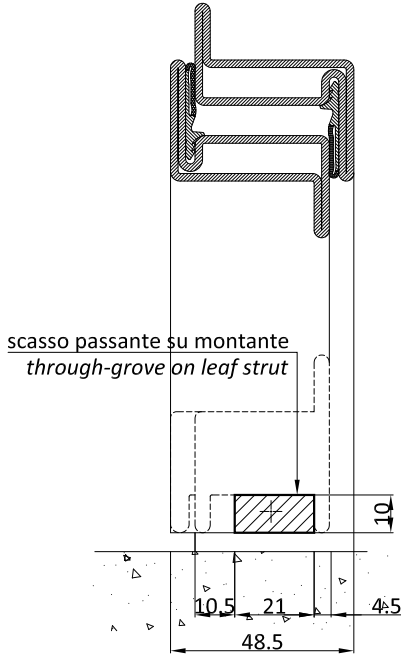
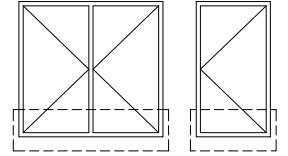
ATTENZIONE
 Possibile interferenza tra le viti di fissaggio fermavetri e i componenti interni. Utilizzare viti metriche ed accorciarle all'occorrenza.
ATTENTION
 Possible interference between the glazing retaining screws and internal components. Use metric screws and cut them if necessary.



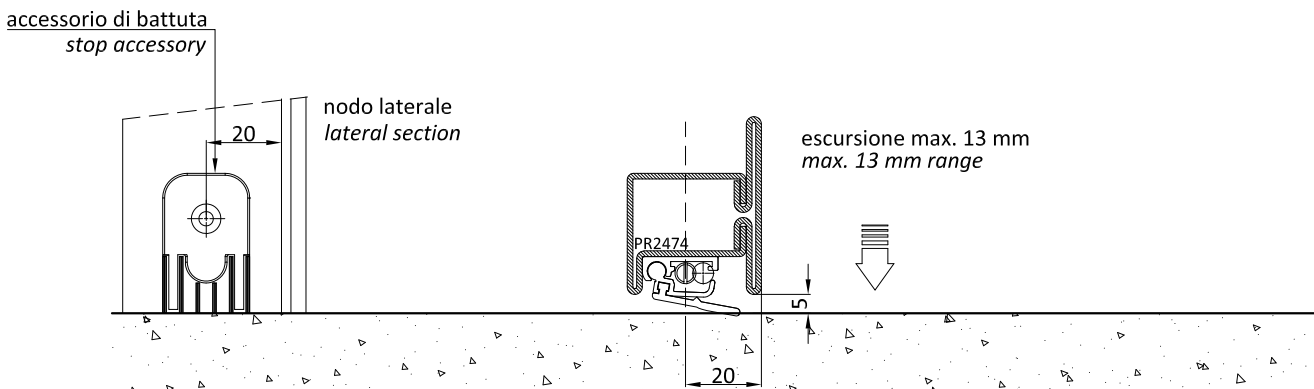
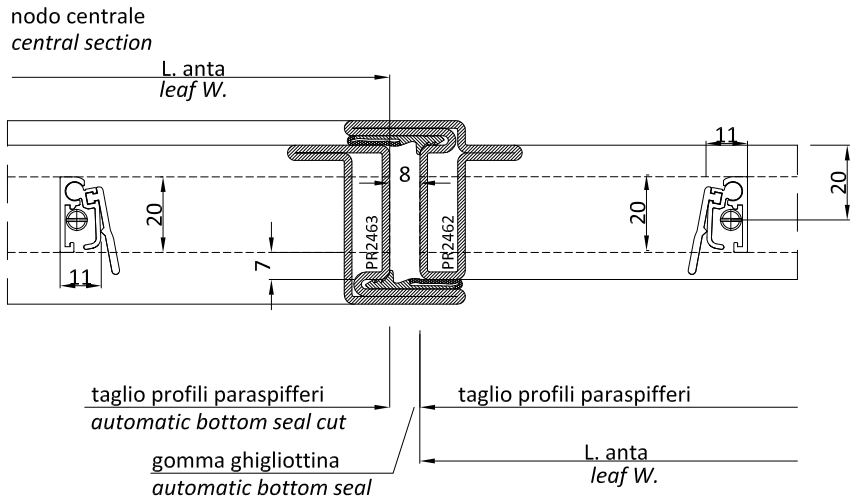
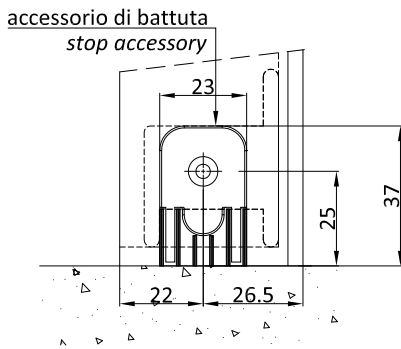
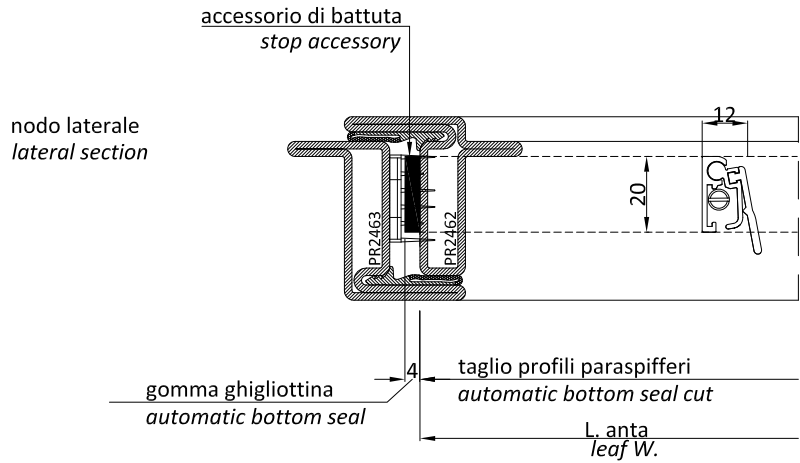
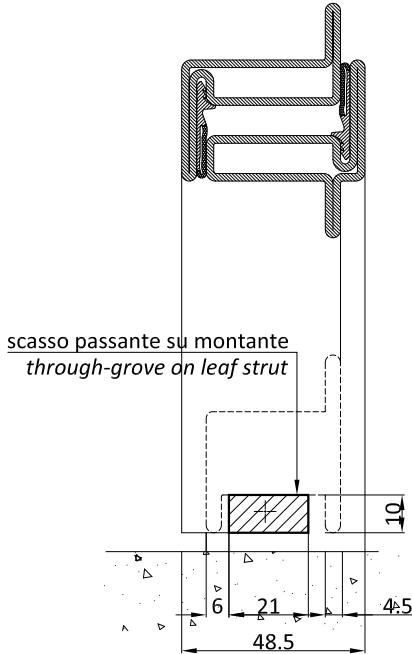
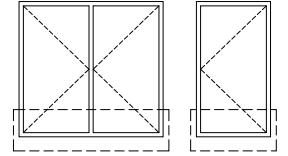
catenaccio inferiore
lower bolt

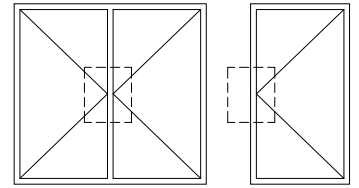
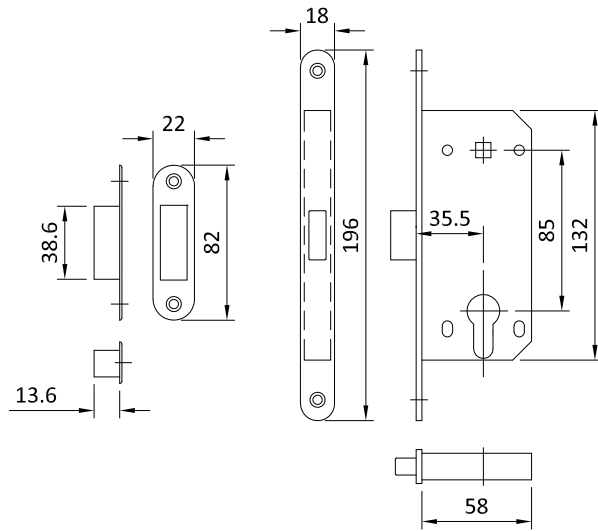
- individuare la posizione (x) corretta del foro secondo il posizionamento del catenaccio
- pre-forare $\varnothing 3$ mm la piastrina in ferro
- saldarla al profilo
- allargare il foro a $\varnothing 7.5$ mm
- identify the correct position (x) of the hole in according to the positioning of the bolt
- predrill $\varnothing 3$ mm the steel plate
- weld it to the profile
- widen the hole to $\varnothing 7.5$ mm

Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2436A	310 - 530 mm	302 - 522 mm
AC2436B	440 - 830 mm	432 - 822 mm
AC2436C	640 - 1130 mm	632 - 1122 mm

