

# TB-600 SERIES

11-2015-V.02

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## TB-600 SERIES

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# GULF EXTRUSIONS

Gulf Extrusions Co. LLC, the flagship company of the Al Ghurair Group of Companies, was founded in 1978, Dubai, UAE where it has over the years earned the reputation known as one of the most innovative and reliable companies in the Middle East.

Located close to its raw material supplier Dubai Aluminium Company Ltd (DUBAL), the world's largest single smelter site, Gulf Extrusions has become one of the largest extrusion plants in the region.

Gulf Extrusions quality products can be seen in many of today's progressive structures. The company was formed with the sole purpose to meet the increasing demands for aluminium extrusions in domestic, regional and international markets.

Gulf Extrusions six presses and highly skilled workforce are able to produce 60,000 metric tonnes per annum with a rated capacity of 24,000 tonnes for powder coated finish, 6,000 tonnes for anodized finish and can offer more than 18,000 profile designs. These extrusions cover numerous industries ranging from architectural to transportation, engineering to structural sections, components for household items, HVAC and customized products.

During the progressive stages of Gulf Extrusions, from its inception to expansion, the company not only has acquired a majority share in the local market, it has also made its presence felt globally throughout the GCC countries, Indian sub -continent, South East Asia, Australia, Africa, Europe and Canada.

Our commitment and utmost priority is to provide customers with the finest quality of aluminium extrusions.

Gulf Extrusions looks ahead to inevitable challenges and product advancements of the new era.

Quality is an inseparable element of all activities carried out at Gulf Extrusions. Gulf Extrusions is dedicated to respond and deliver on time, high quality, tailor-made and cost effective products. The management and staff are committed to implement a comprehensive and integrated Quality Management System in accordance with the International Quality Standards of ISO 9001 and ISO 14001.

### **INTERNATIONAL STANDARD COMPLIANCE**

#### Extrusions Dimensions Tolerances:

- BS EN 755 - 9:2008
- BS EN 12020 - 2:2008
- DIN 1748, DIN 17615
- ASTM B221

#### Powder Coated Finish:

- BS:6496 Clause: 10.4, 10.5, 10.6, 10.7 & 10.8
- ISO 2360 / 2813 / 2409 / 2931
- Minimum Film Thickness – 60 Microns

#### Anodizing Finish:

- BS EN 12373-1 2001 Clause 7 (BS:6161 Part 6)
- BS:3987 Clause 2, 3, 5, 6
- Appendix- A, B, C, D, E, F, G, H, J, K, L Minimum Film Thickness- 16 Microns



### **PRODUCT QUALITY CERTIFICATES**



Qualicoat (European Powder Coaters Association):

- A quality label for coating on metal for Architectural Applications
- A product license under the control of EWAA (European Wrought Aluminium Association) in Zurich Switzerland



Qualanod (European Anodizers Association):

- A quality label organization to guarantee high quality Aluminium Anodizing.
- A product license under the control of EWAA (European Wrought Aluminum Association) in Zurich Switzerland



- SASO



- ESMA



Health & Safety:

- OHSAS 18001 (Certification for occupational health & safety management)



Management:

- ISO 9001 (Quality Management System)



- ISO/TS 16949:2009 (Management System)



Environment:

- ISO 14001 (Environment Management System)



Membership in International Organization:

- AAC member (Aluminium Anodizers Council - USA)
- AEC member (Aluminum Extruders Council - USA)
- DIN EN 15088



**CHEMICAL COMPOSITIONS**

**ALLOY 6005A**

Element	Minimum	Maximum
Si	0.50	0.90
Fe	-	0.35
Cu	-	0.30
Mn	-	0.50
Mg	0.40	0.70
Cr	-	0.30
Zn	-	0.20
Ti	-	0.10
Other Each	-	0.05
Other Total	-	0.15
Aluminium	Remainder	

**ALLOY 6060**

Element	Minimum	Maximum
Si	0.30	0.60
Fe	0.10	0.30
Cu	-	0.10
Mn	-	0.10
Mg	0.35	0.60
Cr	-	0.05
Zn	-	0.15
Ti	-	0.10
Other Each	-	0.05
Other Total	-	0.15
Aluminium	Remainder	

**ALLOY 6063**

Element	Minimum	Maximum
Si	0.20	0.60
Fe	-	0.35
Cu	-	0.10
Mn	-	0.10
Mg	0.45	0.90
Cr	-	0.10
Zn	-	0.10
Ti	-	0.10
Other Each	-	0.05
Other Total	-	0.15
Aluminium	Remainder	

**ALLOY 6082**

Element	Minimum	Maximum
Si	0.70	1.30
Fe	-	0.50
Cu	-	0.10
Mn	0.40	1.00
Mg	0.60	1.20
Cr	0.04	0.15
Zn	-	0.20
Ti	-	0.10
Other Each	-	0.05
Other Total	-	0.15
Aluminium	Remainder	

**ALLOY 6061**

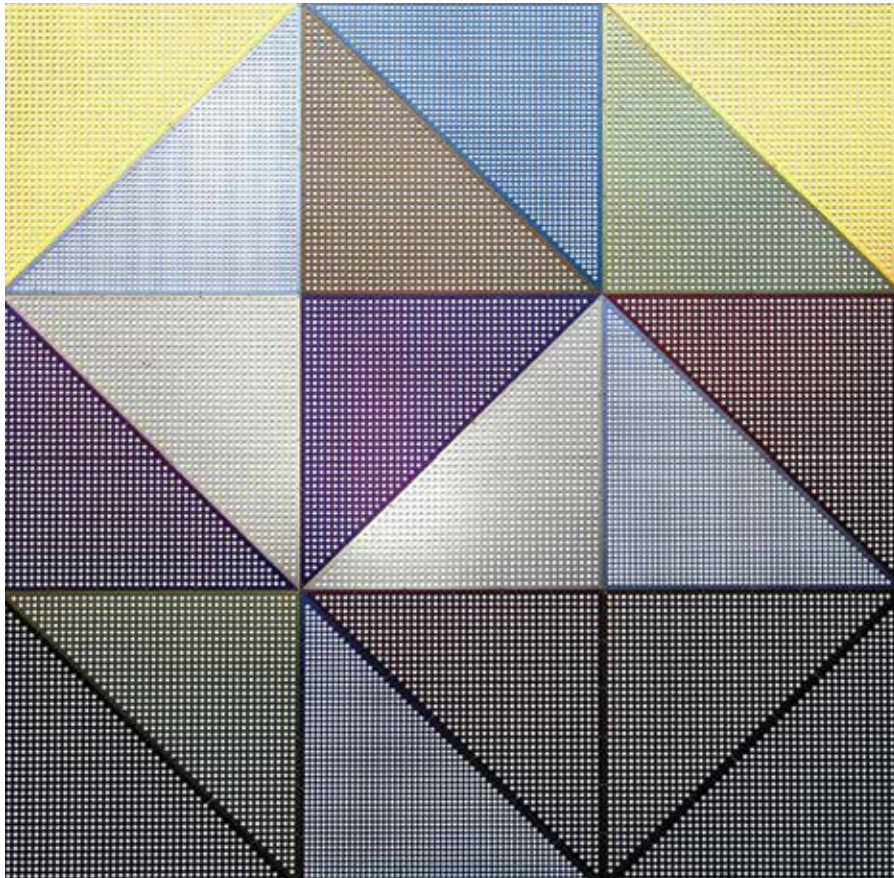
Element	Minimum	Maximum
Si	0.40	0.80
Fe	-	0.70
Cu	0.15	0.40
Mn	-	0.15
Mg	0.8	1.20
Cr	0.04	0.35
Zn	-	0.25
Ti	-	0.15
Other Each	-	0.05
Other Total	-	0.15
Aluminium	Remainder	

**ANODIZING**

A wide range of anodizing treatment options are possible for the aluminium profile sections of this system. The color choices from Gulf Extrusions range from Natural, Gold, and Bronze to Spectro colors (Red, Blue, Green, and Gray).

This surface treatment process involves first pre-treatment with scotch brite brushing for the unfinished profiles, and then subsequently fully immersing the aluminium profiles in an acidic electrolyte solution through which electric current is passed creating an anodic film on the profiles ranging from 5-30MICs.

The process is guaranteed and certified for use by QUALANOD - A quality label Organization to guarantee high quality aluminium anodizing and the company's ISO 9001 certification.





**Authorization to use the quality sign**



This is to certify that

**GULF EXTRUSIONS CO. LLC**

P.O. BOX 5598  
AE – Dubai

**Licence number: 2000**

is authorized to use the quality sign which is shown above according to the REGULATIONS FOR USE OF THE QUALANOD QUALITY LABEL FOR SULPHURIC ACID-BASED ANODIZING OF ALUMINIUM.

**Date of issue of the licence:** 10.03.2000  
**Period of validity of the licence:** until 31.12.2016

Zurich, 12 November 2015

**QUALANOD**

Thomas Becker  
President

**CERTIFICATION BODY**

Josef Schoppig  
AC-Fiduciaire SA



Mailing address:  
QUALANOD, P.O. Box 1507, CH-8027 Zurich  
Domicile:  
QUALANOD c/o AC-Fiduciaire SA, Tödistrasse 47, CH-8002 Zurich

Phone: +41 (0)43 305 09 70  
Fax: +41 (0)43 305 09 98  
E-mail: info@qualanod.net  
Internet: www.qualanod.net

**POWDER COATING**

- Horizontal & Vertical Powder coating lines with an Annual Capacity of 24 000 MT  
Powder Coating BS: 6496 Clause: 10.4, 10.5, 10.6, 10.7, & 10.8  
ISO 2360/2813/2409/2931  
Minimum Film Thickness - 60 Microns

A wide choice of colors for powder coating can be used for the aluminium profile sections.

From Gulf Extrusions the following powder types are available

- Polyester Façade (PE-F)
- Super Durable Façade (SDF) & Hyper Durable Façade (HDF) (Where SDF & HDF are equivalent to Poly-Vinylidene DiFluoride (PVDF) in terms of corrosion performance)
- Anti Bacterial (recommended to be used in Hospitals)
- Anti Static (recommended for laboratories, electronics assembly buildings) and Heat Resistant in nature.

This surface treatment process involves the following pre-treatment

1. Degreasing
2. Washing
3. Etching
4. Washing
5. Chromatising
6. Double washing in dematerialized water

Once completed, powder is applied using an electrostatic spraying process with charged powder particles, followed by curing in an oven under a controlled temperature of 180-200C for paint polymerization where the paint layer is at least 60mic.

This whole process is certified for use from QUALICOAT - A quality label for coating on metal for Architectural Applications.

GUARANTEE PERIOD:  
10 years for PE-F Quality  
25 years for PE-SDF

## Authorization to use the quality sign



This is to certify that

### GULF EXTRUSIONS CO. LLC

P.O. BOX 5598  
AE – Dubai

### Licence number: 1901

is authorized to use the quality sign which is shown above according to the REGULATIONS FOR THE USE OF THE QUALICOAT QUALITY SIGN FOR PAINT, LACQUER AND POWDER COATINGS ON ALUMINIUM FOR ARCHITECTURAL APPLICATIONS.

**Date of issue of the licence:** 15.03.2000  
**Period of validity of the licence:** until 31.12.2016

Zurich, 17 November 2015

#### QUALICOAT

*M. C. Panam*

Mohammed C. Panam  
President

#### CERTIFICATION BODY

*JS*

Josef Schoppig  
AC-Fiduciaire SA



Mailing address:  
QUALICOAT, P.O. Box 1507, CH-8027 Zurich  
Domicile:  
QUALICOAT c/o AC-Fiduciaire SA, Tödistrasse 47, CH-8002 Zurich

Phone: +41 (0)43 305 09 70/79  
Fax: +41 (0)43 305 09 98  
E-mail: info@qualicoat.net  
Internet: www.qualicoat.net

# INTRODUCTION TO THE SYSTEM

TB-600 Thermal break Hinged system is a unique, elegant 60mm width frame designed to achieve a better performance with a wide variety of frames available to cover the needed applications. It is designed for heavy duty use (H-HC40) according to the American National Standard. The results have been impressive to energy conservation, sound reduction, water and dust proofing.

The importance of thermal conductivity in the aluminum frame becomes apparent when one considers that the frame accounts for an average of 25% of the total window surface.

Normal Aluminum Profiles  $k=5.7 \text{ W/M}^2\text{k}$   
With 16mm Thermal Strip  $K=3.3 \text{ W/M}^2\text{K}$

All profiles are available in all colors in order to meet today's modern architectural requirements, along with the possibility of bi-coloration due to the separation done by the thermal break strips.

For better performance of the System, Alignment cleats for the frame and the shutter are used. Durable weather sealment mastic is a must at all joints. Specially designed EPDM gaskets are made available with the system to enhance the performance and create easy assembly. Other accessories such as rollers and flush handles come as part of the system.

## Sections:

The sections in gulf extrusions line are produced by extruding aluminum on a wide range of presses starting with a 800 tons to 4400 tons press. They are made of aluminum alloys 6060,6063,6082,6005 according to British Standard Specification for extrusion Dimensions Tolerances BS EN 755-9:2008 and BS EN 12020-2:2008

## Frame:

Tubular with a width of 60mm, a wide range of frames is available to suit most of the required application in the building codes.

## Sash:

Tubular straight. They are 60 or 67 mm thick. A wide range available to cover all applications of doors, single and double leaves and outward openings even swing doors.

**Assembly:**

Assembly of the frames and sashes is done by 45° cut whereas door bottom on profiles are custom 90°.

**Glazing:**

Standard or insulating ranges from "18 to 38"mm maintained by 3 EPDM gaskets and a glazing bead must be on the inside installation.

**Sealing:**

Sealing is achieved by the compression of 3 EPDM gaskets pressured during closing.

**Performance:****THERMAL SYSTEM**

Casement & Turn + Tilt Window /HINGED DOOR

1. 18.6MM Polymide strip can withstand up to 220°C with high thermal resistance to reduce heat transfer from  $k= 5.7 \text{ W/M}^2\text{K}$  to  $K=3.0 \text{ W/M}^2\text{K}$
2. Insulated glass unit, ensuring the performance of the system interms of energy conservation and sound insulation.
3. Outer contact gasket for efficient sound insulation and sealing against water and dust.
4. Inner gasket to enhance the system performance.
5. Central sealing Gasket.
6. Special EPDM GASKETS TO HOLD GLASS IN POSITION.

## Confirmation of Testing Compliance

### CLADDING TECHNOLOGY DIVISION

Ref. AFBT Report No: DLR0448 Date: June 2008

AFBT COTC No: WQ 07 23352 / C595

**System Supplier:**  
Gulf Extrusions Co.,  
P. O. Box 5598,  
Dubai,  
U.A.E

**Installer:**  
Gulf Extrusions Co.,  
P. O. Box 5598,  
Dubai,  
U.A.E

**System:** System Development  
SIDE HINGED WINDOW

Al Futtaim Bodycote (AFB) tested components from the above-mentioned system at their Dubai laboratory on the date shown for the following parameters:

- ▶ Air Infiltration ASTM E283-04
- ▶ Water Penetration ASTM E331-00 (Static)
- ▶ Wind Resistance ASTM E330-02 (Serviceability)
- ▶ Wind Resistance ASTM E330-02 (Safety)

At the time of test, the system was found to comply with specification requirements for all the parameters tested. This confirmation of testing compliance relates only to the system described above, installed and tested at AFB Dubai laboratory, as fully detailed in test report referenced above.

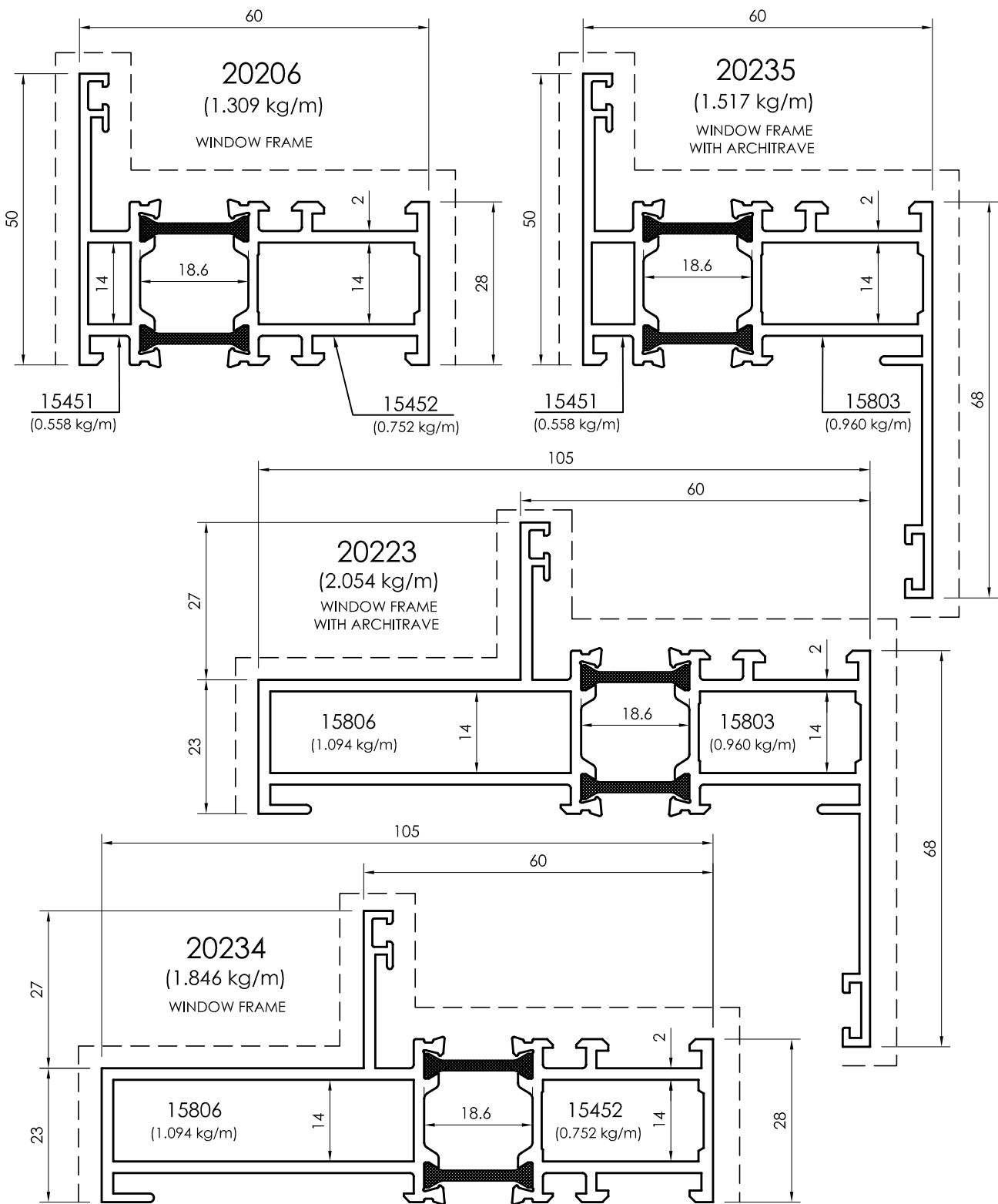
Tests marked ' \* ' in this report are not included in our UKAS schedule of accreditation.

Signed:  Test Engineer

Signed:  Cladding Manager

# PROFILES

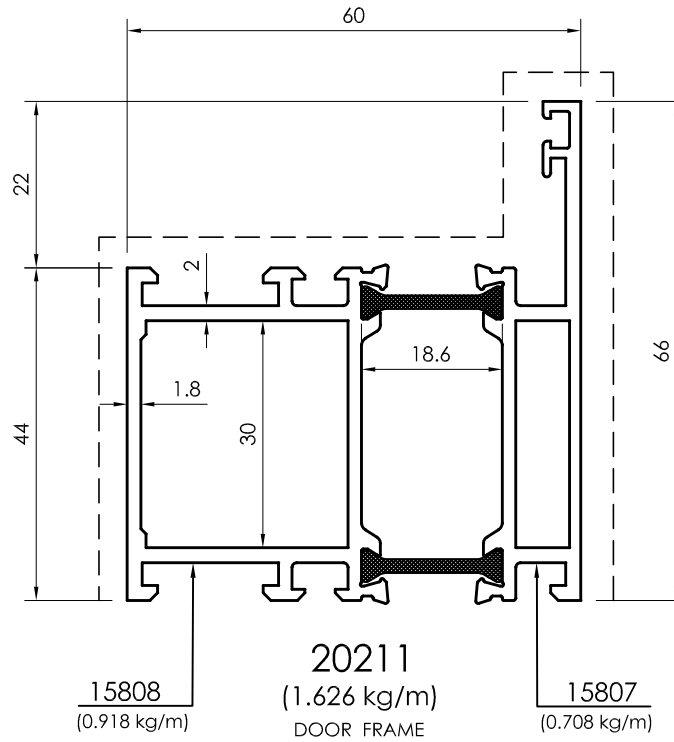
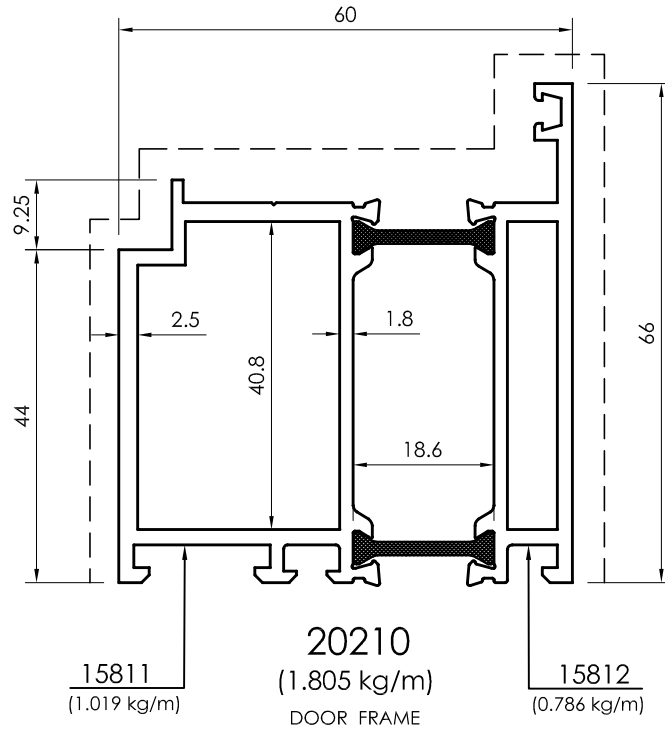
Frame Profiles



All dimensions in mm  
Visible area\_\_\_\_\_

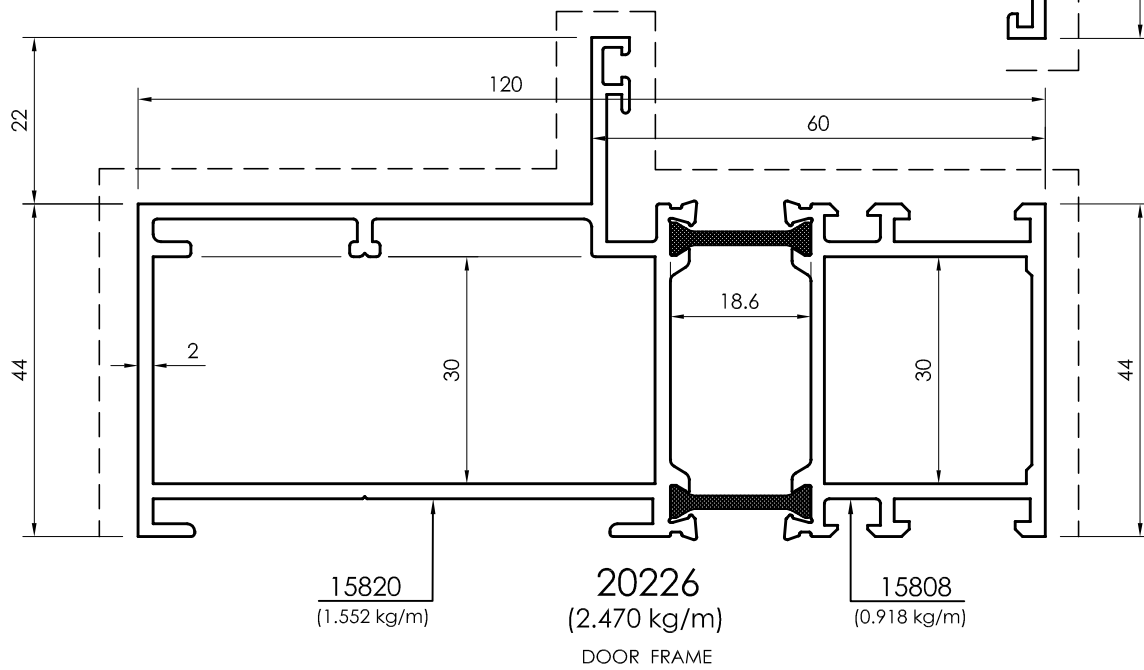
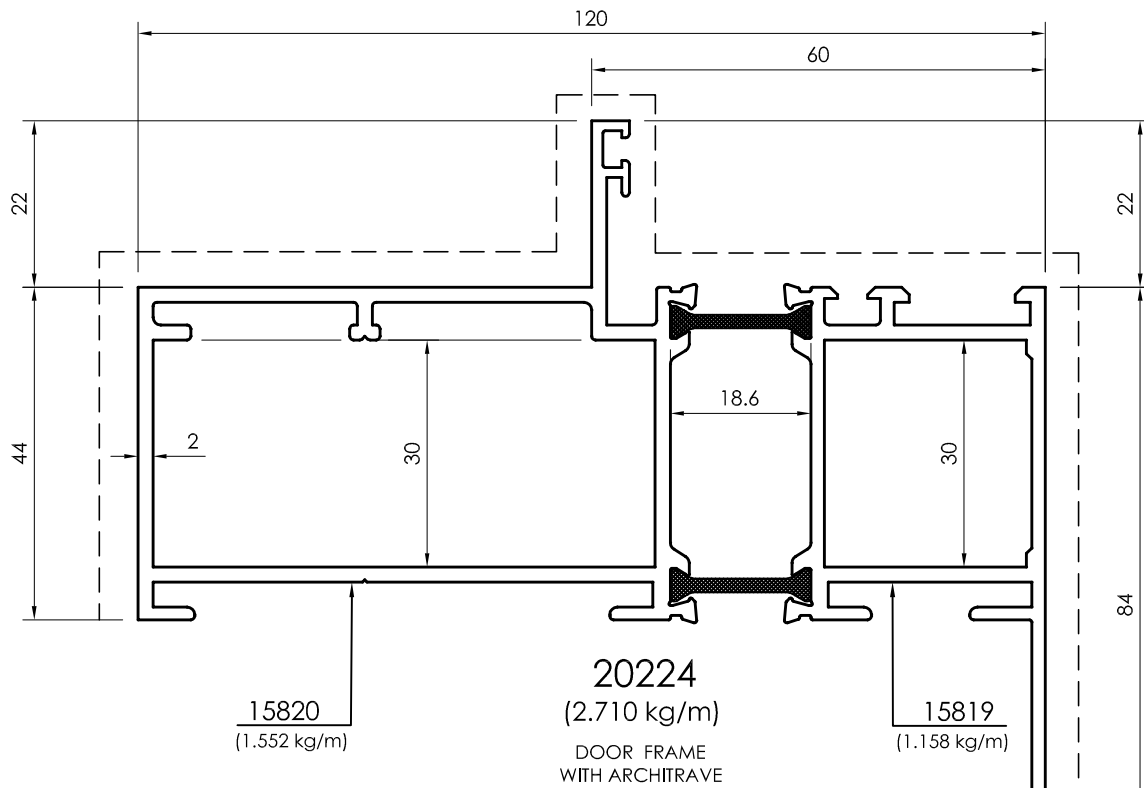


Frame Profiles



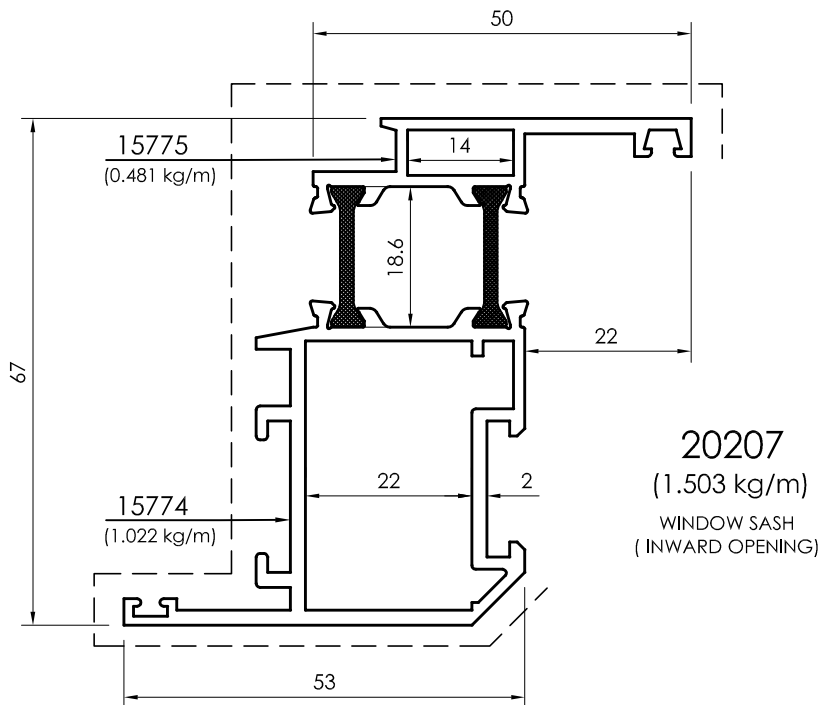
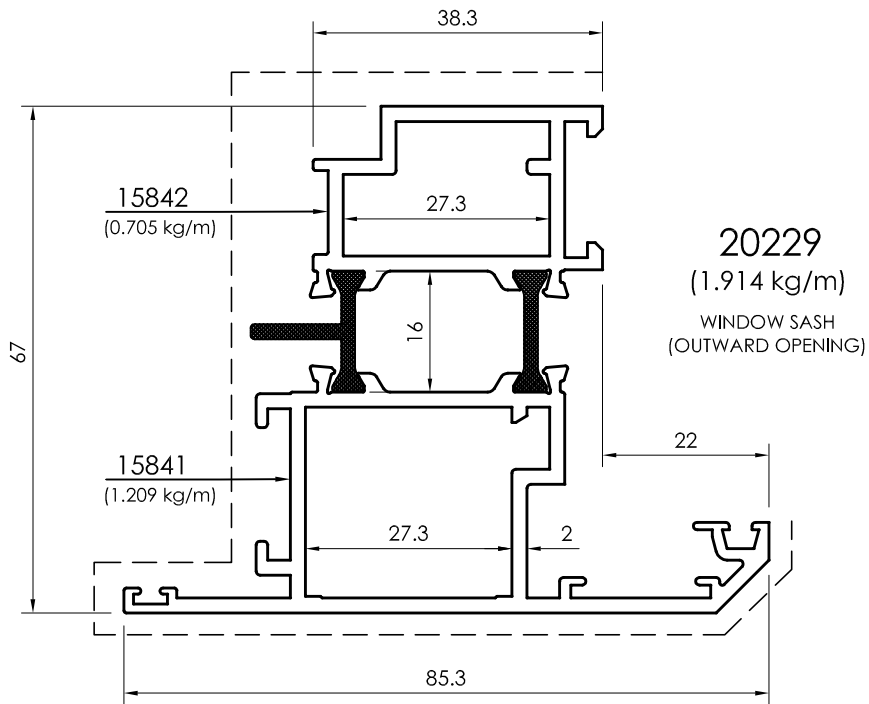
All dimensions in mm  
----- Visible area

Frame Profiles



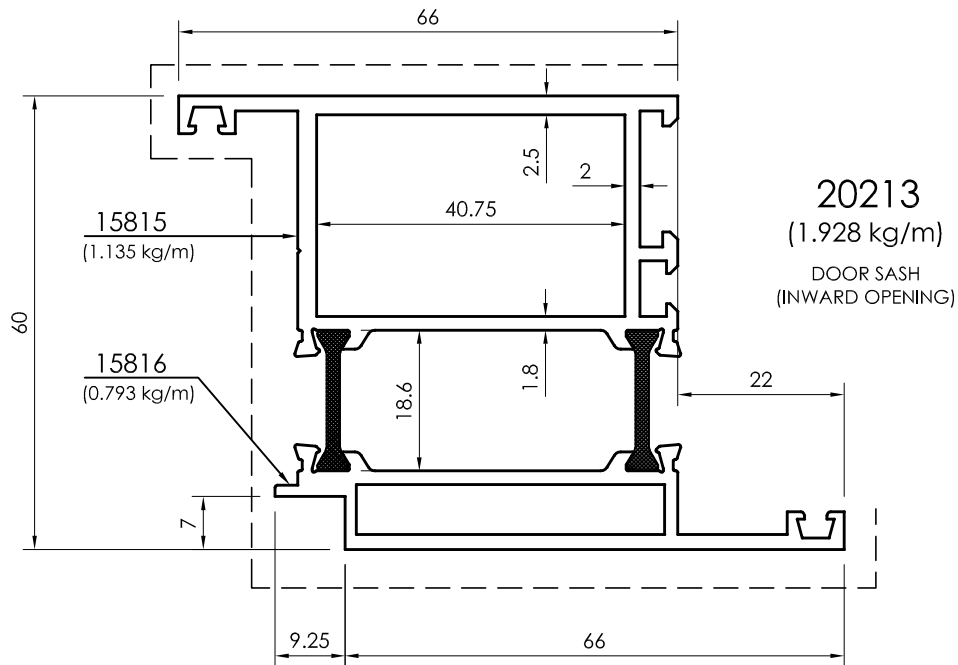
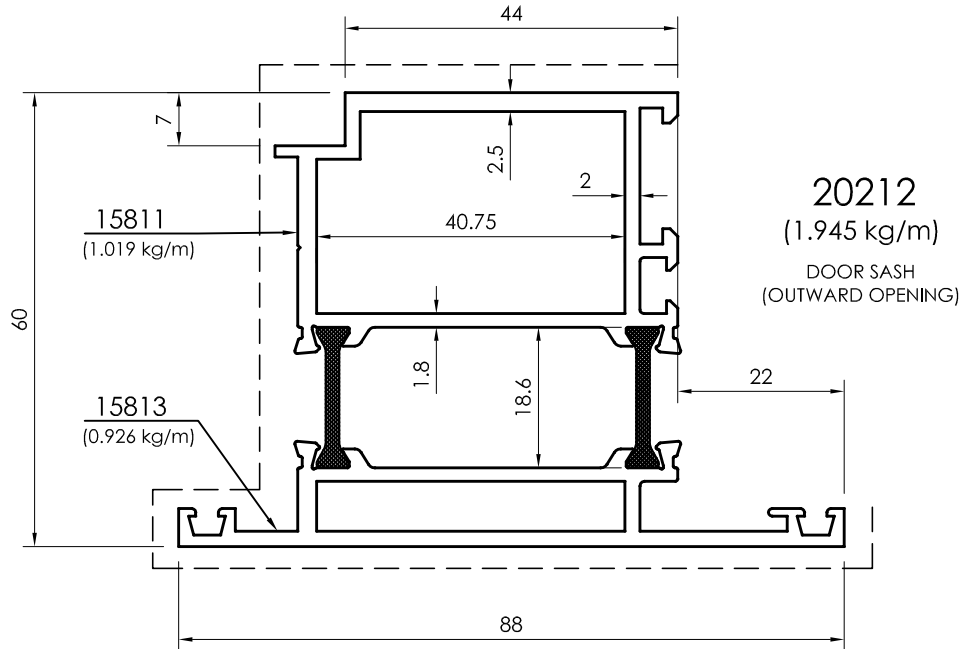
All dimensions in mm  
Visible area\_\_\_\_\_

Sash Profiles



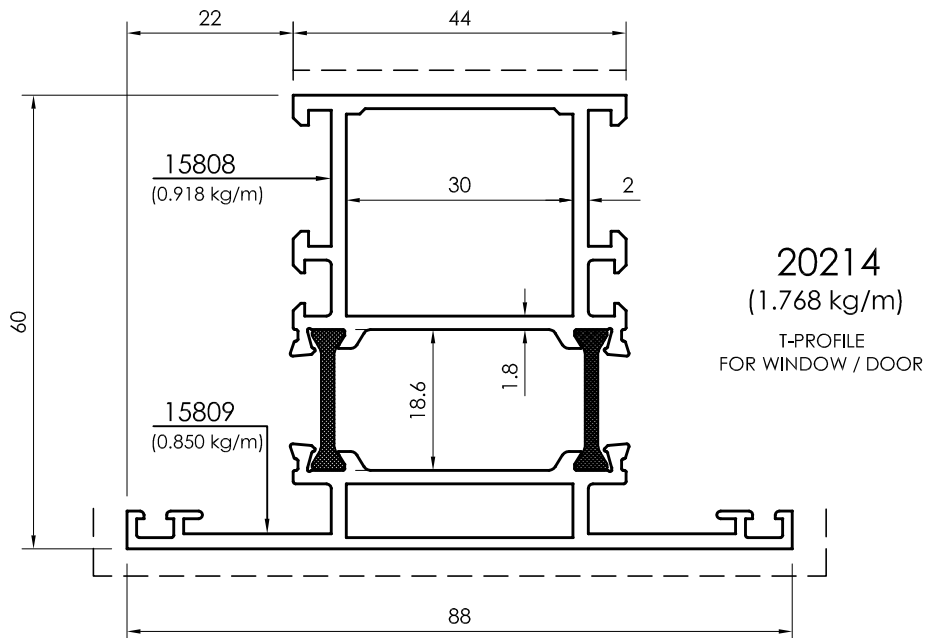
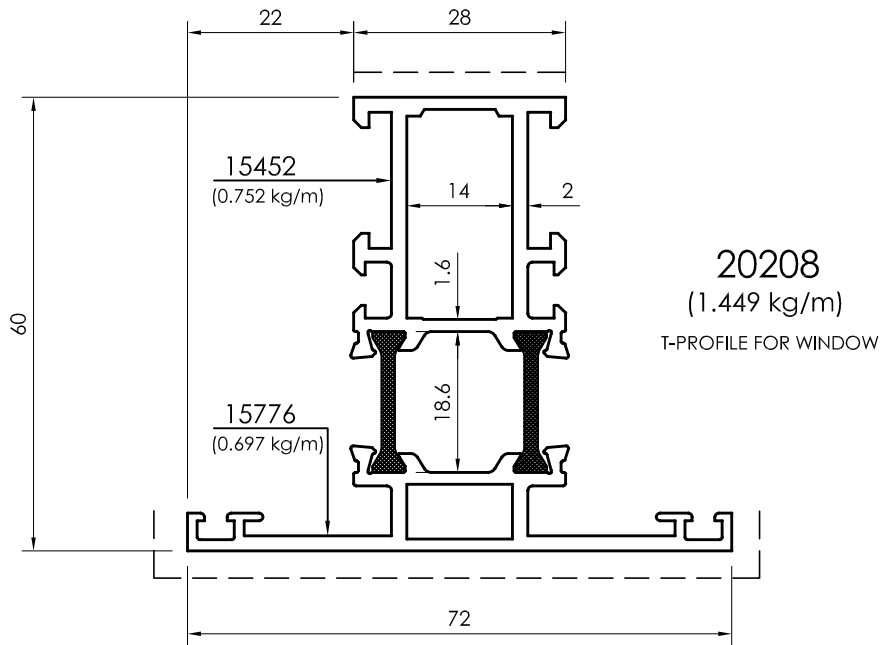
All dimensions in mm  
----- Visible area

