



ecoFRAMEplus®

Centre Pocket Double Glazed Framing

ecoFRAMEplus

101.6mm Centre Pocket DG Framing

Technical Manual

March 2025 | ISSUE P

alspec®
EVERYTHING ALUMINIUM
& HARDWARE

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1. Technical Manual Release Notes

This page is intended to record all changes to the **ecoFRAMEplus 101.6mm CENTRE POCKET DOUBLE GLAZED FRAMING** 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	03/2008	Technical manual initial release	
B	08/2008	Santoprene glazing wedges added	
C	02/2009	Loading table explanation added, added double glazing framing extrusions	
D	06/2010	Full manual revised - section numbers changed	
E	01/2011	Sill & bead extrusions updated	
F	01/2014	Technical manual revised and updated for reprint	
G	06/2015	Extrusion pages and contact page updated	
H	02/2020	Technical Manual Update & Re-release	360
I	06/2020	50mm Pocket Framing Added & Updated	385
J	02/2021	ECO211 removed and replaced with ECO240 & ECO241	429
K	02/2021	Added note for 50mm Pocket Frame on page 5.5	436
L	02/2023	Added ECO229 to Extrusions page 5.5	545
M	05/2023	Added FRT210420.R2 BAL AA-40 Test Report to page 4.2	554
N	11/2023	Added OT23-173 Test Summary on page 4.2	573
O	04/2024	Added OT24-219 Test Summary on page 4.3	584
P	03/2025	Added ECO206 to Extrusions page 5.3	611

2. Technical Specifications

ALUMINIUM

Aluminium frames should be manufactured using Alspec's **ecoFRAMEplus 101.6mm CENTRE POCKET DOUBLE GLAZED FRAMING** system.

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

GLAZING

- Minimum glass thickness is 4mm.
- Maximum glass thickness is 43mm.
- Glazing components shall be as per Alspec Technical Manual. Refer to page 12.1 to 12.4 for glazing details.
- For window & door systems requiring a co-extruded captive gasket on the external side of the glazed pocket, Santoprene is the recommended material to be applied.

HARDWARE

- All hardware as per Alspec 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 **ecoFRAMEplus 101.6mm CENTRE POCKET DOUBLE GLAZED FRAMING** 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.

3. Loading Tables

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 door frame, which is 2400mm high and 1000mm wide, refer to the table below;

Step 1: Locate the height

Step 2: Locate the width

Step 3: Determine the Maximum wind pressure based on the height and width.

SECTION PART NO.	Panel Height	Maximum Design Pressure (Pa)					
	2850	S	1040	840	720	630	570
		U	2410	1960	1660	1460	1310
	2700	S	1230	1000	850	750	680
		U	2700	2190	1870	1640	1480
	2550	S	1460	1200	1020	910	830
		U	3040	2470	2210	1860	1690
	2400	S	1770	1450	1250	1080	1010
		U	3440	2810	2410	2100	1940
	2250	S	2160	1780	1530	1370	1270
		U	3940	3230	2780	2470	2270
	2100	S	2670	2210	1920	1730	1610
		U	4550	3750	3240	2900	2680
lxx = xxx x xxx mm4	Panel Width		800	1000	1200	1400	1600

Diagram illustrating the steps to find the Maximum Design Pressure (Pa) for a door frame (2400mm high, 1000mm wide):

- STEP 1:** Locate the height (2400mm) in the Panel Height column.
- STEP 2:** Locate the width (1000mm) in the Panel Width column.
- STEP 3:** Determine the Maximum wind pressure based on the height and width. The intersection of 2400mm height and 1000mm width shows a pressure of 1450 Pa (Suction) and 2810 Pa (Uplift).

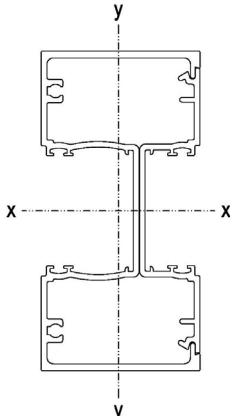
3. Loading Tables

ECO201 + ECO204 Mullion Combination

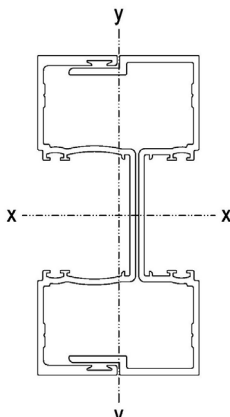
Max Stress = 110Mpa

S = Serviceability limit state I/250

U = Ultimate limit state

ECO201 + ECO204 MULLION COMBINATION	Panel Height	Maximum Design Pressure (Pa)						
	3600	S	600					
		U	1780					
	3300	S	790	640	540			
		U	2120	1720	1450			
	3000	S	1060	860	730	640	570	530
		U	2580	2090	1770	1550	1390	1270
	2700	S	1460	1190	1020	900	810	750
		U	3210	2610	2220	1950	1760	1620
	2400	S	2100	1720	1480	1320	1210	1130
		U	4090	3350	2870	2540	2310	2150
	2100	S	3000	2630	2290	2060	1920	1830
		U	5410	4460	3850	3450	3190	3030
	1800	S	3000	3000	3000	3000	3000	3000
		U	7510	6250	5490	5020	4760	4670
Ixx = 1052x 10³ mm⁴	Mullion Width		800	1000	1200	1400	1600	1800

ECO212 + ECO213 Mullion Combination

ECO212 + ECO213 MULLION COMBINATION	Panel Height	Maximum Design Pressure (Pa)						
	3600	S	670	540				
		U	1970	1590				
	3300	S	870	710	600	520		
		U	2360	1910	1610	1400		
	3000	S	1170	950	810	710	640	580
		U	2860	2320	1970	1720	1540	1410
	2700	S	1620	1320	1130	1000	900	830
		U	3560	2890	2460	2170	1950	1800
	2400	S	2330	1910	1640	1460	1340	1250
		U	4540	3710	3180	2820	2560	2390
	2100	S	3000	2920	2540	2290	2130	2030
		U	6000	4940	4270	3830	3540	3360
	1800	S	3000	3000	3000	3000	3000	3000
		U	8320	6930	6080	5560	5280	5180
Ixx = 1165 x 10³ mm⁴	Mullion Width		800	1000	1200	1400	1600	1800

Tables are based on theoretical section properties

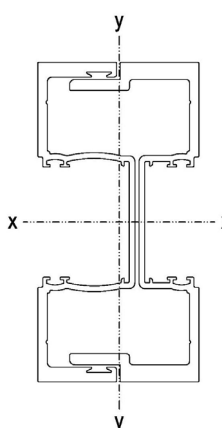
3. Loading Tables

ECO214 + ECO215 Mullion Combination

Max Stress = 110Mpa

S = Serviceability limit state I/250

U = Ultimate limit state

ECO214 + ECO215 MULLION COMBINATION	Panel Height	Maximum Design Pressure (Pa)						
	4200	S	660	530				
		U	2280	1830				
	3900	S	830	670	560			
		U	2650	2140	1800			
	3600	S	1060	860	720	630	560	
		U	3120	2520	2120	1840	1640	
	3300	S	1380	1120	950	830	740	680
		U	3720	3010	2540	2220	1980	1800
	3000	S	1850	1500	1280	1120	1010	930
		U	4520	3670	3110	2720	2440	2230
	2700	S	2560	2090	1780	1570	1430	1320
		U	5620	4570	3890	3420	3090	2840
	2400	S	3000	3000	2600	2310	2120	1980
		U	7170	5860	5020	4450	4050	3770
	2100	S	3000	3000	3000	3000	3000	3000
		U	9000	7810	6750	6050	5590	5310
	1800	S	3000	3000	3000	3000	3000	3000
		U	9000	9000	9000	8790	8330	8180
$I_{xx} = 1839 \times 10^3 \text{ mm}^4$	Mullion Width		800	1000	1200	1400	1600	1800
								2000

Tables are based on theoretical section properties

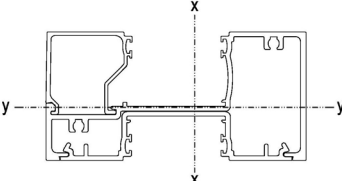
3. Loading Tables

ECO202, 204, 203 Transom

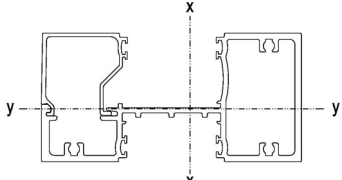
Max Stress = 110Mpa

S = Serviceability limit state I/250

U = Ultimate limit state

ECO202, 204, 203 TRANSOM	Transom Centres	Maximum Design Loads (Pa)				
	2400	S	3000	3000		
		U	9000	4840		
	2100	S	3000	3000		
		U	9000	5100		
	1800	S	3000	3000	2690	
		U	9000	5370	3270	
	1500	S	3000	3000	2780	
		U	9000	5650	3400	
	1200	S	3000	3000	3000	1860
		U	9000	5980	3840	2690
	900	S	3000	3000	3000	2330
		U	9000	7130	4750	3410
	Max Kg		160	160	95	60
	Max Kg					40
$I_{xx} = 853 \times 10^3 \text{ mm}^4$ $I_{yy} = 122 \times 10^3 \text{ mm}^4$	Transom length		1200	1500	1800	2100
						2400

ECO225 + ECO203 Transom

ECO225 + ECO203 TRANSOM	Transom Centres	Maximum Design Loads (Pa)				
	2400	S	3000	3000	2410	
		U	9000	4818	2930	
	2100	S	3000	3000	2530	
		U	9000	5072	3080	
	1800	S	3000	3000	2670	
		U	9000	5339	3250	
	1500	S	3000	3000	2770	1600
		U	9000	5620	3380	2300
	1200	S	3000	3000	3000	1850
		U	9000	5950	3810	2680
	900	S	3000	3000	3000	2320
		U	9000	7090	4730	3390
	Max Kg		180	180	150	95
	Max Kg					65
$I_{xx} = 848 \times 10^3 \text{ mm}^4$ $I_{yy} = 194 \times 10^3 \text{ mm}^4$	Transom length		1200	1500	1800	2100
						2400

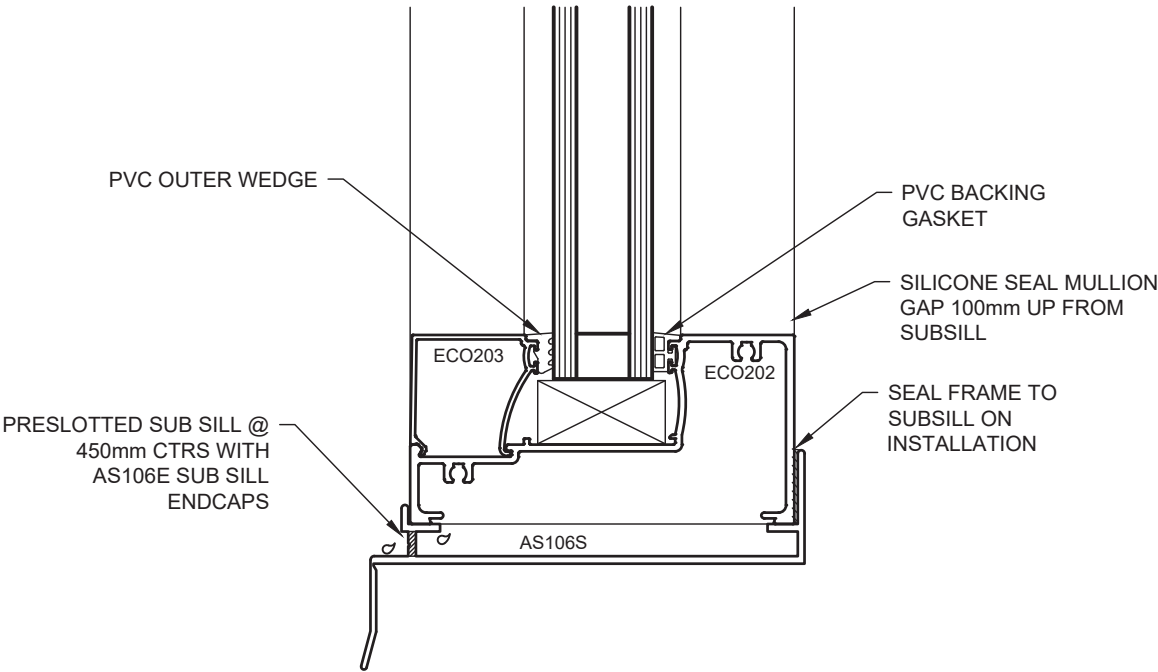
Tables are based on theoretical section properties

Maximum glass weights have been determined to limit deflection to 5mm,
using setting block locations at 1/8 points.

4. Test Summary

AS2047 - Fixed/ Fixed

TEST REPORT:	AS08-019
SYSTEM CONFIGURATION	ecoFRAMEplus 101.6mm FRAMING F/F
TEST SAMPLE SIZE	2100 H x 2400 W
SERVICEABILITY LOAD	+/- 2000 Pa
ULTIMATE LOAD	+/- 3000 Pa
WATER PENETRATION	1000 Pa
AIR INFILTRATION @ 75Pa	+ 0.08 L/s/ms ² - 0.08 L/s/ms ²



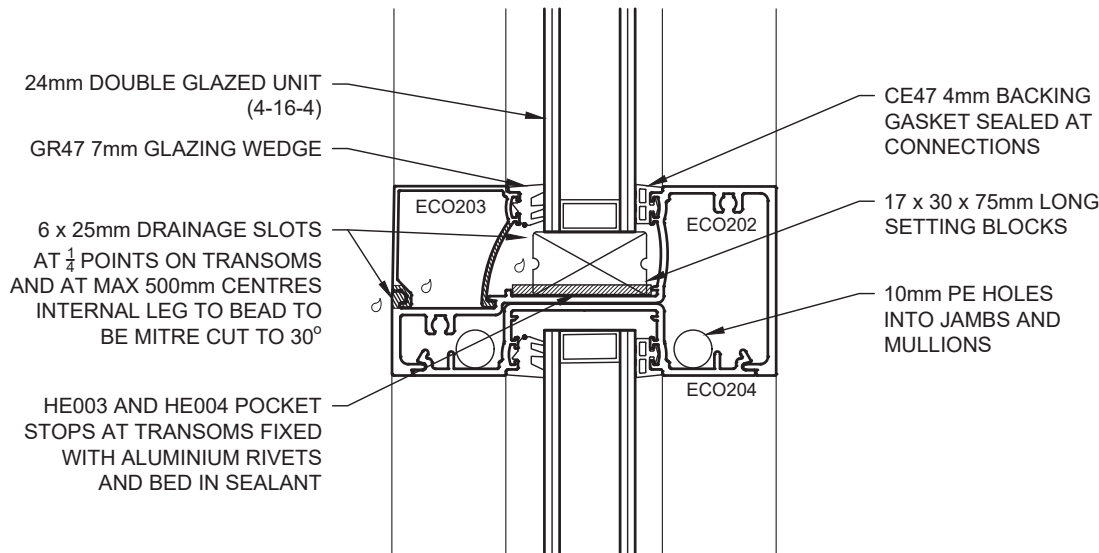
DISCLAIMER:

