SPILKA SWING ™

Profile design and Fitting instructions

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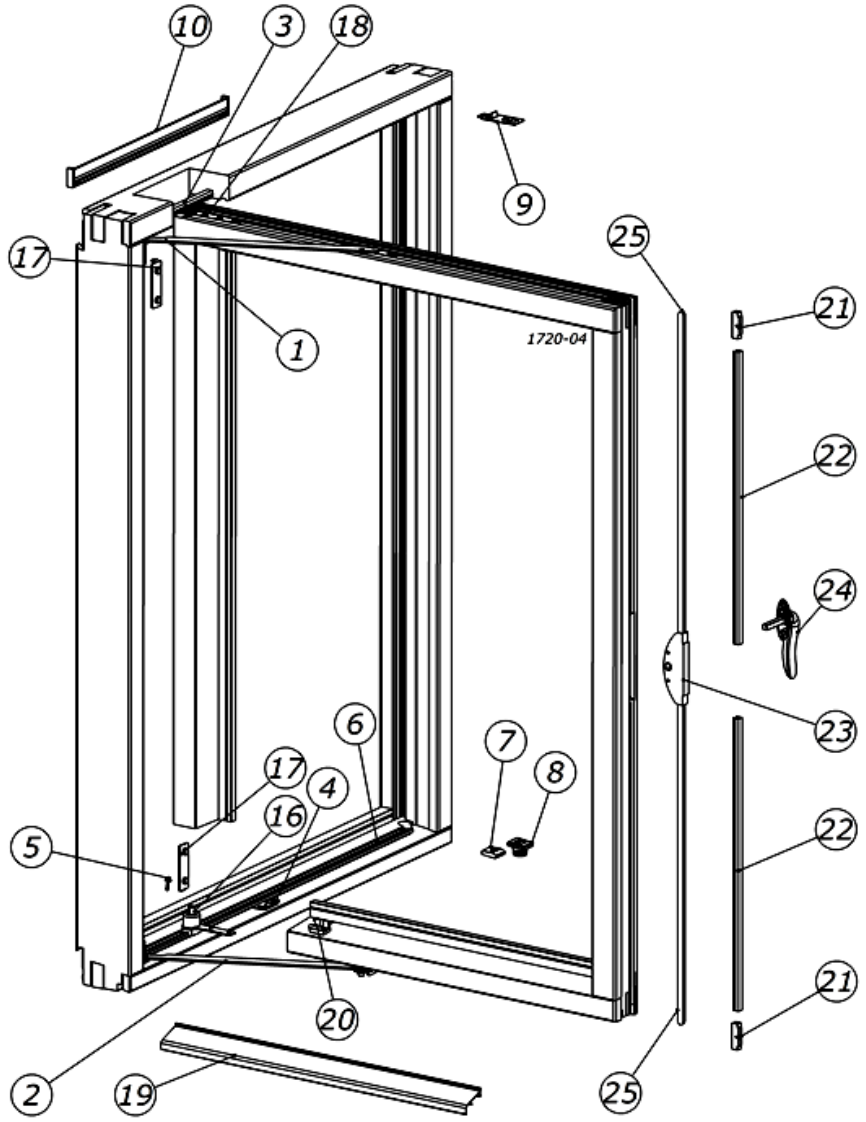
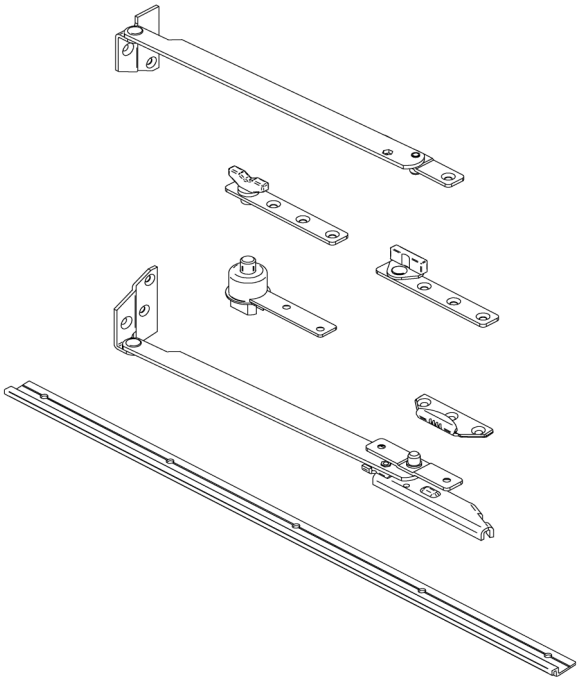
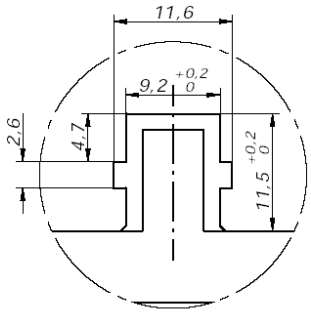


