 AAAMSA Group <small>Corporate Member</small>	<i>ASDA</i> Aluminium Stockists and Distributors Association	
	Crealco Swift 30.5™	SANS 613 2000 Pa <b>A3</b>

SWIFT™ 30.5  
WINDOW (30.5 mm)

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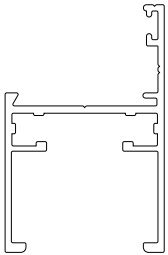
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

SWIFT™ 30.5  
WINDOW (30.5 mm)

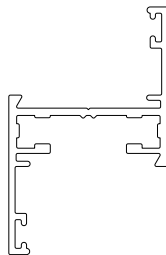
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**Profile Identification**

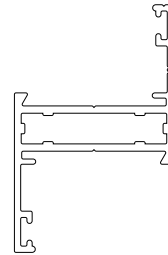
**Swift 30.5 Window Profiles**



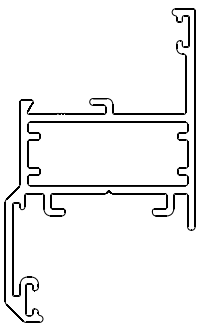
**DIE No. W32028** | **Swift 30.5 Frame  
30mm Equal Leg**



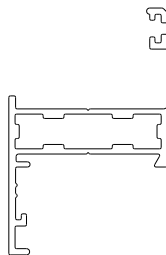
**DIE No. W32027** | **Swift 30.5 Frame  
30mm Unequal Leg**



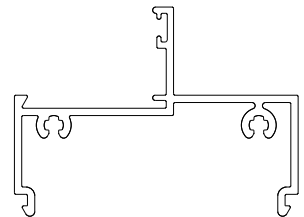
**DIE No. W55684** | **Swift 30.5  
Sash Tubular**



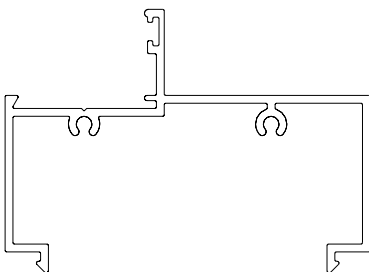
**DIE No. W57602** | **Swift 30.5  
Sash Multi Locking**



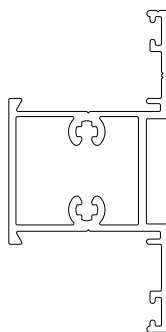
**DIE No. W55441** | **Swift 30.5 Sash  
Picture Frame**



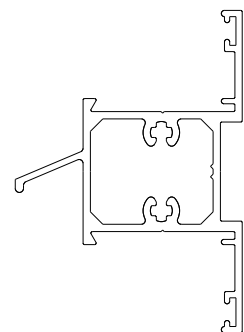
**DIE No. W28481** | **Swift 30.5  
Frame 54mm**



**DIE No. W70968** | **Swift 30.5 Frame  
70mm Sidelight**



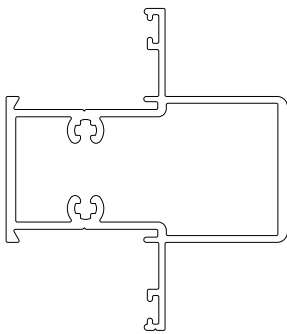
**DIE No. W55685** | **Swift 30.5 Mullion  
30mm**



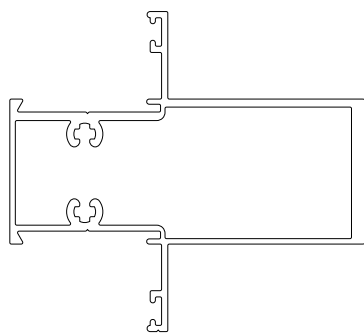
**DIE No. W53630** | **Swift 30.5 Mullion  
30mm Weather Bar**

**Profile Identification**

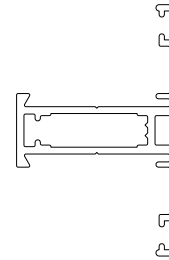
**Swift 30.5 Window Profiles**



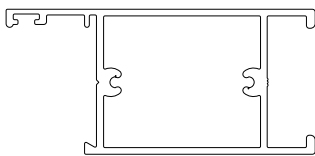
**DIE No. W54651** Swift 30.5 Mullion 54mm



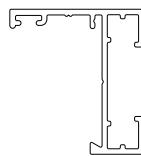
**DIE No. W54652** Swift 30.5 Mullion 70mm



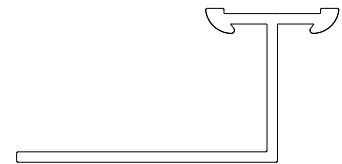
**DIE No. W54867** Swift 30.5 Mullion 30mm Cottage Pane



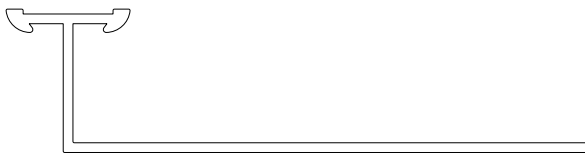
**DIE No. \*W57051** Swift 30.5 Sidelight Sill 65mm



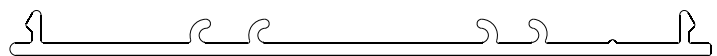
**DIE No. W36831** Swift 30.5 Frame Short Leg



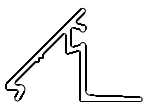
**DIE No. W28002** Swift 30.5 Fixing Lug Twist In's



**DIE No. W34190** Swift 30.5 Fixing Lug Twist-In L



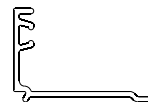
**DIE No. W30607** Fixing Lug



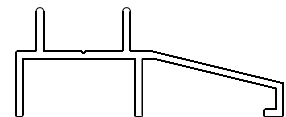
**DIE No. W27991** Swift 30.5 Bead 4&5mm



**DIE No. W28325** Swift 30.5 Bead 6mm



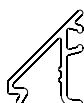
**DIE No. W34657** Swift 30.5 Bead Dbl Glz 23mm Gap



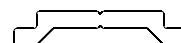
**DIE No. \*W32205** Swift 28 Sill Rail



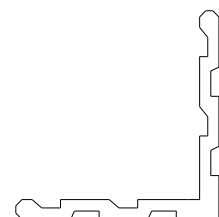
**DIE No. W31139** Swift 30.5 Bead Multi 13mm Gap



**DIE No. W35620** Swift 30.5 Bead Multi Locking



**DIE No. W29131** Locking Bar



**DIE No. W52695** Swift 28 Corner Cleat 50mm

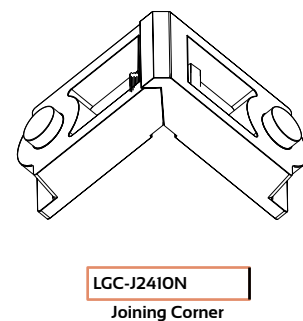
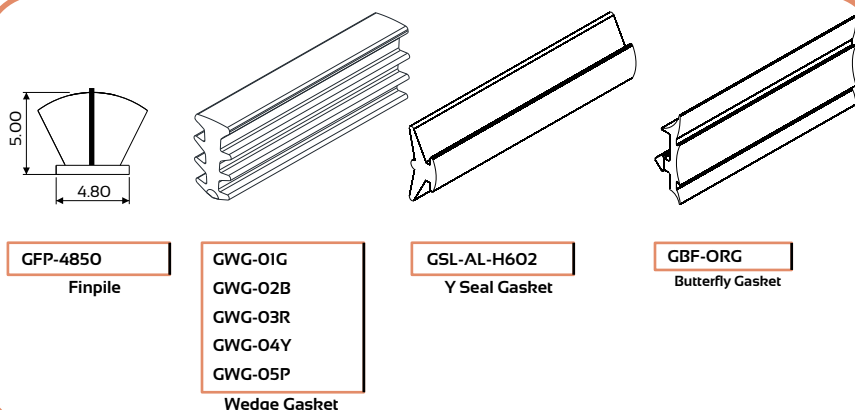
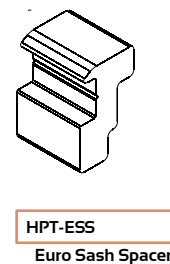
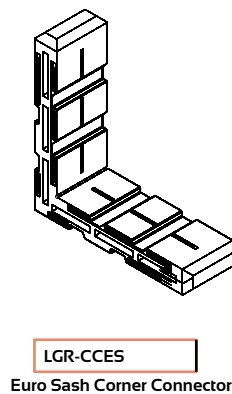
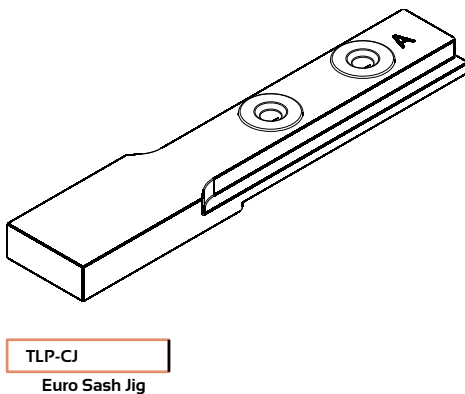
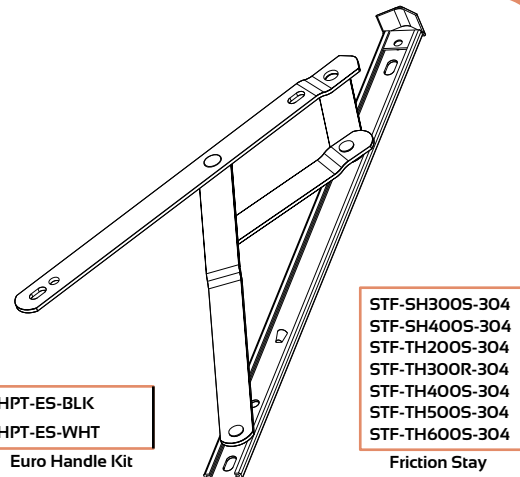
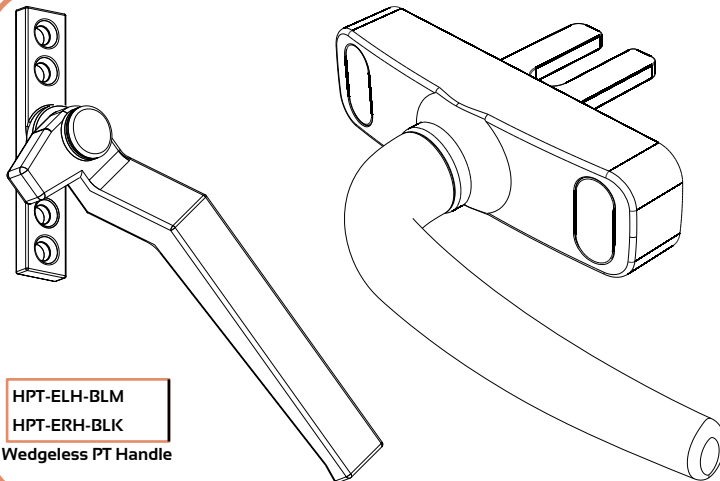
\* - Non-Stock Item (only available from the mill)



## Hardware Components

### RECOMMENDED SWIFT 30.5 COMPONENTS

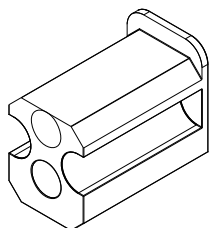
All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on [www.crealco-components.com](http://www.crealco-components.com)



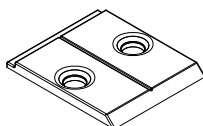
## Hardware Components

### RECOMMENDED SWIFT 30.5 COMPONENTS

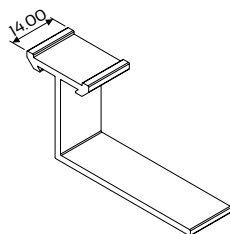
All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on [www.crealco-components.com](http://www.crealco-components.com)



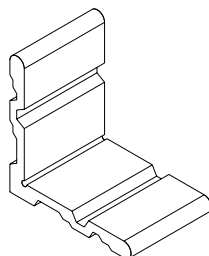
**LGR-CC305B**  
30.5 Cross Connector  
PVC (Black)



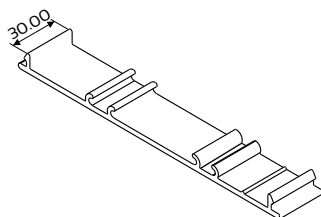
**LGR-MP305B**  
Swift 30.5  
Glazing Bar Packer (Black)



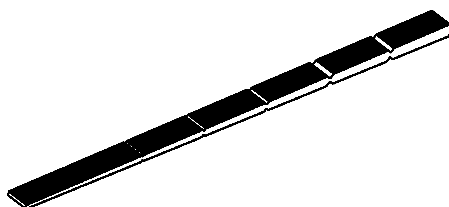
**LGF-TL305-28002**  
Swift 30.5 Twist  
Lug 14mm



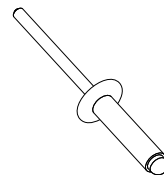
**LGC-52695-305;  
LGC-305-PVC**  
Cleat Corner Alu Swift 30.5;  
Cleat Corner PVC 30.5



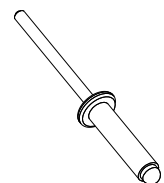
**LGF-MULTI**  
Multi Fixing Lug



**FSN-CSB**  
Glass Setting Blocks



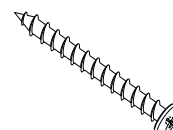
**FRC-410**  
C/Sunk Rivet



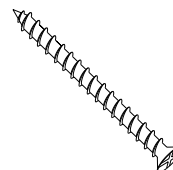
**FRD-4810**  
Dome Rivet



**FSC-0809HBP**  
Screw POSI S/S  
ST CS Handle 8x9



**FSP-0830P-SS**  
Screw POSI S/S  
ST PH 8x30



**FSC-0840P-SS**  
Screw POSI S/S  
ST CS 8x40

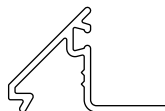




(A)

GBF-ORG

Butterfly Orange  
H500 Gasket



DIE No. W31139

Swift 30.5 Bead  
Multi 13mm Gap



Wedge Gasket

(B)



GWG-01G

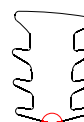


Wedge Gasket

(C)



GWG-02B



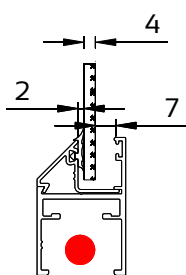
Wedge Gasket

(D)

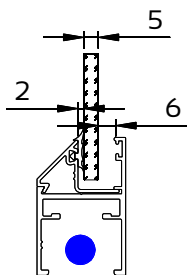


GWG-03R

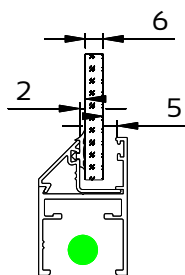
## WEDGES



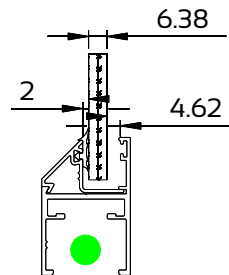
A+D



A+C



A+B

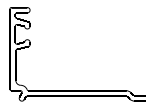


A+B



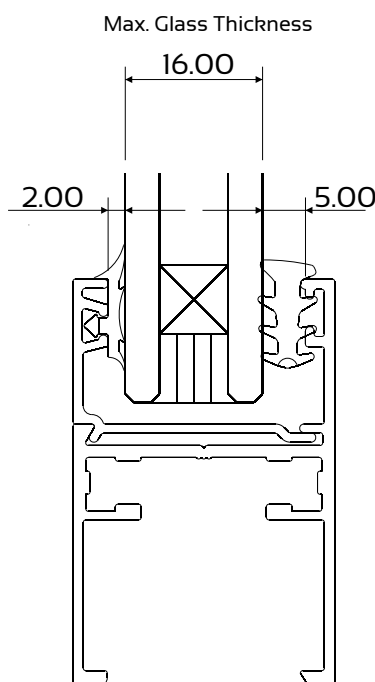
GBF-ORG

● Butterfly Orange  
H500 Gasket



DIE No. W34657

Swift 30.5 Bead  
Dbl Glz 23mm Gap

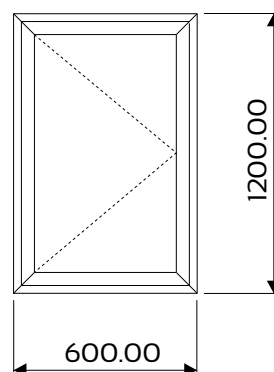
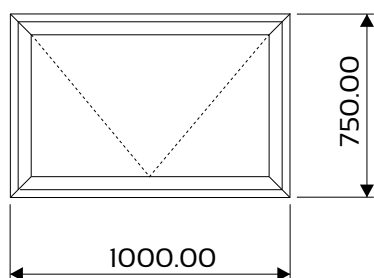


## Wedge Gasket Chart

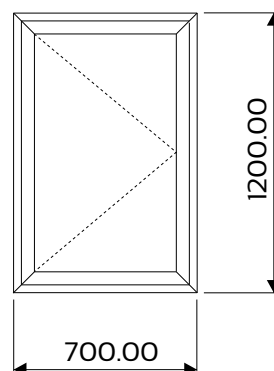
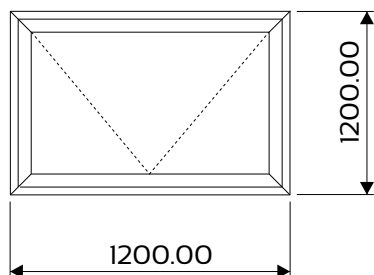
Code	Description	Wedge Gap To Fit
GWG-01G	Wedge 01 Green 6mm & 6.38mm Glass	4.10mm To 5.50mm
GWG-02B	Wedge 02 Blue 5mm Glass	5.60mm To 6.70mm
GWG-03R	Wedge 03 Red 4mm Glass	6.80mm To 7.50mm
GWG-05P	Wedge 01 Purple 20mm Double Glazing	7.60mm To 8.80mm

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	W55684	1000	750
Side Hung		600	1200



MULTI LOCK SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W57602	1200	1200
Side Hung		700	1200



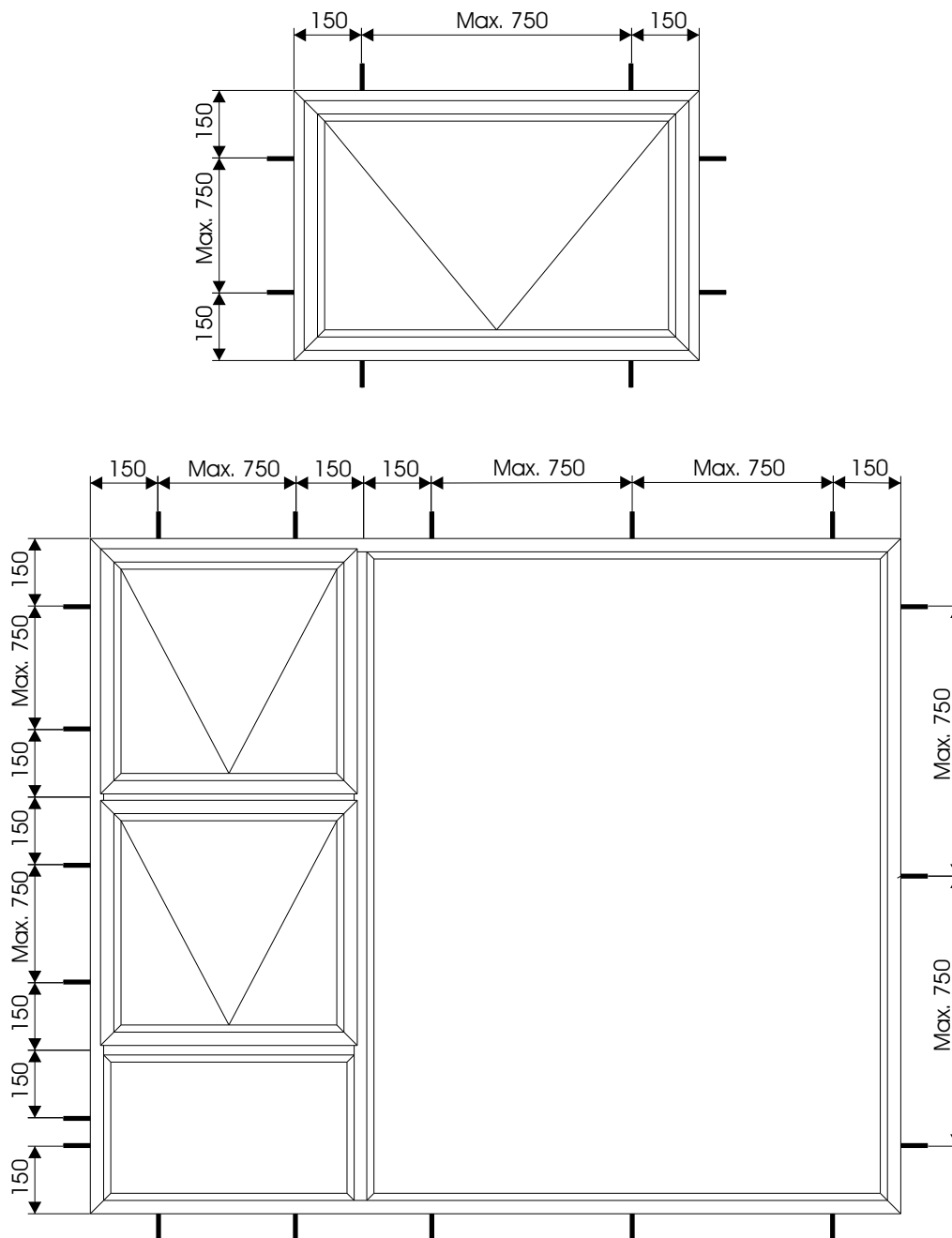
## Typical Fastening Positions

**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.

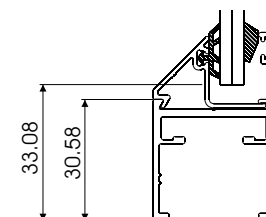
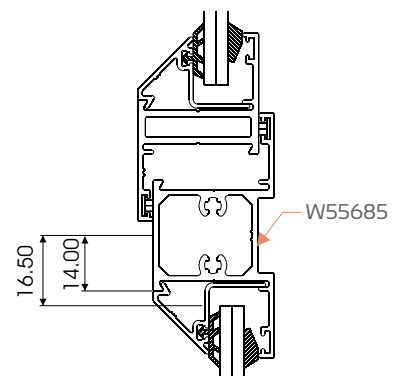
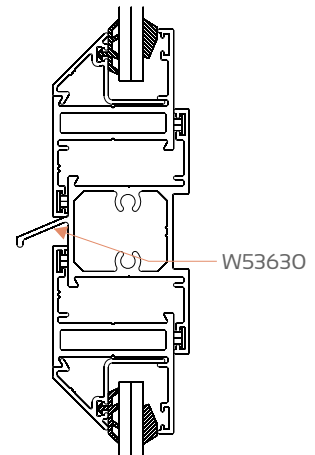
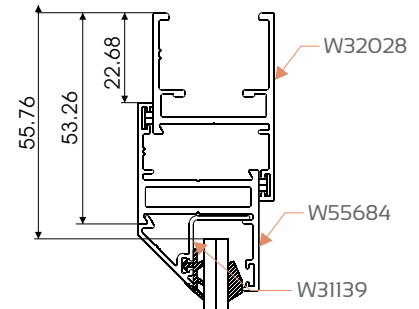
**DISCLAIMER:** Please note that fixation of the frame to the structure is an element which **MUST** be specified and certified by an appropriate engineer and is not the responsibility of Wispeco.