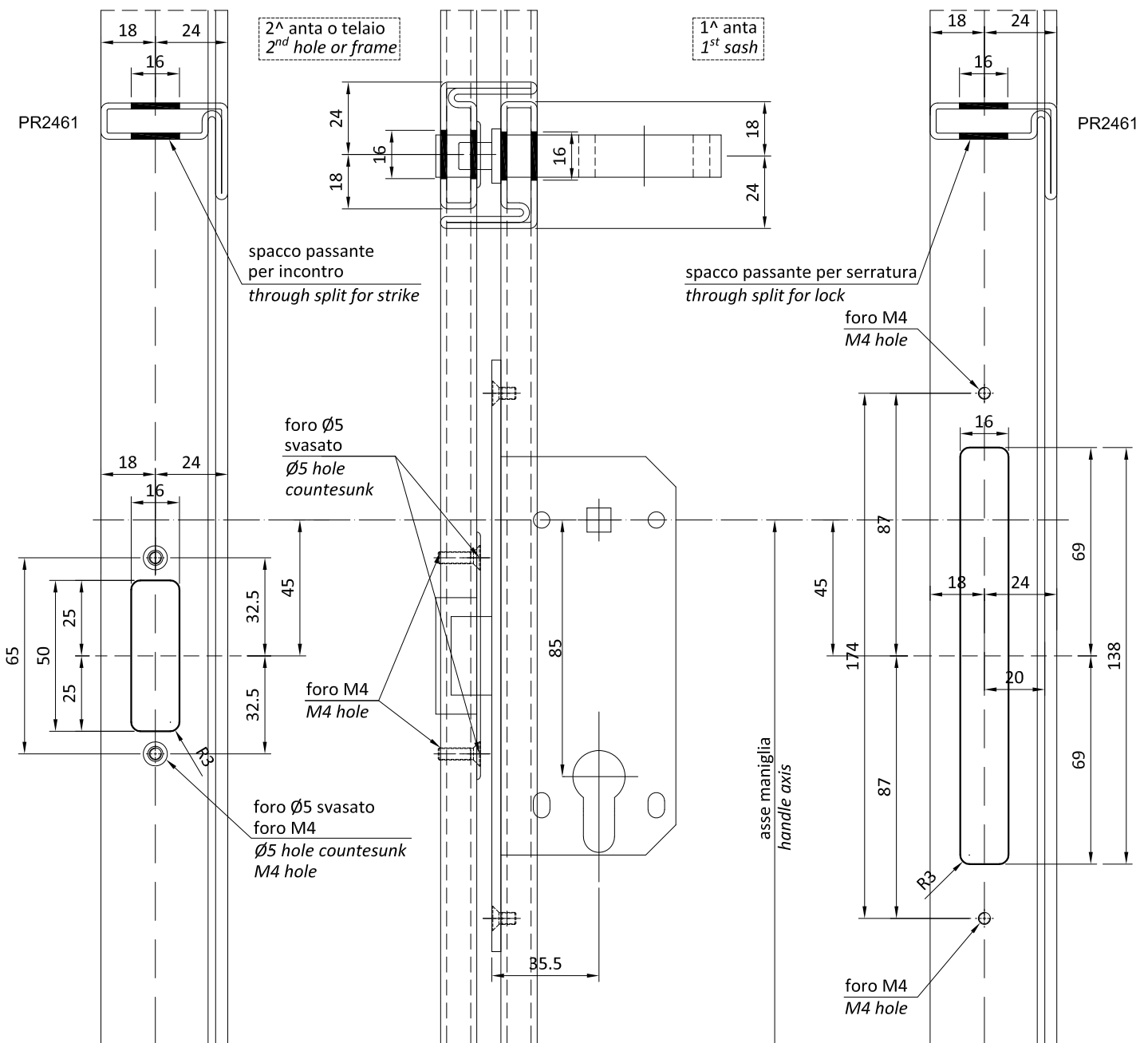


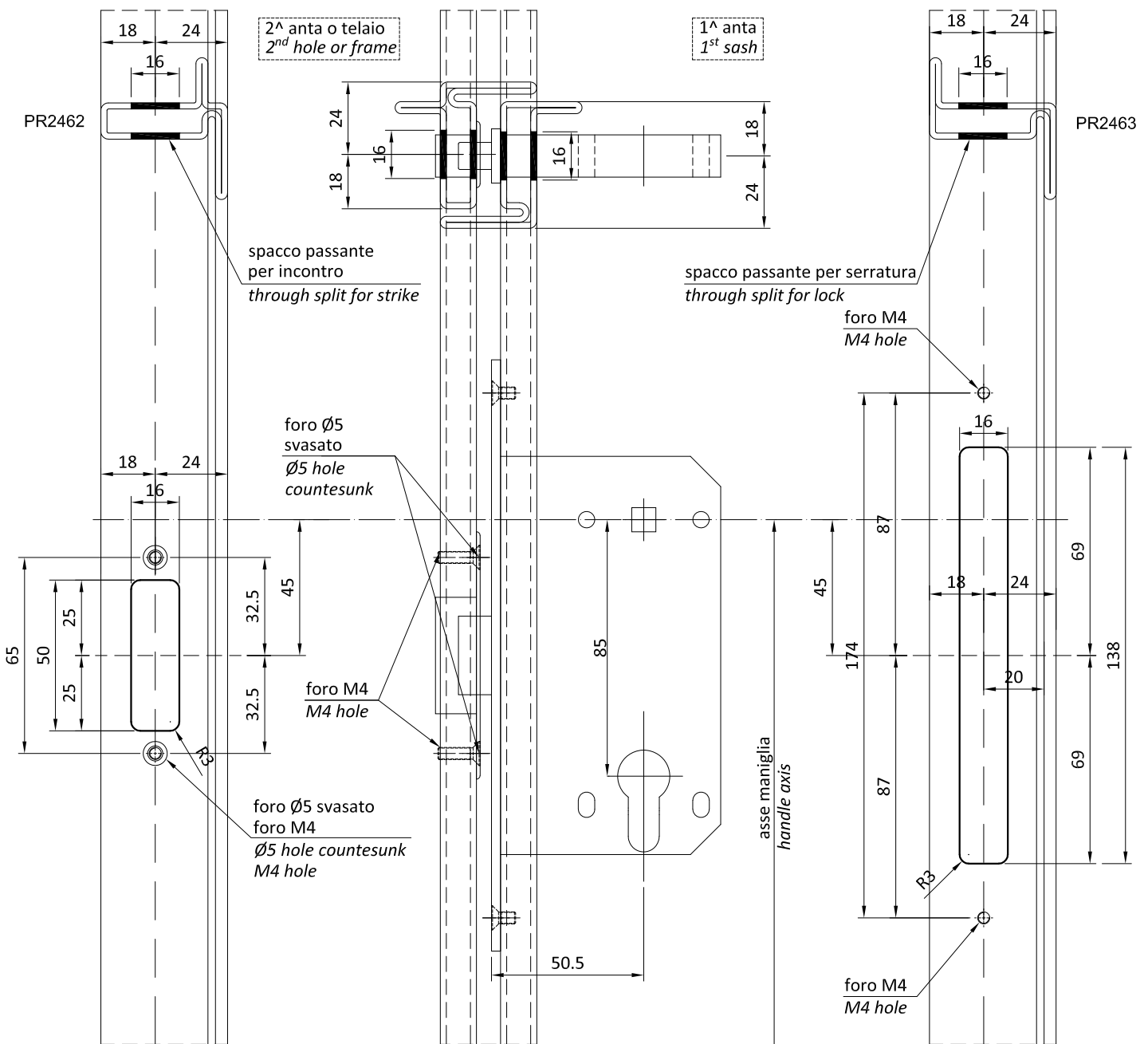
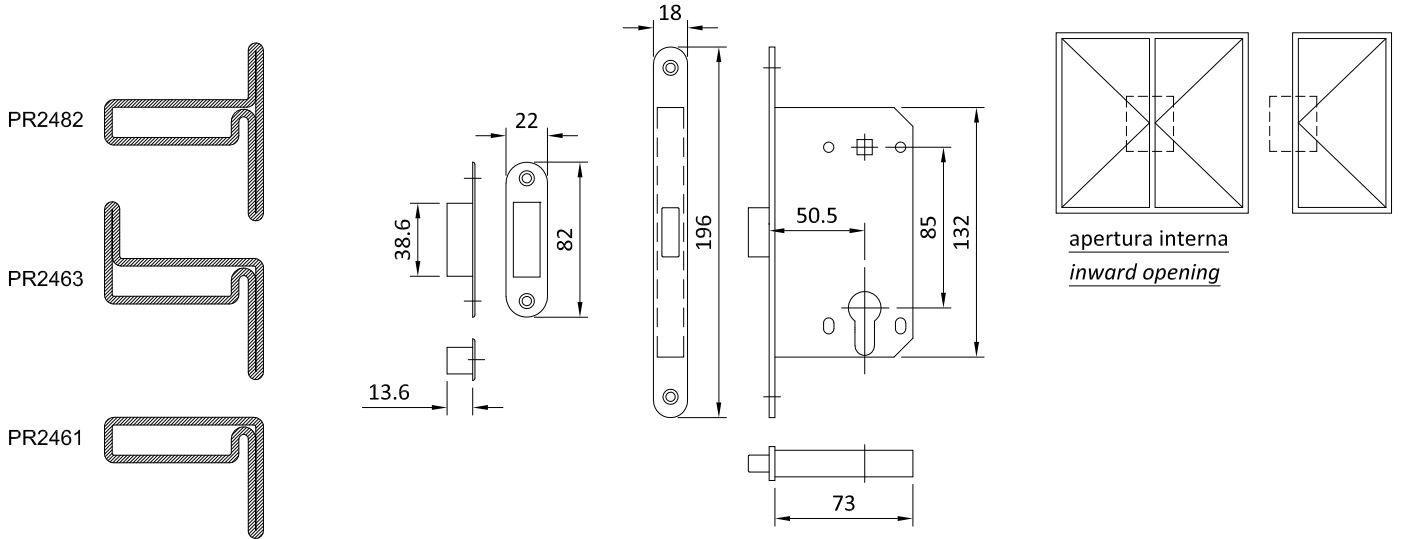
Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
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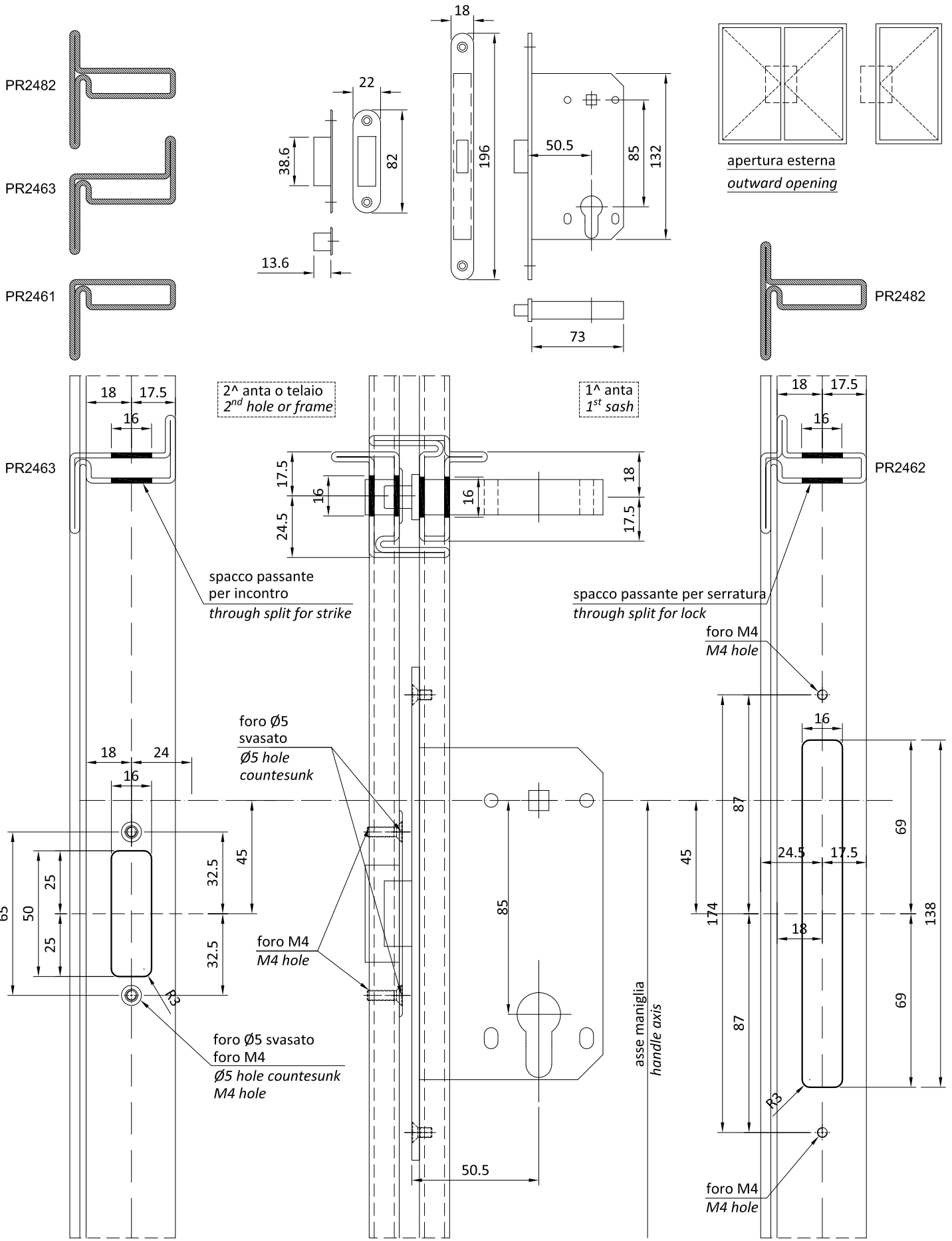


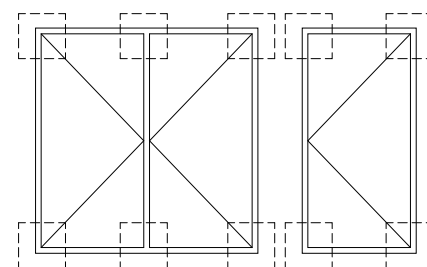
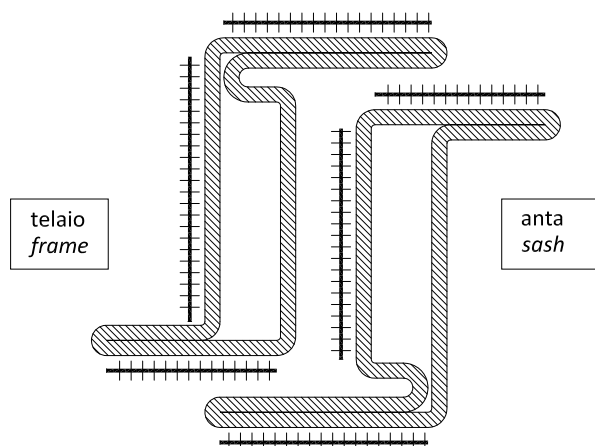


