ProVista ®
Sashless Double Hung Window

Technical Manual

January 2025 | ISSUE K

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ProVista
Sashless Double Hung Window

Contents

1. Technical Manual Release Notes

This page is intended to record all changes to the **PROVISTA SASHLESS DOUBLE HUNG WINDOW** 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 #
A	5/12/18	Technical manual initial release	N/A
B	6/3/19	Release 2	N/A
C	7/2019	Servery Configuration added	345
D	3/2020	Full Tech Manual re-release plus 18mm D/G + 18mm D/G Servery, BAL40, Servery Bumpers and No Sill	363
E	6/2020	60mm High Performance Sill Configuration + Extrusions	384
F	7/2020	Drawings Updated (10.21,11.6 and 11.9)	
G	5/2021	Added finishes for SDHA006 on page 6.3	463
H	2/2022	Updated dimension reference points, part numbers and 18mm DG Lock Machining on pages 10.11, 10.15 - 10.28	509
I	7/2022	Added Test Summary OT22-123 to page 4.4	524
J	2/2024	EcoFrame dedicated sill, head and jamb adaptors pg 5.3, 8.23, 8.24 and 9.7 No sill detail updated pg 8.8 and pg 8.19 Typical Detail pages rearranged Chapter 8 18mm Rail and Interlock machining pg10.29	578
K	7/2024	Added OT24-224 Test Summary to page 4.5	586

2. Technical Specifications

ALUMINIUM
Aluminium frames should be manufactred using Alspec's **PROVISTA SASHLESS DOUBLE HUNG WINDOW** framing system.

Refer to wind load tables for maximum sash widths and N ratings.

HARDWARE
All other hardware as per Aspec Technical Manual

FINISHED
- 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 PROVISTA SASHLESS DOUBLE HUNG WINDOW 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.

PERFORMANCE SUMMARY	
MAX ULS	4500PA
MAX WATER	458PA
MAX N GENERAL	N5 NON EXPOSED
MAX N CORNER	N5 NON EXPOSED
MAC C GENERAL	C2 EXPOSED
MAX C CORNER	C1 EXPOSED

SASH LIMITATIONS		
MAX SASH WEIGHT	HD PULLEY	100KG (50 EA. SASH)
	WIDE PULLEY	80KG (40 EA. SASH)
	SERVERY STD	50KG (25 EA. SASH)
	SERVERY HD	100KG (50 EA. SASH)
SASH HEIGHT	MIN.	350mm
	MAX.	1800mm
SASH WIDTH	MIN	350mm
	MAX	REFER TO MAX SASH WIDTH PGS: 3.1 -3.5

Loading Table Guide

The following pages contain wind pressure tables that may be used as a guide to the suitability of Alspec Aluminium Systems framing for various wind loads and frame sizes.

In most situations the Design Wind Pressure for a particular building should be available from the building designer or engineer.

Framing must be checked for suitability.

For a Sash Width, which is 750mm Wide and using Tough Glass, refer to the table below;
Step 1: Locate the Width
Step 2: Locate the Glass type
Step 3: Determine the Maximum wind pressure based on the Sash Width.

		Design Wind Pressure (kPa)	
Sash Width		Tough	La
600	S	6.8	6.1
	U	9	3.4
650	S	5.3	4.8
	U	7.7	2.9
700	S	4.3	3.8
	U	6.6	2.5
750	S	3.5	3.1
	U	5.8	2
800	S	2.8	2.6
	U	5.1	1.9

STEP 1 → 750
STEP 2 → Tough
STEP 3 → 750 (S, U)

3. Loading Tables

Loading Tables - Maximum Sash Width - 6mm

S = Serviceability limit state l/250

U = Ultimate limit state

Sash Width		Design Wind Pressure (kPa) Tough	Lam
600	S	6.8	6.1
	U	9	3.4
650	S	5.3	4.8
	U	7.7	2.9
700	S	4.3	3.8
	U	6.6	2.5
750	S	3.5	3.1
	U	5.8	2.2
800	S	2.8	2.6
	U	5.1	1.9
850	S	2.4	2.1
	U	4.5	1.7
900	S	2	1.8
	U	4	1.5
950	S	1.7	1.5
	U	3.6	1.4
1000	S	1.5	1.3
	U	3.2	1.2
1050	S	1.3	1.1
	U	2.9	1.1
1100	S	1.1	1
	U	2.7	1
1150	S	1	0.9
	U	2.5	0.9
1200	S	0.8	0.8
	U	2.3	0.8
1250	S	0.7	0.7
	U	2.1	0.8
1300	S	0.7	0.6
	U	1.9	0.7
1350	S	0.6	0.5
	U	1.8	0.7
1400	S	0.5	0.5
	U	1.7	0.6
1450	S	0.5	0.4
	U	1.5	0.6
1500	S	0.4	0.4
	U	1.4	0.5
1550	S	0.4	0.4
	U	1.4	0.5
1600	S	0.4	0.3
	U	1.3	0.5
1650	S	0.3	0.3
	U	1.2	0.4
1700	S	0.3	0.3
	U	1.1	0.4
1750	S	0.3	0.2
	U	1.1	0.4
1800	S	0.2	0.2
	U	1	0.4

NOTE:

Human Impact Requirements Apply To Sashless Windows With 6mm Glazing As Per AS1288 Section 5.15

All Windows Subject To Human Impact Shall Be Grade A Safety Glass With The Below Maximum Width:

6mm Tough: 1200mm
6mm Lam: 750mm

Tables are based on theoretical section properties

3. Loading Tables

Loading Tables - Maximum Sash Width - 10mm

S = Serviceability limit state l/250

U = Ultimate limit state

Sash Width		Design Wind Pressure (kPa) Tough	Lam
600	S	31.7	30.7
	U	22.9	9
650	S	24.9	24.1
	U	19.5	7.6
700	S	19.9	19.3
	U	16.8	6.6
750	S	16.2	15.7
	U	14.6	5.7
800	S	13.3	12.9
	U	12.9	5
850	S	11.1	10.8
	U	11.4	4.5
900	S	9.4	9.1
	U	10.2	4
950	S	8	7.7
	U	9.1	3.6
1000	S	6.8	6.6
	U	8.2	3.2
1050	S	5.9	5.7
	U	7.5	2.9
1100	S	5.1	5
	U	6.8	2.7
1150	S	4.5	4.3
	U	6.2	2.4
1200	S	3.9	3.8
	U	5.7	2.2
1250	S	3.5	3.4
	U	5.3	2.1
1300	S	3.1	3.0
	U	4.9	1.9
1350	S	2.8	2.7
	U	4.5	1.8
1400	S	2.5	2.4
	U	4.2	1.6
1450	S	2.2	2.2
	U	3.9	1.5
1500	S	2.0	2.0
	U	3.7	1.4
1550	S	1.8	1.8
	U	3.4	1.3
1600	S	1.7	1.6
	U	3.2	1.3
1650	S	1.5	1.5
	U	3.0	1.2
1700	S	1.4	1.3
	U	2.8	1.1
1750	S	1.3	1.2
	U	2.7	1.1
1800	S	1.2	1.1
	U	2.5	1.0

NOTE:

Human Impact Requirements Apply To Sashless Windows With 6mm Glazing As Per AS1288 Section 5.15

Tables are based on theoretical section properties

Loading Tables - Maximum Sash Width - General N Ratings

GENERAL RATING			MAX SASH WIDTH (mm)			
			6mm		10mm	
			TOUGH	LAM	TOUGH	LAM
N1	SLS	400	1538	1425	2572	2321
	ULS	600				
N2	SLS	400	1538	1164	2572	1895
	ULS	900				
N3	SLS	600	1344	933	2247	1519
	ULS	1400				
N4	SLS	800	1221	781	2029	1271
	ULS	2000				
N5	SLS	1200	1067	637	1656	1038
	ULS	3000				
N6	SLS	1600	N/A	N/A	N/A	N/A
	ULS	4000				
C1	SLS	600	1343	823	2138	1340
	ULS	1800				
C2	SLS	800	1097	672	1746	1094
	ULS	2700				
C3	SLS	1200	N/A	N/A	N/A	N/A
	ULS	4000				
C4	SLS	1600	N/A	N/A	N/A	N/A
	ULS	5300				

NOTE:

Human Impact Requirements Apply To Sashless Windows With 6mm Glazing As Per AS1288 Section 5.15

All Windows Subject To Human Impact Shall Be Grade A Safety Glass With The Below Maximum Width:

6mm Tough: 1200mm
6mm Lam: 750mm

Tables are based on theoretical section properties

Loading Tables - Maximum Sash Width - Corner N Ratings

CORNER RATING			MAX SASH WIDTH (mm)			
			6mm		10mm	
			TOUGH	LAM	TOUGH	LAM
N1	SLS	600	1344	1164	2247	1895
	ULS	900				
N2	SLS	600	1344	968	2247	1577
	ULS	1300				
N3	SLS	800	1221	781	2029	1271
	ULS	2000				
N4	SLS	1200	1040	637	1784	1271
	ULS	3000				
N5	SLS	1800	849	520	1352	847
	ULS	4500				
N6	SLS	2500	N/A	N/A	N/A	N/A
	ULS	6000				
C1	SLS	800	1097	672	1746	1094
	ULS	2700				
C2	SLS	1200	N/A	N/A	N/A	N/A
	ULS	4000				
C3	SLS	1800	N/A	N/A	N/A	N/A
	ULS	5900				
C4	SLS	2500	N/A	N/A	N/A	N/A
	ULS	8000				

NOTE:

Human Impact Requirements Apply To Sashless Windows With 6mm Glazing As Per AS1288 Section 5.15

All Windows Subject To Human Impact Shall Be Grade A Safety Glass With The Below Maximum Width:

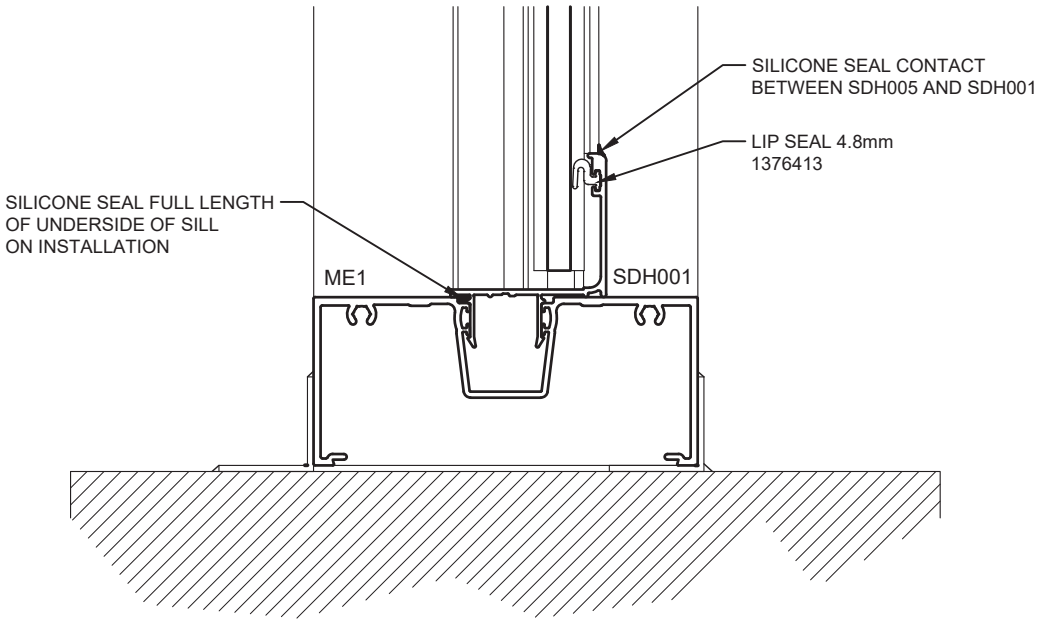
6mm Tough: 1200mm
6mm Lam: 750mm

Tables are based on theoretical section properties

4. Test Summary

AS2047 - 6mm Single Glazed 2 Pane

TEST REPORT:	AS18-351
SYSTEM CONFIGURATION	XX - SDH007 STILE 6mm, SDH001 SILL
TEST SAMPLE SIZE	2.1m High x 0.9m Wide
ULTIMATE LOAD	+/- 4573 Pa
WATER PENETRATION	304 Pa
AIR INFILTRATION	75Pa + 2.08 L/ms^2 - 2.44 L/ms^2
OPERATING FORCE TEST **INITIATING MOVEMENT** **SUSTAINING MOVEMENT**	 87 N 78.1 N

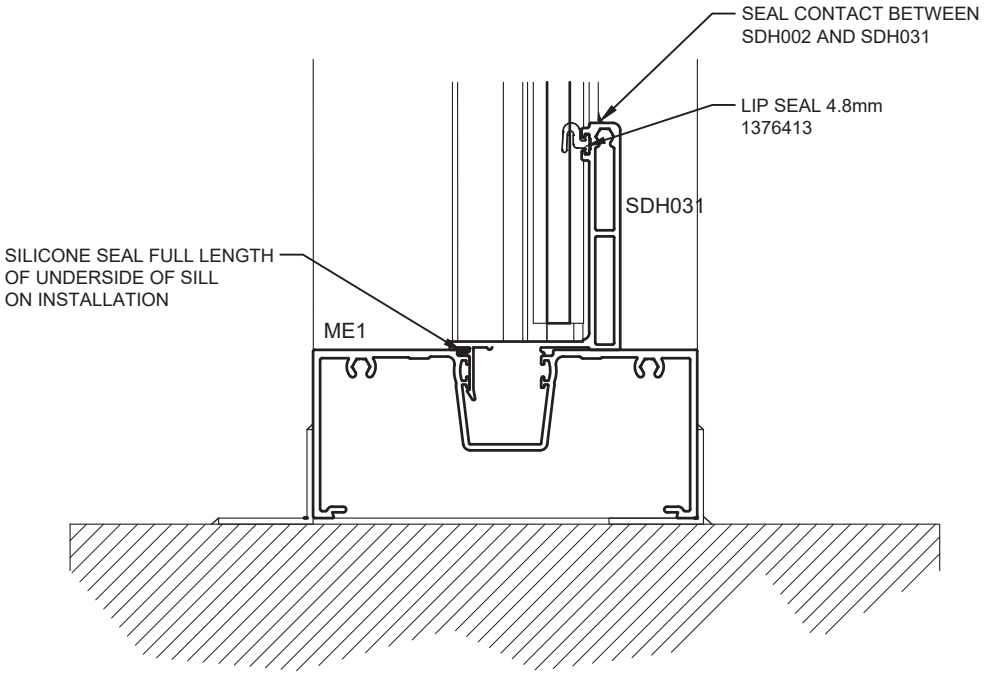


DISCLAIMER:
Please note that the test results shown above reflect specific configurations of a system and are representative only. If a specific high wind load or a different configuration (i.e. changes to frames, transoms, mullions) is required on a project please discuss with Alspec prior to commencement.

4. Test Summary

AS2047 - 6mm Single Glazed 2 Pane

TEST REPORT:	OT20-007
SYSTEM CONFIGURATION	XX - SDH007 STILE 6mm, SDH031 SILL, SDHA022 PULLEY WATER CAP
TEST SAMPLE SIZE	2.1m High x 0.9m Wide
ULTIMATE LOAD	+/- 3038 Pa
WATER PENETRATION	458 Pa
AIR INFILTRATION	75Pa + 0.97 L/ms^2 - 0.97 L/ms^2
OPERATING FORCE TEST **INITIATING MOVEMENT** **SUSTAINING MOVEMENT**	 68.1 N 41.9 N



NOTE:
1. SDH031 obsolete, substitute SDH032 with ME8 and screw fix with 6G x 1/2 (13mm) Countersunk Screws with 4G Head

DISCLAIMER:
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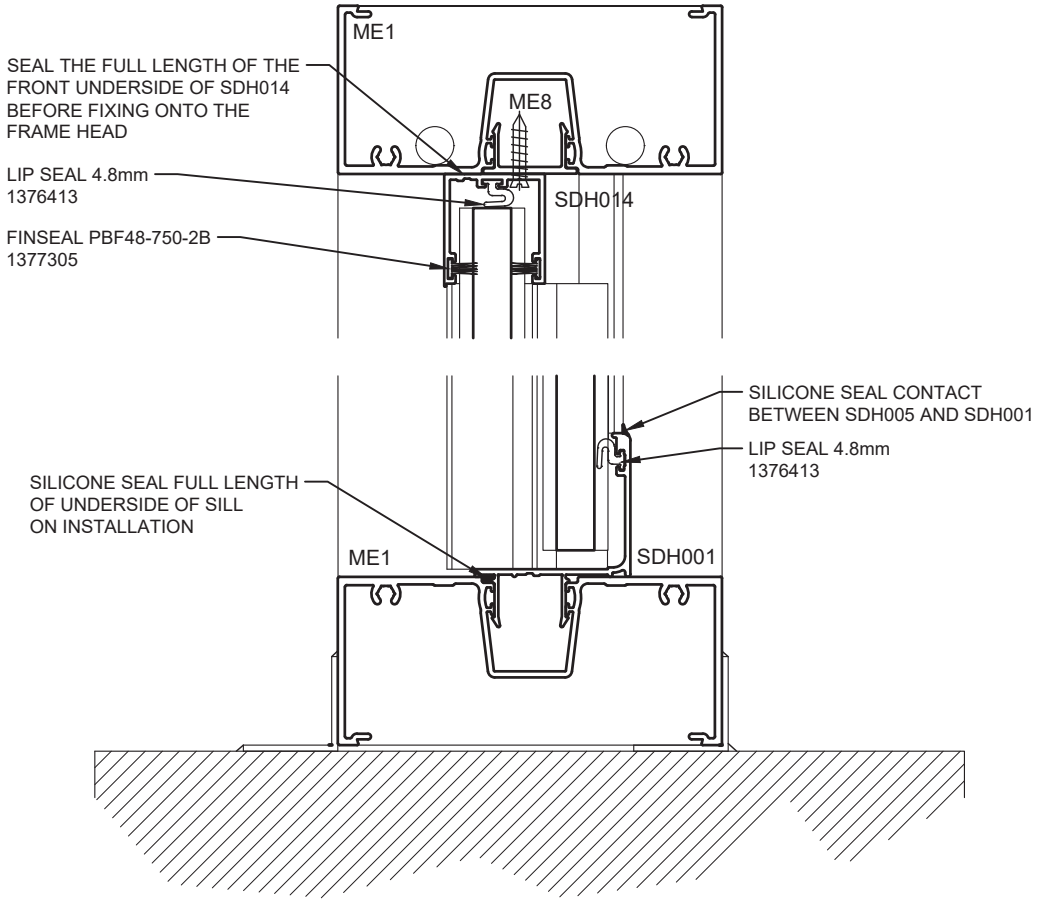
4. Test Summary

AS2047 - 10mm Single Glazed 2 Pane

TEST REPORT:	AS19-376
WINDOW TYPE & GLASS	XX - SDH017 STILE 10mm, SDH001 SILL
TEST SAMPLE SIZE	1.8m High x 0.9m Wide
ULTIMATE LOAD	+/- 4507 Pa
WATER PENETRATION	302 Pa
AIR INFILTRATION	75Pa + 2.49 L/ms^2 - 3.12 L/ms^2
OPERATING FORCE TEST **INITIATING MOVEMENT** **SUSTAINING MOVEMENT**	 70.5 N 65 N



DISCLAIMER:
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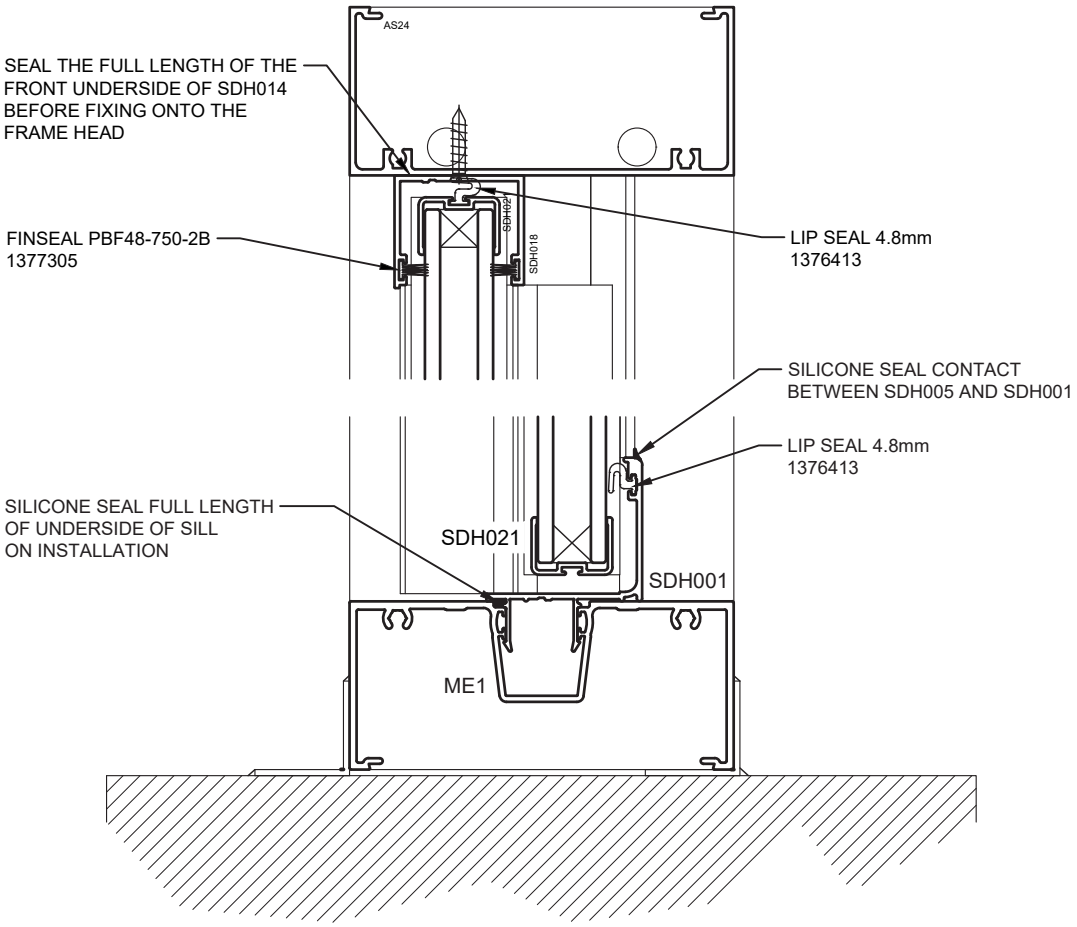
4. Test Summary

AS2047 - 18mm Double Glazed 2 Pane

TEST REPORT:	OT22-123
SYSTEM CONFIGURATION	XX - SDH024 STILE 18mm SDH001 SILL
TEST SAMPLE SIZE	2.1m High x 0.9m Wide
ULTIMATE LOAD	+/- 2004 Pa
WATER PENETRATION	245 Pa
AIR INFILTRATION	75Pa + 3.54 L/ms^2 - 4.16 L/ms^2
OPERATING FORCE TEST **INITIATING MOVEMENT** **SUSTAINING MOVEMENT**	 137.1 N 58.3 N

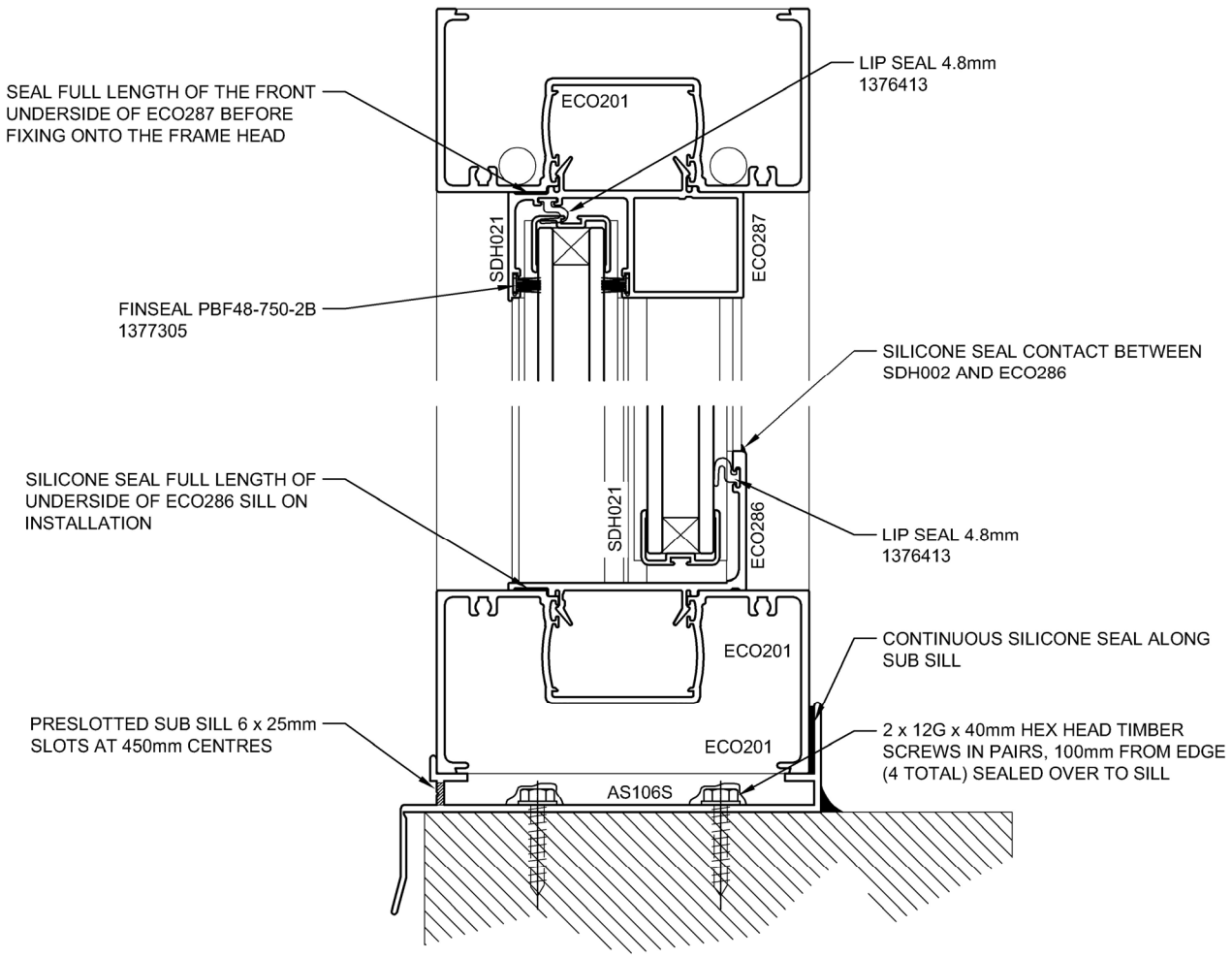


DISCLAIMER:
Please note that the test results shown above reflect specific configurations of a system and are representative only. If a specific high wind load or a different configuration (i.e. changes to frames, transoms, mullions) is required on a project please discuss with Alspec prior to commencement.

4. Test Summary

AS2047 - 18mm Double Glazed 2 Pane with ecoFRAMEplus Adaptors

TEST REPORT:	OT24-224
SYSTEM CONFIGURATION	XX - SDH024 STILE 18mm SDH022 Interlock ECO286 SILL AS106S Sub Sill
TEST SAMPLE SIZE	2.11m High x 0.91 Wide
ULTIMATE LOAD	+/- 4005 Pa
WATER PENETRATION	202 Pa
AIR INFILTRATION	75Pa + 2.91 L/ms^2 - 3.96 L/ms^2
OPERATING FORCE TEST **INITIATING MOVEMENT** **SUSTAINING MOVEMENT**	 107.8 N 31.1 N



DISCLAIMER:
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4. Test Summary

Acoustic - AS/NZS ISO 717.1

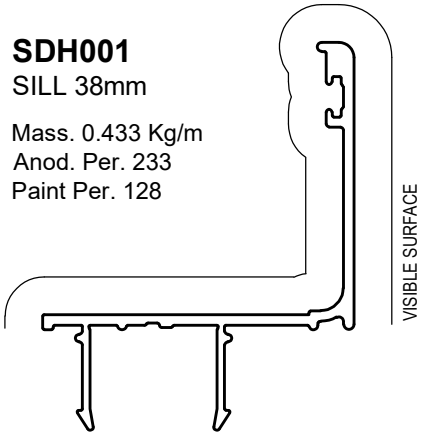
TEST REPORT	PRODUCT DESCRIPTION	SIZE	GLASS	SEALS	Rw
TL660-04-1	F/XX 6.38 LAM	1200mm (H) x 1800mm (W)	6.38mm LAM	PBF 48-750-2P PBF 48-900-2P LIP SEAL 4.8mm PBF 48-475-2P	28 (-1; -2)
TL660-06-1	F/XX 10.38 LAM	1200mm (H) x 1800mm (W)	10.38mm LAM	PBF 48-750-2P PBF 48-900-2P LIP SEAL 4.8mm PBF 48-475-2P	29 (-1; -1)
TL660-07-1	F/XX 10.38 LAM	1200mm (H) x 1800mm (W)	10.38mm LAM	PBF 48-750-2P PBF 48-900-2P LIP SEAL 4.8mm PBF 48-475-2P	31 (-1; -2)
TL636-08-1	Carinya Awning 6.38 LAM I 100mm Air Gap I ProVista XX 6.38 LAM with F/F Side Lite	1200mm (H) x 1800mm (W)	6.38mm LAM	GR61 CE49 CO-EXT GR47 CE7 BULB SEAL LIP SEAL 4.8mm PBF 48-750-2P PBF 48-900-2P	47 (-2; -5)

BAL40 - AS 1530.8.1-2007

TEST REPORT	PRODUCT DESCRIPTION	SIZE	GLASS	SEALS	RESULT
FRT180018.3	XX 6mm TOUGH	800mm (H) x 750mm (W)	6mm TOUGH	PBF 48-550-2B QLON48650FR CE7FR SDH026 BAL40 Stile	BAL40

5. Extrusions

Frame Adaptors



SDH001
SILL 38mm

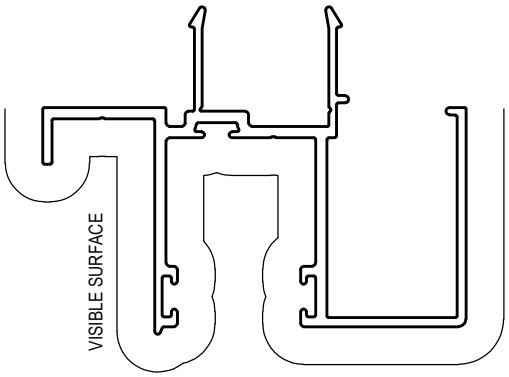
Mass. 0.433 Kg/m
Anod. Per. 233
Paint Per. 128

SDH009
SILL (NO LEGS)

Mass. 0.348 Kg/m
Anod. Per. 174
Paint Per. 116

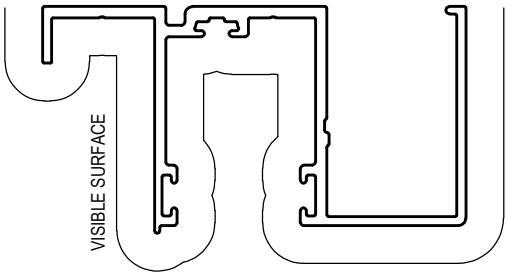
SDH032
SILL NO LEGS
60mm

Mass. 0.793 Kg/m
Anod. Per. 221
Paint Per. 165



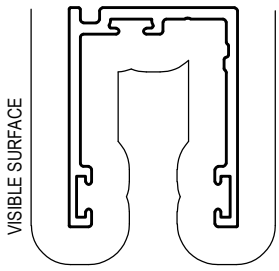
SDH004
HEAD 6mm

Mass. 0.681 Kg/m
Anod. Per. 388
Paint Per. 137



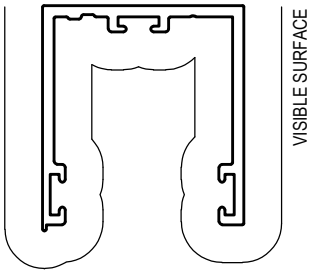
SDH010
HEAD 6mm (NO LEGS)

Mass. 0.605 Kg/m
Anod. Per. 329
Paint Per. 179



SDH011
6mm ACOUSTIC
HEAD/SILL

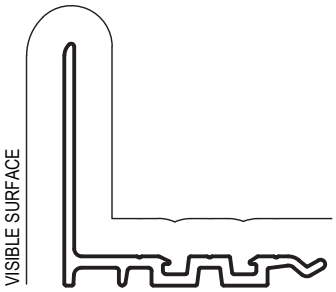
Mass. 0.349 Kg/m
Anod. Per. 189
Paint Per. 132



SDH014
SDH HEAD 10mm

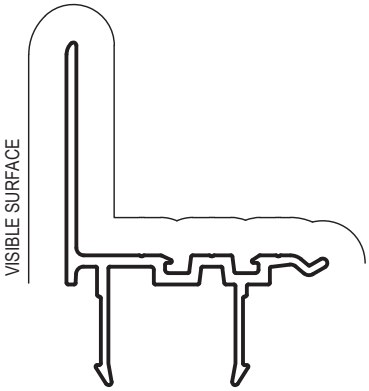
Mass. 0.373 Kg/m
Anod. Per. 200
Paint Per. 139

Frame Adaptors



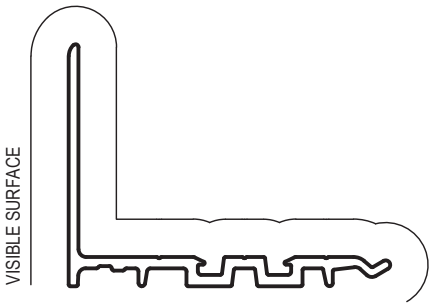
SDH005
JAMB OUTER LEG 6mm

Mass. 0.289 Kg/m
Anod. Per. 155
Paint Per. 100



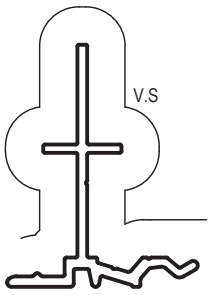
SDH012
JAMB OUTER 6mm CLIP IN

Mass. 0.373 Kg/m
Anod. Per. 209
Paint Per. 100



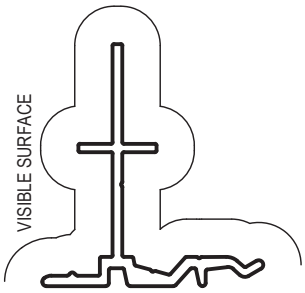
SDH015
JAMB OUTER LEG 10mm

Mass. 0.329 Kg/m
Anod. Per. 175
Paint Per. 103



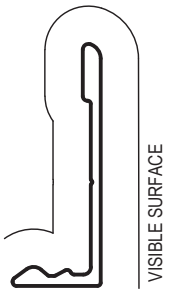
SDH006
JAMB ADD-ON LEG 6mm

Mass. 0.245 Kg/m
Anod. Per. 138
Paint Per. 106



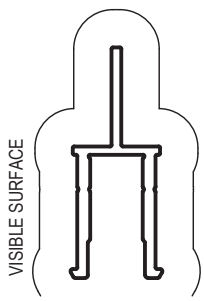
SDH016
JAMB ADD-ON LEG 10mm

Mass. 0.272 Kg/m
Anod. Per. 148
Paint Per. 107



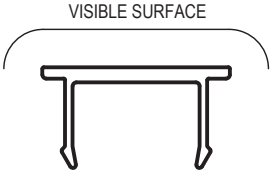
SDH002
JAMB INNER LEG

Mass. 0.181 Kg/m
Anod. Per. 100
Paint Per. 100



SDH003
JAMB RUNNER

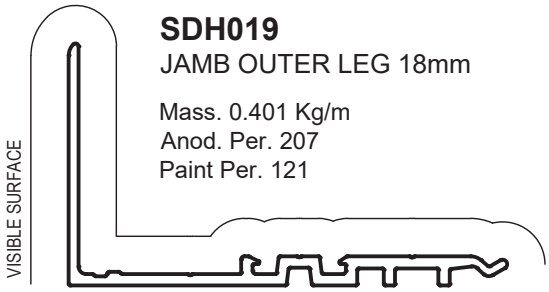
Mass. 0.226 Kg/m
Anod. Per. 118
Paint Per. 100



ME8
POCKET FILLER

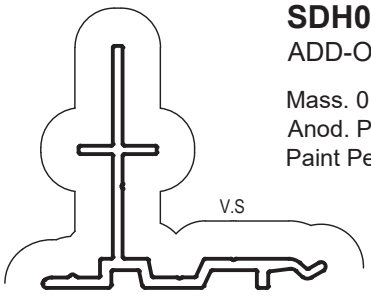
Mass. 0.181 Kg/m
Anod. Per. 100
Paint Per. 100

Frame Adaptors



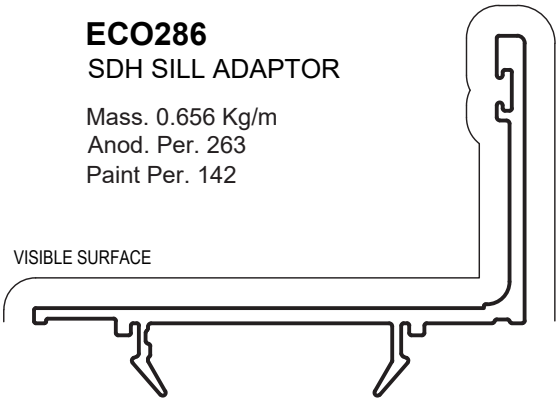
SDH019
JAMB OUTER LEG 18mm

Mass. 0.401 Kg/m
Anod. Per. 207
Paint Per. 121



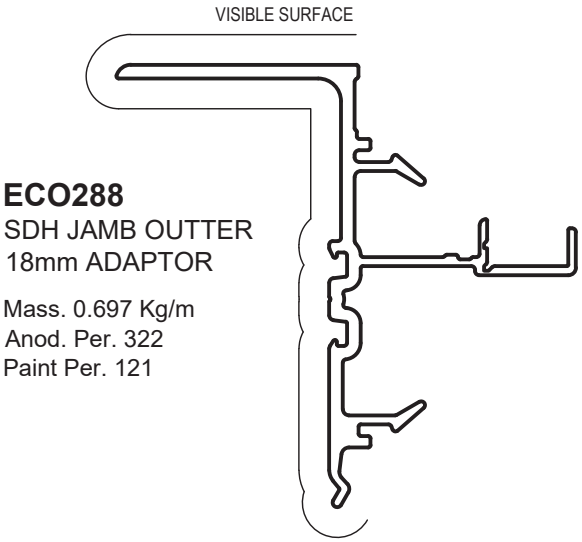
SDH020
ADD-ON LEG 18mm

Mass. 0.305 Kg/m
Anod. Per. 167
Paint Per. 103



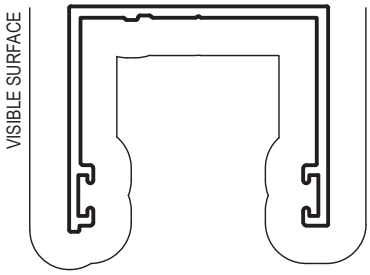
ECO286
SDH SILL ADAPTOR

Mass. 0.656 Kg/m
Anod. Per. 263
Paint Per. 142



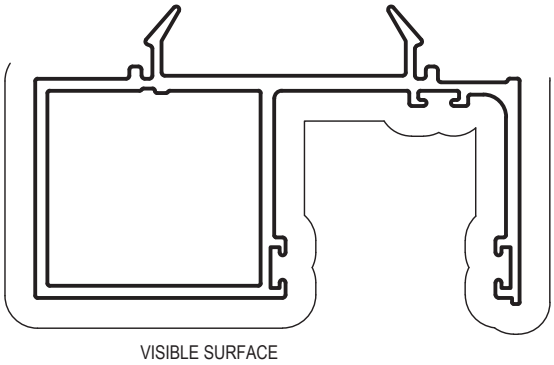
ECO288
SDH JAMB OUTTER
18mm ADAPTOR

Mass. 0.697 Kg/m
Anod. Per. 322
Paint Per. 121



SDH018
HEAD 18mm

Mass. 0.391 Kg/m
Anod. Per. 205
Paint Per. 150

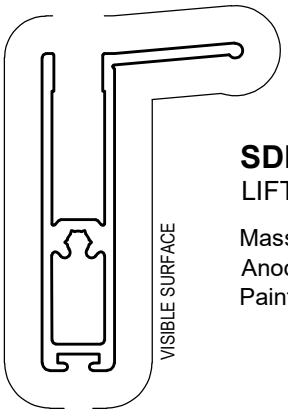


ECO287
SDH HEAD 18mm ADAPTOR

Mass. 0.941 Kg/m
Anod. Per. 316
Paint Per. 179

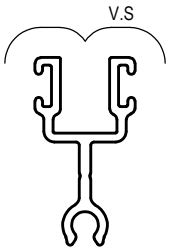
5. Extrusions

Sash



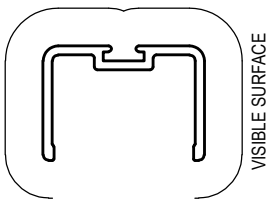
SDH008
LIFT RAIL 6mm

Mass. 0.477 Kg/m
Anod. Per. 192
Paint Per. 121



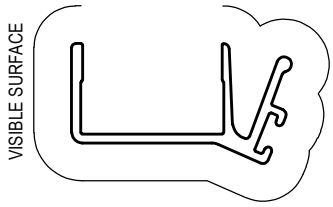
SDH026
BAL40 STILE 6mm

Mass. 0.208 Kg/m
Anod. Per. 125
Paint Per. 100



SDH021
RAIL 18mm

Mass. 0.176 Kg/m
Anod. Per. 110
Paint Per. 100

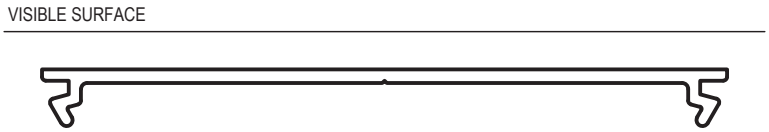


SDH022
INTERLOCK 18mm

Mass. 0.229 Kg/m
Anod. Per. 135
Paint Per. 100

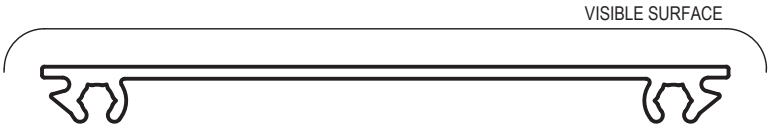
5. Extrusions

Frame



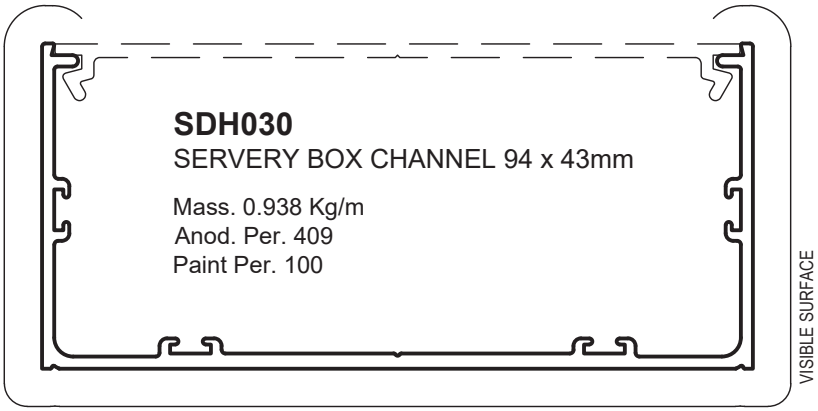
AS5
FLUSH ADAPTOR

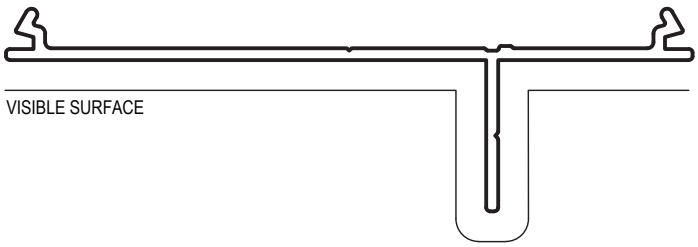
Mass. 0.500 Kg/m
Anod. Per. 213
Paint Per. 100



AS5F
FLUSH ADAPTOR WITH SCREW FLUTES

Mass. 0.538 Kg/m
Anod. Per. 231
Paint Per. 100





AS221
20mm REVEAL ADAPTOR

Mass. 0.522 Kg/m
Anod. Per. 250
Paint Per. 100

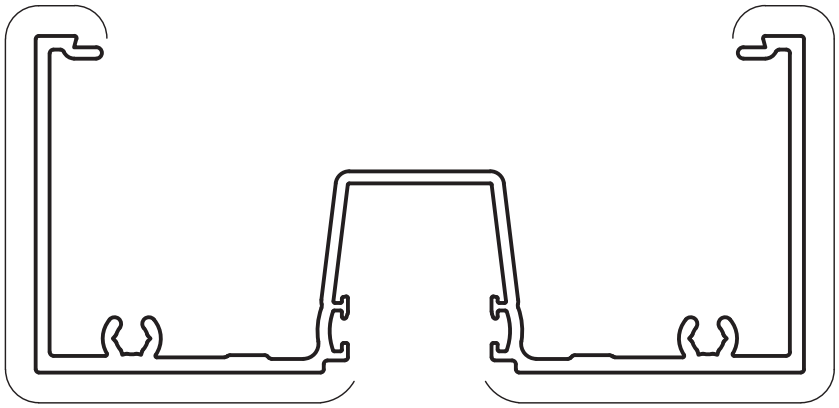
AS60
100mm INTERNAL COUPLER

Mass. 0.752 Kg/m
Anod. Per. 281
Paint Per. 0

Ixx = 249 x 10^3 mm^4

5. Extrusions

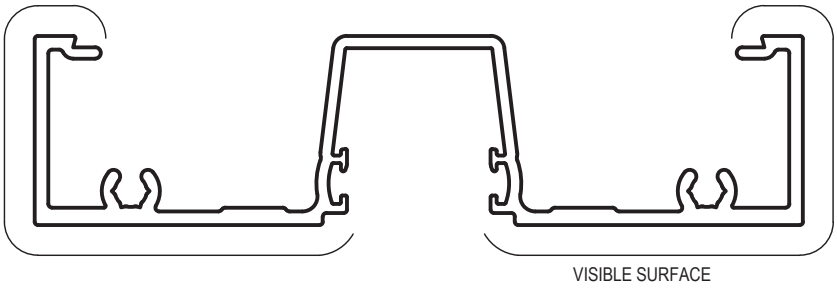
Frame



ME1
FRAME / JAMB

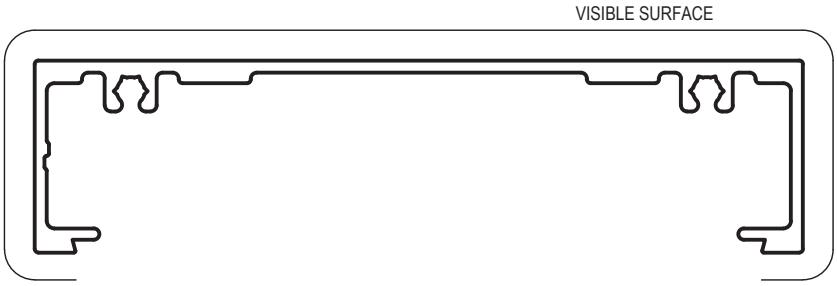
Mass. 1.365 Kg/m
Anod. Per. 560
Paint Per. 182

Ixx = 695.7 x 10^3 mm^4



ME22
25mm NARROW FRAME

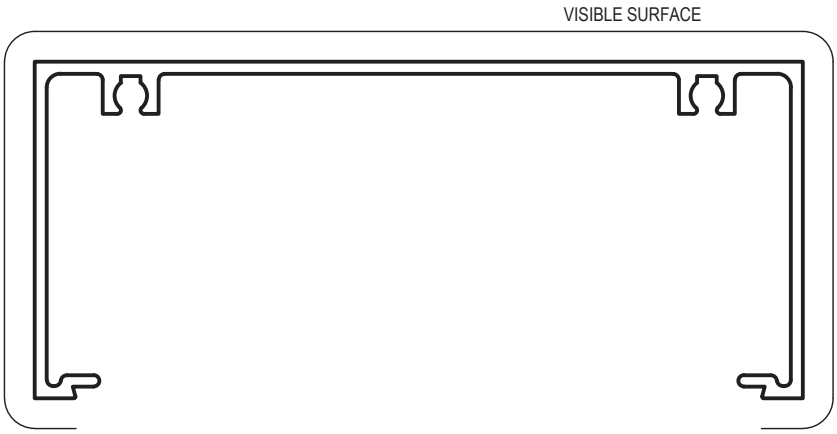
Mass. 1.155 Kg/m
Anod. Per. 475
Paint Per. 143



AS23
25mm PLAIN FRAME

Mass. 0.961 Kg/m
Anod. Per. 367
Paint Per. 163

Ixx = 513.44 x 10^3 mm^4



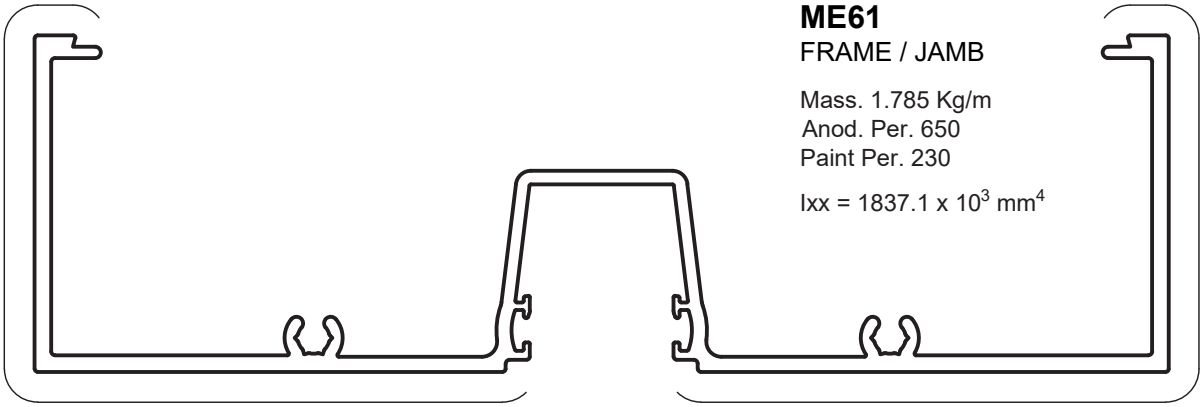
AS24
PLAIN FRAME

Mass. 1.010 Kg/m
Anod. Per. 446
Paint Per. 201

Ixx = 606.3 x 10^3 mm^4

5. Extrusions

Frame



ME61
FRAME / JAMB

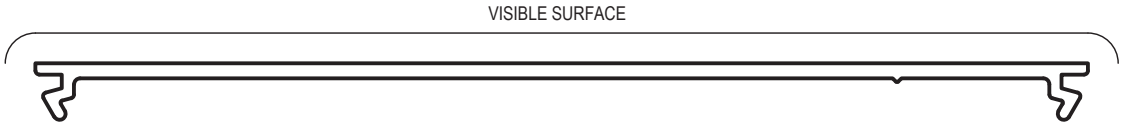
Mass. 1.785 Kg/m
Anod. Per. 650
Paint Per. 230

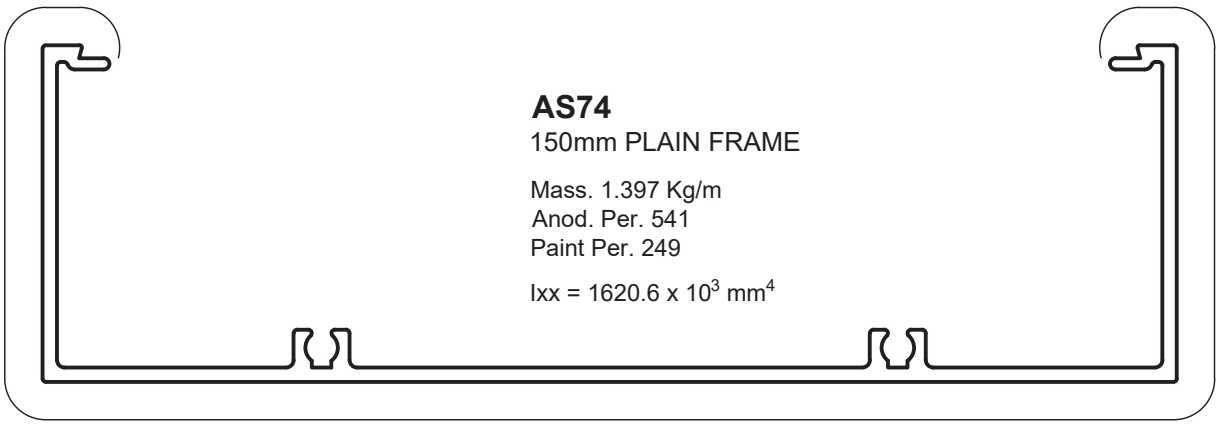
Ixx = 1837.1 x 10^3 mm^4

AS605
150mm FLUSH ADAPTOR

Mass. 0.810 Kg/m
Anod. Per. 310
Paint Per. 140

Ixx = 539.1 x 10^3 mm^4

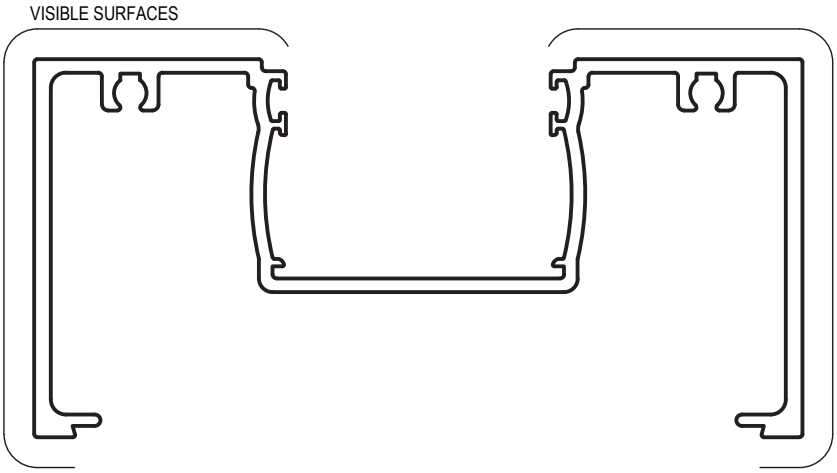




AS74
150mm PLAIN FRAME

Mass. 1.397 Kg/m
Anod. Per. 541
Paint Per. 249

Ixx = 1620.6 x 10^3 mm^4



ECO201
101.6mm DG FRAME

Mass. 1.592 Kg/m
Anod. Per. 602
Paint Per. 180

Ixx = 858.76 x 10^3 mm^4
Iyy = 142.04 x 10^3 mm^4

ECO204
101.6mm DG POCKET INFILL

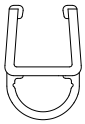
Mass. 0.741 Kg/m
Anod. Per. 320
Paint Per. 100

Ixx = 193.60 x 10^3 mm^4
Iyy = 14.20 x 10^3 mm^4

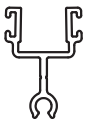
Sash PVC Components

SDH007 STILE PVC 6mm x 3m	
PART	1607407
FINISH	BLACK (034)
QTY	LENGTH

SDHA013 LAP SEAL 6mm x 3m	
PART	1378813
FINISH	CLEAR (0Z1)
QTY	EACH

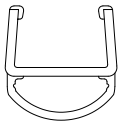


SDHA023 SERVERY SEAL 6mm x 2.6mm	
PART	1379703
FINISH	CLEAR (0Z1)
QTY	EACH

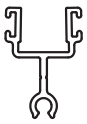


SDH017 STILE PVC 10mm x 3m	
PART	1607417
FINISH	BLACK (034)
QTY	LENGTH

SDHA014 LAP SEAL 10mm x 3m	
PART	1378814
FINISH	CLEAR (0Z1)
QTY	LENGTH



SDHA024 SERVERY SEAL 10mm x 2.6m	
PART	1379704
FINISH	CLEAR (0Z1)
QTY	EACH



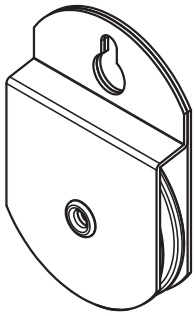
SDH024 STILE PVC 18mm x 3m	
PART	1607423
FINISH	BLACK (034)
QTY	LENGTH

