

AF 60
EBE 65
CATALOGO
TECNICO
TECHNICAL
CATALOGUE

METALFORM™



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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione di 65 mm, idoneo per la realizzazione di porte esterne pedonabili, rettangolari, aventi caratteristiche di resistenza al fuoco.

I **profili in metallo** componenti il sistema sono dello spessore di 15/10 mm e sono ottenuti tramite profilatura a freddo di nastri in acciaio zincato, acciaio inox e acciaio Corten.

Il **taglio termico dei profili** è realizzato tramite un estruso termoplastico resistente al fuoco reso solidale alle parti in metallo esterne da una resina resistente al fuoco ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce la massima resistenza torsionale e flettente.

Le cavità costituenti il profilo sono riempite mediante listelli in calcio silicato necessario per poter garantire la resistenza del profilo al fuoco.

Il sistema può essere installato su **muratura** in calcestruzzo, in laterizio, parete in cartongesso e su facciata continua 4F.

La **costruzione dei telai** prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto e la successiva ripresa delle superfici in vista.

Il sistema prevede la possibilità di alloggiare **vetri** singoli o stratificati (di sicurezza) a una o più camere.

Integrated system of thermally broken profiles, hardware and gaskets with 65 mm, suitable for rectangular pedestrian doors, with fire resisting characteristic.

The metal profiles that make up the system are 15/10 mm thick and are obtained from the cold-forming of the coils in galvanized steel, stainless steel and Corten steel.

The thermal break of the profiles is realized with a thermoplastic extruded with fire resistance characteristic that is collocated flush with the external parts in metal by means of a high-density resin injected at high pressure. The result is a seamless connection without interruptions which guarantees maximum resistance to torsional and bending stress.

The steel shell of the profile is filled by means of calcium silicate strips needed to guarantee the fire resistance characteristic of the profile.

The system can be installed on concrete wall, brick wall, plasterboard and on glazing wall 4F.

For frame assembly the profiles must be joined by welding the sections in contact with each other

Thermally insulated glazing may be used with single or stratified (safety) glass.

Sistema porte:

Complanarità delle ante;

Doppia guarnizione di tenuta per elevate caratteristiche prestazionali e acustiche;

Guarnizioni termoespandenti per il blocco di fiamme, calore e fumi.

Cerniere ad avvitare.

Kit serratura per 1 e 2 ante e relativi accessori (sequenziatore di apertura, coordinatore di chiusura, chiudiporta automatico).

Maniglia e/o maniglione antipánico interno.

Paraspifferi inferiore con guarnizione a pinna.

Doors system:

coplanarity of the doors;

double sealing gasket for high performance and acoustics;

thermoexpanding gasket for fire, heat and smoke insulating.

Screwed hinges

Kit lock for 1 and 2 leaf door with related accessories (opening sequencer, closing coordinator, automatic door closer).

Handle and/or internal antipanic handle.

lower seal with fin.

PRESTAZIONI

Sistema porte

Trasmittanza termica (UNI EN 10077-2)

-Nodo tipo (acciaio inox) con $U_f=2,6 \text{ W/m}^2\text{K}$

Resistenza all'aria (UNI EN 12207)

-Classe 4

Resistenza all'acqua (UNI EN 12208)

-Classe 2A

Resistenza al vento (UNI EN 12210)

-Classe C3

Resistenza al fuoco (UNI EN 13501-2)

-EI₂ 60

Tenuta al fumo (UNI EN 13501-2)

-S₂₀₀

Durabilità – cicli di apertura e chiusura (UNI EN 1191)

-Classe 5 (200.000 cicli)

PERFORMANCES

Door system

Thermal transmittance (UNI EN 10077-2)

-Typical section (stainless steel) with $U_f=2,6 \text{ W/m}^2\text{K}$

Air resistance (UNI EN 12207)

-Class 4

Watertightness (UNI EN 12208)

-Class 2A

Resistance to wind load (UNI EN 12210)

-Class C3

Fire resistance (UNI EN 13501-2)

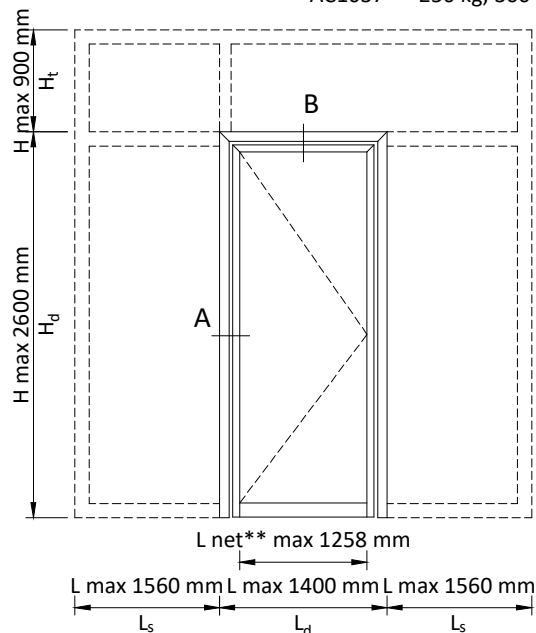
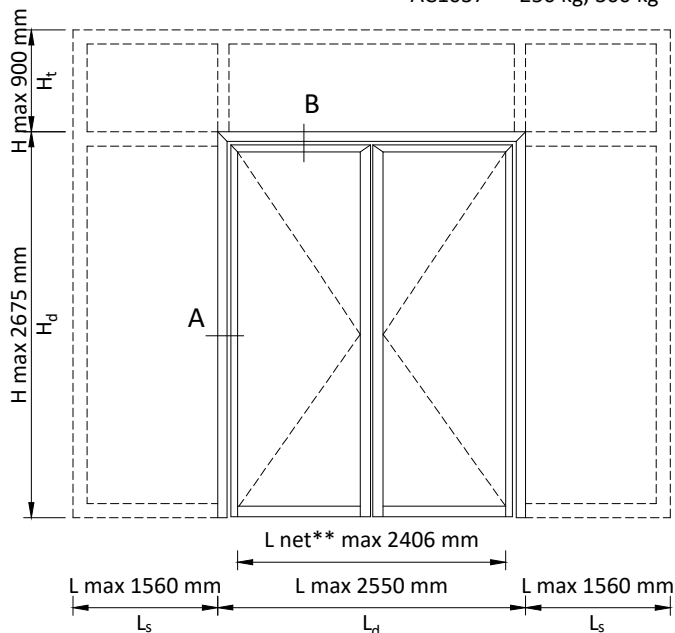
-EI₂ 60

Smoke control (UNI EN 13501-2)

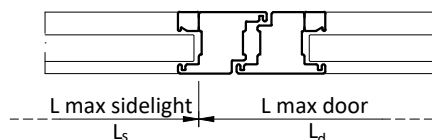
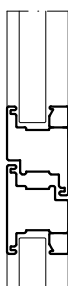
-S₂₀₀

Durability – opening and closing cycle (UNI EN 1191)

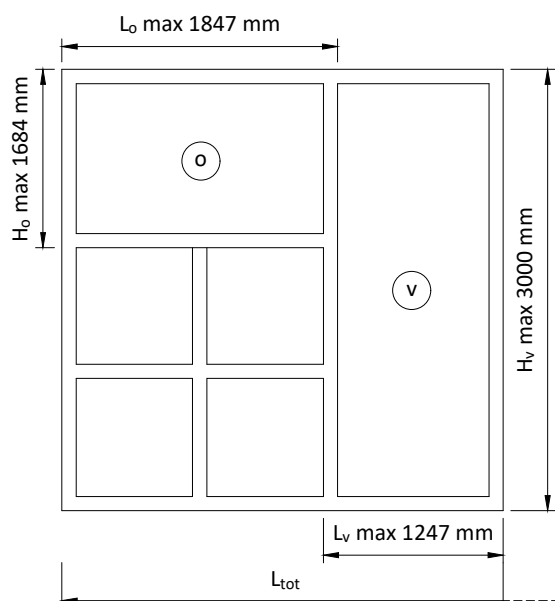
-Class 5 (200.000 cycles)

Limiti e tipologie dimensionali - *Maximum dimension and Types of door***porta ad un anta**
*one-leaf doors*peso massimo anta*
*maximum leaf weight**AC1033 - 160 kg; 200 kg*
AC1037 - 250 kg; 300 kg***porta a due ante**
*two-leaf doors*peso massimo anta*
*maximum leaf weight**AC1033 - 160 kg; 200 kg*
AC1037 - 250 kg; 300 kg*

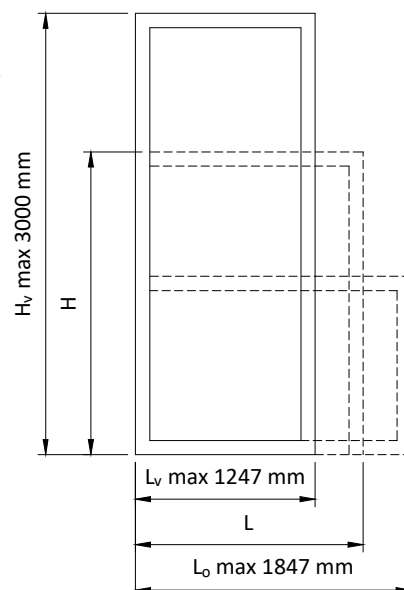
A

H max toplight
 H_t
H max door
 H_d 

B

* con cerniera aggiuntiva per H serramento > 2200 mm
*with additional hinge for doors with height > 2200 mm*** luce netta passaggio
*net opening passage***fissi**
glazing wallDimensioni massime -
regole di estensione:
*Maximum dimensions -
extension rules:*

con / with

 $L_v \text{ max} < L \leq L_o \text{ max}$
 $H = 3,11 \text{ m}^2 / L$ 

Elemento costruttivo di supporto - Supporting construction element

Descrizione elemento di supporto / <i>Supporting construction description</i>	Tipologie applicabili / <i>Types applicable</i>
muratura in mattoni pieni / <i>masonry</i>	Porte e fissi / <i>doors & glazing wall</i>
parete in calcestruzzo alleggerito / <i>aerated concrete wall</i>	Porte e fissi / <i>doors & glazing wall</i>
parete in cartongesso / <i>plasterboard wall</i>	Porte / <i>doors</i>
parete in blocchi cellulari Ytong / <i>concrete cellular wall - Ytong wall</i>	Porte e fissi / <i>doors & glazing wall</i>
facciata vetrata continua 4F / <i>glazing wall 4F</i>	Porte / <i>doors</i>

Tipologie di vetri - Glass type

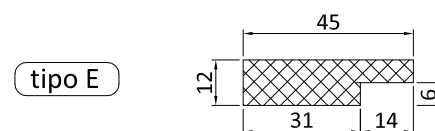
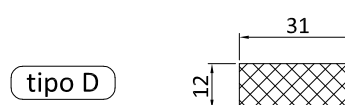
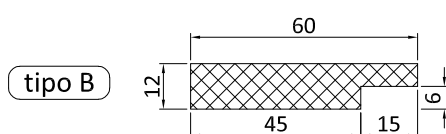
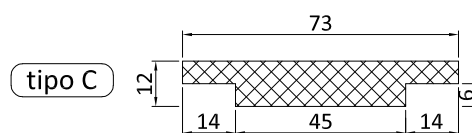
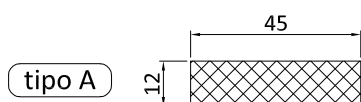
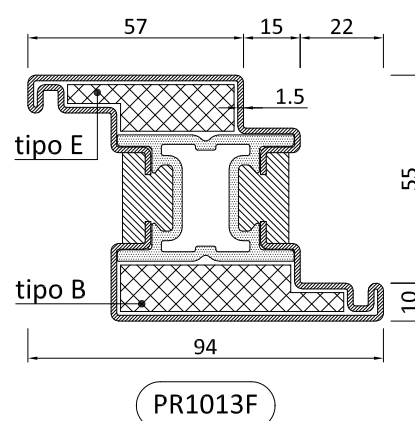
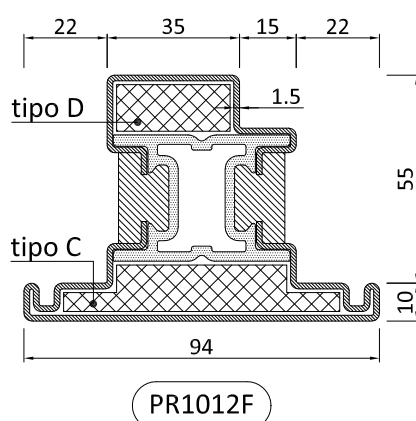
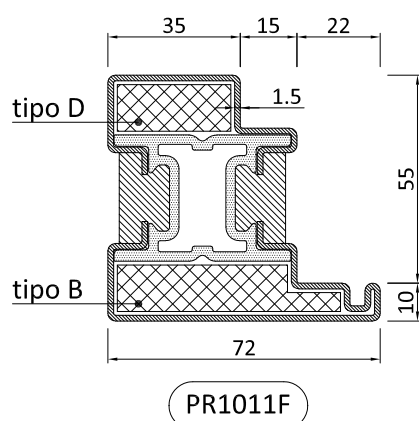
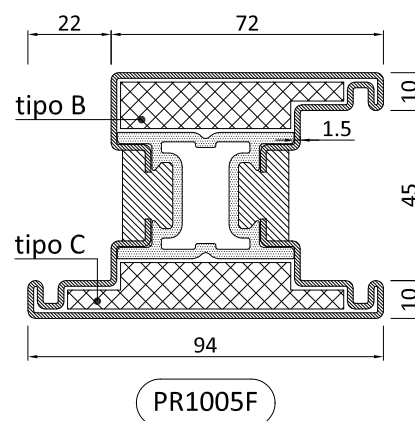
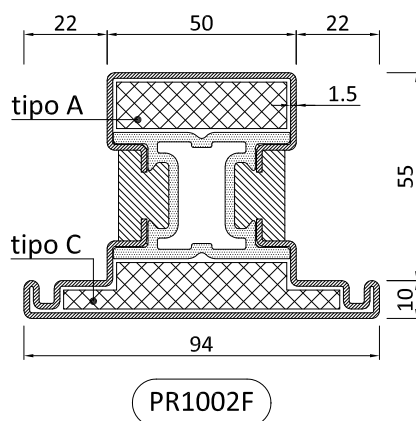
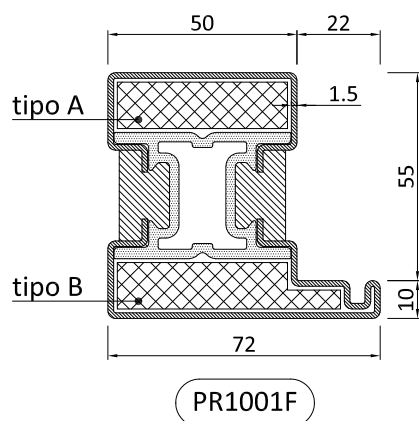
Tipologia / <i>Type</i>	Spessore / <i>Thickness</i>	Tipologie applicabili / <i>Types applicable</i>	distanza da profilo / <i>gap from profile</i>
PILKINTON - Pyrostop 60-101	23 mm	Porte / <i>doors</i>	5 mm
PILKINTON - Pyrostop 60-102	27 mm	Porte / <i>doors</i>	
VETROTECH - Contraflam 60-3	27 mm	Porte e fissi / <i>doors & glazing wall</i>	
VETROTECH - Contraflam 60-3	29 mm	Porte e fissi / <i>doors & glazing wall</i>	
VETROTECH - IGU: Contraflam 60-3: ≥ 27 mm camera/chamber: ≤ 20 mm Vetro esterno/external glass: Stadip 44.2 silence: 8,6 mm	$40 \text{ mm} \leq s \leq 58 \text{ mm}$	Porte / <i>doors</i>	
PILKINTON - IGU: PYROSTOP 60-181 or PYROSTOP 60-171 Pyrostop 60-101: ≥ 23 mm camera/chamber: ≤ 16 mm Vetro esterno/external glass: LSG: 11 mm	$39 \text{ mm} \leq s \leq 54 \text{ mm}$	Porte / <i>doors</i>	

Nota: per applicazione vetri su profilo vedi sezione 2.7 / *Note: for glass application on profile see section 2.7*

Tipologie di profili e materiali - Profiles type and materials

Tipologia / <i>Type</i>	Profondità sezione / <i>section depth</i>	Materiali / <i>materials</i> *	Tipologie applicabili / <i>Types applicable</i>
AF60 EBE 65	65 mm	Acciaio zincato / acciaio inox / acciaio Corten <i>Galvanized steel / stainless steel / Corten steel</i>	Porte e fissi / <i>doors & glazing wall</i>

* verniciatura profilo fino a 1,5 mm di spessore / *Painting of profile up to 1,5 mm of thickness*

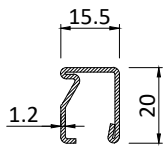


NOTE | NOTE

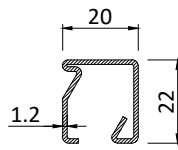
- listelli in calcio silicato forniti contestualmente ai profili /
Calcium silicate strips supplied along with the profiles

- listelli da inserire all'interno dei profili in fase di assemblaggio/lavorazione (vedi sez. assemblaggio e lavorazioni) /
strips to be insert on the profiles during the assembly/tooling activities (see assembling and tooling sections)

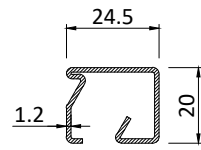
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
PR1001F	5,80	-	0,31	19,04	21,92	6	PR1013F	5,94	-	0,36	21,72	33,08	6
PR1002F	6,25	-	0,36	20,90	37,36	6							
PR1005F	6,91	-	0,42	25,18	47,37	6							
PR1011F	5,27	-	0,31	17,66	21,11	6							
PR1012F	6,06	-	0,36	19,40	36,22	6							



PR2007



PR1007



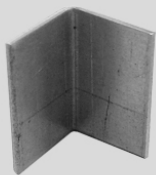
PR2008

MATERIALE | MATERIAL

PR _ _ _ _ F.ZN acciaio zincato | *galvanized steel*PR _ _ _ _ F.CZ acciaio corten grezzo | *untreated corten steel*PR _ _ _ _ F.ST acciaio inox satinato | *satined stainless steel*PR _ _ _ _ F.SB acciaio inox scotch brite | *scotch brite stainless steel*PR _ _ _ _ F.L3 acciaio inox lucido | *polished stainless steel*PR _ _ _ _ F.IZ acciaio inox naturale | *natural stainless steel*

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2007	0,57	-	0,13			6
PR1007	0,70	-	0,16			6
PR2008	0,75	-	0,17			6

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				



AC1014.ZN acciaio zincato | *galvanised steel*
AC1014.CZ acciaio corten | *corten steel*
AC1014.ST inox satinato | *satinated stainless steel*
AC1014.SB inox scotch brite | *scotch brite st. steel*
AC1014.L3 inox lucido | *polished stainless steel*

AC 1014.xx

Accessorio inversione battuta
per porte
PR1012F-PR1013F

n.2 pz. per ogni angolo

*Reverse closure kit for doors
PR1012F-PR1013F*

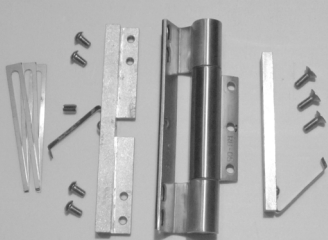
n. 2 pieces for each corner



AC 1080I

Rostro di sicurezza in acciaio inox
Completo di viti e rinforzi

*Stainless steel security pin
With screws and strengtheners*



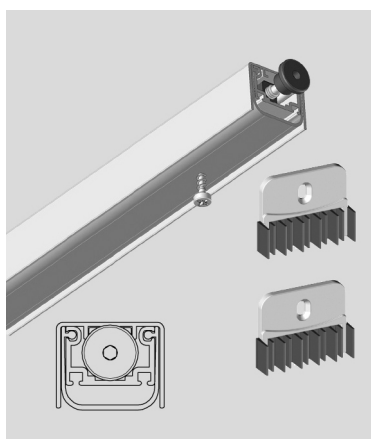
AC1033.IB inox brunito | *burnished stainless steel*
AC1033.IZ inox verniciabile | *paintable stainless steel*
AC1033.SB inox scotch brite | *scotch brite st. steel*
AC1033.ST inox satinato | *satinated stainless steel*
AC1033.L3 inox lucido | *polished stainless steel*
AC1033.CZ corten grezzo | *untreated corten steel*
AC1033.CT corten trattato | *treated corten steel*

AC1033.xx

Cerniera a stilo ad avvitare con
viti e rinforzi per porta
Peso massimo anta: 160 kg

*Screw-on hinge with screws and
strengtheners for door
Maximum leaf weight: 160 kg*

AISI 304



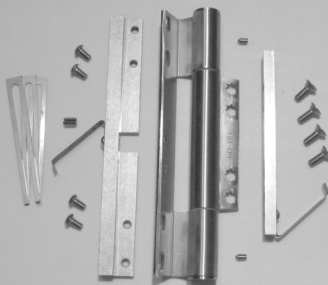
AC 1081.x

Paraspiffero automatico a
ghigliottina

Guillotine type draught excluder

Dimensioni anta | *Leaf dimension*

AC1081.A: 615 → 730 mm
 AC1081.B: 715 → 830 mm
 AC1081.C: 815 → 930 mm
 AC1081.D: 915 → 1030 mm
 AC1081.E: 1015 → 1130 mm
 AC1081.F: 1115 → 1230 mm
 AC1081.G: 1215 → 1330 mm



AC1037.IB inox brunito | *burnished stainless steel*
AC1037.SB inox scotch brite | *scotch brite st. steel*
AC1037.ST inox satinato | *satinated stainless steel*
AC1037.L3 inox lucido | *polished stainless steel*

AC1037.xx

Cerniera a stilo ad avvitare con
viti e rinforzi per porta
Peso massimo anta: 250 kg

*Hinge to be screwed with screws
and strengtheners for door
Maximum leaf weight: 250 kg*

AISI 304



AC 1081F.65

Kit isolamento profilo PR1005F
in zona paraspiffero
L 1220 mm

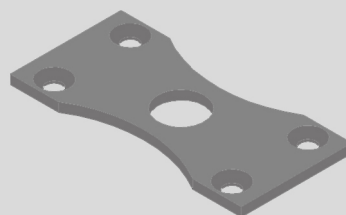
*Insulation kit for PR1005F profile
on draught excluder zone
L 1220 mm*



AC 1040

Kit chiusura porte seconda anta
Acciaio inox

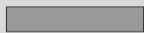
*Second leaf door closing kit
Stainless steel*



AC 1510.65

Piastra di giunzione gusci per
profili EBE65

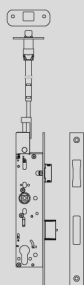
*Joint plates for EBE65 profile
shells*

**AC 1526.x**

Spessore vetro in calcio silicato
di dimensioni 26x80 mm

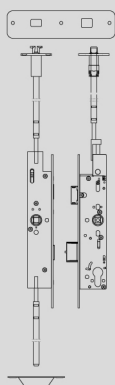
*Calcium silicate shim with
dimension 26x80 mm*

AC1526.2 spessore | *thickness* 2 mm
AC1526.3 spessore | *thickness* 3 mm
AC1526.5 spessore | *thickness* 5 mm

**AC 1560.65**

Kit serratura antipanico per
porta a 1 anta in EBE65

*Antipanic lock kit for 1 leaf door
in EBE65*

**AC 1562.65**

Kit serratura antipanico per
porta a 2 ante in EBE65

*Antipanic lock kit for 2 leaf door
in EBE65*

**CV 5001**

Vite per boccia fermavetri

Screw for glazing bead bushing

TPS 4.2x16 mm

CV 5012

Boccia per fermavetri

Bushing for glazing bead

CV5001 acciaio zincato | *galvanized steel*
CV5001I acciaio inox | *stainless steel*

CV5012 acciaio zincato | *galvanized steel*
CV5012I acciaio inox | *stainless steel*

**GE 1001S**

Guarnizione di battuta siliconica
per porte

Silicone gasket for door

**GP 0095**

Guarnizione interna fermavetro
spessore 3 mm

*Internal gasket for glazing bead,
3mm thick*

**GE 1006**

Guarnizione esterna vetro

External gasket

**GC 2006.x**

Guarnizione ceramica
colore bianco

*Ceramic gasket
white color*

GC2006.2 spessore|thickness 2 mm
GC2006.3 spessore|thickness 3 mm
GC2006.4 spessore|thickness 4 mm
GC2006.5 spessore|thickness 5 mm

**GE 1011**

Guarnizione interna fermavetro
spessore 3-4 mm

*Internal gasket for 3-4 mm thick
glazing bead*

**GC 2006.x.NE**

Guarnizione ceramica
colore nero

*Ceramic gasket
black color*

GC2006.2.NE spessore|thickness 2 mm
GC2006.3.NE spessore|thickness 3 mm

**GE 1012**

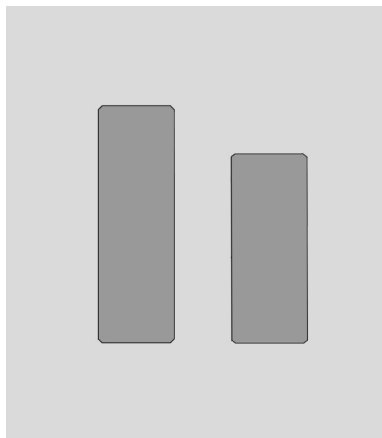
Guarnizione interna fermavetro
spessore 6-8 mm

*Internal gasket for 6-8 mm thick
glazing bead*

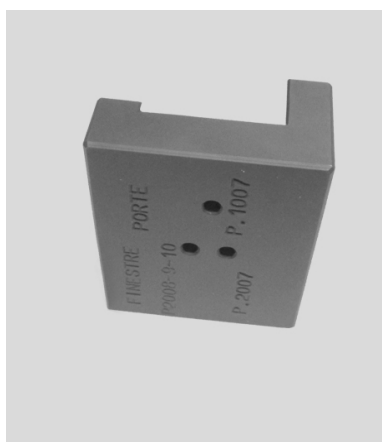
**GU 1501.24**

Guarnizione intumescente
dimensioni sezione 24x2 mm

*Intumescent gasket section
dimension 24x2 mm*

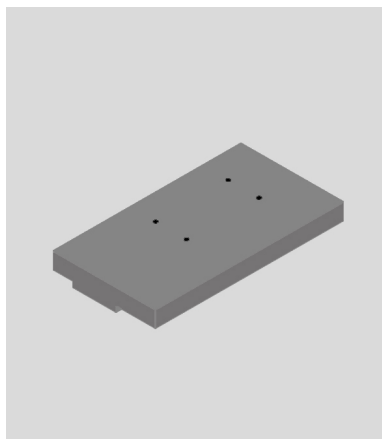
**AT 1000**

Ganasce di taglio per profili
EBE 65
*Cutting jaws for profiles
EBE 65*

**AT 1234**

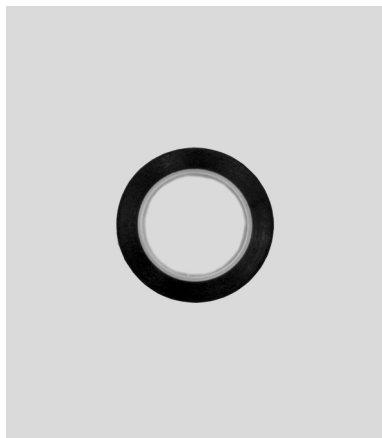
Maschera per esecuzione fori
fissaggio fermavetri con boccole

*Jig for drilling holes for glazing
bead with bushings*

**AT 1510.65**

Maschera per esecuzione fori
fissaggio piastra contenimento
gusci per profili EBE65

*Jig for drilling holes for joint
plates for EBE65 profile shells*

**SA 1024**

Nastro adesivo protettivo per
verniciatura
24 mm

*Adhesive tape for painting
24 mm*

**SA 2032**

Primer di adesione per profili
verniciati

*Adhesion primer for painted
profiles*

**SA 2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**SA 2033**

Liquido di adesione per
materiale plastico

Adhesion liquid for plastic

**SA 2002**

Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 3001**

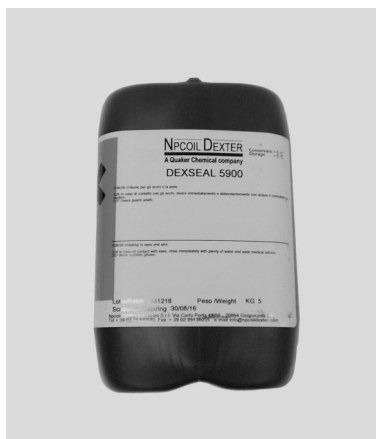
Acido per ossidazione corten

Oxidising acid for corten

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA 3002**

Passivante per ossidazione corten
25 Kg

*Passivating agent for corten
25 Kg*

SA 3002/5

Passivante per ossidazione corten
5 Kg

*Passivating agent for corten
5 Kg*

**SA 3003**

Cera d'api per finitura corten

Beeswax for Corten finishing

**SL 0021**

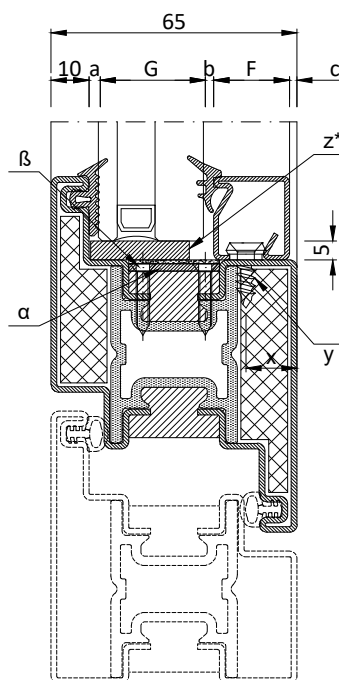
Silicone nero per guarnizioni

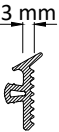
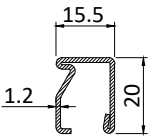
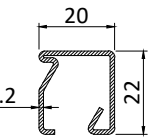
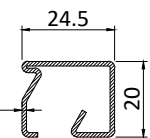
Black silicone for gaskets

**SL 1550**

Colla con reazione al fuoco classe A1 per fissaggio listelli calcio silicato al profilo

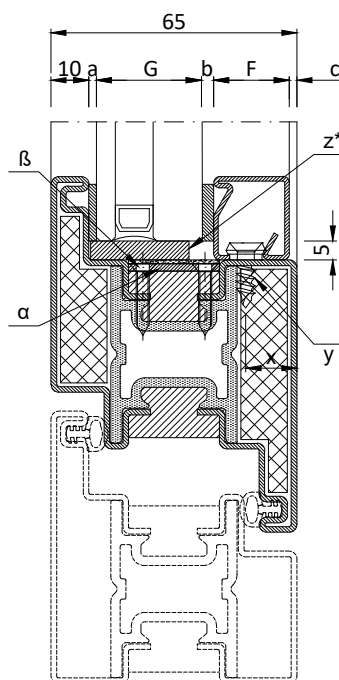
Reactive glue to fire class A1 for fixing calcium silicate infill into the profiles

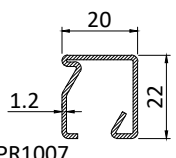
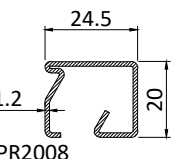


F	G	Guarnizioni - <i>gaskets</i>								
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushing and screws for glazing bead fixing	piatti collegamento gusci profilo profile joint plates	guar. intumescente sotto vetro under glass intumescent gasket
Code		a	b	b	b	x	c	y	α	β
 PR2007	27 - 29	3	-	-	27	8.5	1	CV5001(i) CV5012(i)	AC1510.65	GU1501.20
			-	-	29	7.5	0			
 PR1007	23 - 29		27	27	23	13.5	2	CV5001(i) CV5012(i)	AC1510.65	GU1501.20
			29	29	-	11.5	0			
 PR2008	23		-	-	-	-	-	CV5001(i) CV5012(i)	AC1510.65	GU1501.20
			-	23	-	16	0			

z* = spessori di supporto vetro in calcio silicato AC1526/5 (vedi sez. spessori vetro)

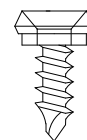
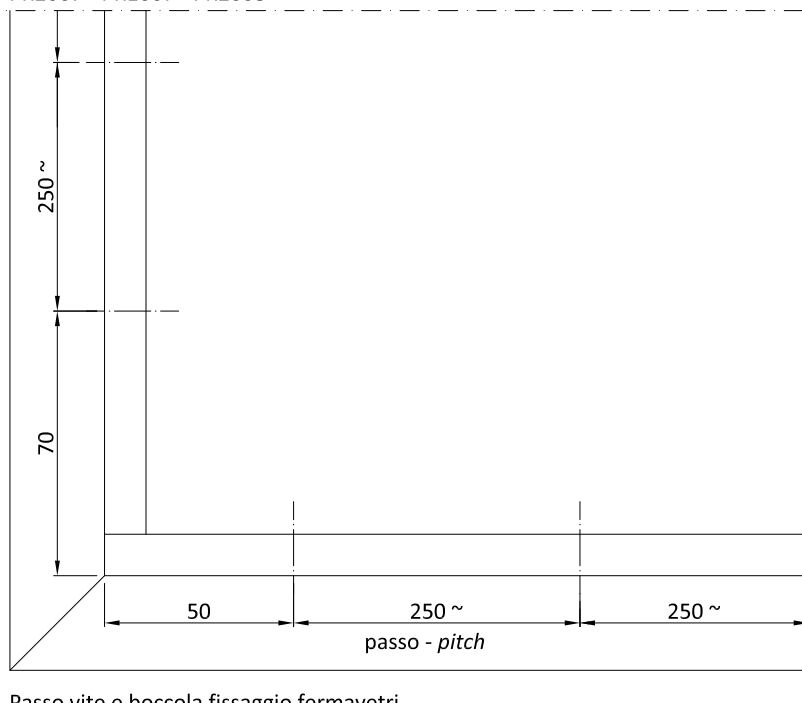
z* = calcium silicate shims for glass support AC1526/5 (see sect. glass shims)

