



Hastings

Front Glazed Framing



Hastings 550 Front Glazed Plant On

Technical Manual
February 2024 | ISSUE D

alspec[®]
EVERYTHING ALUMINIUM
& HARDWARE

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This page is intended to record all changes to the **HASTINGS 550 FRONT GLAZED PLANT ON** technical manual pages.

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

ISSUE	DATE	Amendment Description	Refer to Tech Memo #
	09/2008	Technical Manual Initial Release	
A	02/2009	Technical Manual Updated	
B	05/2017	Technical Manual Updated For Re-Release	
C	04/2021	Technical Manual Updated For Re-Release	453
D	11/2023	Added OT23-202, OT23-205, OT23-204 and OT23-206 Test Summary to page 4.1 - 4.4	573

ALUMINIUM

Aluminium frames should be manufactured using Alspec's HASTINGS 550 FRONT GLAZED PLANT ON system.

Refer to wind load table for maximum panel heights and widths.

GLAZING

Standard SG Panel: 6mm - 18mm

Standard DG Panel: 24mm - 32mm

Glazing wedges shall be Alspec's wedges and channels for HASTINGS 550 FRONT GLAZED PLANT ON system to suit standard and captive glazing options, refer to glazing pages in Alspec Technical Manual.

HARDWARE

All hardware as per Alspec Technical Manual

FINISHES

- All powder coated material shall be produced to AS3715.
- All anodised material shall be produced to AS1231

TESTING

Product shall have a test report to show compliance to AS2047.

All products are available from Alspec (A.B.N. 63 001 252 259) as detailed in the "Alspec" catalogue or on the Internet at www.alspec.com.au. All such framing is to be constructed, assembled and fixed to meet the requirement of AS2047 (windows in buildings), AS1170 (loading code). All glass, glazing rubbers, seals and gaskets shall be applied in accordance with the requirements of AS1288 (glass in buildings - selection and installation) or AS4666 (Insulated Glass Units).

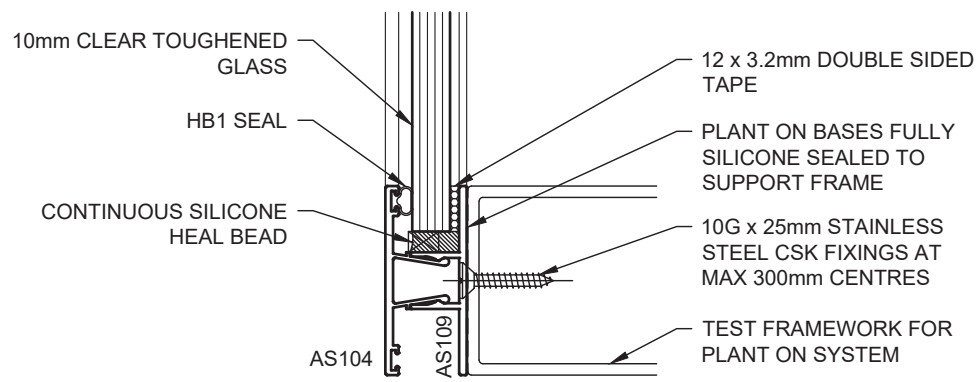
Fabricators of the HASTINGS 550 FRONT GLAZED PLANT ON system should seek certification by a consultant structural engineer as to the framing being acceptable for the design wind pressure and deflection characteristics required of the site.



4. Test Summary

AS2047 - Single Glazed Window Configuration

TEST REPORT:	OT23-202
SYSTEM CONFIGURATION	HASTINGS 550 F/F FRONT GLAZED, SINGLE GLAZED FRAMING
TEST SAMPLE SIZE	2.432m high x 2.432m wide
ULTIMATE LOAD	+/- 8.0 kPa
WATER PENETRATION	1008 Pa
AIR INFILTRATION @ 75Pa	+ 0.05 L/m/s ² - 0.05 L/m/s ²

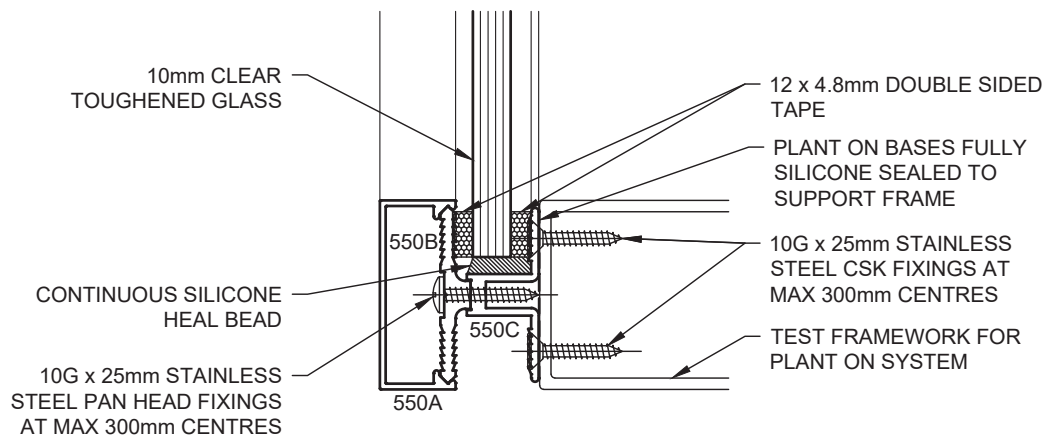


DISCLAIMER:
Please note that the test results shown above reflect specific configurations of a system and are representative only. If a specific high wind load or a different configuration (i.e. changes to frames, transoms, mullions) is required on a project please discuss with Alspec prior to commencement.

4. Test Summary

AS2047 - Single Glazed Window Configuration

TEST REPORT:	OT23-205
SYSTEM CONFIGURATION	HASTINGS 550 F/F FRONT GLAZED, SINGLE GLAZED FRAMING
TEST SAMPLE SIZE	2.432m high x 2.432m wide
ULTIMATE LOAD	+/- 8.003 kPa
WATER PENETRATION	1002 Pa
AIR INFILTRATION @ 75Pa	+ 0.03 L/m/s ² - 0.03 L/m/s ²



DISCLAIMER:

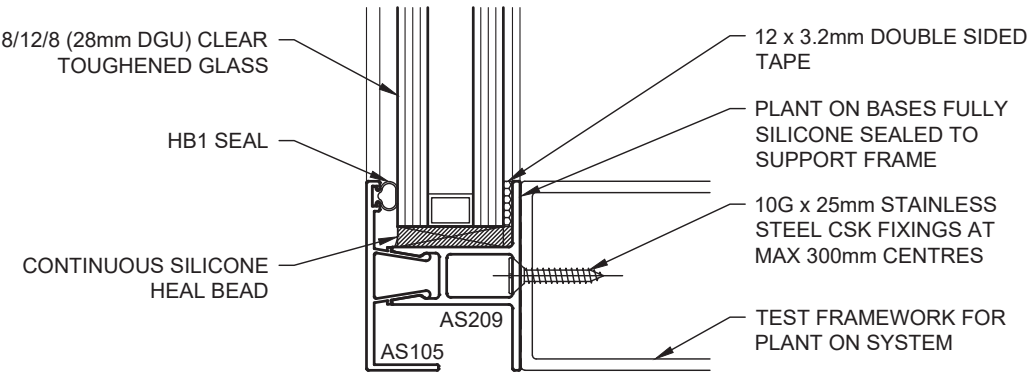
Please note that the test results shown above reflect specific configurations of a system and are representative only. If a specific high wind load or a different configuration (i.e. changes to frames, transoms, mullions) is required on a project please discuss with Alspec prior to commencement.



4. Test Summary

AS2047 - Double Glazed Window Configuration

TEST REPORT:	OT23-204
SYSTEM CONFIGURATION	HASTINGS 550 F/F FRONT GLAZED, DOUBLE GLAZED FRAMING
TEST SAMPLE SIZE	2.432m high x 2.432m wide
ULTIMATE LOAD	+/- 8.003 kPa
WATER PENETRATION	1002 Pa
AIR INFILTRATION @ 75Pa	+ 0.03 L/m/s ² - 0.02 L/m/s ²

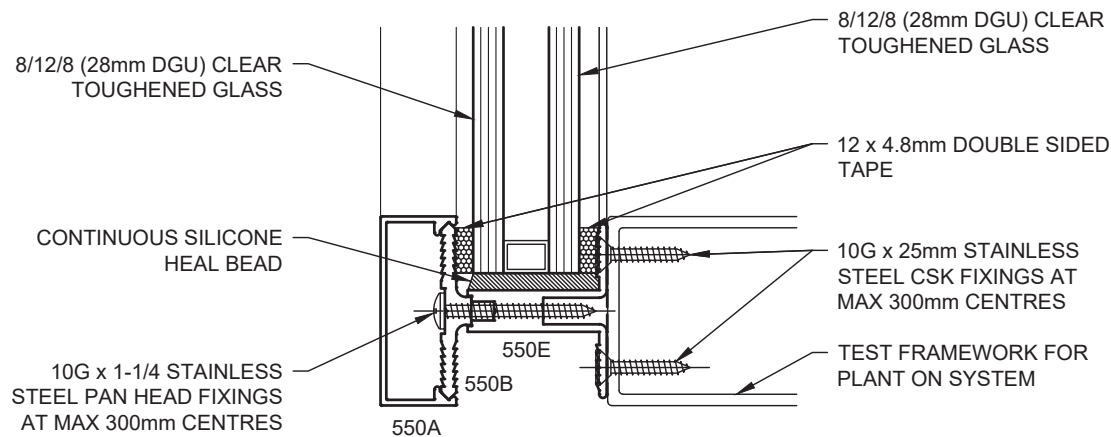


DISCLAIMER:
Please note that the test results shown above reflect specific configurations of a system and are representative only. If a specific high wind load or a different configuration (i.e. changes to frames, transoms, mullions) is required on a project please discuss with Alspec prior to commencement.

4. Test Summary

AS2047 - Double Glazed Window Configuration

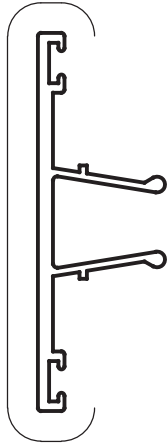
TEST REPORT:	OT23-206
SYSTEM CONFIGURATION	HASTINGS 550 F/F FRONT GLAZED, DOUBLE GLAZED FRAMING
TEST SAMPLE SIZE	2.432m high x 2.432m wide
ULTIMATE LOAD	+/- 8.015 kPa
WATER PENETRATION	1005 Pa
AIR INFILTRATION @ 75Pa	+ 0.02 L/m/s ² - 0.02 L/m/s ²



DISCLAIMER:

Please note that the test results shown above reflect specific configurations of a system and are representative only. If a specific high wind load or a different configuration (i.e. changes to frames, transoms, mullions) is required on a project please discuss with Alspec prior to commencement.