SDHA021 LAP SEAL FR 6mm x 3m	
PART	1378501
FINISH	CLEAR (0Z1)
QTY	EACH

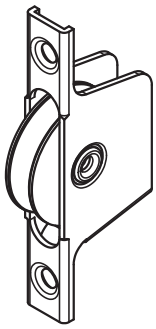
6. Hardware & Components

Sash Hardware Components

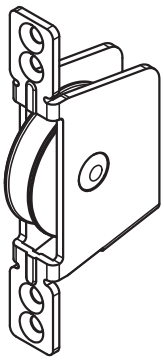
SDHA015 PULLEY HEAVY DUTY 100kg	
PART	1378815
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



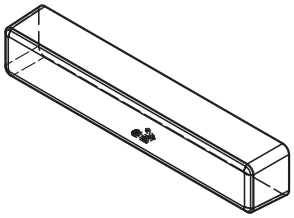
SDHA002 PULLEY WIDE 80kg	
PART	1378802
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



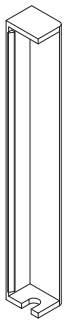
SDHA003 SERVERY STANDARD 50kg	
PART	1378803
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



SDHA004 SERVERY HD 100kg	
PART	1378804
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



SDHA012 ACRYLIC HANDLE	
PART	1378812
FINISH	TRANSPARENT (050)
QTY	EACH

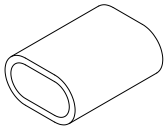


Note: Required for 450Pa water, see page 11.13; for 6mm glazed frames only

SDHA022 PULLEY WATER CAP	
PART	1379702
FINISH	BLACK (034)
QTY	EACH

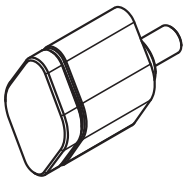
SDHA017 CORD RACESPEC BRAID 3mm 400kg		
PART	1378957	1378001
FINISH	BLACK (034)	BLACK (034)
QTY	ROLL (100m)	METRE

SDHA025 WIRE SS316 2mm x 20m	
PART	1379705
FINISH	STAINLESS STEEL (0G8)
QTY	ROLL

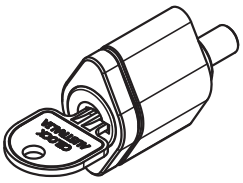


SDHA026 SWAGE SLEEVE 2mm	
PART	1379706
FINISH	STAINLESS STEEL (0G8)
QTY	EACH

Sash Lock Components



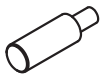
SDHA005 DIAMOND PUSH LOCK KEYLESS	
PART	1378805
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



SDHA006 DIAMOND PUSH LOCK KEYED SSS	
PART	1378806
FINISH	STAINLESS STEEL (0G8)
QTY	EACH

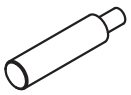
SDHA006 DIAMOND PUSH LOCK KEYED SATIN BLK	
PART	1379709
FINISH	SATIN BLACK (059)
QTY	EACH

SDHA006 DIAMOND PUSH LOCK KEYED PW	
PART	1379710
FINISH	PEARL WHITE GLOSS (0UI)
QTY	EACH



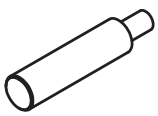
Note: used for 6mm glazed frames

SDHA007 EXTENSION BOLT 17mm	
PART	1378807
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



Note: used for 10mm glazed frames

SDHA008 EXTENSION BOLT 26mm	
PART	1378808
FINISH	STAINLESS STEEL (0G8)
QTY	EACH



Note: used for 18mm glazed frames

SDHA009 EXTENSION BOLT 42mm	
PART	1378809
FINISH	STAINLESS STEEL (0G8)
QTY	EACH

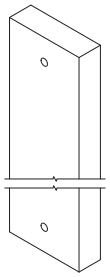
Note: used for 18mm glazed frames

SDHA010 EXTENSION BOLT 12mm	
PART	1378950
FINISH	STAINLESS STEEL (0G8)
QTY	EACH

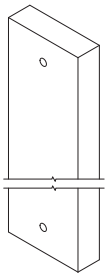
6. Hardware & Components

Servery Components

SETTING BLOCK 10 x 13 x 75mm BAG OF 50	
PART	1376762
FINISH	BLACK (034)
QTY	BAG



SDHA019 STEEL PLATE 65 x 20 x 1.5m	
PART	1379701
FINISH	NOT SPECIFIED (099)
QTY	EACH

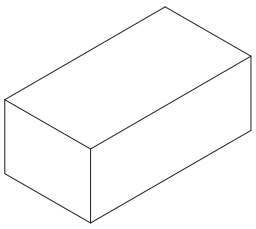


SDHA020 STEEL PLATE 70 x 25 x 1.5m	
PART	1379700
FINISH	NOT SPECIFIED (099)
QTY	EACH

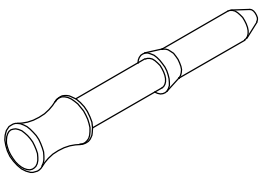
SDHA028 STEEL PLATE FRONT BUMPER	
PART	1379708
FINISH	BLACK (034)
QTY	ROLL (100m)

SDHA027 STEEL PLATE SIDE & BACK BUMPER	
PART	1379707
FINISH	BLACK (034)
QTY	ROLL (250m)

Screening Components



RDHA8 FLYSCREEN TENSION BLOCK 16 x 10 x 30mm (600m)	
PART	1315048
FINISH	BLACK (034)
QTY	ROLL



PLASTIC PLUNGER PIN		
PART	1320008	1311061
FINISH	BLACK (034)	BLACK (034)
QTY	EACH (500)	EACH

6. Hardware & Components

Seals

IMAGE	PART #	FINISH	DESCRIPTION
	1377305	BLACK (034)	PBF48-750-2B FINSEAL T-SLOT x 300m
	1377307		PBF48-750-2B FINSEAL T-SLOT x 1m
	1377312	GREY (036)	PBF48-900-2B FINSEAL T-SLOT x 300m
	1377314		PBF48-900-2 FINSEAL T-SLOT X 1m
	1377301	BLACK (034)	PBF48-550-2B FINSEAL T-SLOT x 450m
	1377309		PBF48-550-2B FINSEAL T-SLOT x 1m
	1377603	BLACK (034)	QLON SEAL FIRE RETARDANT x 1m
	1376459	BLACK (034)	CE7FR CO-EXT BULB SEAL (7mm DIA) F/RES x 200m
	1376413	BLACK (034)	LIP SEAL 4.8mm x 200m
	1376414		LIP SEAL 4.8mm x 1m

Fasteners

SCREWS			
PART #	HEAD	DESCRIPTION	LOCATION
1382617	PHILLIPS	6g x 1/2 (13mm) SS PHIL #2 CSK 4g HEAD x 1000	SASHLESS FRAME SECTIONS TO MAIN FRAME SECTIONS & FIXED SASH FIXING TO FRAME
1382093	PHILLIPS	6g x 3/4 (19mm) SS PHIL CSK 4g HEAD x 1000	
1382044	PHILLIPS	8g x 3/4 (19mm) SS PHIL PAN S/TAP SCREW x 1000	SERVERY BOX TO FRAME
1382653	SQUARE	8g x 1 (25mm) 304SS SQ #2 CSK S/TAP SCREW x 1000	FIXED PANEL SETTING BLOCK & SERVERY PULLEY FIXINGS
1382014	PHILLIPS	8g x 1 (25mm) SS PHILLIPS CSK S/TAP x 500	
1382654	SQUARE	8g x 1 1/4 (32mm) 304SS SQ #2 CSK S/TAP x 1000	SASHLESS FRAME SECTIONS TO DOOR PANELS
1382654	PHILLIPS	8g x 1 1/4 (32mm) SS PHILLIPS CSK S/TAP x 200	
1382656	SQUARE	8g x 2 (51mm) 304SS SQ #2 CSK S/TAP SCREW x 1000	STD PULLEY FIXINGS WIDE PULLEY FIXINGS
1382018	PHILLIPS	8g x 2 (51mm) SS PHILLIPS CSK S/TAP SCREW x 200	
1382052	PHILLIPS	8g x 2 (51mm) SS PHILLIPS PAN S/TAP SCREW x 500	

6. Hardware & Components

Silicone

100% NEUTRAL CURE SILICONE

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

100% MATTE NEUTRAL CURE SILIICONE

- 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

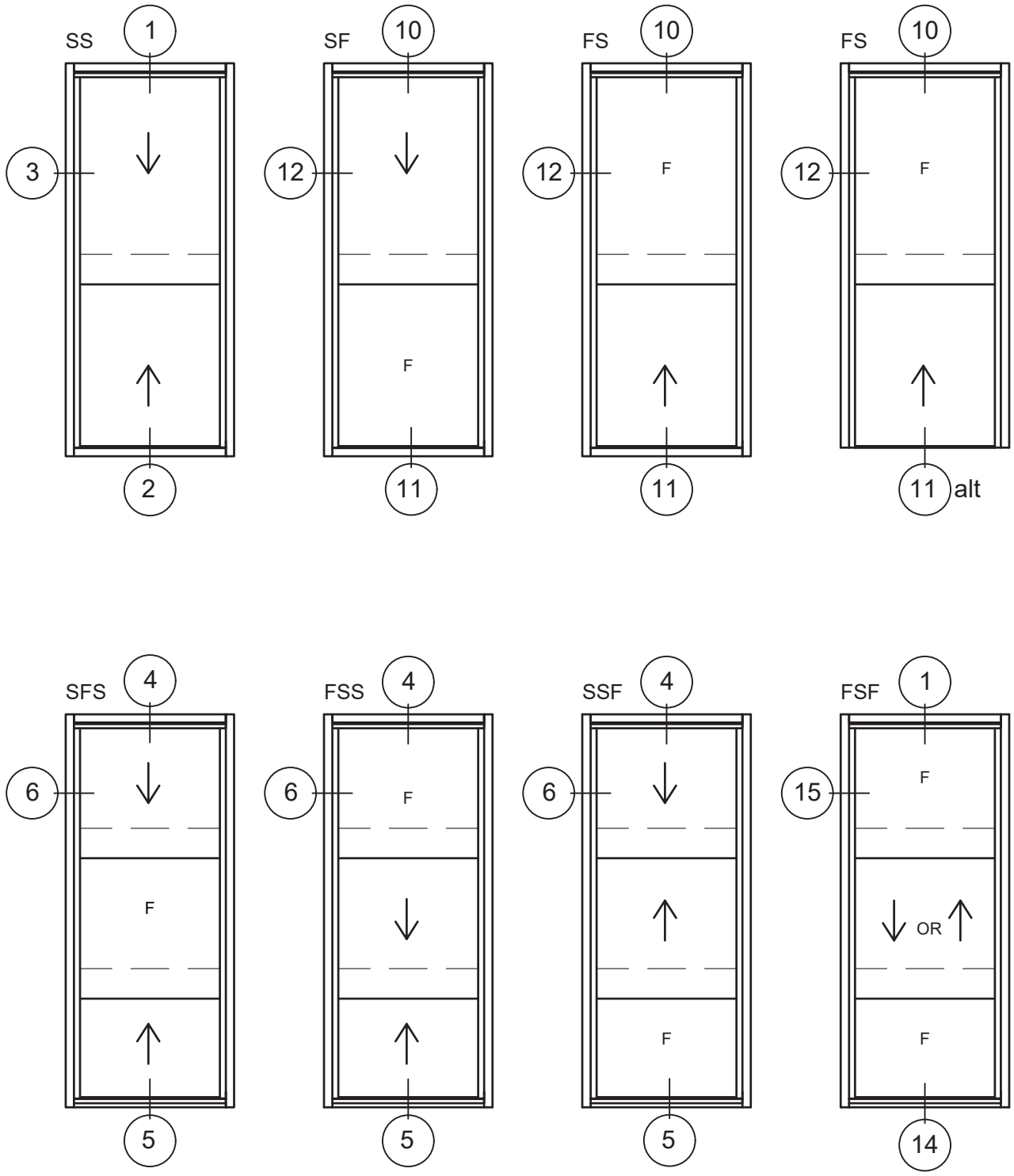
- Premium 100% silicone
- UV Stable
- 2-5 minute skin time
- Flexible + 25%
- No slump

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

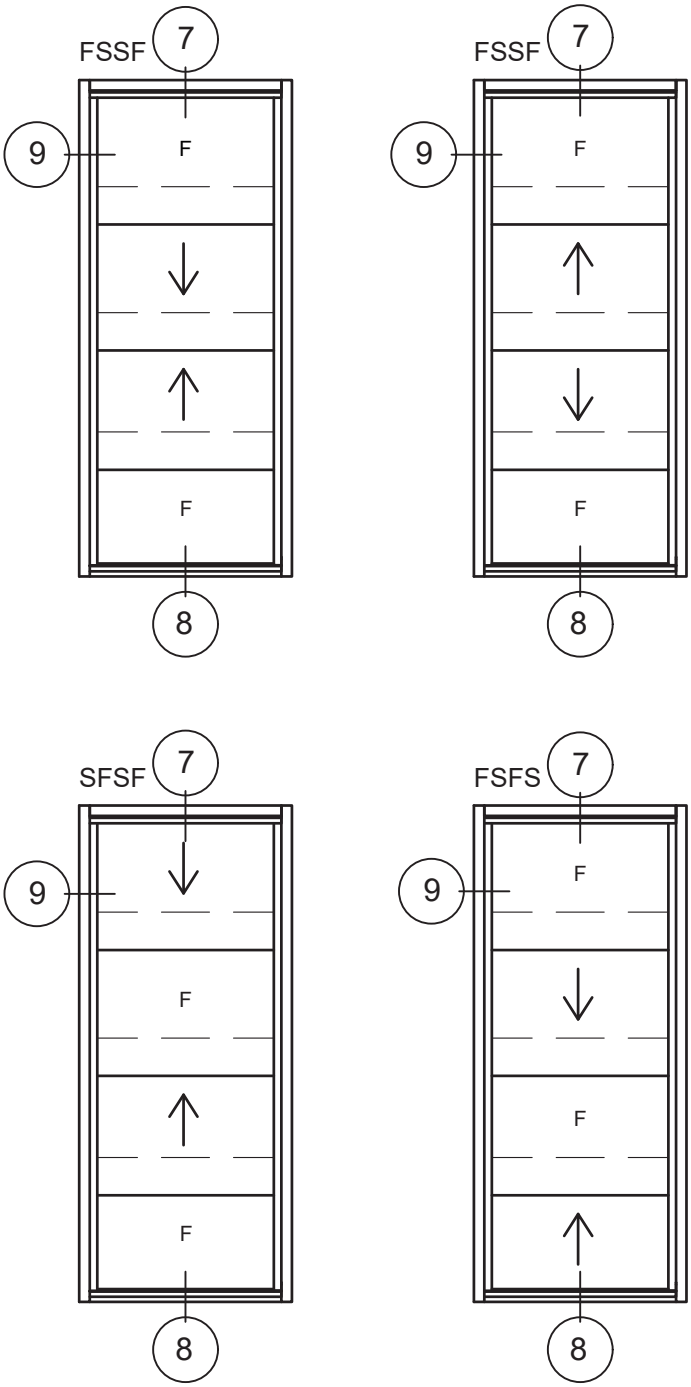
Silicone Product Codes

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

7. Typical Elevation

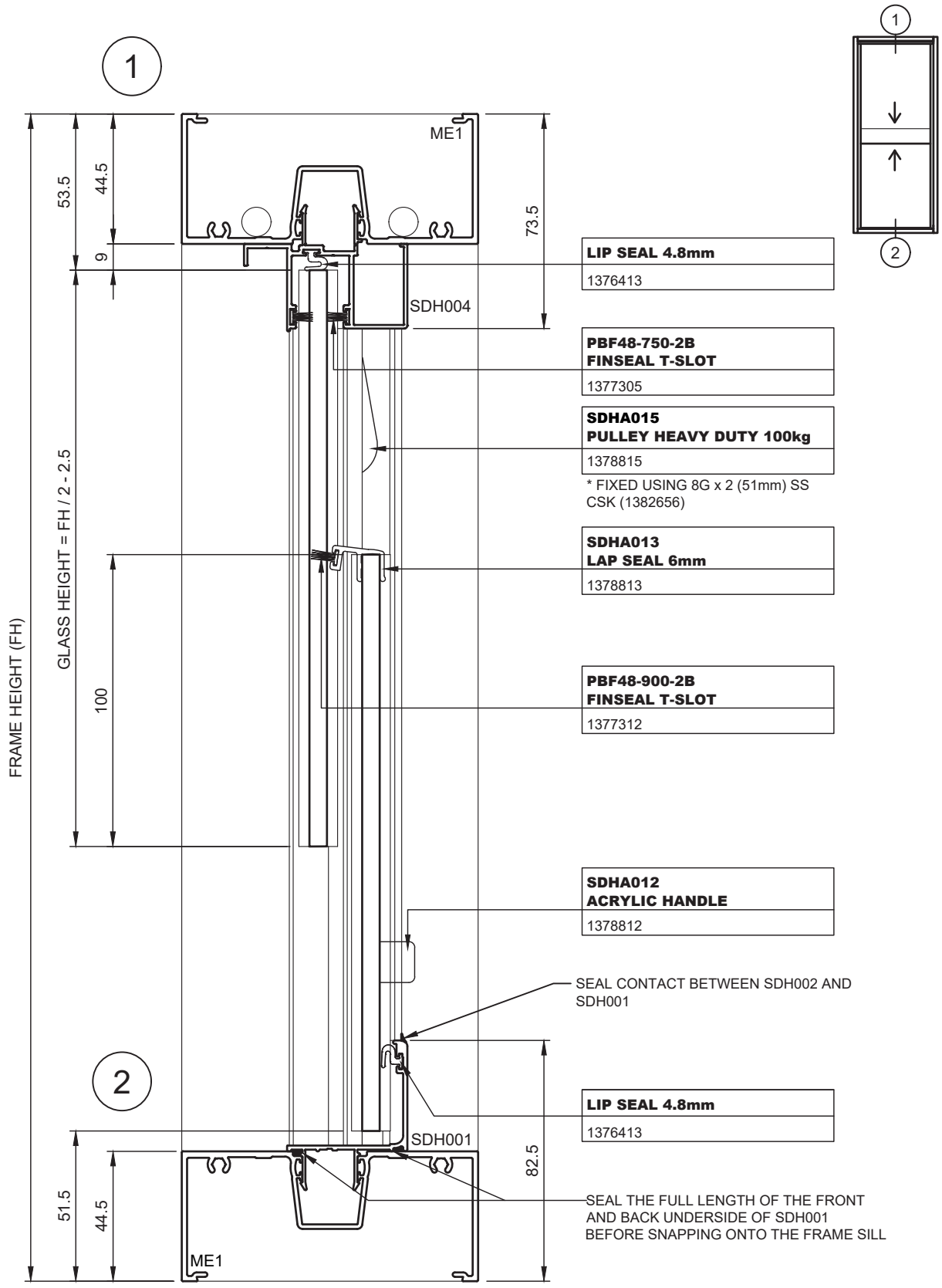


7. Typical Elevation



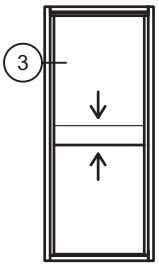
8. Typical Details

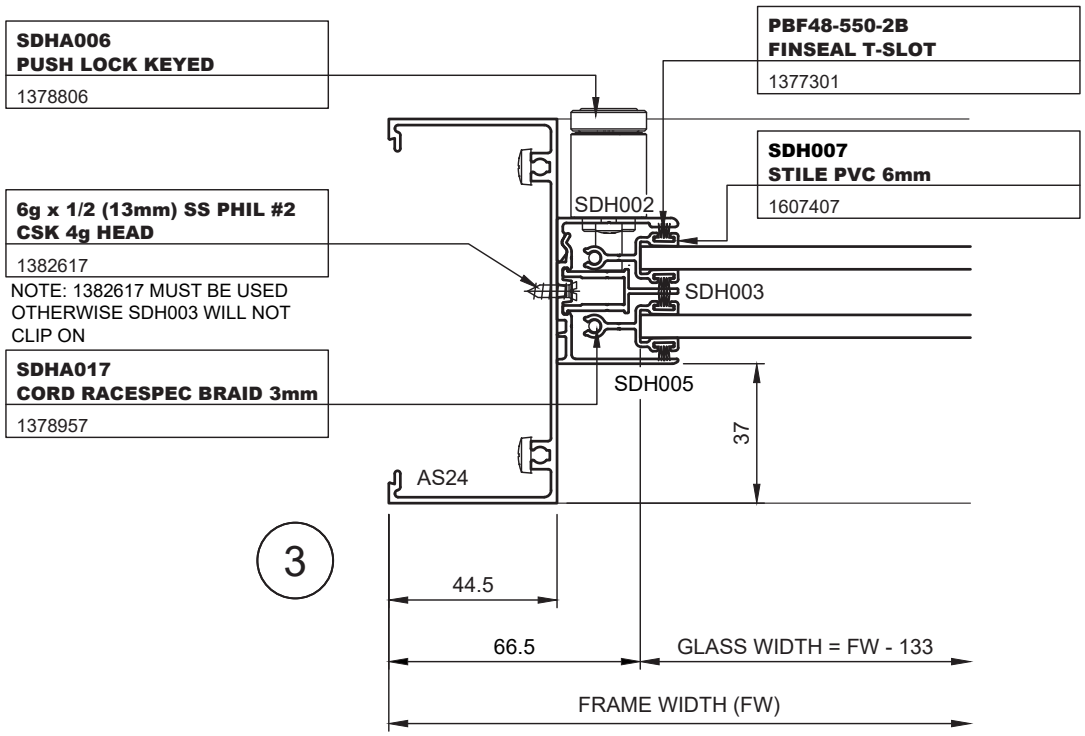
2 Pane Typical Head & Sill Detail - 6mm Glass



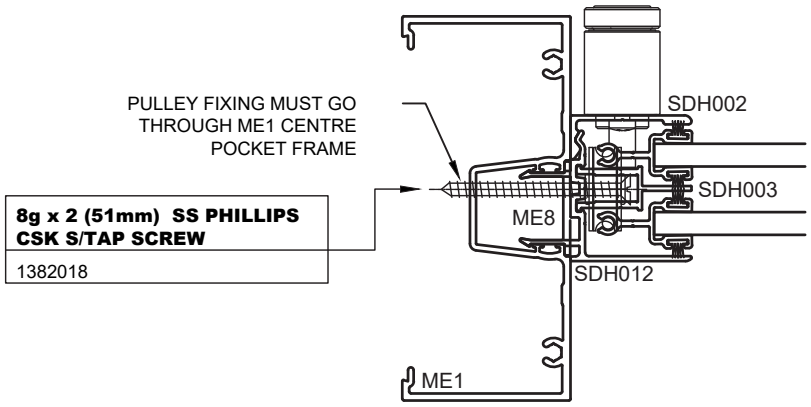
8. Typical Details

2 Pane Typical Jamb Detail - 6mm Glass



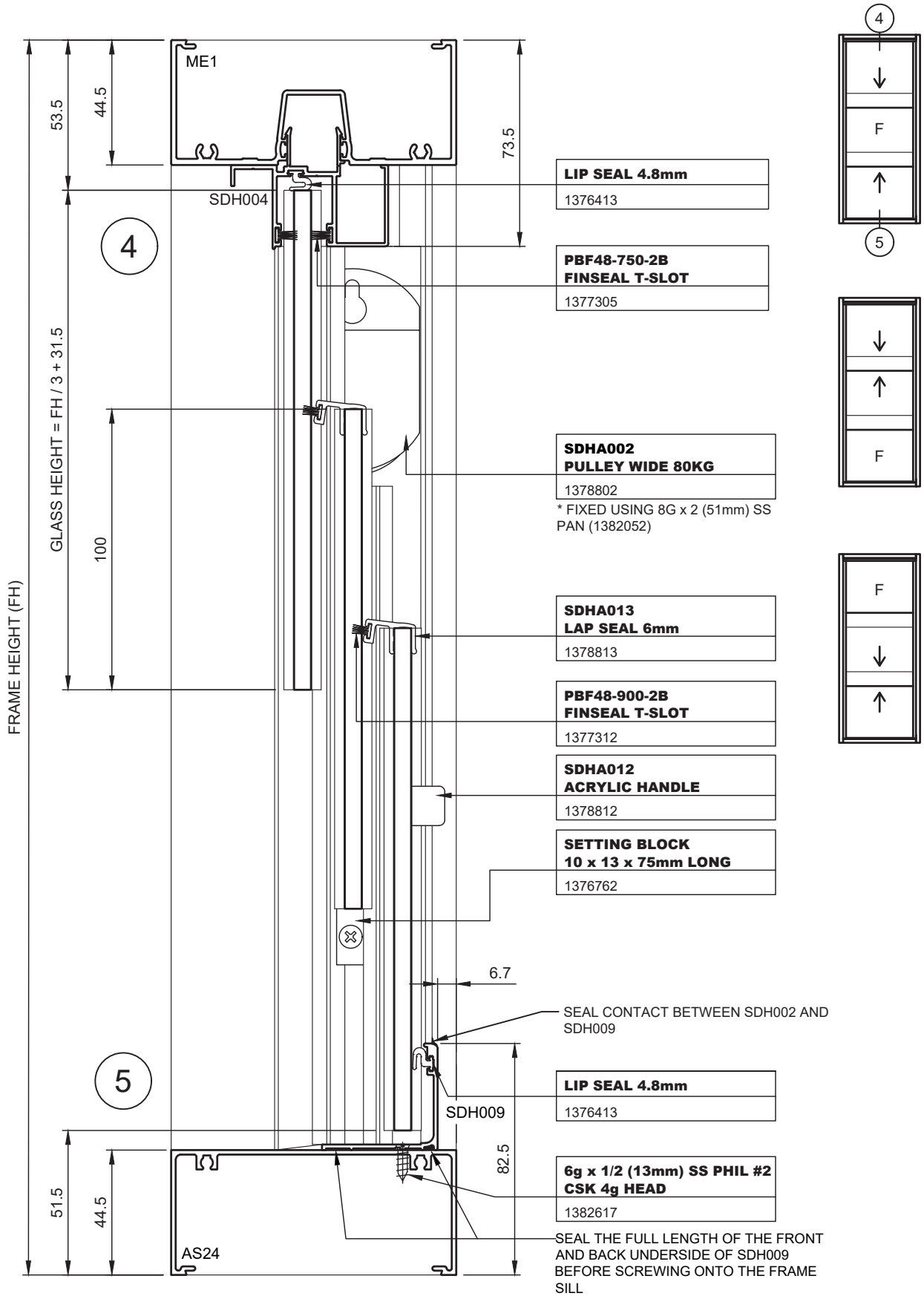


SDH012 CLIP ON JAMB OPTION



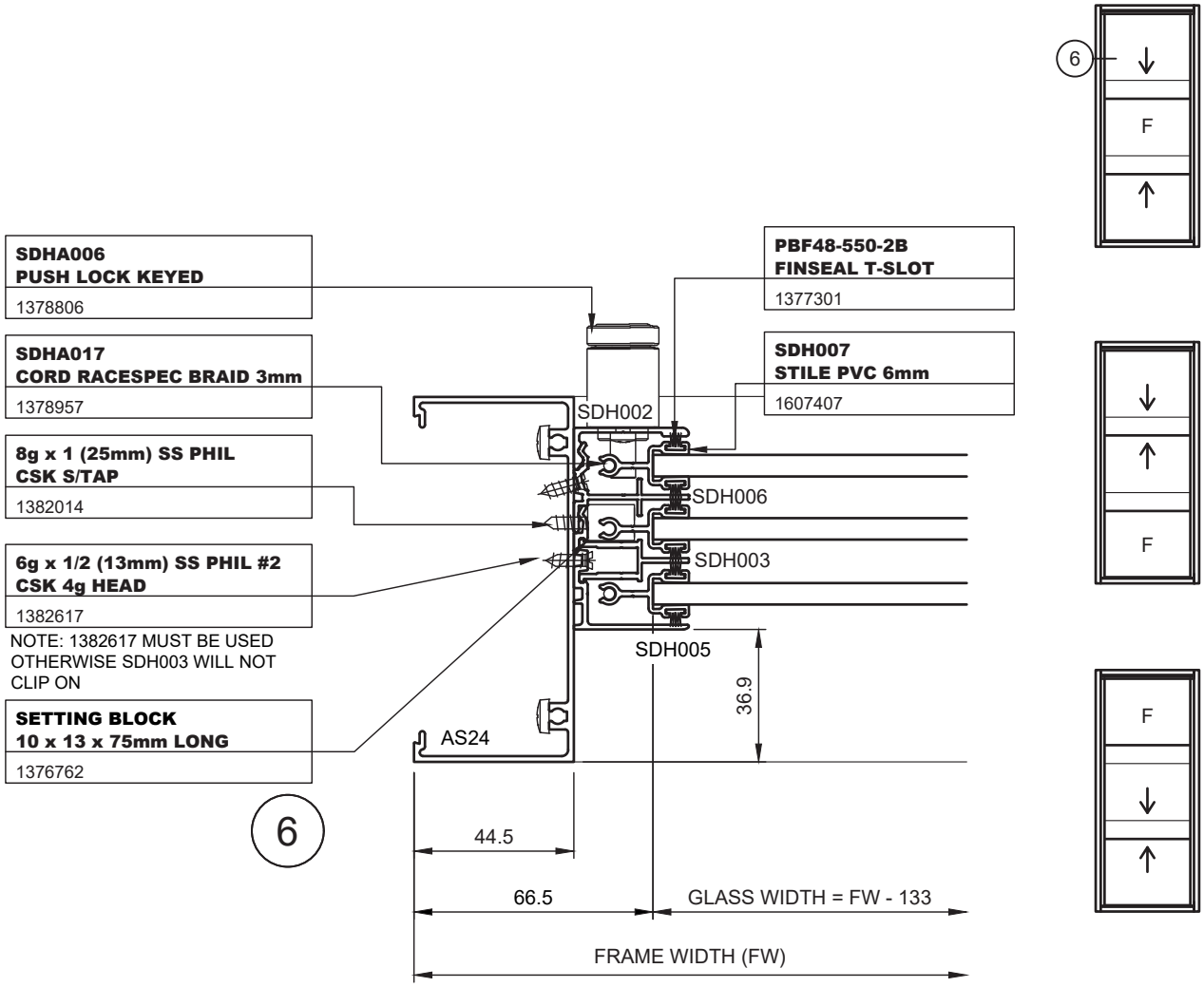
8. Typical Details

3 Pane Typical Head & Sill Detail - 6mm Glass

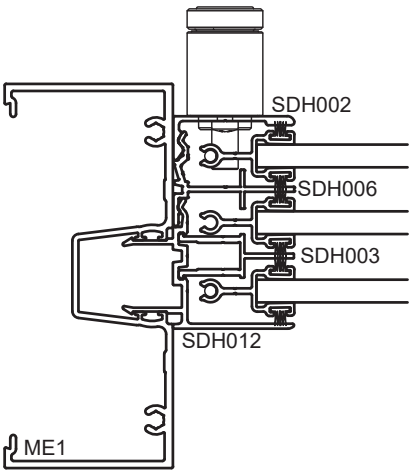


8. Typical Details

3 Pane Typical Jamb Detail - 6mm Glass

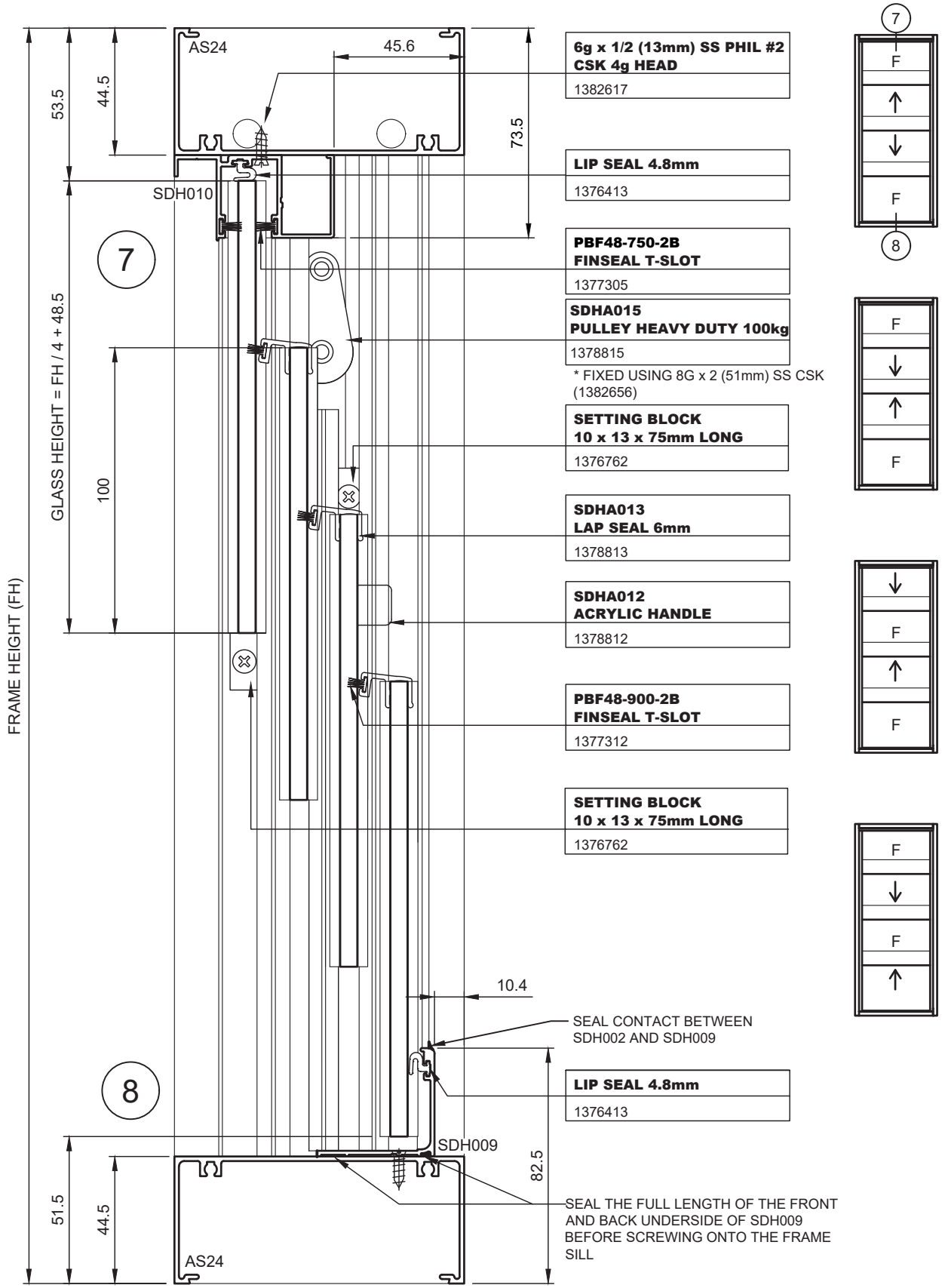


SDH012 CLIP ON JAMB OPTION



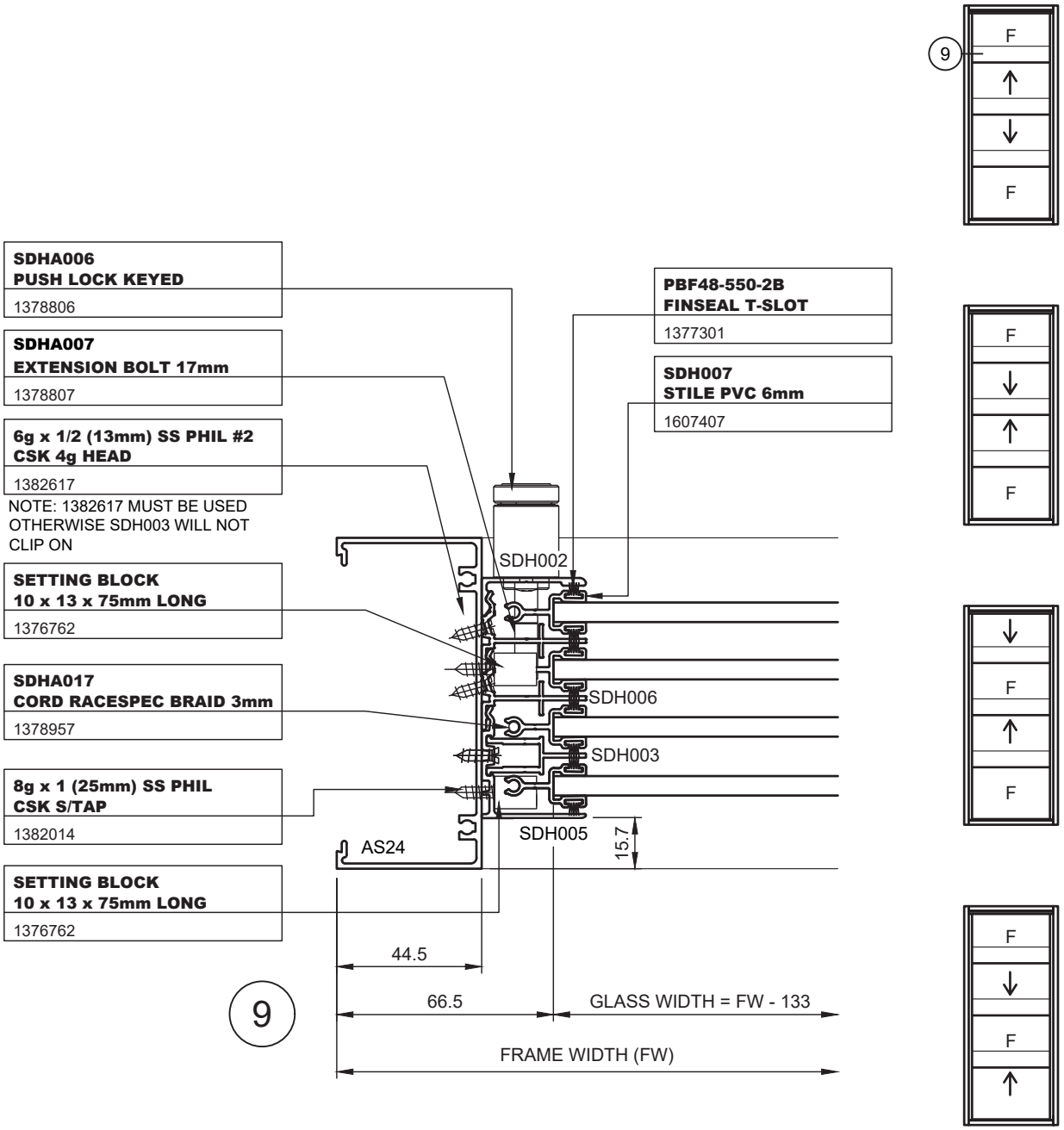
8. Typical Details

4 Pane Typical Head & Sill Detail - 6mm Glass



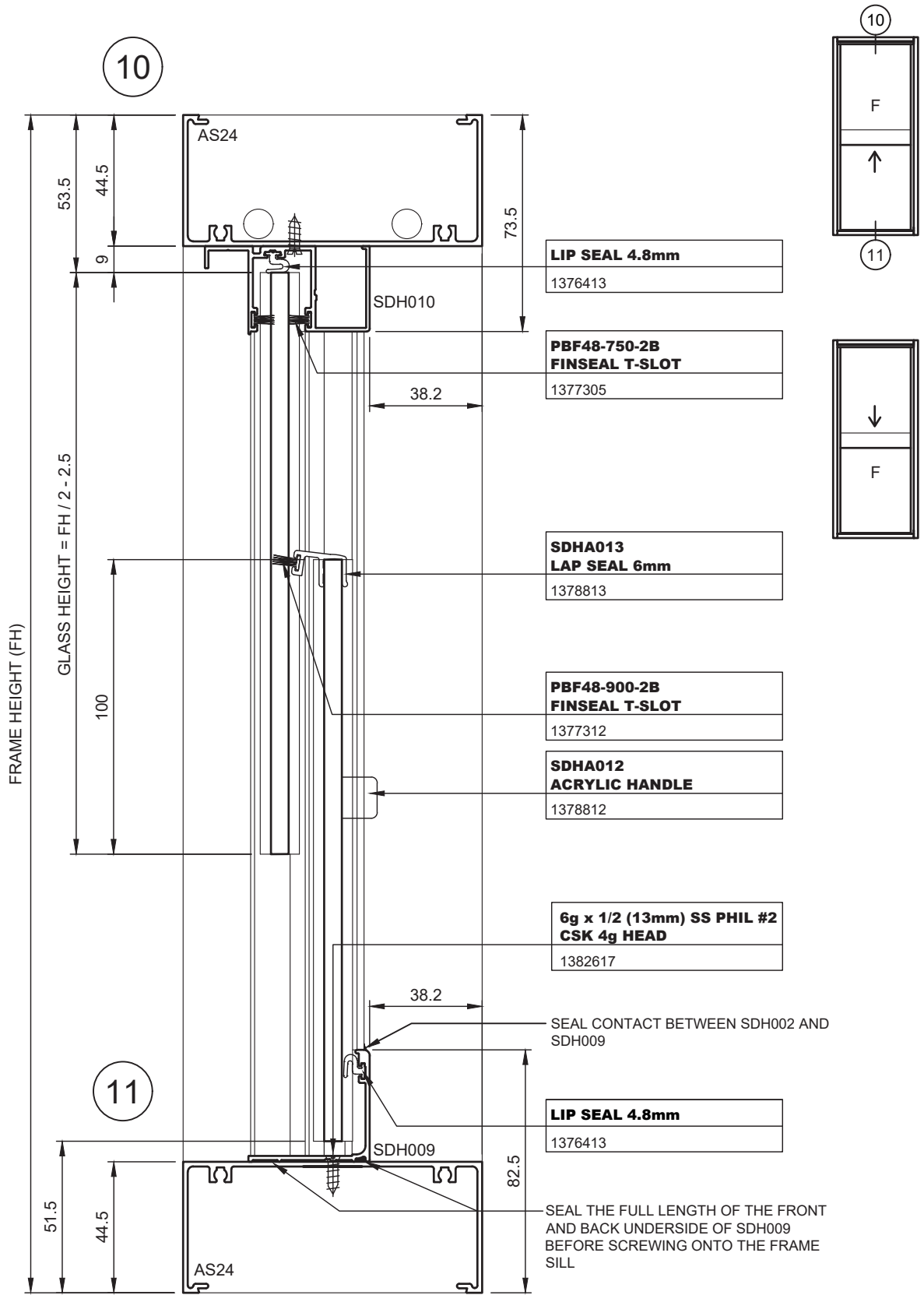
8. Typical Details

4 Pane Typical Jamb Detail - 6mm Glass



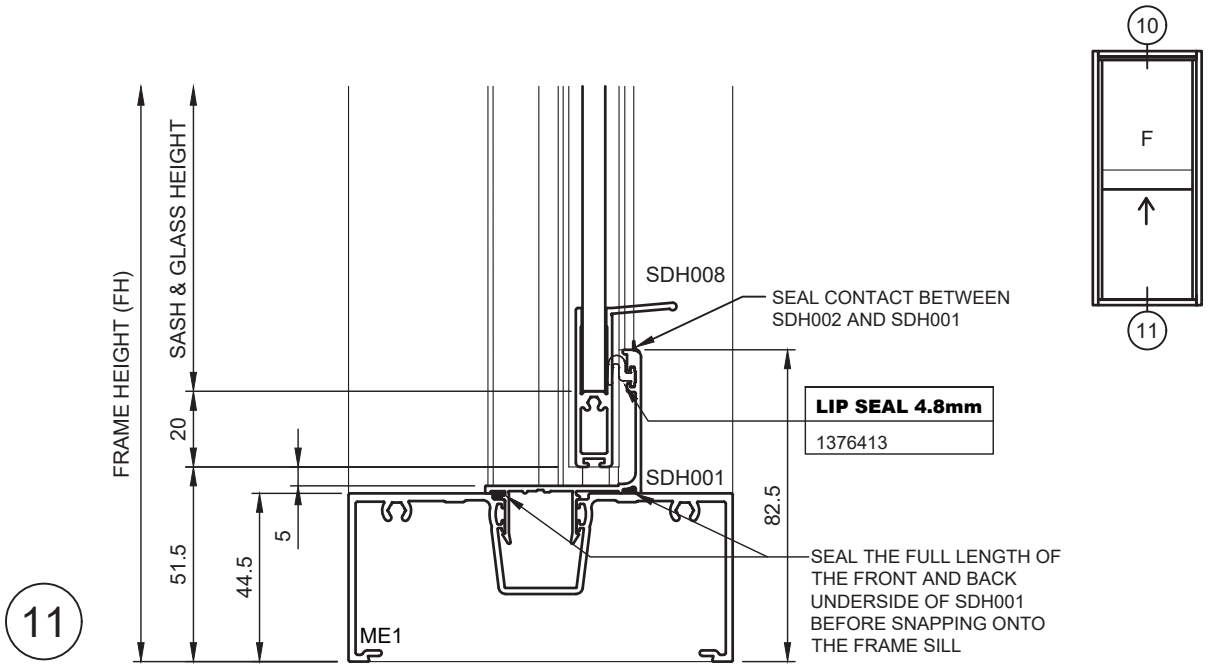
8. Typical Details

2 Pane Servery Typical Head and Sill Detail - 6mm Glass

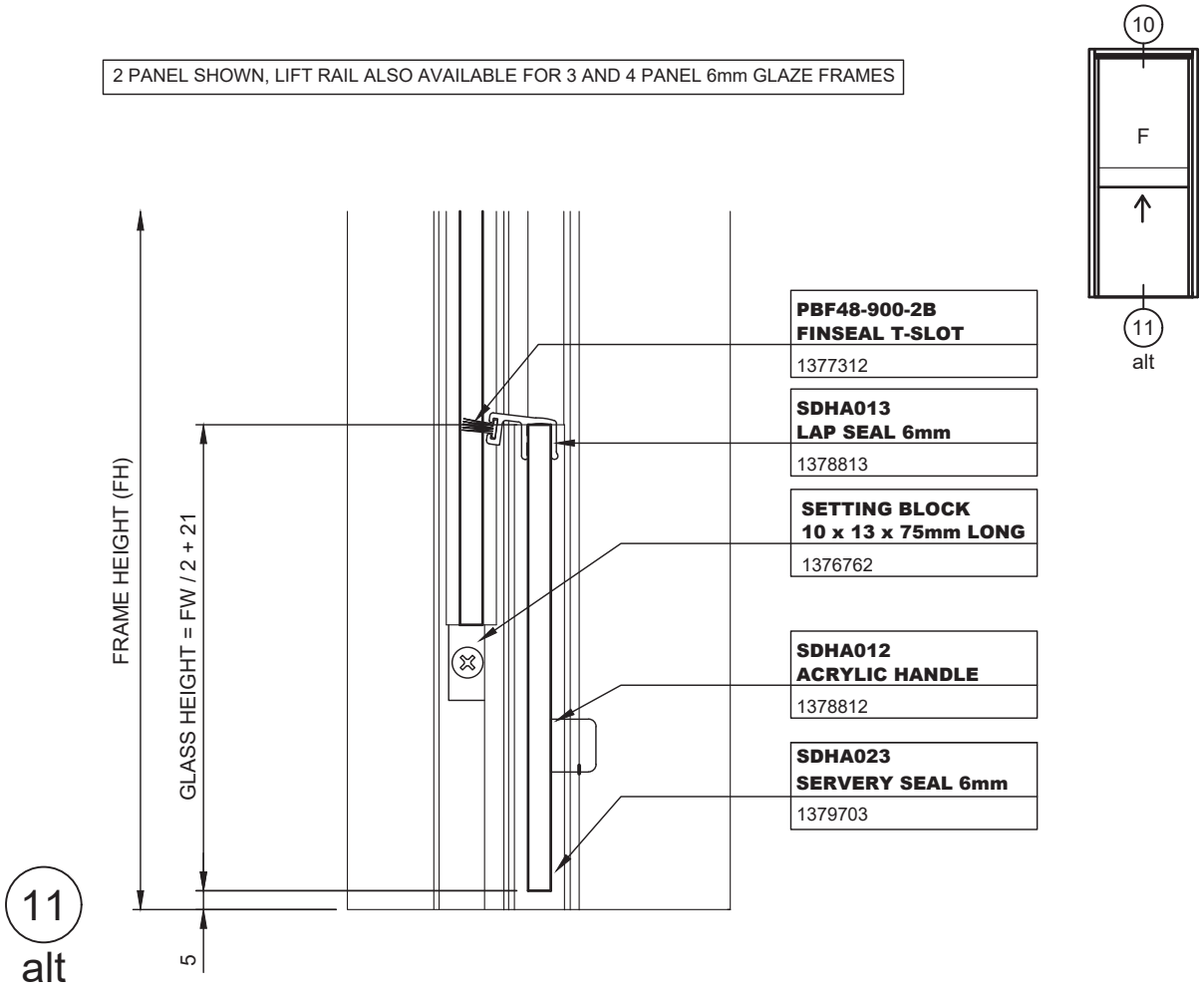


8. Typical Details

2 Pane Servery Typical Sill Detail - 6mm Glass Lift Rail and No Sill Option



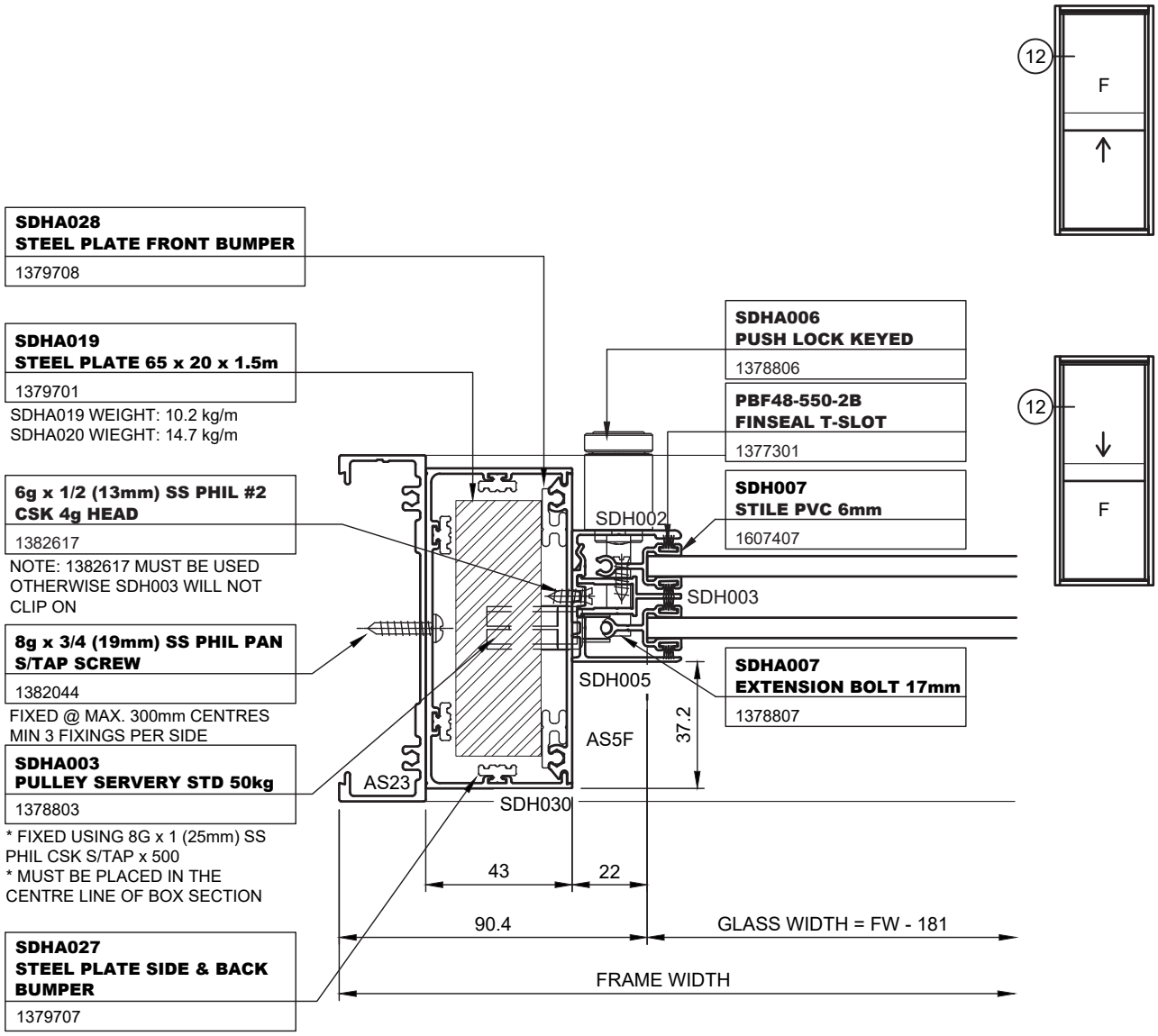
2 PANEL SHOWN, LIFT RAIL ALSO AVAILABLE FOR 3 AND 4 PANEL 6mm GLAZE FRAMES



