



Assembly Information

for PVCu Windows

System designation:

TR > TREND-System

Glossary of standard terms:

SRW > Sash Rebate Width

SRH > Sash Rebate Height

FHH > Fixed Handle Height

VHH > Variable Handle Height

"All dimensions are in mm"

Index

**Application Information
(Maximum Sizes, Weights, Safety Information)**

**The
Single Sash Window**

**The
Double Sash Window**

**The
Half Round Window**

**The
Angled Window**

Application Information

for Tilt and Turn Windows and Doors

Maximum Sash Weight

Max. 80 kg	Max. 100 kg	Max. 120 kg
TREND scissor stay hinge with 3 mm Ø locating-pins.	Dependant on TREND scissor stay hinge with 7 mm Ø load pins and TREND bottom hinge with 3 mm locating-pins.	Dependant on TREND scissor stay hinge and pivot post with 7 mm Ø load pins.

Attention: The maximum sash weights must not be exceeded.

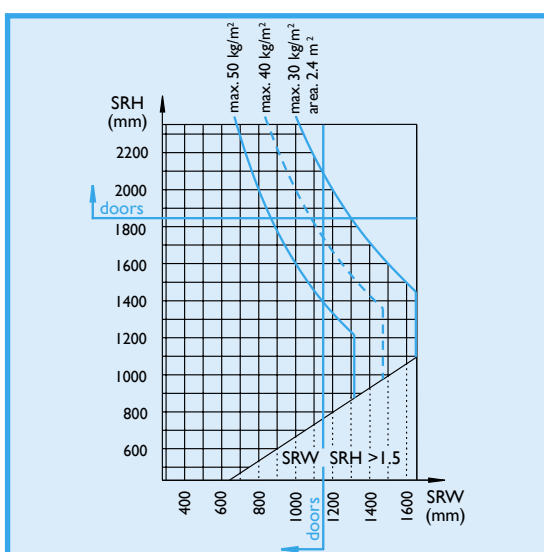
Sash Sizes

Max.	SRW 1650 SRH 2350	The overall area must not exceed 2.4 m ² or 120 kg sash weight and a height to width ratio of max. 1 : 1.5.
Min.	SRW 280 SRH 320	With corner element B, Scissor stay size 00 and drive gear size 00.
	SRW 350 SRH 295	With corner element B (with the locking cam fitted on the top), Scissor stay size 00 and drive gear size 00.

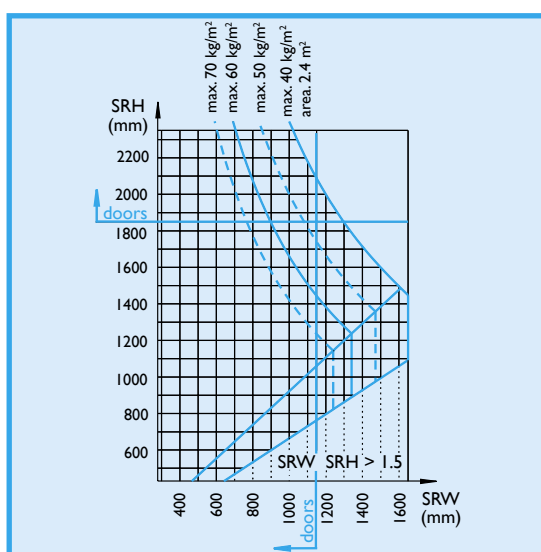
Diagram for calculating the permissible sash weight.

Glass thickness mm	24	22	20	18	16	14	12	1 mm Glass = 2.5 kg / m ²
Glass weight kg/m ²	60	55	50	45	40	35	30	

Max. 80 kg Sash Weight



Max. 100 kg Sash Weight

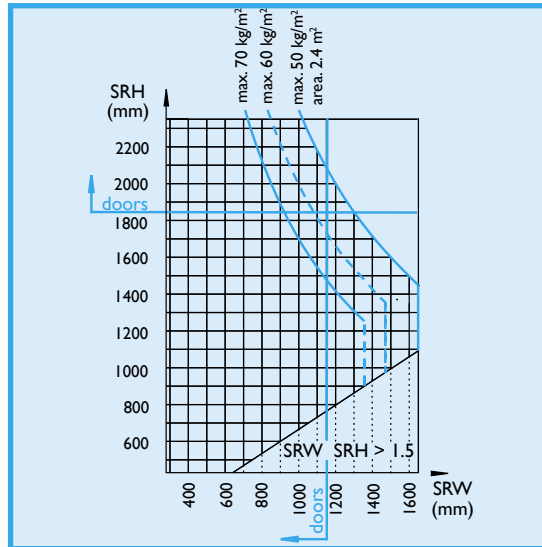


Order numbers and size information are available on request

Application Information

for Tilt and Turn Windows and Doors

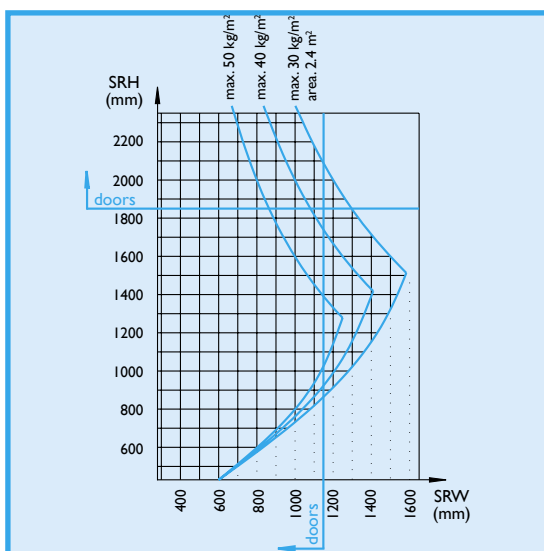
Max. 120 kg Sash Weight



If the glass thickness is under 12 mm and the sash size is within the permissible size range and the height to width ratio does not exceed SRH : SRW 1: 1.5 the window can be produced.

Angled window

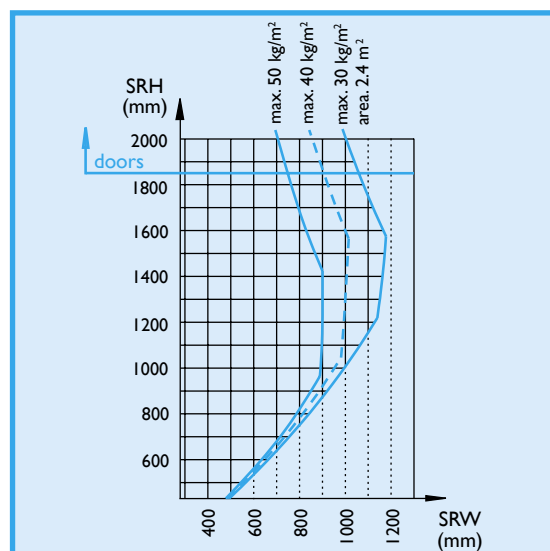
Diagram for the determination of the permissible sizes of angled windows to max. 80 kg sash weight.



SRH = Relating to the largest sash height

Half round window

Diagram for the determination of the permissible sizes of half round windows to max. 80 kg sash weight.

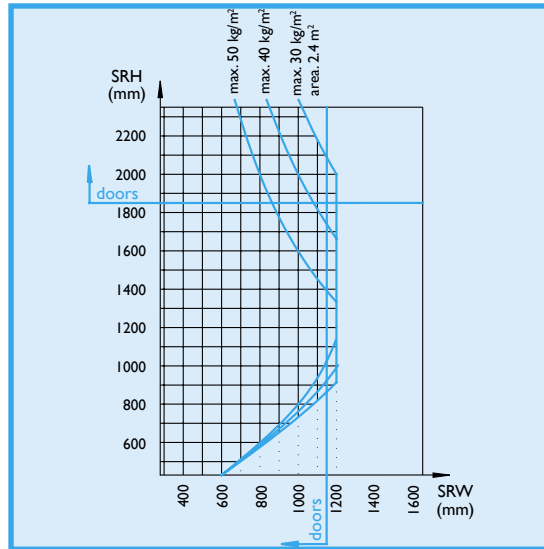


SRH = The start of the arch line

Order numbers and size information are available on request

Angled window

Diagram for the determination of the permissible sizes when half round scissor stays are used on angled windows to max. 80 kg sash weight.



SRH = Relating to the largest sash height hinge side

Order numbers and size information are available on request

Fabrication Advice

Security Information for the assembly of load bearing security components

Advice on the MACO-Surface Coating

The MACO-Surface treatment process contains an extra layer of wax that seals the passivation layer. The resulting coating performs well when salt spray tested.

PVCu Windows and Doors

The maximum sash weights as stated by MACO must not be exceeded.

The maximum weight stated by the profile extruder must not exceed our recommendations. Please pay attention to our functional diagrams.

Fixing of load bearing parts (see tables)

The tightness of the screw fixings for the top and bottom hinges must not exceed the forces shown in the tables below. To ensure that they are not exceeded the window fabricator should have the forces checked by a test institute.



The MACO Wax Coating

- Enables a high level of corrosion protection.
- Surface slide is significantly improved.
- More regular surface coating.

Traction force value in reliance of the sash weight as per RAL-RG 607/3

Window W 1300 x H 1200 mm

Sash Weight in kg	Force in Newton (N) with 5-times security
60	1650
70	1900
80	2200
90	2450
100	2700
110	3000
120	3250
130	3500

Traction force value in reliance of the sash weight as per RAL-RG 607/3

Window-Doors W 900 x H 2300 mm

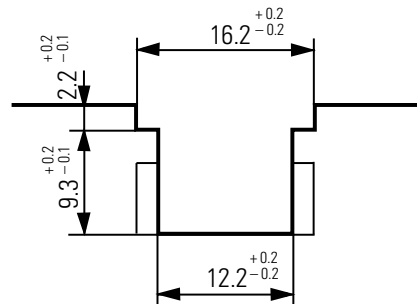
Sash Weight in kg	Force in Newton (N) with 5-times security
60	600
70	700
80	800
90	900
100	1000
110	1100
120	1150
130	1250

