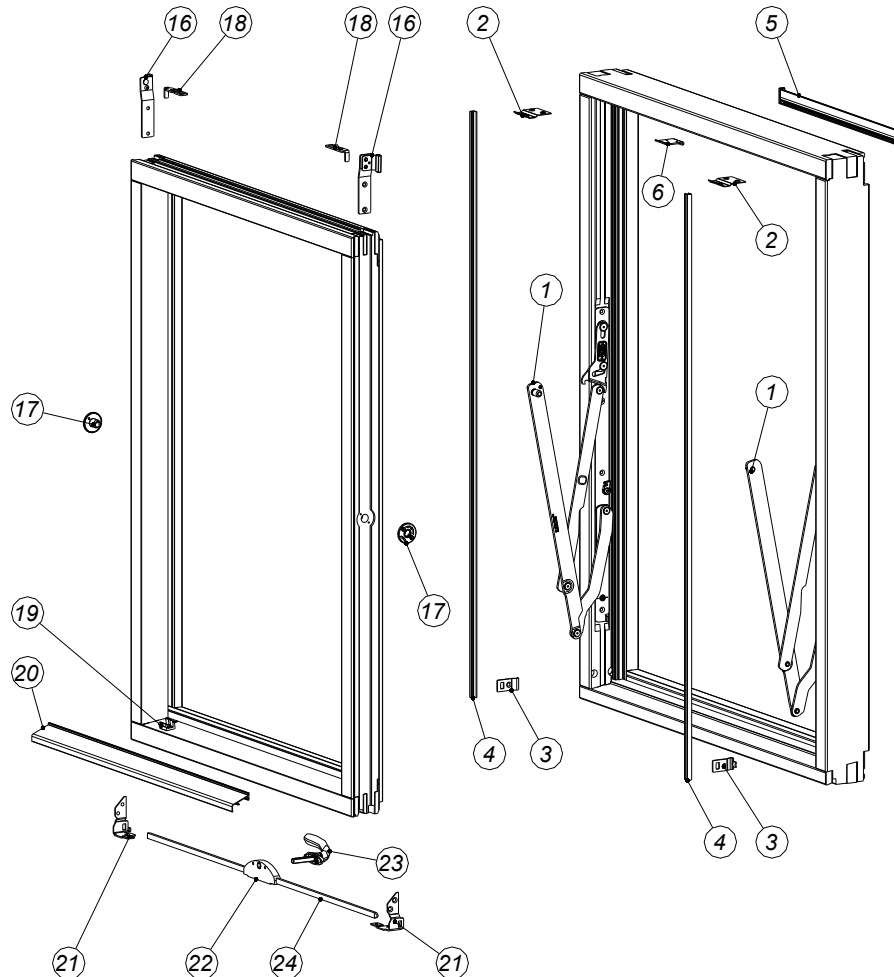


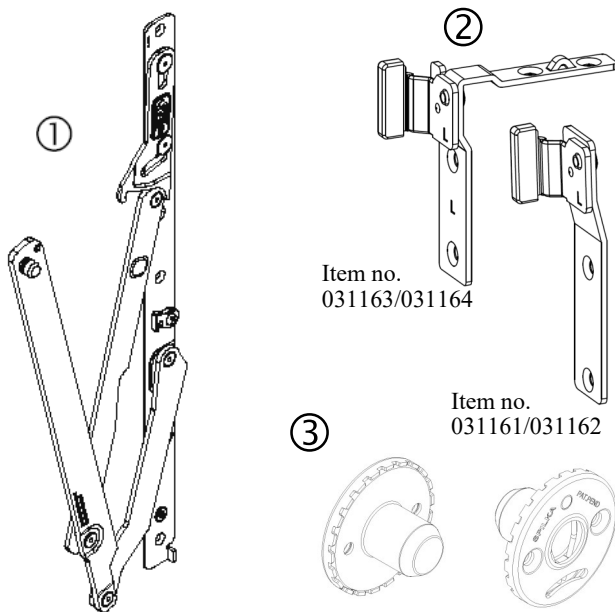
Updated: 07.07.2021



Item	Components, frame	Item	Components, sash
1	HINGE	16	HEAD SLIDES
2	END KEEP HEAD	17	CENTRE SASH ASSEMBLY
3	END KEEP	18	SECURITY DETAIL OPUS
4	U-PROFILE	19	CLIPS FOR GLAZING BEAD
5	SPILVENT VENTILATOR	20	GLAZING BEAD
6	CENTRE SASH KEEPS	21	GUIDES
		22	LOCKBOX
		23	HANDLES AND ACCESORIES
		24	ESPAÑOLETTE RODS
			CLIPS FOR BARS AND ACCESSORIES

* Please be aware that product illustration may vary to the physical product due to amendments and development.