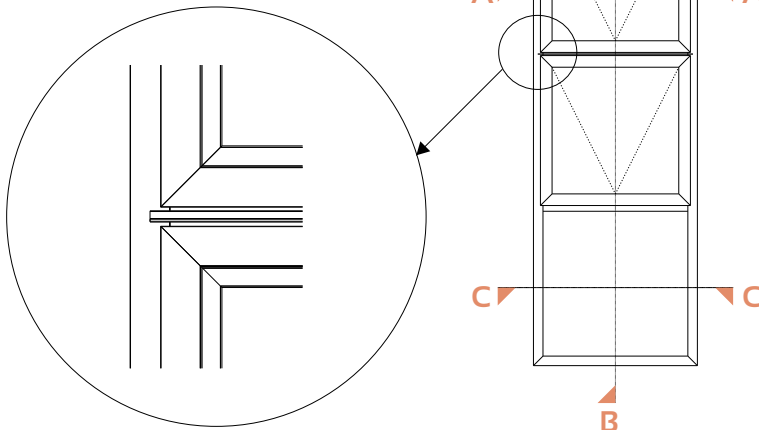
## Typical Cross-sectional Details

### Double Top Hung Over Fixed

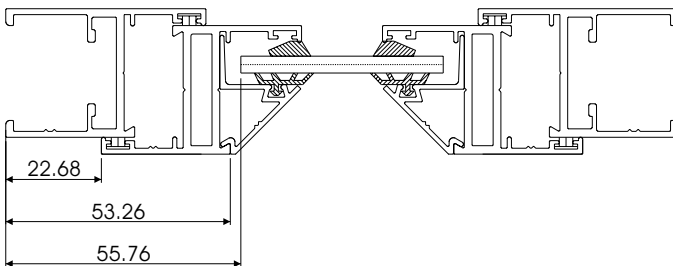
#### SECTION B-B Section not to scale



SHOWING TRANSOM WITH  
WEATHER BAR OVERLAP



#### SECTION A-A Section not to scale

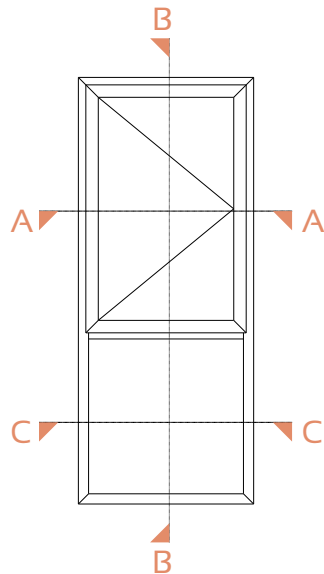


#### SECTION C-C Section not to scale



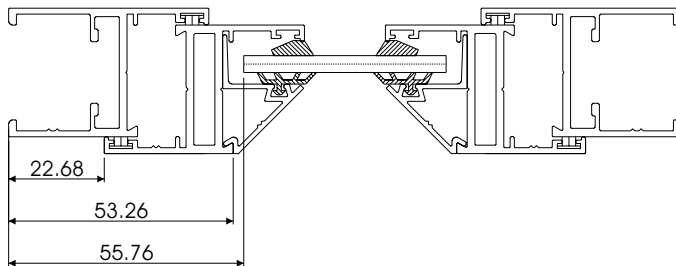
## Typical Cross-sectional Details

### Side Hung Over Fixed



#### SECTION A - A

Section not to scale



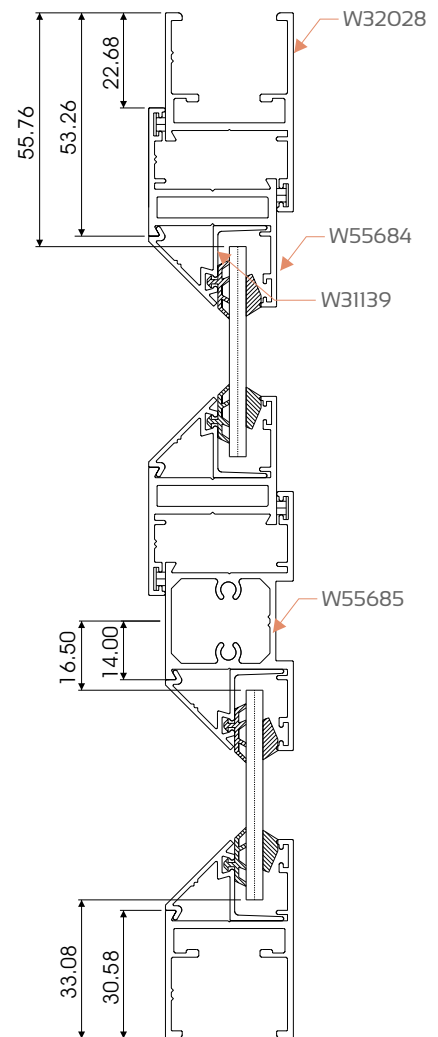
#### SECTION C - C

Section not to scale



#### SECTION B - B

Section not to scale

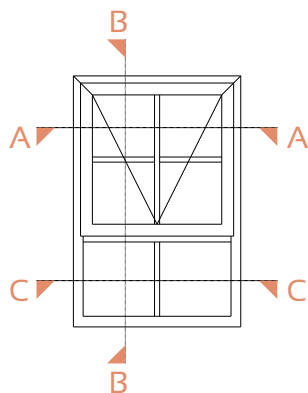
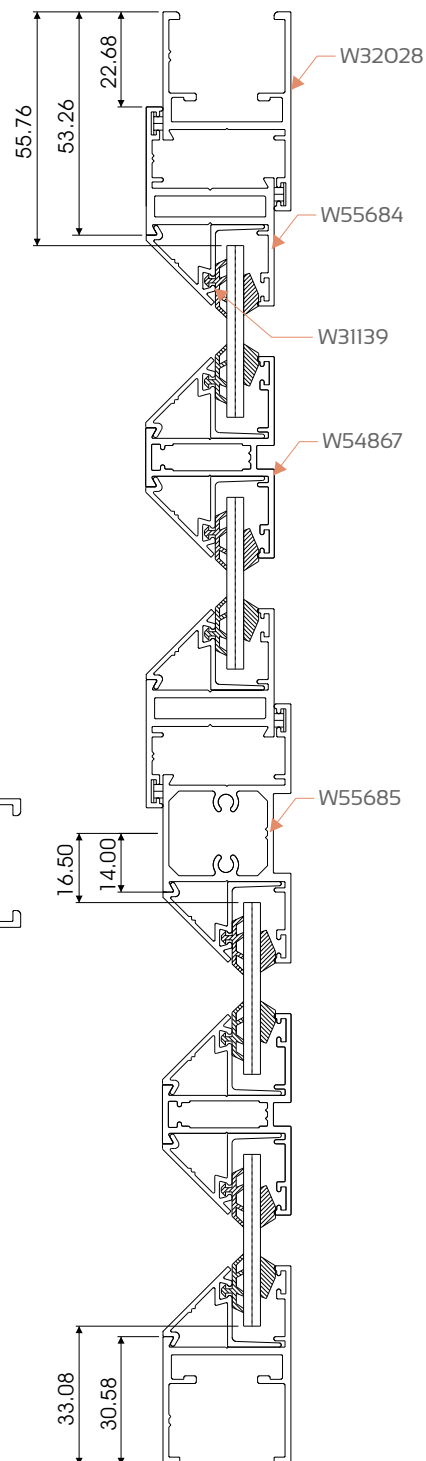


## Typical Cross-sectional Details

### Cottage Pane 2x2 Top Hung Over 2x1 Fixed Panel

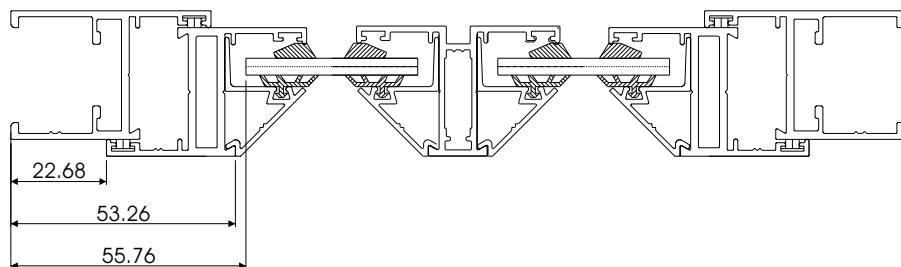
#### SECTION B-B

Section not to scale



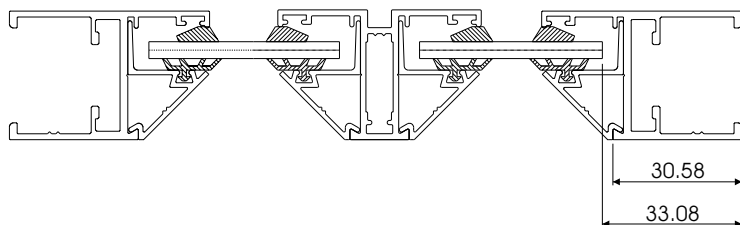
#### SECTION A - A

Section not to scale



#### SECTION C-C

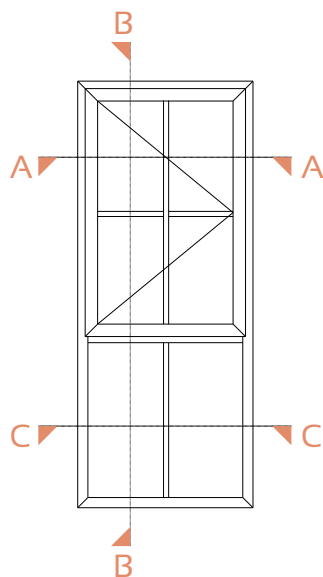
Section not to scale



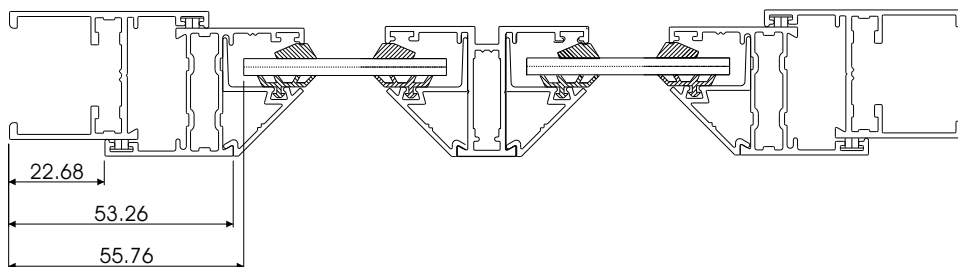


## Typical Cross-sectional Details

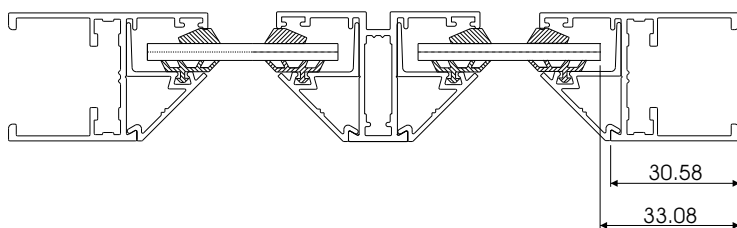
### Cottage Pane Side Hung Over Fixed Panel



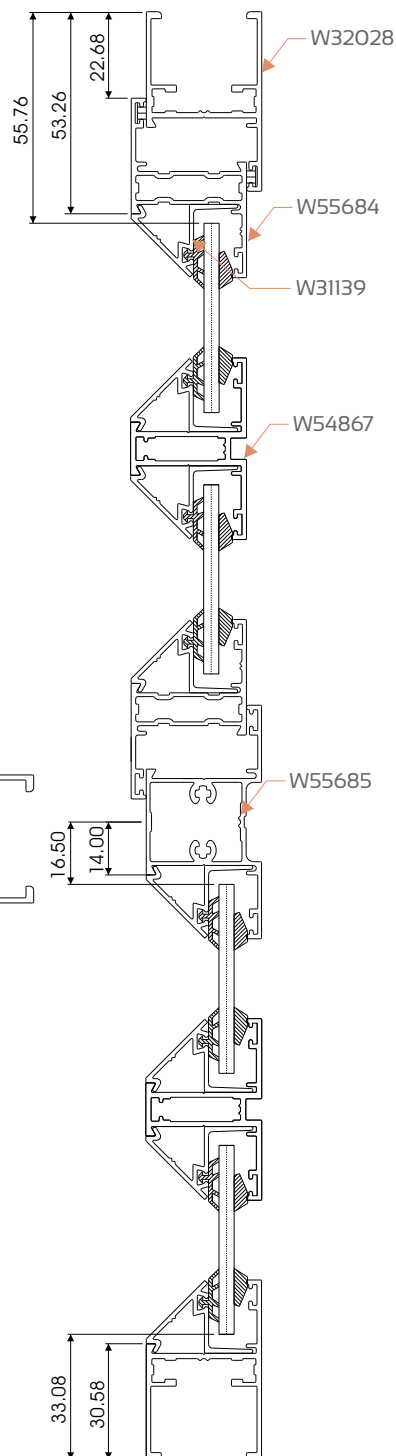
**SECTION A - A**  
Section not to scale



**SECTION C-C**  
Section not to scale

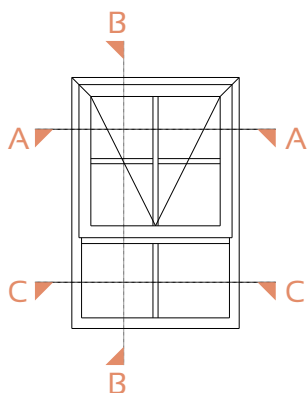


**SECTION B-B**  
Section not to scale

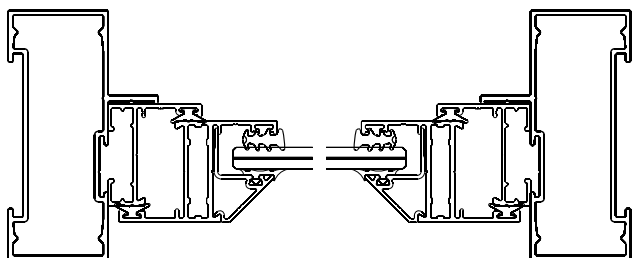


## Typical Cross-sectional Details

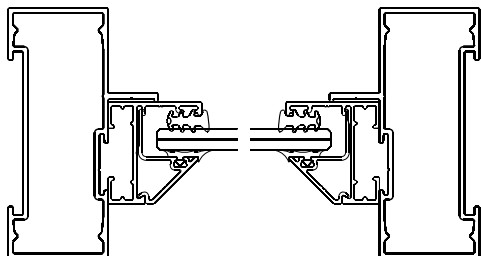
### Cottage Pane 2x2 Top Hung Over 2x1 Fixed Panel



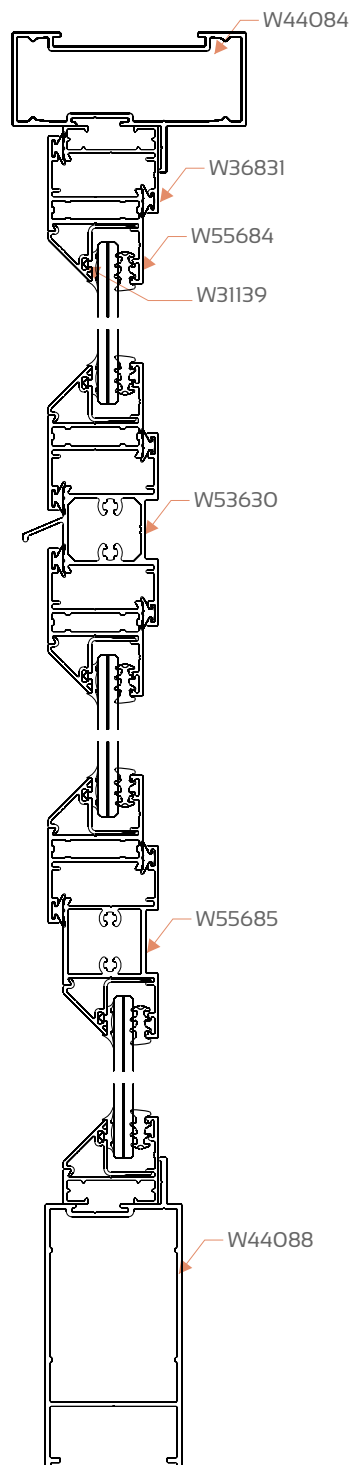
**SECTION A - A**  
Section not to scale

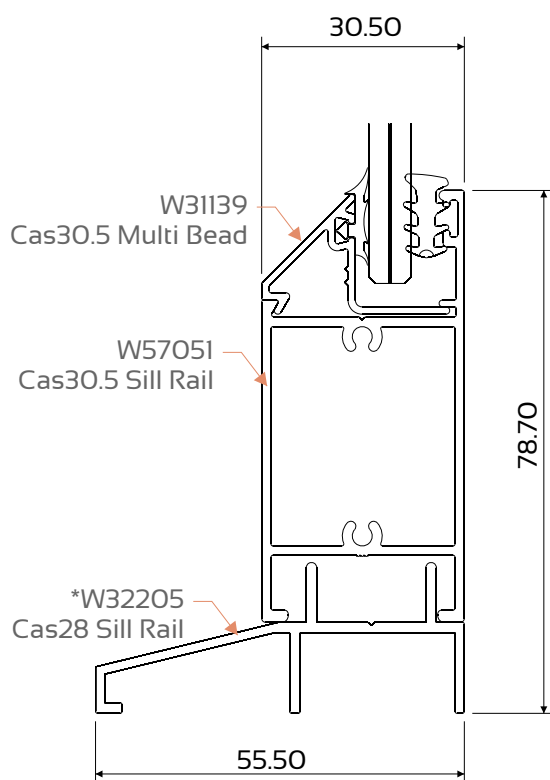


**SECTION C - C**  
Section not to scale

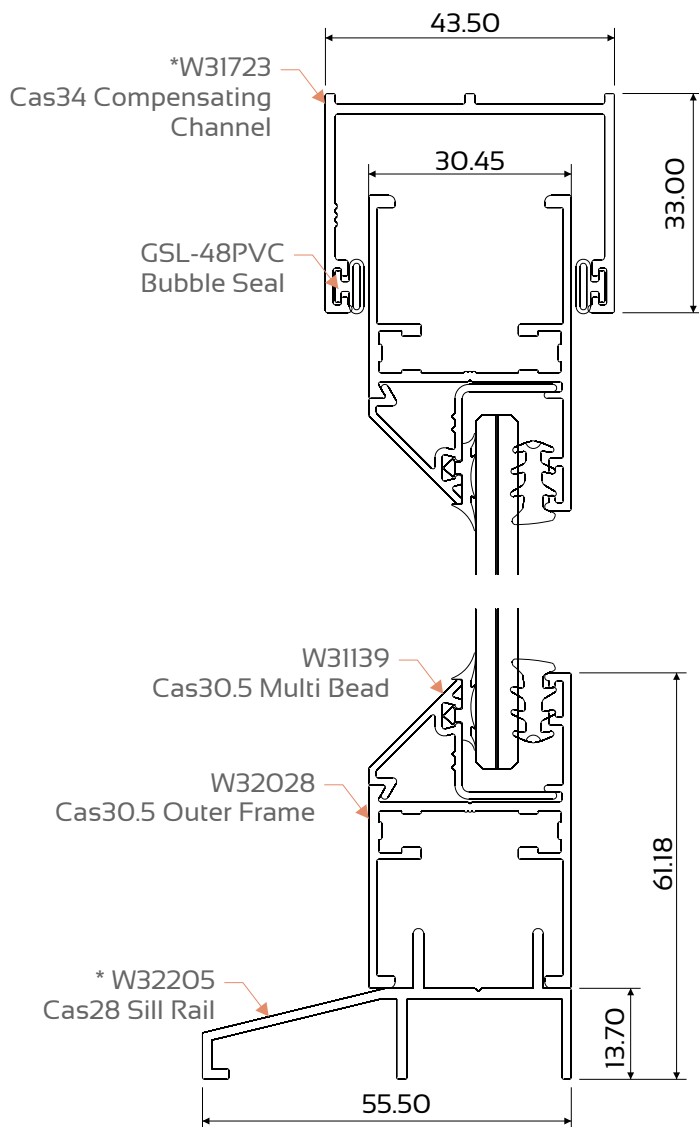


**SECTION B - B**  
Section not to scale



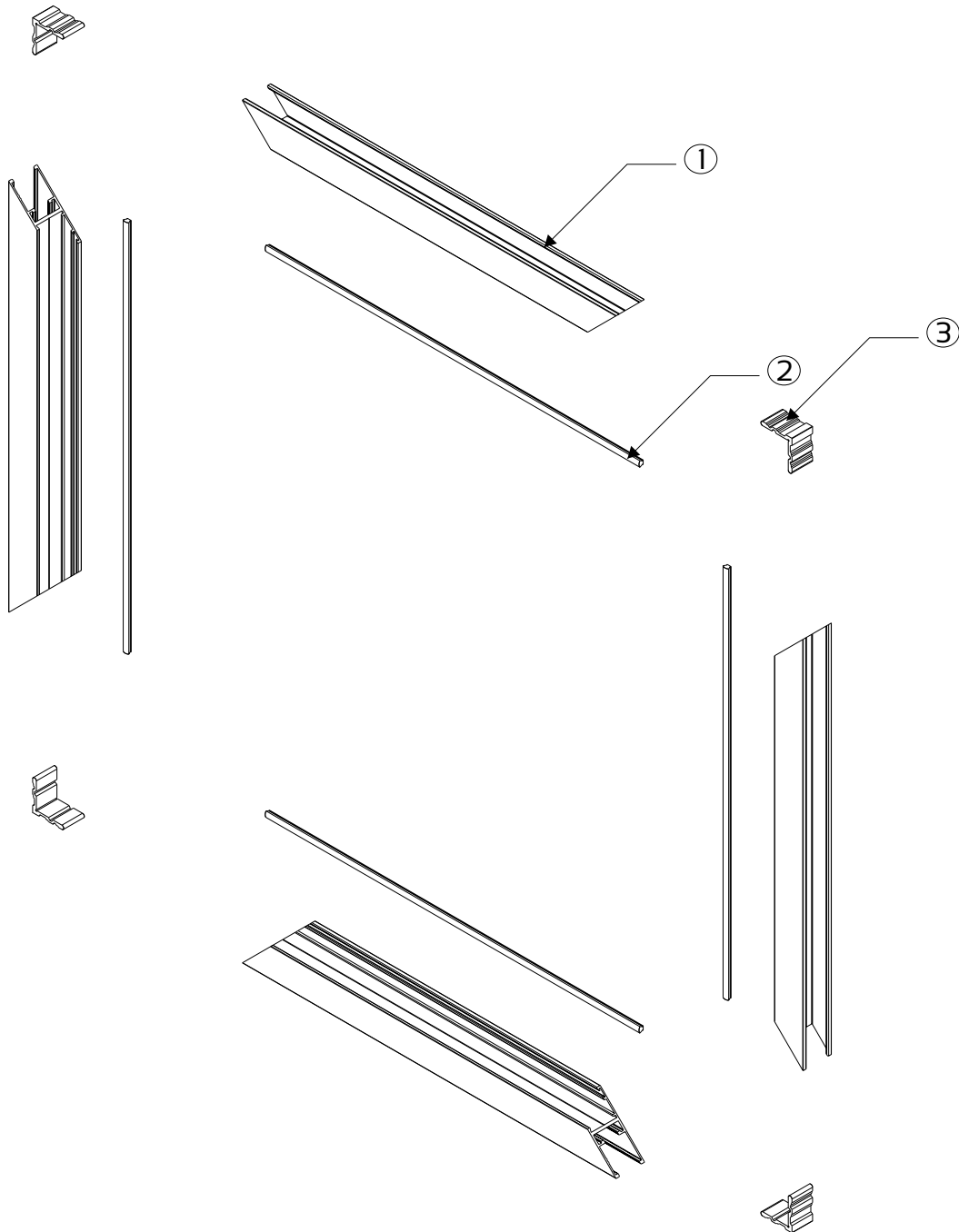


Typical Vertical Section showing High Rise Sill Detail



Typical Vertical Section showing Comp Channel & Sill Detail

\* - Non-Stock Dies

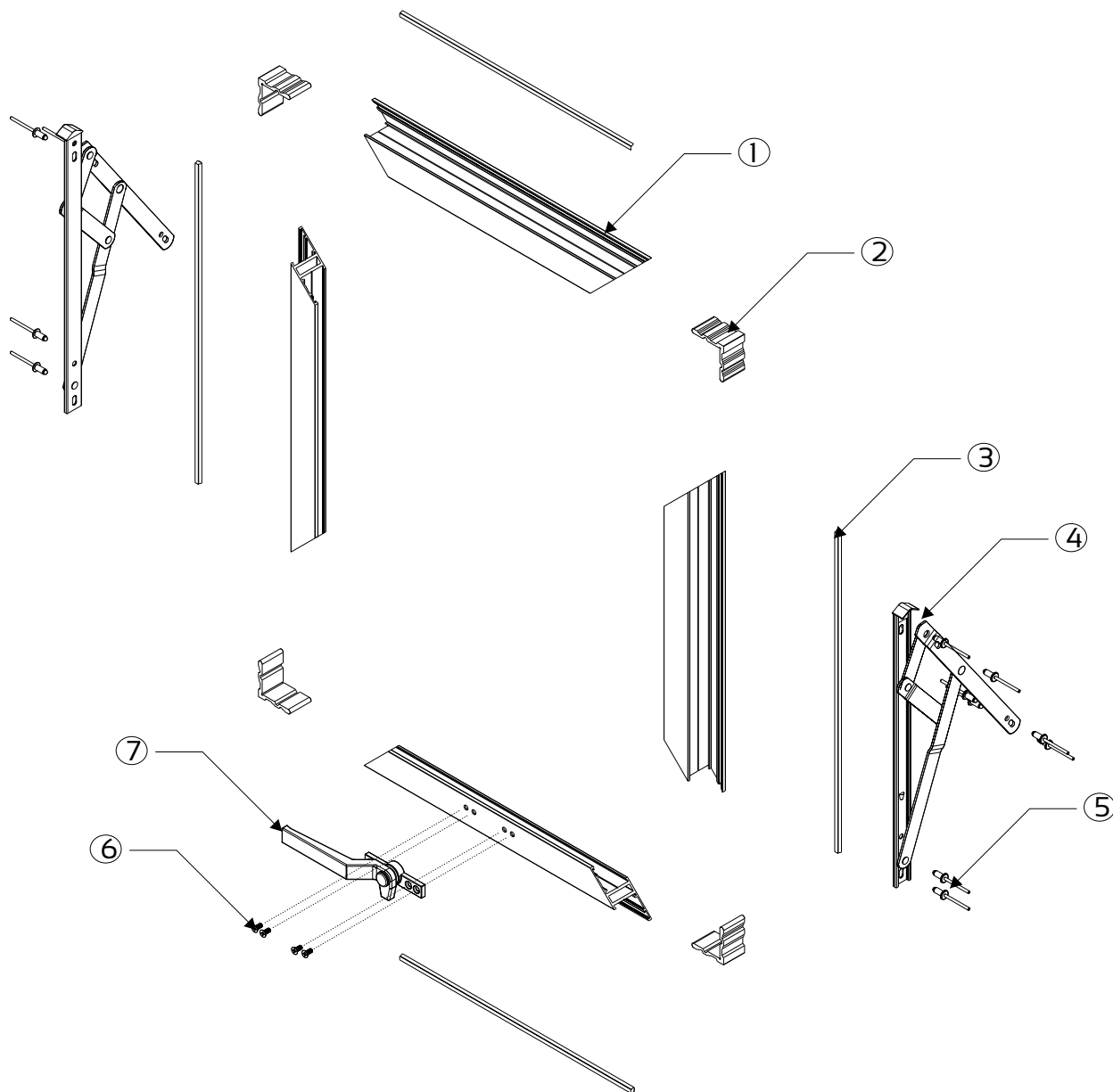


### System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W32028	Frame 30mm Equal Leg Standard

### Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Finpile	Finpile
3	4	Corner Cleat	Swift 30.5 Corner Cleat 40mm



### System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W55684	Sash Tubular Standard

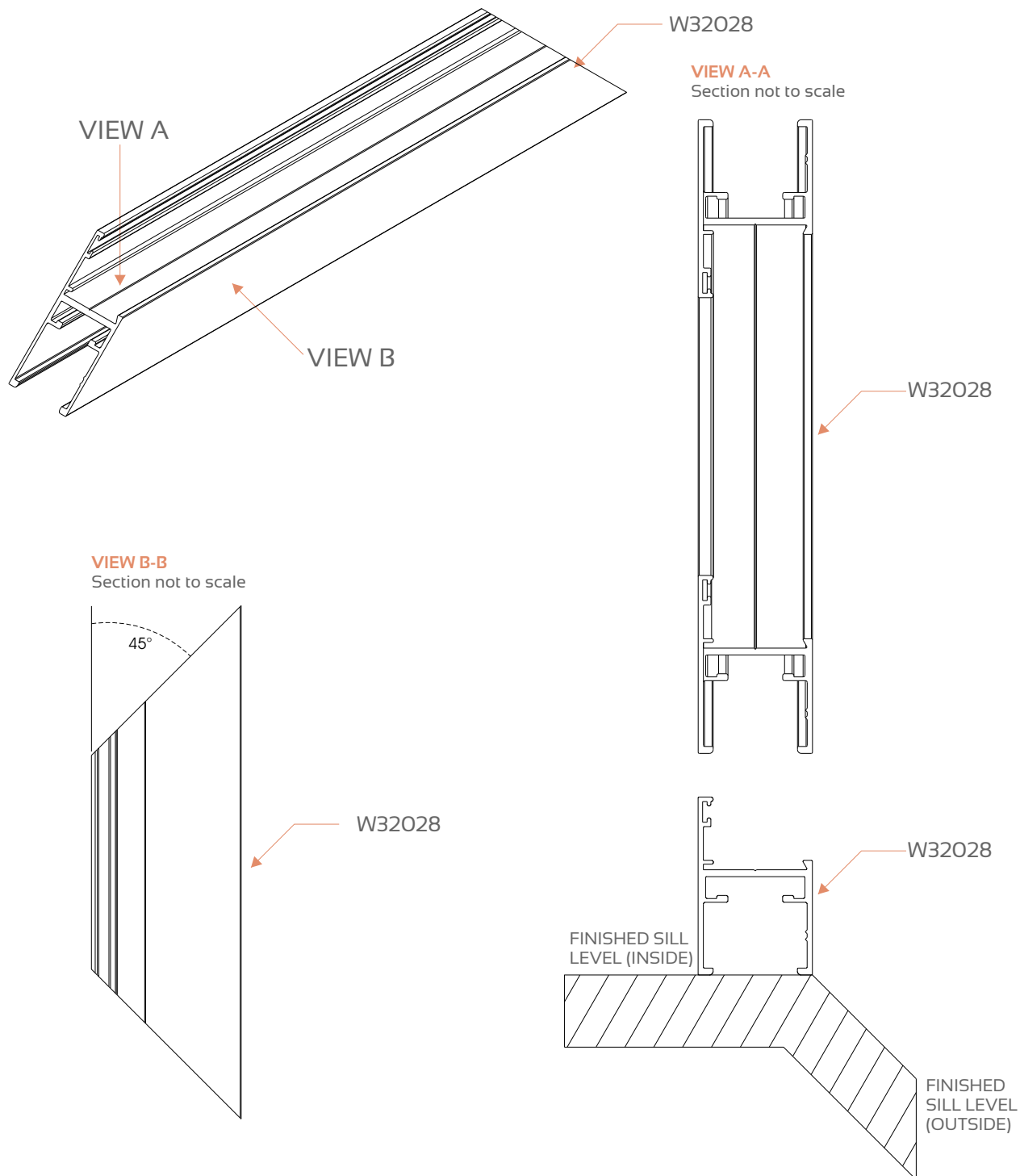
### Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Corner Cleat	Swift 30.5 Corner Cleat 40mm
3	4	Finpile	Finpile
4	2	Friction Stay	Friction Stay
5	12	Pop Rivet	C/Sunk/Dome Rivet
6	4	Screw	Handle Screw Blunt Point
7	1	Handle	Euroline PT Handle

