

# EBE Style

CATALOGO  
TECNICO  
TECHNICAL  
CATALOGUE

**METALFORM**



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# METALFORM

## CICLO PRODUTTIVO E DI VERIFICA QUALITÀ PRODUCTION AND QUALITY AUDIT CYCLE

### 1. Controllo materiale in arrivo / *Incoming equipment check*

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

- Strisci profondi / *Deep scratches* verifica visiva / *visual check*
- Botte e avvallamenti sulla superficie / *Bumps and dips on surface* verifica visiva / *visual check*

### 2. Taglio barre e controllo barre / *Rods Cutting and checking*

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

### 3. Lavorazioni / *Processing*

#### **lavorazioni su barra - porta** **Rod - door processing**

	PBE001	PBE004	PBE0011	PBE0012	PBE0013	PBE0021
fori squadrette interne <i>holes for Internal bracket</i>	V	-	V	V	V	V
fori squadrette allineamento <i>holes for alignment bracket</i>	V	-	V	V	V	V
fori fissaggio cavallotti <i>holes for butt joint fixing</i>	-	V	-	-	-	-
fori areazione <i>holes for ventilation</i>	-	-	-	V	V	-
fori scarico acqua <i>holes for drip</i>	V	V	-	V	V	-
fori fissaggio a muro <i>holes for wall mounting</i>	V	-	V	-	-	V
fori inserimento serratura <i>holes for lock</i>	-	-	-	V	V	-
fori inserimento riscontri serratura <i>holes for lock strikes</i>	-	-	V	V	V	V
fori inserimento catenaccio <i>holes for bold</i>	-	-	-	V	V	-
fori fissaggio cerniera ACE033B <i>holes for ACE033B hinge fixing</i>	-	-	-	V	-	V
fori fissaggio cerniera AC1033B <i>holes for AC1033B hinge fixing</i>	-	-	V	-	V	-
fori fissaggio rostri <i>holes for Check points fixing</i>	-	-	V	V	V	V

**lavorazioni su barra - finestra**  
**Rod - window processing**

	PBE201	PBE204	PBE220	PBE221	PBE222	PBE233
fori squadrette interne <i>holes for internal brackets</i>	V	-	-	V	-	V
fori squadrette allineamento <i>holes for alignment brackets</i>	V	-	-	V	-	V
fori fissaggio cavallotti <i>holes for butt joint fixing</i>	-	V	-	-	V	-
fori areazione <i>holes for ventilation</i>	-	-	-	-	-	V
fori scarico acqua <i>holes for drip</i>	V	V	-	-	-	-
fori inserimento cremonese <i>holes for spagnolette</i>	-	-	-	-	-	V
fori incontri meccanismo AR <i>fitting holes for return mechanism</i>	-	-	-	V	V	-
fori cerniere a scomparsa <i>holes for concealed hinges</i>	-	-	-	V	-	V
fori cerniere <i>holes for hinges</i>	-	-	-	V	-	V
asportazione dentello poliuretano <i>remove polyurethane indent</i>	-	-	-	-	-	V
fori fissaggio a muro <i>holes for wall mounting</i>	V	-	-	V	-	-

**4. Assiemaggio / Assembly****a. Porta / door**

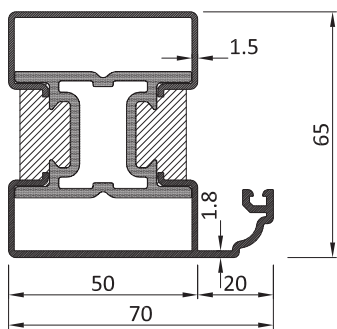
- |  |                           |
|--|---------------------------|
| i. Inserimento rinforzi cerniere e rostri / <i>hinge stiffener and check point</i> | nota tecnica: 7.13 - 7.16 |
| ii. Inserimento squadrette / <i>brackets</i>                                       | nota tecnica: 7.2 - 7.8   |
| iii. Sigillatura interna / <i>internal seal</i>                                    | nota tecnica: 7.1         |
| iv. Saldatura sezione / <i>section joint</i>                                       | nota tecnica: 7.2 - 7.8   |
| v. Fissaggio squadrette / <i>brackets fixing</i>                                   | nota tecnica: 7.2 - 7.8   |
| vi. Saldatura accessori inversione battuta / <i>Inverting closure strip joint</i>  | nota tecnica: 7.10        |
| vii. Fissaggio/saldatura traversi / <i>transom joint</i>                           | nota tecnica: 7.9         |
| viii. Saldatura rinforzi aletta esterna / <i>external glazing stiffener joint</i>  | nota tecnica: 7.2 - 7.8   |

**b. Finestra / window**

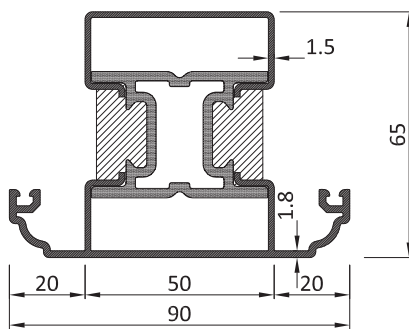
- |   |                         |
|---|-------------------------|
| i. Inserimento squadrette / <i>brackets assembly</i>                            | nota tecnica: 6.2 - 6.3 |
| ii. Sigillatura interna / <i>internal seal</i>                                  | nota tecnica: 6.1       |
| iii. Saldatura sezione / <i>section joint</i>                                   | nota tecnica: 6.2 - 6.3 |
| iv. Fissaggio squadrette / <i>brackets fixing</i>                               | nota tecnica: 6.2 - 6.3 |
| v. Fissaggio/saldatura traversi / <i>transom joint</i>                          | nota tecnica: 6.5 - 6.6 |
| vi. Saldatura rinforzi aletta esterna / <i>external glazing stiffener joint</i> | nota tecnica: 6.2 - 6.3 |



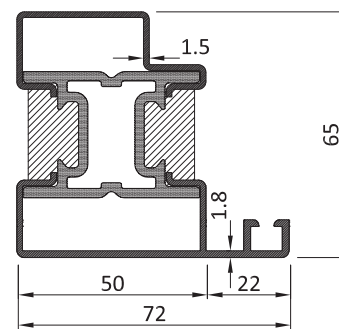
- |      |   |                               |
|------|---|-------------------------------|
| 5.   | Lavorazione per brunitura / <i>process for burnishing</i>   |                               |
| a.   | Fori su telaio per scarichi acqua brunitore / <i>holes on frame for draining</i>  | nota tecnica: 10.2 - 10.3     |
| b.   | Marcatura e imballo telai esterni e ante /<br><i>external frames and leafs branding and packing</i>                             | -                             |
| c.   | Marcatura e imballo telai fermavetro / <i>Glazing beads branding and packing</i>  | -                             |
| d.   | Marcatura e imballo dividi vetro / <i>Muntin bars branding and packing</i>  | -                             |
| e.   | Imballo scarichi acqua / <i>Metal drips packing</i>   | -                             |
| 6.   | Applicazione accessori e sigillature / <i>hardware and seals application</i>  |                               |
| a.   | Porta / <i>door</i>   |                               |
| i.   | Montaggio cerniere / <i>hinges assembly</i>   | nota tecnica: 7.13 - 7.16     |
| ii.  | Montaggio rostri / <i>check points assembly</i>   | nota tecnica: 7.16            |
| iii. | Montaggio catenaccio / <i>bold assembly</i>   | nota tecnica: 7.12            |
| iv.  | Applicazione serratura e incontri / <i>lock and strike plate application</i>  | nota tecnica: 7.11            |
| v.   | Montaggio guarnizioni di battuta / <i>weatherstrip assembly</i>   | nota tecnica: 2.1             |
| b.   | Finestra e fissi / <i>window and fixes</i>  |                               |
| i.   | applicazione e sigillatura guarnizioni giunto aperto /<br><i>weatherstrips for open joint assembly</i>                          | nota tecnica: 6.8             |
| ii.  | applicazione scarichi acqua / <i>metal drips assembly</i>   | nota tecnica: 6.7 - 6.8; 7.17 |
| iii. | Montaggio ferramenta anta ribalta / <i>hardware installation for<br/>hopper window</i>  | nota tecnica: 6.12 - 6.14     |
| iv.  | Montaggio guarnizioni di battuta / <i>weatherstrips assembly</i>  | nota tecnica: 2.1             |
| 7.   | Vetrazione / <i>Glasses</i>   |                               |
| a.   | Applicazione clips fermavetro / <i>clips for glazing beads application</i>  | nota tecnica: 2.1             |
| b.   | Sigillatura angolare fermavetro esterno / <i>corner sealing for external<br/>glazing bead</i>                                   | nota tecnica: 6.2 - 6.3       |
| c.   | Inserimento fermavetri / <i>glazing beads assembly</i>  | nota tecnica: 2.1             |
| d.   | Applicazione profilo plastico per dividivetro GU2030E / <i>securing of<br/>plastic profiles GU2030E muntin bars</i>             | nota tecnica: 2.4             |
| e.   | Applicazione dividivetro / <i>securing of muntin bars</i>   | nota tecnica: 2.4             |
| 8.   | Controlli su prodotto finito / <i>checks on the finished product</i>  |                               |
| a.   | Verifica planarità esterna telai / <i>external flatness of the frames</i>   | -                             |
| b.   | Verifica distanza interna ed esterna tra anta e telaio / <i>check internal<br/>and external distance between leaf and frame</i> | nota tecnica: 10.1            |
| c.   | Verifica sigillature per scarico acqua / <i>check seals on metal drips</i>  | -                             |
| d.   | Verifica funzionamento cremonese/maniglia serratura   | -                             |
| e.   | Verifica brunitura superficiale / <i>surface burnishing check</i>   | -                             |
| 9.   | Installazione / <i>installation</i>   | -                             |



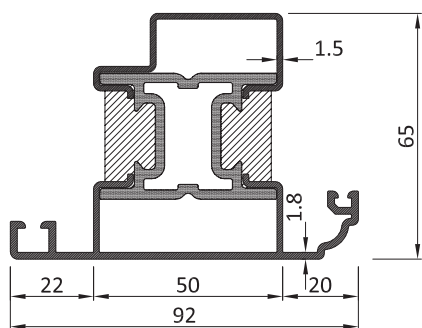
PBE001



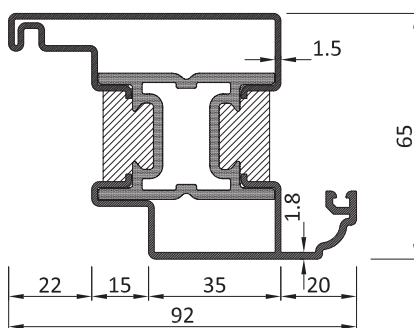
PBE004



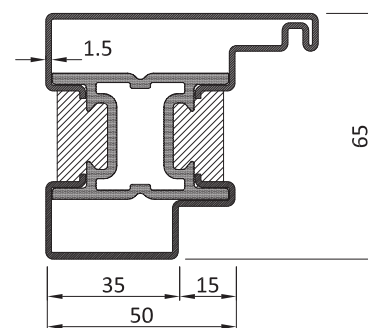
PBE011



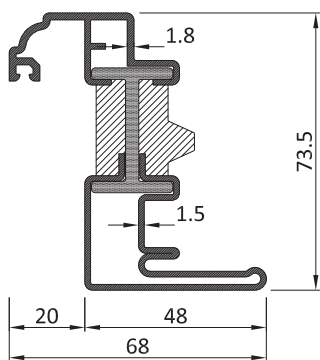
PBE012



PBE013

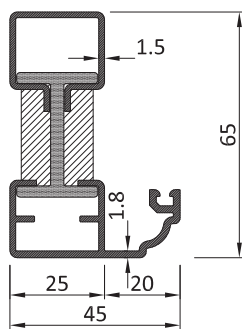


PBE021

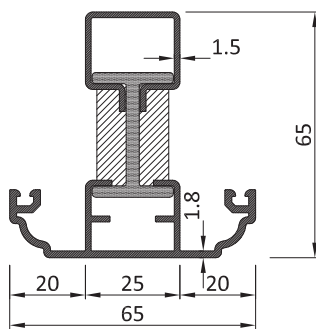


PBE233

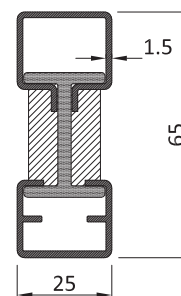
Profile n.	P Kg/m		A cm <sup>2</sup>	Jx cm <sup>4</sup>	Jy cm <sup>4</sup>	L. m	Profile n.	P Kg/m		A cm <sup>2</sup>	Jx cm <sup>4</sup>	Jy cm <sup>4</sup>	L. m
	ZN-CT I	OT						ZN-CT I	OT				
PBE001						6	PBE021						6
PBE004						6	PBE233						6
PBE011						6.5							
PBE012						6							
PBE013						6							



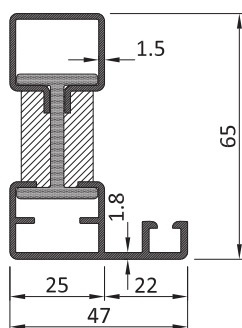
PBE201



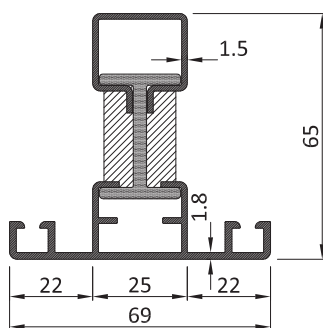
PBE204



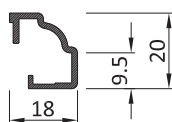
PBE220



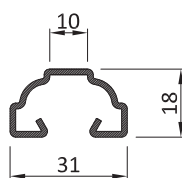
PBE221



PBE222

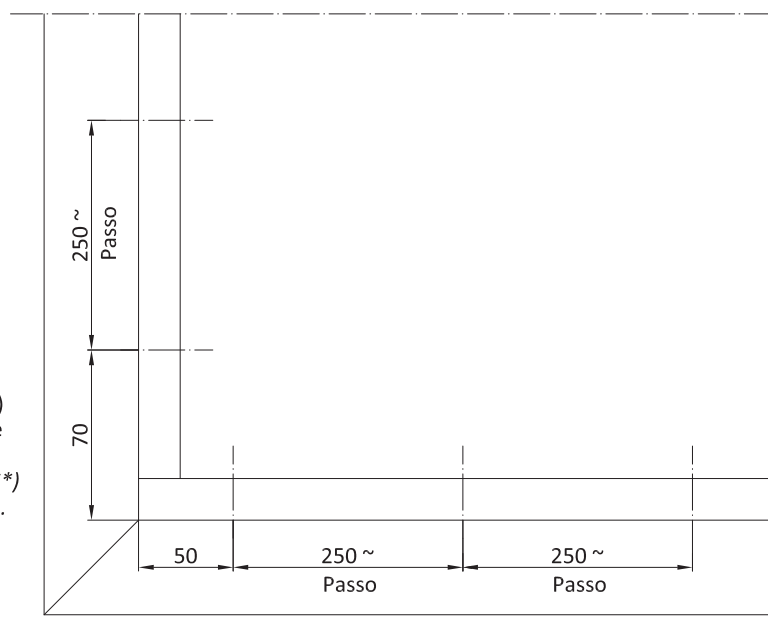
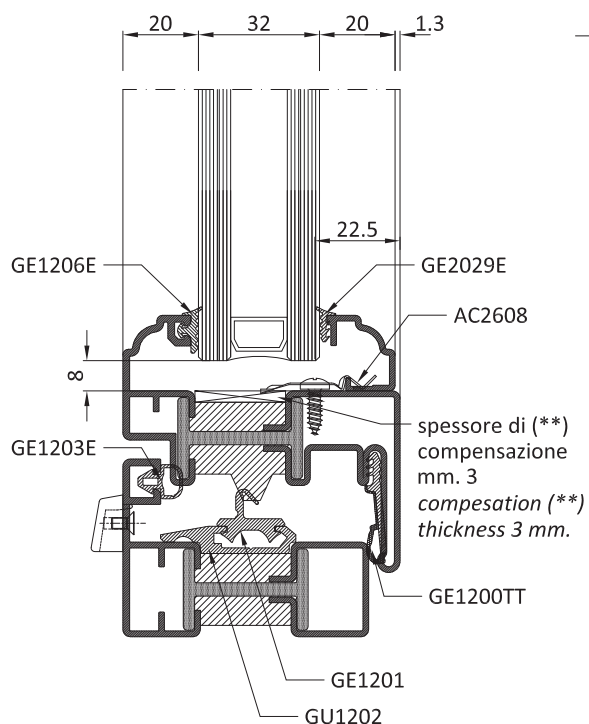


PBE028

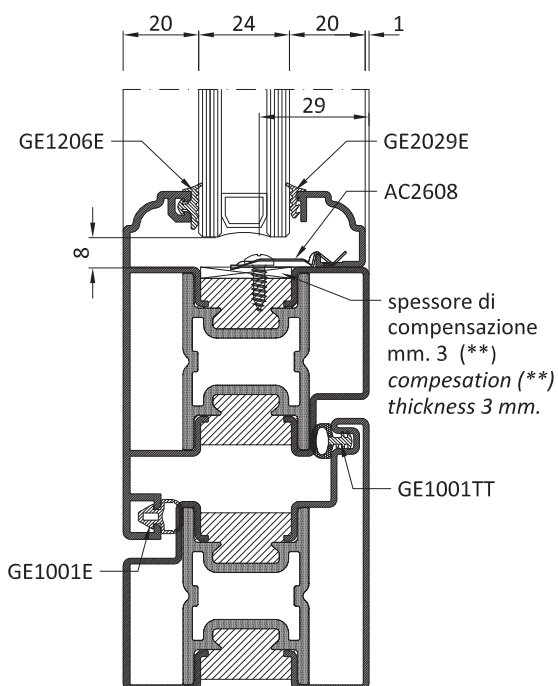
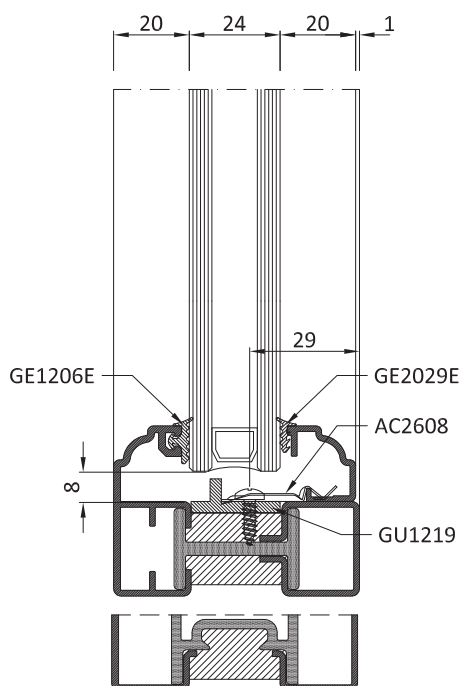


PBE030

Profile n.	P Kg/m	A cm <sup>2</sup>	Jx cm <sup>4</sup>	Jy cm <sup>4</sup>	L. m	Profile n.	P Kg/m	A cm <sup>2</sup>	Jx cm <sup>4</sup>	Jy cm <sup>4</sup>	L. m
	ZN-CT OT						ZN-CT OT				
PBE201					6.5	PBE222					6
PBE202					6	PBE028					6.5
PBE204					6.5	PBE030					6.5
PBE220					6						
PBE221					6						

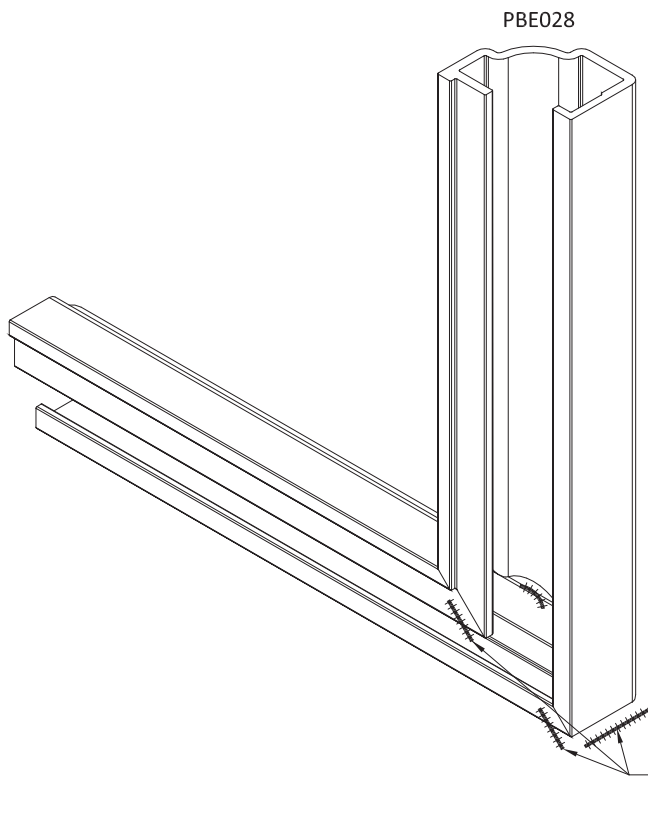
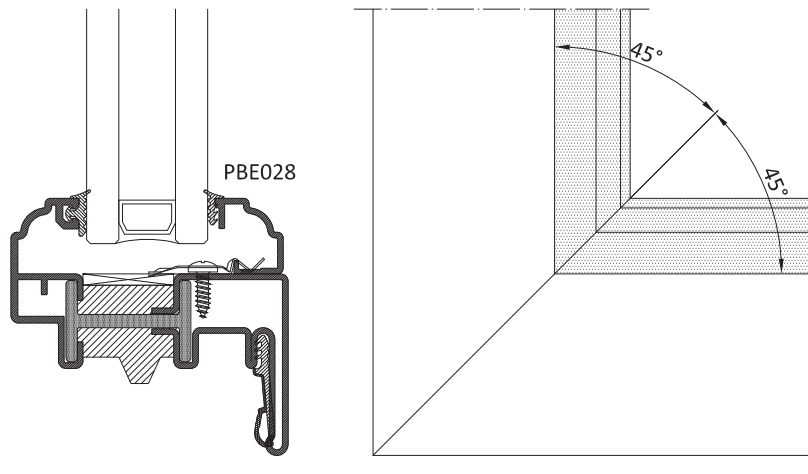


passo viti fissaggio fermavetro con clip AC2608 e vite TCR 3.5 x 9.5\*  
screws pitch for glazing beads fix with clip AC2608 and screw TCR 3.5 x 9.5\*



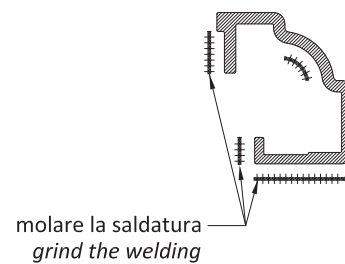
\* vite TC 3.5 x 9.5 non inclusa - screw TC 3.5 x 9.5 not included

\*\* spessore escluso - thickness not included



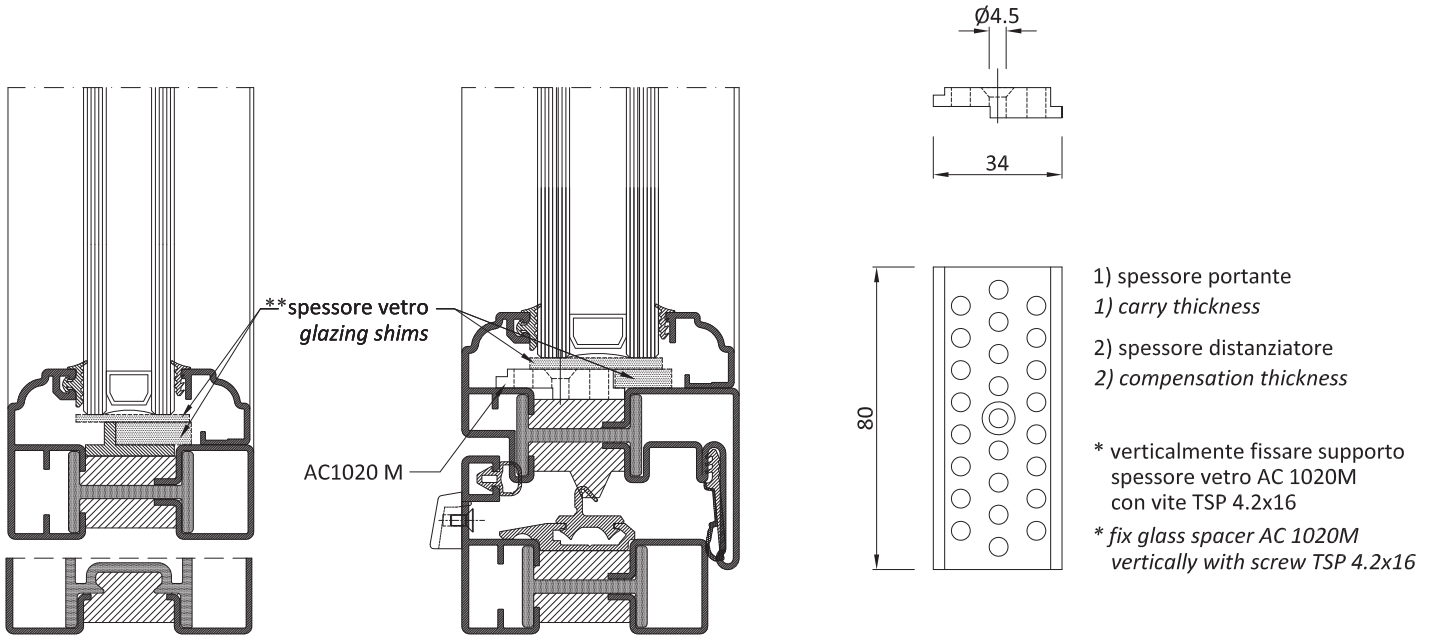
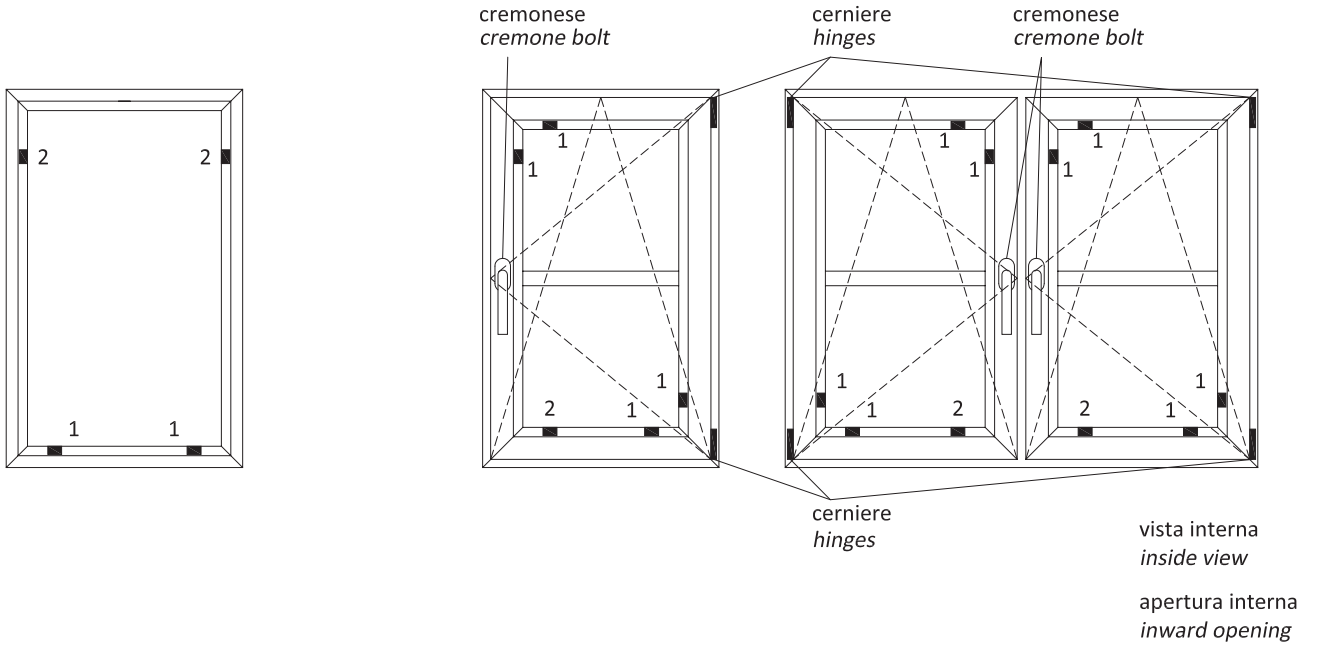
Saldare a TIG con materiale di riporto\*\* nelle zone indicate con +++++

TIG welding with filler material\*\* in the areas indicated with +++++



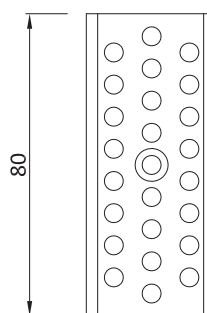
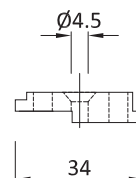
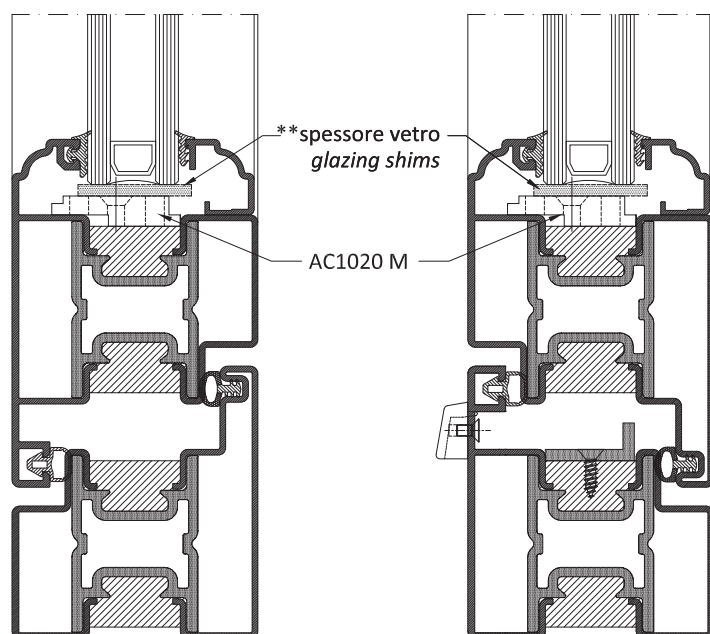
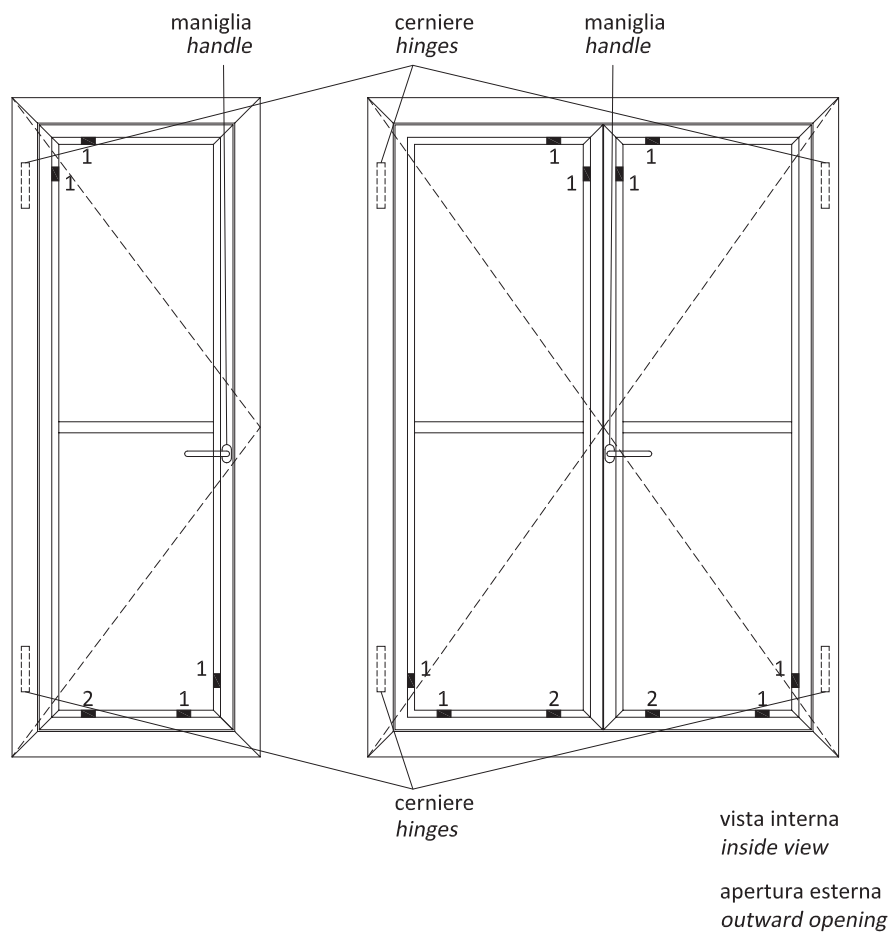
molare la saldatura  
grind the welding

\*\* filo  $\varnothing 1$  mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
wire  $\varnothing 1$  mm Cu Si 3 - classification AWS A5.7 ER Cu Si-A



\* vite TSP 4.2 x 16 non inclusa - screw TSP 4.2 x 16 not included

\*\* spessori vetro non inclusi - glass thickness not included

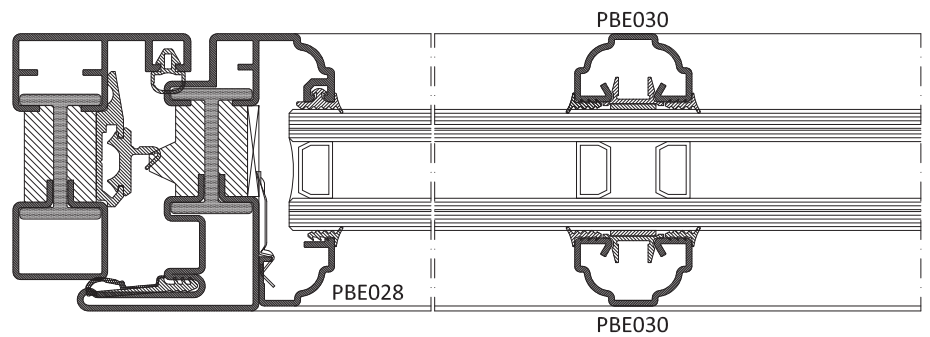
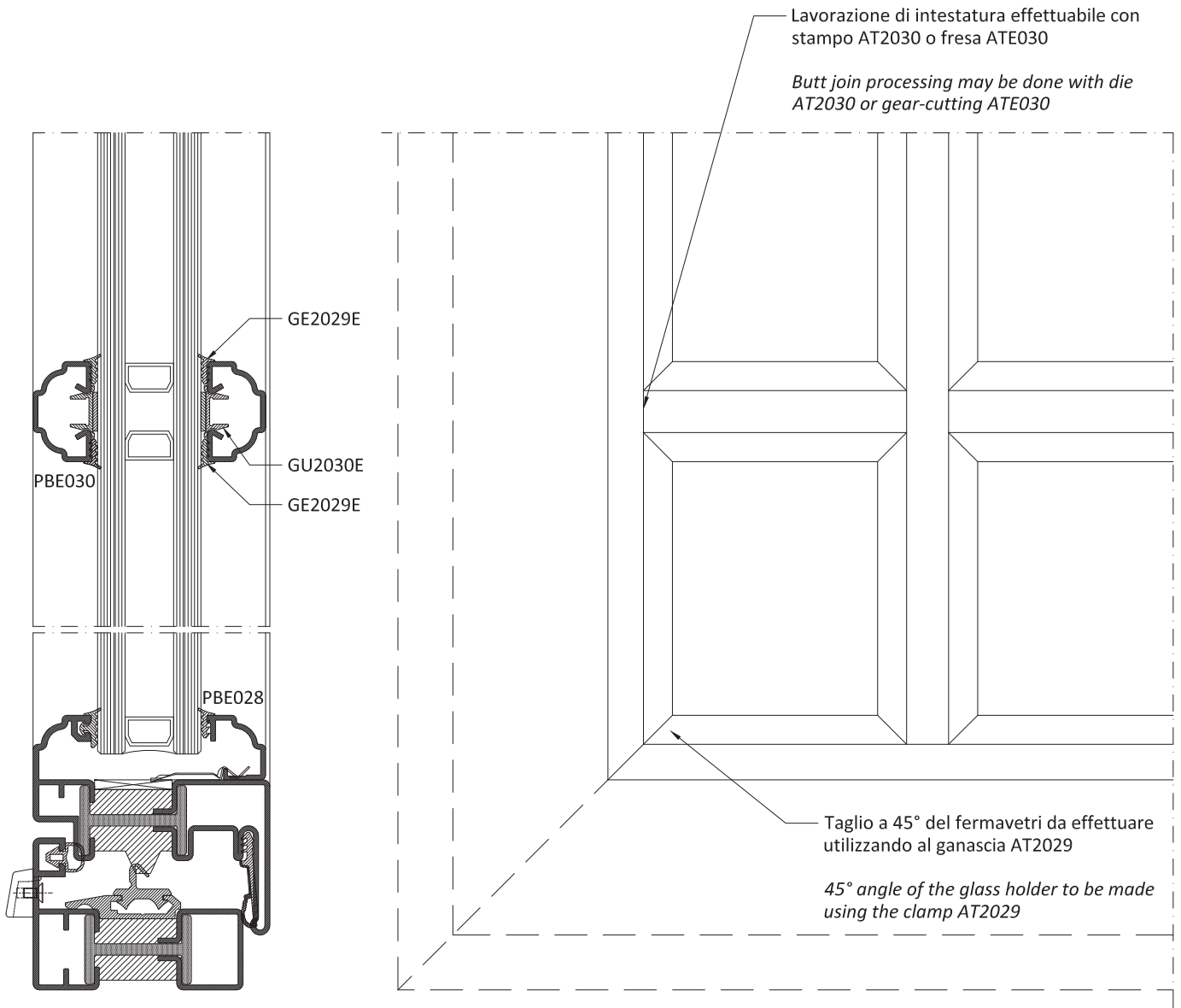


