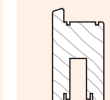
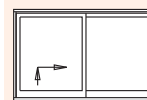


HS-PORTAL 300

Lift and Slide fittings for timber doors
with guide rail HH0130-01/-02



... with the decisive advantages:

- center fixed bogies
- one piece cut to length sealing rail B
- thermally insulated threshold
- clip on replaceable running rail
- smooth operation

Size range Scheme A

Sash width	(mm)	720 to 3335
Sash height (sliding sash)	(mm)	1175 to 2675
Outer frame width	(mm)	1470 to 6700
Outer frame height	(mm)	1325 to 2825
Sash weight	(kg)	max. 300
Backset (Gear)	(mm)	37.5
Sash thickness	(mm)	56, 66 or 68
Sash clearance	(mm)	10 ¹⁾ or 28 (or 30 only if FHD 66)
Handle position (window: FH 1175 -1775)	(mm)	410
Handle position (door: FH 1775 -2675)	(mm)	1010

1) only for sash thicknesses 66 and 68 mm

The recommendations for profile section, timber quality and design, contained in DIN 68 121, are applicable to the SIEGENIA-AUBI HS PORTAL 300 fittings.

The threshold must be horizontal and fixed at every 50 cm.

Profile sections must be as specified on the following SIEGENIA drawings

<i>HSde1046</i>	HS-PORTAL with guide rail HH0130-02 Sash thickness 68 mm or
<i>HSde1048</i>	HS-PORTAL with guide rail HH0130-02 Sash thickness 66 mm
<i>HSde1050</i>	HS-PORTAL with guide rail HH0130-01 Sash thickness 56 mm

For installation of the frame corner connection HH7642-06 see Installation Instruction:

<i>HSde1045</i>	HS-/HSK-PORTAL threshold HH7642-06 and the applicable frame corner connection
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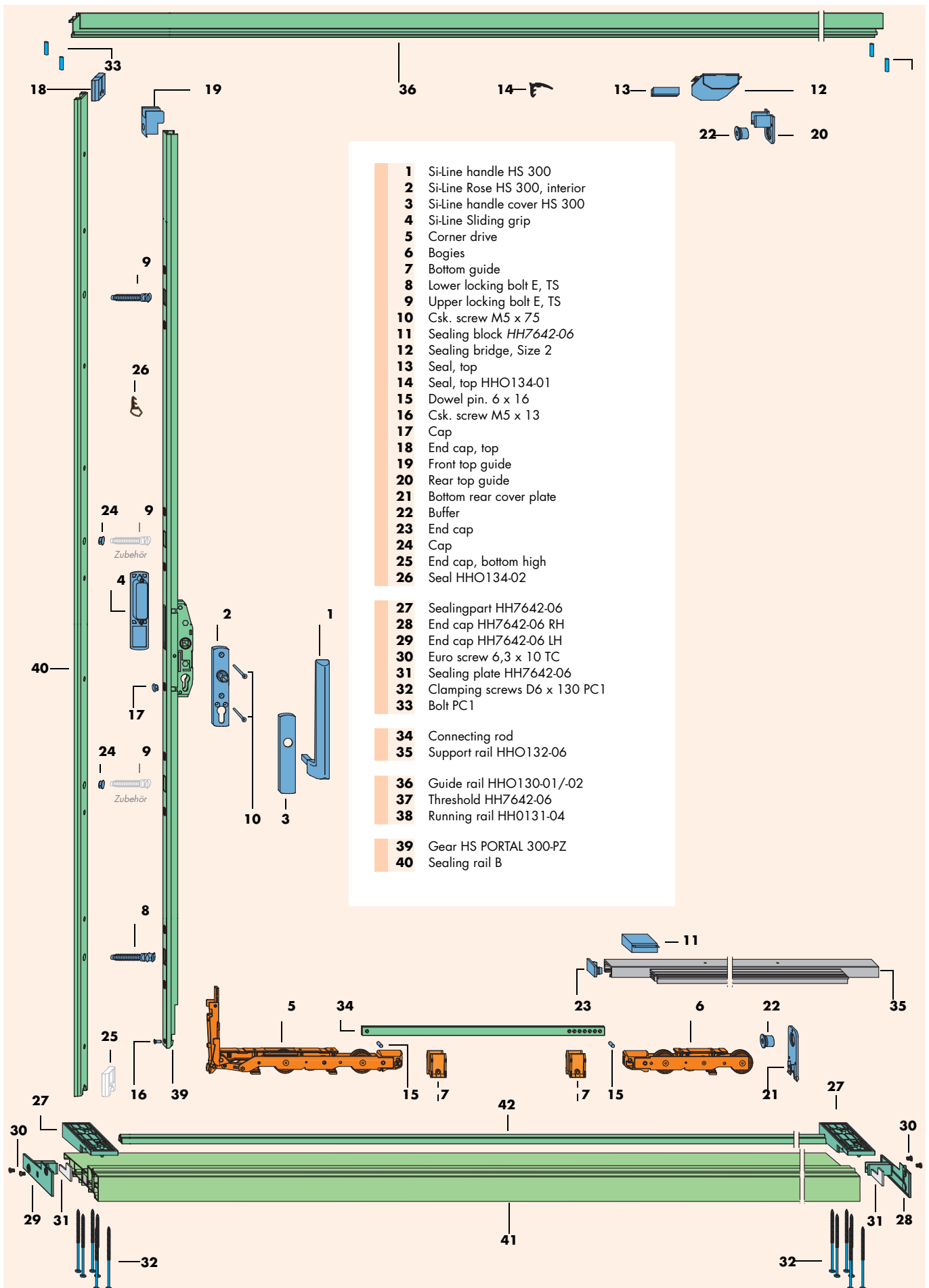
For installation of the burglar resistant sealing rail C-E see Installation Instruction:

<i>HSde1010</i>	HS-PORTAL 300-E Burglar resistant lift and slide fittings for timber doors
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Contents

Size range Scheme A	Page 1	Horizontal section (I).....	Page 12
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Parts list.....	Page 4	Outer frame: fitting of parts (II).....	Page 15
Jigs.....	Page 5	Vertical section, bottom.....	Page 16
Scheme options and accessories (I).....	Page 6	Preparation of the sash (I).....	Page 17
Accessories (II).....	Page 7	Preparation of the sash (II).....	Page 18
Accessories (III).....	Page 8	Sash: fitting of parts.....	Page 19
Rail B in timber.....	Page 9	Outer frame: fitting of parts (III) and.....	
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HS-PORTAL 300 Fittings layout



HS-PORTAL 300 Parts List

Ref.	Qty.	Materialshorttext	Materialnumber				
			white	grey	black	mid-bronze	
	1	Si-line HS-PORTAL 300 handle carton <i>comprising:</i>					
1	1	Si-line handle HS 300					
2	1	Si-line Rose HS 300, interior					
3	1	Si-line Cover cap HS 300					
4	1	Si-line sliding grip long					
	1	Basic carton HS- 300 H TS <i>comprising:</i>	PMKB0030-100010				
5	1	Corner drive VSU HS 300 TS					
6	1	Bogie HS 300 TS					
7	3	Guide, bottom					
	1	Additional carton HS-H HH0130-01/-02 for Guide rail HH013001/02 <i>comprising:</i>	PMKB0130-102010	PMKB0130-1E6010	PMKB0130-123010	PMKB0130-131010	
8	1	Locking bolt E, bottom TS					
9	1	Locking bolt E, top TS					
10	2	Csk. screw M5 x 75 Sash thickness 68 mm					
11	0..1	Sealing block HH7642-06 only for Threshold HH7642-06 ¹⁾					
12	1	Sealing bridge Size 2					
13	1	Seal, top					
14	1	Seal, top HH0134-01 Length 6,8 m					
	1	Bag of Sash parts HS/HSK-250					
15	2	Dowel pin 6 x 16					
16	1	Csk. screw M5 x 13					
17	1	Cap grey					
17	1	Cap brown					
	1	Bag, HS-PORTAL 250 HH0130-01/02 <i>comprising:</i>					
18	1	End cap, top					
19	1	Guide, top front					
20	1	Guide, top rear					
21	1	Cover plate, bottom rear					
22	2	Buffer					
23	1	Handle cover					
24	1	Cap					
25	0..1	End cap, bottom high	PDIB0040-002010	PDIB0040-0E6010	PDIB0040-0F8010	PDIB0040-031010	
26	1	Seal HH0134-02 Length 17,5 m	RAL 7040 grey PDPB0030-0E6010	RAL 7040 grey PDPB0030-0E6010	RAL 9005 black PDPB0030-099010	RAL 9005 black PDPB0030-099010	
	0..1	Frame corner connection HH 7642-06	Size 56/2 Sash thickness/Sash clearance (in mm) 56/28 and 68/10 56/3 68/28	grey RAL 7040 ¹⁾ PMRB0010-0E6010 PMRB0020-0E6010	grey RAL 7040 ¹⁾ PMRB0010-0E6010 PMRB0020-0E6010	black RAL 9005 PMRB0010-023010 PMRB0020-023010	black RAL 9005 PMRB0010-023010 PMRB0020-023010
27	2	Sealingpart HH7642-06	Size 56/2 Sash thickness/Sash clearance (in mm) 56/28 and 68/10 56/3 68/28				
28	1	End cap HH7642-06 RH					
29	1	End cap HH7642-06 LH					
		Bag frame corner connection HH7642-06 accessories <i>comprising:</i>					
30	4	Euro screw 6,3 x 10 TC					
31	2	Sealing plate HH7642-06					
32	12	Clamping screws D6 x 130 PC1					
33	4	Bolt PC1					
	34	Connecting rod	Size 150 TS Length (in mm) 898 FB (in mm) 720 to 1500 200 TS 1398 1501 to 2000 250 TS 1898 2001 to 2500 335 TS 2748 2501 to 3350			719282 719480 719497 719725	
	35	Support rail HH0132-06	150 1580 720 to 1500 200 2080 1501 to 2000 250 2580 2001 to 2500 335 3430 2501 to 3350	grey RAL 7040 PPZB0050-0E6010 PPZB0060-0E6010 PPZB0070-0E6010 PPZB0080-0E6010	grey RAL 7040 PPZB0050-0E6010 PPZB0060-0E6010 PPZB0070-0E6010 PPZB0080-0E6010	black RAL 9005 PPZB0050-023010 PPZB0060-023010 PPZB0070-023010 PPZB0080-023010	black RAL 9005 PPZB0050-023010 PPZB0060-023010 PPZB0070-023010 PPZB0080-023010