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

4. Test Summary

AS2047 - Fixed Fixed/ Fixed

TEST REPORT:	OT23-173
SYSTEM CONFIGURATION	ecoFRAMEplus 101.6mm FRAMING F F/F
TEST SAMPLE SIZE	2432 H x 2432 W
SERVICEABILITY LOAD	+/- 1602 Pa
ULTIMATE LOAD	+/- 5501 Pa
WATER PENETRATION	480 Pa
AIR INFILTRATION @ 75Pa	+ 0.03 L/s/ms ² - 0.09 L/s/ms ²



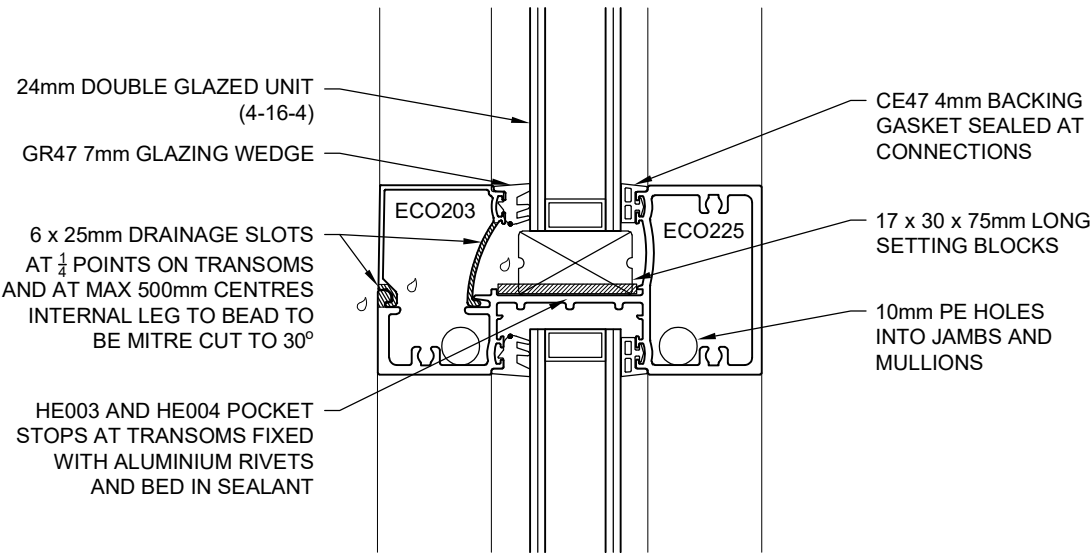
DISCLAIMER:

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

4. Test Summary

AS2047 - Fixed/Fixed/Fixed Fixed

TEST REPORT:	OT24-219
SYSTEM CONFIGURATION	ecoFRAMEplus 101.6mm FRAMING F/F/FF ECO214/ECO215 Mullions, ECO225/ECO203 Transom, AS3315 Sub Sill
TEST SAMPLE SIZE	3215 H x 4583 W
SERVICEABILITY LOAD	+/- 804 Pa
ULTIMATE LOAD	+/- 2001 Pa
WATER PENETRATION	240 Pa
AIR INFILTRATION @ 75Pa	+ 0.04 L/s/ms ² - 0.03 L/s/ms ²



DISCLAIMER:

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

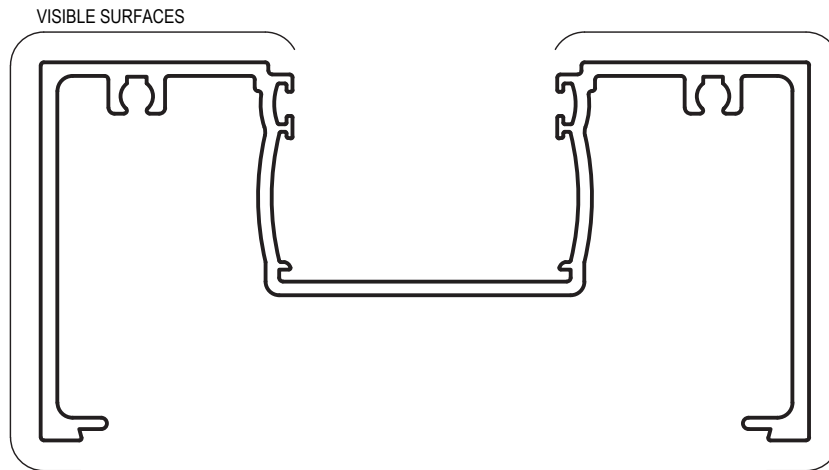
4. Test Summary

Acoustic - AS/NZS ISO 717.1

TEST REPORT	PRODUCT DESCRIPTION	SIZE	GLASS	Rw
4704-8	ecoFRAMEplus 101.6mm FIXED/ FIXED	2.1m (H) x 1.8m (W)	6.38mm LAMINATE	32
TL636-10-1	ecoFRAMEplus 101.6mm FIXED/ FIXED	1.2m (H) x 1.8m (W)	10.38 LAMINATE/ 12 ARG/ 6.38mm LAMINATE	40
TL636-16-1	ecoFRAMEplus 101.6mm with SWAN EVO HINGED DOOR / FIXED	2.1m (H) x 1.8m (W)	6.38 LAMINATE/ 12 ARG/ 6.38mm LAMINATE	38
TL636-15-1	ecoFRAMEplus 101.6mm with SWAN EVO HINGED DOOR / FIXED	2.1m (H) x 1.8m (W)	6.38 LAMINATE/ 12 ARG/ 6.5mm VLAM HUSH	37

BAL40 - AS 1530.8.1-2007

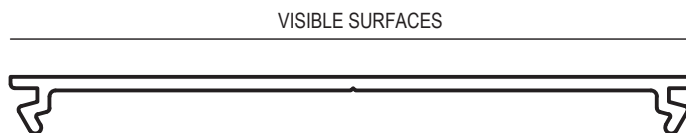
TEST REPORT	PRODUCT DESCRIPTION	SIZE	GLASS	SEALS	RESULT
FRT210420.R2	ecoFRAMEplus 101.6mm FIXED	2.6m (H) x 2.6m (W)	6/12/6mm CLEAR TOUGHENED	GR48FR and CE37FR	BALAA40



ECO201
101.6mm DG FRAME

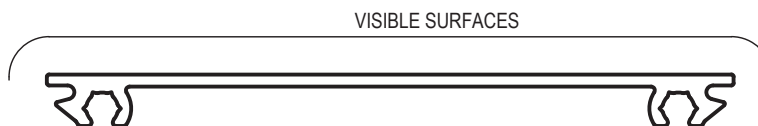
Mass. 1.592 Kg/m
Anod. Per. 602
Paint Per. 180

$I_{xx} = 858.76 \times 10^3 \text{ mm}^4$
 $I_{yy} = 142.04 \times 10^3 \text{ mm}^4$



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



ECO204
101.6mm DG POCKET INFILL

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

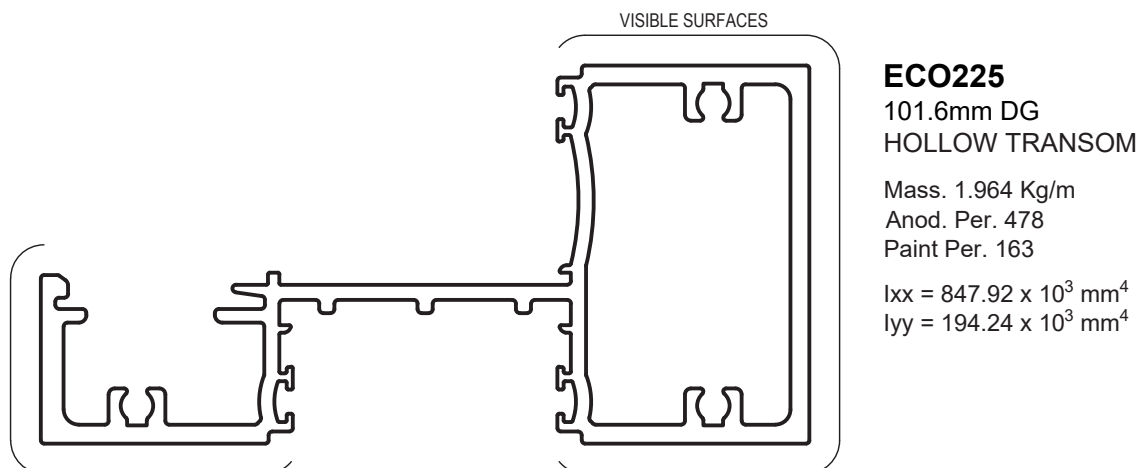
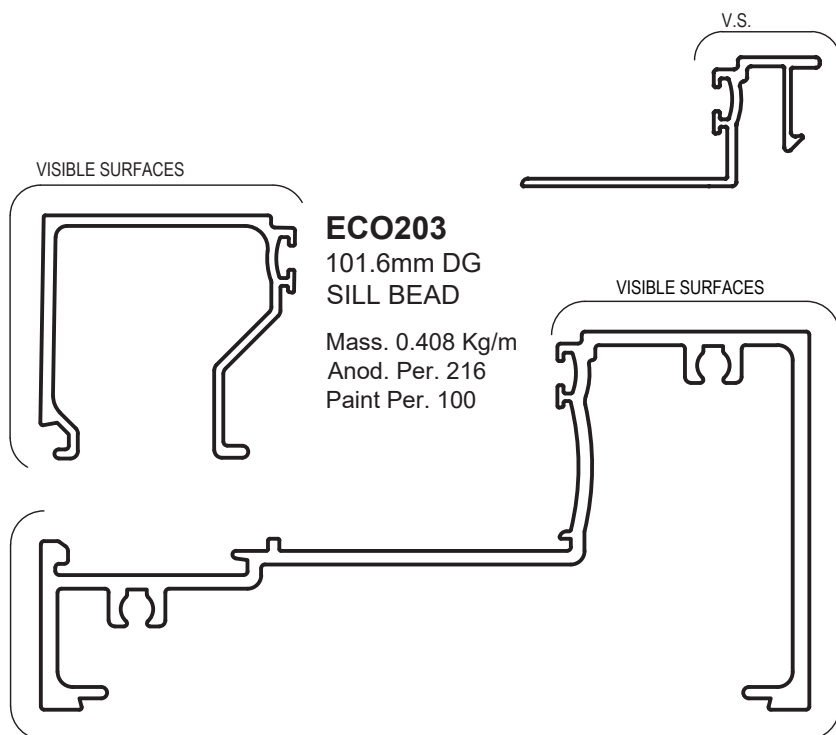
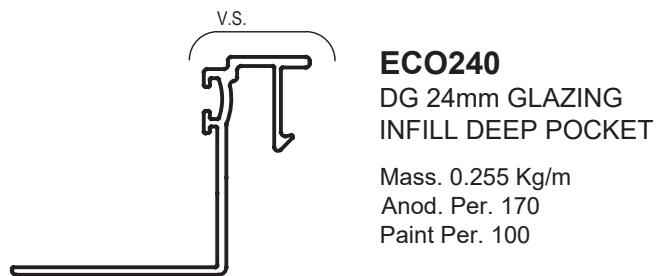
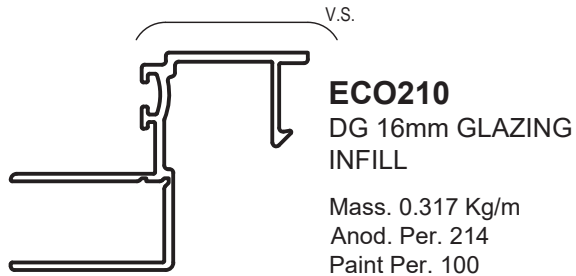
$I_{xx} = 193.60 \times 10^3 \text{ mm}^4$
 $I_{yy} = 14.20 \times 10^3 \text{ mm}^4$

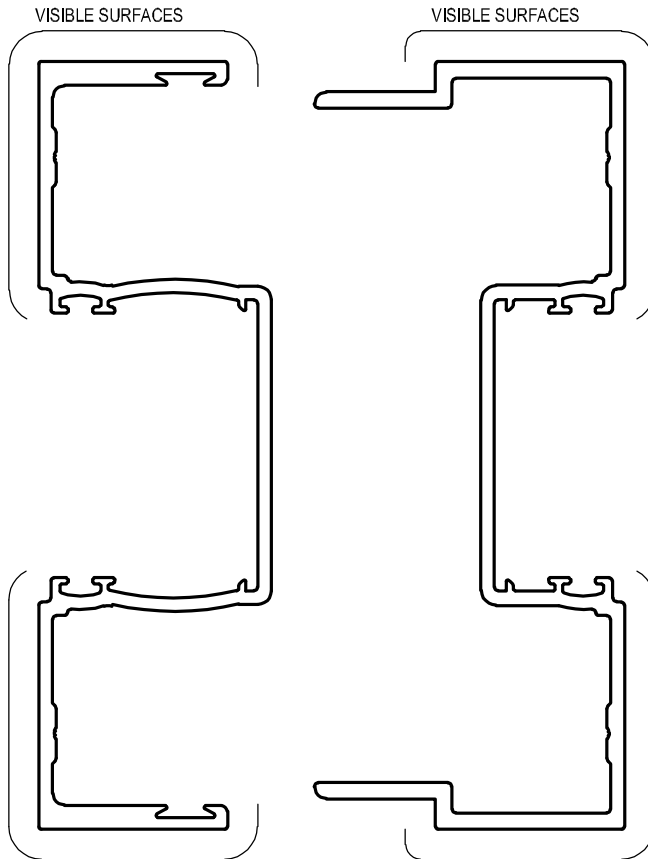


ECO218
EZI REVEAL ADAPTOR

Mass. 0.806 Kg/m
Anod. Per. 377
Paint Per. No Visible Surface

5. Extrusions

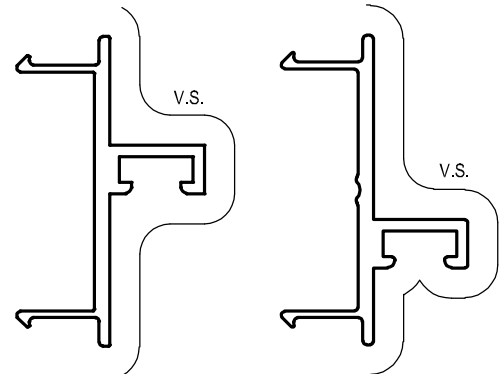




ECO207

101.6mm DG
45mm DOOR STOP

Mass. 0.367 Kg/m
Anod. Per. 169
Paint Per. 100



ECO209

101.6mm DG
35mm DOOR STOP

Mass. 0.366 Kg/m
Anod. Per. 168
Paint Per. 100

ECO212

101.6mm DG
MULLION DEEP POCKET

Mass. 1.189 Kg/m
Anod. Per. 455
Paint Per. 115

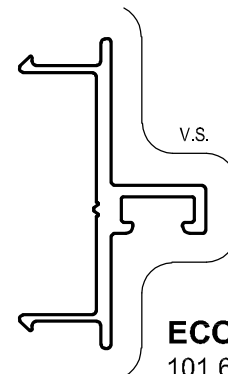
$I_{xx} = 531.10 \times 10^3 \text{ mm}^4$

