PRODUCT MANUAL

February 2020

SWIFT™ 28

WINDOW (28 mm)

crealco
creative aluminium

A product of
WISPECO Aluminium

SWIFT™ 28 WINDOW (28 mm)

LEGAL DISCLAIMER

General Documentation Disclaimer

This manual is intended as a manufacturing and installation advisory document. For correct specifications, sizing of profiles and structural information please consult the StarFront Application. If the information you require is not available through the StarFront Application, please contact your stockist before proceeding. It is advisable to have all sizing and performance criteria checked by a qualified structural engineer to ensure that the required criteria will be met.

All information, recommendations or advice contained in this documentation is given in good faith to the best of Wispeco's knowledge and is based on current procedures in effect.

Since the actual use of this documentation by the user is beyond the control of Wispeco, such use is within the exclusive responsibility of the user. Wispeco cannot be held responsible for any loss incurred through incorrect or faulty use of this documentation. Training of Wispeco systems is important for ensuring correct procedures in the manufacturing of products.

Great care has been taken to ensure that the information provided is correct.

Ensure that you have the latest available manual. The revision number and date can be checked on the latest StarFront version.

Wispeco will accept no responsibility for any errors and/or omissions, which may have inadvertently occurred.

Specifications concerning products and applications

This manual is based on standard configurations only. As there are many configurations not covered in this manual, contact your stockist with regards to a configuration not represented herein if required.

AutoDesk drawings (CAD Symbol Library) are available on request and can be issued with the consent of the Wispeco Technical Department.

All mechanical joints must be sealed with a **Crealco approved joint sealer**. Failure to correctly seal the joints can affect the performance of the system. Information on joint sealing can be found in the Cleaning & Maintenance Manual** available for download from **www.crealco.co.za** or from StarFront.

All drawings in the Wispeco Documentation are NOT to scale and are used for illustrative purposes only.

Wispeco will not accept responsibility for the use of standard products since Wispeco does not know where these products are being installed.

The hardware recommended in this documentation is suitable for use in most atmospheric environments. When hardware is used in severe coastal environments the manufacturer of the hardware must be consulted.

For the coastal regions and any other high corrosion areas, the following is advised: to minimize phylliform corrosion use SurTec650 RTU spray during the manufacturing of aluminium profile systems. This should be applied, before assembly, on all pre-work aluminium where the powder coating covering has been removed thereby exposing the raw aluminium base.

The use of non-specified hardware or incorrect mechanical fasteners can adversly affect the mechanical and weathering performance of the system and we strongly advise against deviations. A Wispeco Consultant can advise you of any hardware issues and limitations with regard to this system.

The use of anti-magnetic stainless steel screws and aluminium pop rivets is recommended to reduce galvanic corrosion in harsh environments.

Fixing lugs on frames must be positioned as per the user manual and used in accordance to the AAMSA specifications. When profiles are screwed together the screw centres must also be according to the user manual or as specified by an engineer.

All glass used within Wispeco products must comply with SAGGA regulations. Laminated glass must not stand in water.

***For Cleaning and Maintenance of this system please download the Wispeco Installation, Cleaning and Maintenance Procedures from the Crealco website (www.crealco.co.za).*

By continuing to use this documentation you acknowledge that you understand and accept the legal disclaimer.

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

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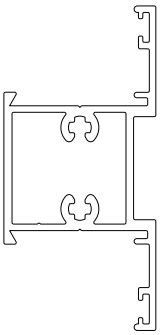
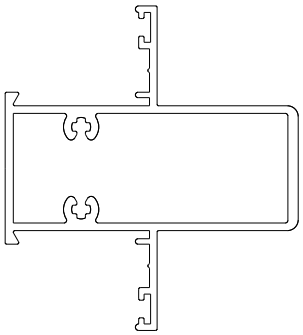
Profile Identification

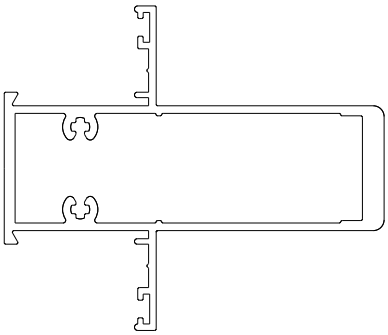
Swift 28 Window Profiles



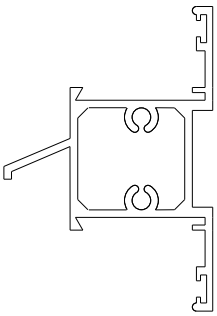
DIE No. W55683 Swift 28 Mullion 28mm



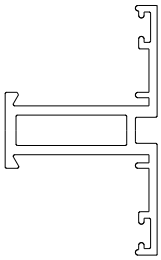
DIE No. W54348 Swift 28 Mullion 54mm



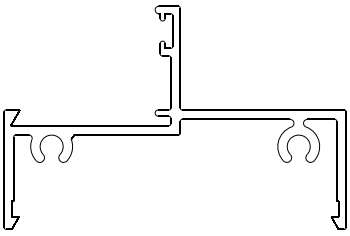
DIE No. W54329 Swift 28 Mullion 70mm



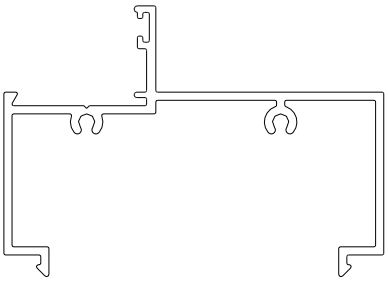
DIE No. W13142 Swift 28 Mullion 28mm Weather Bar



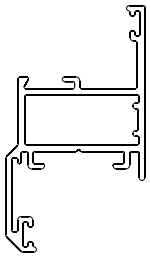
DIE No. W53283 Swift 28 Mullion 28mm Cottage Pane



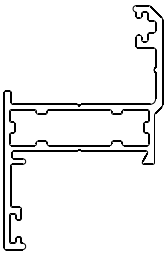
DIE No. W52007 Swift 28 Frame 54mm



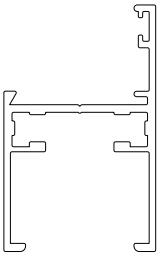
DIE No. W70963 Swift 28 Frame 70mm Sidelight



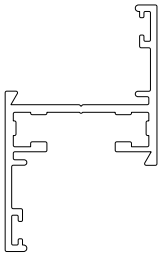
DIE No. W57496 Swift 28 Sash Multi Lock



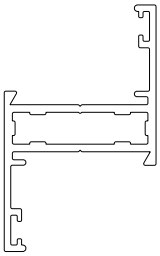
DIE No. W55497 Swift 28 Sash Picture Frame



DIE No. W32026 Swift 28 Frame 28mm Equal Leg



DIE No. W32025 Swift 28 Frame 28mm Unequal Leg



DIE No. W55682 Swift 28 Sash Tubular

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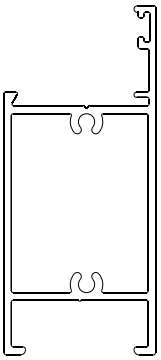
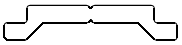
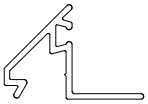


* DIE No. W57052 Swift 28 Sidelight Sill 65mm

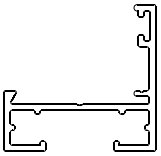
* DIE No. W32204 Swift 28 Compensating Head



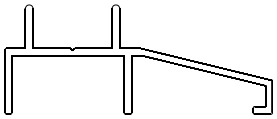
DIE No. W29131 Locking Bar



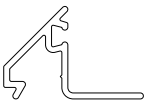
DIE No. W29697 Swift 28 Bead 12mm Gap



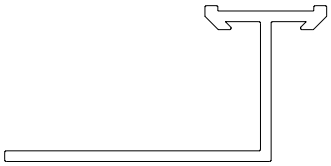
DIE No. W36832 Swift 28 Short Leg Frame



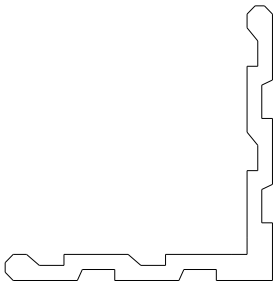
* DIE No. W32205 Swift 28 Sill Rail



DIE No. W31137 Swift 28 Bead 13mm Gap

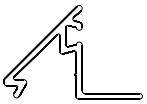


DIE No. W24052 Swift 28 Fixing Lug Twist In

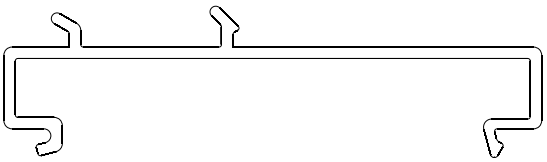


DIE No. W52695 Swift 28 Corner Cleat 50mm

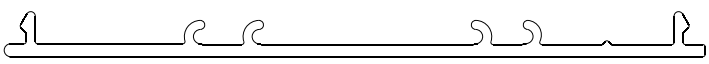
DIE No. W35487 Swift 28 Bead Multi Lock 13mm Gap



DIE No. W52693 Swift28 Bead 4mm



DIE No. W26780 Swift 28 Adaptor Sidelight



DIE No. W30607 Fixing Lug

** - Non-Stock Profile (Available from the Mill only)*

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Hardware Components

RECOMMENDED SWIFT 28 COMPONENTS

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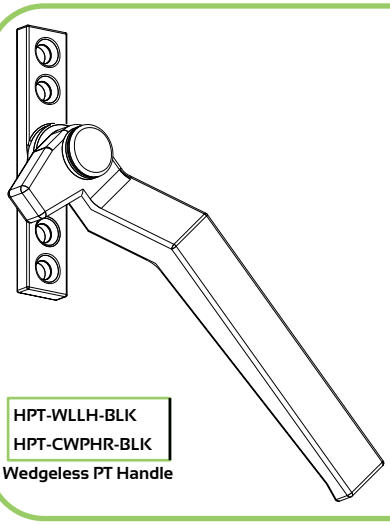
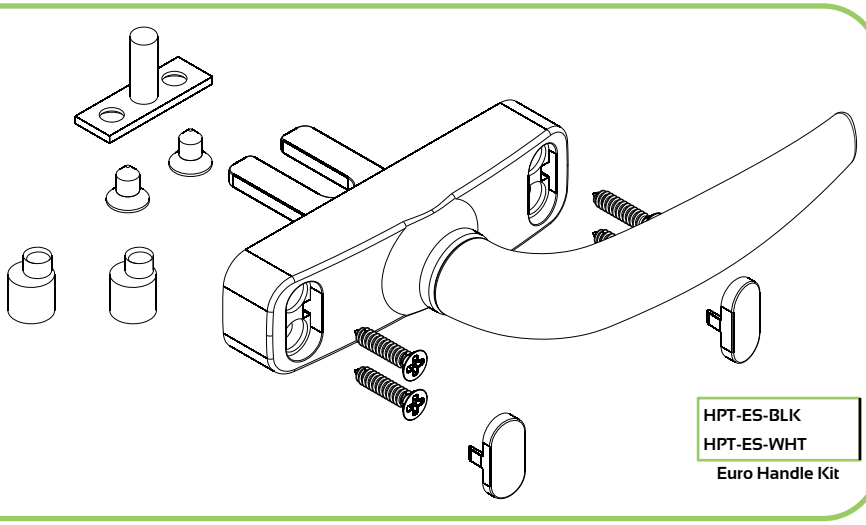
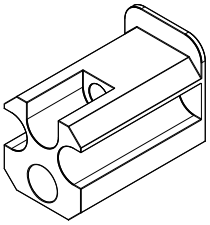


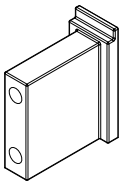
HPT-WLLH-BLK
HPT-CWPHR-BLK
Wedgeless PT Handle



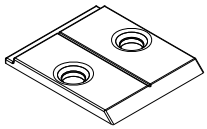
HPT-ES-BLK
HPT-ES-WHT
Euro Handle Kit



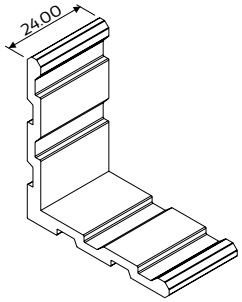
LGR-CC28R
Swift 28 Cross Connector PVC (Red)



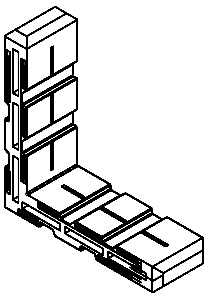
LGR-28CP
Swift 28 Cottage Pane Cross Connector 28mm (Black)



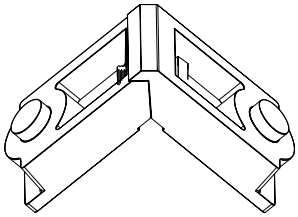
LGR-MP28R
Glazing Bar Packer (Red)



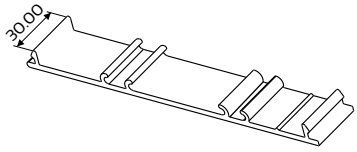
LGC-28-PVC or LGC-52695-28
Crealco Swift 28 Corner Cleat PVC or Crealco Swift 28 Corner Cleat



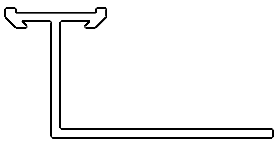
LGR-CCES
Euro Sash Corner Connector



LGC-J2410N
Joining Corner 24x10 Glass Filled Nylon



LGF-MULTI
Multi Fixing Lug Alum 15mm



LGF-TL28-24052
Crealco Swift 28 Twist Lug 11.5mm

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Hardware Components

RECOMMENDED SWIFT 28 COMPONENTS

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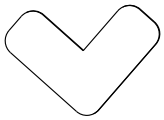
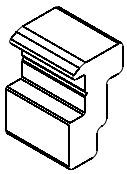
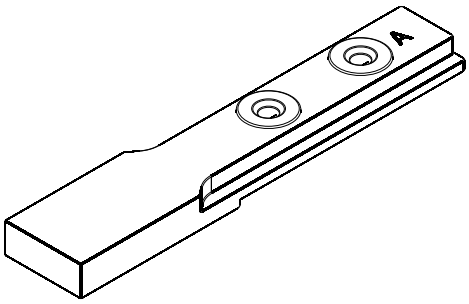


SGD-FMG520
Alignment Mitre Corner

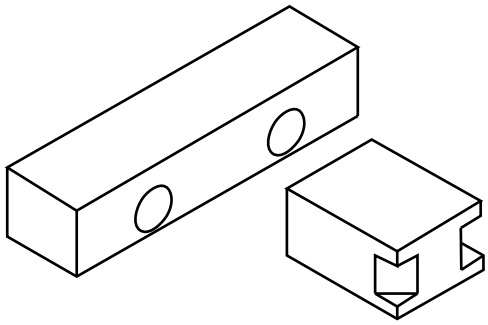
SGD-FM48
Frame Mitre Guide



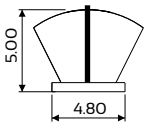
HPT-ESS
Euro Sash Spacer



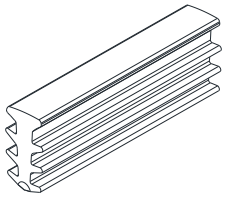
TLP-CJ
Crealco Swift Jig



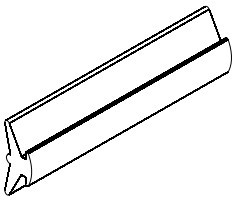
TLP-CT28
Crealco Swift 28 Crimp Tool



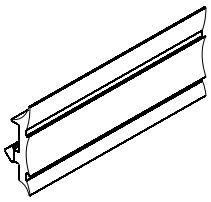
GFP-4850
Finpile



GWG-01G
GWG-02B
GWG-03R
GWG-04Y
GWG-05P
Wedge Gasket



GSL-AL-H602
Y Seal Gasket



GBF-ORG
Butterfly Gasket

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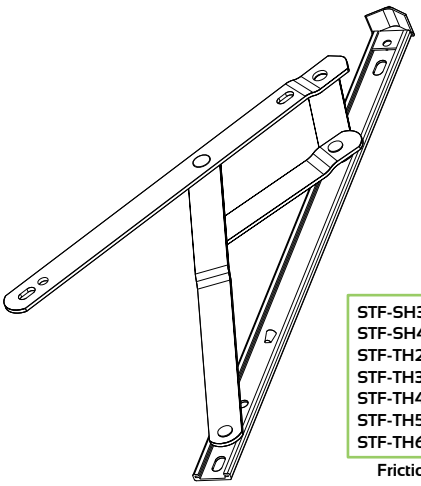
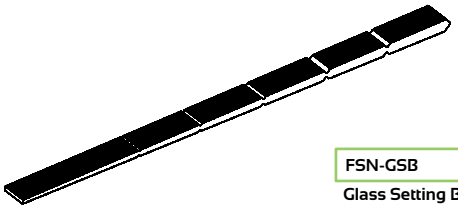
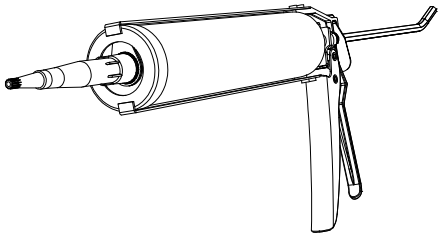


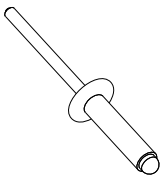
STF-SH300S-304
STF-SH400S-304
STF-TH200S-304
STF-TH300R-304
STF-TH400S-304
STF-TH500S-304
STF-TH600S-304
Friction Stay



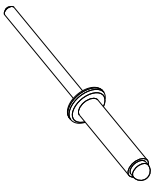
FSN-GSB
Glass Setting Blocks



Crealco Silicone Tube

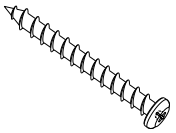


FRC-410
C/Sunk Rivet

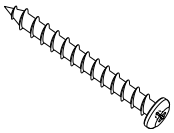


FRD-4810
Dome Rivet 1.8x10

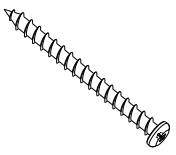
FSC-0809HBP
Handle Screw -
Blunt Point 8x9 C/S



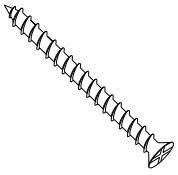
NON STOCK ITEM
P/Head POSI
4x30 S/S Screw



FSP-0830P-SS
P/Head POSI
8x30 S/S Screw



FSP-0630P-SS
P/Head POSI
6x30 S/S Screw



FSC-0840P-SS
Countersunk POSI
8x40 S/S Screw

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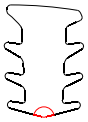
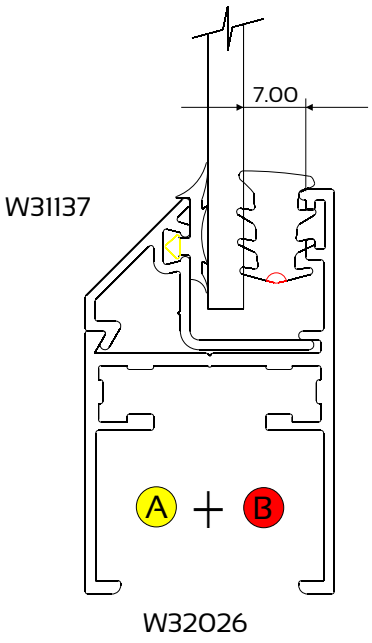
Butterfly Gasket & Wedge Codes

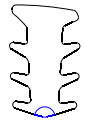
Butterfly Gasket
A GBF-ORG



Wedge Gasket
B GWG-03R

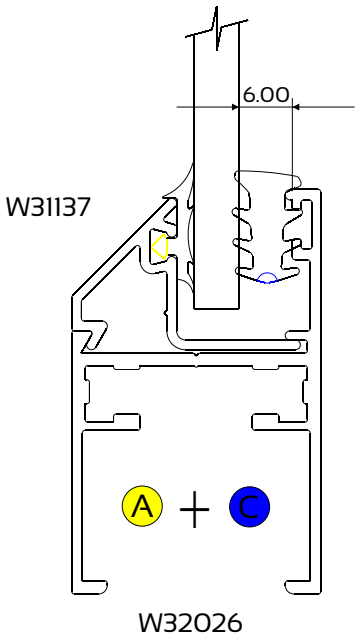
4mm Glass

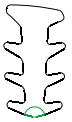




Wedge Gasket
C GWG-02B

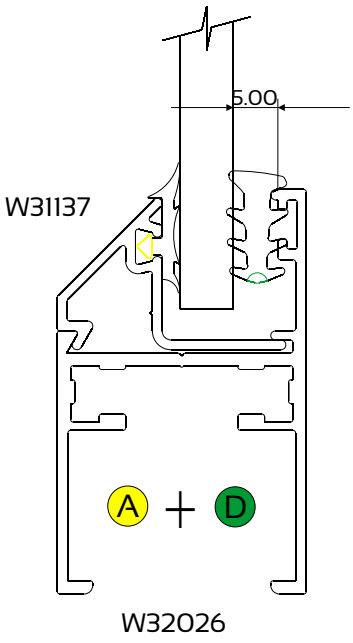
5mm Glass





Wedge Gasket
D GWG-01G

6 & 6.38mm Glass



Wedge Gasket Chart

Code	Description	Wedge Gap To Fit
GWG-01G	Wedge 01 Green 6mm & 6.38mm Glass	4.10mm To 5.50mm
GWG-02B	Wedge 02 Blue 5mm Glass	5.60mm To 6.70mm
GWG-03R	Wedge 03 Red 4mm Glass	6.80mm To 7.50mm
GWG-05P	Wedge 01 Purple 20mm Double Glazing	7.60mm To 8.80mm

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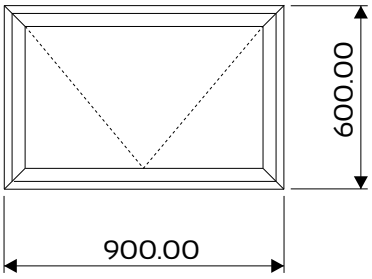
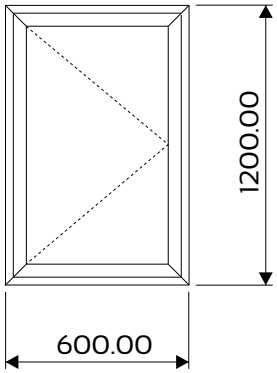
Sash Limitation Guide

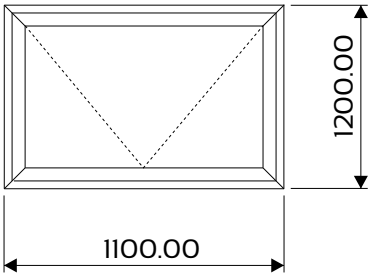
The sash limitations of the system are strictly calculated in accordance to AAMSA guidelines and take into account the aluminium specifications as well as the glass used. Please ensure that these are adhered to as any product produced outside of these limitations will not adhere to AAMSA regulations.

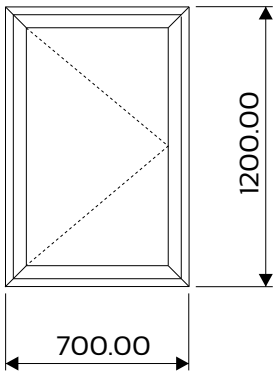
STANDARD SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W55682	900	600
Side Hung		600	1200





MULTI LOCK SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W57496	1100	1200
Side Hung		700	1200





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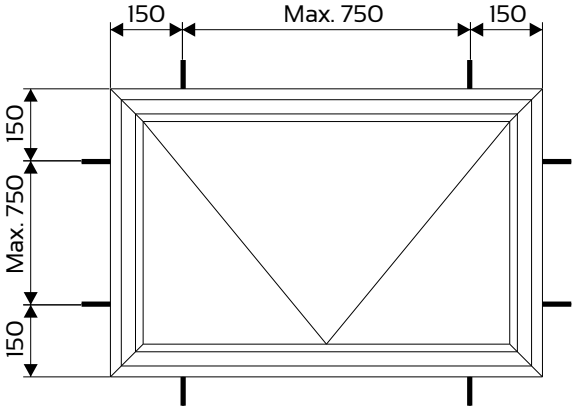
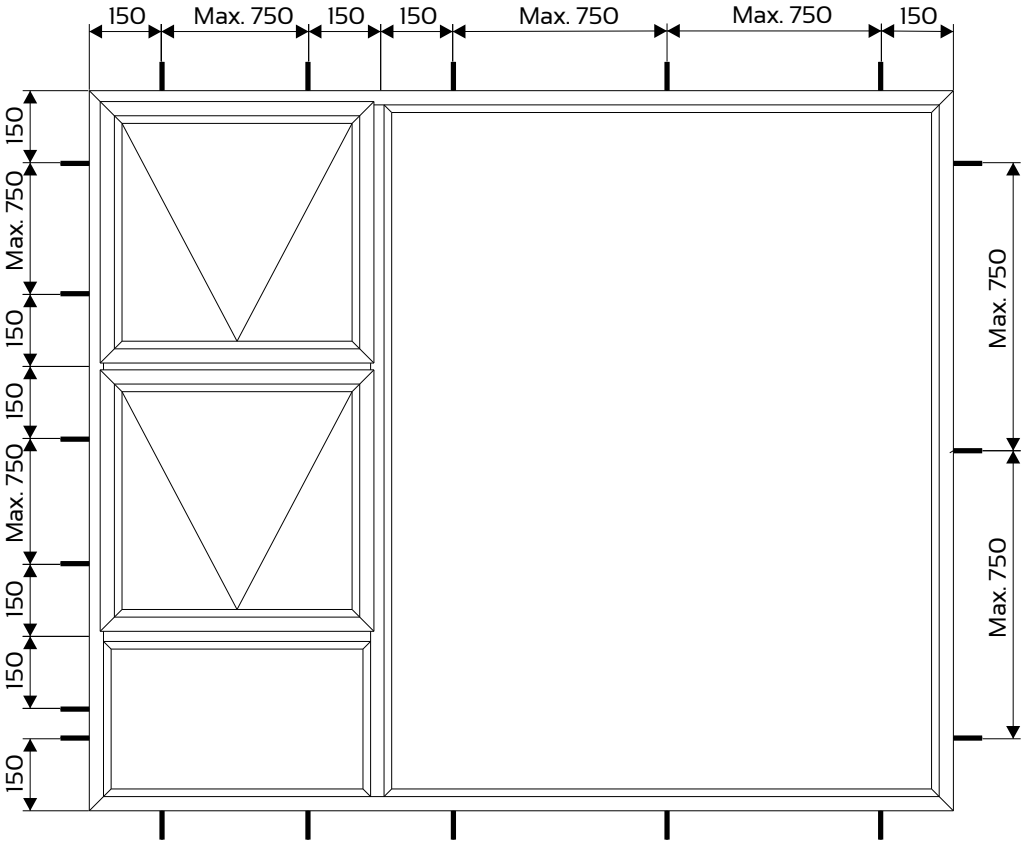
Typical Fastening Positions

IMPORTANT:
As there are many different methods of fixing the window to the structure, the illustration below is a general fixation detail. The illustration defines the general method and hole fixing. Before installation or machining of the holes, please ensure that you have checked the required fixing method with the appropriated building engineer and that your chosen methods meets their specifications

Failure to fix the window to correct building or engineer specifications will result in the door not meeting the required specifications.

