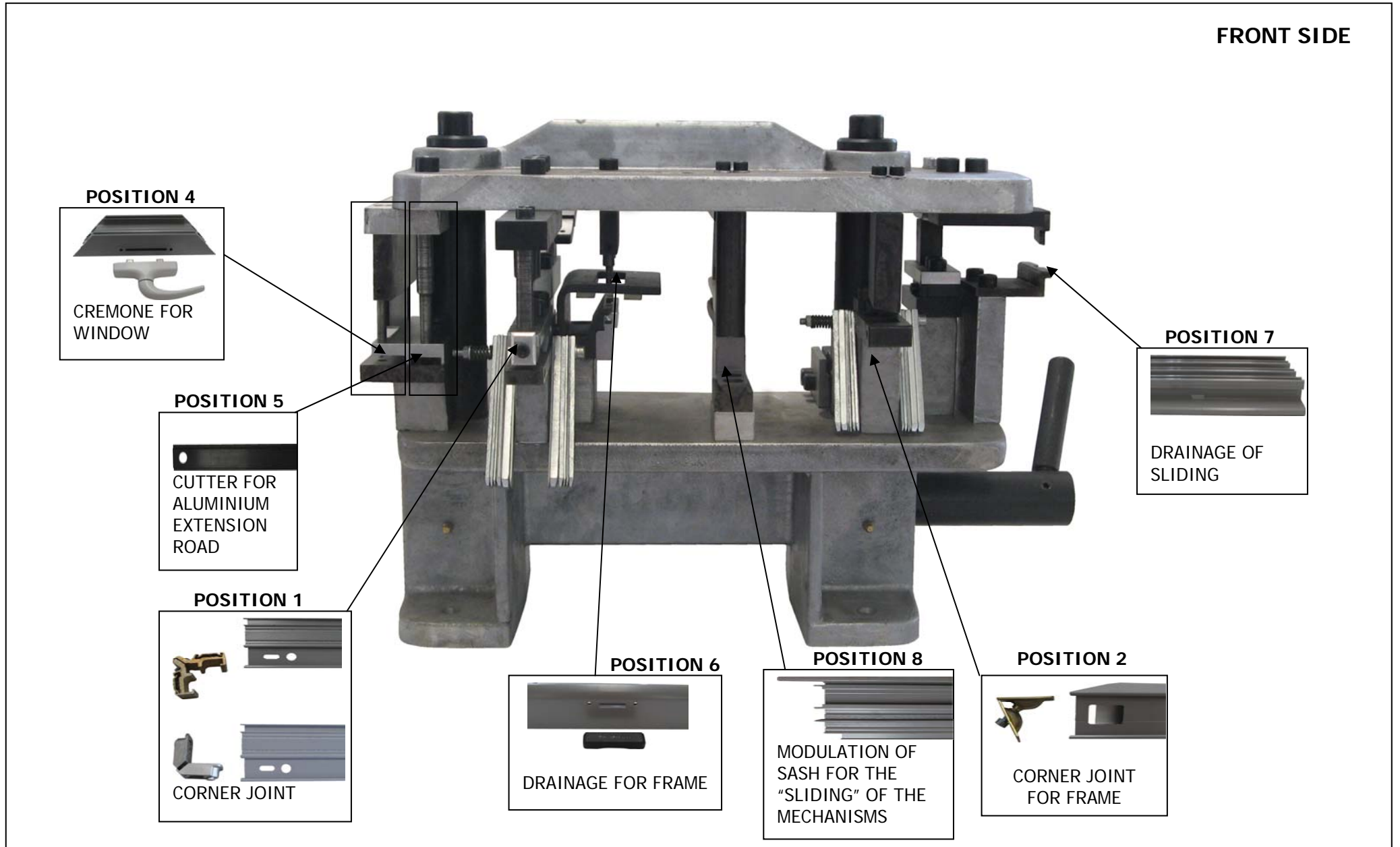


MANUAL OF PRESS

AT038-102-07

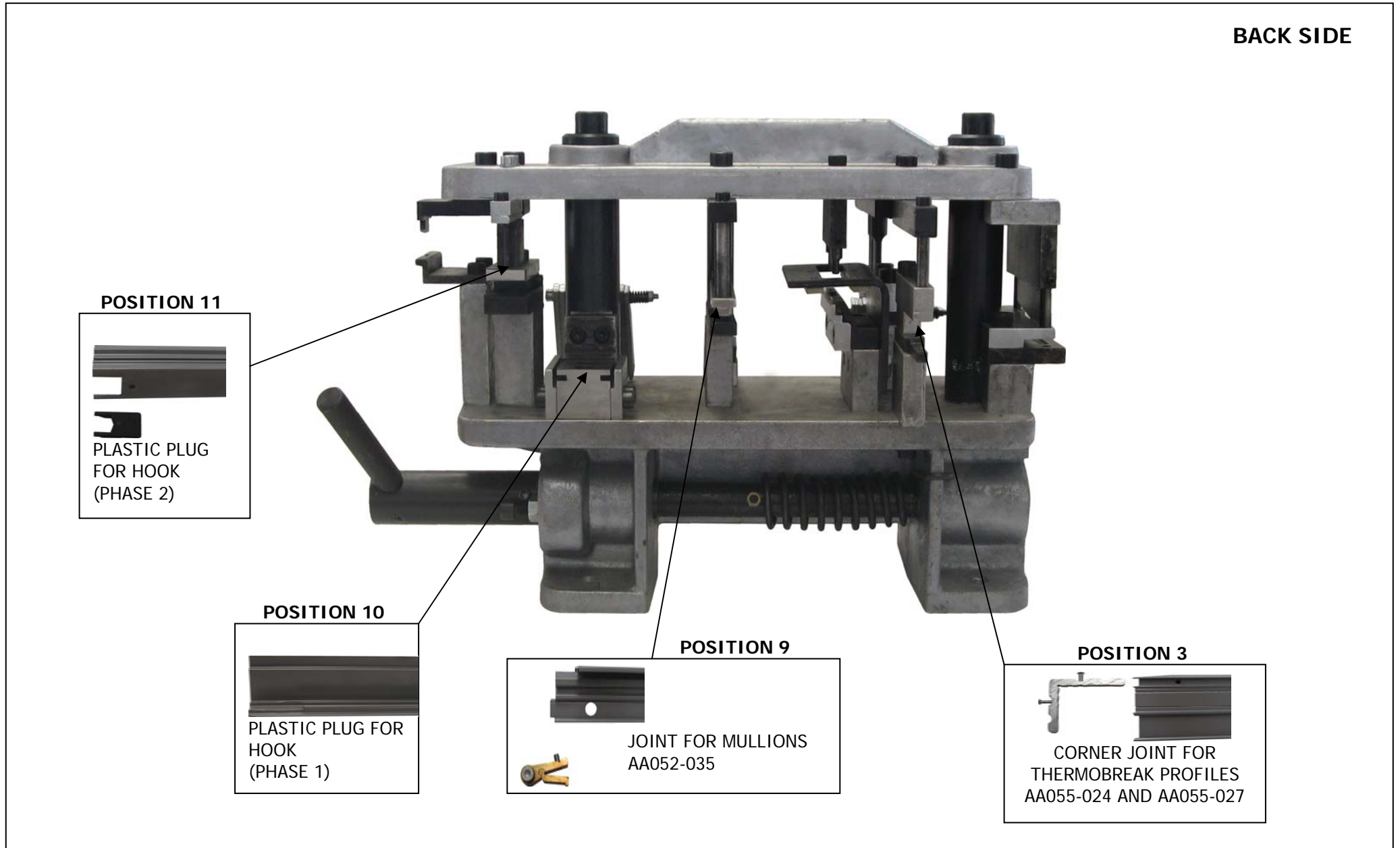
FRONT SIDE



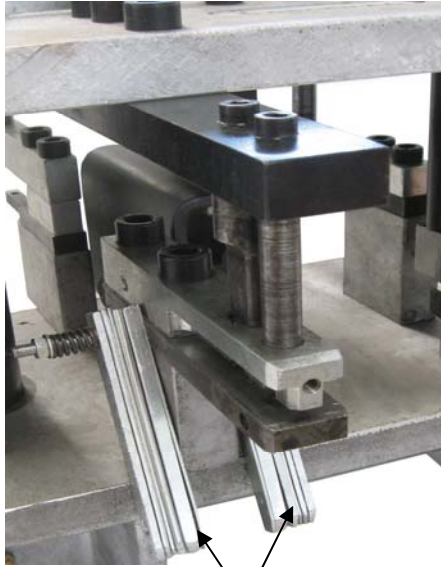
MANUAL OF PRESS

AT038-102-07

BACK SIDE



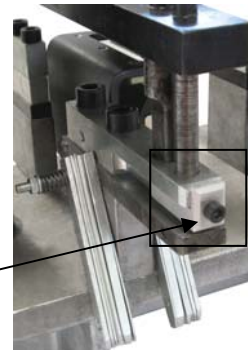
CONFIGURATION OF PROFILE FOR CORNER JOINT- POSITION 1