1) Sealing block for Threshold HH7642-04 in separate Order

2) or use black


HS-PORTAL 300 Parts List

Ref.	Qty.	Materialshorttext	Materialnumber								
			EV 1 silver	RAL 7040 grey	C 34 dark bronze	C 33 mid-bronze					
dependent on RAB	36	1	Guide rail HH0130-01 <i>for FH-D 56 mm</i>		Size	Length (in mm)	RAB (in mm)	EV 1 silver	EV 1 silver	C 34 dark bronze	C 33 mid-bronze
			300	2900	1470 to 3000	125298	125298	125304	-		
			350	3400	3001 to 3500	125311	125311	-	-		
			400	3900	3501 to 4000	125335	125335	125342	-		
			450	4400	4001 to 4500	125359	125359	-	-		
			500	4900	4501 to 5000	125373	125373	125380	-		
			570	5600	5001 to 5700	125397	125397	-	-		
			670	6600	5701 to 6700	125410	125410	125427	-		
			Guide rail HH0130-02 <i>for FH-D 68 mm</i>		Size	Length (in mm)	RAB (in mm)	EV 1 silver	EV 1 silver	C 34 dark bronze	C 33 mid-bronze
			300	2900	1470 to 3000	137154	137154	137178	155516		
	350	3400	3001 to 3500	137161	137161	-	-				
	400	3900	3501 to 4000	152669	152669	151037	155141				
	450	4400	4001 to 4500	153390	153390	-	-				
	500	4900	4501 to 5000	151341	151341	155165	155172				
	570	5600	5001 to 5700	151167	151167	-	-				
	670	6600	5701 to 6700	150498	150498	155196	134863				
	dependent on RAB	1	Threshold HH7642-06		Size	Length (in mm)	RAB (in mm)	EV 1 silver	EV 1 silver	C 34 dark bronze	C 33 mid-bronze
			300		1470 to 3000	PMBB0010-524010	PMBB0010-524010	PMBB0010-532010	PMBB0010-530010		
			350		3001 to 3500	PMBB0020-524010	PMBB0020-524010	-	-		
400				3501 to 4000	PMBB0030-524010	PMBB0030-524010	PMBB0030-532010	PMBB0030-530010			
450				4001 to 4500	PMBB0040-524010	PMBB0040-524010	-	-			
500				4501 to 5000	PMBB0050-524010	PMBB0050-524010	PMBB0050-532010	PMBB0050-530010			
570				5001 to 5700	PMBB0060-524010	PMBB0060-524010	-	-			
670				5701 to 6700	PMBB0070-524010	PMBB0070-524010	PMBB0070-532010	PMBB0070-530010			
<i>comprising:</i>											
37			1	Threshold HH7642-06		300	3000				
	350	3500									
	400	4000									
	450	4500									
	500	5000									
	670	6700									
38	1	Running rail HH0131-04		300	3105						
		350	3505								
		400	4005								
		450	4505								
		500	5005								
		670	6705								
dependent on FH	39	1	Gear HS-PORTAL 300-PZ		Size	Handle location (in mm)	FH (in mm)	EV 1 silver	EV 1 silver	C 34 dark bronze	C 33 mid-bronze
			170	410	1175 to 1775	PGKB0010-524010	PGKB0010-524010	PGKB0010-532010	PGKB0010-532010		
			220	1010	1776 to 2275	PGKB0020-524010	PGKB0020-524010	PGKB0020-532010	PGKB0020-532010		
			260	1010	2276 to 2675	PGKB0030-524010	PGKB0030-524010	PGKB0030-532010	PGKB0030-532010		
	40	1	Sealing rail B HS <i>Alternatively: Timber rail B (see Page 9).</i>		Size	FH (in mm)	RAL 9003 white	RAL 7040 grey	RAL 9005 black	RAL 9005 black	
260	1175 to 2675	PPDB0010-002010	PPDB0010-0E6010	PPDB0010-023010	PPDB0010-023010						


Handle options

Ref.	Qty.	Materialshorttext	colour	Materialnumber
	1	Si-line HS-PORTAL 300 handle carton <i>comprising:</i>	RAL 9003 white	PMHB0010-502010
1	1	Si-line handle HS 300	RAL 8022 brown	PMHB0010-512010
2	1	Si-line Rose HS 300 innen	EV 1 silver	PMHB0010-524010
3	1	Si-line Cover cap HS 300	EV 2 new silver	PMHB0010-526010
4	1	Si-line sliding grip	C 33 mid-bronze	PMHB0010-530010
	1	Si-line HS-PORTAL 300 PZ handle carton <i>for internal locking</i> <i>comprising:</i>	titanium matt bright	PMHB0010-534010
No illust.	1	Si-line handle HS 300	RAL 9001 white	PMHB0020-501010
	1	Si-line Rose HS 300 innen	RAL 9003 white	PMHB0020-502010
	1	Si-line Cover cap HS 300 PZ	RAL 8022 brown	PMHB0020-512010
	1	Si-line sliding grip	EV 1 silver	PMHB0020-524010
			EV 2 new silver	PMHB0020-526010
			C 33 mid-bronze	PMHB0020-530010
			titanium matt bright	PMHB0020-534010

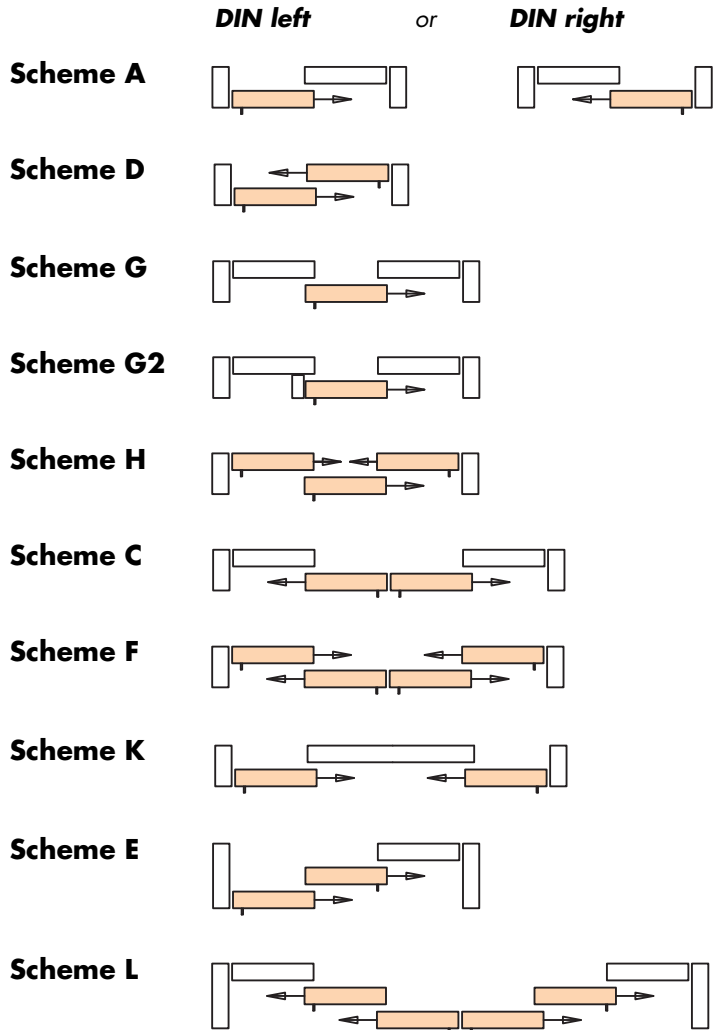
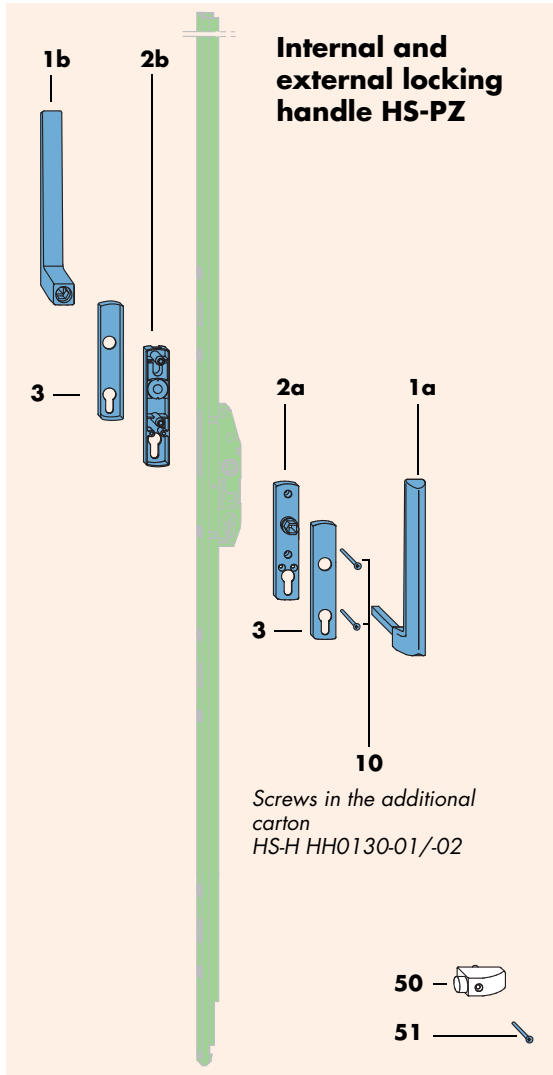
HS-PORTAL 300 Jigs

