

1. Anleitung für das Sägen der Profile

Die Doppelgehrungssäge ist vor Beginn der Fertigung auf ein korrektes Zuschnittergebnis anhand eines Probeschnittes in allen Ebenen des Sägeschnittes/Vorschubes zu überprüfen und ggf. einzustellen. Wärmegeädmmte Profile sollten beim Sägen der Gehrung so aufgelegt werden, dass i.d.R. die Innenschale einer Baugruppe rechtwinklig zum Sägeschnitt anliegt. So kann die Toleranzabweichung für die Funktion der Profilverbindungen, der Beschlagaufnahme und der Glasleistenaufnahme minimiert werden. Wie in den nachfolgenden Abbildungen dargestellt, sind beim Sägen je nach Anlage der Profile entsprechende Unterlagen zu verwenden. Diese Unterlagen ergeben mitunter ein Differenzmaß zum eigentlichen Zuschnittmaß und sind bei der Längeneinstellung der Säge zu berücksichtigen. Unterlagen sind in Eigenfertigung herzustellen, wenn nicht mit einer Art. Nr. kenntlich gemacht!

1. Instruction for sawing the profiles

Before starting production, the double mitre-box saw must be tested for correct cutting result by means of a test cut in all the layers of the saw cut/feed; if required, appropriate adjustments must be made. When sawing the mitre, thermally insulated profiles should be positioned in such a way that as a general rule, the inner shell of the profile is positioned at a right angle to the saw cut. Thus the tolerated variation for the function of the profile connections, the fitting housing and the glazing bead housing can be minimized. As shown in the illustrations below, appropriate shims must be used for sawing depending on the positioning point of the profile. In some cases, these shims result in a differential dimension as compared to the actual cutting to length dimension and must be taken into consideration when adjusting the saw length. Shims fabricated by self production, if not identified with an art. nr.!

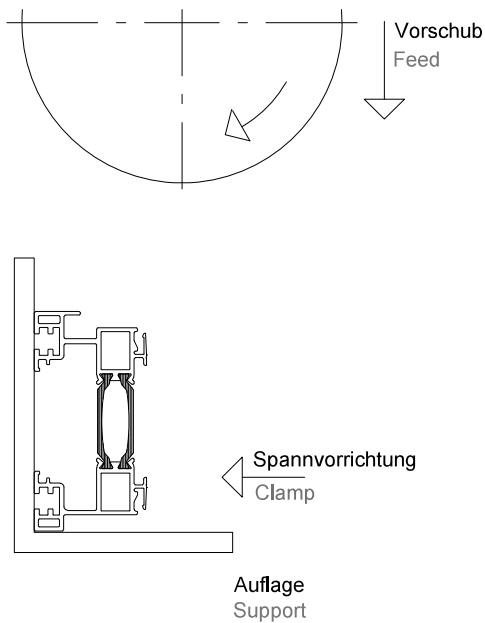


Abb. 1a
Illustration 1a

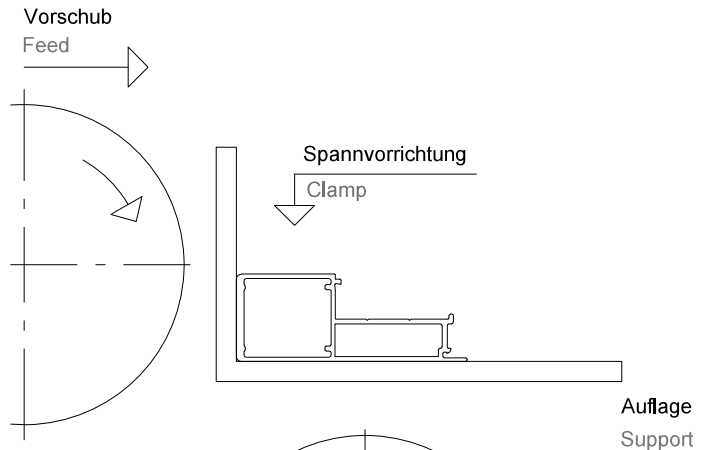


Abb. 1b
Illustration 1b

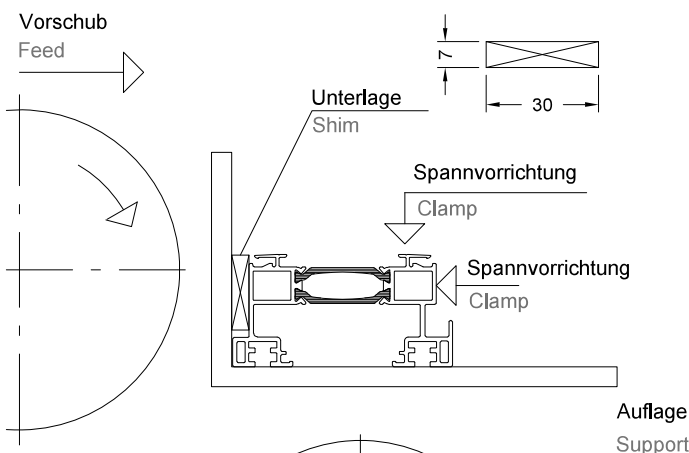
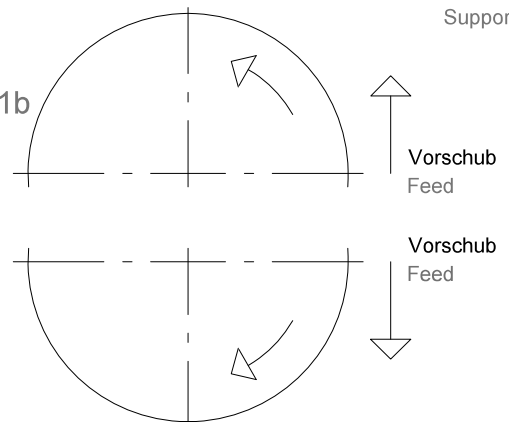


Abb. 1c
Illustration 1c

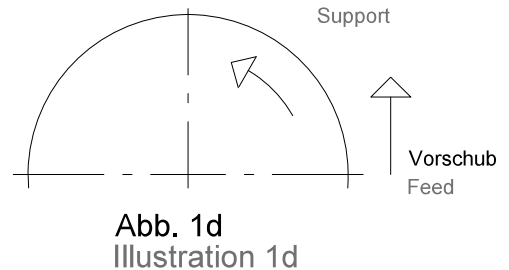
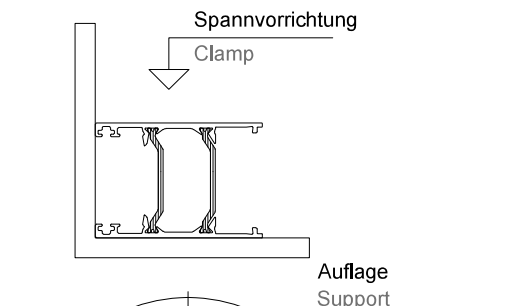
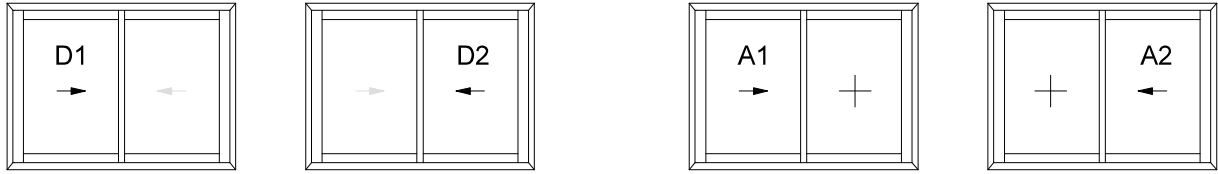


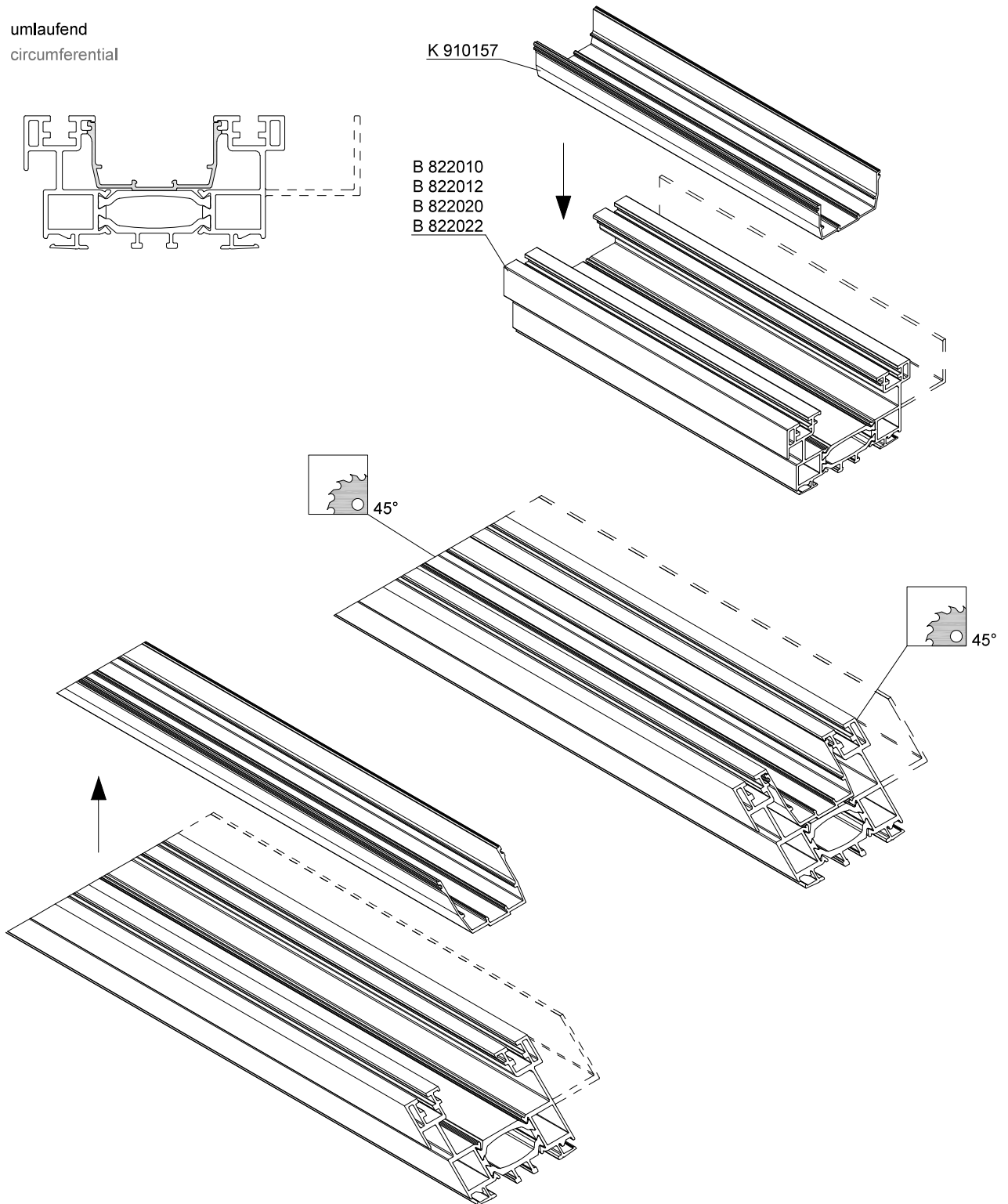
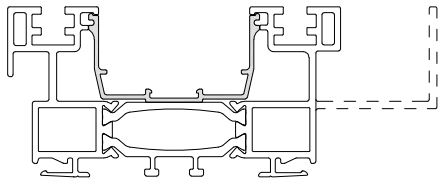
Abb. 1d
Illustration 1d



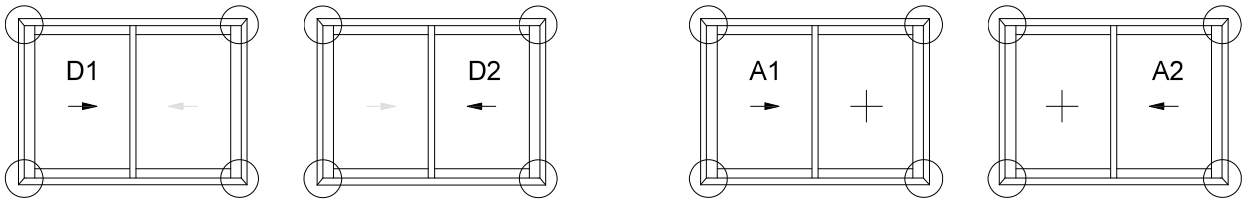
B 822010, B 822012, B 822020, B 822022

K 910157

umlaufend
 circumferential



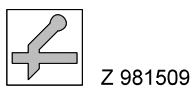
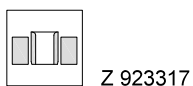
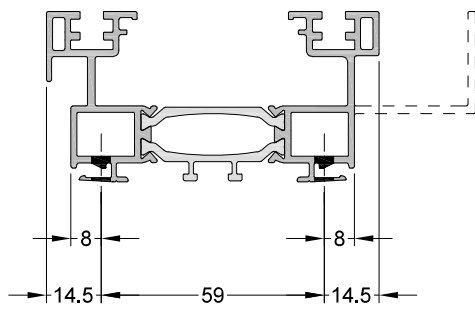
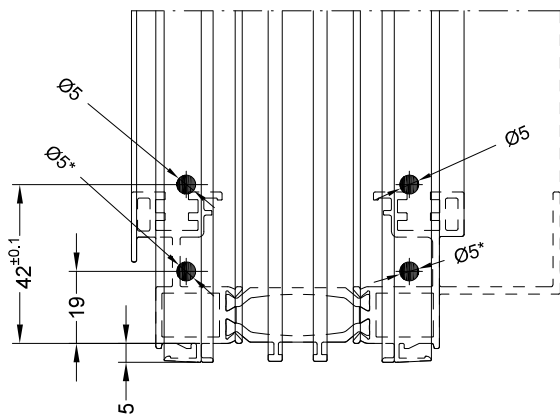
RAHMENBEARBEITUNG
 FRAME PROCESSING



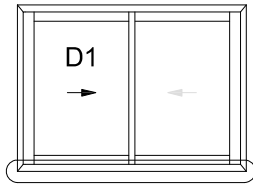
B 822010, B 822012, B 822020, B 822022

* Bohrung wahlweise,
 für nachträgliche Verklebung

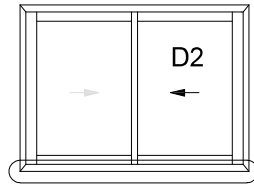
* drilling optional,
 for retro gluing after assembly



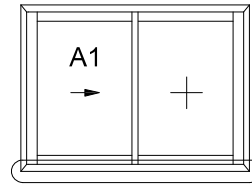
RAHMENBEARBEITUNG
 FRAME PROCESSING



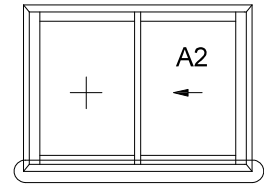
Schema D1 dargestellt
 Schema D1 shown



Schema D2 spiegelbildlich
 Schema D2 mirror-inverted

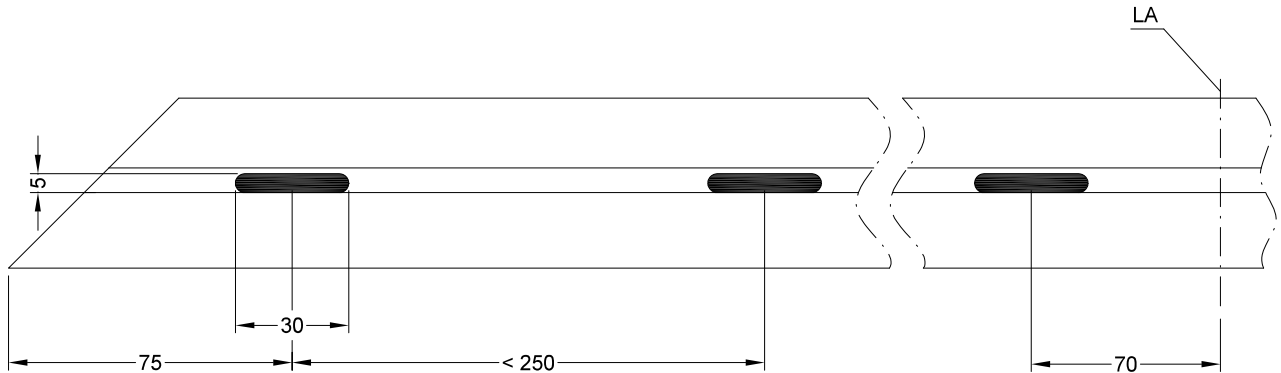


Schema A1 dargestellt
 Schema A1 shown

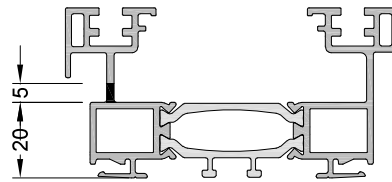


Schema A2 spiegelbildlich
 Schema A2 mirror-inverted

B 822010, B 822012, B 822020, B 822022



Z 981511

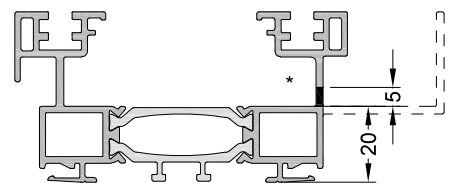
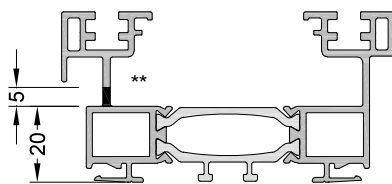
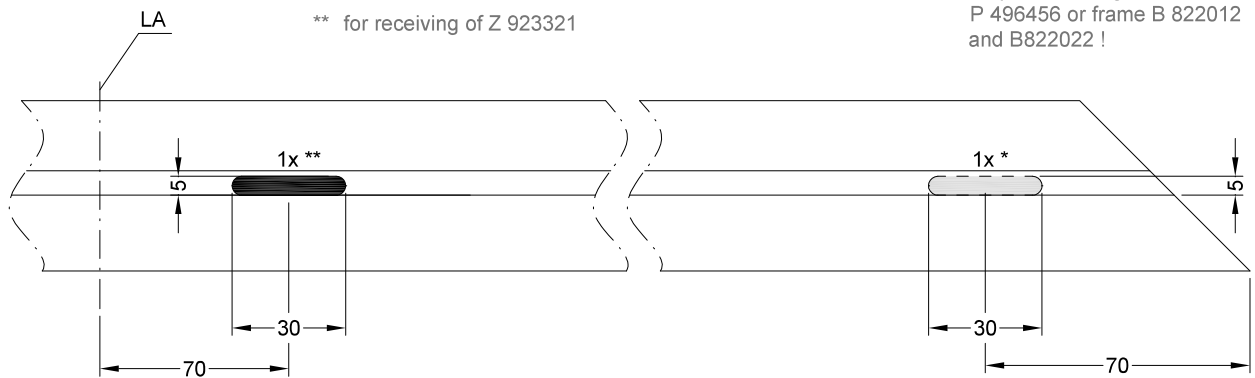


** Zur Aufnahme von Z 923321

** for receiving of Z 923321

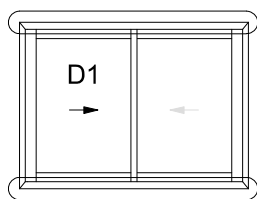
* Nur bei der Verwendung vom
 Wetterschenkel P 496456 oder
 Rahmen B 822012 und B822022 !

* only when using water bar
 P 496456 or frame B 822012
 and B822022 !

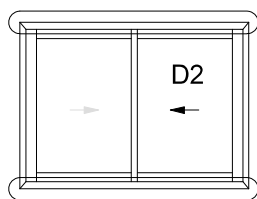


Z 981511

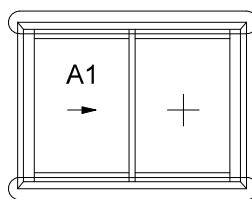
RAHMENBEARBEITUNG
 FRAME PROCESSING



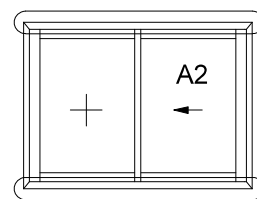
Schema D1 dargestellt
 Schema D1 shown



Schema D2 spiegelbildlich
 Schema D2 mirror-inverted

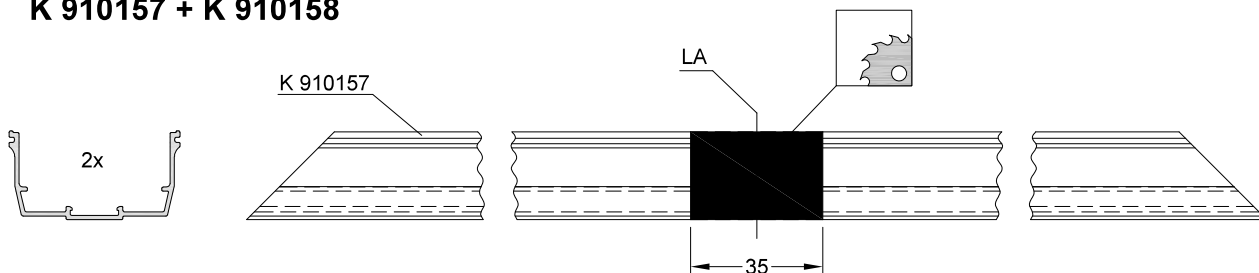


Schema A1 dargestellt
 Schema A1 shown

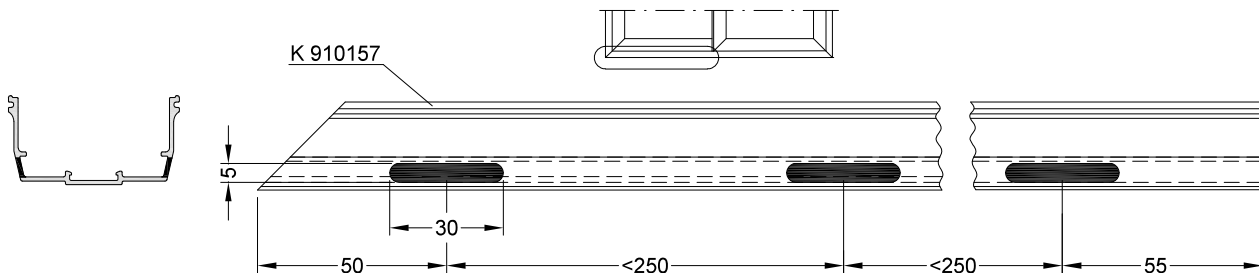


Schema A2 spiegelbildlich
 Schema A2 mirror-inverted

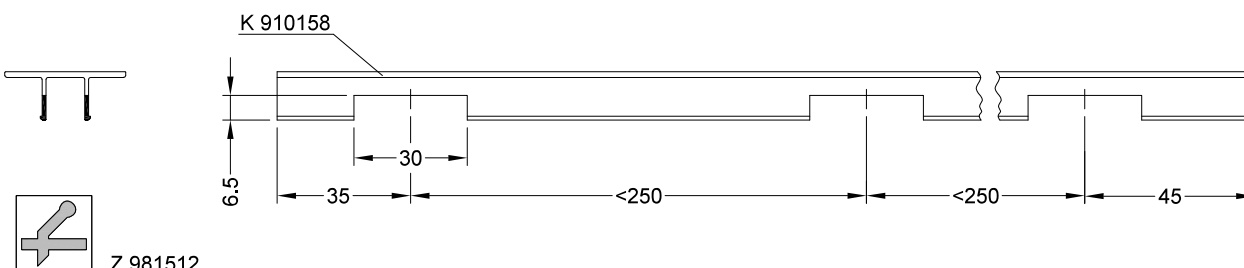
K 910157 + K 910158



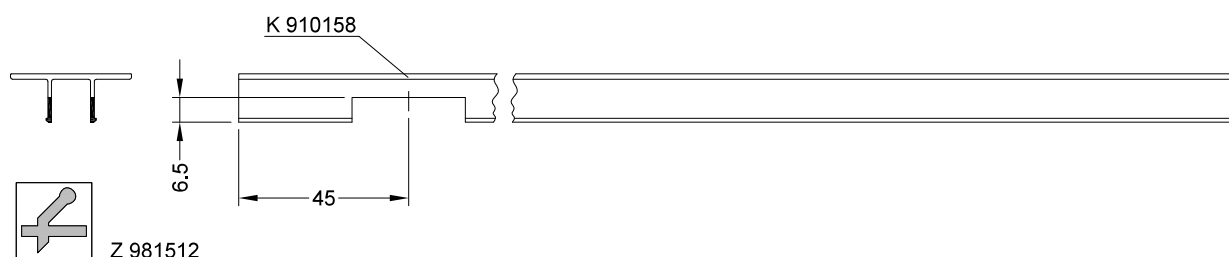
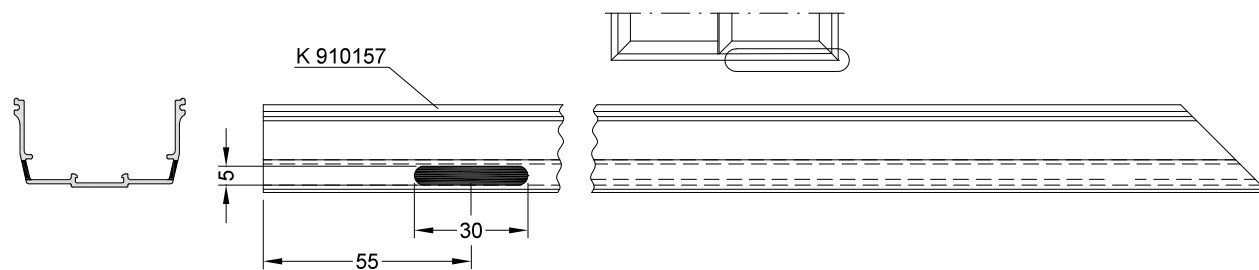
Schema A1/D1 dargestellt Schema A2/D2 spiegelbildlich
 Schema A1/D1 shown Schema A2/D2 mirror-inverted



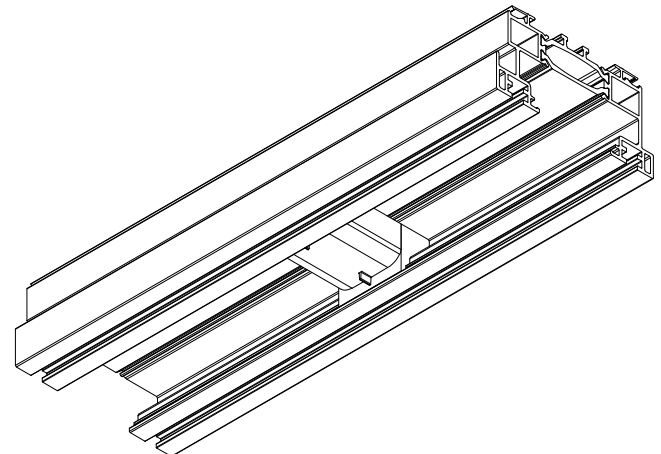
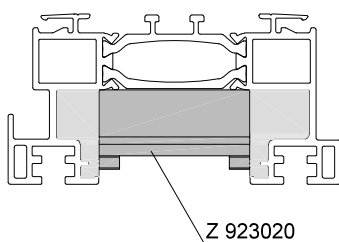
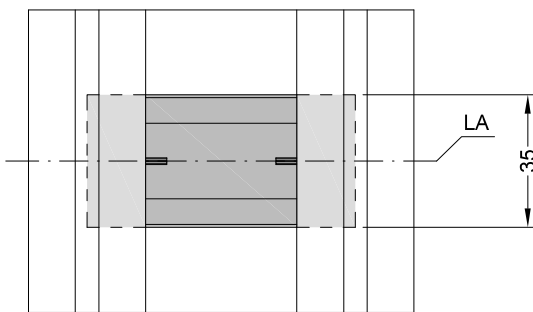
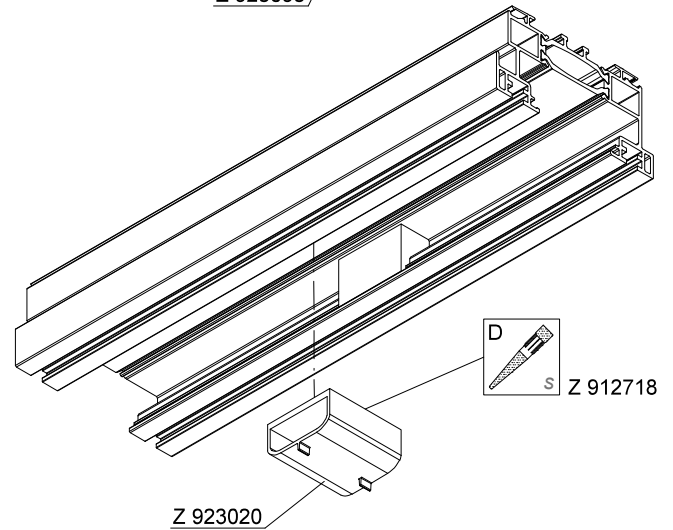
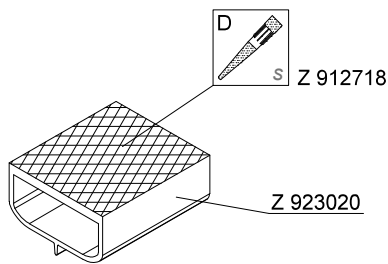
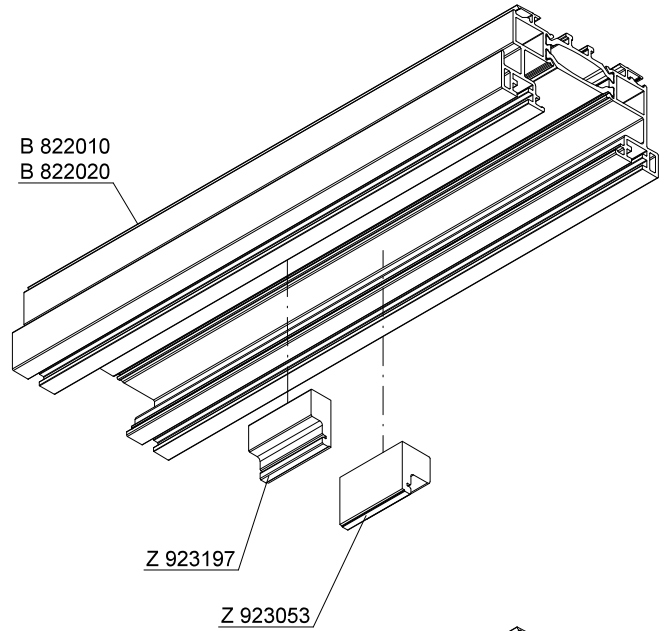
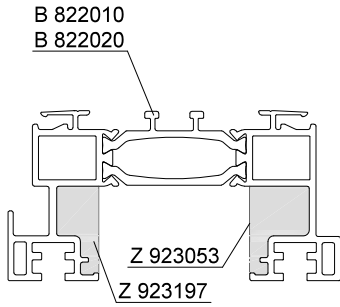
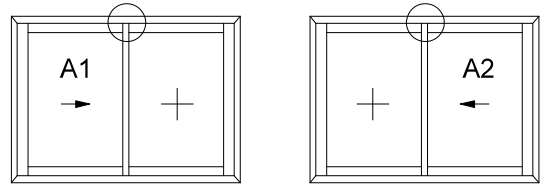
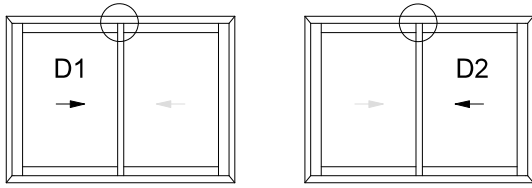
Schema A1/D1 dargestellt Schema A2/D2 spiegelbildlich
 Schema A1/D1 shown Schema A2/D2 mirror-inverted



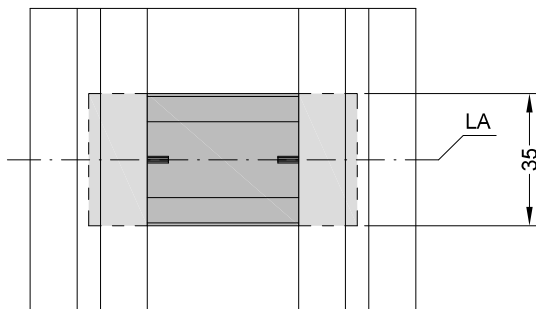
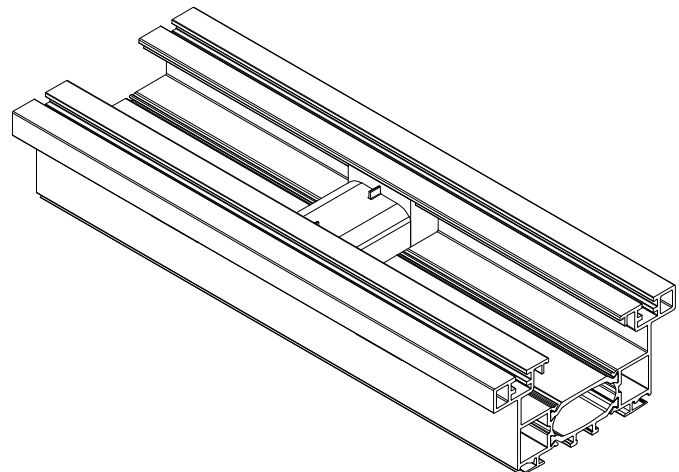
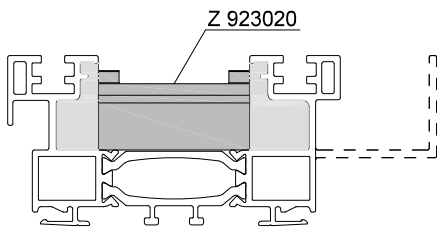
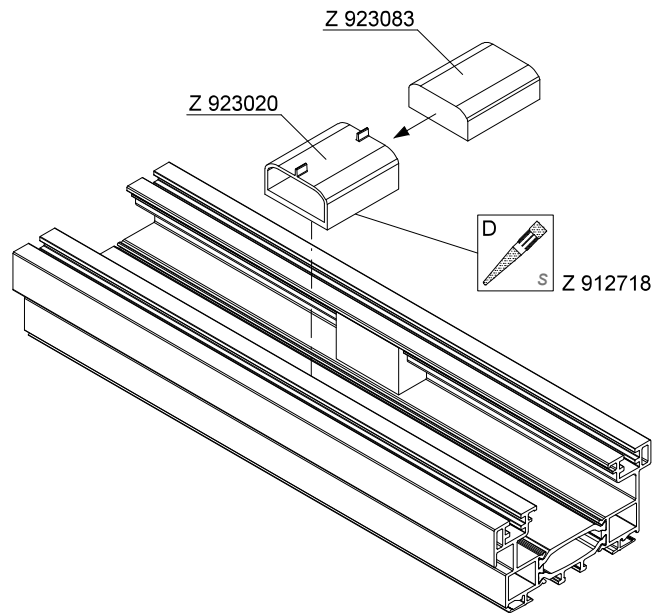
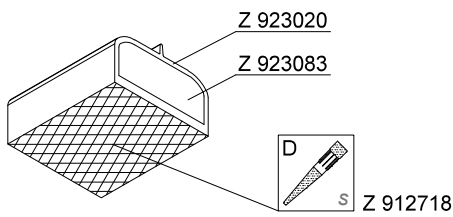
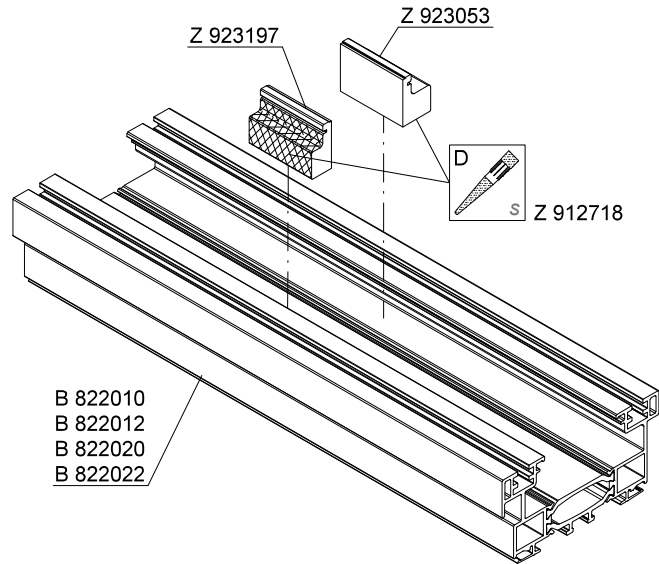
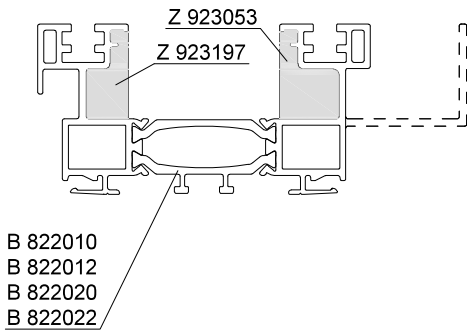
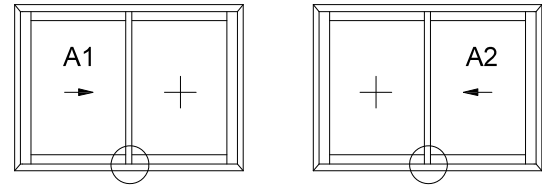
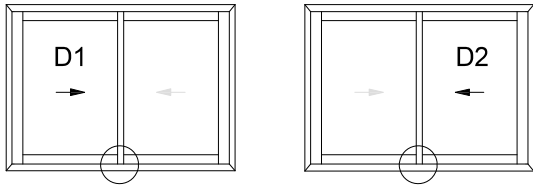
Schema A1/D1 dargestellt Schema A2/D2 spiegelbildlich
 Schema A1/D1 shown Schema A2/D2 mirror-inverted



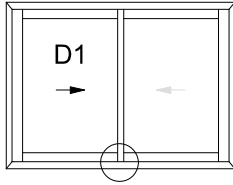
RAHMENMONTAGE
 FRAME ASSEMBLY



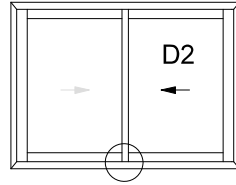
RAHMENMONTAGE
 FRAME ASSEMBLY



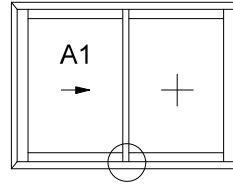
RAHMENMONTAGE
 FRAME ASSEMBLY



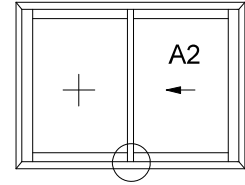
Schema D1 dargestellt
 Schema D1 shown



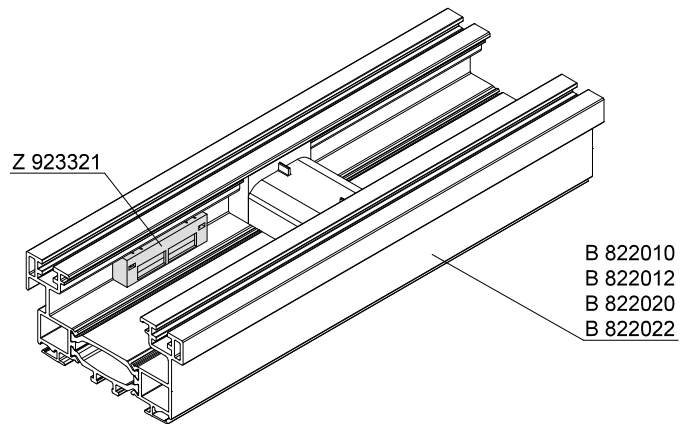
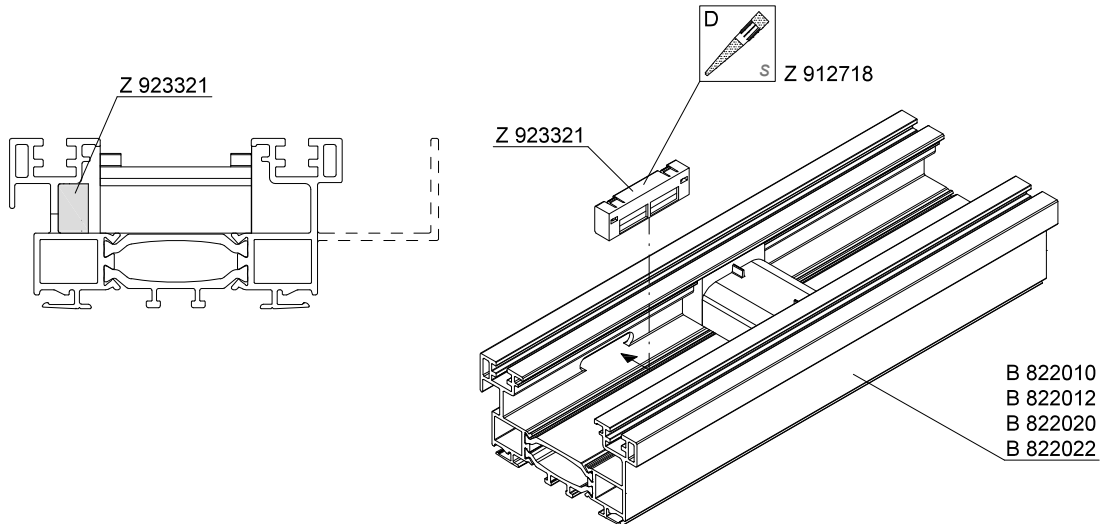
Schema D2 spiegelbildlich
 Schema D2 mirror-inverted



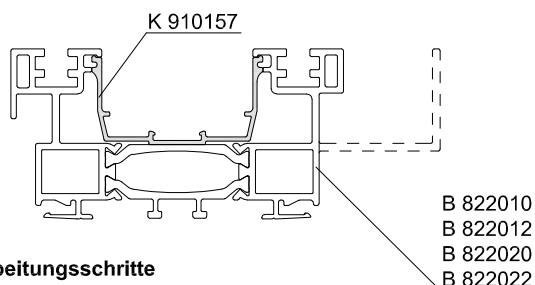
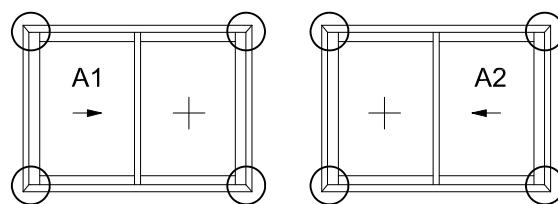
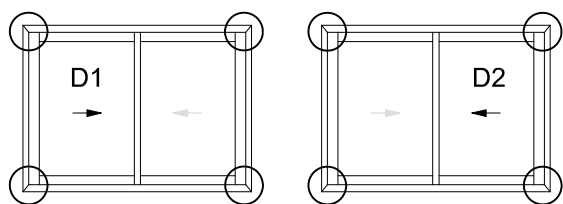
Schema A1 dargestellt
 Schema A1 shown



Schema A2 spiegelbildlich
 Schema A2 mirror-inverted



RAHMENMONTAGE
 FRAME ASSEMBLY

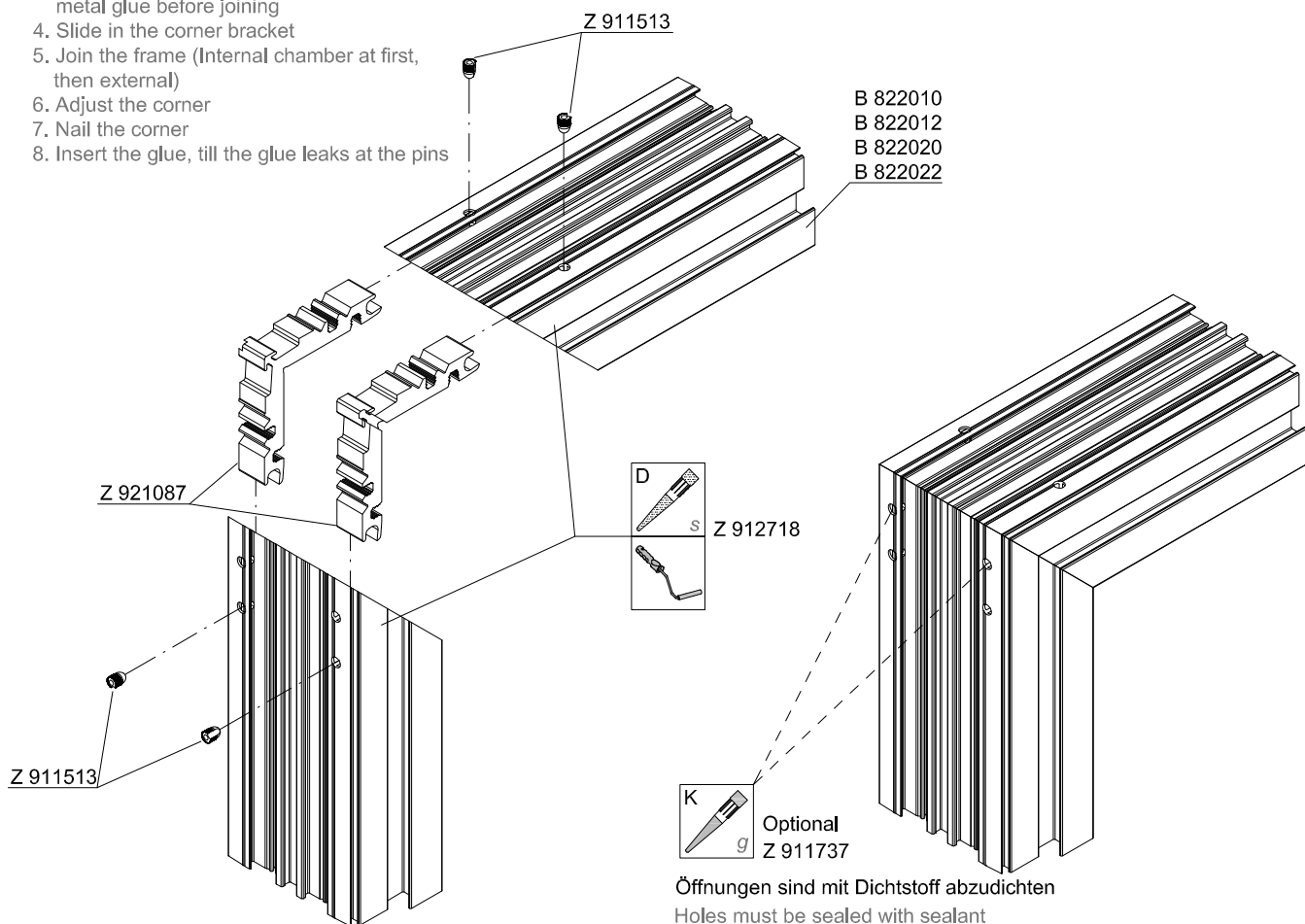
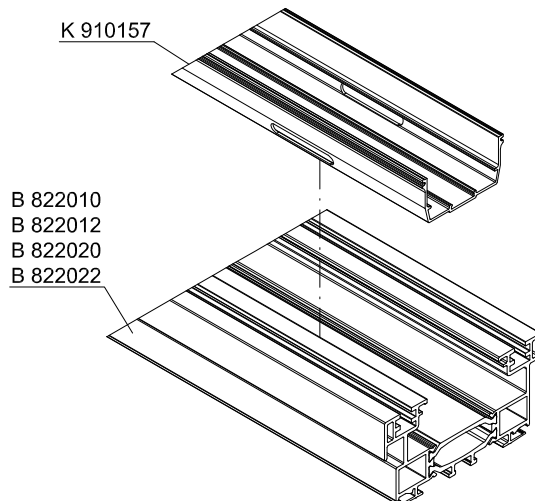


Bearbeitungsschritte

1. K 910157 umlaufend eindrücken
2. Schnittflächen versiegeln
3. Falls keine nachträgliche Verklebung vorgesehen ist, müssen vor dem Fügen alle Profillinienflächen im Eckbereich mit HUECK Metallkleber bestrichen werden
4. Eckverbinder einschieben
5. Rahmen fügen (erst Innen-, dann Außenkammer)
6. Ecke ausrichten
7. Ecke verstiften
8. Kleber einspritzen, bis der Kleber an den Stiften austritt

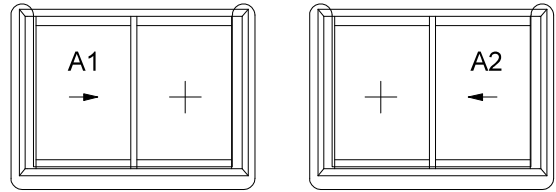
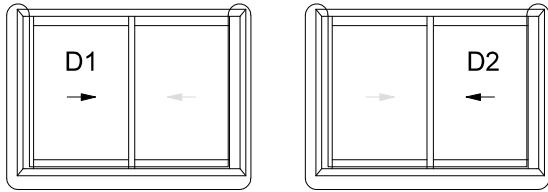
Processing steps

1. Insert K 910157 circumferential
2. Seal the cut surfaces
3. If there is no subsequent gluing planned, all inner profile surfaces at the corner area must be applied with HUECK metal glue before joining
4. Slide in the corner bracket
5. Join the frame (Internal chamber at first, then external)
6. Adjust the corner
7. Nail the corner
8. Insert the glue, till the glue leaks at the pins

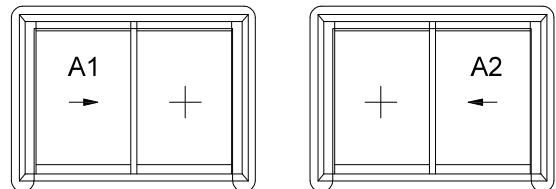
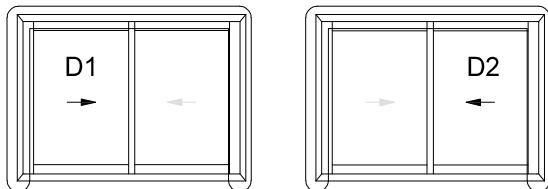
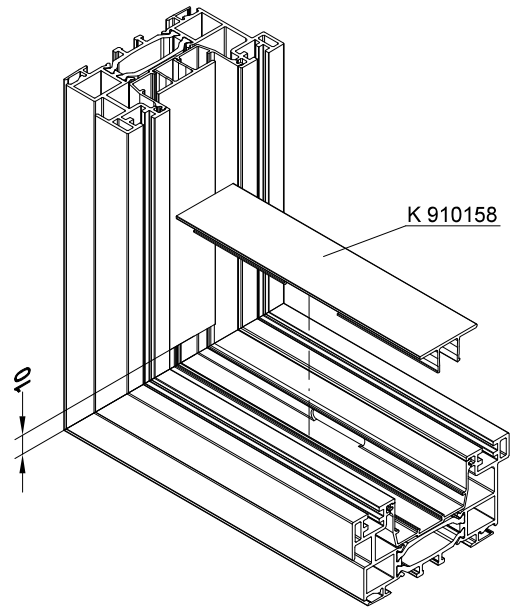
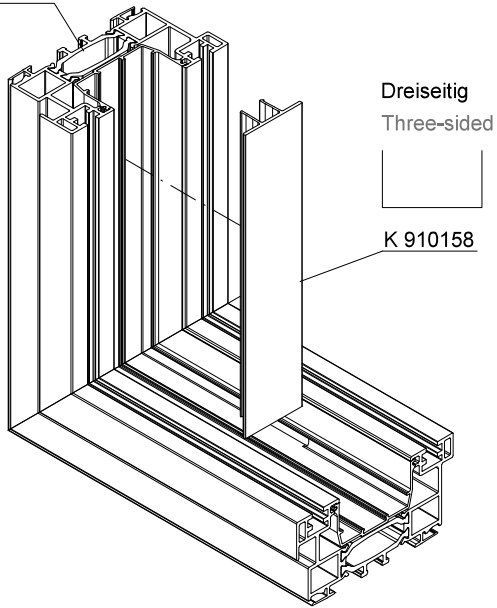


Öffnungen sind mit Dichtstoff abzudichten
 Holes must be sealed with sealant

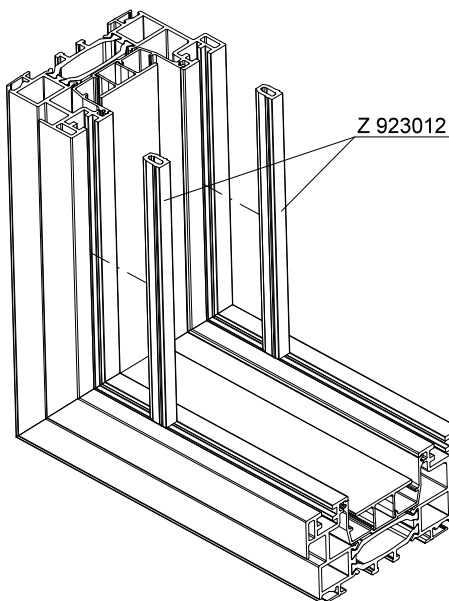
RAHMENMONTAGE
 FRAME ASSEMBLY



B 822010
 B 822012
 B 822020
 B 822022



Dreiseitig
 Three-sided



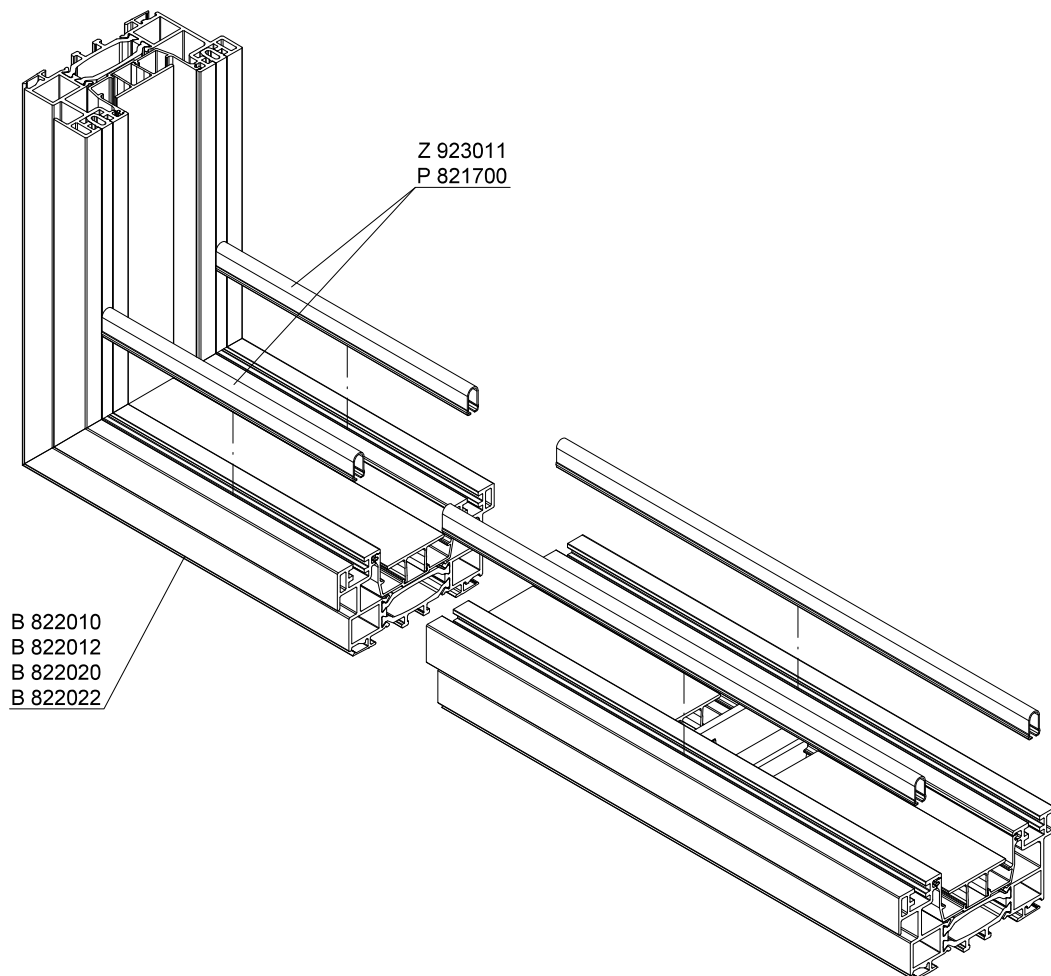
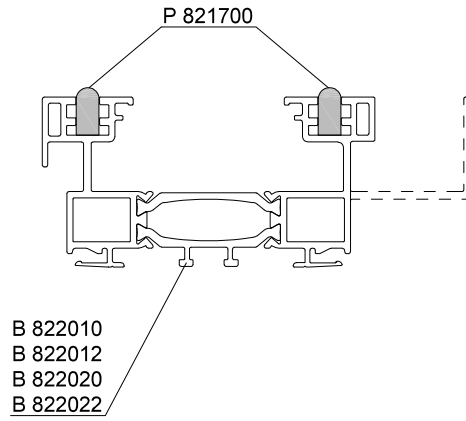
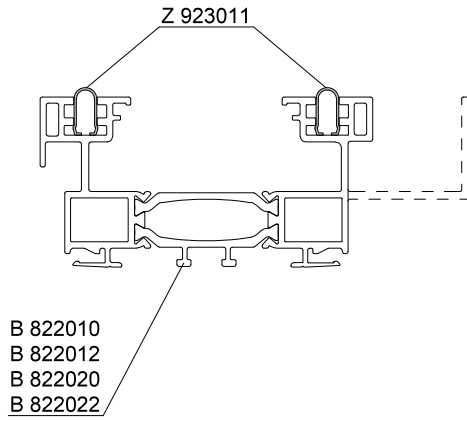
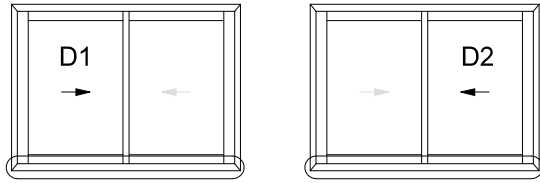
Bearbeitungsschritte

1. Schließteile einbauen und positionieren (siehe Kapitel Beschlagenbau)
2. Dichtungen einziehen

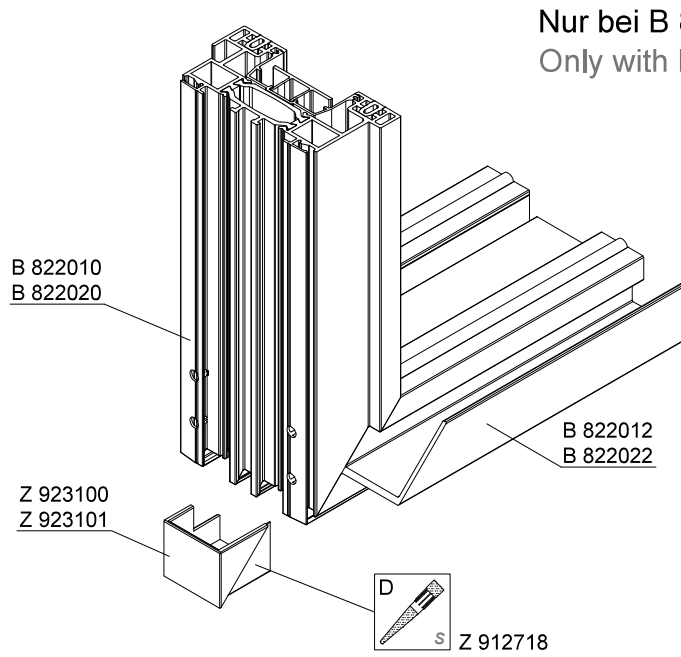
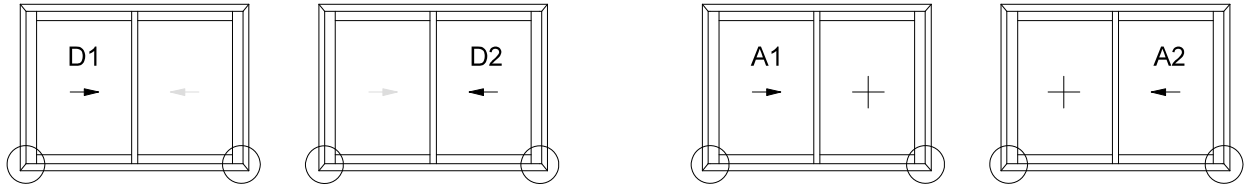
Processing steps

1. Install and position the locking parts (see chapter fitting installation)
2. Insert the gaskets

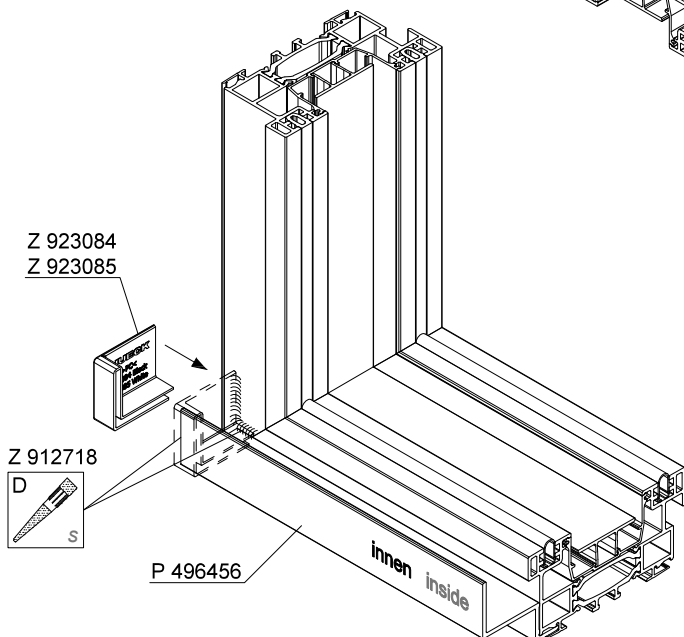
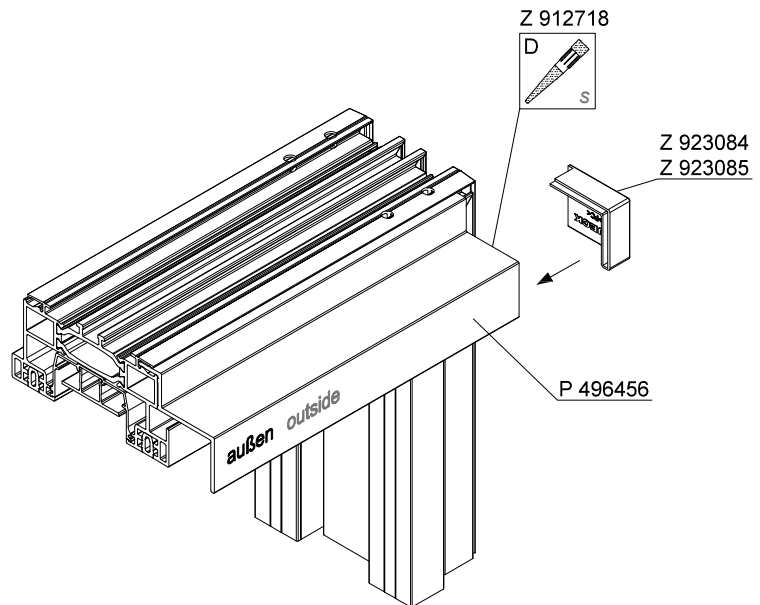
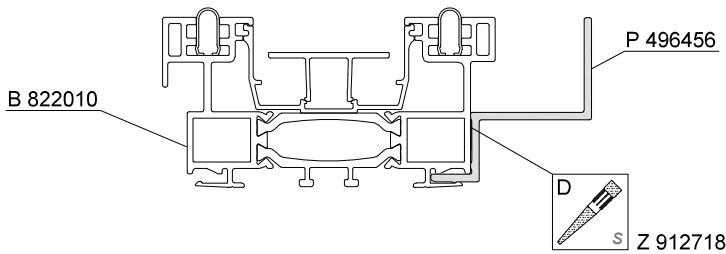
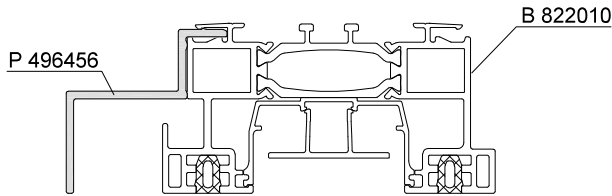
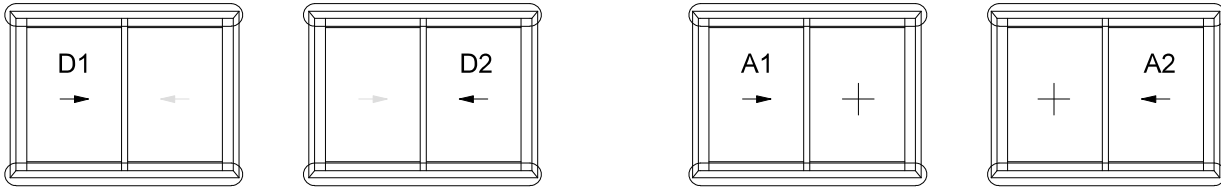
RAHMENMONTAGE
FRAME ASSEMBLY



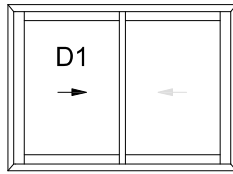
RAHMENMONTAGE
 FRAME ASSEMBLY



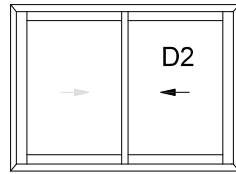
RAHMENMONTAGE
 FRAME ASSEMBLY



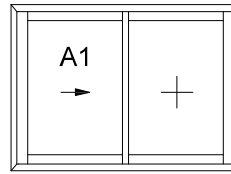
FLÜGELMONTAGE
 SASH ASSEMBLY



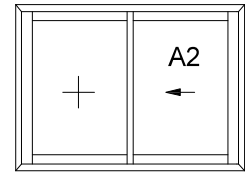
Schema D1 dargestellt
 Scheme D1 shown



Schema D2 spiegelbildlich
 Scheme D2 mirror-inverted



Schema A1 dargestellt
 Scheme A1 shown



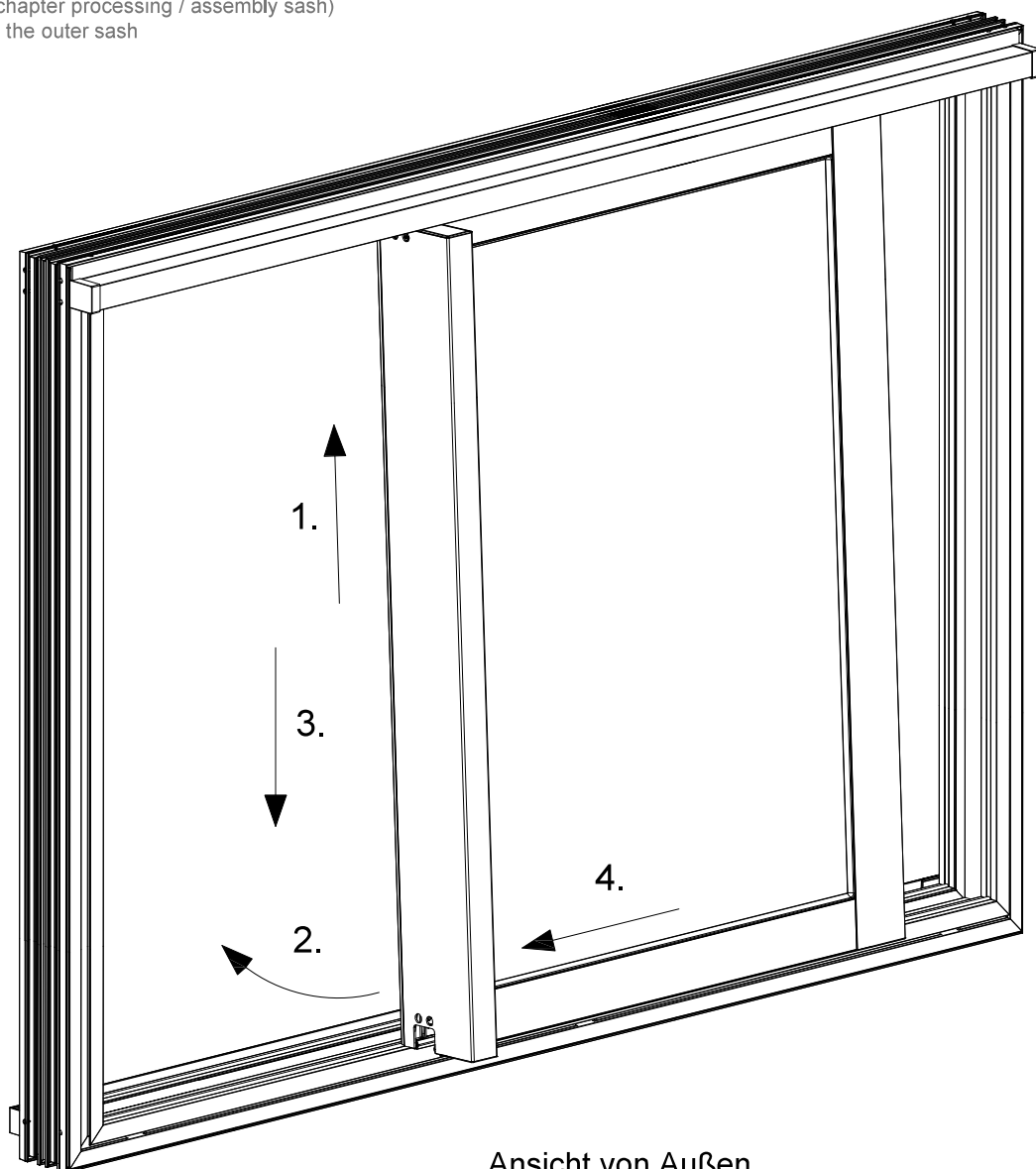
Schema A2 spiegelbildlich
 Scheme A2 mirror-inverted

Bearbeitungsschritte

1. Äußeren Flügel montieren
 (Siehe Kapitel Verarbeitung / Montage Flügel)
2. Äußeren Flügel einhängen

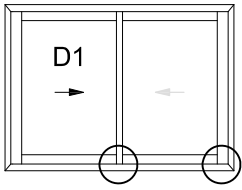
Processing steps

1. Assemble the outer sash
 (see chapter processing / assembly sash)
2. Insert the outer sash

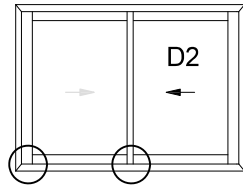


Ansicht von Außen
 Outside view

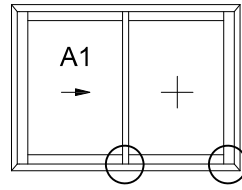
FLÜGELMONTAGE
 SASH ASSEMBLY



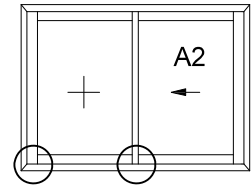
Schema D1 dargestellt
 Scheme D1 shown



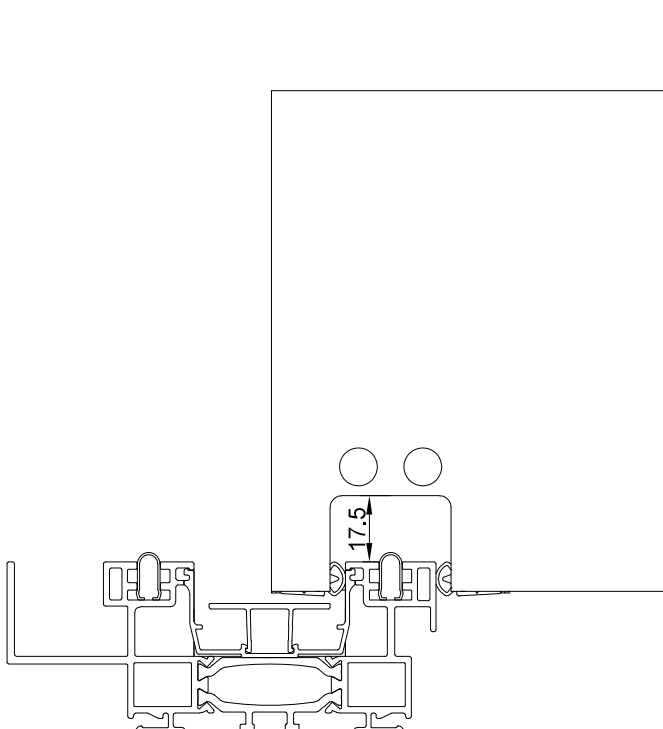
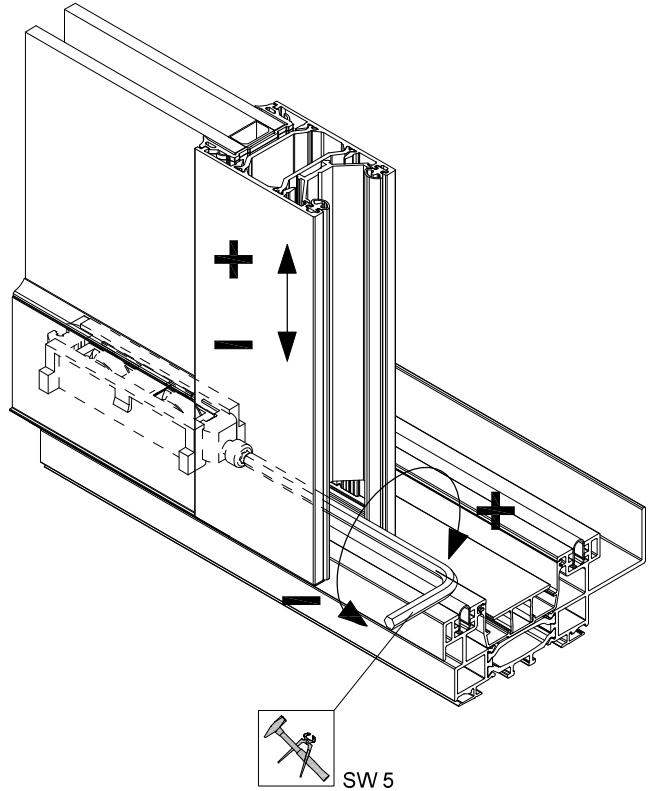
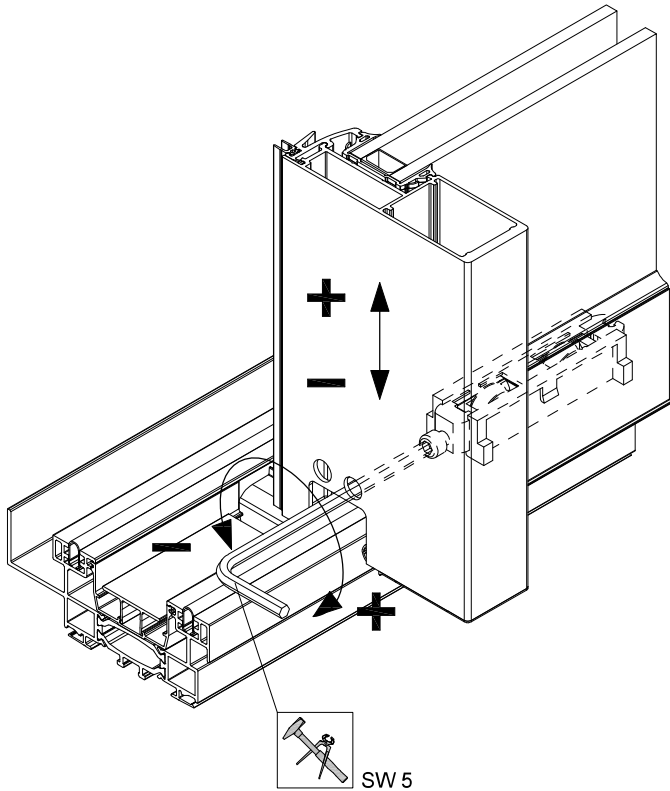
Schema D2 spiegelbildlich
 Scheme D2 mirror-inverted



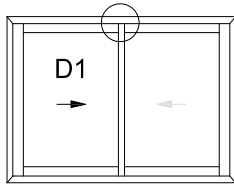
Schema A1 dargestellt
 Scheme A1 shown



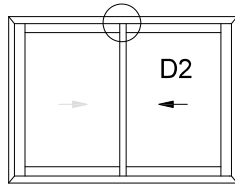
Schema A2 spiegelbildlich
 Scheme A2 mirror-inverted



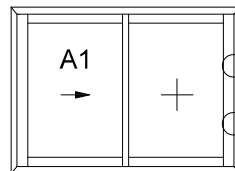
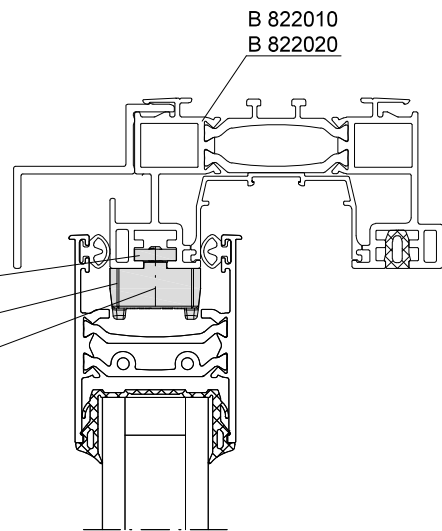
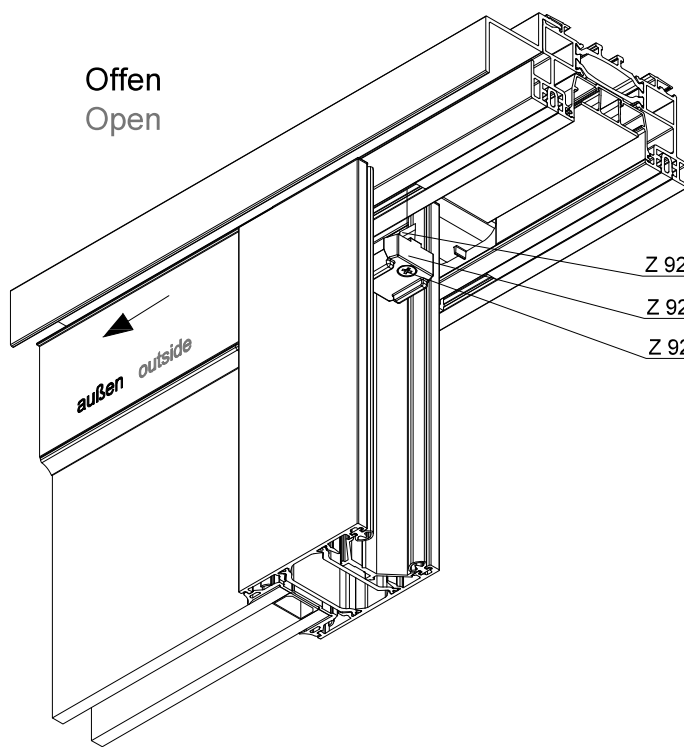
FLÜGELMONTAGE
 SASH ASSEMBLY



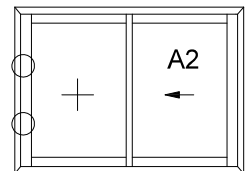
Schema D1 dargestellt
 Scheme D1 shown



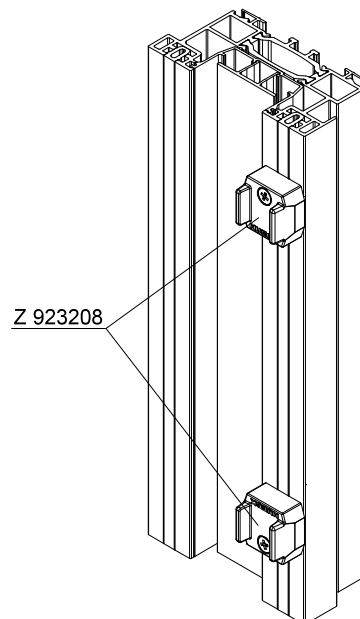
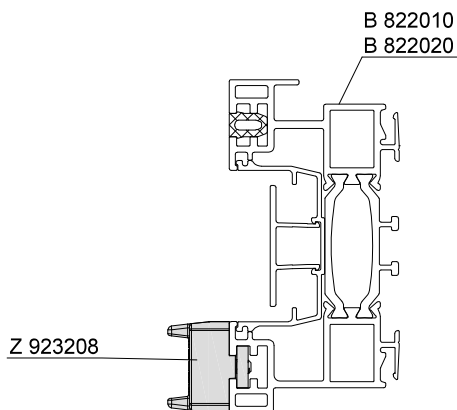
Schema D2 spiegelbildlich
 Scheme D2 mirror-inverted



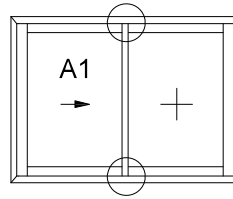
Schema A1 dargestellt
 Scheme A1 shown



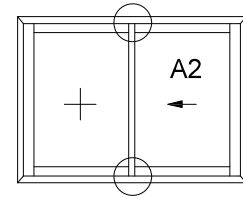
Schema A2 spiegelbildlich
 Scheme A2 mirror-inverted



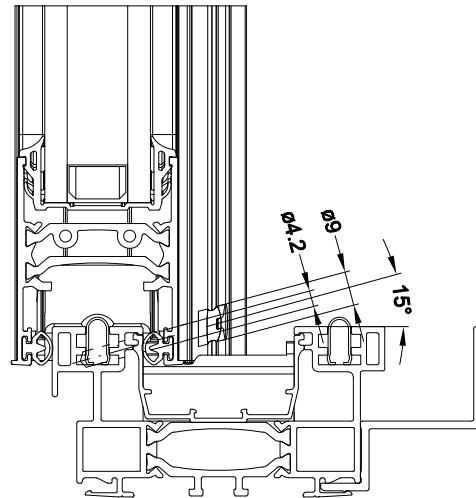
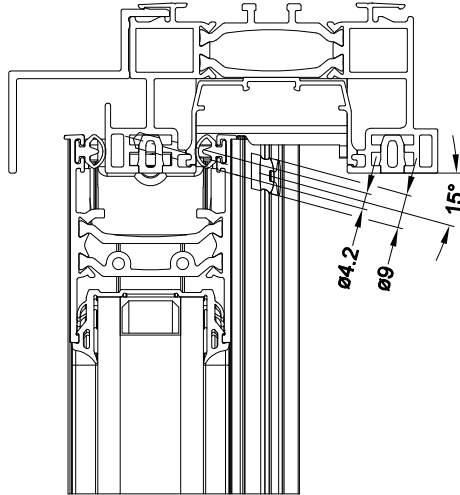
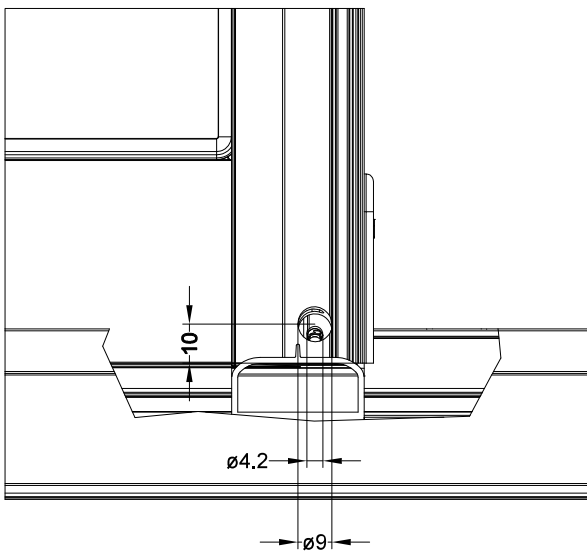
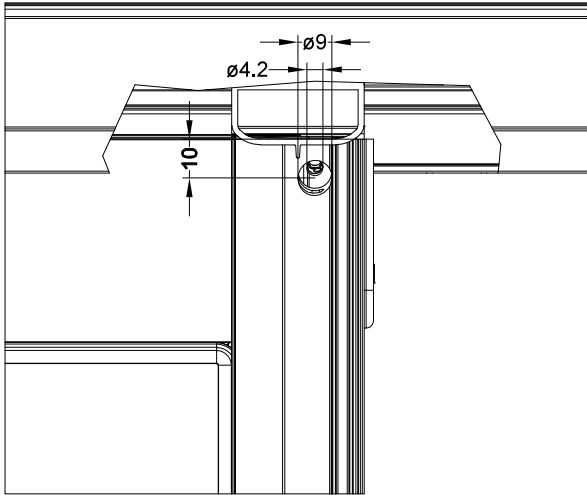
FLÜGELMONTAGE
SASH ASSEMBLY



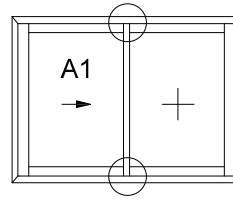
Schema A1 dargestellt
Scheme A1 shown



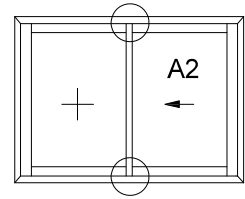
Schema A2 spiegelbildlich
Scheme A2 mirror-inverted



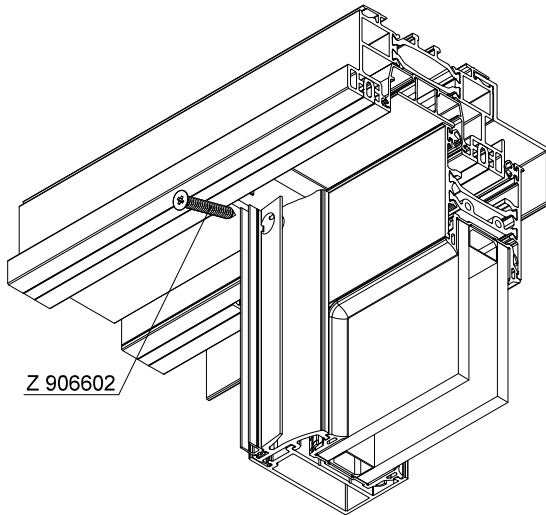
FLÜGELMONTAGE
 SASH ASSEMBLY



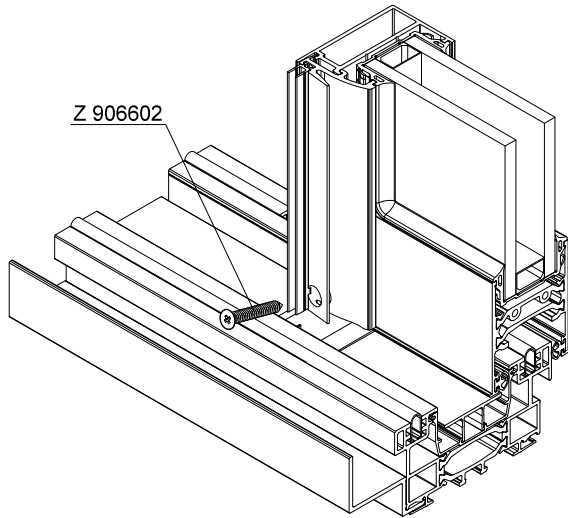
Schema A1 dargestellt
 Schema A1 shown



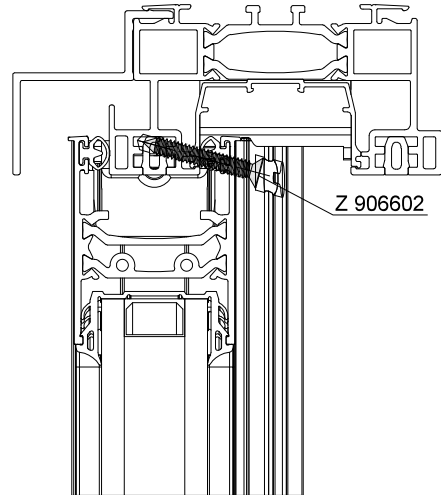
Schema A2 spiegelbildlich
 Schema A2 mirror-inverted



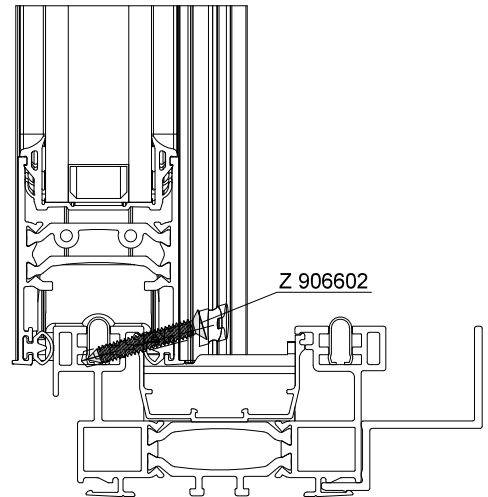
Z 906602



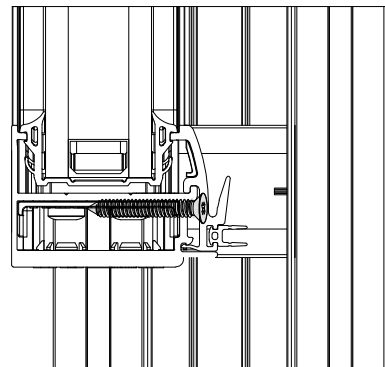
Z 906602



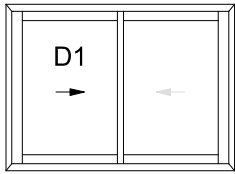
Z 906602



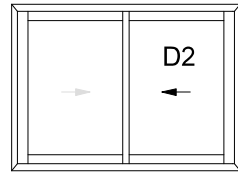
Z 906602



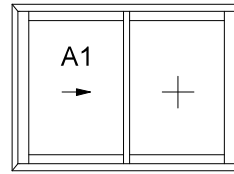
FLÜGELMONTAGE
SASH ASSEMBLY



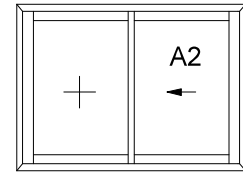
Schema D1 dargestellt
Scheme D1 shown



Schema D2 spiegelbildlich
Scheme D2 mirror-inverted



Schema A1 dargestellt
Scheme A1 shown



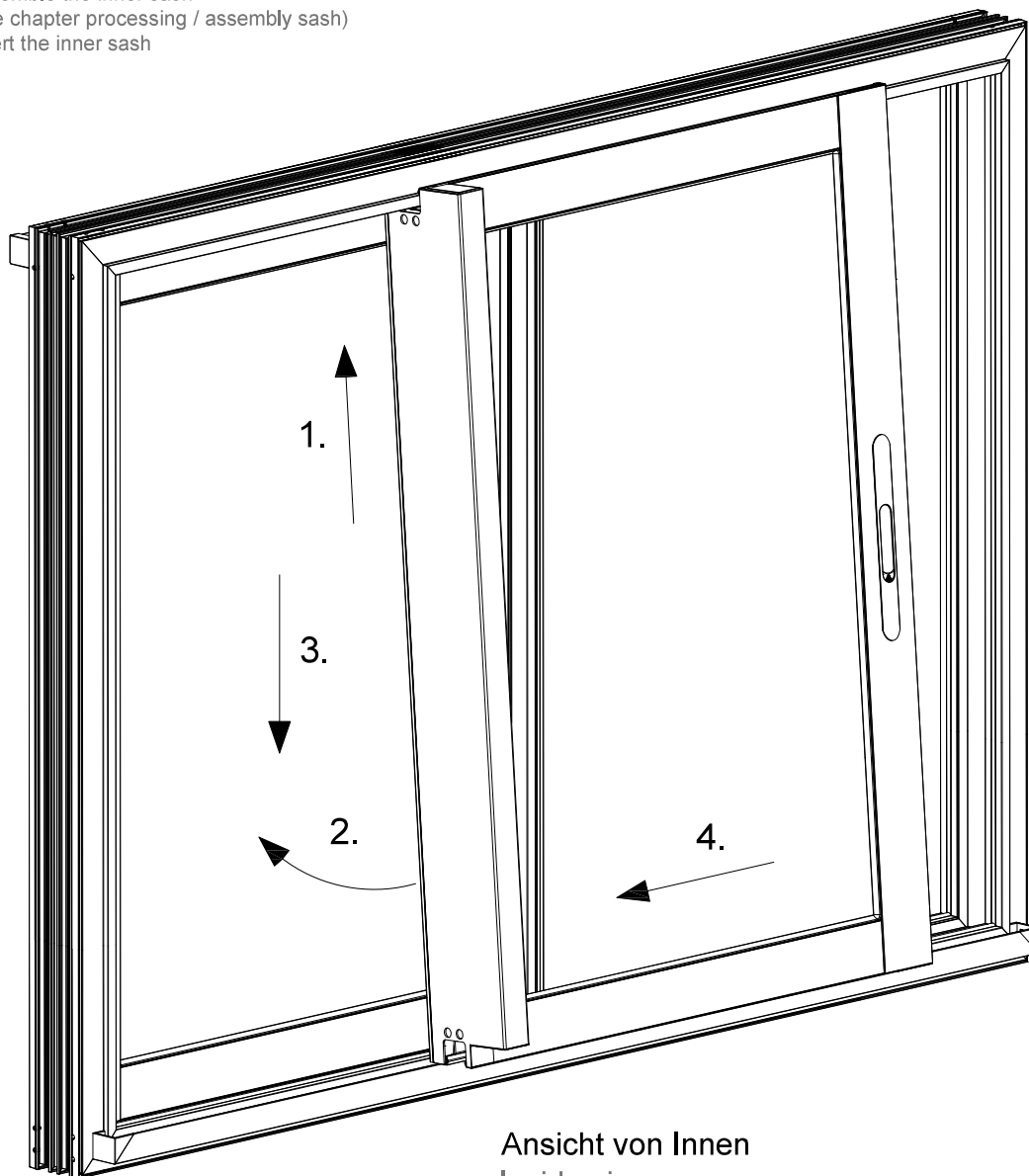
Schema A2 spiegelbildlich
Scheme A2 mirror-inverted

Bearbeitungsschritte

1. Inneren Flügel montieren
(Siehe Kapitel Verarbeitung / Montage Flügel)
2. Inneren Flügel einhängen

Processing steps

1. Assemble the inner sash
(see chapter processing / assembly sash)
2. Insert the inner sash

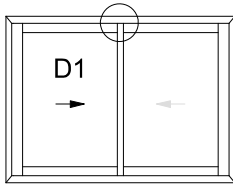


Ansicht von Innen
Inside view

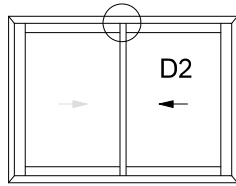
Der äußere Griff + Stopper muss demontiert sein.

