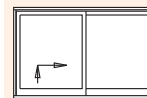


HS-PORTAL 300

Lift and Slide fittings for timber doors
with guide rail KH0130-01



... 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)	1190 to 2690
Outer frame width	(mm)	1470 to 6700
Outer frame height	(mm)	1308 to 2808
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 1190 -1790)	(mm)	410
Handle position (door: FH 1790 -2690)	(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>HSde1047</i>	HS-PORTAL with guide rail KH0130-01 Sash thickness 68 mm or <i>HSde1049</i> HS-PORTAL with guide rail KH0130-01 Sash thickness 66 mm
<i>HSde1051</i>	HS-PORTAL with guide rail KH0130-01 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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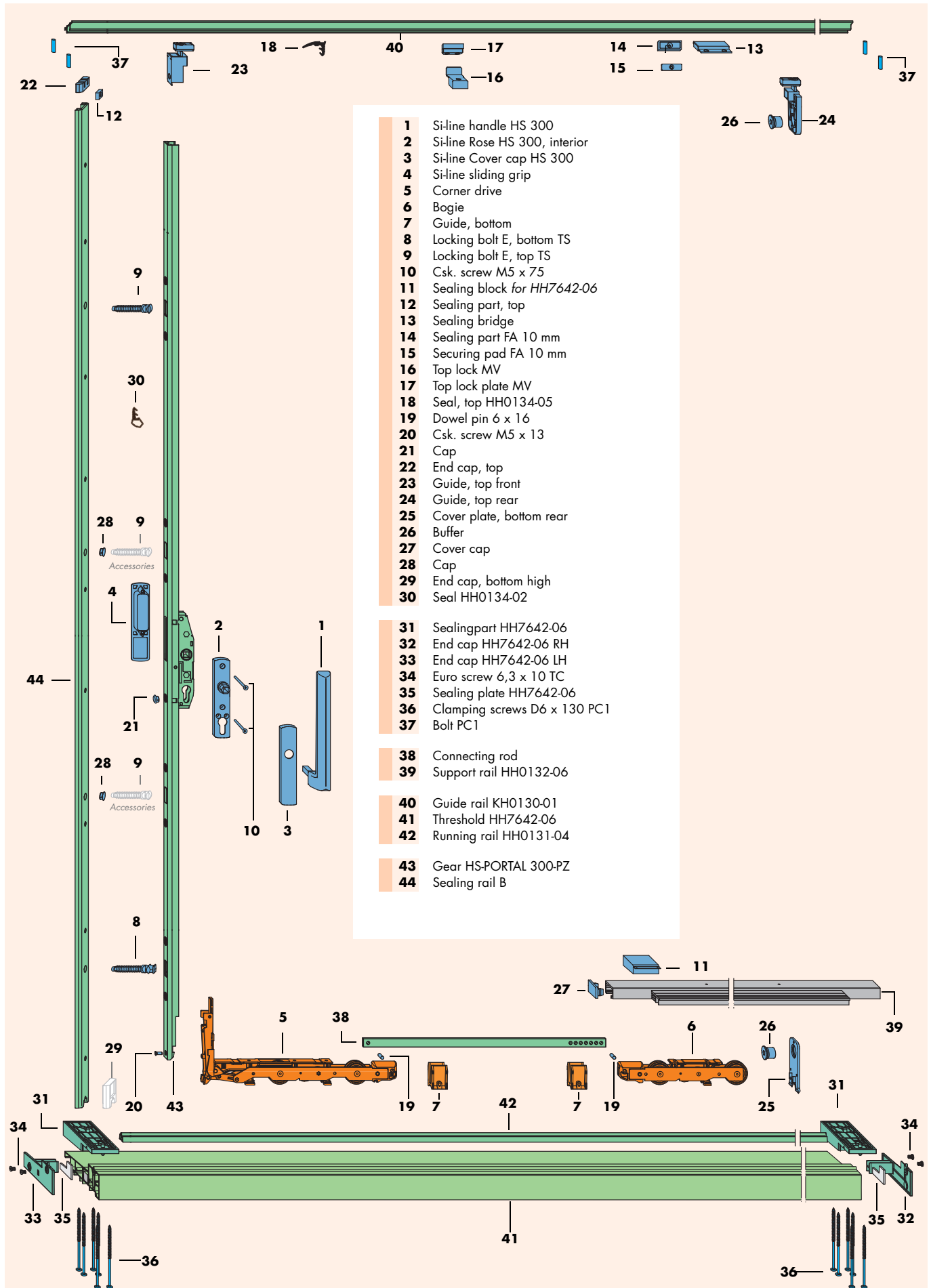
For installation of the burglar resistant sealing rail C-E see Installation Instruction:

<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
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Important notes and abbreviations.....	Page 10	Installation of the sliding sash	Page 20
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HS-PORTAL 300 Fittings layout



- 1** Si-line handle HS 300
- 2** Si-line Rose HS 300, interior
- 3** Si-line Cover cap HS 300
- 4** Si-line sliding grip
- 5** Corner drive
- 6** Bogie
- 7** Guide, bottom
- 8** Locking bolt E, bottom TS
- 9** Locking bolt E, top TS
- 10** Csk. screw M5 x 75
- 11** Sealing block for HH7642-06
- 12** Sealing part, top
- 13** Sealing bridge
- 14** Sealing part FA 10 mm
- 15** Securing pad FA 10 mm
- 16** Top lock MV
- 17** Top lock plate MV
- 18** Seal, top HH0134-05
- 19** Dowel pin 6 x 16
- 20** Csk. screw M5 x 13
- 21** Cap
- 22** End cap, top
- 23** Guide, top front
- 24** Guide, top rear
- 25** Cover plate, bottom rear
- 26** Buffer
- 27** Cover cap
- 28** Cap
- 29** End cap, bottom high
- 30** Seal HH0134-02
- 31** Sealingpart HH7642-06
- 32** End cap HH7642-06 RH
- 33** End cap HH7642-06 LH
- 34** Euro screw 6,3 x 10 TC
- 35** Sealing plate HH7642-06
- 36** Clamping screws D6 x 130 PC1
- 37** Bolt PC1
- 38** Connecting rod
- 39** Support rail HH0132-06
- 40** Guide rail KH0130-01
- 41** Threshold HH7642-06
- 42** Running rail HH0131-04
- 43** Gear HS-PORTAL 300-PZ
- 44** Sealing rail B