Formula for self calculation:

$$W : H \times G : 2 \times 5$$

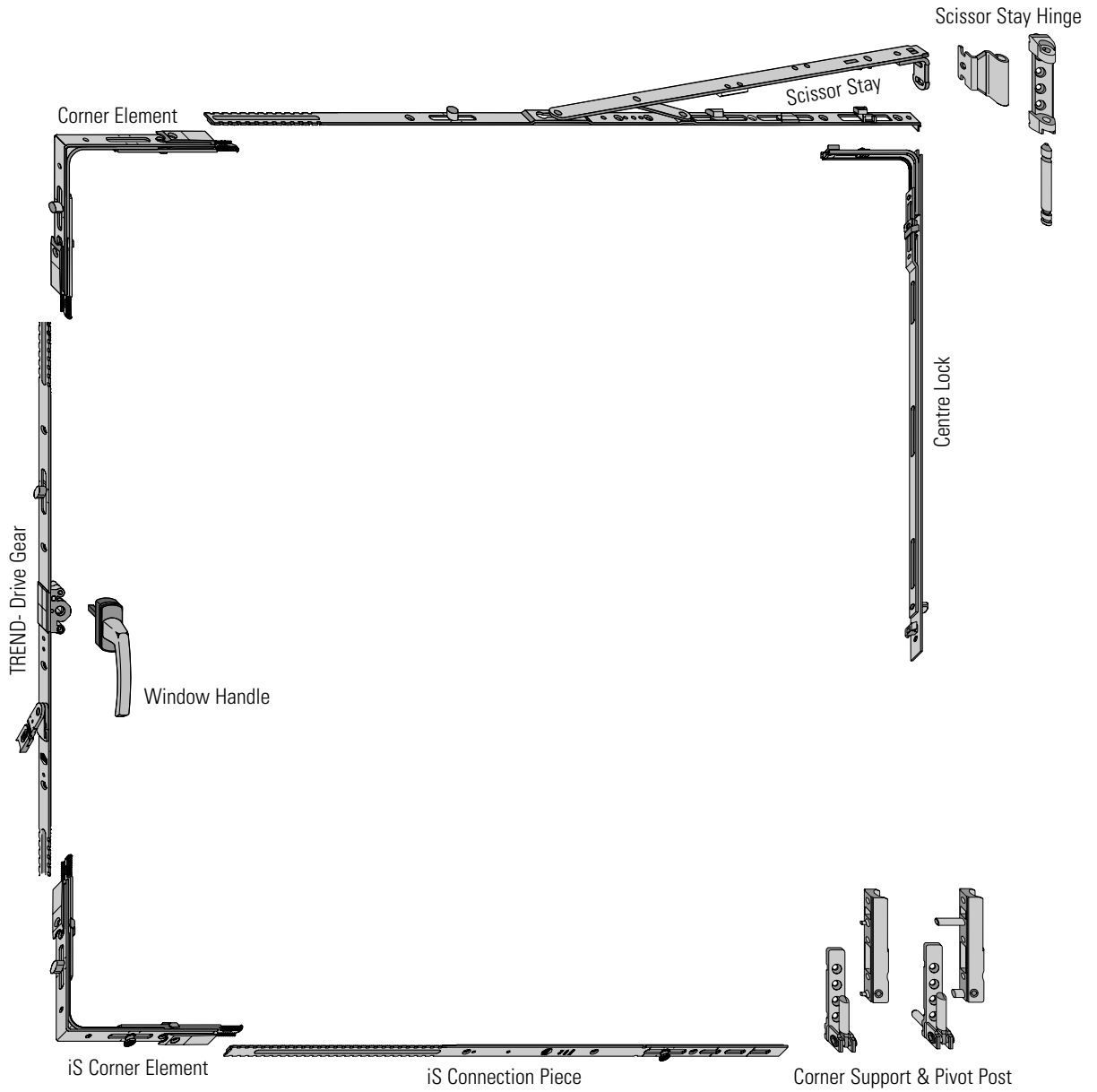
(W = Width, H = Height, G = Sash Weight)

The installation of Tilt and Turn fittings requires a Eurogroove. The Eurogroove detail is shown below:



Tilt First Fittings

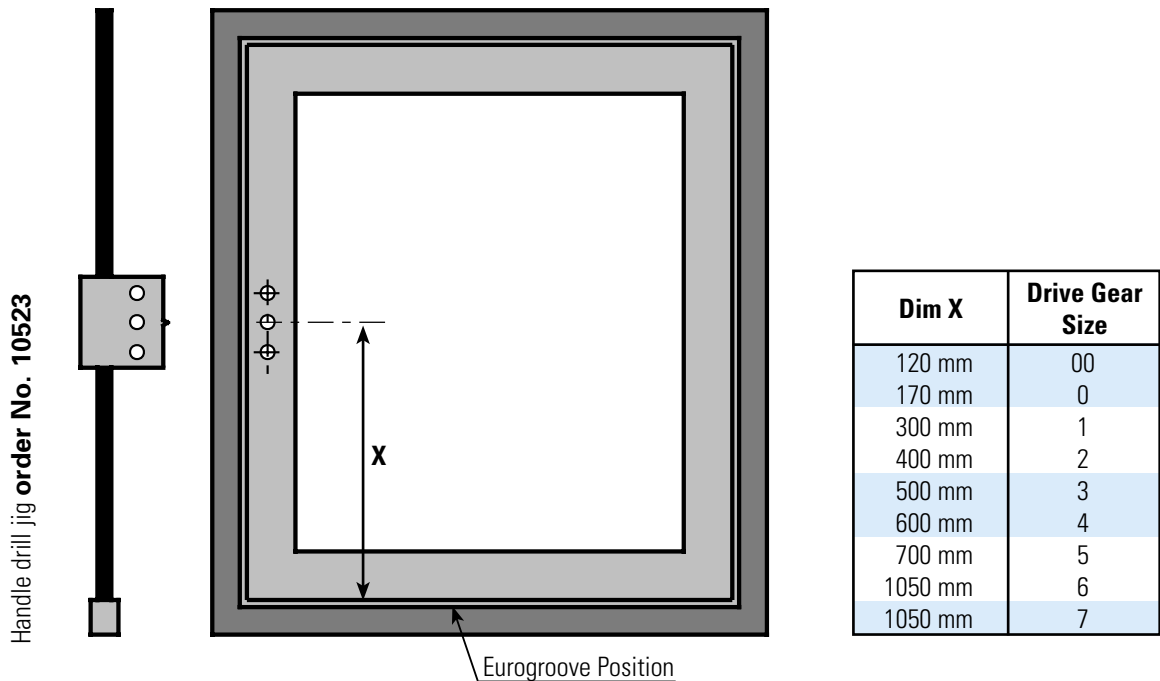
Overview



Order numbers and size information are available on request

Sash Preparation

Handle Preparation

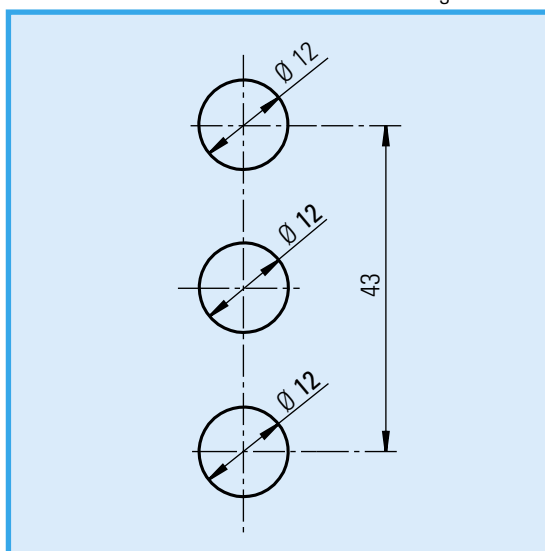


Set the handle drill jig (Order No. 10523) to the corresponding drive gear size. Locate the jig into the eurogroove and drill the 3 mm guide holes.

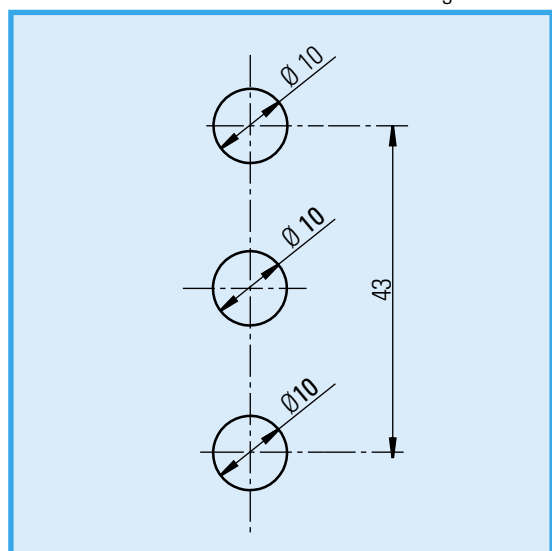
With VHH drive gear locate the jig into the eurogroove and ensure that the guide line is in the same position as the guide line on the drive gear.

Drill Centres:

For window handles with 12 mm Lugs

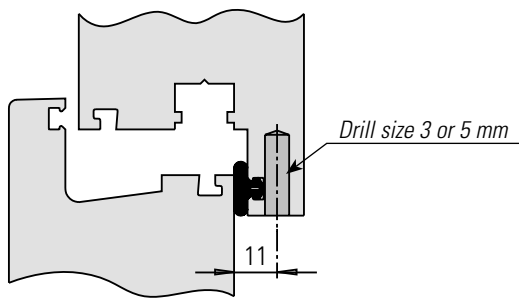


For window handles with 10 mm Lugs



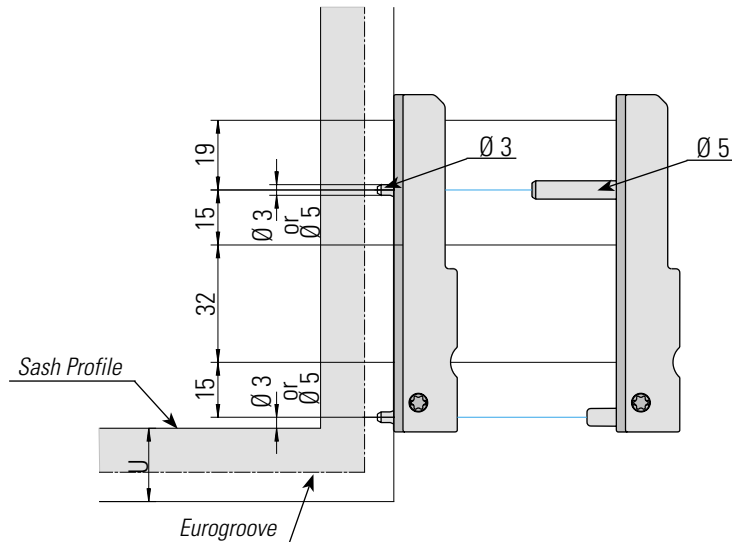
Order numbers and size information are available on request

Hinge Assembly

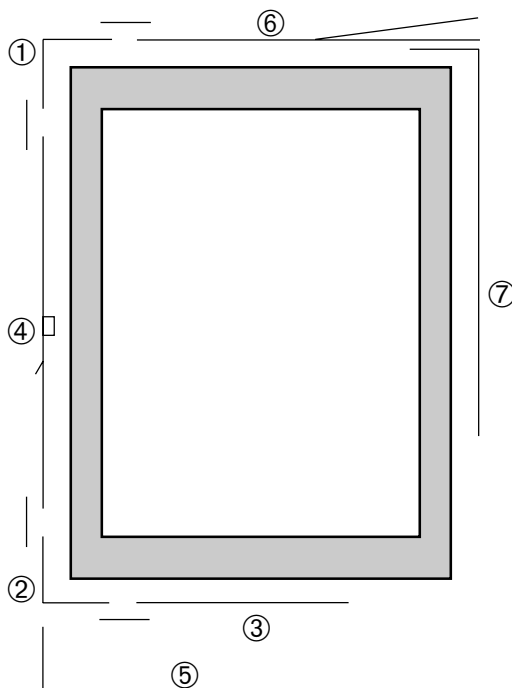


N ^o	Sash-Drill Jig
21564	for 3 mm Locating pins
28235	for 3 mm Locating pins (for 5° Bevel)
21562	for 5 mm Locating pins
23279	for 5 mm Locating pins (for 5° Bevel)

1. Locate the jig into the bottom corner of the eurogroove.
2. Adjust the jig as required.
3. Drill 3 mm or 5 mm pilot holes as required.



