

1000
SLIDING WINDOW

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 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).*

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.

Index	ii
Legal Disclaimer.....	1

General System

Profile Identification.....	2-3
Hardware Components.....	4-6
Fixing Details.....	7
Cross-Sectional Detail.....	
Detail on A-A showing Interlocker.....	8
Detail on B-B.....	9
Frame Assembly Detail.....	
Outer Frame.....	10
Sash Component	11
Floor Level Detail - Sill Drainage.....	12
Corner Joining Details.....	
Outer Frame.....	13-15
Drainage Details.....	
Outer Frame.....	16-18
Corner Joining Details.....	
Sash Frame	19-21
Machining Detail for Clip-On Interlocker.....	22
Interlocker Detail - Clip On.....	23
Machining Detail - Astragal.....	24
Lock Detail.....	25
Machining Detail - Etex Handle.....	26
Assembly Details.....	
Outer Frame.....	27-28
Heavy Duty Interlocker.....	29
Sliding Window Punch & Cut Out Identification	30
Assembly Details.....	
Vertical Section - Fitting of Anti-Lift Stoppers.....	31
Horizontal Section - Fitting of Anti-Lift Stoppers.....	32
Flyscreen Assembly for both Double & Triple Track	33
Glazing Procedure.....	34

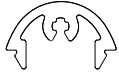
1000

SLIDING WINDOW

PRODUCT MANUAL

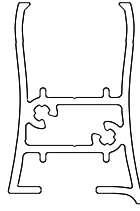
Profile Identification

Series 1000 Profiles



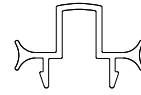
DIE No. W28819

Heavy Duty
Handle Cap



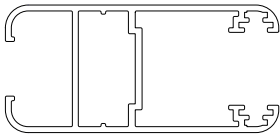
DIE No. W54022

Heavy Duty Handle



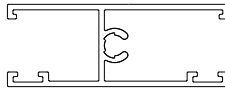
DIE No. W72183

Astragal
For Meeting Stile



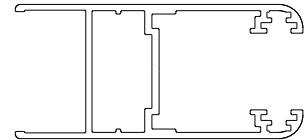
DIE No. W50855

Sash Frame



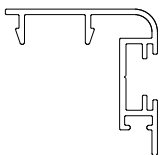
DIE No. W72248

Sash Frame
Transom



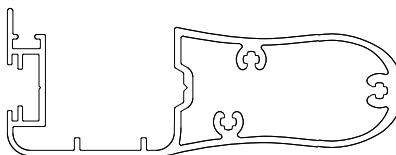
DIE No. W54274

Heavy Duty
Sash Frame



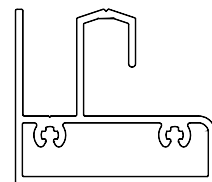
DIE No. W72204

Clip-On
Interlocker



DIE No. W54318

Heavy Duty
Interlocker



DIE No. W54400

Outer Frame
Shutter



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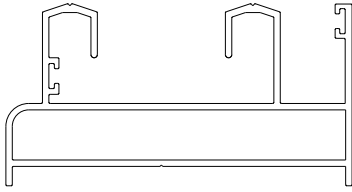
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SLIDING WINDOW

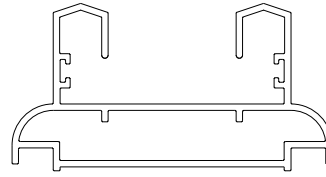
PRODUCT MANUAL

Profile Identification

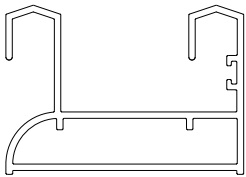
Series 1000 Profiles



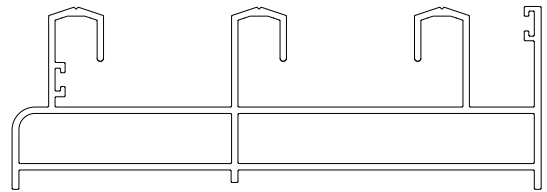
DIE No. W54272 Outer Frame With Lip



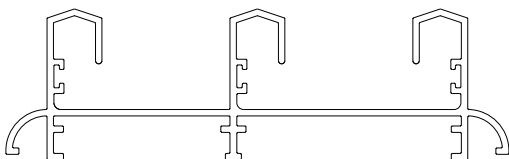
DIE No. W50879 Symmetrical Double Track



DIE No. W50827 Outer Frame Double Track



DIE No. W54299 Triple Frame With Lip



DIE No. W29233 Triple Track



DIE No. W14014 500 Sill Extension



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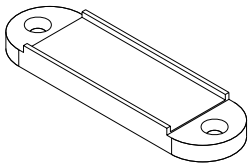
SLIDING WINDOW

PRODUCT MANUAL

Hardware Components

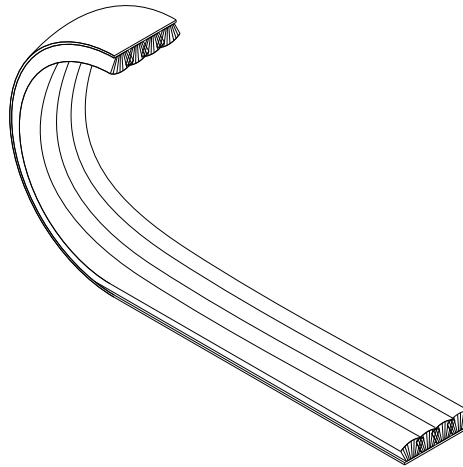
RECOMMENDED SERIES 1000 COMPONENTS

All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com



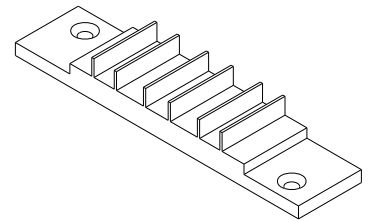
PEX-2685

Draft Excluder



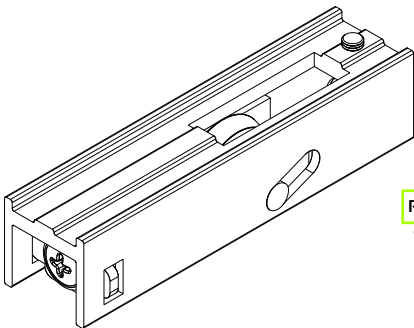
PEX-PSO

Pile for Draft Excluder



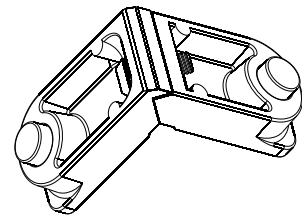
PEX-E28

Draft Excluder



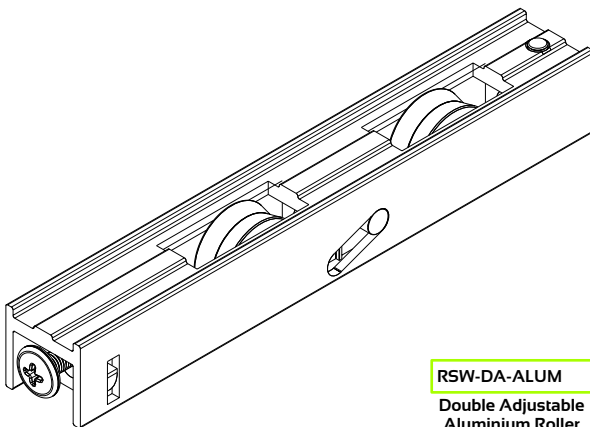
RSW-SA23-ALUM

Single Adjustable
Aluminium Roller



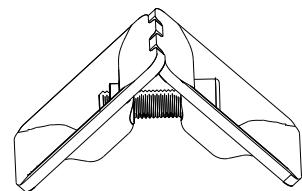
LGC-JC2410N

Joining Corner



RSW-DA-ALUM

Double Adjustable
Aluminium Roller



LGC-JCC

Joining Corner
Cup Type



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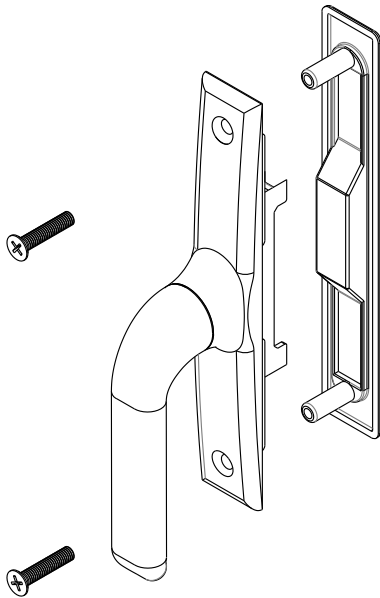
SLIDING WINDOW

PRODUCT MANUAL

Hardware Components

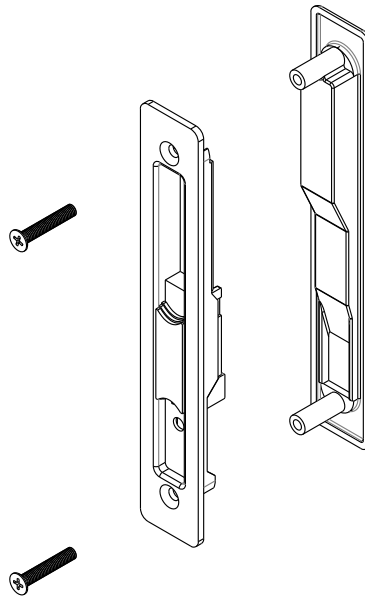
RECOMMENDED SERIES 1000 COMPONENTS

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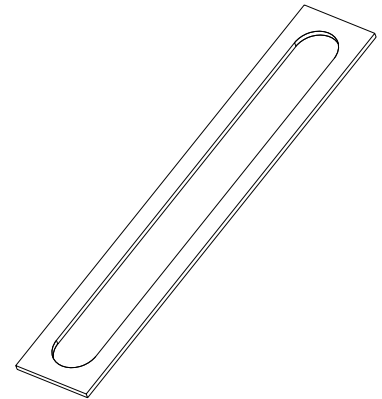
SDW-DSL791

Domus Handle
(Black or White)



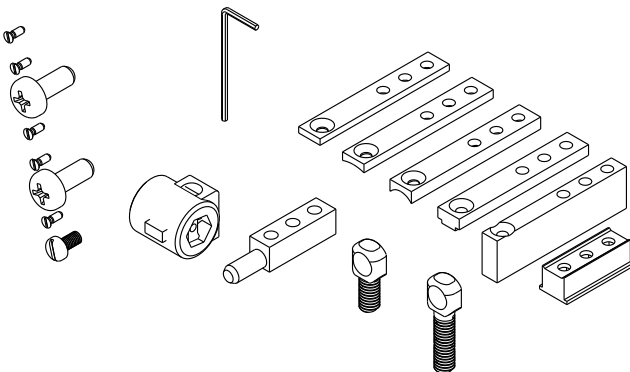
SDW-DSL78

Domus Flush Handle
(Black or White)



SUN-SSE-BLK

PVC Backing Plate

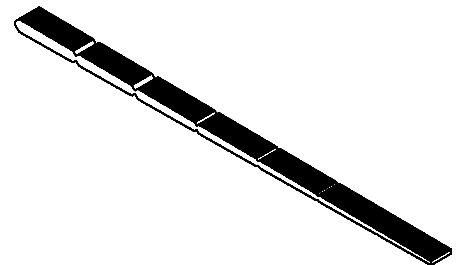


DW-DSL780I-SS

Domus S/Stell Keep Set
(White)

SDW-KP006

Domus S/Stell Keep Set
(Black)