## Typical Outer Frame Machining Details

### Equal Leg

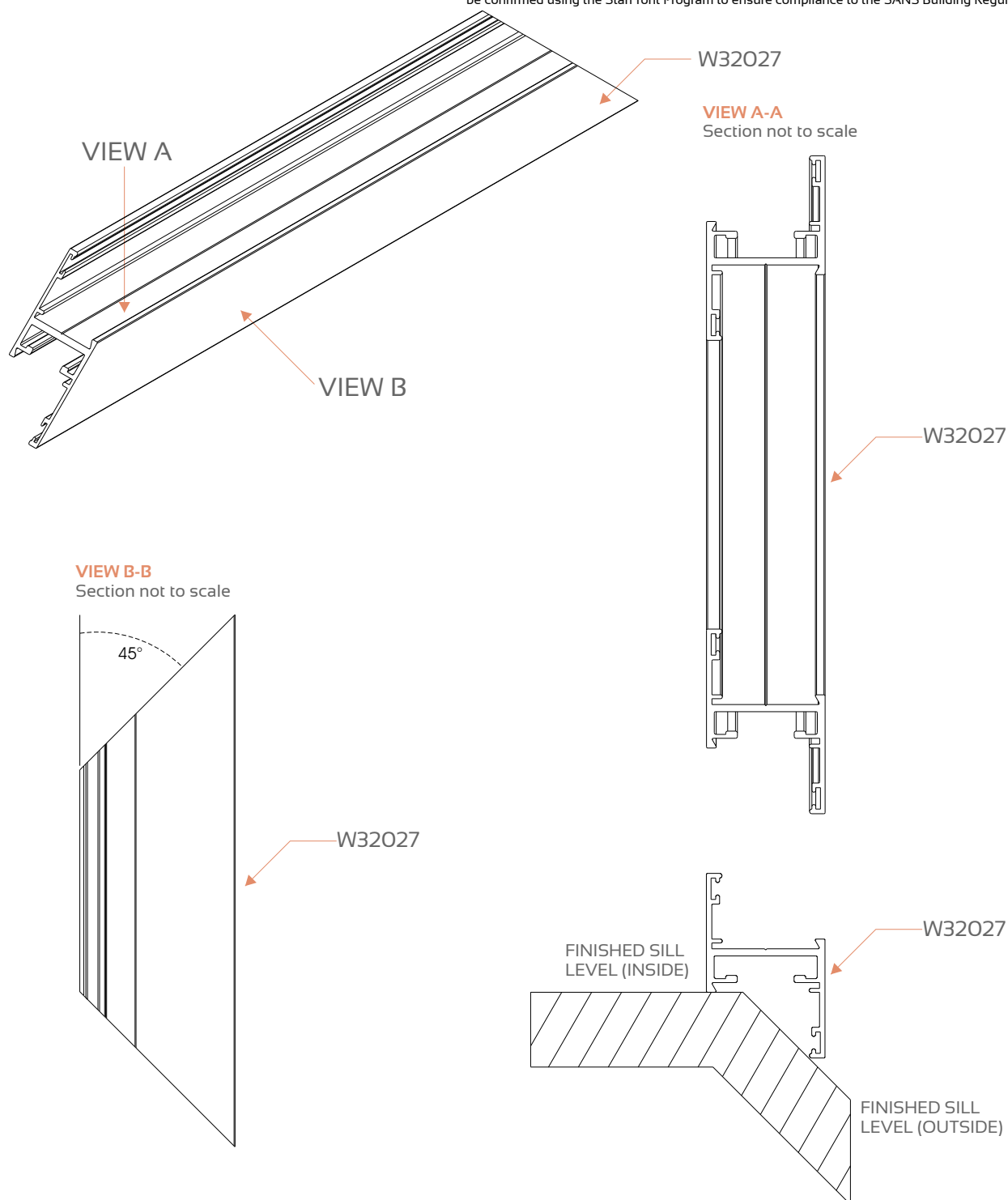
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Outer Frame Machining Details

### Unequal Leg

**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.

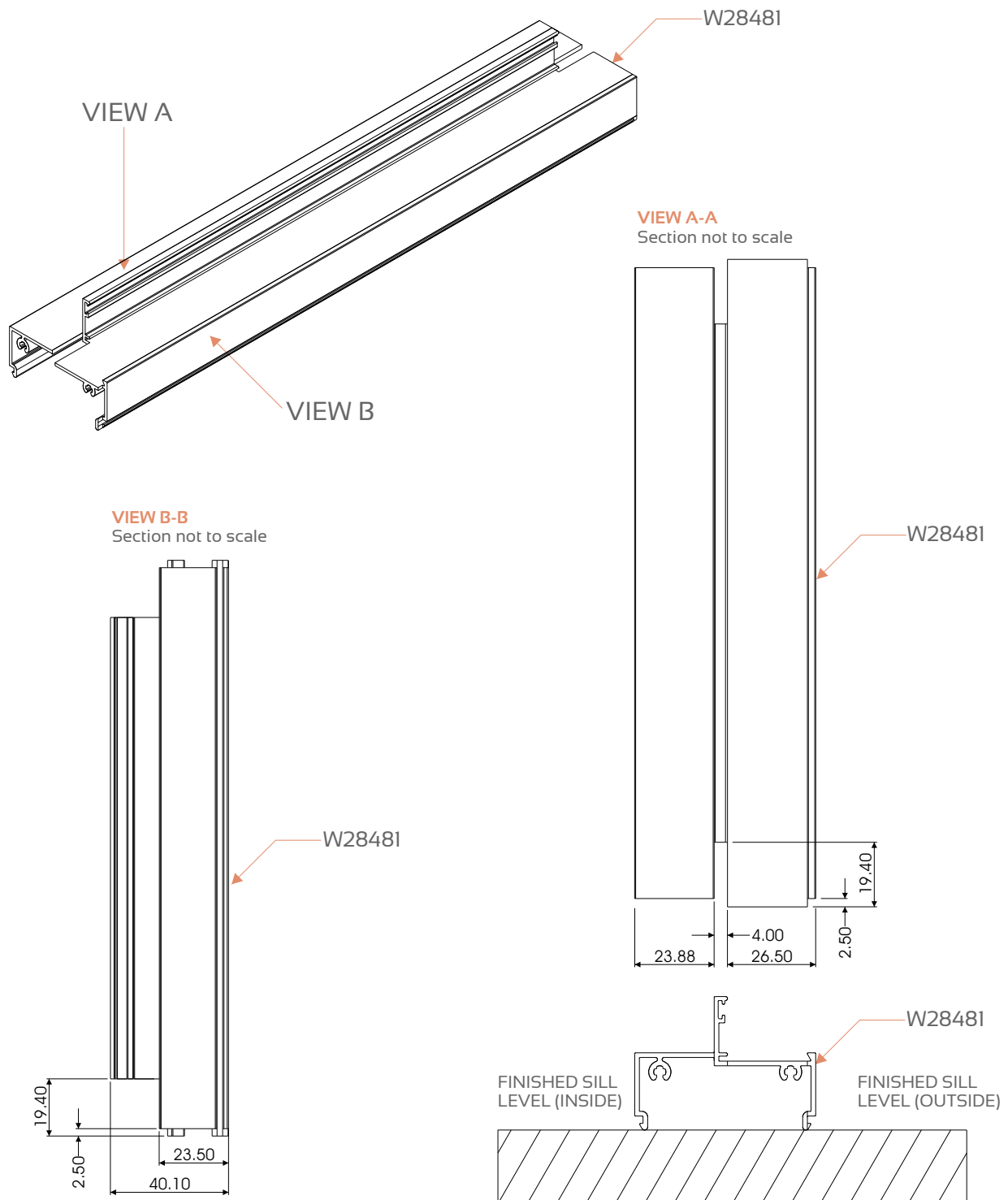




## Typical Outer Frame Machining Details

54mm

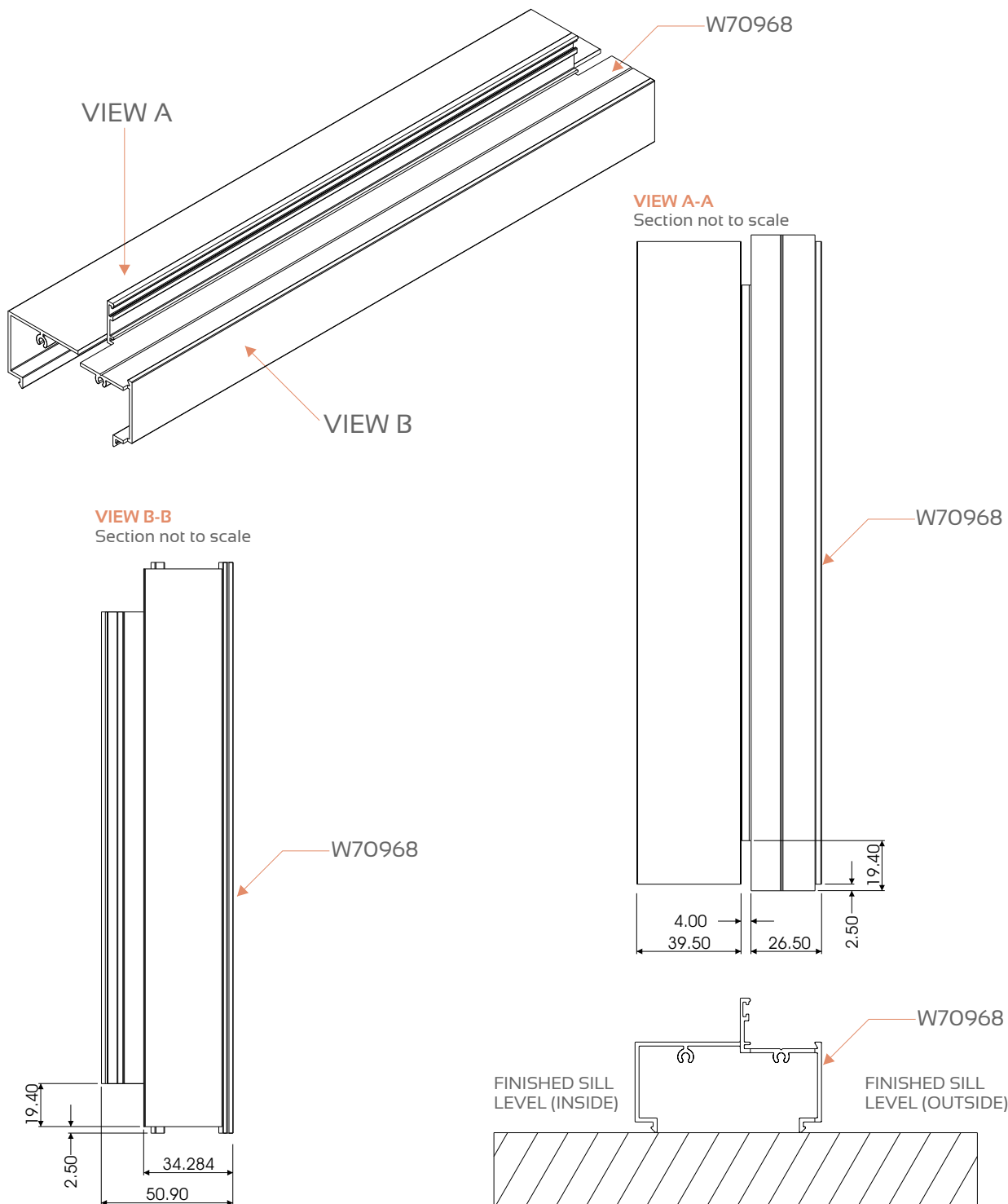
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



**Typical Outer Frame Machining Details**

70mm

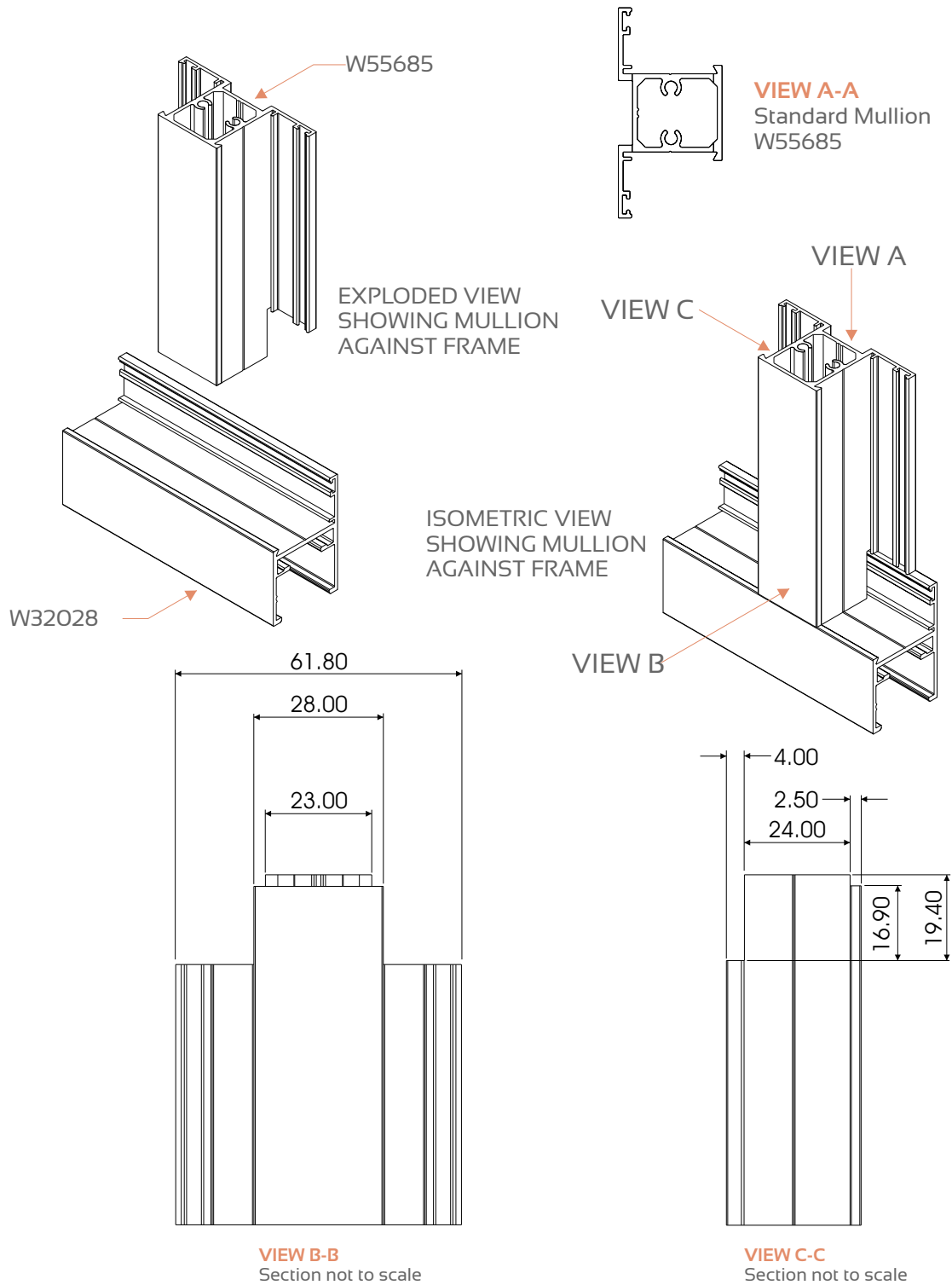
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Mullion Machining Details

### Standard Machining Detail for End Milling on Equal Leg Outer Frame

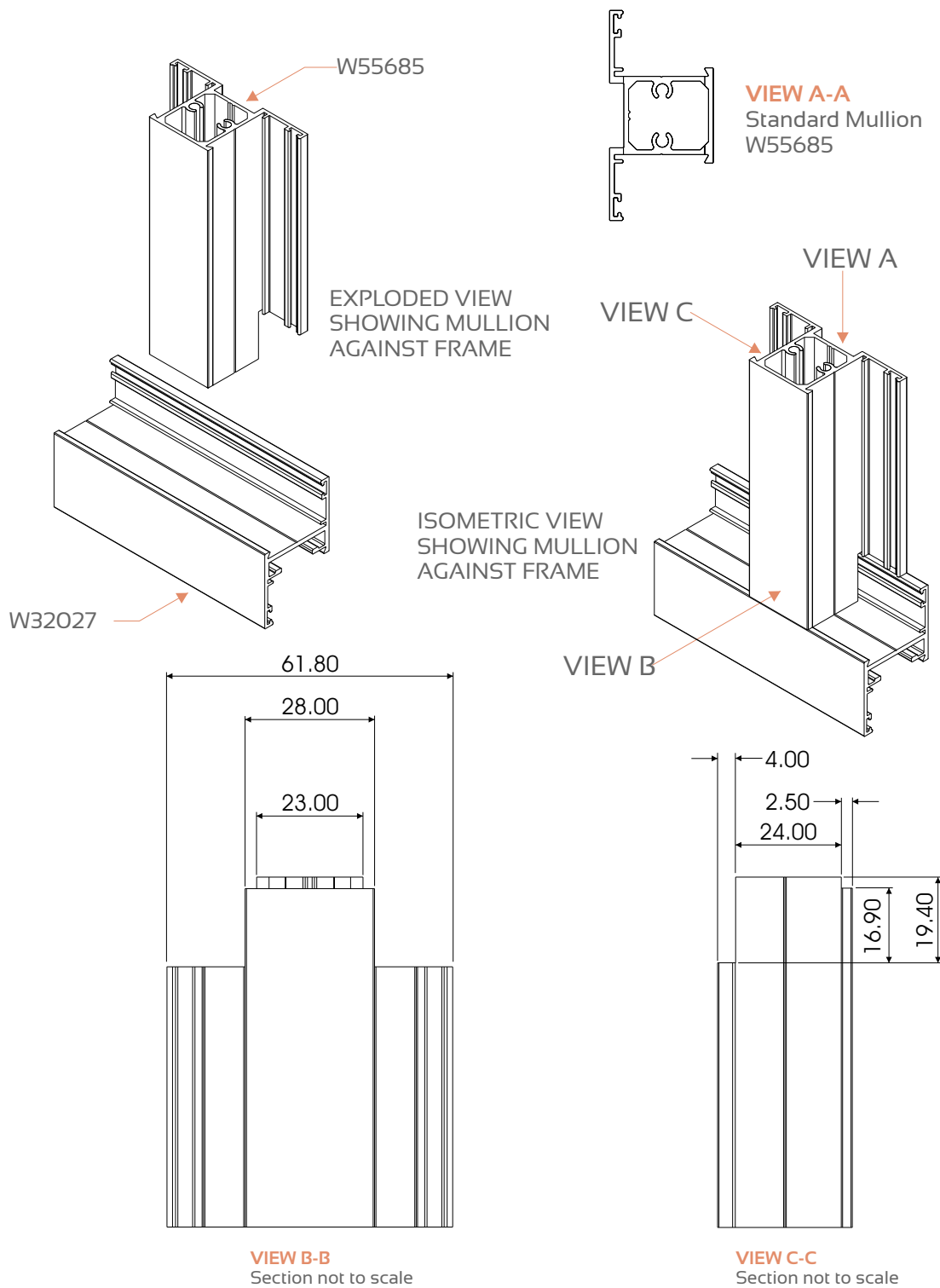
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Mullion Machining Details

### Standard Machining Detail for End Milling on Unequal Leg Outer Frame

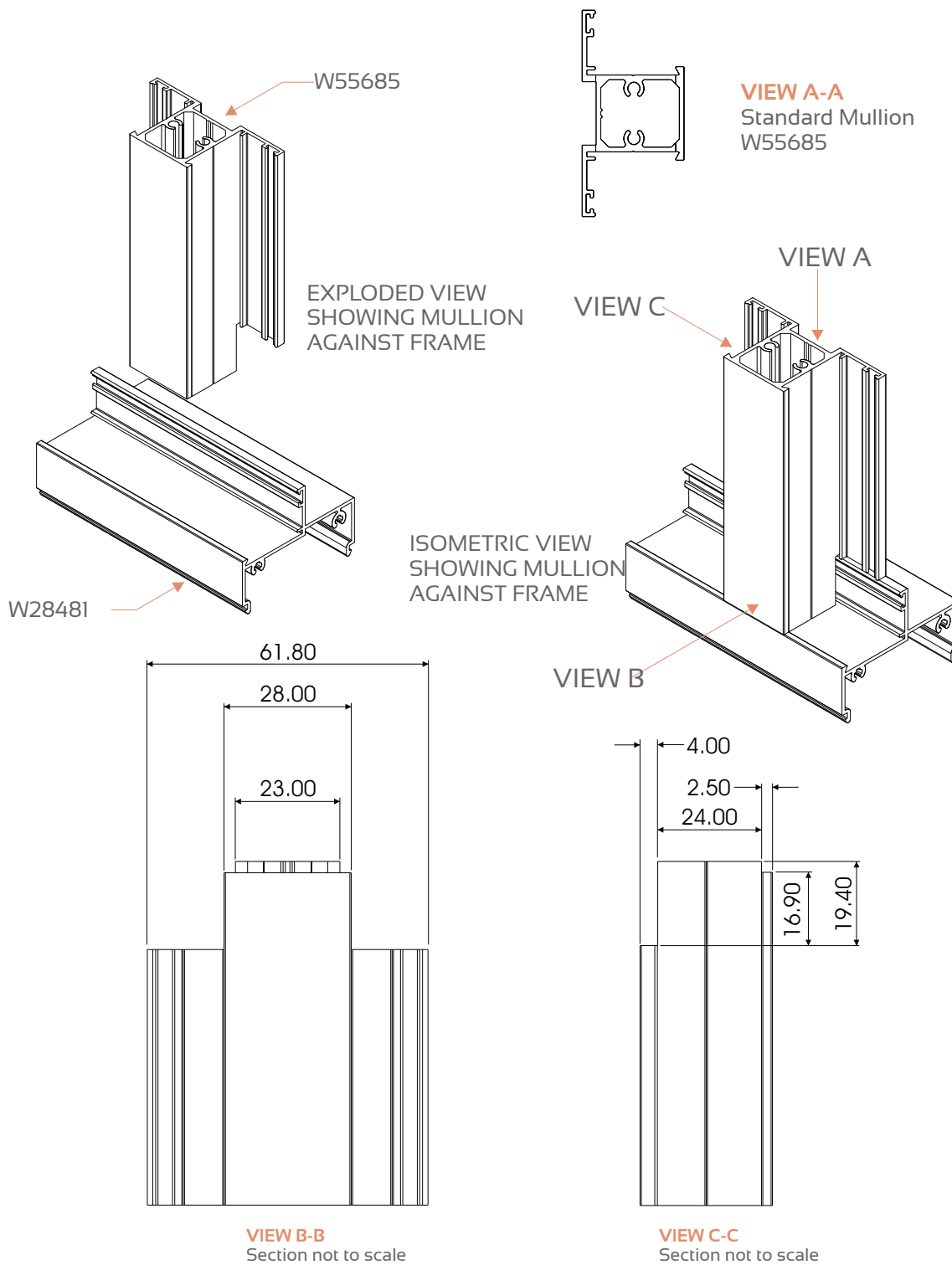
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Mullion Machining Details

### Standard Machining Detail for End Milling on 54mm Outer Frame

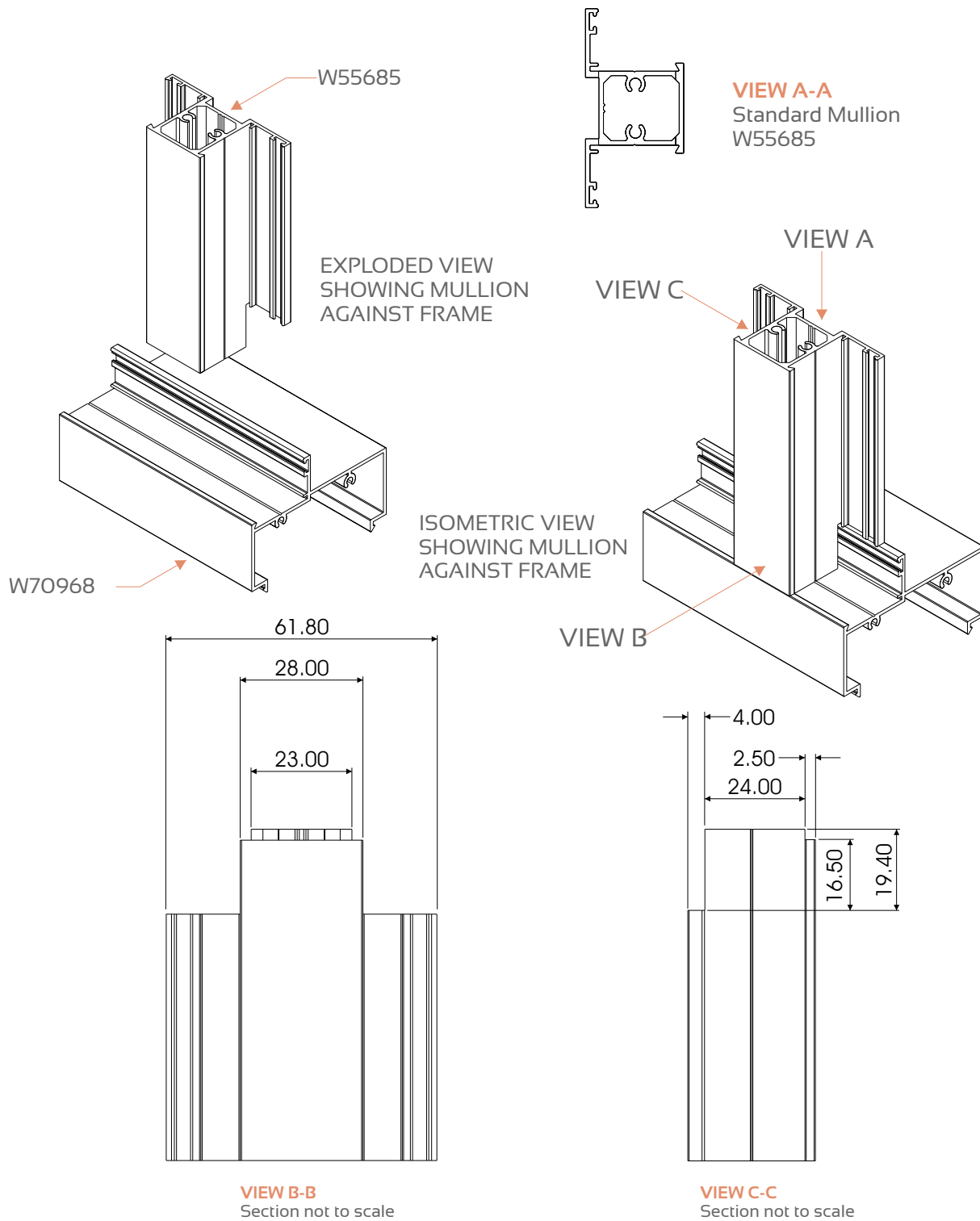
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Mullion Machining Details