HS-PORTAL 300 Parts List

Ref.	Qty.	Materialshorttext	Materialnumber			
			white	grey	black	C 33 mid-bronze
	1	Si-line HS-PORTAL 300 handle carton <i>comprising:</i>	see handle options on Page 4 bottom			
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 HTS <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 KH130-01 for guide rail KH13001 <i>comprising:</i>	PMKB0120-102010	PMKB0120-1E6010	PMKB0120-123010	PMKB0120-131010
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	1	Sealing block only for Threshold HH7642-06				
12	1	Sealing part, top HSK				
13	1	Sealing bridge FA 28 mm				
14	1	Sealing part FA 10 mm				
15	1	Securing pad FA 10 mm				
16	2	Top lock MV				
17	1	Top lock plate MV				
18	1	Seal, top HH013405 Length 3.4 m				
	1	Bag of Sash parts HS/HSK-250				
19	1	Dowel pin 6 x 16				
20	1	Csk. screw M5 x 13				
21	1	Cap grey				
	1	Cap brown				
	1	Bag HSPORTAL 250 KH013001:				
22	1	End cap, top				
23	1	Guide, top front				
24	1	Guide, top rear				
25	1	Cover plate, bottom rear				
26	2	Buffer				
27	1	Cover cap for support rail				
28	3	Cap for sealing rail(44)				
29	0..1	End cap, bottom high	PDIB0040-002010	PDIB0040-0E6010	PDIB0040-0F8010	PDIB0040-031010
			grey RAL 7040	grey RAL 7040	black RAL 9005	black RAL 9005
30	1	Seal HH0134-02 Length 17.5 m	PDPB0030-0E6010	PDPB0030-0E6010	PDPB0030-099010	PDPB0030-099010
			grey RAL 7040 ¹⁾	grey RAL 7040 ¹⁾	black RAL 9005	black RAL 9005
	0..1	Frame corner connection HH 7642-06	PMRB0010-0E6010	PMRB0010-0E6010	PMRB0010-023010	PMRB0010-023010
		Size 56/2 Sash thickness/Sash clearance (in mm) 56/28 and 68/10				
		56/3 68/28	PMRB0020-0E6010	PMRB0020-0E6010	PMRB0020-023010	PMRB0020-023010
31	2	Sealingpart HH7642-06				
		Size 56/2 Sash thickness/Sash clearance (in mm) 56/28 and 68/10				
		56/3 68/28				
32	1	End cap HH7642-06 RH				
33	1	End cap HH7642-06 LH				
		Bag frame corner connection HH7642-06 accessories <i>comprising:</i>				
34	4	Euro screw 6,3 x 10 TC				
35	2	Sealing plate HH7642-06				
36	12	Clamping screws D6 x 130 PC1				
37	4	Bolt PC1				
	38	Connecting rod				
		Size 150 TS Length (in mm) 898 FB (in mm) 720 to 1500				719282
		200 TS 1398 1501 to 2000				719480
		250 TS 1898 2001 to 2500				719497
		335 TS 2748 2501 to 3350				719725
	39	Support rail HH0132-06	grey RAL 7040	grey RAL 7040	black RAL 9005	black RAL 9005
		150 1580 720 to 1500	PPZB0050-0E6010	PPZB0050-0E6010	PPZB0050-023010	PPZB0050-023010
		200 2080 1501 to 2000	PPZB0060-0E6010	PPZB0060-0E6010	PPZB0060-023010	PPZB0060-023010
		250 2580 2001 to 2500	PPZB0070-0E6010	PPZB0070-0E6010	PPZB0070-023010	PPZB0070-023010
		335 3430 2501 to 3350	PPZB0080-0E6010	PPZB0080-0E6010	PPZB0080-023010	PPZB0080-023010

1) or use black

HS-PORTAL 300 Parts List (continuation)

Ref.	Qty.	Materialshorttext	Materialnumber							
			EV 1 silver	grey	C 34 dark bronze	C 33 mid-bronze				
depends on RAB	40	Guide rail KH0130-01 for FHD 56 mm and 68 mm	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	130865	130865	130872	155202	
			350	3400	3001 to 3500	130889	130889	-	-	
			400	3900	3501 to 4000	130902	130902	130919	155226	
			450	4400	4001 to 4500	130926	130926	-	-	
			500	4900	4501 to 5000	130940	130940	130957	155240	
	570	5600	5001 to 5700	130964	130964	-	-			
	670	6600	5701 to 6700	130988	130988	130995	155264			
	1	Threshold HH7642-06	Size	Length (in mm)	RAB (in mm)	PMBB0010-524010	PMBB0010-524010	PMBB0010-532010	PMBB0010-530010	
			300		1470 to 3000	PMBB0020-524010	PMBB0020-524010	-	-	
			350		3001 to 3500	PMBB0030-524010	PMBB0030-524010	PMBB0030-532010	PMBB0030-530010	
			400		3501 to 4000	PMBB0040-524010	PMBB0040-524010	-	-	
450				4001 to 4500	PMBB0050-524010	PMBB0050-524010	PMBB0050-532010	PMBB0050-530010		
500				4501 to 5000	PMBB0060-524010	PMBB0060-524010	-	-		
comprising:		670		5701 to 6700	PMBB0070-524010	PMBB0070-524010	PMBB0070-532010	PMBB0070-530010		
41	1	Threshold HH7642-06	300	3000						
			350	3500						
			400	4000						
			450	4500						
			500	5000						
			570	5700						
42	1	Running rail HH0131-04	300	3105						
			350	3505						
			400	4005						
			450	4505						
			500	5005						
			570	5705						
43	1	Gear HS-PORTAL 300-PZ	Size	Handle location(in mm)	FH (in mm)	PGKB0010-524010	PGKB0010-524010	PGKB0010-532010	PGKB0010-532010	
			170	410	1190 to 1790	PGKB0020-524010	PGKB0020-524010	PGKB0020-532010	PGKB0020-532010	
			220	1010	1791 to 2290	PGKB0030-524010	PGKB0030-524010	PGKB0030-532010	PGKB0030-532010	
			260	1010	2291 to 2690					
44	1	Sealing rail B	Size		FH (in mm)	RAL 9003 white ²⁾	RAL 7040 grey ²⁾	RAL 9005 black	RAL 9005 black	
			260		1190 to 2690	PPDB0010-002010	PPDB0010-0E6010	PPDB0010-023010	PPDB0010-023010	

1) or use black


2) Or use Sealing rail B in the colour black.
Alternatively: Timber rail B (see Page 9).

Ref.	Qty.	Materialshorttext	Color	Materialnumber
	1	Si-line HS-PORTAL 300 handle carton comprising	RAL 9003 white	PMHB0010-502010
			RAL 8022 brown	PMHB0010-512010
			EV 1 silver	PMHB0010-524010
			EV 2 new silver	PMHB0010-526010
			C 33 mid-bronze	PMHB0010-530010
No diag..	1	Si-line HS PORTAL 300 PZ handle carton for internal locking Element - with PZ comprising	titanium matt bright	PMHB0010-534010
			RAL 9001 white	PMHB0020-501010
			RAL 9003 white	PMHB0020-502010
			RAL 8022 brown	PMHB0020-512010
			EV 1 silver	PMHB0020-524010
	1	Si-line handle HS 300	EV 2 new silver	PMHB0020-526010
			C 33 mid-bronze	PMHB0020-530010
			titanium matt bright	PMHB0020-534010
	1	Si-line Rose HS 300, interior	RAL 9005 black	PMHB0020-532010
			RAL 9005 black	PMHB0020-530010
	1	Si-line Cover cap HS 300 PZ		
	1	Si-line sliding grip		