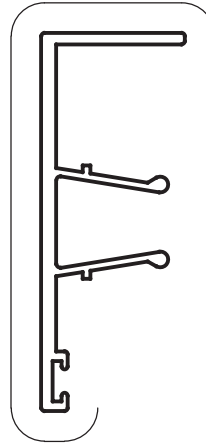
VISIBLE SURFACE



AS104
SNAP ADAPTOR

Mass. 0.381 Kg/m
Anod. Per. 188
Paint Per. 100

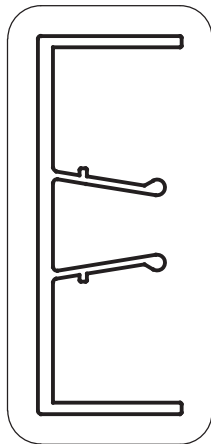
VISIBLE SURFACE



AS105
SNAP ADAPTOR

Mass. 0.443 Kg/m
Anod. Per. 211
Paint Per. 100

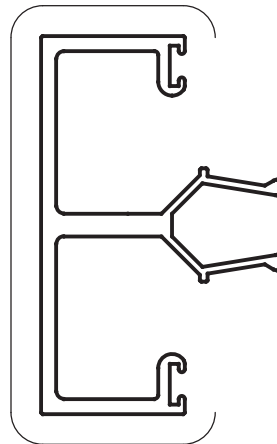
VISIBLE SURFACE



AS119
SNAP COVER

Mass. 0.505 Kg/m
Anod. Per. 235
Paint Per. 100

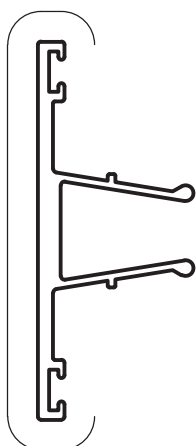
VISIBLE SURFACE



AS113
DEEP ADAPTOR

Mass. 0.749 Kg/m
Anod. Per. 235
Paint Per. 100

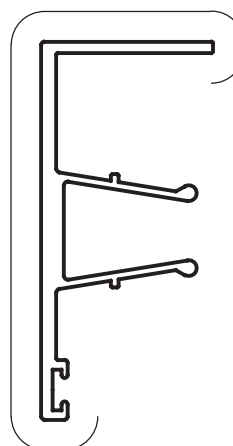
VISIBLE SURFACE



AS124
SNAP ADAPTOR

Mass. 0.438 Kg/m
Anod. Per. 201
Paint Per. 100

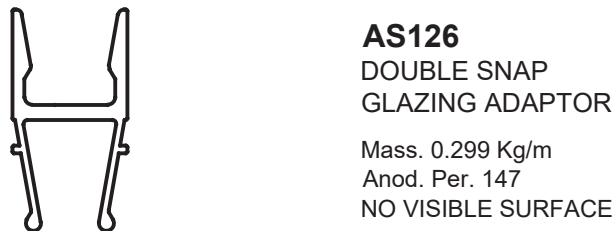
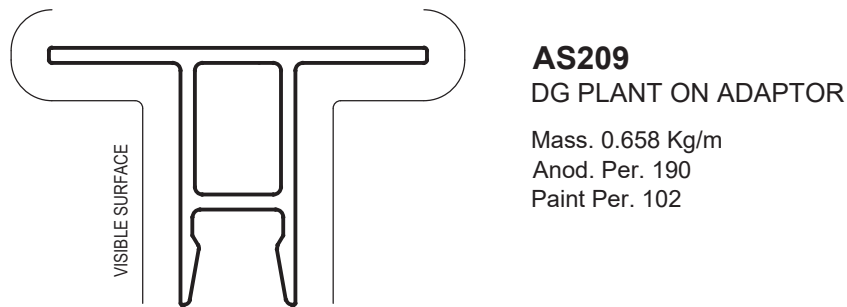
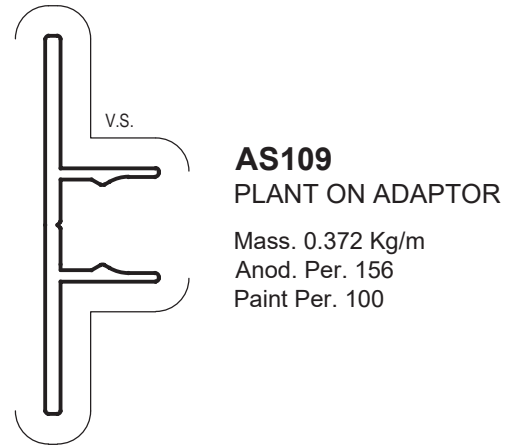
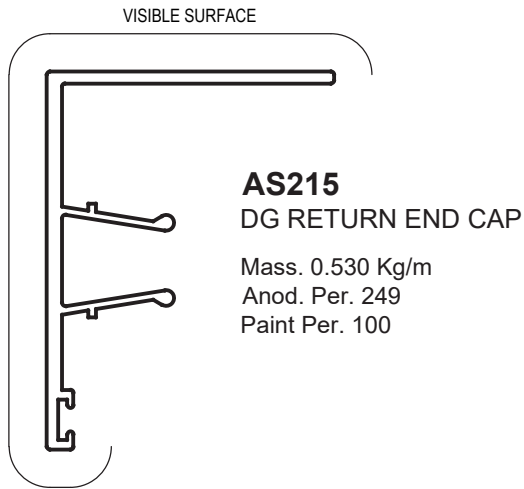
VISIBLE SURFACE

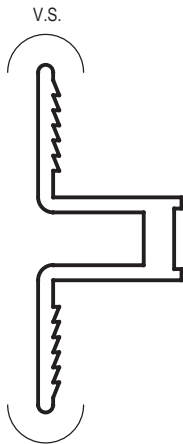


AS125
SNAP ADAPTOR
WITH LEG

Mass. 0.515 Kg/m
Anod. Per. 232
Paint Per. 100

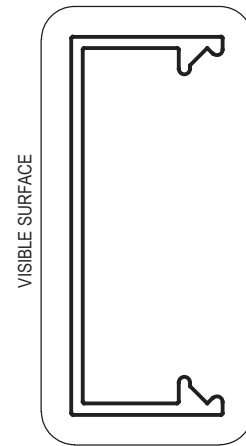
5. Extrusions





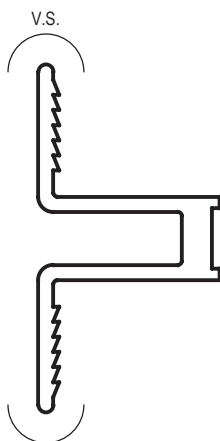
550C
SG GLAZE
ADAPTOR

Mass. 0.491 Kg/m
Anod. Per. 167
Paint Per. 100



550A
SNAP COVER

Mass. 0.402 Kg/m
Anod. Per. 189
Paint Per. 100



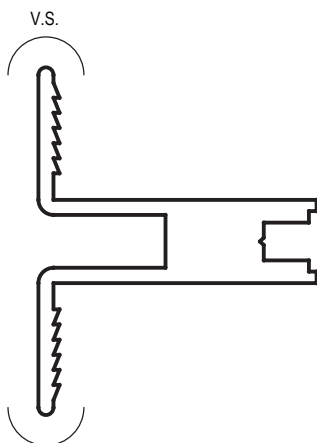
550J
SG GLAZE
ADAPTOR
14-18mm

Mass. 0.547 Kg/m
Anod. Per. 186
Paint Per. 100



550B
CLAMP


Mass. 0.495 Kg/m
Anod. Per. 126
NO VISIBLE SURFACE



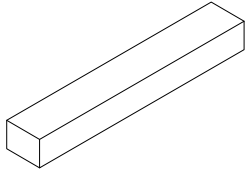
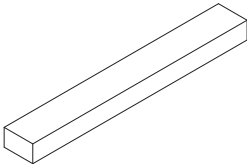
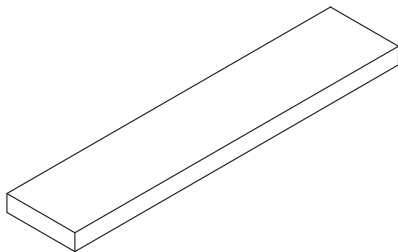
550E
DG GLAZE
ADAPTOR

Mass. 0.886 Kg/m
Anod. Per. 220
Paint Per. 100

Seals

IMAGE	PART #	FINISH	DESCRIPTION
	1376300	BLACK (034)	HB1 BULB SEAL x 100m
	1376301		HB1 BULB SEAL x 1m
	1385506	BLACK (034)	12mm x 6.4mm DOUBLE SIDED GLAZING TAPE x 10.7m
	1385549		12mm x 3.2mm DOUBLE SIDED GLAZING TAPE x 30.5m
	1385577		12mm x 4.8mm DOUBLE SIDED GLAZING TAPE x 15.2m
	1385580		12mm x 1.6mm DOUBLE SIDED GLAZING TAPE x 61m

Accessories



SETTING BLOCK 5 x 21 x 100mm BAG OF 100	
PART	1376774
FINISH	BLACK (034)
QTY	BAG OF 100

SETTING BLOCK 10 x 6 x 75mm BAG OF 100	
PART	1376775
FINISH	BLACK (034)
QTY	BAG OF 100

SETTING BLOCK 6 x 8 x 50mm BAG OF 1000	
PART	1376776
FINISH	BLACK (034)
QTY	BAG OF 1000

Silicone



100% NEUTRAL CURE SILICONE

- Premium 100% silicone
- UV Stable
- Superior adhesion
- Flexible + 25%
- AS4020 Approved



100% MATTE NEUTRAL CURE SILICONE

- Premium 100% silicone
- Matte finish
- UV Stable
- Outstanding elongation
- Higher strength



41 CLADDING SILICONE

- Premium 100% silicone
- UV Stable
- Superior adhesion
- Movement capability + 50%



WET AREA SILICONE

- Premium 100% silicone
- Mould inhibited
- Movement capability + 25%
- UV Stable
- Non corrosive
- Superior adhesion



HYBRID PU ADHESIVE SEALANT

- No isocyanates
- Internal/External
- No shrinking/staining
- Paintable
- Excellent adhesion



20 ACETIC CURE SILICONE

- Premium 100% silicone
- UV Stable
- Superior adhesion
- Flexible + 25%



D60 SILICONE

- Premium 100% silicone
- UV Stable
- 2-5 minute skin time
- Flexible + 25%
- No slump

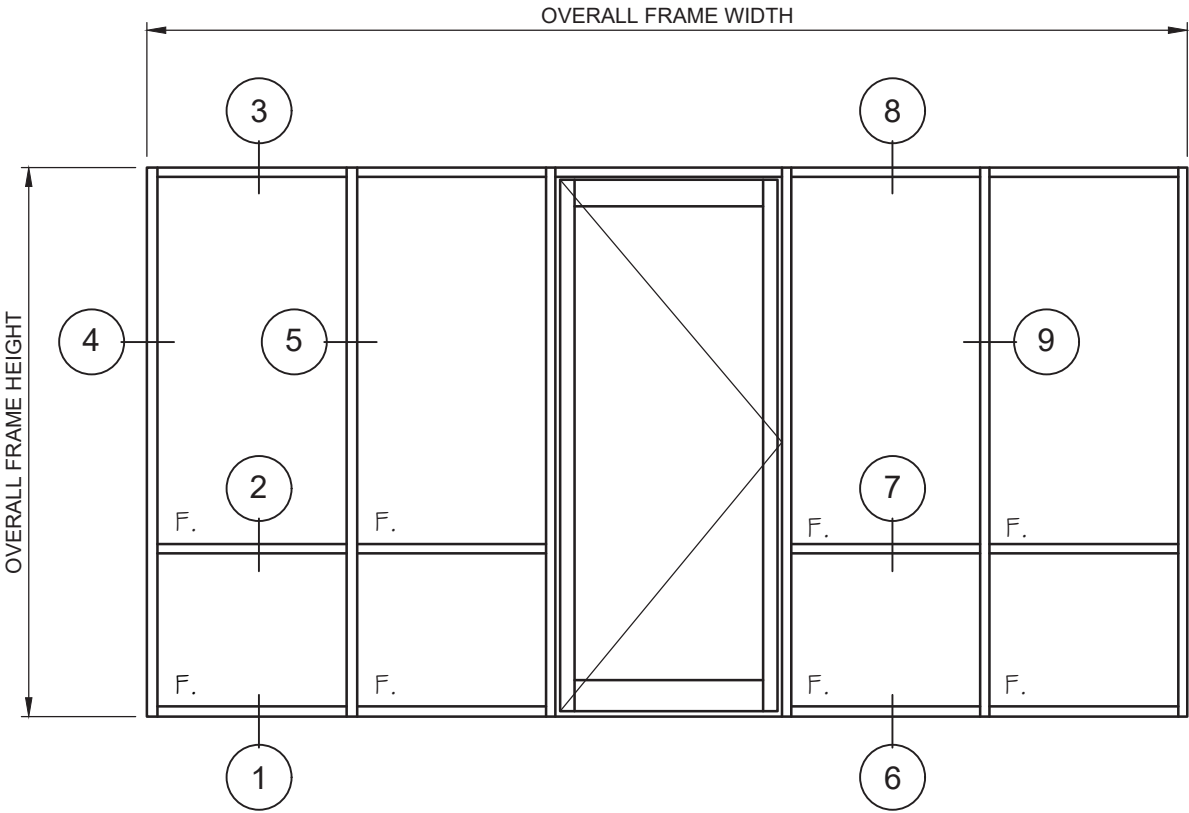
*For more information on silicones,
please refer to Alspec Silicone Brochure.