### Standard Machining Detail for End Milling on 70mm Outer Frame

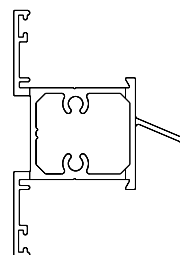
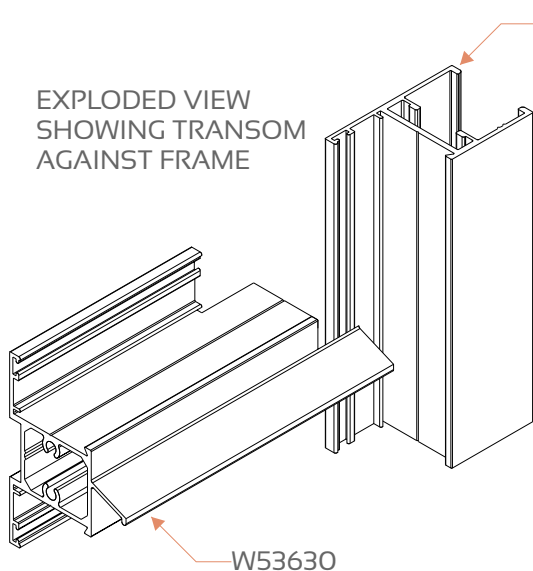
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Transom with W/Bar Machining Detail

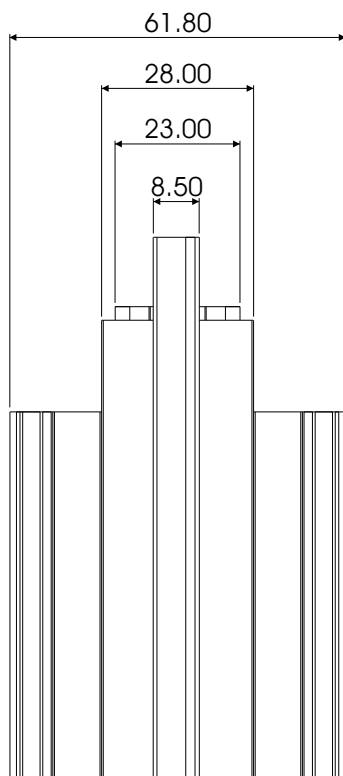
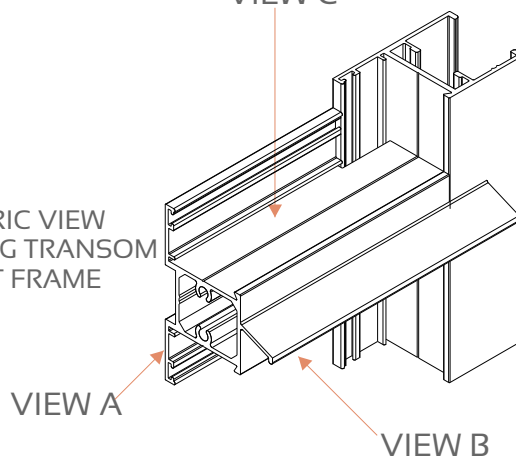
for End Milling on Equal Leg Outer Frame

**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.

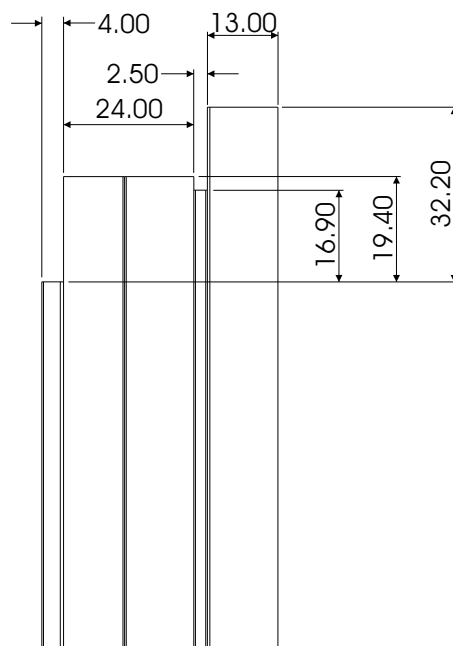


ISOMETRIC VIEW  
SHOWING TRANSOM  
AGAINST FRAME

**VIEW C**



**VIEW B-B**  
Section not to scale



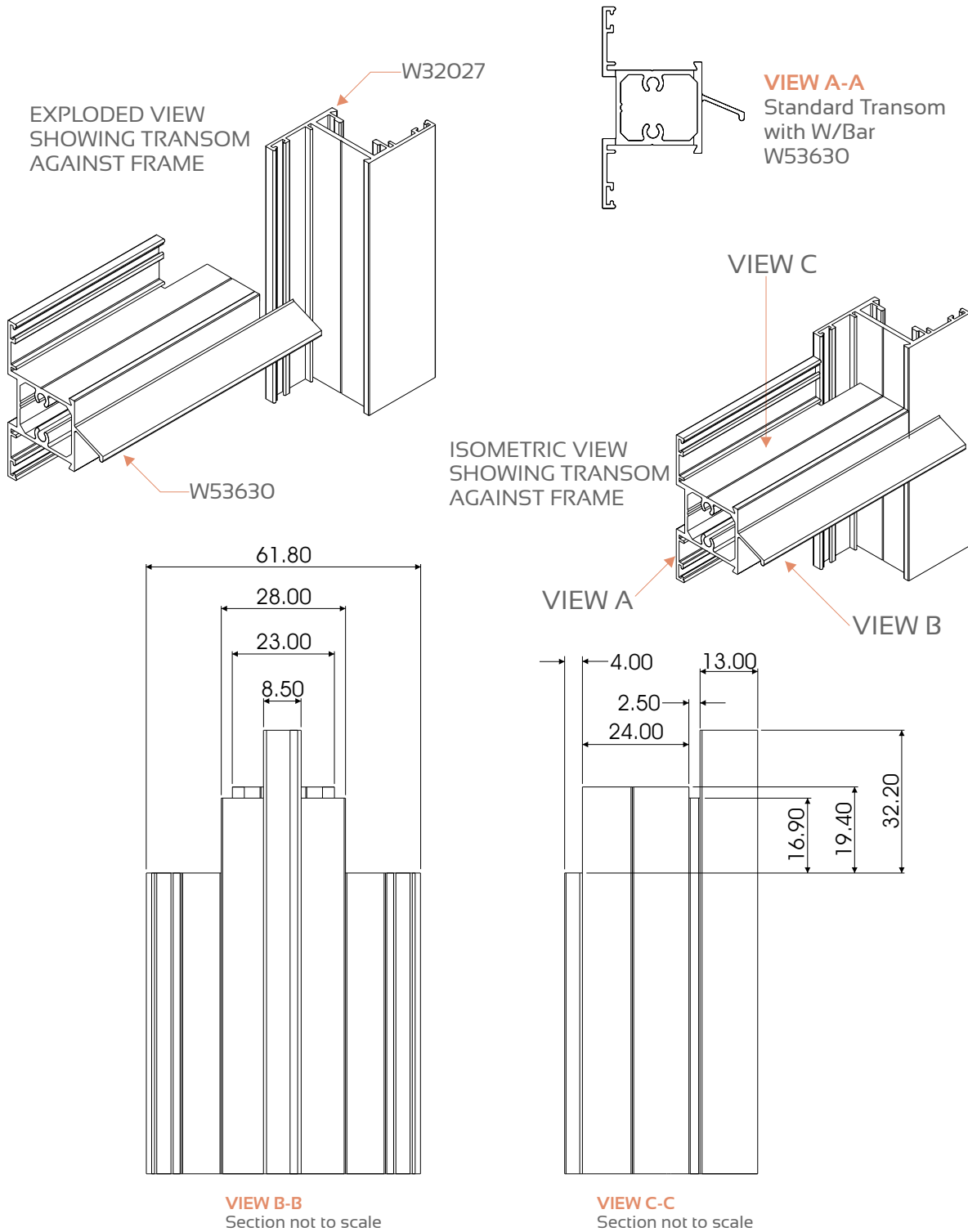
**VIEW C-C**  
Section not to scale



## Typical Transom with W/Bar Machining Detail

for End Milling on Unequal Leg Outer Frame

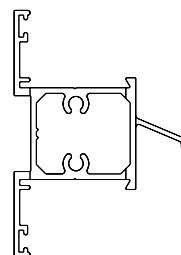
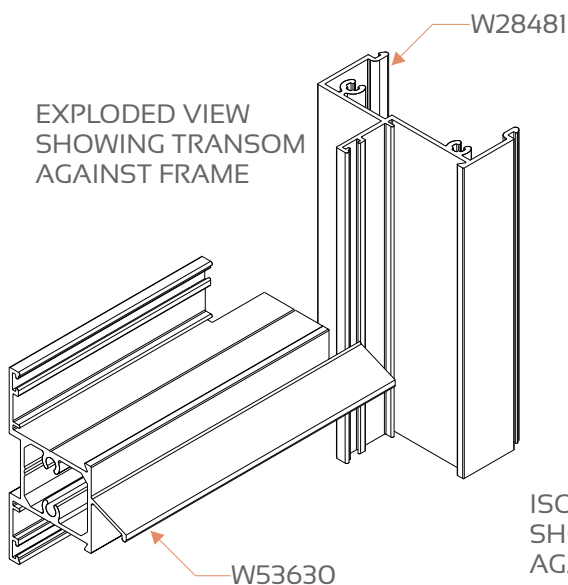
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



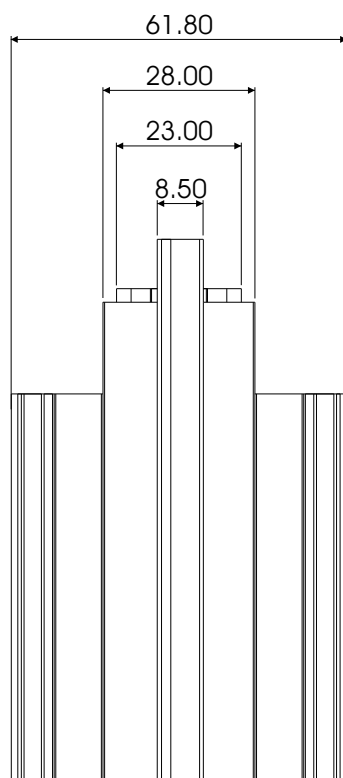
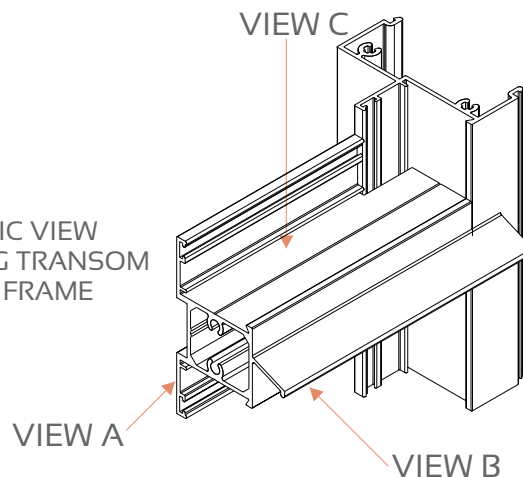
## Typical Transom with W/Bar Machining Detail

for End Milling on 54mm Outer Frame

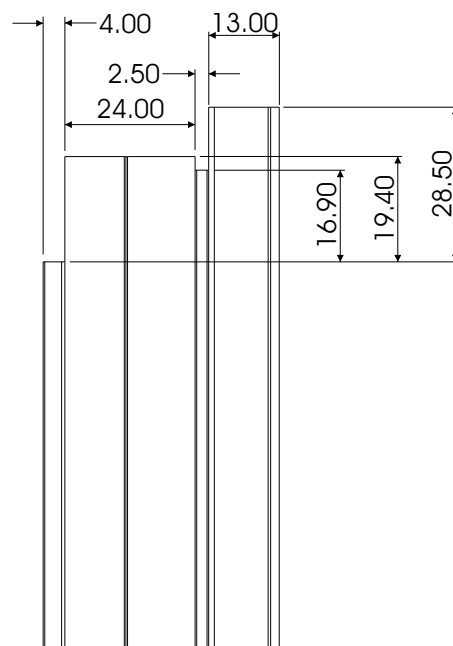
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



ISOMETRIC VIEW  
SHOWING TRANSOM  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

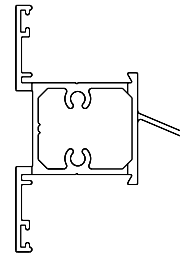
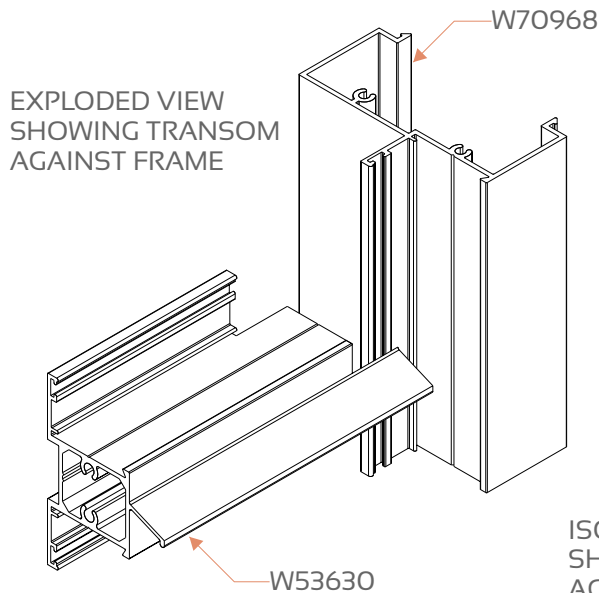


**VIEW C-C**  
Section not to scale

## Typical Transom with W/Bar Machining Detail

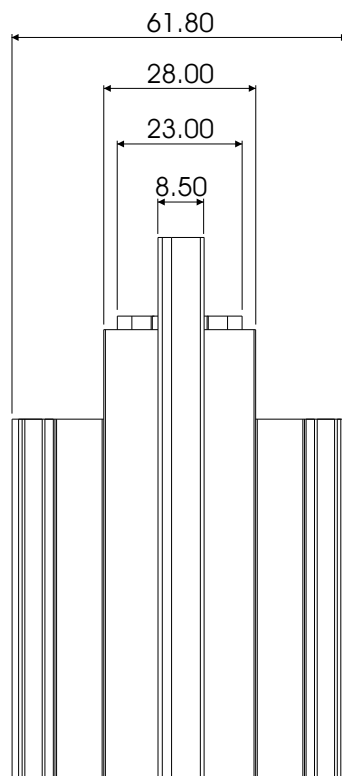
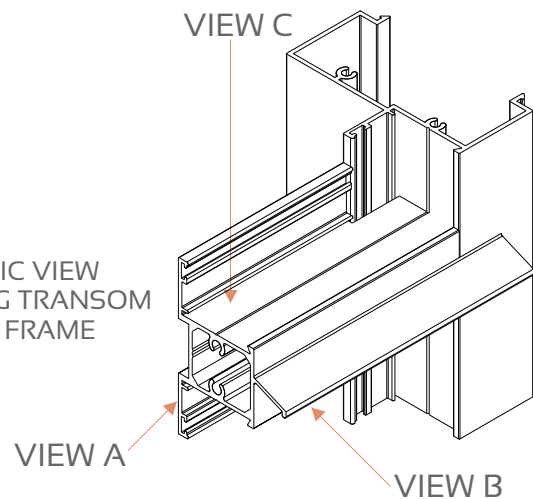
for End Milling on 70mm Outer Frame

**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.

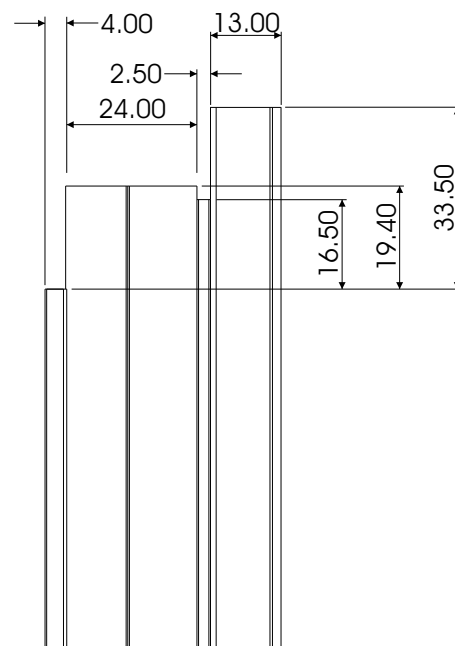


**VIEW A-A**  
Standard Transom  
with W/Bar  
W53630

ISOMETRIC VIEW  
SHOWING TRANSOM  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

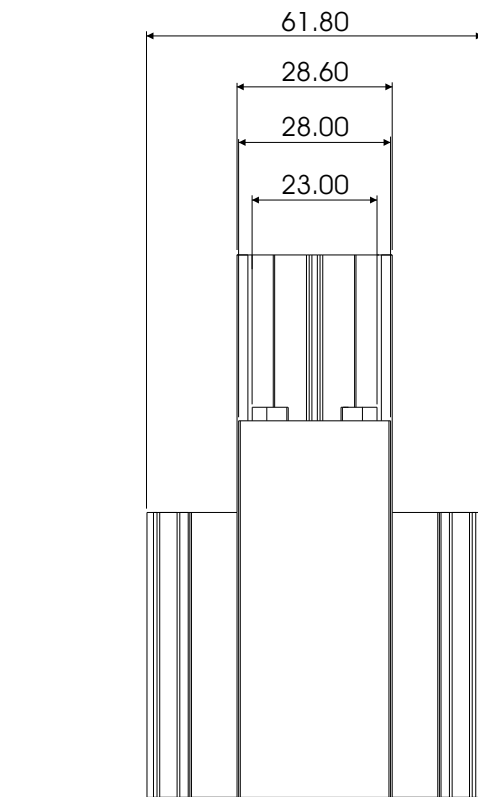
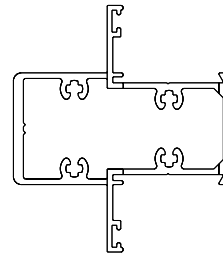
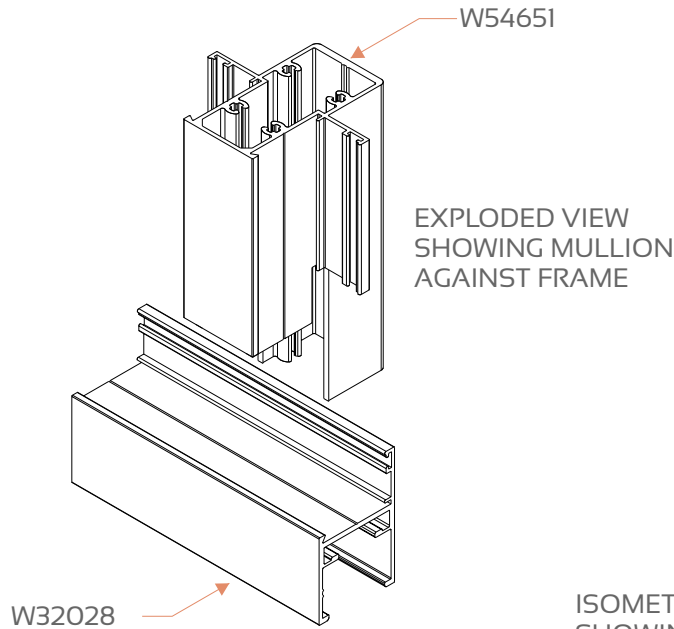


**VIEW C-C**  
Section not to scale

**Typical 54mm Mullion Machining Detail**

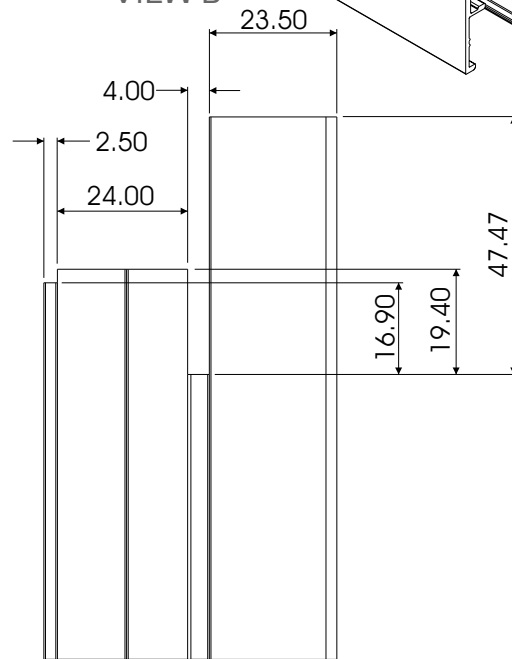
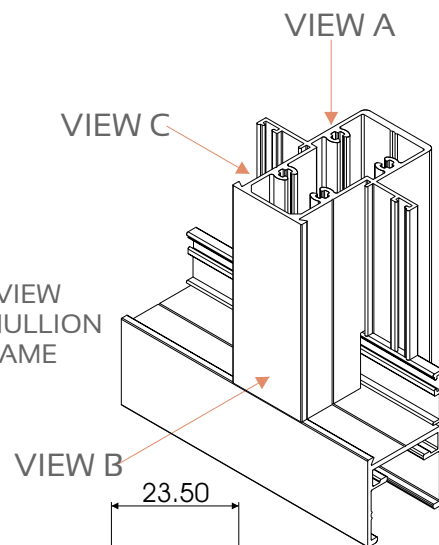
for End Milling on Equal Leg Outer Frame

**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.



**VIEW B-B**  
Section not to scale

ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME

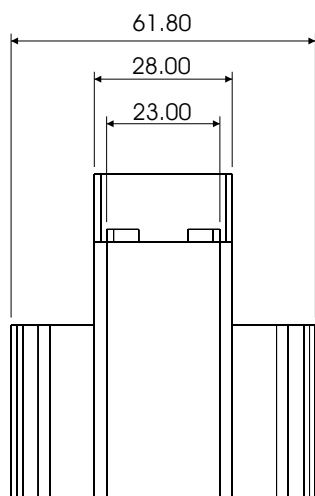
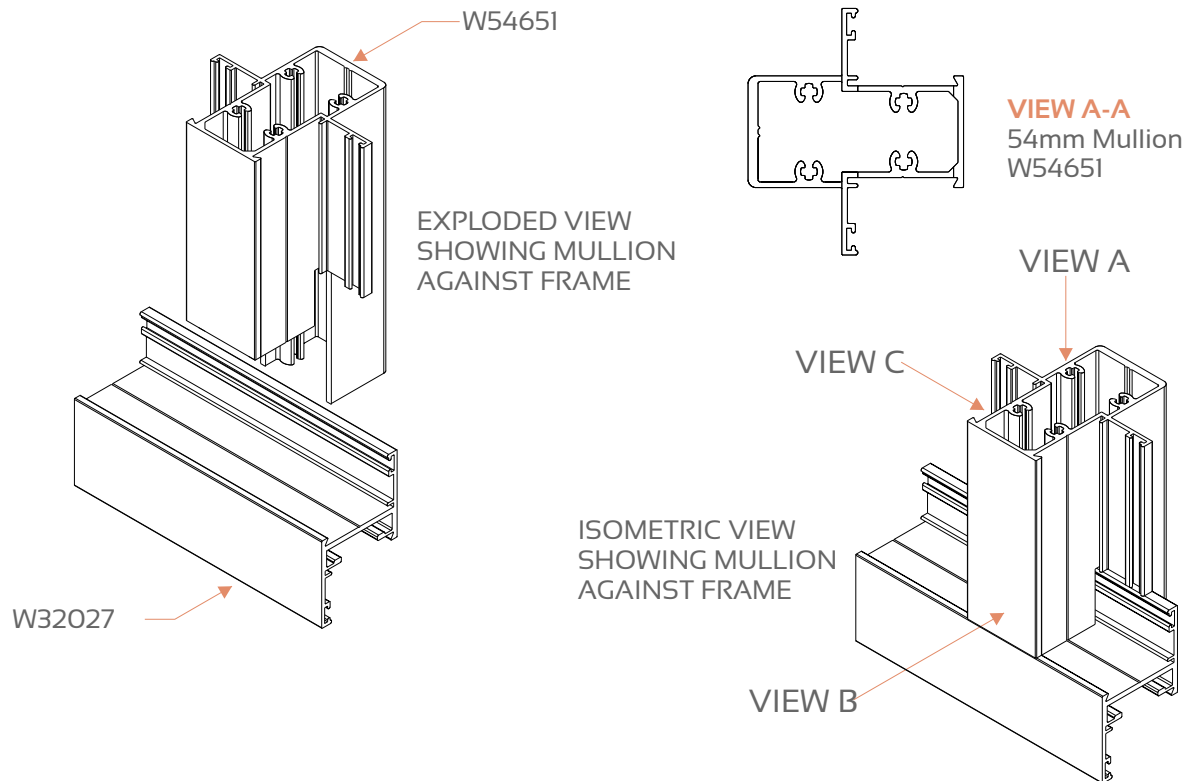


**VIEW C-C**  
Section not to scale

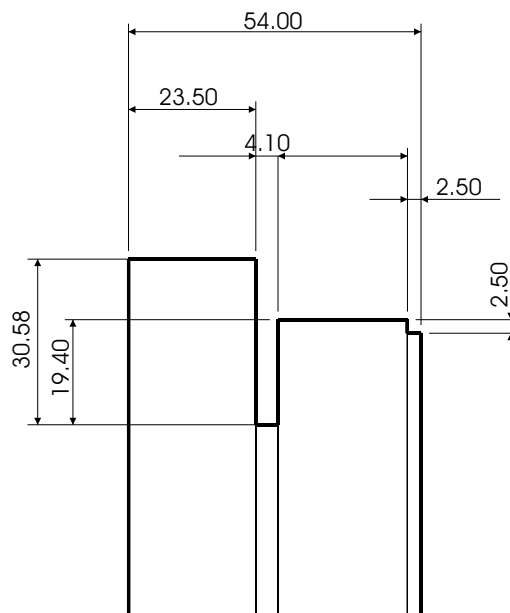
## Typical 54mm Mullion Machining Detail

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

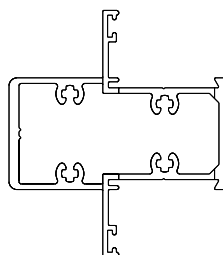
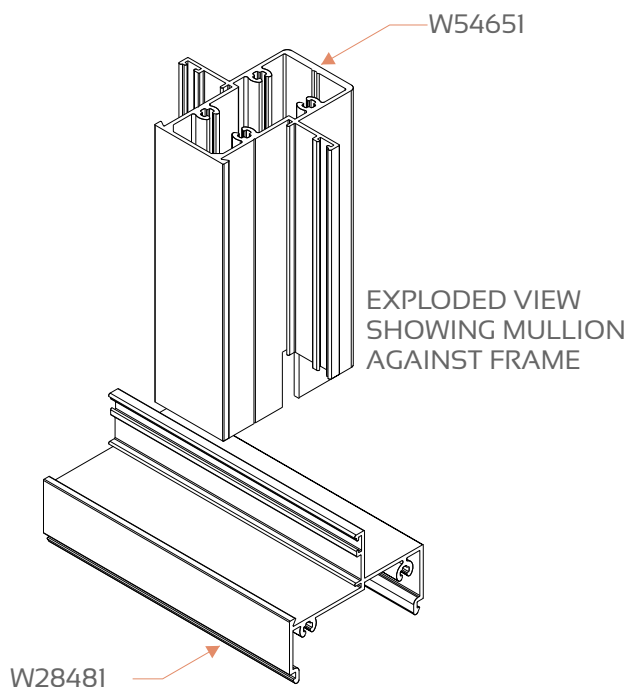