The outer handle + stopper has to be dismantled

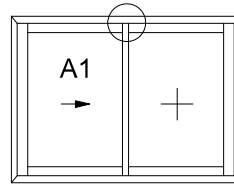
FLÜGELMONTAGE
 SASH ASSEMBLY



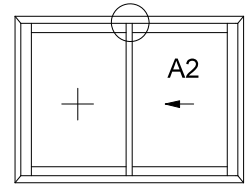
Schema D1 dargestellt
 Schema D1 shown



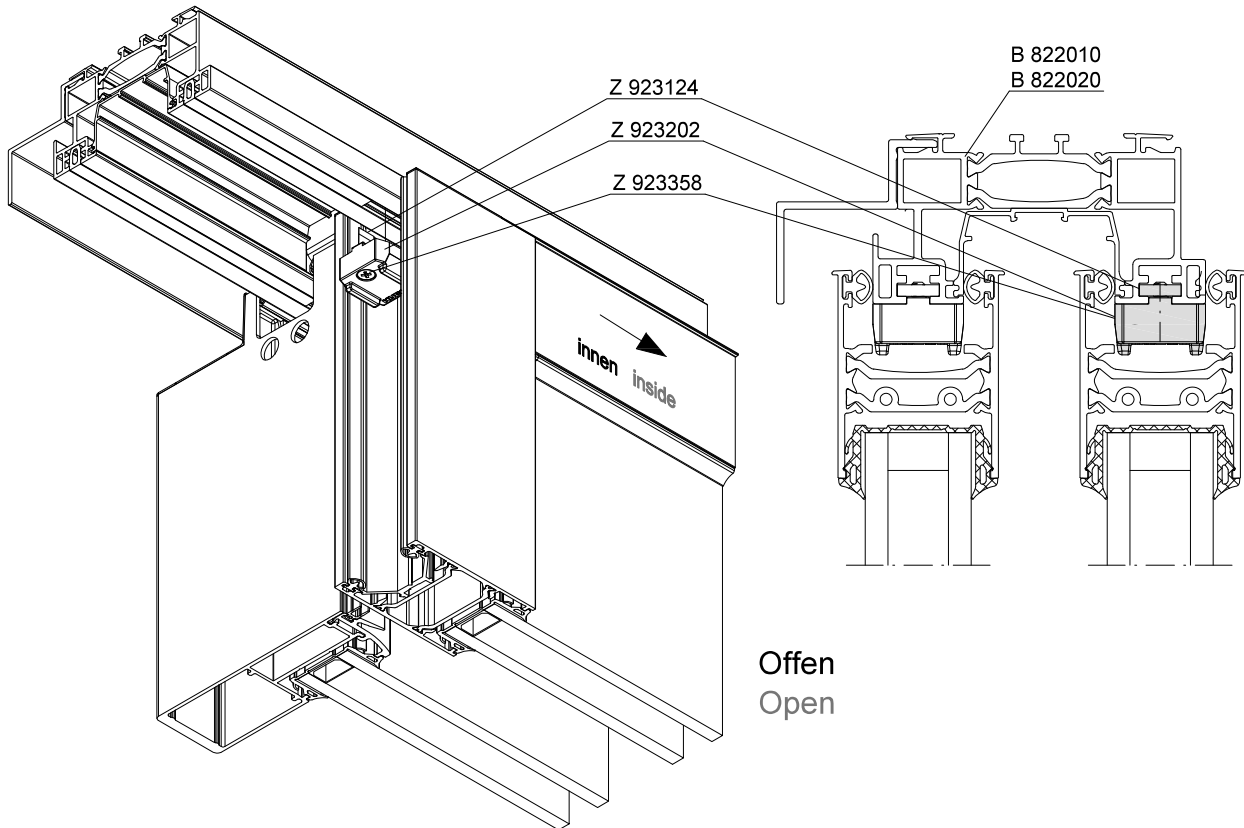
Schema D2 spiegelbildlich
 Schema D2 mirror-inverted



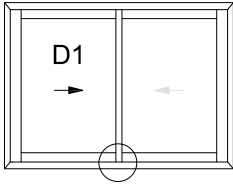
Schema A1 dargestellt
 Schema A1 shown



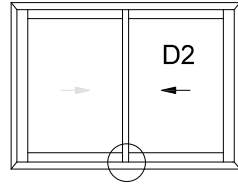
Schema A2 spiegelbildlich
 Schema A2 mirror-inverted



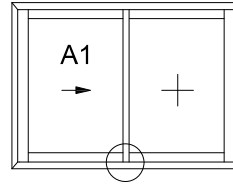
FLÜGELMONTAGE
 SASH ASSEMBLY



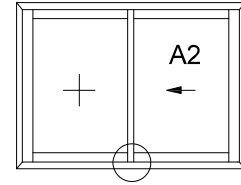
Schema D1 dargestellt
 Scheme D1 shown



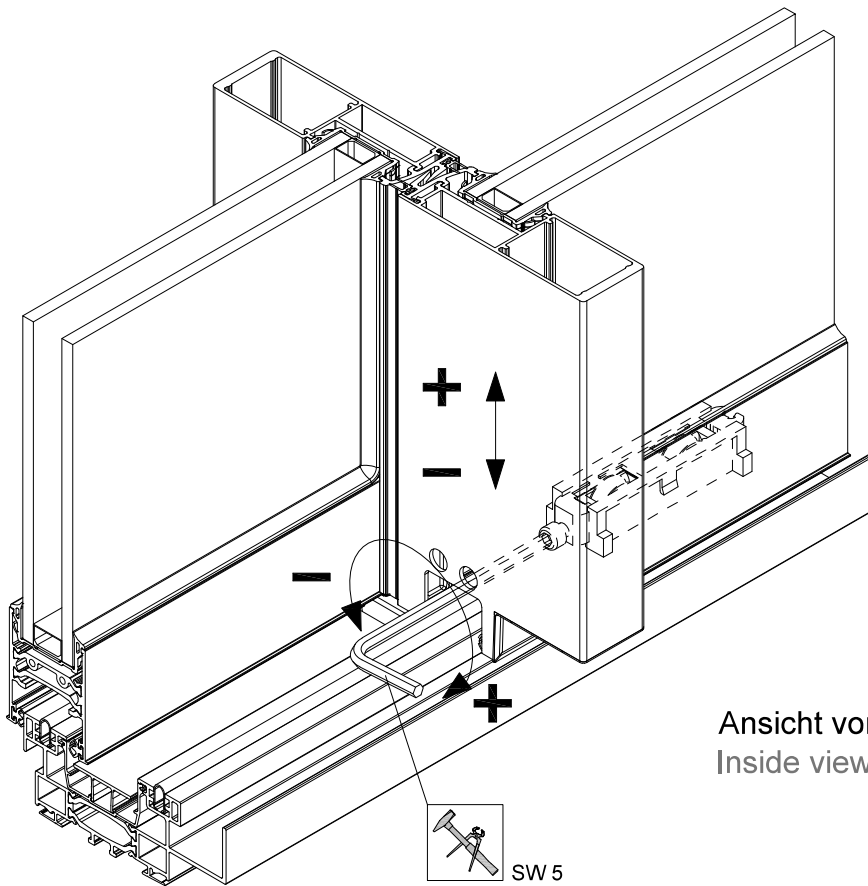
Schema D2 spiegelbildlich
 Scheme D2 mirror-inverted



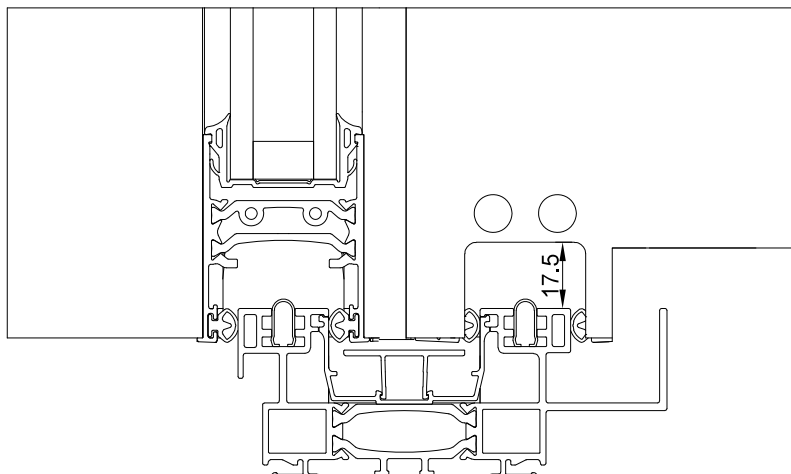
Schema A1 dargestellt
 Scheme A1 shown



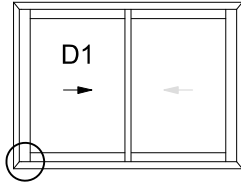
Schema A2 spiegelbildlich
 Scheme A2 mirror-inverted



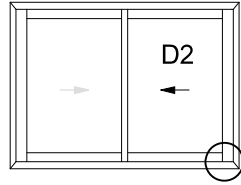
Ansicht von Innen
 Inside view



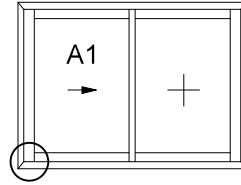
FLÜGELMONTAGE
 SASH ASSEMBLY



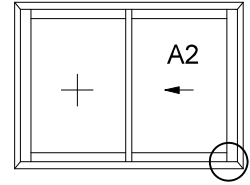
Schema D1 dargestellt
 Schema D1 shown



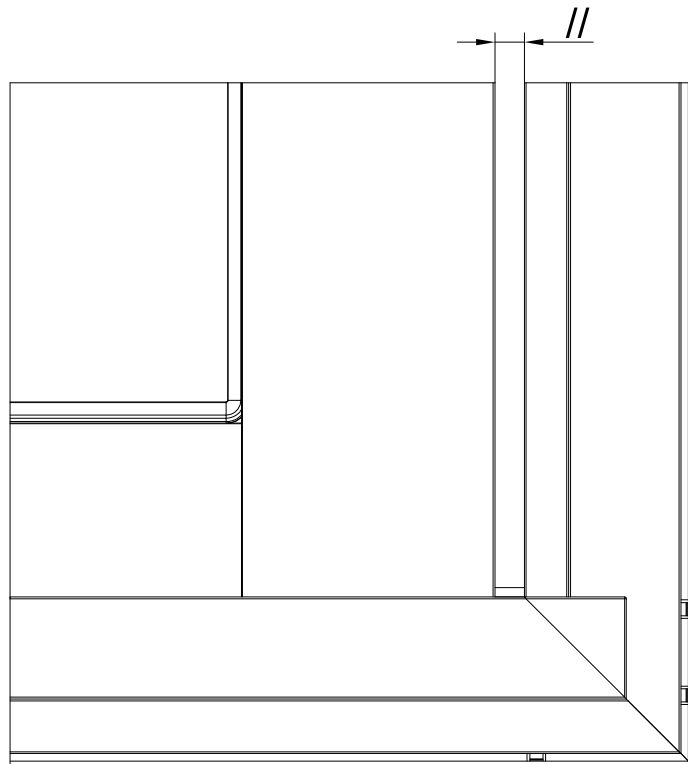
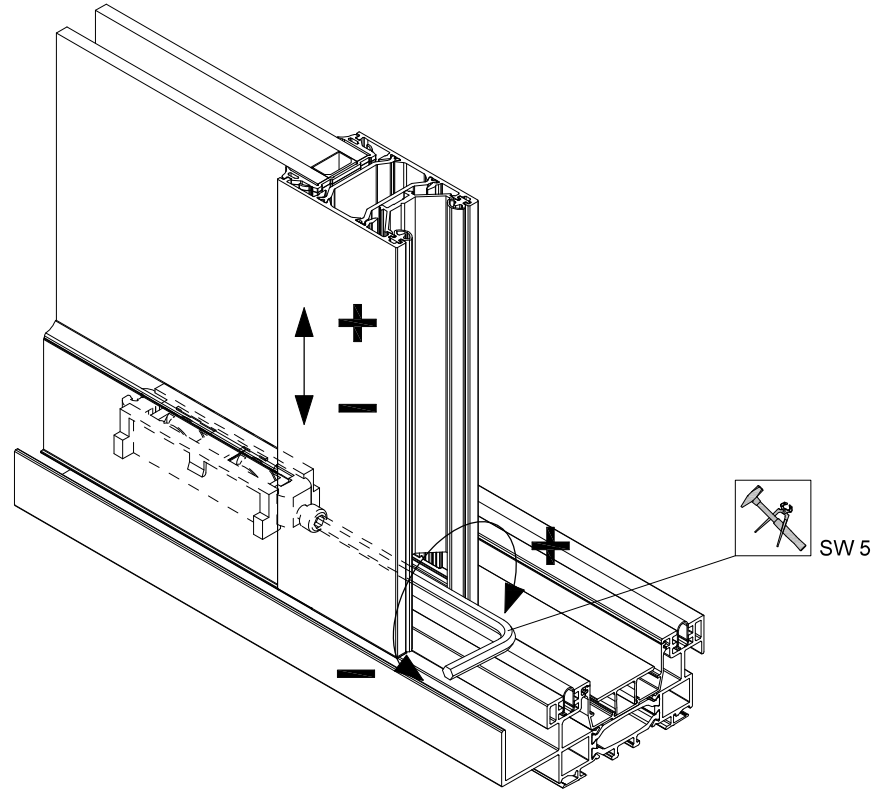
Schema D2 spiegelbildlich
 Schema D2 mirror-inverted



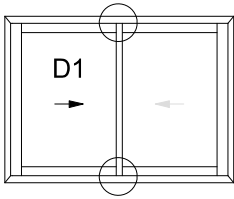
Schema A1 dargestellt
 Schema A1 shown



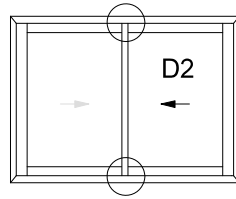
Schema A2 spiegelbildlich
 Schema A2 mirror-inverted



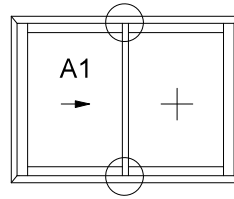
FLÜGELMONTAGE
SASH ASSEMBLY



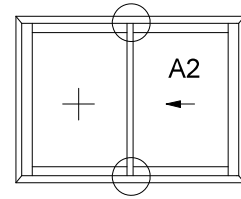
Schema D1 dargestellt
Scheme D1 shown



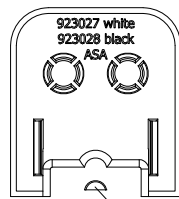
Schema D2 spiegelbildlich
Scheme D2 mirror-inverted



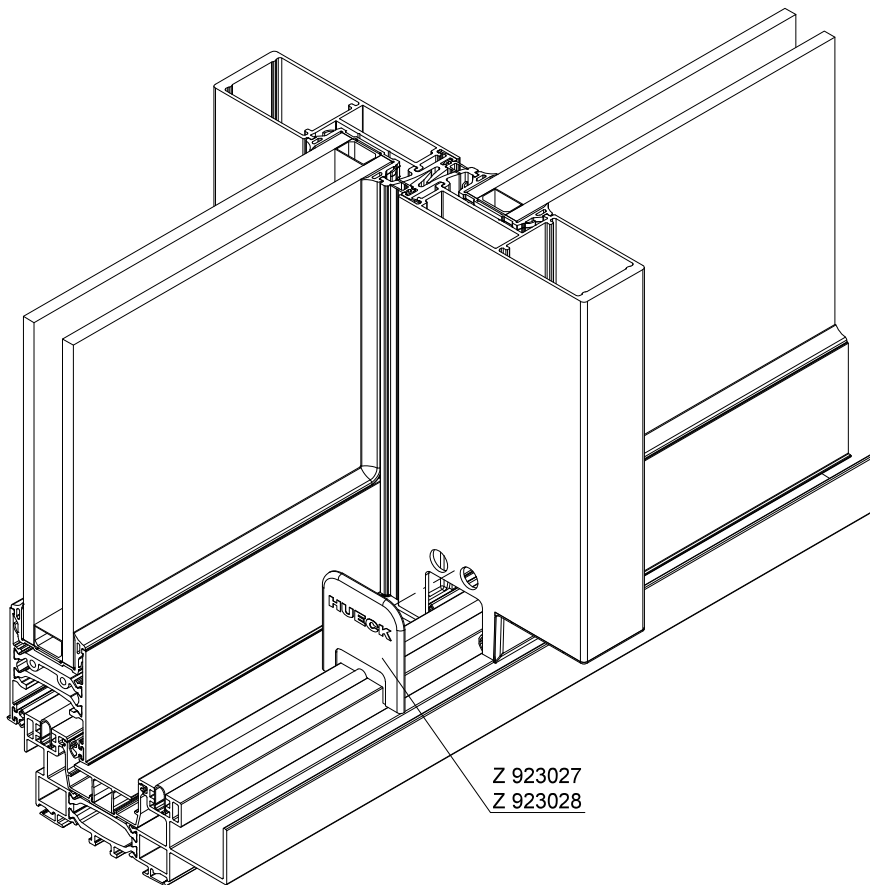
Schema A1 dargestellt
Scheme A1 shown



Schema A2 spiegelbildlich
Scheme A2 mirror-inverted

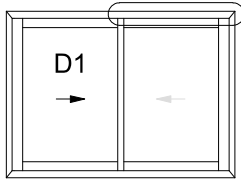


Nur unten
Only below

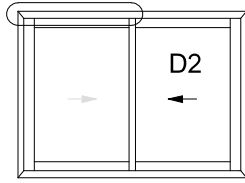


Z 923027
Z 923028

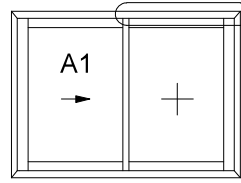
RAHMENMONTAGE
 FRAME ASSEMBLY



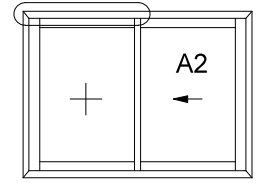
Schema D1 dargestellt
 Scheme D1 shown



Schema D2 spiegelbildlich
 Scheme D2 mirror-inverted

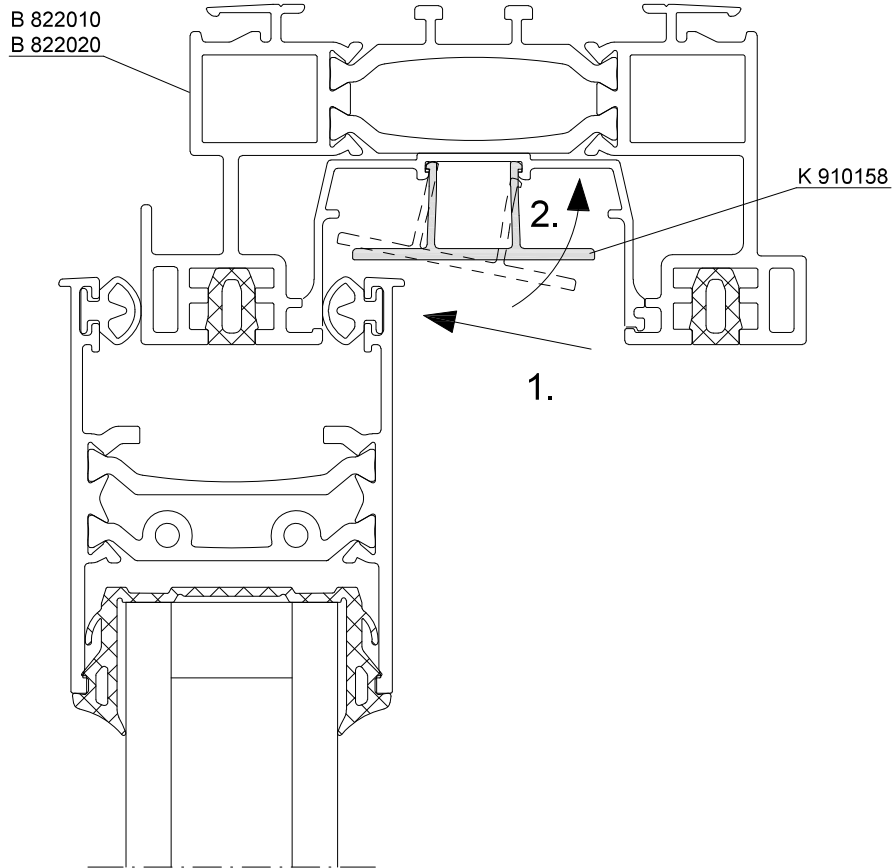


Schema A1 dargestellt
 Scheme A1 shown

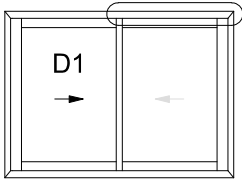


Schema A2 spiegelbildlich
 Scheme A2 mirror-inverted

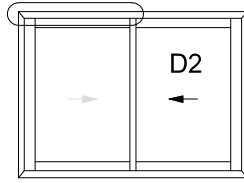
Optional



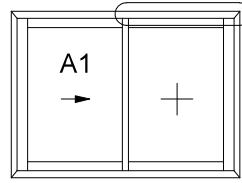
RAHMENMONTAGE
FRAME ASSEMBLY



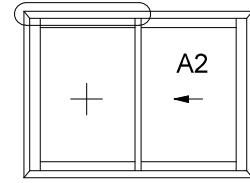
Schema D1 dargestellt
Scheme D1 shown



Schema D2 spiegelbildlich
Scheme D2 mirror-inverted

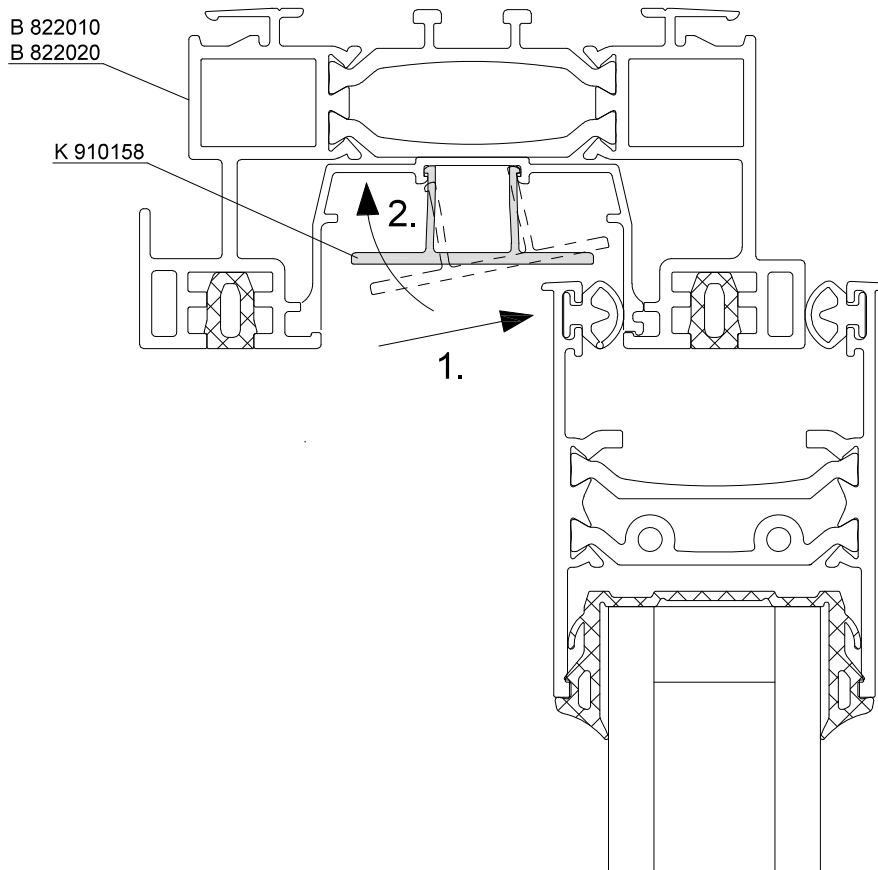


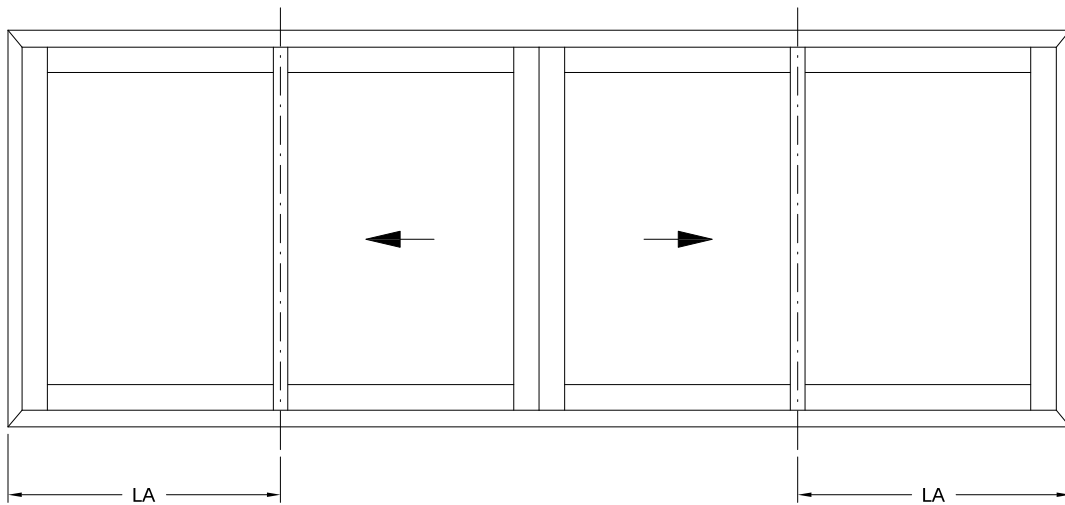
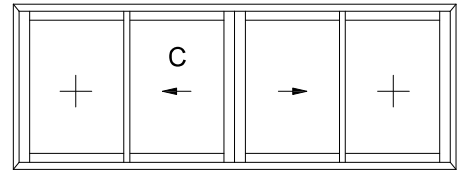
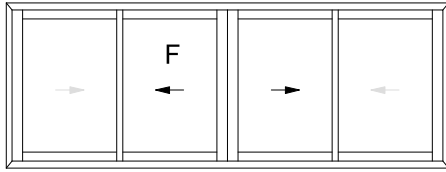
Schema A1 dargestellt
Scheme A1 shown



Schema A2 spiegelbildlich
Scheme A2 mirror-inverted

Optional





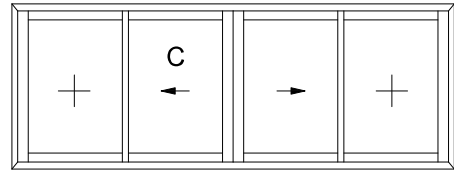
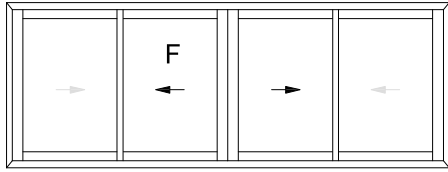
Bei gleicher Aufteilung der Flügelbreiten:

$$LA = RB / 4 + 16,75$$

With the same division of the sash widths:

$$LA = RB / 4 + 16,75$$

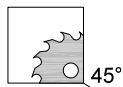
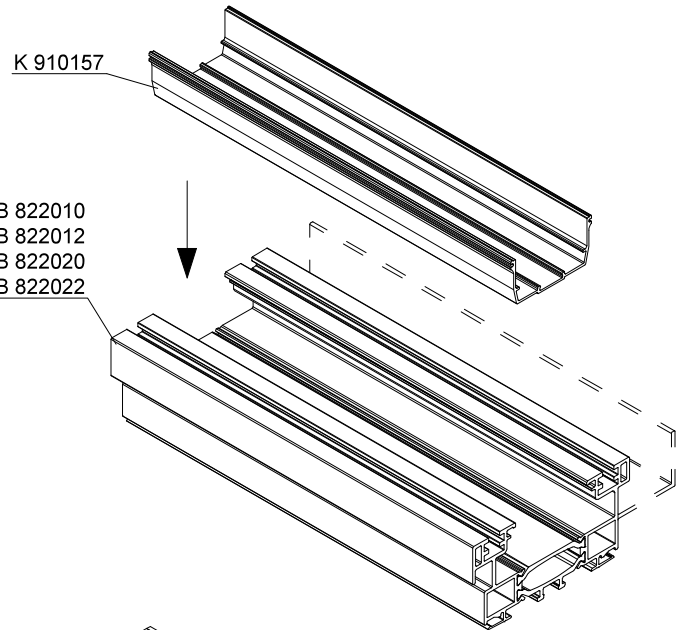
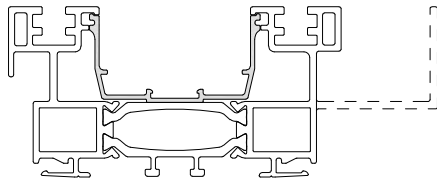
RAHMENBEARBEITUNG
FRAME PROCESSING



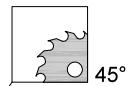
B 822010, B 822012, B 822020, B 822022

K 910157

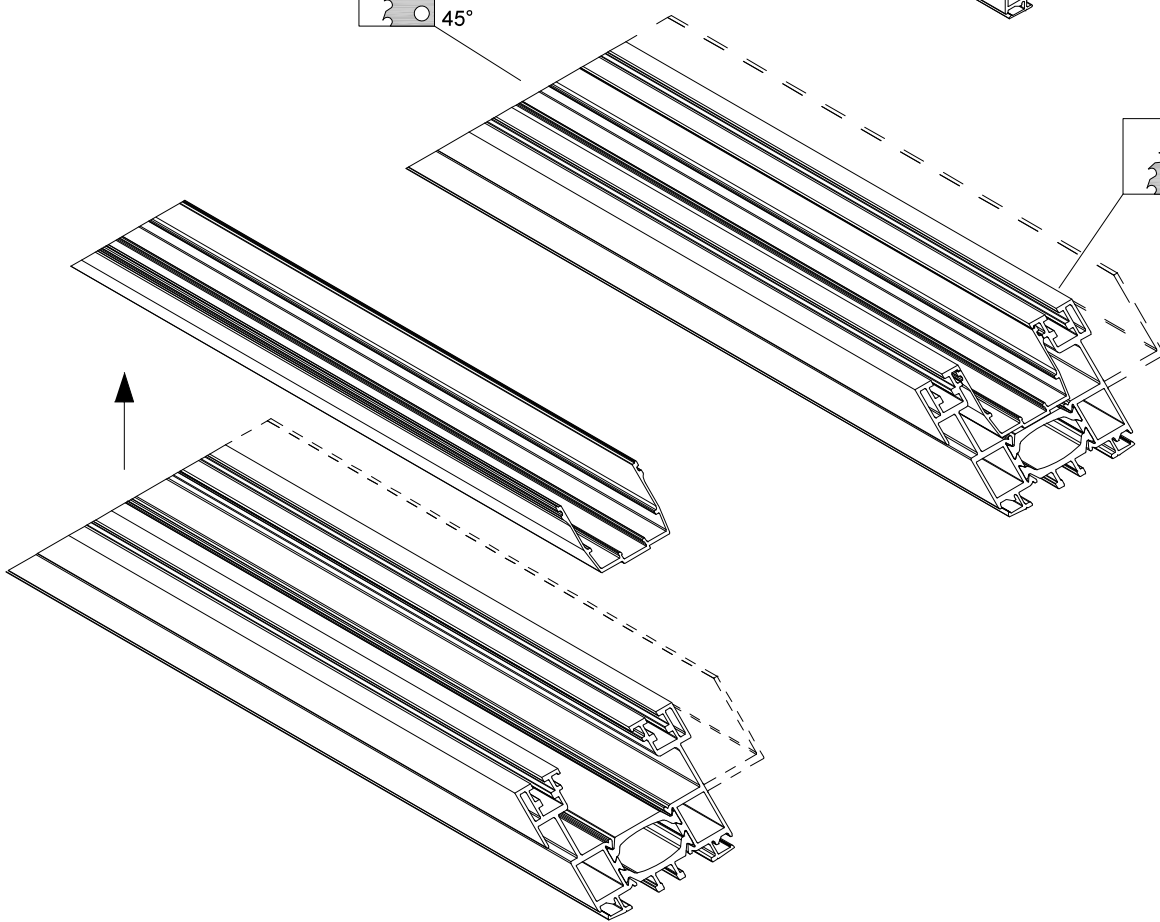
umlaufend
circumferential



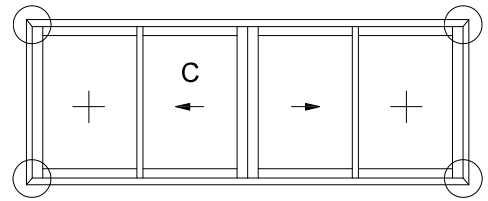
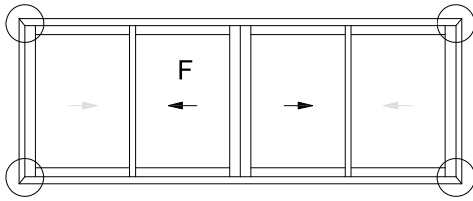
45°



45°



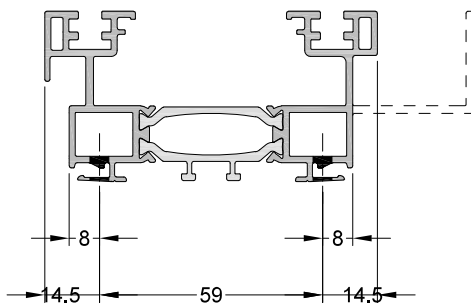
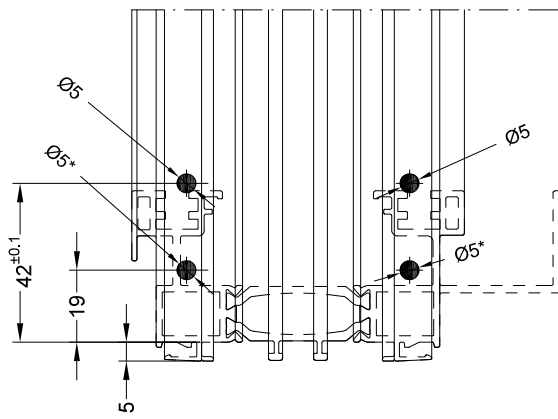
RAHMENBEARBEITUNG
 FRAME PROCESSING



B 822010, B 822012, B 822020, B 822022

* Bohrung wahlweise,
 für nachträgliche Verklebung

* drilling optional,
 for retro gluing after assembly

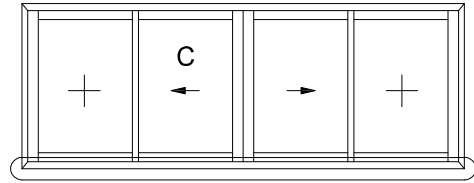
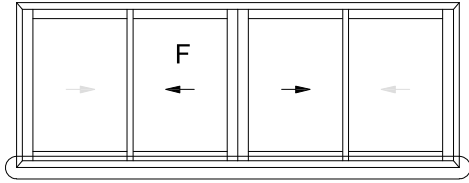


Z 923317



Z 981509

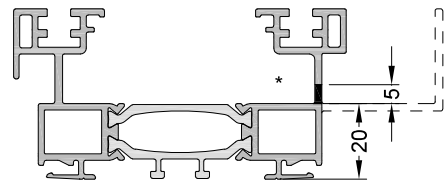
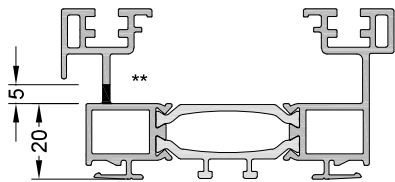
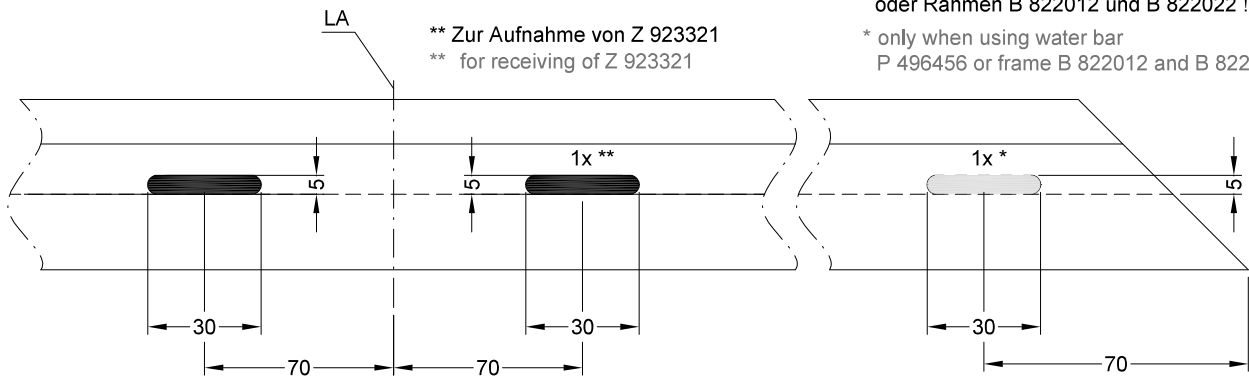
RAHMENBEARBEITUNG
 FRAME PROCESSING



B 822010, B 822012, B 822020, B 822022

* Nur bei der Verwendung vom
 Wetterschenkel P 496456
 oder Rahmen B 822012 und B 822022 !

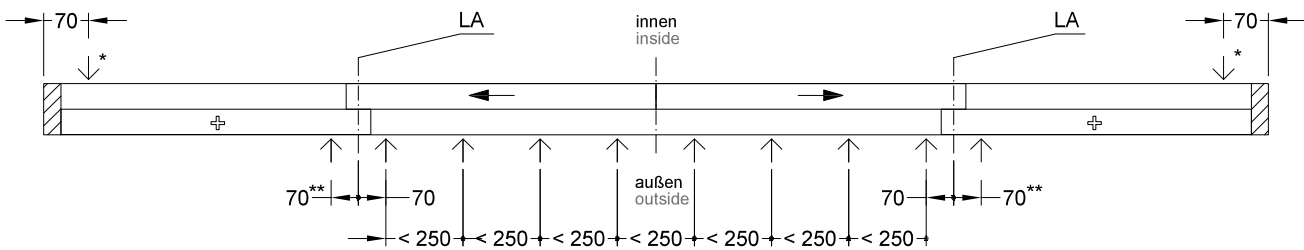
* only when using water bar
 P 496456 or frame B 822012 and B 822022 !



Z 981511

Schema C dargestellt
 Schema C shown

Schema F identisch
 Schema F the same



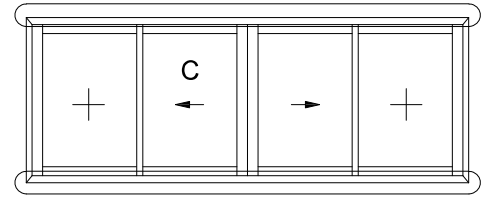
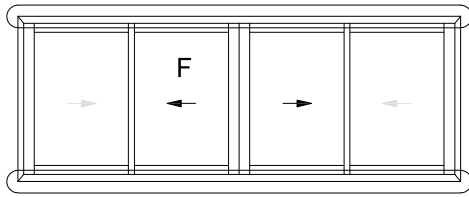
* Nur bei der Verwendung vom Wetterschenkel P 496456 oder Rahmen B 822012 oder B 822022 !

* only when using water bar P 496456 or frame B 822012 or B 822022!

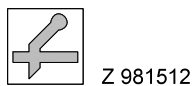
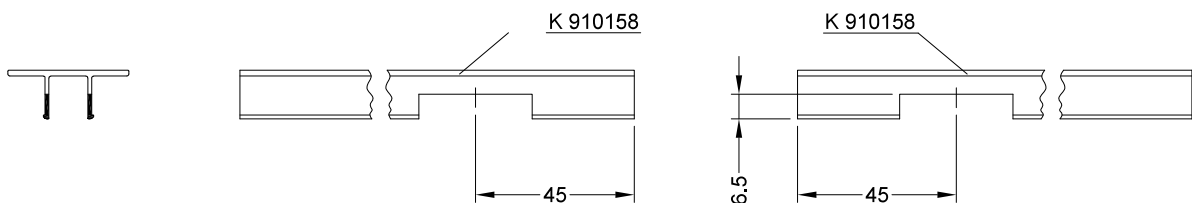
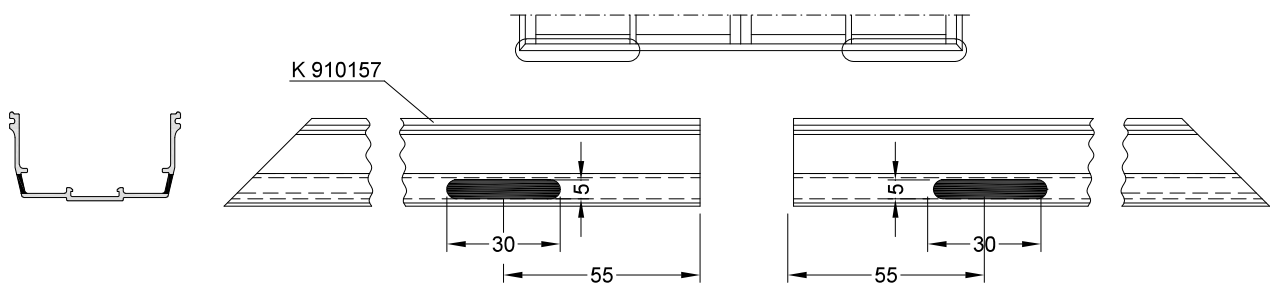
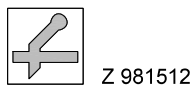
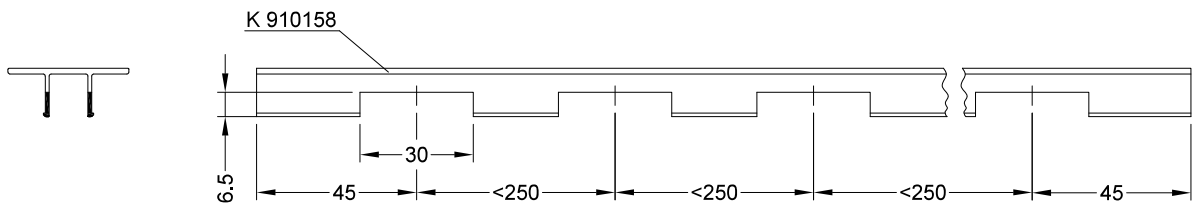
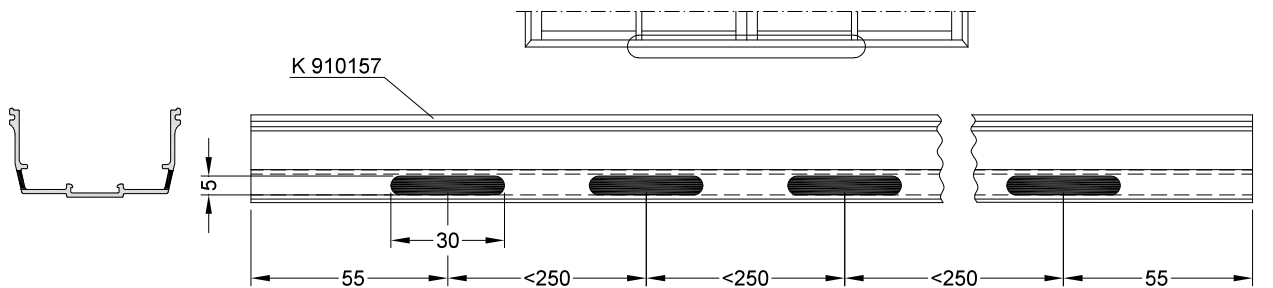
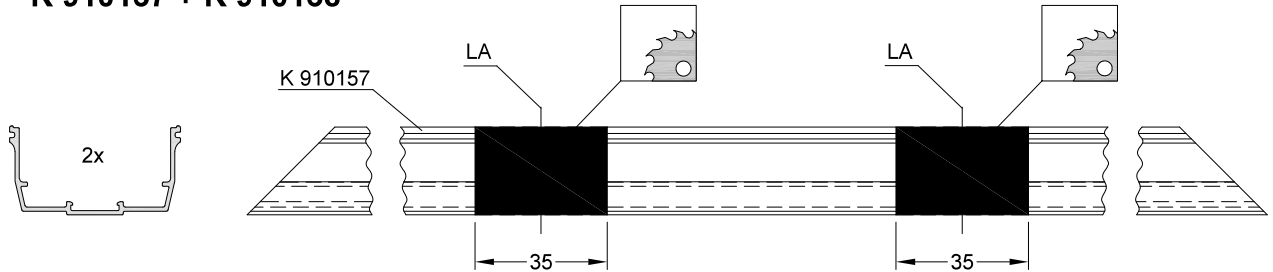
** Zur Aufnahme von Z 923321

** for receiving of Z 923321

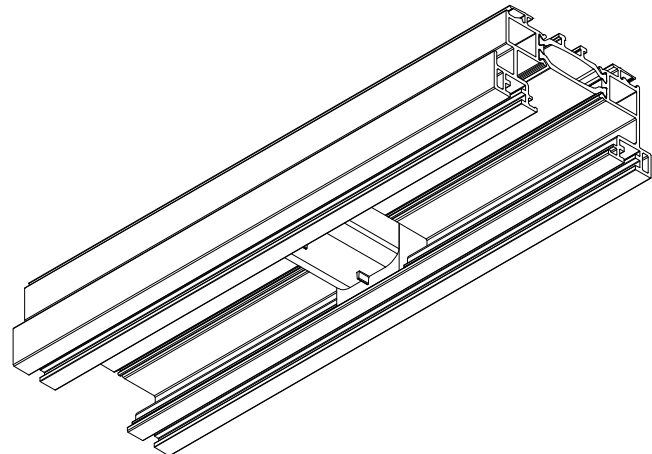
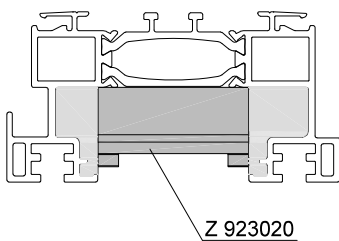
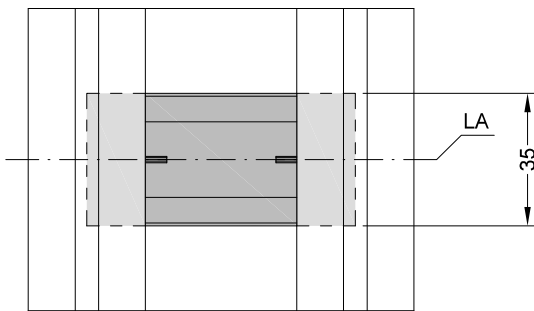
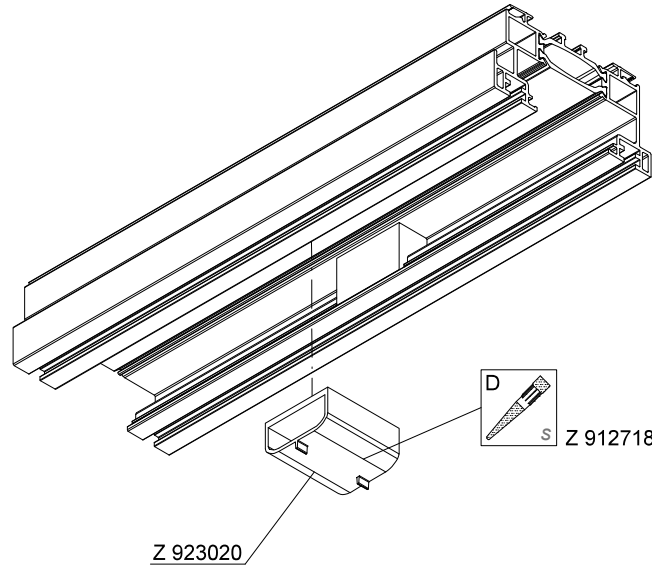
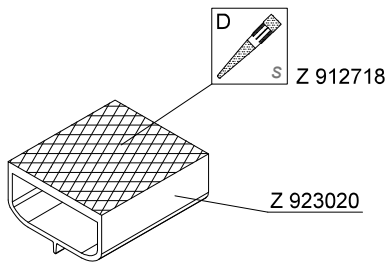
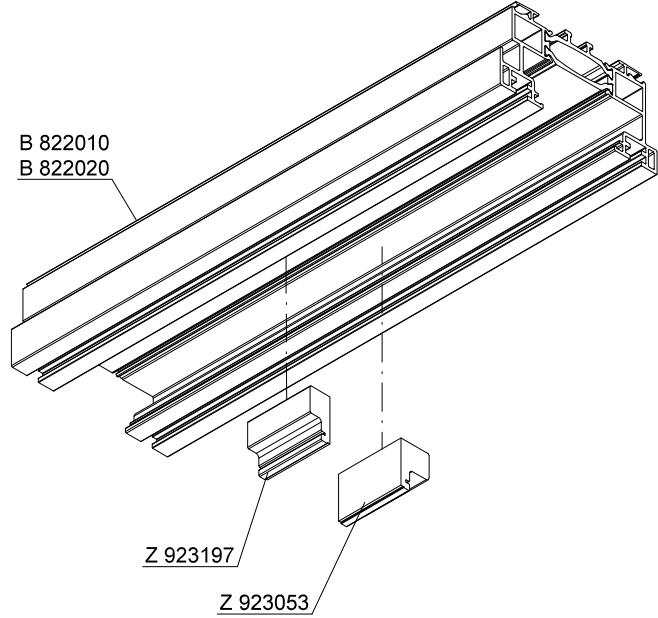
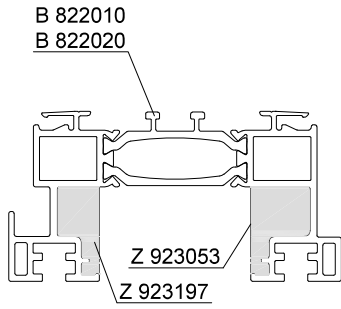
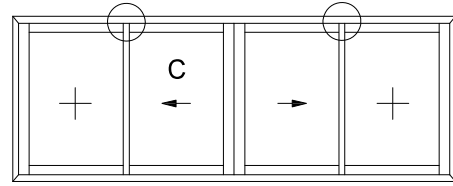
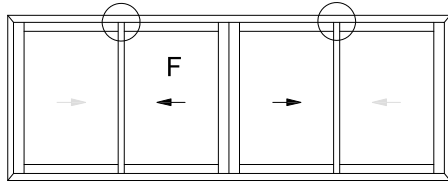
RAHMENBEARBEITUNG
 FRAME PROCESSING



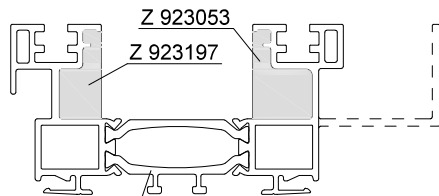
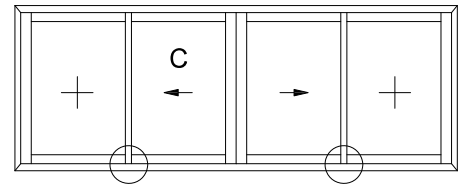
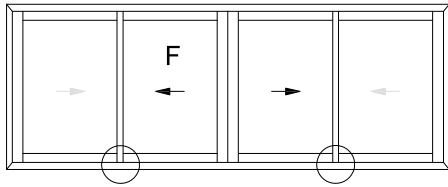
K 910157 + K 910158



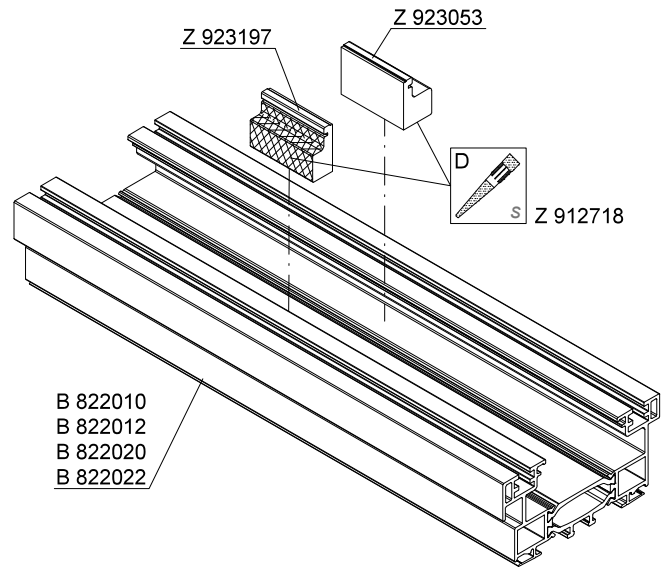
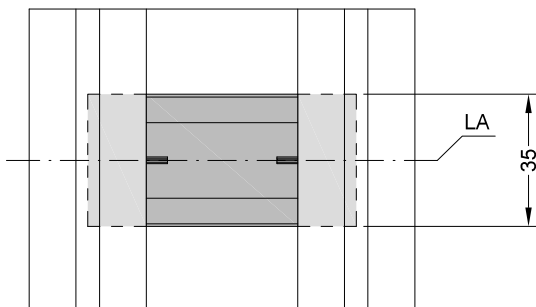
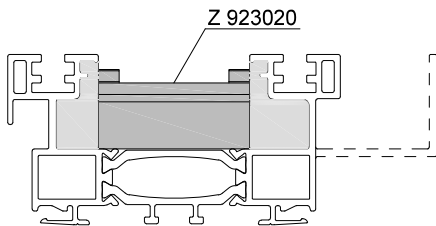
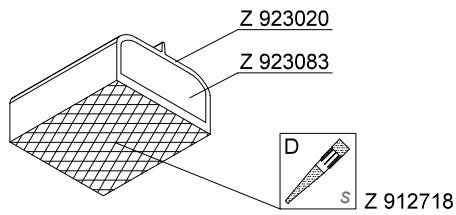
RAHMENMONTAGE
 FRAME ASSEMBLY



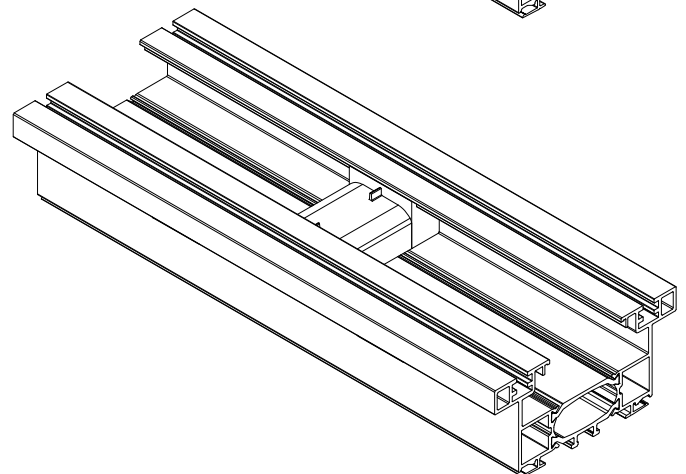
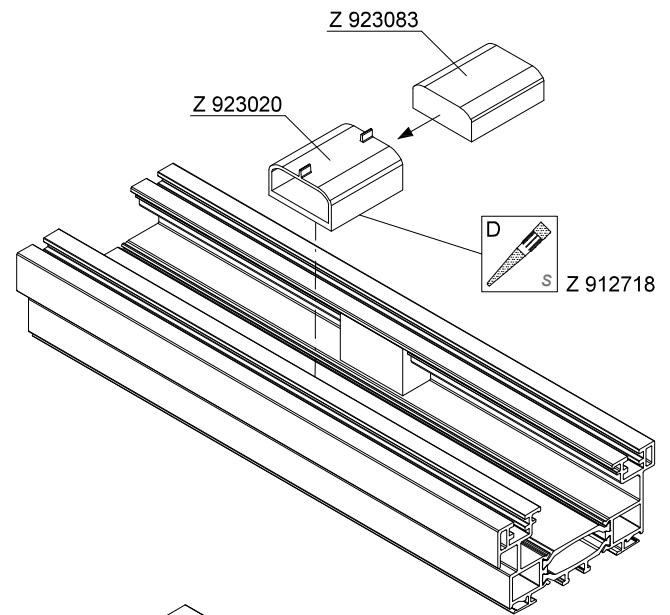
RAHMENMONTAGE
 FRAME ASSEMBLY



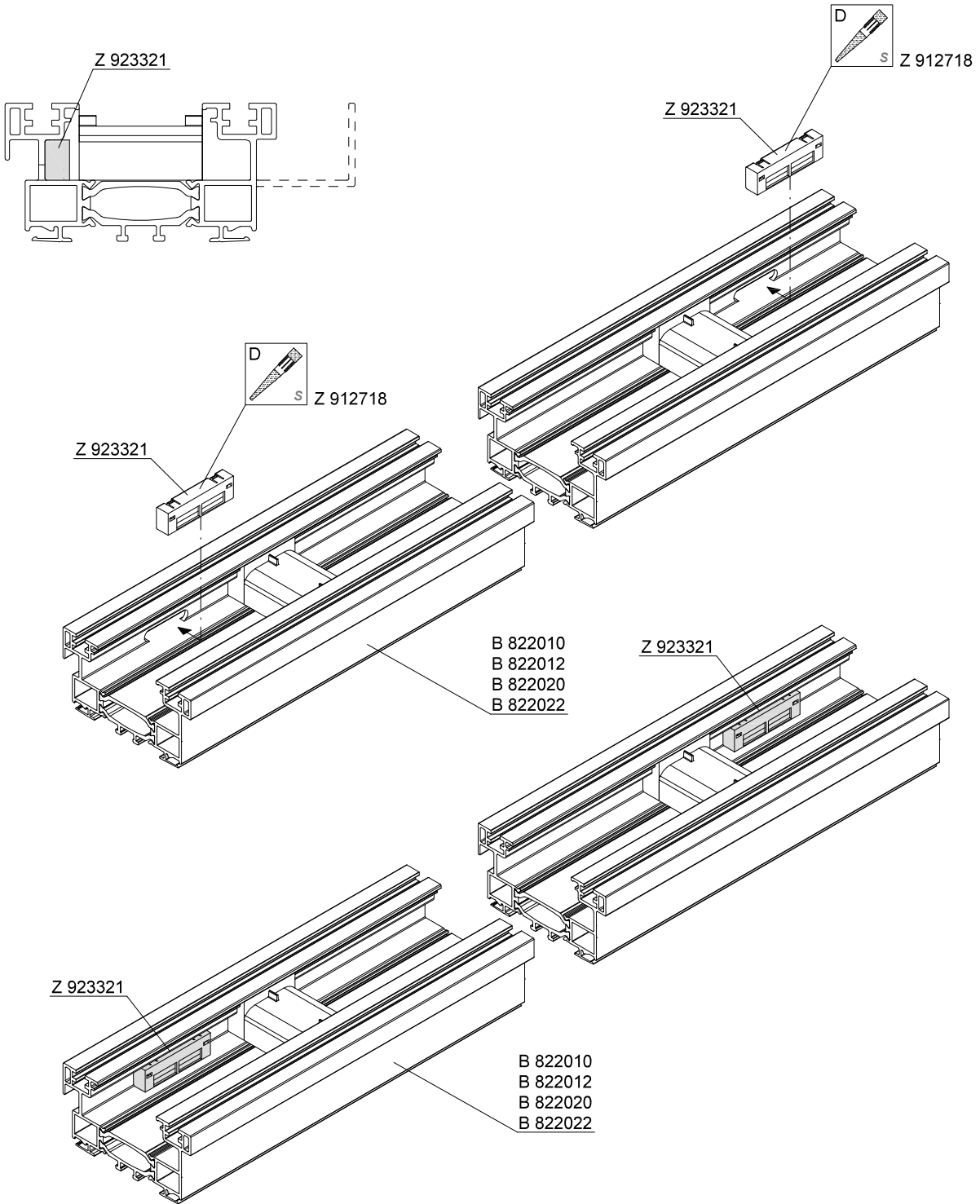
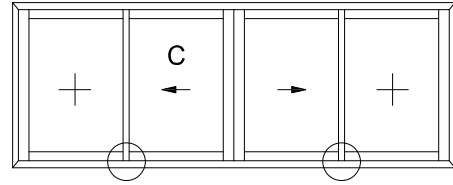
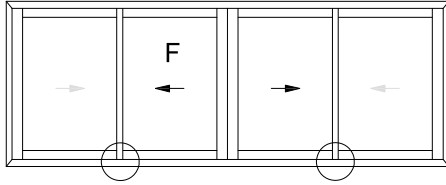
B 822010
 B 822012
 B 822020
 B 822022



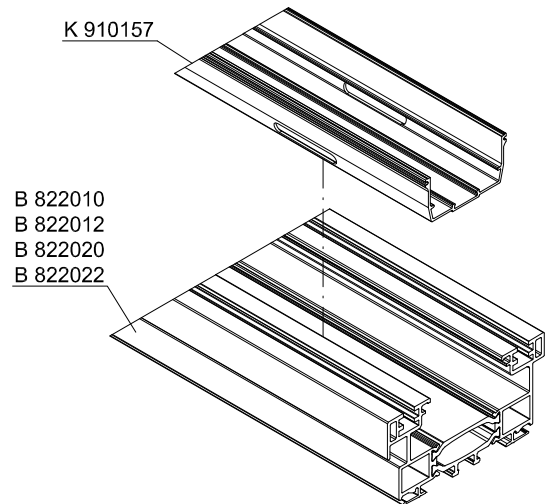
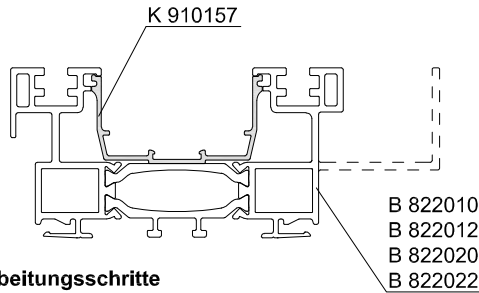
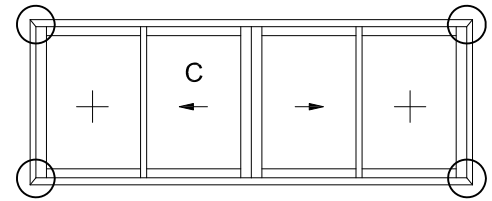
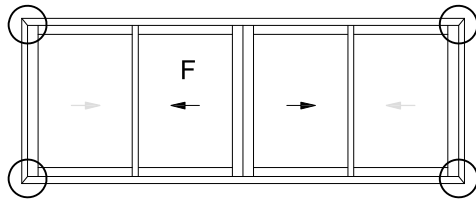
B 822010
 B 822012
 B 822020
 B 822022



RAHMENMONTAGE
 FRAME ASSEMBLY



RAHMENMONTAGE
FRAME ASSEMBLY

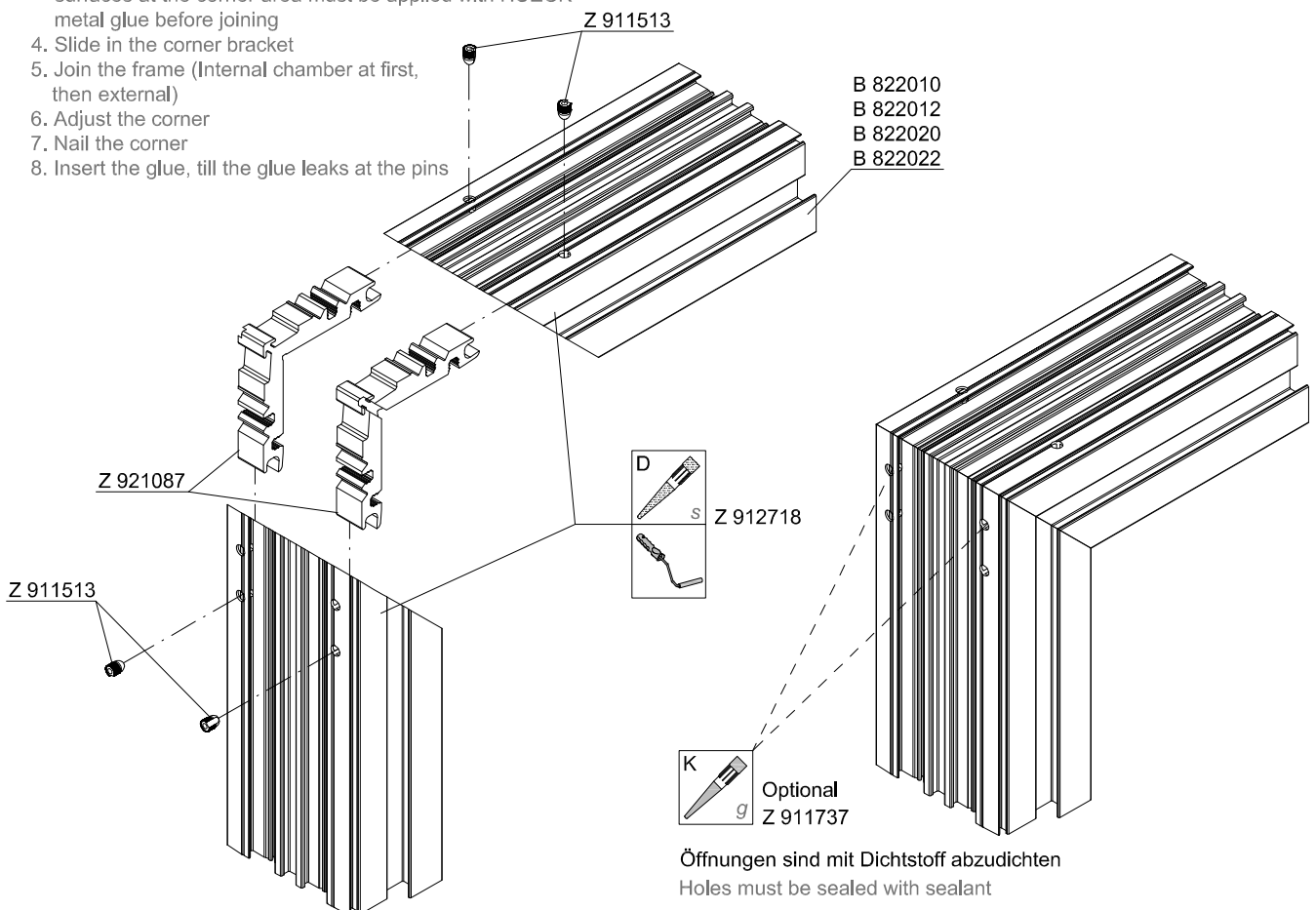


Bearbeitungsschritte

1. K 910157 umlaufend eindrücken
2. Schnittflächen versiegeln
3. Falls keine nachträgliche Verklebung vorgesehen ist, müssen vor dem Fügen alle Profillinienflächen im Eckbereich mit HUECK Metallkleber bestrichen werden
4. Eckverbinder einschieben
5. Rahmen fügen (erst Innen-, dann Außenkammer)
6. Ecke ausrichten
7. Ecke verstiften
8. Kleber einspritzen, bis der Kleber an den Stiften austritt

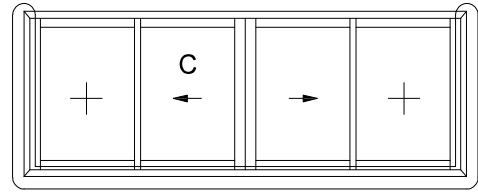
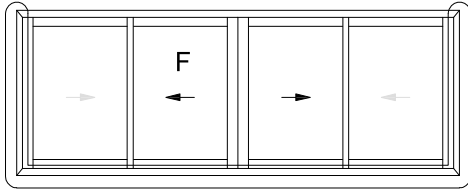
Processing steps

1. Insert K 910157 circumferential
2. Seal the cut surfaces
3. If there is no subsequent gluing planned, all inner profile surfaces at the corner area must be applied with HUECK metal glue before joining
4. Slide in the corner bracket
5. Join the frame (Internal chamber at first, then external)
6. Adjust the corner
7. Nail the corner
8. Insert the glue, till the glue leaks at the pins

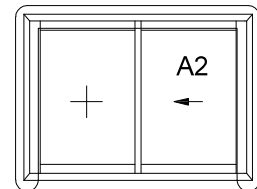
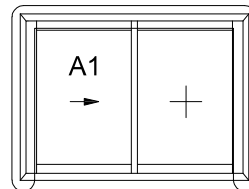
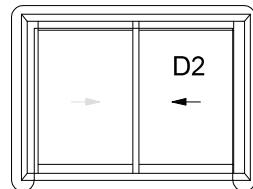
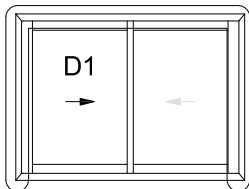
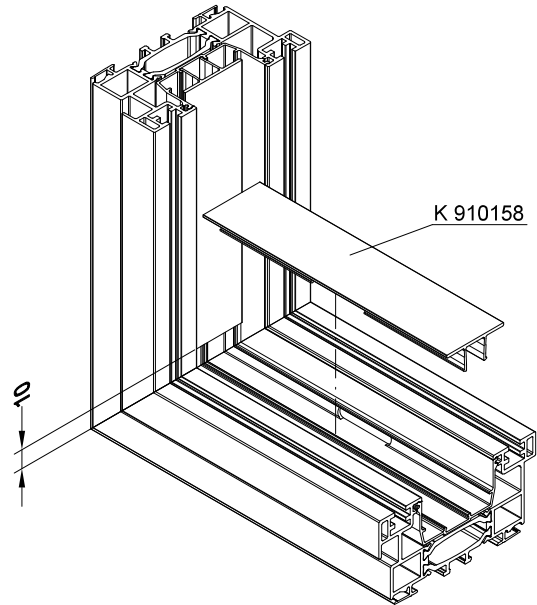
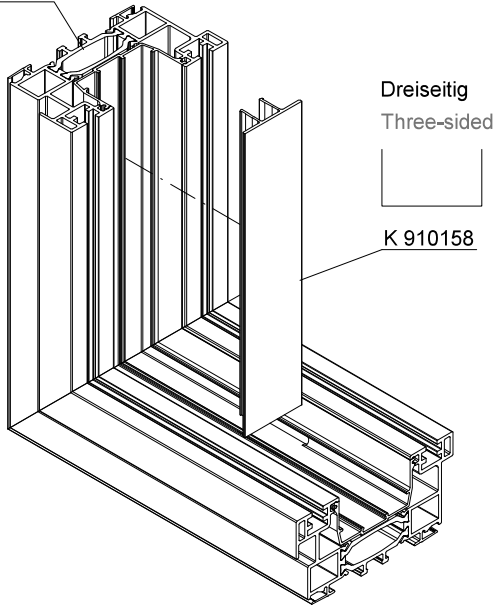


Öffnungen sind mit Dichtstoff abzudichten
Holes must be sealed with sealant

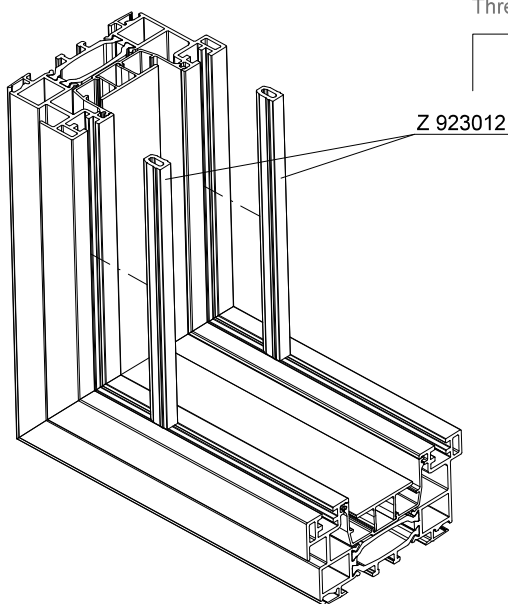
RAHMENMONTAGE
 FRAME ASSEMBLY



B 822010
 B 822012
 B 822020
 B 822022



Dreiseitig
 Three-sided



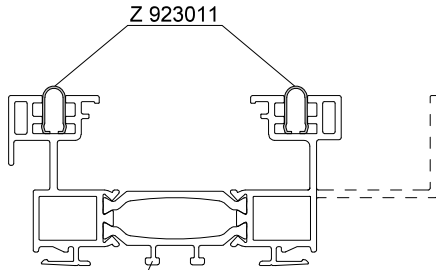
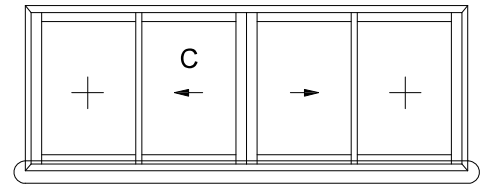
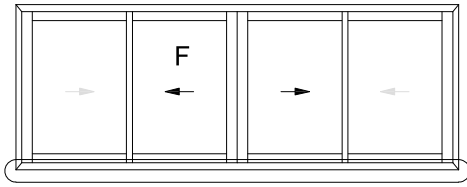
Bearbeitungsschritte

1. Schließteile einbauen und positionieren (siehe Kapitel Beschlageinbau)
2. Dichtungen einziehen

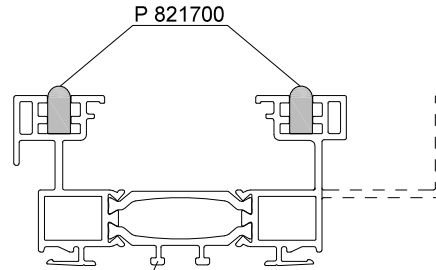
Processing steps

1. Install and position the locking parts (see chapter fitting installation)
2. Insert the gaskets

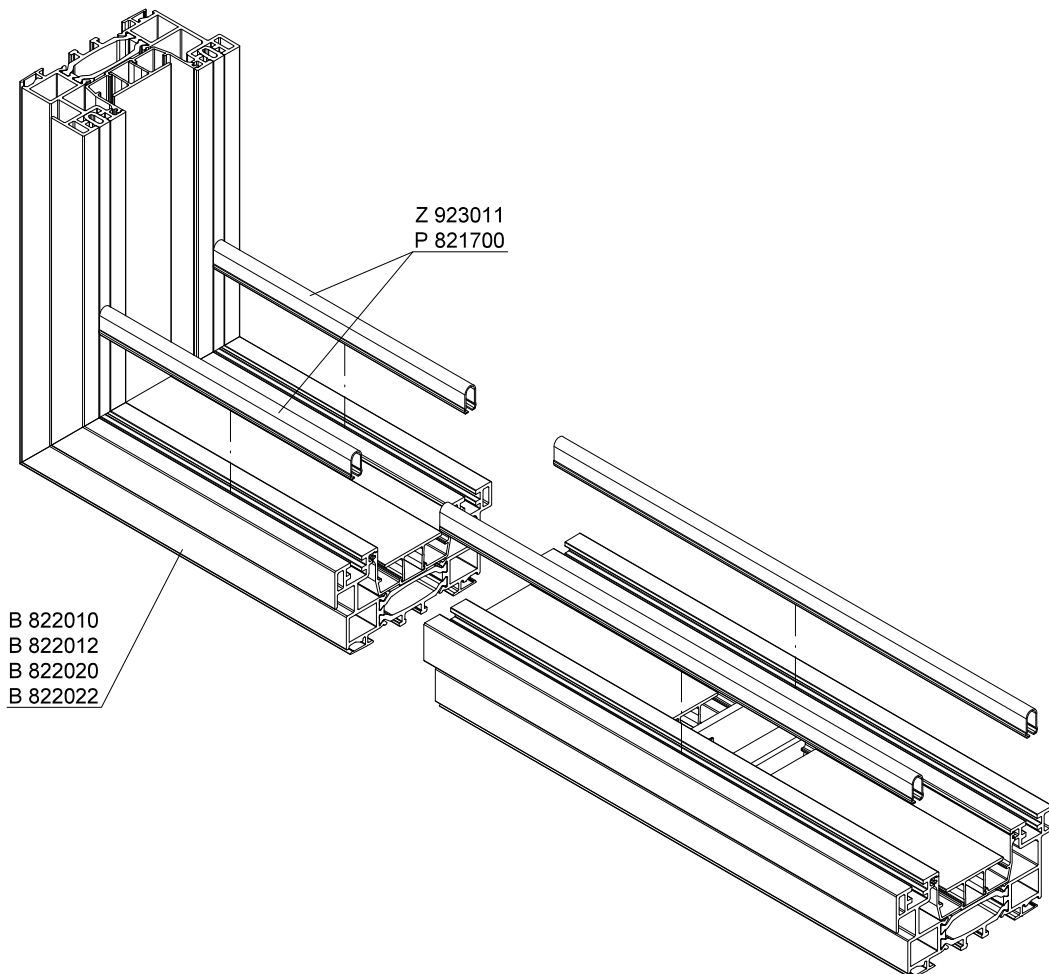
RAHMENMONTAGE
 FRAME ASSEMBLY



B 822010
 B 822012
 B 822020
 B 822022

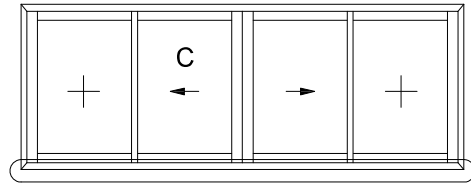
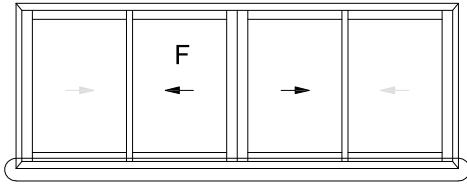