Materialshorttext	Tool	Materialnumber
 <p>Jig EB 650-1/06 for Frame corner connection HH 7642-06</p>	Drill: Ø 6.5 mm	PABB0050-000010
 <p>Drill jig EB 650-3 for gear holes comprising:</p> <p>Item 1 drilling jig EB 650-3 for gear holes</p> <p>Item 2 positioning rod for EB 650-3 and EB 651-3 (inc. bottom stop)</p>	Drill: Ø 12 mm Ø 20 mm	PABB0040-521010 157244
 <p>Jig for locking bolts</p>	Drill: Ø 10 mm	155066
 <p>Milling template for sliding grip and centre lock</p>	Cutter: Ø 20 mm cutter guide: Ø 27 mm Drill: Ø 7 mm	141373

When using the timber sealing rail B, instead of plastic sealing rail B (40) the following is also required:

 <p>Centre punch for the locking bolt, for centre punching on sealing rail B</p>		141519
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HS-PORTAL 300 Scheme options and accessories (I)

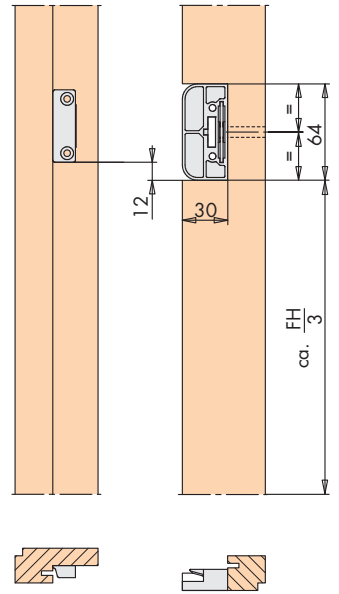
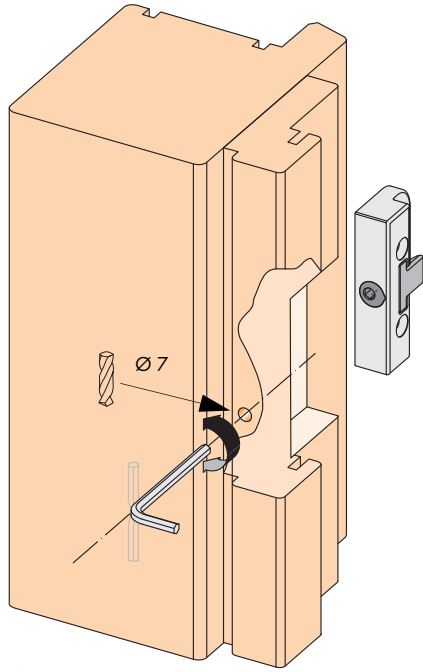
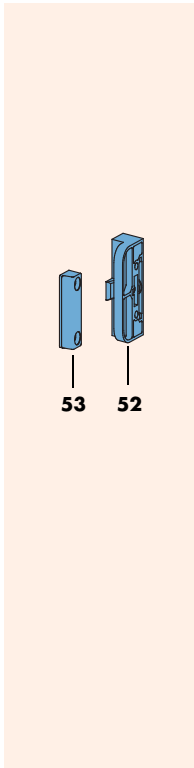


For a style of door using internal and external locking handles the parts listed on pages 3 and 4 are required. Instead of the Si-Line HS 300 handle carton, (1, 2, 3 and 4) the parts listed below are used.

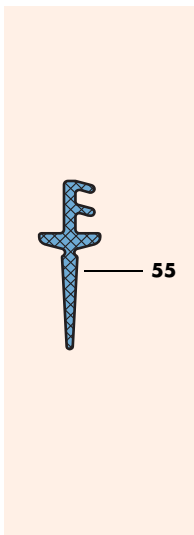
Ref.	Qty.	Materialkurztext	colour	Materialnumber
	1	Si-line handle HS PORTAL 300 PZ carton internal <i>only use with HS 300 PZ external locking handle with profile cylinder for lockable elements -with profile cylinder internal and external comprising:</i>	RAL 9001 white RAL 9003 white RAL 8022 brown	PMHB0050-501010 PMHB0050-502010 PMHB0050-512010
1a	1	Si-line handle HS 300 PZ internal	EV 1 silver	PMHB0050-524010
2a	1	Si-line rose HS 300 internal	EV 2 new silver	PMHB0050-526010
3a	1	Si-line handle cover HS 300 PZ	C 33 mid-bronze titanium matt bright	PMHB0050-530010 PMHB0050-534010
	1	Si-line handle Si-line HS PORTAL 300 PZ carton external <i>only use with HS 300 PZ internal locking handle with profile cylinder for lockable elements -with profile cylinder internal and external bestehend aus:</i>	RAL 9001 white RAL 9003 white RAL 8022 brown	PMHB0040-501010 PMHB0040-502010 PMHB0040-512010
1b	1	Si-line handle HS 300 PZ external	EV 1 silver	PMHB0040-524010
2b	1	Si-line rose HS 300 external	EV 2 new silver	PMHB0040-526010
3a	1	Si-line handle cover HS 300 PZ	C 33 mid-bronze titanium matt bright	PMHB0040-530010 PMHB0040-534010
50, 51	1	Bag buffer <i>bestehend aus:</i>	RAL 9003 white	821237
	1	Buffer	RAL 9005 black	831922
	1	Chipboard screw 4.5 x 70	mid-bronze	827901

HS-PORTAL 300 Accessories (II)

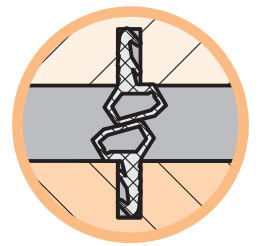
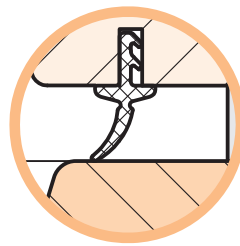
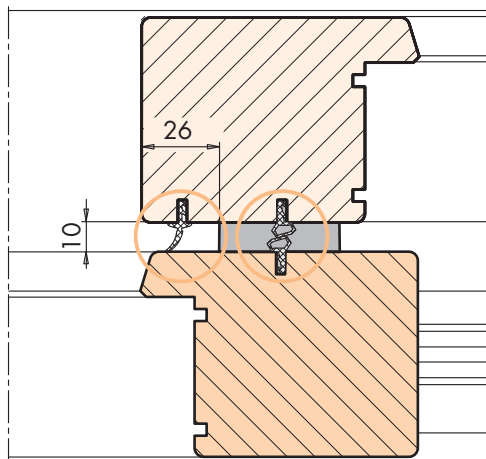
HS PORTAL adjustable centre lock



It is possible to fit more than one centre lock.



Seal HH0134-04 for 10 mm sash clearance



Seal HH0134-04

Please note installation of the standard seal HH0134-02.

	Ref.	Qty.	Materialshorttext	Materialnumber		
				white	black	mid-bronze
Accessories		1	Bag, HS PORTAL centre lock	701850		
			comprising:			
	52	1	Lock MV HS PORTAL			
	53	1	Lock plate MV			
	55	1	Sash seal HH0134-04 for 10 mm sash clearance Length 50 m	PDPB01 10-099010		

HS-PORTAL 300 Accessories (III)

Long Si-line external escutcheon plate

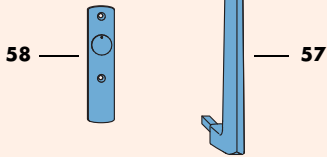


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56

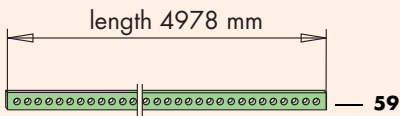
The escutcheon plate (56) may be used instead of the sliding grip handle(4) (See Page 2)

