

**150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED**



TECHNICAL MANUAL

**150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED**

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150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED



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150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

SPECIFICATION

FRAME DIMENSIONS

- 150mm x 50mm

MAX PERFORMANCE

- Serviceable Pressure: +/-3000Pa
- Ultimate Pressure: +/-6000Pa
- Water Penetration: 600Pa Water

MAXIMUM SIZES

- Max mullion height: 4350
- Max mullion centres width: 2200

Refer wind load charts for sizing and pressures.

For sizes and pressures outside of the standard load charts, please contact Rapid Aluminium for assistance

GLAZING

- Double glazed: 18mm-28mm

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG166 / DG167 STANDARD SPLIT MULLION

SECTION PROPERTIES

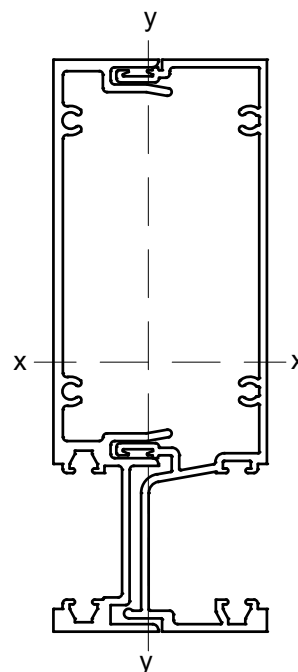
$I_{xx}: 3616 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state I/250

U = Ultimate limit state



Mullion Height	Maximum Design Pressure (Pa)							
4350	S	950	800	690	610	550	510	
	U	2080	1750	1510	1340	1200	1100	
4200	S	1060	890	770	690	620	570	530
	U	2240	1880	1630	1440	1300	1180	1090
4050	S	1190	1000	870	770	690	640	590
	U	2410	2020	1750	1550	1400	1280	1190
3900	S	1330	1120	970	870	780	720	670
	U	2600	2190	1900	1680	1520	1390	1290
3750	S	1500	1270	1100	980	890	820	760
	U	2820	2370	2060	1830	1650	1520	1410
3600	S	1700	1440	1250	1120	1010	930	870
	U	3070	2580	2250	2000	1810	1660	1550
3450	S	1940	1640	1430	1280	1160	1080	1010
	U	3350	2820	2460	2190	1990	1830	1710
3300	S	2220	1880	1650	1470	1340	1250	1170
	U	3670	3100	2700	2410	2190	2020	1900
3150	S	2570	2180	1910	1710	1570	1460	1370
	U	4040	3420	2980	2670	2430	2250	2120
3000	S	2990	2540	2230	2000	1840	1720	1630
	U	4470	3790	3310	2970	2720	2520	2380
Mullion Ctrs		1000	1200	1400	1600	1800	2000	2200

This table is based on theoretical section properties

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG167 / DG168 HEAVY DUTY SPLIT MULLION

SECTION PROPERTIES

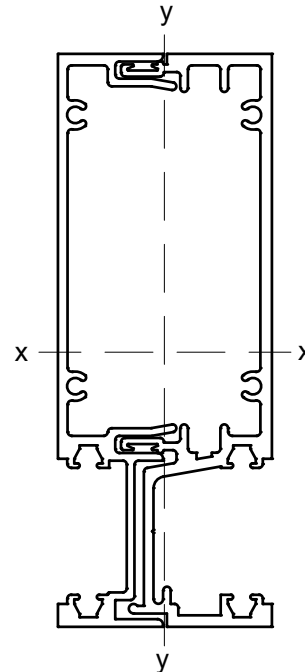
$I_{xx}: 4278 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state I/250

U = Ultimate limit state



Mullion Height	Maximum Design Pressure (Pa)							
4350	S	1130	950	820	730	660	600	560
	U	2570	2150	1860	1650	1480	1350	1250
4200	S	1260	1060	920	810	730	670	620
	U	2760	2320	2000	1770	1600	1460	1350
4050	S	1400	1180	1030	910	820	750	700
	U	2970	2500	2160	1920	1730	1580	1460
3900	S	1580	1330	1150	1030	930	850	790
	U	3210	2700	2340	2080	1870	1720	1590
3750	S	1780	1500	1300	1160	1050	970	900
	U	3480	2930	2540	2260	2040	1870	1740
3600	S	2010	1700	1480	1320	1200	1110	1030
	U	3780	3190	2770	2460	2230	2050	1910
3450	S	2300	1940	1690	1510	1380	1270	1190
	U	4130	3480	3030	2700	2450	2260	2110
3300	S	2630	2230	1950	1740	1590	1480	1390
	U	4520	3820	3330	2970	2700	2490	2340
3150	S	3000	2580	2260	2030	1850	1720	1630
	U	4980	4210	3680	3290	3000	2780	2610
3000	S	3000	3000	2640	2370	2180	2030	1930
	U	5510	4670	4080	3660	3350	3110	2940
Mullion Ctrs		1000	1200	1400	1600	1800	2000	2200

This table is based on theoretical section properties

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG164 JAMB / MULLION

SECTION PROPERTIES

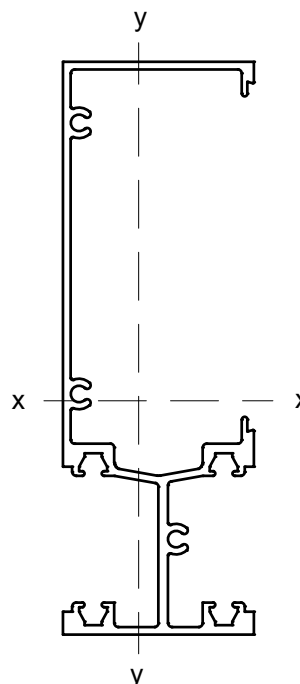
$I_{xx}: 2338 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state $l/250$

U = Ultimate limit state



Mullion Height	Maximum Design Pressure (Pa)							
4050	S	770	640	560				
	U	1440	1210	1050				
3900	S	860	720	630	560			
	U	1560	1310	1130	1010			
3750	S	970	820	710	630	570	530	
	U	1690	1420	1230	1090	990	910	
3600	S	1100	930	810	720	650	600	560
	U	1830	1540	1340	1190	1080	990	920
3450	S	1250	1060	920	820	750	690	650
	U	2000	1690	1470	1310	1190	1090	1020
3300	S	1440	1220	1060	950	870	800	760
	U	2190	1850	1610	1440	1310	1210	1130
3150	S	1660	1410	1230	1100	1010	940	890
	U	2420	2040	1780	1590	1450	1350	1260
3000	S	1930	1640	1440	1290	1190	1110	1050
	U	2670	2270	1980	1780	1620	1510	1420
2850	S	2260	1930	1700	1530	1410	1320	1260
	U	2970	2530	2210	1990	1830	1700	1620
2700	S	2680	2290	2020	1830	1690	1590	1530
	U	3330	2840	2490	2250	2070	1940	1850
Mullion Ctrs		1000	1200	1400	1600	1800	2000	2200

This table is based on theoretical section properties

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG171 TRANSOM

SECTION PROPERTIES

$I_{xx}: 2070 \times 10^3 \text{ mm}^4$

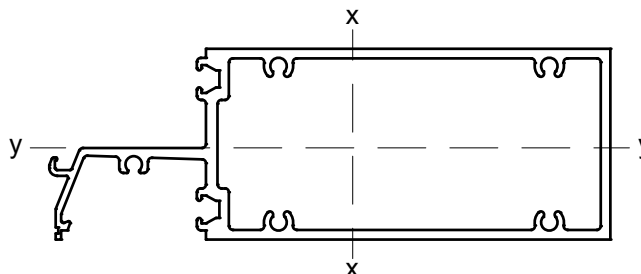
$I_{yy}: 397 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state 1/250

U = Ultimate limit state



Max weight is limited by 4mm max deflection with
setting blocks at 1/8 points

Transom Ctrs	Maximum Design Pressure (Pa)							
1700	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	5900	4730	3900
1600	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	5980	4840	4010
1500	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	4990	4160
1400	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5180	4340
1300	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5420	4570
1200	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5730	4840
1100	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5180
1000	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5600
900	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
800	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
Max Weight		80	80	80	80	80	80	80
Transom length		1200	1350	1500	1650	1800	1950	2100

This table is based on theoretical section properties

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG162 TRANSOM - BEAD GLAZED

SECTION PROPERTIES

$I_{xx}: 2476 \times 10^3 \text{ mm}^4$

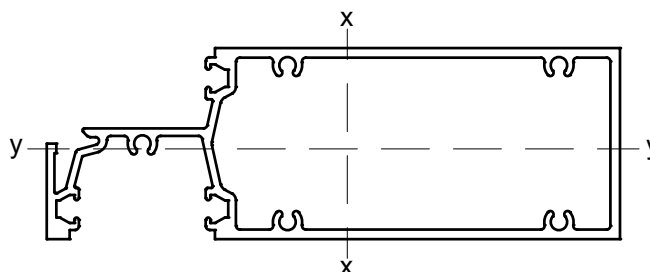
$I_{yy}: 408 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state 1/250

U = Ultimate limit state



Max weight is limited by 4mm max deflection with
setting blocks at 1/8 points

Transom Ctrs	Maximum Design Pressure (Pa)							
1700	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5740	4730
1600	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5870	4870
1500	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5040
1400	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5270
1300	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5540
1200	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5870
1100	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
1000	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
900	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
800	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
Max Weight		80	80	80	80	80	80	80
Transom length		1200	1300	1400	1500	1600	1700	1800

This table is based on theoretical section properties

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG169 INTERNAL GLAZED TRANSOM

SECTION PROPERTIES

$I_{xx}: 2689 \times 10^3 \text{ mm}^4$

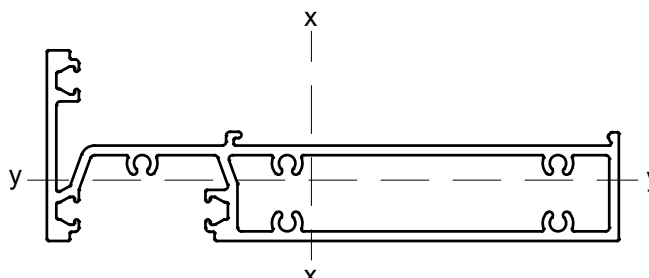
$I_{yy}: 166 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state 1/250

U = Ultimate limit state



Max weight is limited by 4mm max deflection with
setting blocks at 1/8 points

Transom Ctrs	Maximum Design Pressure (Pa)							
1700	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5010
1600	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5150
1500	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5340
1400	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5580
1300	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5870
1200	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
1100	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
1000	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
900	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
800	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	6000
Max Weight		80	80	80	80	80	80	80
Transom length		1200	1300	1400	1500	1600	1700	1800

