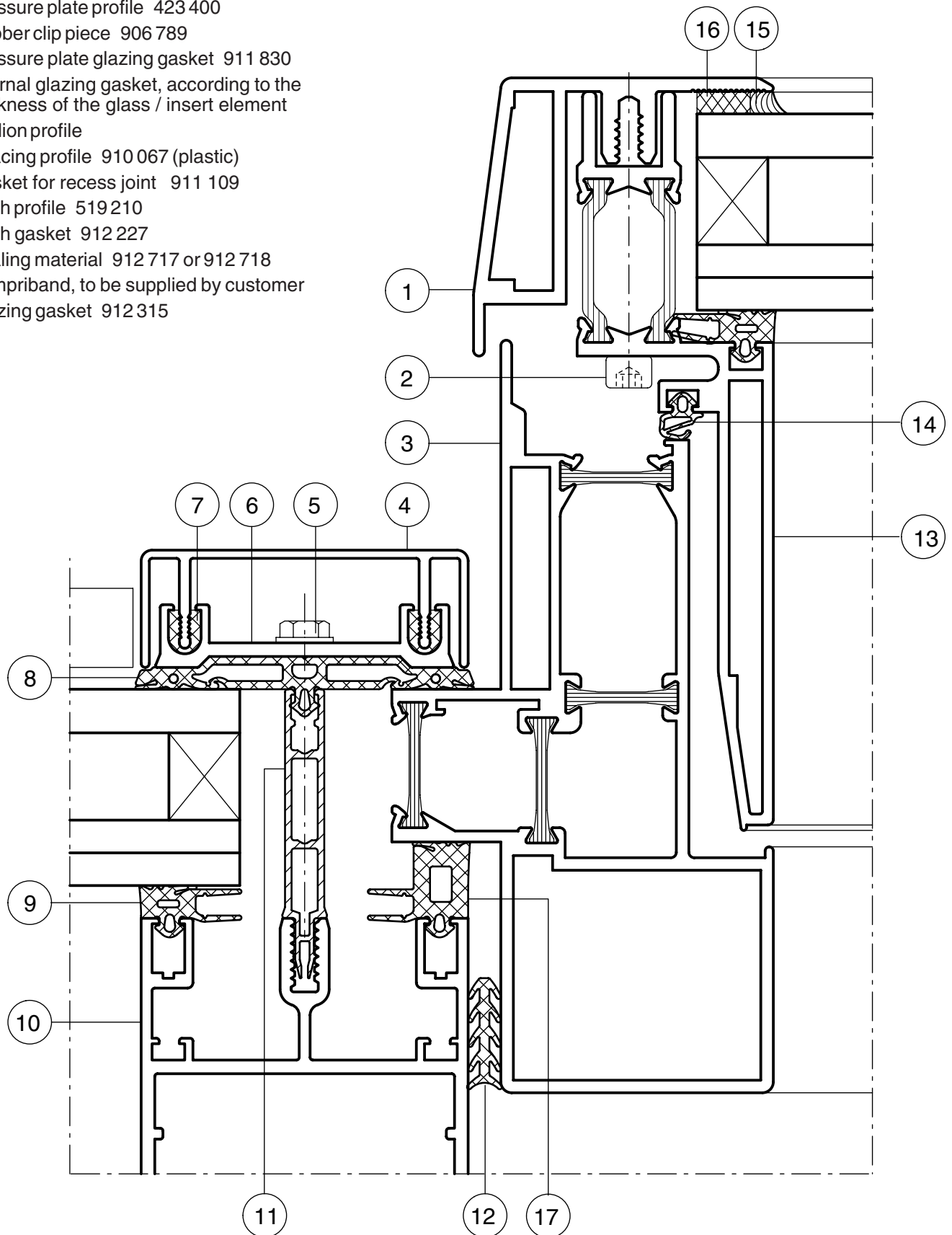


- 1 Coverprofile 519211
- 2 Facade fixing screw 911 936
- 3 Fixed frame 519511
- 4 Coverprofile 460601
- 5 Facade fixing screw 911 937
- 6 Pressure plate profile 423 400
- 7 Rubber clip piece 906 789
- 8 Pressure plate glazing gasket 911 830
- 9 Internal glazing gasket, according to the thickness of the glass / insert element
- 10 Mullion profile
- 11 Spacing profile 910 067 (plastic)
- 12 Gasket for recess joint 911 109
- 13 Sash profile 519210
- 14 Sash gasket 912 227
- 15 Sealing material 912 717 or 912 718
- 16 Kompriband, to be supplied by customer
- 17 Glazing gasket 912 315



21 Skylight window

Opening angle max. 50°.
Roof pitch at least 7°.
Minimum sash height 600 mm.

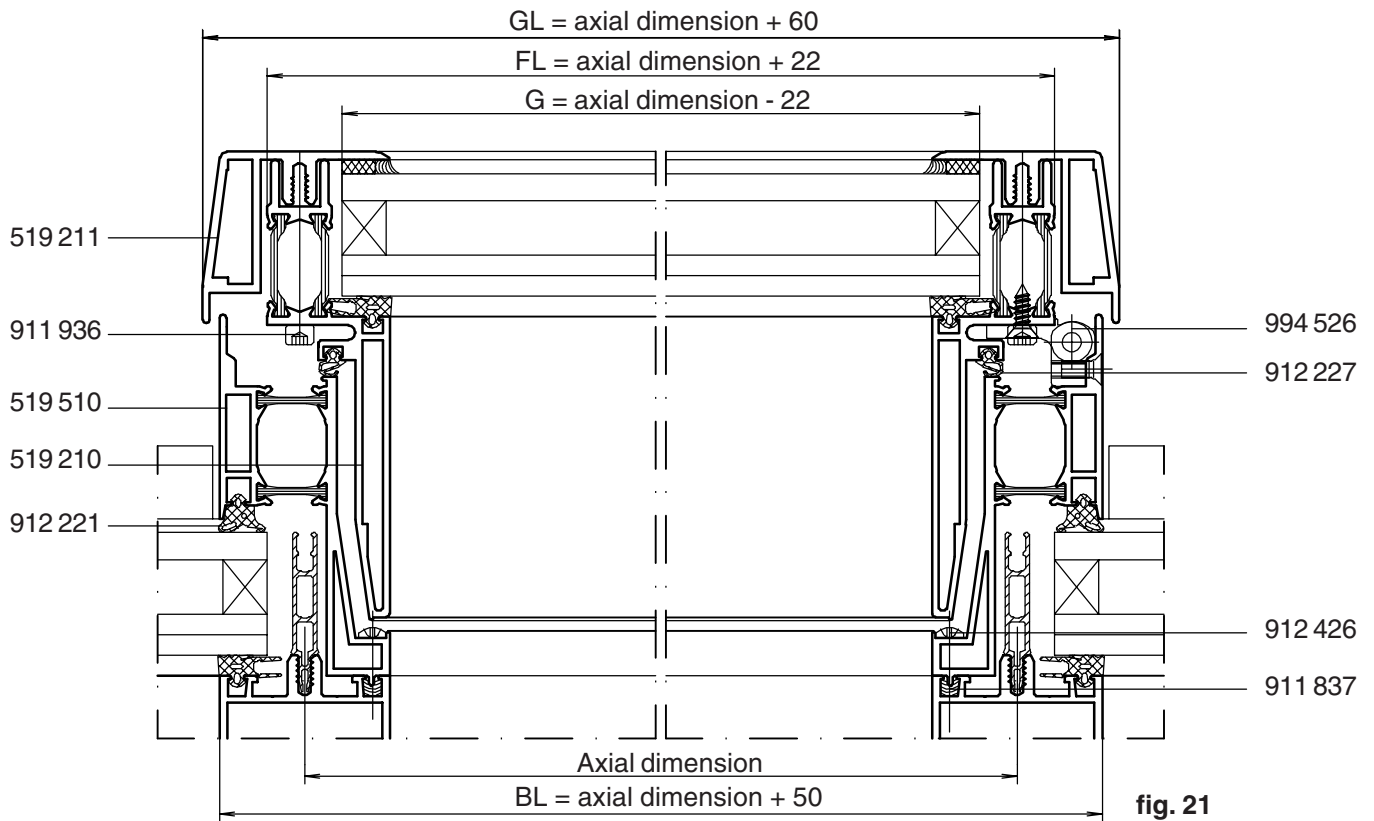
Max. sash weight	120 kg
Max. sash width	1600 mm
Max. sash height	2000 mm
Max. surface area	2.2 m²

21.1 Determining the cutting to length

Cuttings:

Fixed frame - mullion/transom: BL
Sash dimension: FL
Glazing bead dimension: GL
Glass dimension: G