## Sash Profiles



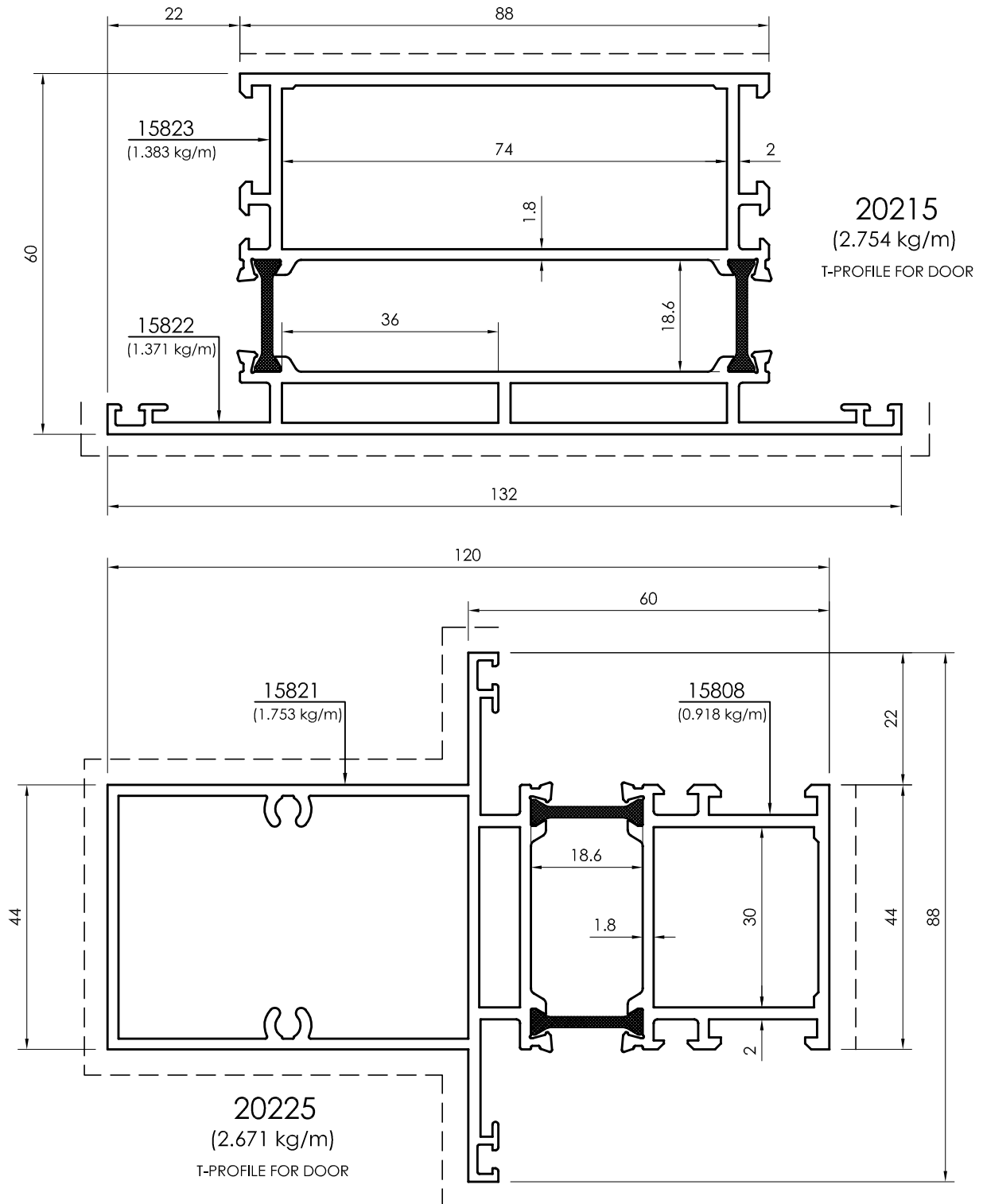
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T - Profiles



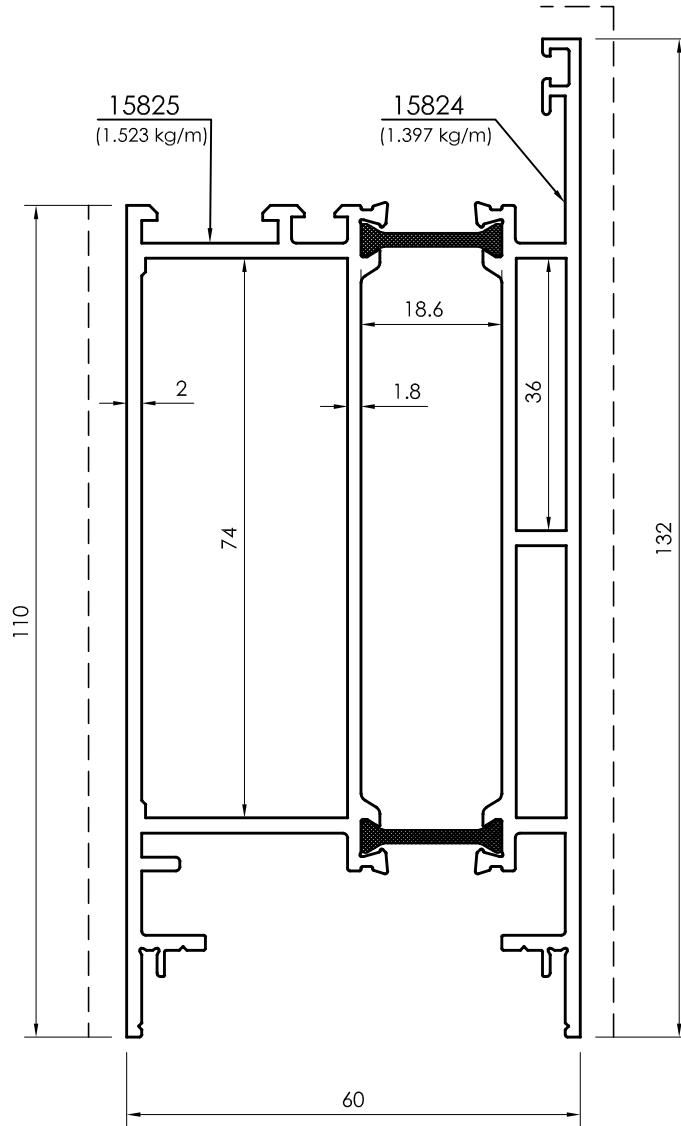
All dimensions in mm  
----- Visible area

T - Profiles



All dimensions in mm  
 Visible area\_\_\_\_\_

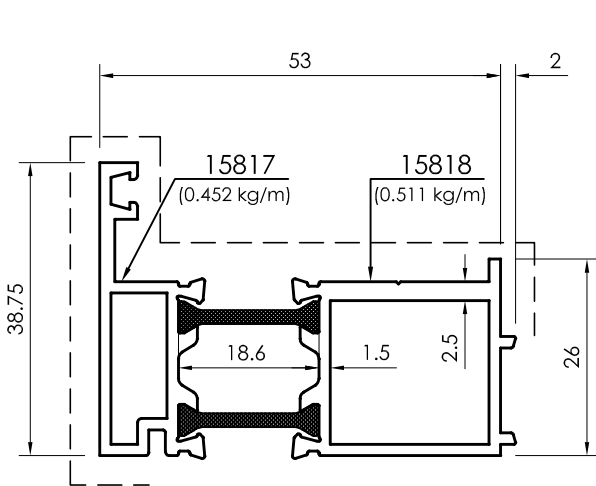
Door Bottom Profiles



**20227**  
 (2.920 kg/m)  
 BOTTOM PROFILE FOR DOOR

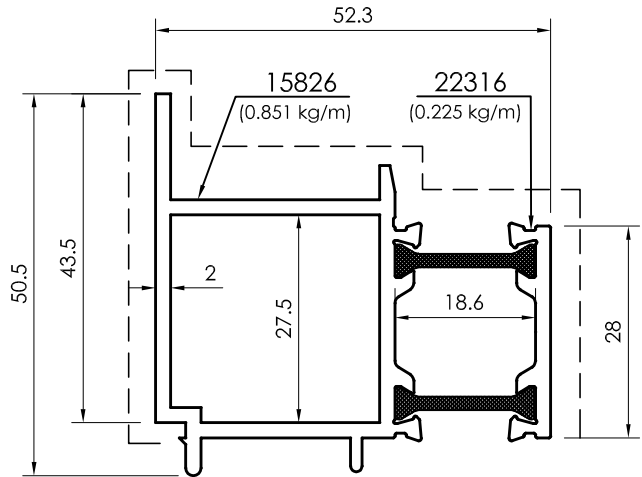
All dimensions in mm  
 ----- Visible area

Complementary Profiles



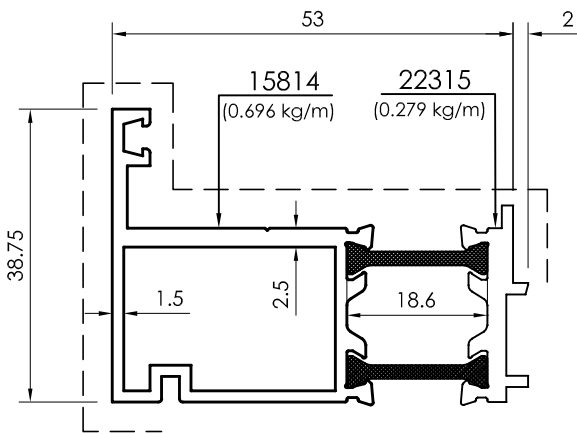
**20216**  
(0.963 kg/m)

FASTENED TO SASH PROFILE 20213  
(FOR DOUBLE LEAF HINGED DOORS  
INWARD OPENING)



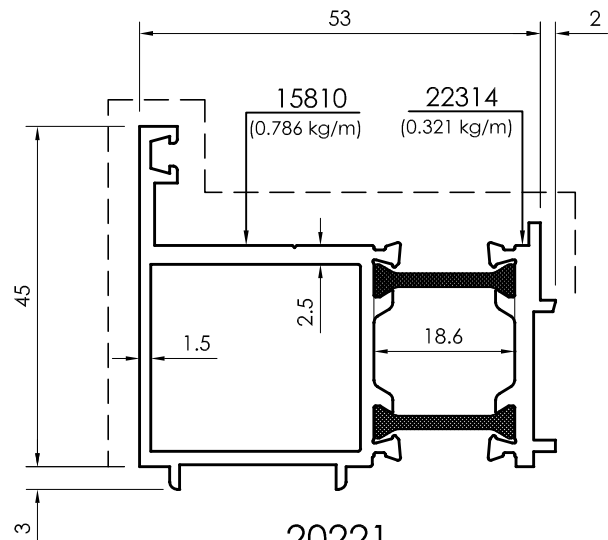
**20220**  
(1.076 kg/m)

FASTENED TO FRAME PROFILE 20206/20211  
T-PROFILE 20214  
(ONLY FOR PIVOT WINDOWS)



**20222**  
(0.975 kg/m)

FASTENED TO SASH PROFILE 20212  
(FOR DOUBLE LEAF HINGED DOORS  
OUTWARD OPENING)



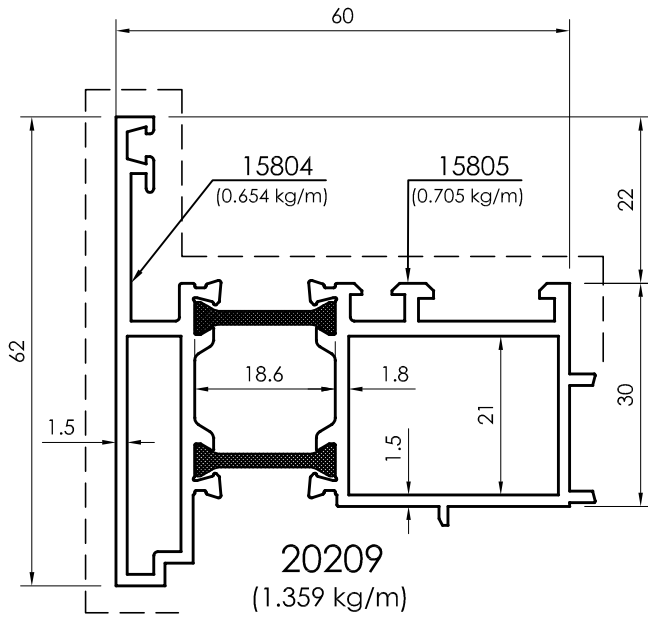
**20221**  
(1.107 kg/m)

FASTENED TO FRAME PROFILE 20211  
(FOR HINGED DOORS  
OUTWARD OPENING)

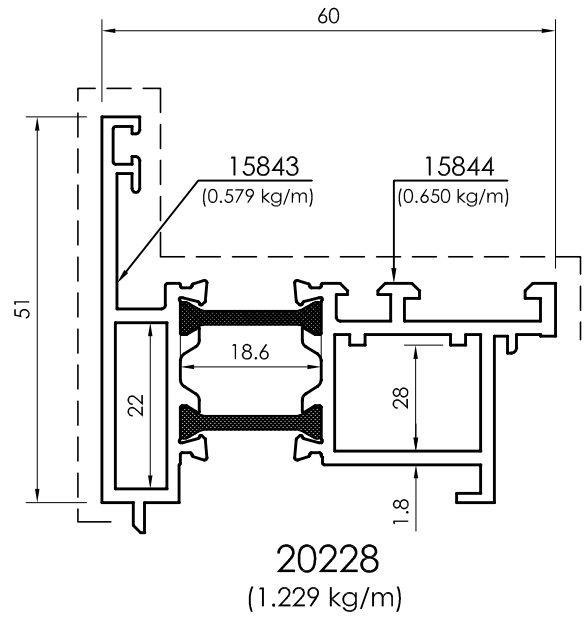
All dimensions in mm  
Visible area\_\_\_\_\_



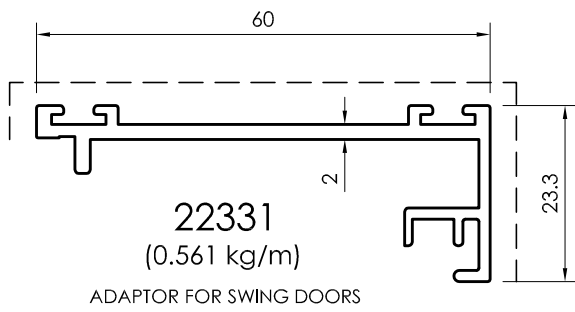
Complementary Profiles



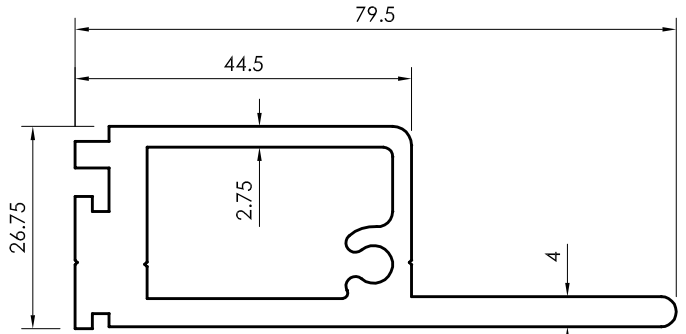
**20209**  
(1.359 kg/m)  
FASTENED TO SASH PROFILE 20207  
(FOR DOUBLE LEAF HINGED WINDOW  
INWARD OPENING)



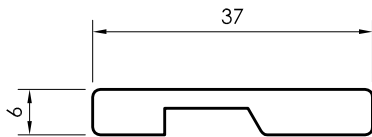
**20228**  
(1.229 kg/m)  
ADAPTOR PROFILE USED WITH  
FRAME PROFILE 20206  
(FOR HINGED WINDOW OUTWARD OPENING)



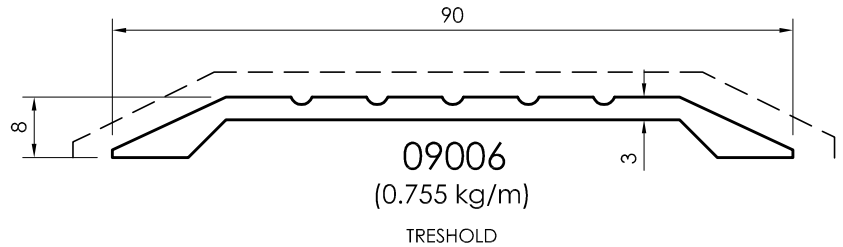
**22331**  
(0.561 kg/m)  
ADAPTOR FOR SWING DOORS



**12871**  
(1.797 kg/m)  
TO JOIN T-PROFILE WITH THE FRAME PROFILES-20206 ,20211 &  
TO THE SASH PROFILE 20213(MILL FINISH)



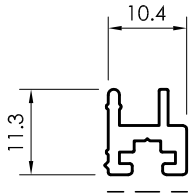
**10300**  
(0.507 kg/m)  
TO USE WITH 20206 / 20211 Etc.  
(MILL FINISH)



**09006**  
(0.755 kg/m)  
TRESHOLD

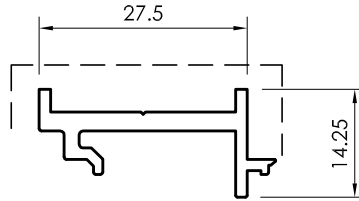
All dimensions in mm  
----- Visible area

## Complementary Profiles



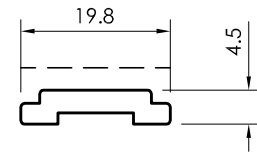
**22317**  
(0.157 kg/m)

TO USE WITH  
BOTTOM PANEL 20227



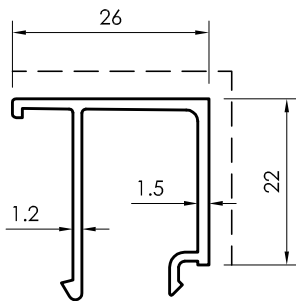
**22313**  
(0.298 kg/m)

TO USE WITH  
HINGED DOOR FRAME  
20211 / 20224 / 20225 / 20226



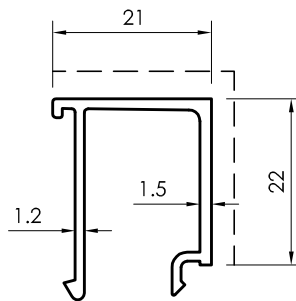
**09888**  
(0.175 kg/m)

TO USE WITH SASH PROFILE  
20207 & 20229 FOR  
LOCKING ARRANGEMENT



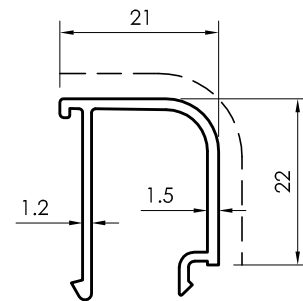
**10371**  
(0.298 kg/m)

GLAZING BEAD FOR  
GLASS THICKNESS FROM  
18mm TO 22mm



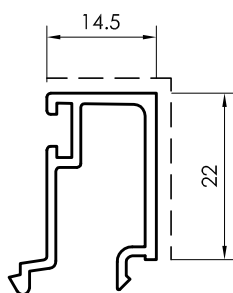
**10372**  
(0.279 kg/m)

GLAZING BEAD FOR  
GLASS THICKNESS FROM  
24mm TO 28mm

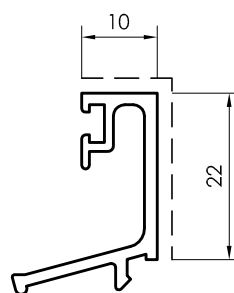


**11546**  
(0.267 kg/m)

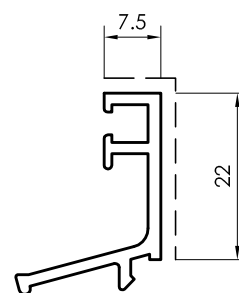
GLAZING BEAD FOR  
GLASS THICKNESS FROM  
24mm TO 28mm  
(7mm CORNER RAD.)



**10377**  
(0.282 kg/m)  
GLAZING BEAD FOR  
GLASS THICKNESS 32mm



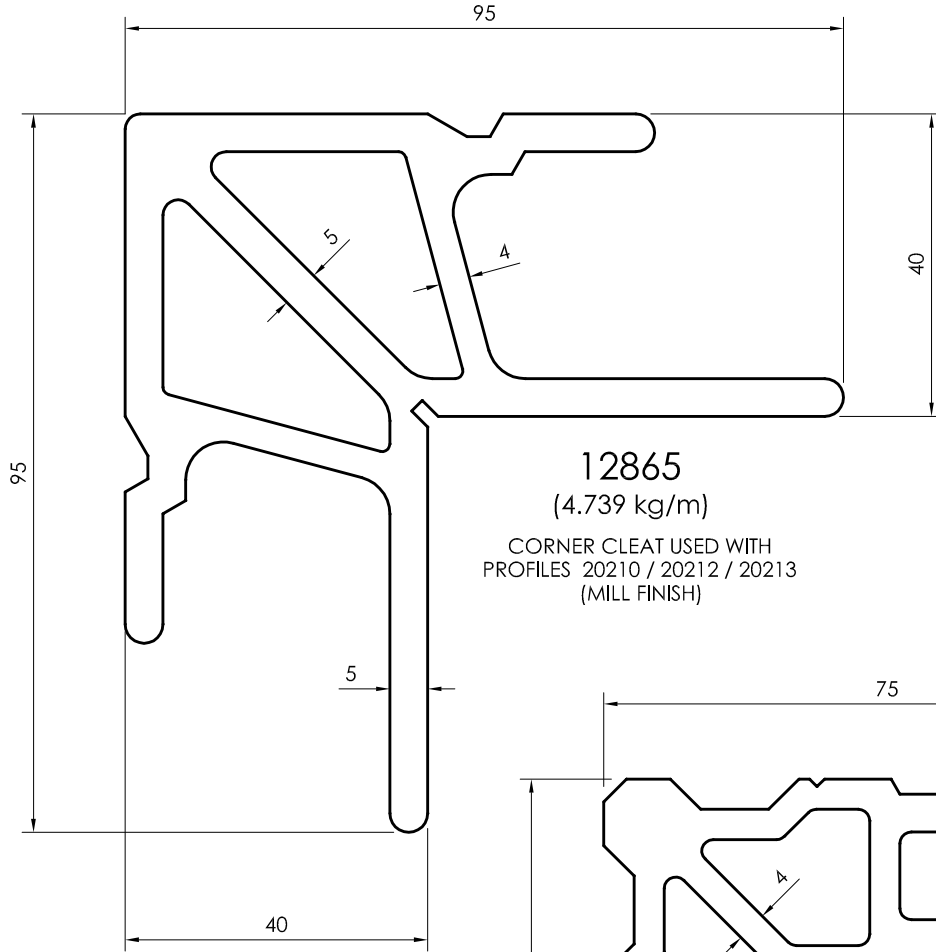
**10464**  
(0.271 kg/m)  
GLAZING BEAD FOR  
GLASS THICKNESS 35mm



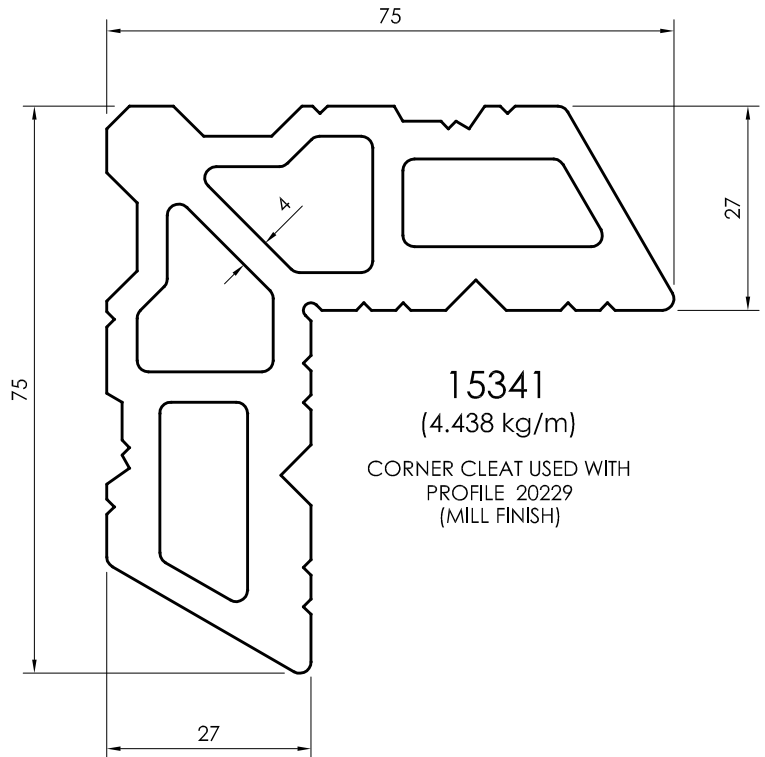
**11321**  
(0.251 kg/m)  
GLAZING BEAD FOR  
GLASS THICKNESS 38mm

All dimensions in mm  
Visible area\_\_\_\_\_

Corner Cleat Profiles



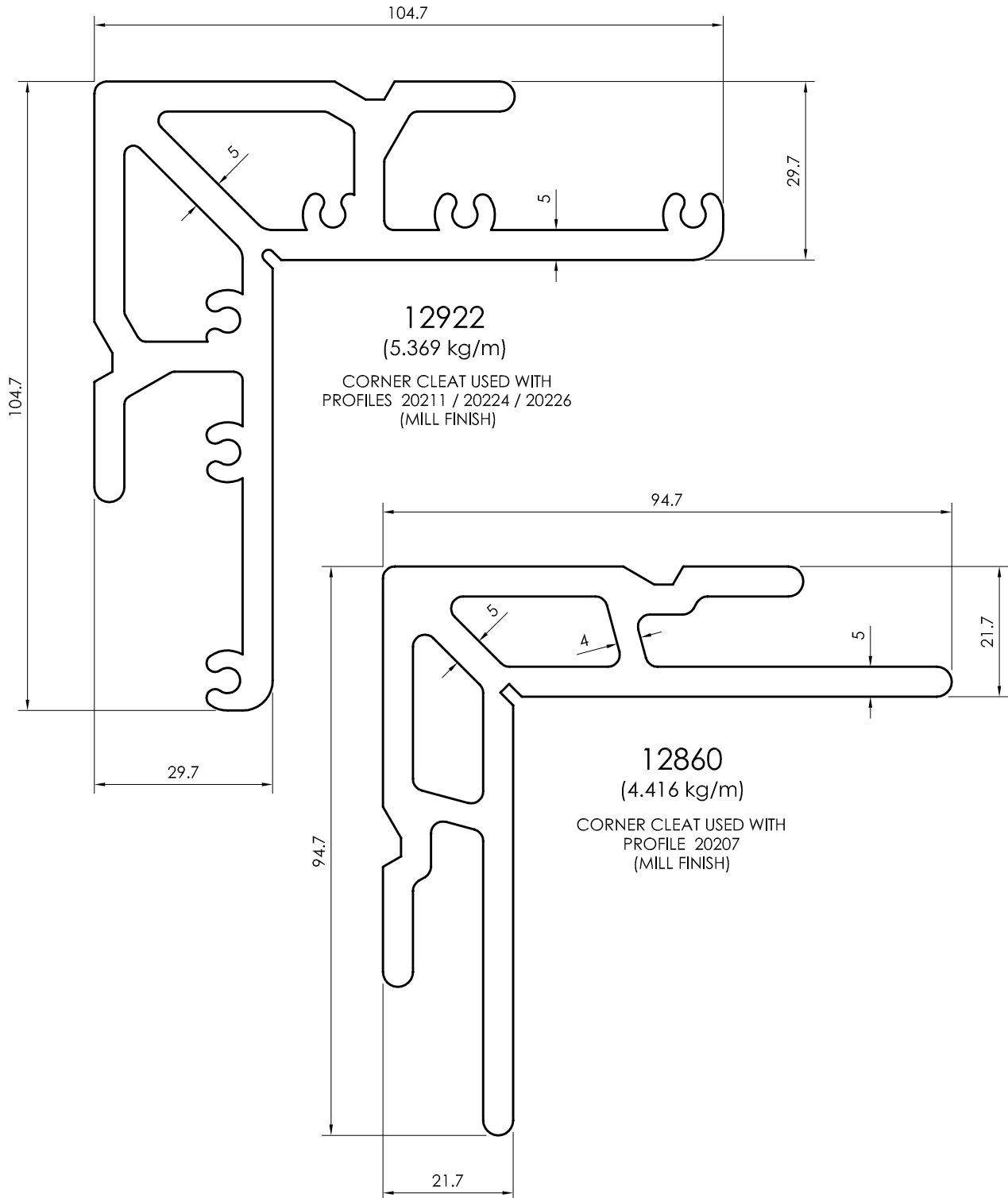
**12865**  
 (4.739 kg/m)  
 CORNER CLEAT USED WITH  
 PROFILES 20210 / 20212 / 20213  
 (MILL FINISH)



**15341**  
 (4.438 kg/m)  
 CORNER CLEAT USED WITH  
 PROFILE 20229  
 (MILL FINISH)

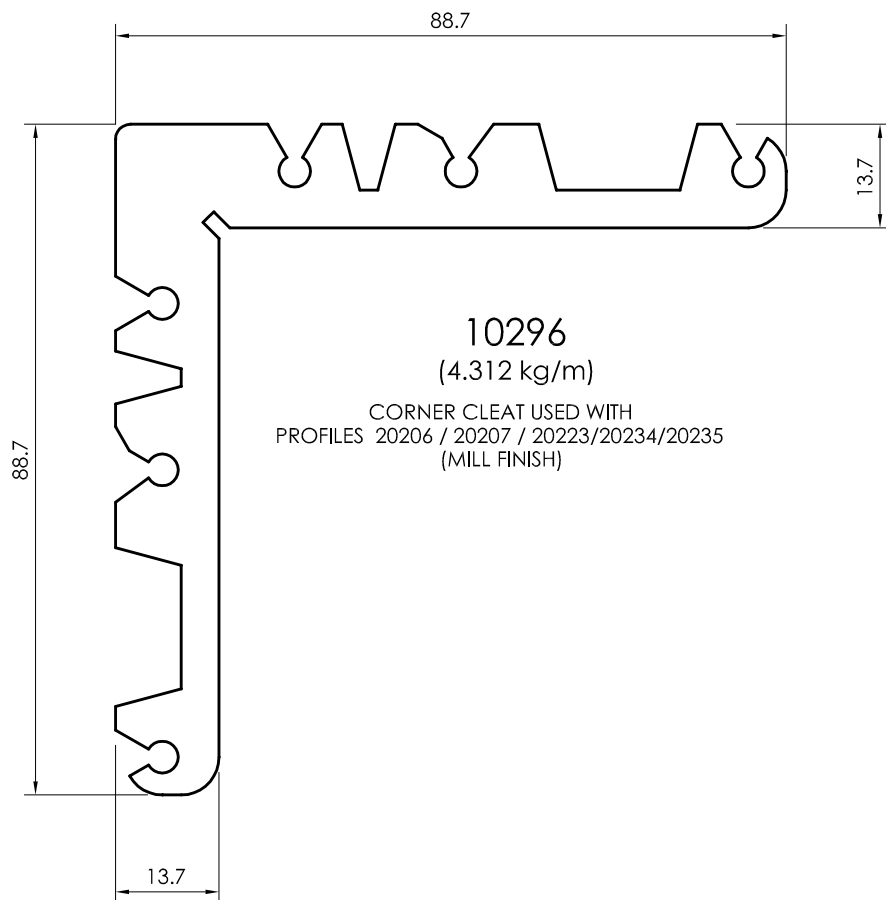
All dimensions in mm  
 ----- Visible area

### Corner Cleat Profiles



All dimensions in mm  
Visible area\_\_\_\_\_

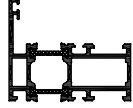
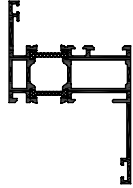
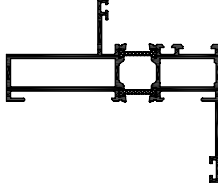
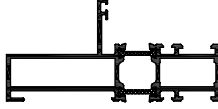
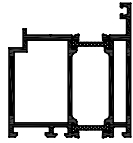
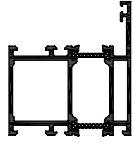
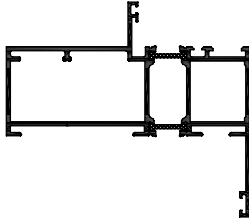
Corner Cleat Profiles



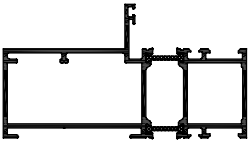
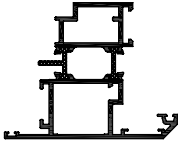
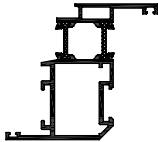
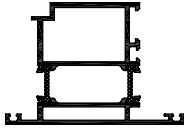
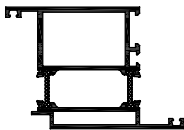
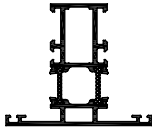
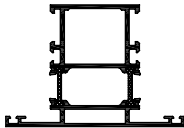
All dimensions in mm  
----- Visible area


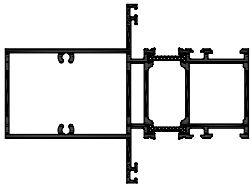



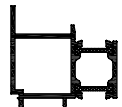
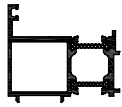


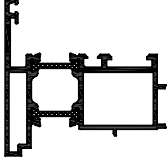
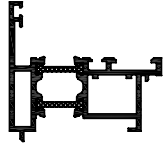





# PROFILE LIST



Profile Reference	Child Profile	Profile Section	Page	Weight KG/M	IX cm <sup>4</sup>	IY cm <sup>4</sup>	WX cm <sup>3</sup>	WY cm <sup>3</sup>
20206	15451 + 15452		14	1.309	7.784	21.577	2.316	6.283
20235	15451 + 15803		14	1.517	19.262	29.602	3.725	9.810
20223	15806 + 15803		14	2.054	20.635	87.691	3.960	14.498
20234	15806 + 15452		14	1.846	9.246	70.822	2.688	12.640
20210	15812 + 15811		15	1.805	26.948	31.577	6.910	9.340
20211	15807 + 15808		15	1.626	20.894	27.436	5.041	8.002
20224	15820 + 15819		16	2.710	49.289	158.867	8.101	23.106




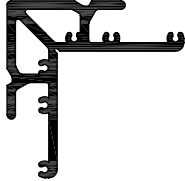




Profile Reference	Child Profile	Profile Section	Page	Weight KG/M	IX cm <sup>4</sup>	IY cm <sup>4</sup>	WX cm <sup>3</sup>	WY cm <sup>3</sup>
20226	15820 + 15808		16	2.470	30.9622	134.832	7.472	20.958
20229	15842 + 15841		17	1.914	38.108	26.617	10.030	6.221
20207	15775 + 15774		17	1.503	32.903	14.483	9.433	3.851
20212	15811 + 15813		18	1.945	34.528	34.905	9.755	7.512
20213	15815 + 15816		18	1.928	36.263	34.677	11.346	7.455
20208	15452 + 15776		19	1.449	24.367	11.917	6.700	3.310
20214	15808 + 15809		19	1.768	30.184	27.631	8.400	6.279

Profile Reference	Child Profile	Profile Section	Page	Weight KG/M	IX cm <sup>4</sup>	IY cm <sup>4</sup>	WX cm <sup>3</sup>	WY cm <sup>3</sup>
20215	15823 + 15822		20	2.754	49.182	125.924	13.684	19.080
20225	15821 + 15808		20	2.671	39.556	124.612	8.990	19.056
20227	15825 + 15824		21	2.920	144.013	56.403	20.886	16.430
20216	15817 + 15818		22	0.963	4.147	12.870	1.664	4.030
20222	15814 + 22315		22	0.975	4.281	15.202	1.727	5.450
20220	15826 + 22316		22	1.076	7.433	15.315	2.526	5.797
20221	15810 + 22314		22	1.107	7.148	16.737	2.570	5.948




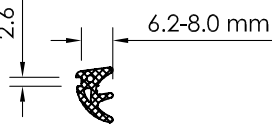
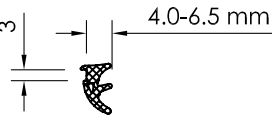





Profile Reference	Child Profile	Profile Section	Page	Weight KG/M	IX cm <sup>4</sup>	IY cm <sup>4</sup>	WX cm <sup>3</sup>	WY cm <sup>3</sup>
20209	15804 + 15805		23	1.359	10.655	22.419	3.040	5.678
20228	15843 + 15844		23	1.229	6.855	18.147	2.120	4.966
22331	--		23	0.561	--	--	--	--
12871	--		23	1.797	--	--	--	--
10300	--		23	0.507	--	--	--	--
22317	--		24	0.157	--	--	--	--
22313	--		24	0.298	--	--	--	--

Profile Reference	Child Profile	Profile Section	Page	Weight KG/M	IX cm <sup>4</sup>	IY cm <sup>4</sup>	WX cm <sup>3</sup>	WY cm <sup>3</sup>
09888	--		24	0.175	--	--	--	--
10372	--		24	0.279	--	--	--	--
11546	--		24	0.267	--	--	--	--
10371	--		24	0.298	--	--	--	--
10377	--		24	0.282	--	--	--	--
10464	--		24	0.271	--	--	--	--
11321	--		24	0.251	--	--	--	--

Profile Reference	Child Profile	Profile Section	Page	Weight KG/M	IX cm <sup>4</sup>	IY cm <sup>4</sup>	WX cm <sup>3</sup>	WY cm <sup>3</sup>
09006	--		23	0.755				
12865	--		25	4.739				
15341	--		25	4.438				
12922	--		26	5.369				
12860	--		26	4.416				
10296	--		27	4.312				



# ACCESSORIES

Gasket Reference	Section	Description	Unit
600.13.005 (SG 2544)		CENTRAL GASKET (FIXED ON TO THE FRAME PROFILE)  (WINDOWS ONLY)	Linear Meter
600.13.001 (SG 1904)		FRONT GLAZING RUBBER USED WITH THE FRAME & SASH PROFILE  (FOR WINDOWS & DOORS)	Linear Meter
600.13.004 (SG 2494)		OUTER & INNER CONTACT GASKET - USED WHERE THE SASH OVER LAPS THE FRAME  (FOR WINDOWS & DOORS)	Linear Meter
600.13.003 (SG 2243)		RUBBER USED WITH GLAZING BEAD	Linear Meter
600.13.002 (SG 2244)		RUBBER USED WITH GLAZING BEAD	Linear Meter
600.13.006		RUBBER USED AT THE BOTTOM FOR THE HINGED DOOR SERIES (*USE MASTIC WHILE FIXING)	Linear Meter
600.13.008		RUBBER USED WITH SASH	Linear Meter
600.13.010		RUBBER USED WITH SASH	Linear Meter
600.13.009		RUBBER USED FOR SWING DOORS TO PREVENT ALUM. TO ALUM. CONTACT	Linear Meter
4 MM BRUSH		BRUSH USED WITH SWING DOOR	Linear Meter

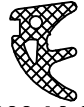




600.13.001  
(SG 1904)

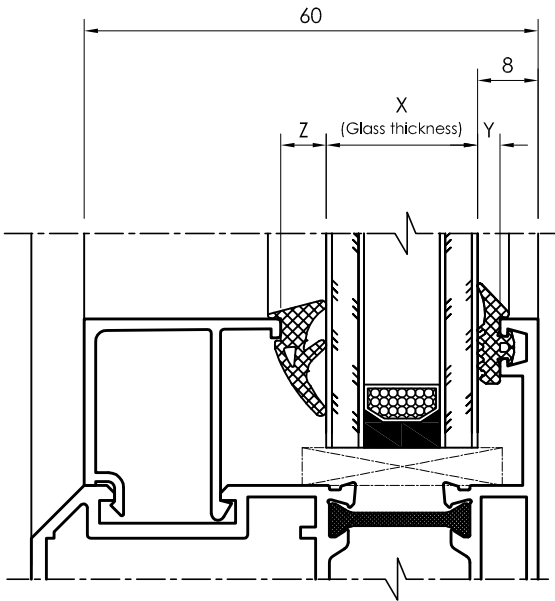









600.13.002  
(SG 2244)







600.13.003  
(SG 2243)


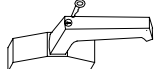




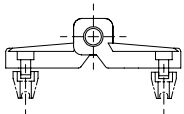

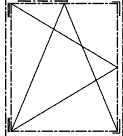
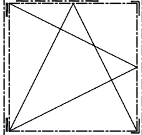
GLAZING BEAD & COMBINATION OF RUBBERS TO BE USED AT THE FRONT & BACK AGAINST VARIOUS GLASS THICKNESS.