DISCLAIMER: Please note that fixation of the frame to the structure is an element which MUST be specified and certified by an appropriate engineer and is not the responsibility of Wispeco.





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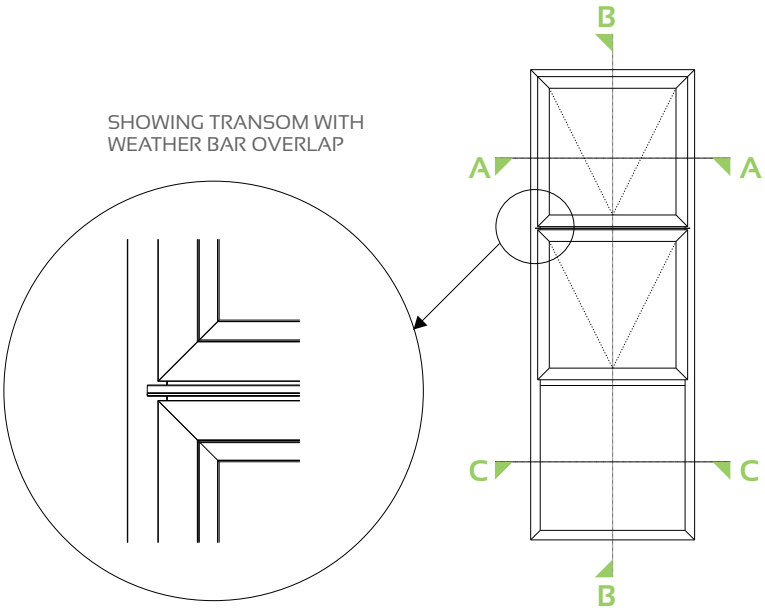
Typical Cross-Sectional Details

Double Top Hung Over Fixed



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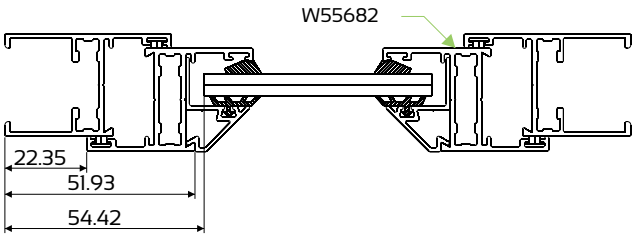

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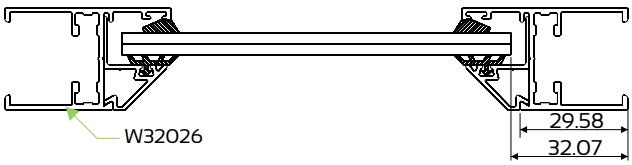

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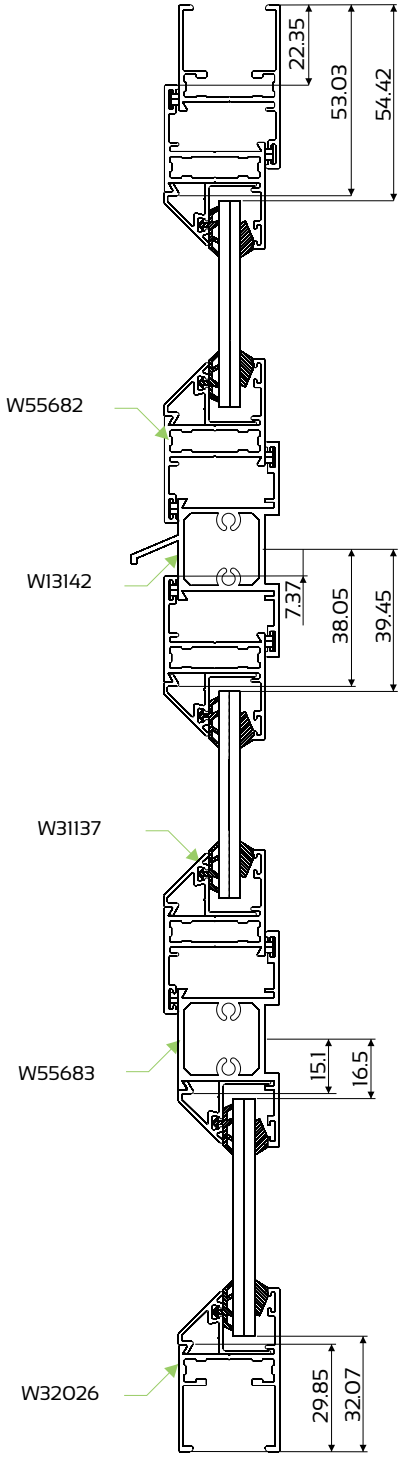

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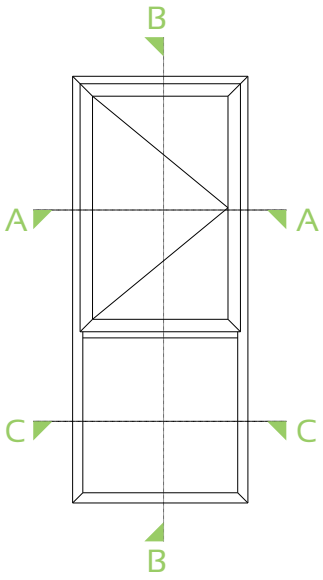
Typical Cross-Sectional Details

Side Hung Over Fixed



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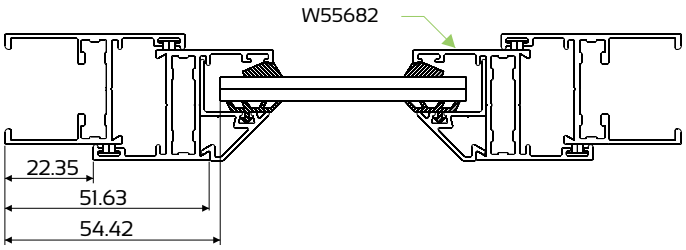

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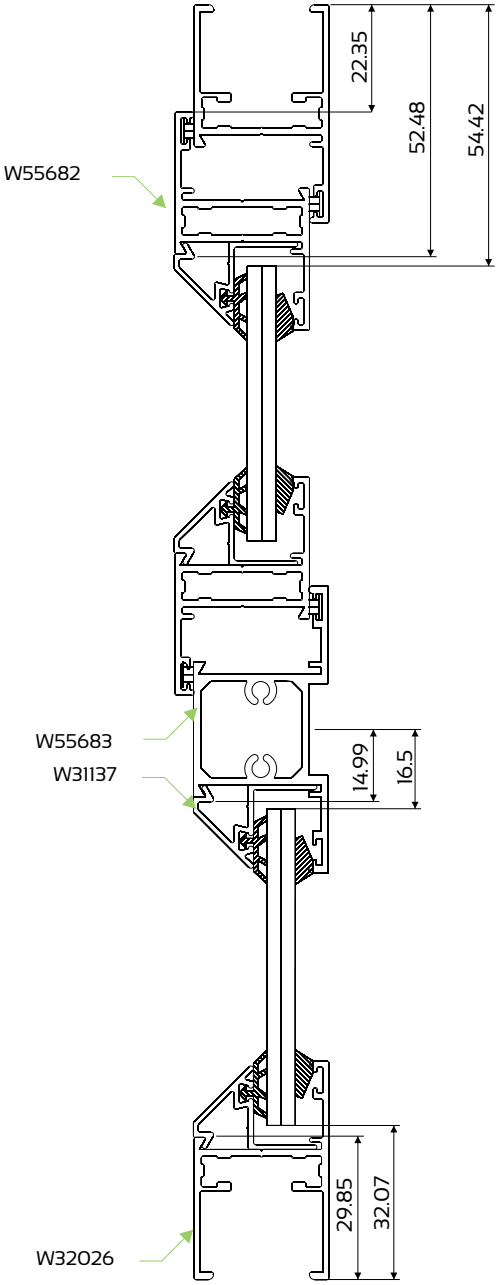

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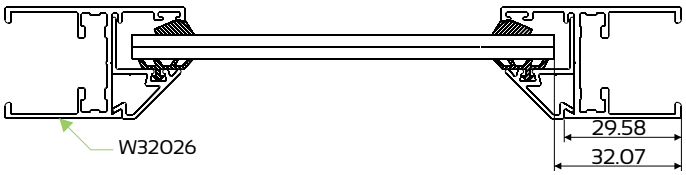

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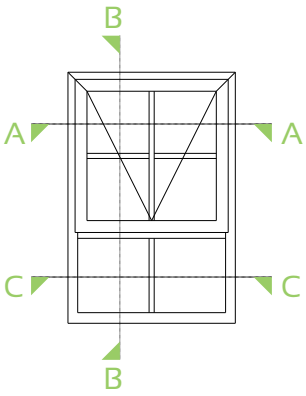
Typical Cross-Sectional Details

Cottage Pane 2x2 Top Hung Over 2x1 Fixed Panel



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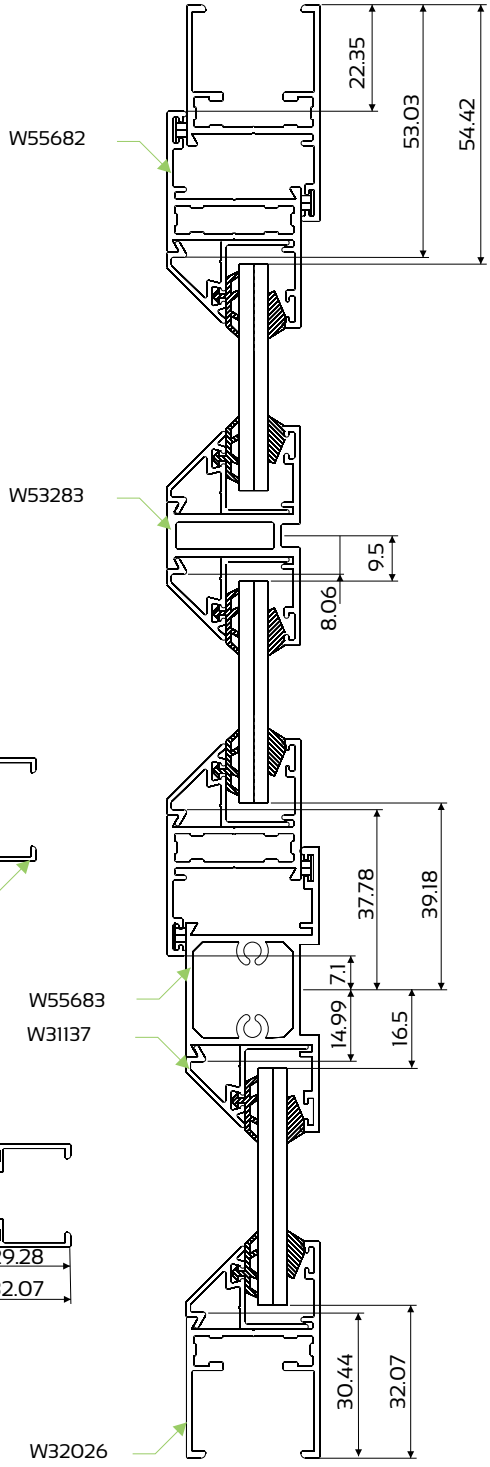

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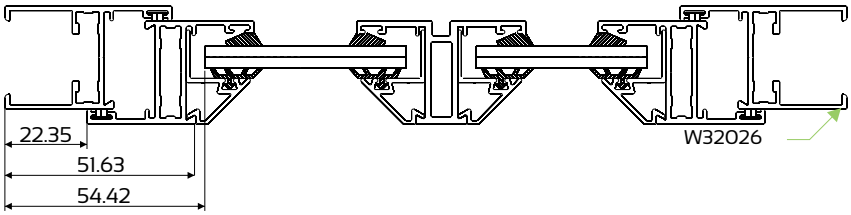

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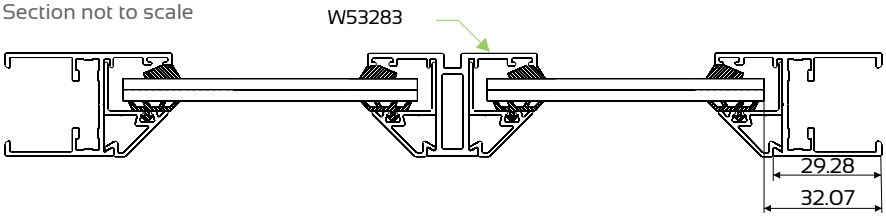

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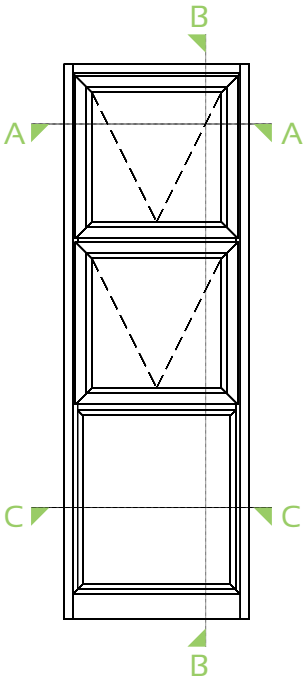
Typical Cross-Sectional Details

Clip 44 with Short Leg Outer Frame Double Top Hung over Fixed



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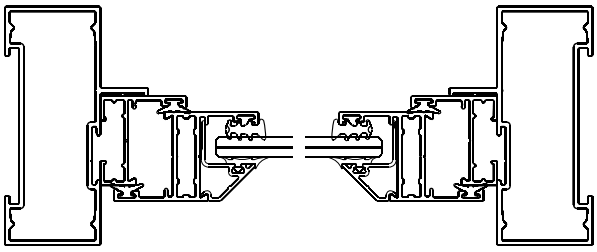

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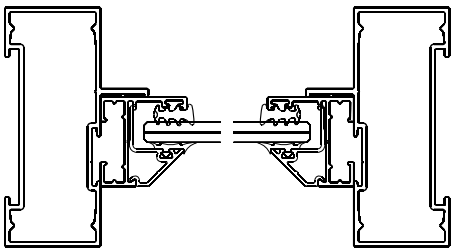

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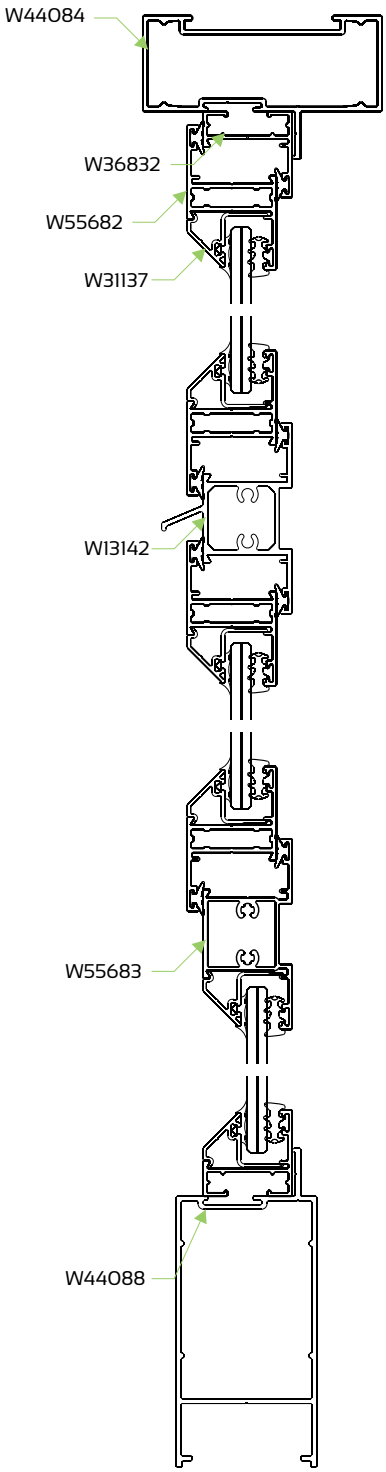

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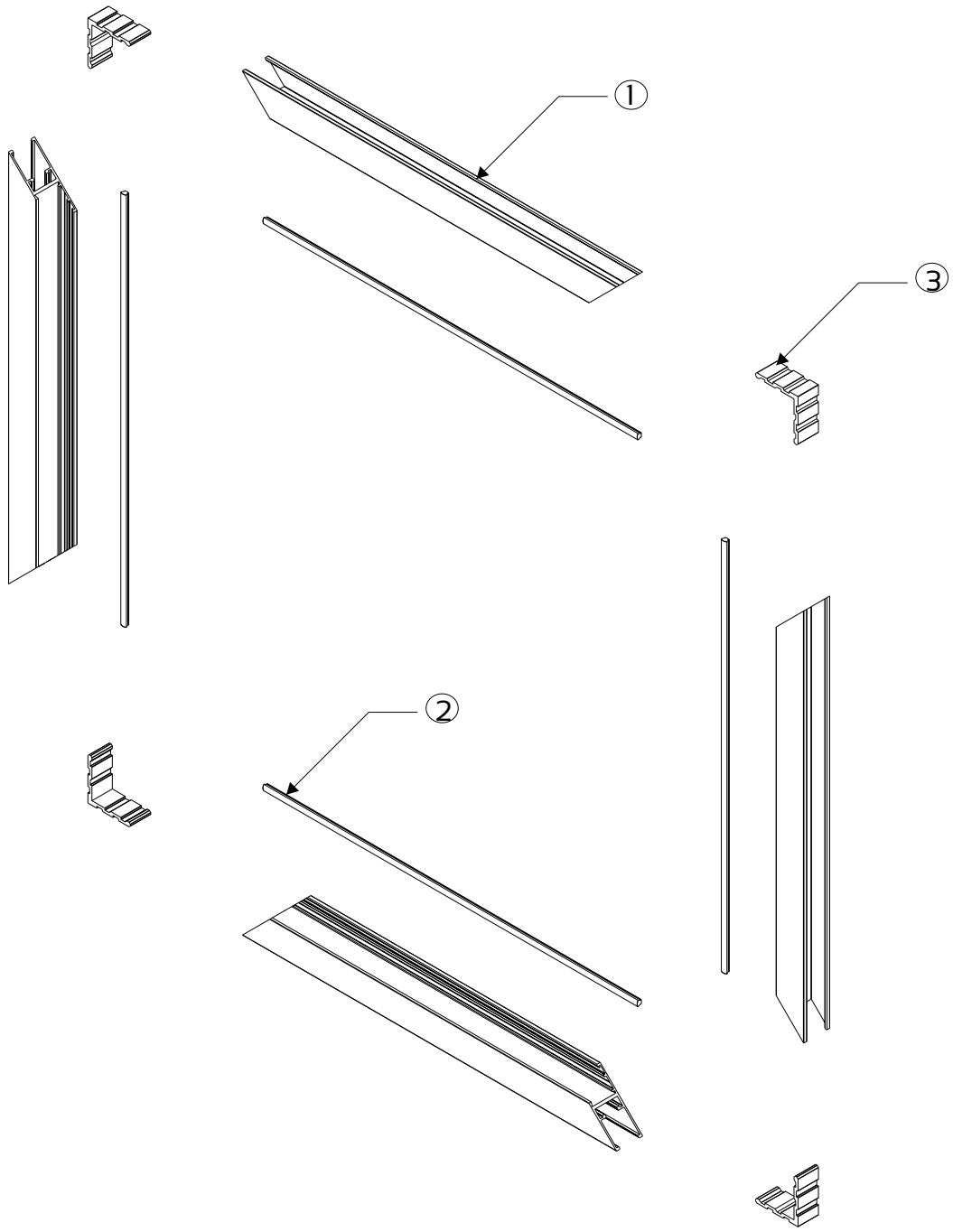
Typical Outer Frame Construction



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W32026	Swift 28 Frame 28mm Equal Leg Std

Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Finpile	Finpile
3	4	Corner Cleat	Swift 28 Corner Cleat 50mm

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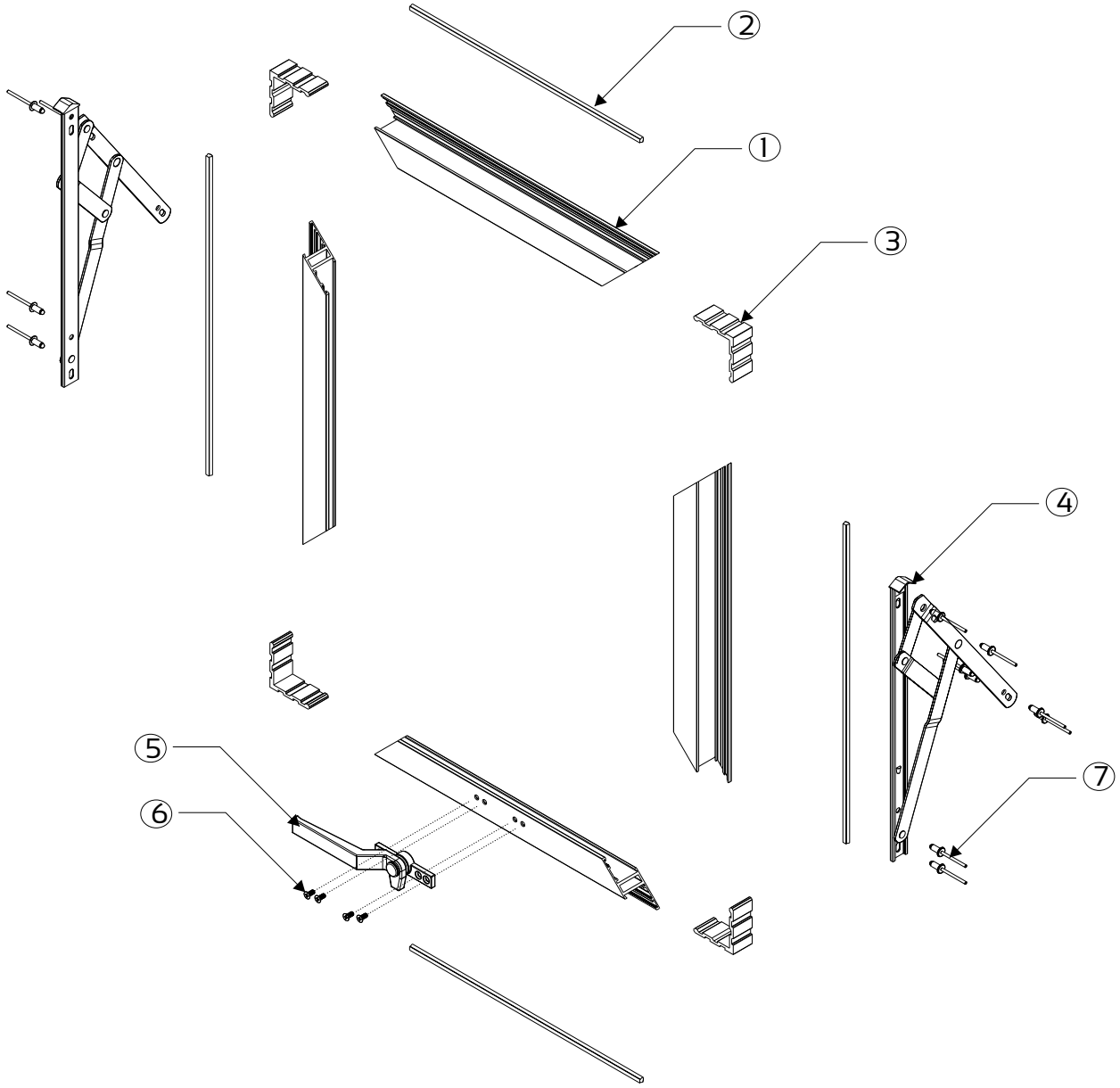
Typical Sash Frame Construction



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W55682	Swift 28 Sash Std

Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Finpile	Finpile
3	4	Corner Cleat	Swift 28 Corner Cleat 50mm
4	2	Friction Stay	Friction Stay
5	1	Handle	Euroline PT Handle
6	4	Screw	Handle Screw Blunt Point
7	12	Pop Rivet	Dome Rivet

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Typical Outer Frame Machining Details

Equal Leg

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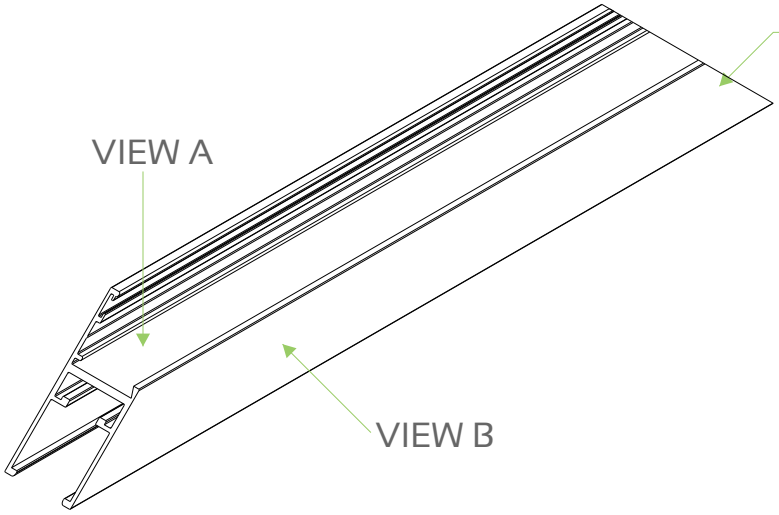

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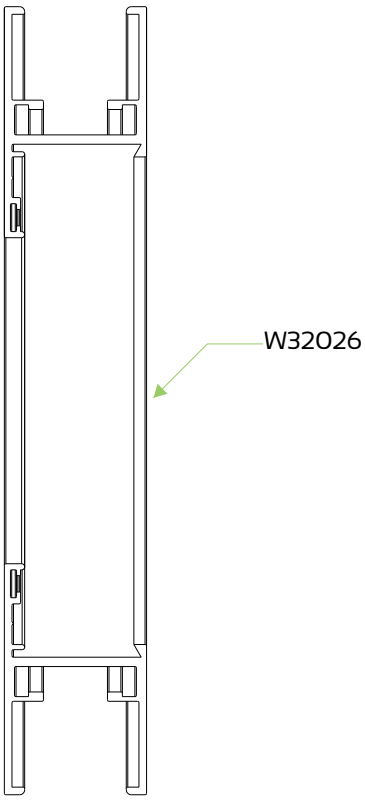

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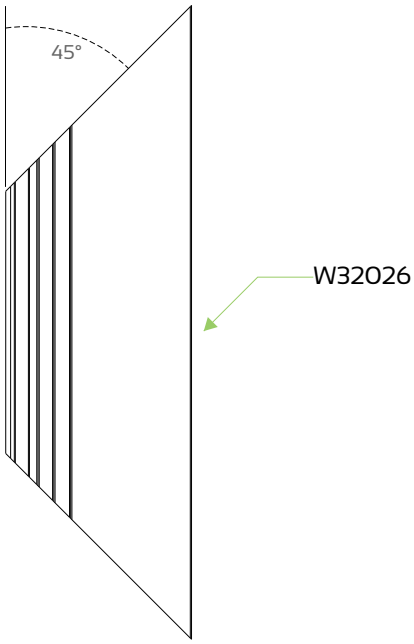

