figure 1

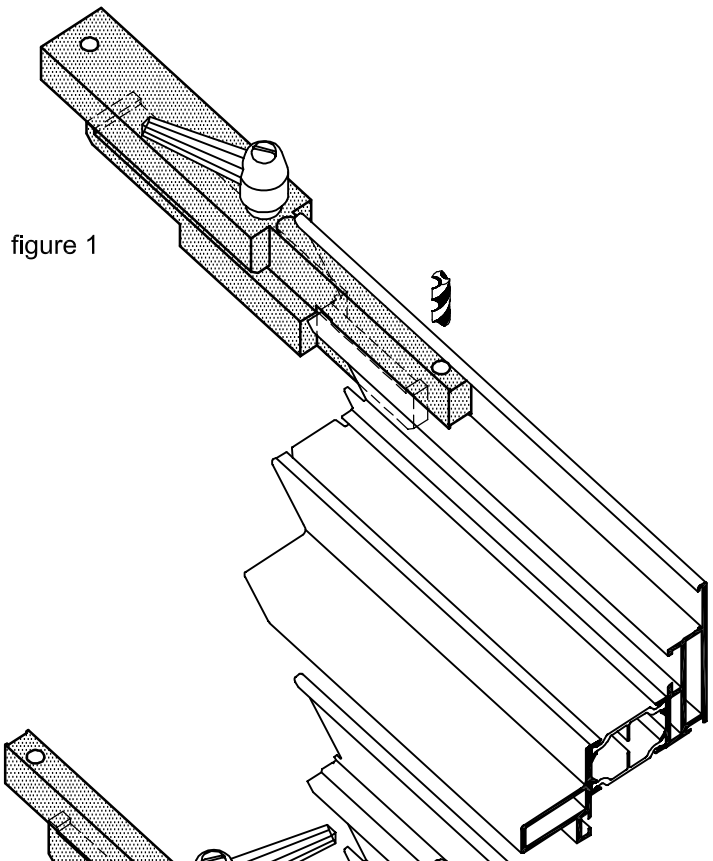


figure 2

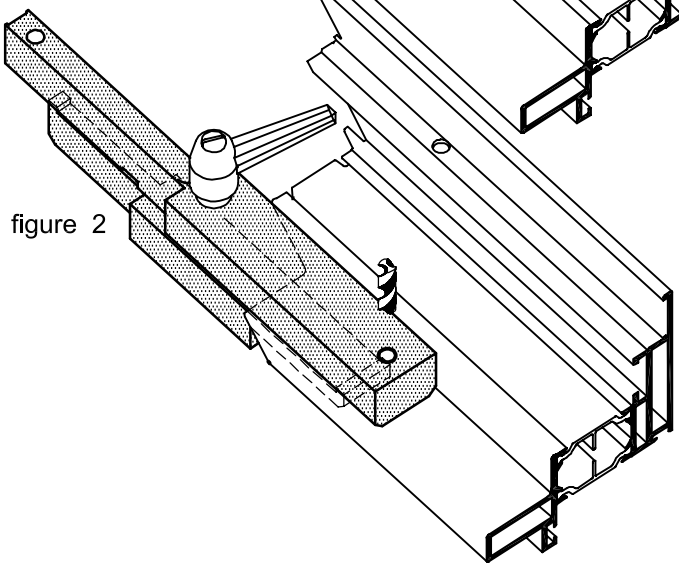
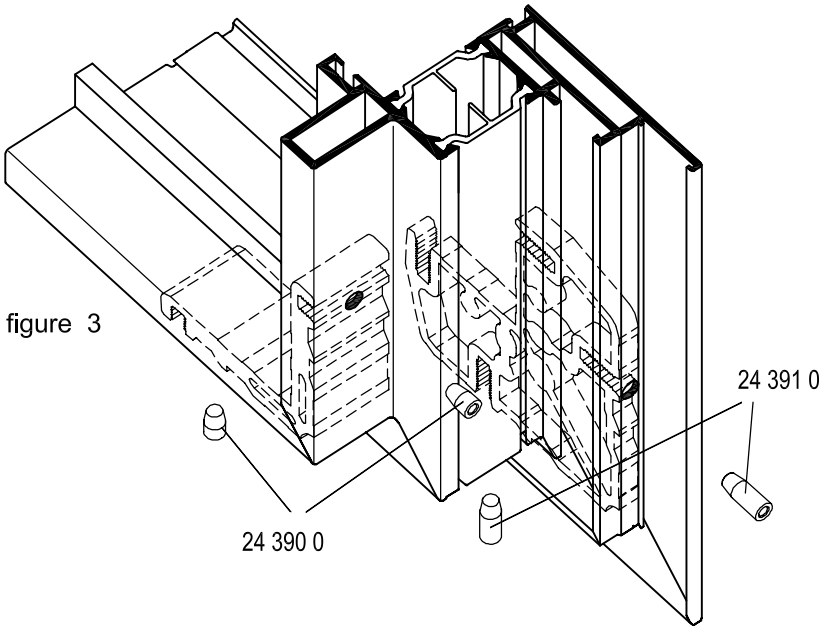