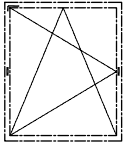
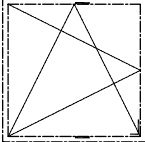
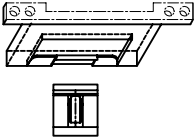
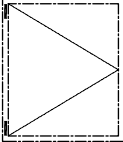
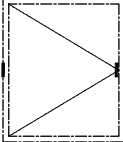
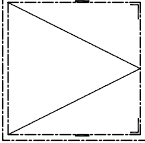
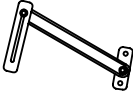
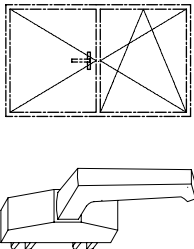


GLASS THICK	GLAZING BEAD TO BE USED	RUBBER AY 'Y' (FRONT RUBBER)	RUBBER AY 'Z' (BACK RUBBER)
18 mm	10371 	600-13-001	600-13-003
20 mm 22 mm	10371 	600-13-001	600-13-002
24 mm	10372 	600-13-001	600-13-003
28 mm	10372 	600-13-001	600-13-002
32 mm	10377 	600-13-001	600-13-002
35 mm	10464 	600-13-001	600-13-003
38 mm	11321 	600-13-001	600-13-003

STANDARD PROFILES FOR THERMAL BREAK

SL. No.	SUPPLIER CODE	MAIN DIMENSIONS IN MM.				SUPPLIER
						
1	912000	16	4.2	1.8	-	TECHNOFORM BAUTEC
2	912800	18.6	4.2	1.8	-	TECHNOFORM BAUTEC
3	A9028	16	4.2	1.8	15	ALFA MID

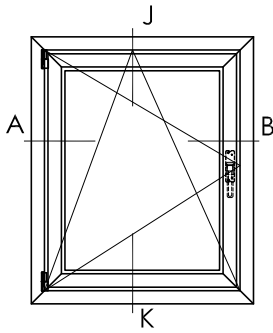
Hardware Reference	Section	Description	Finish
600.16.020		NORMAL HANDLE NO. 26	NATURAL COATED = STANDARD DARKBRONZE COATED=STANDARD WHITE COATED = STANDARD
600.16.021		HANDLE NO. 26 WITH LOCK	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.022		HANDLE NO. 26 (ROUND)	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.023		HANDLE NO. 26 (ROUND) WITH LOCK	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.024		GEAR NO.26	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.025		HANDLE FOR GEAR	NATURAL ANODIZED
600.16.026		HINGES	
600.16.027		MIDDLE FASTENING - UPRIGHT FOR SIDE HUNG	
600.16.030		STANDARD HARDWARE - WITHOUT HANDLE FOR TURN + TILT WINDOW STAY ARM 340 OR 500	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.031		STANDARD HARDWARE - WITHOUT HANDLE FOR TURN + TILT WINDOW STAY ARM 1000	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED

Hardware Reference	Section	Description	Finish
600.16.032		MIDDLE FASTENING - UPRIGHT FOR TURN + TILT WINDOW	
600.16.033		MIDDLE FASTENING - HORIZONTAL INCLUDING SECOND STAY ARM WITH Z PROFILE FOR TURN + TILT + AXER 500	
600.16.034		SAFETY LOCK NO.26	
600.16.040		STANDARD HARDWARE (WITHOUT HANDLE) SIDE HUNG	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.041		MIDDLE FASTENING - UPRIGHT FOR SIDE HUNG	WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED
600.16.042		MIDDLE FASTENING - HORIZONTAL FOR SIDE HUNG	
600.16.045		TILT STAY ARM	
600.16.050		HARDWARE FOR DOUBLE SASHES INCLUDING STRADDLE HANDLE	NATURAL COATED = STANDARD DARKBRONZE COATED = STANDARD WHITE COATED = STANDARD NATURAL ANODIZED DARKBRONZE ANODIZED

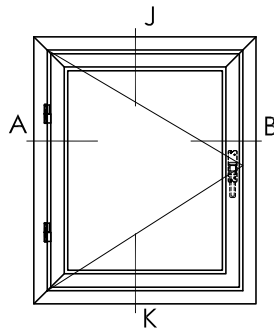


# ASSEMBLY DRAWINGS

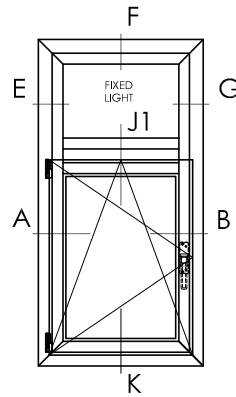
Casement Window Series 600



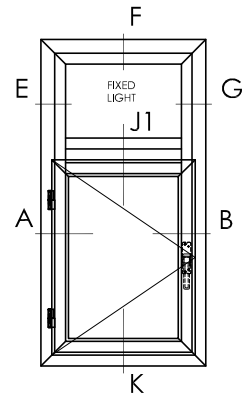
SINGLE LEAF  
TURN & TILT WINDOW  
( INWARD OPENING )



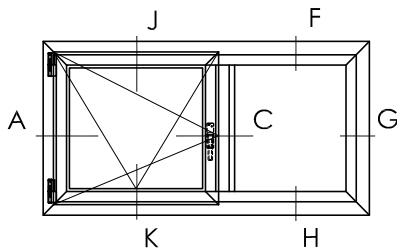
SINGLE LEAF  
CASEMENT WINDOW  
( INWARD OPENING )



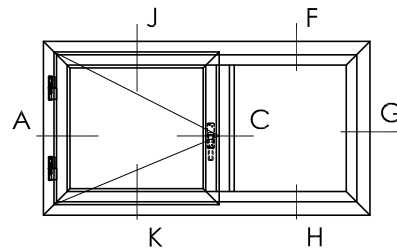
SINGLE LEAF  
TURN & TILT WINDOW  
WITH TOP FIXED PANEL  
( INWARD OPENING )



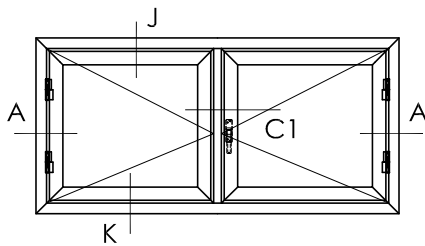
SINGLE LEAF  
CASEMENT WINDOW  
WITH TOP FIXED PANEL  
( INWARD OPENING )



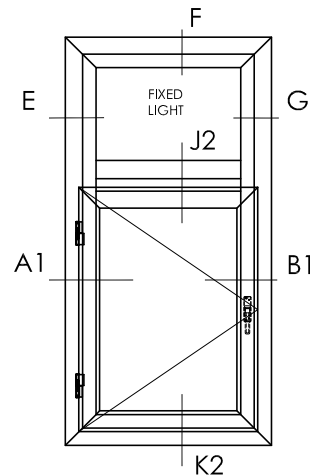
SINGLE LEAF TURN & TILT WINDOW  
WITH SIDE FIXED PANEL  
( INWARD OPENING )



SINGLE LEAF CASEMENT WINDOW  
WITH SIDE FIXED PANEL  
( INWARD OPENING )



DOUBLE LEAF CASEMENT WINDOW  
( INWARD OPENING )

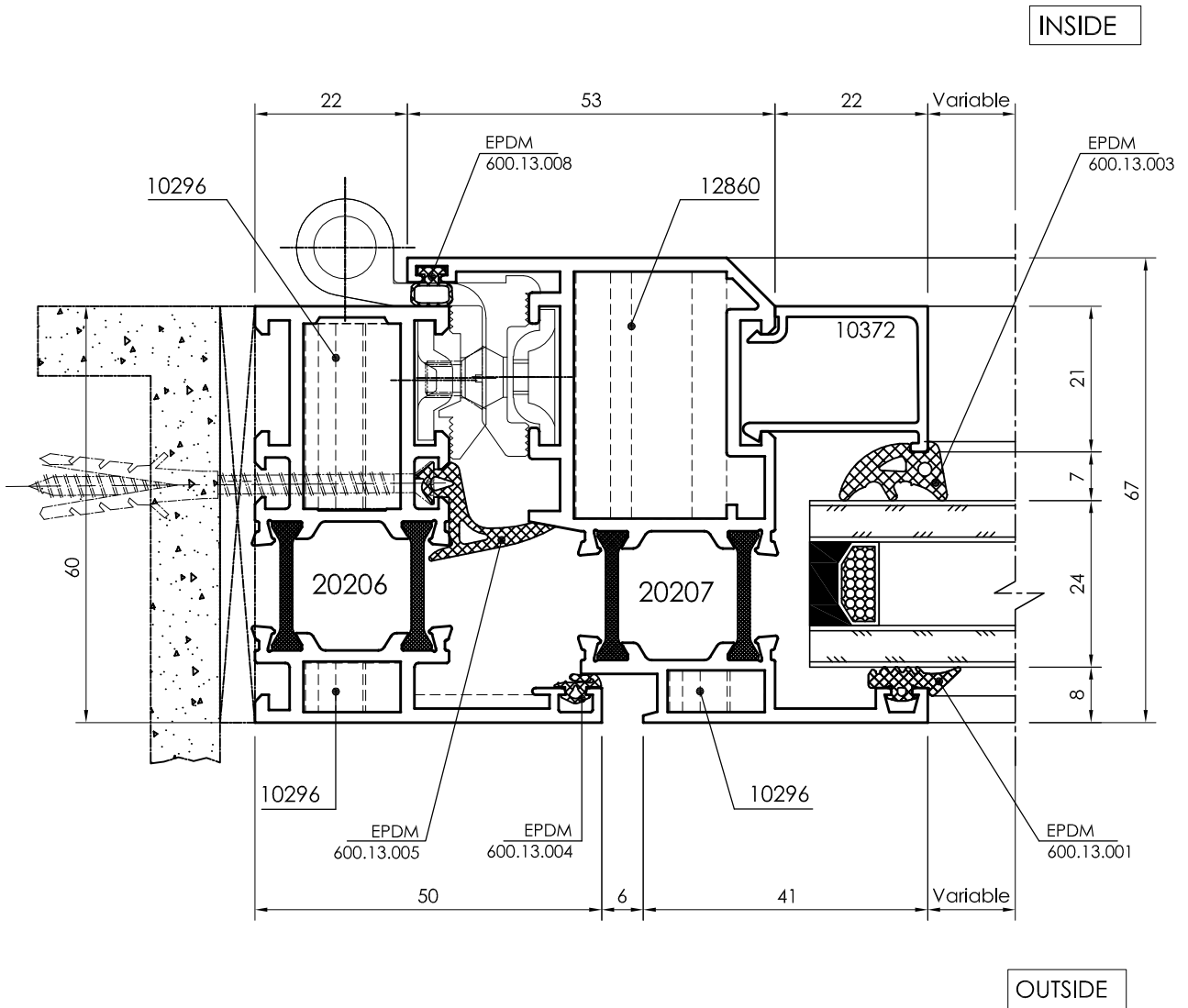


SINGLE LEAF CASEMENT WINDOW  
WITH TOP FIXED PANEL  
( OUTWARD OPENING )

Casement Window Series 600

Detail - A

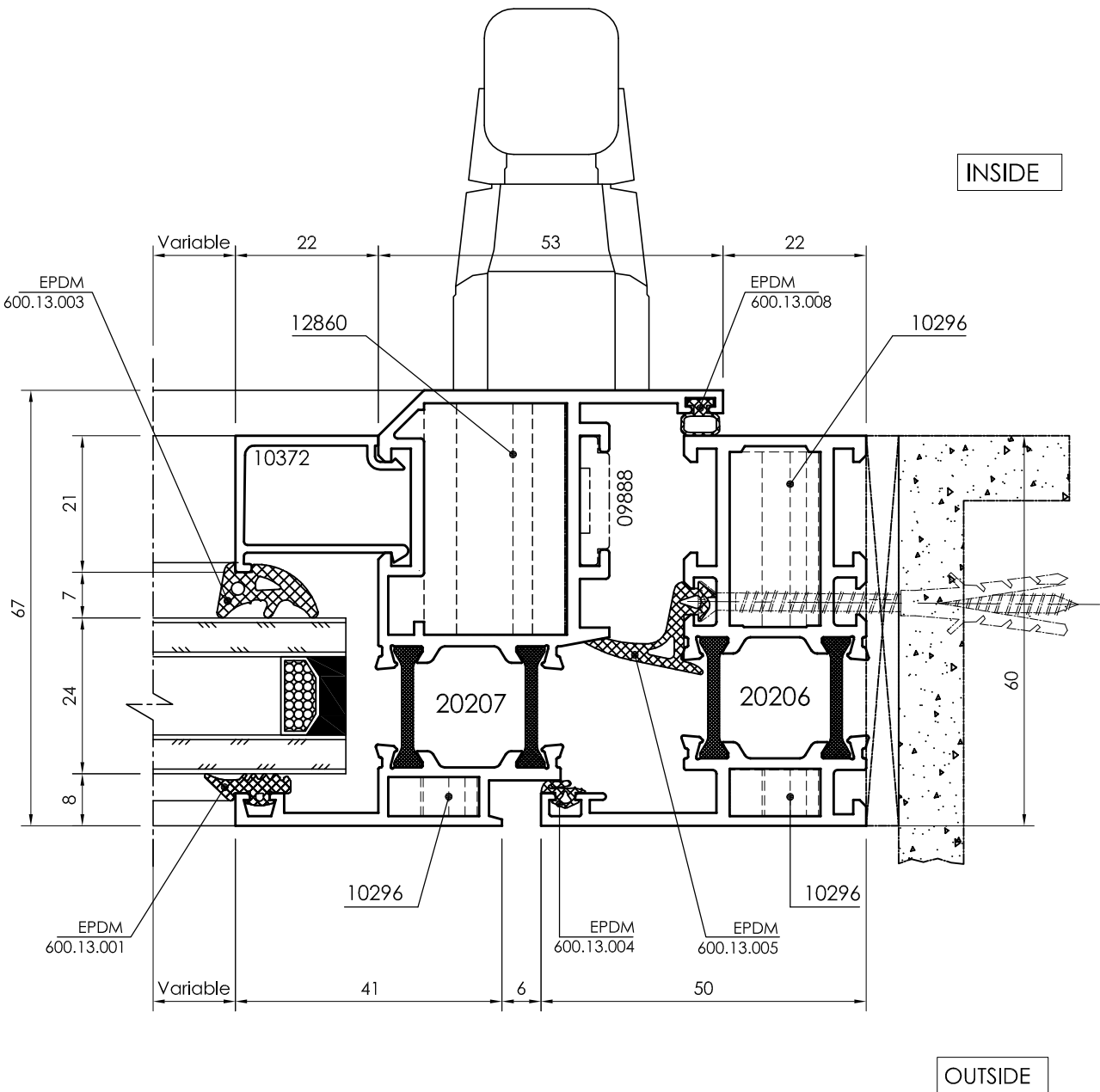
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - B

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

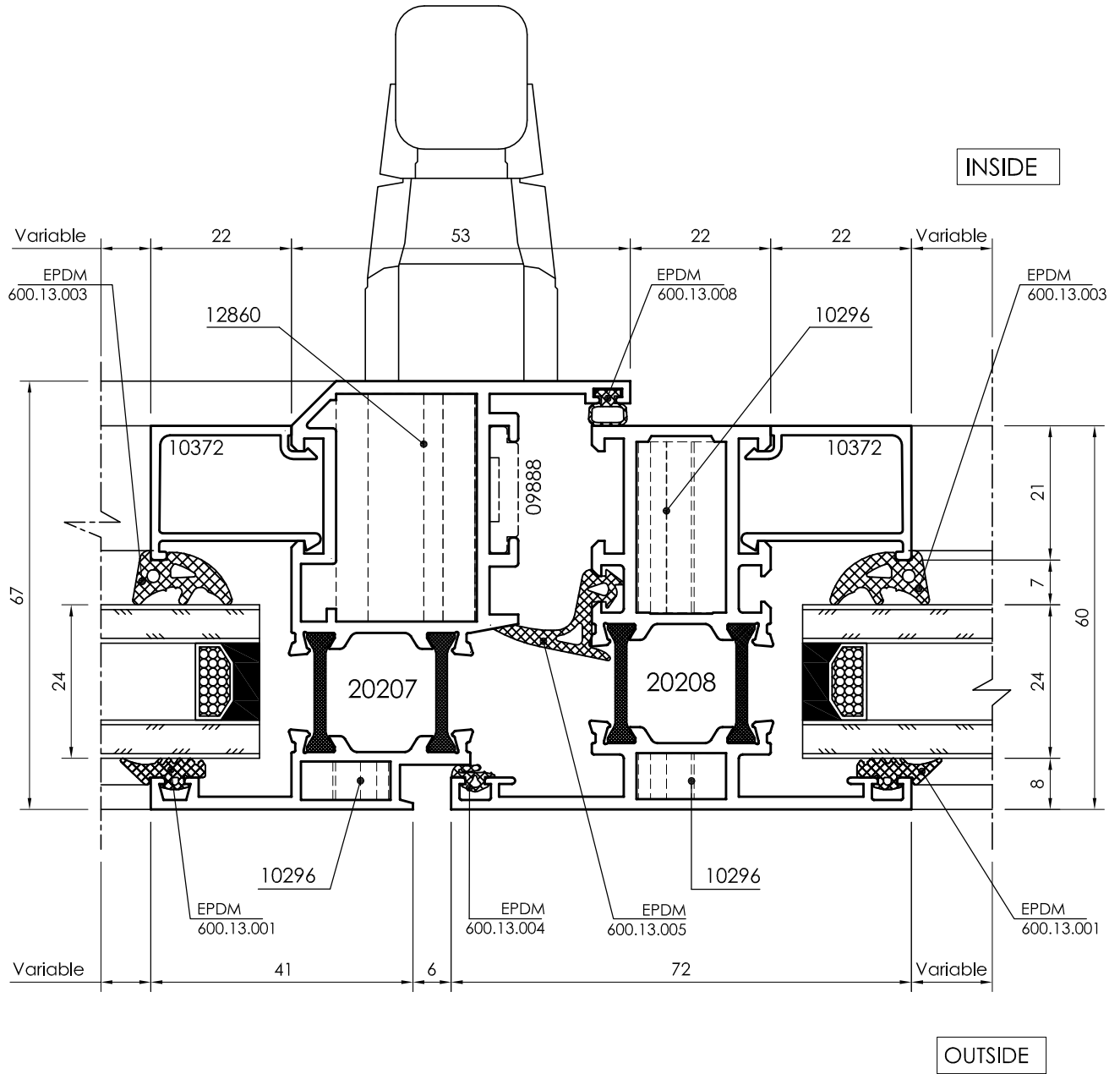




Casement Window Series 600

Detail - C

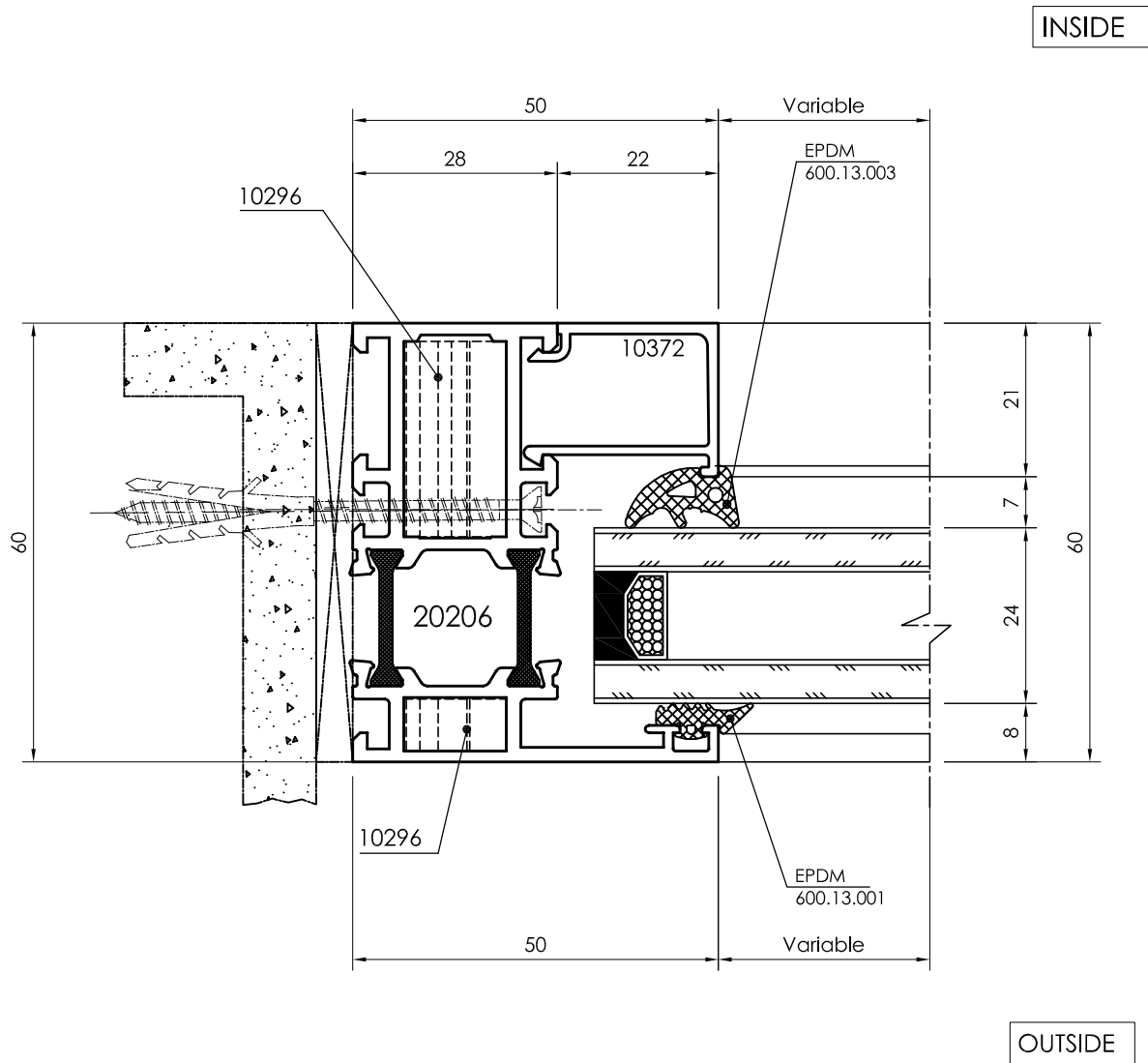
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - E

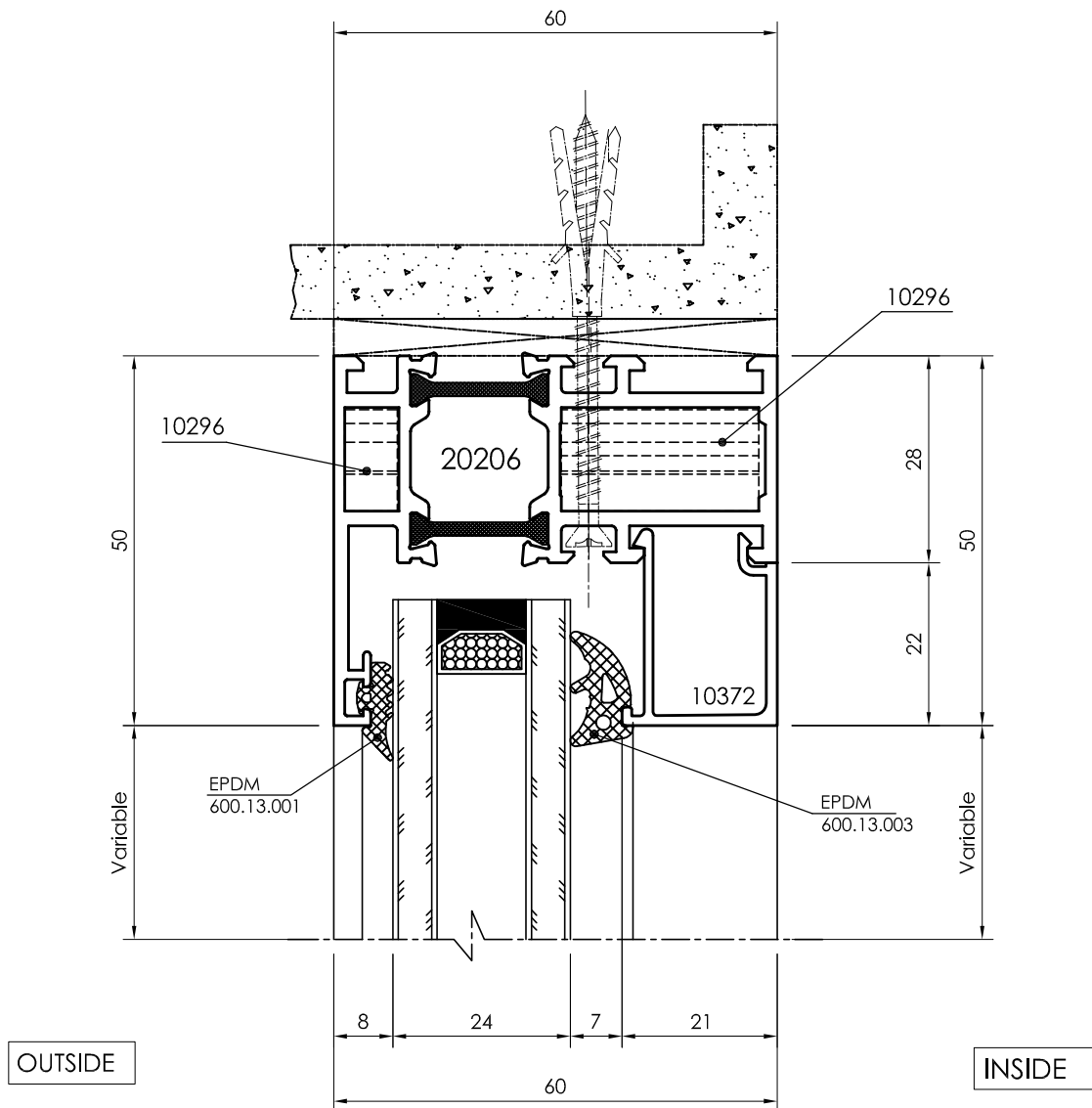
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Casement Window Series 600**

Detail - F

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

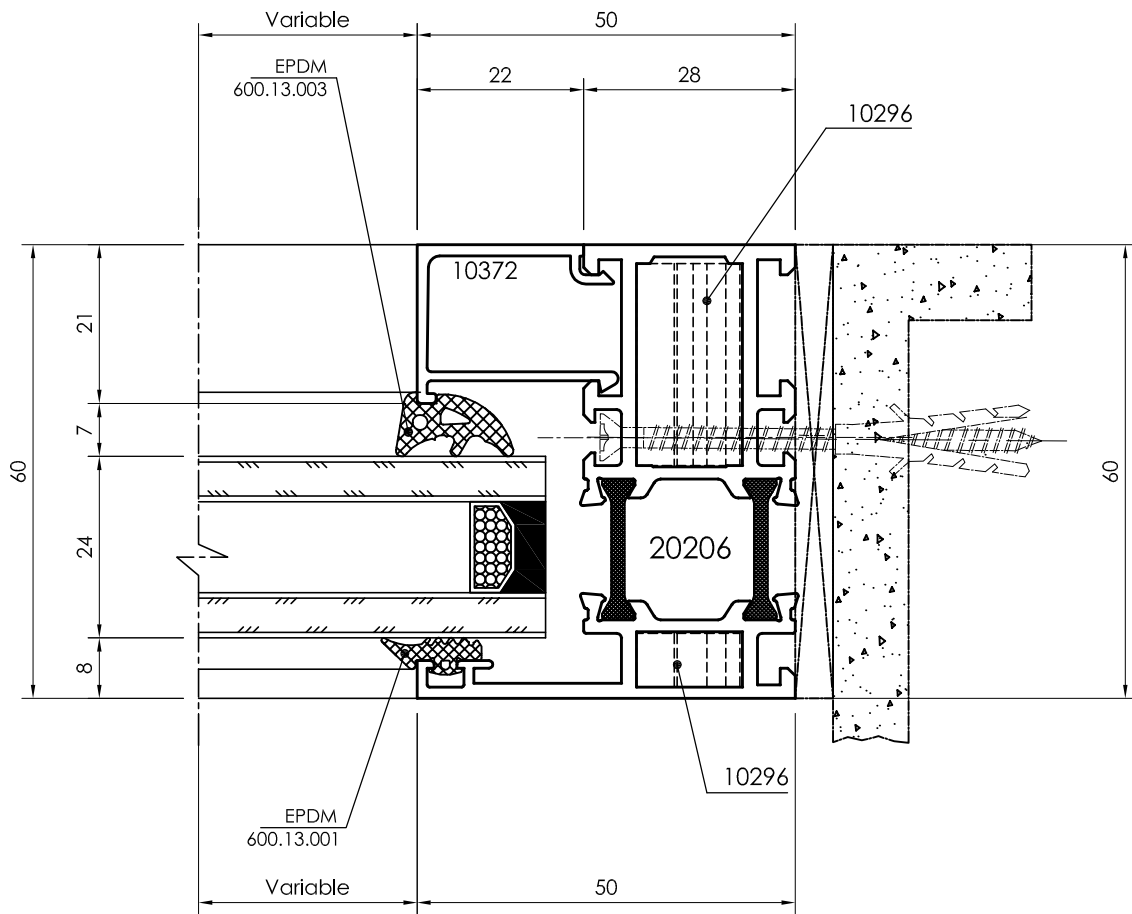


Casement Window Series 600

Detail - G

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

INSIDE

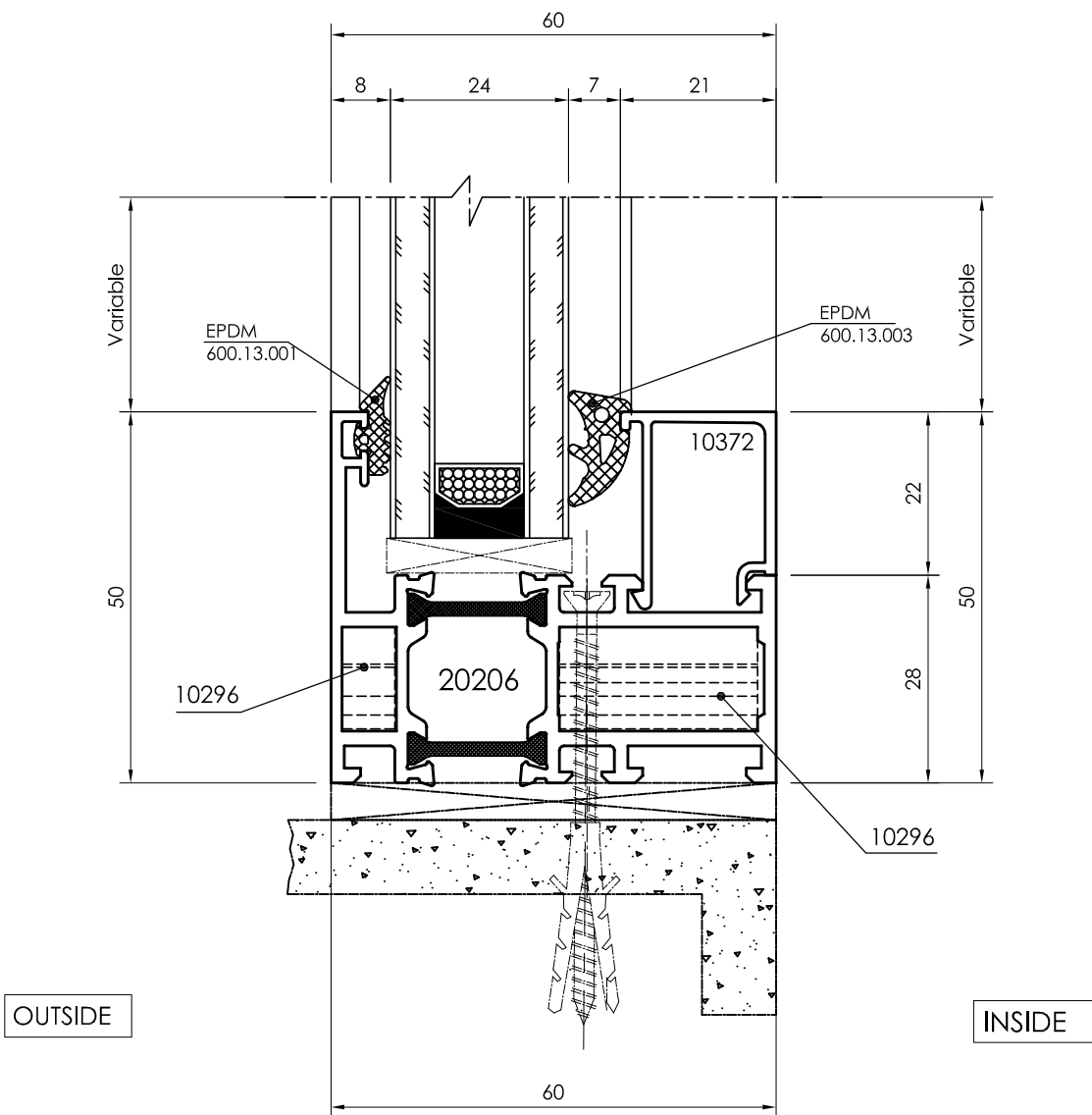


OUTSIDE

Casement Window Series 600

Detail - H

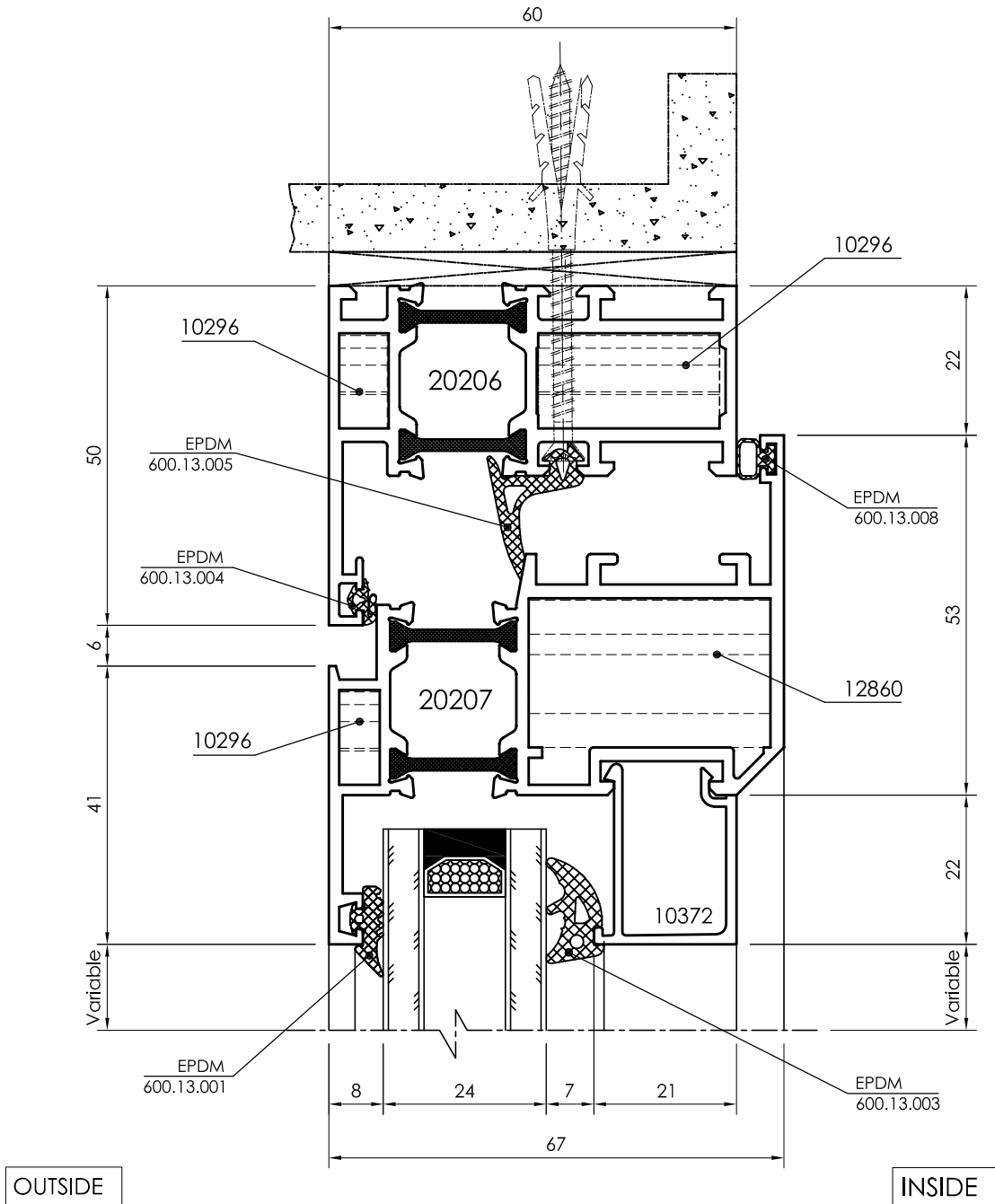
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - J