FSN-GSB

Glass Setting Blocks

1000

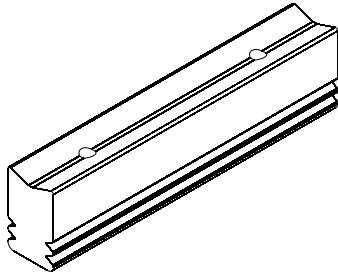
SLIDING WINDOW

PRODUCT MANUAL

Hardware Components

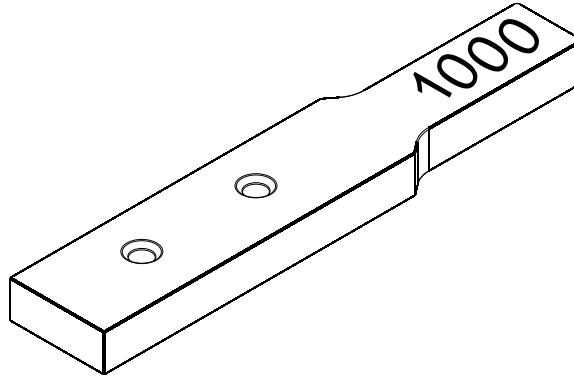
RECOMMENDED SERIES 1000 COMPONENTS

All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com



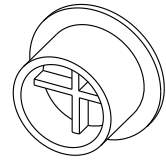
SGD-ALS1000S

1000 Series Anti-Lift



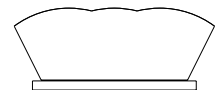
TLP-S1000

1000 Series Jig



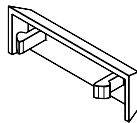
PEX-NRV

Non-Return Valve



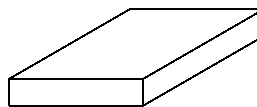
GWP-1360

13mm Woolpile



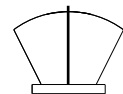
PEX-WDC

Drainage Cover PVC



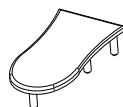
GSN-GSBDG40

Double Glazing
Setting Block



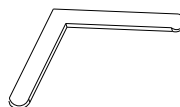
GFP-6750

Finseal



PEC-HHD

Heavy Duty Handle
End Cover



SGD-FMG48

Frame Mitre Guide



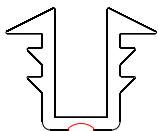
GSL-48EPDM

Bubble Seal



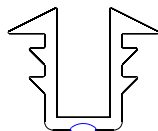
GWG-H23A

Wedge Ripped Gasket



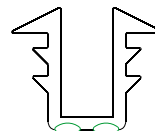
GCH-CR

Red Pip = 4mm Glass



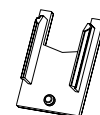
GCH-CB

Blue Pip = 5mm Glass



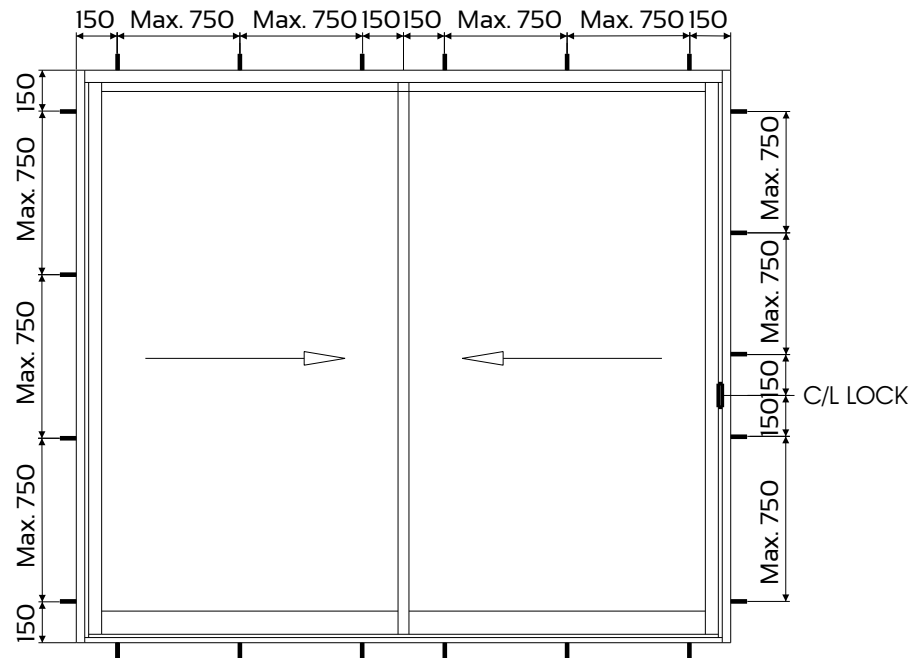
GCH-CG

Green Pip = 6.38mm Glass

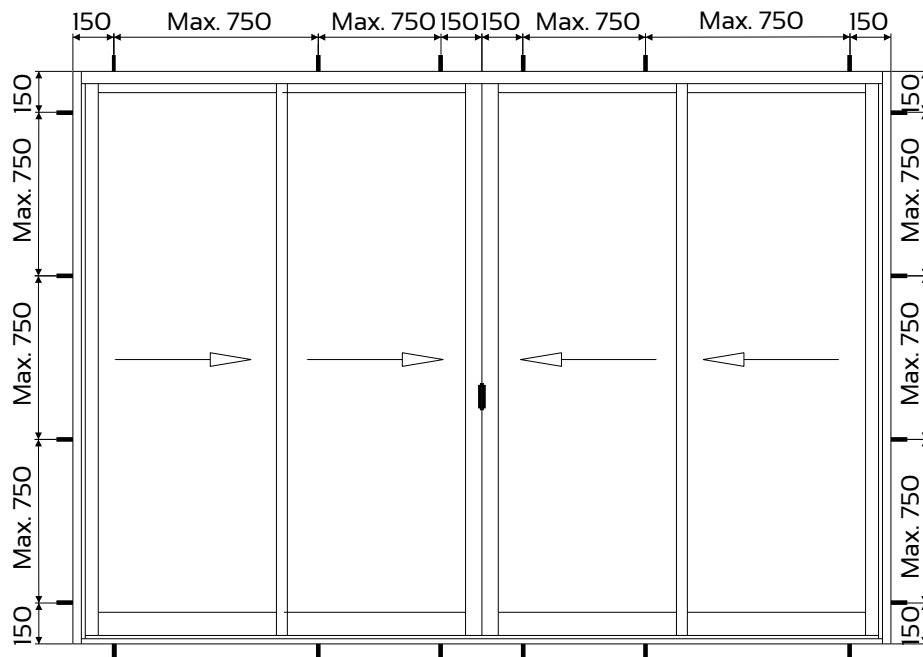


PEC-I1000

Interlocker Cap



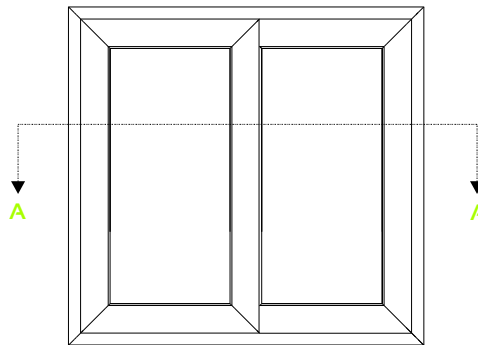
TYPICAL XX SLIDING DOOR &
HORIZONTAL SLIDING WINDOW



TYPICAL XXXX SLIDING DOOR &
HORIZONTAL SLIDING WINDOW

Cross Sectional Detail

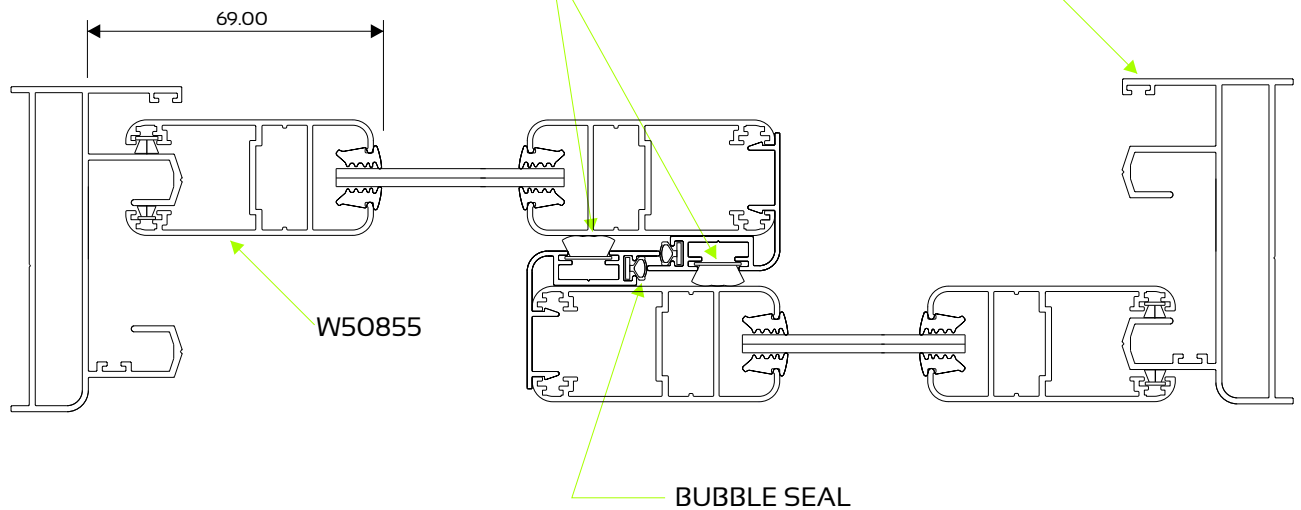
Detail On A-A Showing Interlocker



SECTION A - A

Section not to scale

SASH FRAME WITH CLIP ON INTERLOCKERS
13mm WOOLPILE TO COVER SCREW HEADS



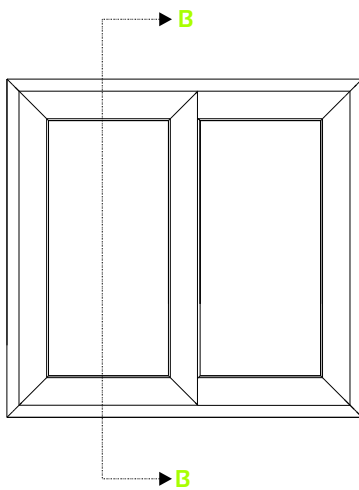
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SLIDING WINDOW

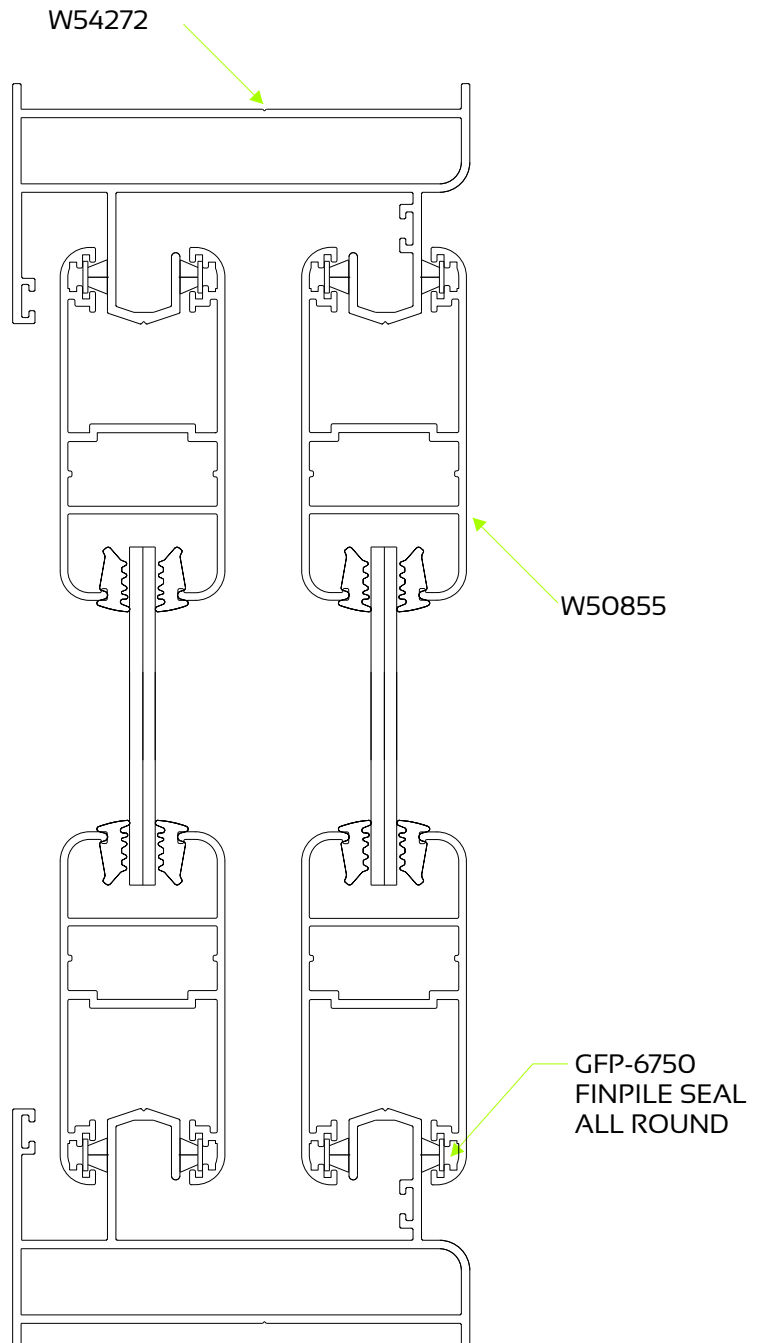
PRODUCT MANUAL

Cross Sectional Detail

Detail On B-B



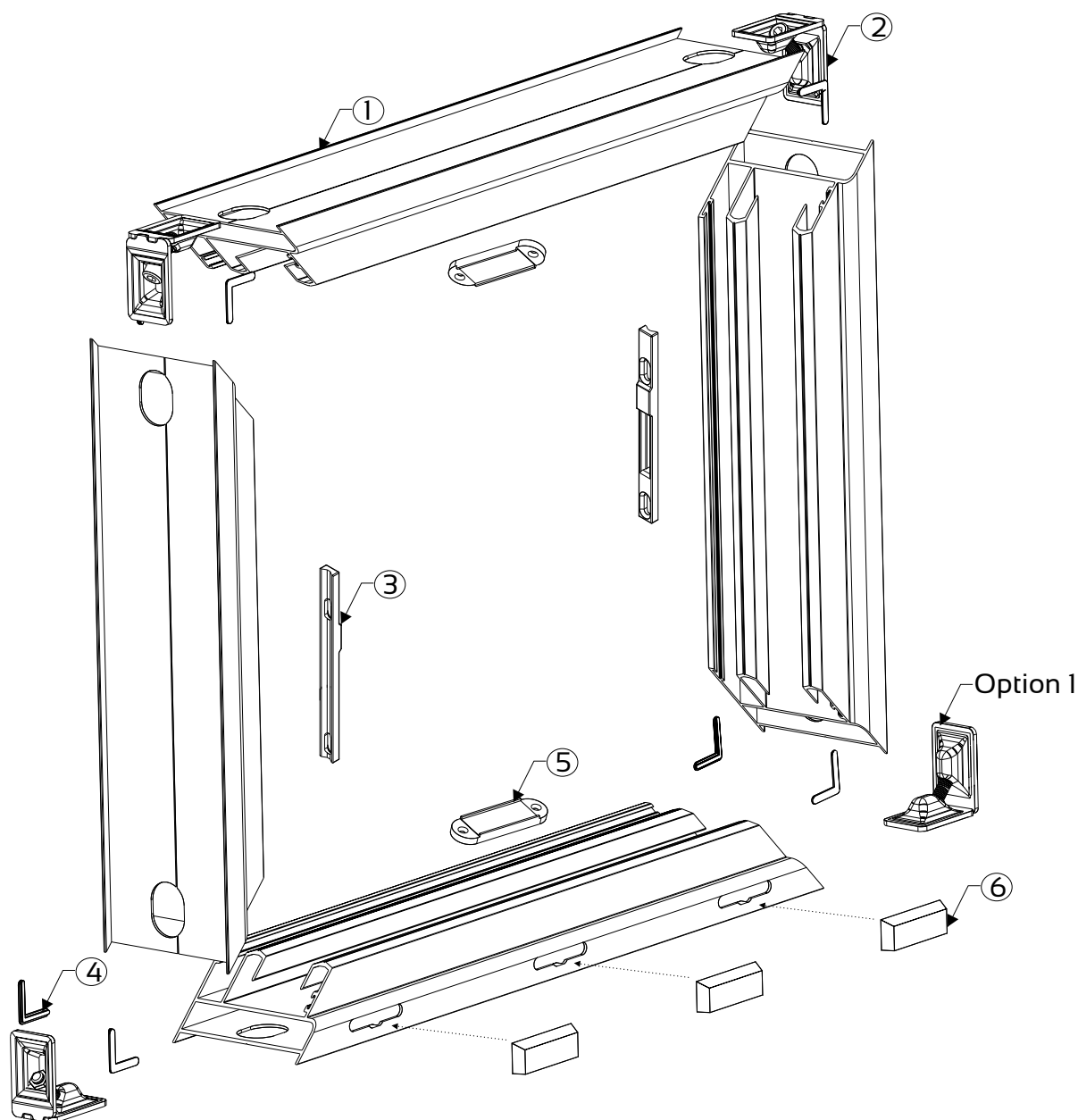
SECTION B-B
Section not to scale



Assembly Detail

Outer Frame Component

All Mechanical Joints & Cup Cleats are to be sealed with silicone.



