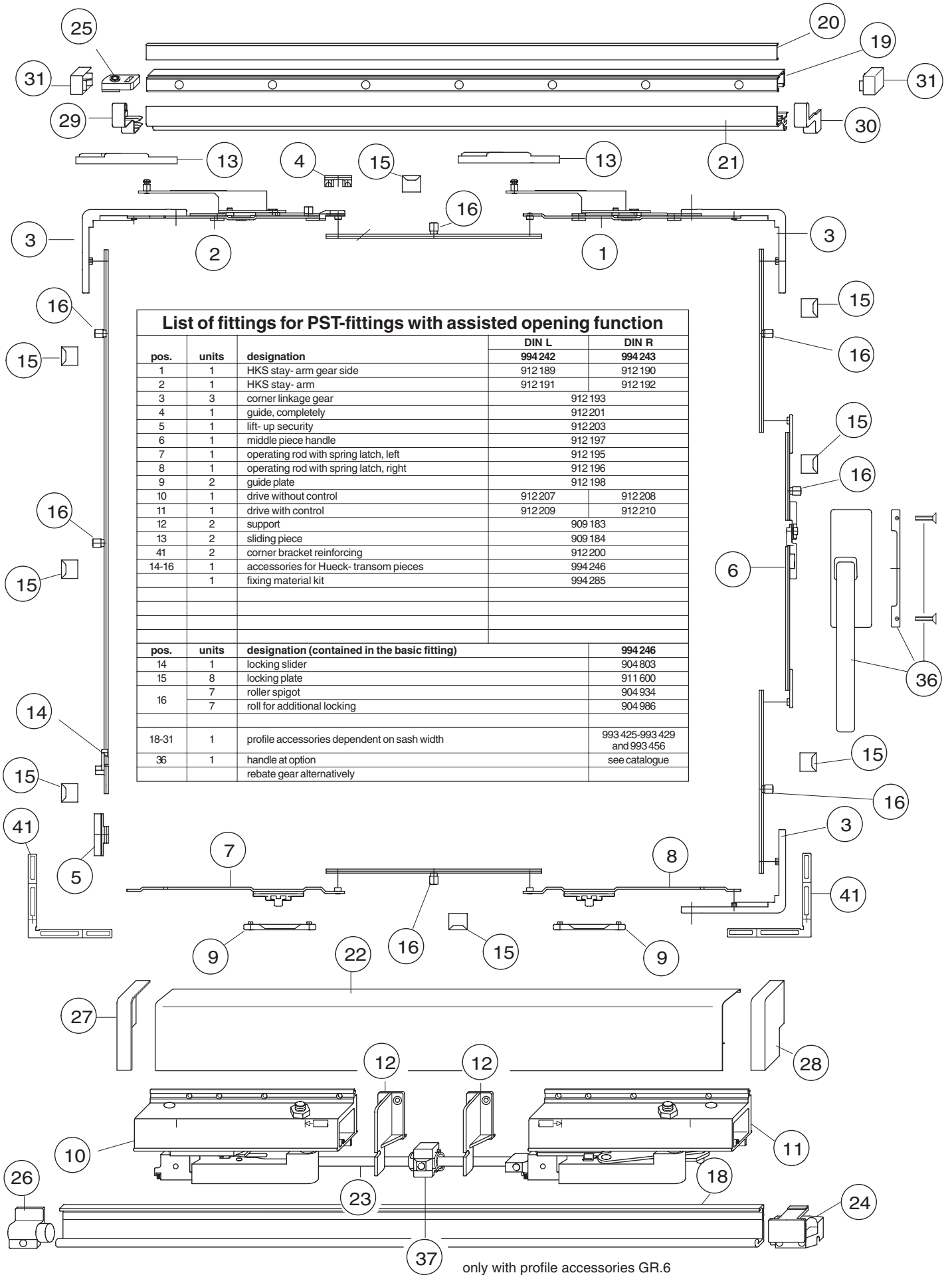


Processing instructions

Parallel sliding and tilting fittings
series HUECK 1.0

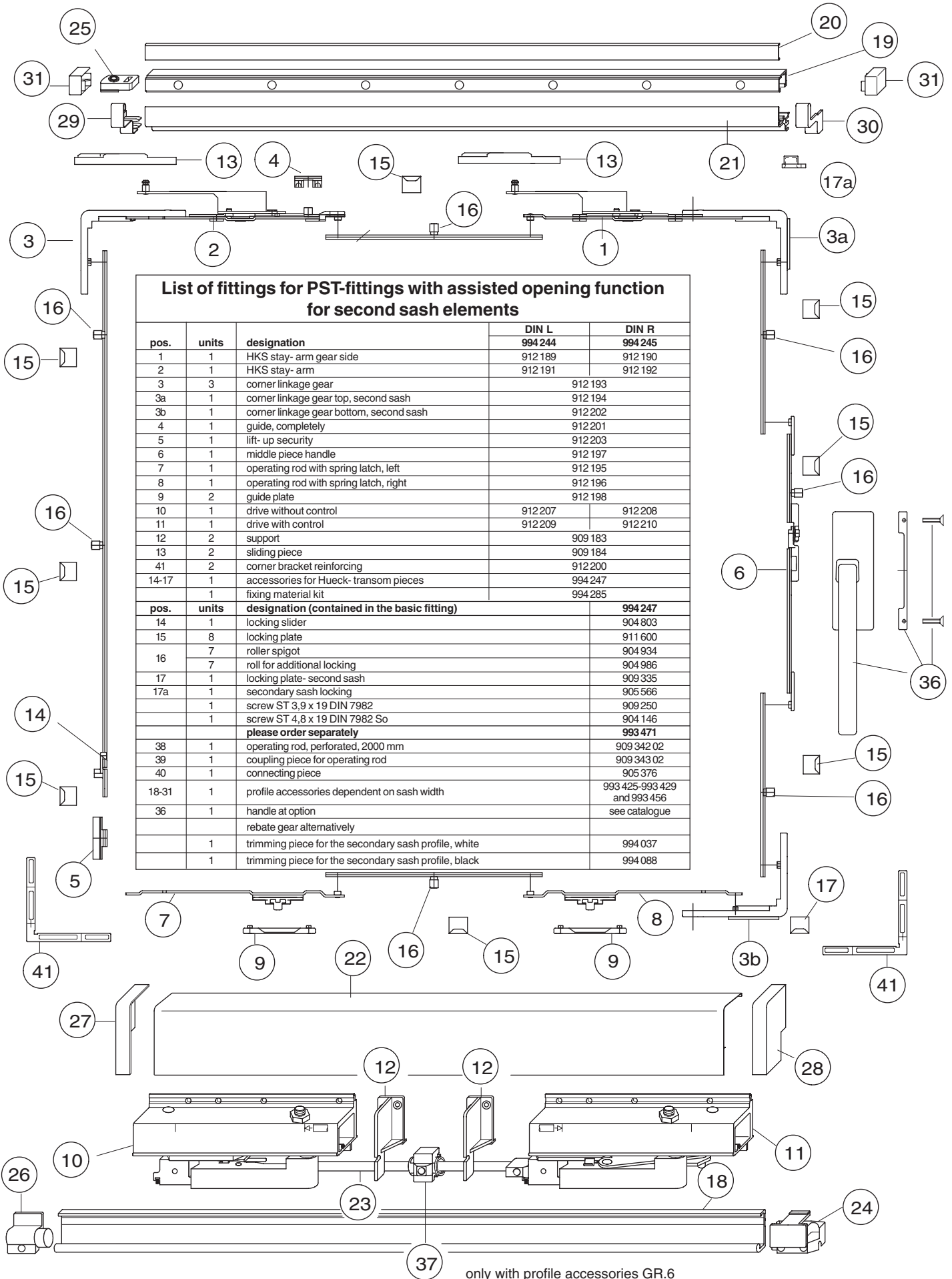
with assisted opening function
max. sash weight 150 kg