2 PANEL SHOWN, ALSO AVAILABLE FOR 3 AND 4 PANEL 6mm GLAZE FRAMES

8. Typical Details

2 Pane Servery Typical Jamb Detail - 6mm Glass

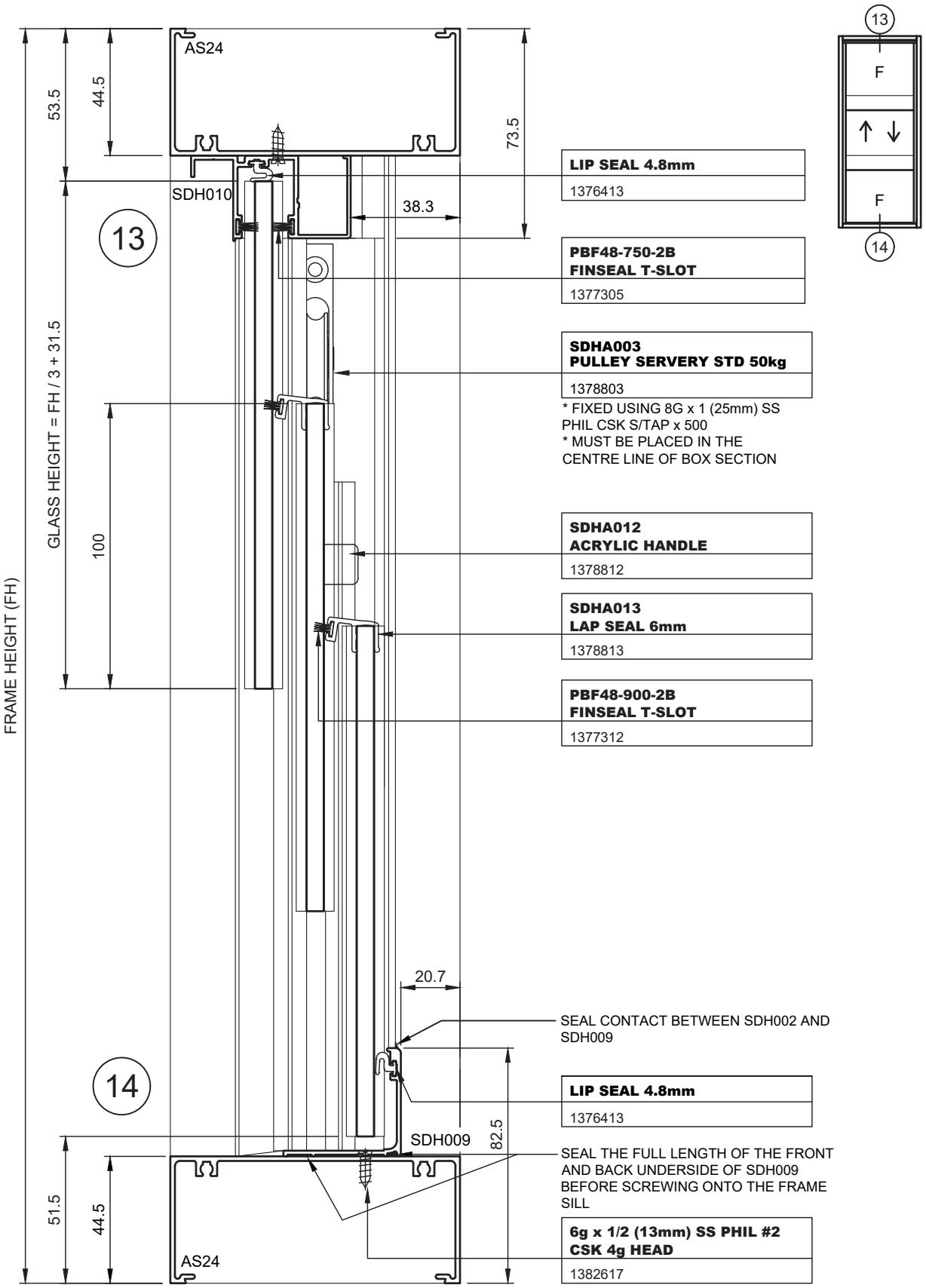


12

NOTE: FOR 2 LITE CONFIGURATIONS, FLAT BAR LENGTH CANNOT BE GREATER THAN GLASS HEIGHT - 200mm

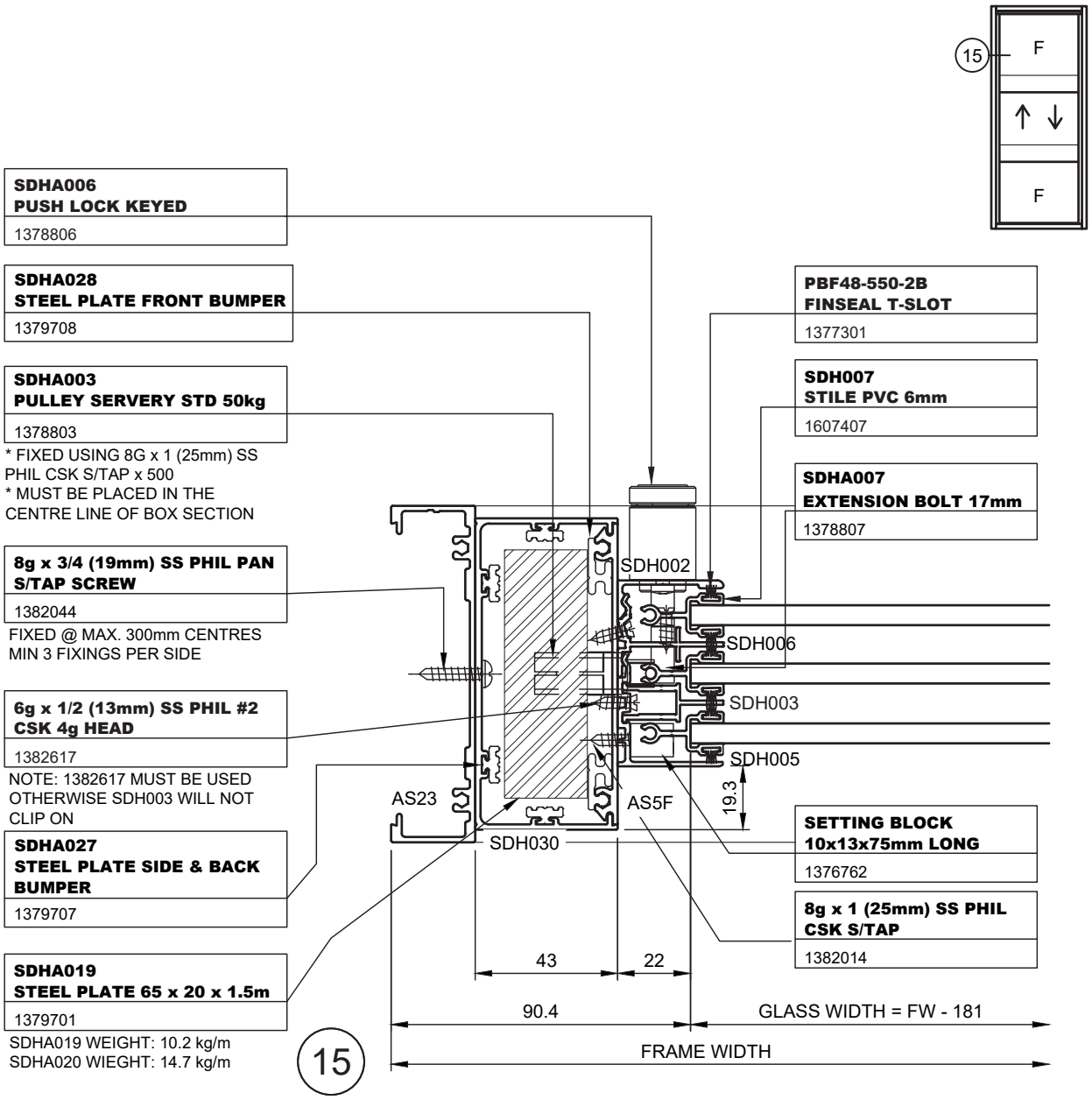
8. Typical Details

3 Pane Servery Typical Head and Sill Detail - 6mm Glass



8. Typical Details

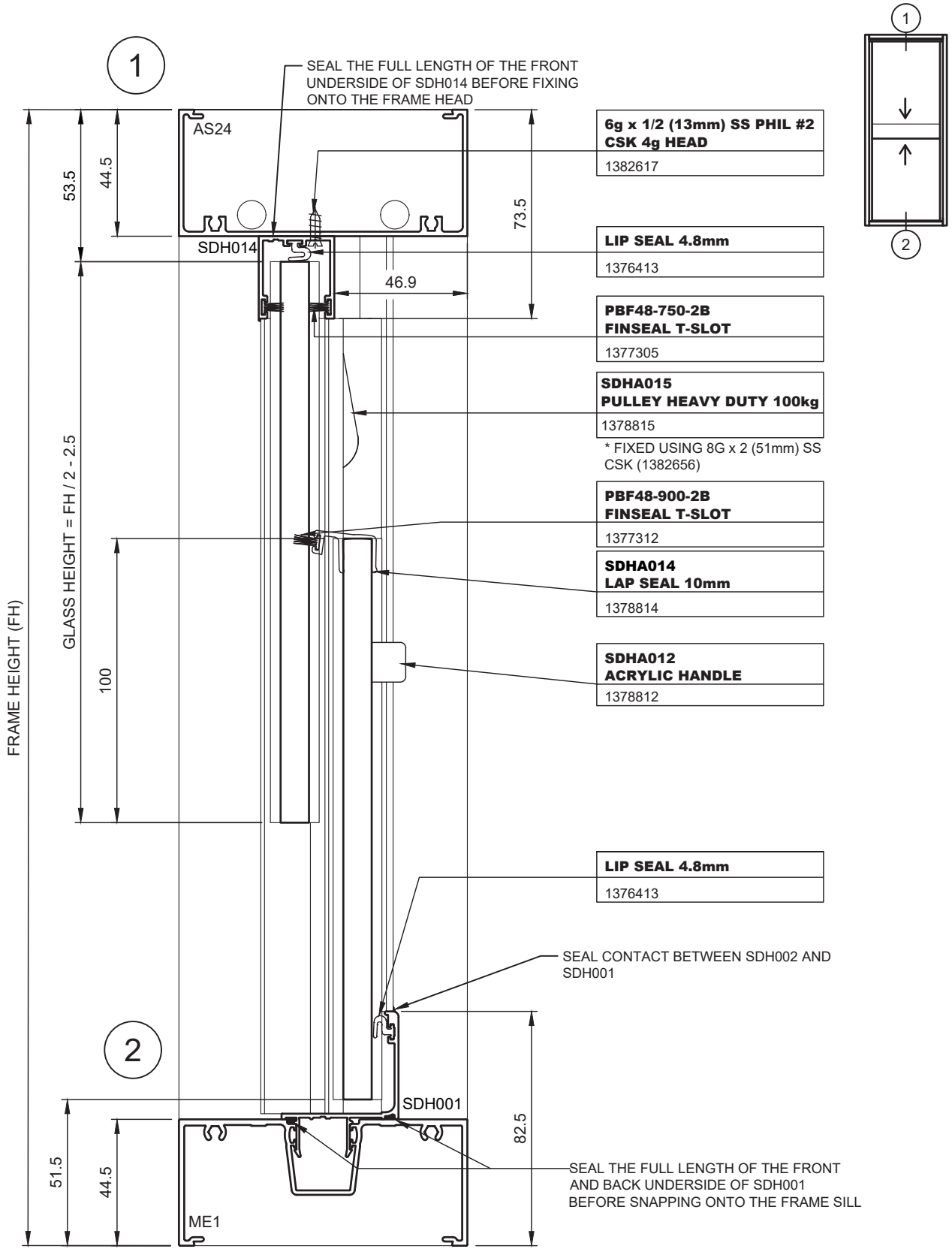
3 Pane Servery Typical Jamb Detail - 6mm Glass



NOTE: FOR 3 LITE CONFIGURATIONS, FLAT BAR LENGTH CANNOT BE GREATER THAN GLASS HEIGHT + 955mm

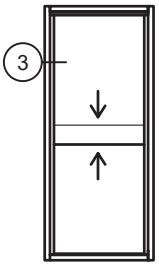
8. Typical Details

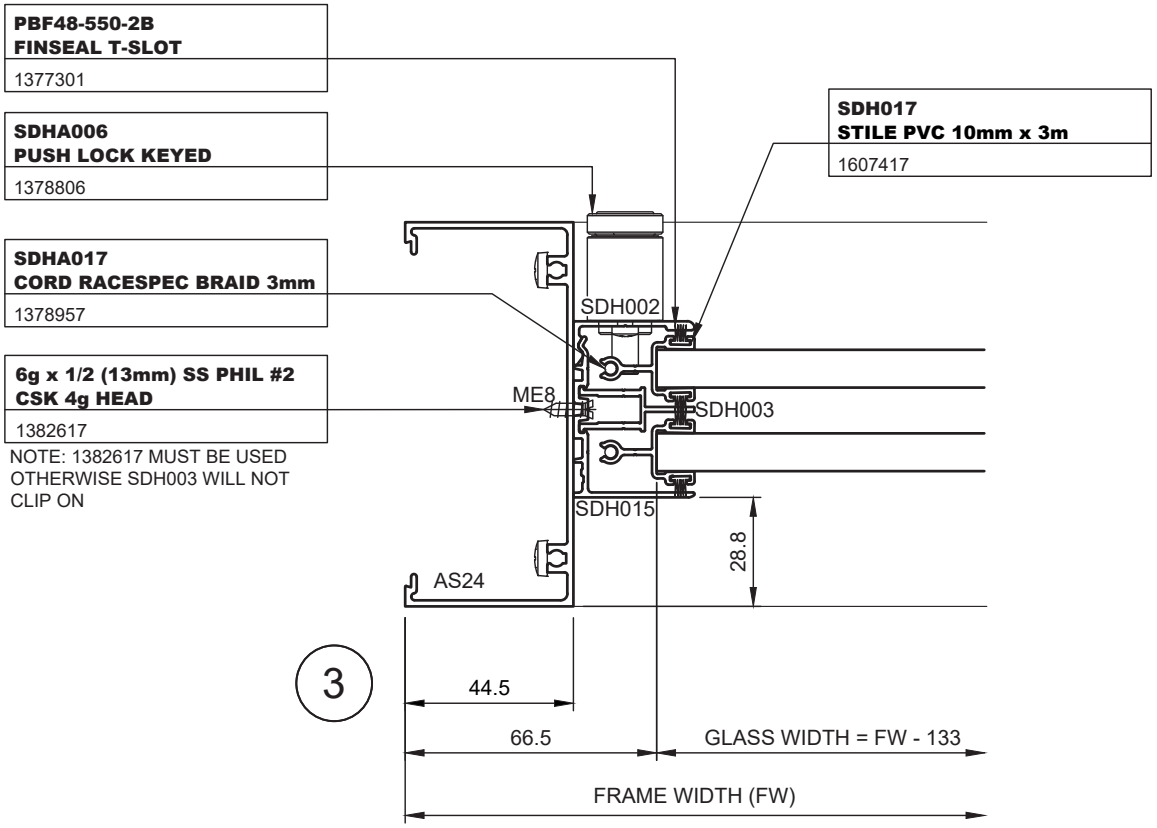
2 Pane Typical Head & Sill Detail - 10mm Glass



8. Typical Details

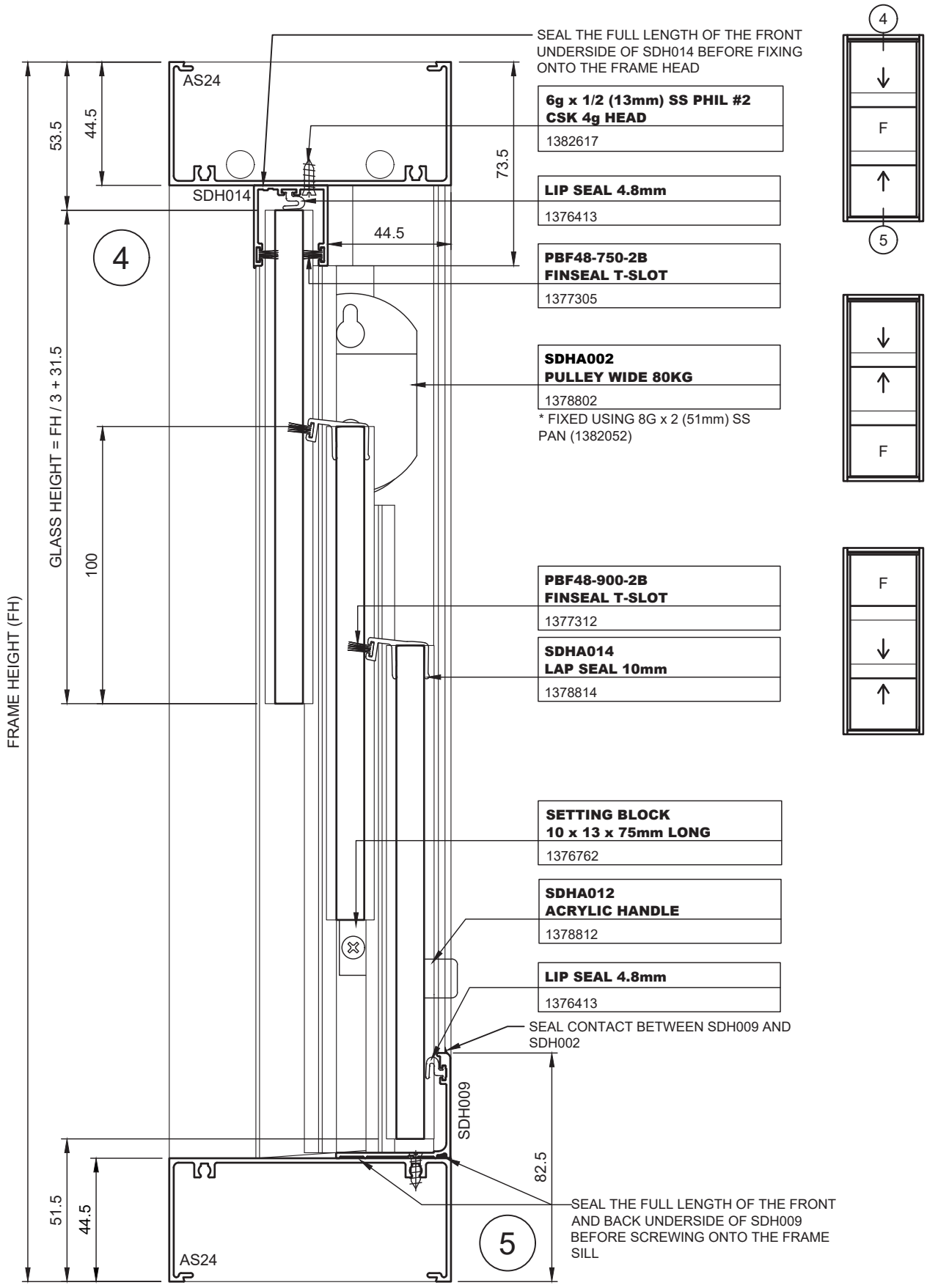
2 Pane Typical Jamb Detail - 10mm Glass



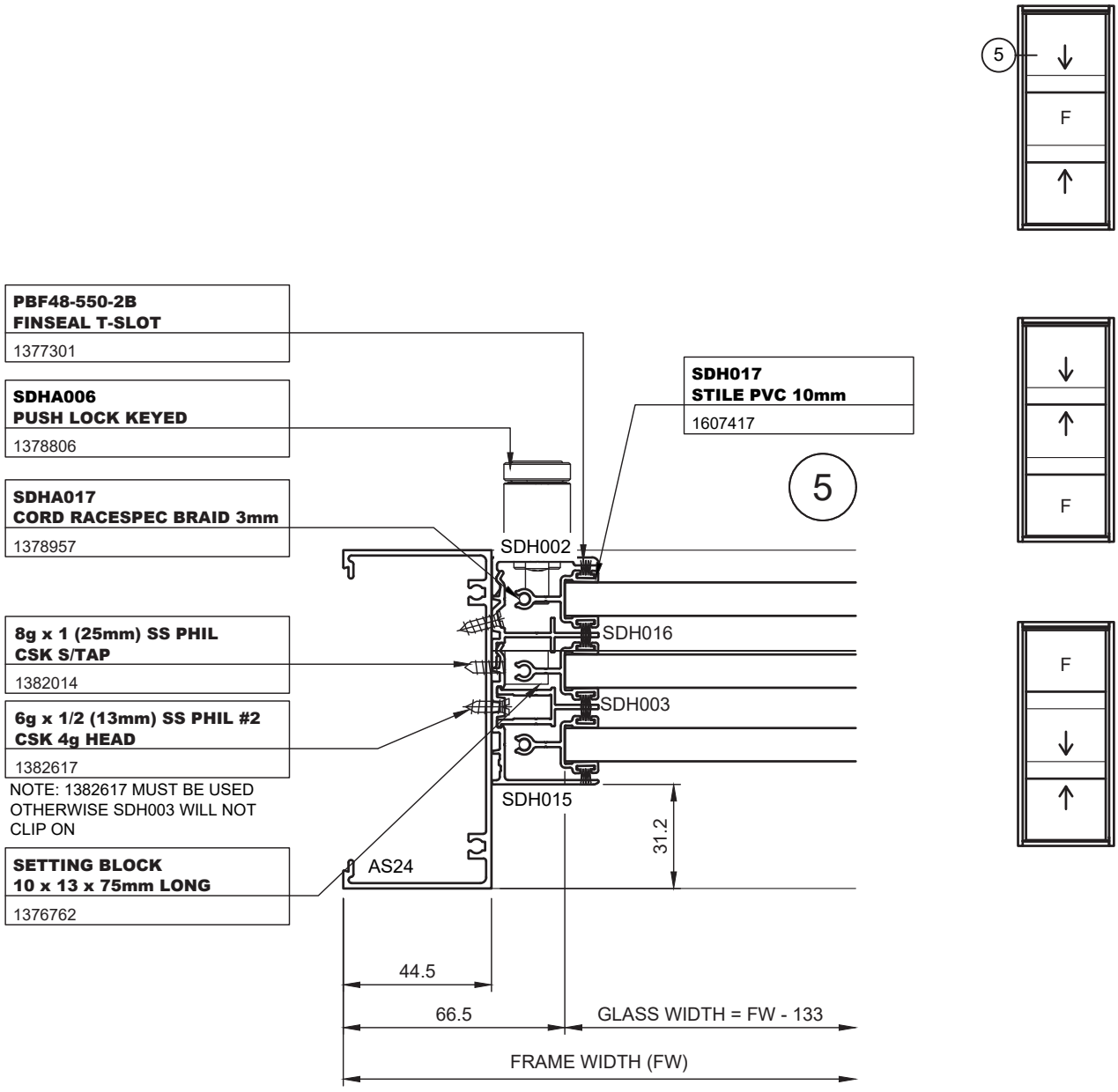


8. Typical Details

3 Pane Typical Head & Sill Detail - 10mm Glass

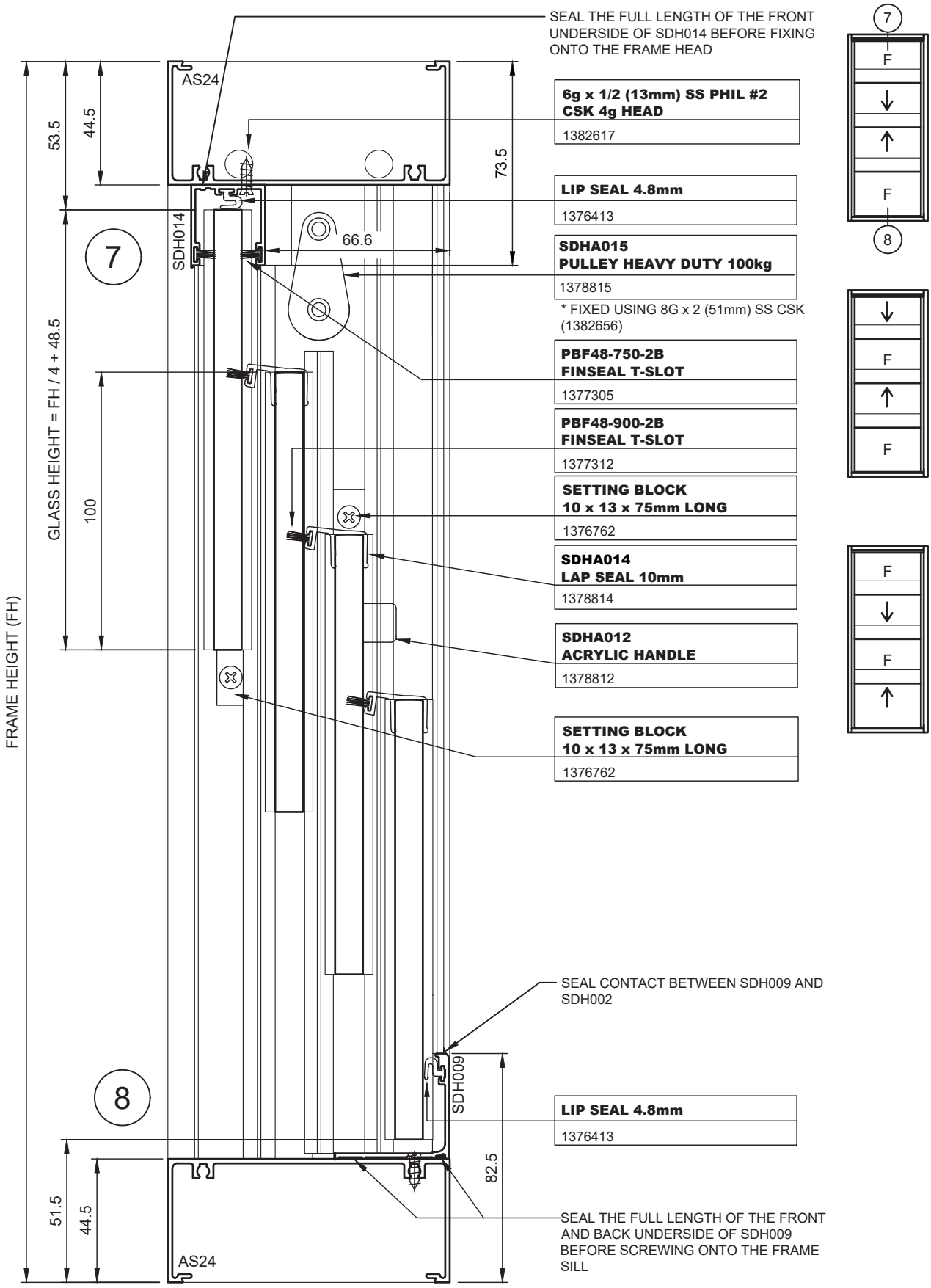


3 Pane Typical Jamb Detail - 10mm Glass



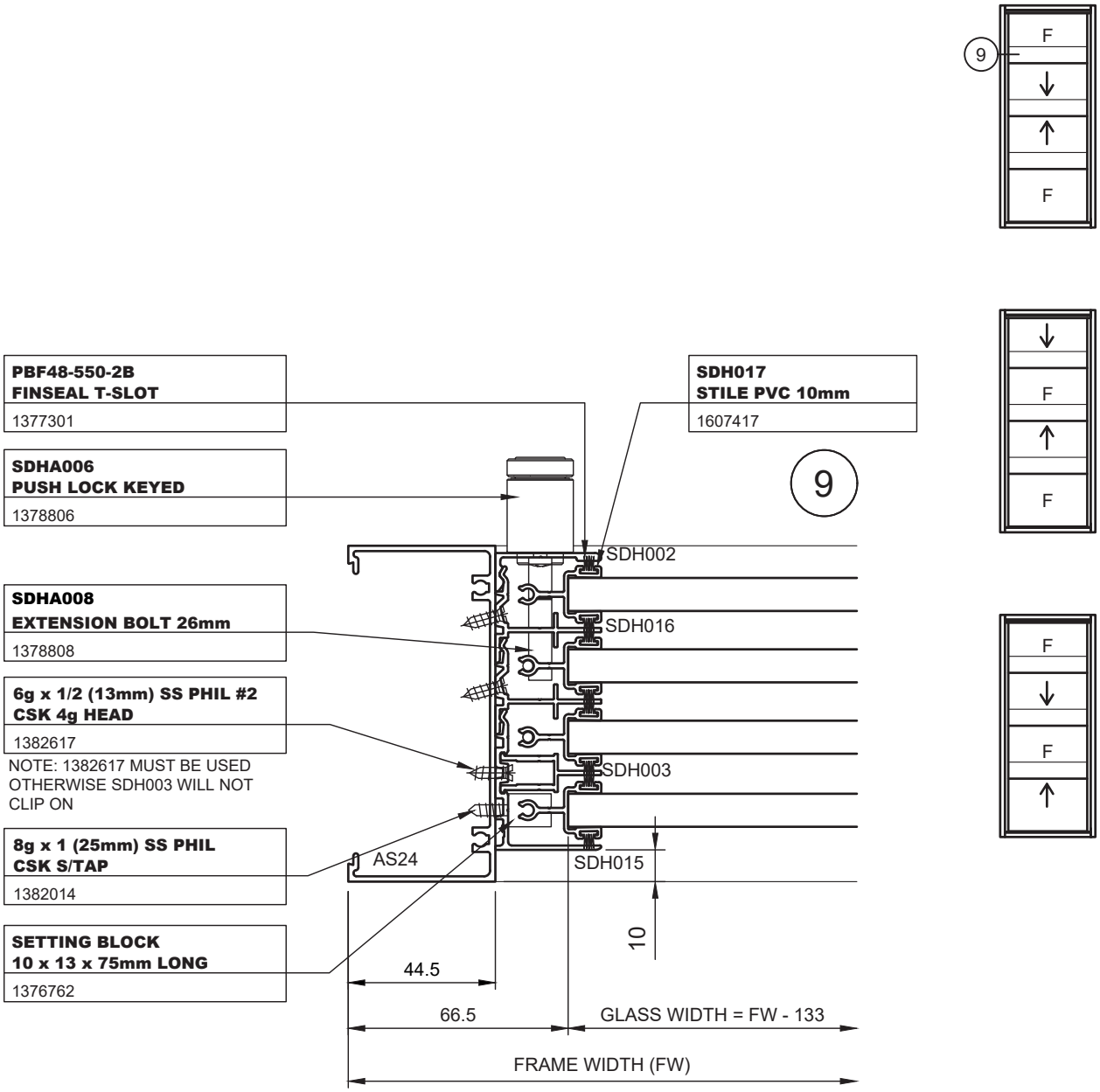
8. Typical Details

4 Pane Typical Head & Sill Detail - 10mm Glass



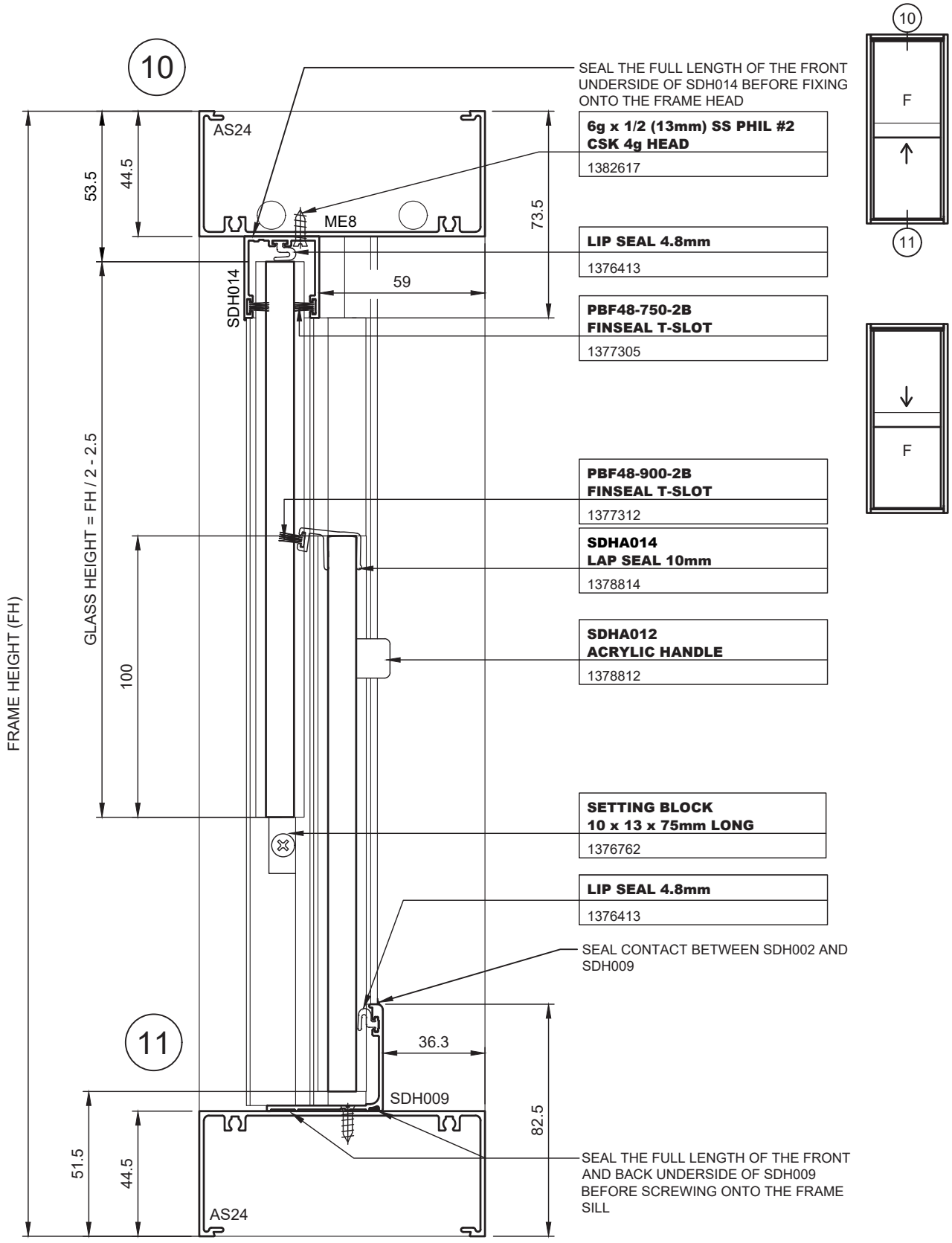
8. Typical Details

4 Pane Typical Jamb Detail - 10mm Glass



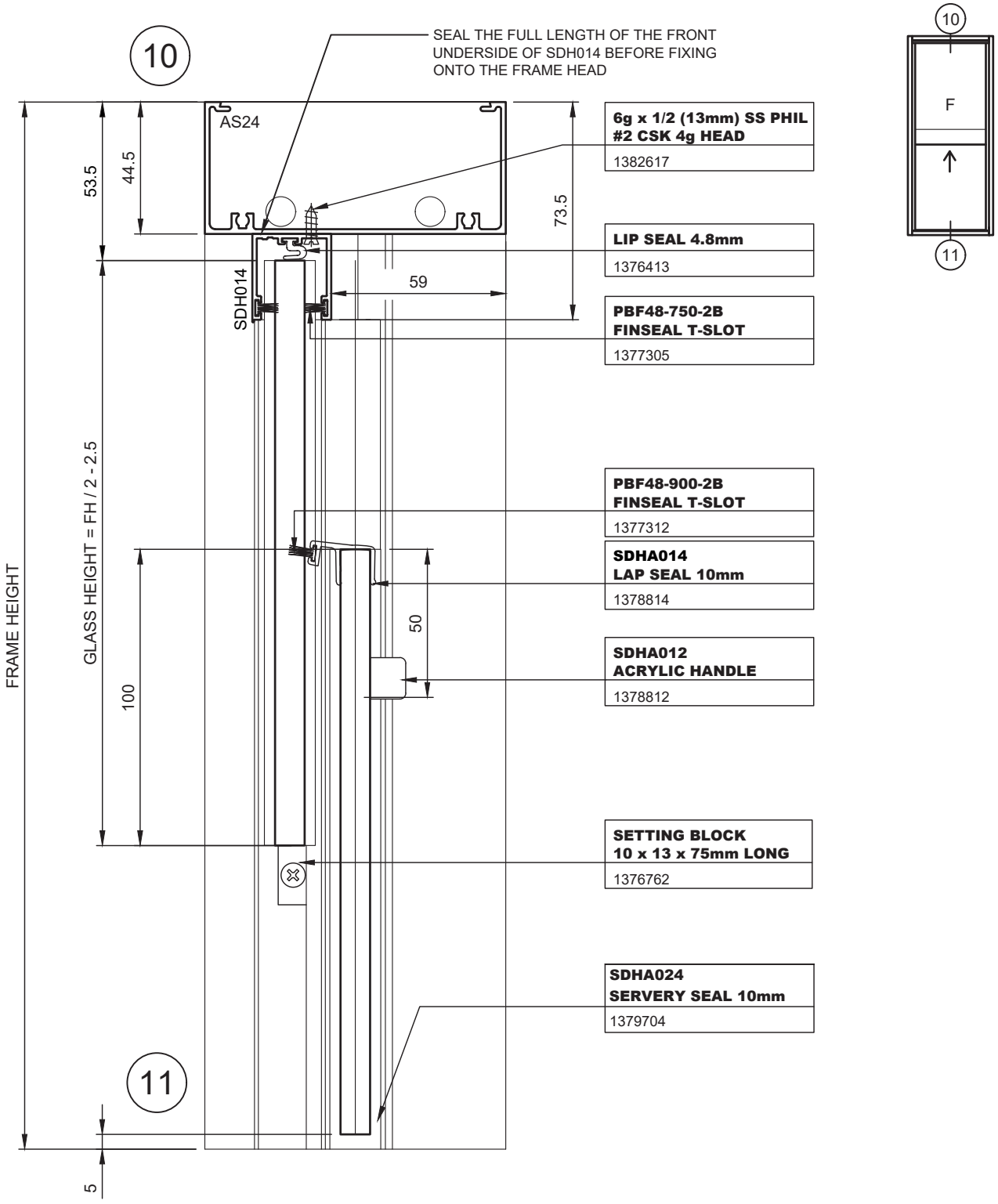
8. Typical Details

2 Pane Servery Typical Head and Sill Detail - 10mm Glass



8. Typical Details

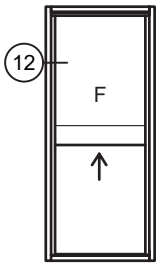
2 Pane Servery Typical Head & No SIll Detail - 10mm Glass

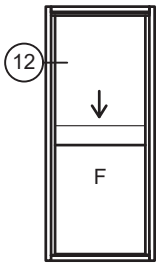


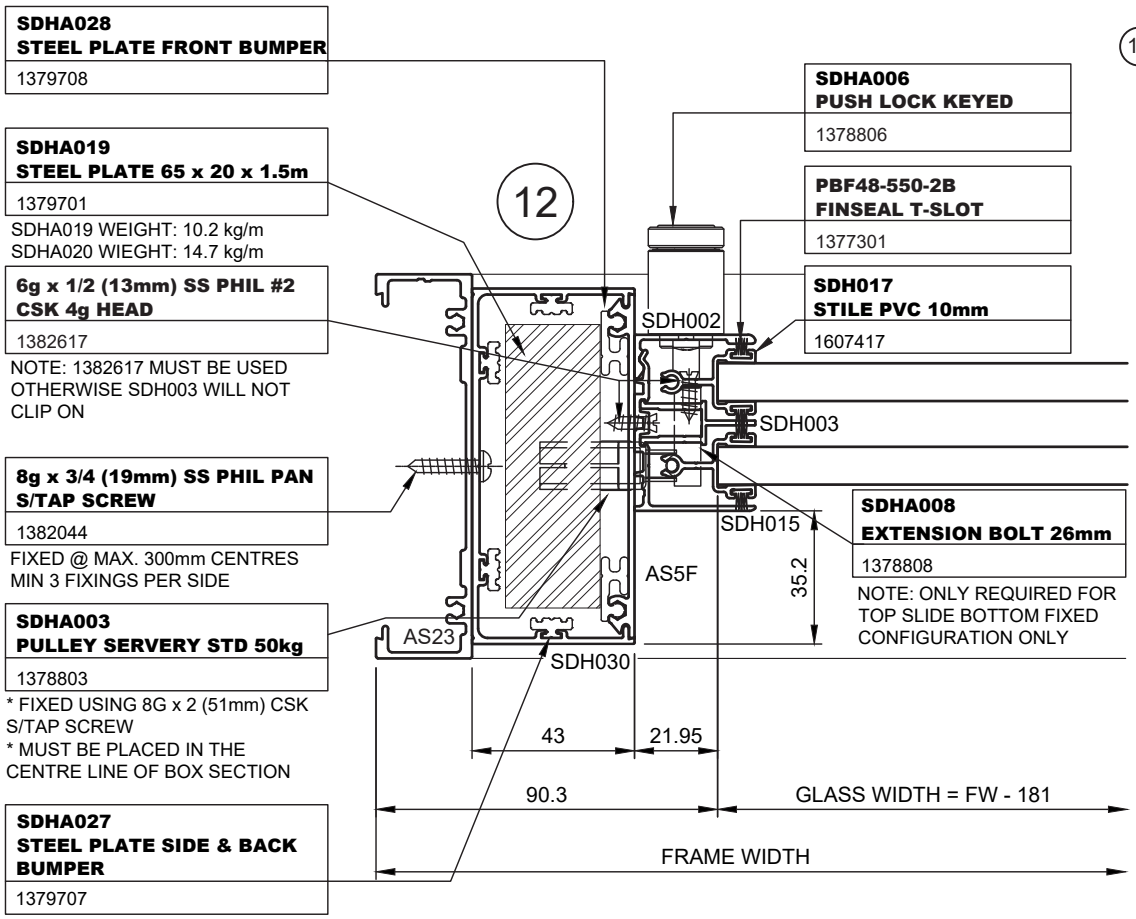
2 PANEL SHOWN, ALSO AVAILABLE FOR 3 AND 4 PANEL 10mm GLAZE FRAMES

8. Typical Details

2 Pane Servery Typical Jamb Detail - 10mm Glass



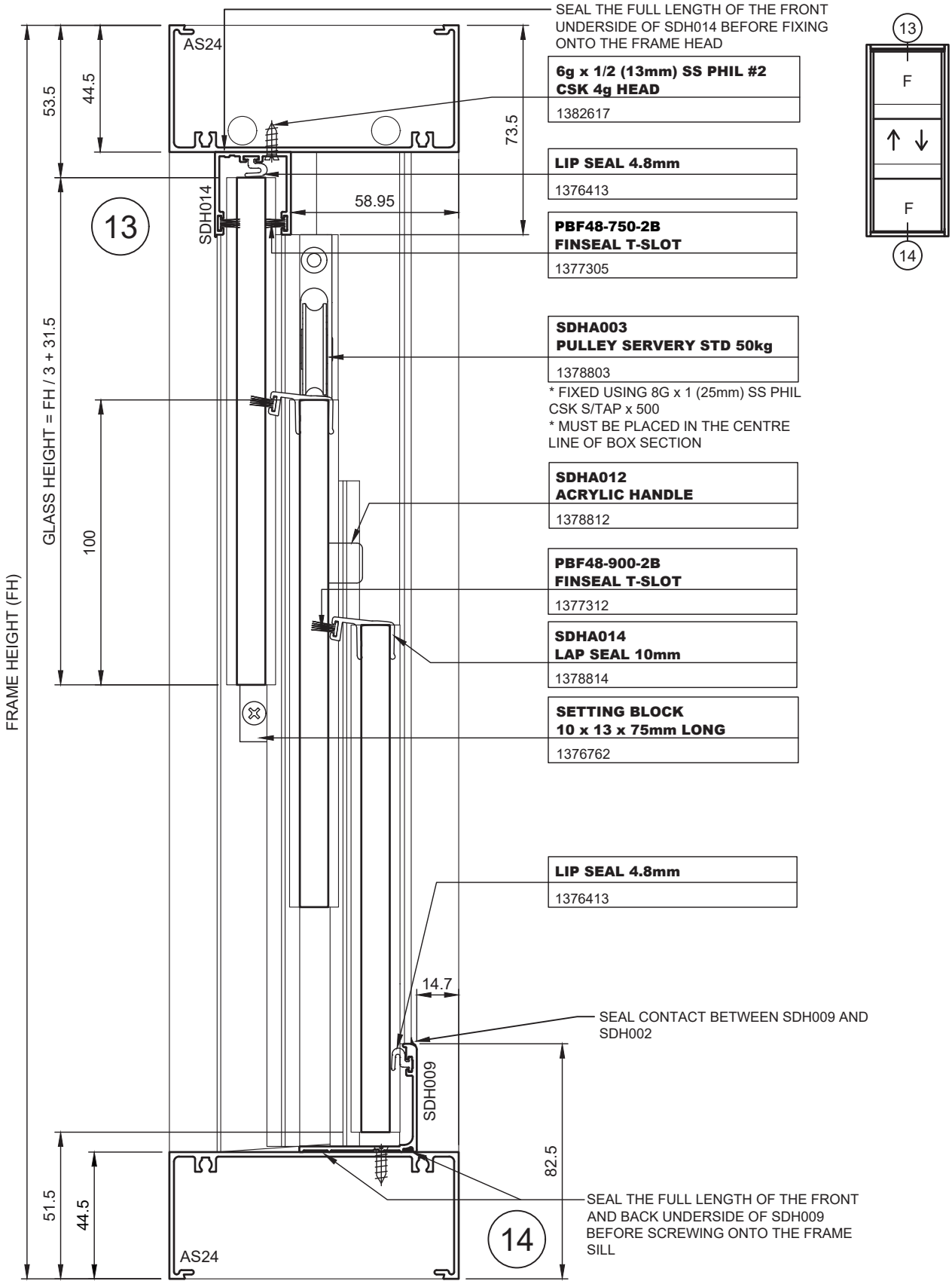




NOTE: FOR 2 LITE CONFIGURATIONS, FLAT BAR LENGTH CANNOT BE GREATER THAN GLASS HEIGHT - 200mm

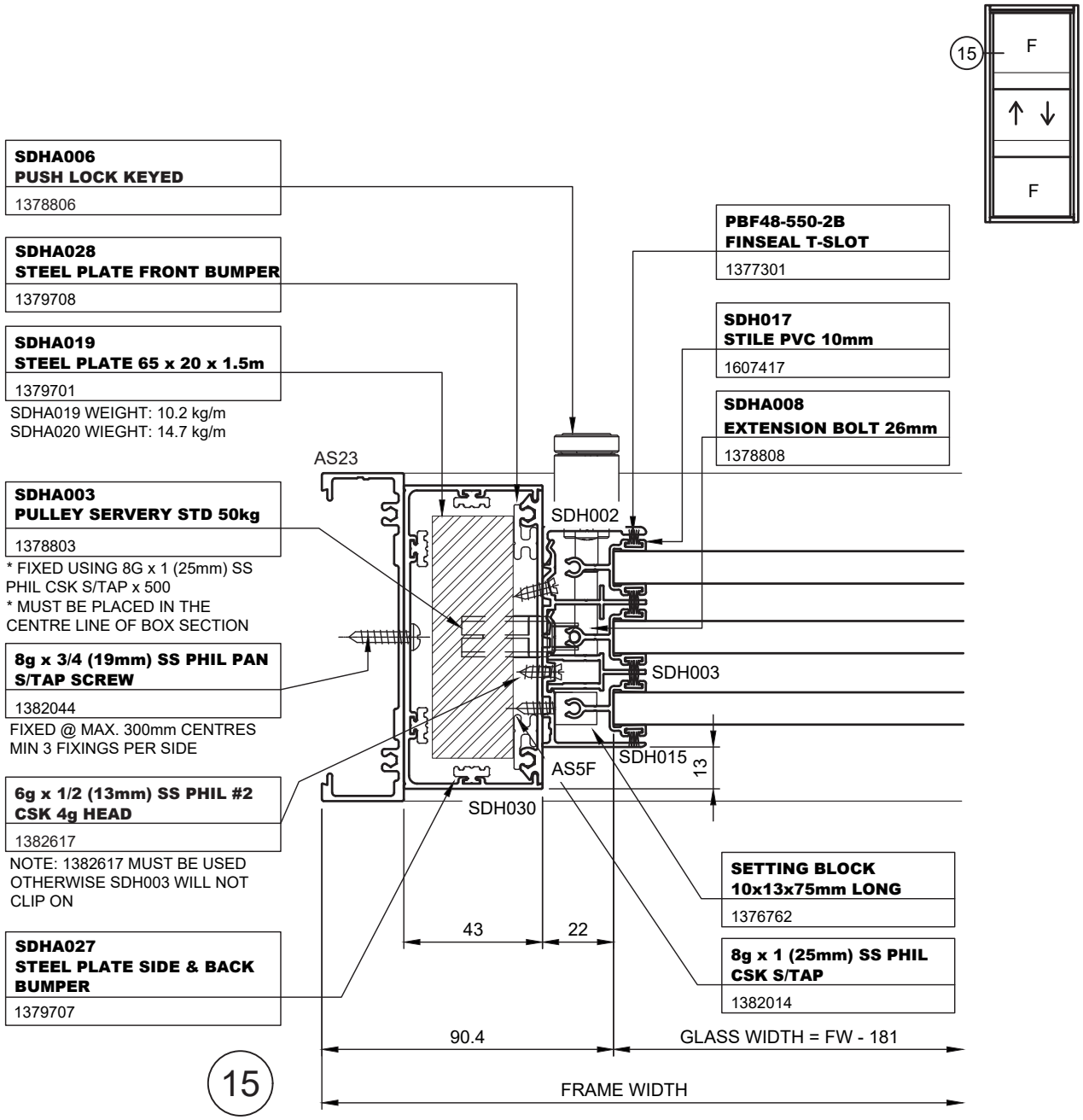
8. Typical Details

3 Pane Servery Typical Head and Sill Detail - 10mm Glass



8. Typical Details

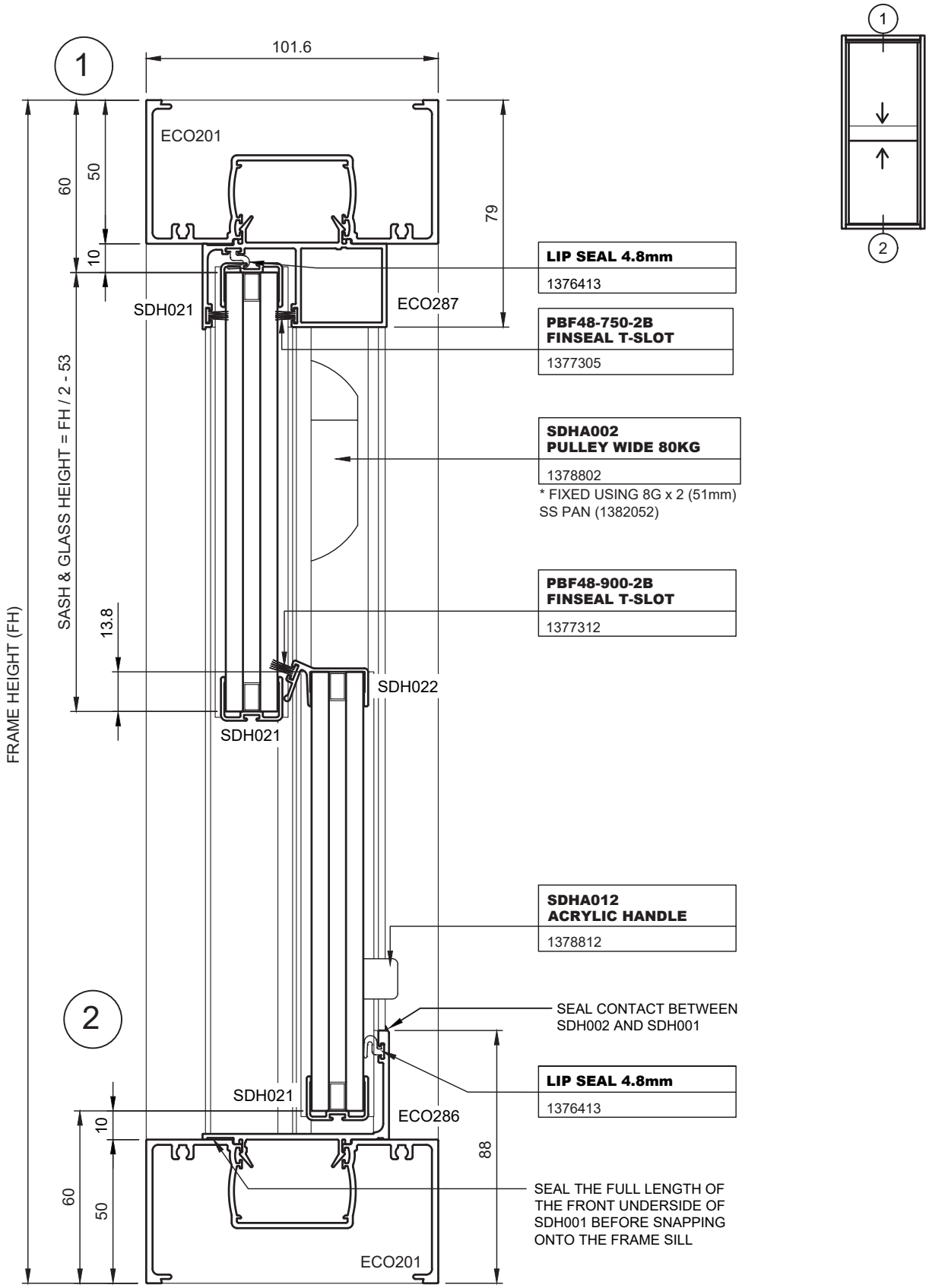
3 Pane Servery Typical Jamb Detail - 10mm Glass