Mounting the Fittings onto the Sash and Frame

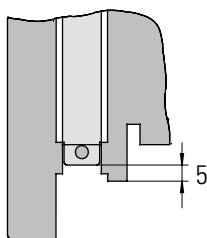


1. Mount **top corner element** ①.
- 1.1. Mount **bottom corner element** ② when used with VHH drive gear (ensure that the mushroom is on the bottom). When the *SRW exceeds 800 mm fit **bottom iS connection piece** ③.
2. Mark and cut **drive gear** ④ to length and mount. When FHH drive gear is being used do not mount the **bottom corner element** ②. Instead fit the **iS centre lock** ⑤ into the drive gear and mount.
3. Mark and cut the **scissor stay** ⑥ to length, couple with **centre lock** ⑦ and mount onto the sash. When the *SRH is over 800 mm a centre lock must be fitted see Diag. 1.
4. Locate the stay support arm into the scissor stay with Torx-Key T20 and turn 90° to lock into position see Diag. 2.
5. With TREND-Drive gears open the sash lifter see Diag. 3.

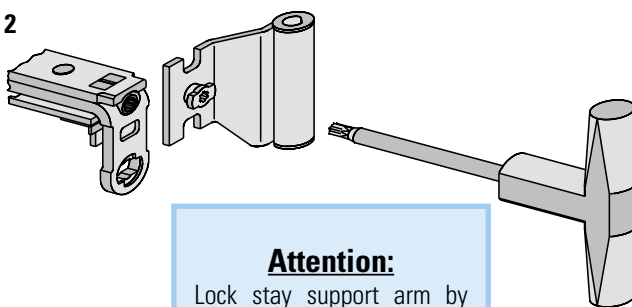
*MACO recommendation on SRH & SRW over 800 mm, Alternatively check with your profile extruder.

Order numbers and size information are available on request

Diag. 1



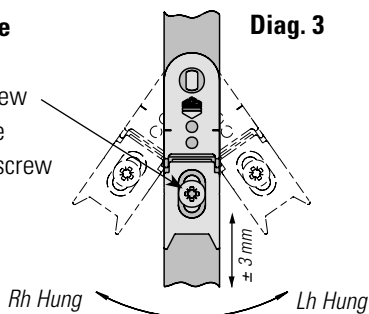
Diag. 2



Attention:
Lock stay support arm by turning through 90°!

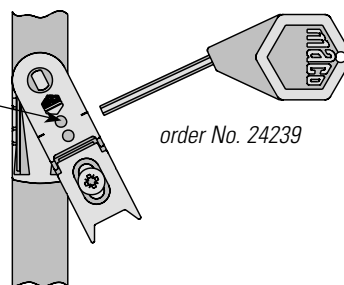
Adjusting the sash lifter

- Slacken screw
- Adjust plate
- Re-tighten screw and open



Re-setting the sash lifter:

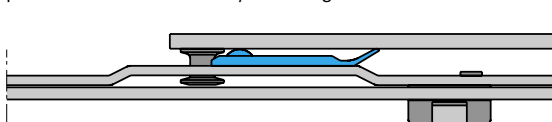
- Press the spring with a 2 mm Allen key
- Move the sash lifter to the other side



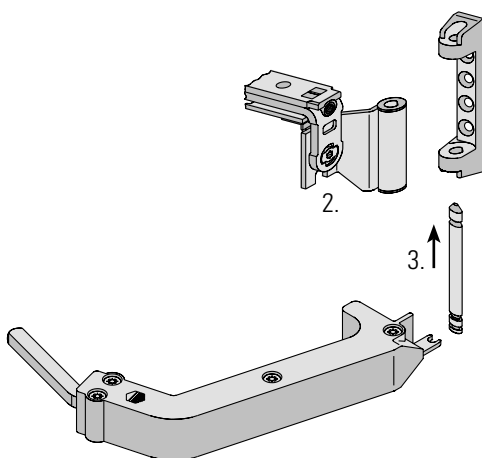
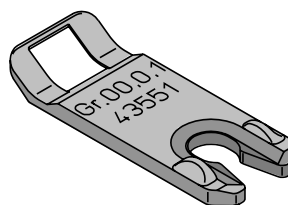
With the correct air gap the max amount of lift that the sash lifter should give is 0.5 mm.

Tilt Restrictor

On windows with a sash rebate height under 600 mm a tilt restrictor must be fitted into the scissor stay this prevents the scissor stay clashing with the frame.



On certain window styles it may be necessary under a SRH of 800 mm.



Hanging the Sash

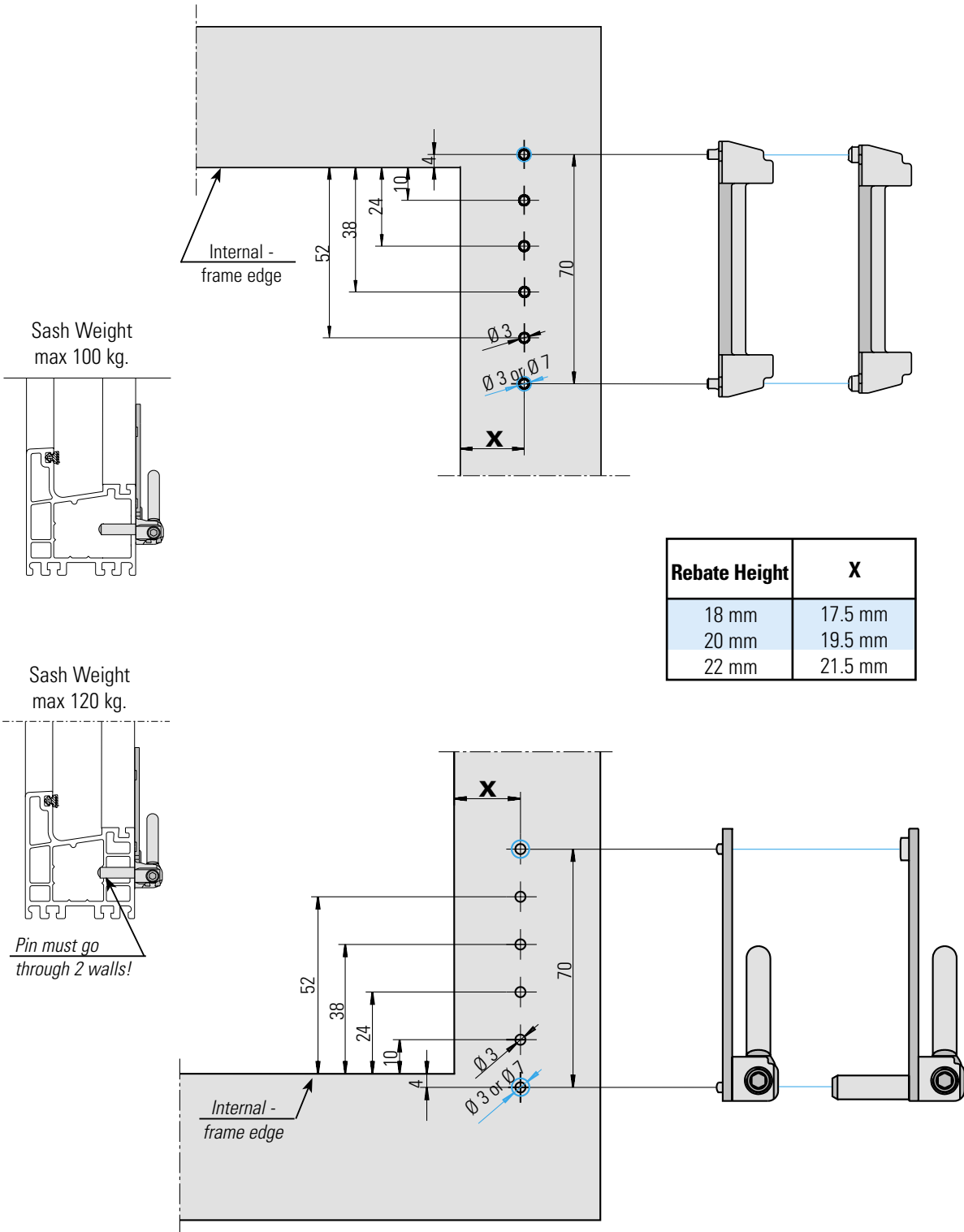
1. Locate the sash onto the bottom hinge.
2. Locate the scissor stay into the top hinge.
3. Insert the spindle bar through the hinge from the bottom.

To simplify the insertion of the spindle, use the end of the blue spindle bar.

Order numbers and size information are available on request

Assembly of Fitting

Hinge Drilling for "MULTI-TREND"

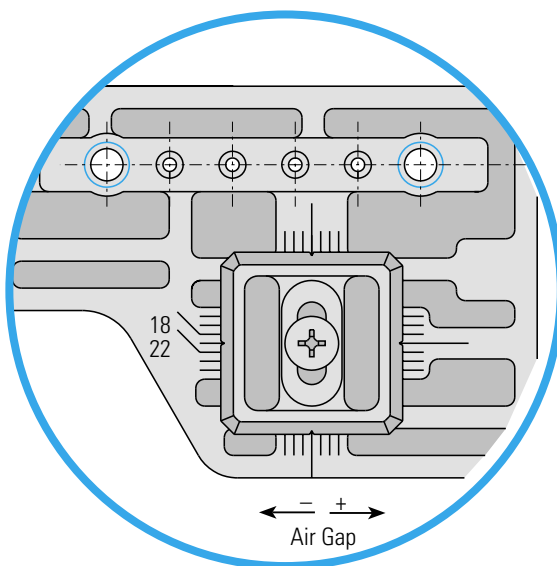


Order numbers and size information are available on request

Hinges onto the Frame

Jig Setting "MULTI-TREND" for TREND Top and Bottom Hinges

Preset for a 20 mm rebate and 12 mm air gap.



No	Drill Jig	Drill Size
28537	for Top and Bottom Hinges, self locating	7 mm
21694	for Top and Bottom Hinges	3 mm
21958	for Top and Bottom Hinges with 7-mm-Pins	7 mm

Procedure:

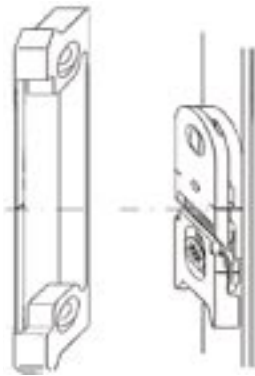
Adjust both blocks on the underside of the jig to match both rebate height and air gap (see above).