List of fittings for PST-fittings with assisted opening function

pos.	units	designation	DIN L	DIN R
			994 242	994 243
1	1	HKS stay- arm gear side	912 189	912 190
2	1	HKS stay- arm	912 191	912 192
3	3	corner linkage gear		912 193
4	1	guide, completely		912 201
5	1	lift- up security		912 203
6	1	middle piece handle		912 197
7	1	operating rod with spring latch, left		912 195
8	1	operating rod with spring latch, right		912 196
9	2	guide plate		912 198
10	1	drive without control	912 207	912 208
11	1	drive with control	912 209	912 210
12	2	support	909 183	
13	2	sliding piece	909 184	
41	2	corner bracket reinforcing		912 200
14-16	1	accessories for Hueck- transom pieces	994 246	
	1	fixing material kit	994 285	
pos. units designation (contained in the basic fitting)			994 246	
14	1	locking slider	904 803	
15	8	locking plate	911 600	
16	7	roller spigot	904 934	
	7	roll for additional locking	904 986	
18-31			1	
profile accessories dependent on sash width			993 425-993 429 and 993 456	
36	1	handle at option	see catalogue	
			rebate gear alternatively	

only with profile accessories GR.6



**List of fittings for PST-fittings with assisted opening function
for second sash elements**

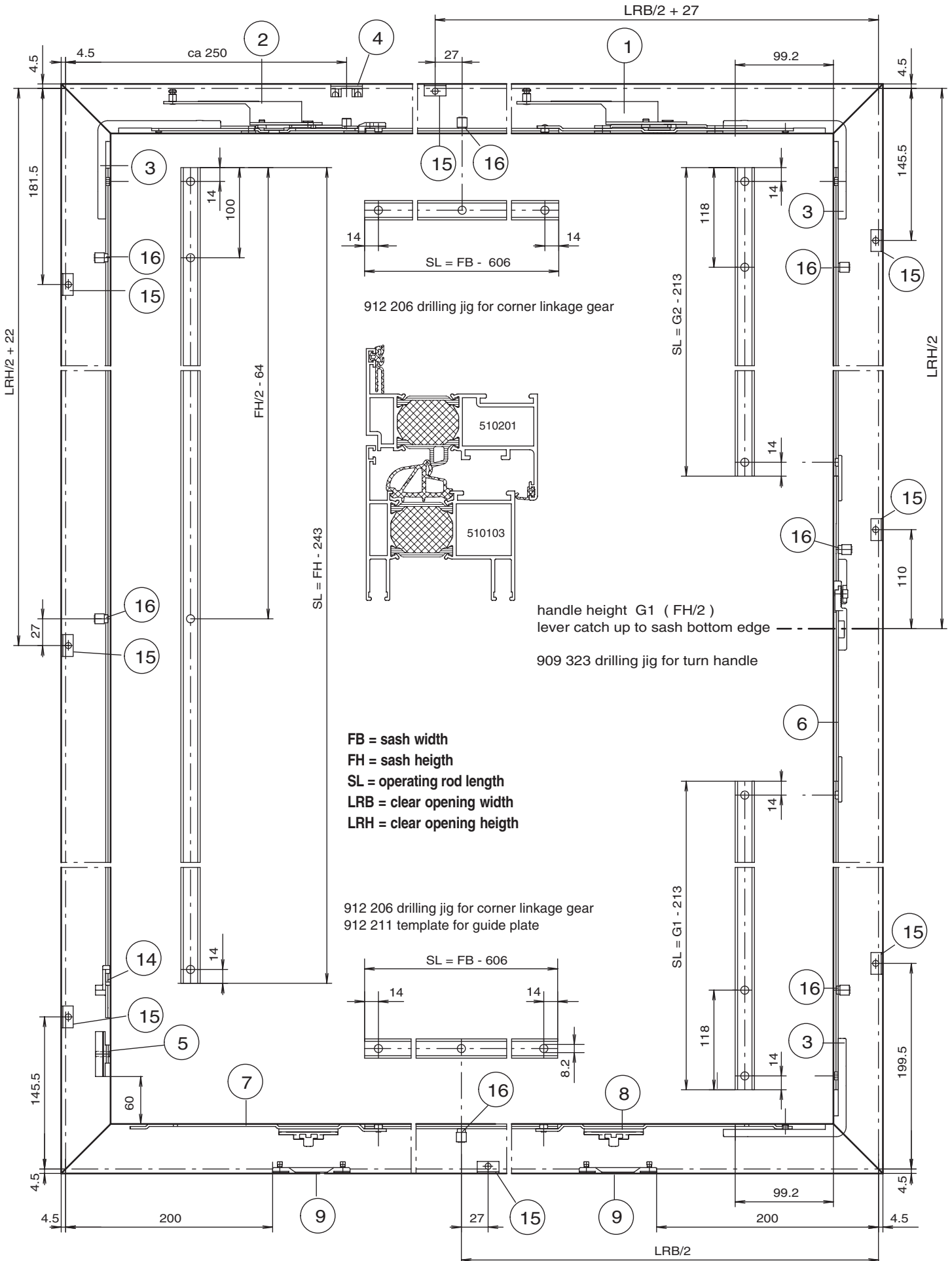
pos.	units	designation	DIN	
			L	R
			994 244	994 245
1	1	HKS stay- arm gear side	912 189	912 190
2	1	HKS stay- arm	912 191	912 192
3	3	corner linkage gear		912 193
3a	1	corner linkage gear top, second sash		912 194
3b	1	corner linkage gear bottom, second sash		912 202
4	1	guide, completely		912 201
5	1	lift- up security		912 203
6	1	middle piece handle		912 197
7	1	operating rod with spring latch, left		912 195
8	1	operating rod with spring latch, right		912 196
9	2	guide plate		912 198
10	1	drive without control	912 207	912 208
11	1	drive with control	912 209	912 210
12	2	support		909 183
13	2	sliding piece		909 184
41	2	corner bracket reinforcing		912 200
14-17	1	accessories for Hueck- transom pieces		994 247
	1	fixing material kit		994 285
pos.	units	designation (contained in the basic fitting)	994 247	
14	1	locking slider		904 803
15	8	locking plate		911 600
	7	roller spigot		904 934
16	7	roll for additional locking		904 986
17	1	locking plate- second sash		909 335
17a	1	secondary sash locking		905 566
	1	screw ST 3,9 x 19 DIN 7982		909 250
	1	screw ST 4,8 x 19 DIN 7982 So		904 146
		please order separately		993 471
38	1	operating rod, perforated, 2000 mm		909 342 02
39	1	coupling piece for operating rod		909 343 02
40	1	connecting piece		905 376
18-31	1	profile accessories dependent on sash width		993 425-993 429 and 993 456
36	1	handle at option rebate gear alternatively		see catalogue
	1	trimming piece for the secondary sash profile, white		994 037
	1	trimming piece for the secondary sash profile, black		994 088