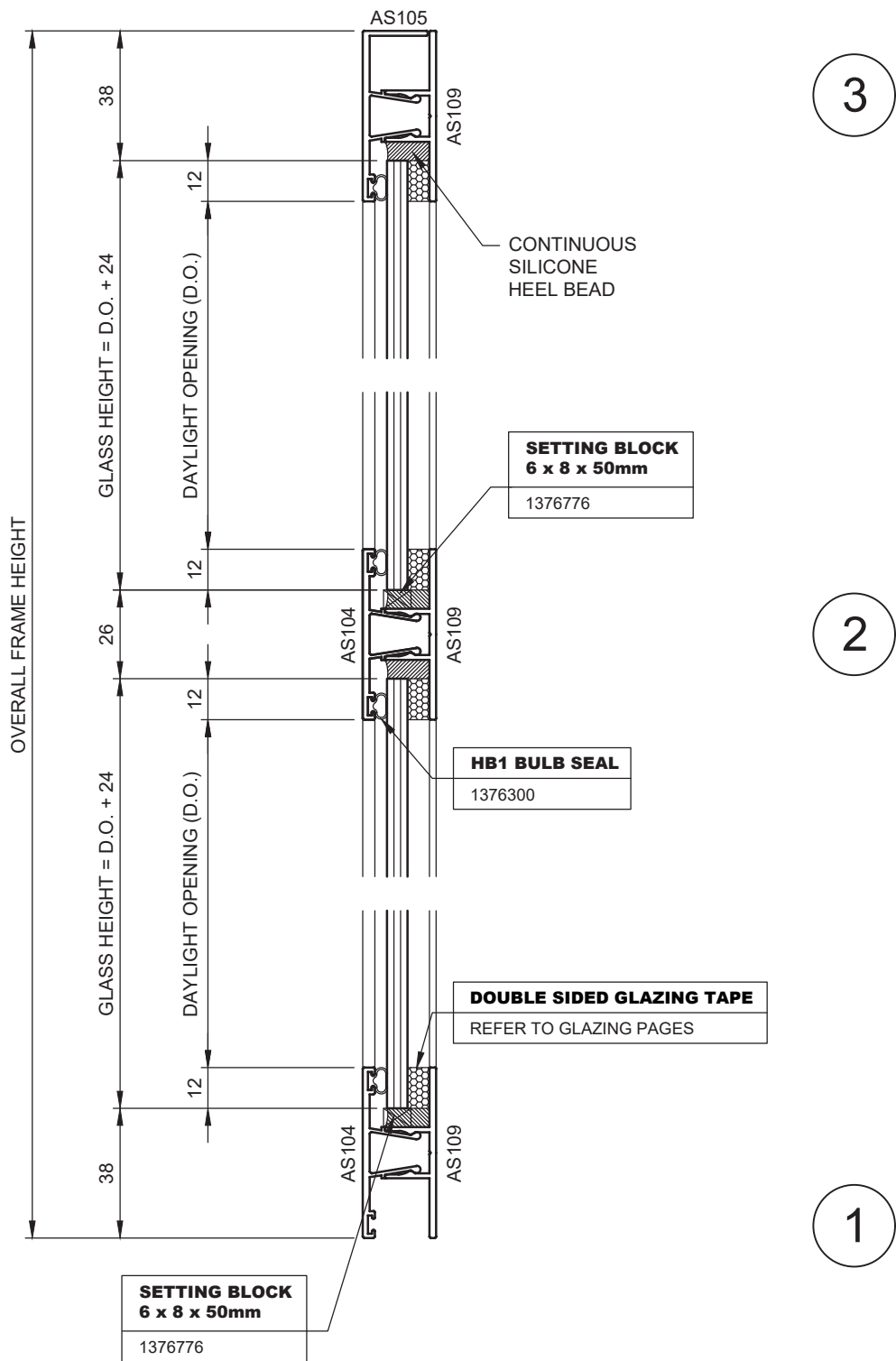
6. Hardware & Components

Silicone Product Codes

Product Category	Item No.	Alspec Part No. Code	Description	Finish	Pack
ALSPEC 100%	1	1386113	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	ALMOND IVORY	CARTRIDGE
	2	1386114	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	ALUMINIUM	CARTRIDGE
	3	1386105	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	BLACK	CARTRIDGE
	4	1386140	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	CAULFIELD GREEN	CARTRIDGE
	5	1386111	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	CLASSIC CREAM	CARTRIDGE
	6	1386108	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	GREY	CARTRIDGE
	7	1386138	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	MONUMENT	CARTRIDGE
	8	1386112	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	OFF WHITE	CARTRIDGE
	9	1386141	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	STONE BEIGE	CARTRIDGE
	10	1386101	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	TRANSLUCENT	CARTRIDGE
	11	1386106	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	WHITE	CARTRIDGE
	12	1386143	ALSPEC 100% NEUTRAL CURE SILICONE x 310g CAT	WOODLAND GREY	CARTRIDGE
ALSPEC 100% MATT	13	1386103	ALSPEC 100% NEUTRAL CURE SILICONE x 420g CAT	BLACK MATT	CARTRIDGE
	14	1386107	ALSPEC 100% NEUTRAL CURE SILICONE x 420g CAT	GREY MATT	CARTRIDGE
	15	1386144	ALSPEC 100% NEUTRAL CURE SILICONE x 420g CAT	WHITE MATT	CARTRIDGE
ALSPEC 20	16	1386115	ALSPEC 20 SILICONE x 310g CAT	TRANSLUCENT	CARTRIDGE
ALSPEC 41 CLADDING	17	1386159	ALSPEC 41 SILICONE x 400g CAT	BLACK MATT	CARTRIDGE
	18	1386117	ALSPEC 41 SILICONE x 600ml SAU	BLACK MATT	SAUSAGE
	19	1386158	ALSPEC 41 SILICONE x 400g CAT	LIGHT GREY MATT	CARTRIDGE
	20	1386118	ALSPEC 41 SILICONE x 600ml SAU	LIGHT GREY MATT	SAUSAGE
	21	1386157	ALSPEC 41 SILICONE x 400g CAT	WHITE MATT	CARTRIDGE
	22	1386145	ALSPEC 41 SILICONE x 600ml SAU	WHITE MATT	SAUSAGE
ALSPEC D60	23	1386121	ALSPEC D60 SILICONE x 310g CAT	BLACK	CARTRIDGE
	25	1386123	ALSPEC D60 SILICONE x 310g CAT	GREY	CARTRIDGE
	26	1386120	ALSPEC D60 SILICONE x 310g CAT	TRANSLUCENT	CARTRIDGE
	27	1386124	ALSPEC D60 SILICONE x 310g CAT	WHITE	CARTRIDGE
ALSPEC HYBRID PU	28	1386127	ALSPEC HYBRID PU x 480g CAT	BLACK	CARTRIDGE
	29	1386126	ALSPEC HYBRID PU x 600ml SAU	BLACK	SAUSAGE
	30	1386160	ALSPEC HYBRID PU x 480g CAT	GREY	CARTRIDGE
	31	1386128	ALSPEC HYBRID PU x 600ml SAU	GREY	SAUSAGE
	32	1386130	ALSPEC HYBRID PU x 480g CAT	WHITE	CARTRIDGE
	33	1386129	ALSPEC HYBRID PU x 600ml SAU	WHITE	SAUSAGE
ALSPEC WET AREA	34	1386137	ALSPEC WET AREA SILICONE x 310g CAT	ALMOND IVORY	CARTRIDGE
	35	1386139	ALSPEC WET AREA SILICONE x 310g CAT	BLACK	CARTRIDGE
	36	1386146	ALSPEC WET AREA SILICONE x 310g CAT	BLUESTONE	CARTRIDGE
	37	1386147	ALSPEC WET AREA SILICONE x 310g CAT	CHARCOAL	CARTRIDGE
	38	1386136	ALSPEC WET AREA SILICONE x 310g CAT	LIGHT GREY	CARTRIDGE
	39	1386148	ALSPEC WET AREA SILICONE x 310g CAT	MID GREY	CARTRIDGE
	40	1386149	ALSPEC WET AREA SILICONE x 310g CAT	OFF WHITE	CARTRIDGE
	41	1386150	ALSPEC WET AREA SILICONE x 310g CAT	PEWTER	CARTRIDGE
	42	1386151	ALSPEC WET AREA SILICONE x 310g CAT	STONE BEIGE	CARTRIDGE
	43	1386154	ALSPEC WET AREA SILICONE x 310g CAT	TAUPE	CARTRIDGE
	44	1386152	ALSPEC WET AREA SILICONE x 310g CAT	TILE GREY	CARTRIDGE
	45	1386133	ALSPEC WET AREA SILICONE x 310g CAT	TRANSLUCENT	CARTRIDGE
	46	1386153	ALSPEC WET AREA SILICONE x 310g CAT	TRAVERTINE	CARTRIDGE
	47	1386134	ALSPEC WET AREA SILICONE x 310g CAT	WHITE	CARTRIDGE

