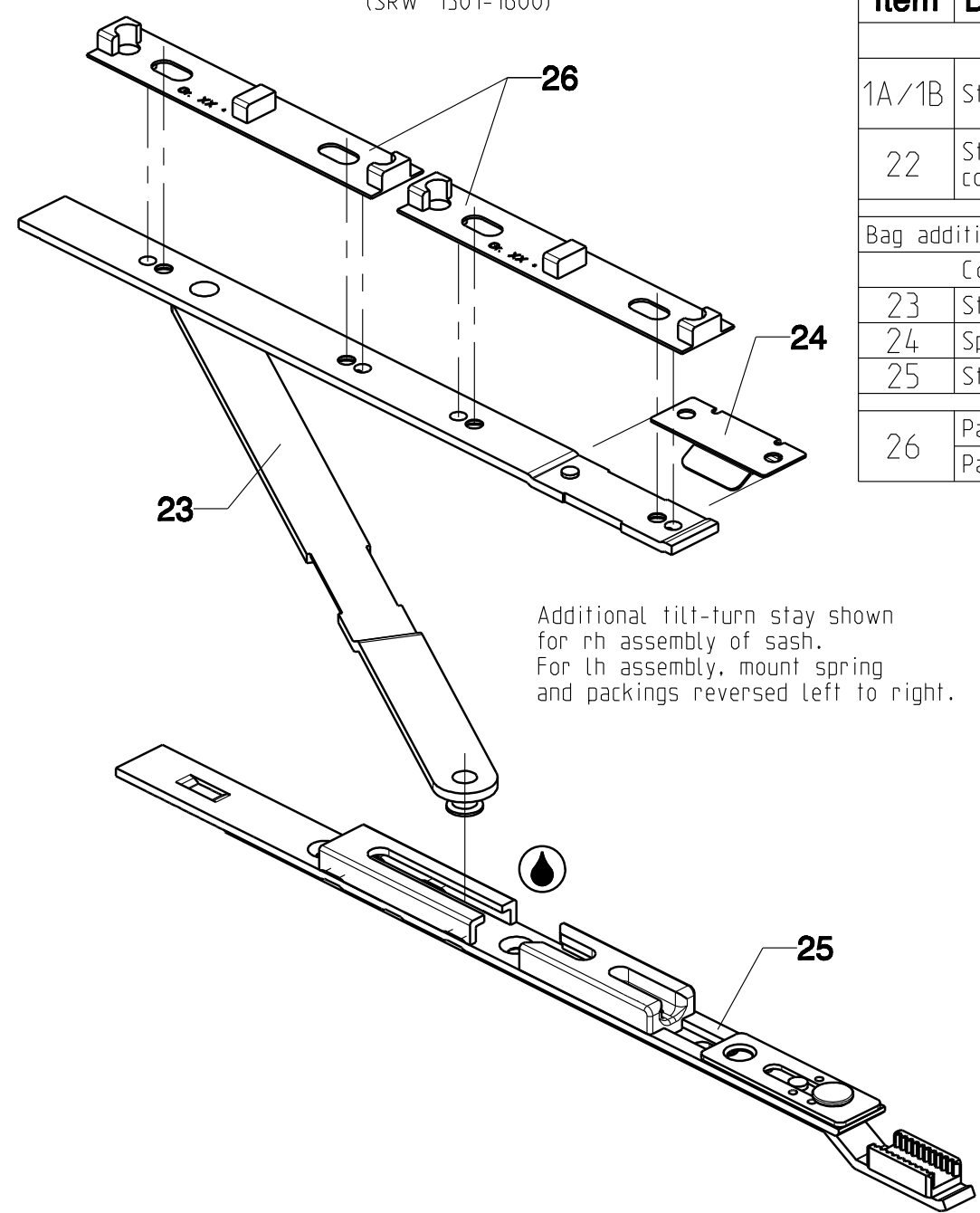
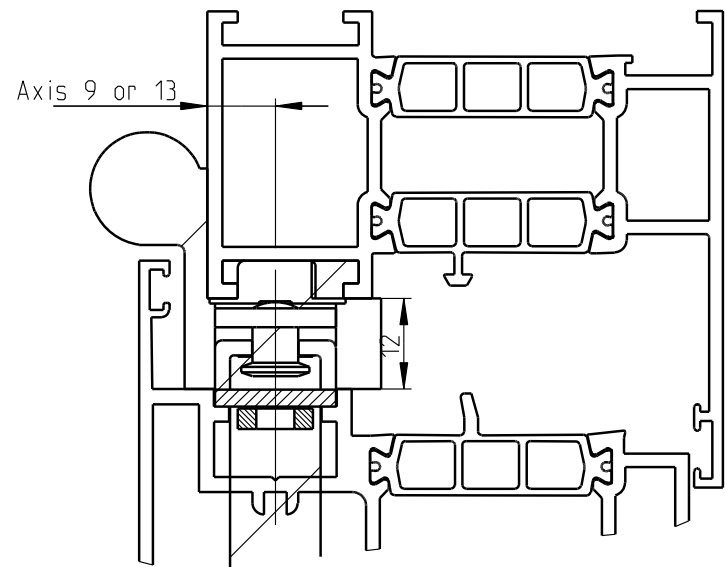