COMPONENTS



Hinges ①

There are 6 hinge sizes (A1-A6), depending on the window height. The hinges are fixed by screws into the frame jambs. All sizes have a safety catch and sizes A3-A6 also include a device to prevent the sash blowing closed. Spilka also offers two additional sizes in HD (heavy duty) that allows a higher weight, A5 and A6.

Head slides ②

These components couple the sash to the frame. It is important that the head slide's rotation point is as far out as possible so the sash does not foul the weather-strip when reversed.

Windows with sash weights above 55kg must be assembled with head slides made for Heavy Duty. *

Rondo Centre sash assemblies ③

These fittings has a stainless top cover and attach the hinge to the sash.

U-profile ④

PP (polypropylene) deformable profile supplied on 500 m rolls.

Drawing 4 shows channel required and profile dimensions.

Profiles

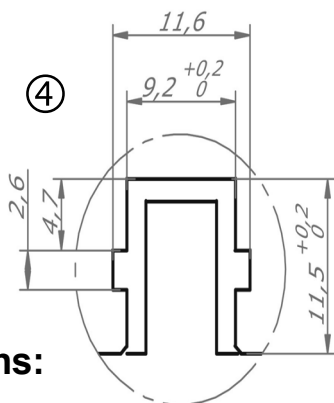
Hinges are fixed in a groove in the inside of the frame jambs, to the outside of the u-profile channel. This 'u-channel' is 11,5 mm deep and 9,2 mm wide.

To allow the sash to reverse a groove on the outside of the sash jambs is used to correctly position the head slides.

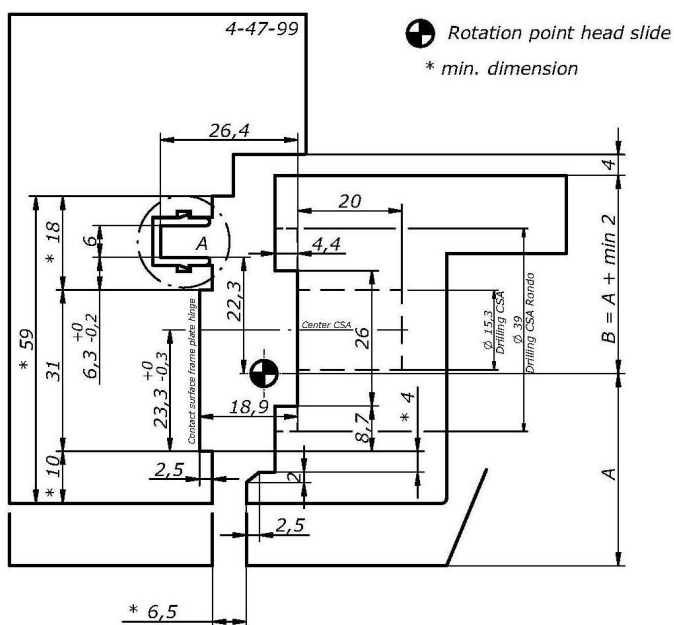
The inner top edge of the sash is rounded (with a radius or chamfer) to allow the sash to easily slide past the weather-strip.

NB! Top and bottom profiles can be different to the side profiles

The outer gap at the sides between sash and frame should be a min 6,5 mm. We recommend a gap of 1-4 mm at the top and between 4-6 mm at the bottom.



Critical dimensions:

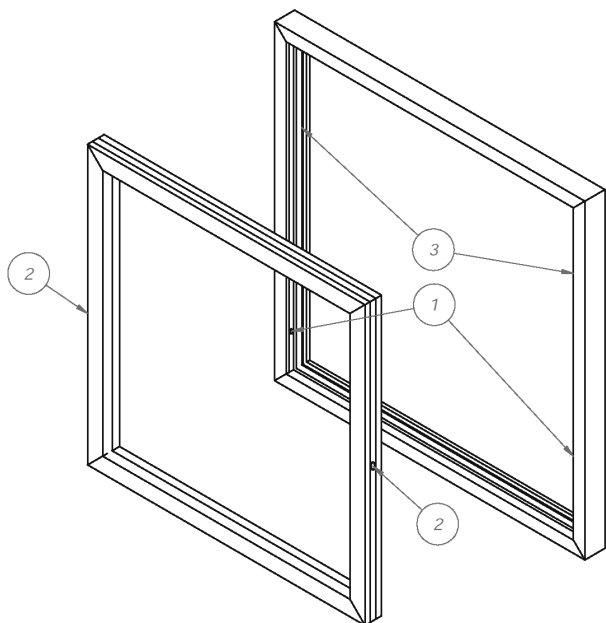


DIMENSIONS AND WEIGHTS

- Min window heights: ca 427 mm outward sash
- Max window heights: 1588 mm outward sash
- Max frame weight: A1 and A2 - 40 kg
- A3 and A4 - 50 kg
- A5 and A6 - 55 kg
- HD (heavy duty) A5 og A6 - 80 kg*

* For sash weight above 55 kg head slides with item no. 031163 and 031164 must be used.