Locate jig into the corner and drill holes as required.

The jig is non handed and has a symmetrical drill pattern for both top and bottom hinges.

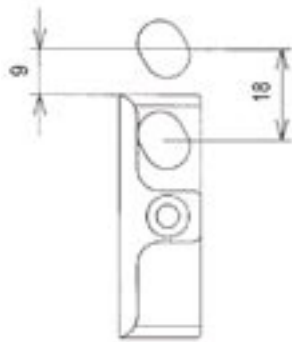
Order numbers and size information are available on request

Striker Plate Manual Location



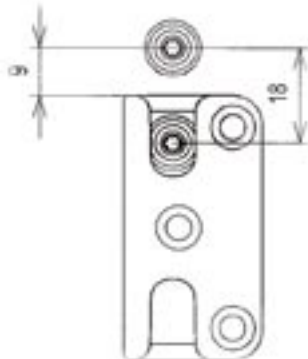
Sash Lifter Striker Plate

1. Ensure that the sash is square in the frame with the correct cover.
2. Transfer the centre line on the sash lifter to the outer frame.
3. Position and fix the sash lifter striker plate onto the frame ensuring that both centre lines correspond with each other.



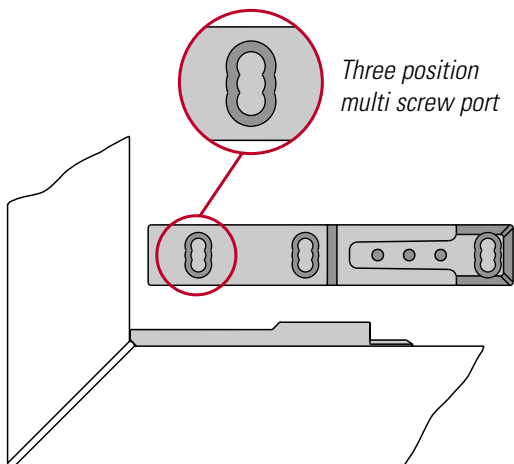
Standard Striker Plate

1. With the locking cams in the central position mark the centre of the cam onto the outer frame.
2. Position and fix the standard striker plate so that the edge of the striker plate is 9 mm away from the centre of the cam.



iS Mushroom Striker Plate

1. With the locking cams in the central position mark the centre of the cam onto the outer frame.
2. Position and fix the iS mushroom striker plate so that the edge of the striker plate is 9 mm away from the centre of the cam.



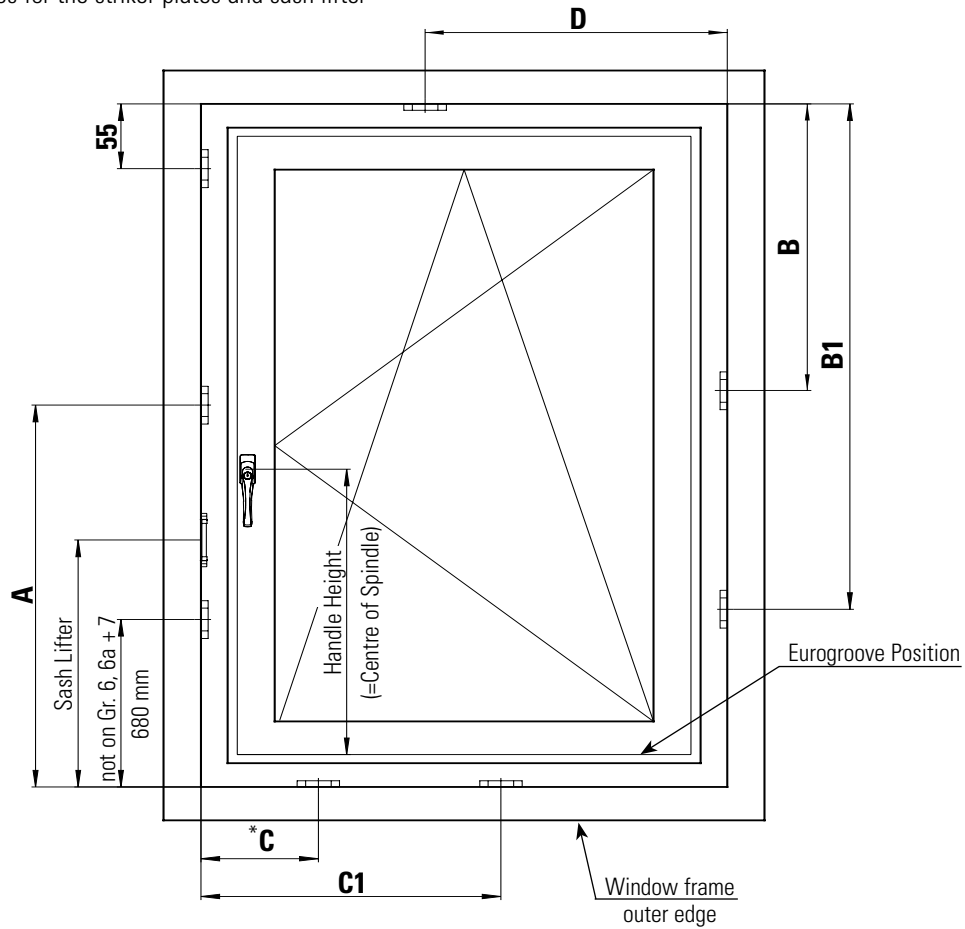
iS Tilt First Striker Plate

1. Locate the striker plate into the bottom corner of the frame as shown.
2. Decide on which of the three multi screw ports is best for your profile system and fix in position.

Order numbers and size information are available on request

Striker Drill Centres

Centre lines for the striker plates and sash lifter

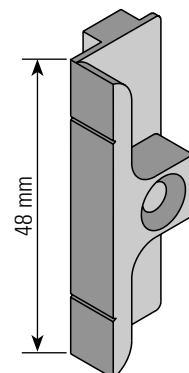


*C = Striker plate for Horizontal Tilt Lock.

TREND Gear Size FHH	SRH	Sash Lifter	A	Handle Height
00	370 – 430	–	–	120
0	431 – 600	–	–	170
1	601 – 800	–	–	300
2	801 – 1000	277	580	400
3	1001 – 1250	377	680	500
4	1251 – 1500	477	780	600
5	1501 – 1750	577	880	700
6A	1751 – 1849	927	1230	1050
6 + 7	1850 – 2350	927	1415	1050

Scissor Stay Size	SRW	D
2	800 – 1050	506
3	1051 – 1300	606
4	1301 – 1500	806
3+Secondary Stay	1401 – 1650	606

Centre Lock Size	SRW / SRH	C	C1	B	B1
00	801 – 1050	152	379	445	–
0	1051 – 1250	152	507	573	–
1	1251 – 1500	152	607	673	–
2	1501 – 1750	152	807	873	–
3	1751 – 2350	132	–	673	1223

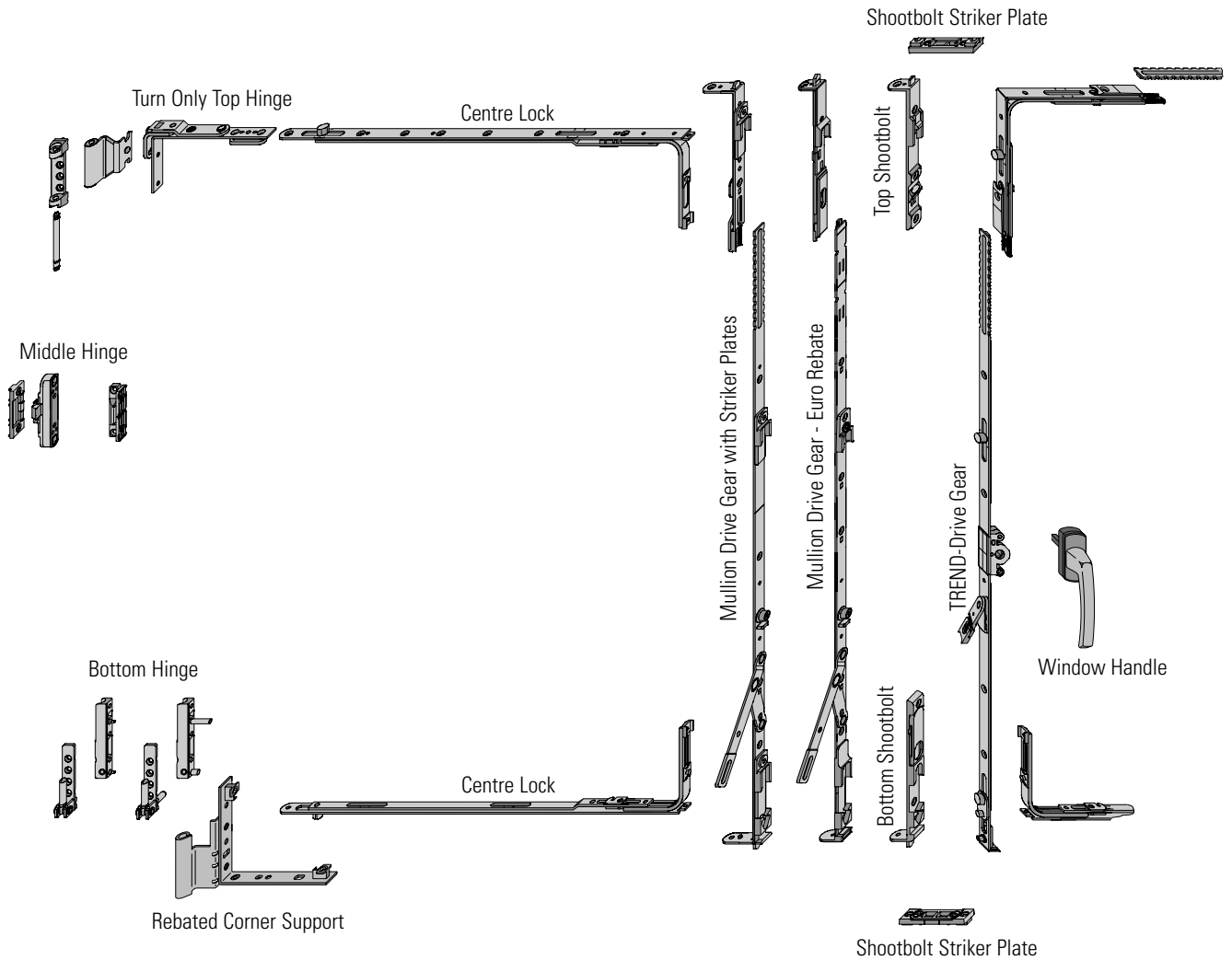


Note:

Striker plate positions relate only to those that have an overall length of 48 mm.