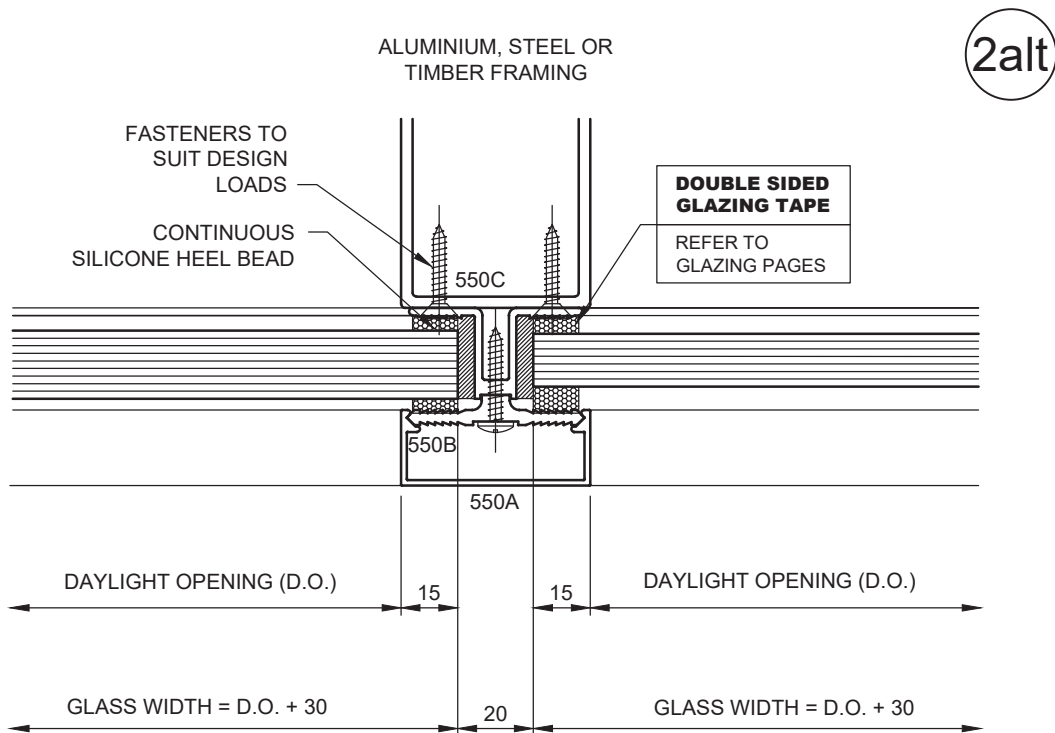
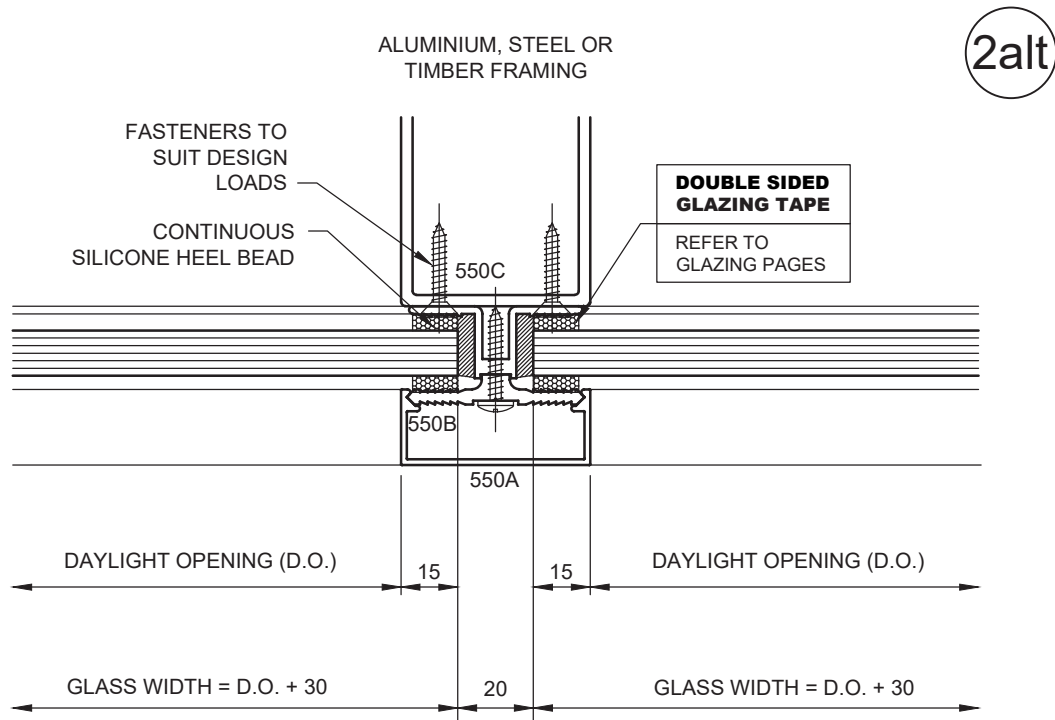