only with profile accessories GR.6

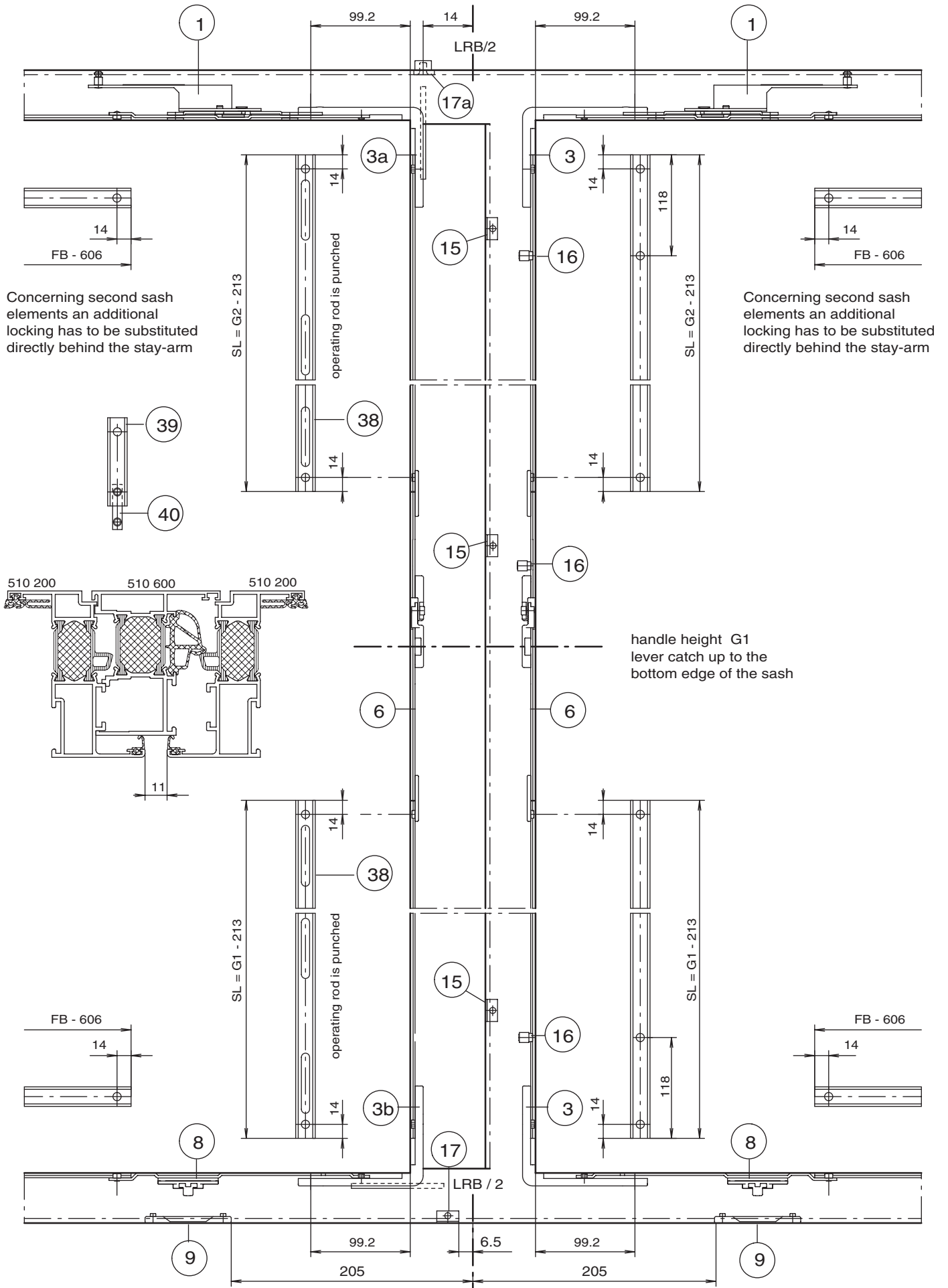
Profile accessories set, dependent on the sash width

dimension 1: sash width 650 - 930 mm
 dimension 2: sash width 931 - 1080 mm
 dimension 3: sash width 1081 - 1280 mm
 dimension 4: sash width 1281 - 1480 mm
 dimension 5: sash width 1481 - 1650 mm
 dimension 6: sash width 1651 - 1850 mm

pos.	units	designation	dimension 1 993 425 02/64	dimension 2 993 426 02/64	dimension 3 993 427 02/64	dimension 4 993 428 02/64	dimension 5 993 429 02/64	dimension 6 993 456 02/64
18	1	roller rail	909 185	909 186	909 187	909 188	909 242	909 314
19	1	slide rail	909 189	909 190	909 191	909 192	909 243	909 315
20	1	screw adhesive masking tape	909 193	909 194	909 195	909 196	909 244	909 316
21	1	holding rail	909 197	909 198	909 199	909 200	909 245	909 317
22	1	cover profile	909 201 02/64	909 202 02/64	909 203 02/64	909 204 02/64	909 246 02/64	909 318 02/64
23	1	connecting rod	909 205	909 206	909 207	909 208	909 247	909 319
24	1	guide setting block	909 209					
25	2	fixing piece, top	909 210					
26	1	fixing piece, bottom	909 211					
27	1	cover cap, bottom left	909 212 02/64					
28	1	cover cap, bottom right	909 213 02/64					
29	1	cover cap, top left	909 214 02/64					
30	1	cover cap, top right	909 215 02/64					
31	2	cover cap-guide	909 216 02/64					
37	1	support						909 372
	50	screw ST 3,9 x 19 DIN 7982	909 250					
	15	screw ST 3,9 x 9,5 DIN 7981	909 249					