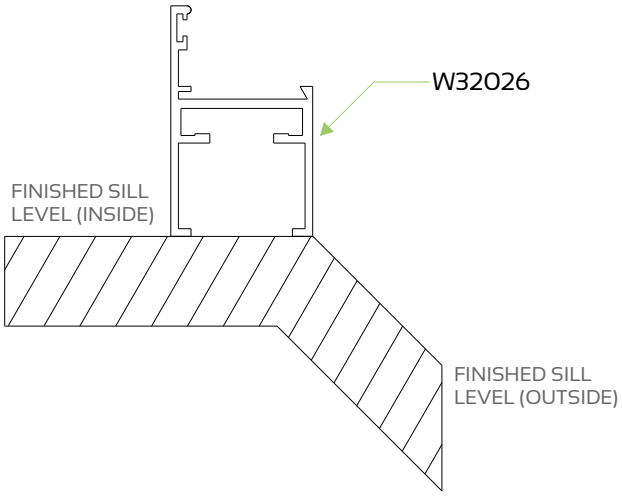

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Typical Outer Frame Machining Details

Unequal Leg

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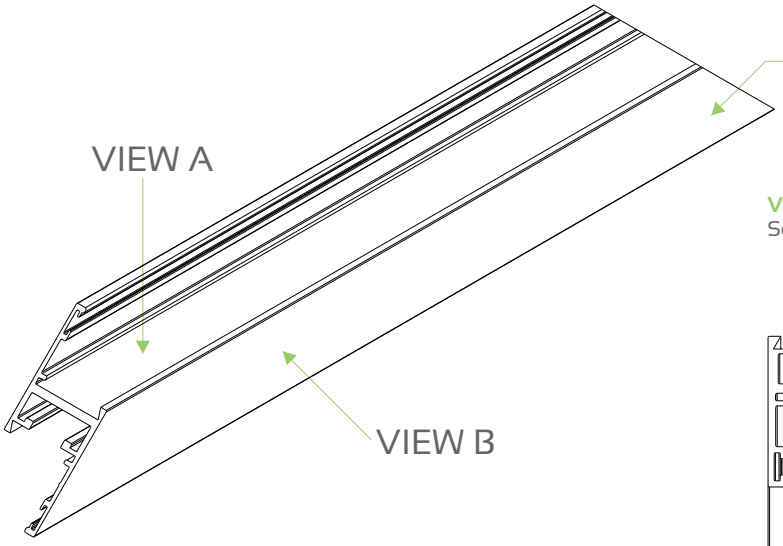

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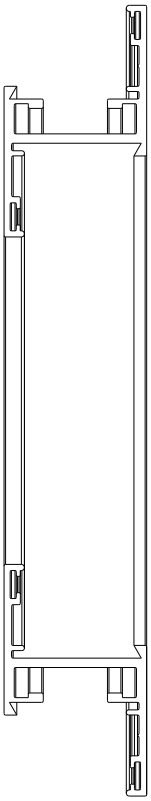

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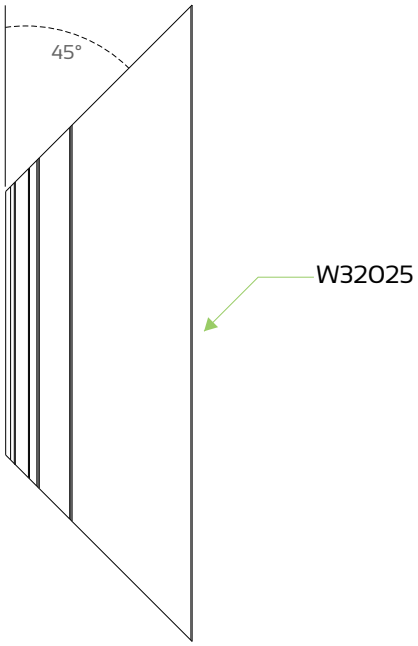

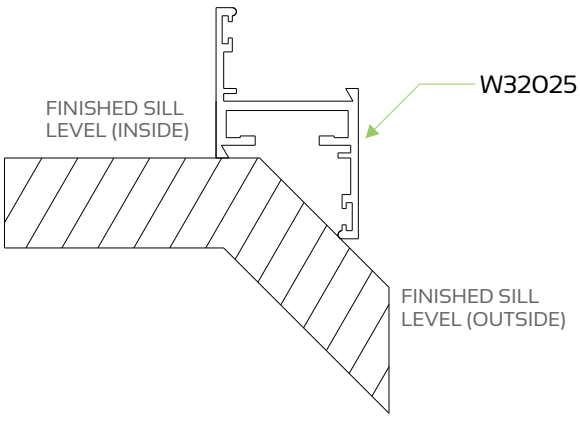

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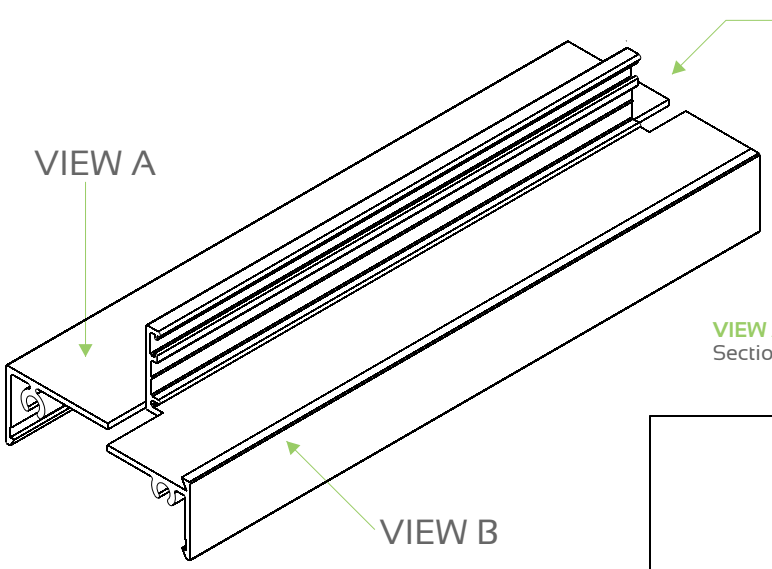
Typical Outer Frame Machining Details

54mm

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



VIEW A-A
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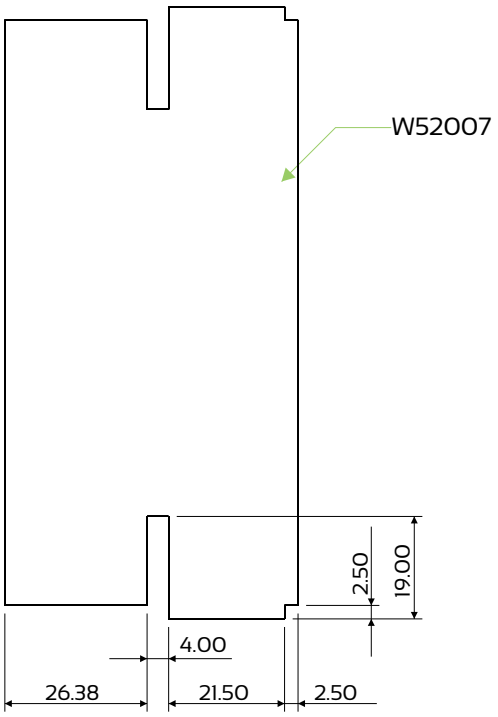

VIEW B-B
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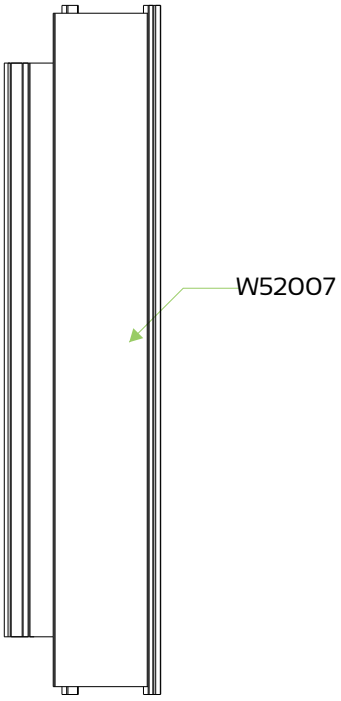

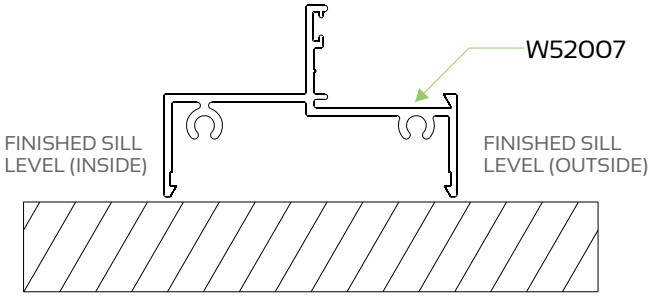

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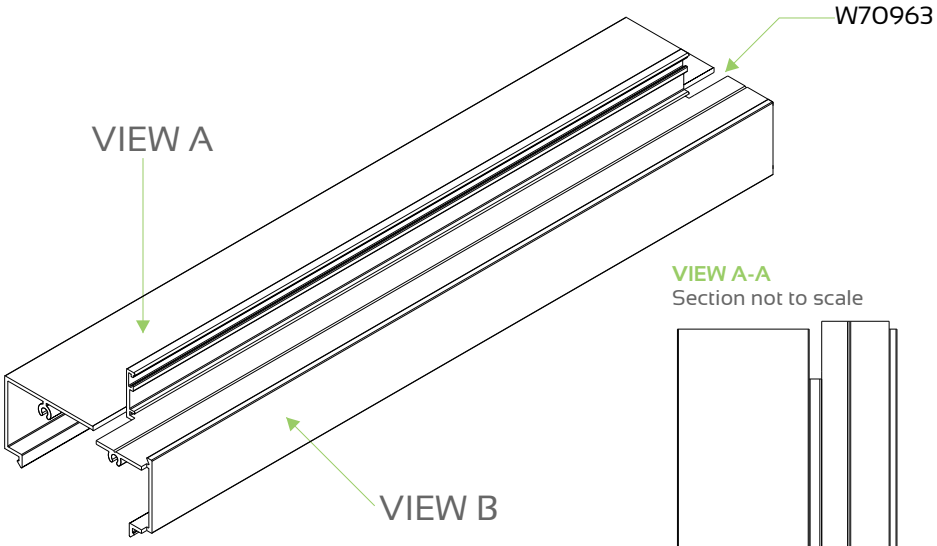
Typical Outer Frame Machining Details

70mm

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



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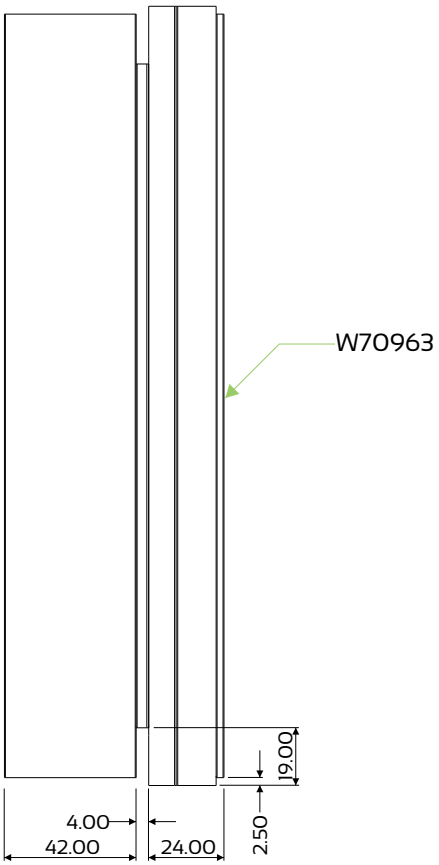
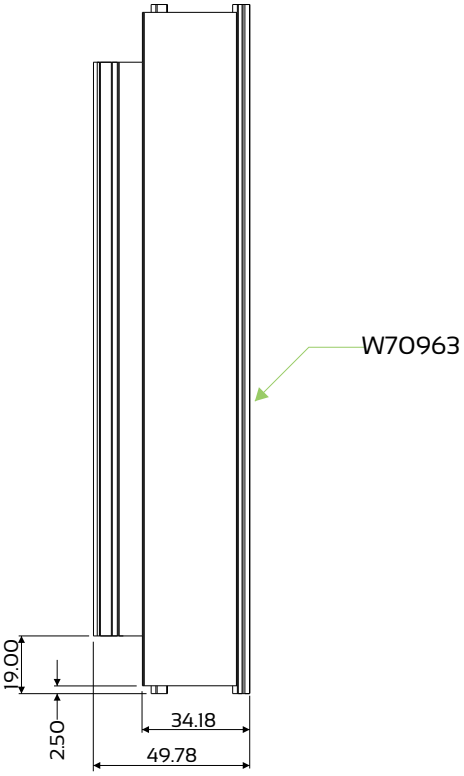
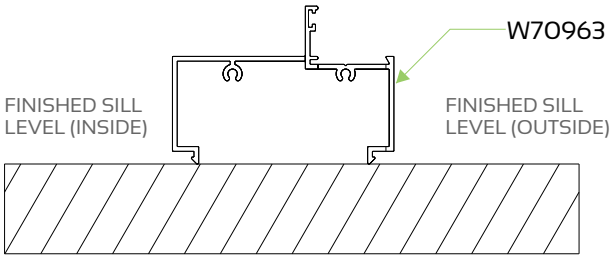


VIEW B-B
Section not to scale





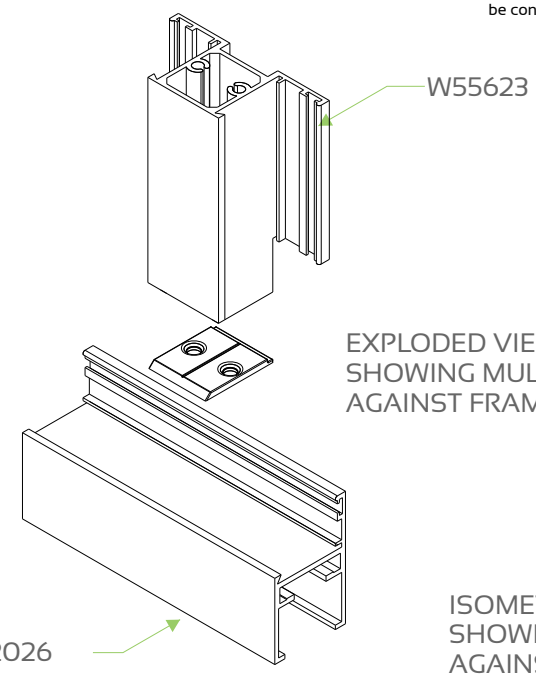
crealco

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

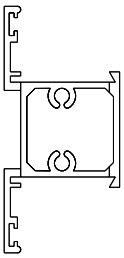
Typical Mullion Machining Details

Standard Machining Detail for End Milling on Equal Leg Outer Frame

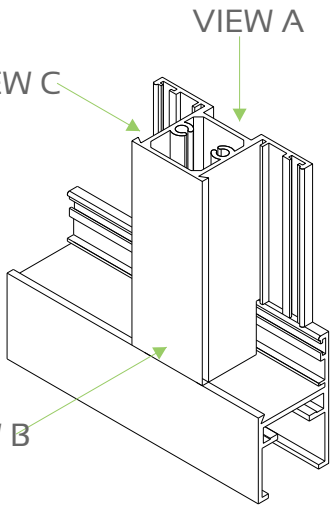
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



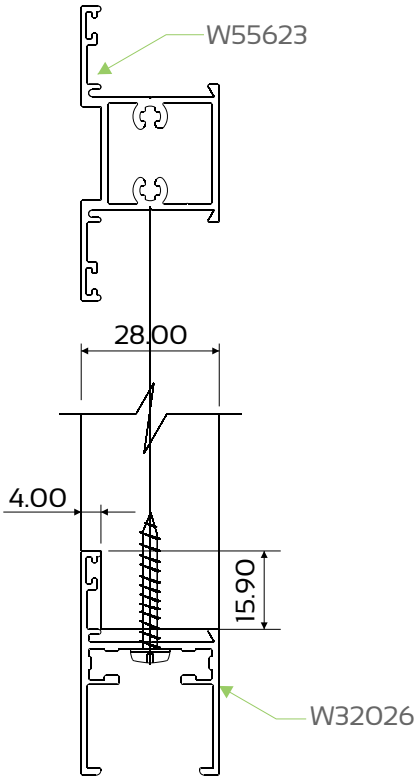
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



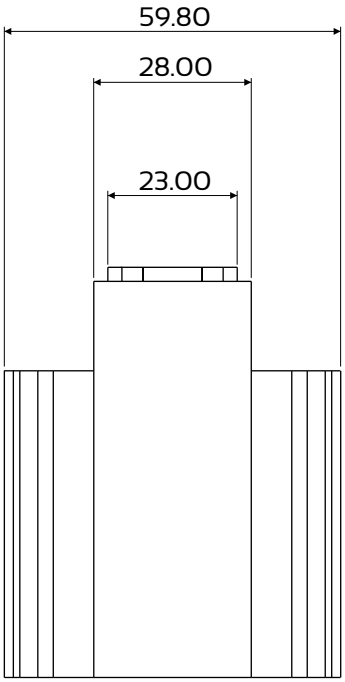
VIEW A-A
Standard Mullion
W55623



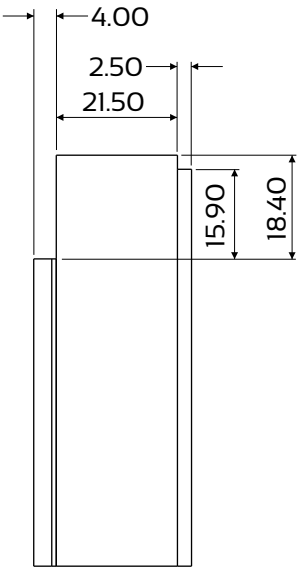
ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



Alternative Machining Detail
for Mullions



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

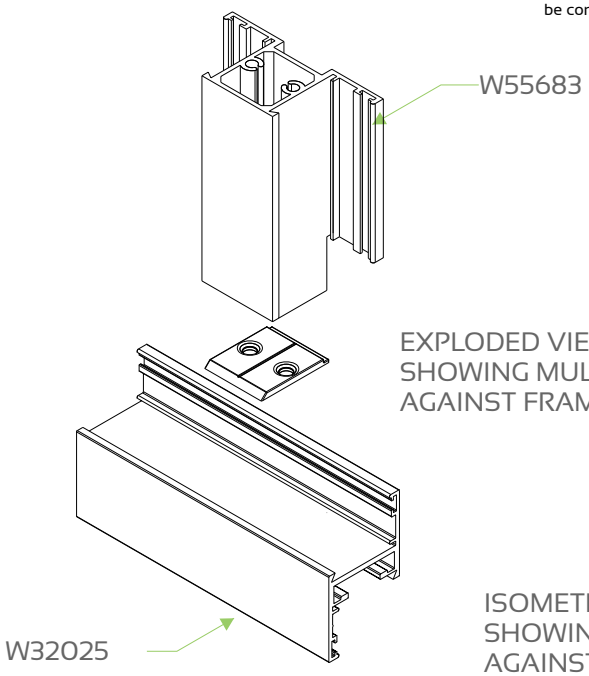
crealco

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

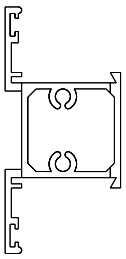
Typical Mullion Machining Details

Standard Machining Detail for End Milling on Unequal Leg Outer Frame

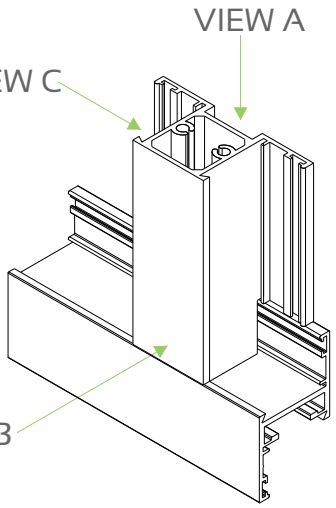
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



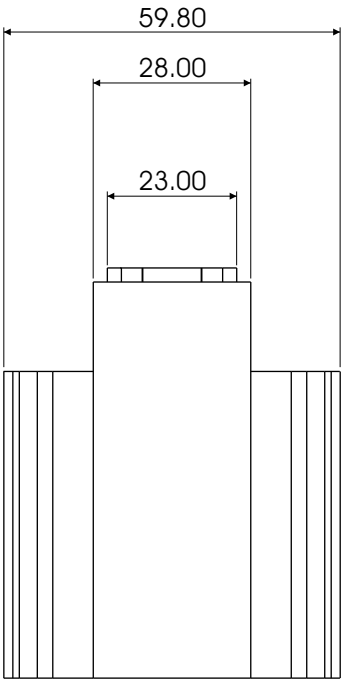
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



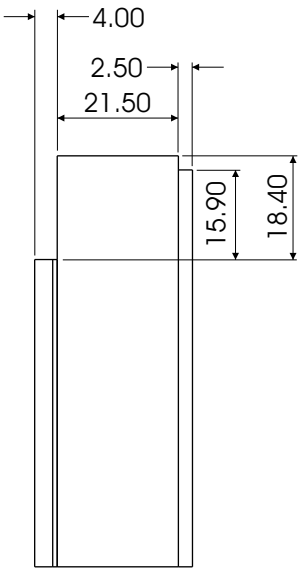
VIEW A-A
Standard Mullion
W55683



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



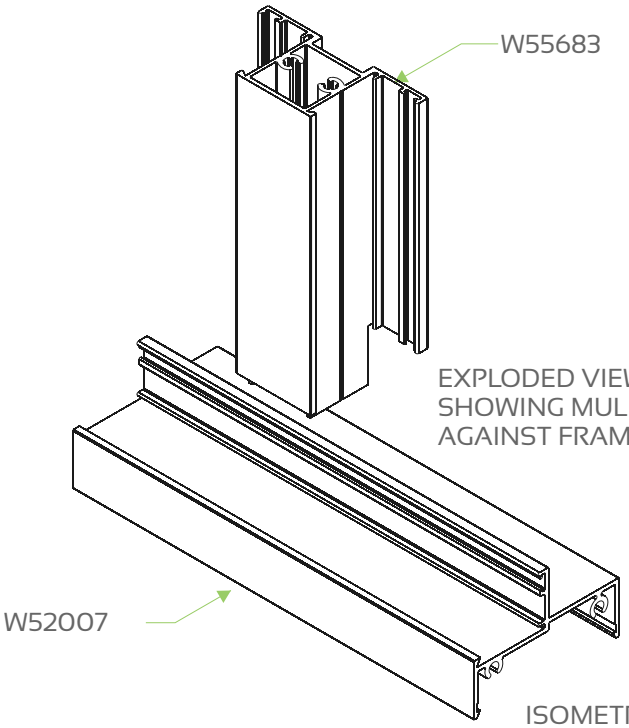
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

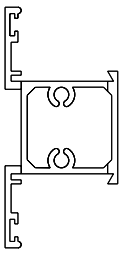
Typical Mullion Machining Details

Standard Machining Detail for End Milling on 54mm Outer Frame

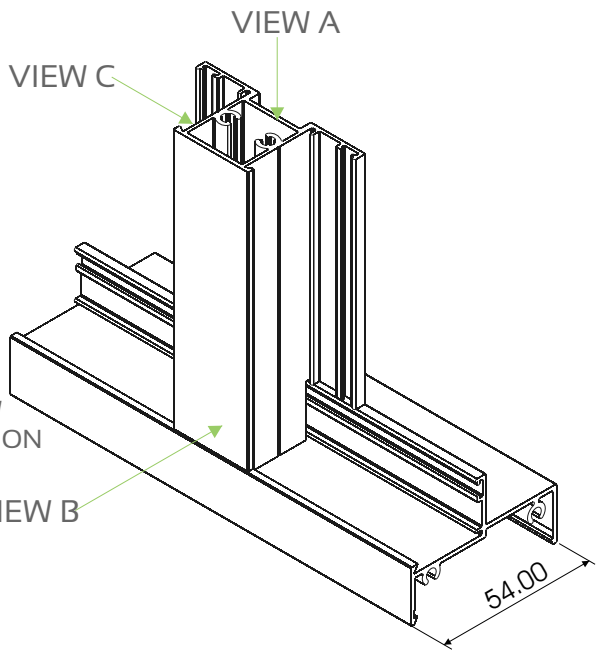
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



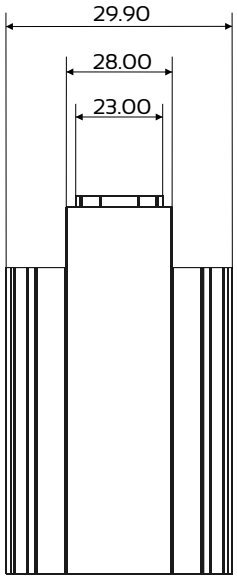
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



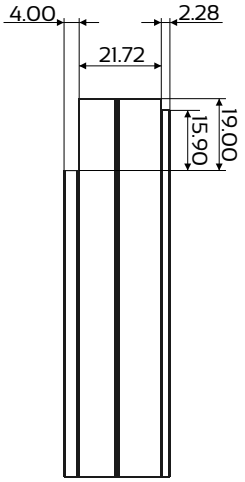
VIEW A-A
Standard Mullion
W55683



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



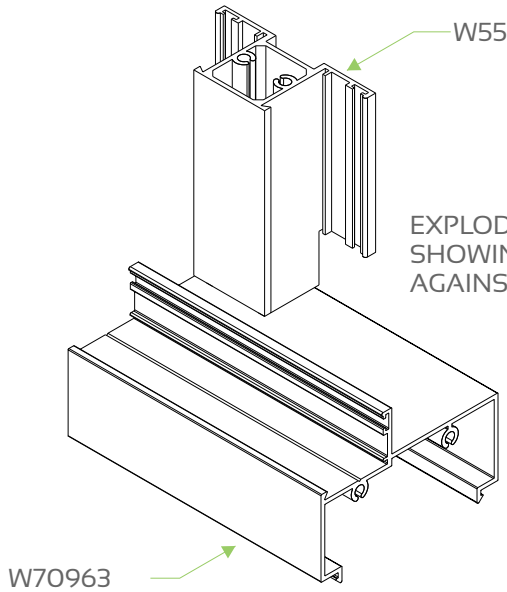
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

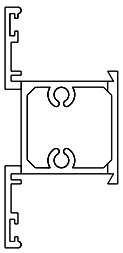
Typical Mullion Machining Details

Standard Machining Detail for End Milling on 70mm Outer Frame

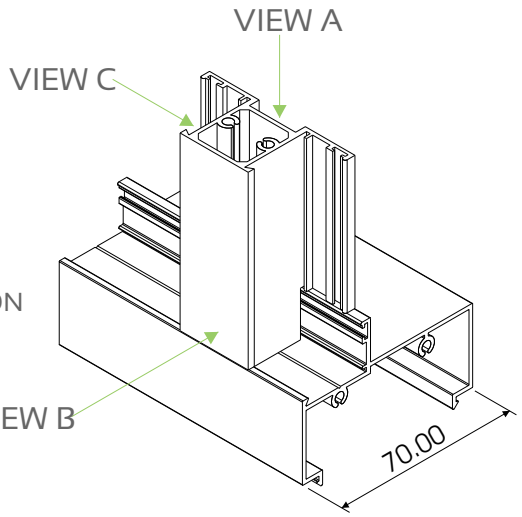
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