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W54272	Outer Frame with Lip

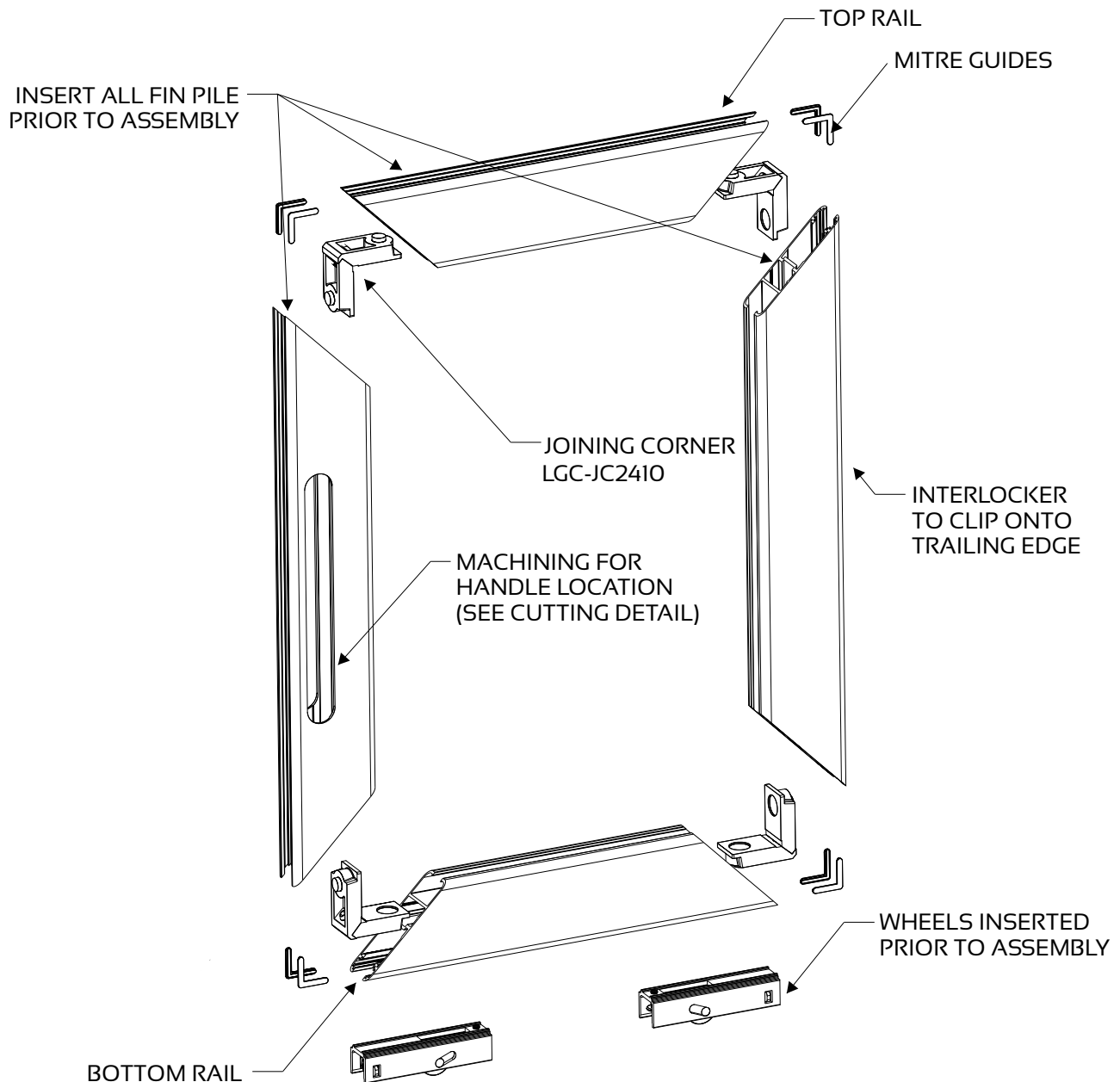
Hardware

ITEM	QTY	COMPONENT DESCRIPTION
2	4	Joining Corner Cup Type
3	2	Striker Plate
4	8	Frame Mitre Guides
5	2	Draught Extruder with Pile
6	2/3	Drainage Covers

Assembly Detail

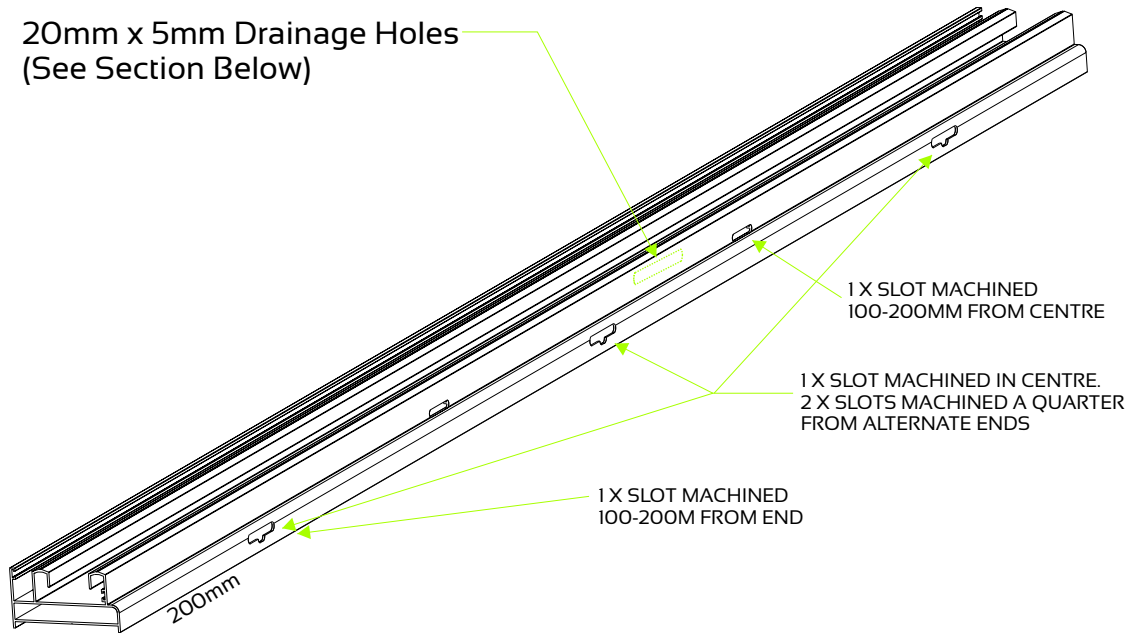
Sash Component

All **Mechanical Joints** to be sealed with a clear silicon. Silicon should be applied to **Joining Corner (JCC2410)** during manufacturing so that, when in place, the silicon forms a seal between the profile and itself, and in doing so, prevents any corrosion that may take place in an average to high corrosion area

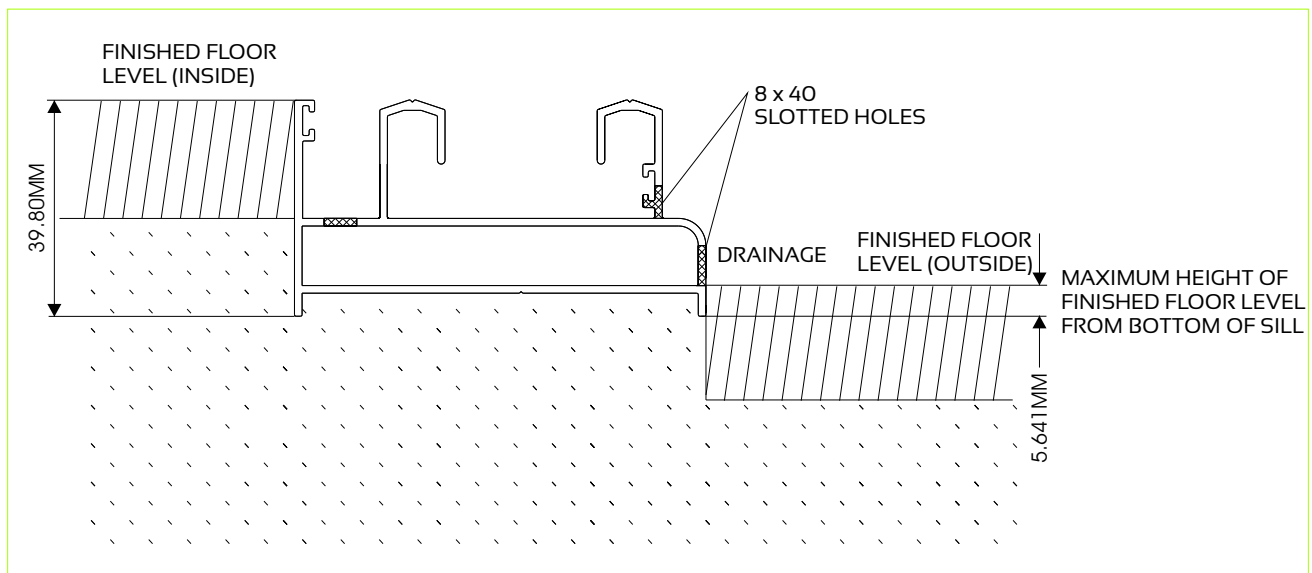


Floor Level Detail

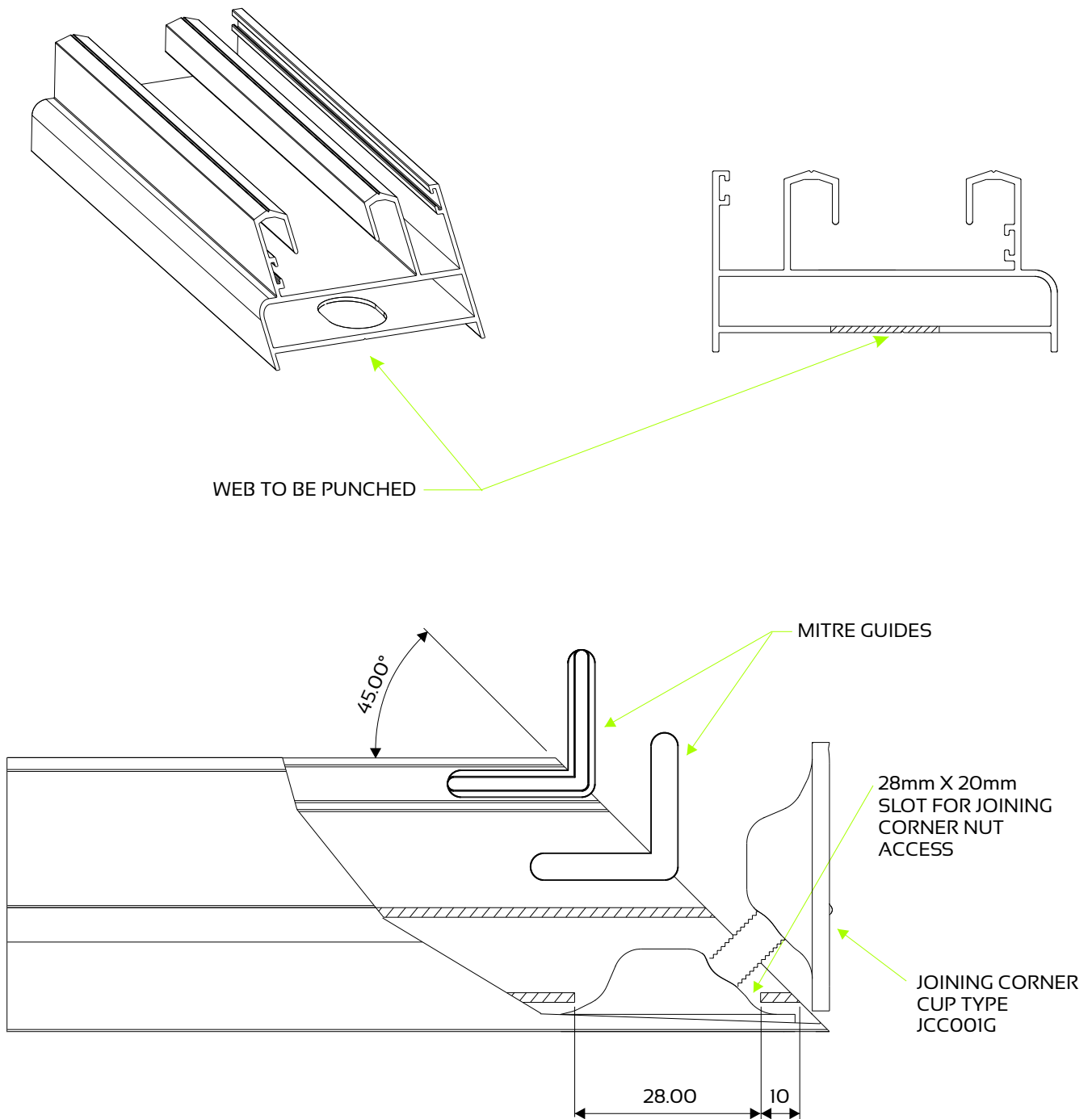
Sill Drainage



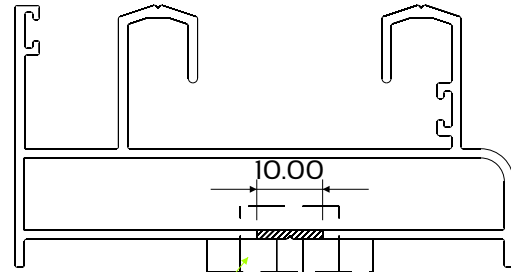
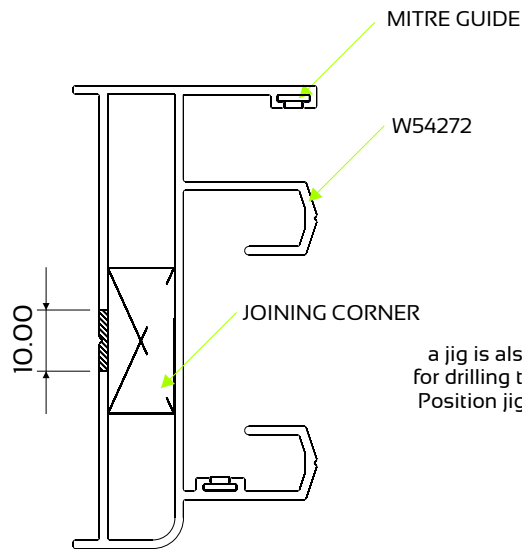
NOTE:
DO NOT DRAIN TRACK UNDER SASH



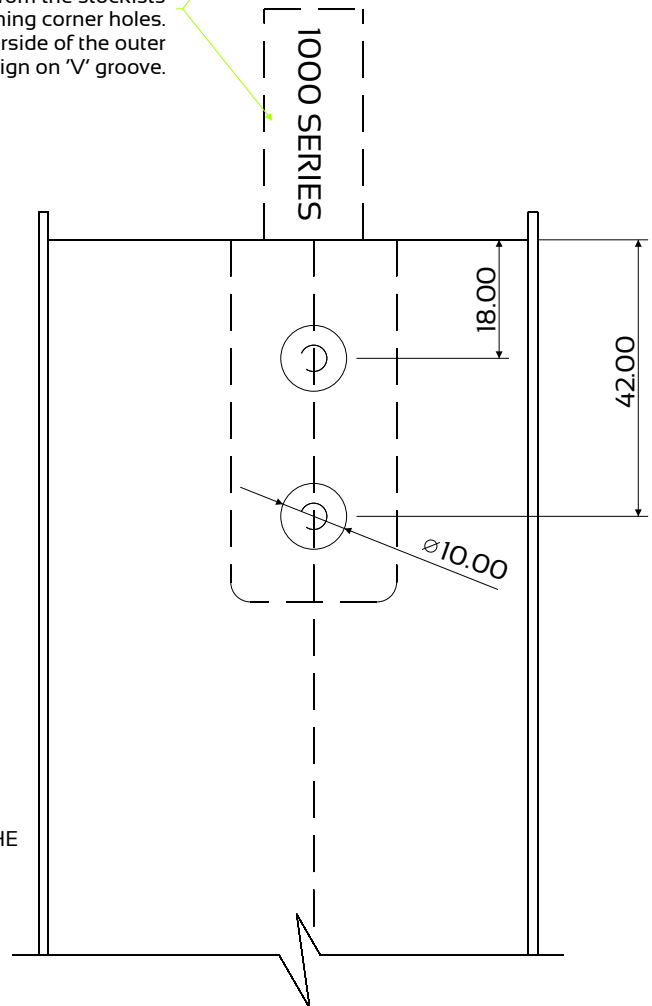
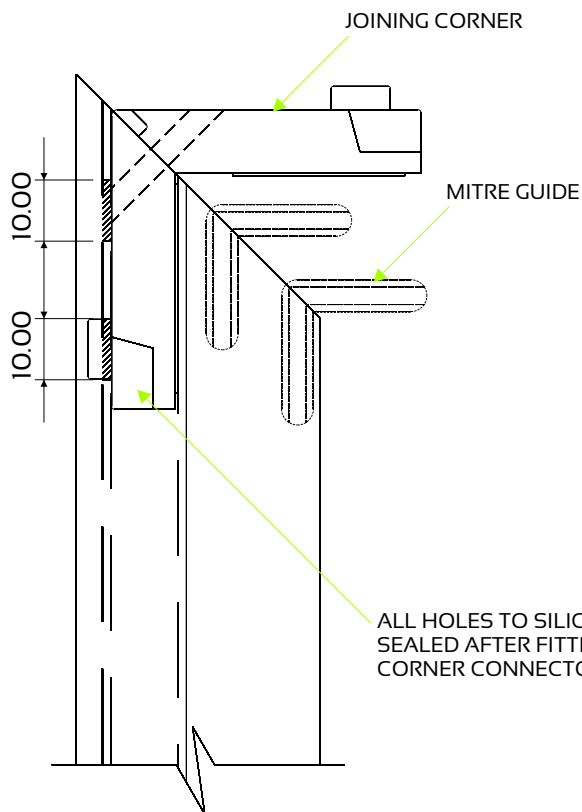
OPTION ONE: USING PUNCH TOOLING