apertura interna | apertura esterna
inward opening | outward opening



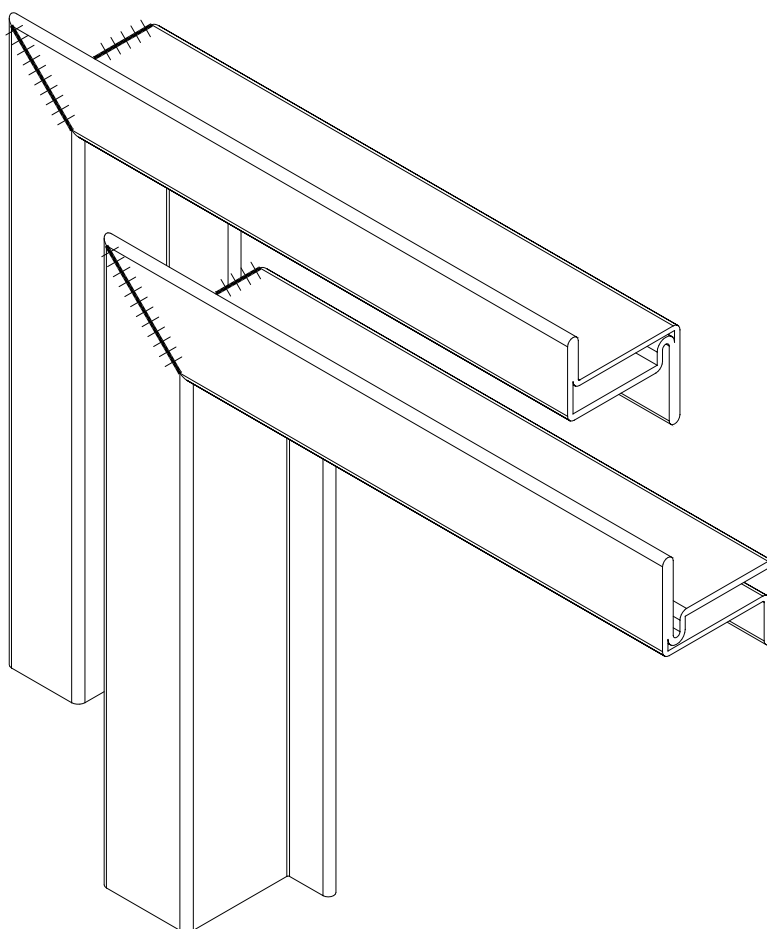


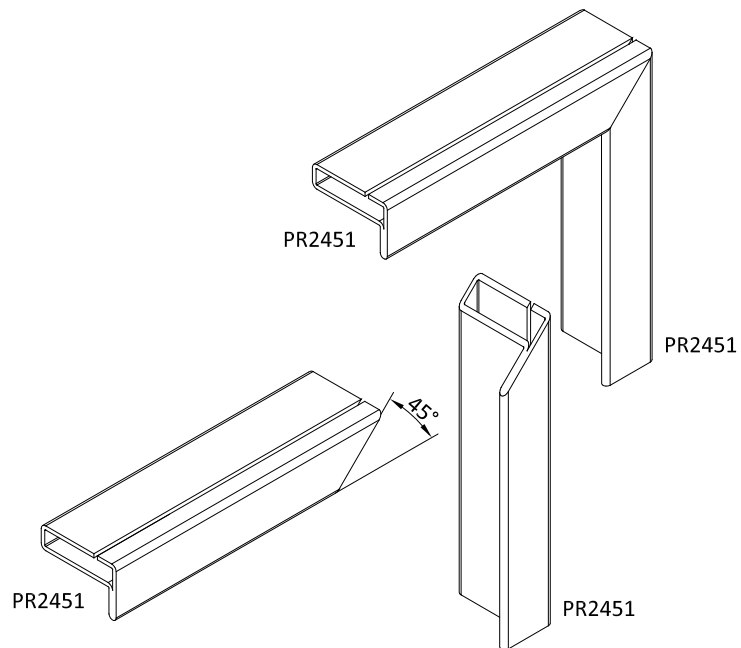
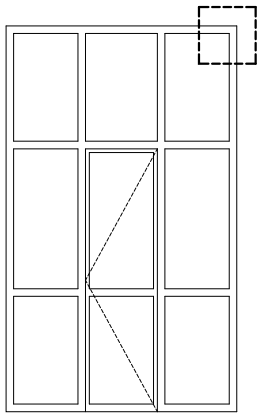




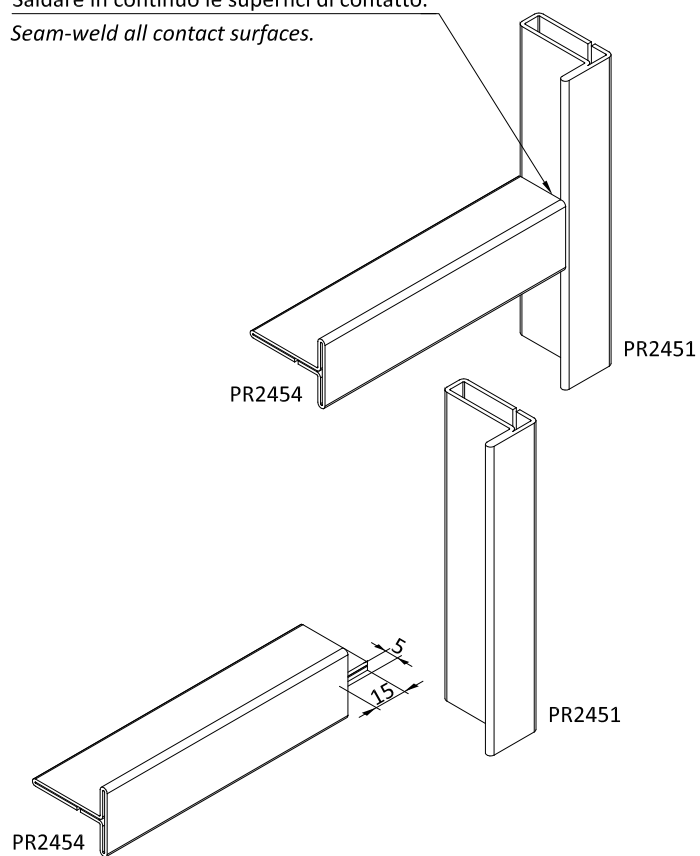
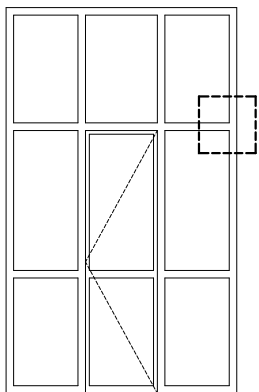
Acciaio decapato
Saldare in continuo le superfici di contatto.

Pickled steel
Seam-weld all contact surfaces.

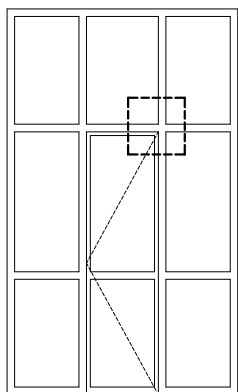




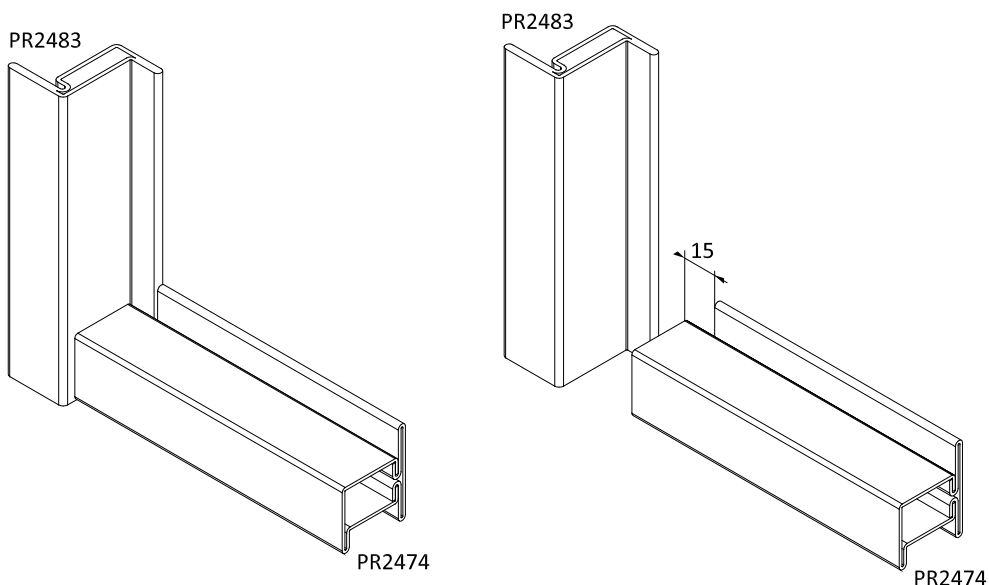
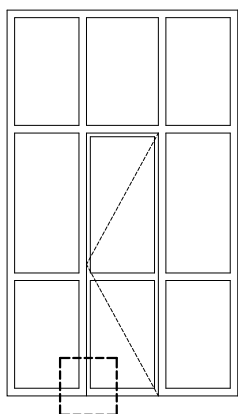
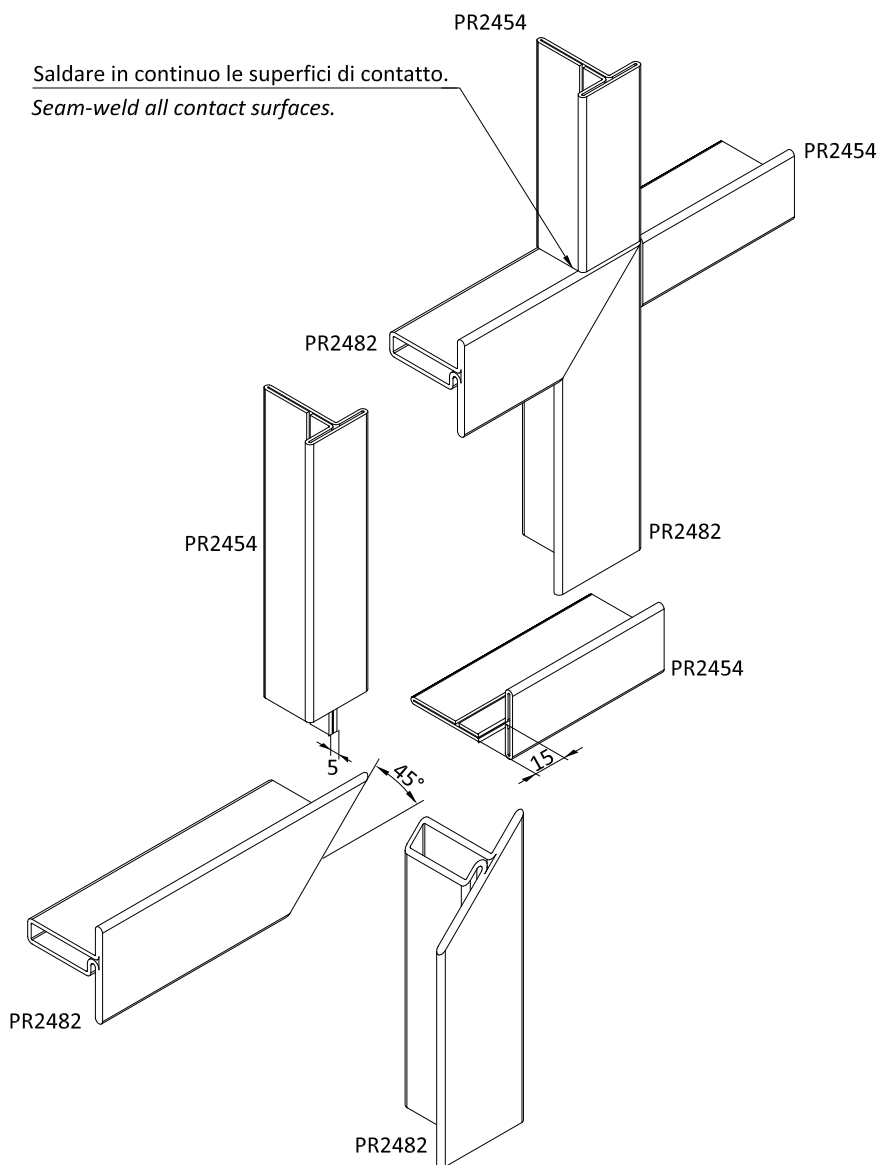
Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.



Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection



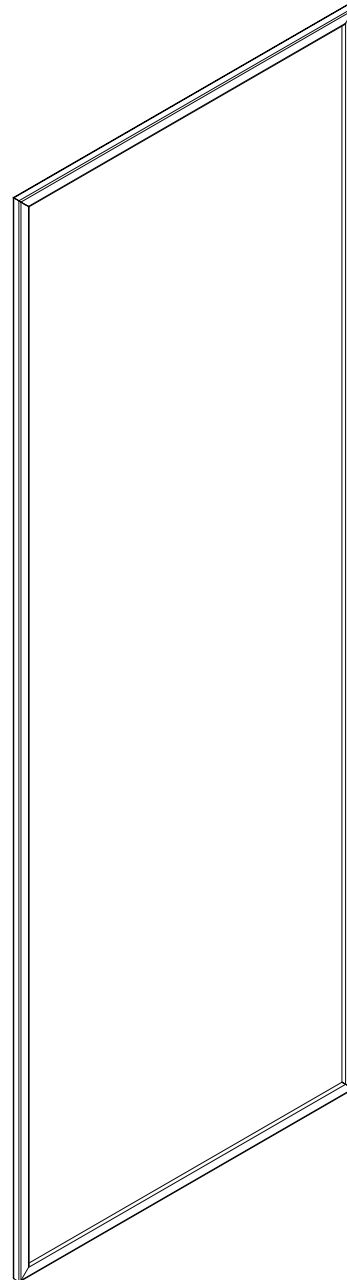
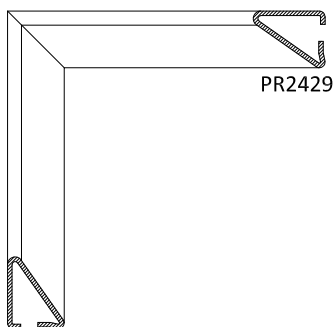
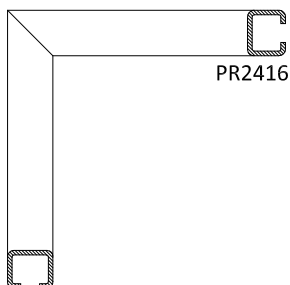
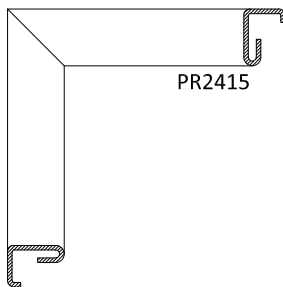
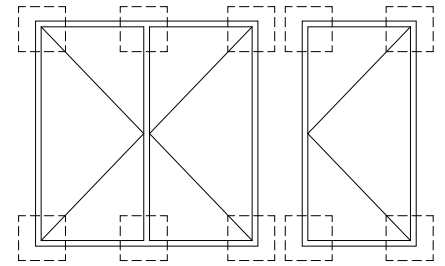
Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.