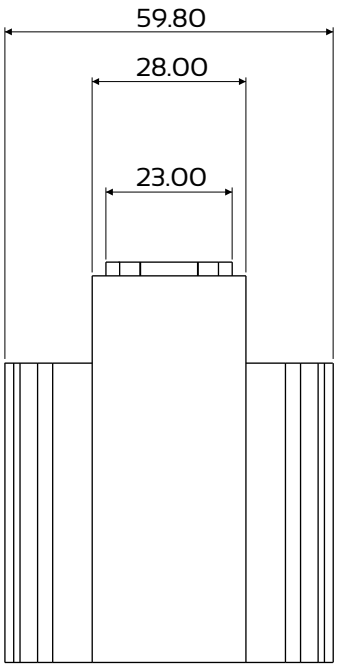
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



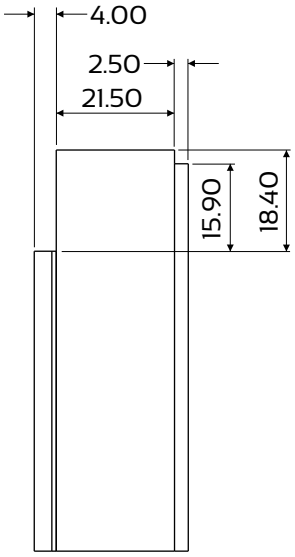
VIEW A-A
Standard Mullion
W55683



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



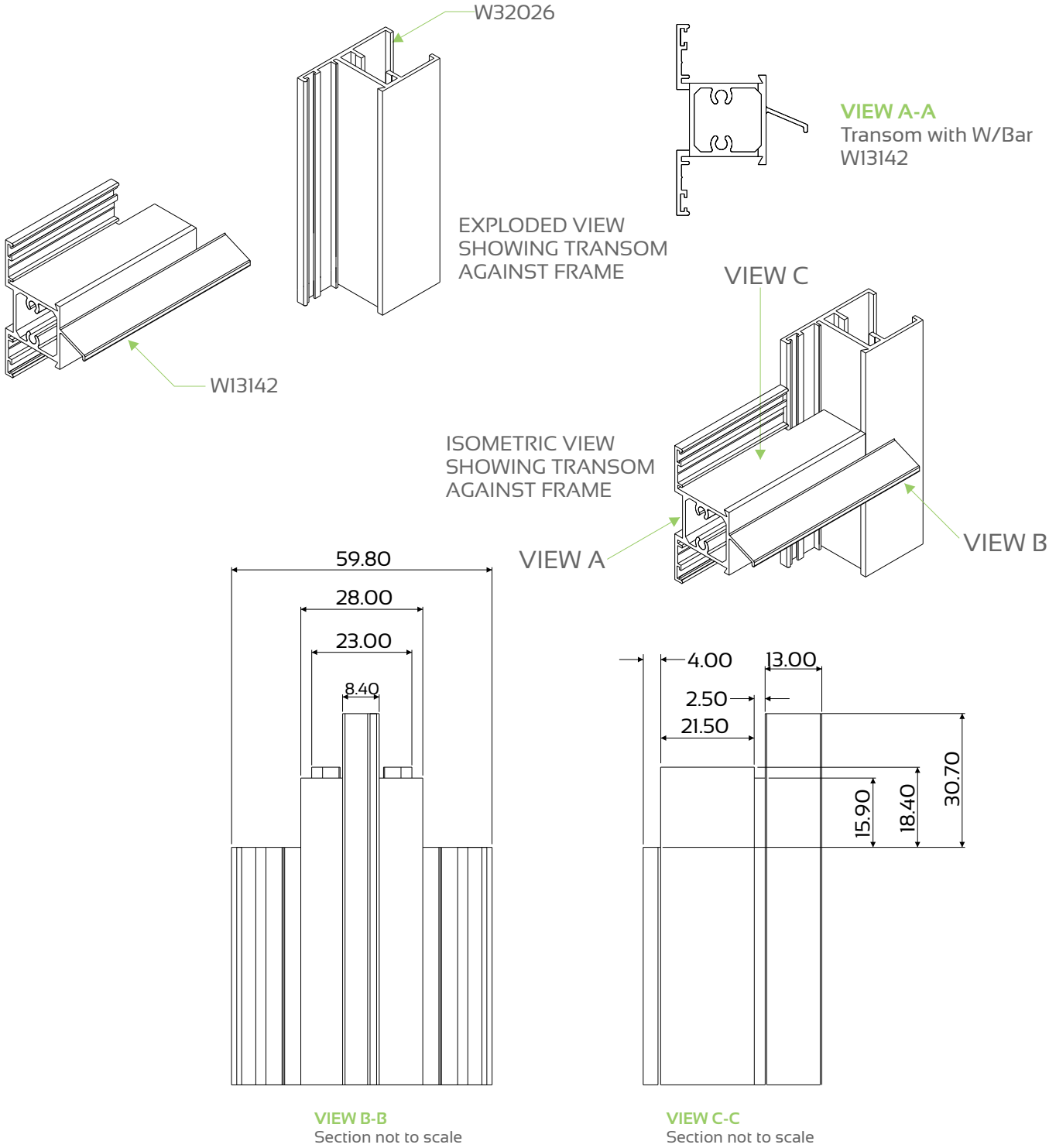
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Transom with W/Bar Machining Detail

for End Milling on Equal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



VIEW B-B
Section not to scale

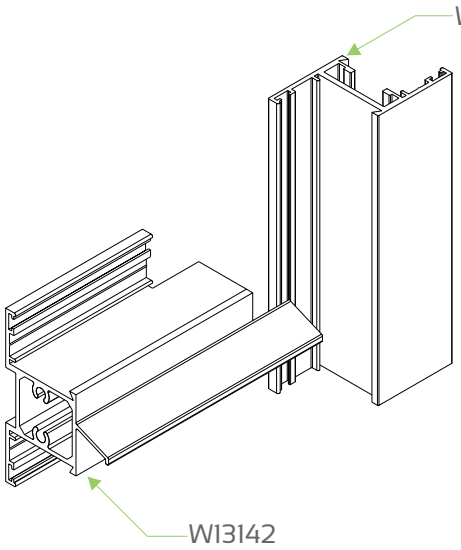
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

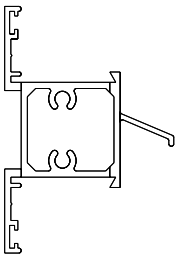
Typical Transom with W/Bar Machining Detail

for End Milling on Unequal Leg Outer Frame

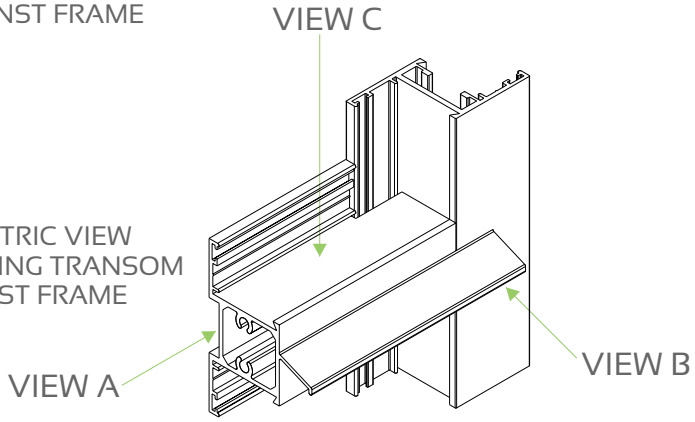
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



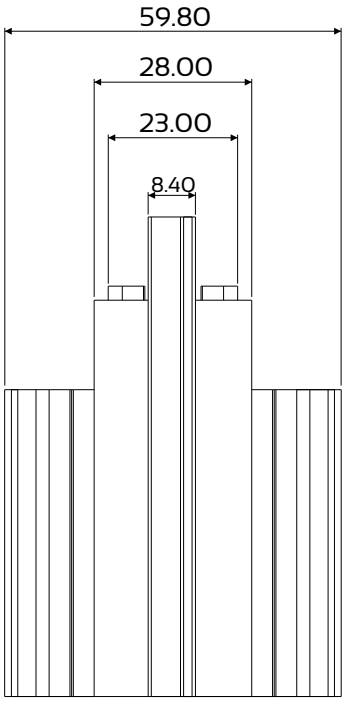
EXPLODED VIEW
SHOWING TRANSOM
AGAINST FRAME



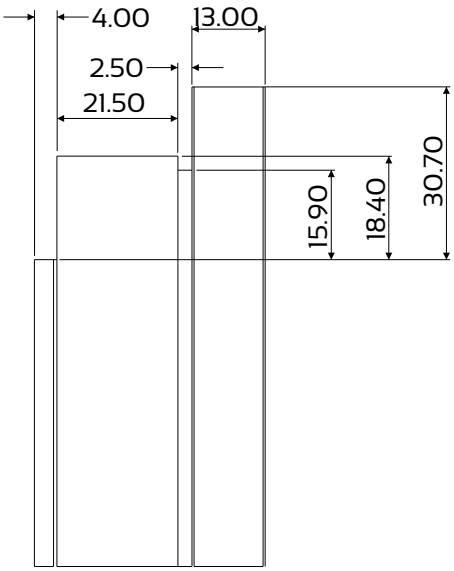
VIEW A-A
Transom with W/Bar
W13142



ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

crealco

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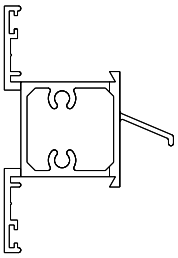
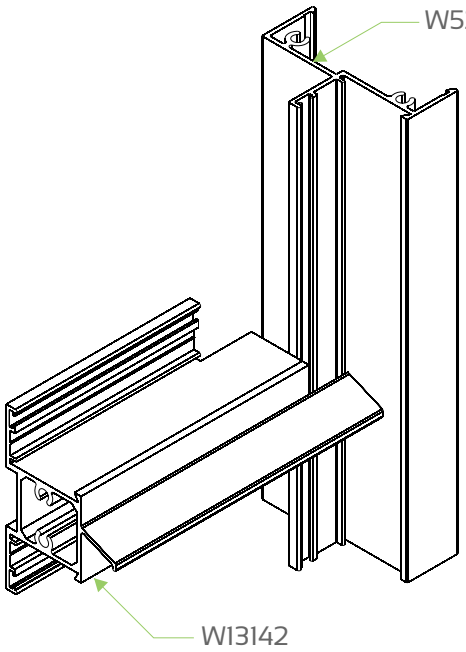
Typical Transom with W/Bar Machining Detail

for End Milling on 54mm Outer Frame

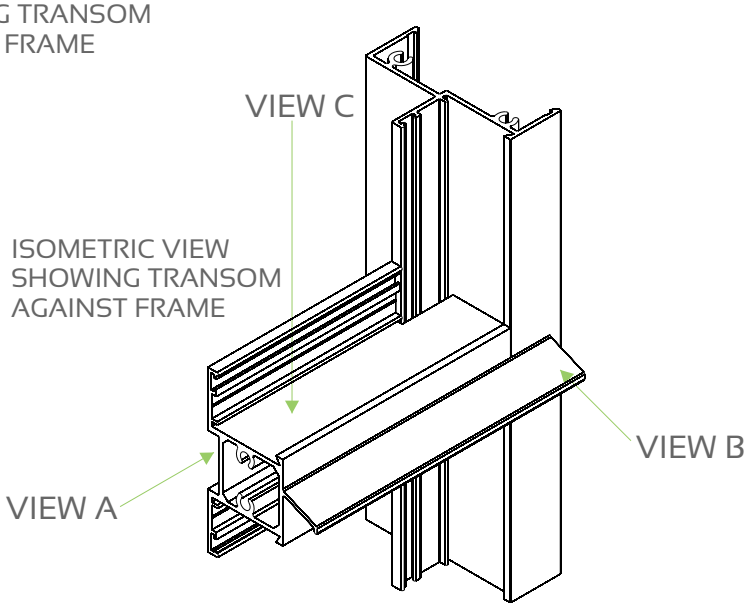
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



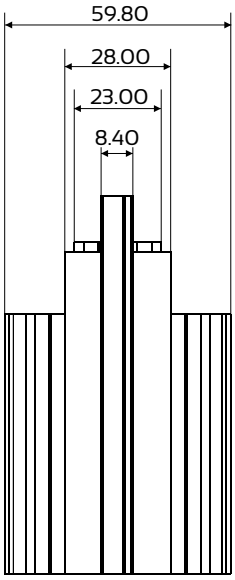
VIEW A-A
Transom with W/Bar
W13142



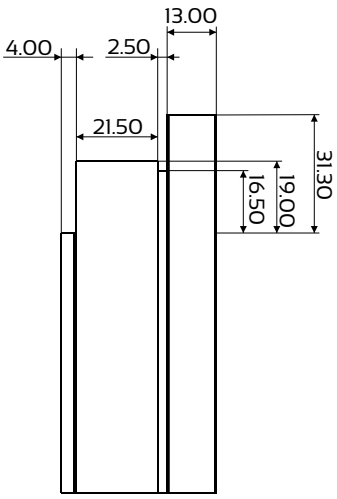
EXPLODED VIEW
SHOWING TRANSOM
AGAINST FRAME



ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

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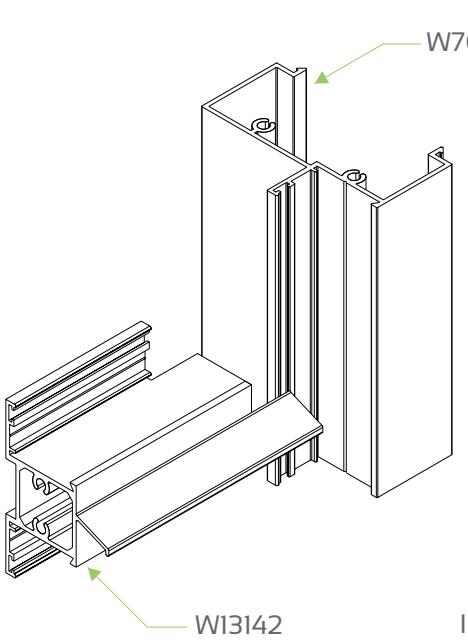
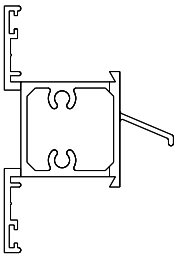
Typical Transom with W/Bar Machining Detail

for End Milling on 70mm Outer Frame

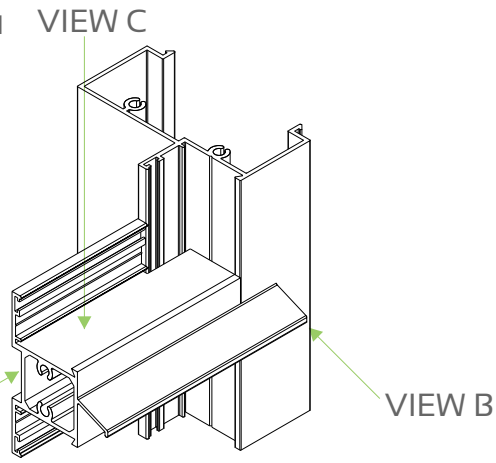
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



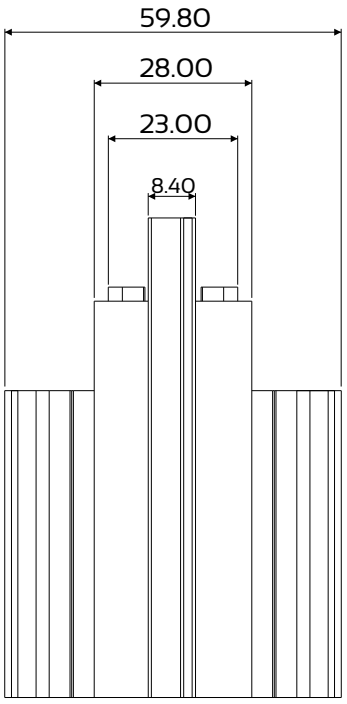
EXPLODED VIEW
SHOWING TRANSOM
AGAINST FRAME



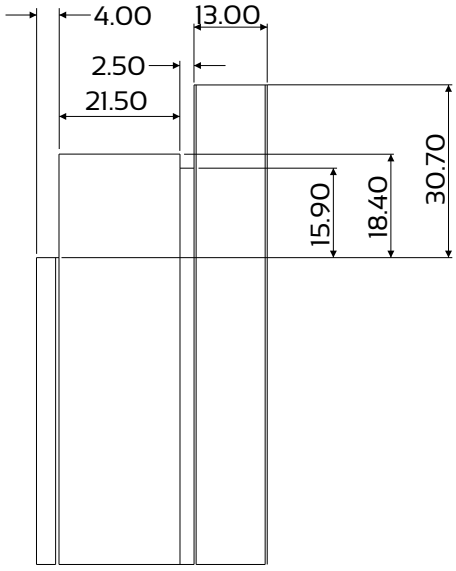
VIEW A-A
Transom with W/Bar
W13142



ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

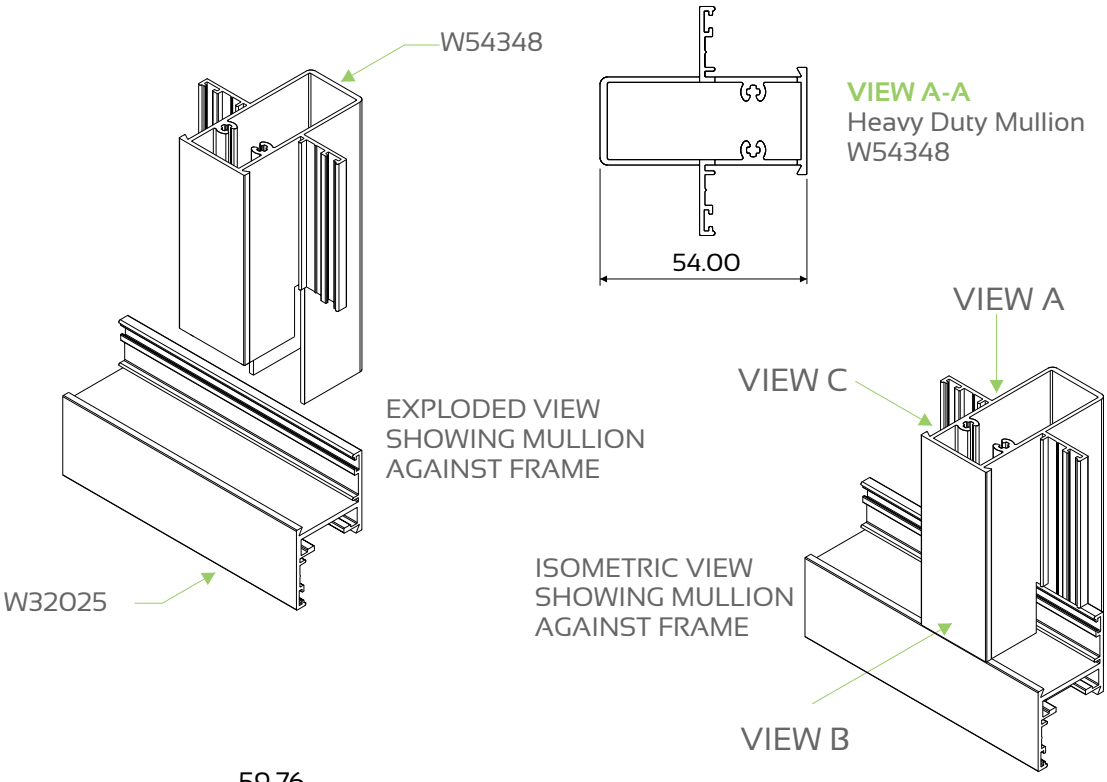
crealco

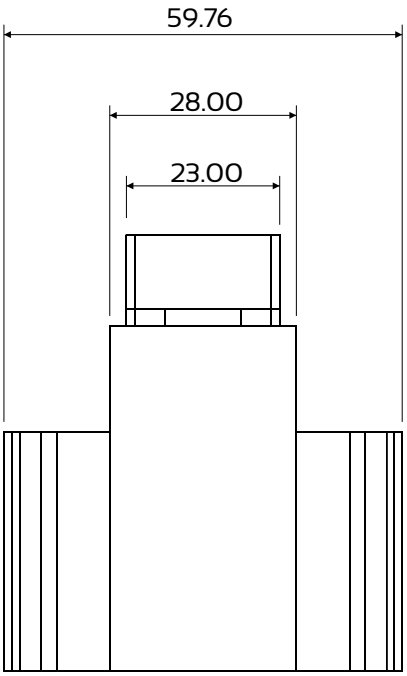
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical 54mm Mullion Machining Detail

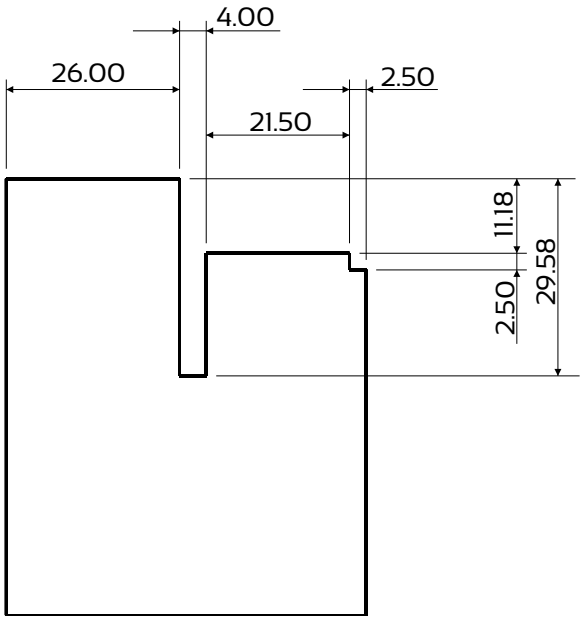
for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.





VIEW B-B
Section not to scale



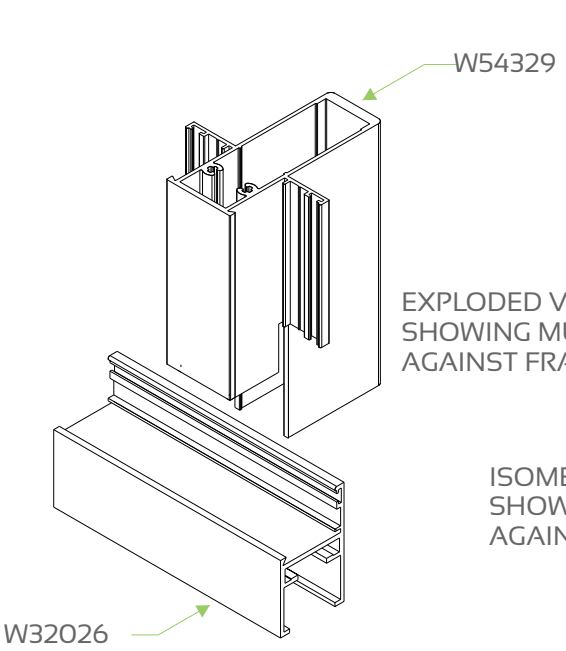
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

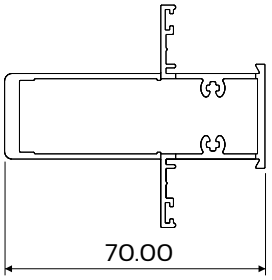
Typical 70mm Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

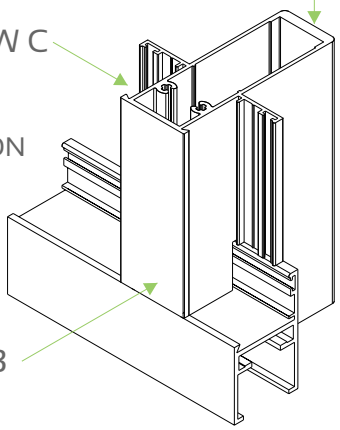
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



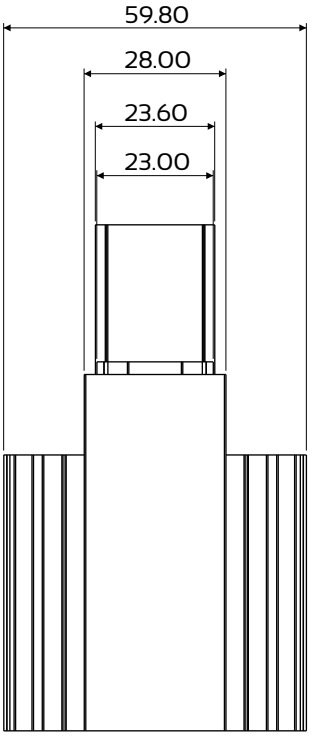
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



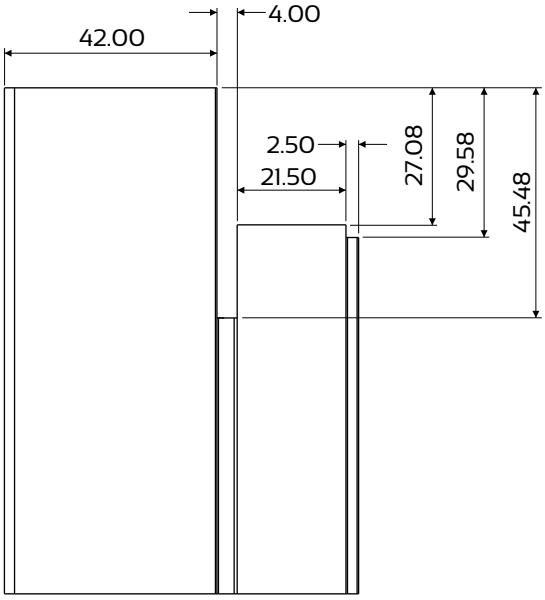
VIEW A-A
Heavy Duty Mullion
W54329



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

crealco

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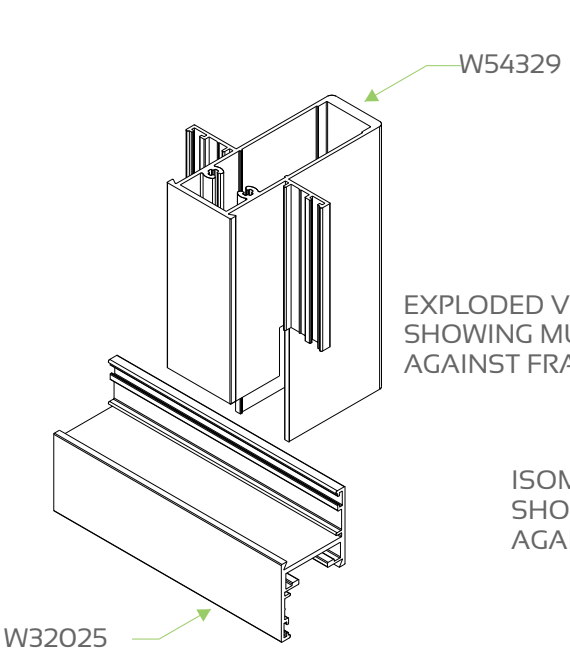
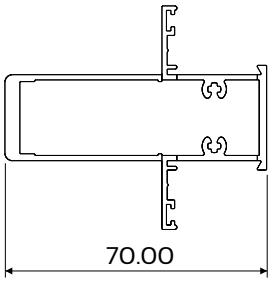
Typical 70mm Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