- 1) spessore portante  
1) carry thickness
- 2) spessore distanziatore  
2) compensation thickness

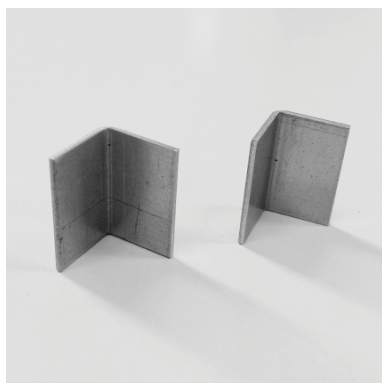
\* verticalmente fissare supporto spessore vetro AC 1020M con vite TSP 4.2x16  
\* fix glass spacer AC 1020M vertically with screw TSP 4.2x16

\* vite TSP 4.2 x 16 non inclusa - screw TSP 4.2 x 16 not included

\*\* spessori vetro non inclusi - glass thickness not included





**AC 1015B**

Kit inversione di battuta dx  
PBE012 - PBE013

*Kit for inverting RH closure  
strip on profiles PBE012 - PBE013*

**AC 1016B**

Kit inversione di battuta sx  
PBE012 - PBE013

*Kit for inverting LH closure  
strip on profiles PBE012 - PBE013*

**AC 1040**

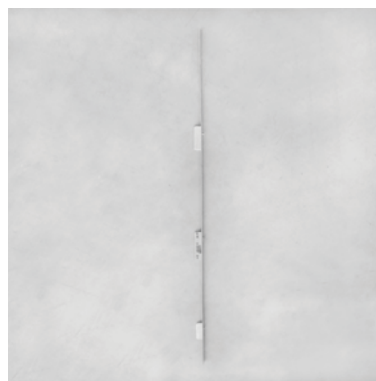
Kit chiusura seconda anta  
porte

*Second leaf closing kit*

**AC 1020M**

Supporto spessore vetro

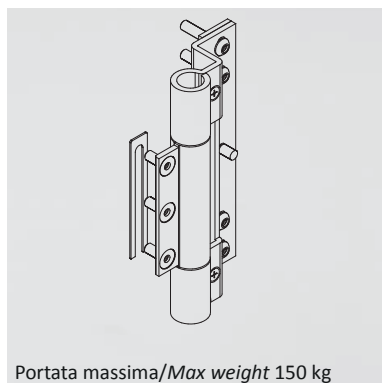
*Glass spacer*

**ACE 065D-S**

Serratura multipunto  
Altezza anta < 2600mm  
Multi closing point  
Leaf height < 2600 mm

**ACE 066D-S**

Serratura multipunto  
Altezza anta  
> 2600mm < 3000mm  
Multi closing point  
Leaf height  
> 2600mm < 3000mm

**AC 1033B**

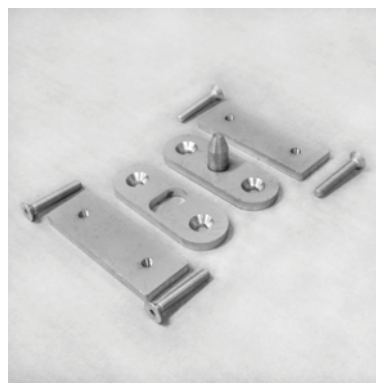
Cerniera a stilo a tre ali  
finitura brunita

Aperture interne

*Three-wings screw-in hinge  
brushed*

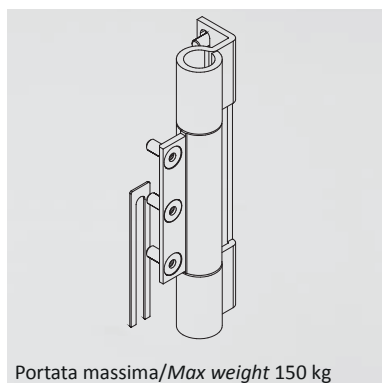
*Inward opening*

Portata massima/Max weight 150 kg

**AC 1080I**

Rostro di sicurezza  
in acciaio inox

*Check point  
in stainless steel*

**ACE 033B**

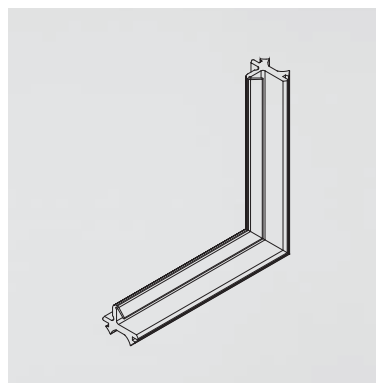
Cerniera a stilo a tre ali  
finitura brunita

Aperture esterne

*Three-wings screw-in hinge  
brushed*

*Outward opening*

Portata massima/Max weight 150 kg

**AC 1216**

Guarnizione d'angolo  
vulcanizzata per GE1201

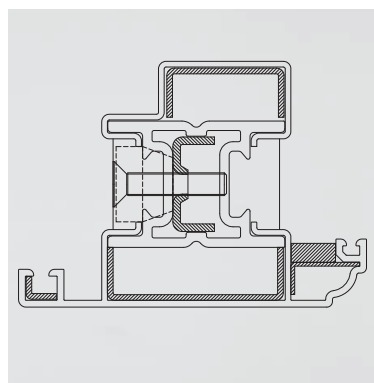
*Vulcanised corner weather  
strip for GE 1201*



## ACE 219B

Scarico acqua

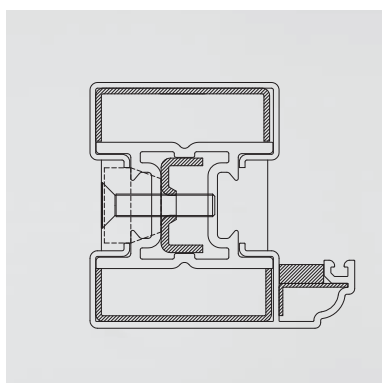
*Metal drip*



## ACE 1005I

Kit per giunzione angolo  
PBE012

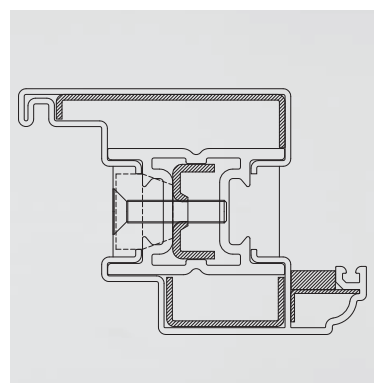
*Corner joint kit  
PBE012*



## ACE 1001I

Kit per giunzione angolo  
PBE001

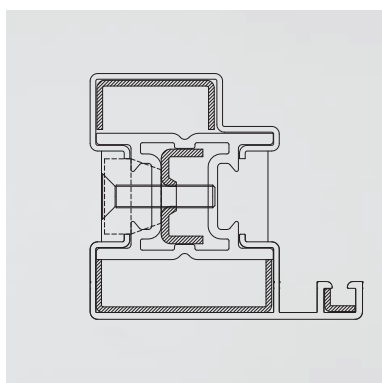
*Corner joint kit  
PBE001*



## ACE 1007I

Kit per giunzione angolo  
PBE013

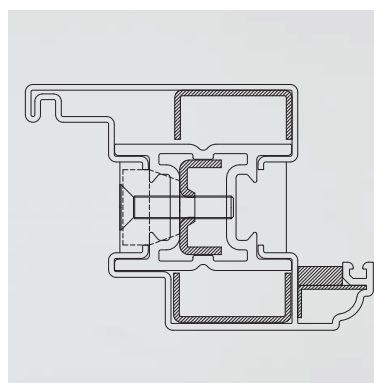
*Corner joint kit  
PBE013*



## ACE 1004I

Kit per giunzione angolo  
PBE011

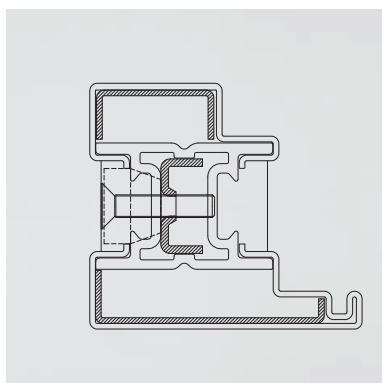
*Corner joint kit  
PBE011*



## ACE 1008I

Kit per giunzione angolo  
PBE012 - PBE013

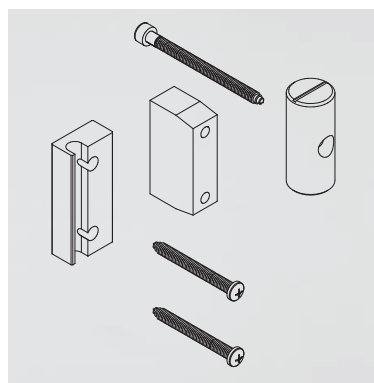
*Corner joint kit  
PBE012 - PBE013*



## AC 1004I

Kit per giunzione angolo  
PBE021

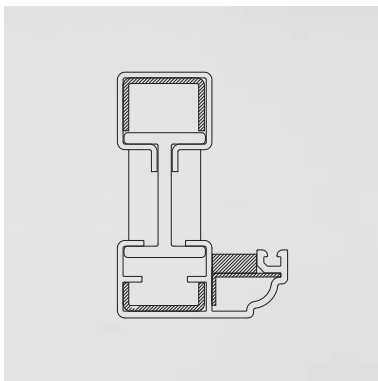
*Corner joint kit  
PBE021*



## ACE 1021

Cavallotto di giunzione  
per PBE004

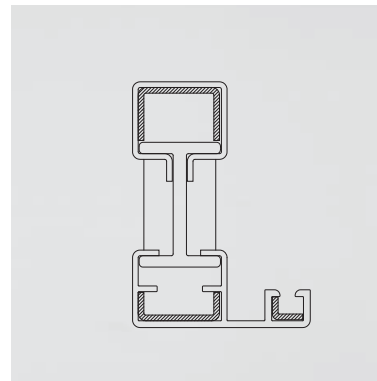
*Butt joint kit for  
PBE004*



**ACE 1201L**

Kit per giunzione angolo  
PBE201

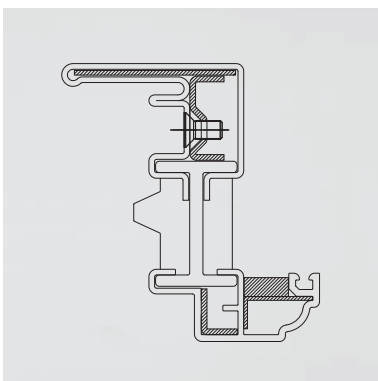
*Corner joint kit  
PBE201*



**ACE 1221L**

Kit per giunzione angolo  
PBE221

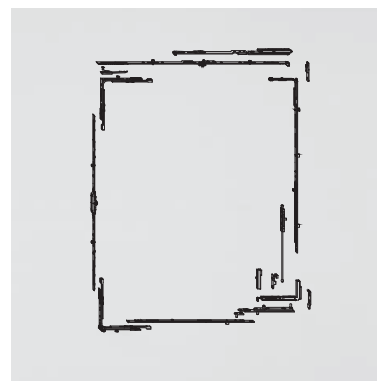
*Corner joint kit  
PBE221*



**ACE 1207L**

Kit per giunzione angolo  
PBE233

*Corner joint kit  
PBE233*

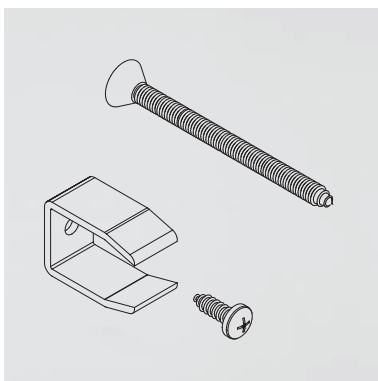


**AC 1281**

Meccanismo E-Look A/R Dx  
cerniere a scomparsa  
*E-Look RH tilt-turn  
with concealed hinges*

**AC 1282**

Meccanismo E-Look A/R Sx  
cerniere a scomparsa per  
profilo PBE233  
*E-Look LH tilt-turn  
with concealed hinges*



**ACE 1211L**

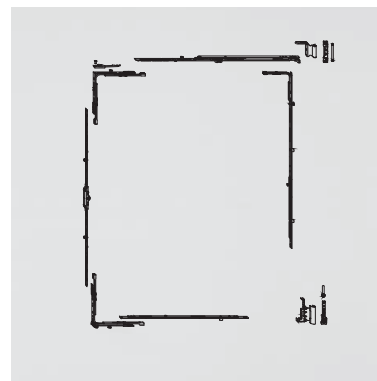
Cavallotto di giunzione  
per PBE222

*Butt joint kit for  
PBE222*

**ACE 1214L**

Cavallotto di giunzione  
per PBE204

*Butt joint kit for  
PBE204*

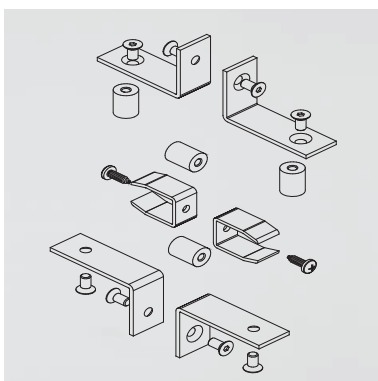


**AC 1291**

Meccanismo E-Look A/R Dx  
cerniere a sormonto INOX  
*E-Look RH tilt-turn with  
open hinges in stainless steel*

**AC 1292**

Meccanismo E-Look A/R Sx  
cerniere a sormonto INOX  
*E-Look RH tilt-turn with  
open hinges in stainless steel*



**ACE 214L**

Cavallotto di giunzione per  
PBE204-PBE204  
PBE222-PBE222

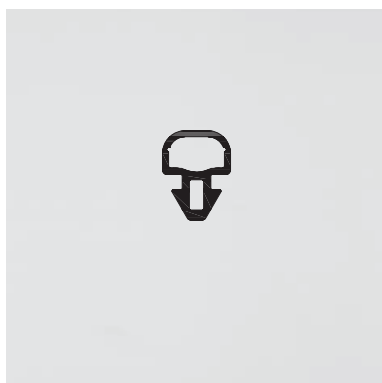
*Butt joint kit for  
PBE204-PBE204  
PBE222-PBE222*



**AC 2608**

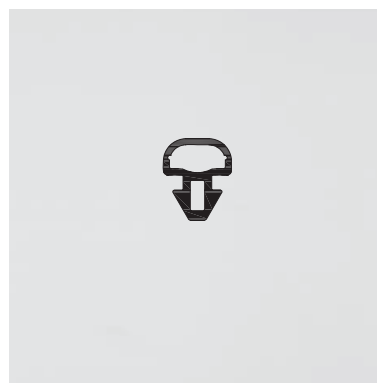
Clips per fissaggio fermavetro  
PBE028

*Clips for glazing bead  
PBE028*

**GE 1001E**

Guarnizione di battuta esterna porta  
per profilo PBE011 - PBE012

*External weather strip for door  
PBE011 - PBE012 profiles*

**GE 1203E**

Guarnizione di battuta esterna  
finestra per profilo PBE221

*Externale weather strip  
for window  
PBE221 profiles*

**GE 1001TT**

Guarnizione di battuta interna porta  
per profilo PBE013 - PBE021

*Internal weather strip for door  
PBE013 - PBE021 profiles*

**GE 1206E**

Guarnizione esterna vetro

*External glass weather strip*

**GE 1200TT**

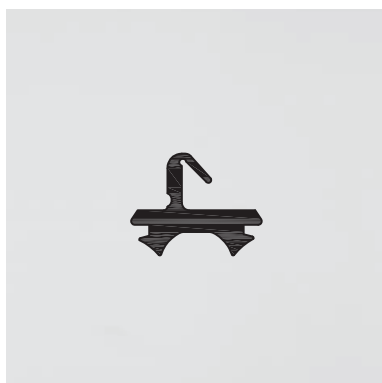
Guarnizione di battuta interna finestra

*Internal weather strip for window*

**GE 2029E**

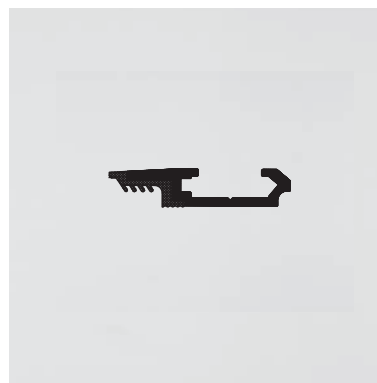
Guarnizione interna  
fermavetro

*Internal weather strip  
for glazing bead*

**GE 1201**

Guarnizione centrale di battuta  
per giunto aperto finestre

*Central open-joint weather strip  
for windows*

**GU 1202**

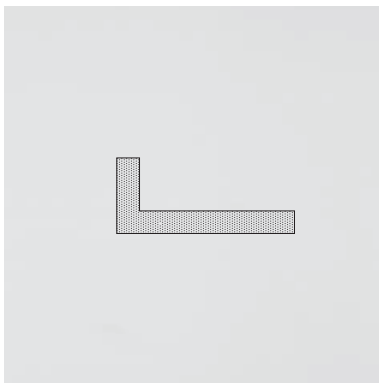
Estruso rigido PVC per  
GE1201

*Rigid extruded PVC section  
for GE1201*

**GU 2030E**

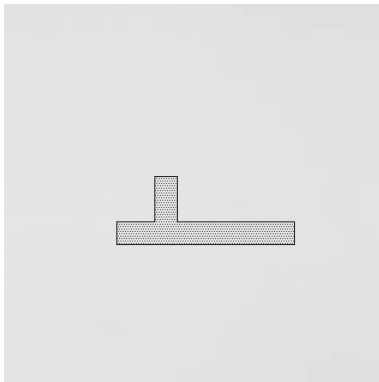
Profilo in PVC per  
fissaggio dividivetro  
PBE030

*PVC profile for fixing glass divider  
PBE030*

**GU 1085**

Profilo in PVC di tenuta  
acqua per porte  
apertura interna

*PVC profile for water content  
doors  
inward opening*

**GU 1219**

Profilo in PVC di tenuta  
acqua fissi

*PVC profile for water content  
fix*



**AT 1001**

Maschera per esecuzione fori di fissaggio squadretta su profili maggiorati

*Jig for drilling holes for corner plate on enlarged profiles*



**ATE 2030**

Stampo per intestatura profilo dividivetro PBE030

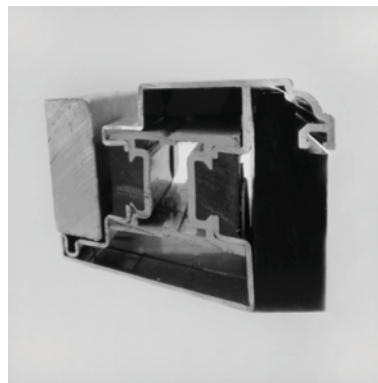
*Butt die for glass divider profile PBE030*



**AT 1233**

Stampo esecuzione fori fissaggio squadretta su profilo PBE233

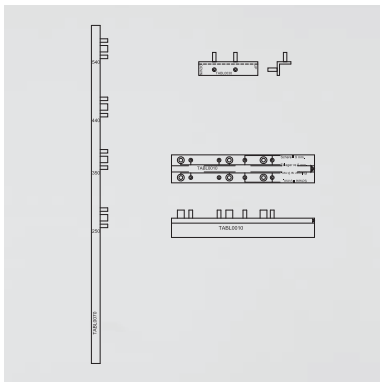
*Die for drilling holes for corner plate on profile PBE233*



**ATE 001**

Ganascia di taglio per profili PBE001 - PBE004 PBE011 - PBE012 - PBE013 PBE021 - PBE201 - PBE204 PBE221 - PBE222

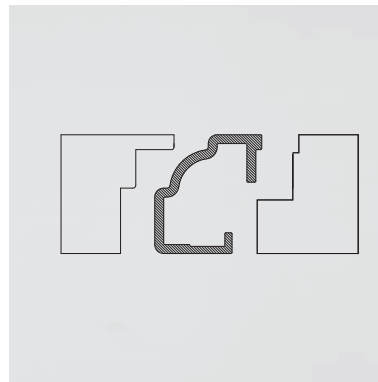
*Cutting jaws for profile PBE001 - PBE004 PBE011 - PBE012 - PBE013 PBE021 - PBE201 - PBE204 PBE221 - PBE222*



**AT 1241V**

Kit dime per A/R scomparsa AC1281 - AC1282

*Template kit for drilling holes for tilt-turn kit with concealed hinges*



**ATE 028**

Ganascia di taglio profilo fermavetro PBE028

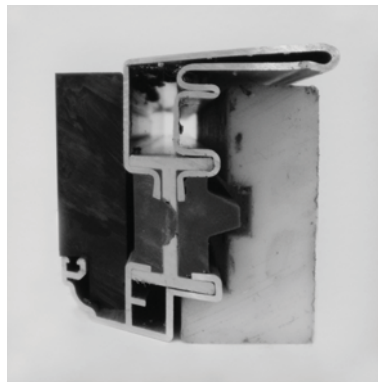
*Cutting jaws for glazin bead profile PBE028*



**AT 1242**

Dima foratura cerniera AC1291

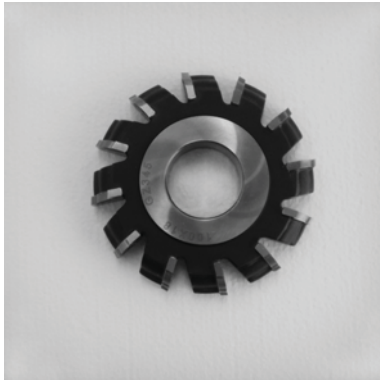
*Jig for drilling holes for tilt-turn hinges in stainless steel*



**ATE 233**

Ganascia di taglio per profili PBE233

*Cutting jaws for profile PBE233*

**ATE 004**

Fresa per profili  
PBE004 - PBE204

*Milling cutter for profiles  
PBE004 - PBE204*

**ATE 030**

Fresa per profilo  
PBE030

*Milling cutter for profiles  
PBE030*

**SL 0019**

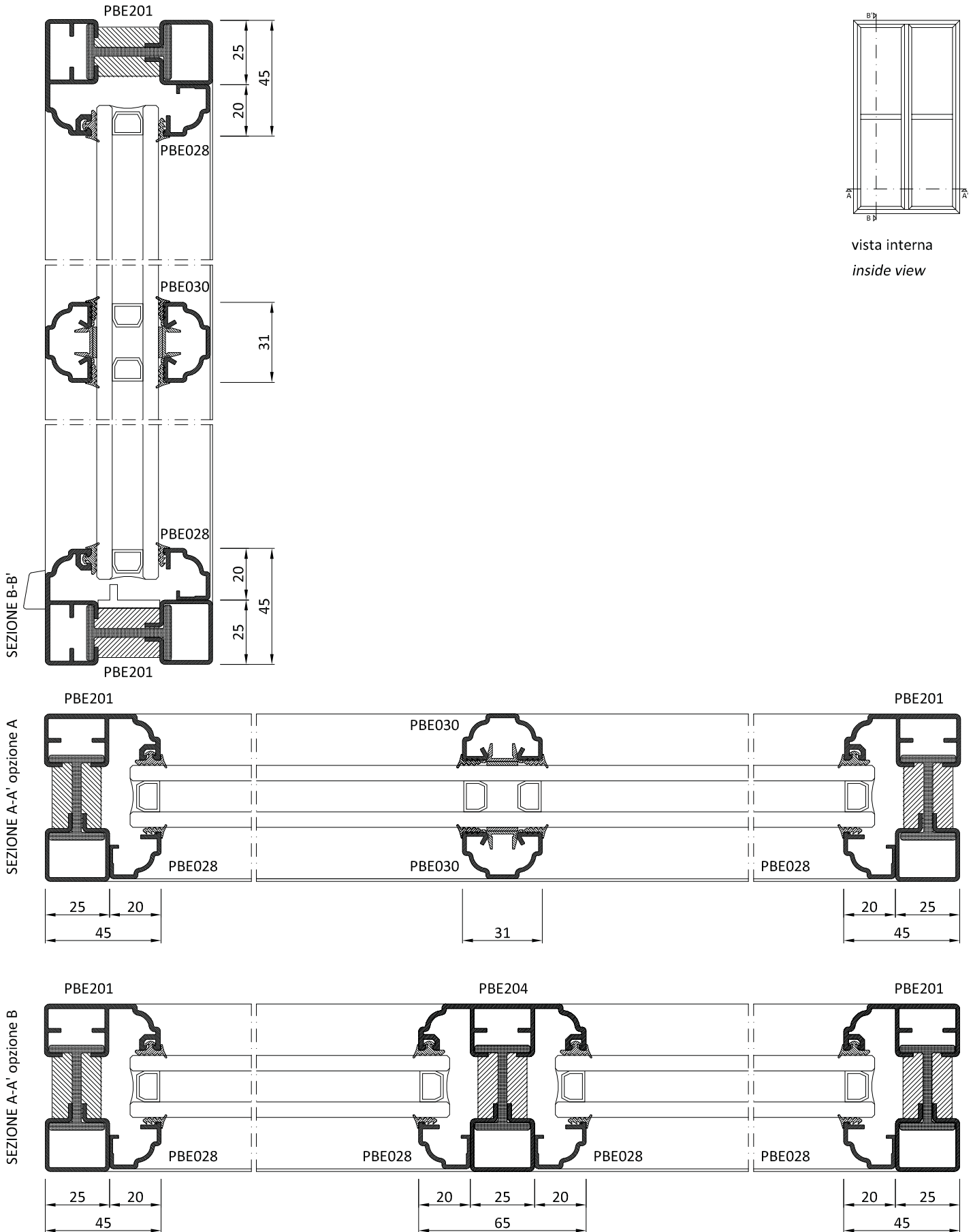
Sigillante a freddo per  
giunzione angoli e traversi

*Cold sealant for corner  
and transom joints*

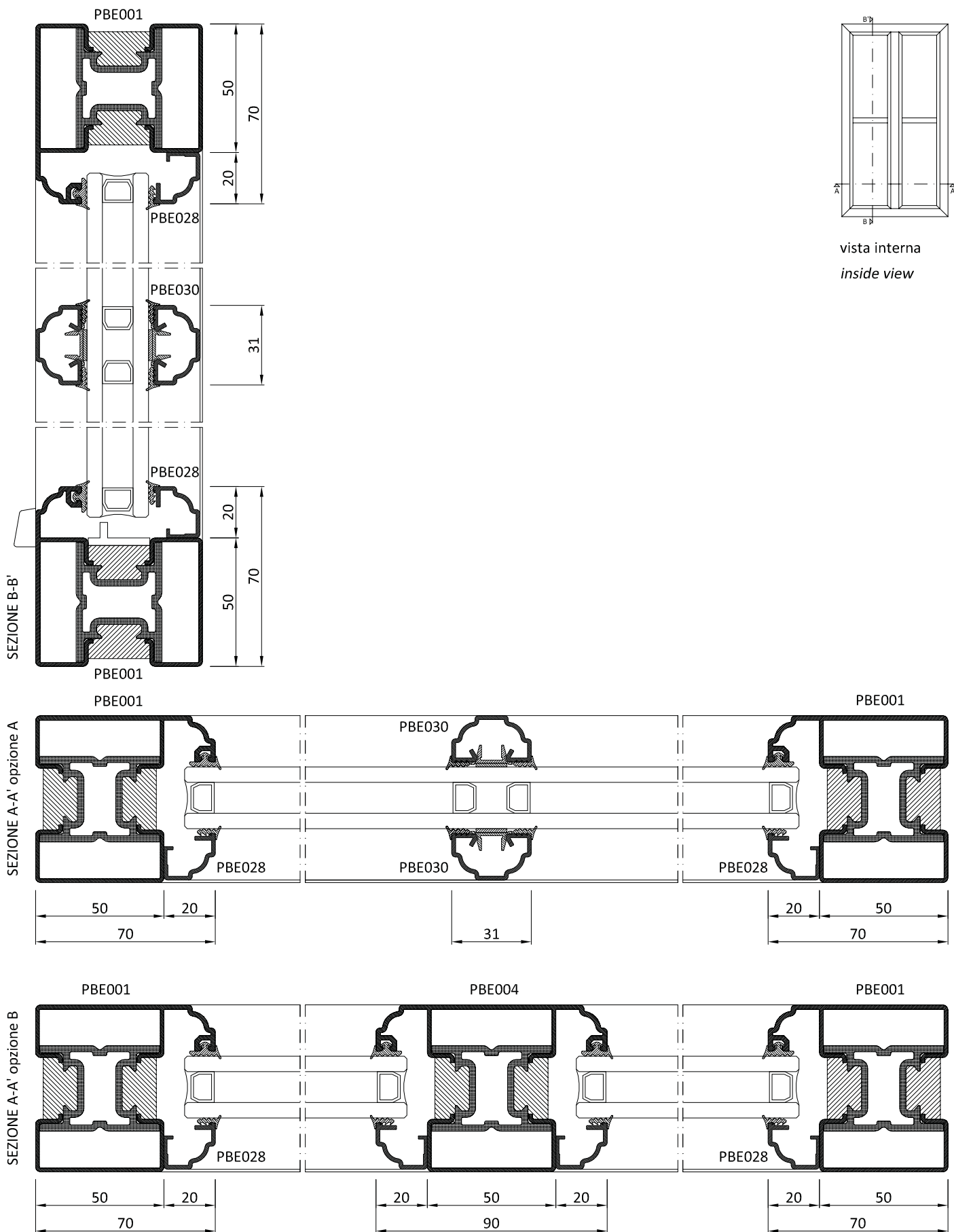
**SL 0021**

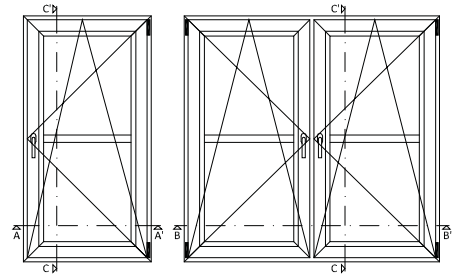
Silicone nero

*Black silicone*

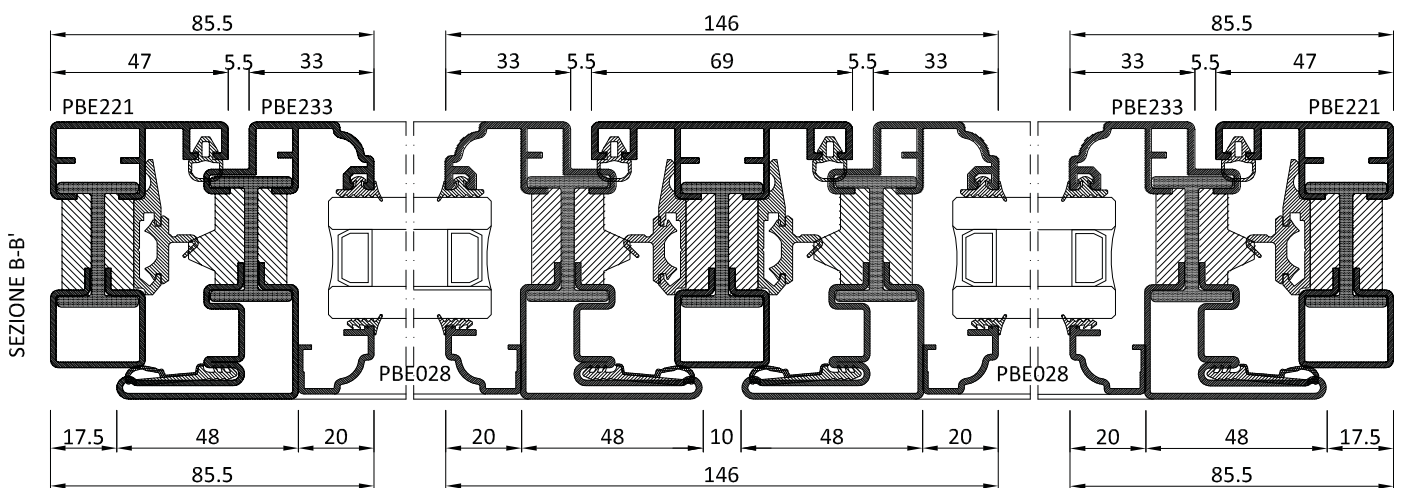
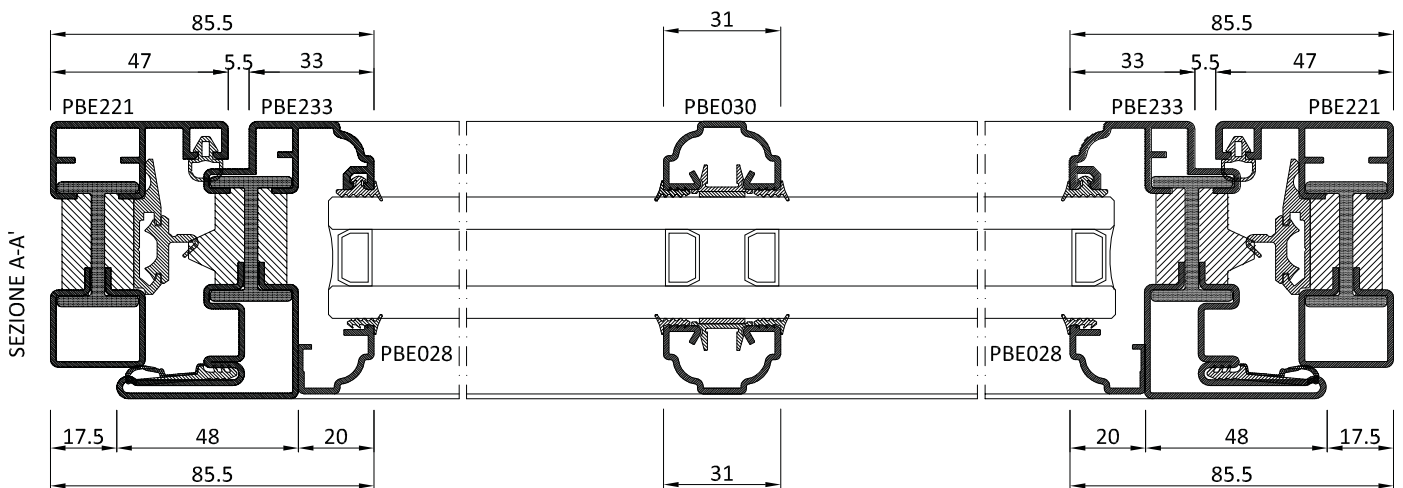


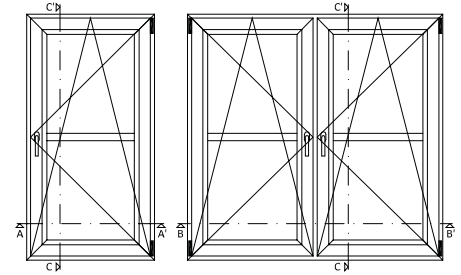
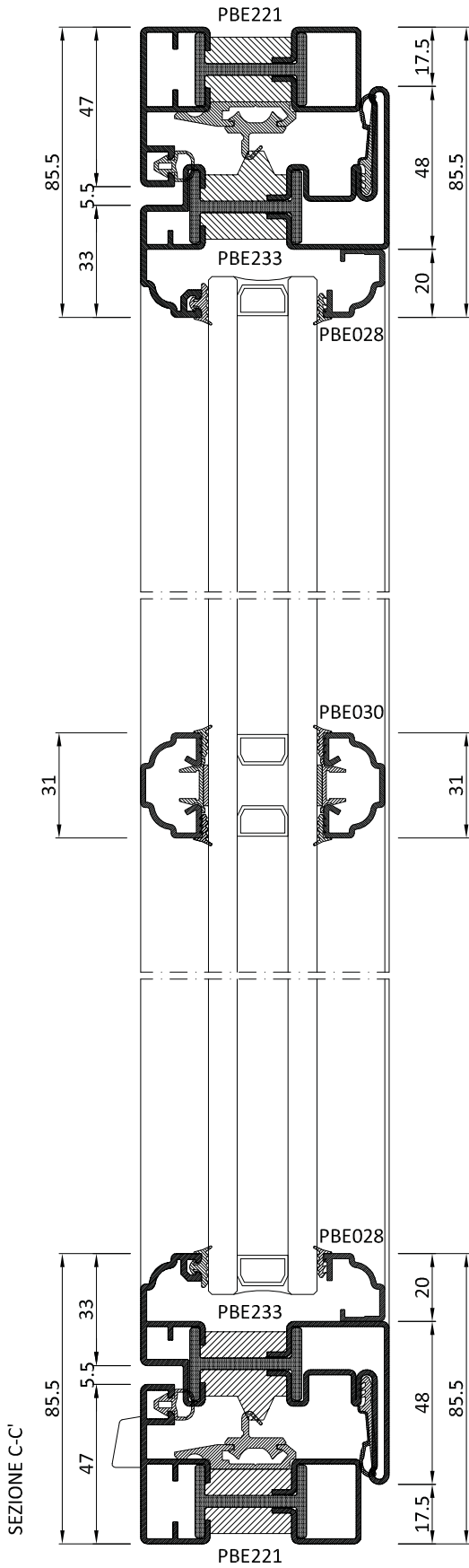