ECO213

101.6mm DG
MULLION SHALLOW
POCKET

Mass. 1.234 Kg/m
Anod. Per. 471
Paint Per. 118

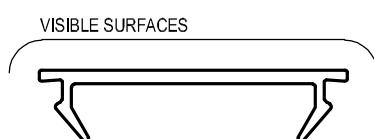
$I_{xx} = 633.86 \times 10^3 \text{ mm}^4$



ECO206

101.6mm DG
40mm DOOR STOP

Mass. 0.366 Kg/m
Anod. Per. 168
Paint Per. 100

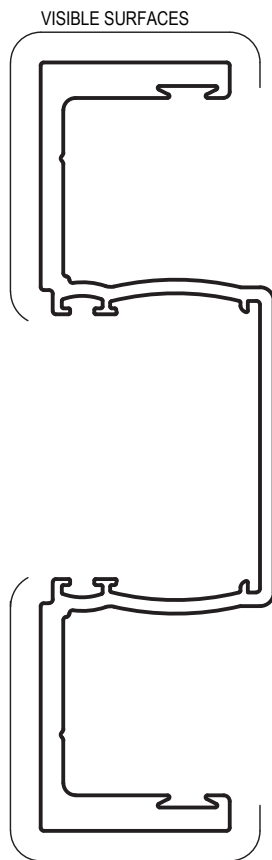


ECO208R

FLUSH POCKET INFILL DG

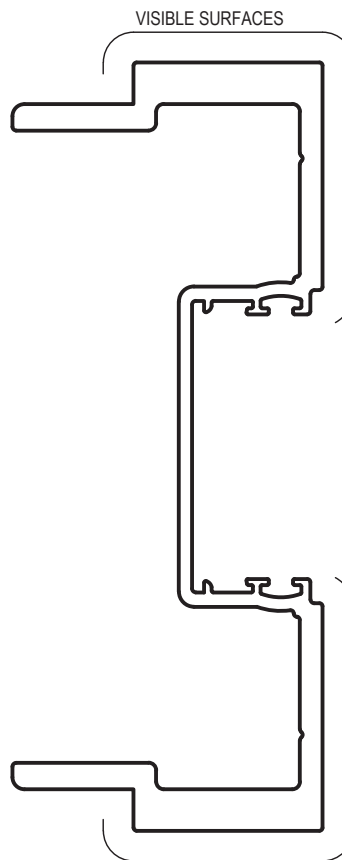
Mass. 0.253 Kg/m
Anod. Per. 119
Paint Per. 100

5. Extrusions



ECO214
101.6mm DG
HD MULLION DEEP
POCKET

Mass. 1.511 Kg/m
Anod. Per. 450
Paint Per. 118
 $I_{xx} = 745.03 \times 10^3 \text{ mm}^4$

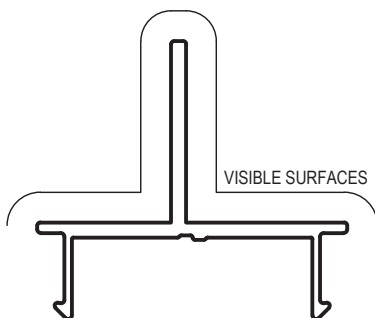


ECO215
101.6mm DG HD
MULLION SHALLOW
POCKET

Mass. 1.900 Kg/m
Anod. Per. 462
Paint Per. 121
 $I_{xx} = 1093.83 \times 10^3 \text{ mm}^4$

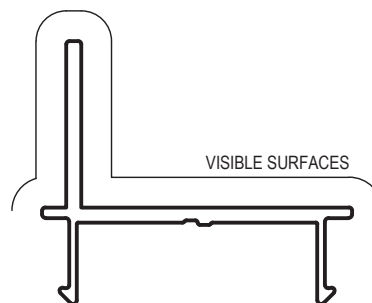
ECO222
50mm SASH
ADAPTOR

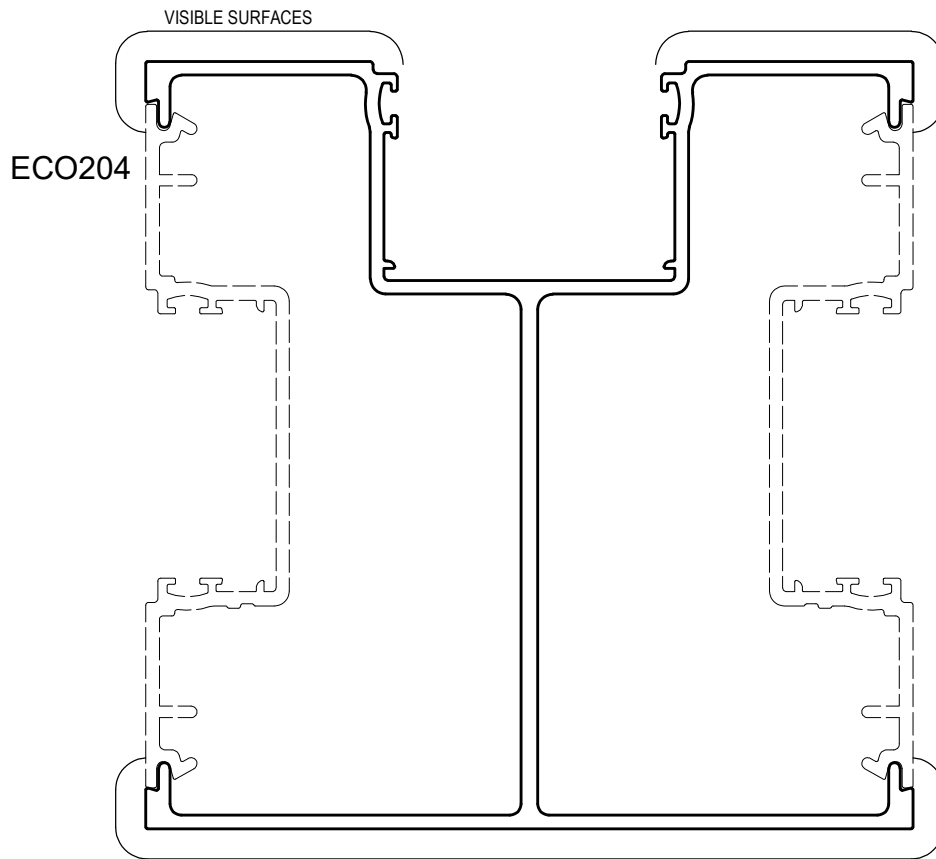
Mass. 0.406 Kg/m
Anod. Per. 178
Paint Per. 100



ECO223
35mm SASH
ADAPTOR

Mass. 0.395 Kg/m
Anod. Per. 174
Paint Per. 100





ECO229

101.6mm CORNER POST

Mass. 1.908 Kg/m

Anod. Per. 735

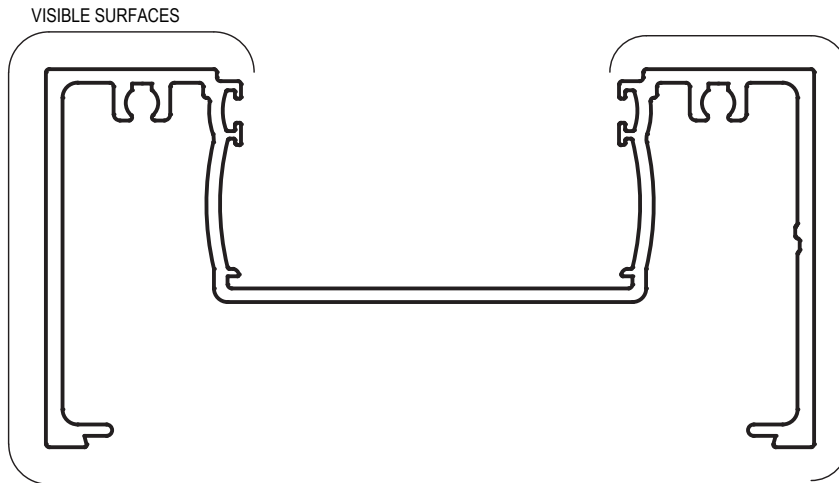
Paint Per. 187

$I_{xx} = 1161.16 \times 10^3 \text{ mm}^4$

5. Extrusions

50mm Pocket Extrusions

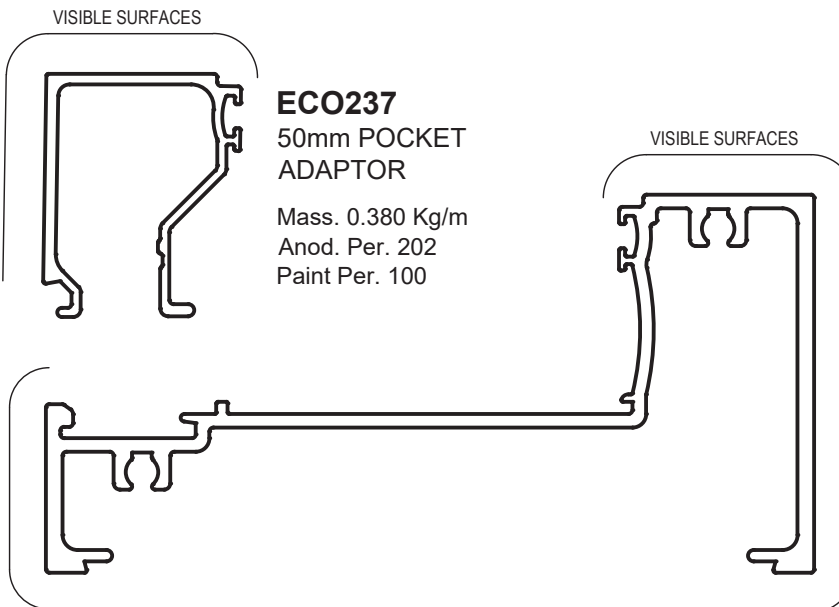
* No mullions or transoms. Silicone glaze only



ECO235

101.6mm FRAME
50mm POCKET

Mass. 1.592 Kg/m
Anod. Per. 602
Paint Per. 148



ECO237

50mm POCKET
ADAPTOR

Mass. 0.380 Kg/m
Anod. Per. 202
Paint Per. 100

ECO236

101.6mm SILL 50mm
POCKET

Mass. 1.297 Kg/m
Anod. Per. 489
Paint Per. 100



ECO238

POCKET FILLER 50mm

Mass. 0.739 Kg/m
Anod. Per. 320
Paint Per. 100

6. Hardware & Components

Glazing Wedges

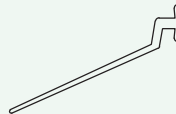
IMAGE	TO SUIT GAP	MATERIAL	PART #	DESCRIPTION
	3mm	PVC	1313055	GR43 GLAZING WEDGE (BROWN) (3mm GAP) PVC x 200m ROLL
		S/PRENE	1313063	GR43S GLAZING WEDGE (BROWN) (3mm GAP) S/PRENE x 200m ROLL
	4mm	PVC	1313056	GR44 GLAZING WEDGE (WHITE) (4mm GAP) PVC x 200m ROLL
		S/PRENE	1313064	GR44S GLAZING WEDGE (WHITE) (4mm GAP) S/PRENE x 200m ROLL
	5mm	PVC	1313057	GR45 GLAZING WEDGE (BLUE) (5mm GAP) PVC x 150m ROLL
		S/PRENE	1313065	GR45S GLAZING WEDGE (BLUE) (5mm GAP) S/PRENE x 150m ROLL
	6mm	PVC	1313058	GR46 GLAZING WEDGE (YELLOW) (6mm GAP) PVC x 150m ROLL
		S/PRENE	1313066	GR46S GLAZING WEDGE (YELLOW) (6mm GAP) S/PRENE x 150m ROLL
	7mm	PVC	1313059	GR47 GLAZING WEDGE (RED) (7mm GAP) PVC x 150m ROLL
		S/PRENE	1313062	GR47S GLAZING WEDGE (RED) (7mm GAP) S/PRENE x 150m ROLL
	8mm	PVC	1313060	GR48 GLAZING WEDGE (ORANGE) (8mm GAP) PVC x 150m ROLL
		S/PRENE	1313067	GR48S GLAZING WEDGE (ORANGE) (8mm GAP) S/PRENE x 150m ROLL
	9mm	PVC	1313076	GR50 GLAZING WEDGE (GREEN) (9mm GAP) PVC x 100m ROLL

6. Hardware & Components

Backing Gaskets

IMAGE	TO SUIT GAP	MATERIAL	PART #	DESCRIPTION
	2mm	PVC	1313052	GR36 BACKING GASKET - PUSH IN (2mm GAP) PVC x 200m ROLL
		S/PRENE	1313053	GR36S BACKING GASKET - PUSH IN (2mm GAP) S/PRENE x 200m ROLL
	2mm	PVC	1313079	CE36 CO-EXT BACKING GASKET (2mm GAP) PVC x 100m ROLL
		S/PRENE	1313080	CE36S CO-EXT BACKING GASKET (2mm GAP) S/PRENE x 100m ROLL
	4mm	PVC	1313054	GR37 BACKING GASKET - PUSH IN (4mm GAP) PVC x 175m ROLL
		S/PRENE	1313069	GR37S BACKING GASKET - PUSH IN (4mm GAP) S/PRENE x 175m ROLL
	4mm	PVC	1313081	CE37 CO-EXT BACKING GASKET (4mm GAP) PVC x 100m ROLL
		S/PRENE	1313082	CE37S CO-EXT BACKING GASKET (4mm GAP) S/PRENE x 100m ROLL
	6mm	PVC	1313074	GR49 BACKING GASKET - PUSH IN (6mm GAP) PVC x 100m ROLL
		S/PRENE	1313075	GR49S BACKING GASKET - PUSH IN (6mm GAP) S/PRENE x 100m ROLL
	6mm	PVC	1313083	CE49 CO-EXT BACKING GASKET (6mm GAP) PVC x 100m ROLL
		S/PRENE	1313084	CE49S CO-EXT BACKING GASKET (6mm GAP) S/PRENE x 100m ROLL

Seals

IMAGE	PART #	FINISH	DESCRIPTION
	1376402	BLACK (034)	DB1 DOOR STOP RUBBER x 100m
	1376403	GREY (036)	DB1 DOOR STOP RUBBER GREY x 200m
	1376452	BLACK (034)	MS1B MULLION RUBBER x 100m
	1823413	BLACK (034)	21mm SILL FLAP x 250m ROLL

