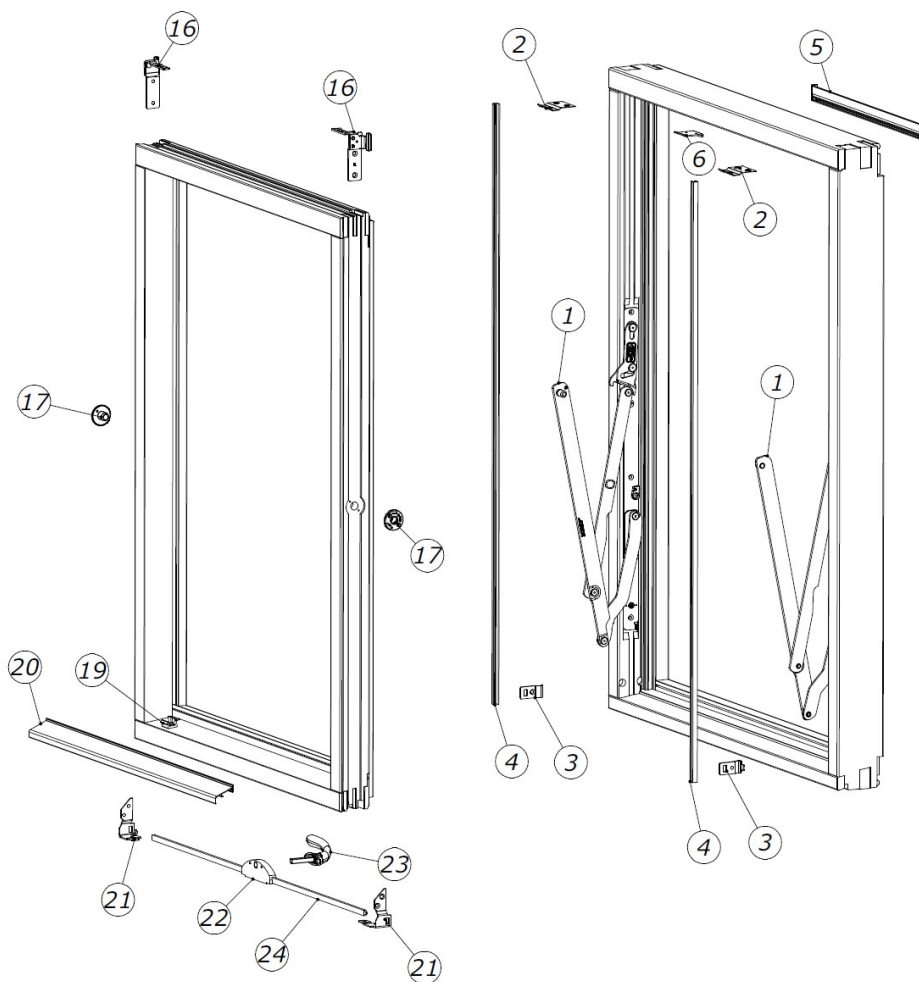


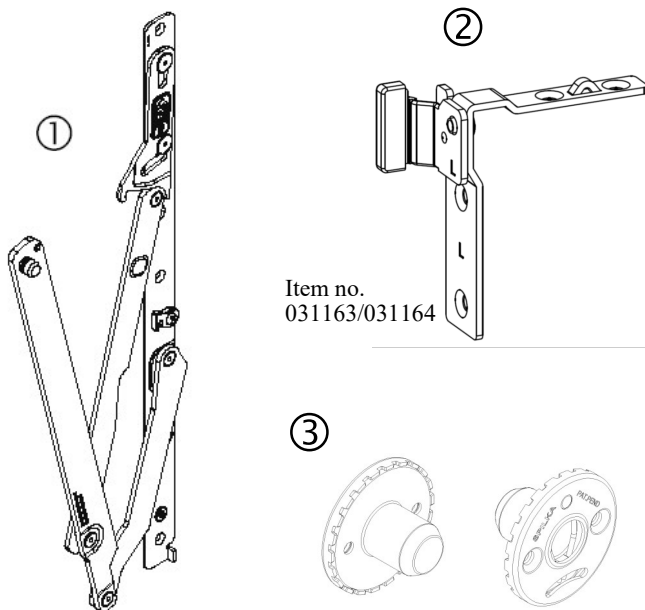
Updated: 25.05.2023



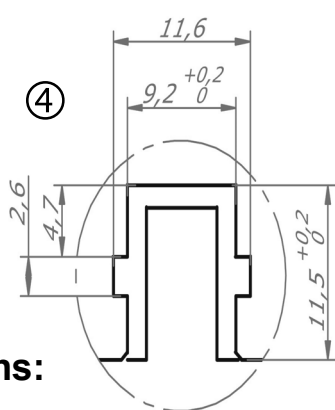
| Item | Components, frame | Item | Components, sash |
|------|----------------------|------|--------------------------------|
| 1 | HINGE | 16 | HEAD SLIDES |
| 2 | END KEEP HEAD | 17 | CENTRE SASH ASSEMBLY |
| 3 | END KEEP | 19 | CLIPS FOR GLAZING BEAD |
| 4 | U-PROFILE | 20 | GLAZING BEAD |
| 5 | SPIILVENT VENTILATOR | 21 | GUIDES |
| 6 | CENTRE SASH KEEPS | 22 | LOCKBOX |
| | | 23 | HANDLES AND ACCESORIES |
| | | 24 | ESPAGNOLETTE RODS |
| | | | CLIPS FOR BARS AND ACCESSORIES |

* Please be aware that product illustration may vary to the physical product due to amendments and development.

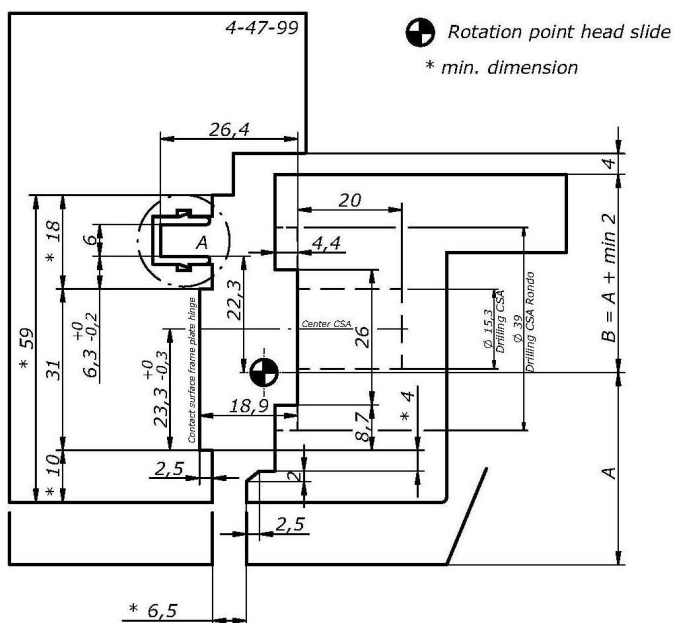
COMPONENTS



Item no.
031163/031164



Critical dimensions:



Hinges ①

There are 6 hinge sizes (A1-A6), depending on the window height. The hinges are fixed by screws into the frame jambs. All sizes have a safety catch and sizes A3-A6 also include a device to prevent the sash blowing closed. Spilka also offers two additional sizes in HD (heavy duty) that allows a higher weight, A5 and A6.