B 822010
 B 822012
 B 822020
 B 822022

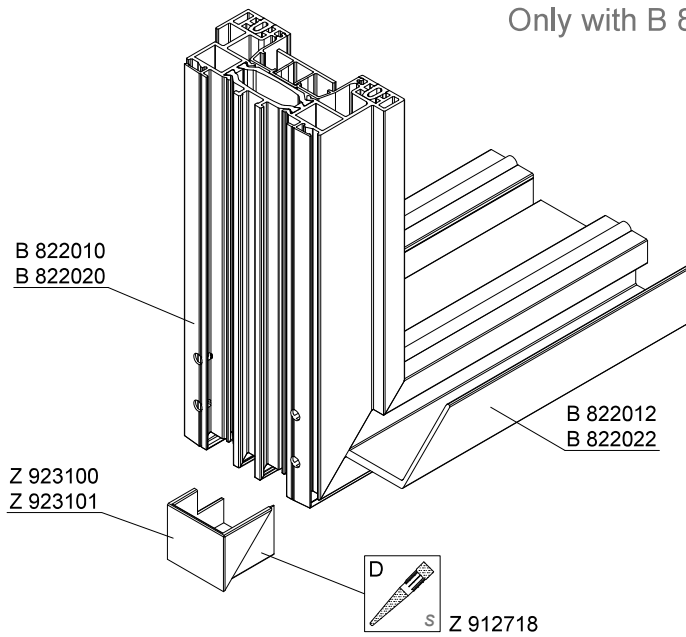


B 822010
 B 822012
 B 822020
 B 822022

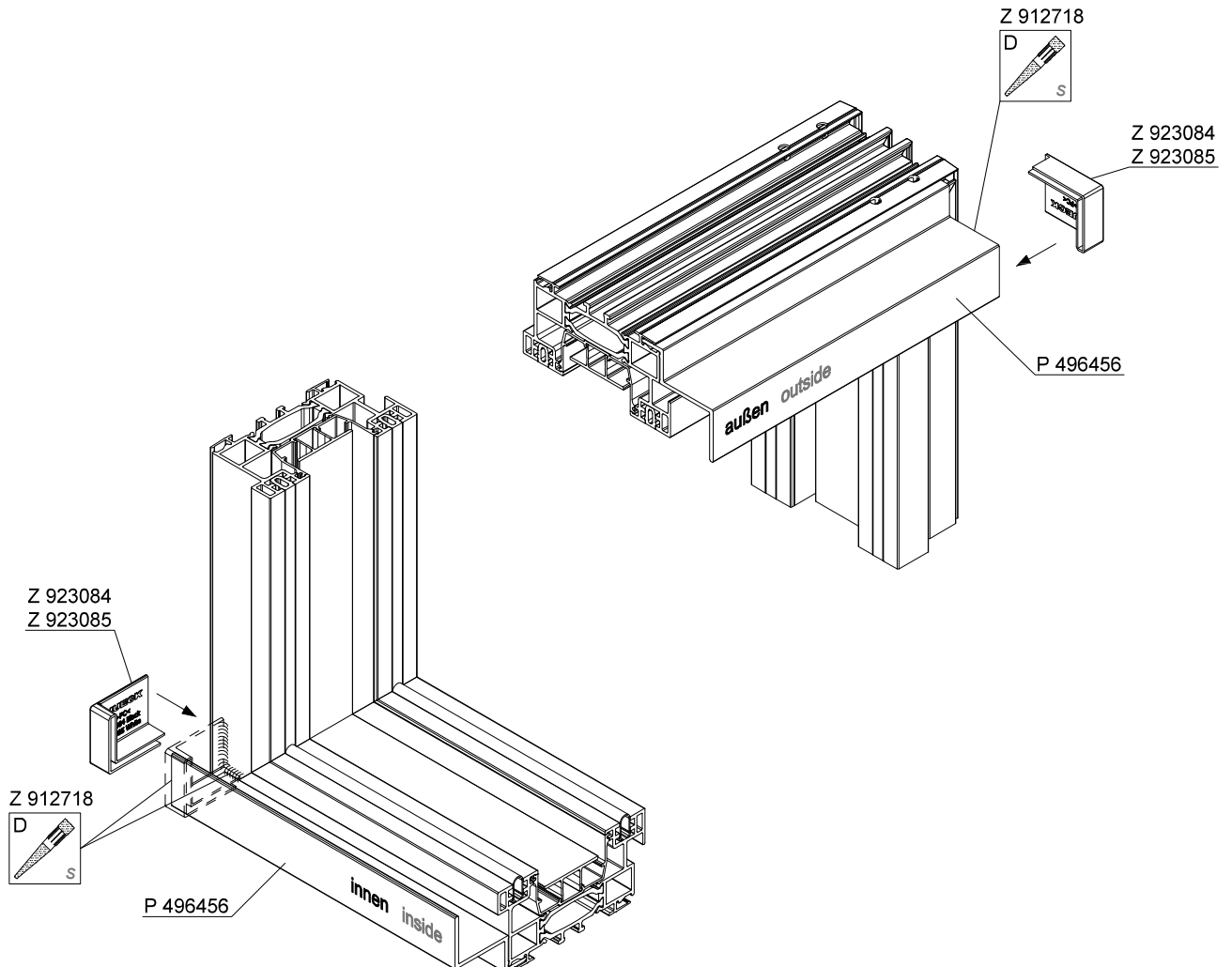
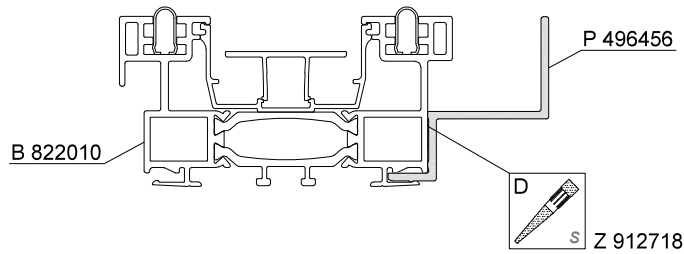
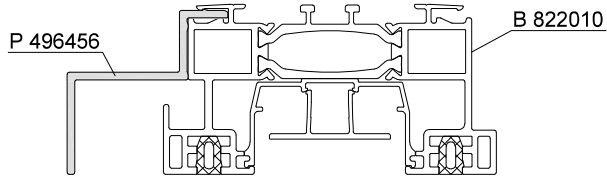
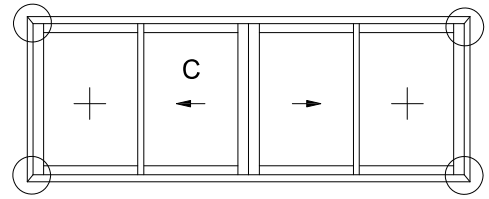
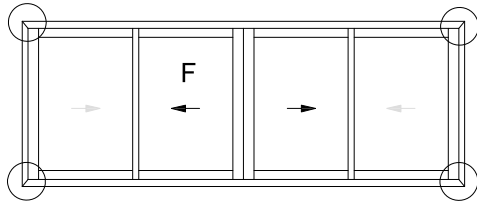
RAHMENMONTAGE
FRAME ASSEMBLY



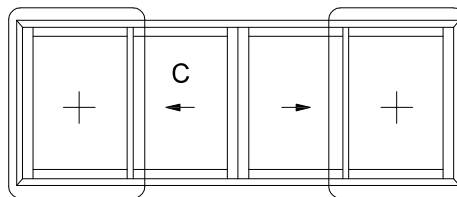
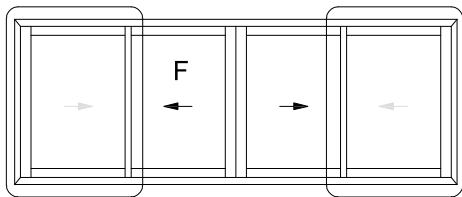
Nur bei B 822012 / B 822022
Only with B 822012 / B 822022



RAHMENMONTAGE
 FRAME ASSEMBLY



FLÜGELMONTAGE
SASH ASSEMBLY

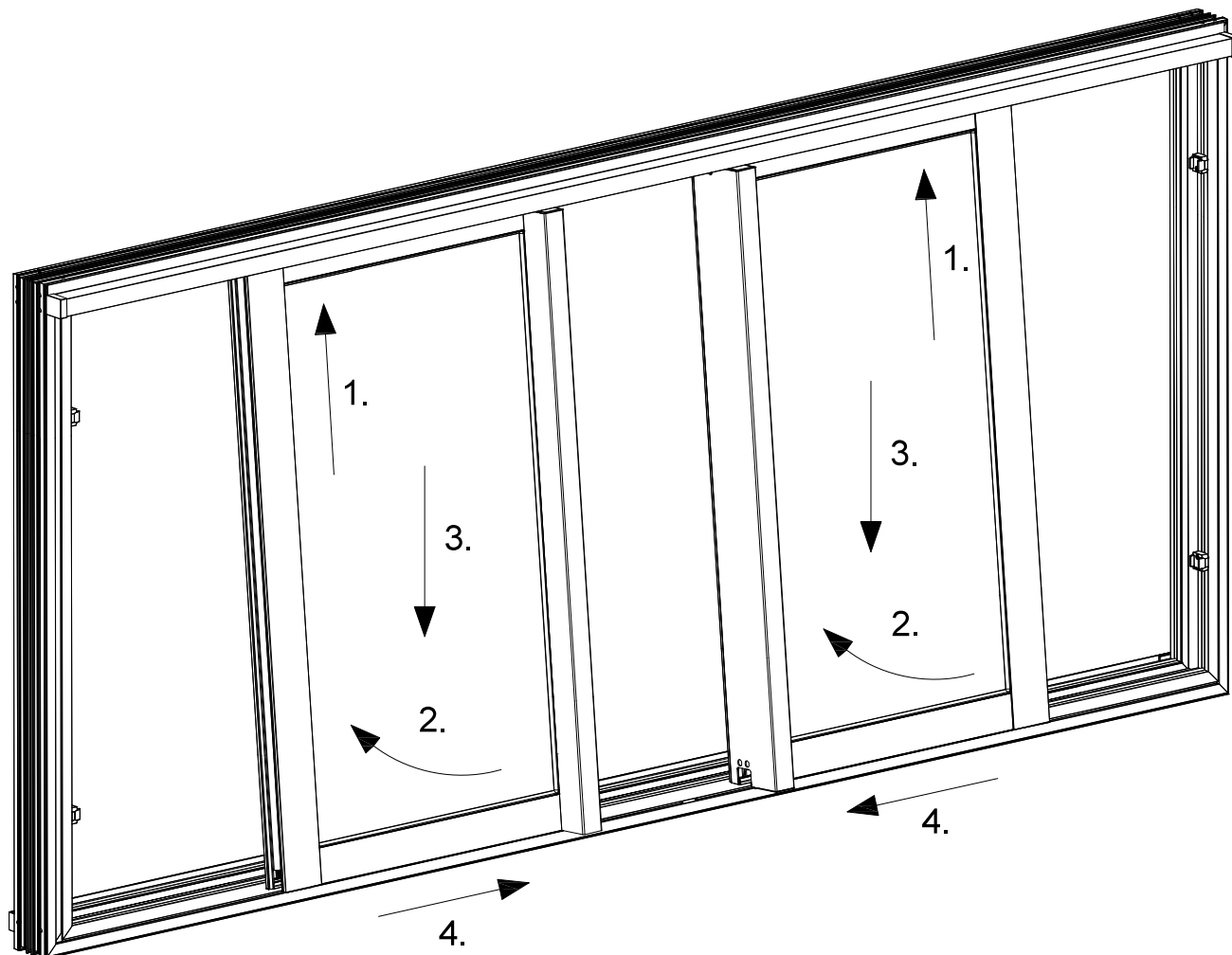


Bearbeitungsschritte

1. Äußere Flügel montieren
(Siehe Kapitel Verarbeitung / Montage Flügel)
2. Äußere Flügel einhängen

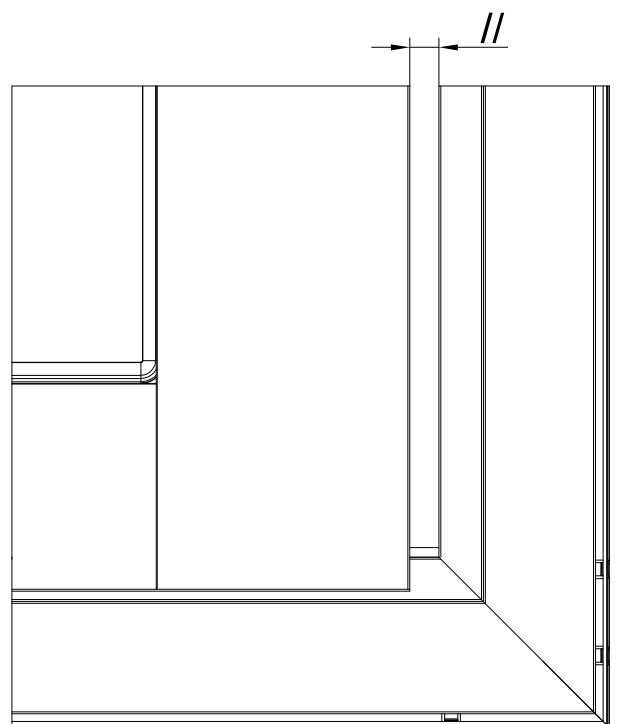
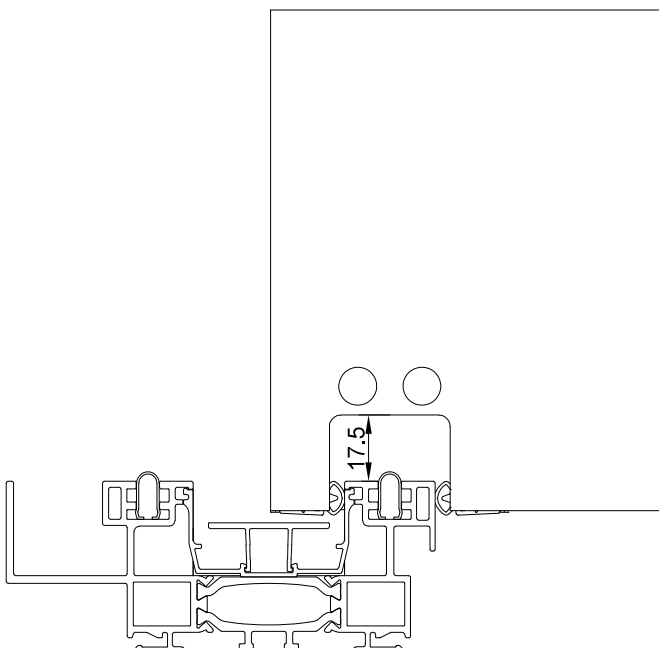
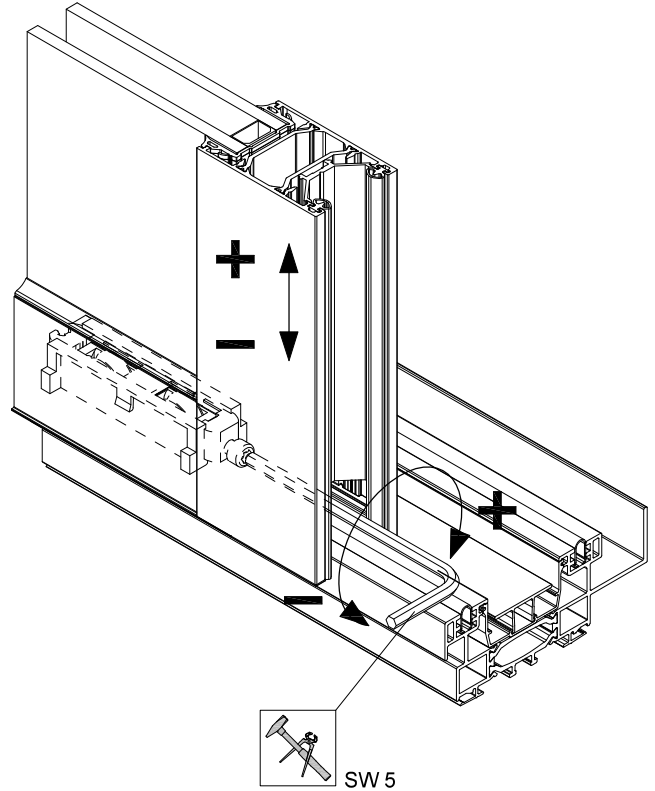
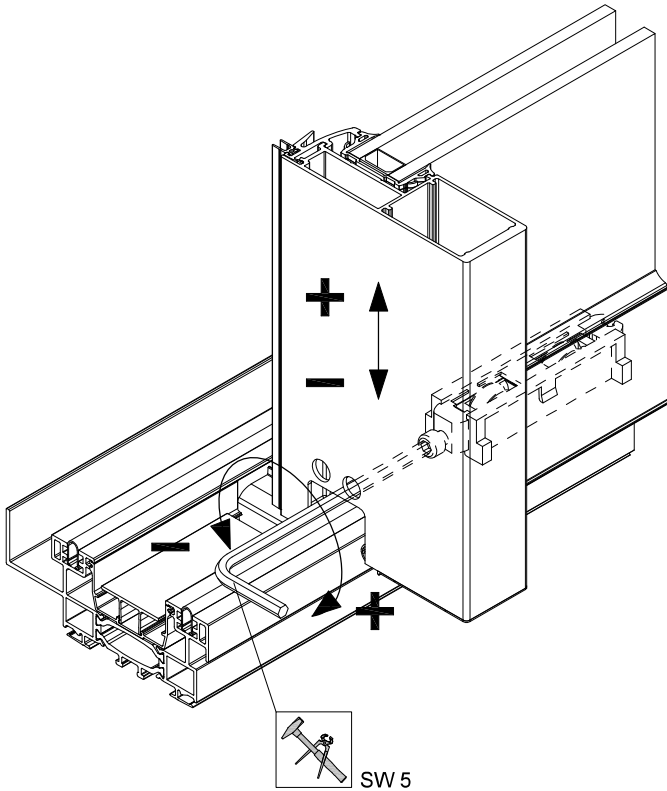
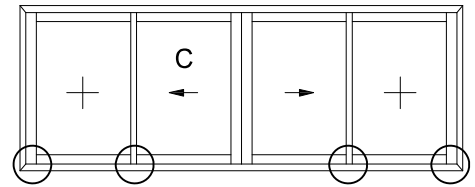
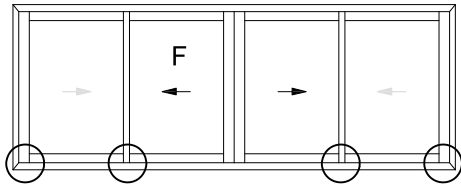
Processing steps

1. Assemble the outer sash
(see chapter processing / assembly sash)
2. Insert the outer sash

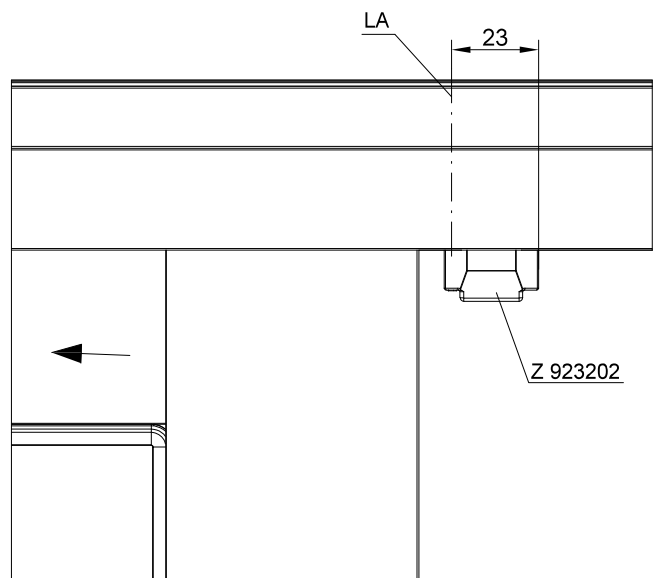
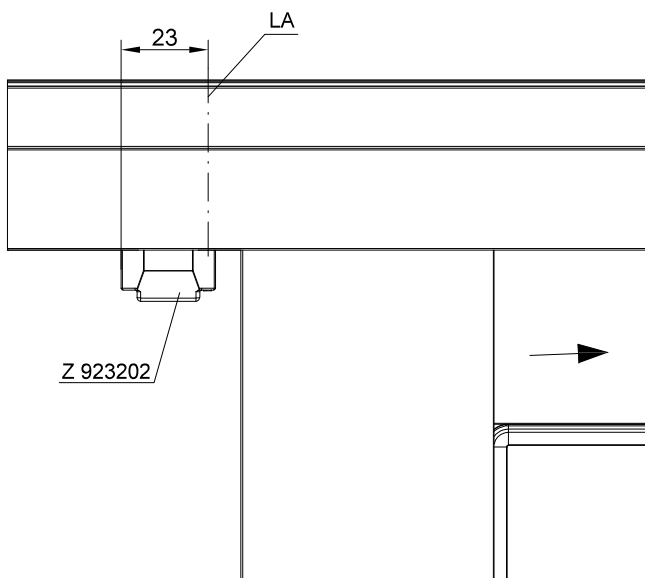
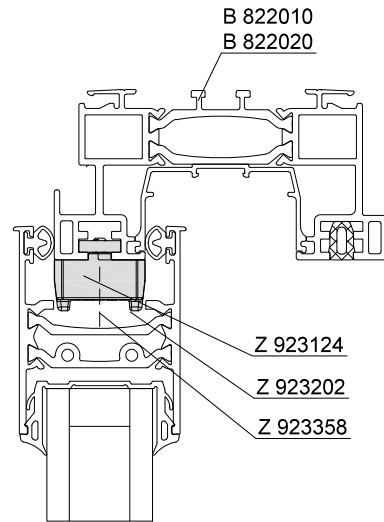
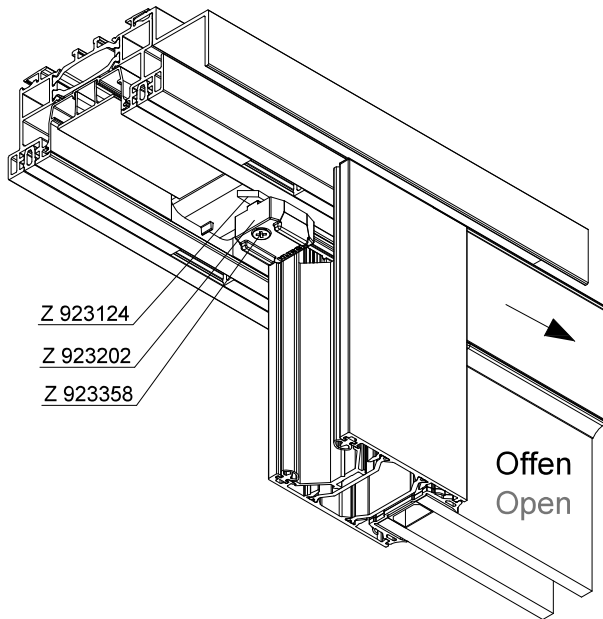
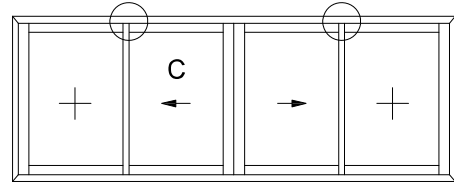
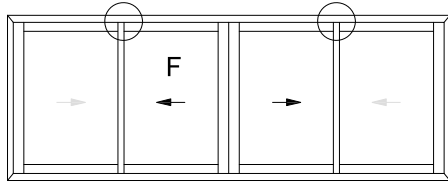


Ansicht von Außen
Outside view

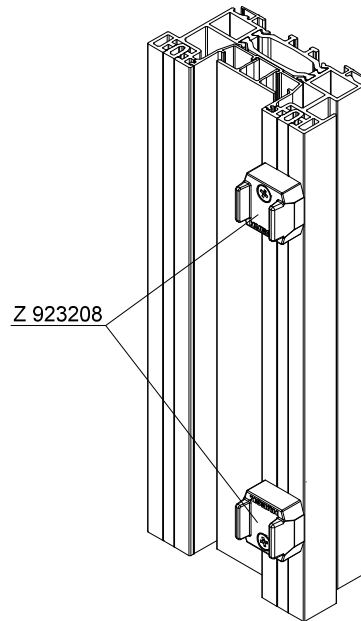
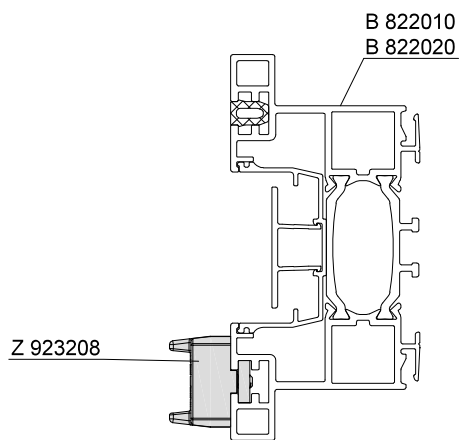
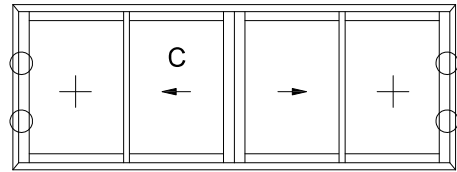
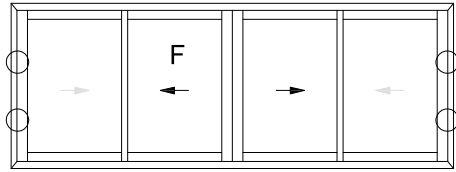
FLÜGELMONTAGE
 SASH ASSEMBLY



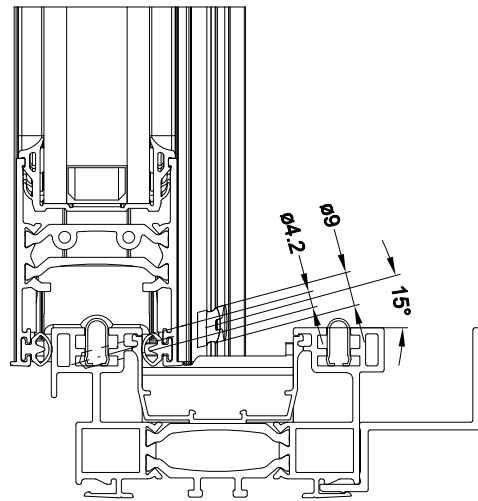
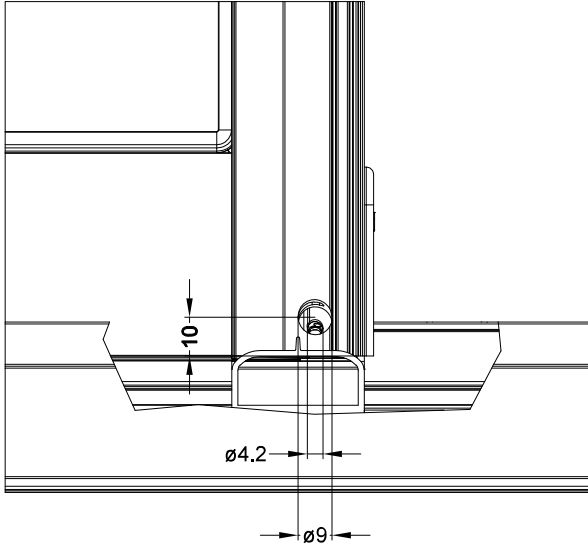
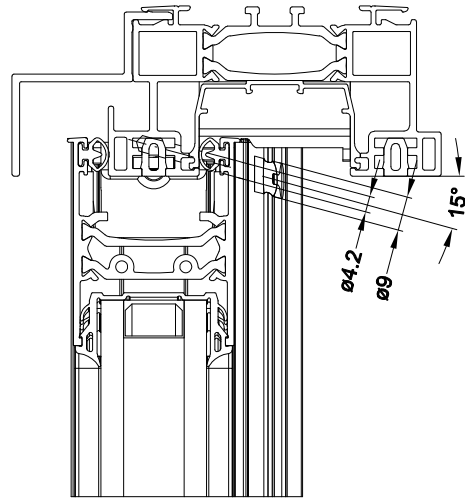
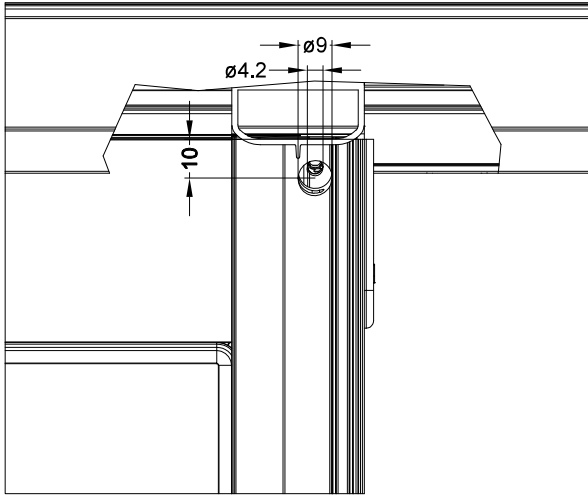
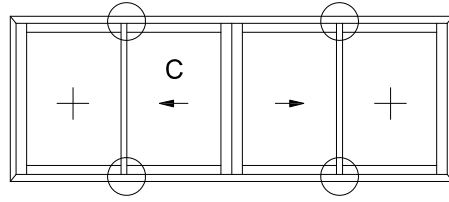
FLÜGELMONTAGE
SASH ASSEMBLY



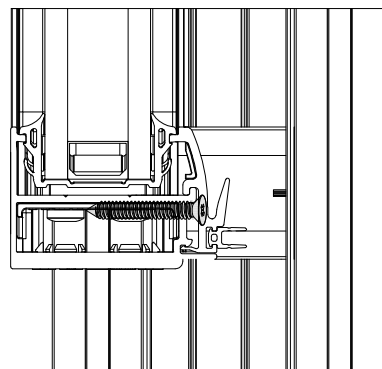
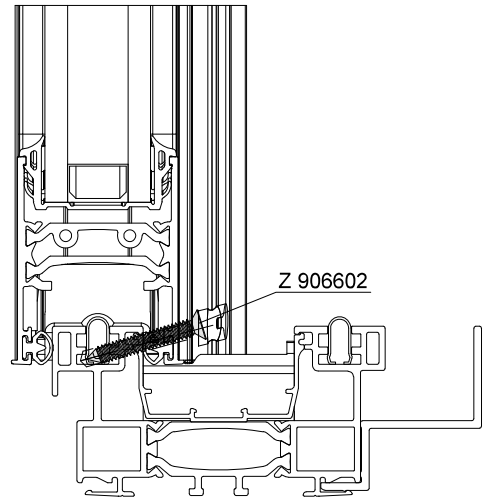
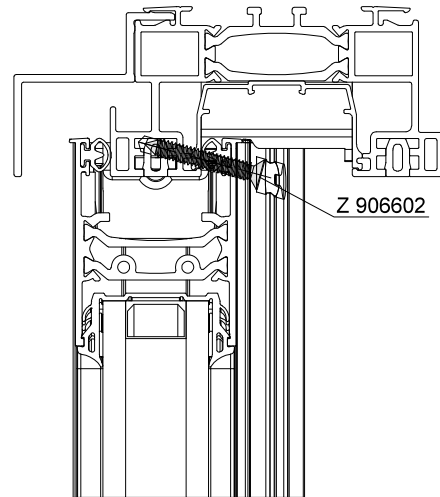
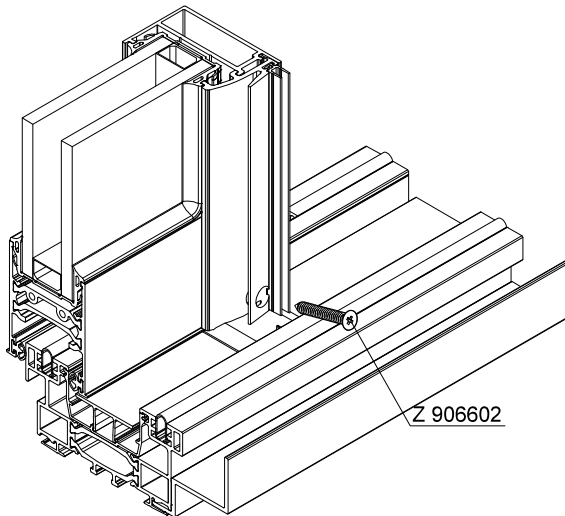
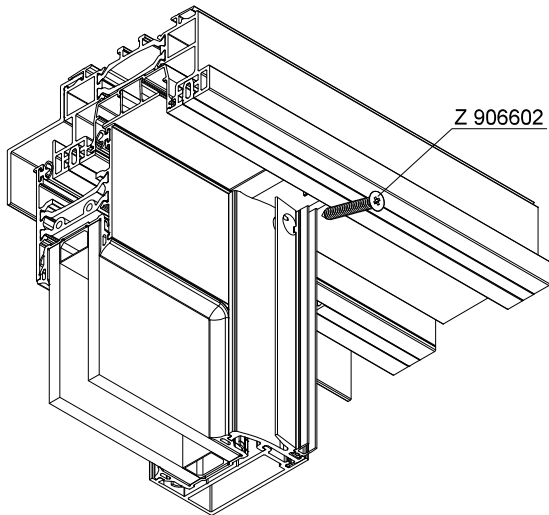
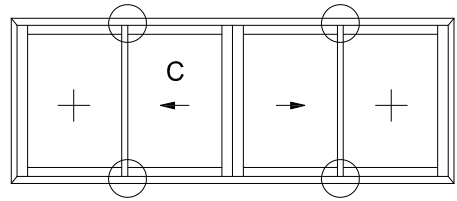
FLÜGELMONTAGE
SASH ASSEMBLY



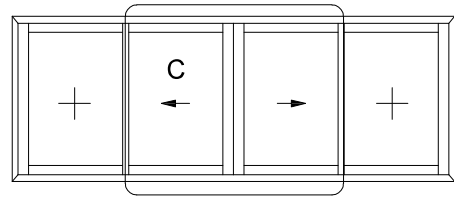
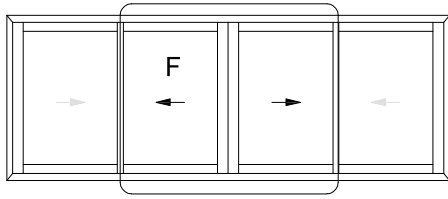
FLÜGELMONTAGE
SASH ASSEMBLY



FLÜGELMONTAGE
 SASH ASSEMBLY



FLÜGELMONTAGE
SASH ASSEMBLY

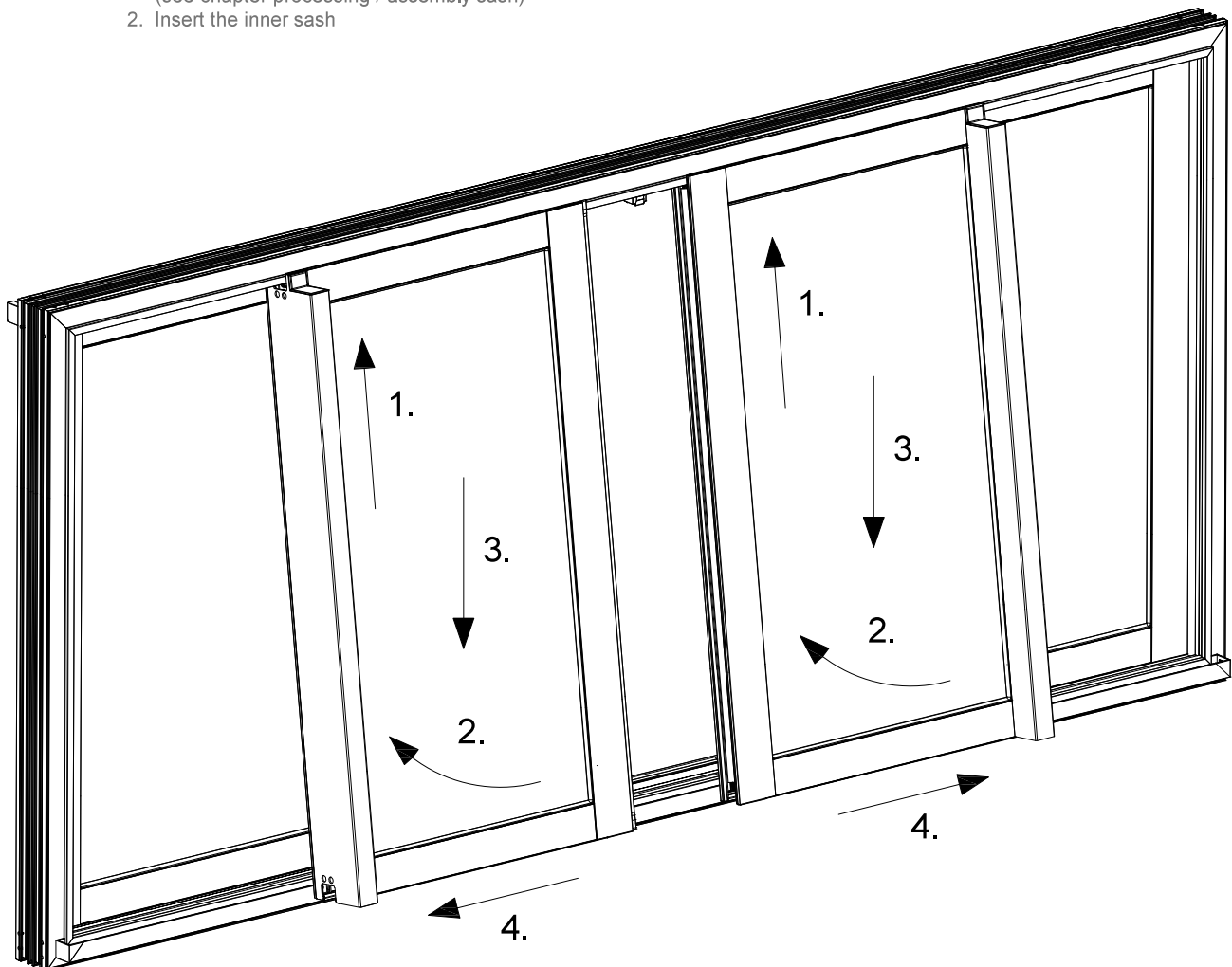


Bearbeitungsschritte

1. Inneren Flügel montieren
(Siehe Kapitel Verarbeitung / Montage Flügel)
2. Inneren Flügel einhängen

Processing steps

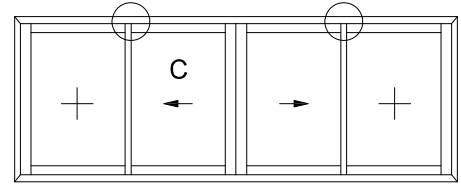
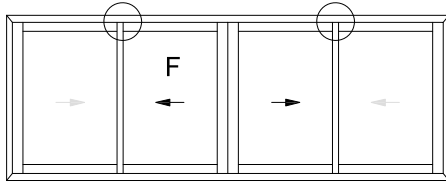
1. Assemble the inner sash
(see chapter processing / assembly sash)
2. Insert the inner sash



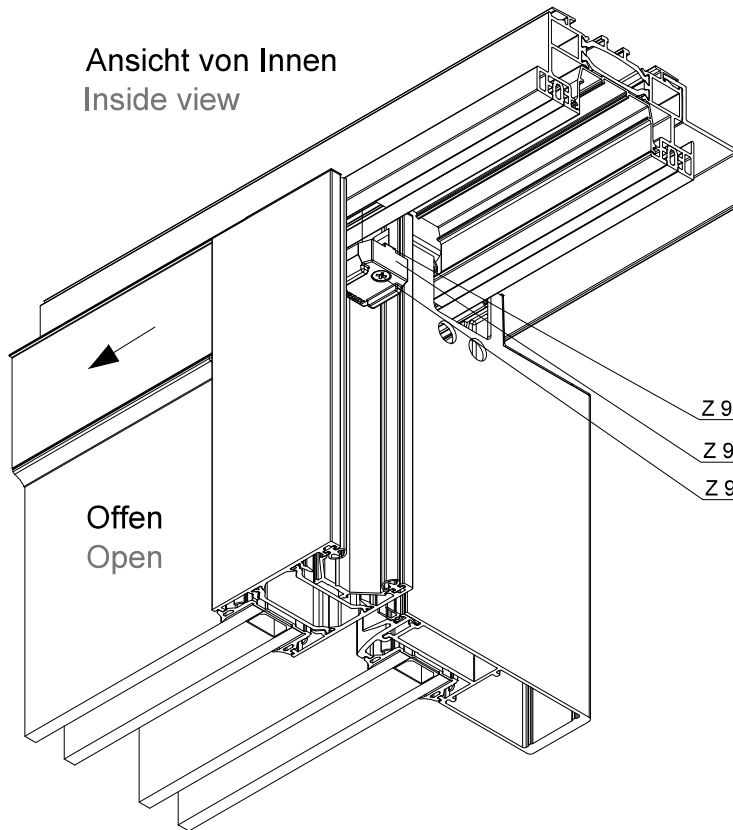
Ansicht von Innen
Inside view

Der äußere Griff + Stopper muss demontiert sein.
The outer handle + stopper has to be dismantled

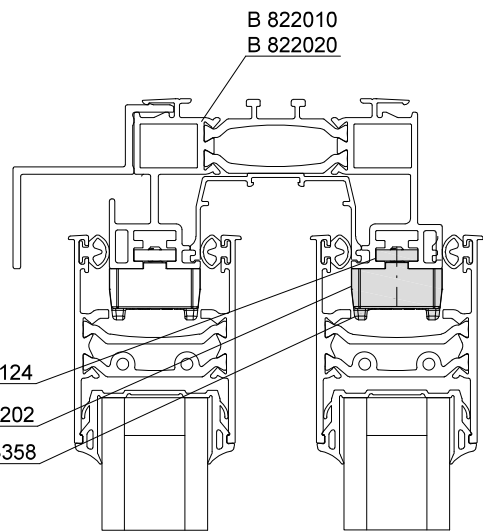
FLÜGELMONTAGE
 SASH ASSEMBLY



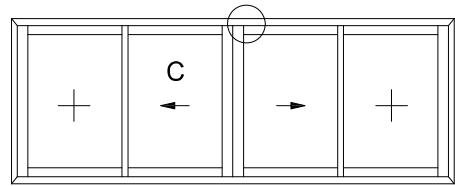
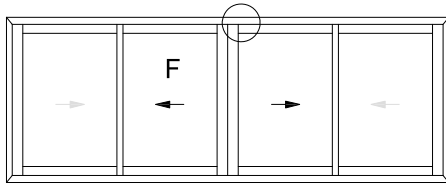
Ansicht von Innen
 Inside view



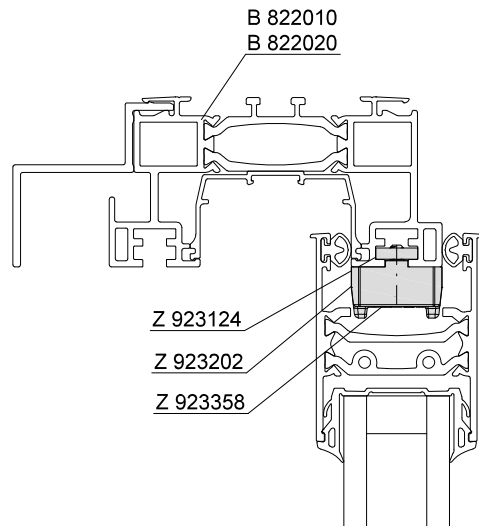
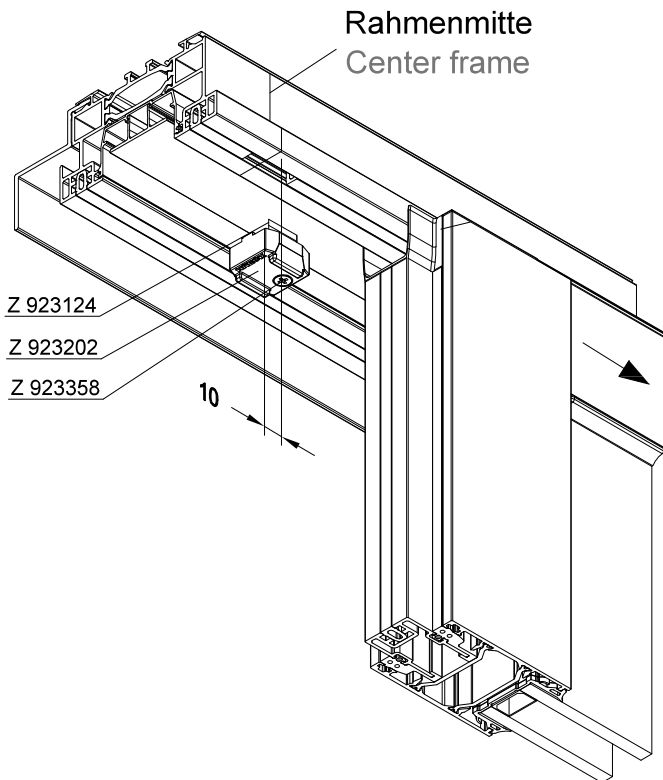
Z 923124
 Z 923202
 Z 923358



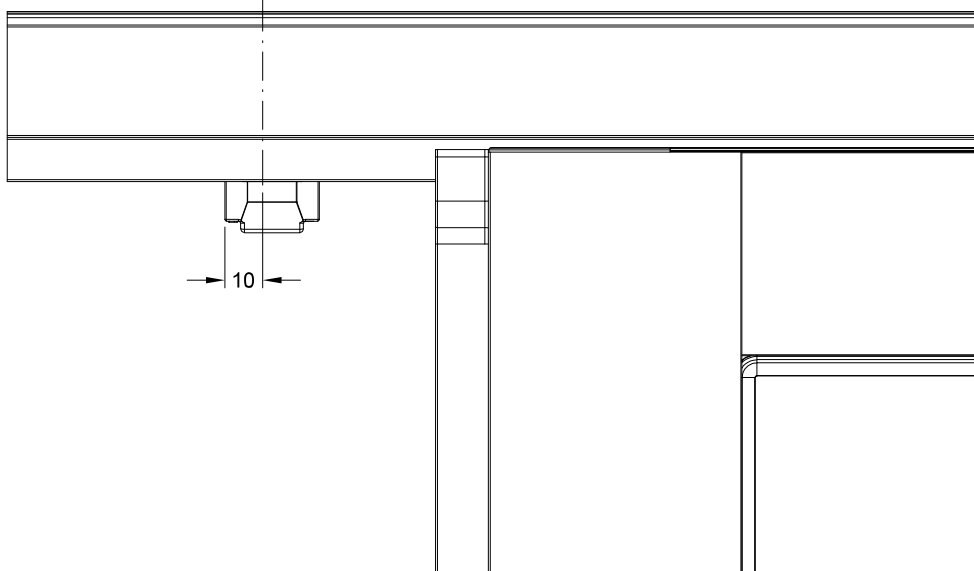
FLÜGELMONTAGE
 SASH ASSEMBLY



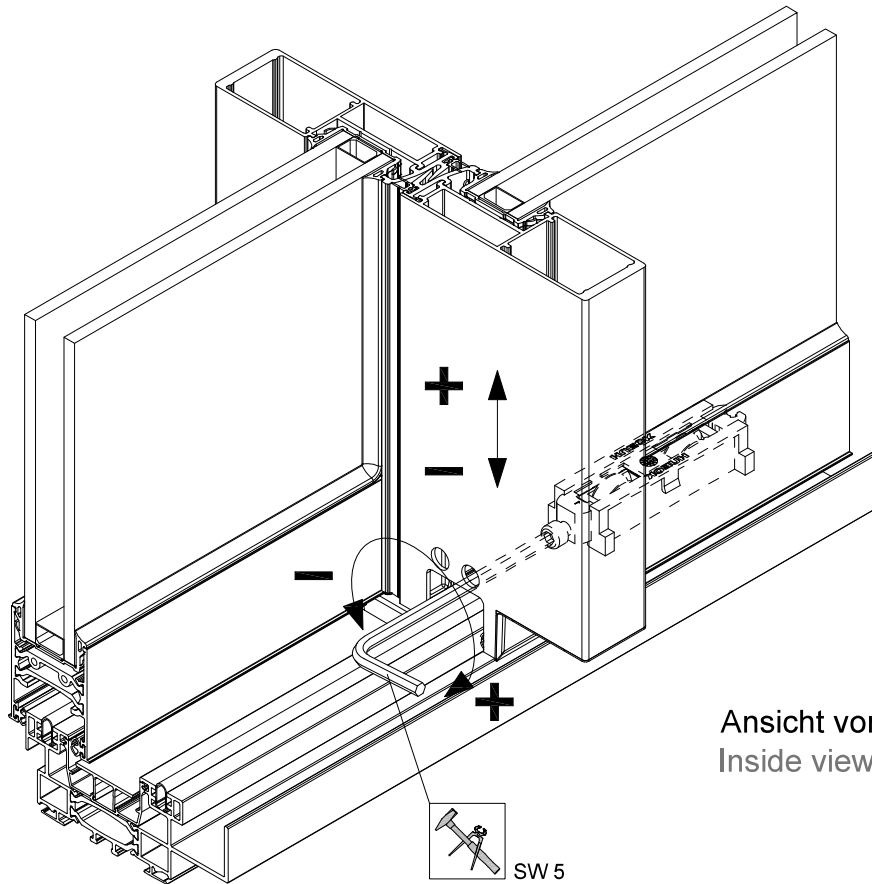
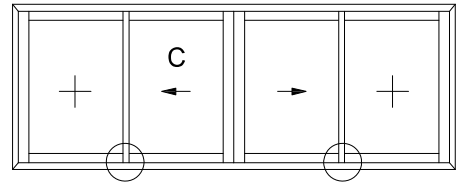
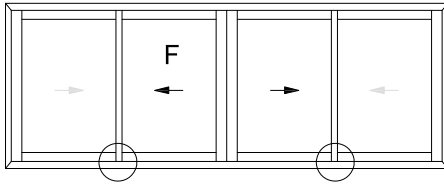
Ansicht von Innen
 Inside view



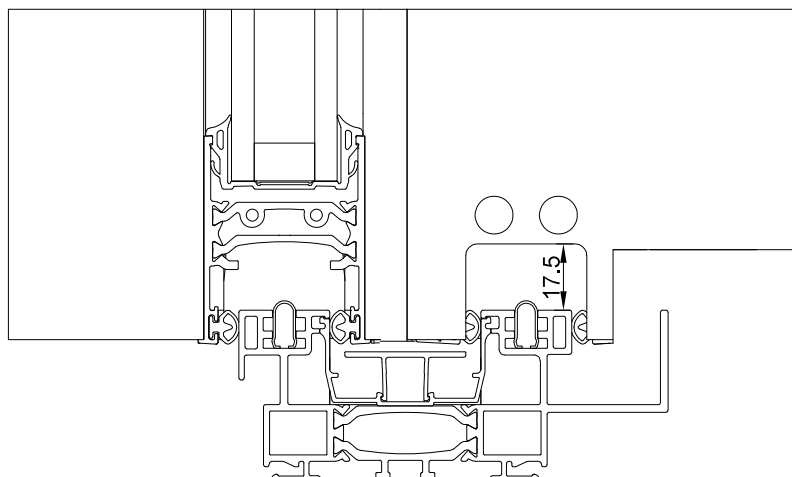
Rahmenmitte
 Center frame



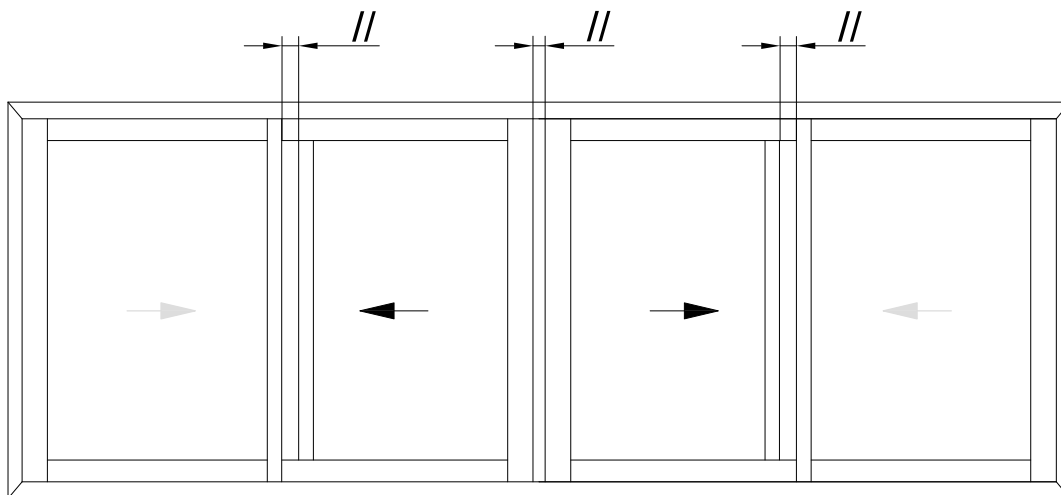
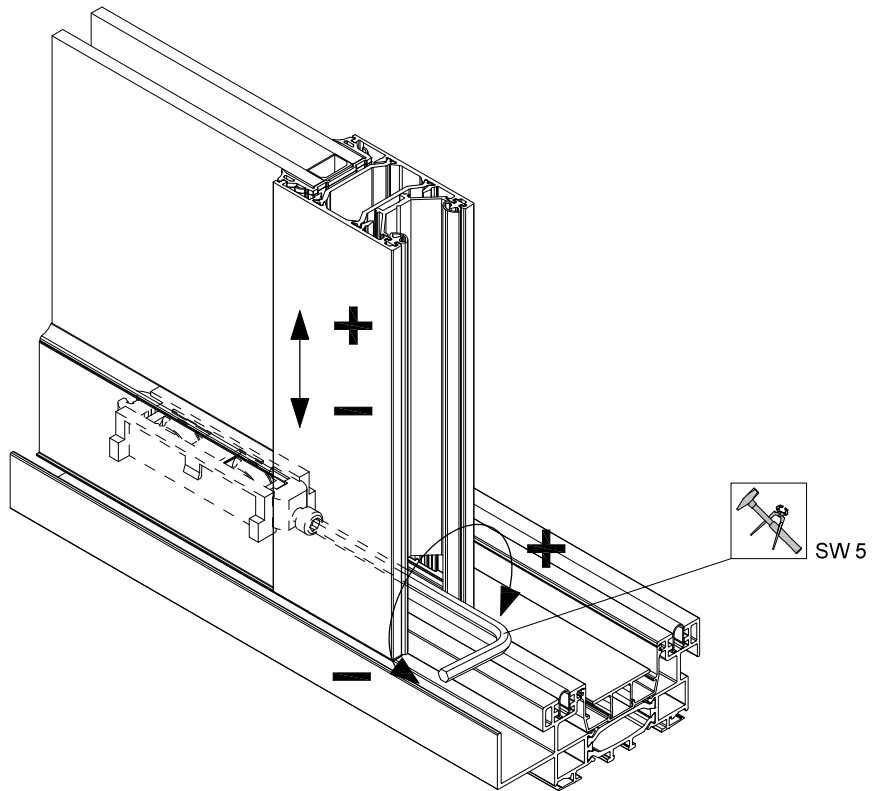
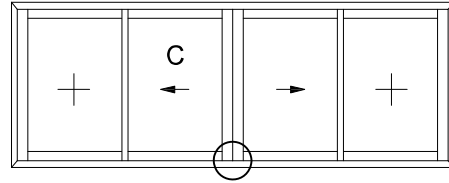
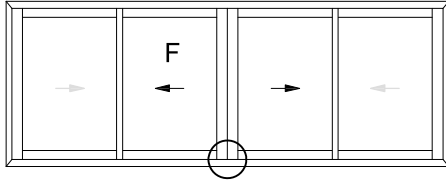
FLÜGELMONTAGE
 SASH ASSEMBLY



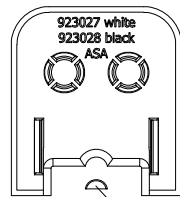
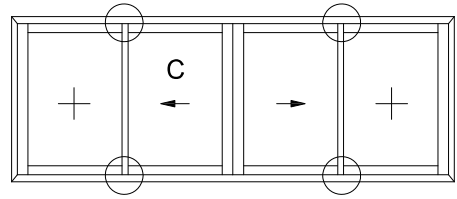
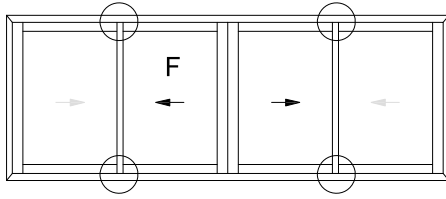
Ansicht von Innen
 Inside view



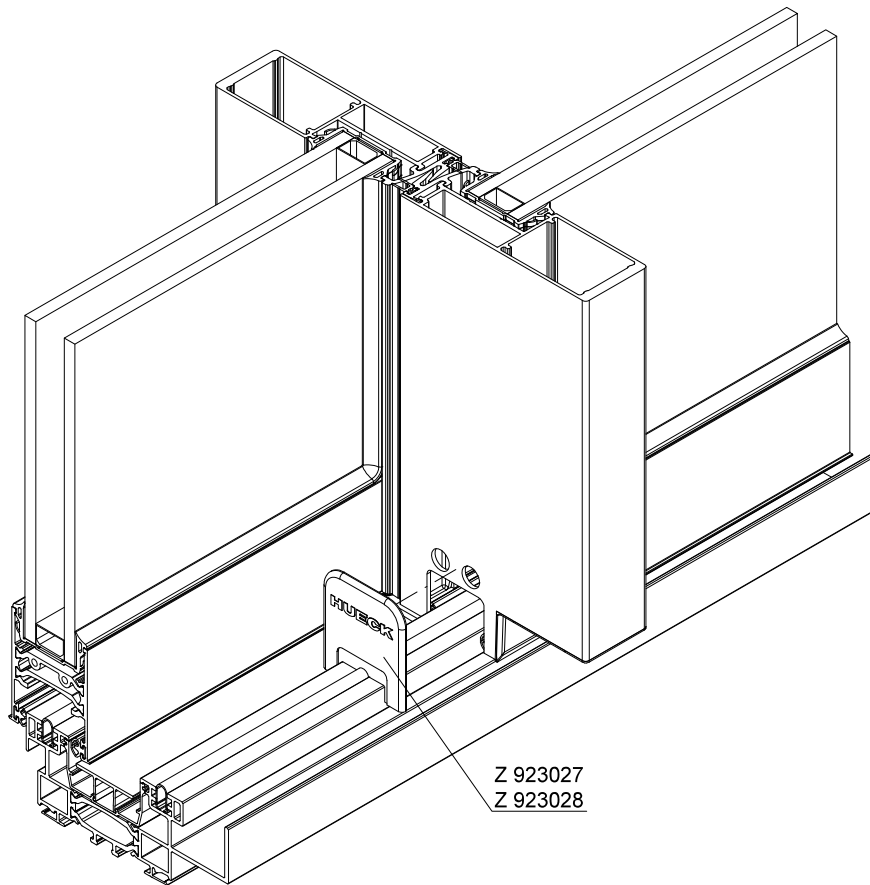
FLÜGELMONTAGE
SASH ASSEMBLY



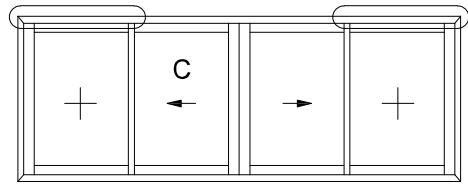
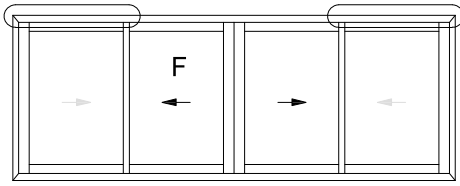
FLÜGELMONTAGE
 SASH ASSEMBLY



Nur unten
 Only below

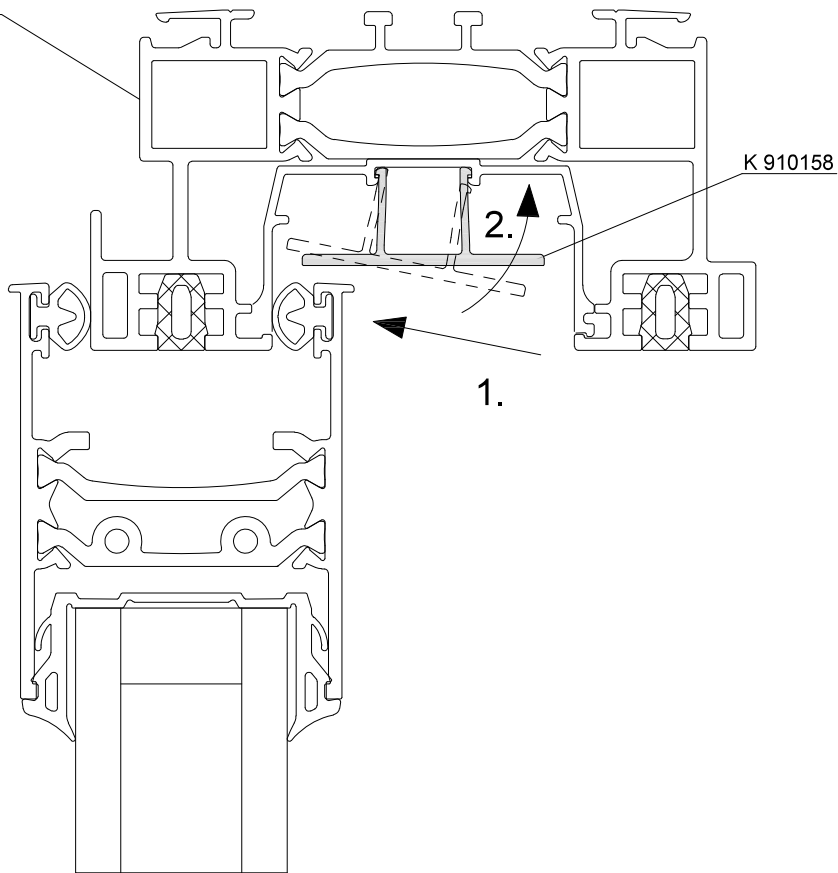


RAHMENMONTAGE
FRAME ASSEMBLY

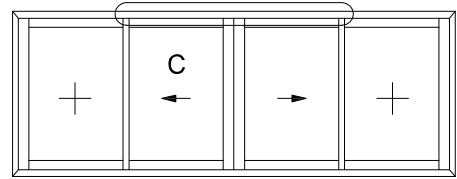
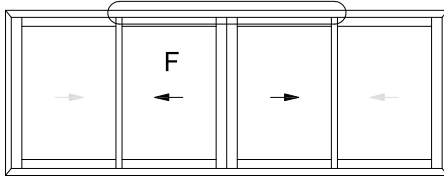


Optional

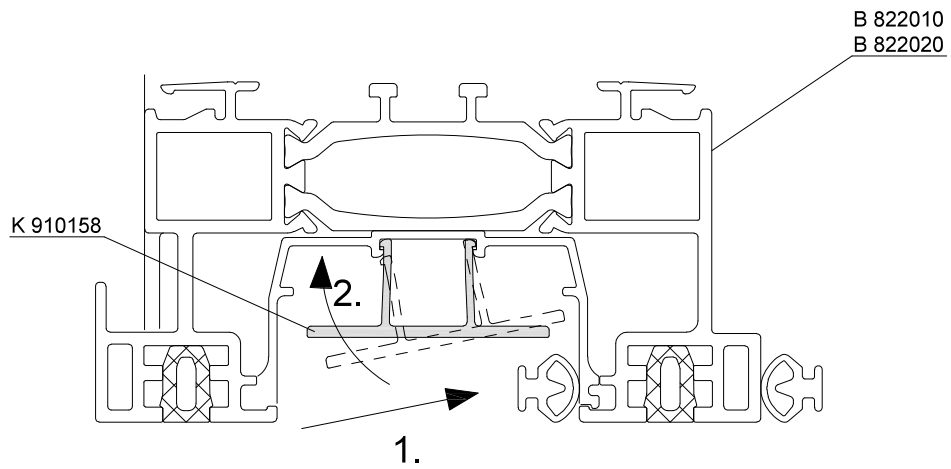
B 822010
B 822020

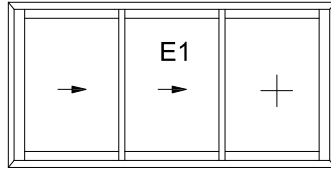


RAHMENMONTAGE
 FRAME ASSEMBLY

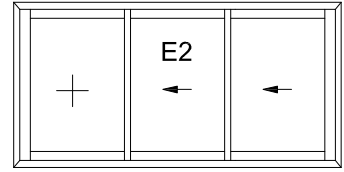


Optional

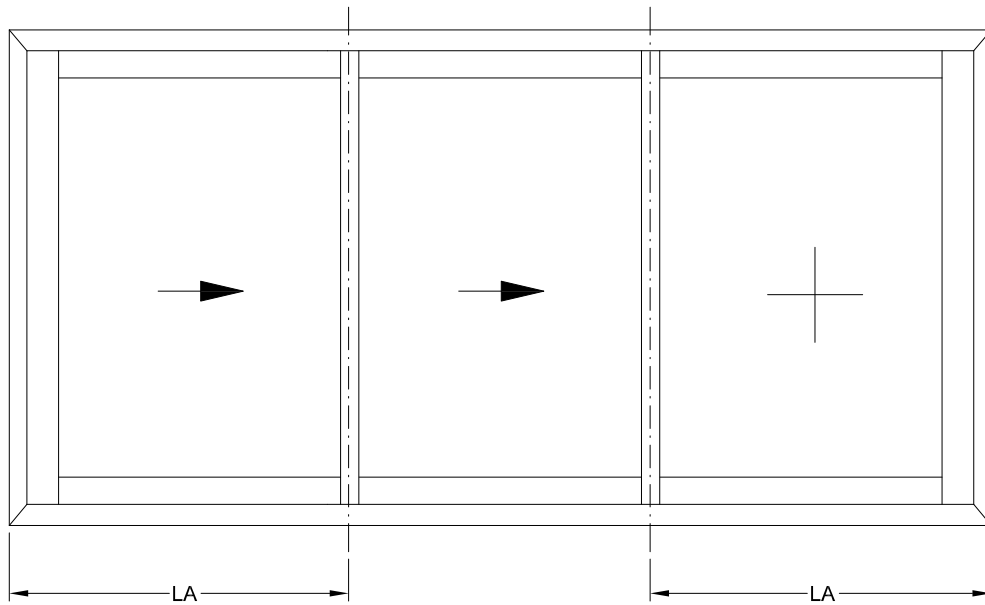




Schema E1 dargestellt
 Scheme E1 shown



Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted



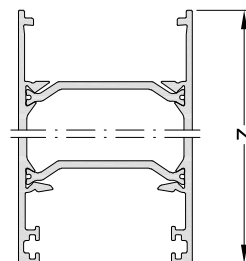
Bei gleichen Glasbreiten:

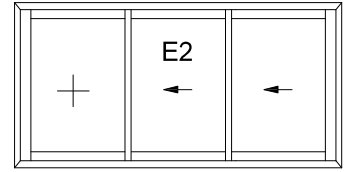
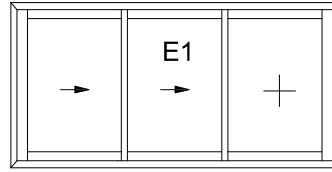
$$LA = (RB + 18,5 - 2 \times Z) / 3 + Z$$

For the same glass sizes

$$LA = (RB + 18,5 - 2 \times Z) / 3 + Z$$

	Z (mm)
B 822200	67
B 822210	77

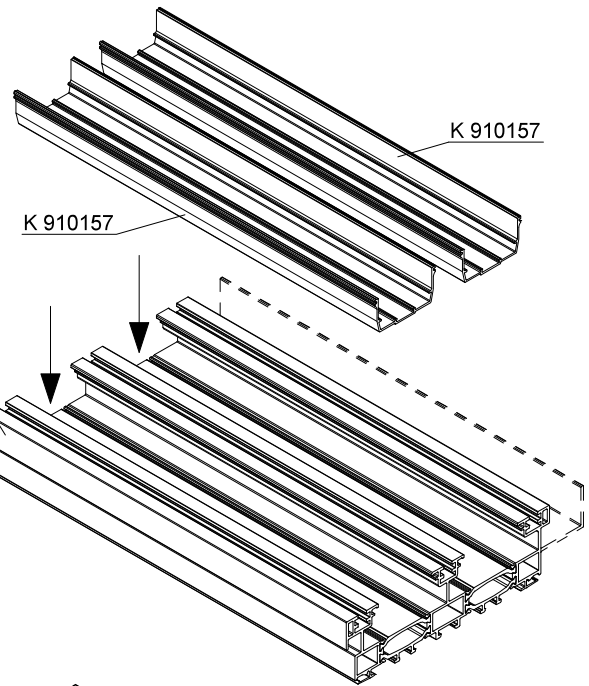
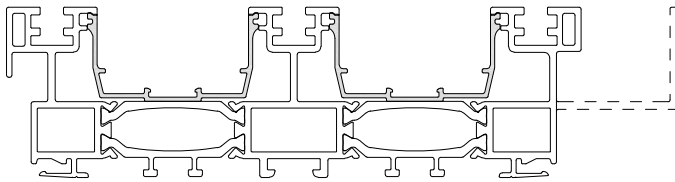




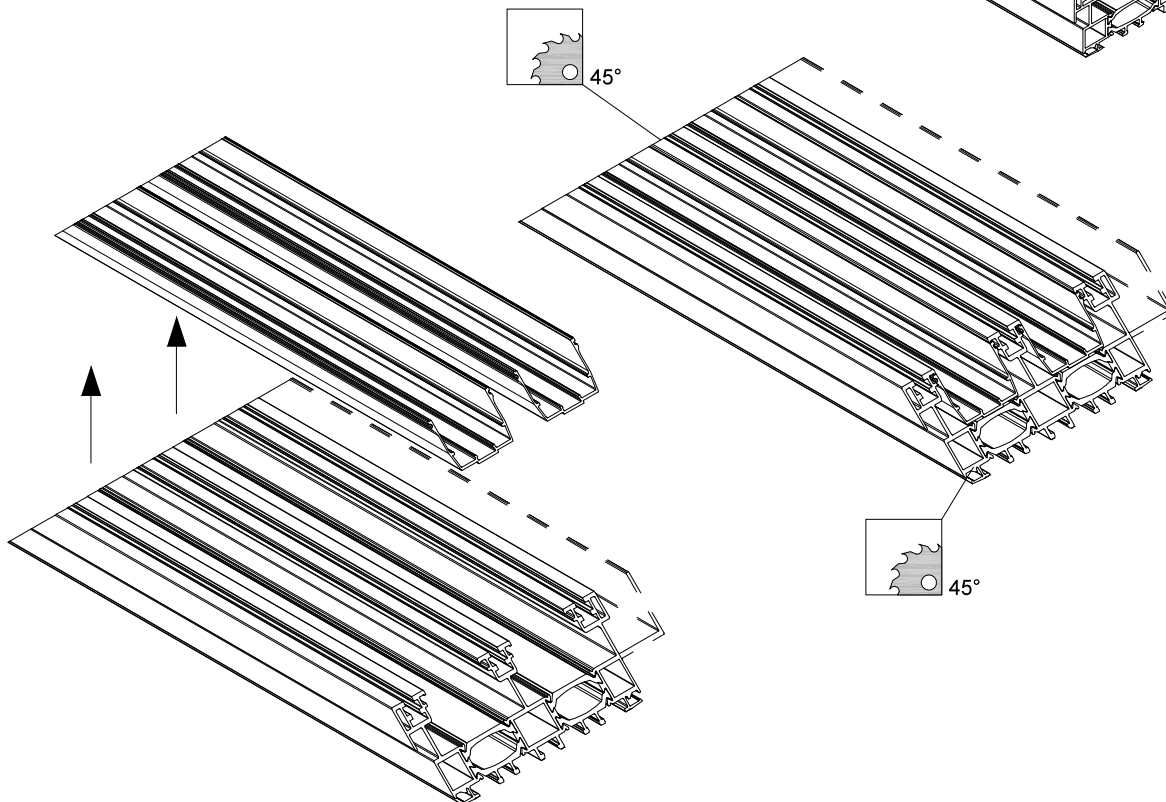
B 822011, B 822013, B 822021, B 822023

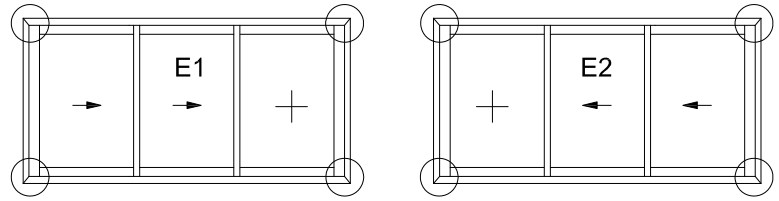
K 910157

umlaufend
circumferential



B 822011
B 822013
B 822021
B 822023

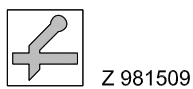
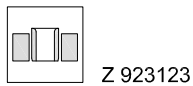
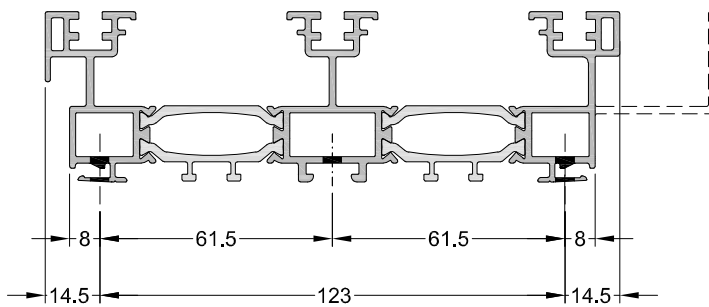
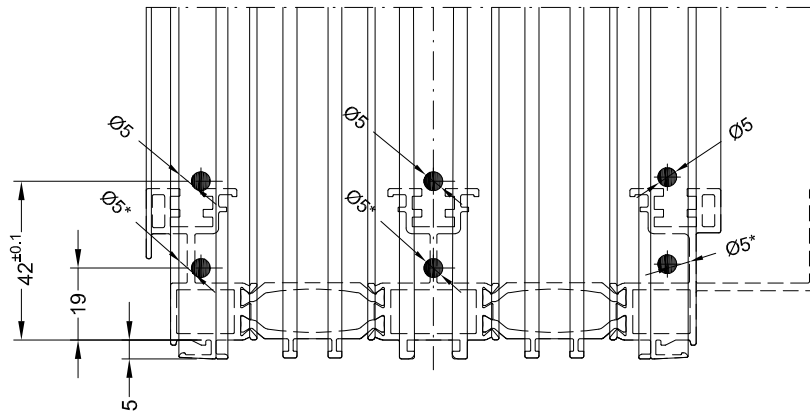


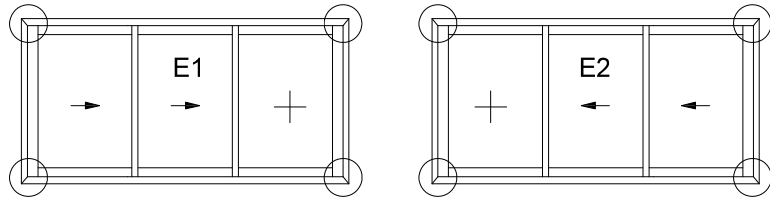


B 822011 + B 822013

* Bohrung wahlweise,
 für nachträgliche Verklebung

* drilling optional,
 for retro gluing after assembly

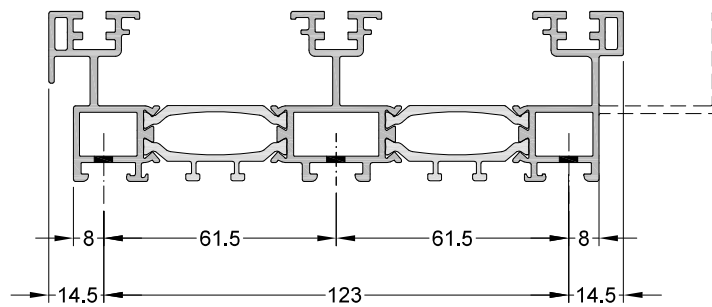
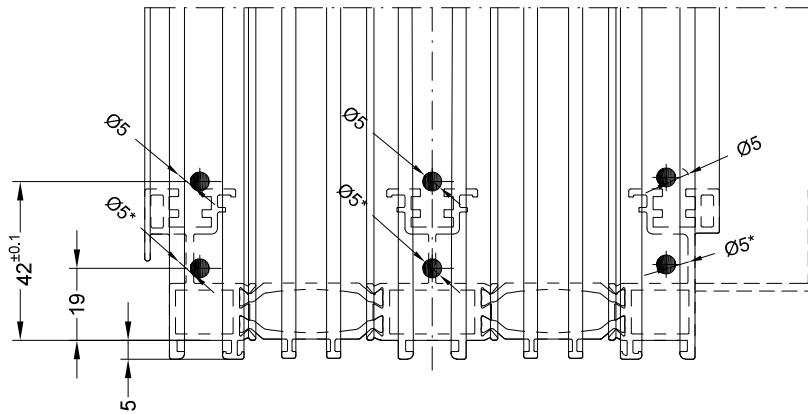




B 822021 + B 822023

* Bohrung wahlweise,
 für nachträgliche Verklebung

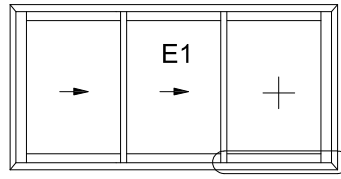
* drilling optional,
 for retro gluing after assembly



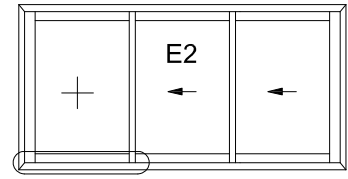
Z 923123
 Z 921426



Z 981289
 Z 981423
 Z 981191
 Z 981509

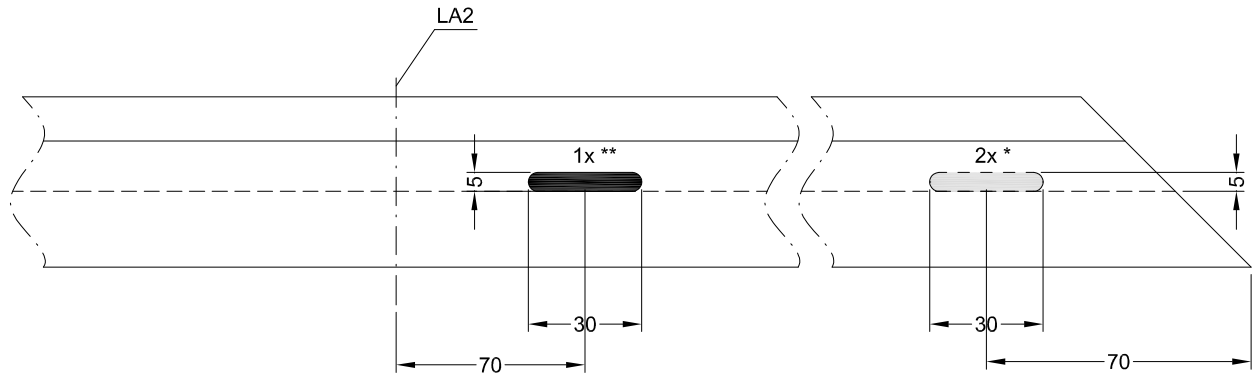


Schema E1 dargestellt
 Scheme E1 shown

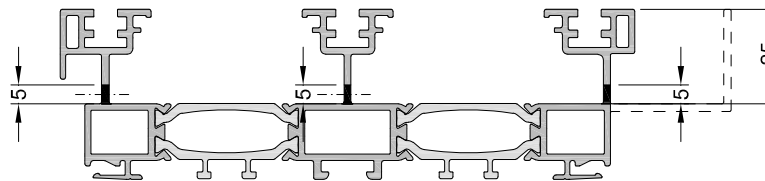


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

B 822011, B 822013, B 822021, B822023

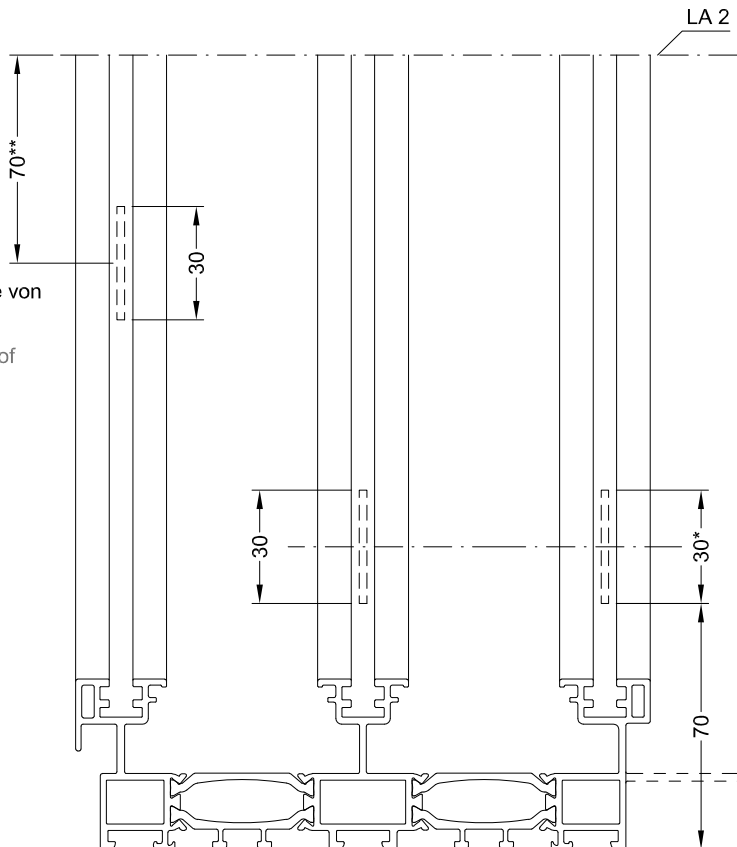


Z 981511



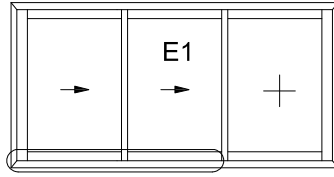
** Zur Aufnahme von
 Z 923321

** for receiving of
 Z 923321

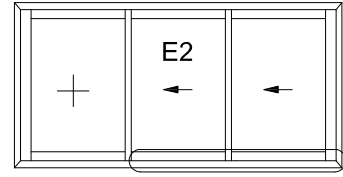


* Nur bei der Verwendung vom
 Wetterschenkel P 496456
 oder Rahmen B 822013 / B 822023 !

* only when using water bar
 P 496456 or frame B 822013 / B 823023!