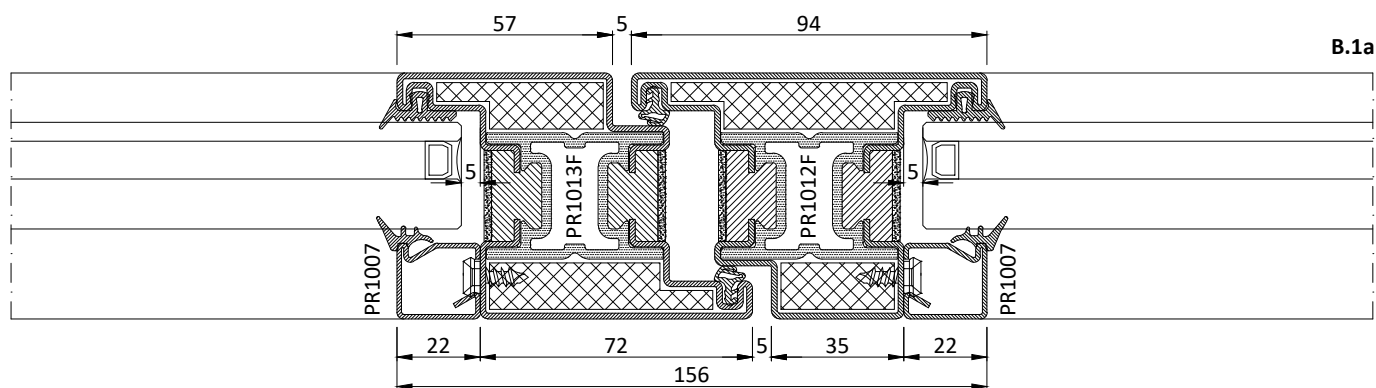
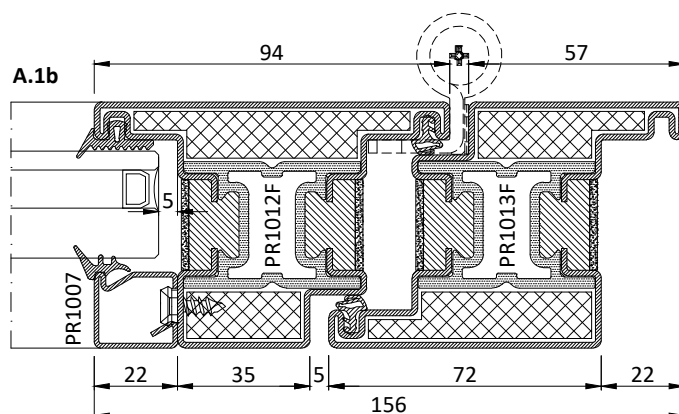
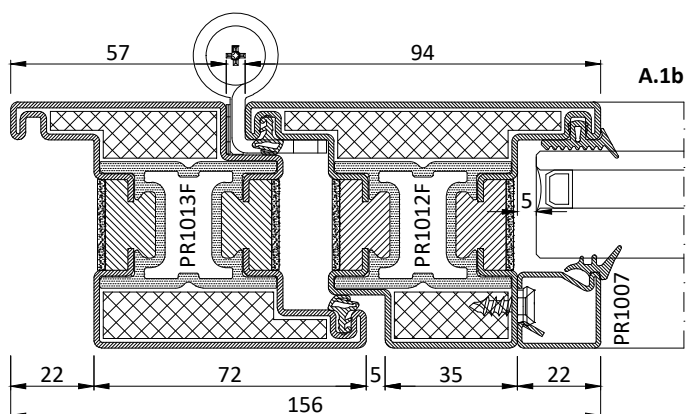
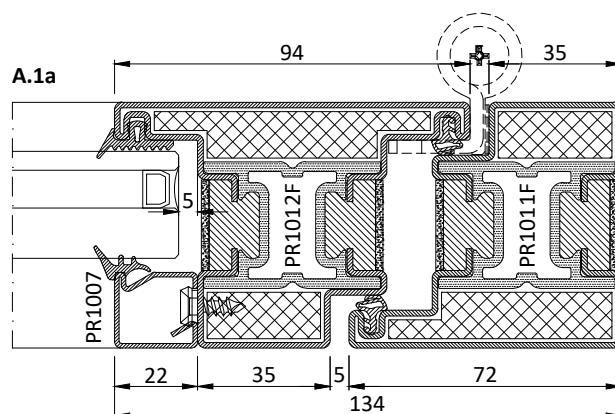
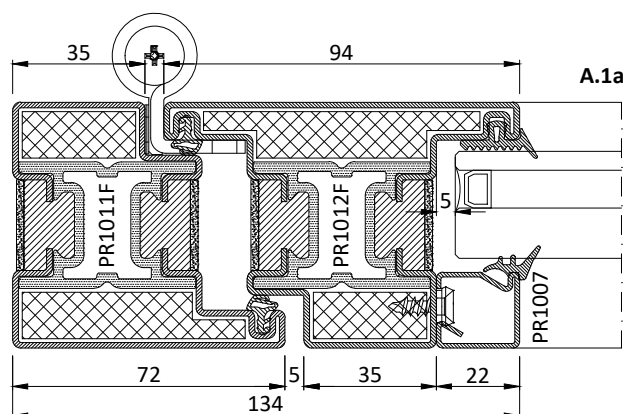
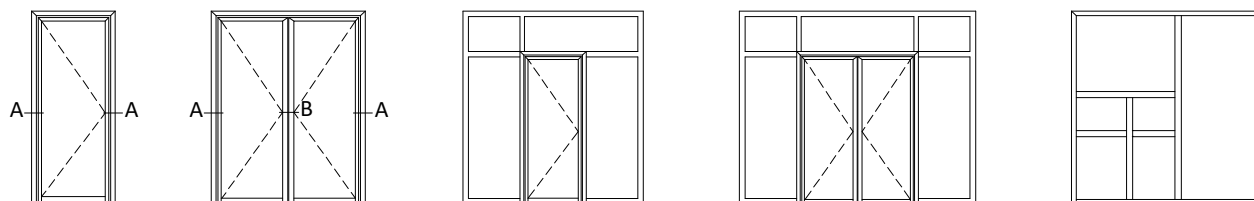


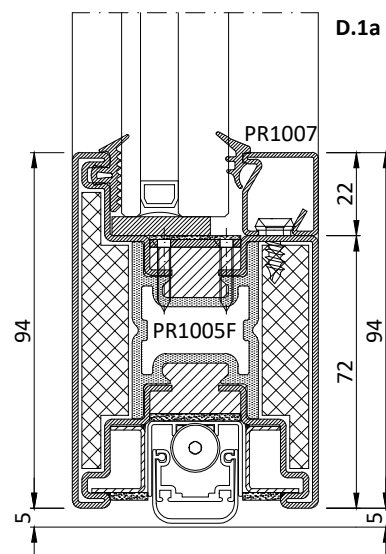
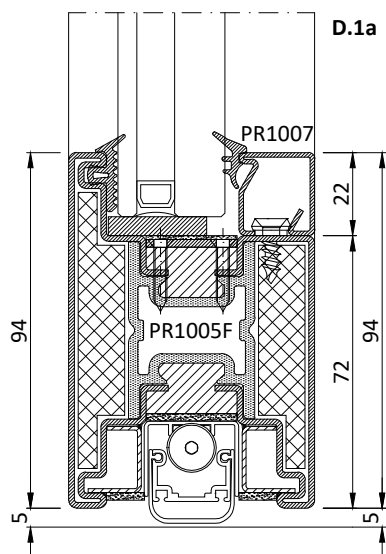
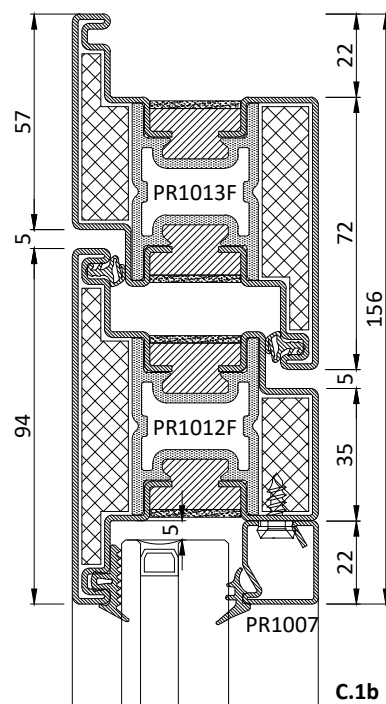
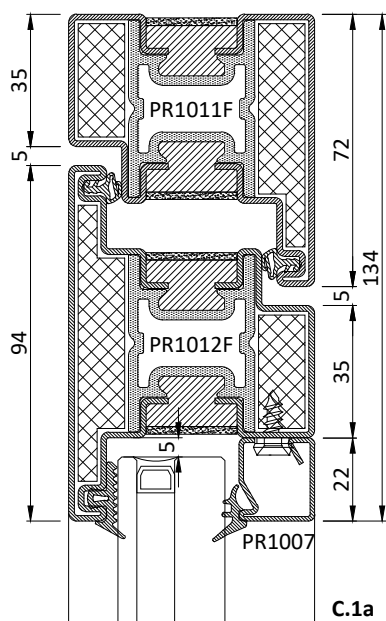
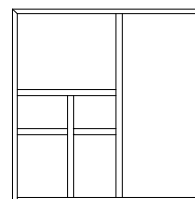
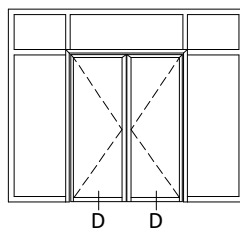
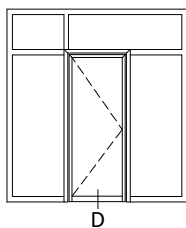
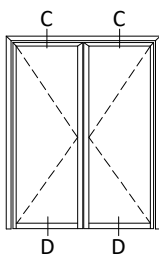
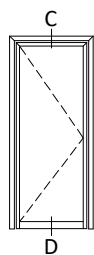
F	G	Guarnizioni - gaskets									
fermavetro glazing bead	range vetro glass range	GC2006/2 2 mm 	GC2006/2 2 mm 	GC2006/3 3 mm 	GC2006/4 4 mm 	GC2006/5 5 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushing and screws for glazing bead fixing	piatti collegamento gusci profilo profile joint plates	guar. intumescente sotto vetro under glass intumescent gasket
Code		a	b	b	b	b	x	c	y	α	β
 PR1007	27 - 29	2	29	-	27	-	13.5	2	CV5001(i) CV5012(i)	AC1510.65	GU1501.20
			-	-	29	-	11.5	0			
 PR2008	23 - 27		-	23	-	-	-	-	CV5001(i) CV5012(i)	AC1510.65	GU1501.20
			27	-	-	23	16	0			

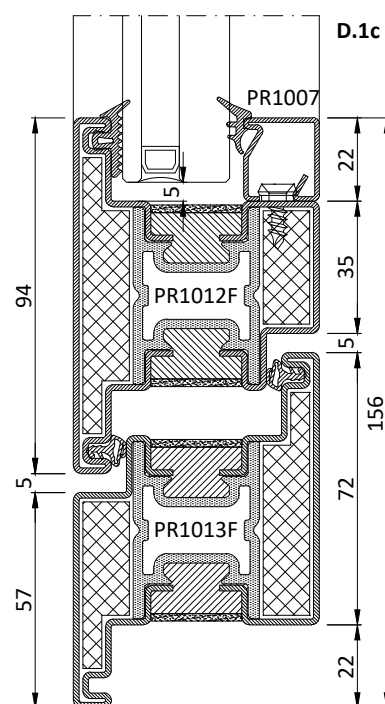
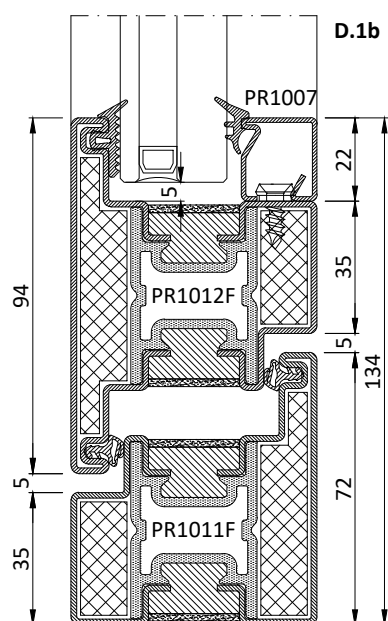
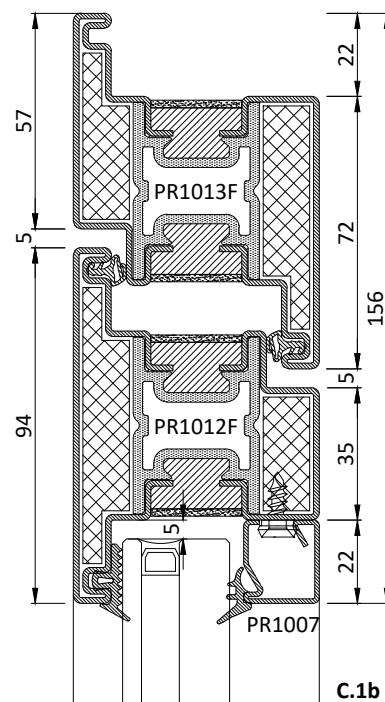
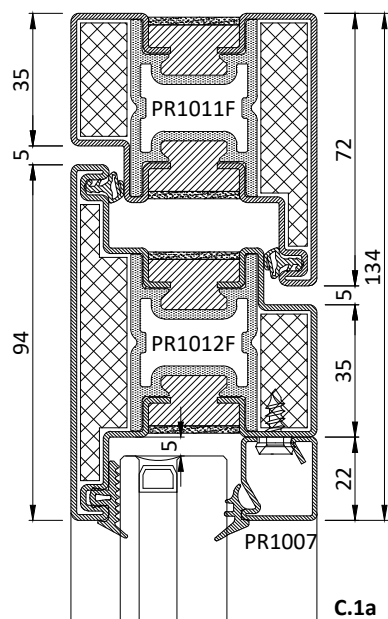
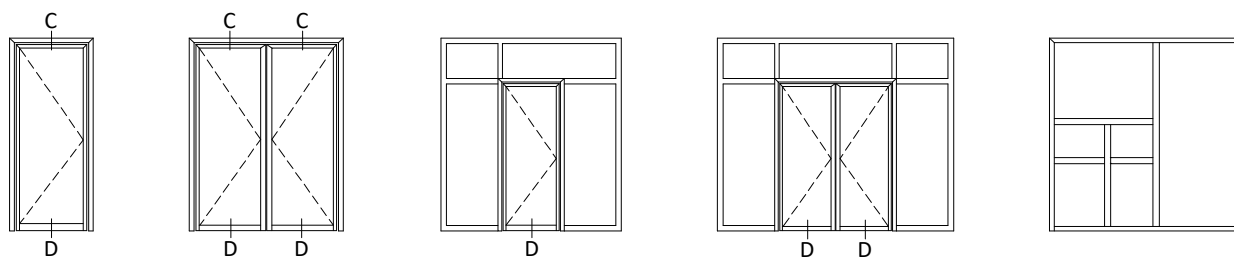
z* = spessori di supporto vetro in calcio silicato AC1526/5 (vedi sez. spessori vetro)
 z* = calcium silicate shims for glass support AC1526/5 (see sect. glass shims)

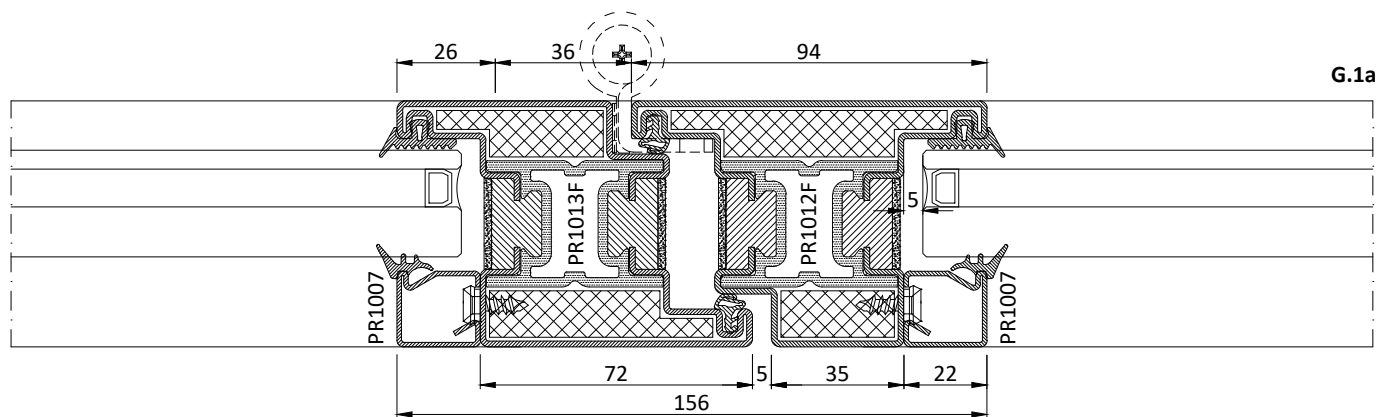
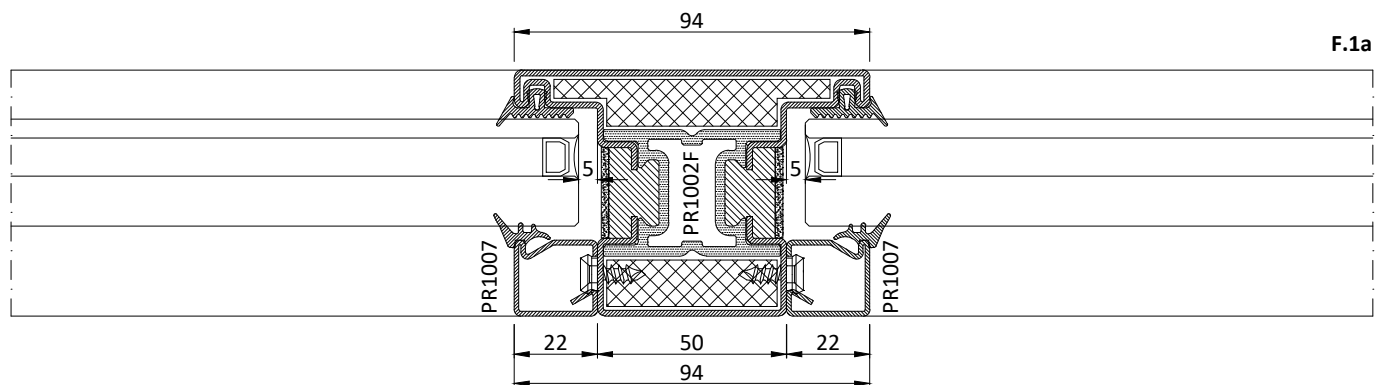
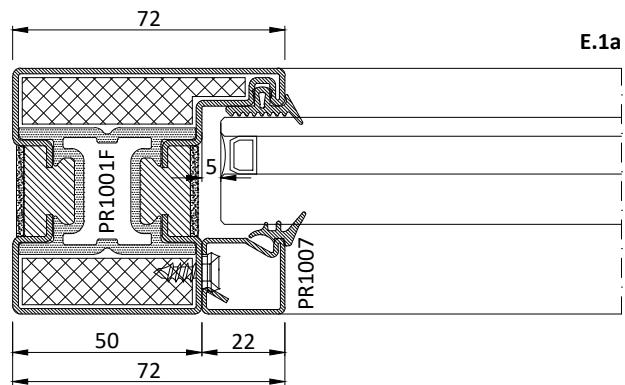
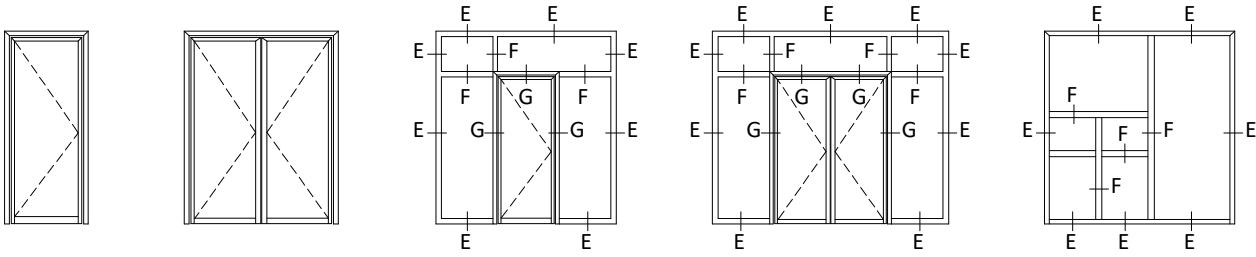
PR2007 - PR1007 - PR2008

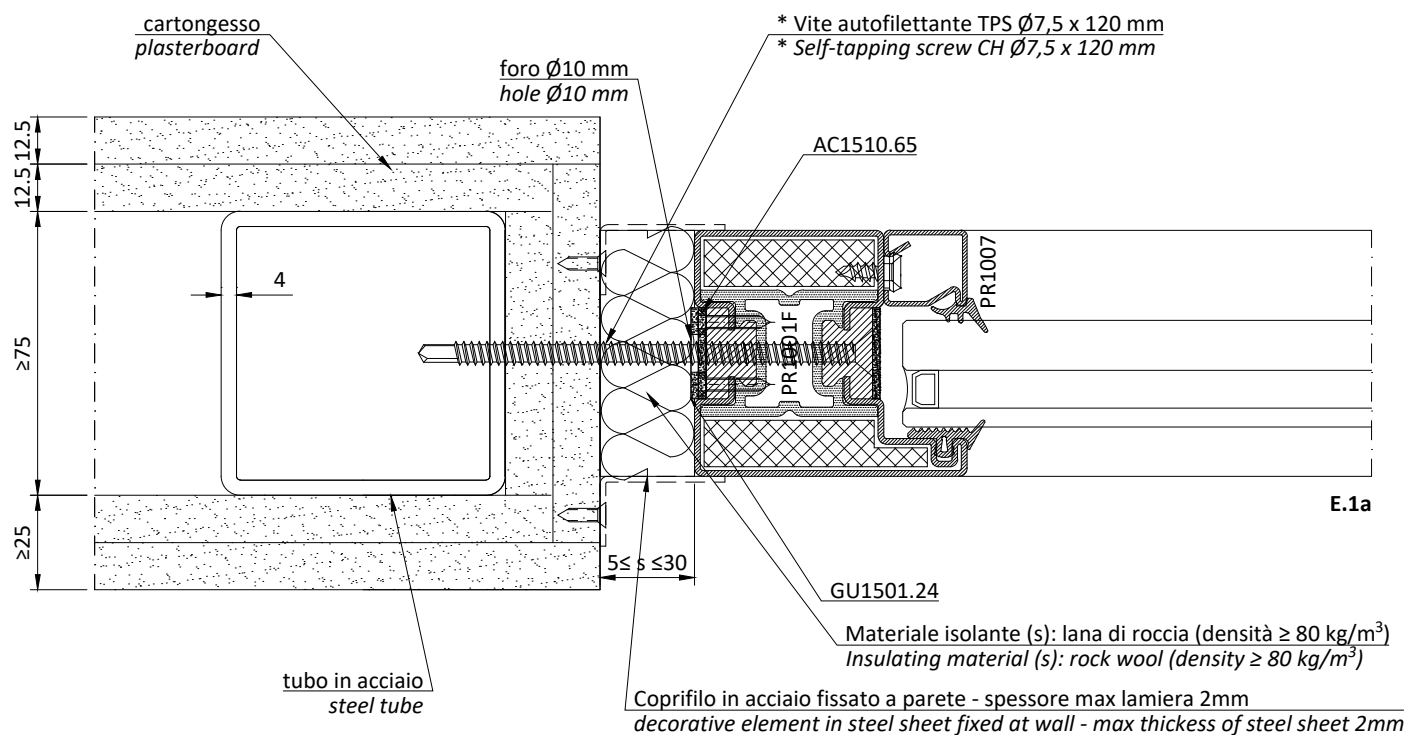
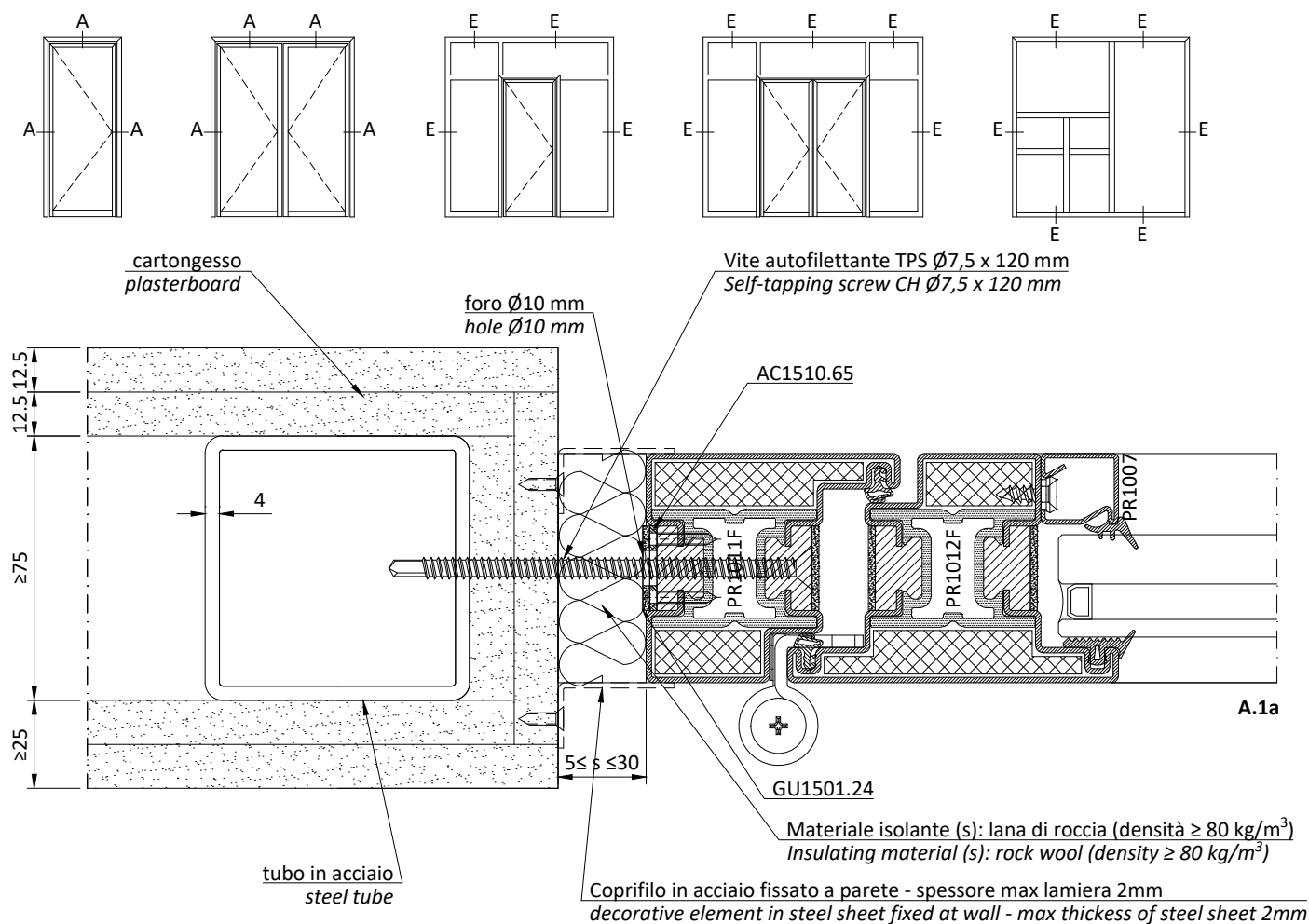
CV5001 + CV5012
CV5001I + CV5012IPasso vite e boccola fissaggio fermavetri
*Clip pitch to fix glazing beads*Fori eseguibili con maschera AT1234
Holes to be done with AT1234



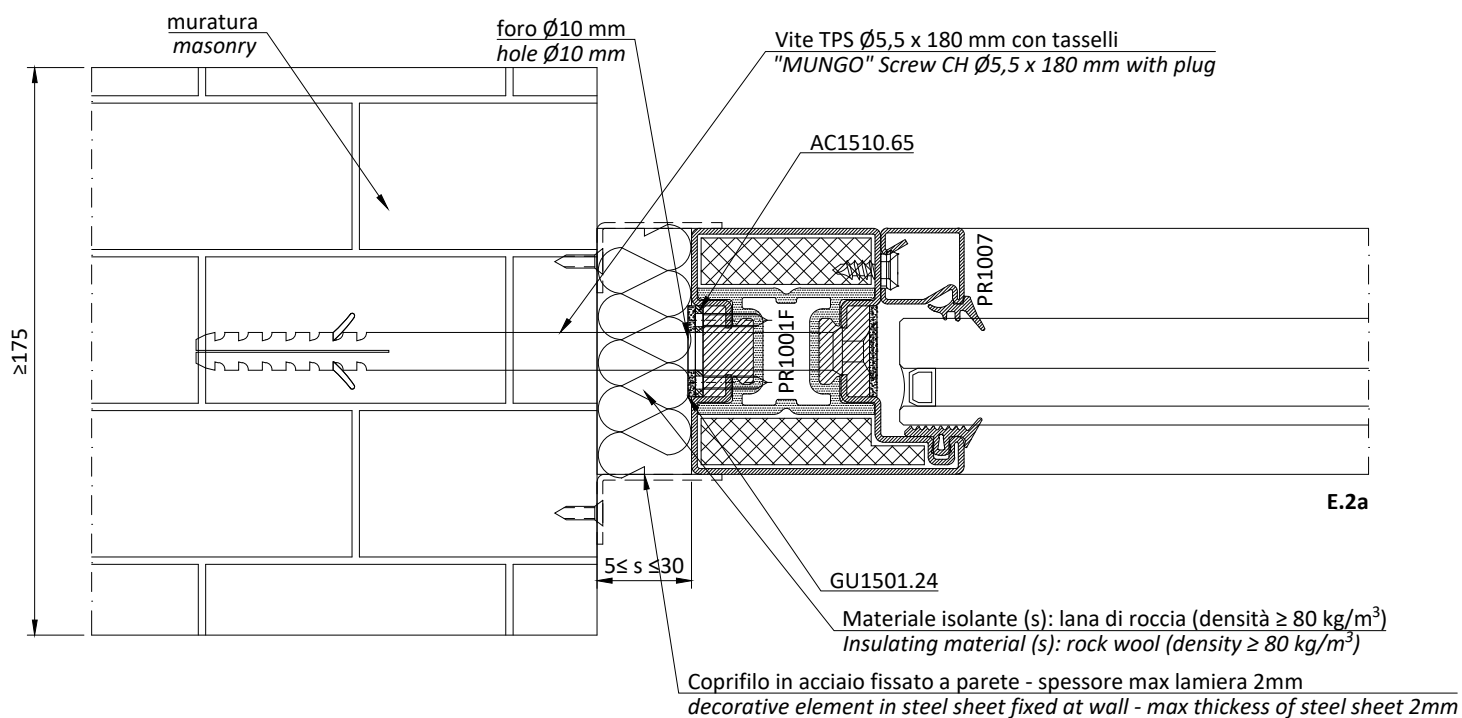
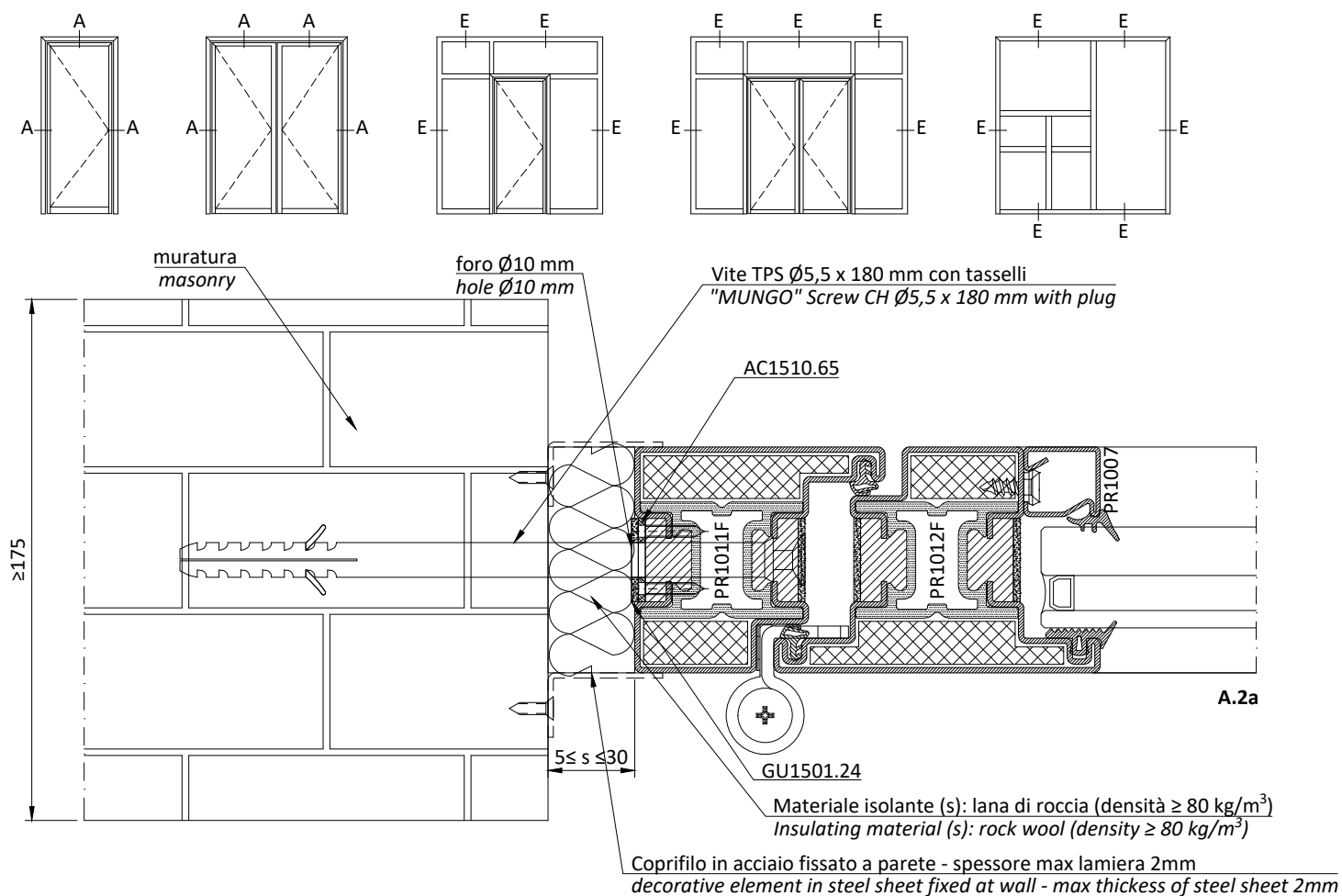