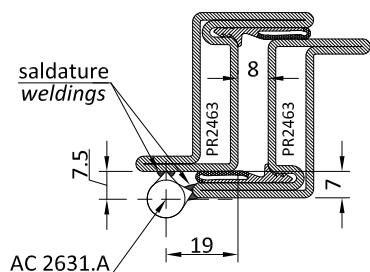
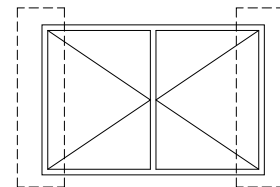
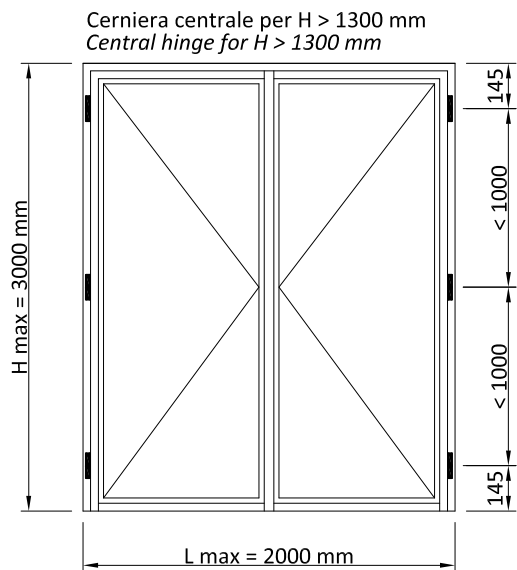


Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection

Acciaio decapato
Saldare in continuo le superfici di contatto indicate

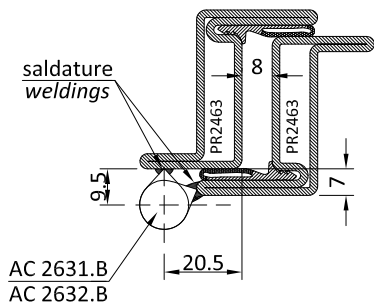
Pickled steel
Seam-weld the shown areas





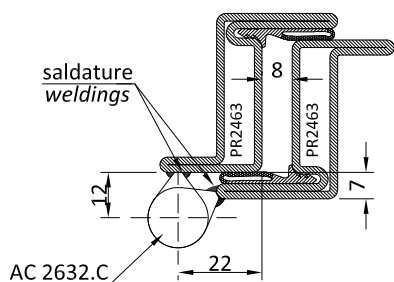
schema di fissaggio
AC2631.A non registrabile
cerniera Ø 10
peso massimo anta 40 kg

installation chart
AC2631.A non-adjustable
Ø 10 Hinge
Max leaf weight 40 kg



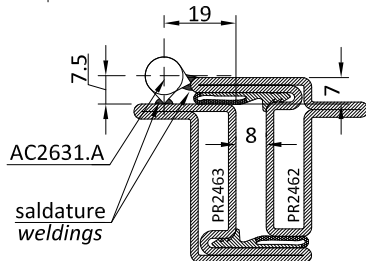
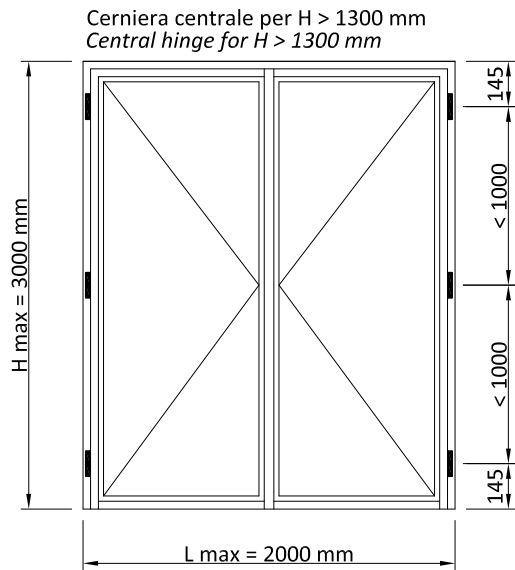
schema di fissaggio
AC2631.B non registrabile
AC2632.B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg

installation chart
AC2631.B non-adjustable
AC2632.B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg

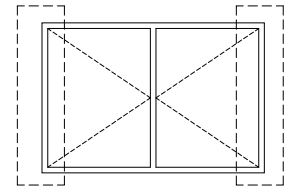


schema di fissaggio
AC2632.C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg

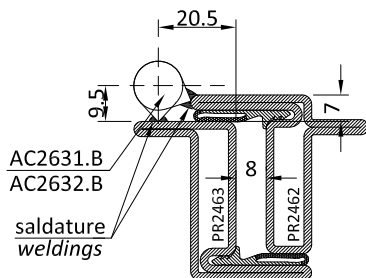
installation chart
AC2632.C adjustable in height
Ø 16 hinge
Max leaf weight 80 kg



schema di fissaggio
AC2631.A non registrabile
cerniera Ø 10
peso massimo anta 40 kg

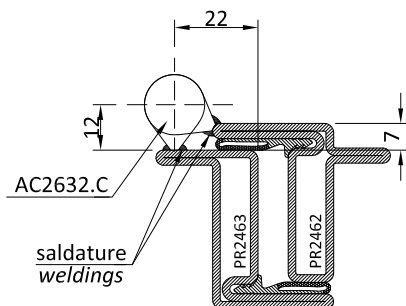


installation chart
AC2631.A non-adjustable
Ø 10 Hinge
Max leaf weight 40 kg



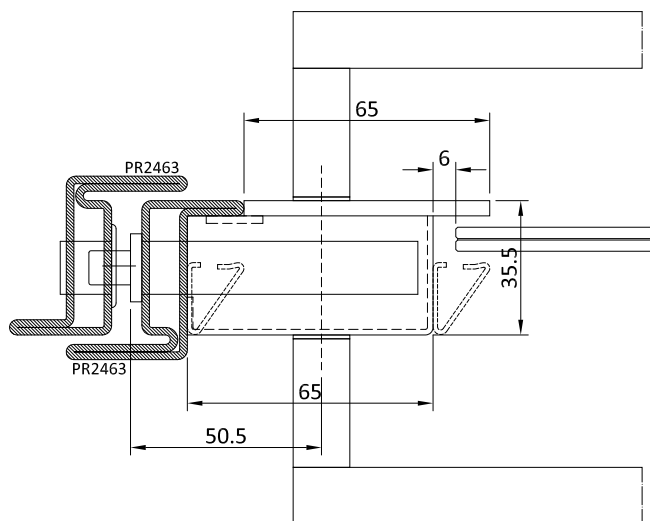
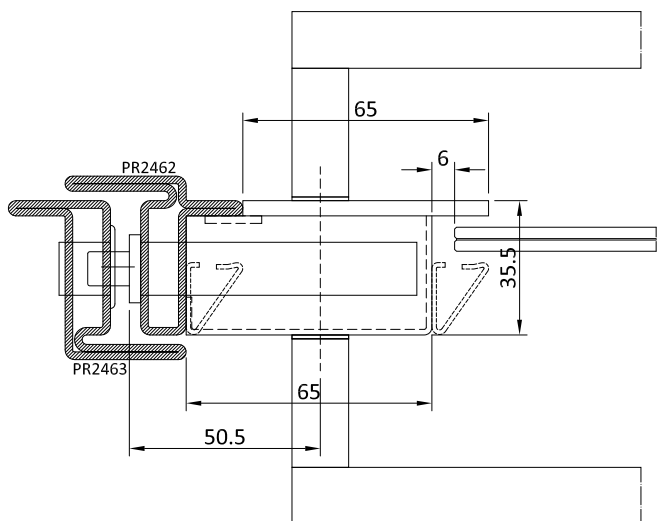
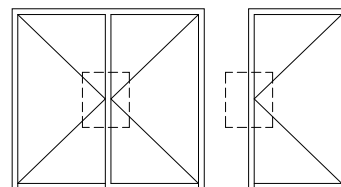
schema di fissaggio
AC2631.B non registrabile
AC2632.B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg

installation chart
AC2631.B non-adjustable
AC2632.B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg

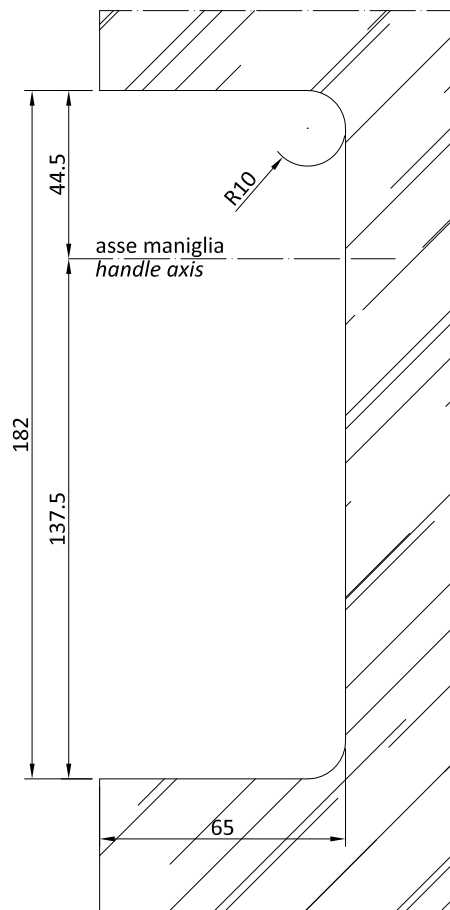
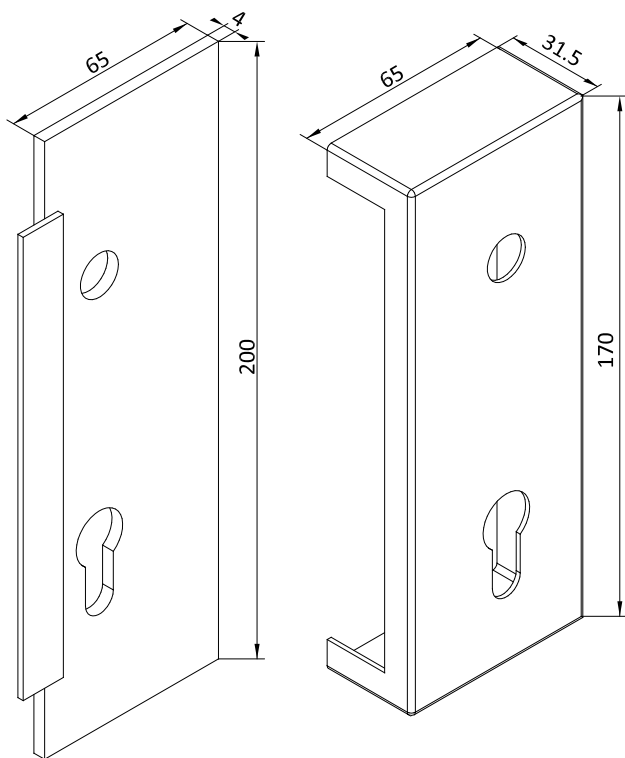


schema di fissaggio
AC2632.C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg

installation chart
AC2632.C adjustable in height
Ø 16 hinge
Max leaf weight 80 kg