Sill, Transom and Head Details



8. Typical Details

Single Glazed Adaptor and Clamp Details

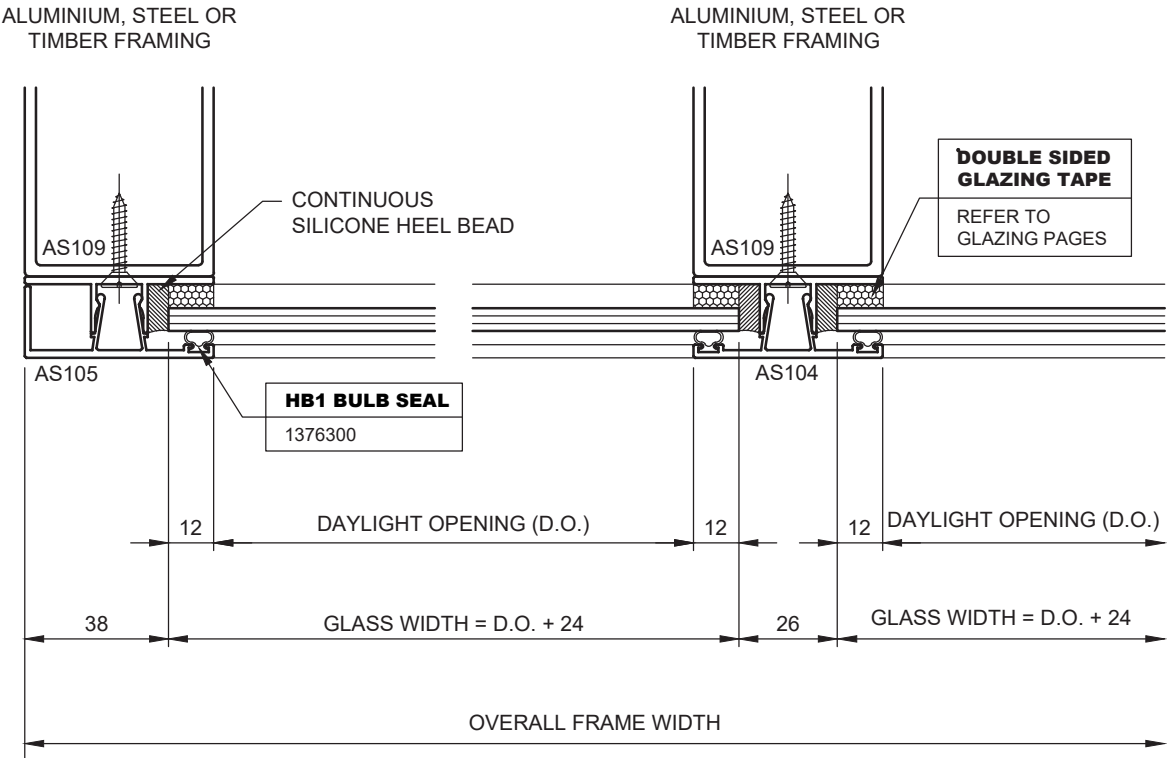


NOTE: SCREW SIZE AND QUANTITY TO BE
CONFIRMED BY ENGINEER

Single Glazed Adaptor Details

4

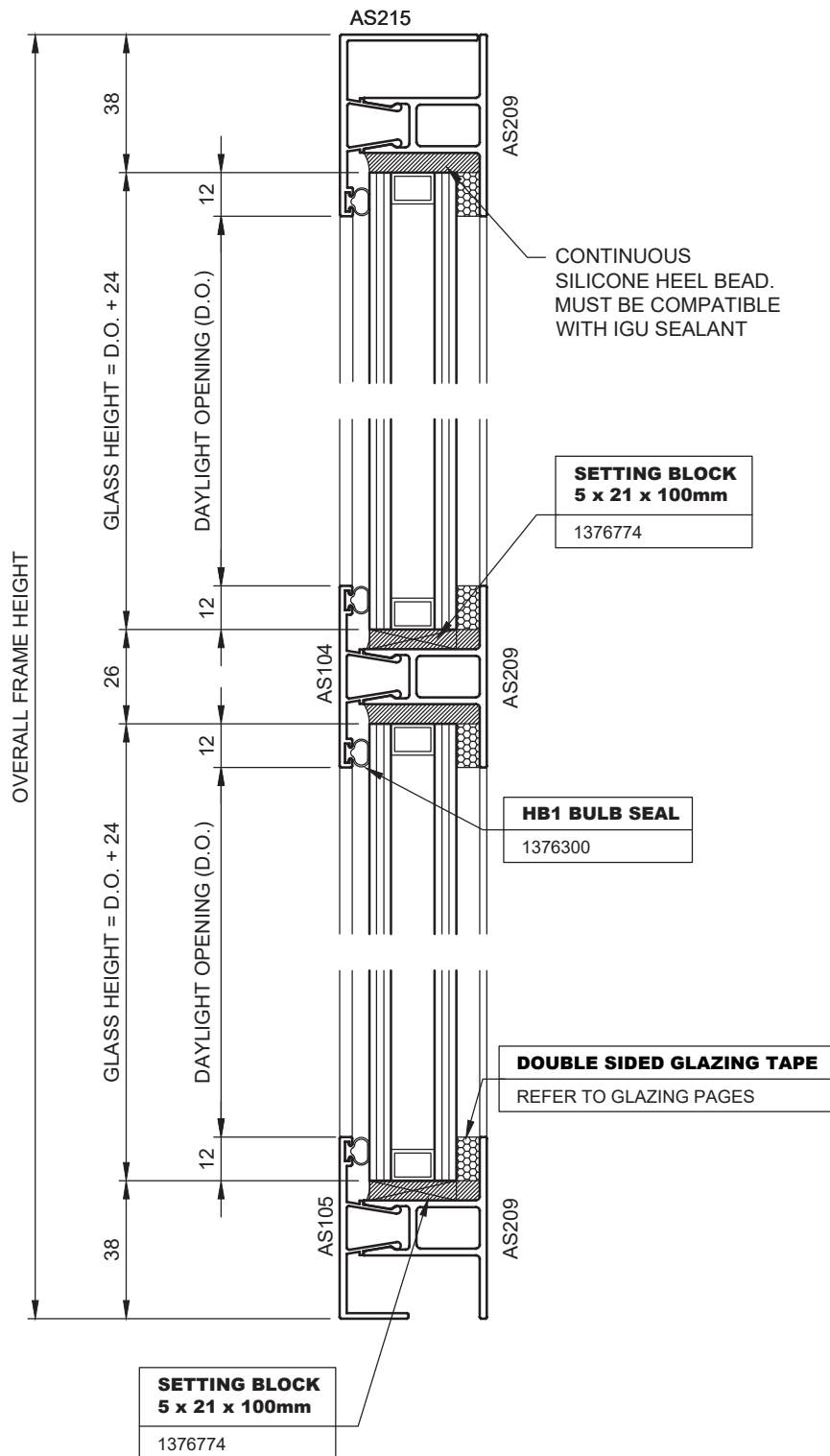
5



NOTE: SCREW SIZE AND QUANTITY TO BE
CONFIRMED BY ENGINEER

8. Typical Details

Double Glazed Sill, Transom and Head Details

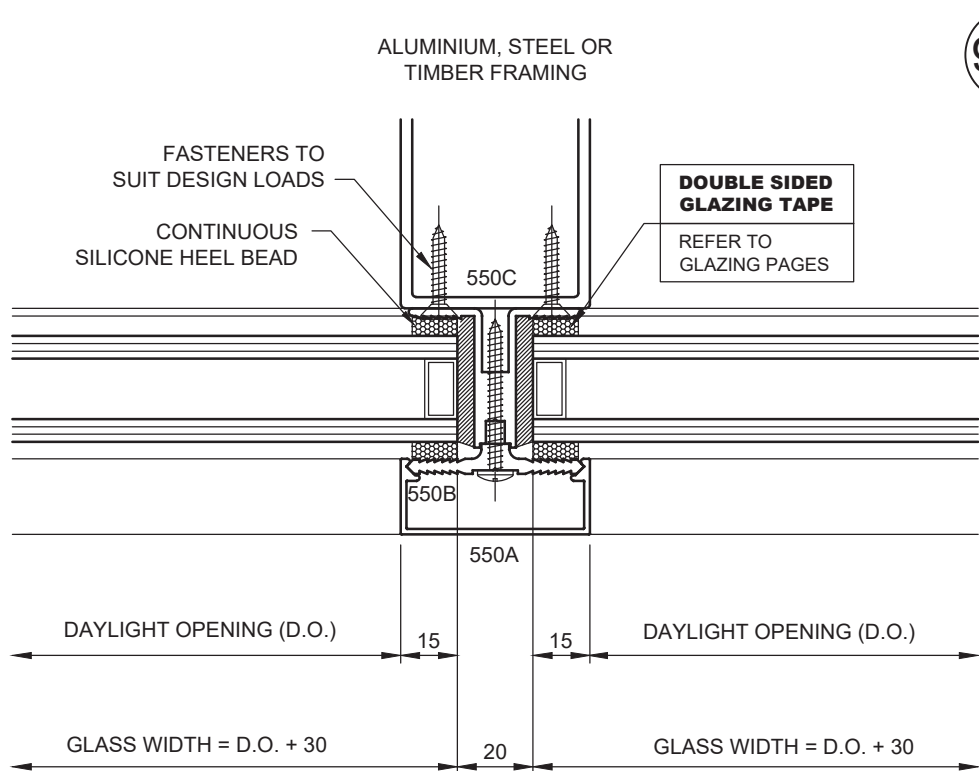
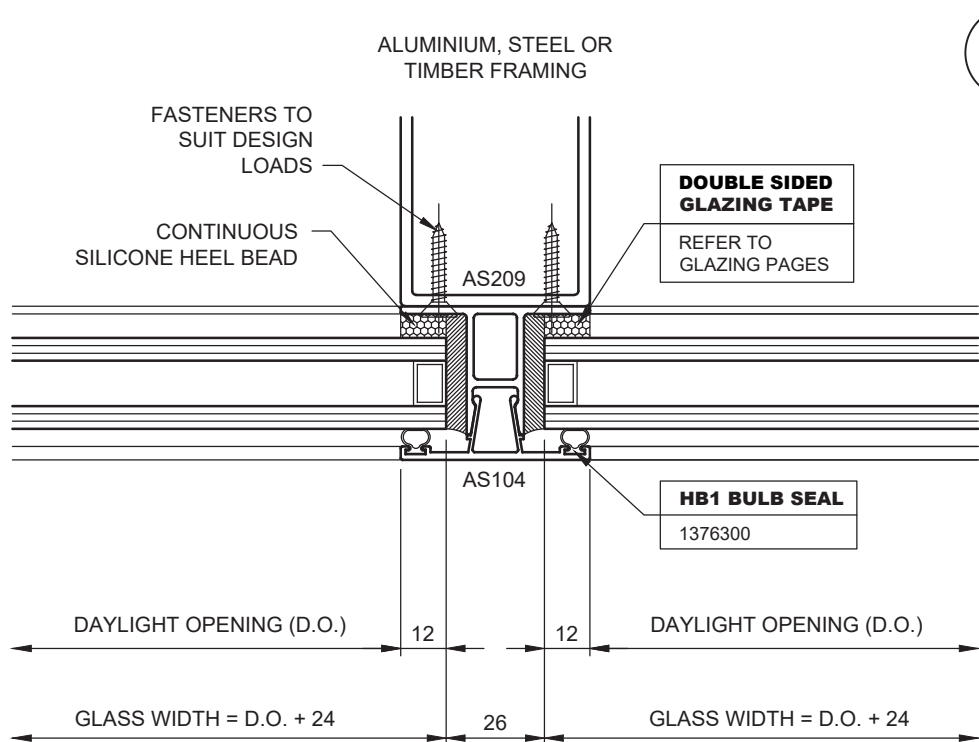


