

CUSTOMER TECHNICAL MEMO # 66

Subject: Hawkesbury, Hawkesbury plus & Swan Door Revisions

Date: 11/6/09

From: Product Development

(26 pages in total)

Please be advised there have been amendments made to our Hawkesbury, Hawkesbury Plus and Swan Door Technical Manuals. We have been made aware of discrepancies relating to the images and sizes of sections MF70 Double Glazed Door Stile, MF71 Double Glazed Rail, MF72 Double Glazed Bead found in these manuals.

The above Technical Manuals have now been amended, revised and updated on the ALSPEC website. All DWG and DXF files have also been amended, revised and updated.

The Tech Manual pages and how they are affected are as follows:

Hawkesbury:

- Page 1.0 Technical Manual Release Notes have been updated with changes
- Page 3.1.8 Extrusions – MF70, MF71 & MF72 section image updated to show correct pocket glazing depth and properties amended
- Page 3.6.6 Door Stile Preparation – MF70 section image updated to show correct glazing pocket depth
- Page 3.6.7 Door Stile Preparation – MF71 section image updated to show correct glazing pocket depth
- Page 3.7.2 Glazing Details – MF70 section image updated to show correct glazing pocket depth

Hawkesbury PLUS:

- Page 1.0 Technical Manual Release Notes have been updated with changes
- Page 3.1.7 Extrusions - MF70, MF71 & MF72 section image updated to show correct pocket glazing depth and properties amended
- Page 3.7.2 Glazing Details – MF70 section image updated to show correct glazing pocket depth

Swan Commercial Door:

- Page 1.0 Technical Manual Release Notes have been updated with changes
- Page 3.1.9 Extrusions – MF70 section image updated to show correct pocket glazing depth
- Page 3.4.9 Double Glazed Details – Detail 21 MF70 section image updated to show correct glazing pocket depth, and Glass width formula amended to read ***Glass width = DW-126.***
- Page 3.6.11 Frame Preparation – MF71 section image updated to show correct glazing pocket depth
- Page 3.6.12 Frame Preparation – MF70 section image updated to show correct glazing pocket depth

All the above pages are included in this Technical Memo. The Technical Memo format has been set for double sided printing so you will be able to easily print these pages and replace them in your manuals. However, you will need to ensure your printer is set to double-sided printing for this to work.

A sticker for the Hawkesbury wall chart is in the process of being created. If you have one of these in your office please let your local Area Manager know and he/she will provide this to you when they are available.

If you have a copy of the Swan Commercial Door Wall Chart, your Area Manager can provide you with an updated copy.

Please be advised there are no problems with the formulas in V6 or the calculators, the problem is only relating to the wrong images of sections shown on the drawings.

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

ALSPEC ALUMINIUM SYSTEMS

TECHNICAL MANUAL

HAWKESBURY

Section 1.0

TECHNICAL MANUAL RELEASE NOTES

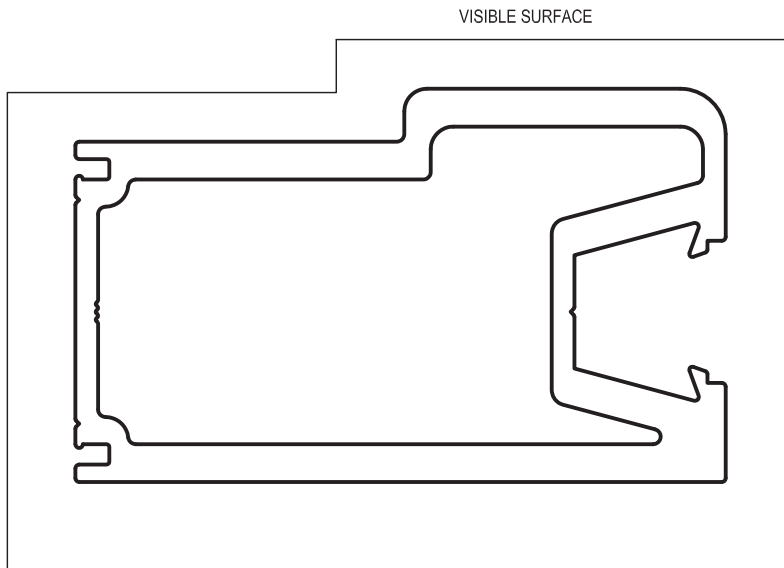
This page is intended to record all changes to the **HAWKESBURY** technical manual pages. It is therefore critical that all changes are recorded in the below AMENDMENTS box prior to release to our customer.

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 this 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

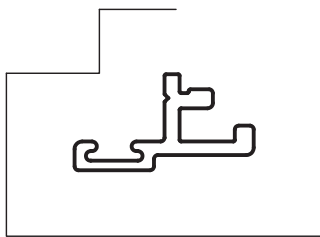
EXTRUSION PROFILES



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

Mass. 3.568 Kg/m
Anod. Per. 341
Paint Per. 278

$I_{xx} = 478.56 \times 10^3 \text{mm}^4$
 $I_{yy} = 1027.78 \times 10^3 \text{mm}^4$

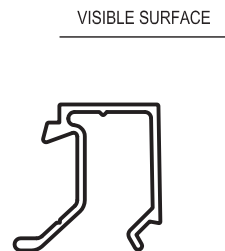


VISIBLE SURFACE

**MFA29
MEETING STILE ADAPTOR**

Mass. 0.219 Kg/m
Anod. Per. 100
Paint Per. 100

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



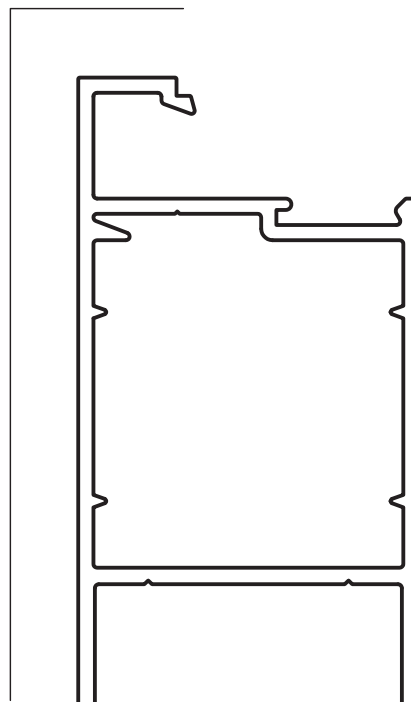
VISIBLE SURFACE

**MF18
GLAZING BEAD**

Mass. 0.18 Kg/m
Anod. Per. 121
Paint Per. 100

$I_{xx} = 2.24 \times 10^3 \text{mm}^4$
 $I_{yy} = 2.85 \times 10^3 \text{mm}^4$

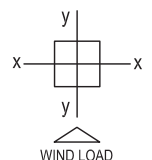
VISIBLE SURFACES



**MF17
TOP & BOTTOM RAIL**

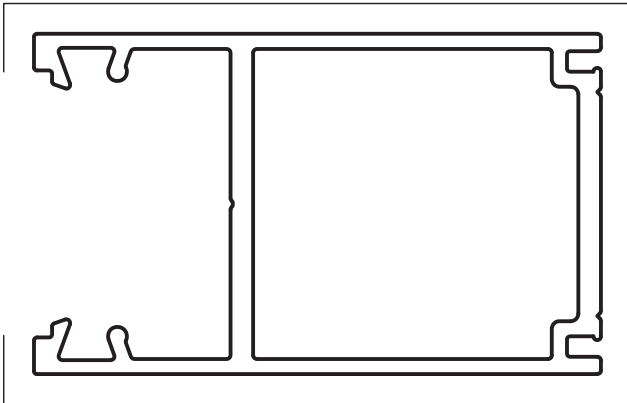
Mass. 1.445 Kg/m
Anod. Per. 327
Paint Per. 166