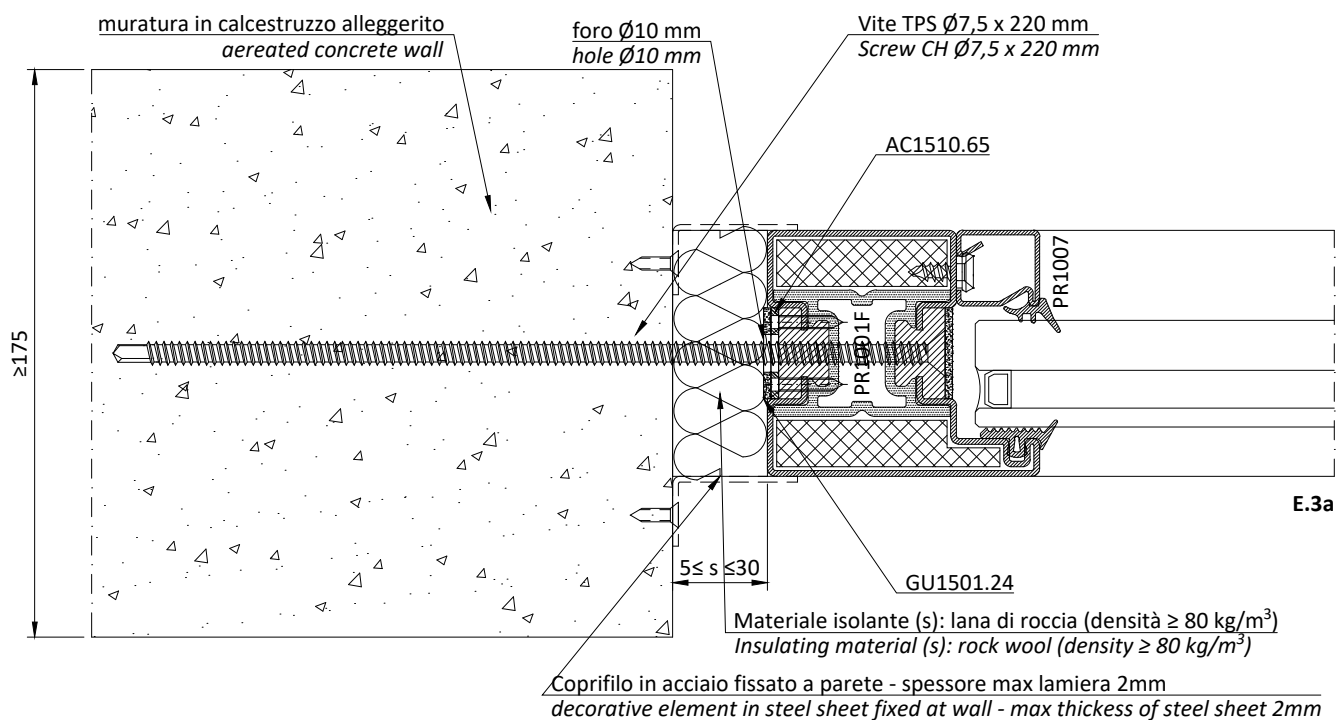
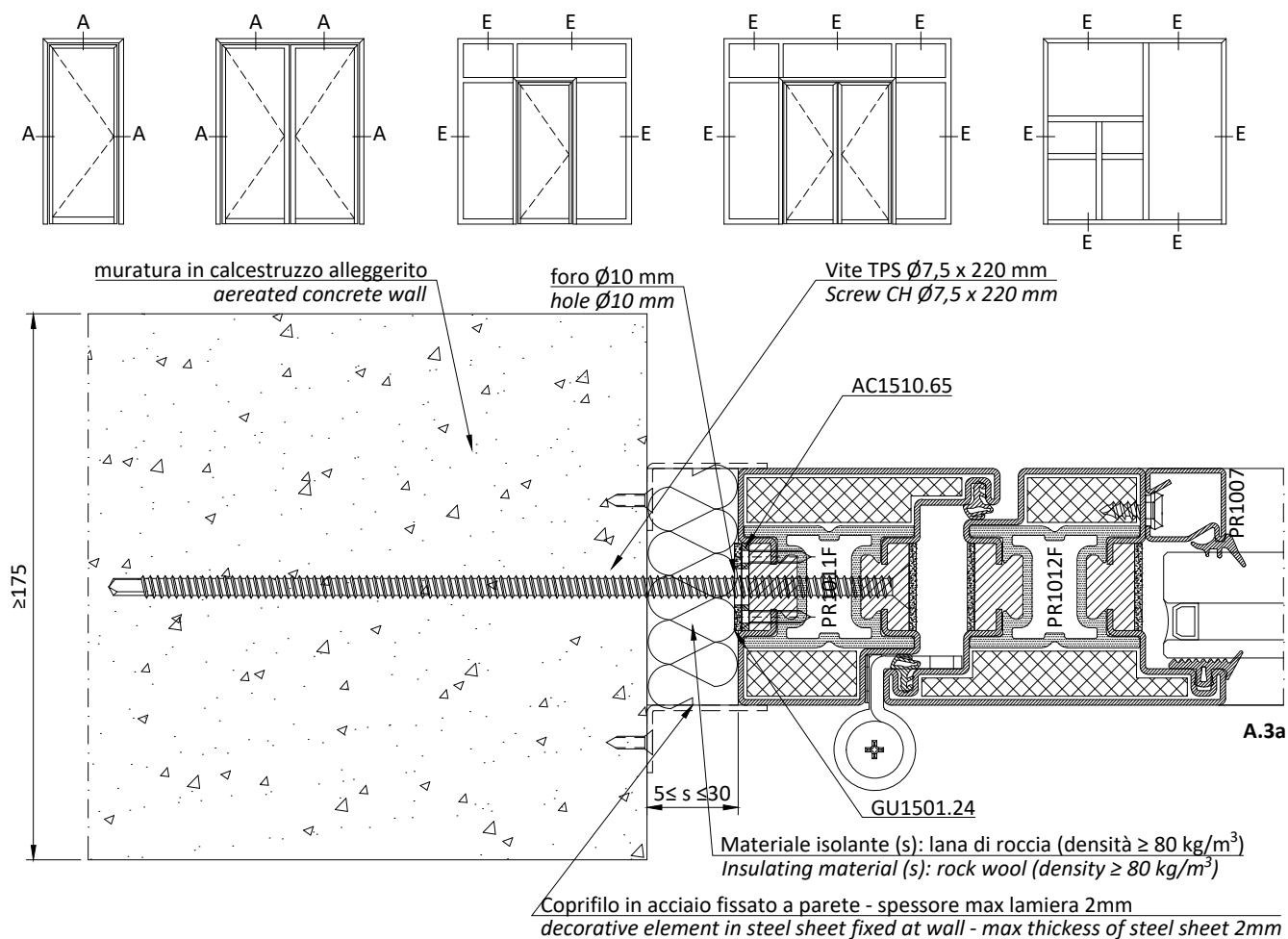




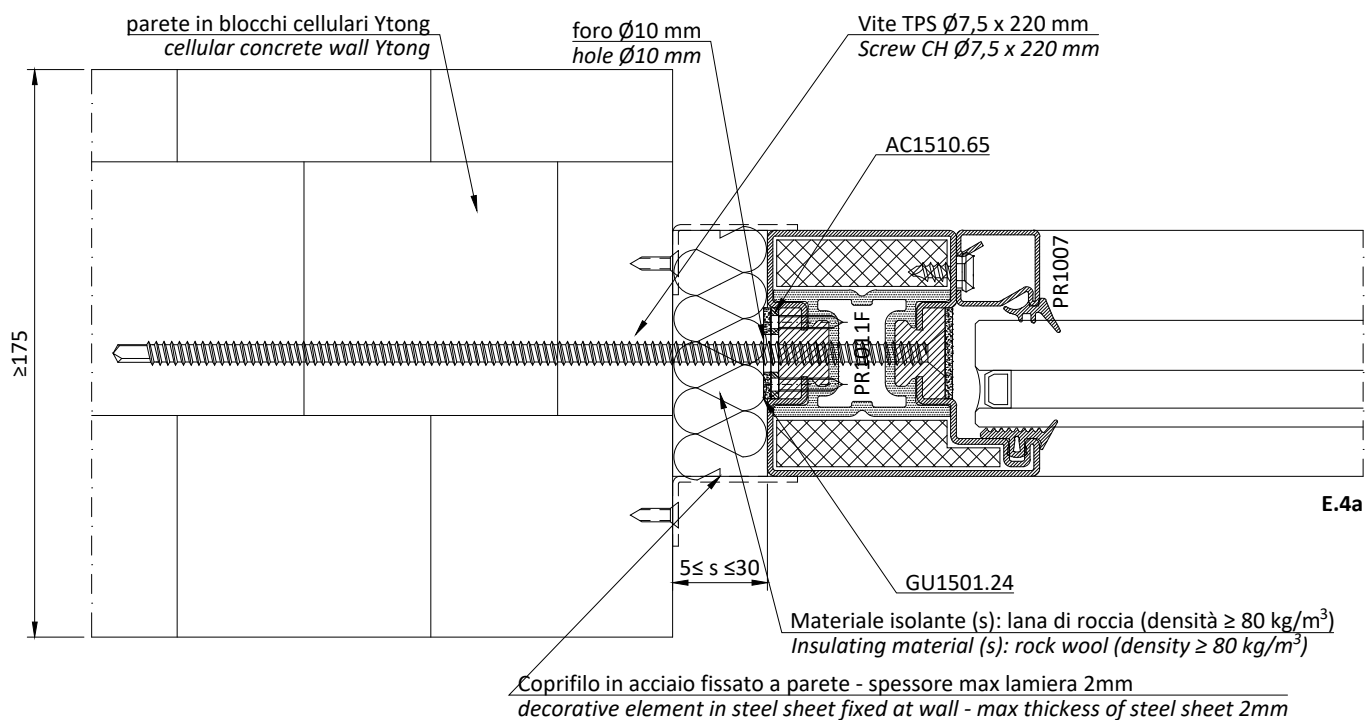
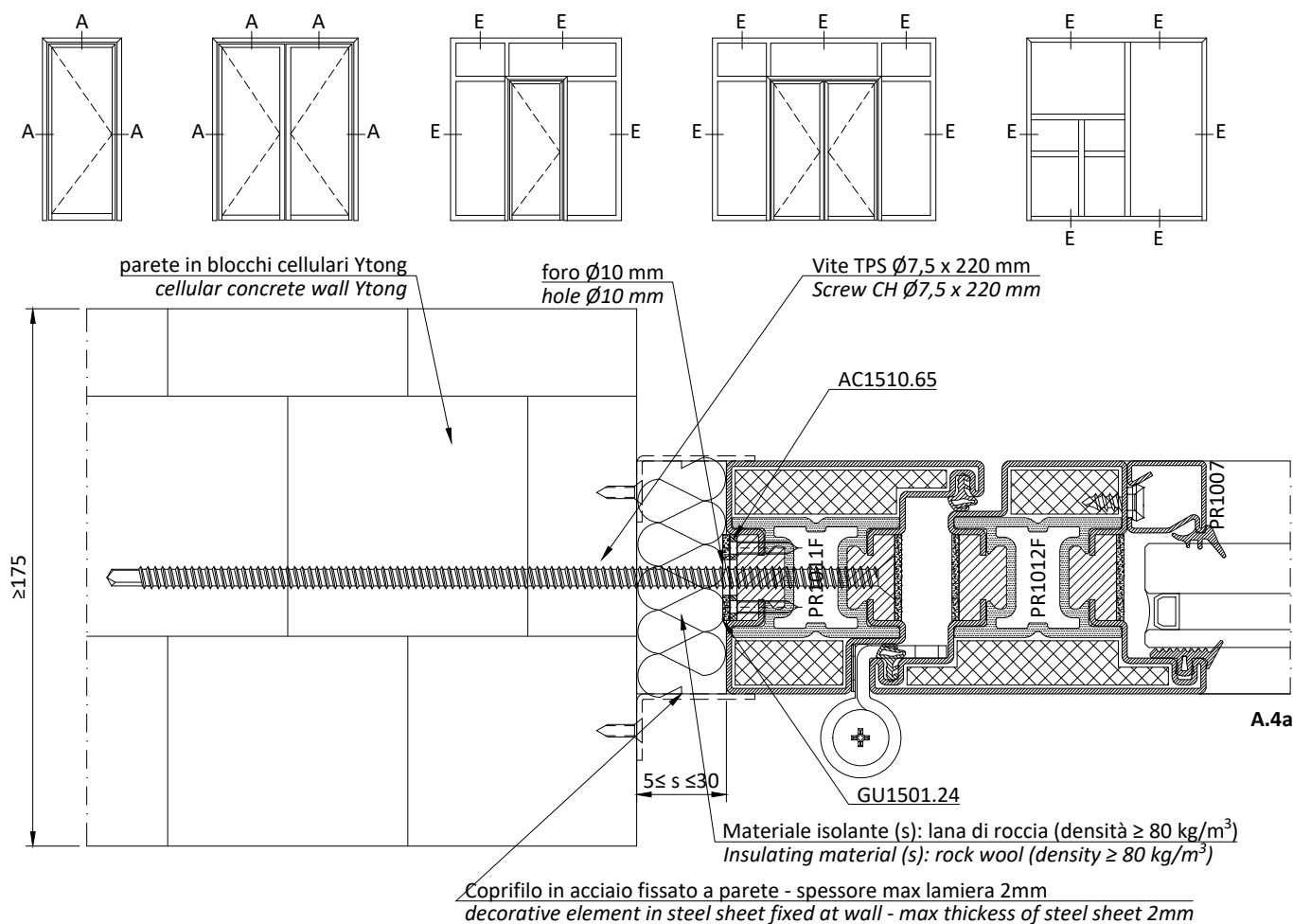
* posizione fissaggi vedi TAV. "interasse massima fissaggi" / fixing point as per TAV. "maximum fixing point spacing"



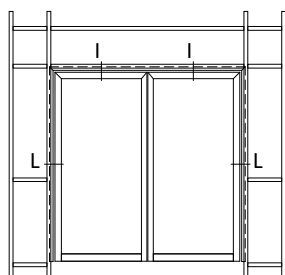
* posizione fissaggi vedi TAV. "interasse massima fissaggi" / fixing point as per TAV. "maximum fixing point spacing"



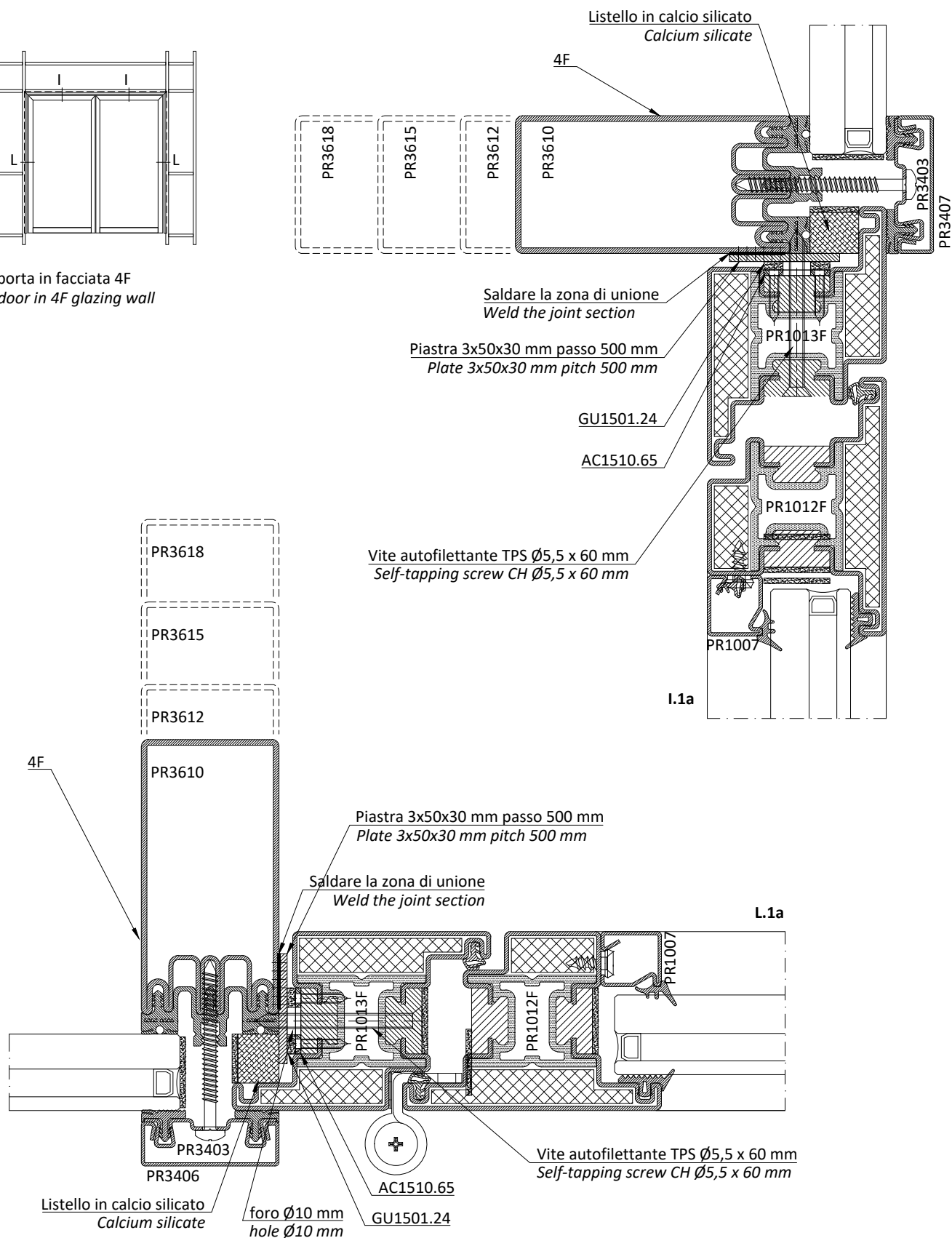
* posizione fissaggi vedi TAV. "interasse massima fissaggi" / fixing point as per TAV. "maximum fixing point spacing"



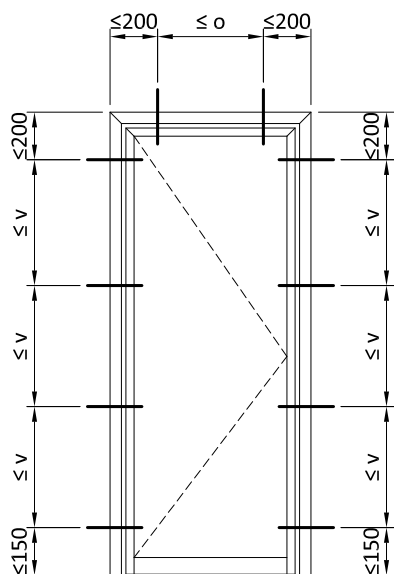
* posizione fissaggi vedi TAV. "interasse massima fissaggi" / fixing point as per TAV. "maximum fixing point spacing"



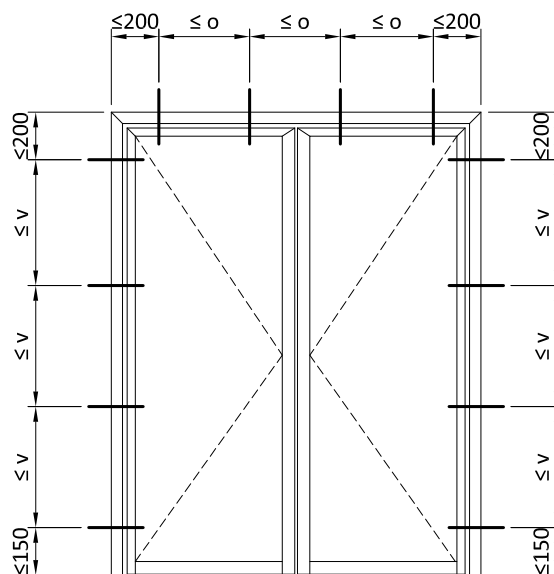
porta in facciata 4F
door in 4F glazing wall



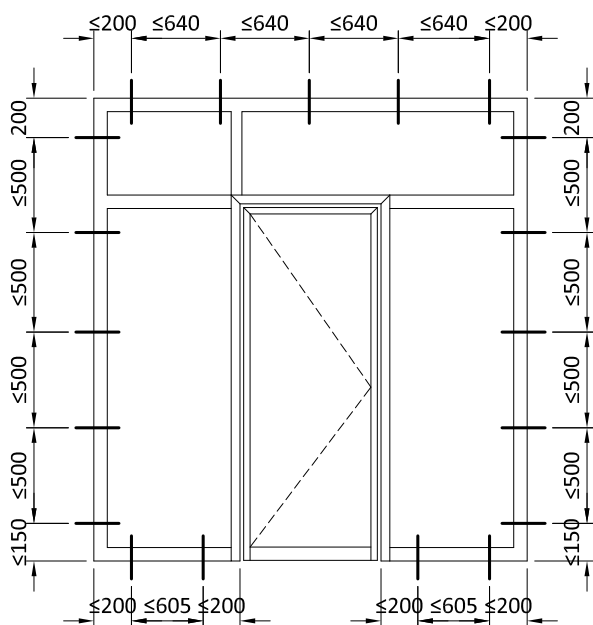
* posizione fissaggi vedi TAV. "interasse massima fissaggi" / fixing point as per TAV. "maximum fixing point spacing"



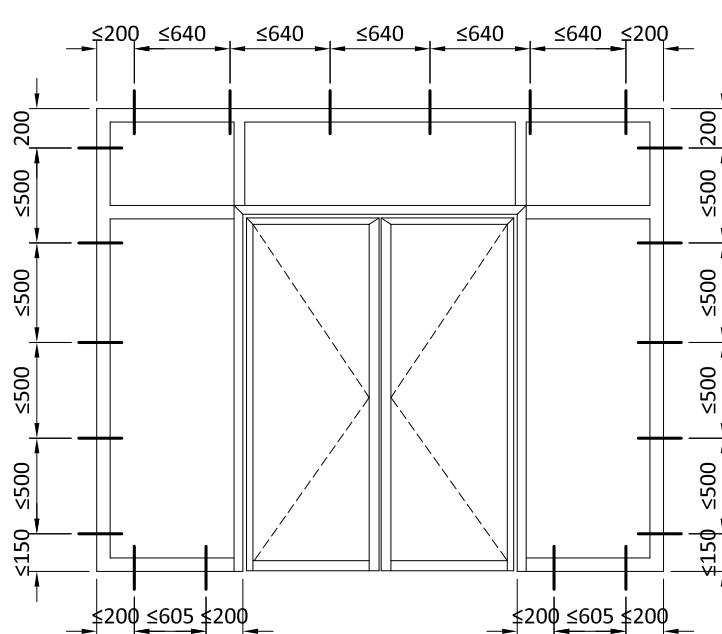
porta ad un anta
one-leaf doors



porta a due ante
two-leaf doors



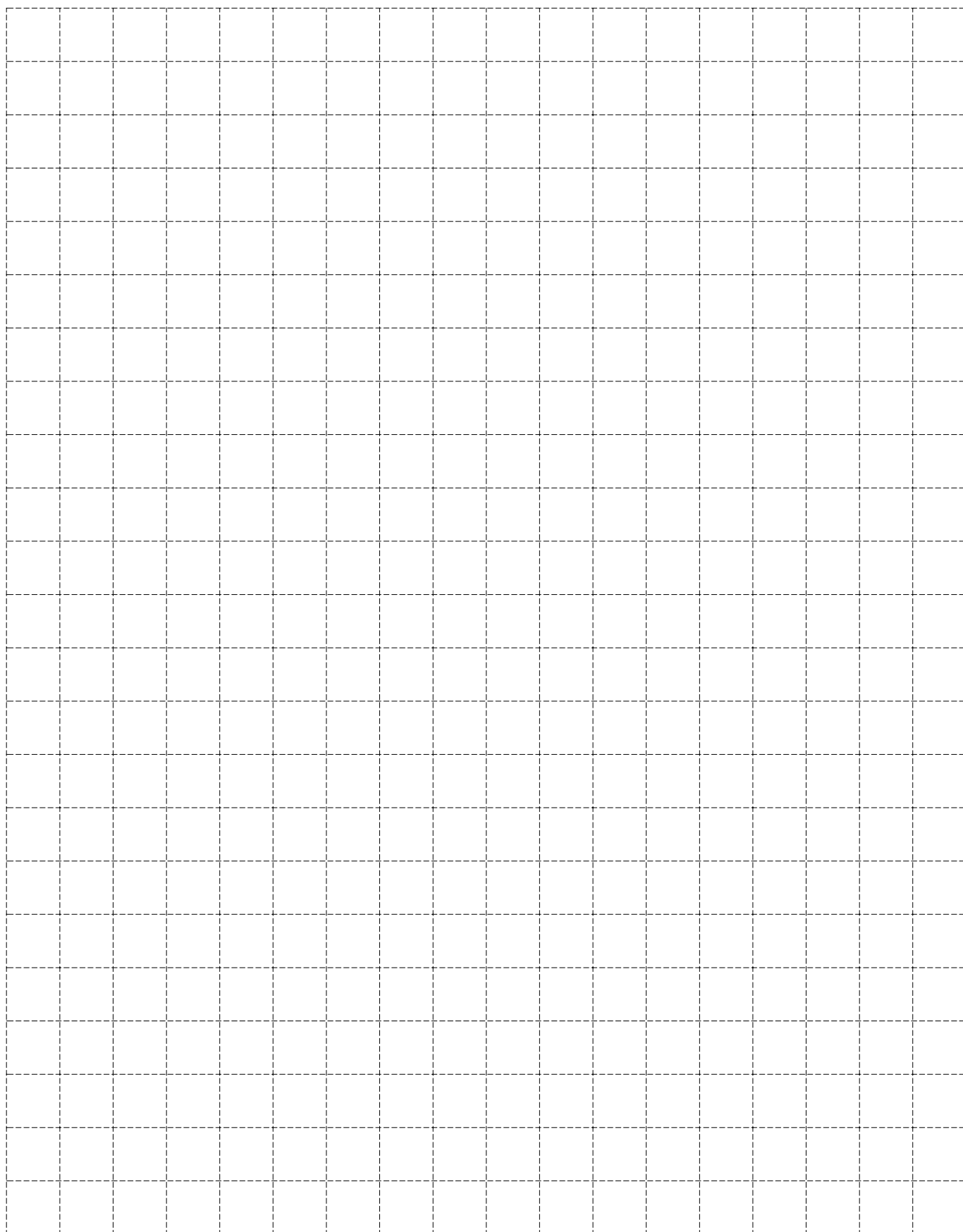
porta ad un anta con sopraluce e laterale fisso
one-leaf doors with toplight and sidelight



porta a due ante con sopraluce e laterale fisso
two-leaf doors with toplight and sidelight

Tipologia di costruzione di supporto / Support construction type	interasse massimo punti di fissaggio (mm) *	
	v	o
Parete in cartongesso / plasterboard wall	716	775
muratura in mattoni pieni / masonry	750	500
parete in calcestruzzo alleggerito / aerated concrete wall	435	444
parete in blocchi cellulari Ytong / cellular concrete wall - Ytong wall	562	640
facciata vetrata continua 4F / curtain wall 4F	500	500

* fissaggi in corrispondenza dei piatti di collegamento gusci AC1510.65 / fixings at the joint plates for profile shells AC1510.65



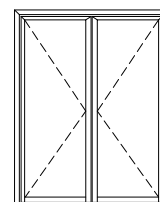
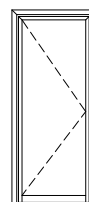
Distinta di taglio e lista componenti | Cutting list and components list

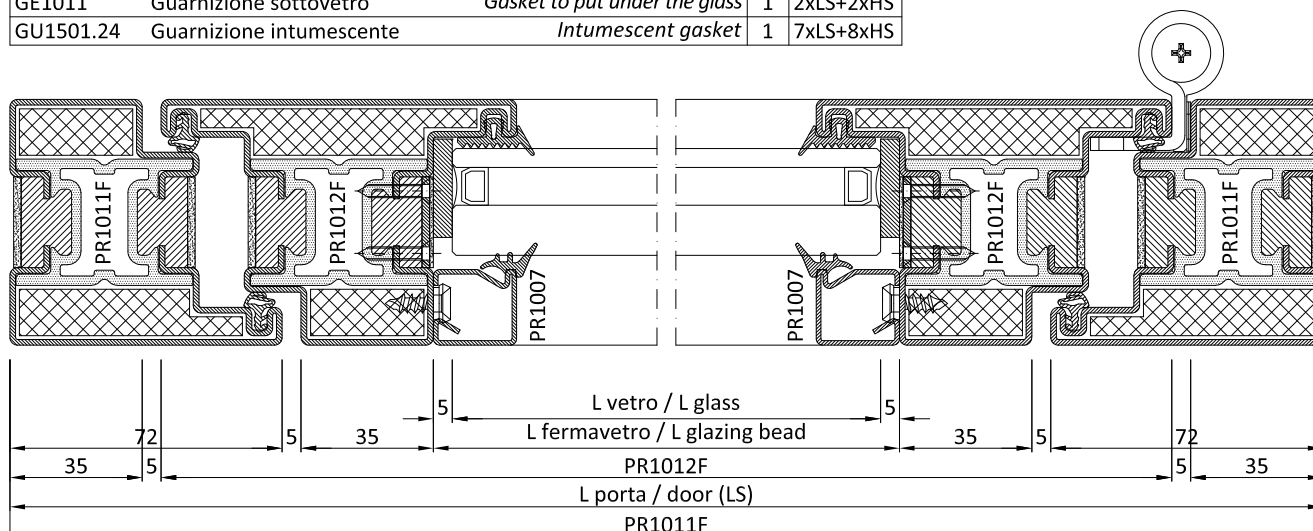
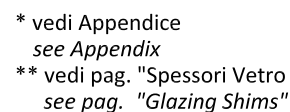
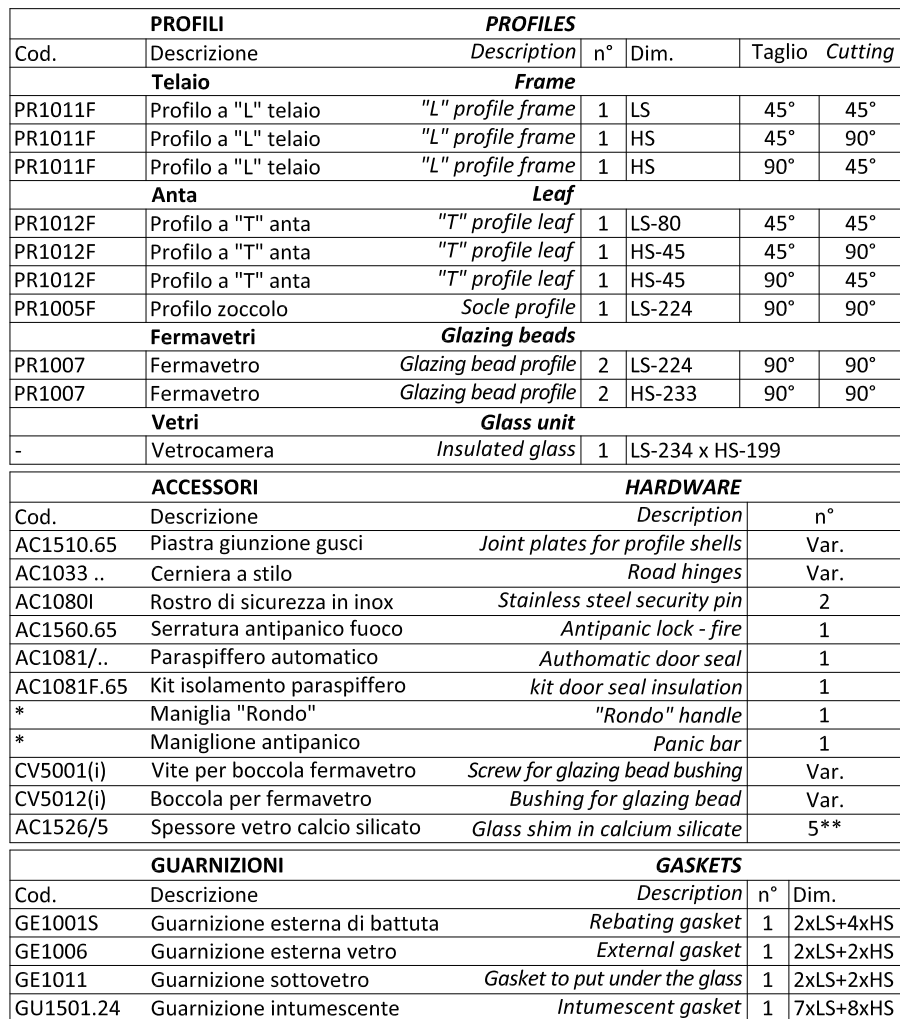
Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.

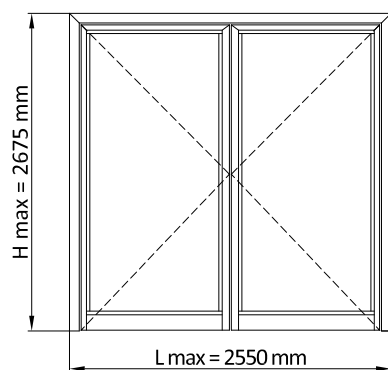
E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.

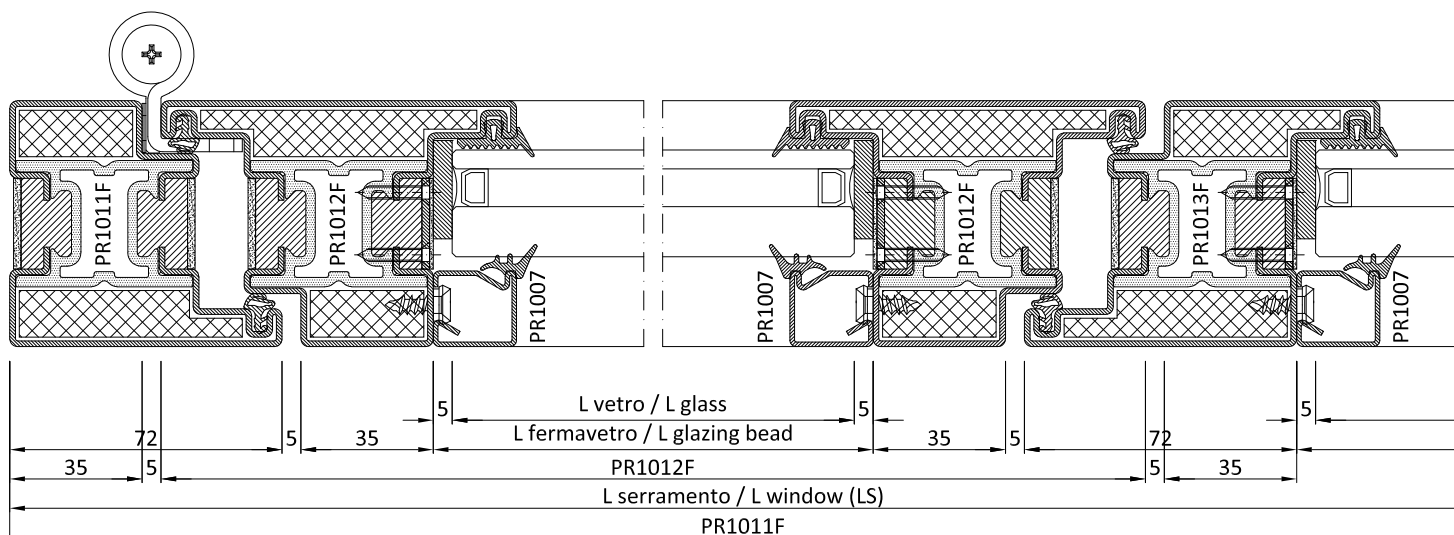
The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.



