

CUSTOMER TECHNICAL MEMO # 242

Subject: Hawkesbury and Hawkesbury Plus Technical Manual and Wall Chart Extrusions update

Date: August 2015

Good Morning,

Please note the following extrusion pages have been revised in line with changes to the Hawkesbury/Hawkesbury Plus Wall Chart, and should replace the existing pages in your current Technical Manuals. Please note a full Hawkesbury Technical Manual update is in progress and will be released when complete.

Hawkesbury

- Cover Page
- Contents page updated (Extrusions)
- Page 1.0 - Technical Manual Release Notes updated with latest changes
- Pages 3.1.1, 3.1.2, 3.1.7 to 3.1.11 - Extrusions pages amended and or added
- Contacts Page updated (Last page)

Hawkesbury Plus

- Cover Page
- Contents page updated (Extrusions)
- Page 1.0 and 1.1 - Technical Manual Release Notes updated with latest changes
- Pages 3.1.5 to 3.1.8 - Extrusions pages amended and added
- Contacts Page updated (Last page)

All the above pages have been included with this Technical Memo. The format has been set for double sided printing so you will be able to easily replace the current pages in your technical manuals. (You will need to ensure your printer is set to double-sided printing.)

The Hawkesbury and Hawkesbury Plus Technical Manuals and Wall Charts have been updated on the ALSPEC website. A copy of this Customer Technical Memo has also been added to the NEWS/CUSTOMER TECHNICAL MEMO link for future reference.

If you have any questions please do not hesitate to contact your local ALSPEC Area Manager or Sales Office.

ALSPEC ALUMINIUM SYSTEMS

TECHNICAL MANUAL

HAWKESBURY

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ALSPEC ALUMINIUM SYSTEMS

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HAWKESBURY

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Section 1.0

TECHNICAL MANUAL RELEASE NOTES

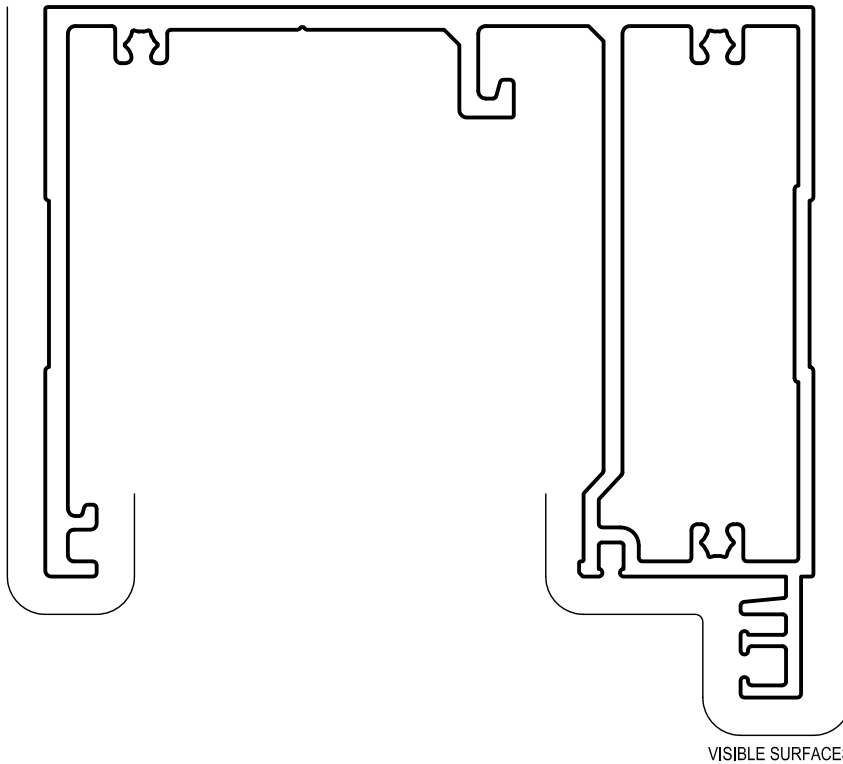
This page is intended to record all changes to the HAWKESBURY technical manual pages. It is therefore critical that all changes are recorded in the below AMENDMENTS box prior to release to our customer.

Changes or additions to this manual will be itemised with a brief description and date when the amendments were made.

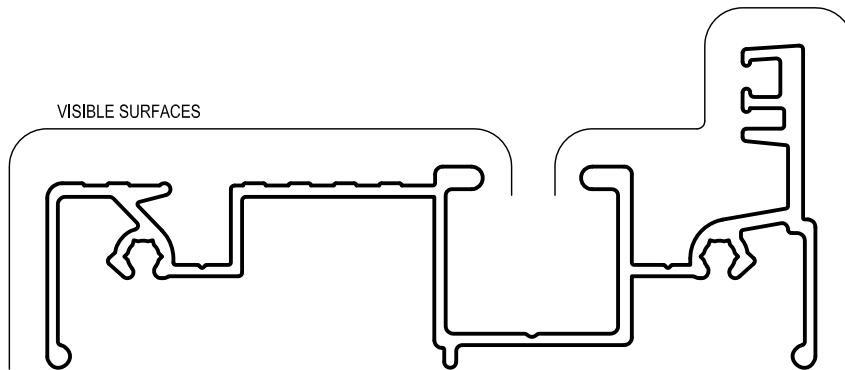
It is important that a copy of the page be issued with the update and inserted as the first page in the customers technical manual.

DATE	AMENDMENT DESCRIPTION	REMOVE PAGE	INSERT NEW PAGE
01 / 09 / 2008	<i>Technical manual initial release</i>	~	~
02 / 02 / 2009	<i>Contents pages</i>	~	~
01 / 12 / 2008	<i>Hardware page</i>	3.2.1	3.2.1
01 / 12 / 2008	<i>Typical meeting stile detail</i>	3.4.3	3.4.3
01 / 02 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 02 / 2009	<i>Specification amended</i>	2.1	2.1
01 / 02 / 2009	<i>Test drawings added</i>	~	2.3.4 to 2.3.6
01 / 02 / 2009	<i>Gasket drawing amended</i>	3.2.1	3.2.1
01 / 02 / 2009	<i>Hardware</i>	~	3.2.2 to 3.2.9
01 / 02 / 2009	<i>Hardware Selection Charts</i>	~	3.2.10 to 3.2.13
01 / 02 / 2009	<i>Bi fold door flat sill - front view</i>	~	3.4.5
01 / 02 / 2009	<i>Bi fold door flat sill - back view</i>	~	3.4.6
01 / 06 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 06 / 2009	<i>Extrusion sections and properties amended</i>	3.1.8	3.1.8
01 / 06 / 2009	<i>Door style preparation for AD1033DG spiggot amended</i>	3.6.6	3.6.6
01 / 06 / 2009	<i>Door rail preparation D.G. image amended</i>	3.6.7	3.6.7
01 / 06 / 2009	<i>Glazing detail D.G. image amended</i>	3.7.2	3.7.2
01 / 02 / 2012	<i>Technical manual revised and updated for re-print</i>	ALL	ALL
01 / 06 / 2015	<i>Cover page amended</i>	Cover Page	Cover Page
01 / 06 / 2015	<i>Extrusion contents page updated</i>	~	~
01 / 06 / 2015	<i>Technical manual release notes updated</i>	1.0	1.0
01 / 06 / 2015	<i>Extrusion updated</i>	3.1.1, 3.1.2, 3.1.8, 3.1.9, 3.1.10	3.1.1, 3.1.2, 3.1.8, 3.1.9, 3.1.10
01 / 06 / 2015	<i>Extrusion pages added</i>	~	3.1.11
01 / 06 / 2015	<i>Contact page updated</i>	Last Page	Last Page