Head slides ②

These components couple the sash to the frame. It is important that the head slide's rotation point is as far out as possible so the sash does not foul the weather-strip when reversed. Head slides is presented in illustration 2.

Rondo Centre sash assemblies ③

These fittings has a stainless top cover and attach the hinge to the sash.

U-profile ④

PP (polypropylene) deformable profile supplied on 500 m rolls. Drawing 4 shows channel required and profile dimensions.

Profiles

Hinges are fixed in a groove in the inside of the frame jambs, to the outside of the u-profile channel. This 'u-channel' is 11,5 mm deep and 9,2 mm wide.

To allow the sash to reverse a groove on the outside of the sash jambs is used to correctly position the head slides.

The inner top edge of the sash is rounded (with a radius or chamfer) to allow the sash to easily slide past the weather-strip.

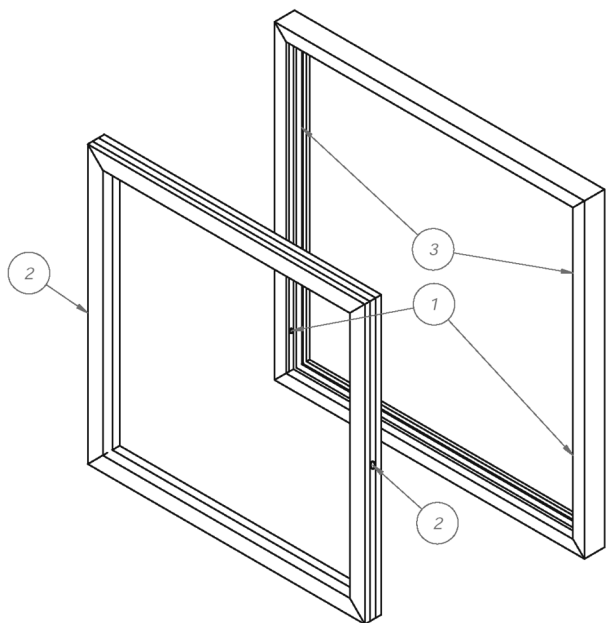
NB! Top and bottom profiles can be different to the side profiles

The outer gap at the sides between sash and frame should be a min 6,5 mm. We recommend a gap of 1-4 mm at the top and between 4-6 mm at the bottom.