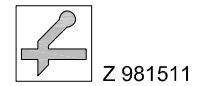
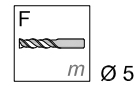
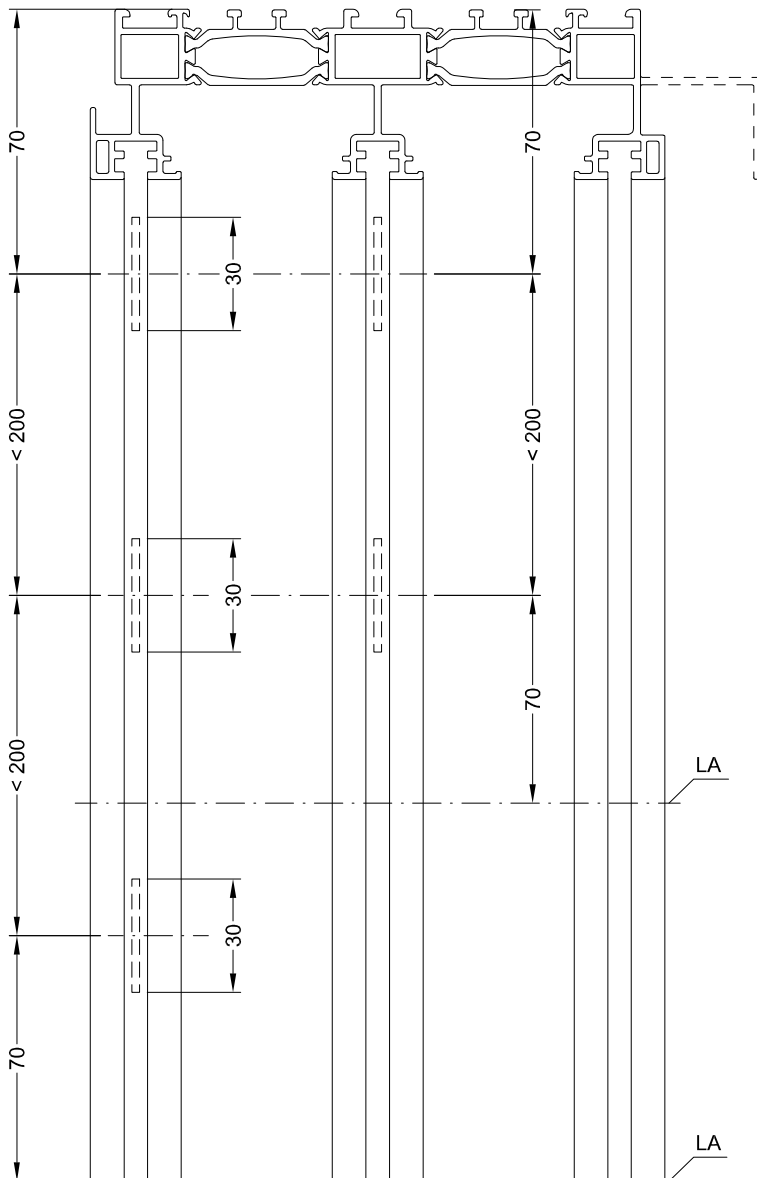
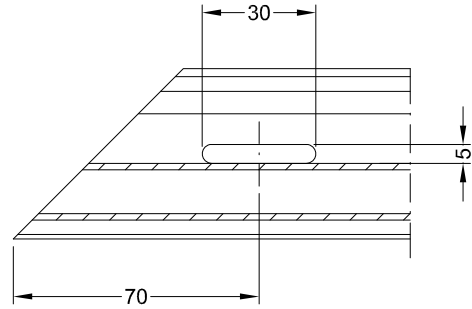
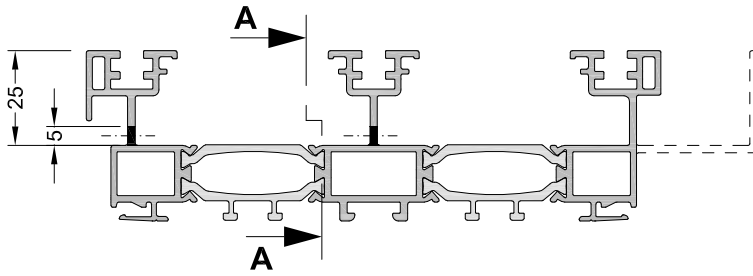
Schema E1 dargestellt
 Scheme E1 shown

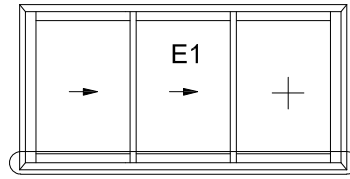


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

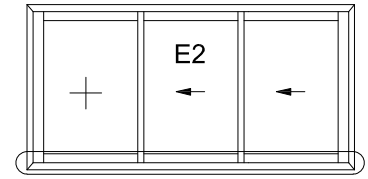
B 821011, B 821013, B 821021, B821051

A - A



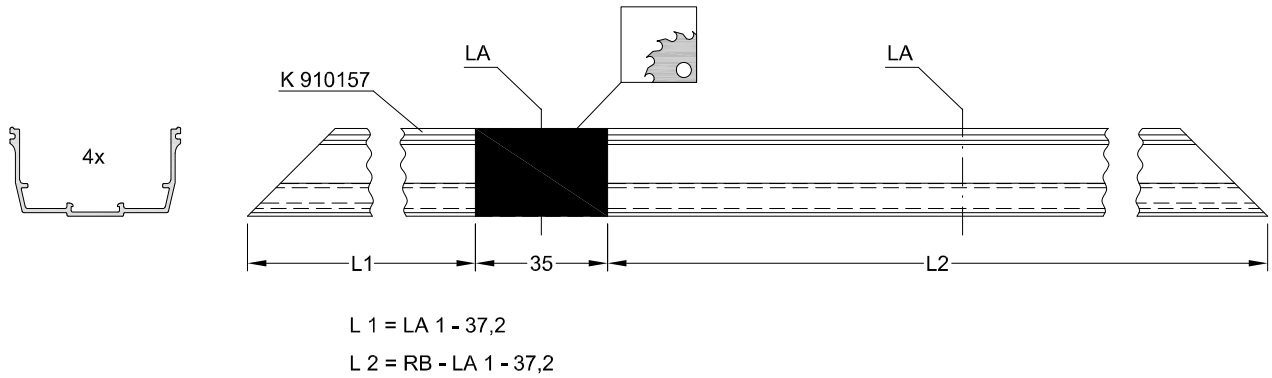


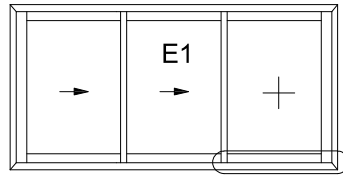
Schema E1 dargestellt
 Scheme E1 shown



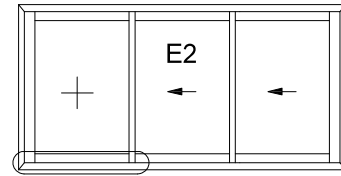
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

K 910157 + K 910158

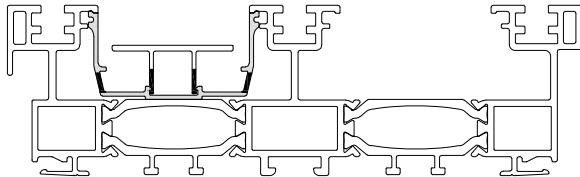




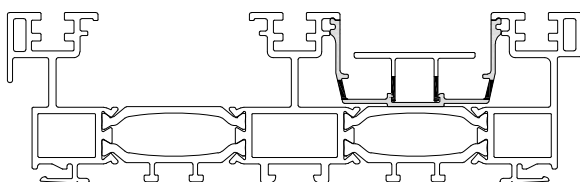
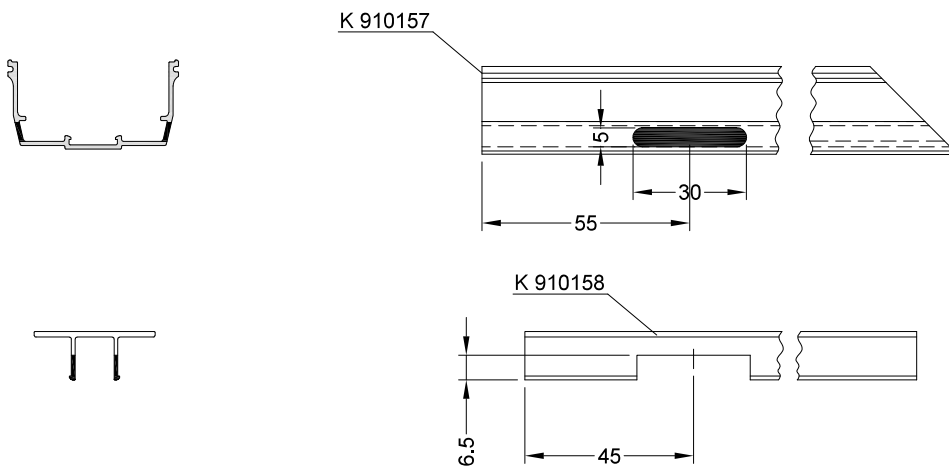
Schema E1 dargestellt
 Scheme E1 shown



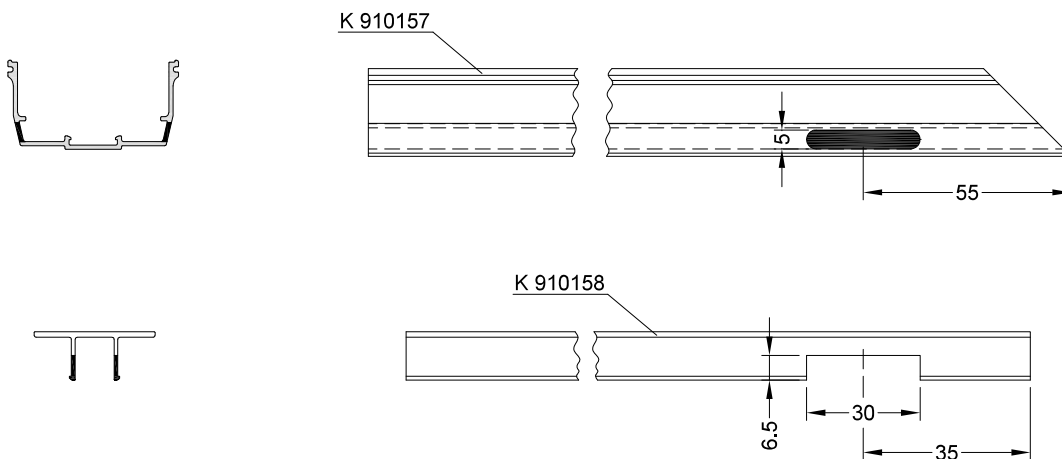
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

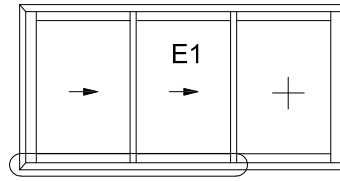


Z 981512

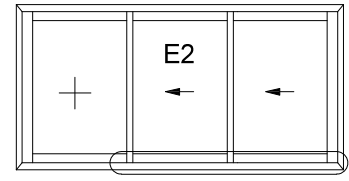


Z 981512

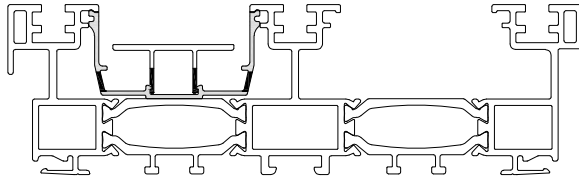




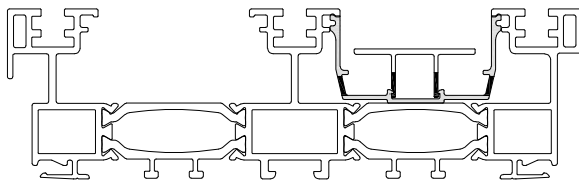
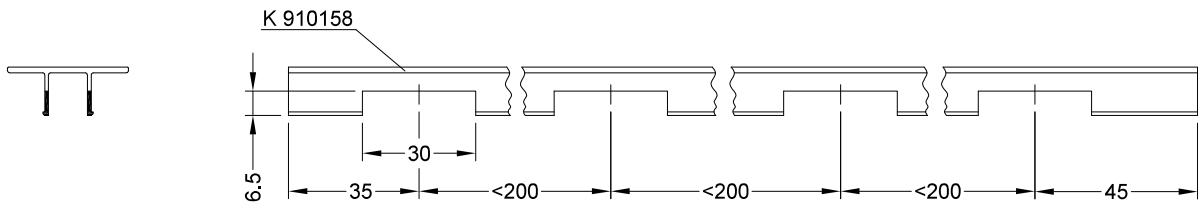
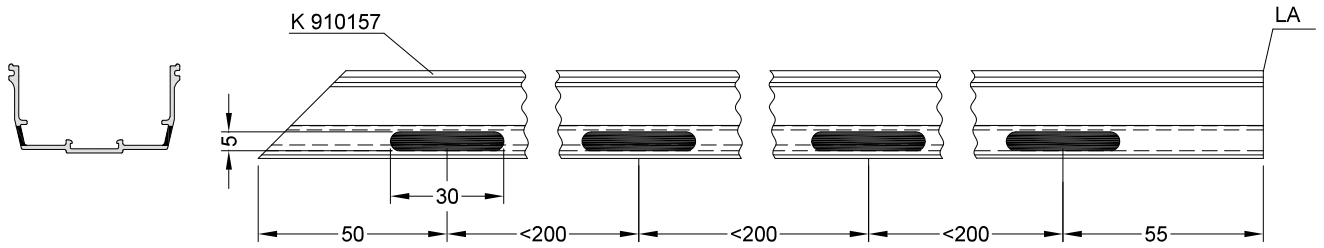
Schema E1 dargestellt
 Scheme E1 shown



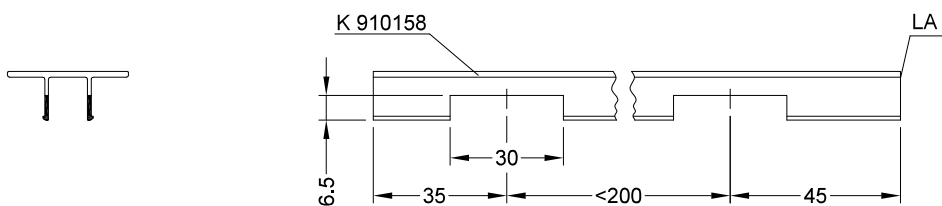
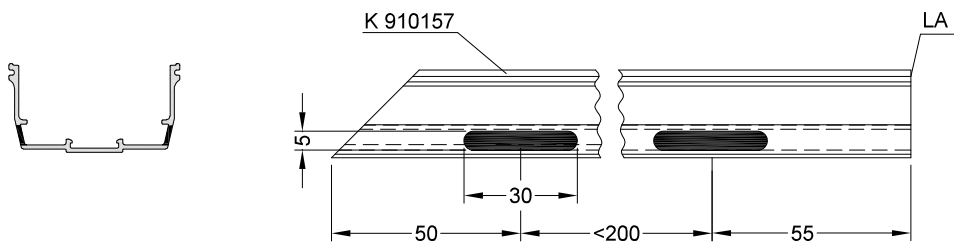
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted



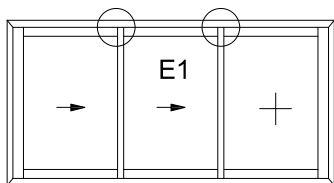
Z 981512



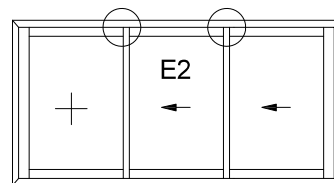
Z 981512



RAHMENMONTAGE
 FRAME ASSEMBLY

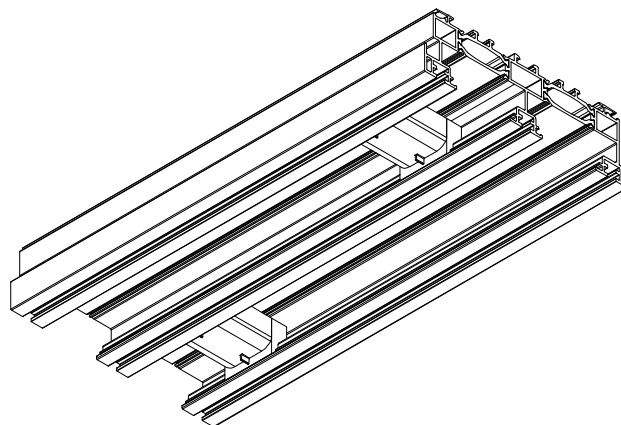
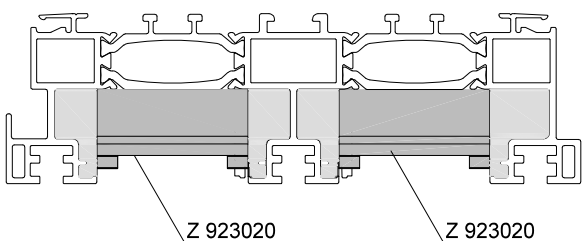
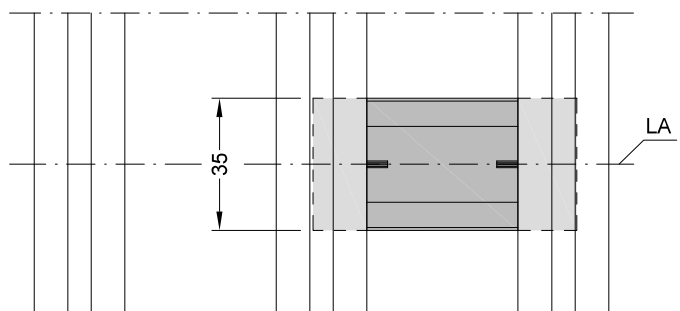
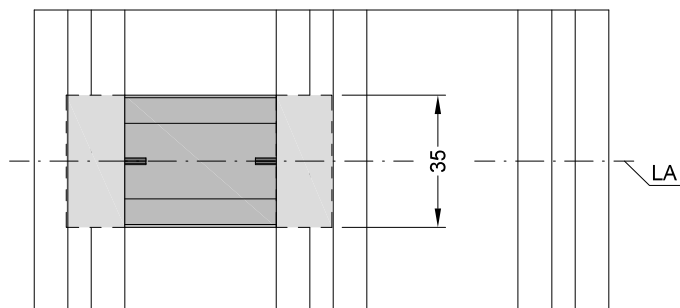
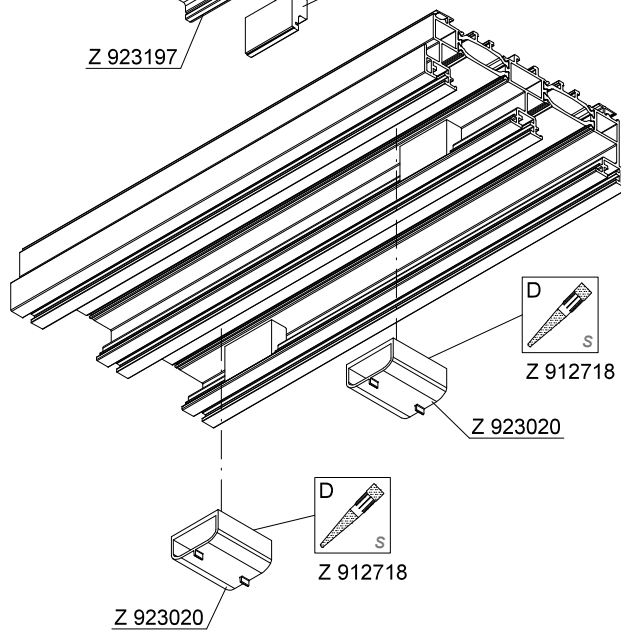
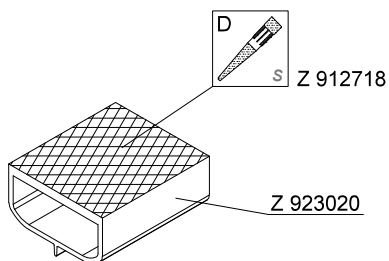
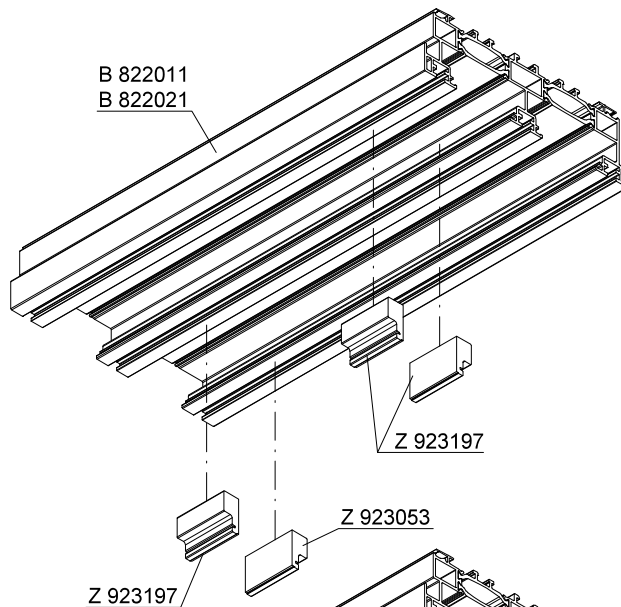
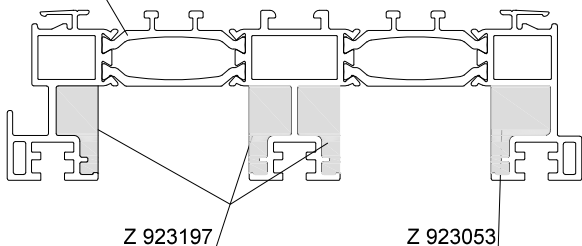


Schema E1 dargestellt
 Scheme E1 shown

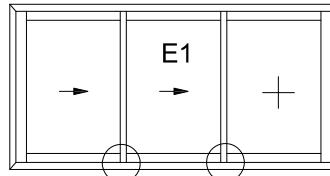


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

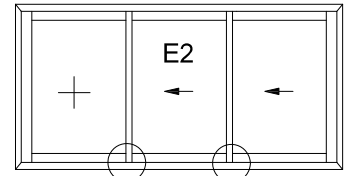
B 822011
 B 822021



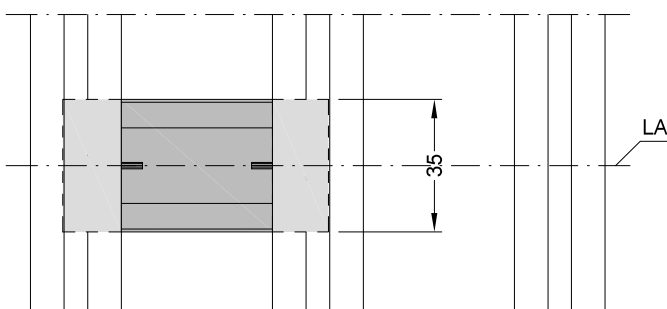
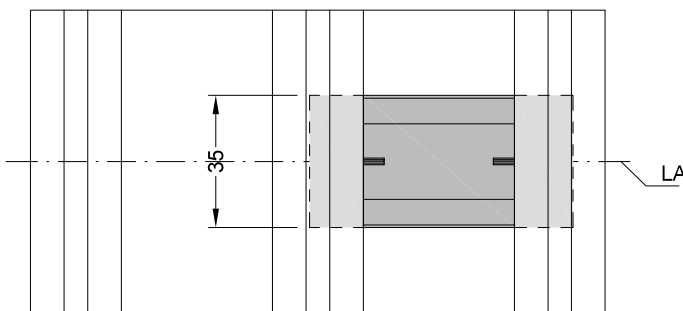
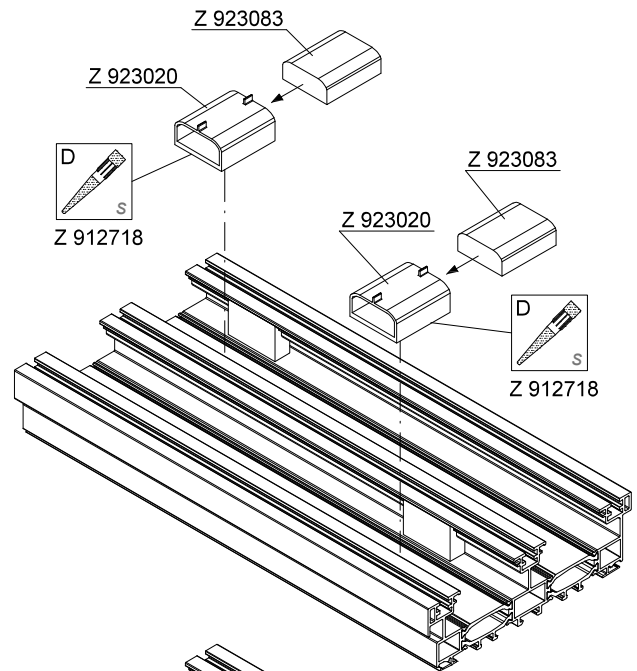
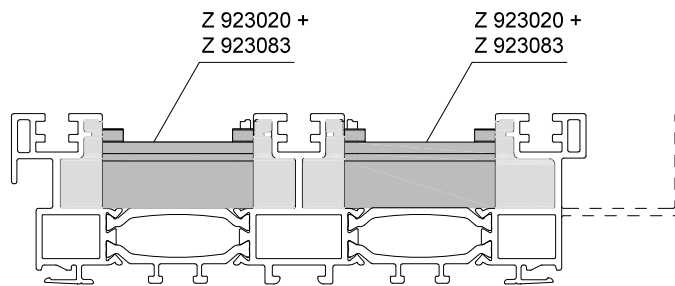
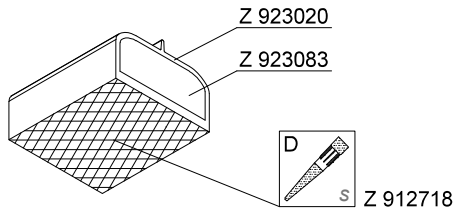
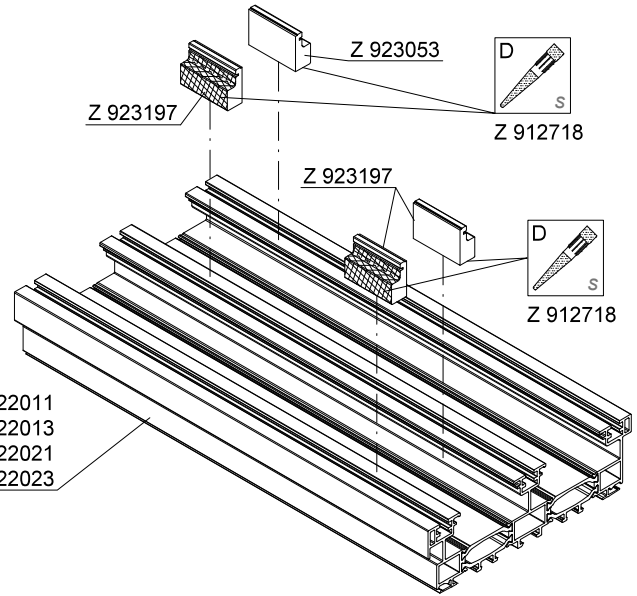
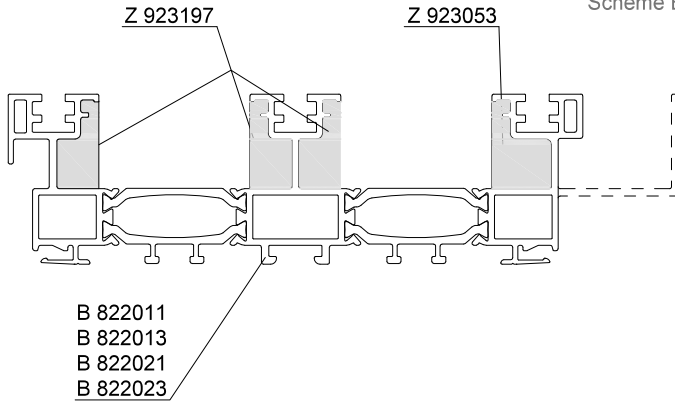
RAHMENMONTAGE
 FRAME ASSEMBLY



Schema E1 dargestellt
 Scheme E1 shown

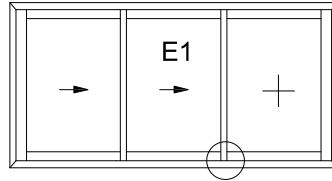


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

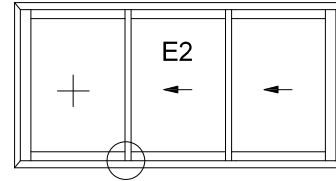


Schema E
 Schema E
 2D

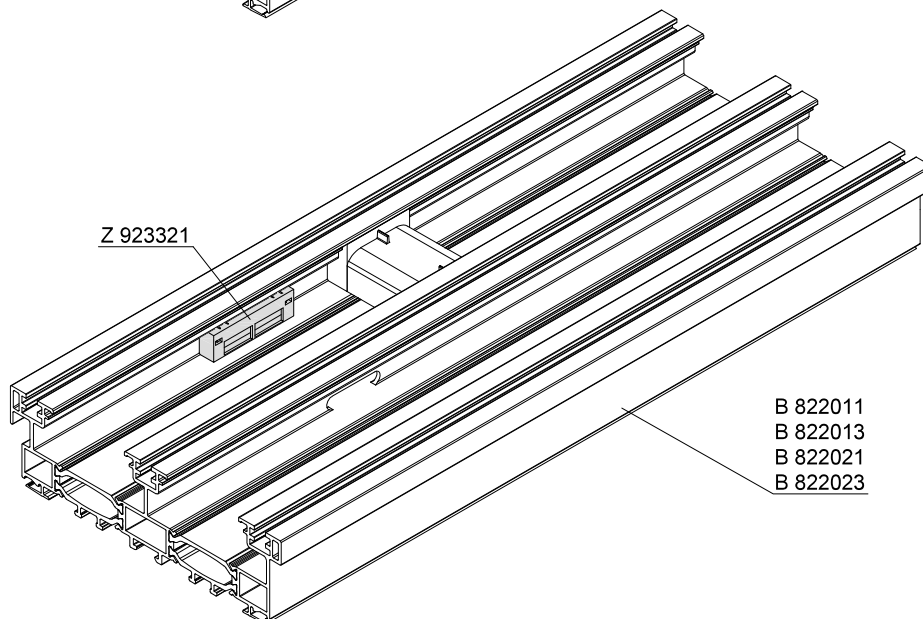
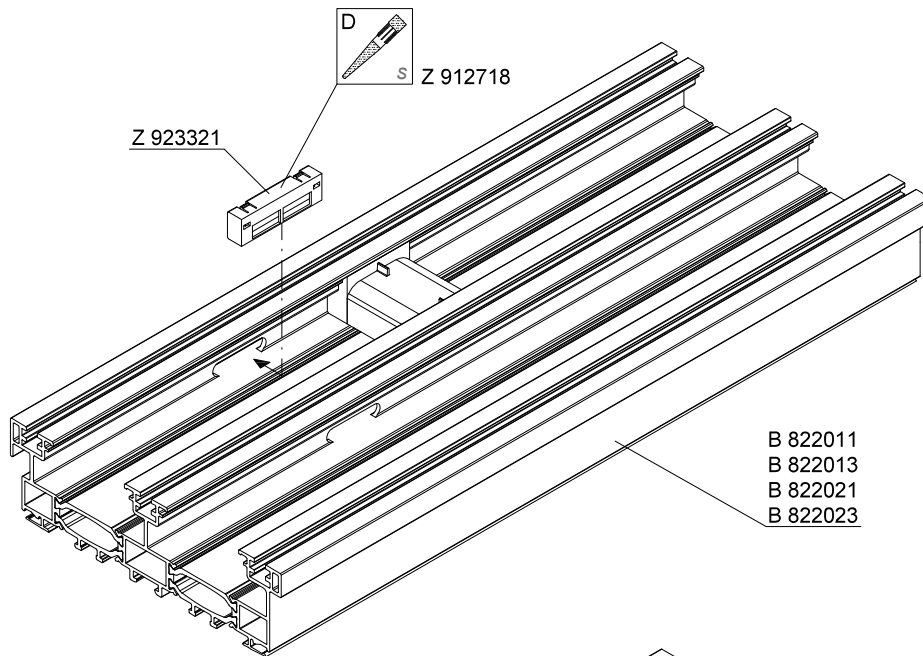
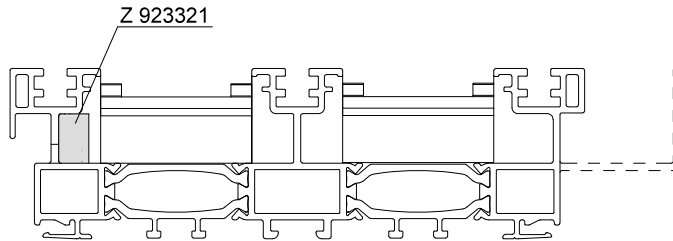
RAHMENMONTAGE
 FRAME ASSEMBLY



Schema E1 dargestellt

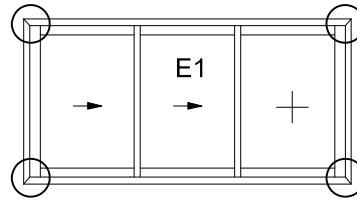
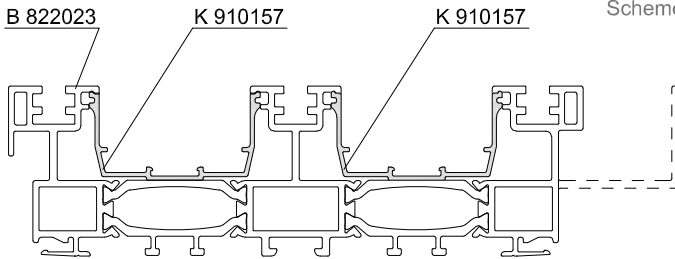


Schema E2 spiegelbildlich

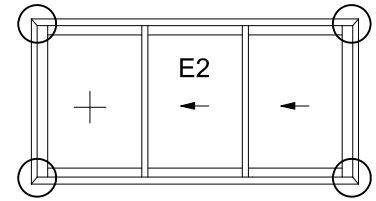


RAHMENMONTAGE
FRAME ASSEMBLY

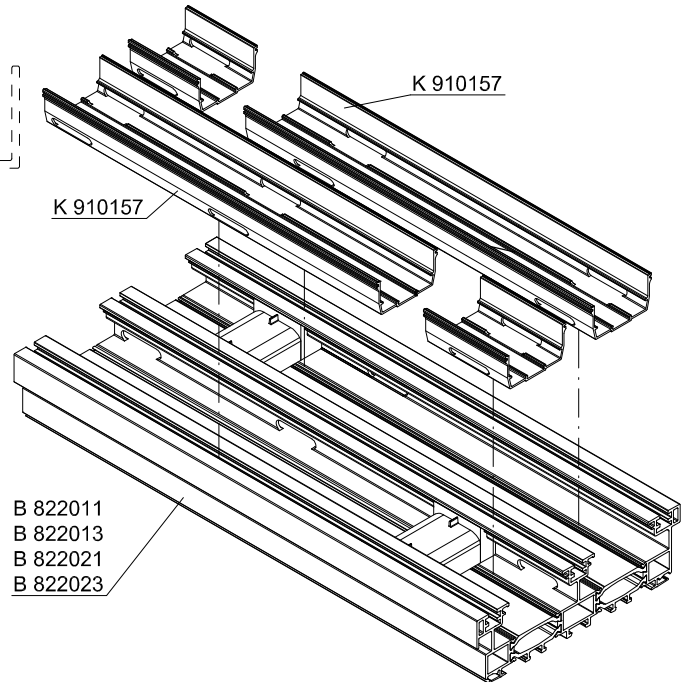
B 822011
B 822013
B 822021
B 822023



Schema E1 dargestellt
Schema E1 shown



Schema E2 spiegelbildlich
Schema E2 mirror-inverted



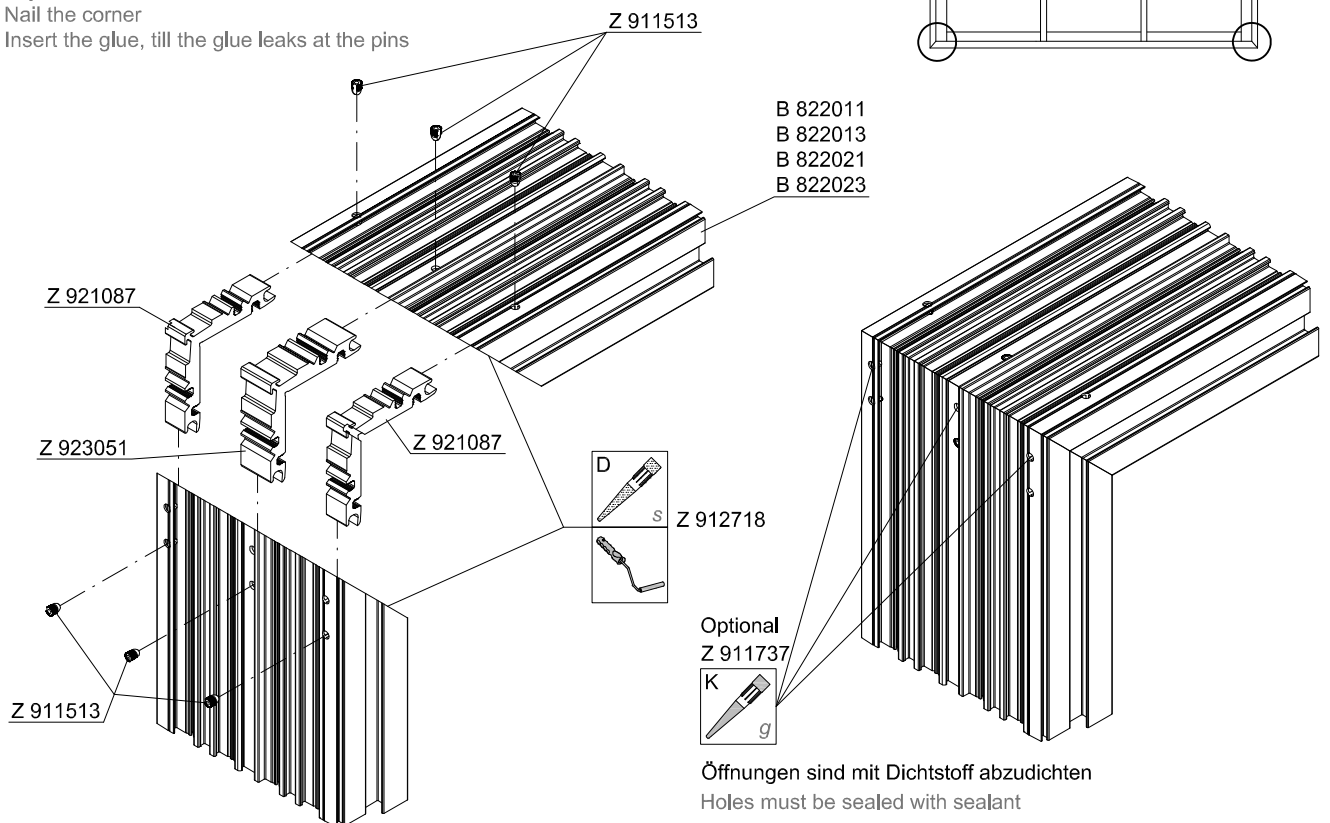
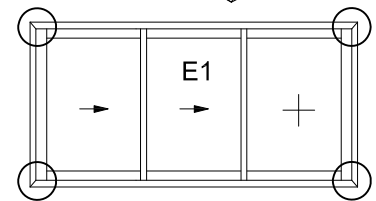
B 822011
B 822013
B 822021
B 822023

Bearbeitungsschritte

1. K 910157 umlaufend eindrücken
2. Schnittflächen versiegeln
3. Falls keine nachträgliche Verklebung vorgesehen ist, müssen vor dem Fügen alle Profilinnenflächen im Eckbereich mit HUECK Metallkleber bestrichen werden
4. Eckverbinder einschieben
5. Rahmen fügen (erst Innen-, dann Außenkammer)
6. Ecke ausrichten
7. Ecke verstiften
8. Kleber einspritzen, bis der Kleber an den Stiften austritt

Processing steps

1. Insert K 910157 circumferential
2. Seal the cut surfaces
3. If there is no subsequent gluing planned, all inner profile surfaces at the corner area must be applied with HUECK metal glue before joining
4. Slide in the corner bracket
5. Join the frame (Internal chamber at first, then external)
6. Adjust the corner
7. Nail the corner
8. Insert the glue, till the glue leaks at the pins



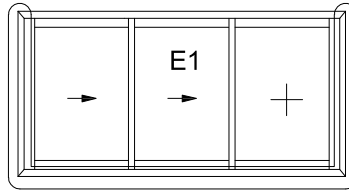
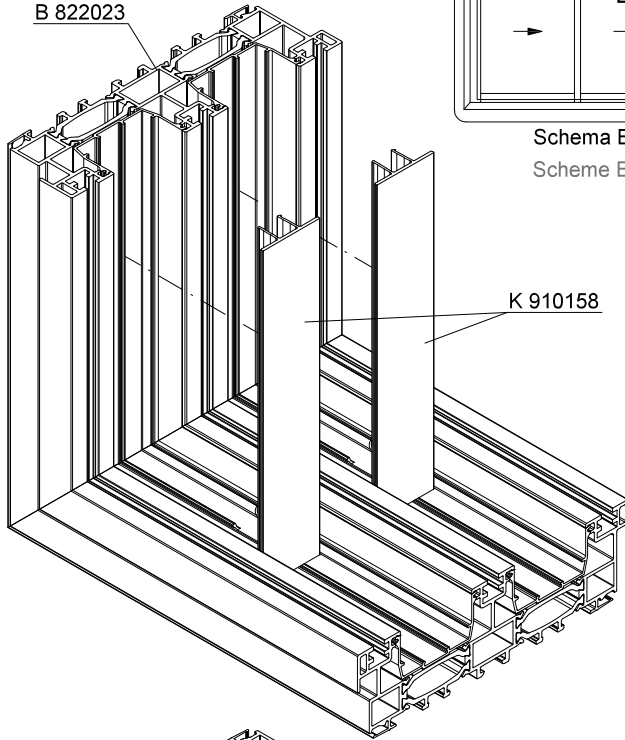
Optional
Z 911737

Öffnungen sind mit Dichtstoff abzudichten
Holes must be sealed with sealant

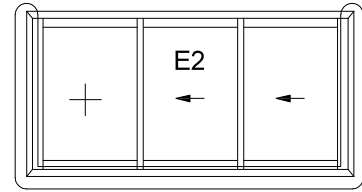
2D
Schema E
Scheme E

RAHMENMONTAGE
FRAME ASSEMBLY

B 822011
B 822013
B 822021
B 822023



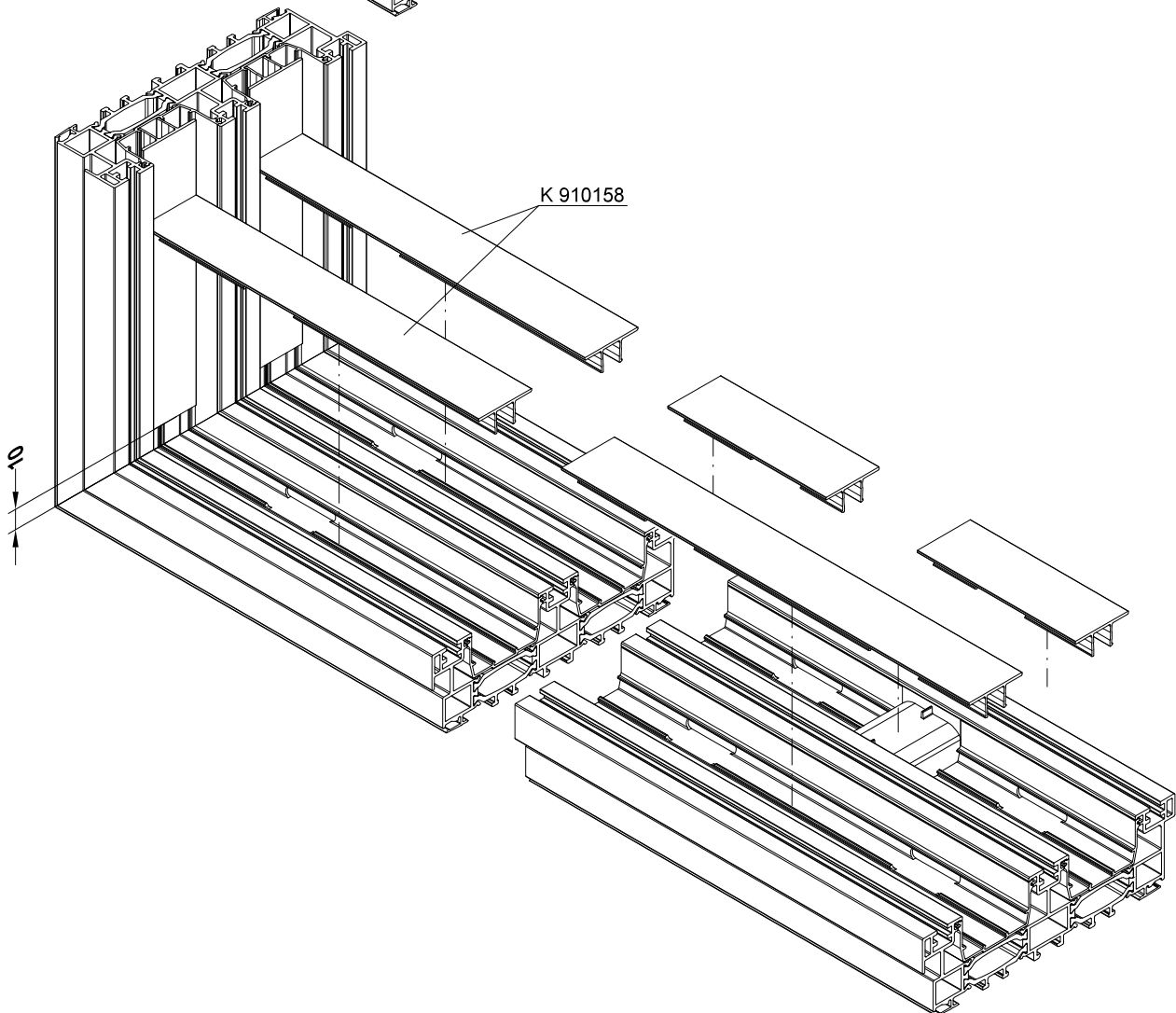
Schema E1 dargestellt
Scheme E1 shown



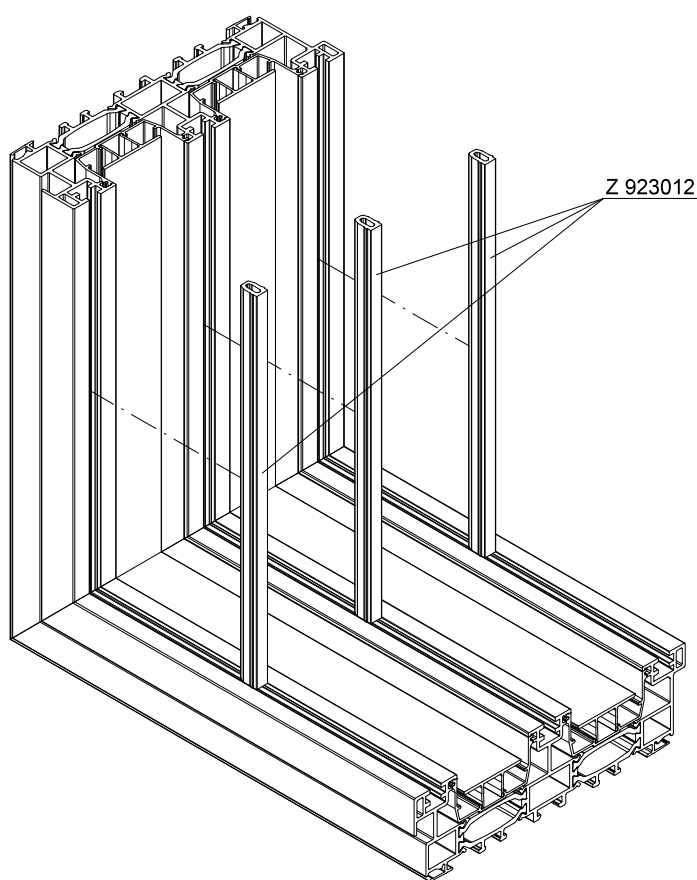
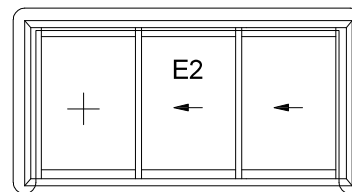
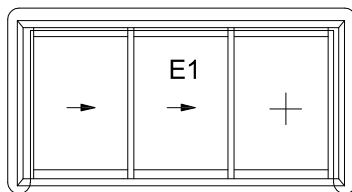
Schema E2 spiegelbildlich
Scheme E2 mirror-inverted

K 910158

Dreiseitig
Three-sided



K 910158



Dreiseitig
 Three-sided



Z 923012

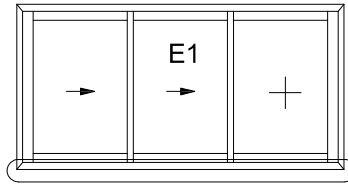
Bearbeitungsschritte

1. Schließteile einbauen und positionieren
 (siehe Kapitel Beschlägeinbau)
2. Dichtungen einziehen

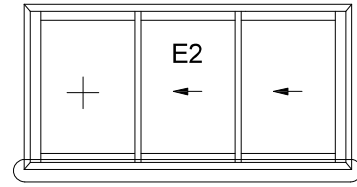
Processing steps

1. Install and position the locking parts
 (see chapter fitting installation)
2. Insert the gaskets

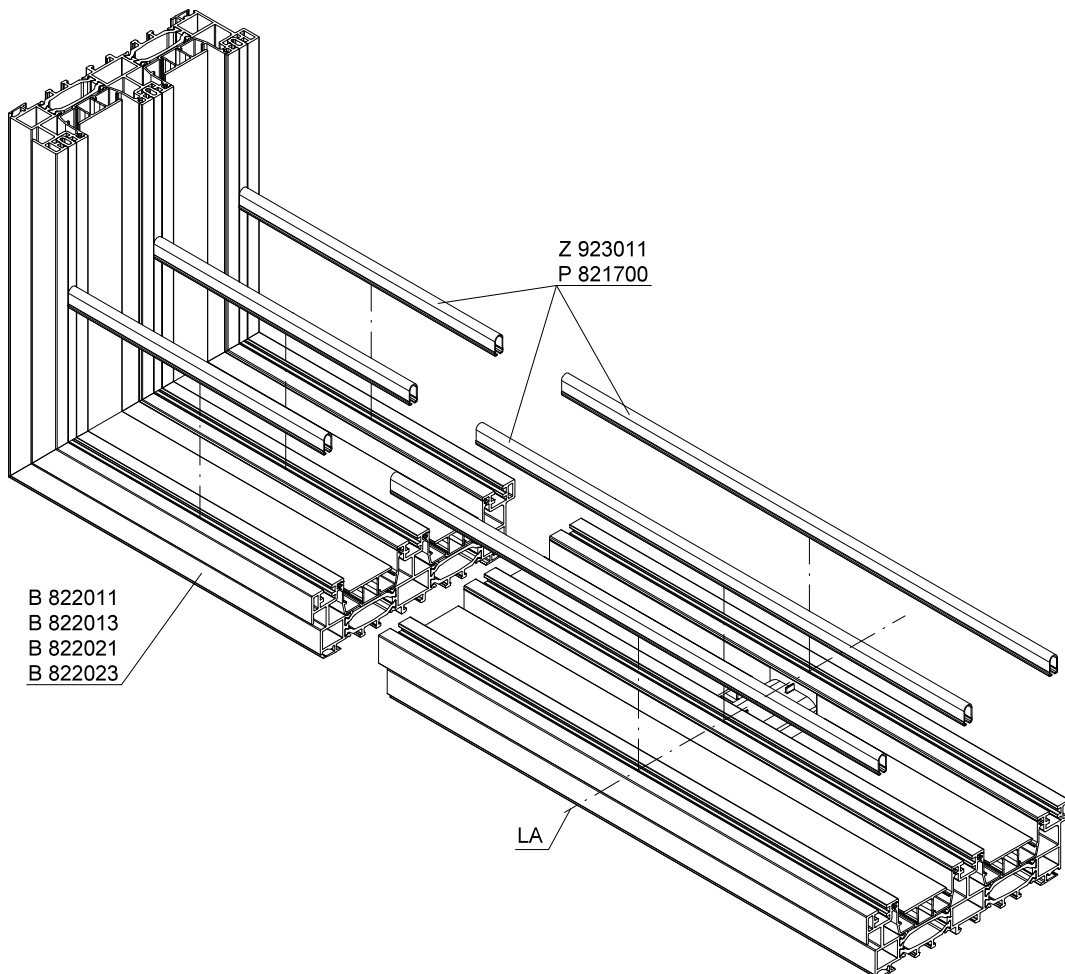
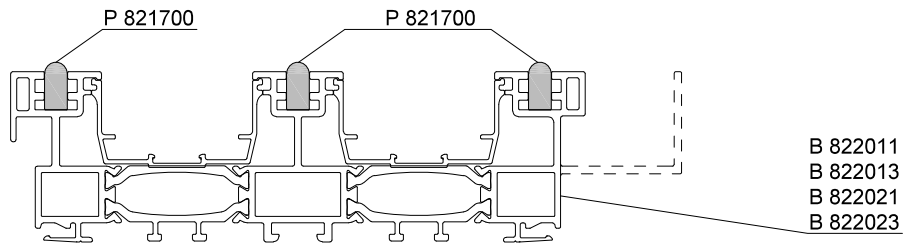
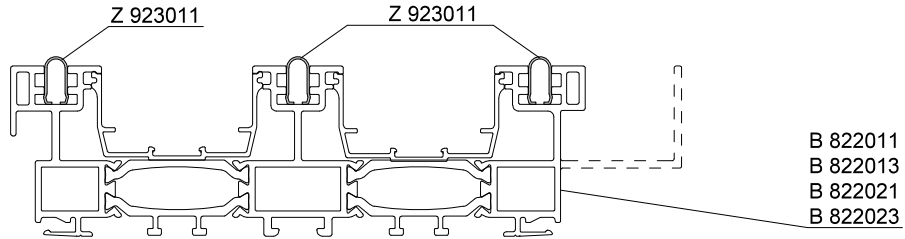
RAHMENMONTAGE
 FRAME ASSEMBLY

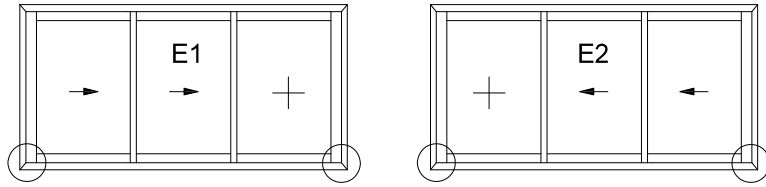


Schema E1 dargestellt
 Scheme E1 shown

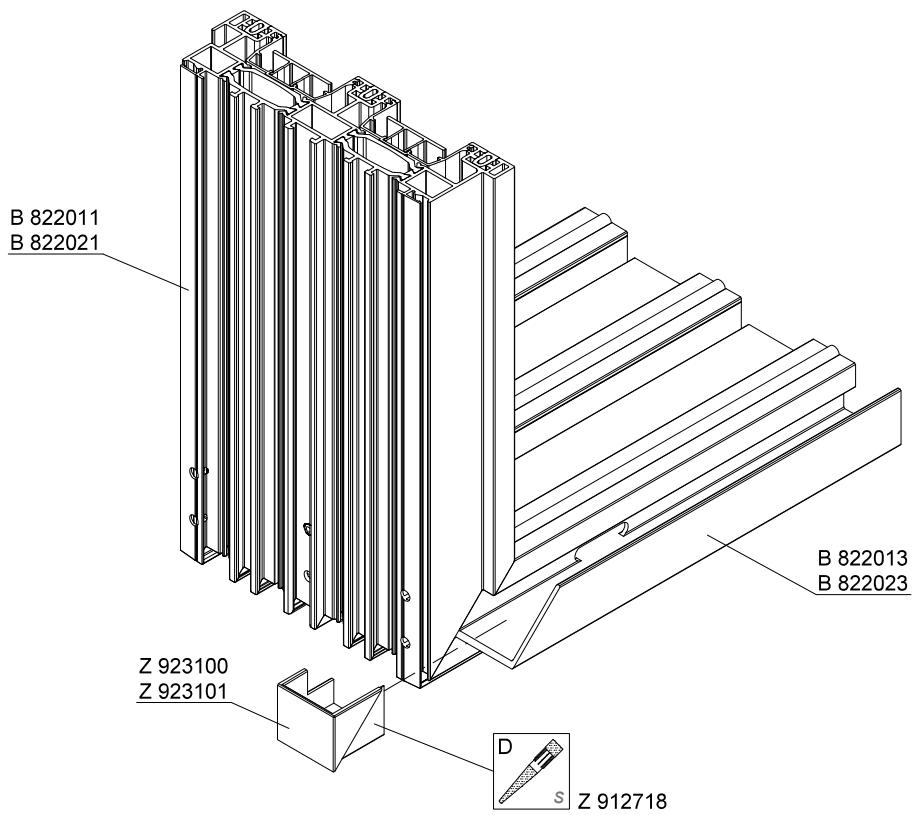


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

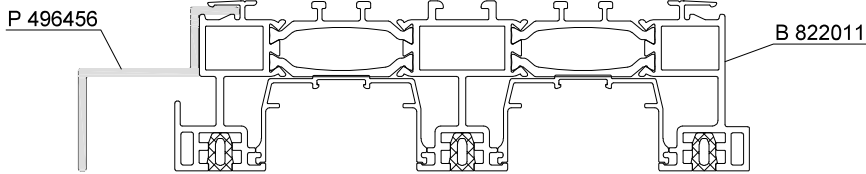
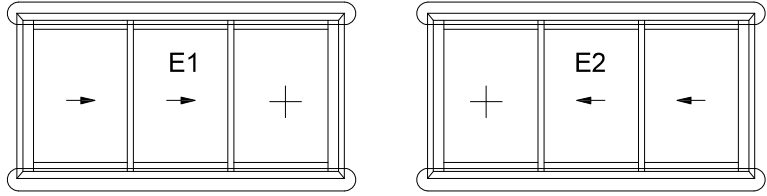




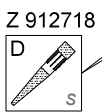
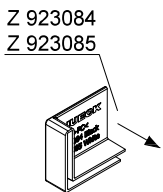
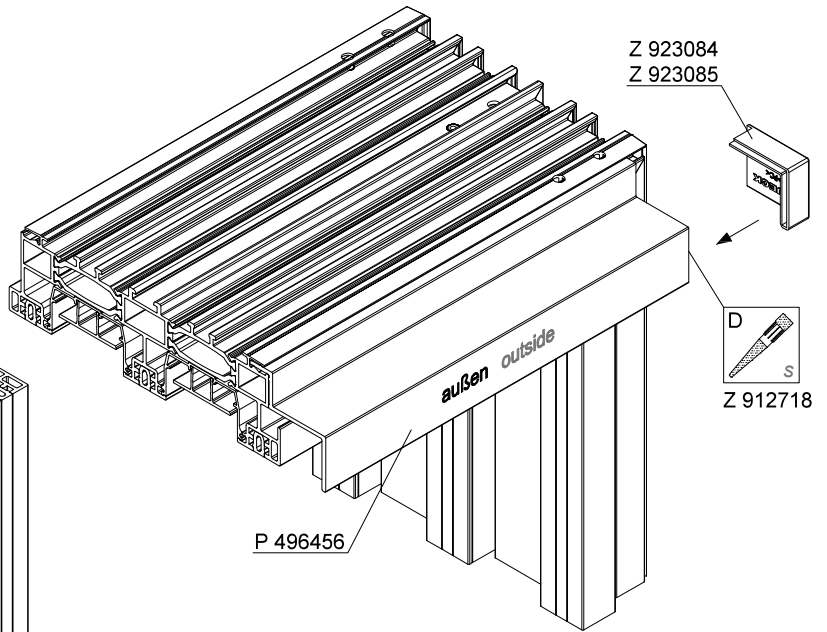
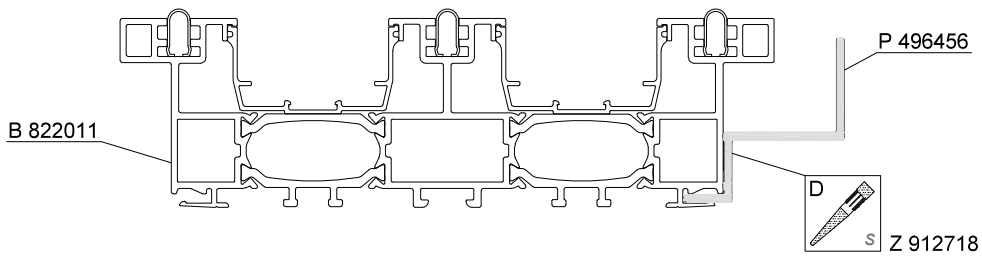
Nur bei B 822013 / B 822023
 Only at B 822013 / B822023



RAHMENMONTAGE
 FRAME ASSEMBLY

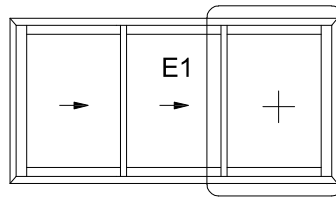


Optional

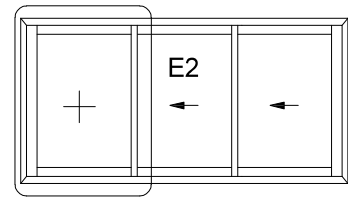


P 496456

innen inside



Schema E1 dargestellt
 Scheme E1 shown



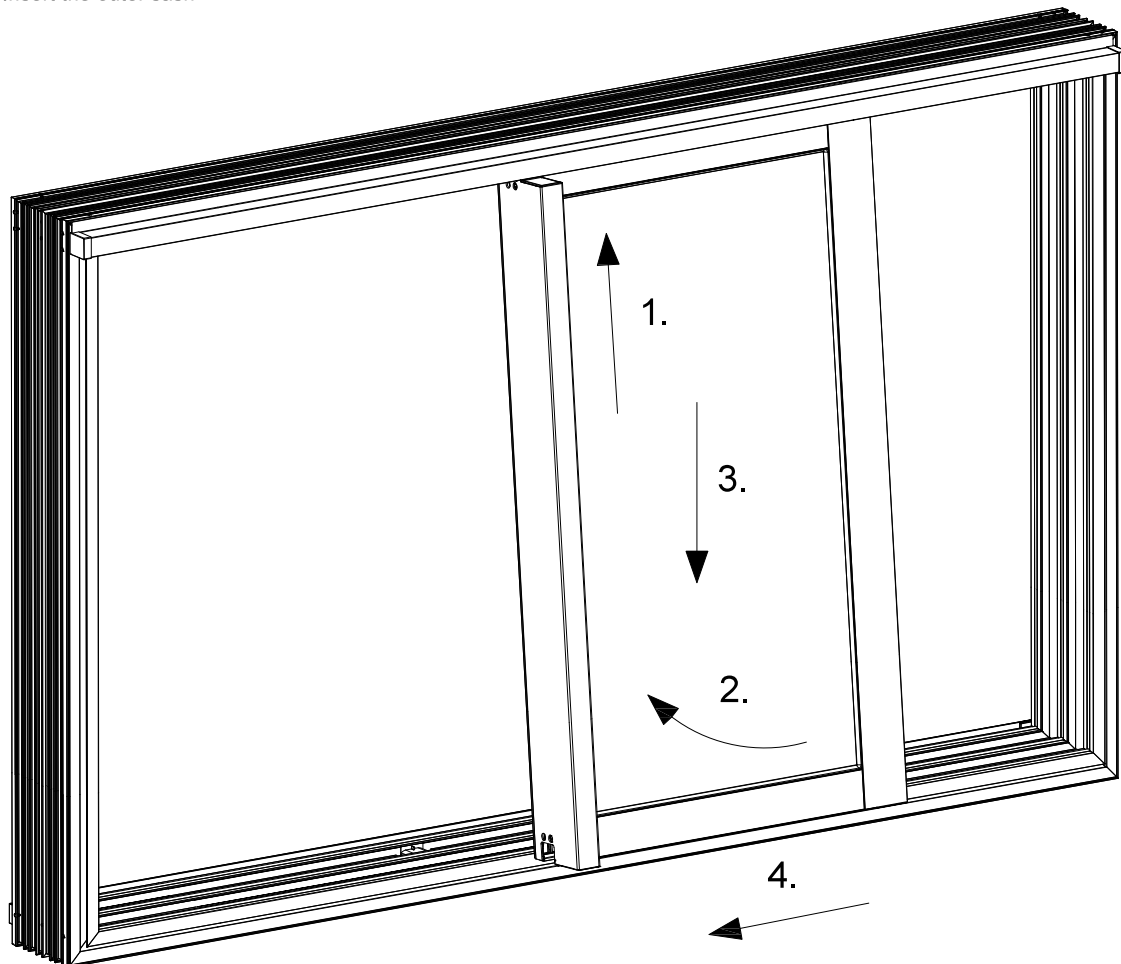
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

Bearbeitungsschritte

1. Äußeren Flügel montieren
 (Siehe Kapitel Verarbeitung / Montage Flügel)
2. Äußeren Flügel einhängen

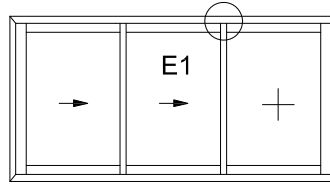
Processing steps

1. Assemble the outer sash
 (see chapter processing / assembly sash)
2. Insert the outer sash

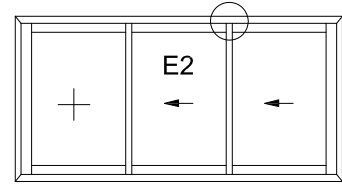


Ansicht von Außen
 Outside view

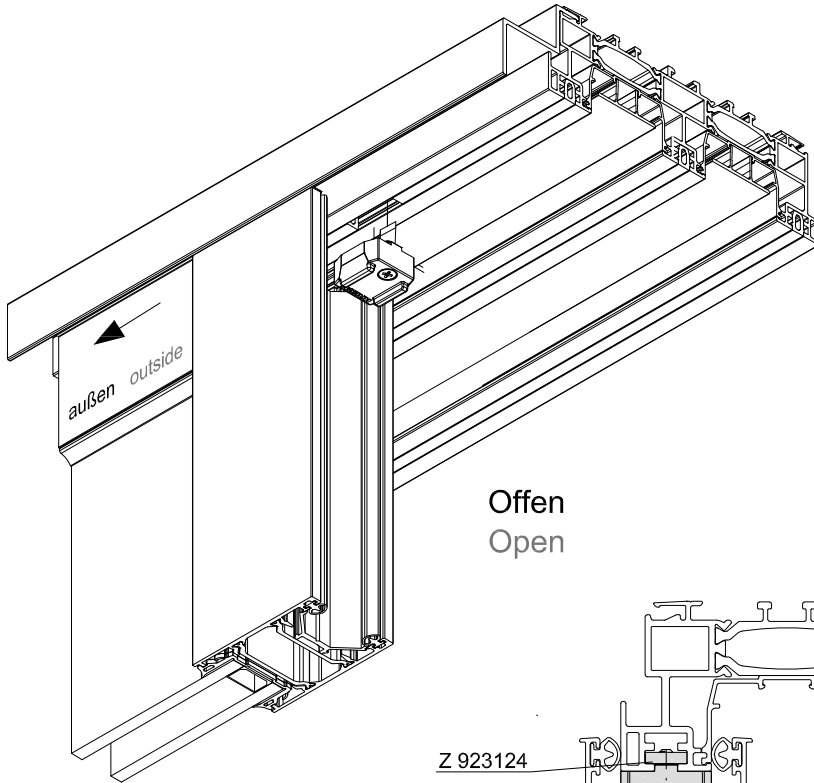
FLÜGELMONTAGE
 SASH ASSEMBLY



Schema E1 dargestellt
 Scheme E1 shown

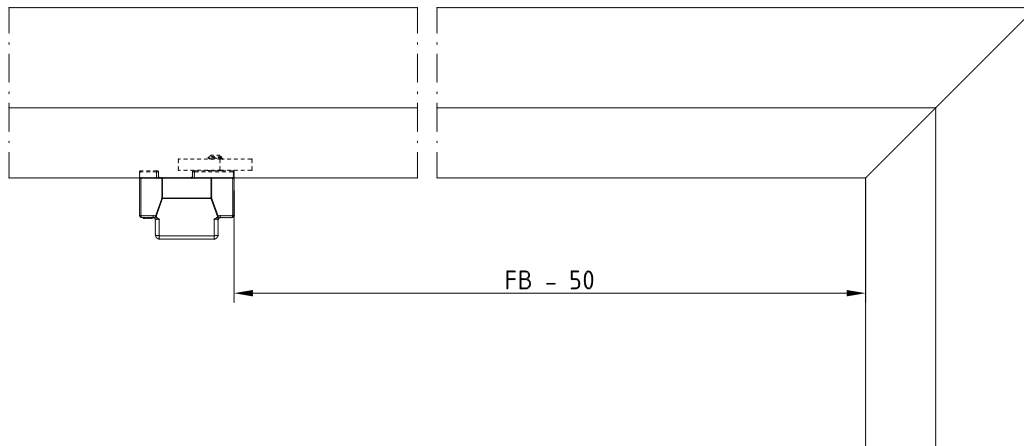
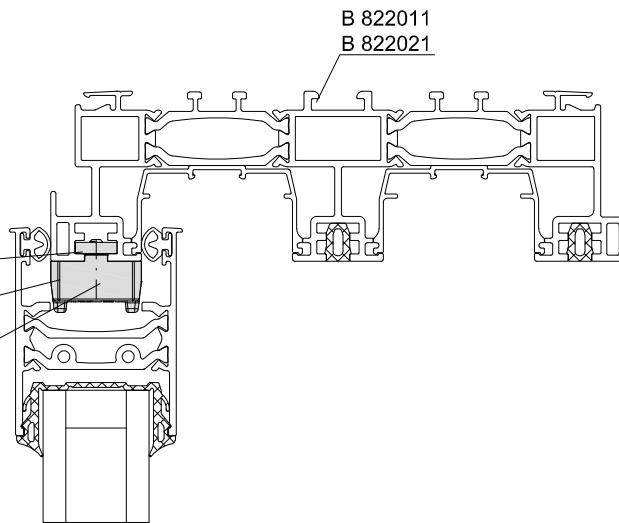


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

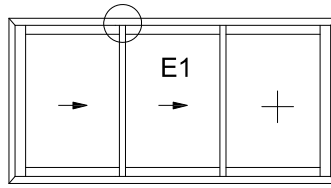


Offen
 Open

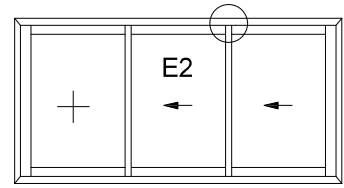
- Z 923124
- Z 923202
- Z 923358



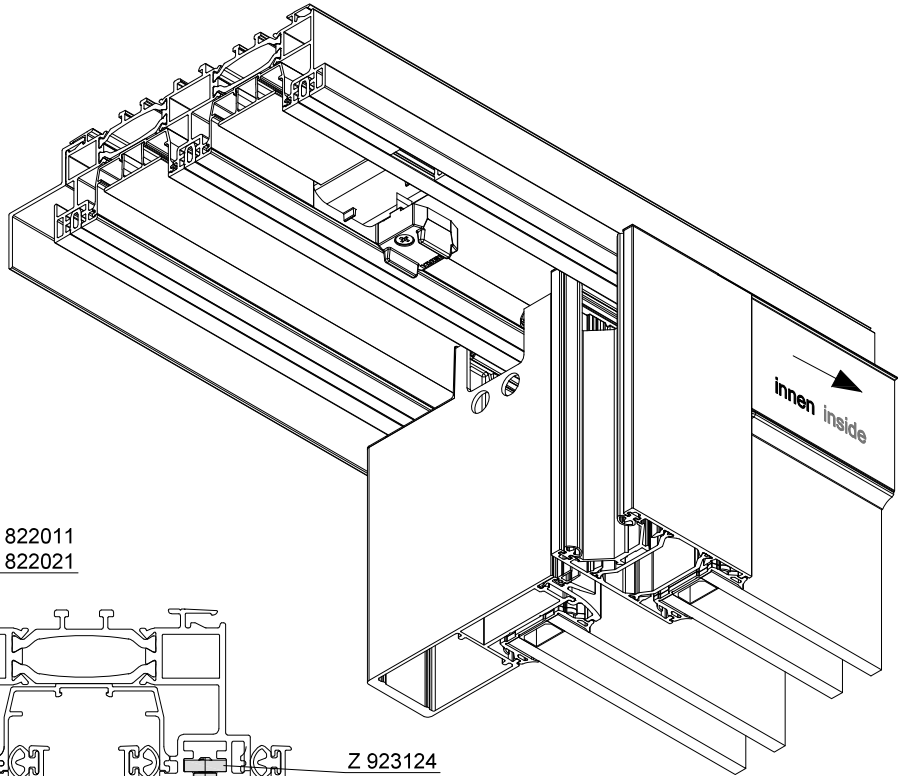
FLÜGELMONTAGE
 SASH ASSEMBLY



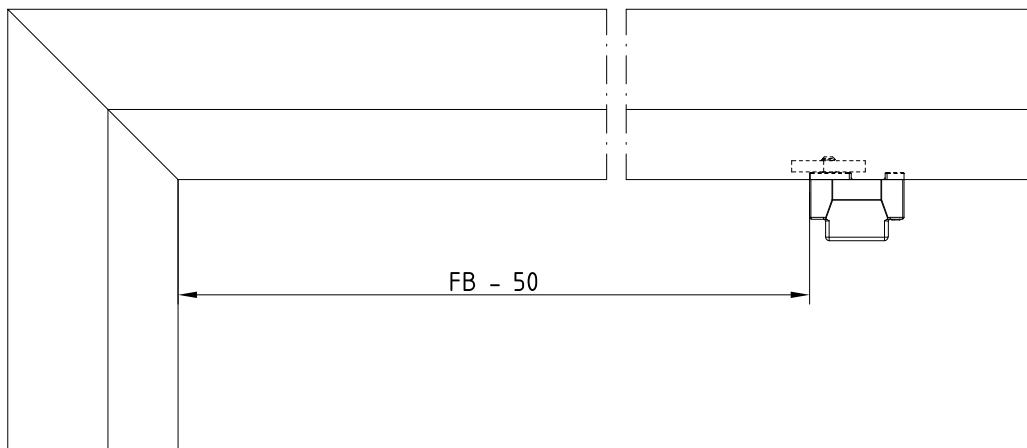
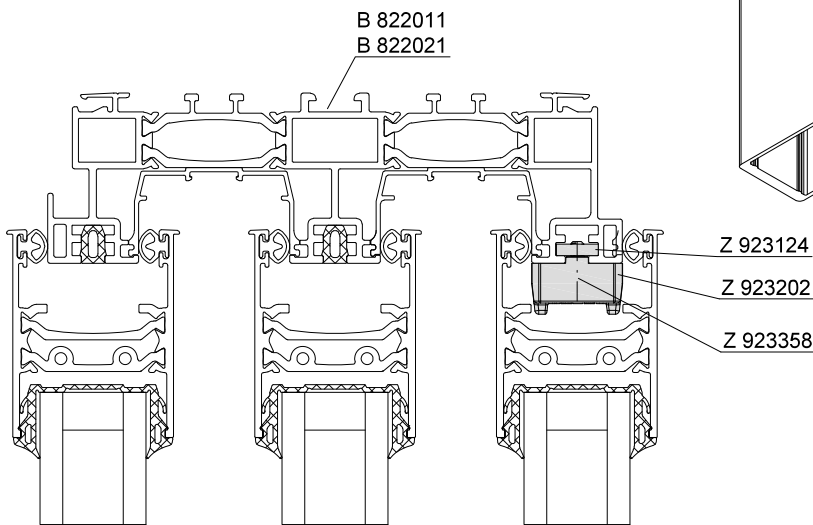
Schema E1 dargestellt
 Scheme E1 shown



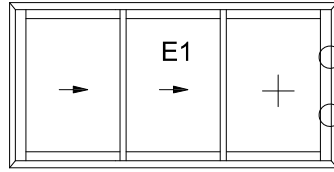
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted



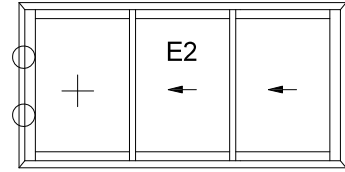
Offen
 Open



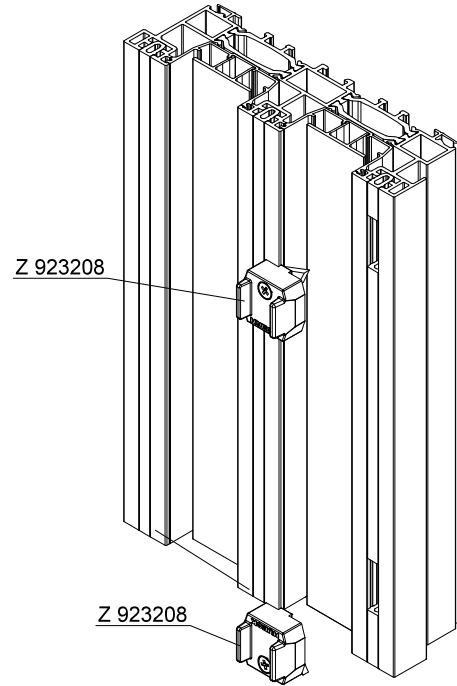
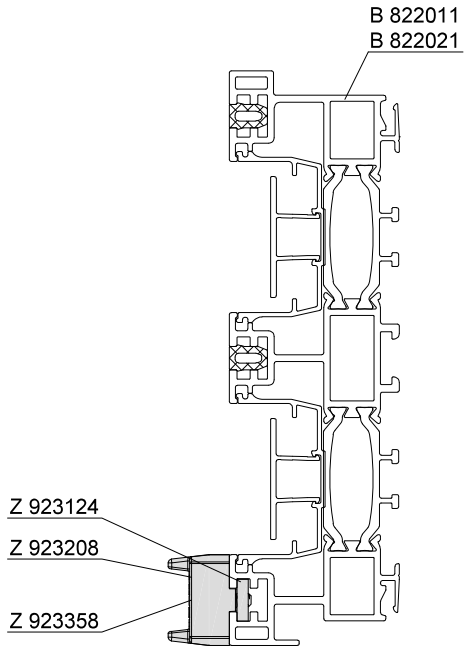
FLÜGELMONTAGE
SASH ASSEMBLY



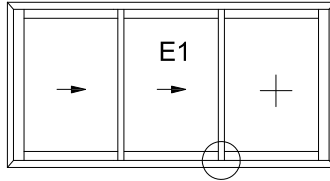
Schema E1 dargestellt
Scheme E1 shown



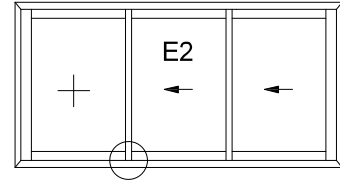
Schema E2 spiegelbildlich
Scheme E2 mirror-inverted



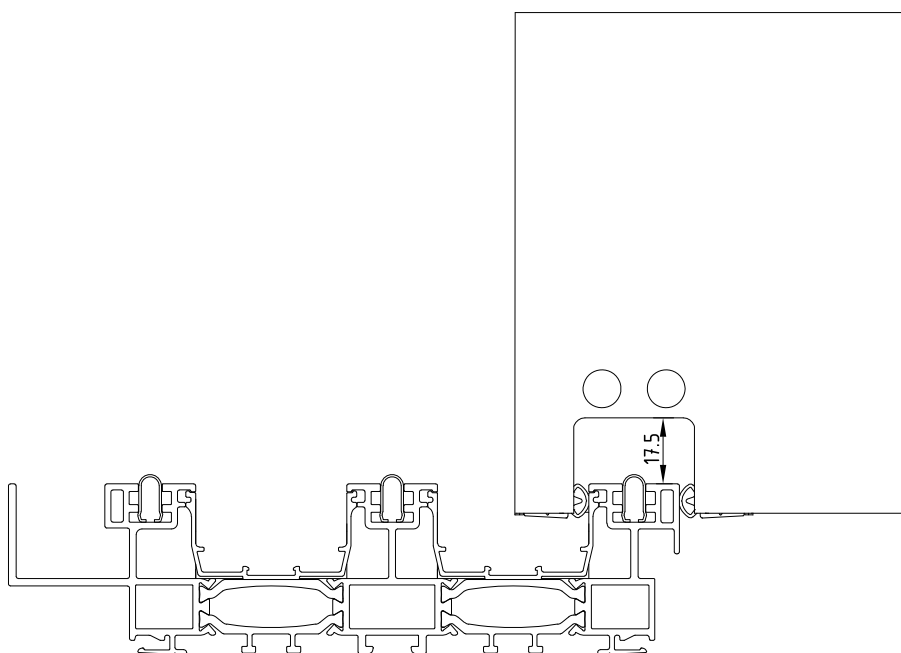
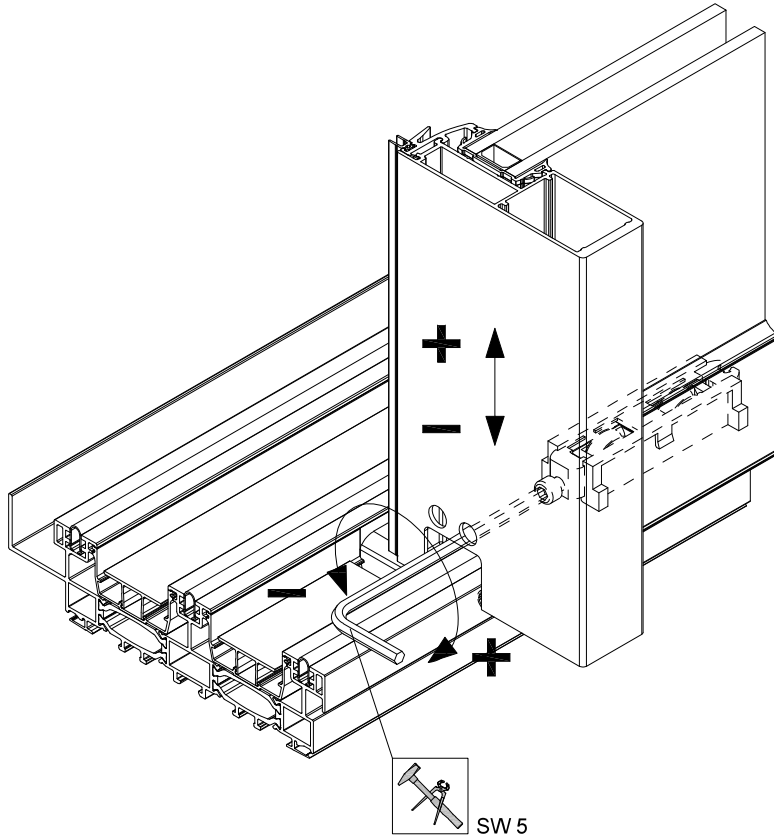
FLÜGELMONTAGE
 SASH ASSEMBLY



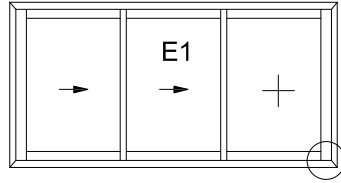
Schema E1 dargestellt
 Scheme E1 shown



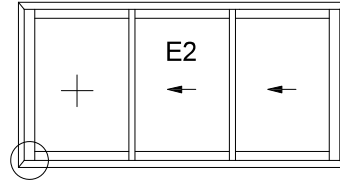
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted



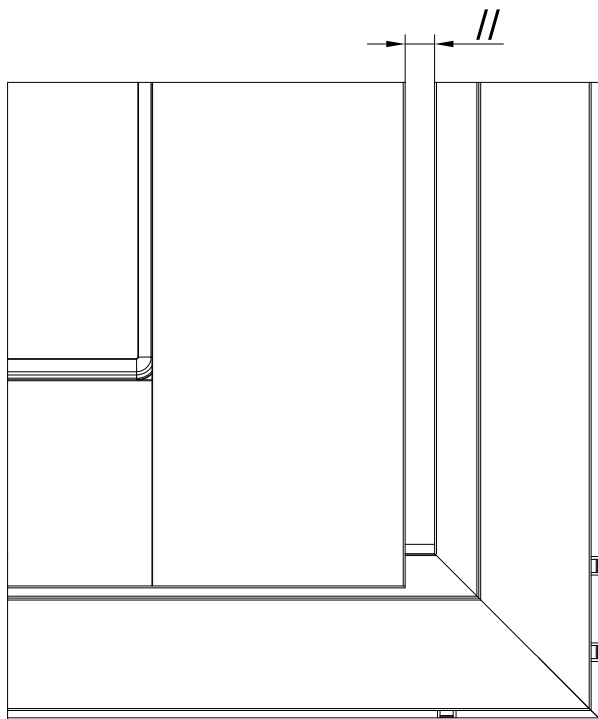
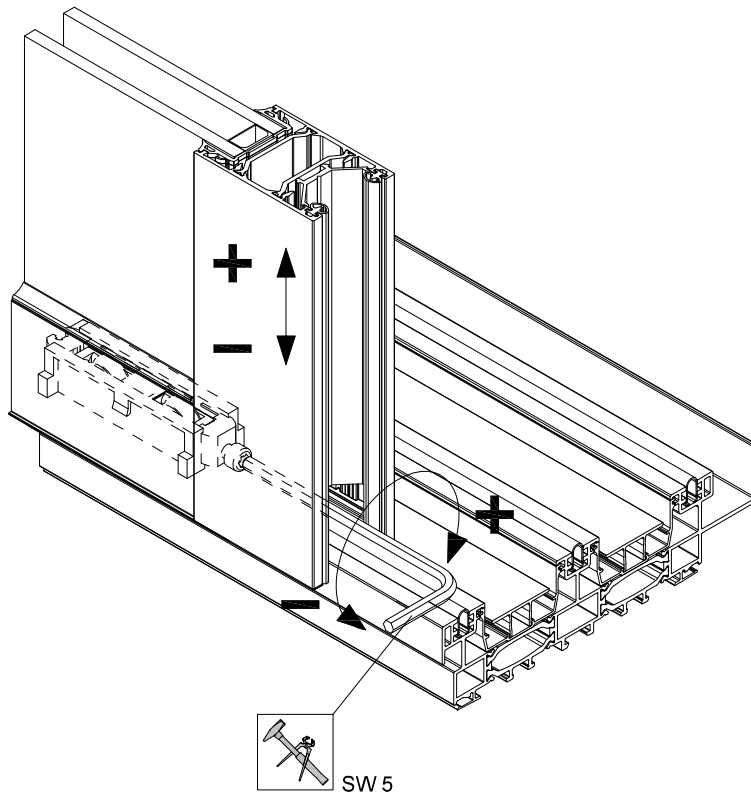
FLÜGELMONTAGE
SASH ASSEMBLY



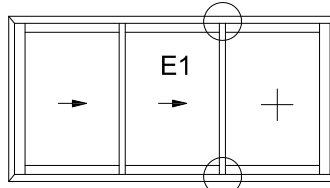
Schema E1 dargestellt
Scheme E1 shown



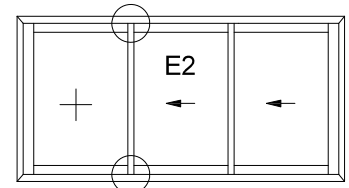
Schema E2 spiegelbildlich
Scheme E2 mirror-inverted



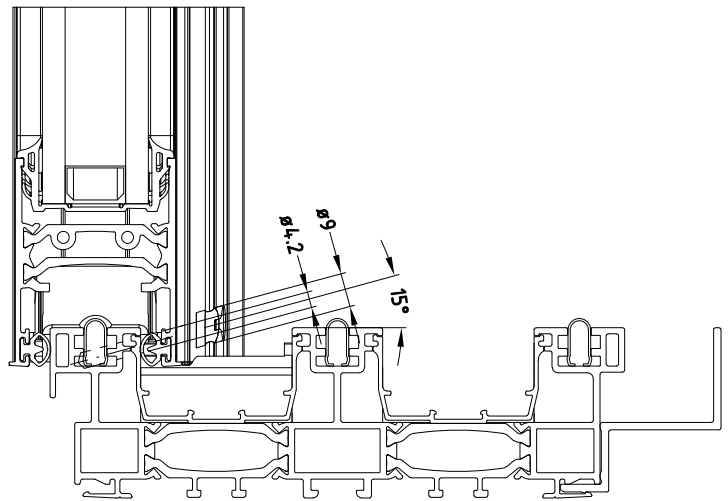
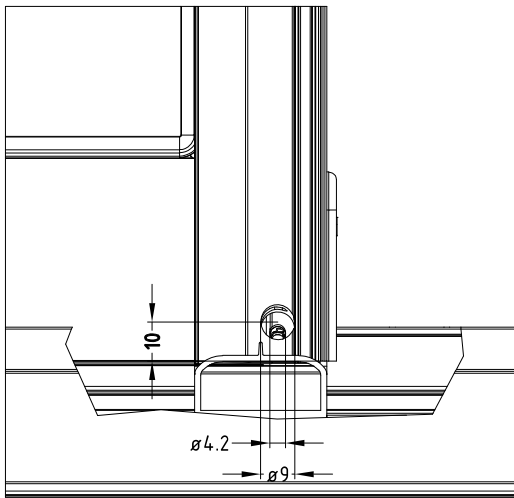
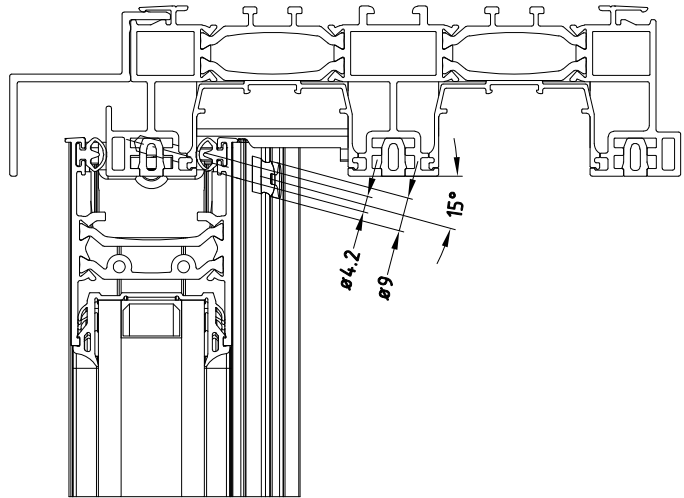
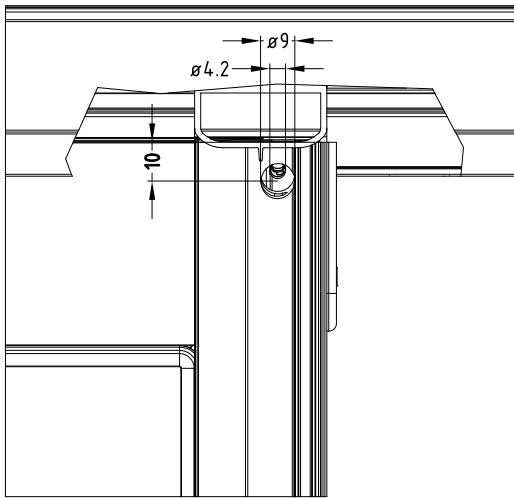
FLÜGELMONTAGE
 SASH ASSEMBLY



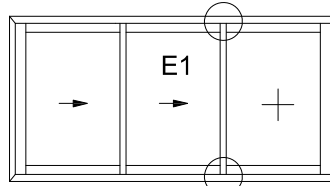
Schema E1 dargestellt
 Scheme E1 shown



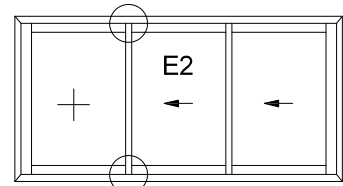
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted