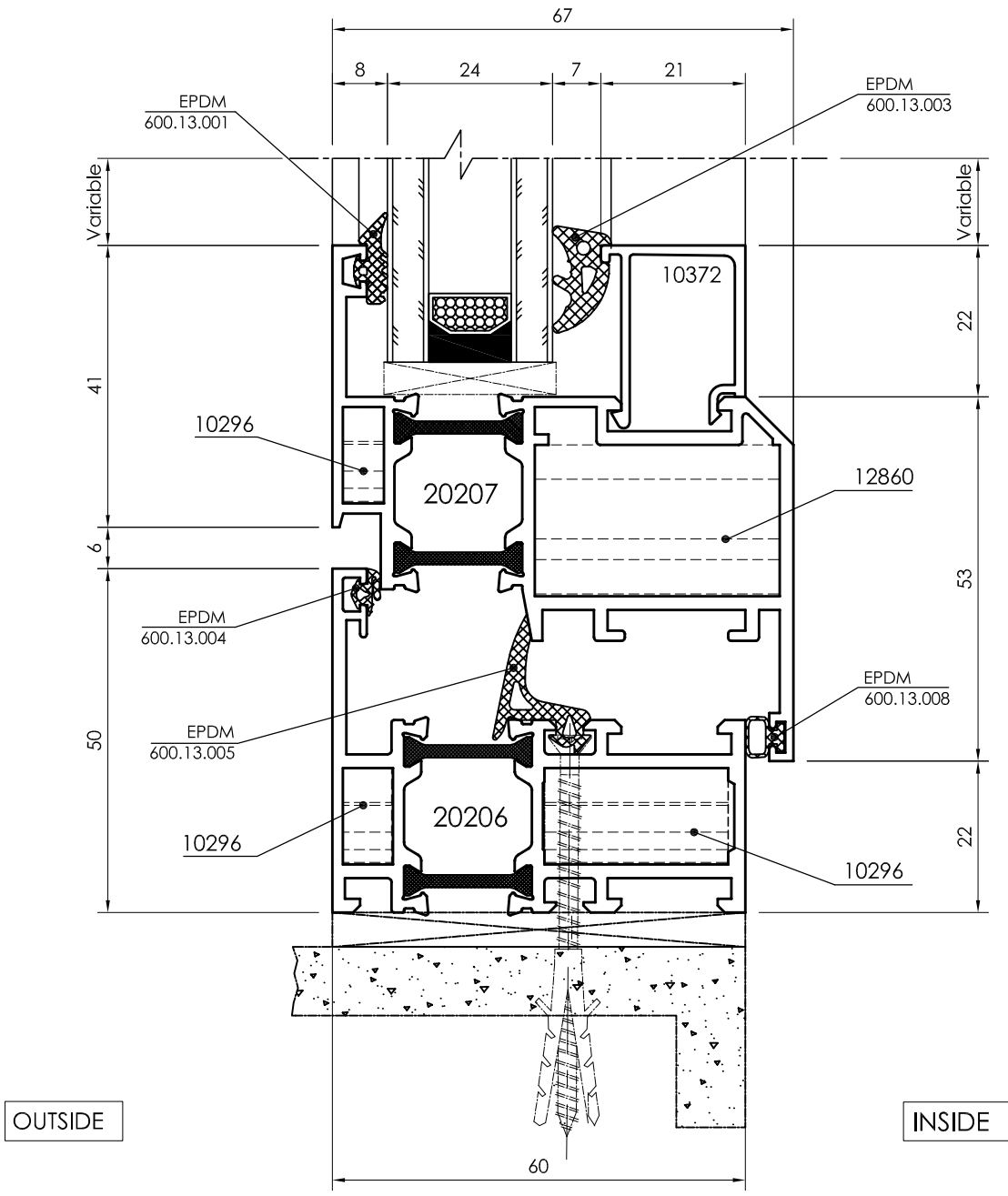
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - K

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

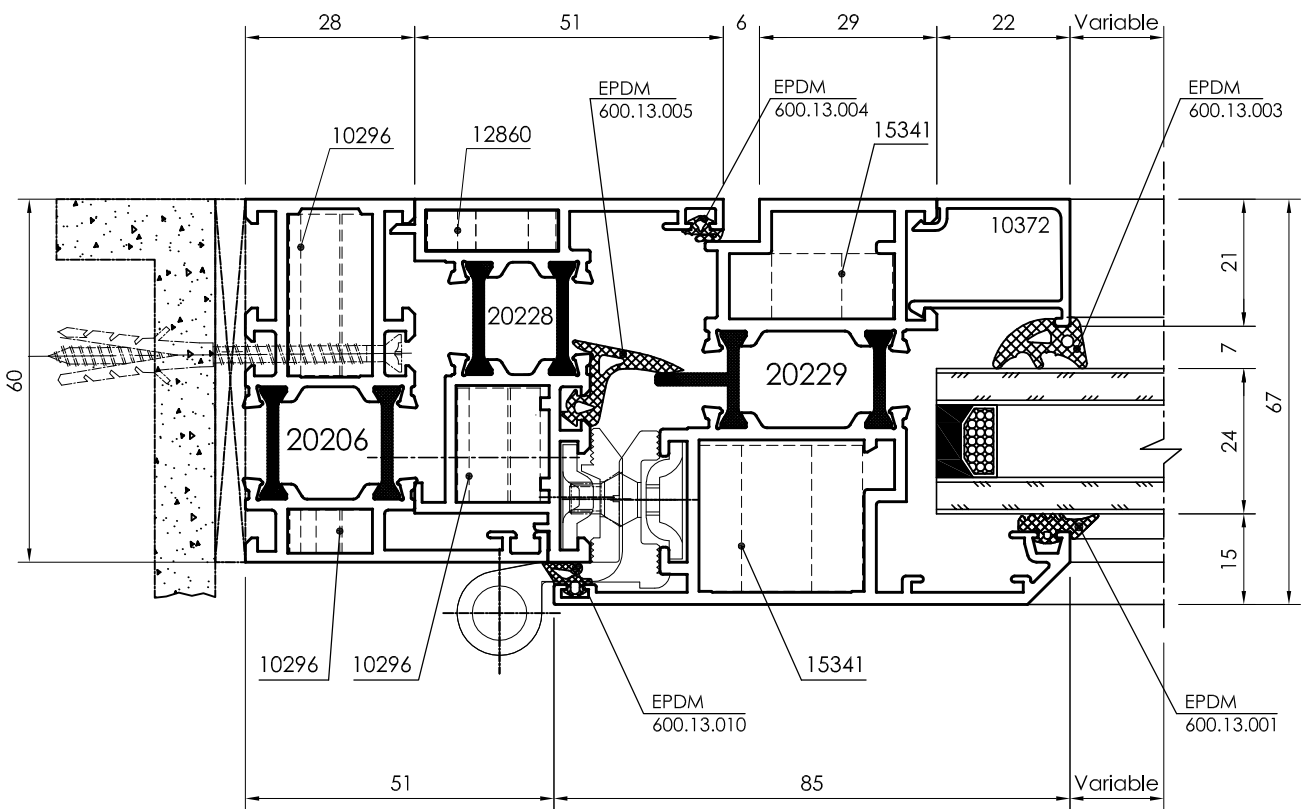


Casement Window Series 600

Detail - A1

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

INSIDE



OUTSIDE

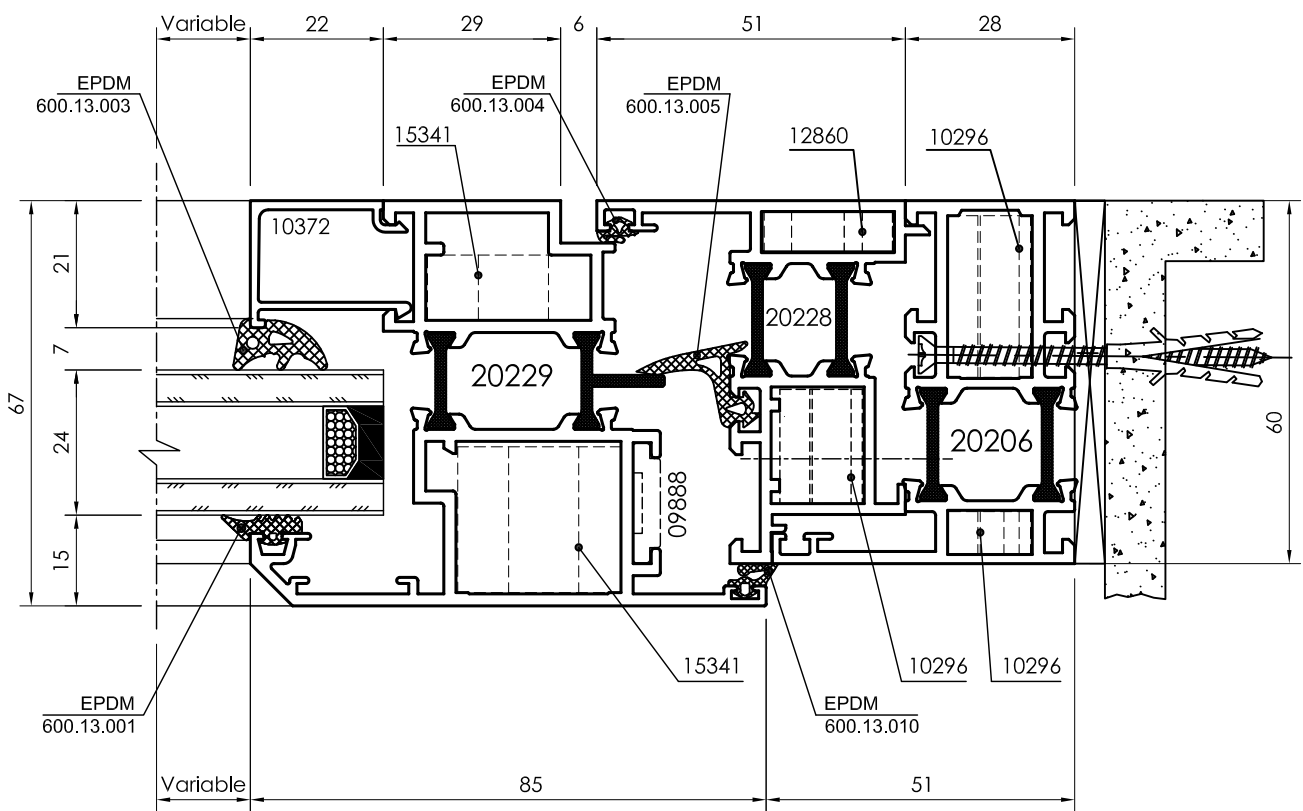


Casement Window Series 600

Detail - B1

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

INSIDE

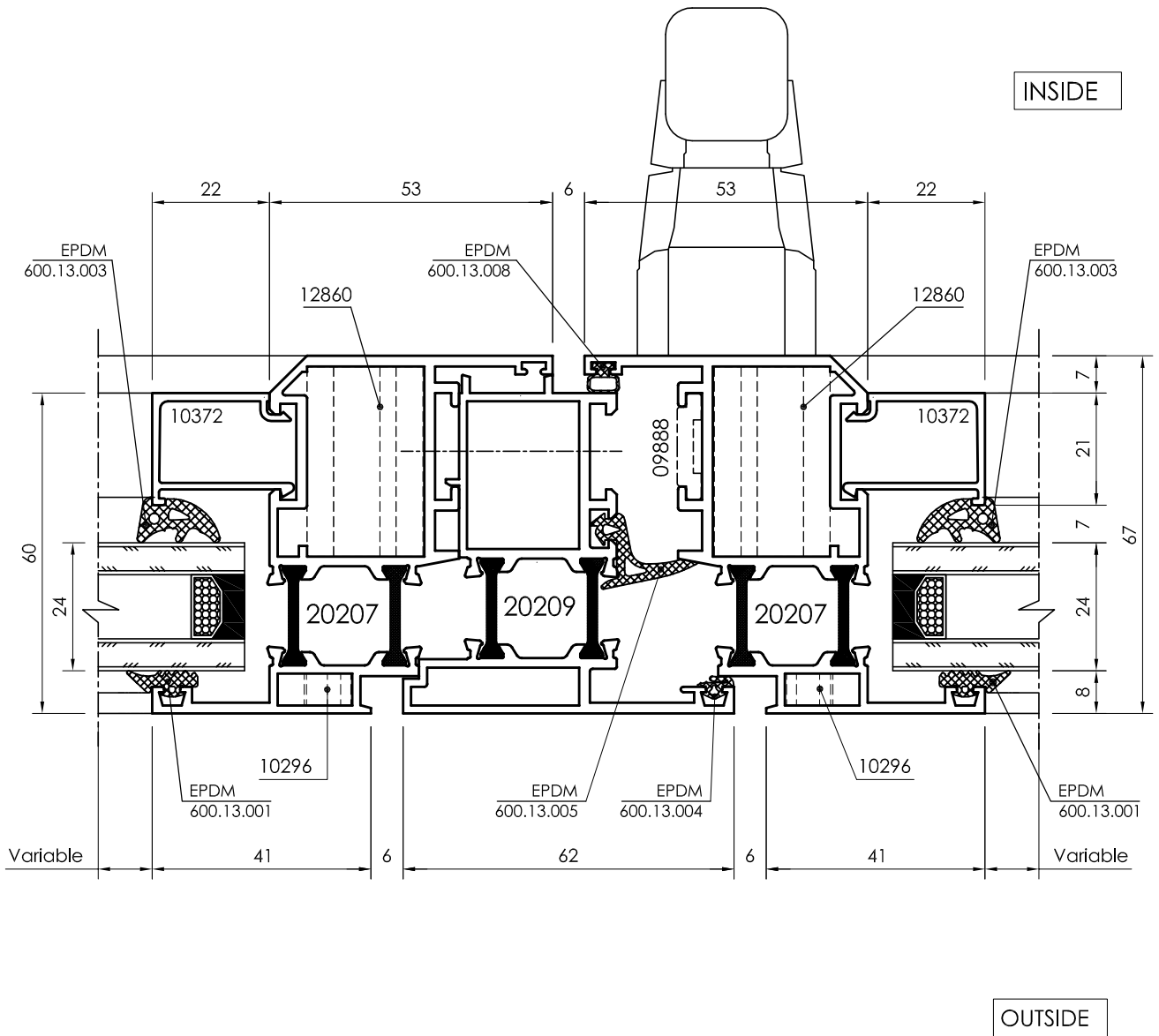


OUTSIDE

Casement Window Series 600

Detail - C1

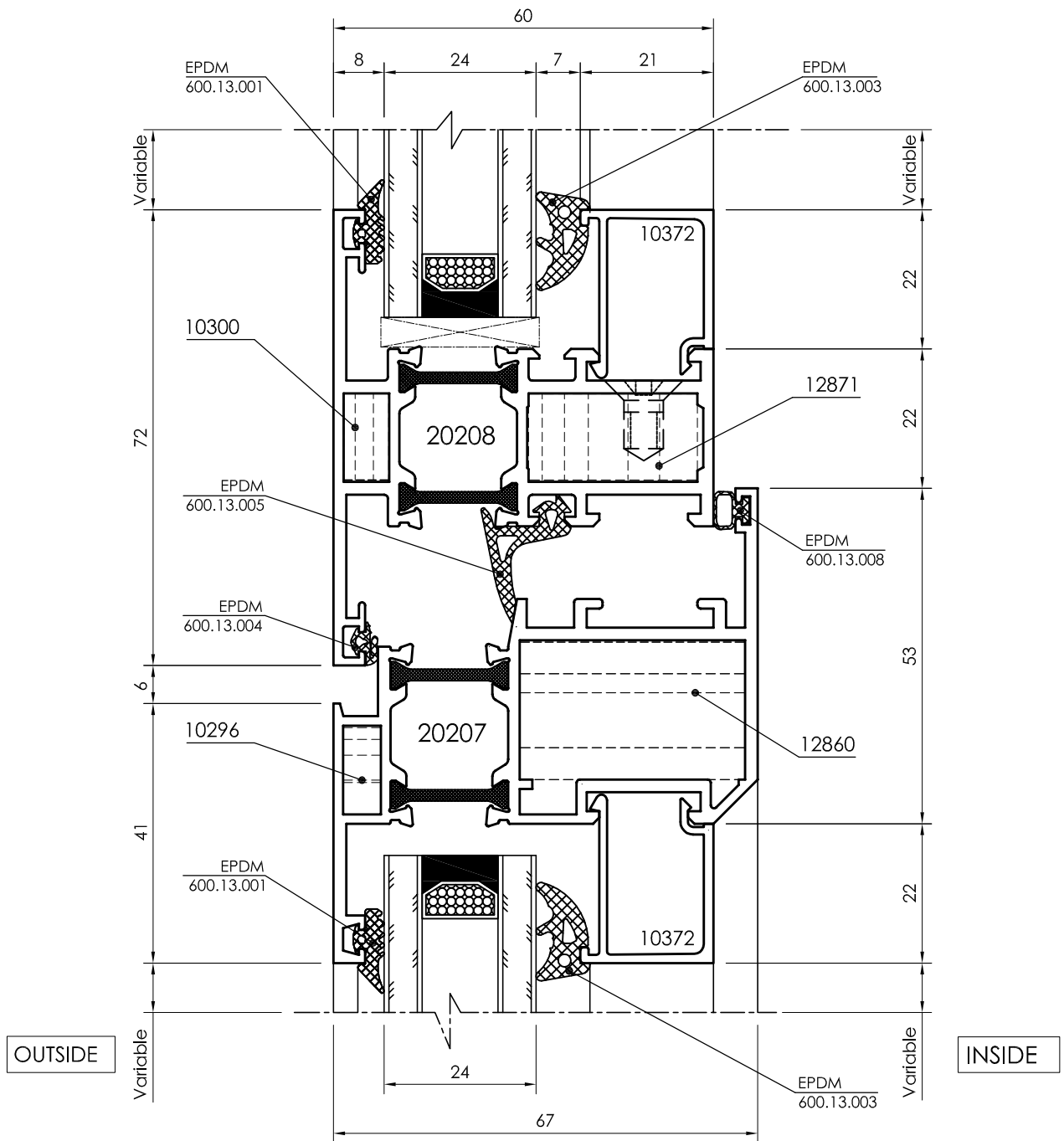
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - J1

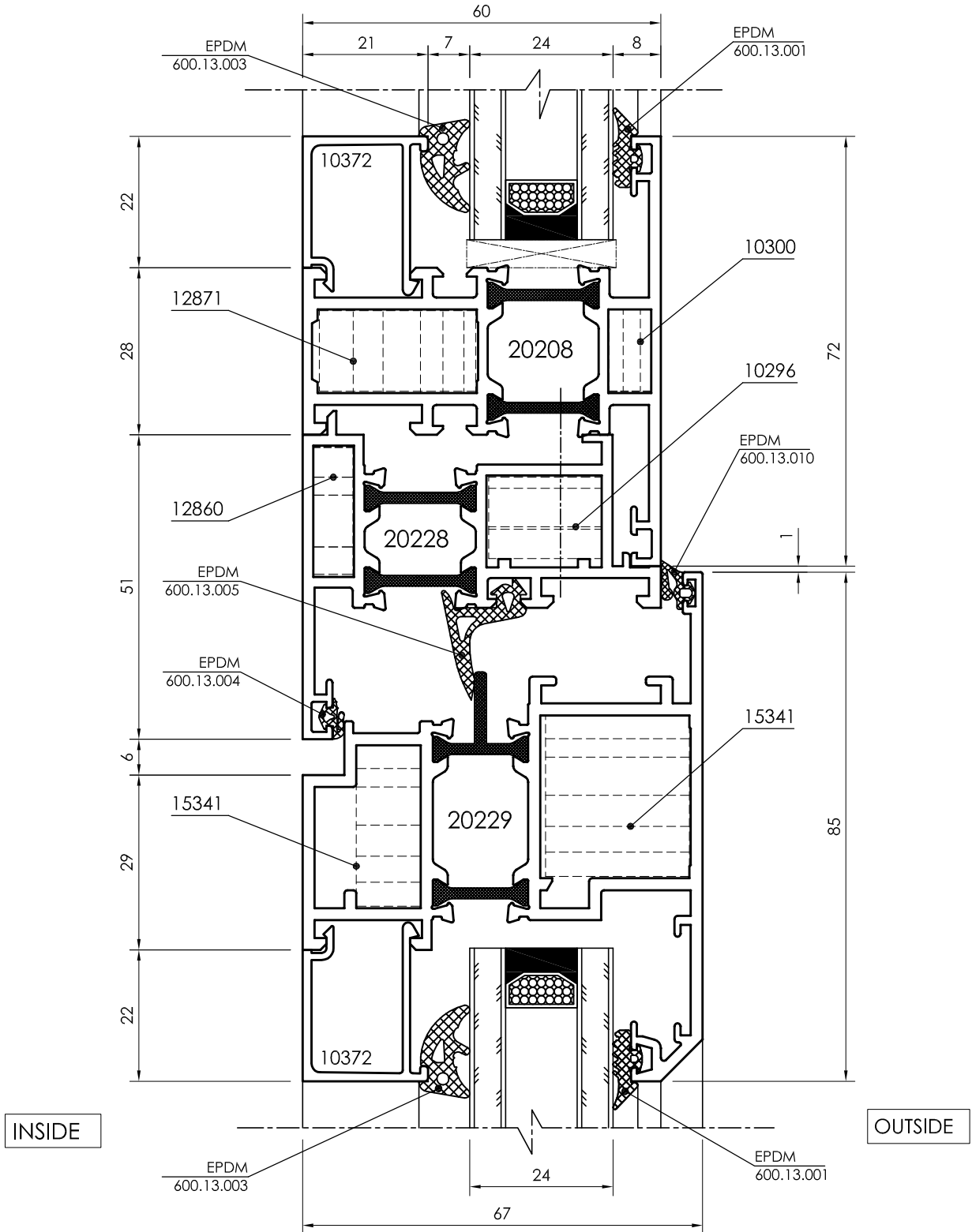
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - J2

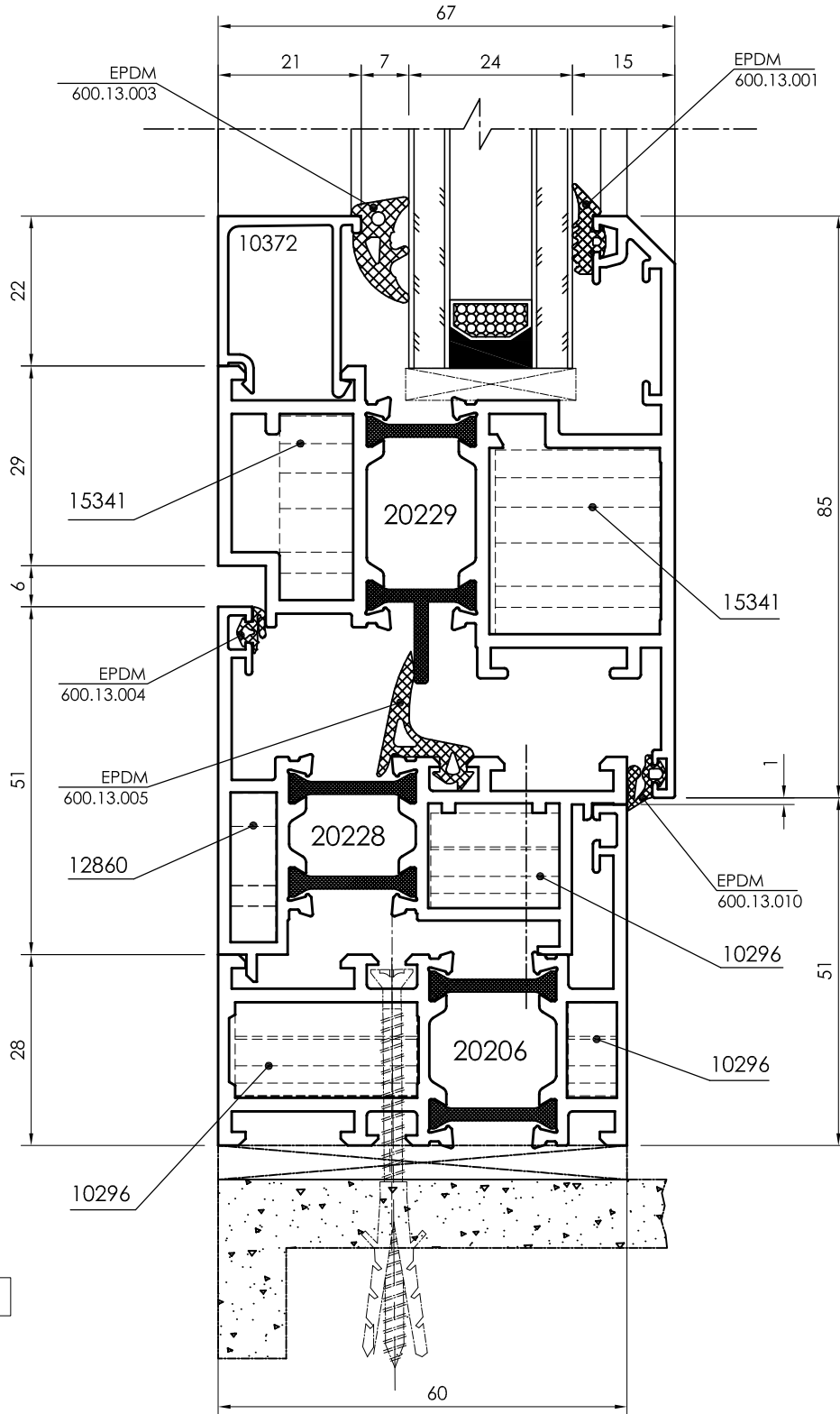
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Casement Window Series 600

Detail - K2

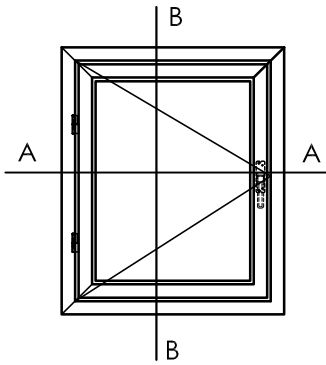
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



INSIDE

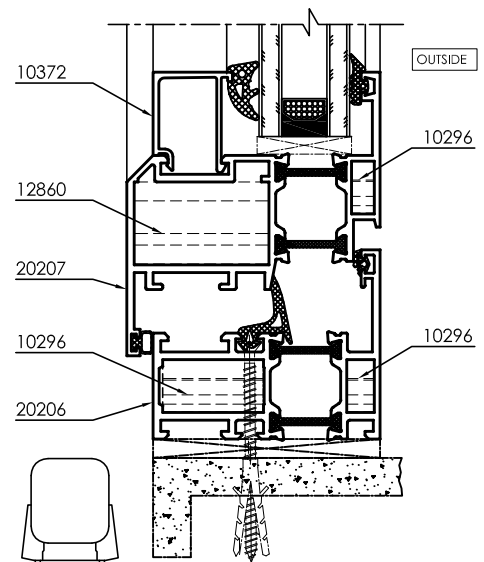
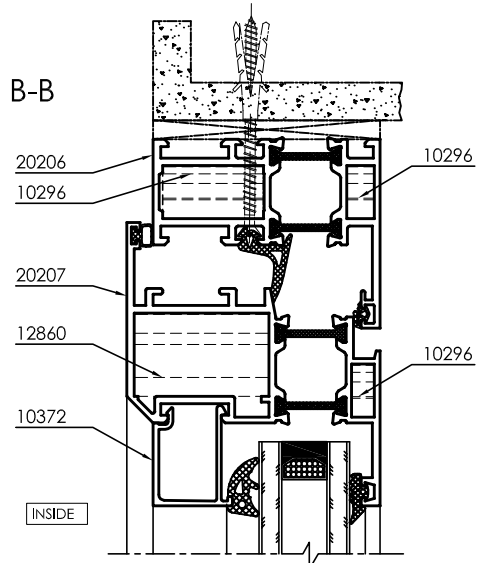
OUTSIDE

Casement Window Series 600



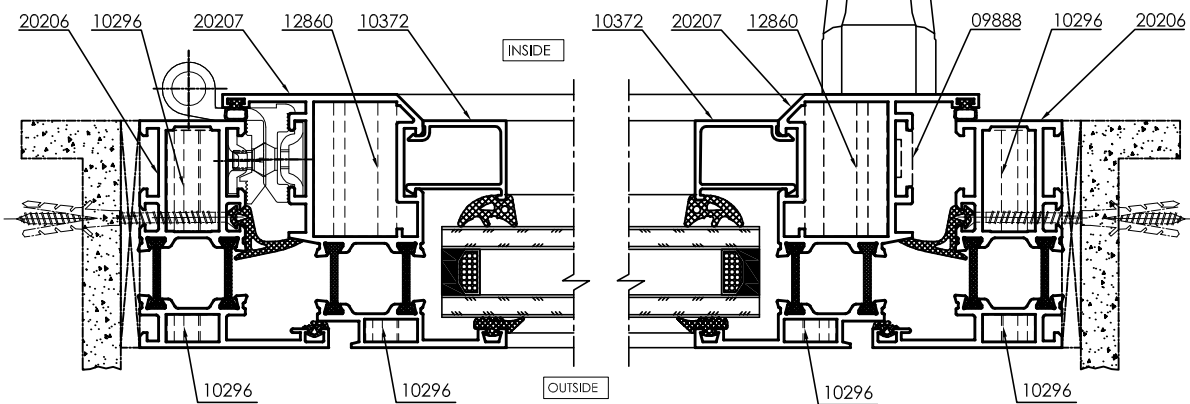
SINGLE LEAF CASEMENT WINDOW  
(INWARD OPENING.)