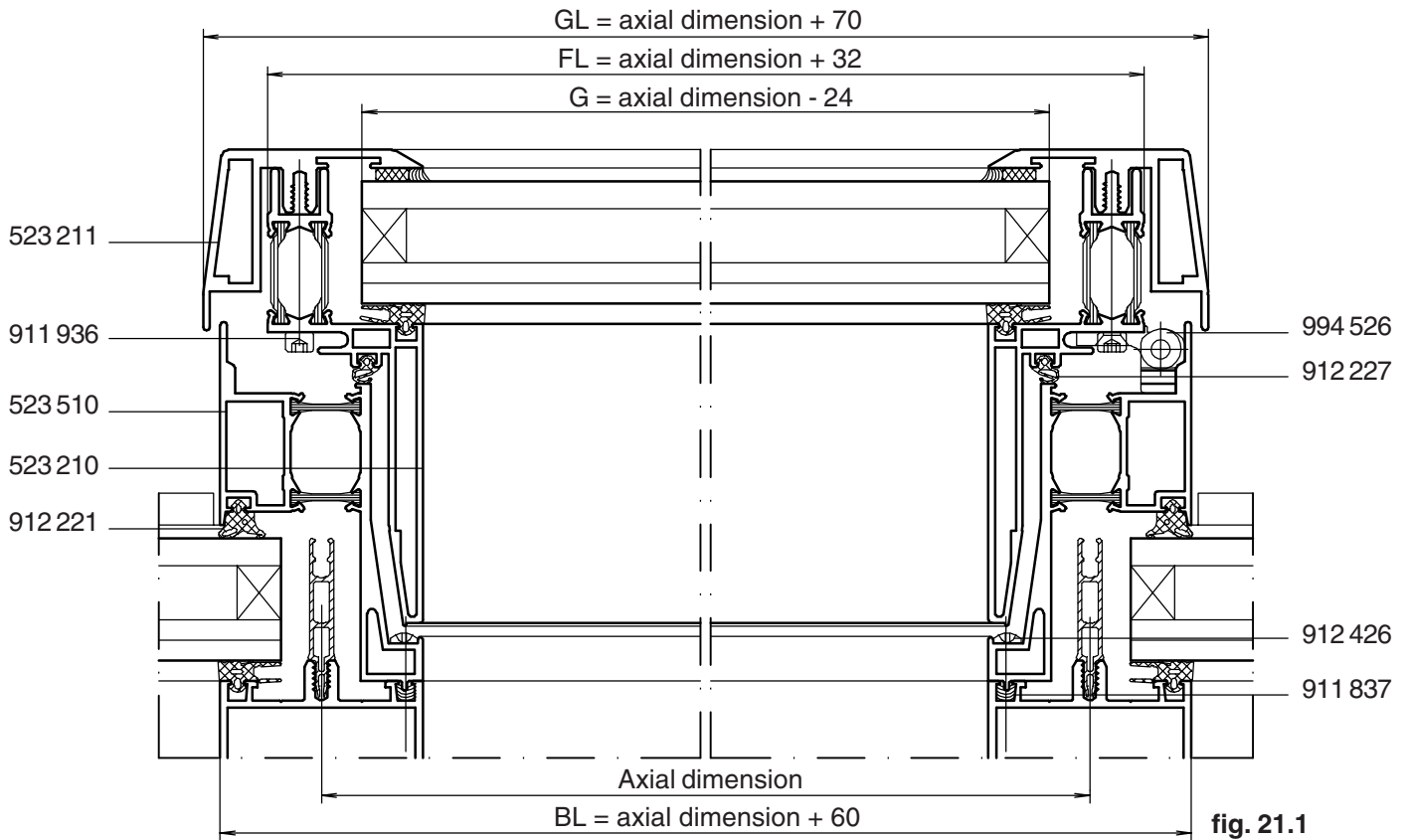
21.1.1 VF 50 supplementary element



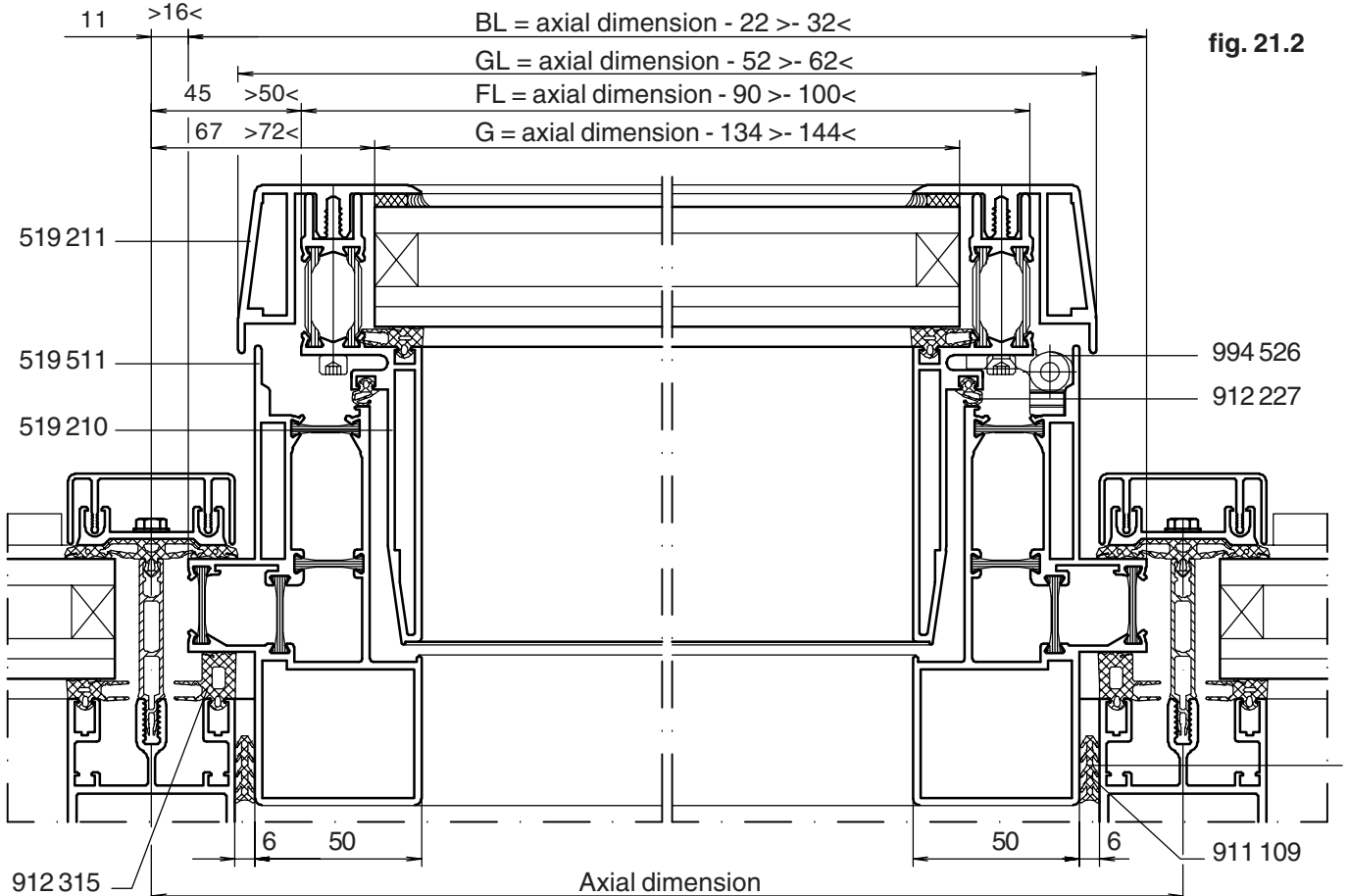
Attention:

Observe the local building regulations if the skylight window is designed as smoke and heat ventilation!

21.1.2 VF 60 supplementary element



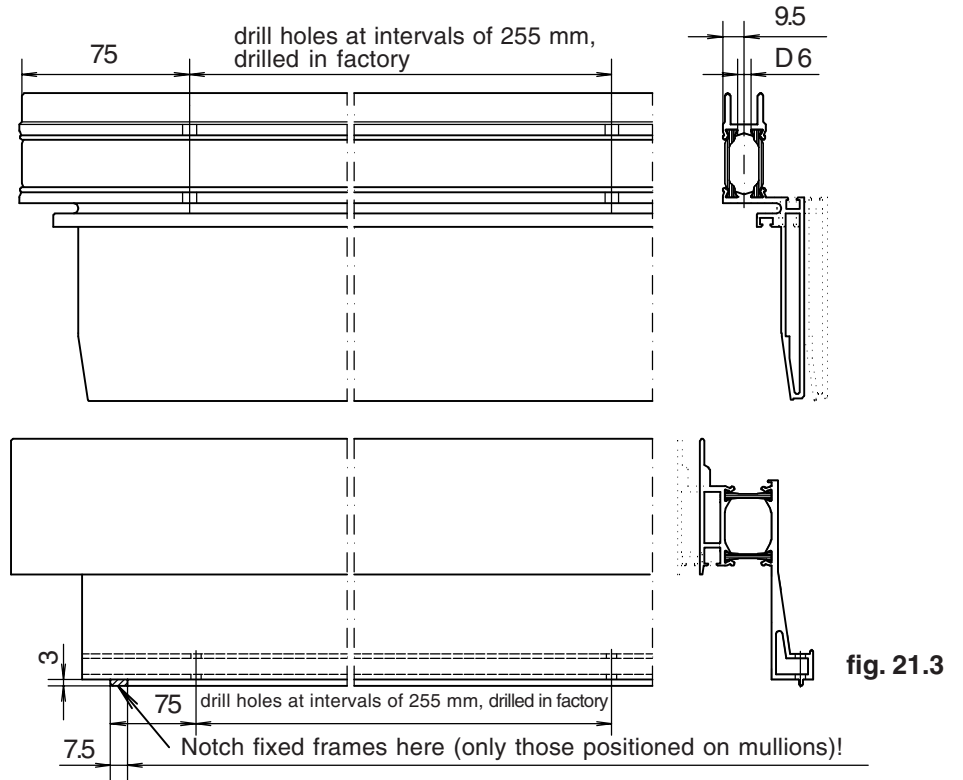
21.1.3 VF 50/VF 60 insert element



Attention: Observe the local building regulations if the skylight window is designed as smoke and heat ventilation!