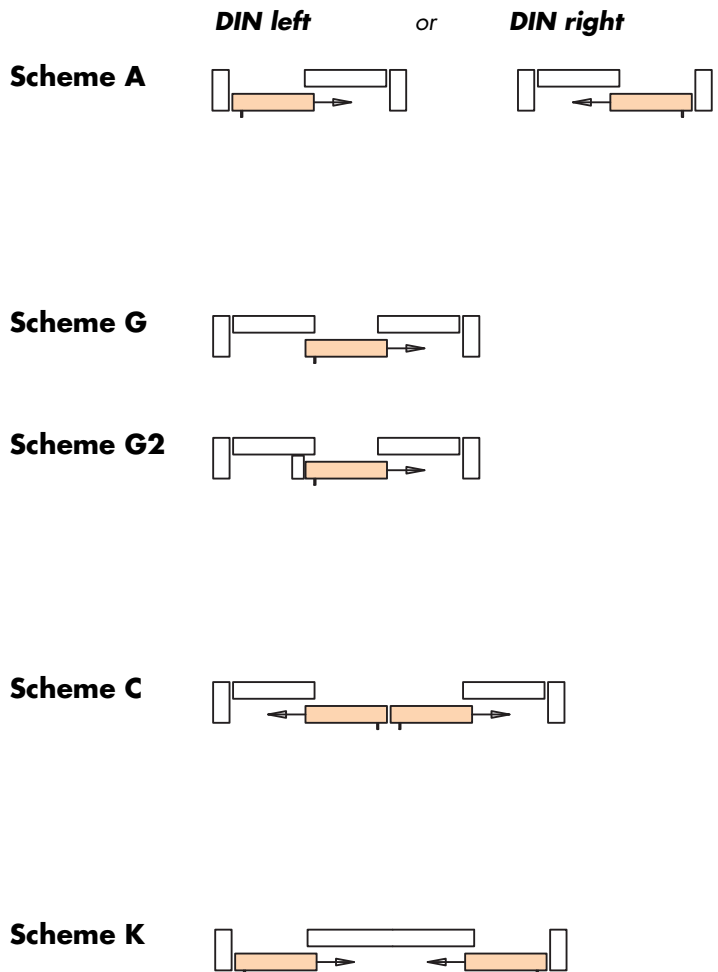
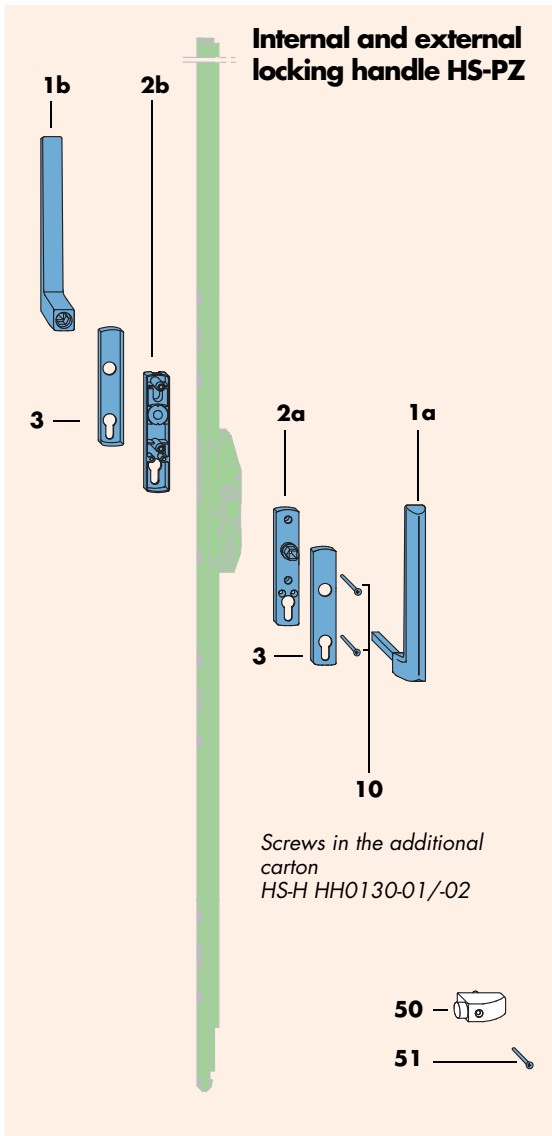
HS-PORTAL 300 Jigs

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 (inc. bottom stop) for EB 650-3 and EB 651-3</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 (44) 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)

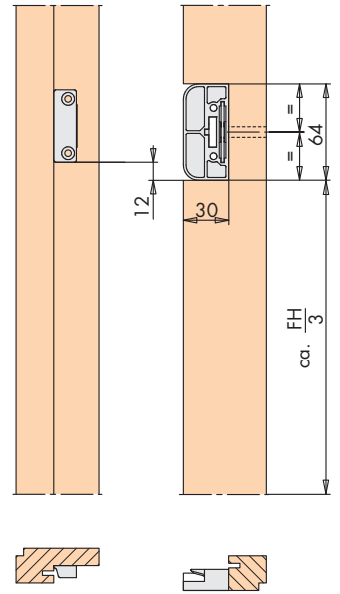
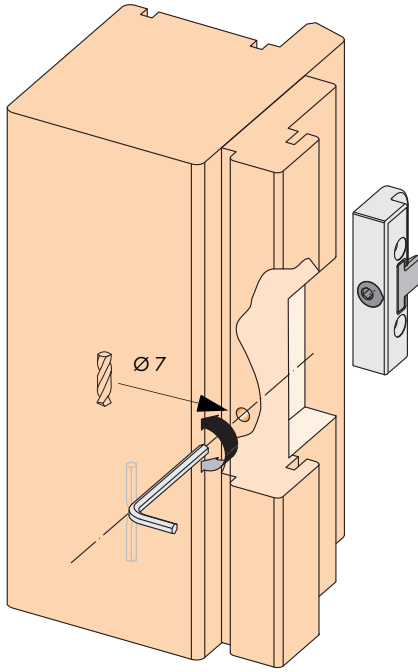
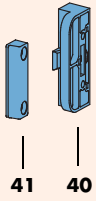


For a style of door using internal and external locking handles the parts listed on pages 3 and 4 are required. Instead of the Si-Line HS 300 handle carton, (1, 2, 3 and 4) the parts listed below are used.

Ref.	Qty.	Materialshorttext	Color	Materialnumber
	1	Si-line handle HS PORTAL 300 PZ internal Only in connection with handle SiLine HS300 PZ external for lockable elements-with profile cylinder internal and external comprising:		
1a	1	Si-line handle HS 300 PZ internal	RAL 9001 white	PMHB0050-501010
2a	1	Rose Si-line HS 300 internal	RAL 9003 white	PMHB0050-502010
3a	1	Si-line handle cover HS 300 PZ	RAL 8022 brown	PMHB0050-512010
	1	Si-line handle HS PORTAL 300 PZ external Only in connection with handle SiLine HS300 PZ internal for lockable elements-with profile cylinder internal and external comprising:		
1b	1	Si-line handle HS 300 PZ external	EV 1 silver	PMHB0050-524010
2b	1	Rose Si-line HS 300 außen	EV 2 new silver	PMHB0050-526010
3a	1	Si-line handle cover HS 300 PZ	C 33 mid-bronze	PMHB0050-530010
	1	titanium matt bright		PMHB0050-534010
	1	Bit. Anschlagbock bestehend aus:		
50	1	Buffer	RAL 9003 white	821237
51	1	Chipboard screw 4,5 x 70	RAL 9005 black	831922
			mid-bronze	827901

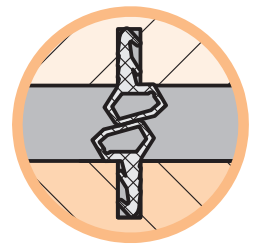
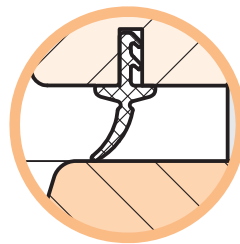
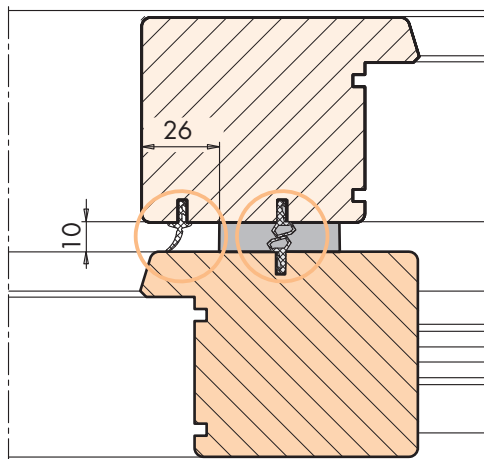
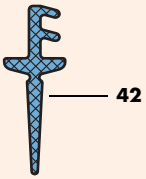
HS-PORTAL 300 Accessories (II)

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:			
	40	1	Lock MV HS PORTAL			
	41	1	Lock plate MV			
	42	1	Sash seal HH0134-04 for 10 mm sash clearance Length 50 m	127148		

HS-PORTAL 300 Accessories (III)