DETAIL : B-B

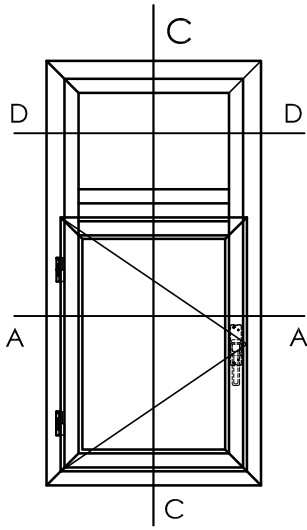


Profiles		
Description	Shape	Section No.
Frame		20206
Sash		20207
Glazing bead		10372
Corner cleat		10296
Corner cleat		12860
Locking profile		09888

DETAIL : A-A



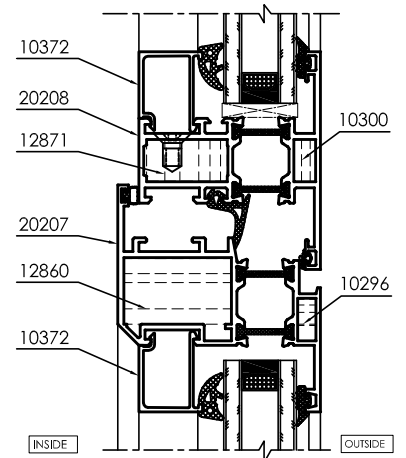
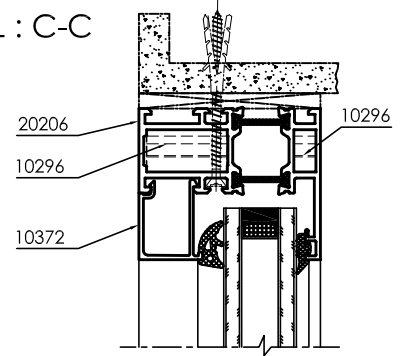
Casement Window Series 600



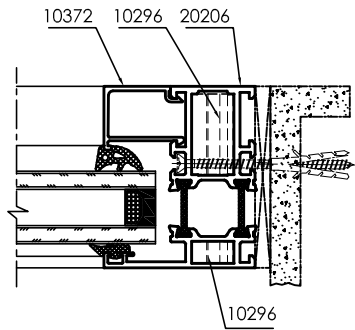
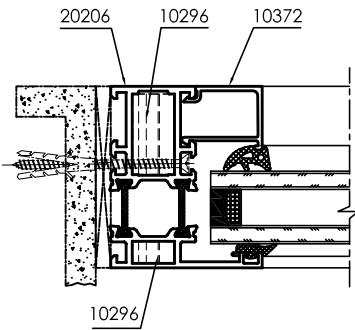
SINGLE LEAF CASEMENT WINDOW  
WITH TOP FIXED PANEL  
(INWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20206
Sash		20207
T - profile		20208
Glazing bead		10372
Corner cleat		10296
Corner cleat		12860
Locking profile		09888
T - Corner profile		12871
T - Corner profile		10300

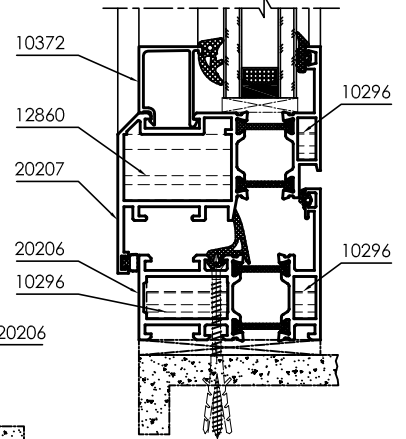
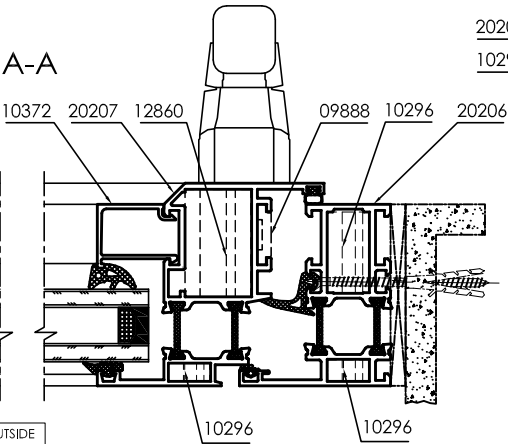
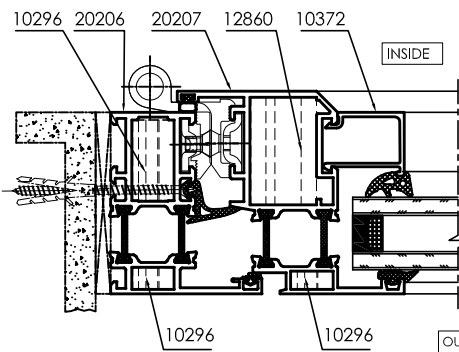
DETAIL : C-C



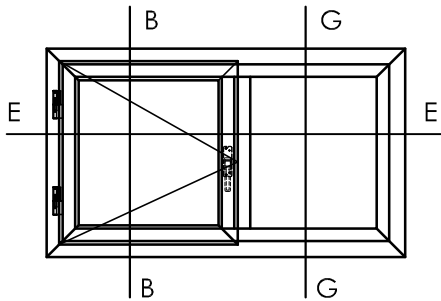
DETAIL : D-D



DETAIL : A-A

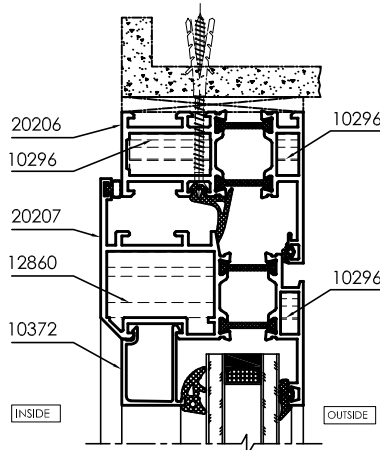


Casement Window Series 600

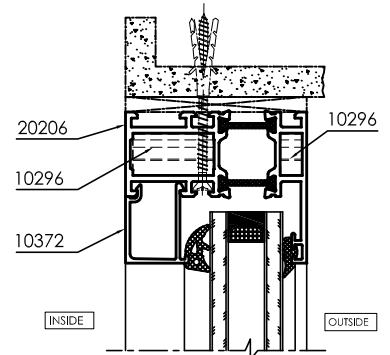


SINGLE LEAF CASEMENT WINDOW  
WITH SIDE FIXED PANEL  
(INWARD OPENING)

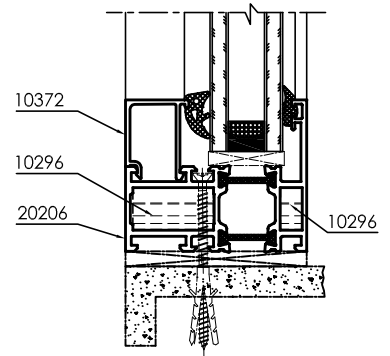
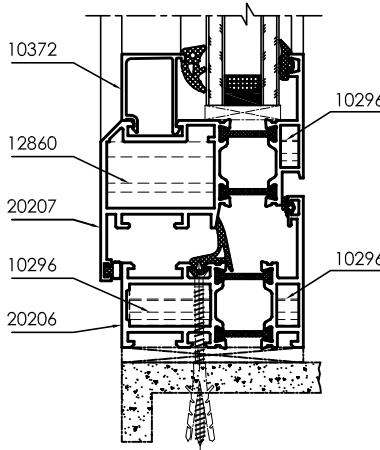
DETAIL : B-B



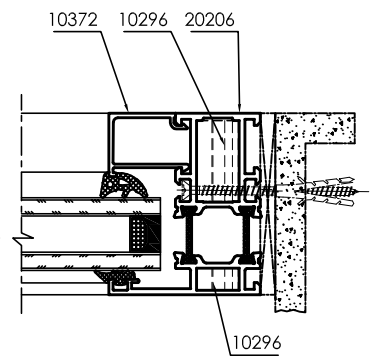
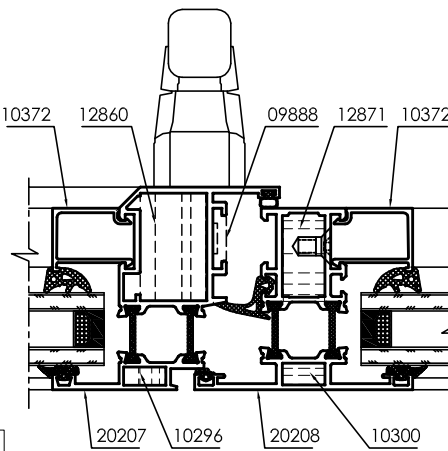
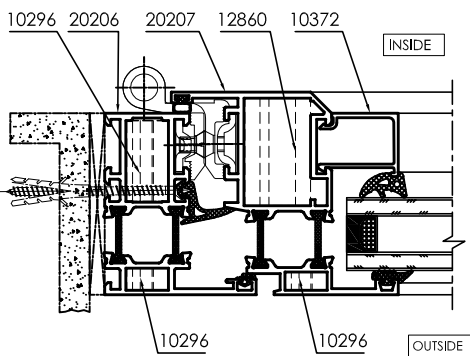
DETAIL : G-G



Profiles		
Description	Shape	Section No.
Frame		20206
Sash		20207
T - profile		20208
Glazing bead		10372
Corner cleat		10296
Corner cleat		12860
Locking profile		09888
T - Corner profile		12871
T - Corner profile		10300

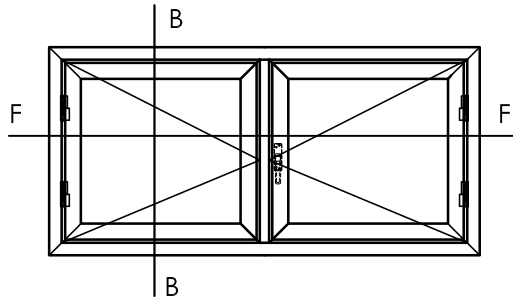


DETAIL : E-E





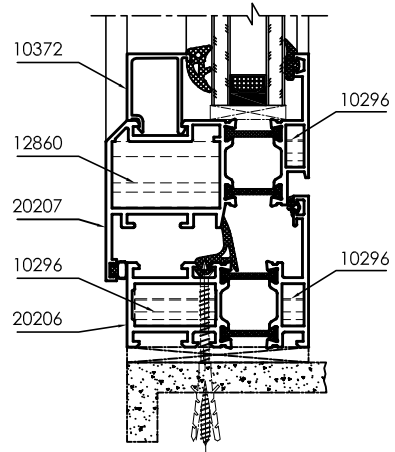
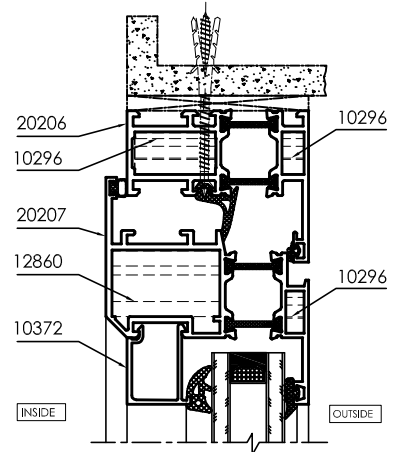
Casement Window Series 600



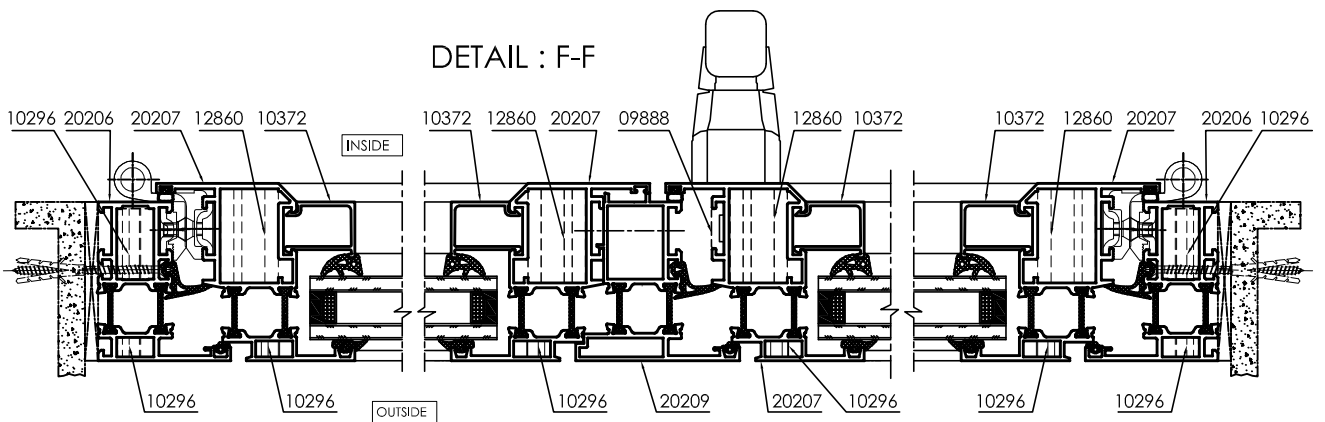
DOUBLE LEAF CASEMENT WINDOW  
(INWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20206
Sash		20207
Adaptor		20209
Glazing bead		10372
Corner cleat		10296
Corner cleat		12860
Locking profile		09888

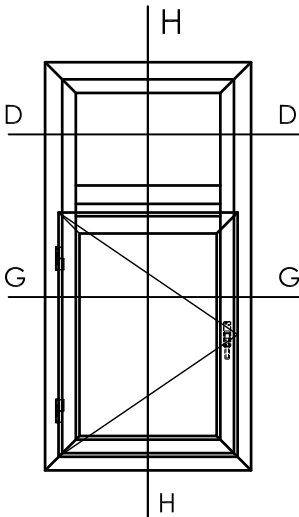
DETAIL : B-B



DETAIL : F-F



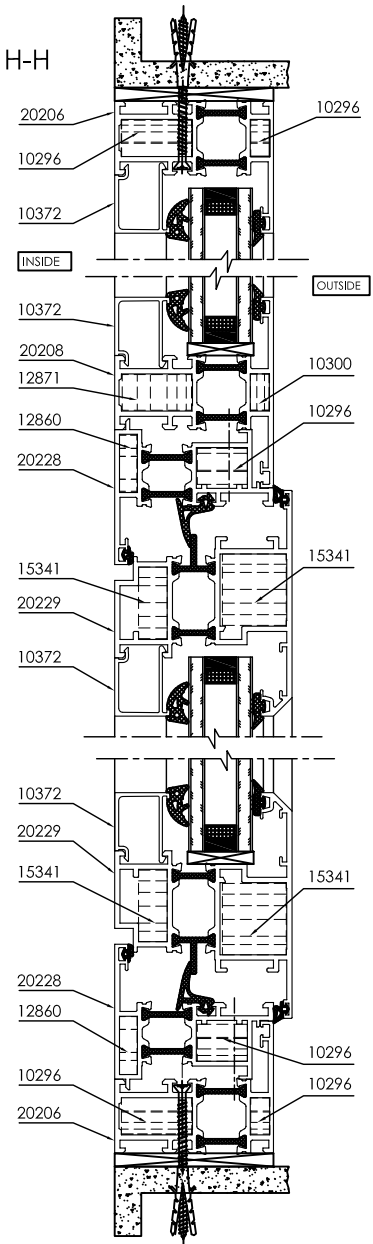
Casement Window Series 600



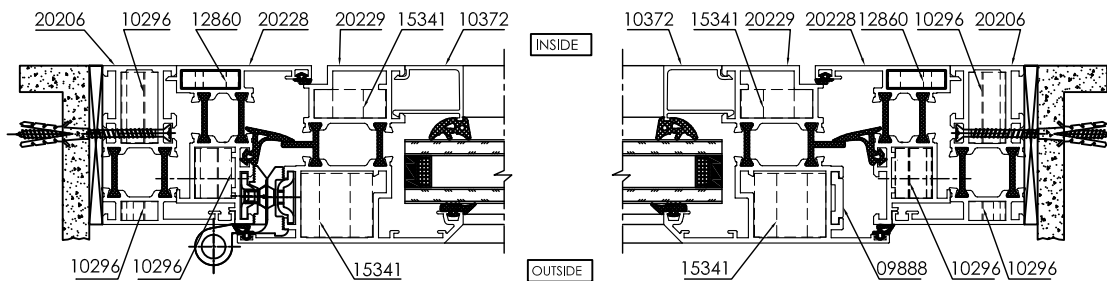
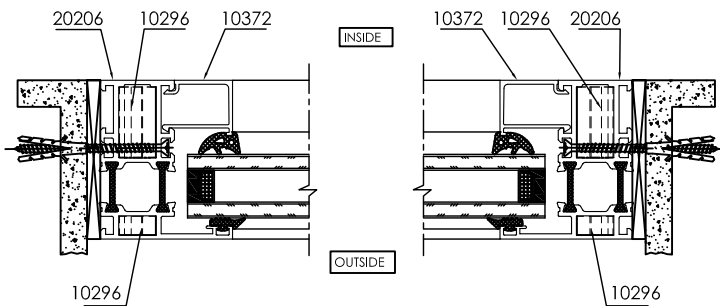
SINGLE LEAF CASEMENT WINDOW  
WITH TOP FIXED PANEL  
(OUTWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20206
Adaptor profile		20228
Sash		20229
T - profile		20208
T - Corner profile		12871
T - Corner profile		10300
Glazing bead		10372
Corner cleat		15341
Corner cleat		10296
Corner cleat		12860
Locking profile		09888

DETAIL : H-H

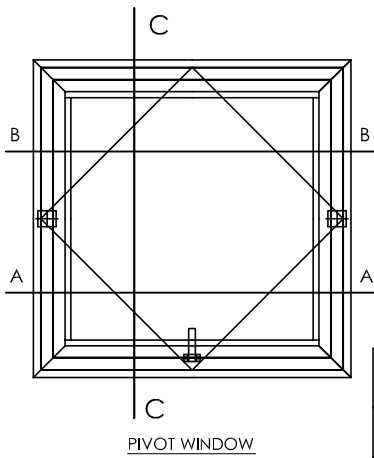


DETAIL : D-D



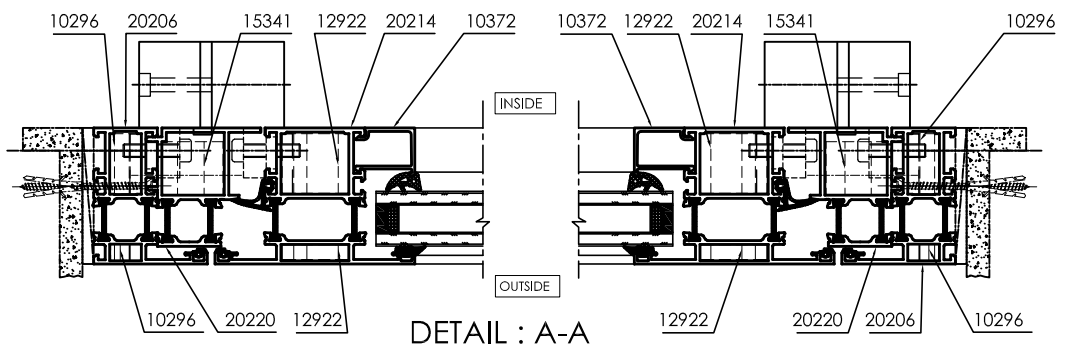
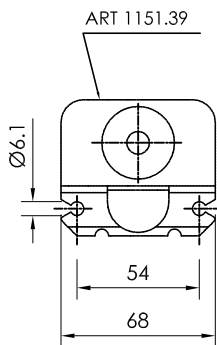
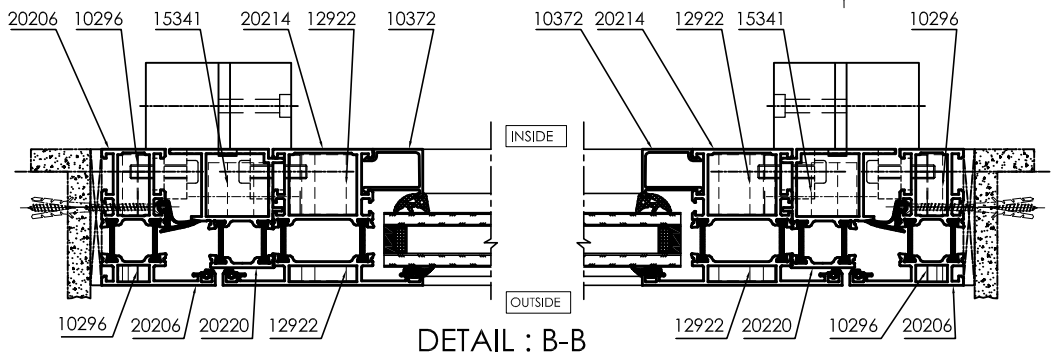
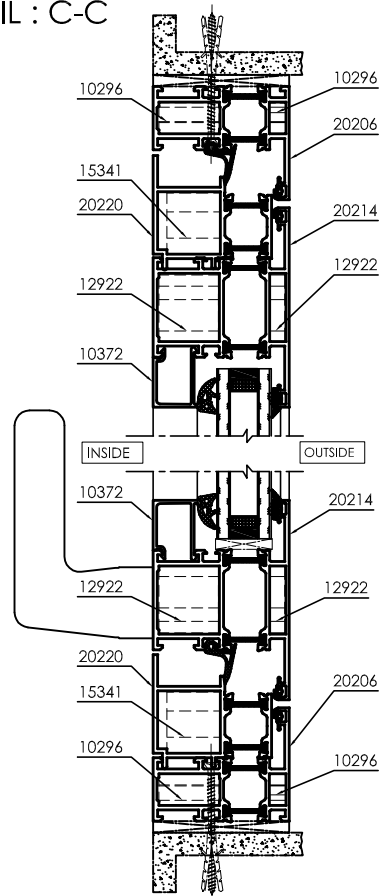
DETAIL : G-G

Casement Window Series 600

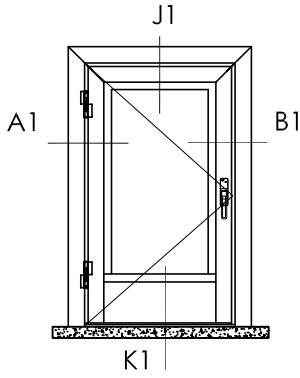


Profiles		
Description	Shape	Section No.
Frame		20206
Adaptor		20220
T - profile		20214
Glazing bead		10372
Corner cleat		10296
Corner cleat		12922
Corner cleat		15341

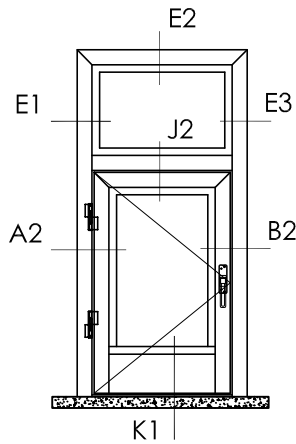
DETAIL : C-C



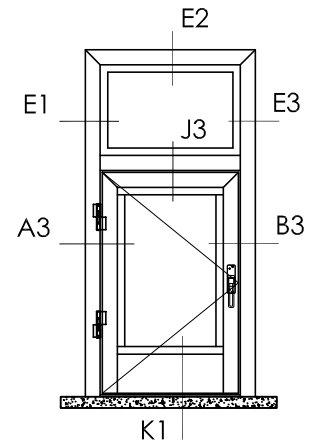
Hinged Door Series 600



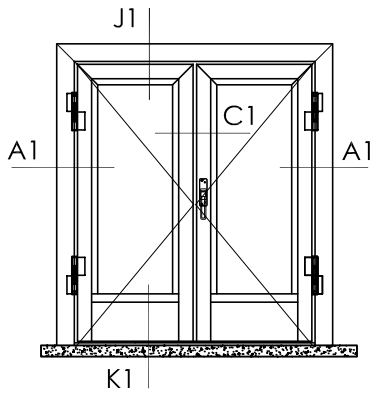
SINGLE LEAF HINGED DOOR  
(INWARD OPENING)



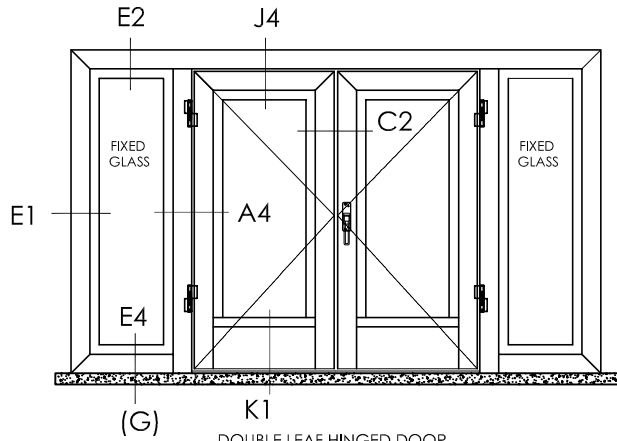
SINGLE LEAF HINGED DOOR  
WITH TOP FIXED PANEL  
(INWARD OPENING)



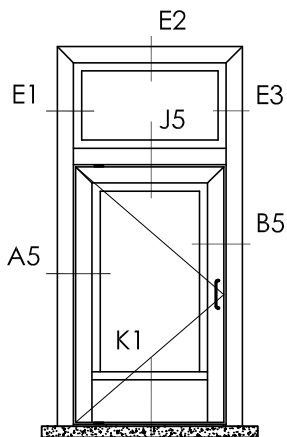
SINGLE LEAF HINGED DOOR  
WITH TOP FIXED PANEL  
(OUTWARD OPENING)



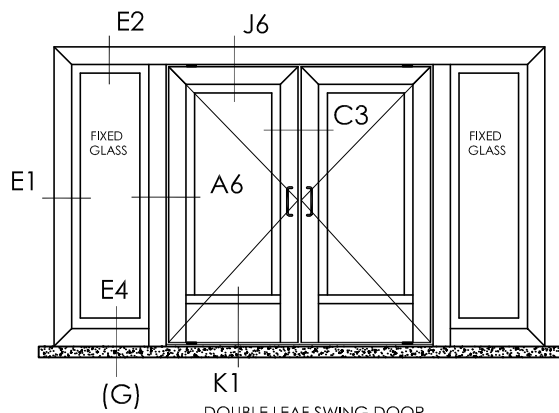
DOUBLE LEAF HINGED DOOR  
(INWARD OPENING)



DOUBLE LEAF HINGED DOOR  
WITH SIDE FIXED PANEL  
(OUTWARD OPENING)



SINGLE LEAF SWING DOOR  
WITH TOP FIXED PANEL

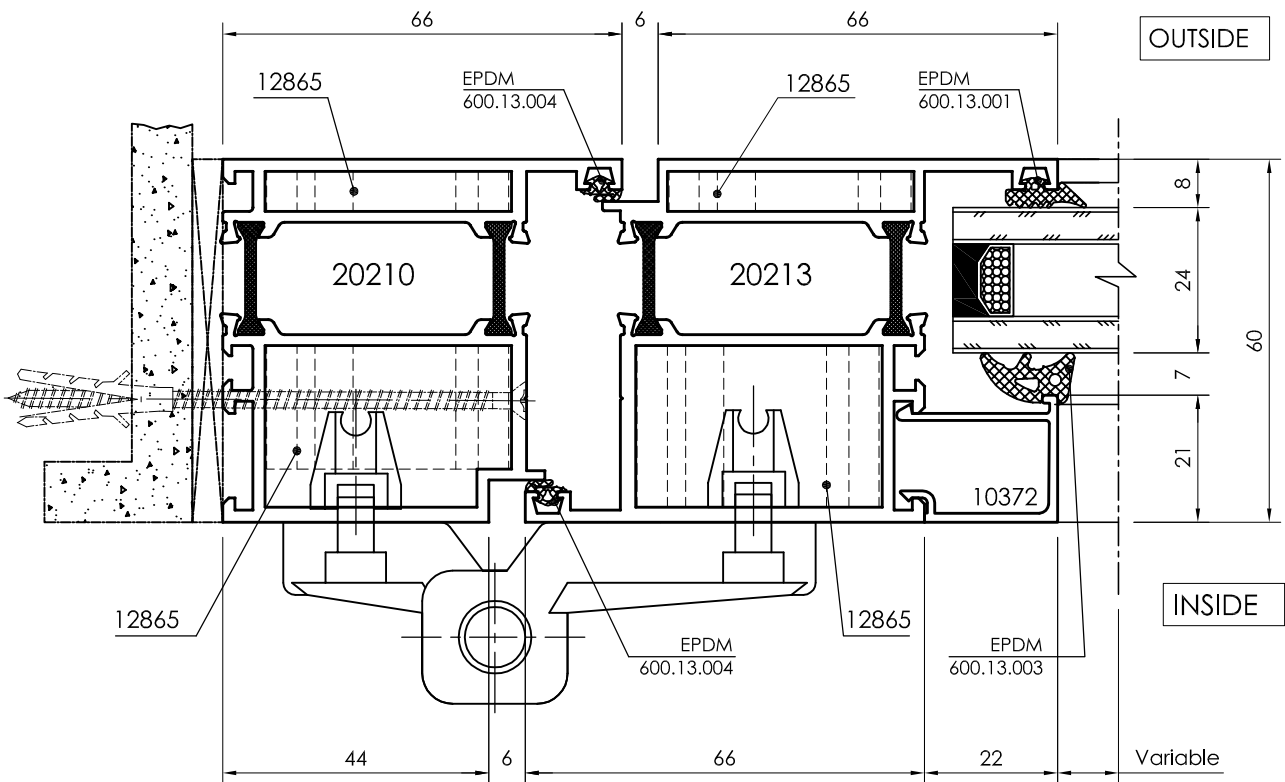


DOUBLE LEAF SWING DOOR  
WITH SIDE FIXED PANEL

Hinged Door Series 600

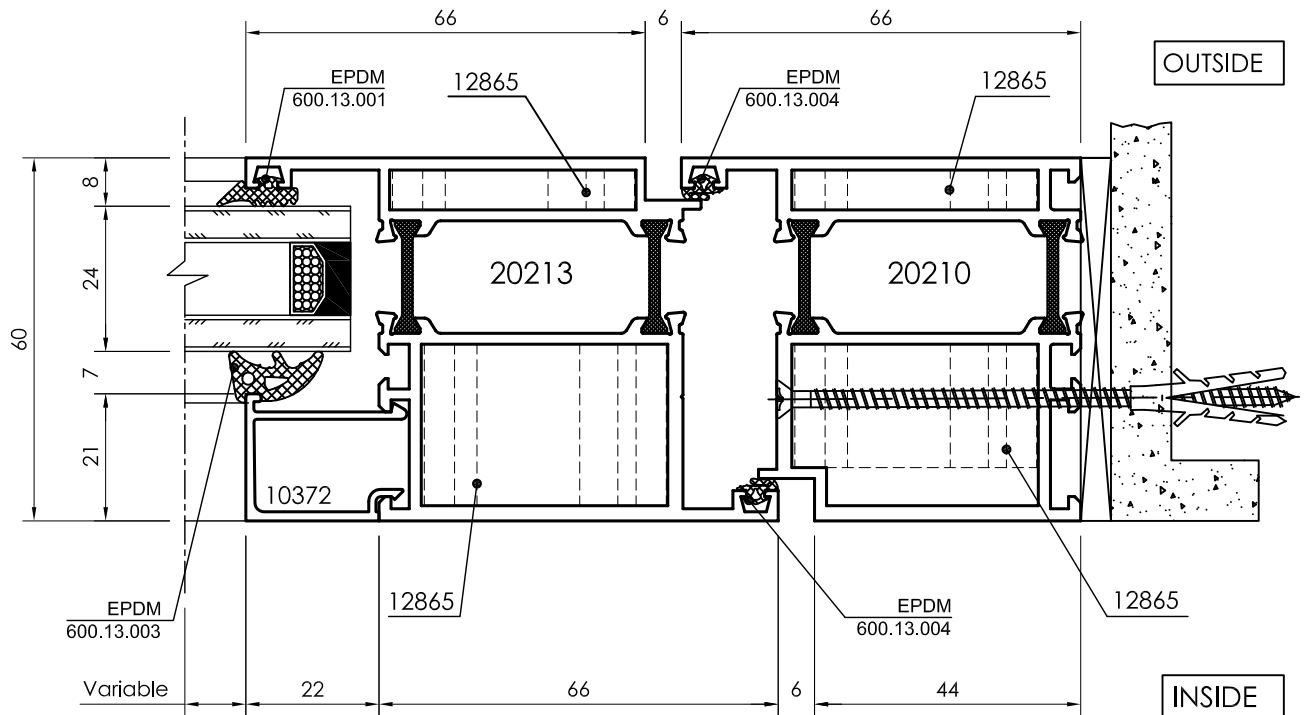
Detail - A1

Insulated Glass unit with Thickness Ranging from 18 to 28 mm



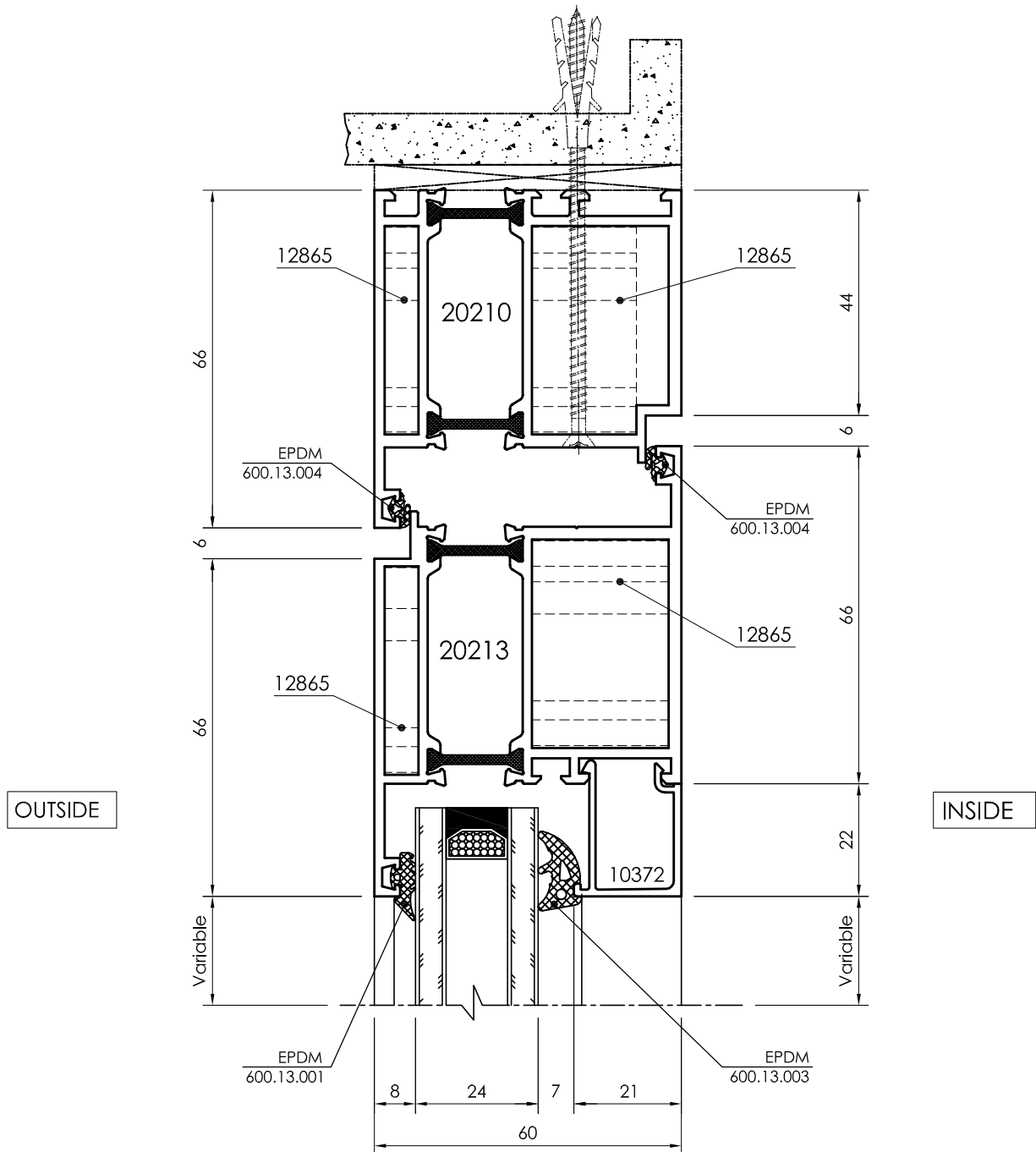
**Hinged Door Series 600**  
Detail - B1

Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Hinged Door Series 600

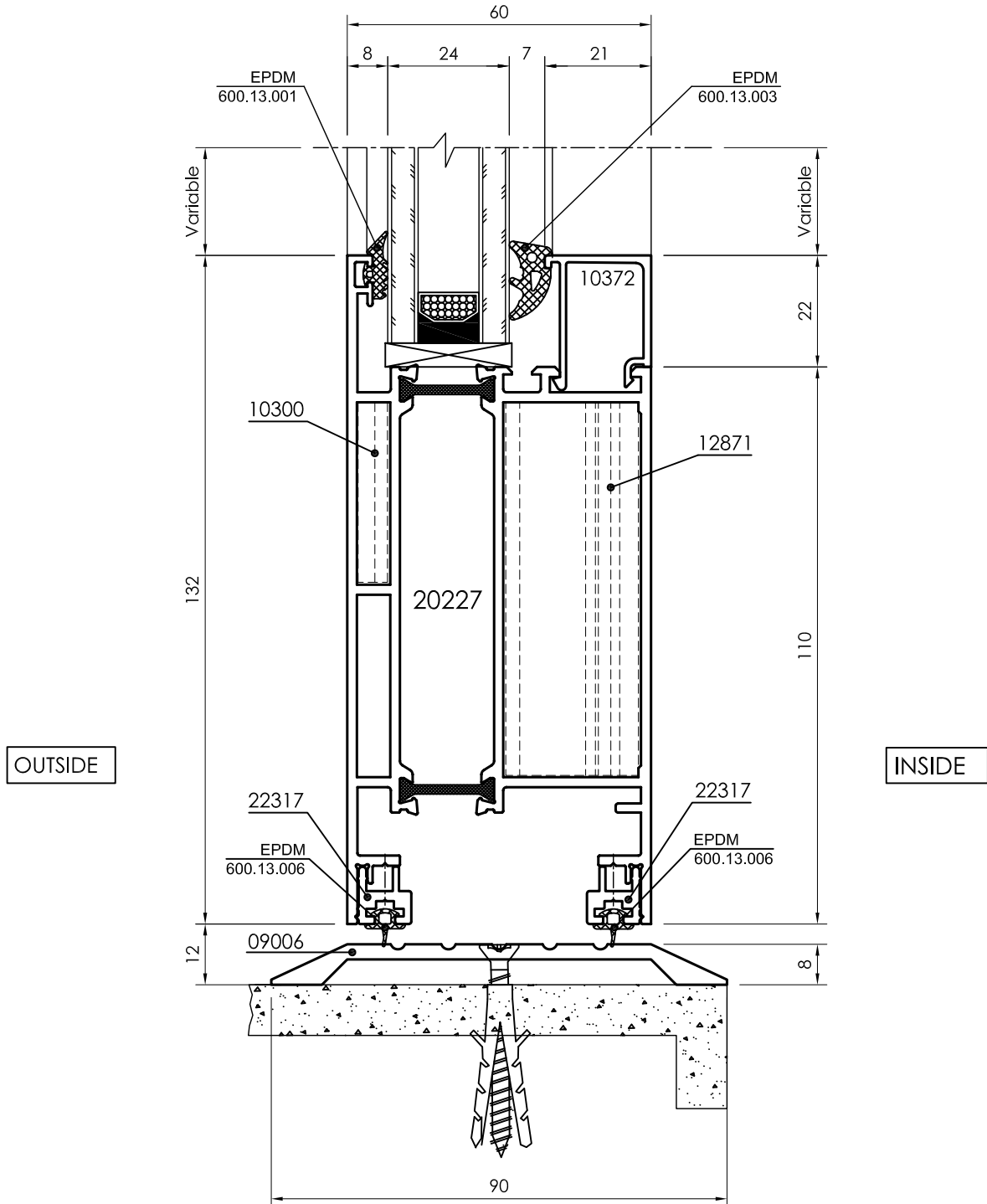
Detail - J1



Hinged Door Series 600

Detail - K1

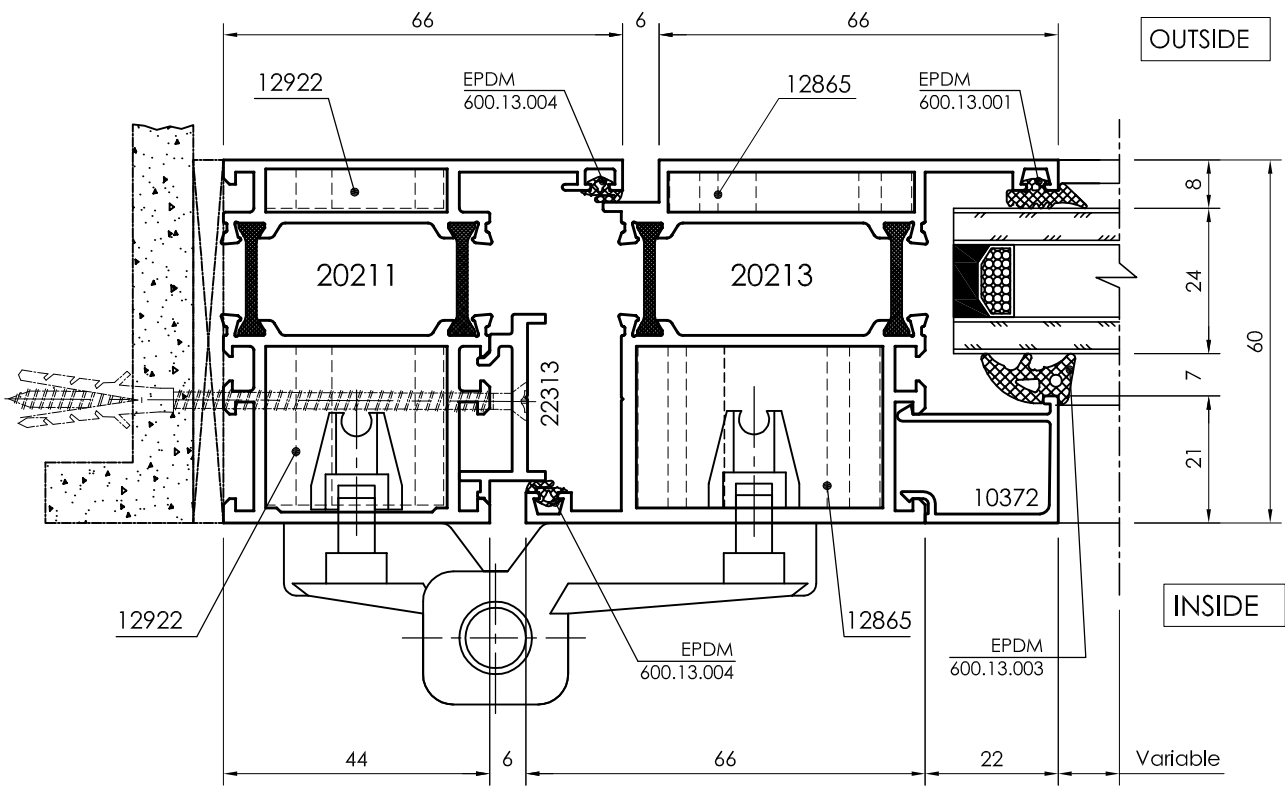
Insulated Glass unit with Thickness Ranging from 18 to 28 mm