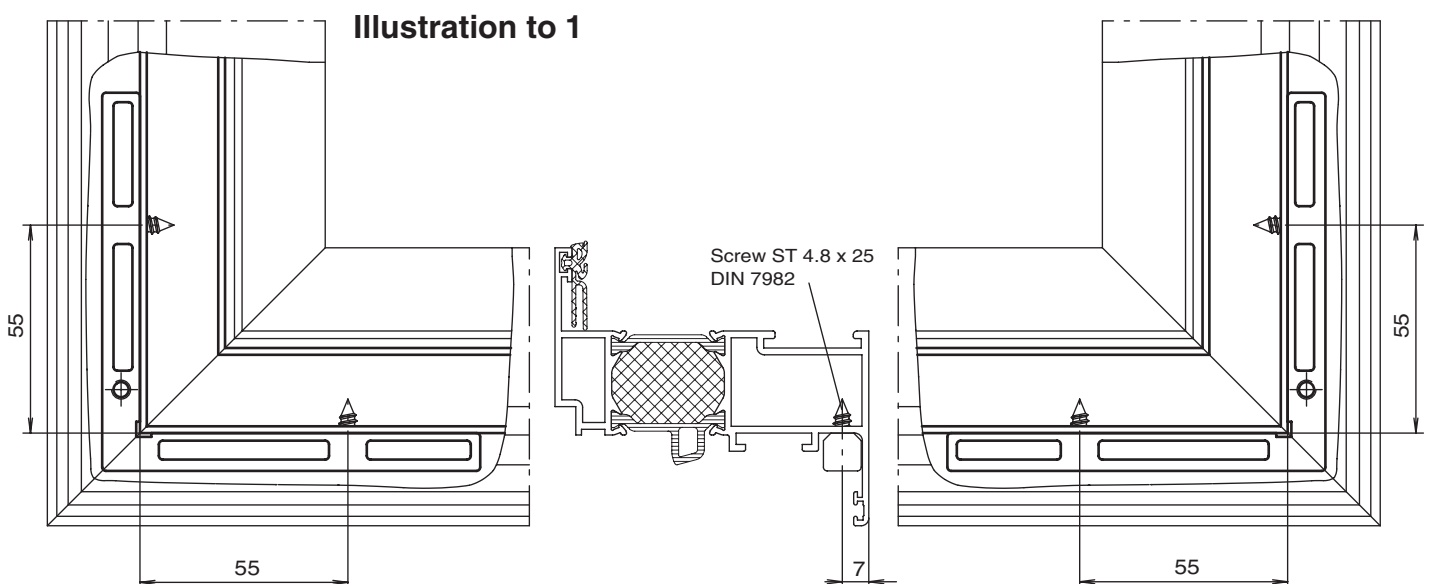
FB = sash width
FH = sash height
SL = operating rod length
LRB = clear opening width
LRH = clear opening height



Assembly sequence:

The sash drilled with smaller holes first lies on the inside.

1. Slide the reinforcing angle (pos. 41) in the sash corner, drill $\varnothing 4,2$ mm and fix it with screws ST 4,8 x 25. The corner chevron 911 616 does not apply in these two sash corners.
2. Cut the two handle side operating rods into length and punch $\varnothing 8,2$ mm, with the punching tool 991 870.
Lower operating rod = G1 - 213 mm (G1 = handle height).
Upper operating rod = G2 - 213 mm (G2 = sash height - G1).
Cut the adverse vertical operating rod into length and punch it.
Operating rod length = sash height FH - 243 mm.
3. Cut horizontal operating rod into length and punch the operating rod top and bottom sash width FB - 606 mm.
From a sash width ≥ 930 mm, an additional lock has to be placed in centre (pos.16).
Slide the handle side operating rod together with the centerpiece in the operating rod channel.
The housing for the handle nosing points to the top.
Slide the adverse vertical operating rod in.
Couple the two lower spring latches with the operating rod.
The spring latches are marked left and right.
The straight side of the spring latch points to the sash over lap.
4. Couple the stay-arms with the operating rod.
Both stay-arms point away from the handle side.
Please attend the designation of the stay-arms:
GOR = handle side top right
GOL = handle side top left
OR = top right
OL = top left
5. Connect the corner linkage gear on handle opposite side with the vertical operating rod and the stay-arm at the top and screw the corner linkage gear.
Turn the stay-arm package into opening position.
6. Couple the corner linkage gear (on handle side) with the stay-arm GOL/GOR and the vertical operating rod at the top and screw the corner linkage gear.
7. Position and screw the guide (pos. 4) like stated.
8. Couple the gear box handle (pos. 36) to the centerpiece and fix the handle with the screwing plate at the sash.



9. Mounting the drives:

Align the drives in a way that a distance dimension of 4mm remains between the outer edge of the sash and the tandem roller. Screw the drive (with guide) on the gear side (handle side).

Attention! Fix the tandem roller exactly horizontally.

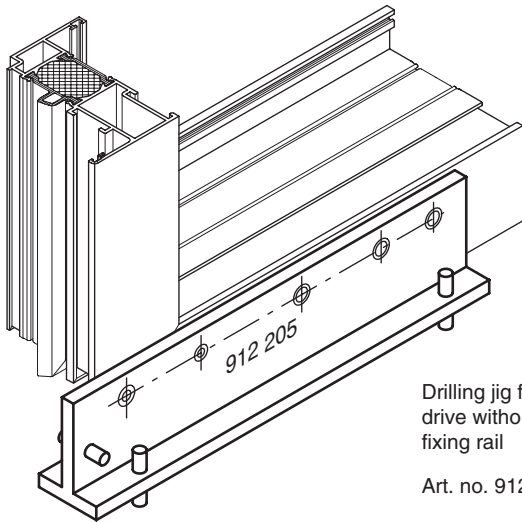
10. Evenly distribute the support pieces (pos. 12) to the sash width and fix it on the sash. (distance ca. 1/3 sash width).

11. Cut the connecting rod (pos. 23) into length, slide it in the drives and fix it with key SW 4. Rod length = $FB - 340$ mm, (see the mark at the drive).