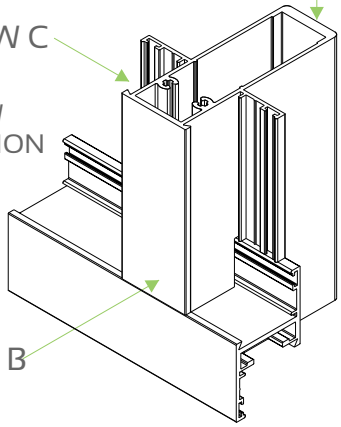
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



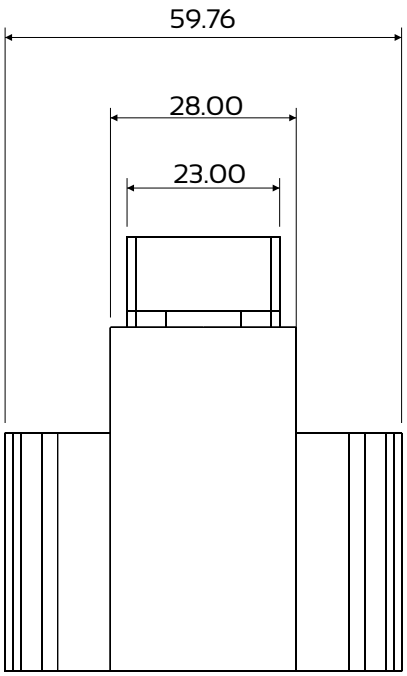
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME



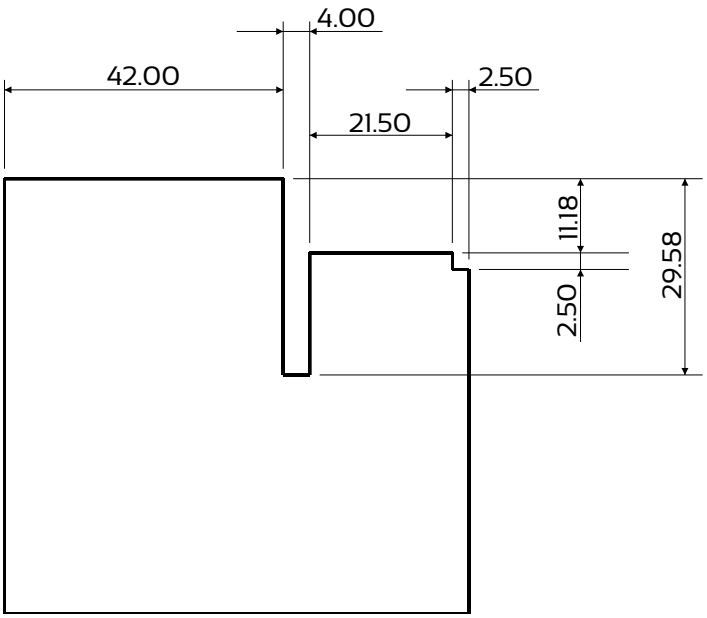
VIEW A-A
Heavy Duty Mullion
W54329



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

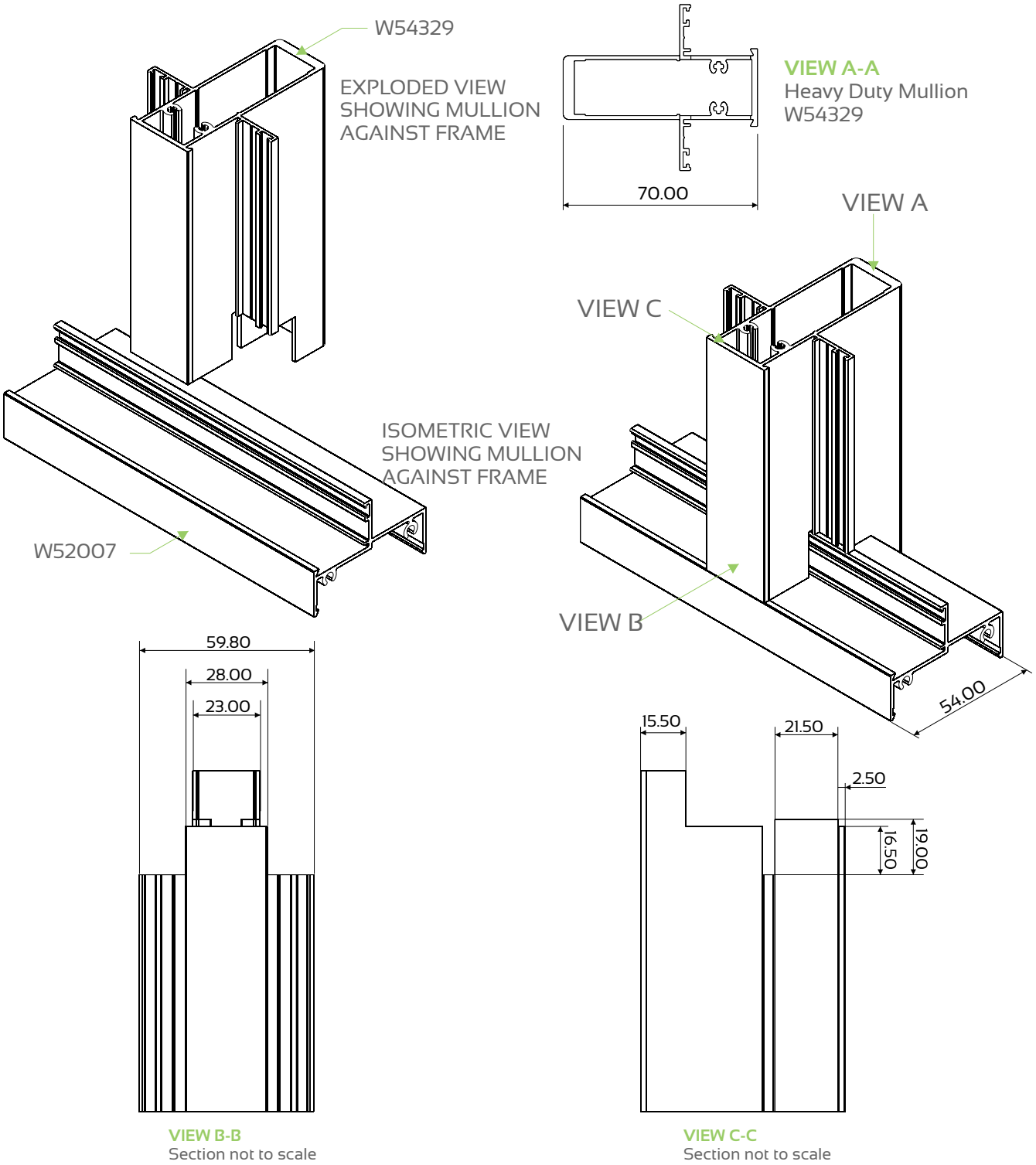
crealco

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical 70mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



VIEW B-B
Section not to scale

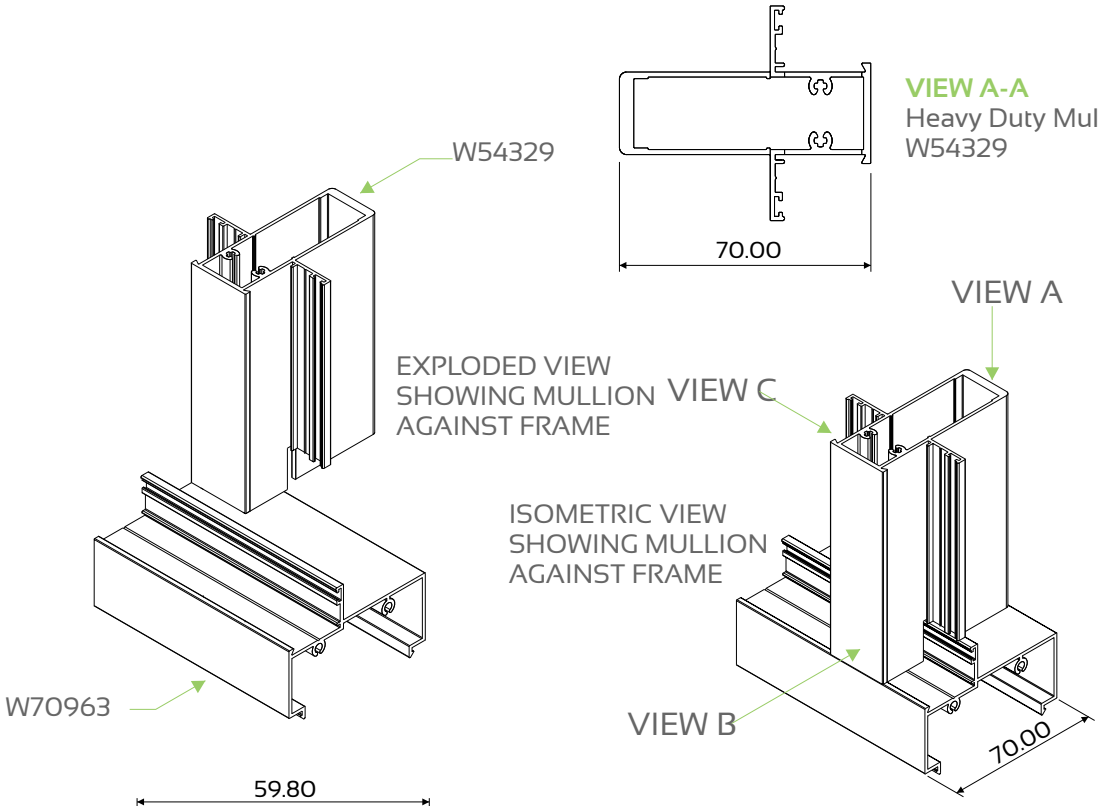
VIEW C-C
Section not to scale

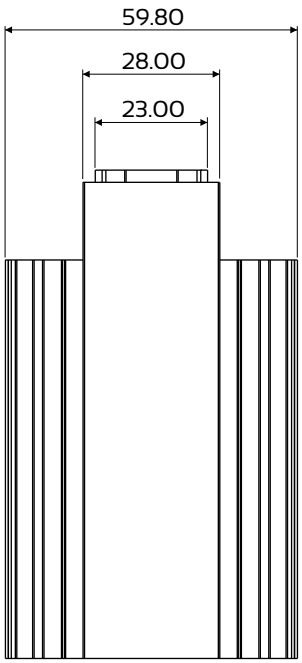
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical 70mm Mullion Machining Detail

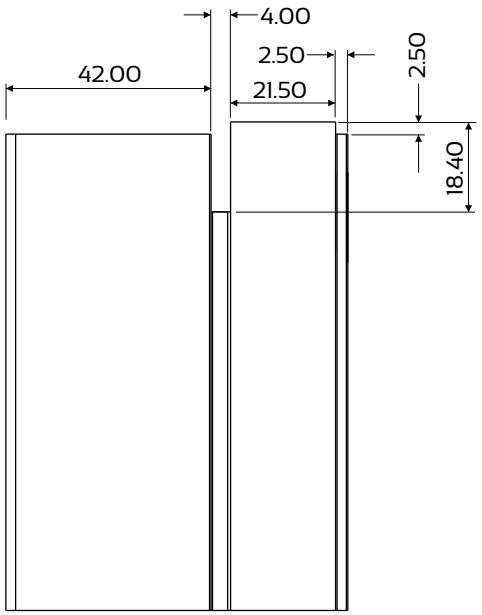
for End Milling on 70mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.





VIEW B-B
Section not to scale



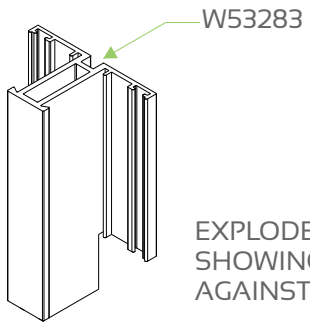
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

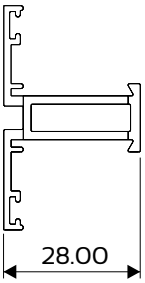
Typical Cottage Pane Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

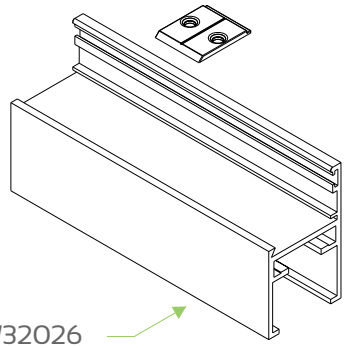
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



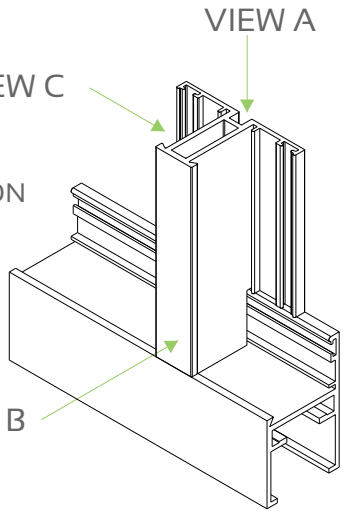
EXPLODED VIEW
SHOWING MULLION
AGAINST FRAME

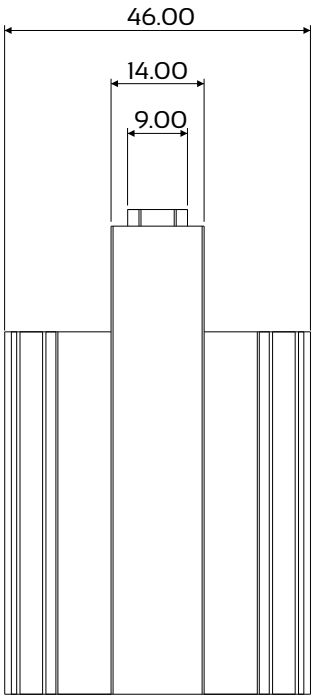


VIEW A-A
Cottage Pane Mullion
W53283

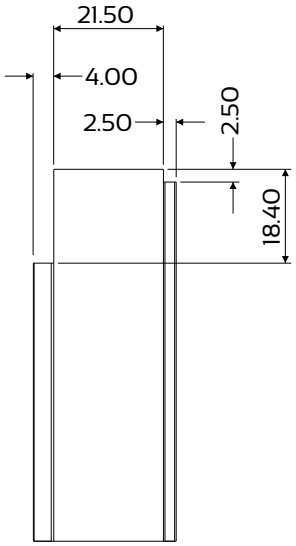


ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME





VIEW B-B
Section not to scale



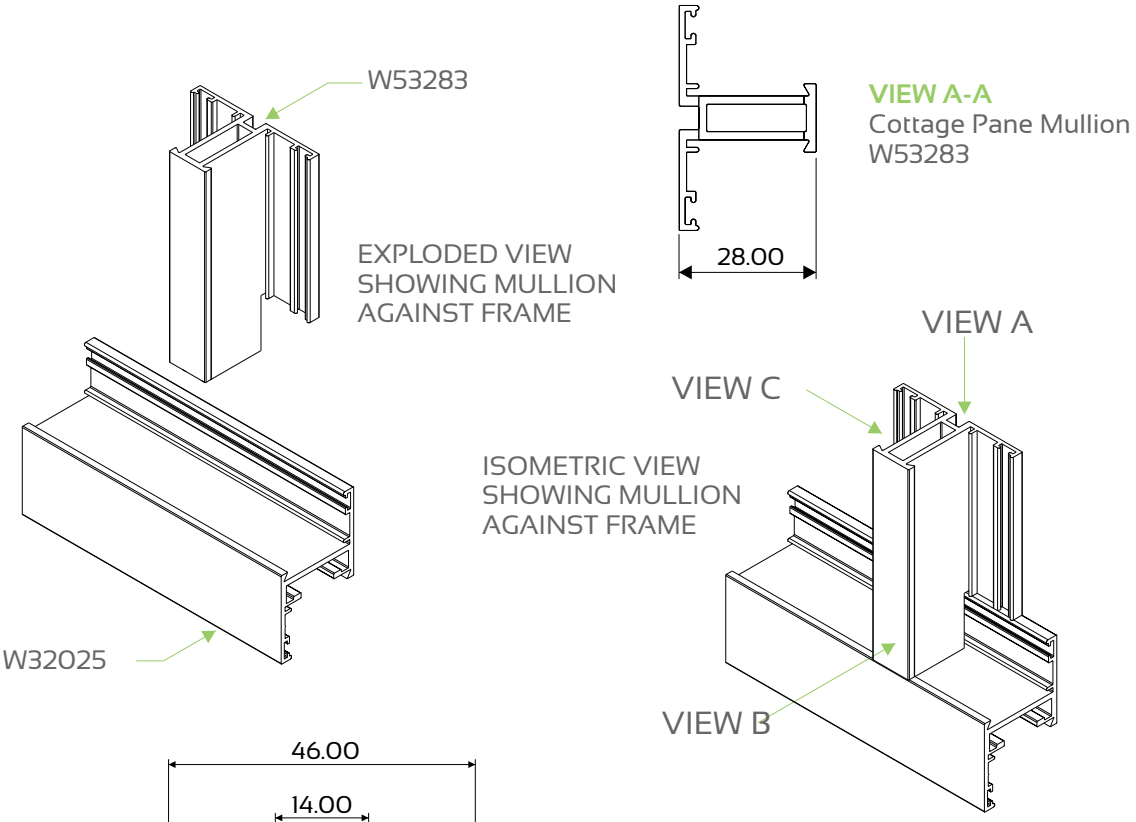
VIEW C-C
Section not to scale

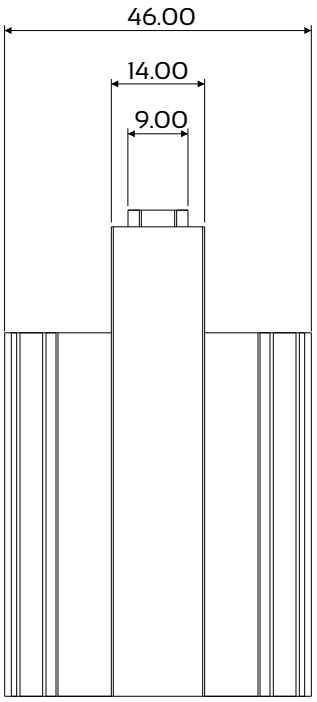
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cottage Pane Mullion Machining Detail

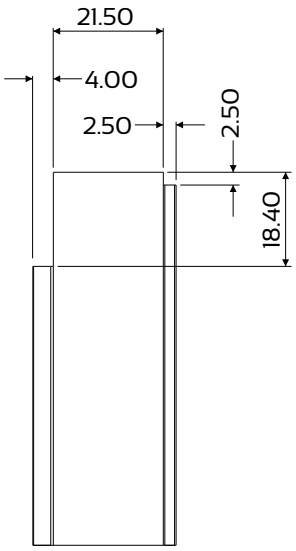
for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.





VIEW B-B
Section not to scale



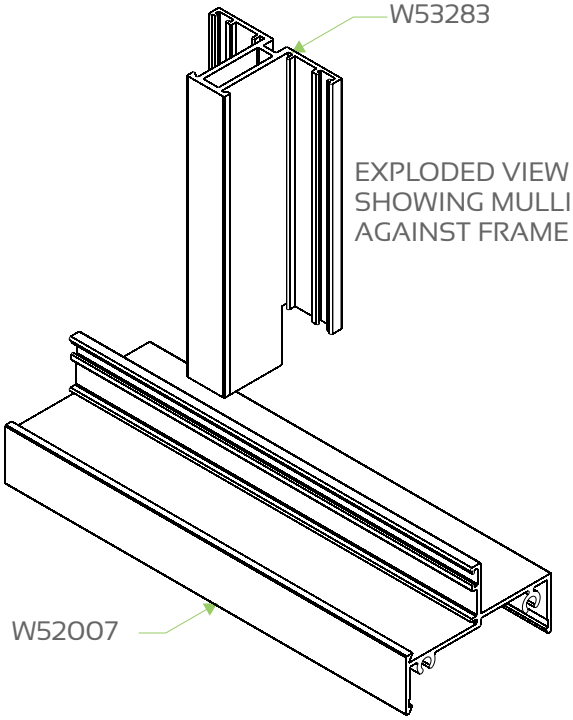
VIEW C-C
Section not to scale

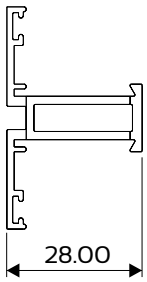
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cottage Pane Mullion Machining Detail

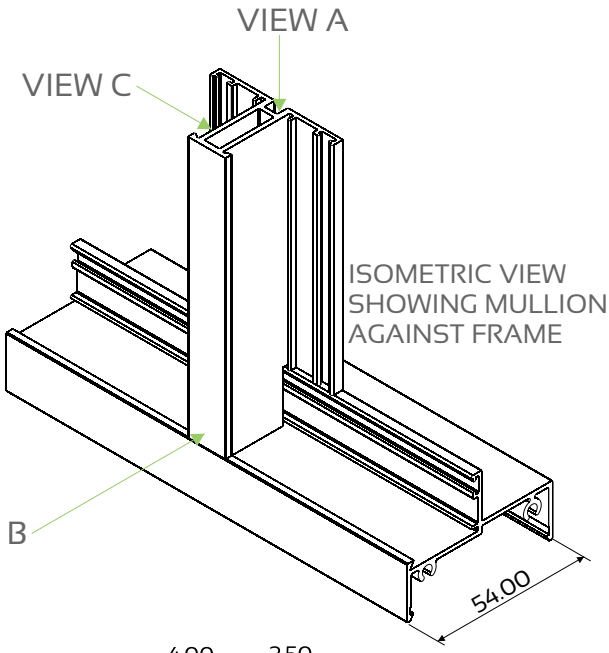
for End Milling on 54mm Outer Frame

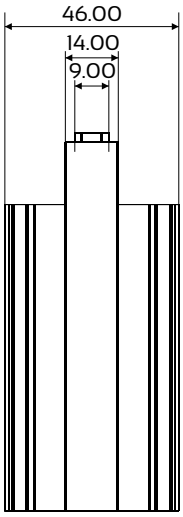
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



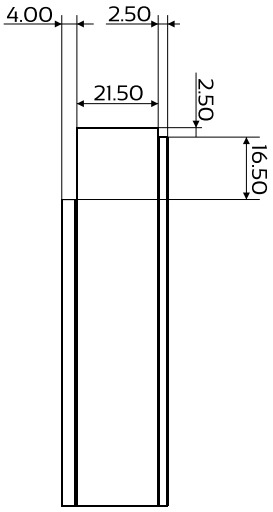


VIEW A-A
Cottage Pane Mullion
W53283





VIEW B-B
Section not to scale



VIEW C-C
Section not to scale

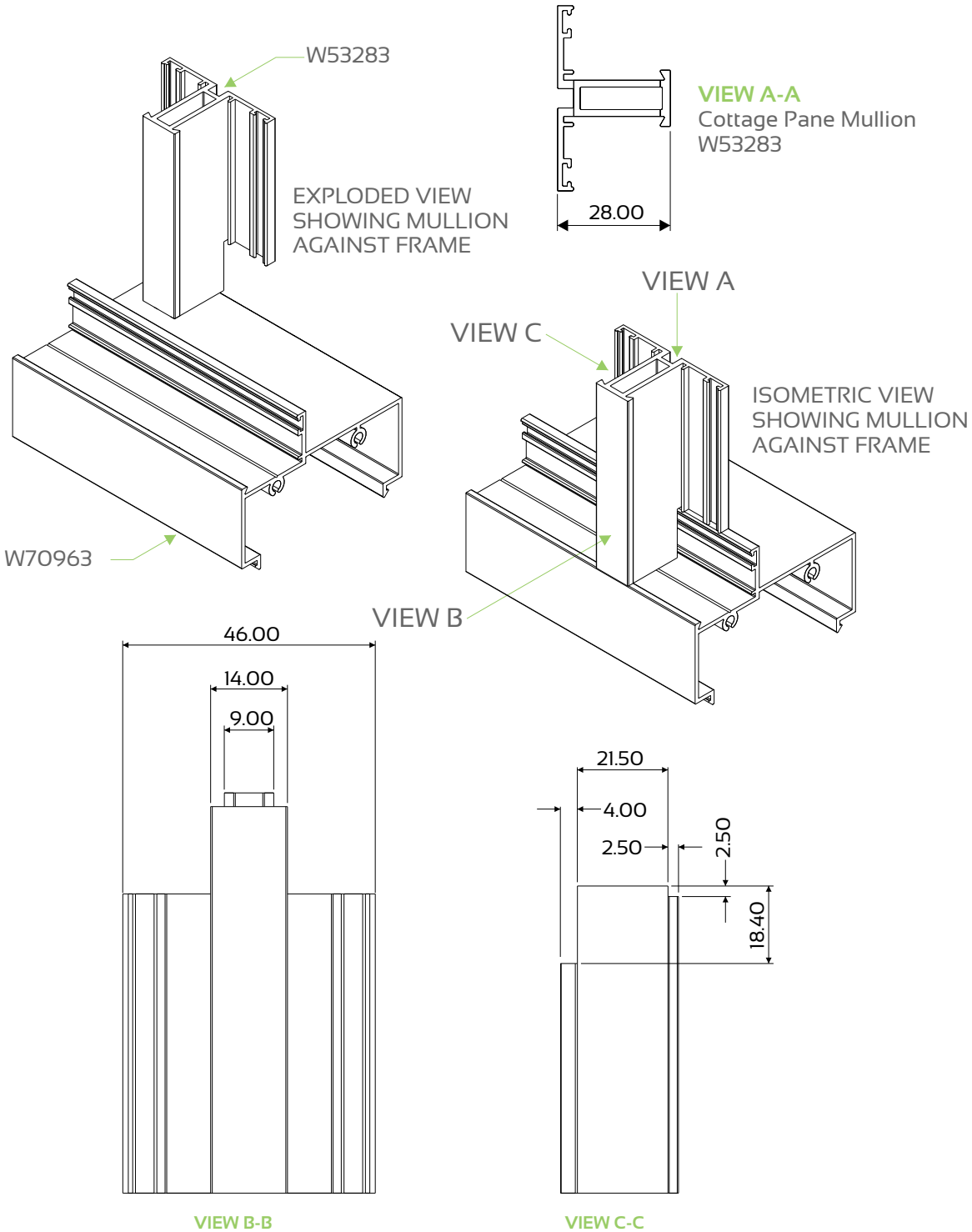
crealco

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cottage Pane Mullion Machining Detail

for End Milling on 70mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



VIEW B-B
Section not to scale

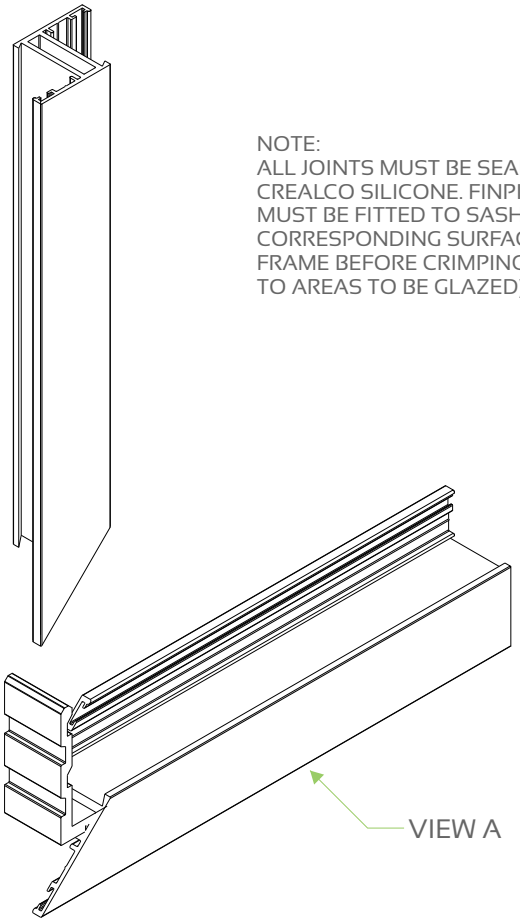
VIEW C-C
Section not to scale

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

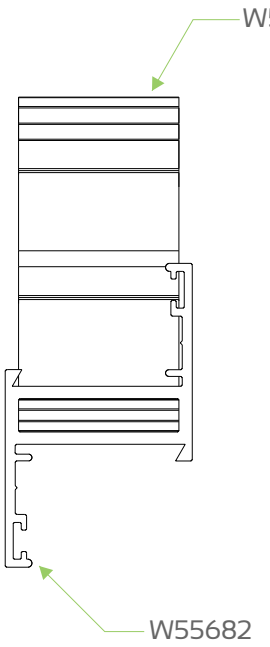
Typical Corner Cleat Assembly Detail

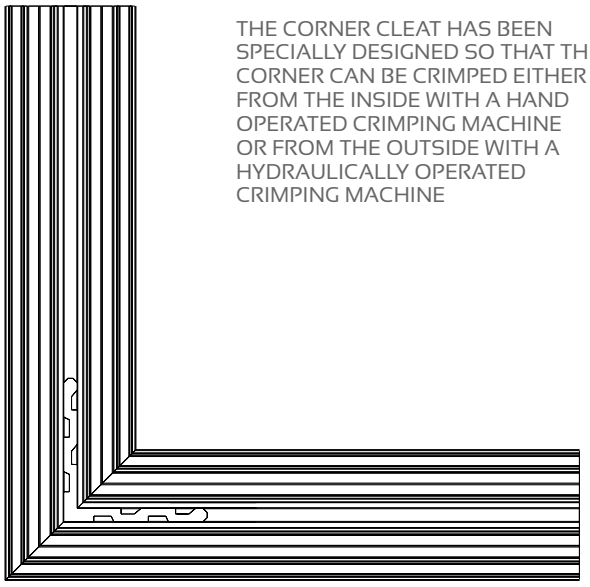
for Tubular Sash

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

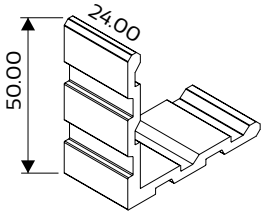


NOTE:
ALL JOINTS MUST BE SEALED WITH CREALCO SILICONE. FINPILE MUST BE FITTED TO SASH AND CORRESPONDING SURFACES OF FRAME BEFORE CRIMPING (NOT TO AREAS TO BE GLAZED)