This table is based on theoretical section properties

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

LOAD TABLE - DG162 SILL / TRANSOM

SECTION PROPERTIES

$I_{xx}: 1538 \times 10^3 \text{ mm}^4$

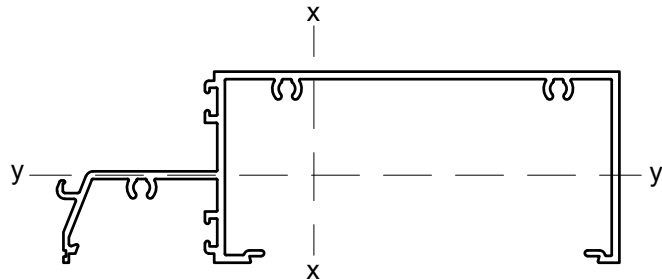
$I_{yy}: 191 \times 10^3 \text{ mm}^4$

Alloy: 6060 T5

Max Stress 110 Mpa

S = Serviceability limit state $l/250$

U = Ultimate limit state

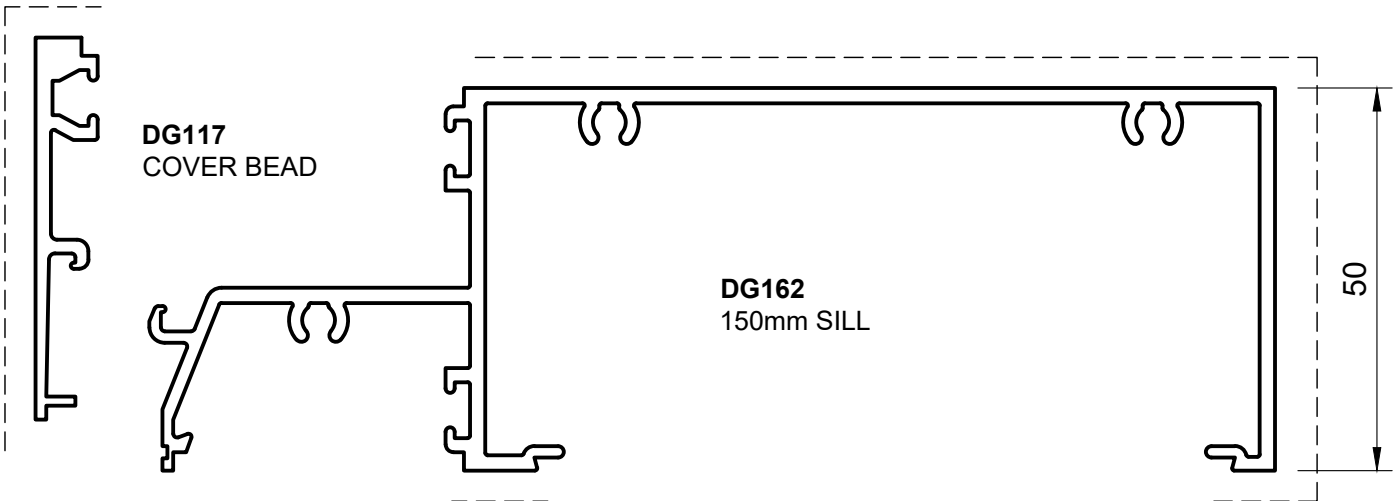
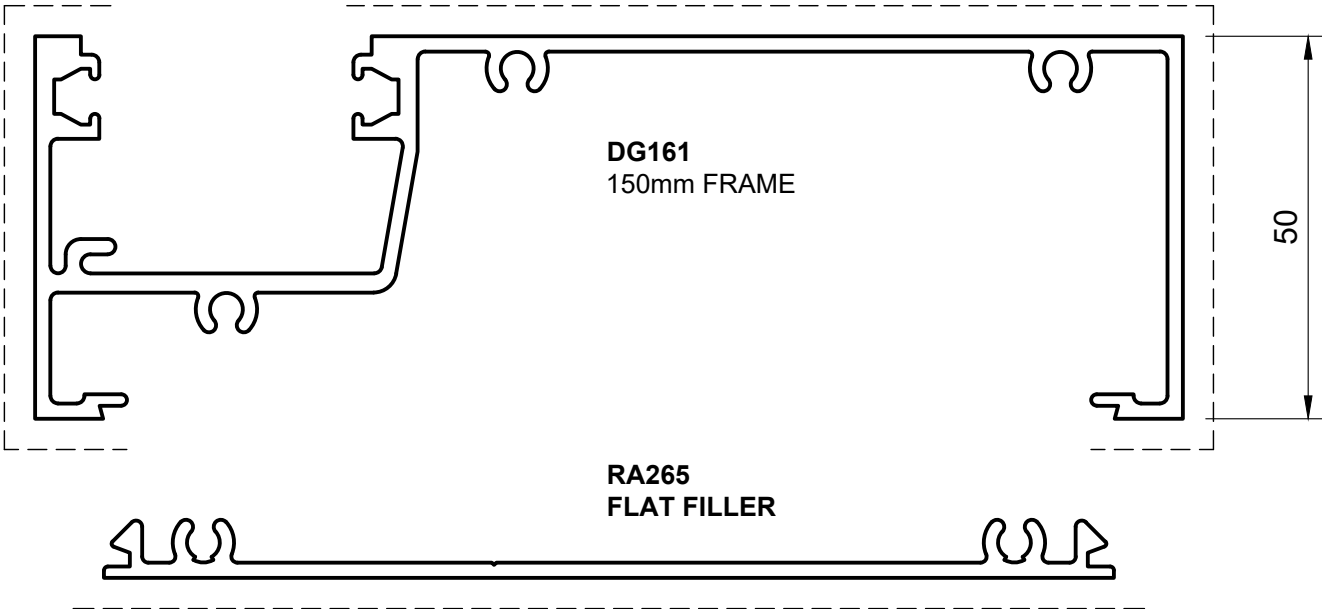


Max weight is limited by 4mm max deflection with
setting blocks at 1/8 points

Transom Ctrs	Maximum Design Pressure (Pa)							
1700	S	3000	3000	3000	3000	3000	3000	2760
	U	6000	6000	6000	6000	4700	3760	3100
1600	S	3000	3000	3000	3000	3000	3000	2830
	U	6000	6000	6000	6000	4760	3850	3190
1500	S	3000	3000	3000	3000	3000	3000	2930
	U	6000	6000	6000	6000	4870	3970	3310
1400	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	5020	4120	3450
1300	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	5220	4320	3630
1200	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	5490	4560	3850
1100	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	5820	4860	4120
1000	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5240	4460
900	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	5720	4880
800	S	3000	3000	3000	3000	3000	3000	3000
	U	6000	6000	6000	6000	6000	6000	5410
Max Weight		80	80	80	80	80	80	80
Transom length		1200	1350	1500	1650	1800	1950	2100

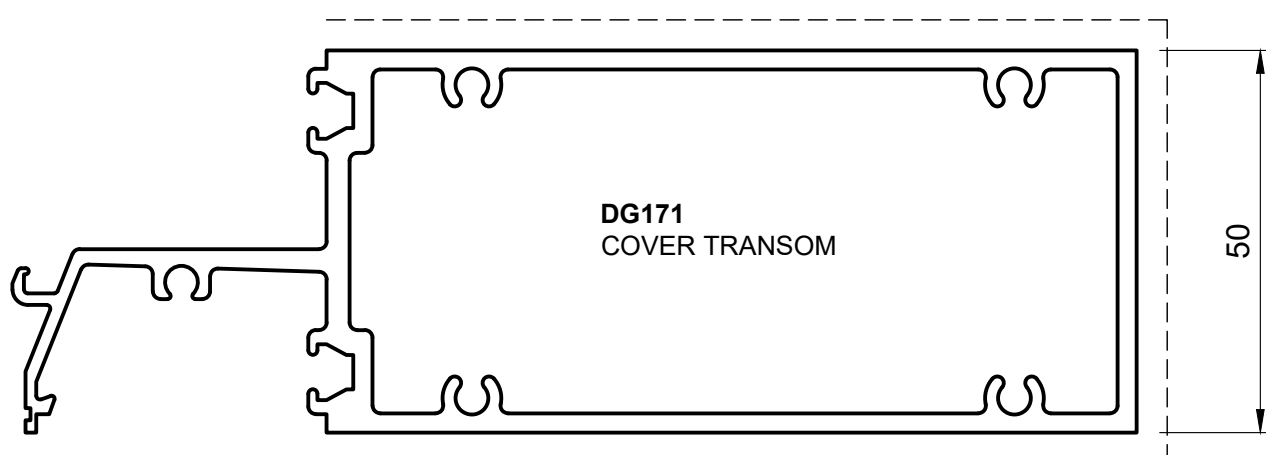
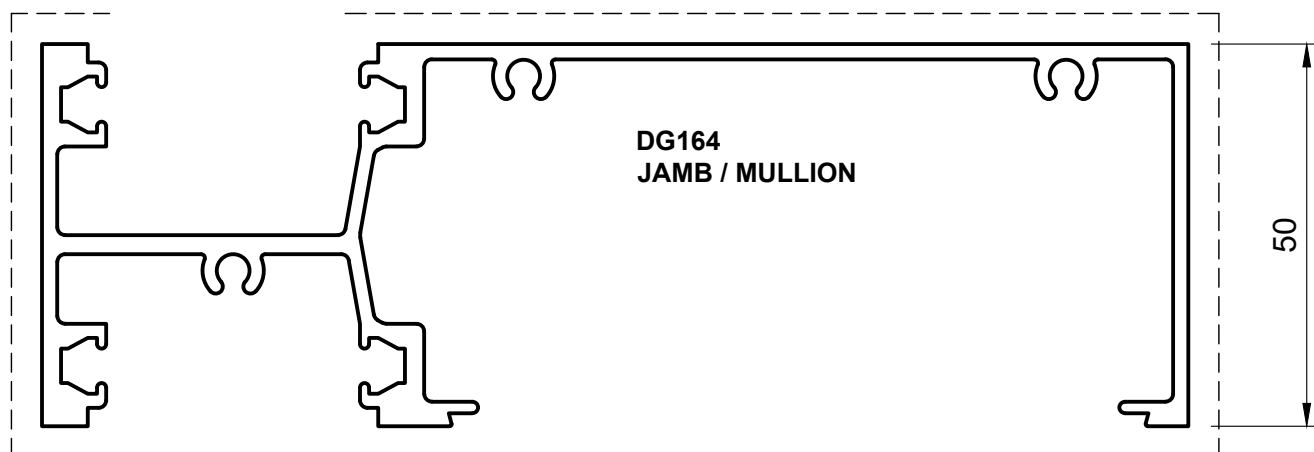
This table is based on theoretical section properties

150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
EXTRUSION PROFILES



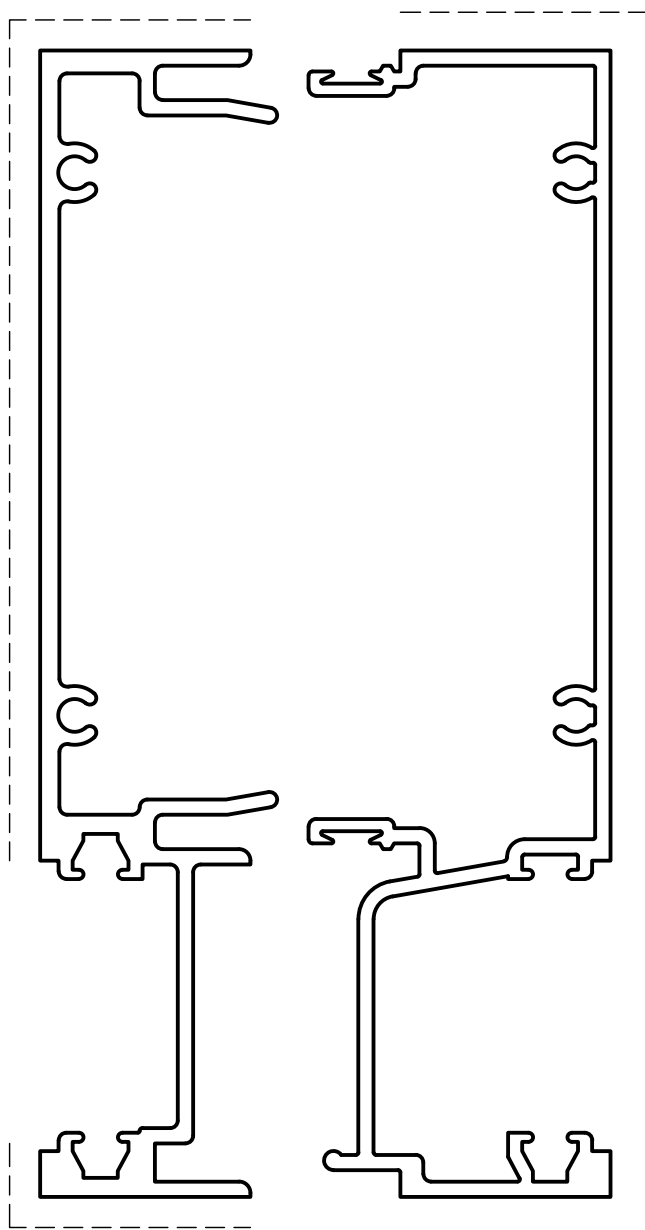
150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

EXTRUSION PROFILES



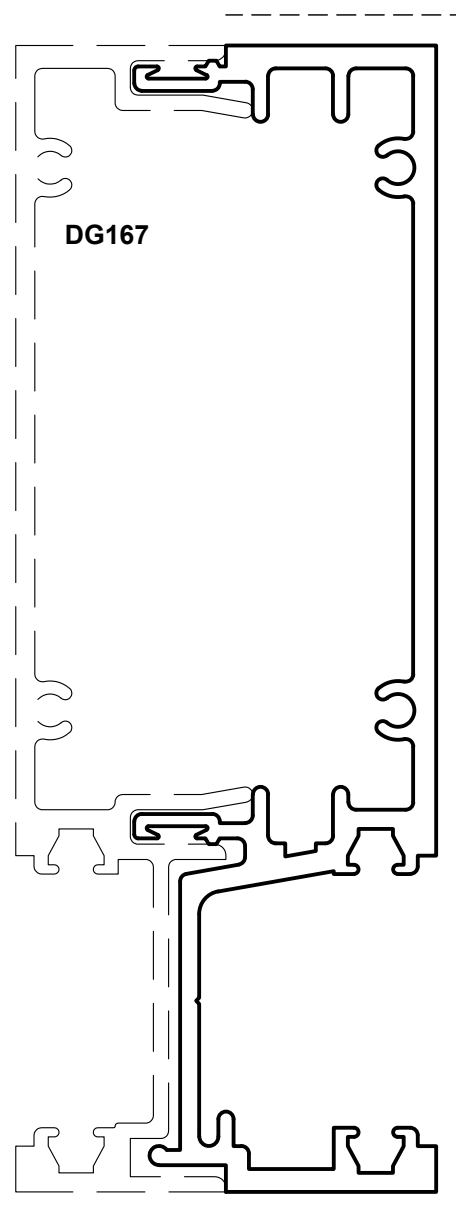
150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

