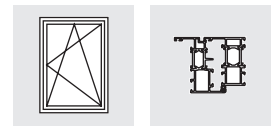
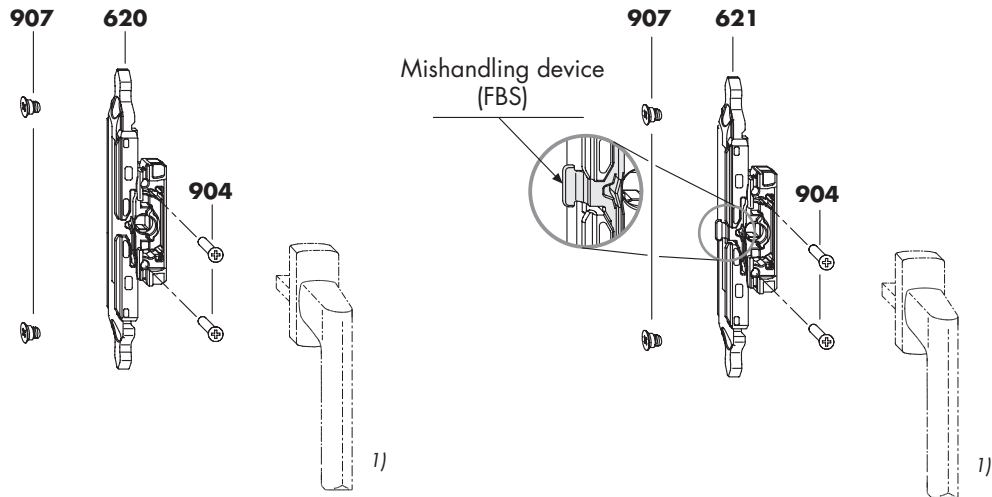


ALU accessories



Gearset M6 Gearset FBS M6

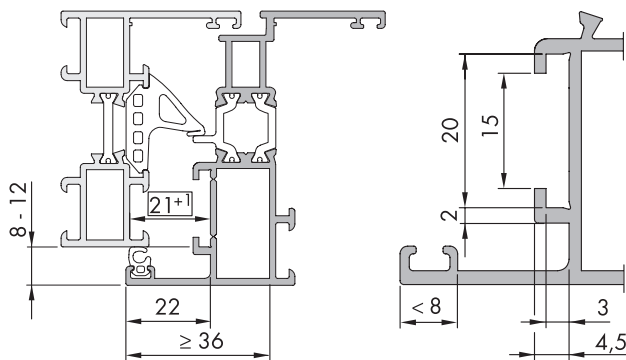


Pos.	Qty.	Description		Material no.		Material no.
	1	Gear set M6 Trial/RR	1	MMGI0090-100010	20	MMGI0090-100030
904	2	Countersunk screw M5 x 35				
620	1	ESG ALU M6				
907	2	Coupling screw M6				
	1	Gear set FBS M6 Trial/RR	1	MMGI0080-100010	20	MMGI0080-100030
904	2	Countersunk screw M5 x 35				
621	1	ESG ALU FBS M6				
907	2	Coupling screw M6				

1) use commonly available window handle (□7 mm x 25 mm, cam Ø 10 mm)

Section suggestion

For section processing dimensions, see page 3



This dimensional specification of the eurogroove for aluminium windows and doors is valid for the accessories to the SIEGENIA fittings.

In addition the system manufacturers specifications must be observed.

Always check the planning manual on aluminium (H4006.3042EN) for further details and specifications/information regarding the product and liability (guidelines: VHBH, TBDK and VHBE).