**VIEW C-C**  
Section not to scale

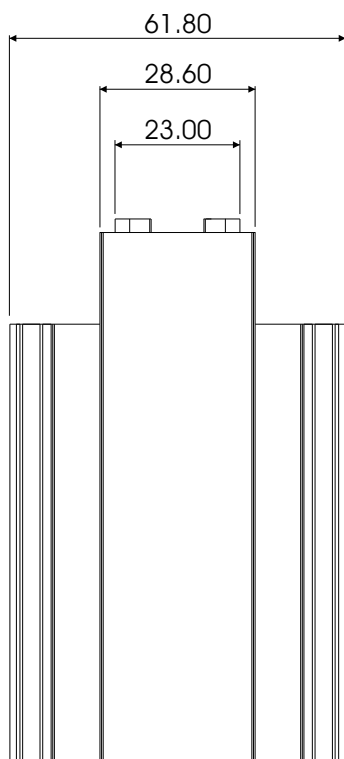
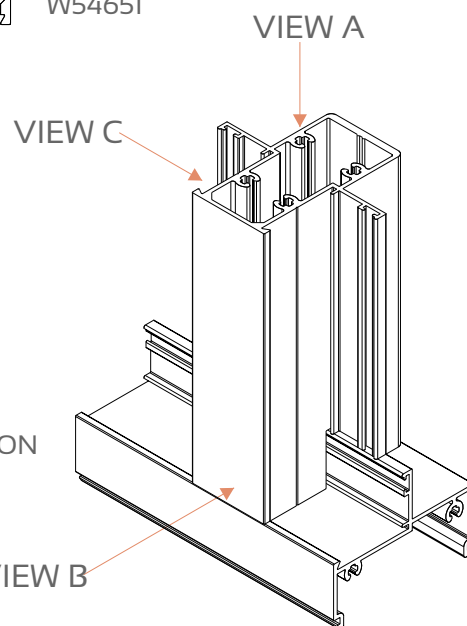
## Typical 54mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

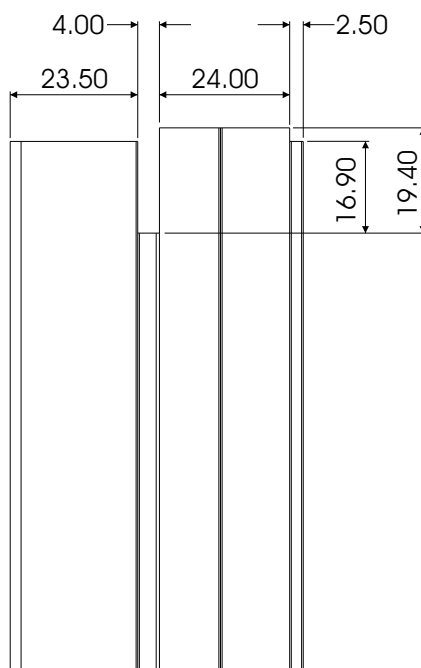
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

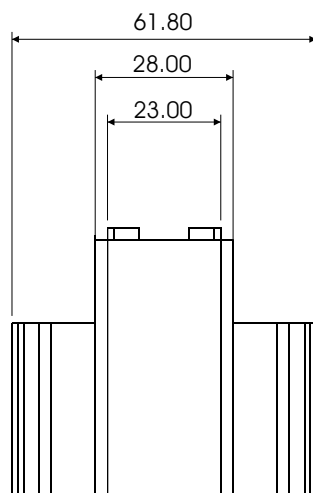
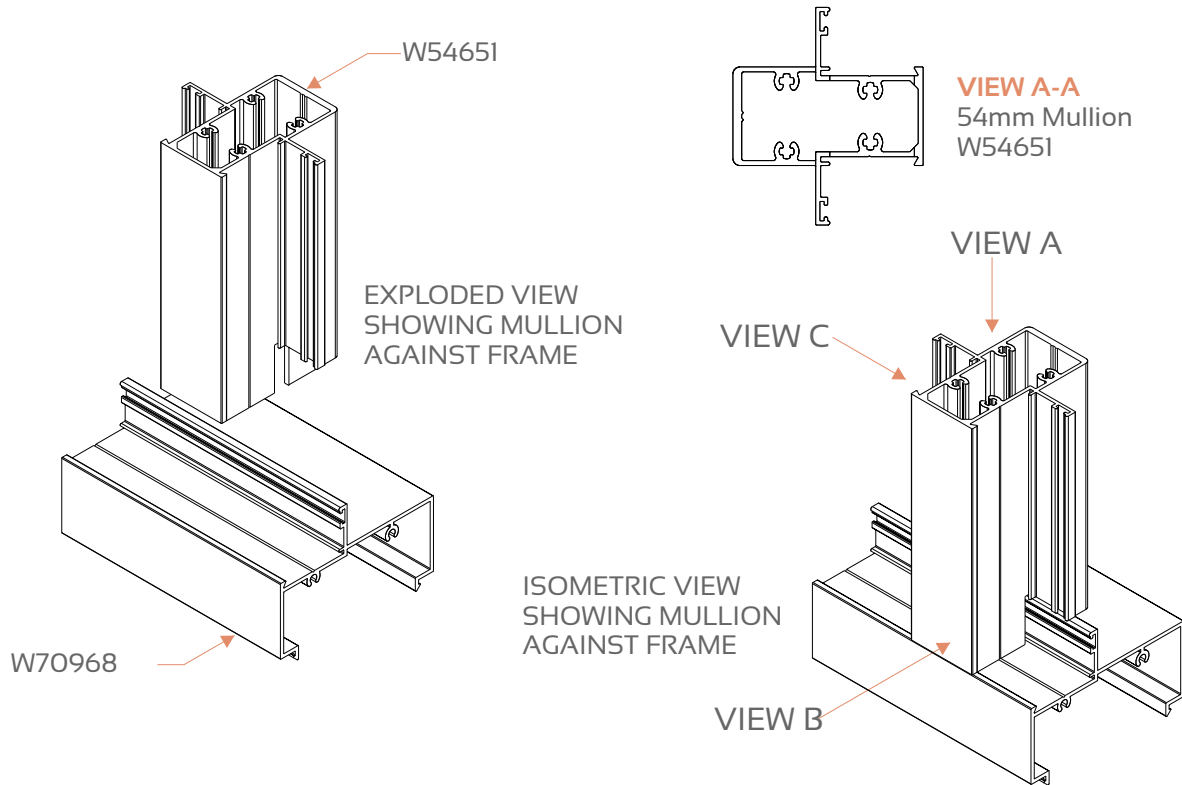


**VIEW C-C**  
Section not to scale

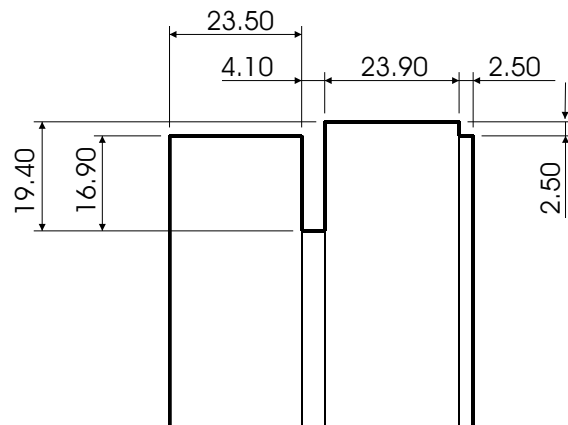
## Typical 54mm Mullion Machining Detail

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



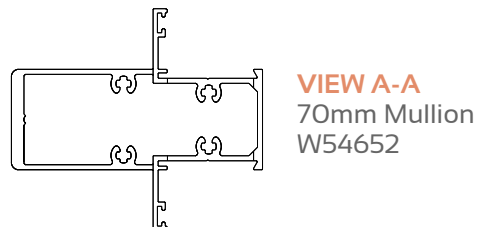
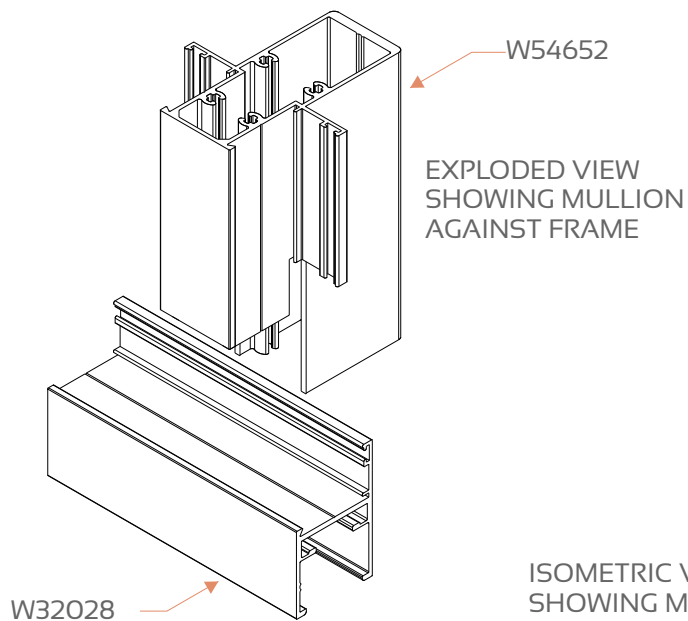
**VIEW C-C**  
Section not to scale



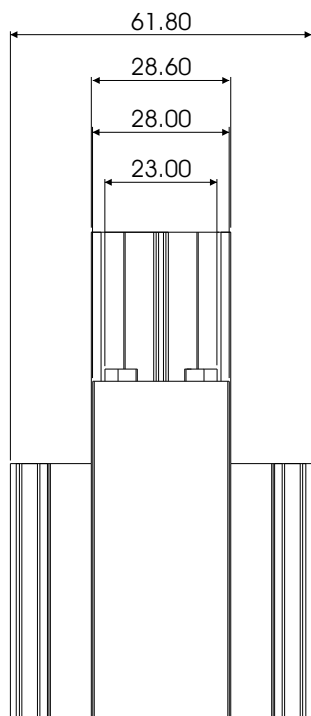
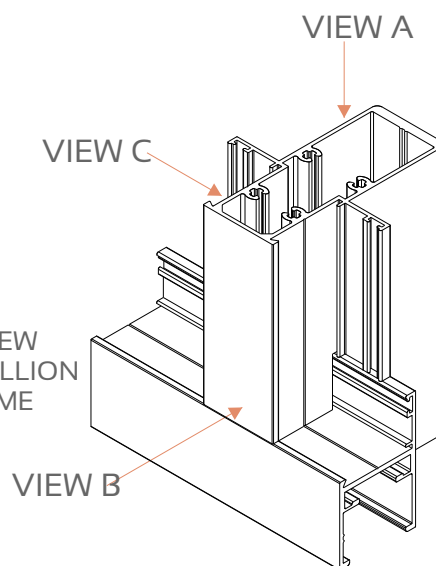
## Typical 70mm Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

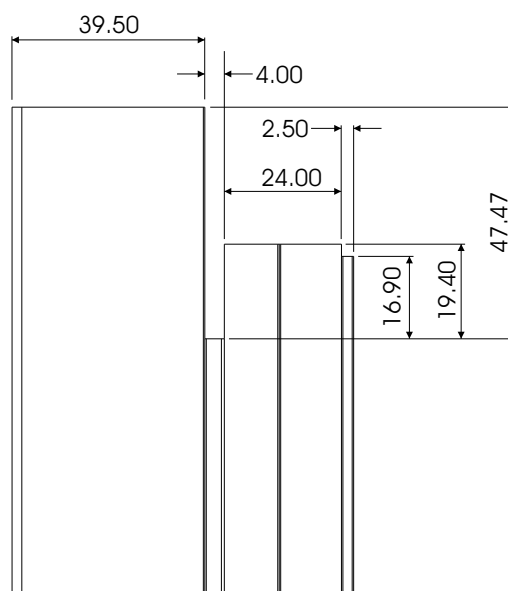
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

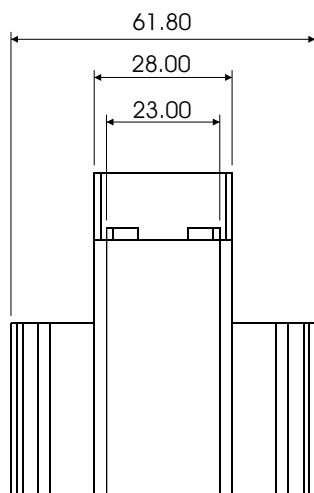
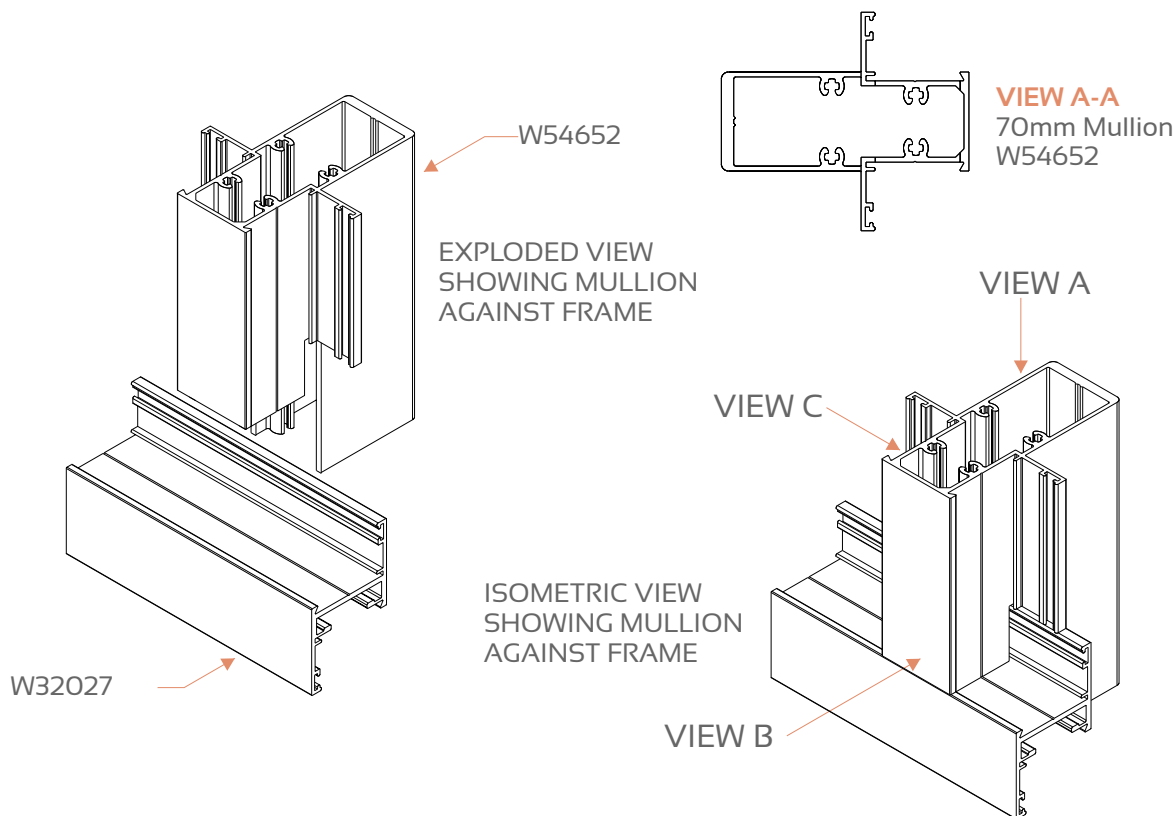


**VIEW C-C**  
Section not to scale

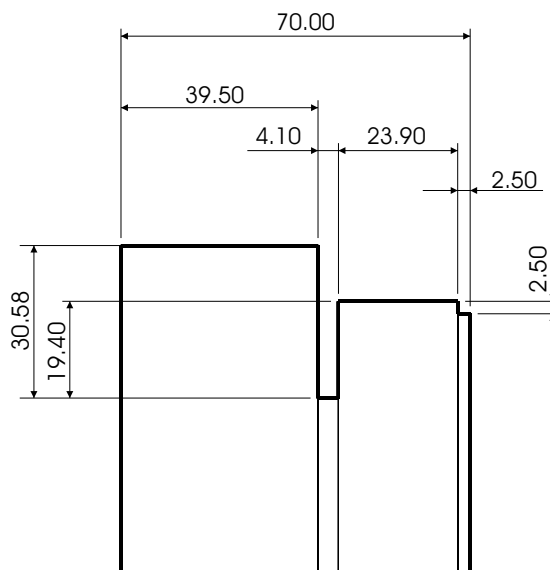
## Typical 70mm Mullion Machining Detail

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.



**VIEW B-B**  
Section not to scale

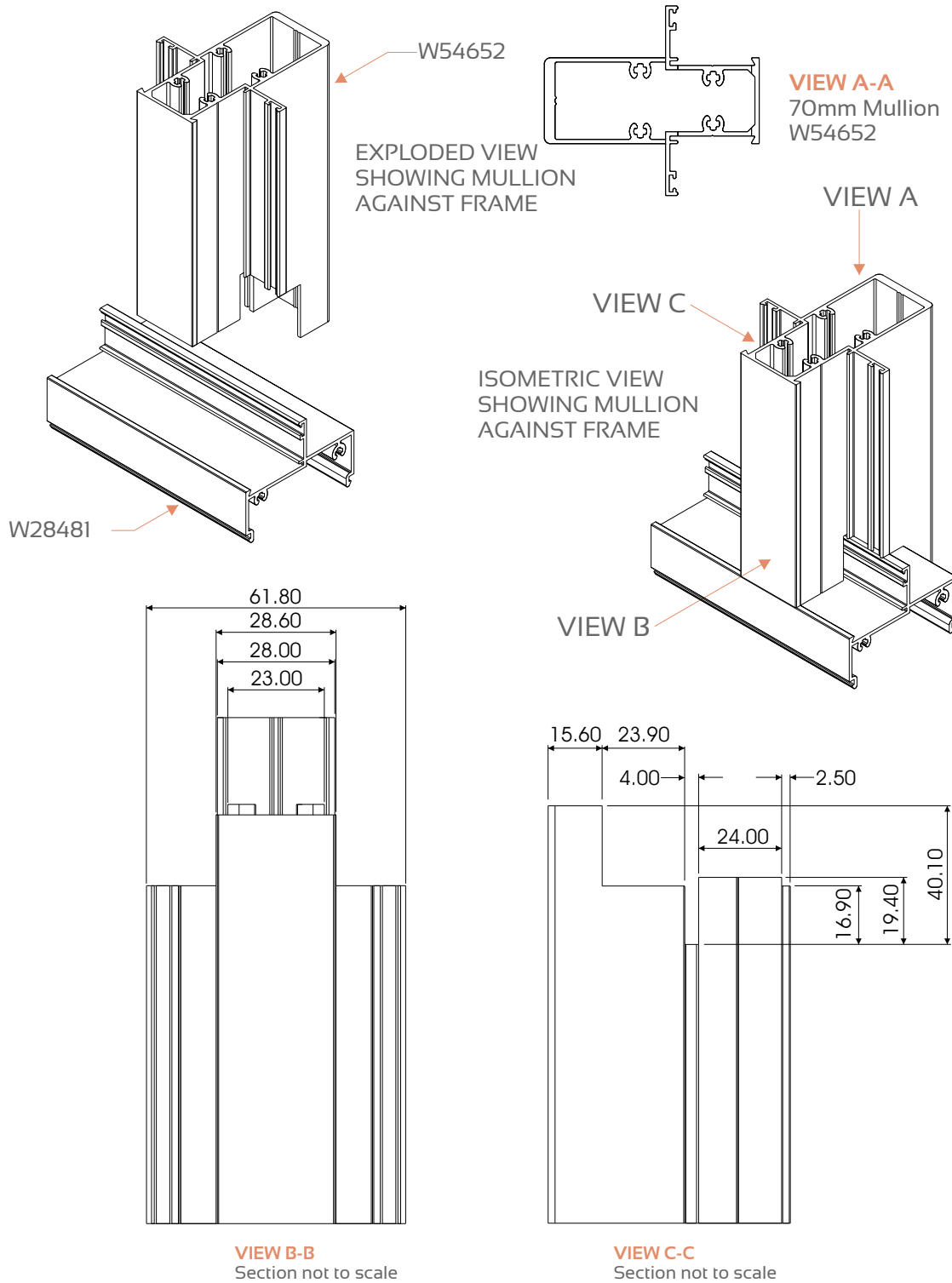


**VIEW C-C**  
Section not to scale

## Typical 70mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

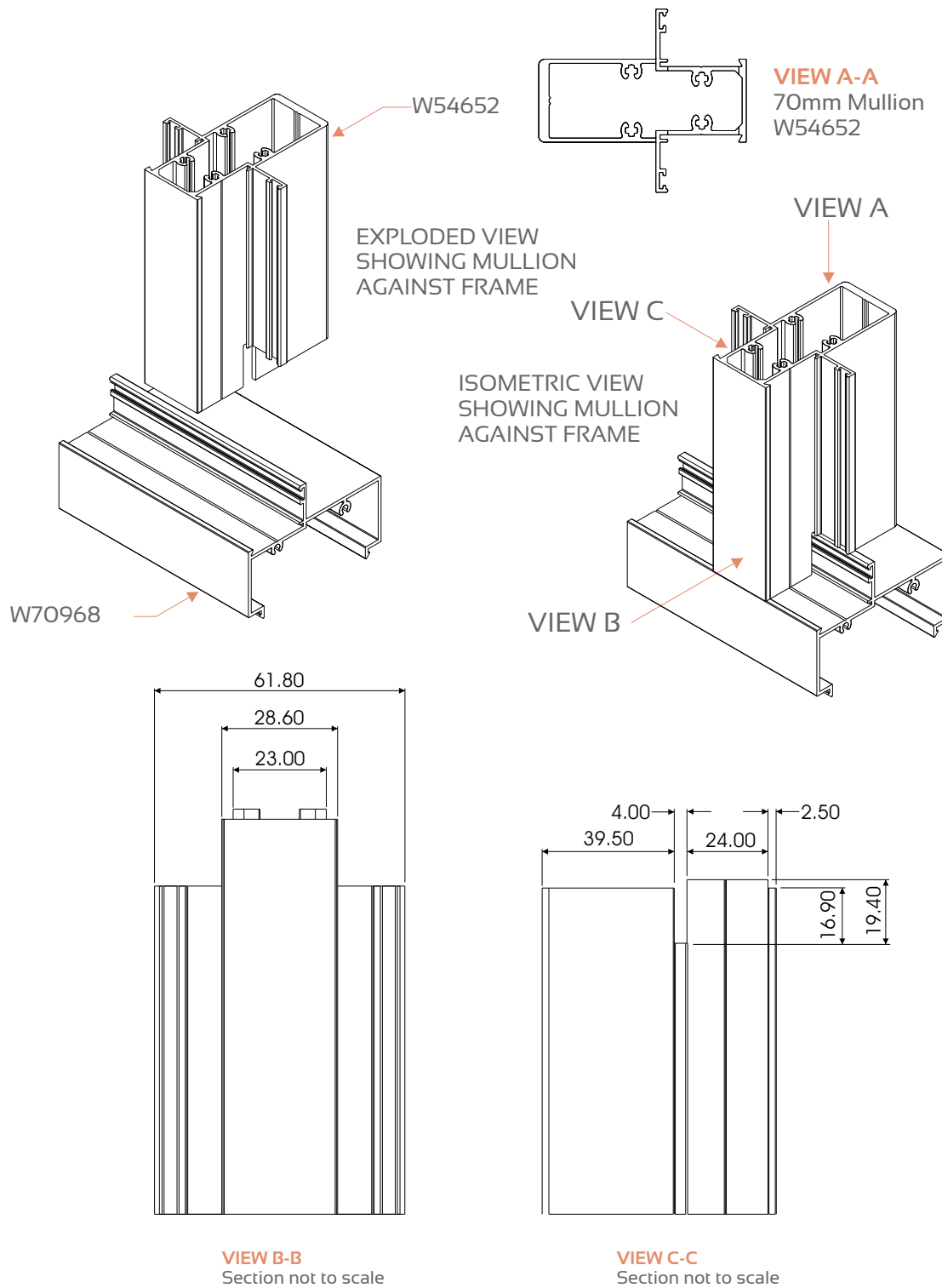
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical 70mm Mullion Machining Detail

for End Milling on 70mm Outer Frame

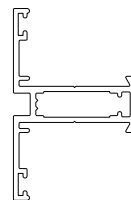
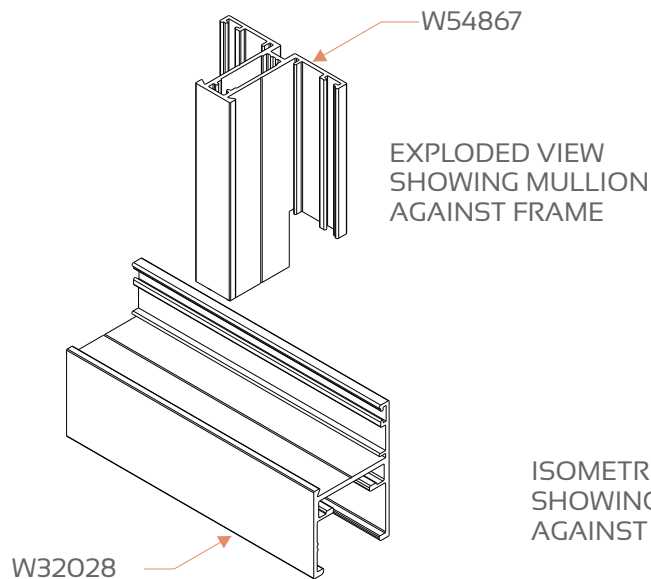
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



## Typical Cottage Pane Mullion Machining Detail

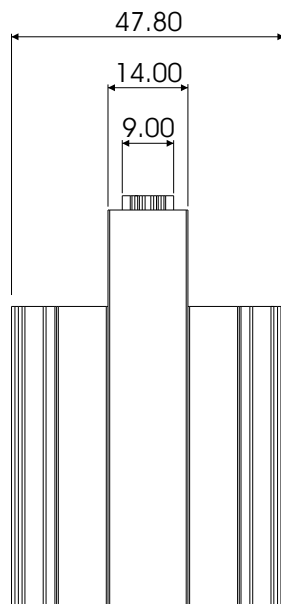
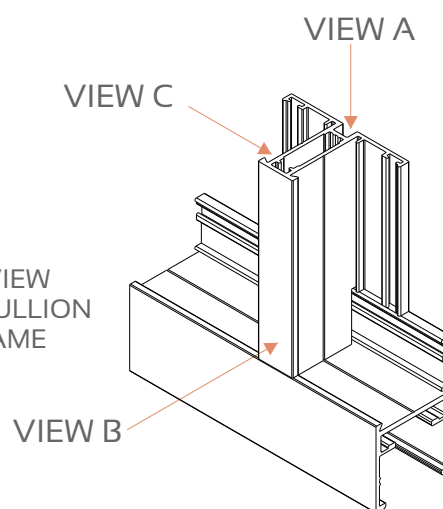
for End Milling on Equal Leg Outer Frame