THE CORNER CLEAT HAS BEEN SPECIALLY DESIGNED SO THAT THE CORNER CAN BE CRIMPED EITHER FROM THE INSIDE WITH A HAND OPERATED CRIMPING MACHINE OR FROM THE OUTSIDE WITH A HYDRAULICALLY OPERATED CRIMPING MACHINE



W52695

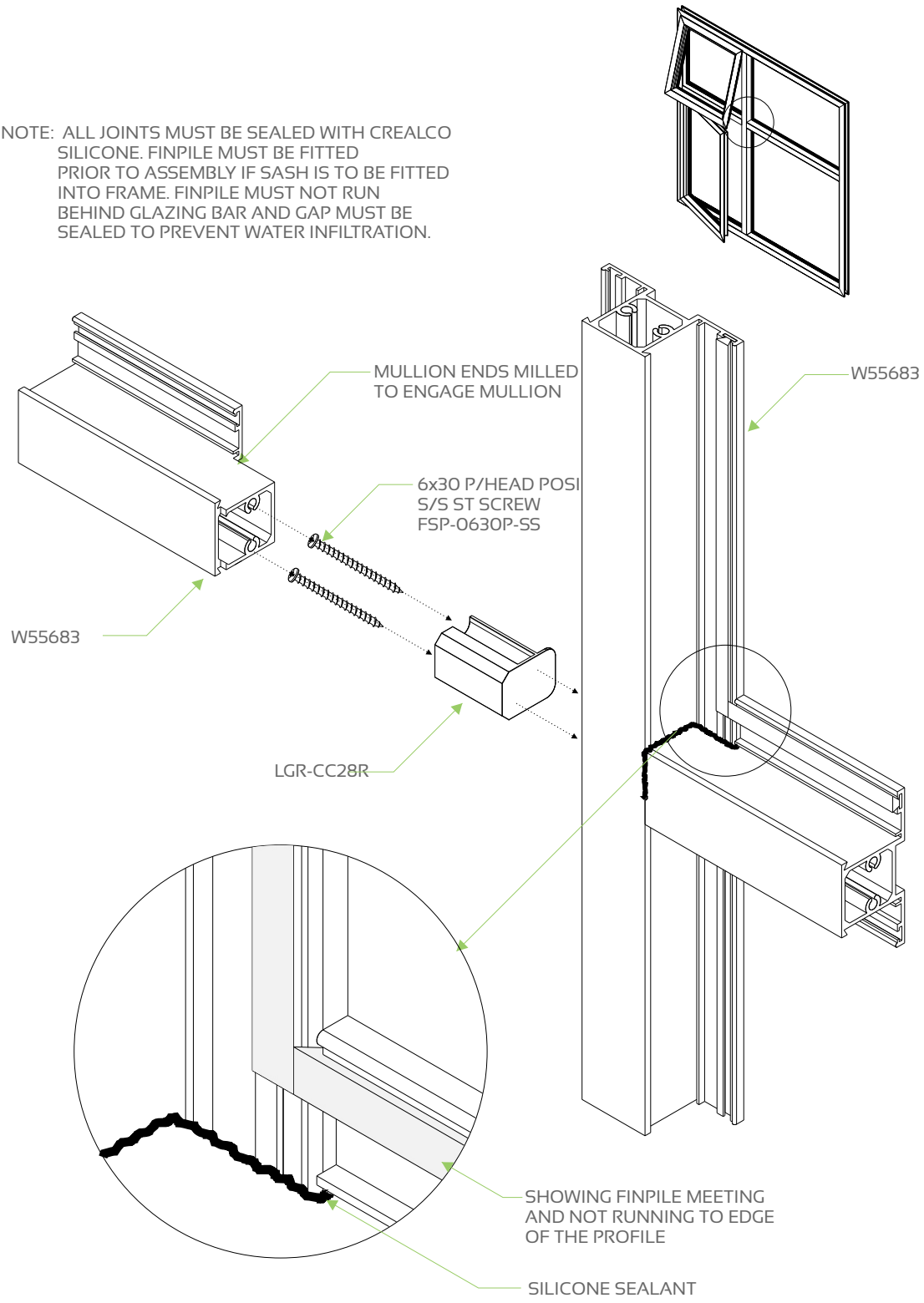
VIEW A-A

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cross Joint Assembly Detail

Standard Mullion

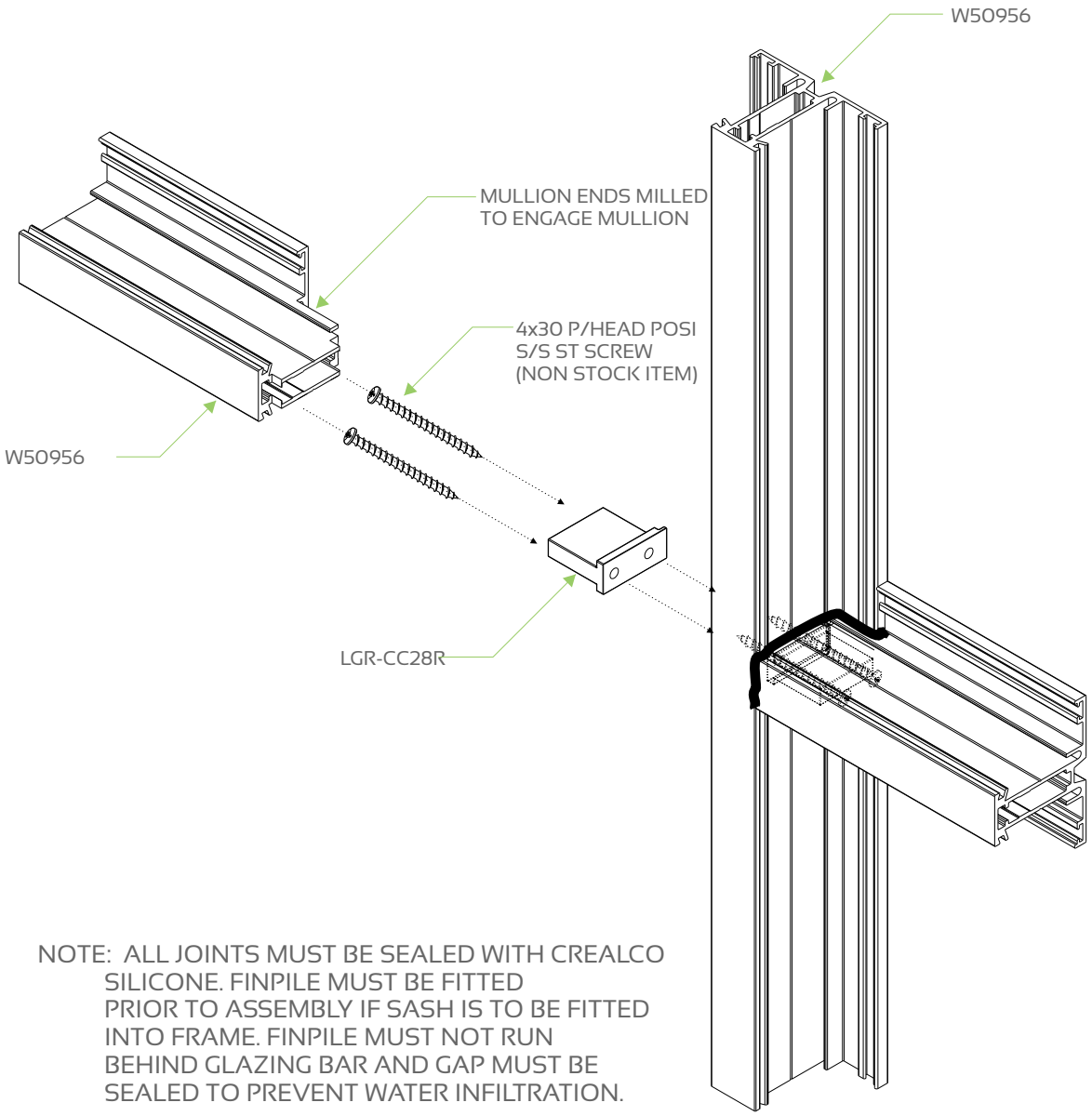
NOTE: ALL JOINTS MUST BE SEALED WITH CREALCO SILICONE. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPILE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.



This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cross Joint Assembly Detail

Cottage Pane Mullion

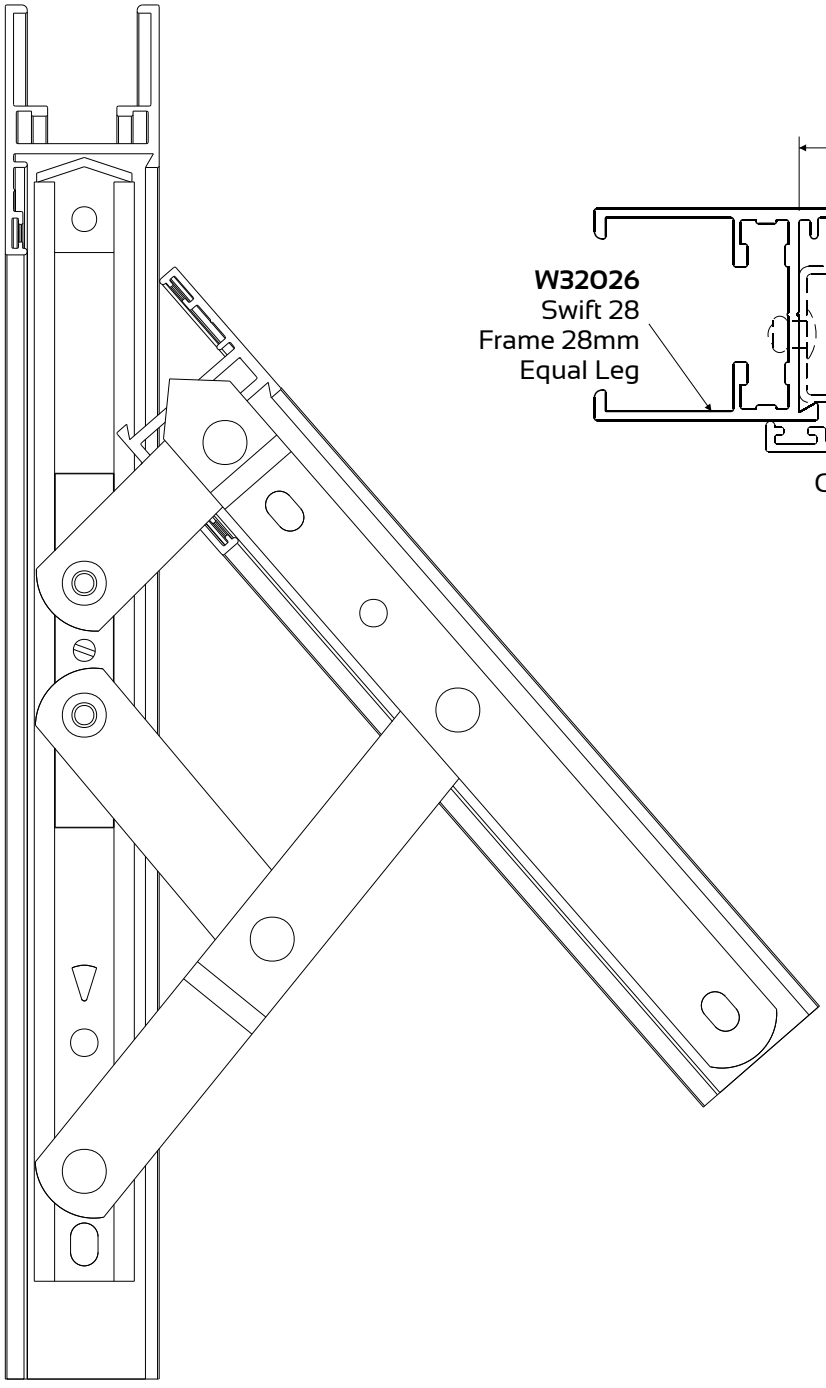


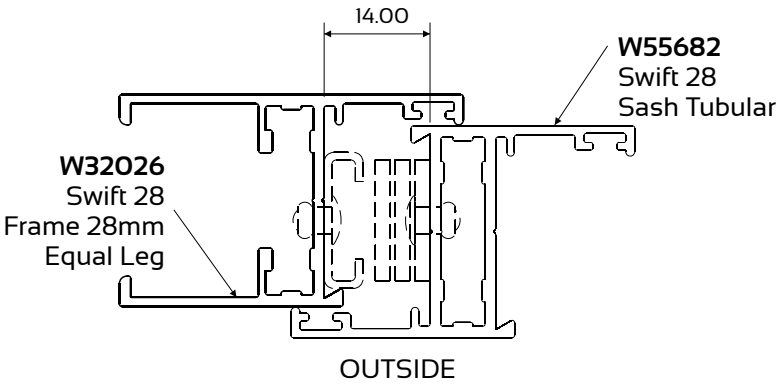
NOTE: ALL JOINTS MUST BE SEALED WITH CREALCO SILICONE. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPILE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.

crealco

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

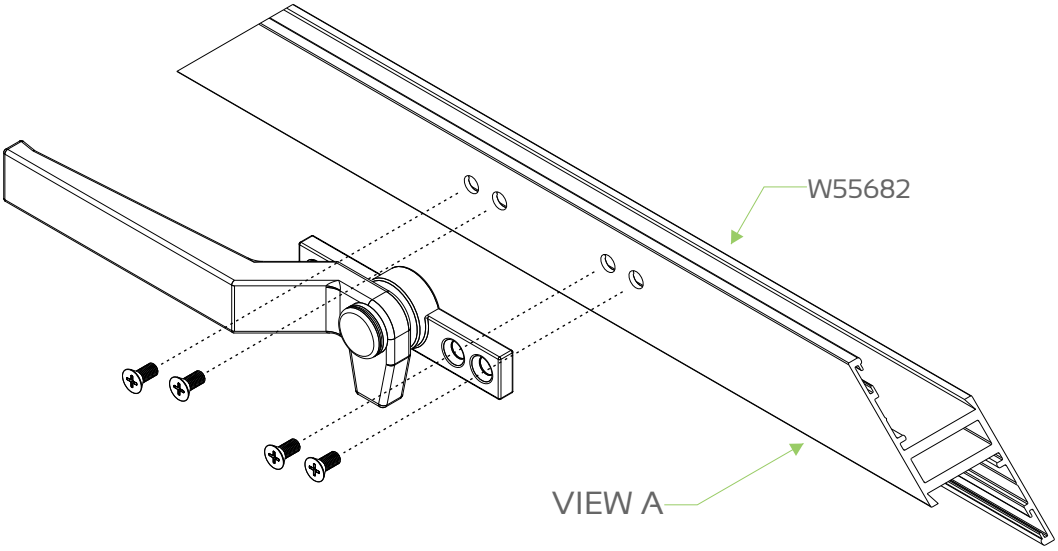
Typical Friction Stay Assembly Detail



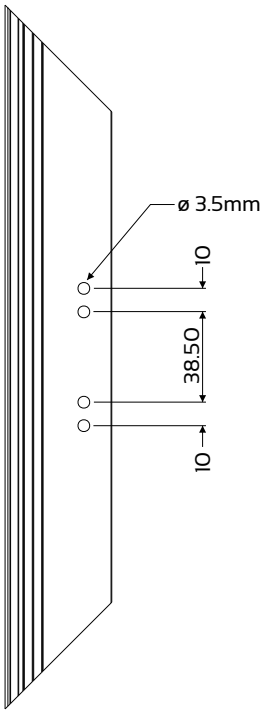


This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

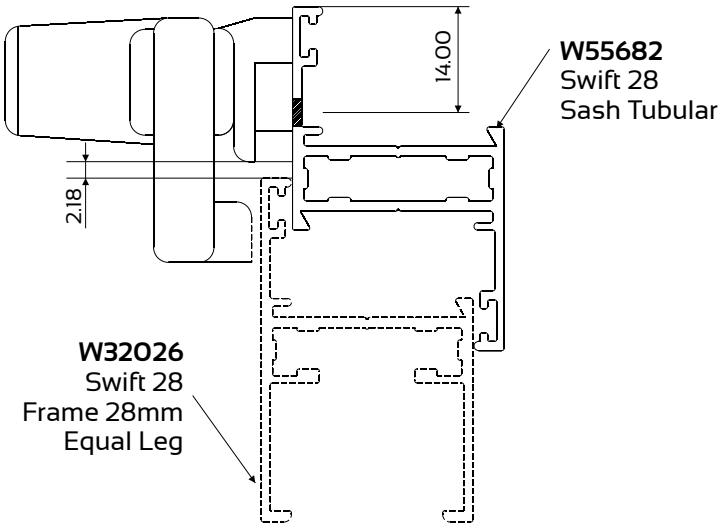
Typical Handle Assembly Detail



NO 8 x 10 COUNTERSUNK SELF-TAPPING
FLAT END SCREWS

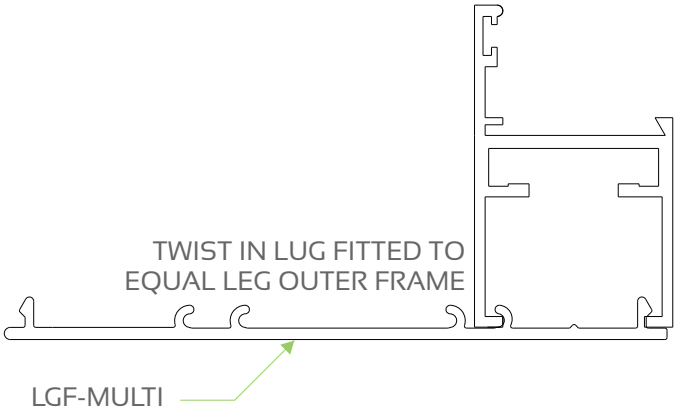


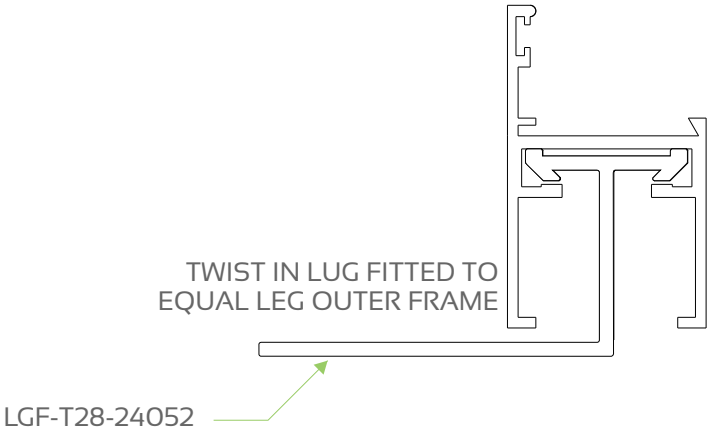
VIEW A-A

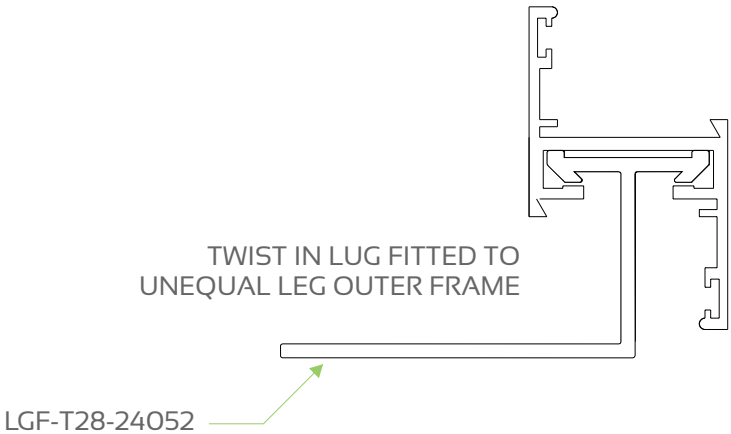


This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Fixing Lug Preparation Detail







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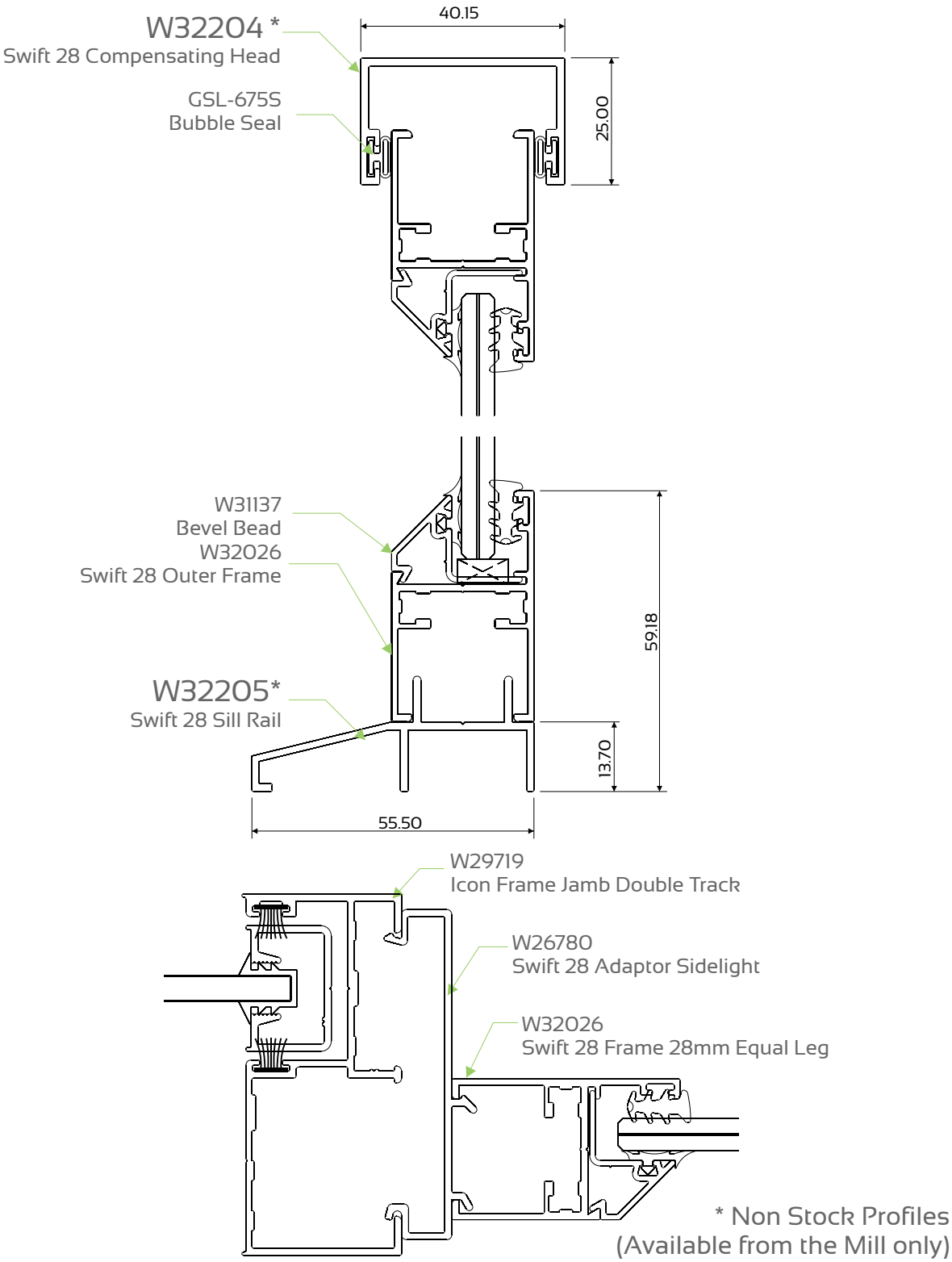
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Compensating Head & Sill Detail



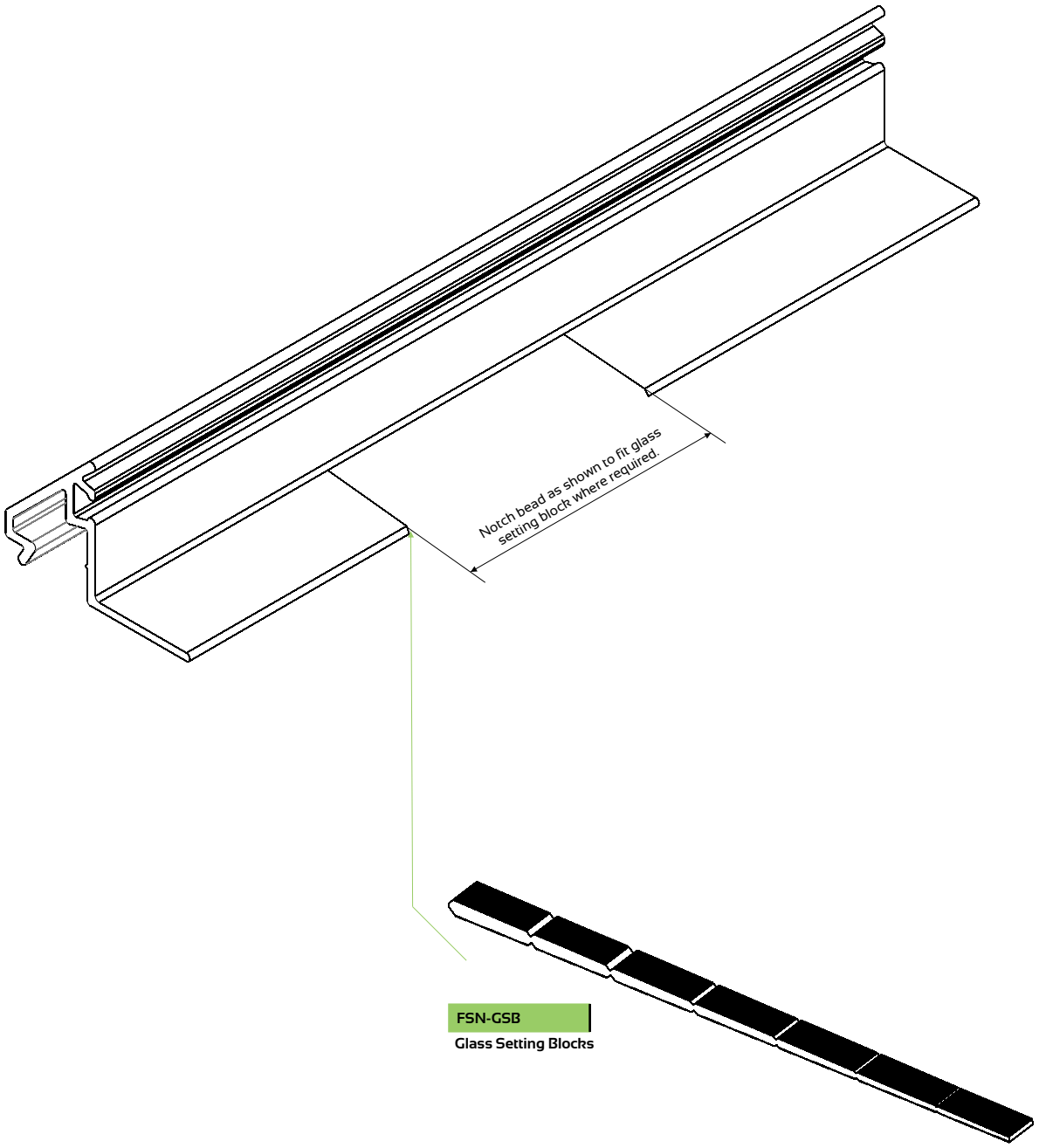
* Non Stock Profiles
(Available from the Mill only)

crealco

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Bead Cut-Out for Setting Block

Bead must be notched out at position of all glass setting blocks according to the length of the glass setting block used.