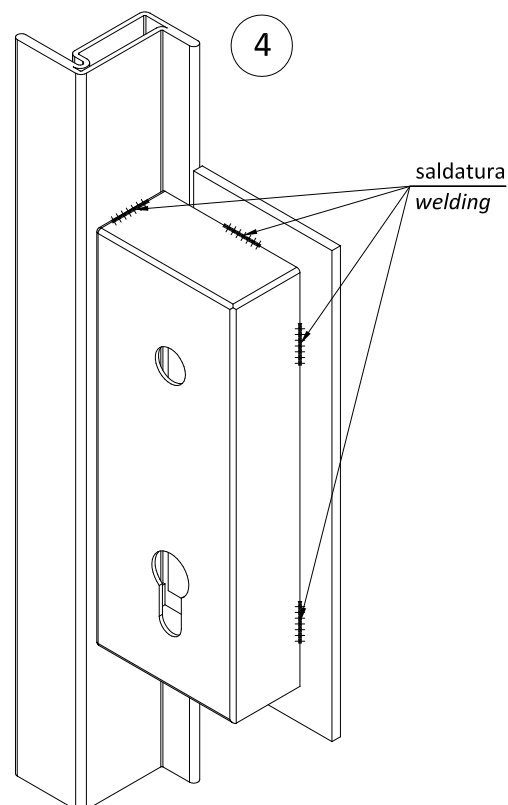
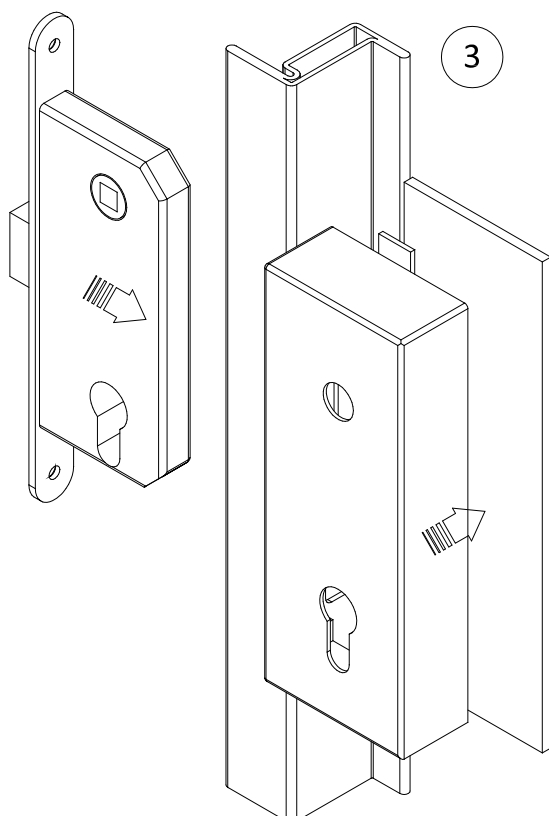
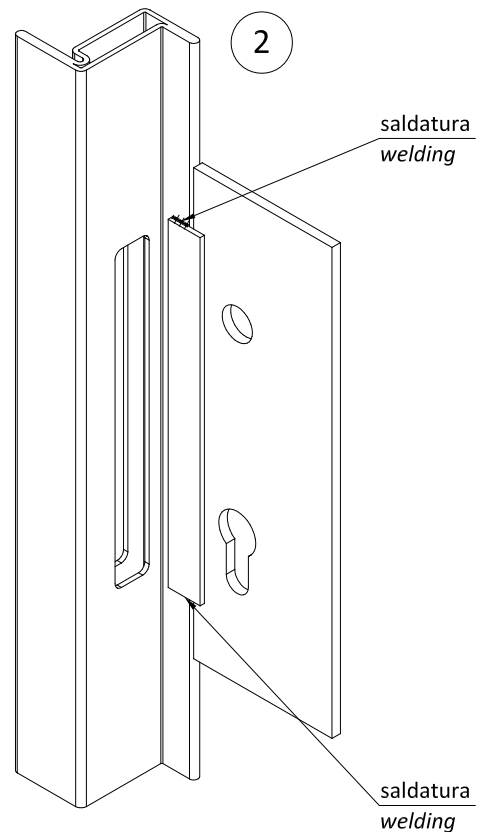
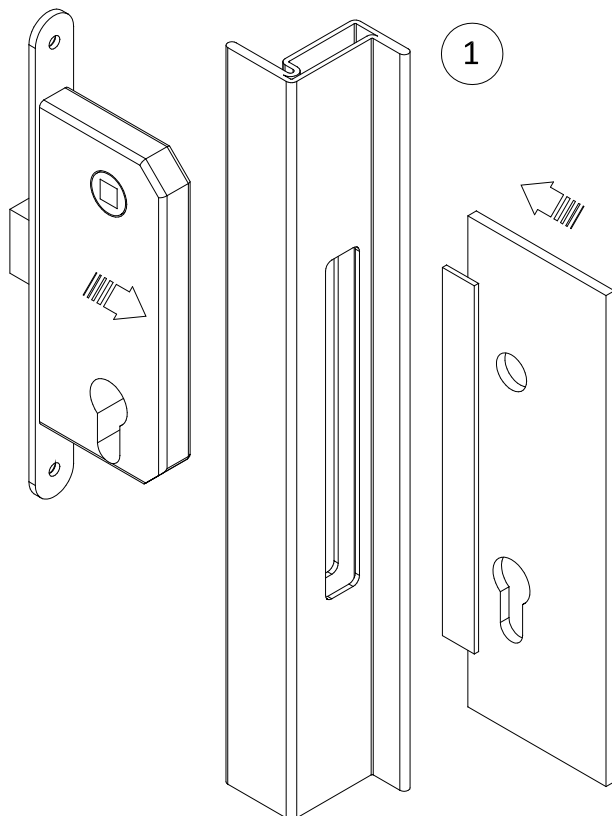
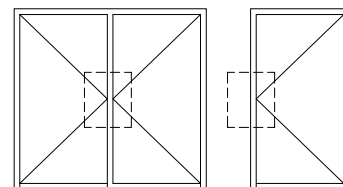
schema lavorazione vetro per inserimento serratura
glass processing scheme for lock insertion

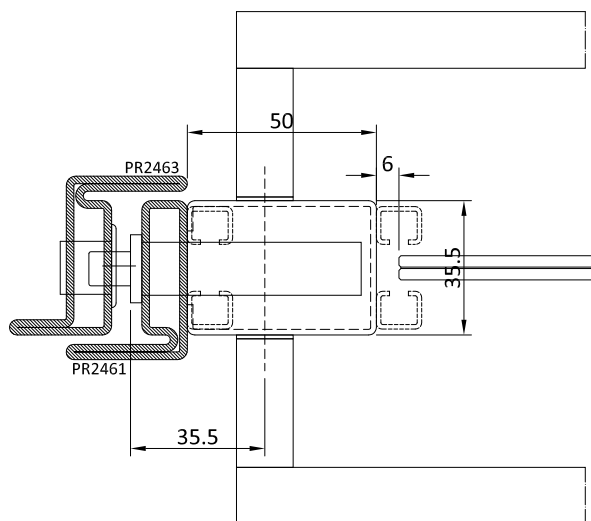
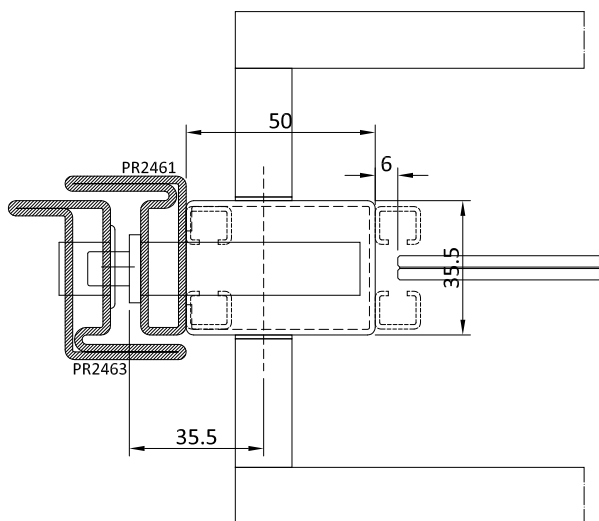
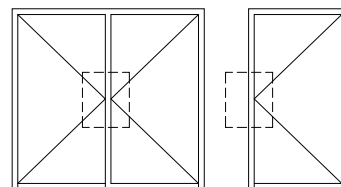


STEP 1 3

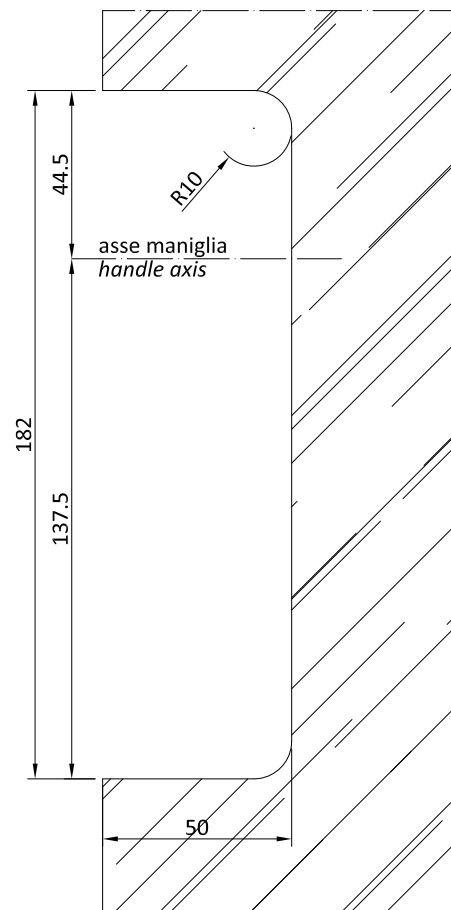
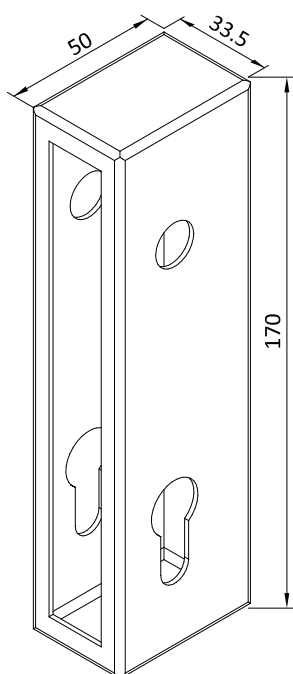
Prima di saldare i componenti scatola copri serratura, inserire la serratura e allineare i fori maniglia e cilindro alla scatola.

Before welding the lock box components, insert the lock and align the handle and cylinder holes to the lock box.





schema lavorazione vetro per inserimento serratura
glass processing scheme for lock insertion

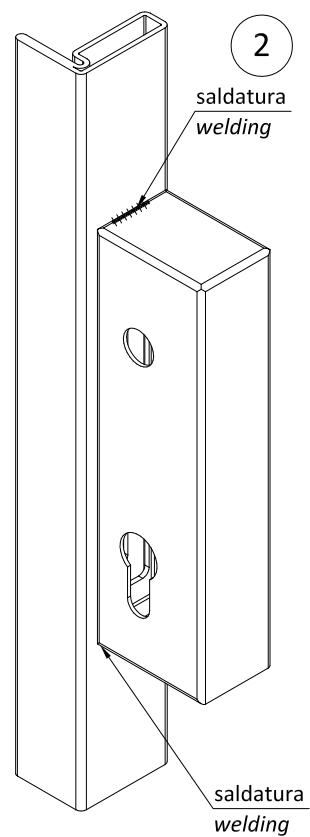
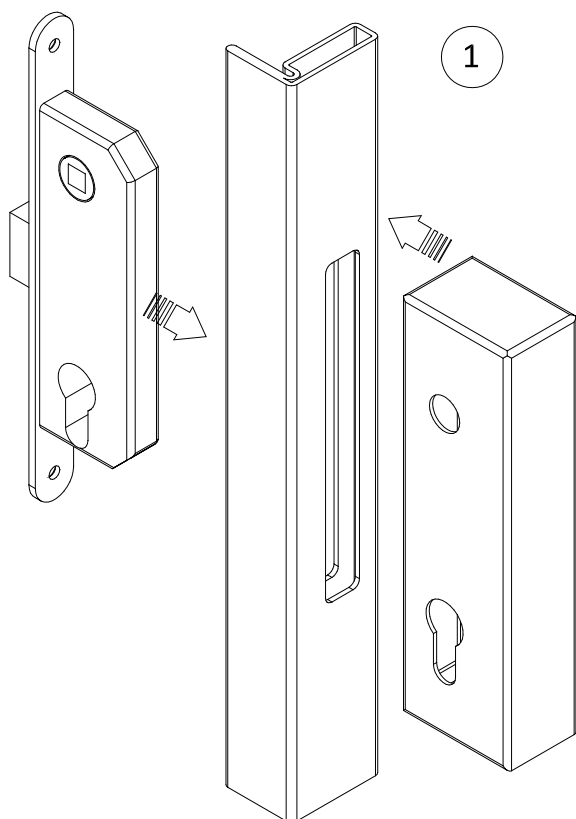
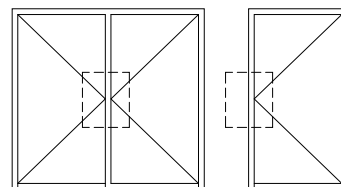