Long Si-line external escutcheon plate

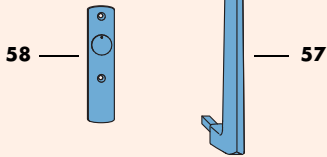


1
56

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

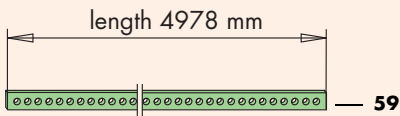
Removable handle

Si-line internal escutcheon plate

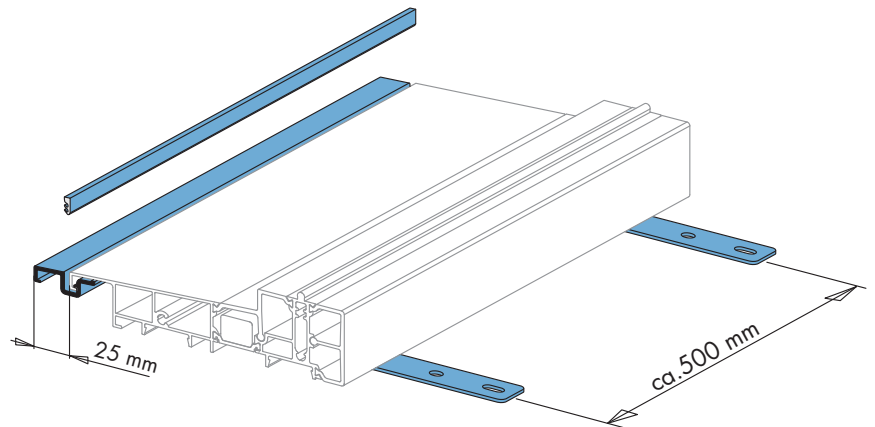
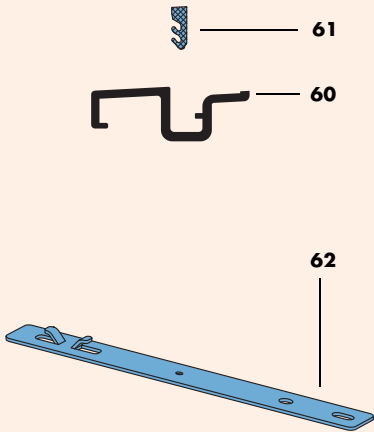


Connecting rod, Size 500

Connecting rod, Size 500 is available in stock lengths

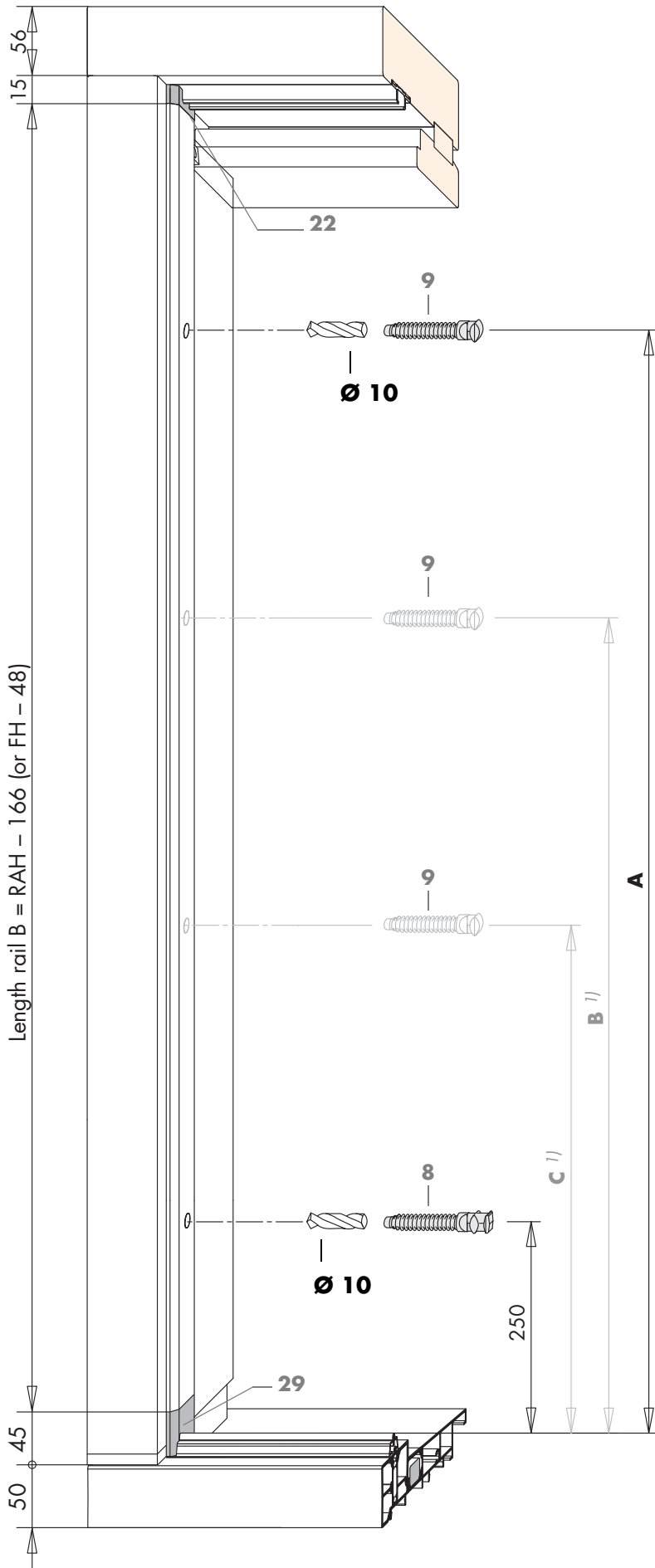


Extension rail HH7646 and fixing cleats



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

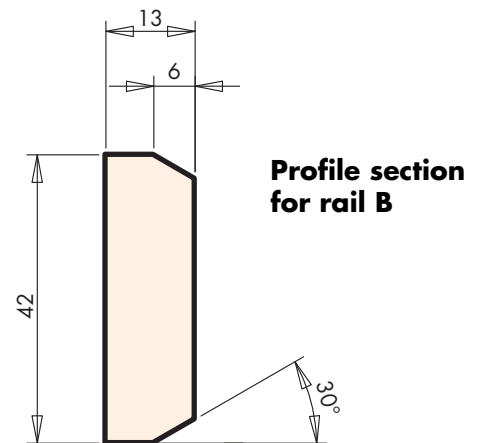


A Fitting the timber rail B

- Cut rail B to length
- Position rail B with bottom end cap (29) and screw on rail B
- Insert top end cap (22) (see also Page 15).

B Fitting the locking bolts (8 and 9).

- Locate centre punch in HS PORTAL 300-PZ gear (43) 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).