(13.) Mounting the additional stay

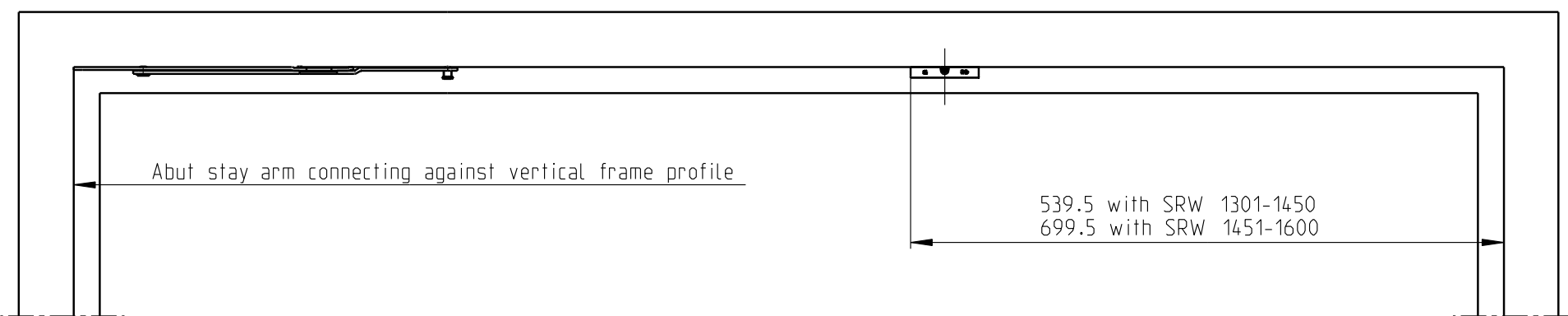
(SRW 1301-1600)



