

## CUSTOMER TECHNICAL MEMO # 79

**Subject:** Commercial Sliding Door , View-max Sliding Window & Double Hung Technical Manual Amendments

**Date:** 7/8/09

**From:** Product Development

Please be advised there have been changes to the Commercial Sliding Door, View-max Sliding Window and View-max Double Hung Technical Manuals. Refer below for a list of changes.

### **Commercial Sliding Door**

Page 1.0 – Technical Manual Release Notes updated

Pages 3.5.1 to 3.5.5 – quantities, formulas and section numbers amended, AD769

Flyscreen add on track added where applicable.

### **View-max Sliding Window**

Page 1.0 – Technical Manual Release Notes updated

Pages 3.5.6 to 3.5.10 and 3.5.21 to 3.5.25 – FS2 Flyscreen formulas amended

### **View-max Double Hung**

Page 1.0 – Technical Manual Release Notes updated

Page 3.1.7 – Flyscreen Channel description & details amended

Pages 3.4.2, 3.4.4, 3.4.6, 3.4.8, 3.4.10 – Flyscreen section number details amended

Pages 3.5.1 to 3.5.5 – Flyscreen formulas amended

Page 3.6.22 – Flyscreen description & notes amended

All the above revised 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 pages in your manuals. You will need to ensure your printer is set to double-sided printing.

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



# ALSPEC ALUMINIUM SYSTEMS

## TECHNICAL MANUAL

### COMMERCIAL SLIDING DOOR

Section 1.0

#### TECHNICAL MANUAL RELEASE NOTES

This page is intended to record all changes to the **COMMERCIAL SLIDING 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	Technical manual initial release	~	~
01 / 02 / 2009	Contents	~	~
01 / 02 / 2009	Technical manual release notes	1.0	1.0
01 / 02 / 2009	Specification	2.1	2.1
01 / 02 / 2009	Load tables	2.2	2.2
01 / 02 / 2009	Test report results	2.3.1	2.3.1
01 / 02 / 2009	Test report results	2.3.2	2.3.2
01 / 02 / 2009	100mm OX standard sill water rating	2.3.3	2.3.3
01 / 02 / 2009	150mm OXX standard sill water rating	2.3.4	2.3.4
01 / 02 / 2009	100mm OX standard sill / HP water rating	~	2.3.5
01 / 02 / 2009	100mm OX standard sill / HP water rating	~	2.3.6
01 / 02 / 2009	100mm OX standard sill / HP water rating	~	2.3.7
01 / 02 / 2009	Extrusion profiles	3.1.15	3.1.15
01 / 02 / 2009	Extrusion profiles	3.1.16	3.1.16
01 / 02 / 2009	Extrusion profiles	3.1.17	3.1.17
01 / 02 / 2009	Extrusion profiles	~	3.1.18
01 / 02 / 2009	Hardware components	3.2.4	3.2.4
01 / 02 / 2009	Sliding flush sill detail with AS335 sub sill front view	~	3.4.14
01 / 02 / 2009	Sliding flush sill detail with AS335 sub sill back view	~	3.4.15
01 / 02 / 2009	Sliding HP sill detail with AS335 sub sill front view	~	3.4.16
01 / 02 / 2009	Sliding flush sill detail with AS335 sub sill back view	~	3.4.17
01 / 02 / 2009	Typical details	3.4.1 to 3.4.12	3.4.1 to 3.4.12
01 / 02 / 2009	Cutting formula – triple track	3.5.4	3.5.4
01 / 02 / 2009	Cutting formula – triple track bi part	3.5.5	3.5.5
01 / 08 / 2009	Technical manual release notes revised	1.0	1.0

# ALSPEC ALUMINIUM SYSTEMS

## TECHNICAL MANUAL

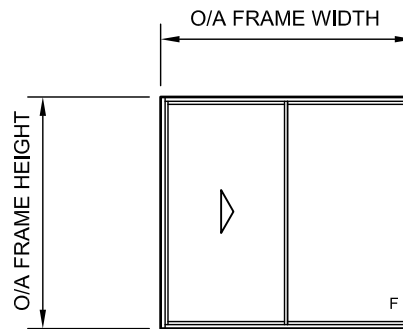
### COMMERCIAL SLIDING DOOR

Section 1.0

#### TECHNICAL MANUAL RELEASE NOTES Cont.

DATE	AMENDMENT DESCRIPTION	REMOVE PAGE	INSERT NEW PAGE
01 / 08 / 2009	<i>New page added</i>	~	1.1
01 / 08 / 2009	<i>Cutting formulars revised</i>	3.5.1 - 3.5.5	3.5.1 - 3.5.5

## EXTRUSION CUTTING FORMULA – SLIDE, FIXED

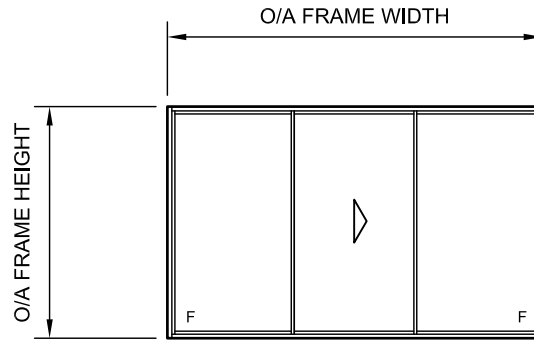


**XO**

<b>CUTTING FORMULA</b>				
<b>PROFILE</b>	<b>SECTION No.</b>	<b>DESCRIPTION</b>	<b>CUTTING FORMULA</b>	<b>QTY</b>
	AD741	HEAD	O/A FRAME WIDTH - 56mm	1
	AD742	HOLLOW SILL	O/A FRAME WIDTH - 56mm	1
	AD741	JAMB	O/A FRAME HEIGHT	2
(A)	AD758, AD757	DOOR RAILS	O/A FRAME WIDTH/2 - 123mm	4
	AD745	CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
(A)	AD795 (optional)	70mm CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
	AD744, 747, 749	INTERLOCK MULLION	O/A FRAME HEIGHT - 82mm	2
	AD729	HEAD THRESHOLD	O/A FRAME WIDTH/2 - 79mm	1
	AD801, AD736	SILL THRESHOLD	O/A FRAME WIDTH/2 - 79mm	1
	AD703	VERT. THRESHOLD	O/A FRAME HEIGHT - 105mm	2
	AD797	FXD. PANEL ADAPTOR	CUT TO 150mm LONG	2
	AD760	FLYDOOR HEAD ADAPT.	O/A FRAME WIDTH - 56mm	1
	AD760	FLYDOOR SILL ADAPT.	O/A FRAME WIDTH - 56mm	1
	AD769	ADD ON TRACK	O/A FRAME WIDTH - 56mm	1
	AD759	FLYDOOR JAMB ADAPT.	O/A FRAME HEIGHT	2
GLASS SIZES 3 OFF O/A FRAME HEIGHT - 182mm O/A FRAME WIDTH / 3 - 103mm				

(A) WHEN USING AD795 70mm CLOSING STILES CUT RAILS 24mm SHORTER

## EXTRUSION CUTTING FORMULA – FIXED, SLIDE, FIXED



**OXO**

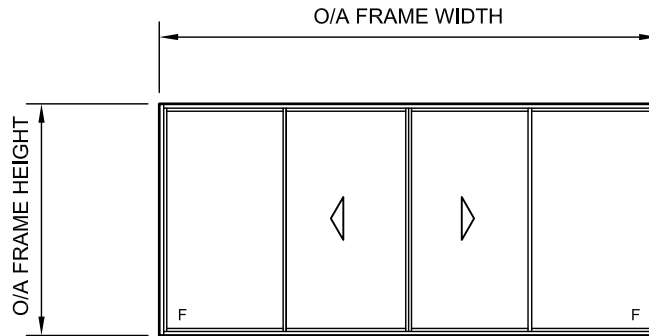
### CUTTING FORMULA

PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AD741	HEAD	O/A FRAME WIDTH - 56mm	1
	AD742	HOLLOW SILL	O/A FRAME WIDTH - 56mm	1
	AD741	JAMB	O/A FRAME HEIGHT	2
(A)	AD758, AD757	DOOR RAILS	O/A FRAME WIDTH/3 - 125mm	6
	AD745	CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
(A)	AD795	70mm CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
	AD755, AD748	BI PART MALE STILE	O/A FRAME HEIGHT - 82mm	1
	AD746, AD756	BI PART FEMALE STILE	O/A FRAME HEIGHT - 82mm	1
	AD744, 747, 749	INTERLOCK MULLION	O/A FRAME HEIGHT - 82mm	2
	AD729	HORIZ. THRESHOLD	O/A FRAME WIDTH/3x2 - 76mm	1
	AD801, AD736	ALT. SILL THRESHOLD	O/A FRAME WIDTH/3x2 - 76mm	1
	AD703	VERT. THRESHOLD	O/A FRAME HEIGHT - 105mm	2
*	AD797	FXD. PANEL ADAPTOR	CUT TO 150mm LONG	2
	AD760	FLYDOOR HEAD ADAPT.	O/A FRAME WIDTH - 56mm	1
	AD760	FLYDOOR SILL ADAPT.	O/A FRAME WIDTH - 56mm	1
	AD769	ADD ON TRACK	O/A FRAME WIDTH - 56mm	1
	AD759	FLYDOOR JAMB ADAPT.	O/A FRAME HEIGHT	2
GLASS SIZES 3 OFF O/A FRAME HEIGHT - 182mm O/A FRAME WIDTH / 3 - 105mm				

(A) WHEN USING AD795 70mm CLOSING STILES CUT RAILS 24mm SHORTER

\* USE UNDER INSIDE FIXED PANEL ONLY

## EXTRUSION CUTTING FORMULA – FIXED, SLIDE, SLIDE, FIXED

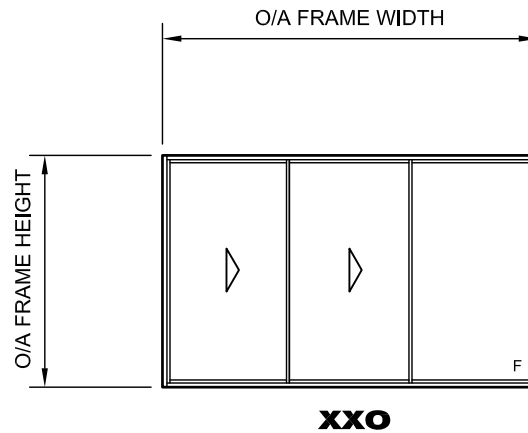


**OXXO**

CUTTING FORMULA				
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AD741	HEAD	O/A FRAME WIDTH - 56mm	1
	AD742	HOLLOW SILL	O/A FRAME WIDTH - 56mm	1
	AD741	JAMB	O/A FRAME HEIGHT	2
(A)	AD758, AD757	DOOR RAILS	O/A FRAME WIDTH/4 - 105mm	8
	AD745	CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
(A)	AD795	70mm CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
	AD755, AD748	BI PART MALE STILE	O/A FRAME HEIGHT - 82mm	1
	AD746, AD756	BI PART FEMALE STILE	O/A FRAME HEIGHT - 82mm	1
	AD744, 747, 749	INTERLOCK MULLION	O/A FRAME HEIGHT - 82mm	4
	AD729	HEAD THRESHOLD	O/A FRAME WIDTH/2 - 79mm	1
	AD801, AD736	SILL THRESHOLD	O/A FRAME WIDTH/2 - 79mm	1
	AD703	VERT. THRESHOLD	O/A FRAME HEIGHT - 105mm	2
	AD797	FXD. PANEL ADAPTOR	CUT TO 150mm LONG	4
	AD760	FLYDOOR HEAD ADAPT.	O/A FRAME WIDTH - 56mm	1
	AD760	FLYDOOR SILL ADAPT.	O/A FRAME WIDTH - 56mm	1
	AD769	ADD ON TRACK	O/A FRAME WIDTH - 56mm	1
	AD759	FLYDOOR JAMB ADAPT.	O/A FRAME HEIGHT	2
GLASS SIZES 4 OFF O/A FRAME HEIGHT - 182mm O/A FRAME WIDTH / 4 - 85mm				