Removable handle

Si-line internal escutcheon plate

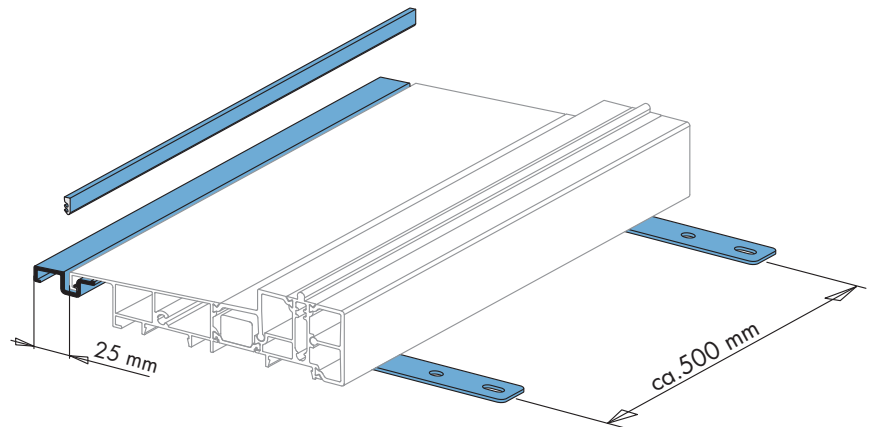
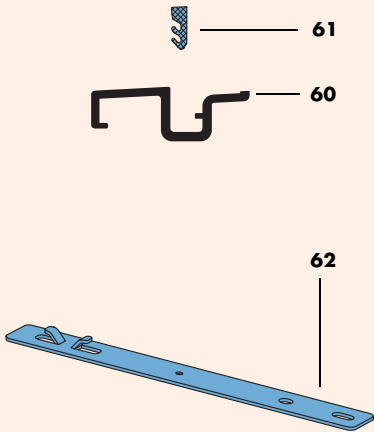


Connecting rod, Size 500



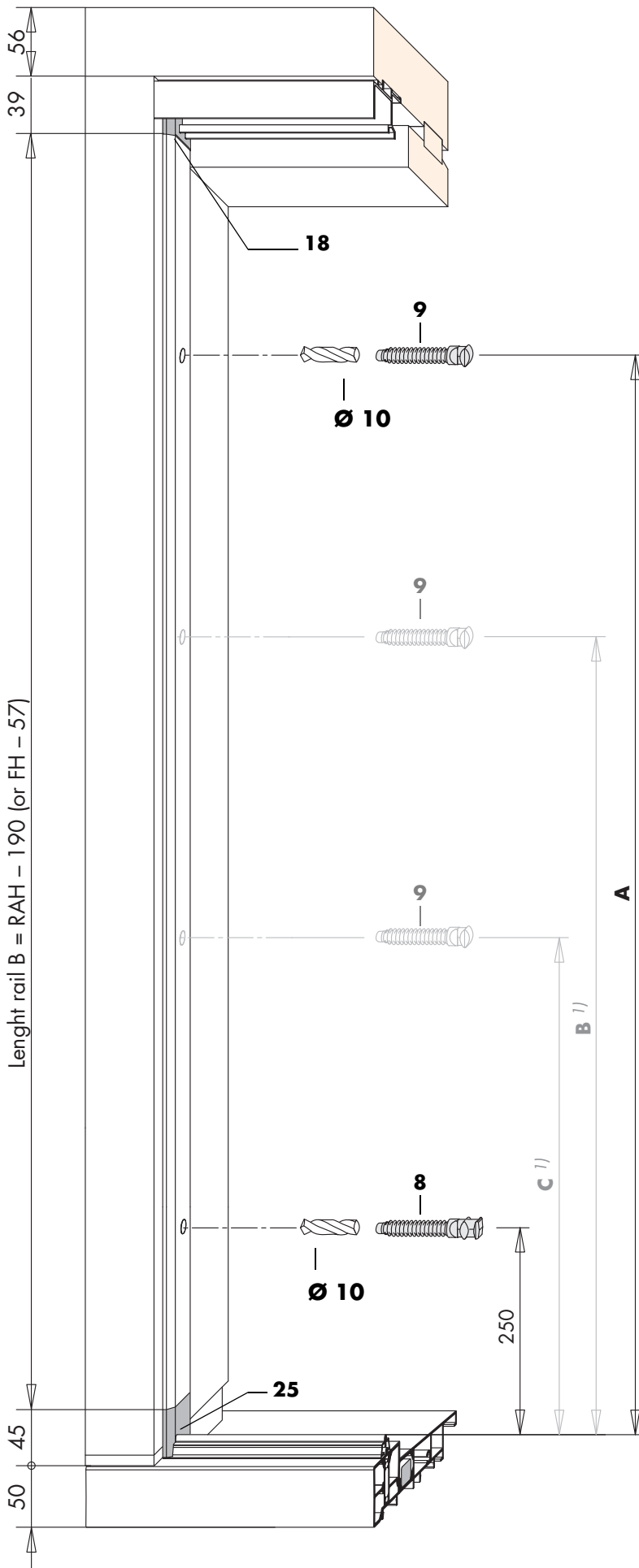
Connecting rod, Size 500 is available in stock lengths.

Extension rail HH7646 and fixing cleats



Ref.	Stück	Materialkurztext	colour	Materialnummer
56	1	Long Si-line external escutcheon plate	RAL 9003 white	PHZB0030-502010
			RAL 8022 brown	PHZB0030-512010
			Si-silver	PHZB0030-525010
57	1	Removable handle	RAL 9003 white	PHIB0060-502010
58	1	Si-line internal escutcheon plate	RAL 9003 white	PHZB0020-502010
			RAL 8022 brown	PHZB0020-512010
			Si-silver	PHZB0020-525010
59	1	Connecting rod Size 500 Length 4978		719732
60, 61	1	Extension rail HH7646 Size 670 with seal HH7633	EV 1 silver	PPVB0060-524010
			C 34 dark bronze	PPVB0060-532010
62	2/metre	Fixing cleat HH7642-06 TS		PBZB0010-100010

HS-PORTAL 300 Timber rail B

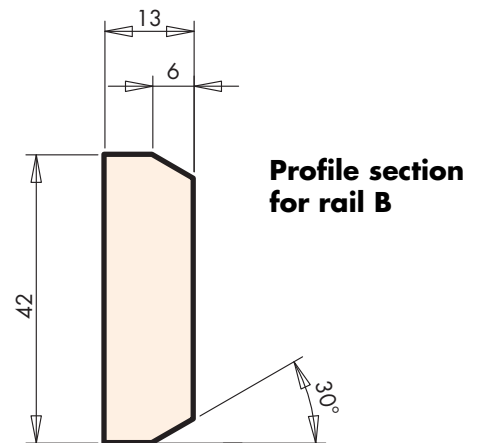


A Fitting the timber rail B

- Cut rail B to length
- Position rail B with bottom end cap **(25)** and screw on rail B
- Adjust top end cap **(18)** to suit the direction of sliding, DIN left or DIN right, and insert it (see also Page 15).

B Fitting the locking bolts **(8 and 9)**.

- Locate centre punch in HS PORTAL 300-PZ gear **(39)** and push the sliding sash against the frame.
- The holes for the locking bolts **(8 and 9)** will be marked by this
- Pre-drill the holes for the locking bolts **(8 and 9)** with $\varnothing 10$ mm drill, or for hard wood $\varnothing 11$ mm,
- Screw in the locking bolts **(8 and 9)** with their jig (see Page 5 and Page 12).



Gear	Dim. A	Dim. B ¹⁾	Dim. C ¹⁾
Size 170	1000	600	-
Size 220	1600	1200	750
Size 260	1900	1200	750

- 1) If desired, two additional top locking bolts **(9)** can be fitted as a centre lock point.
For this the locking points provided on the HS PORTAL 300 PZ gear **(39)** must be opened up.

Important notes

- Please take note of our Product Information „Sliding fittings for the sashes of French doors and windows“.
- The recommendations for profile section, timber quality and design, contained in DIN 68 121, are applicable to the SIEGENIA-AUBI HS PORTAL 300 fittings.

Details given for screwing speeds and torques are binding.

- The Profile sections must be as specified on the following SIEGENIA-AUBI drawings:

HSde1046	HS-PORTAL with guide rail HH0130-02	Sash thickness 68 mm or.
HSde1048	HS-PORTAL with guide rail HH0130-02	Sash thickness 66 mm
HSde1050	HS-PORTAL with guide rail HH0130-01	Sash thickness 56 mm

The hardware parts are manufactured from zinc plated steel and are treated with a special coating.

They should not be used in:

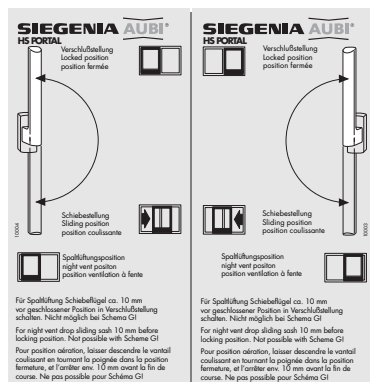
- damp conditions
- aggressive corrosive environments
- salty atmospheres
- on corrosive timbers or timber treated with corrosive substances

If any of the above conditions apply or there is doubt, please consult your SIEGENIA-AUBI representative

- Use only **SIEGENIA-AUBI fittings with SIEGENIA-AUBI fittings**, otherwise we can accept no liability in respect of damages or defects arising where the assembly incorporates other hardware.
- Assemble the hardware components correctly as described on Pages 11 to 20.

Do not overtighten the screws!

- Any surface treatment of the lift and slide elements must take place before fitting the hardware. Post treatment could adversely affect the function of the fittings. In this case we can accept no liability.
- Please follow the standard techniques for glazing and wedging the sealed glass units within the sash and frame
- Do not use any acid bonding sealants, as these can cause corrosion of the hardware components.
- Keep the running rails and all rebates free from dirt and debris - especially residues of cement or plaster. Avoid contact direct of the fittings with water or with cleaning agents.
- Affix a clearly visible copy of the operating sticker to one of the lift and slide sashes (Slide direction DIN left or DIN right). The sticker can be found in the basic carton HS-300 H TS.