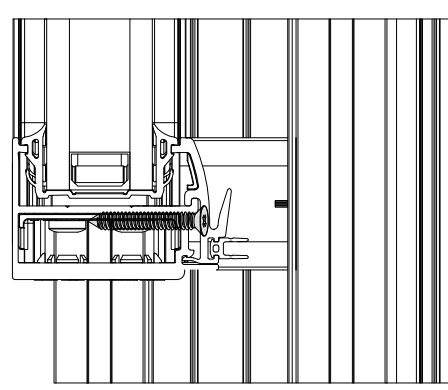
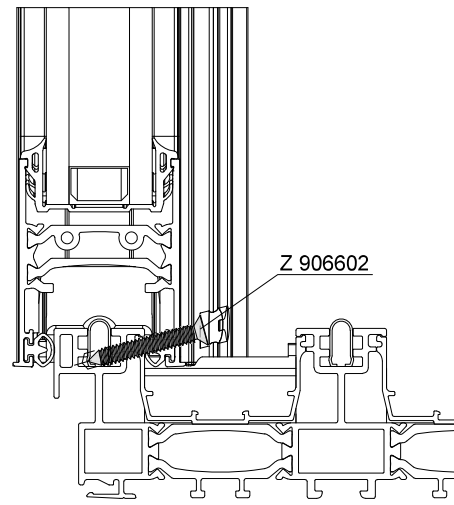
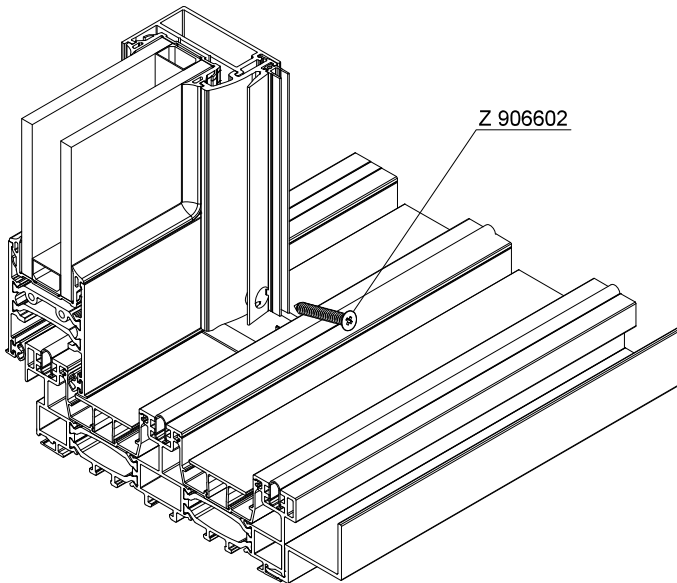
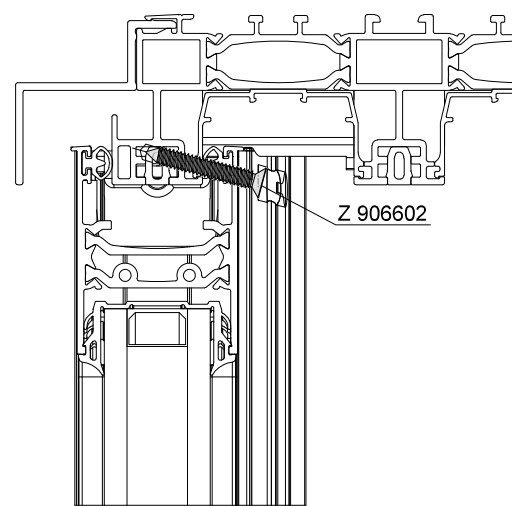
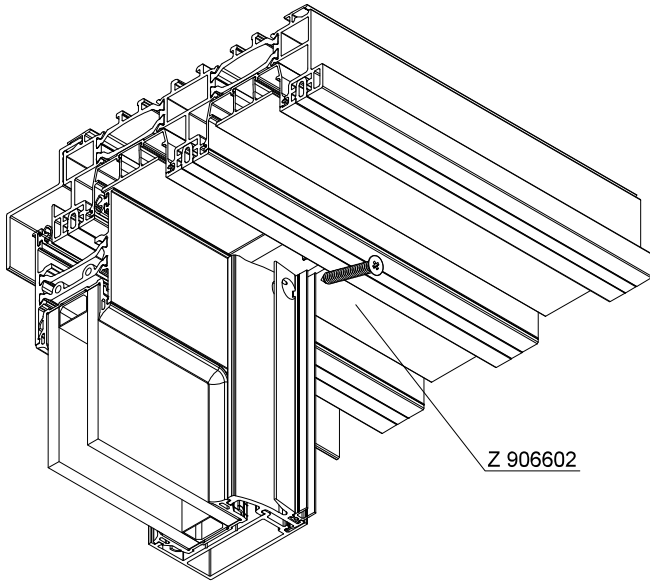
FLÜGELMONTAGE
SASH ASSEMBLY

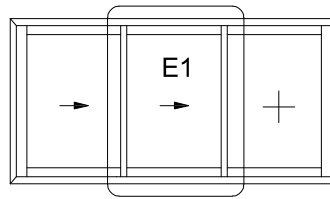


Schema E1 dargestellt
Scheme E1 shown

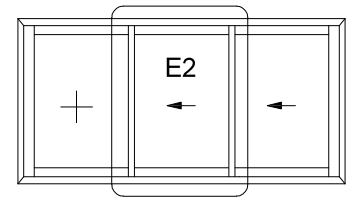


Schema E2 spiegelbildlich
Scheme E2 mirror-inverted





Schema E1 dargestellt
 Scheme E1 shown



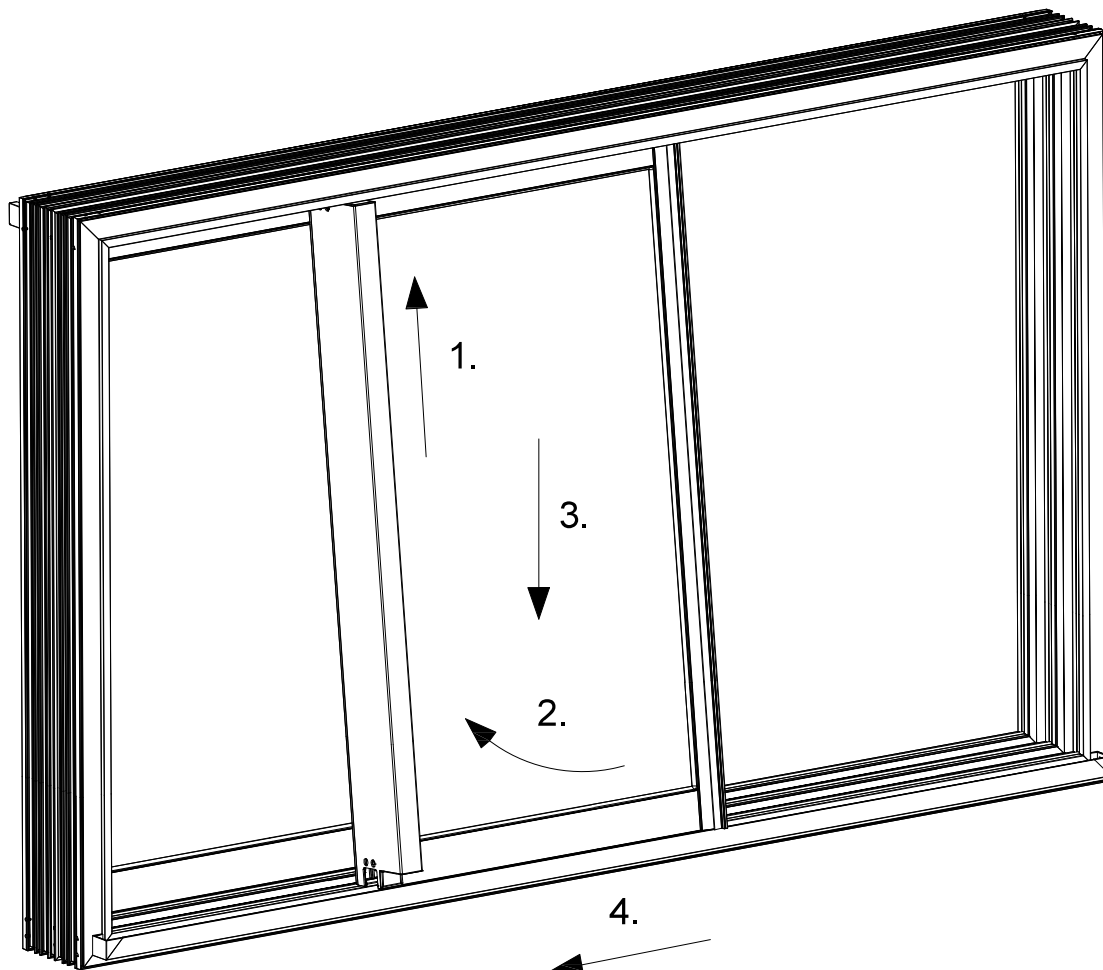
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

Bearbeitungsschritte

1. Mittleren Flügel montieren
 (Siehe Kapitel Verarbeitung / Montage Flügel)
2. Mittleren Flügel einhängen

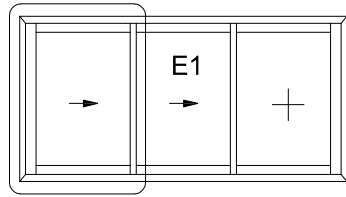
Processing steps

1. Assemble the middle sash
 (see chapter processing / assembly sash)
2. Insert the middle sash

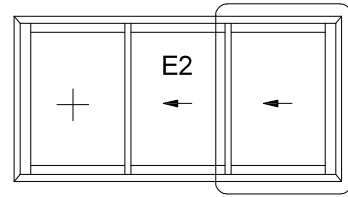


Ansicht von Innen
 Inside view

FLÜGELMONTAGE
SASH ASSEMBLY



Schema E1 dargestellt
Scheme E1 shown



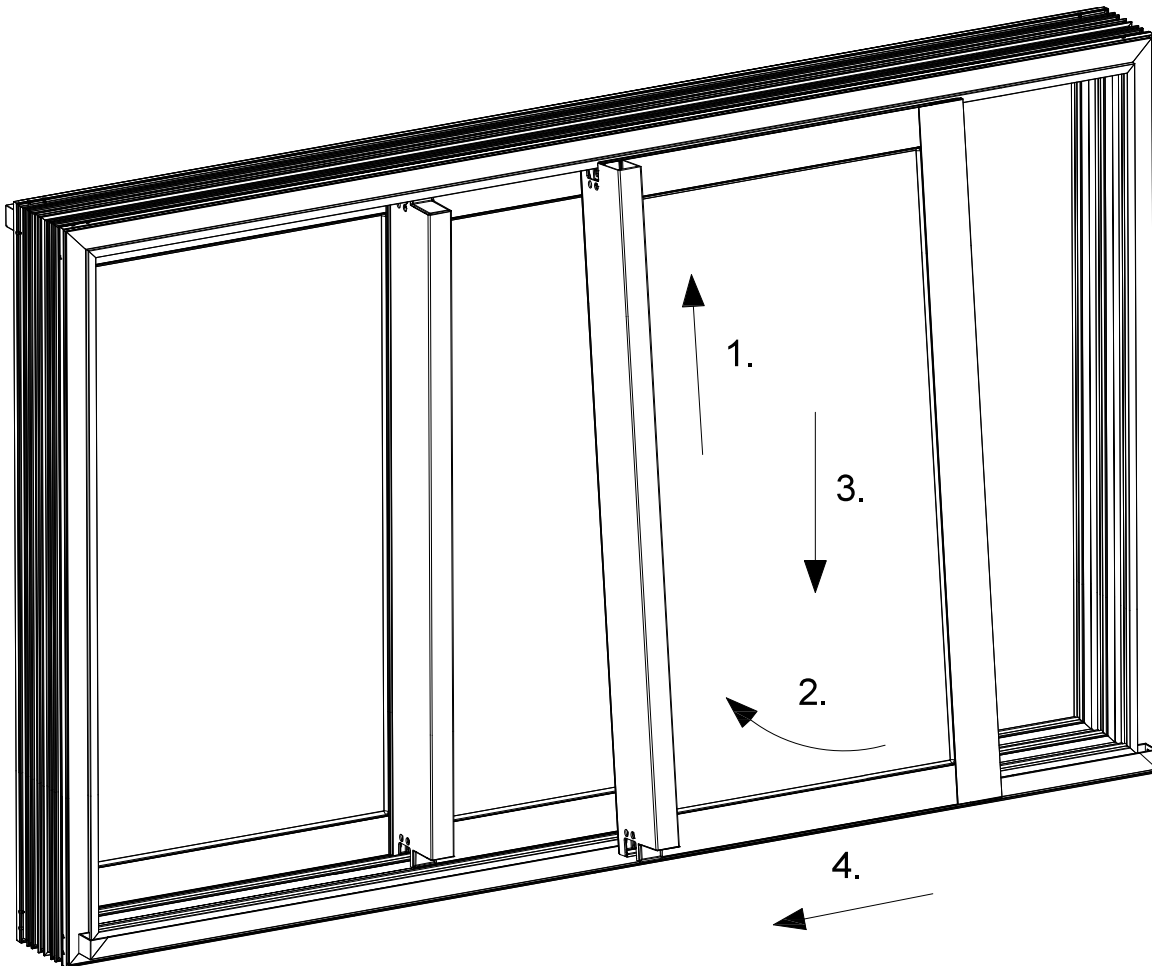
Schema E2 spiegelbildlich
Scheme E2 mirror-inverted

Bearbeitungsschritte

1. Inneren Flügel montieren (Siehe Kapitel Verarbeitung und Montage Flügel)
2. Inneren Flügel einhängen

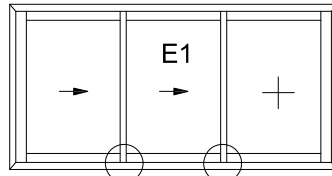
Processing steps

1. Assemble the inner sash (see chapter processing / assembly sash)
2. Insert the inner sash

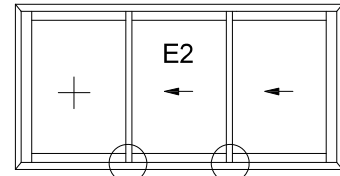


Ansicht von Innen
Inside view

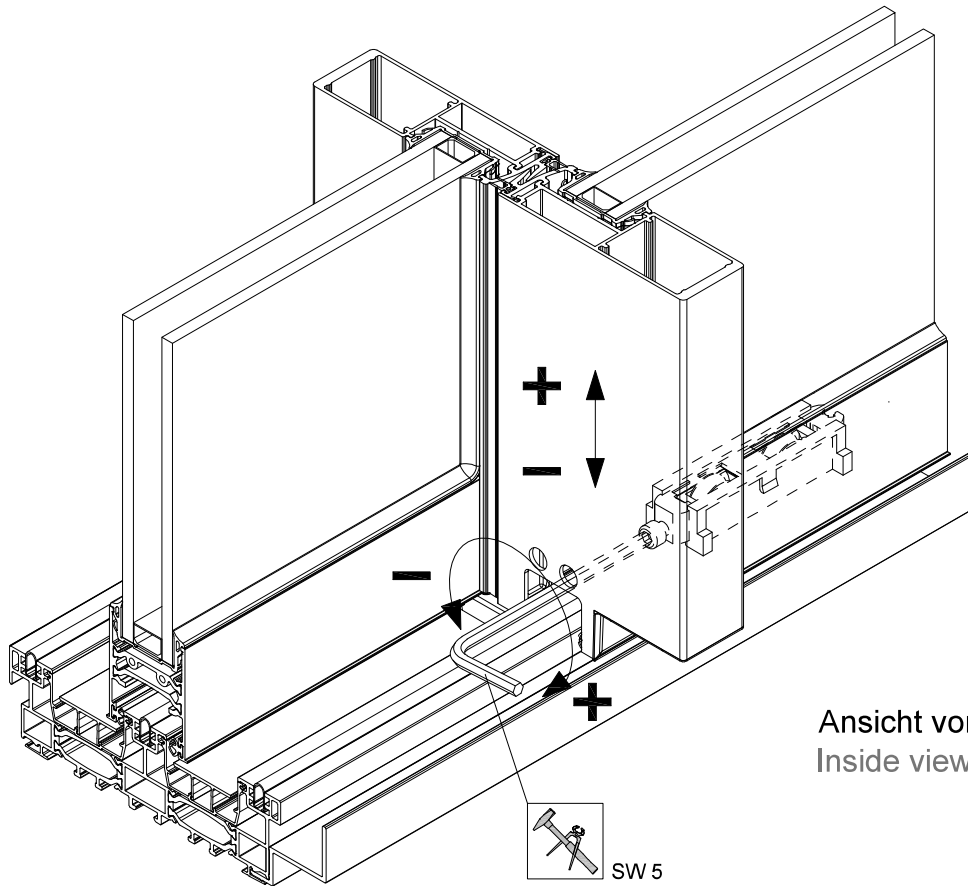
FLÜGELMONTAGE
 SASH ASSEMBLY



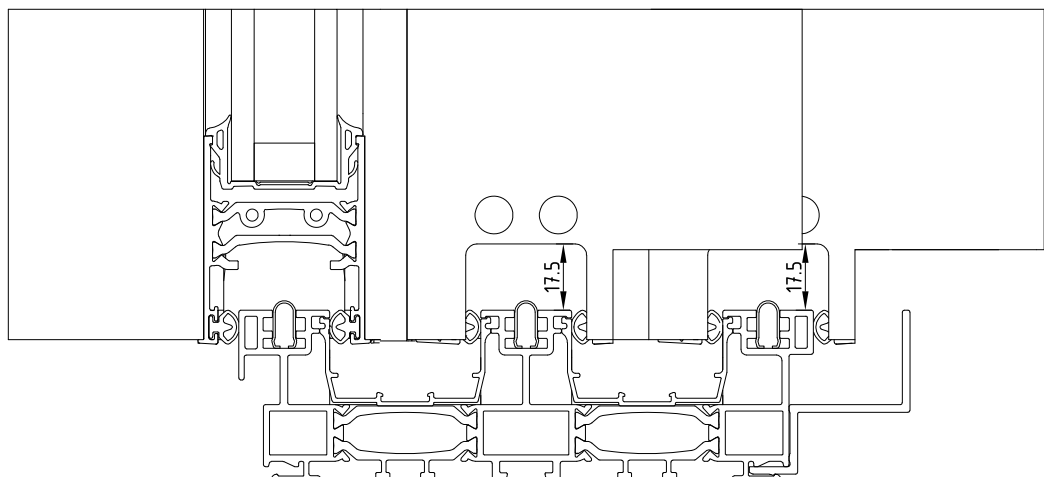
Schema E1 dargestellt
 Schema E1 shown



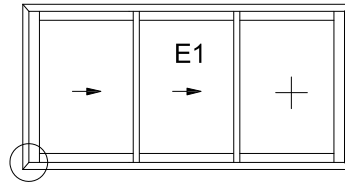
Schema E2 spiegelbildlich
 Schema E2 mirror-inverted



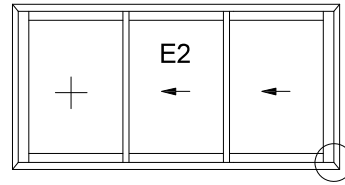
Ansicht von Innen
 Inside view



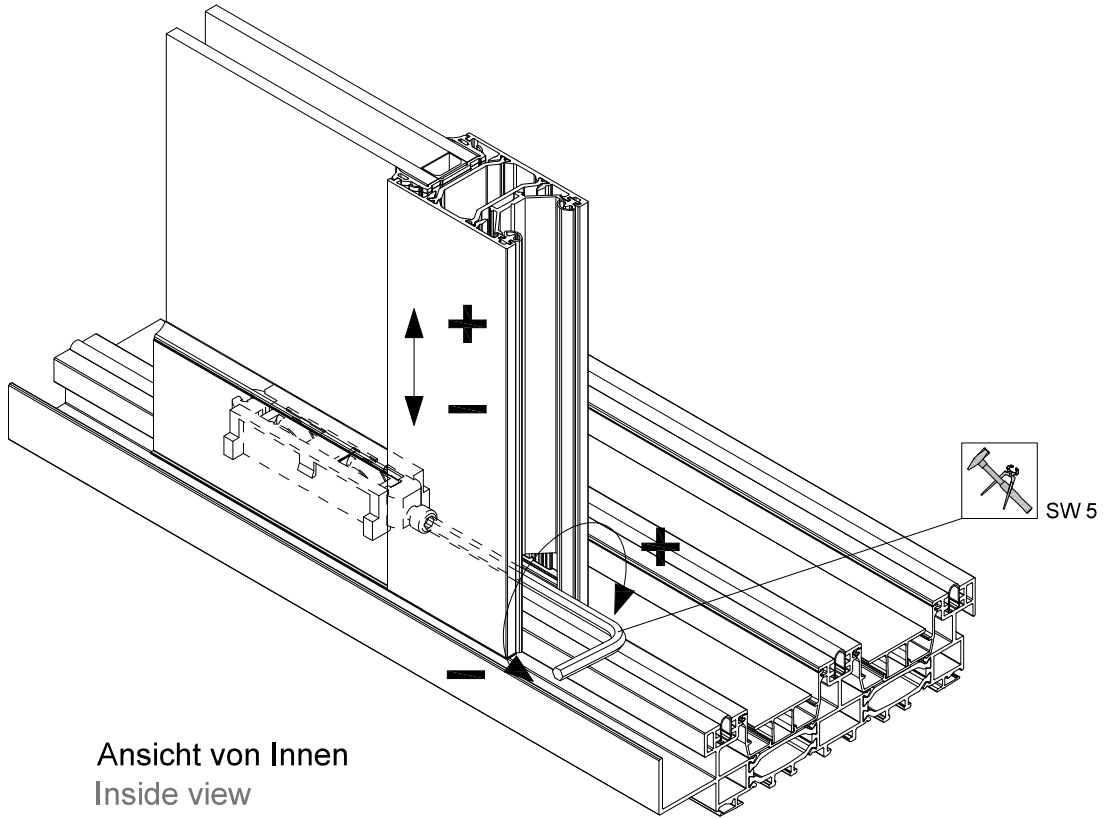
FLÜGELMONTAGE
SASH ASSEMBLY



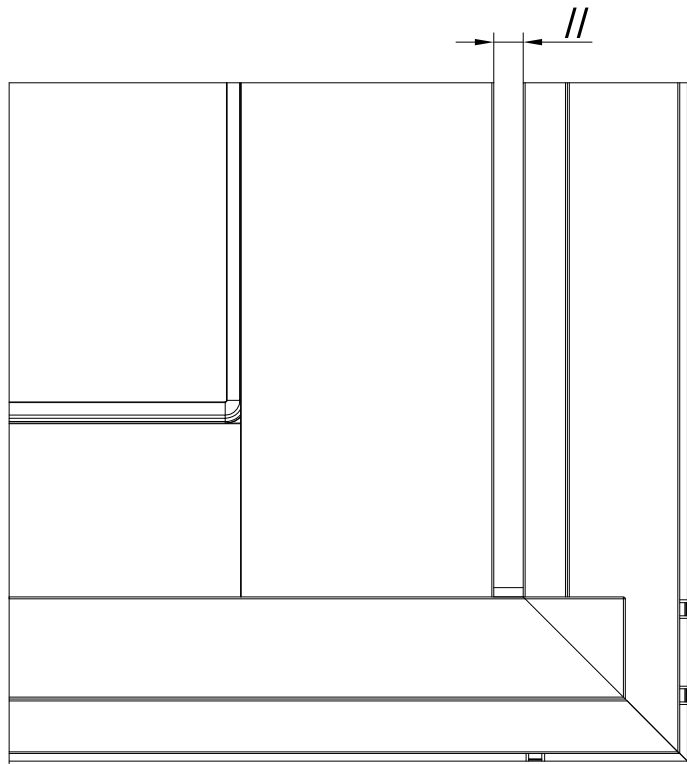
Schema E1 dargestellt
Scheme E1 shown



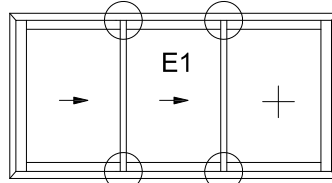
Schema E2 spiegelbildlich
Scheme E2 mirror-inverted



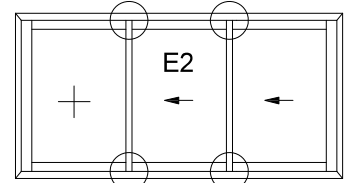
Ansicht von Innen
Inside view



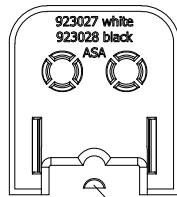
FLÜGELMONTAGE
 SASH ASSEMBLY



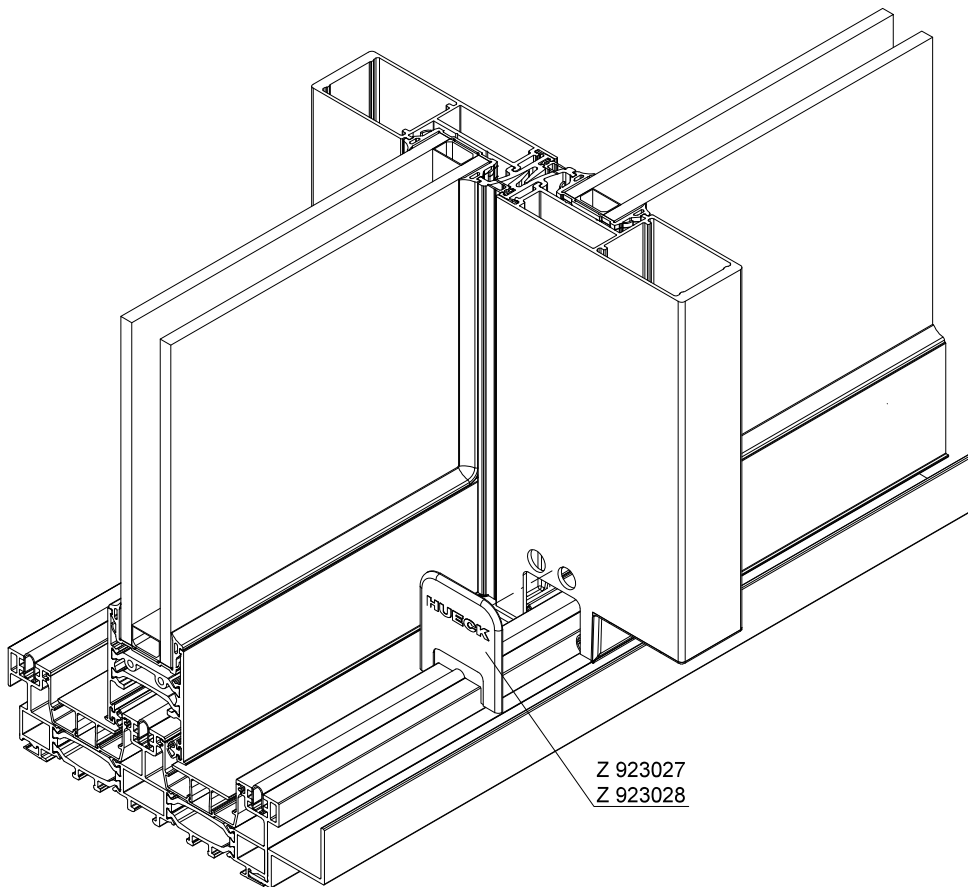
Schema E1 dargestellt
 Scheme E1 shown



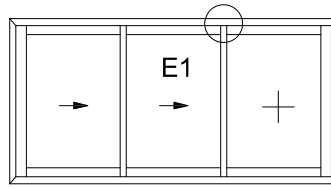
Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted



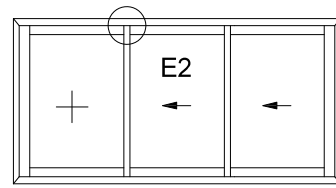
Nur unten
 Only below



FLÜGELMONTAGE
SASH ASSEMBLY

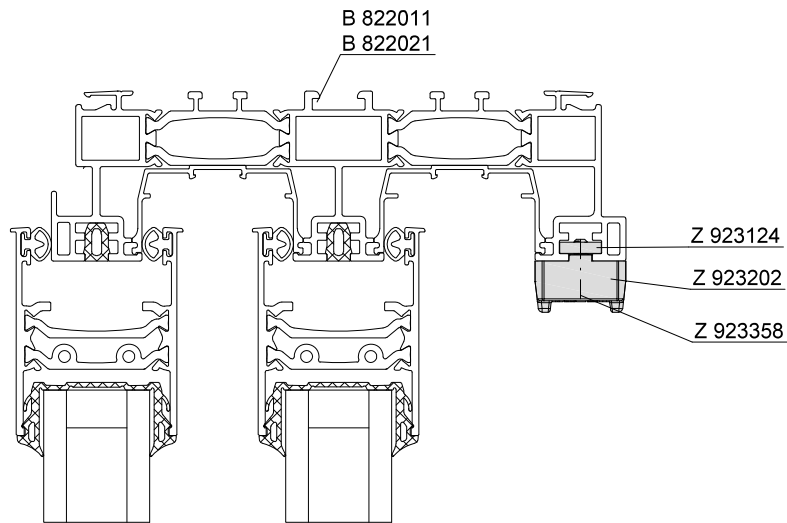


Schema E1 dargestellt
Scheme E1 shown

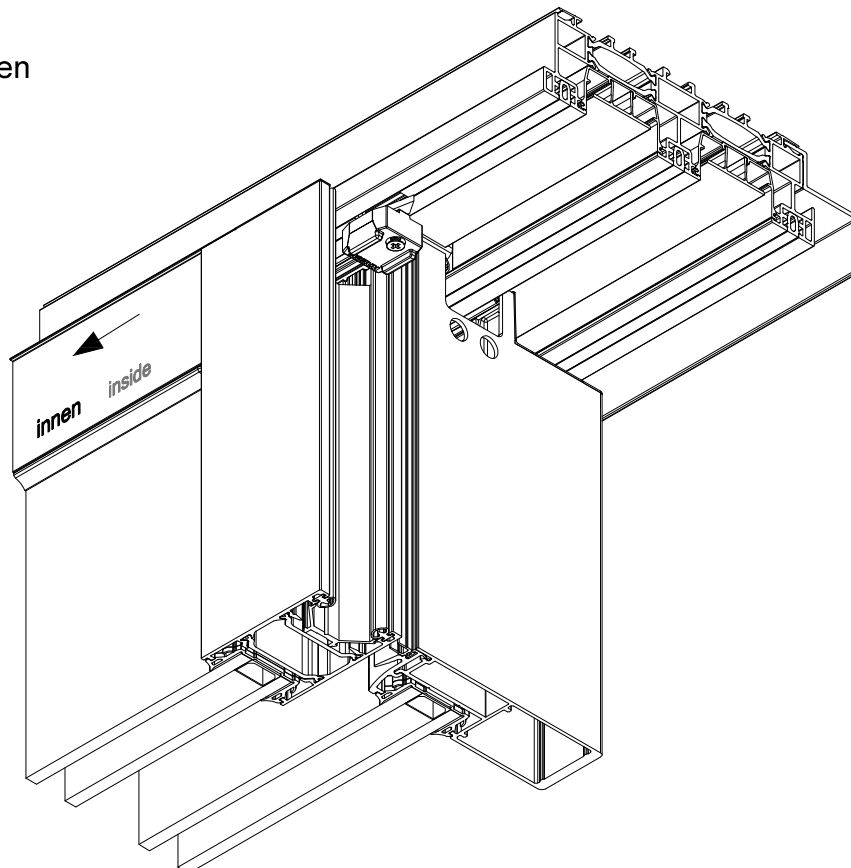


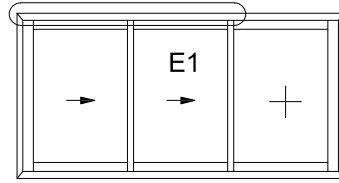
Schema E2 spiegelbildlich
Scheme E2 mirror-inverted

Offen
Open

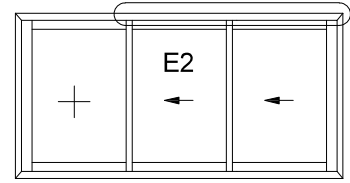


Ansicht von Innen
Inside view



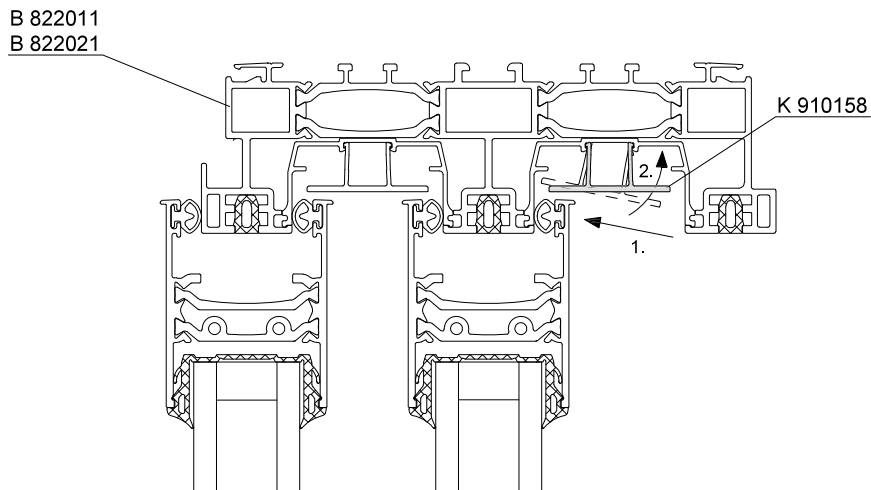
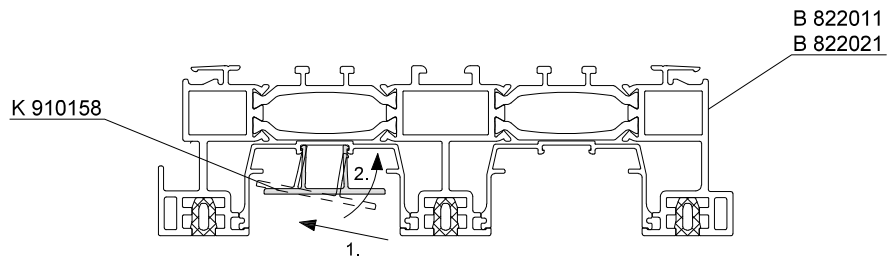
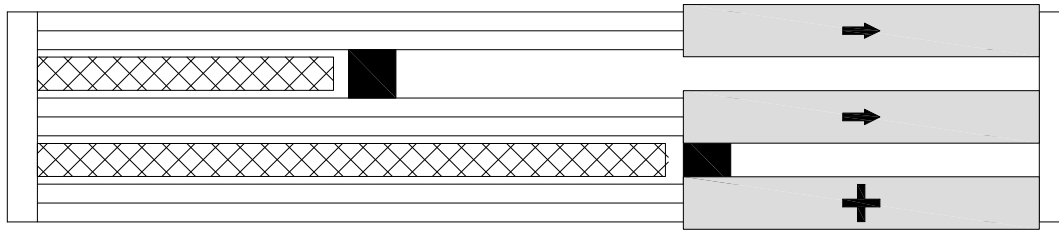


Schema E1 dargestellt
 Scheme E1 shown

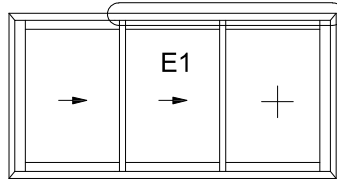


Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

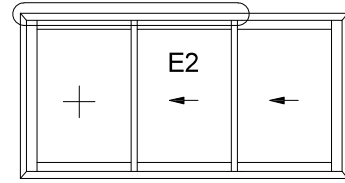
Optional
 Optionally



RAHMENMONTAGE
 FRAME ASSEMBLY

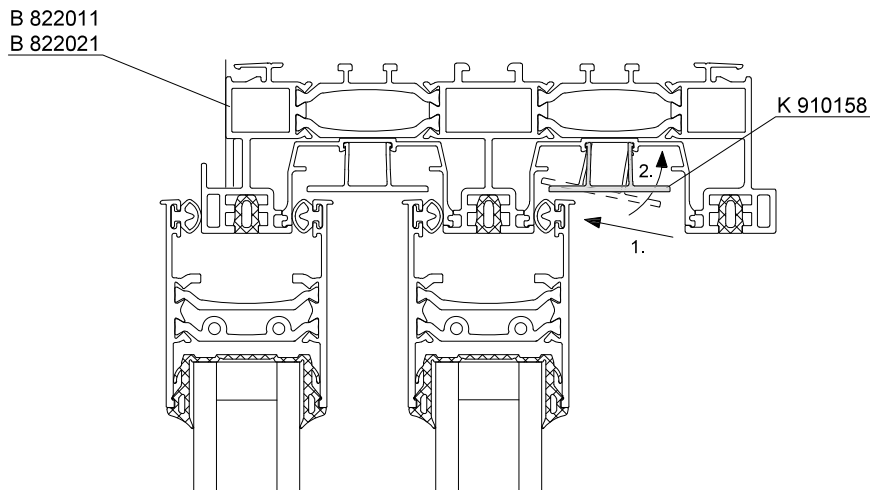
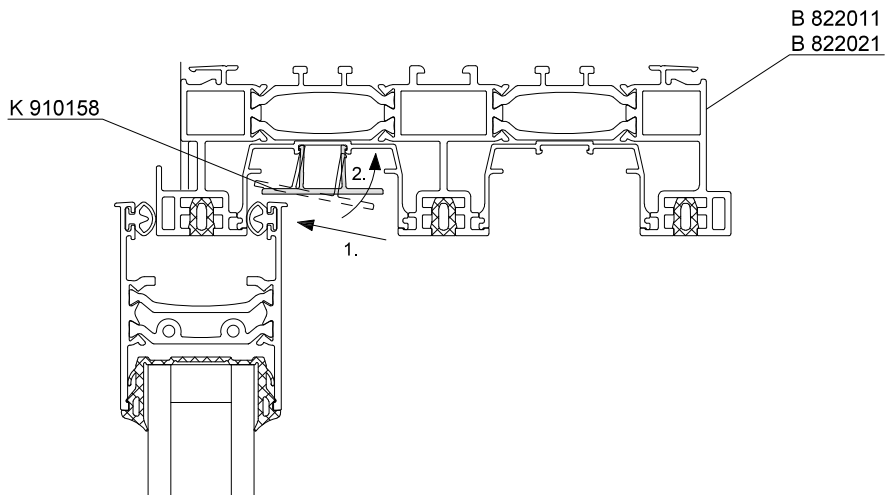
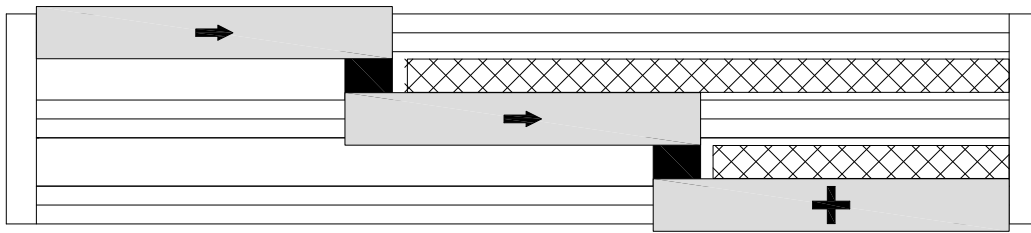


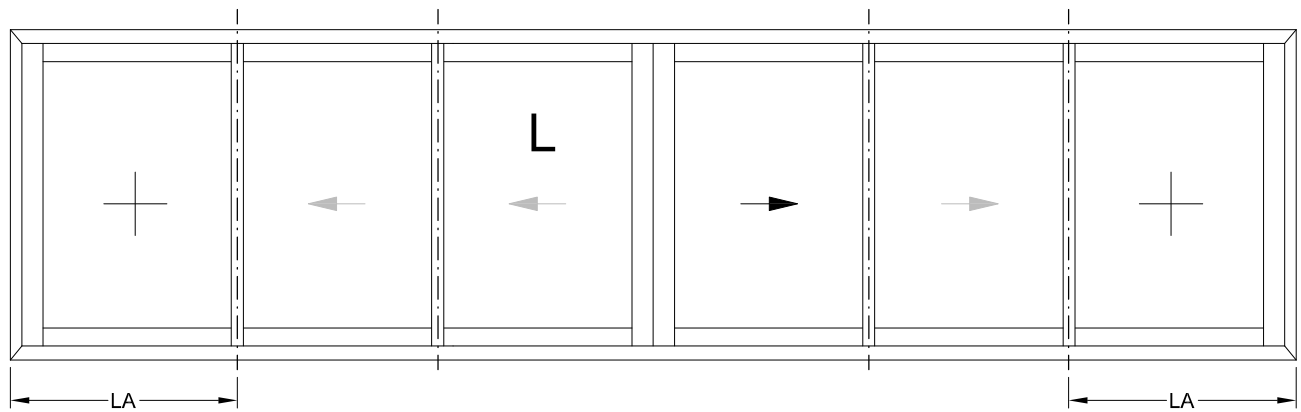
Schema E1 dargestellt
 Scheme E1 shown



Schema E2 spiegelbildlich
 Scheme E2 mirror-inverted

Optional
 Optionally





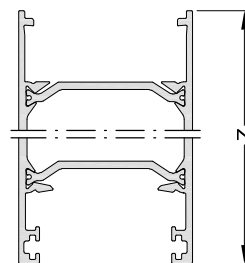
Bei gleichen Glasbreiten:

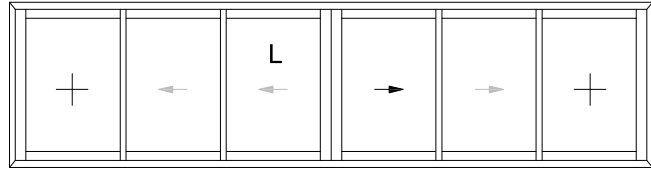
$$LA = (RB + 104 + 2 \times Z) / 6$$

For the same glas sizes

$$LA = (RB + 104 + 2 \times Z) / 6$$

	Z (mm)
B 822200	67
B 822210	77

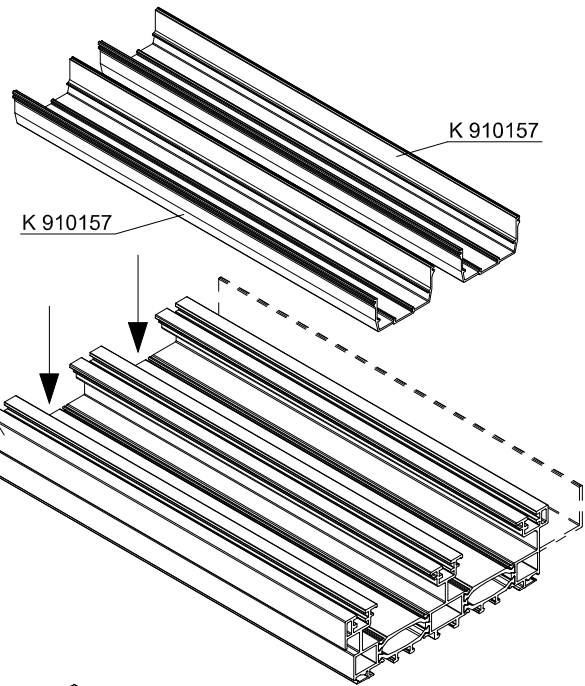
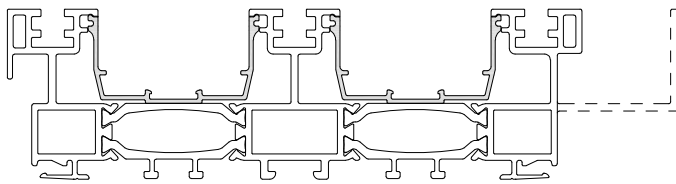




B 822011, B 822013, B 822021, B 822023

K 910157

umlaufend
circumferential



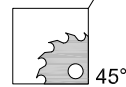
B 822011
B 822013
B 822021
B 822023

K 910157

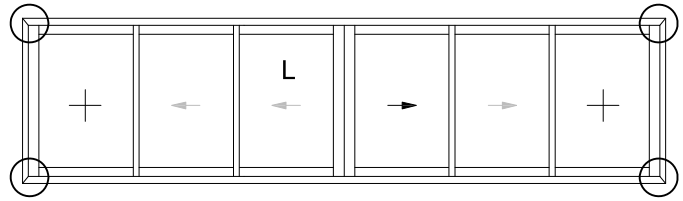
K 910157



45°



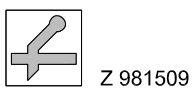
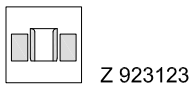
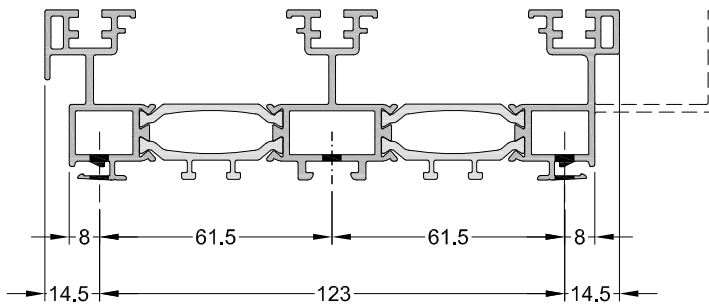
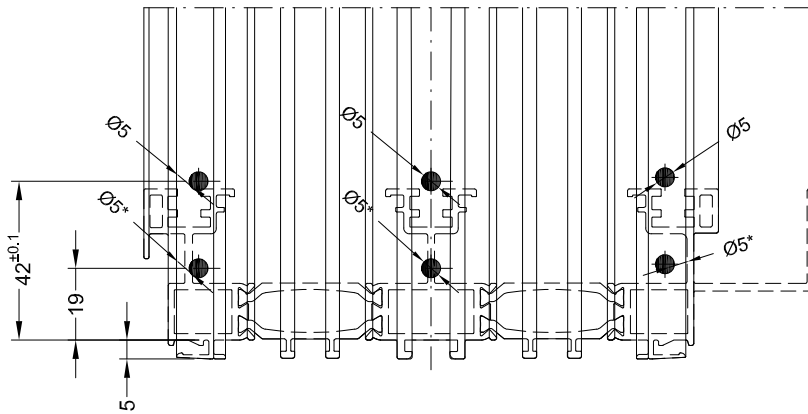
45°

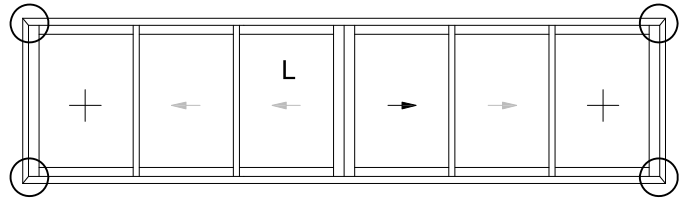


B 822011 + B 822013

* Bohrung wahlweise,
 für nachträgliche Verklebung

* drilling optional,
 for retro gluing after assembly

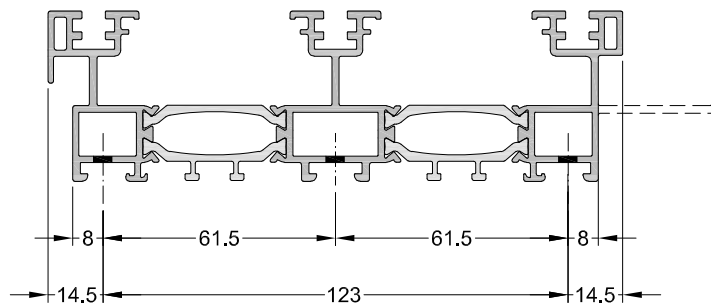
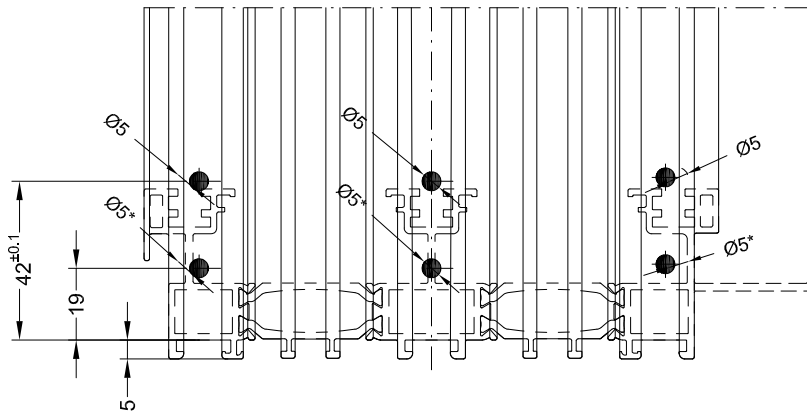




B 822021 + B 822023

* Bohrung wahlweise,
 für nachträgliche Verklebung

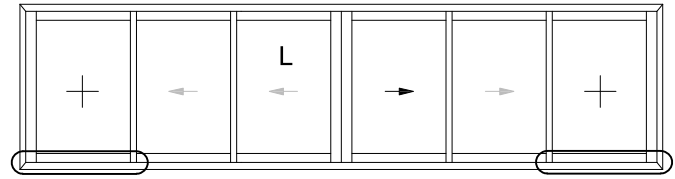
* drilling optional,
 for retro gluing after assembly



Z 923123
 Z 921426



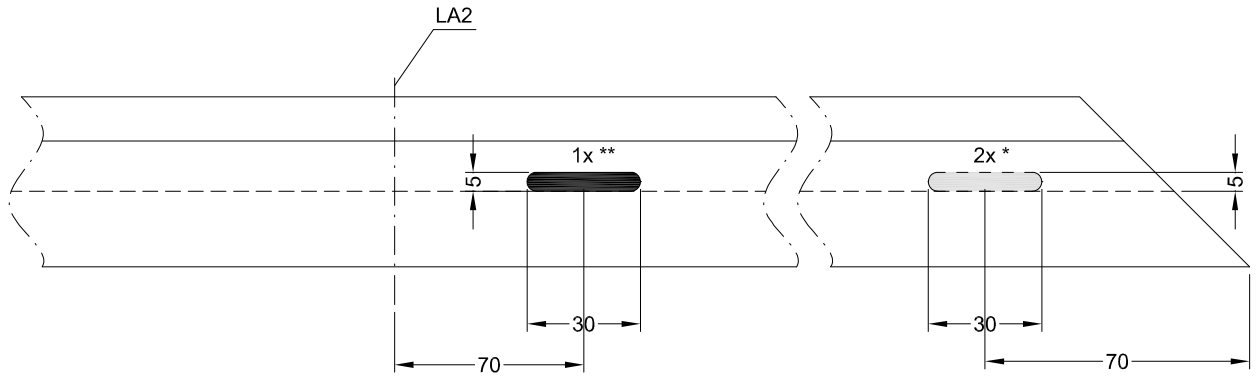
Z 981289
 Z 981423
 Z 981191
 Z 981509



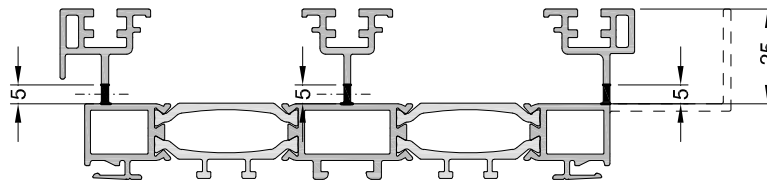
spiegelbildlich
 mirror-inverted

dargestellt
 shown

B 822011, B 822013, B 822021, B822023



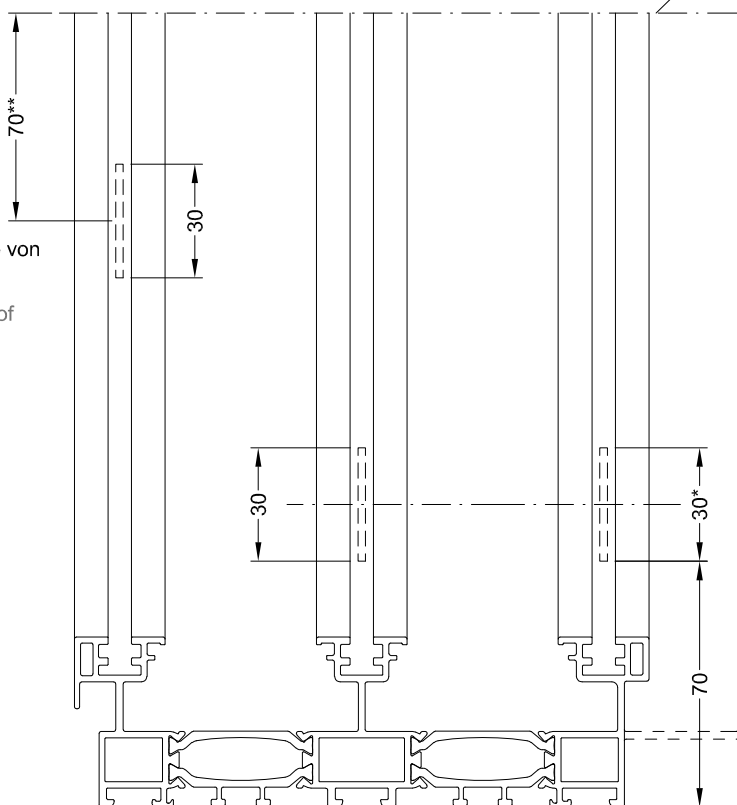
Z 981511



LA 2

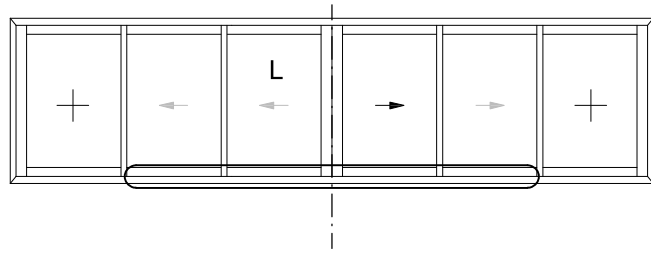
** Zur Aufnahme von
 Z 923321

** for receiving of
 Z 923321

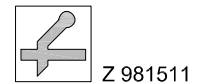
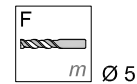
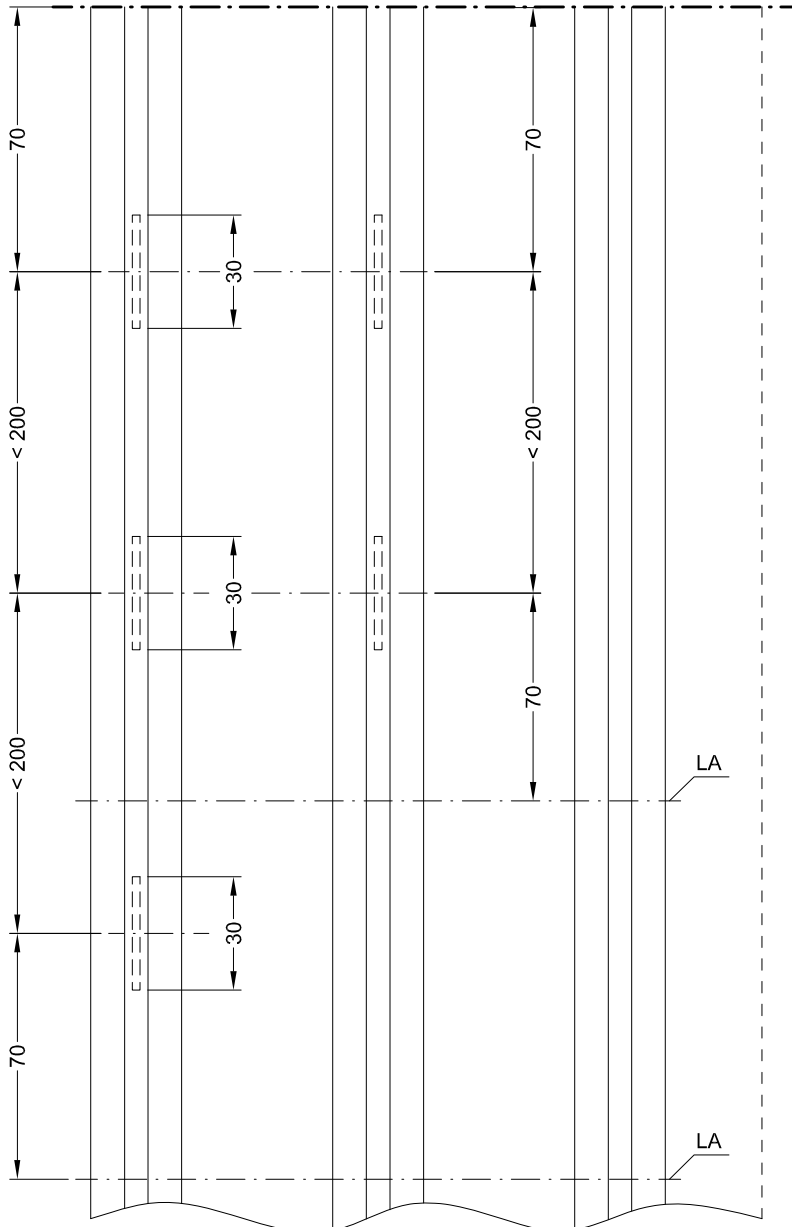
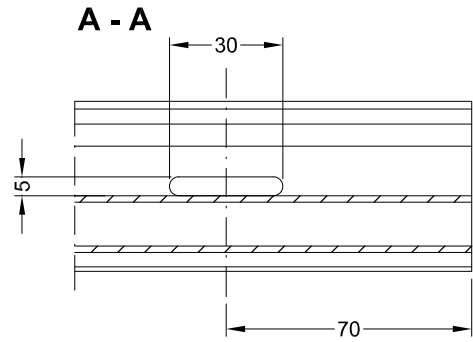
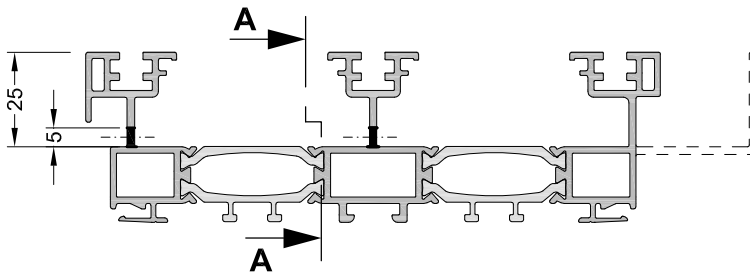


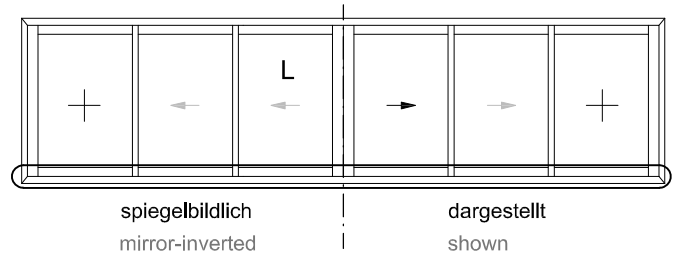
* Nur bei der Verwendung vom
 Wetterschenkel P 496456
 oder Rahmen B 822013 / B 822023 !

* only when using water bar
 P 496456 or frame B 822013 / B 823023!

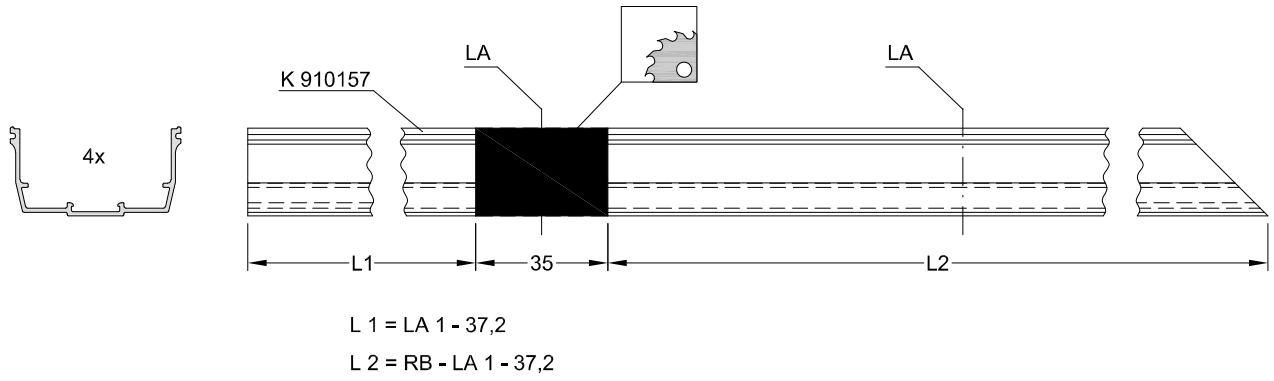


B 821011, B 821013, B 821021, B821051

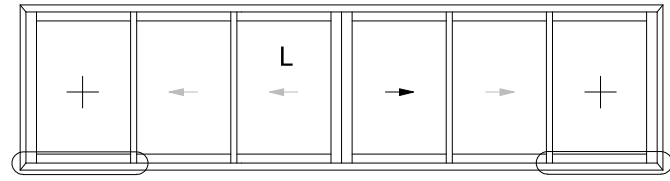




K 910157 + K 910158

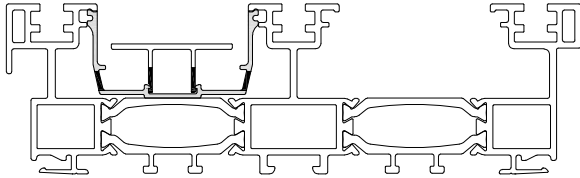


RAHMENBEARBEITUNG
 FRAME PROCESSING

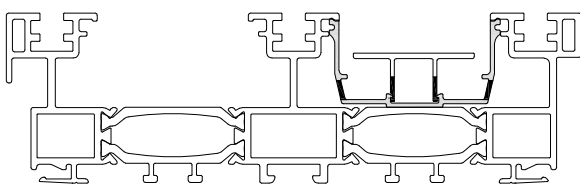
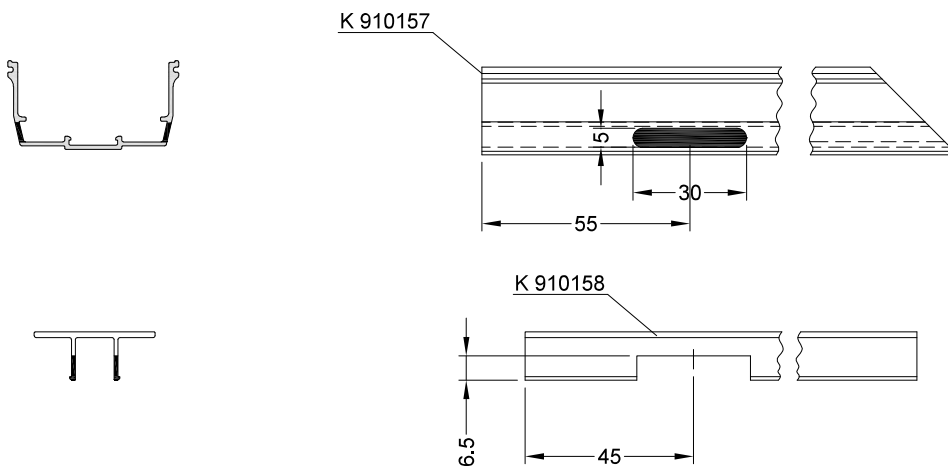


spiegelbildlich
 mirror-inverted

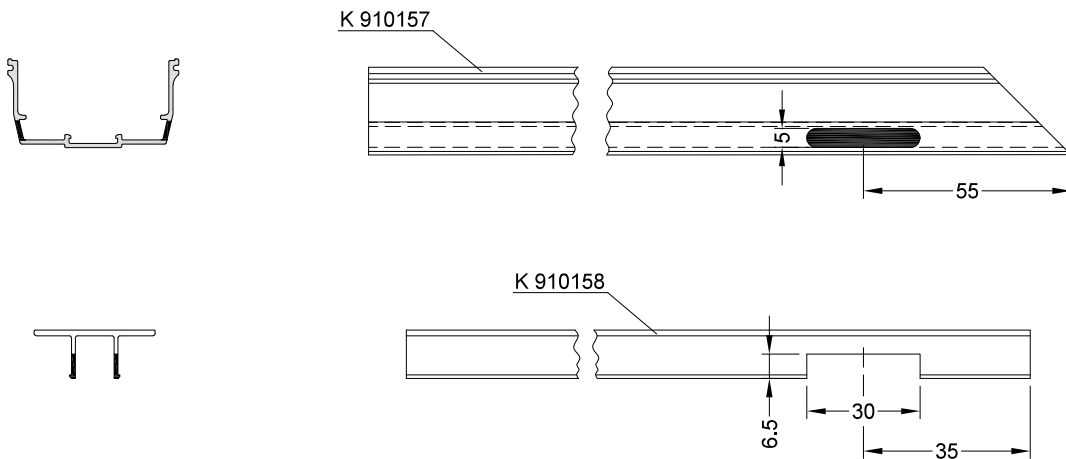
dargestellt
 shown



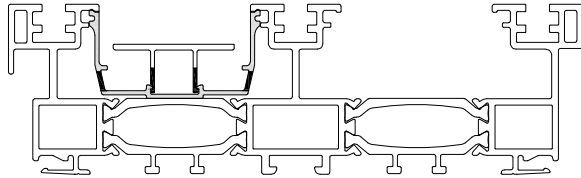
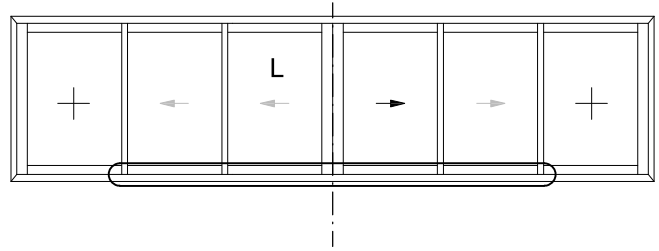
Z 981512



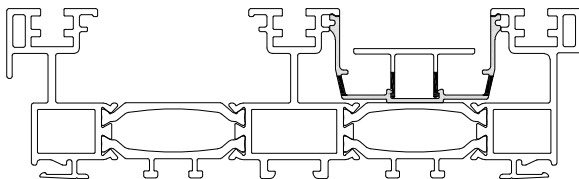
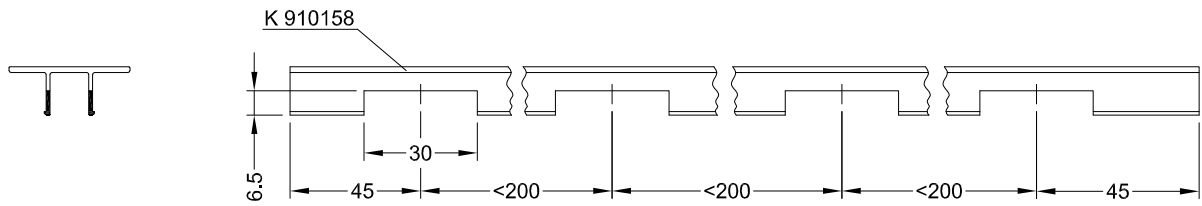
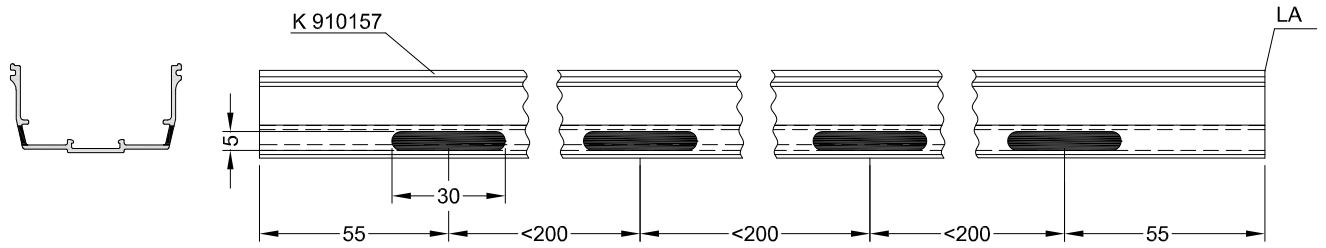
Z 981512



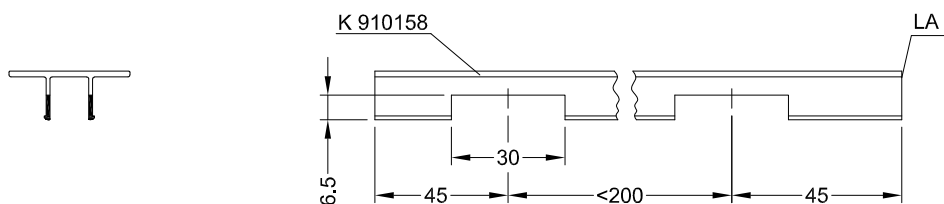
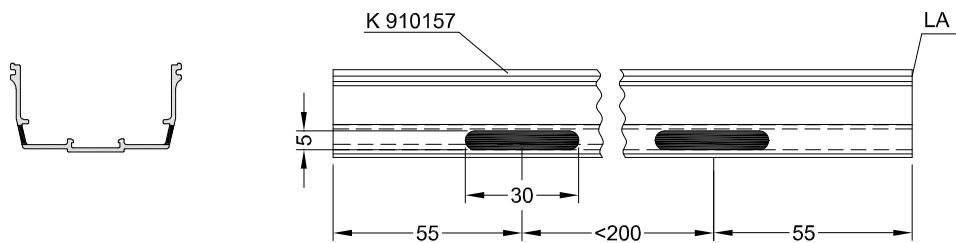
RAHMENBEARBEITUNG
 FRAME PROCESSING



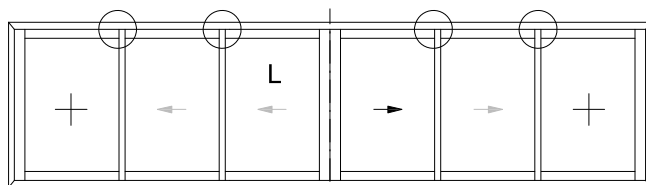
Z 981512



Z 981512

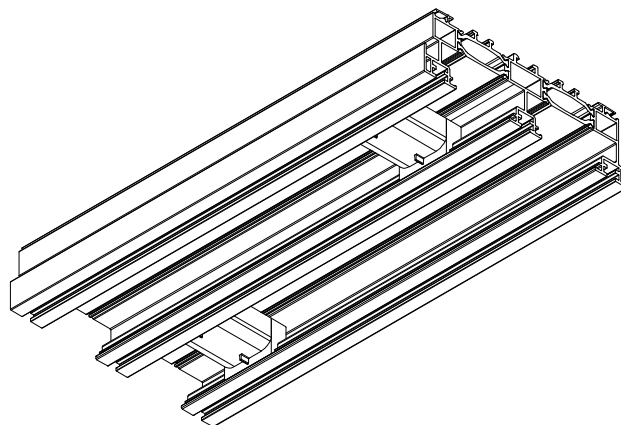
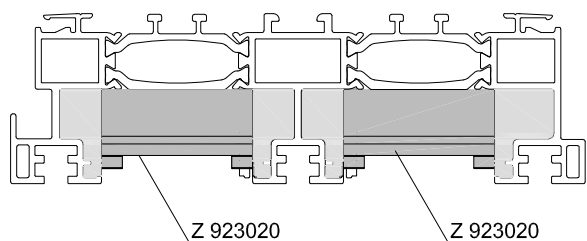
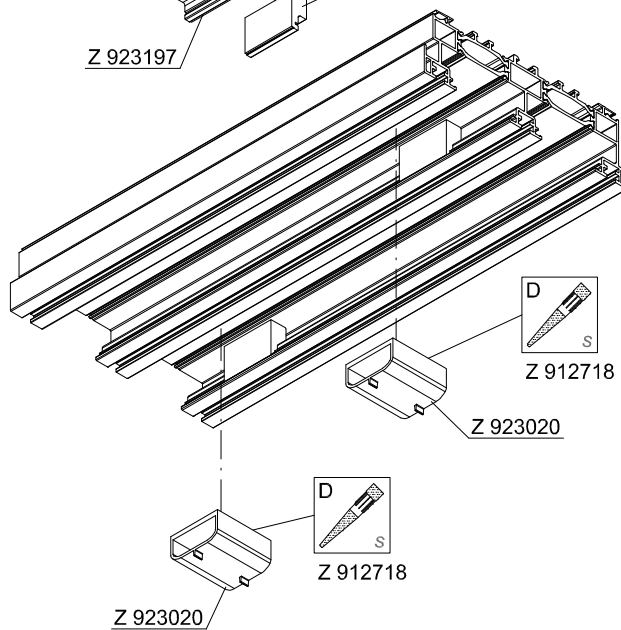
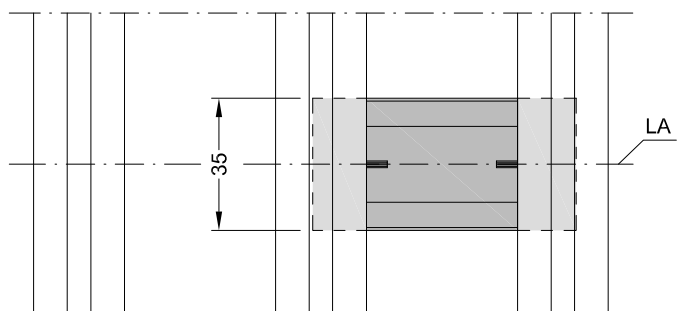
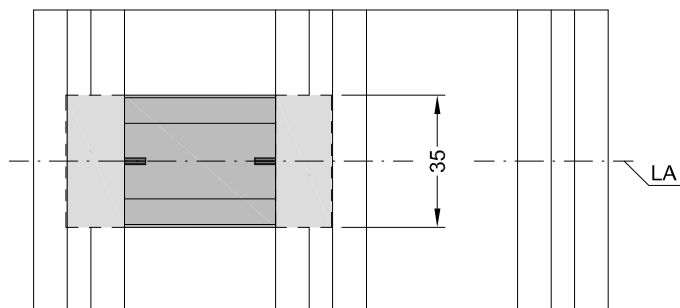
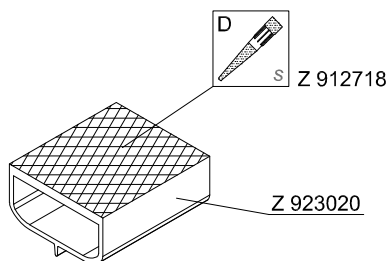
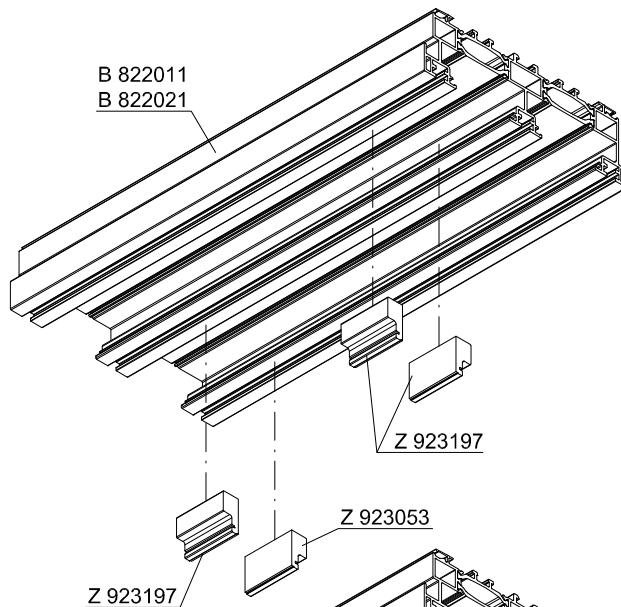
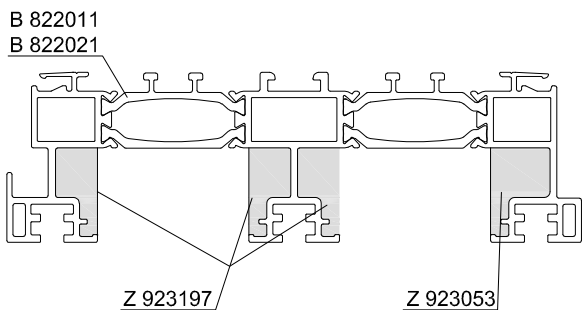


RAHMENMONTAGE
 FRAME ASSEMBLY

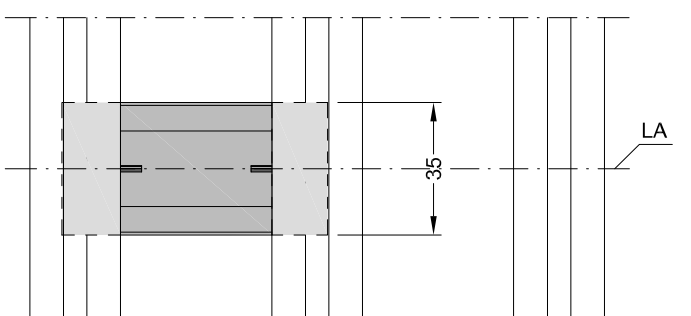
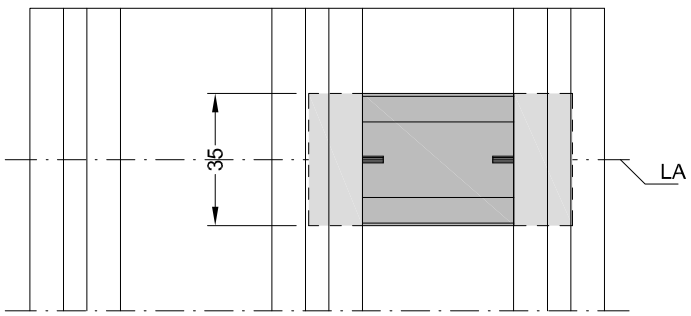
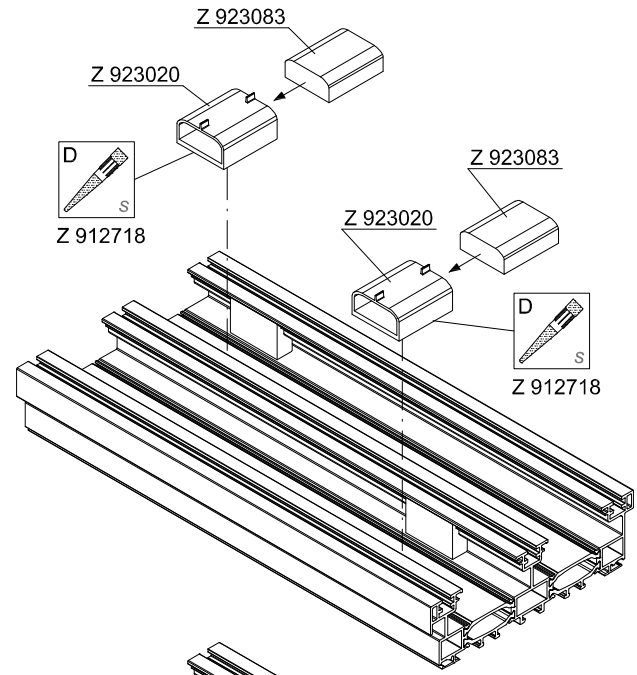
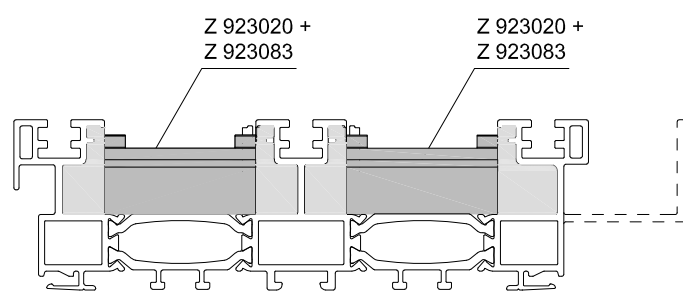
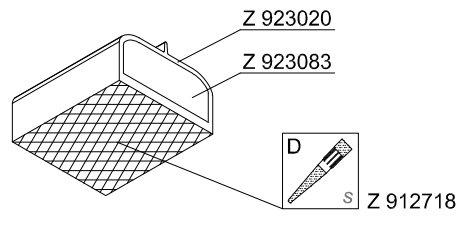
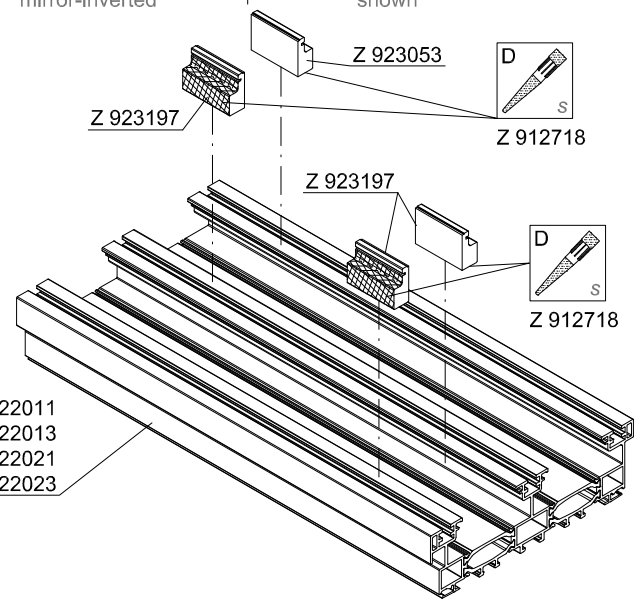
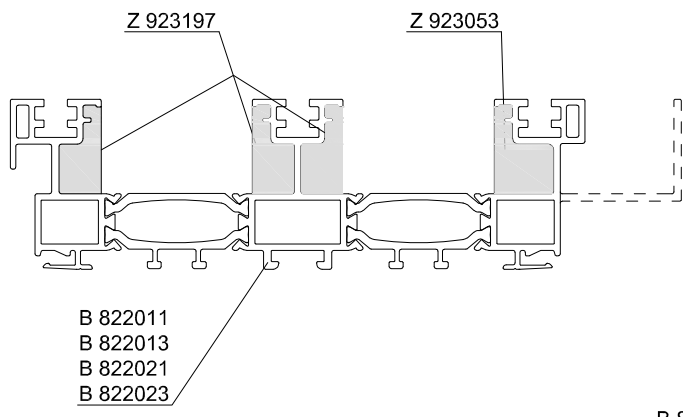
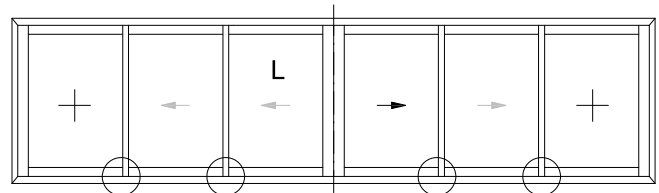


spiegelbildlich
 mirror-inverted

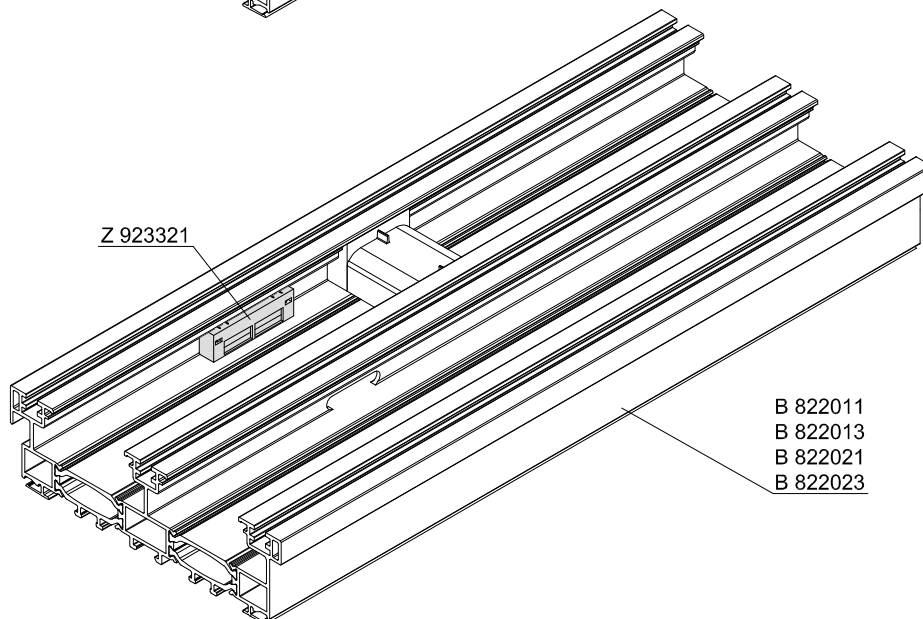
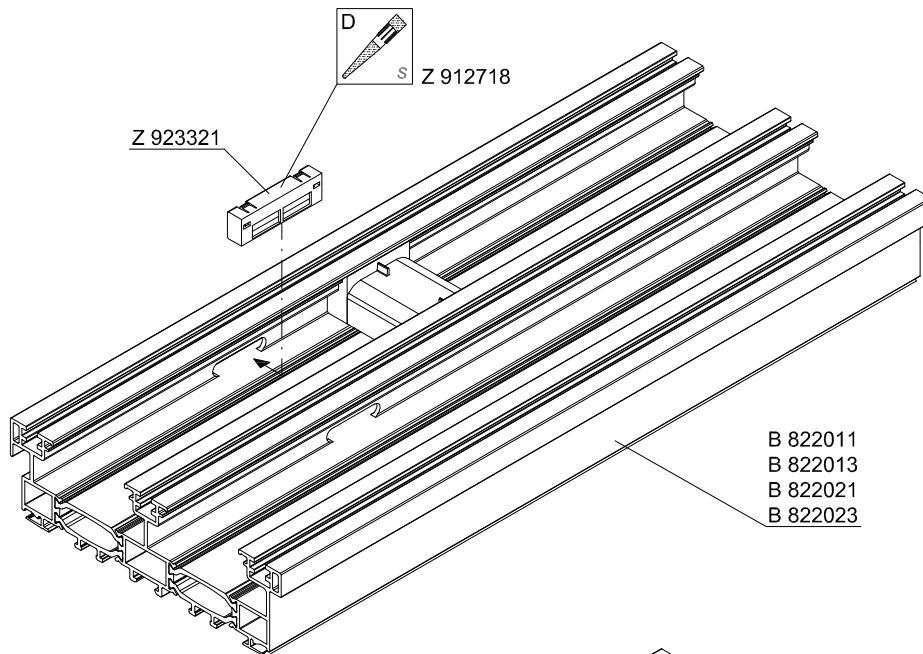
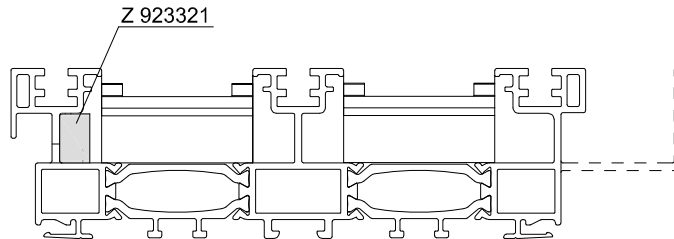
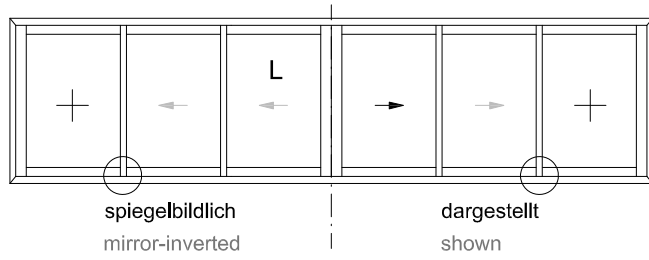
dargestellt
 shown