(A) WHEN USING AD795 70mm CLOSING STILES CUT RAILS 24mm SHORTER

## EXTRUSION CUTTING FORMULA – TRIPLE TRACK



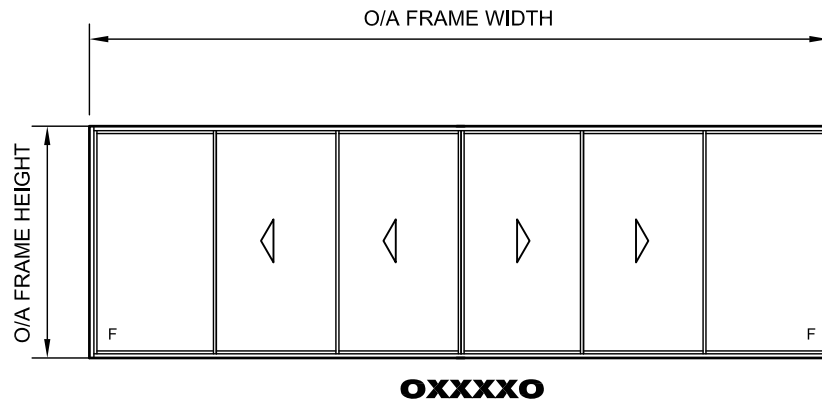
### CUTTING FORMULA

PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AD751	HEAD	O/A FRAME WIDTH - 56mm	1
	AD752	HOLLOW SILL	O/A FRAME WIDTH - 56mm	1
	AD751	JAMB	O/A FRAME HEIGHT	2
(A)	AD758, AD757	DOOR RAILS	O/A FRAME WIDTH/3 - 97mm	8
	AD745	CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
(A)	AD795	70mm CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
	AD745, AD795	CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
	AD744, 747, 749	INTERLOCK MULLION	O/A FRAME HEIGHT - 82mm	4
	AD729	HEAD THRESHOLD	O/A FRAME WIDTH/3x2 - 105mm	1
	AD729	HEAD THRESHOLD	O/A FRAME WIDTH/3 - 58mm	1
	AD729	SILL THRESHOLD	O/A FRAME WIDTH/3 - 58mm	1
	AD736	SILL THRESHOLD	O/A FRAME WIDTH/3x2 - 105mm	1
	AD703	VERT. THRESHOLD	O/A FRAME HEIGHT - 105mm	4
GLASS SIZES 3 OFF O/A FRAME HEIGHT - 182mm O/A FRAME WIDTH / 3 - 77mm				

(A) WHEN USING AD795 70mm CLOSING STILES CUT RAILS 24mm SHORTER



## EXTRUSION CUTTING FORMULA – TRIPLE TRACK BI PART



<b>CUTTING FORMULA</b>				
<b>PROFILE</b>	<b>SECTION No.</b>	<b>DESCRIPTION</b>	<b>CUTTING FORMULA</b>	<b>QTY</b>
	AD751	HEAD	O/A FRAME WIDTH - 56mm	1
	AD752	HOLLOW SILL	O/A FRAME WIDTH - 56mm	1
	AD751	JAMB	O/A FRAME HEIGHT	2
(A)	AD758, AD757	DOOR RAILS	O/A FRAME WIDTH/6 - 85mm	12
	AD745	CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
(A)	AD795	70mm CLOSING STILES	O/A FRAME HEIGHT - 82mm	2
	AD744,747,749	INTERLOCK MULLION	O/A FRAME HEIGHT - 82mm	8
	AD755,AD748	BI PART MALE STILE	O/A FRAME HEIGHT - 82mm	1
	AD746,AD756	BI PART FEMALE STILE	O/A FRAME HEIGHT - 82mm	1
	AD729	HEAD THRESHOLD	O/A FRAME WIDTH/6x4 - 121mm	1
	AD729	HEAD THRESHOLD	O/A FRAME WIDTH/3 - 51mm	1
	AD729	SILL THRESHOLD	O/A FRAME WIDTH/3 - 51mm	1
	AD736	SILL THRESHOLD	O/A FRAME WIDTH/6x4 - 121mm	1
	AD703	VERT. THRESHOLD	O/A FRAME HEIGHT - 105mm	4
GLASS SIZES 6 OFF O/A FRAME HEIGHT - 182mm O/A FRAME WIDTH / 6 - 65mm				

(A) WHEN USING AD795 70mm CLOSING STILES CUT RAILS 24mm SHORTER



# ALSPEC ALUMINIUM SYSTEMS

## TECHNICAL MANUAL

### VIEW-MAX sliding window

Section 1.0

#### TECHNICAL MANUAL RELEASE NOTES

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

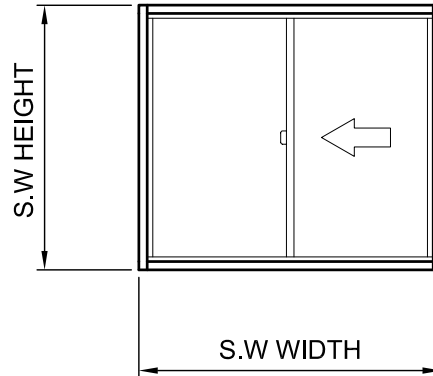
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DATE	AMENDMENT DESCRIPTION	REMOVE PAGE	INSERT NEW PAGE
01 / 08 / 2008	<i>Technical manual initial release</i>	~	~
01 / 02 / 2009	<i>Contents page amended</i>	~	~
01 / 02 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 02 / 2009	<i>Loading table explanation added</i>	2.2	2.2
01 / 02 / 2009	<i>Specification amended</i>	2.1	2.1
01 / 04 / 2009	<i>Contents page amended</i>	~	~
01 / 04 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 04 / 2009	<i>Test report page number amended</i>	2.3	2.3.1
01 / 04 / 2009	<i>Test report page added</i>	~	2.3.2
01 / 04 / 2009	<i>Extrusions, hardware, elevations, general, arrangement, cutting formulas, manufacturing drawings, glazing details</i>	3.1.1 to 3.7.1	3.1.1 to 3.7.1
01 / 08 / 2009	<i>Technical manual release notes amended</i>	1.0	1.0
01 / 08 / 2009	<i>Flyscreen cutting formulas amended</i>	3.5.6 - 3.5.10	3.5.6 - 3.5.10
01 / 08 / 2009	<i>Flyscreen cutting formulas amended</i>	3.5.21 - 3.5.25	3.5.21 - 3.5.25

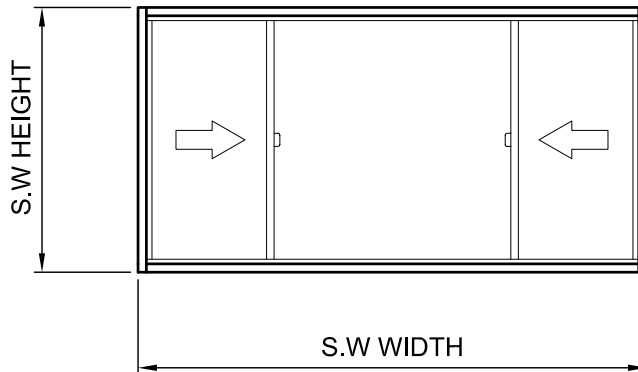


**CUTTING FORMULA OX & XX DG FRAMING, STD SILL**



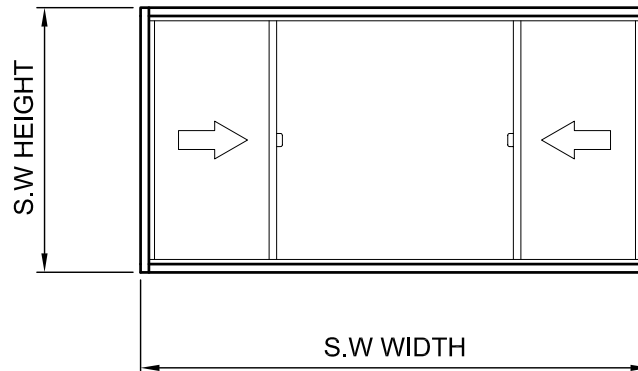
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 100mm	1	1
	VM34	SILL	S.W WIDTH - 100mm	1	1
	SYN-11	JAMB	S.W HEIGHT	2	2
	VM27	DG SASH RECEIVER	S.W HEIGHT - 135mm	2	2
	VM4	DG INTERLOCK STILE	S.W HEIGHT - 137mm	2	2
	VM6	DG PLAIN STILE	S.W HEIGHT - 137mm	2	2
	VM32 or	XX INTERLOCK	S.W HEIGHT - 137mm	1	1
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM39	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM2	DG RAIL	S.W WIDTH/2 - 102mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 95mm	0	2
	FS2	FLYSCREEN	S.W WIDTH/2 - 80mm	0	2
DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT - 115mm x S.W WIDTH/2 - 80mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX 76mm S/GLAZED, STD SILL**



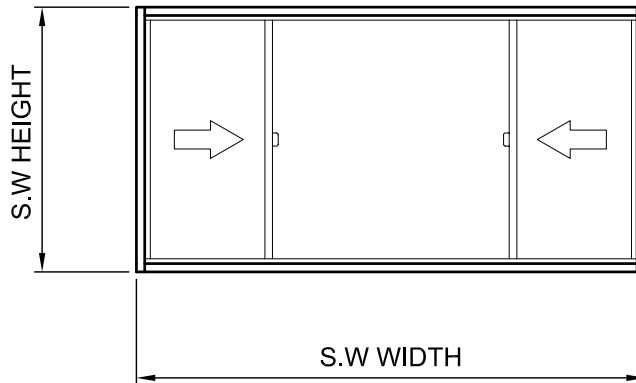
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMUL	QTY 1	QTY 2
	VM8	HEAD	S.W WIDTH - 70mm	1	1
	VM10	SILL	S.W WIDTH - 70mm	1	1
	AS51C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 115mm	2	0
	VM3	INTERLOCK STILE	S.W HEIGHT - 117mm	4	4
	VM5	PLAIN STILE	S.W HEIGHT - 117mm	2	2
	VM9 or VM29 or VM39	INTERLOCK	S.W HEIGHT - 115mm	2	2
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 115mm	0	2
	VM1	RAIL	S.W WIDTH/2 - 40mm	2	2
	VM1	RAIL	S.W WIDTH/4 - 87mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 75mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 65mm	0	4
SINGLE GLAZE SIZES 1 OFF S.W HEIGHT- 97mm x S.W WIDTH/2 - 20mm SINGLE GLAZE SIZES 2 OFF S.W HEIGHT- 97mm x S.W WIDTH/4 - 67mm				NO	SCREEN
				SCREEN	SCREEN

**CUTTING FORMULA XOX 76mm D/GLAZED, STD SILL**



CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM8	HEAD	S.W WIDTH - 70mm	1	1
	VM10	SILL	S.W WIDTH - 70mm	1	1
	AS51C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 115mm	2	0
	VM4	DG INTERLOCK STILE	S.W HEIGHT - 117mm	4	4
	VM6	DG PLAIN STILE	S.W HEIGHT - 117mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 115mm	2	2
	VM39	INTERLOCK	S.W HEIGHT - 115mm	2	2
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 115mm	0	2
	VM2	DG RAIL	S.W WIDTH/2 - 40mm	2	2
	VM2	DG RAIL	S.W WIDTH/4 - 87mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 75mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 65mm	0	4
DOUBLE GLAZE SIZES 1 OFF S/W HEIGHT - 95mm x S.W WIDTH/2 - 18mm DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT - 95mm x S.W WIDTH/4 - 65mm				NO SCREEN	SCREEN