Hint:

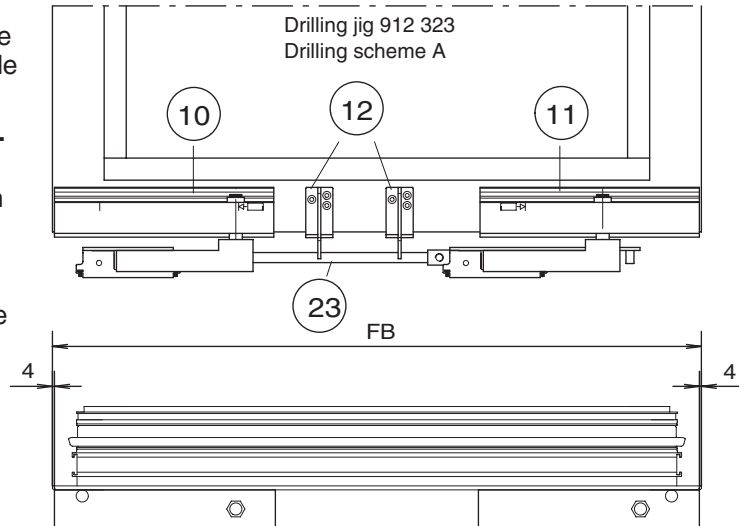
With wide sashes ($FB > 1650$ mm) we recommend to slide the support (pos. 37) in the connecting rail and to fix it.

See drawing page PST 2.

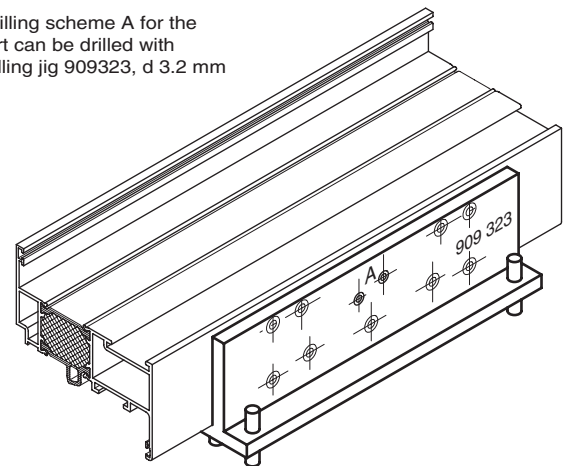


Drilling jig for drive with guide,
drive without guide
fixing rail

Art. no. 912 205



The drilling scheme A for the support can be drilled with the drilling jig 909323, d 3.2 mm

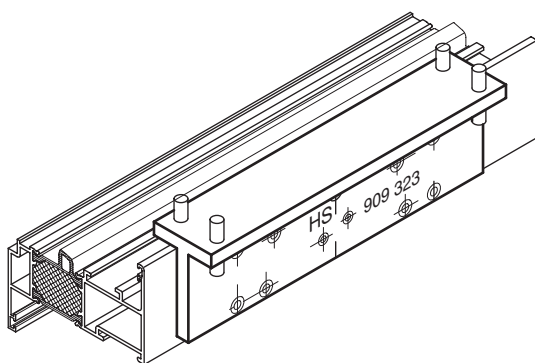
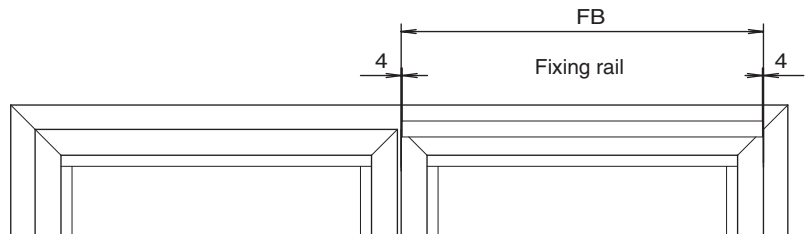


12. Cut the fixing rail into length and screw it from behind at the upper sash lap over the frame.

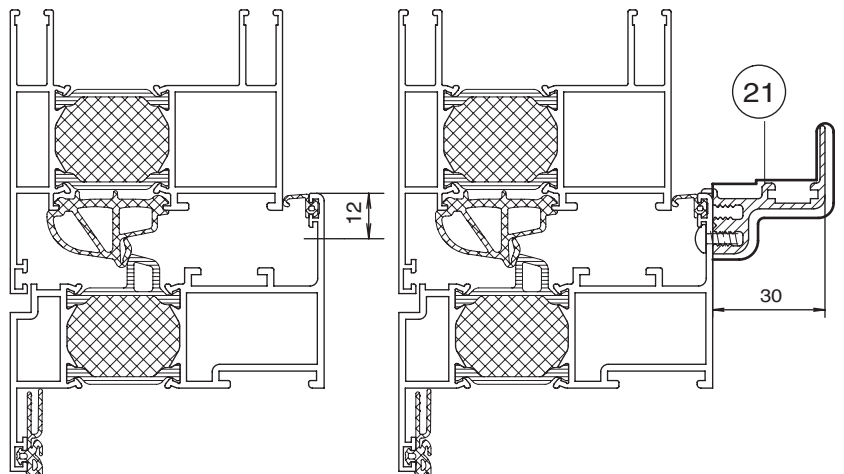
Do not screw it within the stay-arm area!

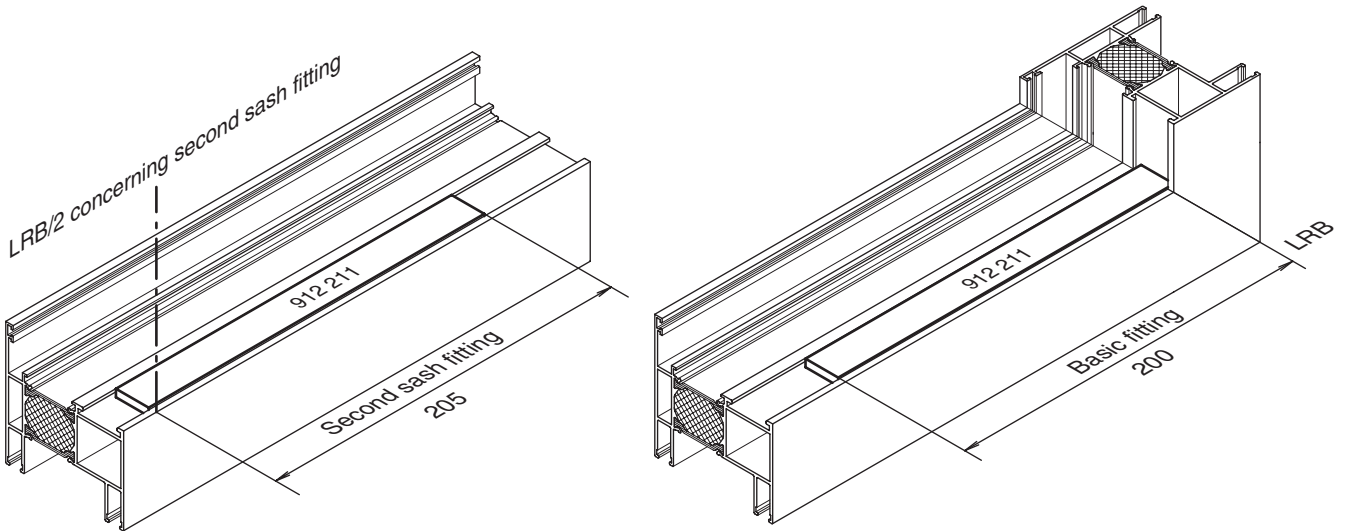
Fixing rail length = $FB - 8$ mm.