EXTRUSION PROFILES



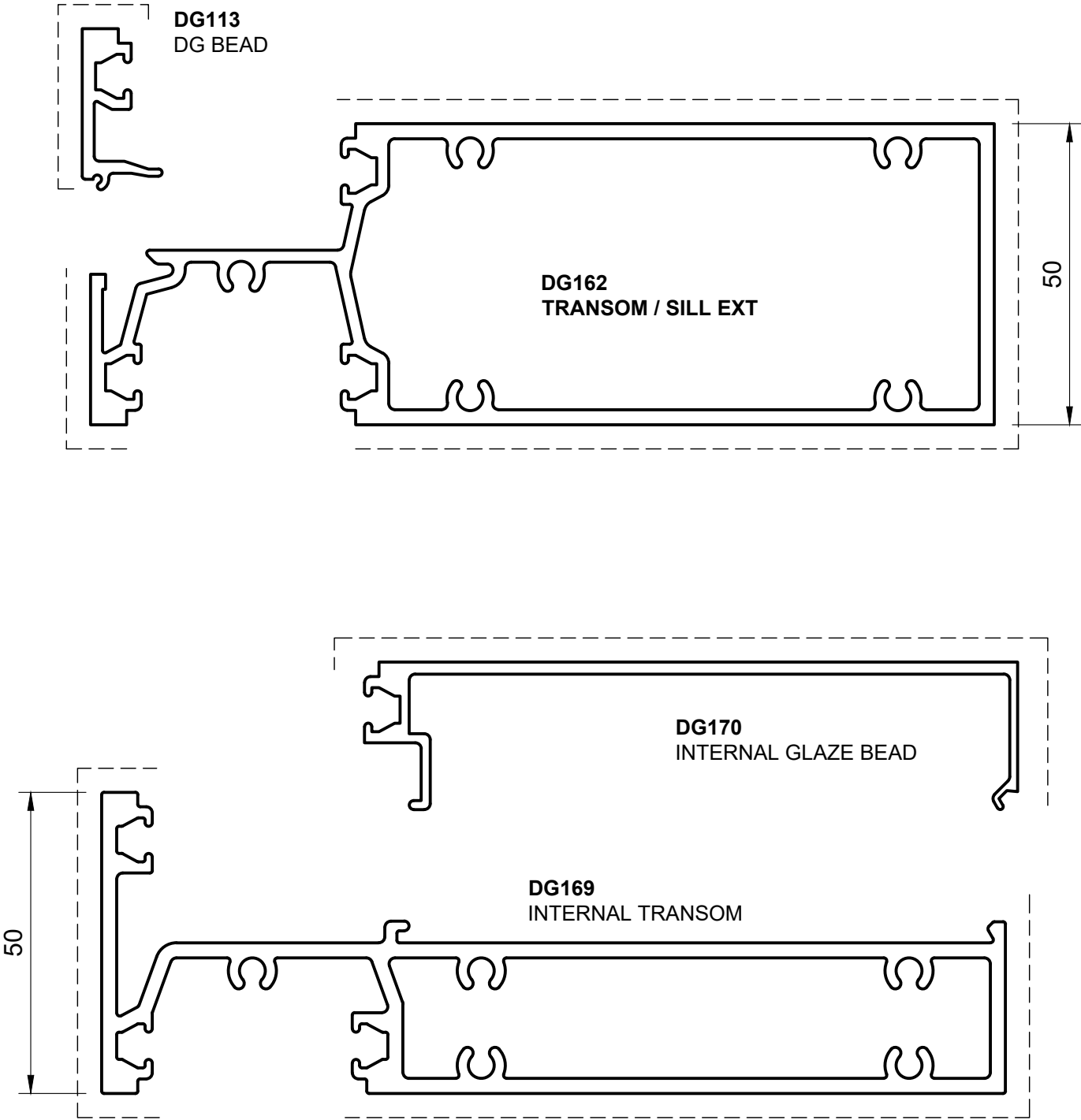
DG167
FEMALE SPLIT
MULLION

DG166
MALE STD SPLIT
MULLION

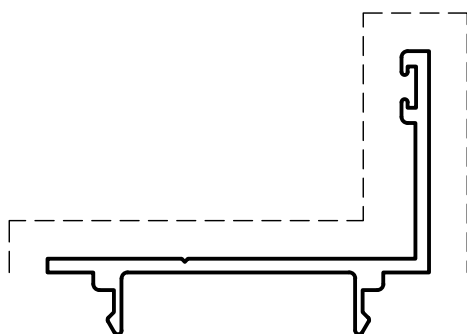


DG168
HEAVY DUTY MALE
SPLIT MULLION

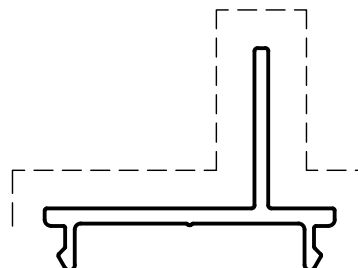
150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
EXTRUSION PROFILES



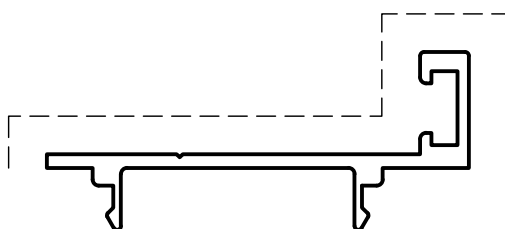
150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED EXTRUSION PROFILES



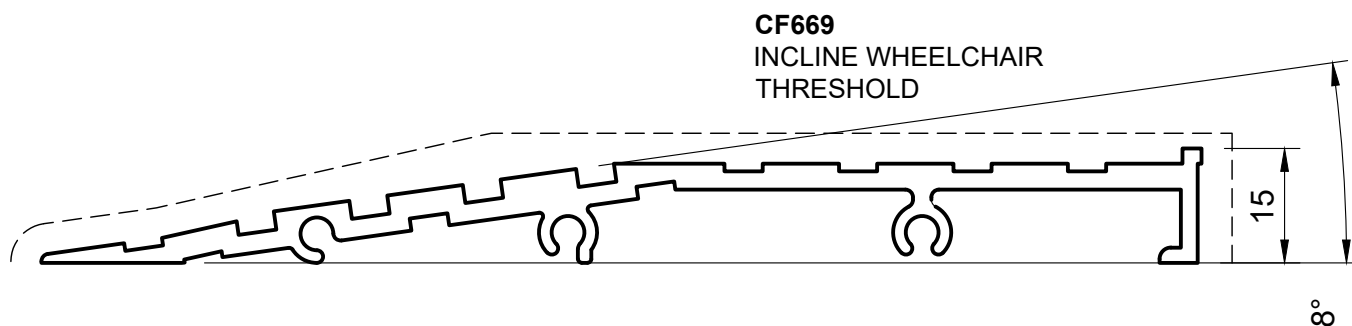
DG156
DG 50mm SASH STOP



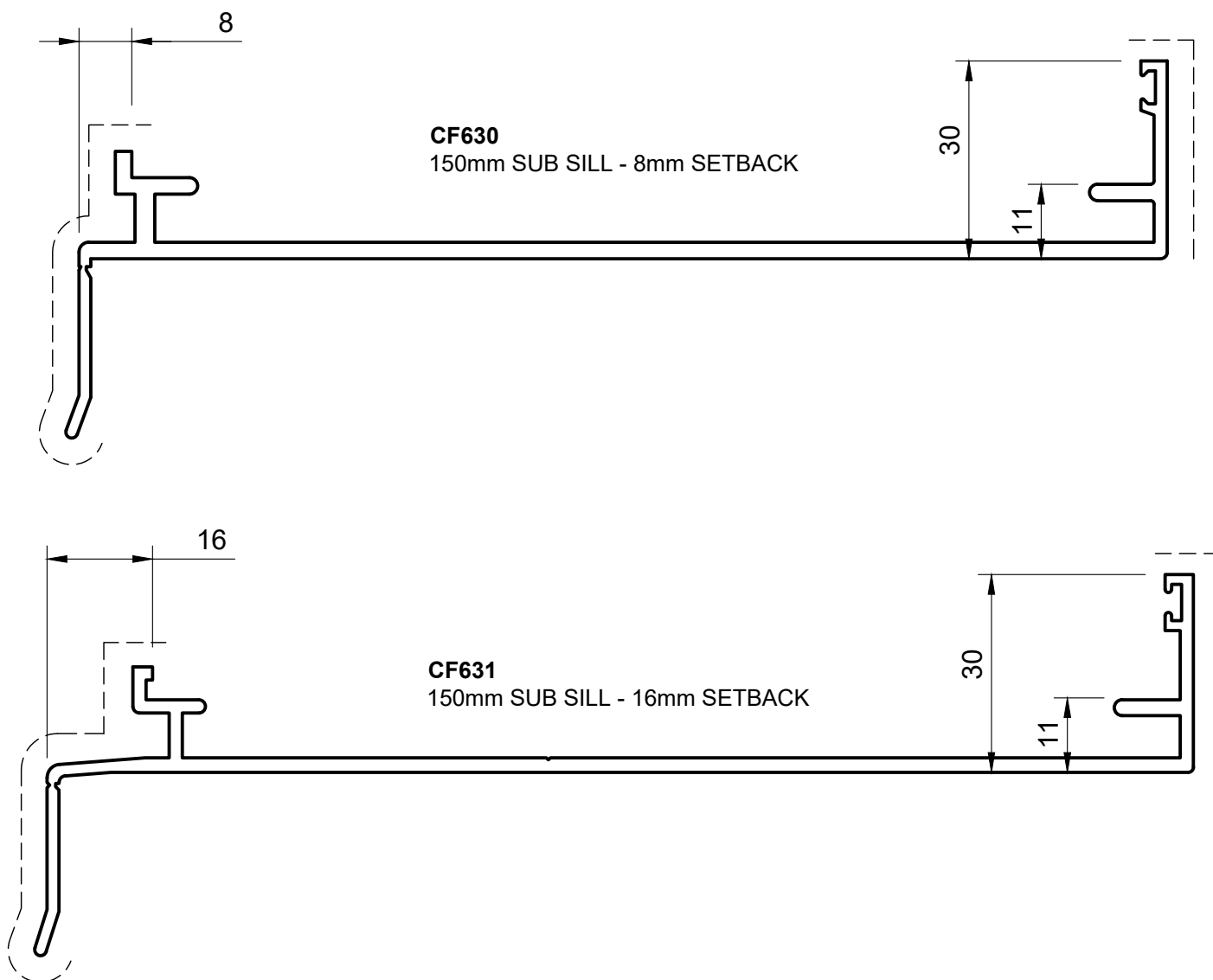
DG116
DG 35mm SASH STOP



DG107
DG 45mm DOOR STOP

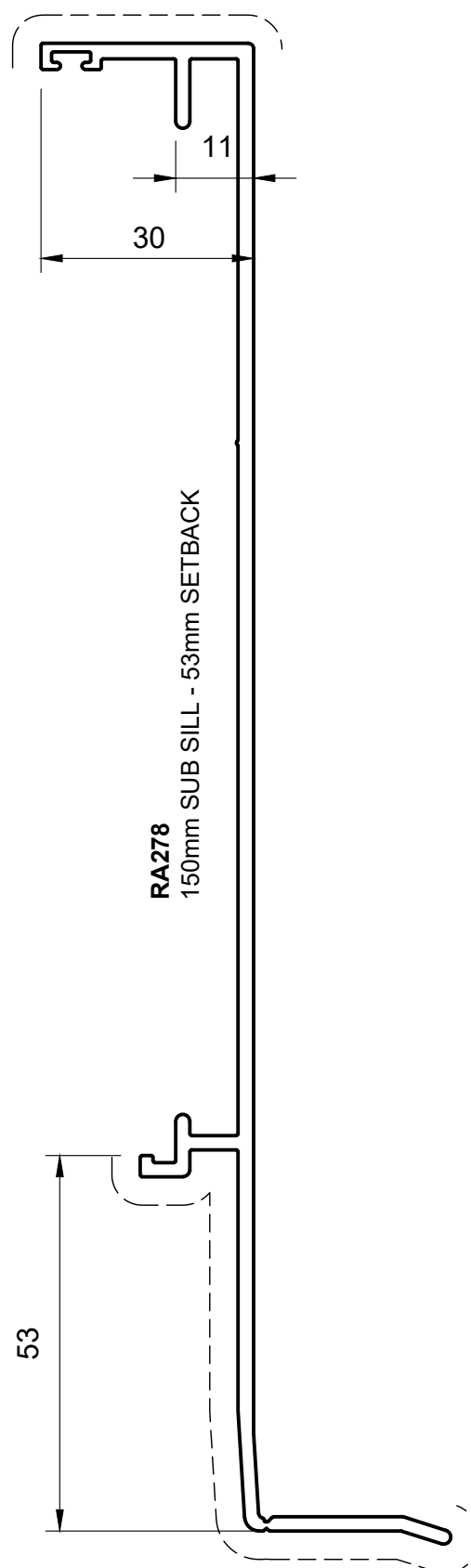
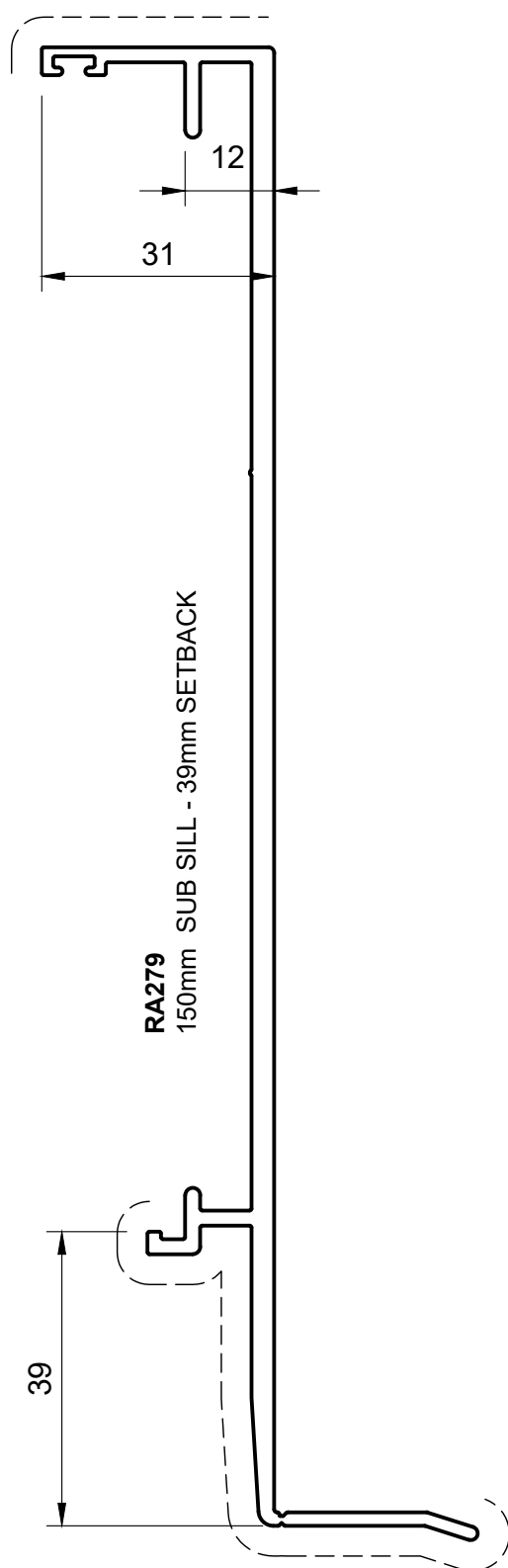