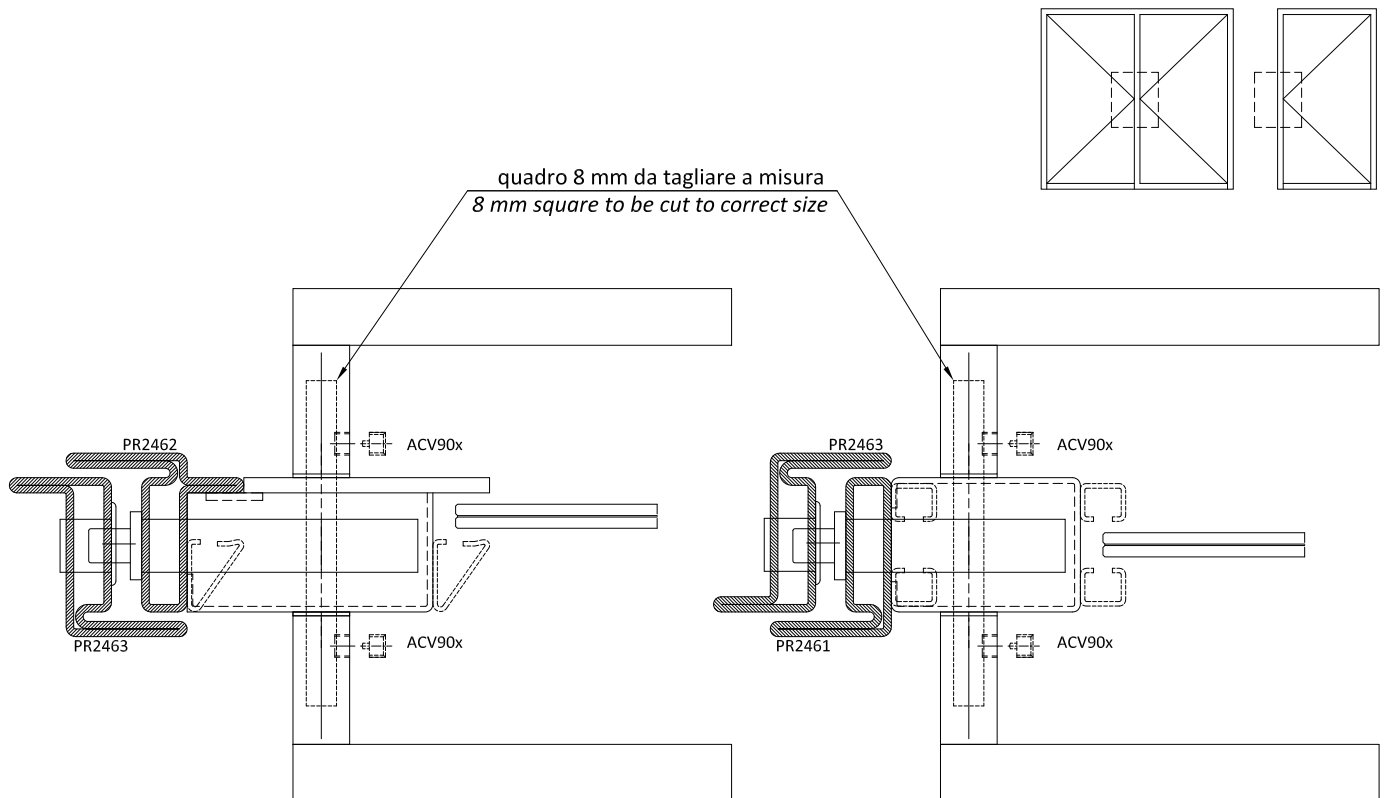
STEP

1

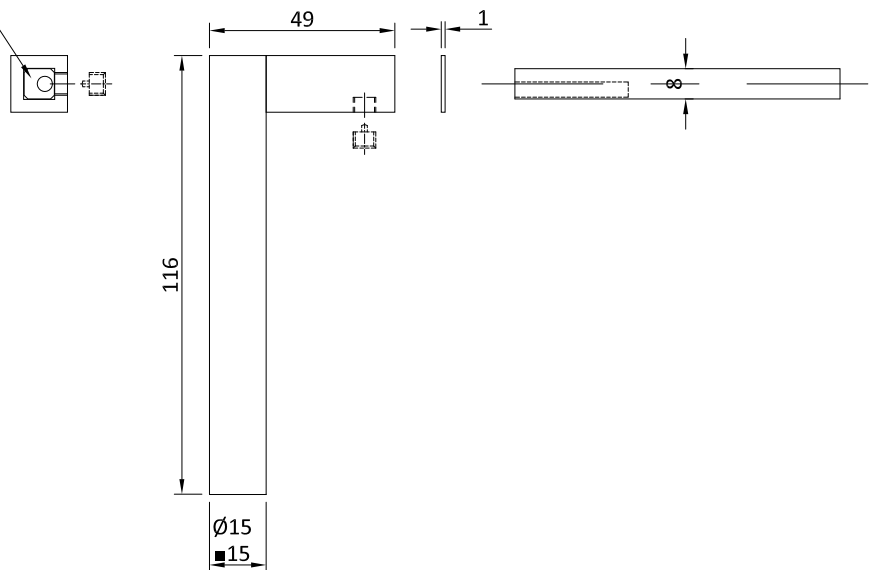
Prima di saldare la scatola copri serratura, inserire la serratura e allineare i fori maniglia e cilindro alla scatola.

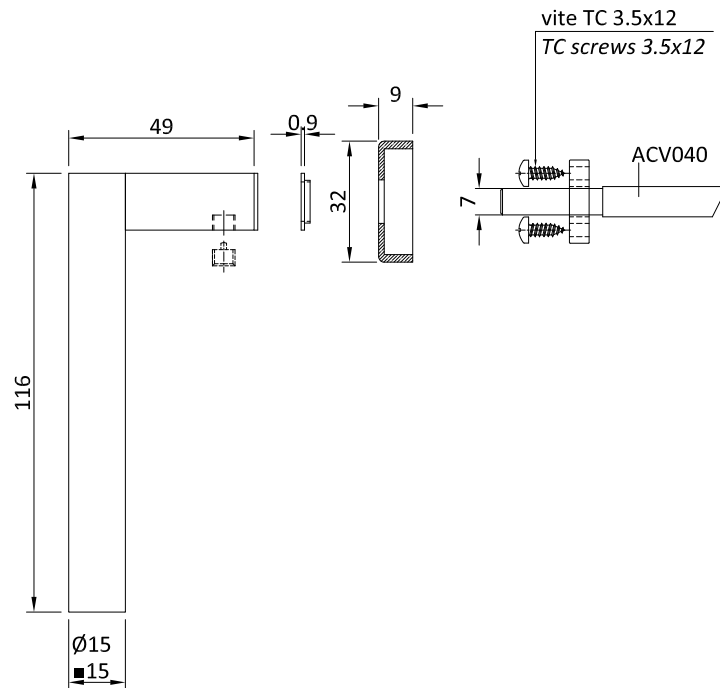
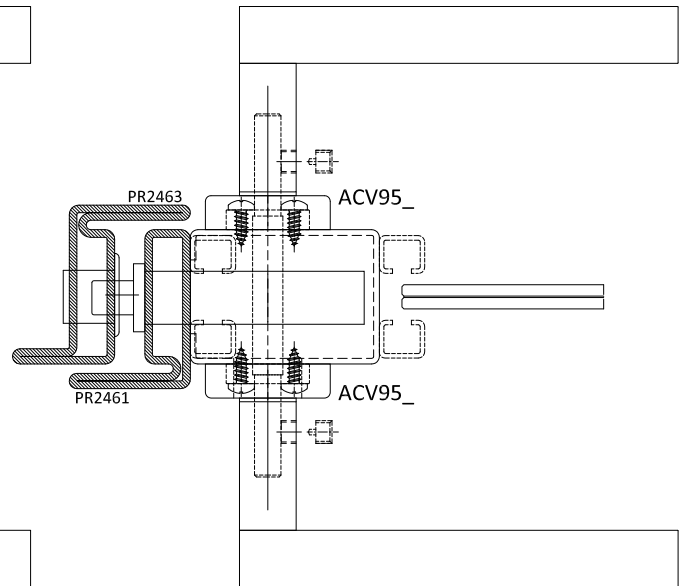
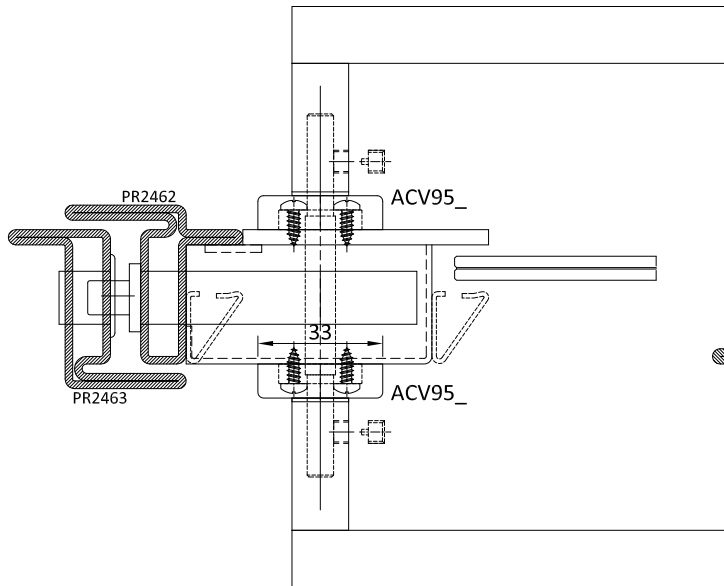
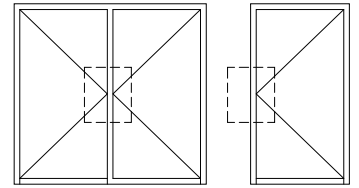
Before welding the lock box, insert the lock and align the handle and cylinder holes to the lock box.

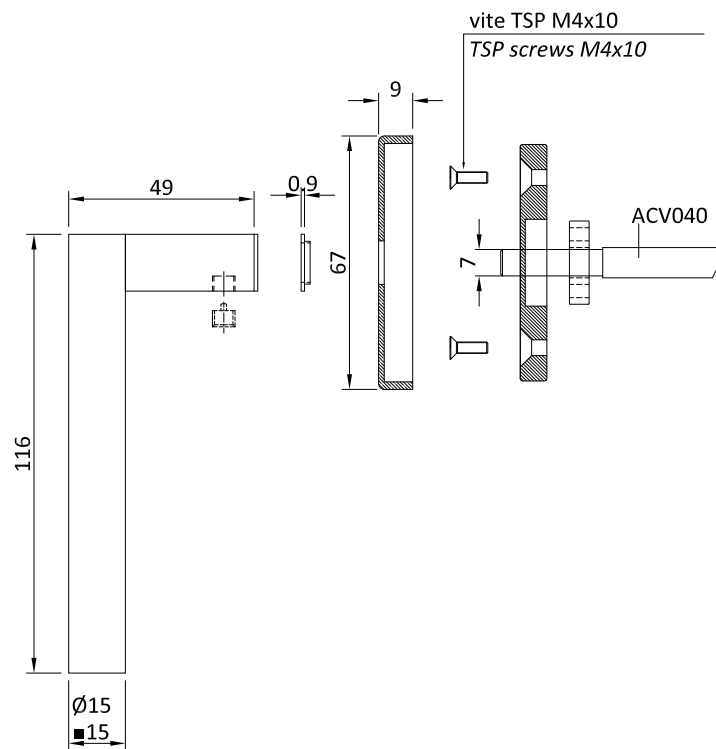
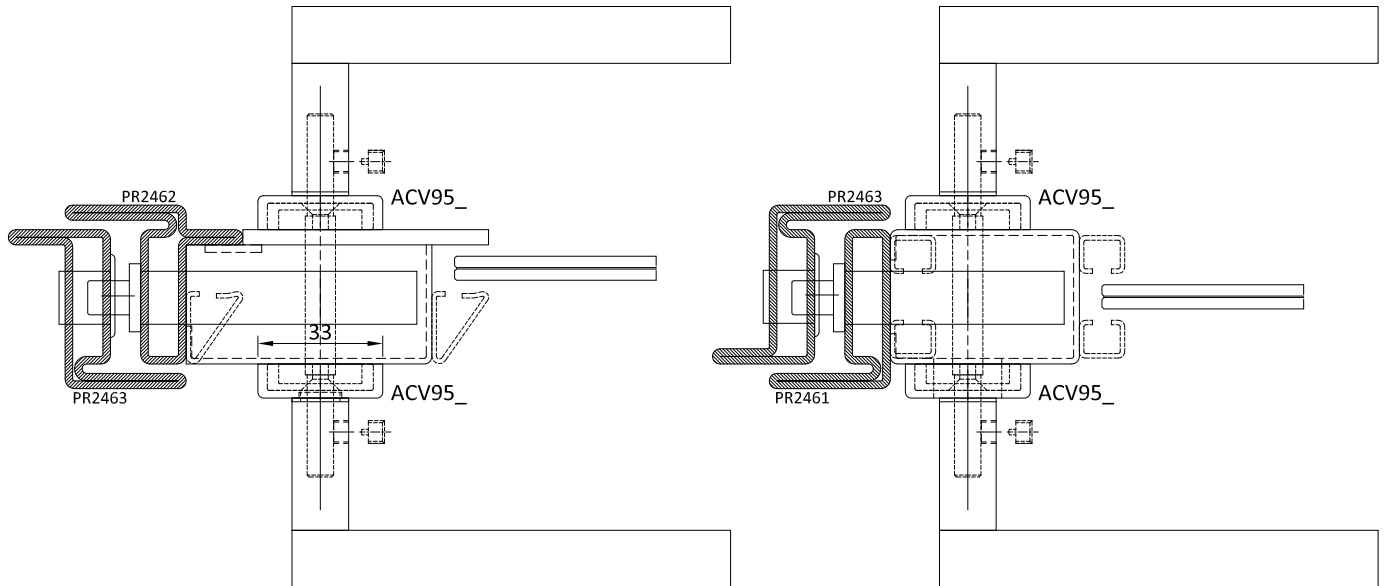
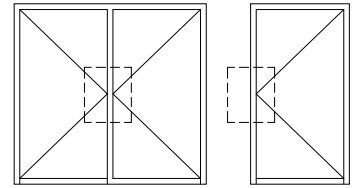