Profile section for rail B

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 (43) 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:

HSde1047	HS-PORTAL with guide rail KH013001	Sash thickness 68 mm or.
HSde1049	HS-PORTAL with guide rail KH013001	Sash thickness 66 mm
HSde1051	HS-PORTAL with guide rail KH013001	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:

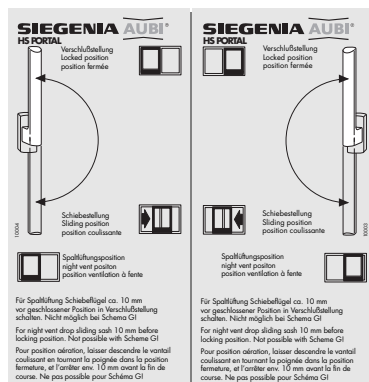
- damp conditions
- aggressive corrosive environments
- salty atmospheres
- on corrosive timbers or timber treated with corrosive substances

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:

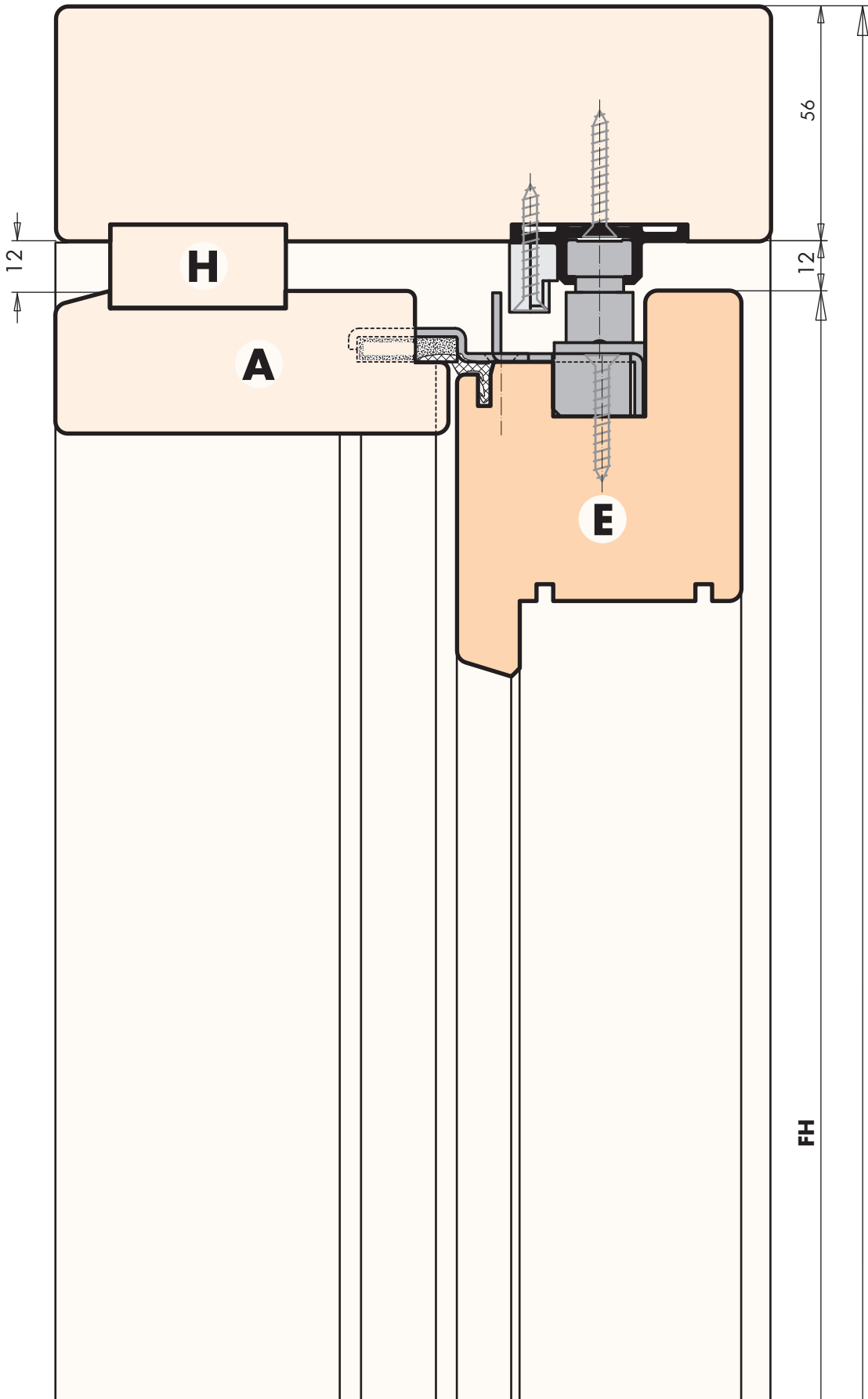
- assembly has not been performed as detailed in our instructions or other specification provided,
- the hardware has been subject to misuse or other external influences,
- the hardware has been modified by a third party,
- un approved combination with other hardware or hardware from another supplier 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

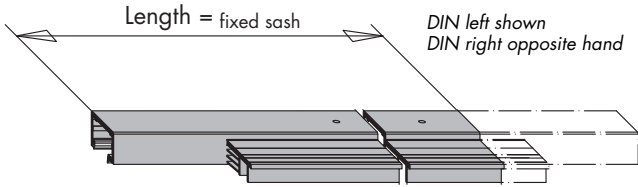
The following abbreviations are used in this document:

HS-PORTAL 300 Vertical cross section, Top

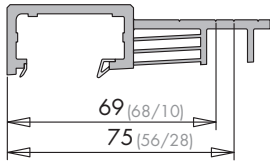
Note: Drawings on pages 11 - 13 and 16 are **not** to scale.



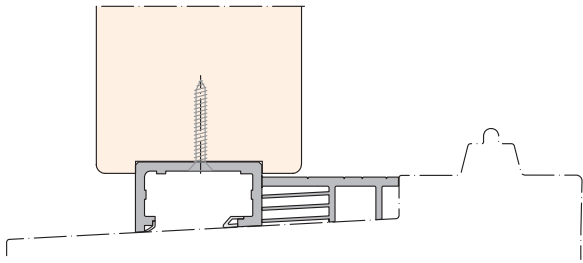
HS-PORTAL 300 Frame: Assembly of components (I)



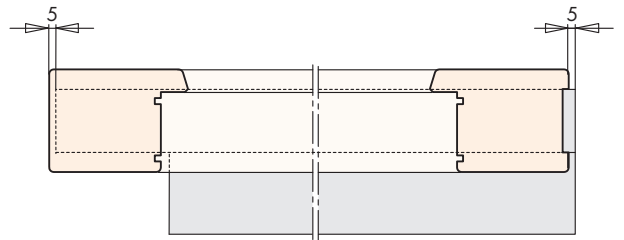
Diag. 1



Diag. 2



Diag. 3



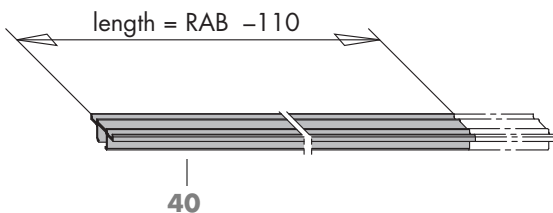
Diag. 4

Assembly sequence

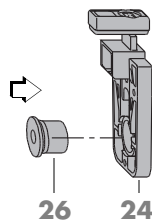
- A** Fixing the support rail HH0132-06 (39) to the fixed sash.
- Cut the support rail HH0132-06 (39) to length according to the sliding direction DIN left or DIN right (Diag. 1).
 - Dependent on the sash thickness / sash clearance 56/28 or 68/10 the support rail must be cut to width along the corresponding notch (Diag. 2).
 - Screw on the support rail HH0132-06 (39) (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 (27) into support rail HH0132-06 (39) and seal it.

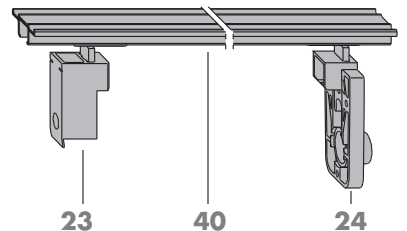
- C** Installing the guide rail KH0130-01 (40).
- Cut the guide rail KH0130-01 (40) to length (Diag. 5).
 - Push buffer (26) into top rear guide (24) (Diag. 6)
 - Screw the guide rail KH0130-01 (40) with the top front guide (23) pushed in, and top rear guide (24) (Diag. 7) onto the frame (see Page 11).