RAHMENMONTAGE
 FRAME ASSEMBLY

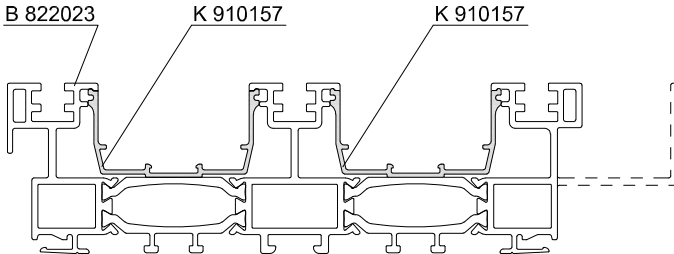


RAHMENMONTAGE
 FRAME ASSEMBLY



RAHMENMONTAGE
FRAME ASSEMBLY

B 822011
B 822013
B 822021
B 822023

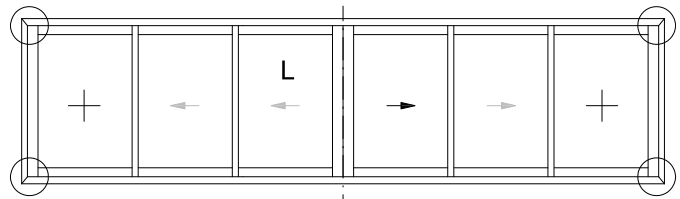


Bearbeitungsschritte

1. K 910157 umlaufend eindrücken
2. Schnittflächen versiegeln
3. Falls keine nachträgliche Verklebung vorgesehen ist, müssen vor dem Fügen alle Profilinnenflächen im Eckbereich mit HUECK Metallkleber bestrichen werden
4. Eckverbinder einschieben
5. Rahmen fügen (erst Innen-, dann Außenkammer)
6. Ecke ausrichten
7. Ecke verstiften
8. Kleber einspritzen, bis der Kleber an den Stiften austritt

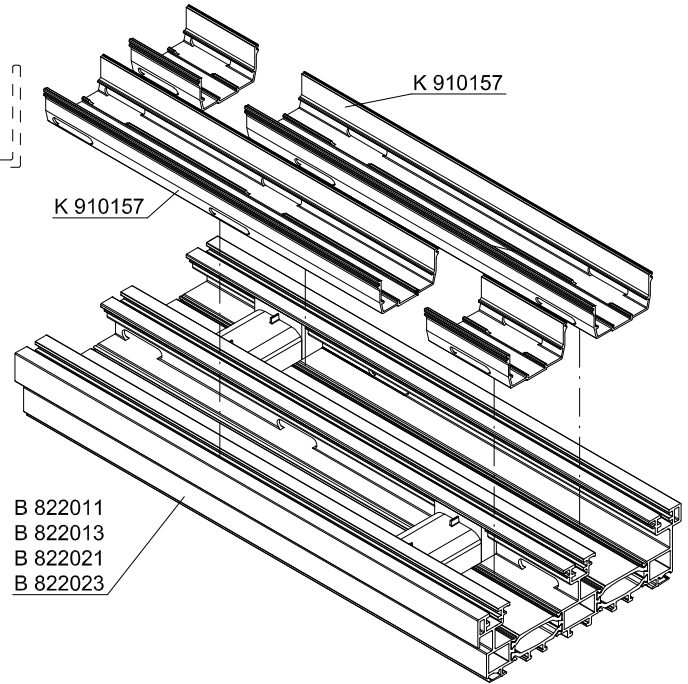
Processing steps

1. Insert K 910157 circumferential
2. Seal the cut surfaces
3. If there is no subsequent gluing planned, all inner profile surfaces at the corner area must be applied with HUECK metal glue before joining
4. Slide in the corner bracket
5. Join the frame (Internal chamber at first, then external)
6. Adjust the corner
7. Nail the corner
8. Insert the glue, till the glue leaks at the pins

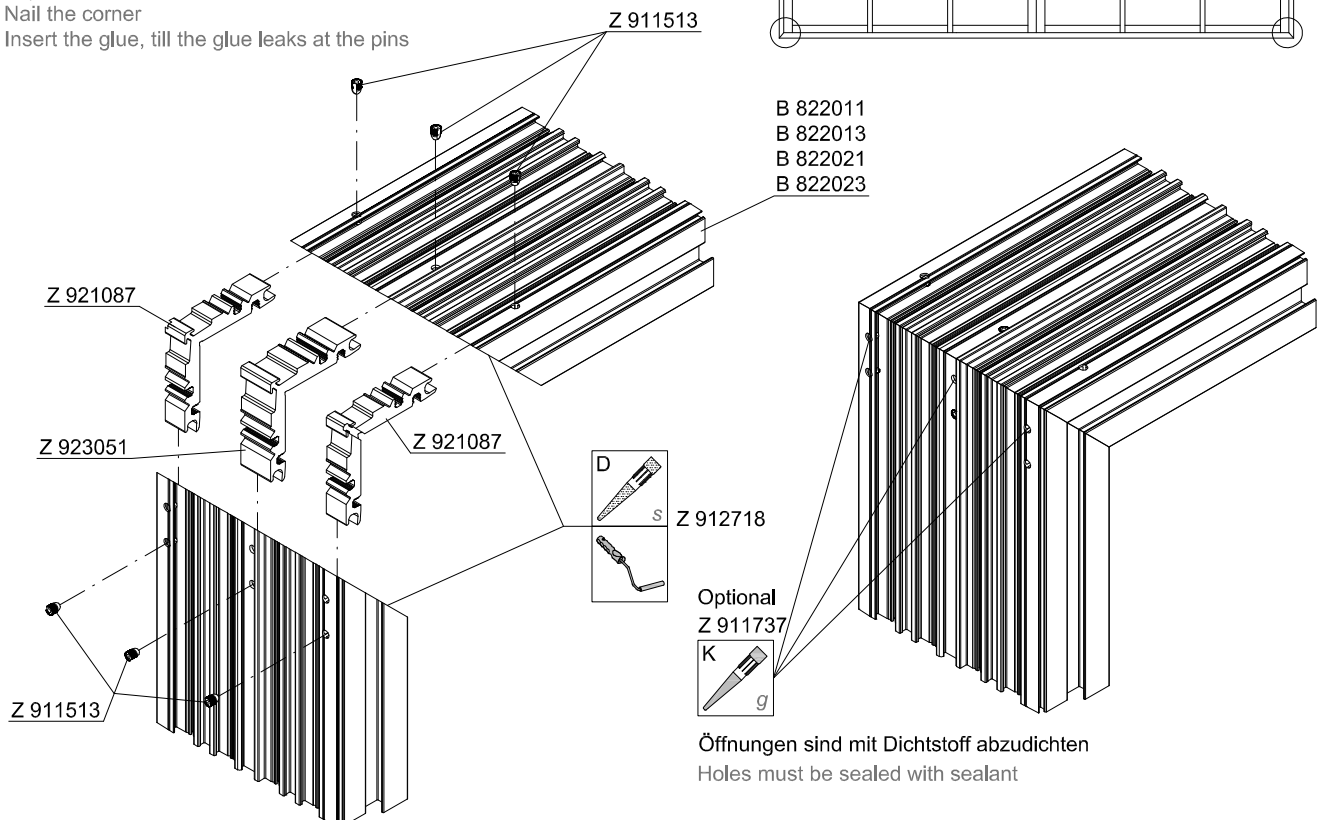
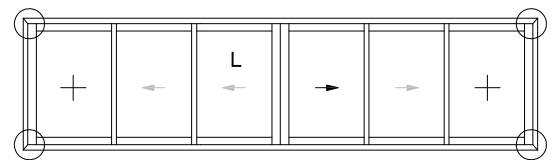


spiegelbildlich
mirror-inverted

dargestellt
shown



B 822011
B 822013
B 822021
B 822023



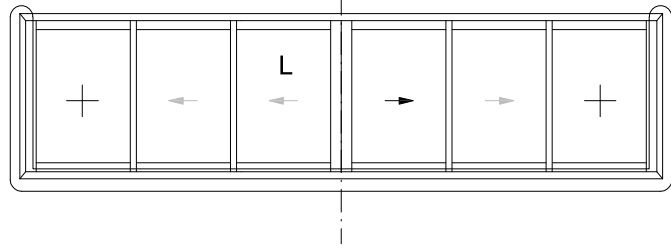
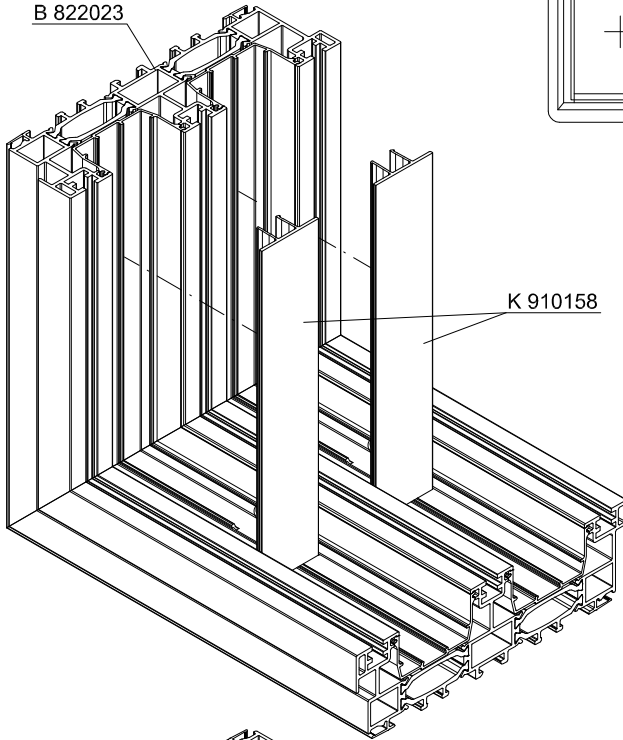
Optional
Z 911737



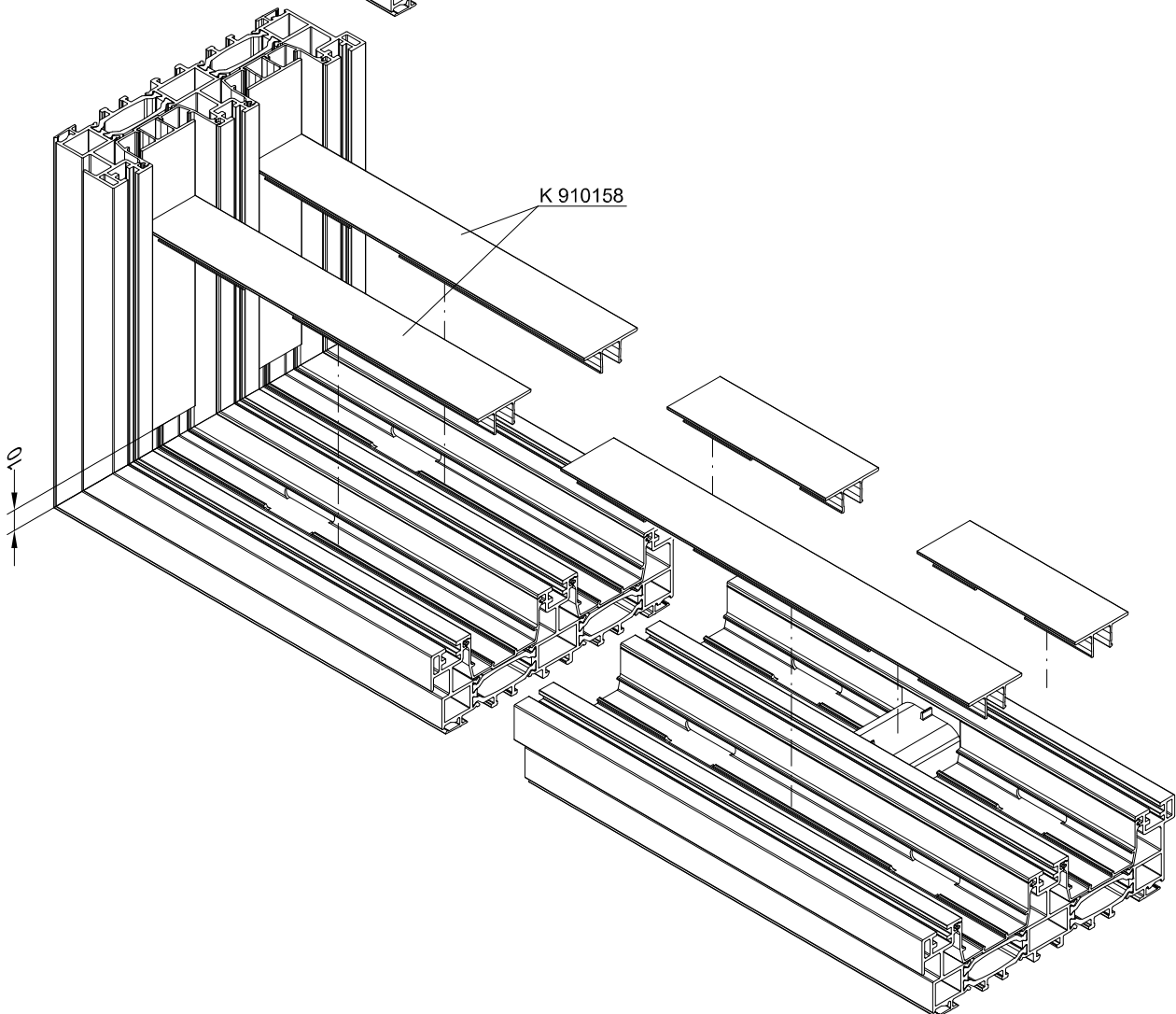
Öffnungen sind mit Dichtstoff abzudichten
Holes must be sealed with sealant

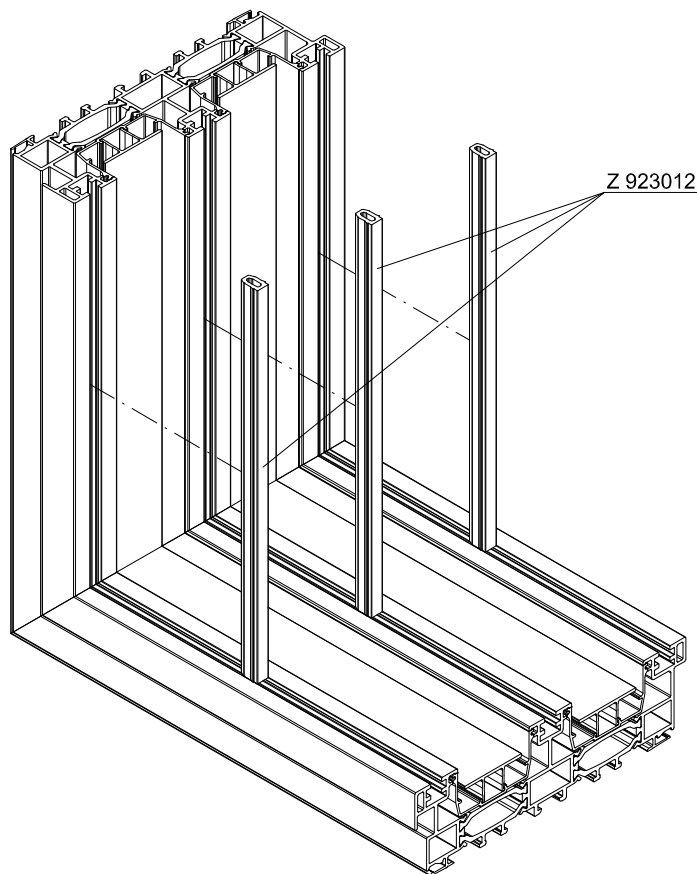
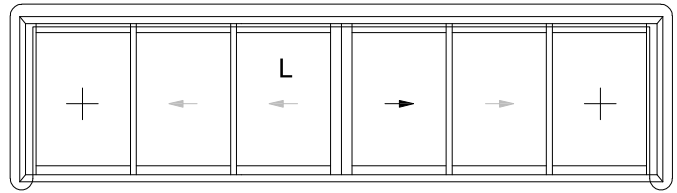
RAHMENMONTAGE
FRAME ASSEMBLY

B 822011
B 822013
B 822021
B 822023



Dreiseitig
Three-sided





Dreiseitig
 Three-sided



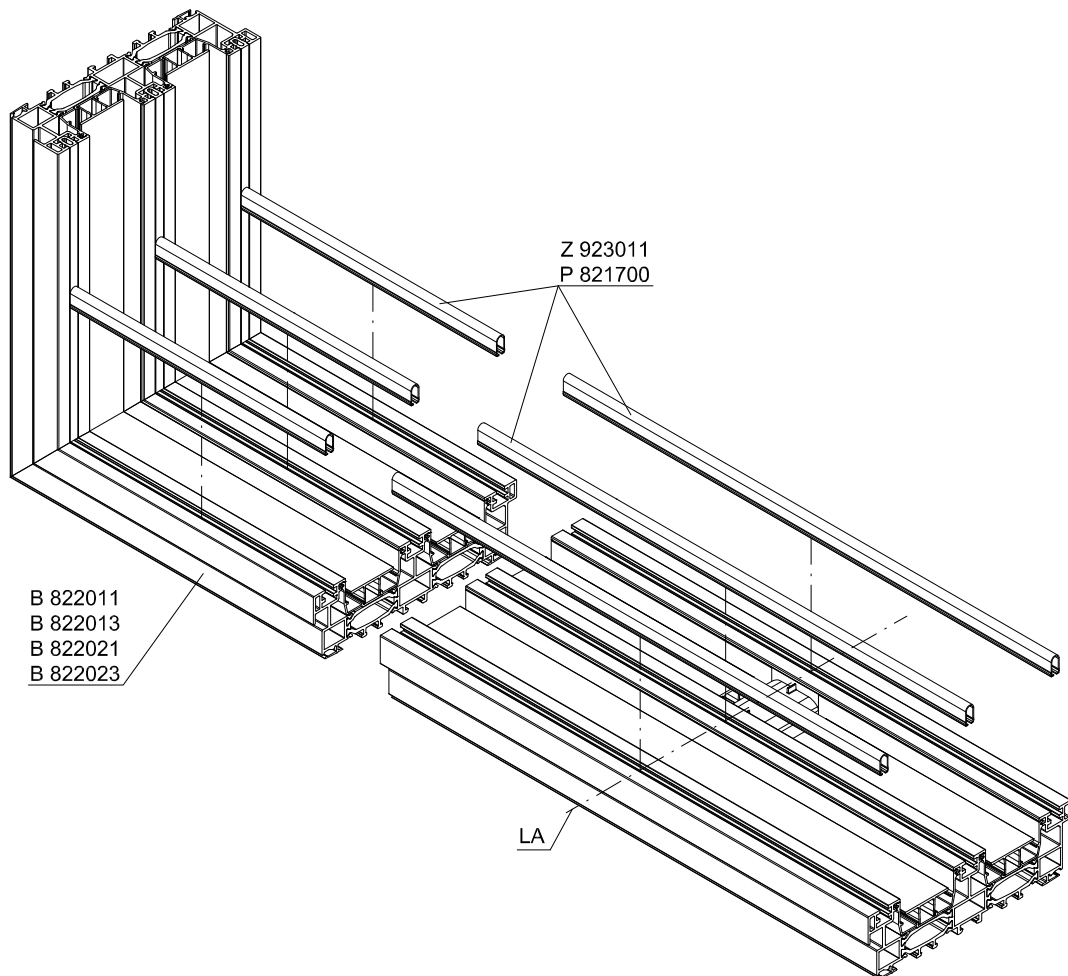
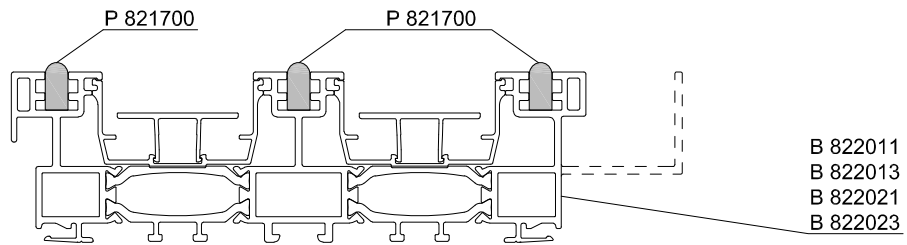
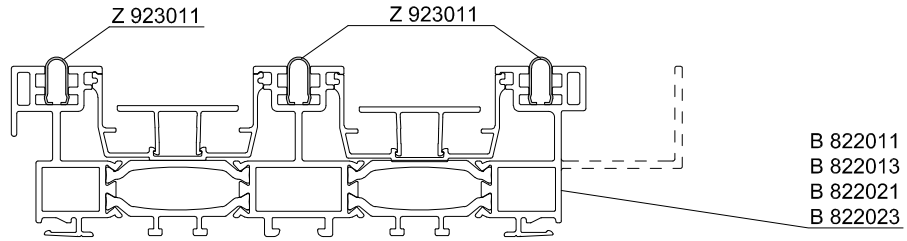
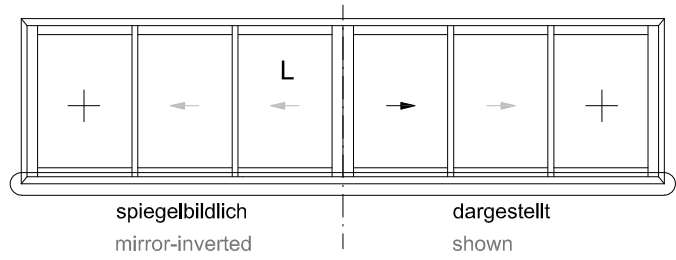
Bearbeitungsschritte

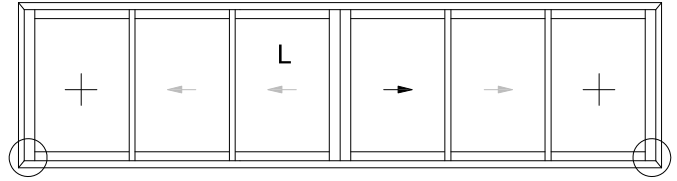
1. Schließteile einbauen und positionieren
 (siehe Kapitel Beschlageinbau)
2. Dichtungen einziehen

Processing steps

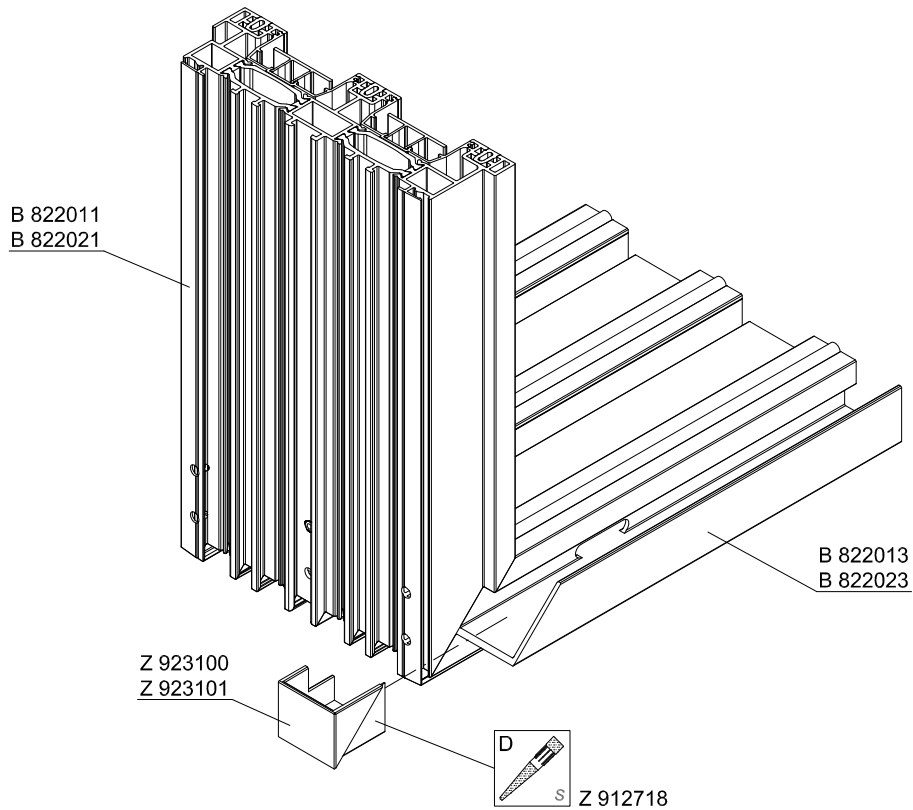
1. Install and position the locking parts
 (see chapter fitting installation)
2. Insert the gaskets

RAHMENMONTAGE
 FRAME ASSEMBLY



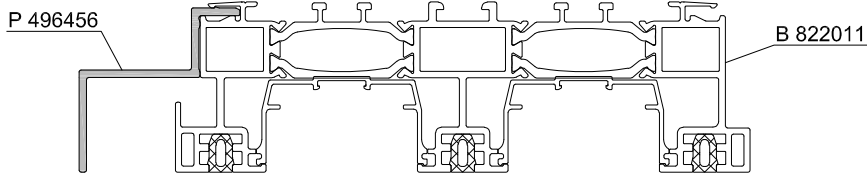
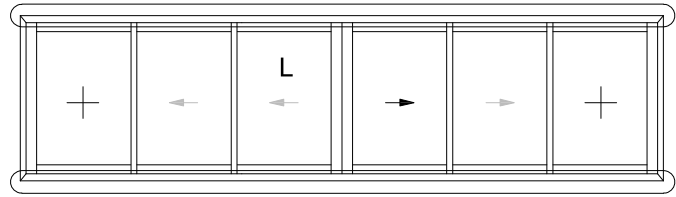


Nur bei B 822013 / B 822023
 Only at B 822013 / B 822023

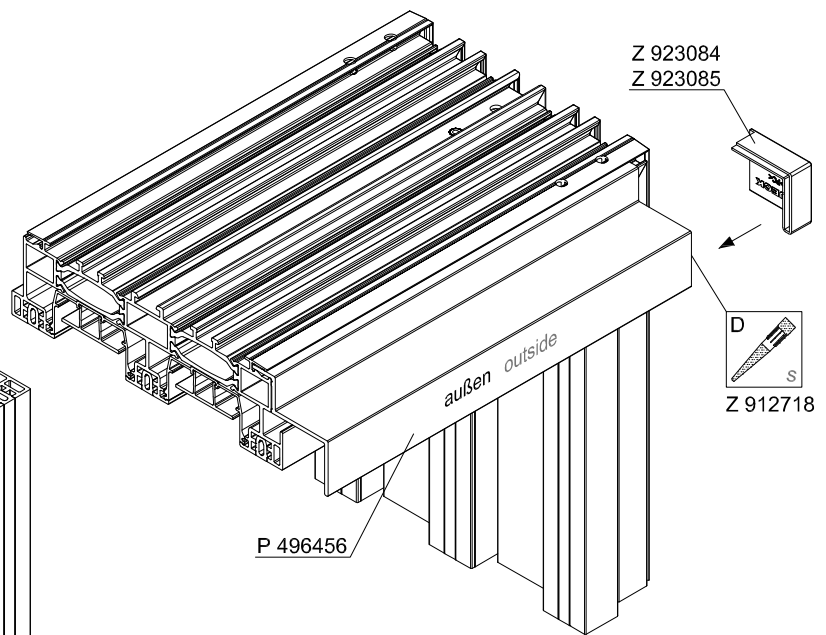
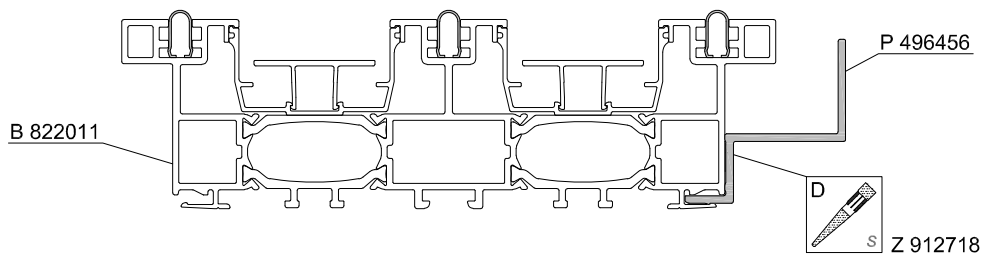


Öffnungen sind mit Dichtstoff abzudichten
 Holes must be sealed with sealant

RAHMENMONTAGE
FRAME ASSEMBLY



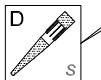
Optional



Z 923084
Z 923085

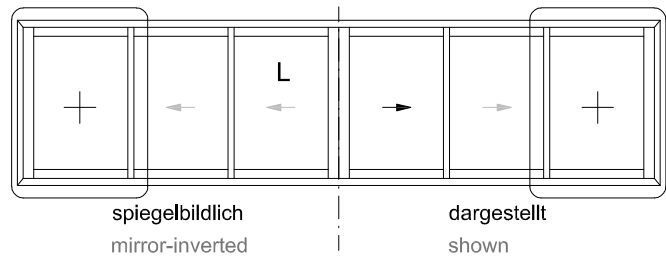


Z 912718



P 496456

innen
inside

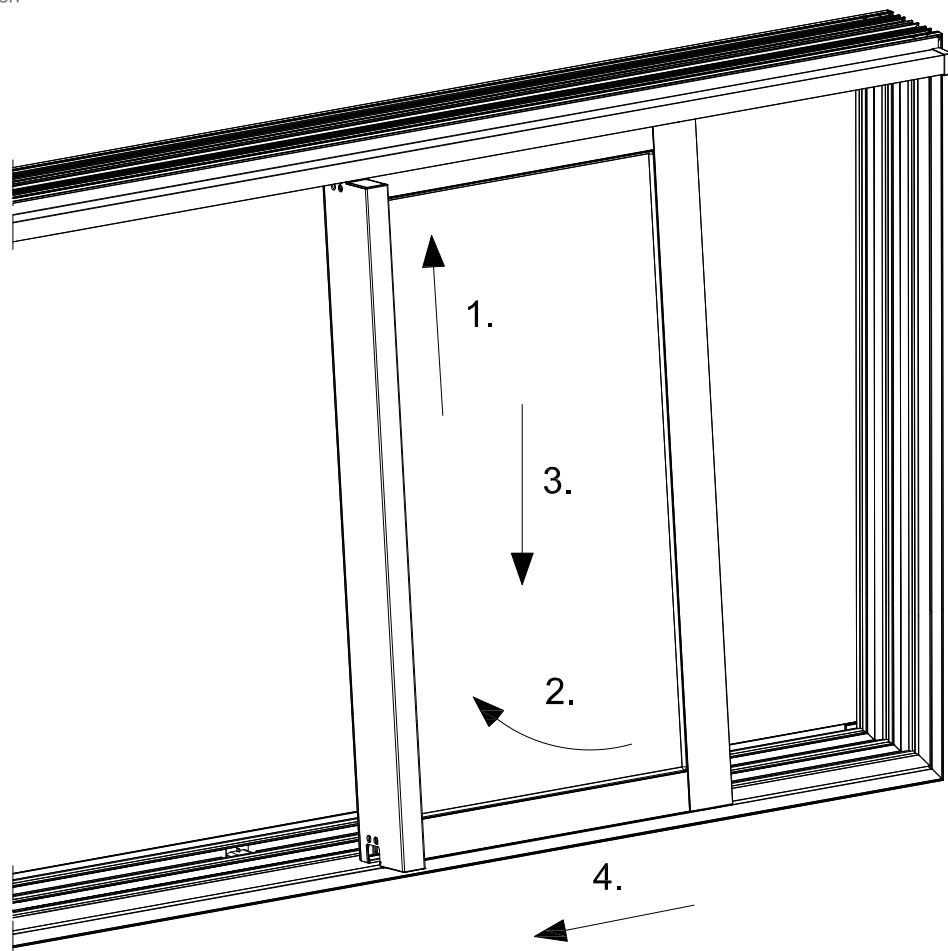


Bearbeitungsschritte

1. Äußere Flügel montieren
 (Siehe Kapitel Verarbeitung / Montage Flügel)
2. Äußere Flügel einhängen

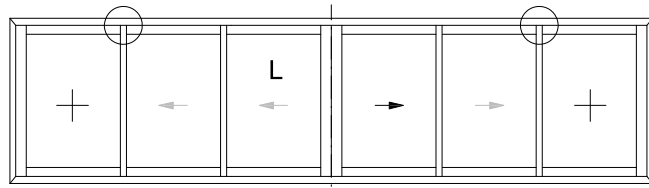
Processing steps

1. Assemble the outer sash
 (see chapter processing / assembly sash)
2. Insert the outer sash



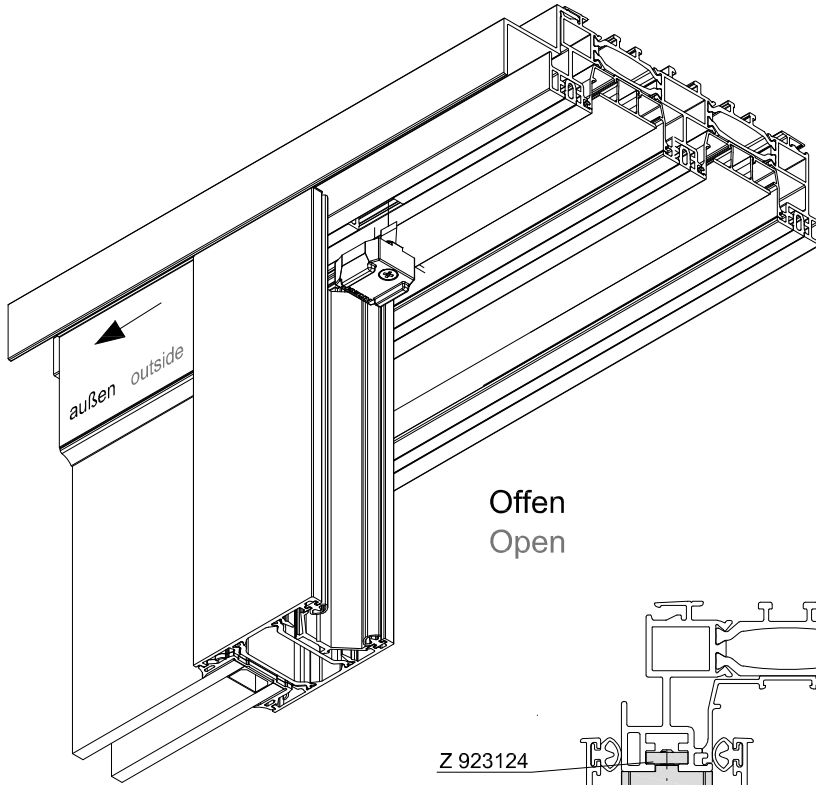
Ansicht von Außen
 Outside view

FLÜGELMONTAGE
 SASH ASSEMBLY



spiegelbildlich
 mirror-inverted

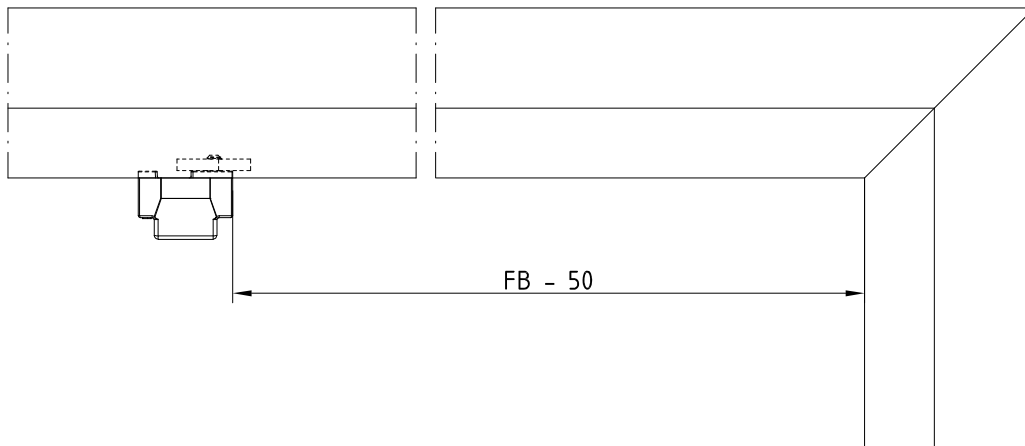
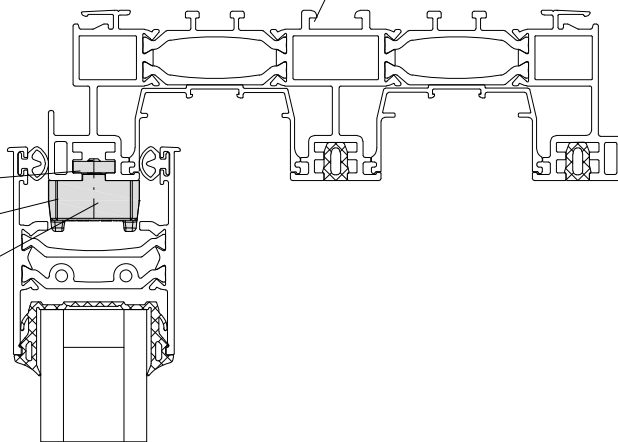
dargestellt
 shown



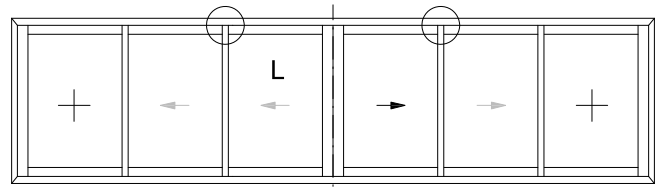
Offen
 Open

Z 923124
 Z 923202
 Z 923358

B 822011
 B 822021

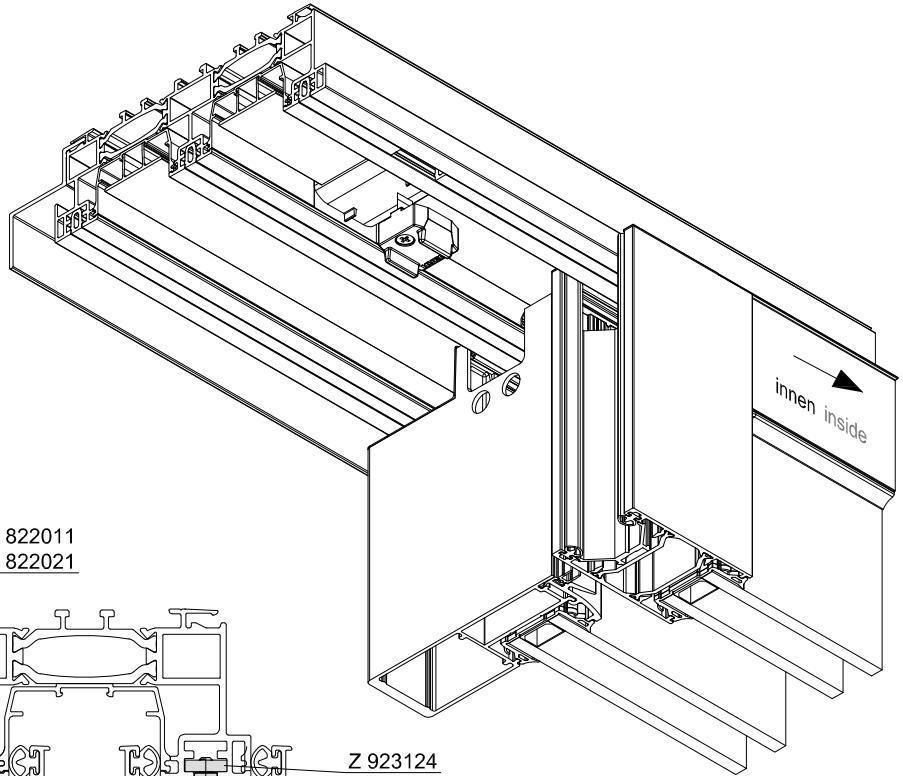


FLÜGELMONTAGE
 SASH ASSEMBLY

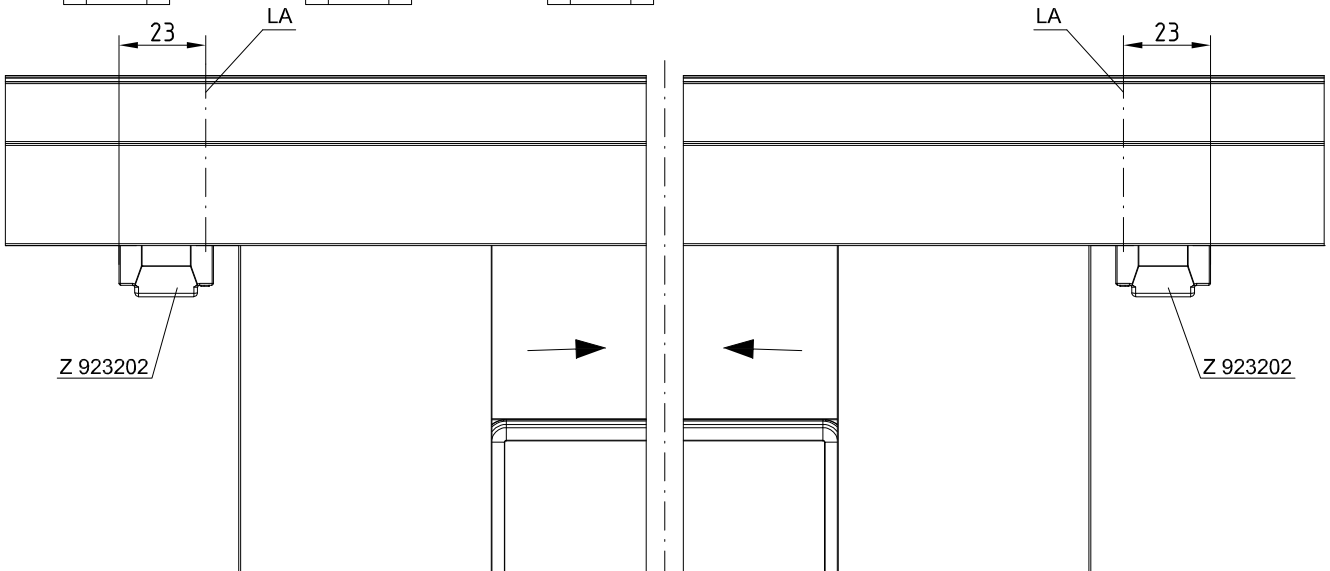
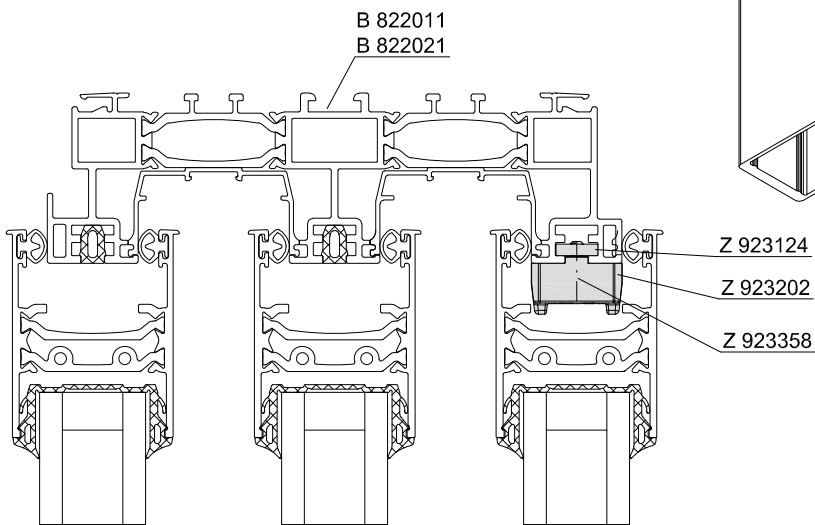


spiegelbildlich
 mirror-inverted

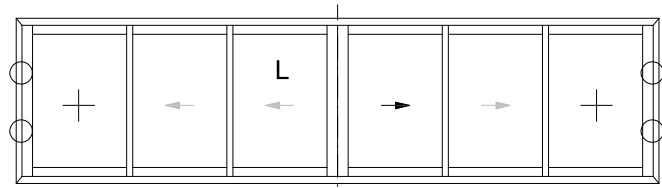
dargestellt
 shown



Offen
 Open

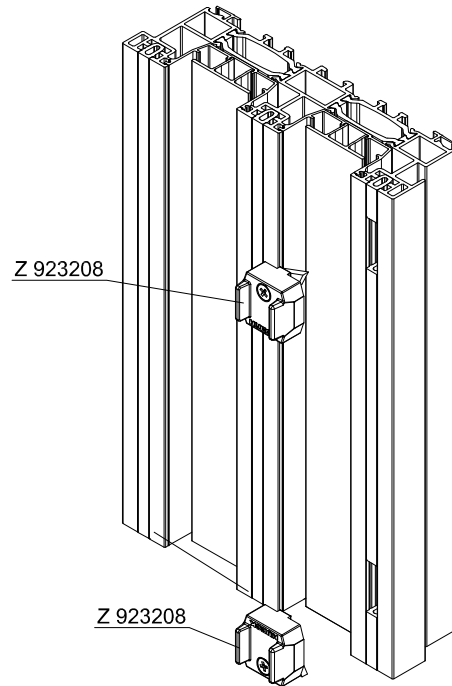
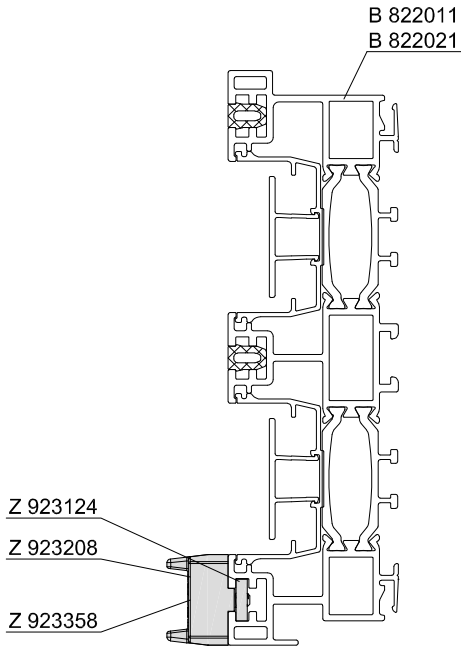


FLÜGELMONTAGE
SASH ASSEMBLY

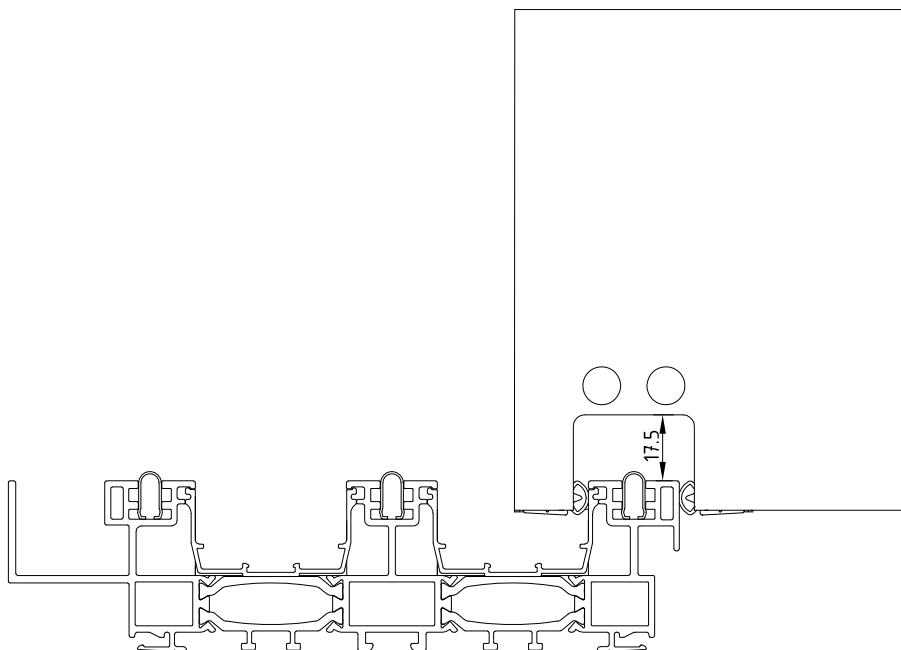
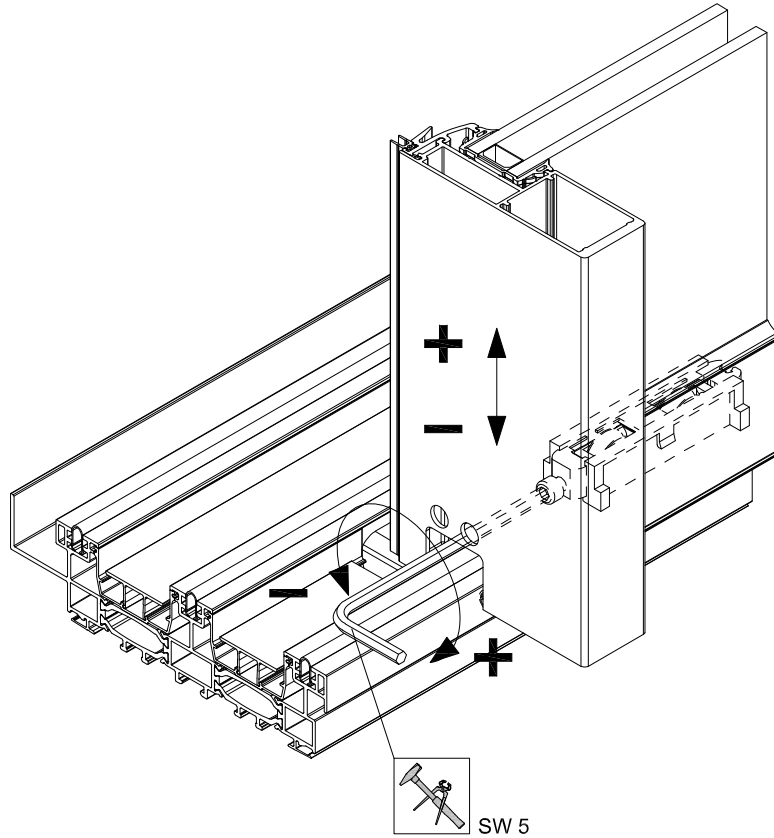
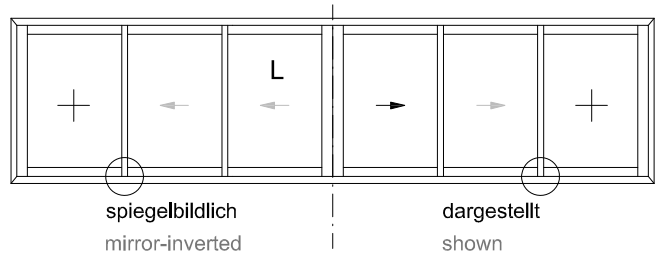


spiegelbildlich
mirror-inverted

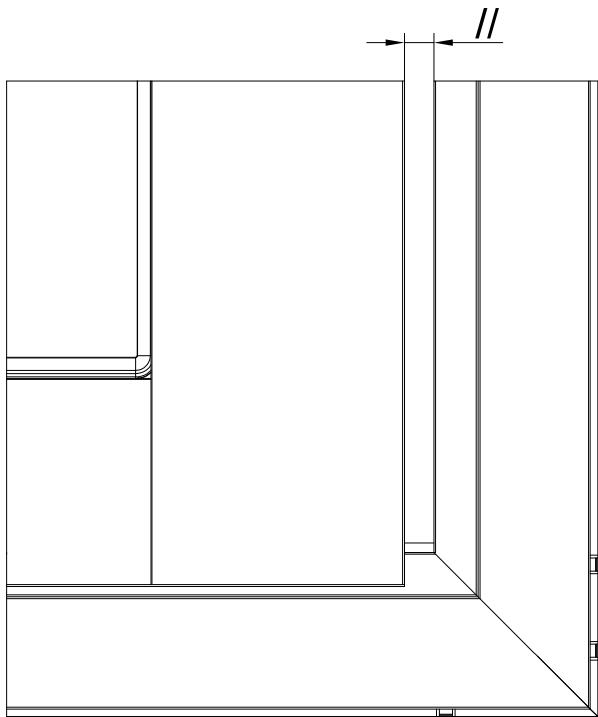
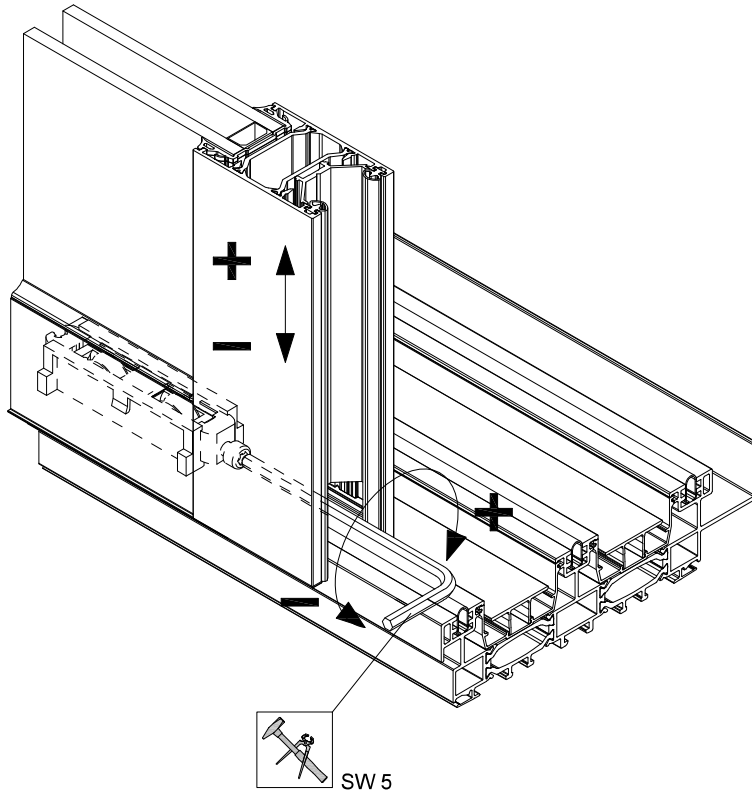
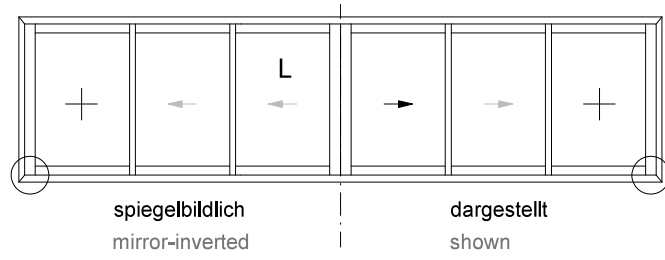
dargestellt
shown



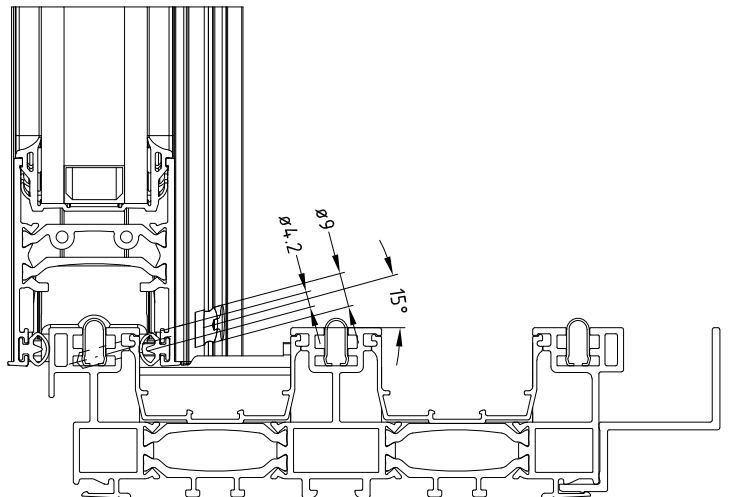
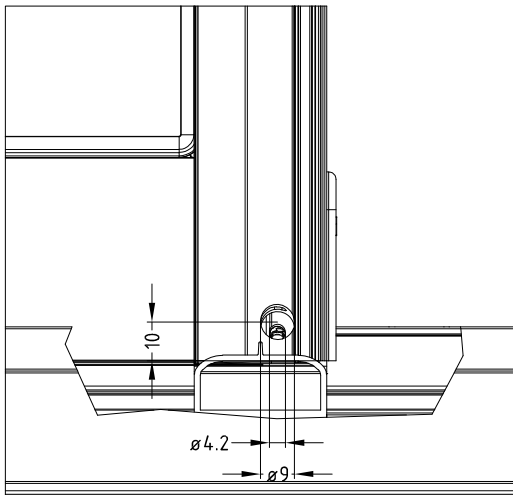
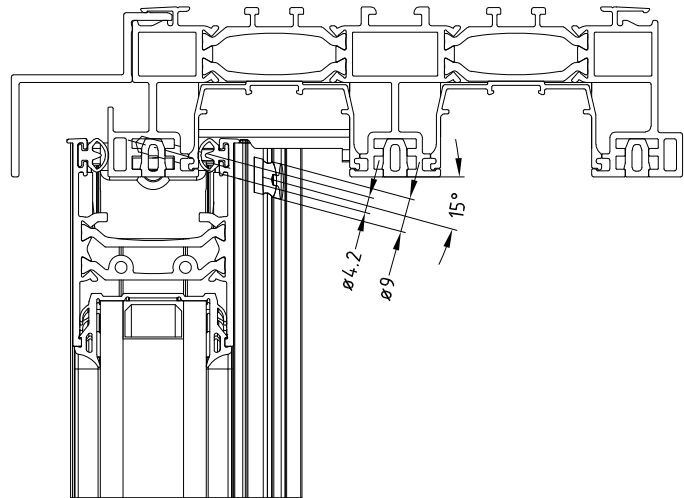
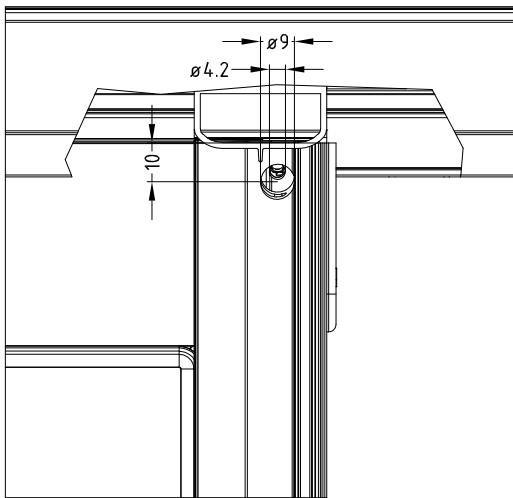
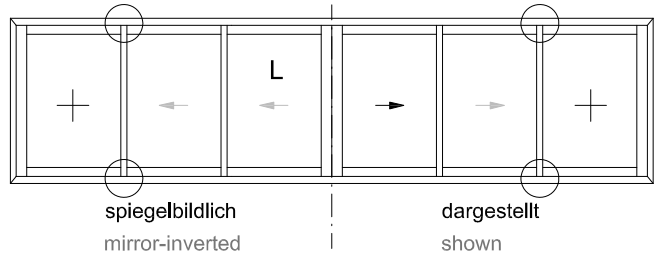
FLÜGELMONTAGE
 SASH ASSEMBLY



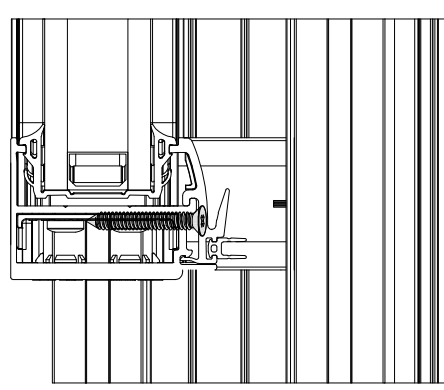
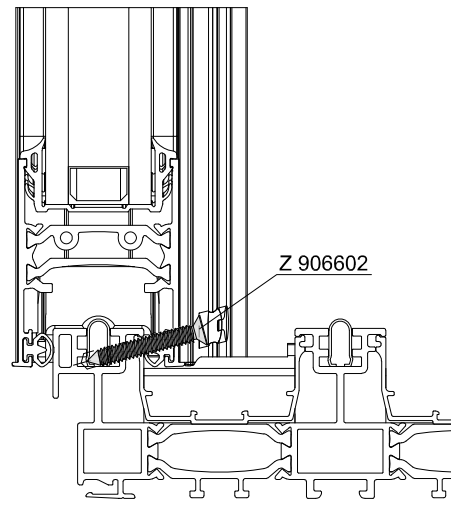
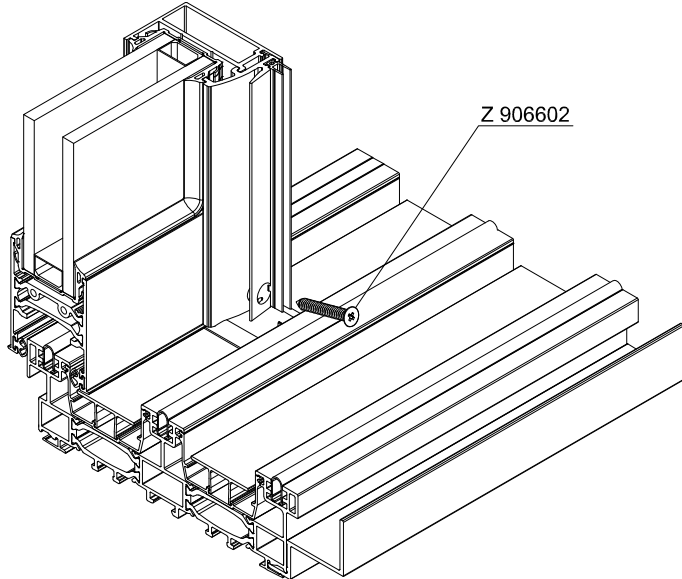
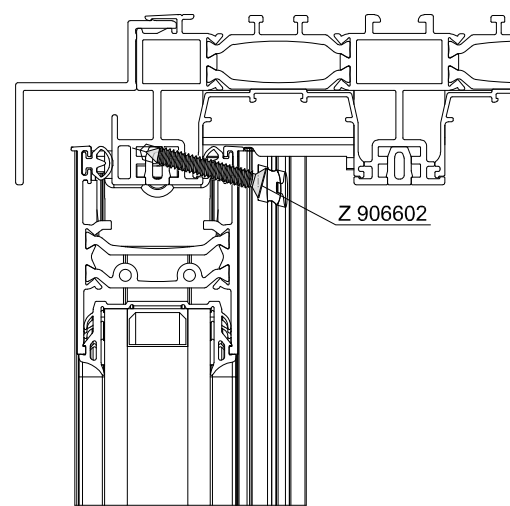
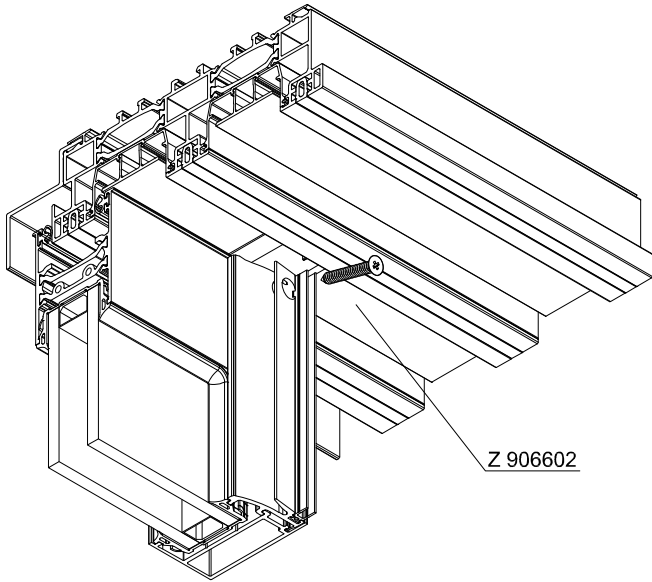
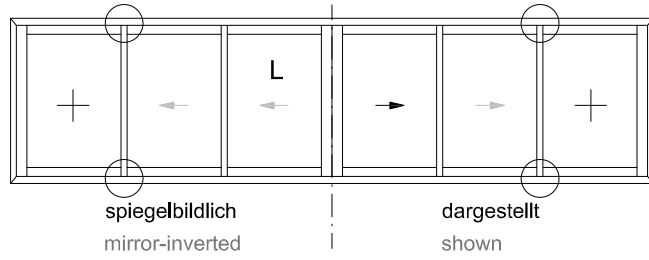
FLÜGELMONTAGE
SASH ASSEMBLY

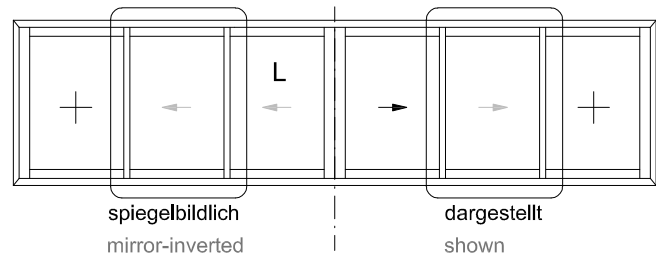


FLÜGELMONTAGE
 SASH ASSEMBLY



FLÜGELMONTAGE
SASH ASSEMBLY



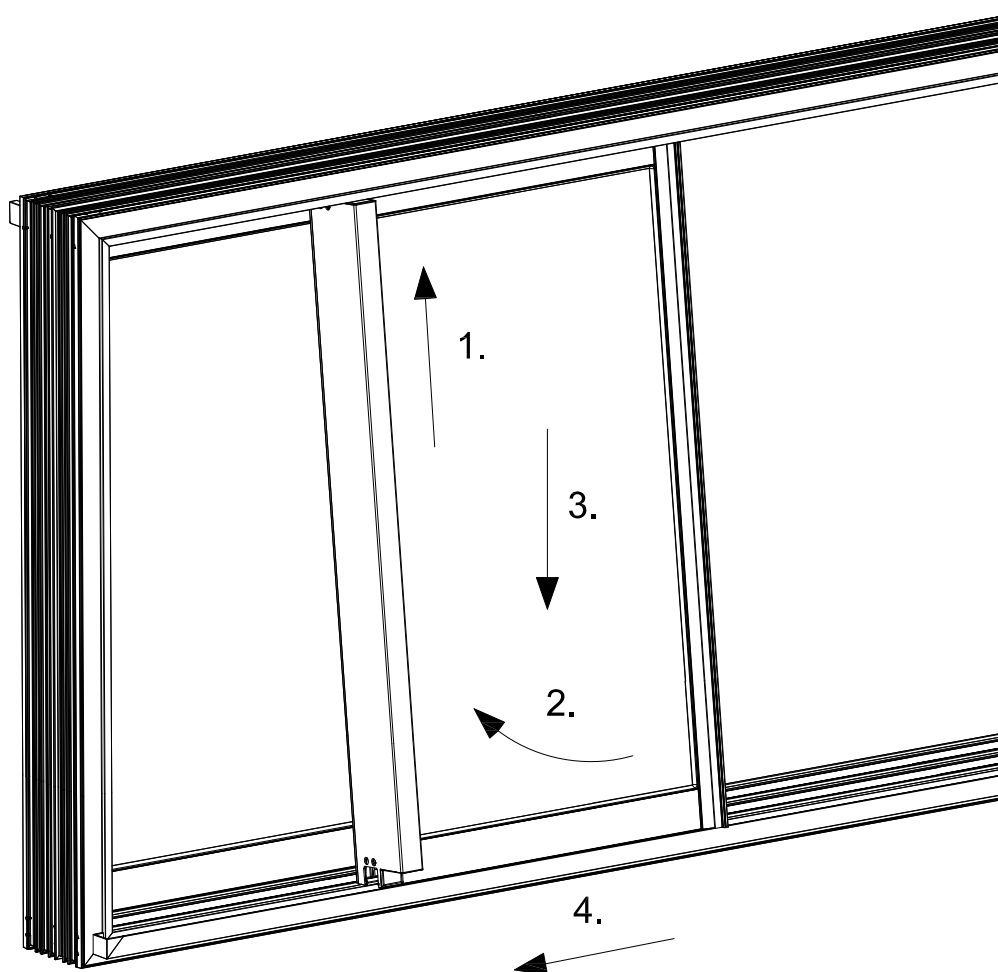


Bearbeitungsschritte

1. Mittleren Flügel montieren
(Siehe Kapitel Verarbeitung / Montage Flügel)
2. Mittleren Flügel einhängen

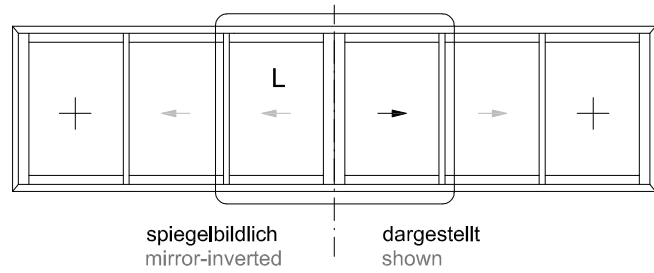
Processing steps

1. Assemble the middle sash
(see chapter processing / assembly sash)
2. Insert the middle sash



Ansicht von Innen
 Inside view

FLÜGELMONTAGE
SASH ASSEMBLY

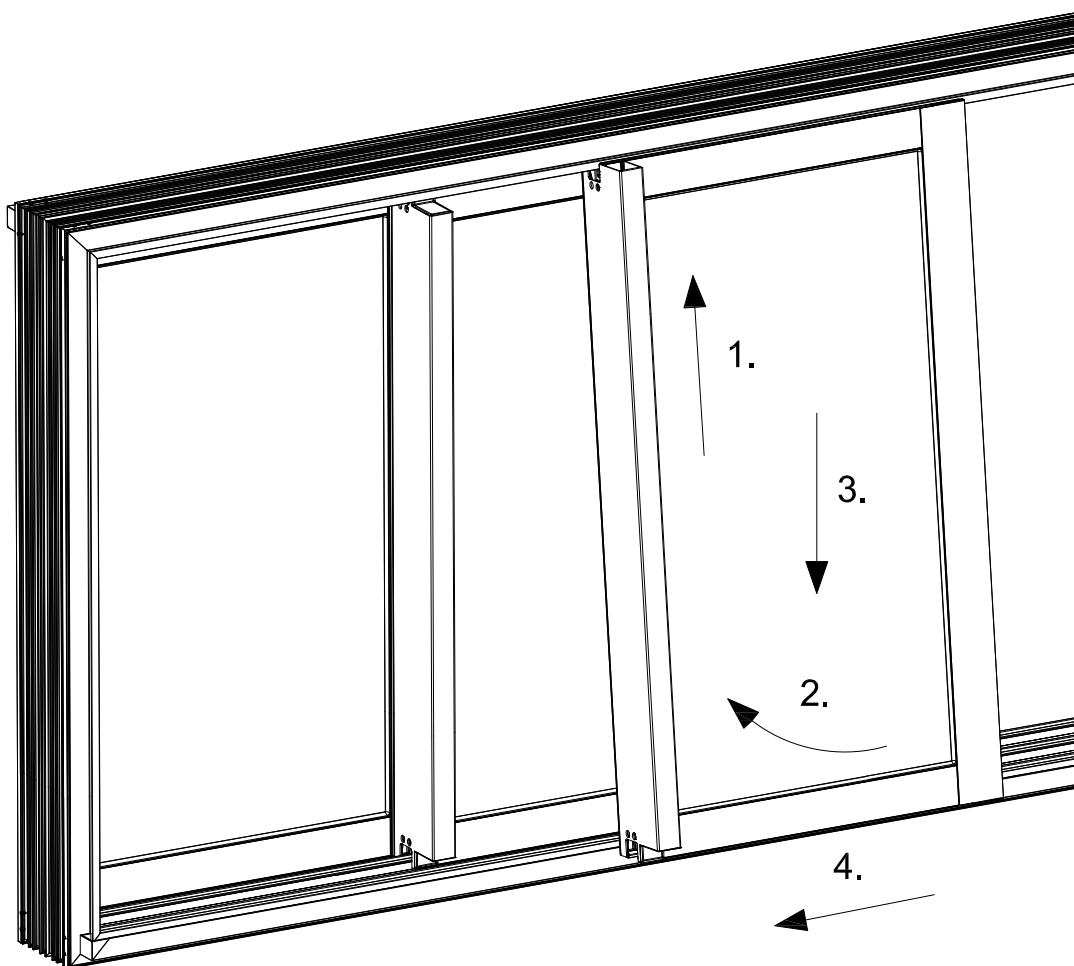


Bearbeitungsschritte

1. Inneren Flügel montieren (Siehe Kapitel Verarbeitung und Montage Flügel)
2. Inneren Flügel einhängen

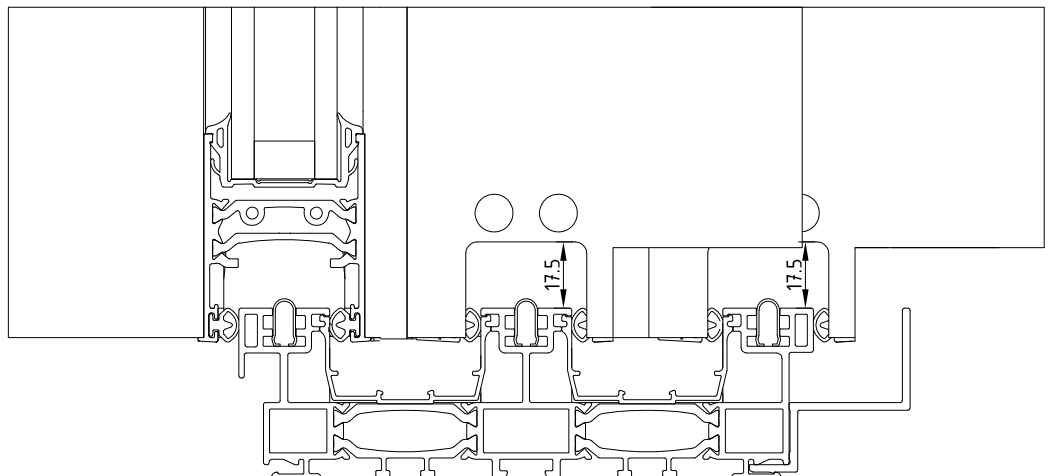
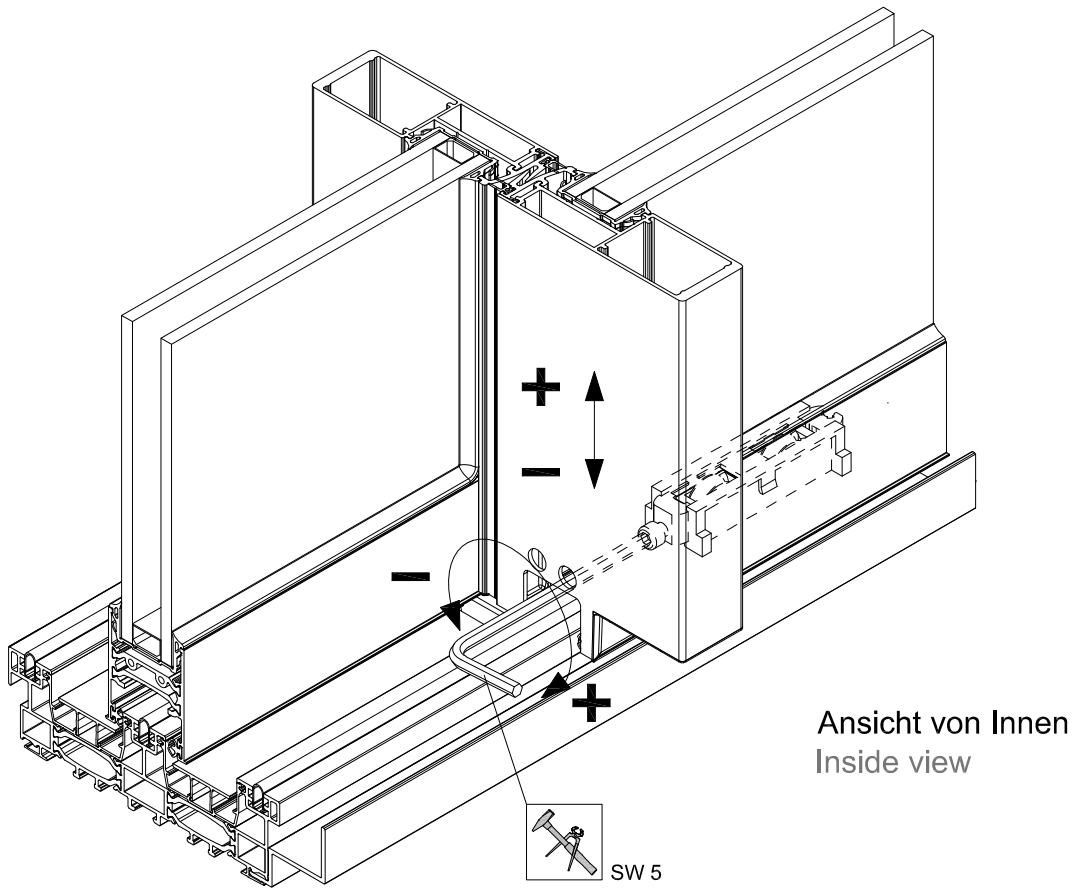
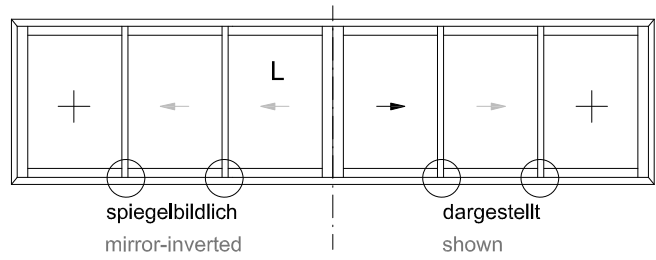
Processing steps

1. Assemble the inner sash (see chapter processing / assembly sash)
2. Insert the inner sash

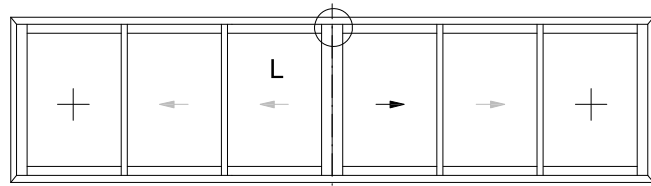


Ansicht von Innen
Inside view

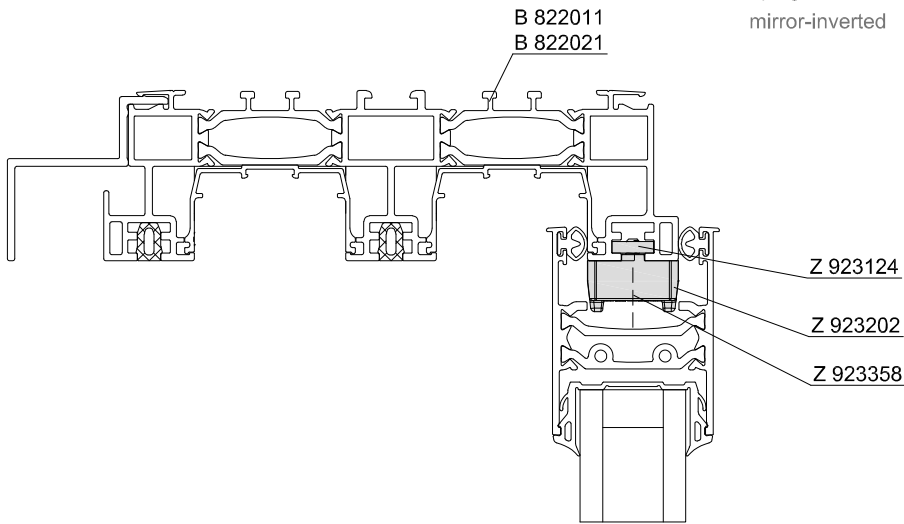
FLÜGELMONTAGE
 SASH ASSEMBLY



FLÜGELMONTAGE
 SASH ASSEMBLY

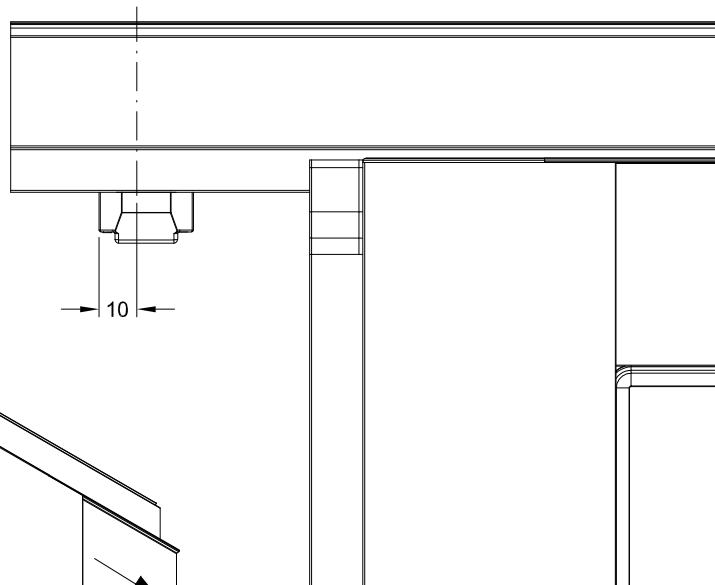


spiegelbildlich | dargestellt
 mirror-inverted | shown

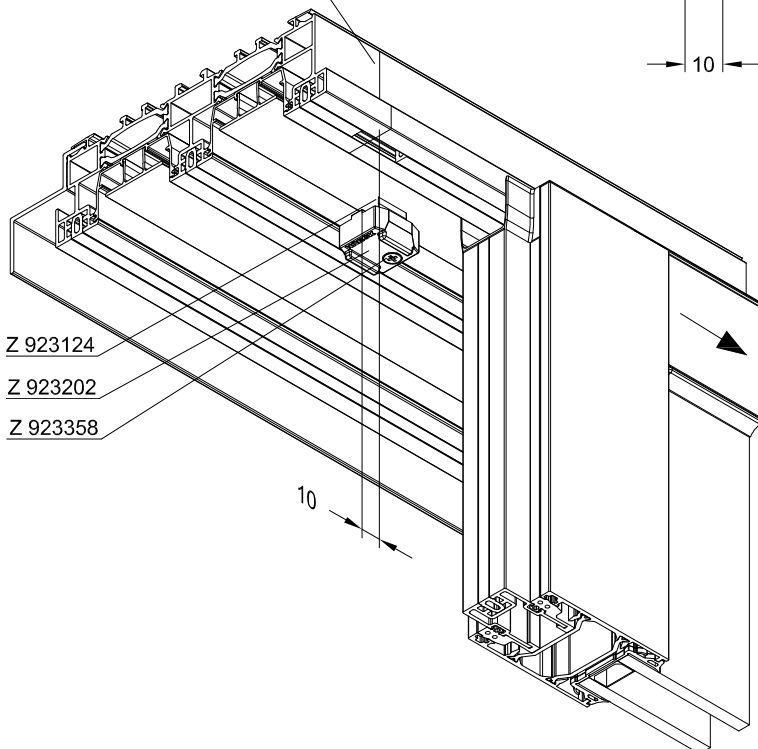


Ansicht von Innen
 Inside view

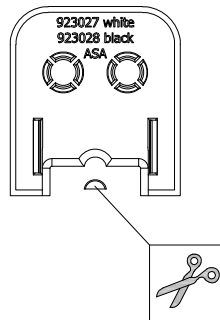
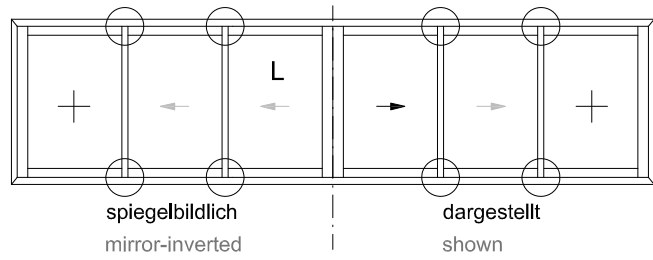
Rahmenmitte
 Center frame