150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED EXTRUSION PROFILES



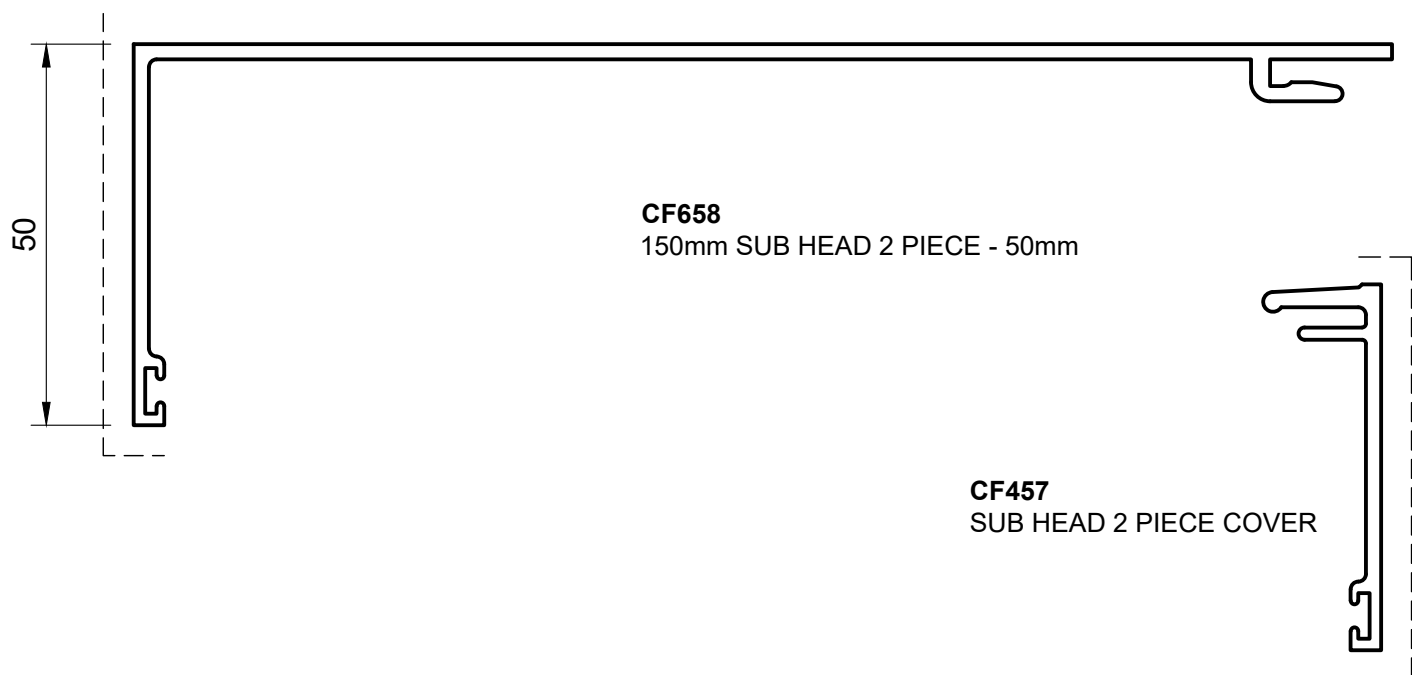
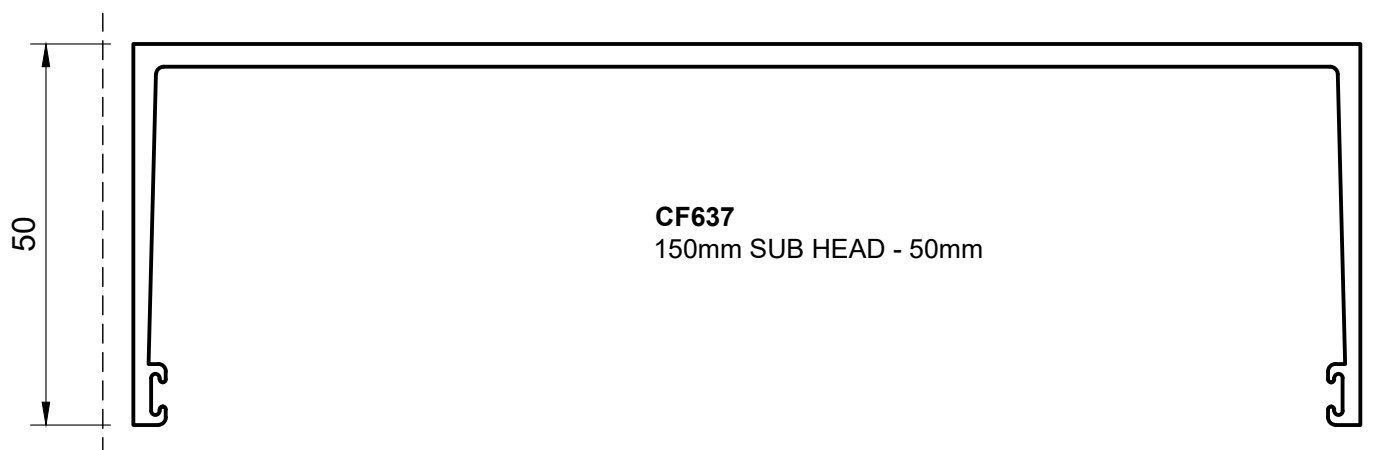
150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

EXTRUSION PROFILES



150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

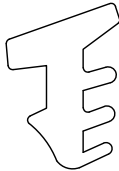
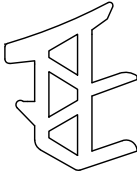
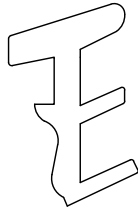
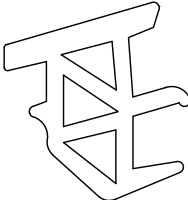
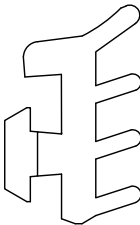
EXTRUSION PROFILES



150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED

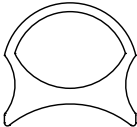


ACCESSORIES

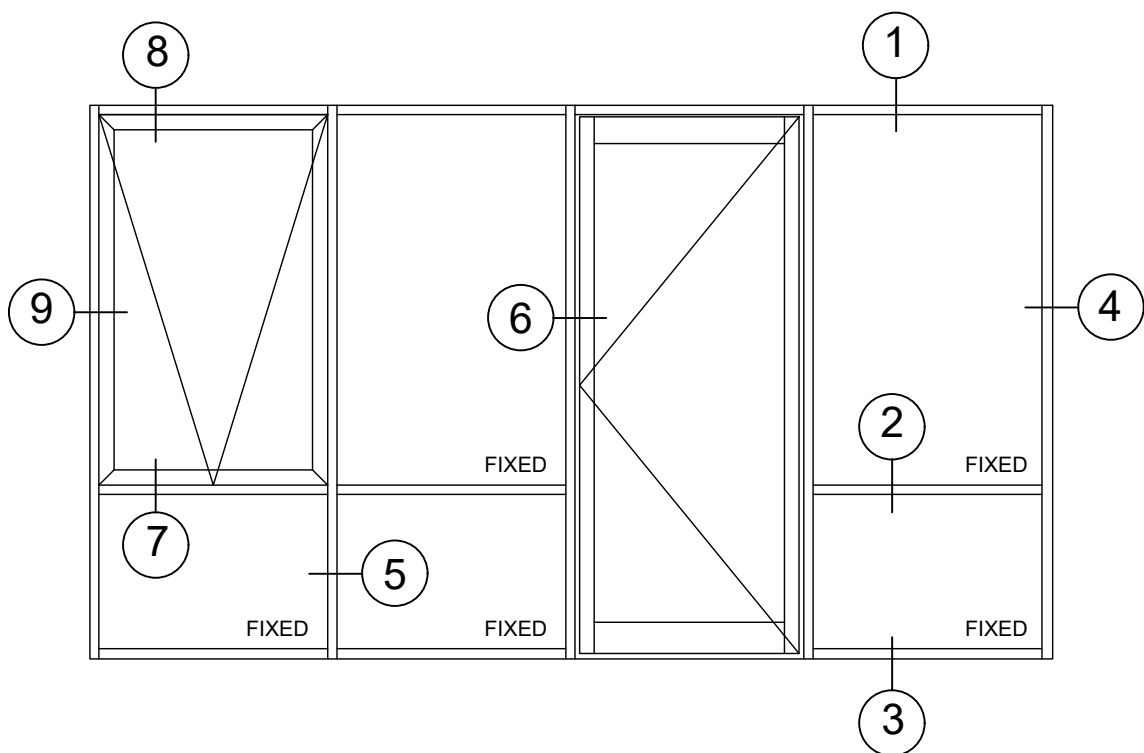
 CFH006 GLAZING WEDGE (4mm GAP) 200m ROLL	 CFH007 GLAZING WEDGE (5mm GAP) 200m ROLL
 CFH008 GLAZING WEDGE (3mm GAP) 250m ROLL	 CFH009 GLAZING WEDGE (6mm GAP) 100m ROLL
 CFH010 GLAZING WEDGE (2mm GAP) 500m ROLL	 CFH015 CAPTIVE WEDGE (4mm GAP) 250m ROLL

150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
ACCESSORIES



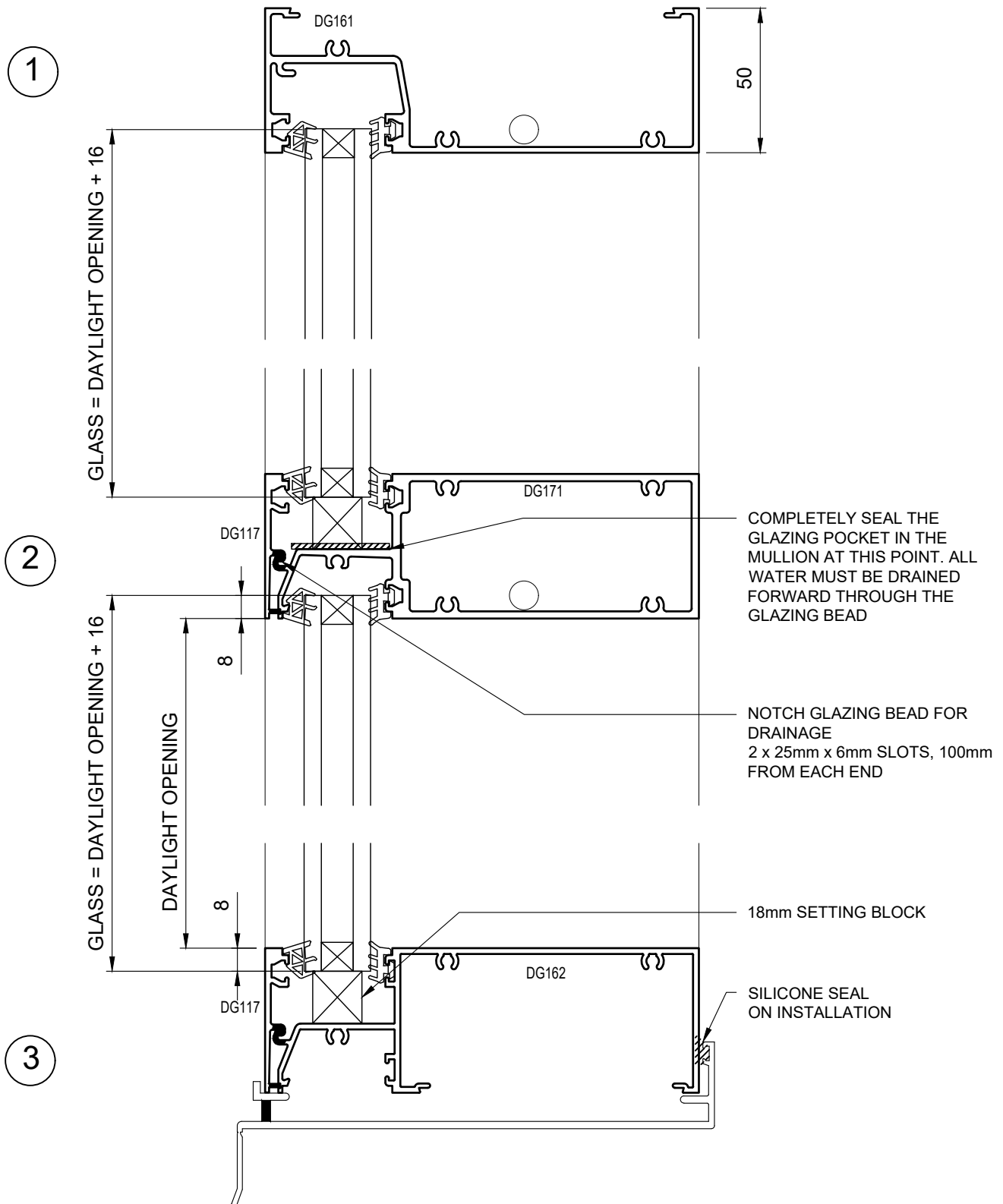
 CFH5 MULLION SEAL 200m ROLL	 CFH4 DOOR BUFFER 200m ROLL
 CFH13 SASH SEAL 200m ROLL	 CFH12 FRINGE PILE 200m ROLL