Diag. 5

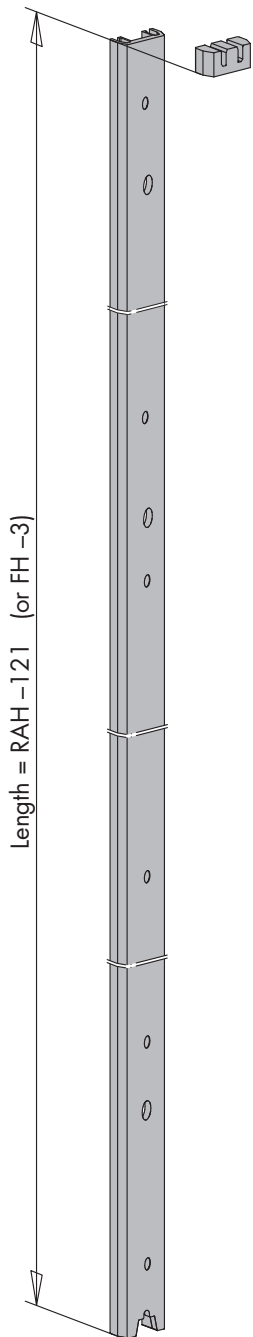


Diag. 6



Diag. 7

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



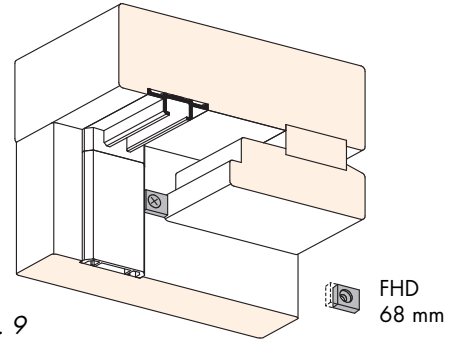
Diag. 8

- D** Fitting the sealing rail B (44).
- Cut the sealing rail B (44) to length (Diag. 6).
 - Position the sealing rail B (44) and screw on.
 - Adjust top end cap (22) to suit the sliding direction DIN left or DIN right (Diag. 6) and insert it.

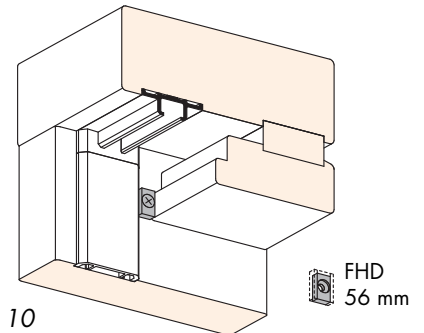
- E** Fitting the top sealing part (12).
- Screw on top sealing part (12) to suit Sash thickness 68 mm (Diag. 9) or 56 mm (Diag. 10)

- F** Fitting the sealing part FA 10 mm (14).
- For 10 mm sash clearance insert sealing part FA 10 mm (14) and secure with securing pad FA 10 mm (15) (Diag. 11).

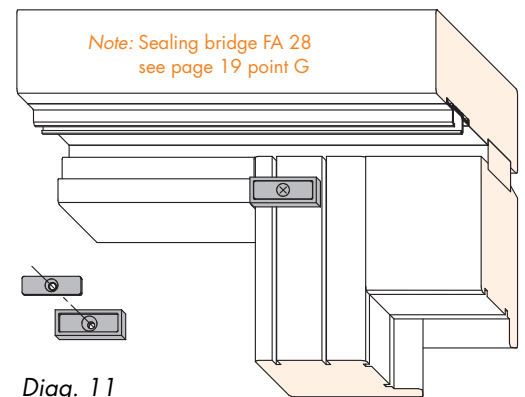
- G** Fitting the sealing block (11)
- For sash thicknesses / sash clearance 56/10, 56/28 or 68/10 cut off the sealing block (11) at the appropriate cutting points (Diag. 9).
 - Fit the sealing block (11) and seal or glue it on.



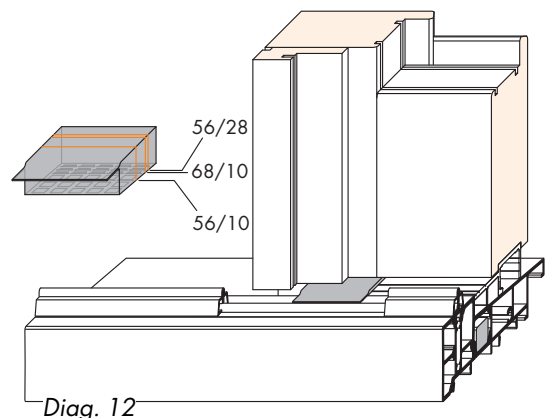
Diag. 9



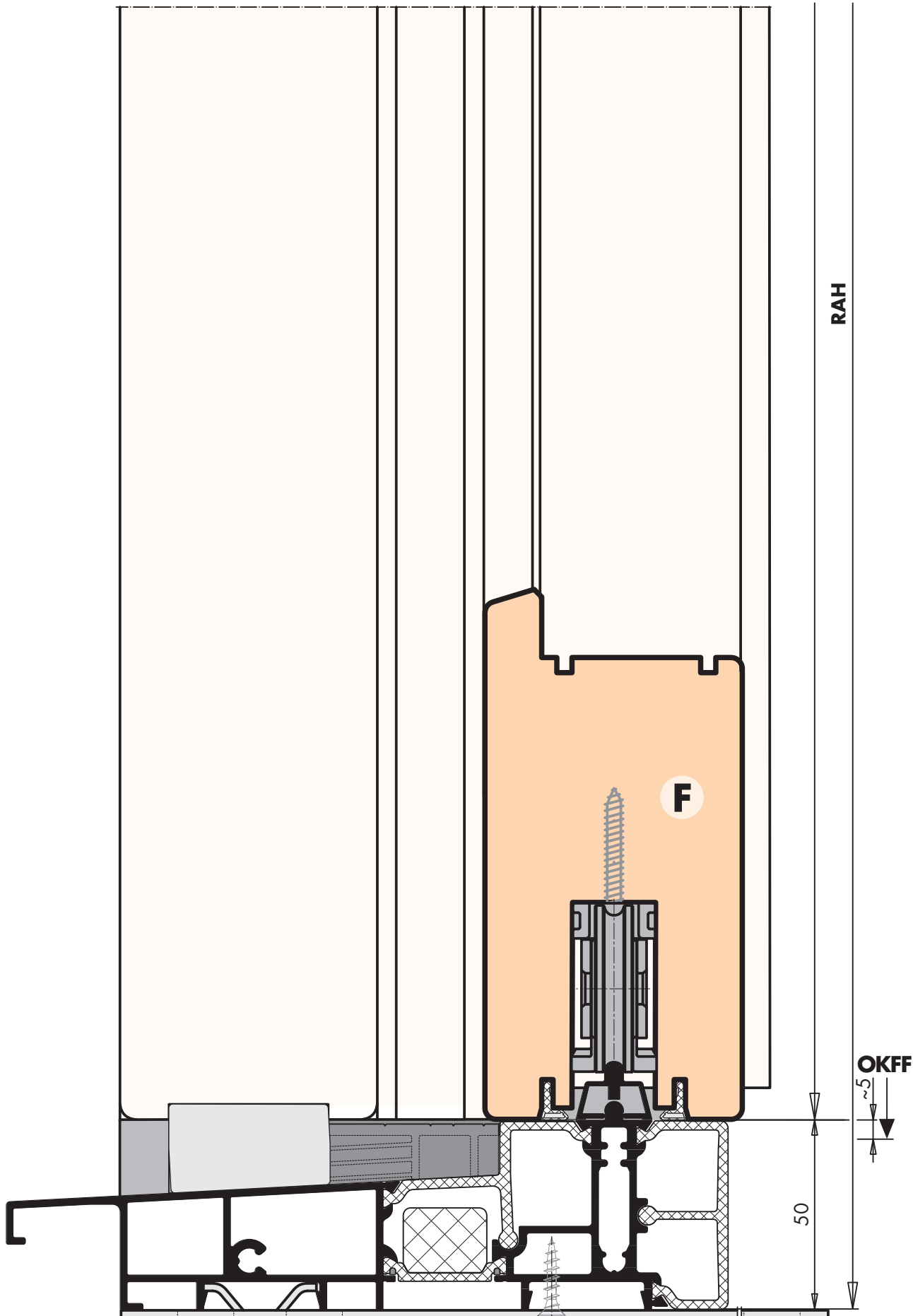
Diag. 10



Diag. 11



Diag. 12



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)