**OPTION TWO:
USING JIG**

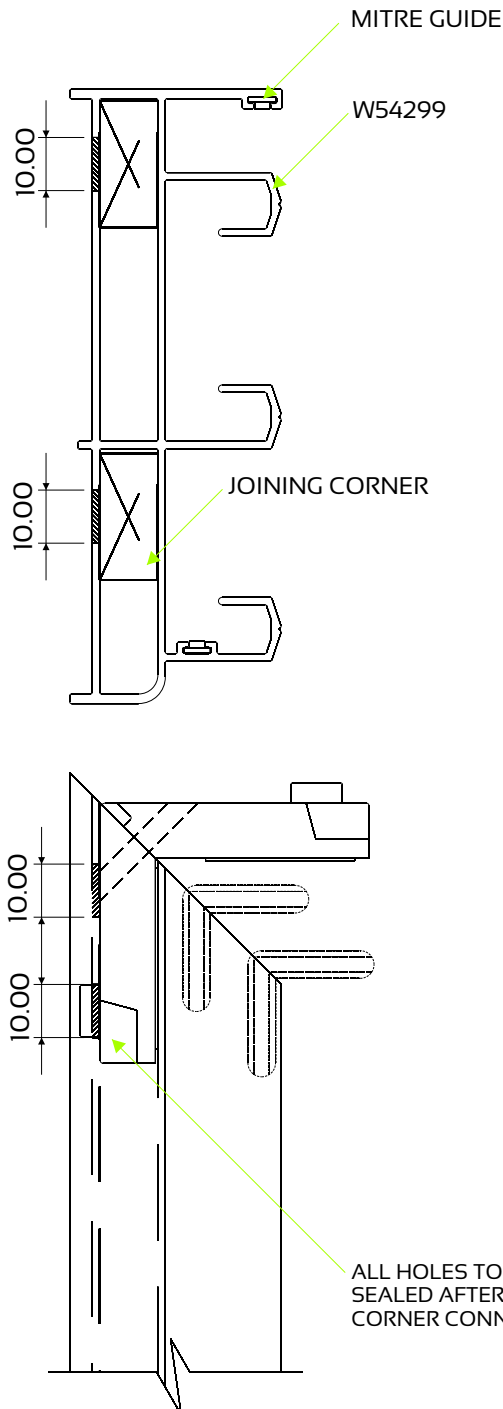


In place of a punch tool, a jig is also available from the stockists for drilling the nylon joining corner holes. Position jig to the underside of the outer frame & align on 'V' groove.

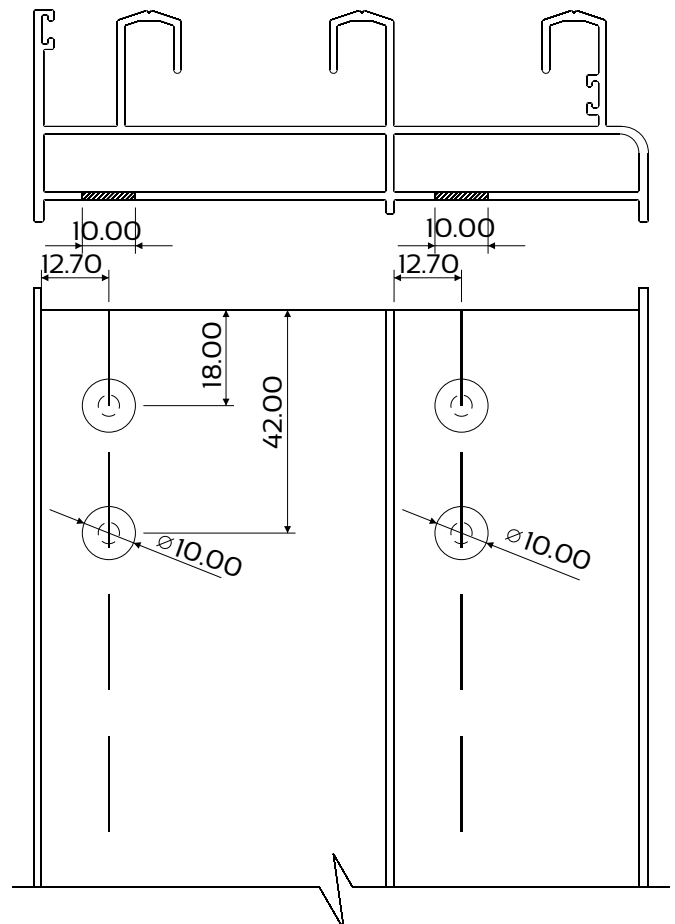


ALL MECHANICAL JOINTS TO BE SILICONE SEALED

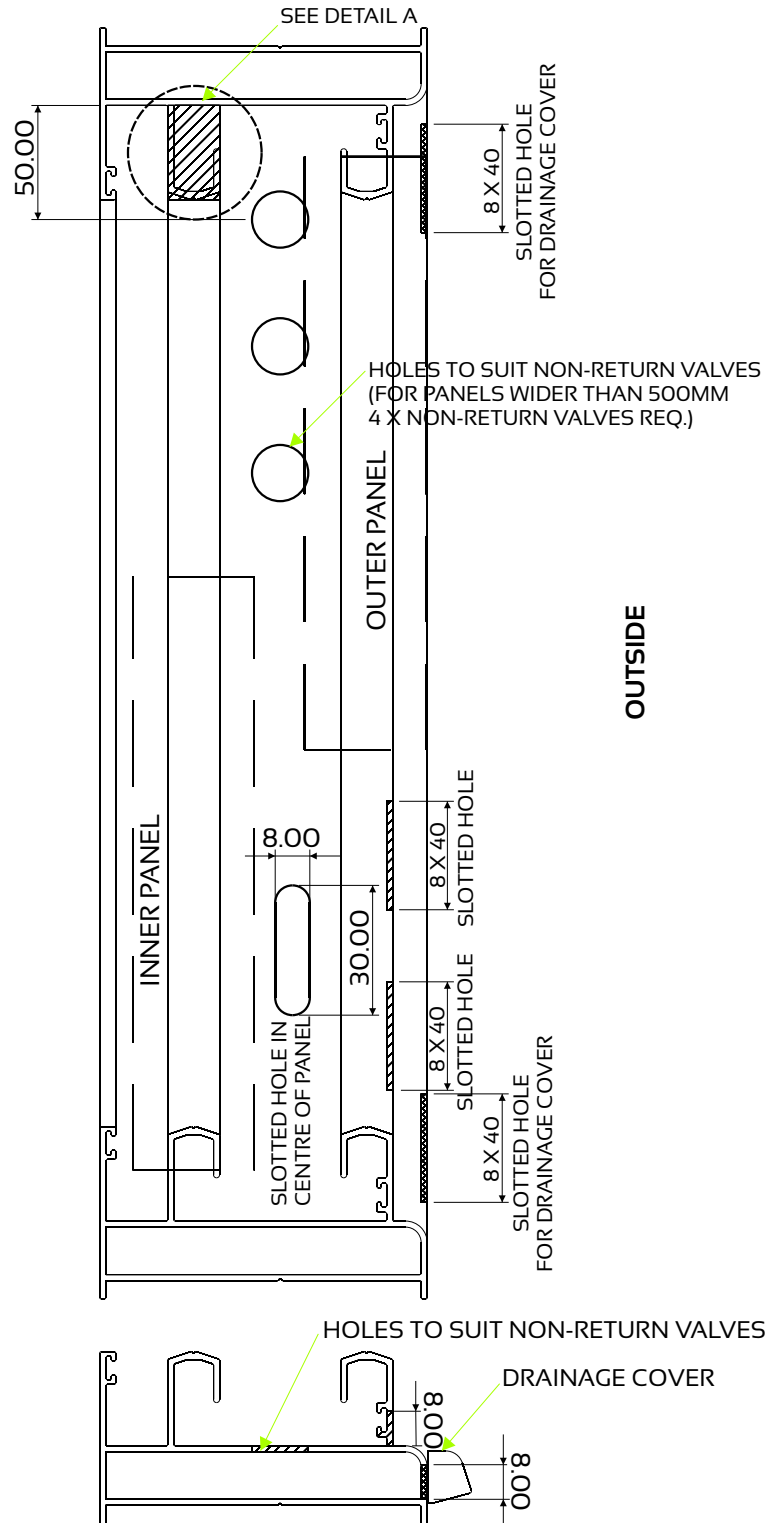
**OPTION TWO:
USING JIG**



IN PLACE OF A PUNCH TOOL,
A JIG IS ALSO AVAILABLE FROM THE STOCKISTS
FOR DRILLING THE NYLON JOINING CORNER HOLES.