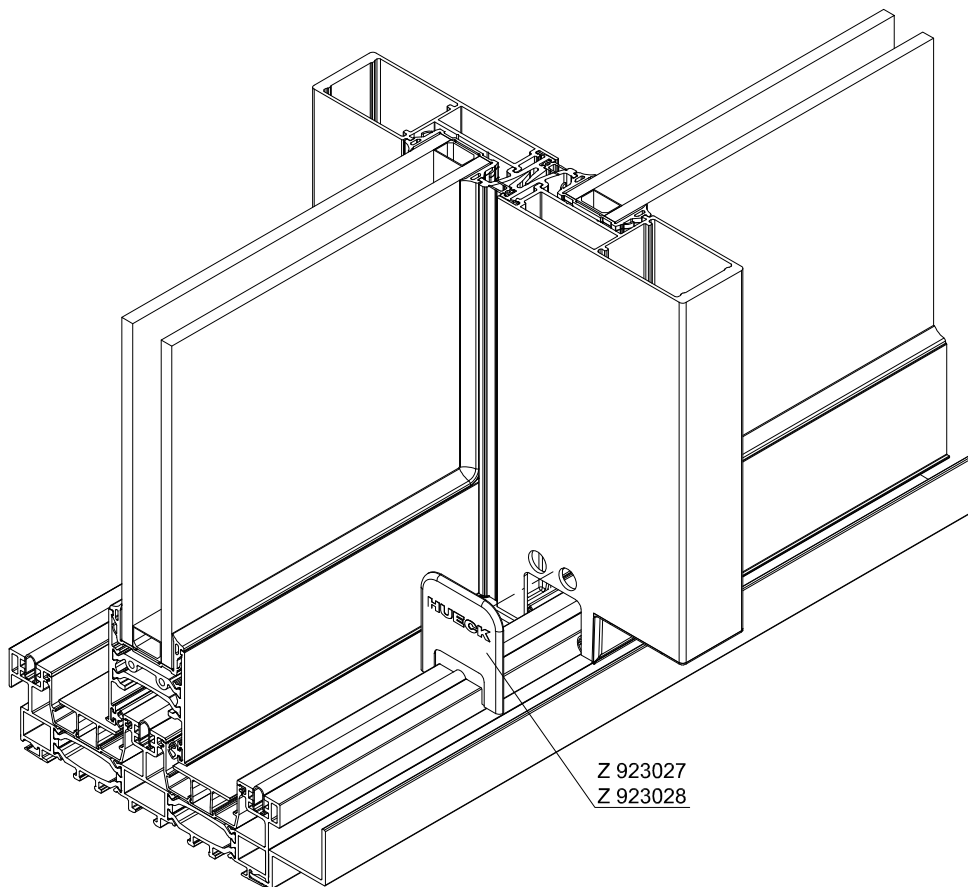
Rahmenmitte
 Center frame



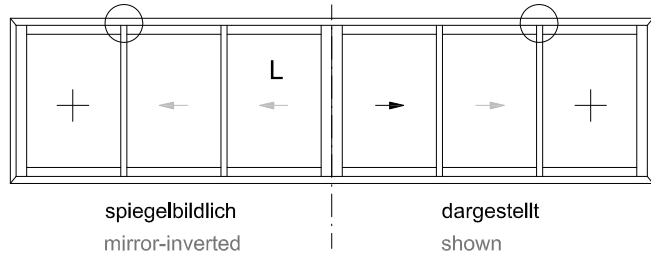
FLÜGELMONTAGE
 SASH ASSEMBLY



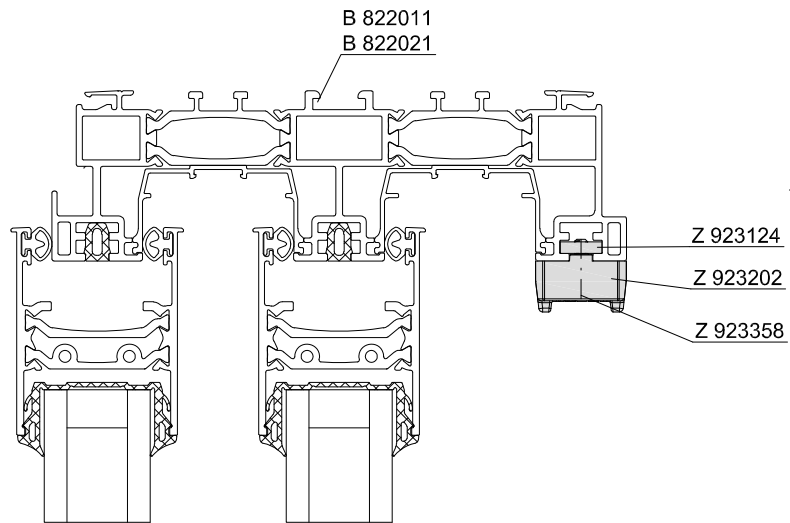
Nur unten
Only below



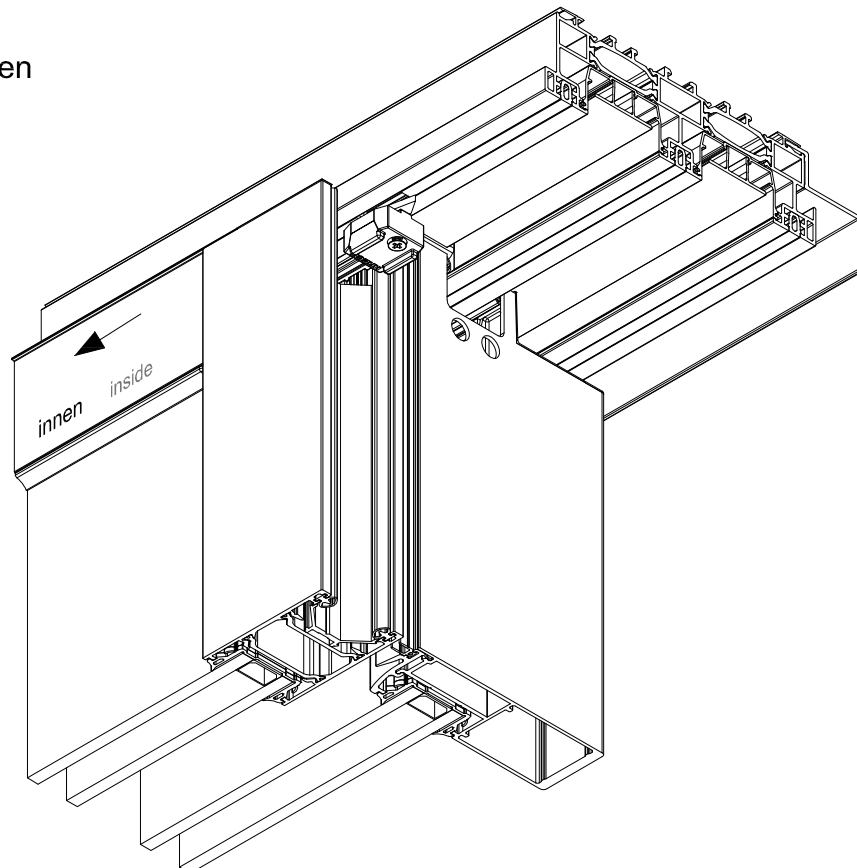
FLÜGELMONTAGE
SASH ASSEMBLY



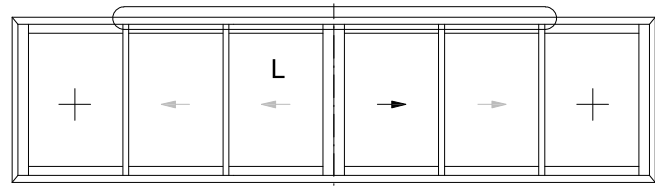
Offen
Open



Ansicht von Innen
Inside view



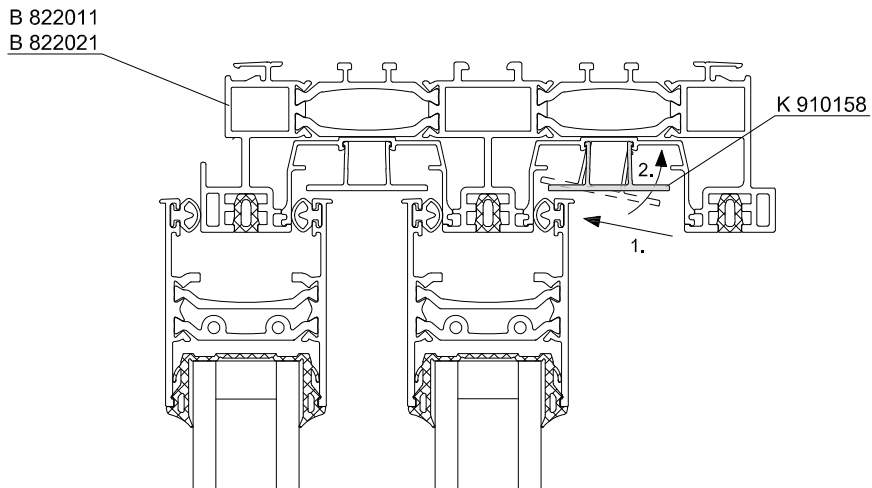
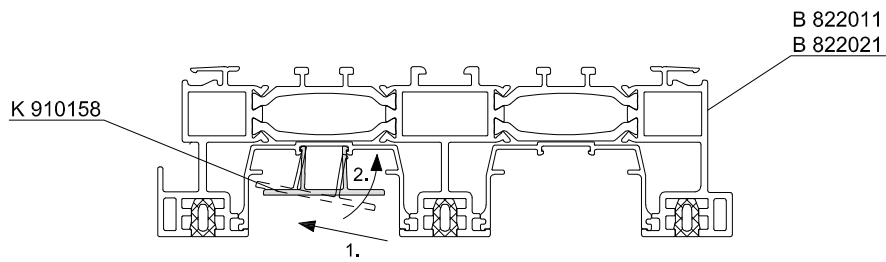
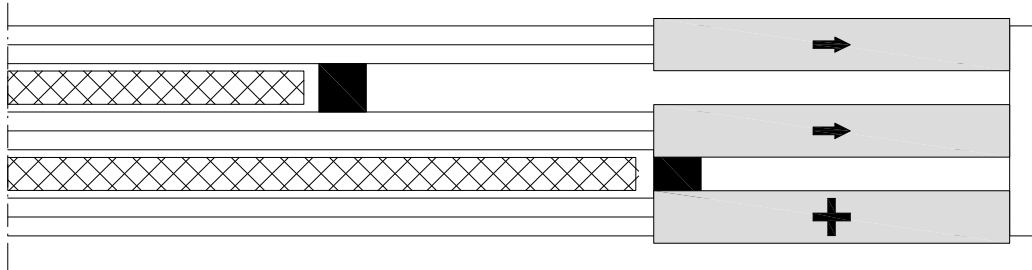
RAHMENMONTAGE
 FRAME ASSEMBLY



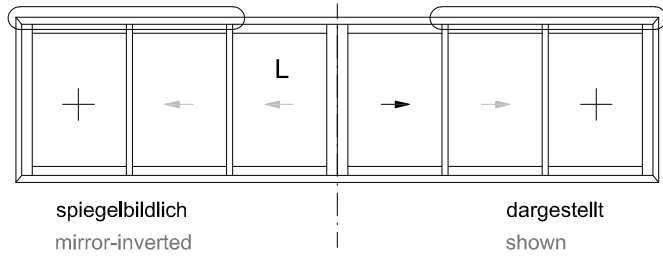
spiegelbildlich
 mirror-inverted

dargestellt
 shown

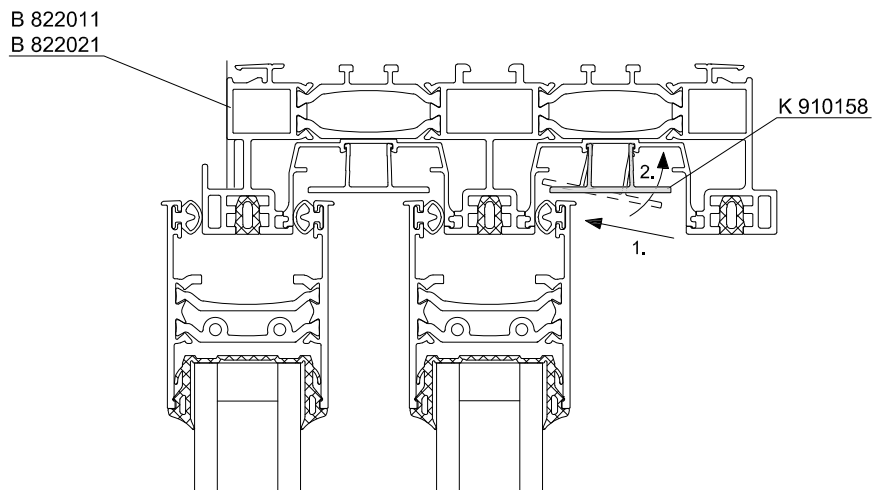
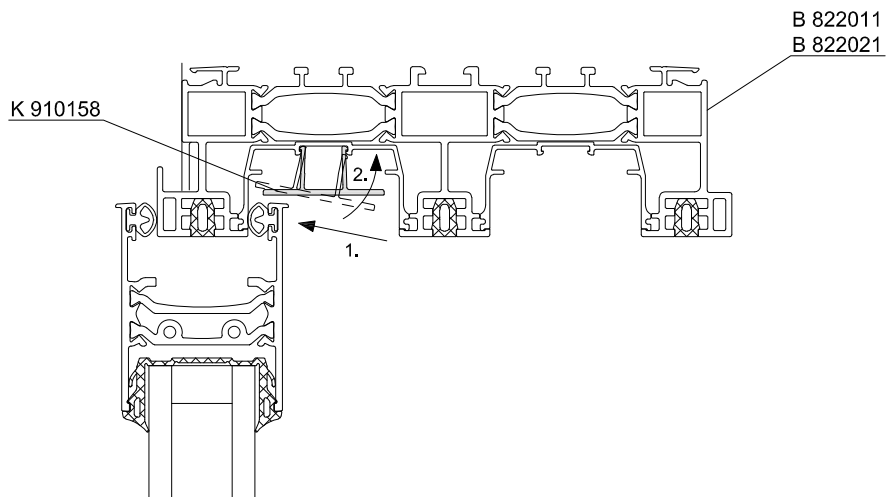
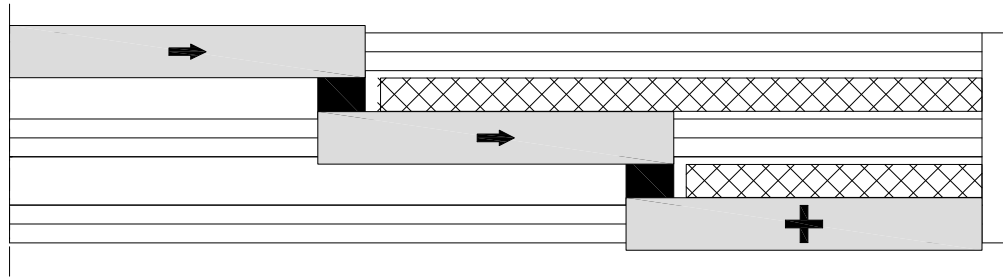
Optional
 Optionally



RAHMENMONTAGE
 FRAME ASSEMBLY



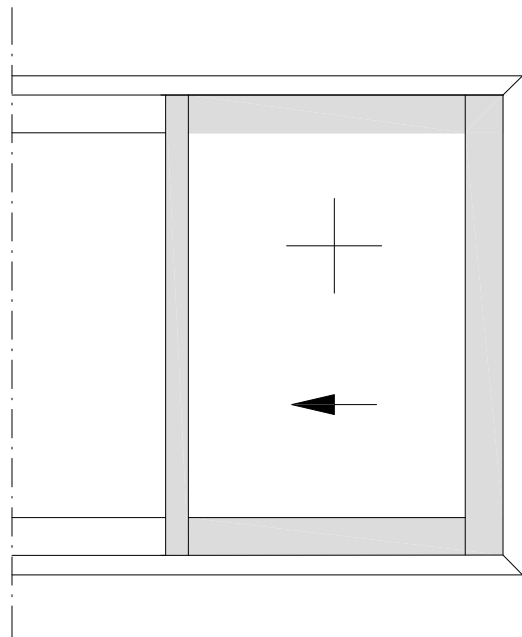
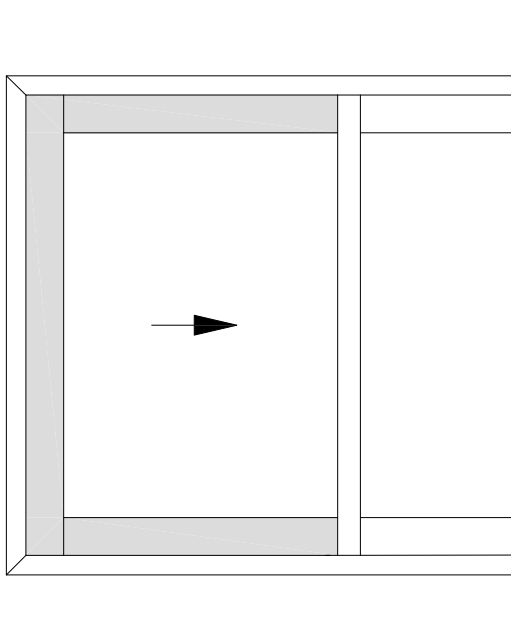
Optional
 Optionally



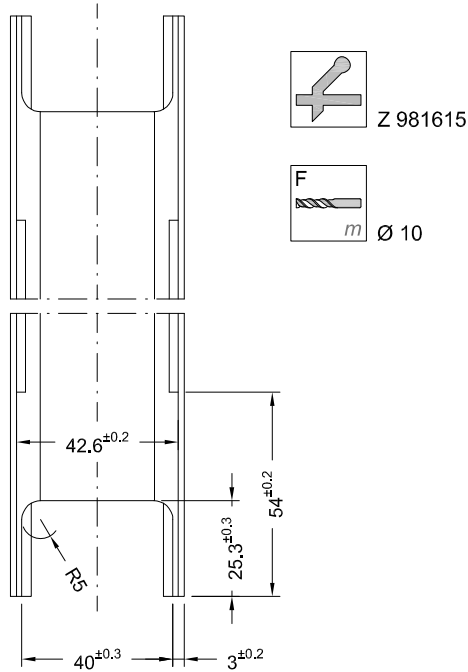


Innerer Flügel
 Internal sash

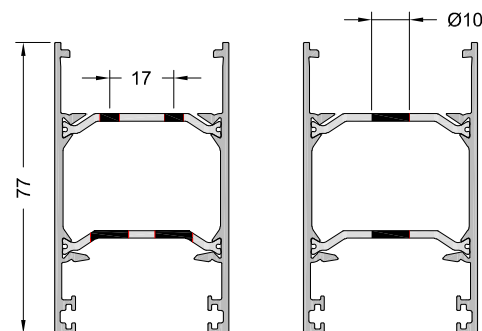
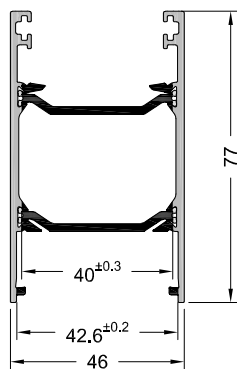
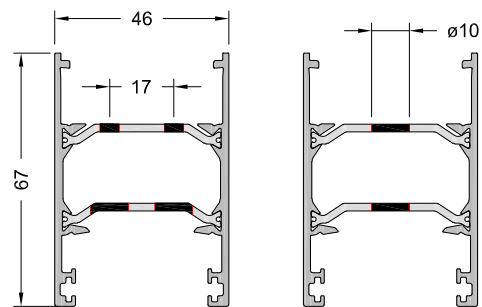
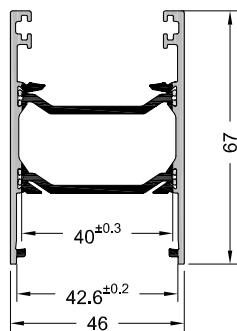
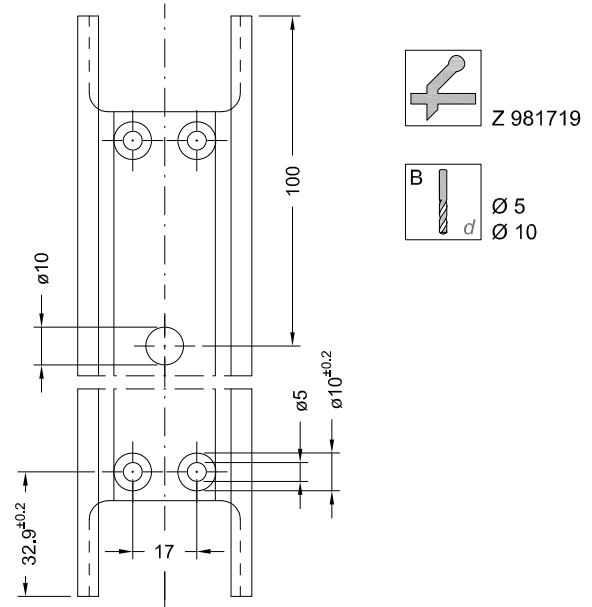
Äußerer Flügel
 External sash



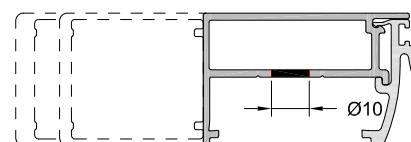
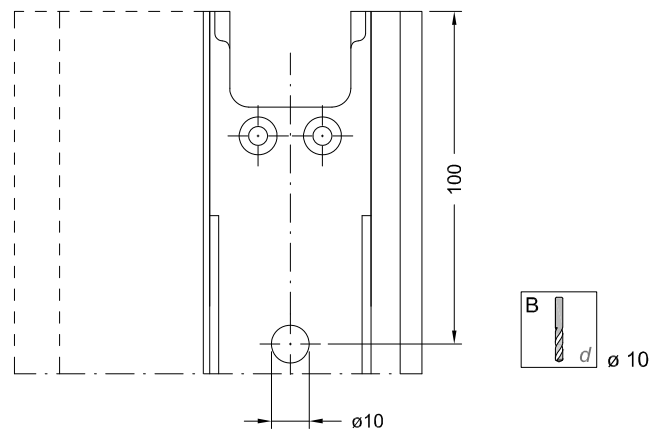
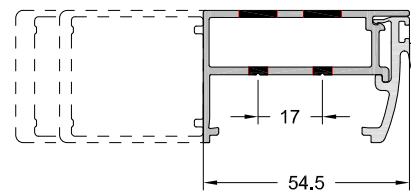
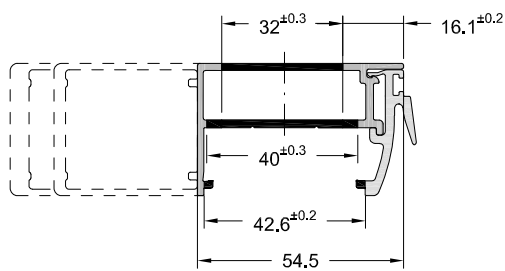
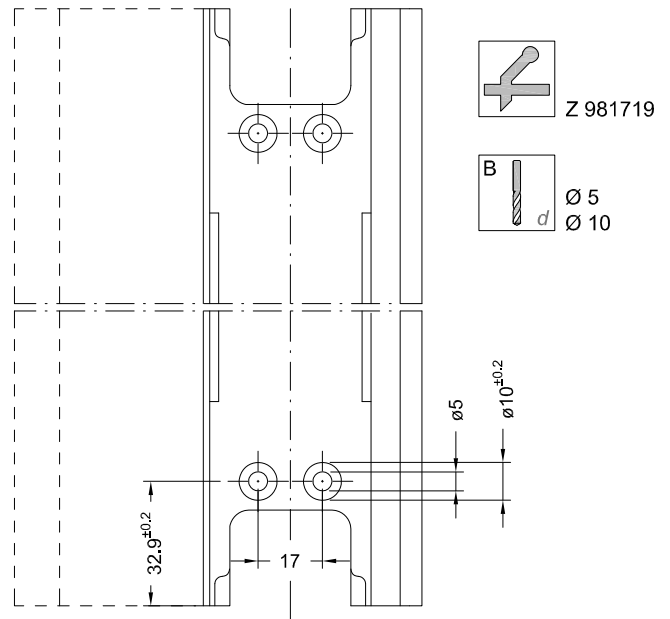
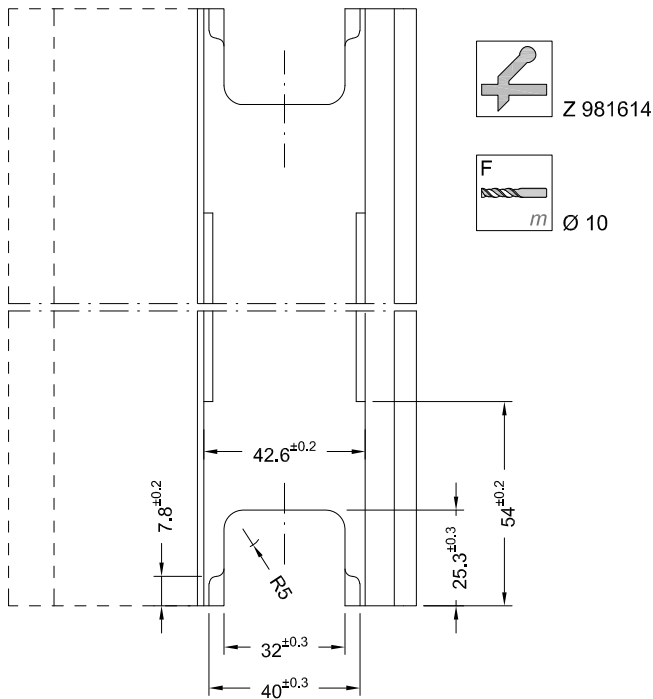
B 822200 + B 822210



B 822200 + B 822210

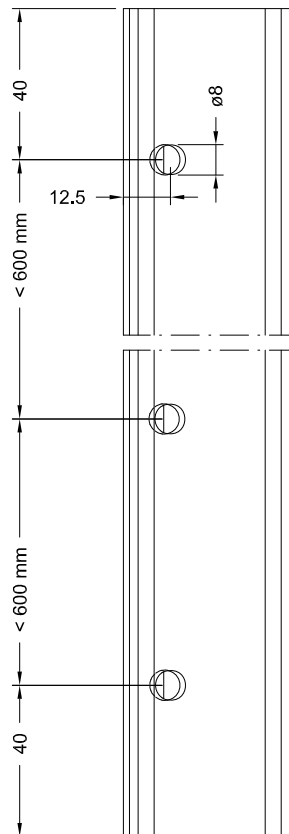
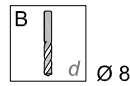
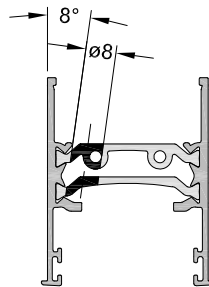


P 822600 + P 822601 + P 822602



Bearbeitung Flügelbelüftung unten
Processing for flush handle

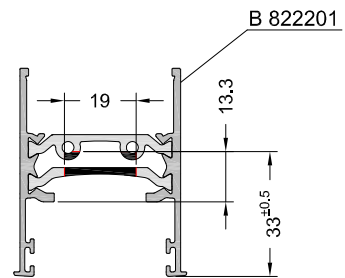
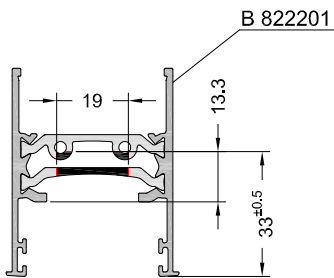
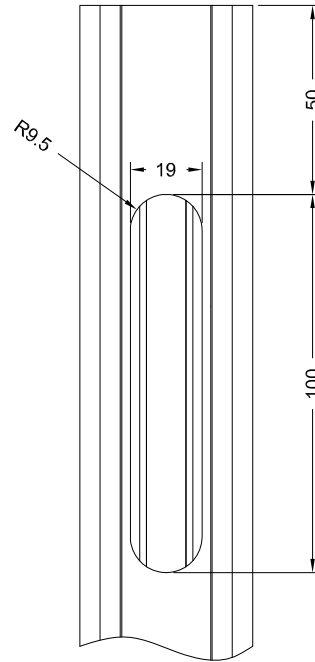
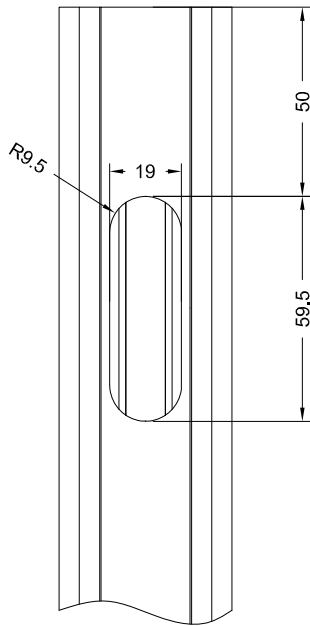
B 822201



Bearbeitung für Laufwagen Z 923234 (60 kg)
 Processing for rollers Z 923234 (60 kg)

Bearbeitung für Laufwagen Z 923235 (120 kg)
 Laufwagen Z 923236 (200 kg)

Processing for rollers Z 923235 (120 kg)
 rollers Z 923236 (200 kg)

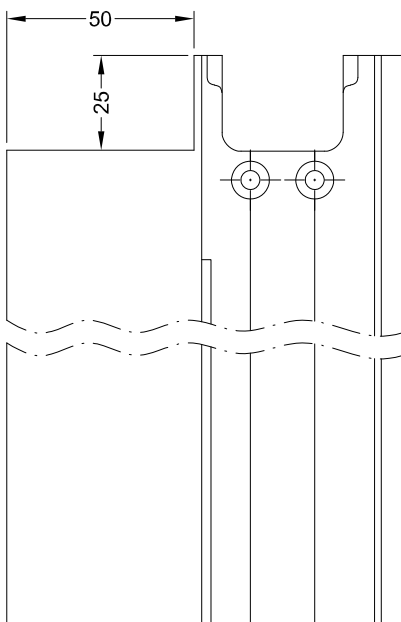


Ausnehmung nur bei Verwendung
vom Zusatzprofil P 496456 oder
Rahmenprofil B 822012, B 822013, B 822022
oder B 822023!

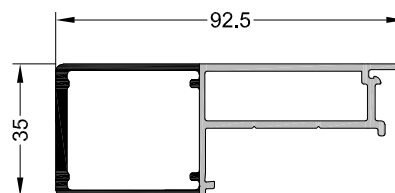
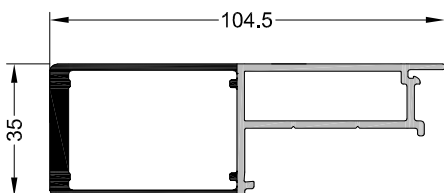
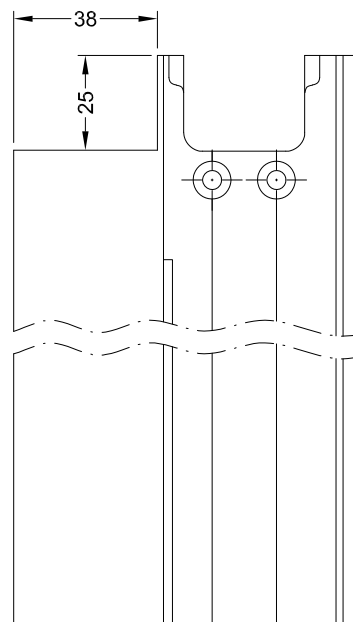
Recess only when using the
additional profile P 496456
or frame B 822012, B 822013, B 822022
or B 822023!!



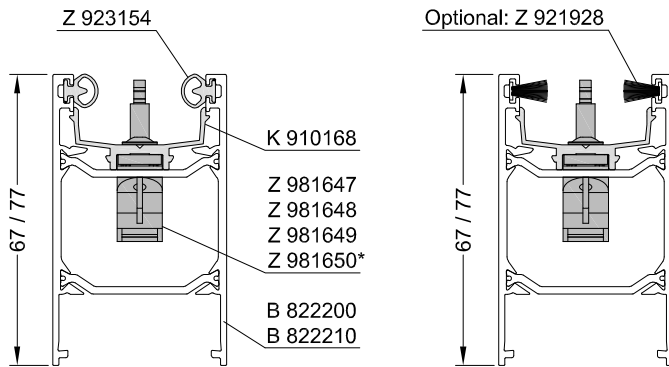
P 821602



P 821601



FLÜGELMONTAGE
 SASH ASSEMBLY



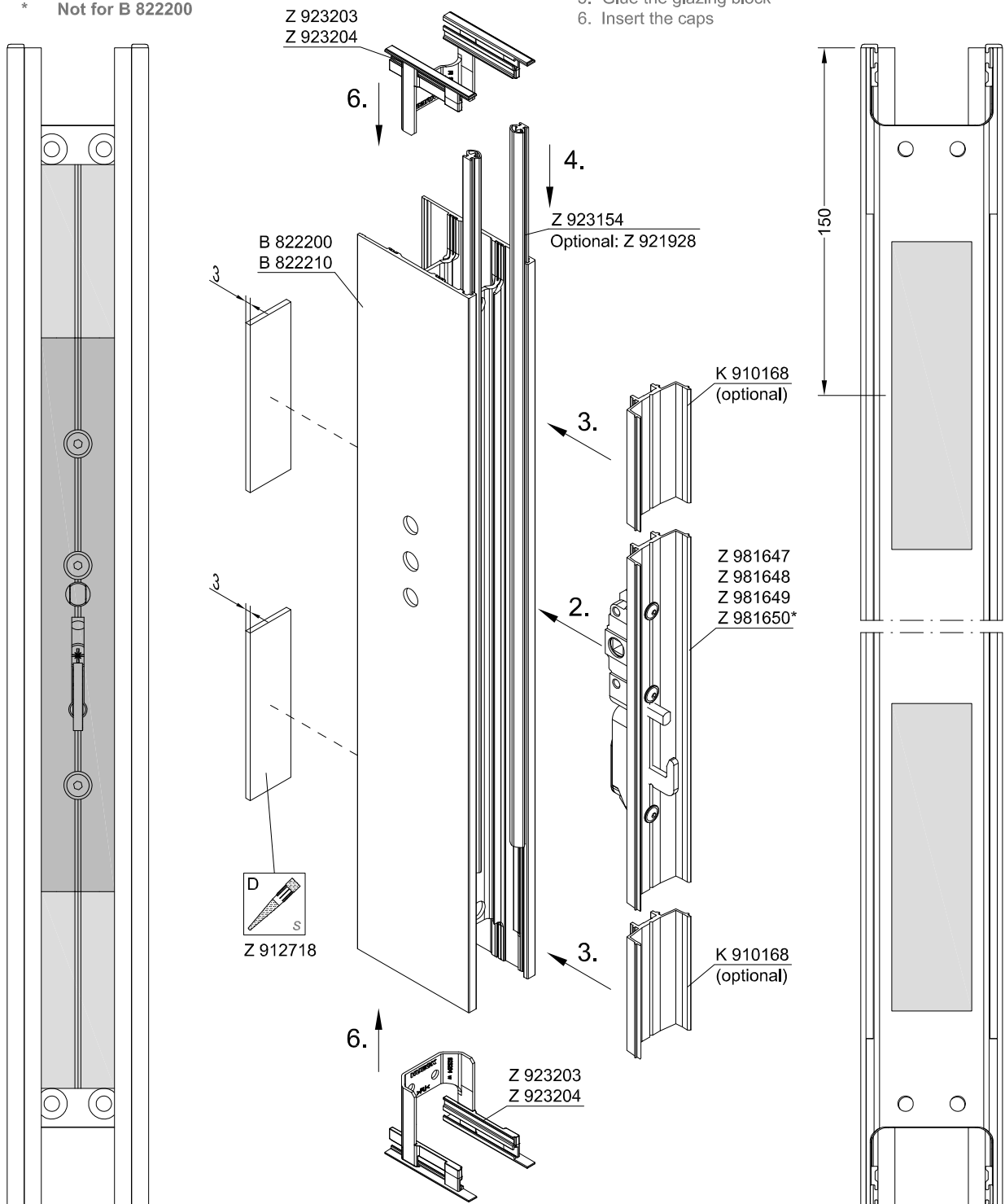
* Nicht bei B 822200
 * Not for B 822200

Bearbeitungsschritte

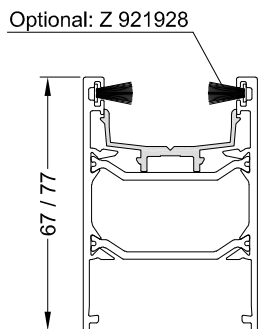
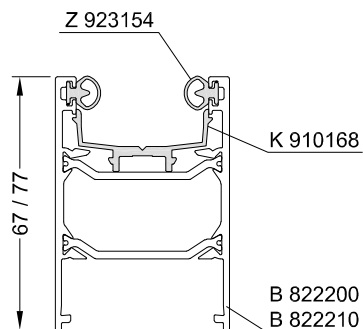
1. Profil bearbeiten (siehe Kapitel Flügelbearbeitung)
2. Schloss einklippen (keine Schlossausfräsung bei festem Flügel Schema A, C, E und L)
3. K 910168 einsetzen (optional)
4. Dichtungen beidseitig einziehen
5. Verglasungsklotz ankleben
6. Endkappen einsetzen

Processing steps

1. Machining the profiles (see chapter sash processing)
2. Install the lock (no lock cut-out with fixed wing scheme A, C, E and L)
3. Insert K 910168 (optional)
4. Insert gasket on both side
5. Glue the glazing block
6. Insert the caps



FLÜGELMONTAGE
SASH ASSEMBLY

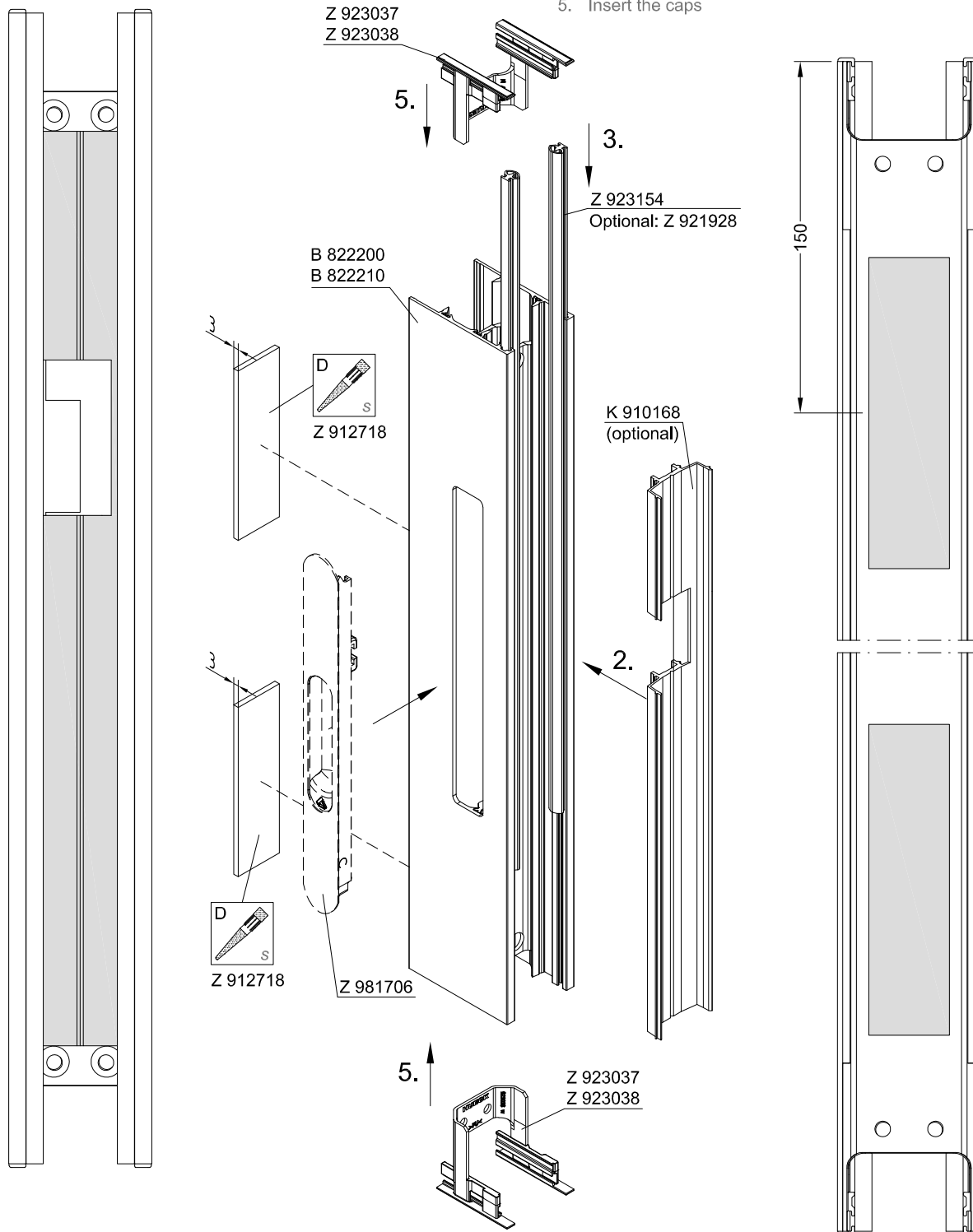


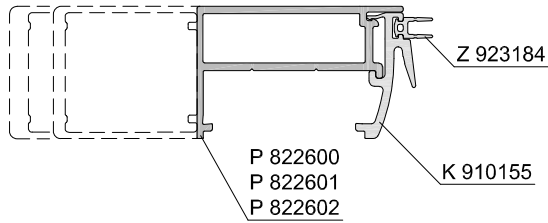
Bearbeitungsschritte

1. Profile P 822200 und K 910168 (optional) bearbeiten (siehe Kapitel Flügelbearbeitung, keine Fräsung für Griffmuschel bei festem Flügel Schema A,C,E und L)
2. K 910168 einsetzen (optional)
3. Dichtungen beidseitig einziehen
4. Verglasungsklotz ankleben
5. Endkappen einsetzen

Processing steps

1. Machining the profiles P 822200 and K 910168 (optional) (see chapter sash processing, no milling for grip with fixed wing scheme A, C, E and L)
2. Insert K 910168 (optional)
3. Insert gasket on both side
4. Glue the glazing block
5. Insert the caps



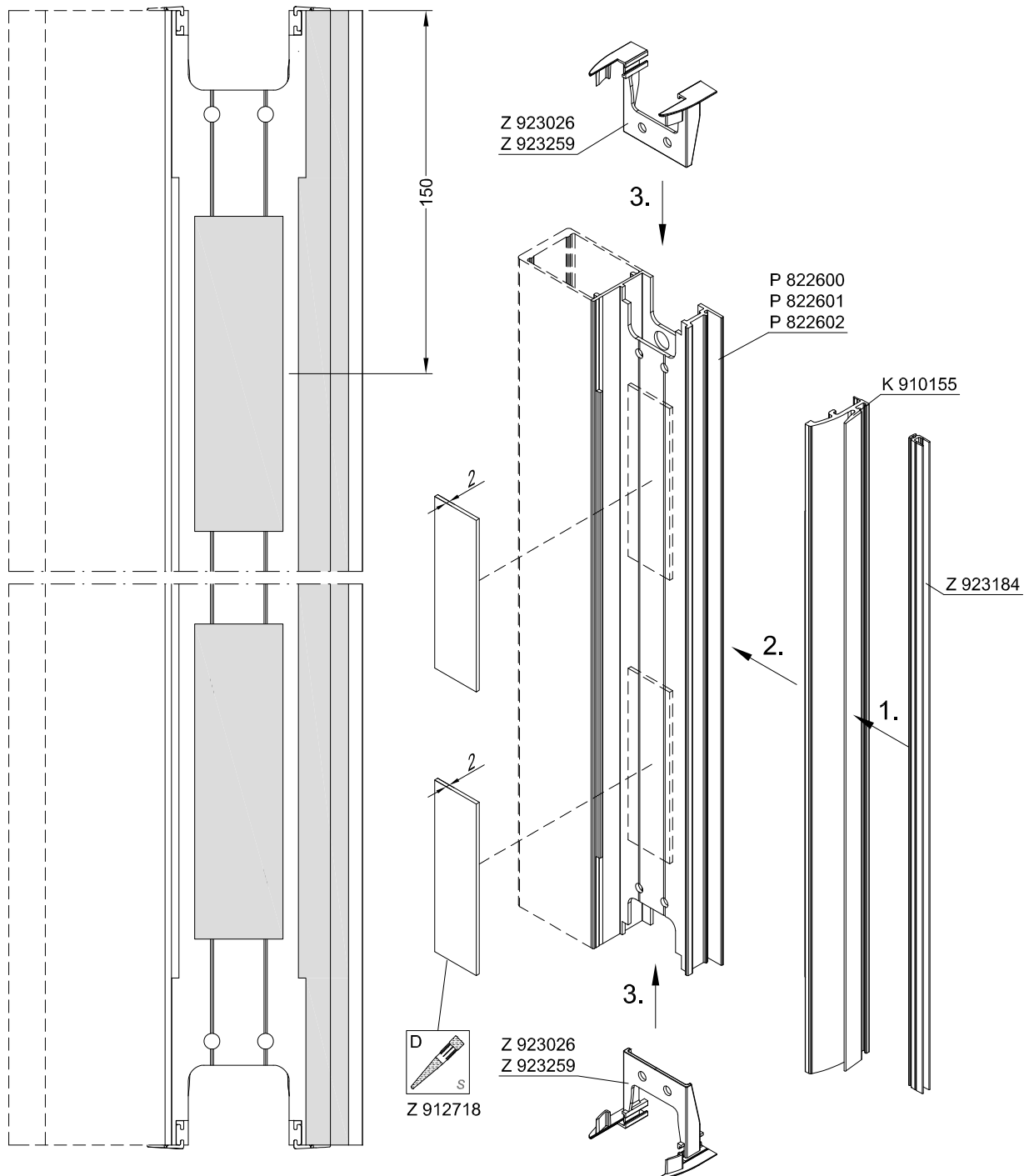


Bearbeitungsschritte

1. Profil bearbeiten (siehe Kapitel Flügelbearbeitung)
2. Dichtung Z 923184 einziehen
3. Verglasungsklotz ankleben
4. Endkappen einsetzen

Processing steps

1. Machining the profiles (see chapter sash processing)
2. Insert gasket Z 923184
3. Glue the glazing block
4. Insert the caps



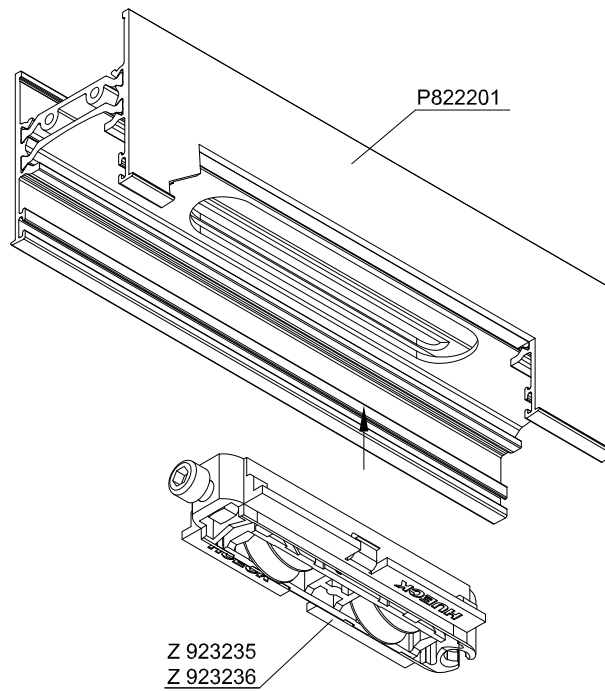
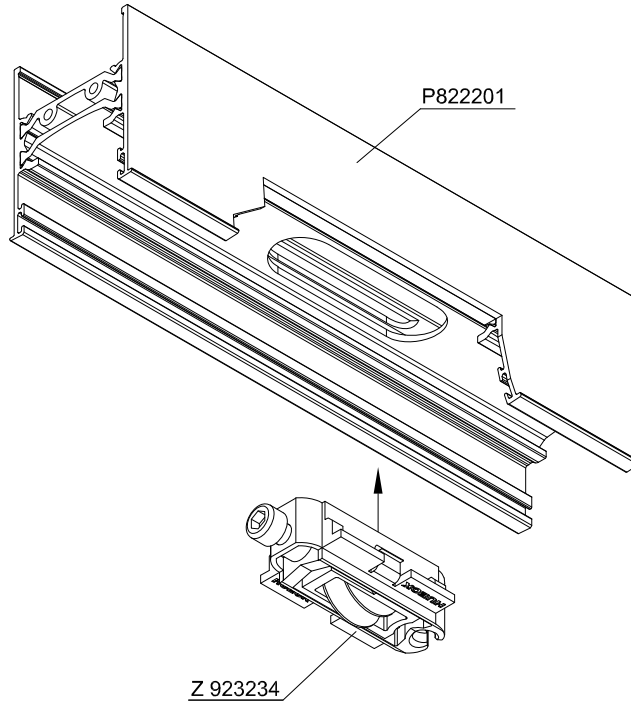
FLÜGELMONTAGE
SASH ASSEMBLY

Bearbeitungsschritte für

1. Laufwagen einklipsen

Processing steps

1. Clip in the rollers

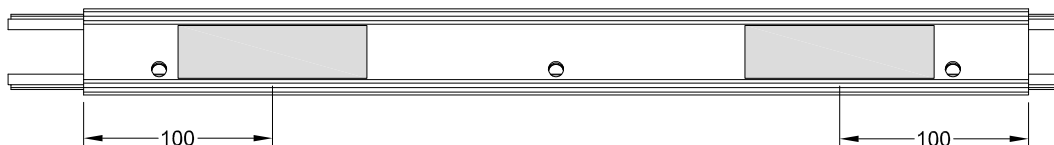
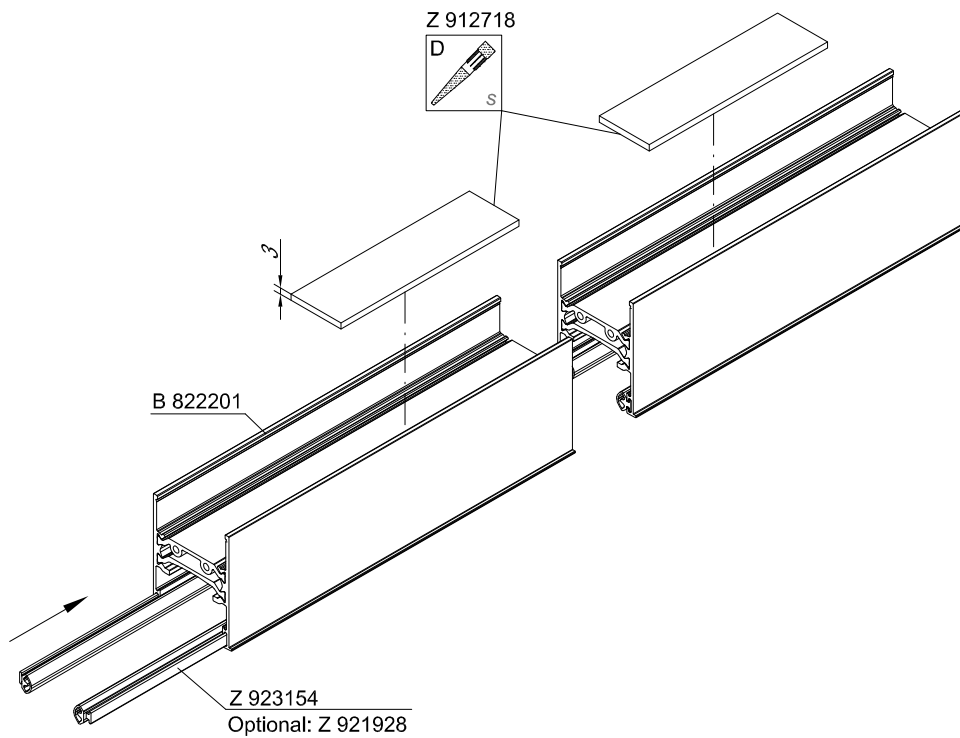
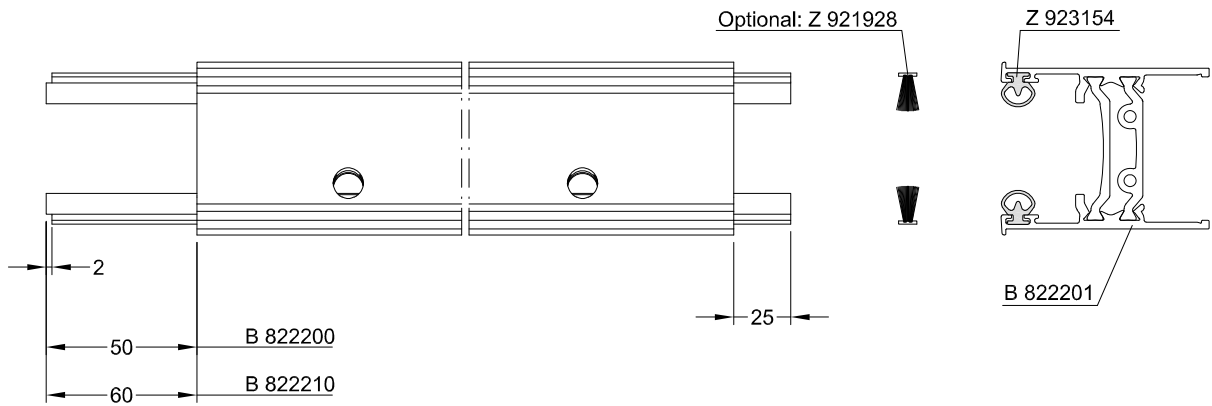


Bearbeitungsschritte

1. Dichtungen beidseitig einziehen
2. DichtungsfüÙe ausklinken
3. VerglasungsklöÙe aufkleben

Processing steps

1. Insert gaskets
2. Cut the gaskets
3. Glue the glazing blocks

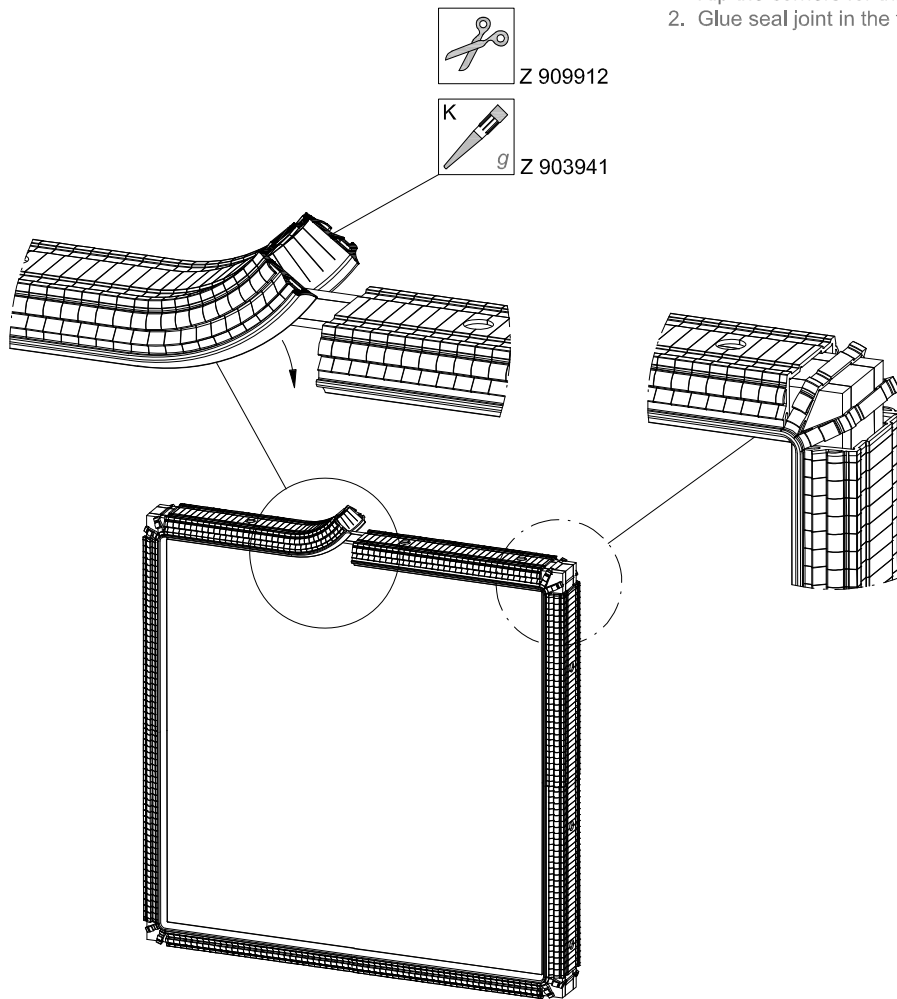


Bearbeitungsschritte

1. Oben mittig beginnend, die Dichtung umlaufend um das Glas ziehen.
Die Ecken hierfür an den Vorstanzungen aufreißen
2. Dichtungsstoß oben mittig verkleben

Processing steps

1. Starting at the top center, put on the gasket continuously to the glass.
Rip the corners for this at the pre-cuts
2. Glue seal joint in the top center



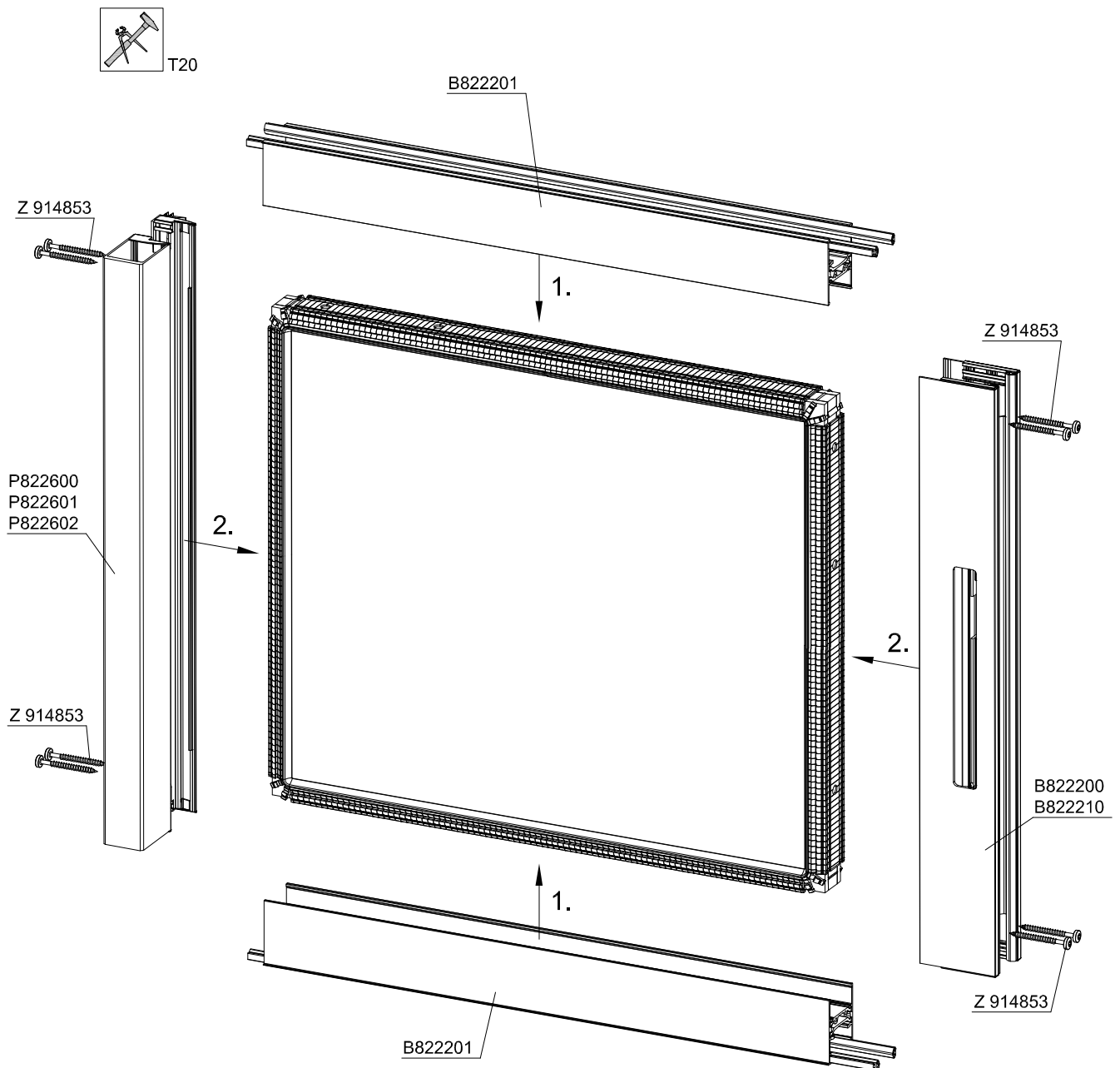
Füllungsdicke Filling thickness	Artikelnummer Article number
24 mm	Z 923298
26 mm	Z 923299
28 mm	Z 923300
30 mm	Z 923301
32 mm	Z 923302

Bearbeitungsschritte

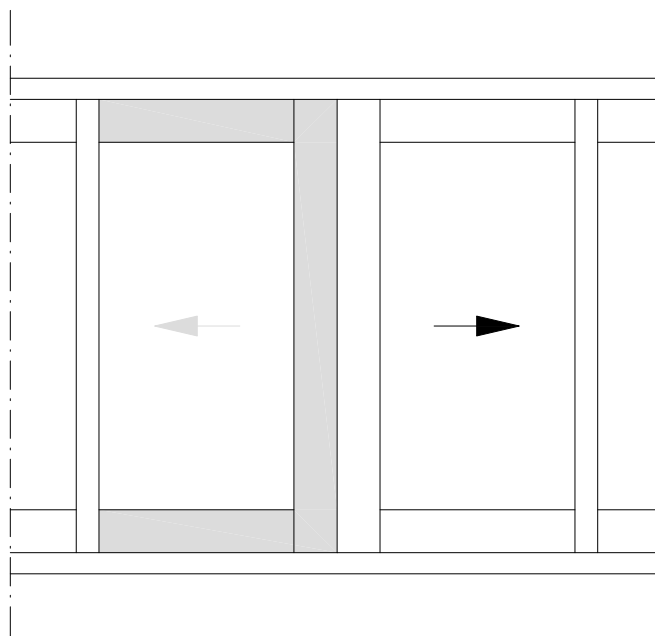
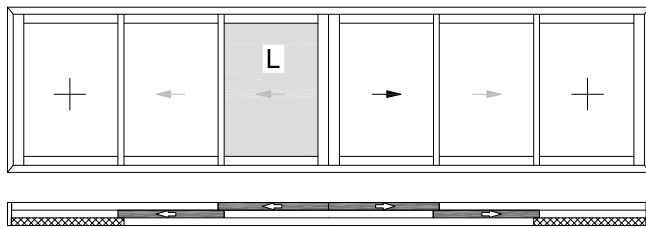
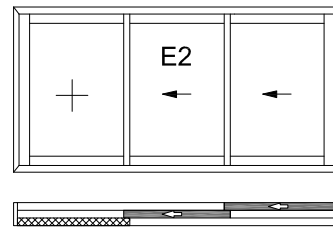
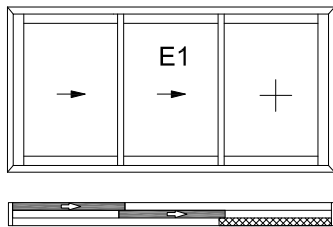
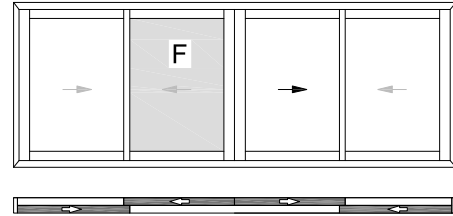
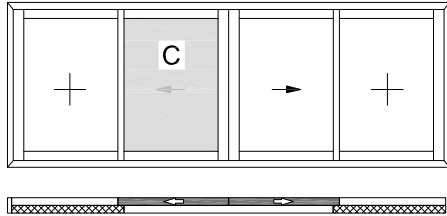
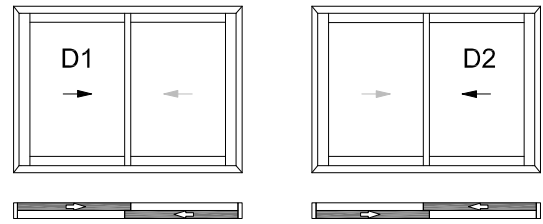
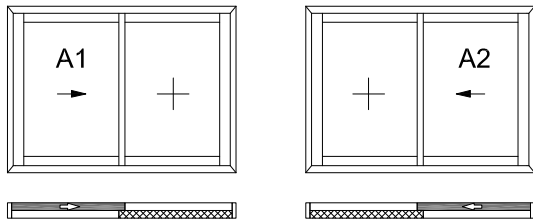
1. Profile aufstecken
2. Mit Z 914853 verschrauben

Processing steps

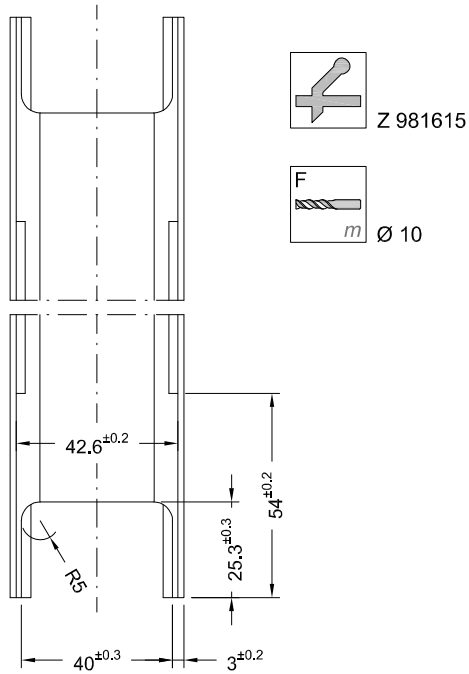
1. Plug profiles
2. Screw together with Z 914853



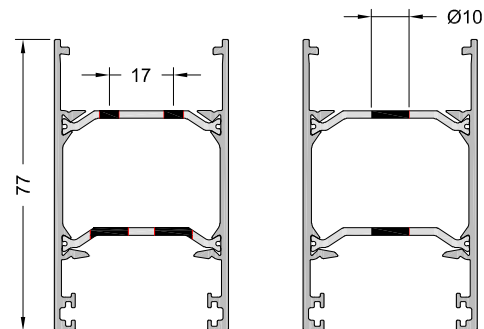
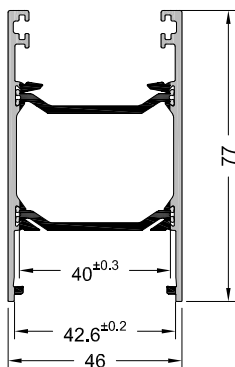
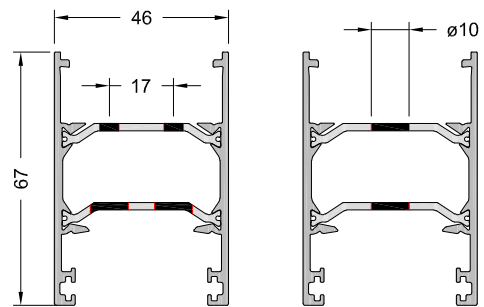
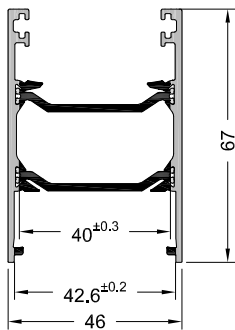
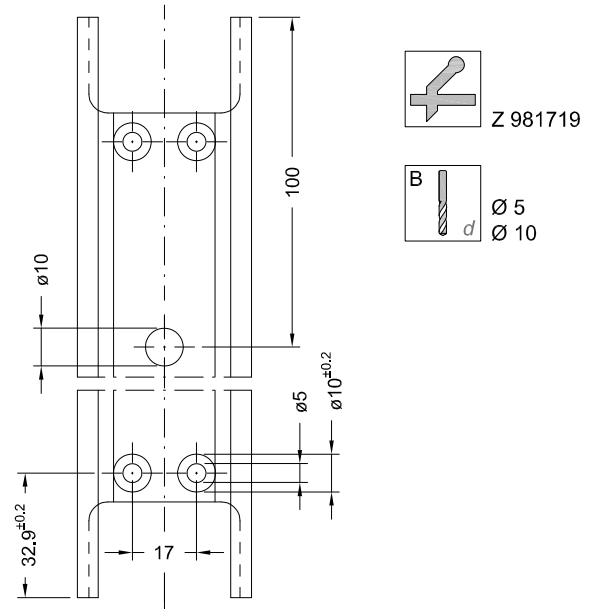
FLÜGELBEARBEITUNG
 SASH PROCESSING



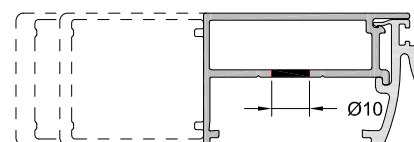
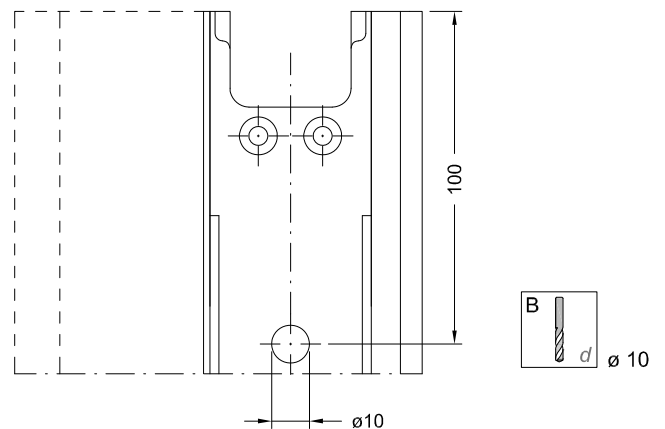
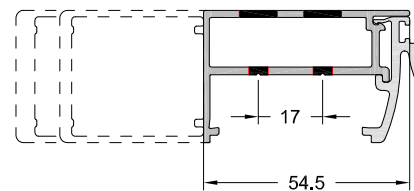
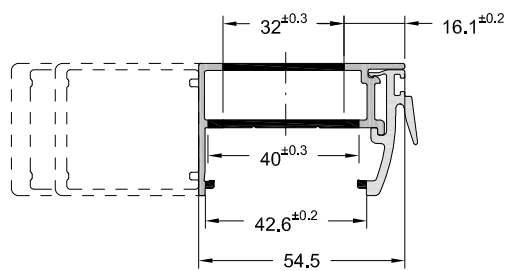
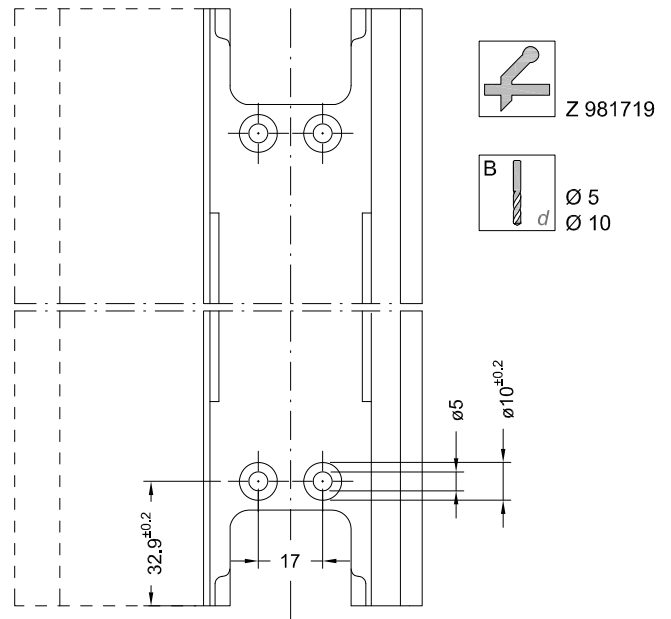
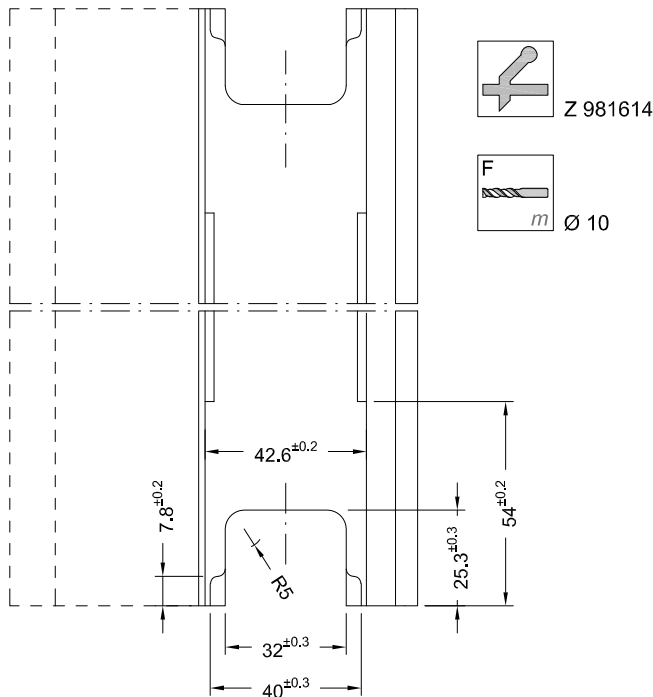
B 82200 + B 82210



B 82200 + B 82210

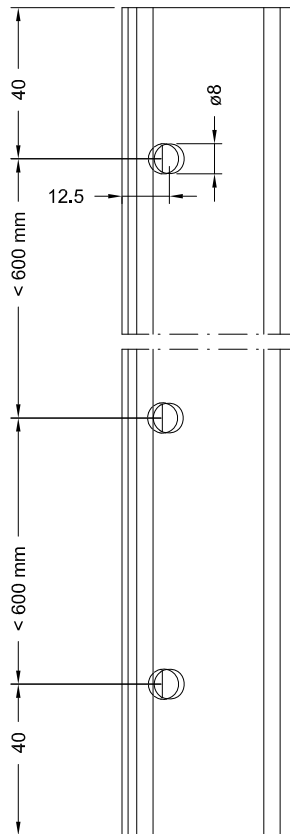
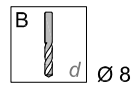
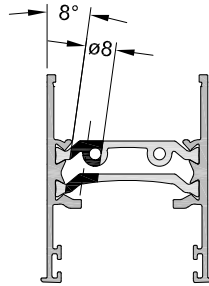


P 822600 + P 822601 + P 822602



Bearbeitung Flügelbelüftung unten
Processing for flush handle

B 822201

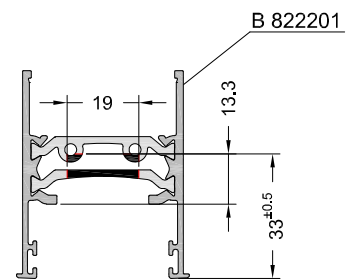
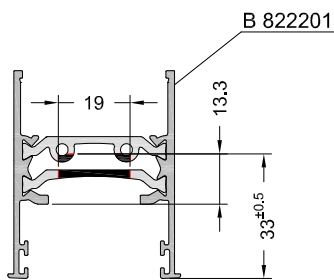
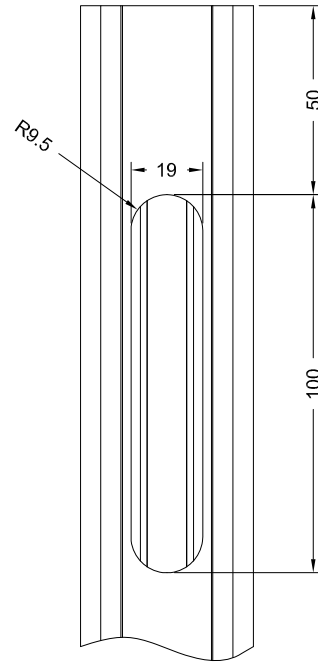
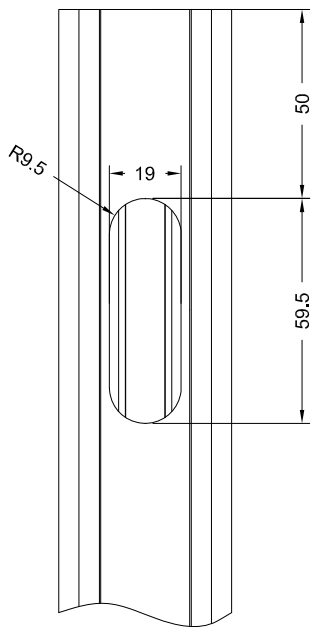


FLÜGELBEARBEITUNG
 SASH PROCESSING

Bearbeitung für Laufwagen Z 923234 (60 kg)
 Processing for rollers Z 923234 (60 kg)

Bearbeitung für Laufwagen Z 923235 (120 kg)
 Laufwagen Z 923236 (200 kg)

Processing for rollers Z 923235 (120 kg)
 rollers Z 923236 (200 kg)

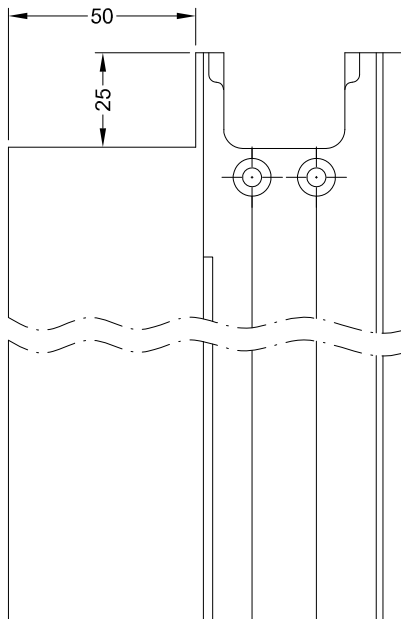


Ausnehmung nur bei Verwendung
vom Zusatzprofil P 496456 oder
Rahmenprofil B 822012, B 822013, B 822022
oder B 822023!

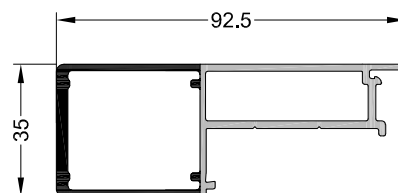
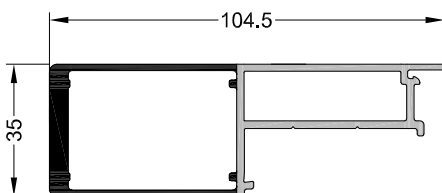
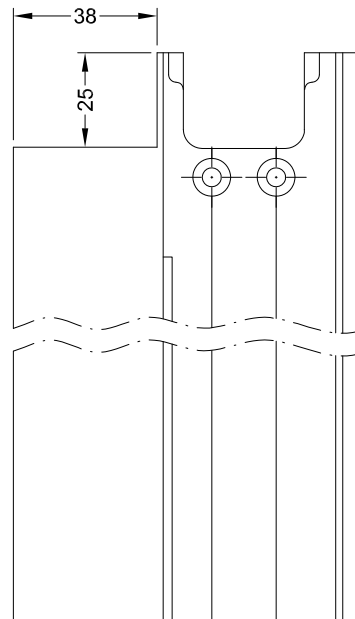
Recess only when using the
additional profile P 496456
or frame B 822012, B 822013, B 822022
or B 822023!!