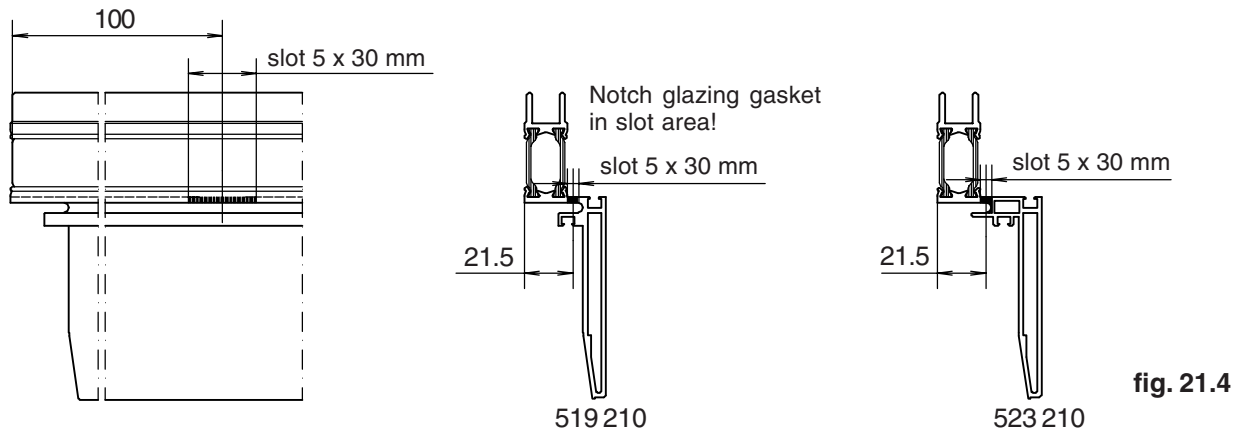
21.2 Profile processing

21.2.1 Fixing drill holes for fixed and sash frames

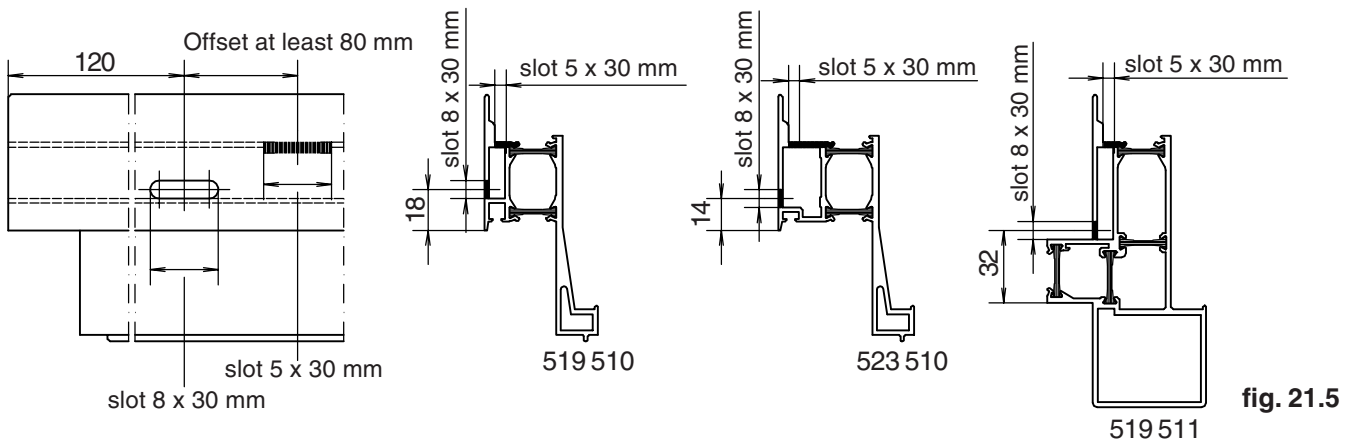


21.2.2 Rebate ventilation and front chamber drainage

Sash frames opposite hinge side (lowest point)



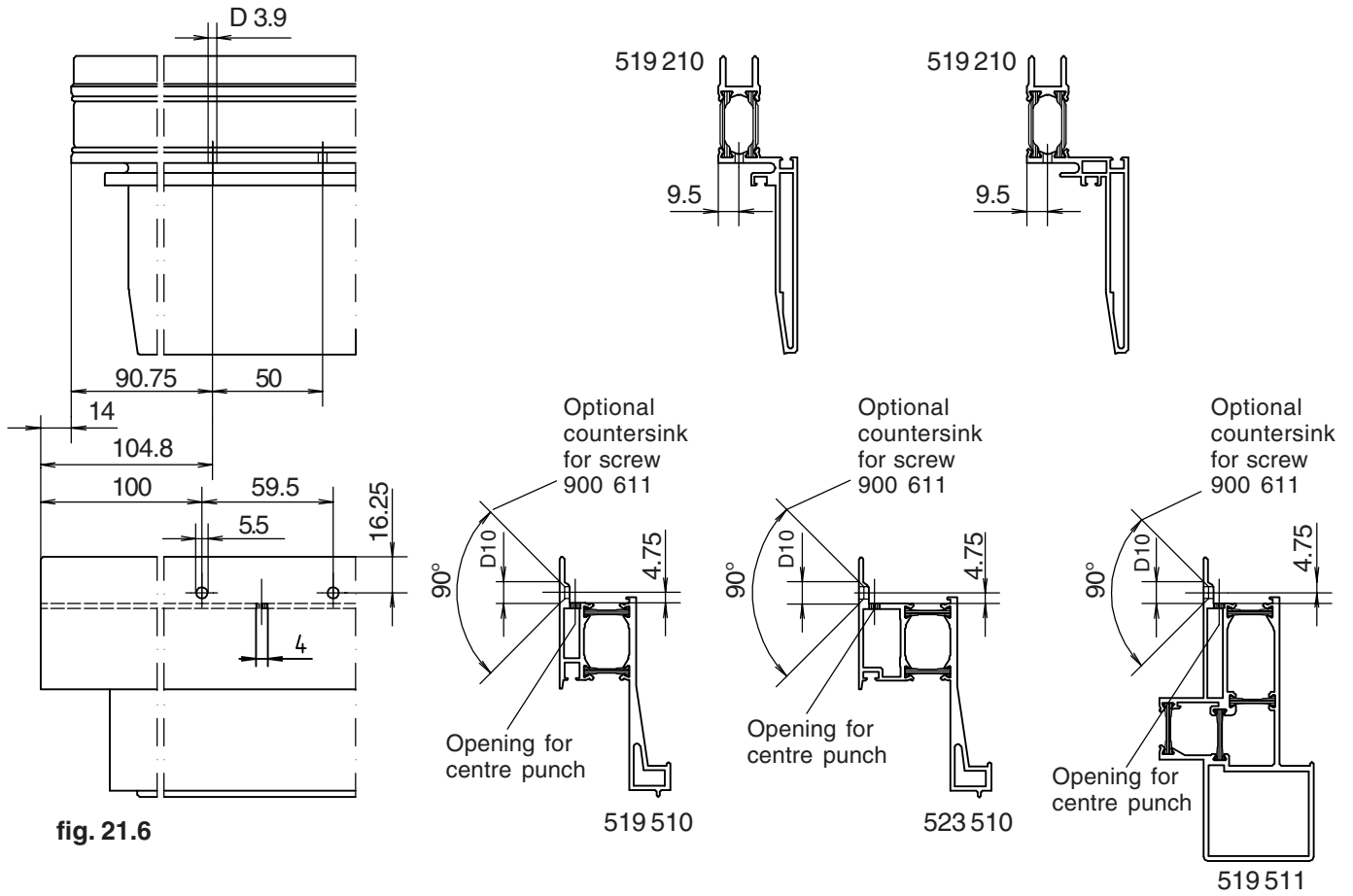
Fixed frames opposite hinge side (lowest point)



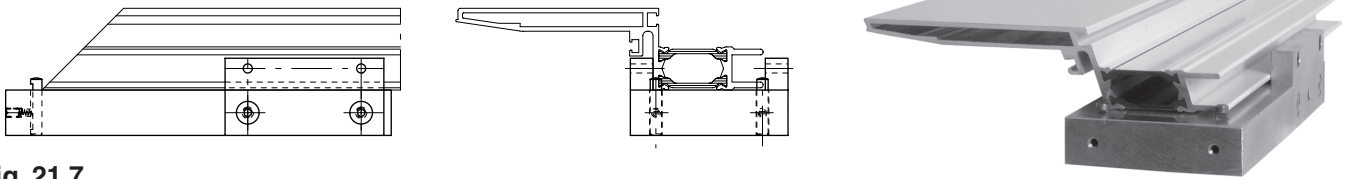
21.2.3 Processing for window hinge

Sash width	Number of hinges
800 mm	2
1250 mm	3
1600 mm	4

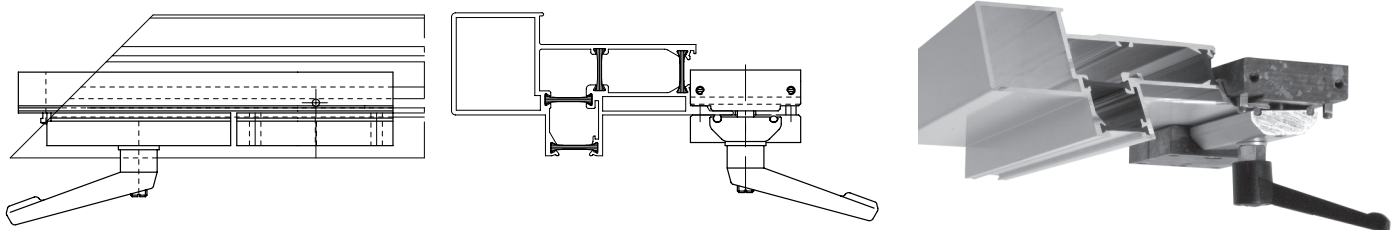
Sash weight	Number of hinges
60 kg	2
90 kg	3
120 kg	4