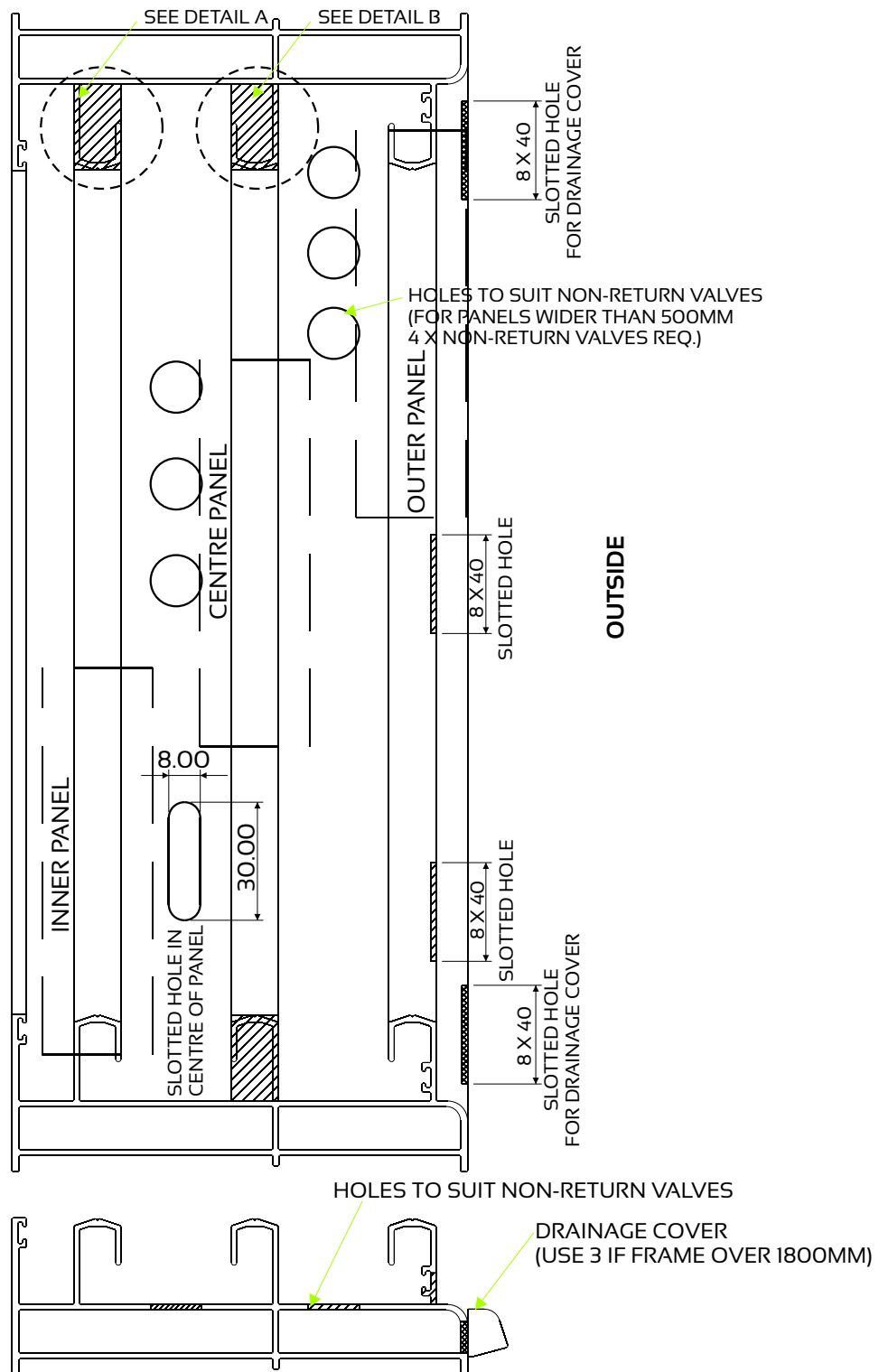


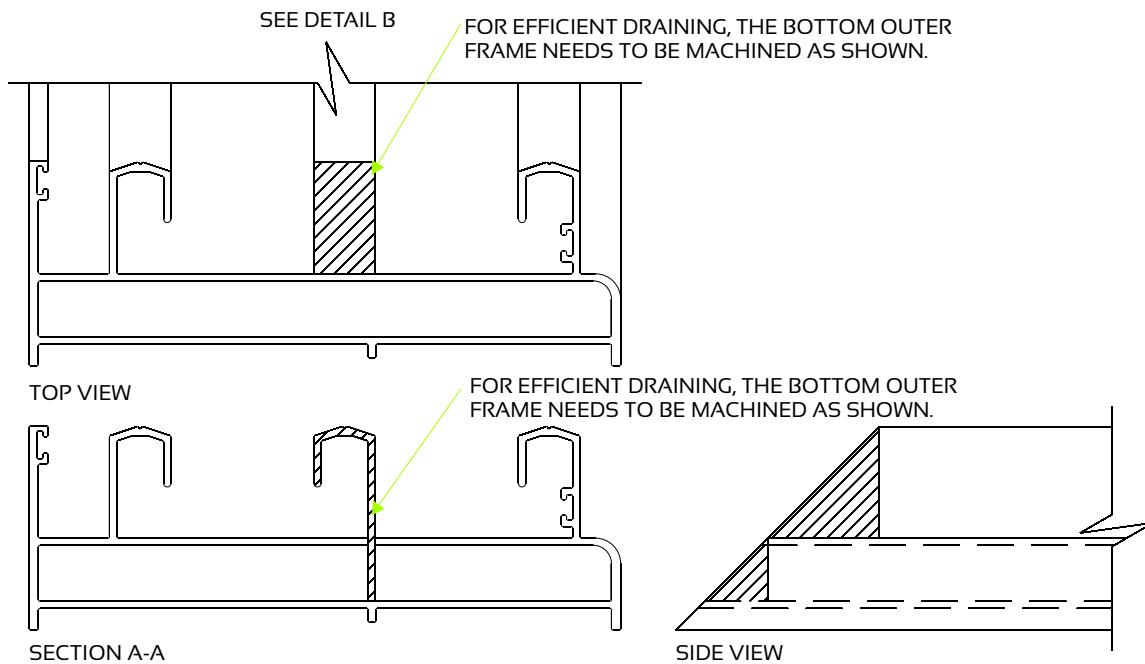
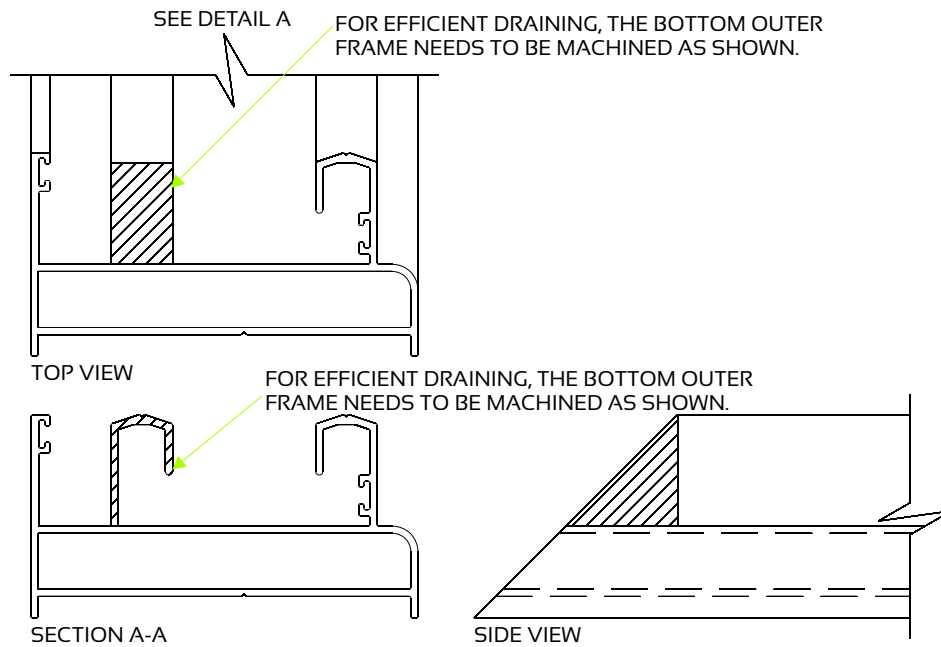
ALL MECHANICAL JOINTS TO BE SILICONE SEALED



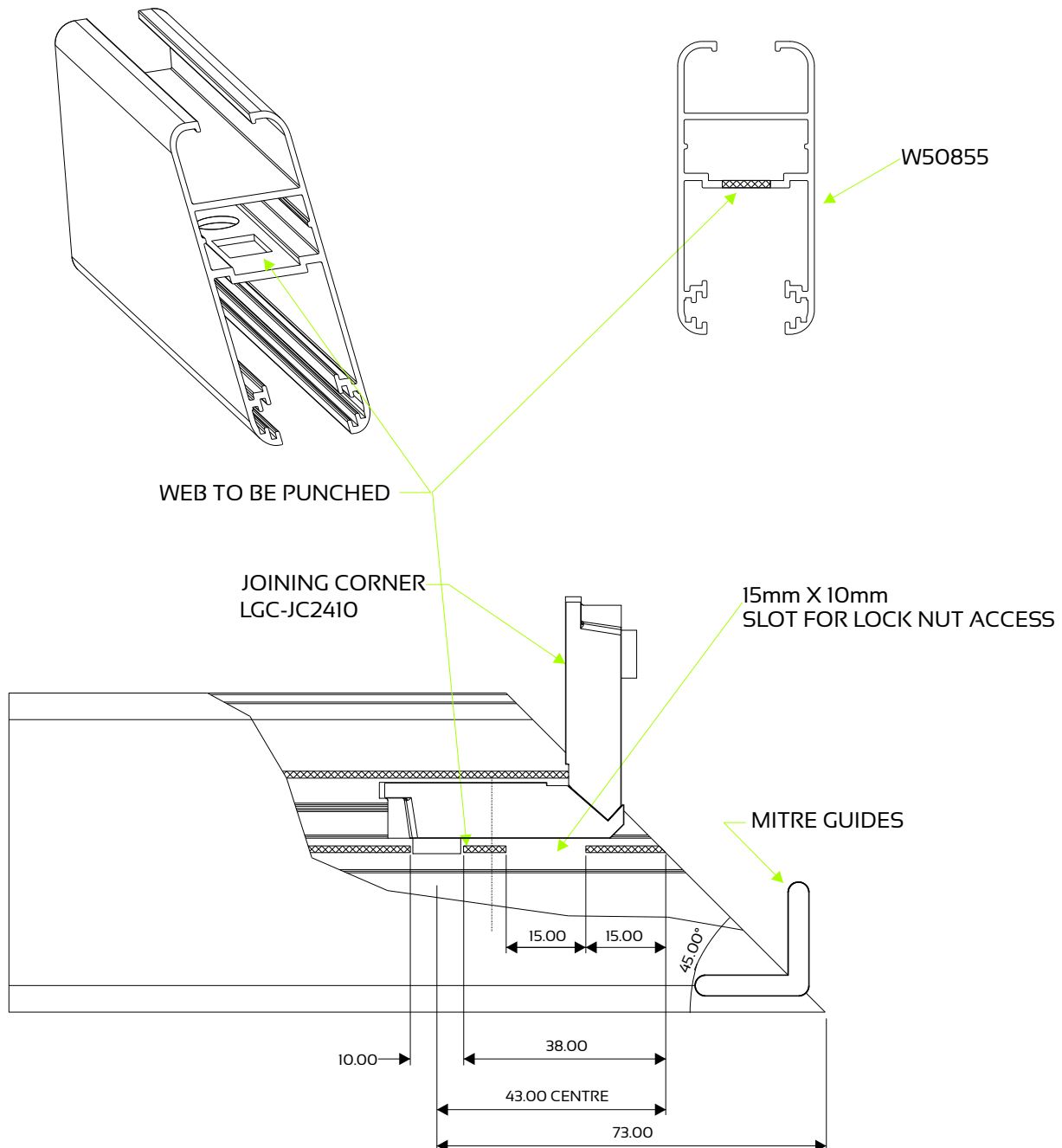
Drainage Details

For Outer Frame - Triple Frame



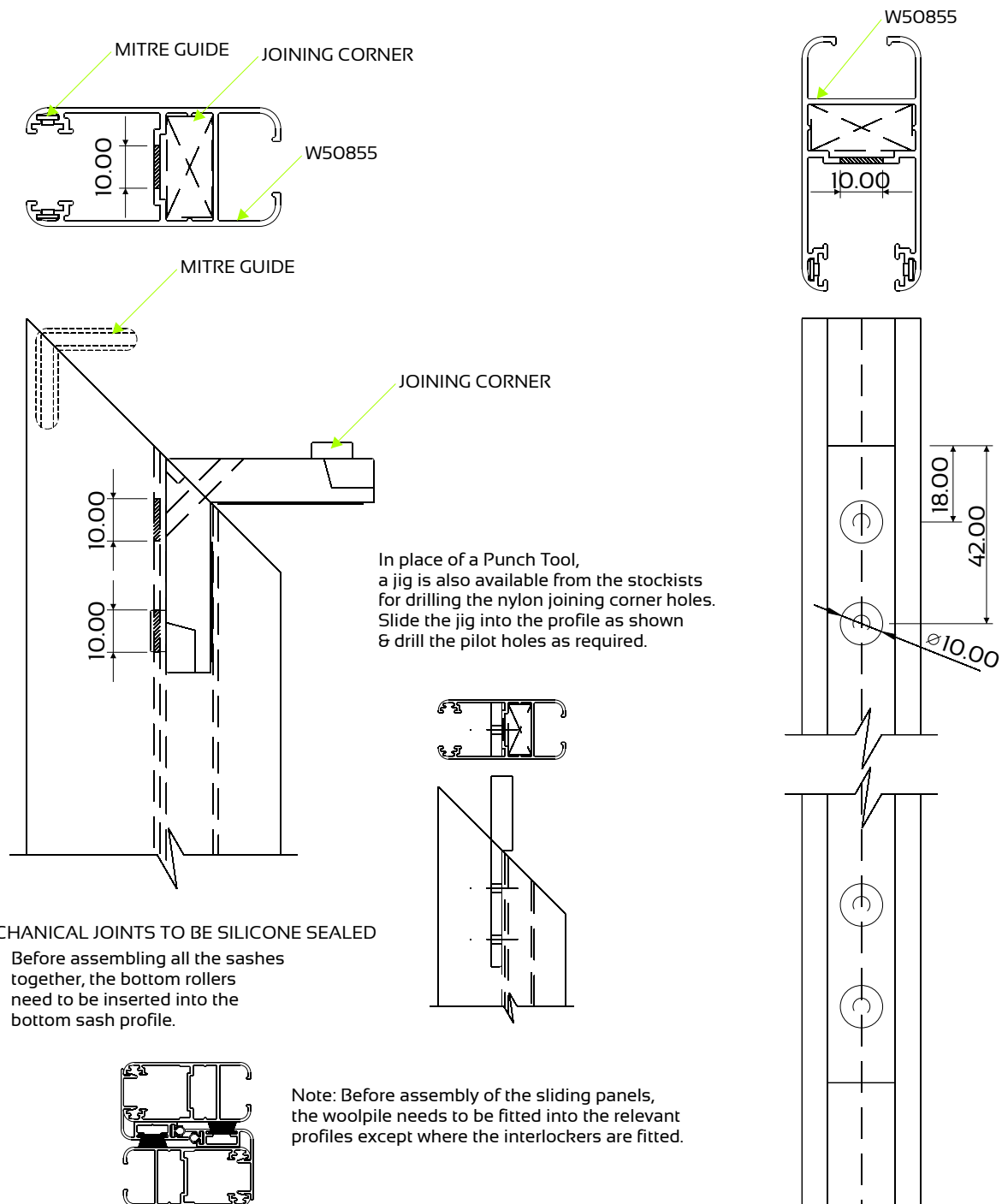


OPTION ONE: USING PUNCH TOOLING

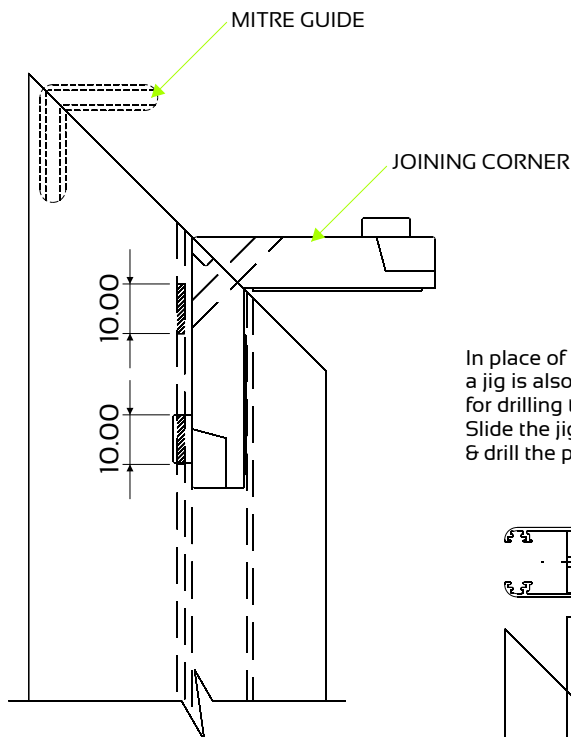
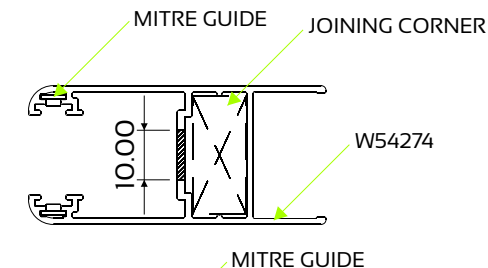


*ALL MECHANICAL JOINTS TO BE SEALED WITH CLEAR SILICON.

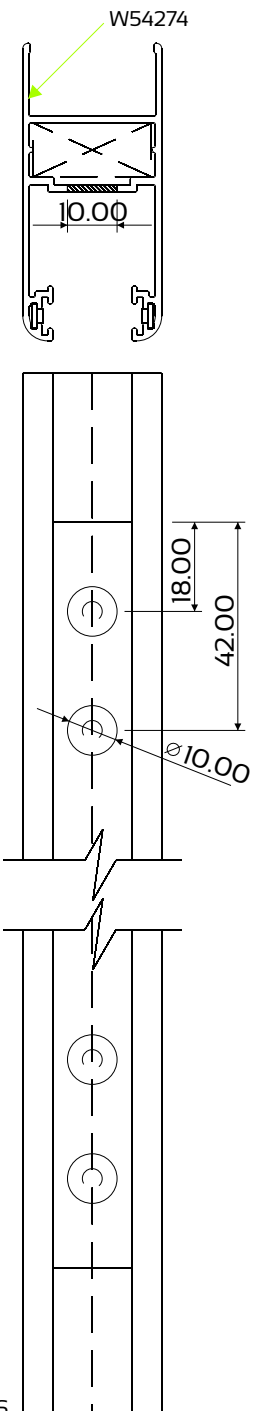
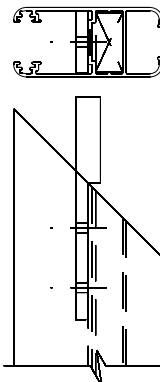
*SILICON SHOULD BE APPLIED TO JCC2410 DURING MANUFACTURING SO THAT WHEN IN PLACE THE SILICON FORMS A SEAL BETWEEN THE PROFILE AND ITSELF AND IN DOING SO PREVENTS ANY CORROSION THAT MIGHT TAKE PLACE IN AN AVERAGE TO HIGH CORROSION AREA.

**OPTION TWO:
USING JIG**

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USING JIG**

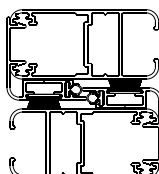


In place of a Punch Tool,
a jig is also available from the stockists
for drilling the nylon joining corner holes.
Slide the jig into the profile as shown
& drill the pilot holes as required.



ALL MECHANICAL JOINTS TO BE SILICONE SEALED

Before assembling all the sashes
together, the bottom rollers
need to be inserted into the
bottom sash profile.