Exclusion of liability

We are not liable for any malfunction or damage to the hardware or doors to which it is fitted which can be attributed to inappropriate use or non observance of our fitting instructions

We accept no liability in respect of any damages or malfunctions caused by the hardware or the lift and slide elements fitted with them, as a result of:

- assembly has not been performed as detailed in our instructions or other specification provided,
- the hardware has been subject to misuse or other external influences,
- the hardware has been modified by a third party,
- un approved combination with other hardware or hardware from another supplier or un approved combinations of hardware with different coatings,
- the hardware is not maintained at least yearly as described in our HS PORTAL maintenance instruction ,
- the end user has not been supplied with and instructed on our maintenance leaflet
- We advise that the external -rolling parts; in particular the running and guide rails must be regularly cleaned.

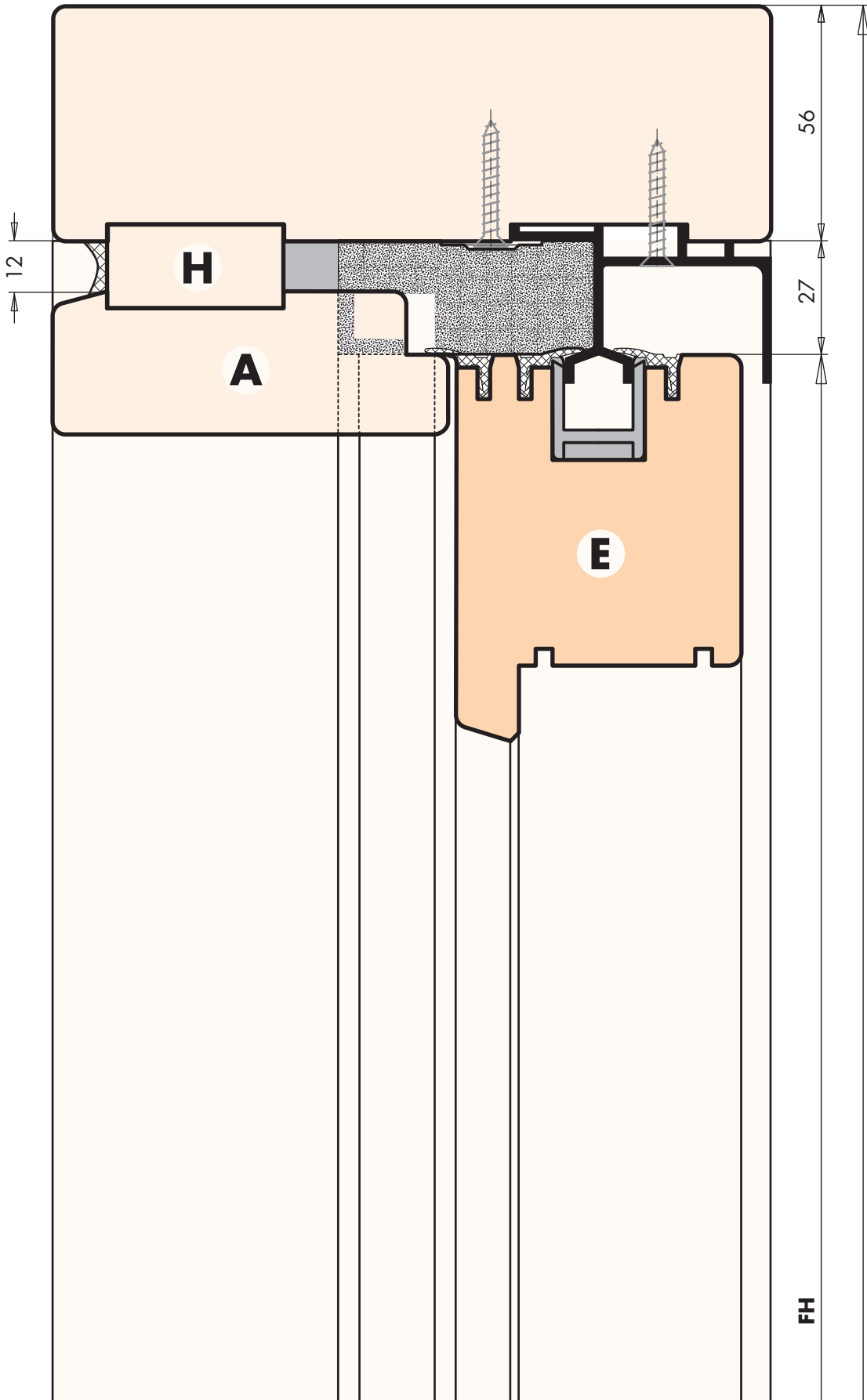
Abbreviations

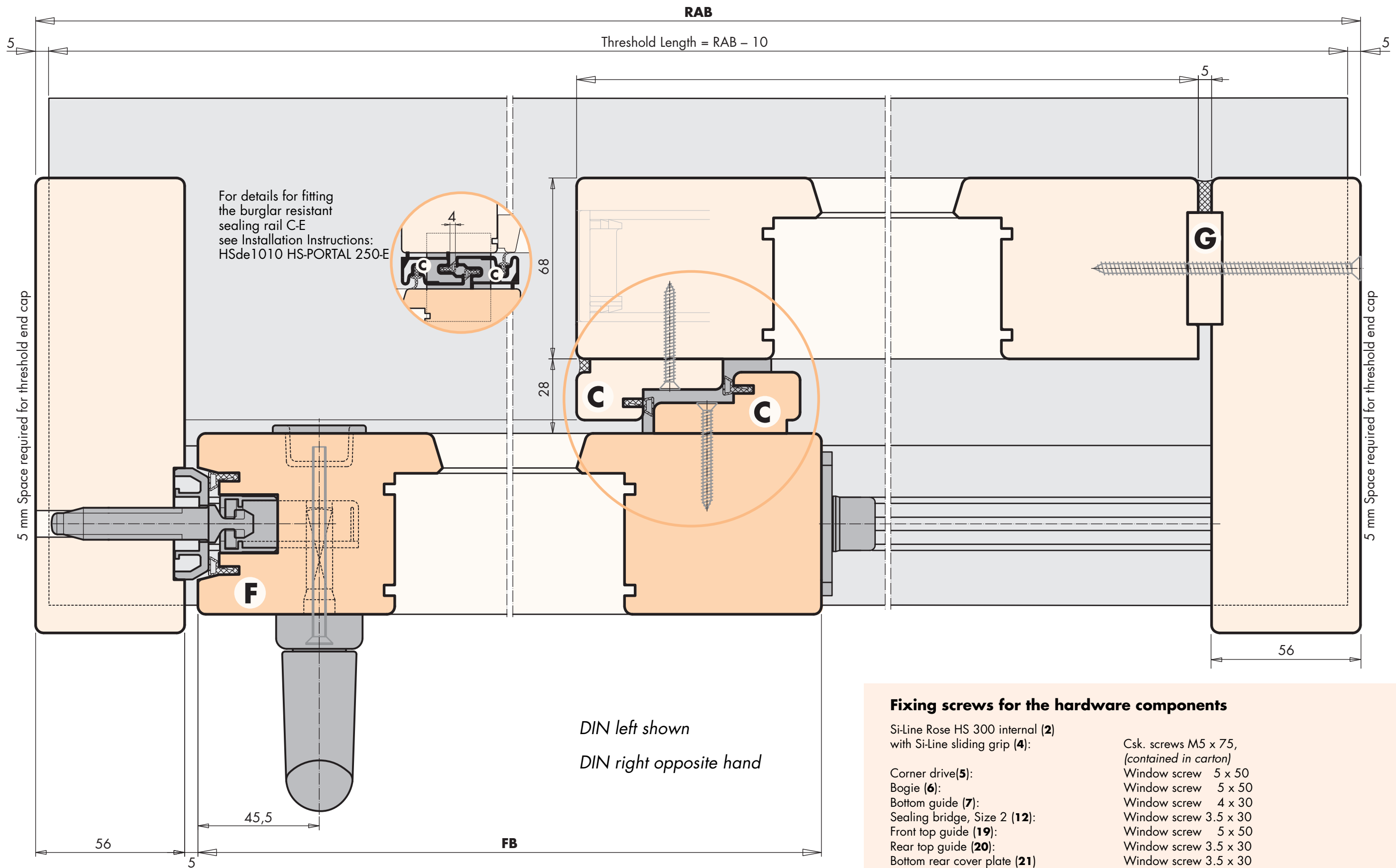
The following abbreviations are used in this document:

EB	Einbohrlehre	HH	Hebeschiebe-Holz	RAH	Rahmenaußenhöhe
FA	Flügelabstand	MV	Mittelverschluß	VSU	Verschlußseite unten
FB	Flügelbreite	OKFF	Oberkante Fertig-Fußboden	VPE	Verpackungseinheit
FB	Flügelbreite	PZ	Profilylinder		
FHD	Flügelholzdicke	RAB	Rahmenaußenbreite		

HS-PORTAL 300 Vertical cross section. top

Note: Drawings on pages 11 - 13 and 16 are **not** to scale.