Because the chamber of profiles differs we use spacers in order that the configuration becomes in the desirable position.

At this cutter we form the profile (frame or sash) in order to place the corner joint. When we want to form sash of PR-52 or sash of PR-26, PR-32, PR-35, we place an additional part in the front side of cutter, as shown in the following picture. The particular additional part is adapted with screw in cutter.

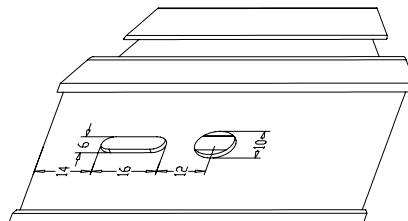
additional part
for alignment of
sash profiles



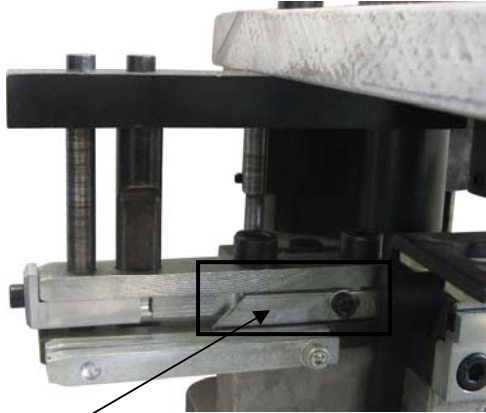
We cut the profile at a corner of 45°. The chamber enters in the cutter as shown in the next photograph.



The final configuration and the needed dimensions are shown at the next pictures.



CONFIGURATION OF PROFILE FOR CORNER JOINT- POSITION 1

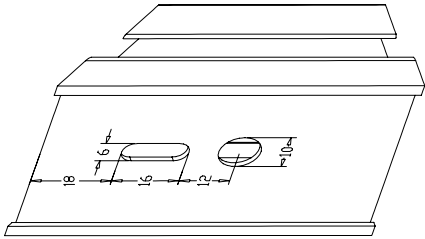


spacer

We use a spacer for corner joints AA032-022, AA043-032, AA052-017, AA052-628, AA055-018. We move the spacer 4mm further in order to make the appropriate configuration.



The final configuration and the needed dimensions are shown at the next pictures.



CONFIGURATION OF PROFILE FOR CORNER JOINT FOR FRAME-POSITION 2



At the particular cutter we form the profile (frame) in order to become the configuration to be placed the corner joint AA052-119.

Because the chamber of profiles differs we use spacers in order that the configuration becomes in the desirable position.



The profile is placed according to the photograph with the chamber enters in the holder of the cutter.



In the next picture are shown the final configuration of profile and the corner joint AA052-119.

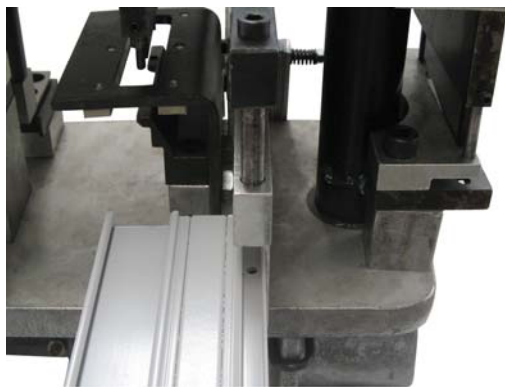
CONFIGURATION OF THERMOBREAK PROFILES FOR CORNER JOINT AA055-024 AND AA055-027-POSITION 3



At this cutter we form the profile (frame or sash) for placing the corner joint in thermobreak profiles. At frame for top-hung outward opening window 50-601 we change the base of the cutter and replace it with the base in the picture below.