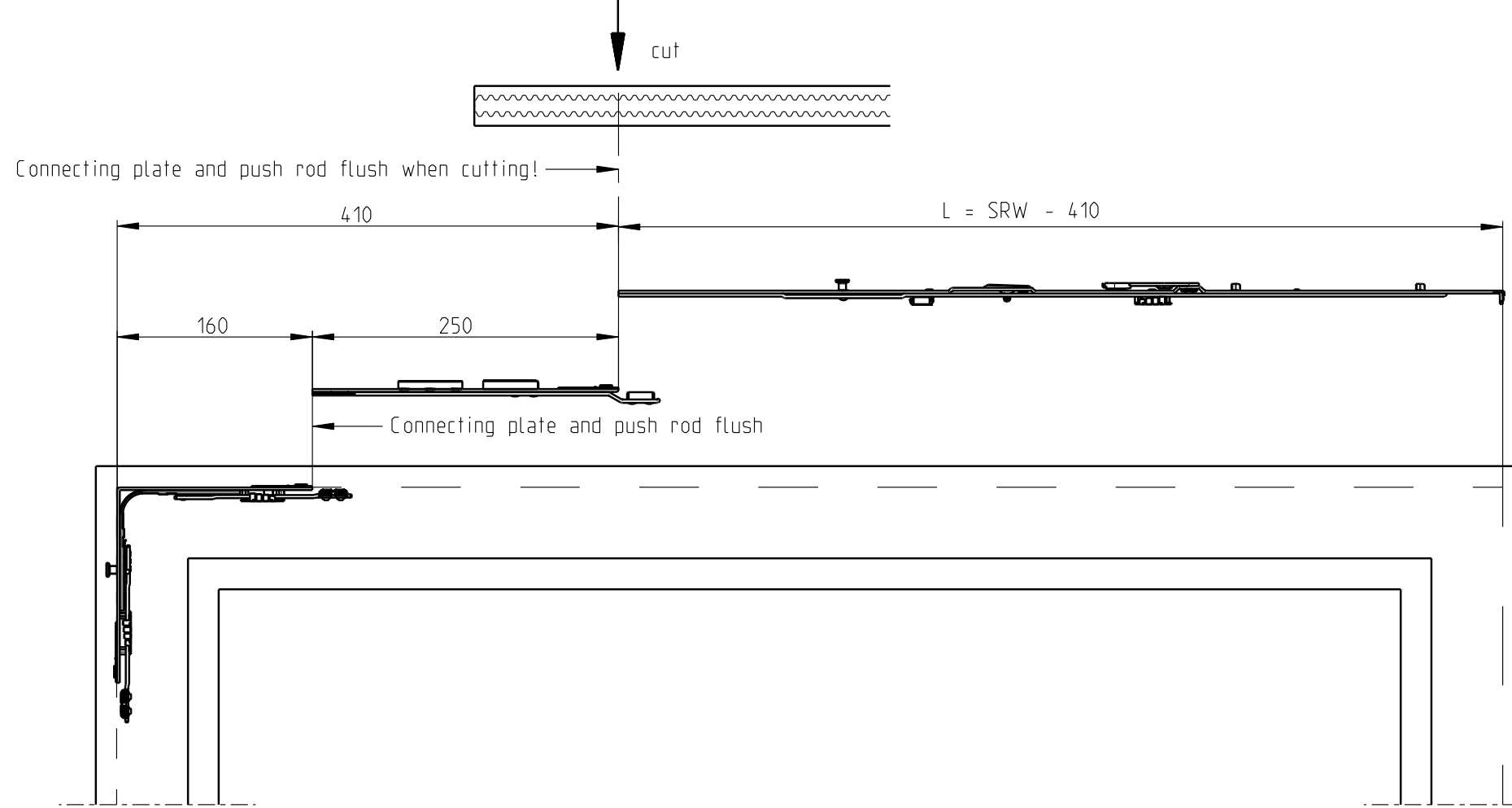
Additional tilt-turn stay shown for rh assembly of sash. For lh assembly, mount spring and packings reversed left to right.



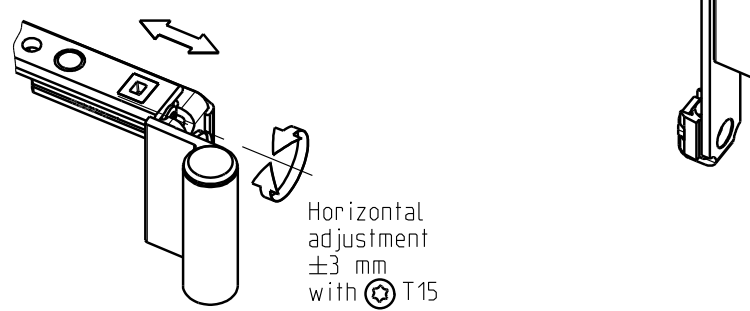
Mounting the additional stay, position of locking plates for principal stay