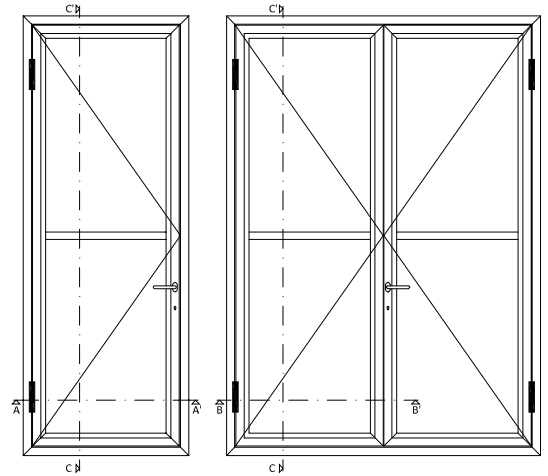
vista interna  
apertura interna  
*inside view*  
*inward opening*



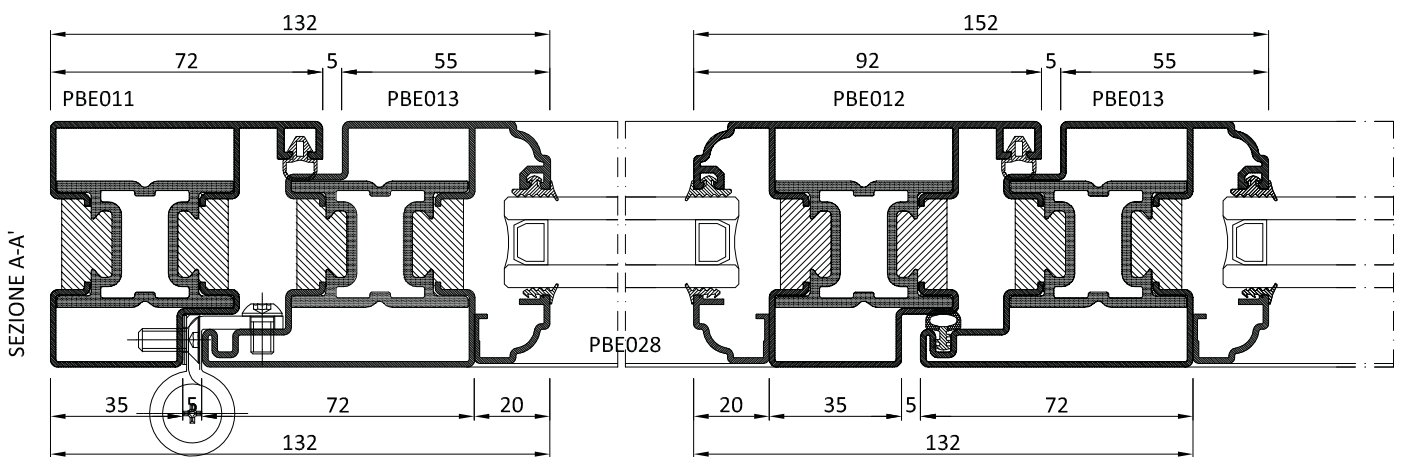
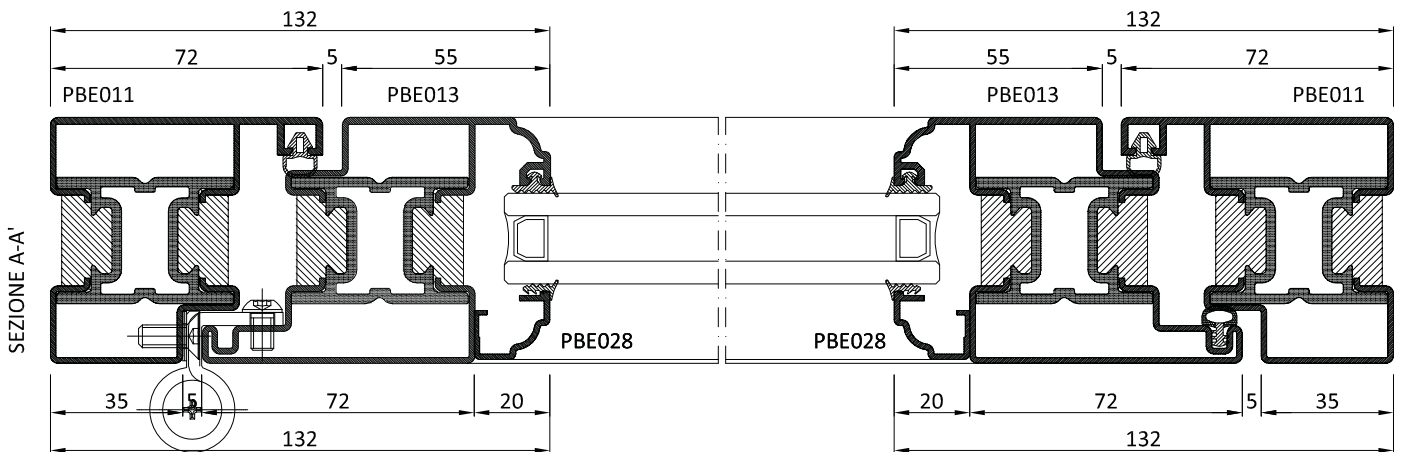


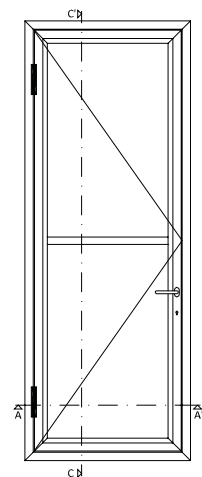
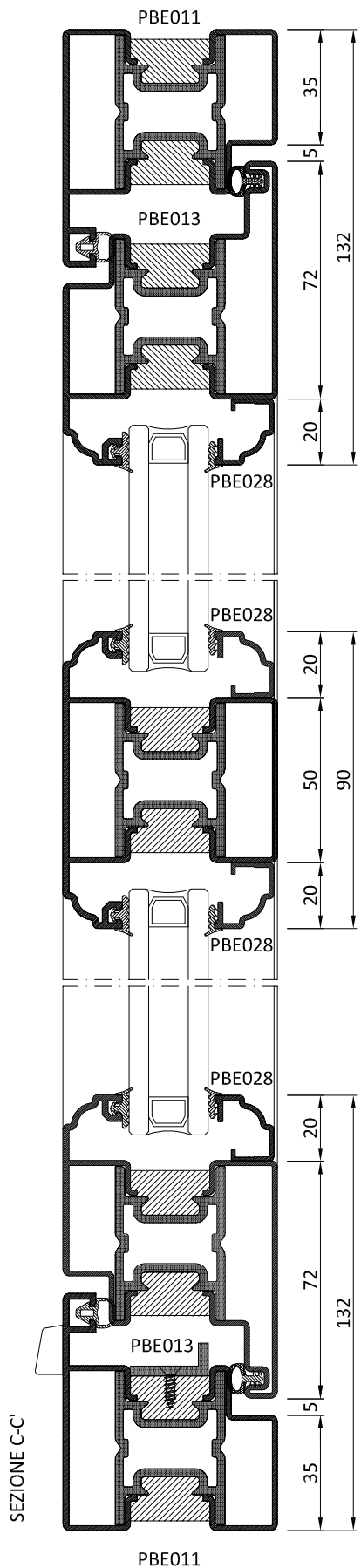
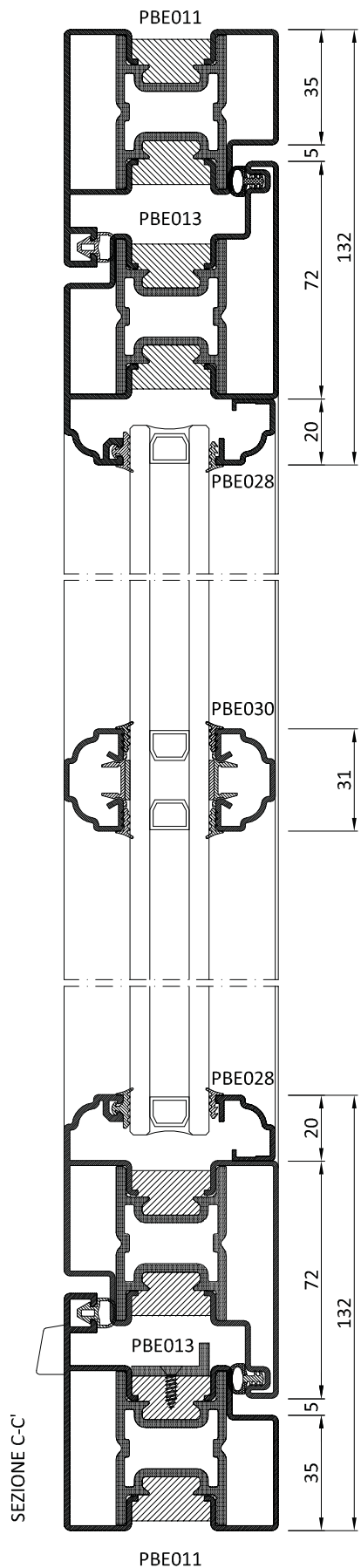
vista interna  
apertura interna  
*inside view*  
*inward opening*

SEZIONE C-C

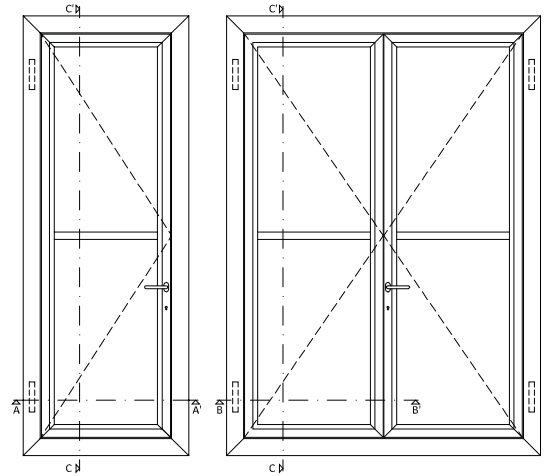


vista interna  
apertura interna  
*inside view*  
*inward opening*

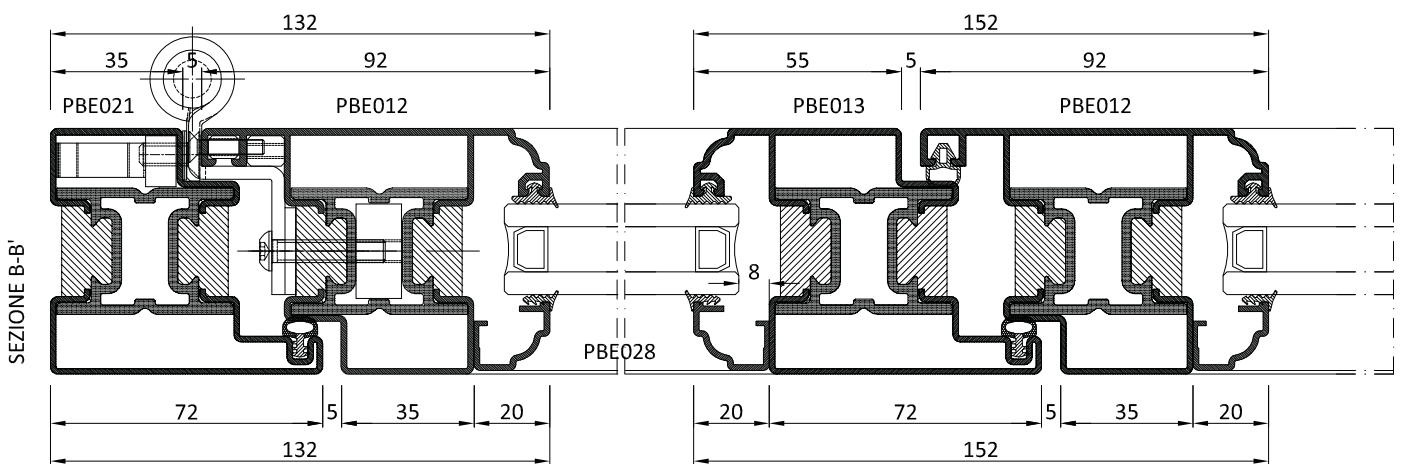
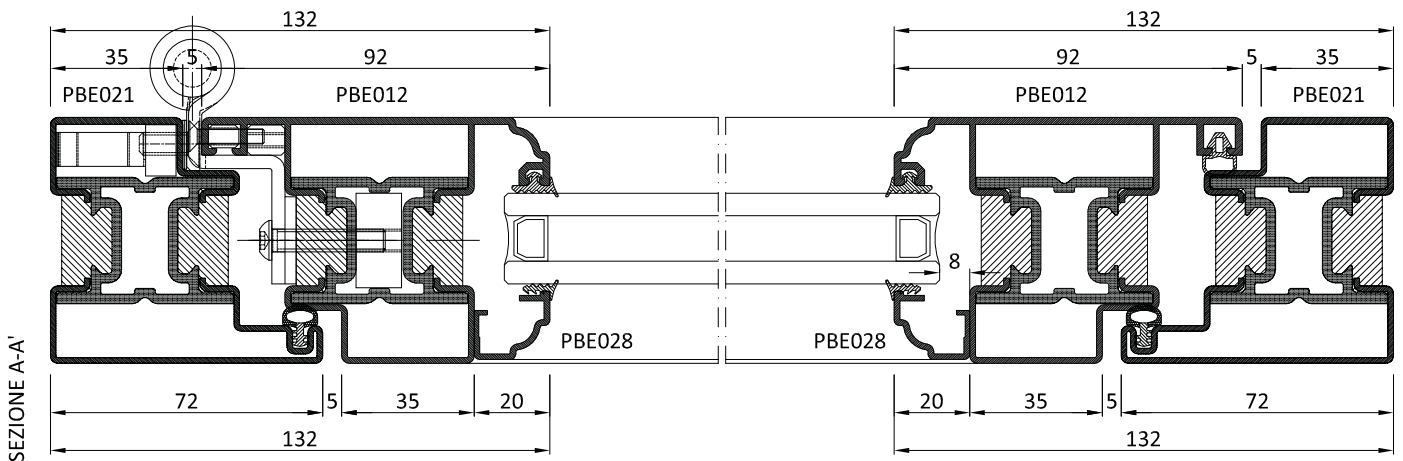




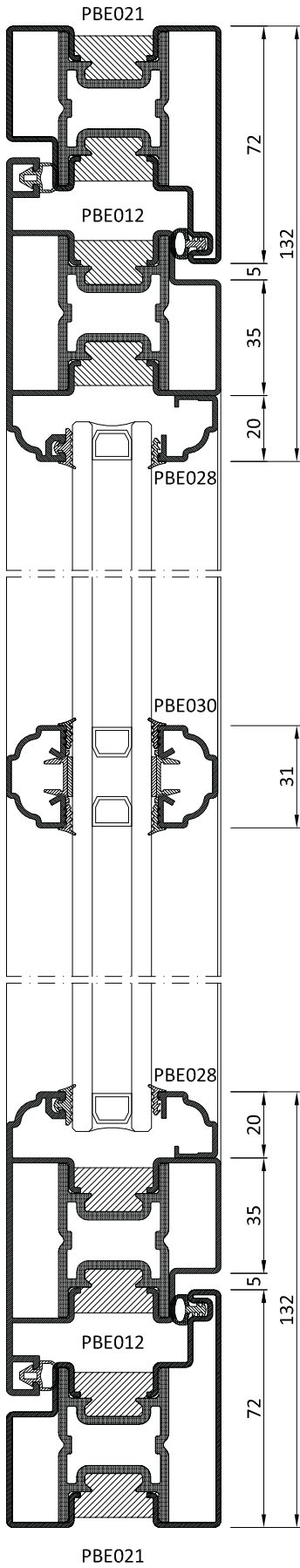
vista interna  
apertura interna  
inside view  
inward opening



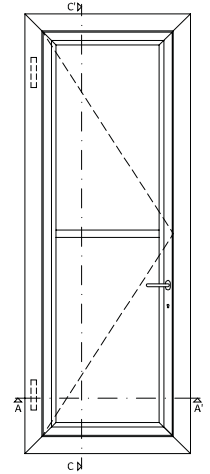
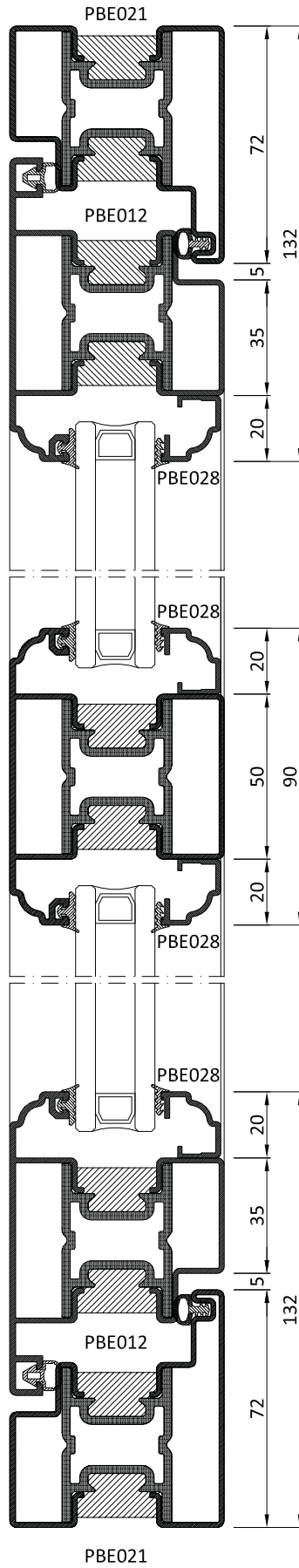
vista interna  
apertura esterna  
inside view  
outward opening



SEZIONE C-C'

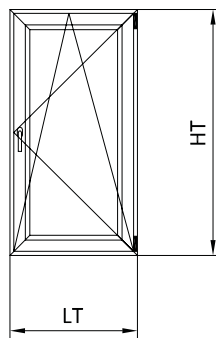


SEZIONE C-C'



vista interna  
apertura esterna  
*inside view*  
*outward opening*

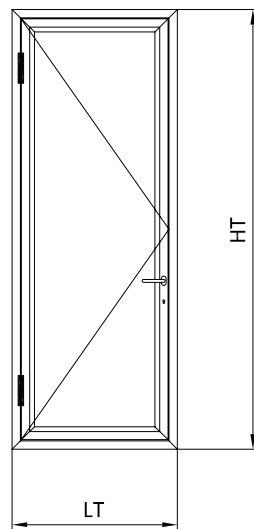




vista interna  
apertura interna  
inside view  
inward opening

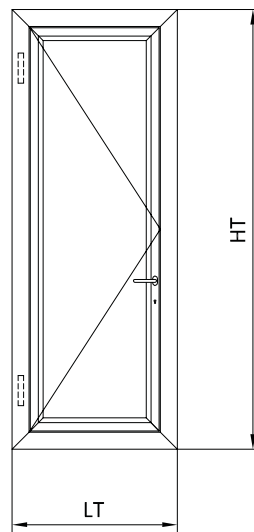
PROFILI - PROFILES						
COD.	DESCRIZIONE - DESCRIPTION	Q.TÀ	DIM. - SIZE	TAGLIO - CUT		TAV. - DRAWING
<b>telaio - external frame</b>						
PBE221	Profilo a "L" - Profile a "L"	2	LT	45°	45°	4.3 - 4.4
PBE221	Profilo a "L" - Profile a "L"	2	HT	45°	45°	4.3 - 4.4
<b>anta - opening frame</b>						
PBE233	Profilo anta - Leaf profile	2	LT-35	45°	45°	4.3 - 4.4
PBE233	Profilo anta - Leaf profile	2	HT-35	45°	45°	4.3 - 4.4
<b>fermavetri - glazing beads</b>						
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	LT-131	45°	45°	4.3 - 4.4
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	HT-131	45°	45°	4.3 - 4.4
<b>VETRI - GLASS</b>						
-	Vetrocamera - Double glazing	1	LT-147 x HT-147			
<b>ACCESSORI - HARDWARE</b>						
ACE1221I	Kit squadrette per PBE221 - Corner joint kit for PBE221	4				6.1
ACE1207I	Kit squadrette per PBE233 - Corner joint kit for PBE233	4				6.2
AC1020M	Spessore per vetrazione - Glass thickness	6				2.2
AC2608	Clips per fermavetro - Clips for glazing bead	var.		Passo - Pitch 250		2.1
AC1206	Angolo vulcanizzato per GE1201 - Vulcanised comere weather strip for GE1201	4				6.6
ACE219	Scarico acqua - Drip for inward opening	var.				6.6
<b>GUARNIZIONI - WEATHER STRIP</b>						
GU1202	Estruso rigido PVC per GE1201 - Rigid extruded PVC section for GE1201	1	LTx2+HTx2			
GE1201	Guarnizione giunto aperto - Central opening - joint weather for windows	1	LTx2+HTx2			
GE1203	Guarnizione di battuta esterna finestra - External weather strip for window	1	LTx2+HTx2			
GE1200TT	Guarnizione di battuta interna finestra - Internal weather strip for window	1	LTx2+HTx2			
GE1206	Guarnizione vetro esterna - External weather strip	1	LTx2+HTx2			
GE2029E	Guarnizione vetro interna - Internal weather strip	1	LTx2+HTx2			





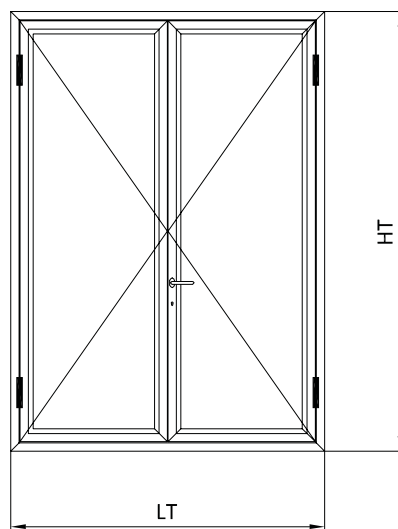
vista interna  
apertura interna  
inside view  
inward opening

PROFILI - PROFILES						
COD.	DESCRIZIONE - DESCRIPTION	Q.TÀ	DIM. - SIZE	TAGLIO - CUT		TAV. - DRAWING
<b>telaio - external frame</b>						
PBE011	Profilo a "L" - Profile a "L"	2	LT	45°	45°	4.5 - 4.6
PBE011	Profilo a "L" - Profile a "L"	2	HT	45°	45°	4.5 - 4.6
<b>anta - opening frame</b>						
PBE013	Profilo "Z" anta - Leaf "Z" profile	2	LT-80	45°	45°	4.5 - 4.6
PBE013	Profilo "Z" anta - Leaf "Z" profile	2	HT-80	45°	45°	4.5 - 4.6
<b>fermavetri - glazing beads</b>						
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	LT-224	45°	45°	4.5 - 4.6
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	HT-224	45°	45°	4.5 - 4.6
<b>VETRI - GLASS</b>						
-	Vetrocamera - Double glazing	1	LT-240 x HT-240			
<b>ACCESSORI - HARDWARE</b>						
ACE1004I	Kit squadrette per PBE011 - Corner joint kit for PBE011	4				7.3
ACE1007I	Kit squadrette per PBE013 - Corner joint kit for PBE013	4				7.5
AC1020M	Spessore per vetrazione - Glass thickness	6				2.2
AC2608	Clips per fermavetro - Clips for glazing bead	var.			Passo - Pitch 250	2.1
ACE219	Scarico acqua - Drip for inward opening	var.				6.6
<b>GUARNIZIONI - WEATHER STRIP</b>						
GE1001TT	Guarnizione di battuta interna porta - Internal weather strip for door	1	LTx2+HTx2			
GE1001E	Guarnizione di battuta esterna porta - External weather strip for door	1	LTx2+HTx2			
GE1206	Guarnizione vetro esterna - External weather strip	1	LTx2+HTx2			
GE2029E	Guarnizione vetro interna - Internal weather strip	1	LTx2+HTx2			
GU1085	Profilo raccolta acqua	1	LT-94			7.15



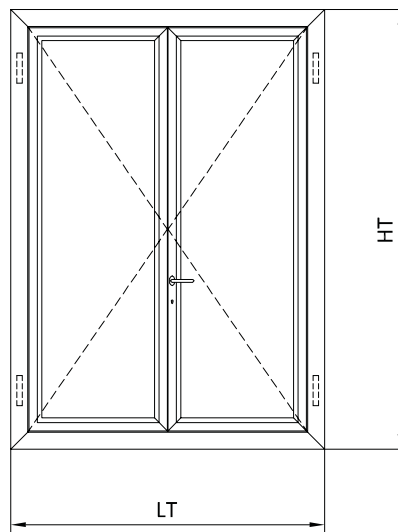
vista interna  
apertura esterna  
inside view  
outward opening

PROFILI - PROFILES						
COD.	DESCRIZIONE - DESCRIPTION	Q.TÀ	DIM. - SIZE	TAGLIO - CUT		TAV. - DRAWING
<b>telaio - external frame</b>						
PBE021	Profilo a "L" - Profile a "L"	2	LT	45°	45°	4.7 - 4.8
PBE021	Profilo a "L" - Profile a "L"	2	HT	45°	45°	4.7 - 4.8
<b>anta - opening frame</b>						
PBE012	Profilo "T" anta - Leaf "T" profile	2	LT- 80	45°	45°	4.7 - 4.8
PBE012	Profilo "T" anta - Leaf "T" profile	2	HT- 80	45°	45°	4.7 - 4.8
<b>fermavetri - glazing beads</b>						
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	LT-224	45°	45°	4.7 - 4.8
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	HT-224	45°	45°	4.7 - 4.8
<b>VETRI - GLASS</b>						
-	Vetrocamera - Double glazing	1	LT-240 x HT-240			
<b>ACCESSORI - HARDWARE</b>						
AC1004I	Kit squadrette per PBE021 - Corner joint kit for PBE021	4				7.2
ACE1005I	Kit squadrette per PBE012 - Corner joint kit for PBE012	4				7.4
AC1020M	Spessore per vetrazione - Glass thickness	6				2.2
AC2608	Clips per fermavetro - Clips for glazing bead	var.		Passo - Pitch 250		2.1
<b>GUARNIZIONI - WEATHER STRIP</b>						
GE1001TT	Guarnizione di battuta interna porta - Internal weather strip for door	1	LTx2+HTx2			
GE1001E	Guarnizione di battuta esterna porta - External weather strip for door	1	LTx2+HTx2			
GE1206	Guarnizione vetro esterna - External weather strip	1	LTx2+HTx2			
GE2029E	Guarnizione vetro interna - Internal weather strip	1	LTx2+HTx2			



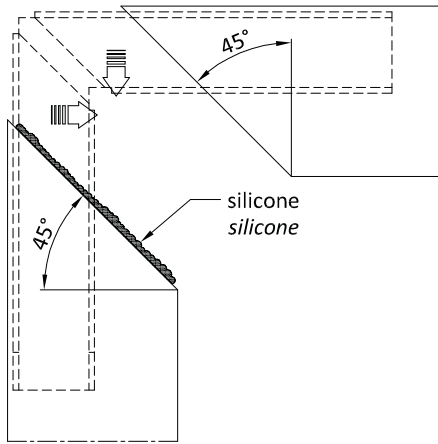
vista interna  
apertura interna  
inside view  
inward opening

PROFILI - PROFILES						
COD.	DESCRIZIONE - DESCRIPTION	Q.TÀ	DIM. - SIZE	TAGLIO - CUT		TAV. - DRAWING
<b>telaio - external frame</b>						
PBE011	Profilo a "L" - Profile a "L"	2	LT	45°	45°	4.5 - 4.6
PBE011	Profilo a "L" - Profile a "L"	2	HT	45°	45°	4.5 - 4.6
<b>anta - opening frame</b>						
PBE013	Profilo "Z" anta - Leaf "Z" profile	4	LT/2-24	45°	45°	4.5 - 4.6
PBE013	Profilo "Z" anta - Leaf "Z" profile	3	HT-80	45°	45°	4.5 - 4.6
PBE012	Profilo "T" anta - Leaf "T" profile	1	HT-80	45°	45°	4.5 - 4.6
<b>fermavetri - glazing beads</b>						
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	LT/2-168	45°	45°	4.5 - 4.6
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	HT-224	45°	45°	4.5 - 4.6
<b>VETRI - GLASS</b>						
-	Vetrocamera - Double glazing	1	LT/2-184 x HT-240			
<b>ACCESSORI - HARDWARE</b>						
ACE1004I	Kit squadrette per PBE011 - Corner joint kit for PBE011	4				7.3
ACE1008I	Kit squadrette per PBE012/PBE013 - Corner joint kit for PBE012/PBE013	2				7.6
ACE1007I	Kit squadrette per PBE013 - Corner joint kit for PBE013	6				7.5
AC1020M	Spessore per vetrazione - Glass thickness	12				2.2
AC2608	Clips per fermavetro - Clips for glazing bead	var.			Passo - Pitch 250	2.1
ACE219	Scarico acqua - Drip for inward opening	var.				7.15
<b>GUARNIZIONI - WEATHER STRIP</b>						
GE1001TT	Guarnizione di battuta interna porta - Internal weather strip for door	1	LTx2+HTx3			
GE1001E	Guarnizione di battuta esterna porta - External weather strip for door	1	LTx2+HTx3			
GE1206	Guarnizione vetro esterna - External weather strip	1	LTx2+HTx4			
GE2029E	Guarnizione vetro interna - Internal weather strip	1	LTx2+HTx4			
GU1085	Profilo raccolta acqua - Profile for collecting water	1	LT-94			7.15



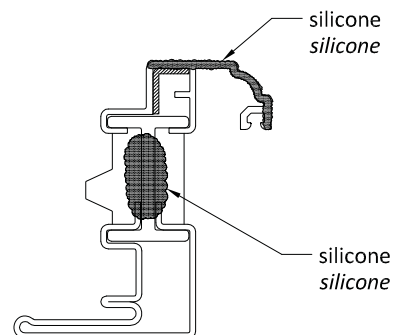
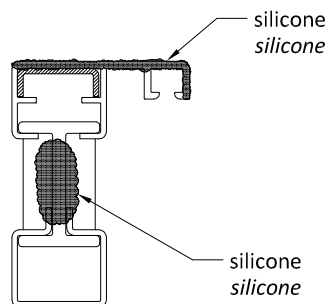
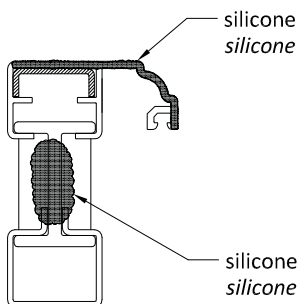
vista interna  
apertura esterna  
inside view  
outward opening

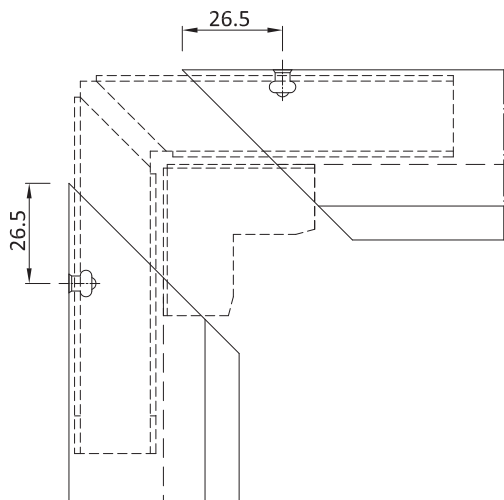
PROFILI - PROFILES						
COD.	DESCRIZIONE - DESCRIPTION	Q.TÀ	DIM. - SIZE	TAGLIO - CUT		TAV. - DRAWING
<b>telaio - external frame</b>						
PBE021	Profilo a "L" - Profile a "L"	2	LT	45°	45°	4.7 - 4.8
PBE021	Profilo a "L" - Profile a "L"	2	HT	45°	45°	4.7 - 4.8
<b>anta - opening frame</b>						
PBE012	Profilo "T" anta - Leaf "T" profile	4	LT/2-24	45°	45°	4.7 - 4.8
PBE012	Profilo "T" anta - Leaf "T" profile	3	HT-80	45°	45°	4.7 - 4.8
PBE013	Profilo "Z" anta - Leaf "Z" profile	1	HT-80	45°	45°	4.7 - 4.8
<b>fermavetri - glazing beads</b>						
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	LT/2-168	45°	45°	4.7 - 4.8
PBE028	Fermavetro h.20 mm - Glazing beds h.20 mm	2	HT-224	45°	45°	4.7 - 4.8
<b>VETRI - GLASS</b>						
-	Vetrocamera - Double glazing	1	LT/2-184 x HT-240			
<b>ACCESSORI - HARDWARE</b>						
AC1004I	Kit squadrette per PBE021 - Corner joint kit for PBE021	4				7.2
ACE1008I	Kit squadrette per PBE012/PBE013 - Corner joint kit for PBE012/PBE013	2				7.6
ACE1005I	Kit squadrette per PBE012 - Corner joint kit for PBE012	6				7.4
AC1020M	Spessore per vetratura - Glass thickness	12				2.2
AC2608	Clips per fermavetro - Clips for glazing bead	var.		Passo - Pitch 250		2.1
<b>GUARNIZIONI - WEATHER STRIP</b>						
GE1001TT	Guarnizione di battuta interna porta - Internal weather strip for door	1	LTx2+HTx3			
GE1001E	Guarnizione di battuta esterna porta - External weather strip for door	1	LTx2+HTx3			
GE1206	Guarnizione vetro esterna - External weather strip	1	LTx2+HTx4			
GE2029E	Guarnizione vetro interna - Internal weather strip	1	LTx2+HTx4			




- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

- 1) insert the bracket
- 2) seal in the specified areas
- 3) joint the profiles
- 4) weld (see following pages)




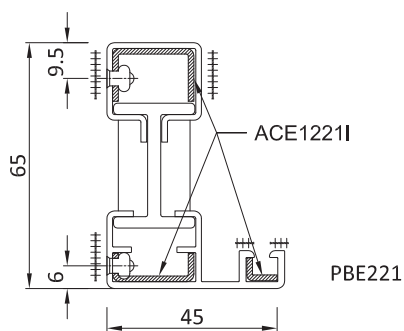
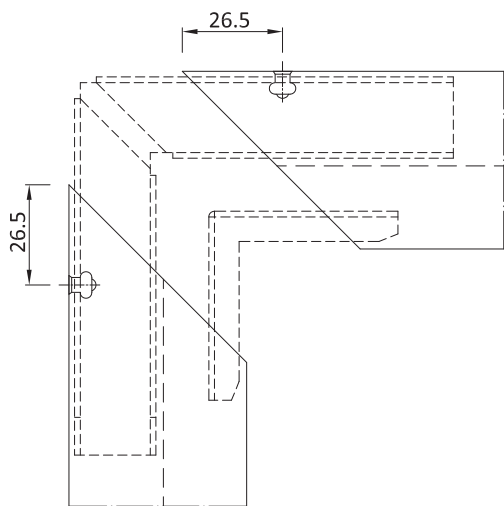
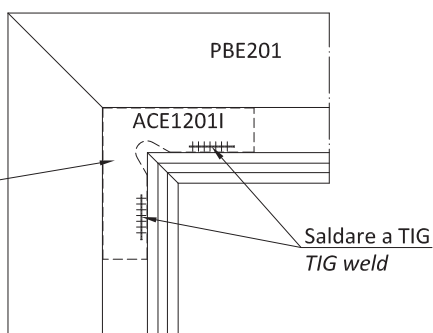
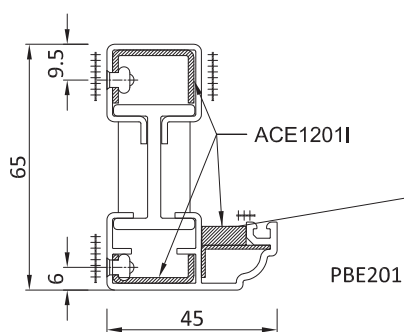


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
Sigillare tutte le superfici di contatto esterne con silicone

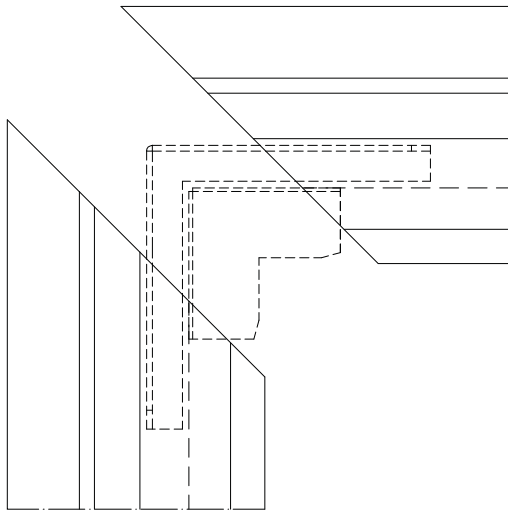
 Rivetti svasati  $\varnothing 4 \times 10$