DIMENSIONS AND WEIGHTS

Min window heights: ca 427 mm outward sash
 Max window heights: 1588 mm outward sash
 Max frame weight: A1 and A2 - 40 kg
 A3 and A4 - 50 kg
 A5 and A6 - 55 kg
 HD (heavy duty) A5 and A6 - 80 kg

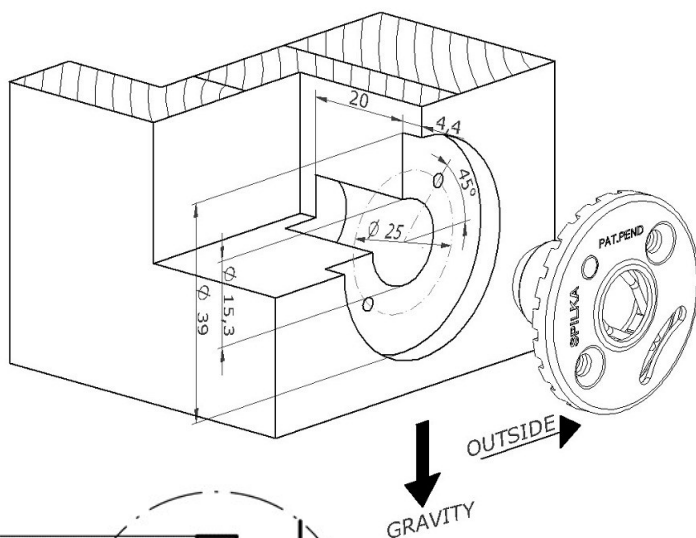
DRILLING AND ROUTING



1. Hole $\varnothing 12,3$ mm for frame plate adjustment point.
2. Hole $\varnothing 15,3 / \varnothing 39$ mm for Rondo centre sash assembly.
3. Grove for head slide.

Frame plate

Pre-drill a hole of $\varnothing 12,3$ mm for frame plate adjustment point. After positioning the hinge at the correct height it can be adjusted +/- 1,0 mm.

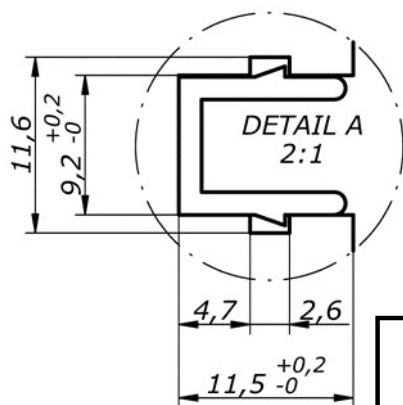


Centre sash assemblies

The starting point for positioning the hinge, is to centre the pivot point 10 mm over the centre of the sash. This will ensure any espagnolette end keeps will not be damaged by the head slide and the sash will remain within the overall window height when reversed.

Positioning may vary according to profile dimensions as will the top and bottom gaps between the sash and frame. Therefore specific calculation should be made for each profile.

Drill holes are shown on the drawing.



| | | WINDOW SIZES AND RELEVANT HINGES | | | | | |
|--------------|------|----------------------------------|-----|-----|------|------|------|
| | | A1 | A2 | A3 | A4 | A5 | A6 |
| H min | [mm] | 427 | 531 | 681 | 861 | 1091 | 1331 |
| H max | [mm] | 530 | 680 | 860 | 1090 | 1330 | 1588 |

H = overall frame height.
Measurements can vary according to profile dimensions

Following information applies for the Opus serie:

Spilka product are tested according to pr EN 13126 – 11 Static load test.

The window manufacturers is responsible for the frame, sash and the fastners (screws and/or blind rivets) with respect to strength and has to consider if the window system is strong enough for the relevant load that will occur.

Mullion:

Note! Window in combination (opening window) devided with mullion, can not be used when the sash weight is over 55 kg.

Window in combination fixed and opening window (with sash weight over 55 kg) devided with mullion, the strength of the mullion and frame be considered by the window manufacturer.

Hinge versions va sash weight:

Max frame weight: A1 and A2 - 40 kg

A3 and A4 - 50 kg

A5 and A6 - 55 kg

HD (heavy duty) A5 and A6 55 kg - 80 kg

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