figure 3



CORNER CONNECTION

Sash profile 52 487 0

Pegging

Figure 1 and 2

	pegging
drill holes per corner	4
drill hole diameter [mm]	5,8
position	horizontal and vertical profile end pieces
drilling jig	22 104 0

figure 1

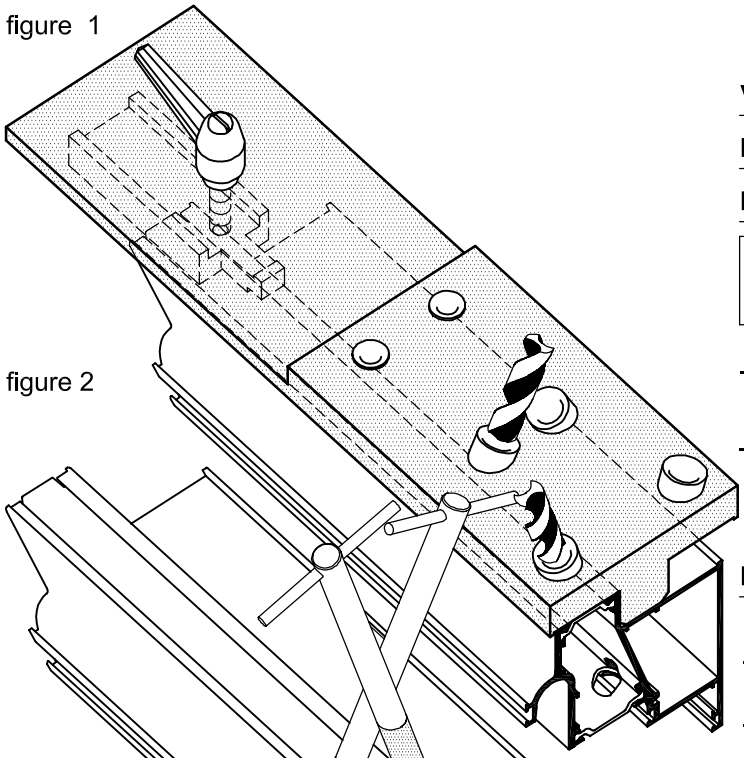


figure 2

figure 3

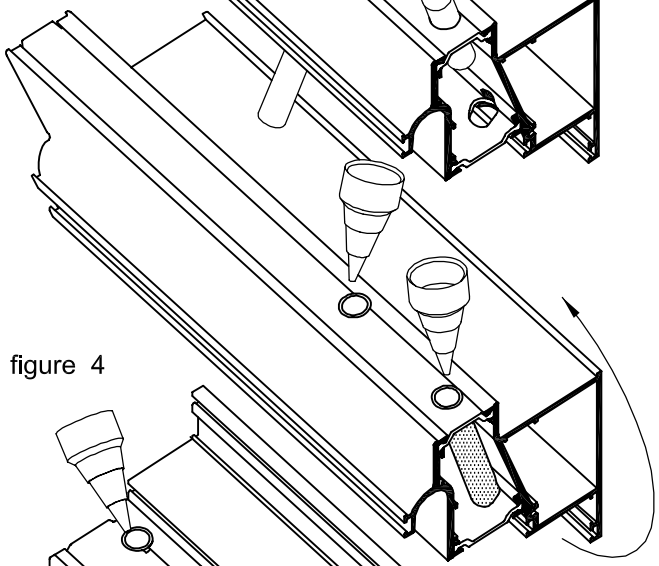
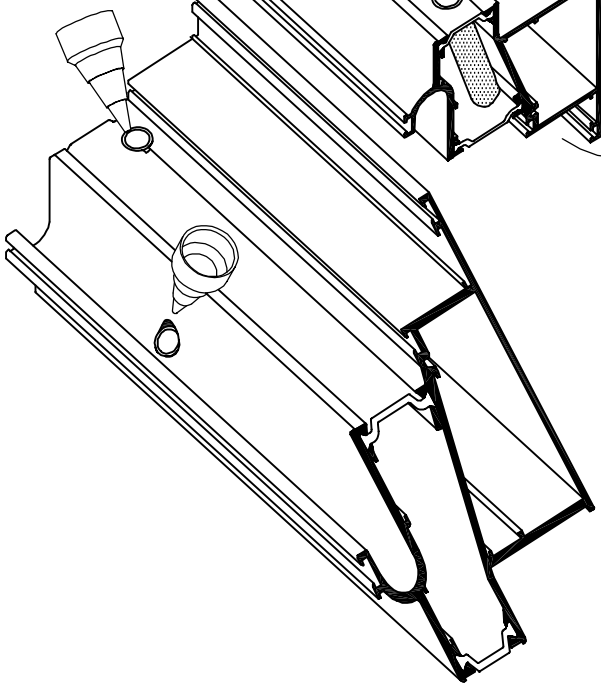


figure 4



VENTILATION HOLES

Frame profIle 52 482 0