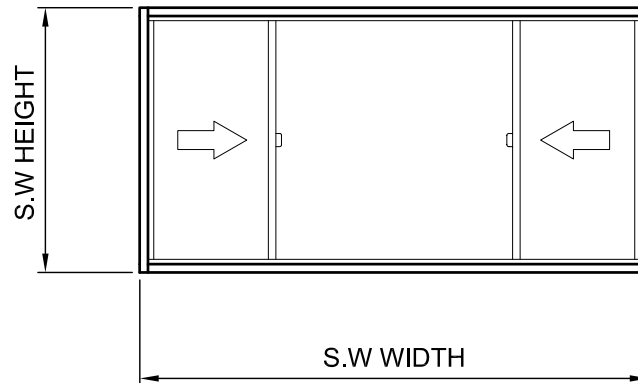
**CUTTING FORMULA XOX 101.6mm S/GLAZED, STD SILL**



CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 89mm	1	1
	VM34	SILL	S.W WIDTH - 89mm	1	1
	AS1C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 135mm	2	0
	VM3	INTERLOCK STILE	S.W HEIGHT - 137mm	2	2
	VM5	PLAIN STILE	S.W HEIGHT - 137mm	2	2
	VM9 or VM29 or VM39	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 135mm	0	2
	VM1	RAIL	S.W WIDTH/2 - 40mm	2	2
	VM1	RAIL	S.W WIDTH/4 - 96mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 95mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 74mm	0	4
SINGLE GLAZE SIZES 1 OFF S.W HEIGHT- 117mm x S.W WIDTH/2 - 20mm SINGLE GLAZE SIZES 2 OFF S.W HEIGHT- 117mm x S.W WIDTH/4 - 76mm				NO SCREEN	SCREEN

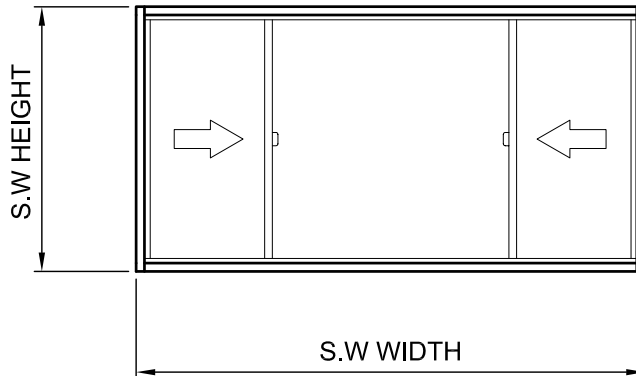


**CUTTING FORMULA XOX 101.6mm D/GLAZED, STD SILL**



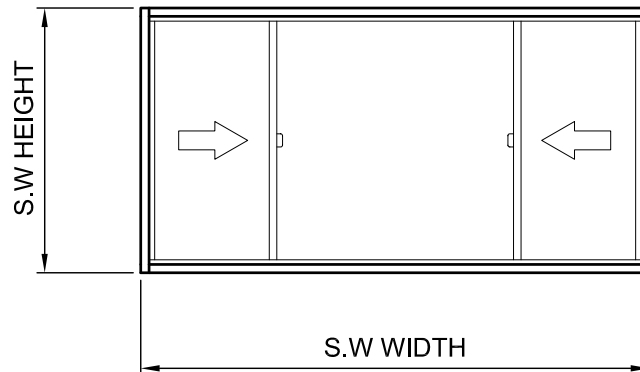
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 89mm	1	1
	VM34	SILL	S.W WIDTH - 89mm	1	1
	AS1C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 135mm	2	0
	VM4	INTERLOCK STILE	S.W HEIGHT - 137mm	2	2
	VM6	PLAIN STILE	S.W HEIGHT - 137mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM39	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 135mm	0	2
	VM2	DG RAIL	S.W WIDTH/2 - 40mm	2	2
	VM2	DG RAIL	S.W WIDTH/4 - 96mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 95mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 74mm	0	4
DOUBLE GLAZE SIZES 1 OFF S.W HEIGHT - 115mm x S.W WIDTH/4 - 18mm DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT - 115mm x S.W WIDTH/2 - 74mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX DG FRAMING, STD SILL**



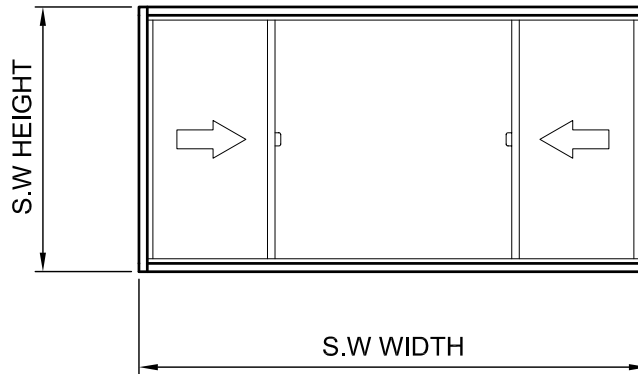
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 100mm	1	1
	VM34	SILL	S.W WIDTH - 100mm	1	1
	SYN-11	JAMB	S.W HEIGHT	2	2
	VM27	DG SASH RECEIVER	S.W HEIGHT - 135mm	2	2
	VM4	DG INTERLOCK STILE	S.W HEIGHT - 137mm	2	2
	VM6	DG PLAIN STILE	S.W HEIGHT - 137mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM39	INTERLOCK	S.W HEIGHT - 135mm	1	1
	VM2	DG RAIL	S.W WIDTH/2 - 40mm	2	2
	VM2	DG RAIL	S.W WIDTH/4 - 100mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 95mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 77mm	0	4
DOUBLE GLAZE SIZES 1 OFF S.W HEIGHT - 115mm x S.W WIDTH/2 - 18mm DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT - 115mm x S.W WIDTH/4 - 78mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX 76mm S/GLAZED, HIGH SILL**



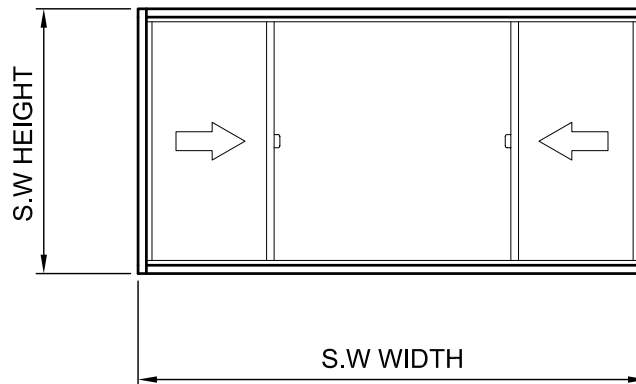
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM8	HEAD	S.W WIDTH - 70mm	1	1
	VM53	HIGH SILL	S.W WIDTH - 70mm	1	1
	AS51C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 132mm	2	0
	VM3	INTERLOCK STILE	S.W HEIGHT - 134mm	4	4
	VM5	PLAIN STILE	S.W HEIGHT - 134mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 132mm	2	2
	VM39	INTERLOCK	S.W HEIGHT - 132mm	2	2
	VM50	THRESHOLD	S.W WIDTH/4 - 55mm	2	0
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 132mm	0	2
	VM1	RAIL	S.W WIDTH/2 - 40mm	2	2
	VM1	RAIL	S.W WIDTH/4 - 87mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 92mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 65mm	0	4
SINGLE GLAZE SIZES 1 OFF S.W HEIGHT- 114mm x S.W WIDTH/2 - 20mm SINGLE GLAZE SIZES 2 OFF S.W HEIGHT- 114mm x S.W WIDTH/4 - 67mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX 76mm D/GLAZED, HIGH SILL**



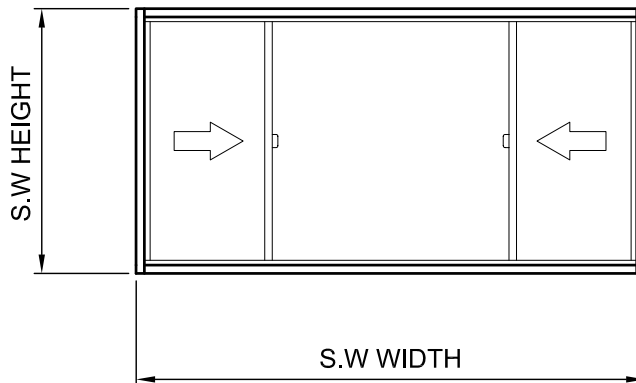
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM8	HEAD	S.W WIDTH - 70mm	1	1
	VM53	HIGH SILL	S.W WIDTH - 70mm	1	1
	AS51C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 132mm	2	0
	VM4	DG INTERLOCK STILE	S.W HEIGHT - 134mm	4	4
	VM6	DG PLAIN STILE	S.W HEIGHT - 134mm	2	2
	VM9 or VM29 or or VM39	INTERLOCK	S.W HEIGHT - 132mm	2	2
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 132mm	0	2
	VM50	THRESHOLD	S.W WIDTH/4 - 55mm	2	0
	VM2	RAIL	S.W WIDTH/2 - 40mm	2	2
	VM2	RAIL	S.W WIDTH/4 - 87mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 92mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 65mm	0	4
DOUBLE GLAZE SIZES 1 OFF S.W HEIGHT -112mm x S.W WIDTH/2 - 18mm DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT -112mm x S.W WIDTH/4 - 65mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX 101.6mm S/GLAZED, HIGH SILL**



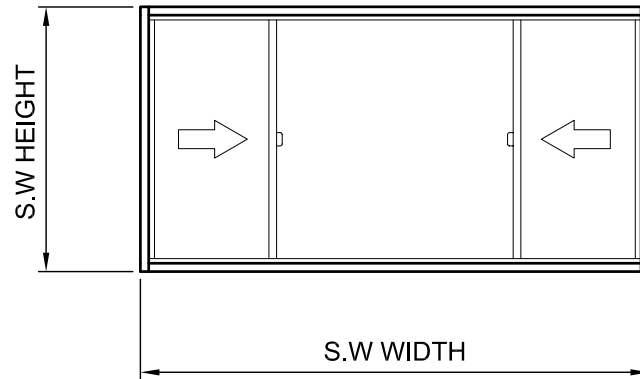
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 89mm	1	1
	VM54	HIGH SILL	S.W WIDTH - 89mm	1	1
	AS1C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 141mm	2	0
	VM3	INTERLOCK STILE	S.W HEIGHT - 143mm	2	2
	VM5	PLAIN STILE	S.W HEIGHT - 143mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 141mm	1	1
	VM39	INTERLOCK	S.W HEIGHT - 141mm	1	1
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 141mm	0	2
	VM50	THRESHOLD	S.W WIDTH/4 - 65mm	2	0
	VM1	RAIL	S.W WIDTH/2 - 40mm	2	2
	VM1	RAIL	S.W WIDTH/4 - 96mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 101mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 74mm	0	4
SINGLE GLAZE SIZES 1 OFF S.W HEIGHT- 123mm x S.W WIDTH/2 - 20mm SINGLE GLAZE SIZES 2 OFF S.W HEIGHT- 123mm x S.W WIDTH/4 - 76mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX 101.6mm D/GLAZED, HIGH SILL**