Hinged Door Series 600

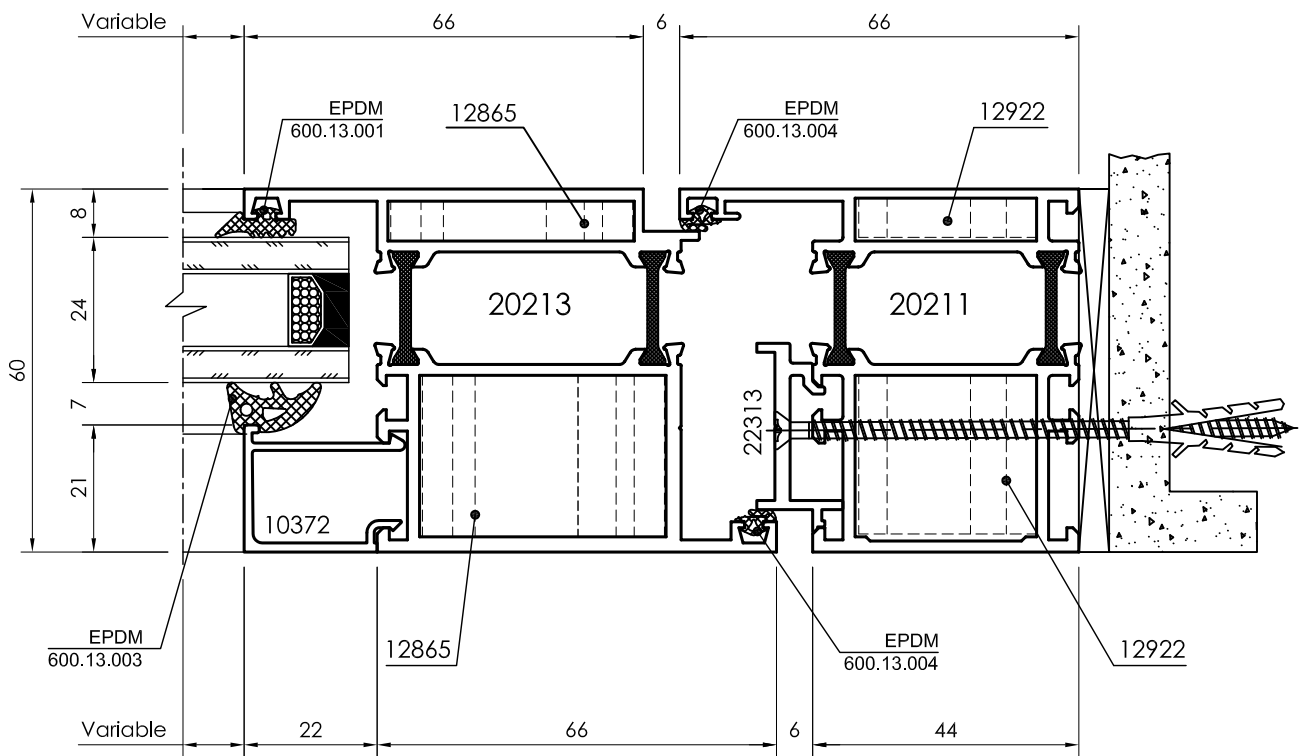
Detail - A2



**Hinged Door Series 600**

Detail - B2

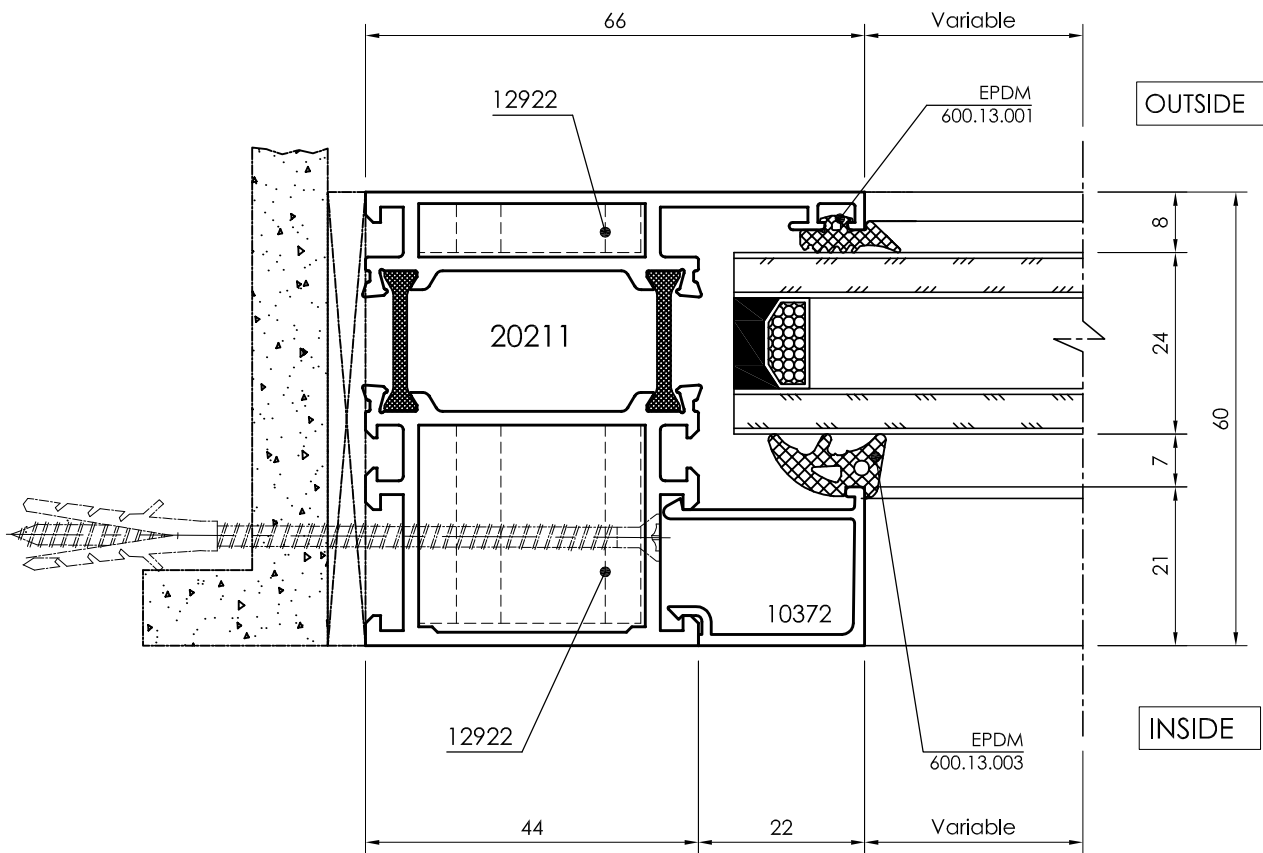
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Hinged Door Series 600

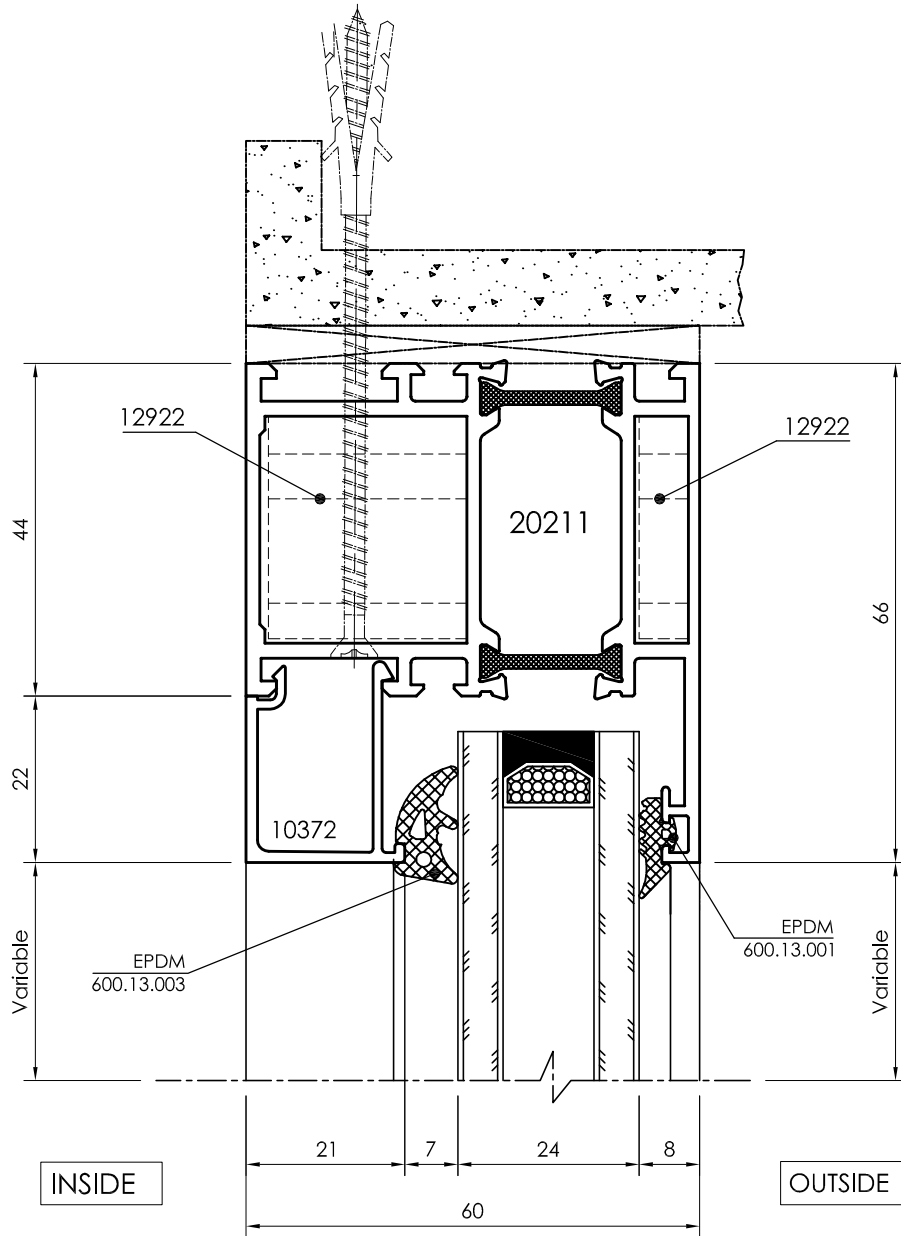
Detail - E1

Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**  
Detail - E2

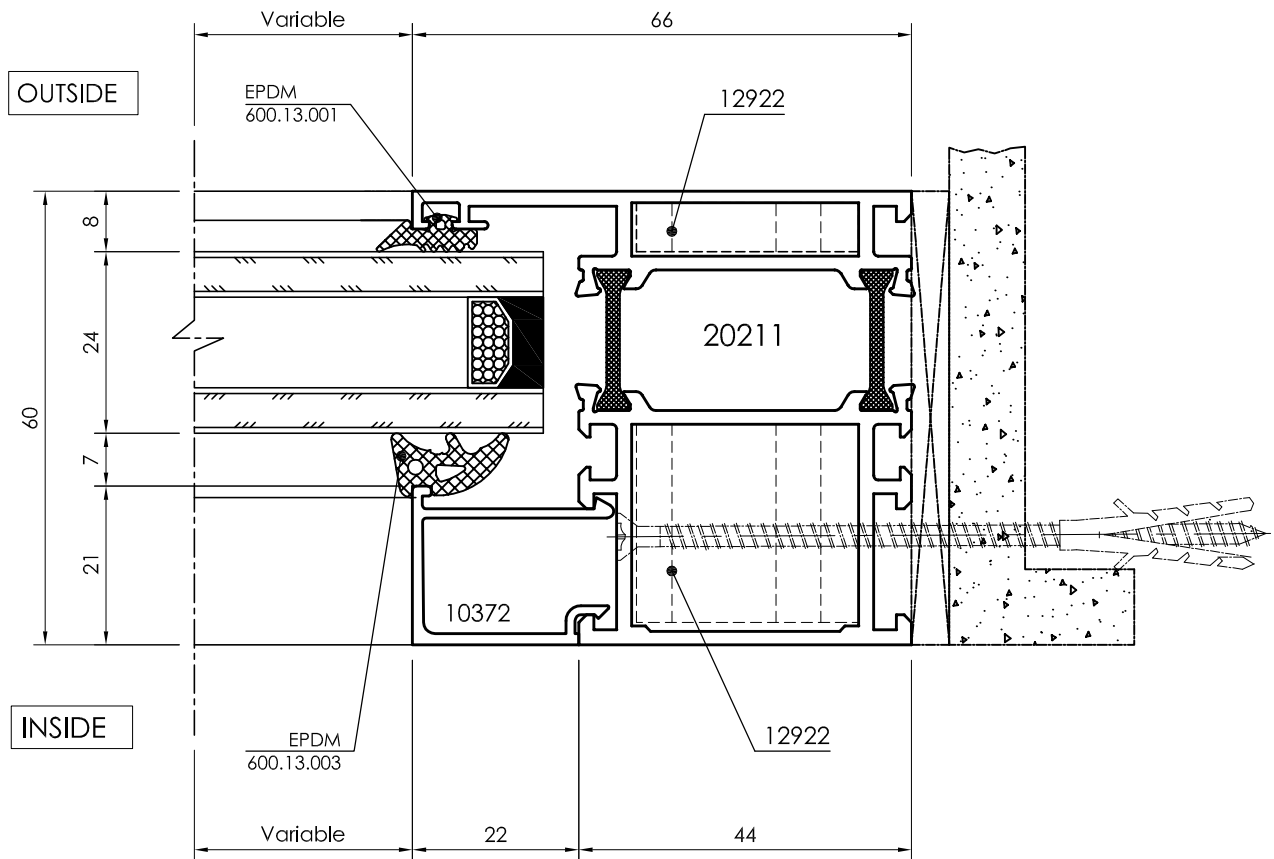
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Hinged Door Series 600

Detail - E3

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

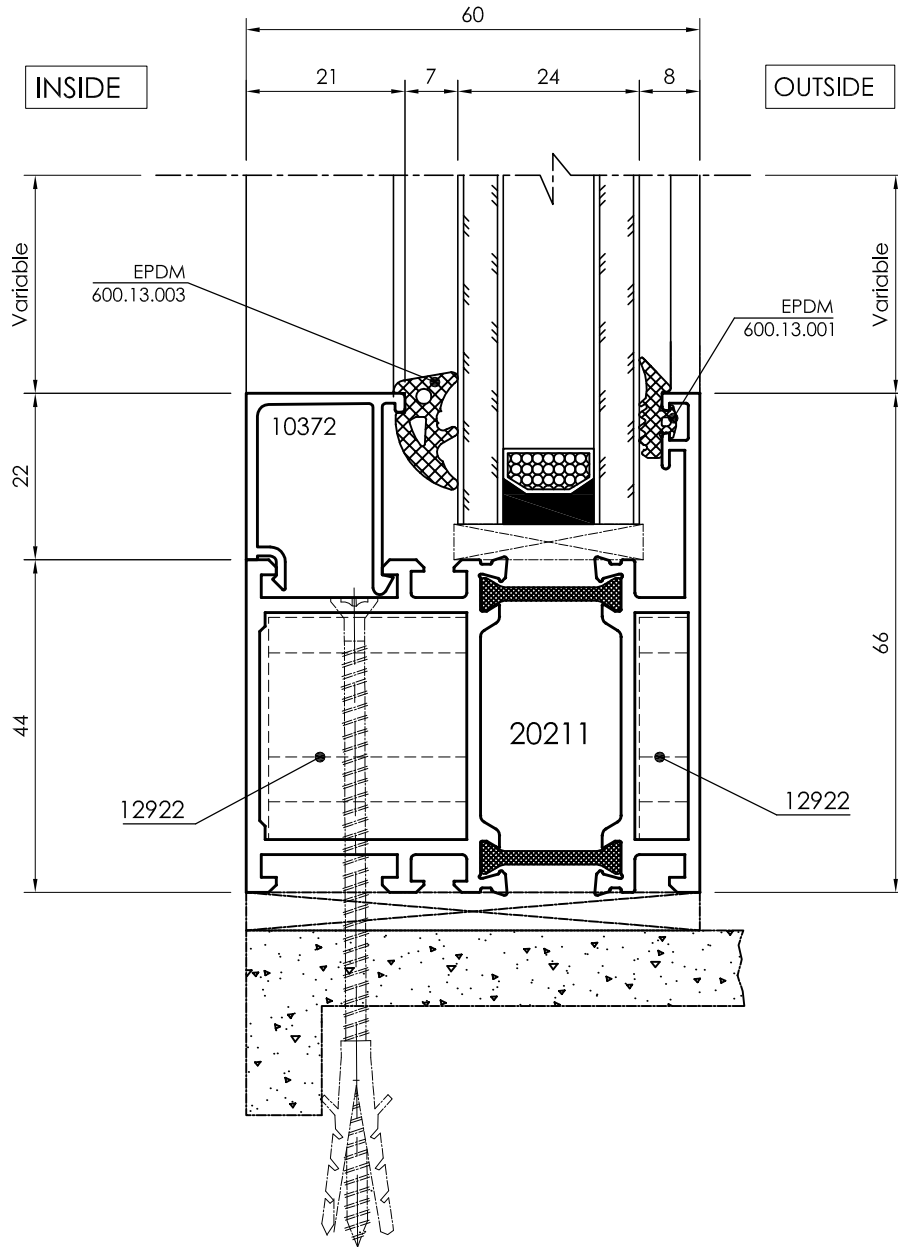


**Hinged Door Series 600**

Detail - E4

(Option - Detail - G)

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

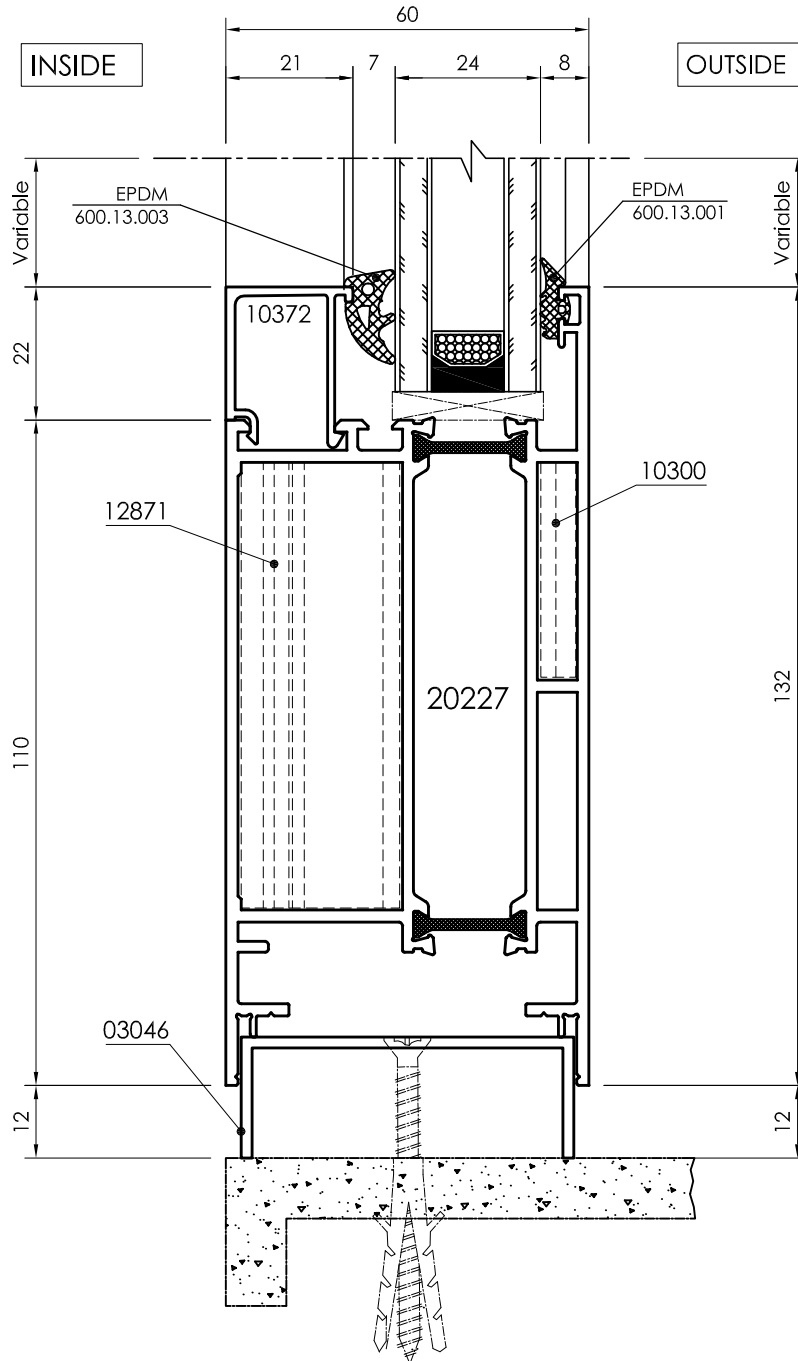


**Hinged Door Series 600**

Detail - G

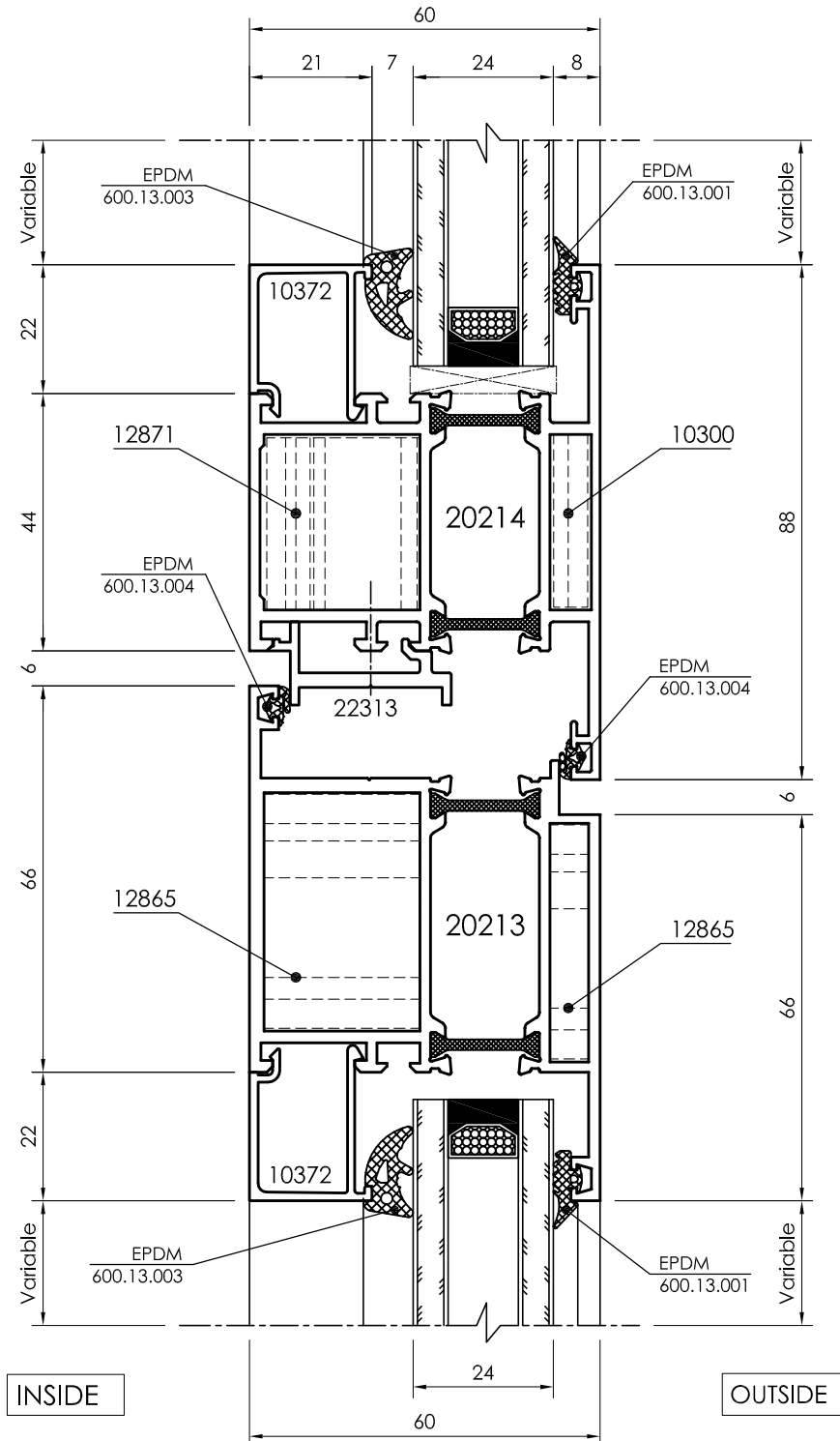
(Option - Detail - E4)

Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**  
Detail - J2

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

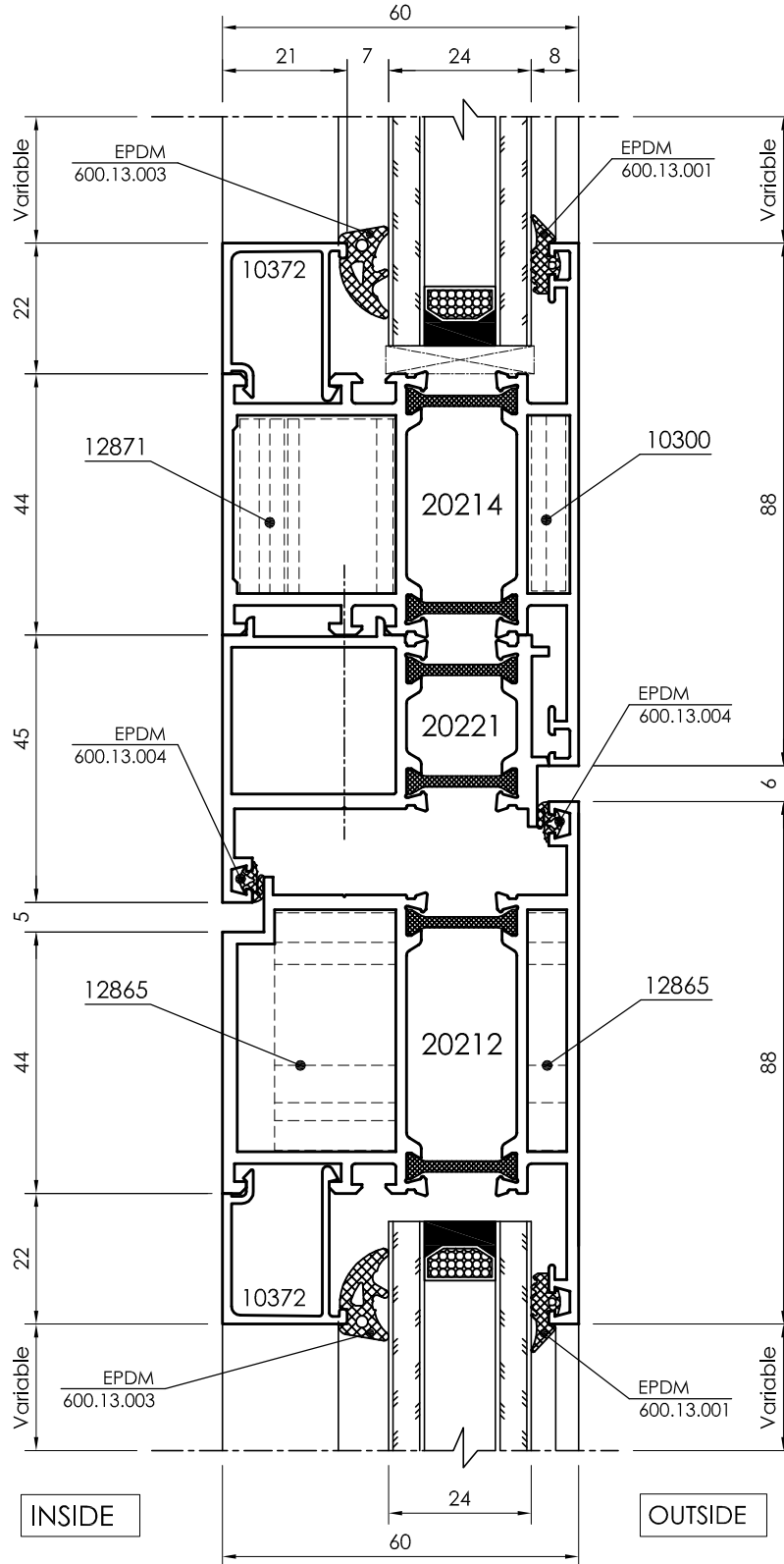




Hinged Door Series 600

Detail - J3

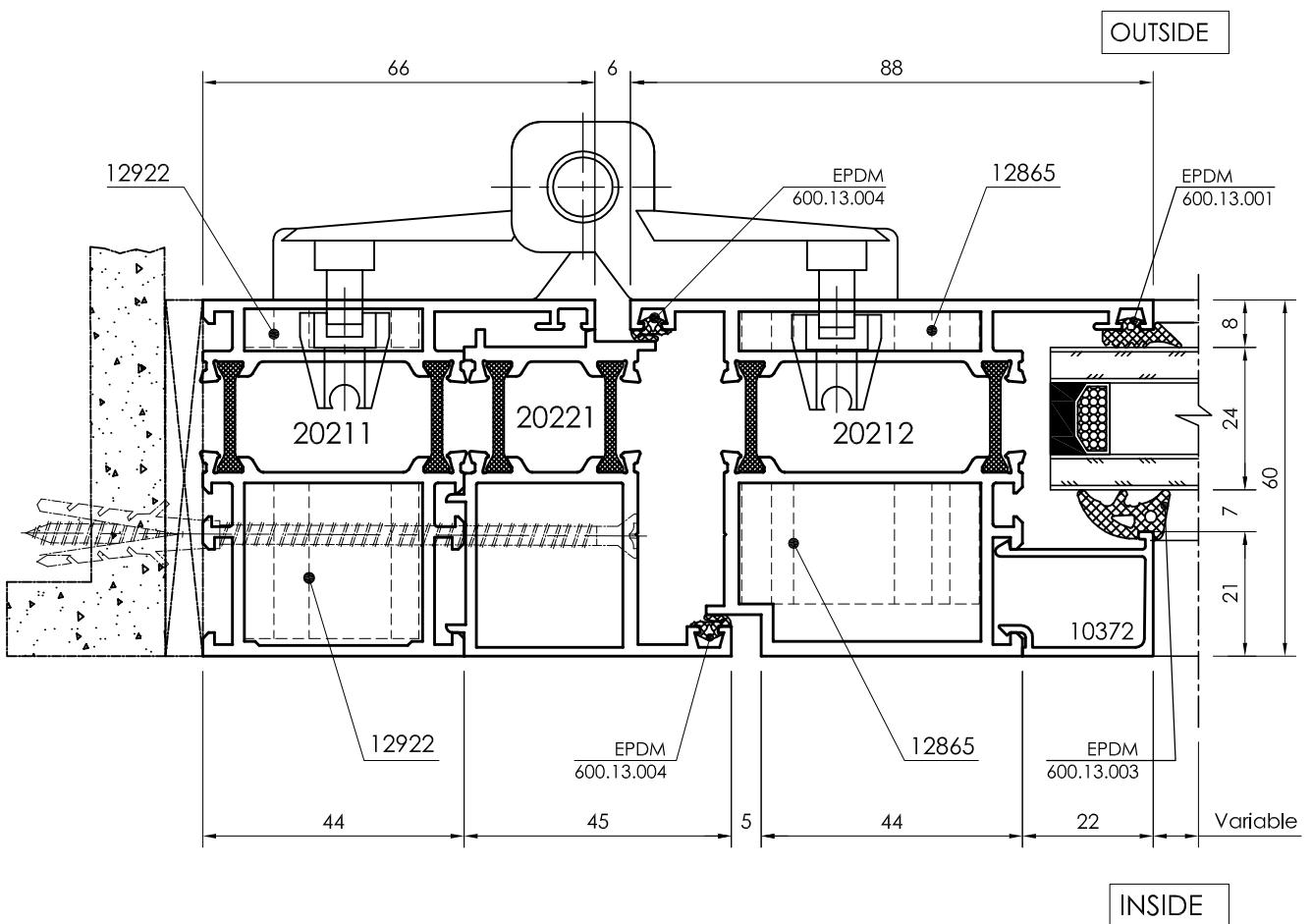
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**

Detail - A3

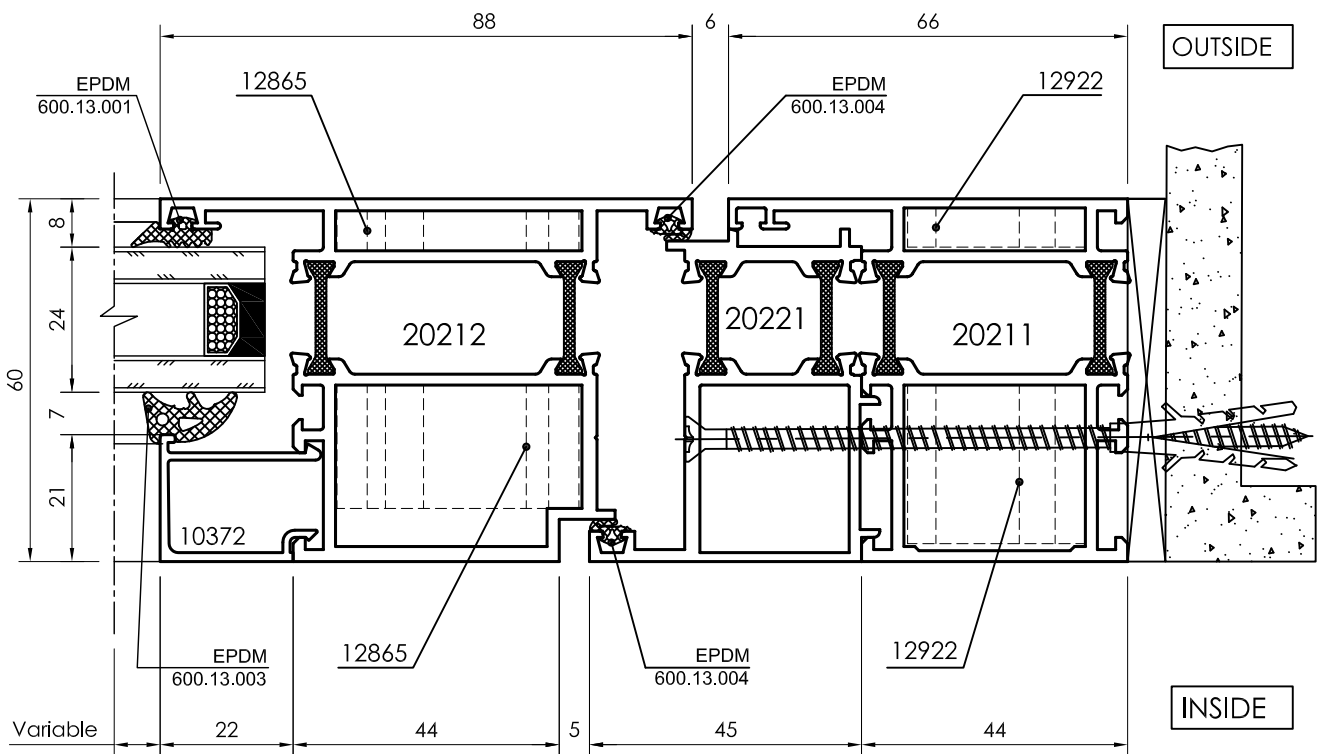
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Hinged Door Series 600