Drilling jig 912 424 for sash profiles 519 210/523 210



Drilling jig 912 298 for fixed frames 519 510/523 510/519 511



21.2.4 Processing for automatic door opener

21.2.4.1 Punching scheme for chain motor art. no. 994 298 / 299 / 300 / 301 / 302 / 303

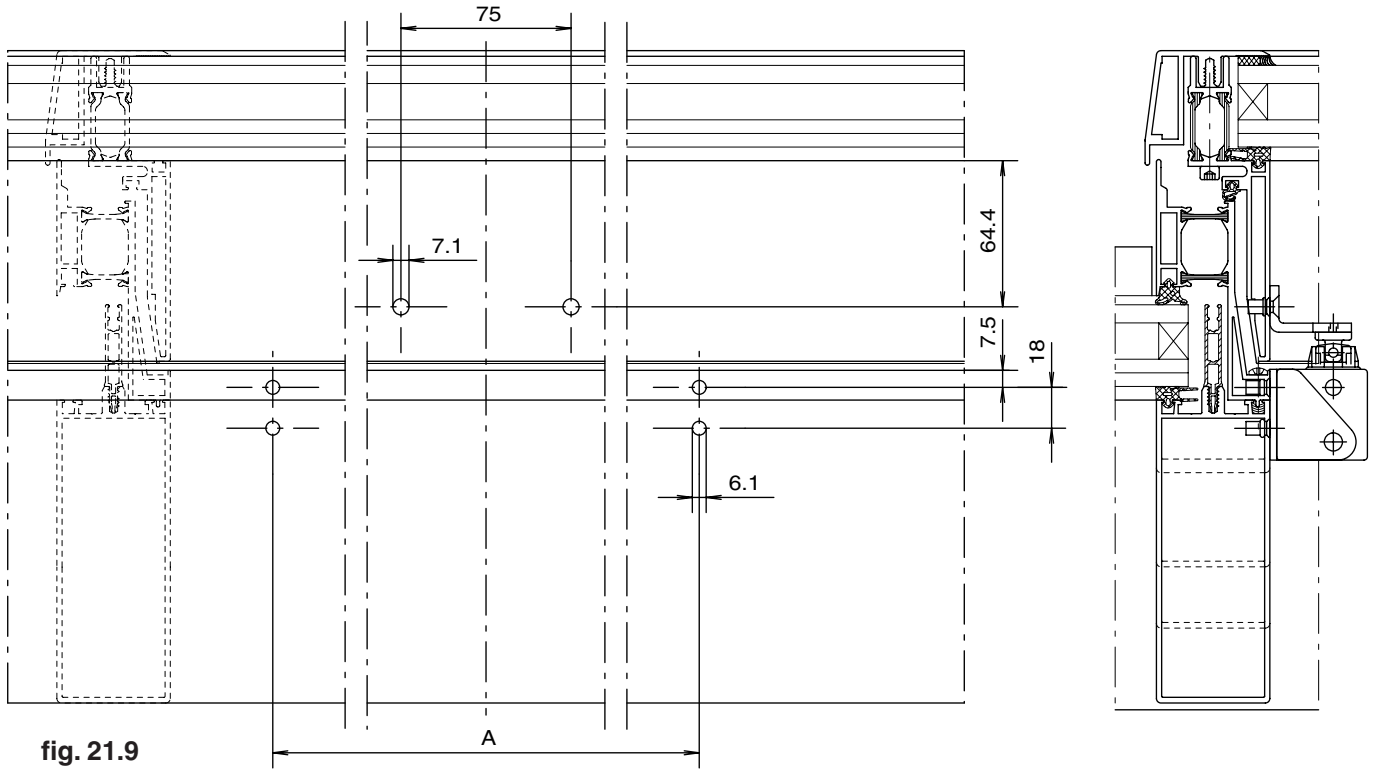


fig. 21.9

article no.	dimension A (mm)
994 298	567
994 299	567
994 300	567
994 301	659
994 302	843
994 303	843

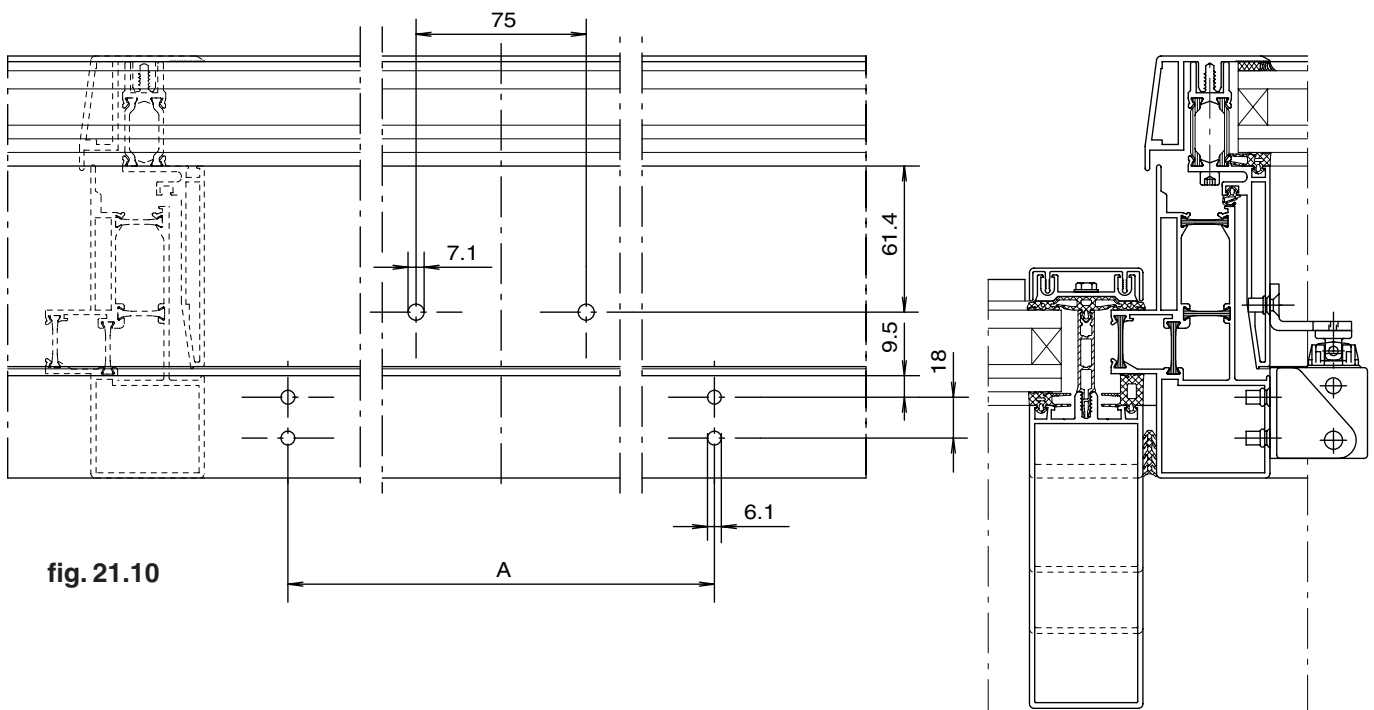
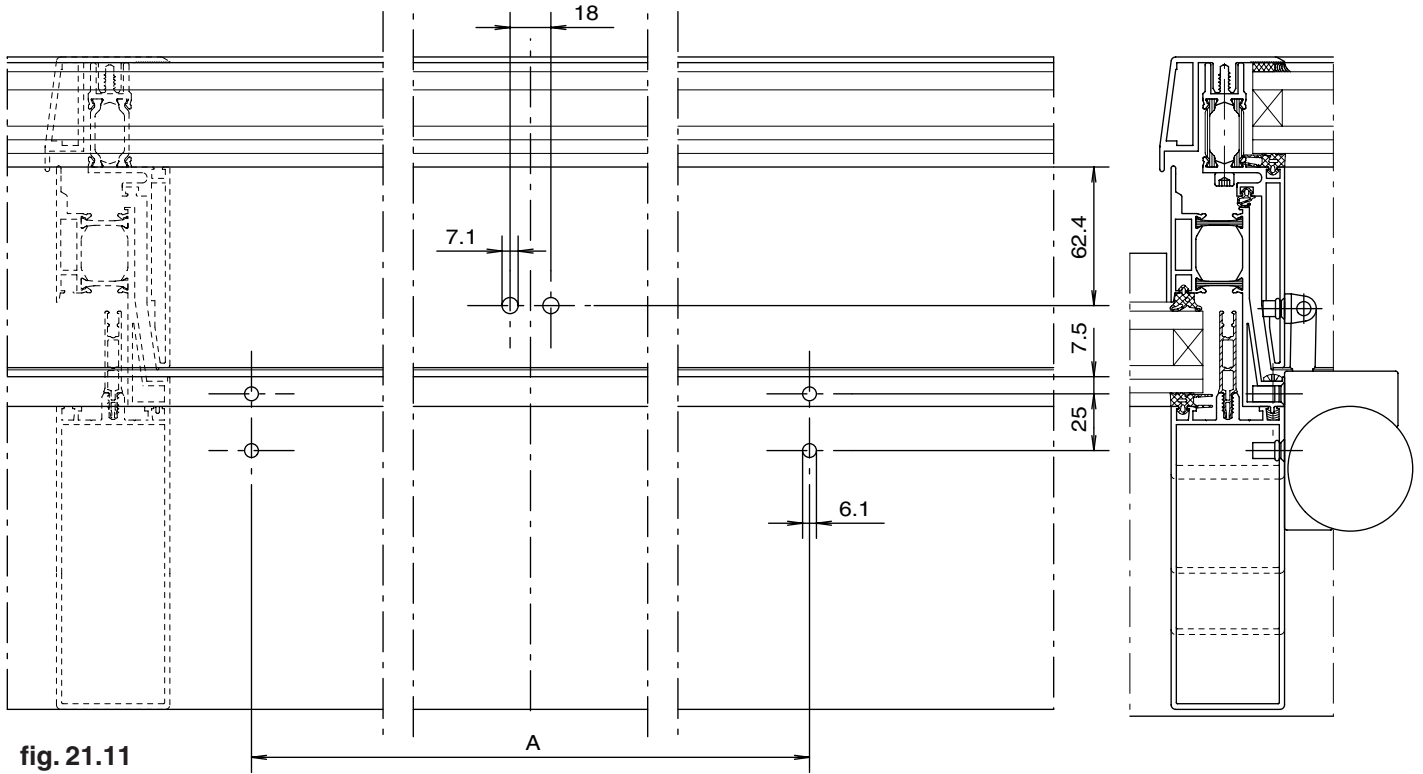
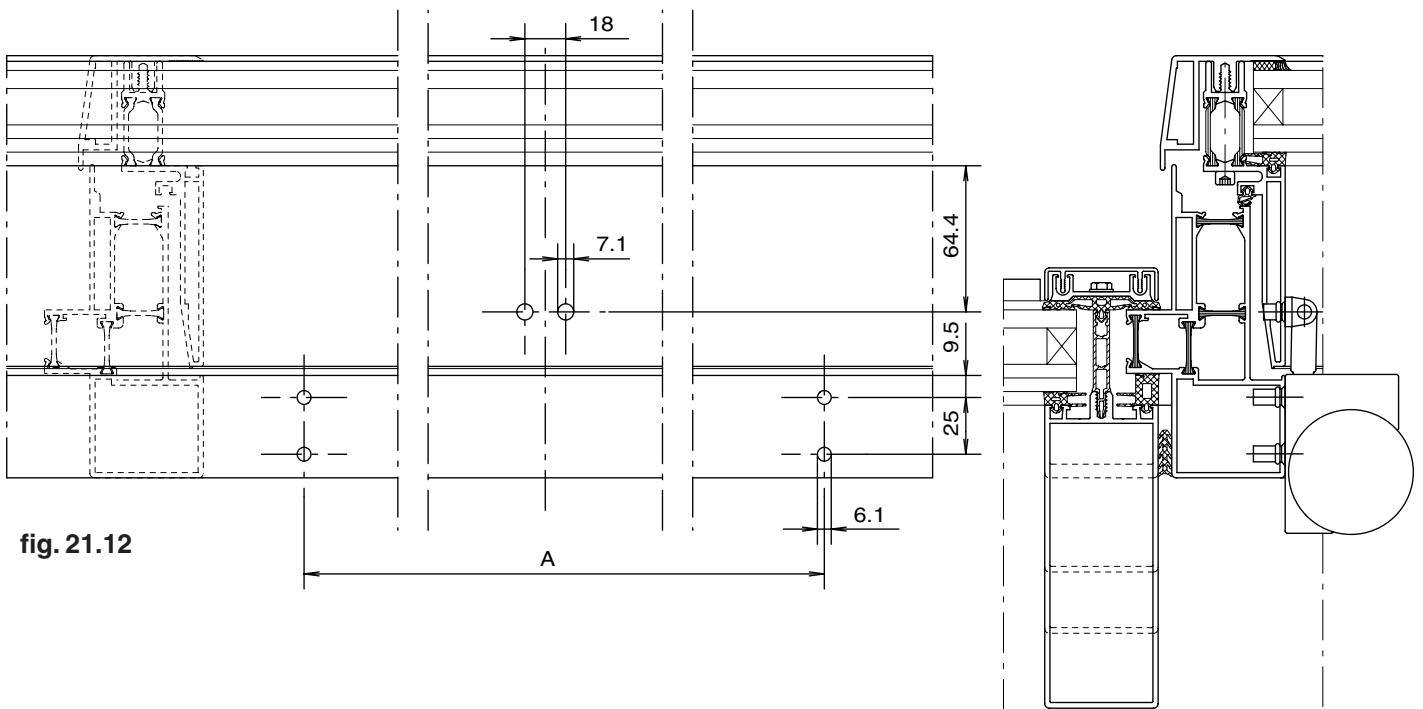