Fixing screws for the hardware components

Si-Line Rose HS 300 internal (2) with Si-Line sliding grip (4):

Csk. screws M5 x 75, (contained in carton)

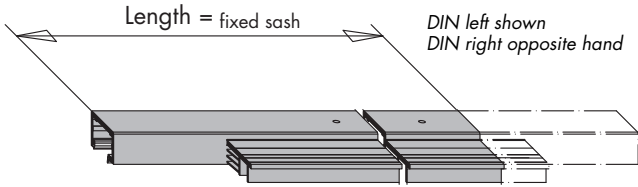
- Corner drive (5):
- Bogie (6):
- Bottom guide (7):
- Sealing bridge, Size 2 (12):
- Front top guide (19):
- Rear top guide (20):
- Bottom rear cover plate (21)
- Support rail HH0132-06 (35):
- Guide rail HH0130-01/-02 (36):
- Gear HS PORTAL 300-PZ (39):
- Sealing rail B (40):

- Window screw 5 x 50
- Window screw 5 x 50
- Window screw 4 x 30
- Window screw 3.5 x 30
- Window screw 5 x 50
- Window screw 3.5 x 30
- Window screw 3.5 x 30
- Window screw 3.5 x 30
- Window screw 4 x 30
- Window screw 3.5 x 30
- Window screw 5 x 50
- Window screw 4 x 30

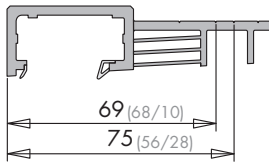
Window screws for timber windows, Steel transparent zinc coated (not supplied).

Sash thickness 68 mm / sash clearance 28 mm
 (Other dimensions are possible from SIEGENIA-AUBI drawings. See page 10)

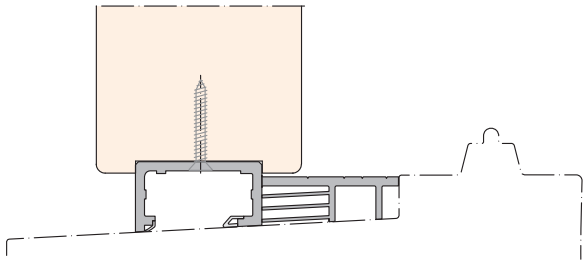
HS-PORTAL 300 Frame: Assembly of components (I)



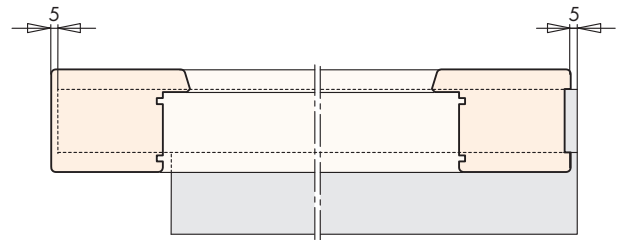
Diag. 1



Diag. 2



Diag. 3



Diag. 4

Assembly sequence

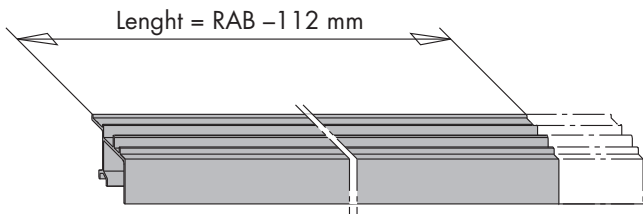
- A** Fixing the support rail HH0132-06 (35) to the fixed sash.
- Cut the support rail HH0132-06 (35) to length according to the sliding direction DIN left or DIN right (Diag. 1).
 - Dependent on the sash thickness / sash clearance 56/28 or 68/10 the support rail must be cut to width along the corresponding notch (Diag. 2).
 - Screw on the support rail HH0132-06 (35) (Diag. 3 and 4).

B Installing the fixed sash in the frame (no diagram).

- First screw strip H, then strip G onto the frame. (See appropriate engineering drawing, from list on Page 10)
- Insert fixed sash into the frame and screw it on (see Page 11 - 13 and Page 16).
- Push end cap (23) into support rail HH0132-06 (35) and seal it.

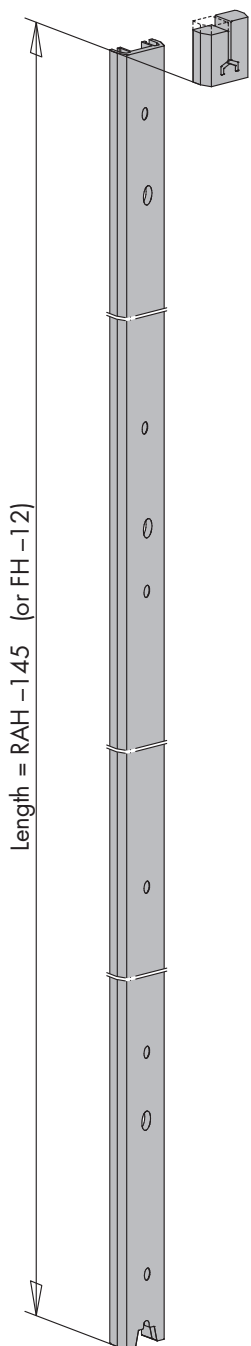
C Installing the guide rail HH0130-01/-02 (36).

- Cut the guide rail HH0130-01/-02 (36) to length (Diag. 5).
- Screw the guide rail HH0130-01/-02 (36) onto the frame (see Page 11).



Diag. 5

HS-PORTAL 300 Frame: Assembly of components (II)

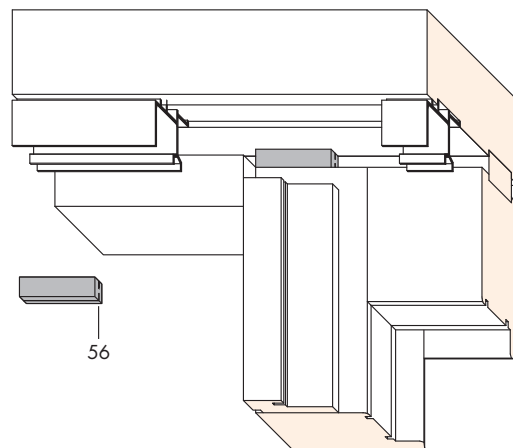


Diag. 6

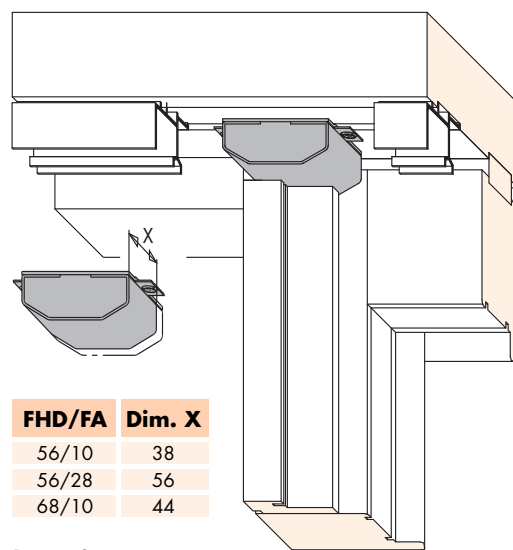
- D** Fitting the sealing rail B (40).
- Cut the sealing rail B (40) to length (Diag. 6).
 - Position the sealing rail B (40) and screw on.
 - Adjust top end cap (18) to suit the sliding direction DIN left or DIN right (Diag. 6) and insert it.

- E** Fitting the top seal (13).
- Insert the top seal (13)
For a sash thickness of 56 mm cut off the top seal (13) at the cutting point provided (Diag. 7).

- F** Fitting the sealing bridge, Size 2 (12).
- Screw sealing bridge, Size 2 (12) onto the frame.
For sash thicknesses / sash clearance 56/10, 56/28 or 68/10 cut the sealing bridge to size, Dimension X (Diag. 8).