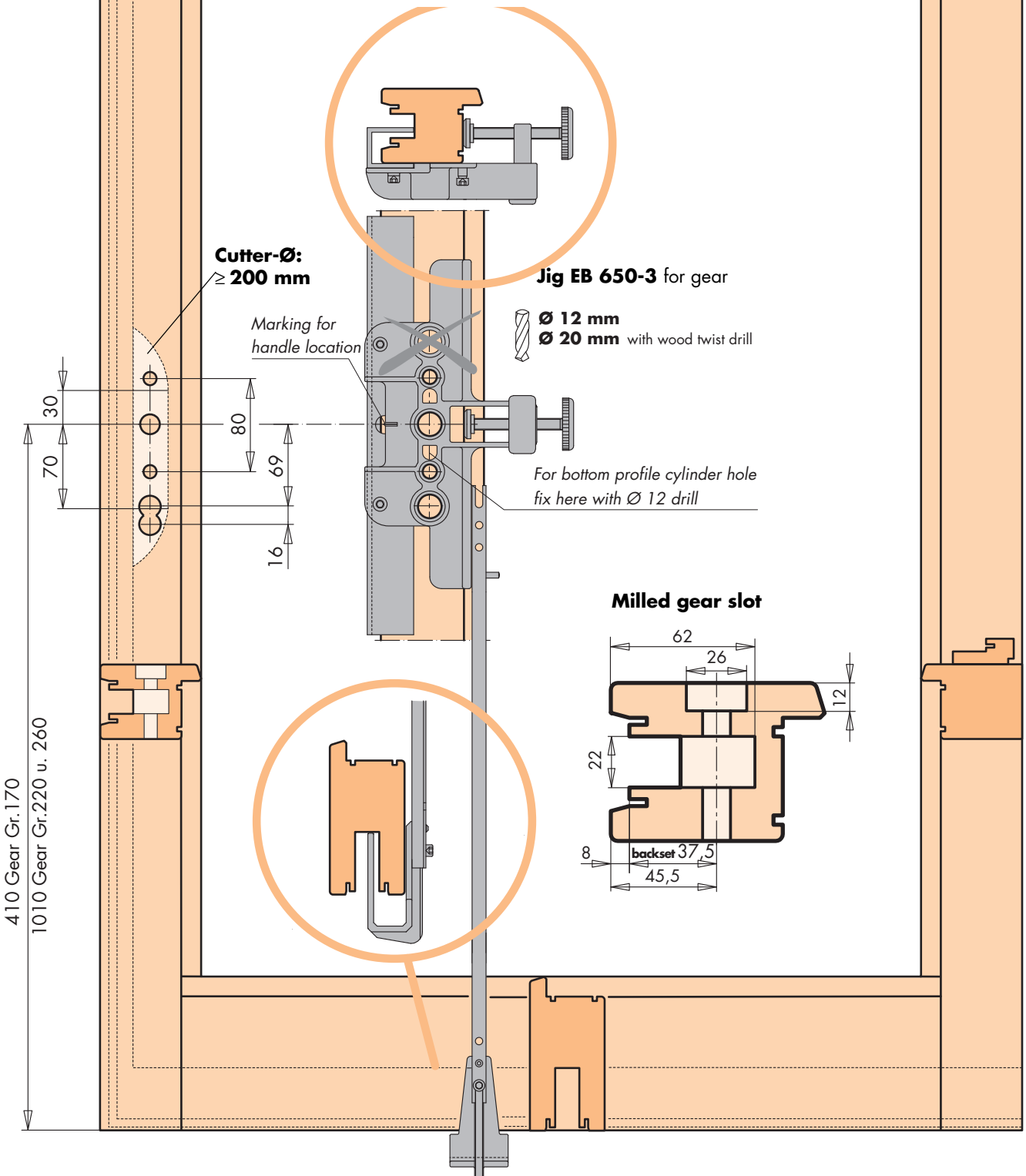
All dimensions (in mm) and details for:

Timber element made to the following SIEGENIA drawings:

HSde1047 HS-PORTAL with guide rail KH0130-01, sash thickness 68 mm

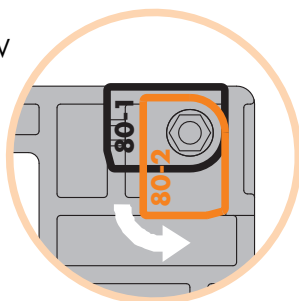
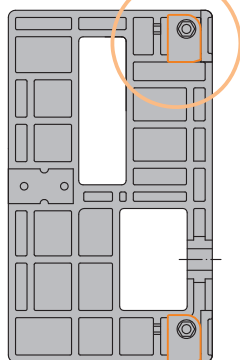
HSde1049 HS-PORTAL with guide rail KH0130-01, sash thickness 66 mm

HSde1051 HS-PORTAL with guide rail KH0130-01, sash thickness 56 mm

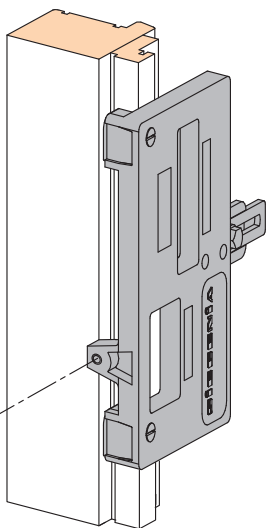


HS-PORTAL 300 Preparation of the sash (II)

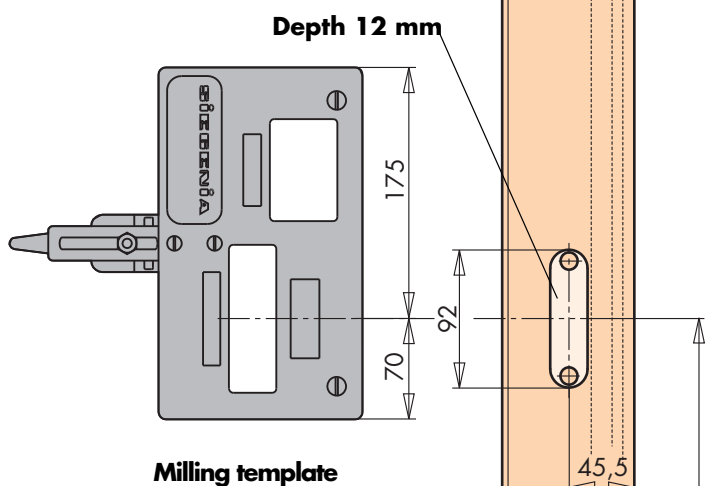
N.B.: Set the stops on the milling template for sliding grip and MV to hardware type 80-2.



Sash drawn from the exterior view



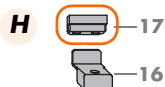
If using the centre lock bag, drill a $\varnothing 7$ mm hole for locking bolt, Item. (52) (see also Page 7).