Base of cutter for 50-601



The profile is placed according to the photograph with the chamber enters in the holder of cutter.



The final configuration of profile is shown at the picture as well as the corner joint for thermobreak profiles.

CONFIGURATION OF PROFILE FOR CREMONE-POSITION 4



At this cutter we form the profile (sash) in order to make the holes that we will place the chermone.



The profile is placed according to the picture and the configuration is made on the external wing of profile.



The final configuration of the sash is shown at the picture, as well as the chermone that is adapted on the sash.

CONFIGURATION OF ALUMINIUM EXTENSION ROAD- POSITION 5



With this cutter we form the aluminium extension road in order to become the suitable configuration at the end of extension road.

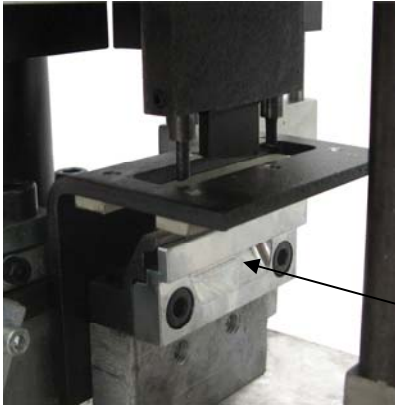


The profile is placed according to the photograph in order to become the desirable configuration at the aluminium extension road.

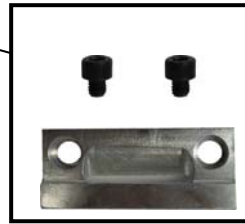


At the next picture is shown the final configuration of extension road.

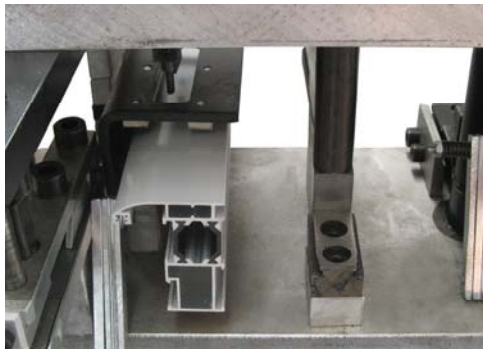
CONFIGURATION OF PROFILE FOR DRAINAGE FOR FRAME-POSITION 6



At this cutter we form the profile to be made the configuration to place the plastic plug AA052-554. We use the additional part for flat frames and flat T-profiles of thermobreak profiles, and we use the cutter without the additional part for the others frames.



additional part



The profile enters in such way that the wing suits in the holder of cutter and the chamber be under, as it appears at the photograph.



The configuration of frame with the drainage AA052-554, are shown at the picture.

CONFIGURATION OF SLIDING PROFILE FOR DRAINAGE- POSITION 7



At this cutter we make the configuration at the drivers of sliding profiles for drainage.



The driver is placed according to the picture, enters between the base of cutter and the cutter.



final configuration of
profile for drainage.

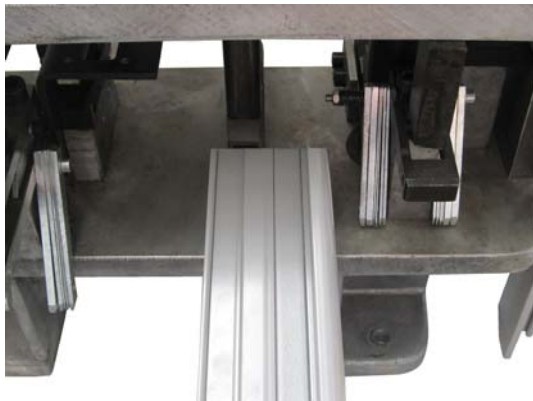
In the next picture is shown the configuration of profile.

MODULATION OF SASH FOR THE SLIDING OF THE TILT-TURN MECHANISMS-POSITION 8

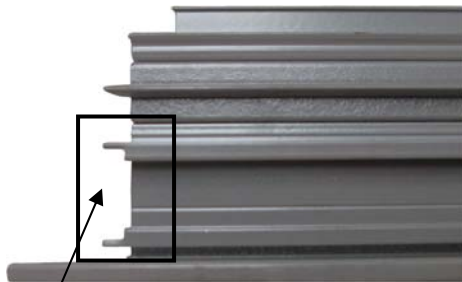


lower base

With this cutter we make the modulation of the profile (sash) for the sliding of tilt-turn mechanisms. We form the edge of camera so that we can place the appropriate accessories.