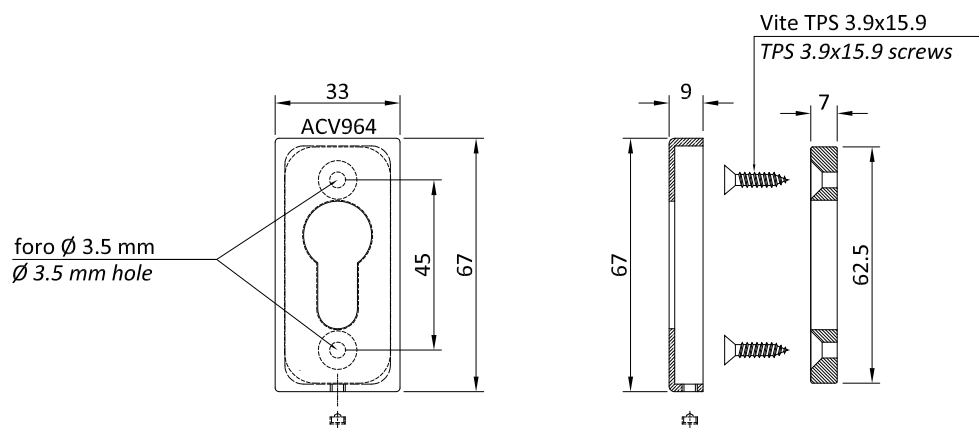
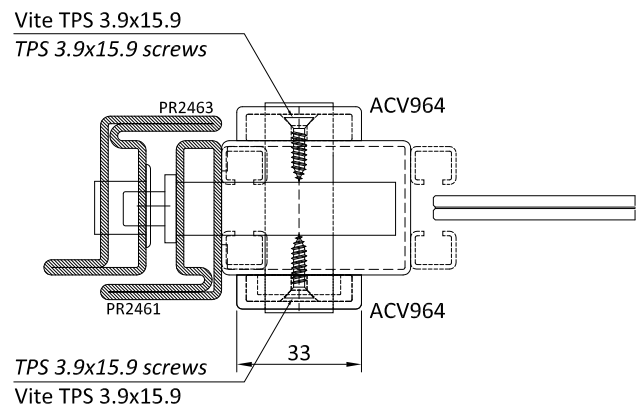
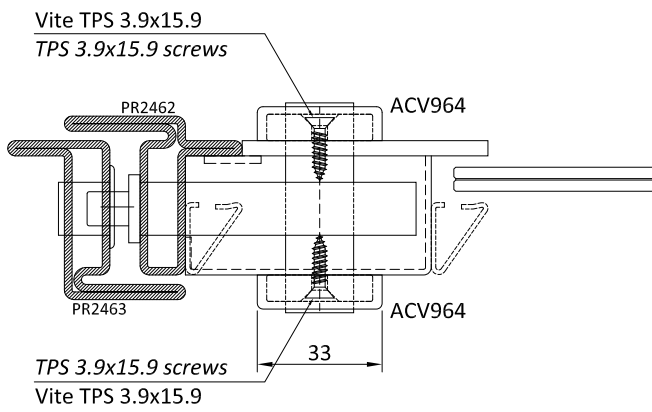
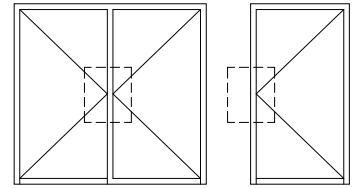


corretto inserimento quadro/grano
correct insertion of square/grain

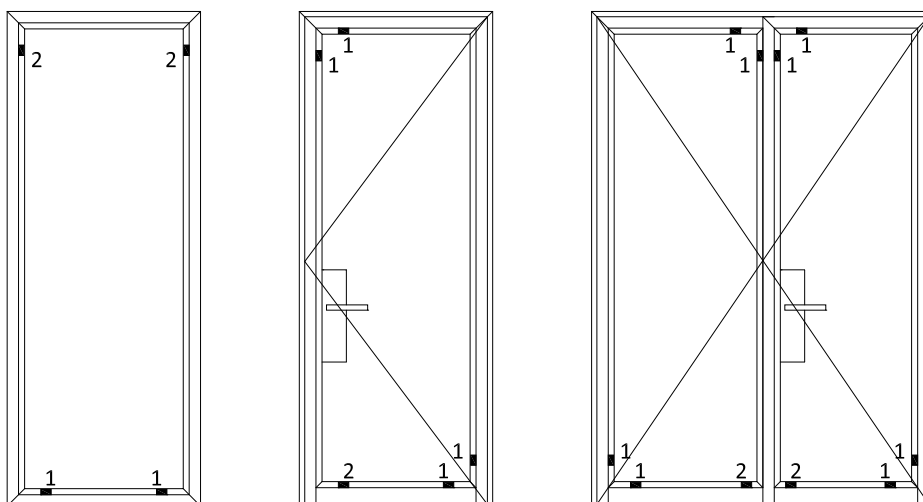




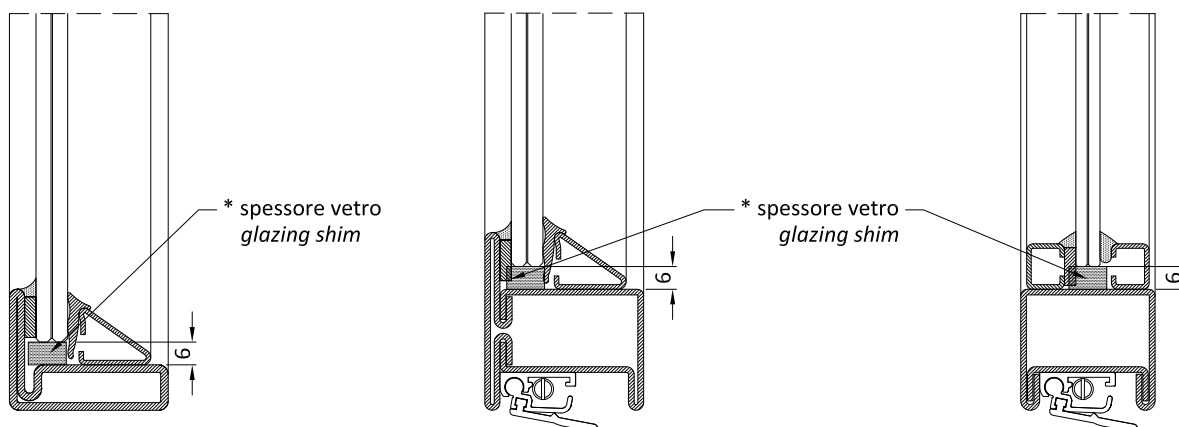




Porta | Door



- 1) spessore portante | *carry shim*
 2) spessore distanziatore | *compensation shim*



Note / Note

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- *The shims width is the same or bigger (+2 mm) than the installed glass spacer.*
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti la migrazione.
- *The shims position has to be provided by using an appropriate material which avoids any movements.*

* spessori vetro non inclusi - *glazing shims not included*

Generalità

I sistemi progettati e sviluppati dalla Secco Sistemi sono idonei per la fabbricazione di un'ampia gamma serramenti, vetrate e facciate in metallo. I sistemi sono rivolti ad aziende esperte e professionali nel campo della lavorazione dei metalli e della costruzione di serramenti e facciate, che sono a conoscenza delle normative di riferimento, delle direttive e delle specifiche tecniche del fornitore del sistema, nonché delle fondamentali regole dell'arte per la produzione e installazione di questi manufatti. Tutta la documentazione tecnica fornita costituisce un riferimento per i tecnici qualificati delle aziende al fine di indicare le modalità per la costruzione dei prodotti. In ogni caso i tecnici qualificati devono analizzare criticamente le indicazioni riportate per verificarne la loro adeguatezza per ogni singola commessa in relazione ai carichi, agli stress previsti e alle condizioni di messa in opera, essendo impossibile riportare in questa documentazione tutte le varianti riscontrabili nei progetti reali.

Tolleranze

OS2 40 è composto da una serie di profili dalle ridottissime dimensioni e prevede un accoppiamento dei telai esterni con le ante apribili con distanza di 8 mm. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-1 mm e la tolleranza per il sormonto degli stessi compresa tra +0/+0.5 mm.

Taglio/Lavorazioni

I profili OS2 40 in acciaio decapato, possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2400) per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio sia per la sezione inclinata a 45° che per la sezione verticale a 90° dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura

I profili OS2 40 possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva eventuale verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura

I profili OS2 40 sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. I telai prima della verniciatura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento.

Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrazione

Il sistema di fissaggio del vetro prevede l'utilizzo di fermavetri agganciati all'interno tramite clips o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione e all'esterno, l'utilizzo di siliconatura e l'inserimento della guarnizione adesiva GE2036 (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m² di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

Installazione

Si consiglia di progettare un corretto numero di fissaggi in relazione al tipo di controtelaio/muratura esistente e alle dimensioni degli elementi da installare. Al termine dell'installazione si verifichi il corretto funzionamento del serramento (facilità di apertura/chiusura, stabilità dell'anta aperta a riposo, etc.), il rispetto delle fughe e del sormonto tra ante apribili e telai fissi, il regolare posizionamento delle guarnizioni e delle sigillature e la mancanza di difetti estetici sulle superfici dei telai e del vetro.

General information

The systems designed and developed by Secco Sistemi are suitable for the manufacturing of a wide range of doors, windows and shutters, as well as faces or facades in metal. The systems are designed for professional and expert companies in the metal-working sector and that of construction of doors, windows, shutters and facades. These companies are well aware of the specific regulations and the directions and technical specifications of the system supplier, and also the fundamental rules of the art of manufacturing and installing these products. All the technical documentation provided furnishes a source of reference for the qualified technicians of the companies, giving indications as to how the products should be constructed. These qualified experts must critically analyse the indications to verify their adequacy for each single order in terms of load, stress and conditions of installation, particularly as this documentation cannot provide for all the different variations that may be found in projects.

Tolerance

OS2 65 is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm. To ensure the correct use of hardware and gaskets the processing must be performed with great care and precision. It is advised to keep the tolerance between $+0/-1$ mm for opening elements and between $+0/+0.5$ mm for their overlapping area.

Cut / Processing

OS2 65 profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. OS2 65 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2800) to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between $-1^\circ/+1^\circ$. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

Welding

OS2 65 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special DPIs provided and in areas with sufficient ventilation and with fumes disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for a later painting without any visible imperfections (pores and ripples).

The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised

Painting/Burnishing

OS2 65 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024/33/42/52). Holes must be drilled (as per instructions) in the frames before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooling.

It is advised to follow pre-treatment and painting cycles as outlined in Secco Sistemi documentation.

Glass application

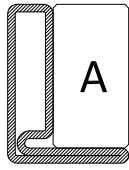
The glazing unit is secured by means of glazing beads which must be fixed by pressure with the dedicated clips or bushings to then fit the appropriate gasket.

Externally, the glazing unit must be sealed with GE2036 and by applying silicone on the whole perimeter (the latter is recommended when the glazed surface is greater than 1 sqm in order to guarantee a higher rigidity of the glazing unit).

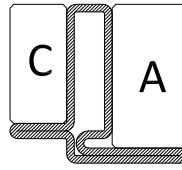
In order to ensure the correct behaviour of the system, it is recommended to verify the proper pressurization of the internal glass bead gaskets and that the external silicone perimeter is completely free of imperfections.

Set up

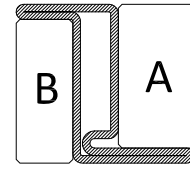
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, you should verify the proper behaviour of the window/door (easiness of opening/closing, stability of the open leaf, etc.), the correctness of joints and overlapping areas between opening leaves and fixed frames, the proper positioning of gaskets and seals, the drainage of frames with weep system and the absence of any aesthetic defects on the frame and glass surfaces.