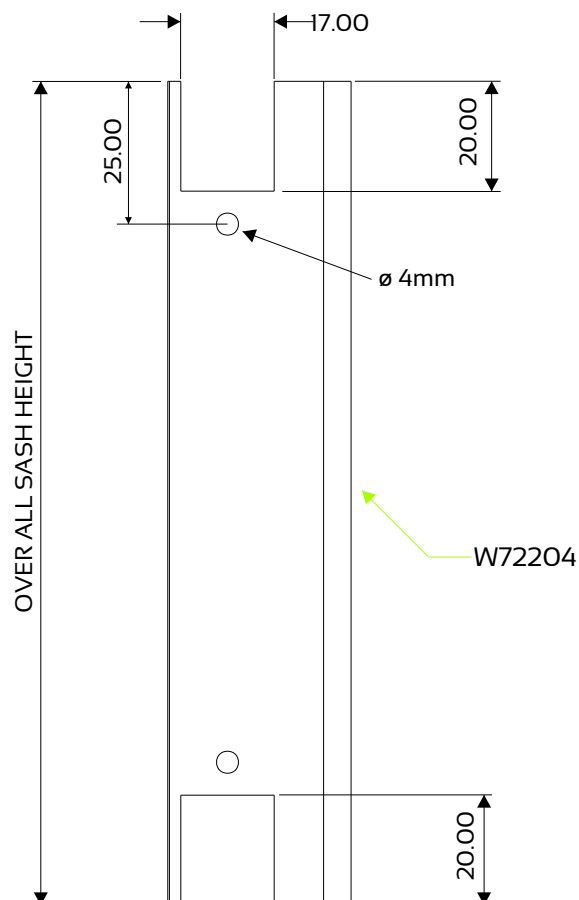
Note: Before assembly of the sliding panels,
the woolpile needs to be fitted into the relevant
profiles except where the interlockers are fitted.

*ALL MECHANICAL JOINTS TO BE SEALED WITH CLEAR SILICON.

*SILICON SHOULD BE APPLIED TO JCC2410 DURING MANUFACTURING SO THAT WHEN IN
PLACE THE SILICON FORMS A SEAL BETWEEN THE PROFILE AND ITSELF AND IN DOING SO PREVENTS
ANY CORROSION THAT MIGHT TAKE PLACE IN AN AVERAGE TO HIGH CORROSION AREA.

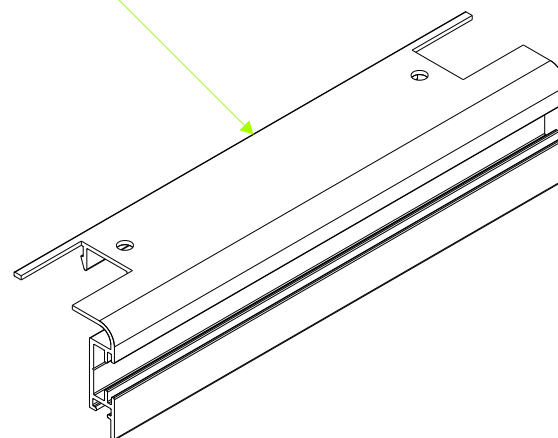
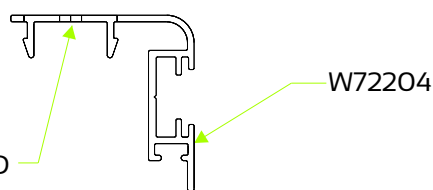
Machining Detail

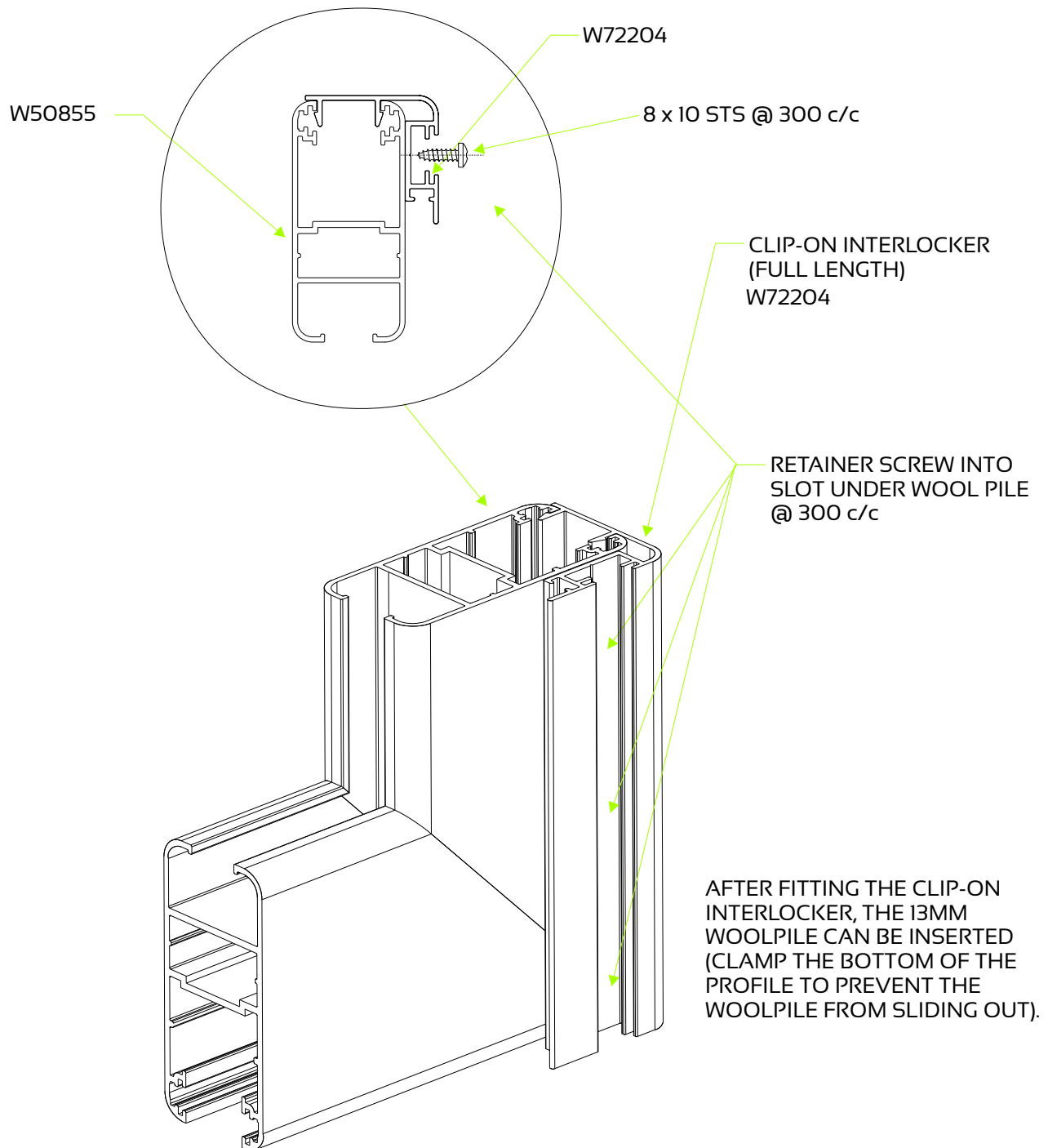
for Clip-On Interlocker

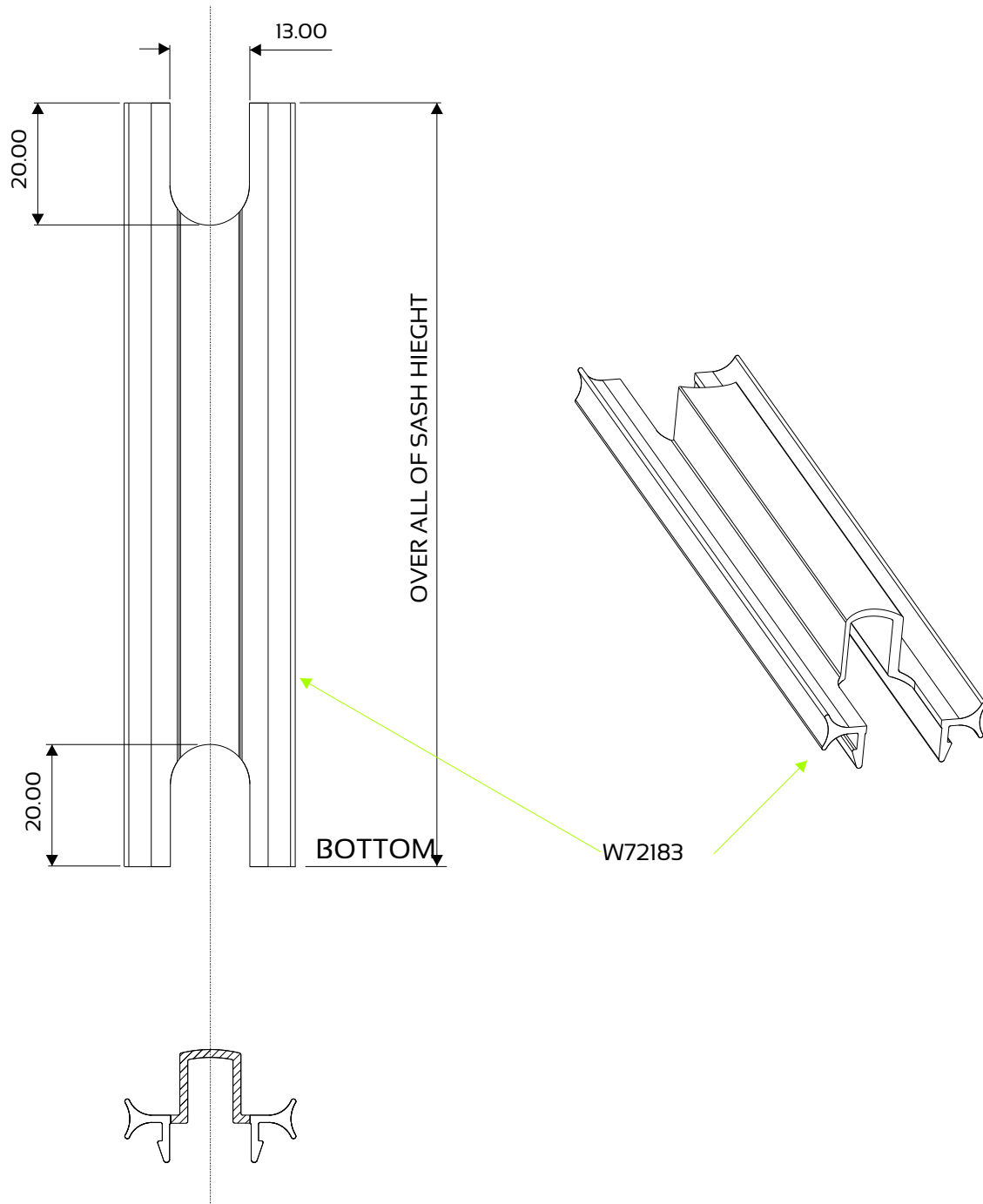


NOTE:
THE INTERLOCKER CAPS CAN ONLY BE
FITTED ONCE THE SASH PANELS HAVE
BEEN INSERTED INTO THE OUTER FRAME.

WEB TO BE PUNCHED
OR ROUTED IF NO
PUNCH TOOL IS BEING
USED.