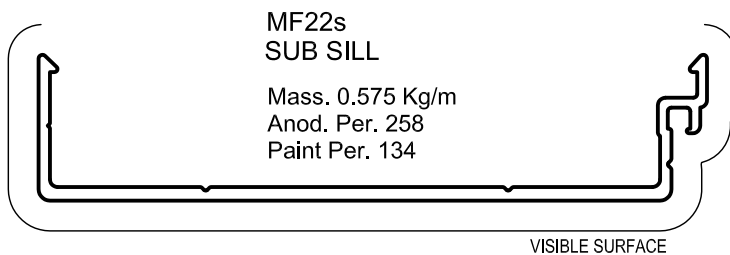
EXTRUSION PROFILES



MFE1
E2/E3 HEAD
Mass. 2.877 Kg/m
Anod. Per. 649
Paint Per. 273



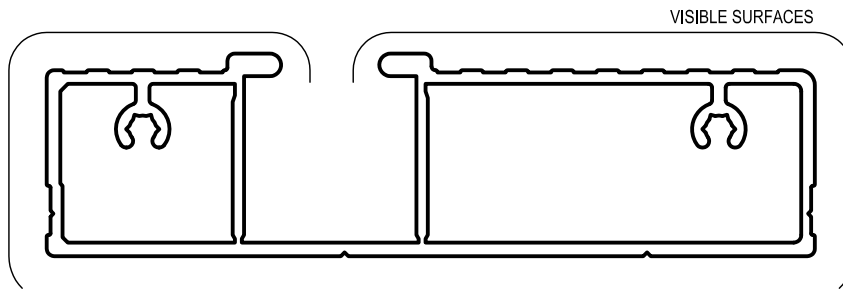
MFE41s
REVERSIBLE SILL
Mass. 1.332 Kg/m
Anod. Per. 557
Paint Per. 330



MF22s
SUB SILL
Mass. 0.575 Kg/m
Anod. Per. 258
Paint Per. 134

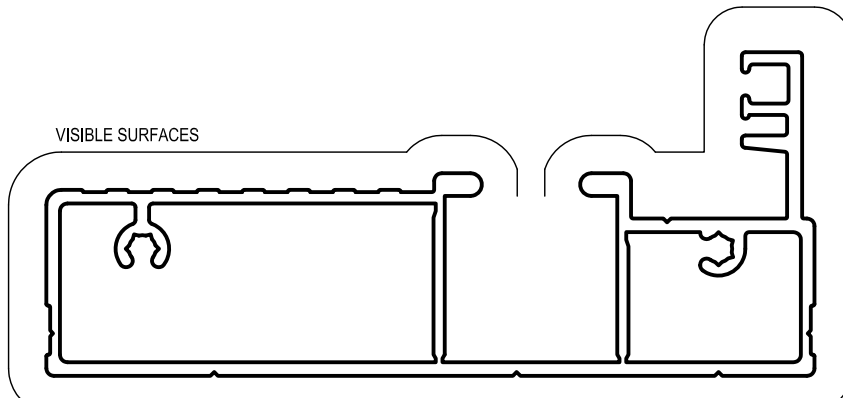
NOTE: MUST BE STOP ENDED
PRIOR TO INSTALLATION