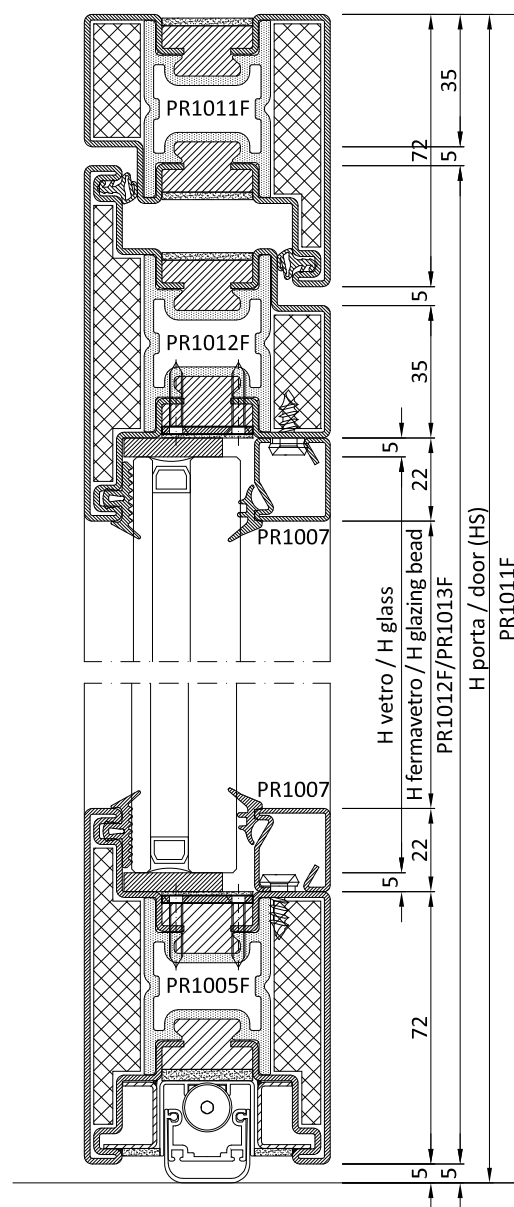




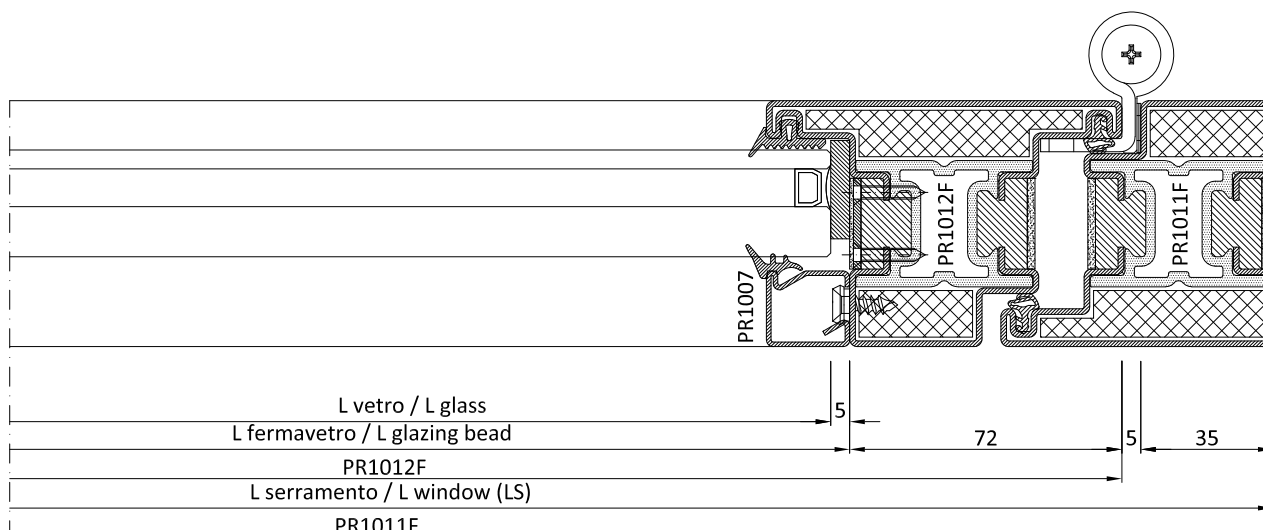
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR1011F	Profilo a "L" telaio	"L" profile frame	1	LS	45°	45°
PR1011F	Profilo a "L" telaio	"L" profile frame	1	HS	45°	90°
PR1011F	Profilo a "L" telaio	"L" profile frame	1	HS	90°	45°
Anta		Leaf				
PR1012F	Profilo a "T" anta	"T" profile leaf	2	(LS-48)/2	45°	45°
PR1012F	Profilo a "T" anta	"T" profile leaf	2	HS-45	45°	90°
PR1012F	Profilo a "T" anta	"T" profile leaf	1	HS-45	90°	45°
PR1013F	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	90°	45°
PR1005F	Profilo zoccolo	Socle profile	2	(LS-336)/2	90°	90°
Fermavetri		Glazing beads				
PR1007	Fermavetro	Glazing bead profile	4	(LS-336)/2	90°	90°
PR1007	Fermavetro	Glazing bead profile	4	HS-233	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	(LS-356)/2 x HS-199		

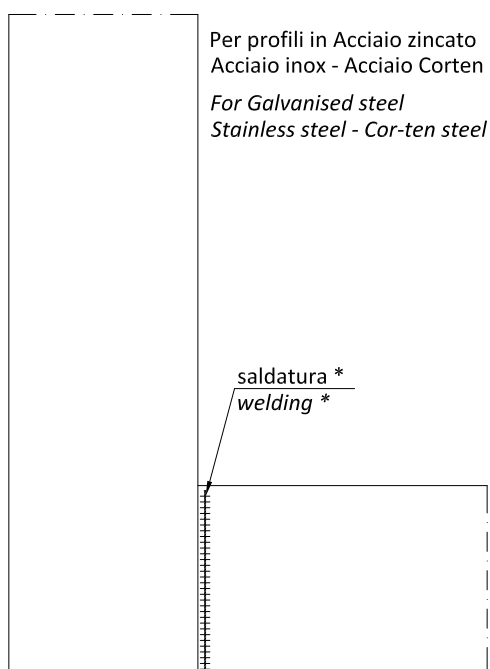
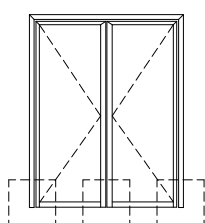
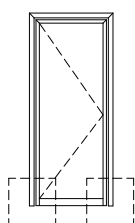
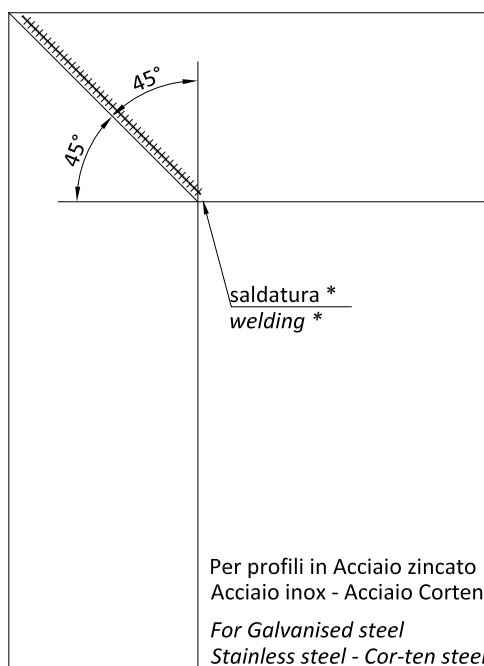
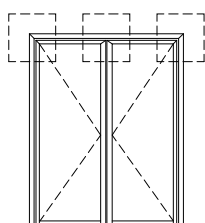
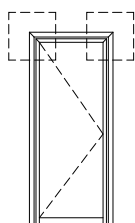


GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001S	Guarnizione esterna di battuta	<i>Rebating gasket</i>	1 2xLS+6xHS
GE1006	Guarnizione esterna vetro	<i>External gasket</i>	1 2xLS+4xHS
GE1011	Guarnizione sottovetro	<i>Gasket to put under the glass</i>	1 2xLS+4xHS
GU1501.24	Guarnizione intumescente	<i>Intumescent gasket</i>	1 7xLS+12xHS



** vedi pag. "Spessori Vetro"
see pag. "Glazing Shims"

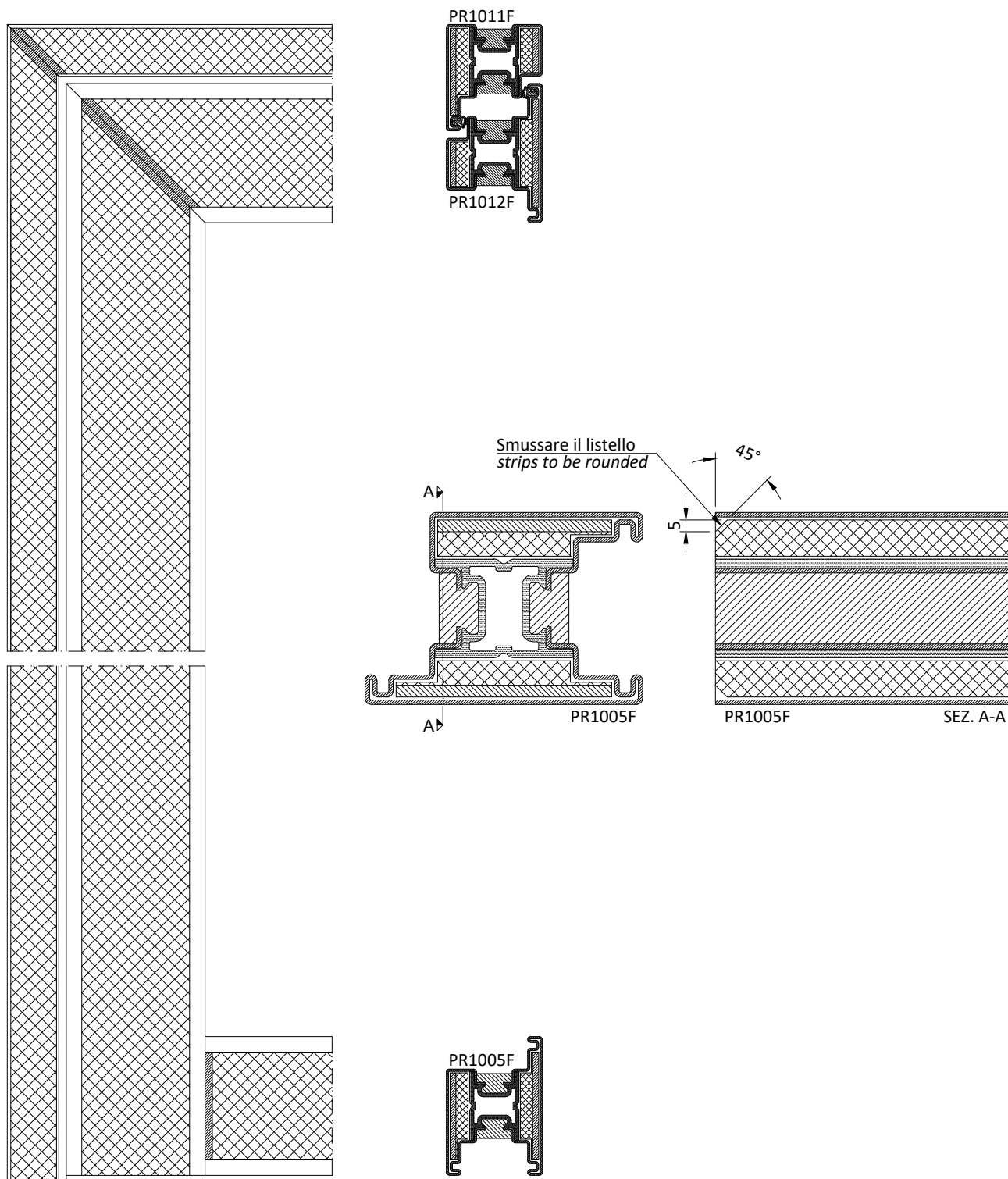


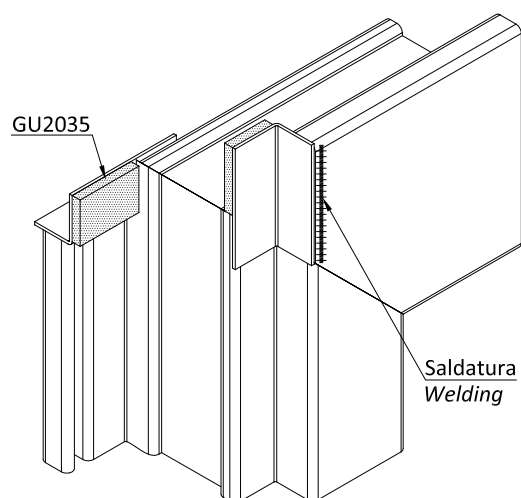
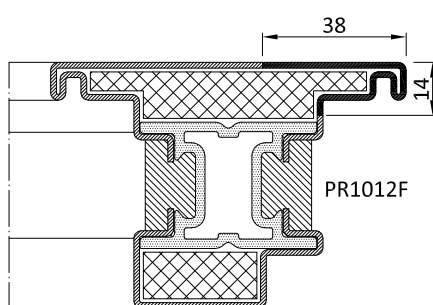
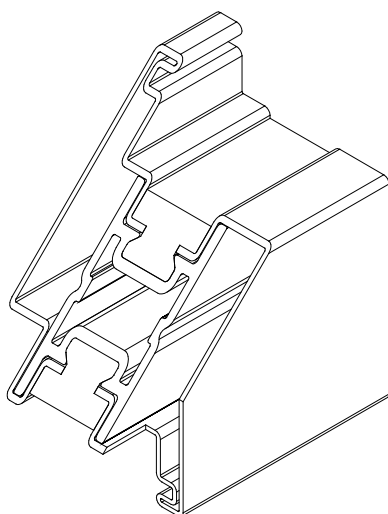
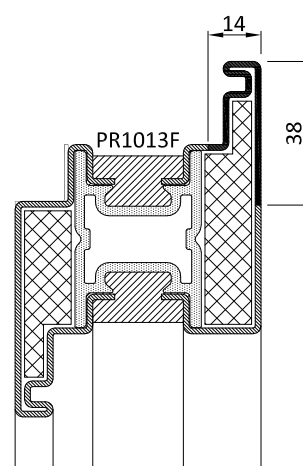
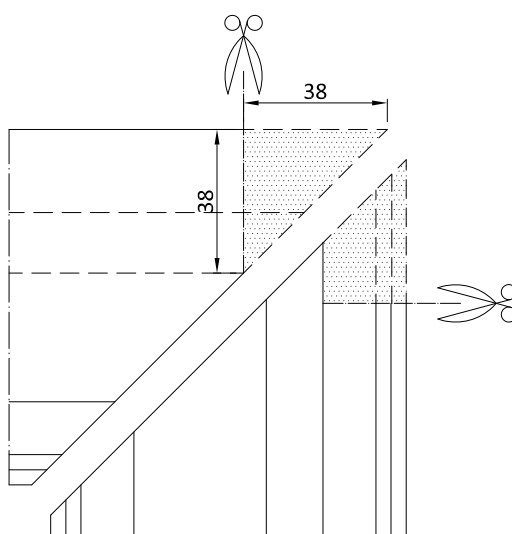
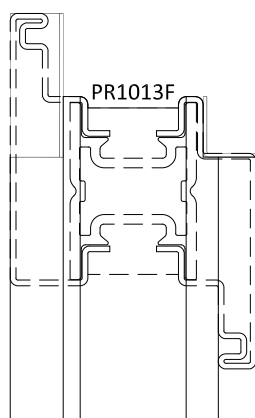
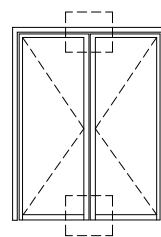
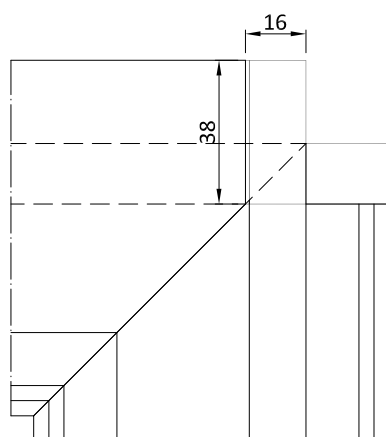
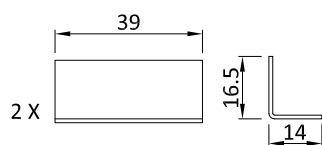


* per le raccomandazioni sulla saldatura si rimanda alla sezione 5.1.1
* for the welding recommendations please refer to the section 5.1.1

Tagliare il listello intumescente a 45° (vedi sezione A-A) in corrispondenza delle giunzioni dei profili per non interferire con la procedura di saldatura del giunto

Strips to be cutted at 45° (see section A-A) on profiles joints in order to do not interfere with the joint welding procedure



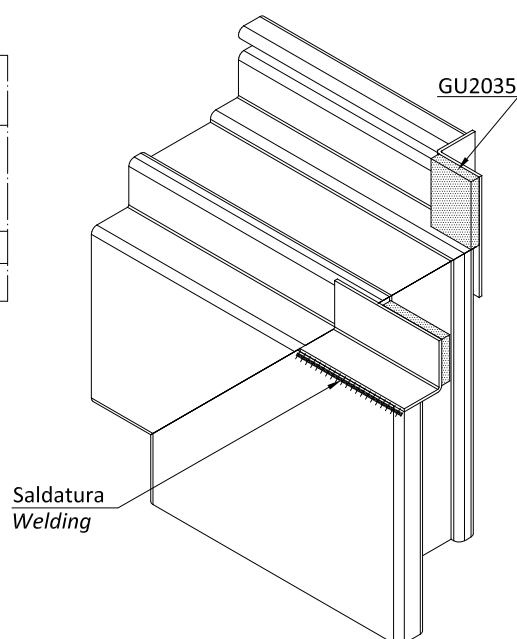
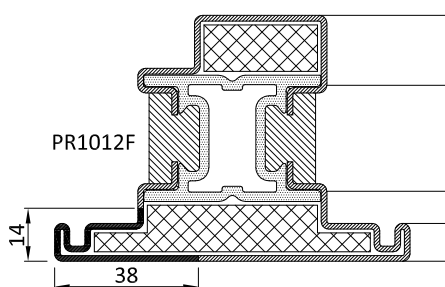
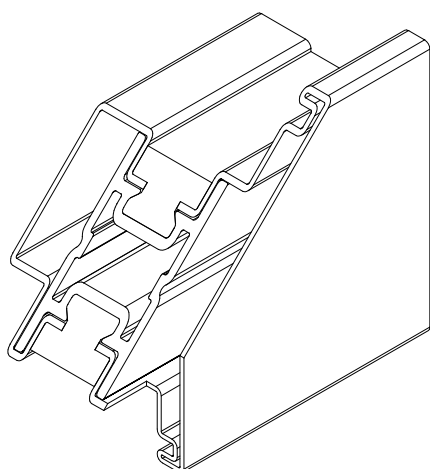
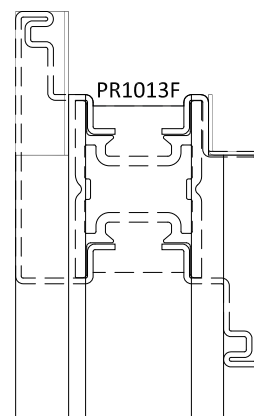
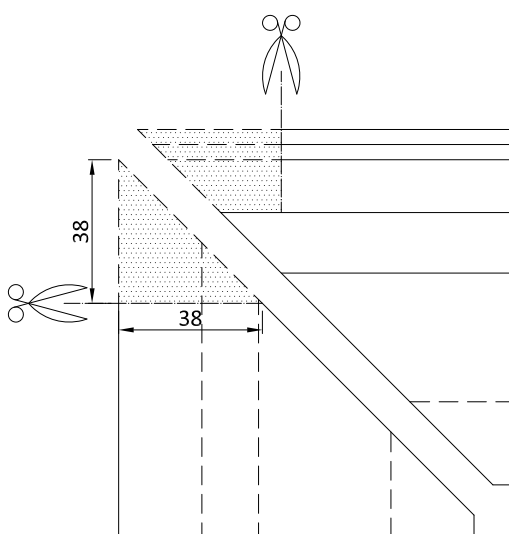
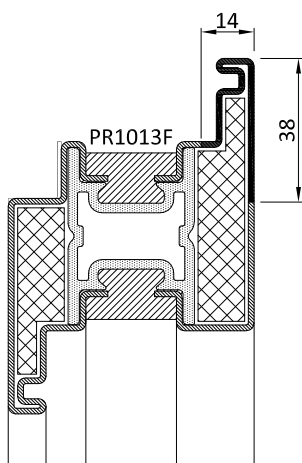
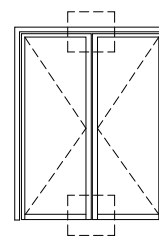
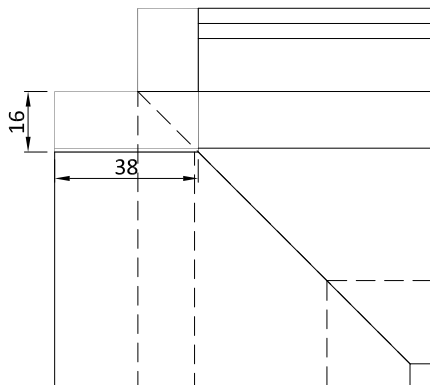
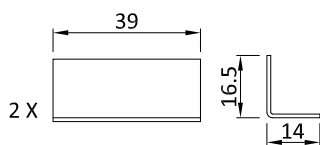


Nota: Saldare e sigillare l'accessorio secondo la tipologia e la mano di apertura

Note: Weld and seal the AC1014 according to the typology and the opening

Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura

Note: Ending caps are provided in larger dimensions. They have to be trimmed after welding

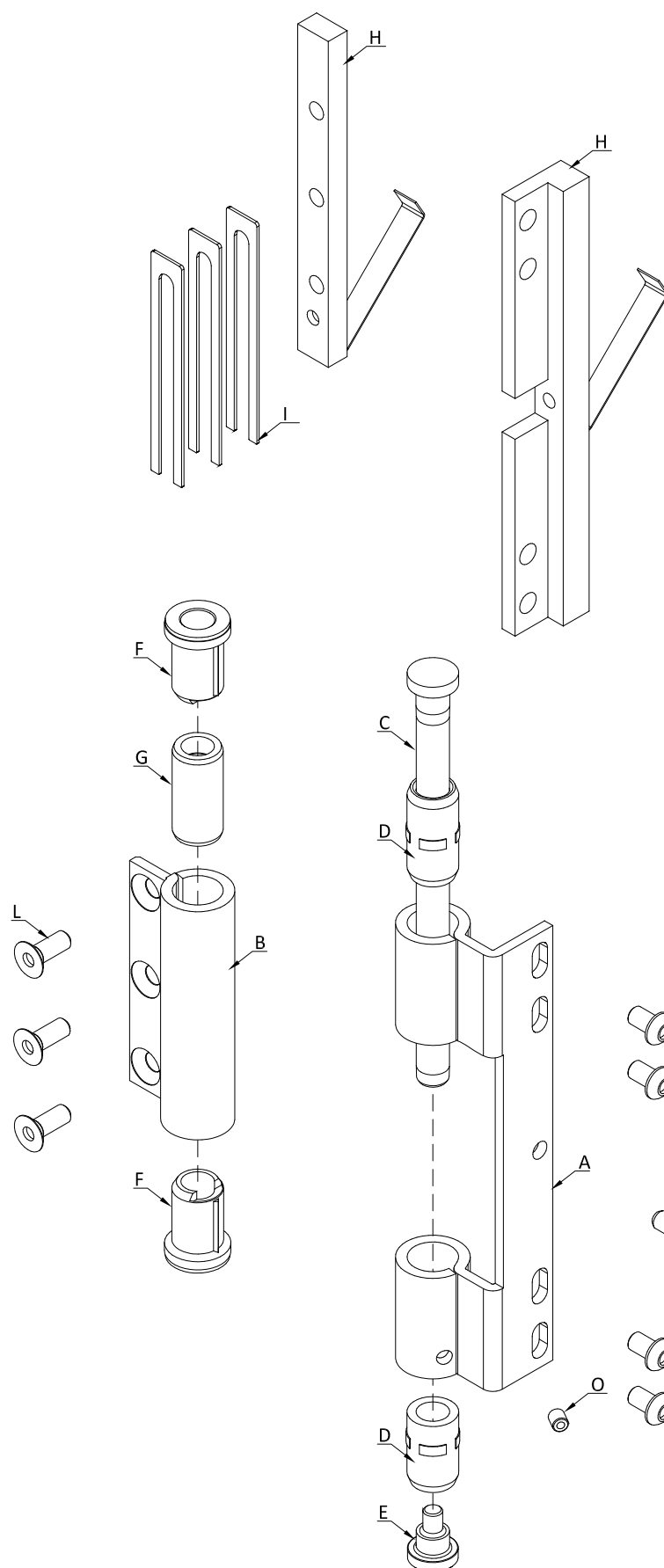


Nota: Saldare e sigillare l'accessorio secondo la tipologia e la mano di apertura

Note: Weld and seal the AC1014 according to the typology and the opening

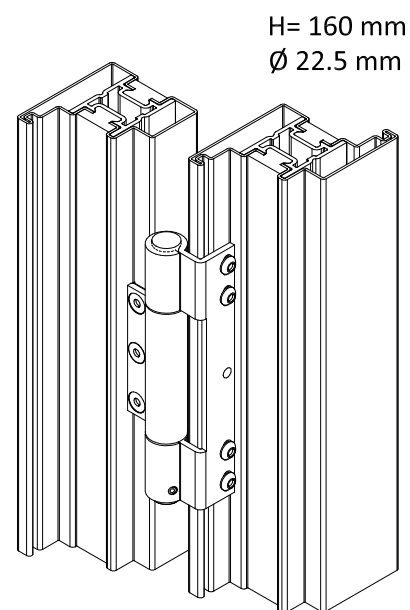
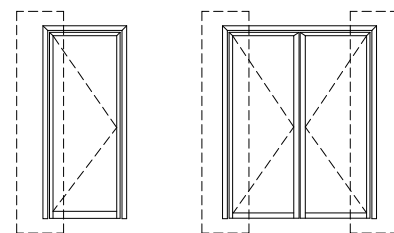
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura

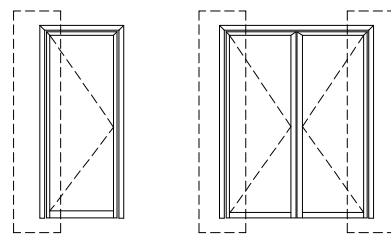
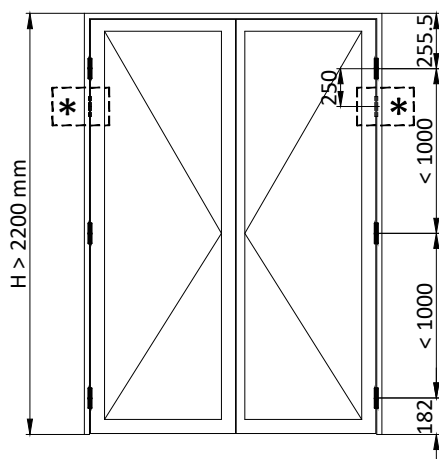
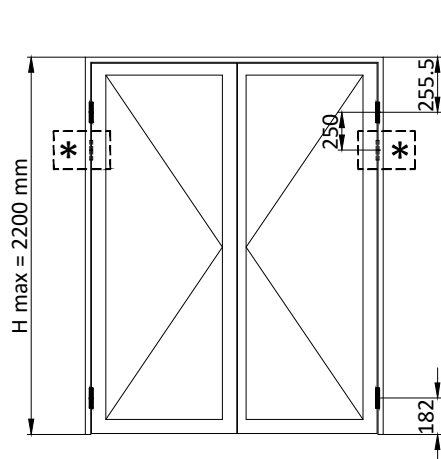
Note: Ending caps are provided in larger dimensions. They have to be trimmed after welding



- A) Corpo cerniera A
B) Corpo cerniera B
C) Perno
D) Distanziatore
E) Tappo a vite
F) Boccola antifrizione
G) Distanziatore
H) Rinforzi interni
I) Distanziale di regolazione
L) Viti acciaio inox TSPEI M6 x 16
M) Vite acciaio inox testa a bottone M6 x 10
N) Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
O) Grano M5 x 6

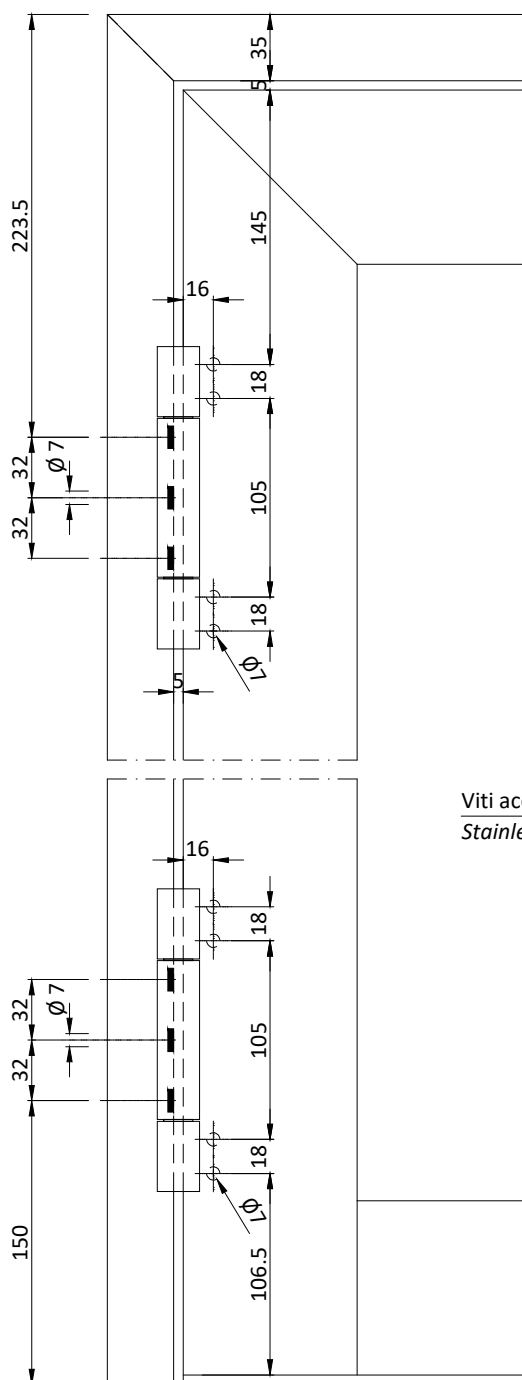
- A) Body of the hinge A
B) Body of the hinge B
C) Pin
D) Spacer
E) Screw cap
F) Antifriction bushing
G) Spacer
H) Internal reinforcements
I) Regulating spacer
L) Stainless steel screws TSPEI M6 x 16
M) Stainless steel button head screws M6 x 10
N) Stainless steel pin Ø 6 x 10 to insert after regulating the leaf
O) Dowel M5x6



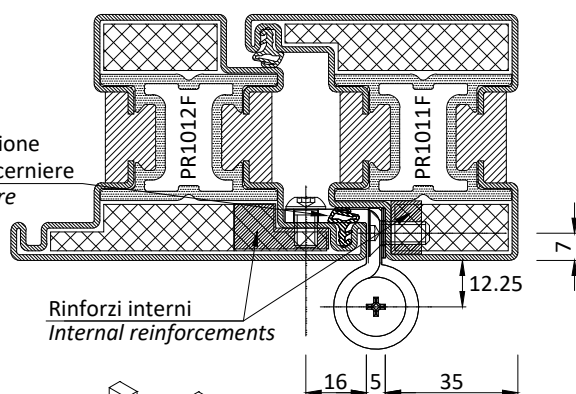


Peso max. per anta 160 kg
Max. weight for leaf: 160 kg

* Cerniera aggiuntiva per peso anta
> di 160 kg - peso max 200 kg
Additional hinge for weight of leaf
> di 160 kg - max 200 kg



GE1001TT - tagliare la guarnizione
dove interseca le cerniere
GE1001TT - cut the gasket where
the hinges cross



Rinforzi interni
Internal reinforcements

Distanziale di regolazione
Regulating spacer

Rinforzi interni
Internal reinforcements

Vite acciaio inox testa a
bottone M6 x 10
Stainless steel button
head screws M6 x 10

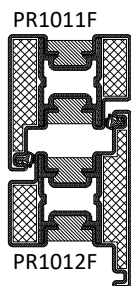
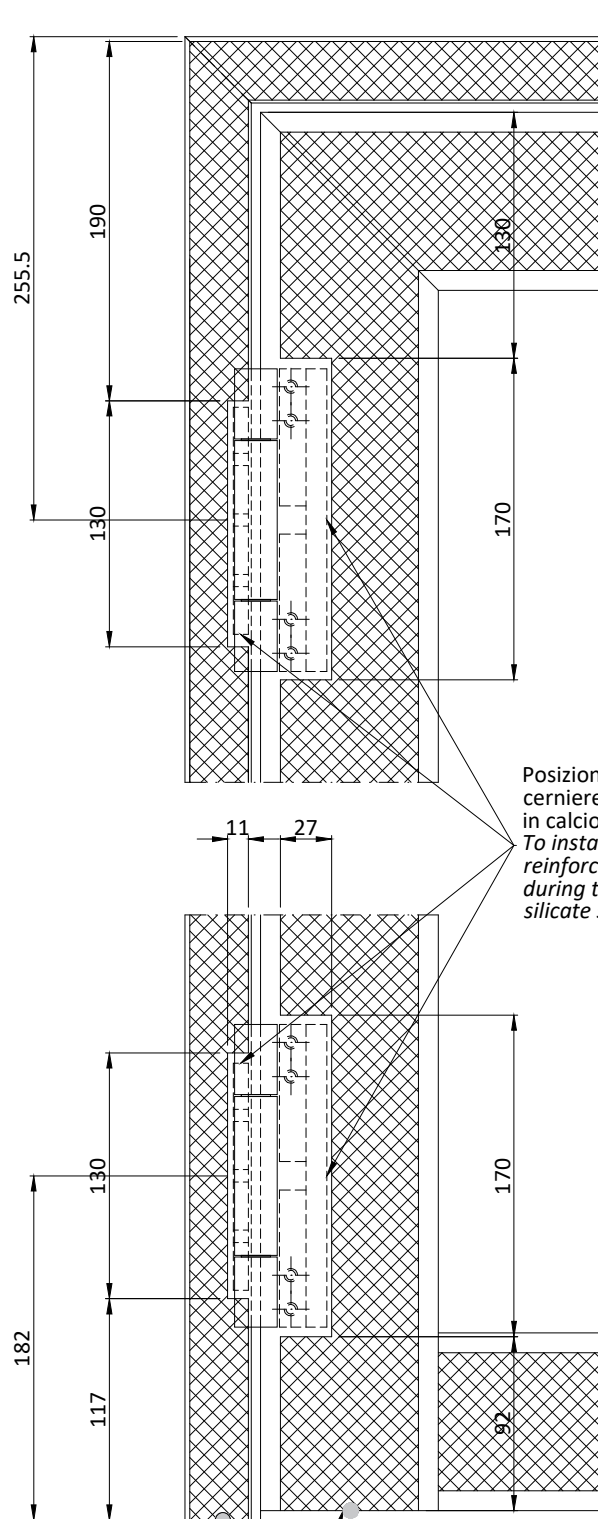
Viti acciaio inox TSPEI M6 x 16
Stainless steel screws TSPEI M6 x 16

Spina inox $\varnothing 6 \times 10$
da inserire dopo la
regolazione dell'anta
Stainless steel pin $\varnothing 6 \times 10$
to insert after regulating
the leaf

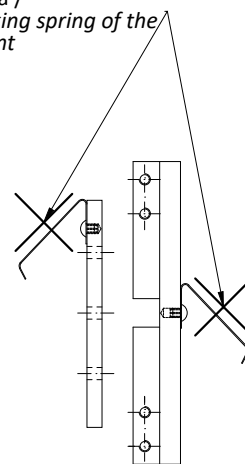
± 1 mm

± 3 mm

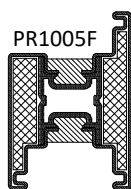
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.
- Tooling can be done also on external opening.