8

7

6

Double Glazed Adaptor and Clamp Details

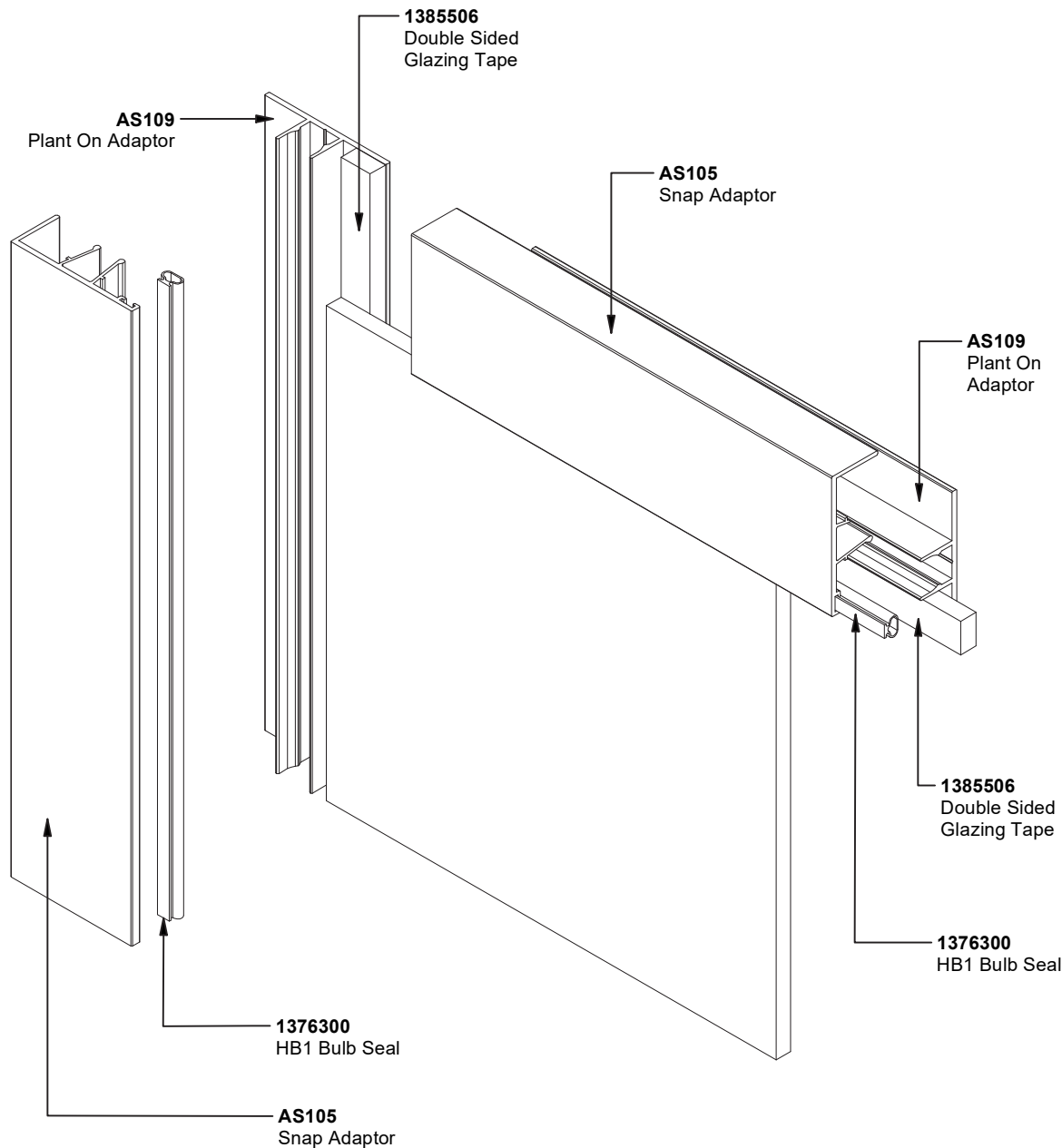


NOTE: SCREW SIZE AND QUANTITY TO BE
CONFIRMED BY ENGINEER

11. Assembly Details

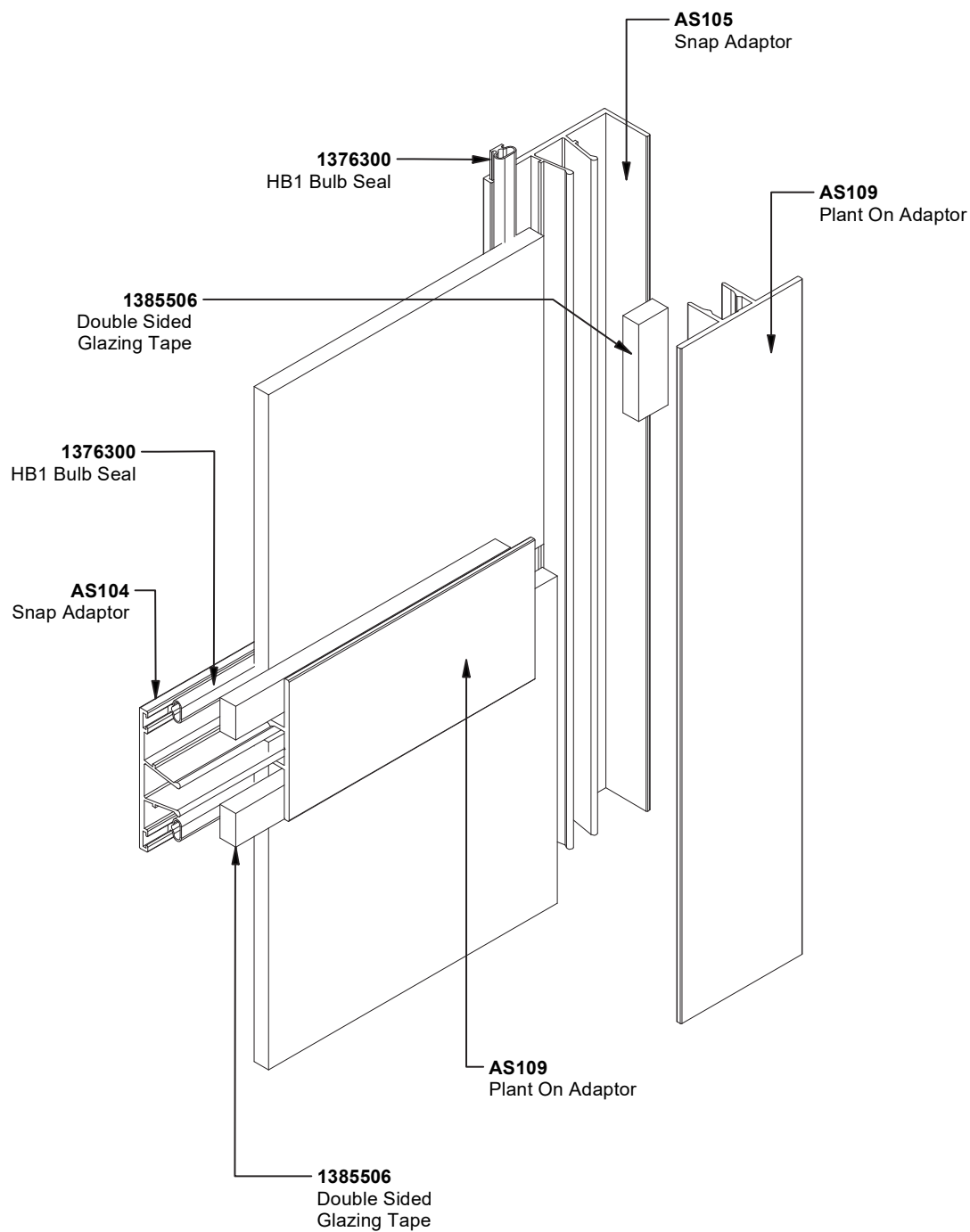


Jamb and Head Assembly Details

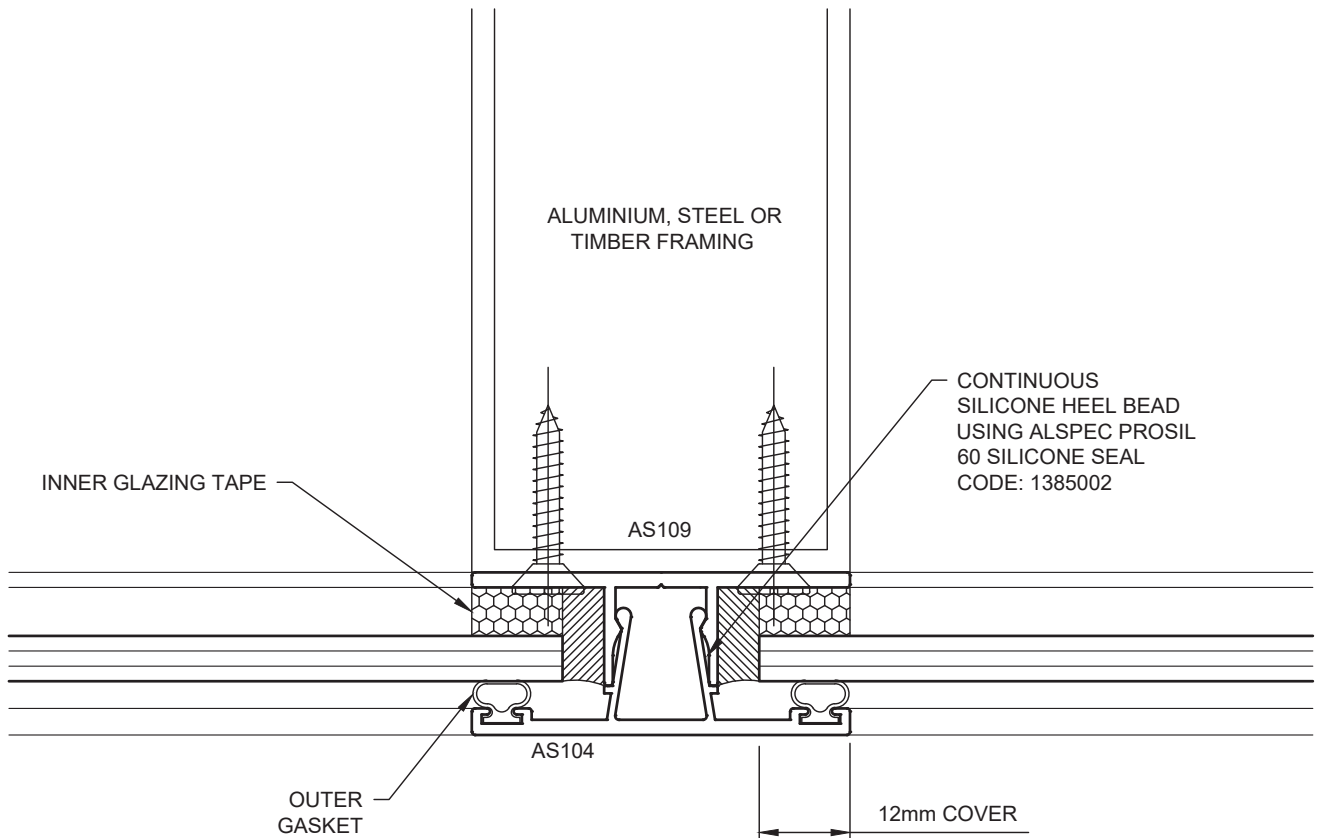


11. Assembly Details

Jamb and Transom Assembly Details



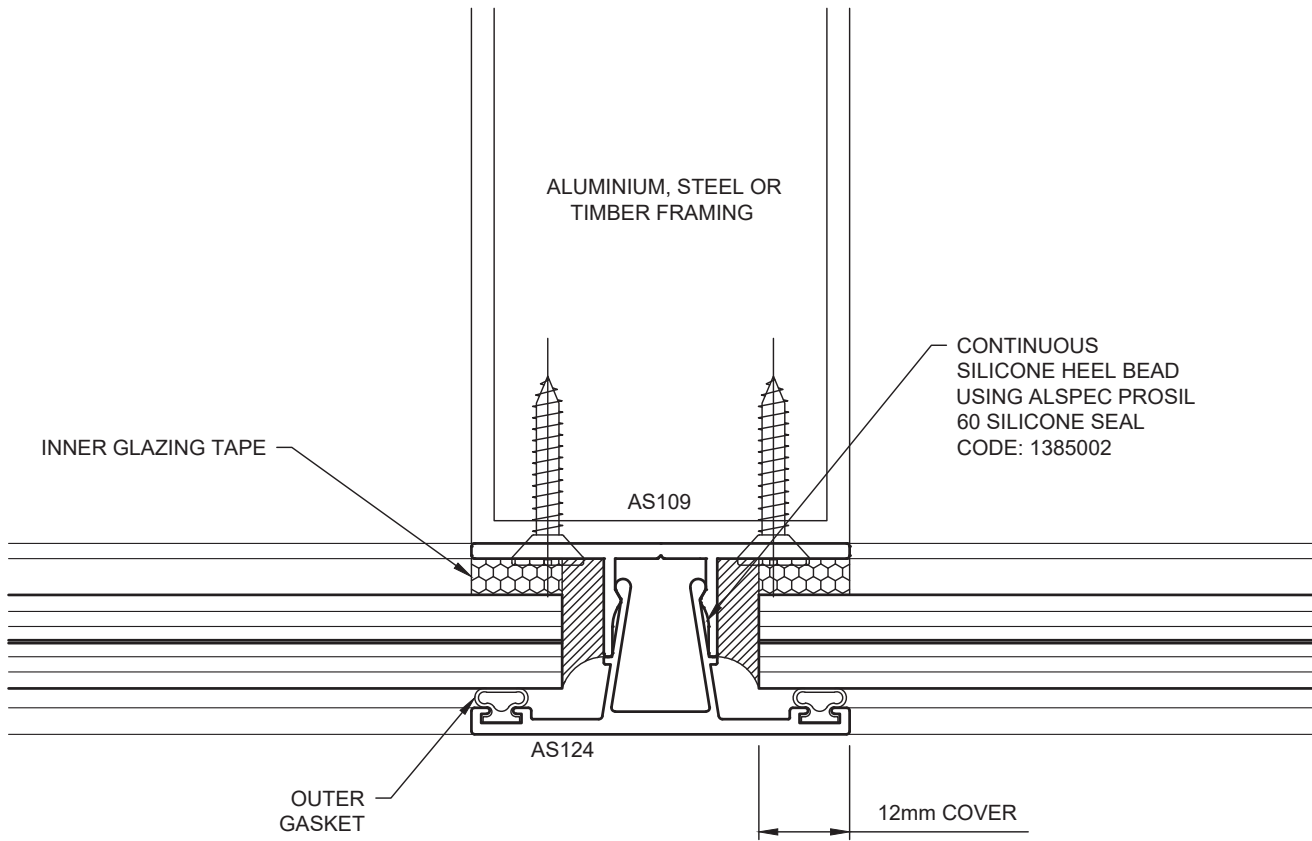
Standard Glazing Details - with AS104 Snap Adaptor



GLASS THICKNESS	OUTER GASKET		INNER GLAZING TAPE	
	REF.	CODE	REF.	CODE
6/6.38mm	HB1	1376300	12 x 6.4mm DOUBLE SIDED	1385506
8/8.38mm	HB1	1376300	12 x 4.8mm DOUBLE SIDED	1385577
10/10.38mm	HB1	1376300	12 x 3.2mm DOUBLE SIDED	1385549

NOTE: FASTENERS TO SUIT DESIGN LOADS

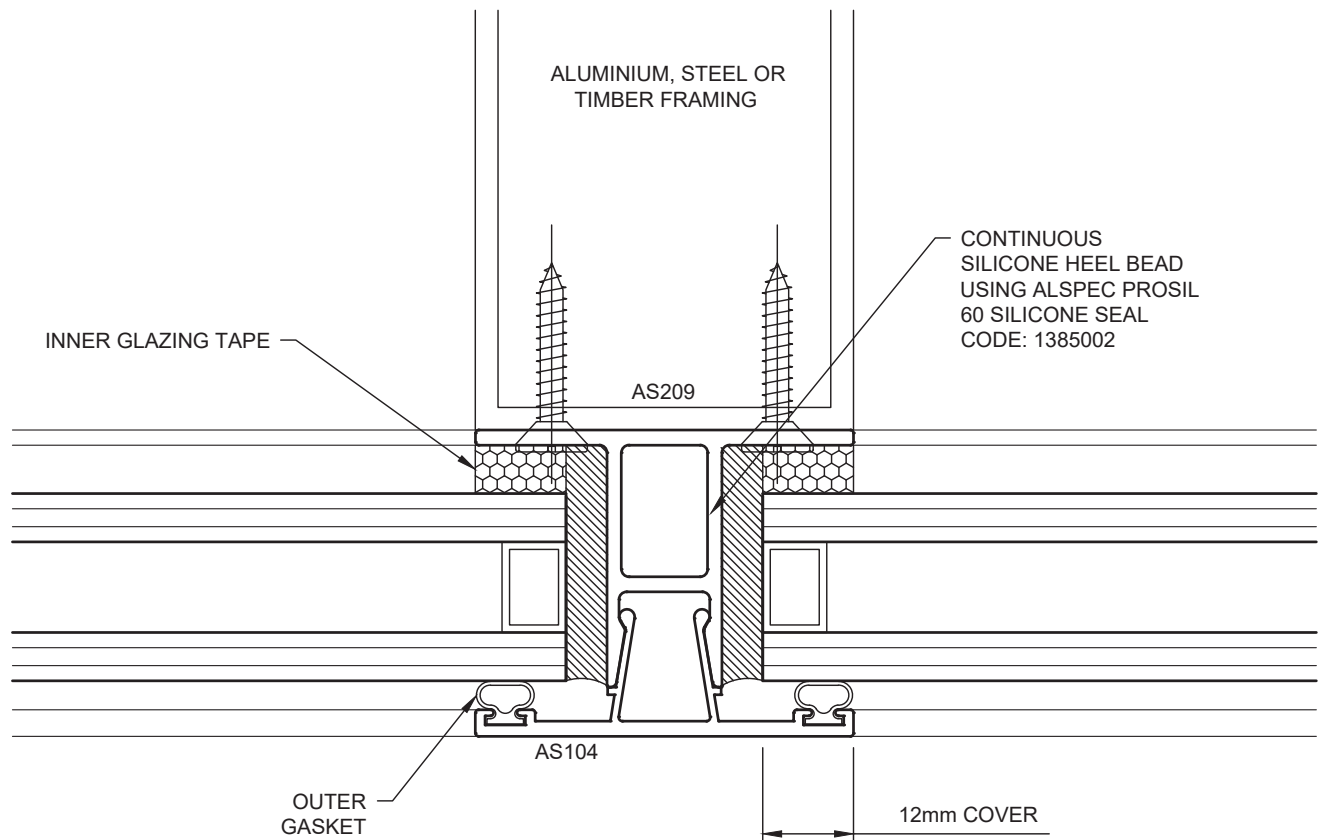
Standard Glazing Details - with AS124 Snap Adaptor



GLASS THICKNESS	OUTER GASKET		INNER GLAZING TAPE	
	REF.	CODE	REF.	CODE
12/12.38mm	HB1	1376300	12 x 3.2mm DOUBLE SIDED	1385549
13.52mm	HB1	1376300	12 x 3.2mm DOUBLE SIDED	1385549