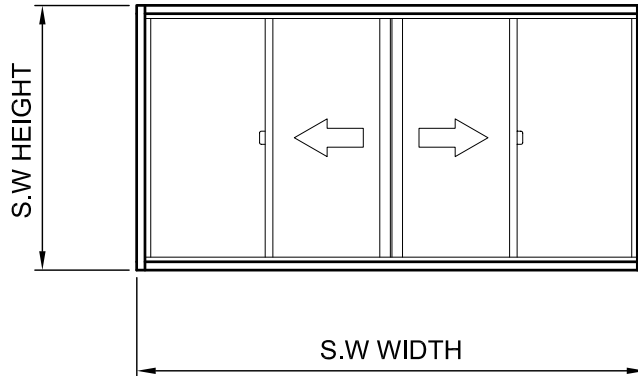
CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 89mm	1	1
	VM54	HIGH SILL	S.W WIDTH - 89mm	1	1
	AS1C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 141mm	2	0
	VM4	DG INTERLOCK STILE	S.W HEIGHT - 143mm	2	2
	VM6	DG PLAIN STILE	S.W HEIGHT - 143mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 141mm	1	1
	VM39	INTERLOCK	S.W HEIGHT - 141mm	1	1
	VM12	SCREEN/SASH RECEIVER	S.W HEIGHT - 141mm	0	2
	VM50	THRESHOLD	S.W WIDTH/4 - 65mm	2	0
	VM2	DG RAIL	S.W WIDTH/2 - 40mm	2	2
	VM2	DG RAIL	S.W WIDTH/4 - 96mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 101mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 74mm	0	4
DOUBLE GLAZE SIZES 1 OFF S.W HEIGHT - 121mm x S.W WIDTH/2 - 18mm DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT - 121mm x S.W WIDTH/4 - 74mm				NO SCREEN	SCREEN

**CUTTING FORMULA XOX DG FRAMING, HIGH SILL**



CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM28	HEAD	S.W WIDTH - 100mm	1	1
	VM54	HIGH SILL	S.W WIDTH - 89mm	1	1
	SYN-11	JAMB	S.W HEIGHT	2	2
	VM27	DG SASH RECEIVER	S.W HEIGHT - 141mm	2	2
	VM4	DG INTERLOCK STILE	S.W HEIGHT - 143mm	2	2
	VM6	DG PLAIN STILE	S.W HEIGHT - 143mm	2	2
	VM9 or VM29 or	INTERLOCK	S.W HEIGHT - 141mm	1	1
	VM39	INTERLOCK	S.W HEIGHT - 141mm	1	1
	VM50	THRESHOLD	S.W WIDTH/4 - 72mm	2	0
	VM2	DG RAIL	S.W WIDTH/2 - 40mm	2	2
	VM2	DG RAIL	S.W WIDTH/4 - 100mm	4	4
	FS2	FLYSCREEN	S.W HEIGHT - 101mm	0	4
	FS2	FLYSCREEN	S.W WIDTH/4 - 77mm	0	4
DOUBLE GLAZE SIZES 1 OFF S.W HEIGHT - 121mm x S.W WIDTH/2 - 18mm DOUBLE GLAZE SIZES 2 OFF S.W HEIGHT - 121mm x S.W WIDTH/4 - 78mm				NO SCREEN	SCREEN

**CUTTING FORMULA OXXO 76mm S/GLAZED, HIGH SILL**



CUTTING FORMULA					
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY 1	QTY 2
	VM8	HEAD	S.W WIDTH - 70mm	1	1
	VM53	HIGH SILL	S.W WIDTH - 70mm	1	1
	AS51C	JAMB	S.W HEIGHT	2	2
	VM11	SASH RECEIVER	S.W HEIGHT - 132mm	2	2
	VM3	INTERLOCK STILE	S.W HEIGHT - 134mm	4	4
	VM5	PLAIN STILE	S.W HEIGHT - 134mm	4	4
	VM9 or VM29 or VM39	INTERLOCK	S.W HEIGHT - 132mm	2	2
	VM17	OXXO ADAPTOR	S.W HEIGHT - 92mm	1	1
	VM50	THRESHOLD	S.W WIDTH/2 - 198mm	1	0
	VM1	RAIL	S.W WIDTH/4 - 68.5mm	8	8
	FS2	FLYSCREEN	S.W HEIGHT - 92mm	0	2
	FS2	FLYSCREEN	S.W WIDTH/2 - 78mm	0	2
SINGLE GLAZE SIZES 4 OFF S.W HEIGHT- 114mm x S.W WIDTH/4 - 48.5mm				NO SCREEN	SCREEN



# ALSPEC ALUMINIUM SYSTEMS

## TECHNICAL MANUAL

### VIEW-MAX double hung

#### Section 1.0

#### TECHNICAL MANUAL RELEASE NOTES

This page is intended to record all changes to the **VIEW-MAX DOUBLE HUNG** 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 / 03 / 2008	<i>Technical manual initial release</i>	~	~
28 / 05 / 2008	<i>Part number reference corrected in the example</i>	3.2.4	3.2.4
28 / 05 / 2008	<i>Glass height cut size corrected &amp; rail number corrected</i>	3.5.3	3.5.3
28 / 05 / 2008	<i>Glass height cut size corrected</i>	3.5.4	3.5.4
28 / 05 / 2008	<i>Glass height cut size corrected</i>	3.5.5	3.5.5
31 / 07 / 2008	<i>Full re-issue with new profiles and format</i>	All	All
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>Test report page updated</i>	2.3	2.3
01 / 02 / 2009	<i>Hardware components pages amended</i>	3.2.1 to 3.2.3	3.2.1 to 3.2.3
01 / 02 / 2009	<i>Max sash height amended</i>	3.2.4	3.2.4
01 / 02 / 2009	<i>Page number amended</i>	3.2.5	3.2.5
01 / 02 / 2009	<i>Mohair deleted</i>	3.4.1, 3.4.3, 3.4.5, 3.4.7, 3.4.9, 3.4.12	3.4.1, 3.4.3, 3.4.5, 3.4.7, 3.4.9, 3.4.12
01 / 02 / 2009	<i>Jamb preparation amended</i>	3.6.1	3.6.1
01 / 02 / 2009	<i>Diameter symbols amended</i>	3.6.2 & 3.6.3	3.6.2 & 3.6.3
01 / 02 / 2009	<i>Sash stop note amended</i>	3.6.9	3.6.9
01 / 02 / 2009	<i>Jamb assembly amended</i>	3.6.10	3.6.10
01 / 02 / 2009	<i>Installation steps amended</i>	3.6.15 to 3.6.18	3.6.15 to 3.6.18
01 / 07 / 2009	<i>Contents page 1 amended</i>	~	~
01 / 07 / 2009	<i>Technical Manual Release Notes Amended</i>	1.0	1.0
01 / 07 / 2009	<i>New page added</i>	~	1.1
01 / 07 / 2009	<i>Window Stop notes and dimension added</i>	3.6.1	3.6.1

# ALSPEC ALUMINIUM SYSTEMS

## TECHNICAL MANUAL

### VIEW-MAX double hung

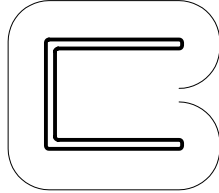
Section 1.0

#### TECHNICAL MANUAL RELEASE NOTES Cont.

DATE	AMENDMENT DESCRIPTION	REMOVE PAGE	INSERT NEW PAGE
01 / 07 / 2009	<i>Window Stop notes added</i>	3.6.8	3.6.8
01 / 07 / 2009	<i>Window Stop note amended</i>	3.6.9	3.6.9
01 / 07 / 2009	<i>Step 1 notes amended</i>	3.6.14	3.6.14
01 / 08 / 2009	<i>Technical manual release notes revised</i>	1.1	1.1
01 / 08 / 2009	<i>Flyscreen channel amended</i>	3.1.7	3.1.7
01 / 08 / 2009	<i>Flyscreen details amended</i>	3.4.2, 3.4.4, 3.4.6 3.4.8, 3.4.10	3.4.2, 3.4.4, 3.4.6 3.4.8, 3.4.10
01 / 08 / 2009	<i>Flyscreen formulas amended</i>	3.5.1 - 3.5.5	3.5.1 - 3.5.5
01 / 08 / 2009	<i>Flyscreen installation details amended</i>	3.6.22	3.6.22

**EXTRUSIONS**

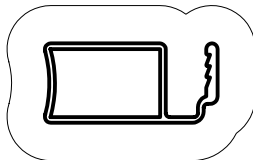
VISIBLE SURFACE



L3455  
FLYSCREEN CHANNEL

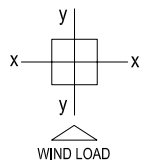
Mass = 0.158 kg/m  
Anod Per = 100  
Paint Per = 100