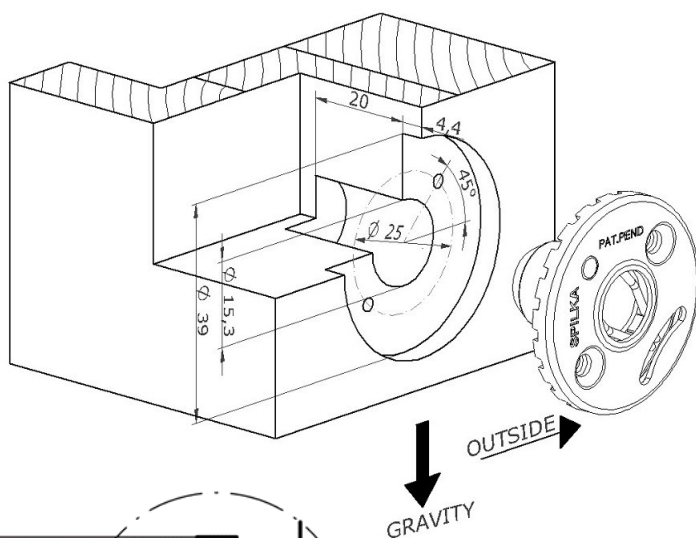
DRILLING AND ROUTING



1. Hole Ø12,3 mm for frame plate adjustment point.
2. Hole Ø15,3 /Ø39 mm for Rondo centre sash assembly.
3. Grove for head slide.

Frame plate

Pre-drill a hole of Ø 12,3 mm for frame plate adjustment point. After positioning the hinge at the correct height it can be adjusted +/- 1,0 mm.

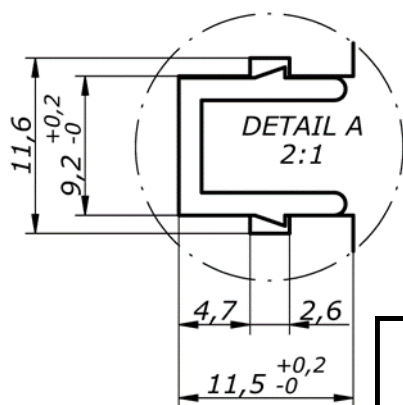


Centre sash assemblies

The starting point for positioning the hinge, is to centre the pivot point 10 mm over the centre of the sash. This will ensure any espagnolette end keeps will not be damaged by the head slide and the sash will remain within the overall window height when reversed.

Positioning may vary according to profile dimensions as will the top and bottom gaps between the sash and frame. Therefore specific calculation should be made for each profile.

Drill holes are shown on the drawing.



		WINDOW SIZES AND RELEVANT HINGES					
		A1	A2	A3	A4	A5	A6
H min	[mm]	427	531	681	861	1091	1331
H max	[mm]	530	680	860	1090	1330	1588

H = overall frame height.
Measurements can vary according to profile dimensions

ASSEMBLY

1. U-channel and hinges are fitted to frame jambs.
2. The head slides and centre sash assemblies are fitted to sash.

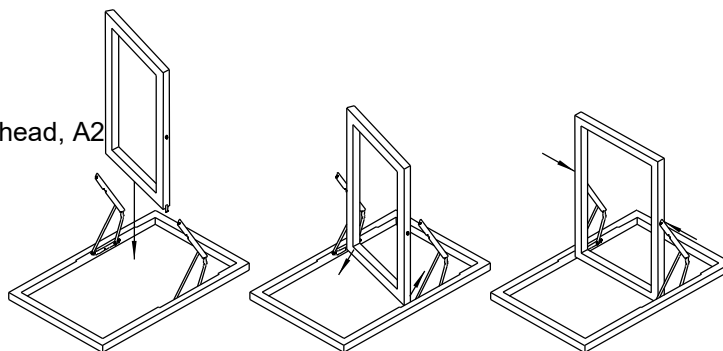
Fitting sash to frame:

1. Frame is laid flat with inside down.
2. Hinges are opened out.
3. The sash is held vertically over frame with head slides down. Tilt the sash diagonally to allow the head slides to be fitted into the u-channel and fit the hinge pivot points into the centre sash assemblies.

(Head slides are treated with a dab of glue to prevent them turning whilst the sash is being fitted into the frame, the bond is broken the first time the sash is reversed.)

Relevant screws

- Hinges $\varnothing 4,5 \times 25$ mm
- Head slides $\varnothing 4,5 \times 25$ mm
- Centre sash ass. Rondo $\varnothing 3,5 \times 25$ mm, small head, A2



Critical dimensions