Contents

Layout of fittings, part list,	
Section suggestion.....	Page 1
Assignment, abbreviations.....	Page 2
Installation procedure, dimensions.....	Page 3
Jigs and punching machines.....	Page 4

Installation instructions

H48.ZUBHLS005en

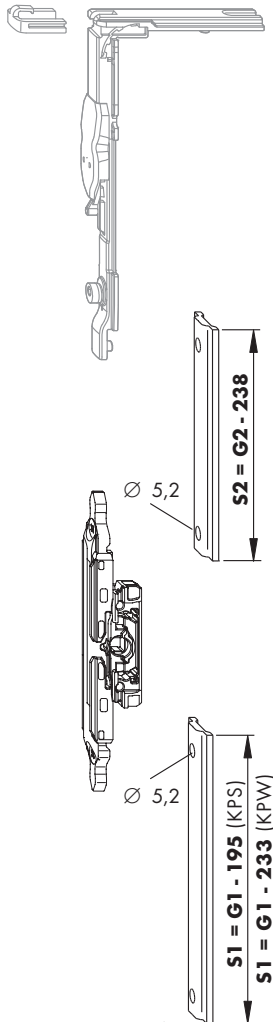
H48.ZUBHLS005en/0

Gear set M6 / FBS M6 - Assignment to gear set and abbreviations

Gear set M6

(see items 2-4 on page 1)

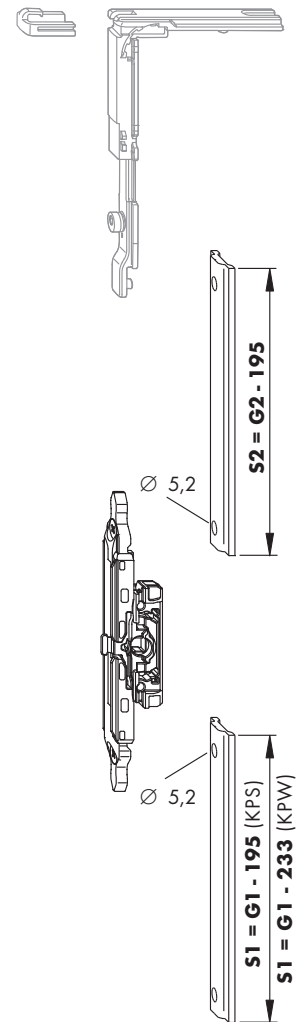
Installation variants
 VS LM-DK FBS-EUL KPS
 VS LM-TBT FBS-EUL KPS
 VS LM-DK-TBT FBS-EUL KPW



Gear set FBS M6

(see items 5-7 on page 1)

Installation variants
 VS LM-DK FBS-G KPS
 VS LM-TBT FBS-G KPS
 VS LM-DK-TBT FBS-G KPW



Abbreviations

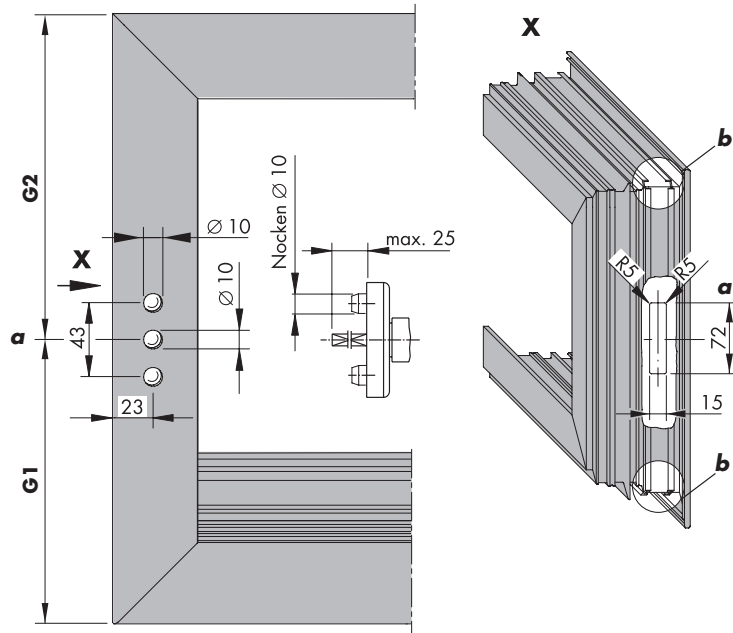
The following abbreviations are used in these assembly instructions:

b	Sash height	PZ	Screwdriver size
b1	Handle height, bottom	TBT	Tilt before turn
b2	Handle height, top	VSO	Locking side, top
DK	Tilt and turn	VSU	Locking side, bottom
FBS	Mishandling device		
FBS-EUL	Mishandling device in corner drive	S1	Operating rod, locking side, bottom
KPS	Tilt point vertical	S2	Operating rod, locking side, top
MV	Centre lock		
Nm	Torque in Nm		