Item	Components, frame
1	HINGE TOP
2	HINGE BOTTOM
3	U-PROFILE
4	KEEPER SECURITY CATCH
5	SCREW FOR RAIL BOTTOM
6	RAIL BOTTOM
7	GUIDING WEDGE
8	END KEEP BOTTOM
9	END KEEP TOP
10	SPILVENT VENTILATOR

Item	Components, sash
16	WHEEL BEARING SWING
17	FRAME PLATE SAFETY SWING
18	HEAD SLIDES
19	GLAZING BEAD
20	CLIPS FOR GLAZING BEAD
21	GUIDES
22	COVER CAP PP
23	LOCKBOX
24	HANDLES AND ACCESSORIES
25	ESPAGNOLETTE RODS
	CLIPS FOR BARS AND ACCESSORIES

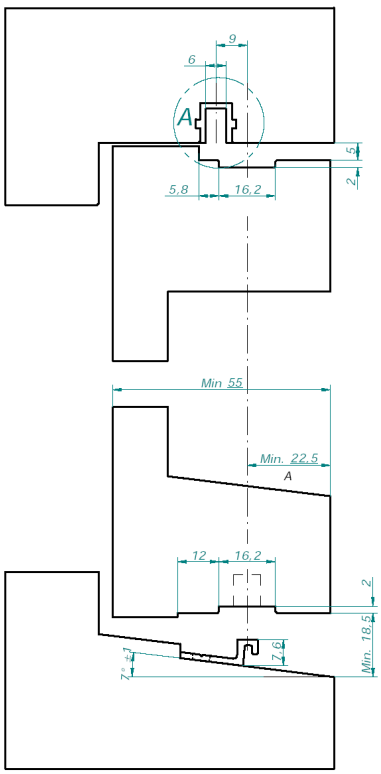
Components





DETAIL A

Critical measurements:



Drawing M 1:1 is shown on page 4.

DIMENSIONS AND WEIGHTS
Minimum window width 388 mm
Maximum window width 888 mm
Maximum sash area 1,45 m^2
Maximum sash weight 40 kg

COMPONENTS

Hinges
There are 6 modules (M4-M8), depending on the sash width.
Hinges have frameplates and sash anchor plates which are respectively screwed to the inside of the frame jamb, and above and below the sash. All hinges are fitted with a safety catch which allows two opening positions. The initial opening meets safety regulation requirements and the second is a wider ventilation position whilst ensuring the window doesn't blow open or closed.
In addition the safety catch functions as a washing position lock when the frame is completely turned around.

Headslide
This guides the sash, running in a u-channel located in the top of the frame. It is important that it's rotation point is towards the outside of the sash head to ensure the sash doesn't foul the gasket when reversed.

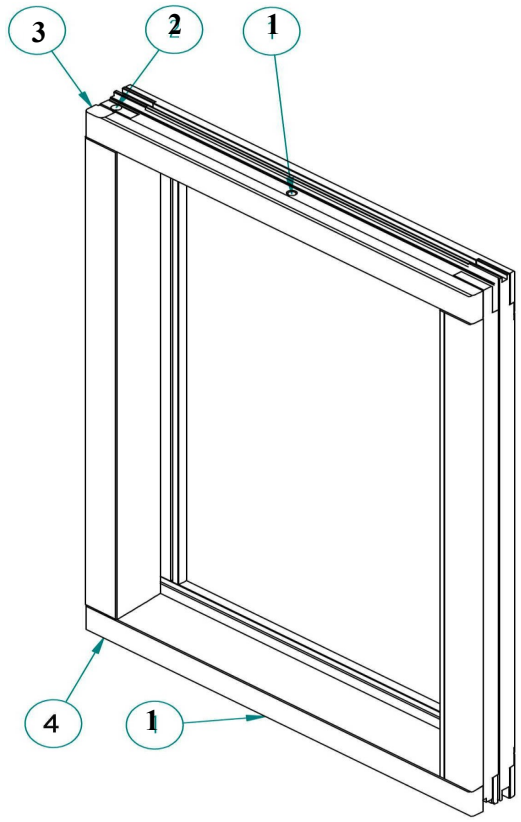
Pivot slide
This unit fits under the sash near it's inner corner and runs on a rail fixed to the top of the frame sill. It's rotation point has to match that of the head slide. See over.