**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.

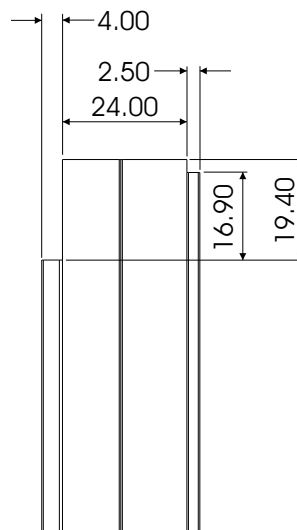


**VIEW A-A**  
Cottage Pane Mullion  
W54867

ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

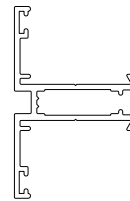
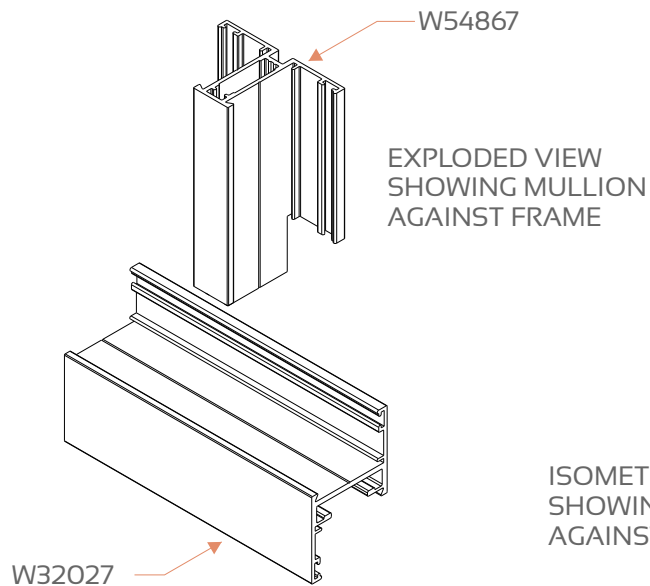


**VIEW C-C**  
Section not to scale

## Typical Cottage Pane Mullion Machining Detail

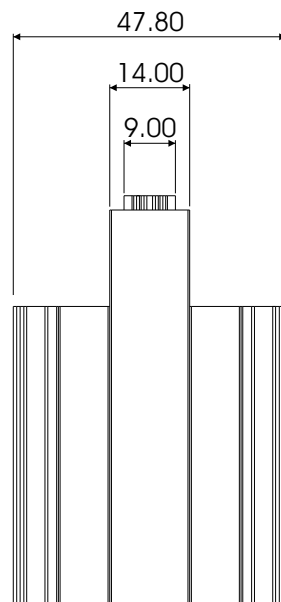
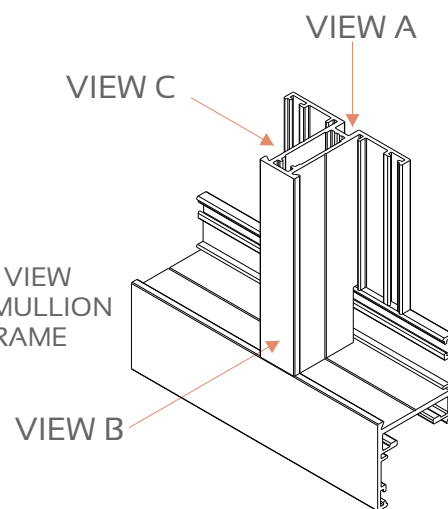
for End Milling on Unequal Leg Outer Frame

**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.

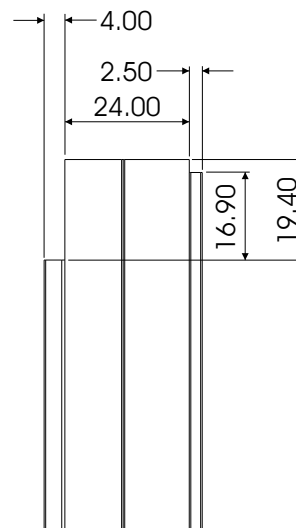


**VIEW A-A**  
Cottage Pane Mullion  
W54867

ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

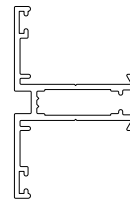
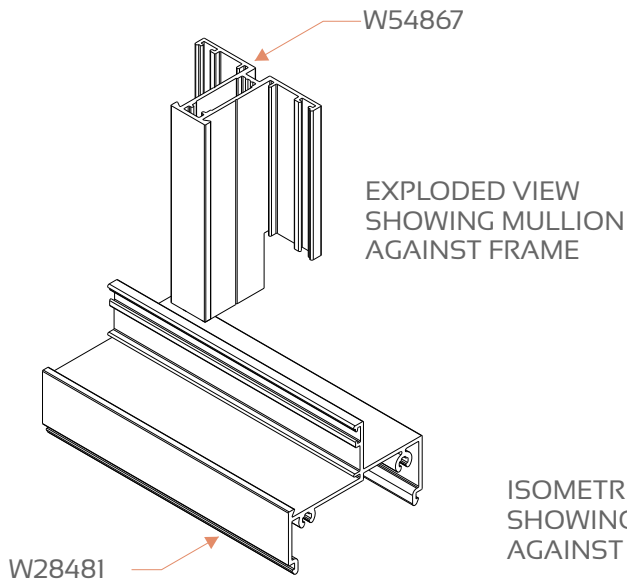


**VIEW C-C**  
Section not to scale

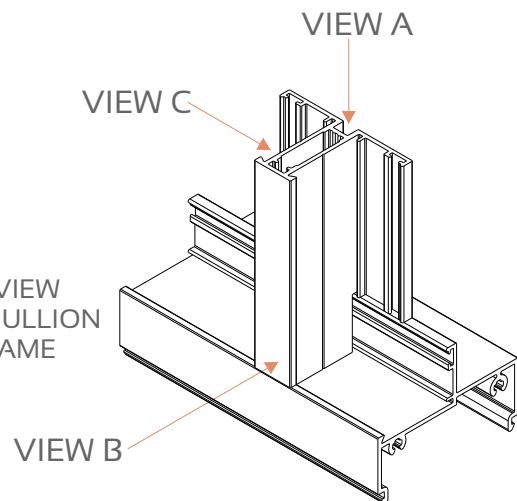
## Typical Cottage Pane Mullion Machining Detail

for End Milling on 54mm Outer Frame

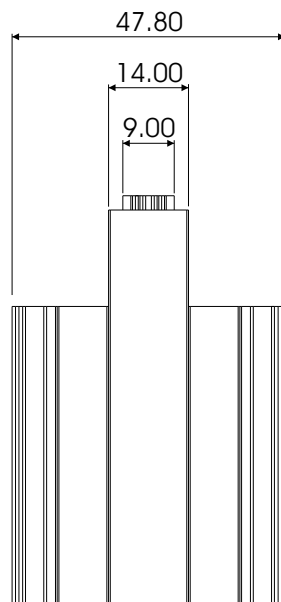
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



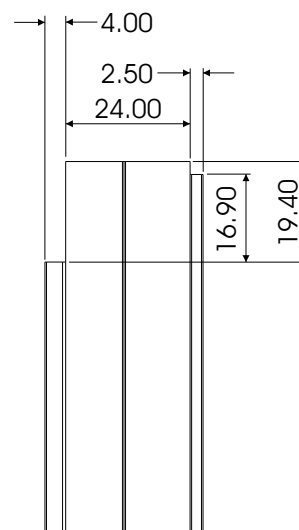
**VIEW A-A**  
Cottage Pane Mullion  
W54867



ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

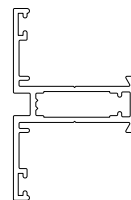
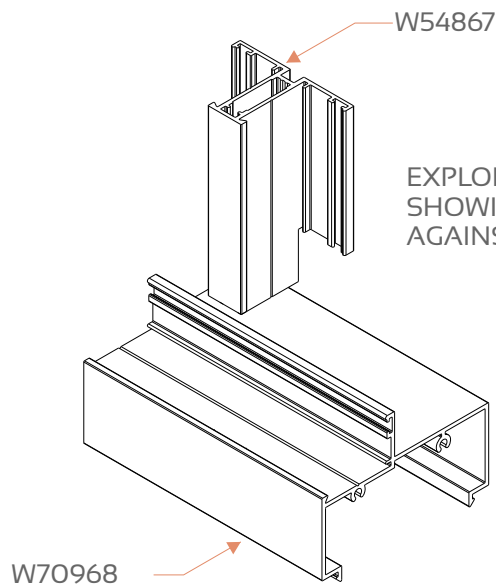


**VIEW C-C**  
Section not to scale

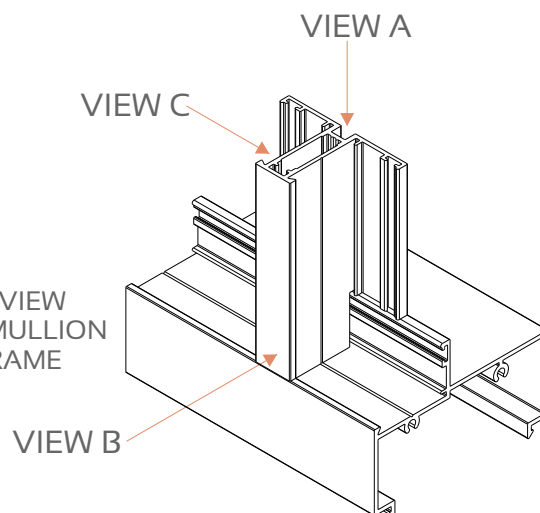
## Typical Cottage Pane Mullion Machining Detail

for End Milling on 70mm Outer Frame

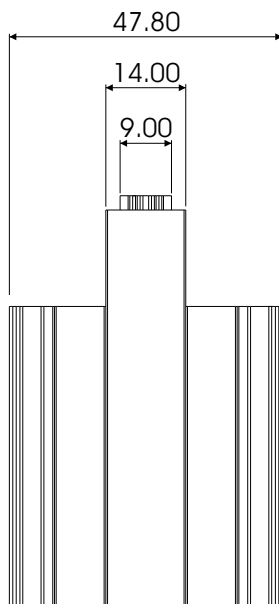
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



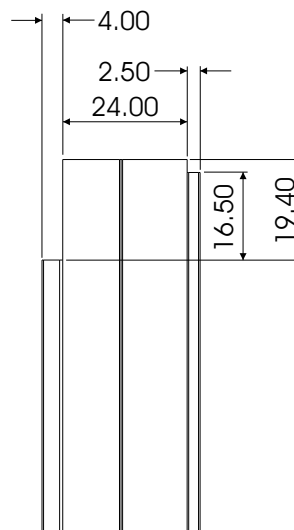
**VIEW A-A**  
Cottage Pane Mullion  
W54867



ISOMETRIC VIEW  
SHOWING MULLION  
AGAINST FRAME



**VIEW B-B**  
Section not to scale

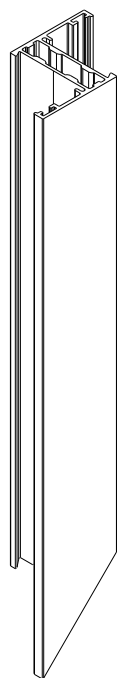


**VIEW C-C**  
Section not to scale

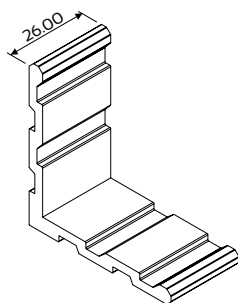
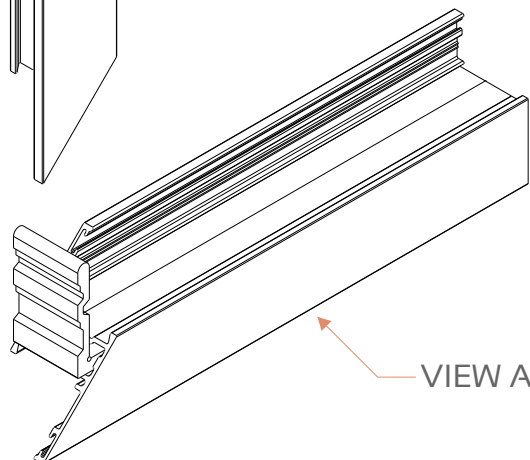


## Typical Corner Cleat Assembly Detail

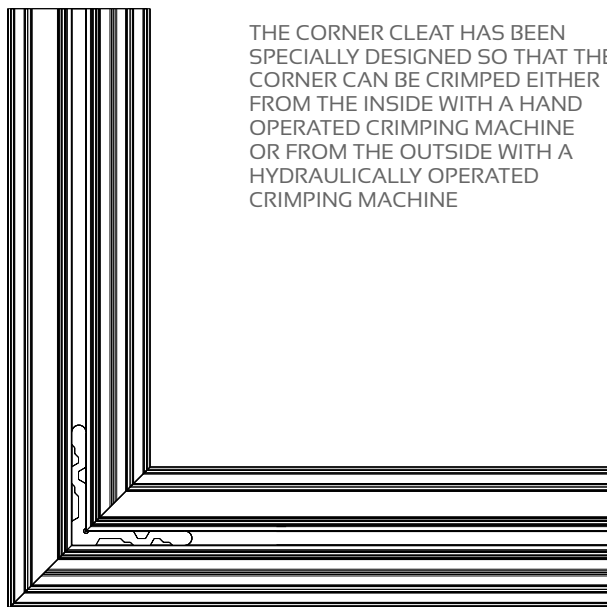
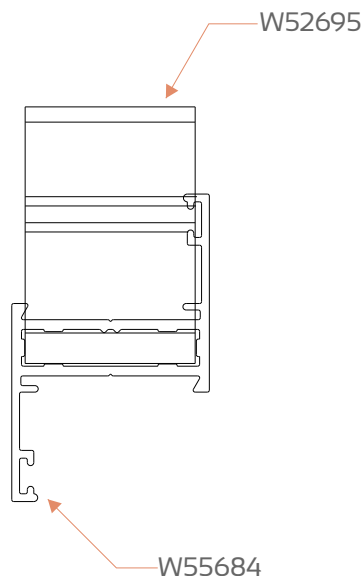
**Please Note:** These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



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



W52695



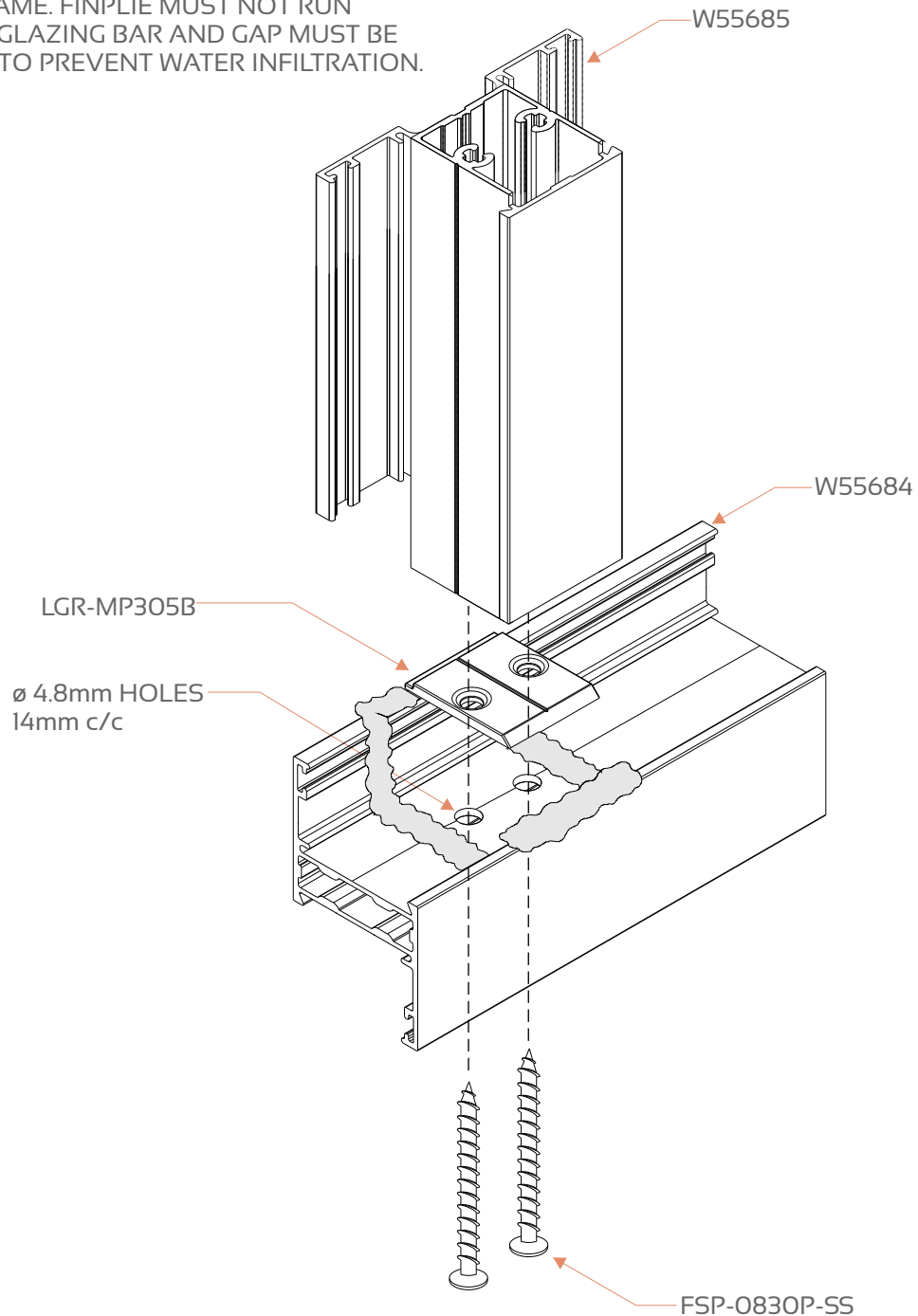
THE CORNER CLEAT HAS BEEN  
SPECIALLY DESIGNED SO THAT THE  
CORNER CAN BE CRIMPED EITHER  
FROM THE INSIDE WITH A HAND  
OPERATED CRIMPING MACHINE  
OR FROM THE OUTSIDE WITH A  
HYDRAULICALLY OPERATED  
CRIMPING MACHINE

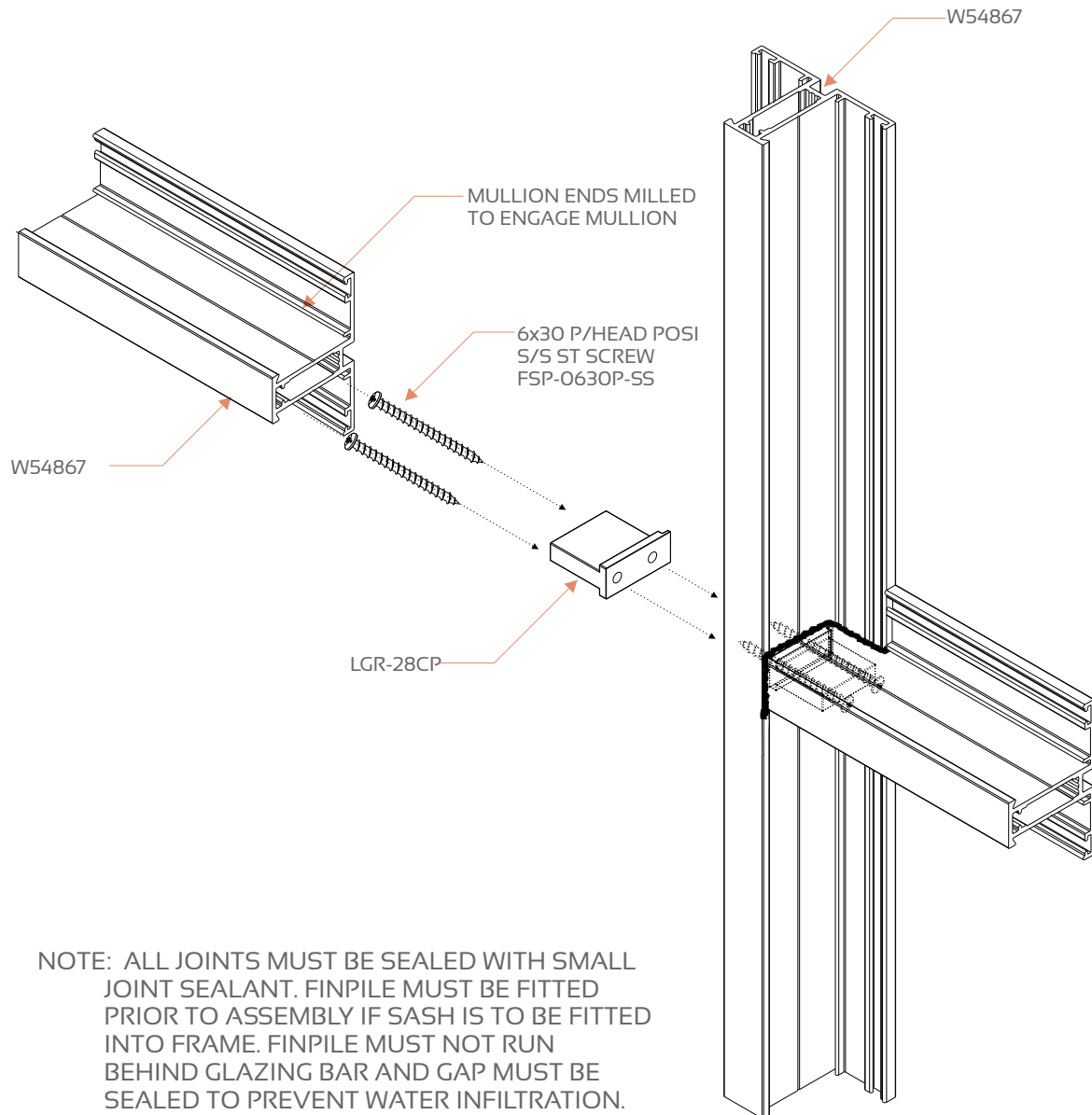
VIEW A-A

**Typical Mullion Packer Frame Joint**

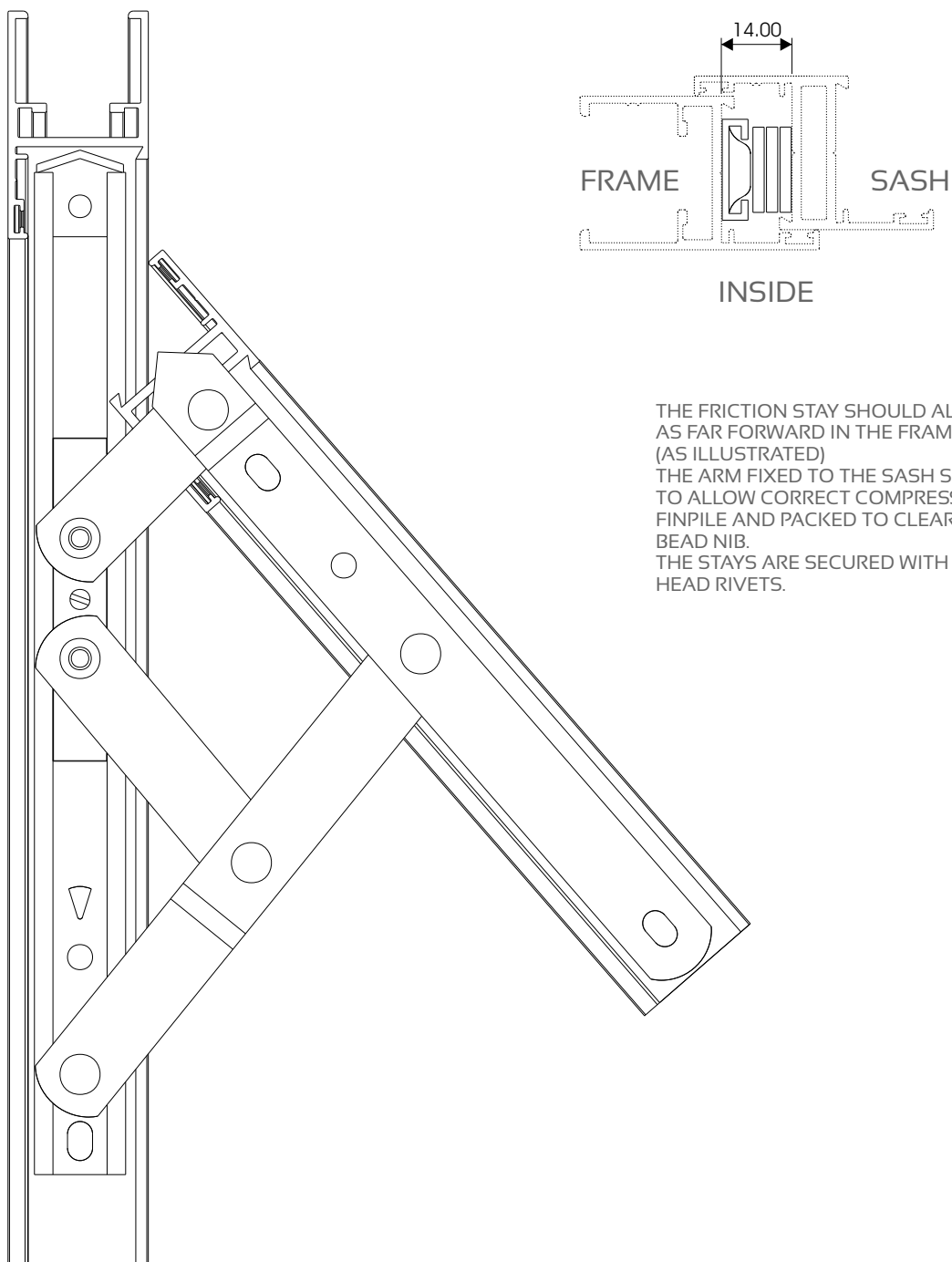
**Assembly Detail**

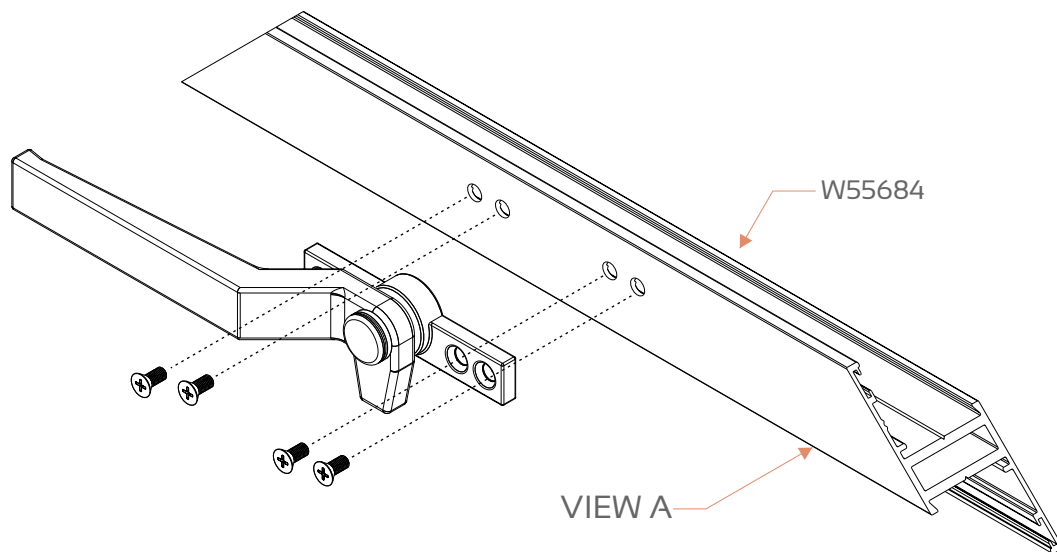
NOTE: ALL JOINTS MUST BE SEALED WITH SMALL JOINT SEALANT. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPILE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.