EXTRUSION PROFILES



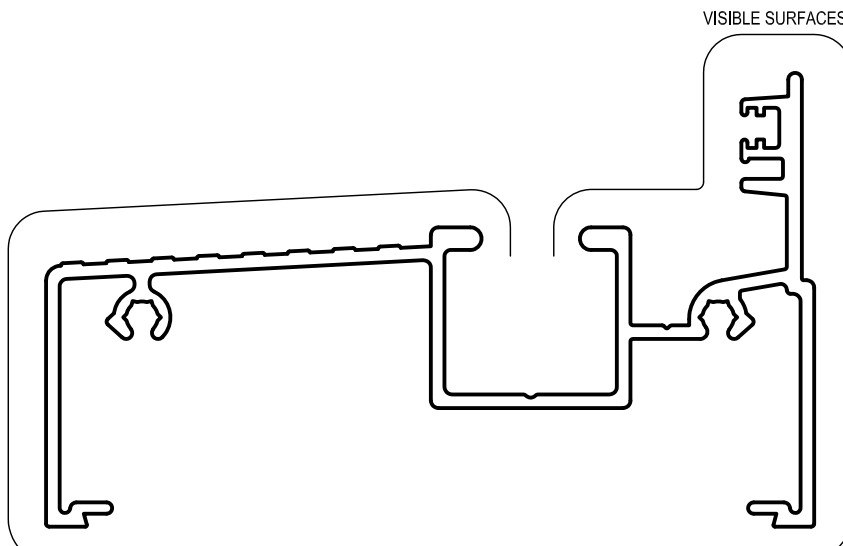
**MFE23
PLAIN SILL**

Mass. 1.449 Kg/m
Anod. Per. 328
Paint Per. 149



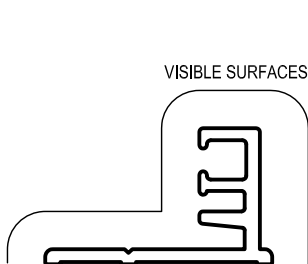
**MFE21
REVERSIBLE SILL**

Mass. 1.609 Kg/m
Anod. Per. 410
Paint Per. 230



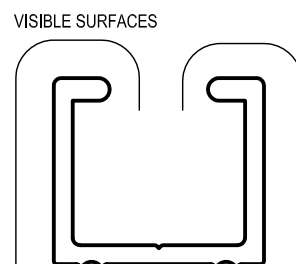
**MF100
HIGH PERFORMANCE
SILL**

Mass. 1.560 Kg/m
Anod Per. 619
Paint Per. 272



**MFE19
DOOR ADAPTOR**

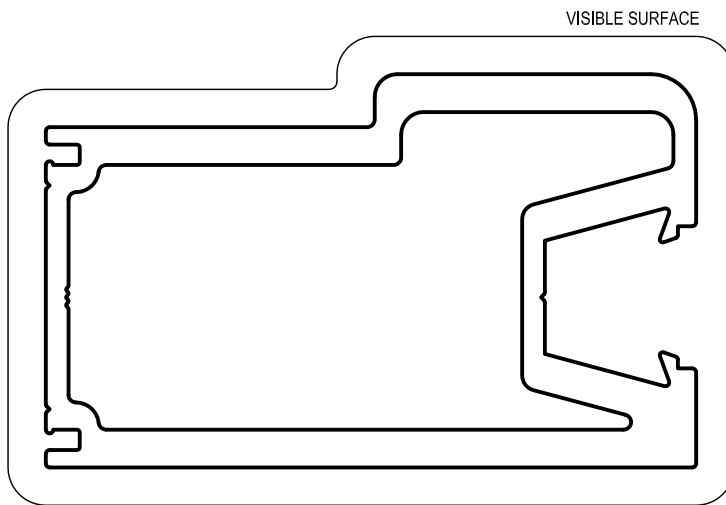
Mass. 0.313 Kg/m
Anod. Per. 134
Paint Per. 100



**MFE20D
DEEP SILL TRACK**

Mass. 0.561 Kg/m
Anod Per. 165
Paint Per. 137

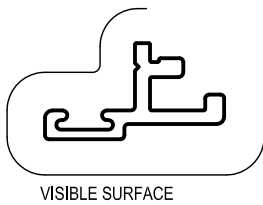
EXTRUSION PROFILES



**MF227
EXTRA H.D. DOOR STILE**

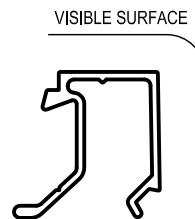
Mass. 3.581 Kg/m
Anod. Per. 342
Paint Per. 273

$I_{xx} = 478.50 \times 10^3 \text{mm}^4$



**MFA29
MEETING STILE
ADAPTOR**

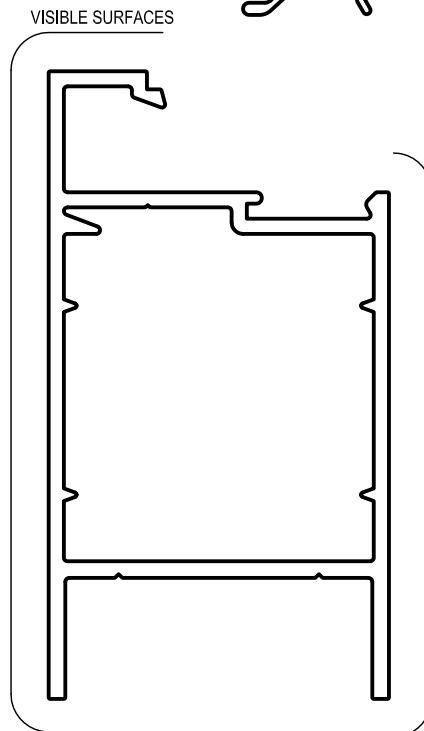
Mass. 0.218 Kg/m
Anod. Per. 100
Paint Per. 100



**MF18
DOOR BEAD**

Mass. 0.18 Kg/m
Anod. Per. 122
Paint Per. 100

FOR SINGLE GLAZED DOOR
USE AD1030E SPIGGOT SET
Code No. 378047

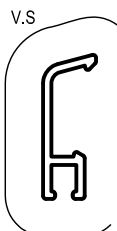


**MF17
DOOR TOP &
BOTTOM RAIL**

Mass. 1.450 Kg/m
Anod. Per. 328
Paint Per. 168

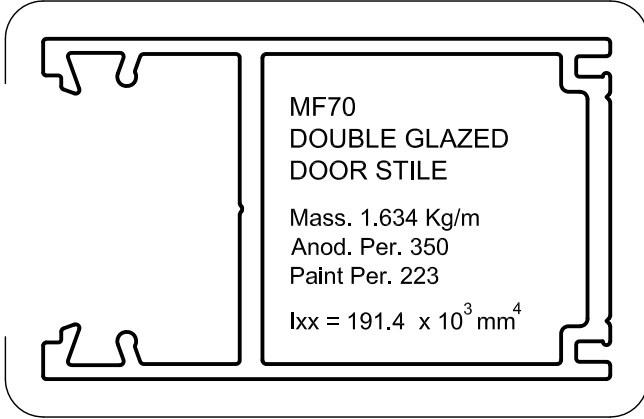
**MF75
WEATHERSEAL
SNAP ON COVER**

Mass. 0.100 Kg/m
Anod. Per. 100
Paint Per. 100

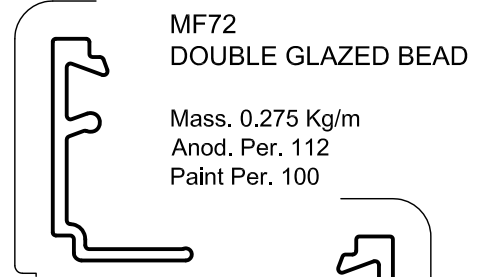


EXTRUSION PROFILES

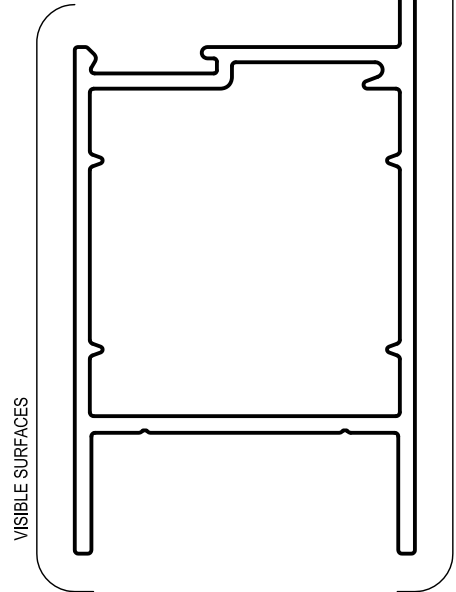
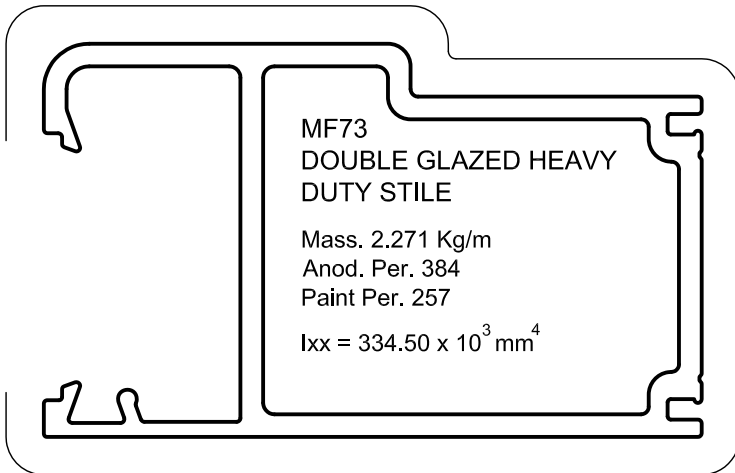
VISIBLE SURFACE



V.S.