*TIG welding with filler material\*\* in the areas indicated with ++++  
Seal all the external contact surfaces with silicone*

 Flaring rivets  $\varnothing 4 \times 10$



\*\* filo  $\varnothing 1$  mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
wire  $\varnothing 1$  mm Cu Si 3 - classification AWS A5.7 ER Cu Si-A

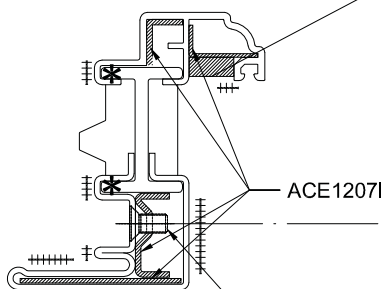
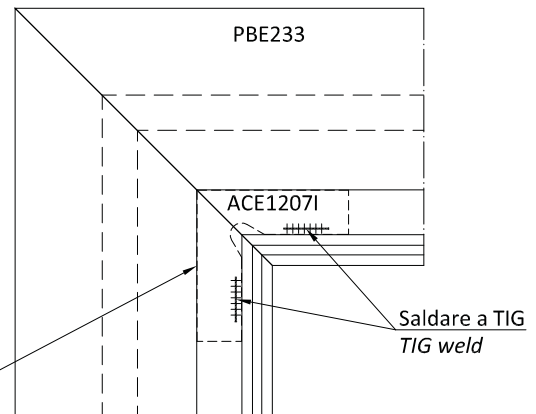
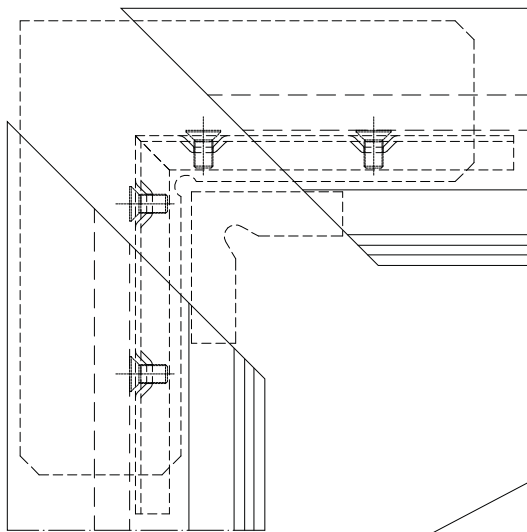
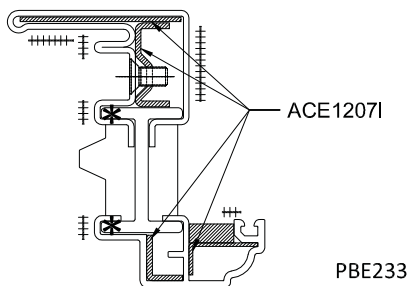


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
Sigillare tutte le superfici di contatto esterne con silicone

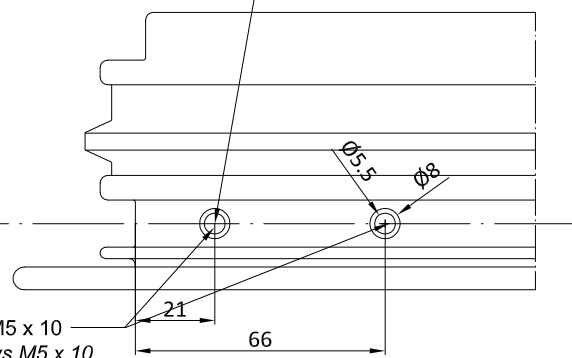
Asportare il poliammide dagli angoli prima di eseguire le saldature  
nelle zone indicate con \*

*TIG welding with filler material\*\* in the areas indicated with ++++  
Seal all the external contact surfaces with silicone*

*Before welding please remove the polyamide from corner  
areas specified with \**

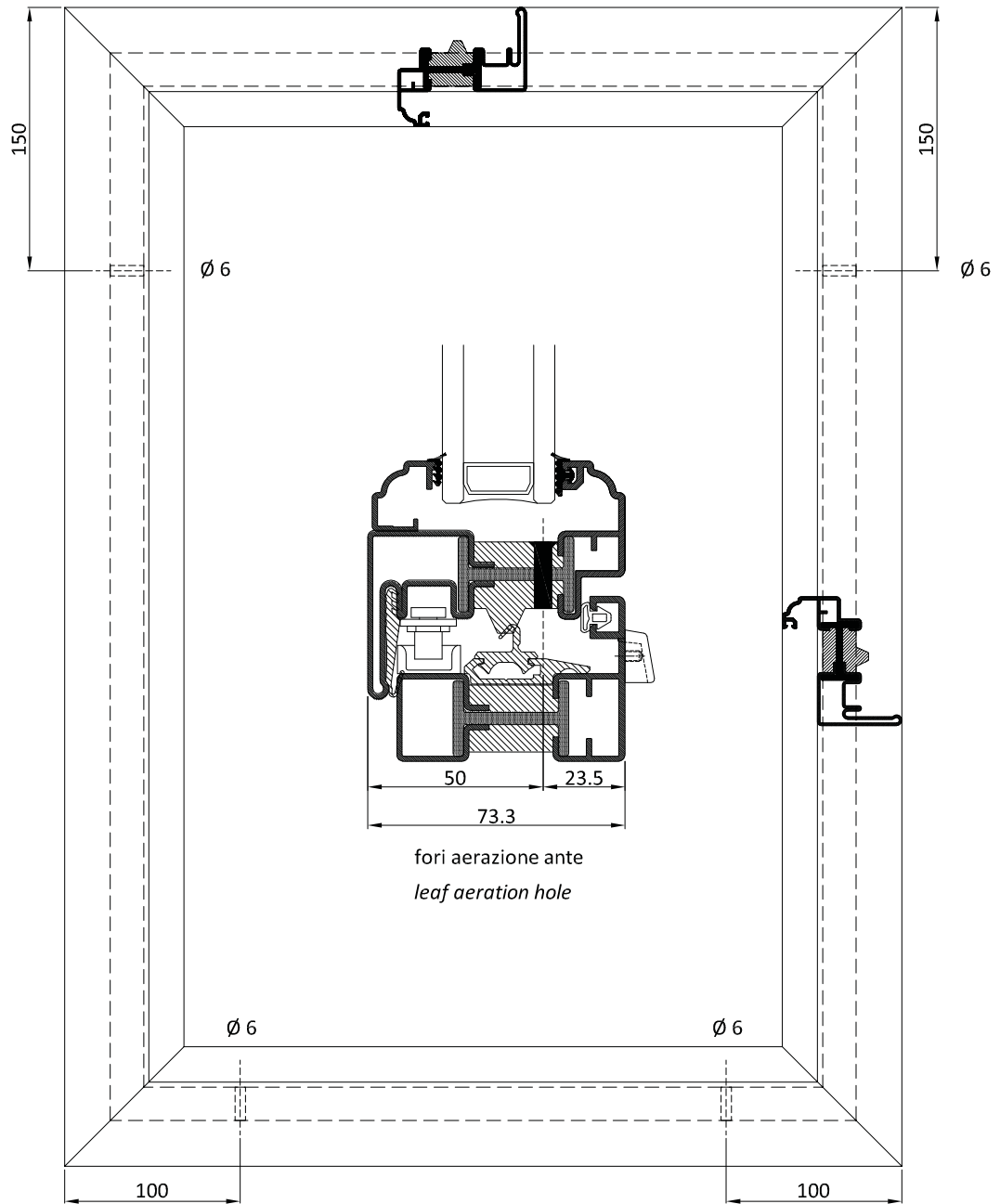
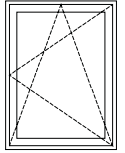


fori imbutiti per viti M5 x 10 con stampo AT1233  
*Drawn drilling for screws M5 x 10 to be made with AT1233*

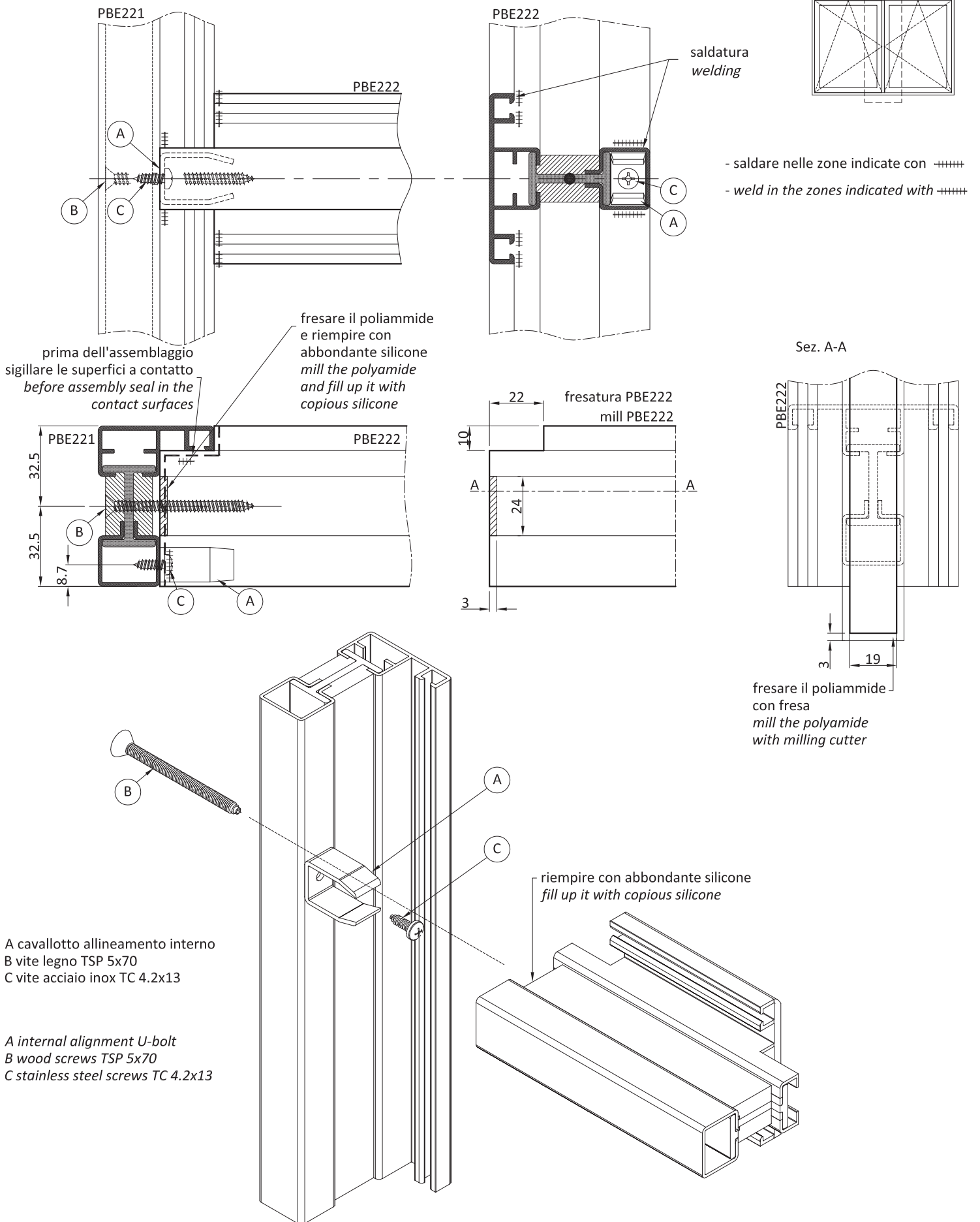


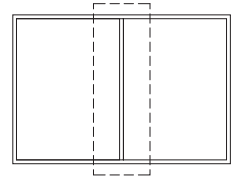
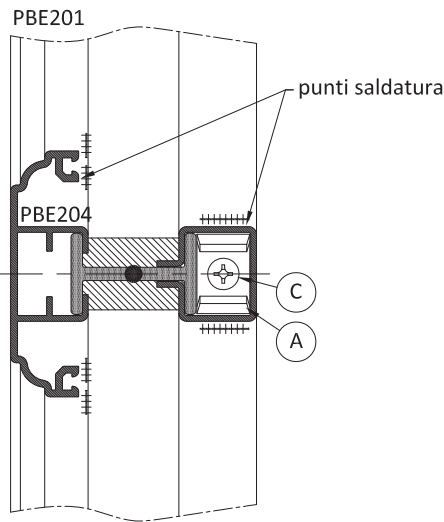
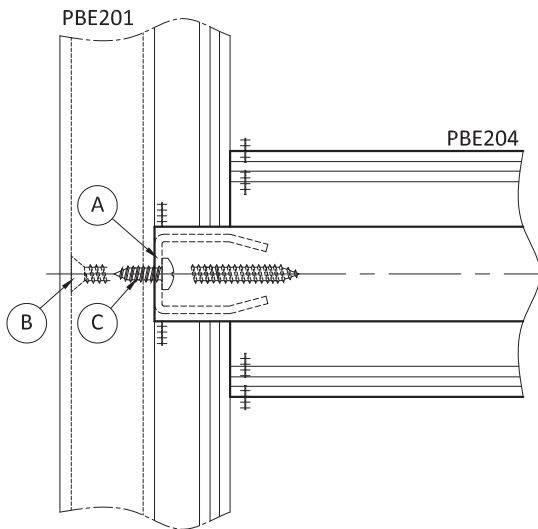
viti acciaio inox M5 x 10  
*stainless steel screws M5 x 10*

\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
*wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A*

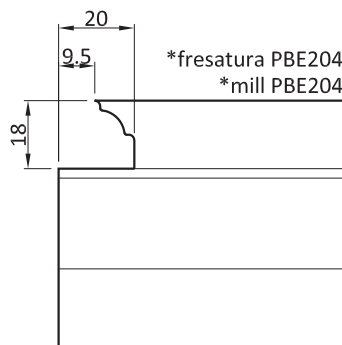
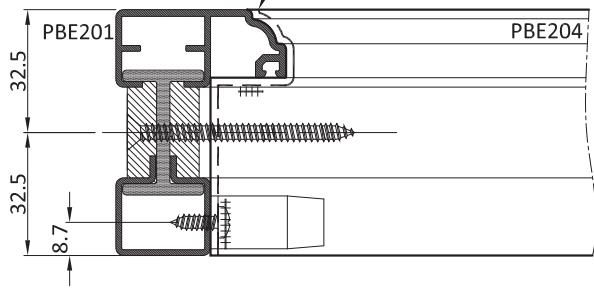








prima dell'assemblaggio  
sigillare le superfici a contatto  
*before assembly seal in the contact  
surfaces*



- Sigillare con silicone tutte le superfici di contatto tra i profili che non vengono saldate

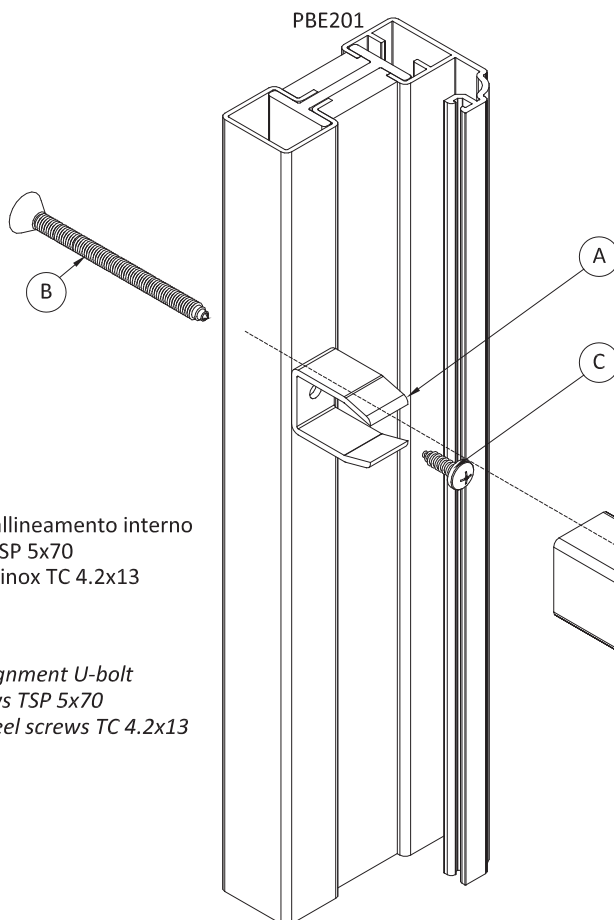
- Saldare nelle zone indicate con - - - - -

\* lavorazione eseguibile con fresa ATE004

- Seal with silicone all the contact surfaces between the profiles that are not welded surfaces

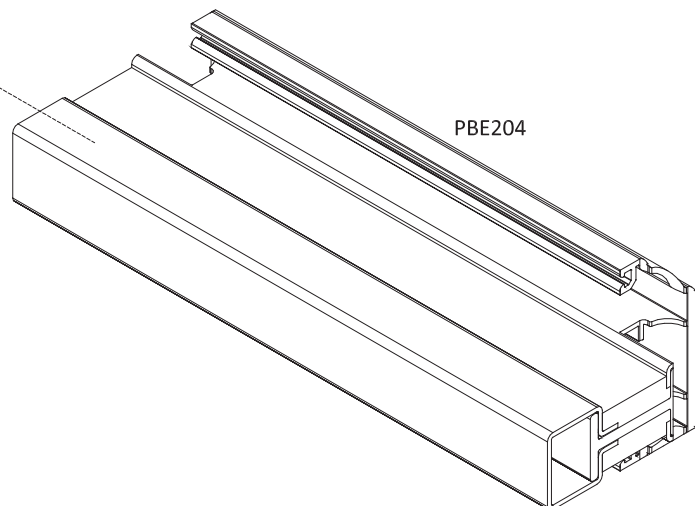
- weld in the zones indicated with - - - - -

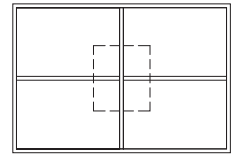
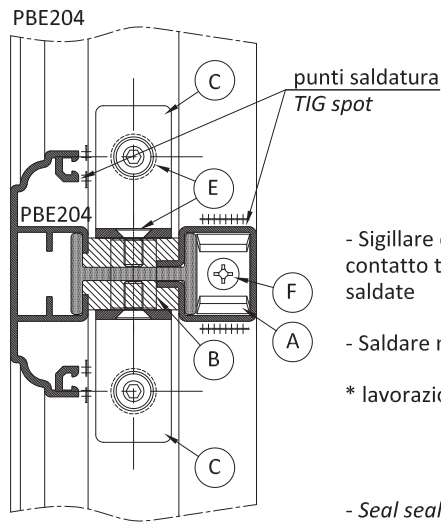
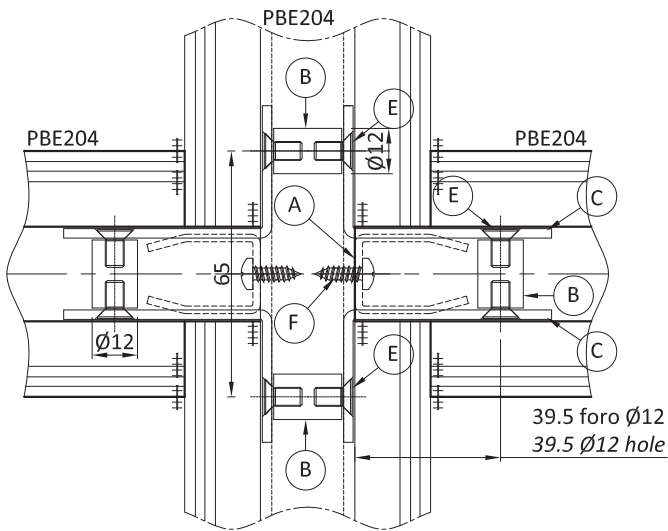
\* working can be done with milling machine ATE004



A cavalletto allineamento interno  
B vite legno TSP 5x70  
C vite acciaio inox TC 4.2x13

A internal alignment U-bolt  
B wood screws TSP 5x70  
C stainless steel screws TC 4.2x13





- Sigillare con silicone tutte le superfici di contatto tra i profili che non vengono saldate

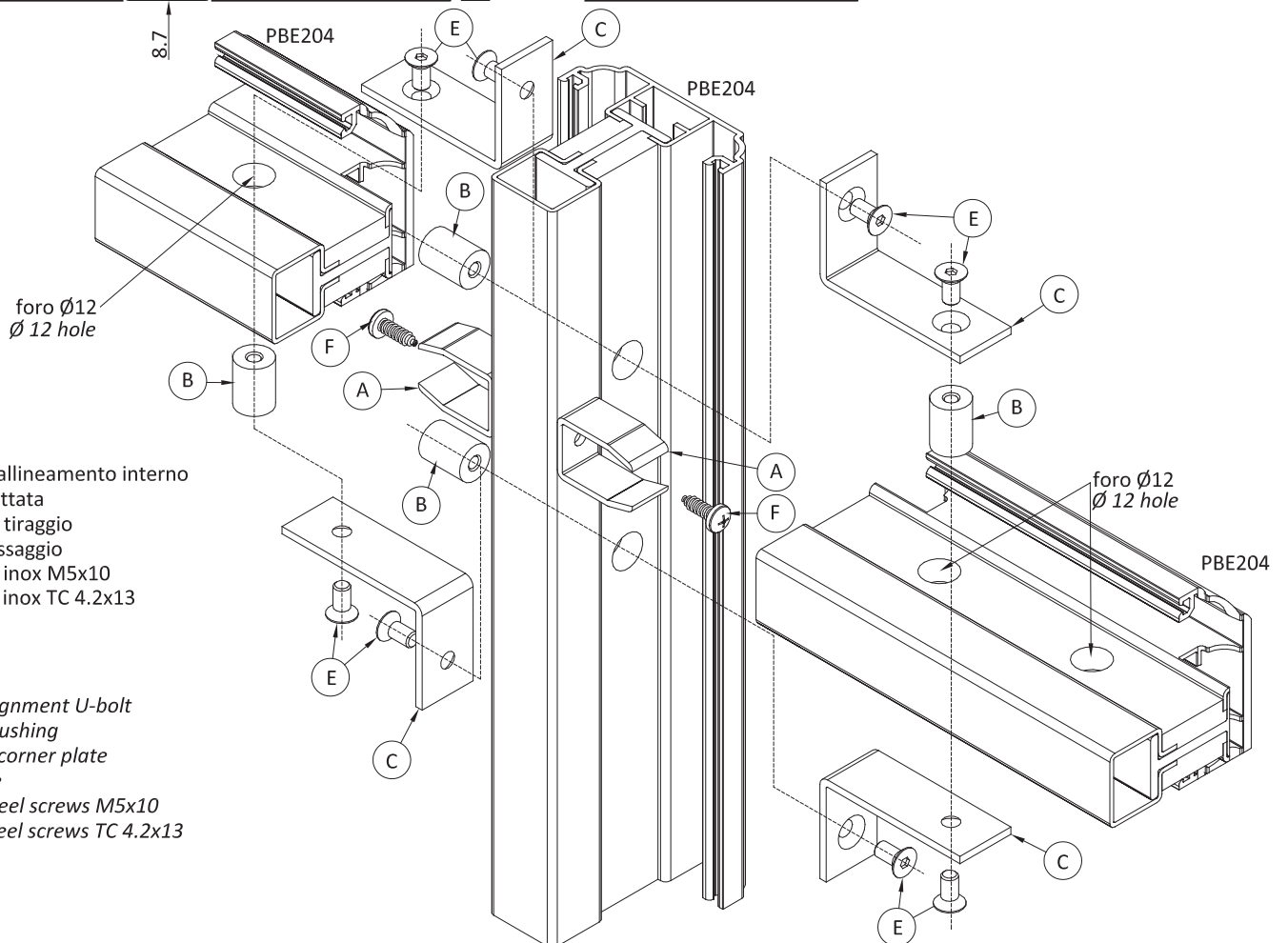
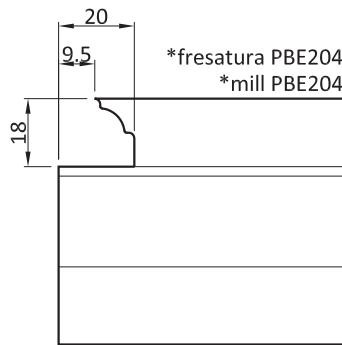
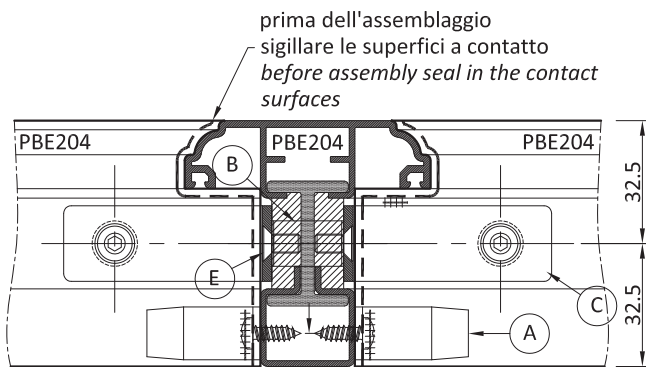
- Saldare nelle zone indicate con -----

\* lavorazione eseguibile con fresa ATE004

- Seal sealant or silicone) all the contact surfaces between the profiles that are not welded surfaces

- weld in the zones indicated with -----

\* working can be done with milling machine ATE004

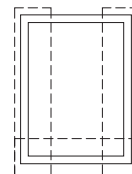


- A cavallotto allineamento interno
- B bussola filettata
- C squadretta tiraggio
- D piastrina fissaggio
- E vite acciaio inox M5x10
- F vite acciaio inox TC 4.2x13

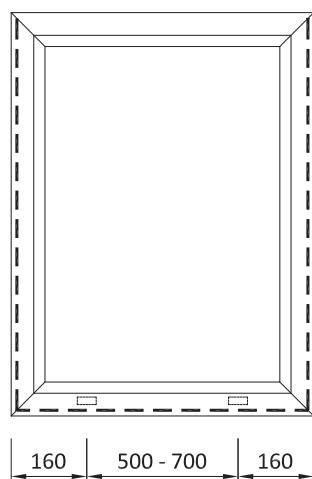
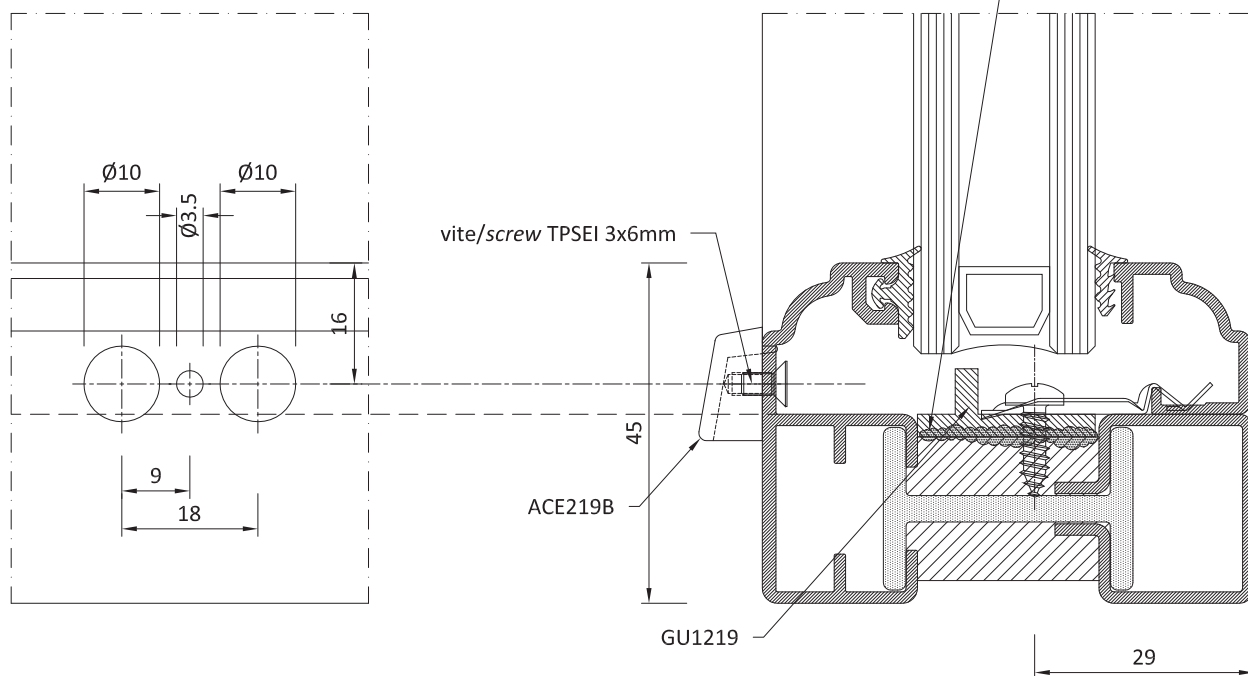
- A internal alignment U-bolt
- B threaded bushing
- C tightening corner plate
- D fixing plate
- E stainless steel screws M5x10
- F stainless steel screws TC 4.2x13

- eseguire fori come da disegno.
- posizionare lo scarico acqua sigillare e fissare con la vite in dotazione TPSEI 3x6mm INOX

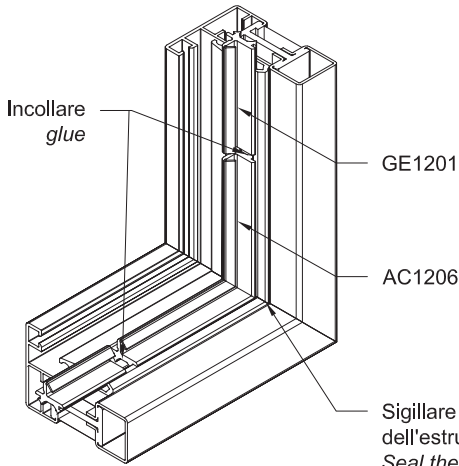
- *drill the holes as shown on the drawing*
- *position the water drain and secure with the supplied TPSEI 3x6mm screw*



sigillare il lato inferiore per tutta la lunghezza  
le zone indicate  
*seal the bottom along its whole length in the  
zones indicated*



-- GU1219

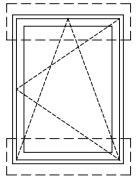


GE1201  
AC1206

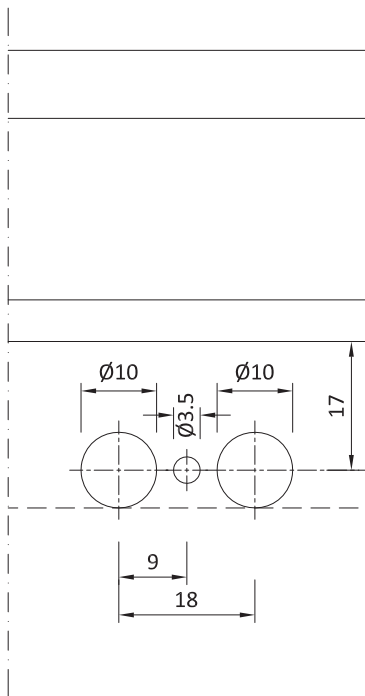
Sigillare l'unione dell'estruso rigido GU1202  
Seal the union of the rigid extruded PVC GU1202

- Eseguire fori come da disegno.
- Posizionare lo scarico acqua sigillare e fissare con la vite in dotazione TPSEI 3x6mm INOX
- Posizionare il supporto della guarnizione di giunto GU1202 e sigillare per tutta la lunghezza e per 200 mm. in altezza.
- Posizionare la guarnizione di giunto GE1201 e gli angoli vulcanizzati AC1216; incollarli alla guarnizione con colla ciano-acrilica e sigillare per la larghezza e per 200 mm. in altezza tra GU1202 e guarnizione GE1201

- drill the holes as shown on the drawing
- Position the water drain and secure with the supplied TPSEI 3x6mm screw
- Position the GU1202 weather strip support and seal along its entire length and for a height of 200 mm.
- Position the GE1201 joint weather strip and the vulcanised AC1216 corners; glue them to the gasket with acrylic adhesive and seal along the entire and for a height of 200 mm. between GU1202 and GE1201

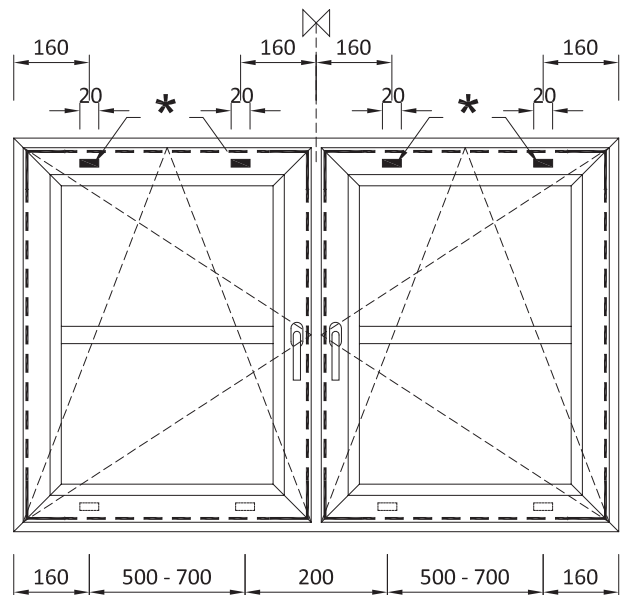
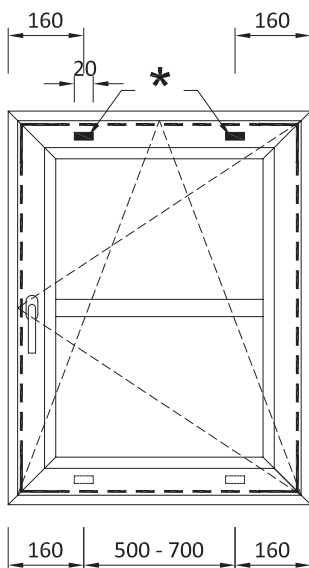
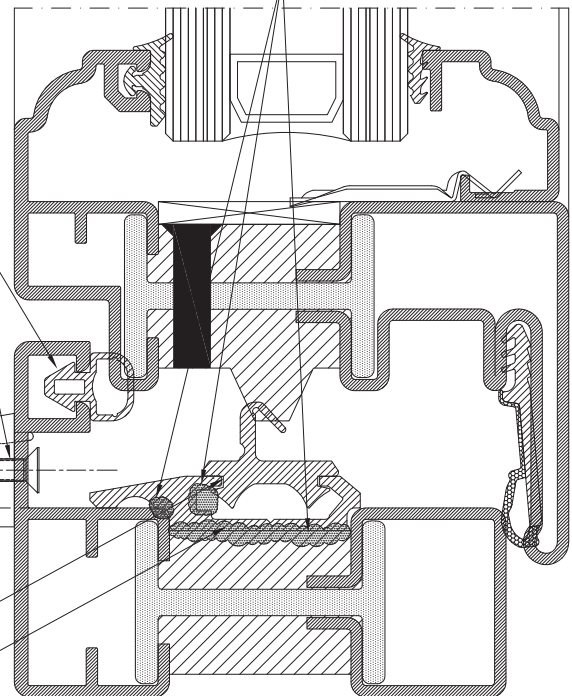


Sigillare il lato inferiore per tutta la lunghezza e 100 mm in altezza le zone indicate  
Seal the bottom edge along its whole length of 100 mm in the zones indicated



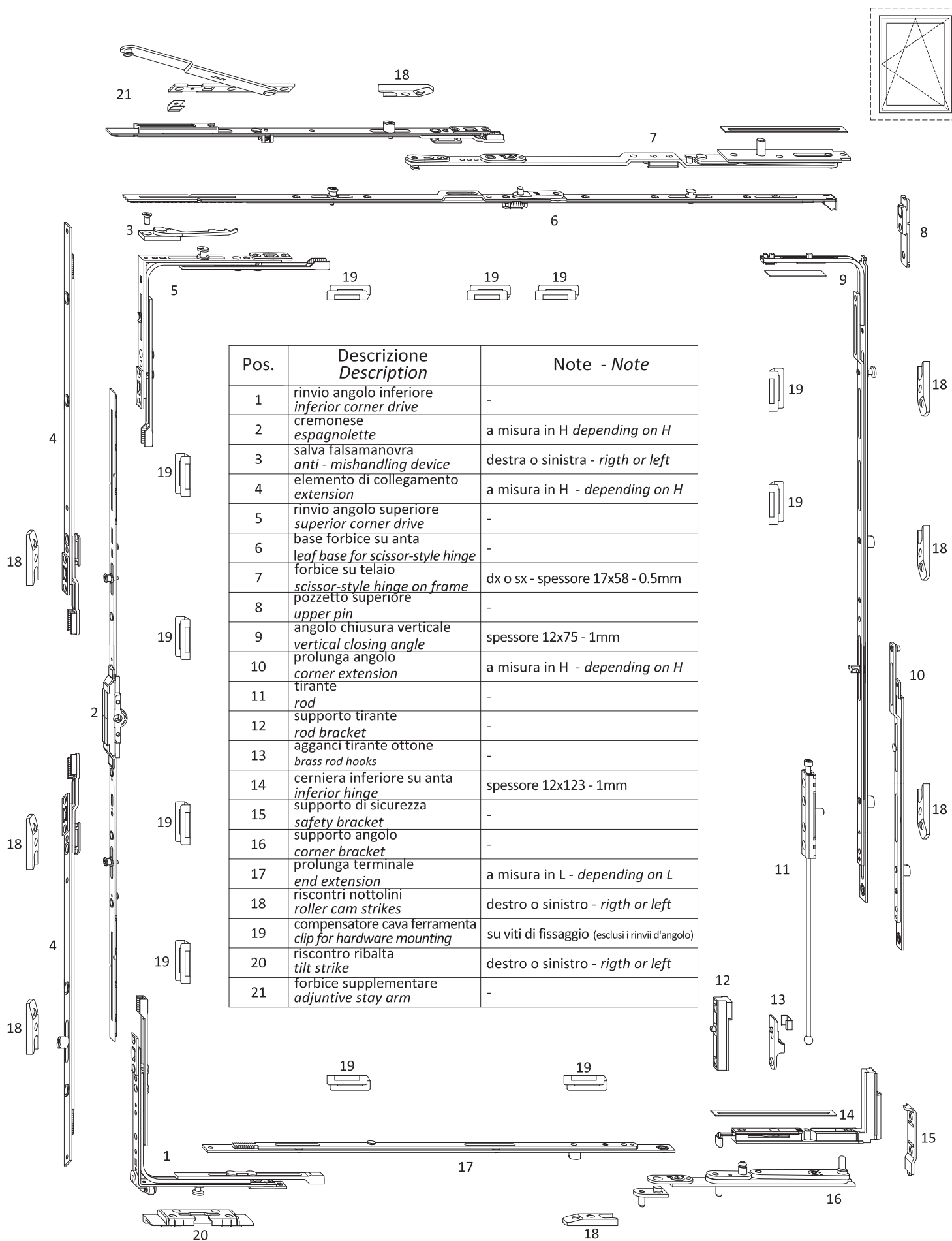
GE1203E  
vite/screw TPSEI 3x6mm  
ACE219B

GE1201 - AC1216  
GU1202



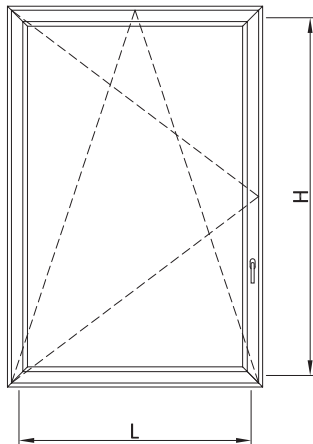
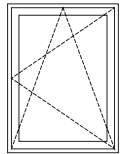
┌ AC1216  
- - GE1201

\* Tagliare la guarnizione GE1203E per 20mm.  
Cut the weather strip GE1203E to 20mm.