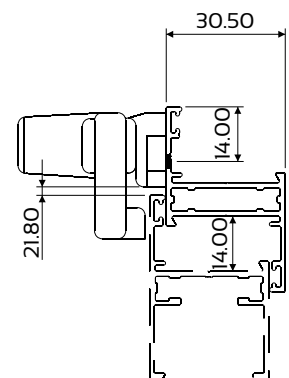
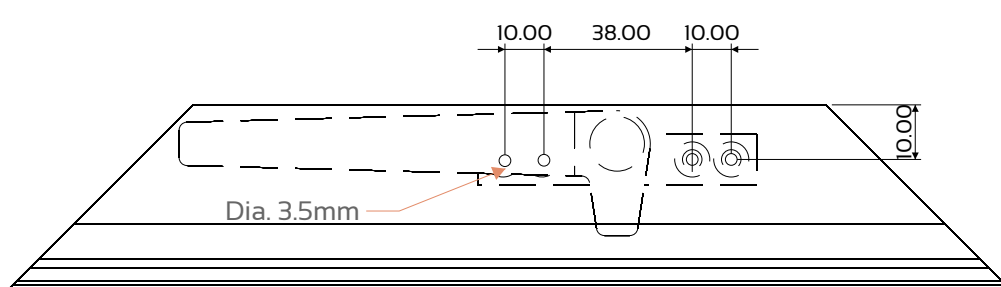


**Typical Friction Stay Assembly Detail**



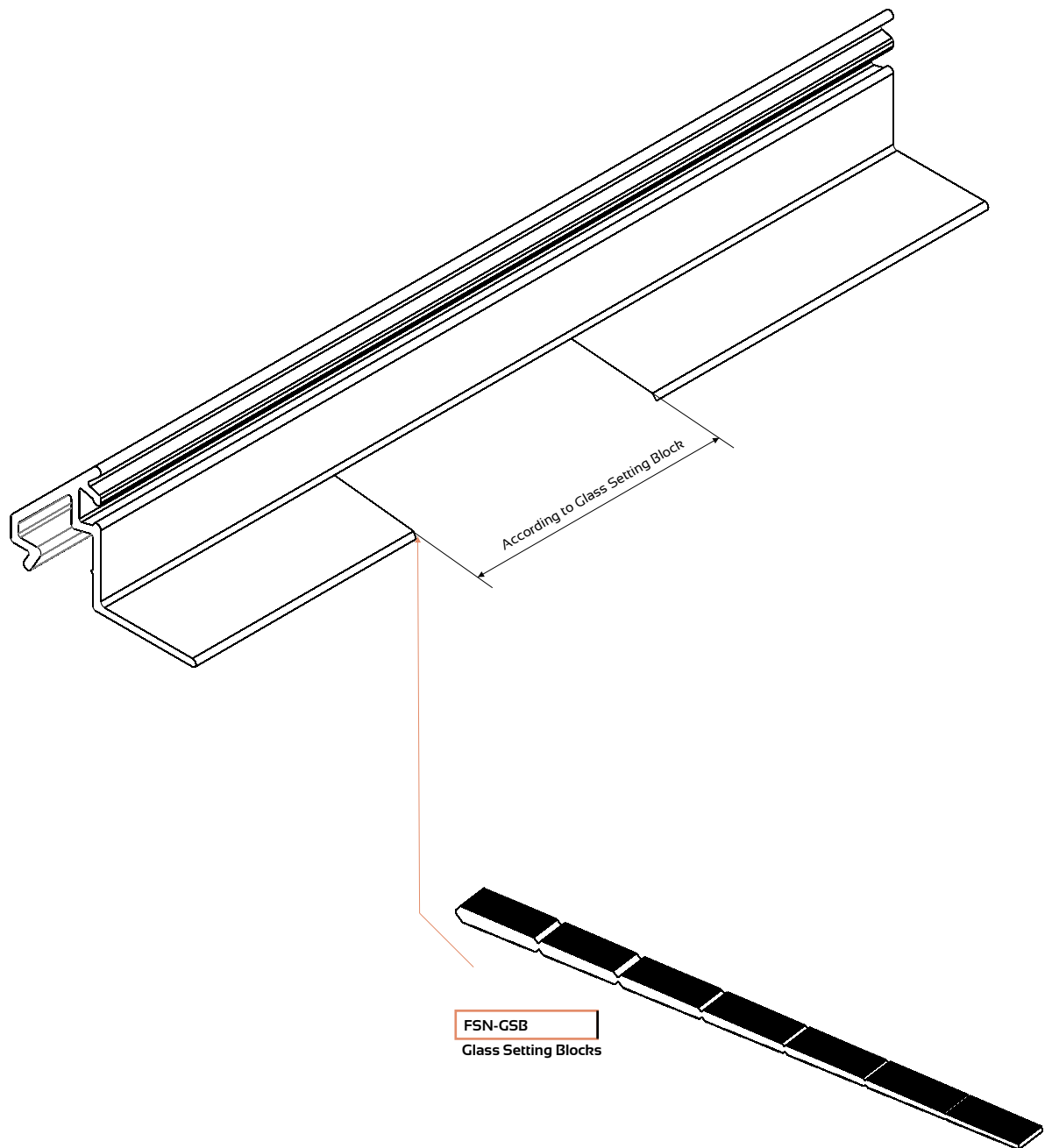


NO 8 x 10 COUNTERSUNK SELF-TAPPING  
FLAT END SCREWS



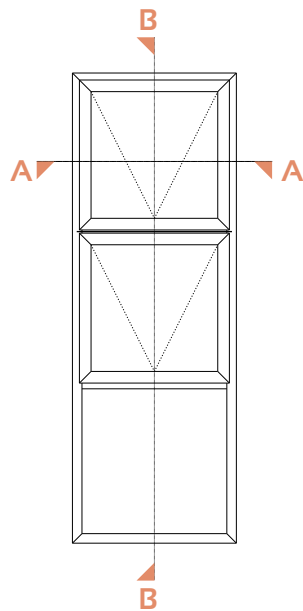
**Typical Bead Cut-Out for Setting Block**

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

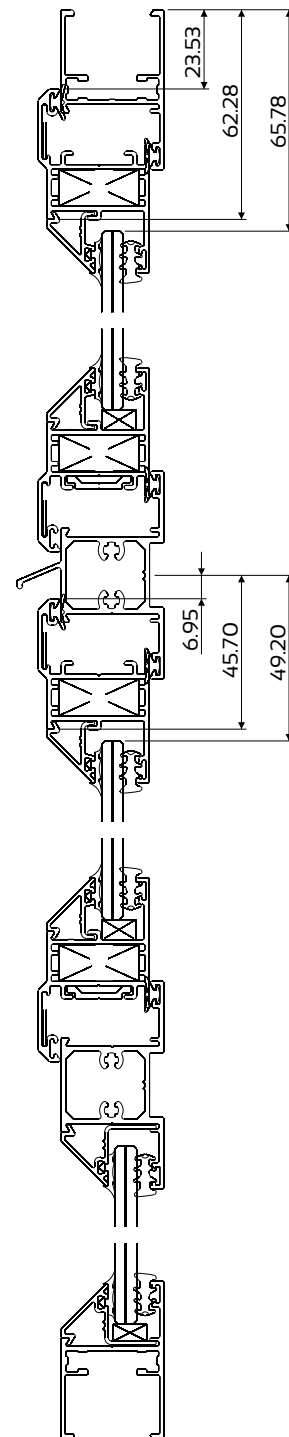


## Typical Cross-sectional Details

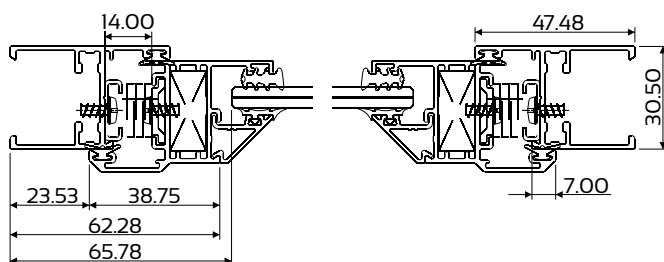
### Double Top Hung over Fixed



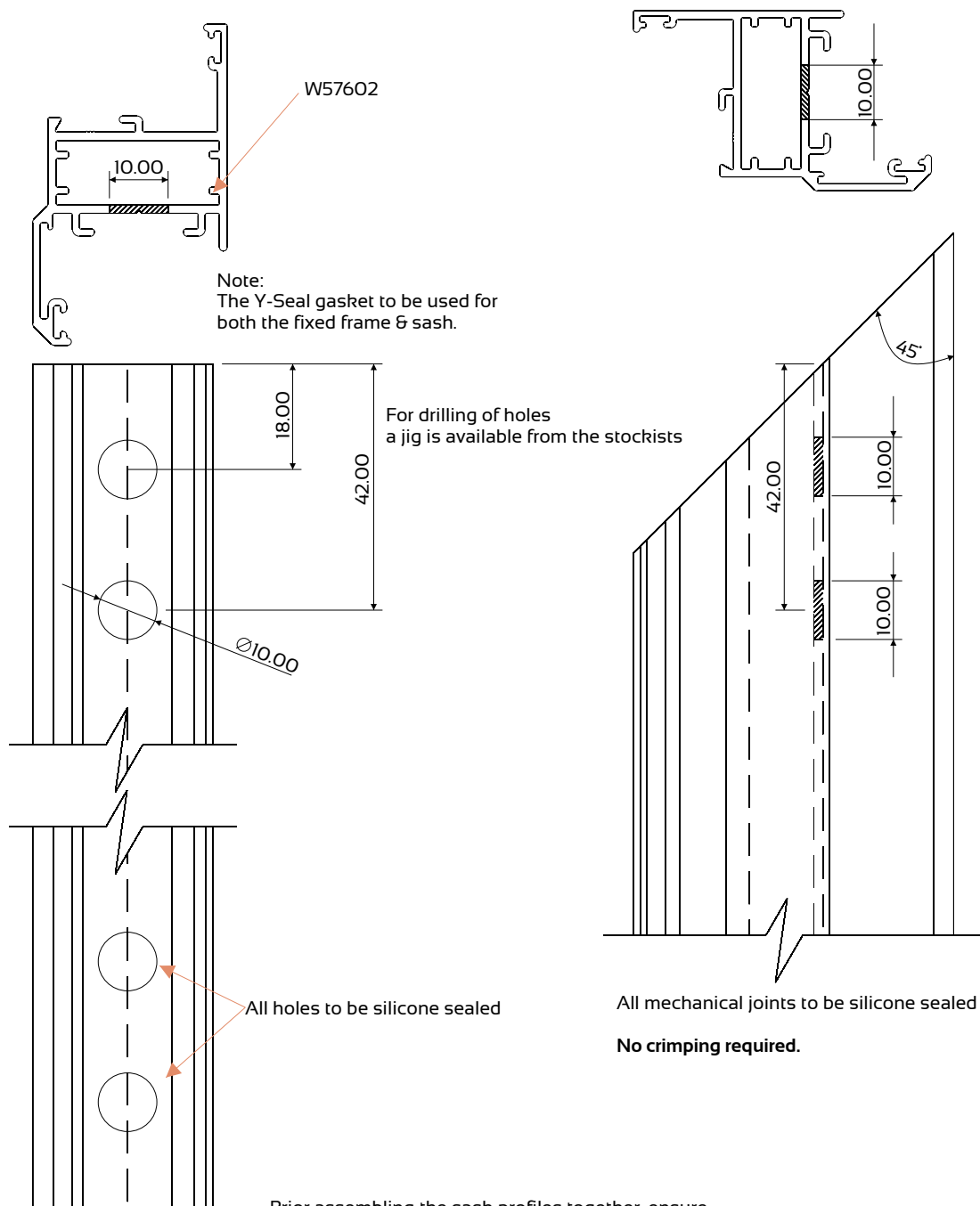
**SECTION B-B**  
Section not to scale



**SECTION A - A**  
Section not to scale



**OPTION A - USING THE JOINING CORNER**



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

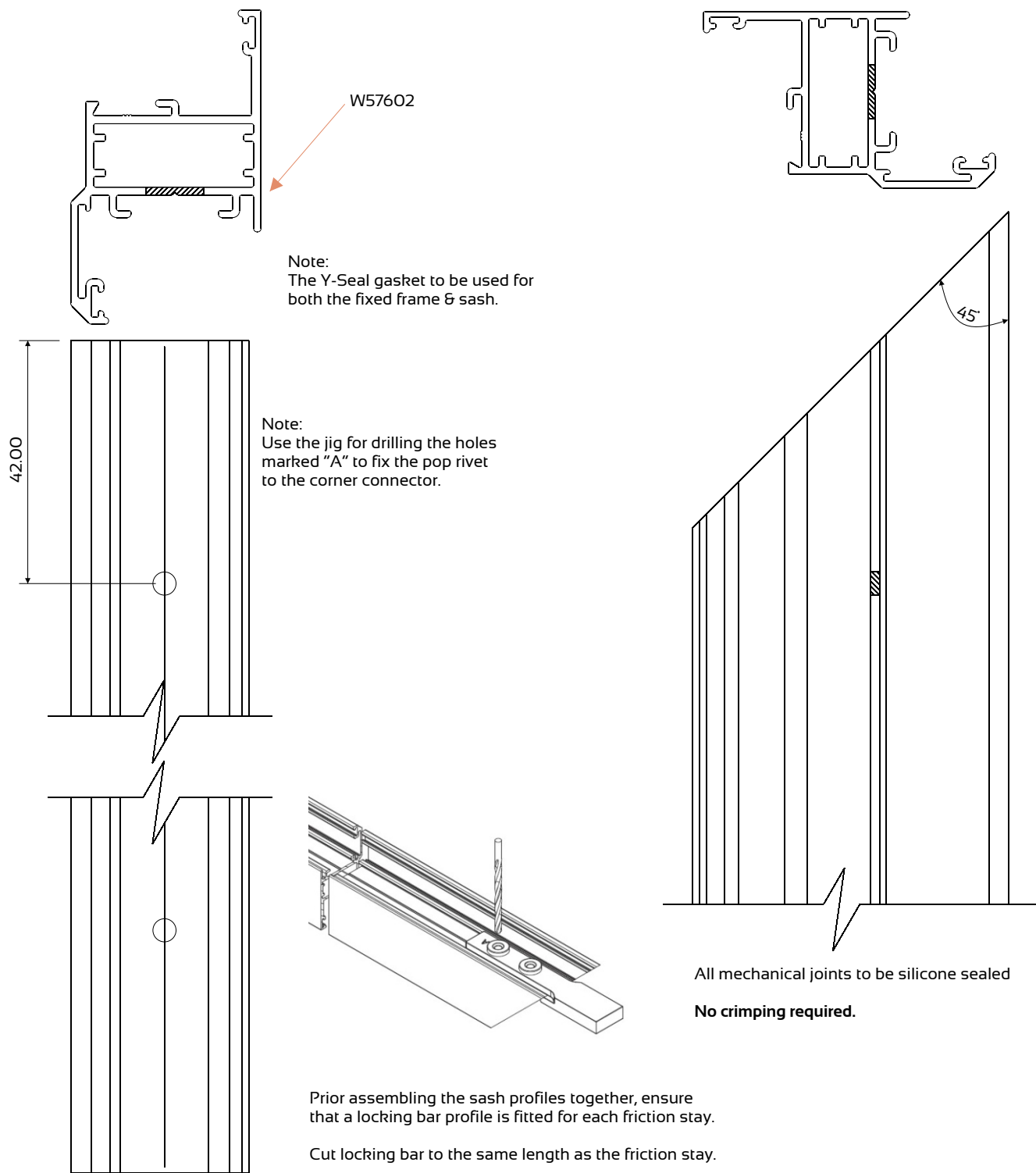
Cut locking bar to the same length as the friction stay.



**Typical Multi Lock Sash Corner Joint Detail**

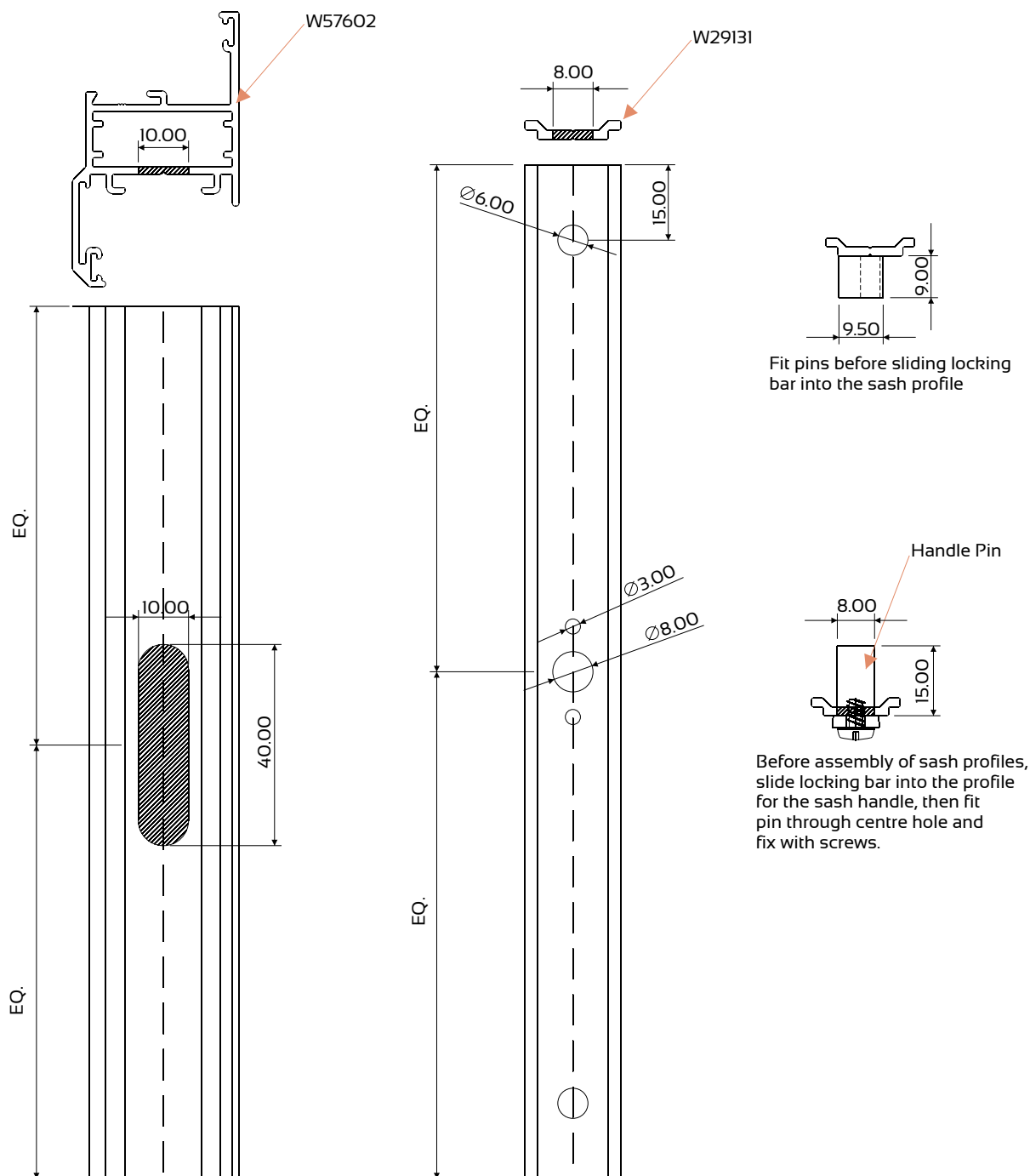
Option B - Using the Corner Connector

**OPTION B - USING THE CORNER CONNECTOR**



## Typical Multi Lock Sash Machining Detail

### Sash & Locking Bar

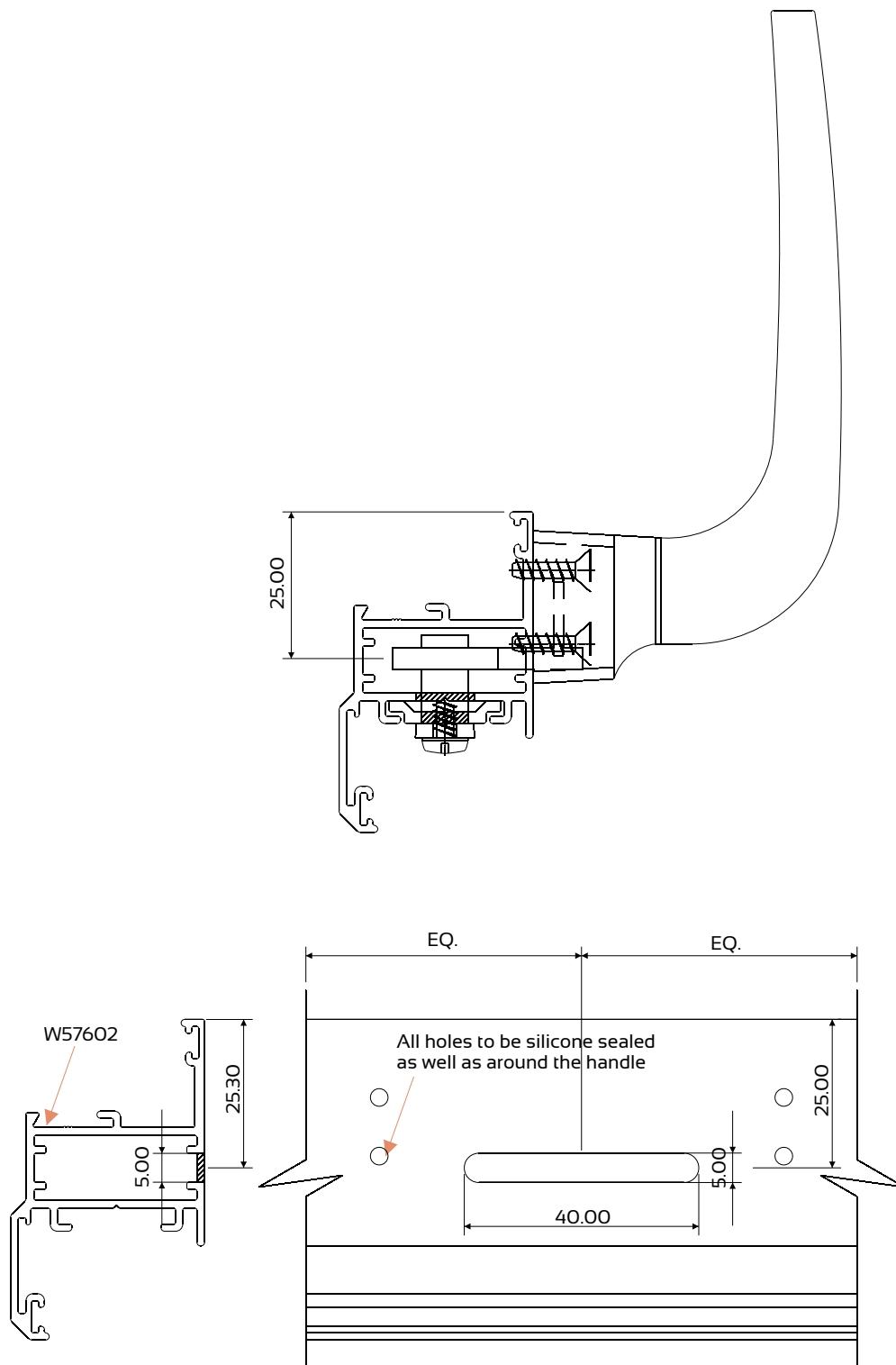


**Note:**

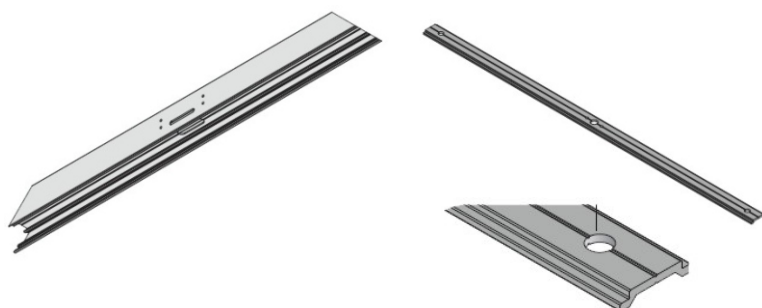
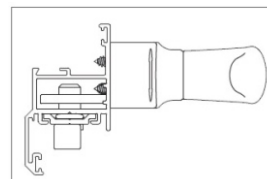
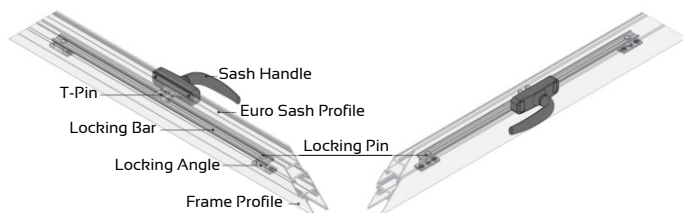
Before assembly of the sash frame, the locking bar needs to be inserted into the bottom sash profile with the locking pins fitted & holes drilled to receive the handle pin.

**Typical Multi Lock Sash Machining Detail**

Handle



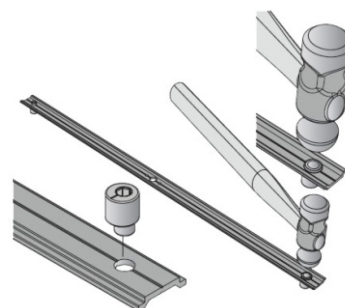
## Typical Fitting of Multi Lock Sash Handles



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 6 machine as shown in diagram 2.

2



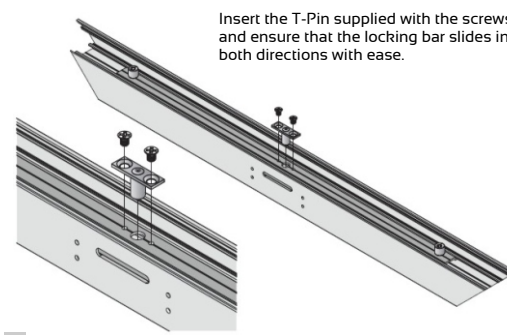
Insert the locking pins into the locking bar. Deform the protruding part of the pin using a ball peen hammer or punch to fix them onto the locking bar.

3



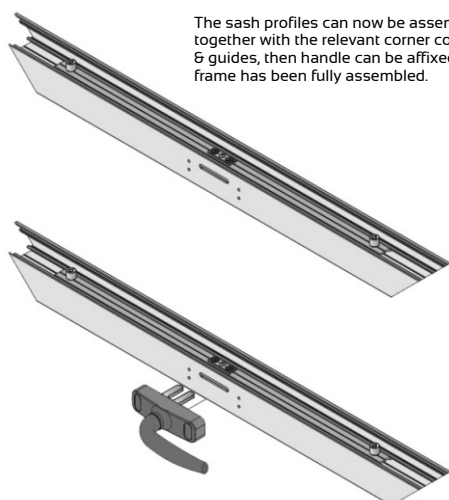
Insert the locking bar into the Sash Profile prior to any assembly of the sash profiles, as the Locking bar will not be able to be added later.

4



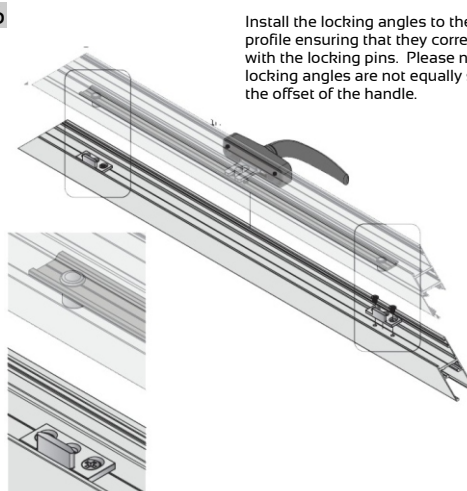
Insert the T-Pin supplied with the screws and ensure that the locking bar slides in both directions with ease.