Order numbers and size information are available on request

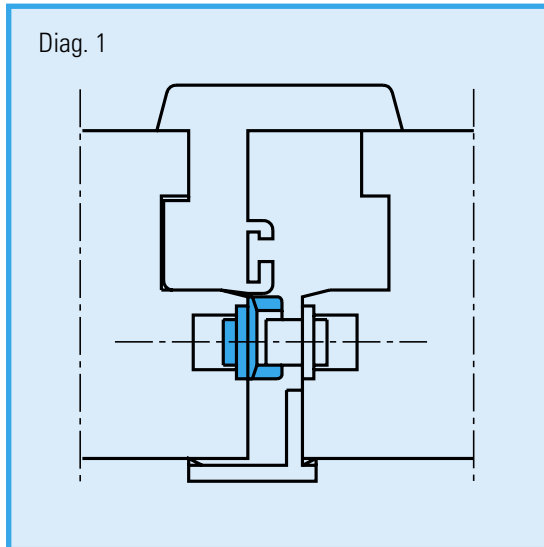
Tilt Turn Fittings for double sash windows



Order numbers and size information are available on request

Installation of 2-Sash Window Fittings

Casement Drive Gear with Mounted Striker Plates

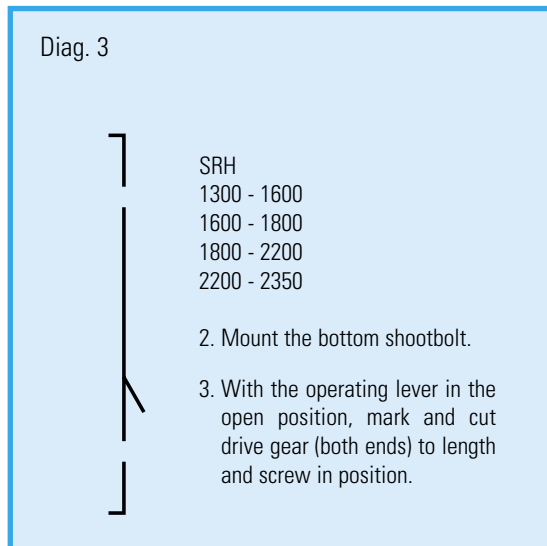
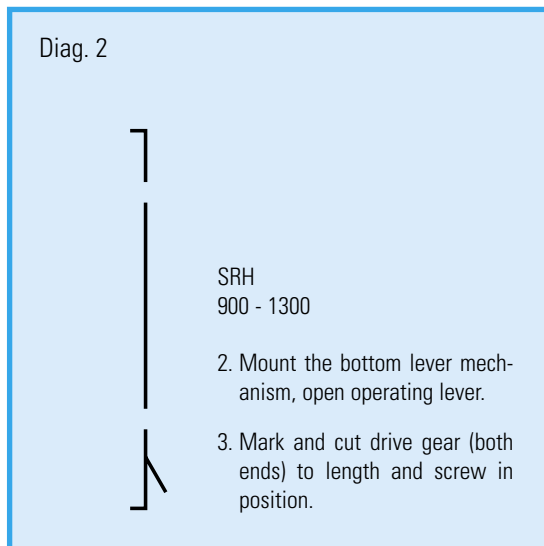


Fitting Instructions – FHH Drive Gear:

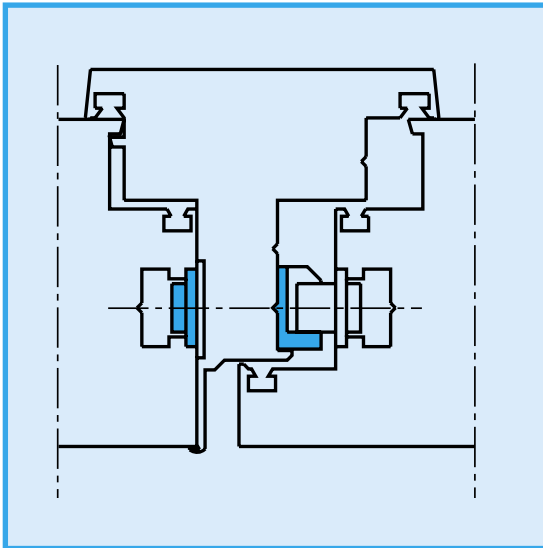
1. Mount the **top shootbolt** (SRW over 800 mm connect with centre lock) and screw in position.
2. Mark and cut drive gear to size to the same length as the T&T drive gear (SRH over 800 mm fit a middle hinge) and screw in position.

Fitting Instructions – VHH Drive Gear:

As with the instructions under FHH drive gear mount the top shootbolt.



Order numbers and size information are available on request



Casement Drive Gear without Striker Plates

Fitting Instructions – FHH Drive Gear:

1. Mount the top shootbolt (SRW over 800 mm connect with centre lock) and screw in position.
2. Mark and cut drive gear to size to the same length as the T&T drive gear (SRH over 800 mm fit a middle hinge) and screw in position.

Instructions for operating Lever

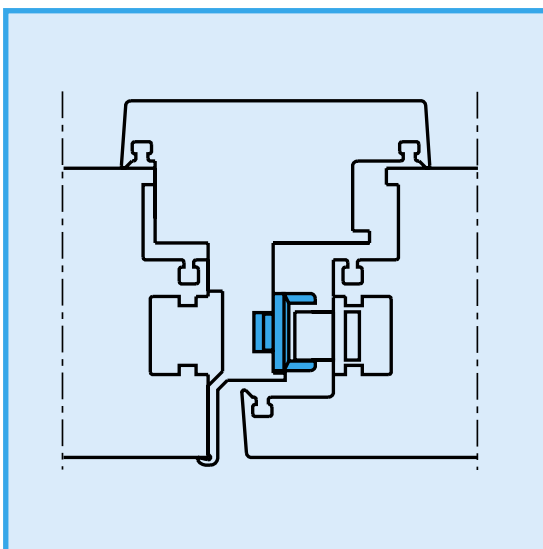
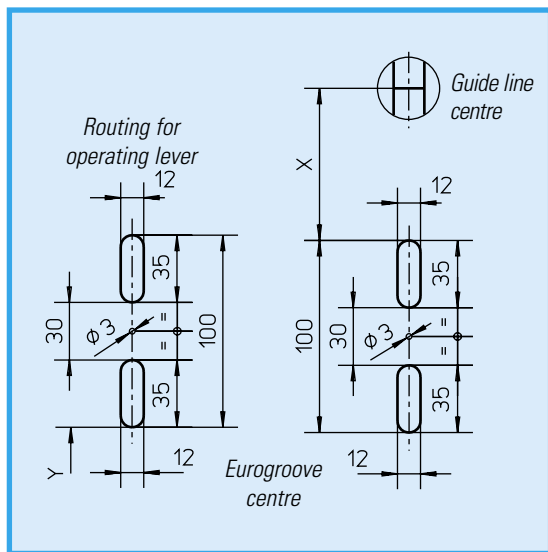
Drive Gear Without Striker Plates

y = 132 mm from Lower Sash Edge by SRH 800 – 1300

x = 235 mm for SRH 1300 – 1800

x = 459 mm for SRH 1800 – 2350

- The false mullion should be machined (as shown) cut the connection lugs to size. With the drive gear in the turn position fit the operating lever.
- Striker plate jig for double sash windows.
Order No. 12754



Casement Drive Gear Face Mounted

1. Mount the **top shootbolt**.
- 1.2 With VHH drive gear mount the bottom shootbolt.
2. Mark and cut the **drive gear** to size, locate and connect. The casement drive gear can now be screwed in position.

Order numbers and size information are available on request

Installation Jigs

1. Std strikes for double sash drive gear.
2. Std strikes for top and bottom shootbolts.

MULTI №	TREND №	Jigs for double sash
12754	10497	FHH
12764	10499	VHH

Installation of Turn Only Hinges

1. Locate and fix turn only hinge in the eurogroove.
2. The turn only stay uses the same hinge as the T&T sash, the sight lines are exactly the same.

Installation of Middle Hinges

Rebate Fixing Middle Hinge:

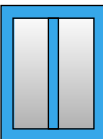
1. Position the sash into the frame.
2. Compress the gaskets by the required amount.
3. Position and fix the middle hinge to the sash and

frame.

Universal Middle Hinge:

Use the sash and frame locating jig No. 50947.

ATTENTION: The sash requires a eurogroove.



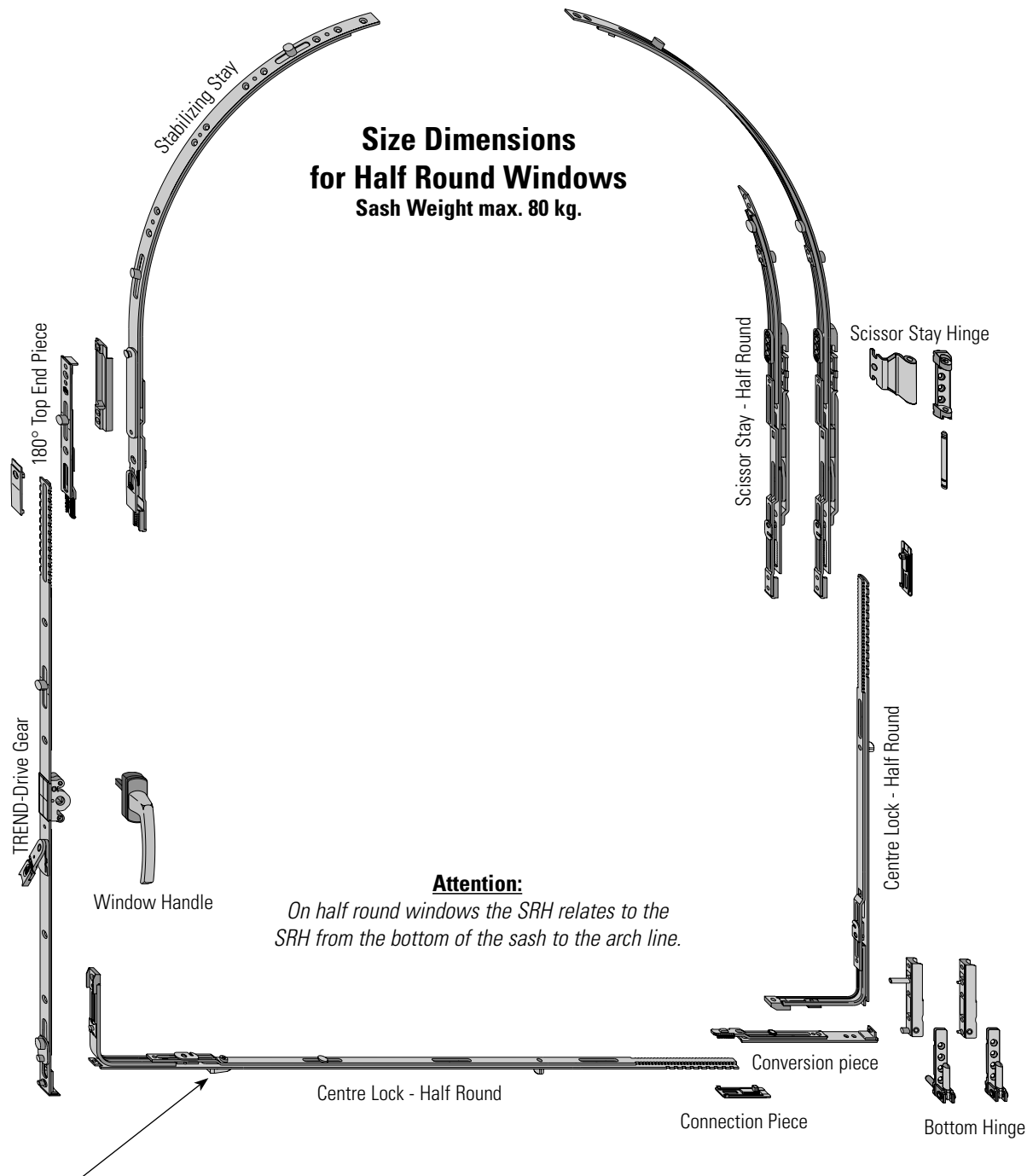
Installation of Shootbolt Striker Plates

Position striker plate to the centre of the frame. Alternatively striker plate jig No. 21398 is available.