fig. 21.10

21.2.4.2 Punching scheme for double chain motor art. no. 994 293 / 294 / 295



article no.	dimension A (mm)
994 293	331
994 294	423
994 295	515



21.2.4.3 Punching scheme for spindle motor art. no. 994 296 / 297

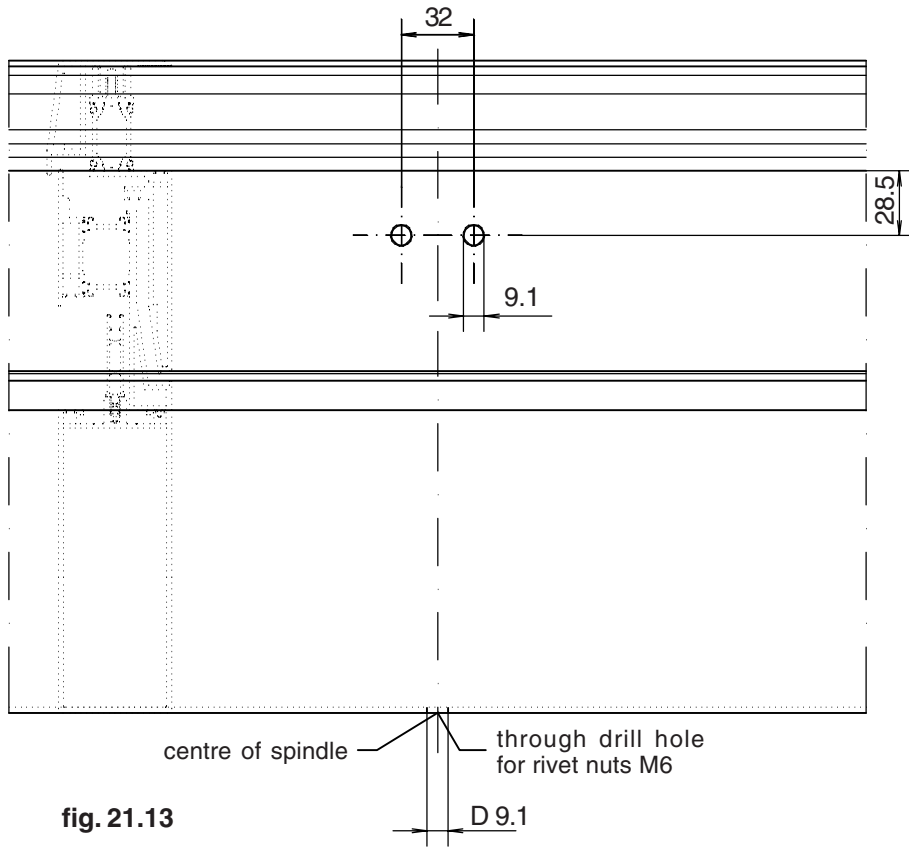


fig. 21.13

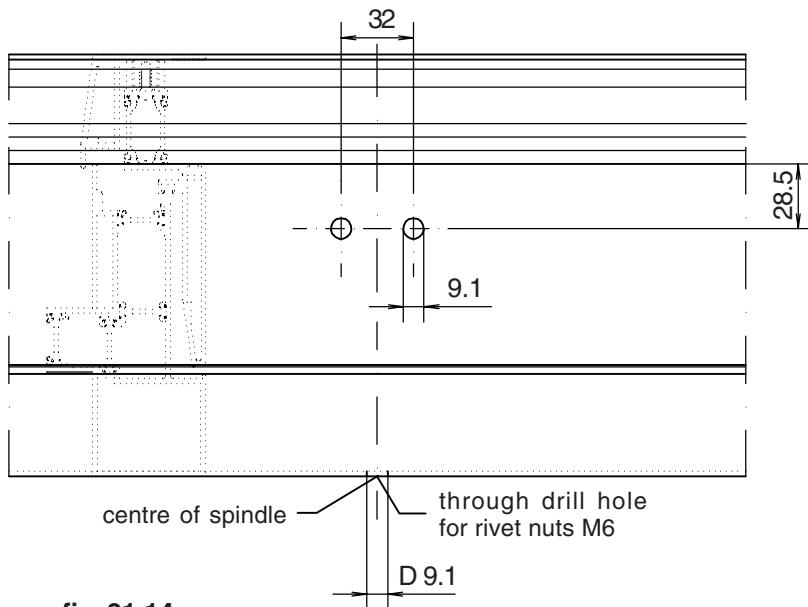
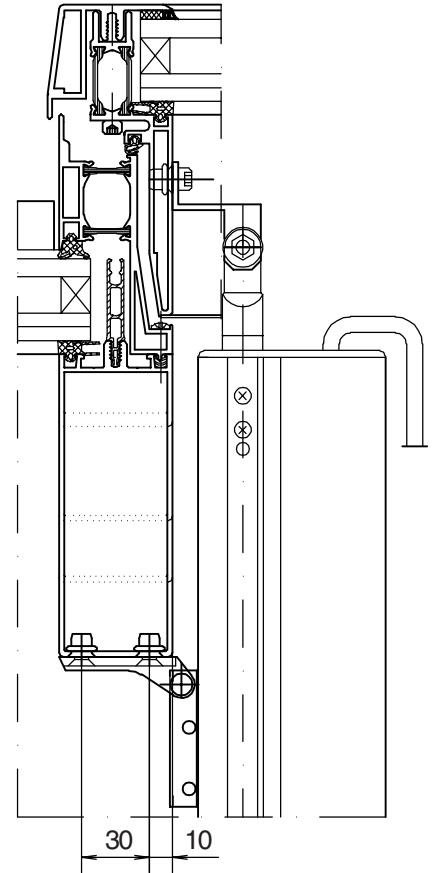
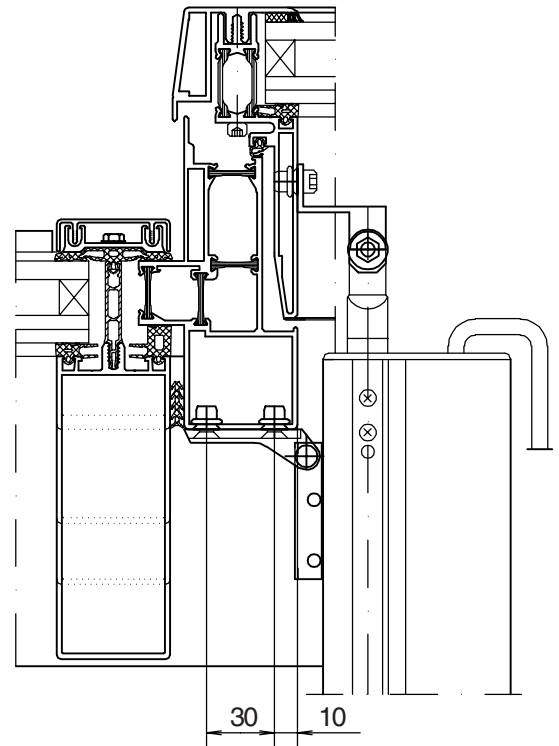