Figure 1

drilling jig	942 005

- bottom face of frame: at least two pairs of drill holes, diameter 10 mm
- upper face of frame: at least two pressure equalization holes, diameter 10 mm

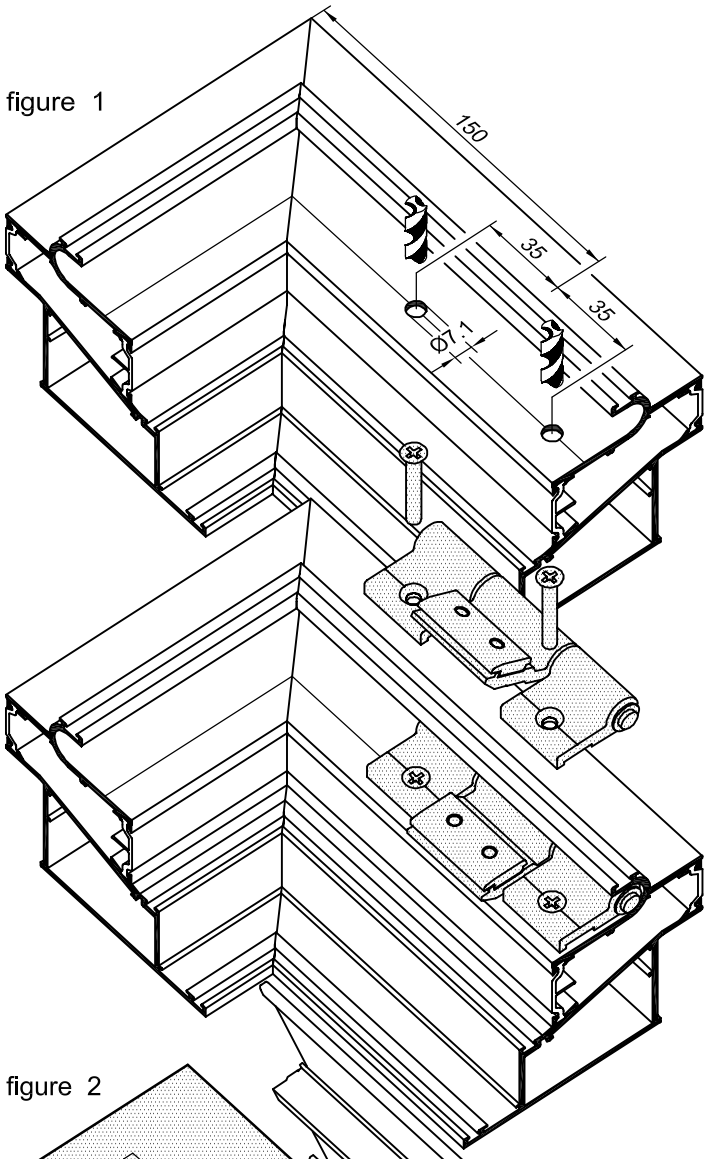
Figure 2

bottom face of frame:
- install plastic tube 23 322 0 on assembly aid 22 106 0
- insert into the frame drill holes and align in a flush way on the inside
- remove assembly aid