$I_{xx} = 175.16 \times 10^3 \text{mm}^4$
 $I_{yy} = 317.08 \times 10^3 \text{mm}^4$



EXTRUSION PROFILES

VISIBLE SURFACE

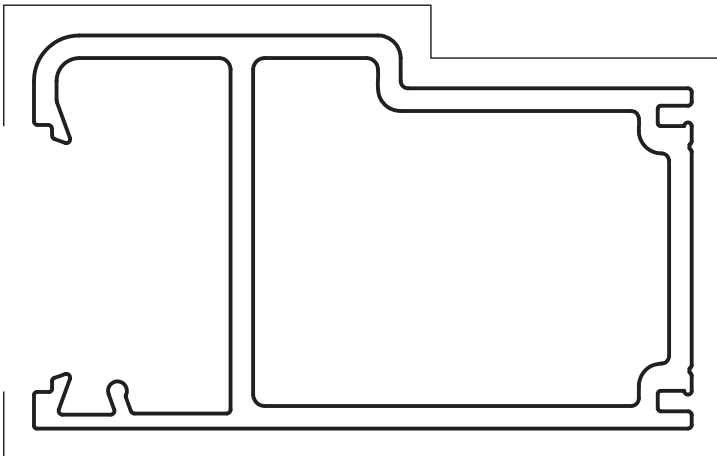


MF70
DOUBLE GLAZED DOOR STILE

Mass. 1.627 Kg/m
Anod. Per. 347
Paint Per. 223

$I_{xx} = 191.5 \times 10^3 \text{ mm}^4$
 $I_{yy} = 360.4 \times 10^3 \text{ mm}^4$

VISIBLE SURFACE

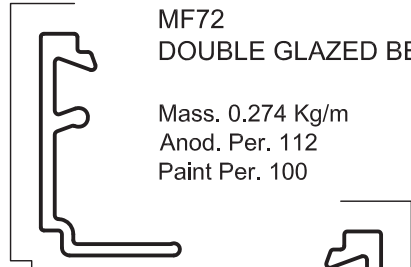


MF73
DOUBLE GLAZED HEAVY
DUTY STILE

Mass. 2.262 Kg/m
Anod. Per. 384
Paint Per. 257

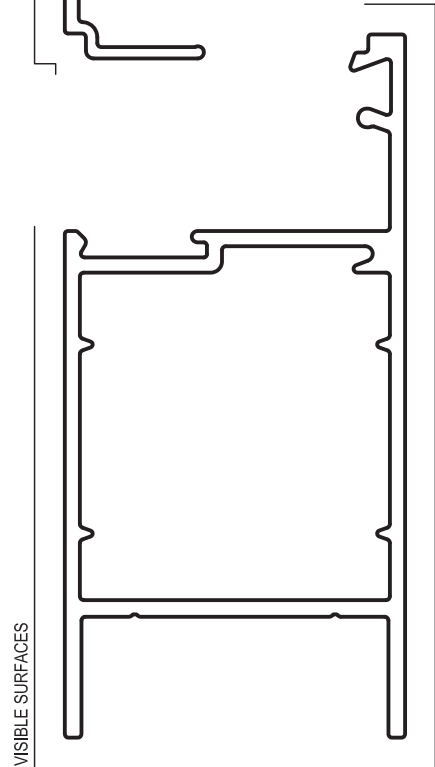
$I_{xx} = 334.51 \times 10^3 \text{ mm}^4$
 $I_{yy} = 641.18 \times 10^3 \text{ mm}^4$

V.S.



MF72
DOUBLE GLAZED BEAD

Mass. 0.274 Kg/m
Anod. Per. 112
Paint Per. 100

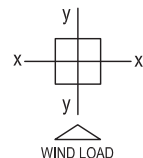


MF71
DOUBLE GLAZED TOP &
BOTTOM RAIL

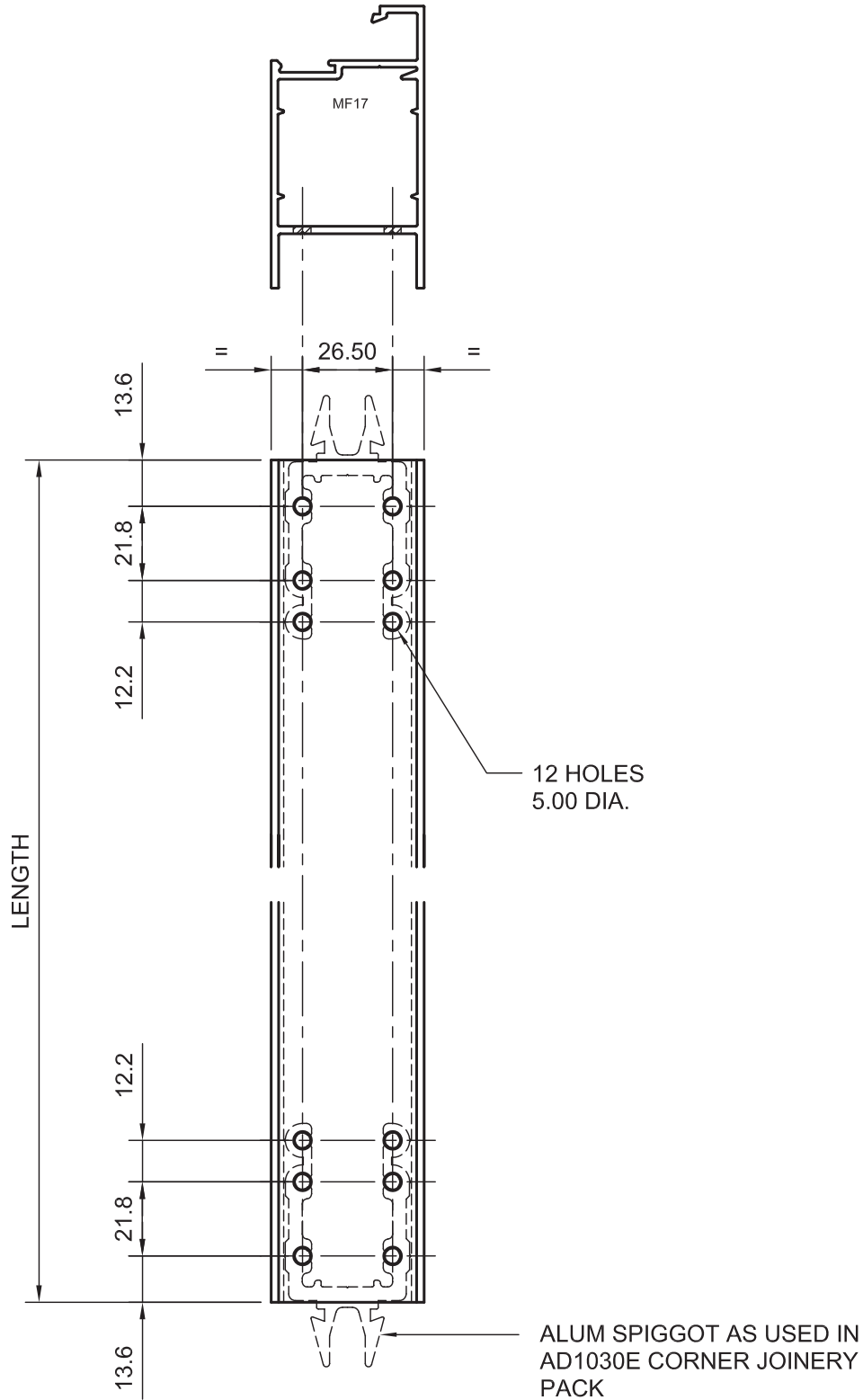
Mass. 1.489 Kg/m
Anod. Per. 335
Paint Per. 241