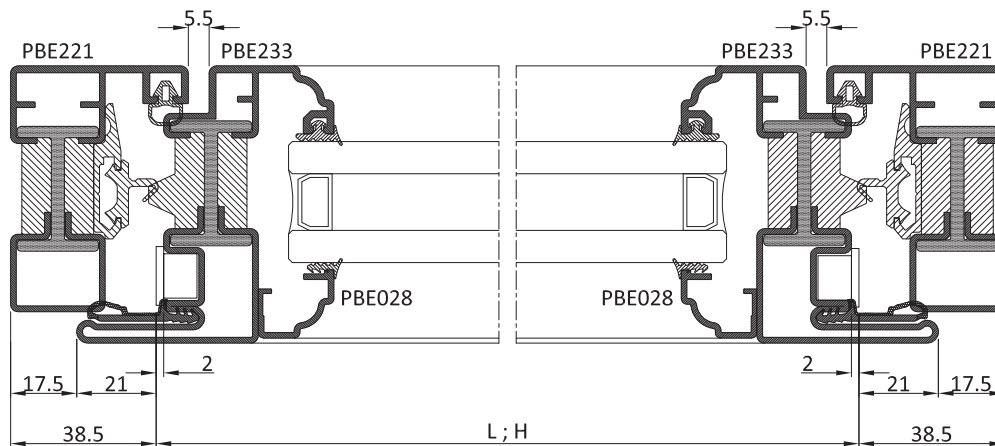
Pos.	Descrizione Description	Note - Note
1	rinvio angolo inferiore <i>inferior corner drive</i>	-
2	cremonese <i>espagnolette</i>	a misura in H <i>depending on H</i>
3	salva falsamanovra <i>anti - mishandling device</i>	destra o sinistra - <i>right or left</i>
4	elemento di collegamento <i>extension</i>	a misura in H - <i>depending on H</i>
5	rinvio angolo superiore <i>superior corner drive</i>	-
6	base forbice su anta <i>leaf base for scissor-style hinge</i>	-
7	forbice su telaio <i>scissor-style hinge on frame</i>	dx o sx - spessore 17x58 - 0.5mm
8	pozzetto superiore <i>upper pin</i>	-
9	angolo chiusura verticale <i>vertical closing angle</i>	spessore 12x75 - 1mm
10	prolunga angolo <i>corner extension</i>	a misura in H - <i>depending on H</i>
11	tirante <i>rod</i>	-
12	supporto tirante <i>rod bracket</i>	-
13	agganci tirante ottone <i>brass rod hooks</i>	-
14	cerniera inferiore su anta <i>inferior hinge</i>	spessore 12x123 - 1mm
15	supporto di sicurezza <i>safety bracket</i>	-
16	supporto angolo <i>corner bracket</i>	-
17	prolunga terminale <i>end extension</i>	a misura in L - <i>depending on L</i>
18	riscontri nottolini <i>roller cam strikes</i>	destra o sinistra - <i>right or left</i>
19	compensatore cava ferramenta <i>clip for hardware mounting</i>	su viti di fissaggio (esclusi i rinvii d'angolo)
20	riscontro ribalta <i>tilt strike</i>	destra o sinistra - <i>right or left</i>
21	forbice supplementare <i>adjunctive stay arm</i>	-

limiti dimensionali anta ribalta  
*dimensional limits for tilt and turn windows*



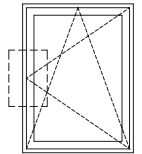
limiti dimensionali anta - <i>dimensional limits for windows leaf</i>			
	1 anta	2 ante	
<i>finestre windows</i>	350<L<1500	700<L<2400	L < H 100 kg (cern a scomparsa) (concealed hinges)
<i>porte finestre windows</i>	350<L<1260	700<L<2400	L < 2/3 H 100 kg (cern a scomparsa) (concealed hinges)

riferimento misure (cava ferramenta)  
*measure reference (hardare reference)*



L \ H	601 800	801 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2230	2231 2460
451 - 550	A9	B9	C9	D9	E9	F9	G9	H9	I9
551 - 680	A0	B0	C0	D0	E0	F0	G0	H0	I0
681 - 850	A1	B1	C1	D1	E1	F1	G1	H1	I1
851 - 1050		B2	C2	D2	E2	F2	G2	H2	I2
1051 - 1250			C3	D3	E3	F3	G3	H3	I3
1251 - 1450				D4	E4	F4	G4	H4	I4



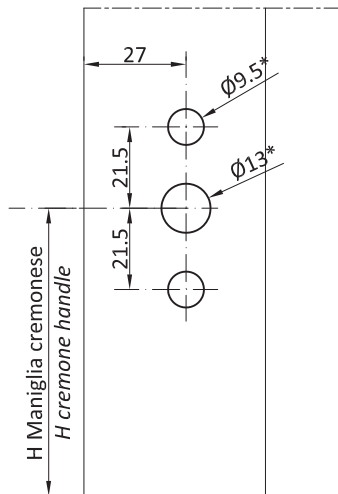


altezza maniglia cremonese <i>cremone bolt handle height</i>		
	H cava ferramenta <i>H hardware slot</i>	H maniglia <i>H handle</i>
finestre <i>windows</i>	431 < H > 489	190
	490 < H > 600	variabile da 245 a 300 <i>variable from 245 to 300</i>
	601 < H > 800	variabile da 330 a 550 <i>variable from 330 to 550</i>
	801 < H > 1000	variabile da 330 a 550 <i>variable from 330 to 550</i>
	1001 < H > 1200	variabile da 330 a 550 <i>variable from 330 to 550</i>
	1201 < H > 1400	490
	1401 < H > 1600	490
porte-finestre <i>french windows</i>	1601 < H > 1800	490
	1801 < H > 2000	1090
	2001 < H > 2200	1090
	2201 < H > 2460	1090

altezza cremonese standard  
*standard cremone bolt height*

N.B. lavorazioni e dimensioni valide anche per AC1291-2  
*note: processing and dimensions valid also for ac1291-2*

Fori per inserimento quadro comando e fissaggio maniglia  
*Holes for fitting the control panel and securing the handle*

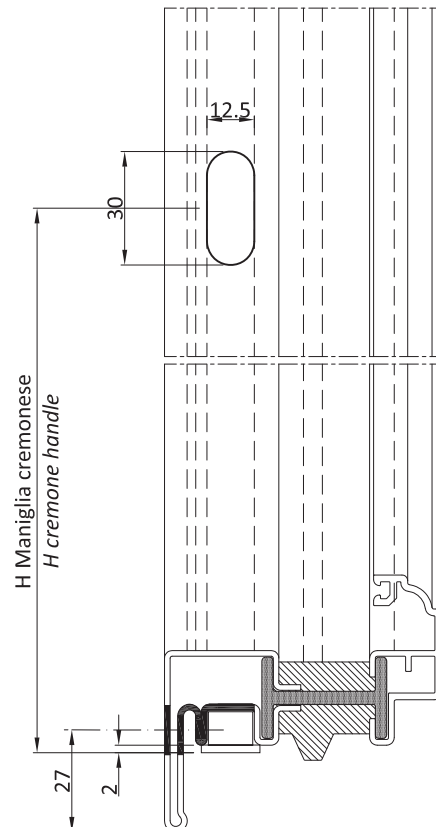


\*verificare Ø fori con sistema DK scelto  
*\*check holes ø with chosen DK system*

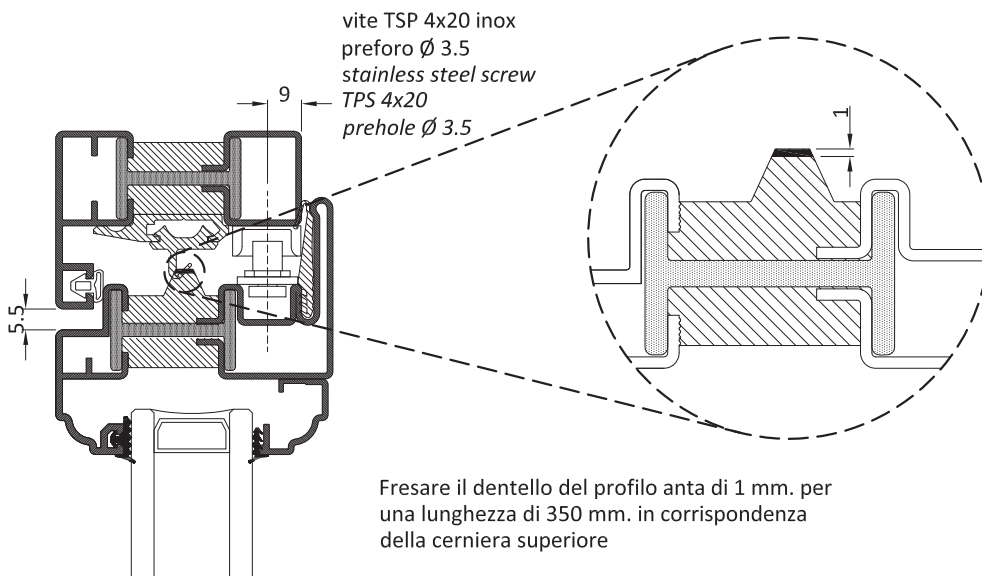
N.B. lavorazione valida per AC5056

*note: processing valid for AC5056*

Asola per inserimento meccanismo cremonese  
*Slot for espagnolette mechanism insertion*



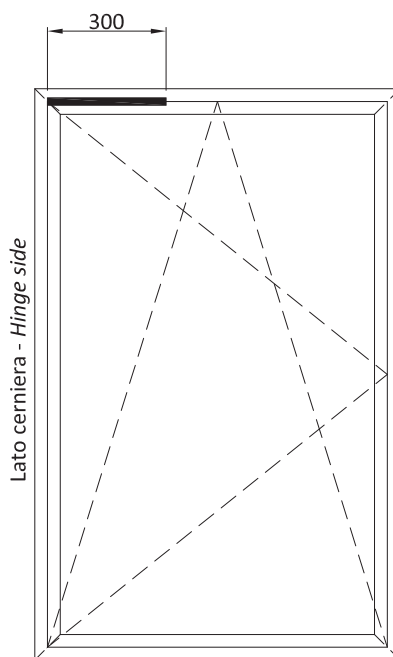
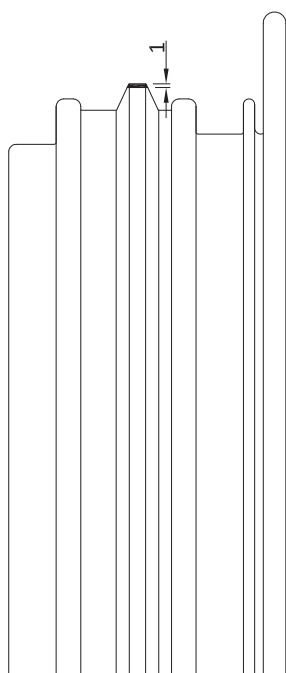
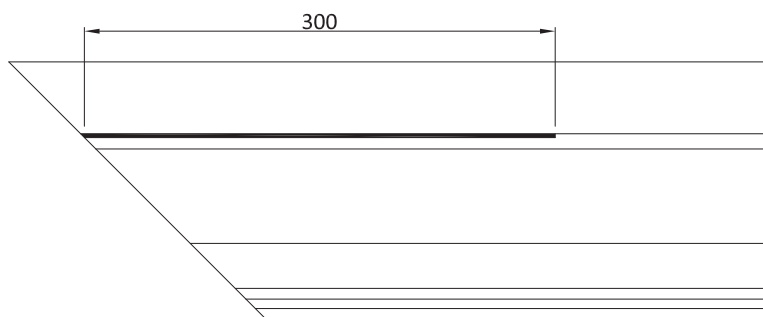
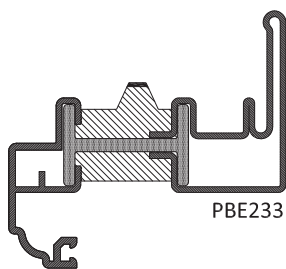


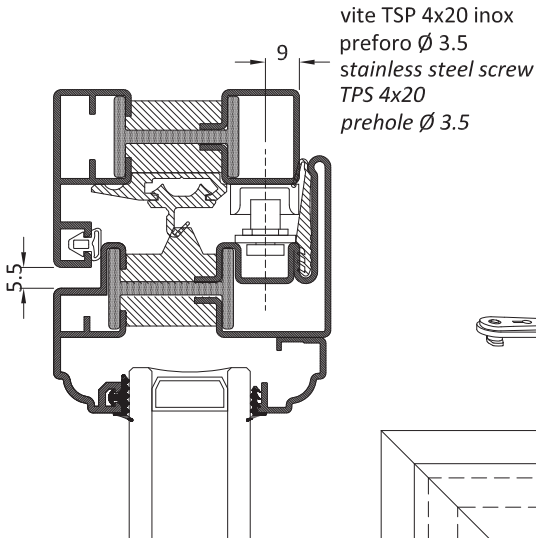


vite TSP 4x20 inox  
preforo Ø 3.5  
stainless steel screw  
TPS 4x20  
prehole Ø 3.5

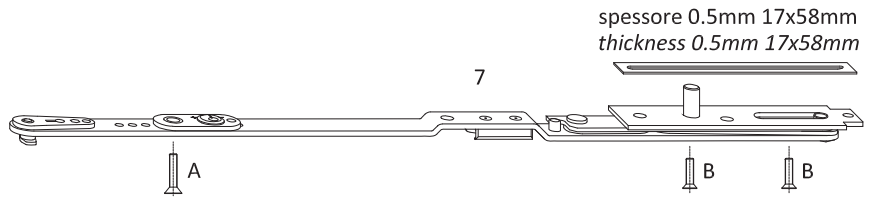
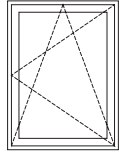
Fresare il dentello del profilo anta di 1 mm. per una lunghezza di 350 mm. in corrispondenza della cerniera superiore

*Mill the tooth of the 1 mm leaf profile for a length of 350 mm corresponding to the top hinge*

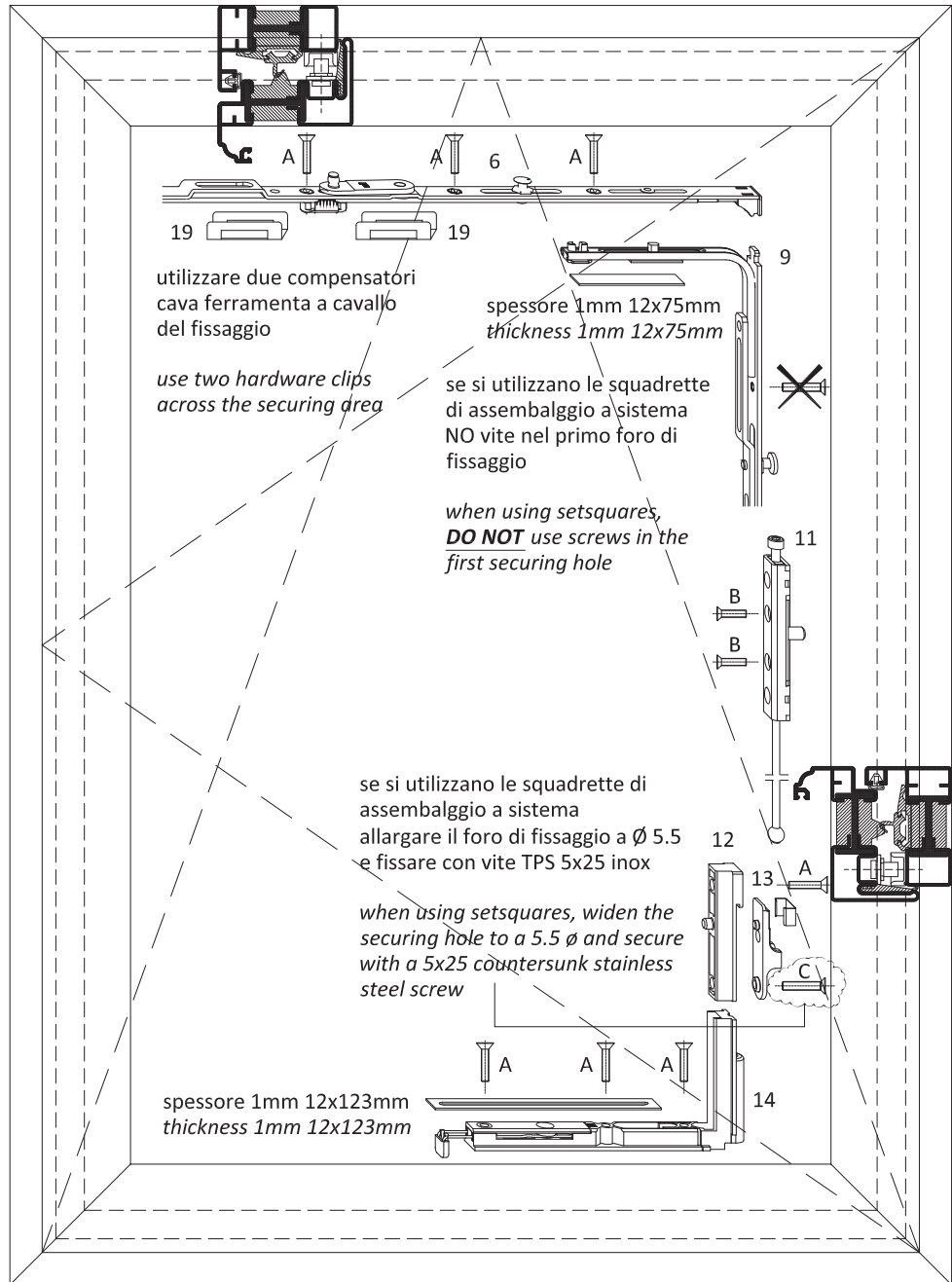




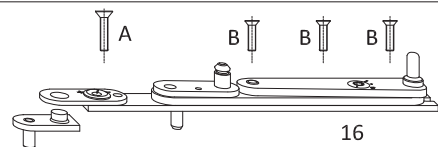
vite TSP 4x20 inox  
preforo  $\varnothing$  3.5  
stainless steel screw  
TPS 4x20  
prehole  $\varnothing$  3.5

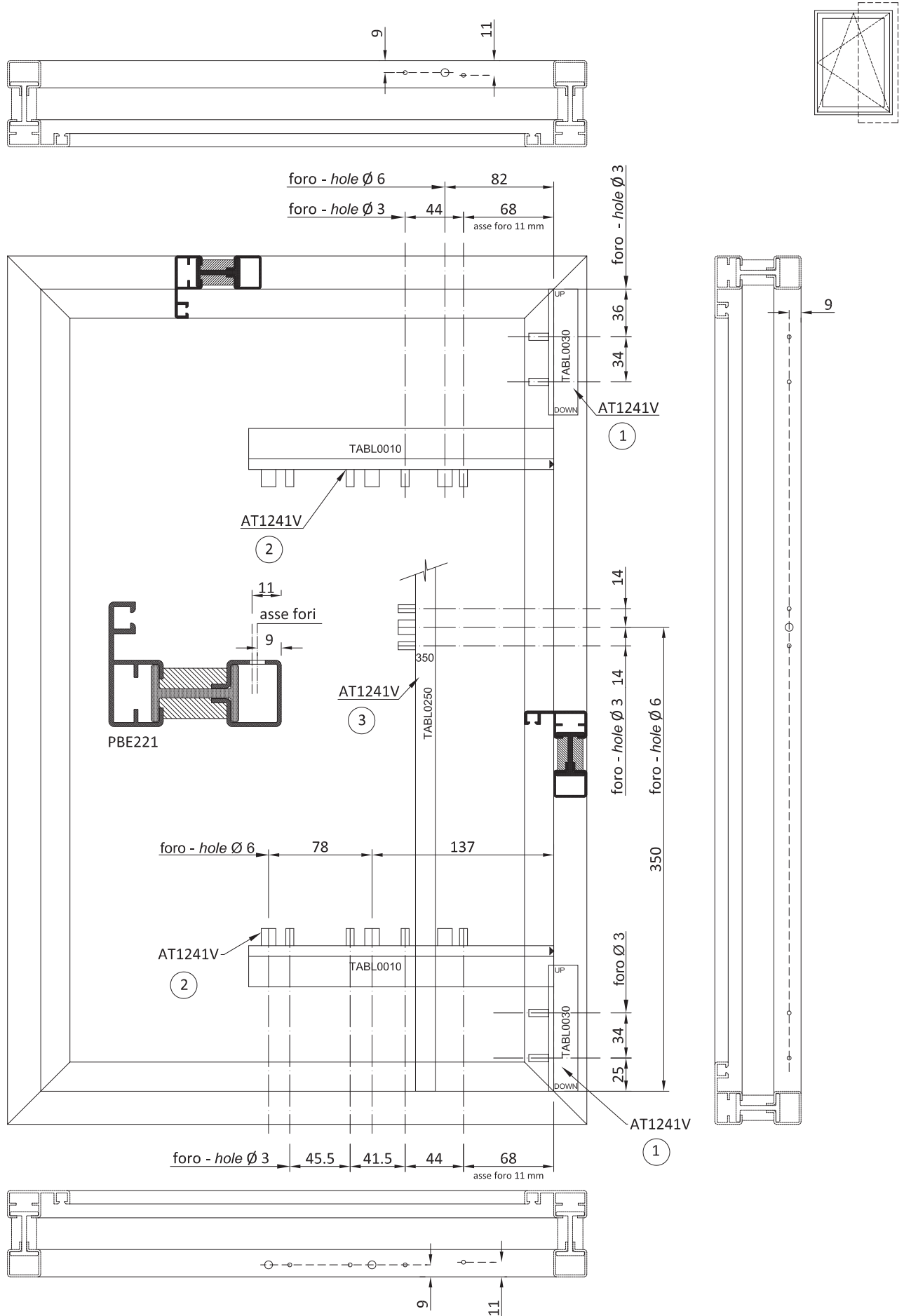


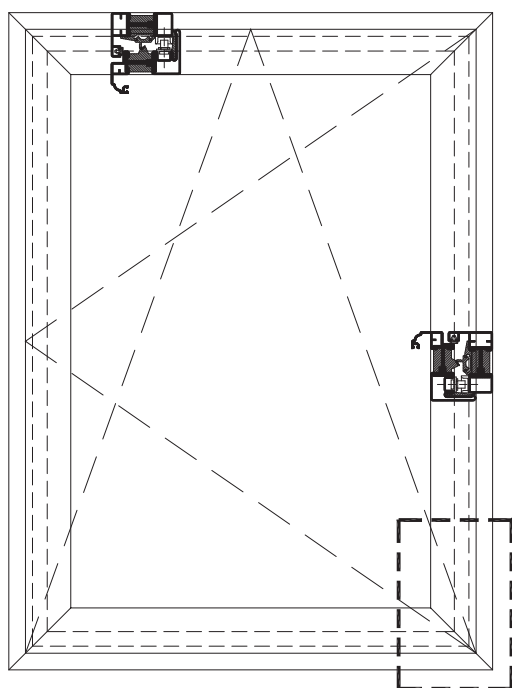
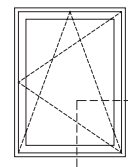
spessore 0.5mm 17x58mm  
thickness 0.5mm 17x58mm



- A vite trilobata TPS 4x20 inox  
countersunk trilobe 4x16 stainless  
steel screw
- B vite trilobata TPS 4x16 inox testa  
ribassata  
countersunk trilobe 4x16 stainless  
steel screw with reduced head
- C vite TPS 5x25 inox  
countersunk 5x25 stainless steel  
screw





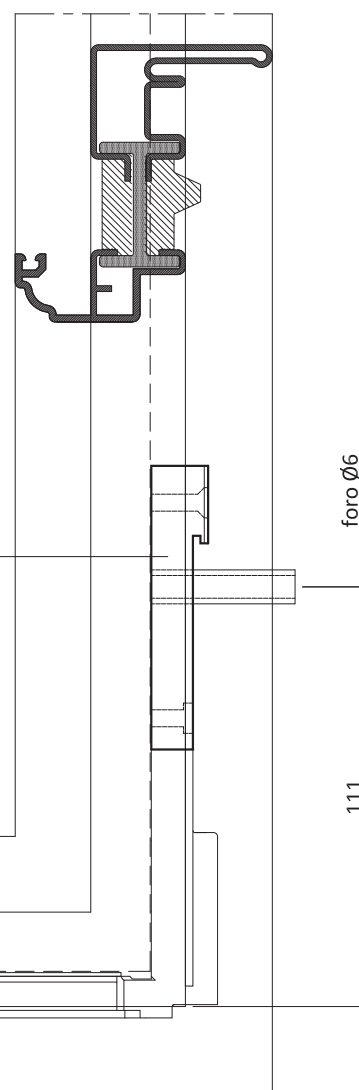


appoggiare la dima alla cerniera inferiore per i fori di fissaggio del supporto tirante (12)

*lay the drill jig on the lower hinge to drill the holes for the supporting rod (12)*

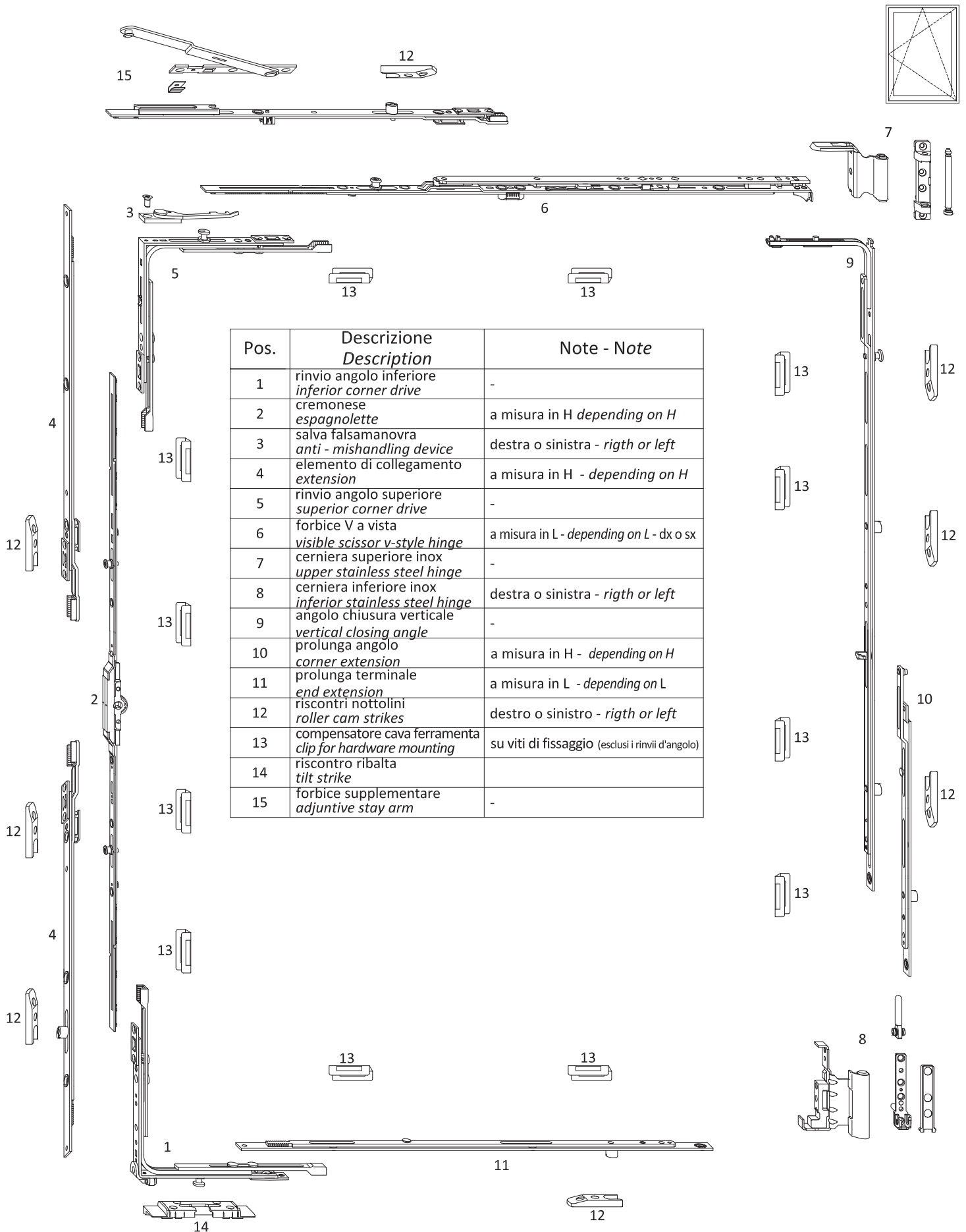
ATTENZIONE alla lavorazione specifica se si utilizzano le squadrette di assiemaggio

*pay ATTENTION to the specific processing procedure if set squares are used*

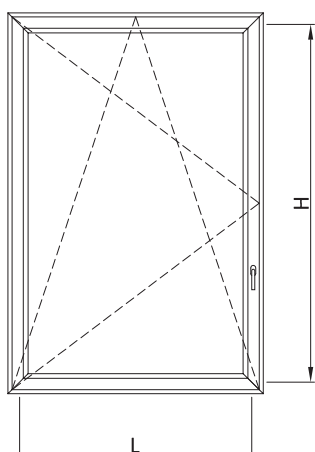
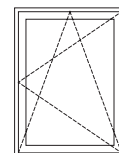


posizionare la cerniera inferiore (14) con lo spessore in dotazione

*position the lower hinge (14) with the support provided*

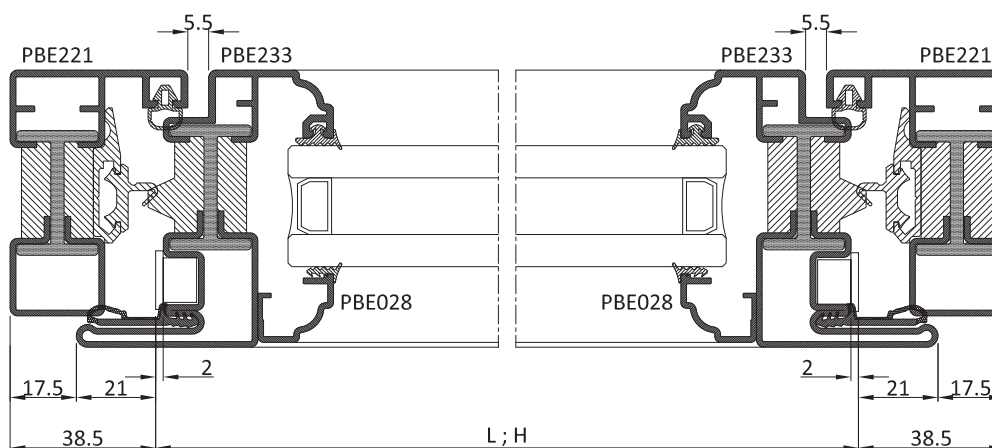


limiti dimensionali anta ribalta  
*dimensional limits for tilt and turn windows*

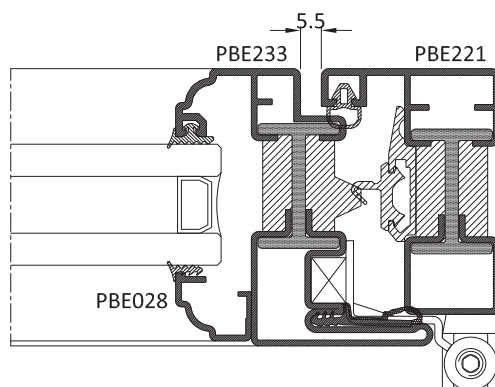
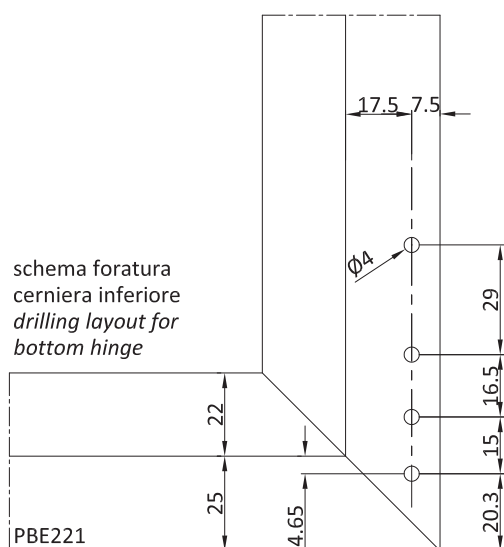
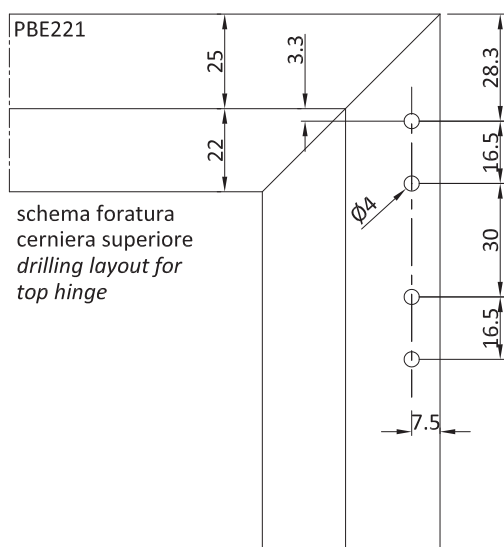
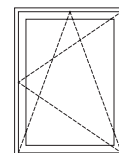


limiti dimensionali anta - <i>dimensional limits for leaf</i>			
	1 anta	2 ante	
finestre <i>windows</i>	350<L<1500	700<L<2400	L < H 130 kg (cern a vista) <i>(stainless steel hinges)</i>
porte finestre <i>windows</i>	350<L<1260	700<L<2400	L < 2/3 H 130 kg (cern a vista) <i>(stainless steel hinges)</i>

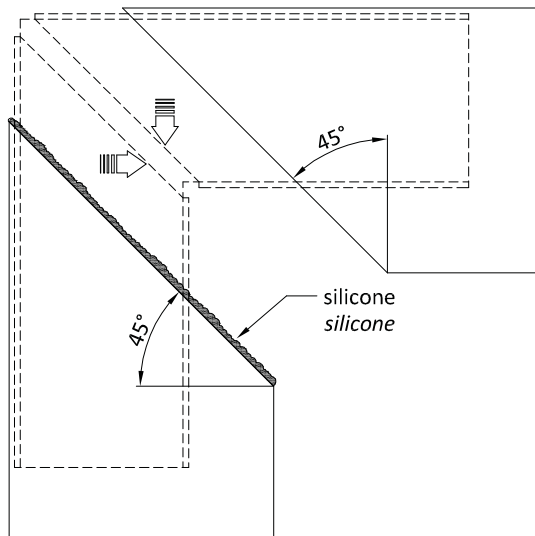
riferimento misure (cava ferramenta)  
*measure reference (hardware reference)*