NOTE: FASTENERS TO SUIT DESIGN LOADS

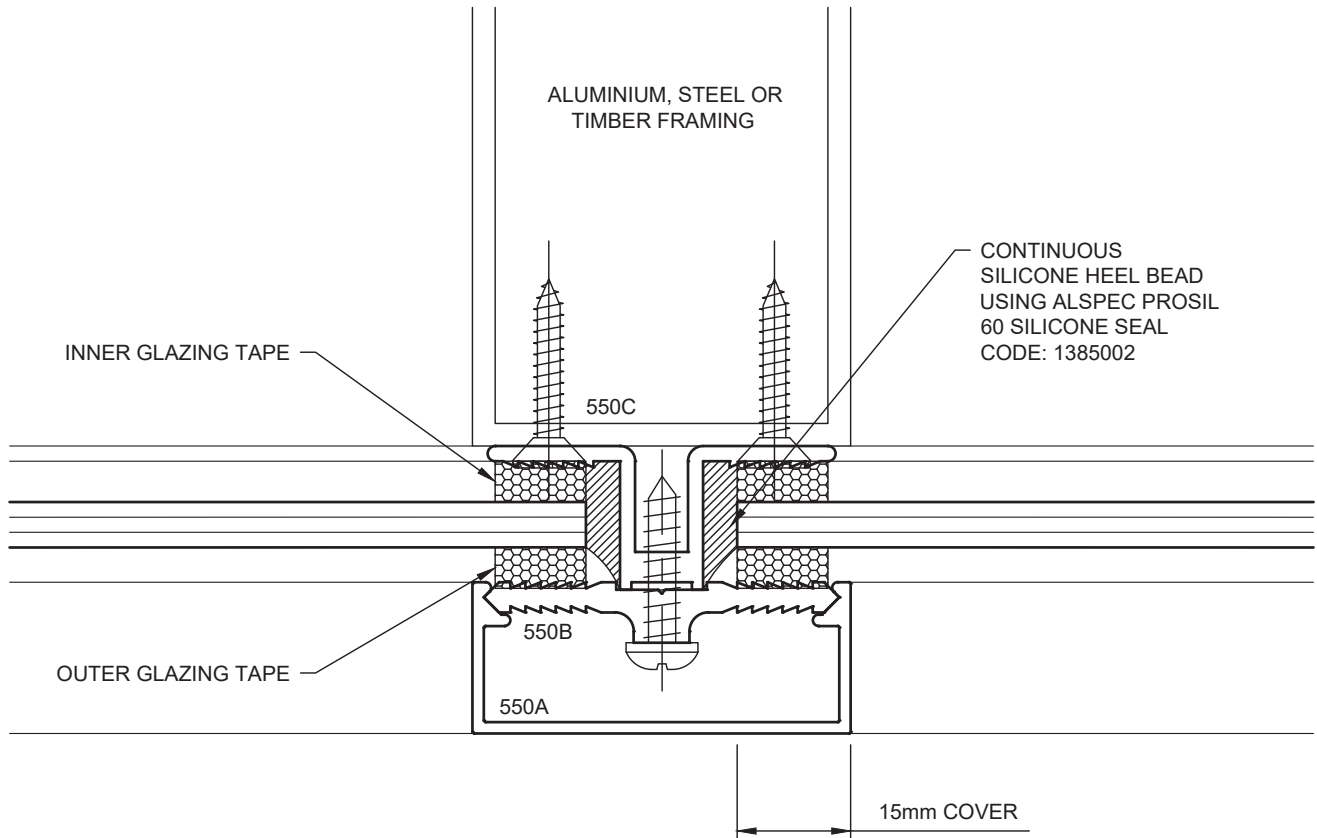
Standard Glazing Details - Double Glazed



GLASS THICKNESS	OUTER GASKET		INNER GLAZING TAPE	
	REF.	CODE	REF.	CODE
24mm	HB1	1376300	12 x 6.4mm DOUBLE SIDED	1385506
26mm	HB1	1376300	12 x 4.8mm DOUBLE SIDED	1385577
28mm	HB1	1376300	12 x 3.2mm DOUBLE SIDED	1385549

NOTE: FASTENERS TO SUIT DESIGN LOADS

Standard Glazing Details - with Reversed 550C Glazing Adaptor and Clamp

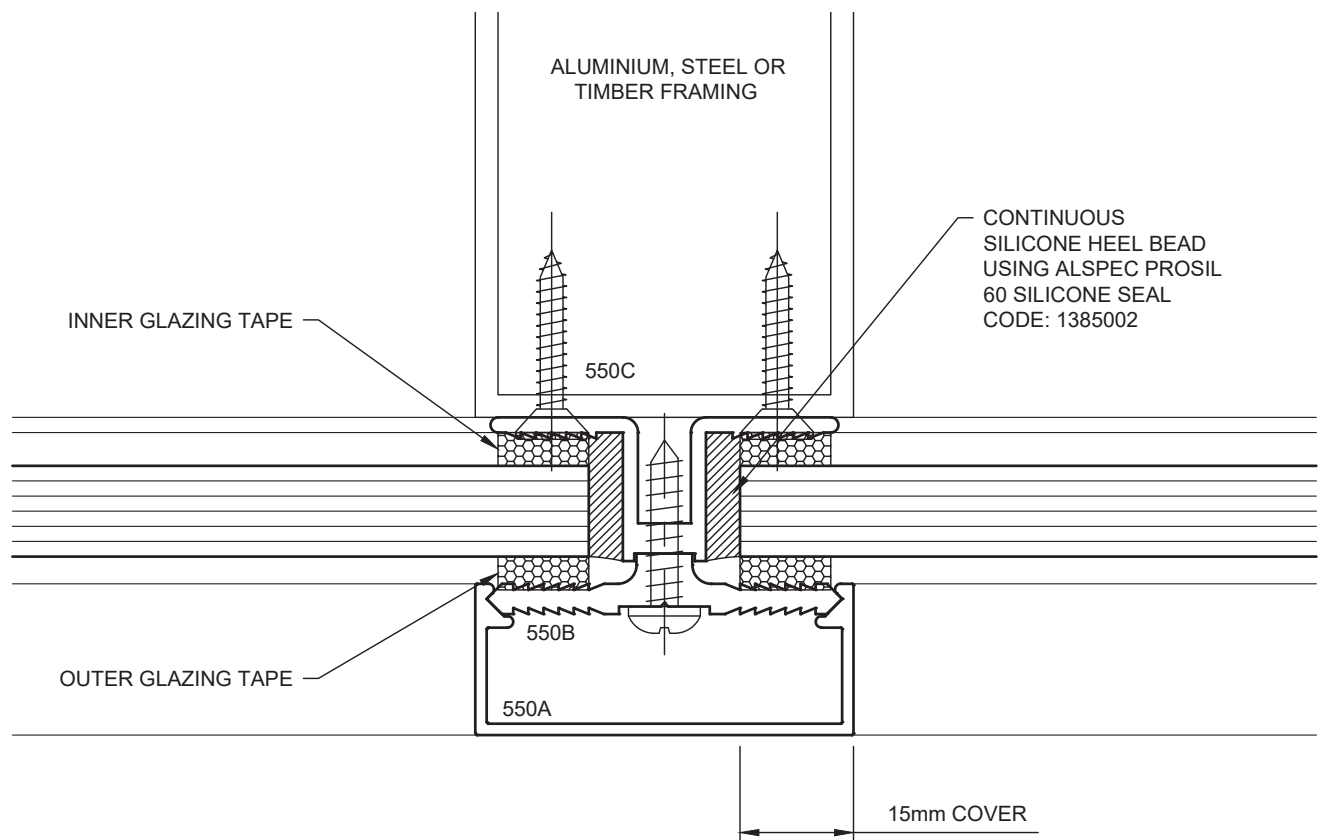


	OUTER GLAZING TAPE		INNER GLAZING TAPE	
GLASS THICKNESS	REF.	CODE	REF.	CODE
12/12.38mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 3.2mm DOUBLE SIDED	1385549
13.52mm	12 x 1.6mm DOUBLE SIDED	1385580	12 x 1.6mm DOUBLE SIDED	1385580

550B GLAZING CLAMP REVERSED

NOTE: FASTENERS TO SUIT DESIGN LOADS

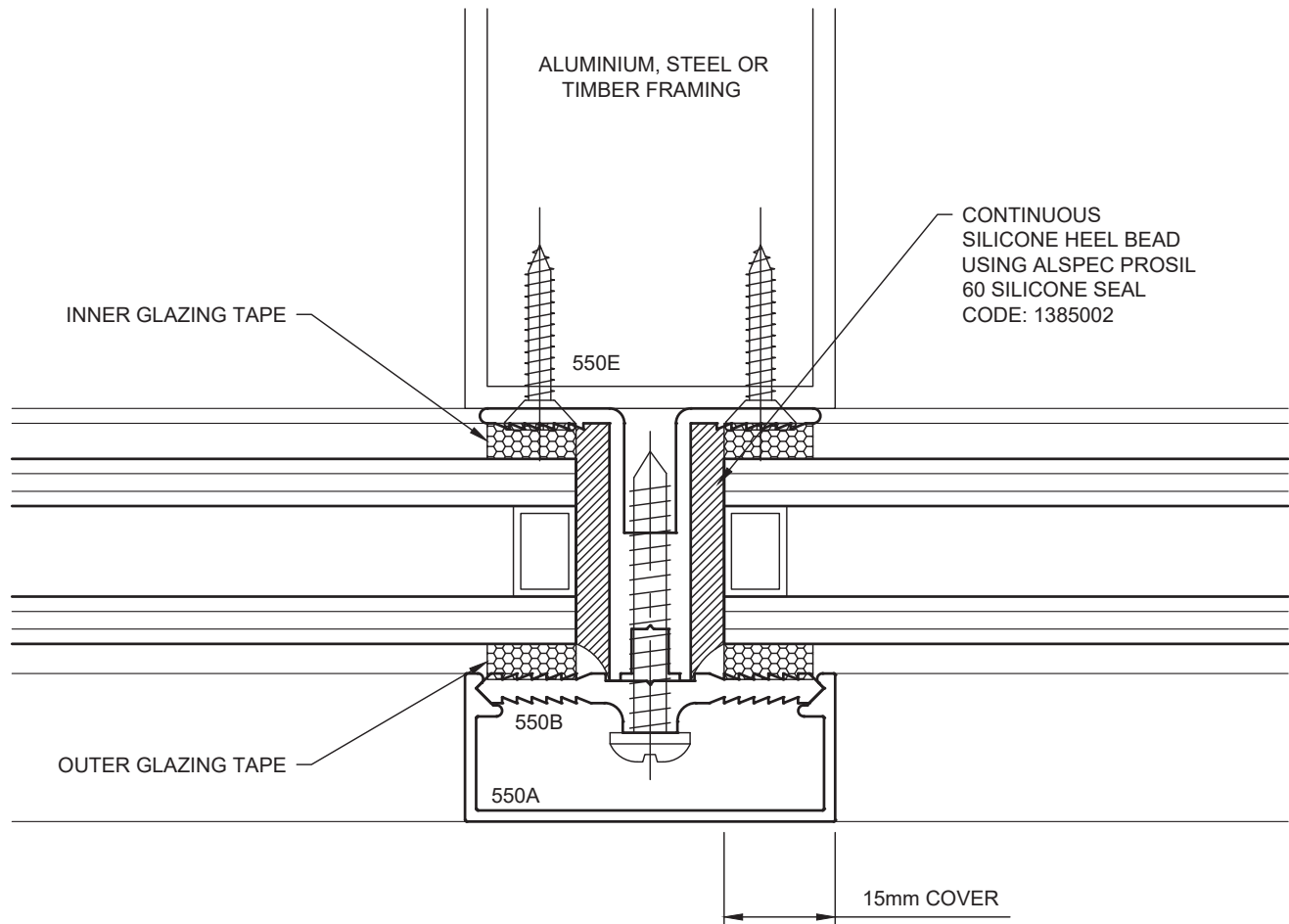
Standard Glazing Details - with 550C Glazing Adaptor and Clamp