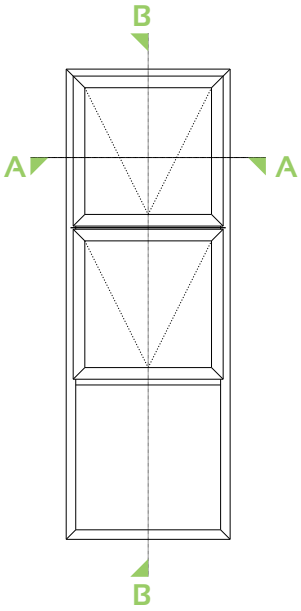
FSN-GSB
Glass Setting Blocks

crealco

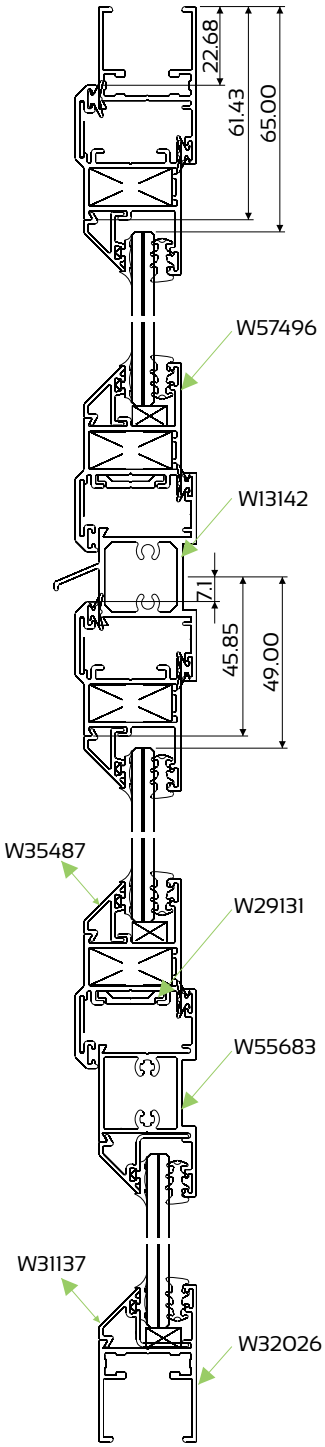
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Typical Cross-Sectional Details

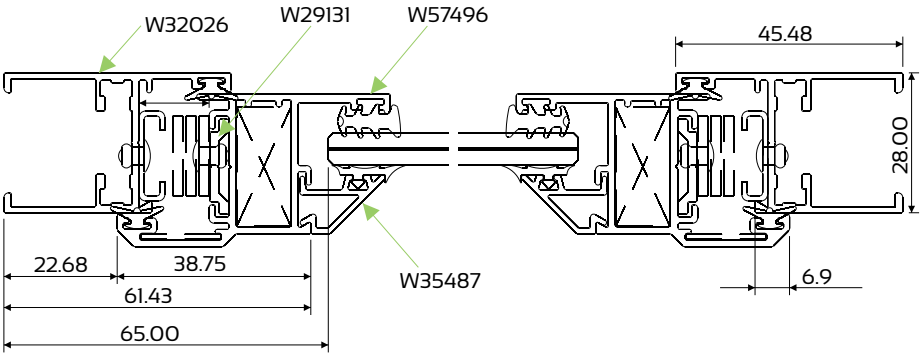
Double Top Hung Over Fixed



SECTION B-B
Section not to scale

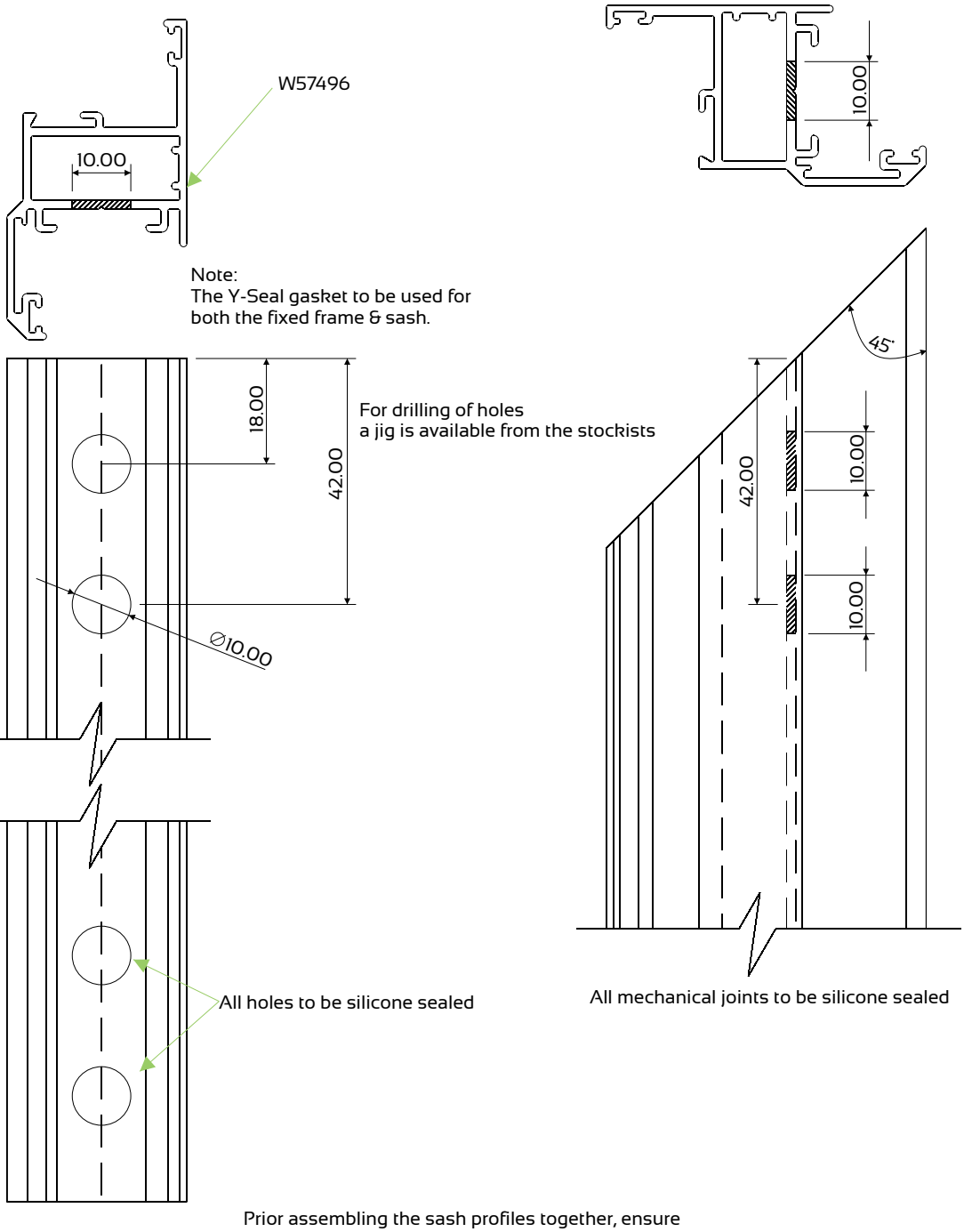


SECTION A-A
Section not to scale



This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

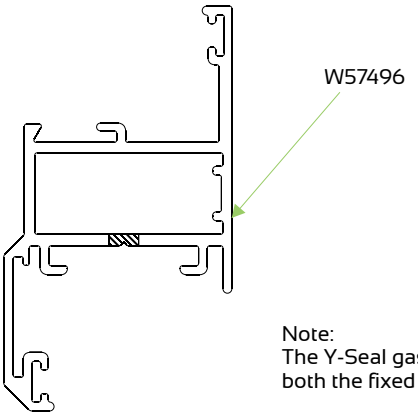
OPTION A - USING THE JOINING CORNER

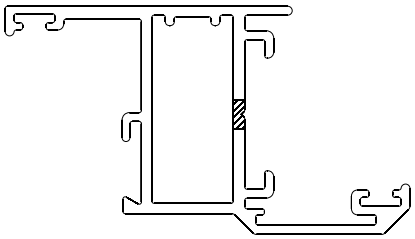


Prior assembling the sash profiles together, ensure that a locking bar profile is fitted for each friction stay.

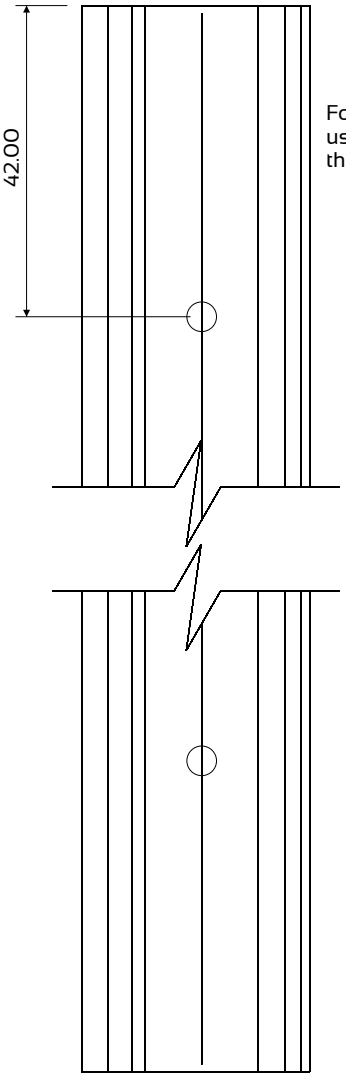
Cut locking bar to the same length as the friction stay.

OPTION B - USING THE CORNER CONNECTOR

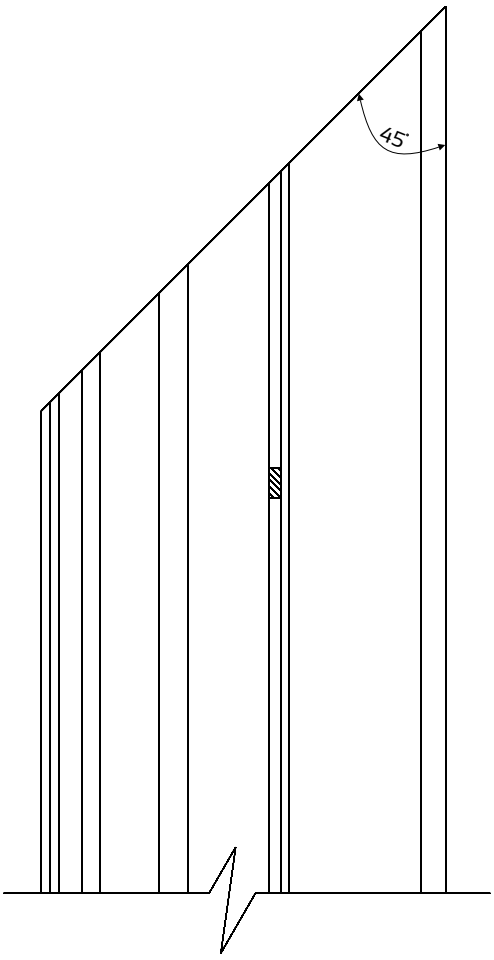




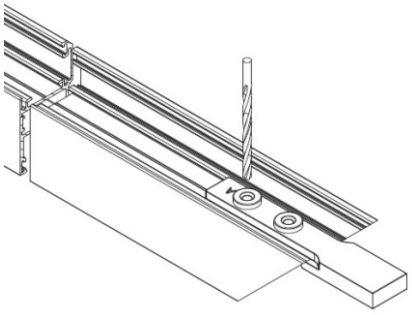
Note:
The Y-Seal gasket to be used for both the fixed frame & sash.



For drilling of holes for the corner connector, using the sash jig, only drill a hole to pop rivet the corner connector.



All mechanical joints to be silicone sealed



Prior assembling the sash profiles together, ensure that a locking bar profile is fitted for each friction stay.

Cut locking bar to the same length as the friction stay.

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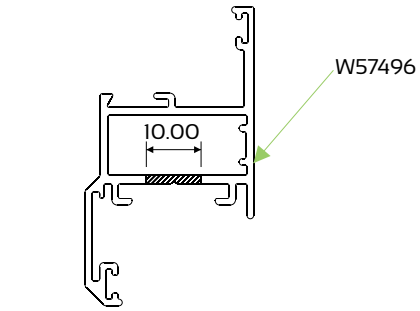
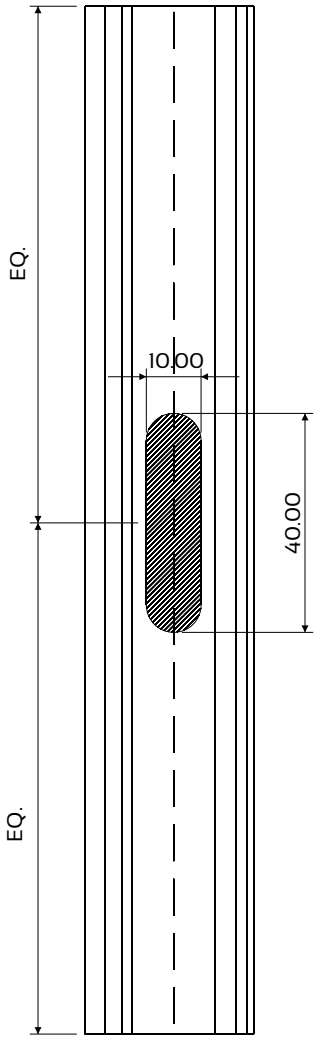
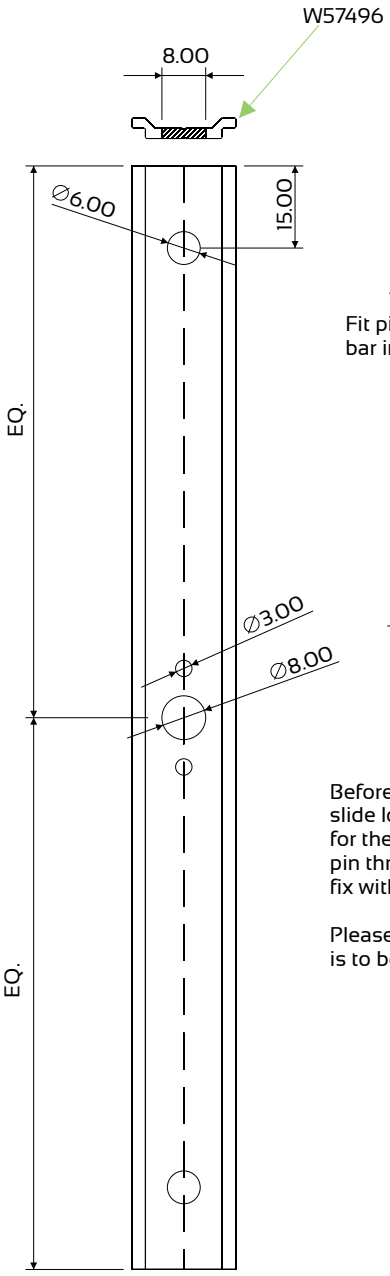
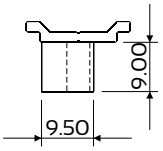
Typical Multi-Locking Sash Machining Detail

Sash & Locking Bar

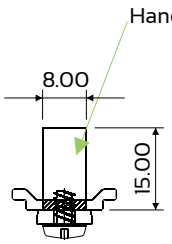








Fit pins before sliding locking bar into the sash profile



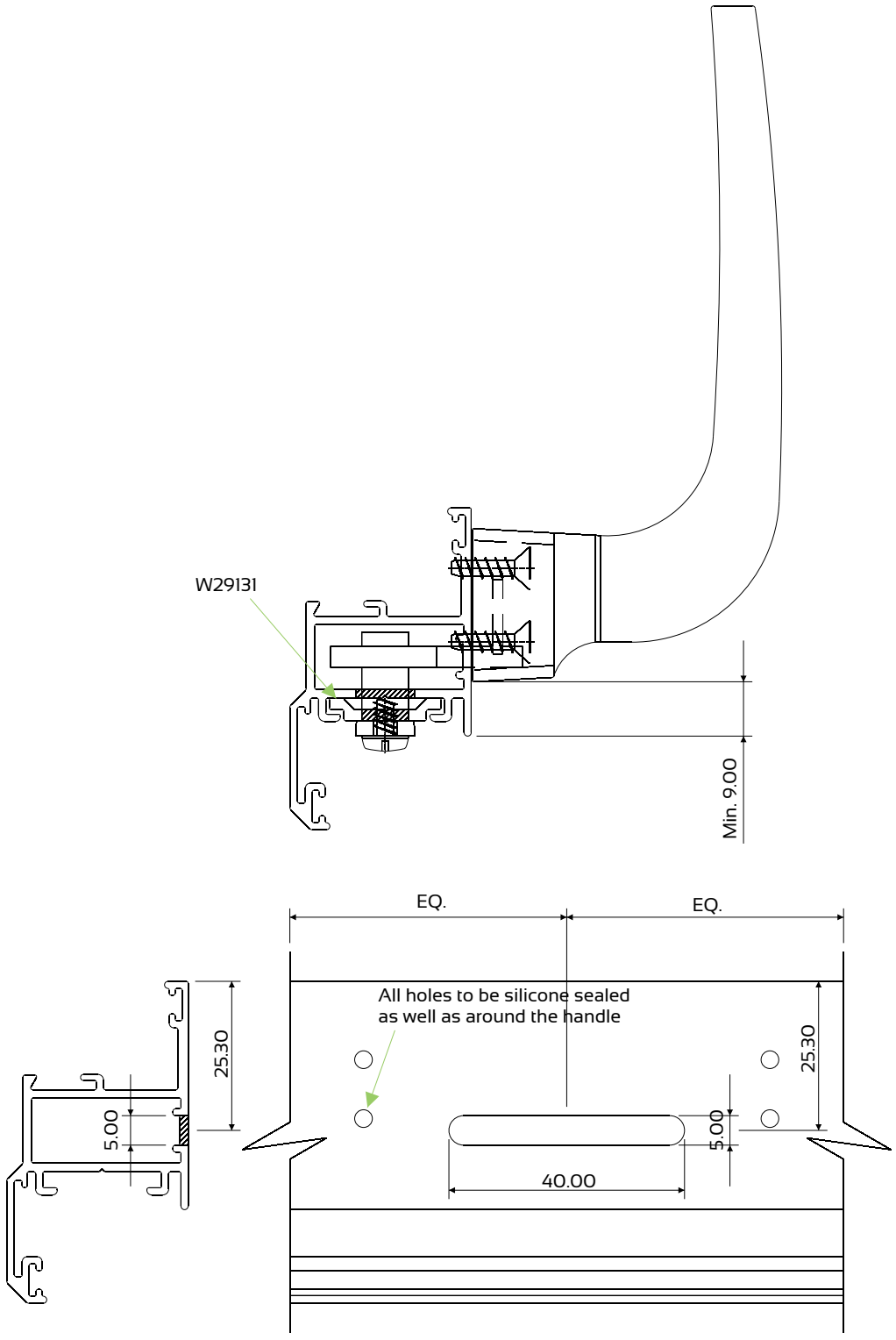
Before assembly of sash profiles, slide locking bar into the profile for the sash handle, then fit pin through centre hole and fix with screws.

Please note, that the shorter pin is to be used for the sashes.

Note:
Before assembly of the sash frame, the locking bar needs to be inserted into the bottom sash profile with the locking pins fitted & holes drilled to receive the handle pin.

Typical Multi-Locking Sash Machining Detail

Handle



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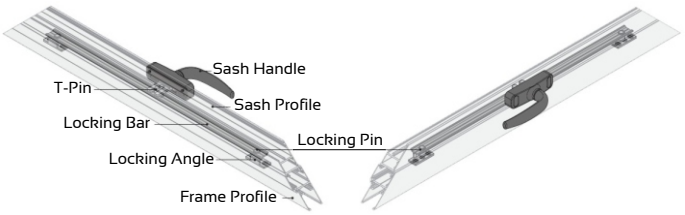
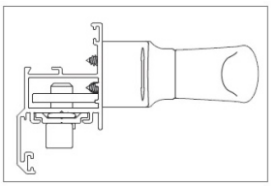
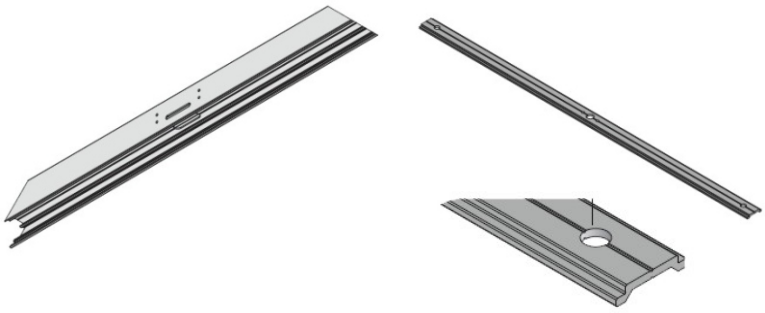
Typical Fitting of Multi-Locking Sash Handles



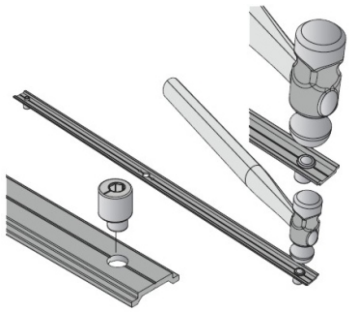




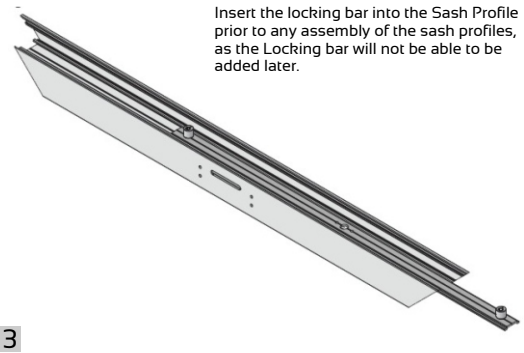
Once all frame profiles have been cut to length and deburred, machine the handle profile according to Maching details as shown on the previous page.

Cut the locking bar as per StarFront & machine as shown in diagram 2.

2

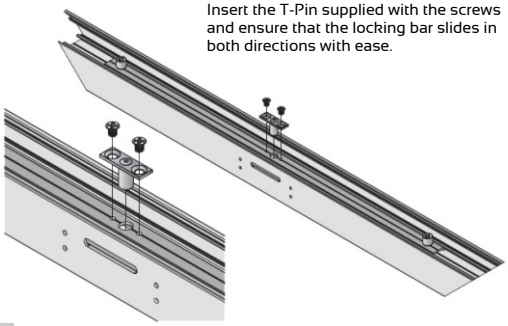


Insert the locking pins into the locking bar. Deform the protruding part of the pin using a ball peen hammer or punch to fix them onto the locking bar.



Insert the locking bar into the Sash Profile prior to any assembly of the sash profiles, as the Locking bar will not be able to be added later.

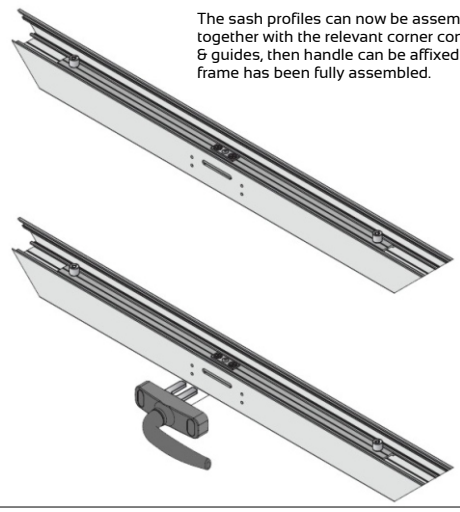
3



Insert the T-Pin supplied with the screws and ensure that the locking bar slides in both directions with ease.