VISIBLE SURFACE



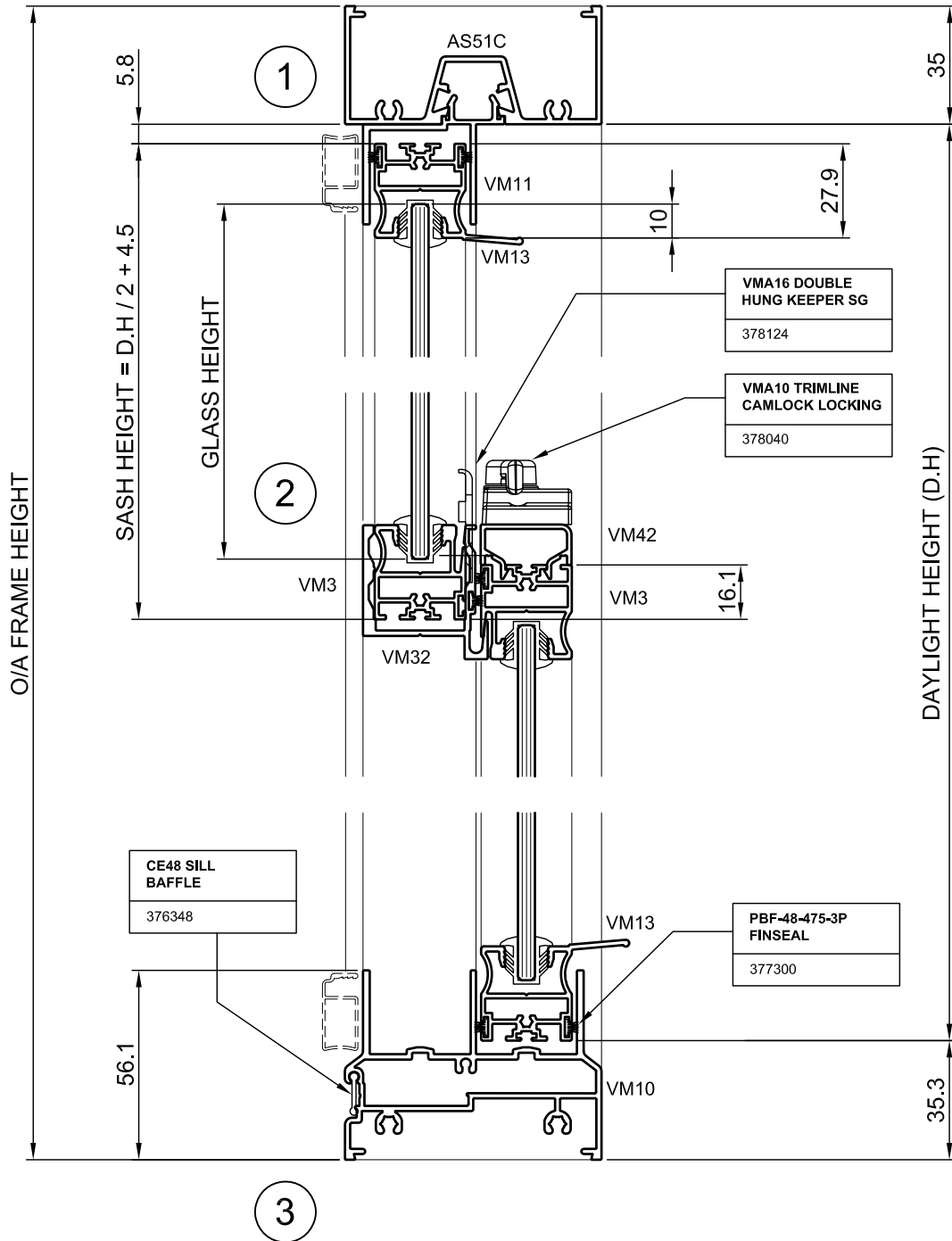
FS2  
FLYSCREEN

Mass = 0.158 kg/m  
Anod Per = 100  
Paint Per = 100

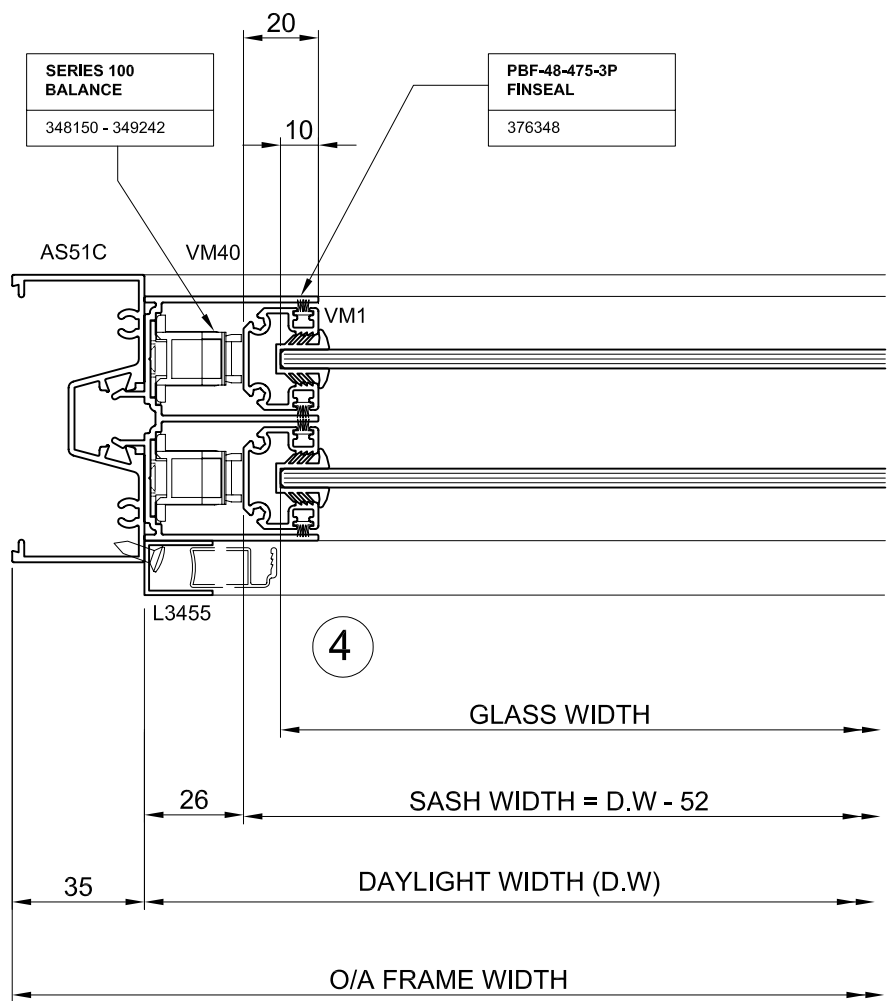




**VERTICAL DETAIL OF 76mm FRAMING**

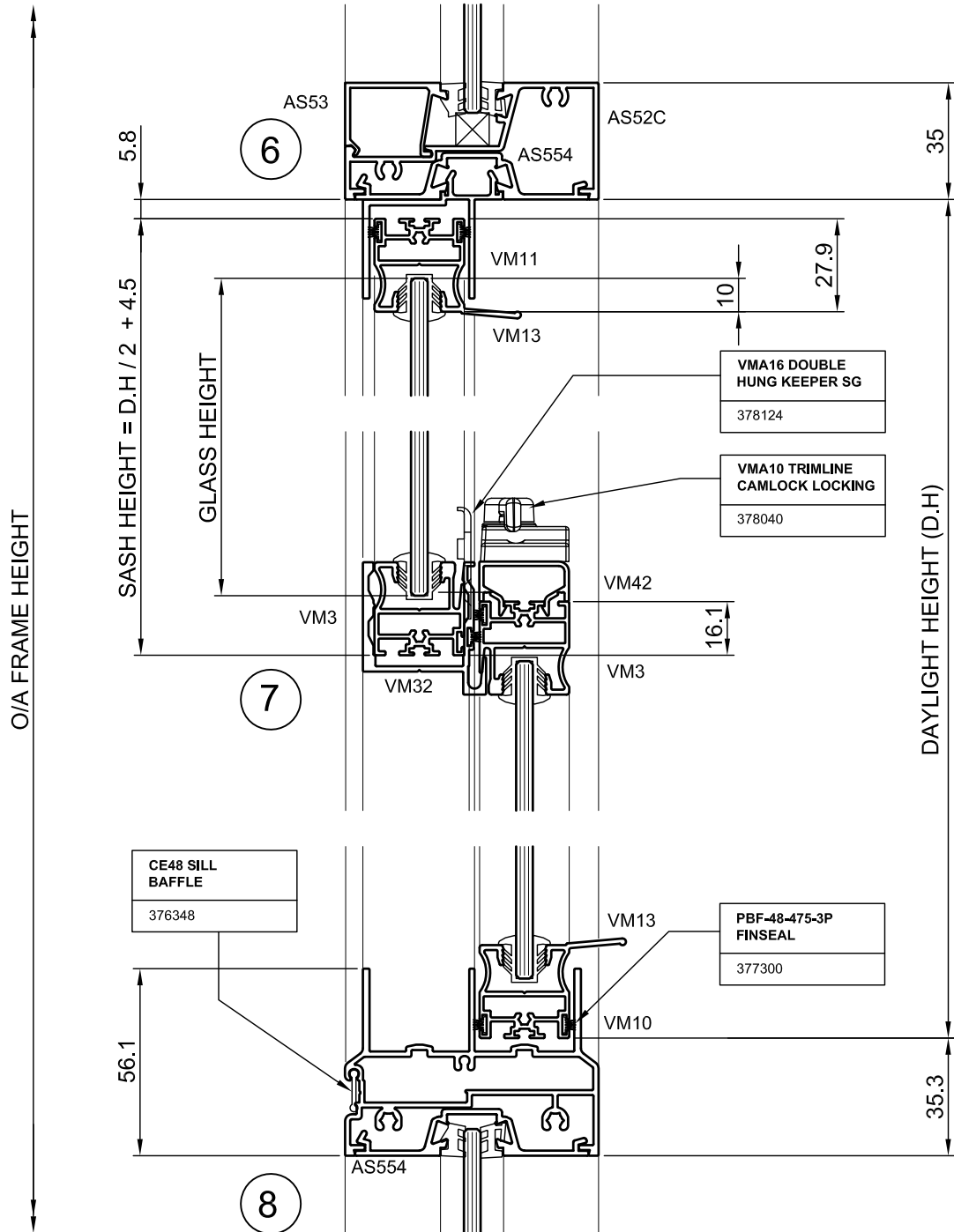


**HORIZONTAL DETAIL OF 76mm FRAMING**

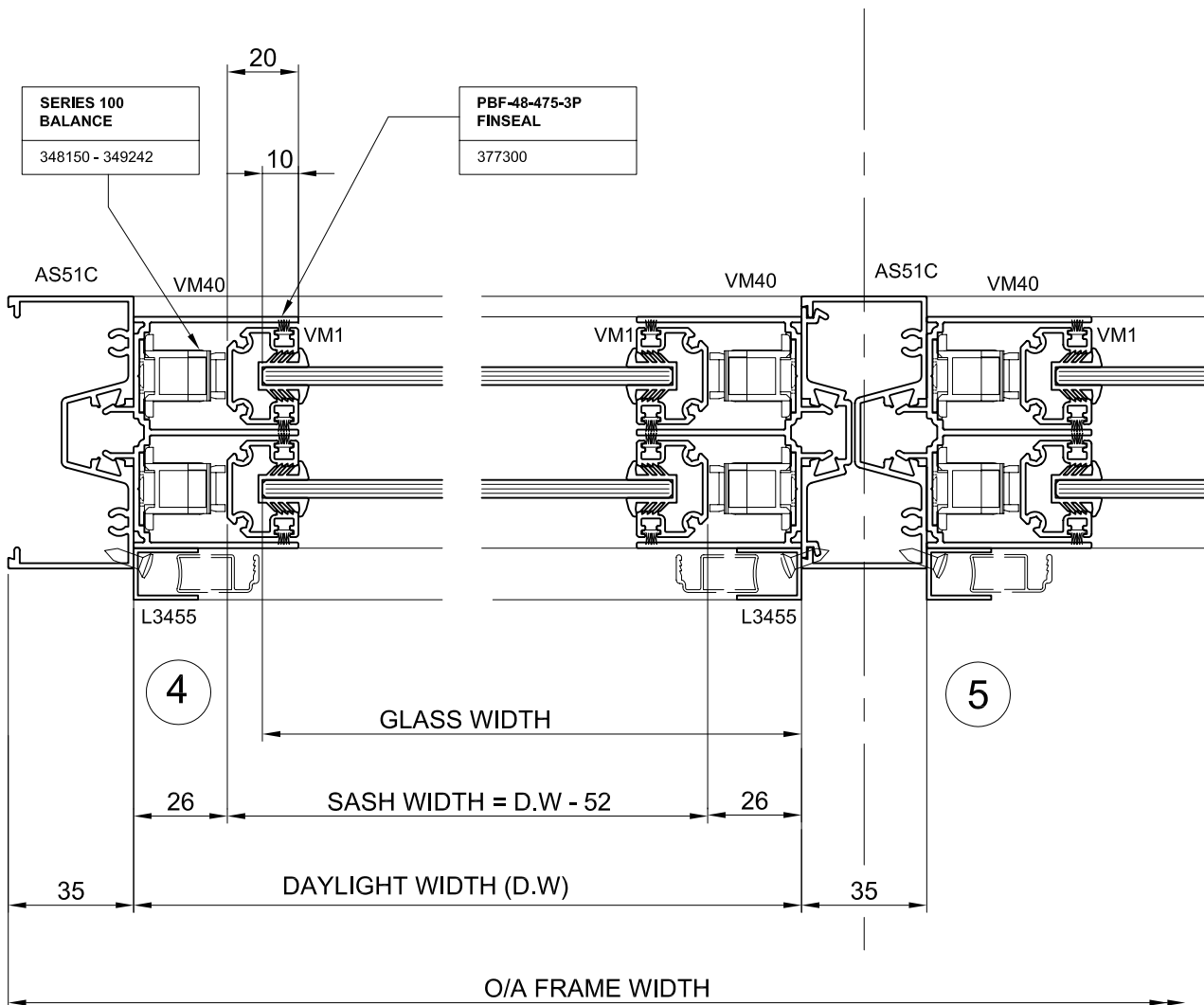


HALF SCALE

**VERTICAL DETAIL OF 76mm FRAMING OVER/UNDER LIGHT**



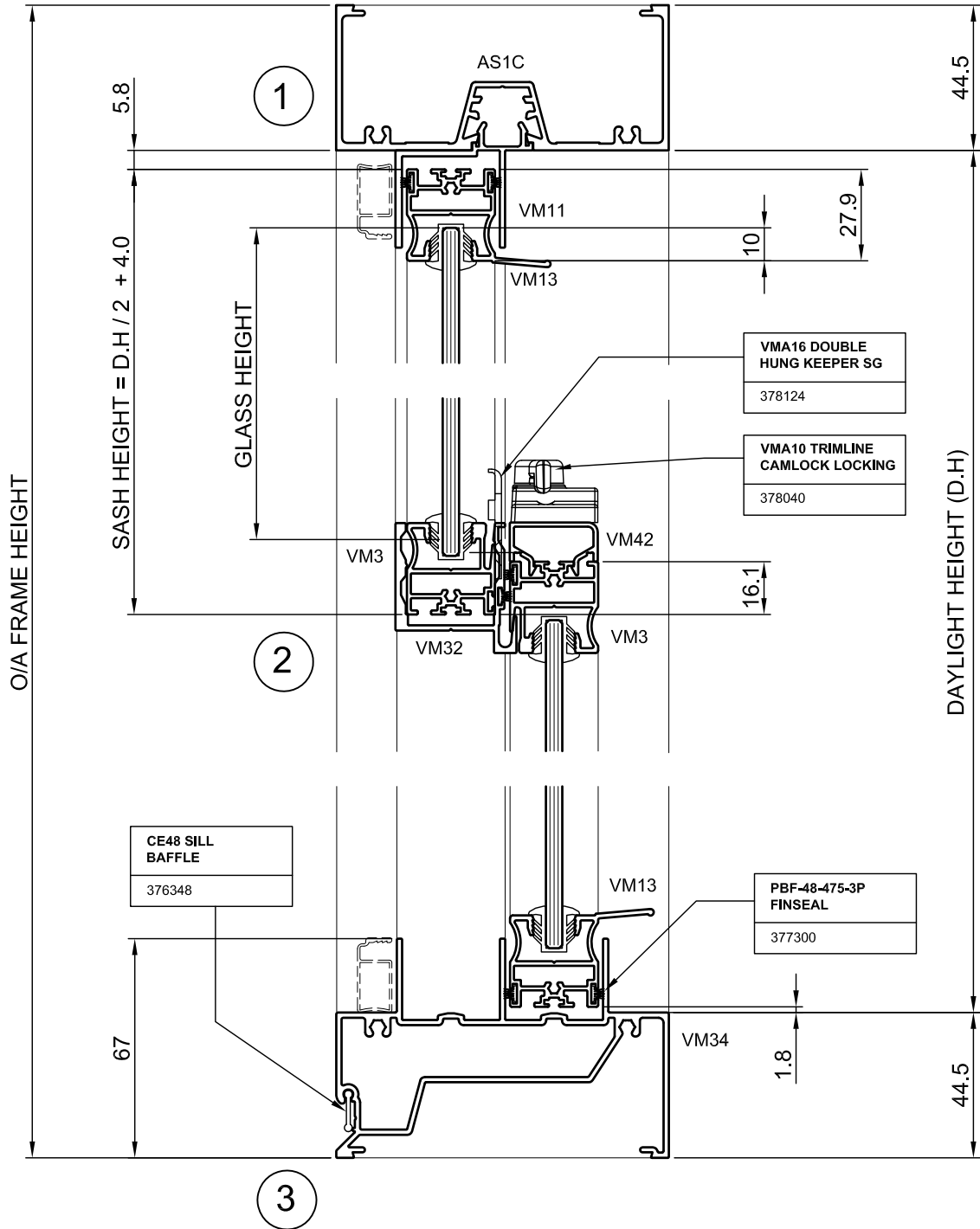
**HORIZONTAL MULLION DETAIL OF 76mm FRAMING**