GLASS THICKNESS	OUTER GLAZING TAPE		INNER GLAZING TAPE	
	REF.	CODE	REF.	CODE
10/10.38mm	12 x 6.4mm DOUBLE SIDED	1385506	12 x 4.8mm DOUBLE SIDED	1385577
12/12.38mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 3.2mm DOUBLE SIDED	1385549
13.52mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 1.6mm DOUBLE SIDED	1385580
16mm	12 x 1.6mm DOUBLE SIDED	1385580	12 x 1.6mm DOUBLE SIDED	1385580

NOTE: FASTENERS TO SUIT DESIGN LOADS

Standard Glazing Details - with Reversed 550E Double Glazing Adaptor and Clamp

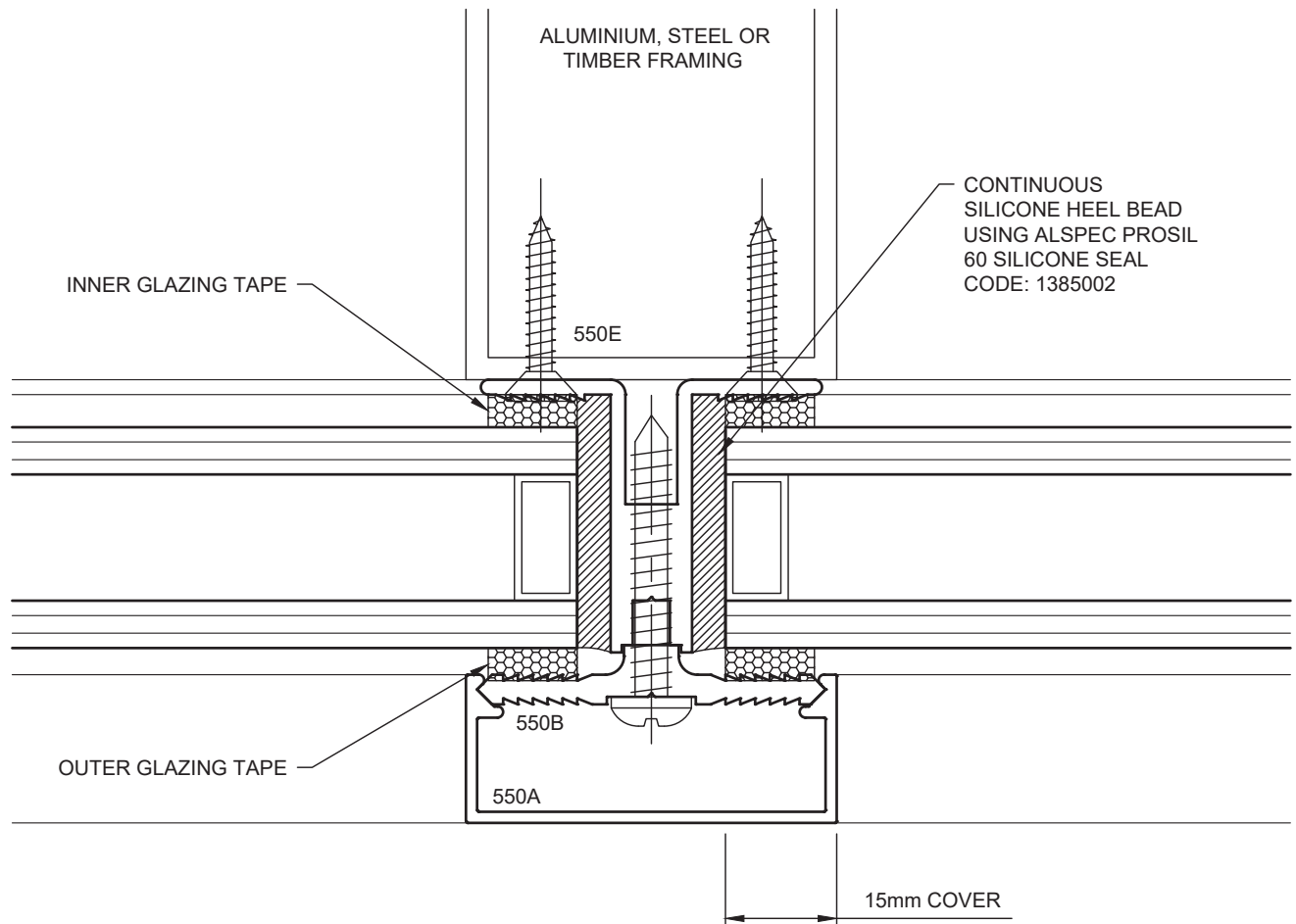


	OUTER GLAZING TAPE		INNER GLAZING TAPE	
GLASS THICKNESS	REF.	CODE	REF.	CODE
24mm	12 x 4.8mm DOUBLE SIDED	1385577	12 x 4.8mm DOUBLE SIDED	1385577
26mm	12 x 4.8mm DOUBLE SIDED	1385577	12 x 3.2mm DOUBLE SIDED	1385549
28mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 3.2mm DOUBLE SIDED	1385549
30mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 1.6mm DOUBLE SIDED	1385580

550B GLAZING CLAMP REVERSED

NOTE: FASTENERS TO SUIT DESIGN LOADS

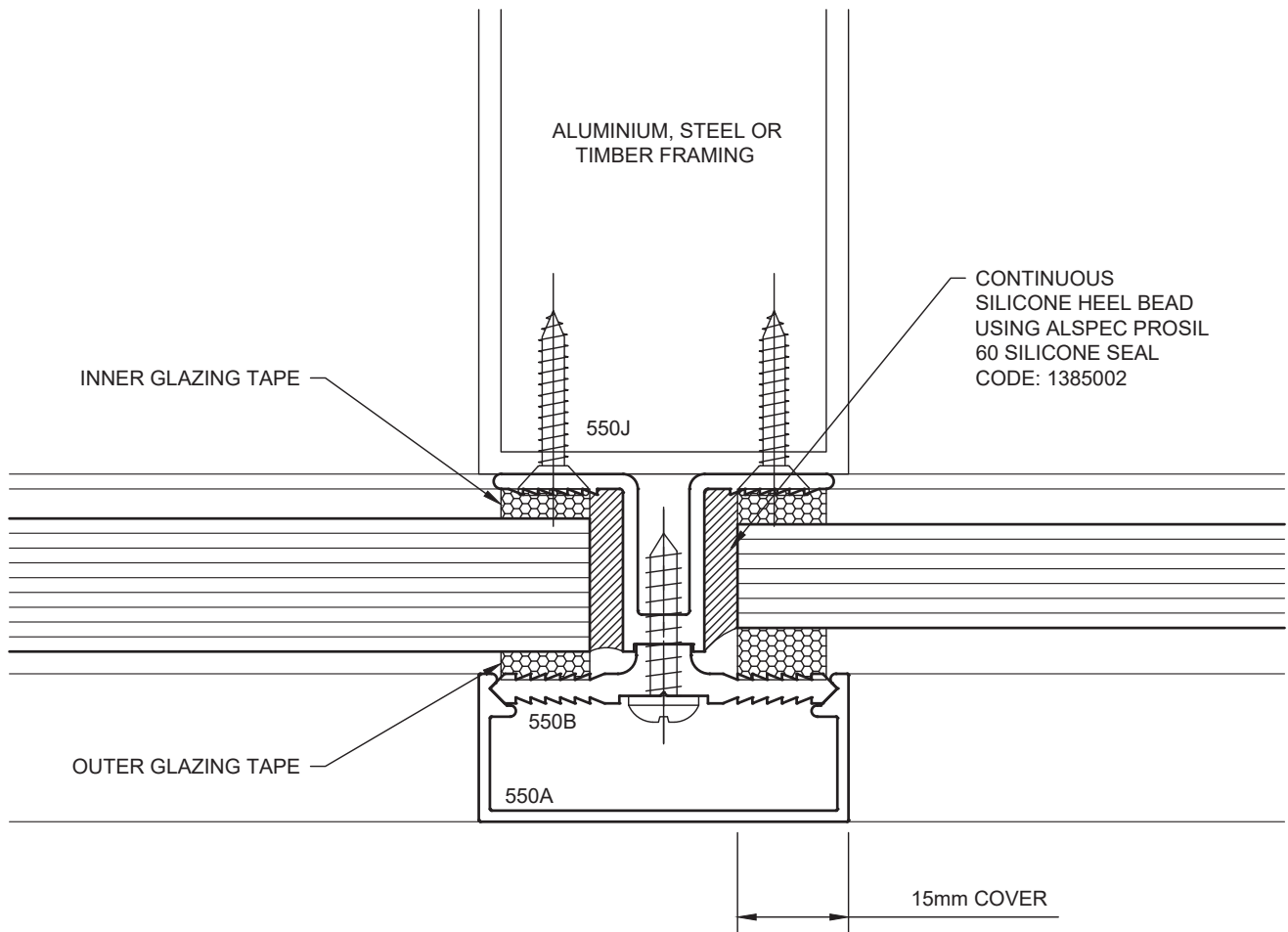
Standard Glazing Details - with 550E Double Glazing Adaptor and Clamp



GLASS THICKNESS	OUTER GLAZING TAPE		INNER GLAZING TAPE	
	REF.	CODE	REF.	CODE
28mm	12 x 4.8mm DOUBLE SIDED	1385577	12 x 4.8mm DOUBLE SIDED	1385577
30mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 4.8mm DOUBLE SIDED	1385577
32mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 3.2mm DOUBLE SIDED	1385549

NOTE: FASTENERS TO SUIT DESIGN LOADS

Standard Glazing Details - with 550J Glazing Adaptor and Clamp



GLASS THICKNESS	OUTER GLAZING TAPE		INNER GLAZING TAPE	
	REF.	CODE	REF.	CODE
14mm	12 x 6.4mm DOUBLE SIDED	1385506	12 x 4.8mm DOUBLE SIDED	1385577
18mm	12 x 3.2mm DOUBLE SIDED	1385549	12 x 4.8mm DOUBLE SIDED	1385577

NOTE: FASTENERS TO SUIT DESIGN LOADS

FRAMING

Your new **Hastings 550 Front Glazed Plant On** system have been manufactured using the highest quality materials available to the Architectural industry. Constructed from Architectural grade aluminium, these products are highly corrosion resistant and exceptionally strong. With a moderate amount of maintenance, the **Hastings 550 Front Glazed Plant On** system will retain it's good looks and resist the elements for years to come.

The **Hastings 550 Front Glazed Plant On** system are the product of extensive research and development and designed to resist corrosion and rusting, but as with all external elements on the building require some maintenance to keep them looking good and performing well. Depending on how harsh the environment elements are, the maintenance period will vary. Refer to recommended maintenance table below.

Your **Hastings 550 Front Glazed Plant On** system should only ever need to be washed down with a soft bristled brush using warm water and mild detergent. Rinse well with fresh water and remove any detergent residue. Strong detergents and abrasive cleaners should never be used to clean the **Hastings 550 Front Glazed Plant On** system as they may scratch or damage the surface finish.

MAINTENANCE PERIOD TABLE

ENVIRONMENT	RECOMMENDED MAXIMUM MAINTENANCE INTERVAL
Mild	Six Months
Moderate	Three Months
Tropical/Severe	One Month

Environmental Definitions:

Mild – Being rural, away from the coast and remote from industry and urban activity.

Moderate – Being mainly urban, inland and away from heavy industry.

Tropical – Being coastal/marine, subject to salt deposition and within 15km of the Eastern coast or 10km of the Western coast of Australia.

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All pictures shown in this catalogue are for illustration purposes only. Actual product may vary due to product enhancement.