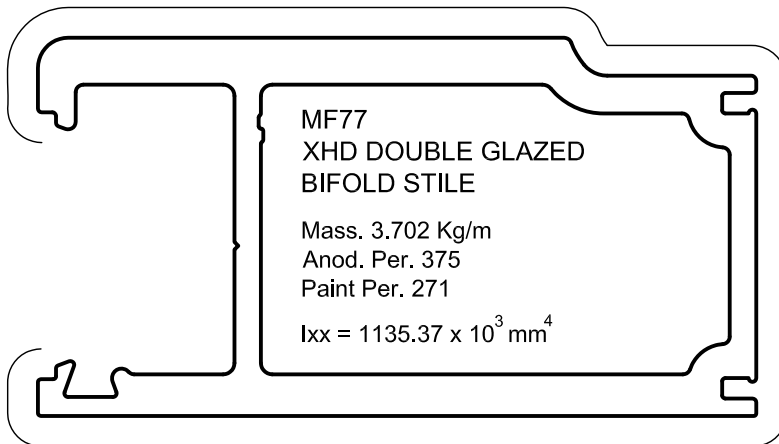
VISIBLE SURFACE



MF71
DOUBLE GLAZED
DOOR RAIL

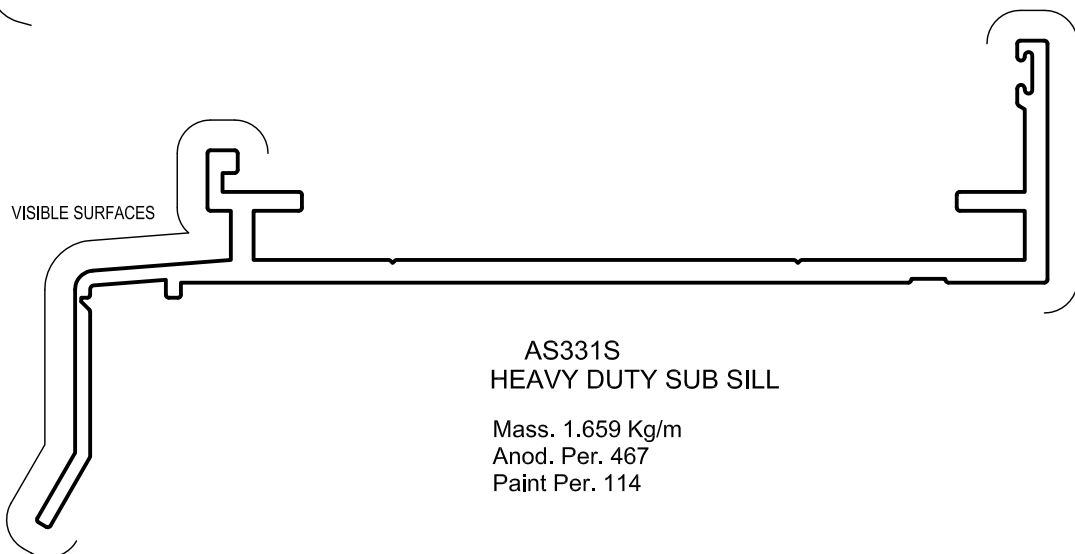
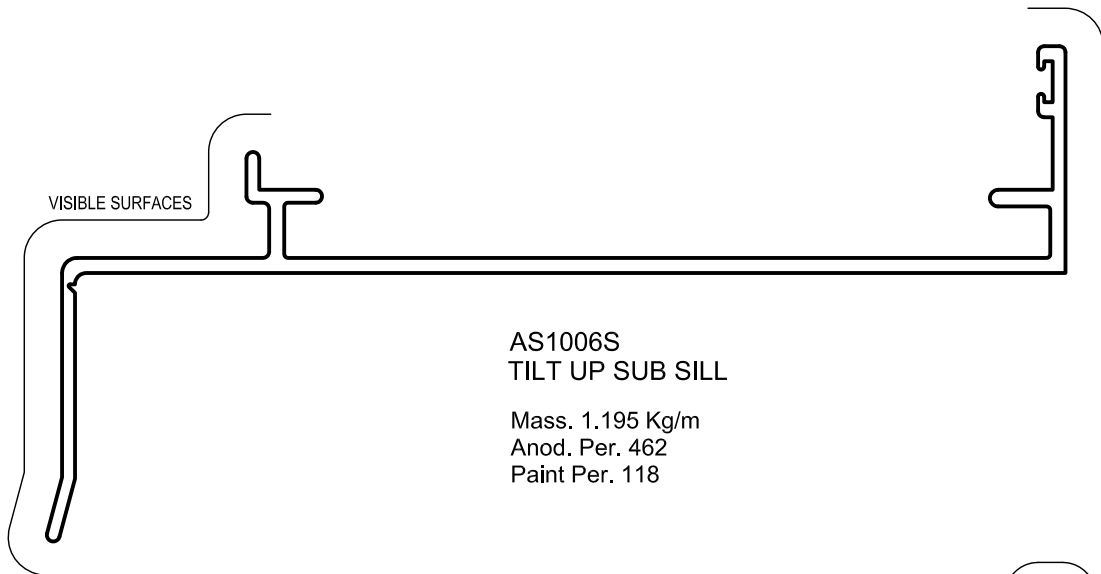
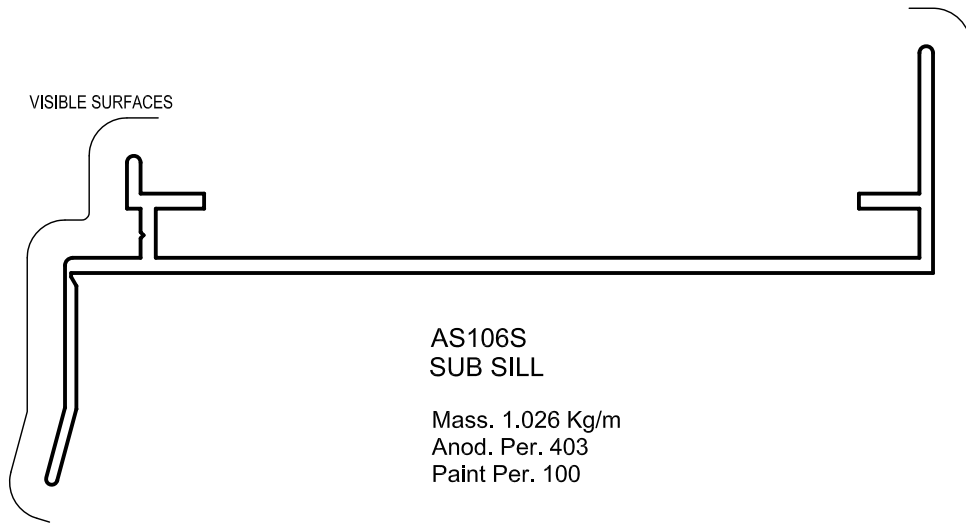
Mass. 1.494 Kg/m
Anod. Per. 335
Paint Per. 170