Gear set ALU M6 / ALU FBS M6 - Installation procedure and dimensions

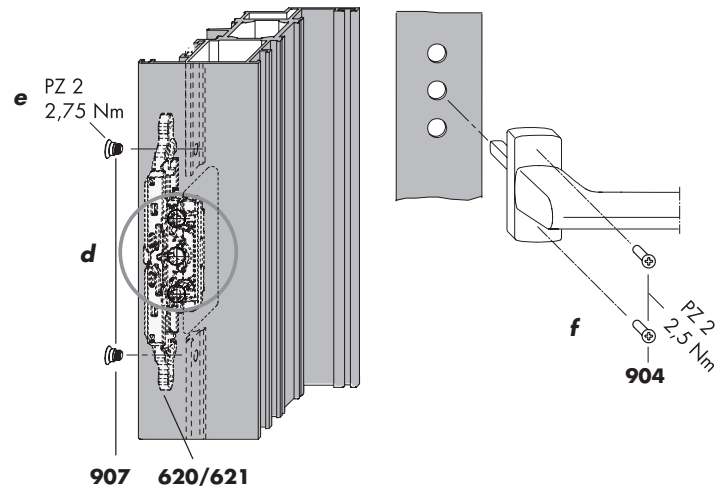
Preparation

- a** Perform section processing for window handle (1) (Figures 1+2).
- b** Open operating rod guiding groove. (Figure 2).
- c** Process operating rods S1 and S2 according to instructions on page 2.



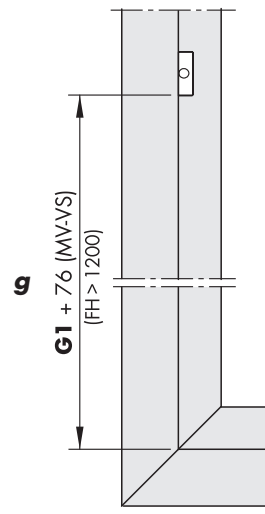
Sash

- d** Insert ESG ALU M6 / ESG ALU FBS M6 (620/621) into the processed section 72 x 15 (Figure 3).
- e** Screw SG ALU M6 / ESG ALU FBS M6 (620/621) in operating rod punch hole Ø 5.2 using coupling screw M6 (907) (PZ 2, torque 2.75 Nm ± 0.25 Nm) (Figure 3).
- f** Screw on window handle using countersunk screws M5 x 35 (904) (PZ 2, torque 2.5 ± 0.25 Nm) (Figure 4).



Frame

- g** At FH > 1250 mm, position striker according to the dimensions (Figure 5) and fix in place using grub screws (key dimension 2.5, torque 1.5 ± 0.25 Nm).