$I_{xx} = 185.1 \times 10^3 \text{ mm}^4$
 $I_{yy} = 361.2 \times 10^3 \text{ mm}^4$

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

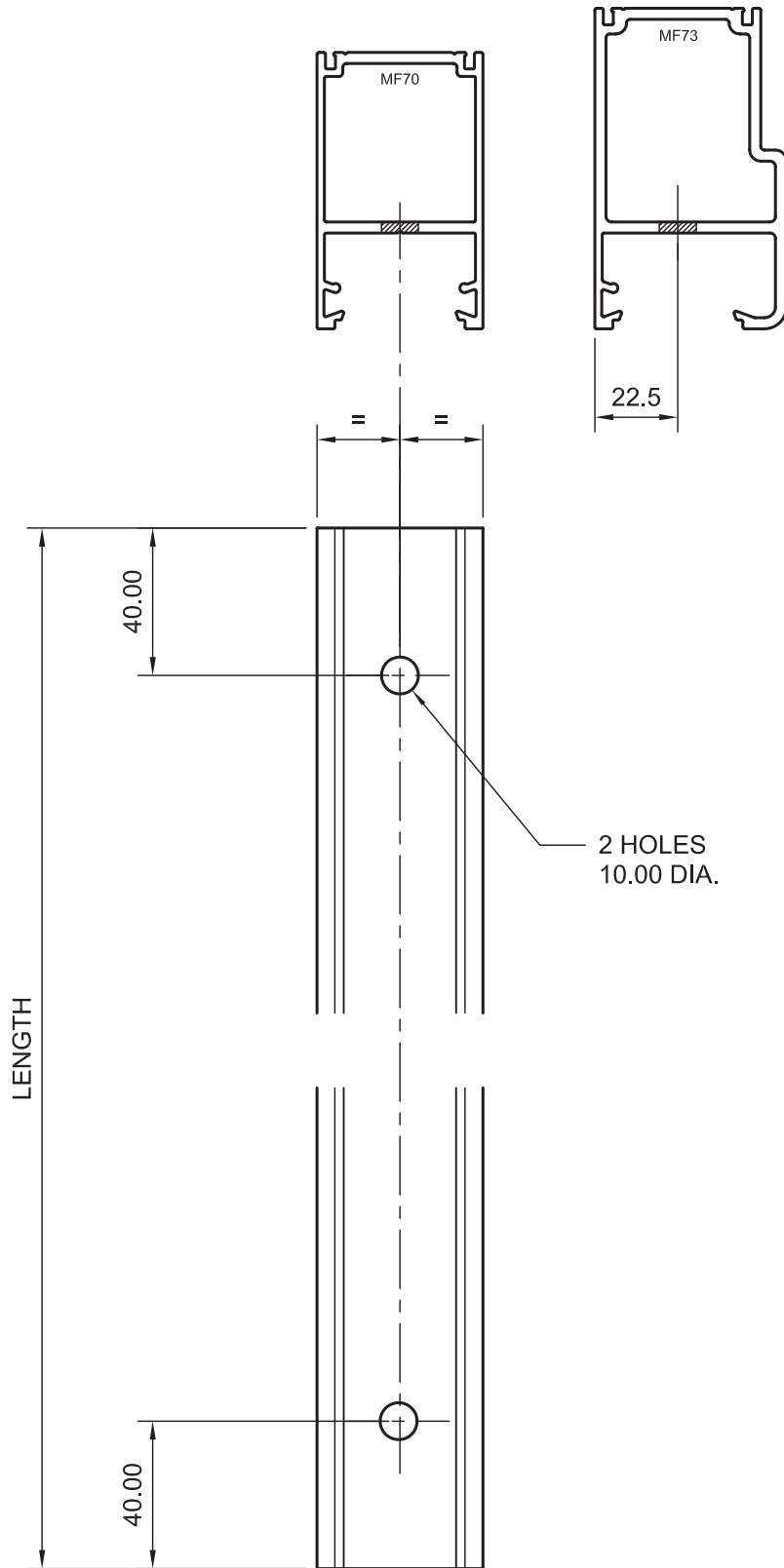


DOOR RAIL PREPARATION SINGLE GLAZED



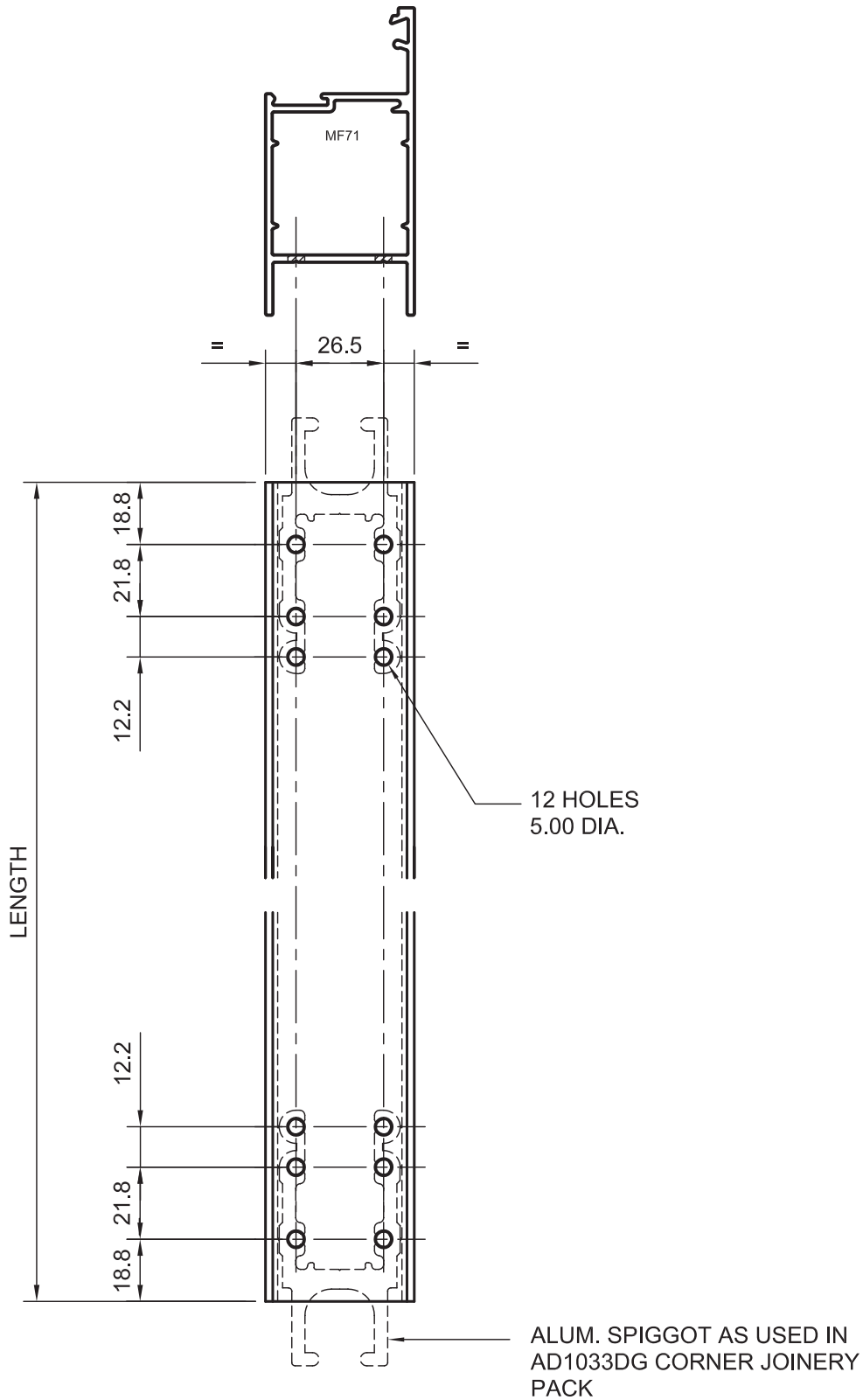
HALF SCALE

DOOR STYLE PREPARATION FOR AD1033DG SPIGOT



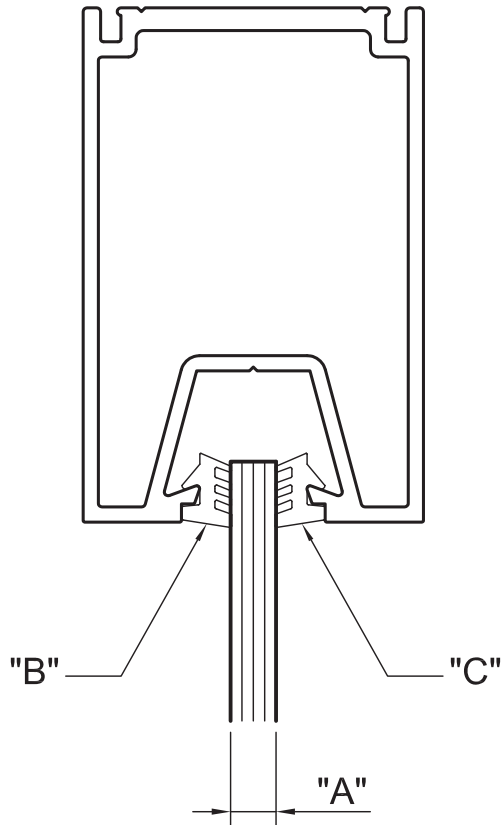
HALF SCALE

DOOR RAIL PREPARATION DOUBLE GLAZED



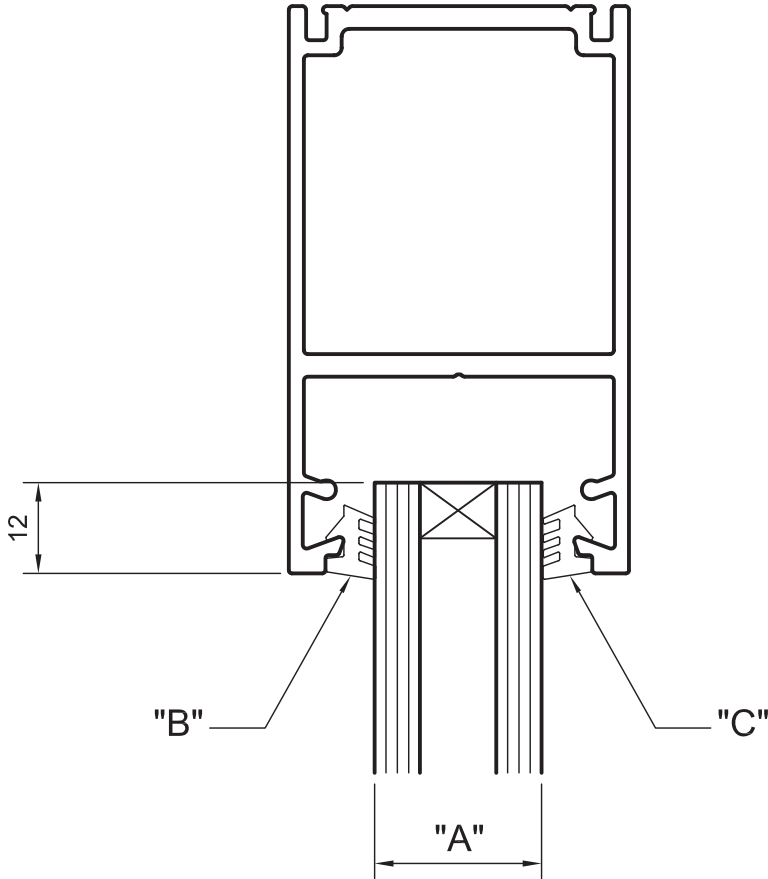
HALF SCALE

GLAZING DETAILS



"A" GLASS THICKNESS	"B" OUTER WEDGE	"C" INNER WEDGE
4mm	GR4 Code 376021	GR4 Code 376021
5mm	GR3 Code 376015	GR4 Code 376021
6mm	GR3 Code 376015	GR3 Code 376015