Order numbers and size information are available on request

Half Round Fittings

Turn First Only



Attention:
The run up wedge and striker plate are not required with the TREND drive gear!

Order numbers and size information are available on request

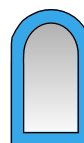
Half Round Size Matrix

	SRW	370 – 620	620 – 850	850 – 1070	1070 – 1250		
SRH		HR Centre Lock Gr. 1 HR End Piece 180° HR Scissor Stay Gr. 1 SRW 500 Stay Gr. 0 2 Std Striker Plates	HR Centre Lock Gr. 2 HR End Piece 180° HR Scissor Stay Gr. 2 3 Std Striker Plates	HR Centre Lock Gr. 3 HR End Piece 180° HR Scissor Stay Gr. 2 4 Std Striker Plates	HR Centre Lock Gr. 4 HR Stabilizing Stay HR Scissor Stay Gr. 2 5 Std Striker Plates		
600 – 390	Basic Carton Drive Gear Gr. 1A (use without HR End Piece 180°) HR Centre Lock Gr. 1	HH 300 <small>bis FFH 500 nur ein Winkeltrieb Gr. 1</small>	HH 750	Sash Weight over 80 kg with 12 mm Glass Thickness. SRW-SRH Conflict.		Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 1 Std Striker Plates	
700 – 600	Basic Carton Drive Gear Gr. 2A (use without HR End Piece 180°) HR Centre Lock Gr. 1	HH 400	HH 400			Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 1 Std Striker Plates	
800 – 700	Basic Carton Drive Gear Gr. 3 (use without HR End Piece 180°) HR Centre Lock Gr. 2 up to SRH 750 Gr. 1	HH 500	HH 500	900		Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 1 Std Striker Plates	
900 – 800	Basic Carton Drive Gear Gr. 4 (use without HR End Piece 180°) HR Centre Lock Gr. 2	HH 600	HH 600	HH 600		Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 1 Std Striker Plates	
1000 – 900	Basic Carton Drive Gear Gr. 5 (use without HR End Piece 180°) HR Centre Lock Gr. 2	HH 700	HH 700	HH 700	1150	Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 1 Std Striker Plates	
1250 – 1000	Basic Carton Drive Gear vhh. Gr. 3* HR Centre Lock Gr. 4 under SRH 1200 Gr. 3 Tilt Lock Bolt	HH 550	HH 600	HH 600	HH 600	Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 2 Std Striker Plates	
1400 – 1250	Basic Carton Drive Gear vhh. Gr. 3* HR Centre Lock Gr. 4 Tilt Lock Bolt	HH 700	HH 700	HH 700	HH 700	Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 2 Std Striker Plates	
1650 – 1400	Basic Carton Drive Gear vhh. Gr. 4* HR Centre Lock Gr. 4 Extension Piece 250 Tilt Lock Bolt	HH 750	HH 750	HH 750	HH 750	1200	Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 2 Std Striker Plates
1830 – 1650	Basic Carton Drive Gear vhh. Gr. 4* HR Centre Lock Gr. 4 Extension Piece 400 Tilt Lock Bolt	HH 900	HH 900	HH 900	HH 930	Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 3 Std Striker Plates	
2050 – 1830	Basic Carton Drive Gear Gr. 6 HR Centre Lock Gr. 4 Extension Piece 600	HH 1050	HH 1050	HH 1050	HH 1050	Pivot Post Corner Support Scissor Stay Hinge Scissor Stay Support Arm 1 Sash Lifter Strike Plate** 1 Tilt Strike Plate 1 Std Striker Plates	

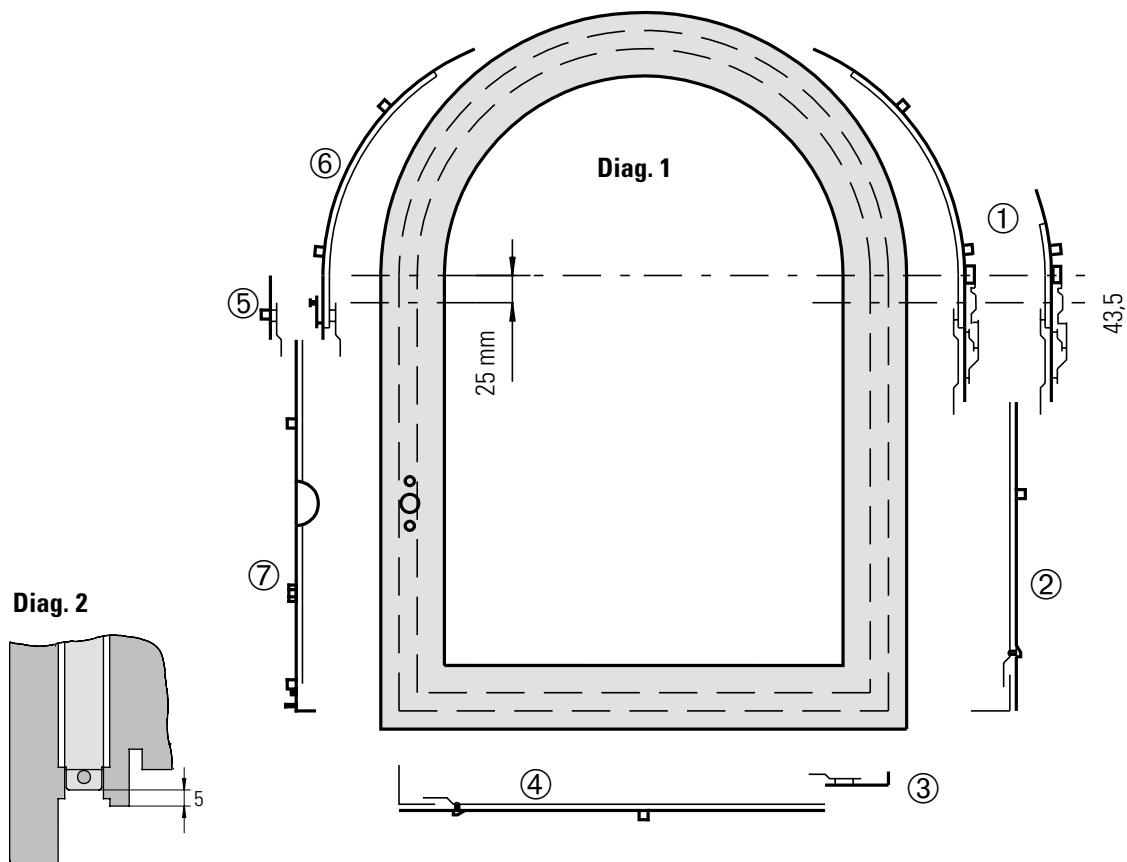
*Remove screw guide on tilt lock bolt.

**Sash lifter strike only required with TREND-Drive Gear.

Order numbers and size information are available on request



Mounting the Fittings onto the Sash



1. Locate the **scissor stay** ① so that the guide line is positioned at the beginning of the arch. Move the stay into the tilt mode to insert all fixing screws and then reset the scissor stay into the turn position.

2. Crop and fit the **hinge side centre lock** ② (over 1450 mm SRH, first fit a gear extension). Ensure that the centre lock locates as shown in Diag. 2.

3. Fit the **bottom conversion piece** ③.

4. Crop and fit the **bottom centre lock** ④ (Diag. 2 & 3).

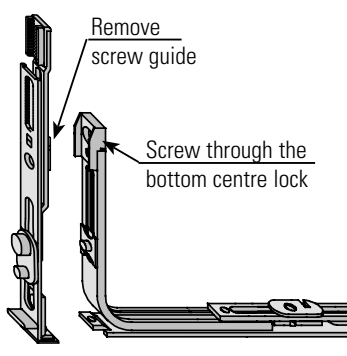
5. Fit the **drive gear end piece** ⑤ or **stabilizing stay** ⑥ (if required). Attention: The guide line must be positioned 25 mm below the start of the arch (Diag. 1)!

6. Crop and fit the **T&T drive gear** ⑦. Attention: Only drive gears that have a sash lifter can be used. For drive gear routing see instructions for single sash windows. Attention: With TREND-Drive Gear activate the sash lifter.

7. For **bottom hinge assembly** (rebate fixing only) see instructions for single sash windows.

8. Position and fit all **striker plates**.

Diag.

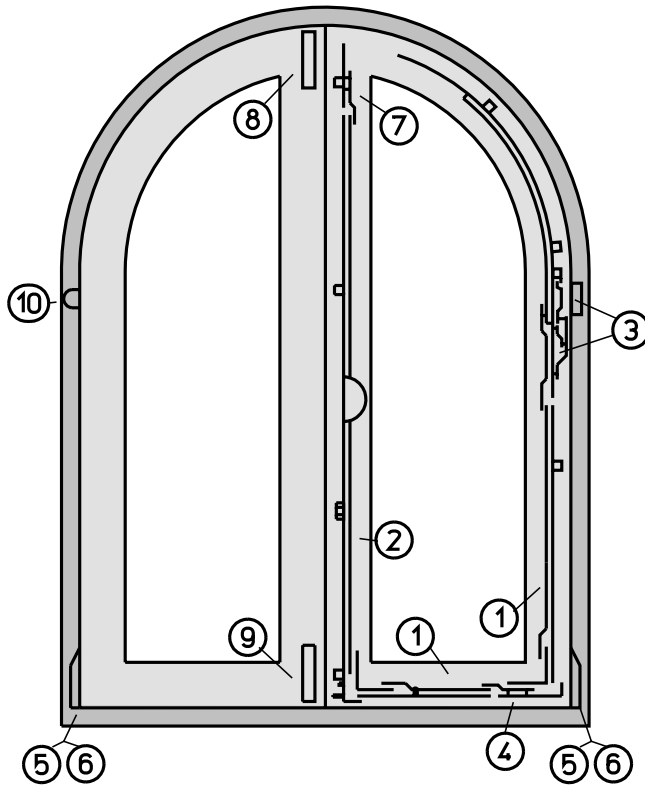


Order numbers and size information are available on request

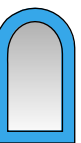
Half Round Windows with Two Sashes

Turn First Only

Measure the SRH to the top of the arch to determine the most suitable drive gear.