Cutting the stay arm connecting plate



Adjusting the stay arm



Gasket pressure adjustment  
±1 mm  
with T15

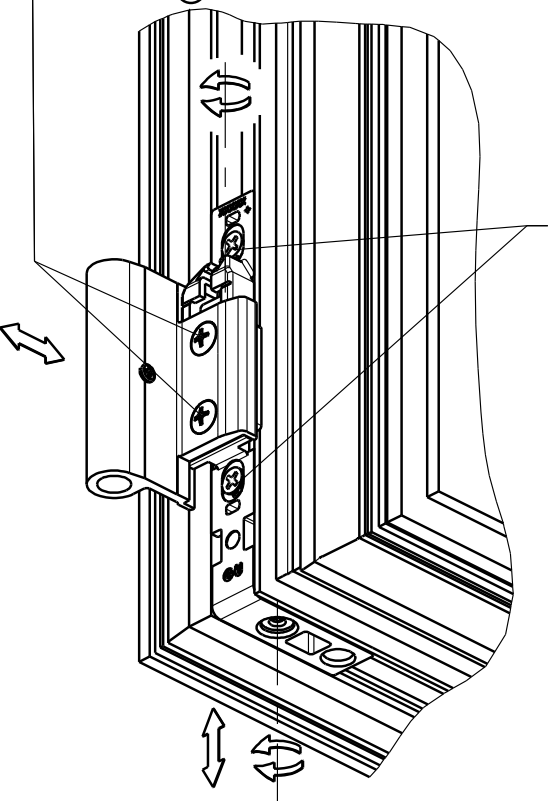
Adjusting the side hung hinge



Horizontal adjustment  
±3 mm  
with T15

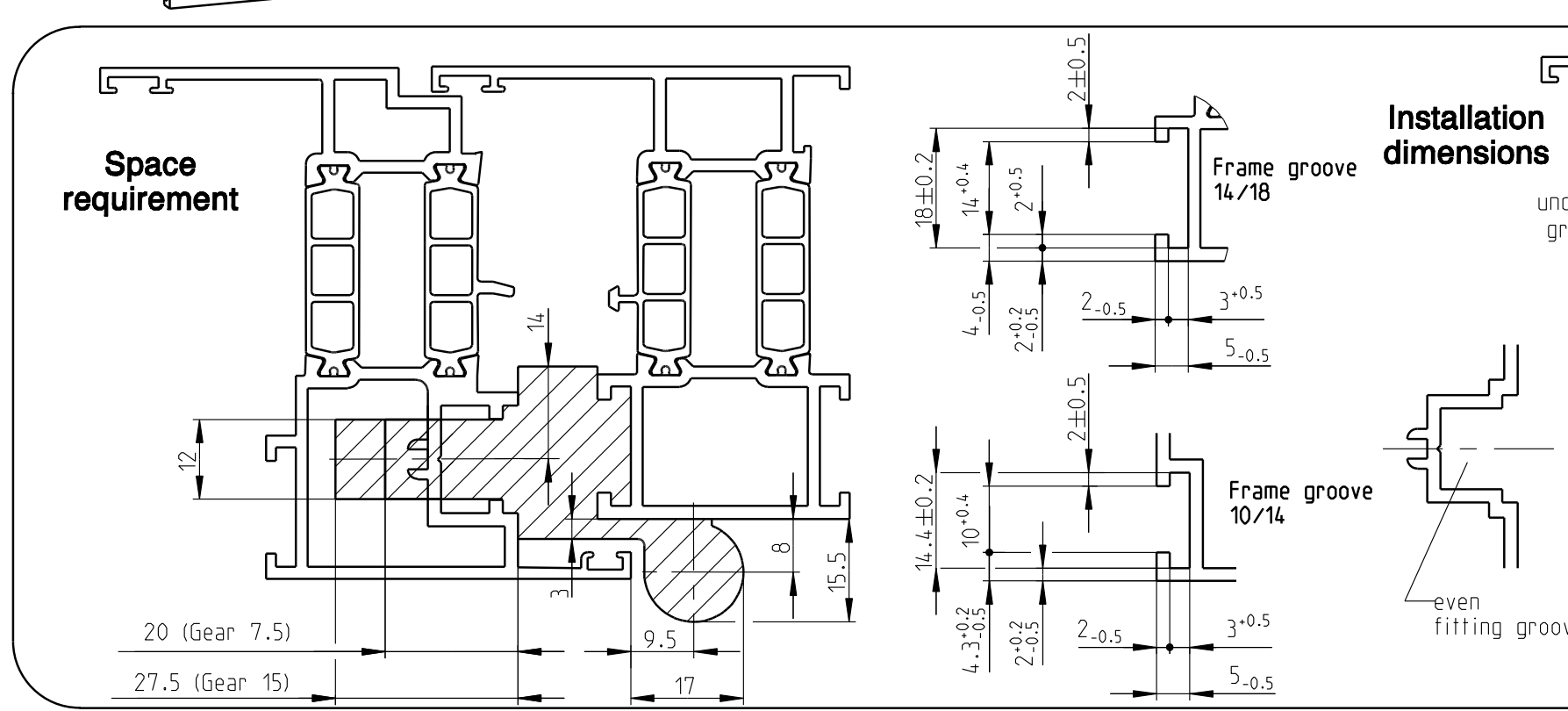