Attach the covers pos. 29 and 30 to the fixing rail.



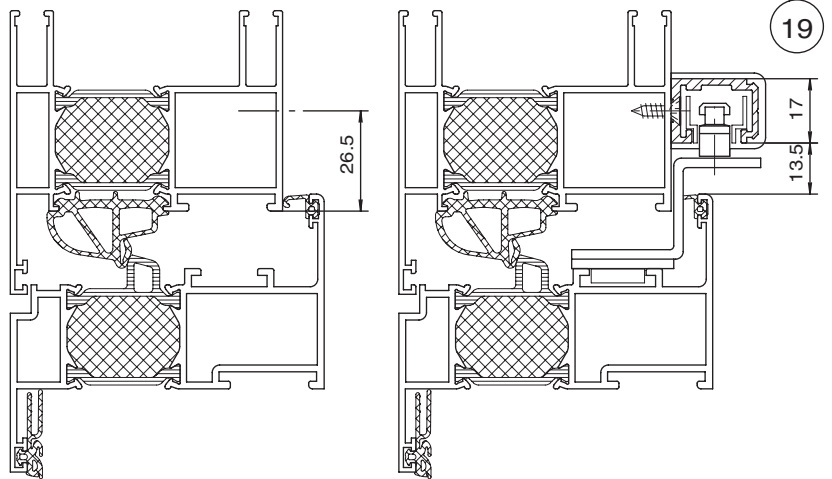
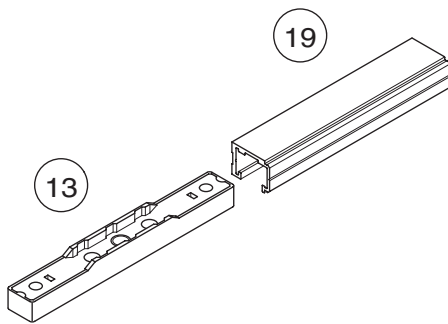
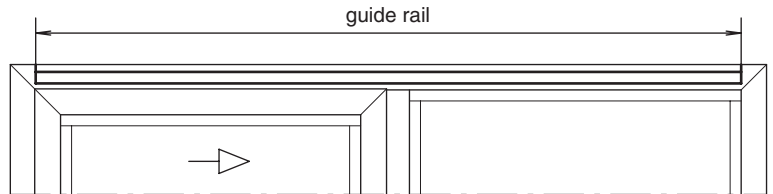
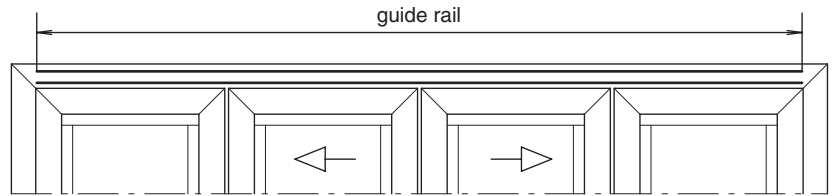
The drillings for the fixing rail can be carried out with the drilling jig 909 323 drilling scheme HS d 4.2mm





Assembly at the fixed frame

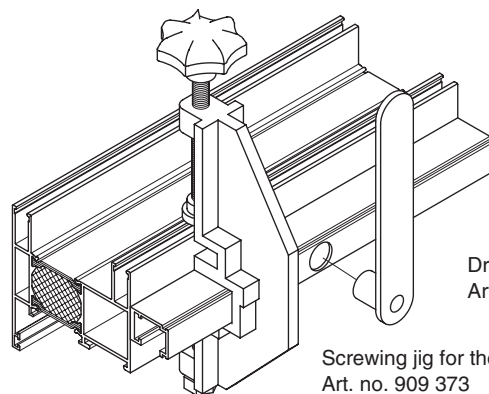
13. Clamp the strike plate (pos. 15) on the fixed frame according to the predetermined dimensions.
Position and clamp the guide plate (pos. 9) at the fixed frame with the gauge Art. No. 912 211.
14. The guide piece (on frame side) has to be fixed in the frame groove according to the stated dimensions.



15. Cut the guide rail (pos. 19) into length and fix it at the upper frame profile.
For this matter, the drilling jigs 909 373 and 909 375 can be used.
rail length = clear frame width (LRB)

The distance between the sash over lap and the lower edge of the guide rail amounts to 13.5 mm (control dimension).