- ① centre lock half round
- ② drive gear
- ③ scissor stay – half round (stabilizing stay not suitable)
- ④ conversion piece half round
- ⑤ pivot post
- ⑥ corner support
- ⑦ top end piece half round
- ⑧ shootbolt top
- ⑨ shootbolt bottom
- ⑩ turn only hinge – half round

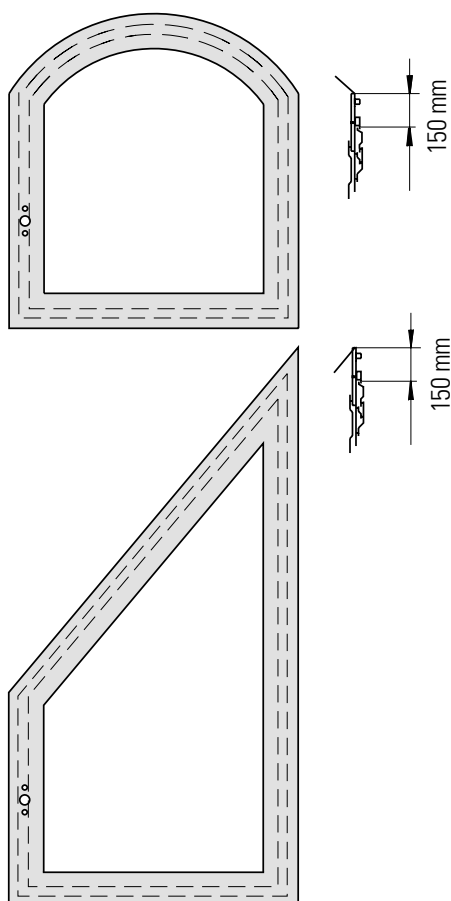


Order numbers and size information are available on request

Half Round Fittings Applied to Sectional and Angled Windows

Sash Assembly

Fitting Instructions see Half Round instructions (Page 22).



Horizontal Top Centre lock

Sectional – and Wide Arch Windows

When the arch length exceeds 1000 mm use the angled window corner element with a 600 mm gear extension to gain a locking point along the arch.

Only scissor stays Gr. 0 & 1 are suitable!

The guide line must be positioned 150 mm below the weld.

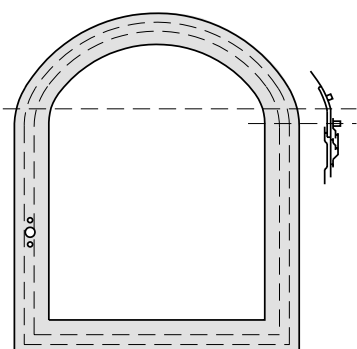
Angled Windows over 50° and under -15°

Only scissor stays Gr. 0 & 1 are suitable!

The guide line must be positioned 150 mm below the corner.

Attention:

No locking points can be positioned along the angle!



Sectional half round window

You can use as a centre lock the half round scissor stay Gr.2 or the half round stabilizing stay.

On segmental or angled windows you can only use the half round scissor stays Gr. 0 or 1.

Note: the range of application is reduced by 150 mm.

Order numbers and size information are available on request

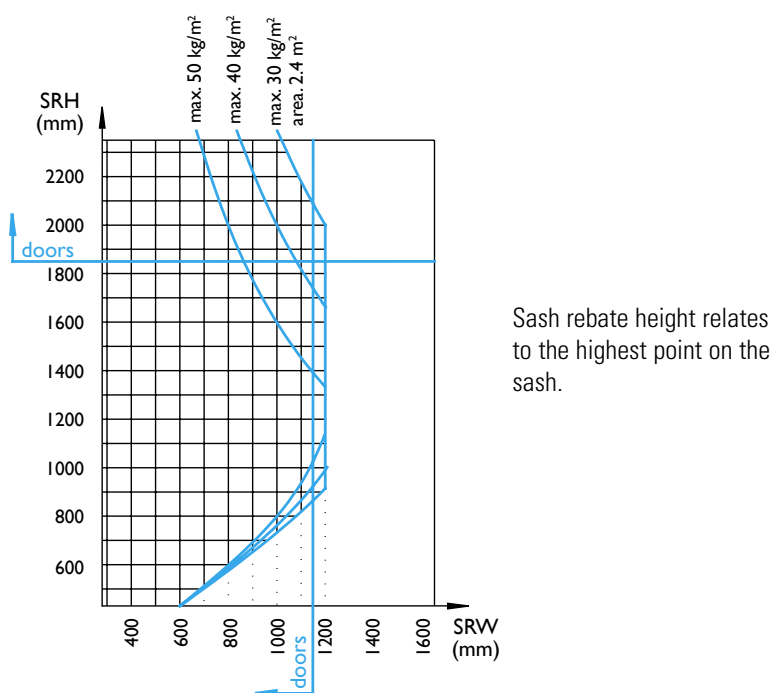
Frame Assembly

Position the striker plates on the curved edge by marking the cam position on the frame. For other striker positions see instructions for single sash windows.

For bottom hinge assembly see instructions for single sash windows. The scissor stay hinge jig must be manually positioned!

Size Dimension

Use of Half Round Scissor Stays on Angled Windows.

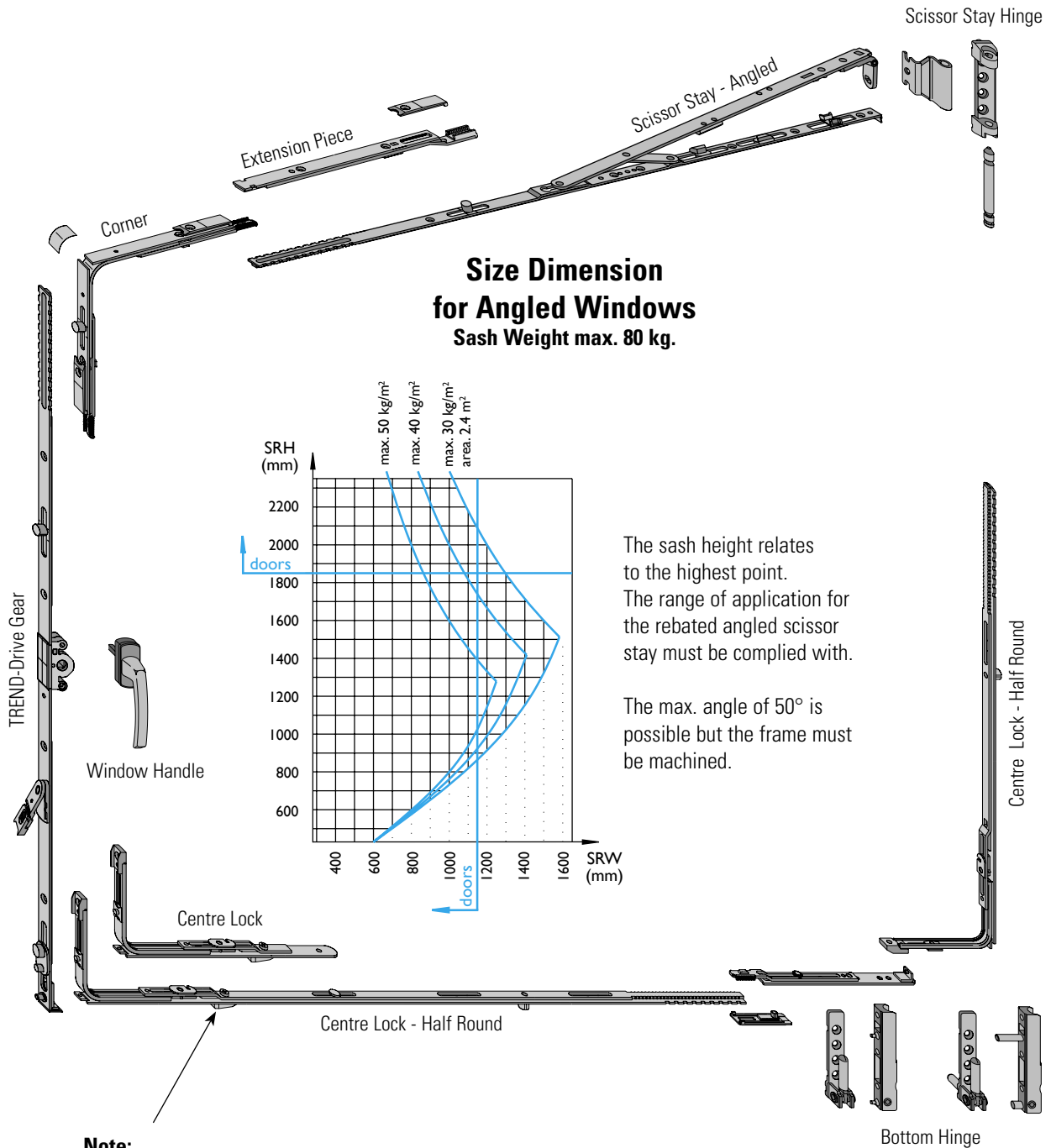


On angled windows from -1° to -15° use the fittings for half round windows (see page 20).



Angled Window Fittings

Turn First Only



Note:
The lifting wedge is not required when using TREND-Drive Gear!