Fasteners

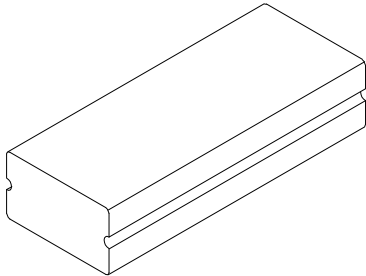
SCREWS			
PART #	HEAD	DESCRIPTION	LOCATION
1382644	SQUARE #2	10g x 1 (25mm) 304SS SQ #2 PAN S/TAP SCREW x 1000	MAIN FRAME
1382054	PHILLIPS #2	10g x 1 (25mm) SS PHIL PAN S/TAP SCREW x 500	FRAME

Frame Joint Gaskets

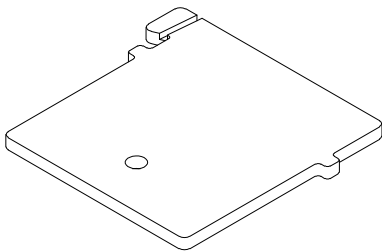
PART #	DESCRIPTION	FINISH
1385509	FJG50 FRAME JOINT GASKET PVC FOAM TAPE 50 x 1.6mm 45.7m	BLACK (034)
		GREY (036)

6. Hardware & Components

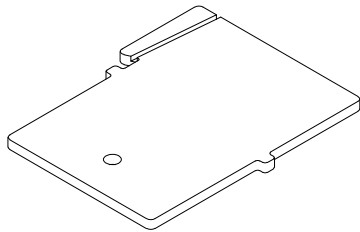
Accessories



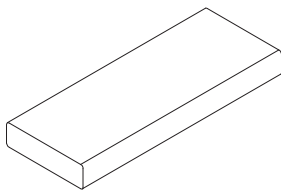
SETTING BLOCK 17 x 30 x 75mm BAG OF 50	
PART	1376734
FINISH	BLACK (034)
QTY	BAG



HE004 POCKET STOP x 50 (FOR ECO201, 212 & 214)	
PART	1378197
FINISH	NOT SPECIFIED (099)
QTY	BAG



HE003 POCKET STOP x 50 (FOR ECO204, 213 & 215)	
PART	1378196
FINISH	NOT SPECIFIED (099)
QTY	BAG



SETTING BLOCK 8 x 29 x 75mm BAG OF 50	
PART	1376771
FINISH	BLACK (034)
QTY	BAG

6. Hardware & Components

Silicone



100% NEUTRAL CURE SILICONE

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



100% MATTE NEUTRAL CURE SILICONE

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



41 CLADDING SILICONE

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



WET AREA SILICONE

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



HYBRID PU ADHESIVE SEALANT

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



20 ACETIC CURE SILICONE

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



D60 SILICONE

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

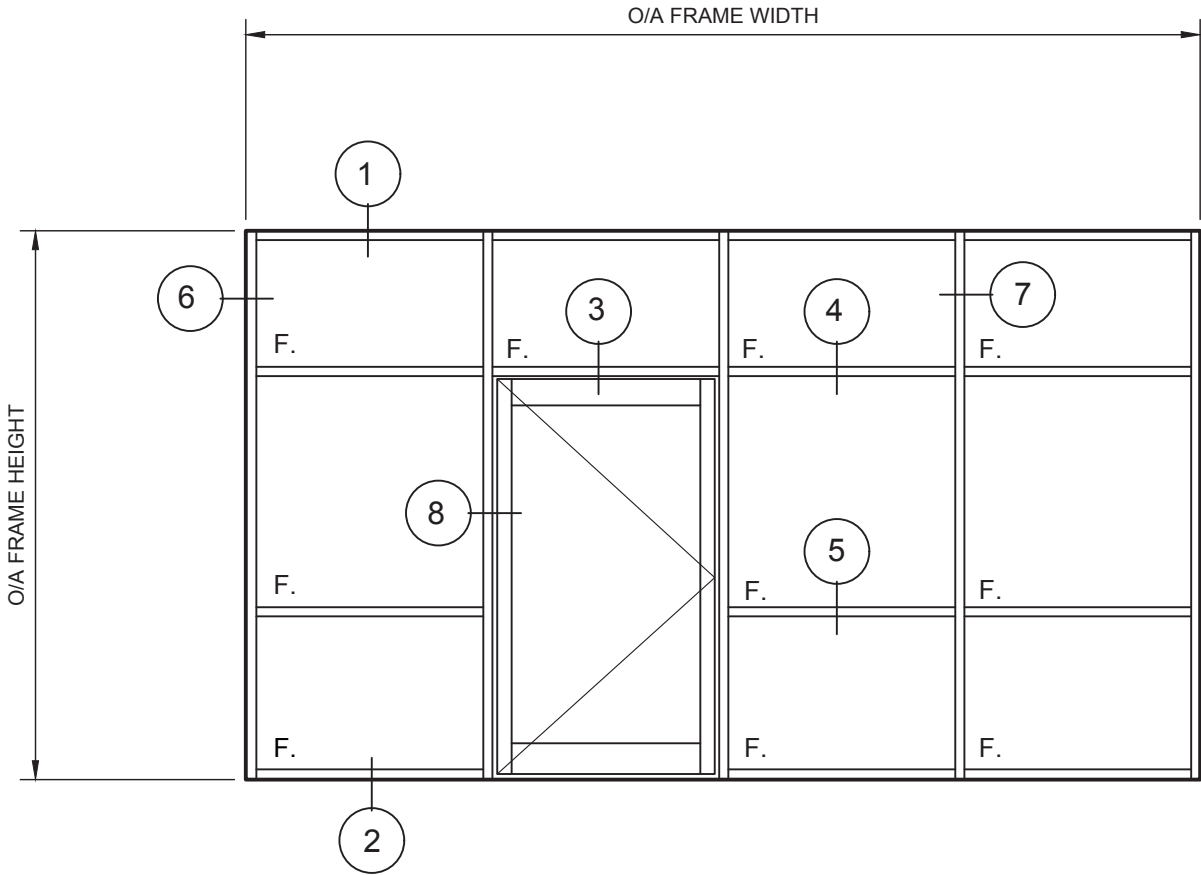
*FOR MORE INFORMATION ON SILICONES,
PLEASE REFER TO ALSPEC SILICONE BROCHURE.

6. Hardware & Components

Silicone Product Codes

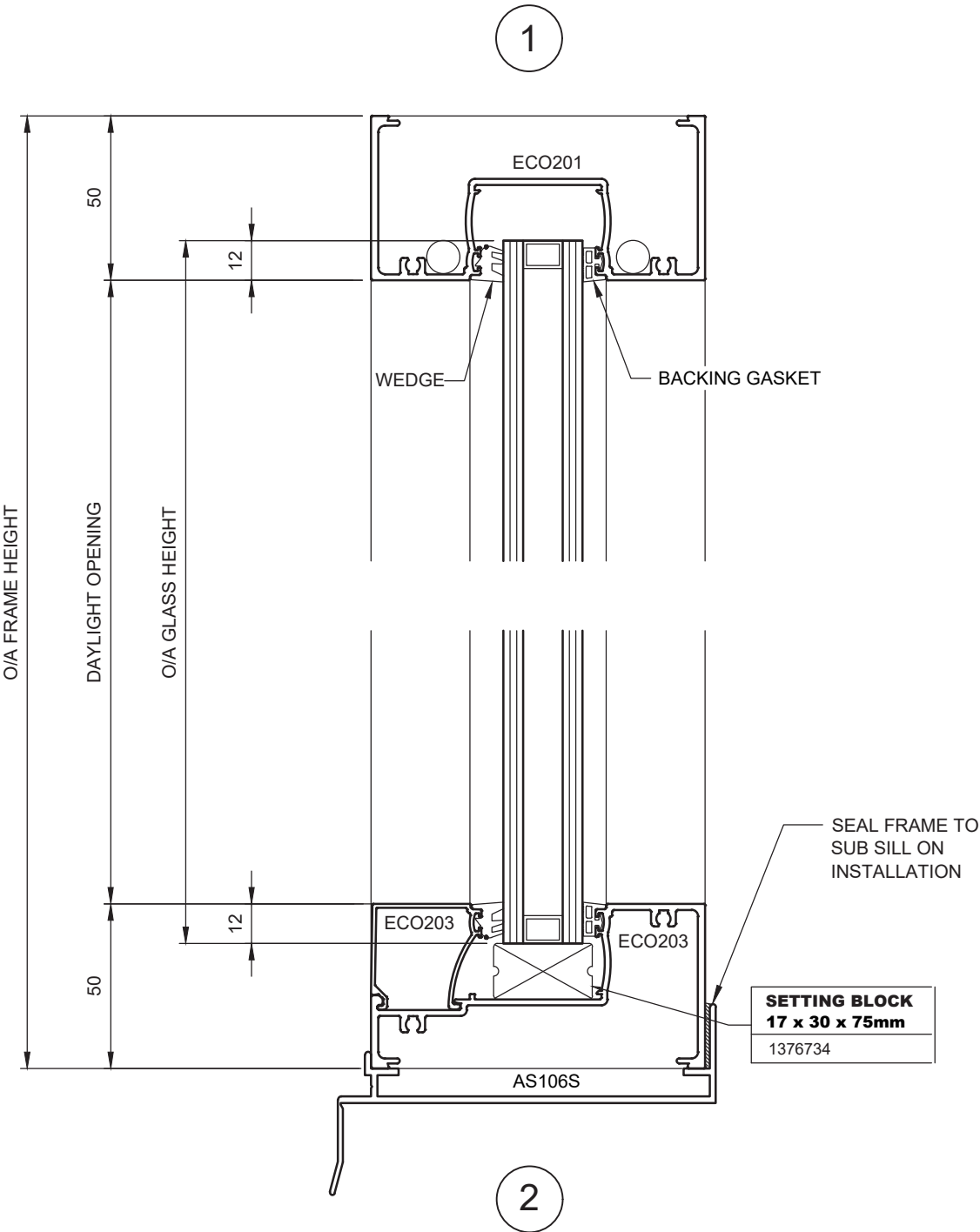
Product Category	Item No.	Alspec Part No.	Description	Finish	Pack
ALSPEC 100%	1	1386113	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	ALMOND IVORY	CARTRIDGE
	2	1386114	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	ALUMINIUM	CARTRIDGE
	3	1386105	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	BLACK	CARTRIDGE
	4	1386140	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	CAULFIELD GREEN	CARTRIDGE
	5	1386111	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	CLASSIC CREAM	CARTRIDGE
	6	1386108	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	LIGHT GREY	CARTRIDGE
	7	1386138	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	MONUMENT	CARTRIDGE
	8	1386112	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	OFF WHITE	CARTRIDGE
	9	1386141	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	STONE BEIGE	CARTRIDGE
	10	1386101	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	TRANSLUCENT	CARTRIDGE
	11	1386106	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	WHITE	CARTRIDGE
	12	1386143	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	WOODLAND GREY	CARTRIDGE
ALSPEC 100% MATT	13	1386103	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	BLACK MATT	CARTRIDGE
	14	1386107	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	LIGHT GREY MATT	CARTRIDGE
	15	1386144	ALSPEC 100% NEUTRAL CURE SILICONE x 300ml CAT	WHITE MATT	CARTRIDGE
ALSPEC 20	16	1386115	ALSPEC 20 ACETIC CURE SILICONE x 300ml CAT	TRANSLUCENT	CARTRIDGE
ALSPEC 41 CLADDING	17	1386159	ALSPEC 41 CLADDING SILICONE x 300ml CAT	BLACK MATT	CARTRIDGE
	18	1386117	ALSPEC 41 CLADDING SILICONE x 600ml SAU	BLACK MATT	SAUSAGE
	19	1386158	ALSPEC 41 CLADDING SILICONE x 300ml CAT	LIGHT GREY MATT	CARTRIDGE
	20	1386118	ALSPEC 41 CLADDING SILICONE x 600ml SAU	LIGHT GREY MATT	SAUSAGE
	21	1386157	ALSPEC 41 CLADDING SILICONE x 300ml CAT	WHITE MATT	CARTRIDGE
	22	1386145	ALSPEC 41 CLADDING SILICONE x 600ml SAU	WHITE MATT	SAUSAGE
ALSPEC D60	23	1386121	ALSPEC D60 SILICONE x 300ml CAT	BLACK	CARTRIDGE
	25	1386123	ALSPEC D60 SILICONE x 300ml CAT	GREY	CARTRIDGE
	26	1386120	ALSPEC D60 SILICONE x 300ml CAT	TRANSLUCENT	CARTRIDGE
	27	1386124	ALSPEC D60 SILICONE x 300ml CAT	WHITE	CARTRIDGE
ALSPEC HYBRID PU	28	1386127	ALSPEC HYBRID PU x 300ml CAT	BLACK	CARTRIDGE
	29	1386126	ALSPEC HYBRID PU x 600ml SAU	BLACK	SAUSAGE
	30	1386160	ALSPEC HYBRID PU x 300ml CAT	GREY	CARTRIDGE
	31	1386128	ALSPEC HYBRID PU x 600ml SAU	GREY	SAUSAGE
	32	1386130	ALSPEC HYBRID PU x 300ml CAT	WHITE	CARTRIDGE
	33	1386129	ALSPEC HYBRID PU x 600ml SAU	WHITE	SAUSAGE
ALSPEC WET AREA	34	1386137	ALSPEC WET AREA SILICONE x 300ml CAT	ALMOND IVORY	CARTRIDGE
	35	1386139	ALSPEC WET AREA SILICONE x 300ml CAT	BLACK	CARTRIDGE
	36	1386146	ALSPEC WET AREA SILICONE x 300ml CAT	BLUESTONE	CARTRIDGE
	37	1386147	ALSPEC WET AREA SILICONE x 300ml CAT	CHARCOAL	CARTRIDGE
	38	1386136	ALSPEC WET AREA SILICONE x 300ml CAT	LIGHT GREY	CARTRIDGE
	39	1386148	ALSPEC WET AREA SILICONE x 300ml CAT	MID GREY	CARTRIDGE
	40	1386149	ALSPEC WET AREA SILICONE x 300ml CAT	OFF WHITE	CARTRIDGE
	41	1386150	ALSPEC WET AREA SILICONE x 300ml CAT	PEWTER	CARTRIDGE
	42	1386151	ALSPEC WET AREA SILICONE x 300ml CAT	STONE BEIGE	CARTRIDGE
	43	1386154	ALSPEC WET AREA SILICONE x 300ml CAT	TAUPE	CARTRIDGE
	44	1386152	ALSPEC WET AREA SILICONE x 300ml CAT	TILE GREY	CARTRIDGE
	45	1386133	ALSPEC WET AREA SILICONE x 300ml CAT	TRANSLUCENT	CARTRIDGE
	46	1386153	ALSPEC WET AREA SILICONE x 300ml CAT	TRAVERTINE	CARTRIDGE
	47	1386134	ALSPEC WET AREA SILICONE x 300ml CAT	WHITE	CARTRIDGE