8mm	GR2 Code 376012	GR3 Code 376015
10mm	GR2 Code 376012	GR2 Code 376012

GLAZING DETAILS DOUBLE GLAZED



"A" GLASS THICKNESS	"B" OUTER WEDGE	"C" INNER WEDGE
16mm	CE17 Code 376350	GR26 Code 376119
18mm	GR3 Code 376015	GR26 Code 376119
24mm	GR2 Code 376012	GR2 Code 376012
26mm	GR3 Code 376015	GR2 Code 376012

ALSPEC ALUMINIUM SYSTEMS

TECHNICAL MANUAL

HAWKESBURY plus

Section 1.0

TECHNICAL MANUAL RELEASE NOTES

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

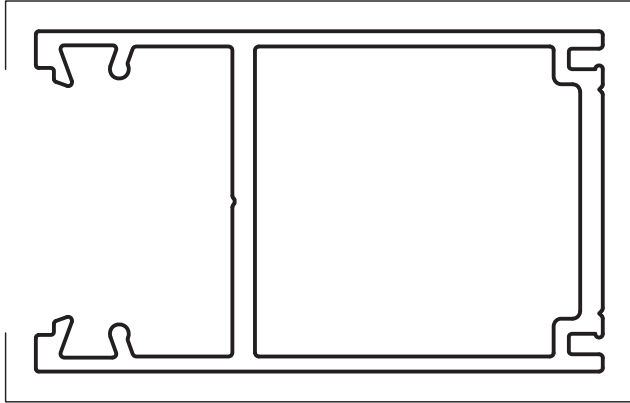
Changes or additions to this manual will be itemised with a brief description and date when the amendments were made.