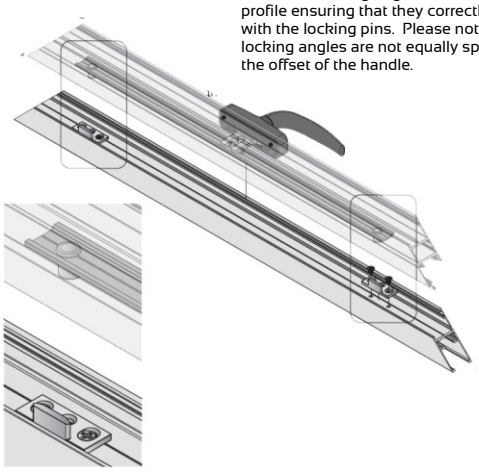
4

5



The sash profiles can now be assembled together with the relevant corner connectors & guides, then handle can be affixed after the frame has been fully assembled.

6



Install the locking angles to the outer frame profile ensuring that they correctly align with the locking pins. Please note that the locking angles are not equally spaced due to the offset of the handle.

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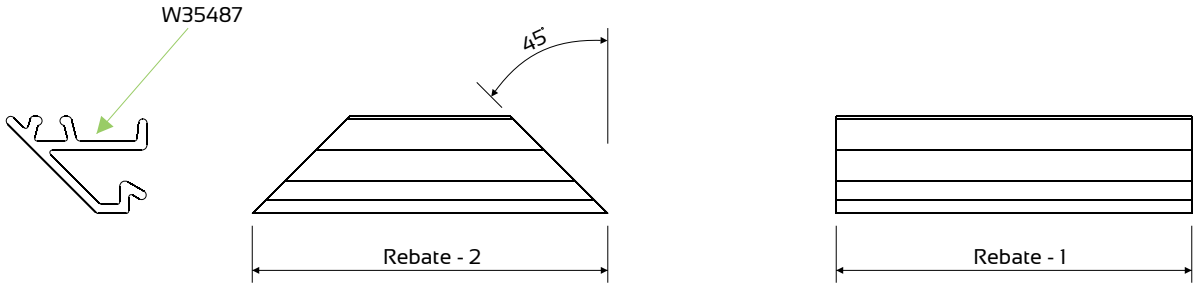
Typical Multi-Locking Sash Cutting Detail

Multi-Locking Bead



Vertical Glazing Bead

Horizontal Glazing Bead

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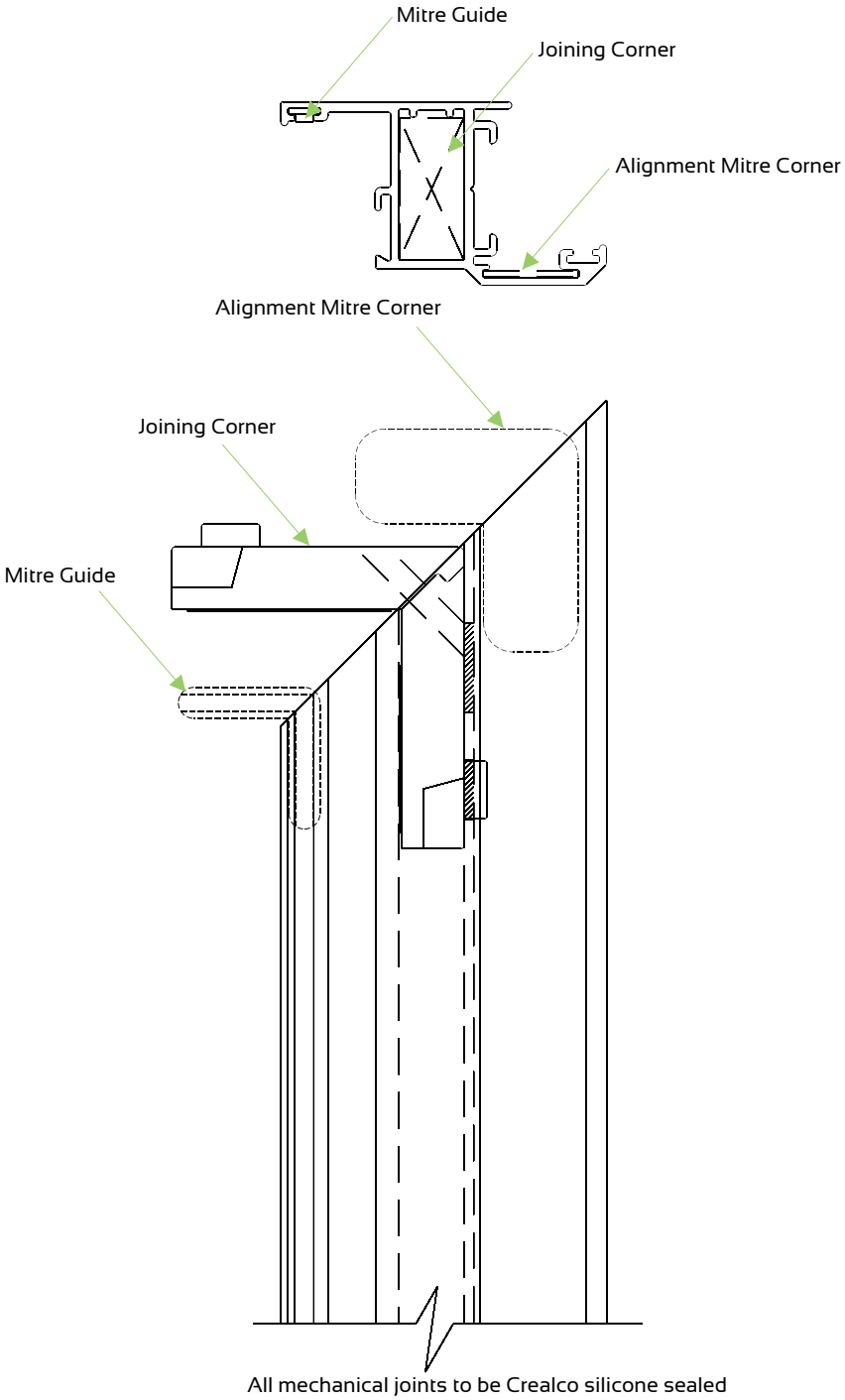
Typical Multi-Locking Sash Assembly Detail

Corner Joint

OPTION A - USING THE JOINING CORNER

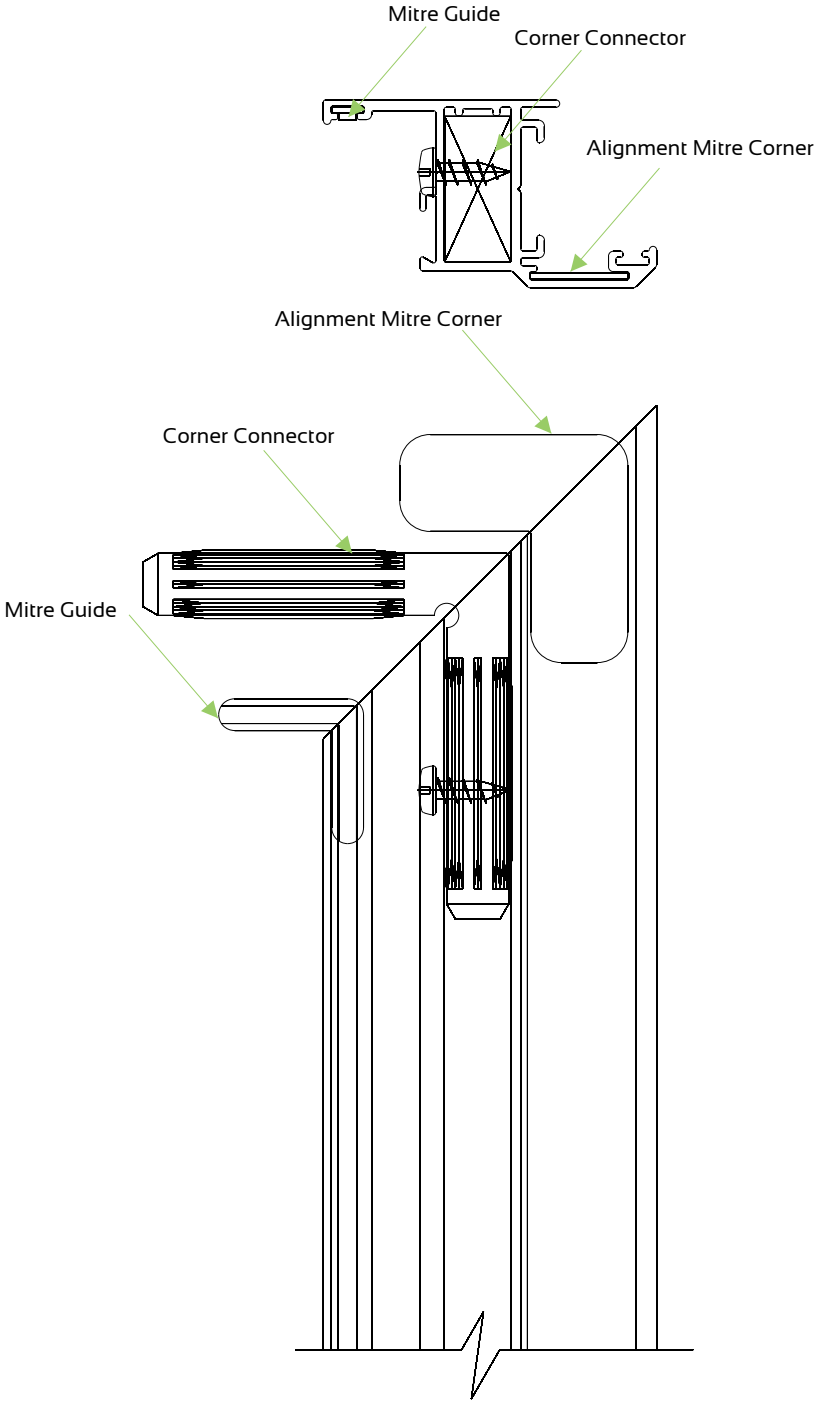


All mechanical joints to be Crealco silicone sealed
Note:
Remember to fit the locking bars for friction stays before assembly of sash frame.

Typical Multi-Locking Sash Assembly Detail

Corner Connector

OPTION B - USING CORNER CONNECTOR



All mechanical joints to be Crealco silicone sealed

Note:
Remember to fit the locking bars for friction stays before assembly of sash frame.

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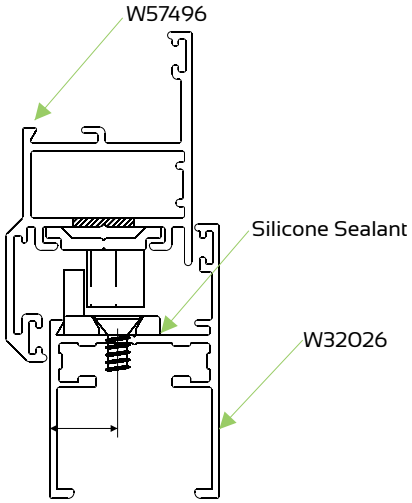
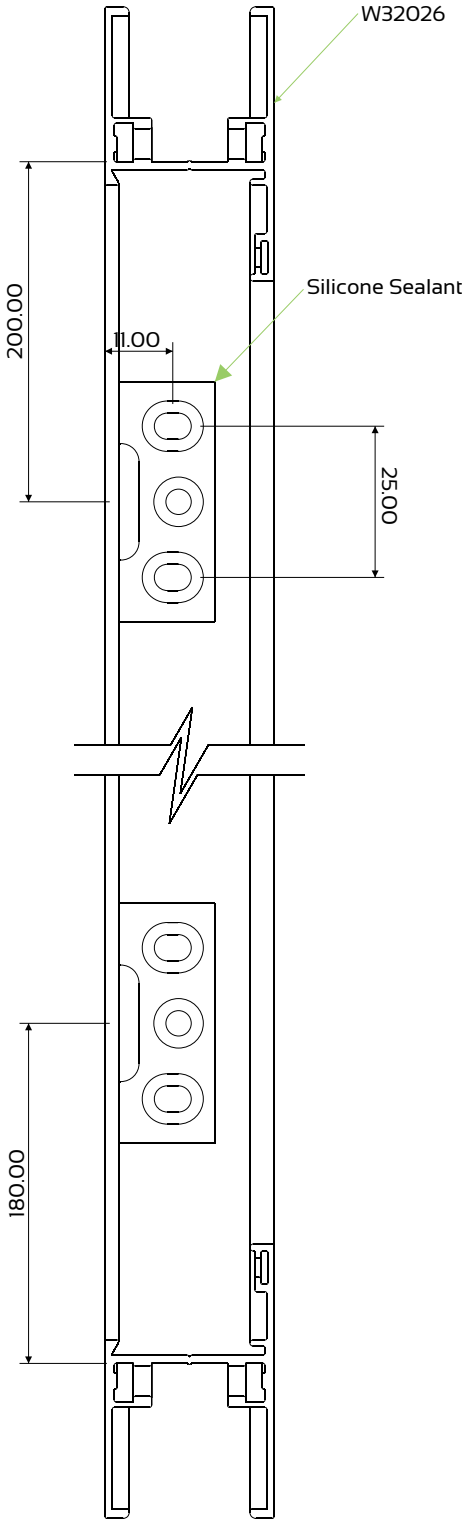
Typical Multi-Locking Sash

Lock Handle Detail



Note:
No Y-seal gasket to be fitted for the bottom sash profile unless the building is over 5 stories high. Ensure the Y-seal gasket sits between the drainage cut-out.



crealco

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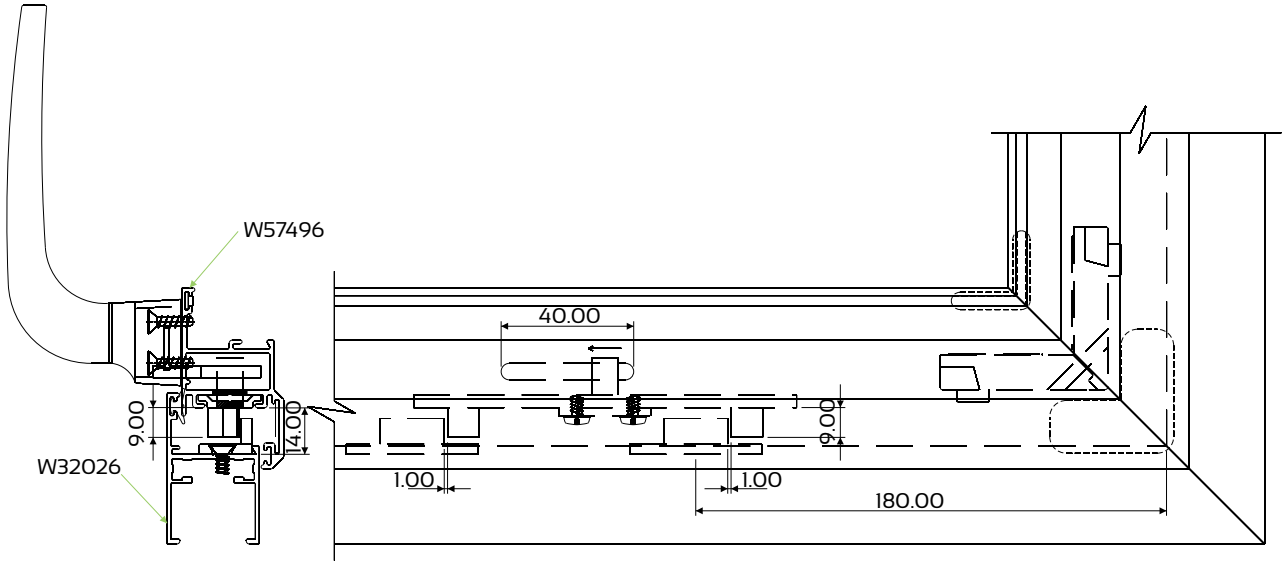
Locking Handle Detail



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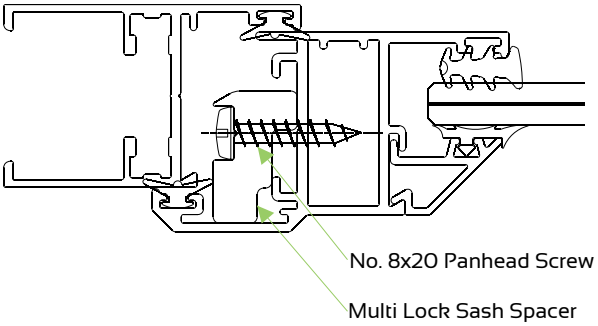
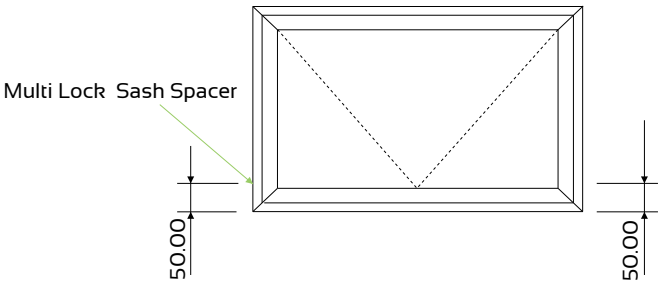
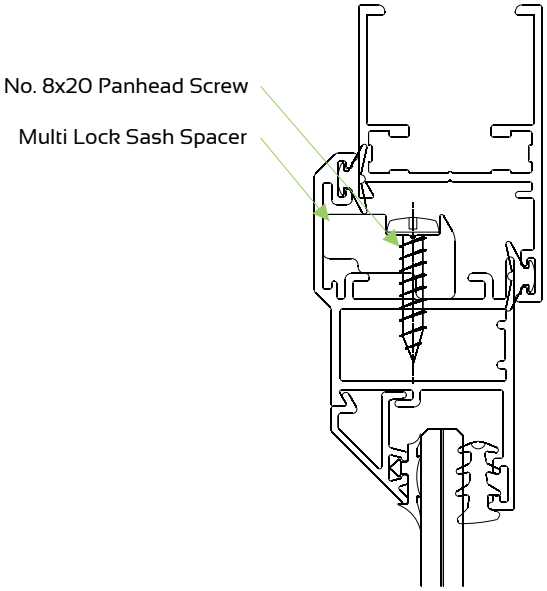
Spacer Detail

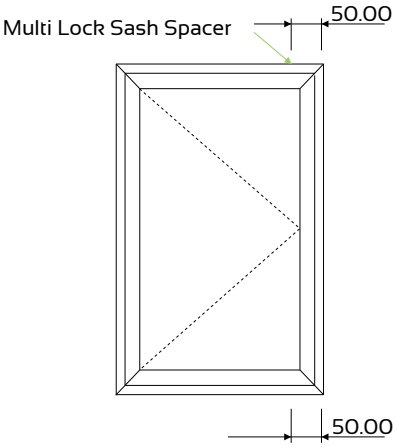


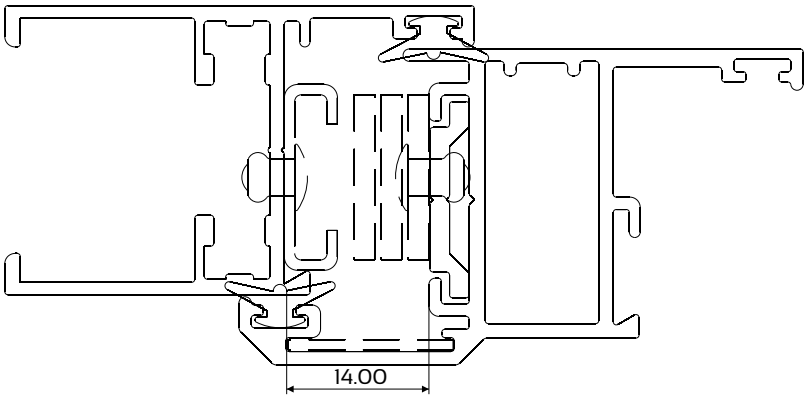
Note:
To assist the top hung sash in opening & closing squarely, a Multi Lock sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.





Note:
To assist the top hung sash in opening & closing squarely, a Multi Lock sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.





Note:
For optimal performance against air & water infiltration,
it is important to position friction stays as shown so that the sash fits almost right against the frame.

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Typical Glazing Procedure

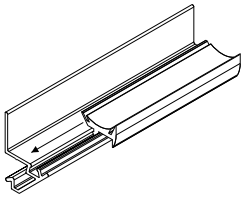
Note:

Insert the pull-in vinyl gasket into the glazing bead by sliding or pressing it into the groove (1). Before cutting the gasket, ensure that it has not been stretched & cut 6mm longer so that the corners are in compression at all times.

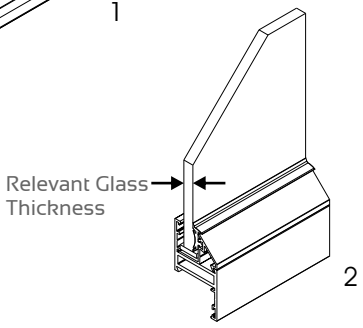
Position the bottom glazing bead in the glazing bead rebate of the relevant profile (2).

Insert the top then the side glazing beads ensuring that they are correctly positioned into place.

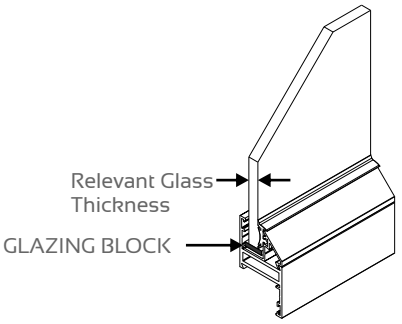
Starting from the top centre, insert the wedge gasket (4) without stretching it. Stop 150mm from the corner & partly cut the wedge gasket 6mm longer than the vertical bead. Insert the gasket into the corner & then roll in remaining 150mm (5). Repeat this on the other sides. Where the gasket end meets, cut the gasket 6mm longer, then insert.



1

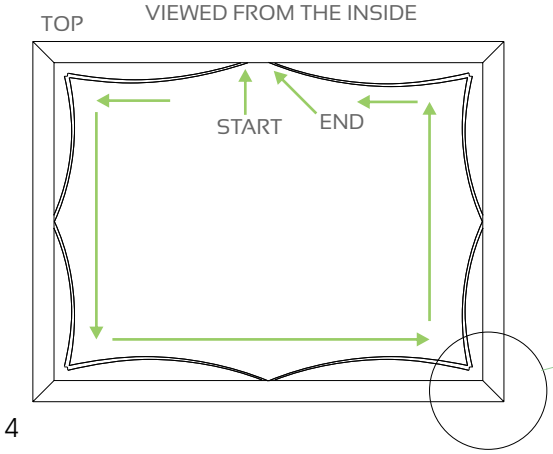


2

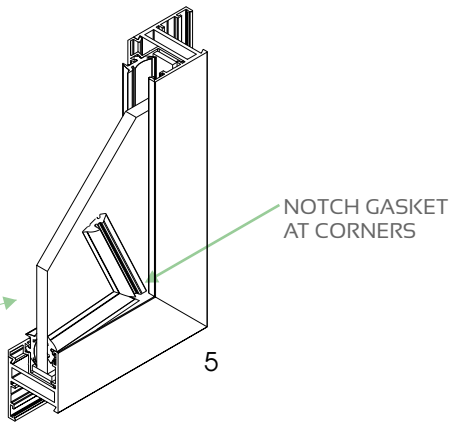


3

ENSURE GASKETS ARE NOT STRETCHED AT ANY STAGE



4



5

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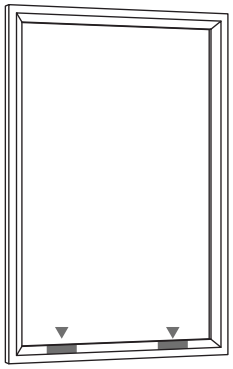
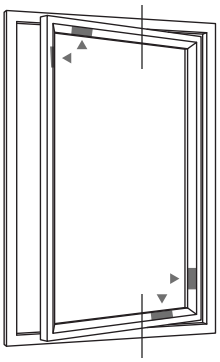
Typical Glazing Procedure

FIXED

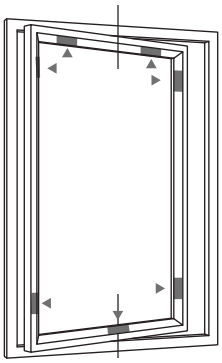


Fixed Light

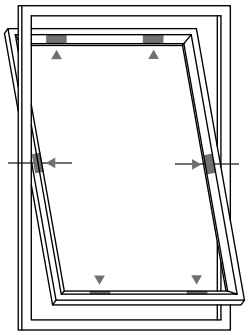
PIVOTING



Vertical Pivot
(hung off-centre)

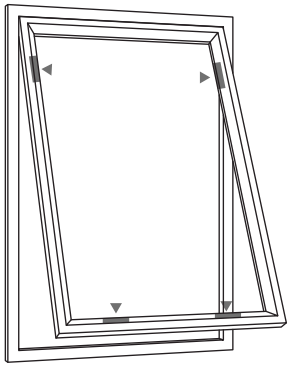


Vertical Pivot
(hung centrally)

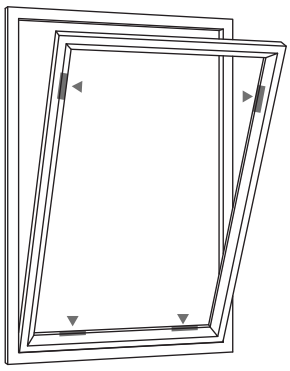


Horizontal Pivot
and reversible

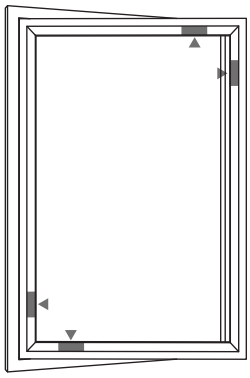
CASEMENT



Top Hung

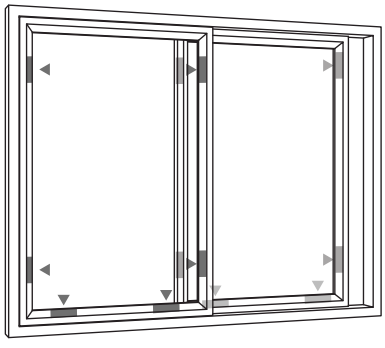


Bottom Hung

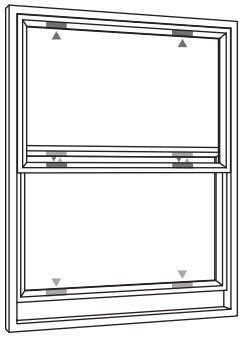


Side Hung

SLIDING



Horizontally sliding
6 setting blocks per pane



Vertically sliding
6 setting blocks per pane

GLAZING

1. Selection of glazing methods.

1.1 Glass Setting Blocks

Glass to metal contact must be avoided at all times by using approved Crealco setting blocks which have a shore hardness of 50 to 90 shore hardness.

Use only setting blocks made of Neoprene, EPDM, Silicone or other elastomeric materials.

Setting blocks are to have a minimum thickness of 3mm & must be at least 27mm in length per square meter of glass area.

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