7. Typical Elevation



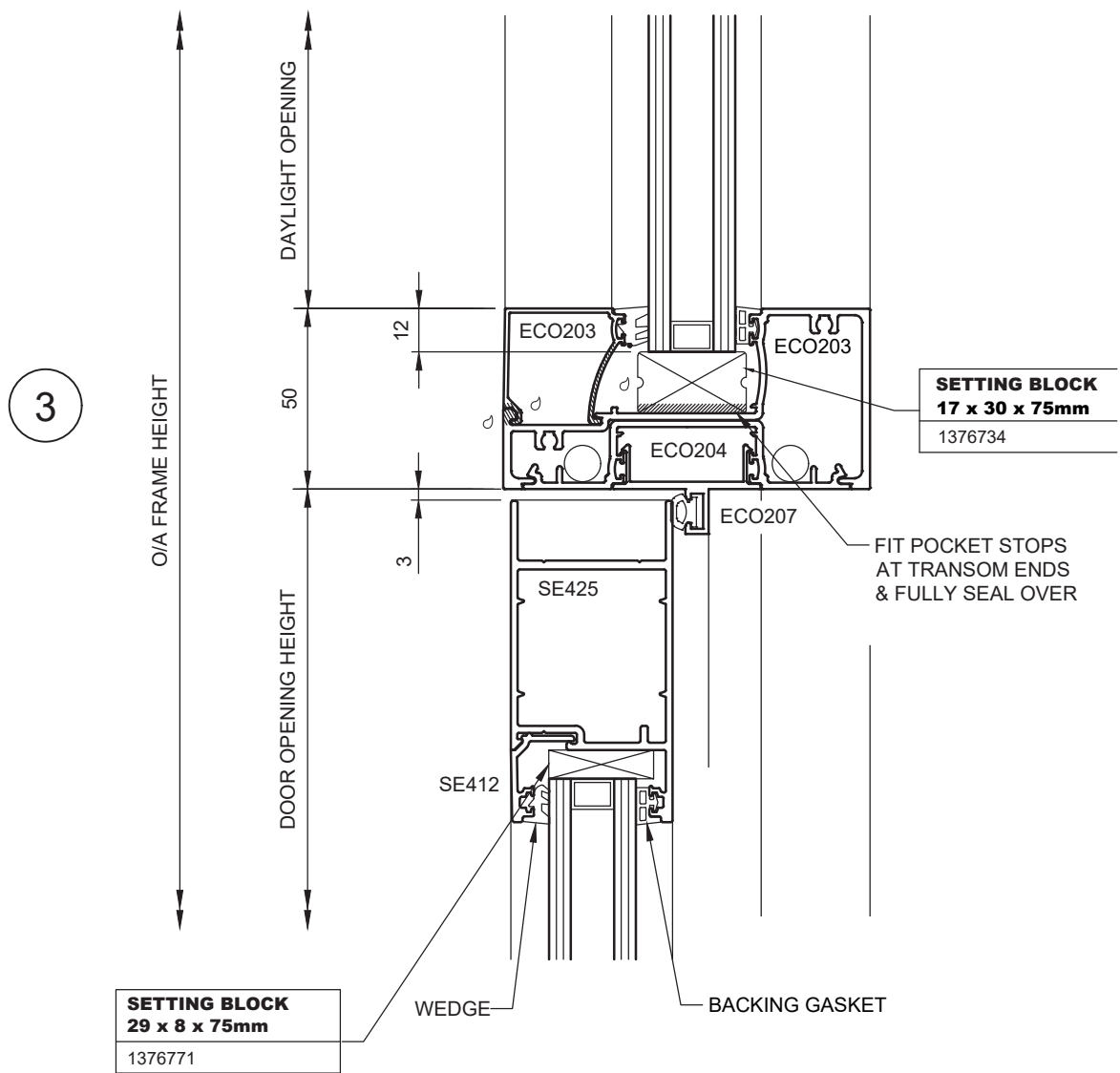
8. Typical Details

Typical Head and Sill Details



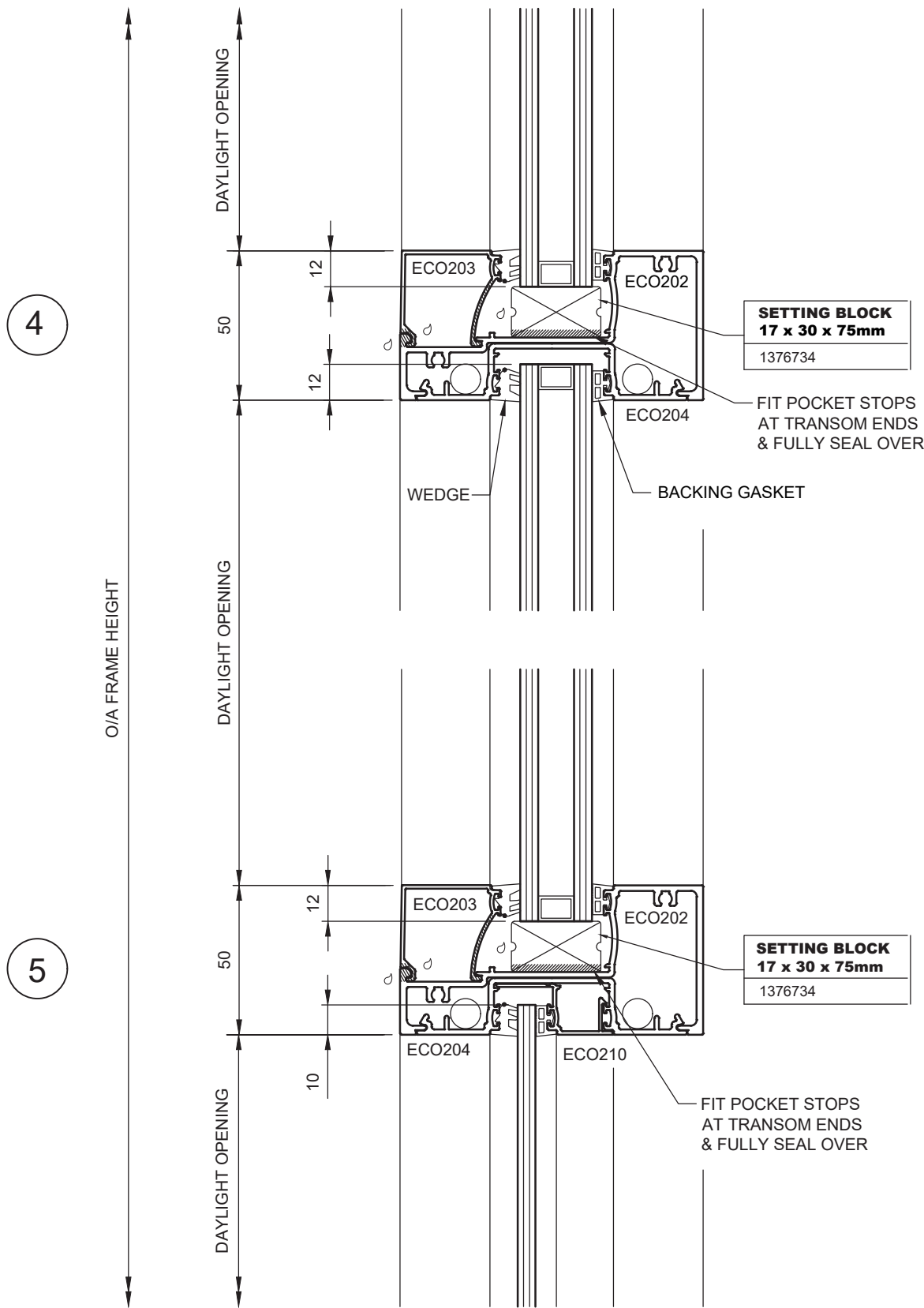
8. Typical Details

Typical Door Head / Transom Details



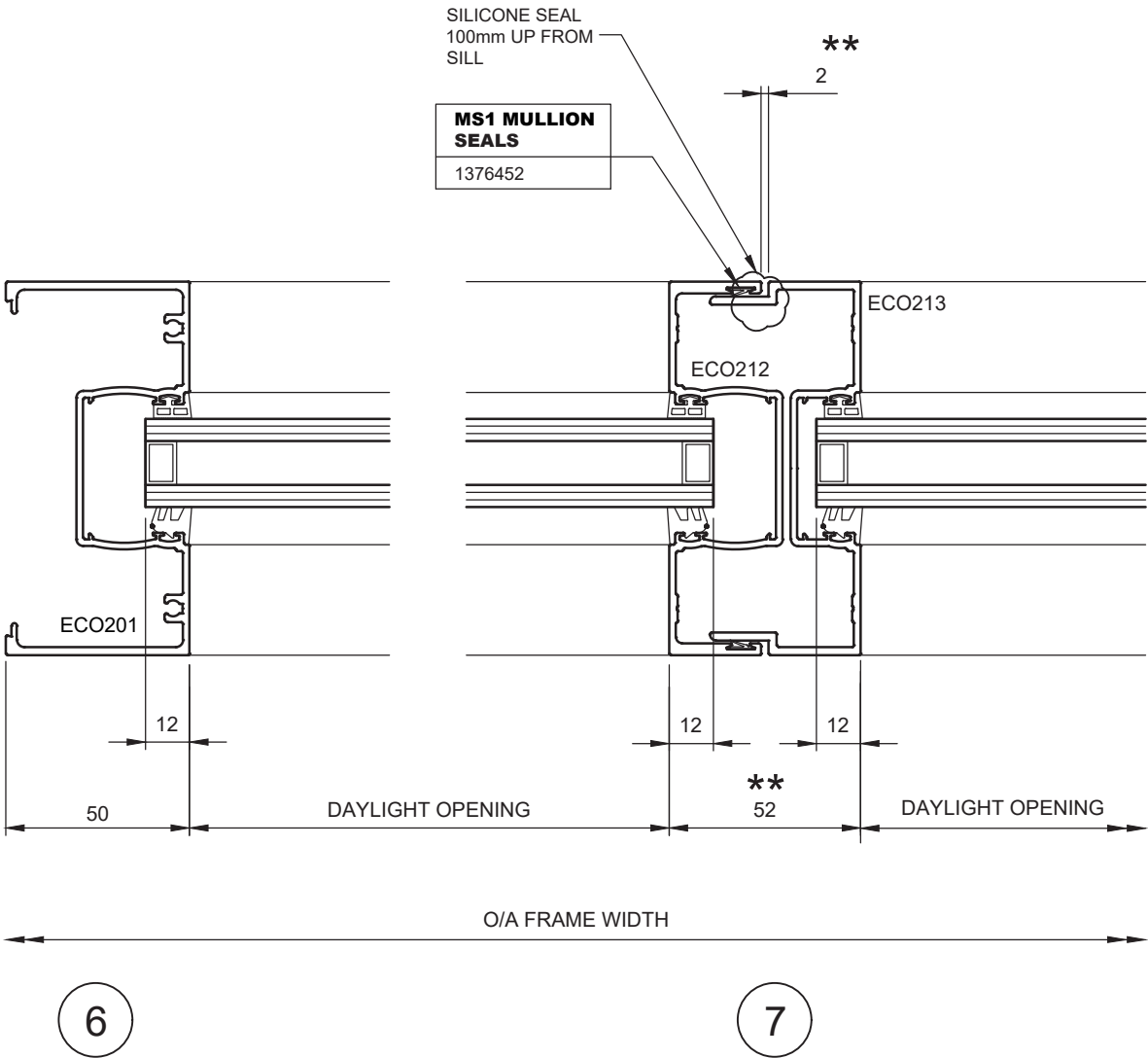
8. Typical Details

Typical Transom Details



8. Typical Details

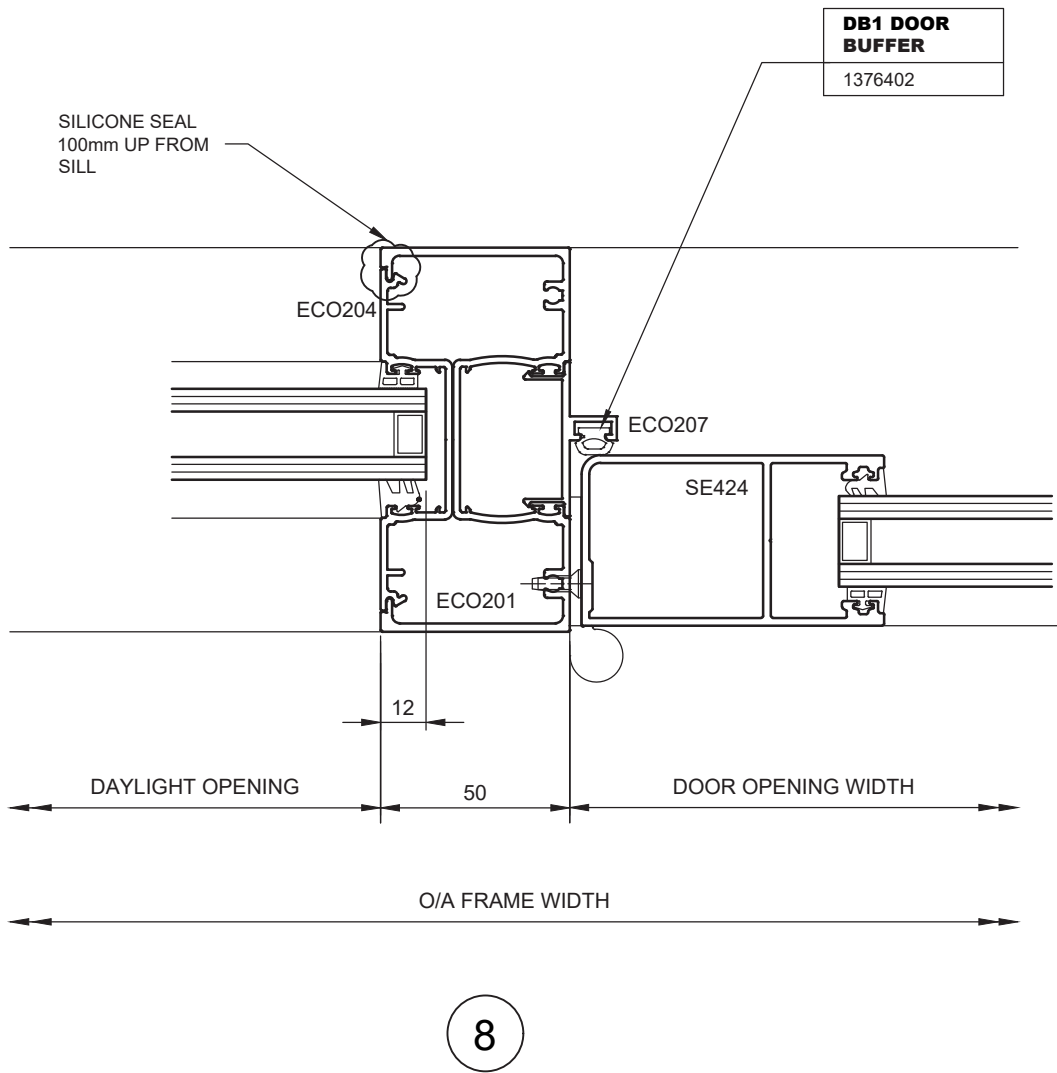
Typical Jamb and Mullion Details



** NOMINAL DIMENSIONS ONLY. MAY VARY DUE TO PROJECT REQUIREMENTS

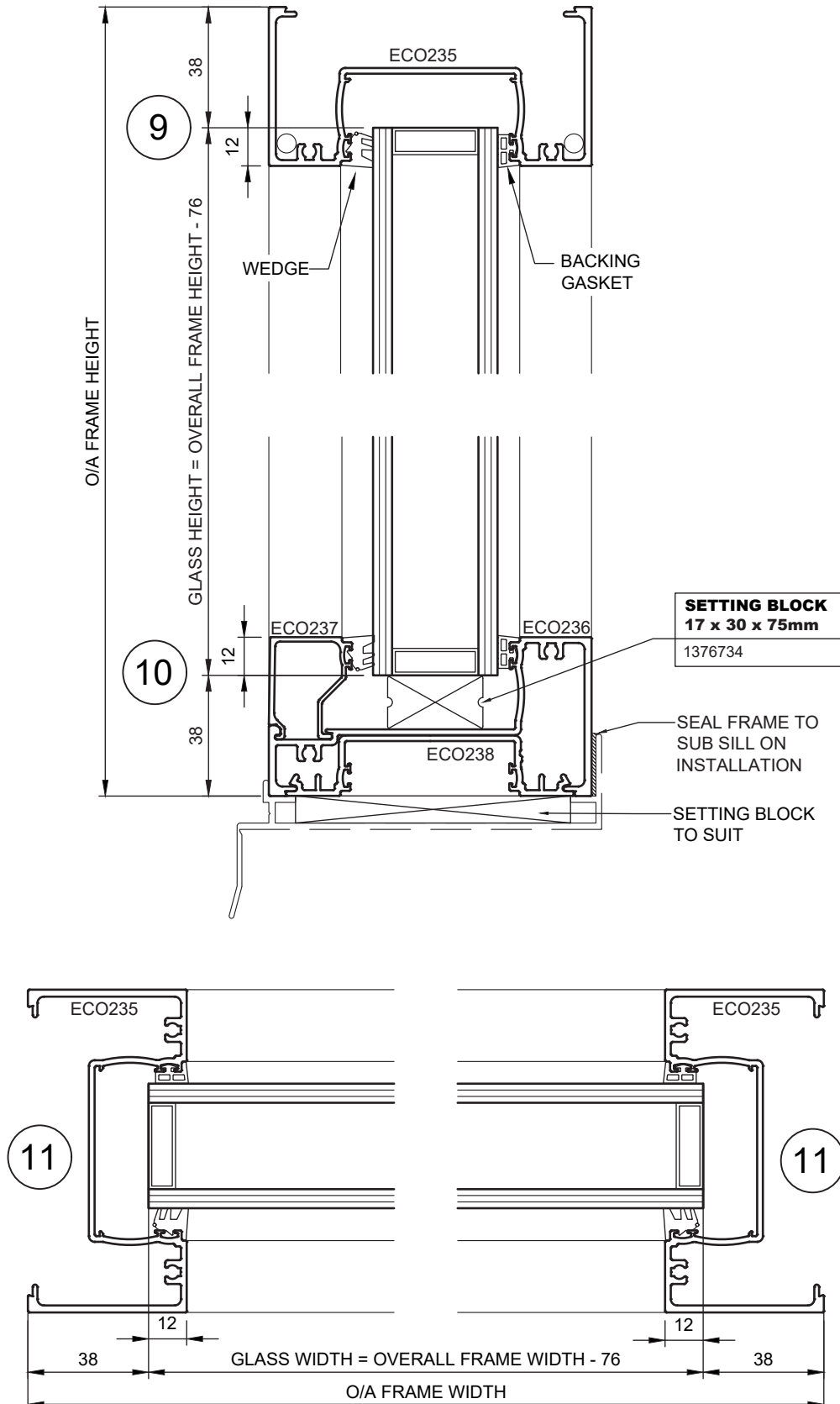
8. Typical Details

Typical Door Jamb Detail - Fixed/ Hinged

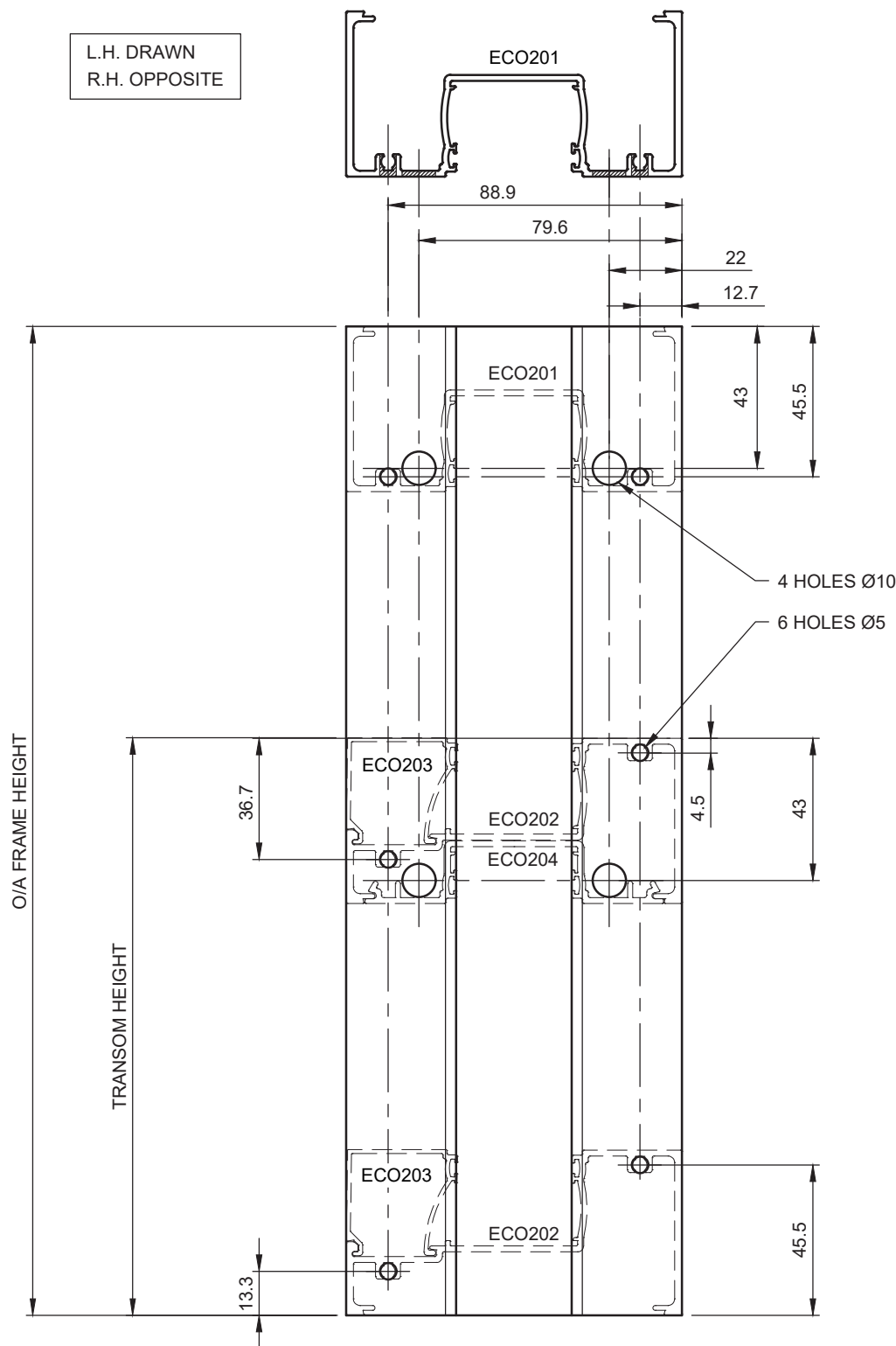


8. Typical Details

Typical Head, Sill and Jamb - 50mm Pocket Frame

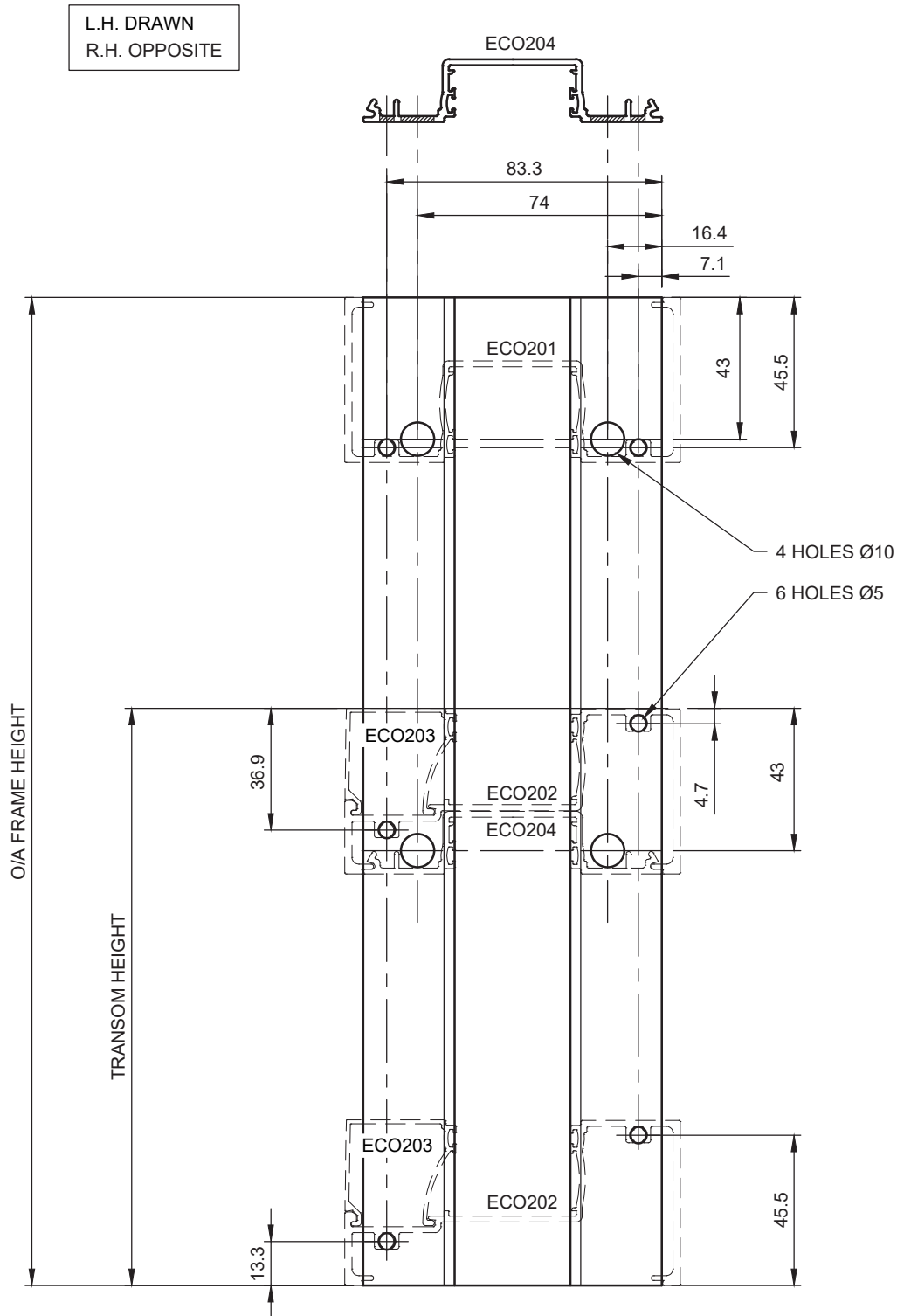


Frame Preparation - Jamb

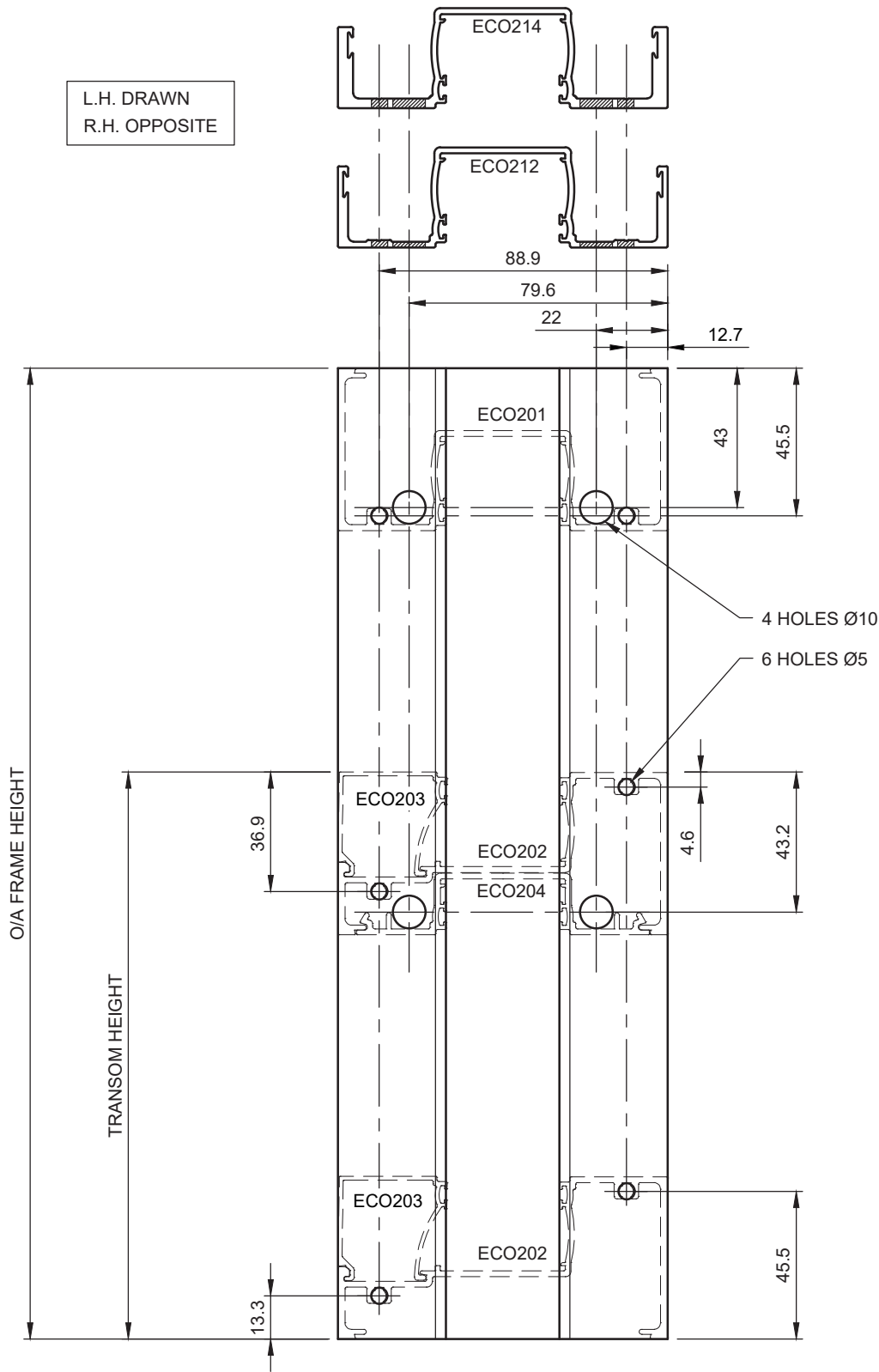


10. Manufacturing Details

Frame Preparation - Glazing Adaptor

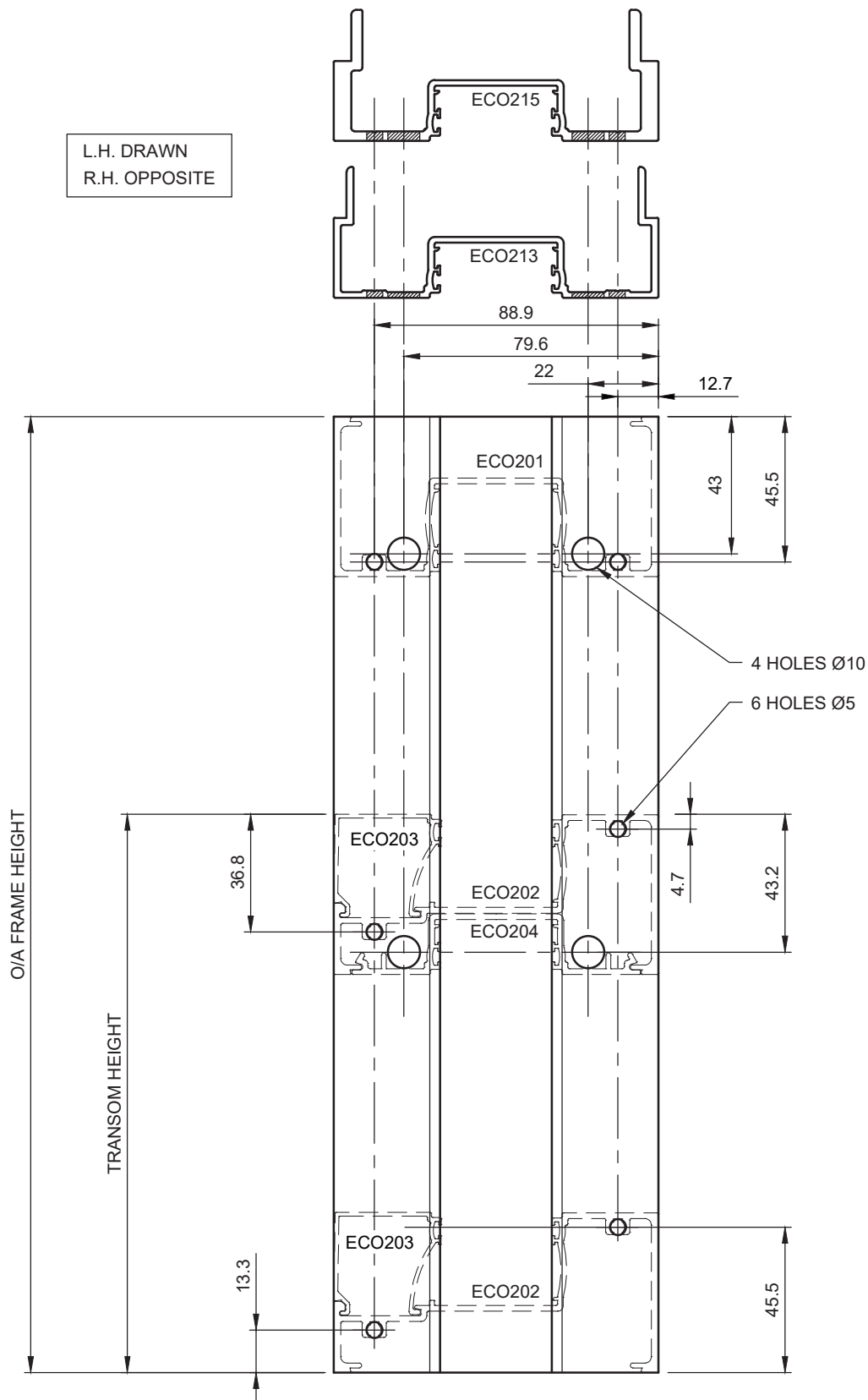


Frame Preparation - Deep Pocket Mullions

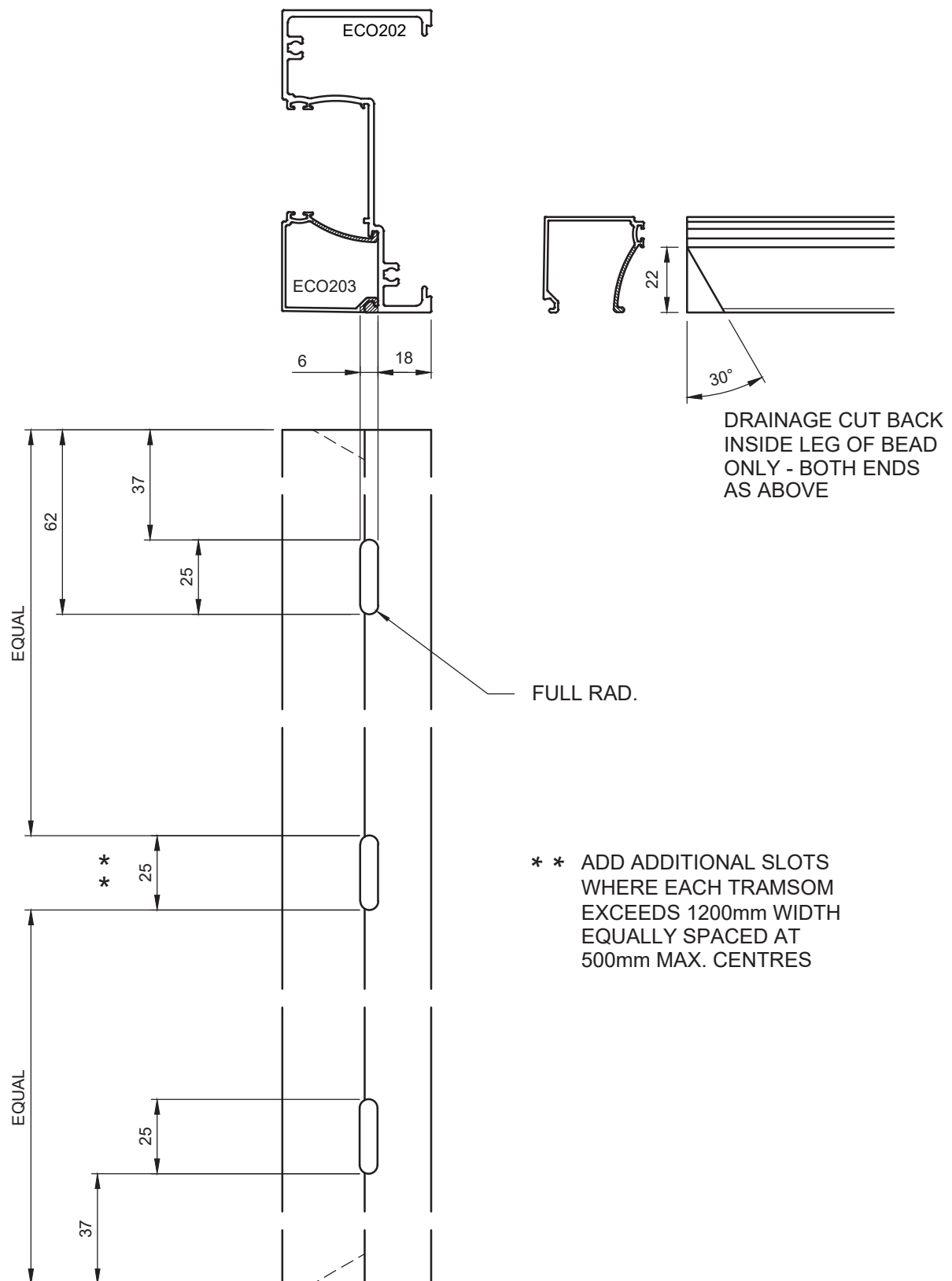


10. Manufacturing Details

Frame Preparation - Shallow Pocket Mullions

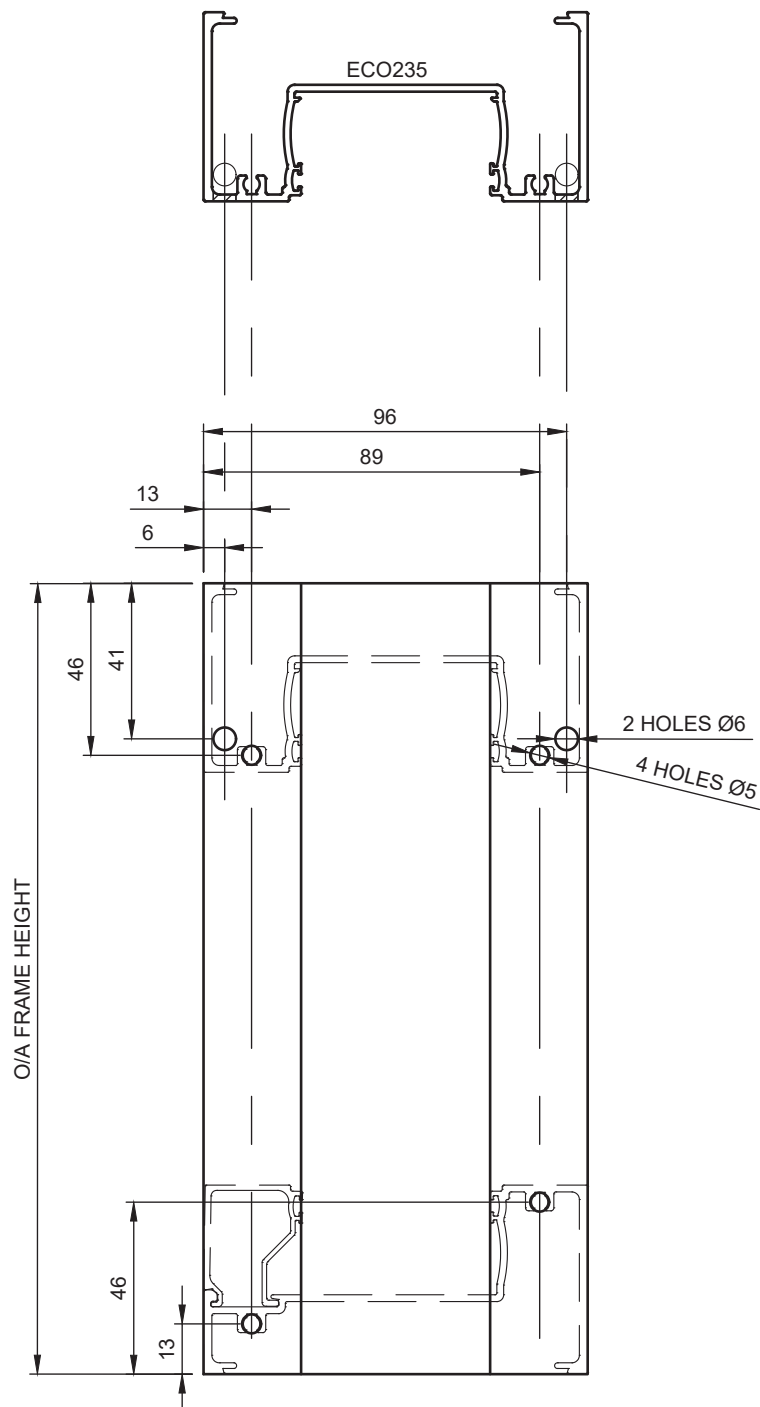


Frame Preparation - Transom Drainage



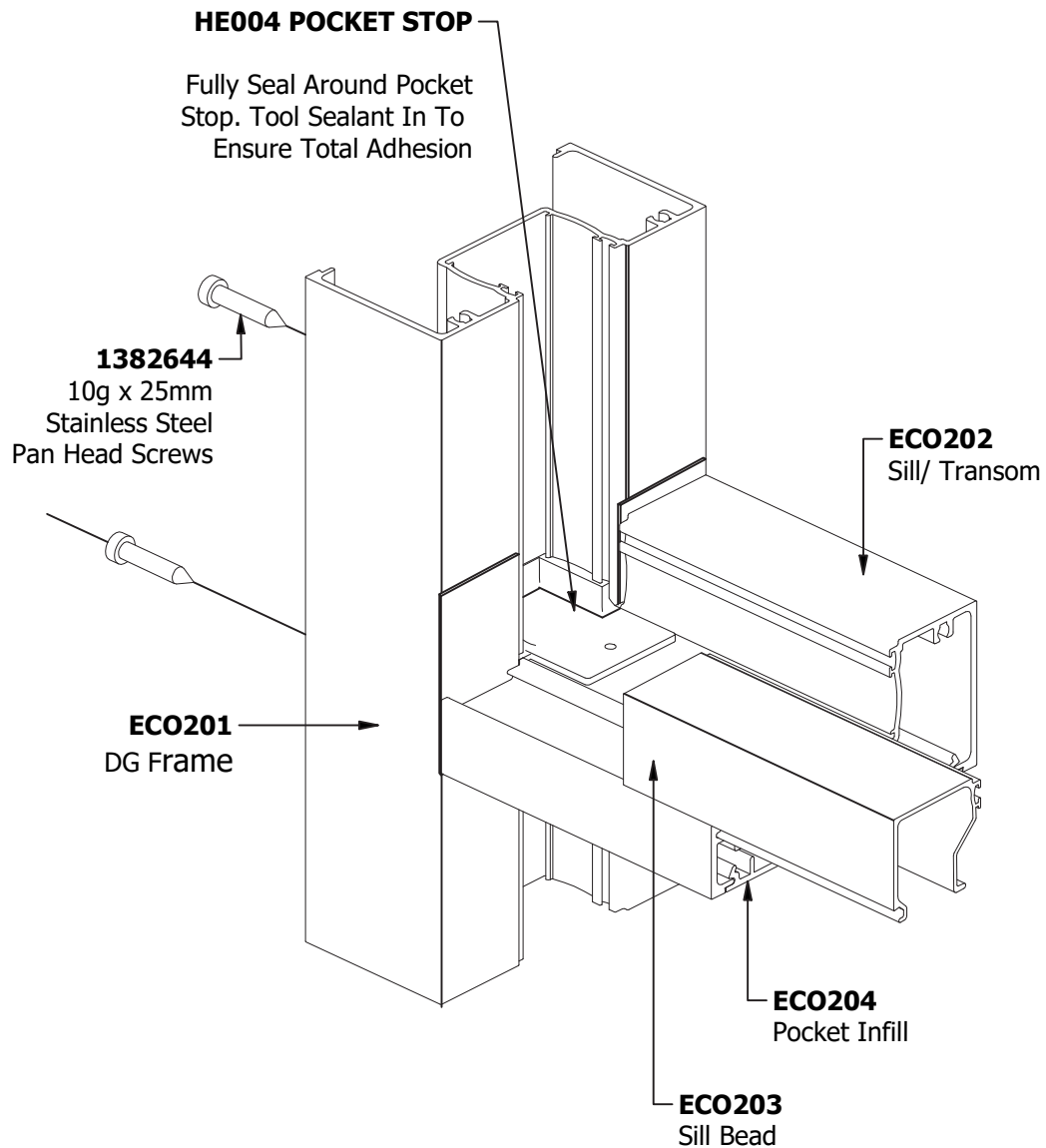
10. Manufacturing Details

Frame/Jamb Preparation - 50mm Pocket Frame



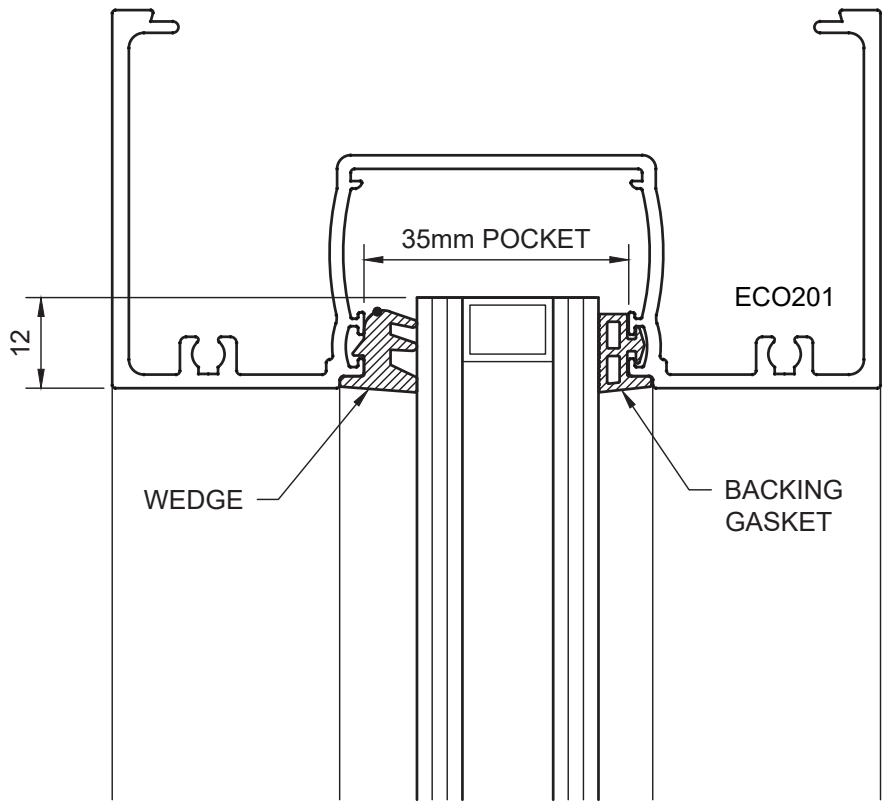
11. Assembly Details

Transom Assembly and Sealing Details



12. Glazing Details