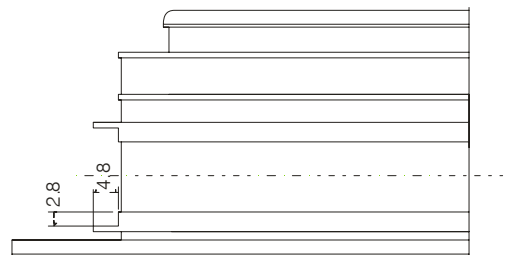


We place the profile as at the picture. The camera must lay at the lower base of the cutter.



configuration of profile

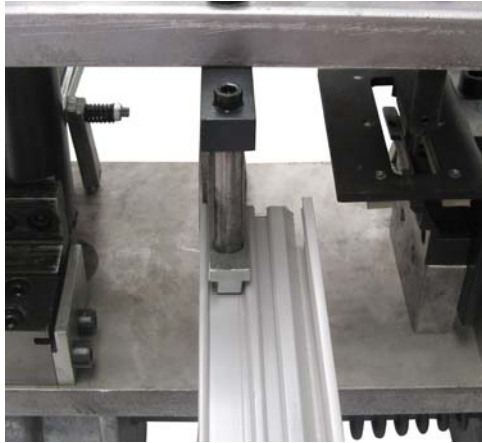
At the next pictures are shown the configuration of profile and distances.



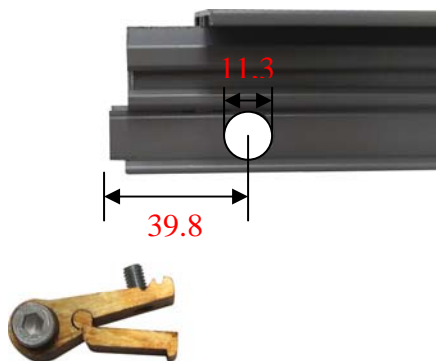
CONFIGURATION OF T-PROFILE FOR JOINT-POSITION 9



At this cutter we place the profile (T-profile) in order to become the configuration to be placed the joint AA052-035.

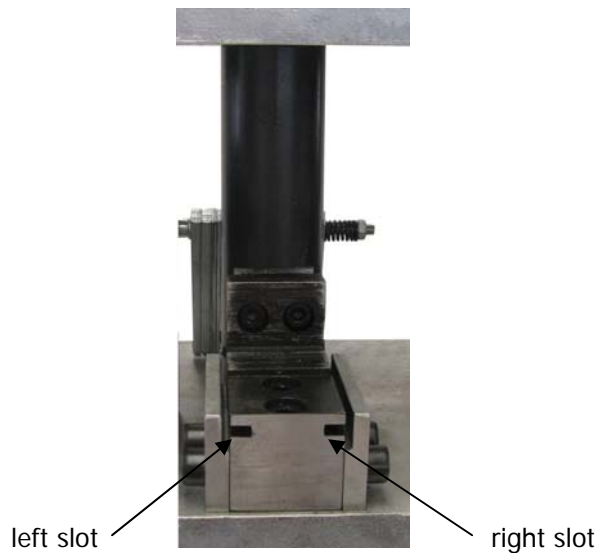


The profile must be machined in an end milling machine before the operation. The profile is placed according to the next picture with the chamber enters in the lower holder of the cutter.



The final configuration of T-profile is shown at the picture with the accessory. At the picture also are shown, the distance from the end of the profile up to the centre of circle (hole) as well as the diameter of hole.

CONFIGURATION OF PROFILE FOR PLASTIC PLUG (PHASE 1) - POSITION 10



At this cutter we make the first configuration at the profile (hook) of the system PR-26 in order to place the plastic plug AA206-015. This cutter is constituted by two slots, which make the same configuration in corresponding sides of profile.



The hook enters in the cutter as it appears at the picture.



The next picture shows the firstly configuration of profile.

CONFIGURATION OF PROFILE FOR PLASTIC PLUG (PHASE 2)-POSITION 11



At this cutter we place the profile (hook) in order to become the final configuration for the plastic plug.



We place the profile as it appears at the next picture.



At the photograph is shown the final configuration of hook as well as the plastic plug.