H \ L	601 800	801 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2460
290 - 410	A9	B9	C9	D9	E9	F9	G9	H9	I9
411 - 570	A0	B0	C0	D0	E0	F0	G0	H0	I0
571 - 800	A1	B1	C1	D1	E1	F1	G1	H1	I1
801 - 1030		B2	C2	D2	E2	F2	G2	H2	I2
1031 - 1260			C3	D3	E3	F3	G3	H3	I3
1260 - 1490				D4	E4				

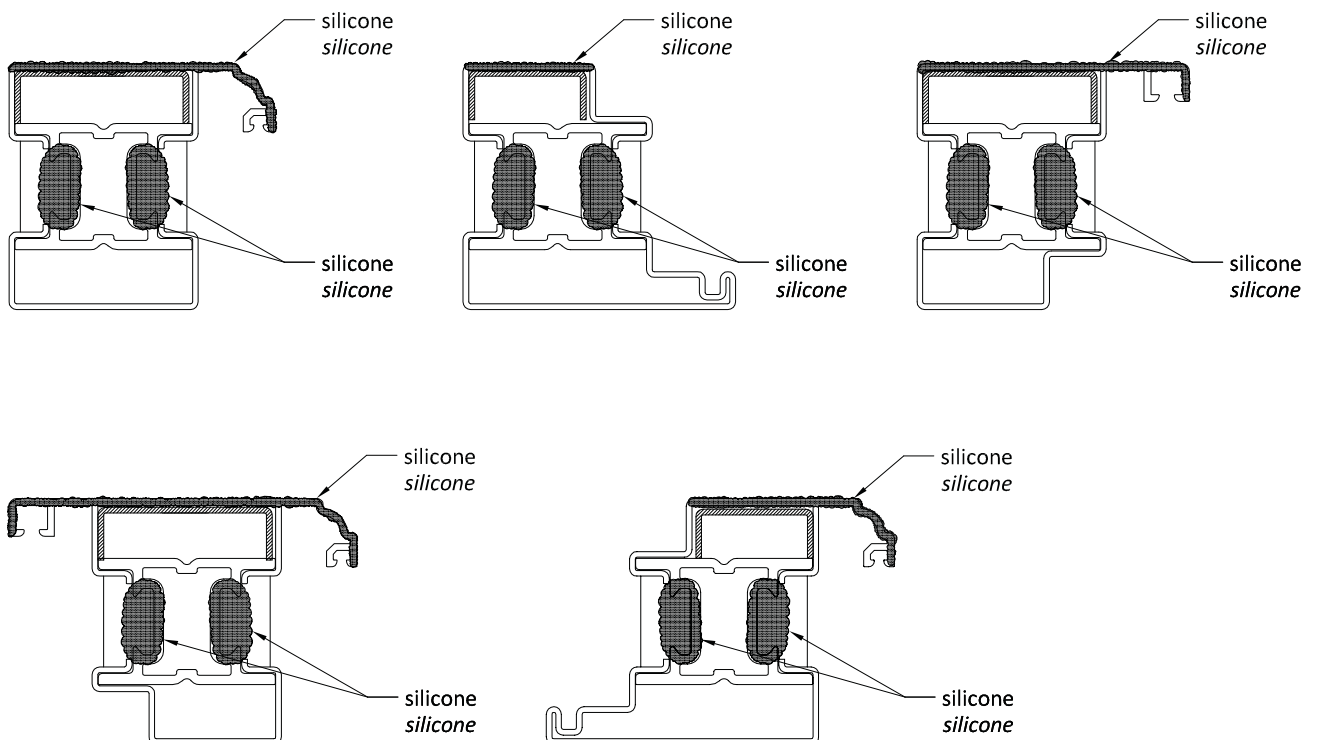


- lavorazioni effettuabili con AT1242  
- working possible with AT1242

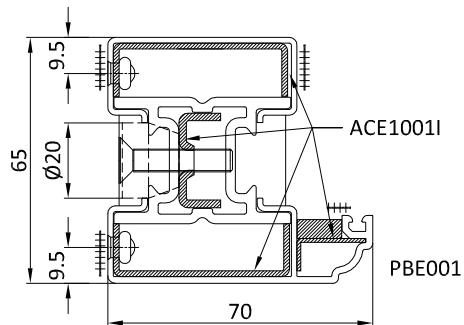
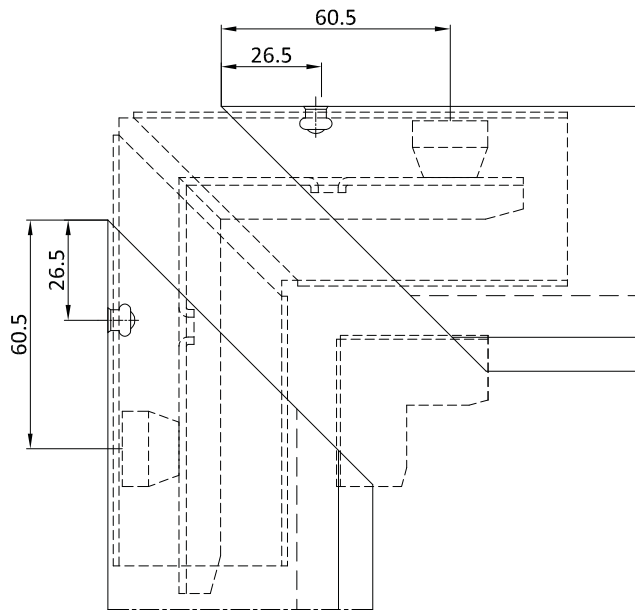


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)


- 1) insert the bracket
- 2) seal in the specified areas
- 3) joint the profiles
- 4) weld (see following pages)






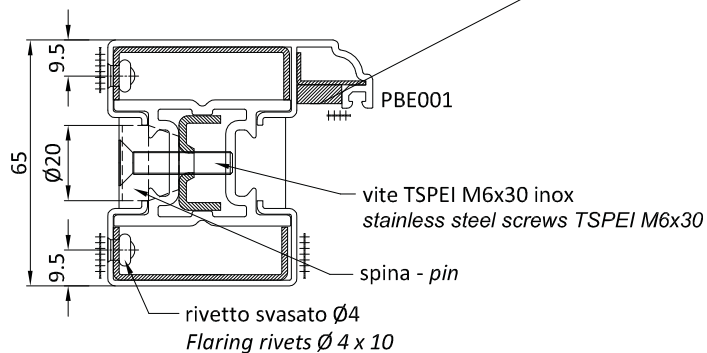
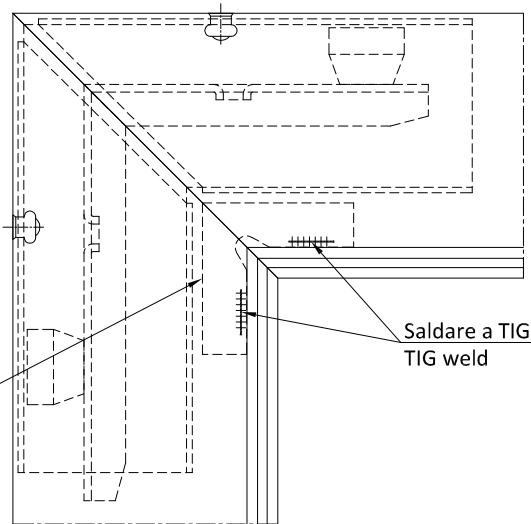
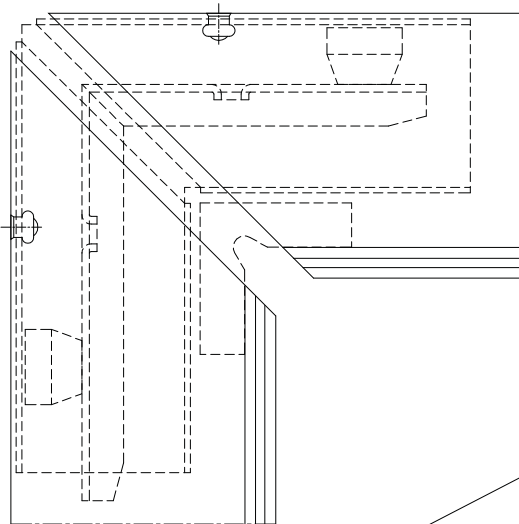
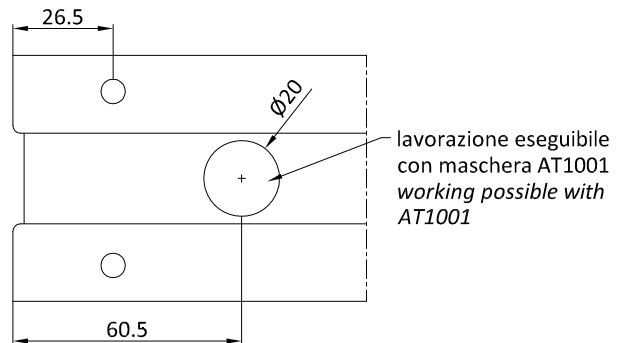


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
Sigillare tutte le superfici di contatto esterne con silicone

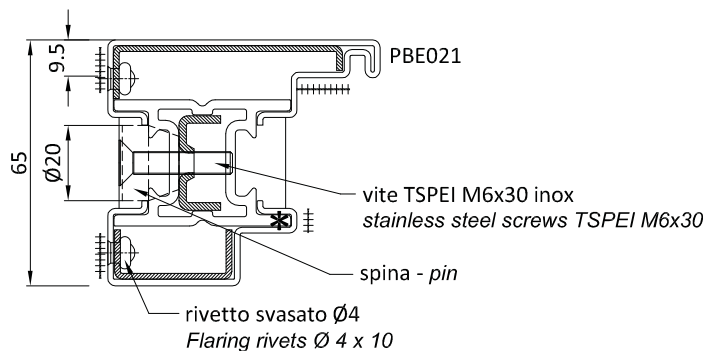
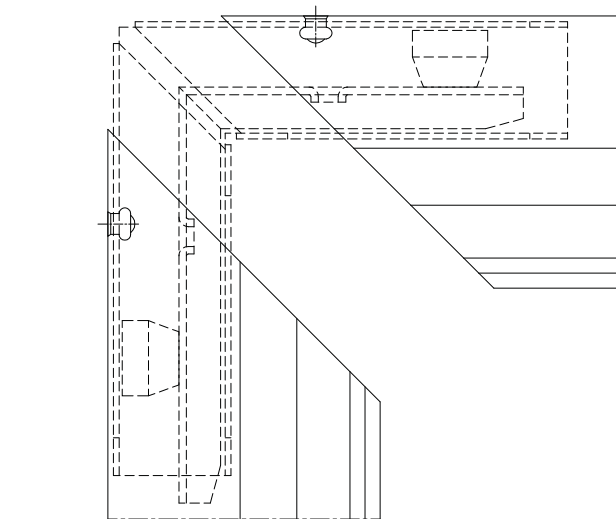
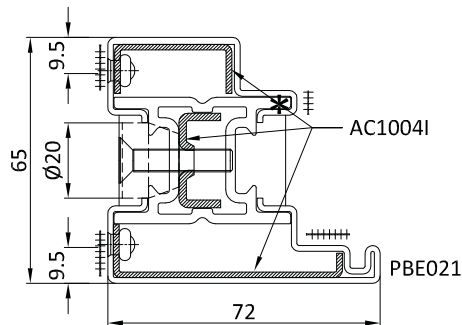
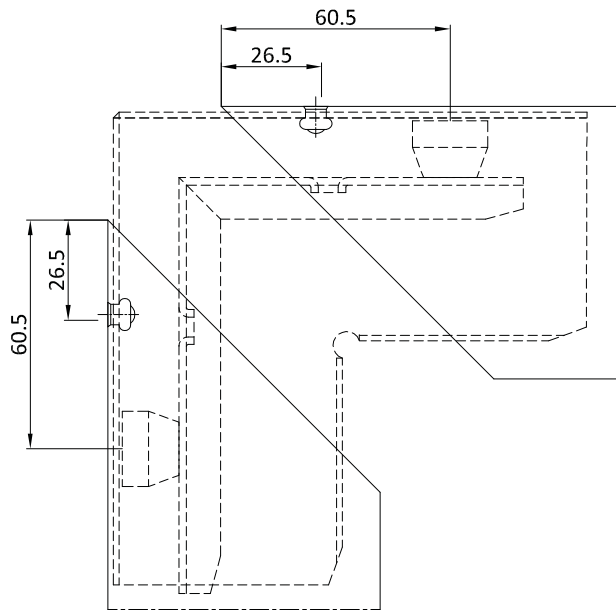
 Rivetti svasati Ø 4 x 10

TIG welding with filler material\*\* in the areas indicated with ++++  
Seal all the external contact surfaces with silicone


 Flaring rivets Ø 4 x 10




\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A

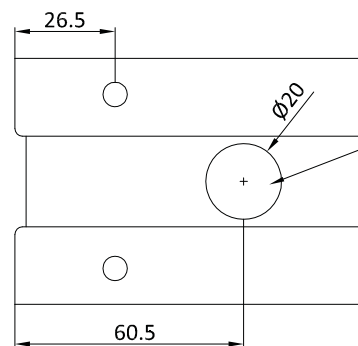


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
 Sigillare tutte le superfici di contatto esterne con silicone  
 Asportare il poliammide dagli angoli prima di eseguire le saldature  
 nelle zone indicate con \*

 Rivetti svasati Ø 4 x 10

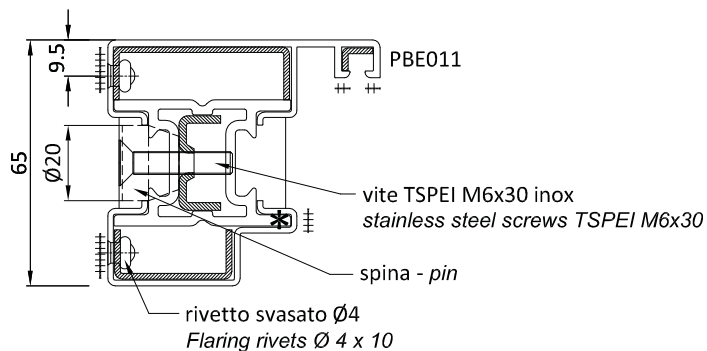
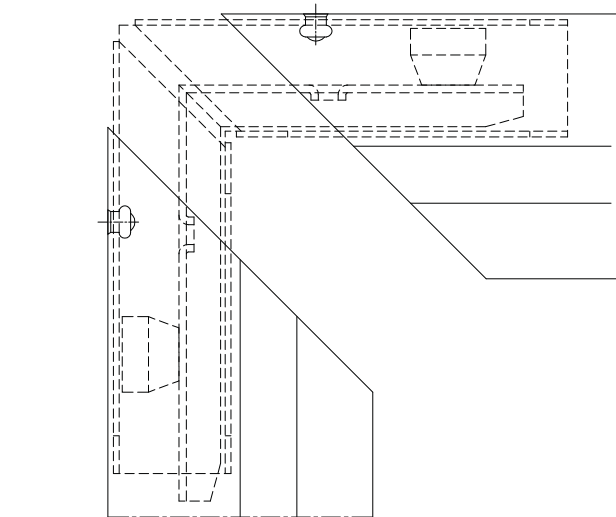
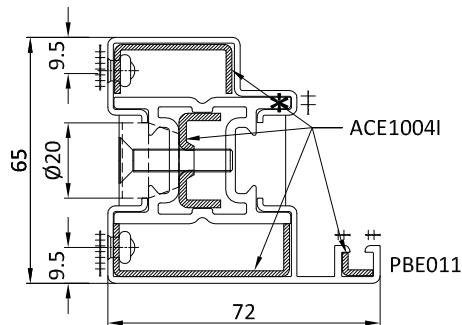
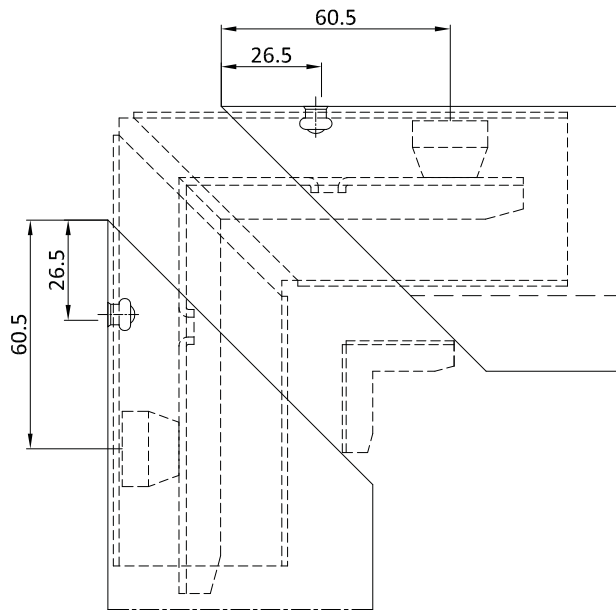
*TIG welding with filler material\*\* in the areas indicated with ++++*  
*Seal all the external contact surfaces with silicone*  
*Before welding please remove the polyamide from corner*  
*areas specified with \**

 Flaring rivets Ø 4 x 10



lavorazione eseguibile  
 con maschera AT1001  
 working possible with  
 AT1001

\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
 wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A

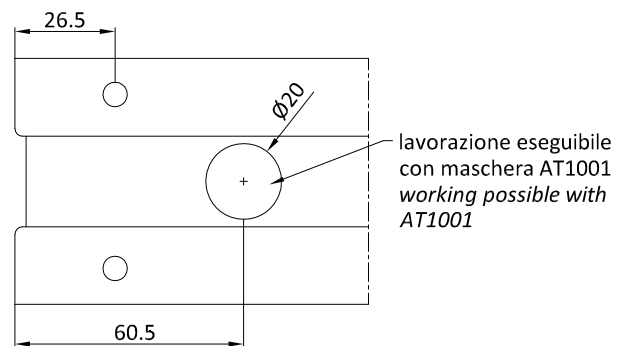


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
 Sigillare tutte le superfici di contatto esterne con silicone  
 Asportare il poliammide dagli angoli prima di eseguire le saldature  
 nelle zone indicate con \*

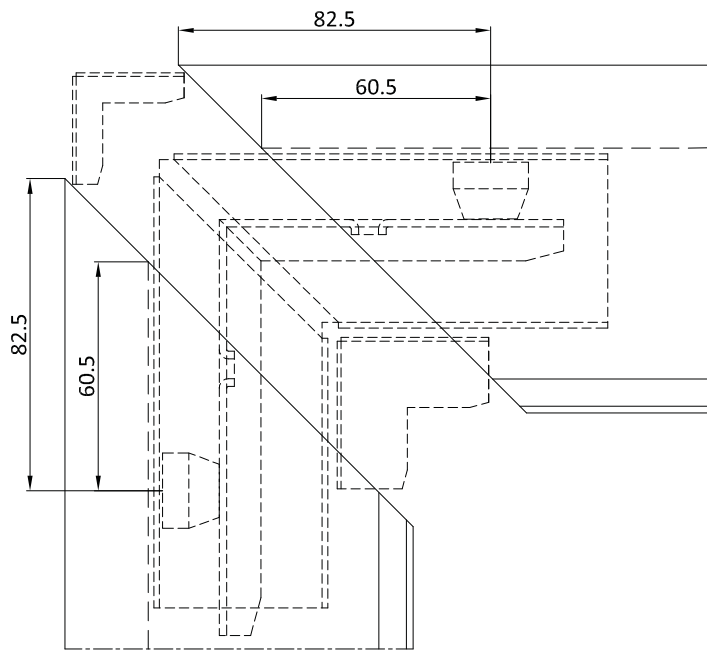
Rivetti svasati Ø 4 x 10

*TIG welding with filler material\*\* in the areas indicated with ++++  
 Seal all the external contact surfaces with silicone  
 Before welding please remove the polyamide from corner  
 areas specified with \**

Flaring rivets Ø 4 x 10

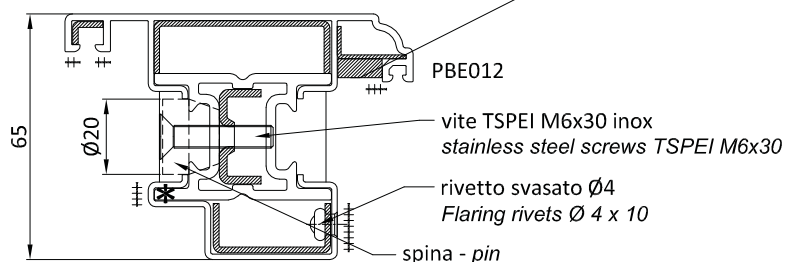
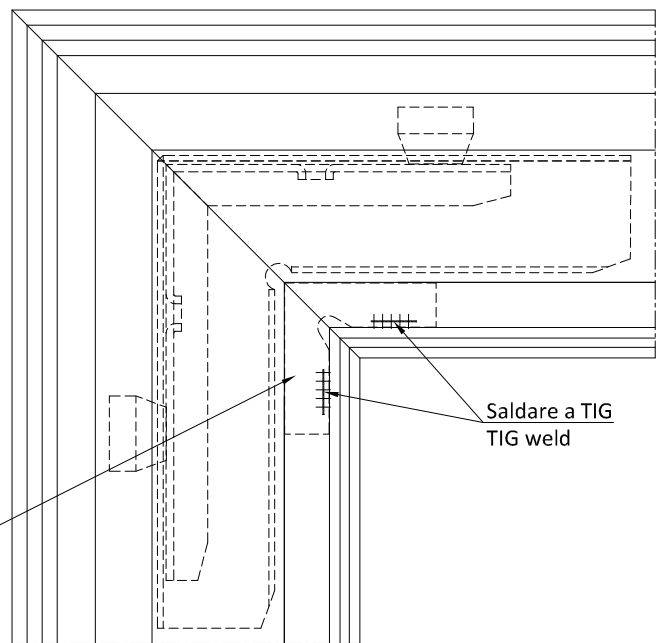
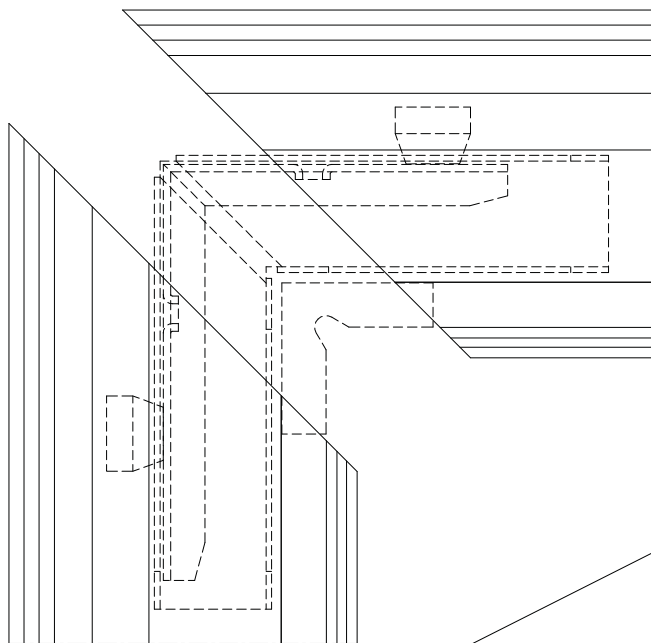
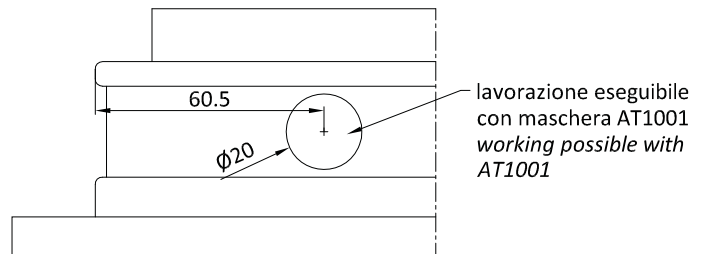
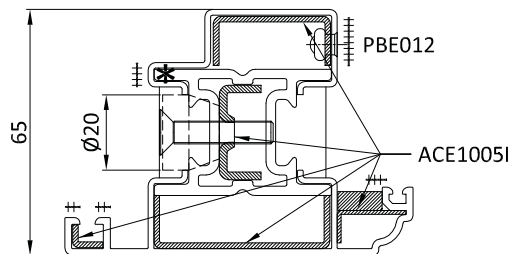


\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
 wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A

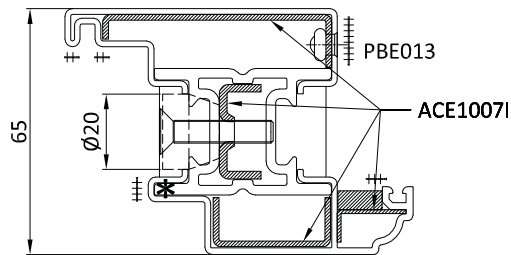
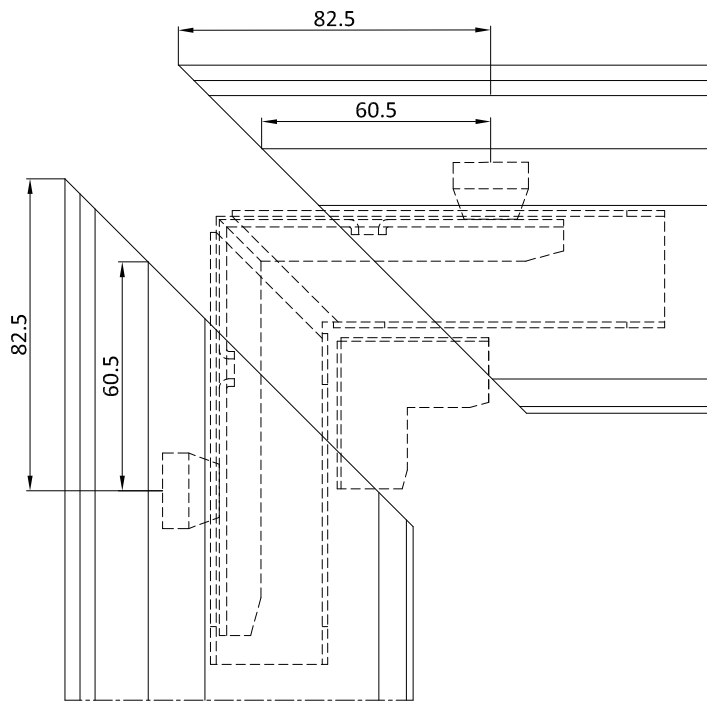


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
 Sigillare tutte le superfici di contatto esterne con silicone  
 Asportare il poliammide dagli angoli prima di eseguire le saldature  
 nelle zone indicate con \*

*TIG welding with filler material\*\* in the areas indicated with ++++  
 Seal all the external contact surfaces with silicone  
 Before welding please remove the polyamide from corner  
 areas specified with \**

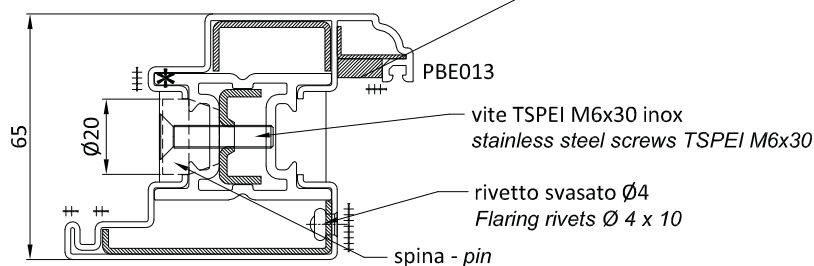
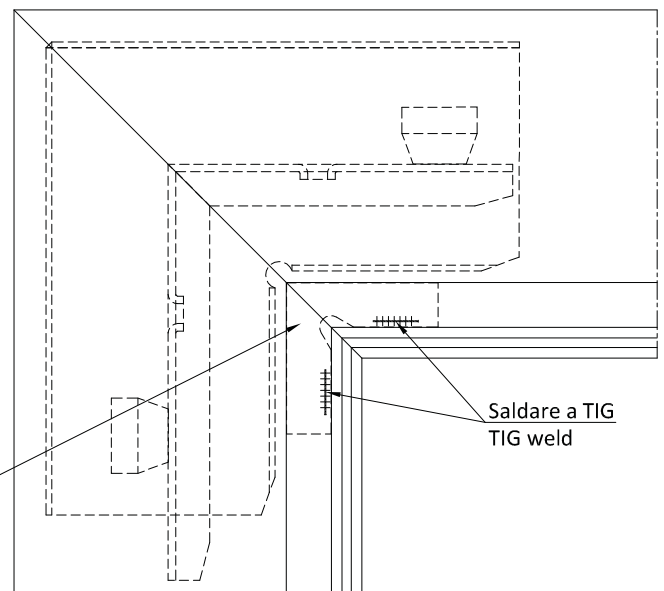
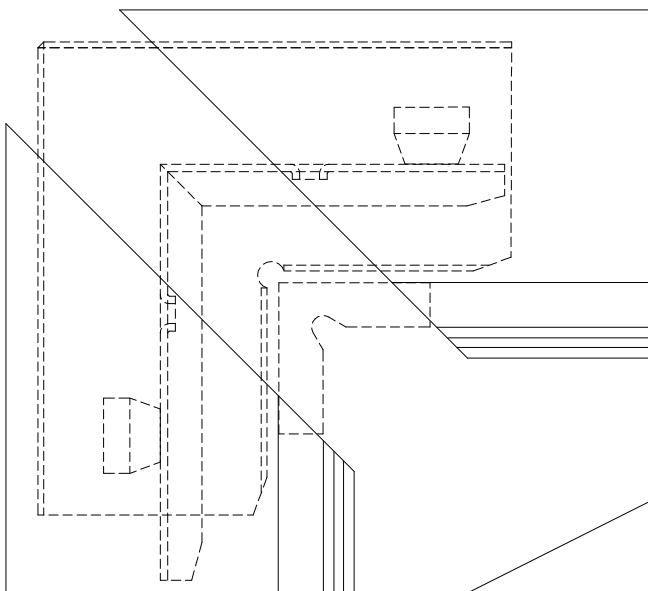
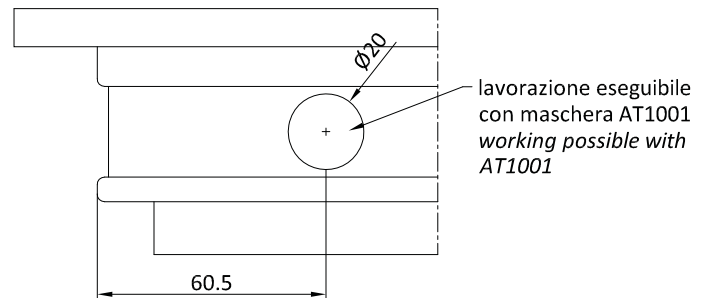


\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
 wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A

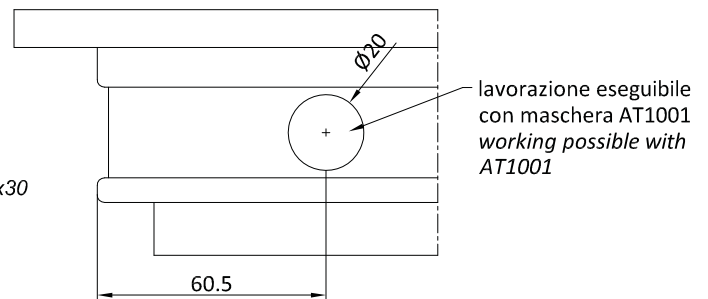
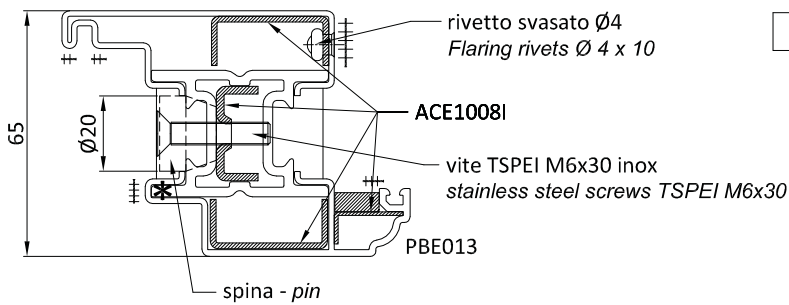
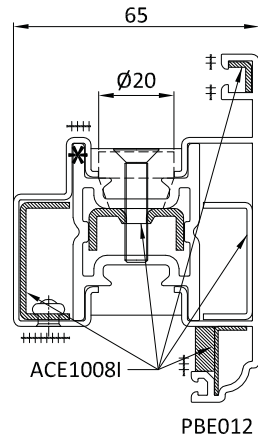
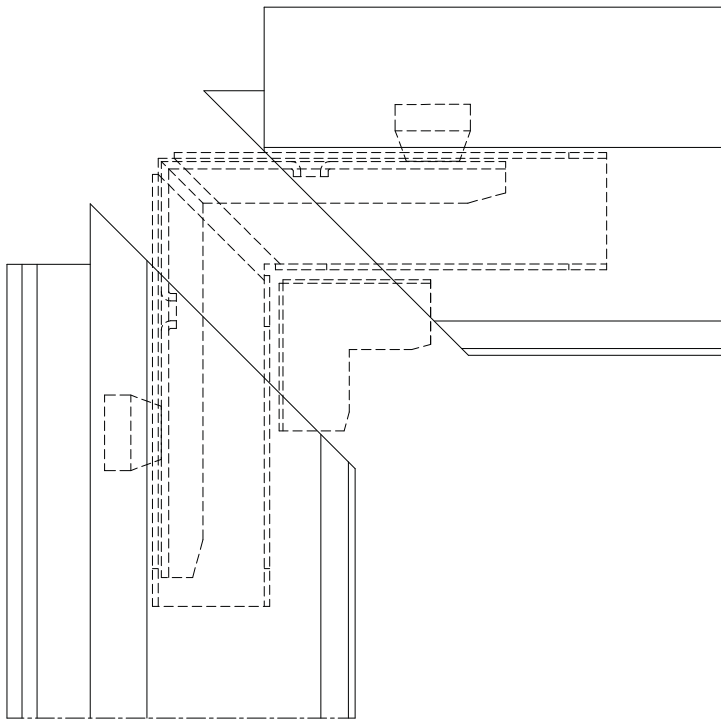


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
 Sigillare tutte le superfici di contatto esterne con silicone  
 Asportare il poliammide dagli angoli prima di eseguire le saldature  
 nelle zone indicate con \*

*TIG welding with filler material\*\* in the areas indicated with ++++  
 Seal all the external contact surfaces with silicone  
 Before welding please remove the polyamide from corner  
 areas specified with \**



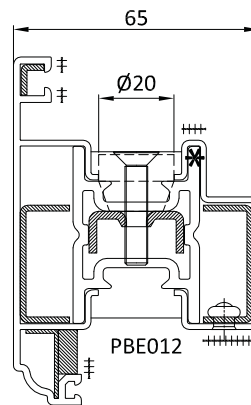
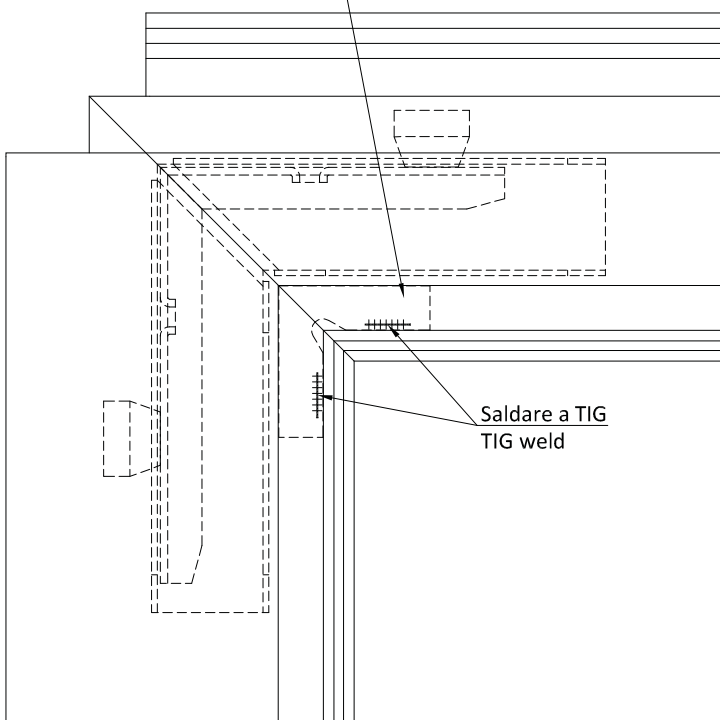
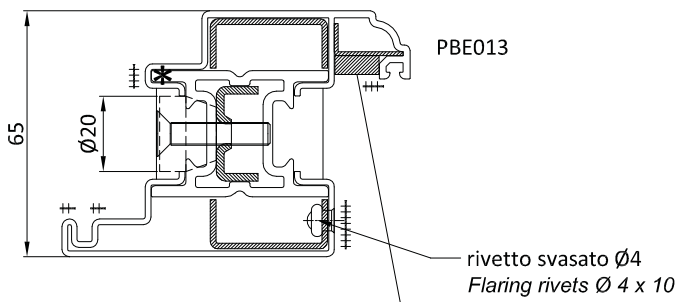
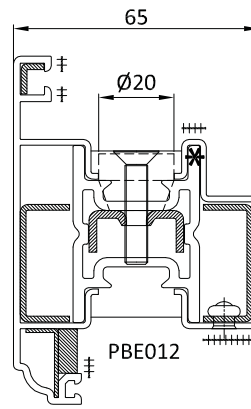
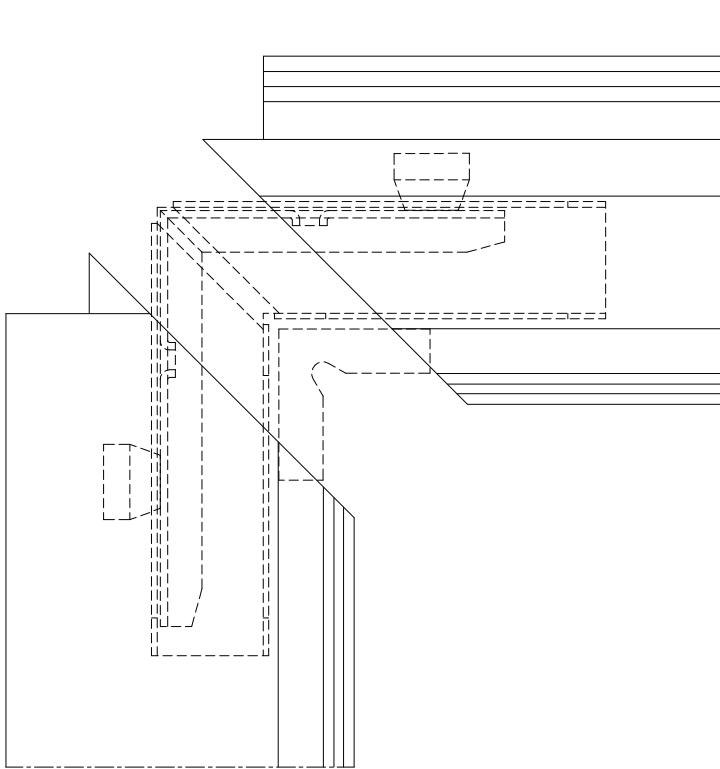
\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
 wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A