Glazing Details - Captive

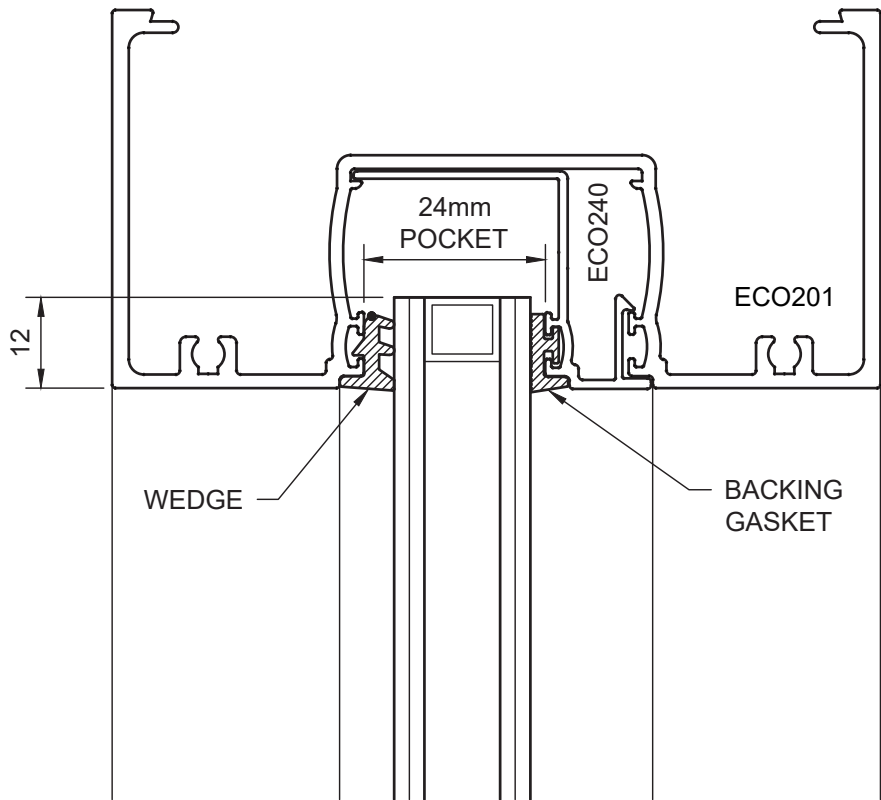


	WEDGE		PUSH IN BACKING GASKET	CO-EXTRUDED BACKING GASKET
GLASS THICKNESS	ID COLOUR	REF. (GAP)	REF. (GAP)	REF. (GAP)
20mm	GREEN	GR50 (9mm)	GR49 (6mm)	CE49 (6mm)
22mm	RED	GR47 (7mm)	GR49 (6mm)	CE49 (6mm)
24mm	RED	GR47 (7mm)	GR37 (4mm)	CE37 (4mm)
25mm	YELLOW	GR46 (6mm)	GR37 (4mm)	CE37 (4mm)
26mm	BLUE	GR45 (5mm)	GR37 (4mm)	CE37 (4mm)
28mm	BROWN	GR43 (3mm)	GR37 (4mm)	CE37 (4mm)

For window & door systems requiring a co-extruded captive gasket on the external side of the glazed pocket, Santoprene is the recommended material to be applied.

12. Glazing Details

Glazing Details - with ECO240 & ECO241 Glazing Adaptors

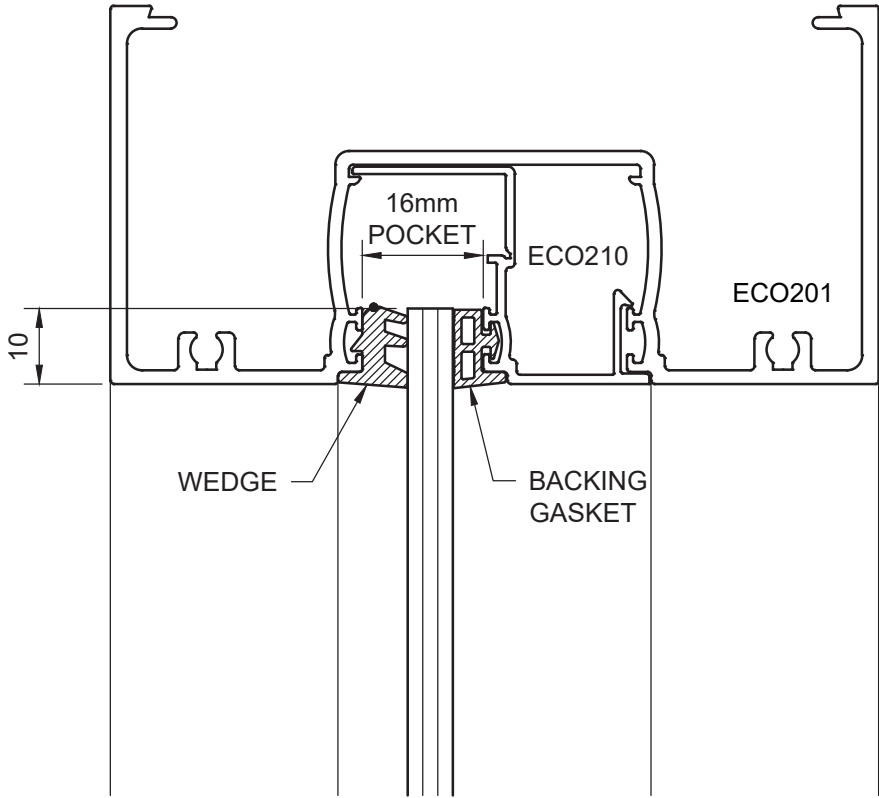


	WEDGE		PUSH IN BACKING GASKET	CO-EXTRUDED BACKING GASKET
GLASS THICKNESS	ID COLOUR	REF. (GAP)	REF. (GAP)	REF. (GAP)
12mm	ORANGE	GR48 (8mm)	GR37 (4mm)	CE37 (4mm)
12.38mm	RED	GR47 (7mm)	GR37 (4mm)	CE37 (4mm)
14mm	YELLOW	GR46 (6mm)	GR37 (4mm)	CE37 (4mm)
16mm	WHITE	GR44 (4mm)	GR37 (4mm)	CE37 (4mm)
18mm	WHITE	GR44 (4mm)	GR36 (2mm)	CE36 (2mm)

For window & door systems requiring a co-extruded captive gasket on the external side of the glazed pocket, Santoprene is the recommended material to be applied.

12. Glazing Details

Glazing Details - With ECO210 Glazing Adaptor

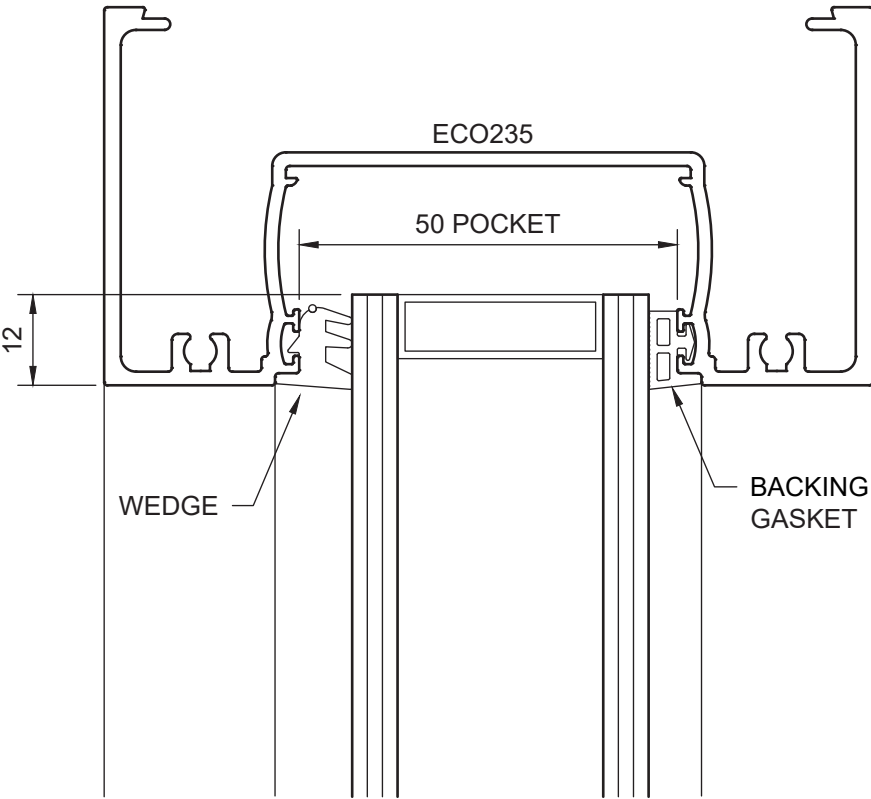


	WEDGE		PUSH IN BACKING GASKET	CO-EXTRUDED BACKING GASKET