Detail - B3

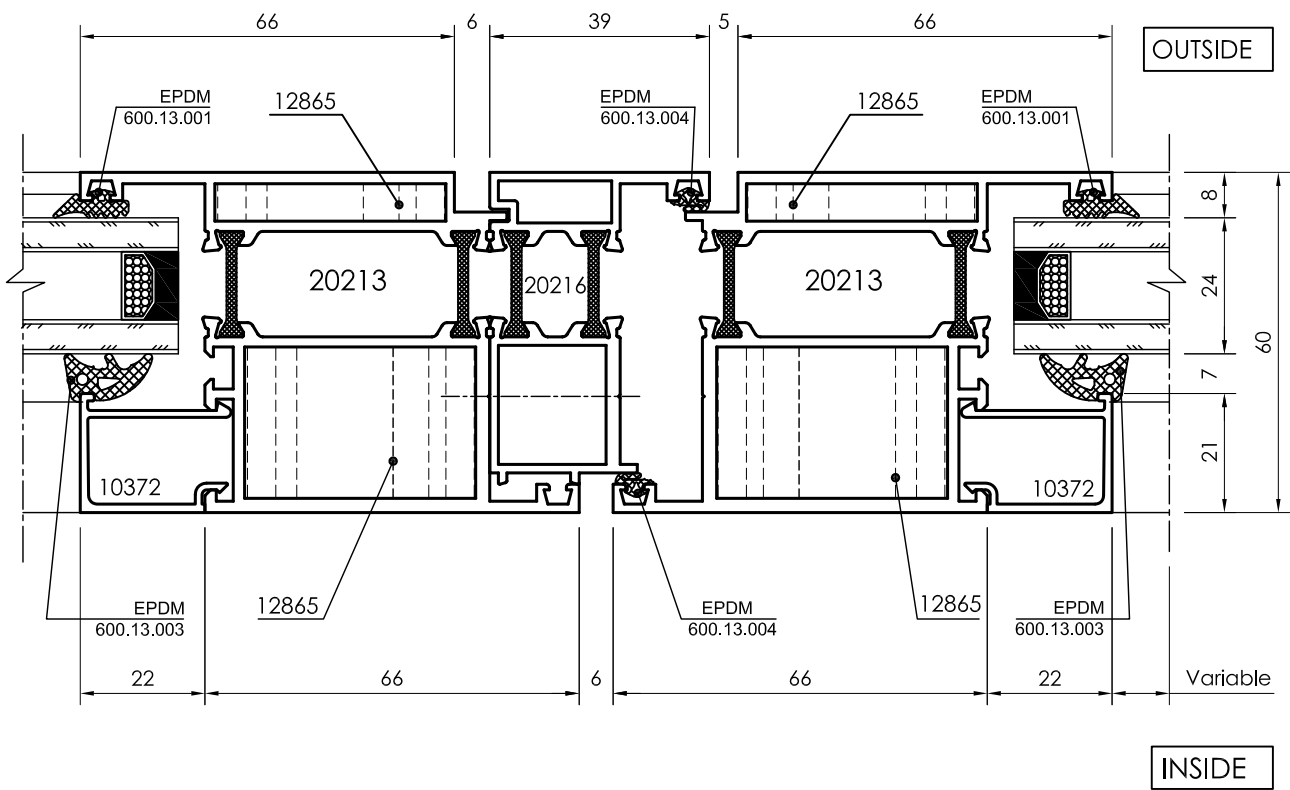
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**

Detail - C1

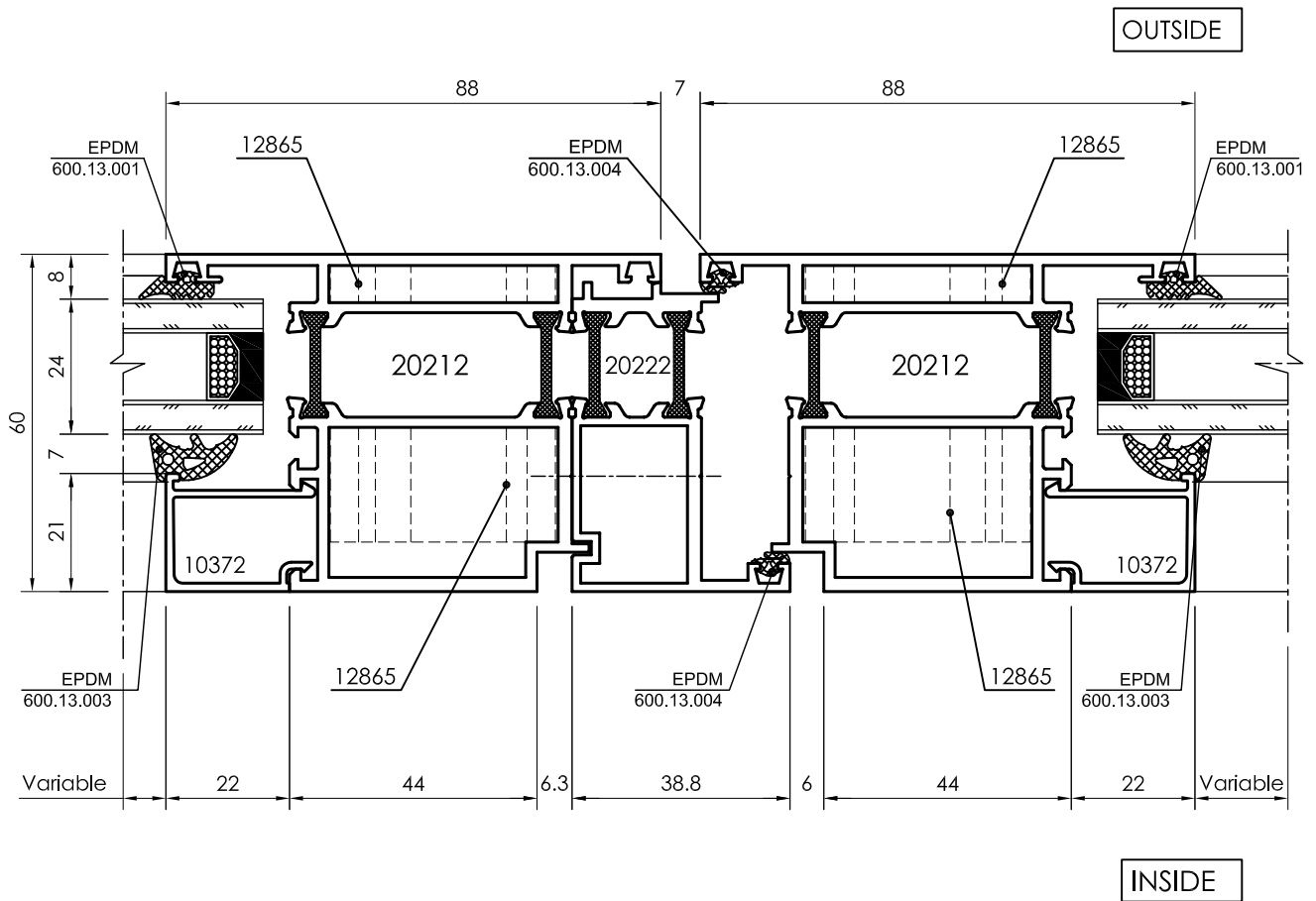
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Hinged Door Series 600

Detail - C2

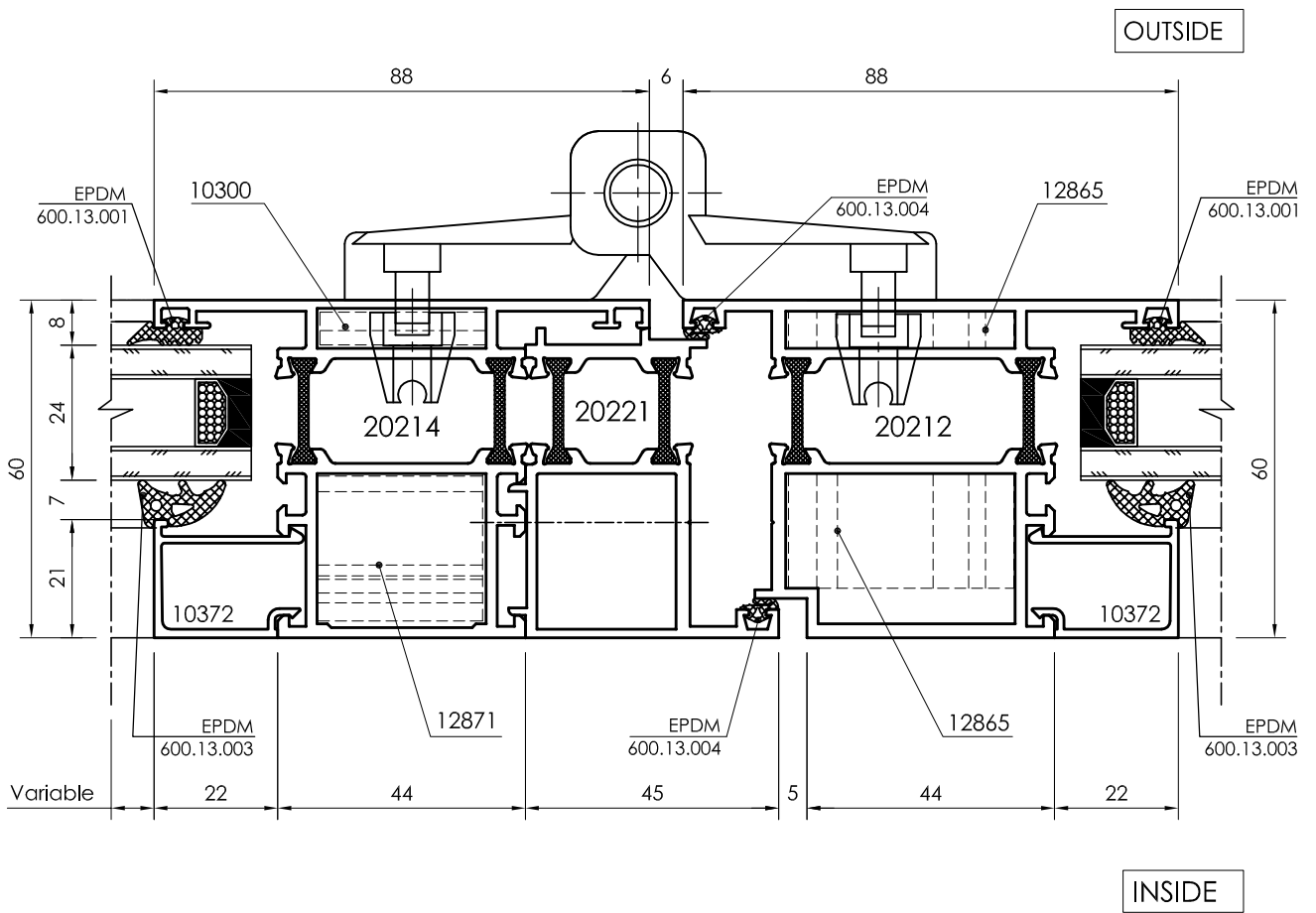
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**

Detail - A4

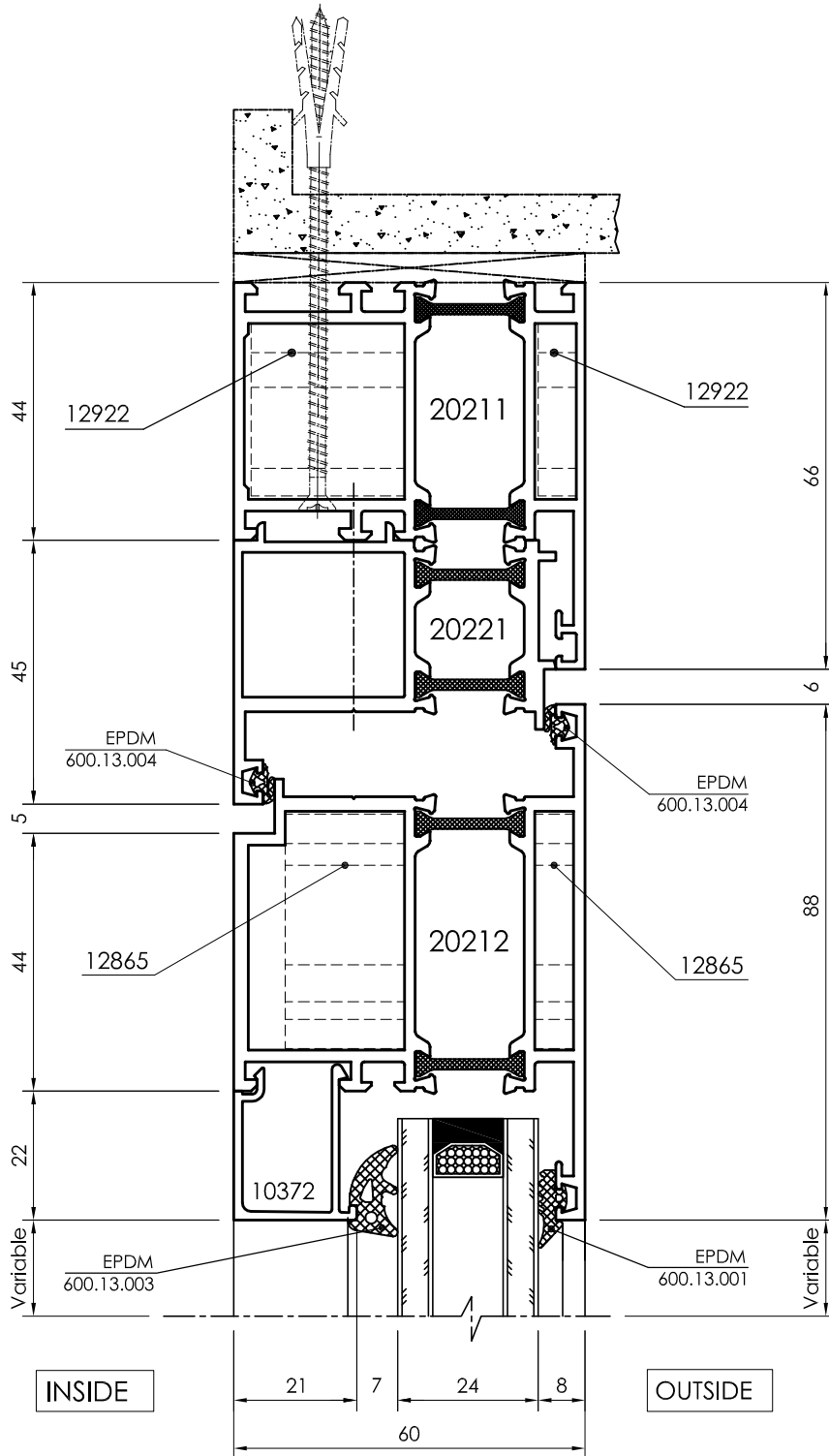
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



Hinged Door Series 600

Detail - J4

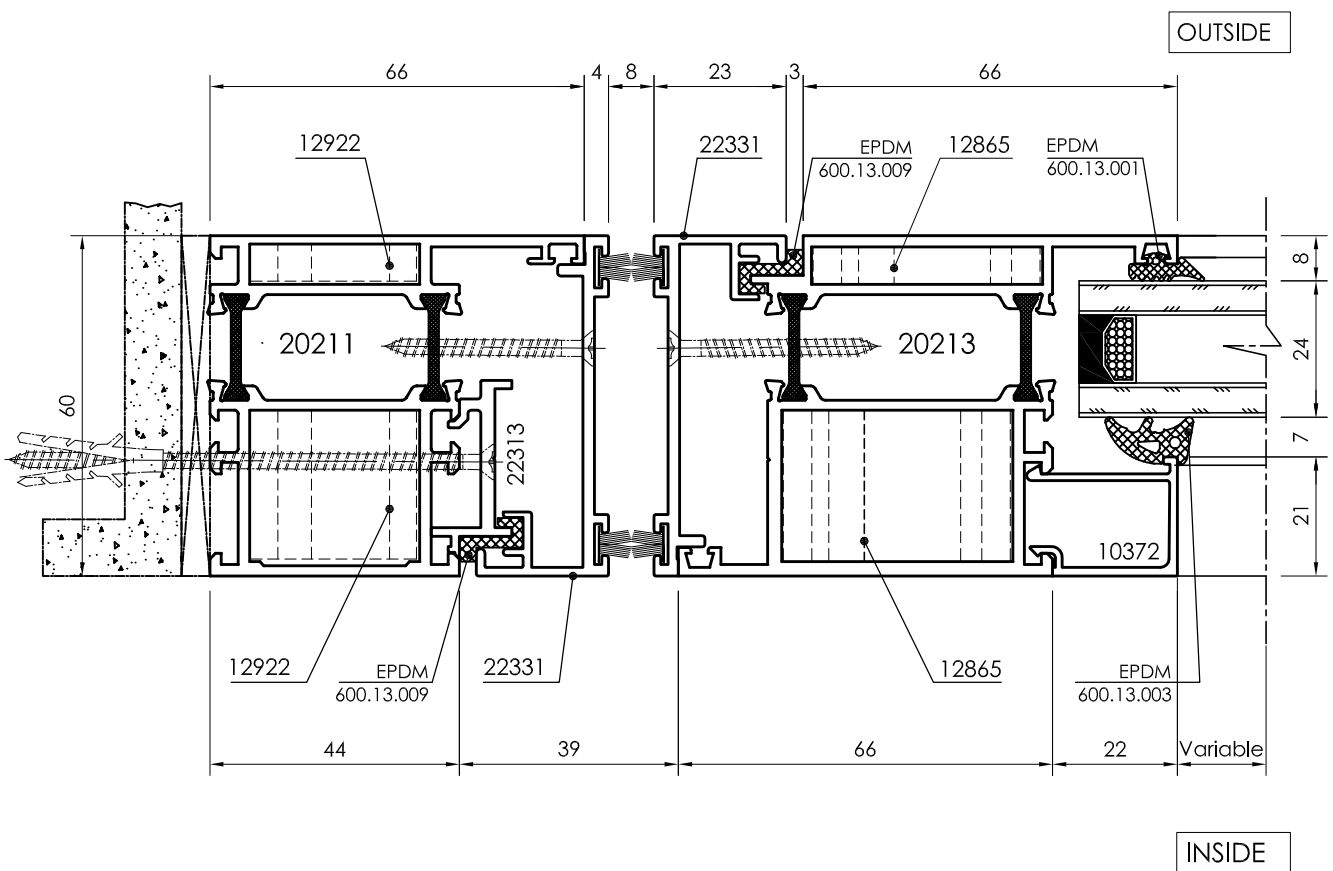
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**

Detail - A5

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

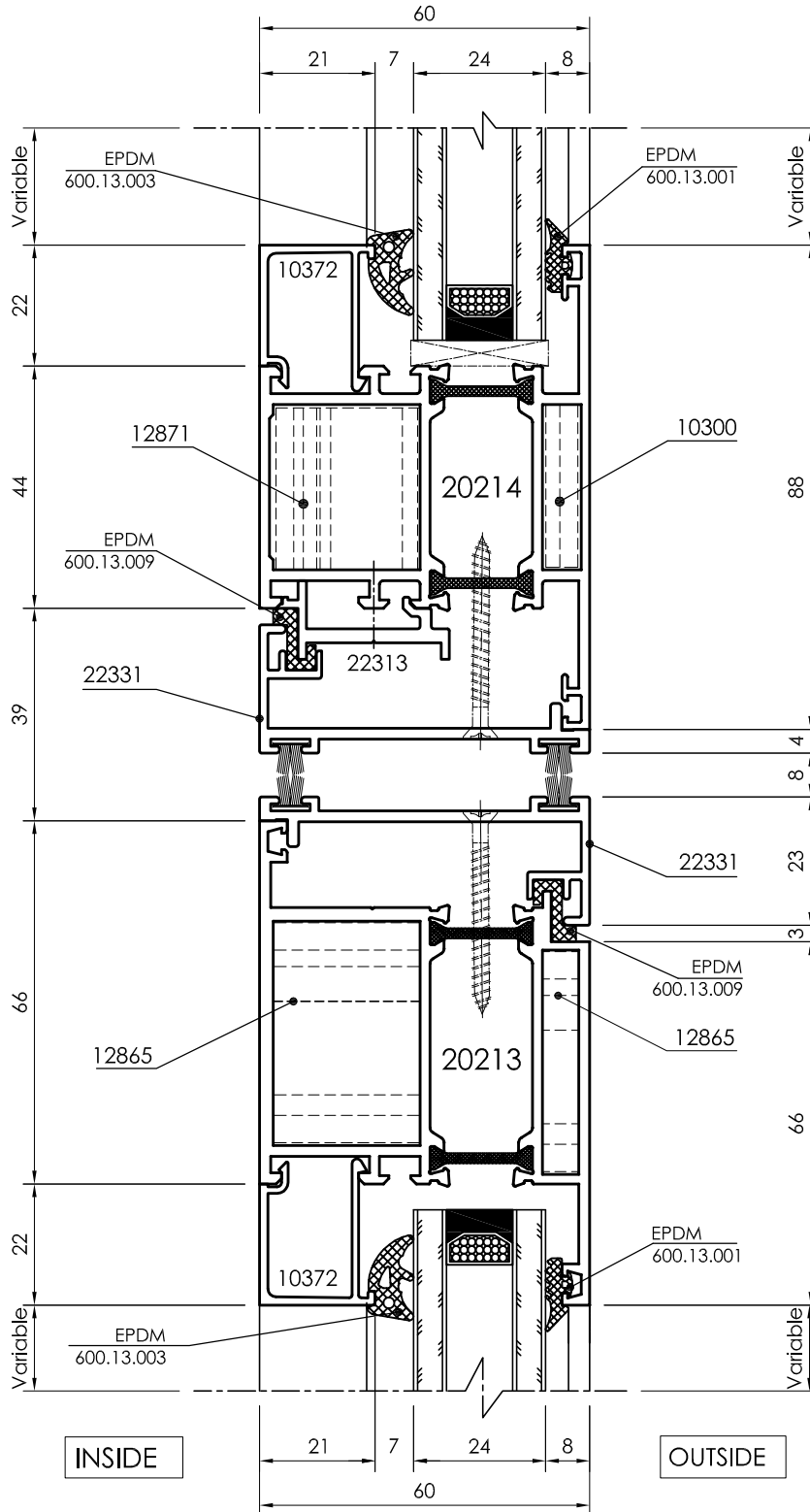




Hinged Door Series 600

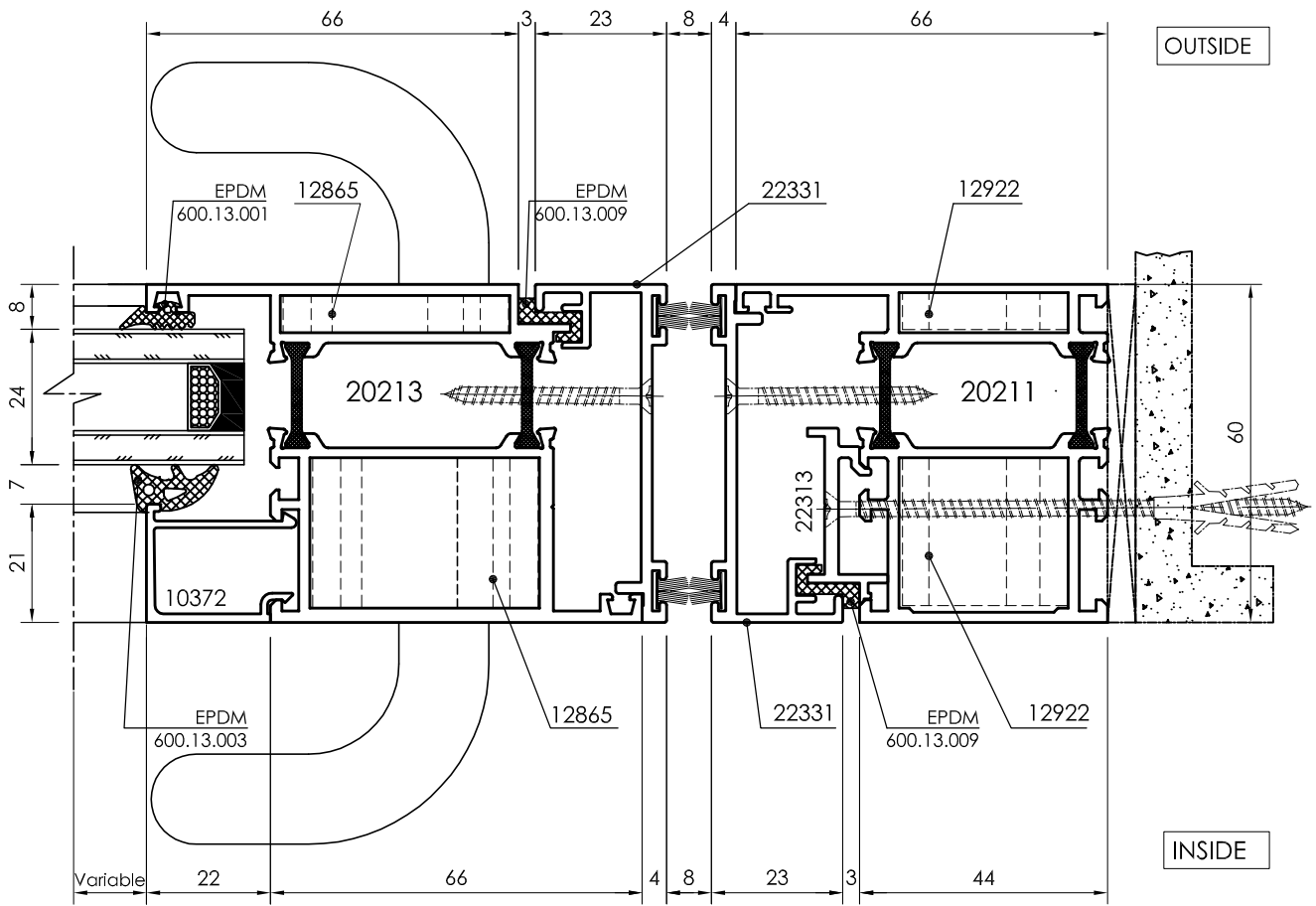
Detail - J5

Insulated Glass unit with Thickness Ranging from 18 to 28 mm



**Hinged Door Series 600**  
Detail - B5

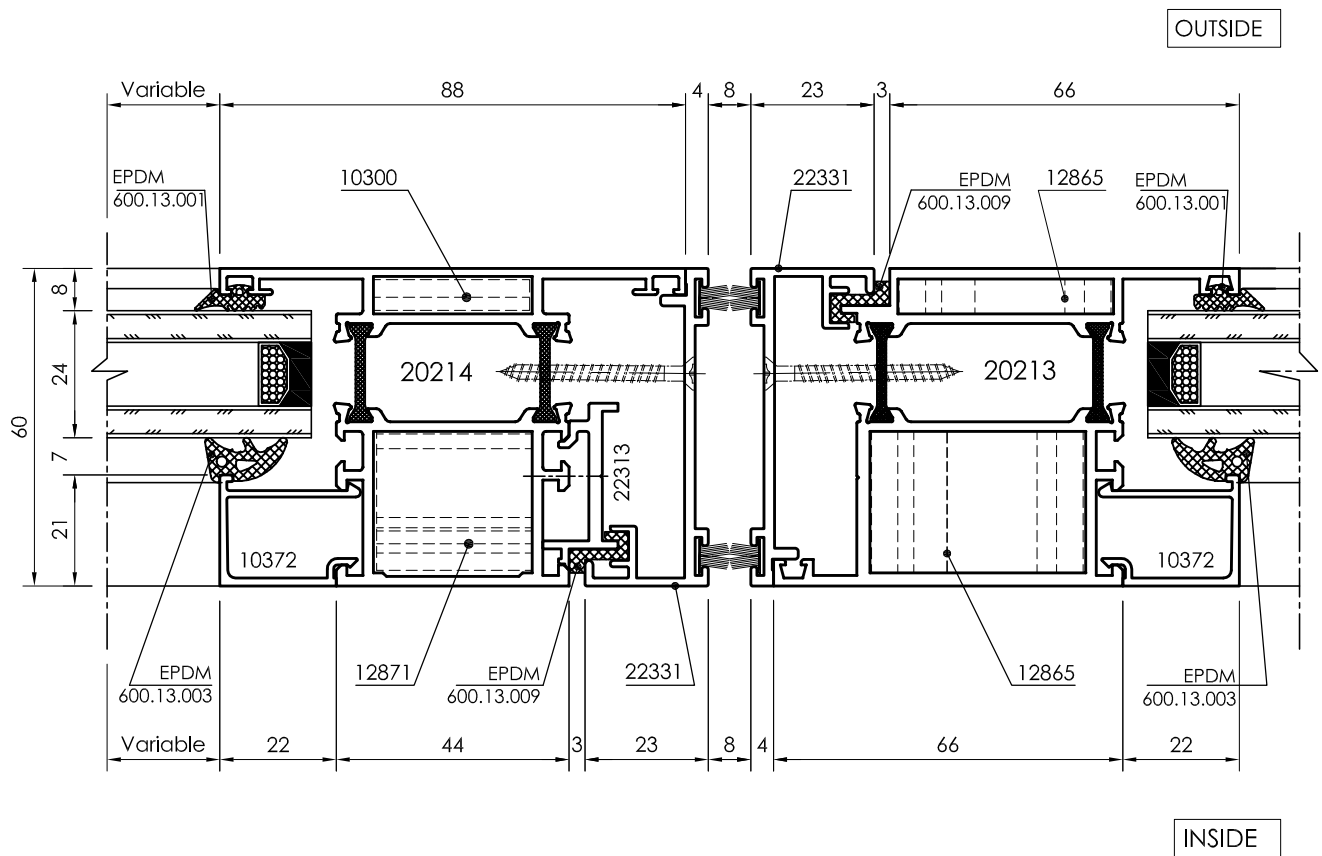
Insulated Glass unit with Thickness Ranging from 18 to 28 mm



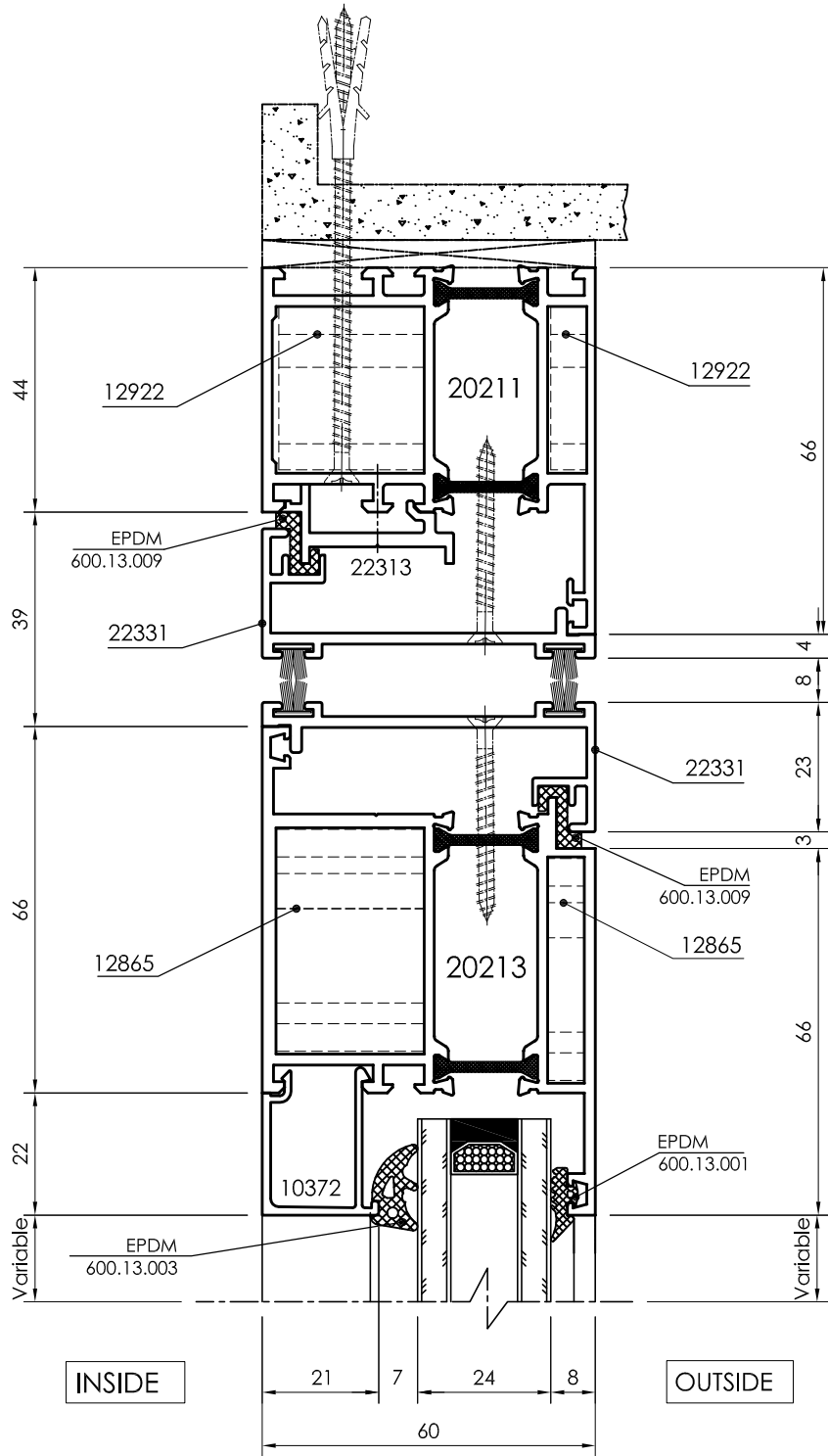
Hinged Door Series 600

Detail - A6

Insulated Glass unit with Thickness Ranging from 18 to 28 mm



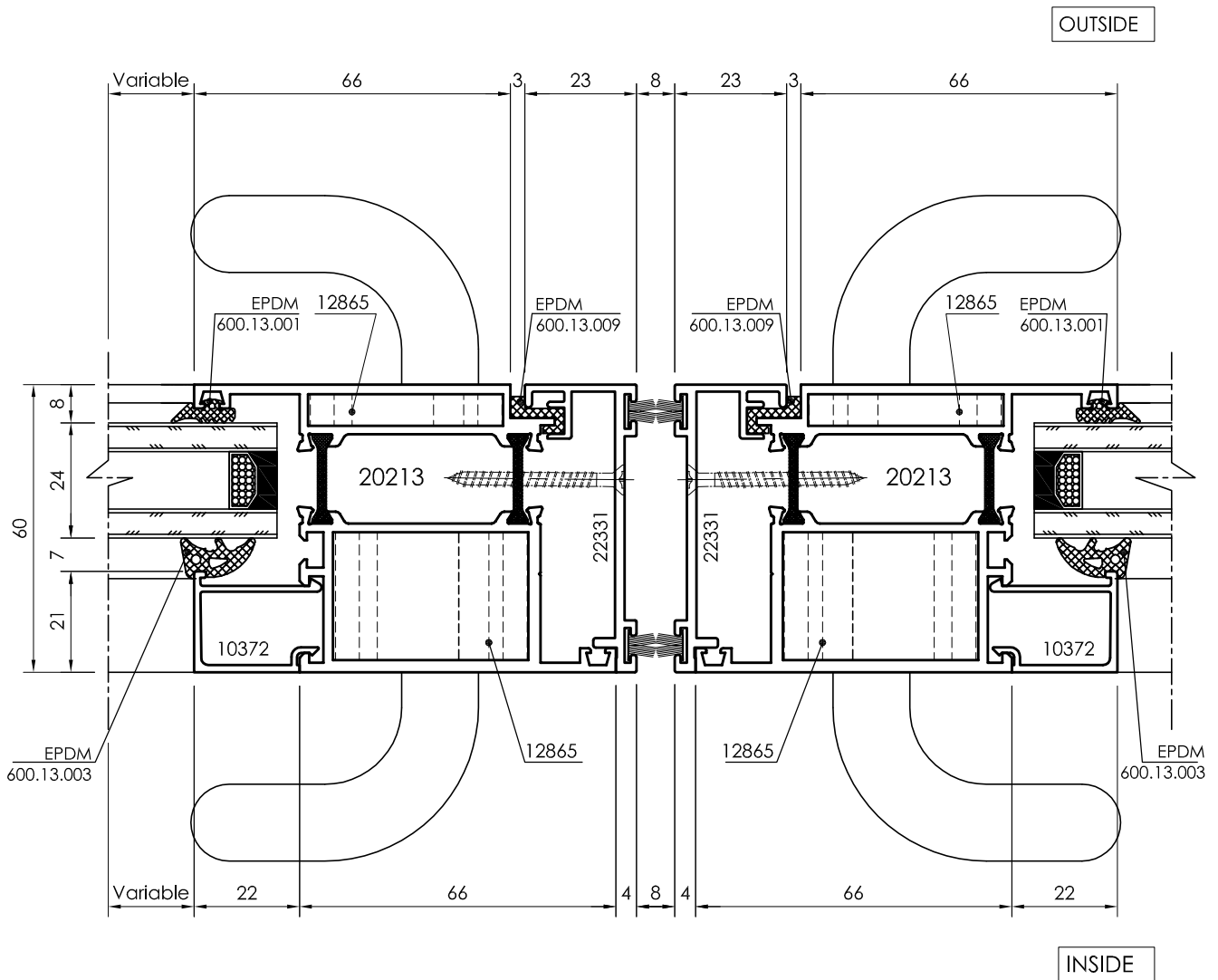
**Hinged Door Series 600**  
Detail - J6