U-profile
PP-channel (polypropylene) supplied in rolls of 500 m. Detail A shows the groove with inset U-channel.

Profiles
The inside of the frame head requires a groove for the u-channel 11.5mm deep and 9.2mm wide. See detail A.
The top and under edges of the sash require a groove to accept their respective sash anchor plates, head slide and pivot slide. Correct positioning is vital to ensure rotation of the sash to the reverse washing position.

The inside edge of the sash jamb on the hinged side must be rounded (with a radius or chamfer) to ensure it slides past the gasket.
The outside gaps between sash and frame should be min. 3mm. Between frame head and sash min. 5mm and lower sash and sill minimum 18,5 mm.

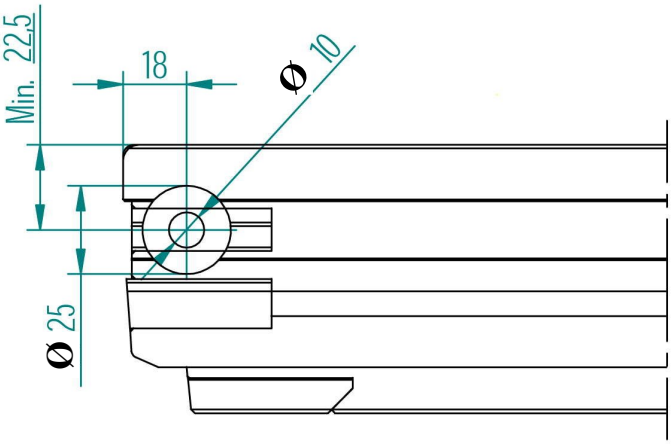
Drilling and routing



Dimensions and weights
1) Hole Ø8,0 mm for centre sash fitting
2) Hole Ø10,0 mm for top sash fitting
3) 3,0 mm slot for frame plate
4) Stepped holes Ø25,0 mm and Ø10 mm for pivot slide (fitted under sash)

Rotation point
The head slide and pivot slide must be a minimum of 22,5 mm in from the outside of the sash and a maximum of 18,0 mm from the inside edge of the sash.
It is important that their rotation points are far enough to the outside of the sash that it does not foul the gasket when reversed.

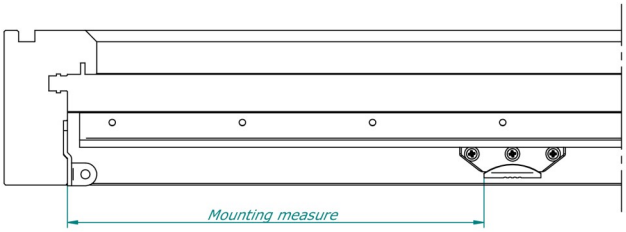
Pivot slide (fitted under sash)
Relevant hole details are shown in the drawing, the depth is relative to the distance between the lower sash edge and the rail fitted to the frame cill.



HINGE MODULES / WINDOW SIZES							
		M4	**M5**	**M6**	**M7**	**M7,5**	**M8**
W min	mm	388	488	588	688	738	788
W max	mm	487	587	687	787	837	888

W = Width outer frame.
Modules might vary with different profile dimensions
AS Spilka Industri can advise on this as necessary.

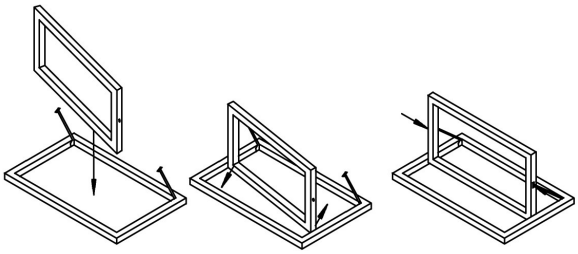
End keeps
Example of drilling for end keeps.
Measurements can vary.