Order numbers and size information are available on request

Table for calculating the scissor stay size

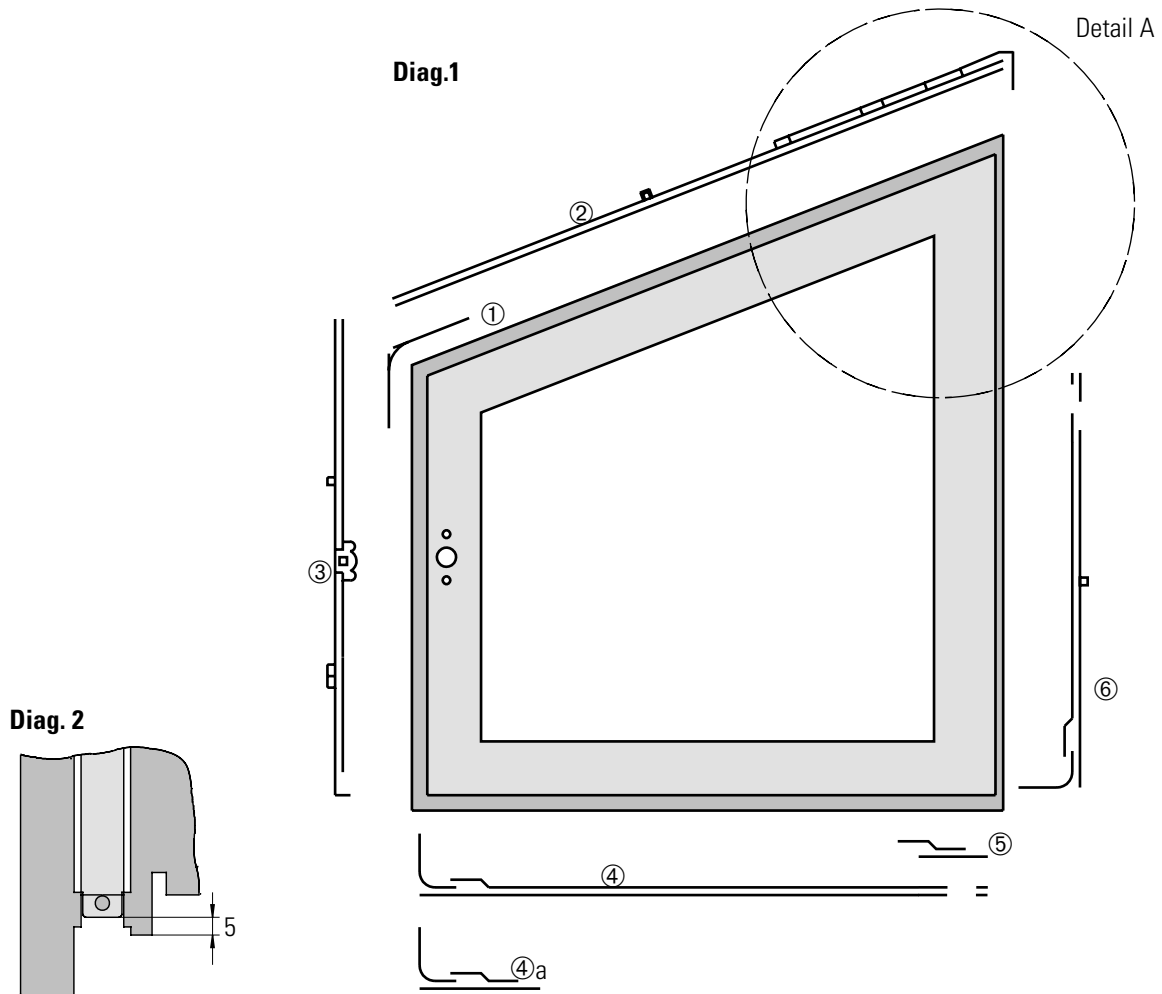
Difference between SRH (Hinge Side) and SRH (Drive Gear Side in mm)																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
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	400	450	500	550	600	650	700	750	800	850	900	950	1000	1050	1100	1150	1200	1250																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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Instructions for use of the table:

738 = length of the angled slope
28,5° = Corner Angle of the window



Order numbers and size information are available on request



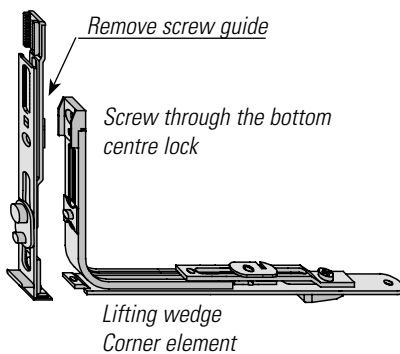
Diag. 2

1. Crop and fit the hinge side **centre lock** ⑥ (if SRH is over 800 mm). Ensure that the centre lock is located as shown in Diag. 2.

2. Fit the **bottom conversion piece** ⑤ (over 800 mm SRH).

3. Crop and fit the **bottom centre lock** ④ (Diag. 2 & 3).

Diag. 3



4. Fit **Corner element A for angled windows** ① adjust it to suit the corner angle!

5. Crop and fit the **T&T drive gear** ③.
Attention: Only drive gears that have a sash lifter can be used.
For drive gear routing see instructions for single sash Windows.

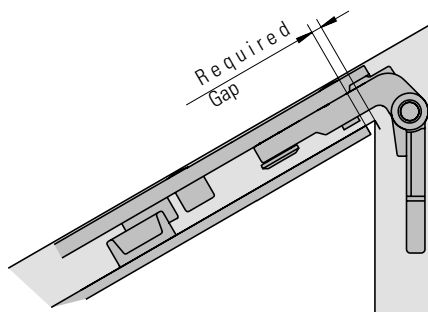
6. Cut and fit **scissor stay** ②.
Attention: For correct positioning of the scissor stay please refer to Detail A.

Order numbers and size information are available on request

to the Sash

Detail A

Gap between edge of stay and eurogroove



For hinge drilling see instructions for single sash windows.

Attention: Centre locks cannot be fitted to the scissor stays for angled windows.

Gap with 12 mm Air Gap			
Stay Angle	Angled Window Scissor Stay	Stay Angle	Angled Window Scissor Stay
50°	0.6 mm	15°	2.5 mm
45°	1.2 mm	10°	2.5 mm
40°	1.7 mm	5°	2.4 mm
35°	2.1 mm	0°	2.3 mm
30°	2.3 mm	-5°	2.0 mm
25°	2.5 mm	-10°	1.8 mm
20°	2.5 mm	-15°	1.4 mm

Turn Only Sash:

Instructions and guidelines for the T&T fittings also apply to turn only fittings (Application, drilling and machining). This also applies to the gap between the edge of the scissor stay and eurogroove.

Required gap between the edge of the scissor stay and sash corner on angled turn only windows.

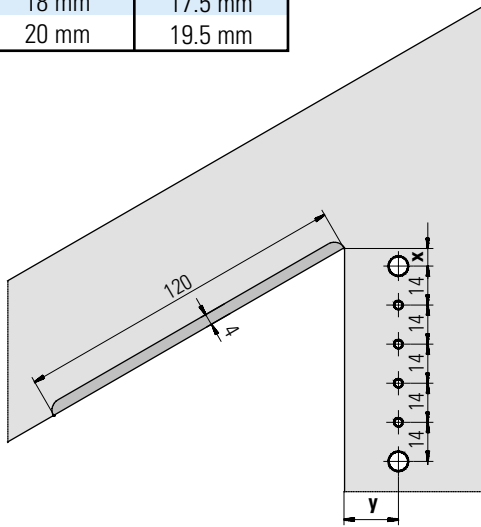
Gap with 12 mm Air Gap			
Stay Angle	Turn Only Angled Hinge	Stay Angle	Turn Only Angled Hinge
50°	12.1 mm	15°	14.0 mm
45°	12.7 mm	10°	14.0 mm
40°	13.2 mm	5°	13.9 mm
35°	13.6 mm	0°	13.8 mm
30°	13.8 mm	-5°	13.5 mm
25°	14.0 mm	-10°	13.3 mm
20°	14.0 mm	-15°	12.9 mm



Order numbers and size information are available on request

Scissor Stay Hinge Drilling

Rebate Height	Dim. Y
18 mm	17.5 mm
20 mm	19.5 mm



Stay Angle	Dim. X with 12 mm Air Gap	Stay Angle	Dim. X with 12 mm Air Gap
50°	15.2 mm	15°	3.8 mm
45°	12.4 mm	10°	3.1 mm
40°	10.1 mm	5°	2.5 mm
35°	8.3 mm	0°	2.1 mm
30°	6.9 mm	-5°	1.8 mm
25°	5.6 mm	-10°	1.5 mm
20°	4.6 mm	-15°	1.4 mm

The maximum angle is 50°. Remove the front edge of the profile to a depth of 4 mm as shown. This ensures that the scissor stay does not

Assembly of Sash and Frame

Application for Scissor Stay Drill Jig:

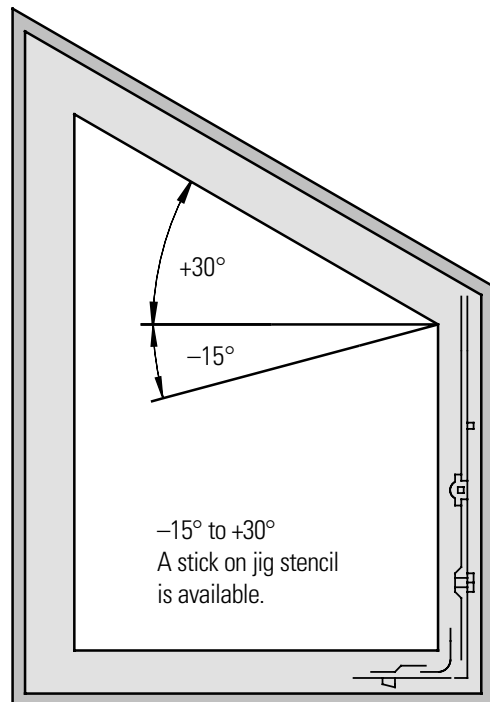
The drill jig can be used with slope angles between -15° and 30°. For windows with a slope angle greater than 30° remove the locating blocks from the jig and position it so that it aligns as shown above.

Attention!

If the jig cannot be located as specified do not compensate by removing the yellow blocks, use spacer bars to reposition the jig in the correct position.

Attention!

The range of application for the rebated scissor stay must be complied with. The max. angle of 50° is possible but the frame must be machined. For drilling the corner support see instructions for single sash windows.



Position the **striker plate** on the angled edge by marking the cam position on the frame. For other striker positions see instructions for single sash windows.

For **bottom hinge** assembly see instructions for single sash windows. The scissor stay hinge jig must be manually positioned!

Order numbers and size information are available on request



MACO-GROUP

MACO-FITTINGS

TECHNOLOGY IN MOTION

Head Office

Austria:
MAYER & CO.
BESCHLÄGE GMBH

A-5020 Salzburg
Alpenstraße 173
Tel.: +43 (0)662 6196-0
Fax: +43 (0)662 6196-101
e-mail: maco@maco.at
<http://www.maco.at>



Subsidiaries

Germany:
MACO-BESCHLÄGE
GESELLSCHAFT M.B.H.

D-94508 Schöllnach
Haidhof 3
Tel.: +49 (0)9903 9323-0
Fax: +49 (0)9903 9323-199
e-mail: d-maco@maco.de
<http://www.maco.de>



United Kingdom:
MACO DOOR & WINDOW
HARDWARE (U.K.) LTD

Eurolink Industrial Centre, Castle
Road, Sittingbourne Kent, ME10 3LY
Tel.: +44 (0)1795 433900
Fax: +44 (0)1795 433901
e-mail: maco@macouk.net
<http://www.macouk.net>



Italy:
MAICO SRL

I-39015 S. Leonardo i.P.
Zona Artigianale 15
Tel.: +39 (0)473 651200
Fax: +39 (0)473 651300
e-mail: maico@maico.com
<http://www.maico.com>



Holland:
MACO-BESCHLÄGE B.V.

NL-7021 BN Zelhem
Stikkenweg 60
Tel.: +31 (0)314 622627
Fax: +31 (0)314 623649
e-mail: info@maco-nl.nl
<http://www.maco-europe.com>



Poland:
MACO POLSKA
SP. z o.o.

PL 42-677 Czekanów k/Gliwice
Ul. Gliwicka 1a
Tel.: +48 (0)32 3050904
Fax: +48 (0)32 3050901
e-mail: maco@demo.pl
<http://www.maco-europe.com>



www.maco-europe.com

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