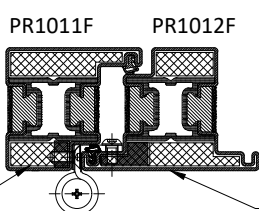
Rimuovere le molle di bloccaggio
dei rinforzi cerniera /
To remove the locking spring of the
hinge reinforcement



Posizionare i rinforzi interni delle
cerniere all'inserimento del listello
in calcio silicato /
To install the internal
reinforcements of the hinges
during the inserting of the calcium
silicate strips

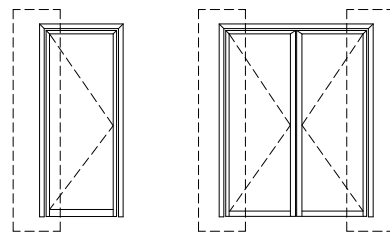
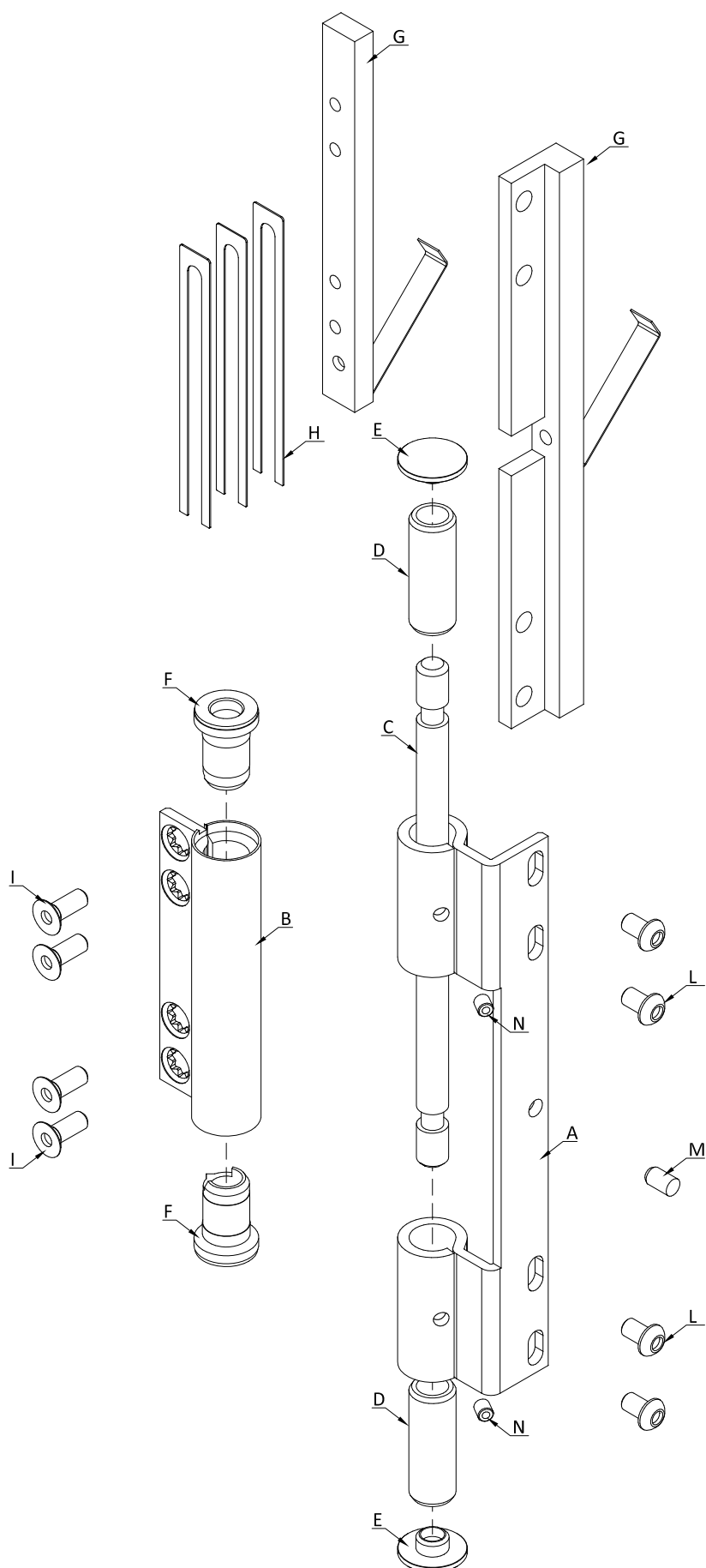


Fissare i listelli al profilo con collante a freddo resistente al fuoco
Strips to be fixed on profile with a cold glue fire resistant



Tipo/Type D per/for PR1611F
Tipo/Type E per/for PR1613F

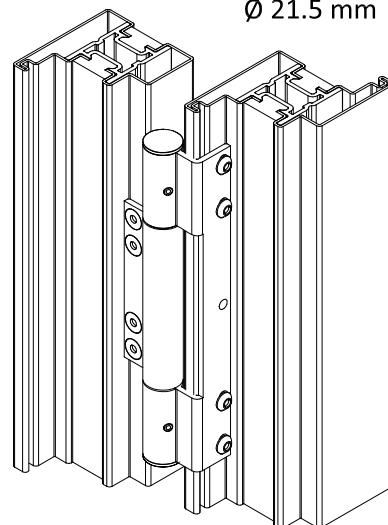
Tipo/Type C

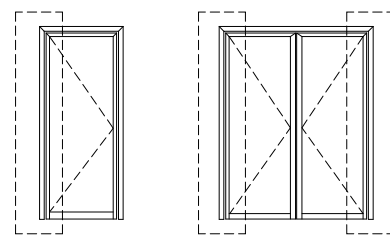
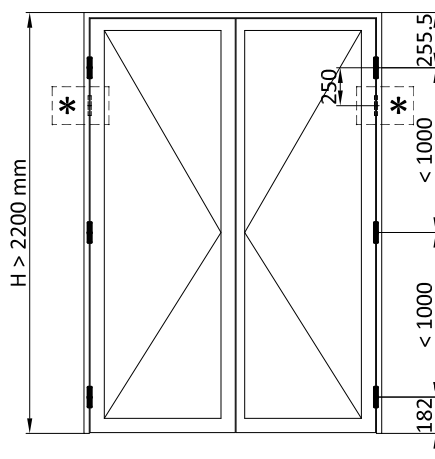


- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Distanziatore
- E) Tappo di finitura
- F) Boccola antifrizione
- G) Rinforzi interni
- H) Distanziale di regolazione
- I) Viti acciaio inox TSPEI M6 x 16
- L) Vite acciaio inox testa a bottone M6 x 10
- M) Spina inox $\varnothing 6 \times 10$ da inserire dopo la regolazione dell'anta
- N) Grano M5 x 6

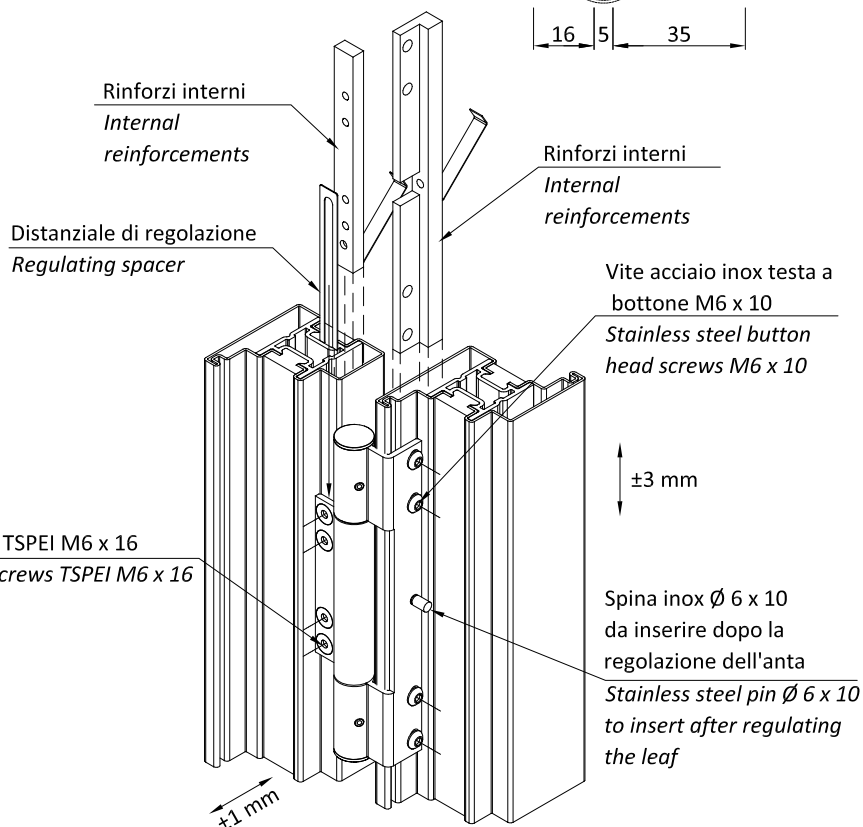
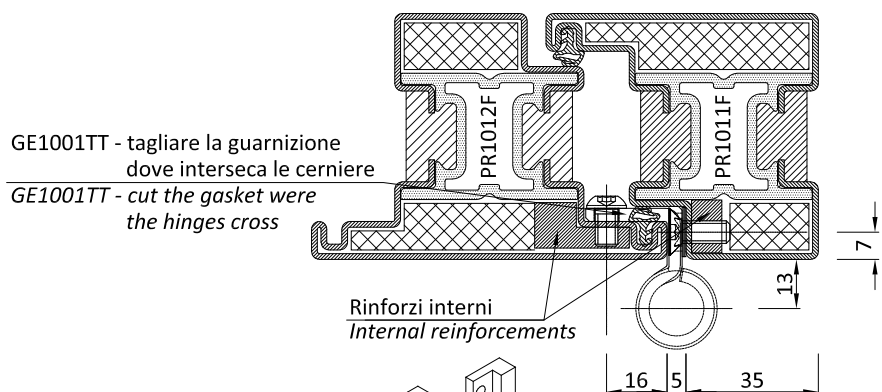
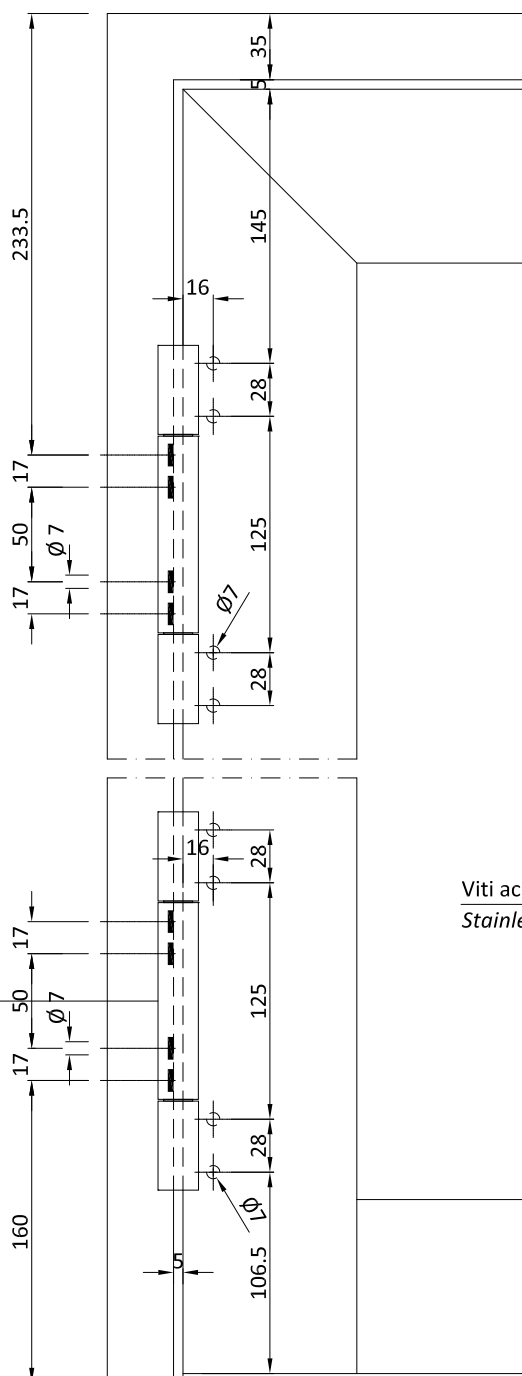
- A) Body of the hinge A
- B) Body of the hinge B
- C) Pin
- D) Spacer
- E) Ending cap
- F) Antifriction bushing
- G) Internal reinforcements
- H) Regulating spacer
- I) Stainless steel screws TSPEI M6 x 16
- L) Stainless steel button head screws M6 x 10
- M) Stainless steel pin $\varnothing 6 \times 10$ to insert after regulating the leaf
- N) Dowel M5x6

H= 204 mm
 $\varnothing 21.5$ mm

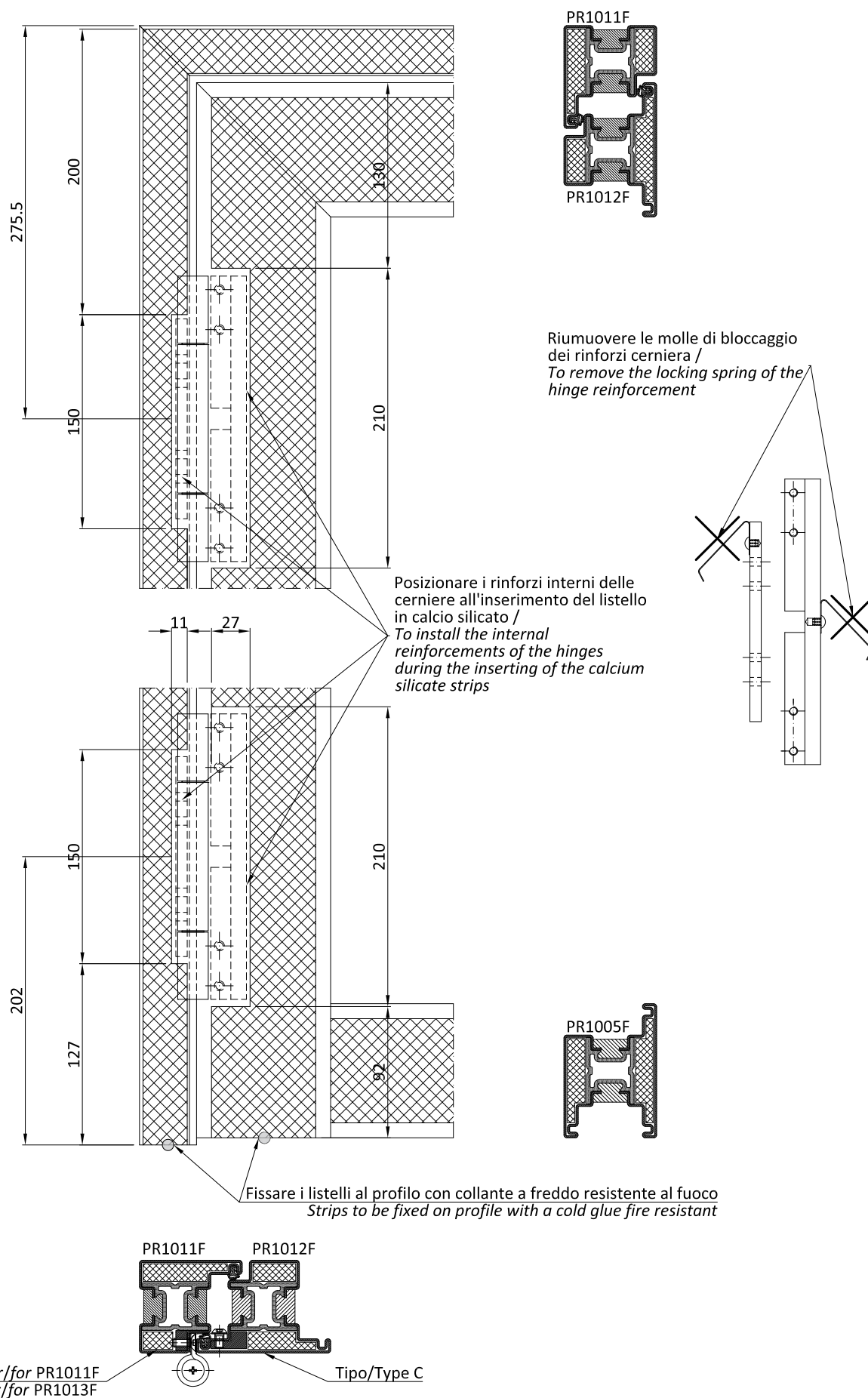


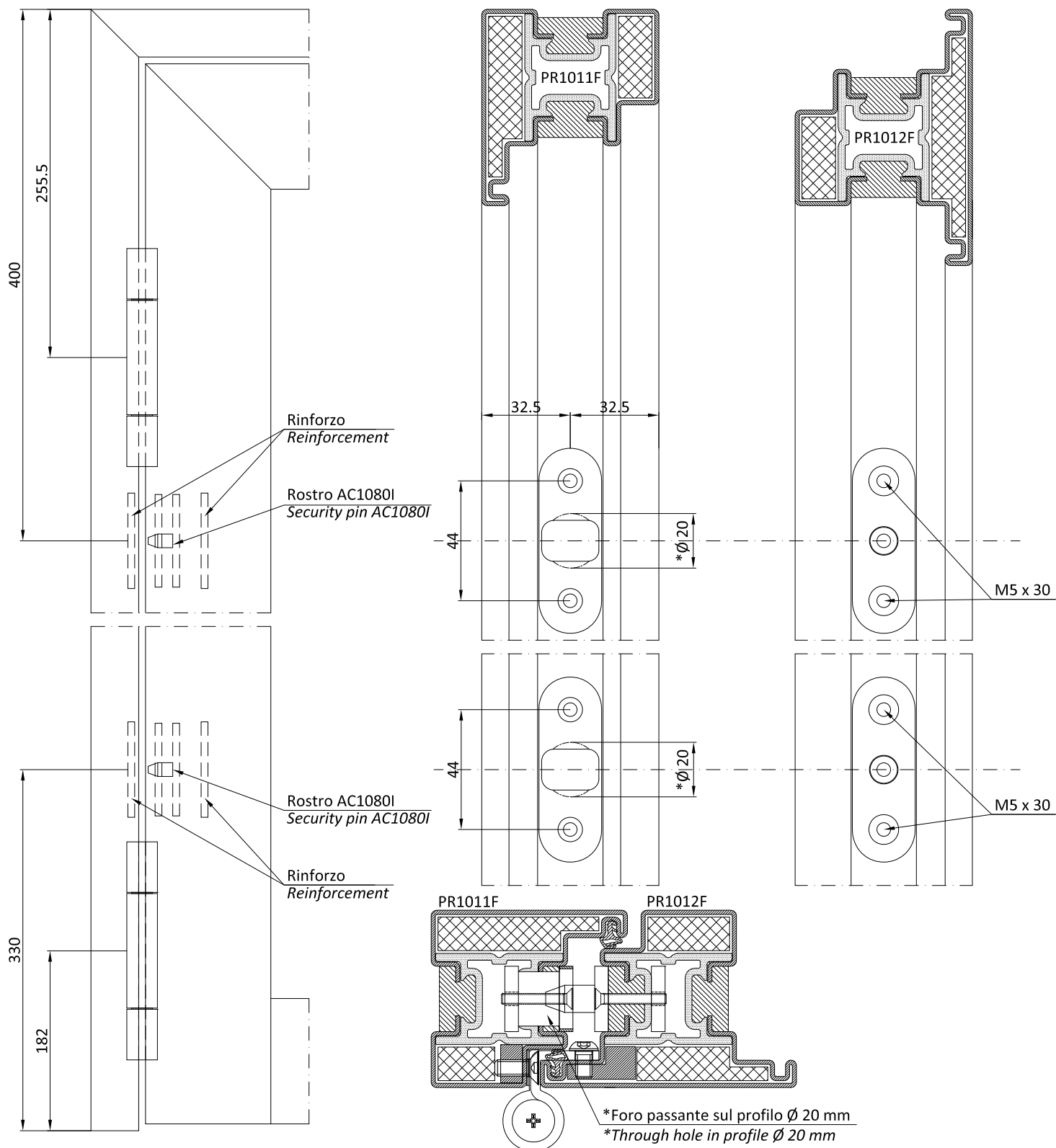
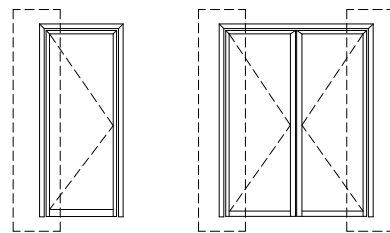
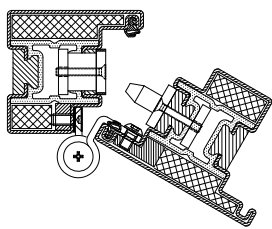


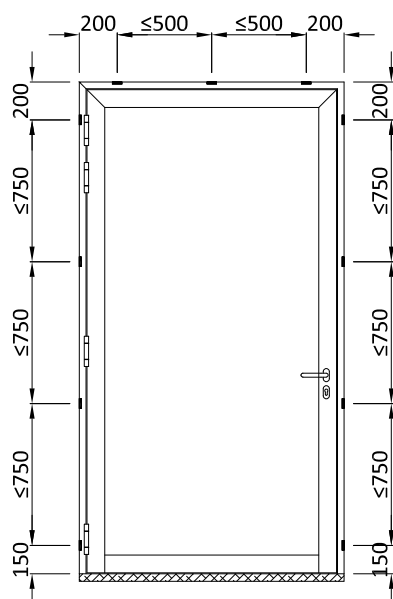
* Cerniera aggiuntiva per peso anta
> di 250 kg - peso max 300 kg
Additional hinge for weight of leaf
> di 250 kg - max 300 kg



- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- *Tooling can also be carried out in intermediate positions.*
- *Tooling is the same on the right and on the left.*
- *Tooling can be done also on external opening.*

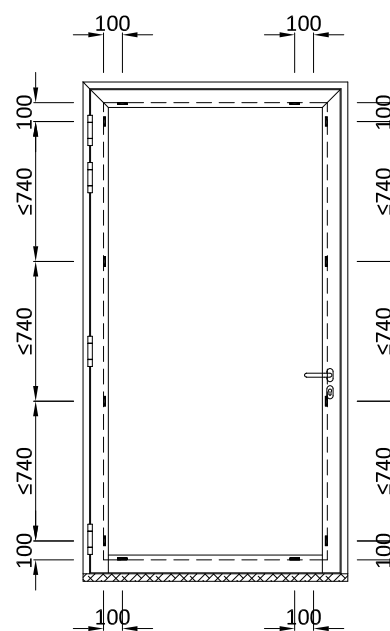






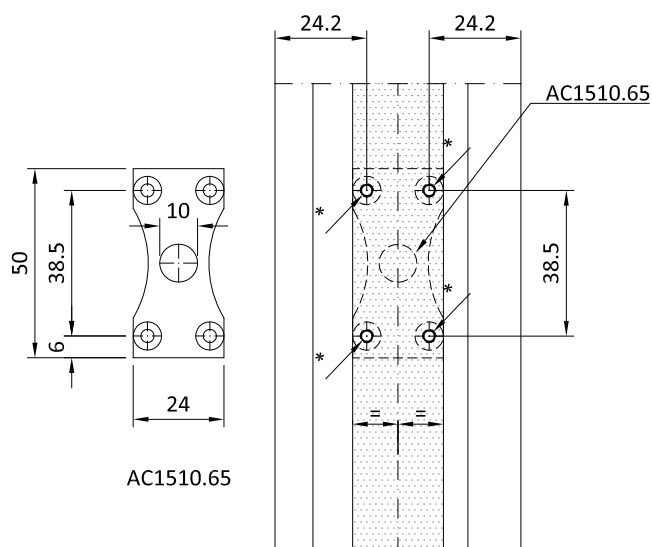
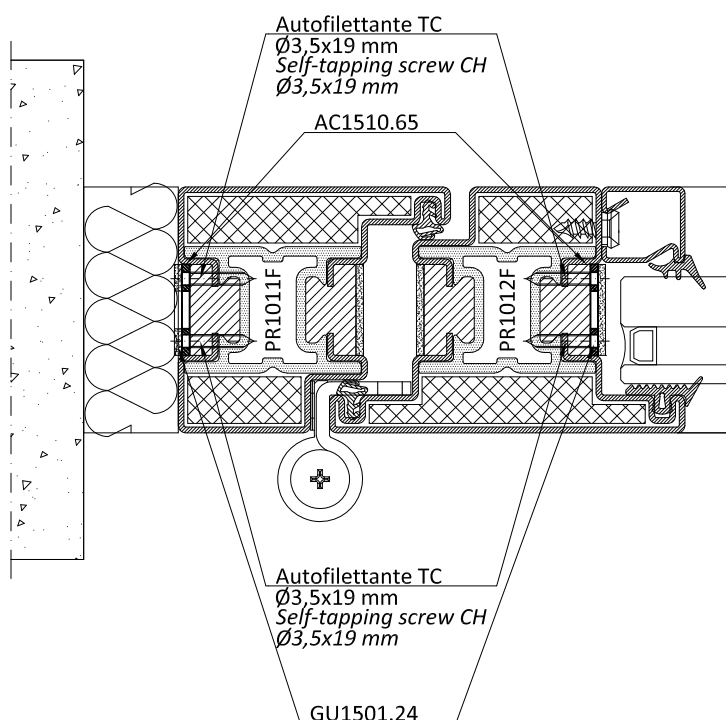
- ❶ Piastrina collegamento AC1510.65 su esterno telaio in corrispondenza dei fori di fissaggio a muro

AC1510.65 joint plate to be fixed on the external side of the door frame at door fixing hole location



- ❷ Piastrina collegamento AC1510.65 su interno anta

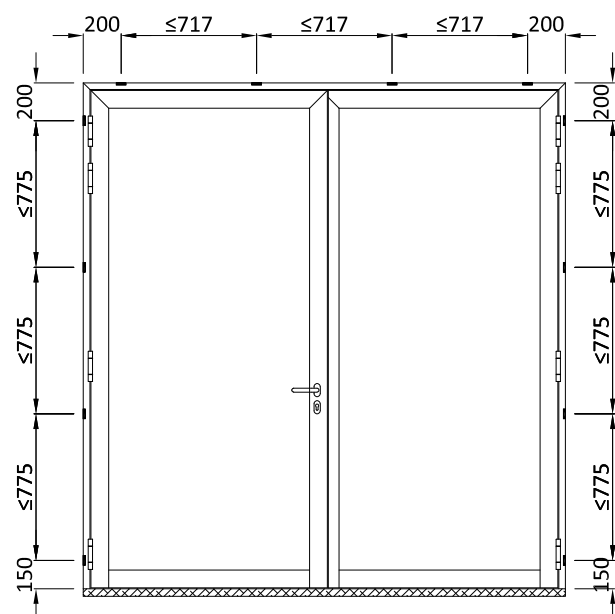
AC1510.65 joint plate to be fixed on the internal side of the door leaf



dimensioni porta / door dimension	quantità totale piastrine / total quantity of plates
1400 x 2600 mm	23**

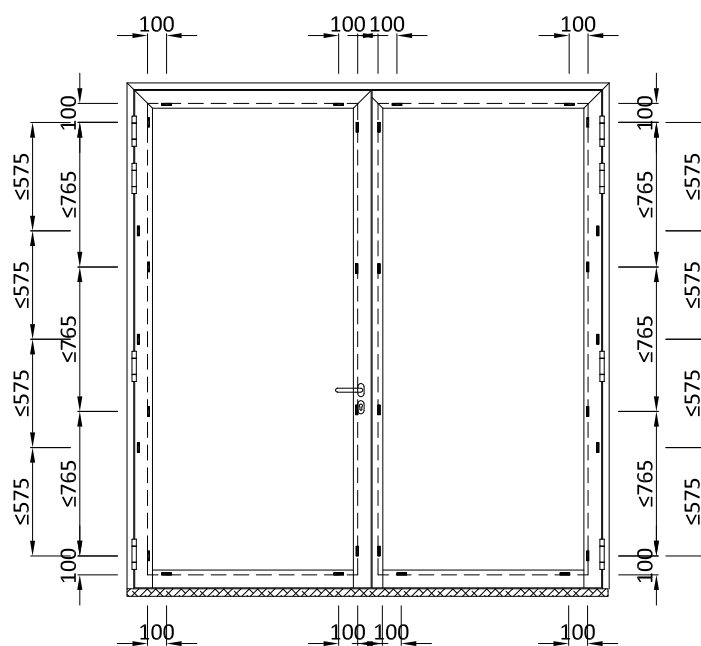
** numero variabile in funzione del tipo di fissaggio a muro
variable number due to the type of wall fixing

* preforare profilo con fori diametro 3 mm utilizzando AT1510.65 / to drill profile with hole diameter 3 mm by using AT1510.65



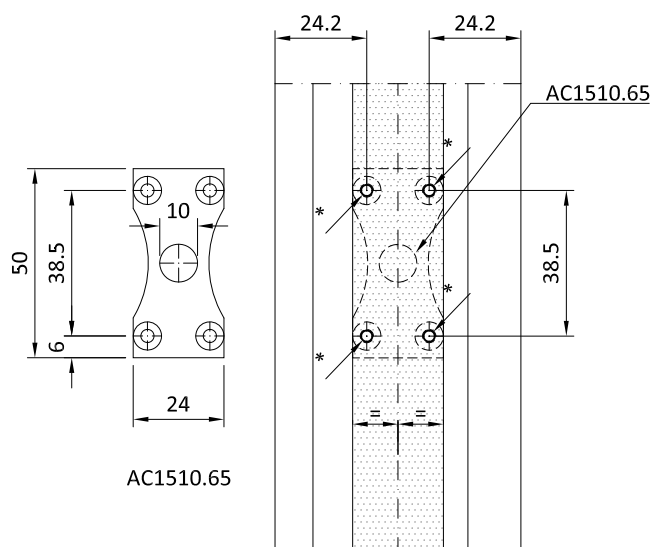
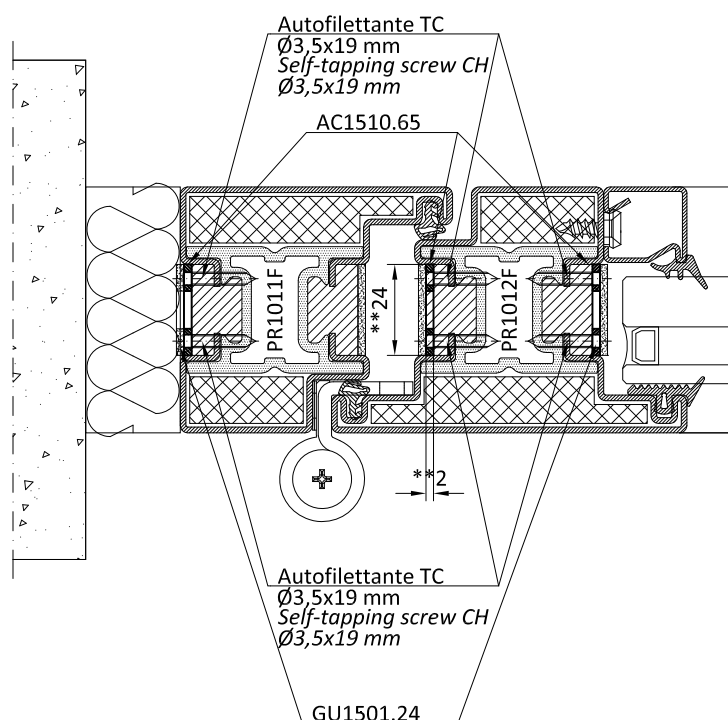
- ❶ Piastrina collegamento AC1510.65 su esterno telaio in corrispondenza dei fori di fissaggio a muro

AC1510.65 joint plate to be fixed on the external side of the door frame at door fixing hole location



- ❶ Piastrina collegamento AC1510.65 su interno ed esterno anta

AC1510.65 joint plate to be fixed on the internal and external side of the door leaf

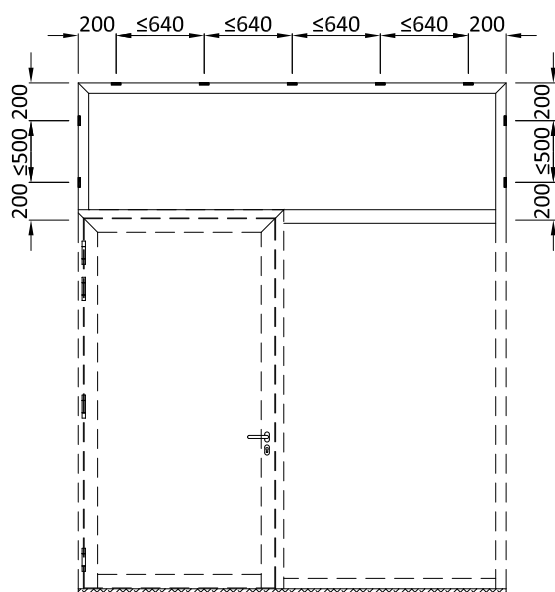


dimensioni porta / door dimension	quantità totale piastrine / total quantity of plates
2550 x 2675 mm	42***

*** numero variabile in funzione del tipo di fissaggio a muro
variable number due to the type of wall fixing

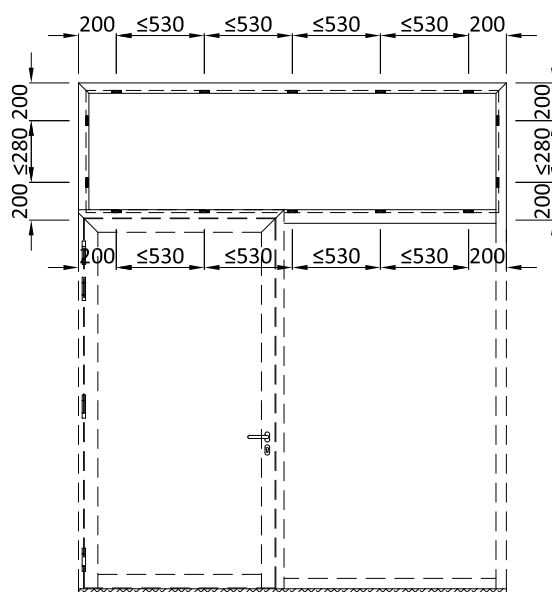
* preforare profilo con fori diametro 3 mm utilizzando AT1510.65 / to drill profile with hole diameter 3 mm by using AT1510.65

** fresare la resina resistente al fuoco tra i gusci del profilo per alloggiamento della piastrina AC1510.65
to mill the resin in between the steel shell of the profile to allow the installation of the plate AC1510.65