NOTE: FOR 3 LITE CONFIGURATIONS, FLAT BAR LENGTH CANNOT BE GREATER THAN GLASS HEIGHT + 955mm

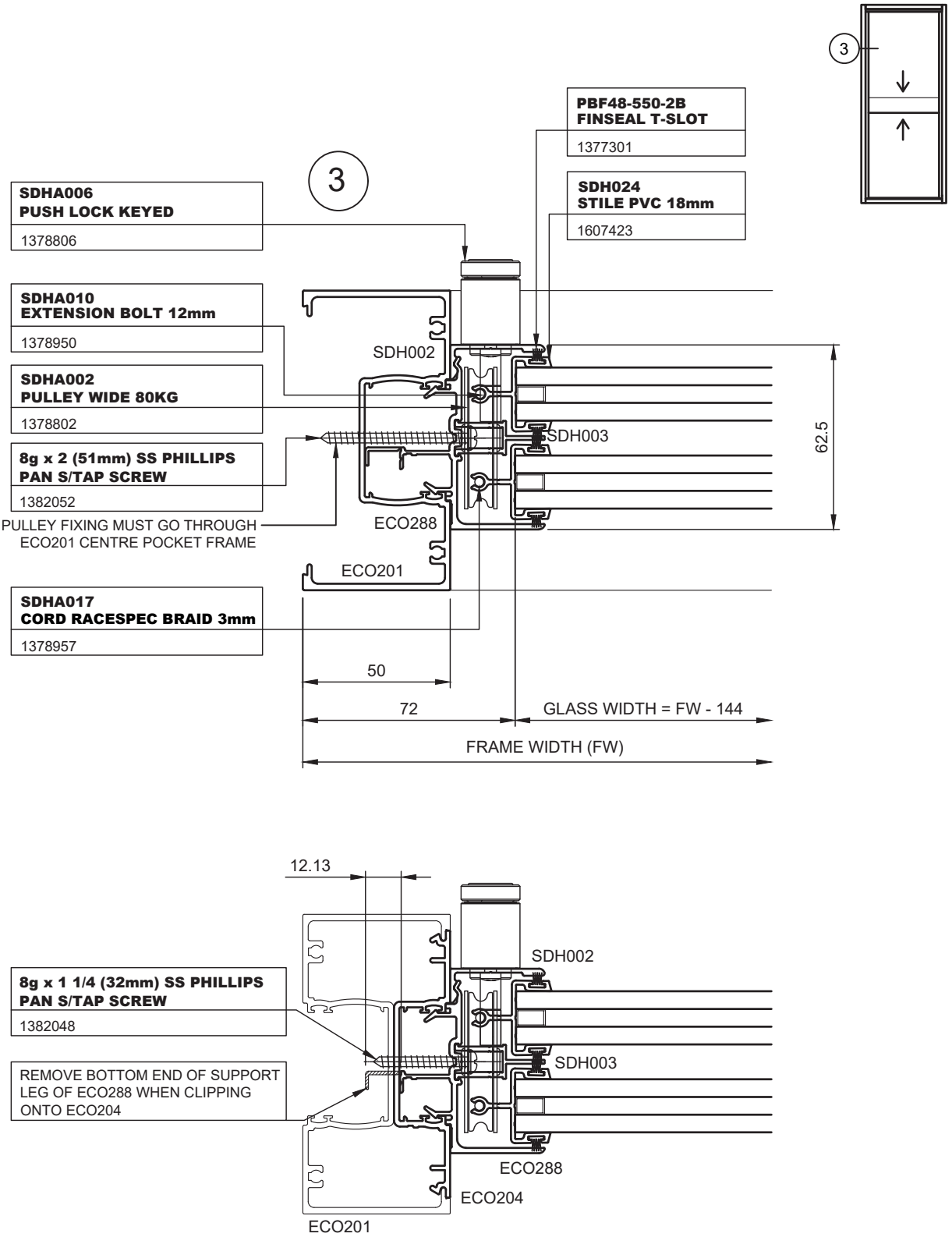
8. Typical Details

2 Pane ecoFRAMEplus Adaptors Typical Head & Sill Detail - 18mm Double Glazed



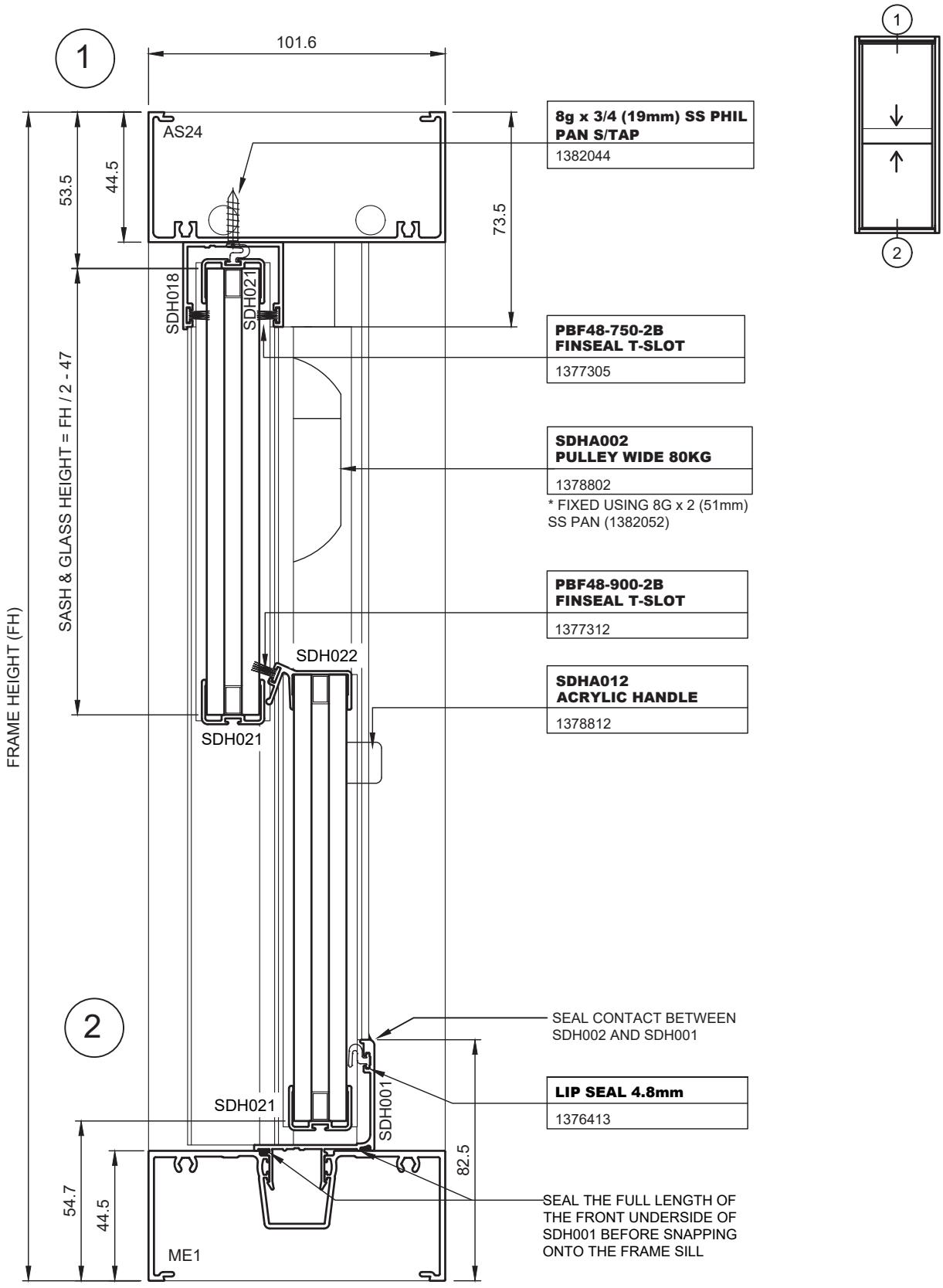
8. Typical Details

2 Pane ecoFRAMEplus Adaptors Typical Jamb Detail - 18mm Double Glazed



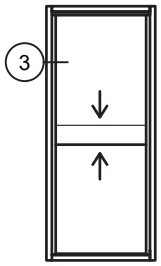
8. Typical Details

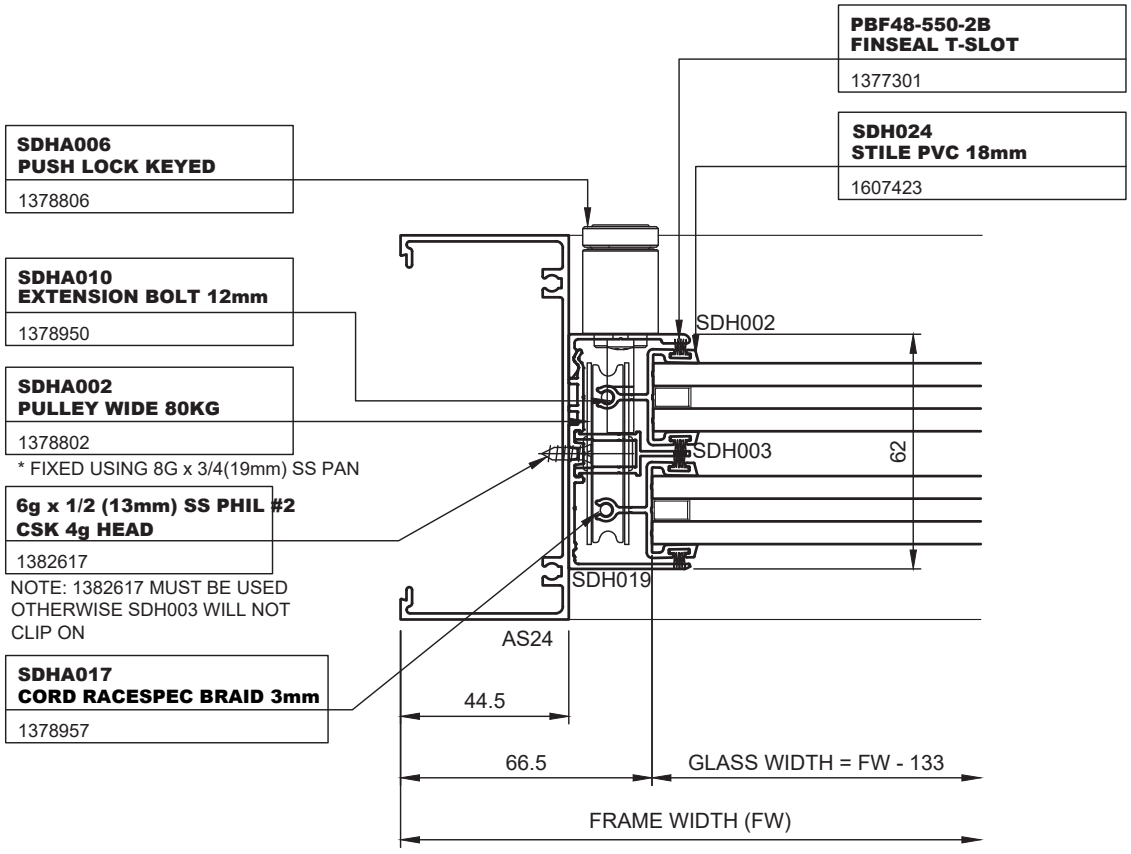
2 Pane Typical Head & Sill Detail - 18mm Double Glazed



8. Typical Details

2 Pane Typical Jamb Detail - 18mm Double Glazed

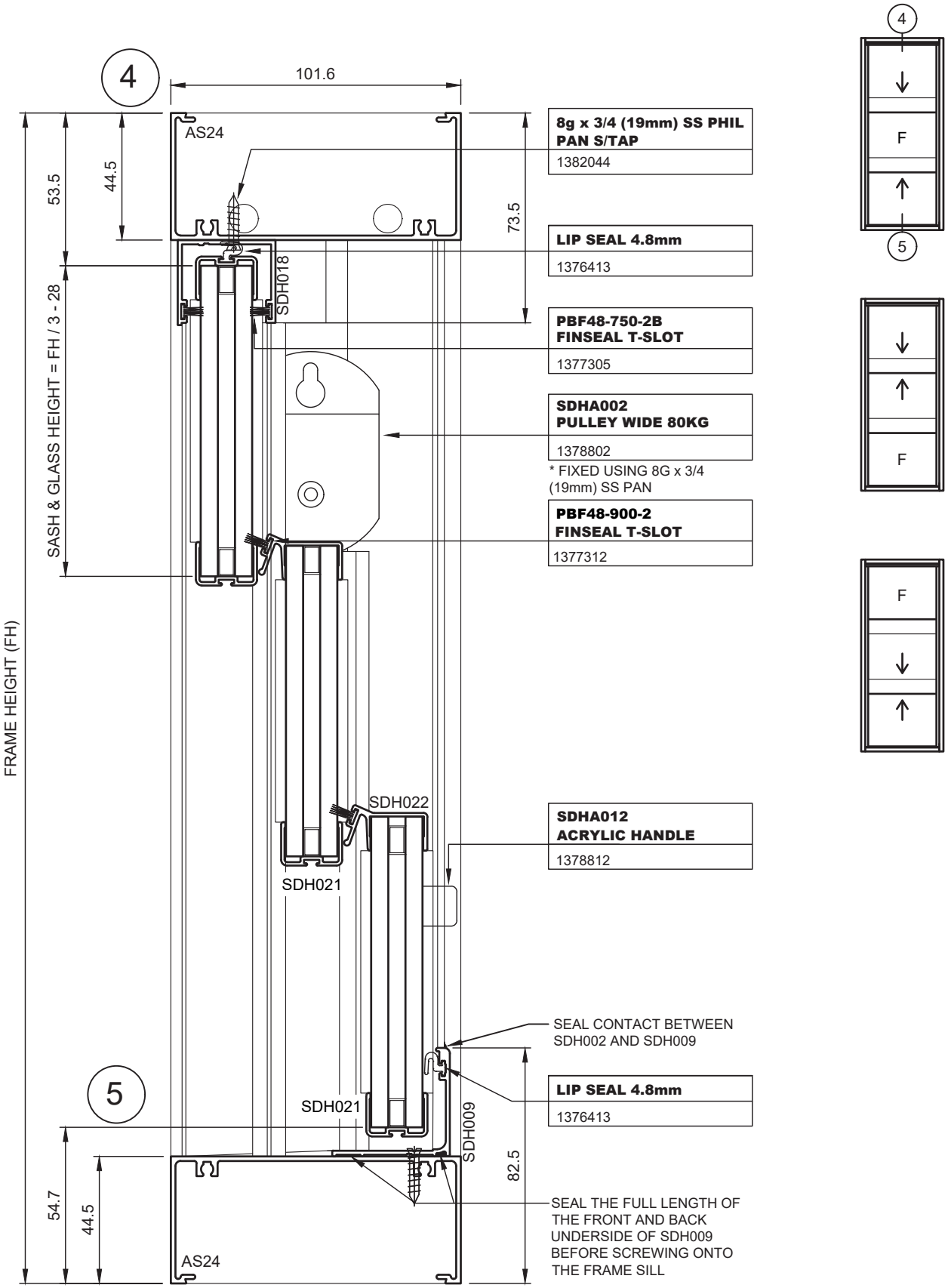




3

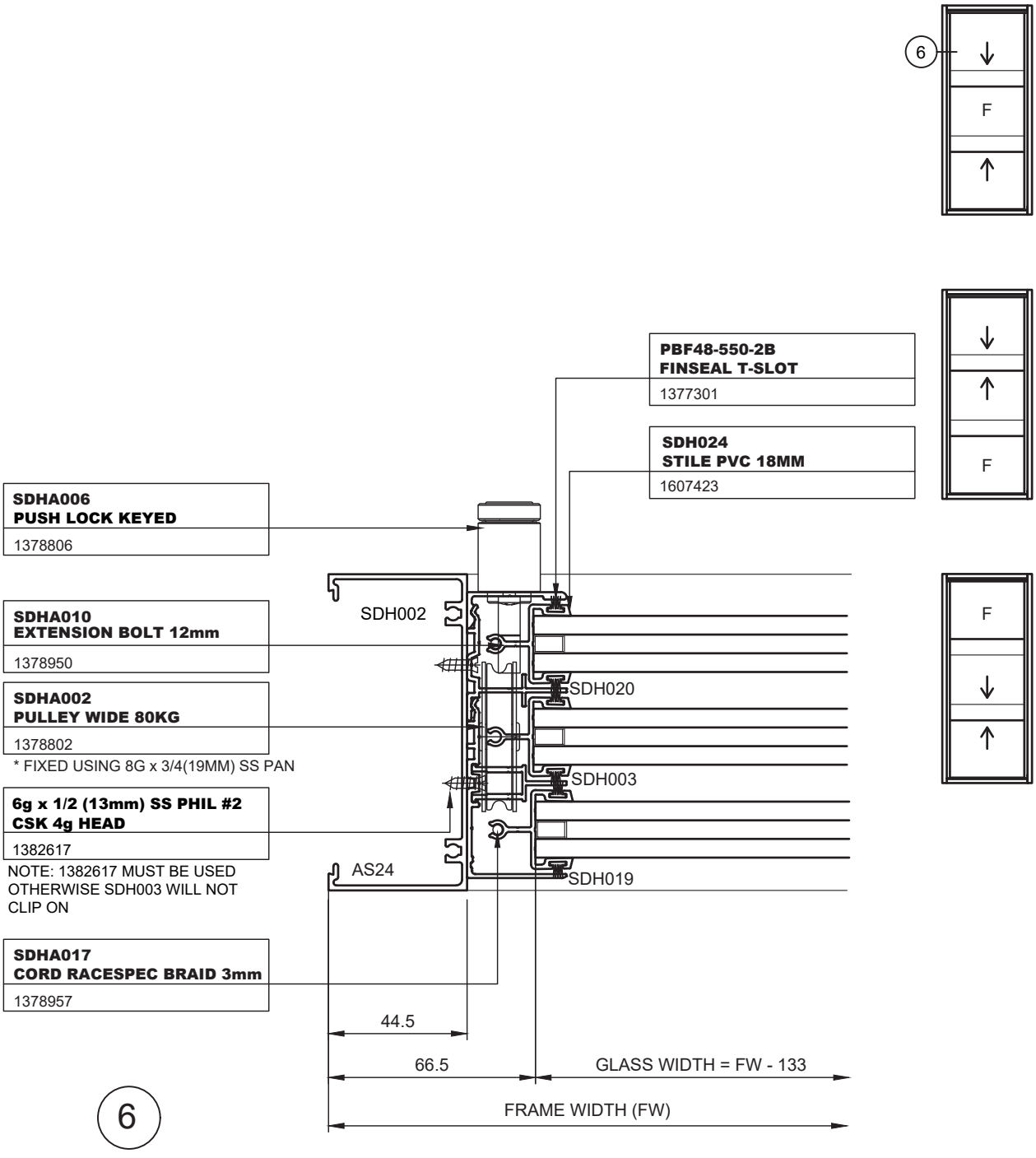
8. Typical Details

3 Pane Typical Head & Sill Detail - 18mm Double Glazed



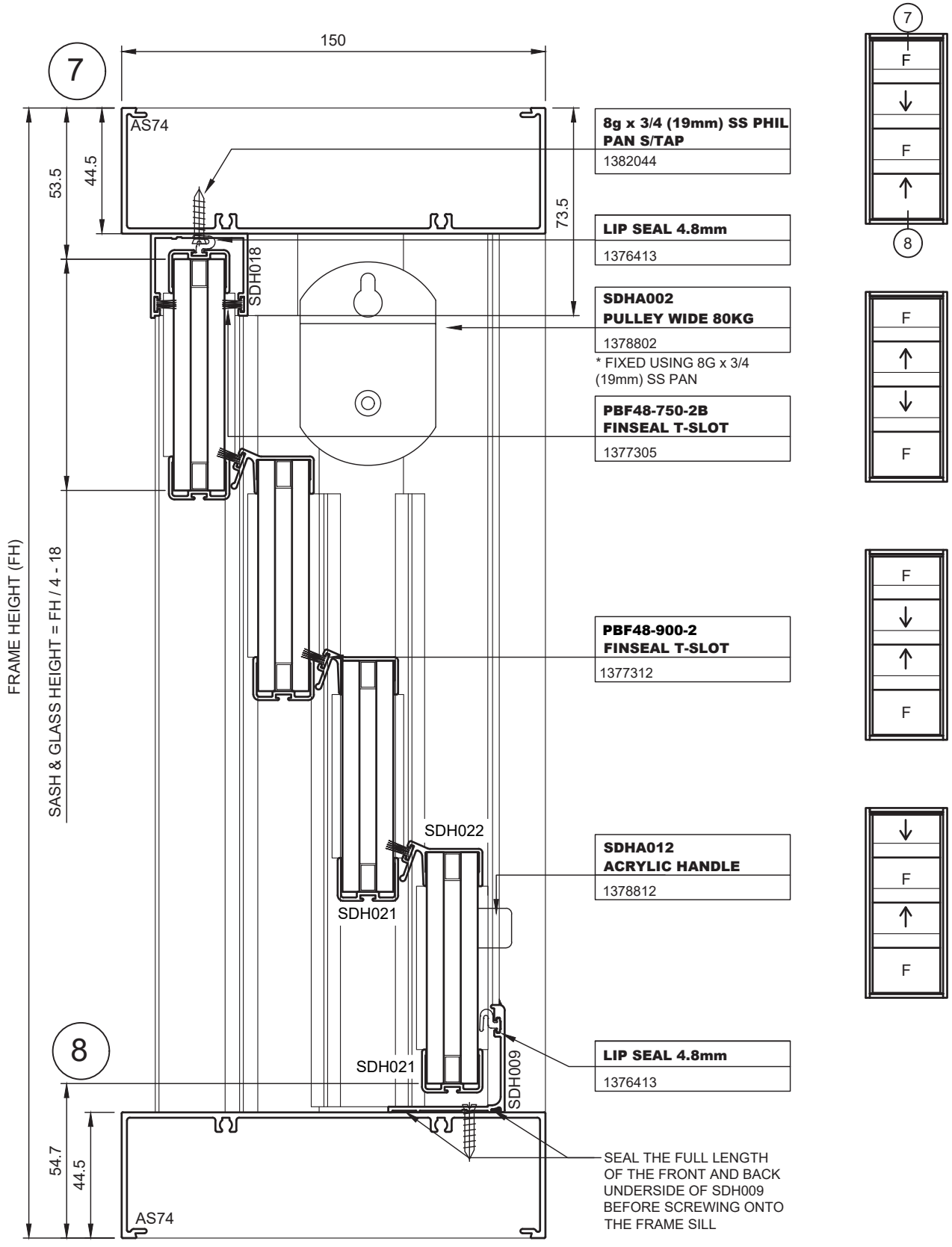
8. Typical Details

3 Pane Typical Jamb Detail - 18mm Double Glazed



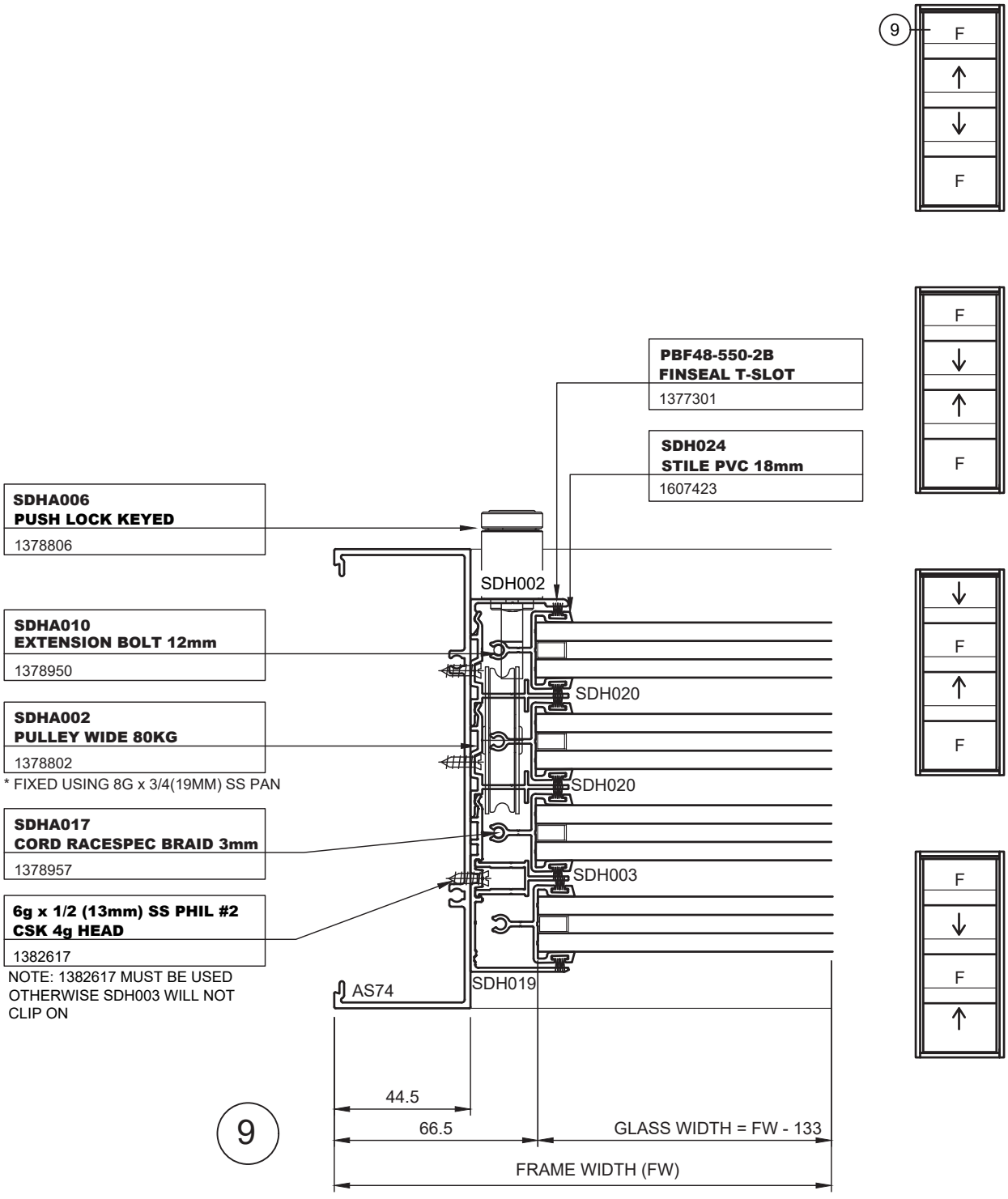
8. Typical Details

Typical Head & Sill Detail - 18mm Double Glazed



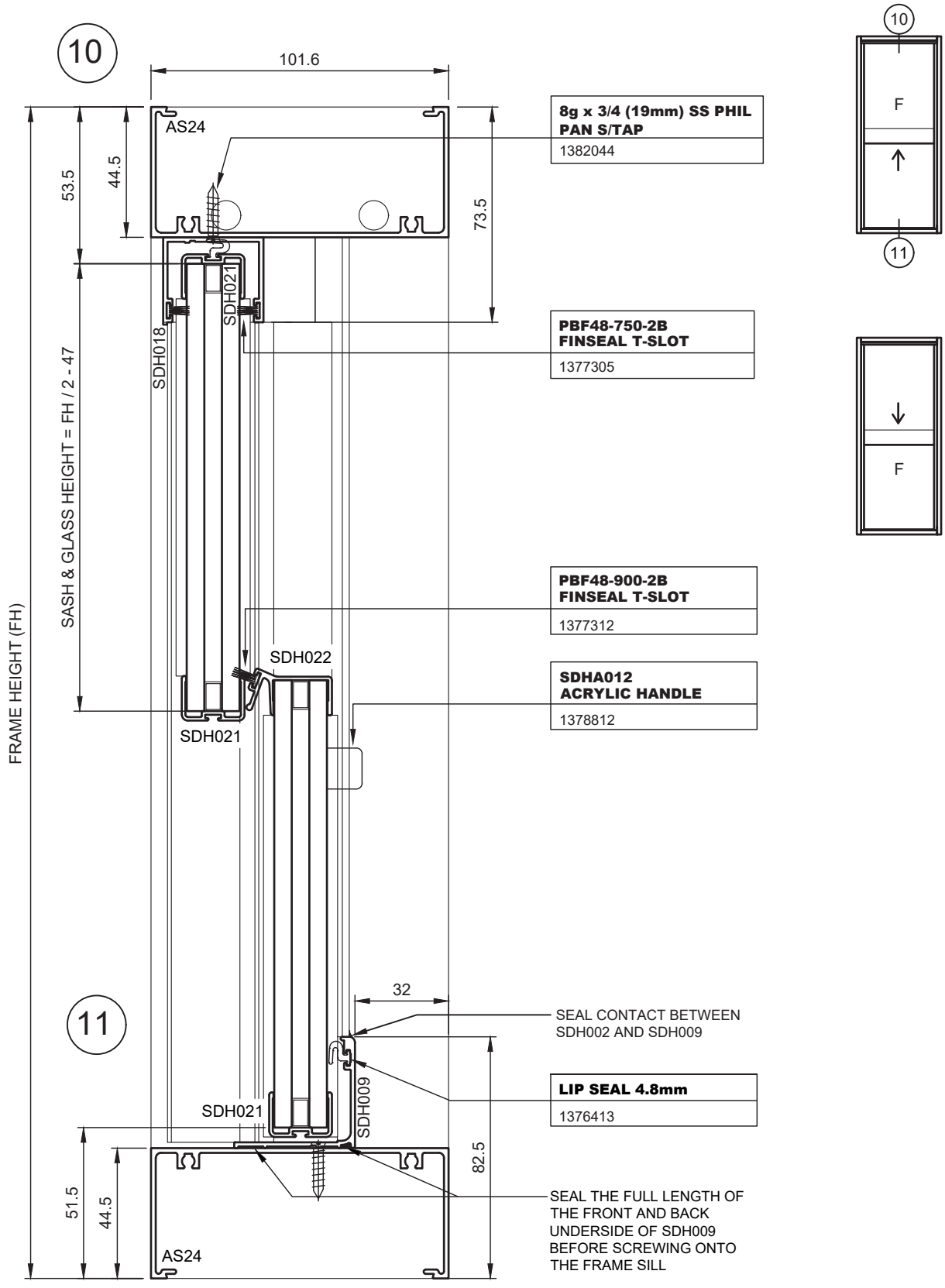
8. Typical Details

3 Pane Typical Jamb Detail - 18mm Double Glazed



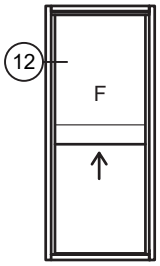
8. Typical Details

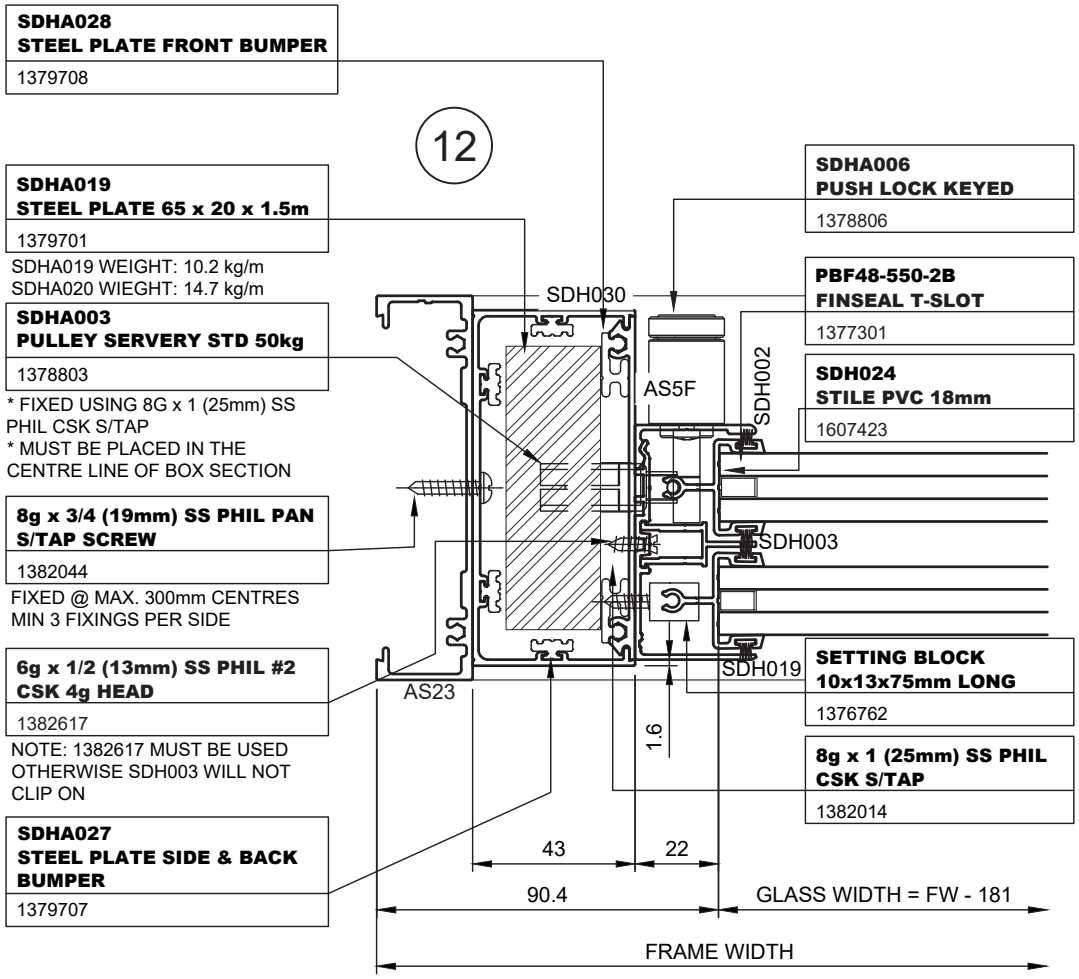
2 Pane Servery Typical Head & SIll Detail - 18mm Double Glazed



8. Typical Details

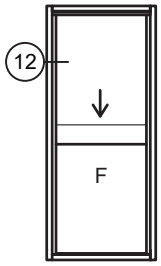
2 Pane Servery Typical Jamb Detail - 18mm Double Glazed

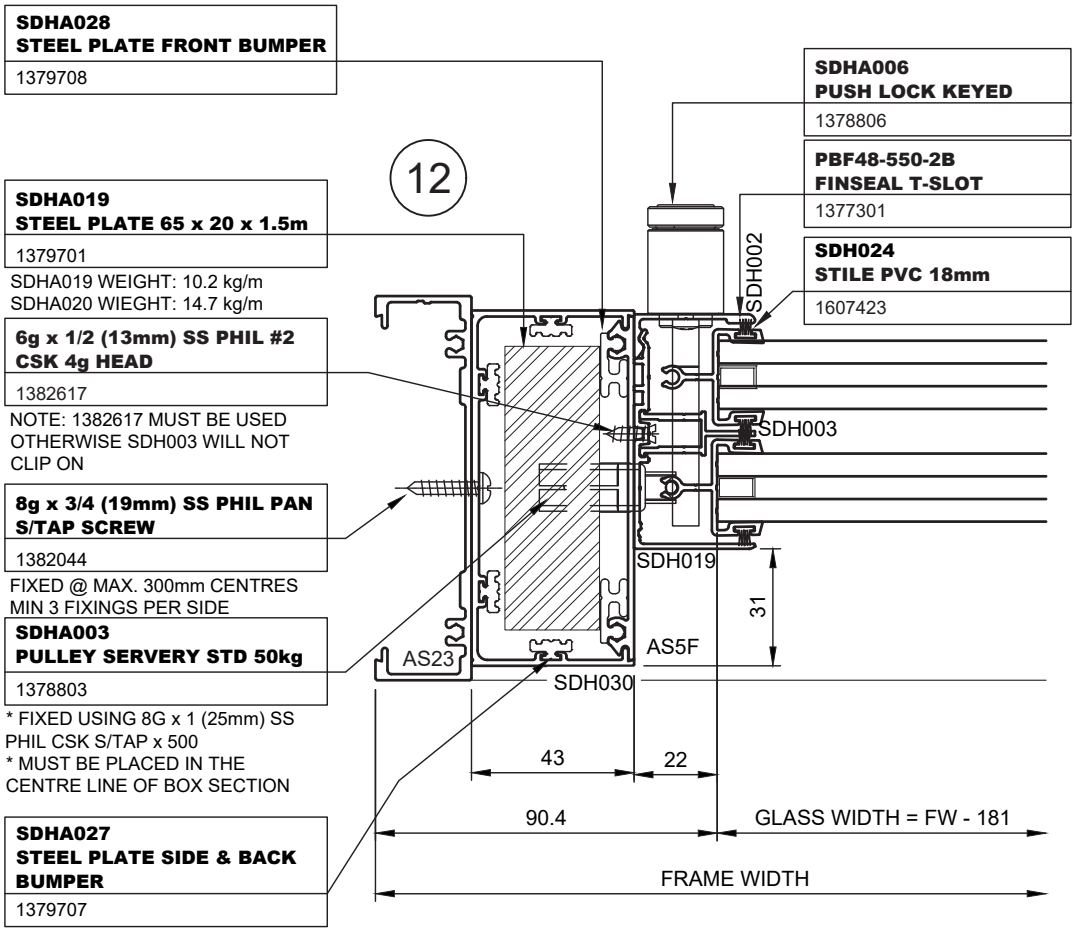




8. Typical Details

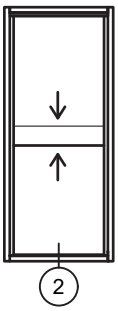
2 Pane Servery Typical Jamb Detail - 18mm Double Glazed