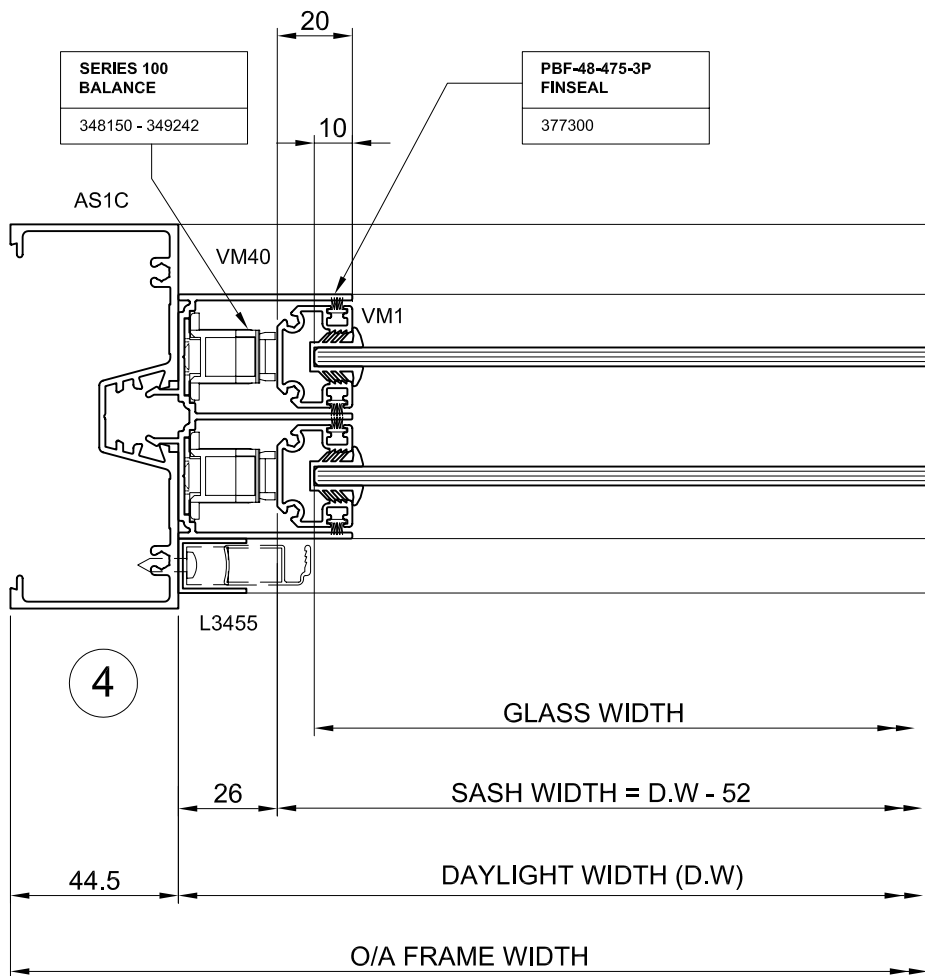
HALF SCALE



**VERTICAL DETAIL OF 101.6mm FRAMING**

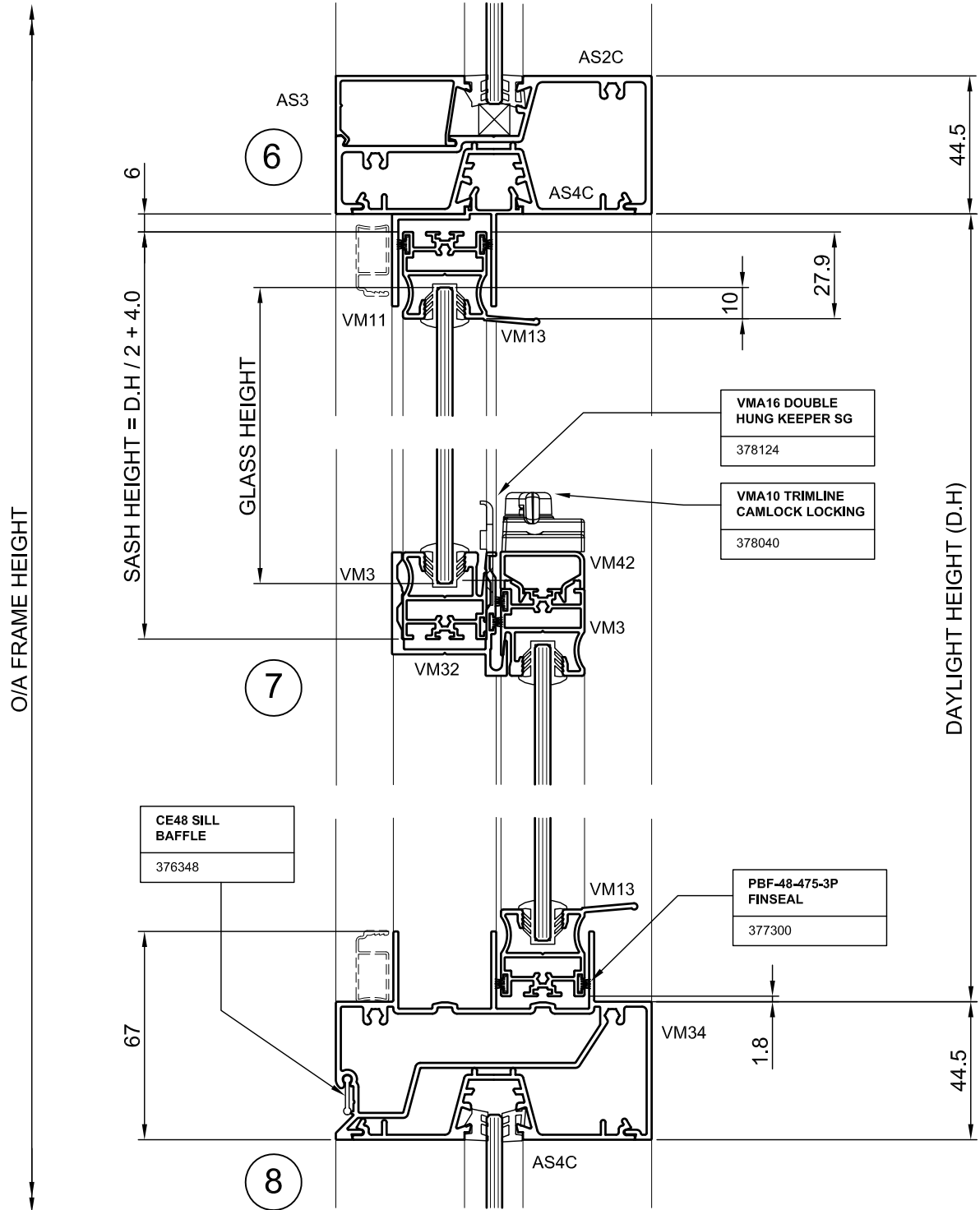


**HORIZONTAL DETAIL OF 101.6mm FRAMING**

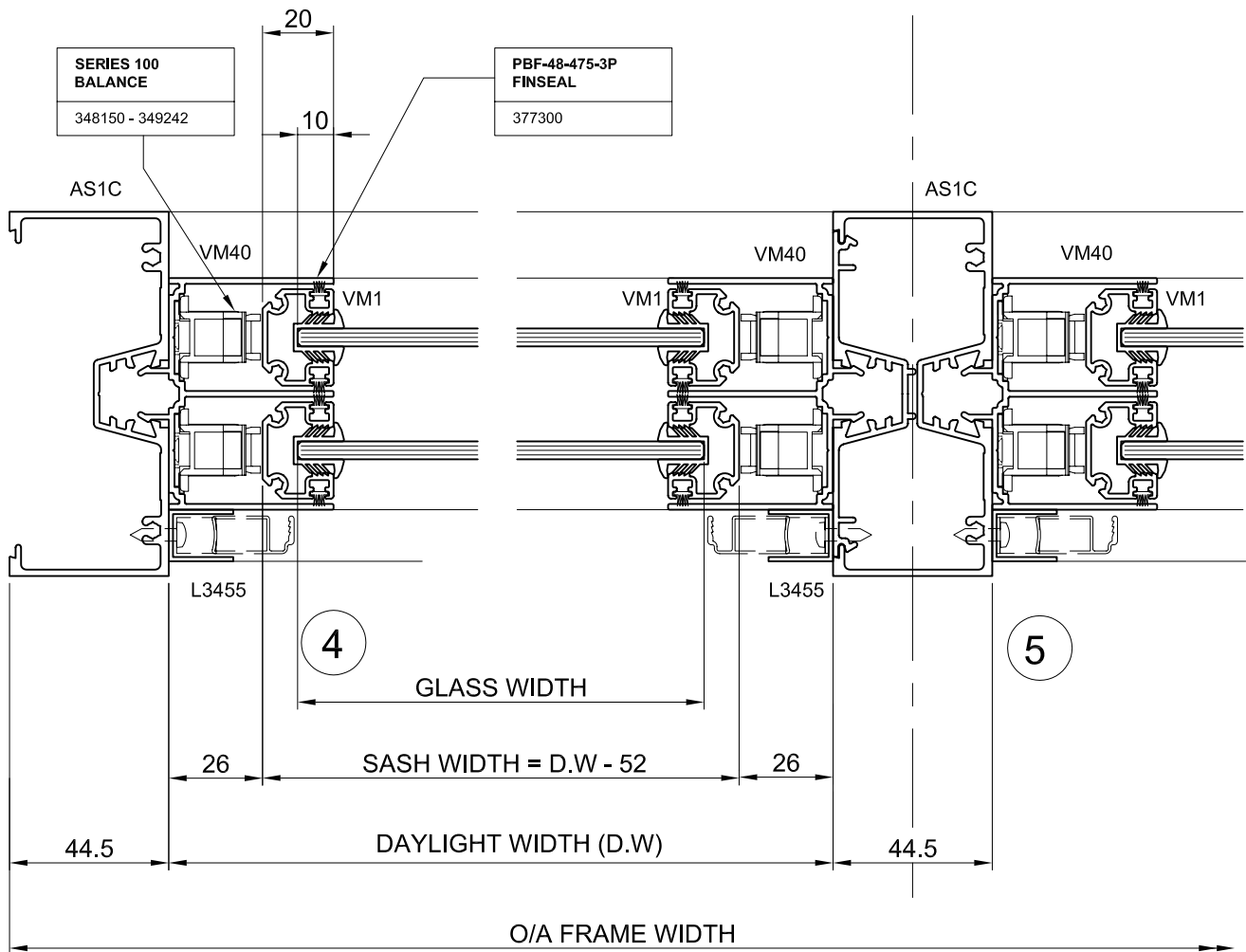


HALF SCALE

**VERTICAL DETAIL OF 101.6mm FRAMING OVER/UNDER LIGHT**

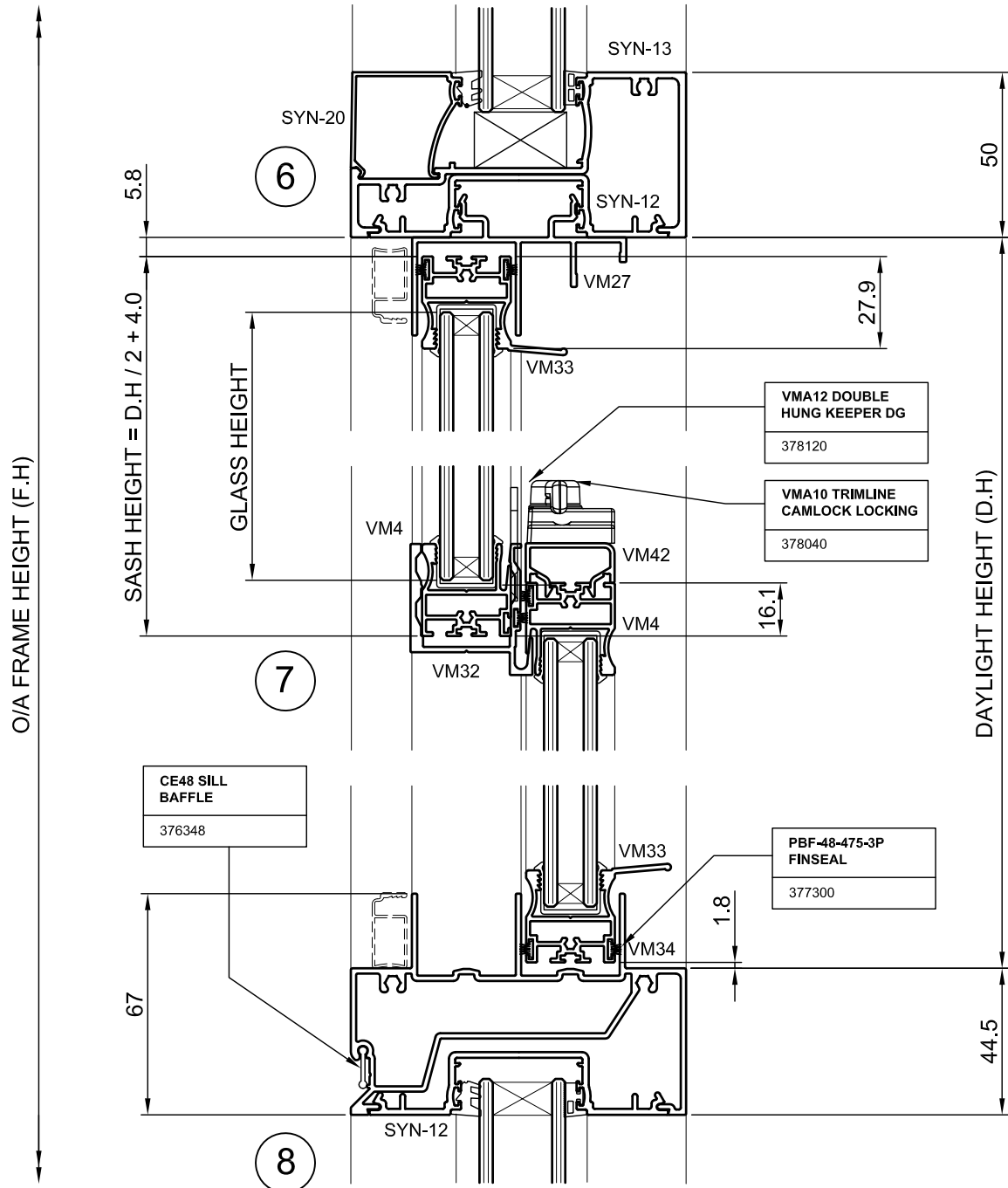


**HORIZONTAL MULLION DETAIL OF 101.6mm FRAMING**

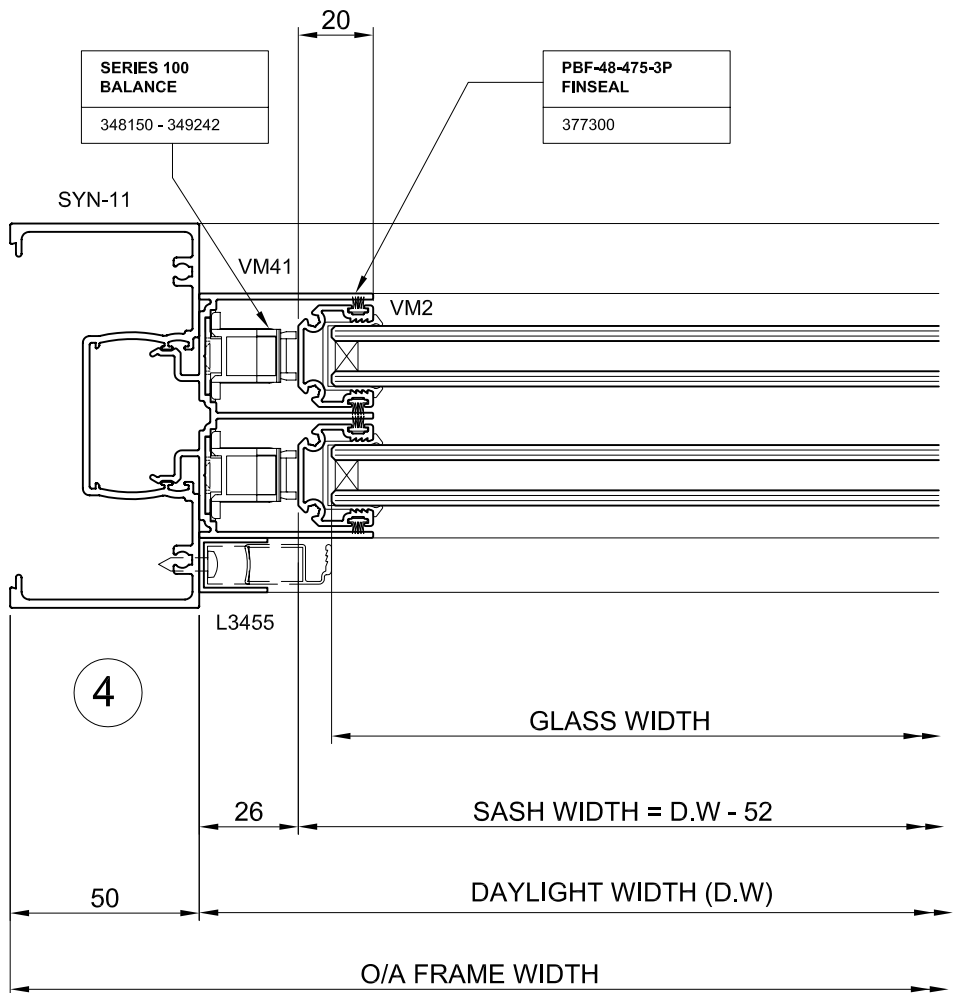


HALF SCALE

**VERTICAL DG DETAIL OF 101.6mm FRAMING OVER/UNDER LIGHT**

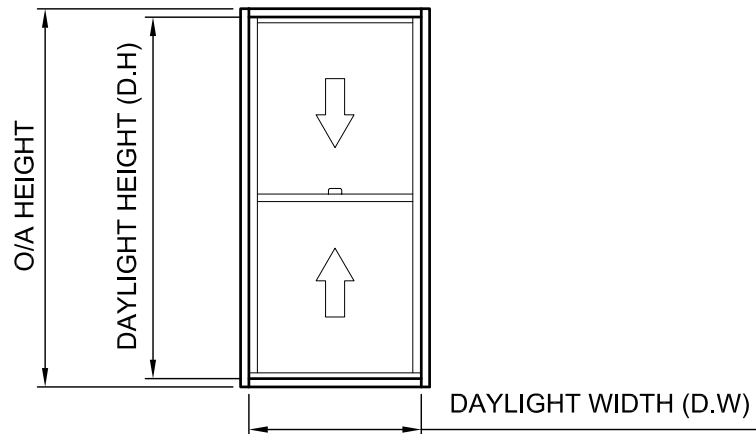


**HORIZONTAL DG DETAIL OF 101.6mm FRAMING**



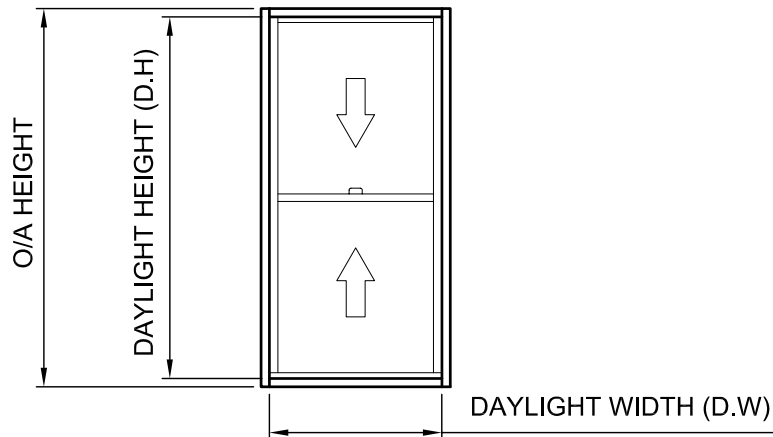
HALF SCALE

**CUTTING FORMULA 76mm FRAMING SINGLE GLAZED**



CUTTING FORMULA				
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AS51C	HEAD	D.W	1
	VM10	SILL	D.W	1
	AS51C	JAMB	O/A HEIGHT	2
	VM11	SASH RECEIVER	D.W - 92mm	1
	VM3	INTERLOCK STILE	D.W - 92mm	2
	VM13	PLAIN RAIL	D.W - 92mm	2
	VM32	INTERLOCK	D.W - 94mm	1
	VM42	CAPPING	D.W - 70mm	1
	VM40	SG JAMB ADAPTOR	D.H - 21mm	2
	VM1	RAIL	D.H /2 - 51.5mm	4
	L3455	FLYSCREEN CHANNEL	D.H + 3mm	2
	FS2	FLYSCREEN	D.H	2
	FS2	FLYSCREEN	D.W - 24mm	2
	AS8C	POCKET INFILL	46mm	2
	AS8C	POCKET INFILL	35mm	2
	AS8C	POCKET INFILL	56mm	2
SINGLE GLAZED SIZE (2 OFF) D.H /2 - 31.5mm D.W - 72mm				