150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
CONFIGURATIONS



150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

VERTICAL DETAIL - EXTERNAL GLAZED - CAP BEAD

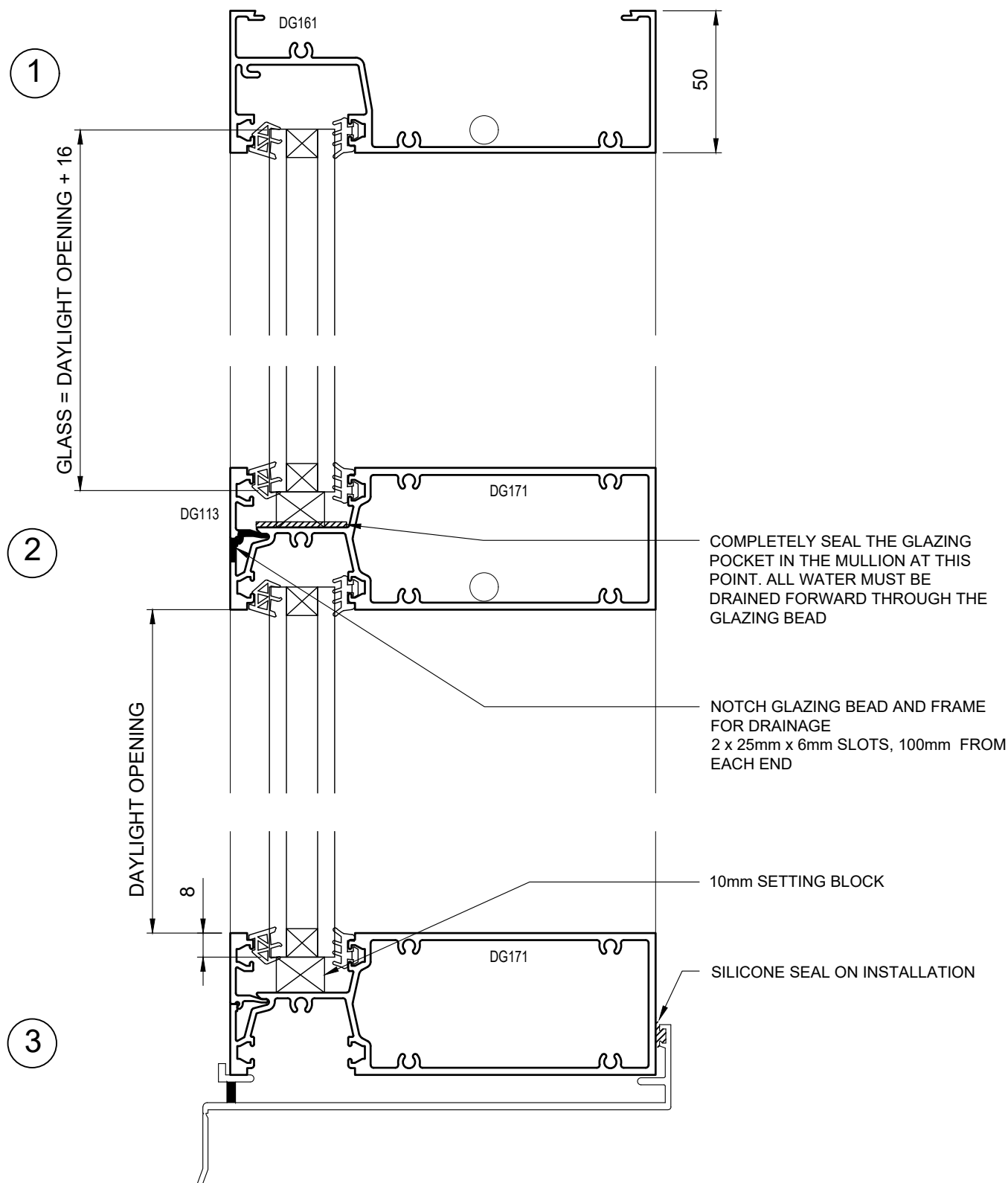


NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

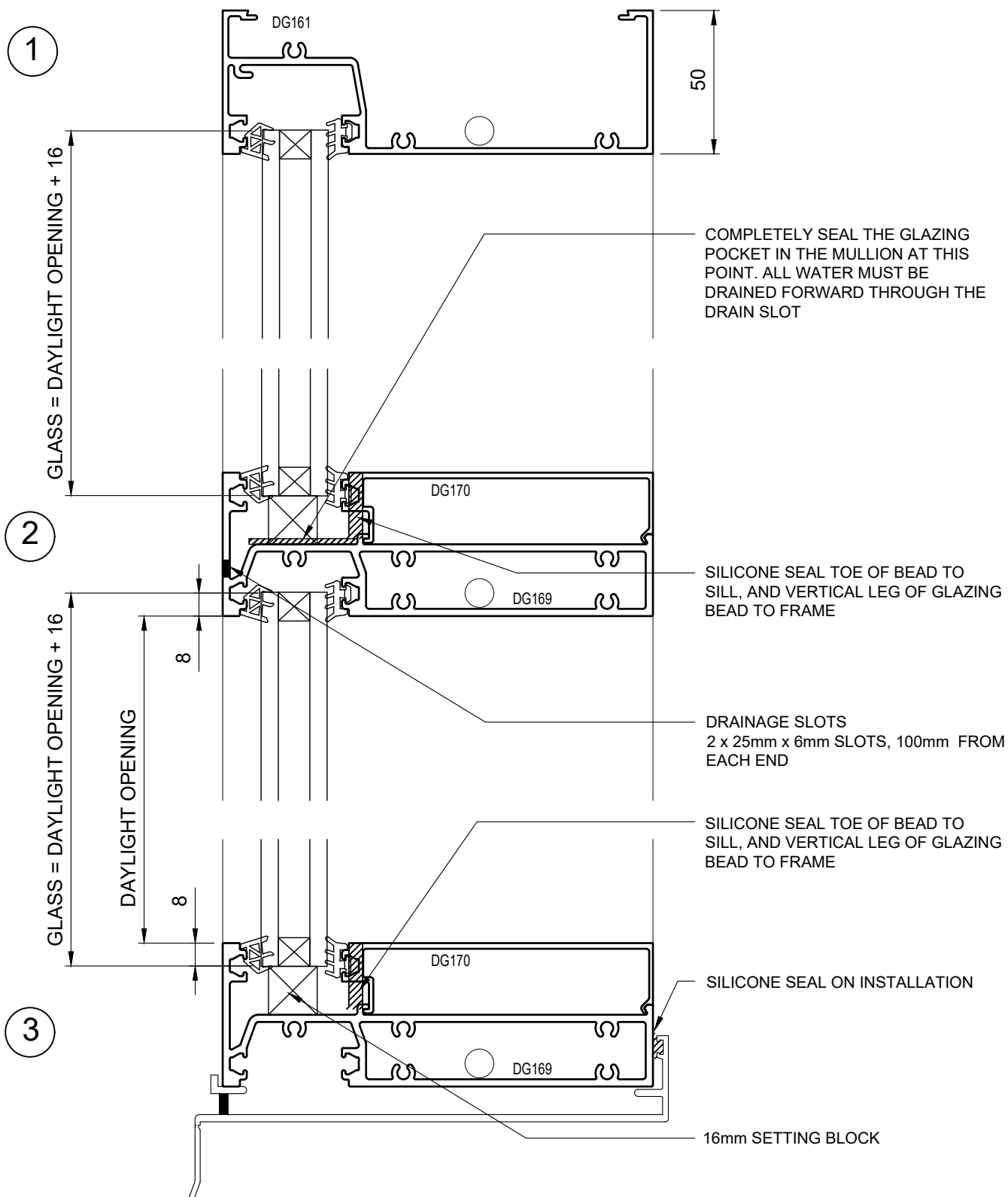
VERTICAL DETAIL - EXTERNAL GLAZED - L BEAD



NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED VERTICAL DETAIL - INTERNAL GLAZED