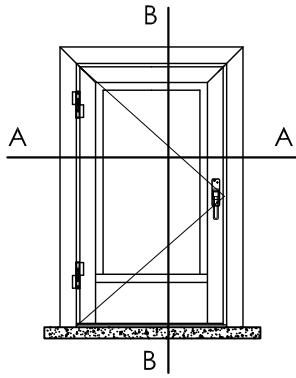
Hinged Door Series 600

Detail - C3

Insulated Glass unit with Thickness Ranging from 18 to 28 mm

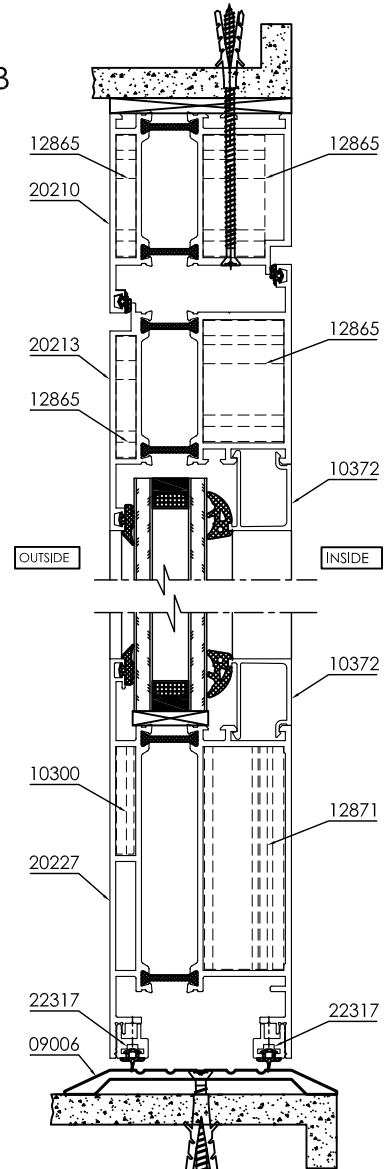


Hinged Door Series 600

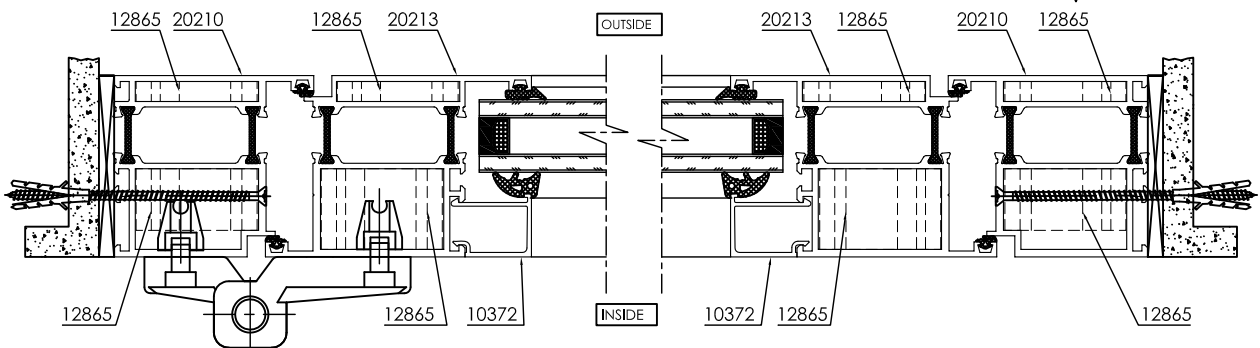


SINGLE LEAF HINGED DOOR  
(INWARD OPENING)

DETAIL : B-B

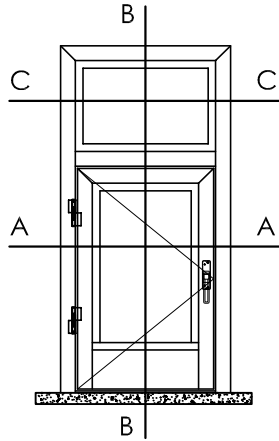


Profiles		
Description	Shape	Section No.
Frame		20210
Sash		20213
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
T - Corner profile		12871
T - Corner profile		10300
Threshold		09006



DETAIL : A-A

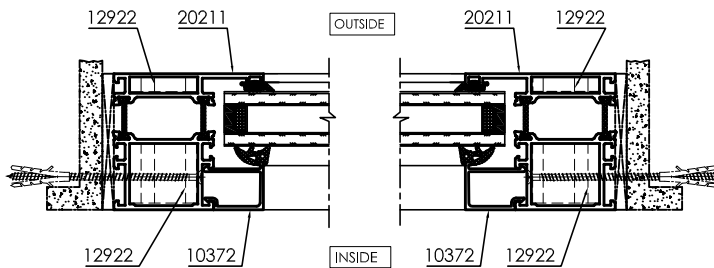
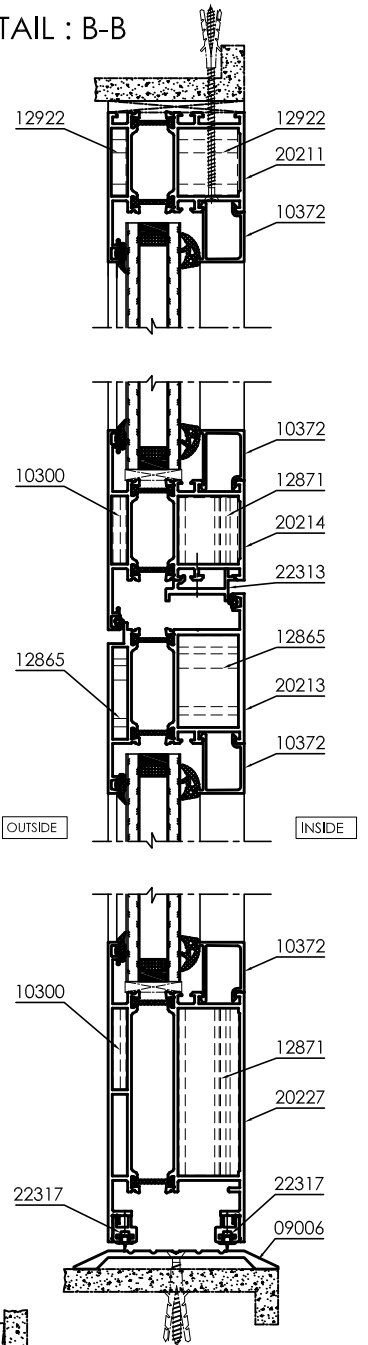
Hinged Door Series 600



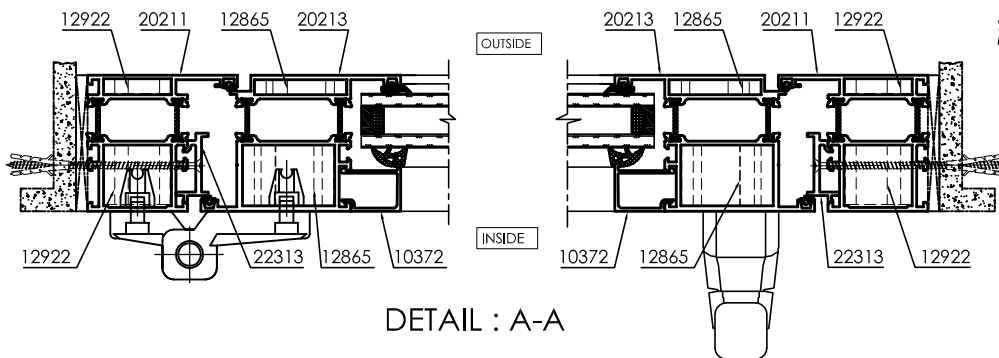
SINGLE LEAF HINGED DOOR  
WITH TOP FIXED PANEL  
(INWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20211
Adaptor		22313
Sash		20213
T - profile		20214
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
Corner cleat		12922
T - Corner profile		12871
T - Corner profile		10300
Threshold		09006

DETAIL : B-B

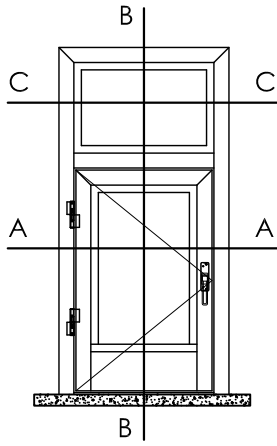


DETAIL : C-C



DETAIL : A-A

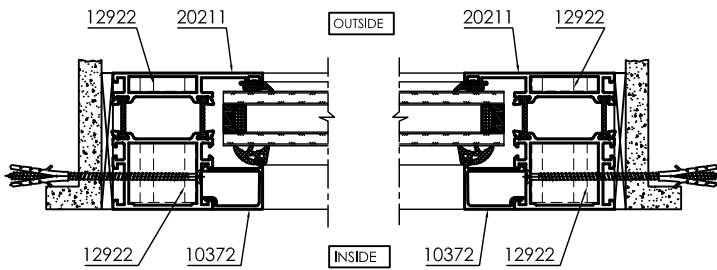
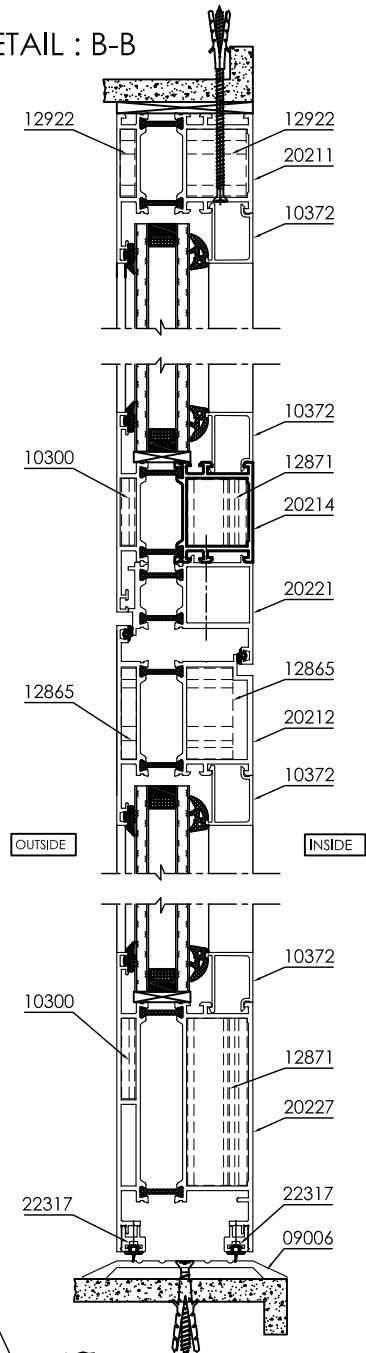
Hinged Door Series 600



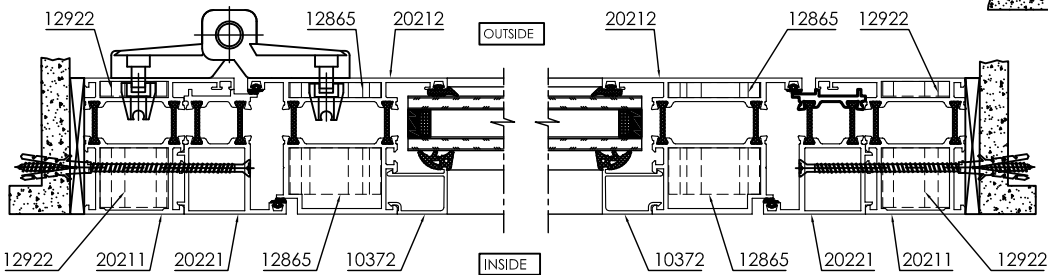
SINGLE LEAF HINGED DOOR  
WITH TOP FIXED PANEL  
(OUTWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20211
Adaptor		20221
Sash		20212
T - profile		20214
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
Corner cleat		12922
T - Corner profile		12871
T - Corner profile		10300
Treshold		09006

DETAIL : B-B



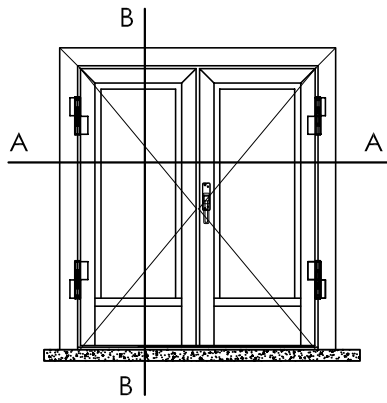
DETAIL : C-C



DETAIL : A-A



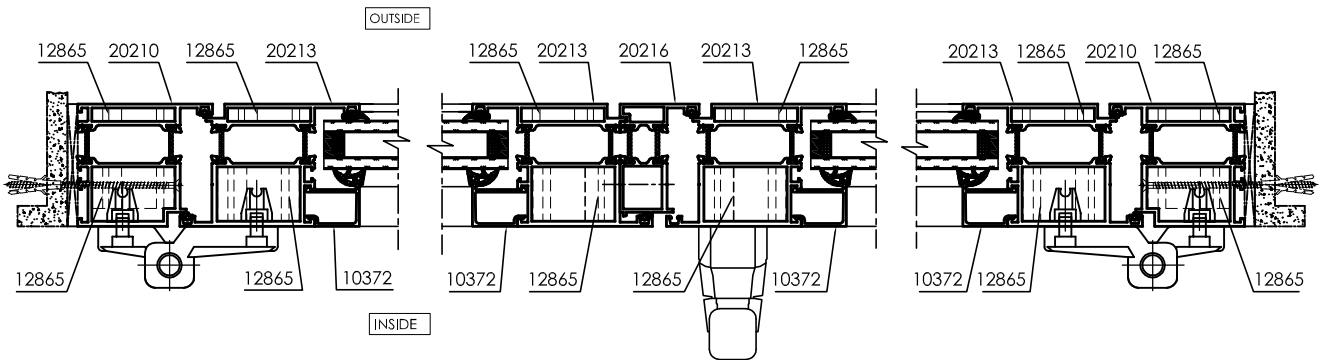
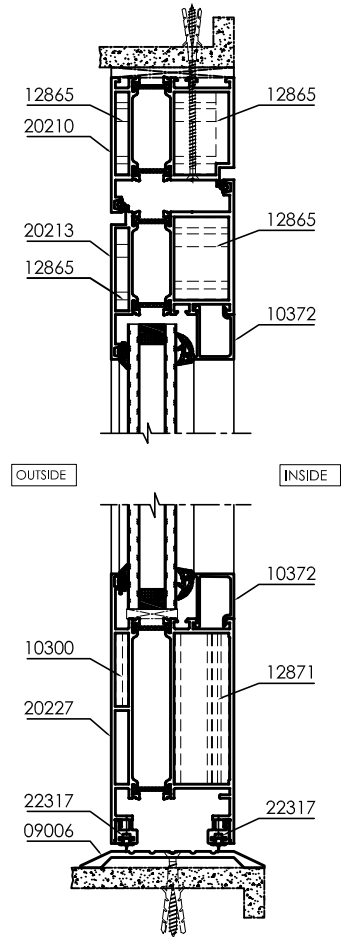
Hinged Door Series 600



DOUBLE LEAF HINGED DOOR  
(INWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20210
Sash		20213
Adaptor		20216
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
T - Corner profile		12871
T - Corner profile		10300
Threshold		09006

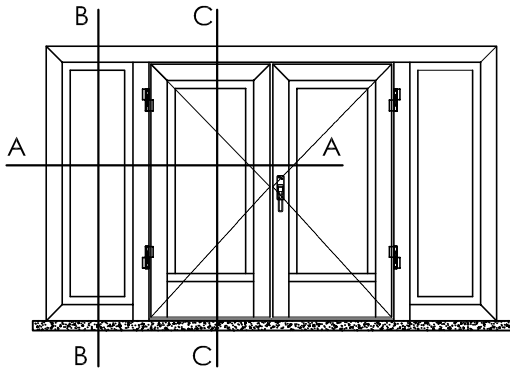
DETAIL : B-B



DETAIL : A-A

Hinged Door Series 600

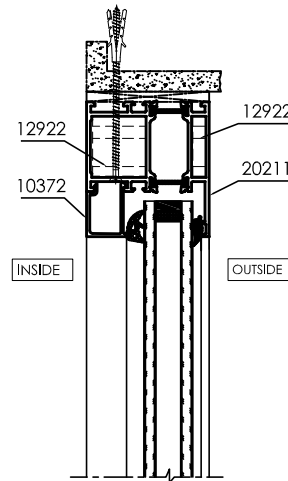
Detail - D1



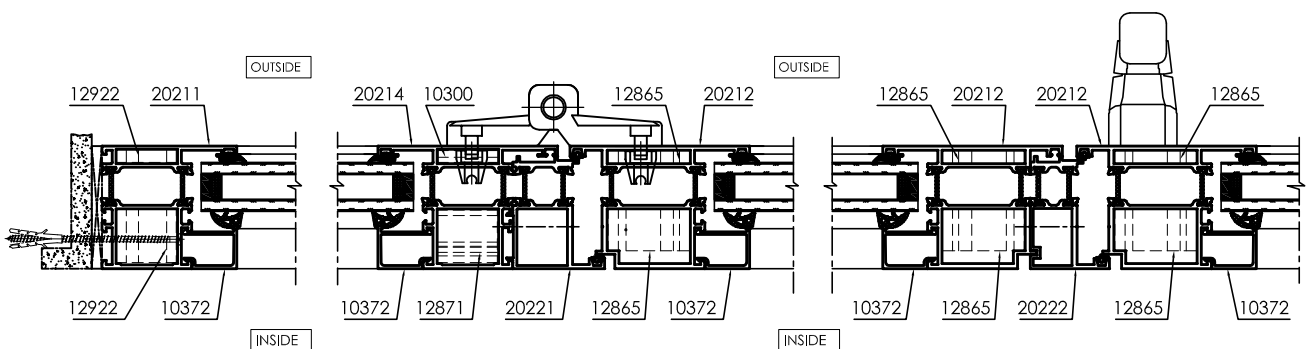
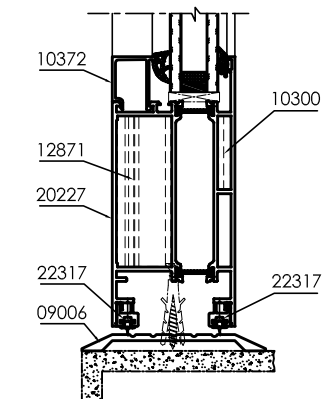
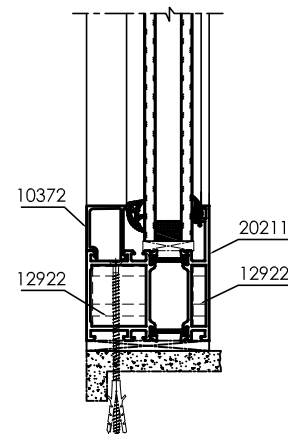
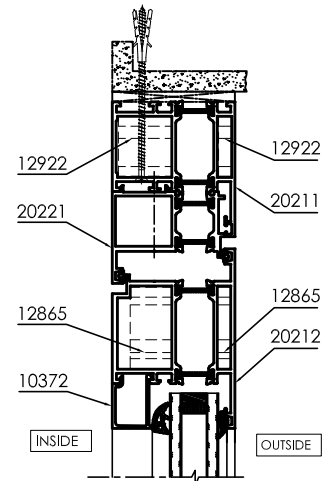
DOUBLE LEAF HINGED DOOR  
WITH SIDE FIXED PANEL  
(OUTWARD OPENING)

Profiles		
Description	Shape	Section No.
Frame		20211
Adaptor		20221
Sash		20212
Adaptor		20222
T - profile		20214
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
Corner cleat		12922
T - Corner profile		12871
T - Corner profile		10300
Threshold		09006

DETAIL : B-B

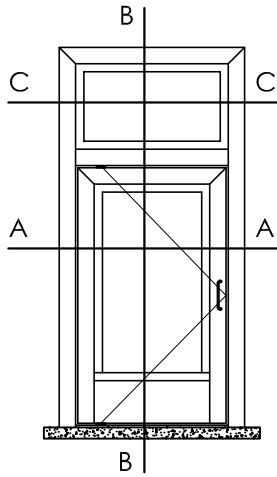


DETAIL : C-C



DETAIL : A-A

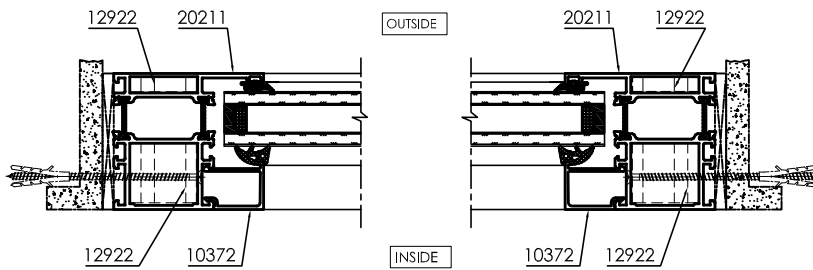
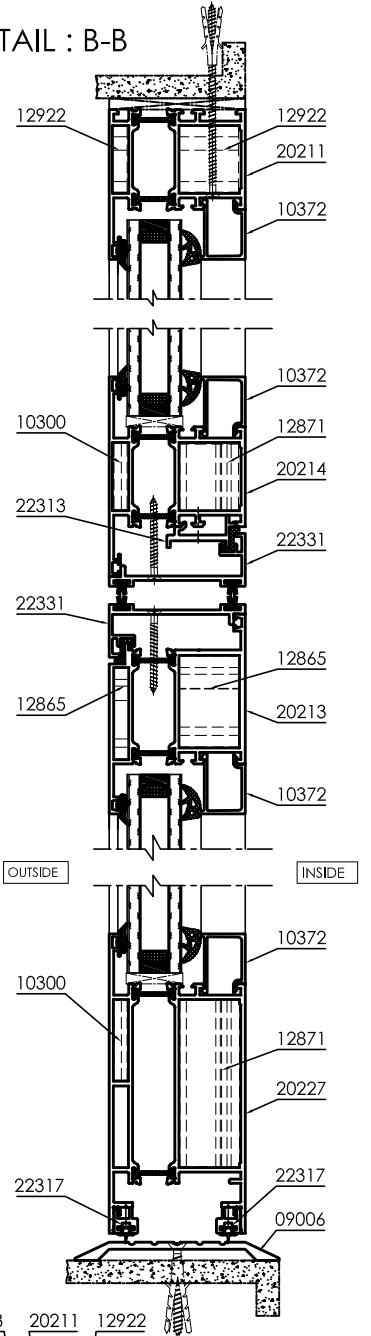
Hinged Door Series 600



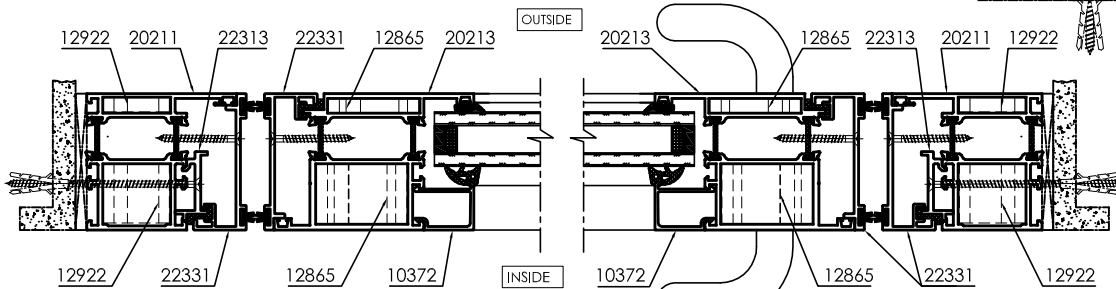
SINGLE LEAF SWING DOOR  
WITH TOP FIXED PANEL

Profiles		
Description	Shape	Section No.
Frame		20211
Adaptor		22313
Sash		20213
Swing adaptor		22331
T - profile		20214
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
Corner cleat		12922
T - Corner profile		12871
T - Corner profile		10300
Threshold		09006

DETAIL : B-B

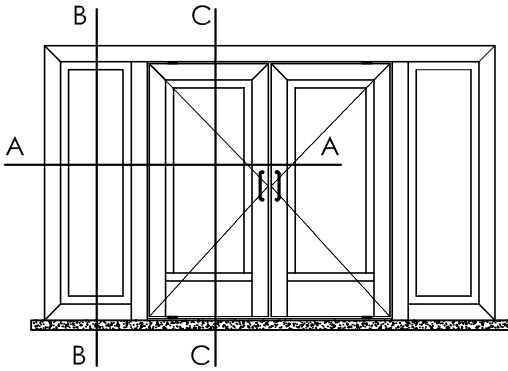


DETAIL : C-C



DETAIL : A-A

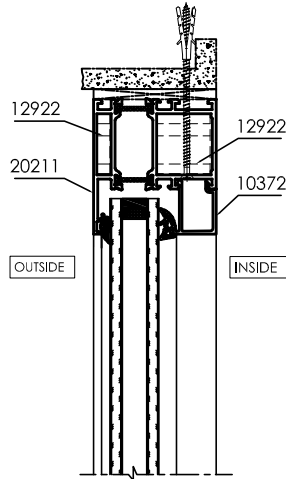
Hinged Door Series 600



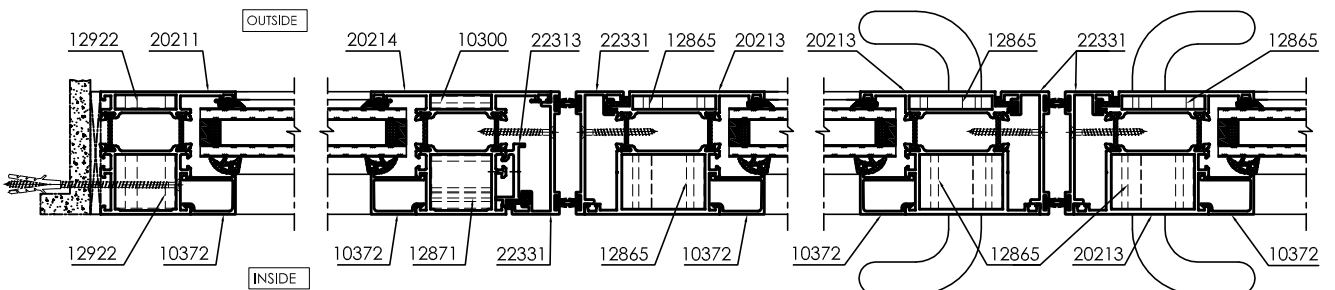
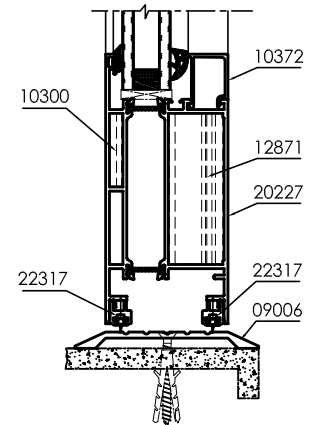
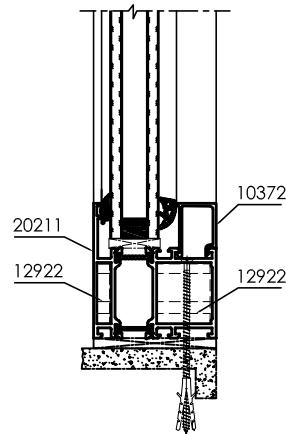
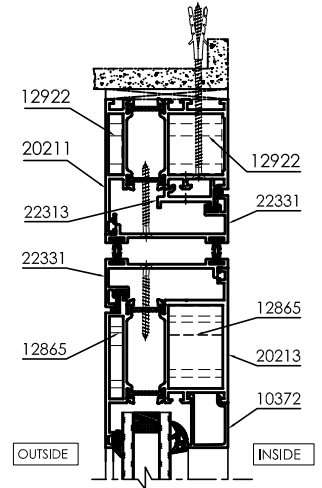
DOUBLE LEAF SWING DOOR  
WITH SIDE FIXED PANEL

Profiles		
Description	Shape	Section No.
Frame		20211
Adaptor		22313
Sash		20213
Swing adaptor		22331
T - profile		20214
Door bottom		20227
Door bottom gasket holder		22317
Glazing bead		10372
Corner cleat		12865
Corner cleat		12922
T - Corner profile		12871
T - Corner profile		10300
Threshold		09006

DETAIL : B-B



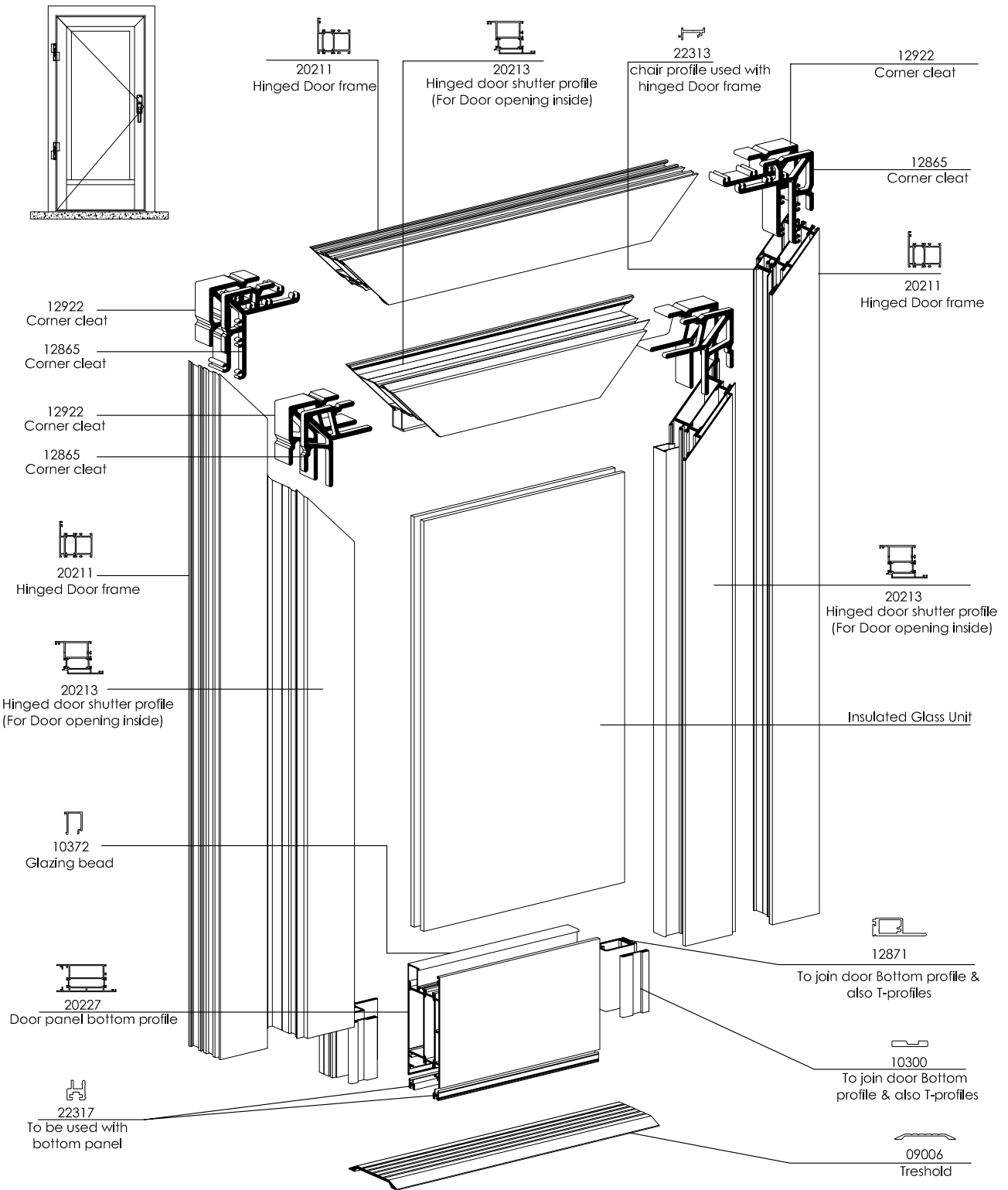
DETAIL : C-C



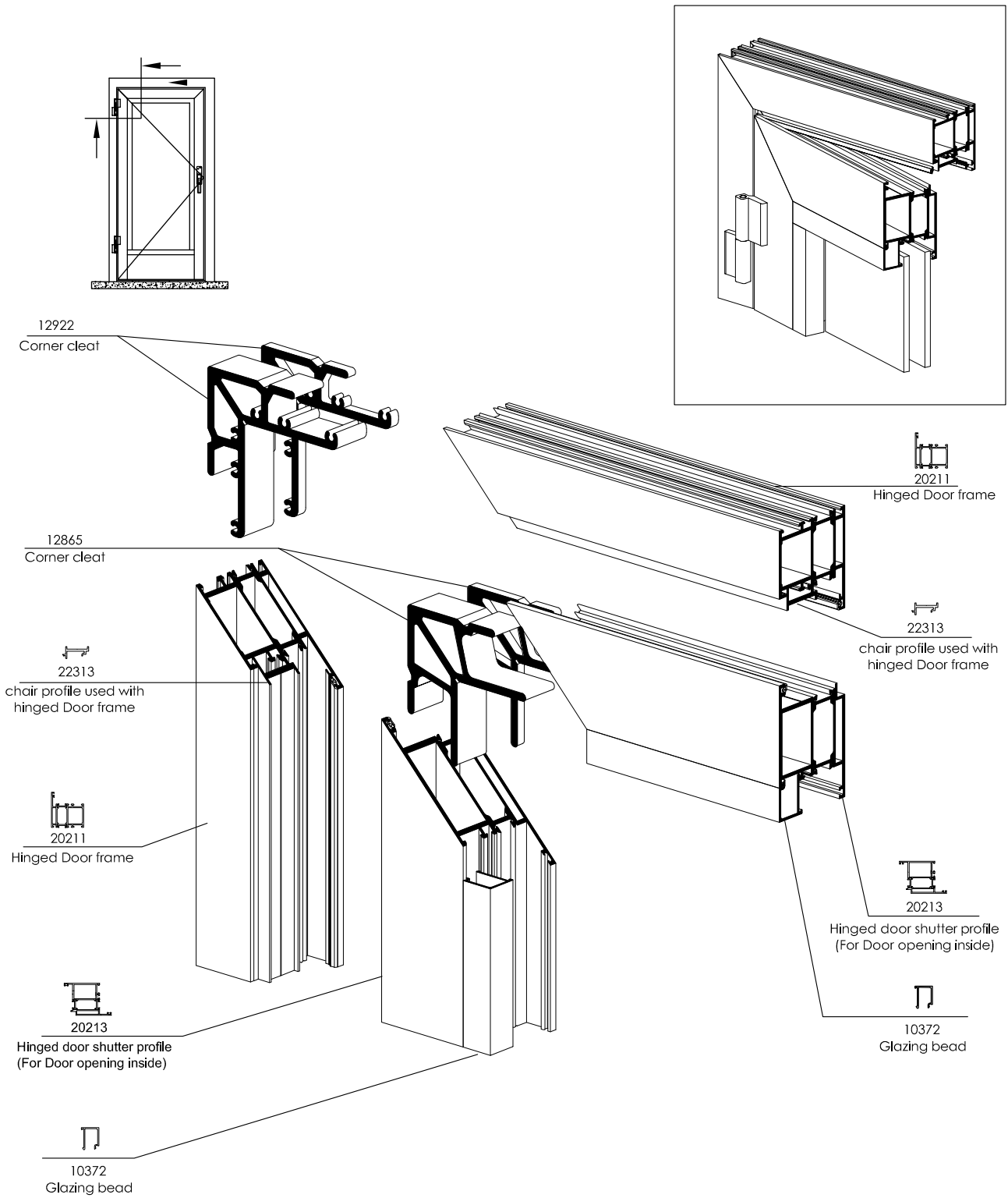
DETAIL : A-A

# 3D SECTIONS

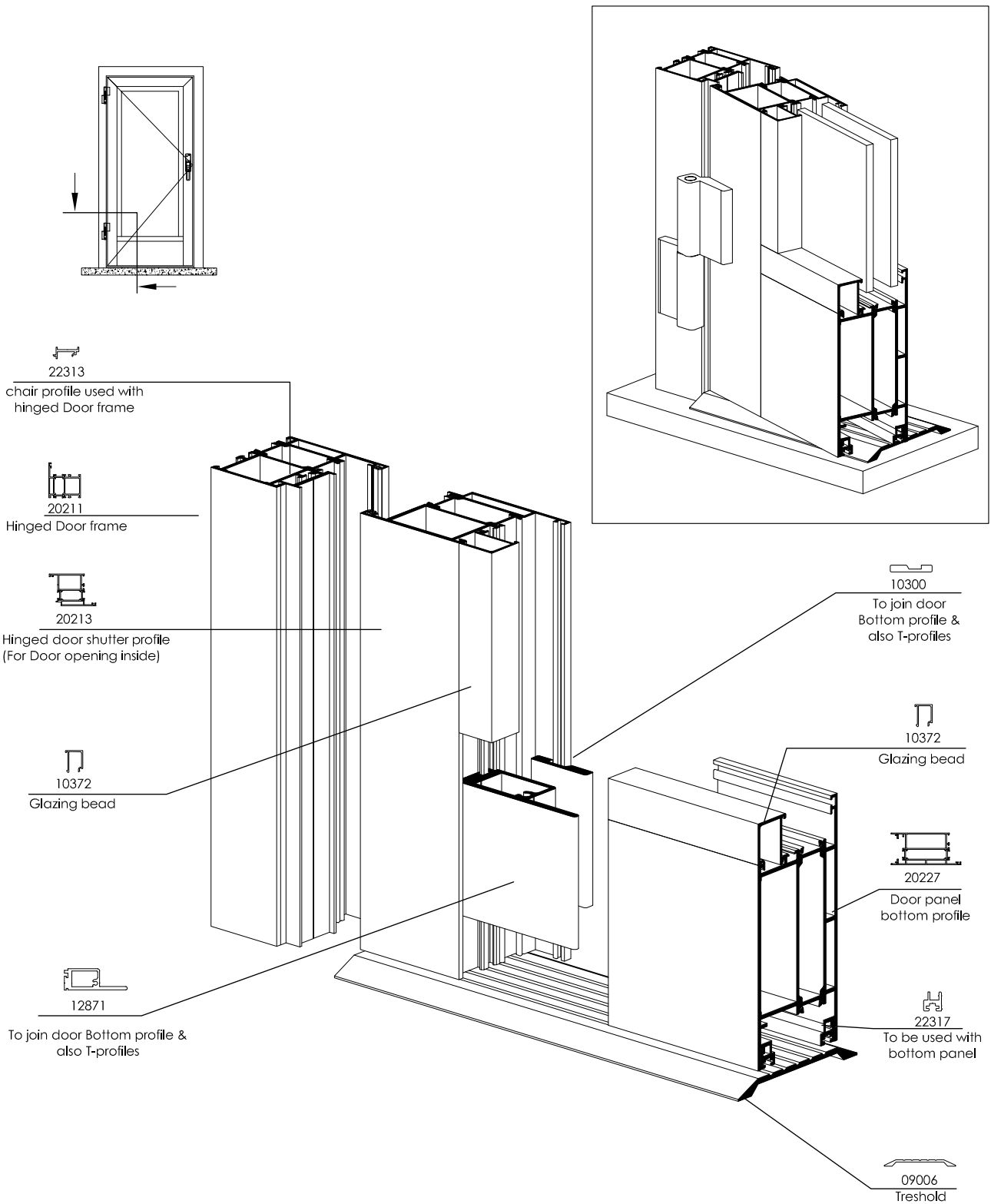
**HINGED DOOR SERIES 600**



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