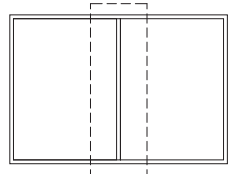
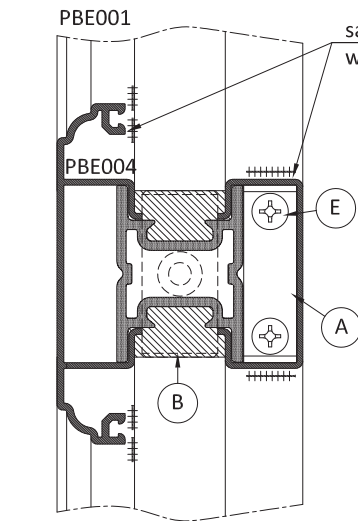
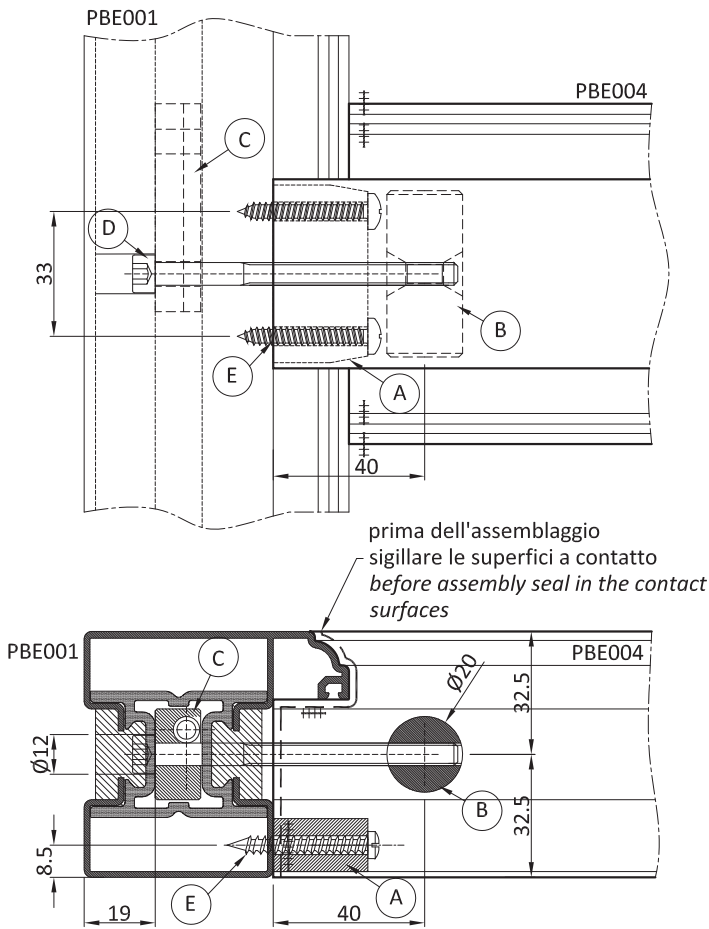


Saldare a TIG con materiale di riporto\*\* nelle zone indicate con ++++  
 Sigillare tutte le superfici di contatto esterne con silicone  
 Asportare il poliammide dagli angoli prima di eseguire le saldature  
 nelle zone indicate con \*

*TIG welding with filler material\*\* in the areas indicated with ++++*  
*Seal all the external contact surfaces with silicone*  
*Before welding please remove the polyamide from corner areas specified with \**

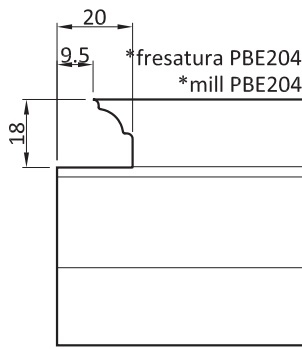
\*\* filo Ø1 mm Cu Si 3 - classificazione AWS A5.7 ER Cu Si-A  
 wire Ø1 Cu Si 3 - classification AWS A5.7 ER Cu Si-A





N.B. lavorazione valida per montanti e traversi anche su profilo porta PBE012 - PBE013

note: processing valid for transom and mullions also on pbe012 - pbe013 door profiles



- Sigillare con silicone tutte le superfici di contatto tra i profili che non vengono saldate

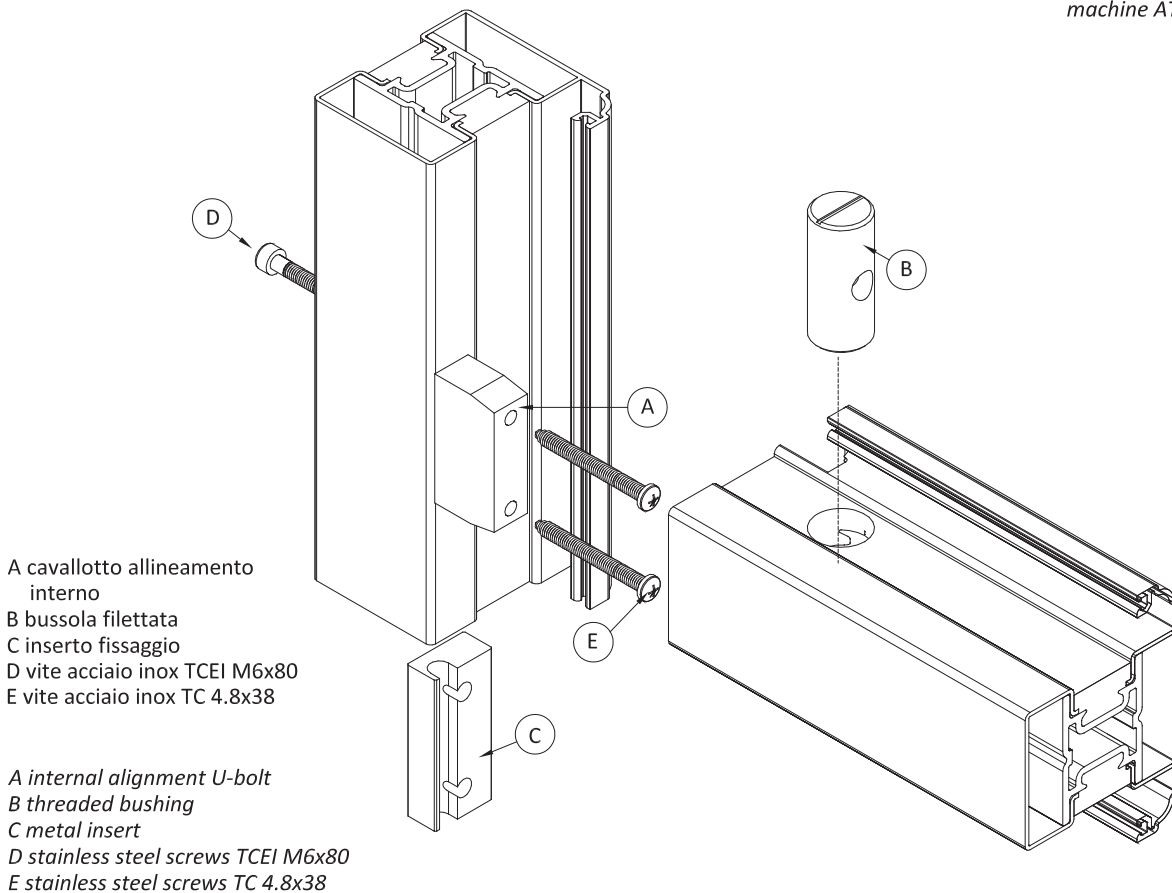
- Saldare nelle zone indicate con +++++

\* lavorazione eseguibile con fresa ATE004

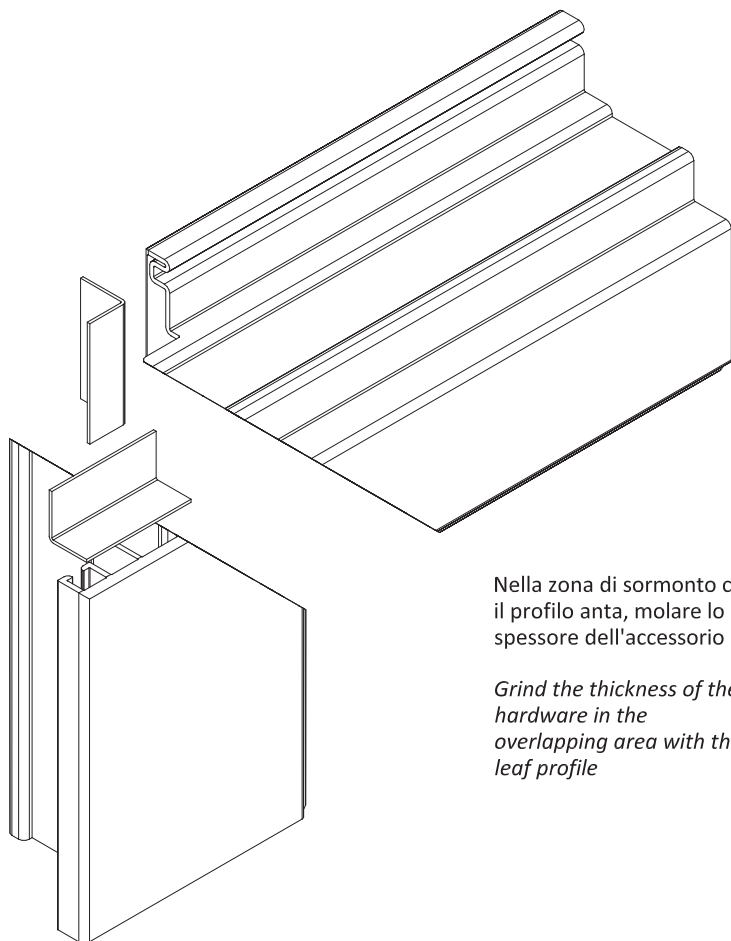
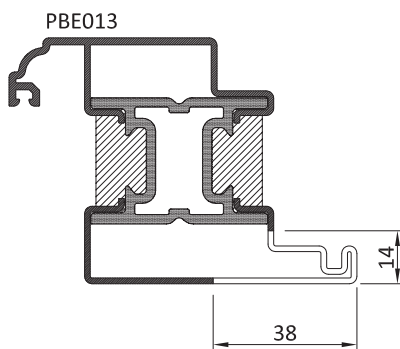
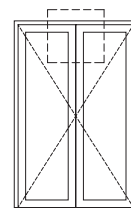
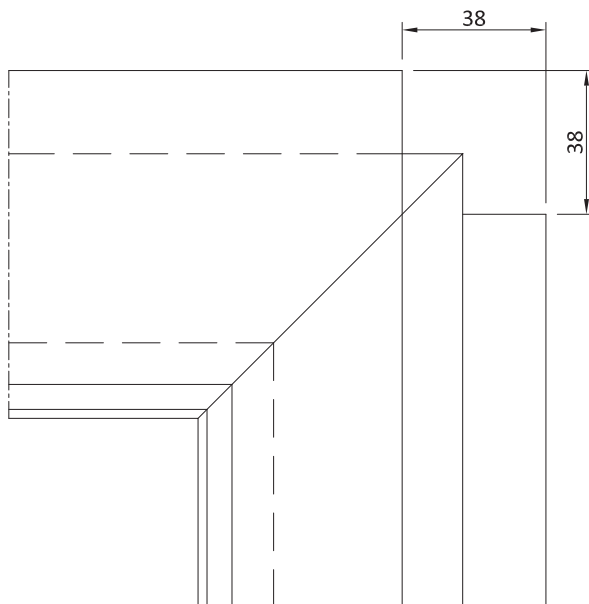
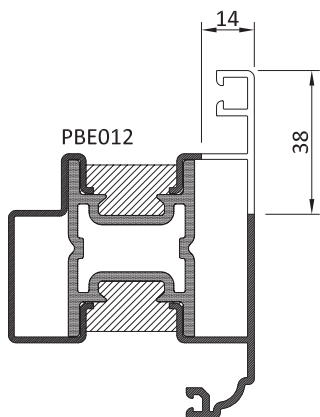
- Seal (with SL0019 sealant or silicone) all the contact surfaces between the profiles that are not welded surfaces

- weld in the zones indicated with +++++

\* working can be done with milling machine ATE004

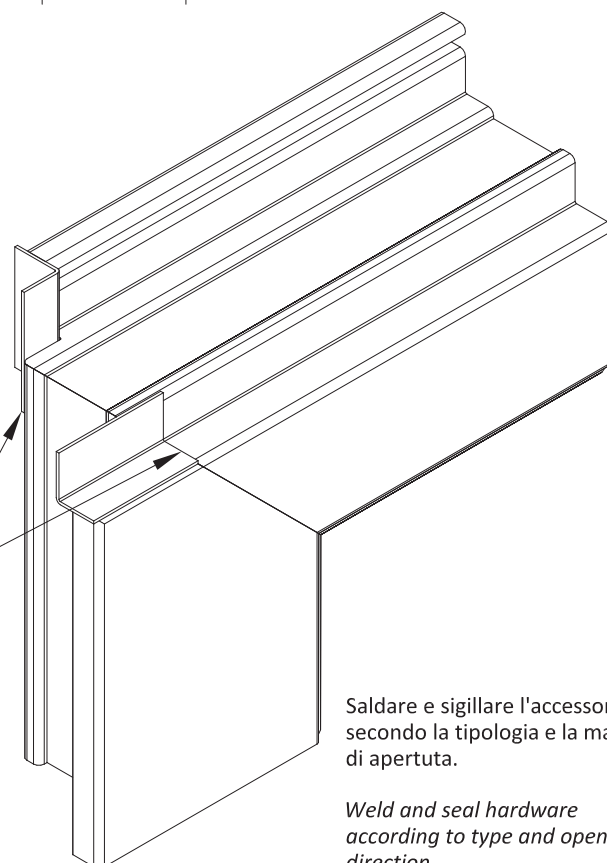






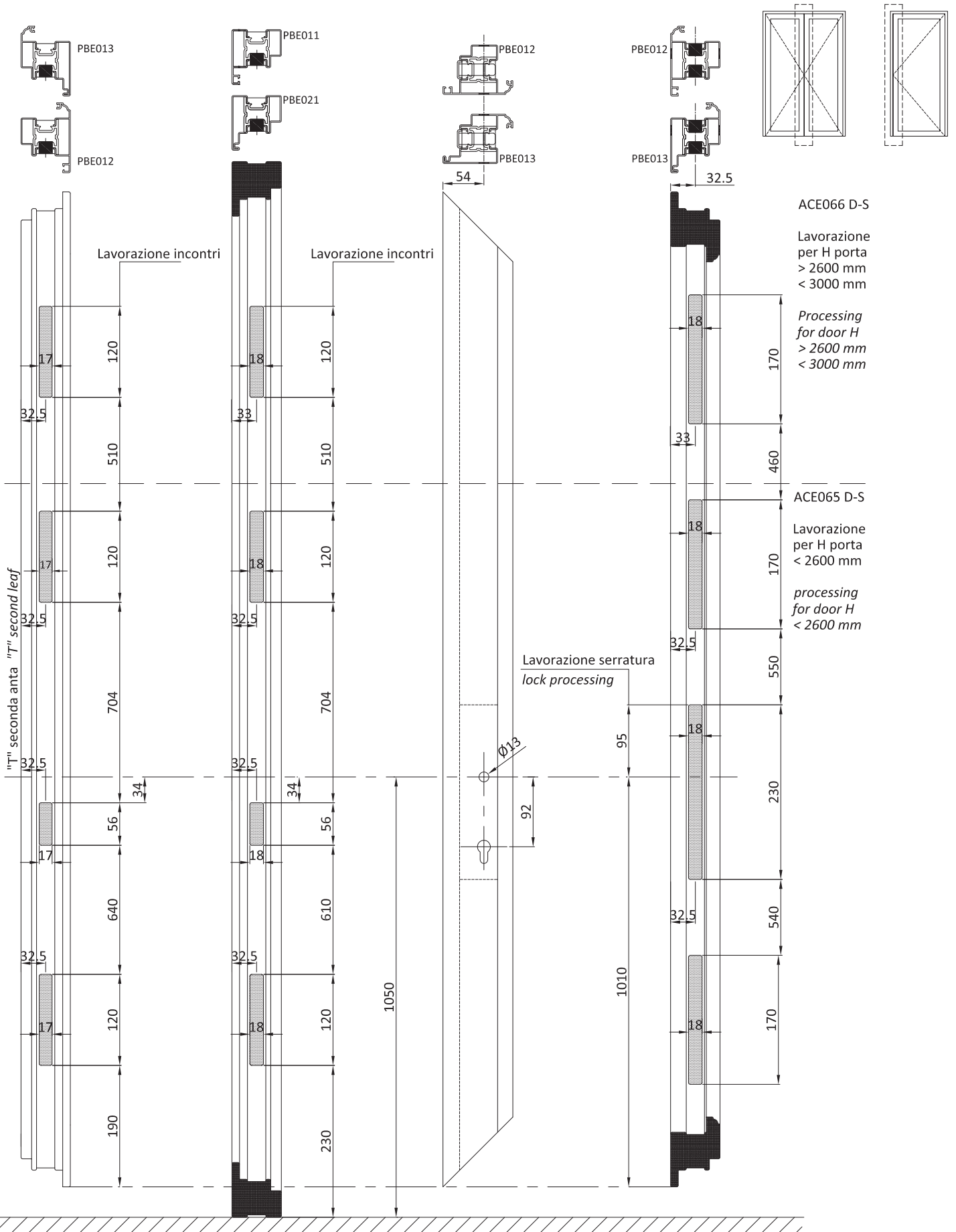
Nella zona di sormonto con il profilo anta, molare lo spessore dell'accessorio

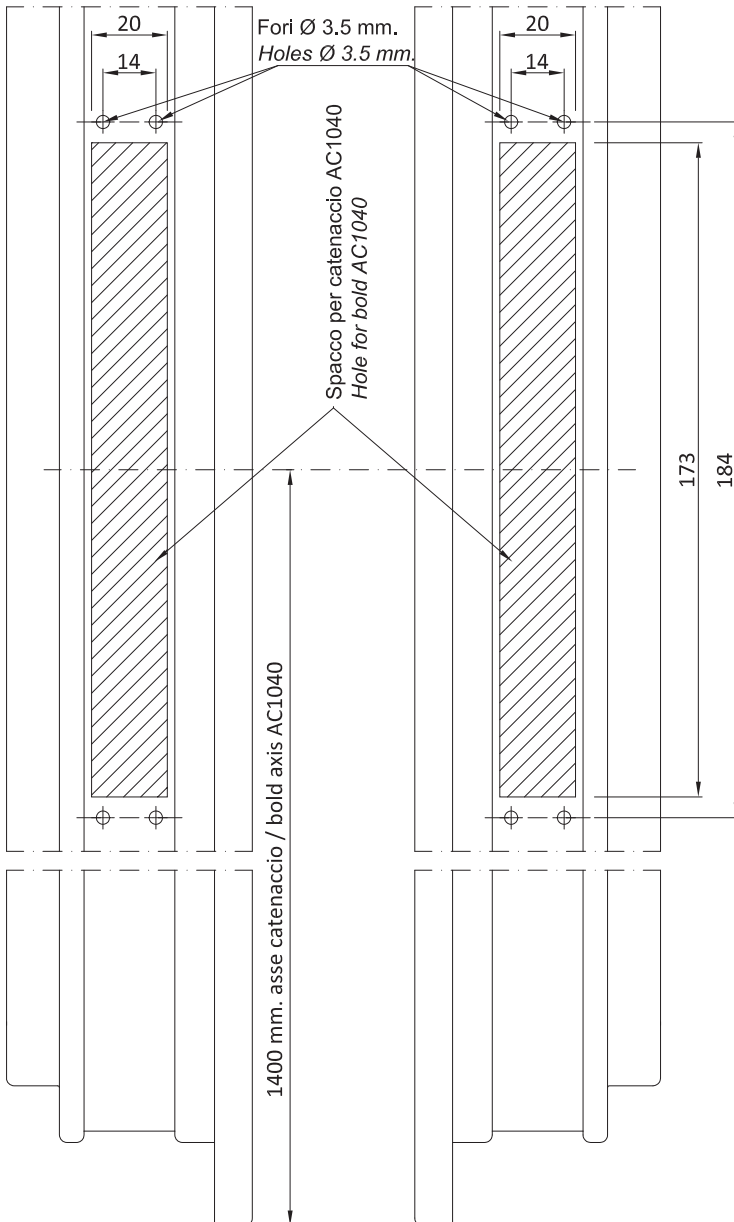
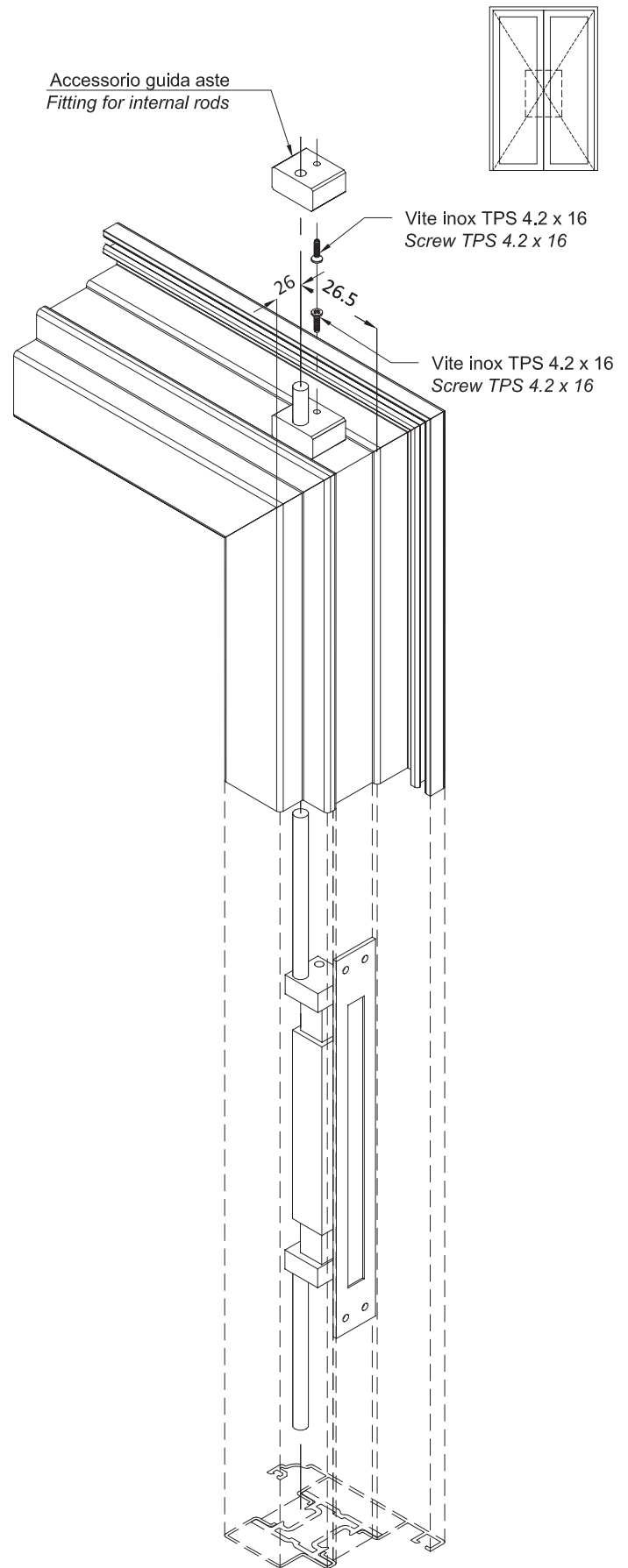
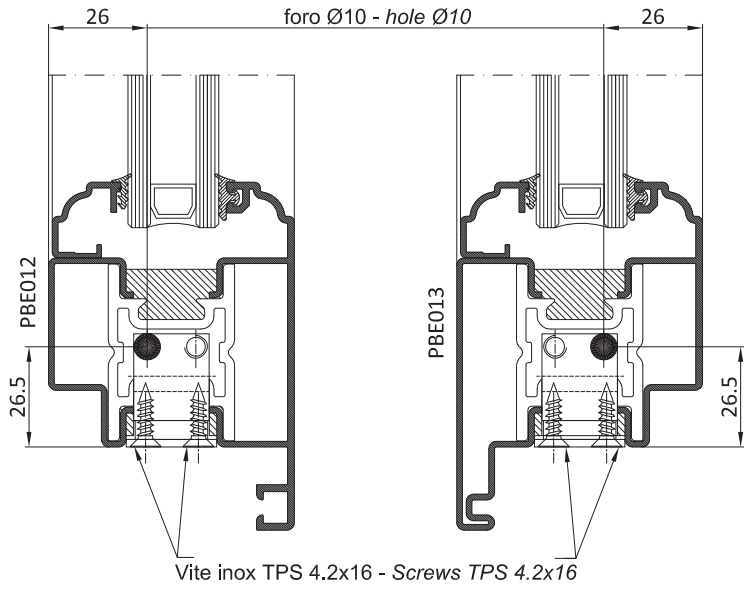
*Grind the thickness of the hardware in the overlapping area with the leaf profile*

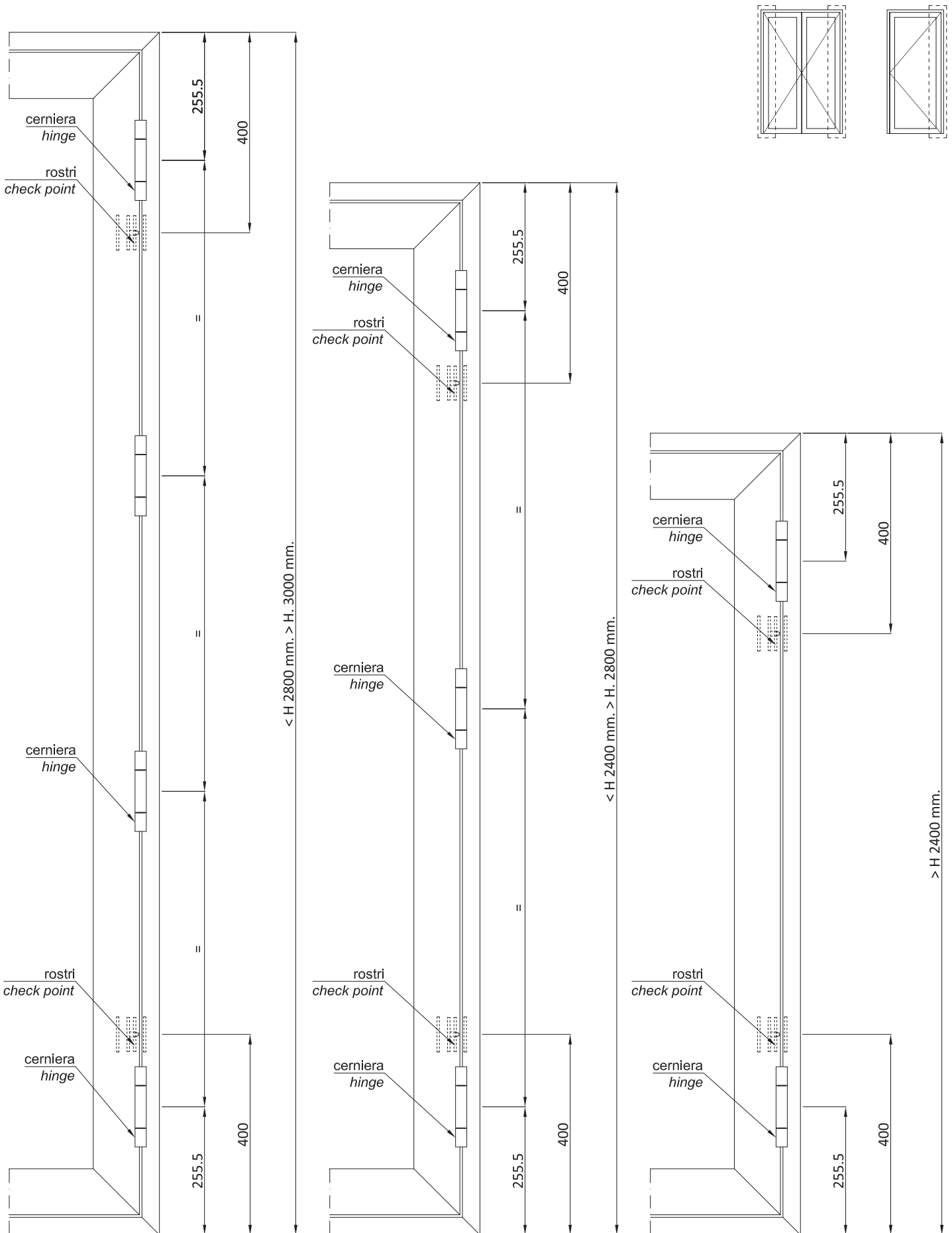


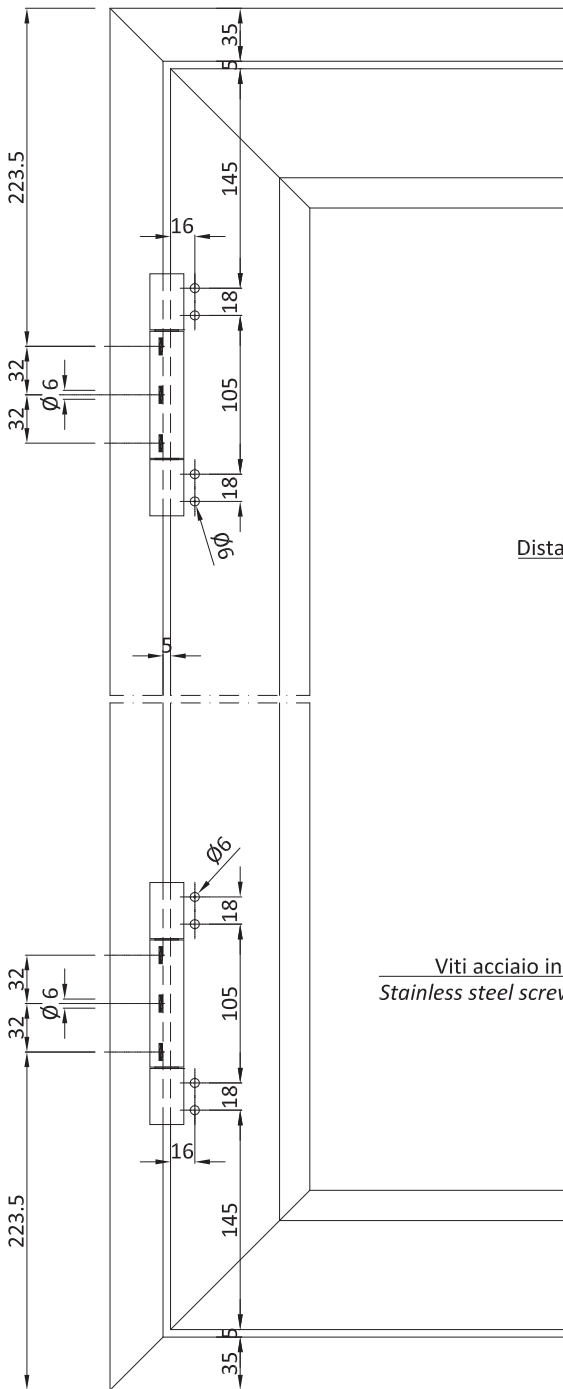
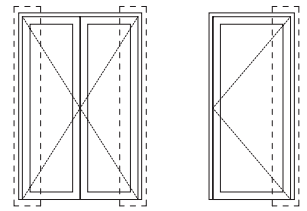
Saldare e sigillare l'accessorio secondo la tipologia e la mano di apertura.