Gear set M6 / FBS M6 - Jigs and punching machines

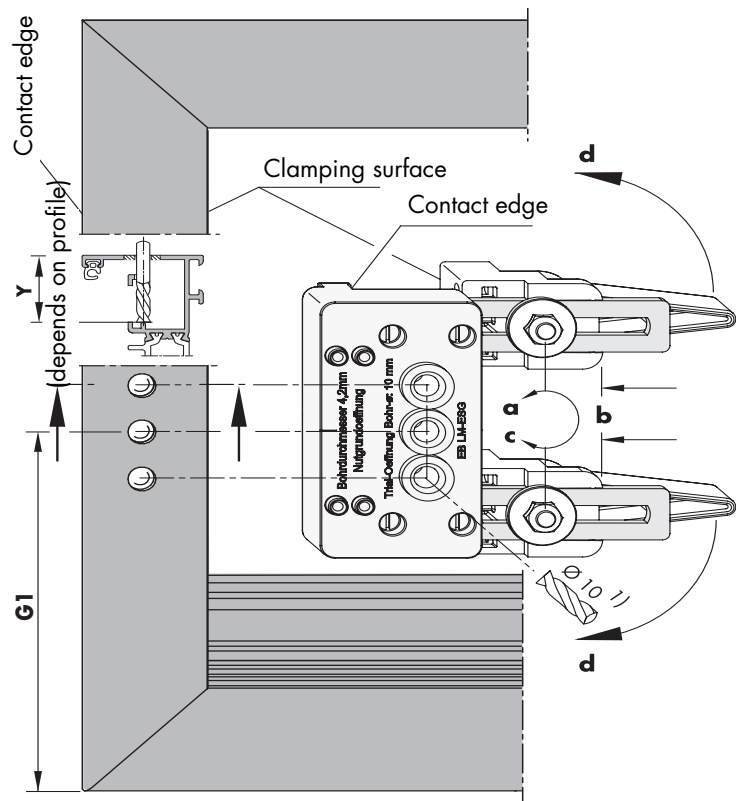


Figure 6

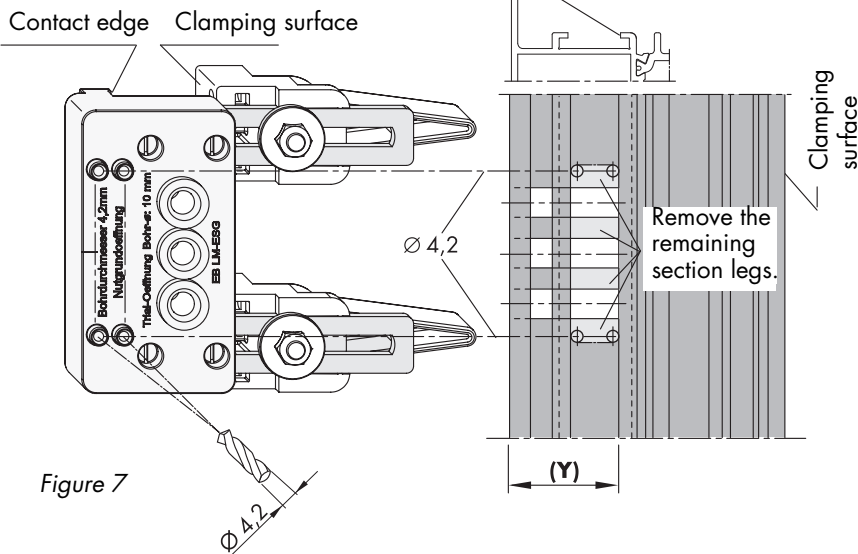


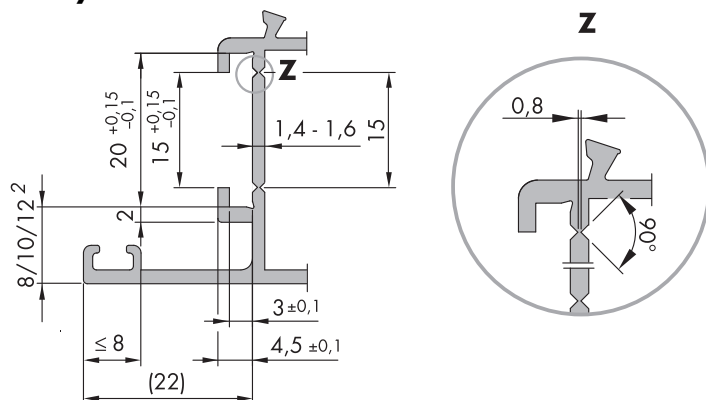
Figure 7

Description		Material no.
Jig Trial ALU-ESG	consisting of:	
	1	MMAH0010-000010
• Jig EB Trial ALU-ESG	1	
• Slot drill ¹⁾ $\varnothing 10$ mm	1	ZAWE0050-00010

Installation procedure for jig Trial ALU-ESG (Figures 6 + 7)

- Loosen nuts on the clamping devices.
 - Position jig according to dimension b1 and slide clamping devices on to the sash section (take account of contact edge).
 - Tighten nuts on the clamping devices.
 - Turn and fix the handles on the clamping devices as shown in the following figures.
- Perform processing.
 - After processing, release the handles on the clamping device and remove jig.

Section suggestion for press cut in the hollow cavity



Punching machine²⁾	1	on request
For 3 x $\varnothing 10$ and $\square 70 \times 15$ (See Figures 1 and 2 on page 3)		