VISIBLE SURFACE

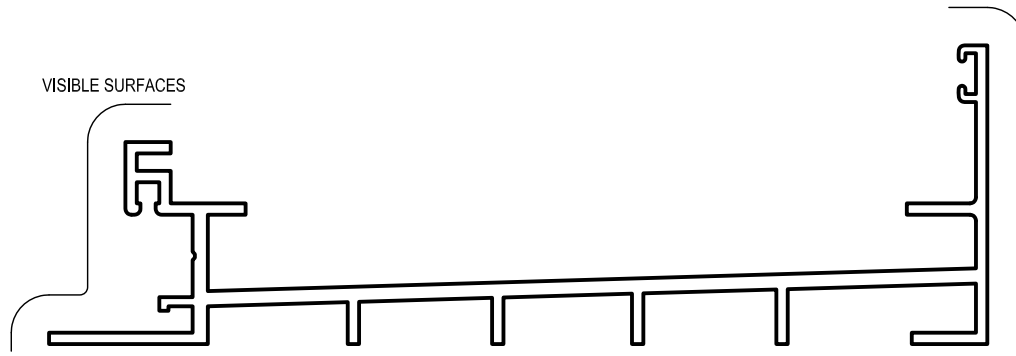


FOR DOUBLE GLAZED DOOR
USE AD1033 SPIGGOT SET
Code No. 378073

EXTRUSION PROFILES

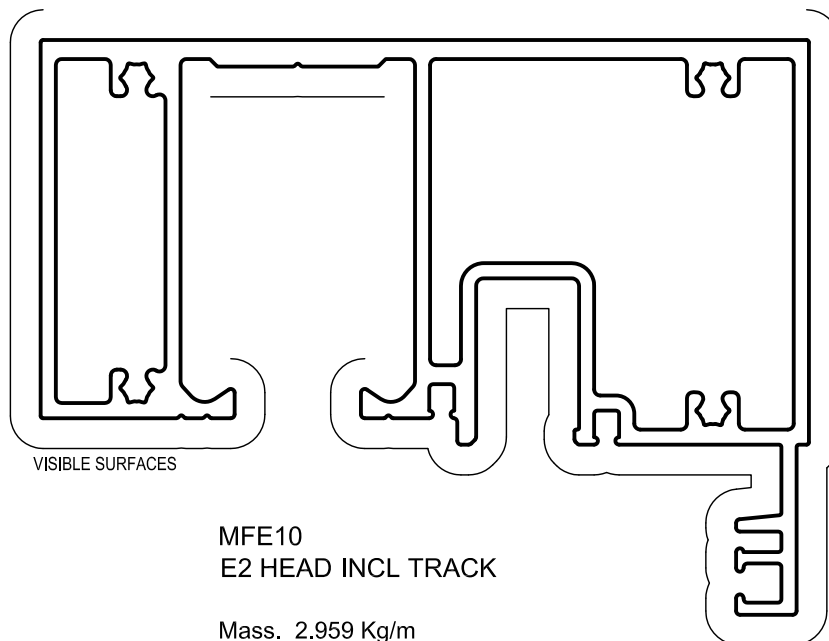


EXTRUSION PROFILES



AS332S
SUB SILL

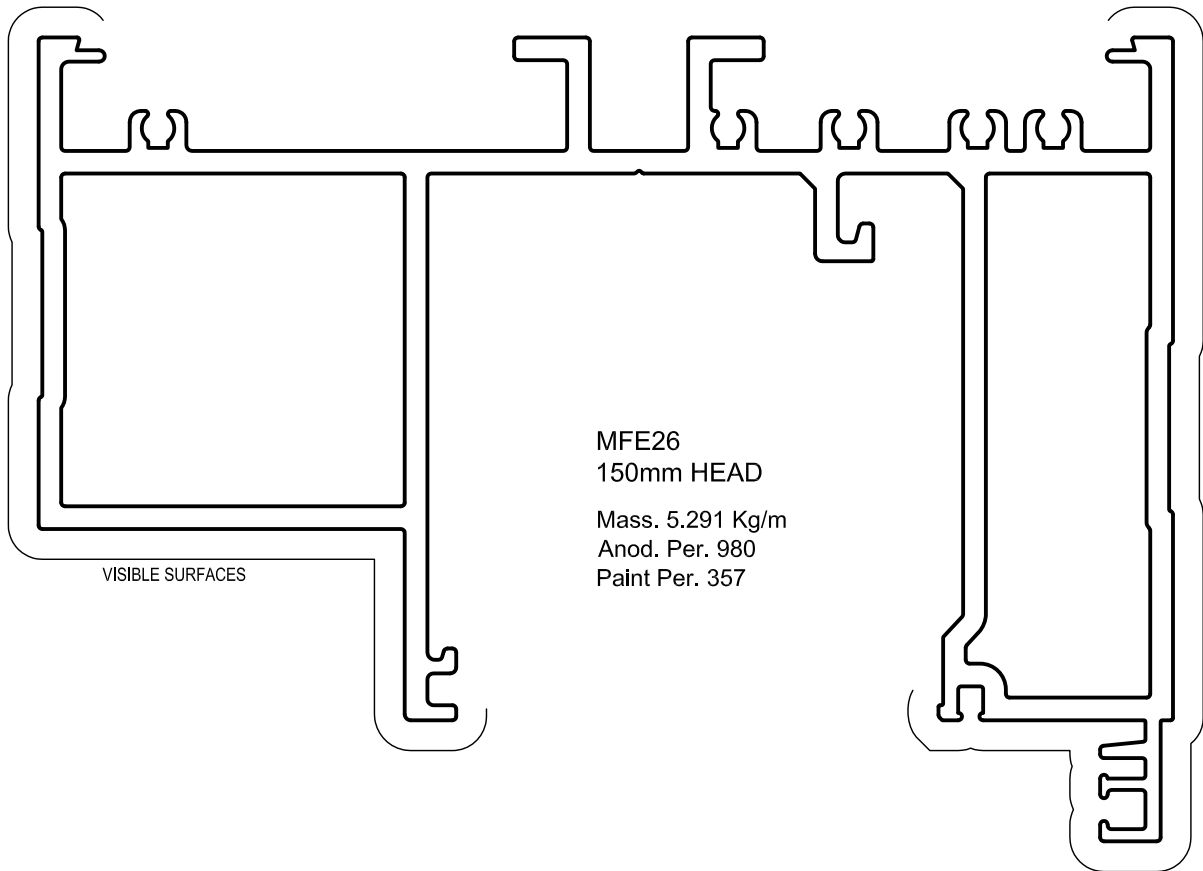
Mass. 1.227 Kg/m
Anod. Per. 529
Paint Per. 124