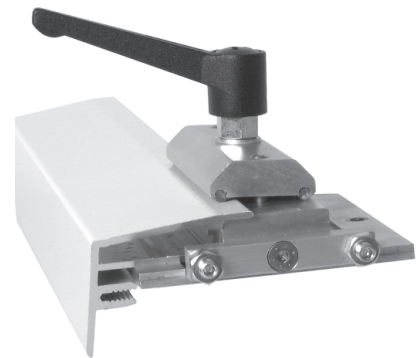
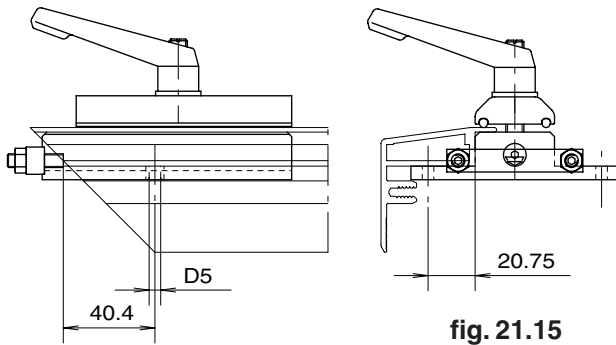
fig. 21.14



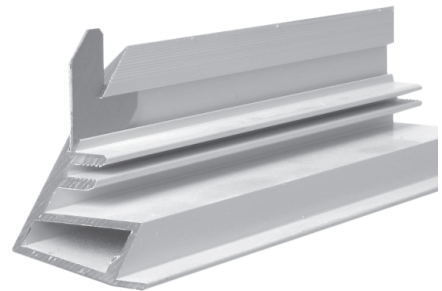
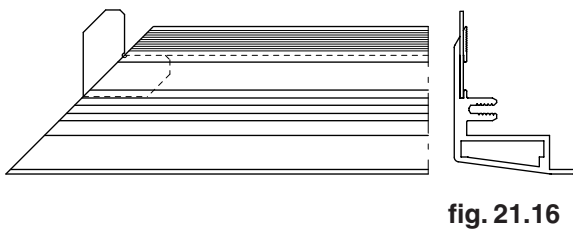
21.2.5 Frame production with corner brackets

Profile number	Inner chamber			Outer chamber			
	Corner bracket	Cylindrical pin	Drilling jig	Corner bracket	Cylindrical pin	Drilling jig	Corner strengthening piece
519 210	912 226	4 x 911 513	912 295				
519 211				912 225	2 x 911 513	912 297	
519 510	912 224	2 x 911 049	912 296	912 223	2 x 911 049	912 294	
519 511	912 380	2 x 900 024	912 395	912 379	2 x 911 049	912 397	907 315
523 210	912 226	2 x 911 513	912 295				
523 211				912 225	2 x 911 513	912 297	907 315
523 510	912 224	2 x 911 049	912 296	912 381	2 x 911 049	912 394	

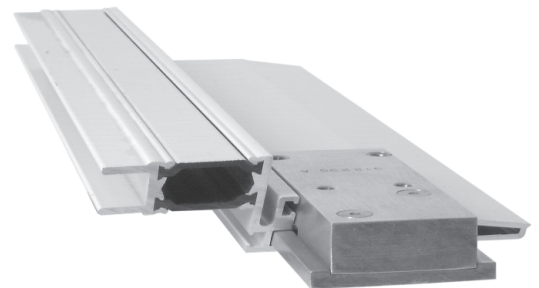
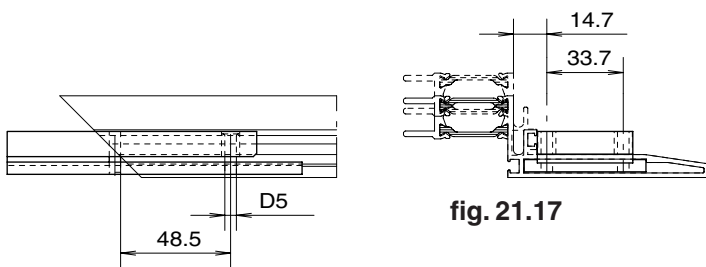
21.2.5.1 Cover profiles 519 211 and 523 211 with drilling jig 912 297



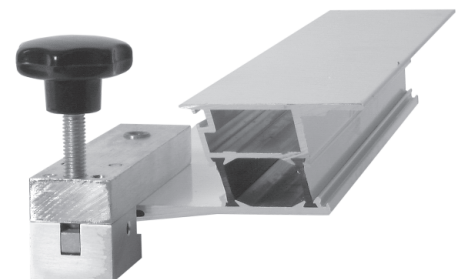
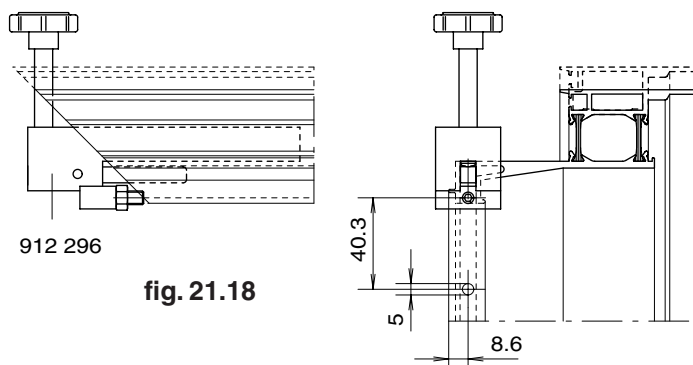
Corner strengthening piece 907 315 is not pegged.



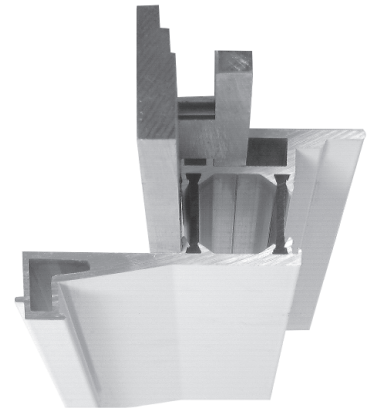
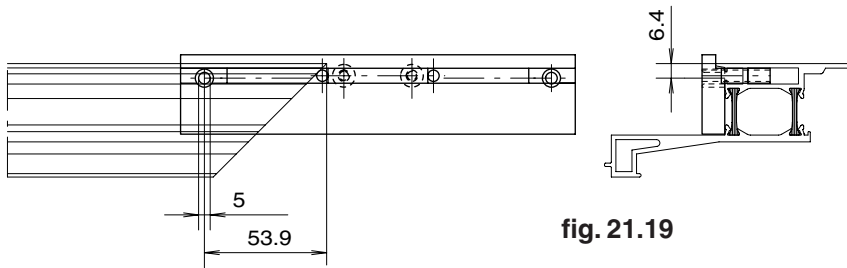
21.2.5.2 Sash profiles 519 210 and 523 210 with drilling jig 912 295



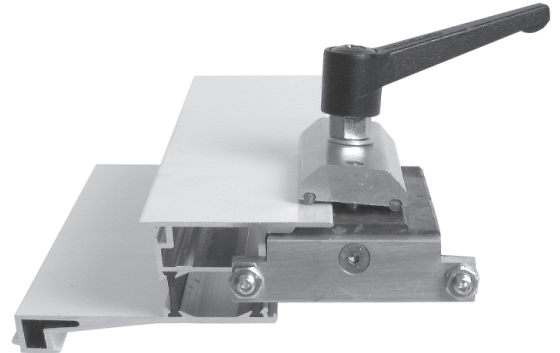
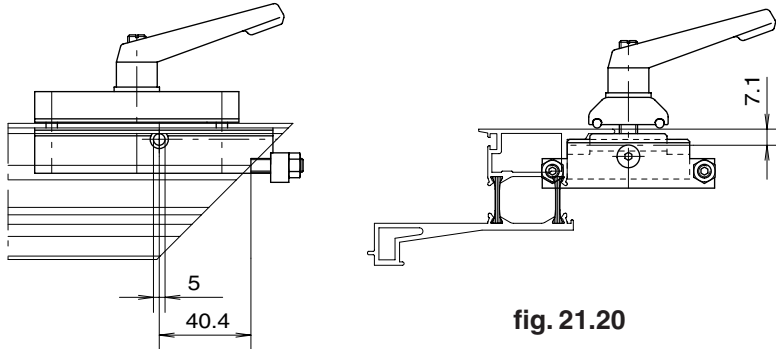
21.2.5.3 Fixed frames 519 510 and 523 510 with drilling jig 912 296



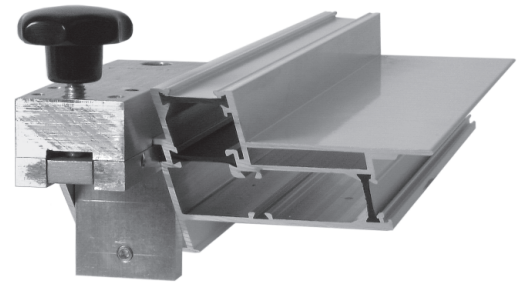
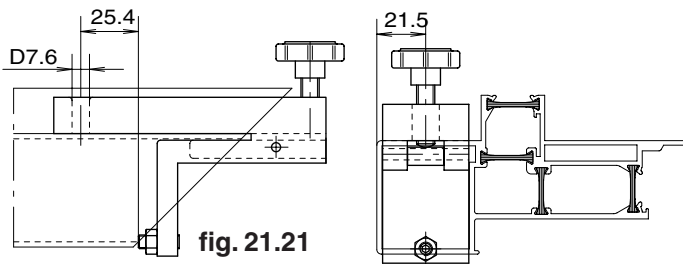
21.2.5.4 Fixed frame 519 510 with drilling jig 912 294