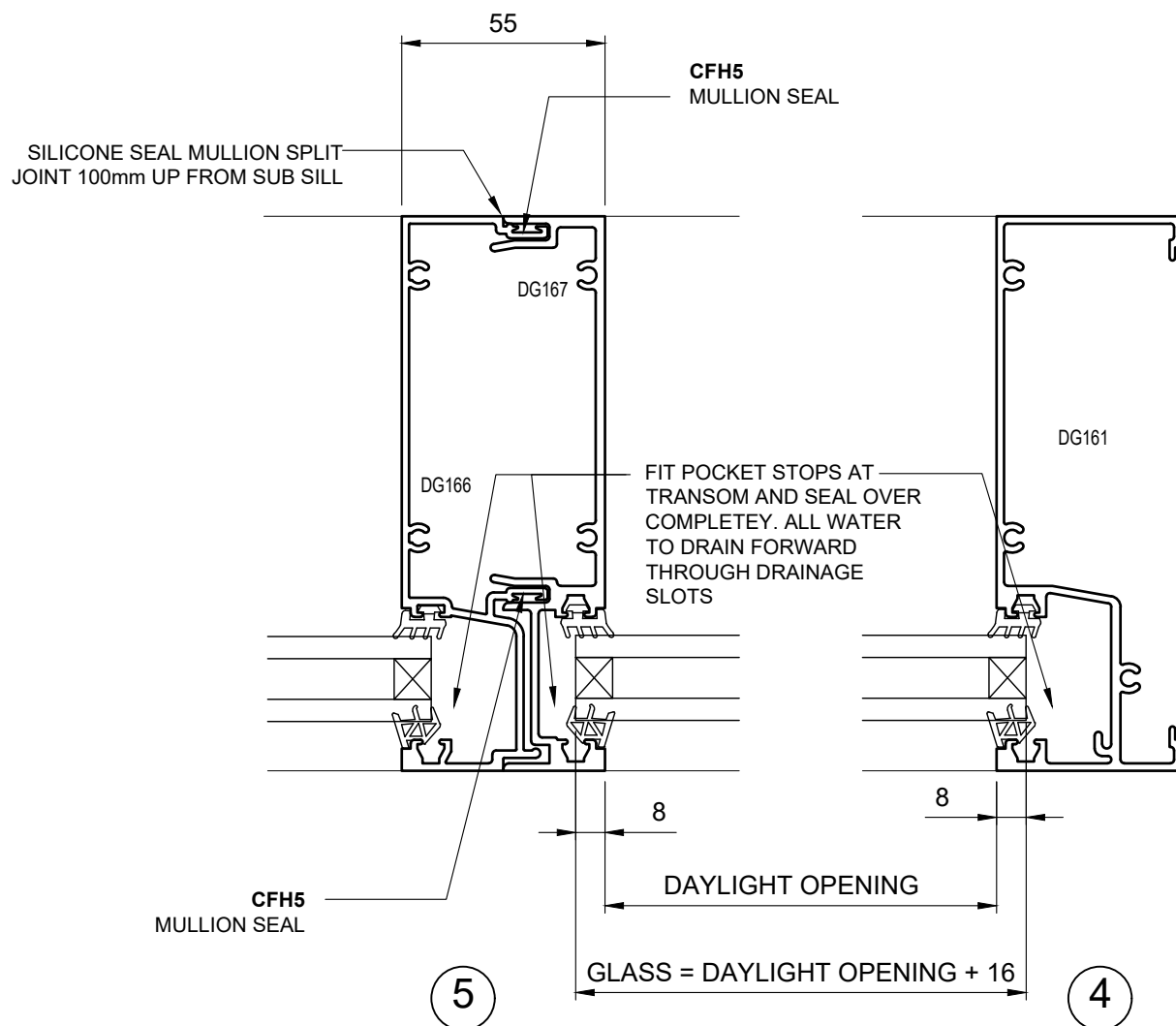


NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

HORIZONTAL DETAIL - STANDARD SPLIT MULLIONS

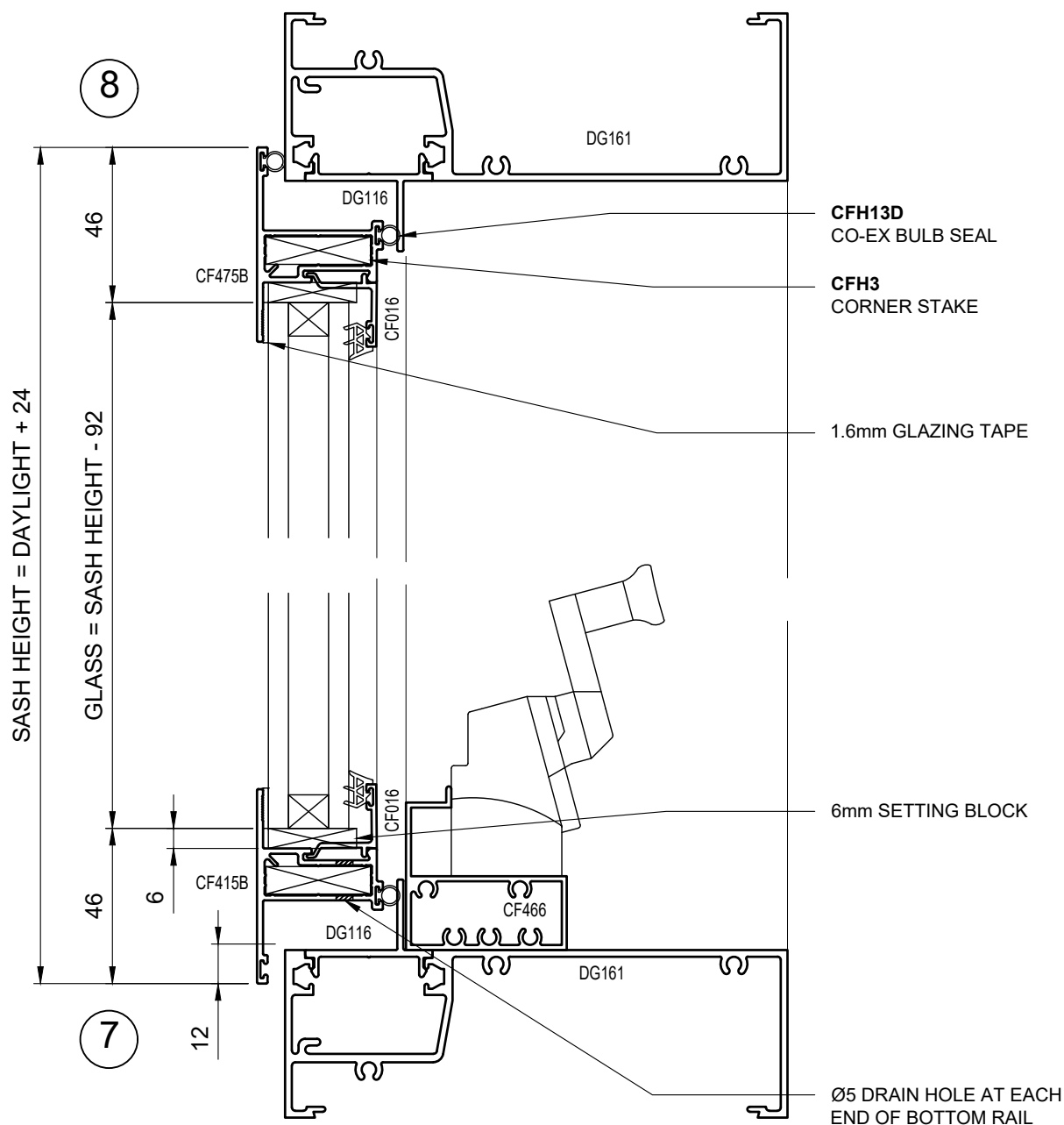


NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

VERTICAL DETAIL - 35mm AWNING

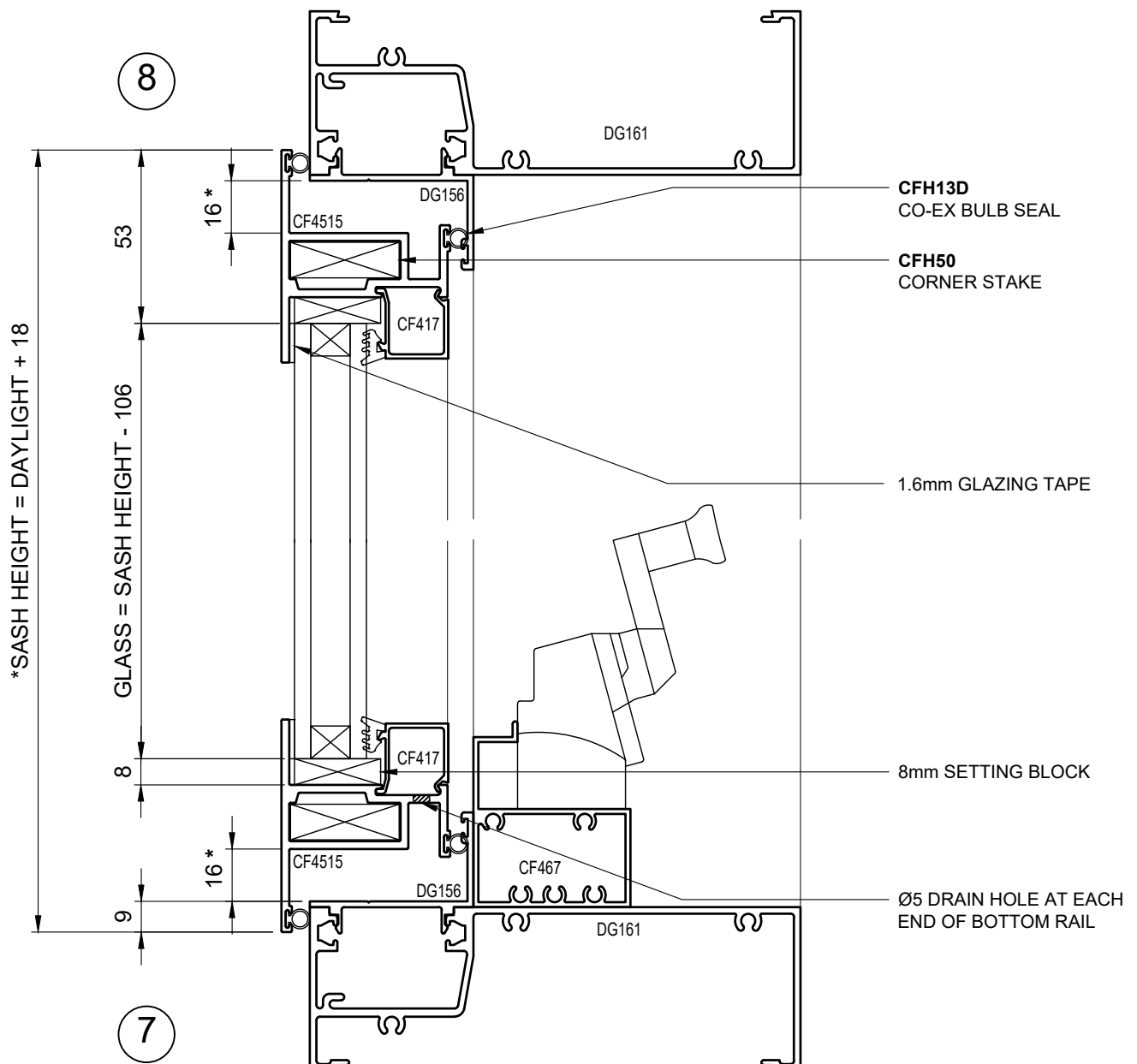


NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

VERTICAL DETAIL - 50mm AWNING



NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

HORIZONTAL DETAIL - AWNING JAMB

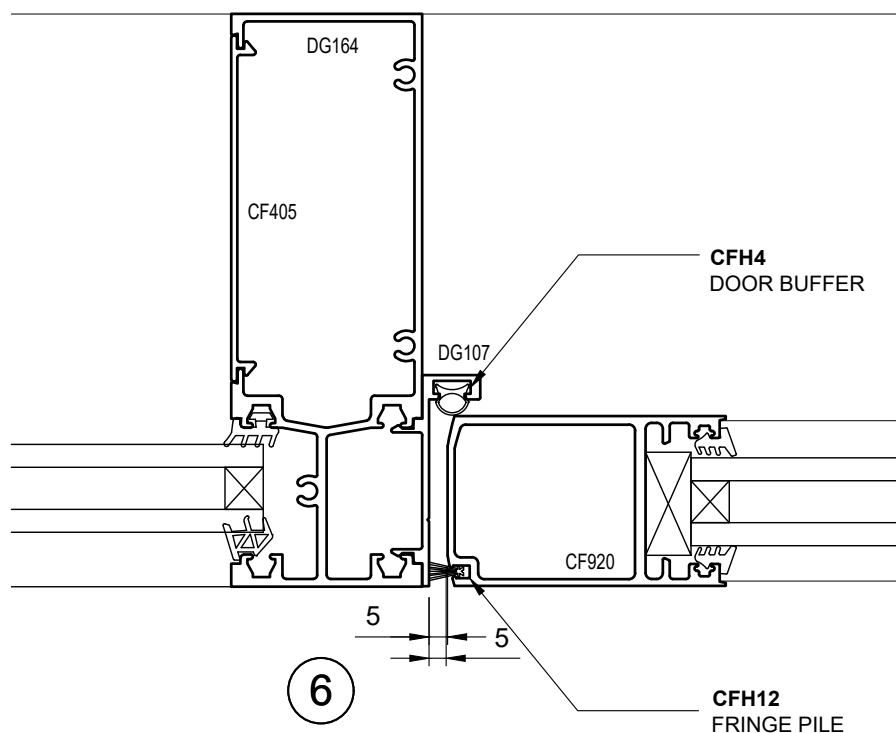
Technical drawing of a door profile cross-section. The drawing shows two main components: DG161 (top) and DG116 (bottom). The DG116 component is shown in a cross-section view, revealing internal details including a central cavity and a small rectangular feature labeled CF016. The CF415B component is shown as a separate part, likely a hinge or latch, with a cross-section view. Dimensions are indicated: 12 (width of the main body), 13 (width of the internal cavity), 40 (total width), and 46 (total width including the CF415B component). A circled number 9 is present in the bottom right corner.

Technical drawing of a window frame cross-section. The drawing shows the internal structure of the frame, including the glass pane and the surrounding frame components. Key dimensions are indicated: 12, 40, 53, and 13*. The drawing is labeled with '9' in a circle, indicating it is part of a series or a specific model.

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

HORIZONTAL DETAIL - 45mm HINGED DOOR JAMB

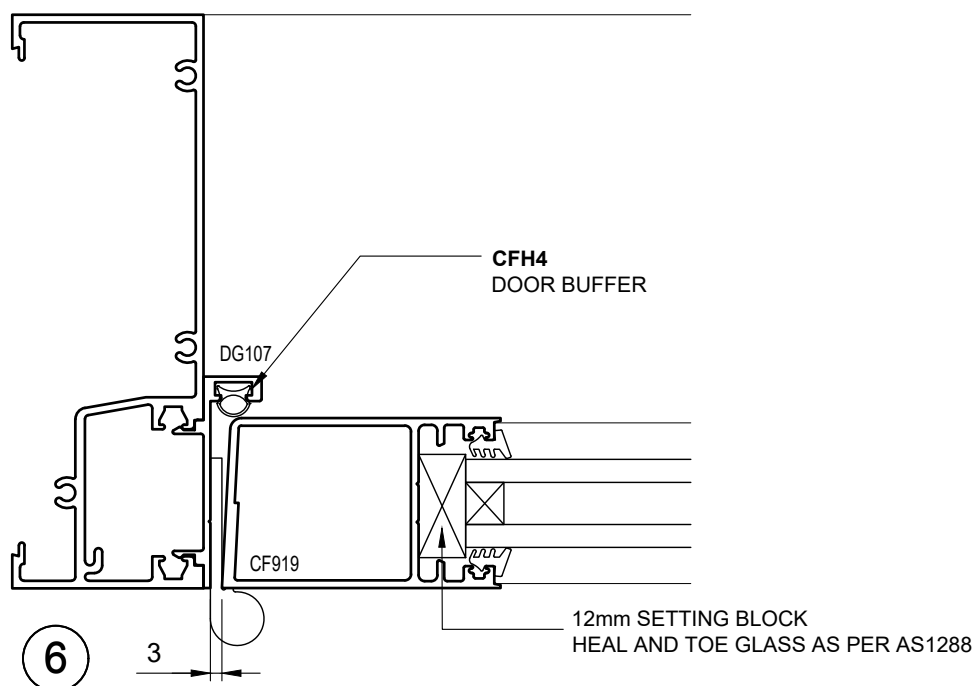


NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

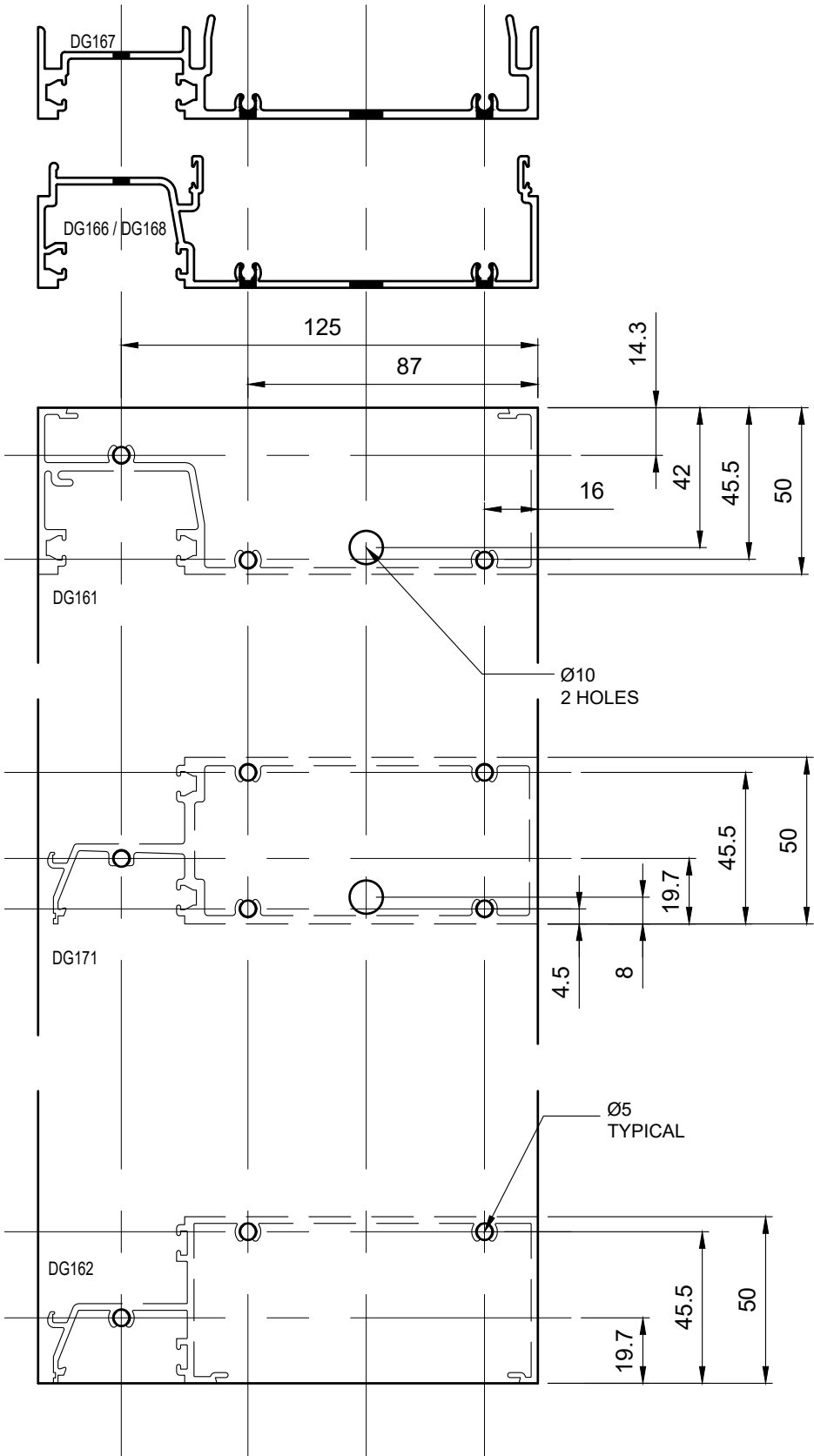
HORIZONTAL DETAIL - 45mm HINGED DOOR JAMB