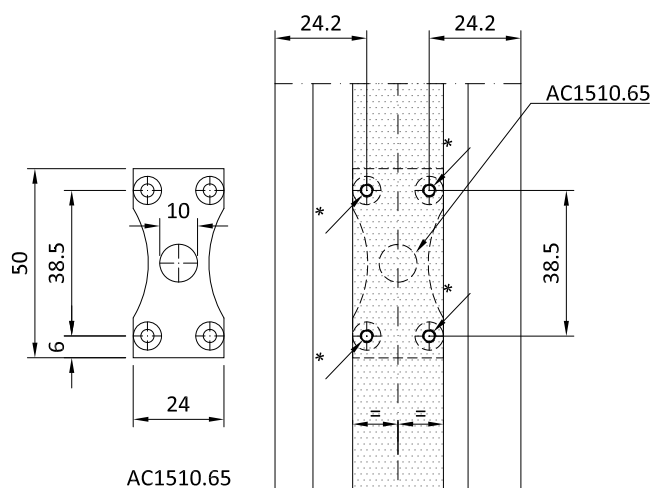
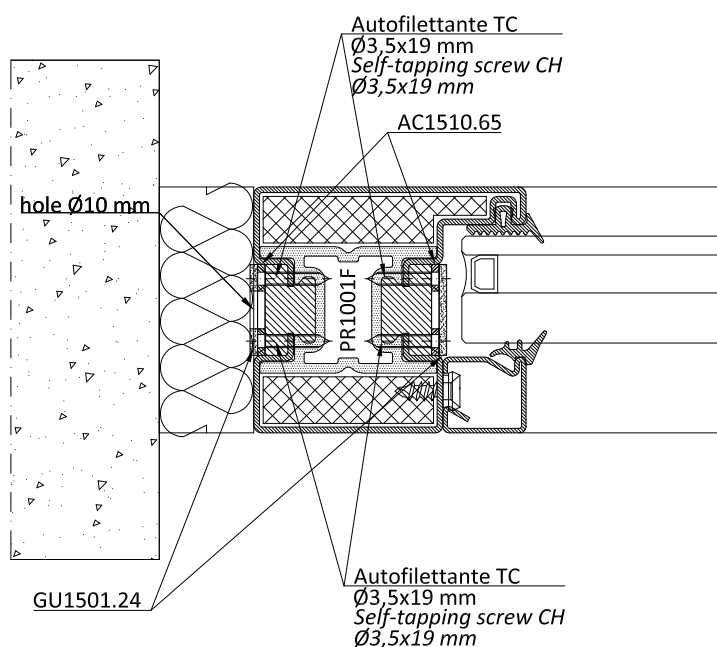
- ❶ Piastrina collegamento AC1510.65
su esterno telaio in corrispondenza
dei fori di fissaggio a muro

*AC1510.65 joint plate to be fixed
on the external side of the door
frame at door fixing hole location*



- ❶ Piastrina collegamento AC1510.65
su interno telaio

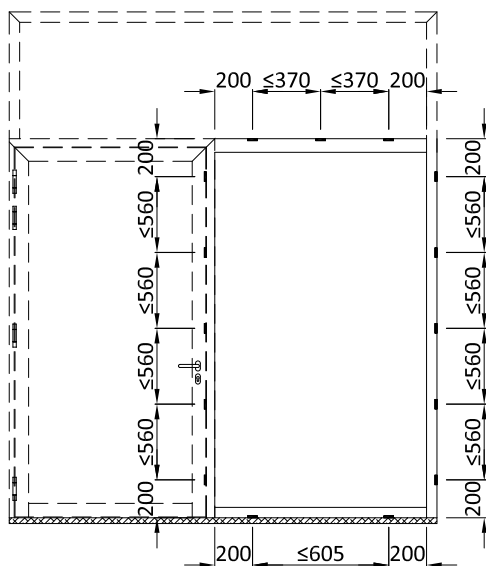
*AC1510.65 joint plate to be fixed on
the internal side of the frame profile*



dimensioni fisso sup./ dimension top light	quantità totale piastrine / total quantity of plates
2690 x 900 mm	23***

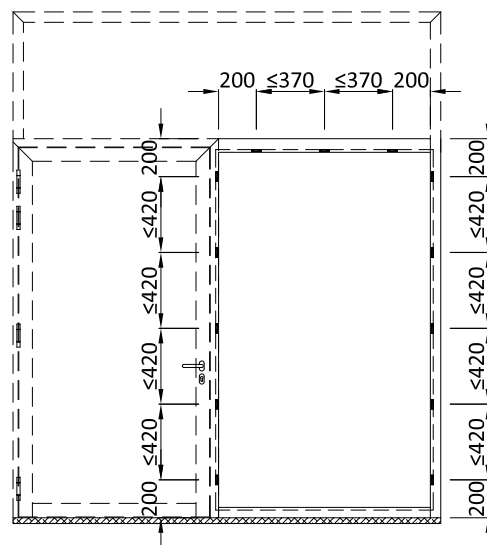
*** numero variabile in funzione del tipo di fissaggio a muro
variable number due to the type of wall fixing

* preforare profilo con fori diametro 3 mm utilizzando AT1510.65 / to drill profile with hole diameter 3 mm by using AT1510.65



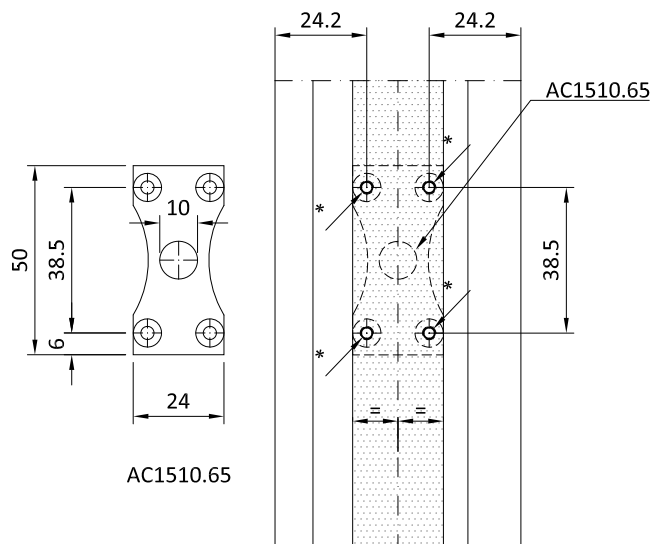
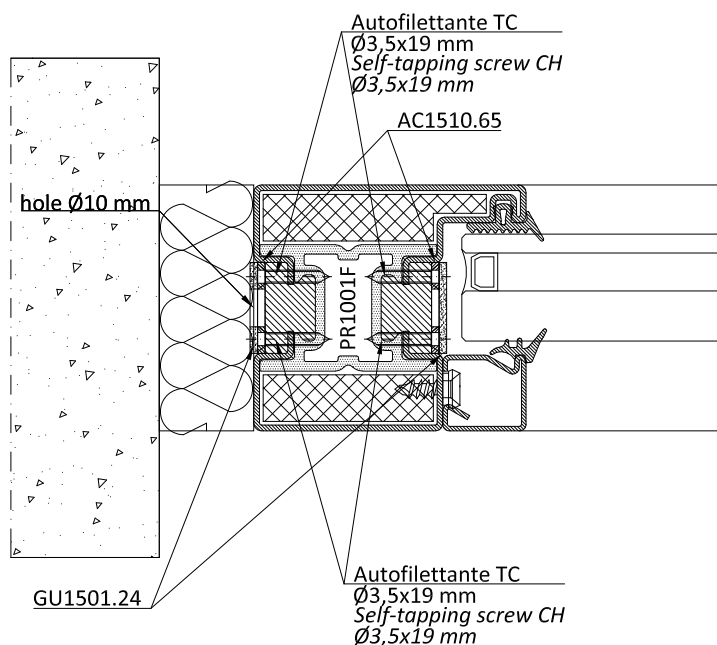
- ❶ Piastrina collegamento AC1510.65
su esterno telaio in corrispondenza
dei fori di fissaggio a muro

*AC1510.65 joint plate to be fixed
on the external side of the door
frame at door fixing hole location*



- ❶ Piastrina collegamento AC1510.65
su interno telaio

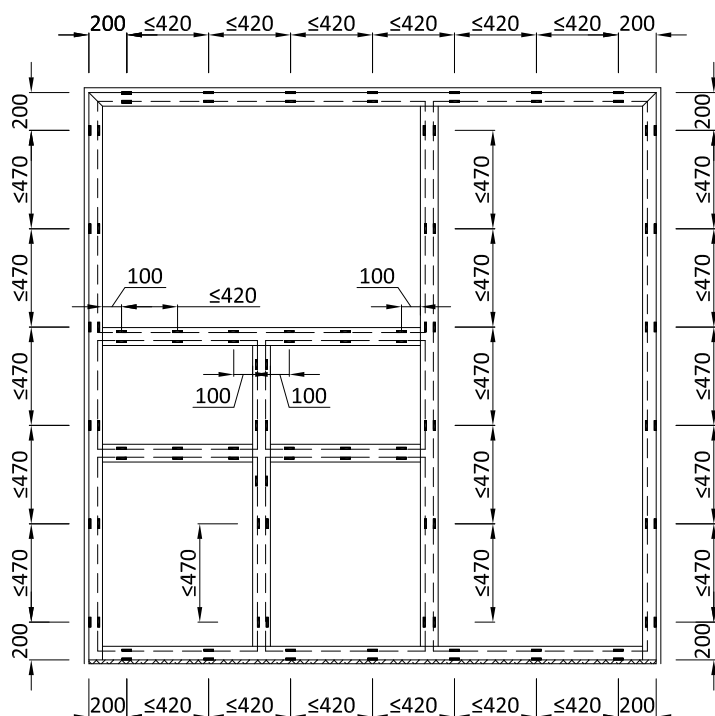
*AC1510.65 joint plate to be fixed on
the internal side of the frame profile*



dimensioni fisso lat./ dimension side light	quantità totale piastrine / total quantity of plates
1560 x 2675 mm	28***

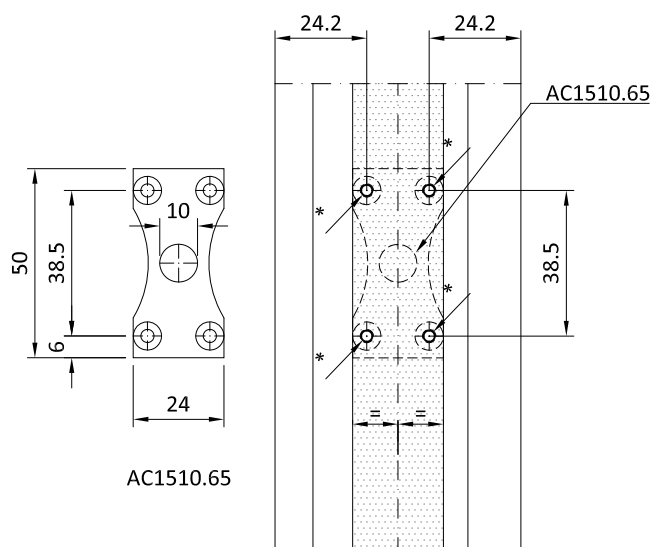
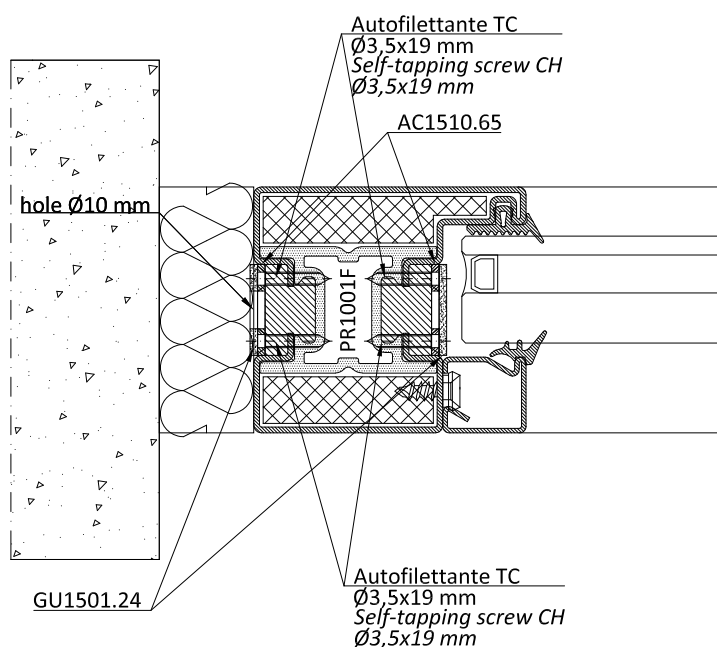
*** numero variabile in funzione del tipo di fissaggio a muro
variable number due to the type of wall fixing

* preforare profilo con fori diametro 3 mm utilizzando AT1510.65 / to drill profile with hole diameter 3 mm by using AT1510.65



- ❶ Piastrina collegamento AC1510.65
su interno ed esterno profilo telaio

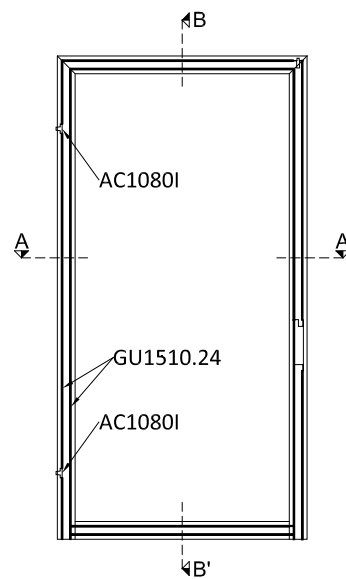
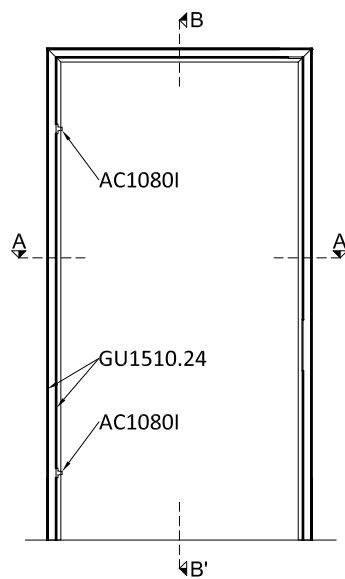
*AC1510.65 joint plate to be fixed on
the internal and external side of the
frame profile*



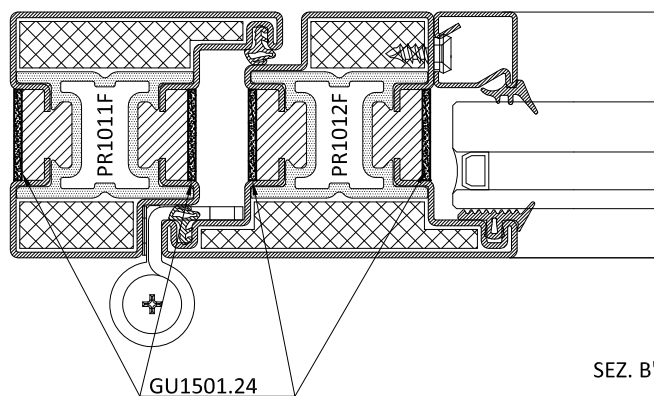
dimensioni fisso lat./ dimension side light	quantità totale piastine / total quantity of plates
1560 x 2675 mm	28***

*** numero variabile in funzione del tipo di fissaggio a muro
variable number due to the type of wall fixing

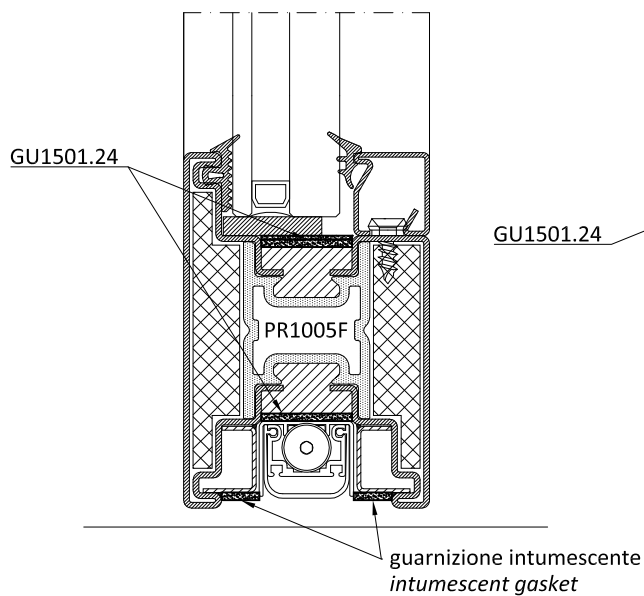
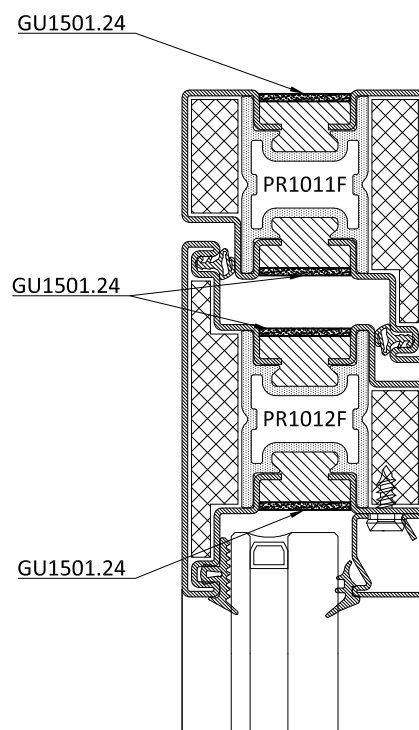
* preforare profilo con fori diametro 3 mm utilizzando AT1510.65 / to drill profile with hole diameter 3 mm by using AT1510.65

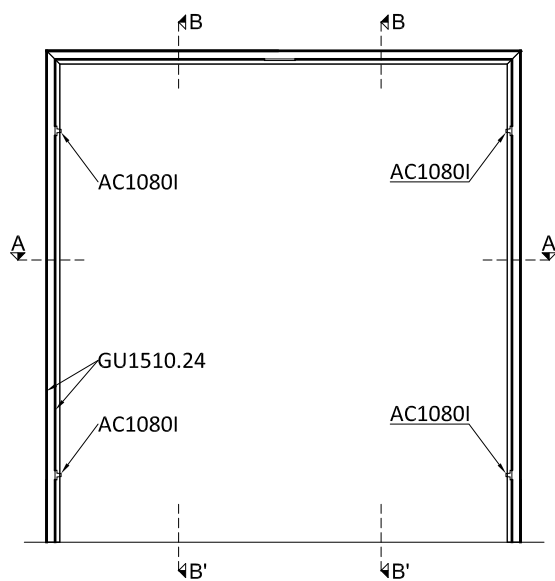


SEZ. A-A

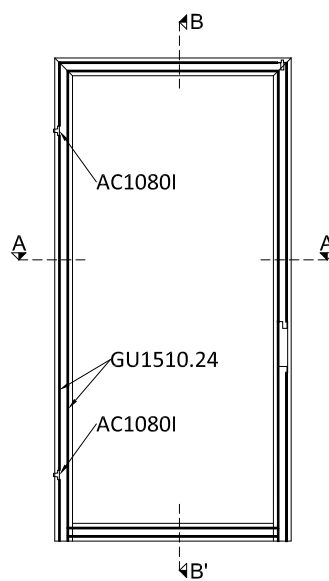


SEZ. B-B

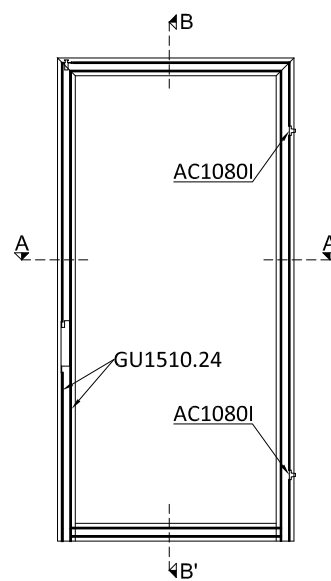




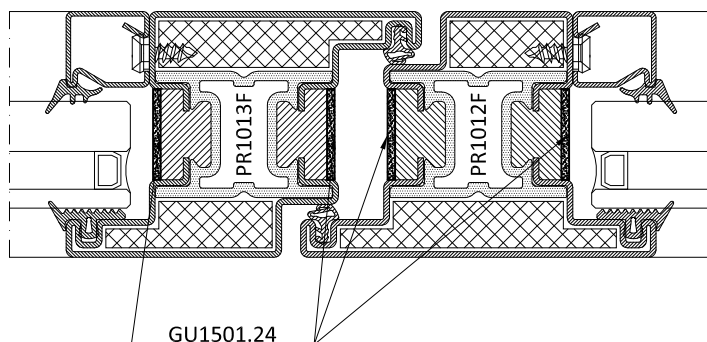
TELAIO/FRAME



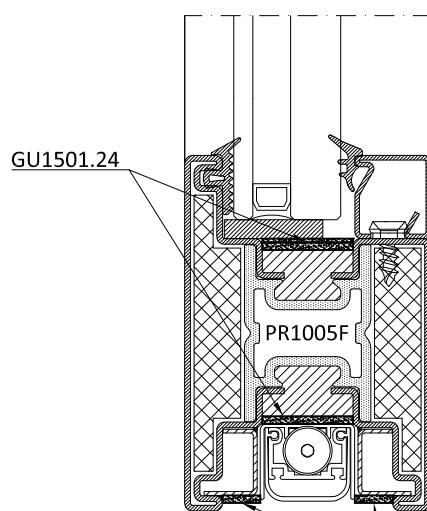
ANTE/LEAF



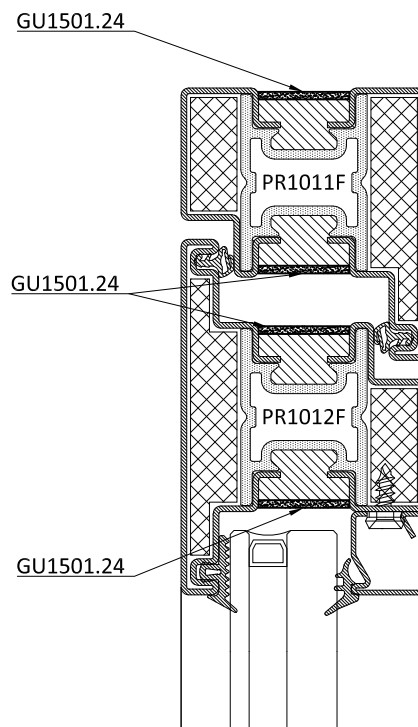
SEZ. A-A

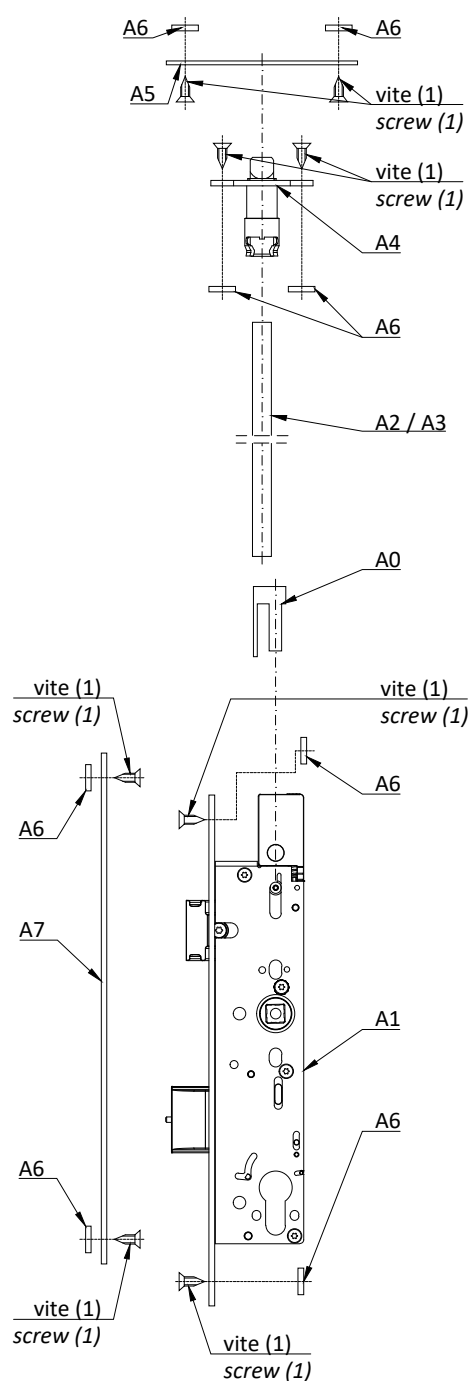


SEZ. B'-B'

guarnizione intumescente
intumescent gasket

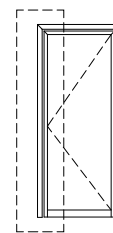
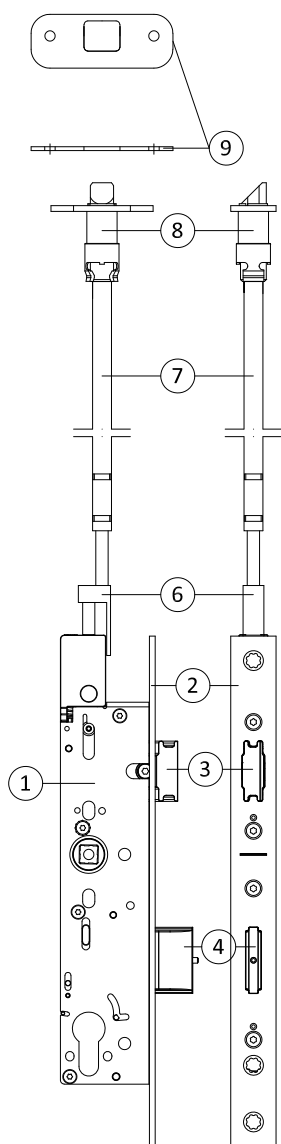
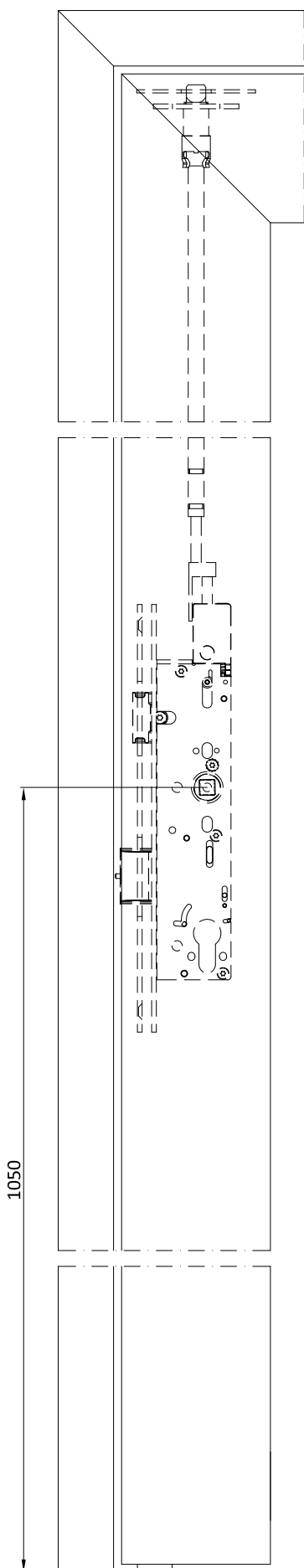
SEZ. B-B





VITI / SCREWS		
	Descrizione / Description	Q.tà / Q.ty
(1)	Vite TSPTC M5x6 mm Screw CCH M5x6 mm	8

KIT SERRATURA PORTA A 1 ANTA AC1560.65 (BKS Series 18) KIT LOCK FOR 1 LEAF DOOR AC1560.65 (BKS Series 18)			
	Tipo / Type	Descrizione / Description	Q.tà / Q.ty
1° anta 1° leaf	A0	adattatore posizione per asta superiore position adapter for top rod	1
1° anta 1° leaf	A1	serratura ambidestra - entrata 35 mm ambidextrous lock - 35 mm inlet	1
1° anta 1° leaf	A2	asta superiore L=1500 mm top rod L=1500 mm	1
1° anta 1° leaf	A3	asta superiore L=2000 mm top rod L=2000 mm	
1° anta 1° leaf	A4	puntale superiore 1° anta top ferrule 1° leaf	1
1° anta 1° leaf	A5	incontro superiore top strike plate	1
1° anta 1° leaf	A6	Piastre di fissaggio Fixing plates	8
1° anta 1° leaf	A7	incontro serratura - entrata 35 mm lock plate - 35 mm inlet	1



AC1560.65

- 1) Serratura
- 2) Frontalino
- 3) Scrocco
- 4) Catenaccio
- 5) Incontro per serratura
- 6) Adattatore posizione asta
- 7) Asta superiore *
- 8) Puntale 1° anta
- 9) Incontro superiore

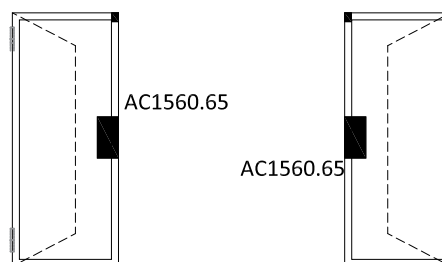
* inserito all'interno della cava
profilo

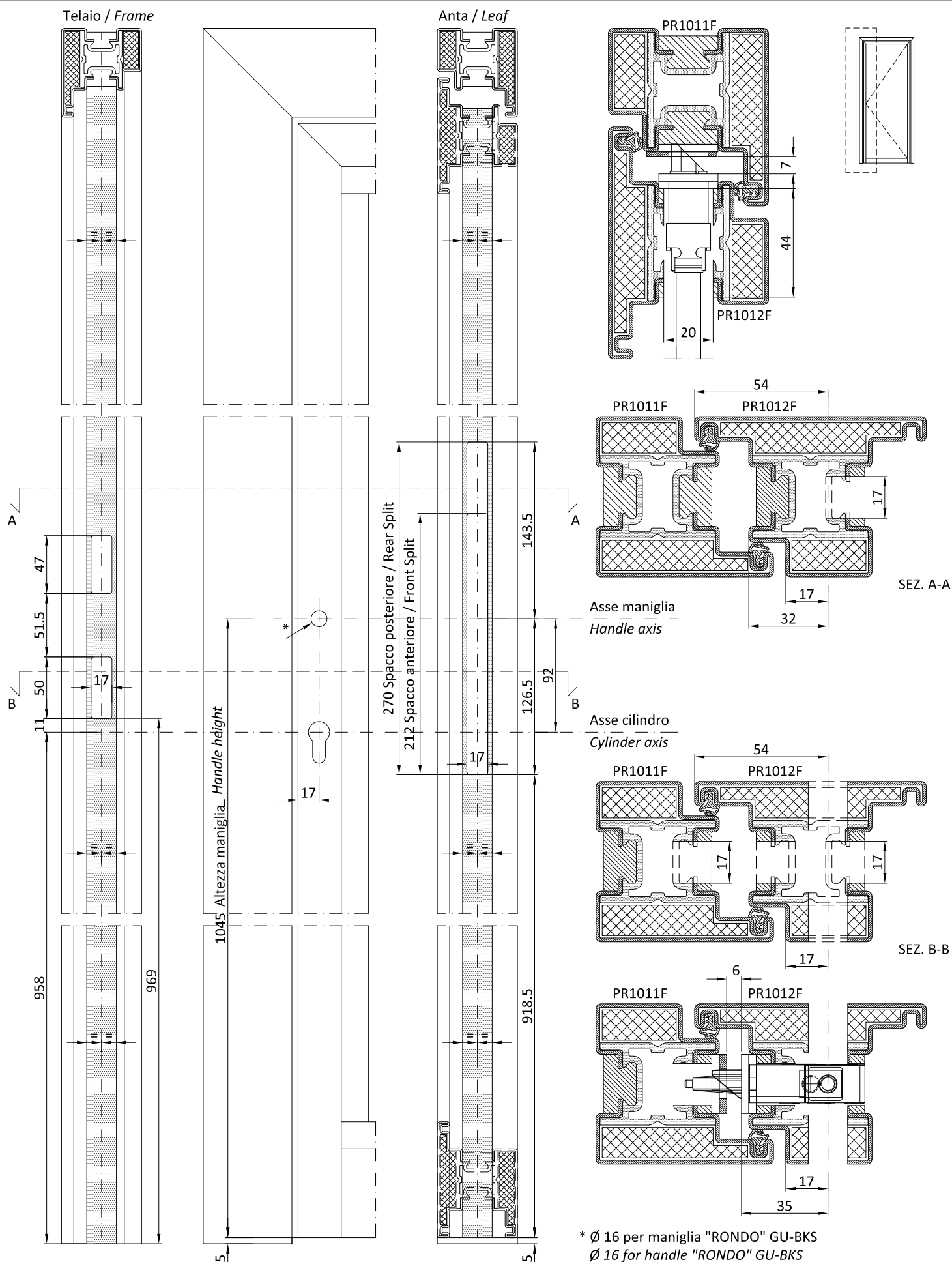
AC1560.65

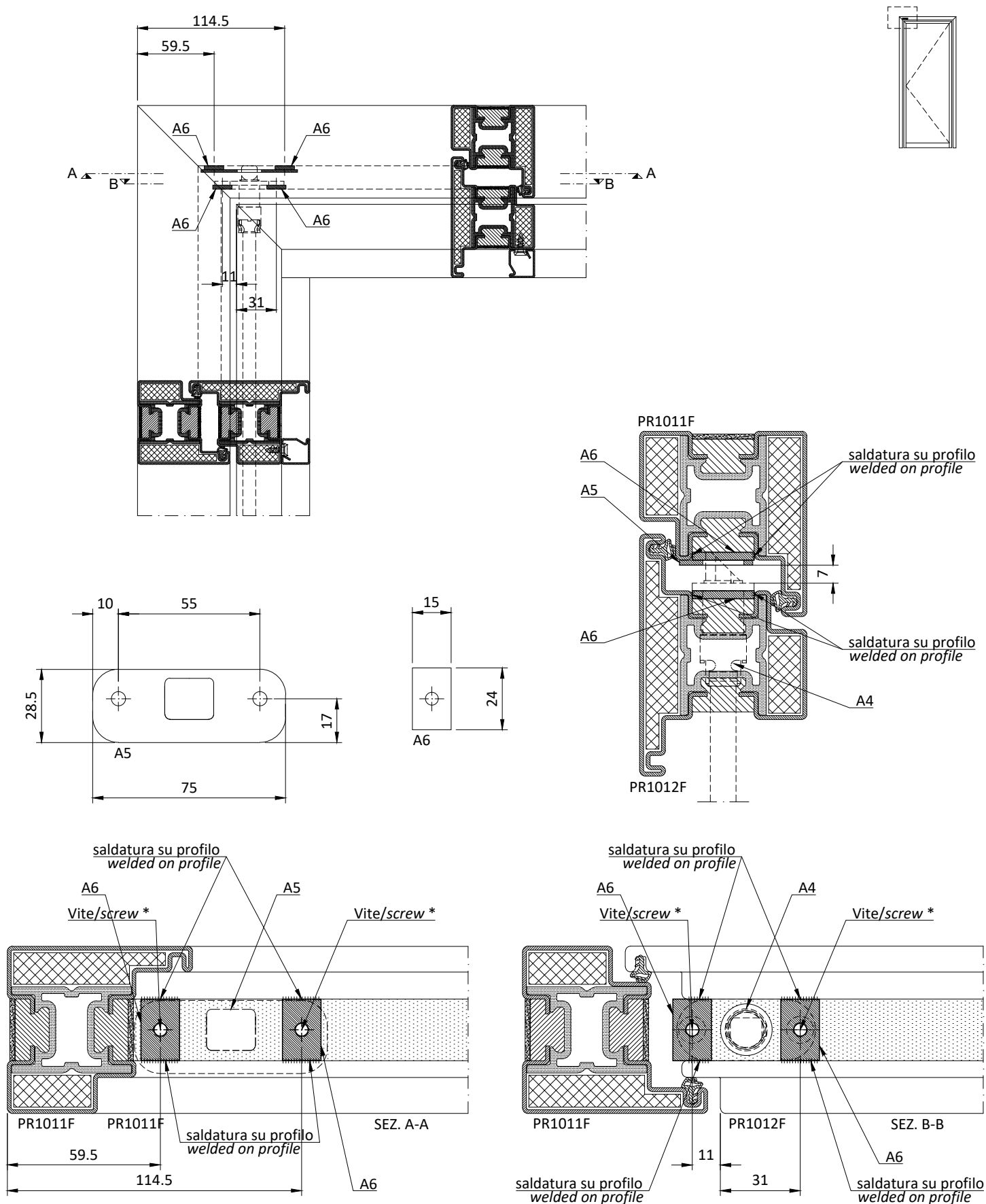
- 1) Lock
- 2) Front plate
- 3) Spring latch
- 4) Bolt
- 5) Strike plate
- 6) Top rod position adapter
- 7) Top rod *
- 8) Top ferrule
- 9) Top strike plate