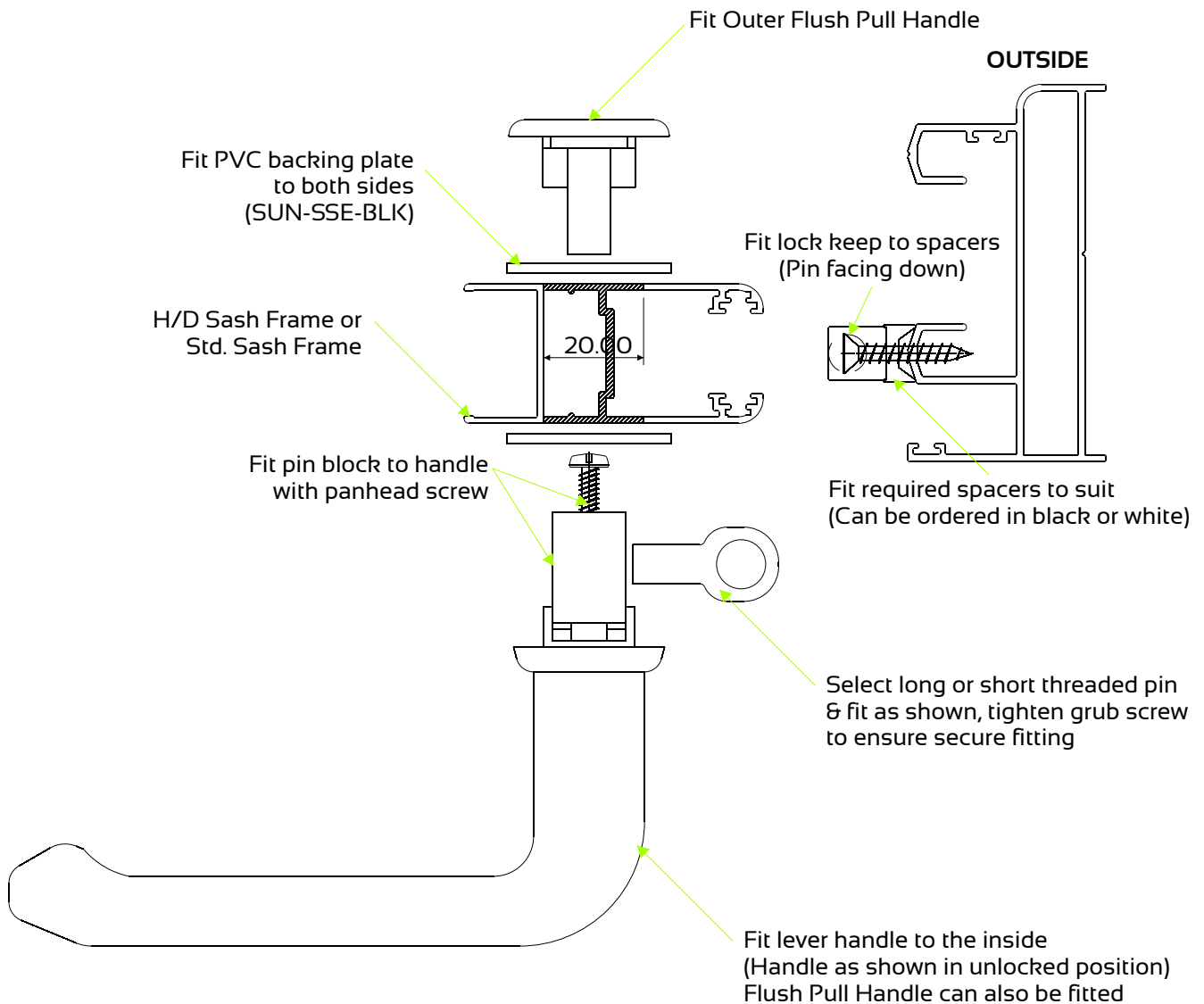


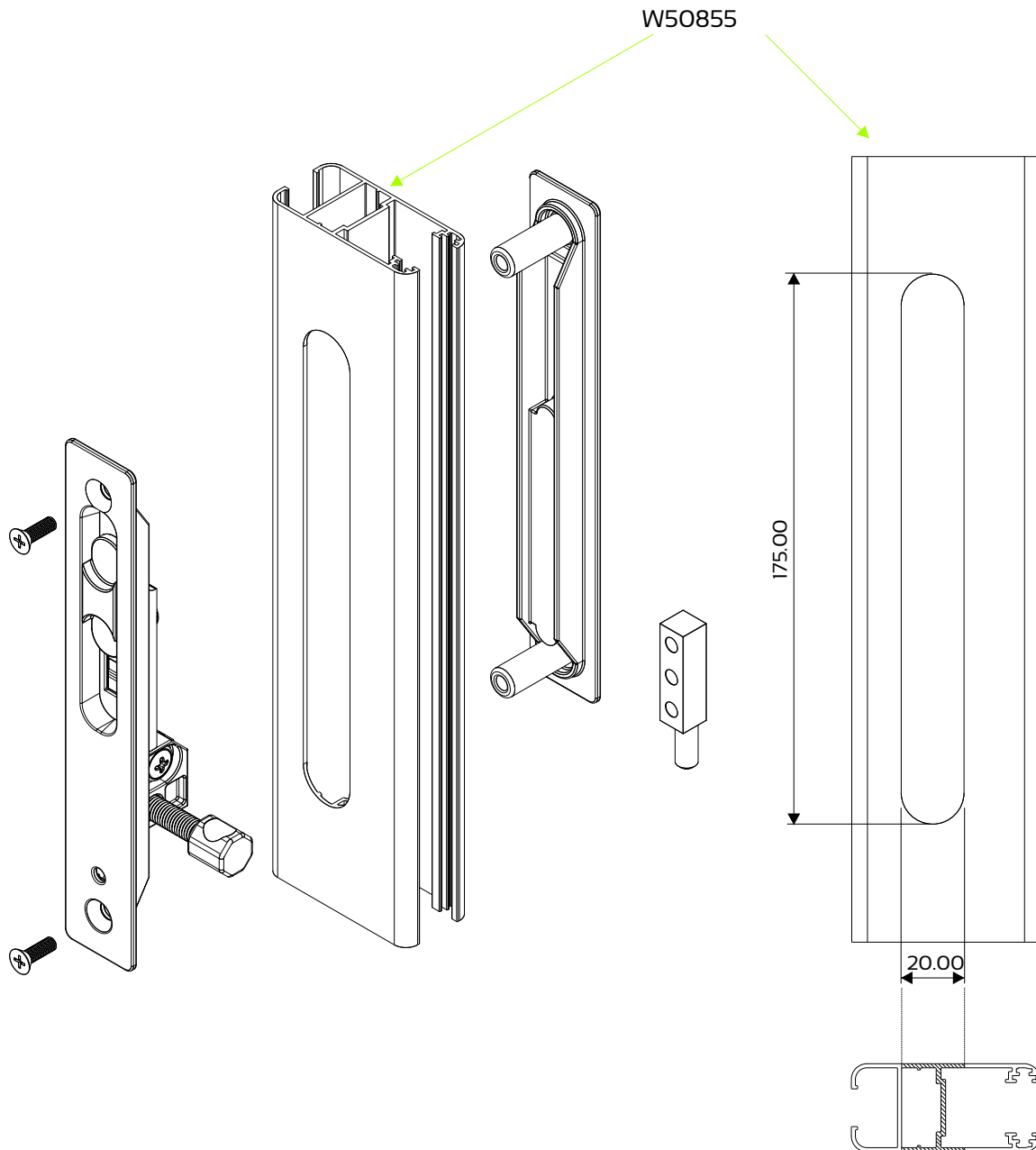




Lock Detail

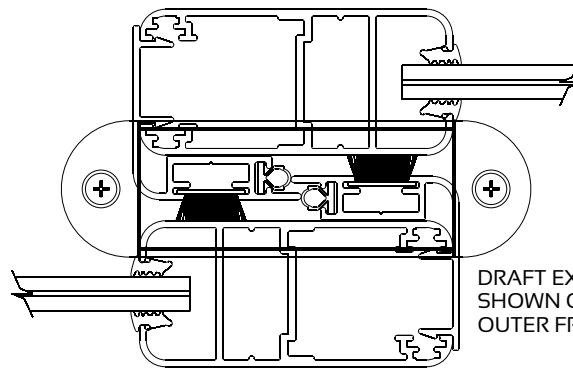
Lever or Flush Pull Handle





Assembly Details

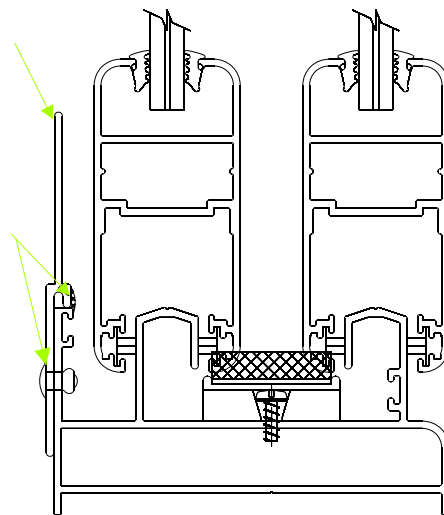
For Outer Frames



DRAFT EXCLUDER TO BE FITTED AS SHOWN ON BOTH THE TOP & BOTTOM OUTER FRAMES.

FOR A2 & A3 REQUIREMENTS
THE SILL EXTENSION
MUST BE FITTED WITH
DIE WI4014

APPLY SILICONE SEALANT

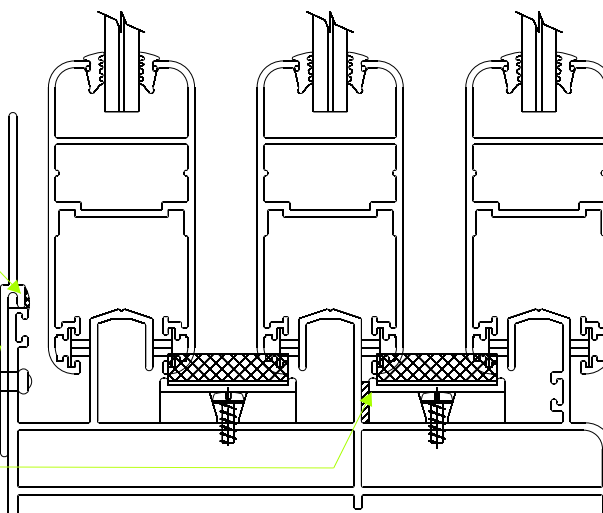


WHEN FITTING THE WOOLPILE ONTO THE DRAFT EXCLUDER, APPLY STRUCTURAL SILICONE TO ENSURE PERMANENT ADHESION. THE DRAFT EXCLUDER CAN ONLY BE FITTED ONCE THE WINDOW PANELS HAVE BEEN INSERTED INTO THE FRAME.

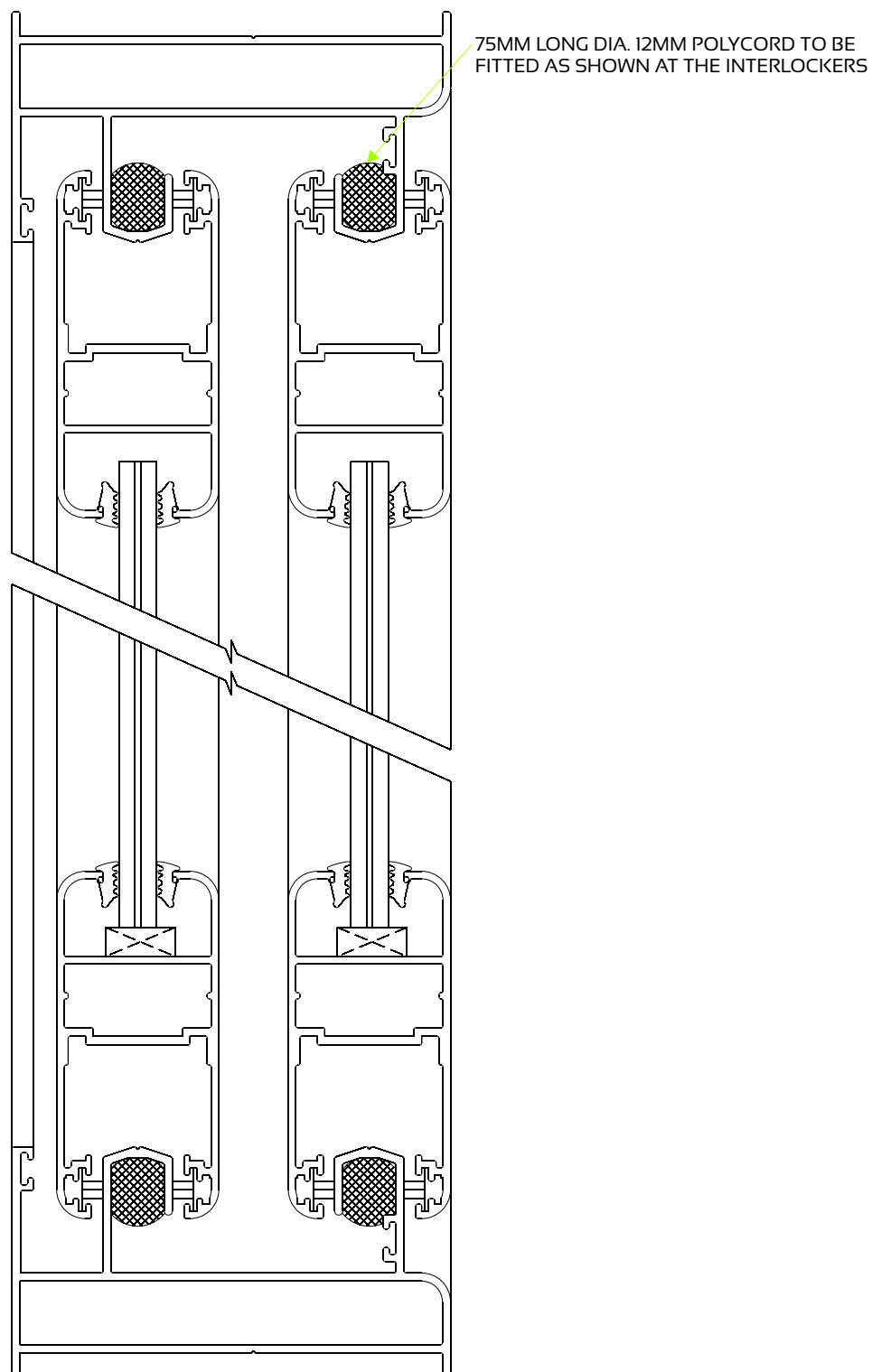
FOR A2 & A3 REQUIREMENTS
THE SILL EXTENSION
MUST BE FITTED WITH
DIE WI4014

APPLY SILICONE SEALANT

SILICONE SEALANT TO BE APPLIED
AS SHOWN WHEN FITTING THE
DRAFT EXCLUDER

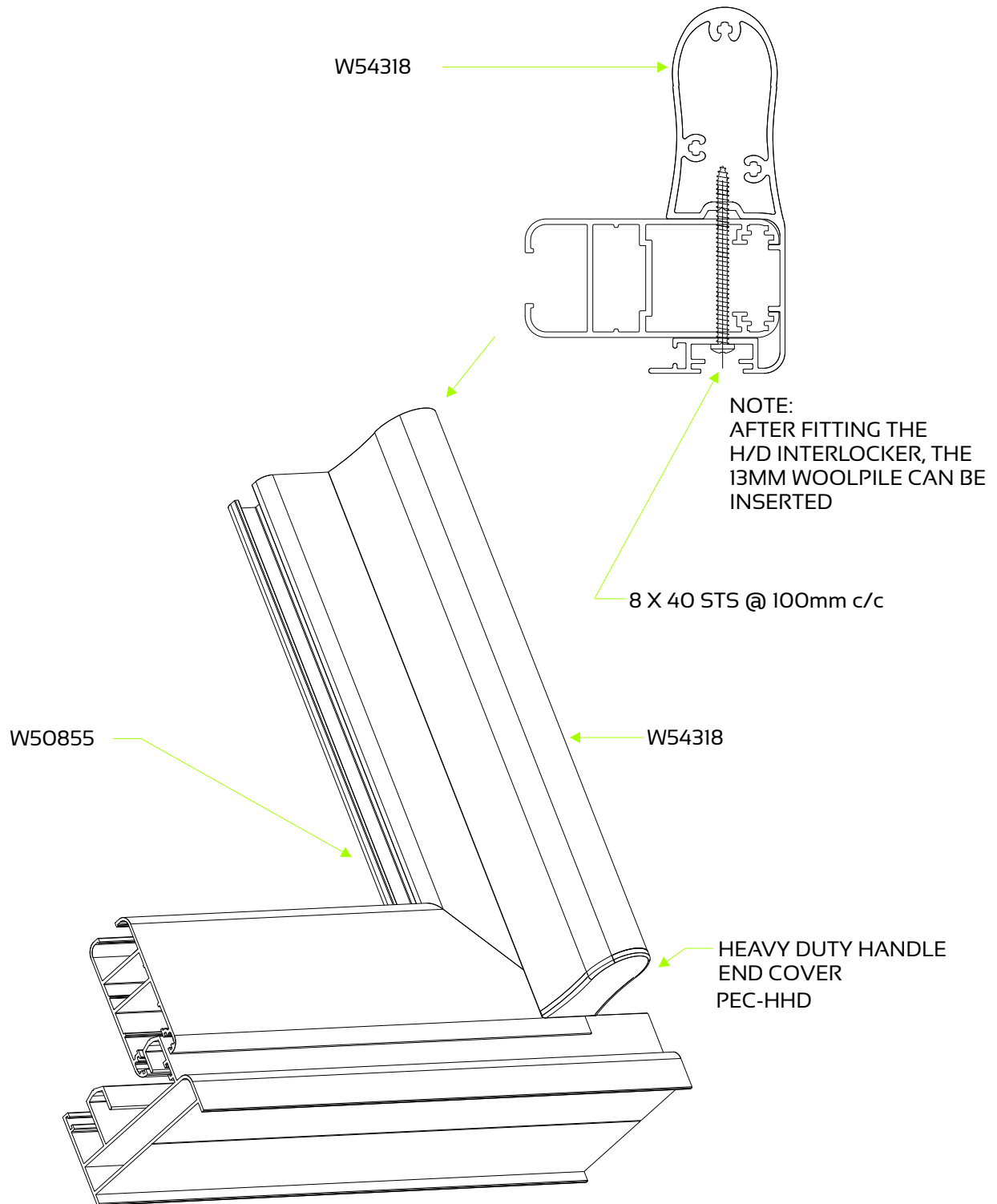


WHEN FITTING THE WOOLPILE ONTO THE DRAFT EXCLUDER, APPLY STRUCTURAL SILICONE TO ENSURE PERMANENT ADHESION. THE DRAFT EXCLUDER CAN ONLY BE FITTED ONCE THE WINDOW PANELS HAVE BEEN INSERTED INTO THE FRAME.