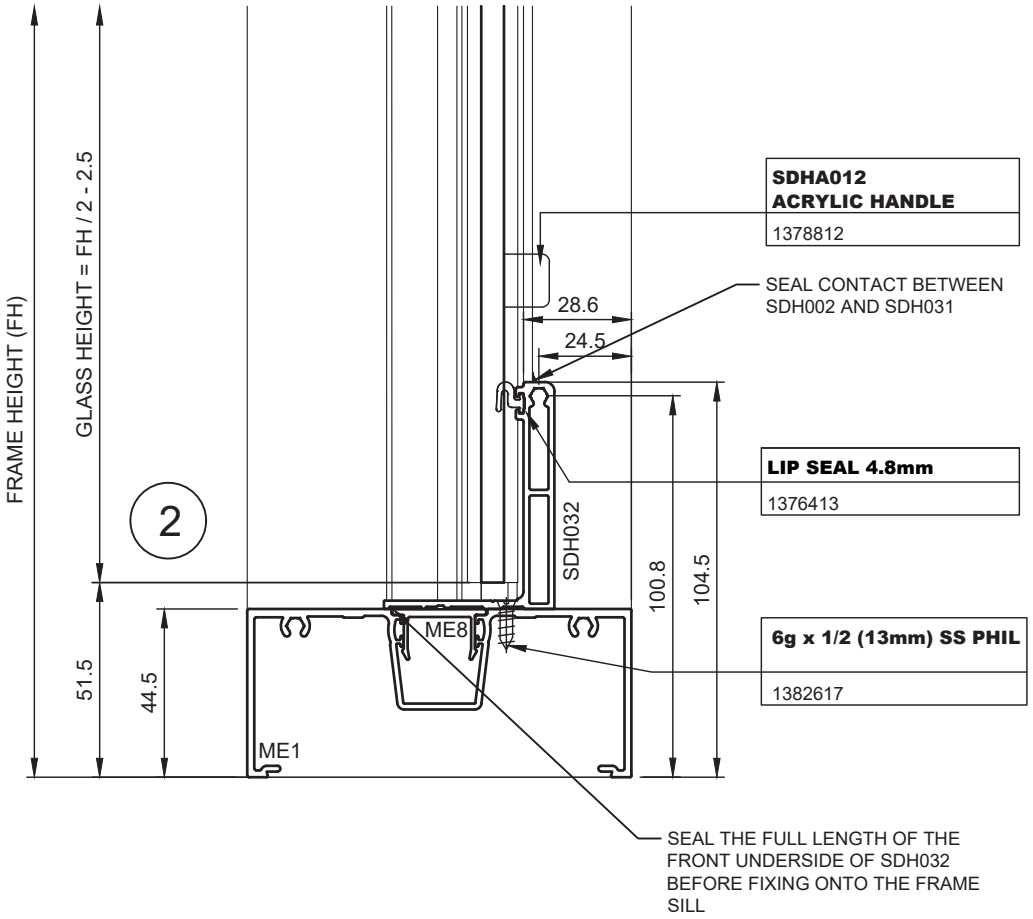




8. Typical Details

450Pa High Sill Option

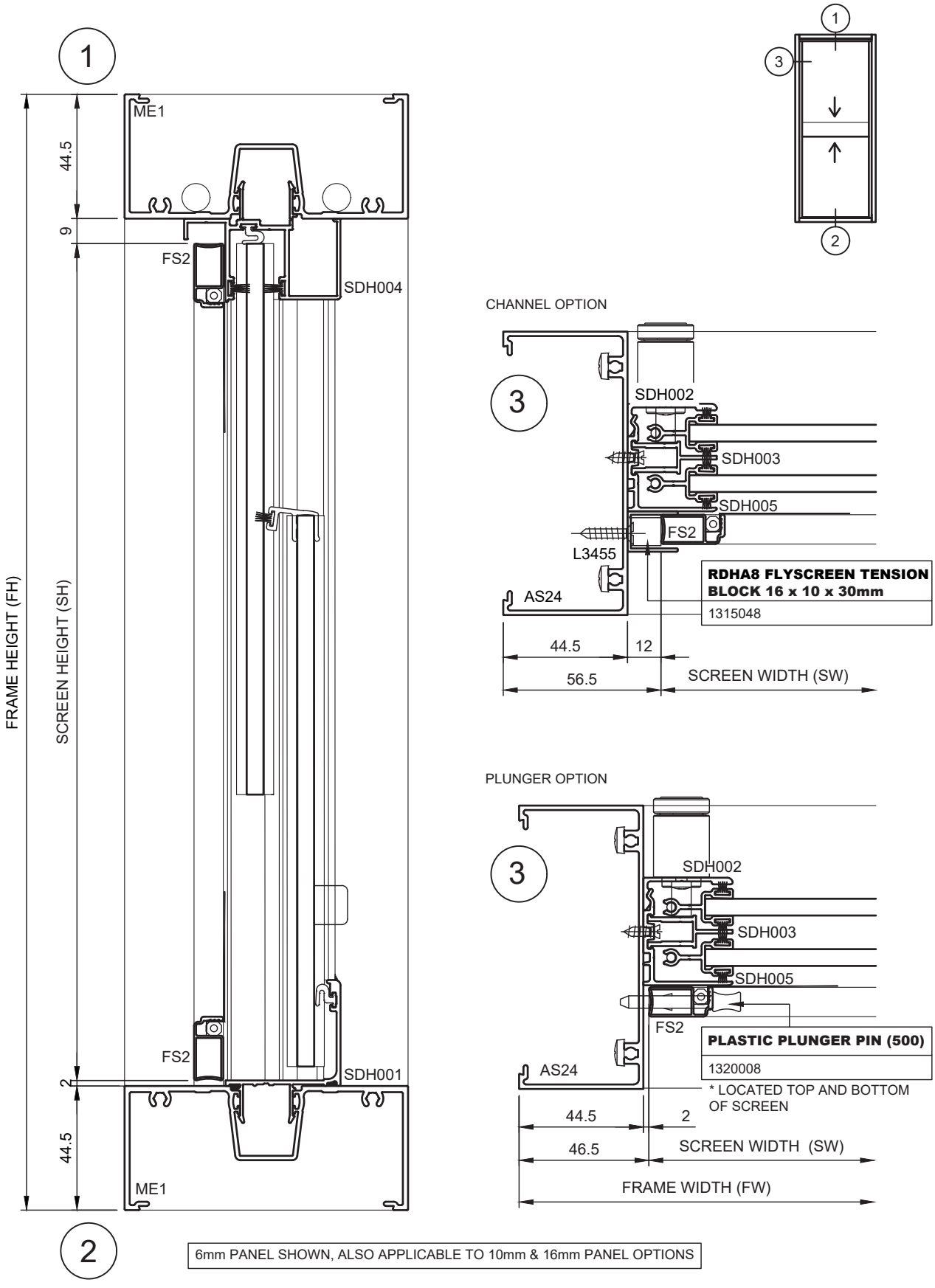




2 PANEL SHOWN, 450Pa SILL ALSO AVAILABLE FOR 10mm AND 18mm DG FRAMES

8. Typical Details

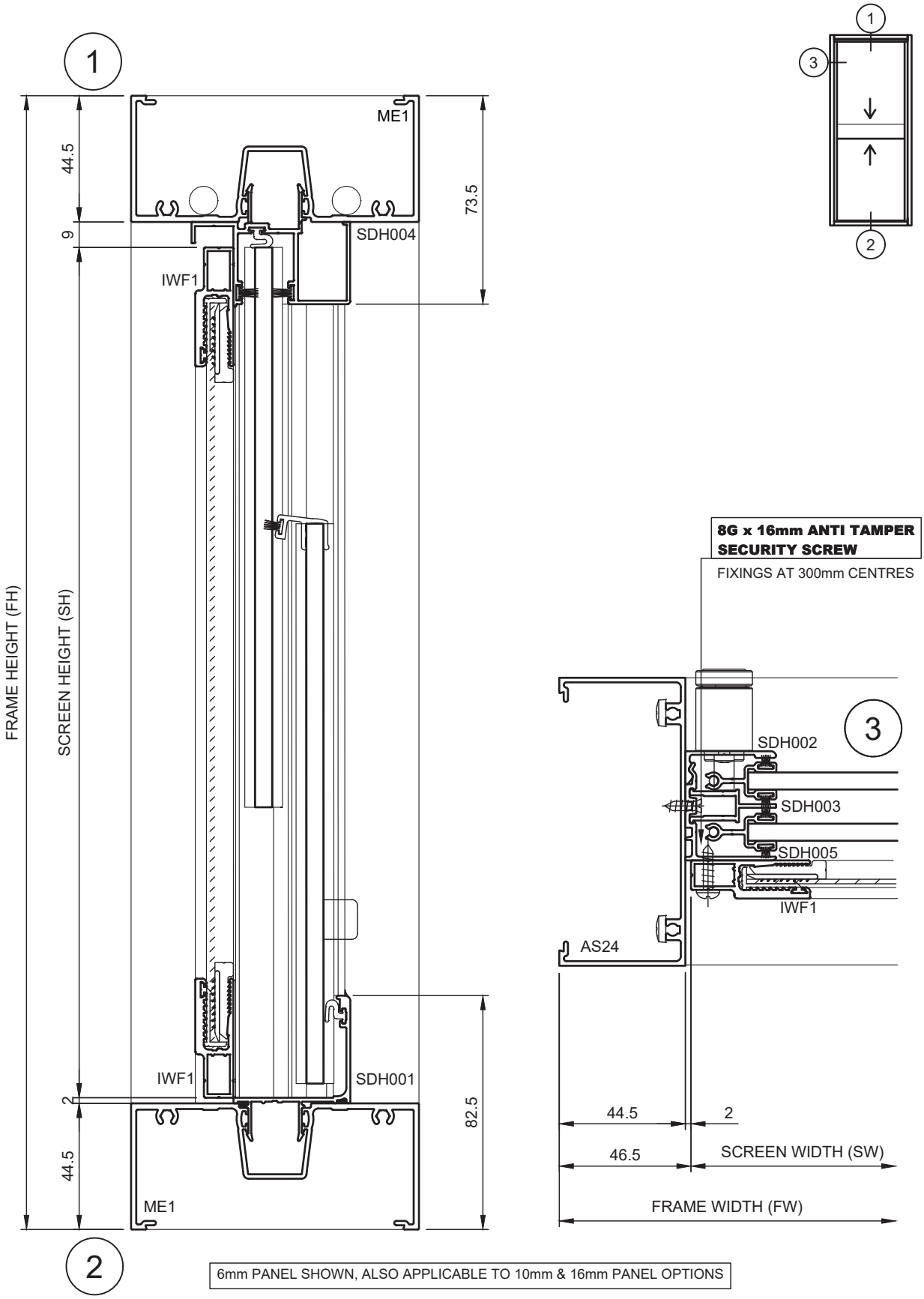
Typical Flyscreen Detail



6mm PANEL SHOWN, ALSO APPLICABLE TO 10mm & 16mm PANEL OPTIONS

8. Typical Details

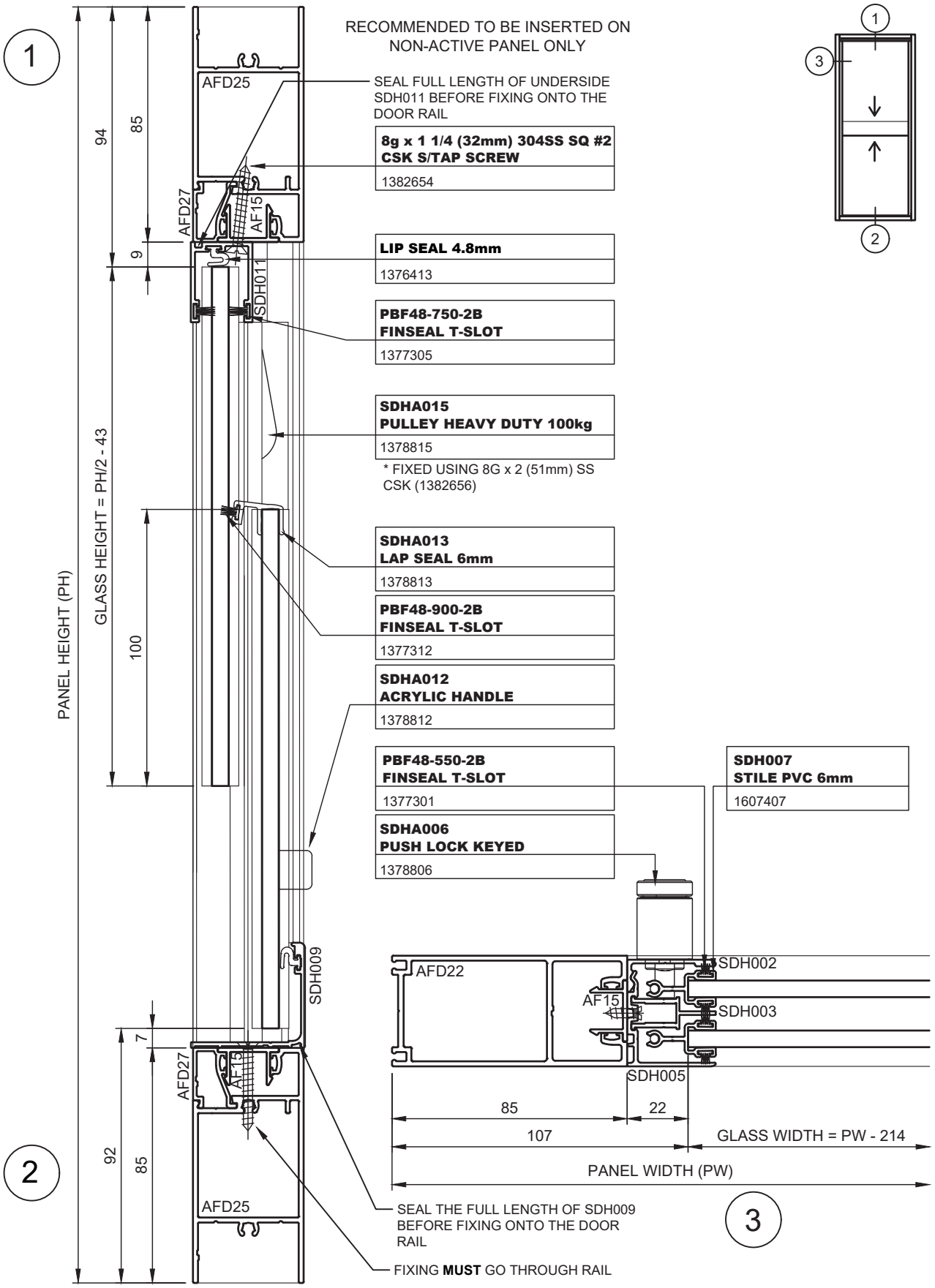
Typical Invisi-Gard Screen Detail



6mm PANEL SHOWN, ALSO APPLICABLE TO 10mm & 16mm PANEL OPTIONS

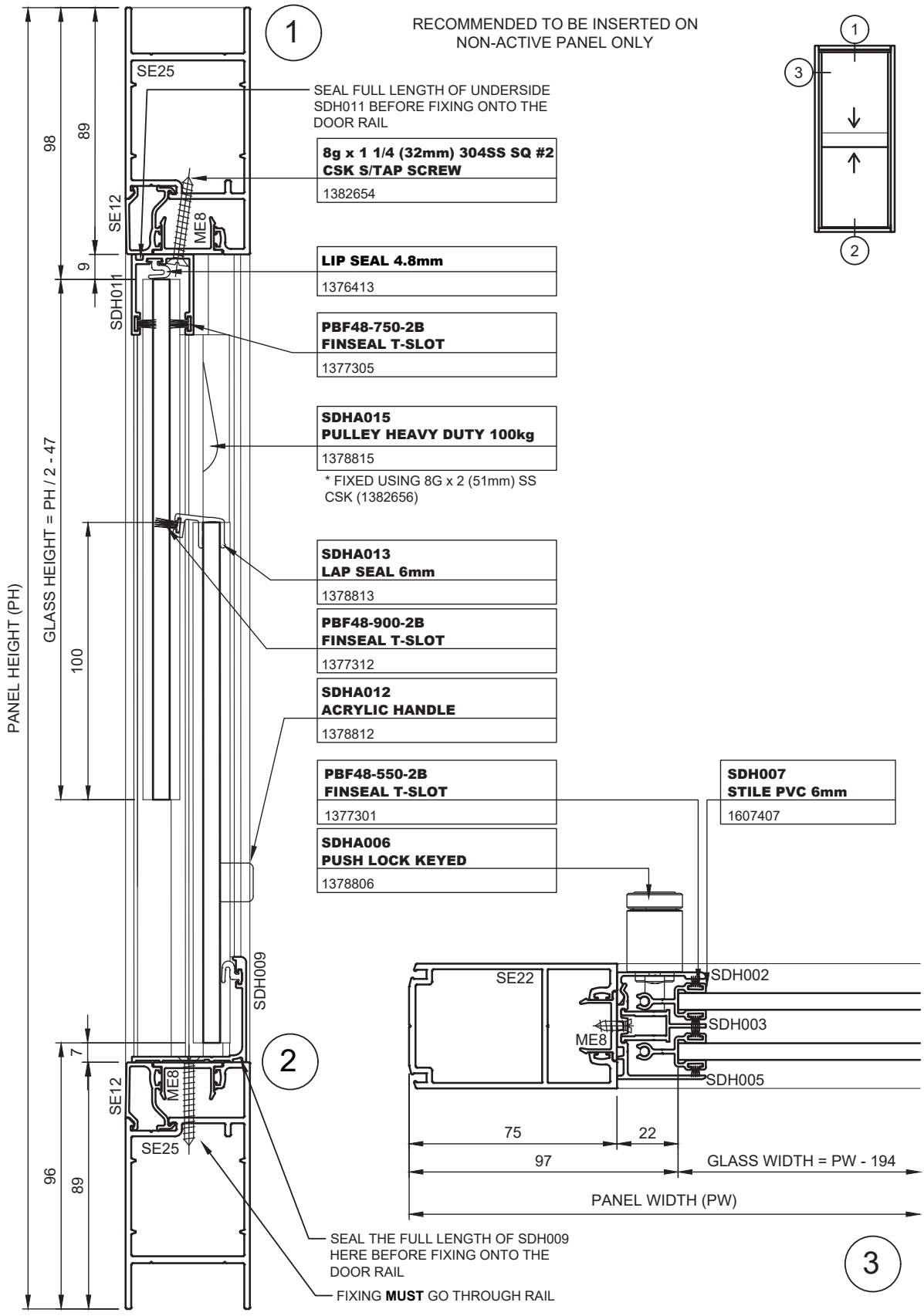
8. Typical Details

Insert into Hinged Door - Air-Flo® & Carinya® 40mm Door Panel



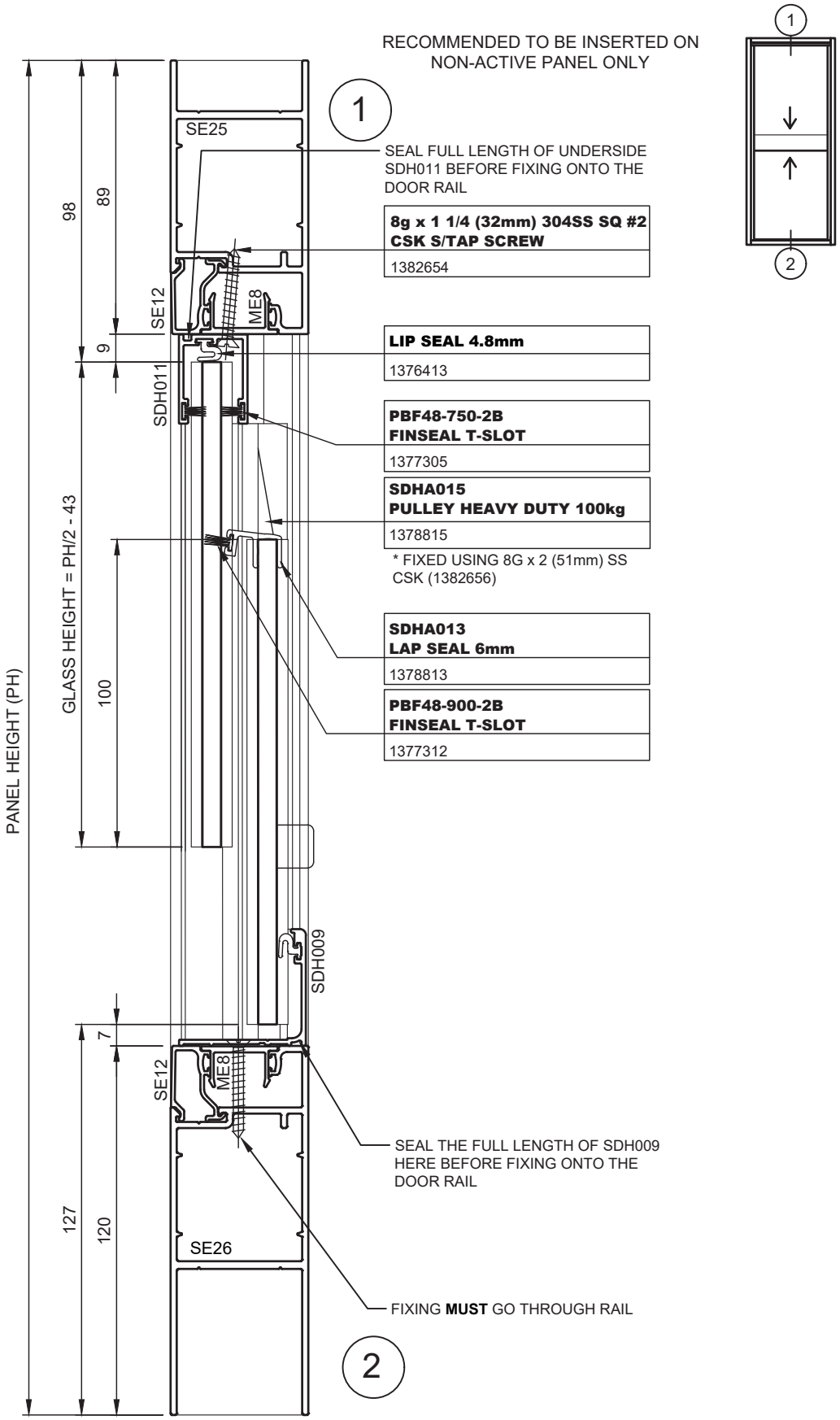
8. Typical Details

Insert into Panel - Swan Evo® 45mm Door Panel



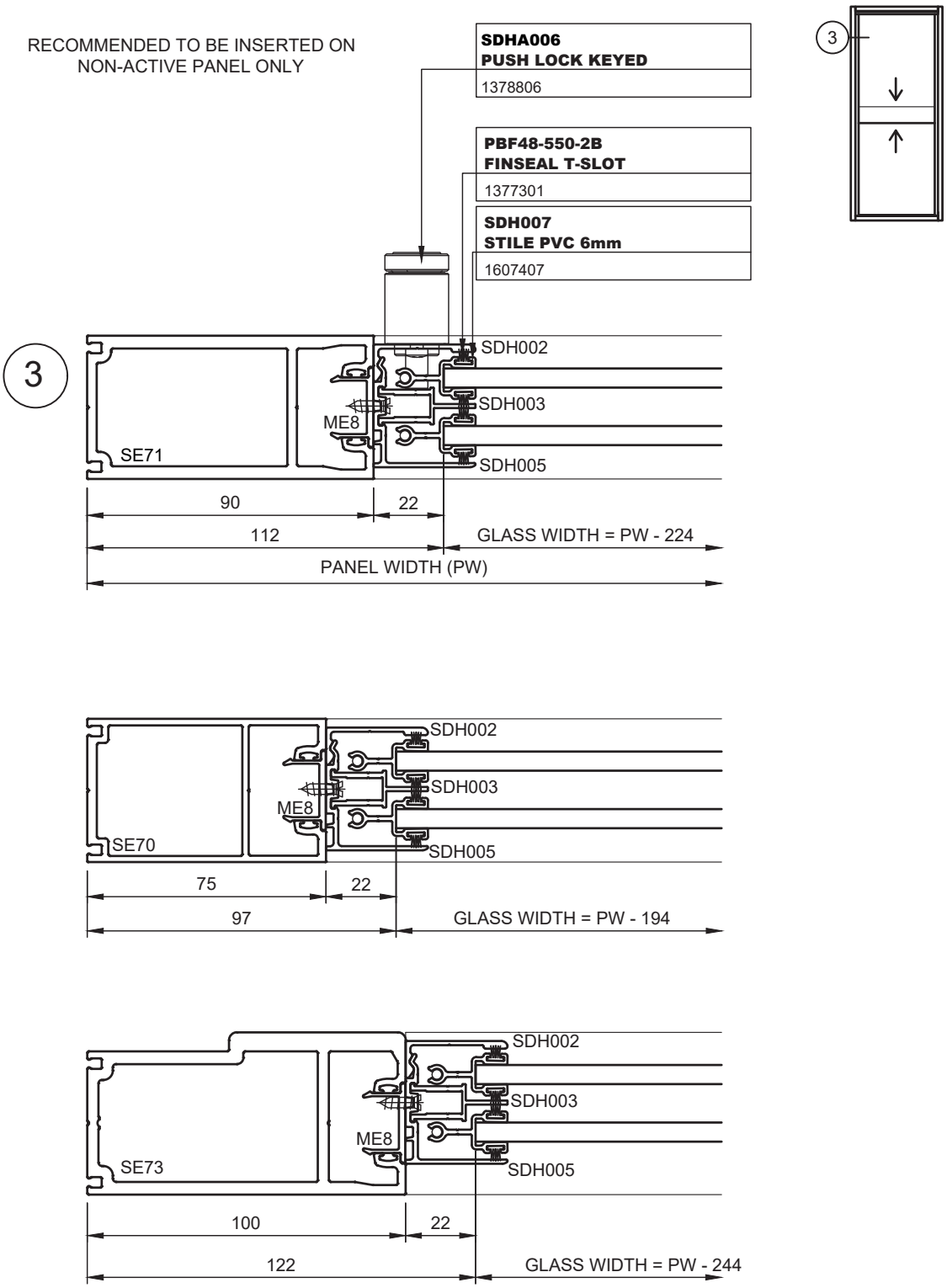
8. Typical Details

Insert into Panel - Hawkesbury® Bifold 45mm Door Panel - Head & Sill



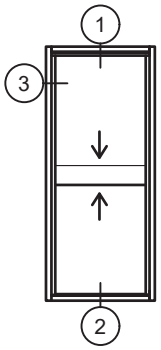
8. Typical Details

Insert into Panel - Hawkesbury® Bifold 45mm Door Panel - Jamb



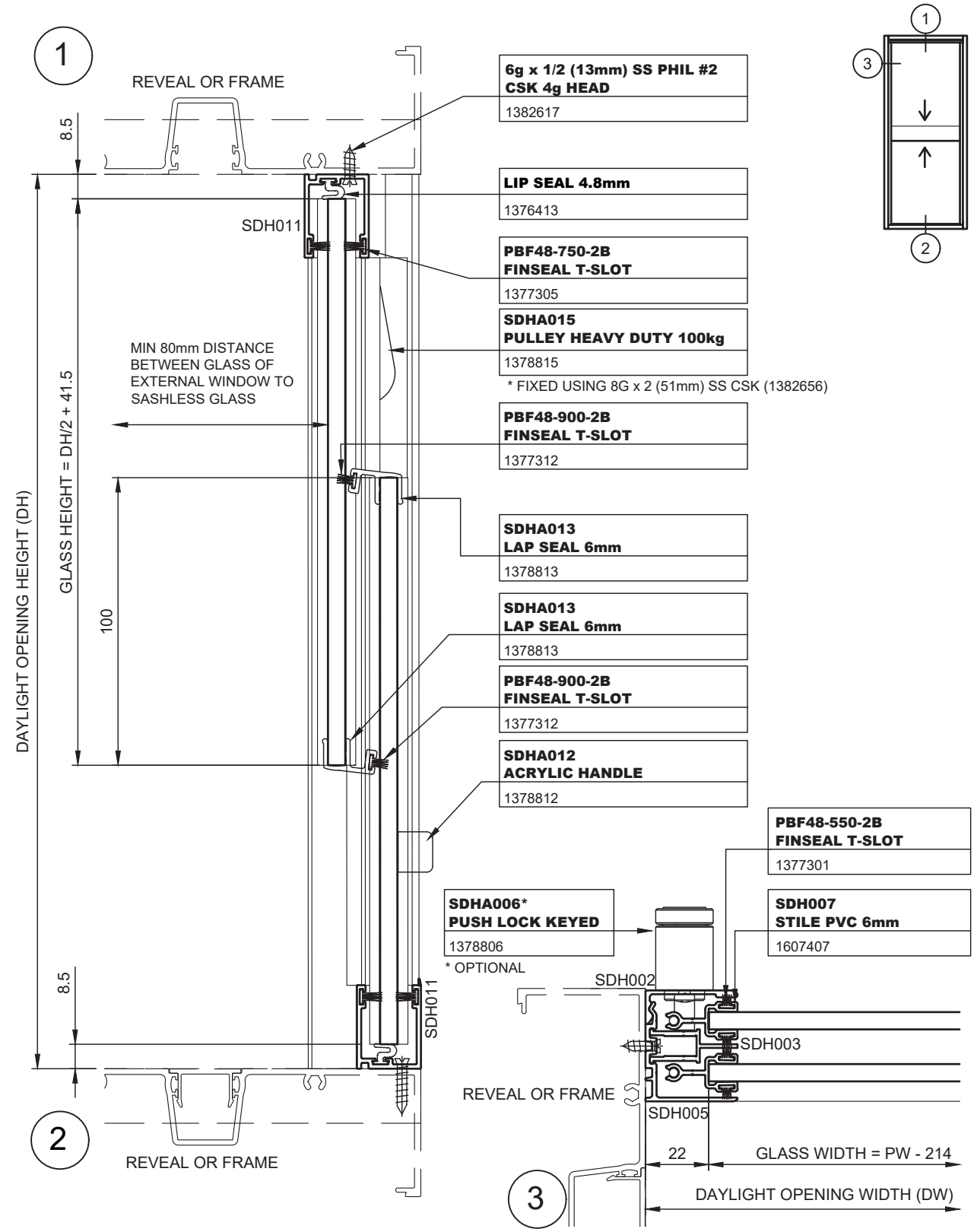
8. Typical Details

Insert into Panel - Hawkesbury® Top Hung 45mm Door Panel



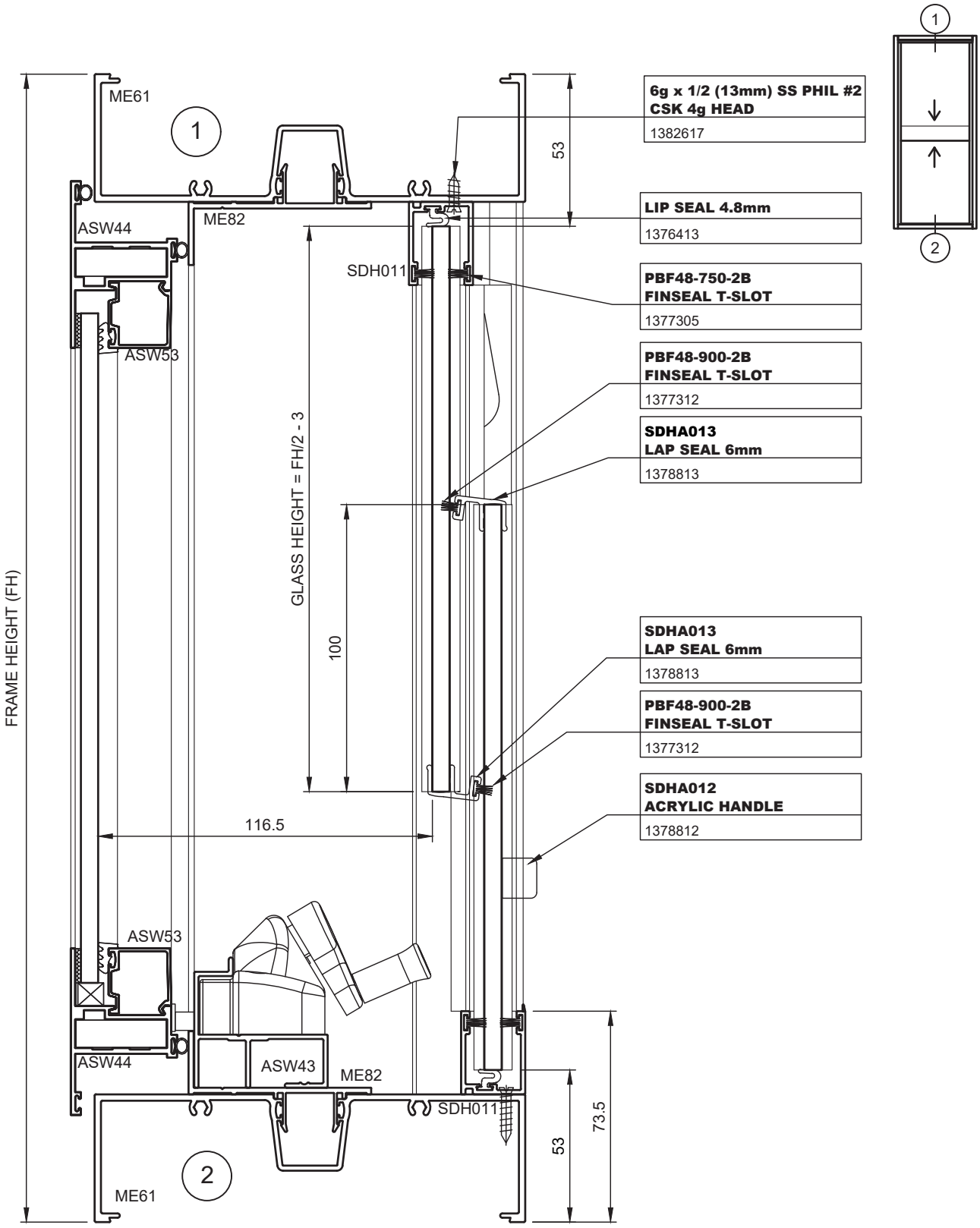
8. Typical Details

Acoustic Secondary Glazed Window



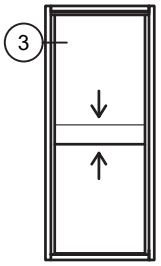
8. Typical Details

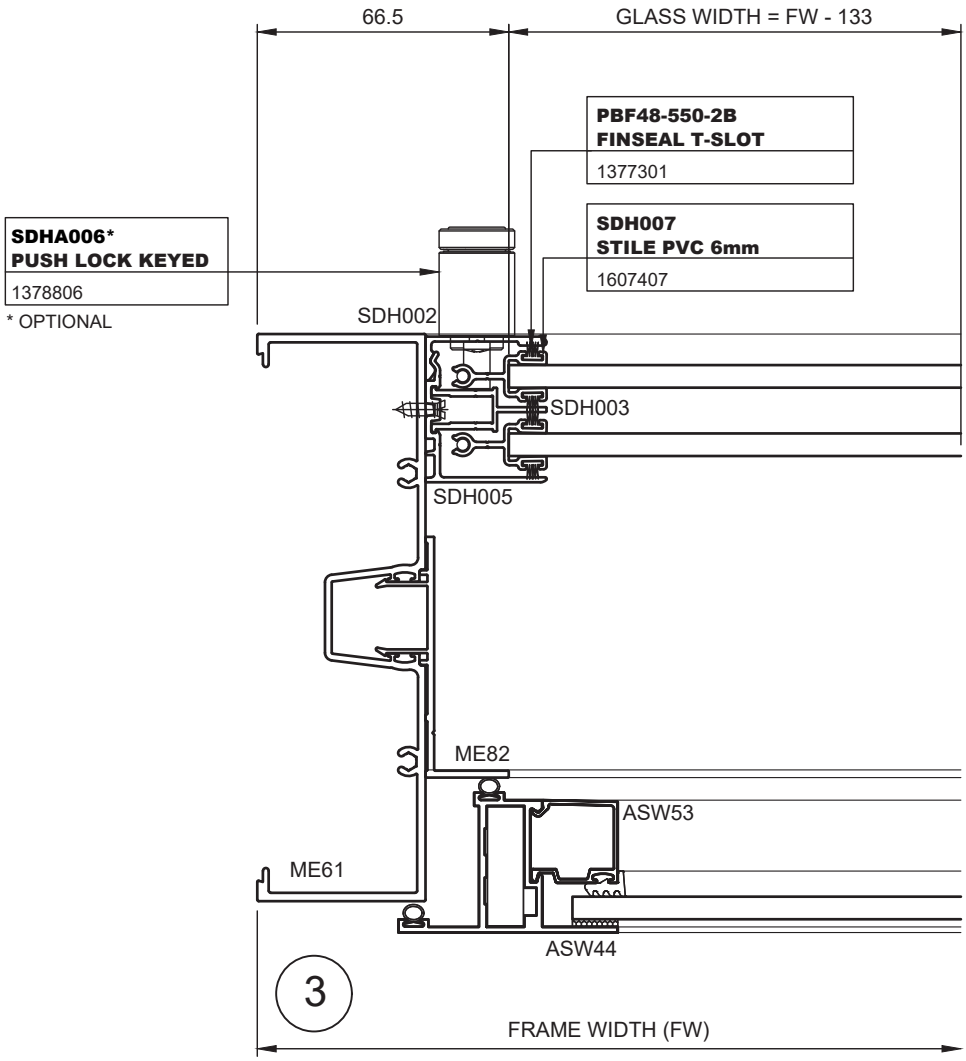
Acoustic Secondary Glazed Window - McArthur Evo 150mm Head & Sill Detail



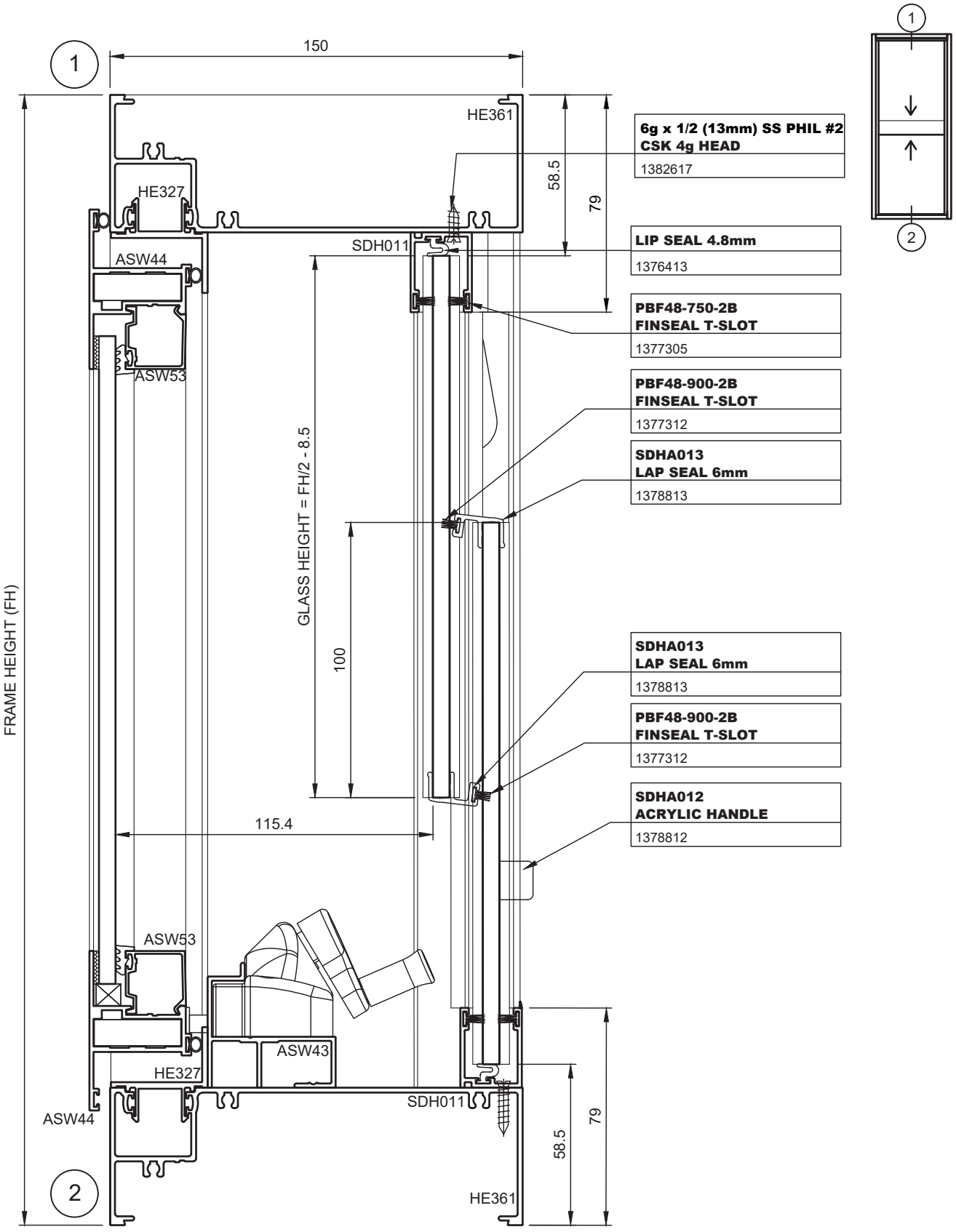
8. Typical Details

Acoustic Secondary Glazed Window - McArthur Evo 150mm Jamb Detail



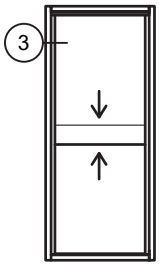


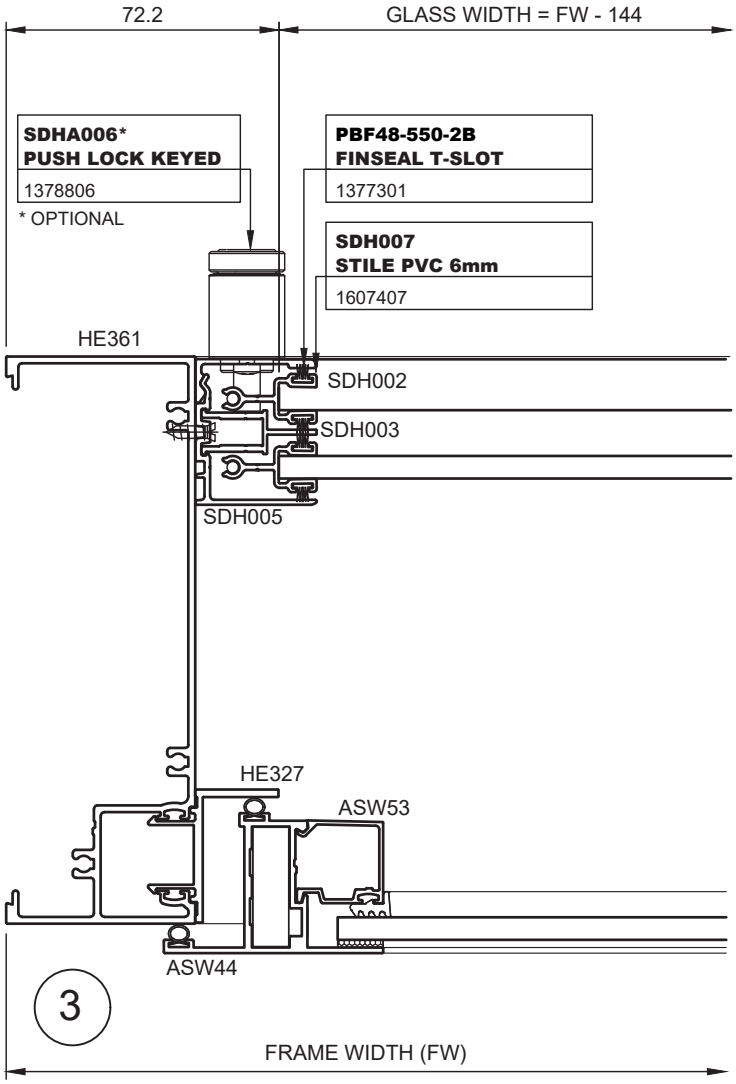
Acoustic Secondary Glazed Window - Hunter Evo 150mm Head & Sill Detail



8. Typical Details

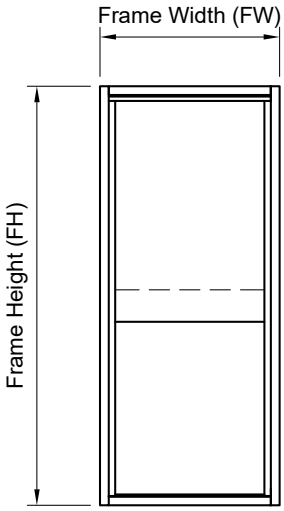
Acoustic Secondary Glazed Window - Hunter Evo 150mm Jamb Detail

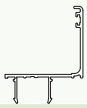
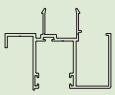
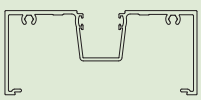




9. Cutting Formulas

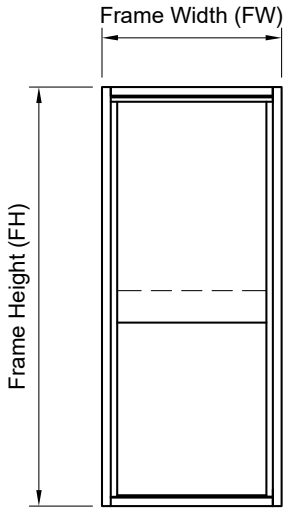
2 Pane - 6mm

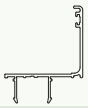
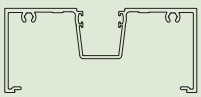


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH001	Sill 38mm	FRAME WIDTH - 89	1
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 156	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH004	Head 6mm	FRAME WIDTH - 89	1
	SDH005	Jamb Outer Leg 6mm	FRAME HEIGHT - 120	2
	SDH007	Stile Pvc 6mm x 3m	FRAME HEIGHT/2 - 0.5	4
	SDHA013	Lap Seal 6mm x 3m	FRAME WIDTH - 154	1
	ME1	Frame/Jamb	FRAME HEIGHT	2
			FRAME WIDTH - 89	2
	ME8	Pocket Filler	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/2 - 2.5	2
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

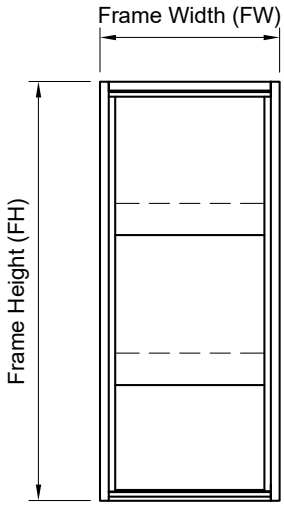
2 Pane - 10mm

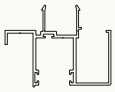


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH001	Sill 38mm	FRAME WIDTH- 89	1
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH014	Head 10mm	FRAME WIDTH - 89	1
	SDH015	Jamb Outer Leg 10mm	FRAME HEIGHT - 120	2
	SDH017	Stile Pvc 10mm x 3m	FRAME HEIGHT/2 - 0.5	4
	SDHA014	Lap Seal 10mm x 3m	FRAME WIDTH - 154	1
	ME1	Frame/Jamb	FRAME HEIGHT FRAME WIDTH - 89	2 2
	ME8	Pocket Filler	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/2 - 2.5	2
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

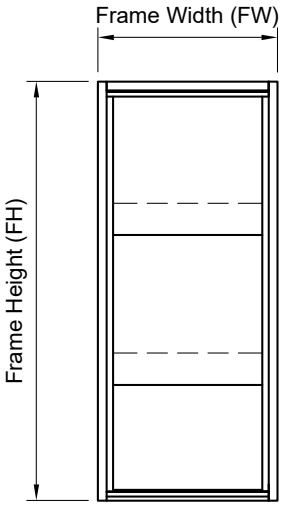
3 Pane - 6mm



PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH004	Head 6mm	FRAME WIDTH - 89	1
	SDH005	Jamb Outer Leg 6mm	FRAME HEIGHT - 118	2
	SDH006	Jamb Add-On Leg 6mm	FRAME HEIGHT - 118	2
	SDH007	Stile Pvc 6mm x 3m	FRAME HEIGHT/3 + 33.5	6
	SDH009	Sill (No Legs)	FRAME WIDTH - 89	1
	SDHA013	Lap Seal 6mm x 3m	FRAME WIDTH - 154	2
	AS24	Plain Frame	FRAME HEIGHT FRAME WIDTH - 89	2 2
GLASS	HEIGHT		FRAME HEIGHT/3 + 31.5	3
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

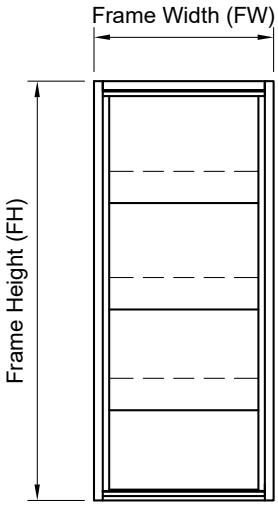
3 Pane - 10mm

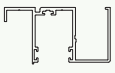


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 89	1
	SDH014	Head 10mm	FRAME WIDTH - 89	1
	SDH015	Jamb Outer Leg 10mm	FRAME HEIGHT - 118	2
	SDH016	Jamb Add-On Leg 10mm	FRAME HEIGHT - 91	2
	SDH017	Stile Pvc 10mm x 3m	FRAME HEIGHT/3 + 33.5	6
	SDHA014	Lap Seal 10mm x 3m	FRAME WIDTH - 154	2
	AS24	Plain Frame	FRAME HEIGHT FRAME WIDTH - 89	2 2
GLASS	HEIGHT		FRAME HEIGHT/3 + 31.5	3
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

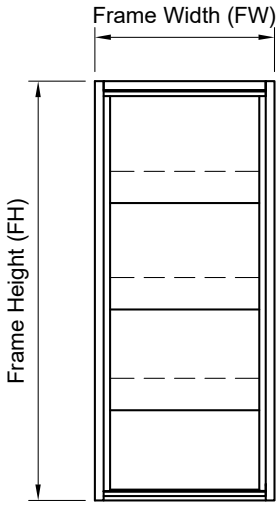
4 Pane - 6mm



PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 118	2
	SDH005	Jamb Outer Leg 6mm	FRAME HEIGHT - 118	2
	SDH006	Jamb Add-On Leg 6mm	FRAME HEIGHT - 120	4
	SDH007	Stile Pvc 6mm x 3m	FRAME HEIGHT/4 + 50.5	8
	SDH009	Sill (No Legs)	FRAME WIDTH - 89	1
	SDH010	Head 6mm No Legs	FRAME WIDTH - 89	1
	SDHA013	Lap Seal 6mm x 3m	FRAME WIDTH - 154	3
	AS24	Plain Frame	FRAME HEIGHT FRAME WIDTH - 89	2 2
GLASS	HEIGHT		FRAME HEIGHT/4 + 48.5	4
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

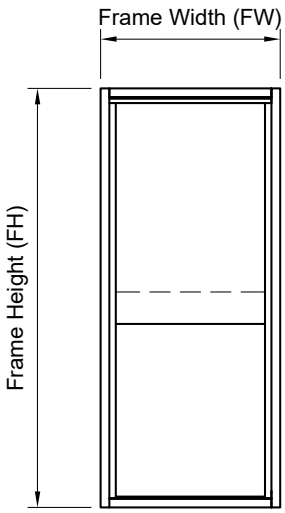
4 Pane - 10mm

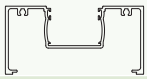


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 118	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 89	1
	SDH014	Head 10mm	FRAME WIDTH - 89	1
	SDH015	Jamb Outer Leg 10mm	FRAME HEIGHT - 118	2
	SDH016	Jamb Add-On Leg 10mm	FRAME HEIGHT - 91	4
	SDH017	Stile Pvc 10mm x 3m	FRAME HEIGHT/4 + 50.5	8
	SDHA014	Lap Seal 10mm x 3m	FRAME WIDTH - 154	3
	AS24	Plain Frame	FRAME HEIGHT FRAME WIDTH - 89	2 2
GLASS	HEIGHT		FRAME HEIGHT/4 + 48.5	4
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

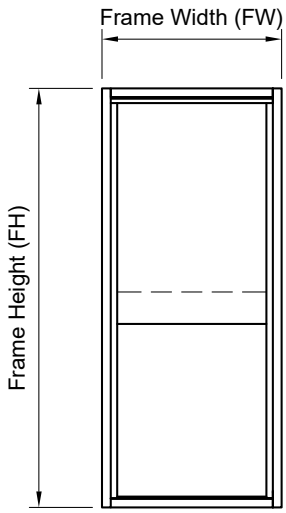
2 Pane - 18mm into ecoFRAMEplus



PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	ECO286	SDH Sill Adaptor	FRAME WIDTH - 100	1
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 167	2
	SDH003	Jamb Runner	FRAME HEIGHT - 131	2
	ECO287	SDH Head 18mm Adaptor	FRAME WIDTH - 100	1
	ECO288	SDH Jamb Outer 18mm Adaptor	FRAME HEIGHT - 131	2
	SDH024	Stile Pvc 18mm x 3m	FRAME HEIGHT/2 - 51	4
	SDH022	Interlock 18mm	FRAME WIDTH - 142	1
	SDH021	Rail 18mm	FRAME WIDTH - 142	3
	ECO201	Frame/Jamb	FRAME WIDTH - 100 FRAME HEIGHT	2 2
GLASS	HEIGHT		FRAME HEIGHT/2 - 53	2
	WIDTH		FRAME WIDTH - 144	

9. Cutting Formulas

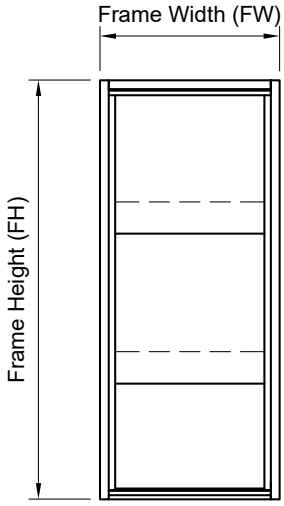
2 Pane - 18mm



PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH001	Sill 38mm	FRAME WIDTH - 89	1
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH018	Head 18mm	FRAME WIDTH - 89	1
	SDH019	Jamb Outer Leg 18mm	FRAME HEIGHT - 120	2
	SDH024	Stile Pvc 18mm x 3m	FRAME HEIGHT/2 - 45	4
	SDH022	Interlock 18mm	FRAME WIDTH - 130	1
	SDH021	Rail 18mm	FRAME WIDTH - 130	3
	ME1	Frame/Jamb	FRAME WIDTH - 89	1
	ME8	Pocket Filler	FRAME WIDTH - 86	1
	AS24	Plain Frame	FRAME HEIGHT FRAME WIDTH - 89	2 1
GLASS	HEIGHT		FRAME HEIGHT/2 - 47	2
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

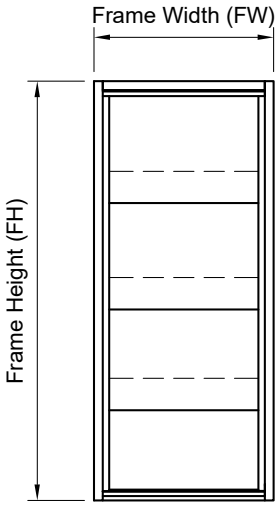
3 Pane - 18mm



PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 89	1
	SDH018	Head 18mm	FRAME WIDTH - 89	1
	SDH019	Jamb Outer Leg 18mm	FRAME HEIGHT - 118	2
	SDH020	Add-On Leg 18mm	FRAME HEIGHT - 91	2
	SDH024	Stile Pvc 18mm x 3m	FRAME HEIGHT/3 - 26	6
	SDH022	Interlock 18mm	FRAME WIDTH - 130	2
	SDH021	Rail 18mm	FRAME WIDTH - 130	4
	AS24	Plain Frame	FRAME HEIGHT	2
			FRAME WIDTH - 89	2
GLASS	HEIGHT		FRAME HEIGHT/3 - 28	3
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

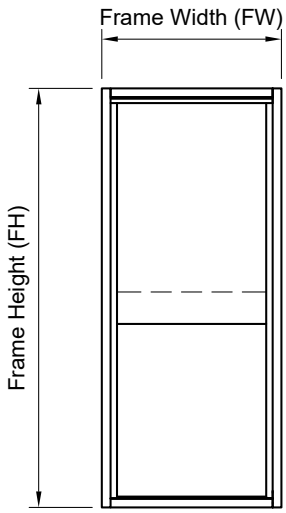
4 Pane - 18mm

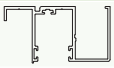


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 127	2
	SDH003	Jamb Runner	FRAME HEIGHT - 118	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 89	1
	SDH018	Head 18mm	FRAME WIDTH - 89	1
	SDH021	Rail 18mm	FRAME WIDTH - 130	5
	SDH019	Jamb Outer Leg 18mm	FRAME HEIGHT - 118	2
	SDH020	Add-On Leg 18mm	FRAME HEIGHT - 91	4
	SDH024	Stile Pvc 18mm x 3m	FRAME HEIGHT/4 - 16	8
	SDH022	Interlock 18mm	FRAME WIDTH - 130	3
	AS74	150mm Plain Frame	FRAME HEIGHT	2
			FRAME WIDTH - 89	2
GLASS	HEIGHT		FRAME HEIGHT/4 - 18	4
	WIDTH		FRAME WIDTH - 133	

9. Cutting Formulas

Servery 2 Pane - 6 mm

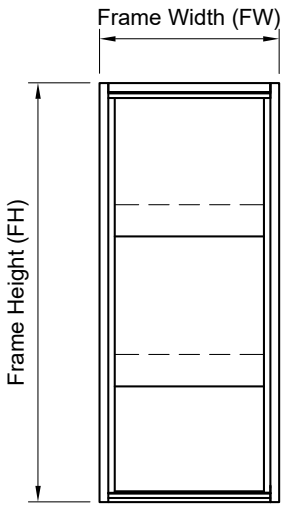


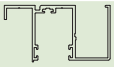
PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	AS5	Flush Adaptor	FRAME HEIGHT - 89	1
	AS23	25mm Plain Frame	FRAME HEIGHT	2
	AS24	Plain Frame	FRAME WIDTH - 50.8	2
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 156	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH005	Jamb Outer Leg 6mm	FRAME HEIGHT - 120	2
	SDH007	Stile Pvc 6mm x 3m	FRAME HEIGHT/2 - 0.5	4
	SDH009	Sill (No Legs)	FRAME WIDTH - 136.8	1
	SDH010	Head 6mm No Legs	FRAME WIDTH - 136.8	1
	SDH030	Servery Box Channel 94 x 43mm	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/2 - 2.5	2
	WIDTH		FRAME WIDTH - 181	
STEEL PLATE	SDHA019	Steel Plate 65 x 20 x 1.5m	GLASS WEIGHT/2	2
	SDHA020	Steel Plate 75 x 25 x 1.5m		

* Refer To Glass Label For Glass Weight Or Use The Below Formula:
Glass Height x Glass Width x Glass Thickness x 2.5

9. Cutting Formulas

Servery 3 Pane - 6 mm

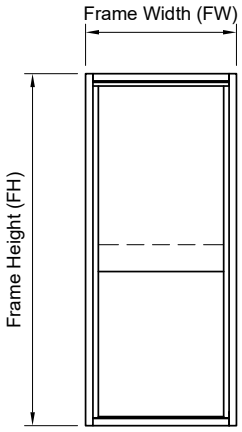


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	AS5	Flush Adaptor	FRAME HEIGHT - 89	1
	AS23	25mm Plain Frame	FRAME HEIGHT	2
	AS24	Plain Frame	FRAME WIDTH - 50.8	2
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 156	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH005	Jamb Outer Leg 6mm	FRAME HEIGHT - 120	2
	SDH006	Jamb Add-On Leg 6mm	FRAME HEIGHT - 120	2
	SDH007	Stile Pvc 6mm x 3m	FRAME HEIGHT/3 + 33.5	6
	SDH009	Sill (No Legs)	FRAME WIDTH - 136.8	1
	SDH010	Head 6mm No Legs	FRAME WIDTH - 136.8	1
	SDH030	Servery Box Channel 94 x 43mm	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/3 - 2.5	2
	WIDTH		FRAME WIDTH - 181	
STEEL PLATE	SDHA019	Steel Plate 65 x 20 x 1.5m	GLASS WEIGHT/3	2
	SDHA020	Steel Plate 75 x 25 x 1.5m		

* Refer To Glass Label For Glass Weight Or Use The Below Formula:
Glass Height x Glass Width x Glass Thickness x 2.5

9. Cutting Formulas

Servery 2 Pane - 10 mm

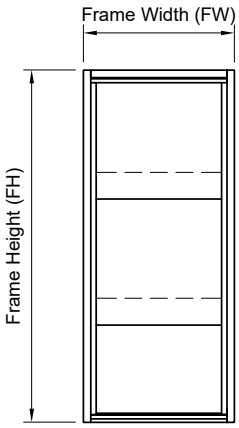


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	AS5	Flush Adaptor	FRAME HEIGHT - 89	1
	AS23	25mm Plain Frame	FRAME HEIGHT	2
	AS24	Plain Frame	FRAME WIDTH - 50.8	2
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 156	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 136.8	1
	SDH014	Head 10mm	FRAME WIDTH - 136.8	1
	SDH015	Jamb Outer Leg 10mm	FRAME HEIGHT - 120	2
	SDH017	Stile Pvc 10mm x 3m	FRAME HEIGHT/2 - 0.5	4
	SDH030	Servery Box Channel 94 x 43mm	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/2 - 2.5	2
	WIDTH		FRAME WIDTH - 181	
STEEL PLATE	SDHA019	Steel Plate 65 x 20 x 1.5m	GLASS WEIGHT/2	2
	SDHA020	Steel Plate 75 x 25 x 1.5m		

* Refer To Glass Label For Glass Weight Or Use The Below Formula:
Glass Height x Glass Width x Glass Thickness x 2.5

9. Cutting Formulas

Servery 3 Pane - 10 mm

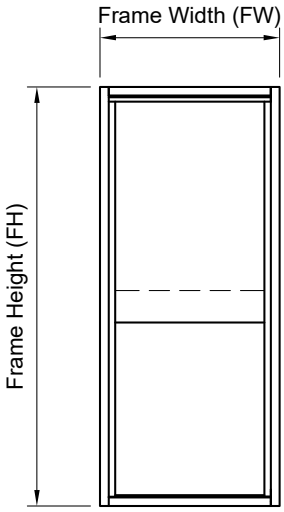


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	AS5	Flush Adaptor	FRAME HEIGHT - 89	1
	AS23	25mm Plain Frame	FRAME HEIGHT	2
	AS24	Plain Frame	FRAME WIDTH - 50.8	2
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 156	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 136.8	1
	SDH014	Head 10mm	FRAME WIDTH - 136.8	1
	SDH015	Jamb Outer Leg 10mm	FRAME HEIGHT - 120	2
	SDH016	Jamb Add-On Leg 10mm	FRAME HEIGHT - 120	2
	SDH017	Stile Pvc 10mm x 3m	FRAME HEIGHT/3 + 33.5	6
	SDH030	Servery Box Channel 94 x 43mm	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/3 - 2.5	2
	WIDTH		FRAME WIDTH - 181	
STEEL PLATE	SDHA019	Steel Plate 65 x 20 x 1.5m	GLASS WEIGHT/3	2
	SDHA020	Steel Plate 75 x 25 x 1.5m		

* Refer To Glass Label For Glass Weight Or Use The Below Formula:
Glass Height x Glass Width x Glass Thickness x 2.5

9. Cutting Formulas

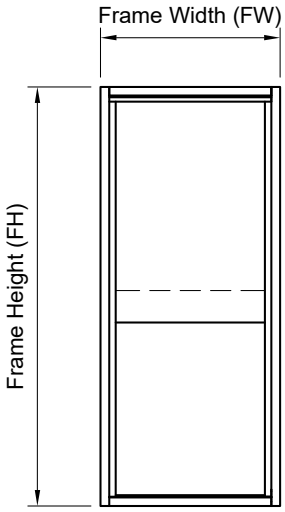
Servery 2 Pane - 18mm

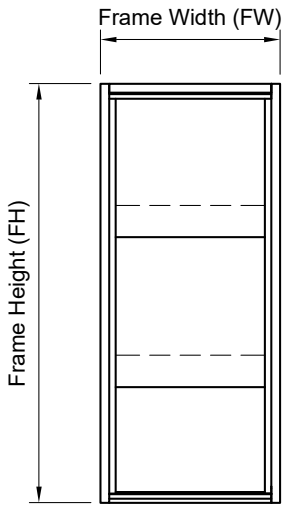


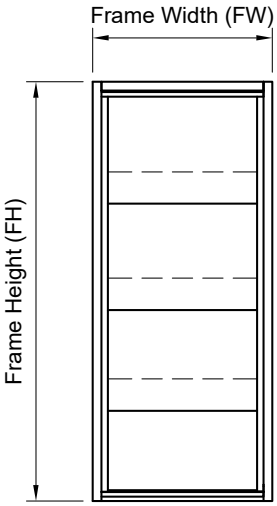
PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	AS5	Flush Adaptor	FRAME HEIGHT - 89	2
	AS23	25mm Plain Frame	FRAME HEIGHT	2
	AS24	Plain Frame	FRAME WIDTH - 50.8	2
	SDH002	Jamb Inner Leg	FRAME HEIGHT - 156	2
	SDH003	Jamb Runner	FRAME HEIGHT - 120	2
	SDH009	Sill (No Legs)	FRAME WIDTH - 136.8	1
	SDH018	Head 18mm	FRAME WIDTH - 136.8	1
	SDH021	Rail 18mm	FRAME WIDTH - 178.5	3
	SDH019	Jamb Outer Leg 18mm	FRAME HEIGHT - 118	2
	SDH020	Add-On Leg 18mm	FRAME HEIGHT - 118	2
	SDH024	Stile Pvc 18mm x 3m	FRAME HEIGHT/2 - 45	4
	SDH022	Interlock 18mm	FRAME WIDTH - 178.5	1
	SDH030	Servery Box Channel 94 x 43mm	FRAME HEIGHT - 89	2
GLASS	HEIGHT		FRAME HEIGHT/2 - 47	2
	WIDTH		FRAME WIDTH - 181	
STEEL PLATE	SDHA019	Steel Plate 65 x 20 x 1.5m	GLASS WEIGHT/2	2
	SDHA020	Steel Plate 75 x 25 x 1.5m		

9. Cutting Formulas

Screening



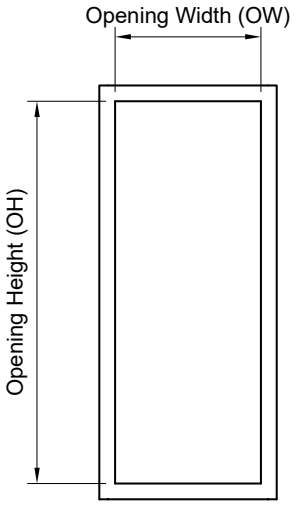


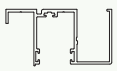


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
INSECT SCREEN w/ PLUNGER PIN	FS2	25 x 11mm Extruded Flyscreen	FRAME HEIGHT - 92	2
	FS2	25 x 11mm Extruded Flyscreen	FRAME WIDTH - 105	2
INSECT SCREEN w/ Jamb Channels	FS2	25 x 11mm Extruded Flyscreen	FRAME HEIGHT - 98	2
	FS2	25 x 11mm Extruded Flyscreen	FRAME WIDTH - 113	2
	L3455	Single Top Track	FRAME HEIGHT - 97	2
INVISI-GARD	IWF1	Invisi Window Frame 11mm	FRAME HEIGHT - 98	2
	IWF1	Invisi Window Frame 11mm	FRAME WIDTH - 105	2
	L3455	Single Top Track	FRAME HEIGHT - 97	2
ALU-GARD	SW3	Security Window Frame	FRAME HEIGHT - 98	2
	SW3	Security Window Frame	FRAME WIDTH - 105	2
	L3455	Single Top Track	FRAME HEIGHT - 97	2
VISION-GARD	SW3	Security Window Frame	FRAME HEIGHT - 98	2
	SW3	Security Window Frame	FRAME WIDTH - 105	2
	L3455	Single Top Track	FRAME HEIGHT - 97	2

9. Cutting Formulas

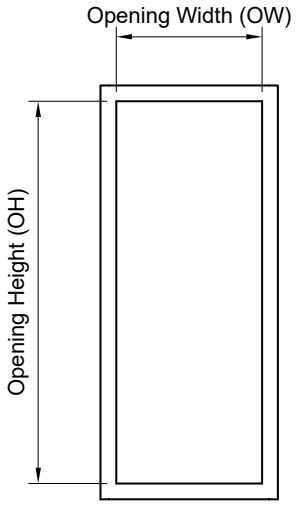
Insert into Frame Opening - 6mm



PROFILE	SECTION NO.	DESCRIPTION	2 PANEL		3 PANEL		4 PANEL	
			CUTTING FORMULA	QTY	CUTTING FORMULA	QTY	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	OH - 67	2	OH - 38	2	OH - 38	2
	SDH003	Jamb Runner	OH - 31	2	OH - 31	2	OH - 31	2
	SDH005	Jamb Outer Leg 6mm	OH - 31	2	OH - 29	2	OH - 29	2
	SDH006	Jamb Add-On Leg 6mm	-	-	OH - 31	2	OH - 31	4
	SDH007	Stile Pvc 6mm x 3m	OH/2 + 43	4	OH/3 + 63	6	OH/4 +73	8
	SDH009	Sill (No Legs)	OW	1	OW	1	OW	1
	SDH010	Head 6mm No Legs	OW	1	OW	1	OW	1
	SDHA013	Lap Seal 6mm x 3m	OW - 65	1	OW - 65	2	OW - 65	3
GLASS	HEIGHT WIDTH		OH/2 + 41 OW - 44	2	OH/3 + 61 OW - 44	3	OH/4 + 71 OW - 44	4

9. Cutting Formulas

Insert into Frame Opening - 10mm

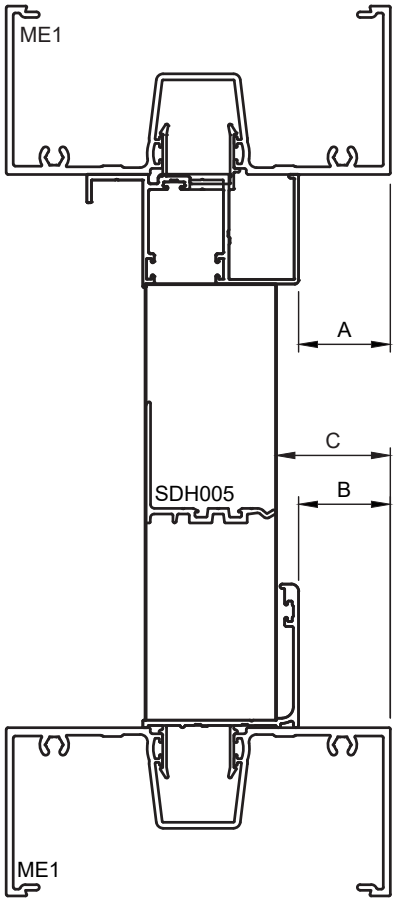


PROFILE	SECTION NO.	DESCRIPTION	2 PANEL		3 PANEL		4 PANEL	
			CUTTING FORMULA	QTY	CUTTING FORMULA	QTY	CUTTING FORMULA	QTY
	SDH002	Jamb Inner Leg	OH - 38	2	OH - 38	2	OH - 38	2
	SDH003	Jamb Runner	OH - 31	2	OH - 31	2	OH - 31	2
	SDH009	Sill (No Legs)	OW	1	OW	1	OW	1
	SDH014	Head 10mm	OW	1	OW	1	OW	1
	SDH015	Jamb Outer Leg 10mm	OH - 31	2	OH - 29	2	OH - 29	2
	SDH016	Jamb Add-On Leg 10mm	-	-	OH - 2	2	OH - 2	4
	SDH017	Stile Pvc 10mm x 3m	OH/2 + 43	4	OH/3 + 63	6	OH/4 +73	8
	SDHA014	Lap Seal 10mm x 3m	OW - 65	1	OW - 65	2	OW - 65	3
GLASS	HEIGHT WIDTH		OH/2 + 41 OW - 44	2	OH/3 + 61 OW - 44	3	OH/4 + 71 OW - 44	4

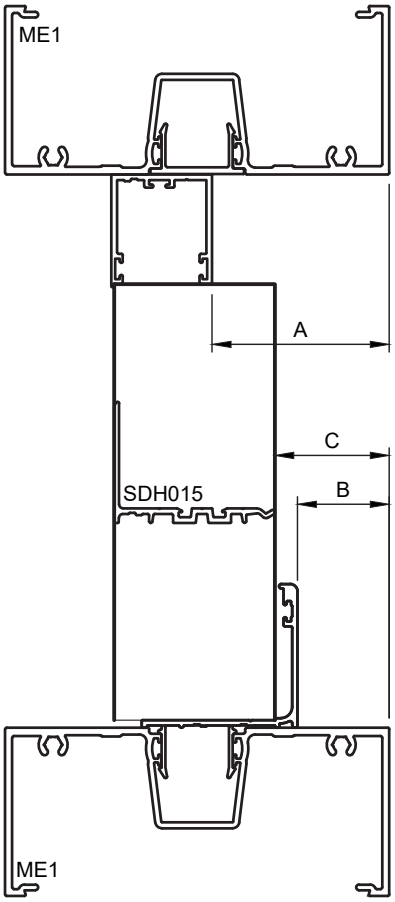
10. Manufacturing Details

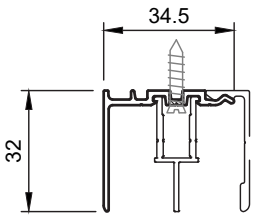
Head, Sill & Jamb Location - ME1

6mm GLAZE OPTION

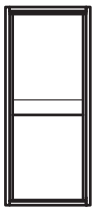


10mm GLAZE OPTION

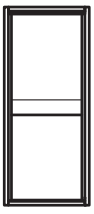




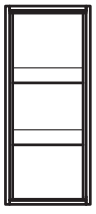
SDH005
SDH015



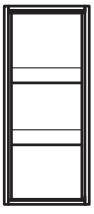
A	24.26mm
B	24.26mm
C	30.25mm



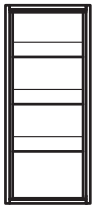
A	48.86mm
B	24.26mm
C	30.25mm



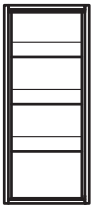
A	24.26mm
B	6.66mm
C	30.25mm



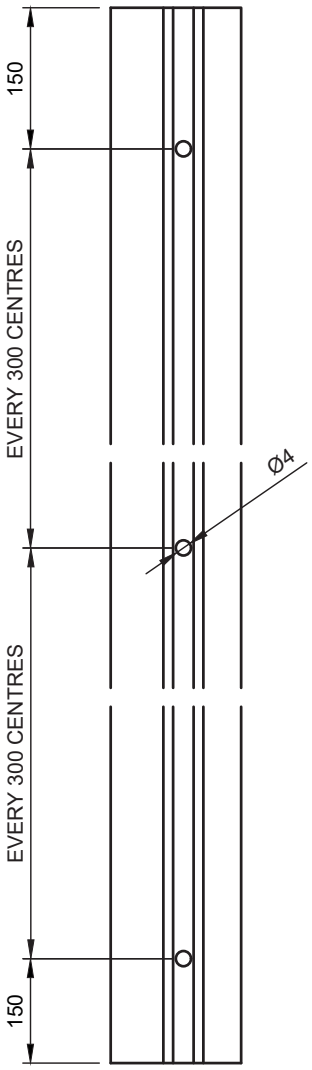
A	44.2mm
B	27.6mm
C	0mm



A	45.6mm
B	10.4mm
C	51.59mm



A	66.3mm
B	49.2mm
C	0mm



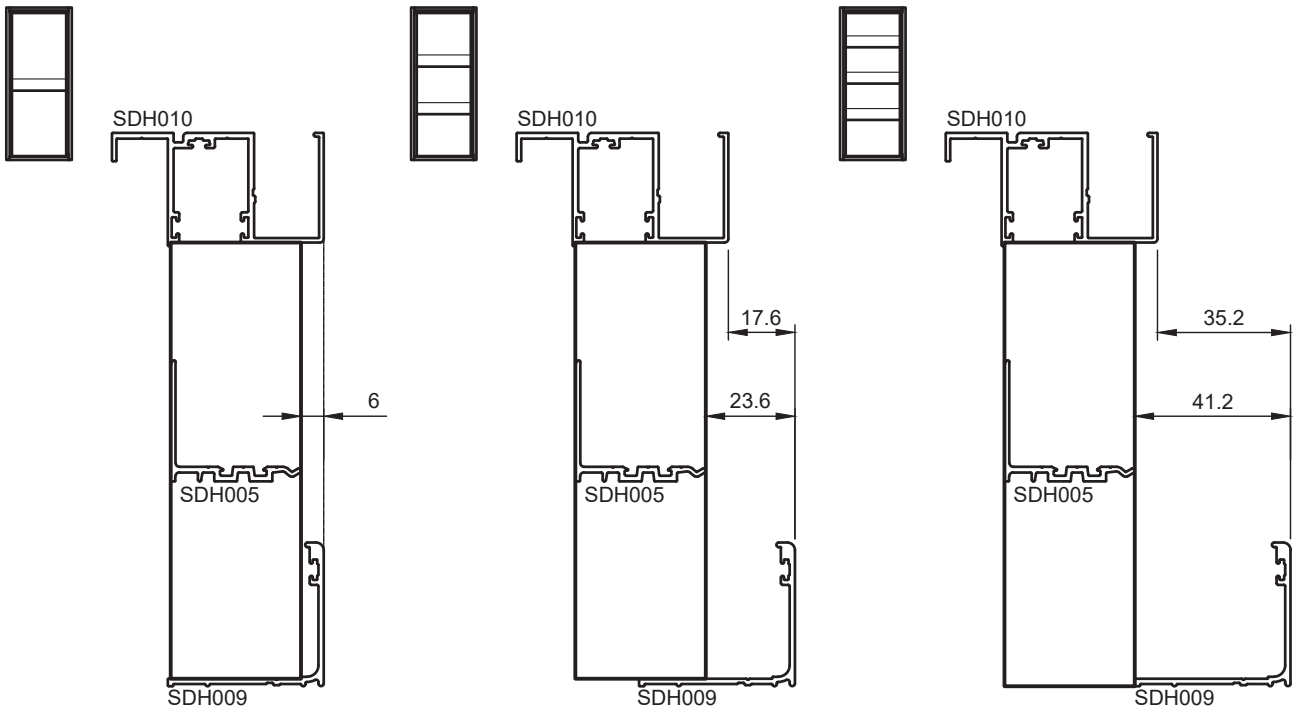
SDH005 MUST HAVE A MINIMUM OF 3 FIXINGS
MAXIMUM DISTANCE BETWEEN FIXINGS IS 300mm