It is important that a copy of this 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
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

EXTRUSION PROFILES

VISIBLE SURFACE

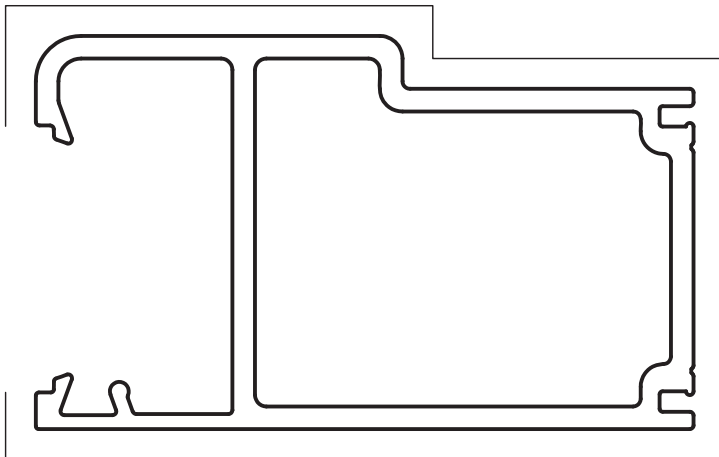


**MF70
DOUBLE GLAZED DOOR STILE**

Mass. 1.627 Kg/m
Anod. Per. 347
Paint Per. 223

$I_{xx} = 191.5 \times 10^3 \text{ mm}^4$
 $I_{yy} = 360.4 \times 10^3 \text{ mm}^4$

VISIBLE SURFACE



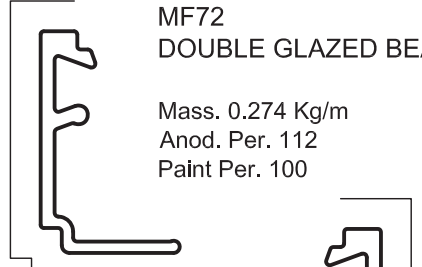
**MF73
DOUBLE GLAZED HEAVY
DUTY STILE**

Mass. 2.262 Kg/m
Anod. Per. 384
Paint Per. 257

$I_{xx} = 334.51 \times 10^3 \text{ mm}^4$
 $I_{yy} = 641.18 \times 10^3 \text{ mm}^4$

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

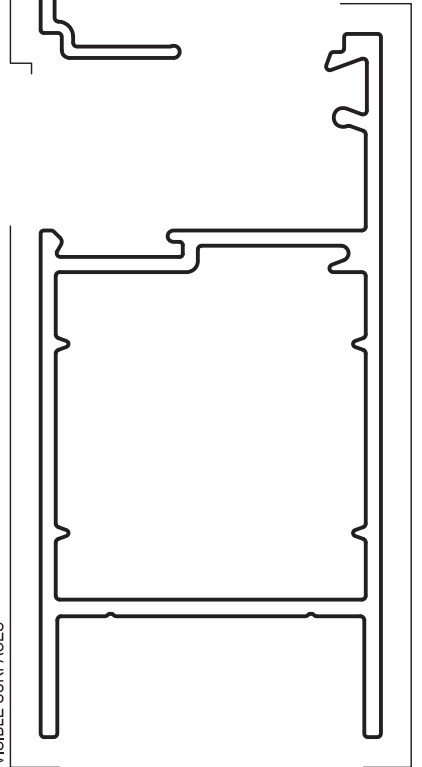
V.S.



**MF72
DOUBLE GLAZED BEAD**

Mass. 0.274 Kg/m
Anod. Per. 112
Paint Per. 100

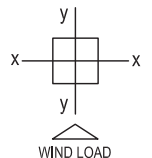
VISIBLE SURFACES



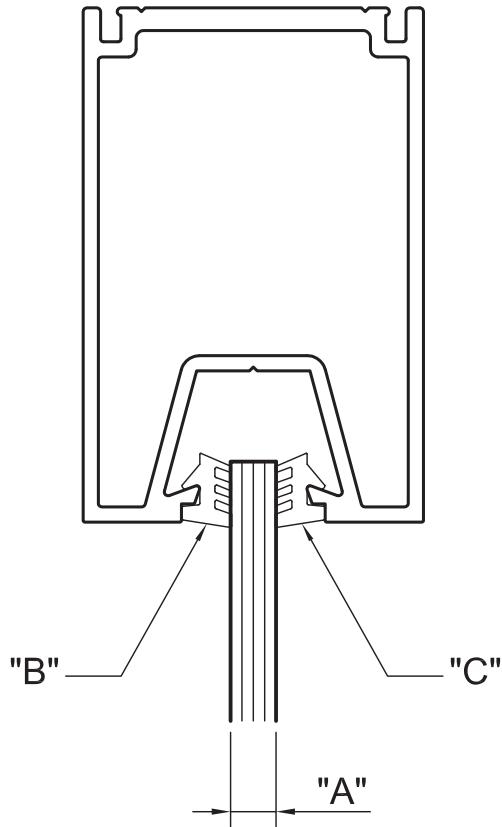
**MF71
DOUBLE GLAZED TOP &
BOTTOM RAIL**

Mass. 1.489 Kg/m
Anod. Per. 335
Paint Per. 241

$I_{xx} = 185.1 \times 10^3 \text{ mm}^4$
 $I_{yy} = 361.2 \times 10^3 \text{ mm}^4$

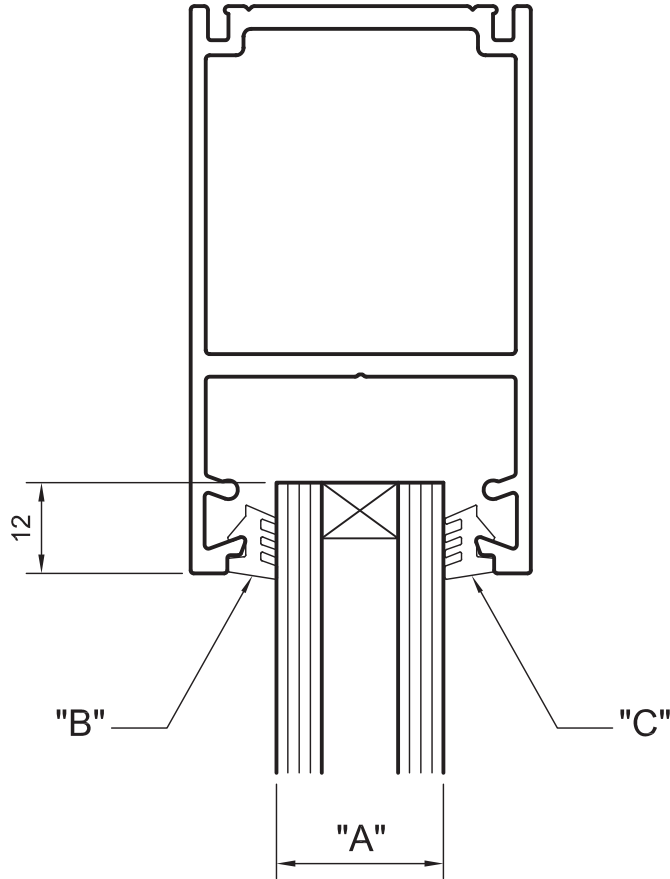


S/G GLAZING DETAILS



"A" GLASS THICKNESS	"B" OUTER WEDGE	"C" INNER WEDGE
4mm	GR4 Code 376021	GR4 Code 376021
5mm	GR3 Code 376015	GR4 Code 376021
6mm	GR3 Code 376015	GR3 Code 376015
8mm	GR2 Code 376012	GR3 Code 376015
10mm	GR2 Code 376012	GR2 Code 376012

D/G GLAZING DETAILS



"A" GLASS THICKNESS	"B" OUTER WEDGE	"C" INNER WEDGE
16mm	CE17 Code 376350	GR26 Code 376119
18mm	GR3 Code 376015	GR26 Code 376119
24mm	GR2 Code 376012	GR2 Code 376012
26mm	GR3 Code 376015	GR2 Code 376012