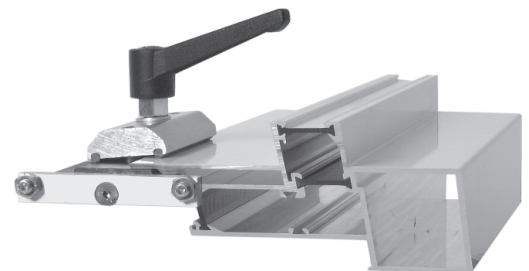
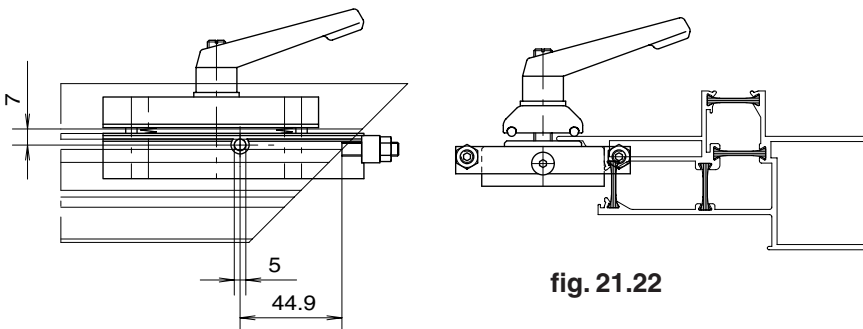
21.2.5.5 Fixed frame 523 510 with drilling jig 912 394



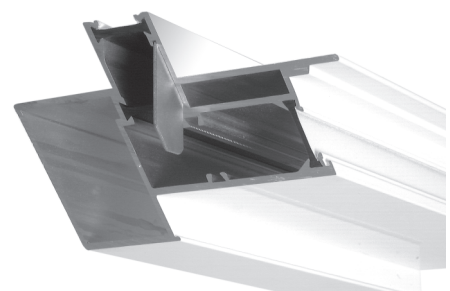
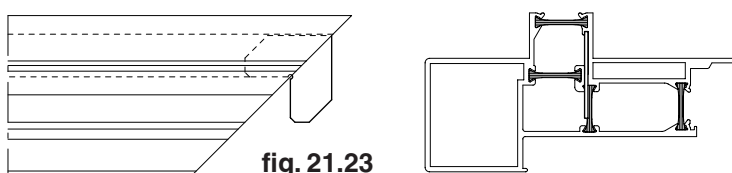
21.2.5.6 Fixed frame 519 511 with drilling jig 912 395



21.2.5.7 Fixed frame 519 511 with drilling jig 912 397



21.2.5.8 Corner strengthening piece 907 315 is not pegged



21.2.5.9 Frame production with corner brackets

In general: All drilling jigs are adjusted in such a way that, theoretically, optimum pre-tension is guaranteed. As, however, the theoretical specifications do not necessarily correspond to the actual conditions (production tolerance), one trial corner should be produced before commencing production.

Once the drilling jig has been adjusted to the profile, the corresponding drill holes can be drilled into the internal and external profile shell. Remove the ridge after processing.

Then remove any oil, metal shavings etc. from the areas where the profiles have been glued.

Put a sufficient amount of glue on the insides of the profile end parts and seal the angle cut with non-hardening sealing compound. Insert corner angles and corner strengthening piece into the profile end parts and push the frame together. Read the processing instructions carefully before using metal glue.

Caution: Corner angles have to be inserted prior to assembly.

Drive cylindrical pins in continuously from one frame corner to the other at approximately 2/3 of length.

Check the corners for correct seat, adjust if necessary. Then drive in the pins by means of a mandrel, art. no. 903 233, until they are flush with the profile. Clean the mitre joints. In case of painted profiles, only benzine (petrol) or a similar detergent should be used.

Cf. technical comments.

21.3 Glazing table

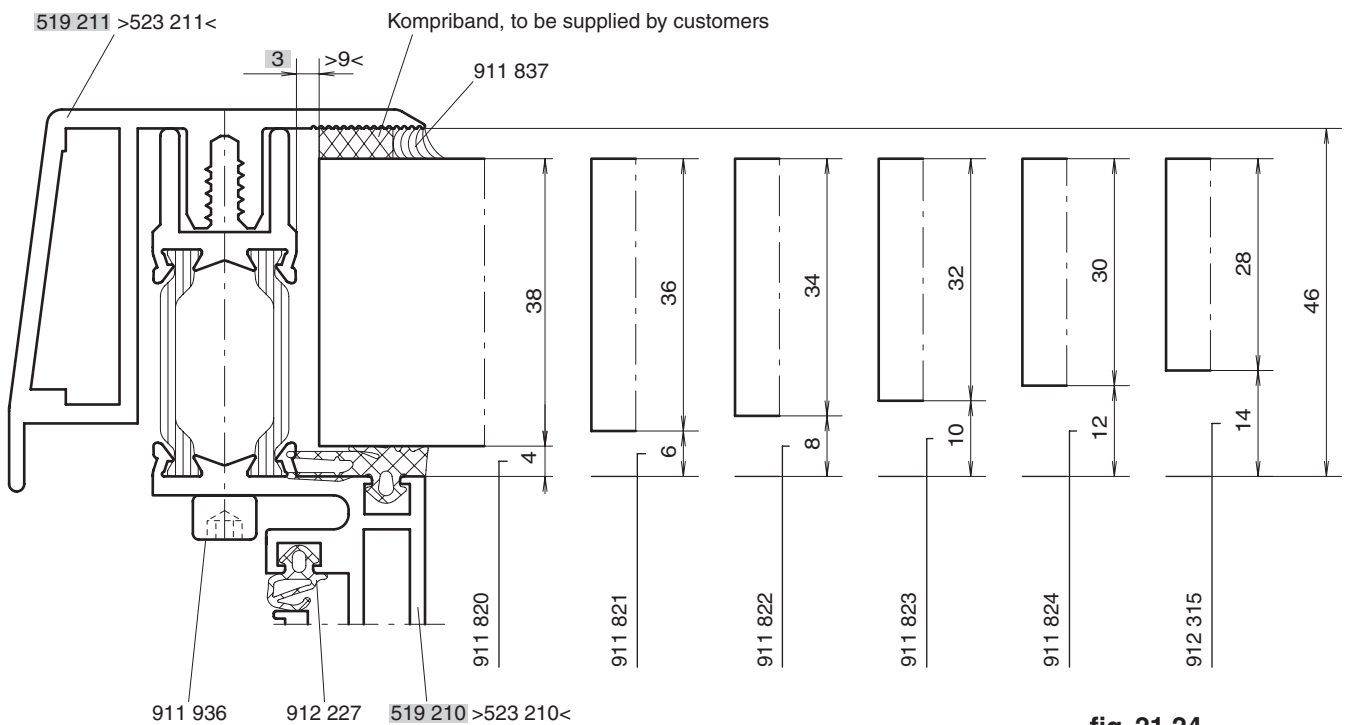


fig. 21.24

Fix the glazing bead 519 211 >523 211< at intervals of 255 mm by means of screw art. no. 911 936.

Gasket joints have to be glued in a vapour-tight way by means of EPDM adhesive art. no. 903 941.

Attention: Make sure that all joint and cutting edges are dry and free from grease and dust!

For glazing, the "Technical guidelines regarding the use of stacked overhead glazing" of the DIBT (German Institute for Building Technology*) have to be observed.

*) Rev. 09/1998, published in the DIBT notification of December 8th, 1998

21.4 Assembly

In case of a construction with supplementary profiles, the fixed frame and the glazed sash are mounted on the substructure separately.

In case of an interlocking element, the window completely produced in the workshop can be mounted.

Attention!

In order to check the exact fit and function of the window, we recommend that you install the sash on the fixed frame in the workshop prior to assembling the fixed frame and the sash to the building structure.

The pressure plate and the cover profile of the mullion-transom construction are to be installed with an 8 mm joint to the fixed frame!

21.4.1 Supplementary construction

Following assembly of the glass panes to the construction, sealing tape art. no. 911 828, approx. 30 cm section, is glued at the mullion and transom joints in the area of the skylight window, see fig. 21.28.

The sill of the pressure plate glazing gasket has to be notched.

Attention: Observe the cutting to length dimension of the pressure plate and the cover profile.