Figure 3 and 4

- seal plastic tubes from the inside and outside with sealing material 912 716

figure 1



POSITION OF HINGES

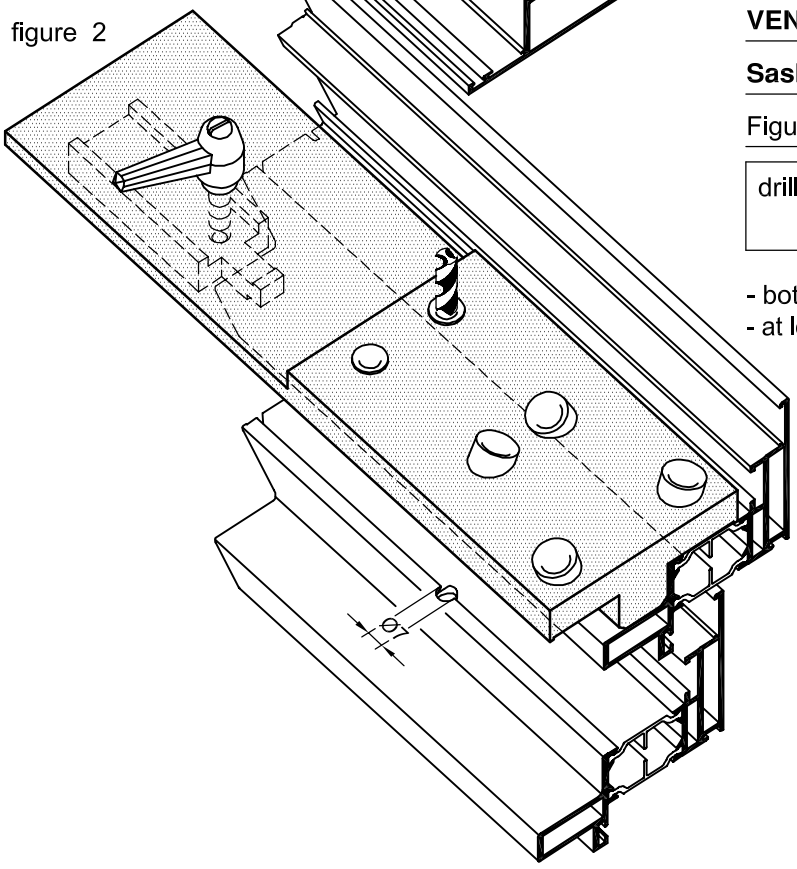
Frame profile 52 482 0

Figure 1

hinge	13 093 10

Upper face of frame:
- at least two pairs of drill holes, diameter 7.1 mm, in the centre of the drilling groove
- fix hinge to the frame
- adjust the sashes and fix by means of hinge clip pieces