SDH005 SHOWN, ALSO APPLICABLE TO SDHA015

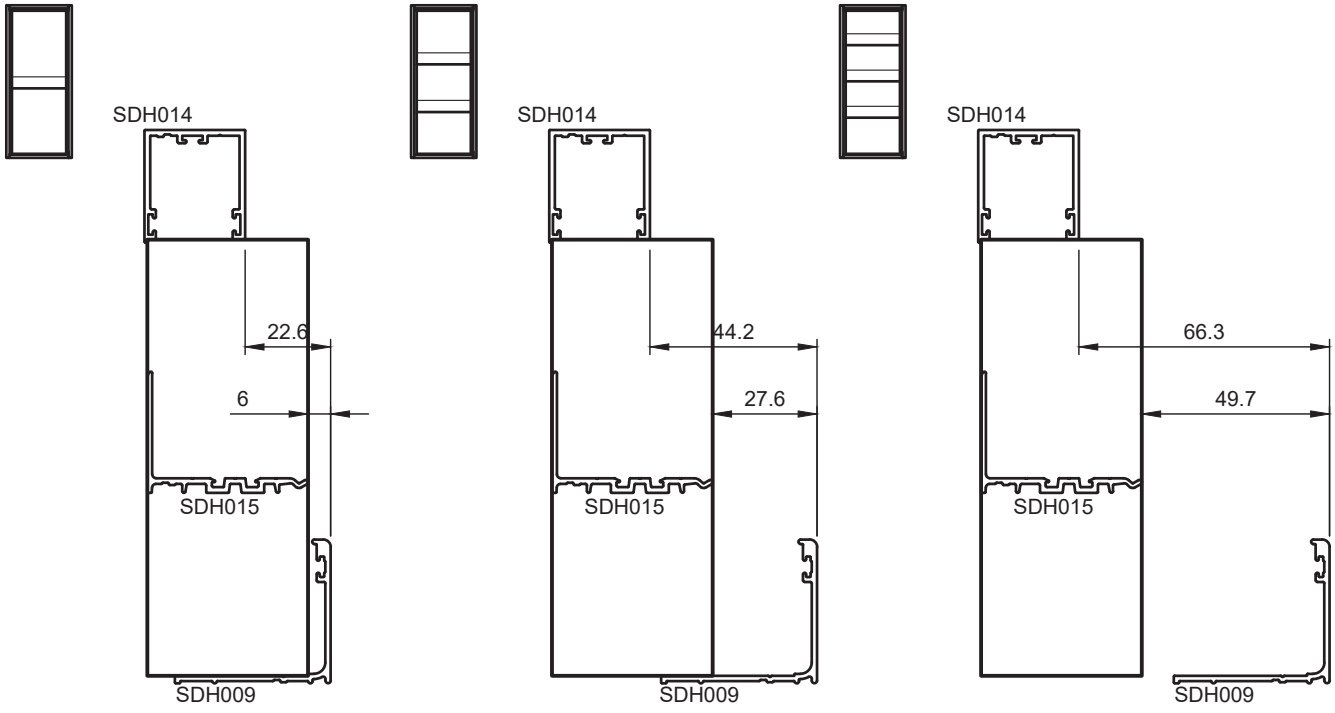
10. Manufacturing Details

Head, Sill & Jamb Location - Prepared Opening

6mm GLAZE OPTION

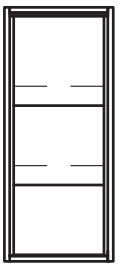


10mm GLAZE OPTION

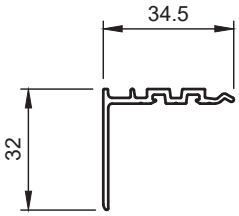


10. Manufacturing Details

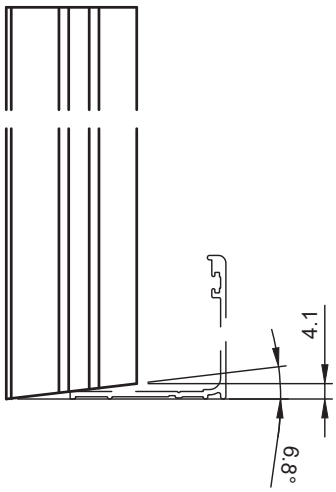
Sill Clearance 3 Panel Configuration



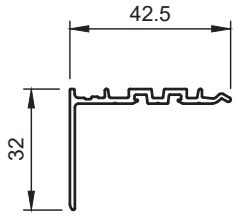
GLAZING: 6mm



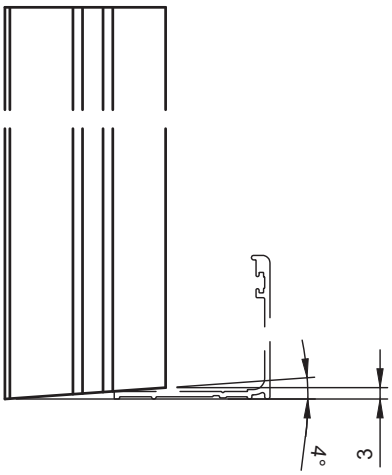
SDH005



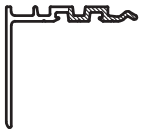
GLAZING: 10mm



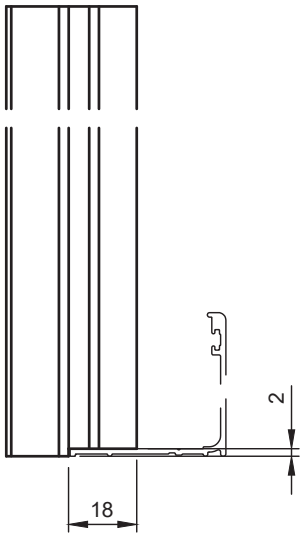
SDH015

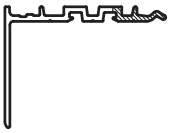


ALTERNATIVE MACHINING FOR SILL CLEARANCE

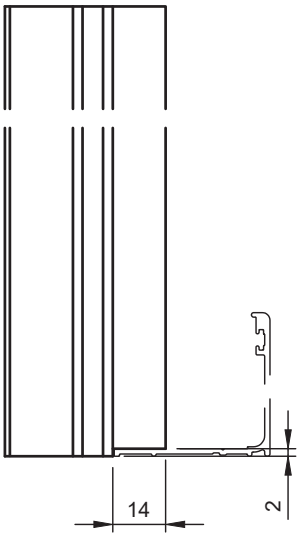


SDH005





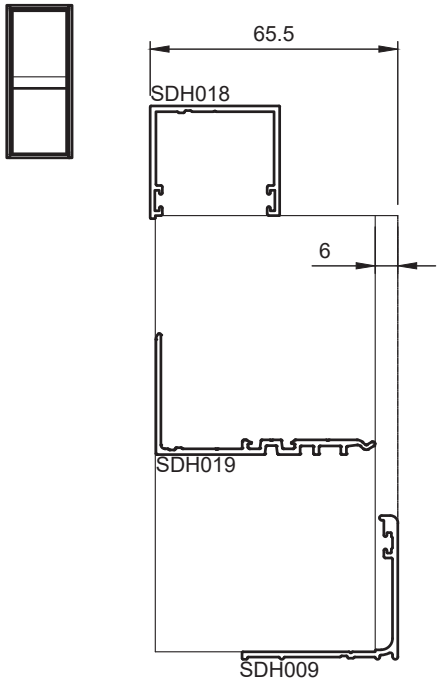
SDH015

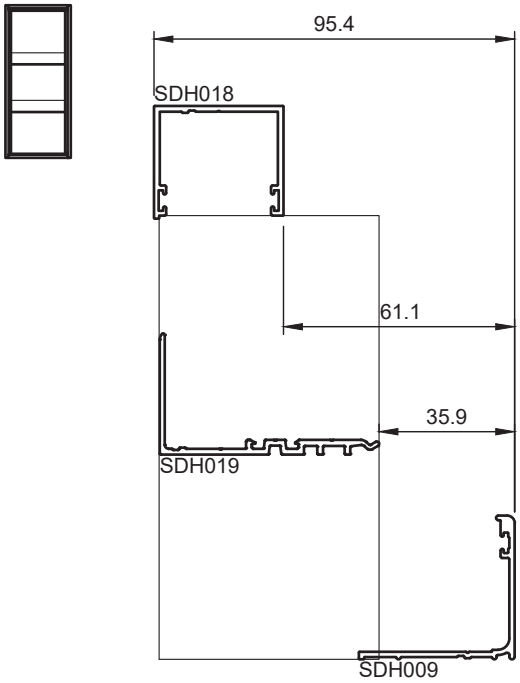


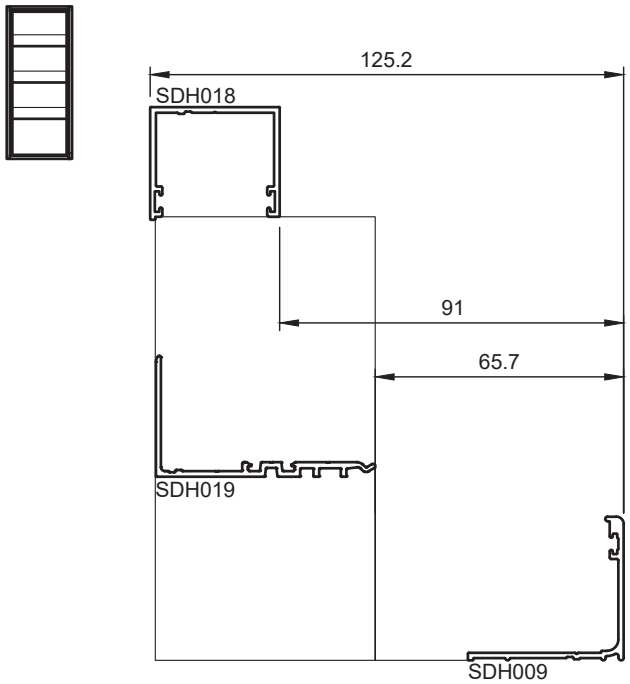
10. Manufacturing Details

Head, Sill & Jamb Location - Prepared Opening (Double Glazed 18mm)

18mm GLAZE OPTION

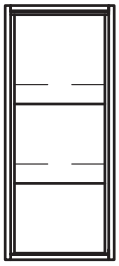


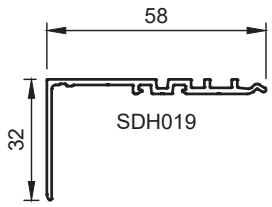


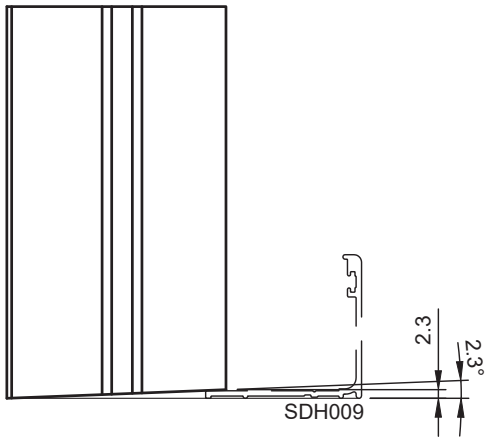


Sill Clearance 3 Panel Configuration (Double Glazed 18mm)

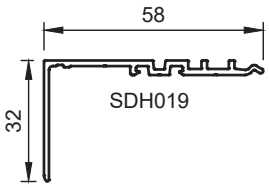
18mm GLAZE OPTION

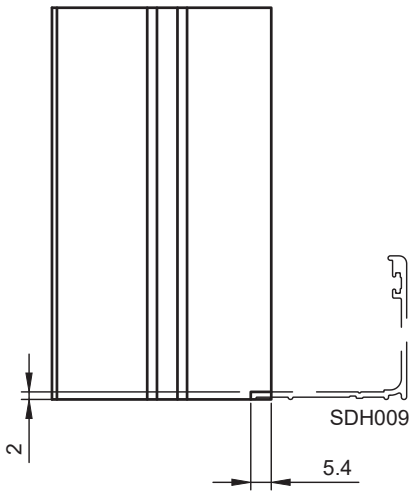






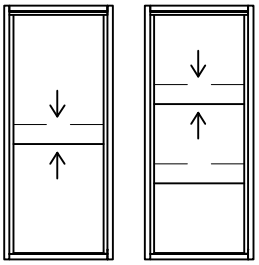
ALTERNATIVE MACHINING FOR SILL CLEARANCE



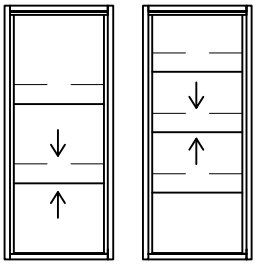


10. Manufacturing Details

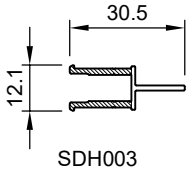
Heavy Duty Pulley SDHA015 - 2, 3 & 4 Lite



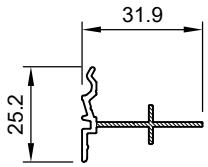
CONFIGURATION: SS & SSF
GLAZING: 6mm 10mm



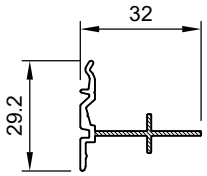
CONFIGURATION: FSS & FSSF
GLAZING: 6mm 10mm



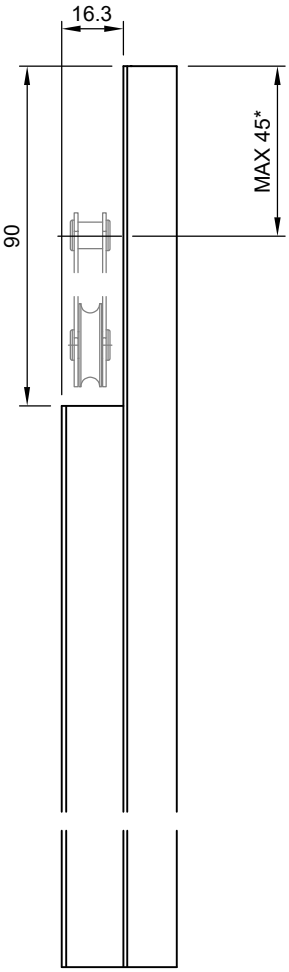
SDH003

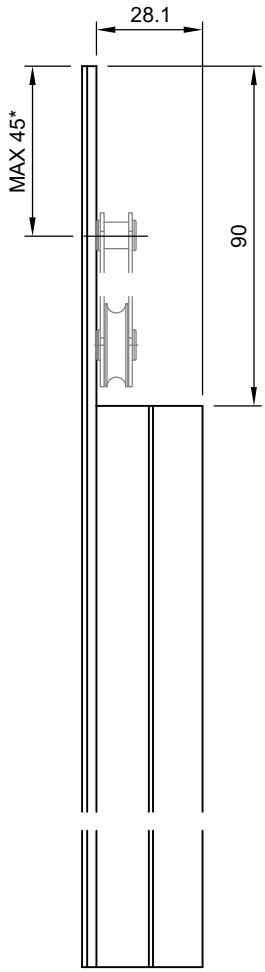


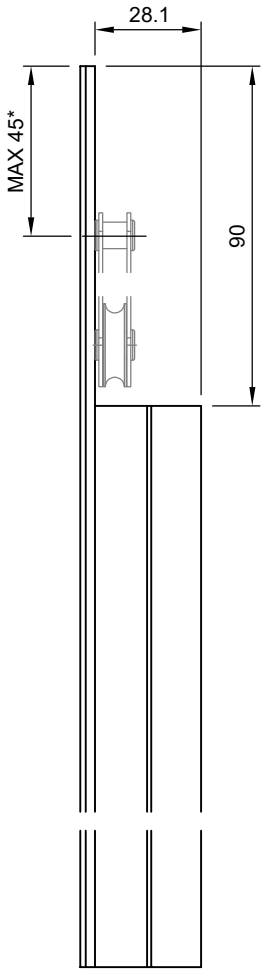
SDH006



SDH016



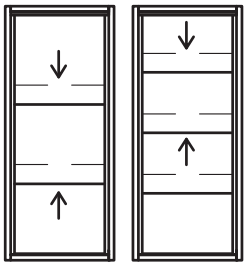




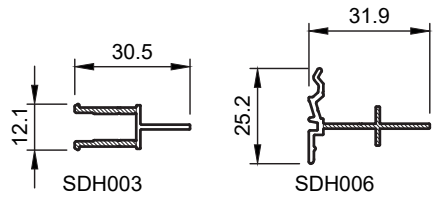
* MAX DISTANCE BETWEEN HEAD AND PULLEY FIXING

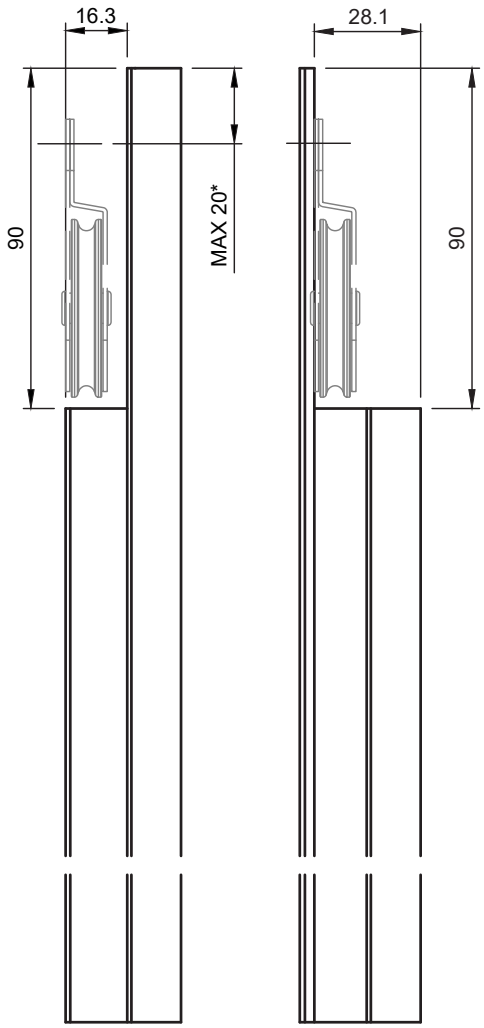
10. Manufacturing Details

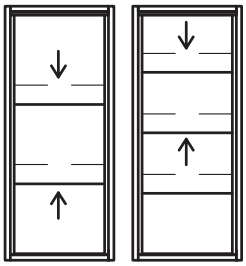
Wide Pulley SDHA002 3 & 4 Lite



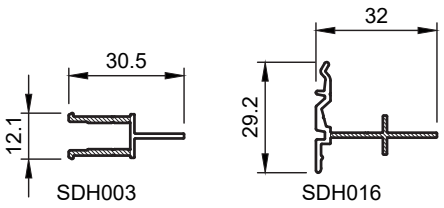
CONFIGURATION: SFS & SFSF
GLAZING: 6mm

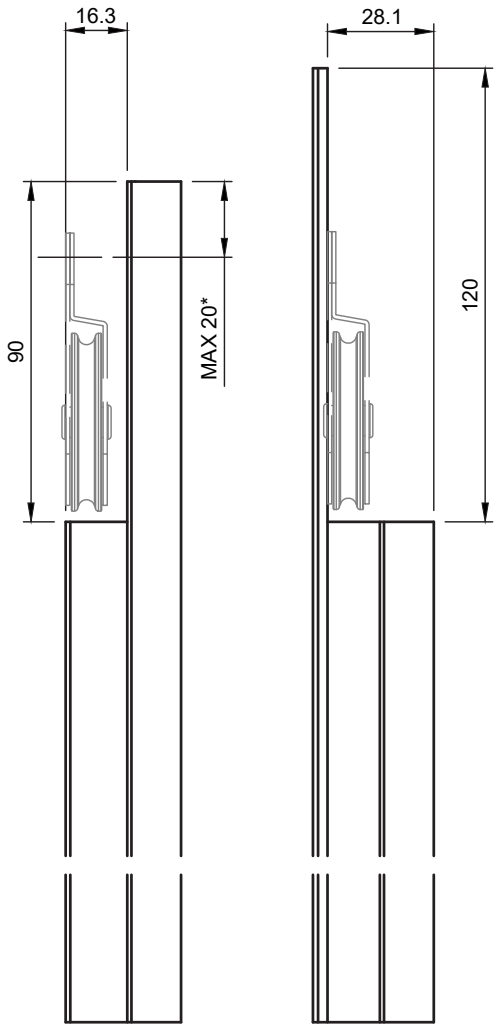






CONFIGURATION: SFS & SFSF
GLAZING: 10mm

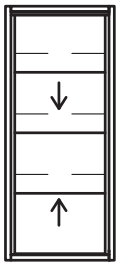




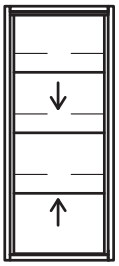
* MAX DISTANCE BETWEEN HEAD AND PULLEY FIXING

10. Manufacturing Details

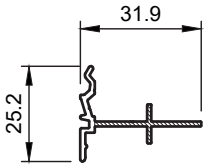
Wide Pulley SDHA002 - 4 Lite



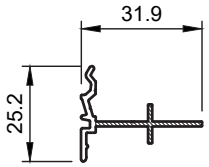
CONFIGURATION: FSFS
GLAZING: 6mm



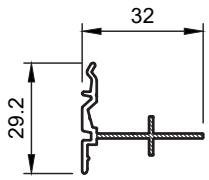
CONFIGURATION: FSFS
GLAZING: 10mm



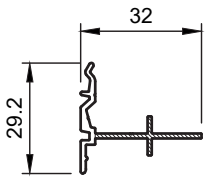
SDH006



SDH006



SDH016



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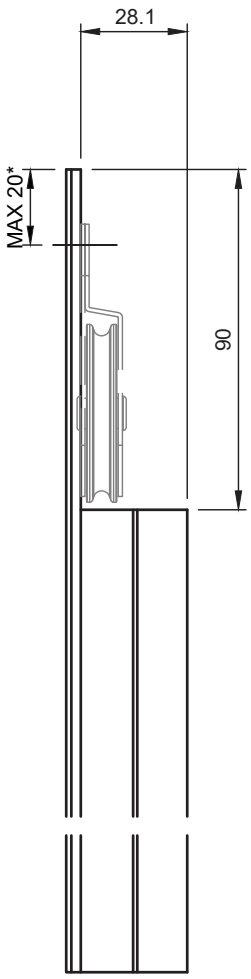
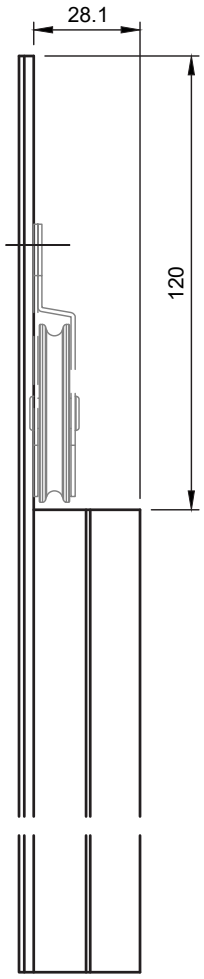
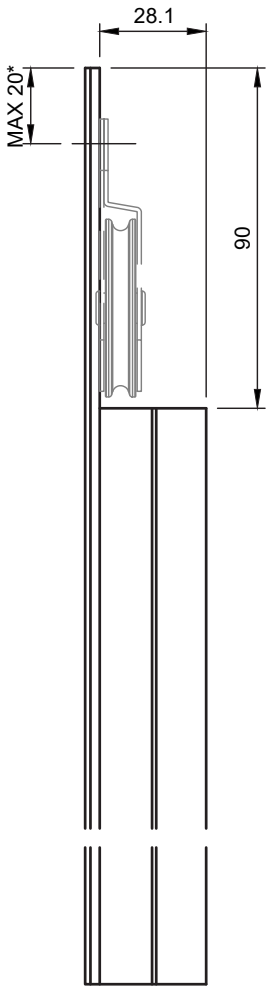
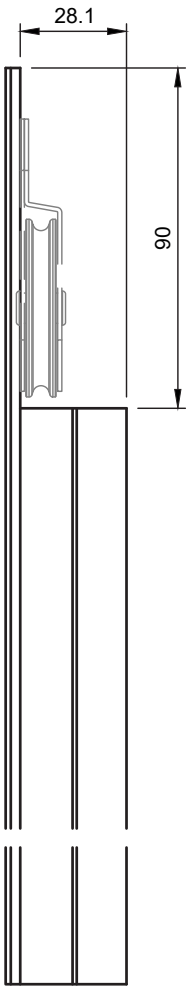




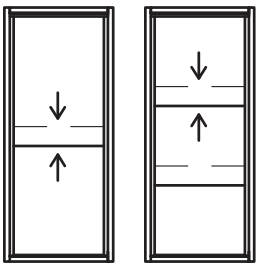




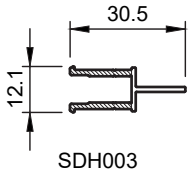
* MAX DISTANCE BETWEEN HEAD AND PULLEY FIXING

10. Manufacturing Details

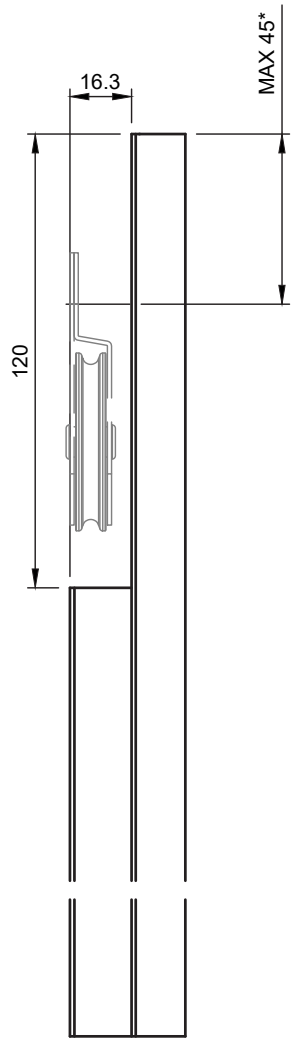
Wide Pulley SDHA002 Clearance (Double Glazed 18mm)

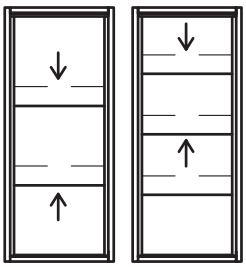


CONFIGURATION: SS & SSF
GLAZING: 18mm

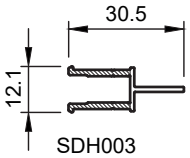


SDH003

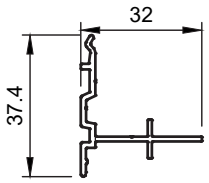




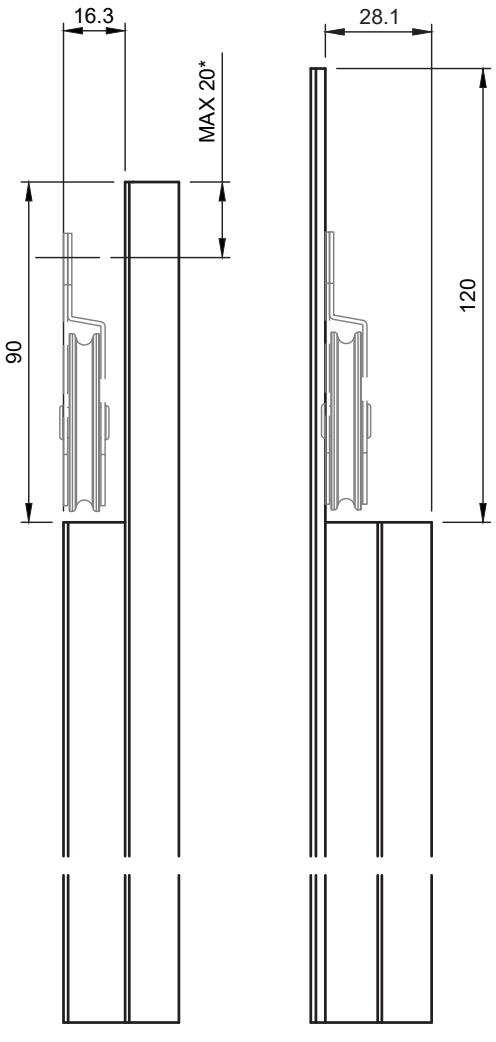
CONFIGURATION: SFS & SFSF
GLAZING: 10mm



SDH003



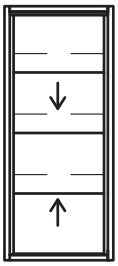
SDH020



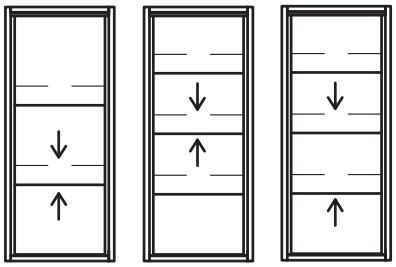
* MAX DISTANCE BETWEEN HEAD AND PULLEY FIXING

10. Manufacturing Details

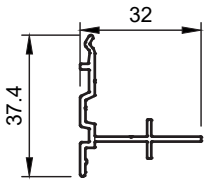
Wide Pulley SDHA002 Clearance (Double Glazed 18mm)



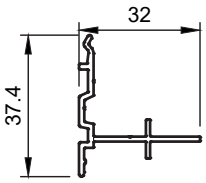
CONFIGURATION: FSFS
GLAZING: 18mm



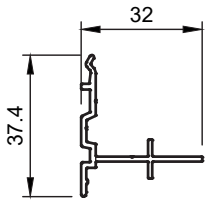
CONFIGURATION: FSS, FSFS & FSSF
GLAZING: 18mm



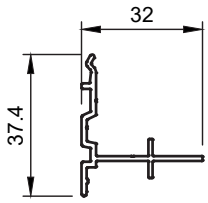
SDH020



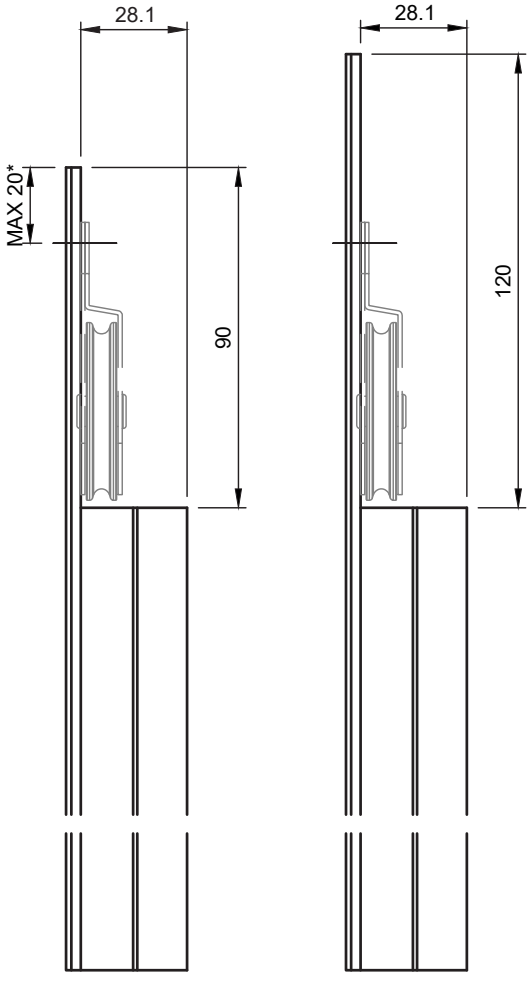
SDH020

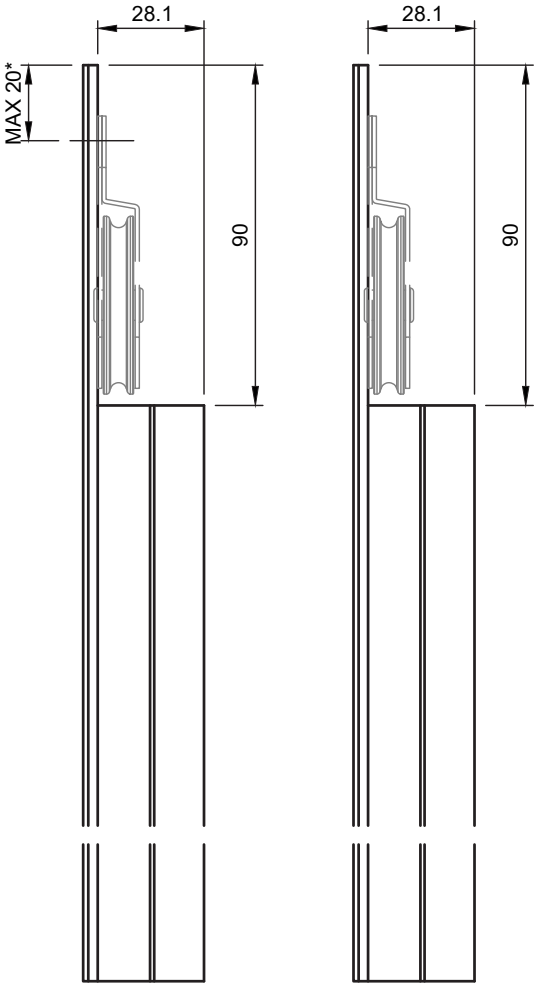


SDH020



SDH020



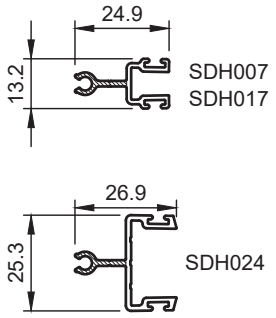


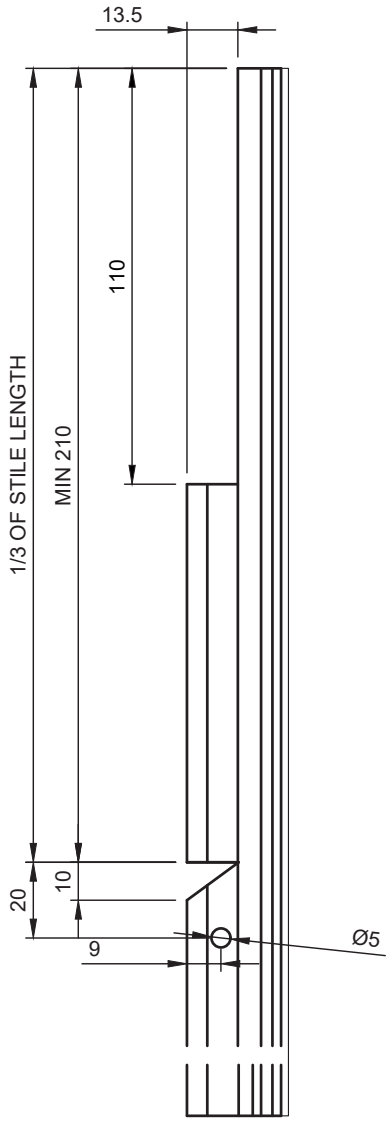
* MAX DISTANCE BETWEEN HEAD AND PULLEY FIXING

10. Manufacturing Details

Stile Machining For Knotting Cord

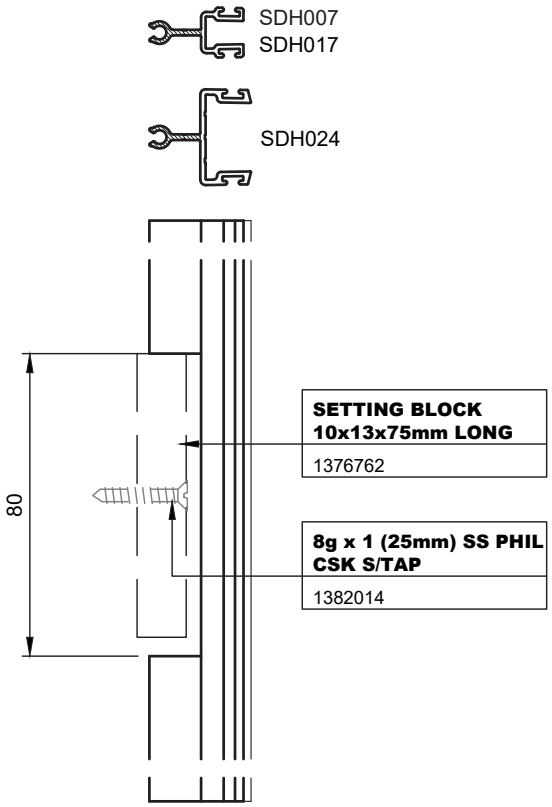
* MACHINED TO ALL OPERATING STILES

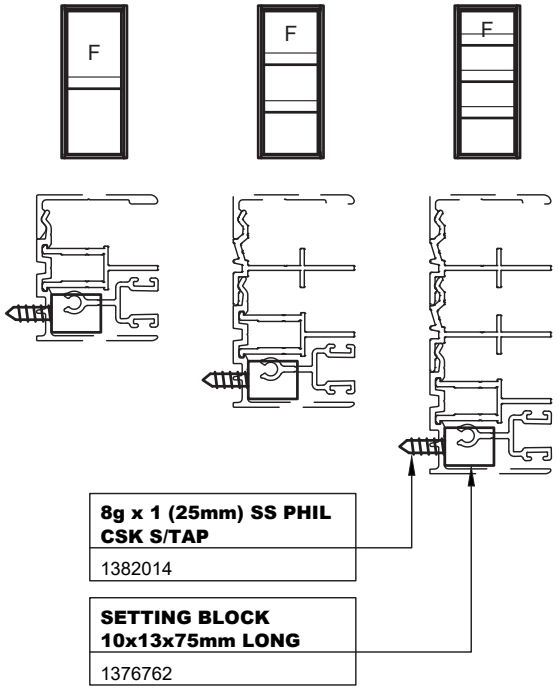


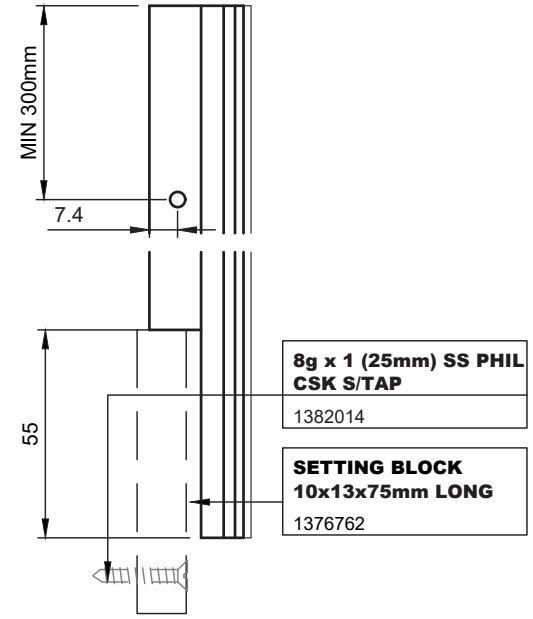


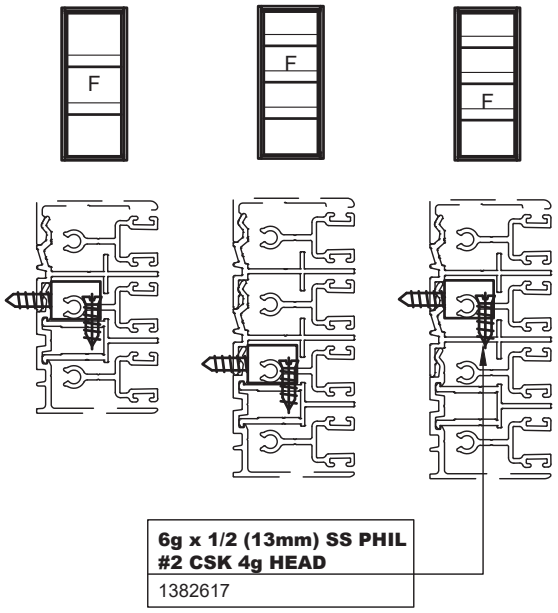
10. Manufacturing Details

Stile Machining For Fixed Sash - Top Panel

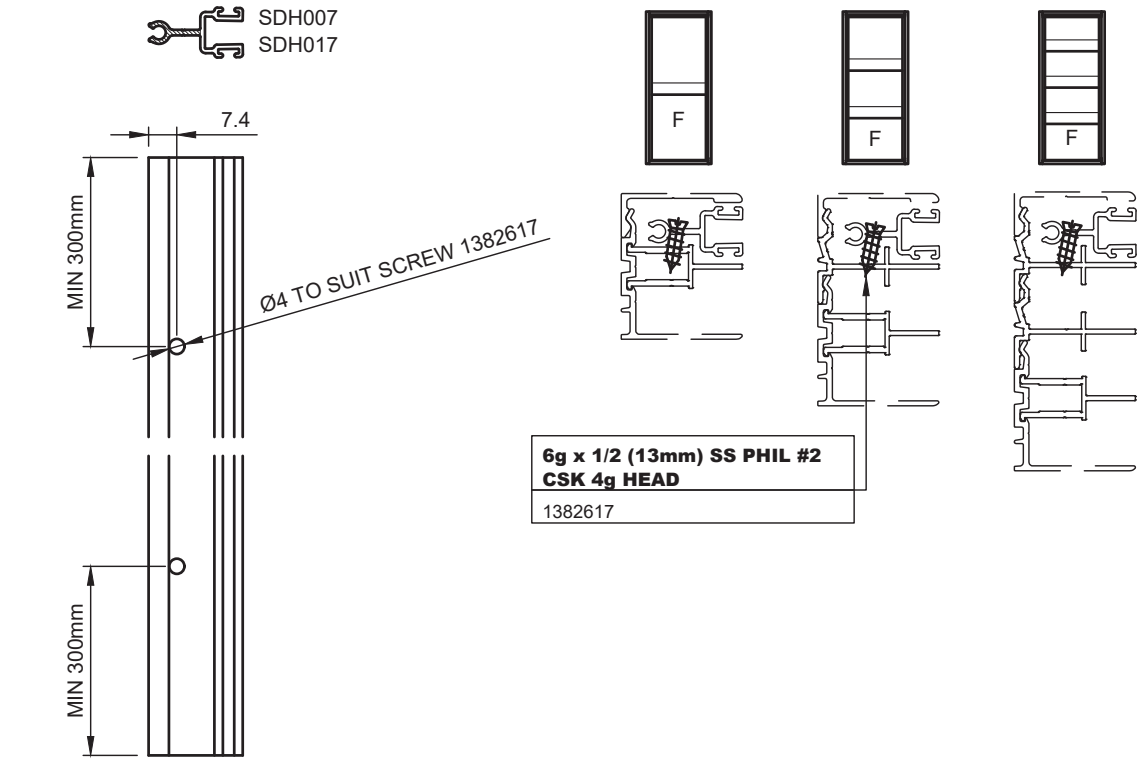


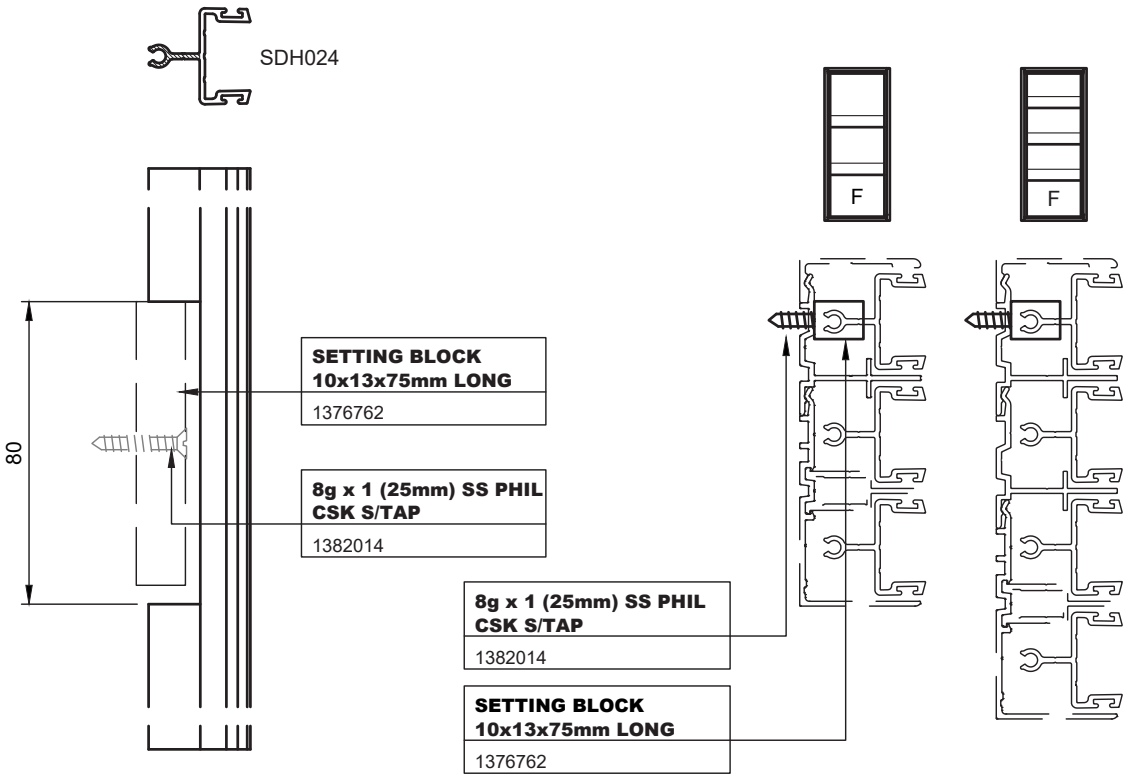






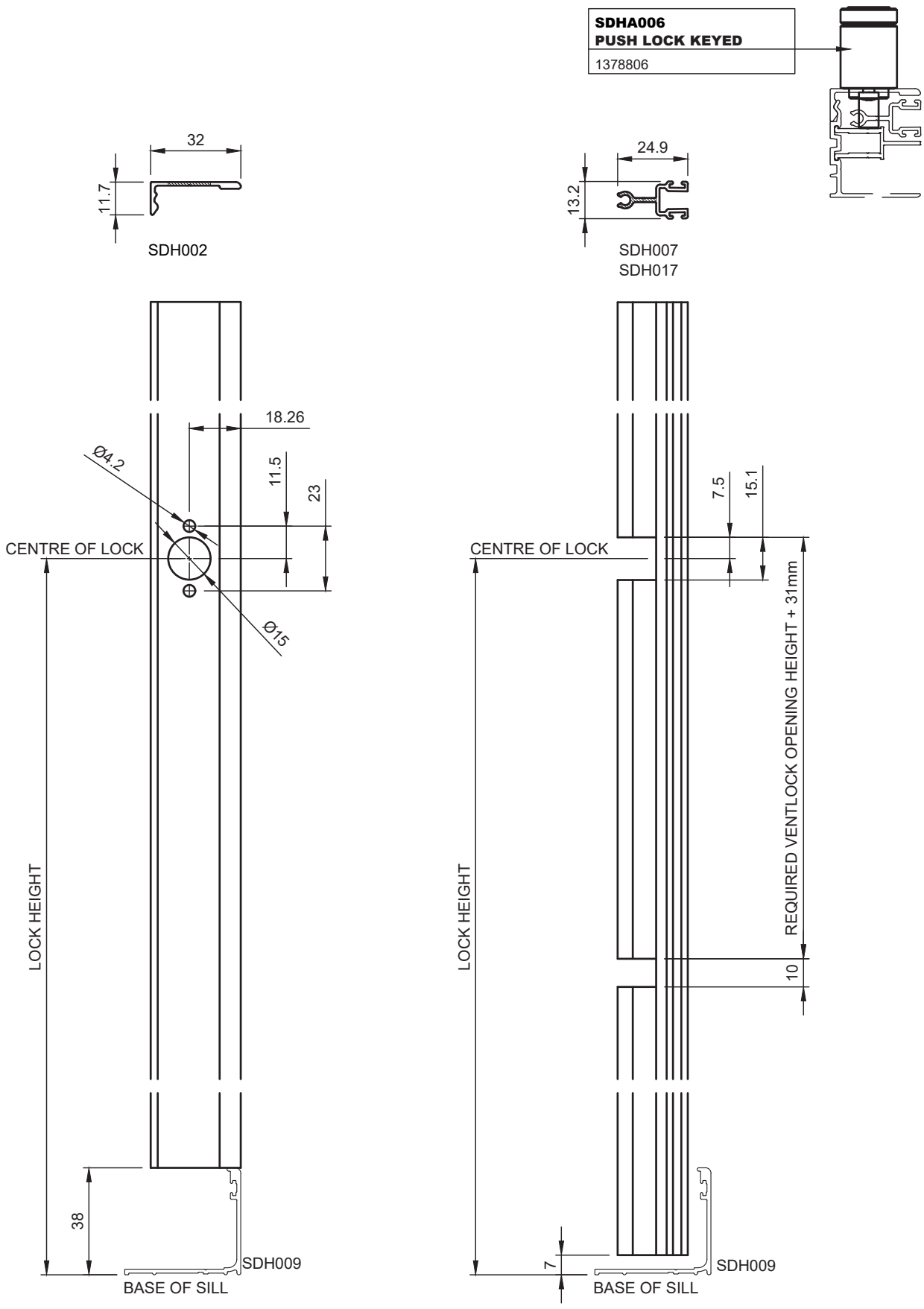
Stile Machining For Fixed Sash - Bottom Panel





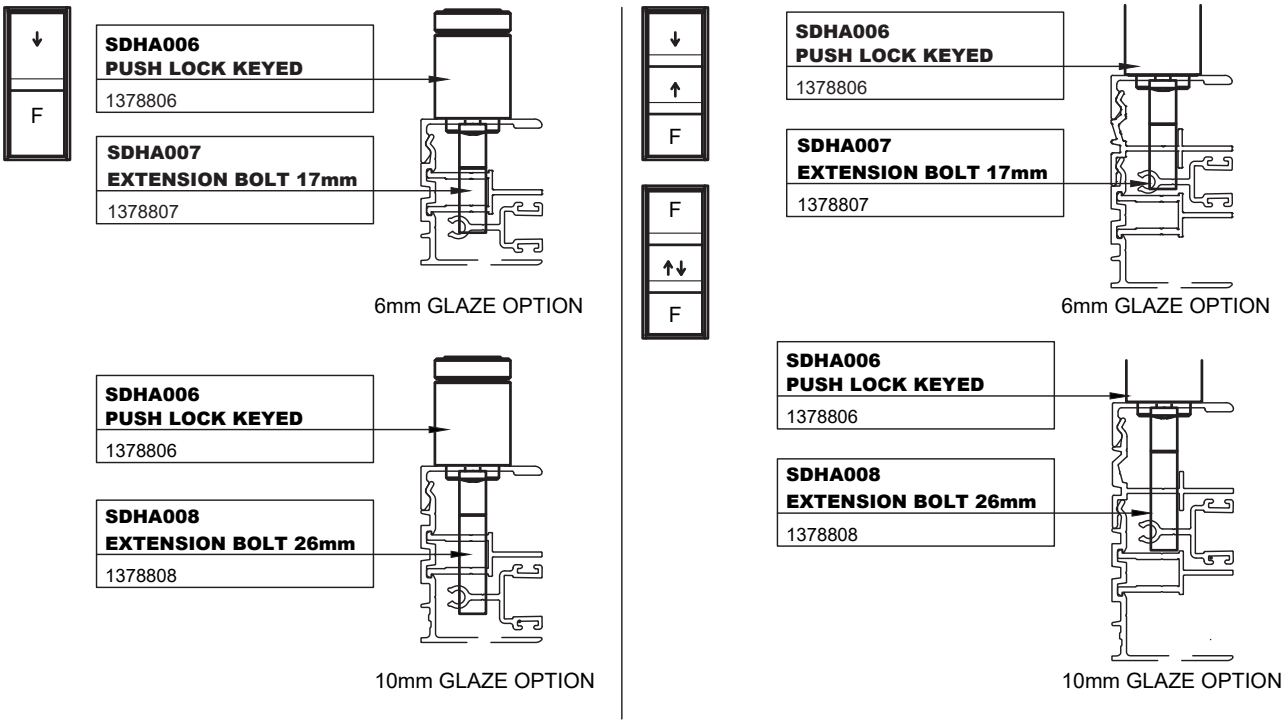
10. Manufacturing Details

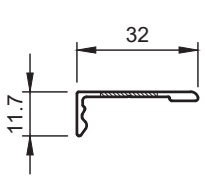
Lock Machining



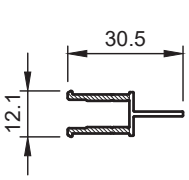
10. Manufacturing Details

Lock Machining With Extension Bolts (Single Glazed 6 & 10mm)