GLASS THICKNESS	ID COLOUR	REF. (GAP)	REF. (GAP)	REF. (GAP)
4mm	ORANGE	GR48 (8mm)	GR37 (4mm)	CE37 (4mm)
5mm	RED	GR47 (7mm)	GR37 (4mm)	CE37 (4mm)
6mm	YELLOW	GR46 (6mm)	GR37 (4mm)	CE37 (4mm)
6.38mm	YELLOW	GR46 (6mm)	GR37 (4mm)	CE37 (4mm)
8mm	WHITE	GR44 (4mm)	GR37 (4mm)	CE37 (4mm)
8.38mm	WHITE	GR44 (4mm)	GR37 (4mm)	CE37 (4mm)
10mm	WHITE	GR44 (4mm)	GR36 (2mm)	CE36 (2mm)
10.38mm	WHITE	GR44 (4mm)	GR36 (2mm)	CE36 (2mm)

For window & door systems requiring a co-extruded captive gasket on the external side of the glazed pocket, Santoprene is the recommended material to be applied.

12. Glazing Details

Glazing Details - 50mm Pocket Frame



	WEDGE		PUSH IN BACKING GASKET	CO-EXTRUDED BACKING GASKET
GLASS THICKNESS	ID COLOUR	REF. (GAP)	REF. (GAP)	REF. (GAP)
35mm	GREEN	GR50 (9mm)	GR49 (6mm)	CE49 (6mm)
37mm	RED	GR47 (7mm)	GR49 (6mm)	CE49 (6mm)
39mm	RED	GR47 (7mm)	GR37 (4mm)	CE37 (4mm)
40mm	YELLOW	GR46 (6mm)	GR37 (4mm)	CE37 (4mm)
41mm	BLUE	GR45 (5mm)	GR37 (4mm)	CE37 (4mm)
43mm	BROWN	GR43 (3mm)	GR37 (4mm)	CE37 (4mm)

For window & door systems requiring a co-extruded captive gasket on the external side of the glazed pocket, Santoprene is the recommended material to be applied.

13. Care & Maintenance

FRAMING

Your new **ecoFRAMEplus 101.6mm Centre Pocket DG** 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 **ecoFRAMEplus 101.6mm Centre Pocket DG** frame will retain it's good looks and resist the elements for years to come.

The **ecoFRAMEplus 101.6mm Centre Pocket DG** 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 **ecoFRAMEplus 101.6mm Centre Pocket DG** 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 **ecoFRAMEplus 101.6mm Centre Pocket DG** 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.

SYDNEY

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Eastern Creek NSW 2766
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sydney@alspec.com.au

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Dandenong South VIC 3175
Phone: 03 8787 6333
melbourne@alspec.com.au

BRISBANE

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Phone: 07 3089 4900
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ADELAIDE

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Phone: 08 8150 6960
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DARWIN

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Phone: 08 8941 7300
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CANBERRA

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Phone: 02 5134 3300
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PERTH

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Malaga WA 6090
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NEWCASTLE

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