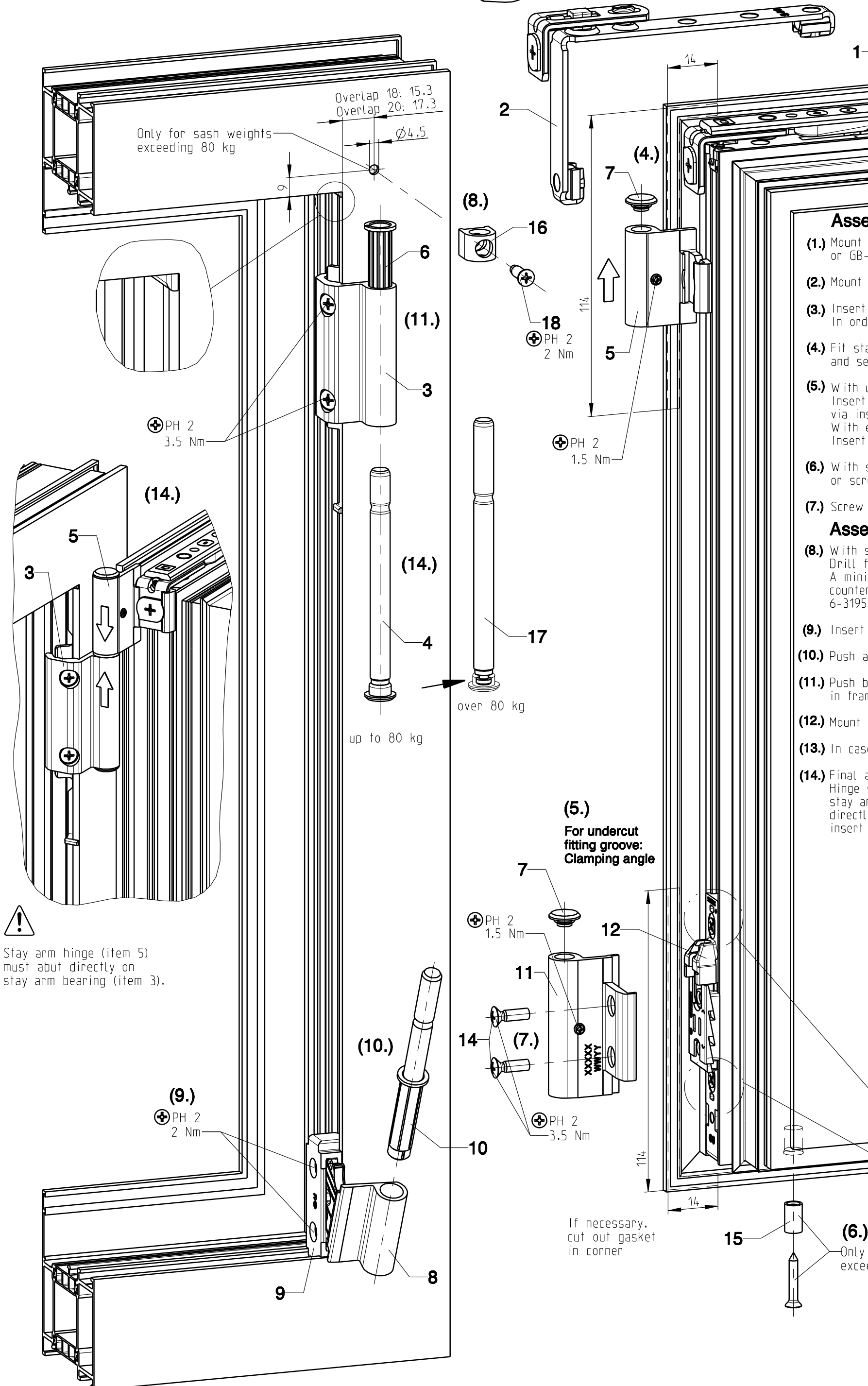
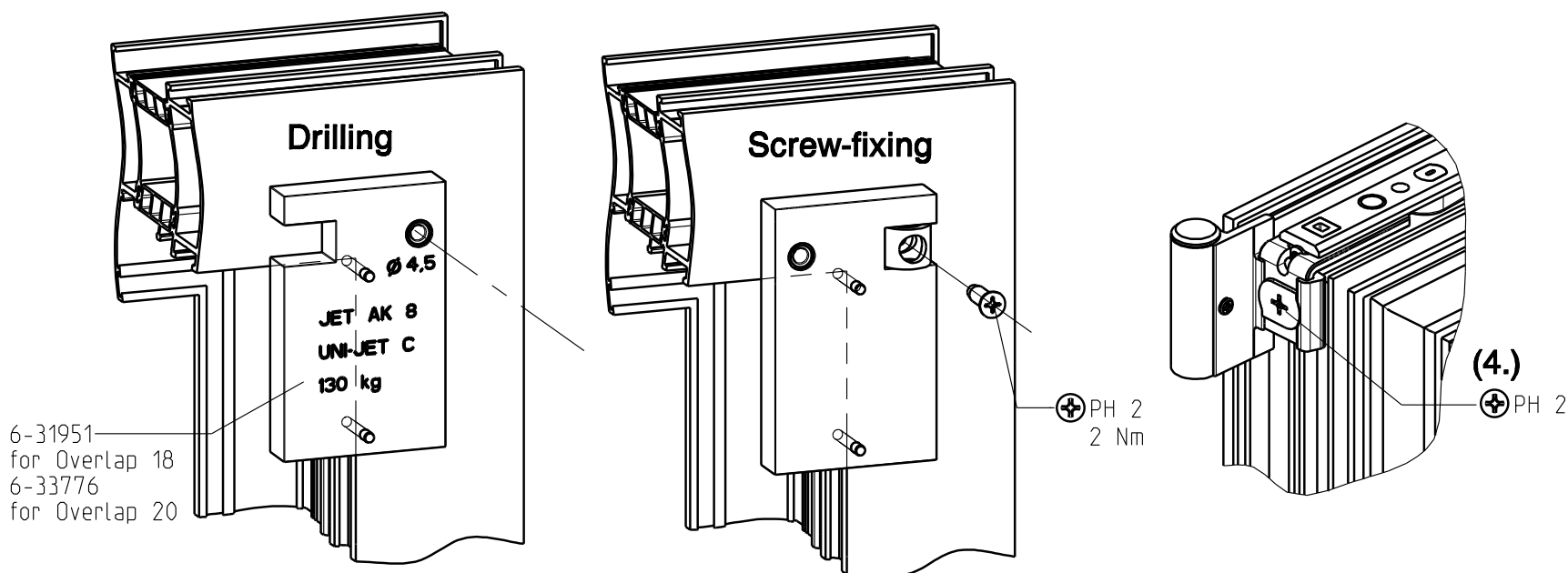
Adjusting the corner hinge