5

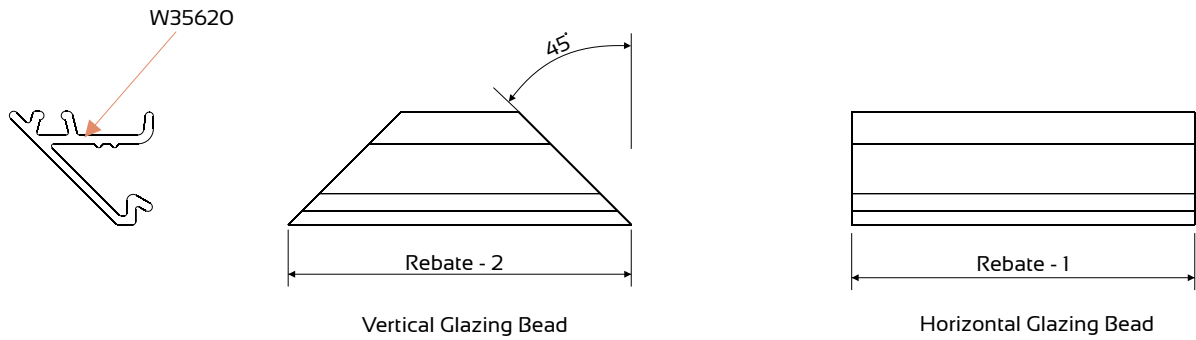


The sash profiles can now be assembled together with the relevant corner connectors & guides, then handle can be affixed after the frame has been fully assembled.

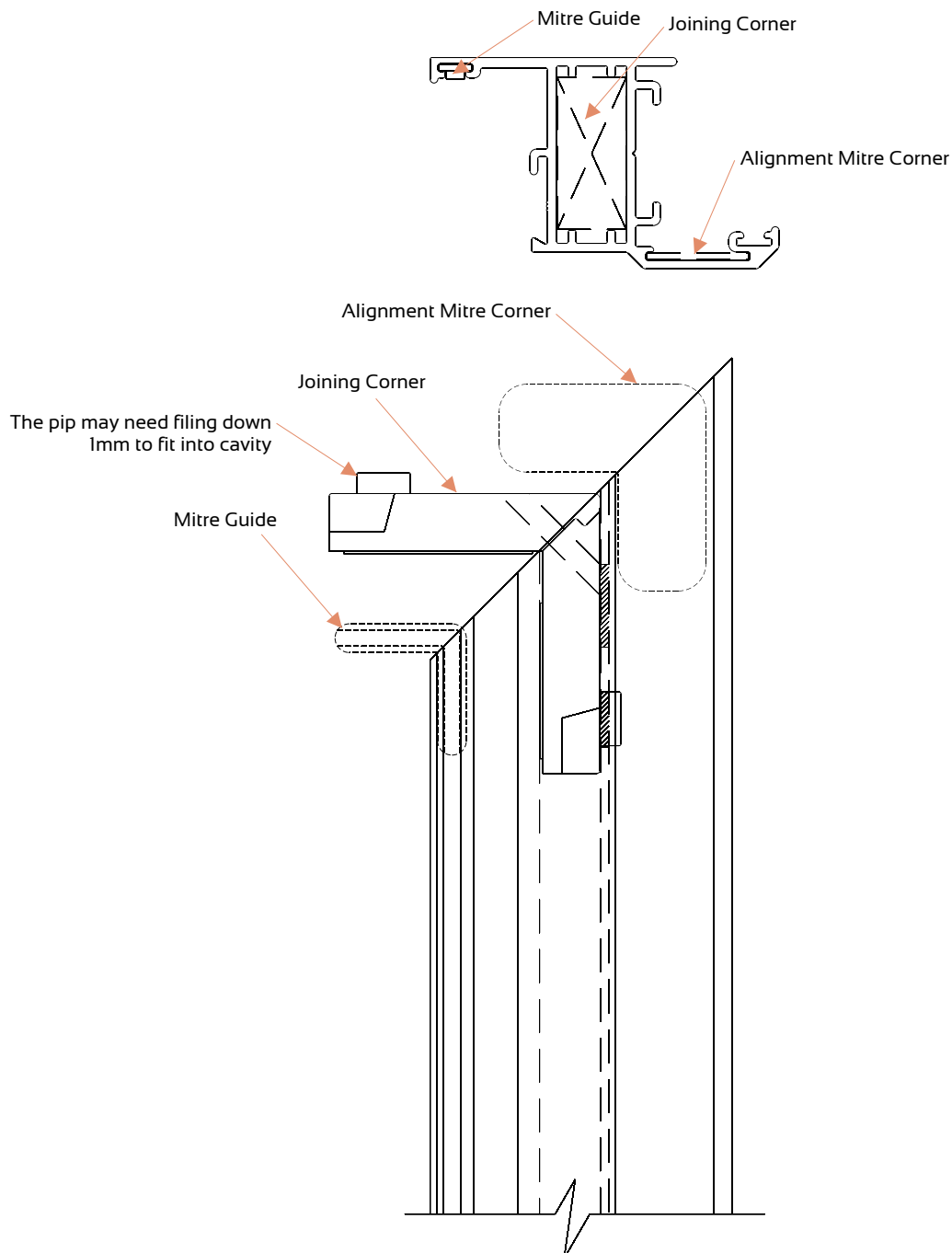
6



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.



OPTION A - USING THE JOINING CORNER

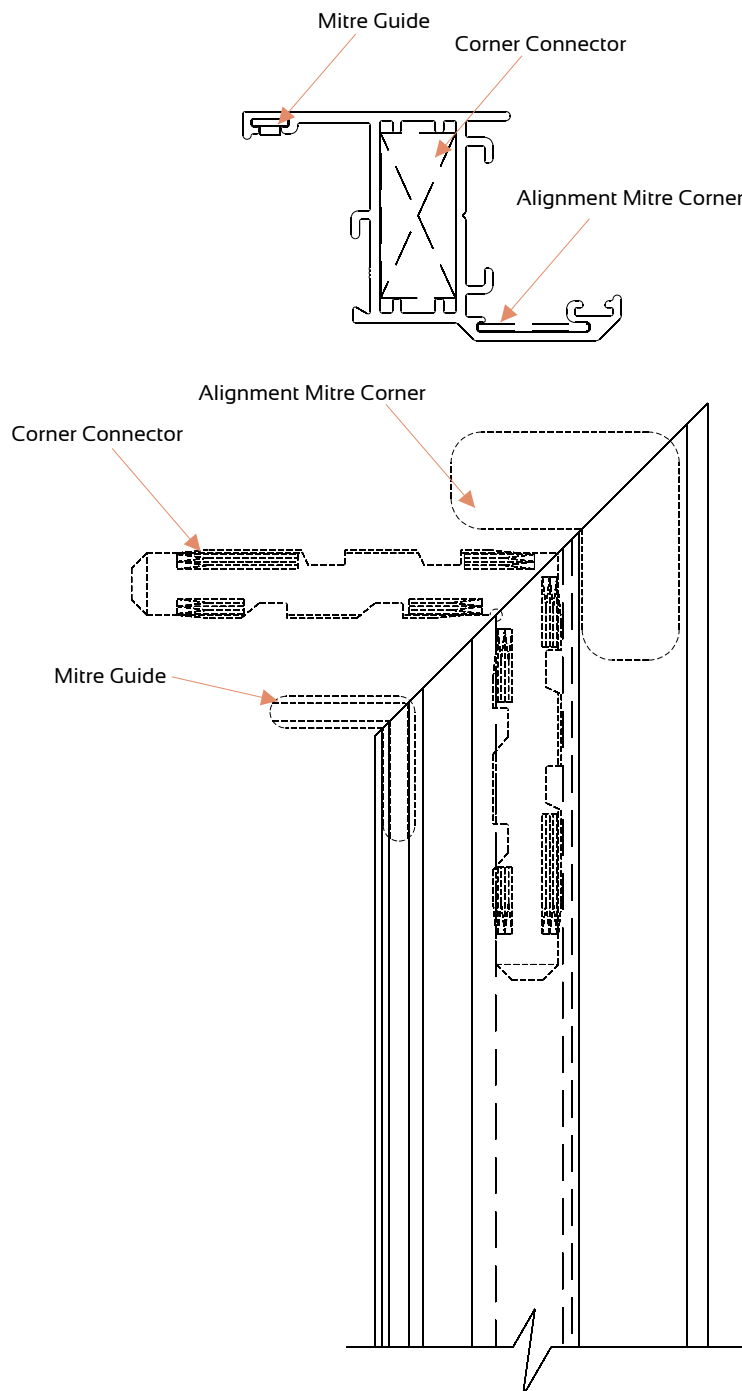


All mechanical joints to be Crealco silicone sealed

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

**No crimping required.**

**OPTION B - USING CORNER CONNECTOR**

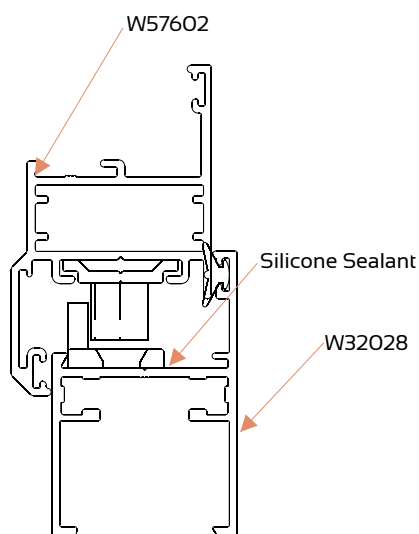


All mechanical joints to be Crealco silicone sealed

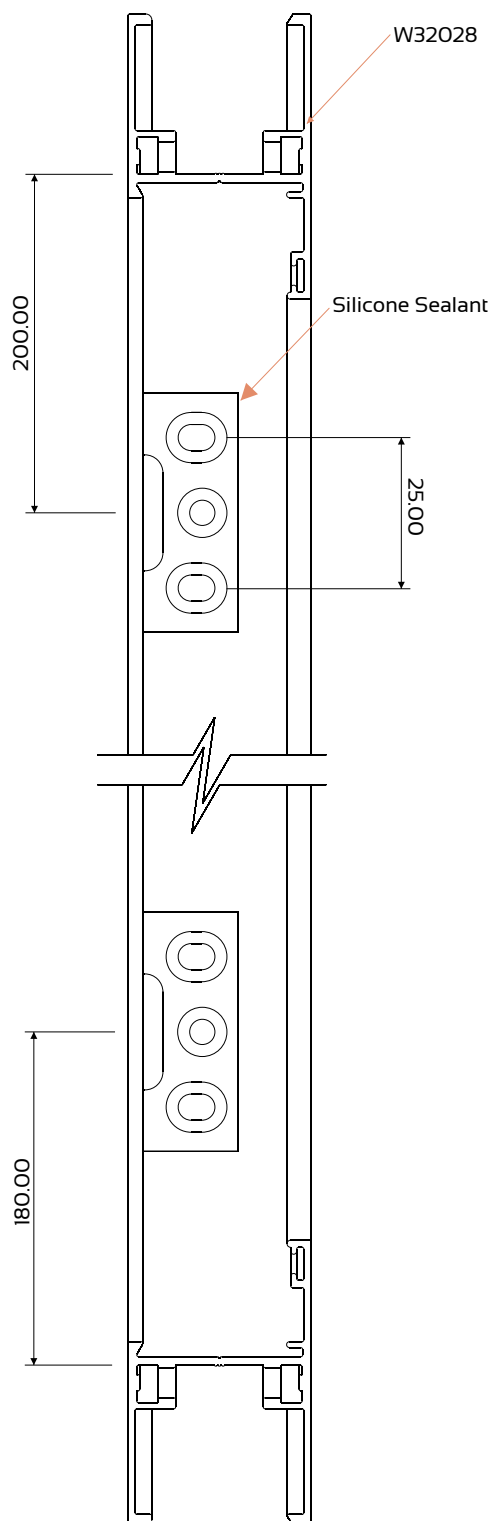
Note: Remember to fit the locking bars for friction stays before assembly of sash frame.

**No crimping required.**

**Typical Multi Lock Sash Locking Angle Detail**



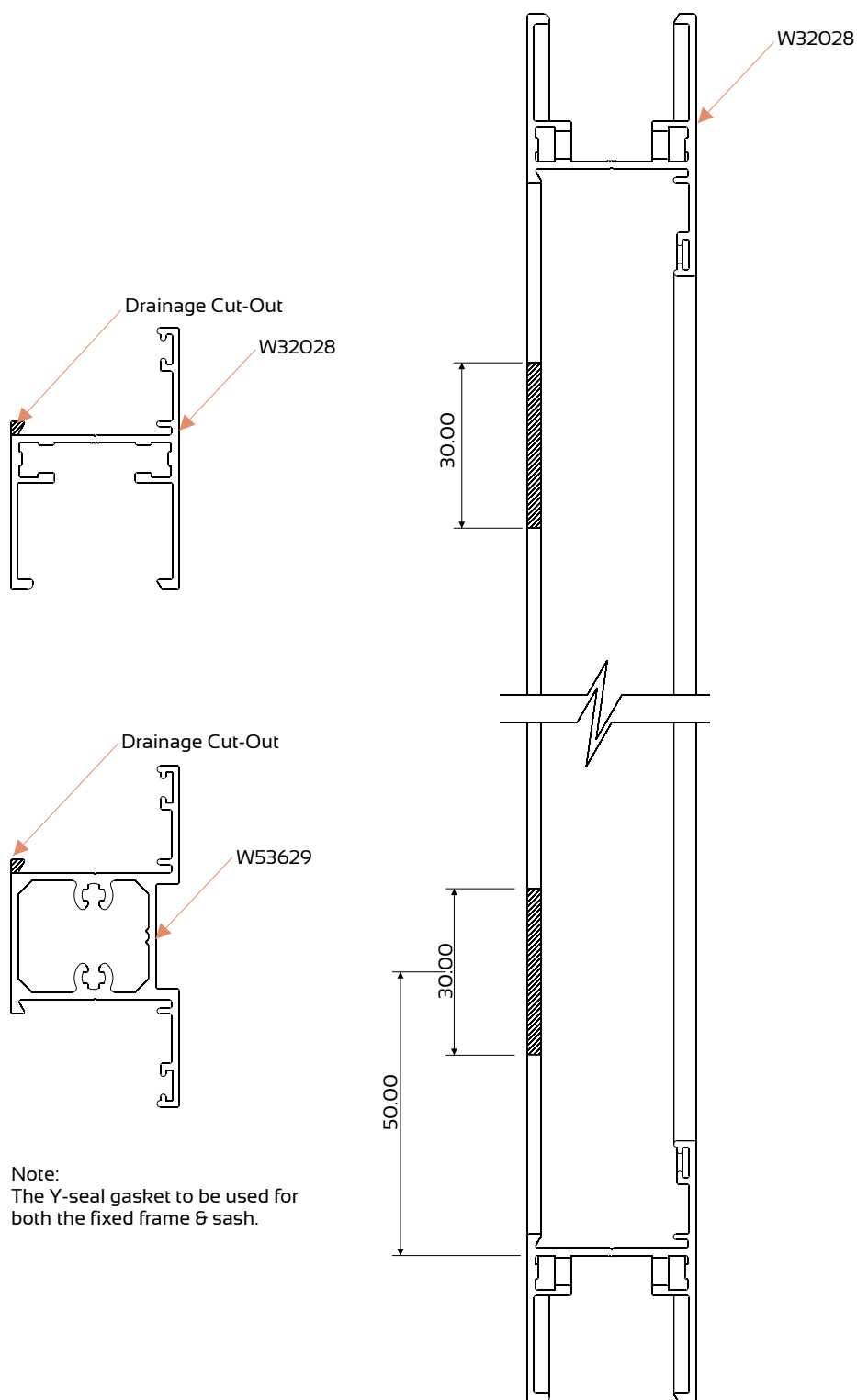
Note:  
No Y-seal gasket to be fitted  
for the bottom sash profile unless  
the building is over 5 stories high.  
Ensure the Y-seal gasket sits  
between the drainage cut-out.



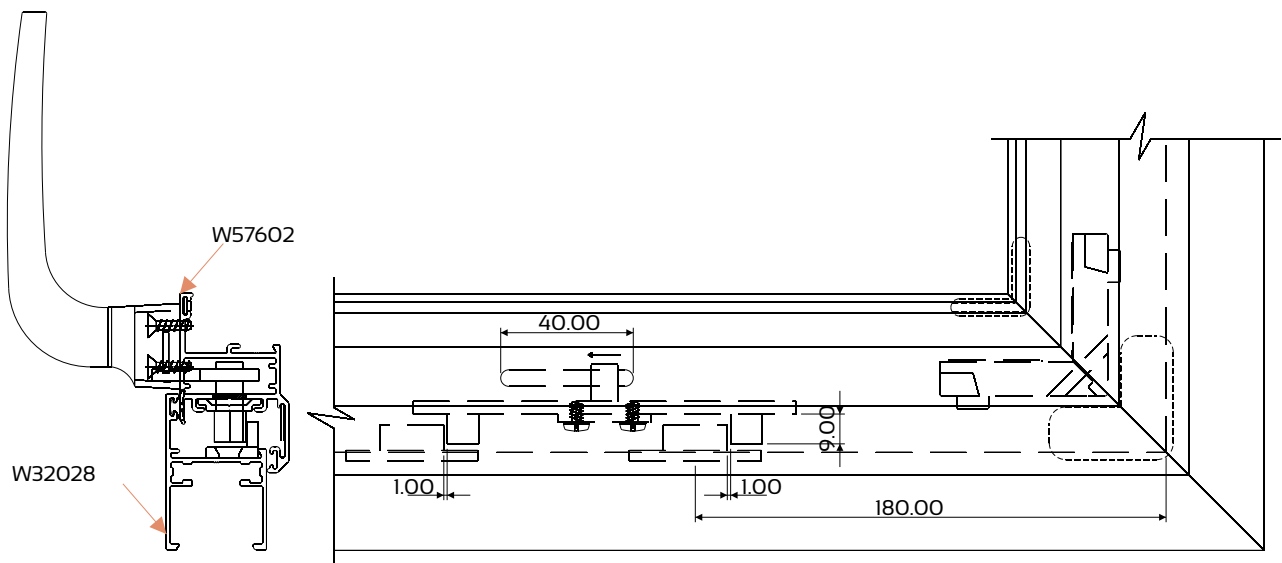


**Typical Multi Lock Sash Outer Frame Drainage Detail**

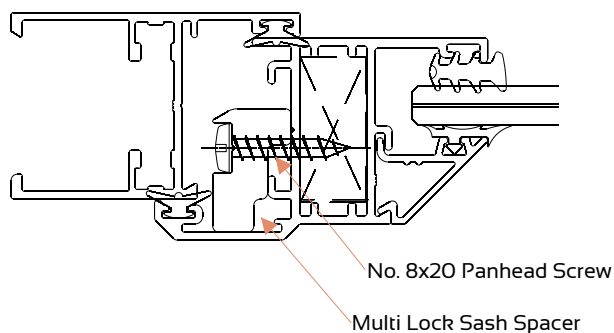
*Detail for Severe Weather Conditions*



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

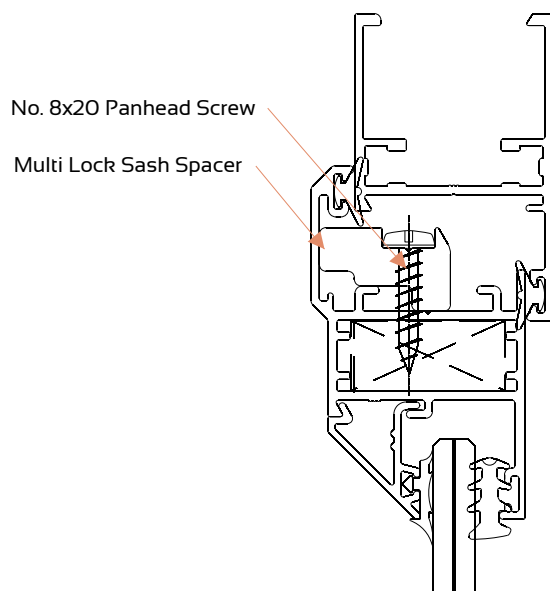
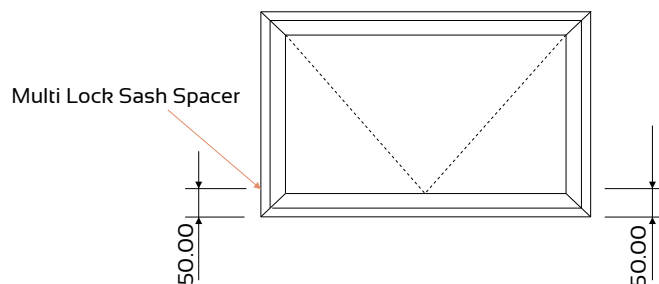


## Typical Fitting of Multi Lock Sash Spacer



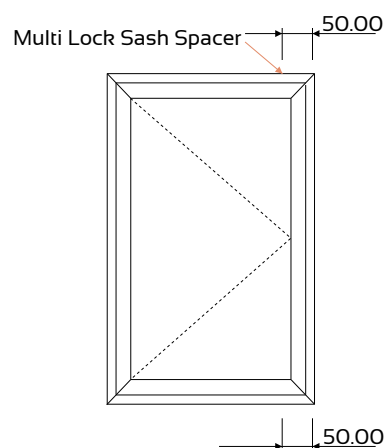
Note:

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.

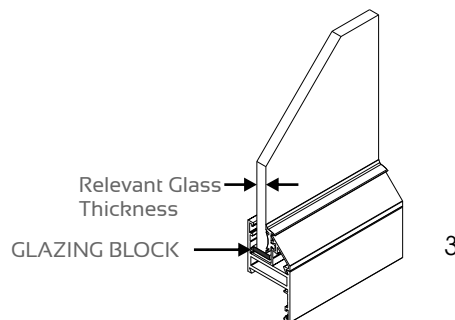
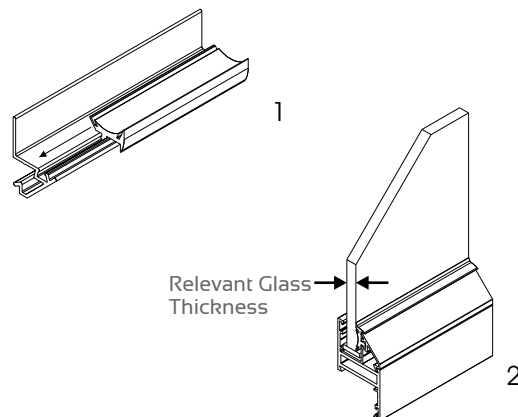
Note:

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.

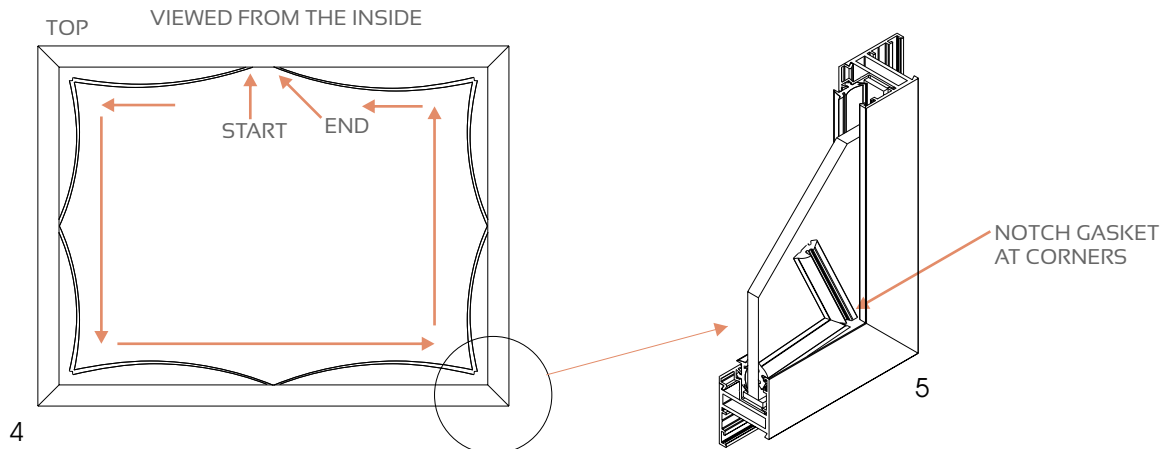
Position the bottom glazing bead in the glazing bead rebate of the relevant profile (2).

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

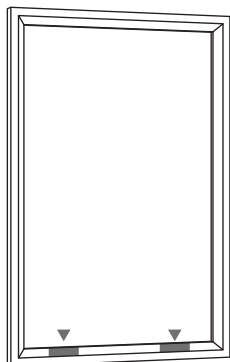
Starting from the top centre, insert the wedge gasket (4) without stretching it. Stop 150mm from the corner & partly cut the wedge gasket 6mm longer than the vertical bead. Insert the gasket into the corner & then roll in remaining 150mm (5). Repeat this on the other sides. Where the gasket end meets,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



**ENSURE GASKETS ARE NOT STRETCHED AT ANY STAGE**

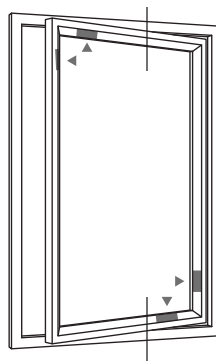


**FIXED**

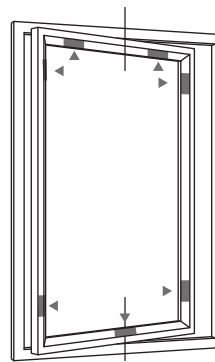


Fixed Light

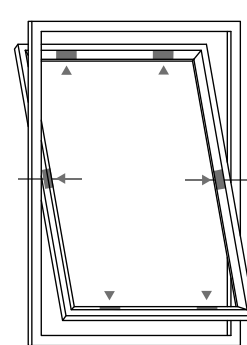
**PIVOTING**



Vertical Pivot  
(hung off-centre)

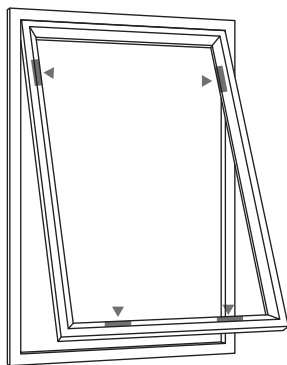


Vertical Pivot  
(hung centrally)

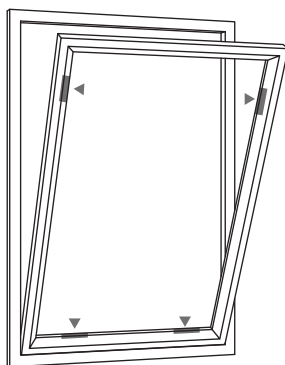


Horizontal Pivot  
and reversible

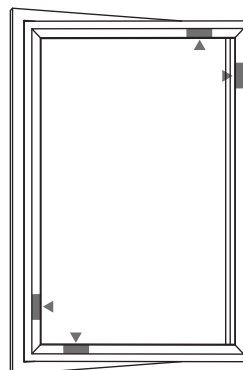
**CASEMENT**



Top Hung

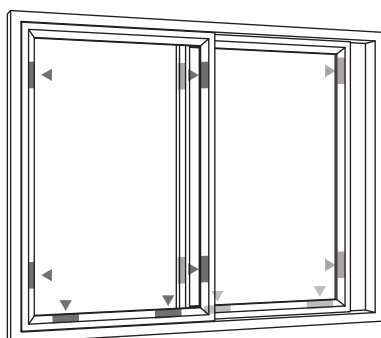


Bottom Hung

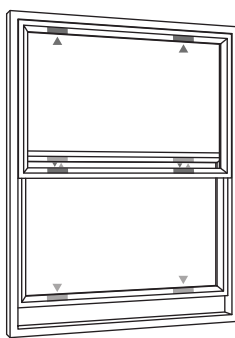


Side Hung

**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.