MFE10
E2 HEAD INCL TRACK

Mass. 2.959 Kg/m
Anod Per. 580
Paint Per. 379

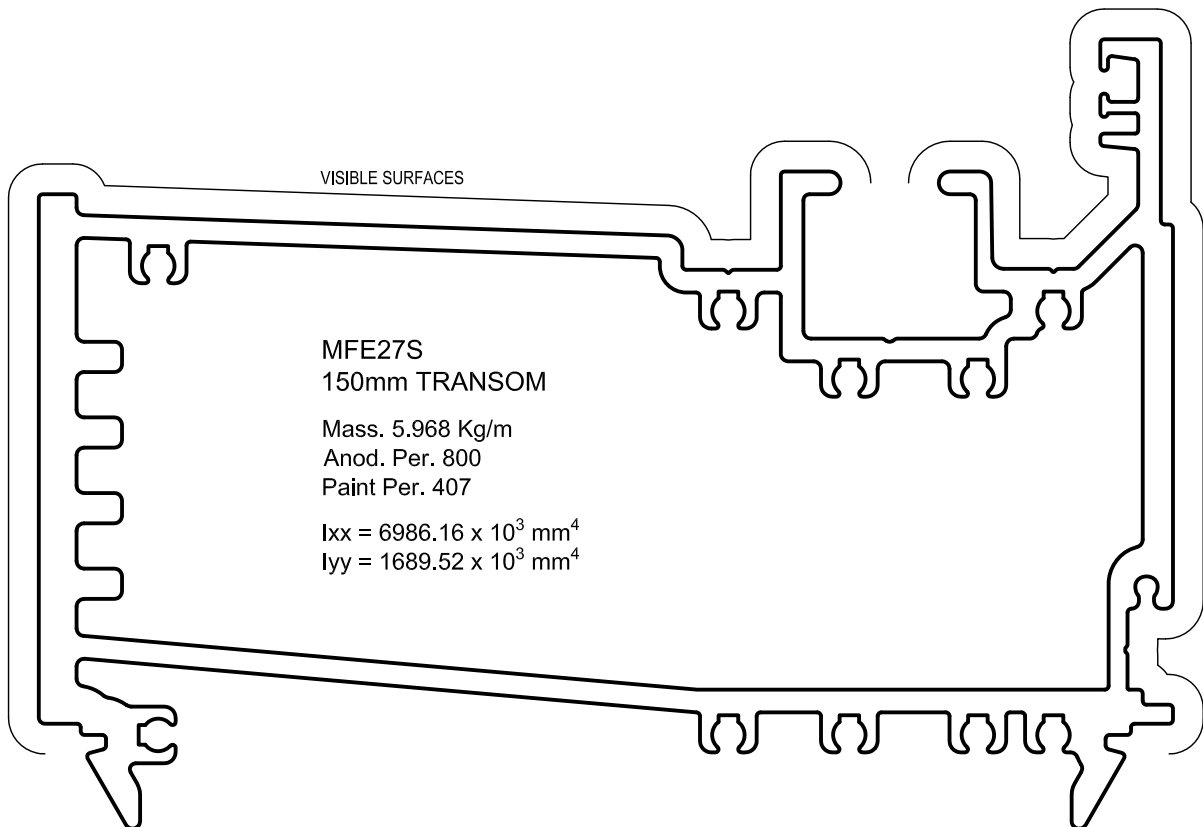
EXTRUSION PROFILES



MFE26
150mm HEAD

Mass. 5.291 Kg/m
Anod. Per. 980
Paint Per. 357

VISIBLE SURFACES



VISIBLE SURFACES

MFE27S
150mm TRANSOM

Mass. 5.968 Kg/m
Anod. Per. 800
Paint Per. 407

$I_{xx} = 6986.16 \times 10^3 \text{ mm}^4$
 $I_{yy} = 1689.52 \times 10^3 \text{ mm}^4$



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ALSPEC ALUMINIUM SYSTEMS

TECHNICAL MANUAL

HAWKESBURY plus

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Section 1.0

TECHNICAL MANUAL RELEASE NOTES

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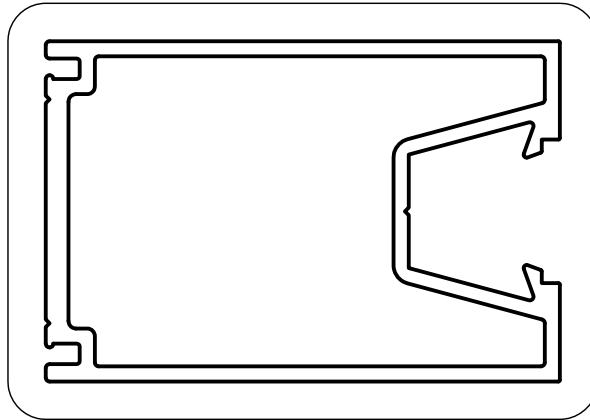
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30 / 04 / 2008	<i>Technical manual initial release</i>	~	~
01 / 12 / 2008	<i>Hardware page</i>	3.2.3	3.2.3
01 / 12 / 2008	<i>Typical head detail</i>	3.4.1	3.4.1
01 / 12 / 2008	<i>Typical sill detail</i>	3.4.2	3.4.2
01 / 12 / 2008	<i>Typical LH jamb detail</i>	3.4.3	3.4.3
01 / 12 / 2008	<i>Typical meeting stile detail</i>	3.4.4	3.4.4
01 / 02 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 02 / 2009	<i>Specification amended</i>	2.1	2.1
01 / 02 / 2009	<i>Loading table explanation page added</i>	2.2	2.2
01 / 02 / 2009	<i>Accessories code amended</i>	3.2.3	3.2.3
01 / 02 / 2009	<i>Contents page updated</i>	~	~
01 / 02 / 2009	<i>Hardware pages added</i>	~	3.4.4 - 3.4.11
01 / 02 / 2009	<i>Hardware selection charts added</i>	~	3.4.12 - 3.4.15
01 / 02 / 2009	<i>Typical hinge mounting details - E2+S/S</i>	3.8.1	3.8.1
01 / 02 / 2009	<i>Typical hinge mounting details - E3+S/S</i>	3.8.2	3.8.2
01 / 06 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 06 / 2009	<i>Extrusion sections and properties amended</i>	3.1.7	3.1.7
01 / 06 / 2009	<i>Glazing details D.G. image amended</i>	3.7.2	3.7.2
01 / 11 / 2009	<i>Contents page updated - 3.6.8 added</i>	~	~
01 / 11 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 11 / 2009	<i>Frame kit notes added</i>	3.6.1	3.6.1
01 / 11 / 2009	<i>Frame kit sill & head mouldings</i>	3.6.8	3.6.8
01 / 02 / 2012	<i>Technical Manual updated for re-printing</i>	ALL	ALL
01 / 06 / 2015	<i>Cover page updated</i>	Cover Page	Cover Page