* inserted inside the profile hole

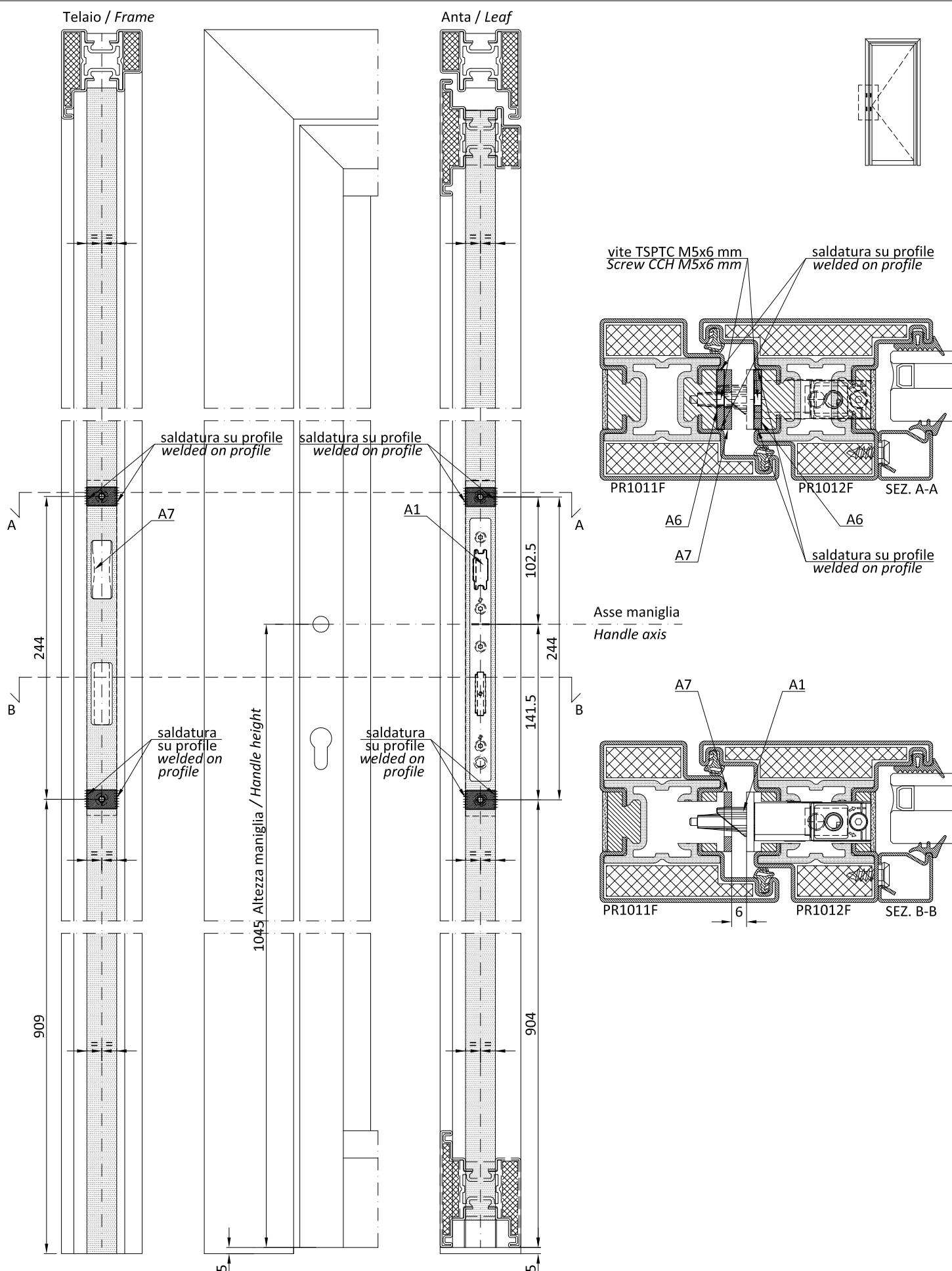
SCHEMA UTILIZZO SERRATURE
DIAGRAM FOR THE USE OF LOCKS

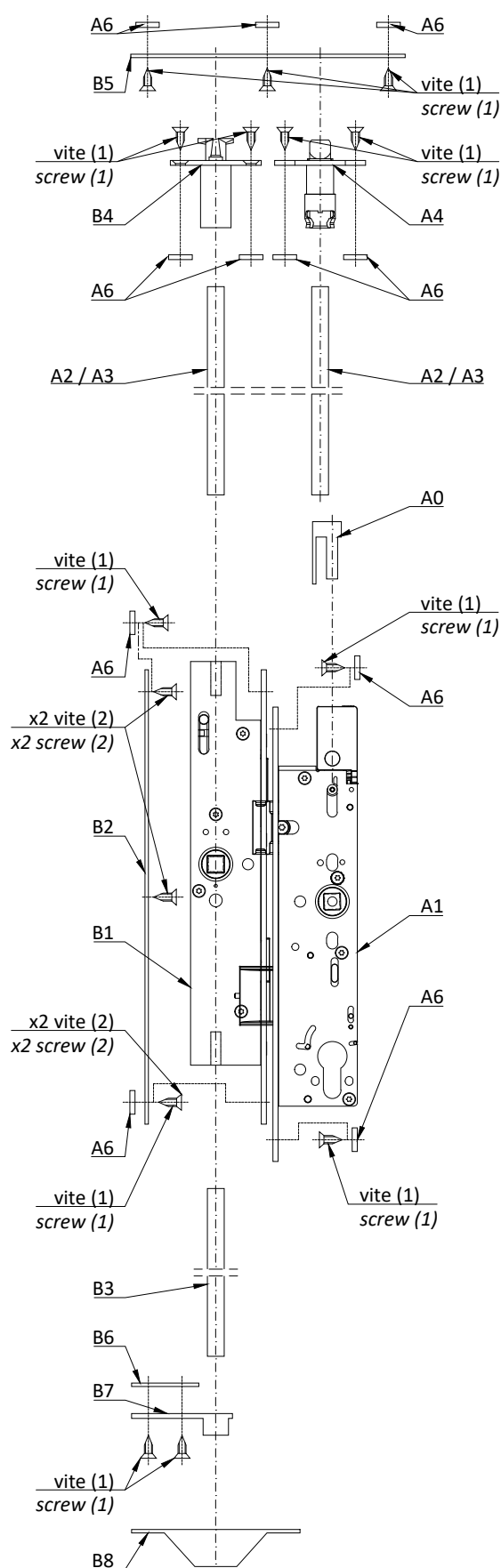
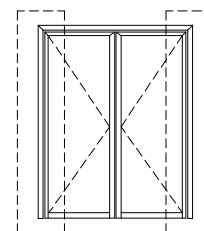






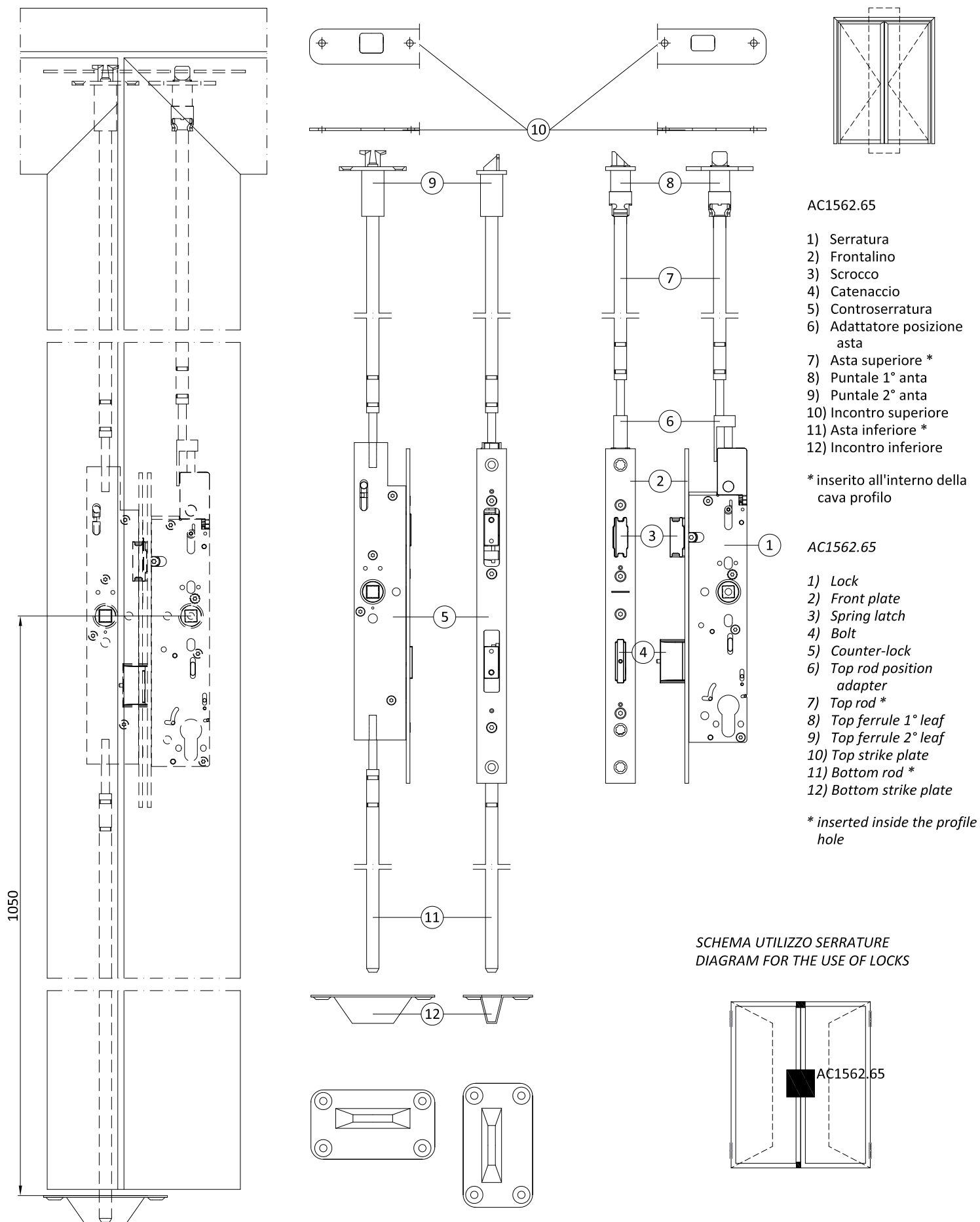
* Vite TSPC M5x6 mm / screw CCH M5x6 mm

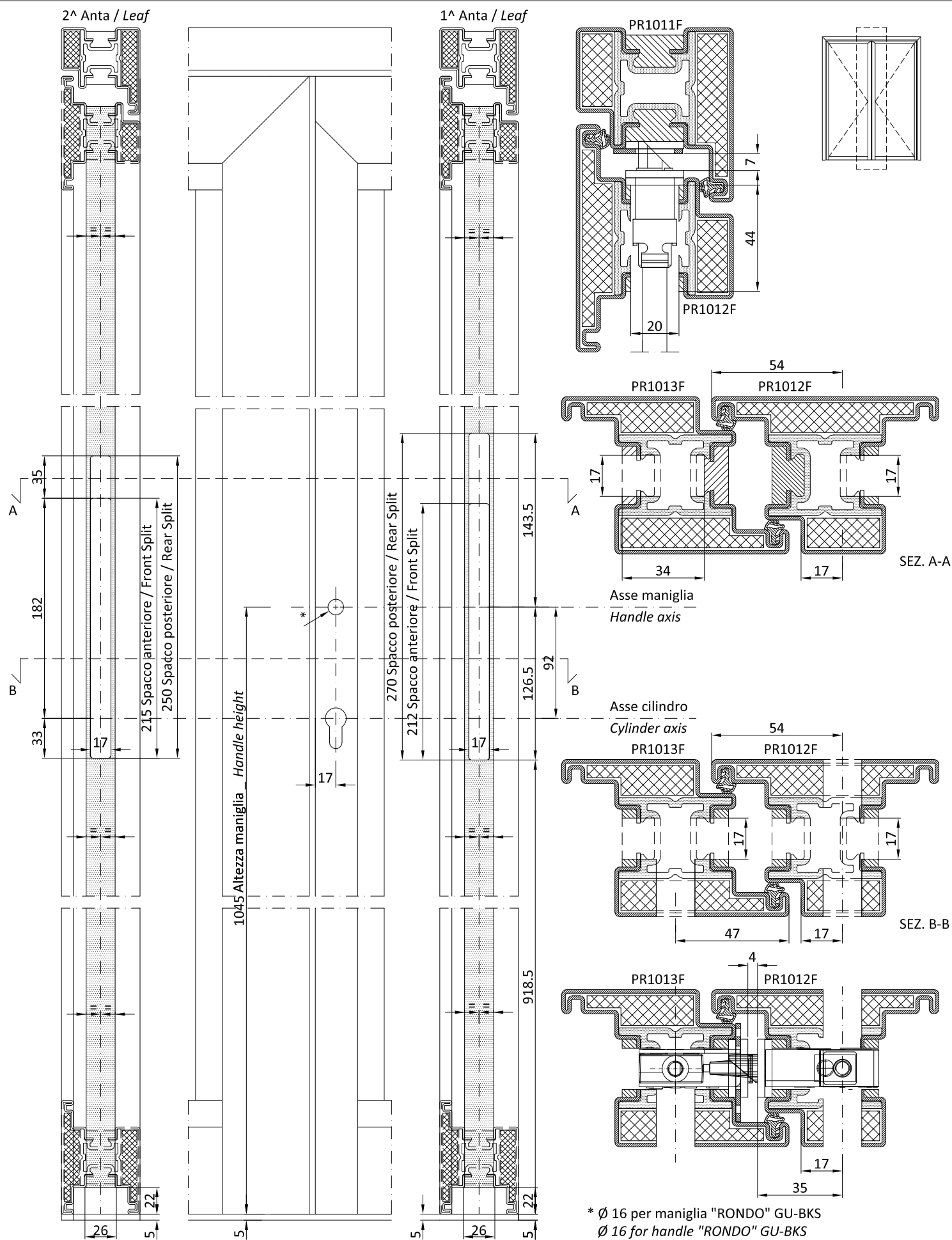


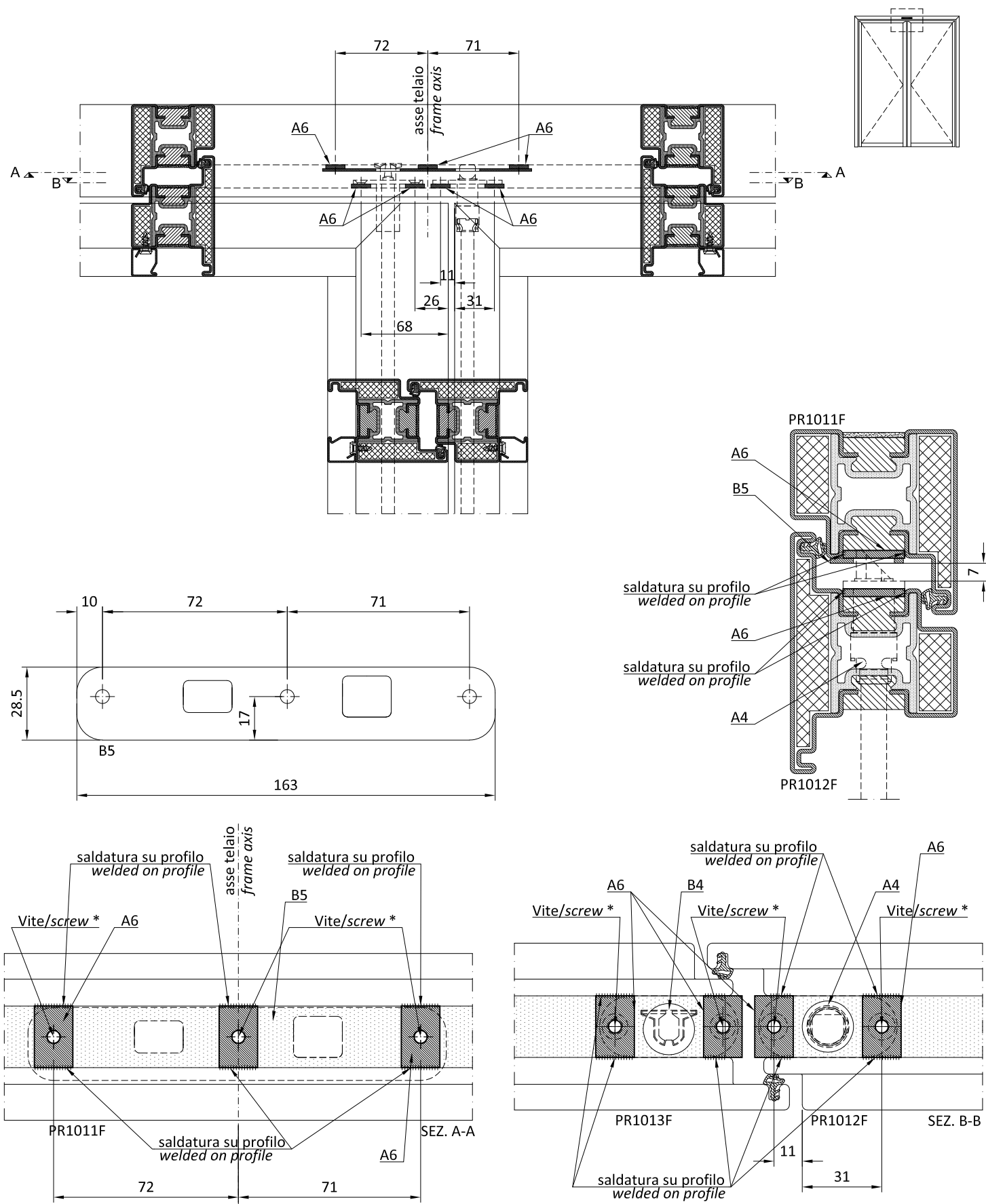


VITI / SCREWS		
	Descrizione / Description	Q.tà / Q.ty
(1)	Vite TSPTC M5x6 mm Screw CCH M5x6 mm	13
(2)	Vite autofilettante TPS Ø3,5x9,5 mm Self-tapping screw CH Ø3,5x9,5 mm	6

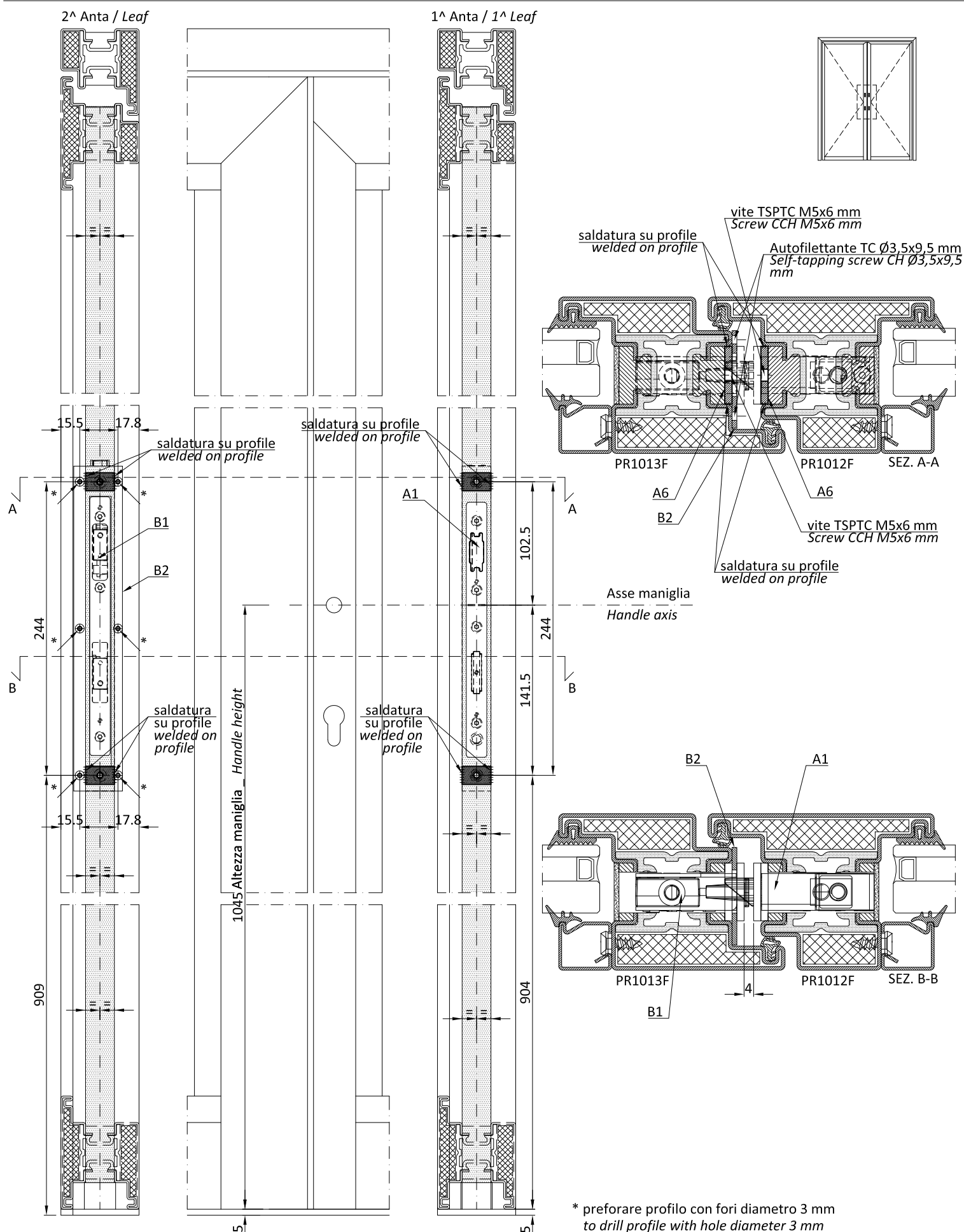
KIT SERRATURA PORTA A 2 ANTE AC1562.65 (BKS Series 18) KIT LOCK FOR 2 LEAF DOOR AC1562.65 (BKS Series 18)			
	Tipo / Type	Descrizione / Description	Q.tà / Q.ty
1° anta 1° leaf	A0	adattatore posizione per asta superiore position adapter for top rod	1
1° anta 1° leaf	A1	serratura ambidestra - entrata 35 mm ambidextrous lock - 35 mm inlet	1
1° anta 1° leaf	A2	asta superiore L=1500 mm top rod L=1500 mm	2
1° anta 1° leaf	A3	asta superiore L=2000 mm top rod L=2000 mm	
1° anta 1° leaf	A4	puntale superiore 1° anta top ferrule 1° leaf	1
1°-2° anta 1°-2° leaf	B5	incontro superiore top strike plate	1
1°-2° anta 1°-2° leaf	A6	Piastre di fissaggio Fixing plates	11
2° anta 2° leaf	B1	Controserratura - entrata 35 mm Counter-lock 35 mm inlet	1
2° anta 2° leaf	B2	Piastra di supporto per contro serratura Support plate for counter-lock	1
2° anta 2° leaf	A2	asta superiore L=1500 mm top rod L=1500 mm	vedi sopra see above
2° anta 2° leaf	A3	asta superiore L=2000 mm top rod L=2000 mm	
2° anta 2° leaf	B3	asta inferiore L=1187 mm bottom rod L=1187 mm	1
2° anta 2° leaf	B4	puntale superiore 2° anta top ferrule 2° leaf	1
2° anta 2° leaf	B6	piastra di supporto per guida asta inferiore support plate for bottom rod guide	1
2° anta 2° leaf	B7	guida asta inferiore su anta bottom rod guide on leaf	1
2° anta 2° leaf	B8	incontro inferiore a vaschetta bottom bowl strike plate	1

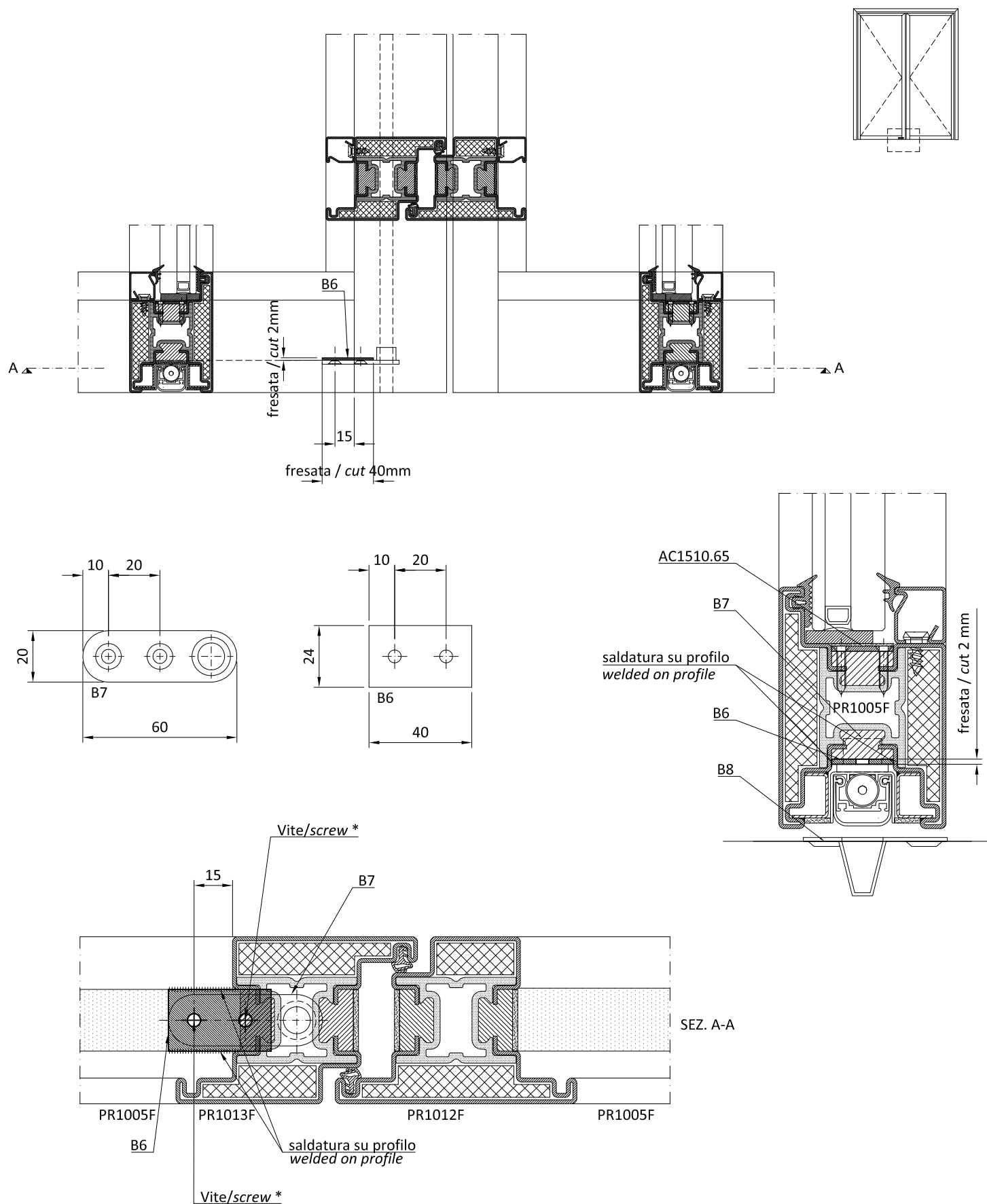




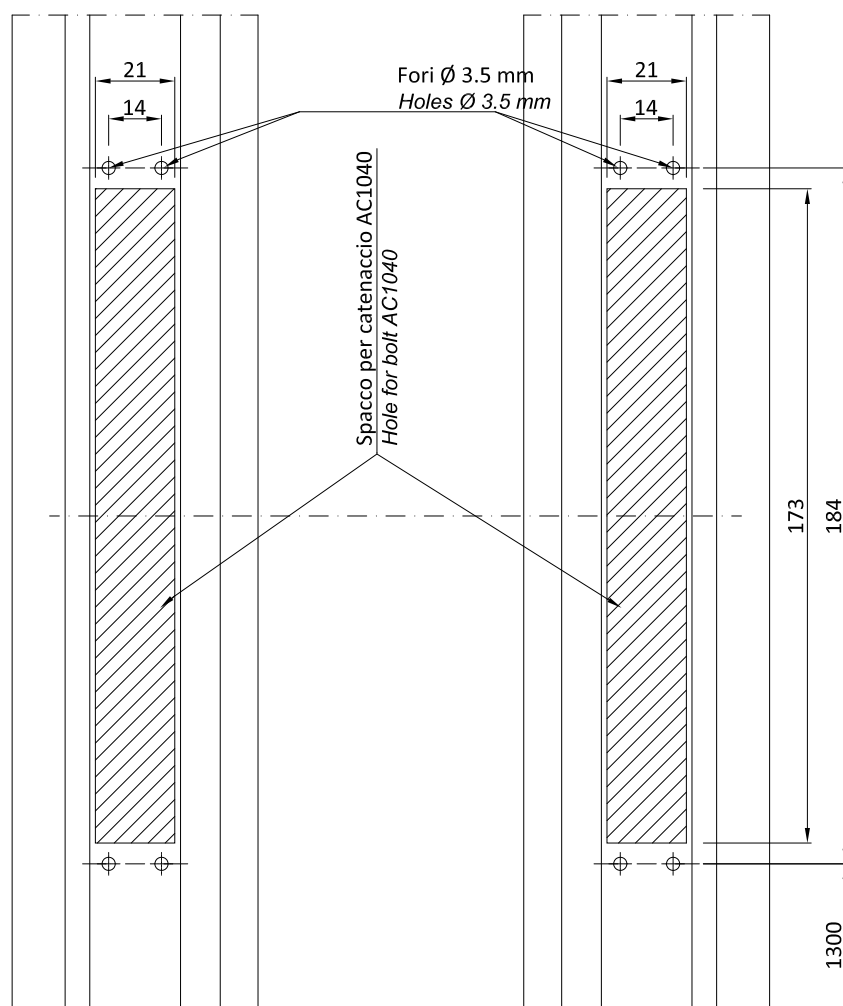
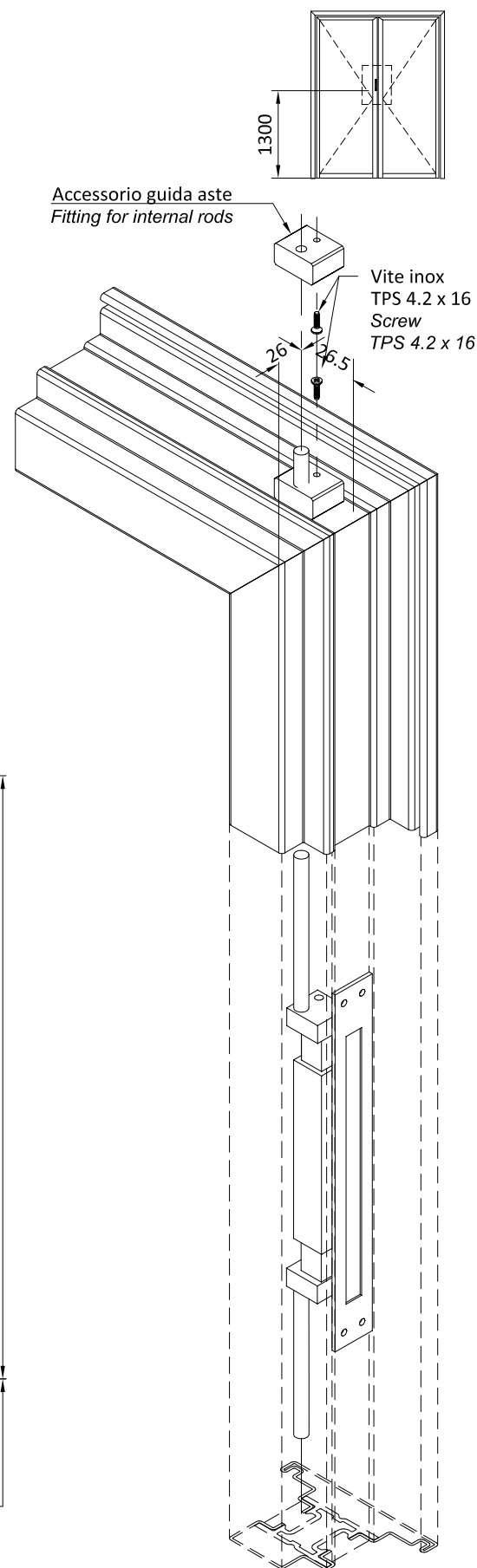
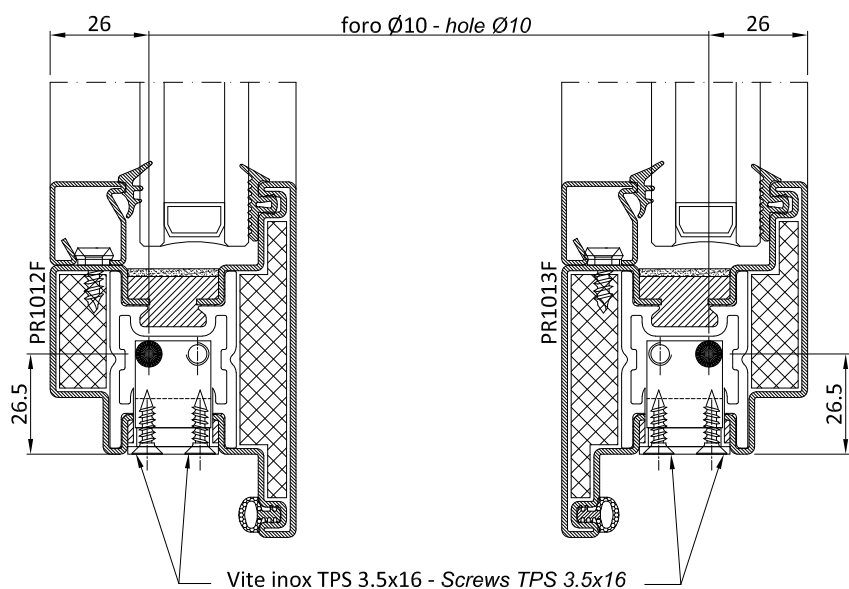