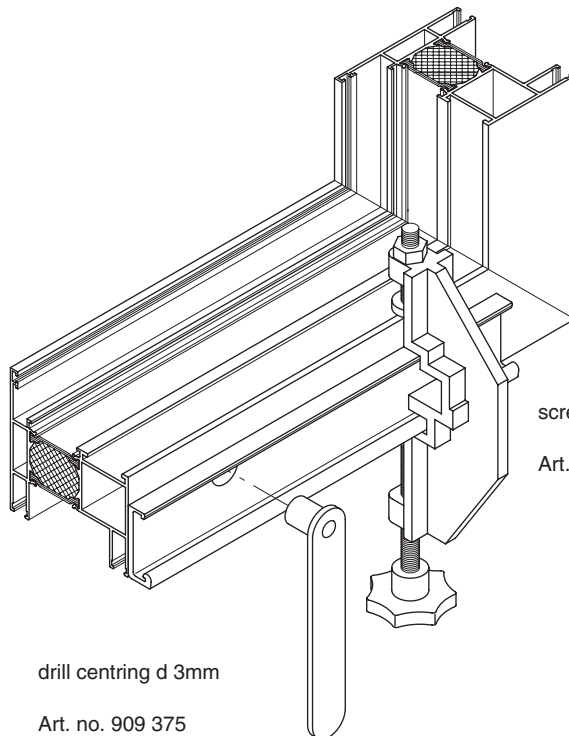
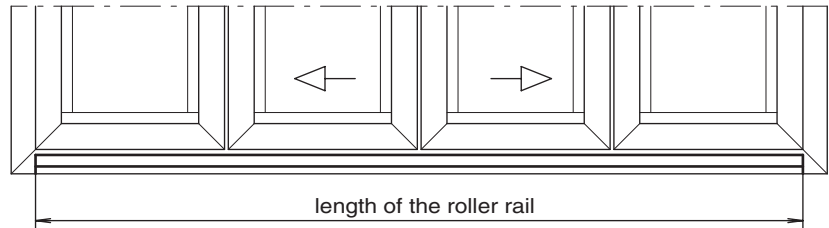
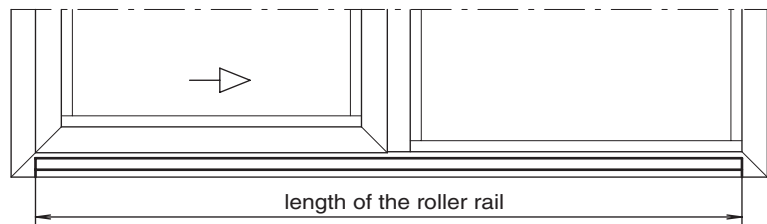
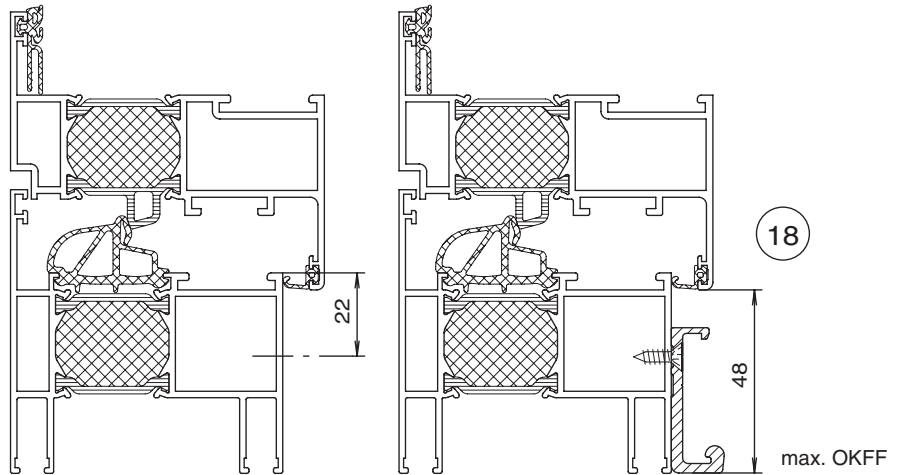
16. Slide the sliding piece (pos. 13) in the guide rail. Cut the screw cover profile (pos. 20) into length and snap it onto the guide rail.



Drill centring tool d 3 mm
Art. no. 909 375

Screwing jig for the guide rail
Art. no. 909 373

17. Cut the roller rail (pos. 18) into length and assemble it.
 length of the roller rail = LRB + 9 mm
 (LRB = clear frame rebate width).
 For assembly, the screwing jigs 909 374 and 909 375 can be used.
 The distance between lower edge of the sash and lower edge of the roller rail amounts to 48mm. (control dimension).



screwing jig for roller rail
 Art. no. 909 374

drill centring d 3mm
 Art. no. 909 375

Insertion of the sliding sash

18. Turn the fitting into sliding position. The handle position has to be horizontal. Put the sash angularly onto the roller rail (pos. 18) and let the stay-arm arbor snap in the center hole of the sliding piece (pos. 13).

Unhinging of the sliding sash

Turn the sash into sliding position. Press the spring in the sliding piece apart with a screw driver or similar. Pull the stay- arm down, place the sash angularly and single it out of the roller rail.

Regulate the sash

19. Clamp the guide setting block pos. 24 at the roller rail, first with one screw.

Attention:

The position of the guide setting block specifies the rebate space.

If necessary, the guide setting block can be adjusted accordingly.

Afterwards screw both screws tightly.

20. Check and adjust the parallelism towards sliding direction.

Unscrew the clamping screw for the connecting rod (pos. 23) at the drive (with guide pos. 11), align the sash parallel and fix the screw again.

21. Check the height adjustment and if necessary adjust it. The drives contain a height adjustment of ± 3 mm.

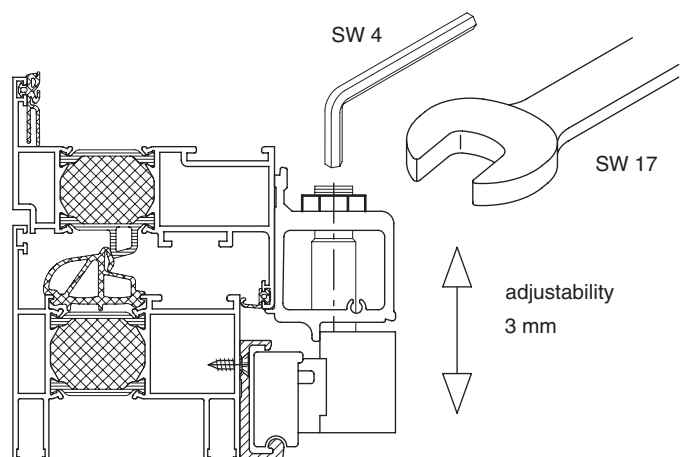
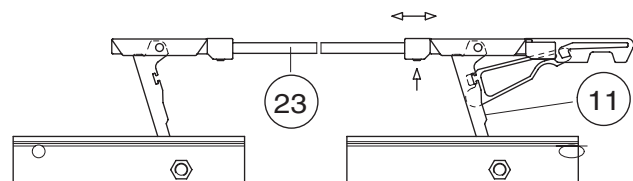
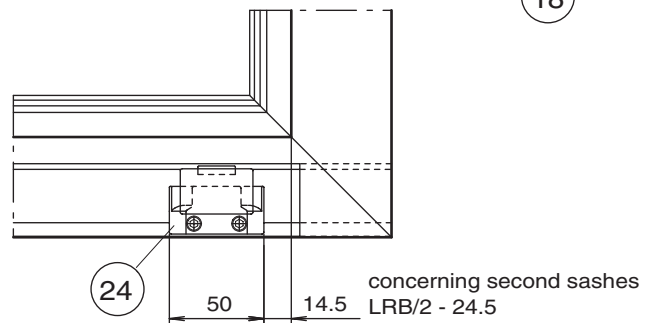
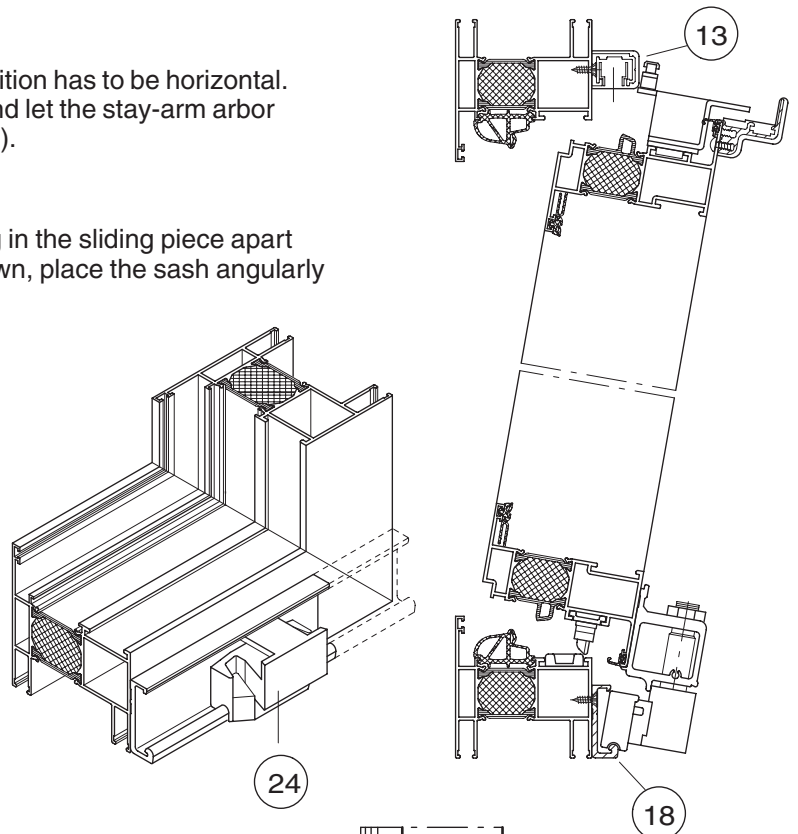
Carry out the height adjustment with an inner hexagon key SW 4 and secure it with a spanner SW 17.