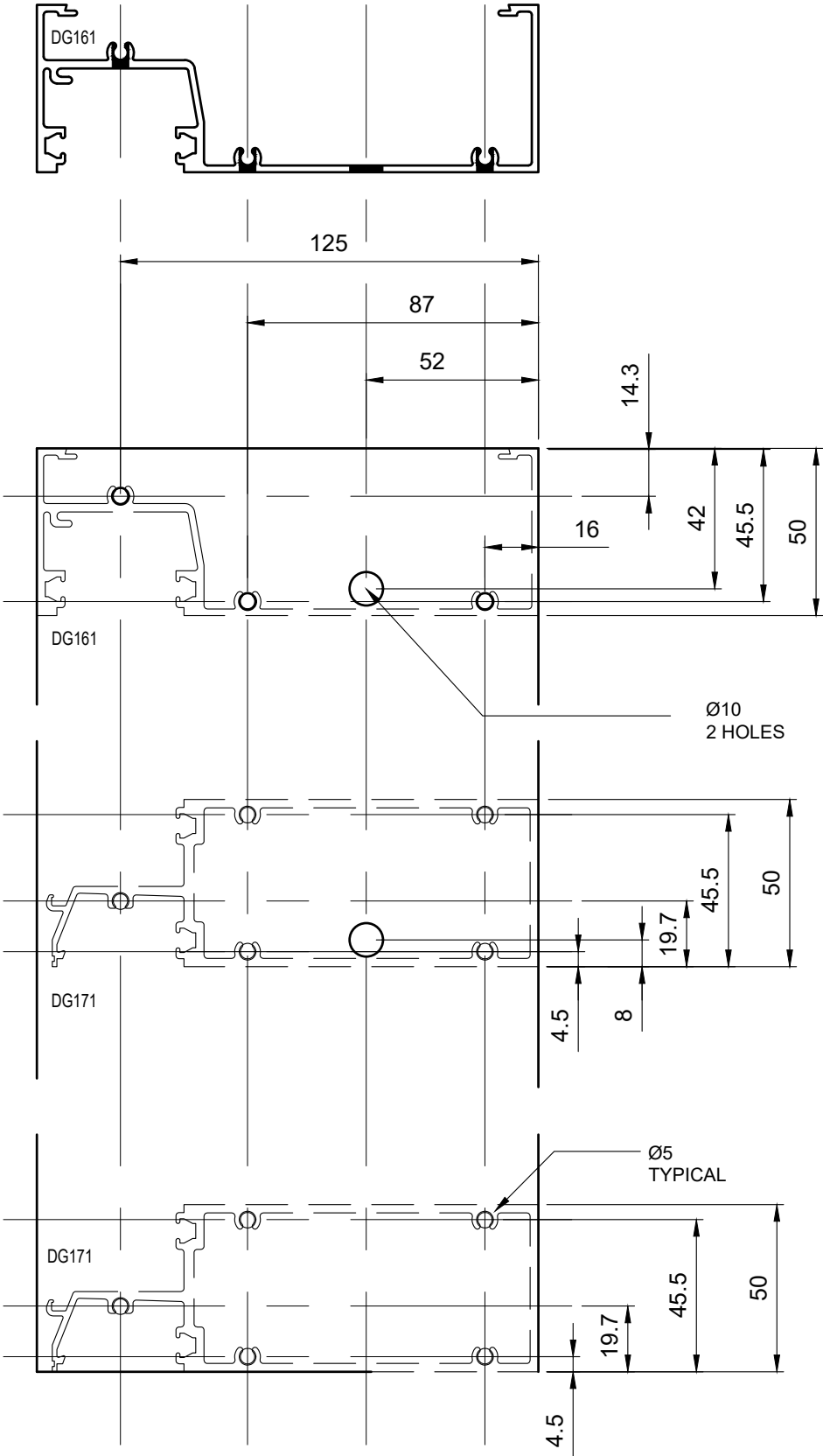
NOTE:

- ALL JOINTS TO BE SEALED USING A SUITABLE SMALL JOINT SEALANT OR CLOSED CELL FRAME GASKET

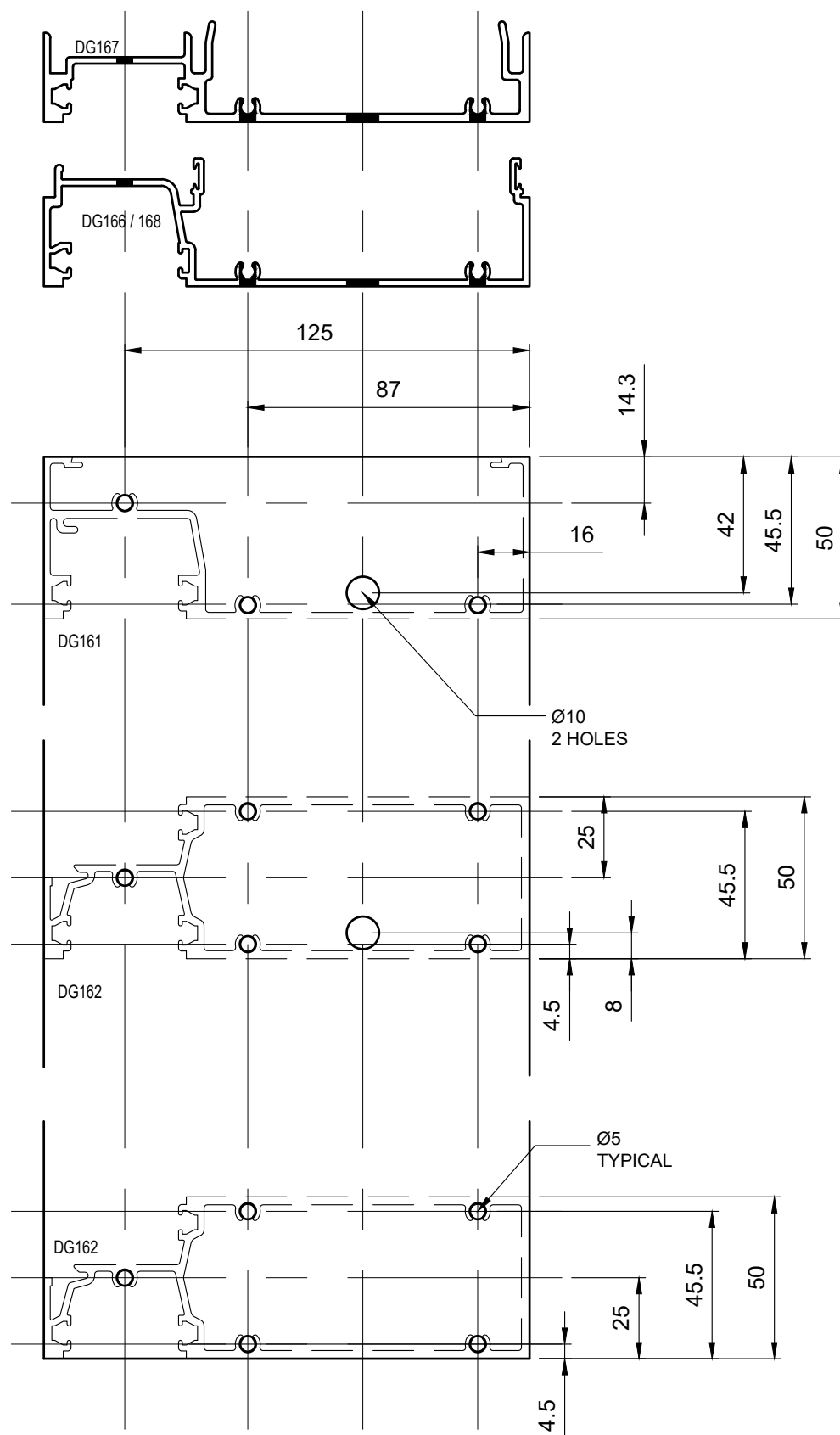
150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
MACHINING - MULLIONS - EXT CAP GLAZE



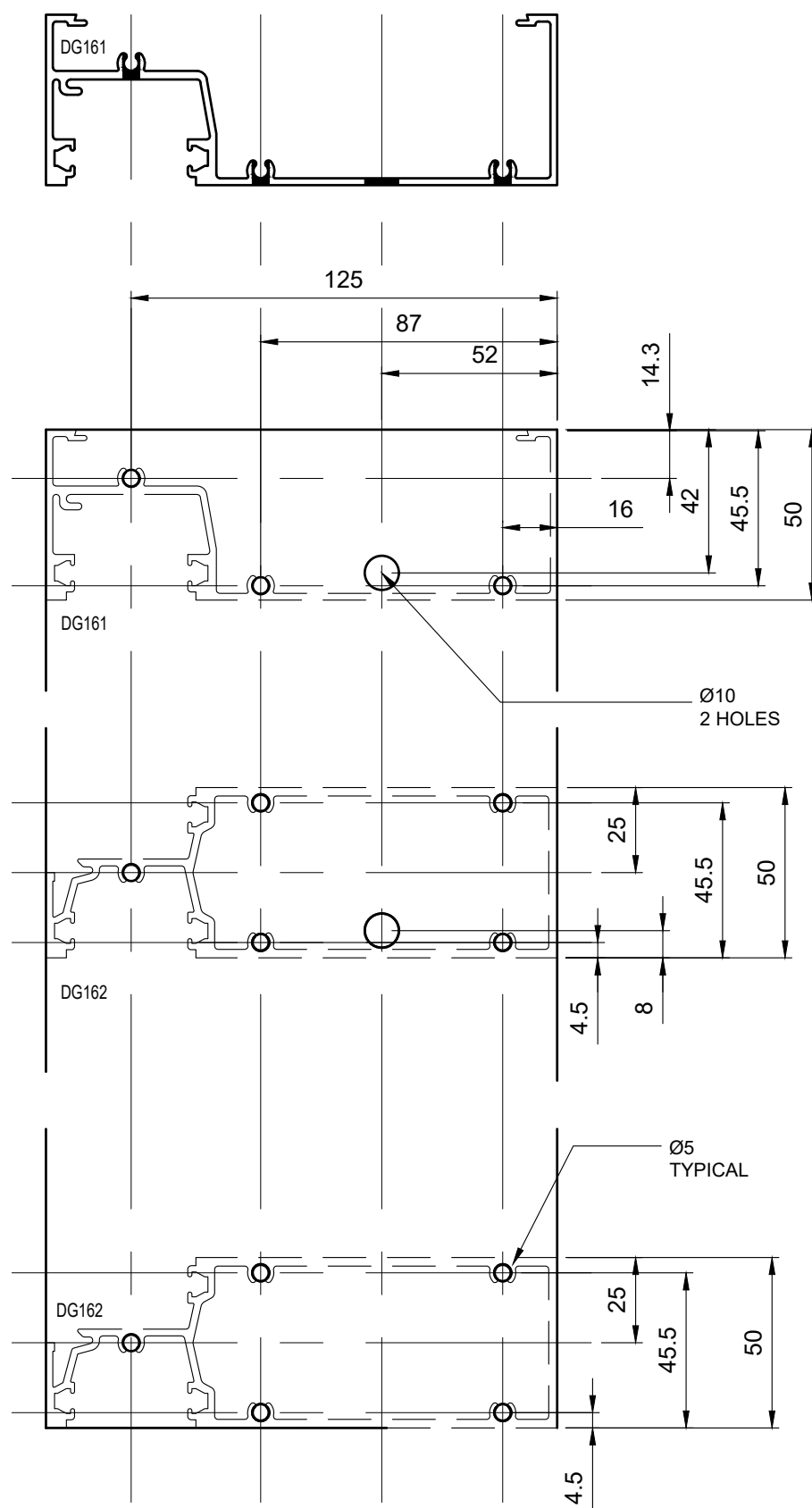
150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
MACHINING - MAIN FRAME - EXT CAP GLAZE