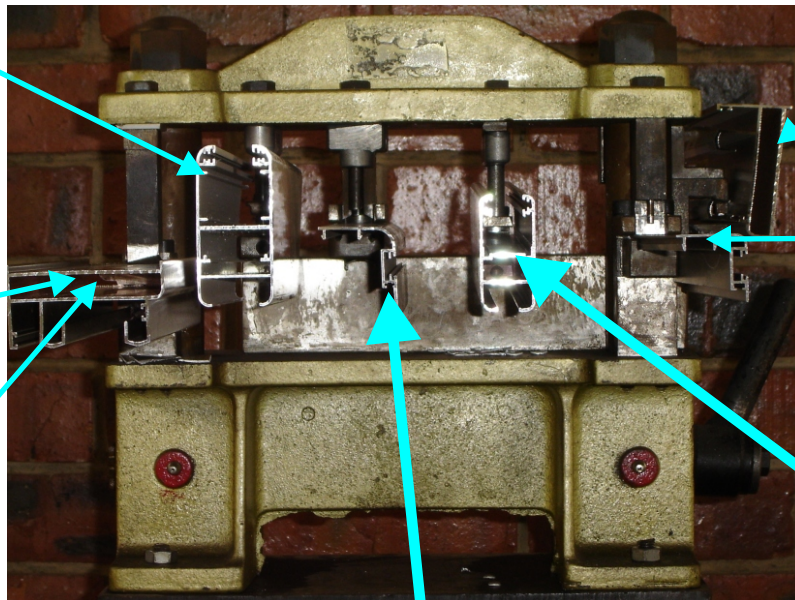


Assembly Detail

Heavy Duty Interlocker

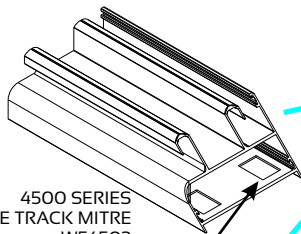


PUNCH TOOL - TLP-P1000



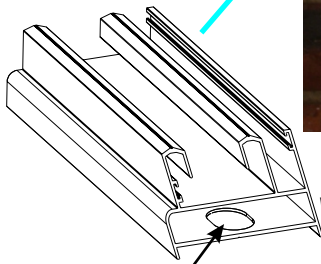
4500 SERIES
MITRE SASH
W54447

WEB TO BE PUNCHED



4500 SERIES
DOUBLE TRACK MITRE
W54503

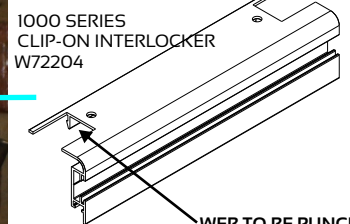
WEB TO BE PUNCHED



1000 SERIES
OUTER FRAME WITH LIP
W54272

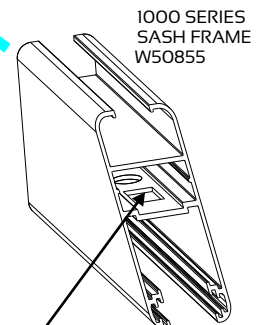
WEB TO BE PUNCHED

DRAIN HOLES TO BE PUNCHED
OUTER FRAME WITH LIP
W54272

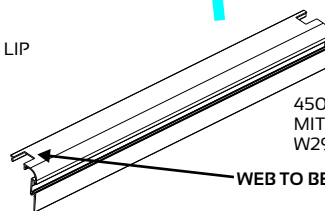


1000 SERIES
CLIP-ON INTERLOCKER
W72204

WEB TO BE PUNCHED



1000 SERIES
SASH FRAME
W50855



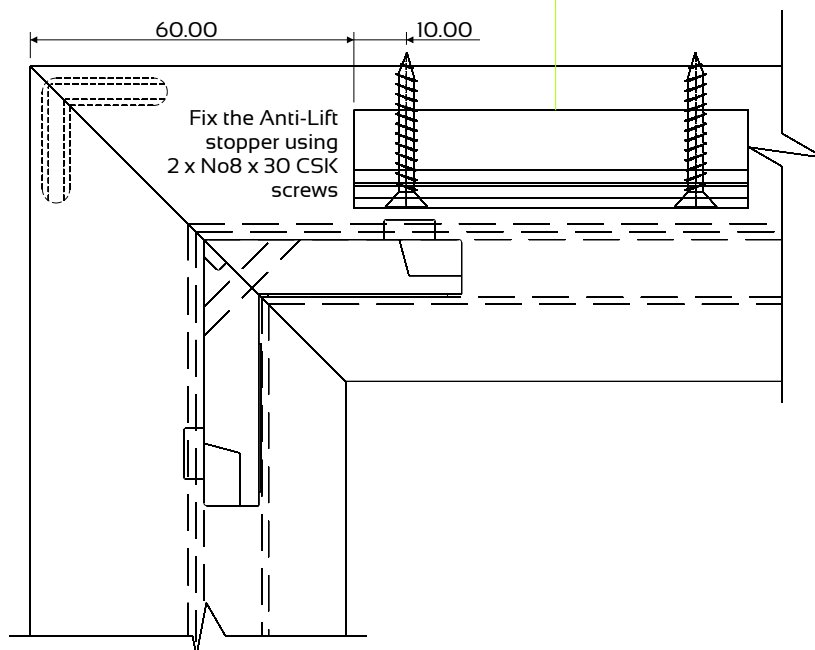
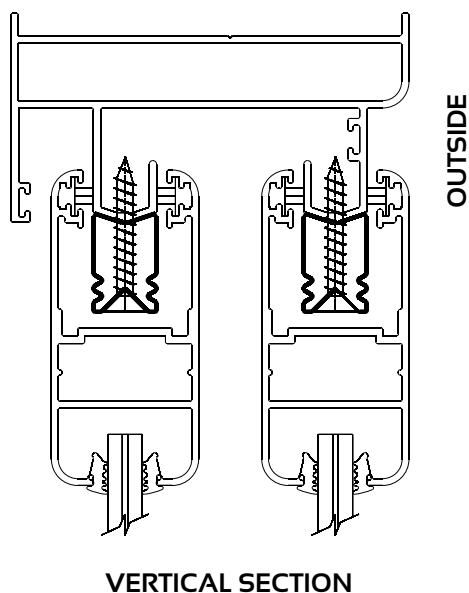
4500 SERIES
MITRE SASH INTERLOCKER
W29715

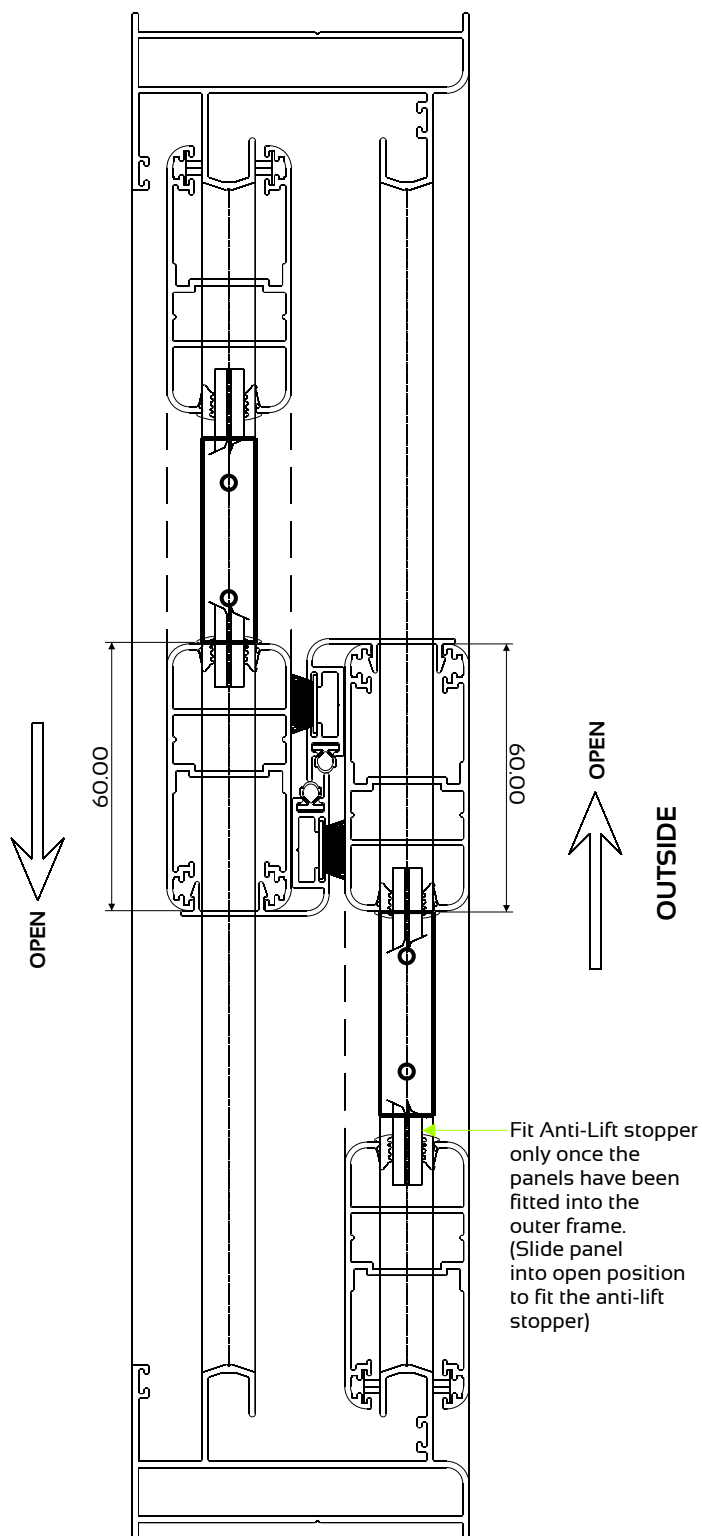
WEB TO BE PUNCHED

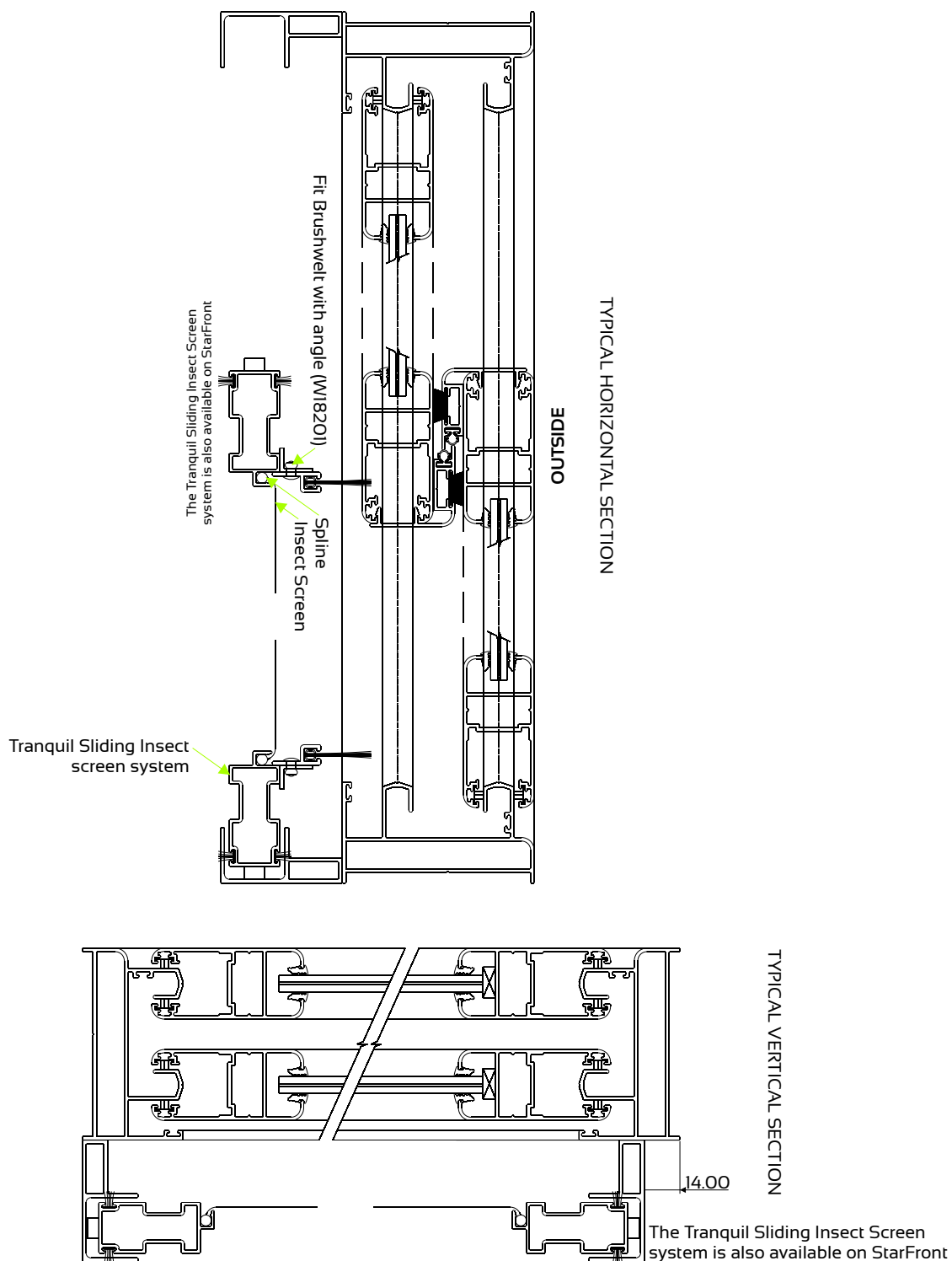
WEB TO BE PUNCHED

SEE HORIZONTAL SECTION FOR POSITION OF
ANTI-LIFTS ON THE HEAD RAIL

Fit Anti-Lift stopper only once the
panels have been fitted into the
outer frame. (Slide panel into open
position to fit the anti-lift stopper)







GLAZING

1. SELECTION OF GLAZING METHODS

1.1 SETTING AND LOCATION BLOCKS

Glass-to-metal contact must be avoided at all times by using setting and location blocks having a hardness of 50° to 90° shore A durometer. Use only blocks made of Neoprene, EPDM, Silicone or other elastomeric material.

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

The position of the setting and location blocks is illustrated in Figure 2.

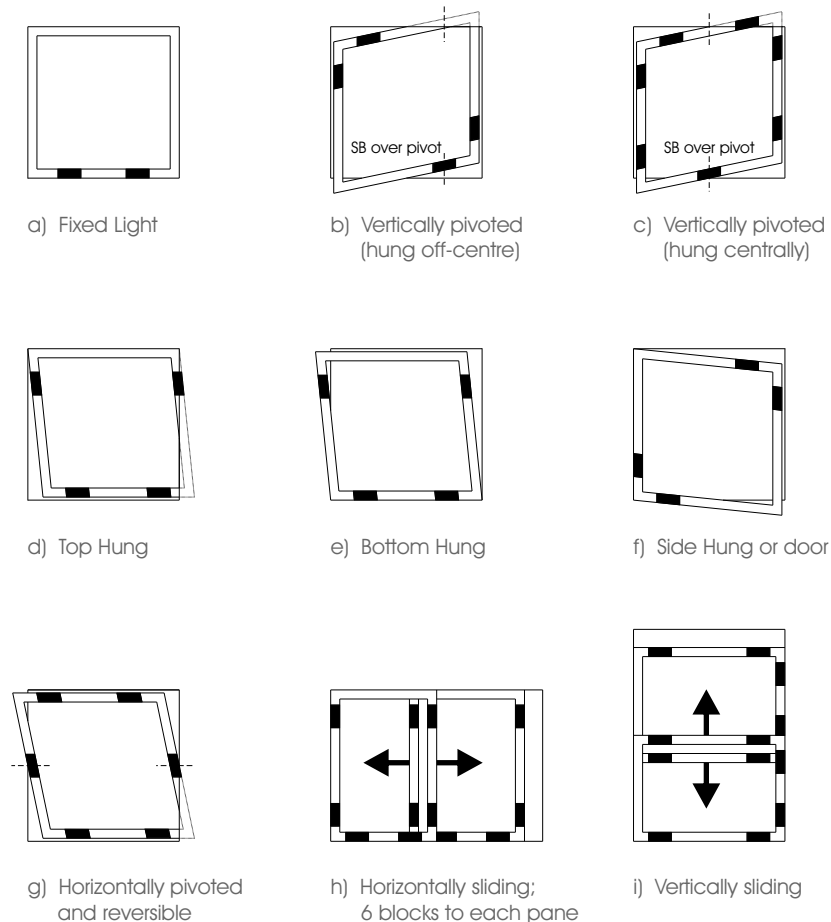


FIGURE 2 - POSITION OF SETTING AND LOCATION BLOCKS