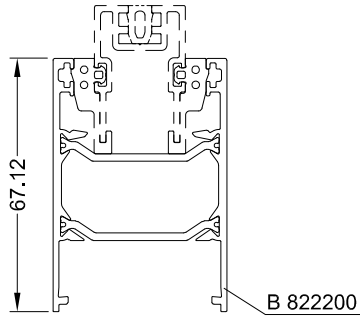
P 821602



P 821601



FLÜGELMONTAGE
 SASH ASSEMBLY

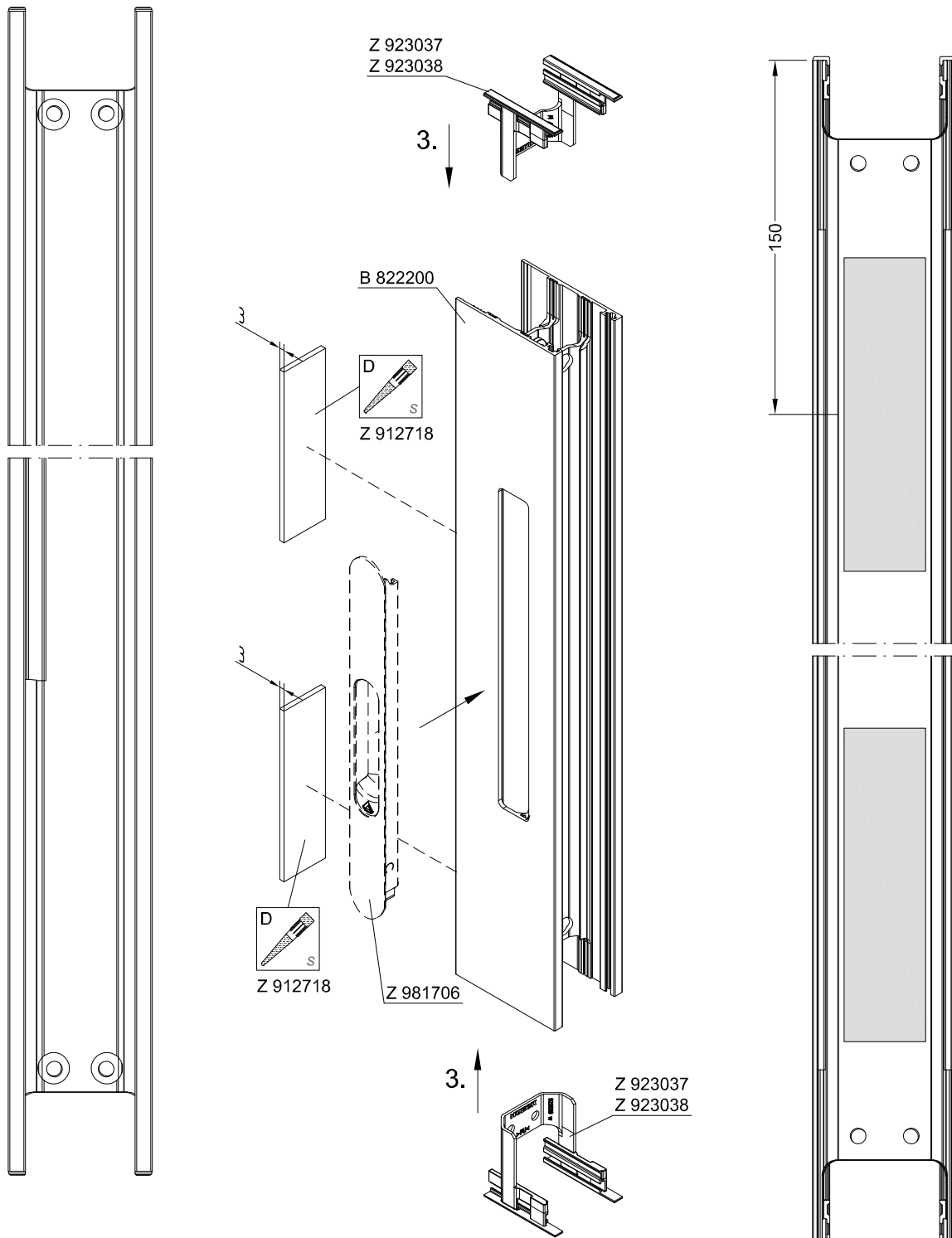


Bearbeitungsschritte

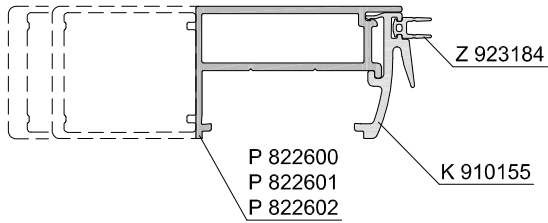
1. Profil P 822200 bearbeiten (siehe Kapitel Flügelbearbeitung)
2. Verglasungsklotz ankleben
3. Endkappen einsetzen

Processing steps

1. Machining the profiles P 822200 and P 822660 (see chapter sash processing)
2. Insert gasket on all sides
3. Insert P822660
4. Glue the glazing block
5. Insert the caps



FLÜGELMONTAGE
 SASH ASSEMBLY

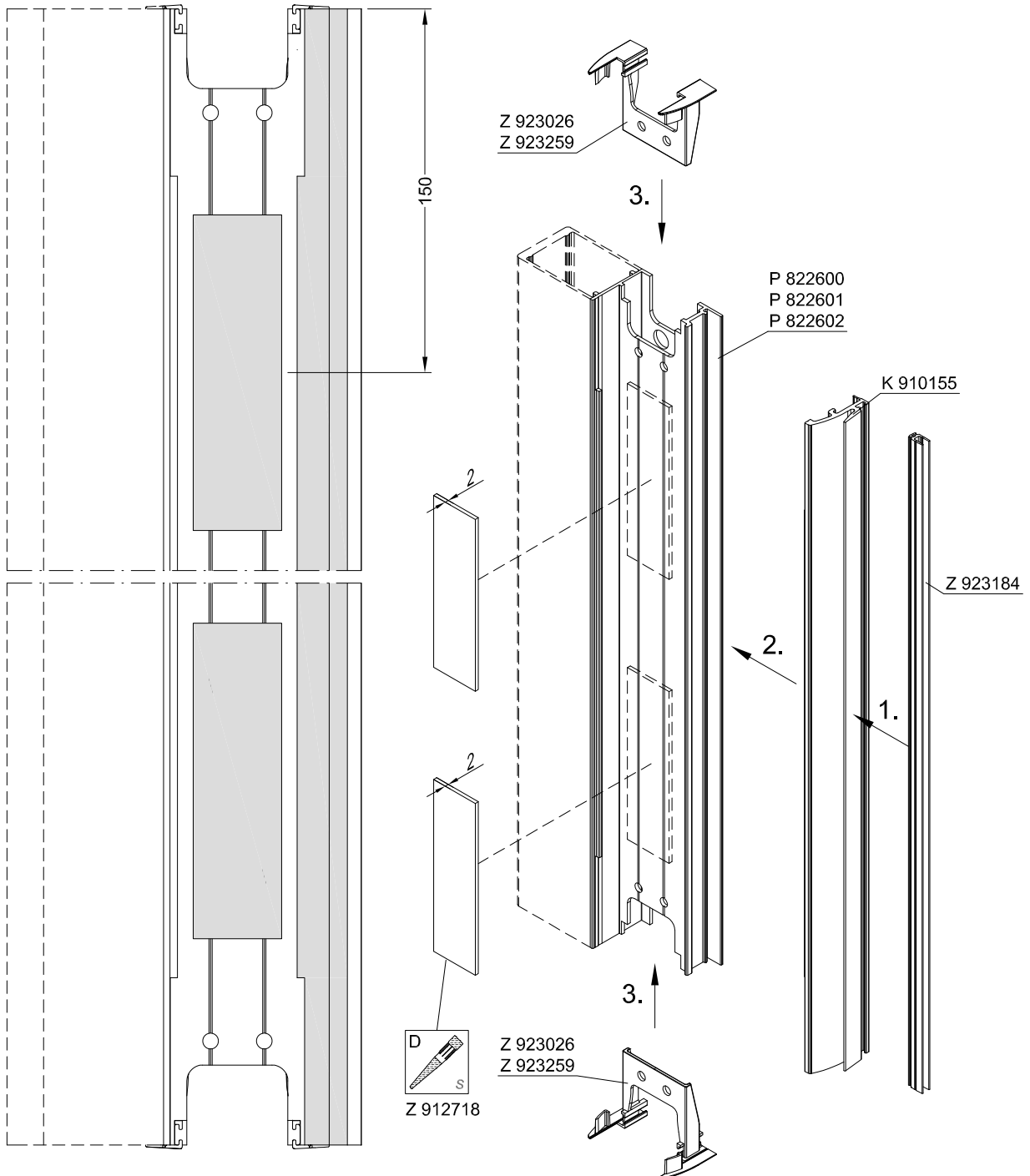


Bearbeitungsschritte

1. Profil bearbeiten (siehe Kapitel Flügelbearbeitung)
2. Dichtung Z 923184 einziehen
3. Verglasungsklotz ankleben
4. Endkappen einsetzen

Processing steps

1. Machining the profiles (see chapter sash processing)
2. Insert gasket Z 923184
3. Glue the glazing block
4. Insert the caps



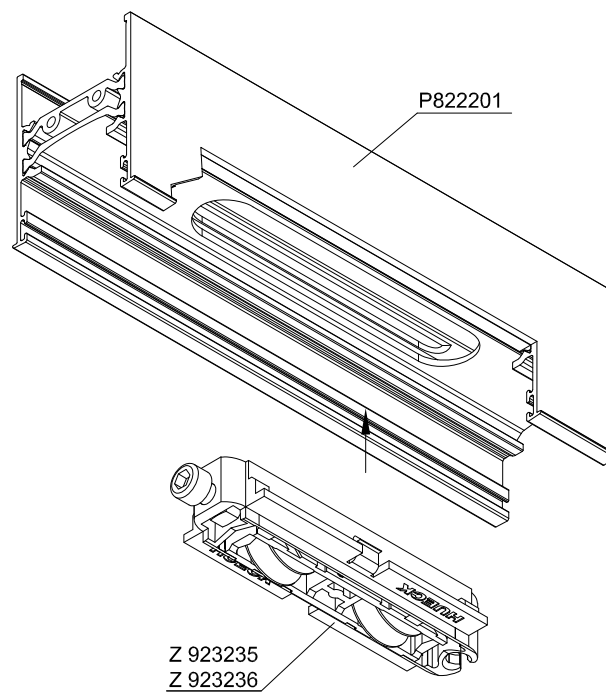
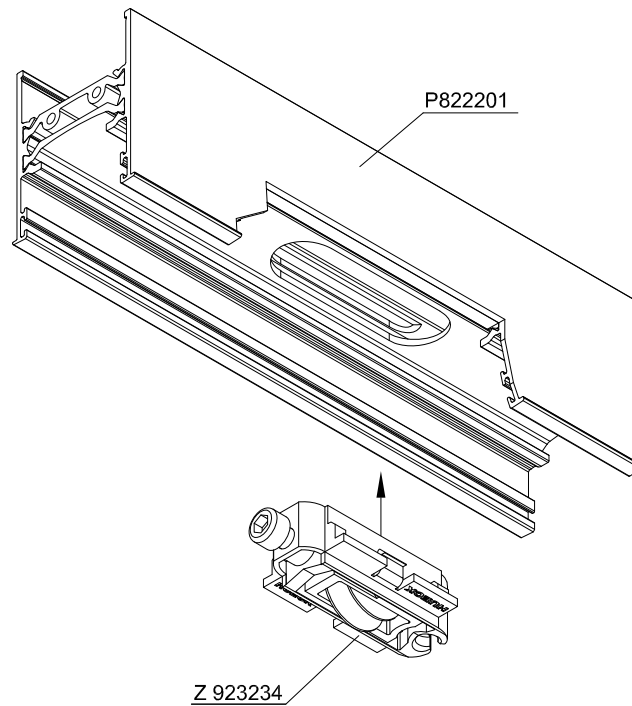
FLÜGELMONTAGE
SASH ASSEMBLY

Bearbeitungsschritte für

1. Laufwagen einklipsen

Processing steps

1. Clip in the rollers



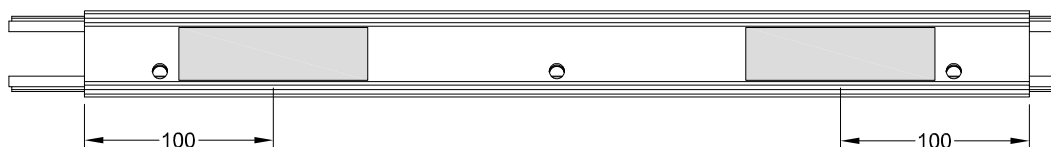
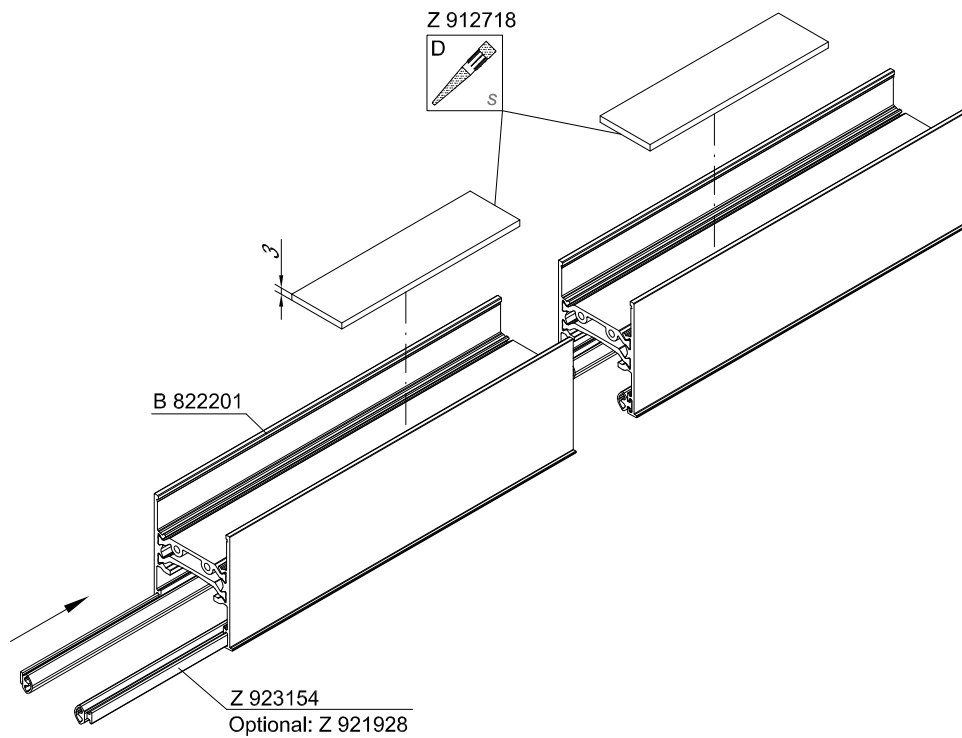
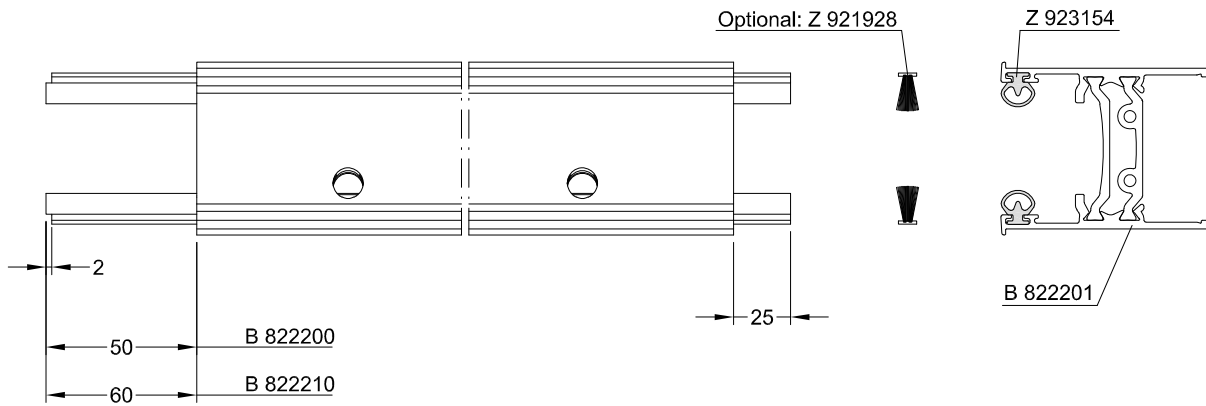
FLÜGELMONTAGE
 SASH ASSEMBLY

Bearbeitungsschritte

1. Dichtungen beidseitig einziehen
2. DichtungsfüÙe ausklinken
3. VerglasungsklöÙe aufkleben

Processing steps

1. Insert gaskets
2. Cut the gaskets
3. Glue the glazing blocks

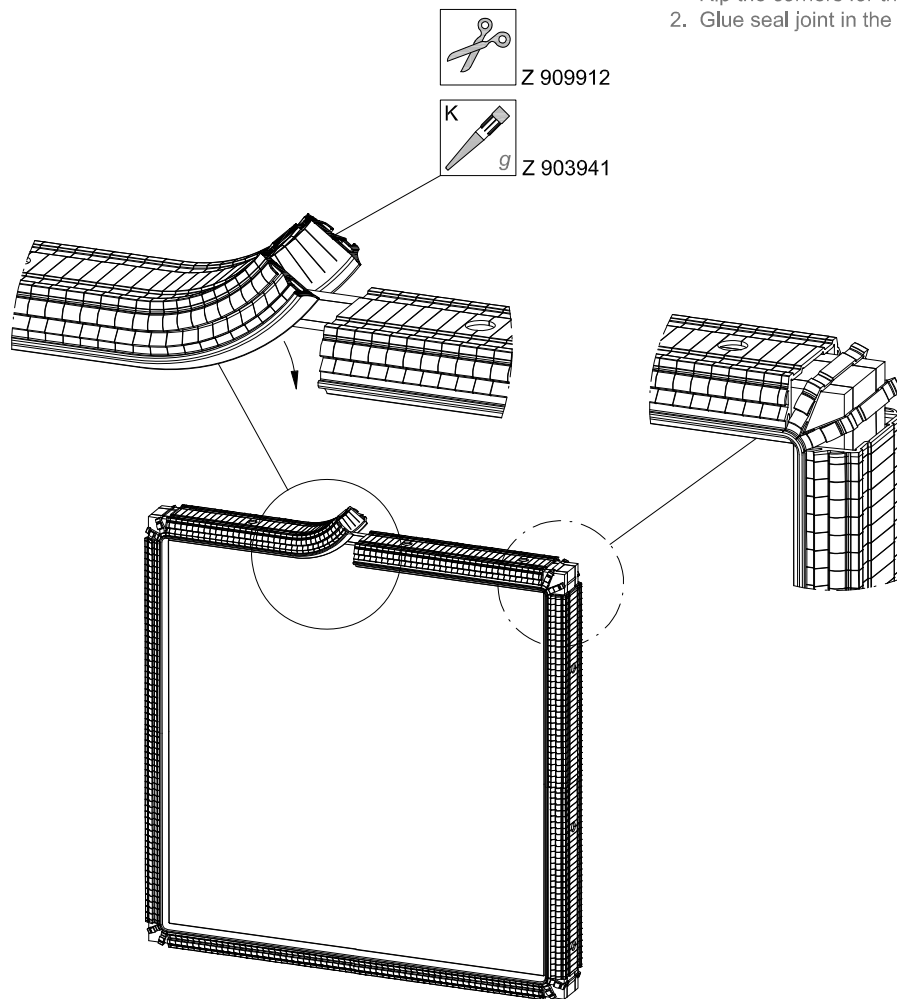


Bearbeitungsschritte

1. Oben mittig beginnend, die Dichtung umlaufend um das Glas ziehen.
 Die Ecken hierfür an den Vorstanzungen aufreißen
2. Dichtungsstoß oben mittig verkleben

Processing steps

1. Starting at the top center, put on the gasket continuously to the glass.
 Rip the corners for this at the pre-cuts
2. Glue seal joint in the top center



Füllungsdicke Filling thickness	Artikelnummer Article number
24 mm	Z 923298
26 mm	Z 923299
28 mm	Z 923300
30 mm	Z 923301
32 mm	Z 923302

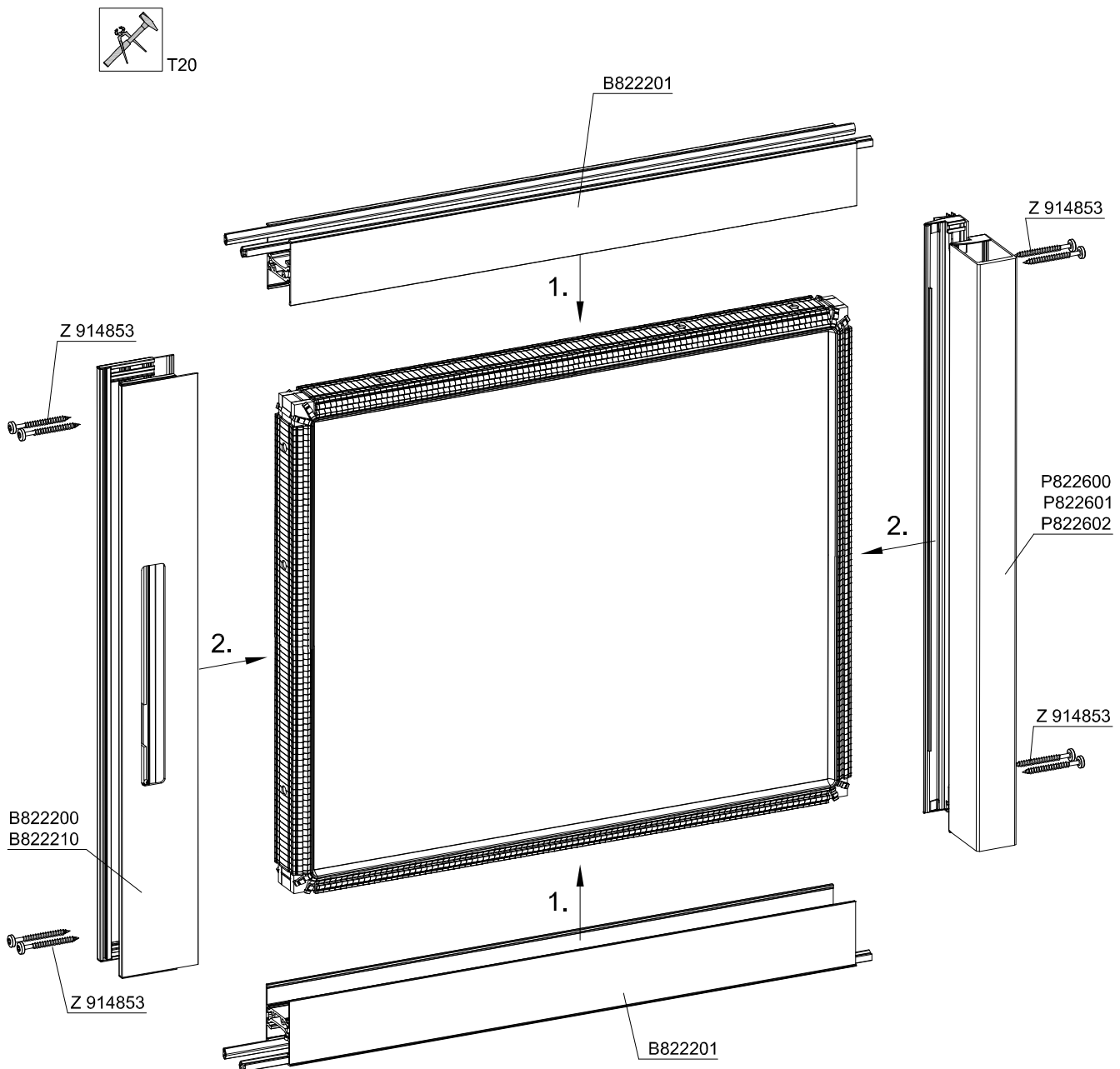
FLÜGELMONTAGE
SASH ASSEMBLY

Bearbeitungsschritte

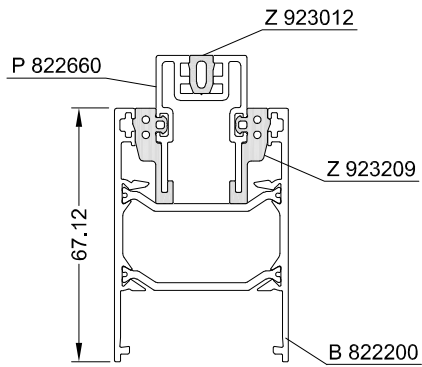
1. Profile aufstecken
2. Mit Z 914853 verschrauben

Processing steps

1. Plug profiles
2. Screw together with Z 914853



FLÜGELMONTAGE
 SASH ASSEMBLY

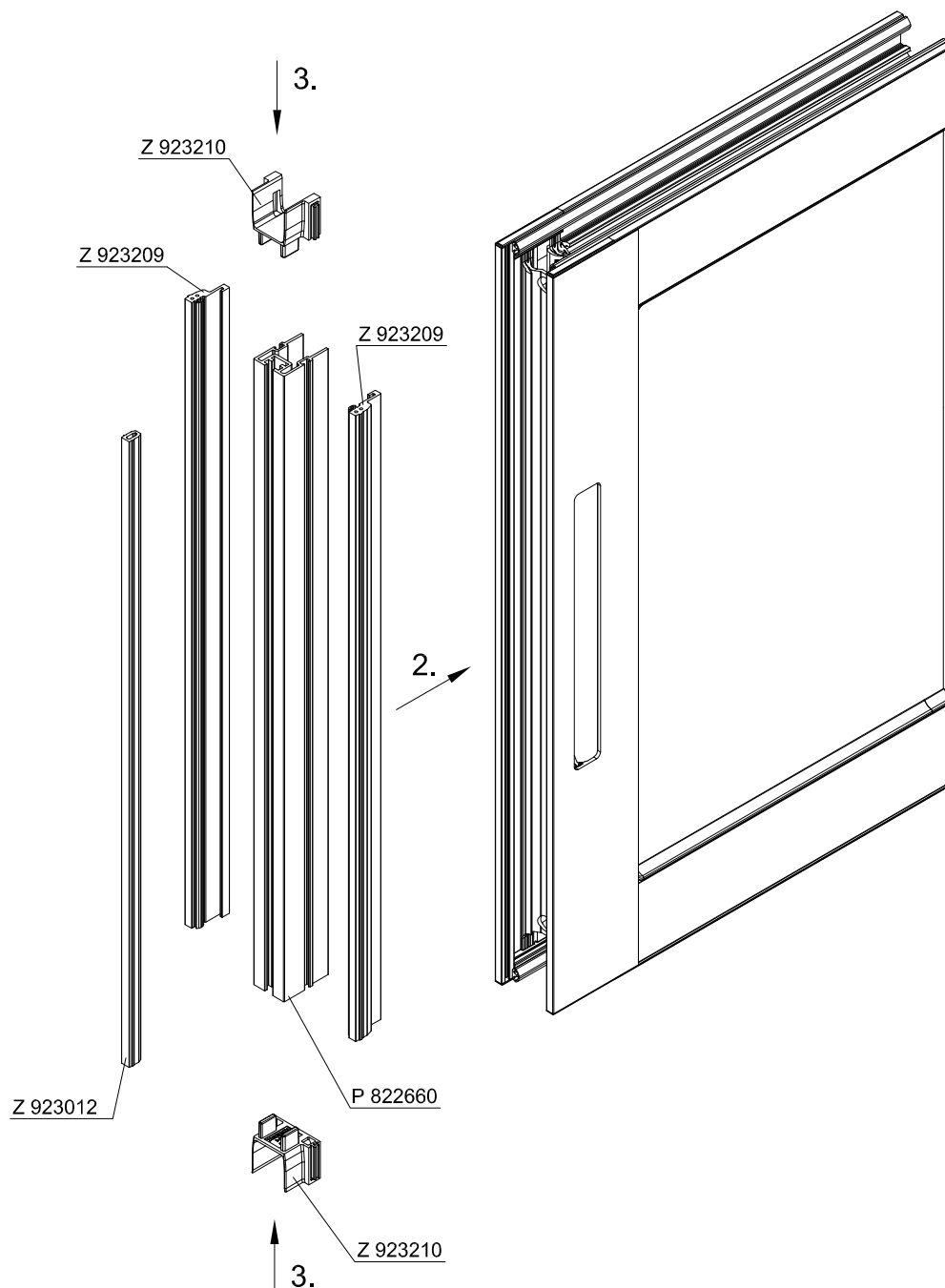


Bearbeitungsschritte

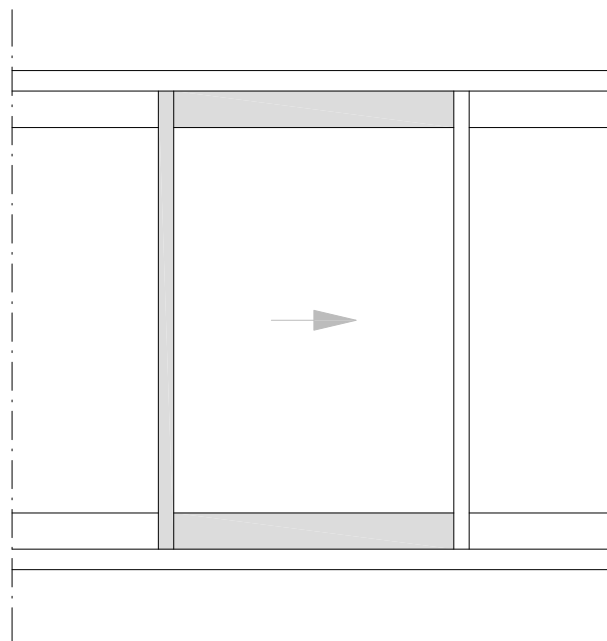
1. Dichtungen allseitig einziehen
2. Profil einsetzen P 822660
3. Z 923210 einsetzen

Processing steps

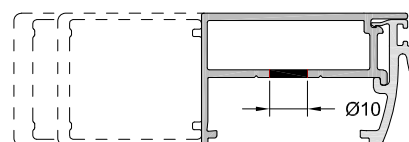
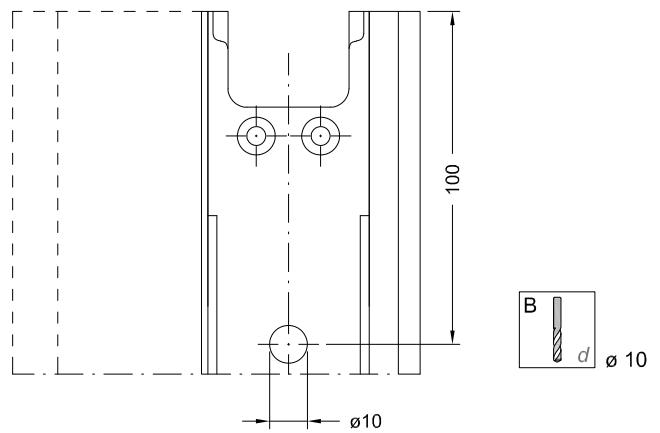
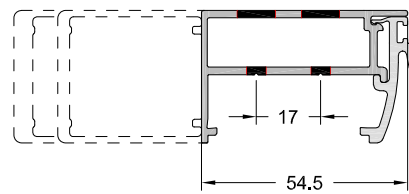
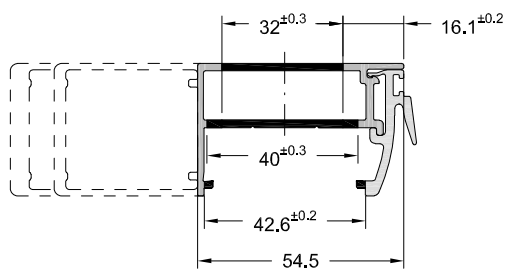
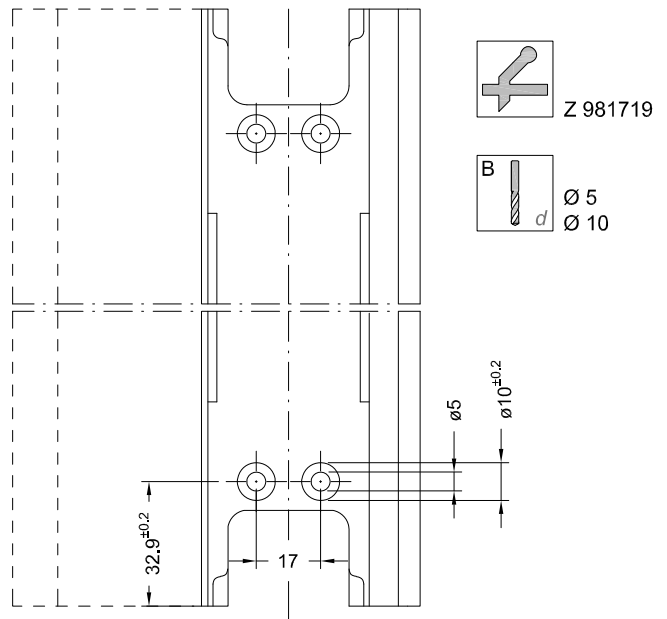
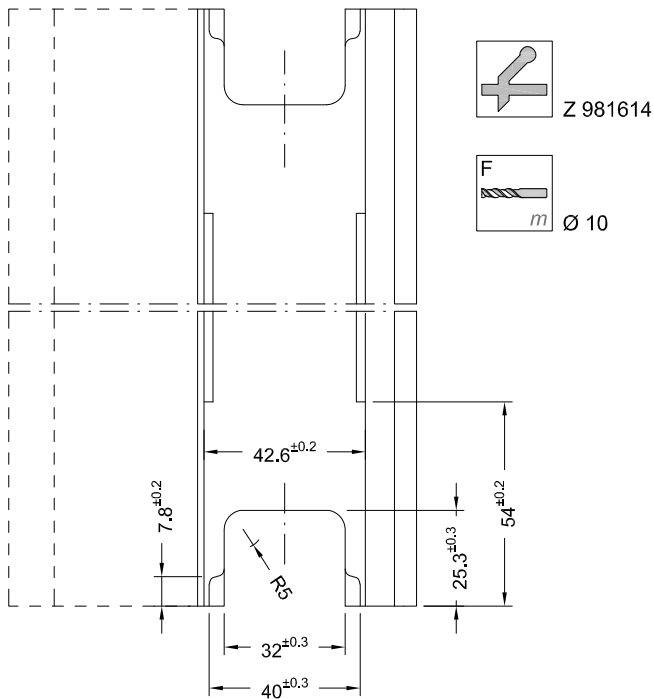
1. Insert gasket on all sides
2. Insert profile P 822660
3. Insert Z 923210



FLÜGELBEARBEITUNG
 SASH PROCESSING

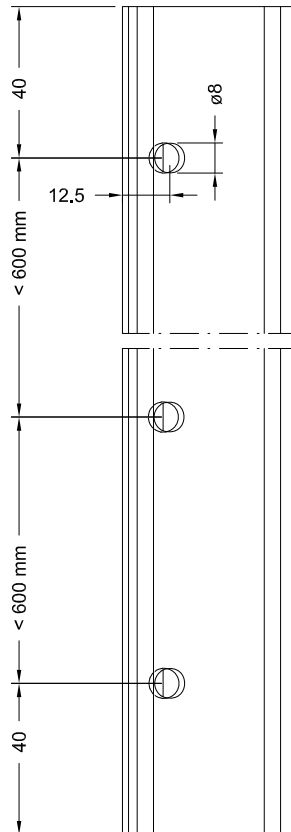
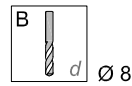
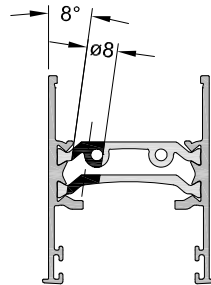


P 822600 + P 822601 + P 822602



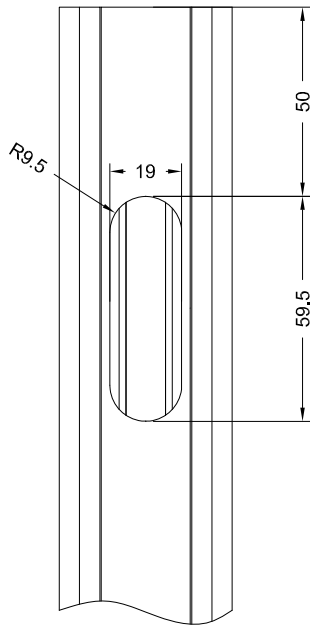
Bearbeitung Flügelbelüftung unten
 Processing for flush handle

B 822201



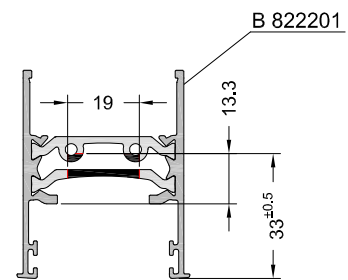
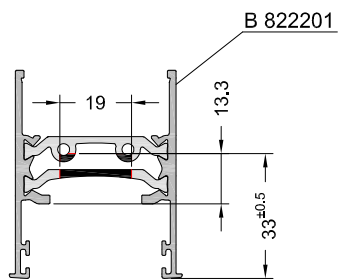
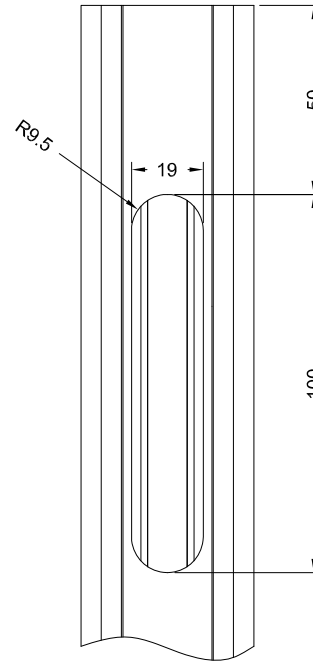
FLÜGELBEARBEITUNG
SASH PROCESSING

Bearbeitung für Laufwagen Z 923234 (60 kg)
Processing for rollers Z 923234 (60 kg)



Bearbeitung für Laufwagen Z 923235 (120 kg)
Laufwagen Z 923236 (200 kg)

Processing for rollers Z 923235 (120 kg)
rollers Z 923236 (200 kg)

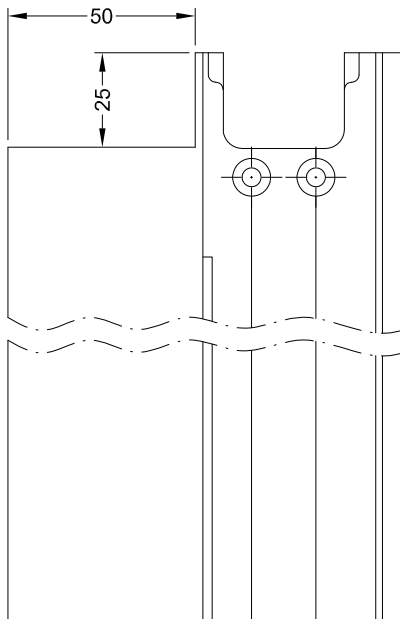


Ausnehmung nur bei Verwendung
 vom Zusatzprofil P 496456 oder
 Rahmenprofil B 822012, B 822013, B 822022
 oder B 822023!

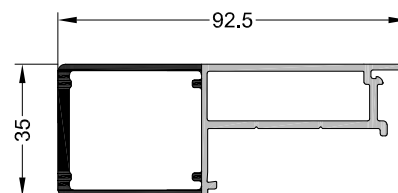
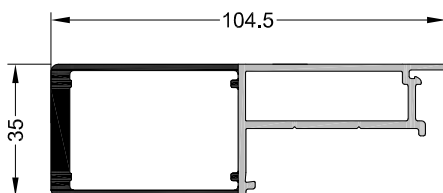
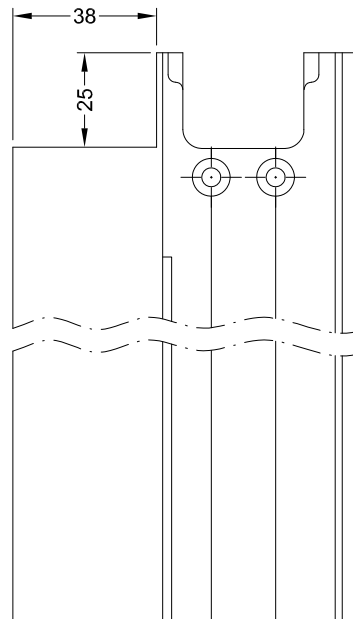
Recess only when using the
 additional profile P 496456
 or frame B 822012, B 822013, B 822022
 or B 822023!!



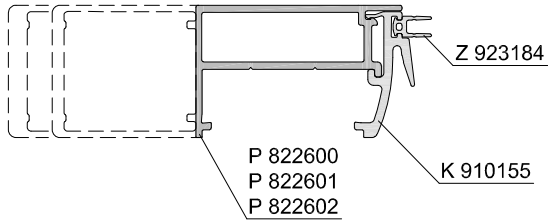
P 821602



P 821601



FLÜGELMONTAGE
 SASH ASSEMBLY

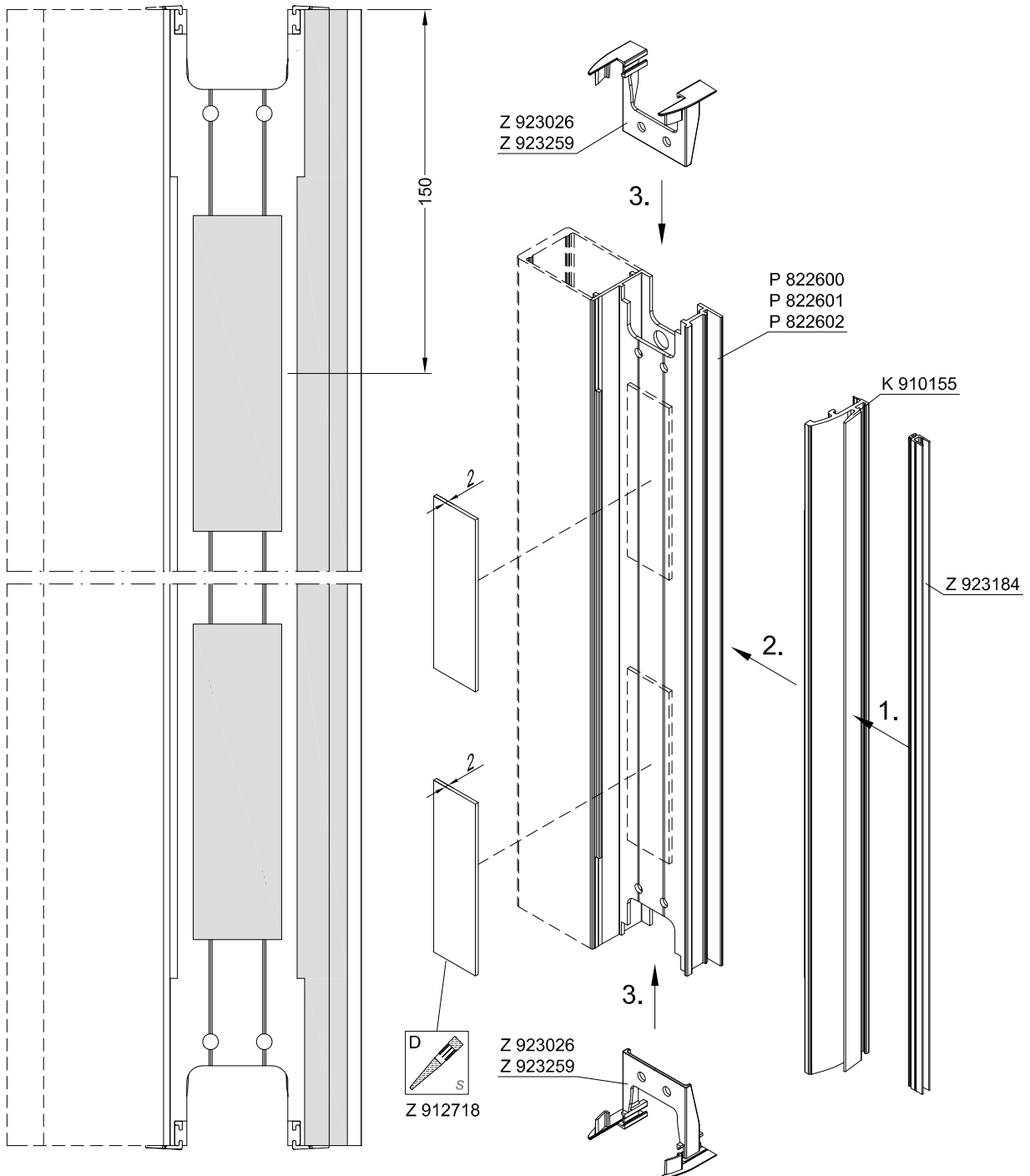


Bearbeitungsschritte

1. Profil bearbeiten (siehe Kapitel Flügelbearbeitung)
2. Dichtung Z 923184 einziehen
3. Verglasungsklotz ankleben
4. Endkappen einsetzen

Processing steps

1. Machining the profiles (see chapter sash processing)
2. Insert gasket Z 923184
3. Glue the glazing block
4. Insert the caps



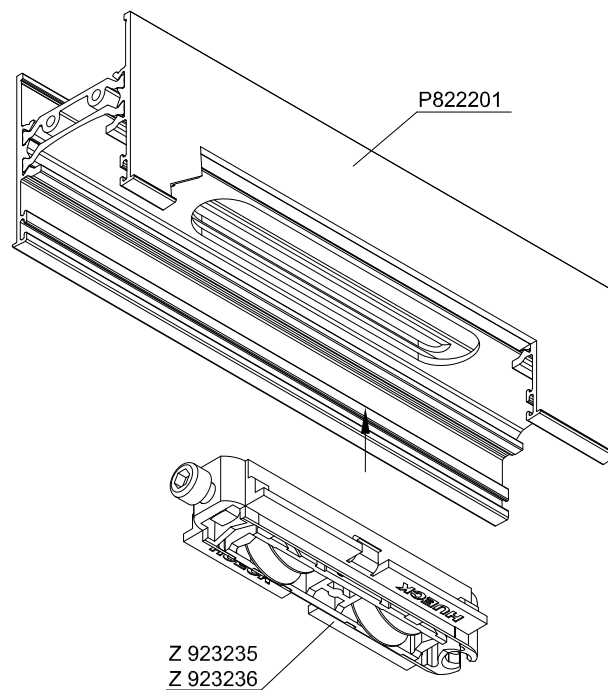
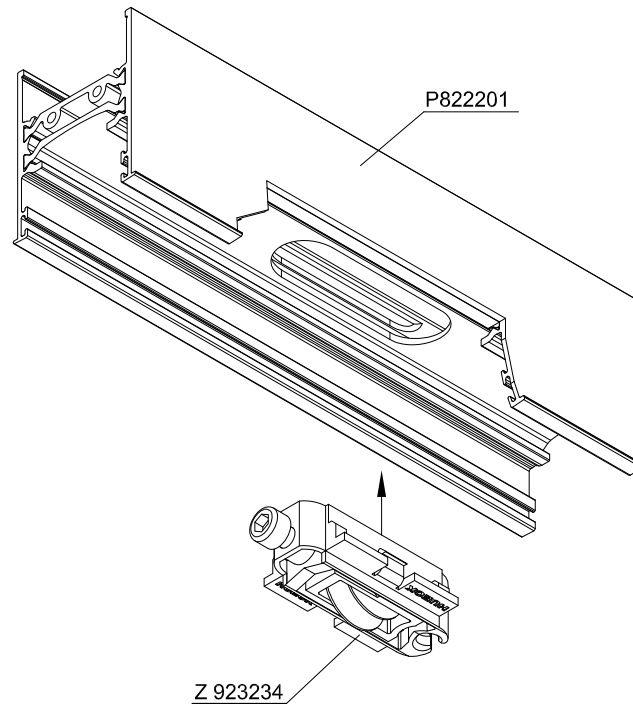
FLÜGELMONTAGE
SASH ASSEMBLY

Bearbeitungsschritte für

1. Laufwagen einklipsen

Processing steps

1. Clip in the rollers



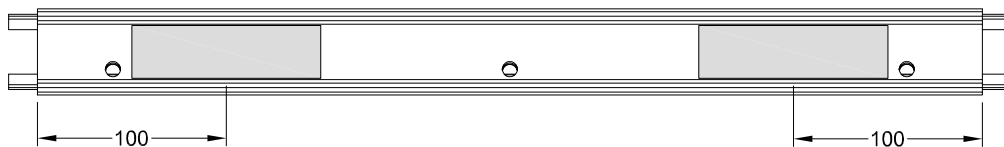
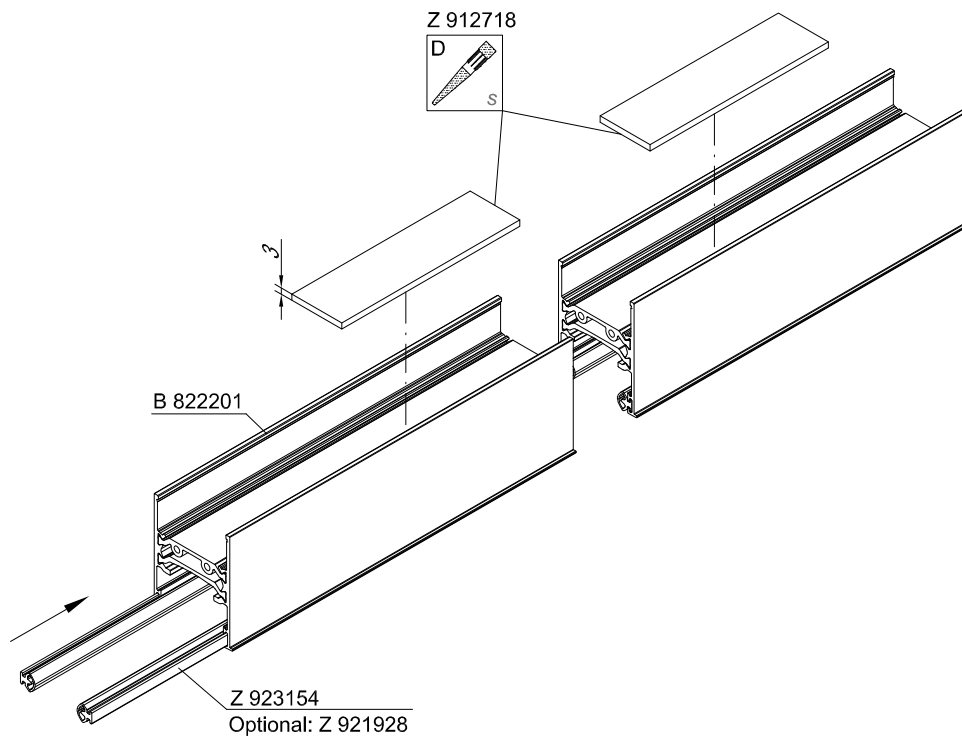
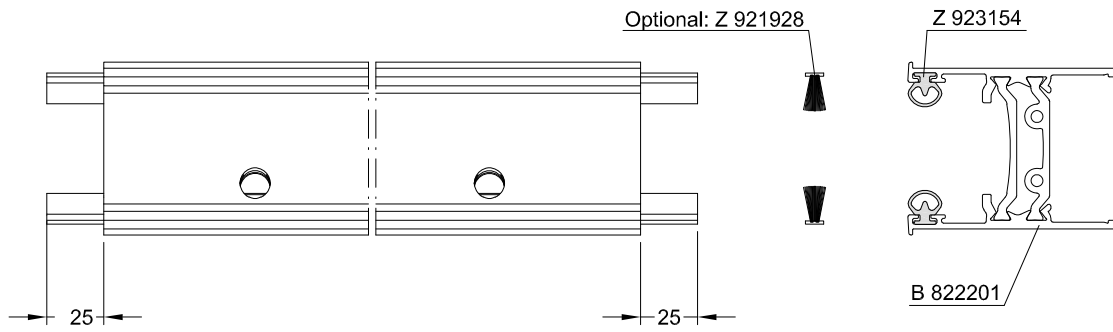
FLÜGELMONTAGE
SASH ASSEMBLY

Bearbeitungsschritte

1. Dichtungen beidseitig einziehen
2. Verglasungsklotze aufkleben

Processing steps

1. Insert gaskets
2. Glue the glazing blocks

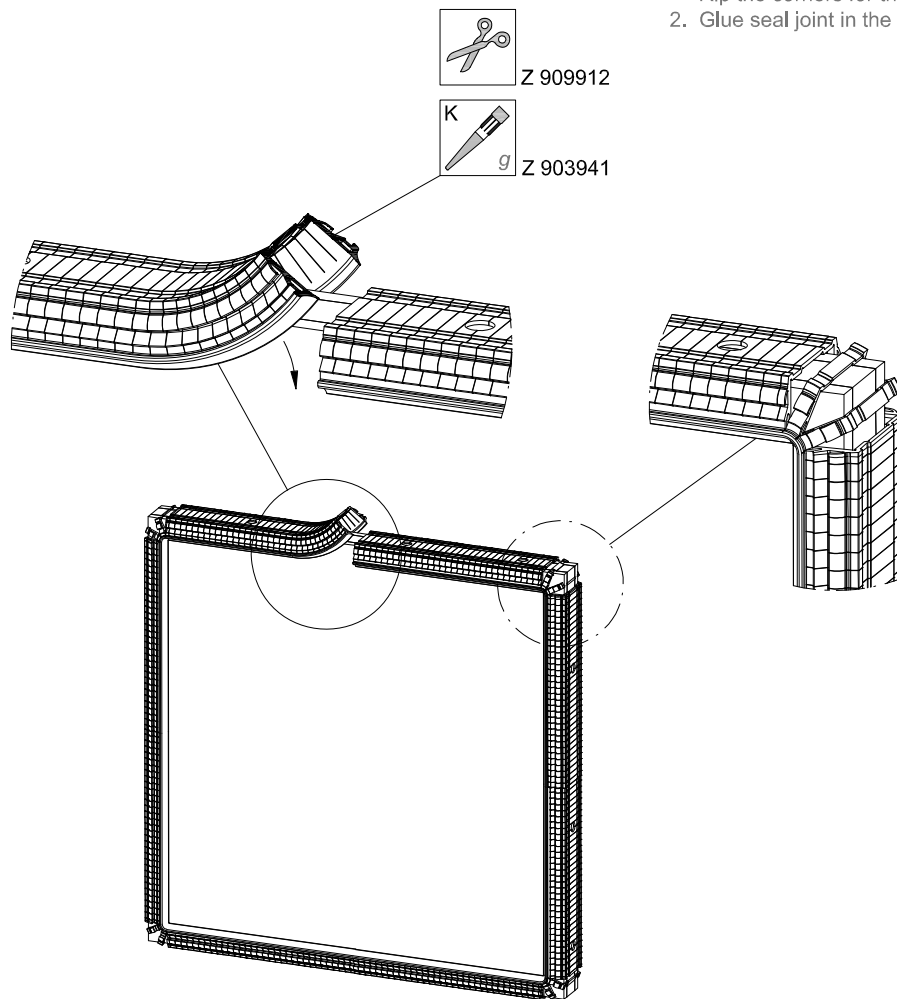


Bearbeitungsschritte

1. Oben mittig beginnend, die Dichtung umlaufend um das Glas ziehen.
Die Ecken hierfür an den Vorstanzungen aufreißen
2. Dichtungsstoß oben mittig verkleben

Processing steps

1. Starting at the top center, put on the gasket continuously to the glass.
Rip the corners for this at the pre-cuts
2. Glue seal joint in the top center



Füllungsdicke Filling thickness	Artikelnummer Article number
24 mm	Z 923298
26 mm	Z 923299
28 mm	Z 923300
30 mm	Z 923301
32 mm	Z 923302

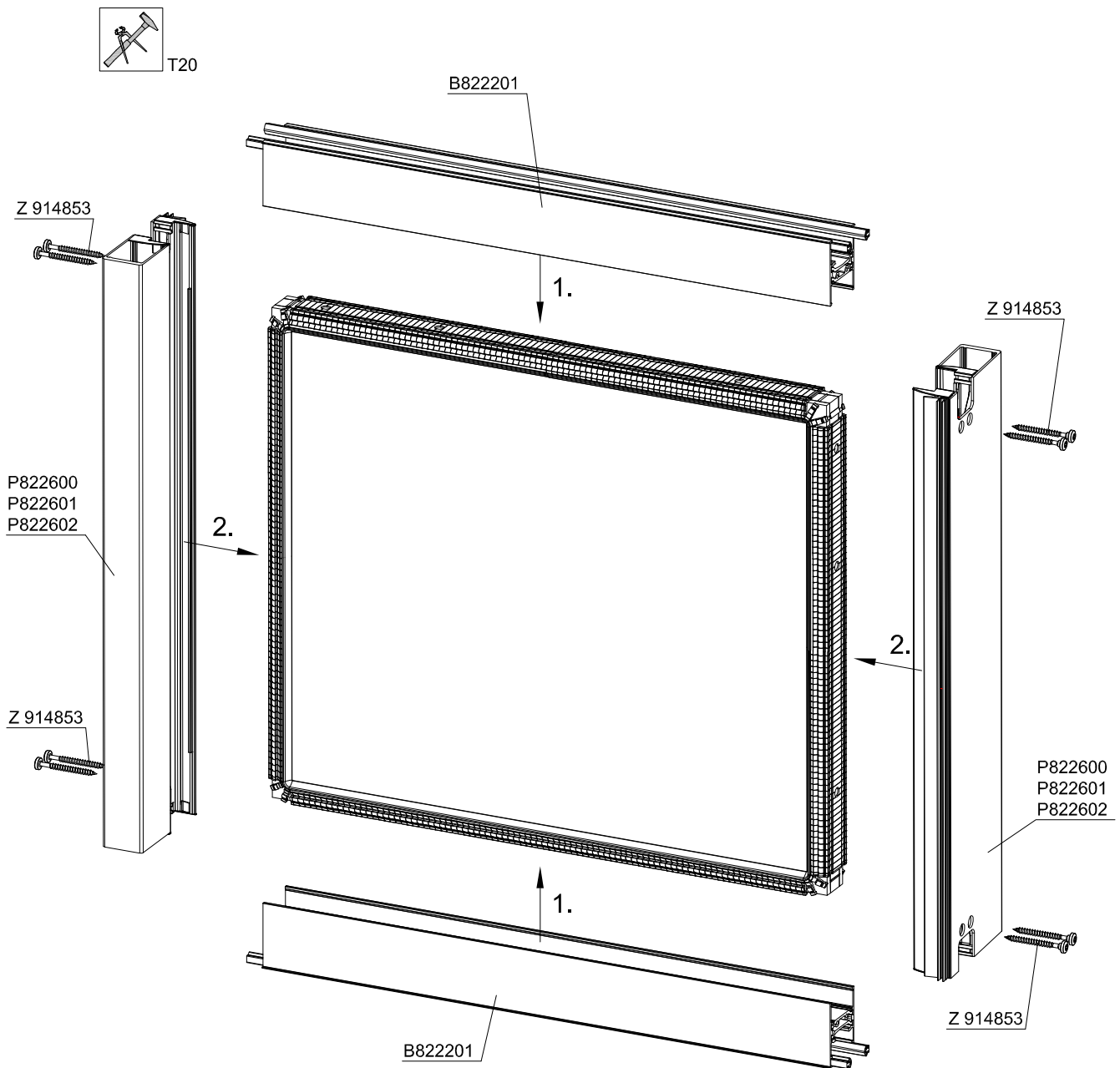
FLÜGELMONTAGE
SASH ASSEMBLY

Bearbeitungsschritte

1. Profile aufstecken
2. Mit Z 914853 verschrauben

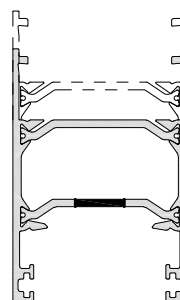
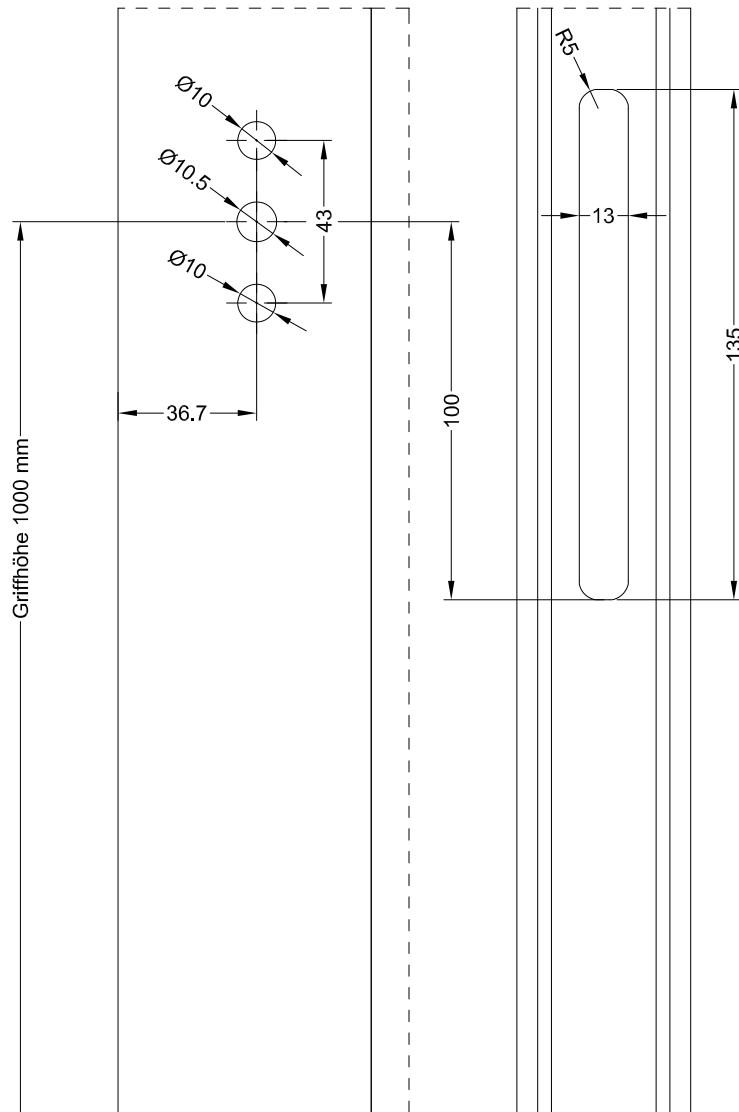
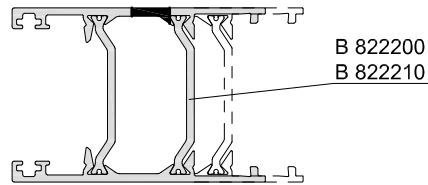
Processing steps

1. Plug profiles
2. Screw together with Z 914853



SCHLOSS - BEARBEITUNG
 LOCK - PROCESSING FOR INSTALLATION

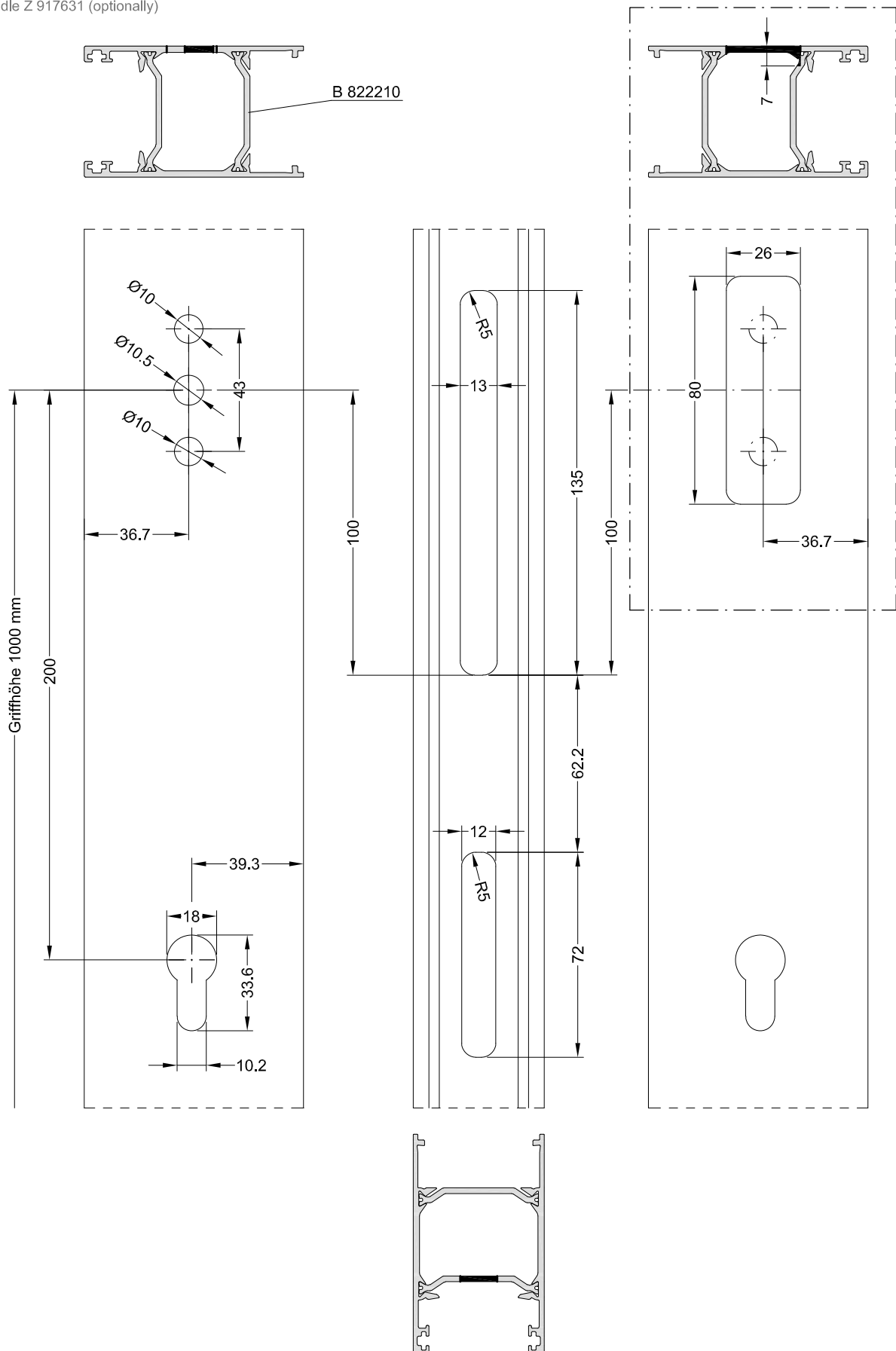
Bearbeitung für Schloss Z 981647, Z 981648 und Z 981649
 Processing for lock Z 981647, Z 981648 and Z 981649



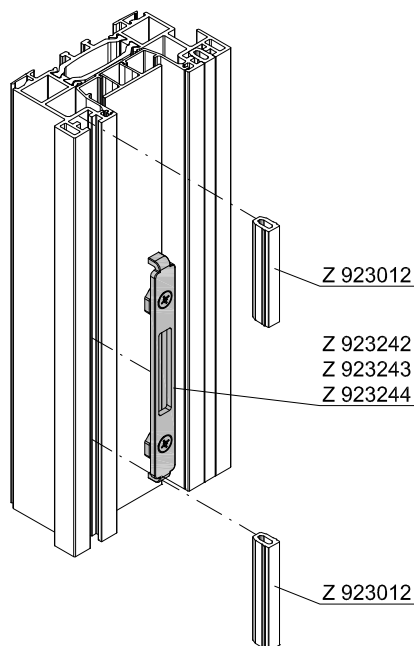
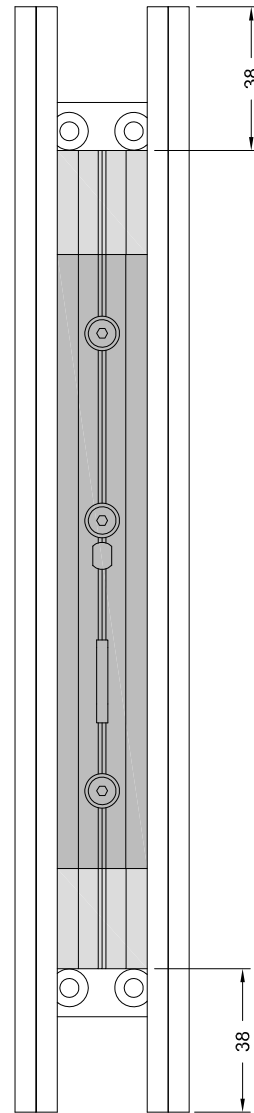
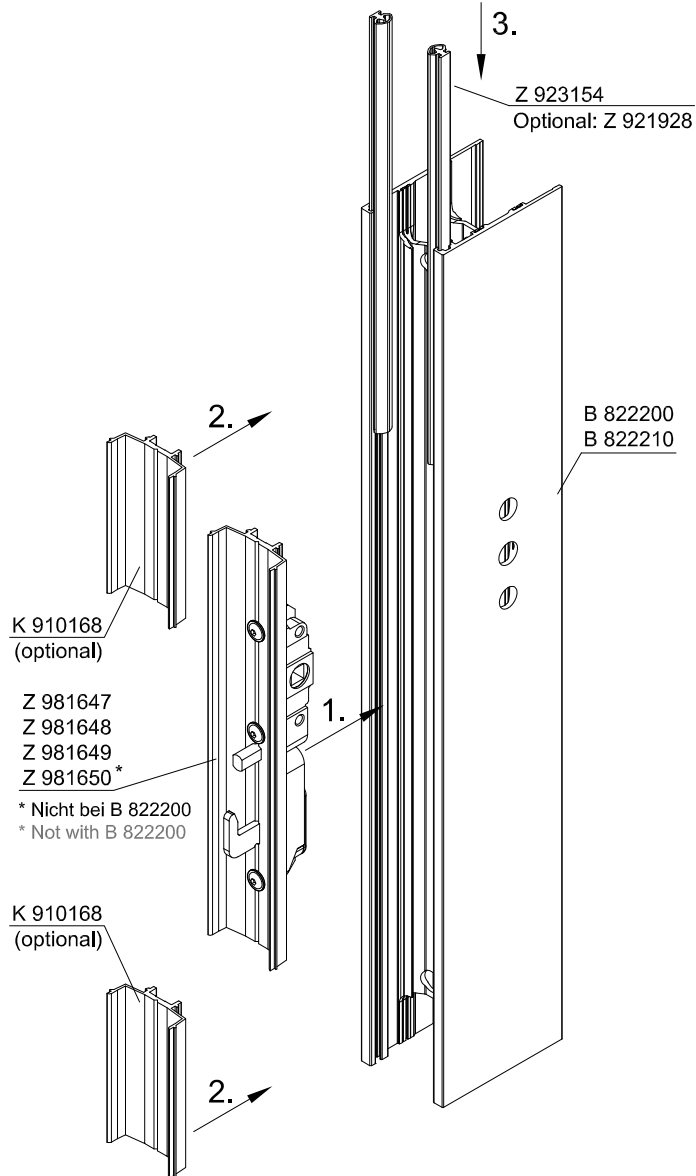
SCHLOSS - BEARBEITUNG
LOCK - PROCESSING FOR INSTALLATION

Bearbeitung für Schloss Z 981650
Griffmuschel Z 917631 (optional)
Processing for lock Z 981650
flush handle Z 917631 (optionally)

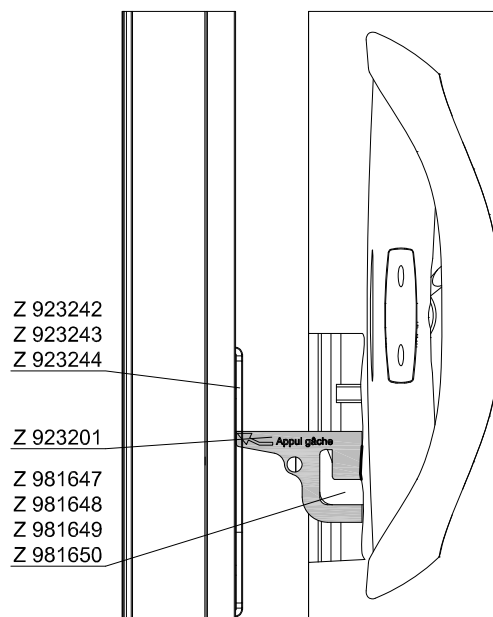
Nur bei Griffmuschel Z 917631 (optional)
Only when using flush handle Z 917631 (optionally)



SCHLOSS - BEARBEITUNG
 LOCK - PROCESSING FOR INSTALLATION

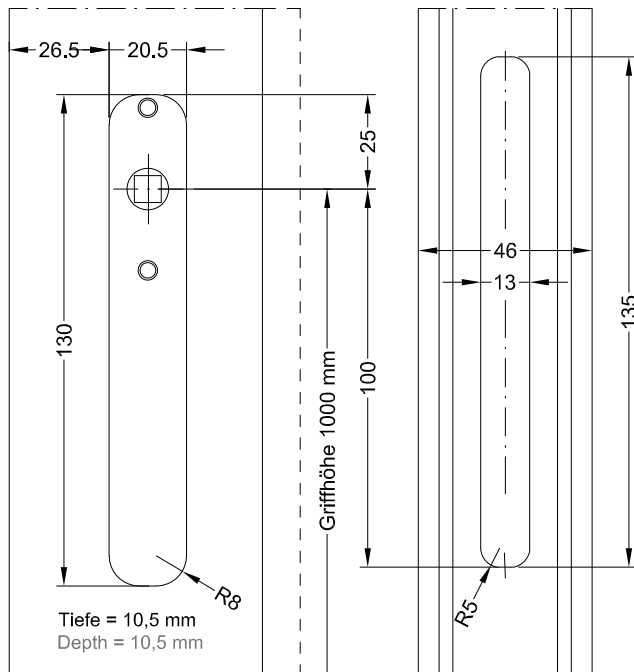
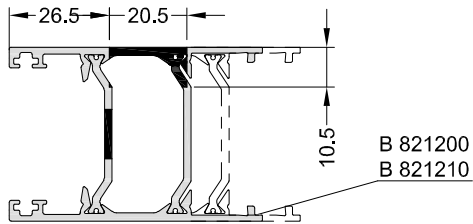


Hebelstellung: Geöffnet
 PLever position: Open



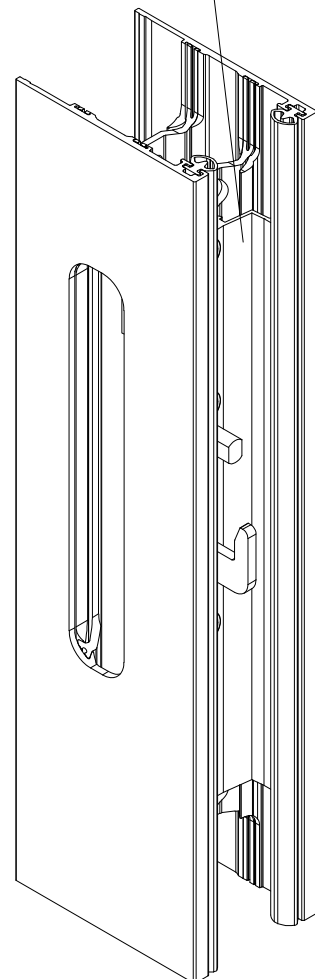
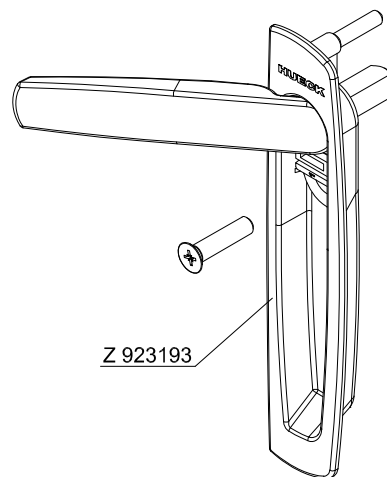
SCHLOSS - BEARBEITUNG
LOCK - PROCESSING FOR INSTALLATION

Bearbeitung für Getriebe und Griffmuschel
Processing for gear, handle and flush handle



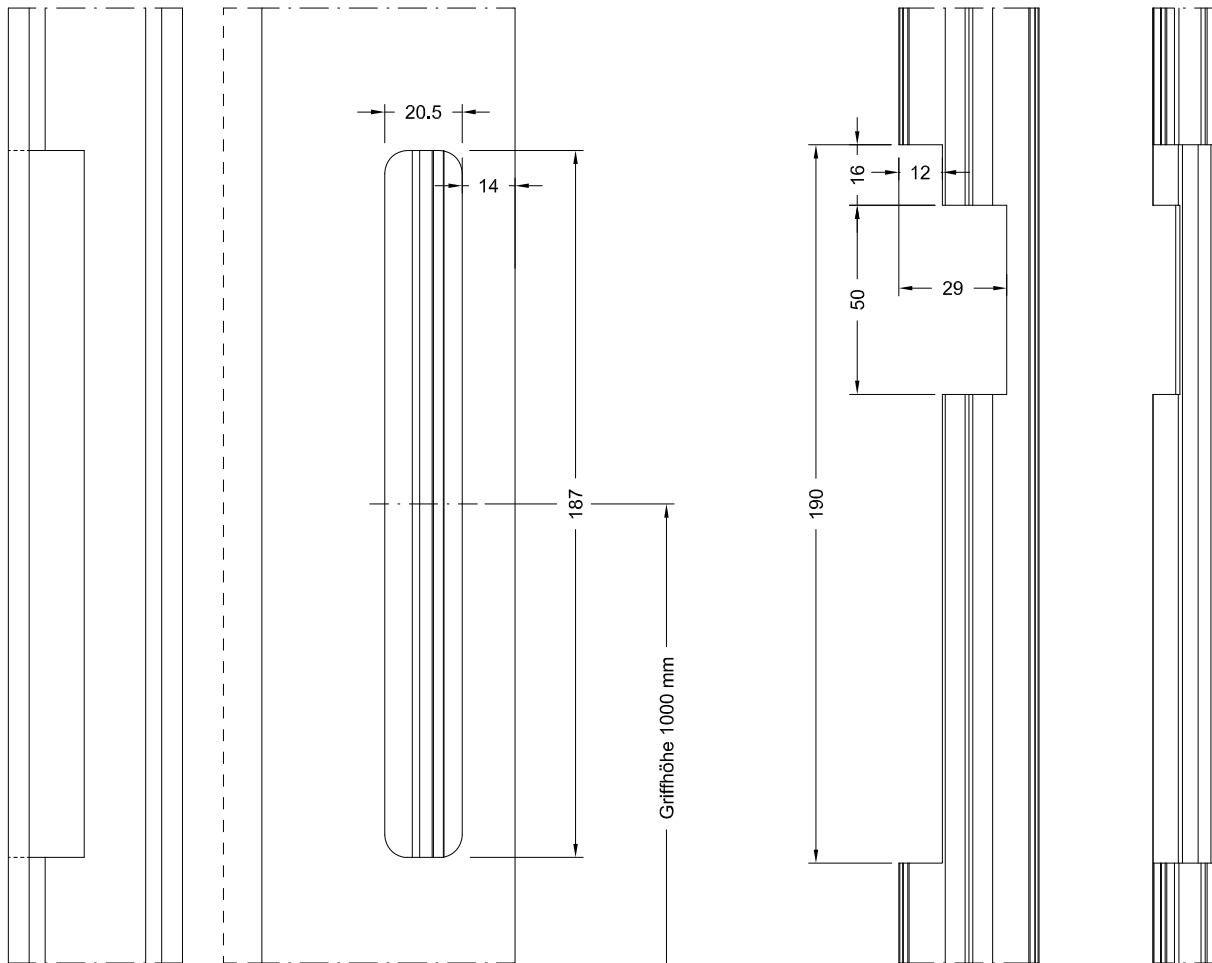
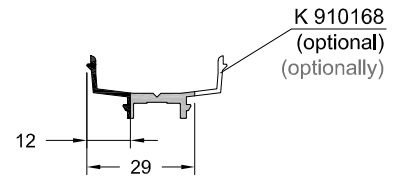
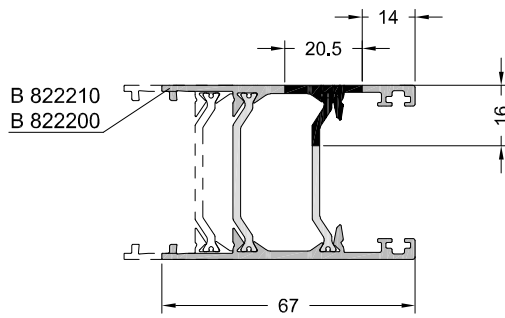
Z 981647
Z 981648
Z 981649
Z 981650*

* Nicht bei B 822200
* Not with B 822200



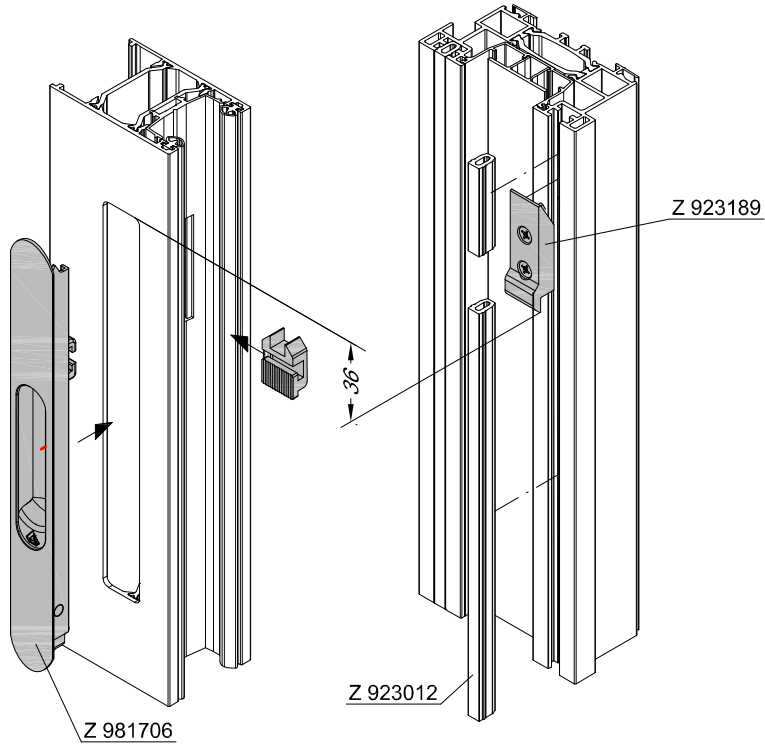
SCHLOSS - BEARBEITUNG
 LOCK - PROCESSING FOR INSTALLATION

Bearbeitung für Griffmuschel
 Processing for handle recess



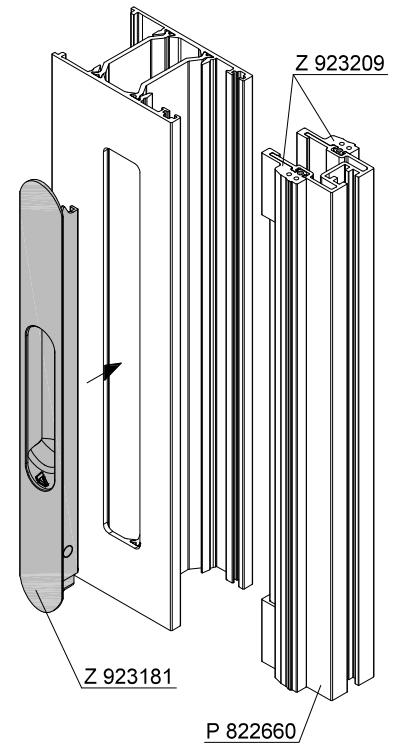
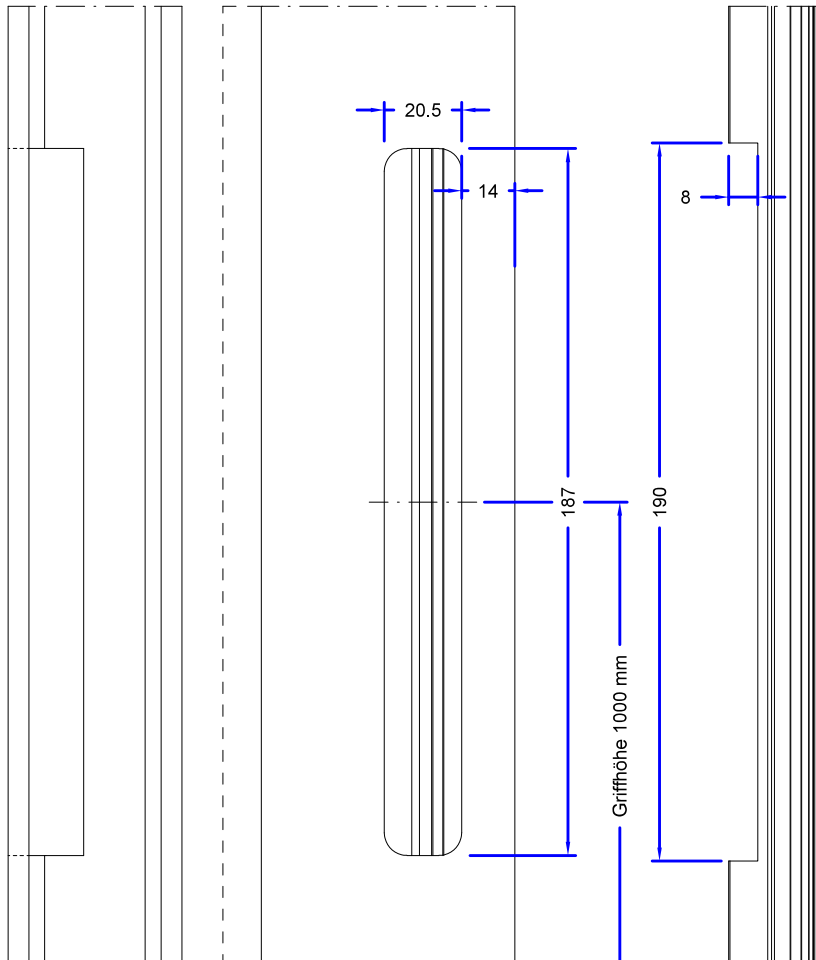
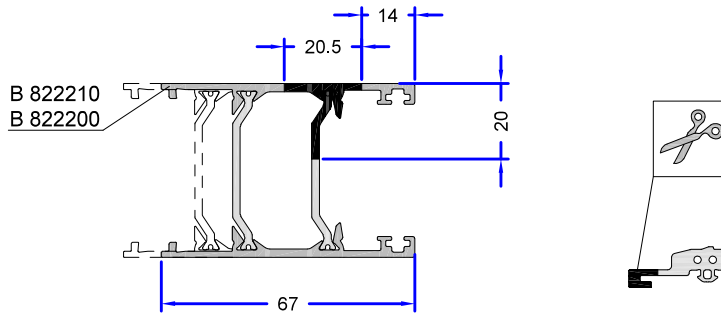
SCHLOSS - BEARBEITUNG
LOCK - PROCESSING FOR INSTALLATION

Montage Griffmuschel
Installation handle recess

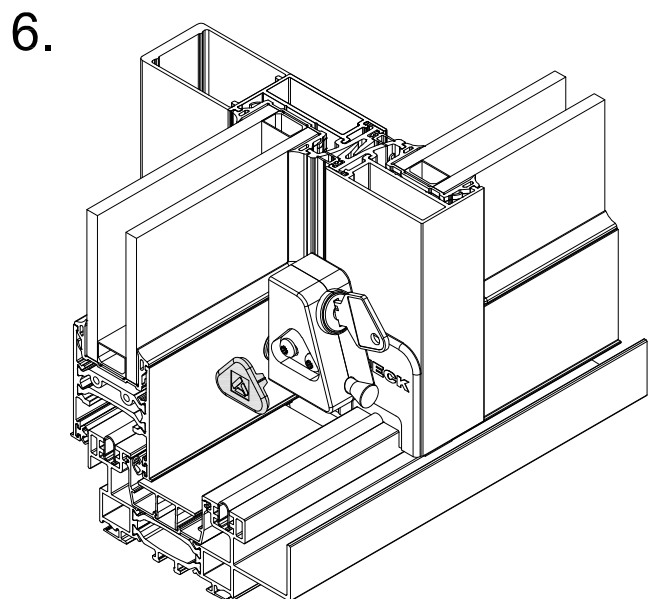
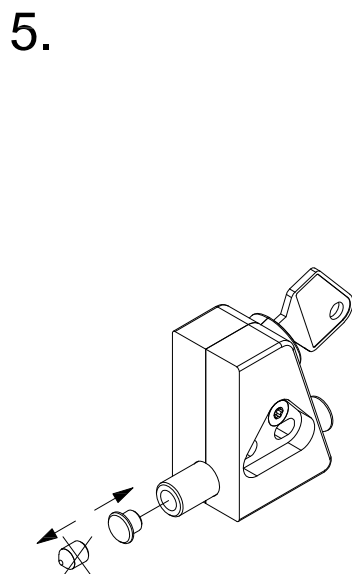
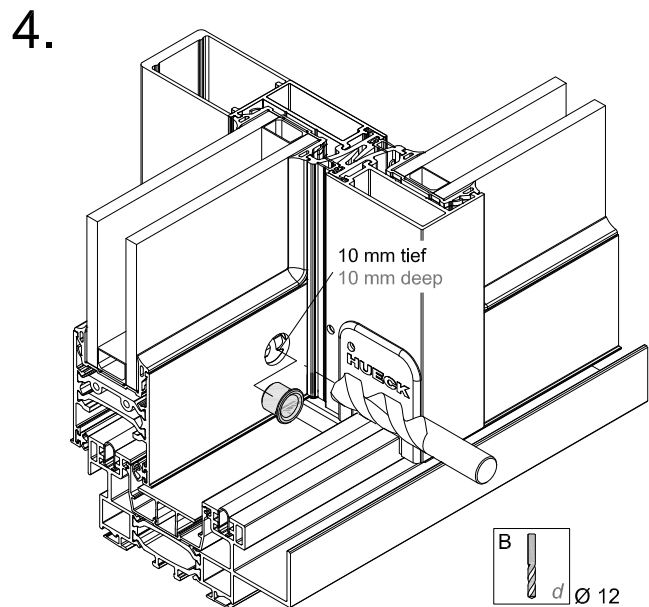
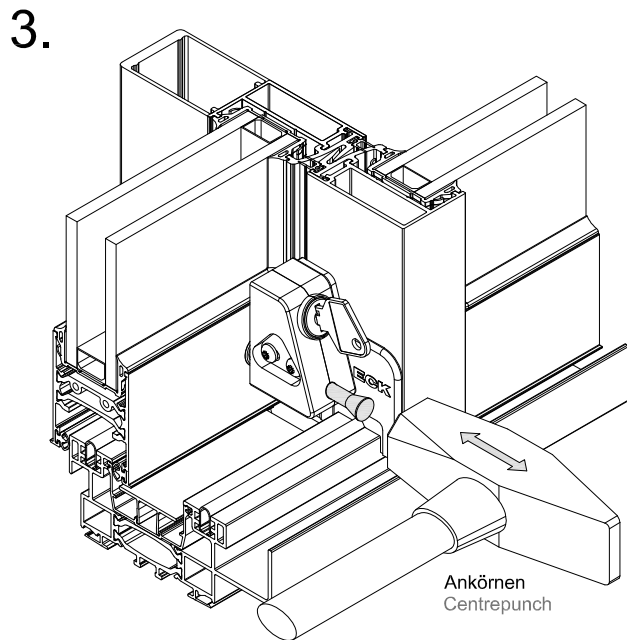
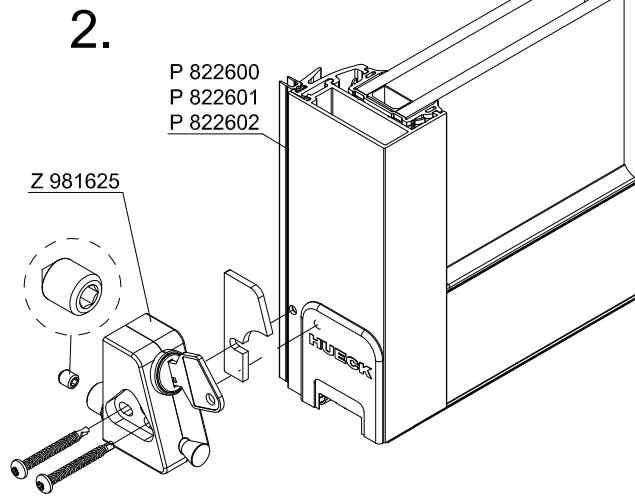
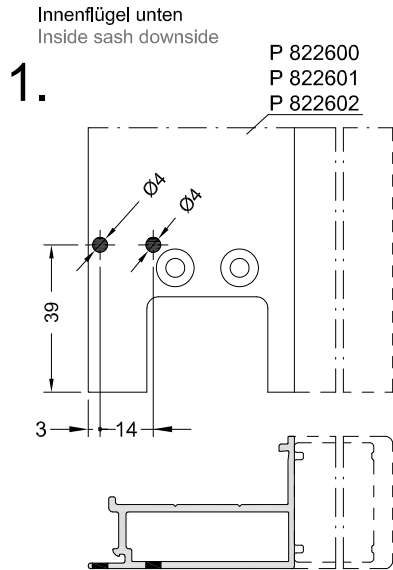


SCHLOSS - BEARBEITUNG
 LOCK - PROCESSING FOR INSTALLATION

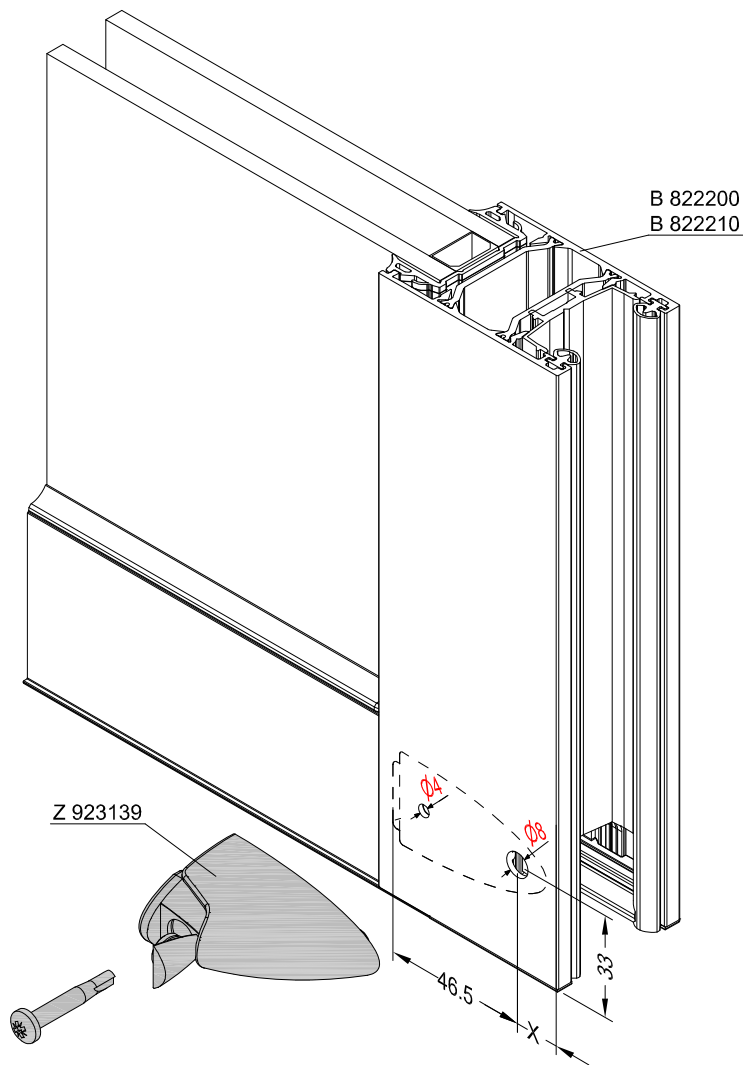
Bearbeitung und Montage Griffmuschel
 Processing and installation handle recess



STOPPER - BEARBEITUNG UND EINBAU
STOPPER - PROCESSING AND INSTALLATION



STOPPER - BEARBEITUNG UND EINBAU
 STOPPER - PROCESSING AND INSTALLATION



Griff (Aussenseite) Handle (outside)	X
Z 981623	15
Z 981624 / 621 / 622	26
Z 923228	109
Z 981616 / 617	103