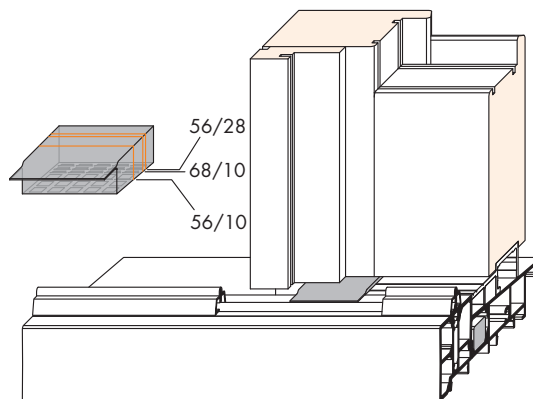
Diag. 7



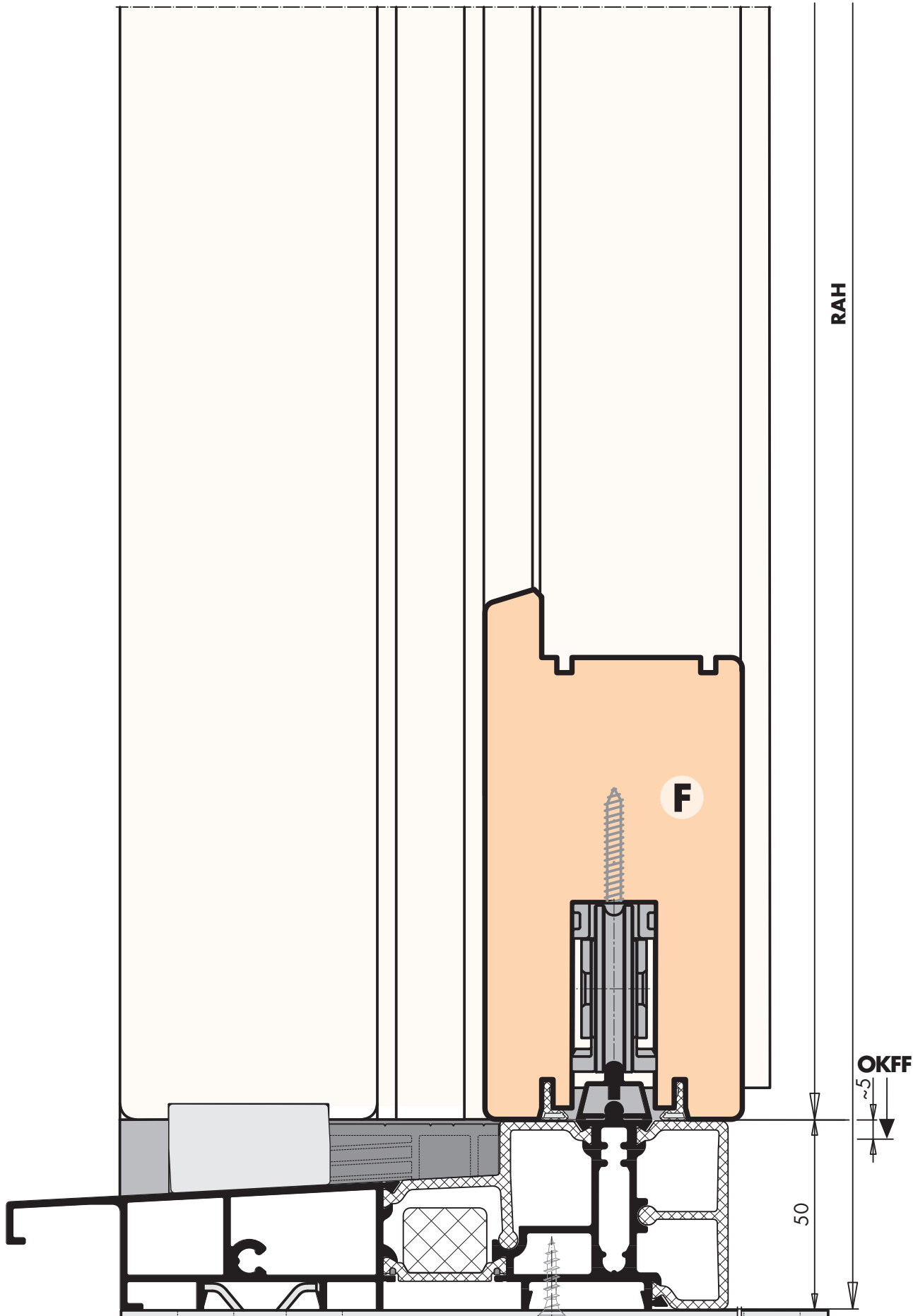
FHD/FA	Dim. X
56/10	38
56/28	56
68/10	44

Diag. 8

- G** Fitting the sealing block (11)
- For sash thicknesses / sash clearance 56/10, 56/28 or 68/10 cut off the sealing block (11) at the appropriate cutting points (Diag. 9).
 - Fit the sealing block (11) and seal or glue it on.



Diag. 9



Note: Threshold height 50 mm !

Note: For installation without running rail HH0131-04 (Handicapped accessible to DIN 18025) see Installation Instructions HSde1045 Page 6

HS-PORTAL 300 Preparation of the sash (I)

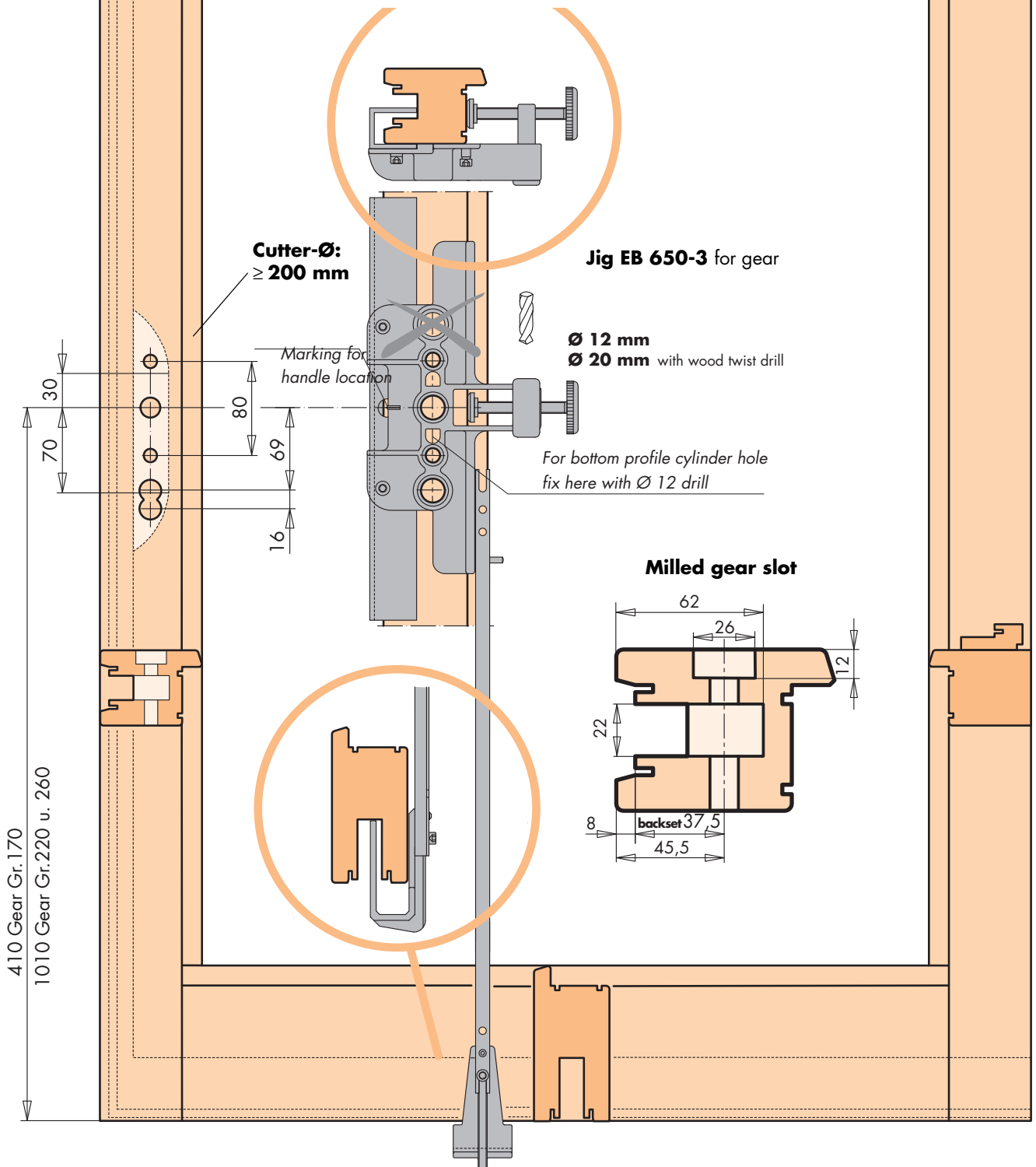
All dimensions (in mm) and details for:

Timber element made to the following SIEGENIA drawings:

HSde1046 HS-PORTAL with guide rail HH0130-02, sash thickness 68 mm

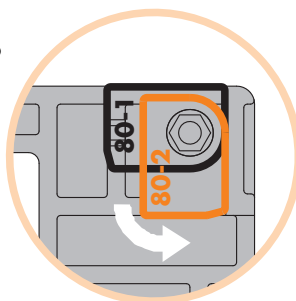
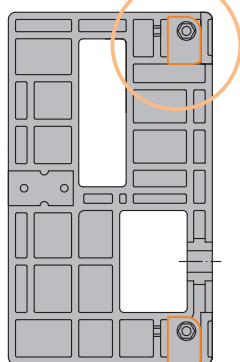
HSde1048 HS-PORTAL with guide rail HH0130-02, sash thickness 66 mm

HSde1050 HS-PORTAL with guide rail HH0130-01, sash thickness 56 mm

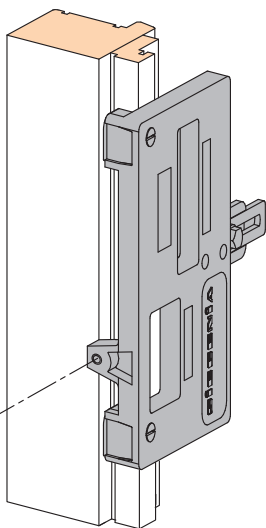


HS-PORTAL 300 Preparation of the sash (II)

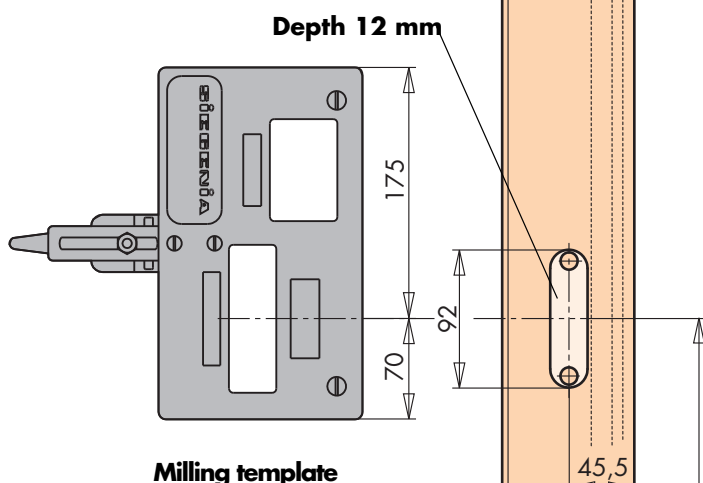
N.B.: Set the stops on the milling template for sliding grip and MV to hardware type 80-2.