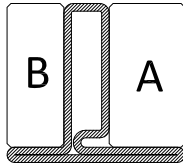
PR2461



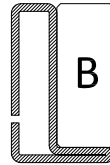
PR2462



PR2463



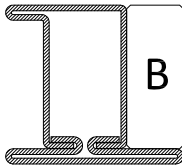
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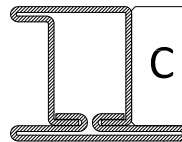
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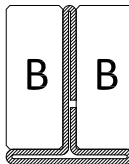
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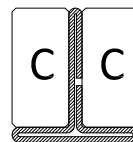
PR2455



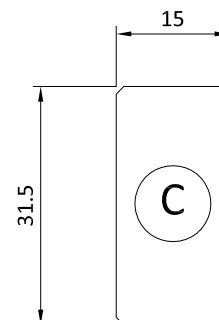
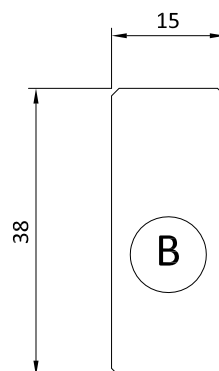
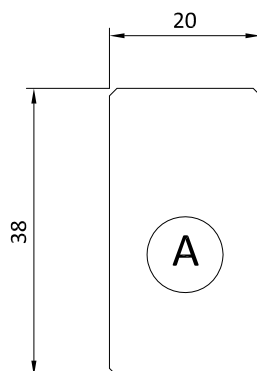
PR2474

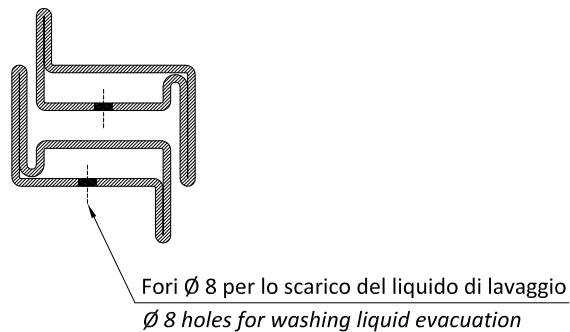
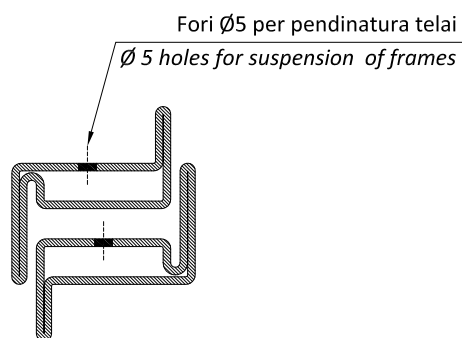
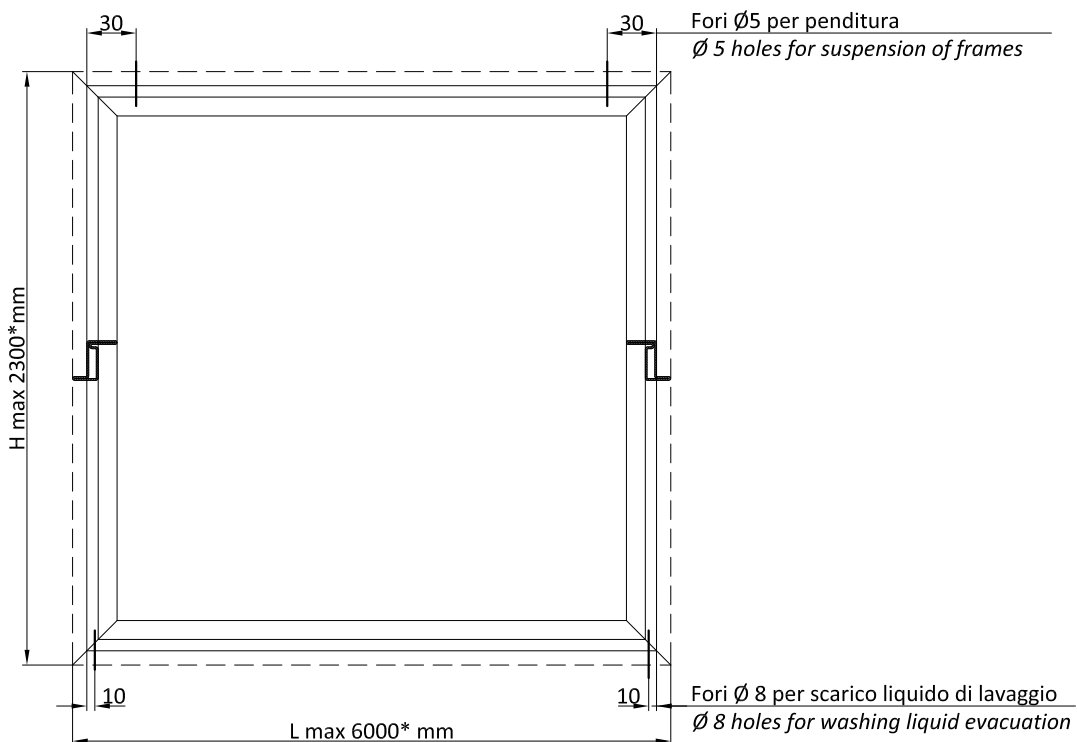


PR2454



PR2464





* Dimensioni massime da verificare con l'impianto di verniciatura scelto
Maximum dimensions to be checked with the chosen painting plant

Troncatricecaratteristiche minime della macchina

- Potenza: 1.8 – 2.5 kW;
- Possibilità di taglio a 45° nei due sensi e a 90°;
- Velocità di taglio ideali: 60-90 giri/min per acciaio;
- Capacità di taglio: 150 x 80 mm a 90°;
100 mm taglio a 45°.

caratteristiche della lama

- Lama da 350 mm con spessore 2.5 mm;
- N° denti: - 300 per tagli a 45°;
- 350 per tagli a 90°;
- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle lame).

Pantografocaratteristiche minime della macchina

- Mandrino con velocità regolabile 2000-11000 giri/min;
- Struttura in ghisa adatta al taglio acciaio;
- Testata pesante per limitare le vibrazioni;
- Chiusura del profilo da lavorare con morse.

caratteristiche minime delle frese

- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle frese);
- Frese a 4 denti;
- Frese con diametro 5 mm per le lavorazioni di scasso.

CutterMinimum requirements for the use of the machine

- Power: 1.8 – 2.5 kW;
- Possibility of cutting at 45° in both directions and at 90°;
- Ideal cutting speed: 60-90 rpm for steel;
- Cutting capability: 150 x 80 mm at 90°;
100 mm cut at 45°.

Blade specifications

- 350 mm blade with a 2.5 mm thickness;
- Number of teeth: 300 for 45° cut;
350 for 90° cut;
- Material: HSS (please verify availability of longer lasting material on the market).

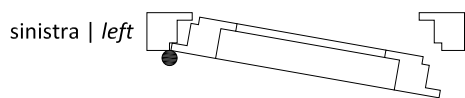
PhantographMinimum requirements for the use of the machine

- Mandrel with a 2000-11000 rpm adjustable speed;
- Machine should be made of cast iron suitable for steel cutting;
- Heavy head in order to limit vibrations;
- Secure the profile to be processed in jaws.

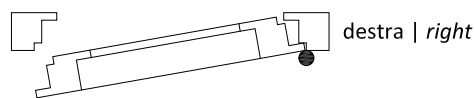
Minimum requirements for the use of a milling machine

- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

APERTURA INTERNA | INWARD OPENING



vista interna | inside view

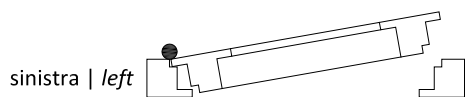


vista interna | inside view

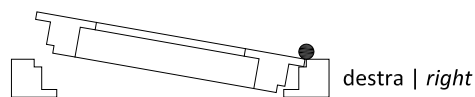
Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2463
AC 2649	P.2463
Serratura Lock	
AC 2493	P.2463
AC 2494	P.2463
Scatola serratura Lock cover box	
AC 2497	P.2463
AC 2498	P.2463

Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2463
AC 2650	P.2463
Serratura Lock	
AC 2493	P.2463
AC 2494	P.2463
Scatola serratura Lock cover box	
AC 2496	P.2463
AC 2498	P.2463

APERTURA ESTERNA | OUTWARD OPENING



vista interna | inside view



vista interna | inside view

Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2462
AC 2650	P.2462
Serratura Lock	
AC 2493	P.2462
AC 2494	P.2462
Scatola serratura Lock cover box	
AC 2497	P.2462
AC 2498	P.2462

Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2462
AC 2649	P.2462
Serratura Lock	
AC 2493	P.2462
AC 2494	P.2462
Scatola serratura Lock cover box	
AC 2496	P.2462
AC 2498	P.2462

1. Controllo materiale in arrivo / *Incoming equipment Control*

Verifica visiva dell'intergrità delle barre con attenzione a: / *Profiles wholeness visual control paying attention to:*

- Strisci profondi / *Deep scratches* verifica visiva / *visual control*
- Botte e avvallamenti sulla superficie / *Bumps and dips on surface* verifica visiva / *visual control*
- Rettilineità barre / *Profiles straightness tolerance* 0,002 x L
- Svergolamento / *Profiles twist tolerance* 1° x m

2. Taglio barre e controllo barre / *Cut and Control of profiles*

- Misura lunghezza / *Length measurement* ±0.5 mm
- Verifica 45° / *45° Control* ± 1°
- Verifica 90° / *90° Control* ± 1°

3. Lavorazioni su barra / *Section processing*

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648 sez 4.3.7		AC2648 sez 4.2.9	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649/50 sez 4.2.6		AC2649/50 sez 4.2.8	
Fori e asole per serratura e incontri <i>Lock and strike slots and holes</i>	AC2493 sez 4.2.15	AC2494 sez 4.2.16	AC2493 sez 4.2.15	AC2494 sez 4.2.17
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2653 sez 4.2.3-4		AC2653 sez 4.2.3-4	
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2440 sez 4.2.11-12	AC2621GB/GC sez 4.2.10	AC2440 sez 4.2.11-12	AC2621GB/GC sez 4.2.10
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.2.1-2		sez 3.2.1-2	

4. Assiemaggio / *Assembly*

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
<u>Costruzione telai / <i>Frame assembly</i></u>				
Saldatura / <i>Welding</i>	- sez 4.3.1-3		- sez 4.3.1-3	
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2653 sez 4.2.3-4		AC2653 sez 4.2.3-4	
<u>Applicazione accessori / <i>Accessories installation</i></u>				
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648 sez 4.3.7		AC2648 sez 4.2.9	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649/50 sez 4.2.6		AC2649/50 sez 4.2.8	
Saldatura cerniere a saldare <i>Hinge welding</i>	AC2631/32 sez 4.3.5		AC2631/32 sez 4.3.6	
Lavorazione per paraspiffero automatico <i>Automatic door bottom seal installation holes</i>	AC2436 sez 4.2.13		AC2436 sez 4.2.14	

5. Preparazione per verniciatura / *Preparation for the powder coating*

- | | |
|--|-----------|
| a. Fori su telaio per scarichi liquidi pretrattamento
<i>Holes on frame for the drainage of pretreatment liquid</i> | sez 5.1.4 |
| b. Marcatura e imballo telai esterni e ante
<i>External frames and leafs branding and packing</i> | - |
| c. Marcatura e imballo telai fermavetro
<i>Glazingbeads frames branding and packing</i> | - |
| d. Marcatura e imballo profili complementari
<i>Additional profiles branding and packing</i> | - |
| e. Imballo scarichi acqua e cerniere
<i>Accessories (water drip, hinges) branding and packing</i> | - |

6. Applicazione accessori / *Hardware and accessories installation*
Porta / *Door*
- I. Montaggio cerniere / *Hinges installation* sez 4.2.6-9
 - II. Montaggio serratura e incontri / *Lock and strikes installation* sez 4.2.15-17
 - III. Applicazione paraspiro automatico /
Automatic door bottom seal installation holes sez 4.2.13-14
 - IV. Montaggio catenaccio / *Flush bolt installation* sez. 4.2.10-11
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
7. Vetrazione / *Glazing*
- a. Applicazione clips fermavetro / *glazing bead clips installation* sez 2.6.1-7
 - b. Applicazione guarnizione esterna / *External glazing gasket installation*
 - c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* sez 4.5.1
 - d. Inserimento fermavetri / *Glazing beads application*
 - e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
 - f. Verifica corretta compressione guarnizione / *Control of the right compression of the gasket*
8. Controlli su prodotto finito / *Control on finished element*
- a. Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
 - c. Verifica funzionamento maniglia serratura / *Control of hardware functioning*
 - d. Verifica finitura superficiale / *Control of surface finishing*
9. Controlli dopo la posa / *Controls after installation*
- a. Verifica corretta installazione telai: squadra, piombo, misure /
Control of alignment and plumbing of frame and leaf
Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
Verifica funzionamento maniglia serratura / *Control of hardware functioning*
 - c. Verifica finitura superficiale / *Control of surface finishing*

MATERIALI**ACCIAIO DECAPATO****Materiale**

Profilati ricavati da nastro di lamiera di acciaio decapato DC01 laminato a freddo, caratterizzato la limiti massimi di snervamento e di rottura ed allungamenti minimi.

Caratteristiche fisiche

Fe P01 | C 0.12% - Mn 0.60% - P 0.045% - S 0.045%

Norme di riferimento

EN 10130:2007

Trattamenti superficiali

Finitura normale: La finitura superficiale ha rugosità $0.6 \mu\text{m} < Ra \leq 1.9 \mu\text{m}$ e il profilo viene fornito con una live oliatura.

MATERIALS**PICKLED STEEL****Materials**

Profiles made from cold-rolled pickled steel sheet coils DC01, characterized by maximum yield and breaking limits and minimum elongations

Physical features

Fe P01 | C 0.12% - Mn 0.60% - P 0.045% - S 0.045%

Norms of reference

EN 10130:2007

Surface treatment

Normal finish: The surface finish has a roughness of $0.6 \mu\text{m} < Ra \leq 1.9 \mu\text{m}$, profiles are supplied slightly oiled

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