figure 2



VENTILATION HOLES

Sash profile 52 487 0

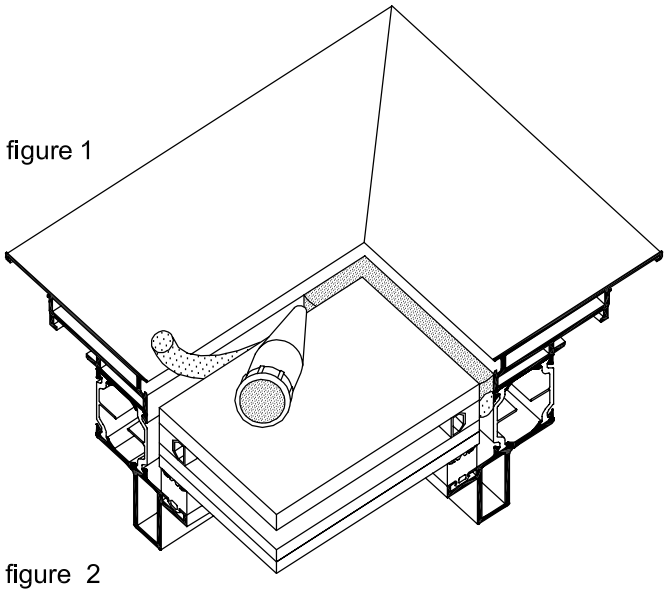
Figure 2

drilling jig	942 005

- bottom and upper face of sash
- at least two drill holes, diameter 7 mm

Comments on processing

figure 1



GLAZING

Sash profile

Figure 1

- push continuous insulating strip 23 774 0 into the glazing rebate, approx. 5 mm deep
- seal pane continuously with 912 718
- avoid contact between sealing material and glass edge bond

figure 2

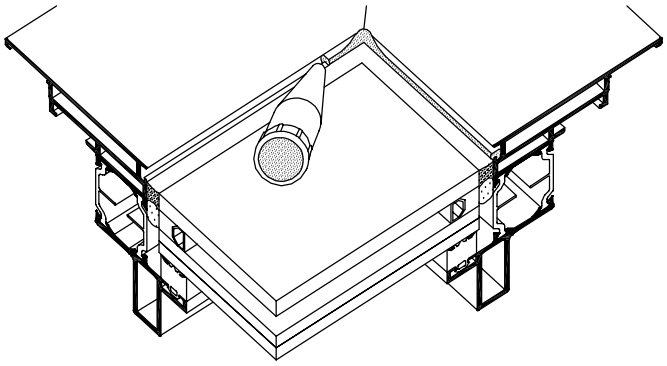
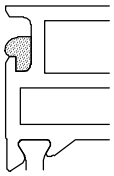
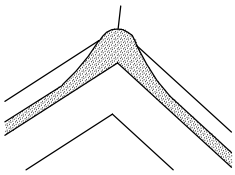


Figure 2

- insert sealing material 912 718 continuously into the glazing rebate profile groove



fill half of the lower groove in a room-filling way



fill the entire groove up to the top at the corner

figure 3

- start with the nozzle at the corner
- as far below the glazing bead as possible
- once the corner is filled, continue injecting to the sides

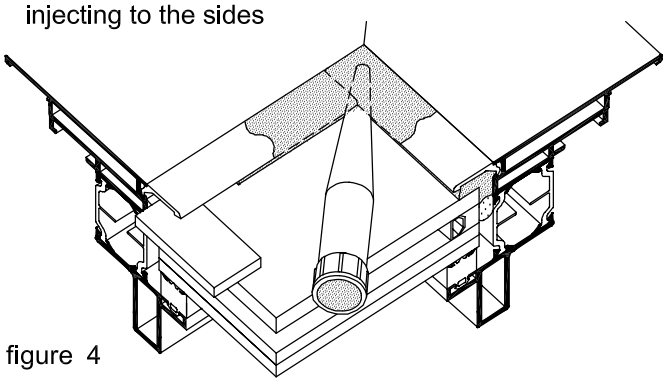


Figure 3

- insert glazing rebate profiles and reinforce
- inject sealing material 912 718 into the corners, 100 mm to the left and to the right
- at the corners, sealing material has to be backfilled to ensure that possible gaps of the glazing rebate joints are sealed as well and/or filled at the pane sealing

figure 4

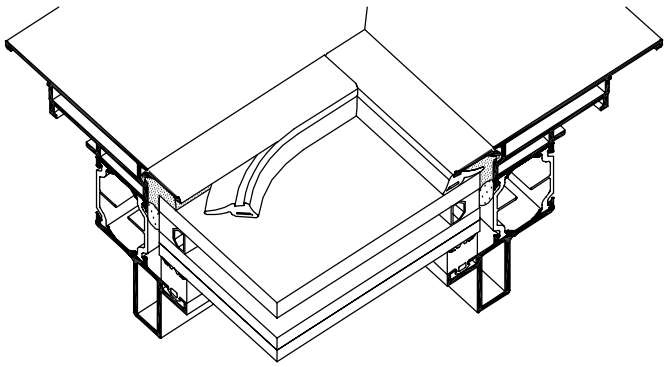


Figure 4

- push gasket wedge in continuously
- seal gasket joints with adhesive 903 941