Sash drawn from the outside

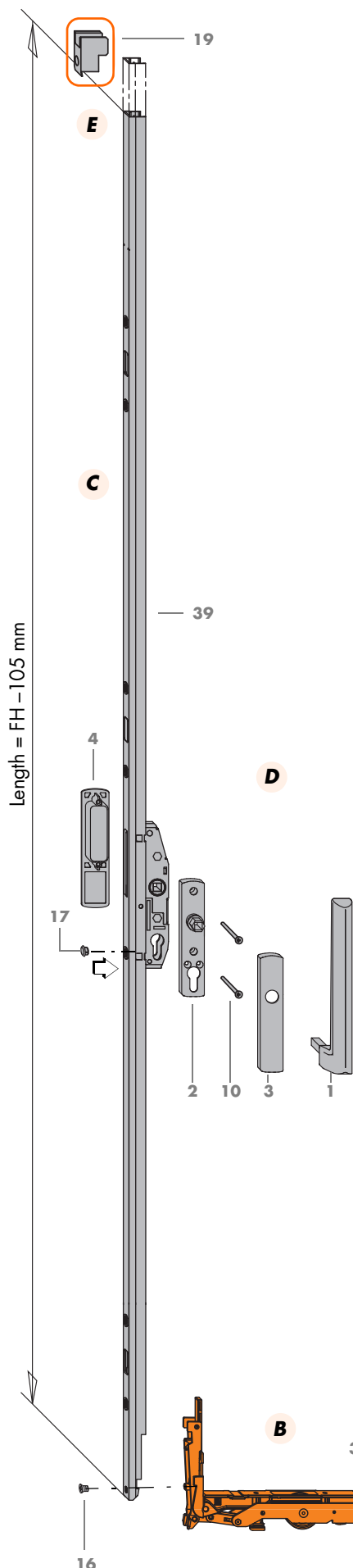


If using the centre lock bag, drill a $\varnothing 7$ mm hole for locking bolt, Item. (52) (see also Page 7).



Milling template
for sliding grip and MV
Cutter: $\varnothing 20$ mm
Cutter guide: $\varnothing 27$ mm

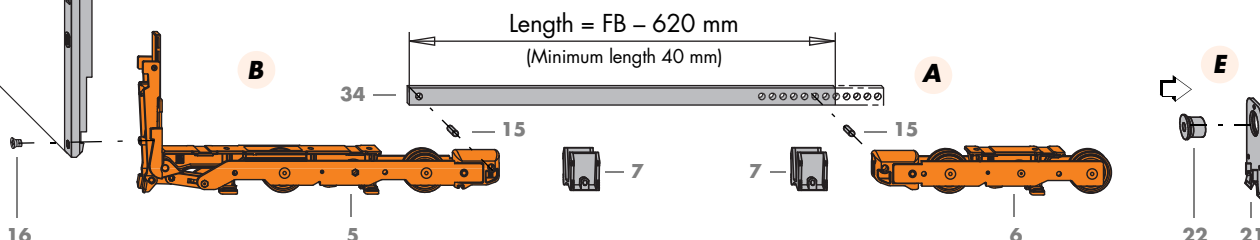
410 Gear Gr.170
1010 Gear Gr.220 u. 260



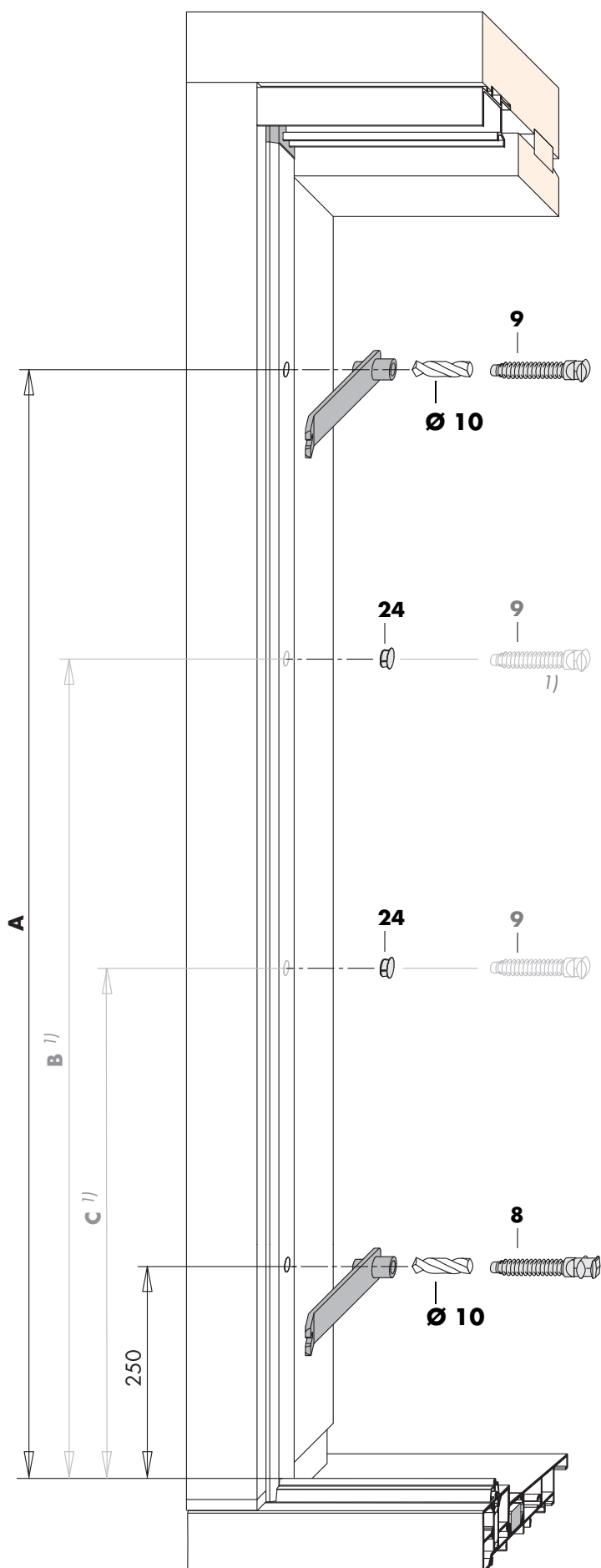
Assembly sequence

- A** Connecting the HS corner drive (5) and HS bogie(6).
 – First insert the cut-to-length connecting rod (34) into the coupling piece of the HS corner drive(5) and join with 6 x 16 dowel pin (15).
 – Insert connecting rod(34) into the coupling piece of the HS bogie (6) and similarly join with 6 x 16 dowel pin (15).
- B** Fit the complete bogie unit into the sash.
 – Screw on the HS corner drive (5) and HS bogie (6).
 – Screw on the bottom guides (7).
- C** Fitting the gear (39).
 – Move the cut-to-length gear (39) into the locking position (handle upwards).
 – Insert gear (39) into the sash and couple to the HS corner drive (5).
 – Secure the gear (39) at the bottom with M5 x 13 countersunk screw (16).
 For other screws see Page 13.
 – Clip cap (17) into the screw hole for fixing the profile cylinder.
- D** Fixing the handle (1) and sliding grip (4):
 – Connect rose (2) and sliding grip (4) using M5 x 75 countersunk screw (10).
 – Clip on the end cap (3).
 – Fit the handle (1) and secure with socket head screw (3 A/F).
- E** Fixing the rear buffers and top guides.
 – Push a buffer (22) each into the bottom rear cover plate (21) and the top rear guide(20).
 – Screw the bottom rear cover plate (21) on the sash.
 – After inserting the sliding sash into the frame, screw on top front guide (19) and top rear guide (20).
- F** Fitting the seals (no diagram).
 – Cut seals (14) and (26) to size and press in. See Page 11 to 13 and 16.

Hinweis: For fixing screws see Page 13.



HS-PORTAL 300 Frame: Fitting of parts (III) and installation of the sliding sash



Diag. 10

- G** Fitting the locking bolts (8 and 9).
- Pre-drill holes for locking bolts (8 and 9) with $\varnothing 10$ mm drill, using the jig for locking bolts (Diag. 10).
 - Screw in locking bolts (8 and 9) with the jig for locking bolts (see also Page 12).
 - Press a cap (24) into the unused locking bolt holes in the plastic sealing rail B. (Diag. 10).

All dimensions in mm

Gear	Dim. A	Dim. B 1)	Dim. C 1)
Size 170	1000	600	–
Size 220	1600	1200	750
Size 260	1900	1200	750

- 1) If desired, two additional top locking bolts (9) can be fitted as a centre lock point.
For this the locking points provided on the HS PORTAL 300 PZ gear (39) must be opened up.

Fitting the sliding sash

- A** Lift the sliding sash into the guide rail from below and set it onto the running rail.
- B** Fit the top rear guide (20), with the buffer (22) pressed in, and the top front guide (19) and screw them on (see Page 19).

Adjustment facilities

- If necessary the vertical seal contact pressure can be adjusted by turning the locking bolts (8 and 9).