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

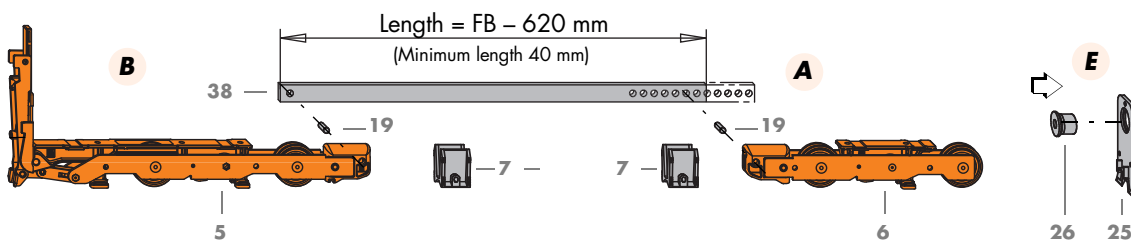
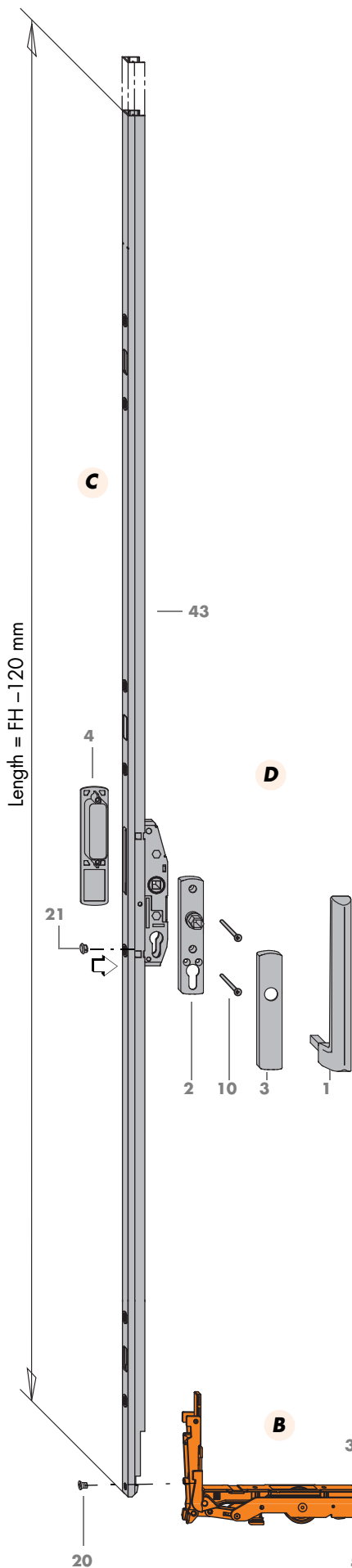
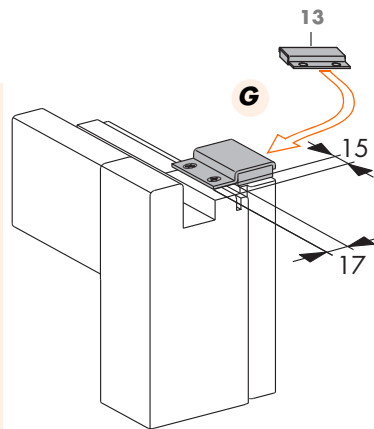
410 Gear Gr.170
1010 Gear Gr.220 u. 260

HS-PORTAL 300 Frame: Assembly of parts



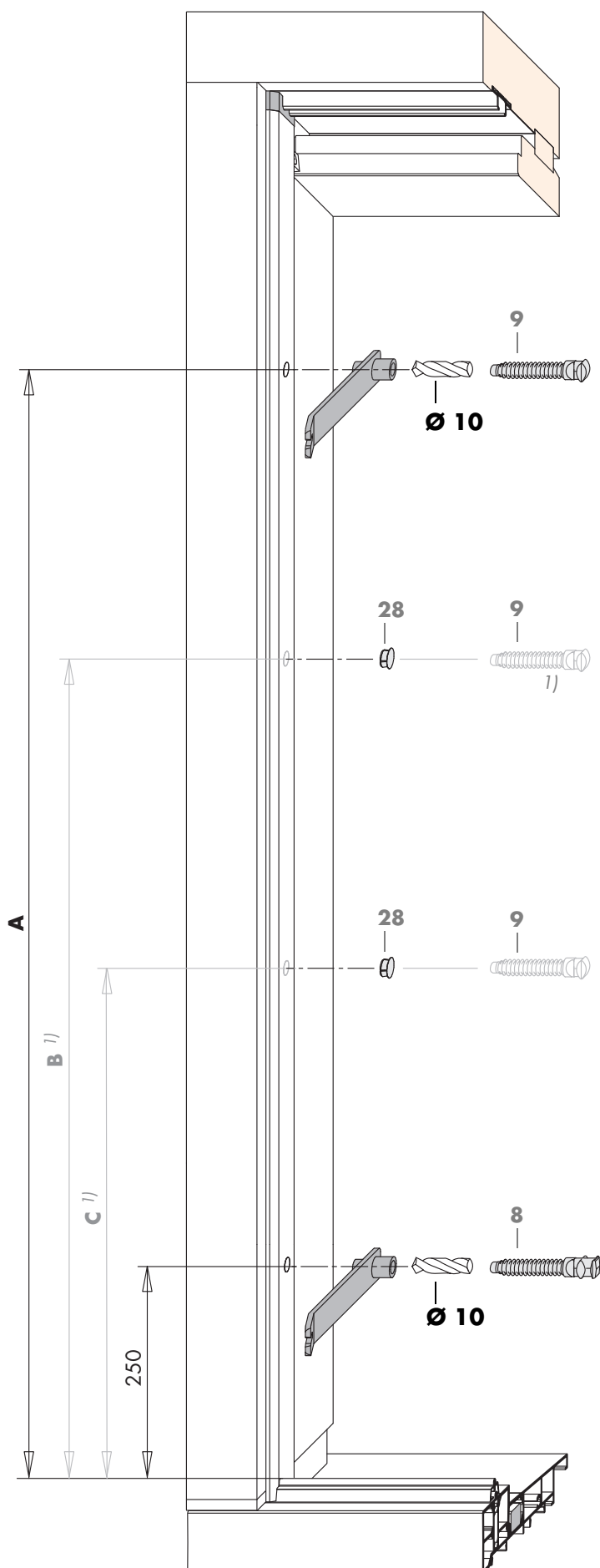
Assembly sequence

- A** Connecting the HS corner drive (5) and HS bogie (6).
- First insert the cut-to-length connecting rod (38) into the coupling piece of the HS corner drive (5) and join with 6 x 16 dowel pin (19).
 - Insert connecting rod (38) into the coupling piece of the HS bogie (6) and similarly join with 6 x 16 dowel pin (19).
- B** Fit the complete bogie unit into the sash.
- Screw on the HS corner drive (5) and HS bogie (6).
 - Screw on the bottom guide (7).
- C** Fitting the gear (43).
- Move the cut-to-length gear (43) into the locking position (handle upwards).
 - Insert gear (43) into the sash and couple to the HS corner drive (5).
 - Secure the gear (43) at the bottom with M5 x 13 countersunk screw (20). For other screws see Page 13.
 - Clip cap (21) 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 bottom rear cover plate (25)
- Push a buffer (26) into the bottom rear cover plate (25).
 - Screw the bottom rear cover plate (25) on the sash.
- F** Fitting the seals (no diagram).
- Cut seal HH0134-02 (30) and top seal HH0134-05 (18) to size and press in. See Page 11 to 13 and 16.
- G** Fixing the sealing bridge FA 28 mm the sealing bridge FA 28 mm (13)
- For a 28 mm sash clearance screw the sealing bridge FA 28 mm (13) on the sash.
- H** Fixing the top horizontal centre lock.
- Screw the top lock MV (16) to the centre of the sash (see also Page 11)
 - **Only after inserting** the sliding sash, screw top lock plate MV (17) onto guide rail (40). (see also Page 11)



Note: 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**).
- Predrill 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 (**28**) 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 (**43**) 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 (**24**), with the buffer (**26**) pressed in, and the top front guide (**23**) 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**).