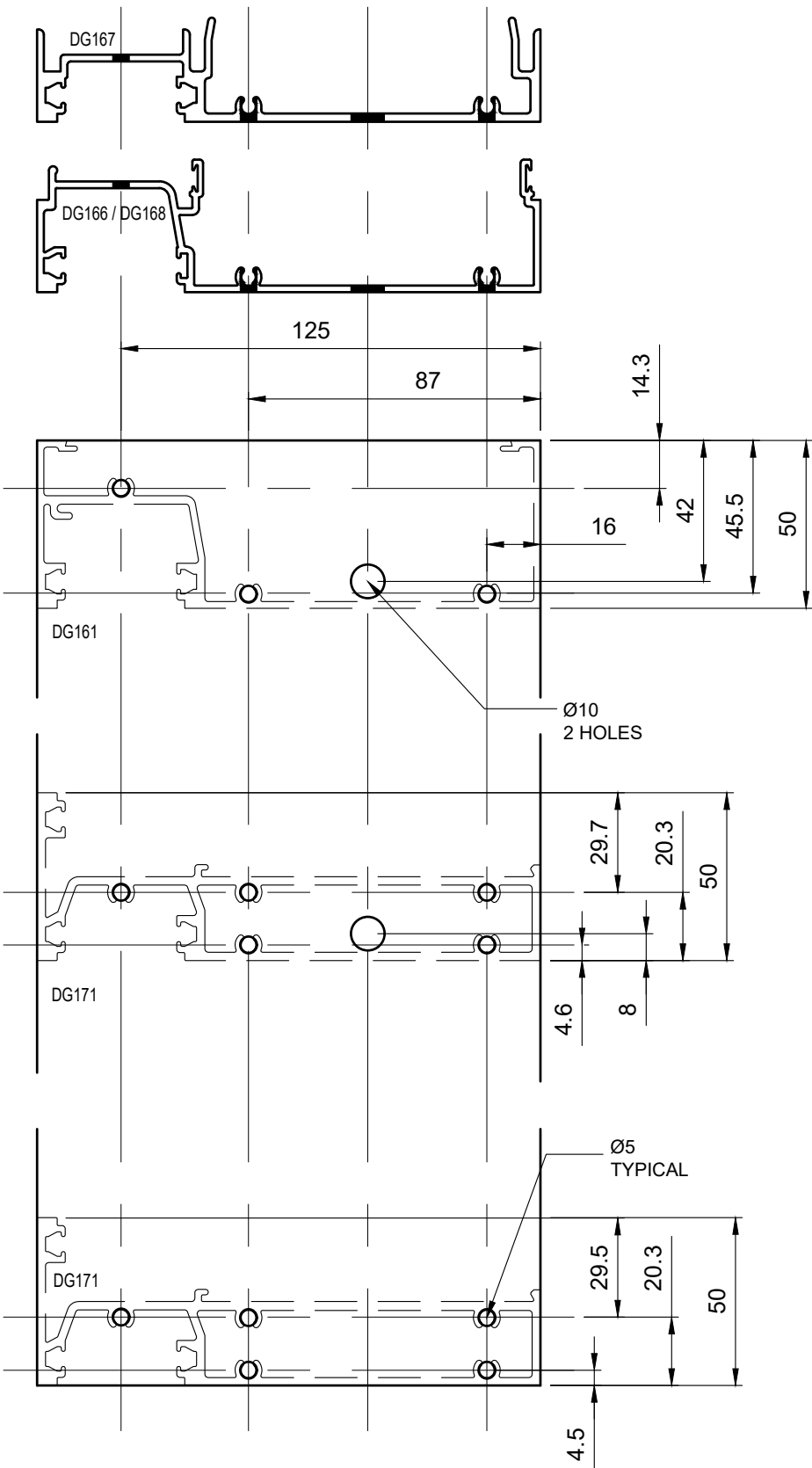
150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED MACHINING - MULLIONS - BEAD GLAZE



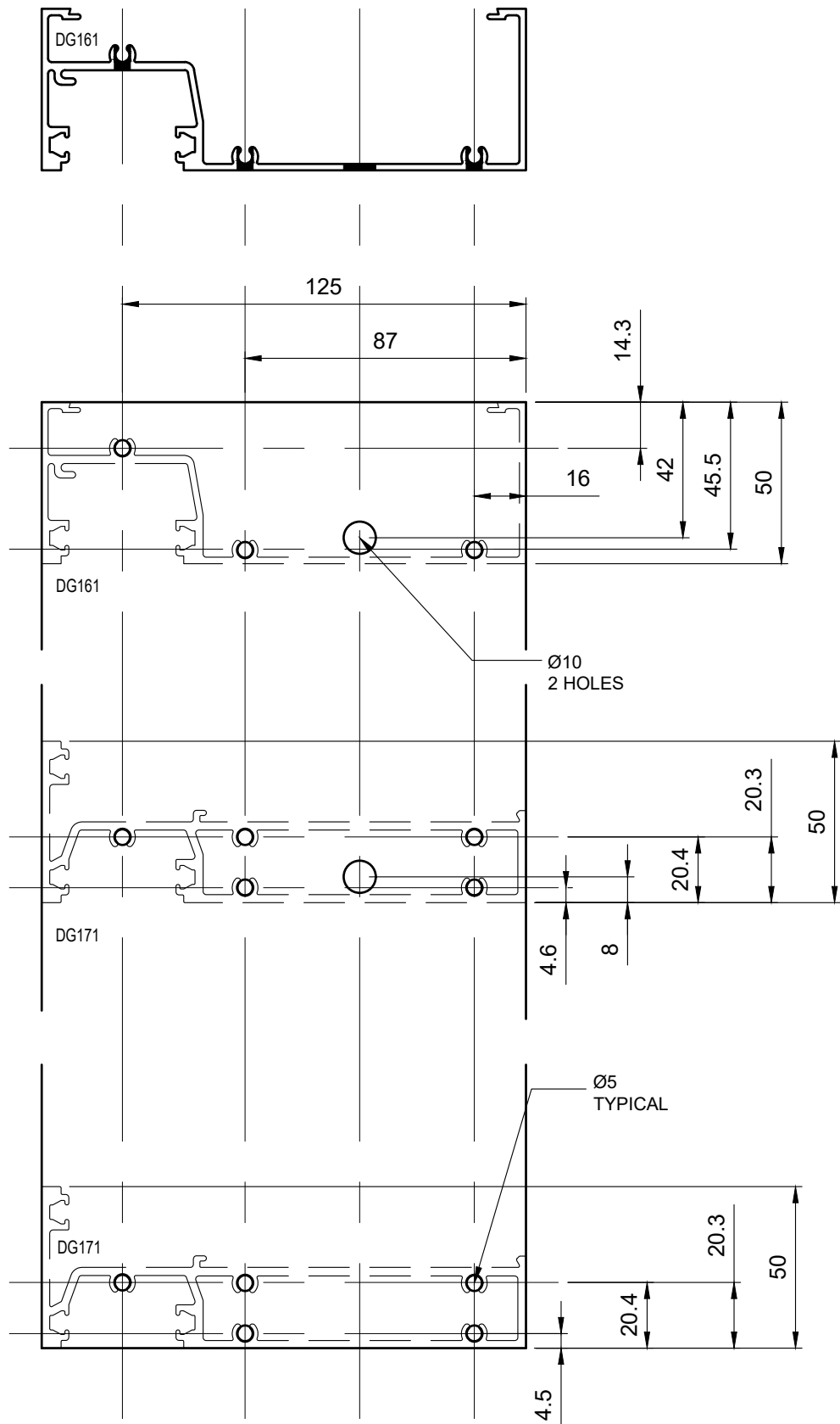
150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED MACHINING - MAIN FRAME - BEAD GLAZE



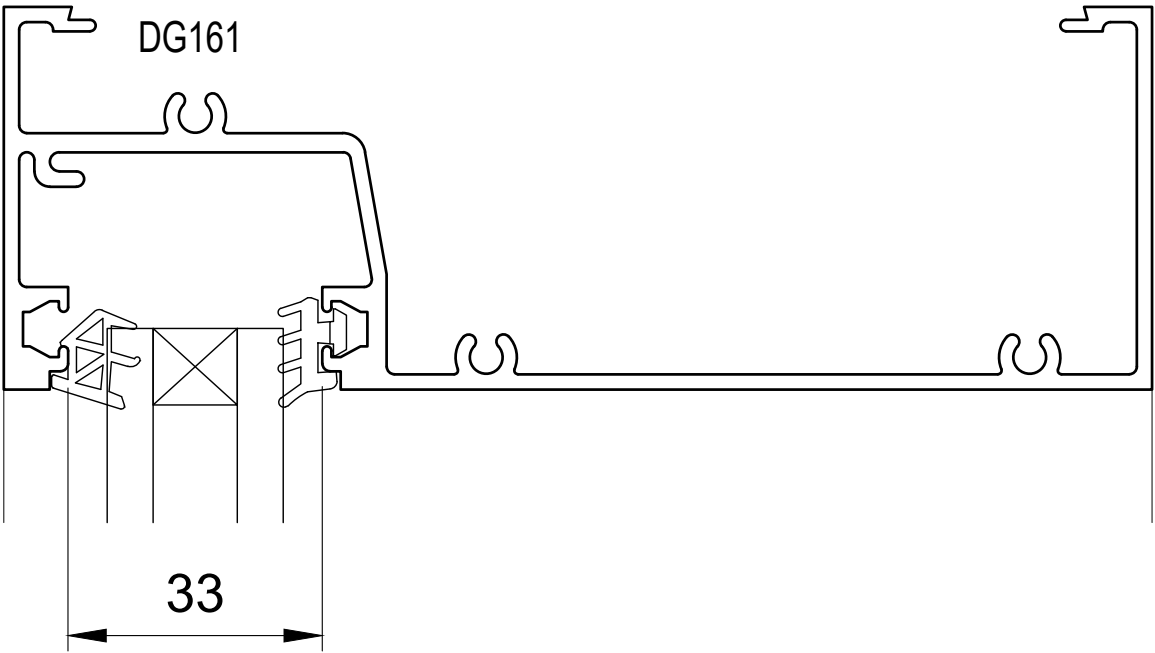
150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
MACHINING - MULLIONS - INT GLAZE



**150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
MACHINING - MAIN FRAME - INT GLAZE**



150mm COMMERCIAL FRAME
FLUSH GLAZED - DOUBLE GLAZED
GLAZING DETAILS - CAPTIVE

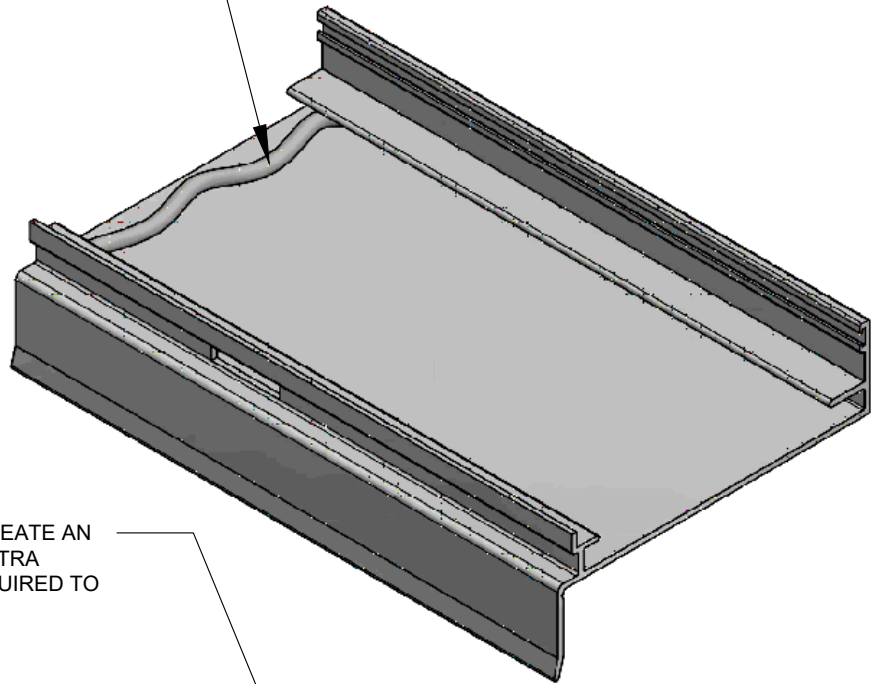


DOUBLE GLAZE - CAPTIVE		
IGU THICKNESS	CAPTIVE	WEDGE
22mm	CFH015 - 6.5mm	CFH007 - 5mm
24mm	CFH015 - 6.5mm	CFH008 - 3mm
26mm	CFH017 - 4mm	CFH007 - 5mm
28mm	CFH017 - 4mm	CFH010 - 2mm

150mm COMMERCIAL FRAME FLUSH GLAZED - DOUBLE GLAZED

SUB SILL END DAM SEALING

LAY A BED OF SILICONE ACROSS THE BASE OF THE SUB SILLS, CAREFULLY SEALING INTO THE CORNERS AND UP THE VERTICAL SUB SILL LEGS



INSTALL A 25 x 25mm ANGLE TO CREATE AN END DAM IN THE SUB SILL. ADD EXTRA SILICONE IN THE CORNERS IF REQUIRED TO ENSURE WATER TIGHTNESS

RIVET ANGLE TO SUB SILL TO ENSURE THE SILICONE SEAL IS NOT DISTURBED OR BROKEN