Completely unload corner hinge before adjusting. Loosen screws. Do not remove completely. Horizontal adjustment ±1 mm with T15

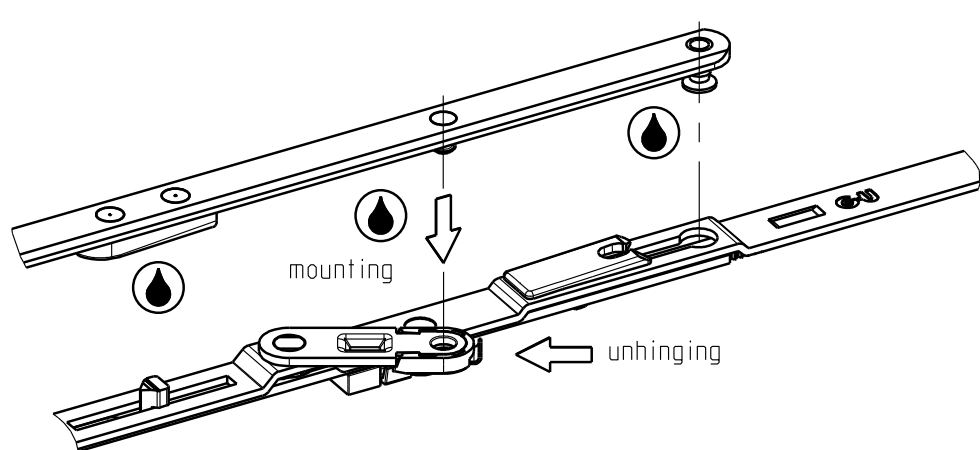


Loosen screws before adjusting. Do not remove completely. Vertical adjustment ±2 mm with T15