EXTRUSION PROFILES

VISIBLE SURFACE

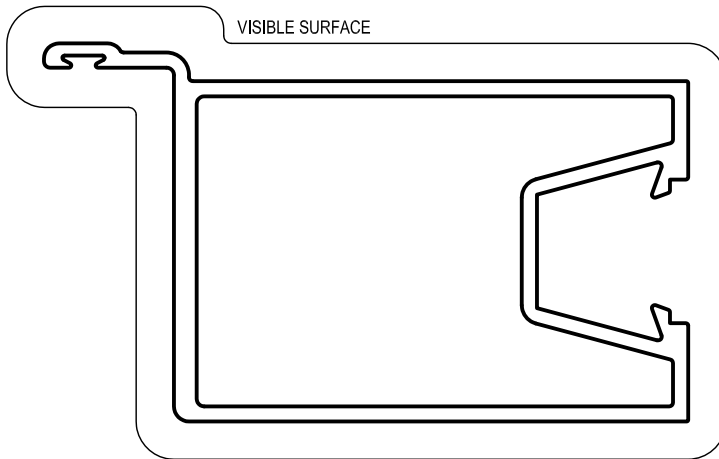


**MF14
FOLDING DOOR STILE**

Mass. 1.565 Kg/m
Anod. Per. 298
Paint Per. 226

$I_{xx} = 167.90 \times 10^3 \text{mm}^4$

VISIBLE SURFACE

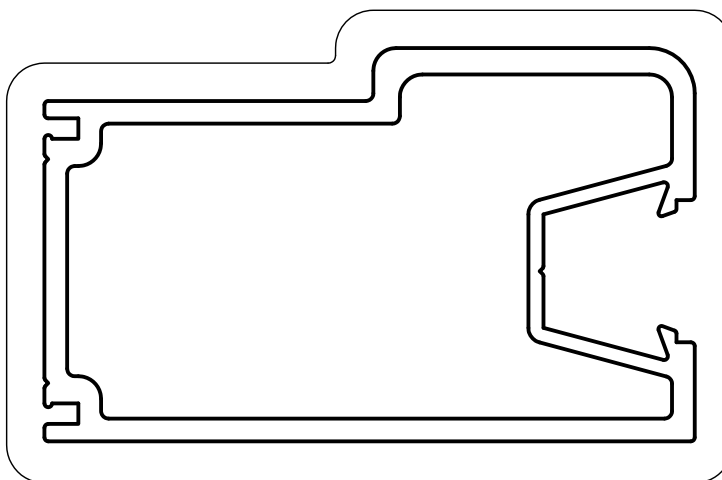


**MF16
MEETING STILE**

Mass. 1.649 Kg/m
Anod. Per. 324
Paint Per. 260

$I_{xx} = 191.50 \times 10^3 \text{mm}^4$

VISIBLE SURFACE



**MF27
HEAVY DUTY DOOR STILE**

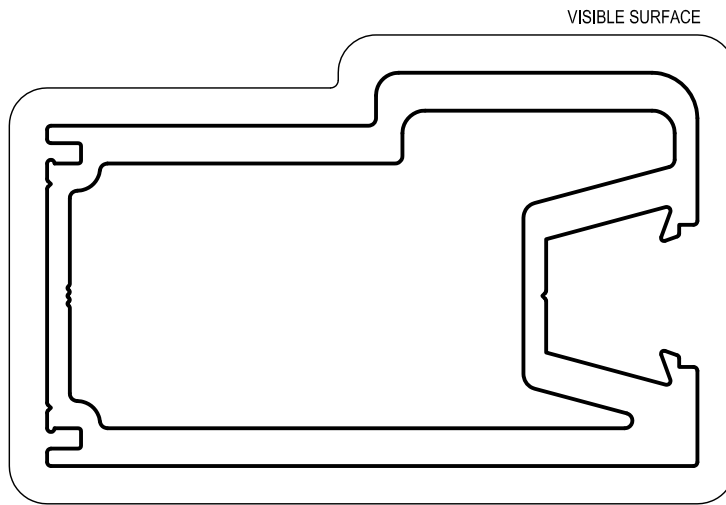
Mass. 2.419 Kg/m
Anod. Per. 342
Paint Per. 273

$I_{xx} = 341.00 \times 10^3 \text{mm}^4$

NOTE: FABRICATION TIPS FOR MF27 & MF227

THE ESCUTCHEON OF THE DUAL POINT LOCK WILL NOT FIT ON MF27 AND MF227 HEAVY DUTY STILES IN AN INWARD OPENING DOOR SET. A NEAT HOLE NEEDS TO BE MILLED FOR THE EURO CYLINDER.

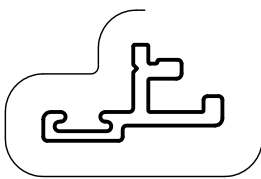
EXTRUSION PROFILES



**MF227
EXTRA H.D. DOOR STILE**

Mass. 3.581 Kg/m
Anod. Per. 342
Paint Per. 273

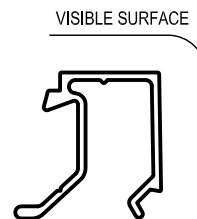
$I_{xx} = 478.50 \times 10^3 \text{mm}^4$