* Vite TPSTC M5x6 mm / screw CCH M5x6 mm





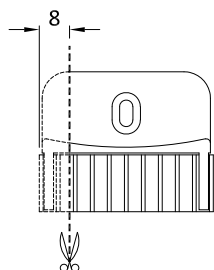
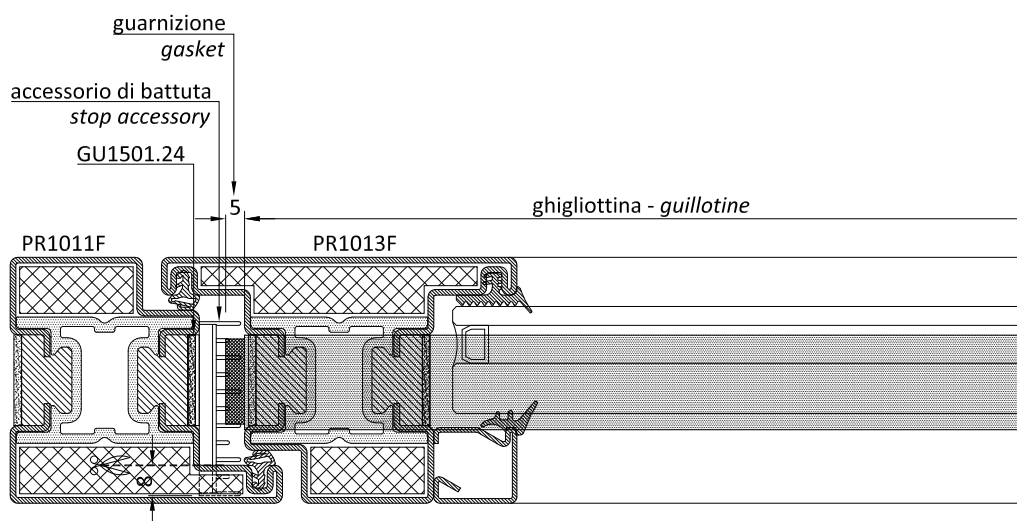
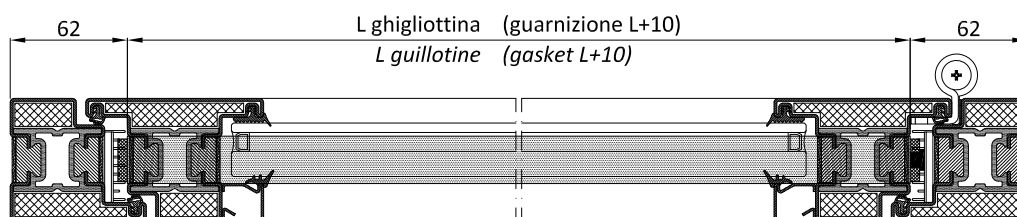
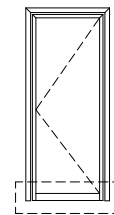
* vite TSPTC M5x6 mm / screw CCH M5x6 mm



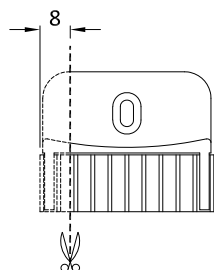
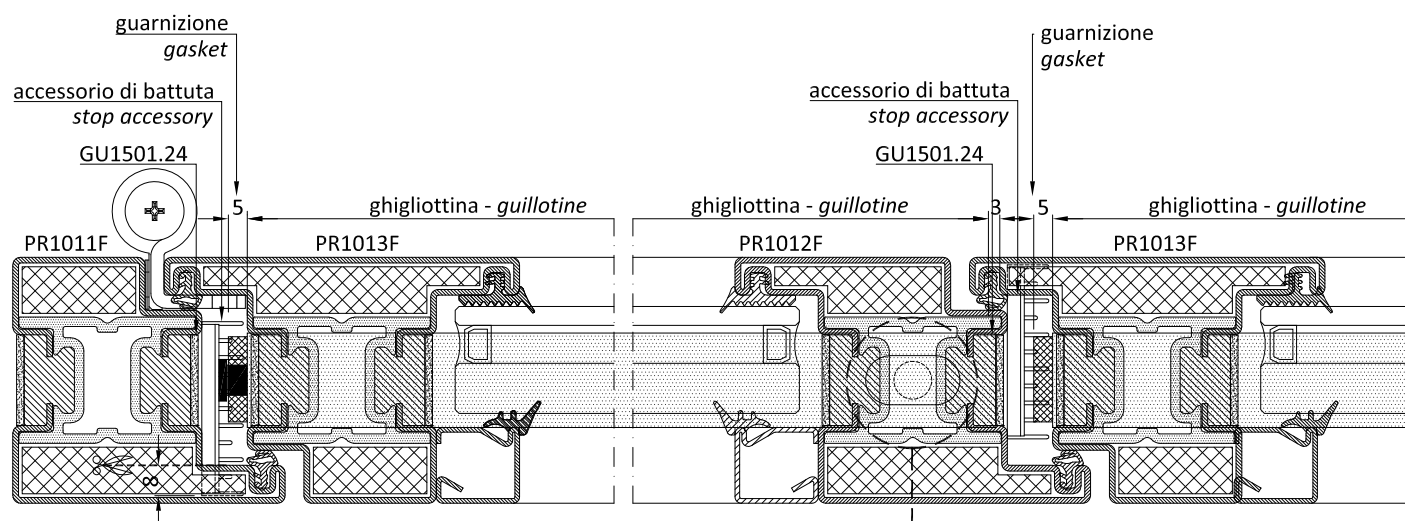
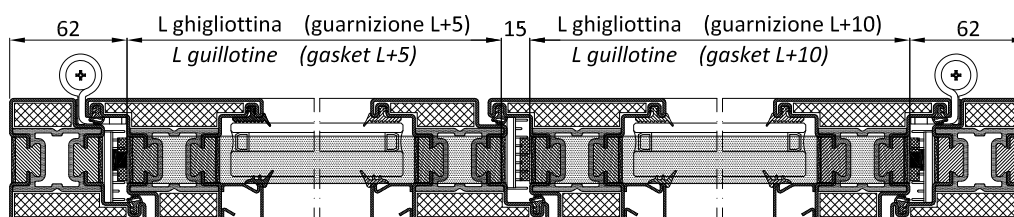
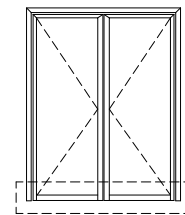
Aste Ø 7 mm L mm 1500
Ø 7 mm L mm 1500 rods

* con catenaccio AC1040, spostare il paraspiro verso l'esterno profilo PR1005F come previsto nel sistema EBE65
with AC1040 bolt, the guillotine AC1081 has to be moved to the external part of the profile PR1005F as foreseen for the EBE65 door system

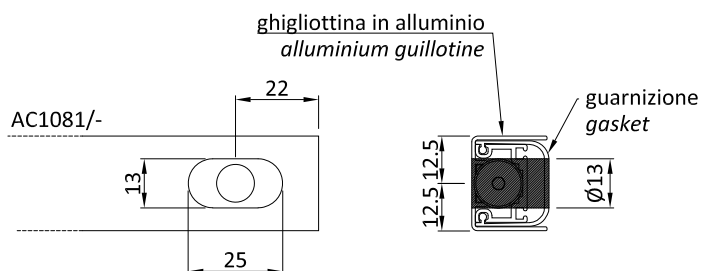
cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230
AC1081/G	1215 → 1330

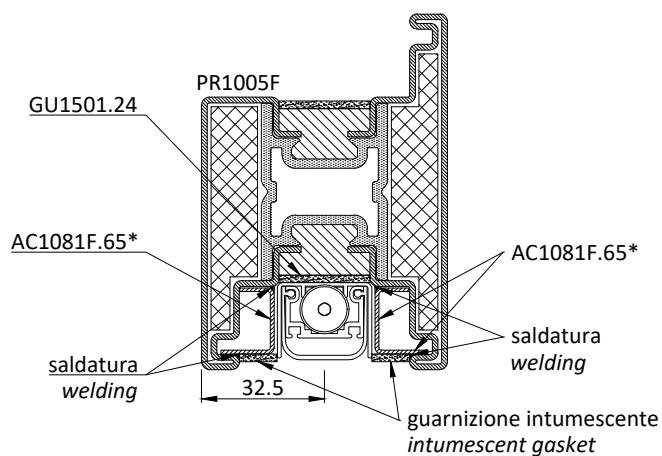
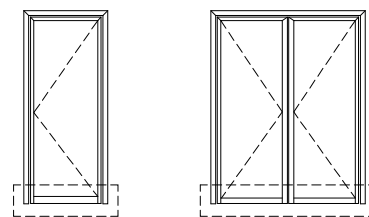
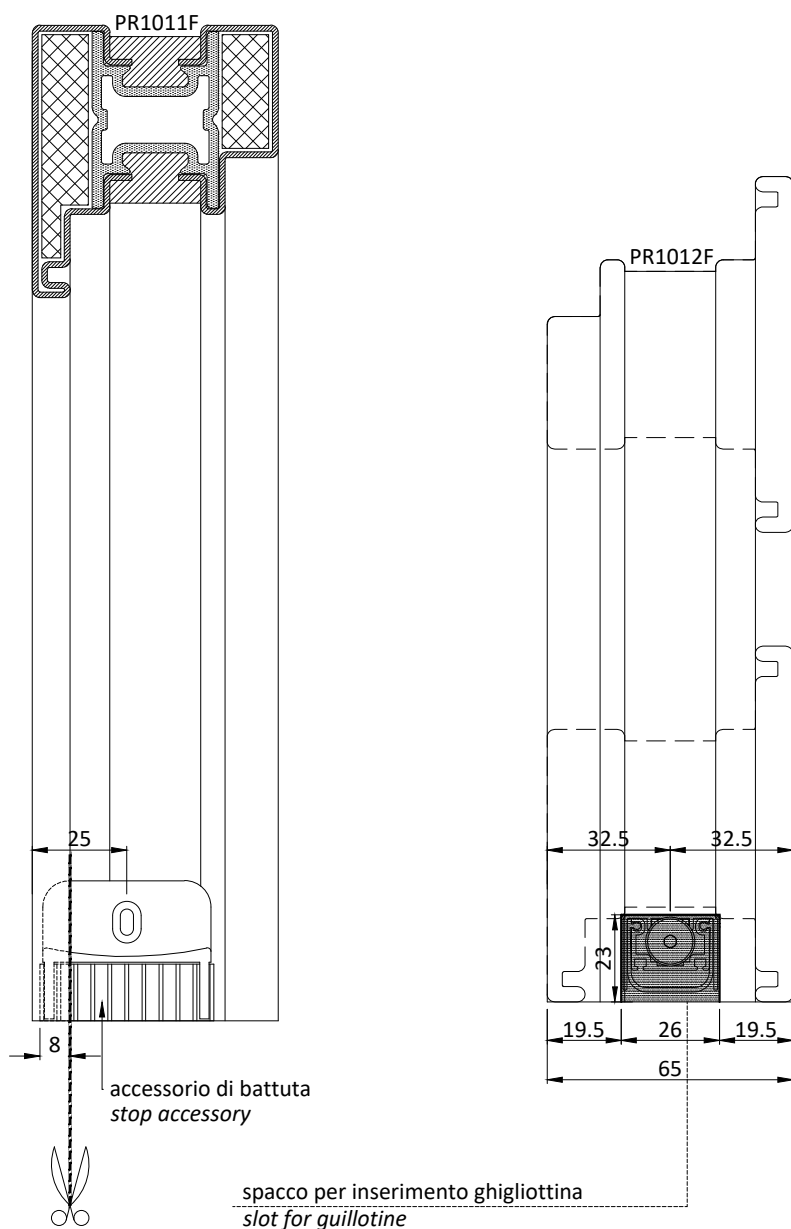


cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230
AC1081/G	1215 → 1330



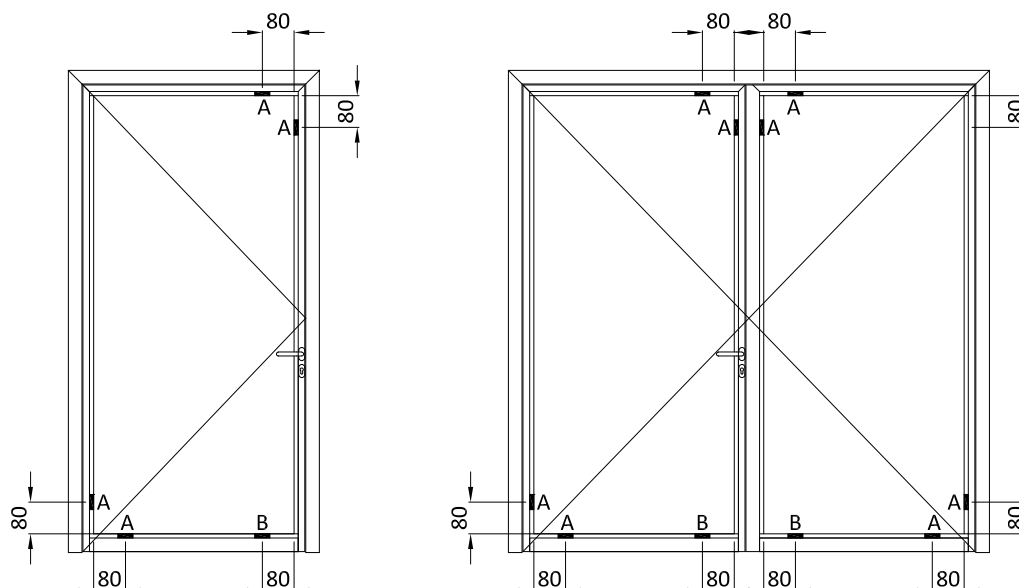
Lavorazione per porta a due ante con AC1562.65
Working for two leaf door with AC1562.65





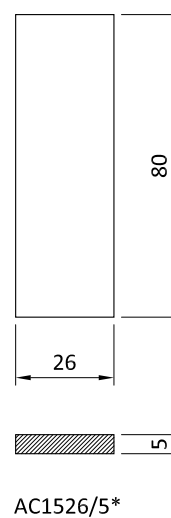
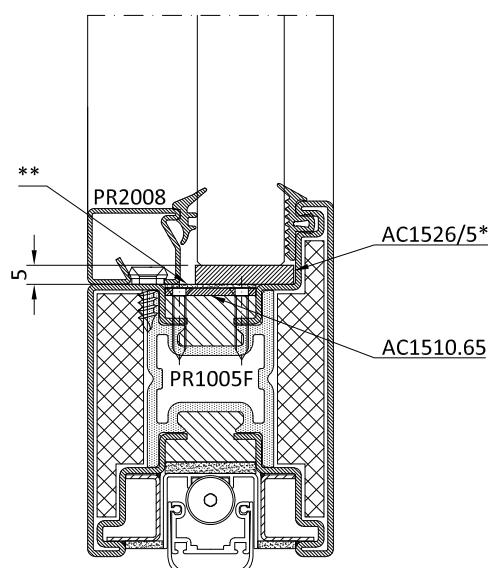
* di lunghezza pari alla lunghezza della ghigliottina / with the same length of the guillotine

viti in dotazione
supplied screws



A) spessore portante / carry shim

B) spessore distanziatore / compensation shim



tipologia porta / door type	quantità totale AC1526/5 total quantity AC1526/5
porta 1 anta / 1 leaf door	5*
porta 2 ante / 2 leaf door	10*

Note / Note

* Spessore elementi in calcio silicato e quantità totali da verificare in fase di montaggio in relazione alle tolleranze del vetro e del profilo / Thickness and total quantity of the calcium silicate shims to be verified during the assembly activities according to the glass and profile tolerances

** Porzione di guarnizione intumescente GU1501.24 se necessaria per fornire una base piana al supporto vetro / part of intumescent gasket GU1501.24 if needed to foresee a flat base support for the glass

Generalità

I sistemi progettati e sviluppati dalla Secco Sistemi sono ideati per la fabbricazione di un'ampia gamma serramenti, vetrate e facciate in metallo. I sistemi sono rivolti ad aziende esperte e professionali nel campo della lavorazione dei metalli e della costruzione di serramenti e facciate, che sono a conoscenza delle normative di riferimento, delle direttive e delle specifiche tecniche del fornitore del sistema, nonché delle fondamentali regole dell'arte per la produzione e installazione di questi manufatti. Tutta la documentazione tecnica fornita costituisce un riferimento per i tecnici qualificati delle aziende al fine di indicare le modalità per la costruzione dei prodotti. In ogni caso i tecnici qualificati devono analizzare criticamente le indicazioni riportate per verificarne la loro adeguatezza per ogni singola commessa in relazione ai carichi, agli stress previsti e alle condizioni di messa in opera, essendo impossibile riportare in questa documentazione tutte le varianti riscontrabili nei progetti reali.

Tolleranze

AF 60 in EBE65 prevede l'accoppiamento tra i telai esterni e le ante apribili con distanza di 12 mm su porte. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-2 mm.

Taglio/Lavorazioni

I profili AF 60 in EBE 65 in acciaio zincato, acciaio inox e corten possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio, mentre per il taglio dei profili in ottone possono anche essere utilizzate troncatrici per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio, sia per la sezione inclinata a 45° che per la sezione verticale a 90°, dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura

I profili AF 60 in EBE 65 possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica ed evitando di saldare in prossimità della giunzione a taglio termico. L'eventuale riscaldamento della resina resistente al fuoco libera sostanze gassose a base di aldeidi e CO: per tale ragione si consiglia di saldare con gli appositi DPI previsti e in zone con sufficiente areazione e in presenza di sistema per l'evacuazione dei fumi. I profili in corten devono essere saldati con apposito filo in corten mentre per i profili in ottone si può utilizzare un filo CuSi3. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura/Brunitura

I profili AF 60 in EBE 65 sono stati progettati per essere **verniciati a liquido a basse temperature di asciugatura (max 100°C)**. I telai prima della verniciatura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi o dei granuli di sabbia utilizzati durante il pretrattamento delle superfici.

Vetrazione

Il sistema di fissaggio del vetro prevede l'utilizzo di fermavetri agganciati all'interno tramite clips o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione interna; all'esterno è previsto l'utilizzo di una guarnizione perimetrale continua giuntata e sigillata in un angolo superiore. Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro.

Installazione

La corretta installazione deve garantire il mantenimento delle performance dichiarate nella marcatura CE e testate in laboratorio. Si consiglia di progettare un corretto numero di fissaggi in relazione al tipo di controtelaio/muratura esistente e alle dimensioni degli elementi da installare. Al termine dell'installazione si verifichi il corretto funzionamento del serramento (facilità di apertura/chiusura, stabilità dell'anta aperta a riposo, etc.), il rispetto delle fughe e del sormonto tra ante apribili e telai fissi, il regolare posizionamento delle guarnizioni e delle sigillature, il drenaggio del telaio e la mancanza di difetti estetici sulle superfici del telaio e del vetro.

General information

The systems designed and developed by Secco Sistemi are suitable for the manufacturing of a wide range of doors, windows and shutters, as well as faces or facades in metal. The systems are designed for professional and expert companies in the metal-working sector and that of construction of doors, windows, shutters and facades. These companies are well aware of the specific regulations and the directions and technical specifications of the system supplier, and also the fundamental rules of the art of manufacturing and installing these products. All the technical documentation provided furnishes a source of reference for the qualified technicians of the companies, giving indications as to how the products should be constructed. These qualified experts must critically analyse the indications to verify their adequacy for each single order in terms of load, stress and conditions of installation, particularly as this documentation cannot provide for all the different variations that may be found in projects.

Tolerance

AF 60 in EBE 65 is made by coupling external frames with the opening leaves with a distance of 12 mm on doors. To ensure the correct functioning of hardware and gaskets, tooling must be performed with great care and precision. It is advised to keep the tolerance between +0/-1 mm for opening elements.

Cut / Processing

AF 60 in EBE 65 profiles in galvanized steel, stainless steel and corten steel can be cut with normal saws, like those used for steel pipes. AF 60 in EBE 65 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws advised to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between -1°/+1°. All Tooling must be performed in line with this technical note and any variations agreed with Secco Sistemi's Technical Department.

Welding

AF 60 in EBE 65 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any resin items with fire resistance characteristic releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special Personal Protective Equipment suggested and in areas with sufficient ventilation and fume-disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for later painting without any visible imperfections (pores and ripples).

Painting/Burnishing

AF 60 in EBE 65 profiles have been designed **to be painted with the liquid coating technique at low temperature for drying phase (max 100°C).**

Holes must be drilled in the frames (as per instructions in these technical specifications) before painting in order to allow drainage of any liquid or dust used as a pre-treatment of the surfaces.

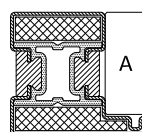
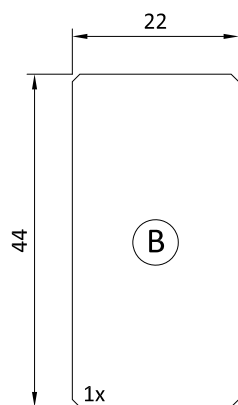
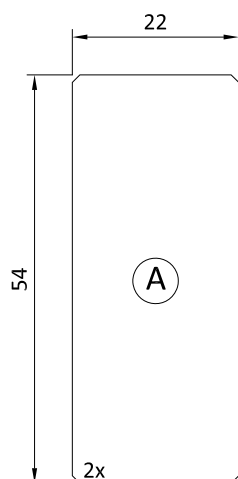
Glass application

Glass needs to be secured internally and externally. Internally, glazing beads must be used together with clips or bushings and then secured by pressure with the appropriate gasket; externally a continuous perimetrical gasket should be applied, jointed and sealed in a top corner. In order to ensure the correct functioning of the system, it is recommended to verify the proper pressurization of the internal glazing bead gaskets.

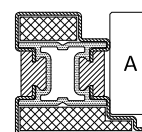
Installation

Proper installation must guarantee that the performances declared in the CE marking and verified in the lab will remain constant. It is advised to arrange a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to install. Once installation is completed, the proper functioning of the window/door (easiness of opening/closing, stability of the open leaf, etc.), should be tested as well as the correctness of joints between opening leaves and fixed frames, the proper positioning of gaskets and seals, the drainage of frames and the absence of any aesthetic defects on the frame and glass surfaces.

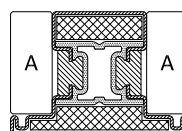
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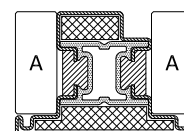
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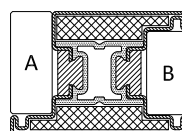
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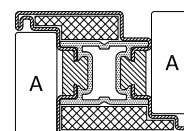
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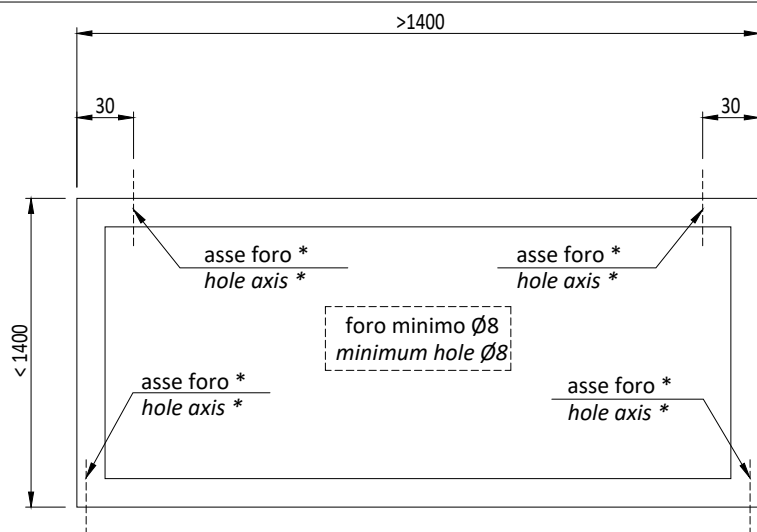
PR1012F



PR1005F



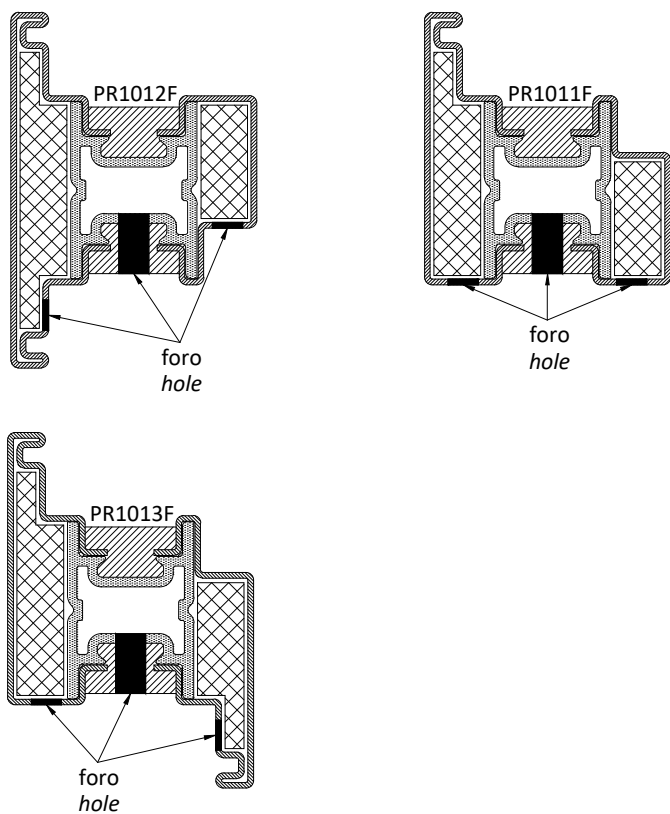
PR1013F



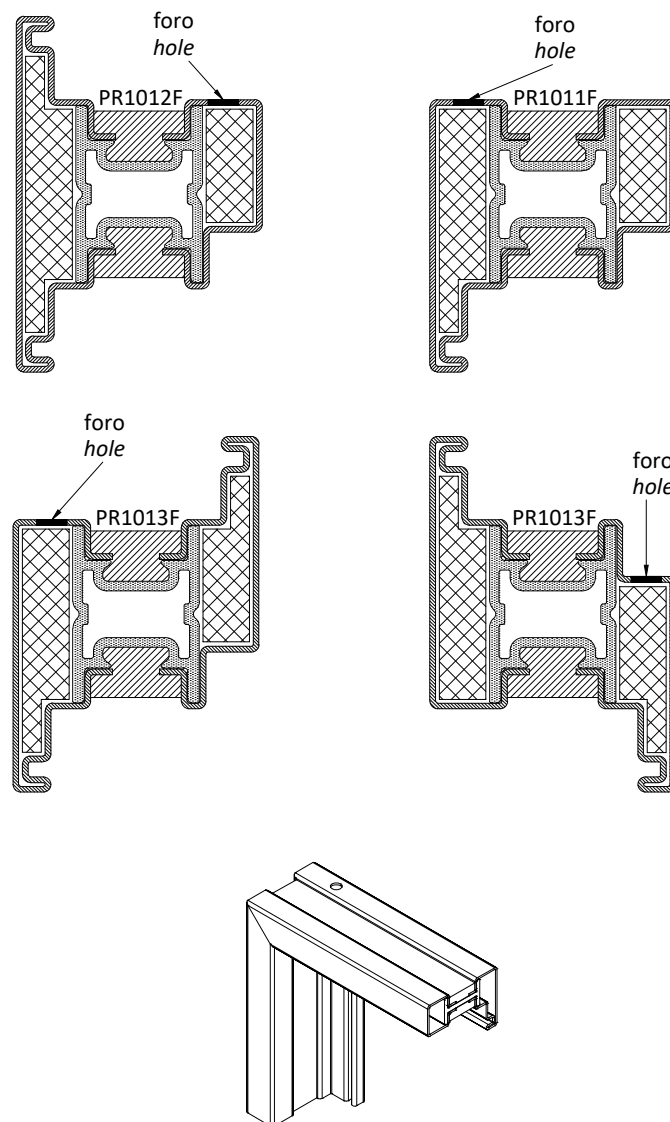
* forare alla massima estremità
* to be drilled on the extremity

N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura
dimensions are indicative - they have to be checked with the powder painting

FORATURA LATO INFERIORE PER SCOLO LIQUIDI
DRILLING BOTTOM FRAME FOR LIQUID DRAINAGE



FORATURA LATO SUPERIORE PER APPENDERE
DRILLING UPPER FRAME FOR FRAME HANGING



Troncatricecaratteristiche minime della macchina

- Potenza: 1.8 – 2.5 kW;
- Possibilità di taglio a 45° nei due sensi e a 90°;
- Velocità di taglio ideali: 15-30 giri/min per acciaio inox;
60-90 giri/min per acciaio zincato e corten,
90 giri/min o superiori per bronzo (OT/67);
- Capacità di taglio: 150 x 80 mm a 90°;
100 mm taglio a 45°.

caratteristiche della lama

- Lama da 350 mm con spessore 2.5 mm;
- N° denti: - 300 per tagli a 45°;
- 350 per tagli a 90°;
- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle lame).

NB: è possibile tagliare la lega OT/67 con le stesse macchine dell'alluminio.

Pantografocaratteristiche minime della macchina

- Mandrino con velocità regolabile 2000-11000 giri/min (per un corretta lavorazione su acciaio inox è necessario operare a n° ridotto di giri < 4000);
- Struttura in ghisa adatta al taglio acciaio;
- Testata pesante per limitare le vibrazioni;
- Chiusura del profilo da lavorare con morse.

caratteristiche minime delle frese

- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle frese);
- Frese a 4 denti;
- Frese con diametro 5 mm per le lavorazioni di scasso.

Foraturemontaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

- Forare con punte da trapano HSS del diametro indicato sulla corrispondente tavola tecnica;
- Maschiare il foro con vite autofilettante zincocromata avente diametro corrispondente alla vite inox fornita nel kit con l'articolo da montare;
- Posizionamento e fissaggio definitivo dell'articolo con le viti inox in dotazione.

fresatura di cave e asole sui profili inox

- Adoperare macchine (pantografi o fresatrici) adeguate alle lavorazioni dell'acciaio;
- Regolazione del numero di giri max (3000 giri/1');
- Impiego di frese di diametro massimo di 8mm a 4 pale in acciaio HSS;
- Abbondare con la lubrificazione, concentrata sull'utensile;
- Ridurre l'avanzamento fino ad accertare un taglio il più regolare possibile;
- È normale un'usura accelerata dell'utensile.

CutterMinimum requirements for the use of the machine

- Power: 1.8 – 2.5 kW;
- Possibility of cutting at 45° in both directions and at 90°;
- Ideal cutting speed: 15-30 rmp for stainless steel;
60-90 rmp for galvanised and corten steel;
90 rmp or higher for bronze (OT/67);
- Cutting capability: 150 x 80 mm at 90°;
100 mm cut at 45°.

Blade specifications

- 350 mm blade with a 2.5 mm thickness;
- Number of teeth: 300 for 45° cut;
350 for 90° cut;
- Material: HSS (please verify availability of longer lasting material on the market).

Note: OT/67 alloy can be cut with machines made for aluminum.

PhantographMinimum requirements for the use of the machine

- Mandrel with a 2000-11000 rmp adjustable speed (for a proper stainless steel processing a slower speed is required i.e.<4000 rpm);
- Machine should be made of cast iron suitable for steel cutting;
- Heavy head in order to limit vibrations;
- Secure the profile to be processed in jaws.

Minimum requirements for the use of a milling machine

- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

DrillingHow to mount closing and moving components on a stainless steel profile

- Use a HSS drill. The diameter of the drill is indicated in the technical note;
- Thread the hole with self-threading zinc-plated screws with the same diameter as the stainless steel screw provided with the kit;
- Position and secure the item with the stainless steel screws provided.

Milling slots and loops in the profiles

- Use machines designed for steel processing (pantographs or milling machines);
- Max rpm setting (3000 rpm);
- Use milling machines with a diameter no bigger than 8 mm and with 4 HSS steel blades;
- Exceed with lubrication, mainly on the machine;
- Processed slowly until the milling is as clean as possible;
- Expect a fast wearing of the machine.

MATERIALI**ACCIAIO INOX****Materiale**

Profilati ricavati da nastro di lamiera di acciaio inox laminato a freddo pre-trattato industrialmente per garantire la massima qualità e uniformità.

Caratteristiche fisiche

AISI 316L Marino (X2 CrNiMo 17-12-2)

Norme di riferimento

EN 10088-2; EU 114

Trattamenti superficiali

Finitura satinata: ottenuta su nastro AISI 304 con finitura superficiale 2B con successiva satinatura con abrasivi a grana 240-280.

Finitura lucida: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2R, riflettività 53% e successiva lucidatura a specchio.

Finitura Scotch Brite: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2B con successiva spazzolatura Scotch Brite.

ACCIAIO COR-TEN**Materiale**

Profilati ottenuti da nastro in acciaio altoresistenziale, autopassivante (che un tempo veniva commercializzato con il nome Cor-Ten) tale da formare, se esposto all'aria, uno strato di ossido uniforme e stabile che, ricoprendo la lamiera, ne arresta la corrosione atmosferica.

Caratteristiche fisiche

Fe 510 X (C max % 0,12; Si % 0,25-0,75; Mn % 0,20-0,50; P % 0,07-0,15; Cu % 0,25-0,55; Cr % 0,30-1,25; Ni max % 0,65)

Norme di riferimento

EN 10149

Trattamenti superficiali

Dopo la profilatura il materiale viene immerso in speciali bagni ossidanti tali da accelerare la formazione dello strato protettivo. Raggiunta la tonalità desiderata della superficie si procede ad una ceratura di stabilizzazione del materiale.

ACCIAIO ZINCATO VERNICIATO**Materiale**

Profilati ottenuti da nastro in lamiera di acciaio zincato a caldo sistema Sendzimir finitura skinpassata

Caratteristiche fisiche

FeP02 GZ 200 (copertura di zinco pari a 200 gr/m² per faccia)

Norme di riferimento

UNI EN 10142/3/7; EURONORM 143

Trattamenti superficiali per la verniciatura

La preparazione del supporto zincato si effettua tramite i processi di sgrassaggio, decapaggio e lavaggio in acqua. Segue l'applicazione di uno strato di zinco per fosfatazione seguito da lavaggi in acqua demineralizzata. Infine applicazione della mano a finire con **vernice a liquido a basse temperature di asciugatura (max 100°C)**.

MATERIALS**STAINLESS STEEL****Materials**

Sections processed out of the cold-rolled coils, industrially pre-treated for utmost quality and uniformity.

Physical features

AISI 316L Marino (X2 CrNiMo 17-12-2)

Norms of reference

EN 10088-2; EU 114

Surface treatment

Satined: obtained on AISI 304 coil 2B pre-finish with post-treatment by means of abrasive 240-280 in grain size.

Polished: obtained on AISI 316L (marine) coil pre-finish with 2R surface finish, 53% reflectivity, and mirror post-polish.

Scotch Brite: obtained on AISI 316L (marine) coil 2B pre-finish with Scotch-Brite post-scrubbing.

CORTEN STEEL**Materials**

Sections processed out of highly resistant self-oxidising steel coils – once traded under the name Cor-Ten. If exposed to the open air, it produces a uniform protective layer that reduces weather corrosion.

Physical features

Fe 510 X (C max % 0,12; Si % 0,25-0,75; Mn % 0,20-0,50; P % 0,07-0,15; Cu % 0,25-0,55; Cr % 0,30-1,25; Ni max % 0,65)

Norms of reference

EN 10149

Surface treatment

After forming, sections are plunged into a special oxydising bath to catalyze formation of the protective coating. Once the desired tone obtained, sections are stabilized by a wax coating.

GALVANIZED AND PAINTED STEEL**Materials**

Sections processed out of hot galvanized steel coils, band "Sendzimir, skinpassed finishing.

Physical features

FeP02 GZ 200 (with zinc coating of 200 gr/sq x m on both faces)

Norms of reference

UNI EN 10142/3/7; EURONORM 143

Pre-painted surface treatment

The preparation of a galvanised surface is made through several processes: degreasing, pickling and washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat is then applied with **liquid coating technique at low temperature for drying phase (max 100°C)**.

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