Window Width	Hinge	Assembly measurements
388-487	M4	147 mm
488-587	M5	197 mm
588-687	M6	247 mm
688-787	M7	297 mm
738-837	M7,5	322 mm
788-888	M8	347 mm

Overall frame width .
Measurements can vary according to profile dimensions.
AS Spilka Industri is helpful with relevant calculations.

ASSEMBLY

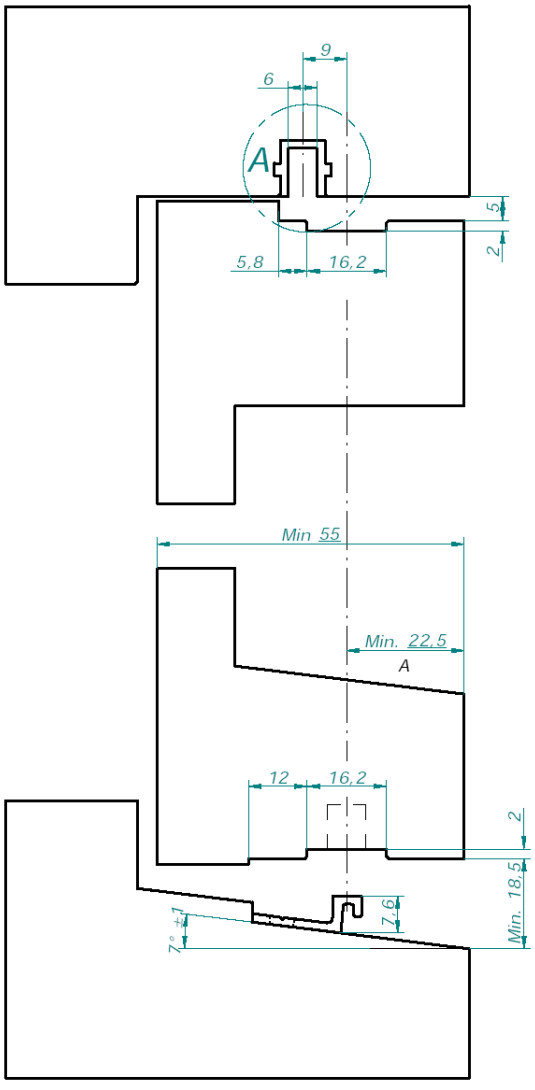


1. U-channel fitted in frame head.
2. Hinges screwed into frame jambs.
3. Rail screwed onto frame cill.
4. Parking wedge screwed to frame cill.
5. End keep screwed to frame cill.
6. Head slide screwed to top of sash.
7. Pivot slide screwed to under edge of sash.

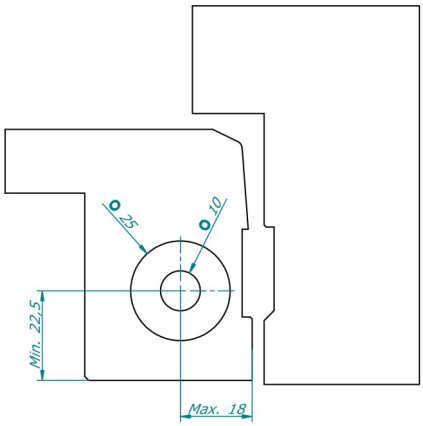
Frame and sash assembly procedure:

1. Frame is placed on bench outer face up.
2. Hinges are fully opened out.
3. Holding the sash diagonally, insert the head slide into the u-channel and place the pivot slide over the rail on the frame cill. Ensure that the widest part of the pivot-slide is fitted to the inside. The locating pin on the sash anchors is pushed into the pre-drilled holes before fixing with screws into the top and bottom of the sash.

Recommended fixing screws:	Part no.	Description
Rail on frame cill	19232	3,8x19 A2 flange head
Parking block cill frame	19234	4,0x20 A2 countersunk
End keep cill frame	19234	4,0x20 A2 ”
Frame plate frame jamb		4,0x30 A2 ”
Head slide frame head		4,0x30 ”
Pivot slide under sash		4,0x30 A2 ”
Sash anchor plates top/under sash		4,0x30 A2 ”



CRITICAL MEASUREMENTS



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