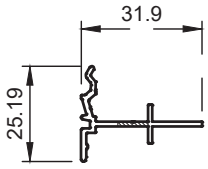




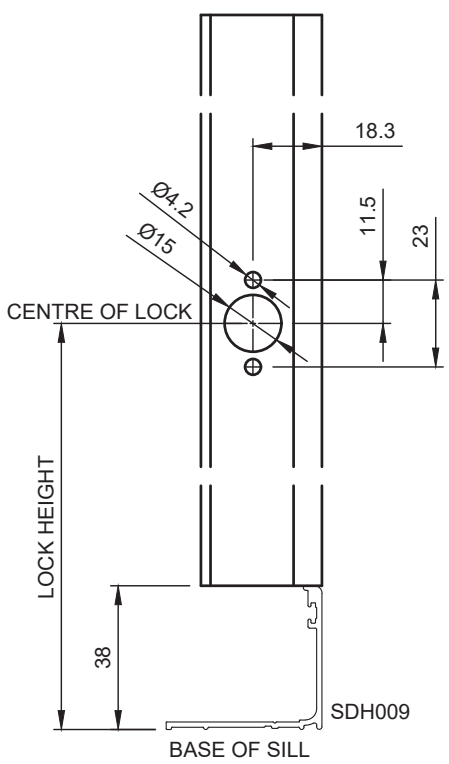
SDH002

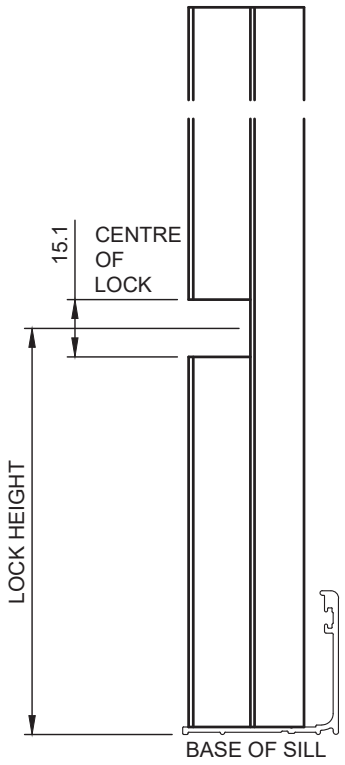


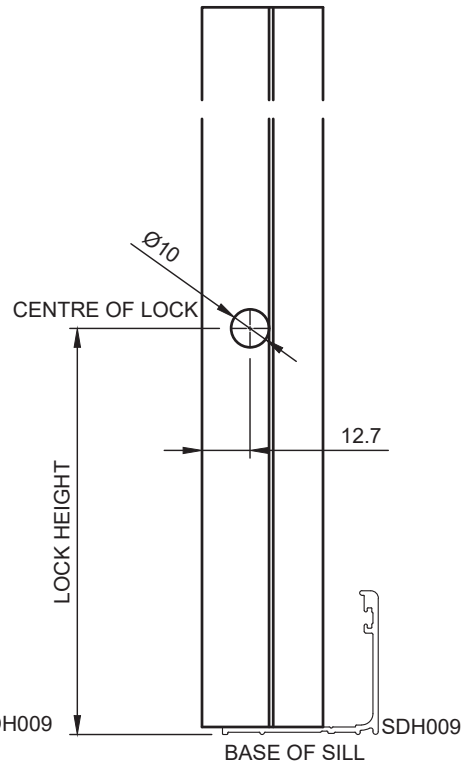
SDH003



SDH006
SDH016

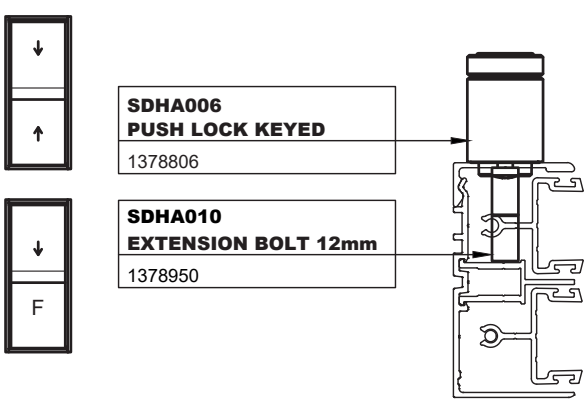


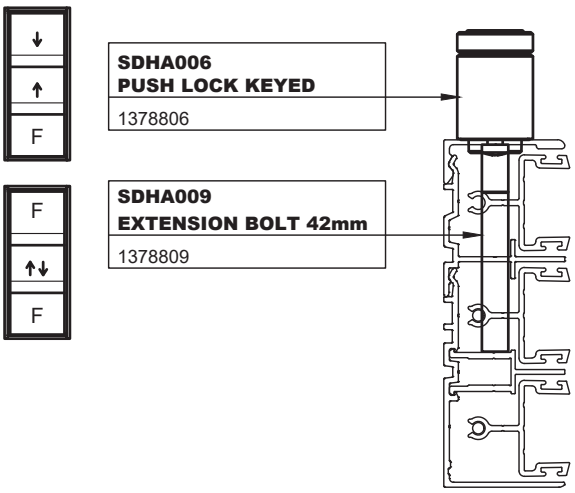


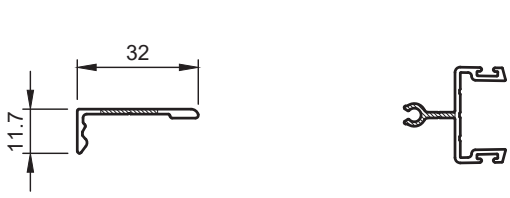


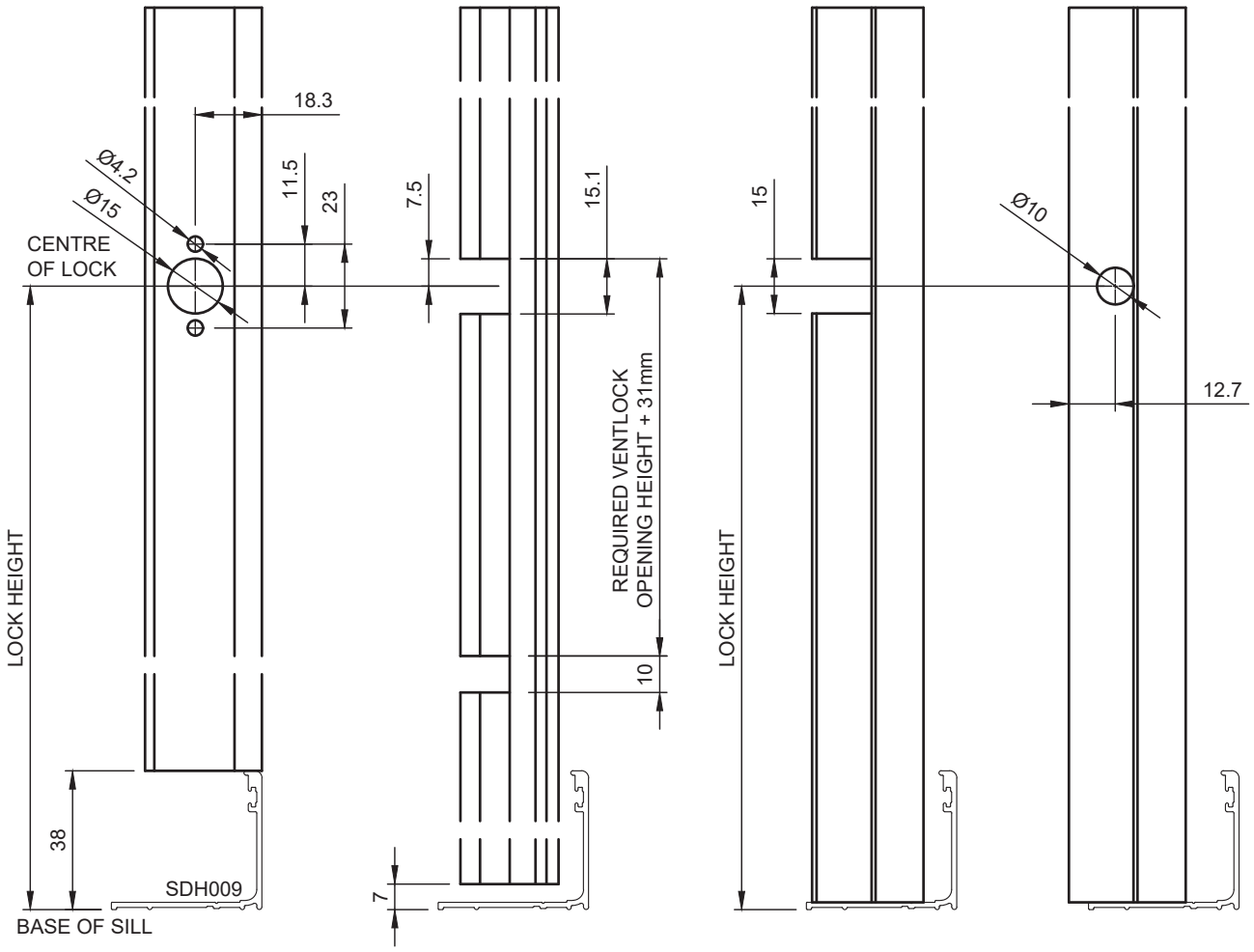
10. Manufacturing Details

Lock Machining With Extension Bolts (Double Glazed 18mm)





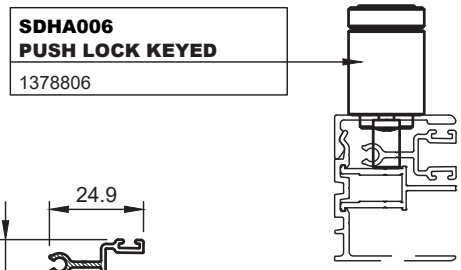


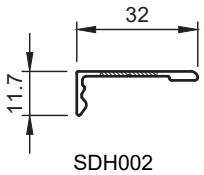


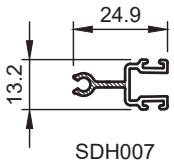
10. Manufacturing Details

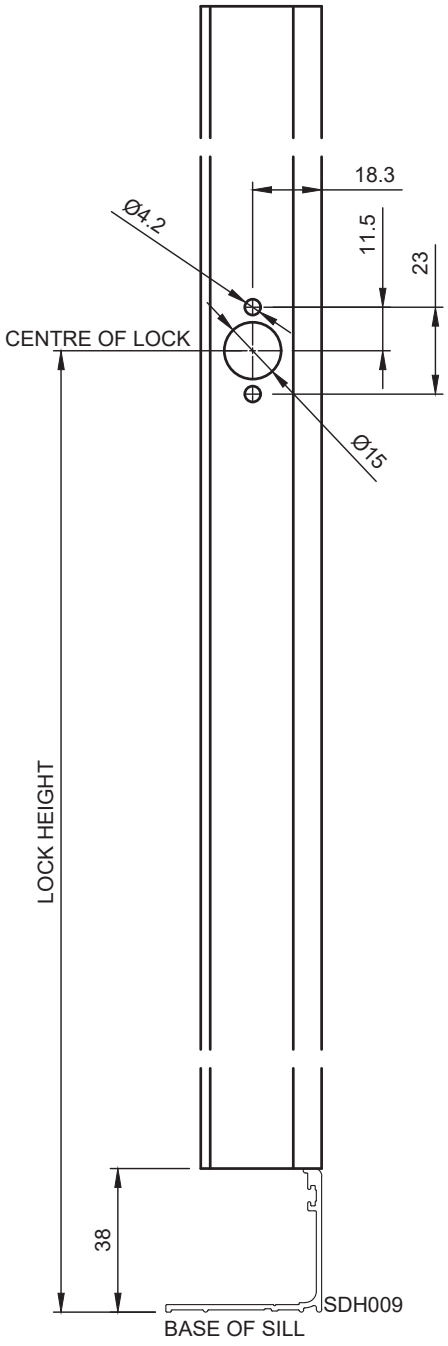
Restricted Opening - Child Resistant Restriction

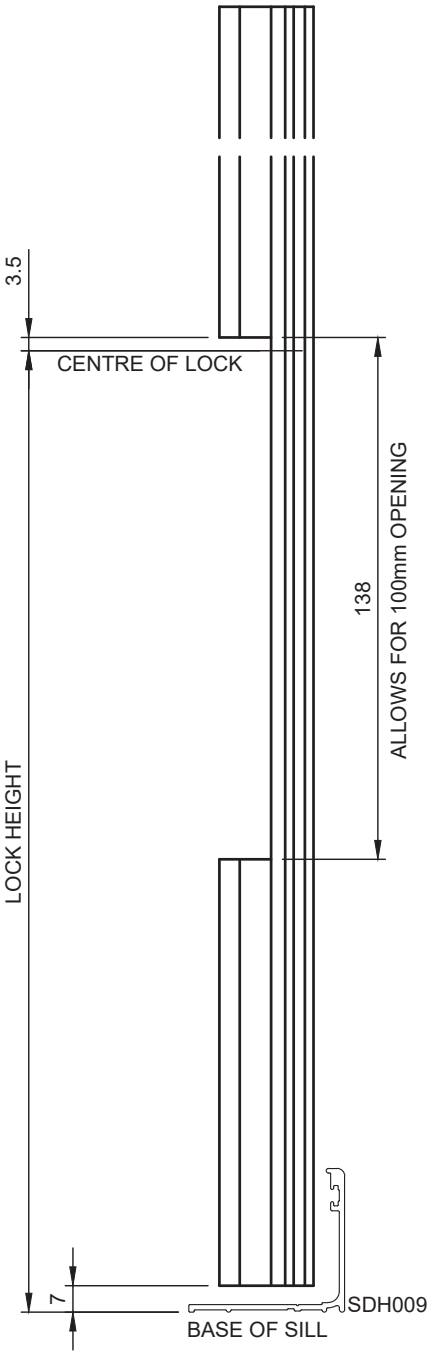
CHILD RESISTANT RESTRICTION METHOD WITH SDHA006 PUSH LOCK
AS PER NATIONAL CONSTRUCTION CODE (VOL 1: D.2.24 & VOL 2: 3.9.2.6)







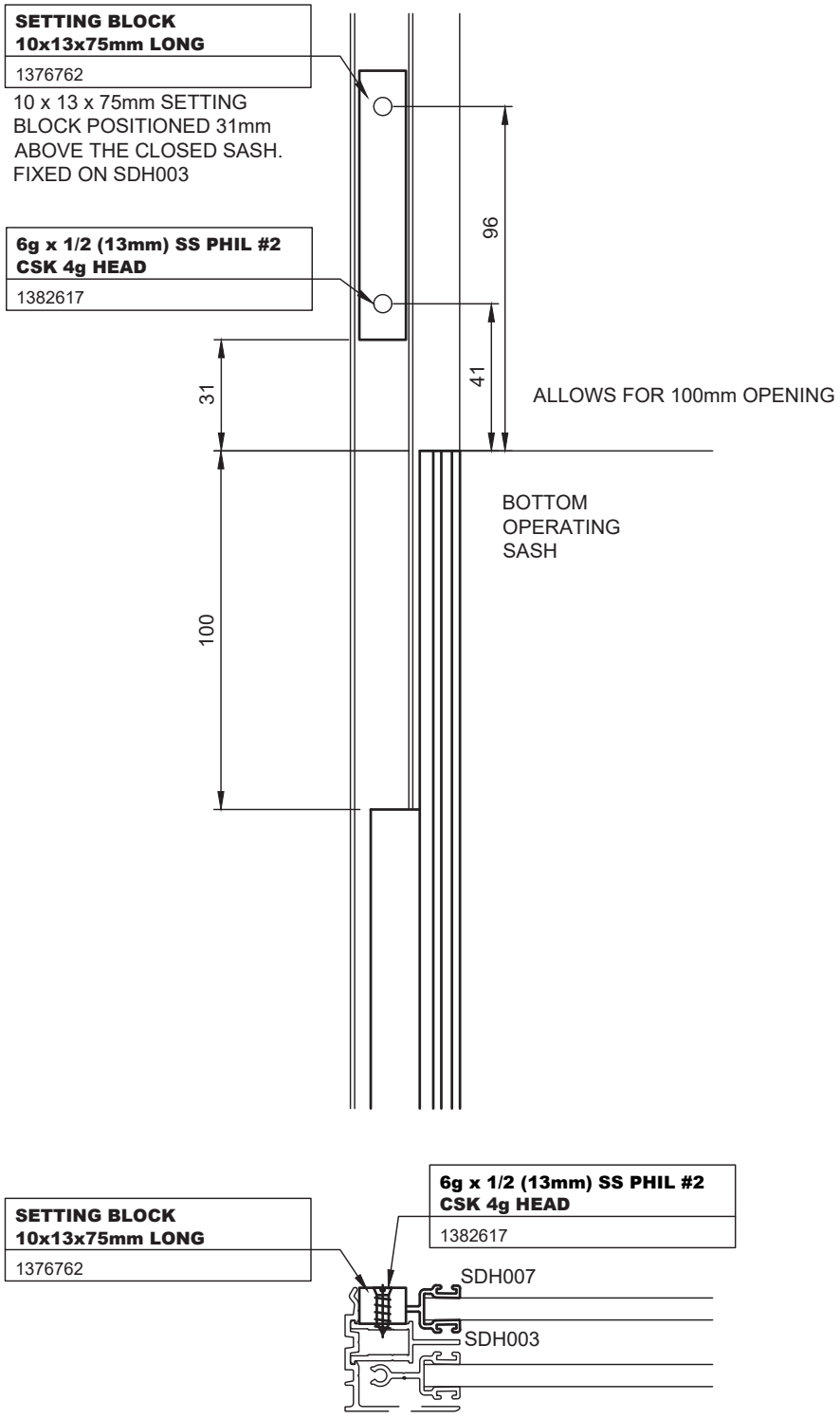




10. Manufacturing Details

Restricted Opening - Permanent Restriction

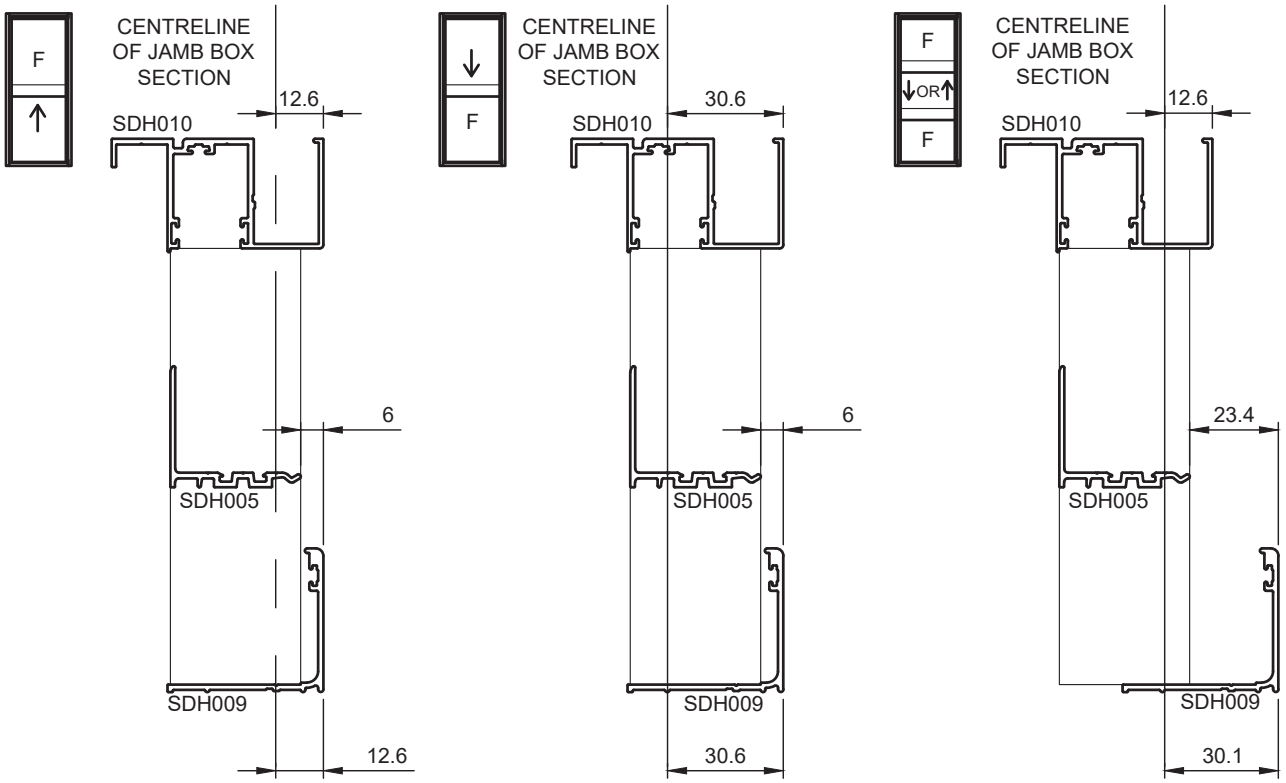
PERMANENT RESTRICTION METHOD WITH 10 x 13 x 75mm SETTING BLOCK
AS PER NATIONAL CONSTRUCTION CODE (VOL 1: D.2.24 & VOL 2: 3.9.2.6)



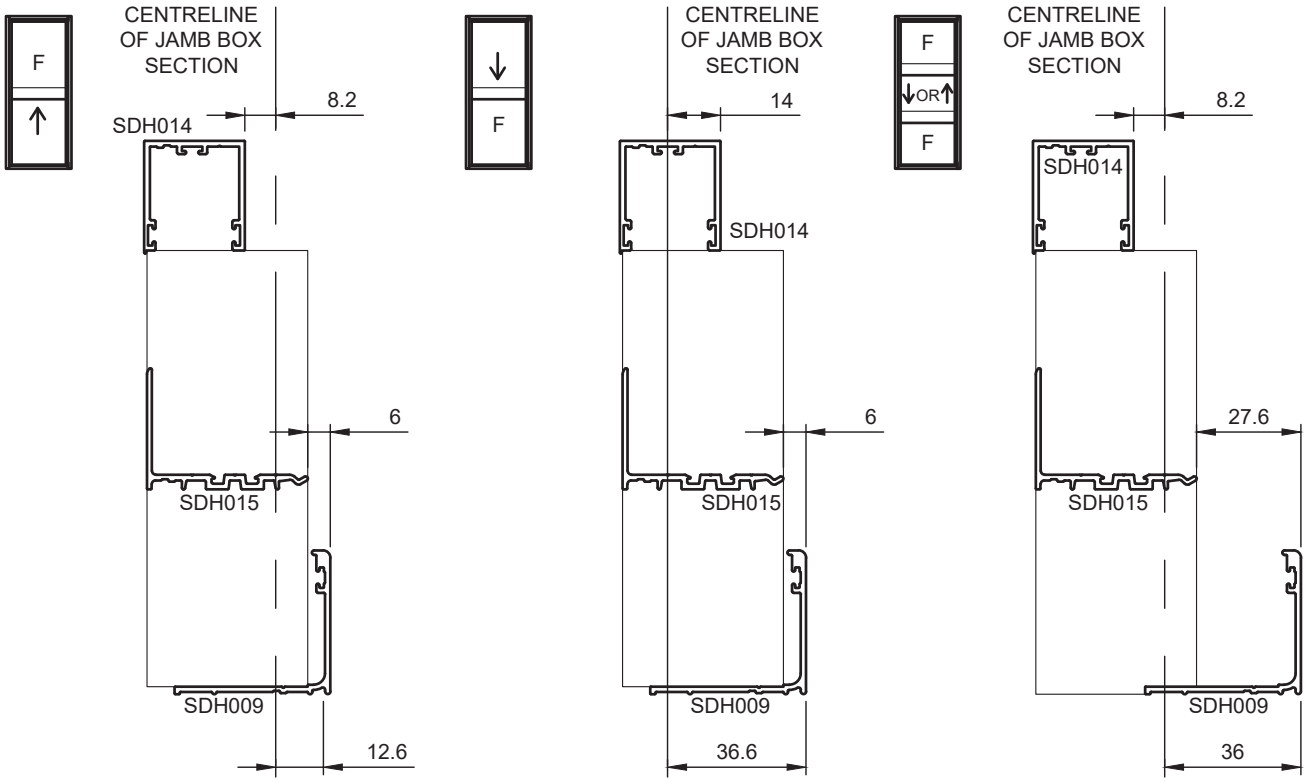
10. Manufacturing Details

Servery Head, Sill & Jamb Location

6mm GLAZE OPTION

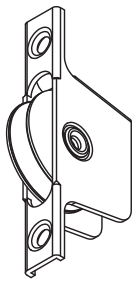


10mm GLAZE OPTION

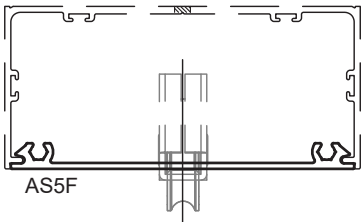


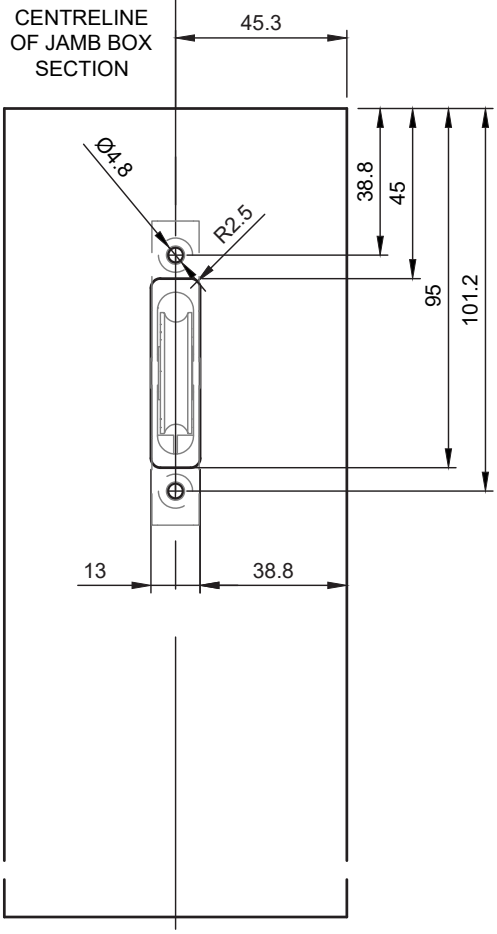
10. Manufacturing Details

Servery Box Pulley Clearance

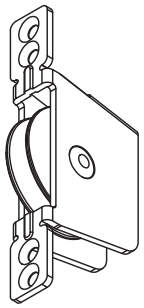


PULLEY SERVERY STD 50kg SDHA003
1378803

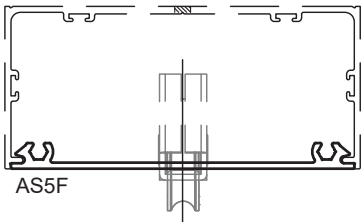


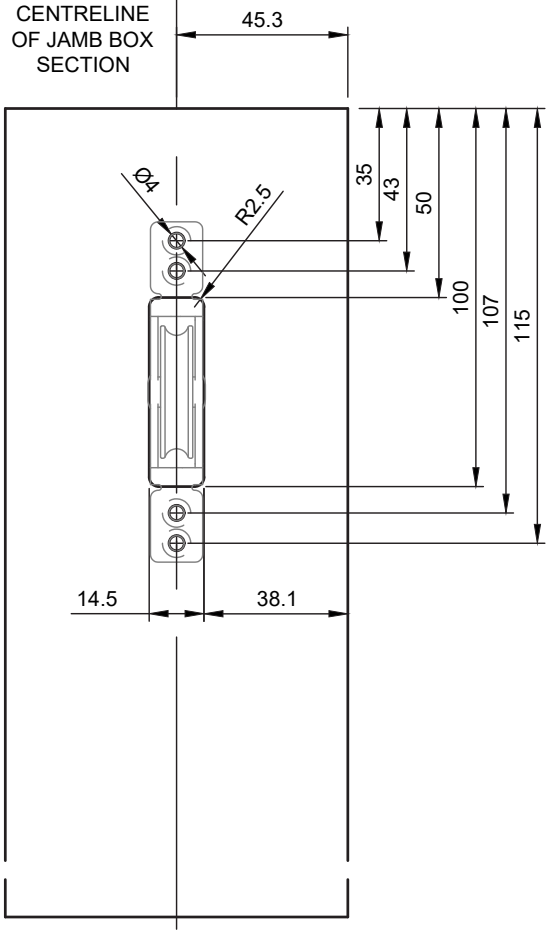


PULLEY MUST ALWAYS
POSITIONED IN THE CENTRE
OF THE BOX SECTION



SERVERY HD 100KG SDHA004
1378804

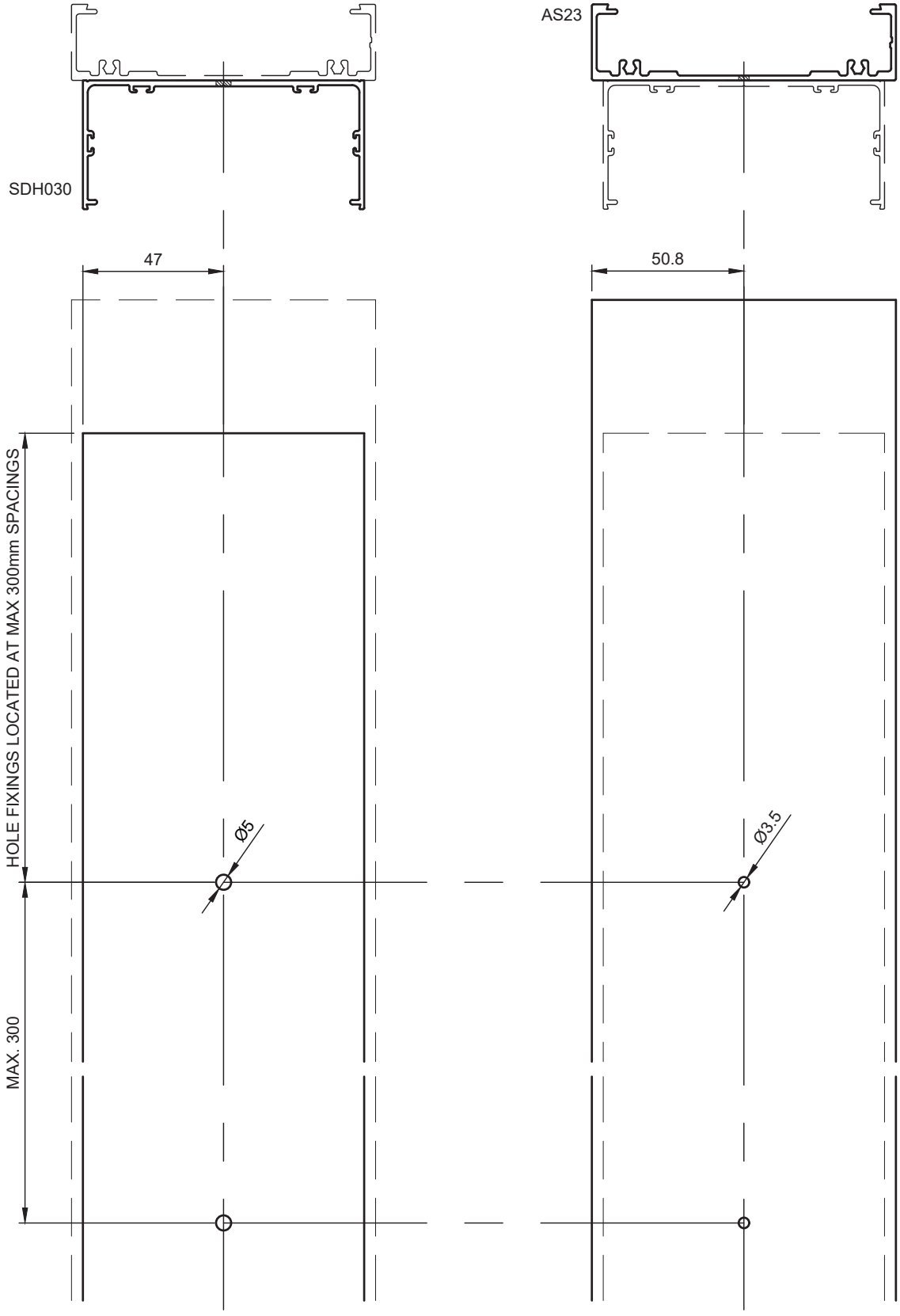




PULLEY MUST ALWAYS
POSITIONED IN THE CENTRE
OF THE BOX SECTION

10. Manufacturing Details

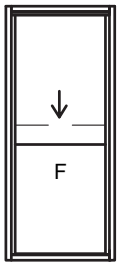
Servery Box Fixing



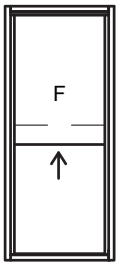
SDH030 MUST HAVE A MINIMUM OF 3 FIXINGS
MAXIMUM DISTANCE BETWEEN FIXINGS IS 300mm

10. Manufacturing Details

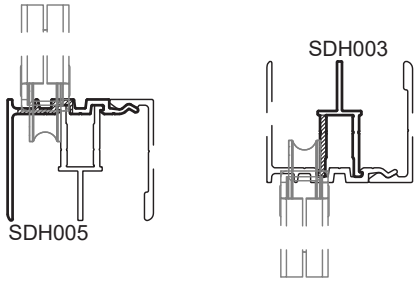
Servery Frame Pulley Clearance - 2 Panel 6mm

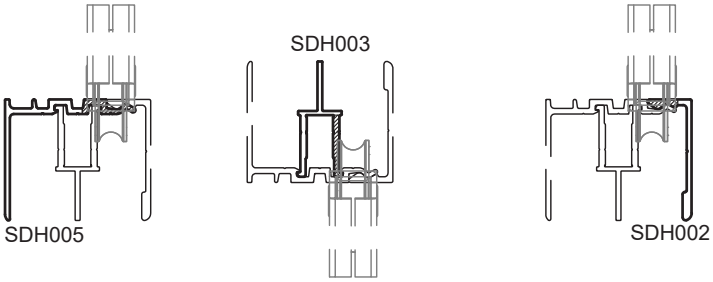


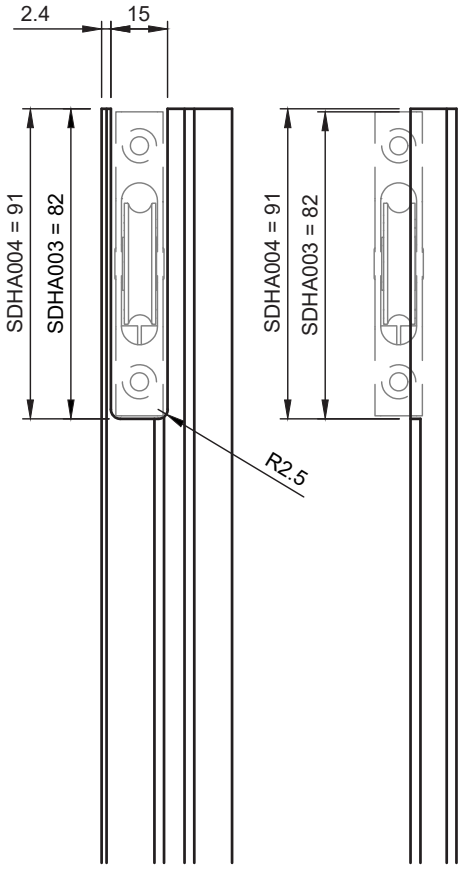
CONFIGURATION: SF
GLAZING: 6mm

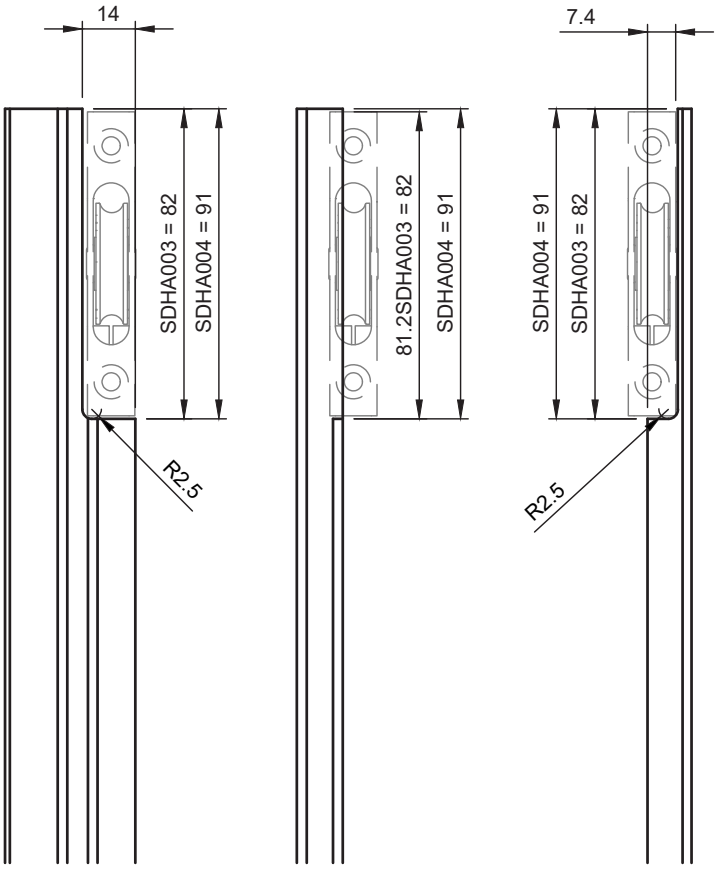


CONFIGURATION: FS
GLAZING: 6mm



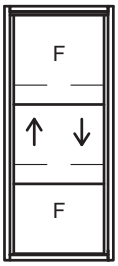




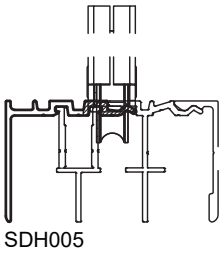


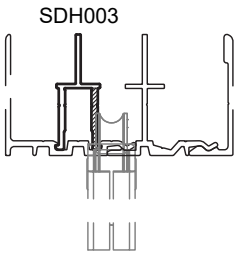
10. Manufacturing Details

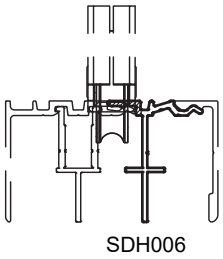
Servery Frame Pulley Clearance - 3 Panel 6mm

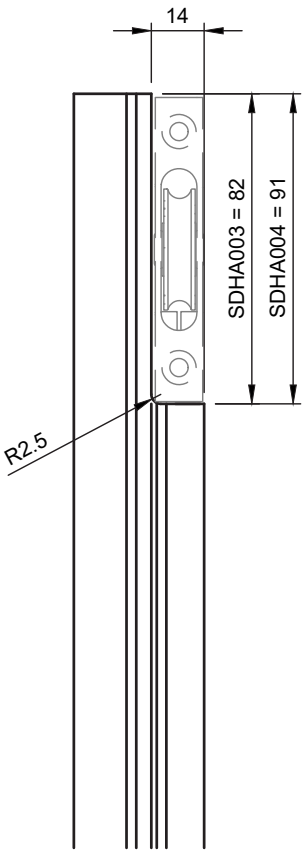


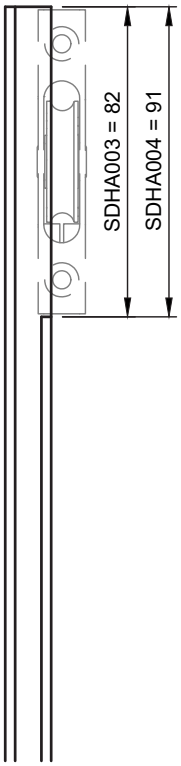
CONFIGURATION: FSF
GLAZING: 6mm

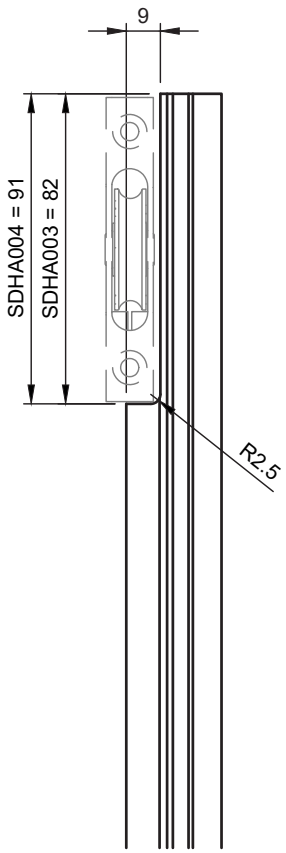






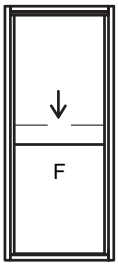




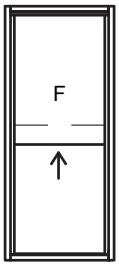


10. Manufacturing Details

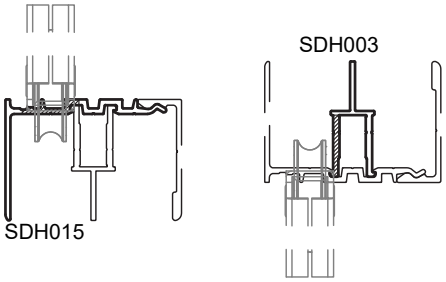
Servery Frame Pulley Clearance - 2 Panel 10mm

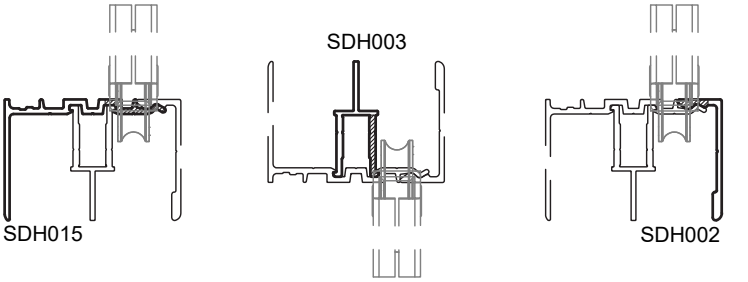


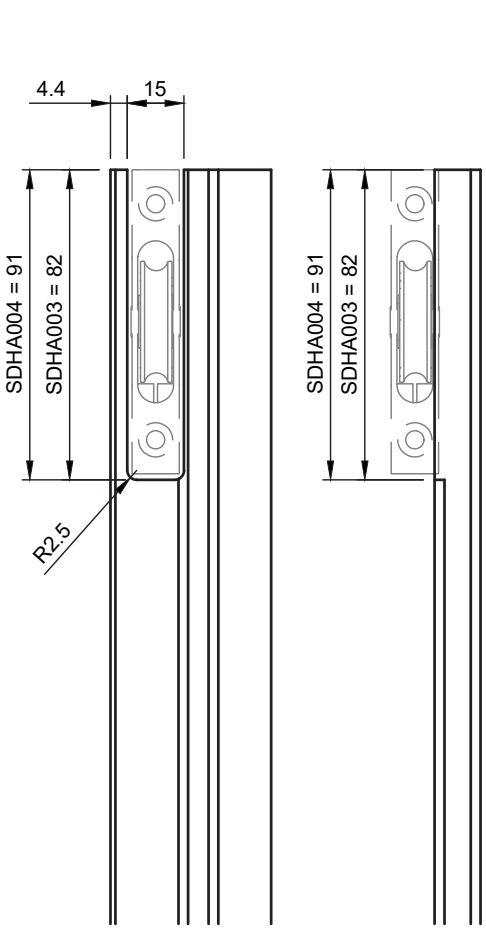
CONFIGURATION: SF
GLAZING: 10mm

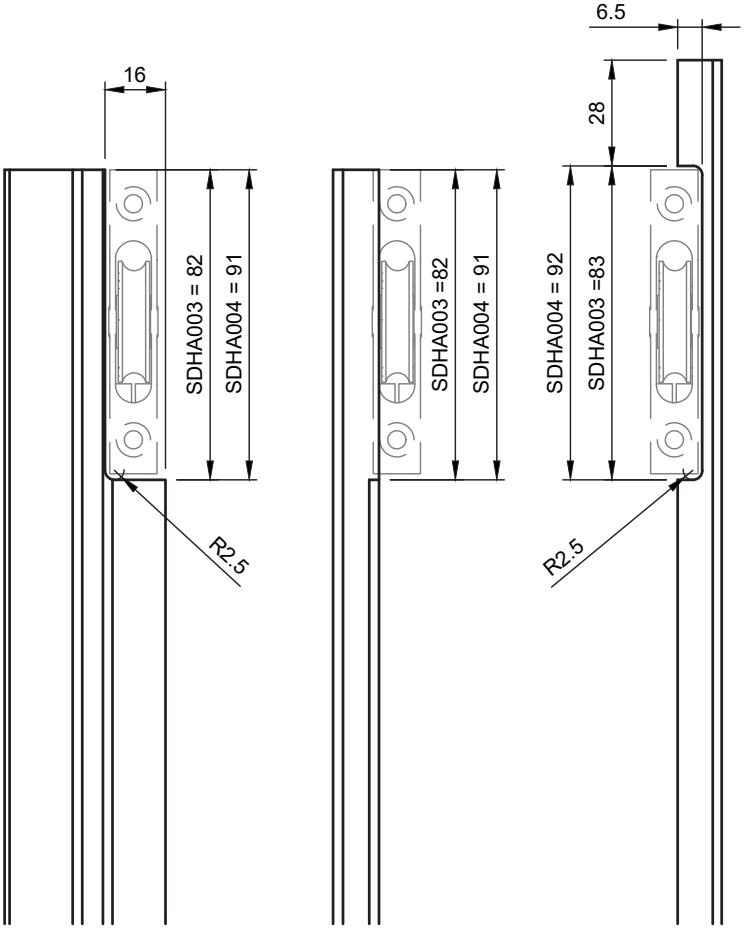


CONFIGURATION: FS
GLAZING: 10mm



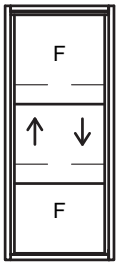




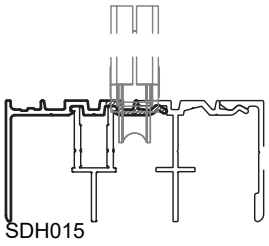


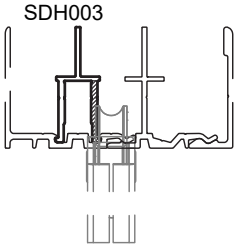
10. Manufacturing Details

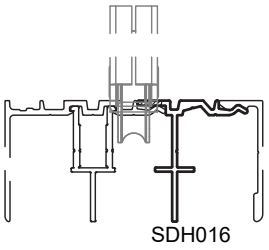
Servery Frame Pulley Clearance - 3 Panel 10mm

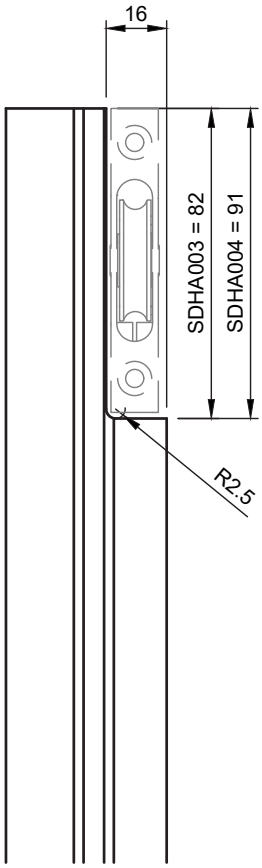


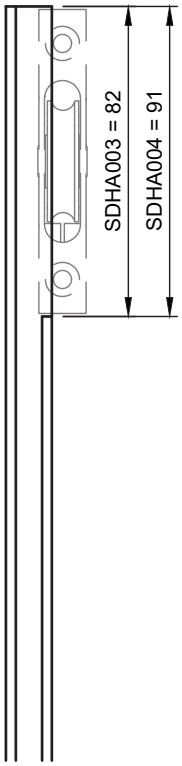
CONFIGURATION: FSF
GLAZING: 10mm

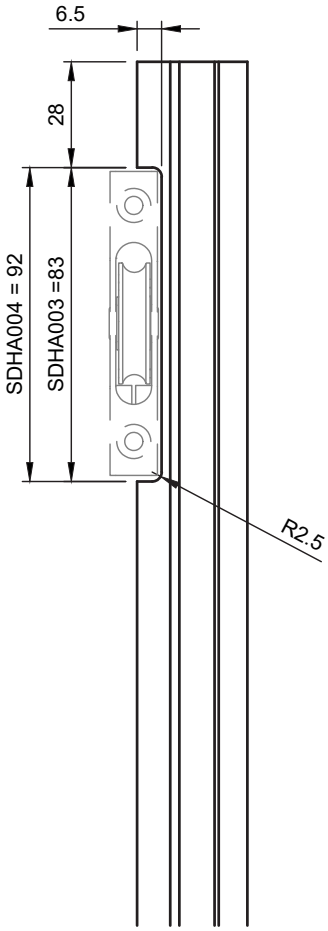






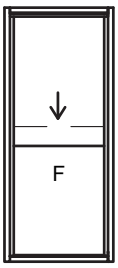




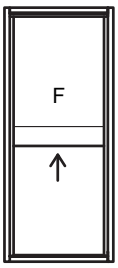


10. Manufacturing Details

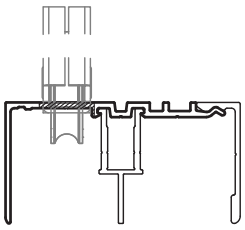
Servery Frame Pulley Clearance - 18mm



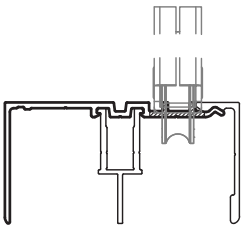
CONFIGURATION: SF
GLAZING: 18mm



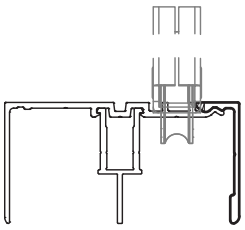
CONFIGURATION: FS
GLAZING: 18mm



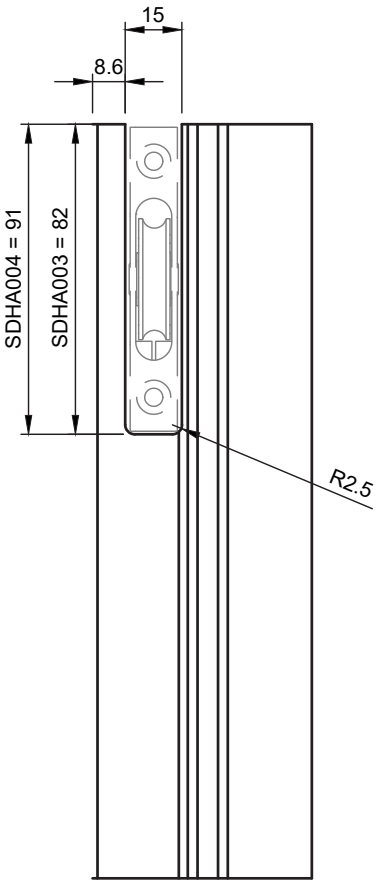
SDH019

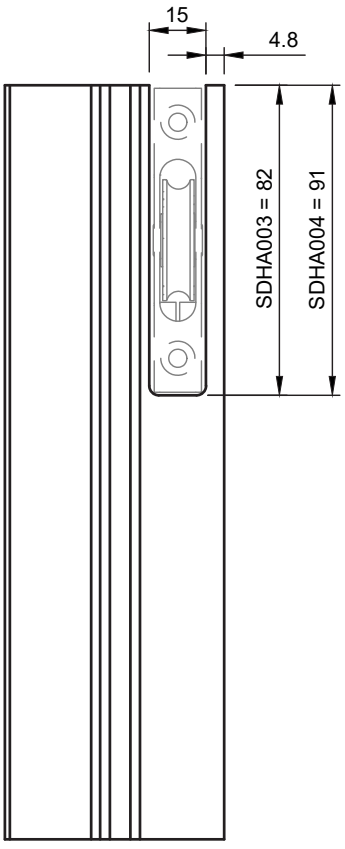


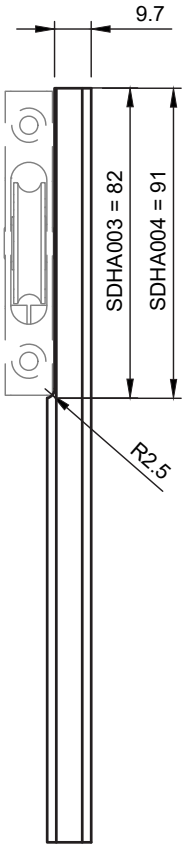
SDH019



SDH002



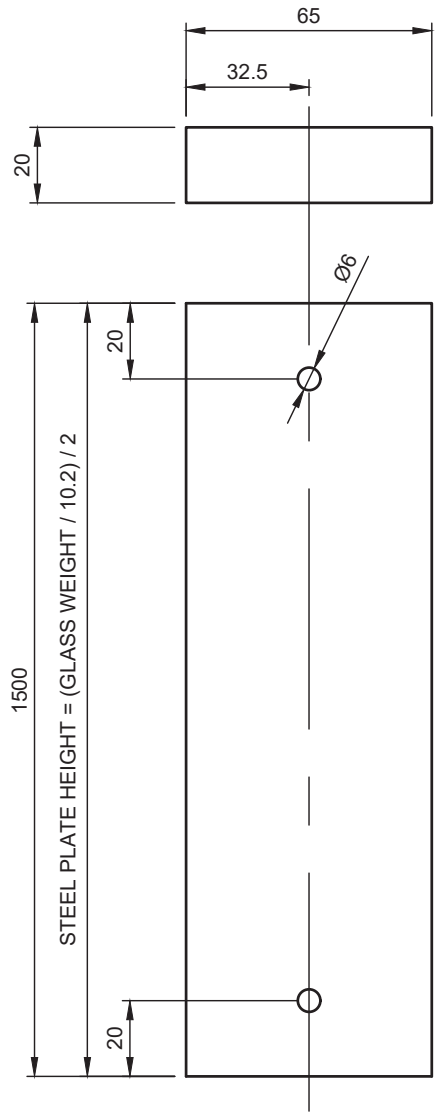




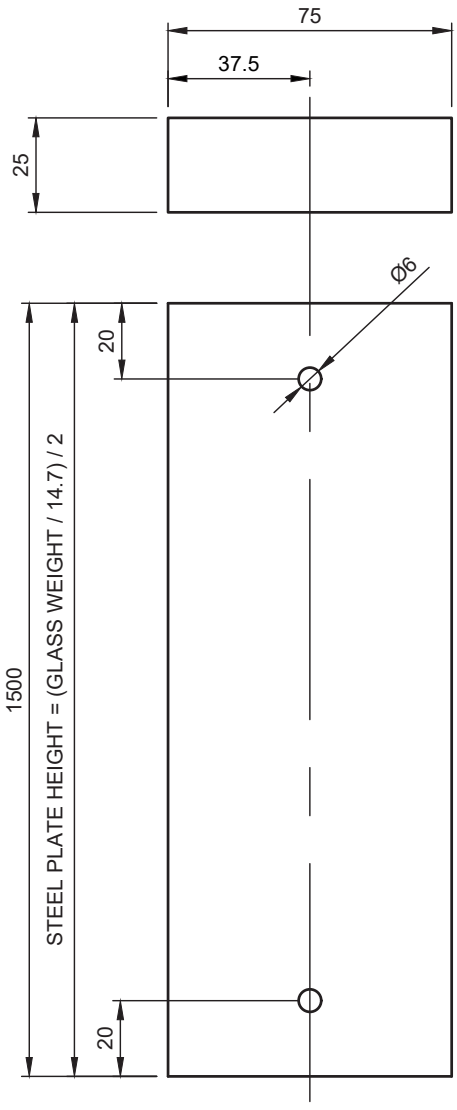
10. Manufacturing Details

Servery Steel Plate Height

SDHA019 STEEL PLATE 65 x 20 x 1.5m
WEIGHT: 10.2kg/m



SDHA020 STEEL PLATE 75 x 25 x 1.5m
WEIGHT: 14.7kg/m



NOTE: ALL HOLES DRILLED AND CUTS NEED TO BE CHAMFERED/COUNTERSUNK TO AVOID POTENTIAL DAMAGE TO THE CORD

REFER TO GLASS LABEL FOR GLASS WEIGHT OR USE THE BELOW FORMULA:

GLASS WEIGHT = GLASS WIDTH (m) x GLASS HEIGHT (m) x GLASS THICKNESS (mm) x 2.5

MAXIMUM PLATE HEIGHTS

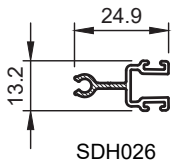
2 PANEL SF, FS:	LESS THAN 1500mm* & LESS THAN GLASS HEIGHT - 200mm
3 PANEL FSF:	LESS THAN 1500mm* & LESS THAN GLASS HEIGHT + 955mm

* PLATE IS SUPPLIED PRE-CUT AT 1500mm LENGTHS WITH 2 x 6mm DIA. HOLES ON EACH END, ANY SIZES REQUIRED GREATER THAN THIS AND MEETS THE OTHER CONSTRAINTS WILL NEED TO BE SOURCED BY THE FABRICATOR

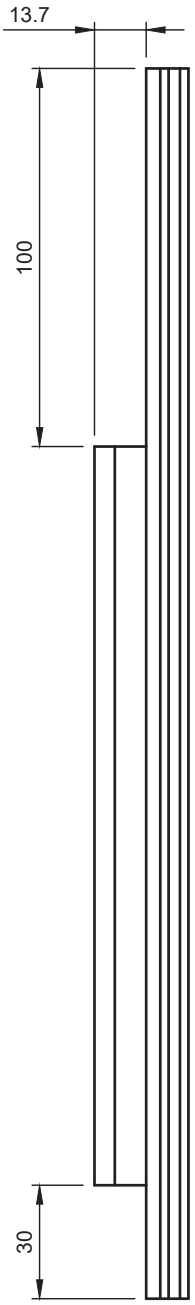
10. Manufacturing Details

Stile Machining for SS Cord - BAL 40

* MACHINED TO ALL OPERATING STILES

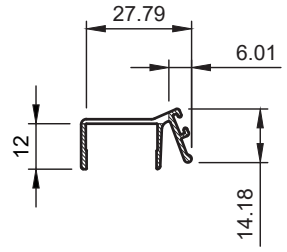


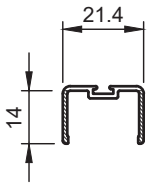
SDH026

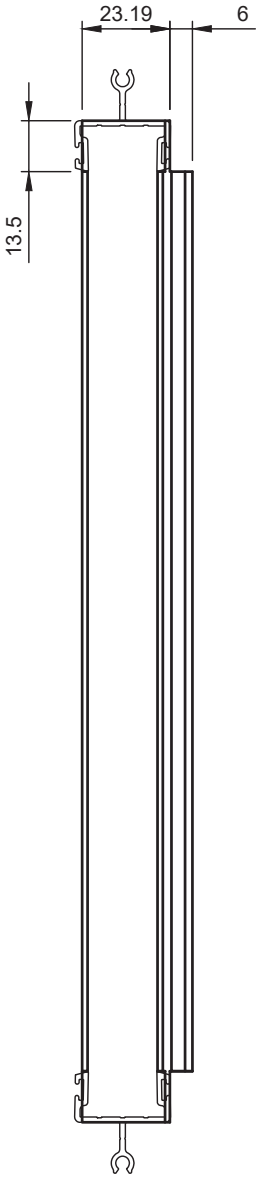


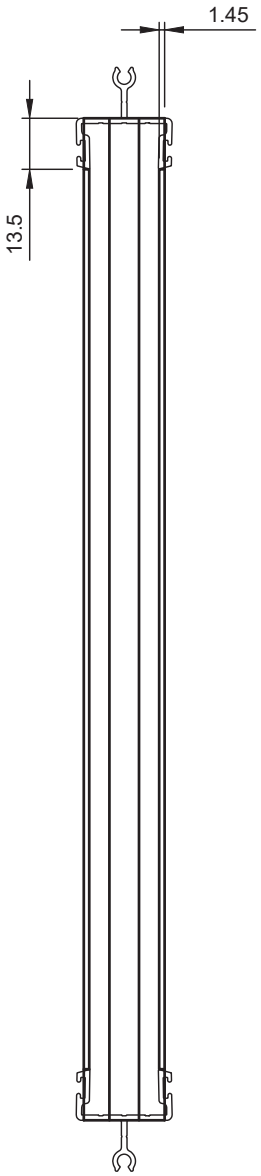
10. Manufacturing Details

18mm Sash Rail and Interlock Preparation



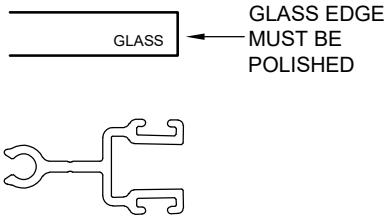




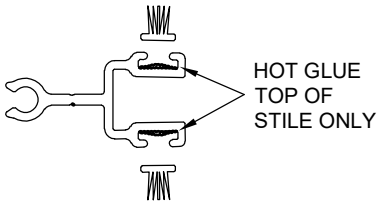


11. Assembly Details

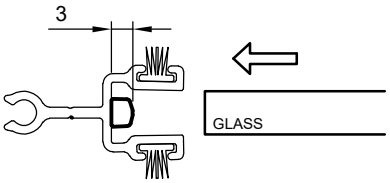
Sash Assembly



CLEAN GLASS EDGE AND PVC STILE SURFACE, ADMIL PROSIL PRIMER CLEANER 1385080 OR SIMILAR, BEFORE APPLYING SILICONE

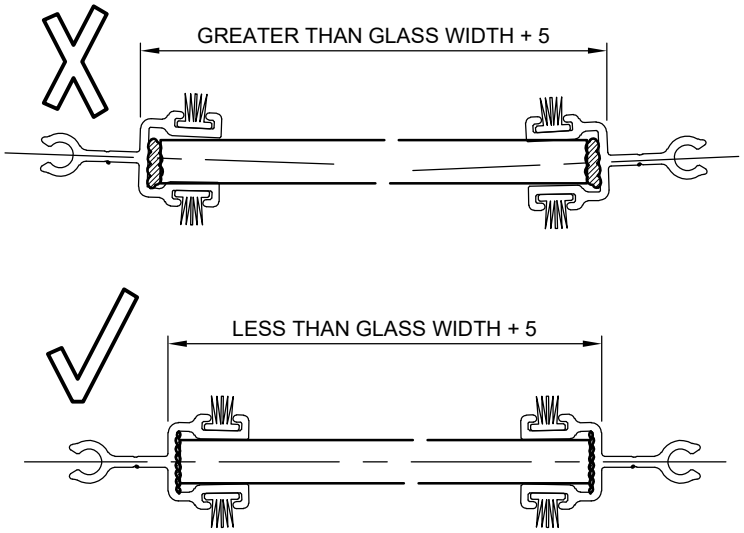


PLACE A DOB OF HOT GLUE ON THE TOP END OF THE STILE, AS SHOWN, TO PREVENT MOHAIR FROM SLIPPING OUT DURING OPERATION RUN THE MOHAIR THE FULL LENGTH OF THE STILE



APPLY 3mm DIA. BEAD OF SILICONE ALONG THE LENGTH OF THE STILE, ADMIL PROSIL 60 SILICON (1385002) OR SIMILAR. FIRMLY PUSH THE GLASS AND STILE TOGETHER ENSURING THE STILE IS STRAIGHT AND PARALLEL WITH THE GLASS

FINAL CHECK

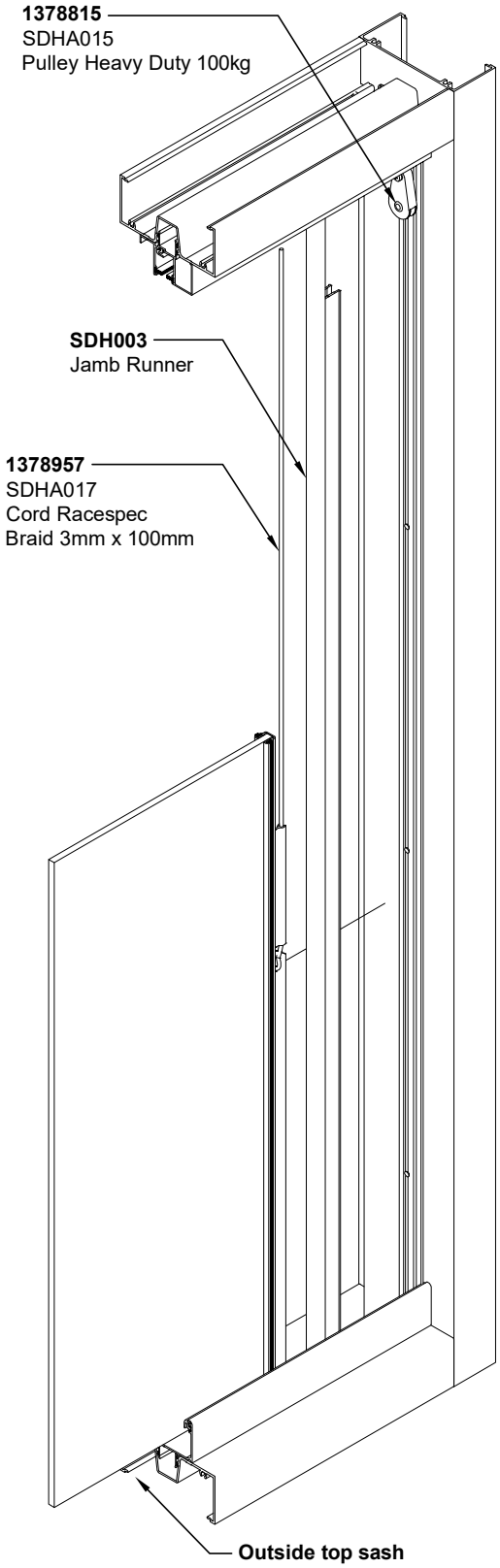


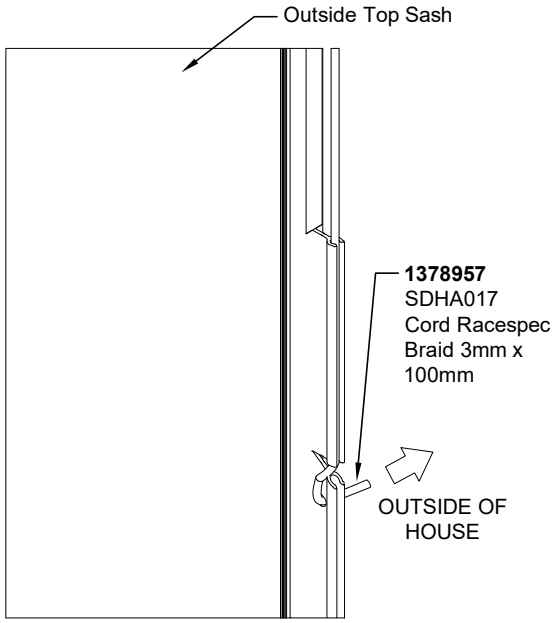
IMPORTANT!