ALSPEC ALUMINIUM SYSTEMS

TECHNICAL MANUAL

SWAN COMMERCIAL DOOR

Section 1.0

TECHNICAL MANUAL RELEASE NOTES

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

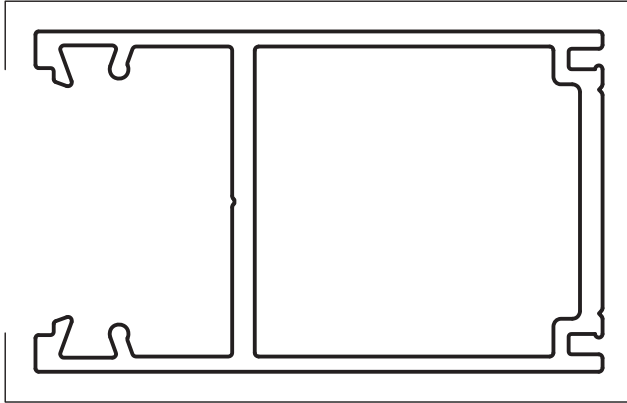
Changes or additions to this manual will be itemised with a brief description and date when the amendments were made.

It is important that a copy of this 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>	~	~
01 / 02 / 2009	<i>Technical manual release notes updated</i>	1.0	1.0
01 / 02 / 2009	<i>New Door Stop extrusion added</i>	3.1.13	3.1.13
01 / 02 / 2009	<i>Seal selection chart updated</i>	3.1.15	3.1.15
01 / 02 / 2009	<i>Spigot kit selection chart added</i>	3.2.6	3.2.6
01 / 02 / 2009	<i>Specification amended</i>	2.1	2.1
01 / 06 / 2009	<i>Technical manual release notes updated</i>	1.0	1.0
01 / 06 / 2009	<i>MF70 extrusion amended</i>	3.1.9	3.1.9
01 / 06 / 2009	<i>Detail 21 MF70 extrusion & formula amended</i>	3.4.9	3.4.9
01 / 06 / 2009	<i>MF71 extrusion amended</i>	3.6.11	3.6.11
01 / 06 / 2009	<i>MF70 extrusion amended</i>	3.6.12	3.6.12

EXTRUSION PROFILES

VISIBLE SURFACE

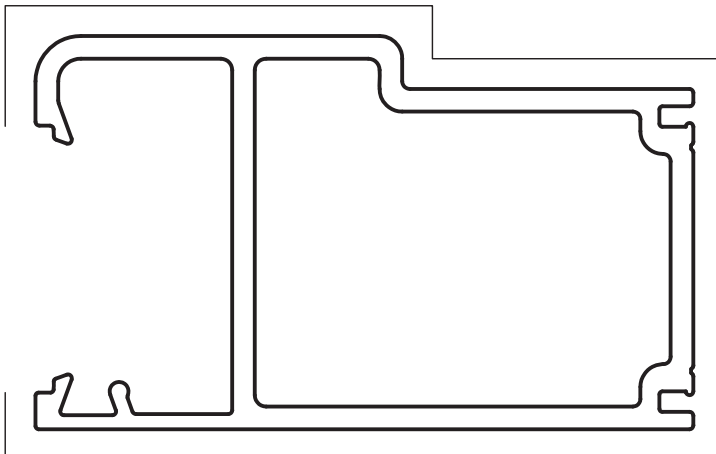


MF70
DOUBLE GLAZED DOOR STILE

Mass. 1.627 Kg/m
Anod. Per. 347
Paint Per. 223

$I_{xx} = 191.5 \times 10^3 \text{ mm}^4$
 $I_{yy} = 360.4 \times 10^3 \text{ mm}^4$

VISIBLE SURFACE



MF73
DOUBLE GLAZED HEAVY
DUTY STILE

Mass. 2.262 Kg/m
Anod. Per. 384
Paint Per. 257

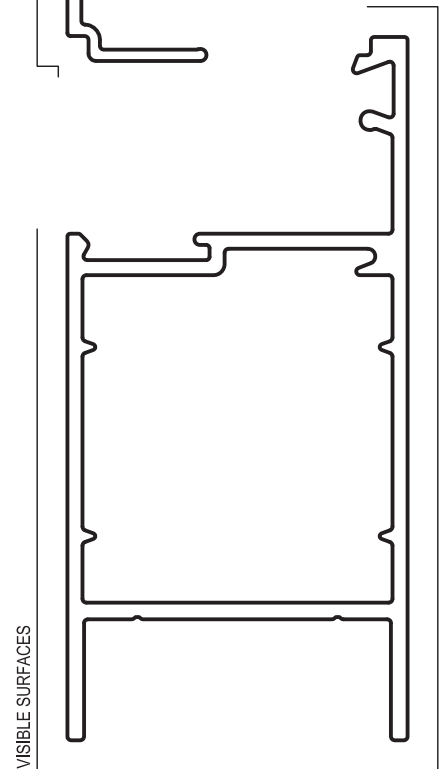
$I_{xx} = 334.51 \times 10^3 \text{ mm}^4$
 $I_{yy} = 641.18 \times 10^3 \text{ mm}^4$

V.S.



MF72
DOUBLE GLAZED BEAD

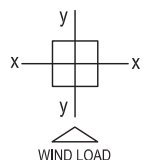
Mass. 0.274 Kg/m
Anod. Per. 112
Paint Per. 100



MF71
DOUBLE GLAZED TOP &
BOTTOM RAIL

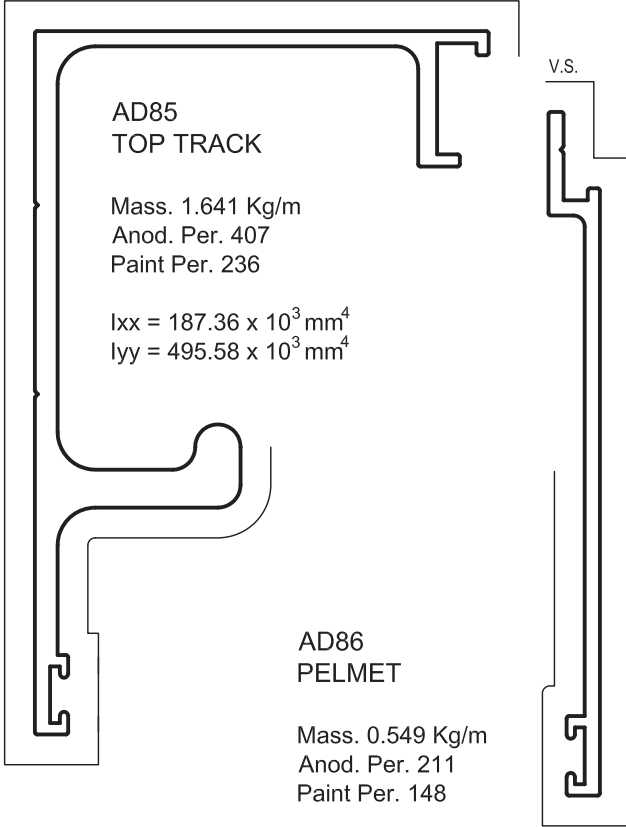
Mass. 1.489 Kg/m
Anod. Per. 335
Paint Per. 241

$I_{xx} = 185.1 \times 10^3 \text{ mm}^4$
 $I_{yy} = 361.2 \times 10^3 \text{ mm}^4$