*Weld and seal hardware according to type and opening direction*

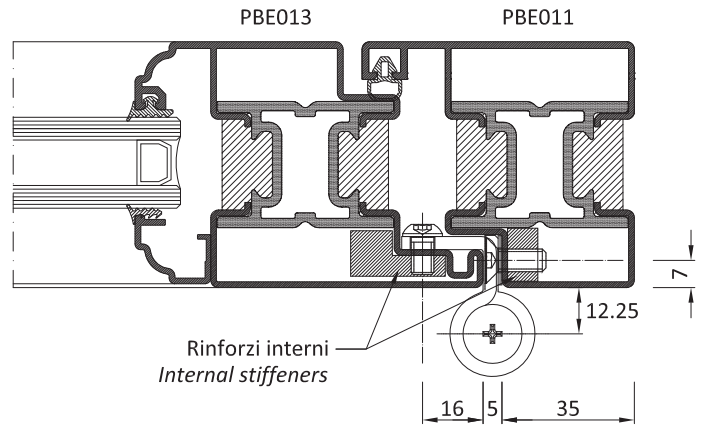








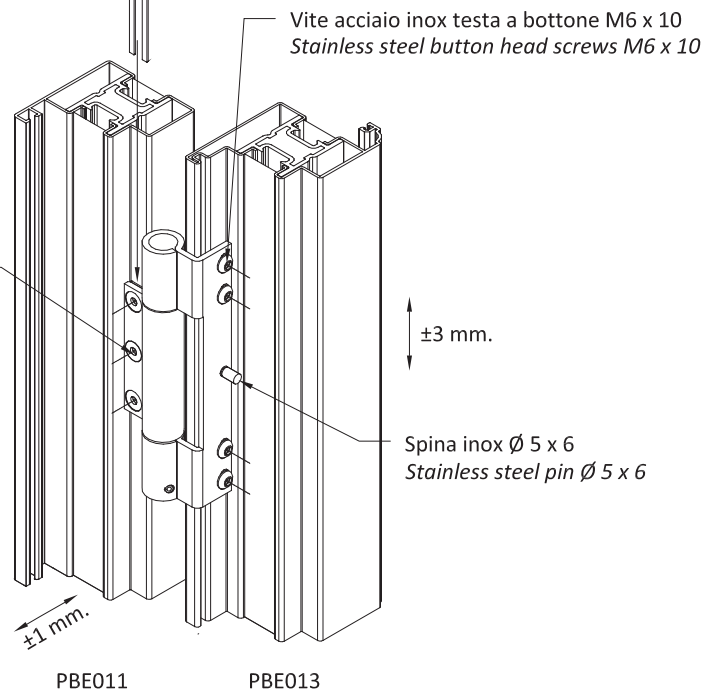
▮ foro - hole Ø 6



Distanziale di regolazione  
Regulating spacer

Viti acciaio inox TCEI M6 x 16  
Stainless steel screws TCEI M6 x 16

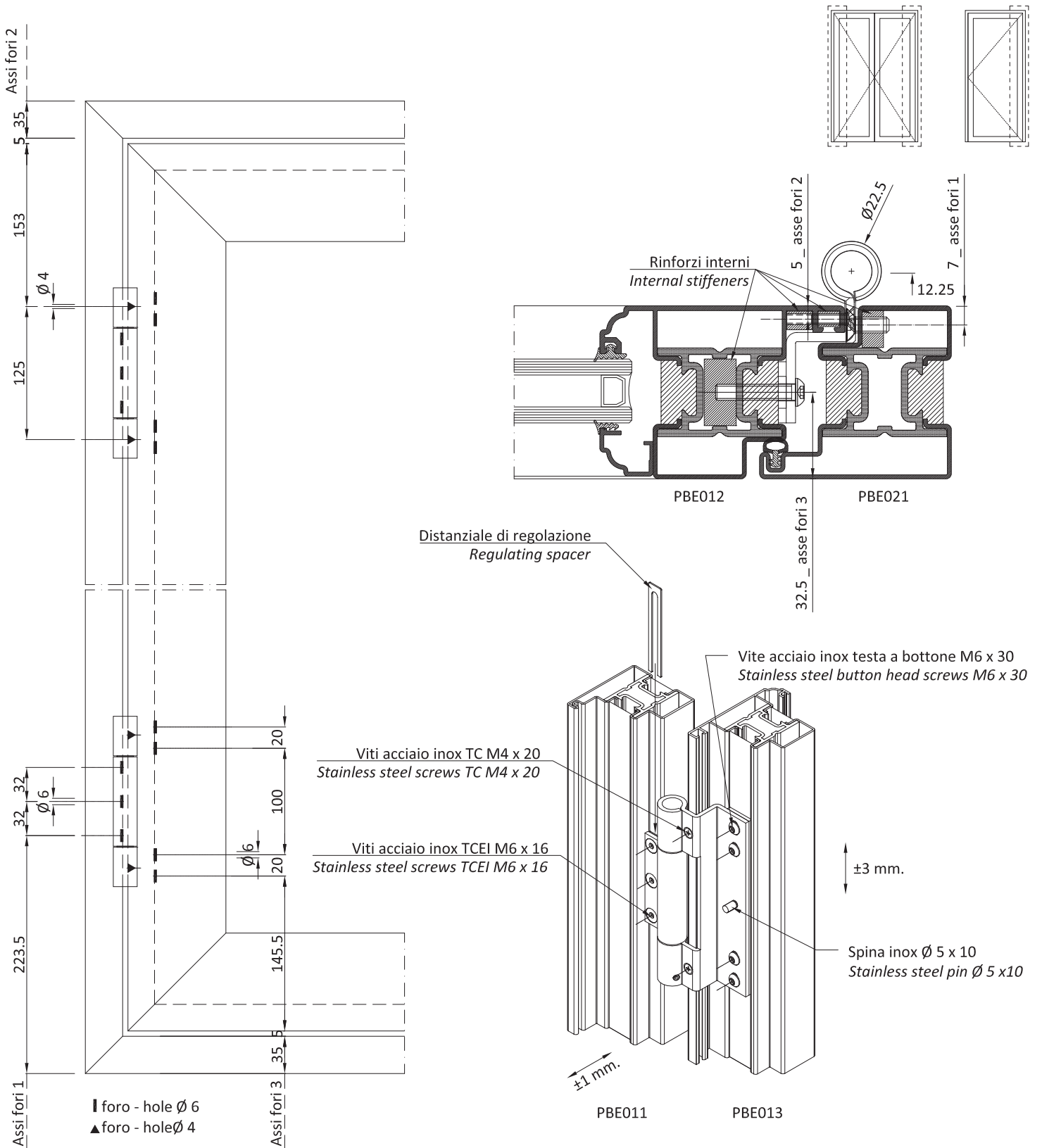
Vite acciaio inox testa a bottone M6 x 10  
Stainless steel button head screws M6 x 10



Portata max: Peso anta 150 Kg - Max weight: leaf weight 150 kg

- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX

- Working can be forseen in the middle position of the door
- Working leaf and right side are specular

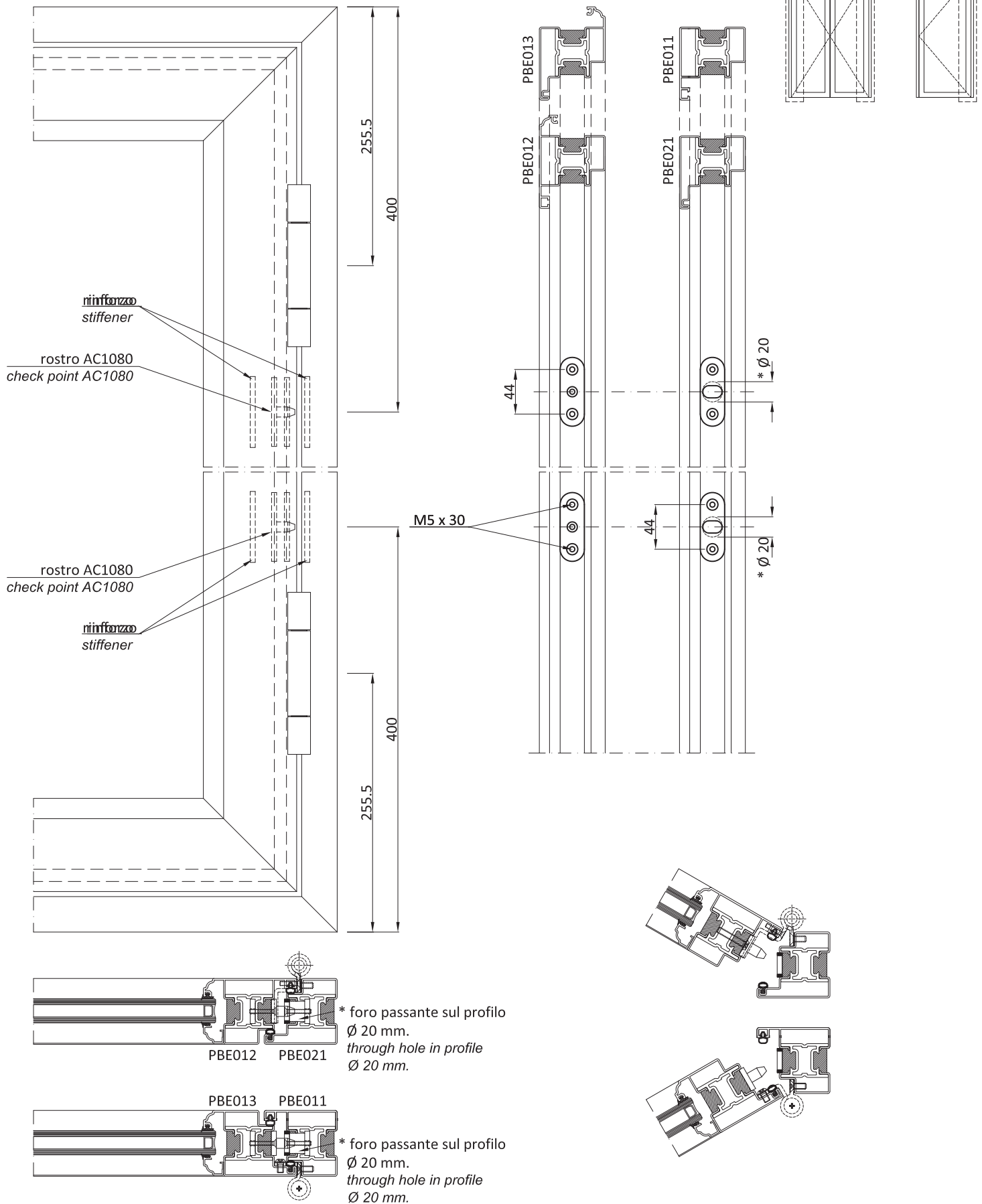


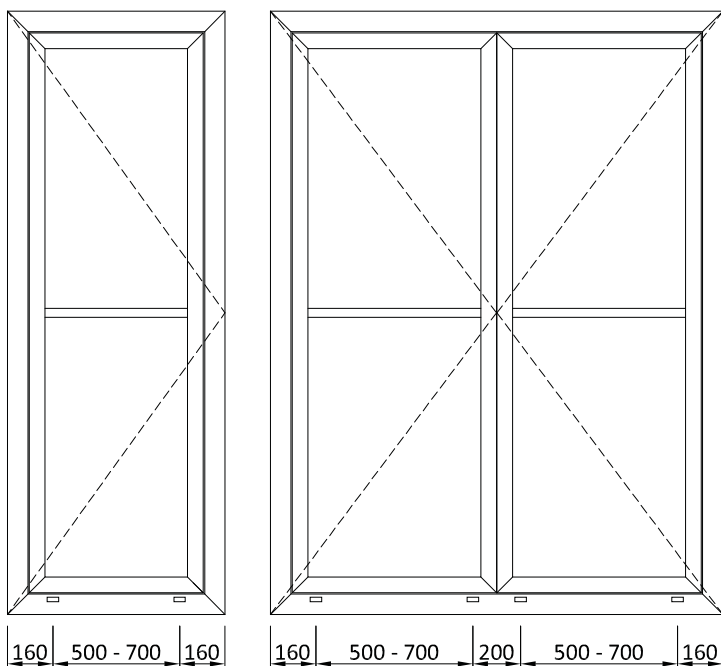
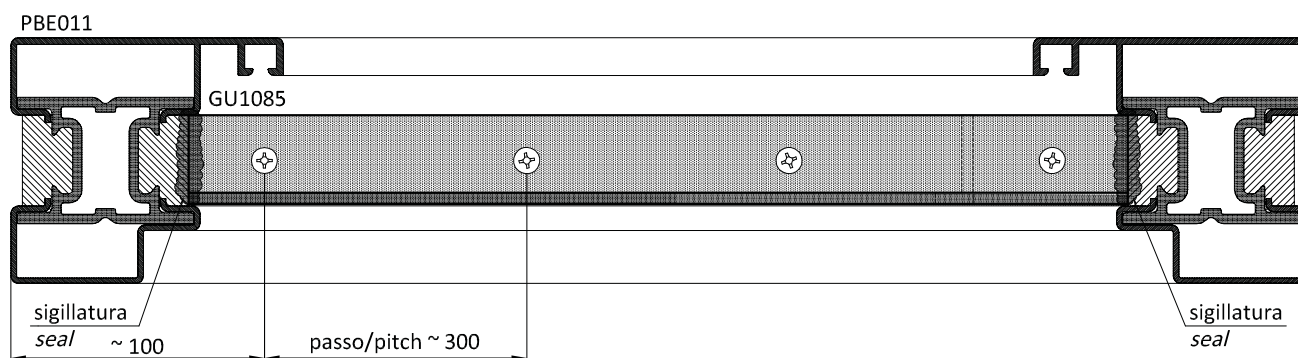
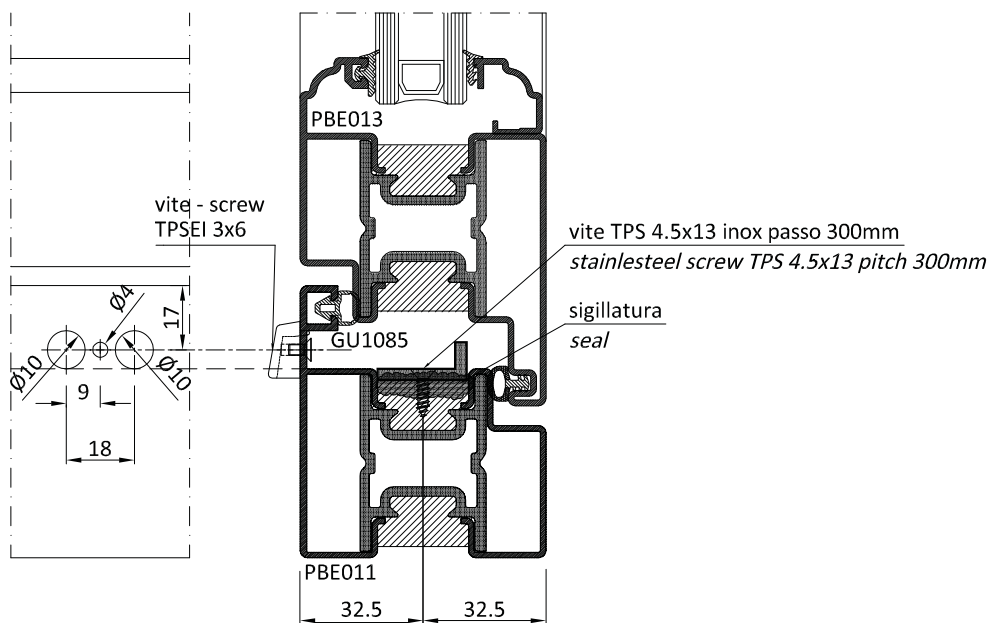
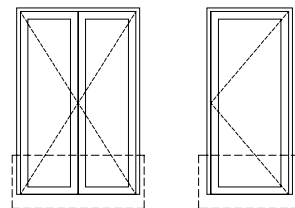
Portata max: Peso anta 150 Kg - Max weight: leaf weight 150 kg

- la lavorazione dell'angolo inferiore è uguale a quella dell'angolo superiore e viceversa
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX

- Inferior and upper corner working is the same
- Working can be forseen in the middle position of the door
- Working leaf and right side are specular





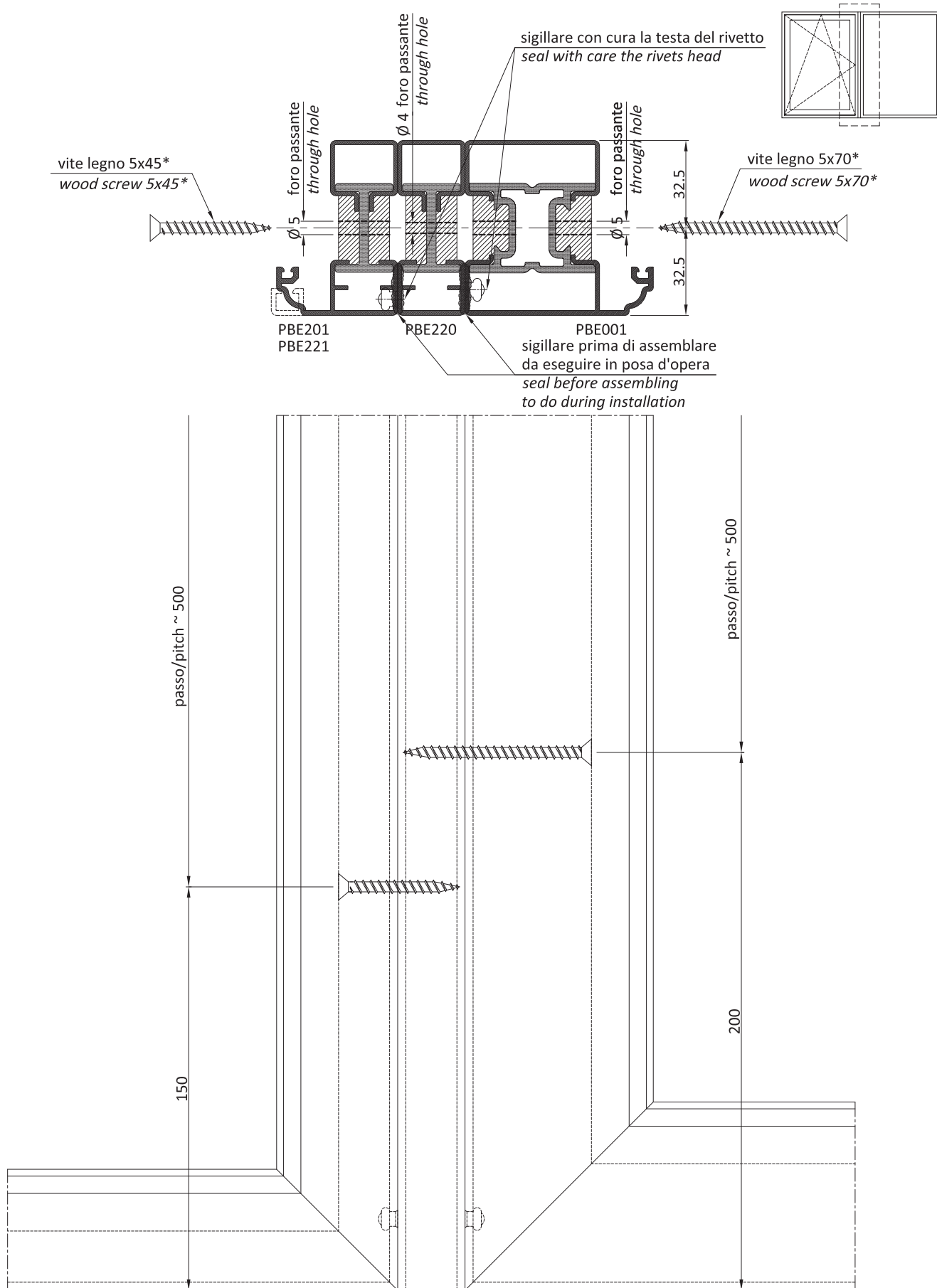


- eseguire fori come da disegno.
- posizionare lo scarico acqua sigillare e fissare con la vite in dotazione TPSEI 3x6mm inox

- drill the holes as shown on the drawing
- position the water drain and secure with the supplied TPSEI 3x6mm screw

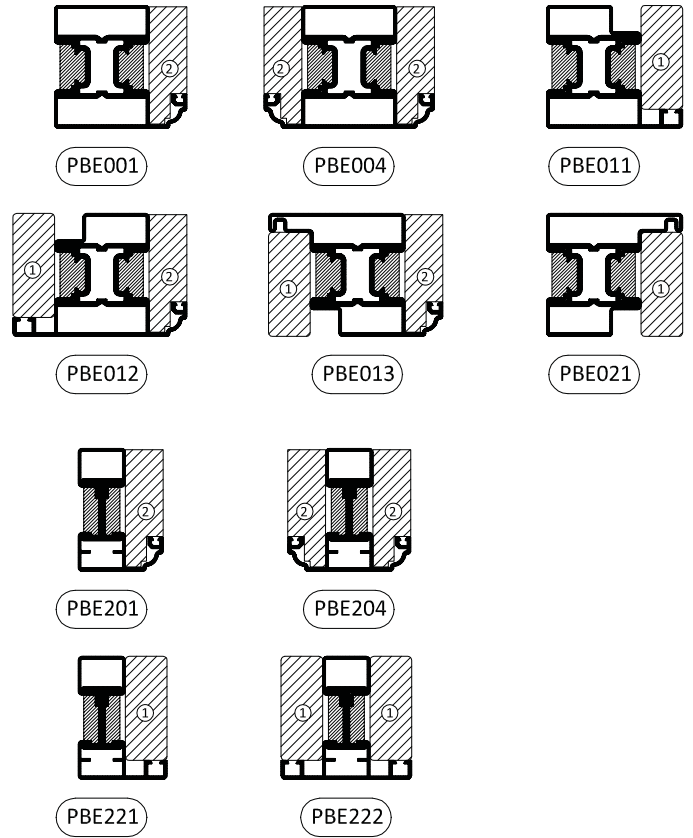
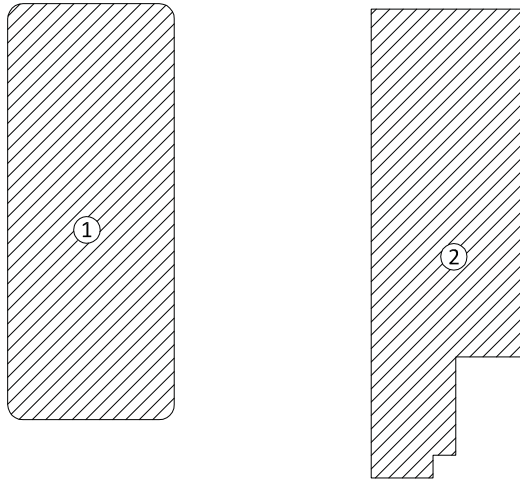
\* vite TPS 4.5x13 inox non inclusa



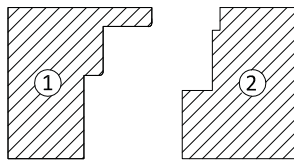


\* viti non comprese

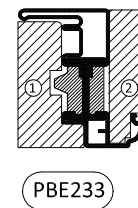
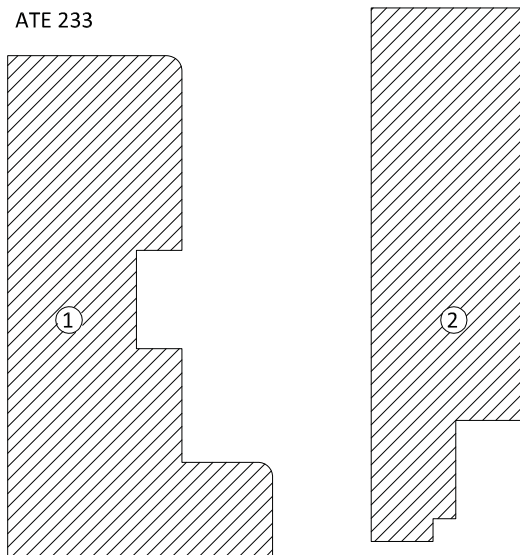
ATE 001

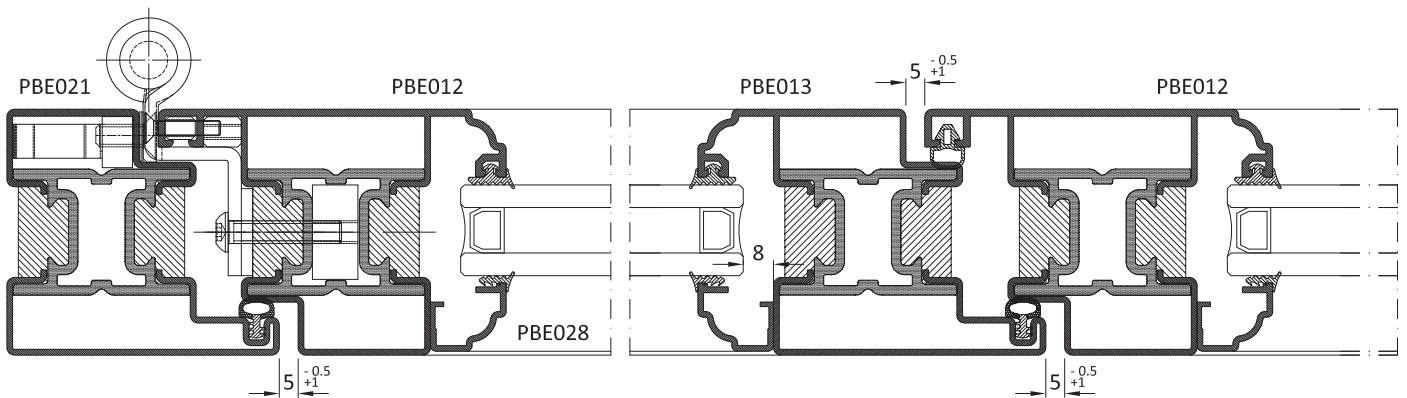
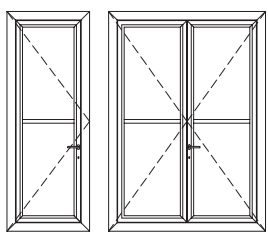
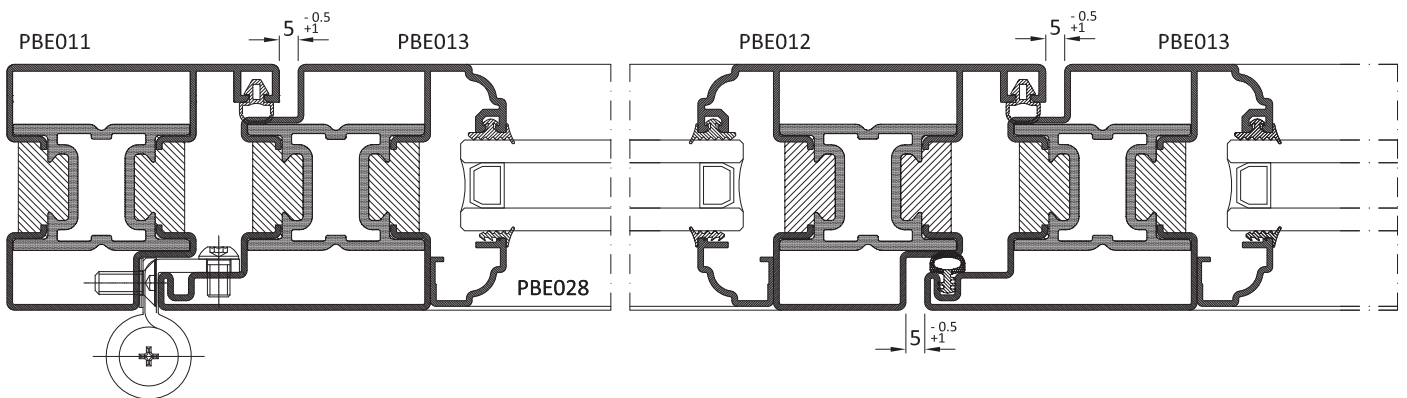
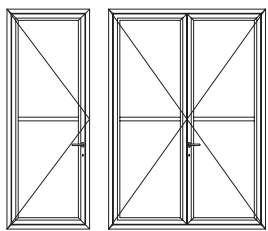
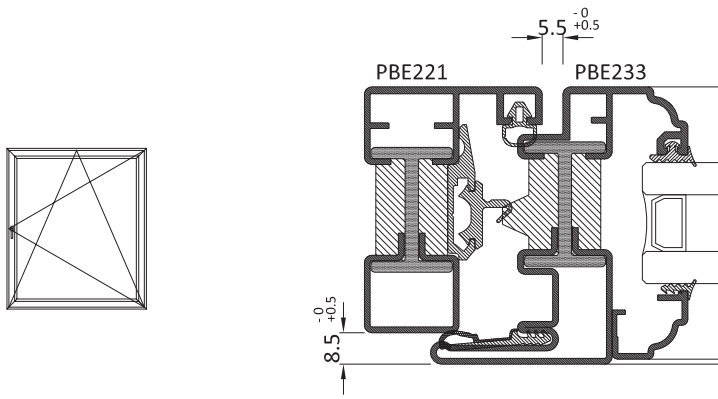


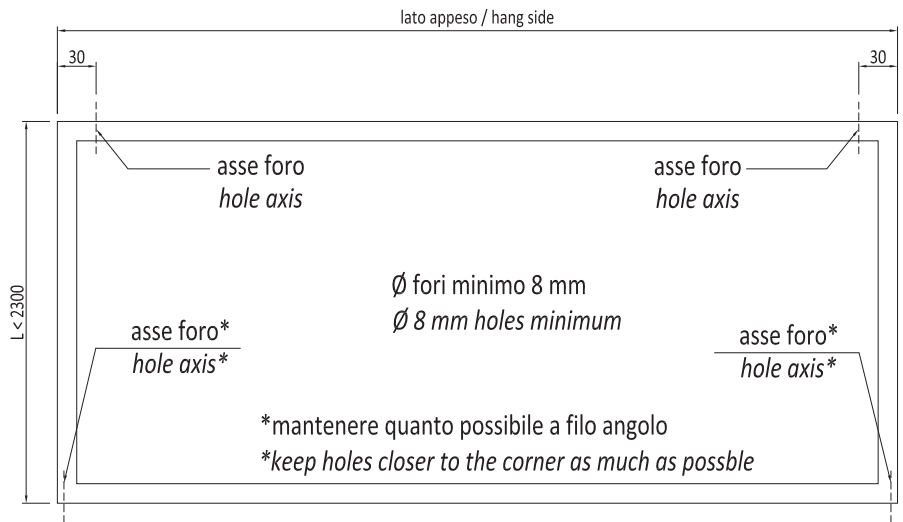
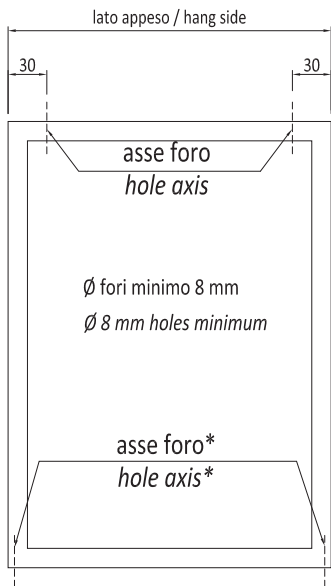
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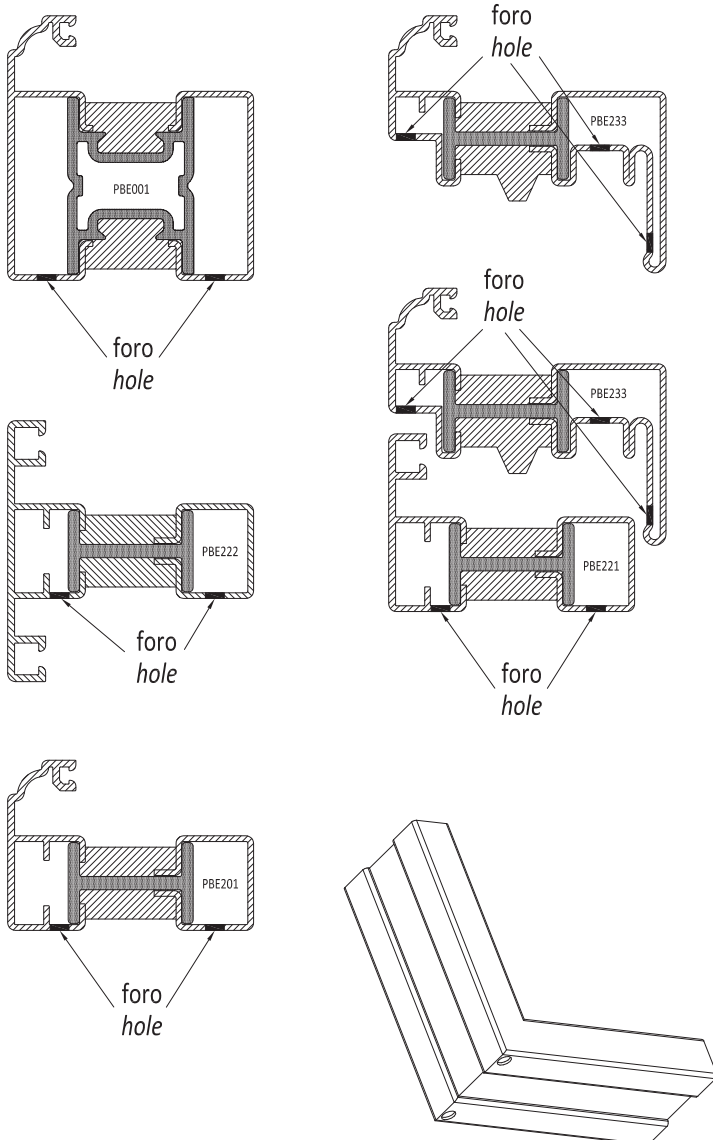
ATE 233



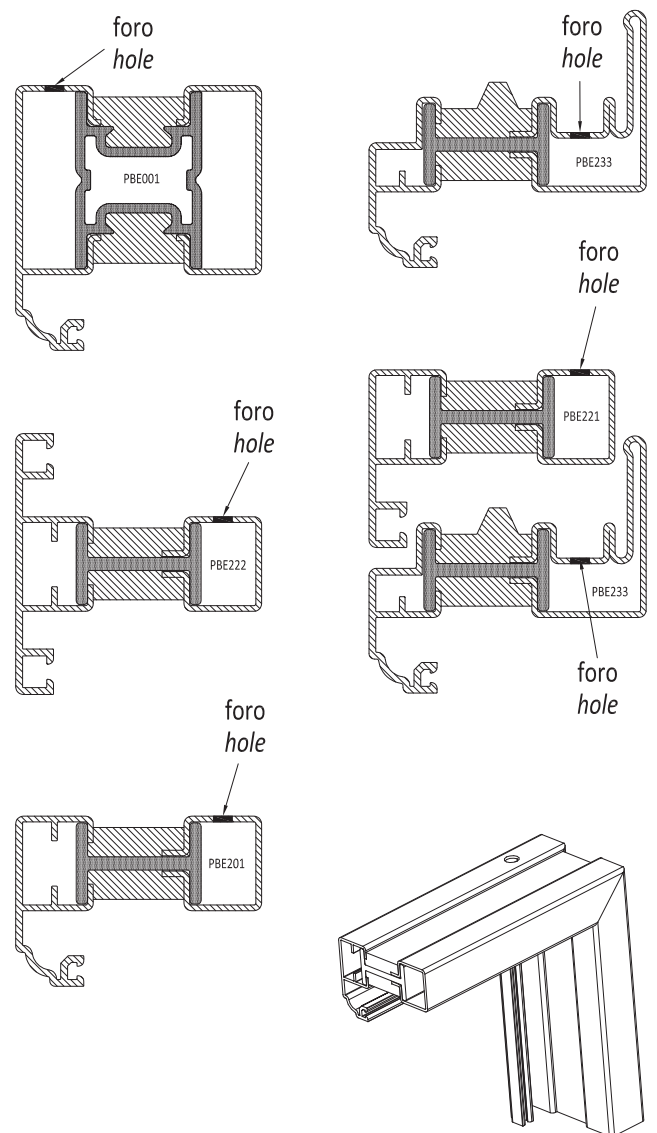


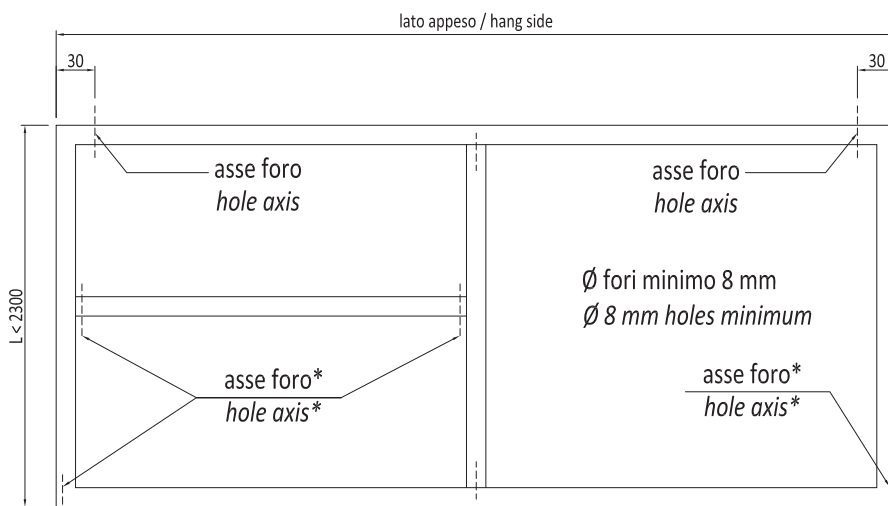


Forature base inferiore per scolo  
Drill holes on lower profiles for draining



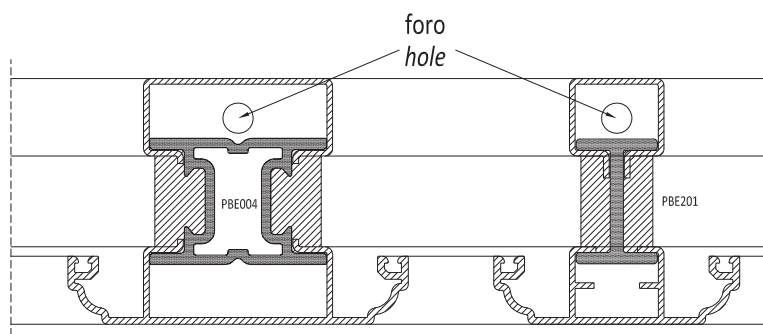
Forature base superiore per appendere  
Drill holes on lower profiles for hanging



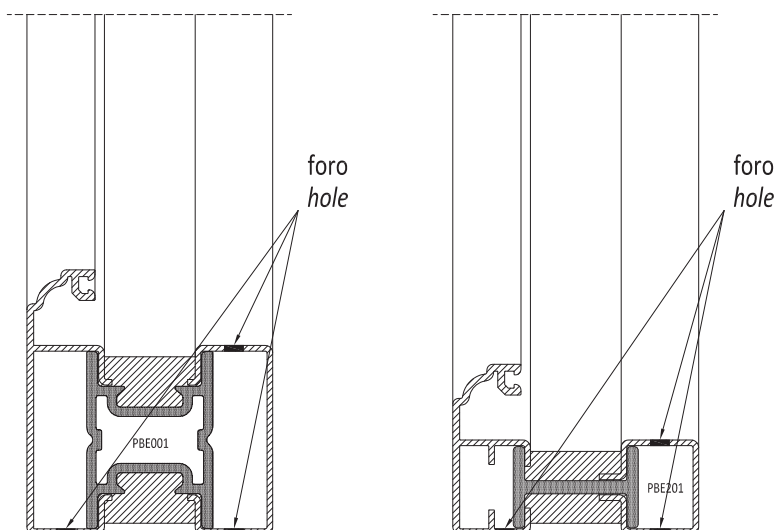
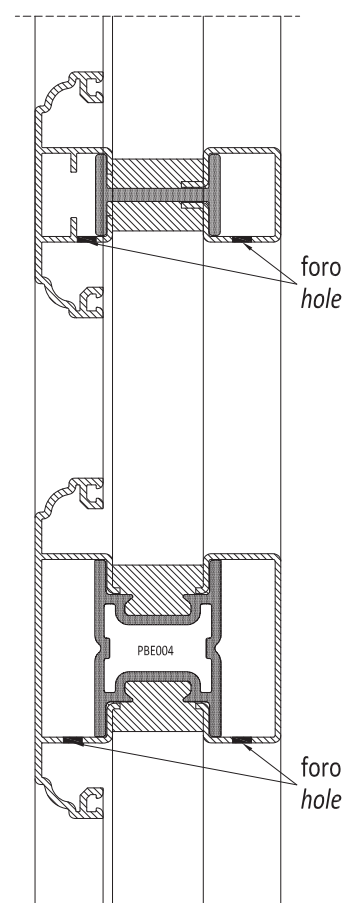


\*mantenere quanto possibile a filo angolo  
\*keep holes closer to the corner as much as possible

**Forature montanti**  
*Drill holes on mullions*



**Forature trasversi**  
*Drill holes on transom*







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