PVC STILE MUST BE PARALLEL WITH THE GLASS MEASURE THE DISTANCE AS SHOWN ABOVE AND ENSURE IT DOES NOT MEASURE MORE THAN GLASS WIDTH + 5mm

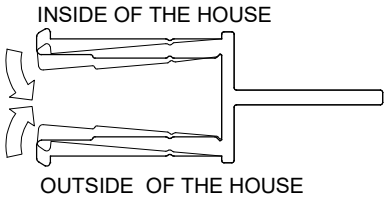
PLEASE ENDURE THAT CURE TIME IS AS PER SILICON MANUFACTURERS INSTRUCTIONS, BEFORE HANGING THE SASHES

Outside Sash & Jamb Runner Clip On Assembly

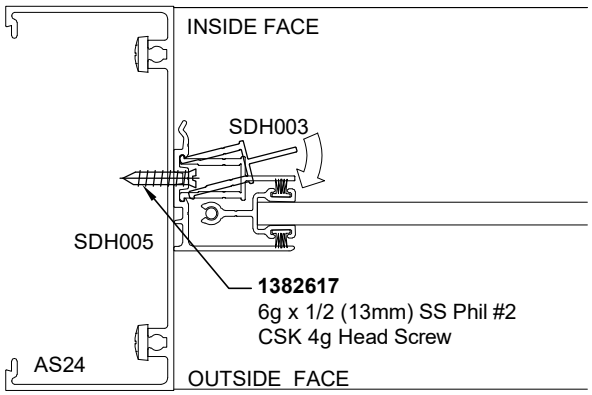




1. FEED CORD THROUGH THE CORD FLUTE OF THE PVC STILE AND THE NOTCH OUT, THEN FEED CORD THROUGH THE HOLE PUNCH OUT SO THAT EXCESS CORD FACES THE OUTSIDE OF THE HOUSE TIE A KNOT HARD UP AGAINST THE FACE OF THE STILE AND CUT THE CORD 30mm PAST THE KNOT. MELT THE END OF THE CORD WITH A LIGHTER TO AVOID CORD FRAYING



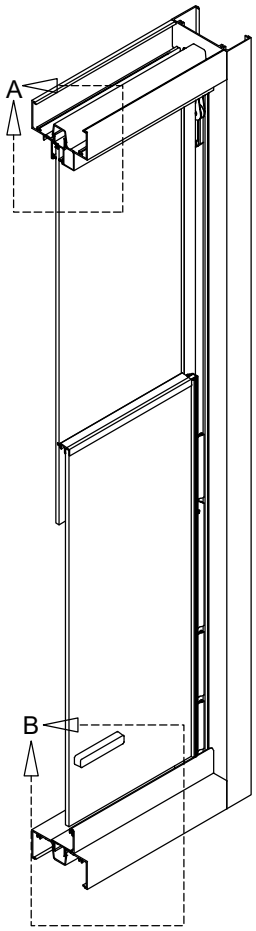
2. SLIGHTLY BEND THE TOP 20mm OF SDH003 LEGS TO HELP WITH CLIPPING ONTO SDH005

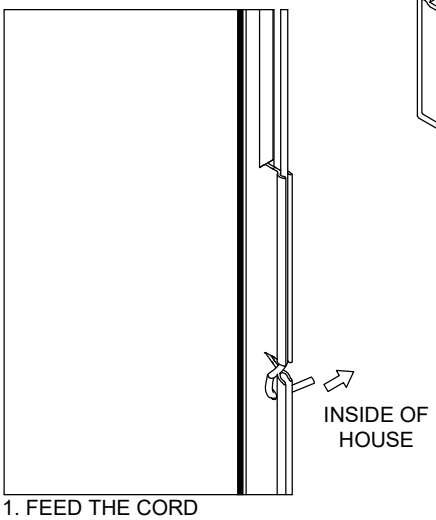


3. CLIP THE INSIDE LEG OF SDH003 ONTO SDH005 FIRST AND, STARTING FROM THE TOP OF THE SECTION, PUSH AND ROTATE THE ADAPTOR TOWARDS THE OUTSIDE SASH UNTIL THE LEG CLIPS ON. WORK YOUR WAY DOWN UNTIL JAMB RUNNER IS COMPLETELY CLIPPED ON.

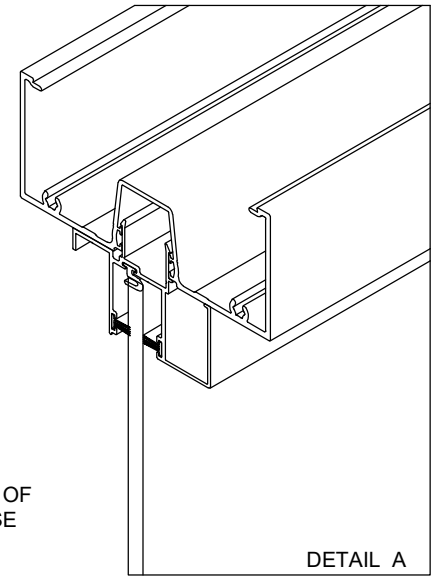
11. Assembly Details

Hanging the Sashes

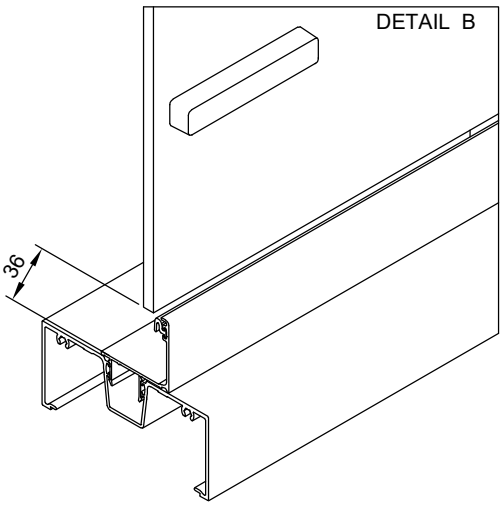




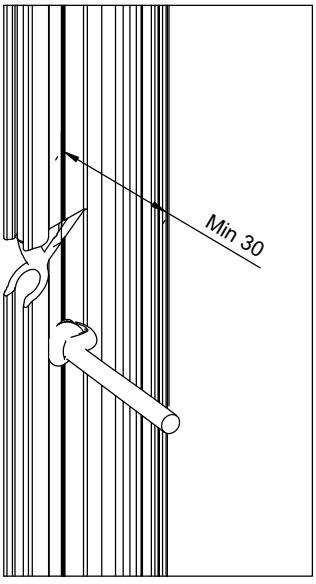
1. FEED THE CORD THROUGH THE CORD FLUTE OF THE PVC STILE BOTTOM SASH UNTIL IT REACHES THE NOTCH OUT TAKE THE CORD OUT THEN FEED IT THROUGH THE HOLE PUNCH OUT SO THAT EXCESS CORD FACES THE INSIDE OF THE HOUSE



2. LIFT THE OUTSIDE TOP SASH HARD UP AGAINST THE HEAD SEAL YOU MAY NEED AN ADDITIONAL PERSON TO ASSIST OR USE A BLOCK OF TIMBER TO HOLD THE SASH IN POSITION



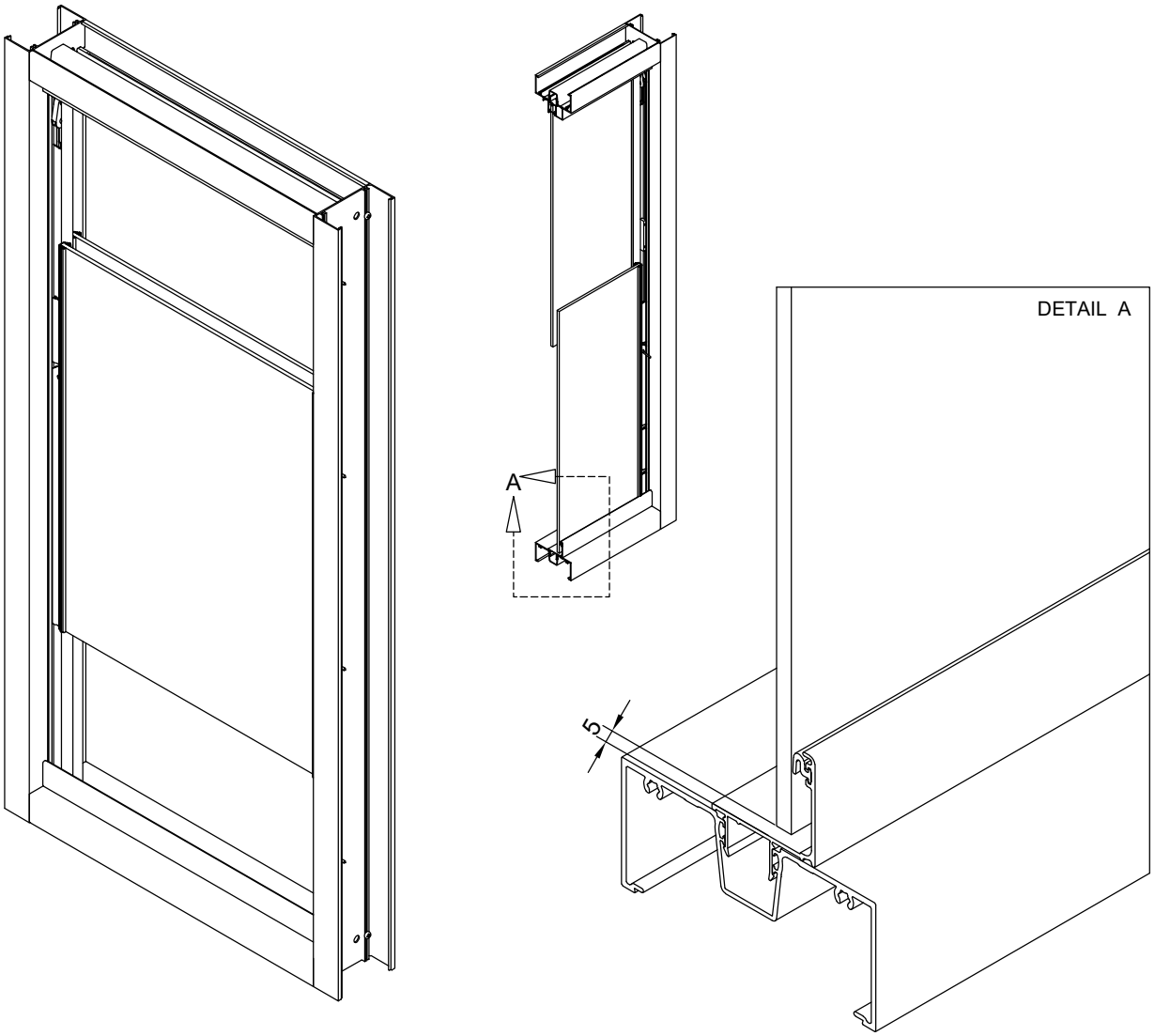
3. RAISE THE BOTTOM INTERNAL SASH SO THE BOTTOM OF THE GLASS LINES UP WITH THE TOP OF THE SILL, USE PACKERS AS REQUIRED



4. TIE THE KNOT, CUT THE CORD 30mm PAST THE KNOT AND MELT THE CUT END WITH A LIGHTER

11. Assembly Details

Sash Adjustments



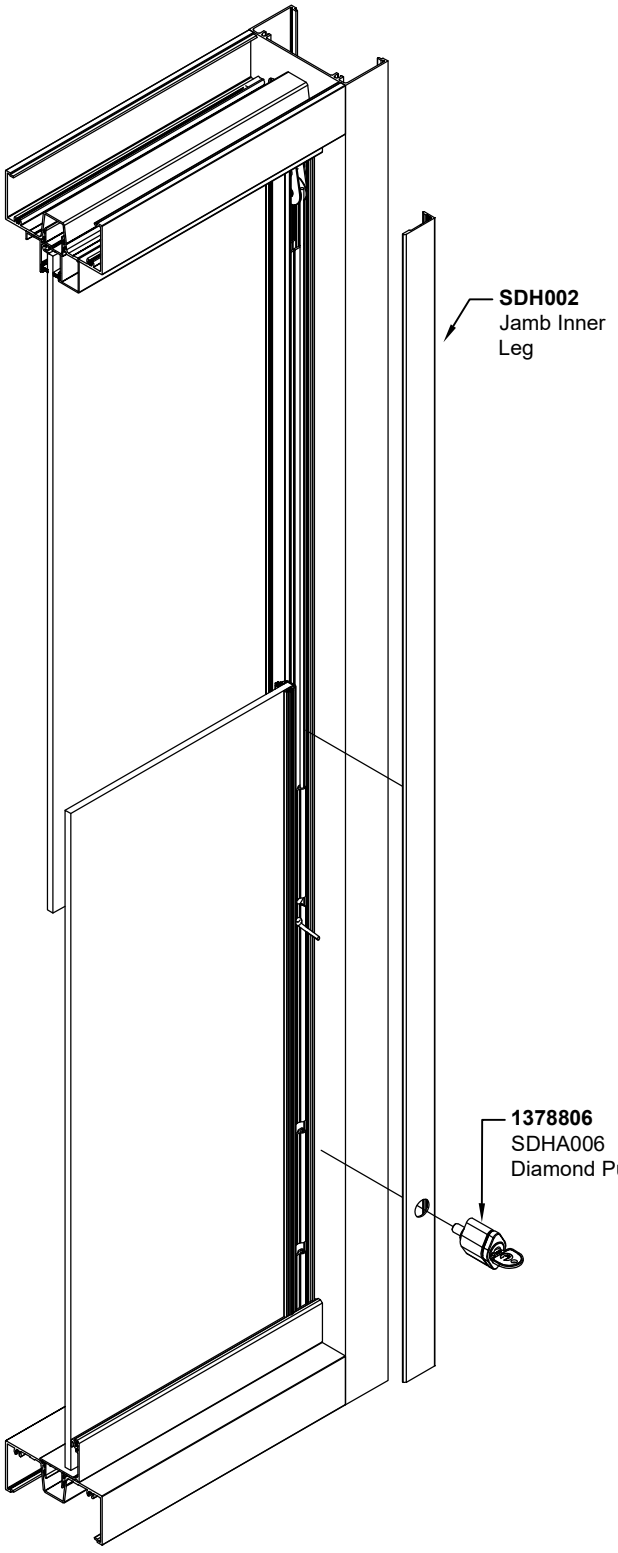
1. SLIDE SASHES UP AND DOWN TO ENSURE IT OPERATES SMOOTHLEY. OPEN THE PANELS SO THAT THEY LINE UP IN THE MIDDLE OF THE WINDOW AS SHOWN. WITH ONE HAND HOLDING THE TOP OF BOTH SASHES AND THE OTHER HANDLE HANDLE THE BOTTOM OF BOTH SASHES, LIFT THE SASHES UP SLIGHTLY THEN FIRMLY PULL DOWN THE SASHES TO STRETCH THE CORDS AND TIGHTEN THE KNOTS

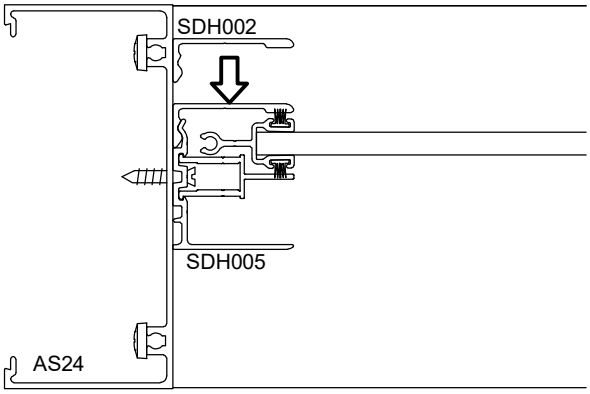
2. CLOSE THE SASHES SO THAT THE TOP IS HARD UP AGAINST THE HEAD SEAL THEN CHECK THAT THE GAP BETWEEN THE BOTTOM INTERNAL GLASS AND THE SILL IS 5mm.

3. CHECK THAT THE GLASS IS STILL PARALLEL AND OPERATES SMOOTHLY, REPEAT ADJUSTMENTS IF REQUIRED.

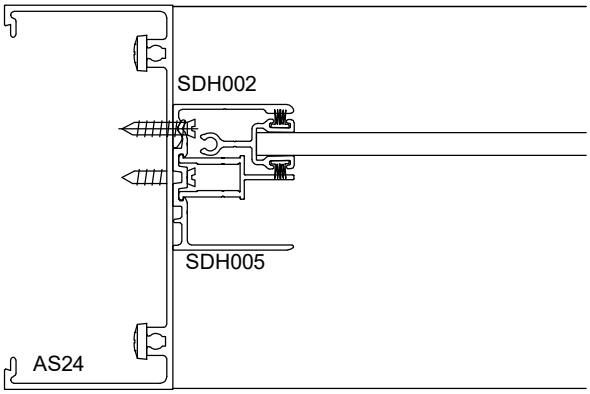
11. Assembly Details

Lock Assembly





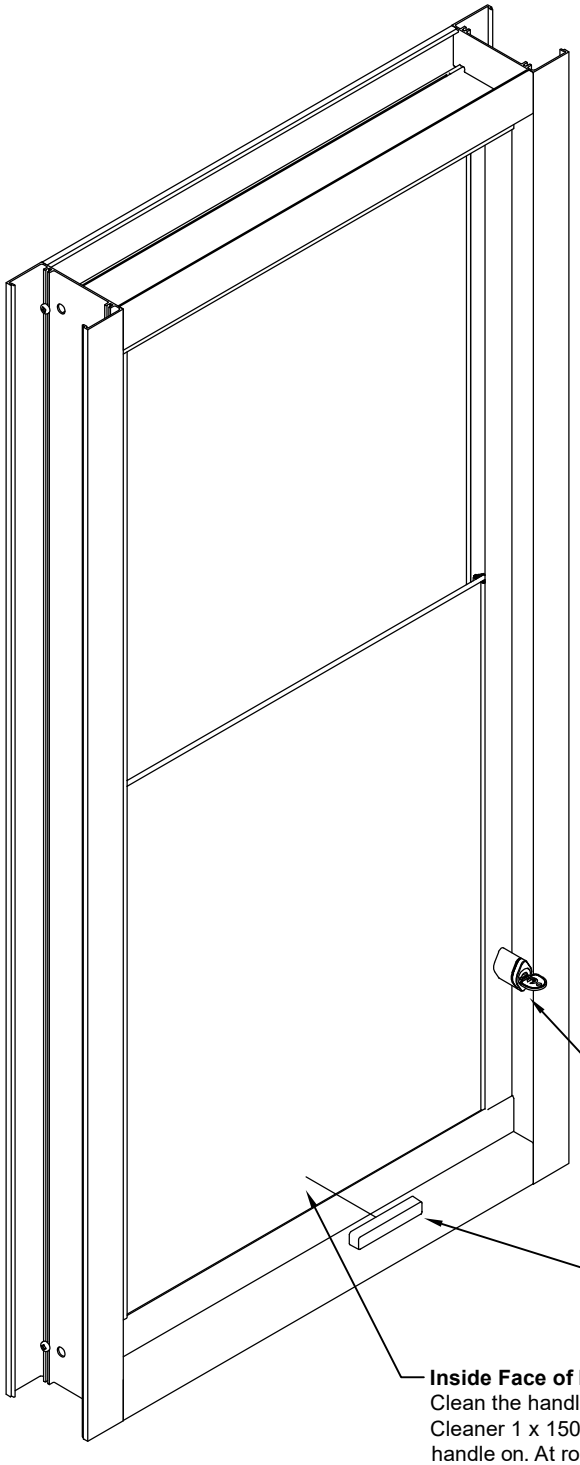
PUSH SDH002 JAMB INNER LEG UNDERNEATH SDH005

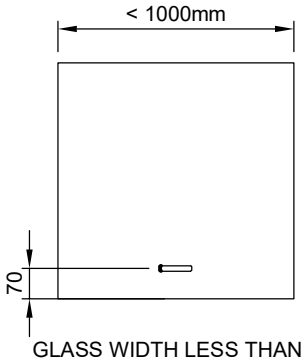


FOR 2KPA ULS OR GREATER, 6 x $\frac{3}{4}$ SS 4G CSK HEAD FIXINGS IS REQUIRED 100mm FROM THE SILL AND AT MIDPOINT OF FRAME

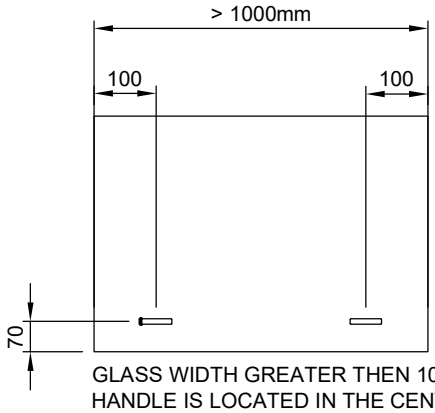
11. Assembly Details

Handle to Glass Assembly





GLASS WIDTH LESS THAN 1000mm HANDLE HEIGHT IS 70mm FROM THE SILL, OR, FOR FLOOR TO CEILING WINDOWS, 70mm FROM THE TOP OF THE GLASS



GLASS WIDTH GREATER THEN 1000mm HANDLE IS LOCATED IN THE CENTRE OF THE SASH, FOR GLASS WIDER THEN 1000mm, 2 HANDLES ARE REQUIRED, 1000mm FROM EACH EDGE OF THE GLASS

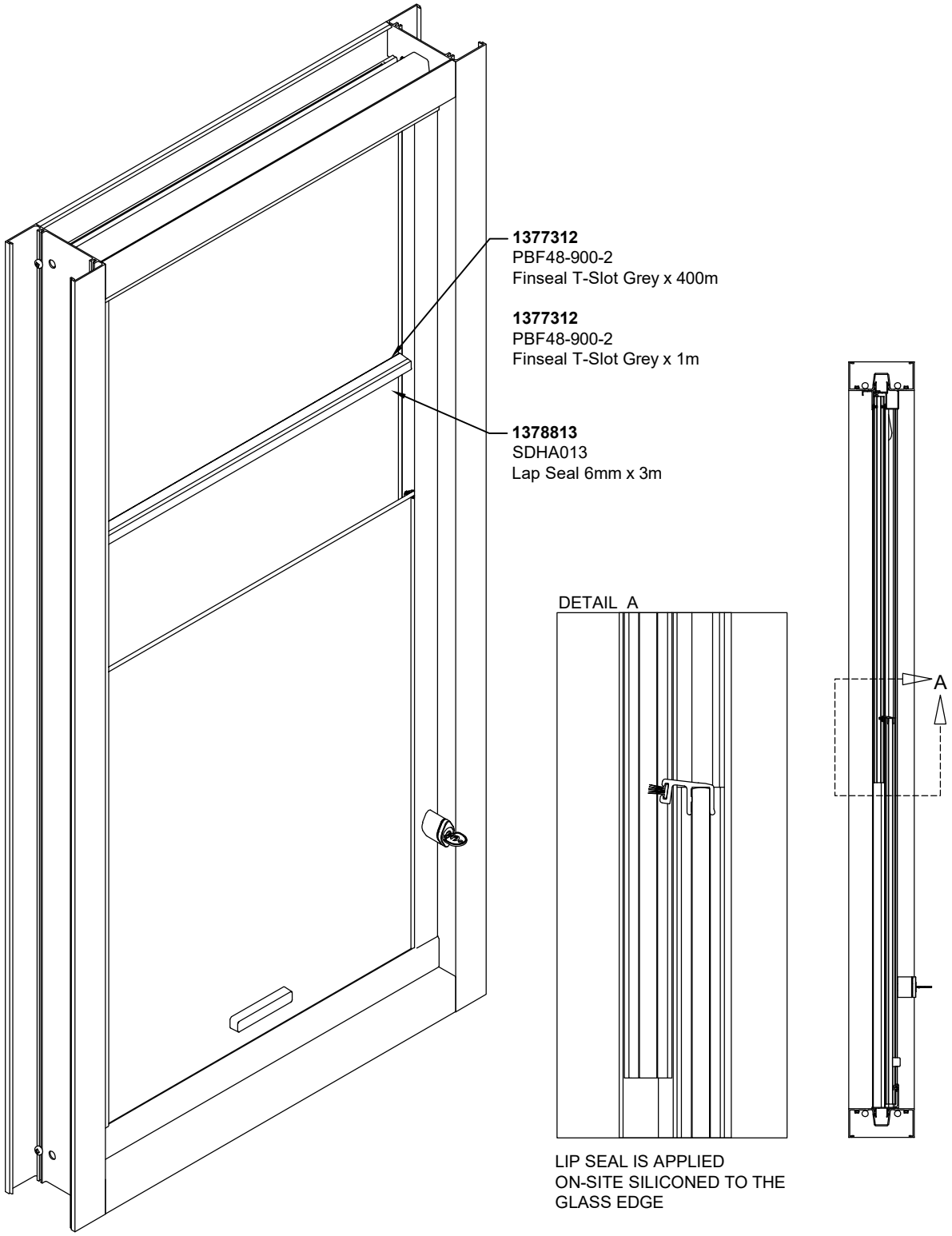
1378806
SDHA006
Diamond Push Lock Keyed

1378812
SDHA012
Acrylic Handle

Inside Face of Bottom Sash
Clean the handle area of the glass with Admil Prosil Primer Cleaner 1 x 150g (1385080), or similar before sticking the handle on. At room temperature, approximately 50% of ultimate strength will be achieved after 20 mins, 90% after 24hrs and 100% after 72 hrs.

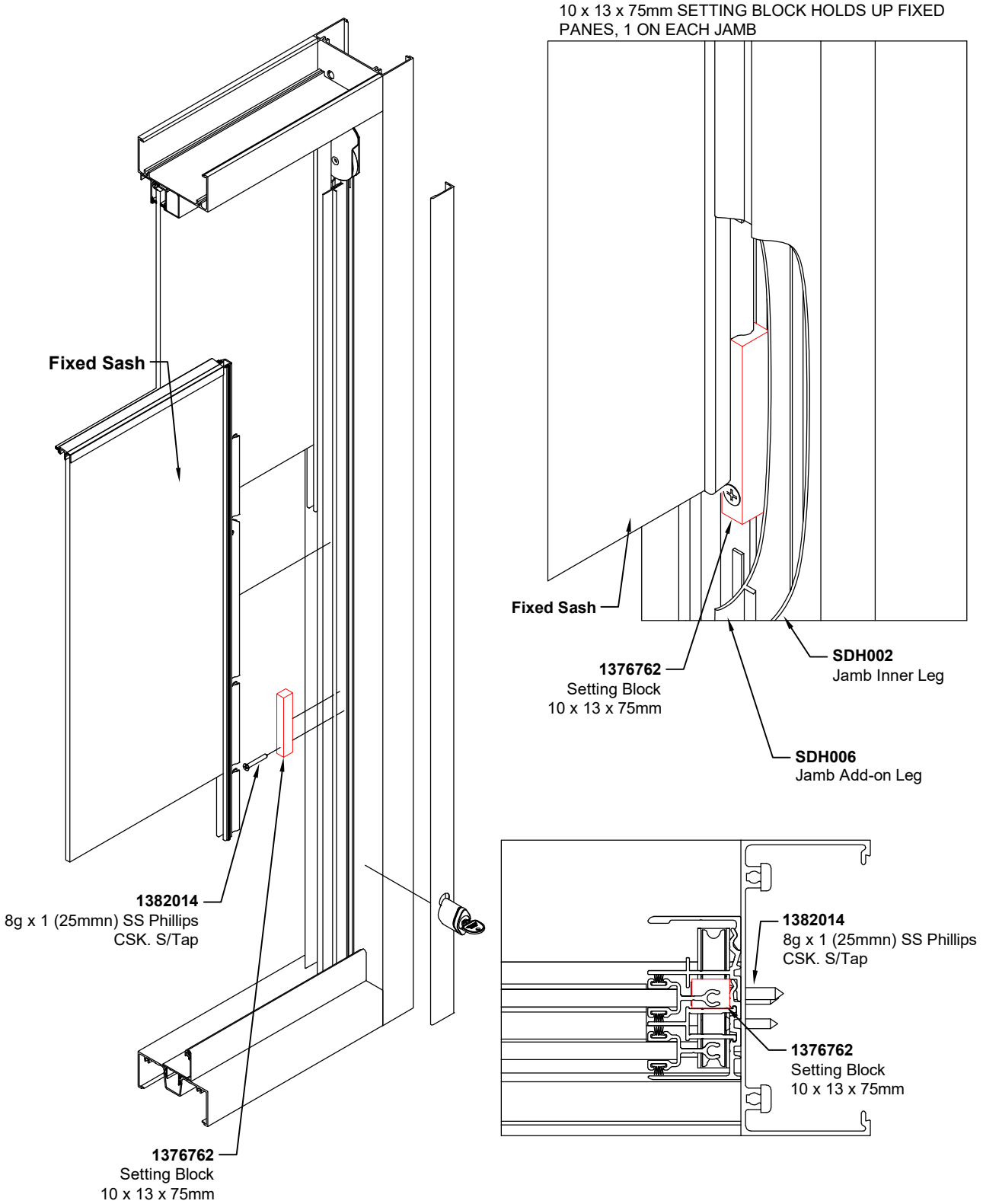
11. Assembly Details

Lap Seal Assembly



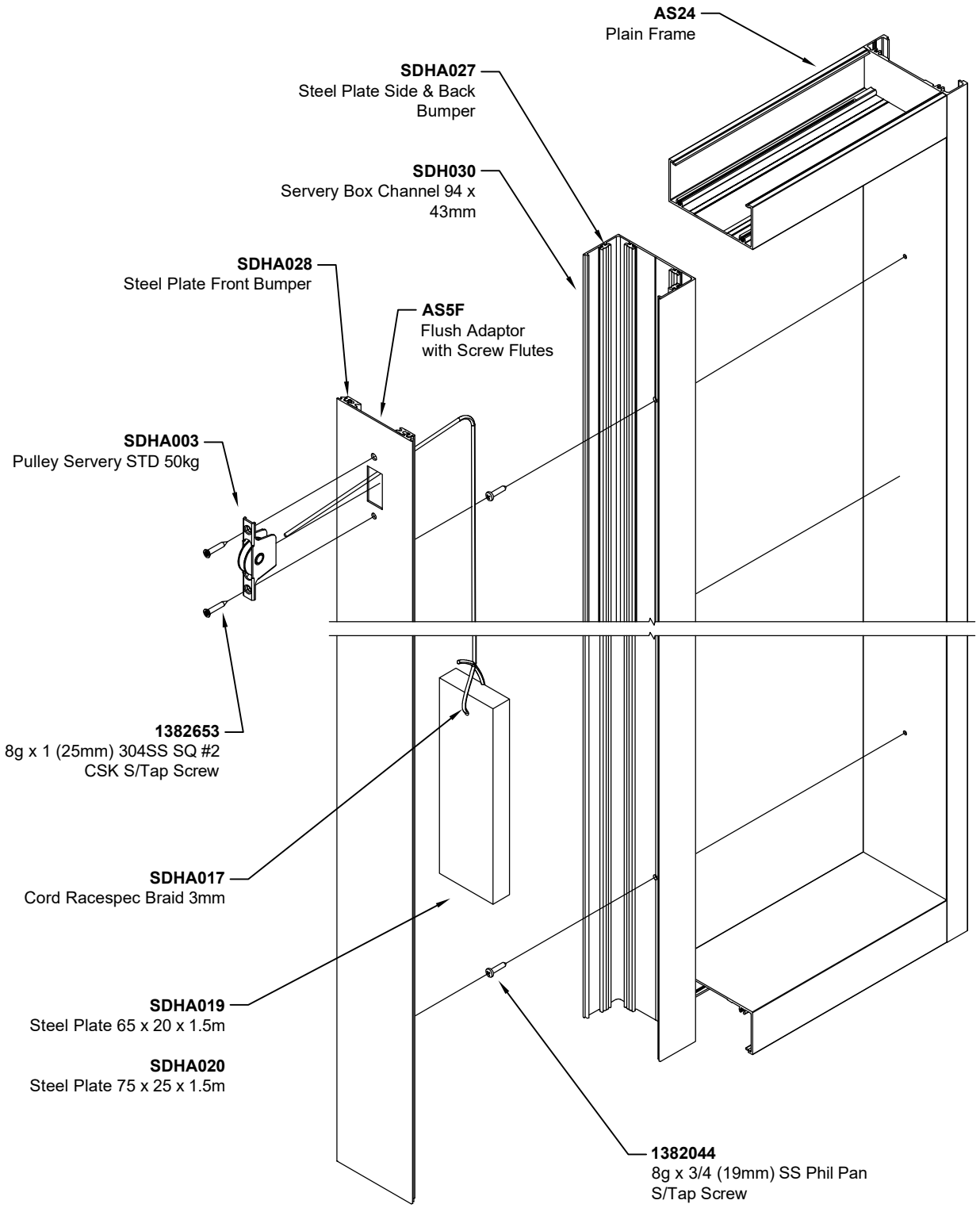
11. Assembly Details

Fixed Sash Assembly



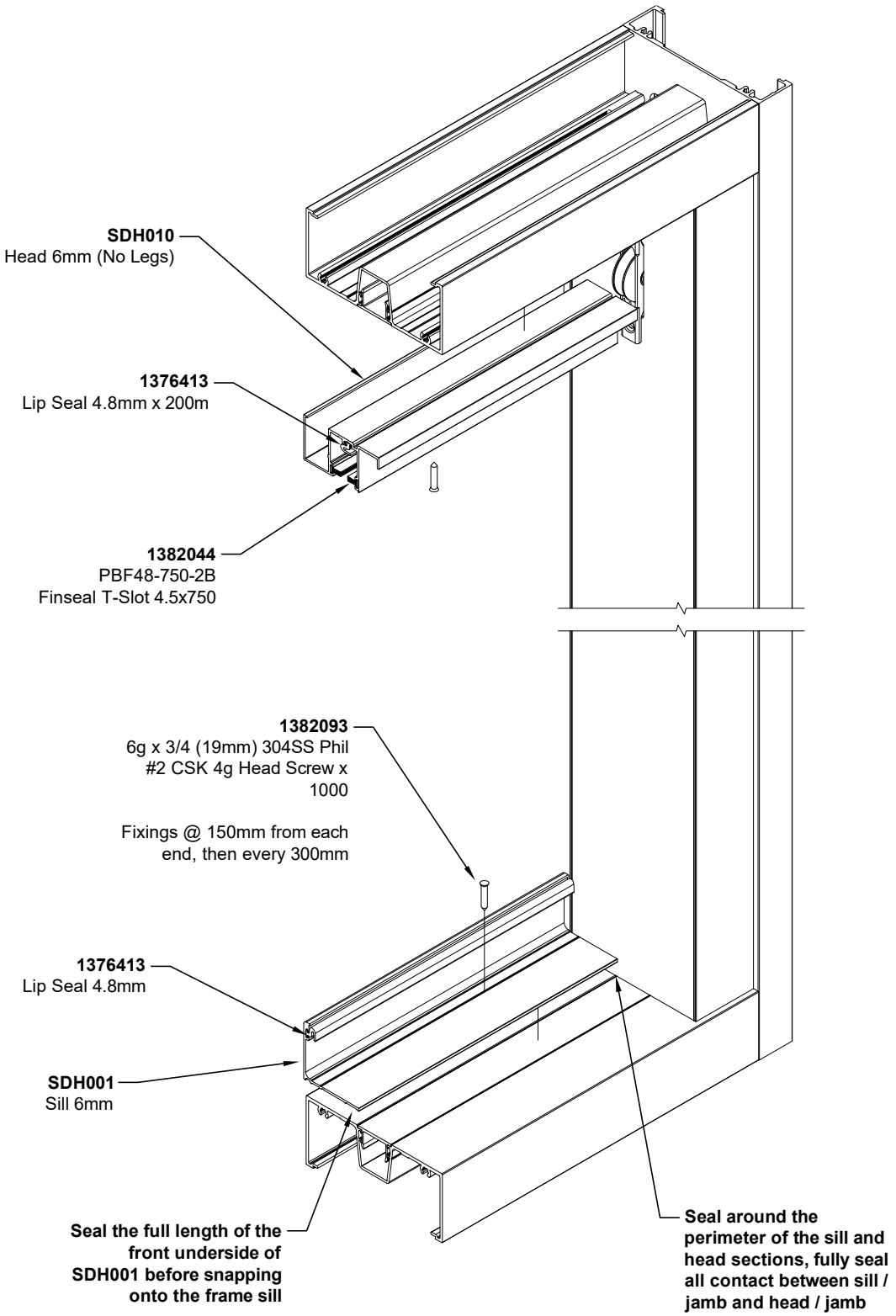
REFER TO STILE MACHINING ON PAGE 10.12 & 10.13

Servery Window - Servery Box Channel



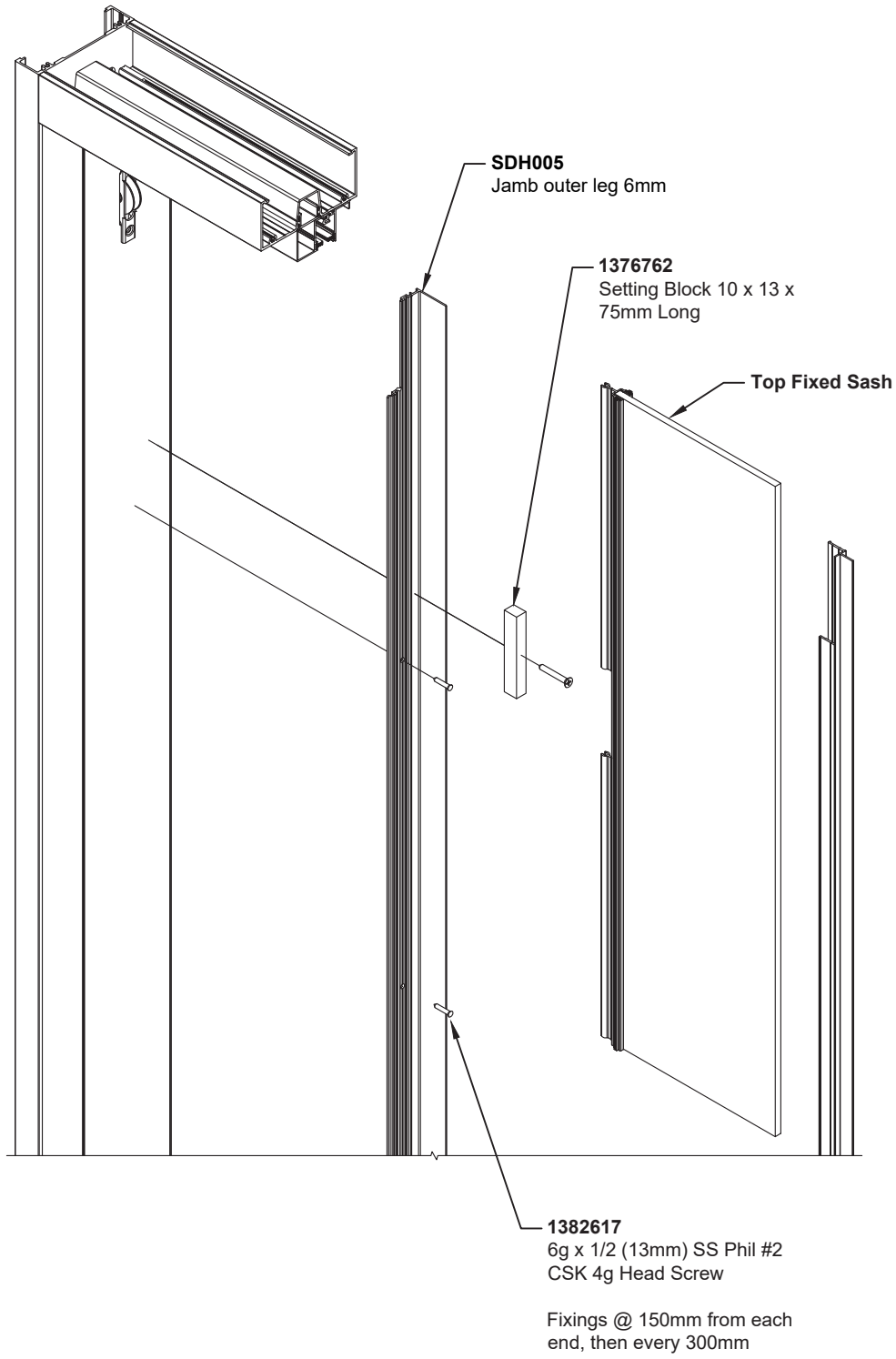
11. Assembly Details

Servery Window - Head & Sill

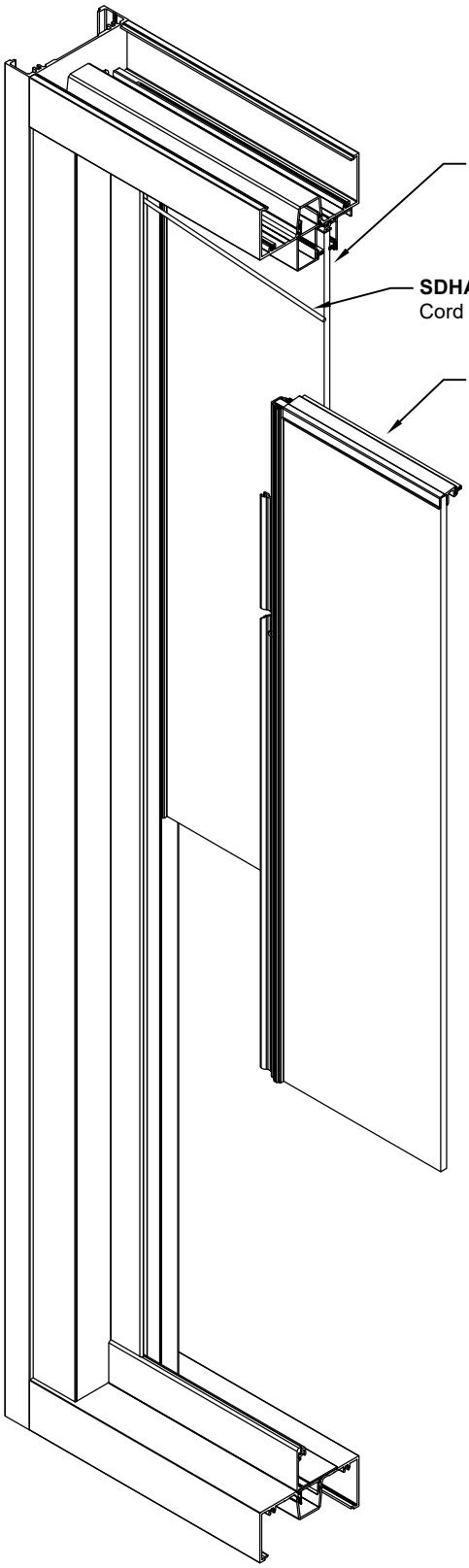


11. Assembly Details

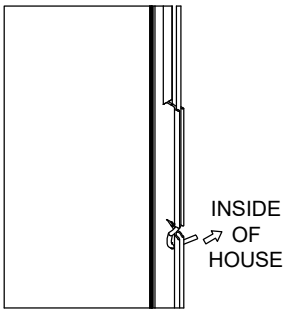
Servery Window - Jamb & Fix Sash



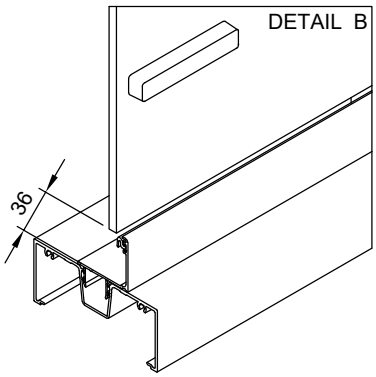
Servery Window - Operating Sash to Weight



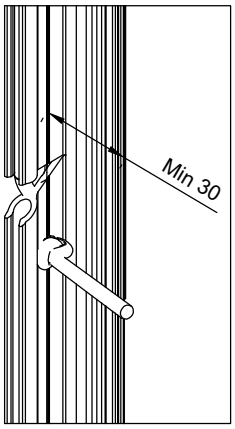
REFER TO STILE MACHINING ON page 10.11



1. FEED THE CORD THROUGH THE CORD FLUTE OF THE PVC STILE BOTTOM SASH UNTIL IT REACHES THE NOTCH OUT TAKE THE CORD OUT THEN FEED IT THROUGH THE HOLE PUNCH OUT SO THAT EXCESS CORD FACES THE INSIDE OF THE HOUSE



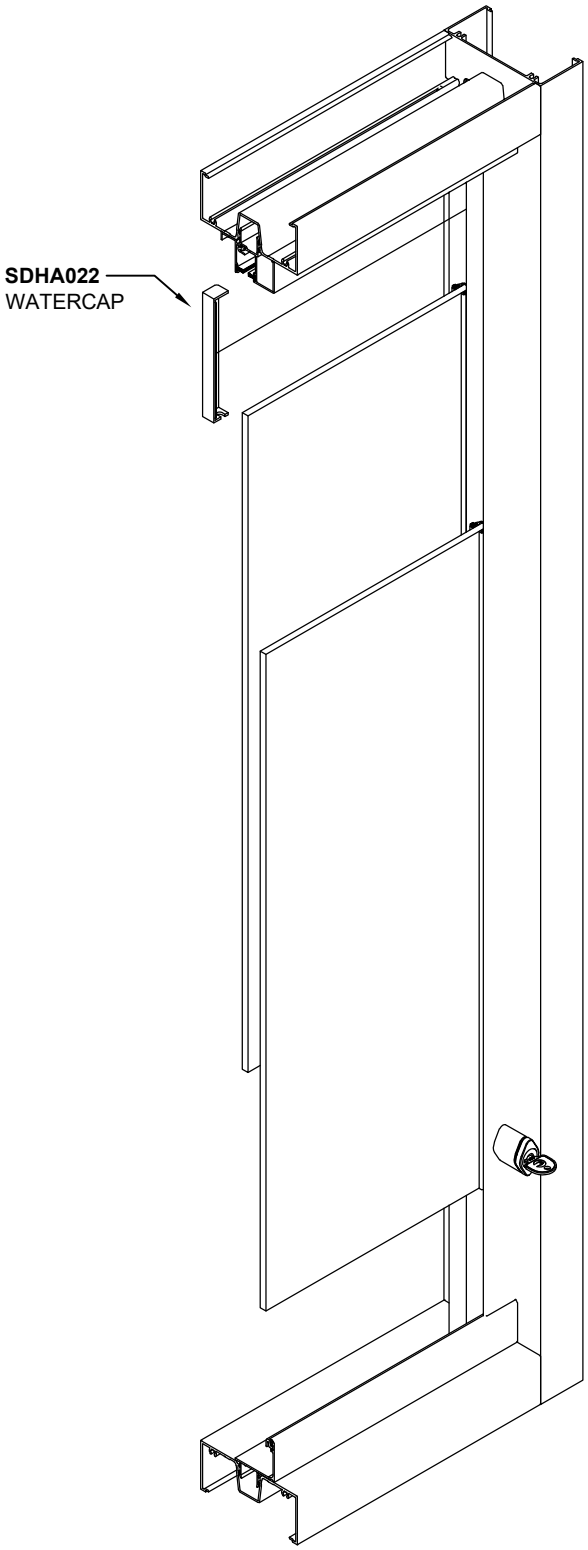
3. RAISE THE BOTTOM INTERNAL SASH SO THE BOTTOM OF THE GLASS LINES UP WITH THE TOP OF THE SILL, USE PACKERS AS REQUIRED



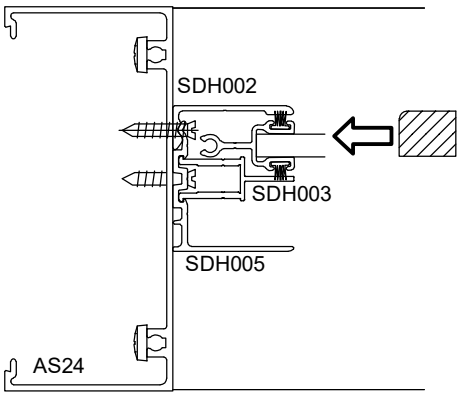
4. TIE THE KNOT, CUT THE CORD 30mm PAST THE KNOT AND MELT THE CUT END WITH A LIGHTER

11. Assembly Details

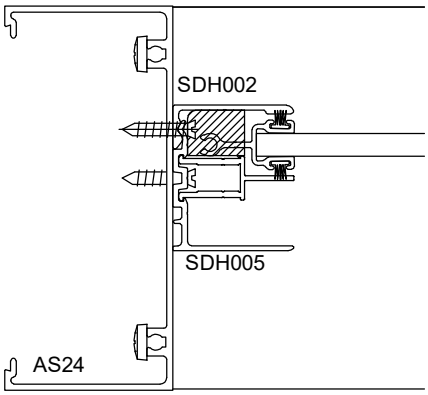
Water Cap Assembly



NOTE: SDHA022 - PULLEY WATER CAP IS ONLY REQUIRED WHEN ACHIEVING 450pA WATER RATING.



PUSH SDHA022 WATERCAP INTO GAP BETWEEN SDH002 AND SDH003 UNTIL PART CLIPS ONTO SDH003.



FRAMING

Your new **Provista Sashless Double Hung Window** frames 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 **Provista Sashless Double Hung Window** frame will retain it's good looks and resist the elements for years to come.

The **Provista Sashless Double Hung Window** frames 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 **Provista Sashless Double Hung Window** frames 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 **Provista Sashless Double Hung Window** frames 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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