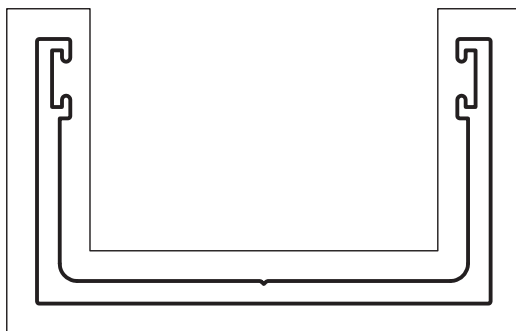
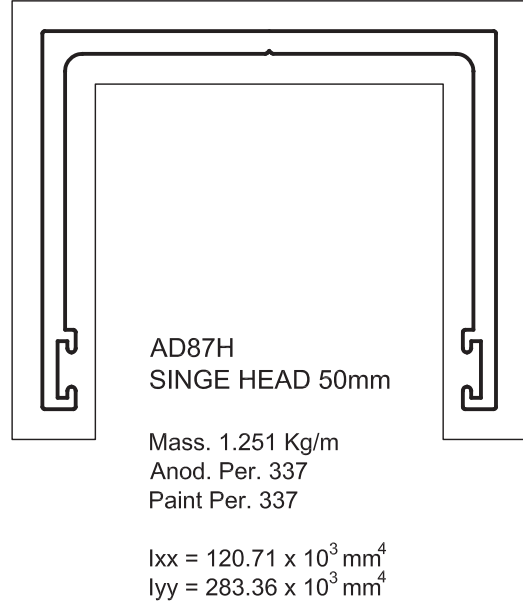


EXTRUSION PROFILES

VISIBLE SURFACE



VISIBLE SURFACE

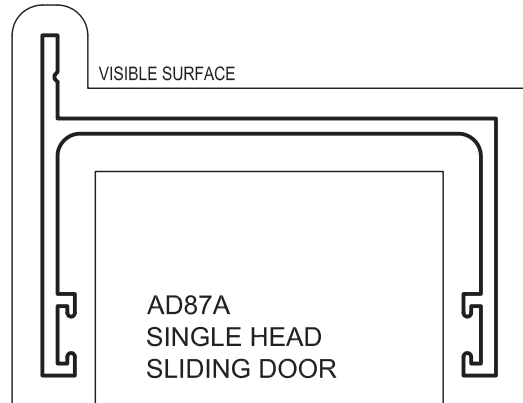


VISIBLE SURFACE

**AD87
BOTTOM GUIDE**

Mass. 1.008 Kg/m
Anod. Per. 277
Paint Per. 277

$I_{xx} = 44.98 \times 10^3 \text{ mm}^4$
 $I_{yy} = 210.19 \times 10^3 \text{ mm}^4$

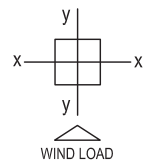


VISIBLE SURFACE

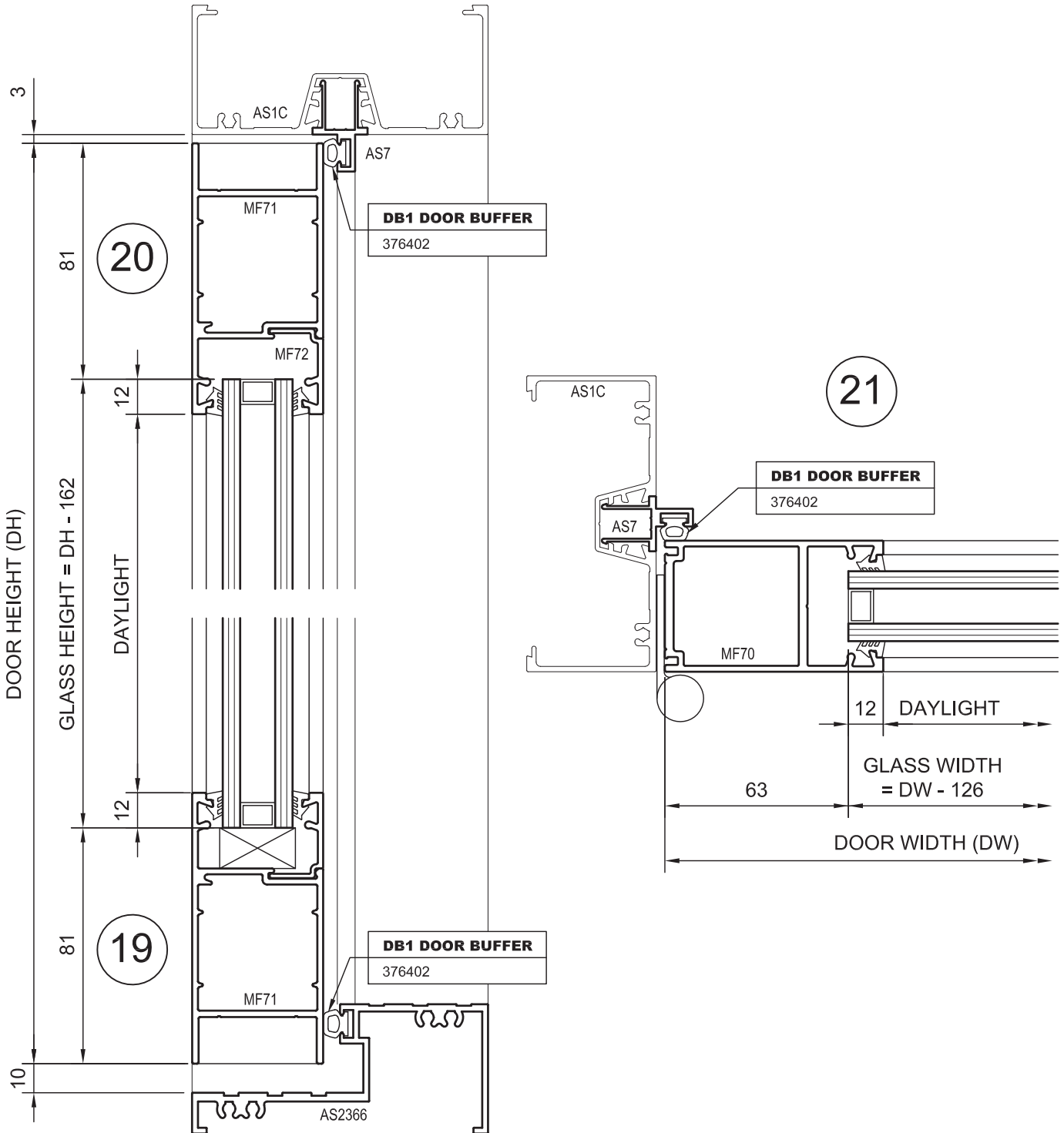
**AD87A
SINGLE HEAD
SLIDING DOOR**

Mass. 0.792 Kg/m
Anod. Per. 300
Paint Per. 300

$I_{xx} = 41.74 \times 10^3 \text{ mm}^4$
 $I_{yy} = 177.83 \times 10^3 \text{ mm}^4$