22. Cut the cover profile (pos. 22) into length at the bottom.

(FB – 8 mm)

total length = mark on the drives

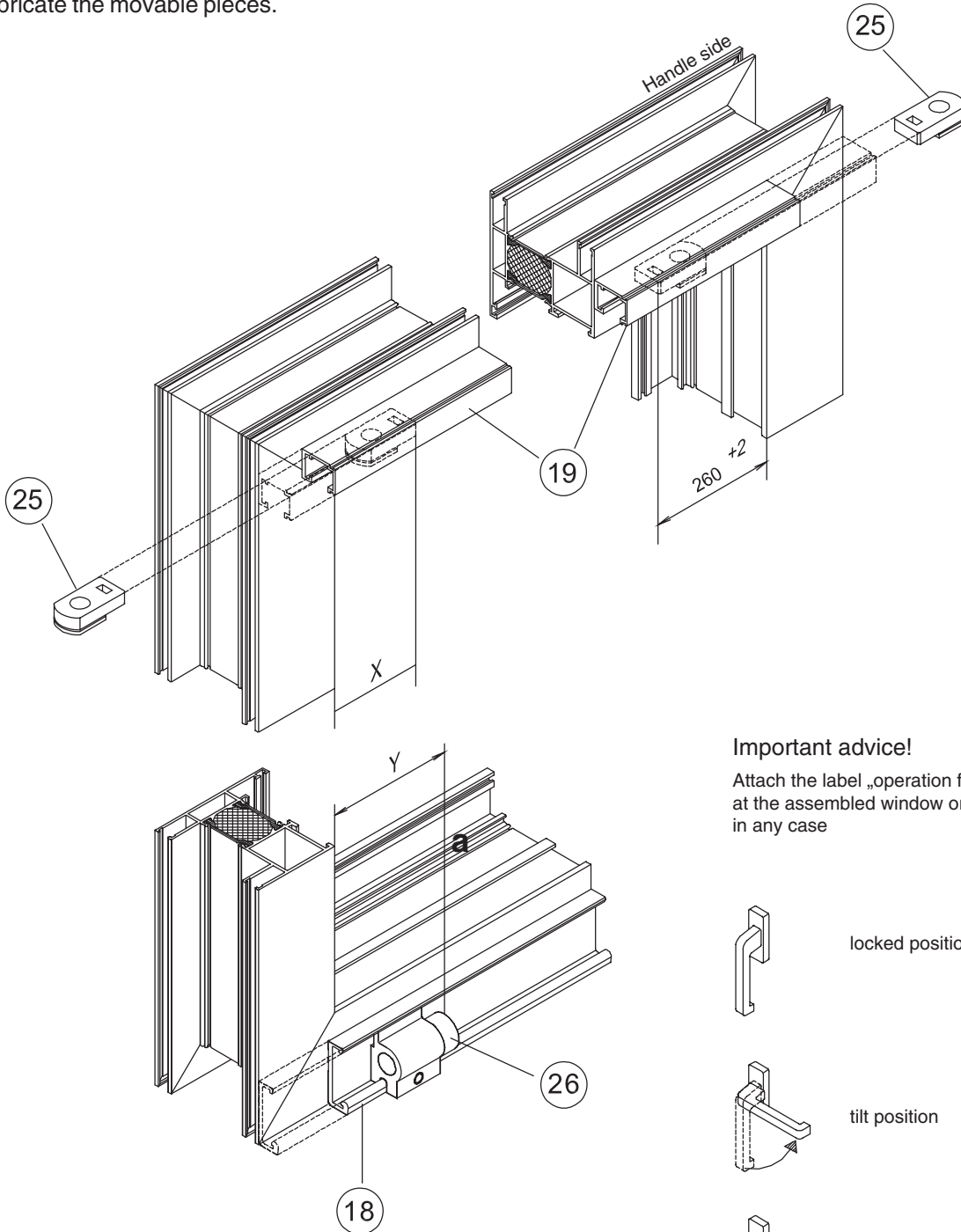
Snap in the cover profile and the cover.



23. Clamp the lower stopper (pos. 26) in the roller rail (pos. 18).
 Fix the upper stopper (pos. 25) in the guide rail (pos. 19).
 Pay attention to an even limit stop at the top and at the bottom (dimension X).

Mount a supplementary stopper on the handle side. The distance between the clear frame rebate and the leading edge should amount to 260 mm. Attach the covers on the side onto the guide rail.

24. Test the functionality of the fitting, and oil or lubricate the movable pieces.

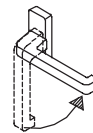


Important advice!

Attach the label „operation function“
 at the assembled window or door
 in any case



locked position



tilt position



sliding release
 not catching when locking



sliding position
 catching when locking