**MFA29
MEETING STILE
ADAPTOR**

Mass. 0.215 Kg/m
Anod. Per. 100
Paint Per. 100

VISIBLE SURFACE

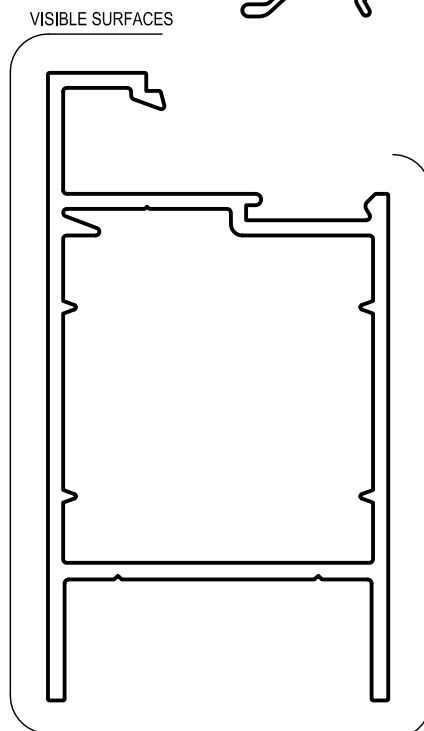


**MF18
DOOR BEAD**

Mass. 0.180 Kg/m
Anod. Per. 122
Paint Per. 100

VISIBLE SURFACE

FOR SINGLE GLAZED DOOR
USE AD1030E SPIGGOT SET
Code No. 378047



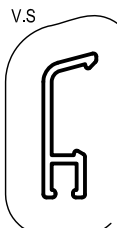
**MF17
DOOR TOP &
BOTTOM RAIL**

Mass. 1.450 Kg/m
Anod. Per. 328
Paint Per. 168

VISIBLE SURFACES

**MF75
WEATHERSEAL
SNAP ON COVER**

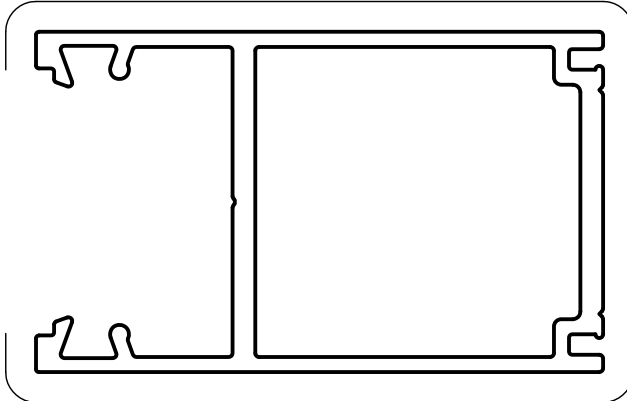
Mass. 0.100 Kg/m
Anod. Per. 100
Paint Per. 100



V.S

EXTRUSION PROFILES

VISIBLE SURFACE

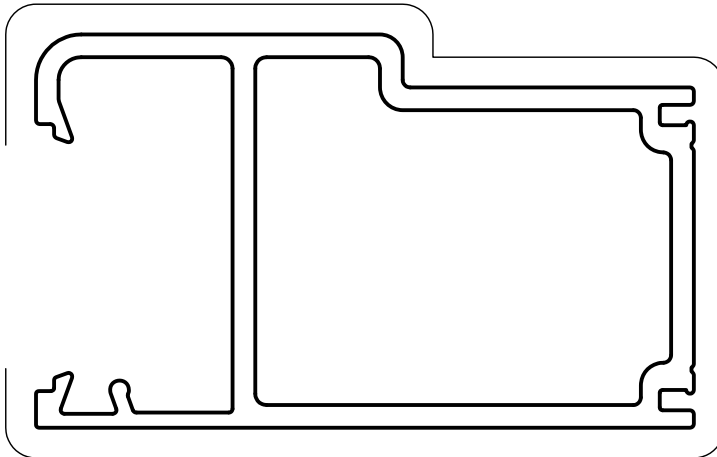


**MF70
DOUBLE GLAZED
DOOR STILE**

Mass. 1.634 Kg/m
Anod. Per. 350
Paint Per. 223

Ixx = 191.4 x 10³ mm⁴

VISIBLE SURFACE

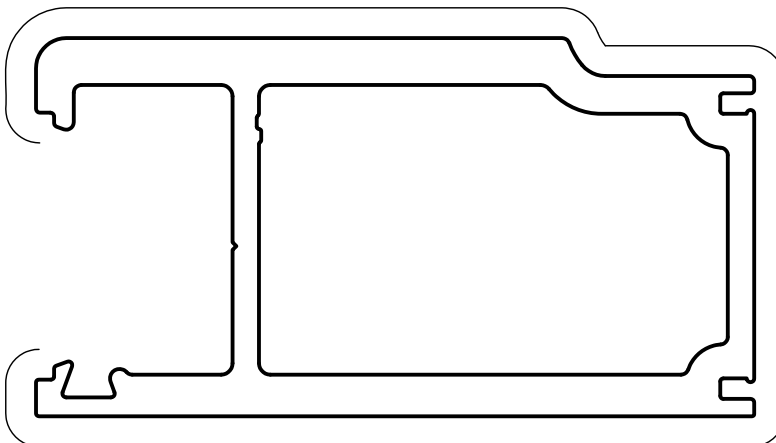


**MF73
DOUBLE GLAZED HEAVY
DUTY STILE**

Mass. 2.271 Kg/m
Anod. Per. 384
Paint Per. 257

Ixx = 334.50 x 10³ mm⁴

VISIBLE SURFACE



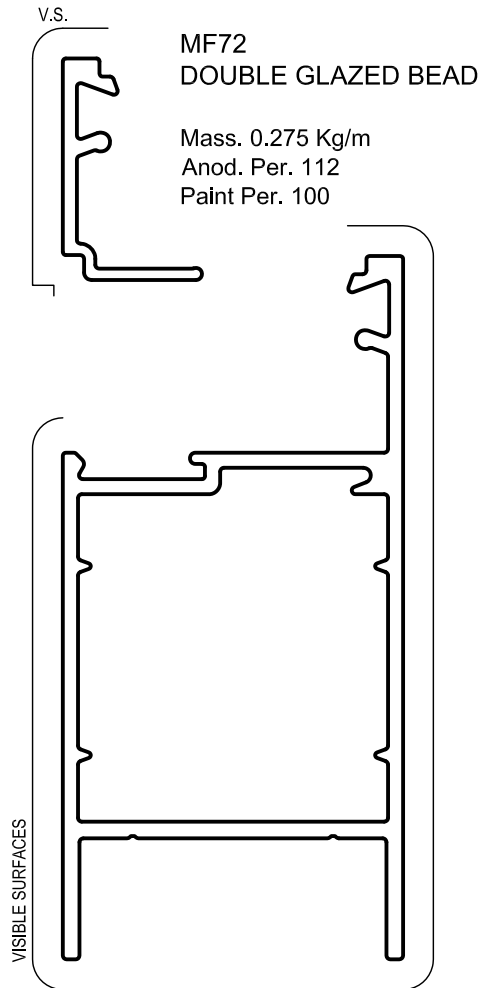
**MF77
EXTRA H/D DOUBLE
GLAZED BIFOLD STILE**

Mass. 3.702 Kg/m
Anod Per. 375
Paint Per. 271

Ixx = 539.39 x 10³ mm⁴

**FOR DOUBLE GLAZED DOOR
USE AD1033 SPIGGOT SET
Code No. 378073**

EXTRUSION PROFILES



MF72
DOUBLE GLAZED BEAD

Mass. 0.275 Kg/m
Anod. Per. 112
Paint Per. 100

MF71
DOUBLE GLAZED
DOOR RAIL

Mass. 1.494 Kg/m
Anod. Per. 335
Paint Per. 170

FOR DOUBLE GLAZED DOOR
USE AD1033 SPIGGOT SET
Code No. 378073



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