(8.) Drilling and fixing jig for safety device for axle 130 kg



(3.) Mounting and unhinging the stay arm

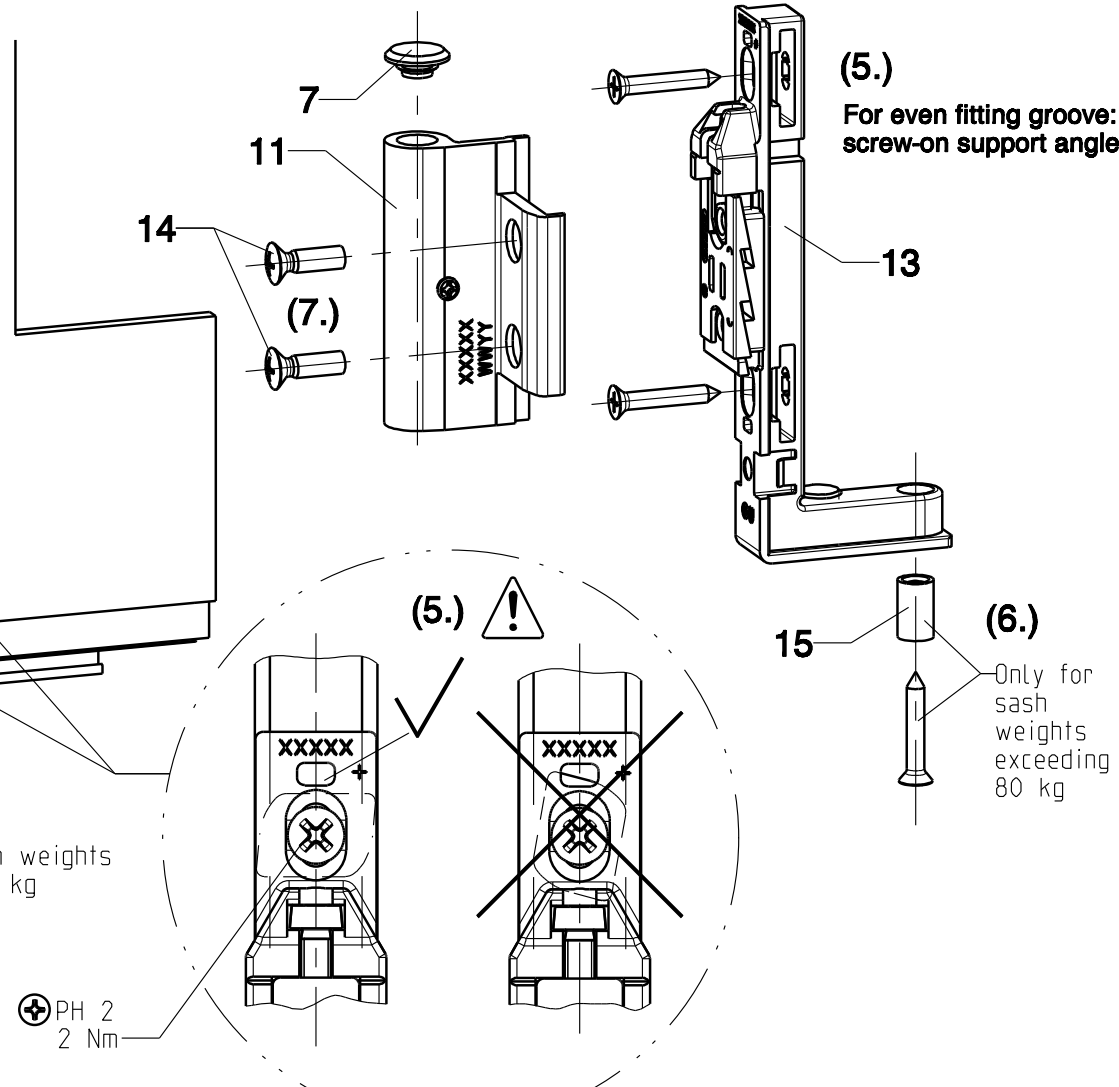


Assembly on sash

- (1) Mount locking mechanism according to working drawing GB-44324 (Tilt-turn/side hung sash) or GB-44483 (rebaté shoot bolt). With SRW 1301-1600 mount additional stay (item 25).
- (2) Mount WOSD (item 19/20) on gear forend.
- (3) Insert stay arm (item 1) in stay arm connecting plate (item 22) and clip it in the control lug. In order to check secure engagement, pull on stay arm firmly.
- (4) Fit stay arm hinge (item 5) on stay arm connecting plate (item 1) and side hung sash hinge (item 2) and secure by tightening the stay arm catch with PH2 until stop.
- (5) With undercut fitting groove: Insert and fix clamping angle (item 12) in fitting groove. Verify correct position of slot nut via inspection aperture in the clamping angle. With even fitting groove: Insert screw-on support angle (item 13) in fitting groove and fix with screws.
- (6) With sash weights over 80 kg insert bearing sleeve 130 kg (item 15) in clamping angle or screw-on support angle and screw to sash profile.
- (7) Screw on corner hinge (item 11).

Assembly on frame

- (8) With sash weights over 80 kg: Drill fixing hole Ø 4.5 (drilling and fixing jig 6-31951 for overlap 18 or 6-33776 for overlap 20). A minimum supporting thread length of 6 mm is required - if necessary, use blind rivet nut with countersunk head M5. Align and screw safety device for axle 130 kg (item 16) with drilling/fixing jig 6-31951 or 6-33776.
- (9) Insert and clamp corner bearing case (item 9) in frame groove.
- (10) Push axle (item 10) into corner bearing. Swivel corner bearing into corner bearing case (item 9).
- (11) Push bearing sleeve (item 6) into stay arm bearing (item 3). Insert and clamp stay arm bearing in frame corner.
- (12) Mount locking plates according to working drawing GB-44324 or GB-44483.
- (13) In case of SRW 1301-1600 mount stay arm (item 23) of additional stay.
- (14) Final assembly: Hinge sash by the corner bearing. Insert axle for stay arm bearing (item 4/17) from underneath through stay arm bearing (item 3) and stay arm hinge (item 5) until stop. Ensure that stay arm hinge abuts directly on stay arm bearing. Fasten threaded pins on corner hinge (item 11) and stay arm hinge (item 5). Insert covers (item 7). Function test: stay arm (item 1) must move into frame smoothly.



Range of application :

Sash rebate width SRW 280-1600  
Sash rebate height SRH 350-2800  
Max. sash weight:  
Standard: 80 kg  
With additional parts K-16595: 130 kg  
Application diagram 0-45044 must be observed.  
It is absolutely necessary to observe the product information in the GU order catalogue.

Profile manufacturers guidelines

The product guidelines of the profile manufacturer regarding construction, assembly, max. sash dimensions, max. sash weights and material qualities (e.g. longitudinal expansion) are to be observed.

Required order specifications :

Sash rebate width SRW  
Sash rebate height SRH  
Sash weight  
Assembly DIN lh or DIN rh  
Groove position  
Width of sash overlap  
Fitting groove even or undercut  
Colour of hinges

Description		Hinge side UNI-JET C		Tilt-turn, first tilt, side hung fittings		Groove position 9 mm and 13 mm		C	
Release No.	Level	Ver.	Released	Scale	Modification				
Mod. No. G27013	Ver.	--	M2	%	5				
Replacement for --	Draft	01.09.06	Bf						
						Drawing No.		0-44708-DL-0-EN	
								1/1	