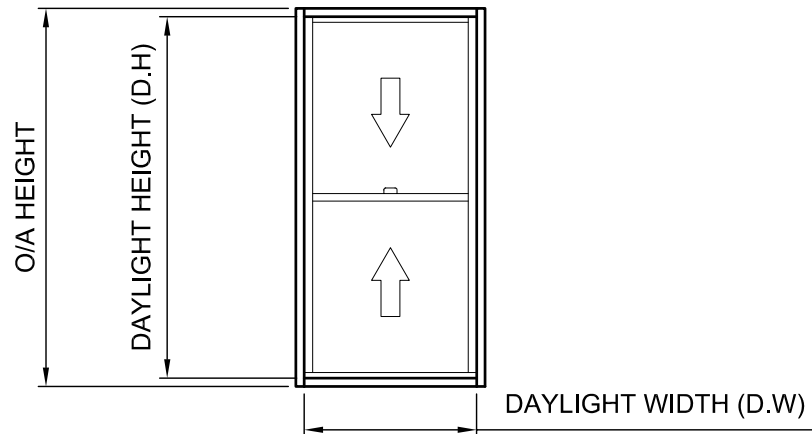
**CUTTING FORMULA 76mm FRAMING DOUBLE GLAZED**



CUTTING FORMULA				
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AS51C	HEAD	D.W	1
	VM10	SILL	D.W	1
	AS51C	JAMB	O/A HEIGHT	2
	VM11	SASH RECEIVER	D.W - 92mm	1
	VM4	DG INTERLOCK STILE	D.W - 92mm	2
	VM33	DG PLAIN RAIL	D.W - 92mm	2
	VM32	INTERLOCK	D.W - 94mm	1
	VM42	CAPPING	D.W - 70mm	1
	VM40	SG JAMB ADAPTOR	D.H - 21mm	2
	VM2	RAIL	D.H / 2 - 51.5mm	4
	L3455	FLYSCREEN CHANNEL	D.H + 3mm	2
	FS2	FLYSCREEN	D.H	2
	FS2	FLYSCREEN	D.W - 24mm	2
	AS8C	POCKET INFILL	46mm	2
	AS8C	POCKET INFILL	35mm	2
	AS8C	POCKET INFILL	56mm	2
DOUBLE GLAZED SIZE (2 OFF) D.H / 2 - 29.5mm D.W - 70mm				

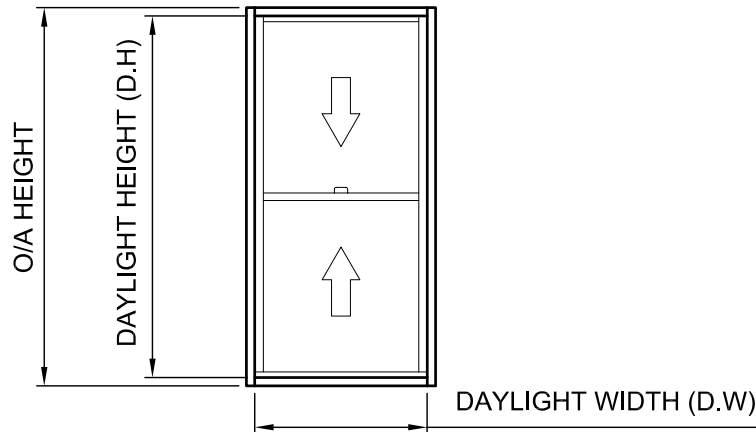


**CUTTING FORMULA 101.6mm FRAMING SINGLE GLAZED**



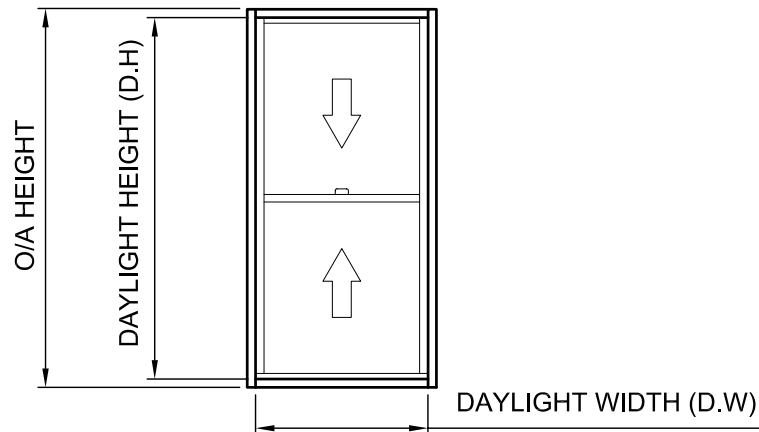
CUTTING FORMULA				
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AS1C	HEAD	D.W	1
	VM34	SILL	D.W	1
	AS1C	JAMB	O/A HEIGHT	2
	VM11	SASH RECEIVER	D.W - 92mm	1
	VM3	INTERLOCK STILE	D.W - 92mm	2
	VM13	PLAIN RAIL	D.W - 92mm	2
	VM32	INTERLOCK	D.W - 94mm	1
	VM42	CAPPING	D.W - 70mm	1
	VM40	SG JAMB ADAPTOR	D.H - 22.5mm	2
	VM1	RAIL	D.H / 2 - 52mm	4
	L3455	FLYSCREEN CHANNEL	D.H + 3mm	2
	FS2	FLYSCREEN	D.H - 3mm	2
	FS2	FLYSCREEN	D.W - 24mm	2
	AS8	POCKET INFILL	46mm	2
	AS8	POCKET INFILL	44mm	2
	AS8	POCKET INFILL	67mm	2
SINGLE GLAZED SIZE (2 OFF) D.H / 2 - 32mm D.W - 72mm				

**CUTTING FORMULA 101.6mm FRAMING DOUBLE GLAZED**



CUTTING FORMULA				
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AS1C	HEAD	D.W	1
	VM34	SILL	D.W	1
	AS1C	JAMB	O/A HEIGHT	2
	VM11	SASH RECEIVER	D.W - 92mm	1
	VM3	DG INTERLOCK STILE	D.W - 92mm	2
	VM13	DG PLAIN RAIL	D.W - 92mm	2
	VM32	INTERLOCK	D.W - 94mm	1
	VM42	CAPPING	D.W - 70mm	1
	VM40	SG JAMB ADAPTOR	D.H - 22.5mm	2
	VM2	RAIL	D.H / 2 - 52mm	4
	L3455	FLYSCREEN CHANNEL	D.H + 3mm	2
	FS2	FLYSCREEN	D.H - 3mm	2
	FS2	FLYSCREEN	D.W - 24mm	2
	AS8	POCKET INFILL	46mm	2
	AS8	POCKET INFILL	44mm	2
	AS8	POCKET INFILL	67mm	2
DOUBLE GLAZED SIZE (2 OFF)D.H / 2 - 30mm D.W - 70mm				

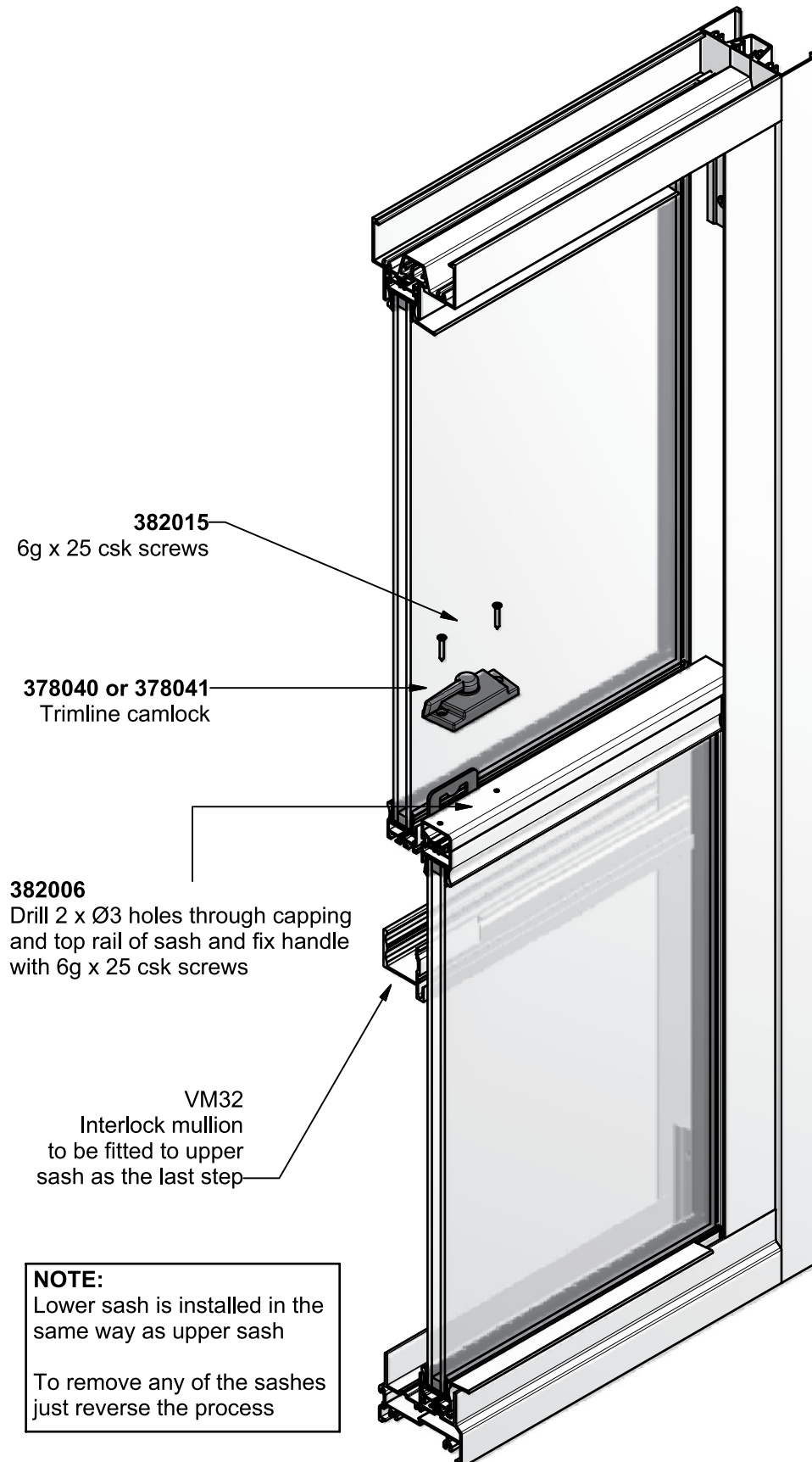
**CUTTING FORMULA DG FRAMING**



CUTTING FORMULA				
PROFILE	SECTION No.	DESCRIPTION	CUTTING FORMULA	QTY
	AS281C	HEAD	D.W	1
	VM34	SILL	D.W	1
	AS281C	JAMB	O/A HEIGHT	2
	VM27	DG SASH RECEIVER	D.W - 92mm	1
	VM4	DG INTERLOCK STILE	D.W - 92mm	2
	VM33	DG PLAIN RAIL	D.W - 92mm	2
	VM32	INTERLOCK	D.W - 94mm	1
	VM42	CAPPING	D.W - 70mm	1
	VM41	DG JAMB ADAPTOR	D.H - 22.5mm	2
	VM2	DG RAIL	D.H / 2 - 52mm	4
	L3455	FLYSCREEN CHANNEL	D.H + 3mm	2
	FS2	FLYSCREEN	D.H - 3mm	2
	FS2	FLYSCREEN	D.W - 24mm	2
	SYN-21	POCKET INFILL	46mm	2
	SYN-21	POCKET INFILL	50mm	2
	SYN-21	POCKET INFILL	67mm	2
DOUBLE GLAZED SIZE (2 OFF) D.H / 2 - 30mm D.W - 70mm				



**UPPER SASH INSTALLATION STEP 8**



**SCREEN INSTALLATION**