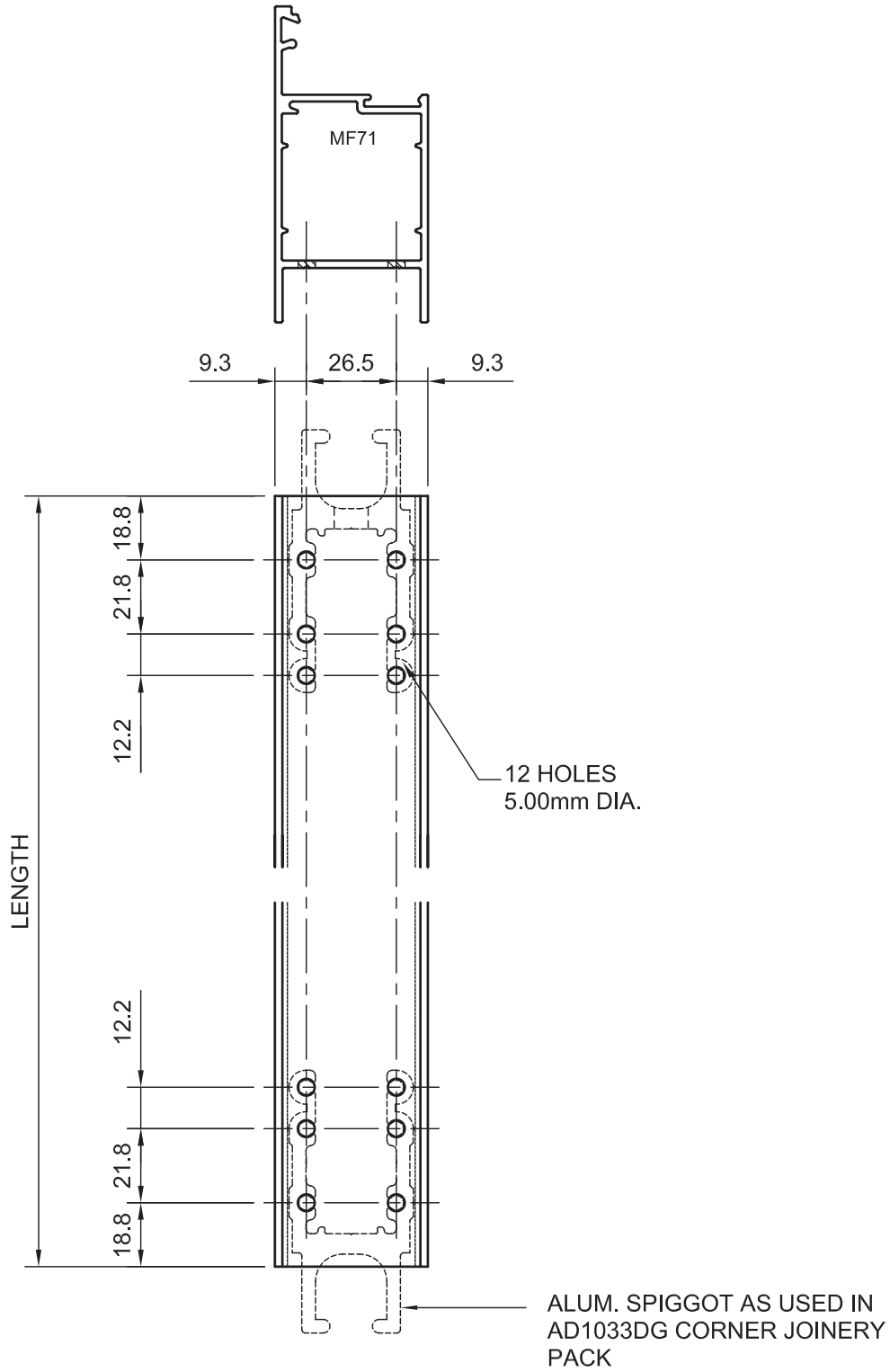


DOUBLE GLAZED TOP, BOTTOM RAIL AND STILE DOOR DETAILS



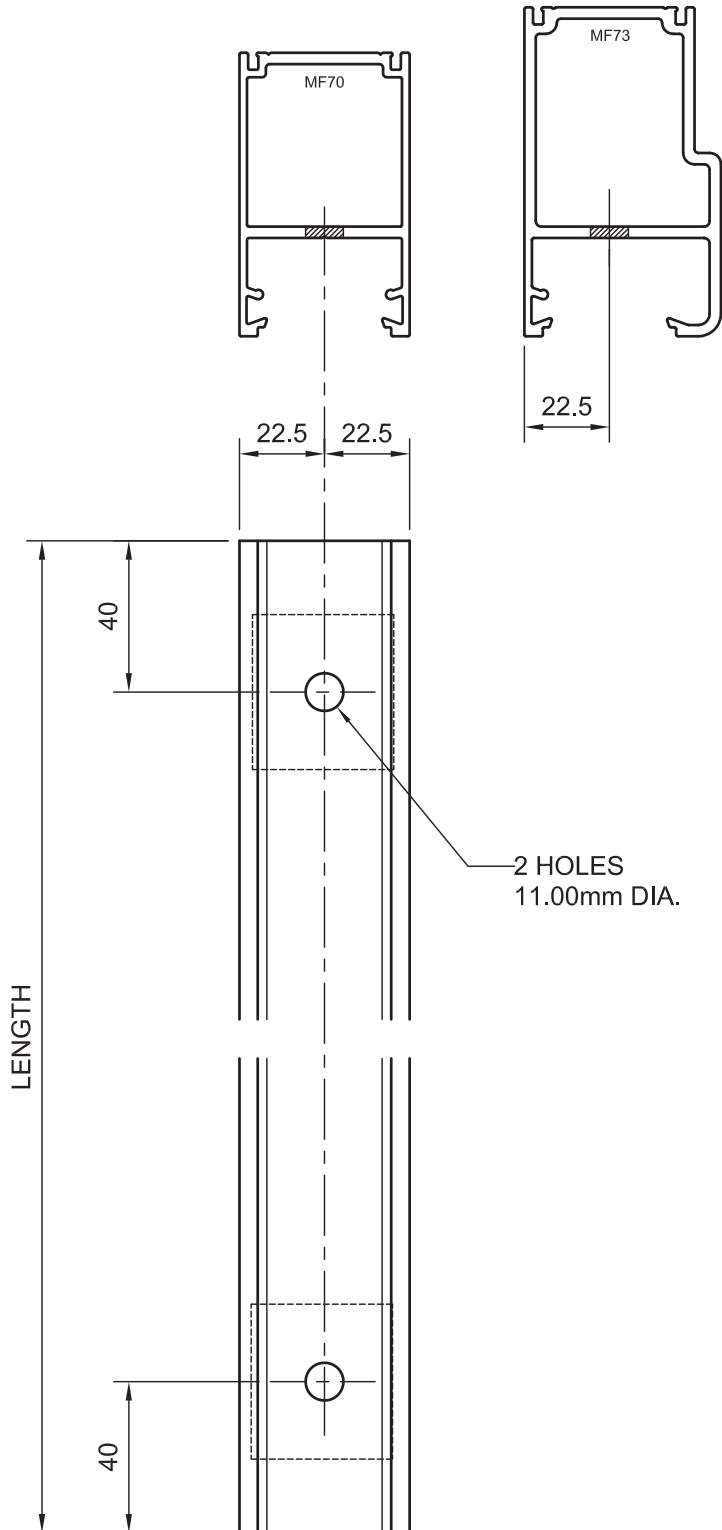
NOTE!
FORMULAS ARE BASED ON SECTIONS
AS SHOWN ON DETAIL PAGES.

FRAME PREPARATION 11



HALF SCALE

FRAME PREPARATION 12



HALF SCALE