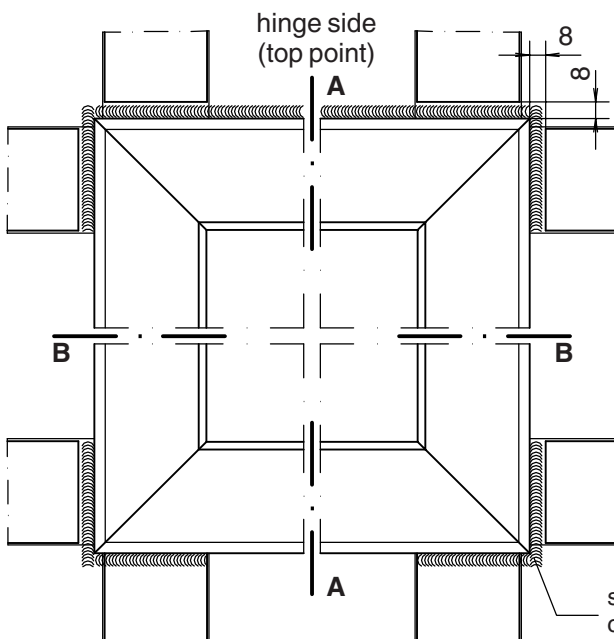


fig. 21.25

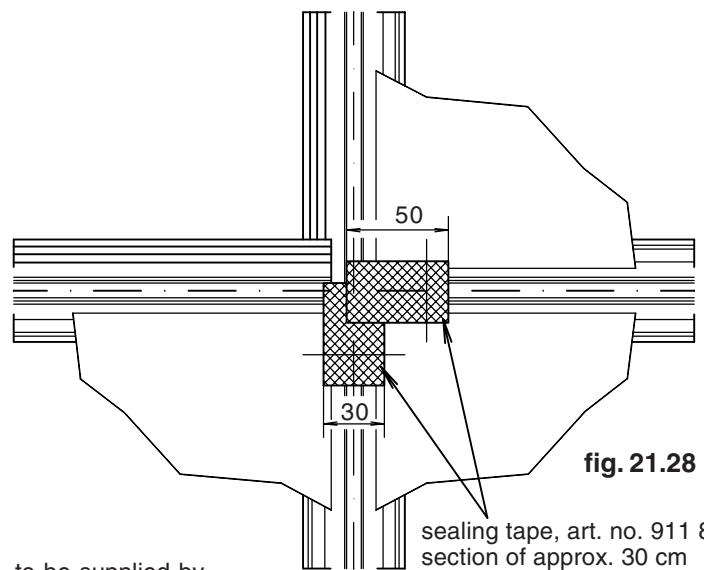


fig. 21.28

sealing tape, art. no. 911 828,
section of approx. 30 cm

sealing, to be supplied by
customer, art. no. 911 837

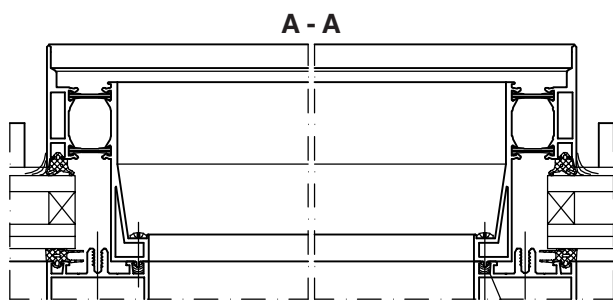
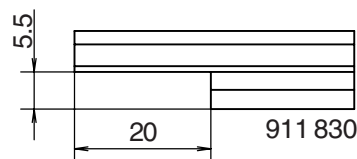


fig. 21.26



sealing, to be supplied by customer,
art. no. 911 837

screws at intervals of 255 mm
(pre-punched in the fixed frame)

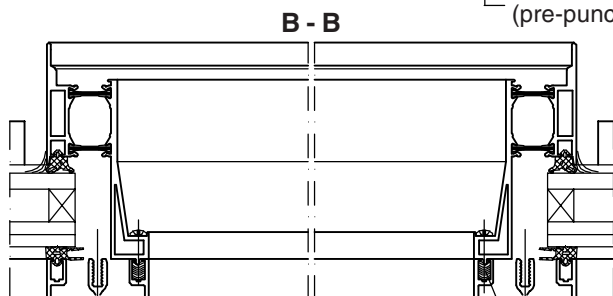


fig. 21.27

sealing, to be supplied by customer, art. no. 911 837

Following assembly of the fixed frame to the mullion-transom construction, the sash is installed. Make sure that the centre punches of the hinges are inserted into the fixed frame drill holes when installing the sashes.

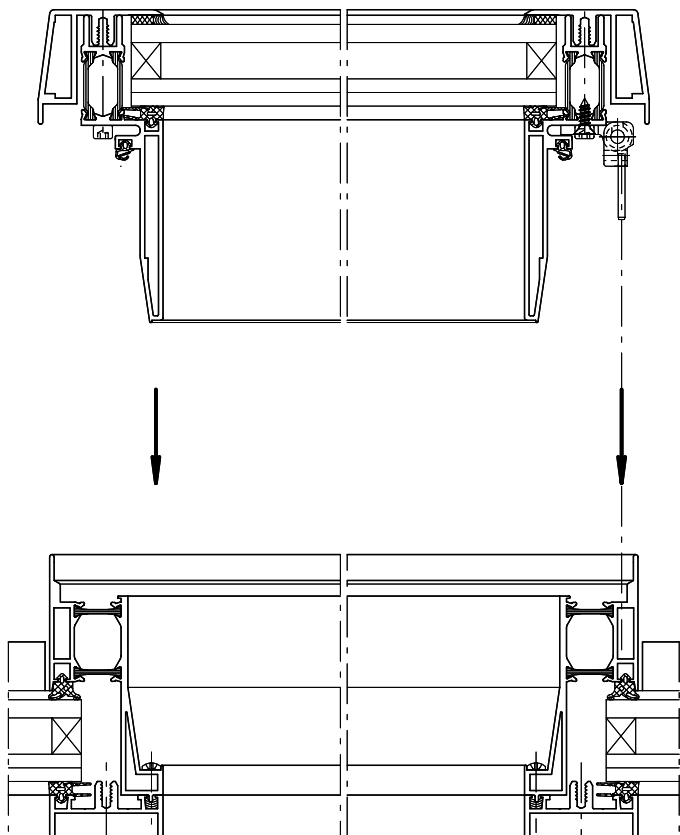


fig. 21.29

Once assembly of the sash frame has been completed, the hinges are screwed to the fixed frame.

Art. no. 900 611 counter-sunk screw

Art. no. 900 252 cap screw

(to be ordered separately)

21.4.2 Interlocking element

As an interlocking element, the sky window is completely pre-assembled in the workshop and inserted into the construction including glazing.

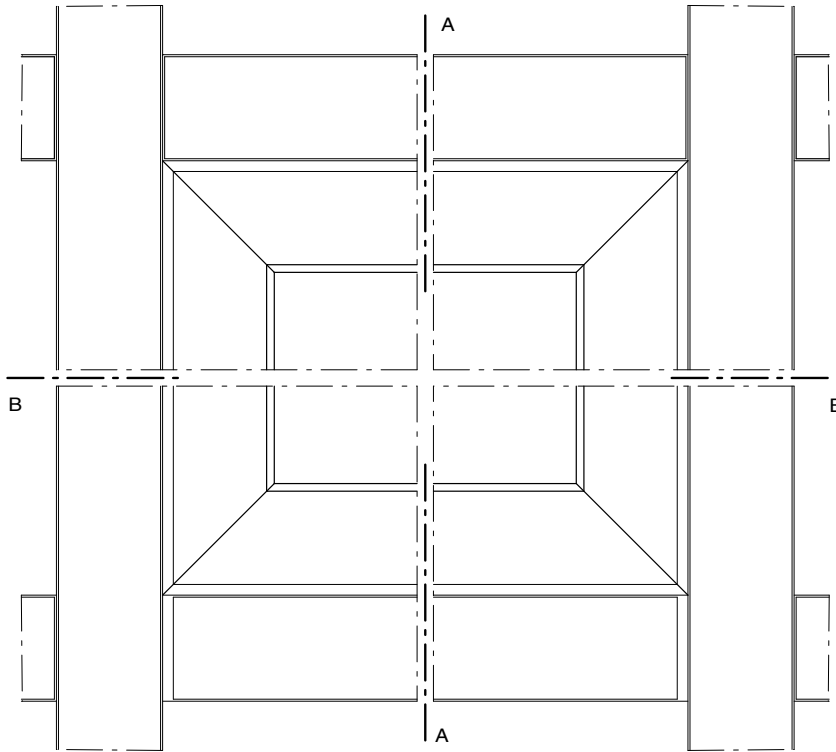


fig. 21.30

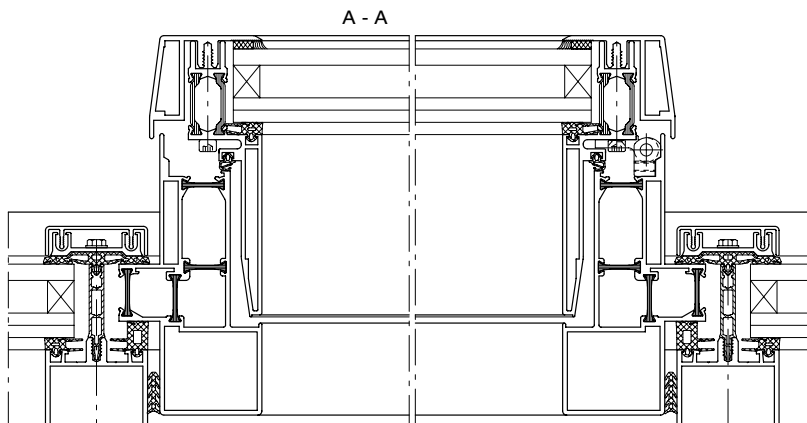


fig. 21.31

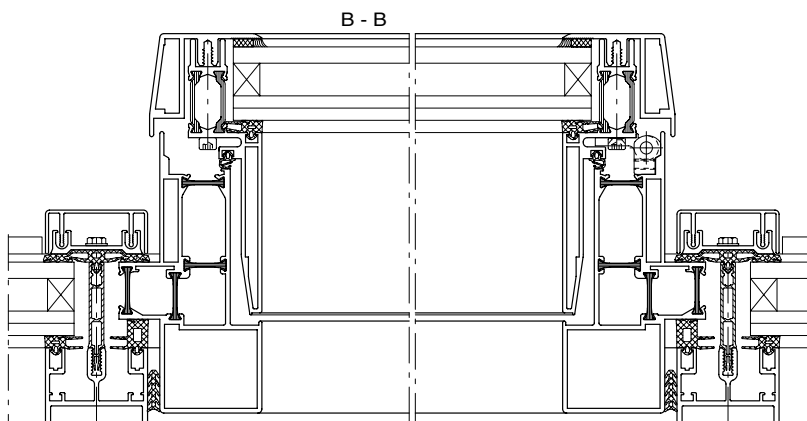


fig. 21.32