



CASEMENT 30.5
WINDOW (30.5mm)

CASEMENT 30.5 WINDOW (30.5mm)

General Documentation Disclaimer

This manual is intended as a manufacturing and installation advisory document. For correct specifications, sizing of profiles and structural information please consult the StarFront Application. If the information you require is not available through the StarFront Application, please contact your stockist before proceeding. It is advisable to have all sizing and performance criteria checked by a qualified structural engineer to ensure that the required criteria will be met.

All information, recommendations or advice contained in this documentation is given in good faith to the best of Wispeco's knowledge and is based on current procedures in effect.

Since the actual use of this documentation by the user is beyond the control of Wispeco, such use is within the exclusive responsibility of the user. Wispeco cannot be held responsible for any loss incurred through incorrect or faulty use of this documentation. Training of Wispeco systems is important for ensuring correct procedures in the manufacturing of products.

Great care has been taken to ensure that the information provided is correct.

Ensure that you have the latest available manual. The revision number and date can be checked on the latest StarFront version.

Wispeco will accept no responsibility for any errors and/or omissions, which may have inadvertently occurred.

Specifications concerning products and applications

This manual is based on standard configurations only. As there are many configurations not covered in this manual, contact your stockist with regards to a configuration not represented herein if required.

AutoDesk drawings (CAD Symbol Library) are available on request and can be issued with the consent of the Wispeco Technical Department.

All mechanical joints must be sealed with a **Crealco approved joint sealer**. Failure to correctly seal the joints can affect the performance of the system. Information on joint sealing can be found in the Cleaning & Maintenance Manual available for download from the Wispeco website or from StarFront.

All drawings in the Wispeco Documentation are NOT to scale and are used for illustrative purposes only.

Wispeco will not accept responsibility for the use of standard products since Wispeco does not know where these products are being installed.

The hardware recommended in this documentation is suitable for use in most atmospheric environments. When hardware is used in severe coastal environments the manufacturer of the hardware must be consulted.

The use of non-specified hardware or incorrect mechanical fasteners can adversely affect the mechanical and weathering performance of the system and we strongly advise against deviations. A Wispeco Consultant can advise you of any hardware issues and limitations with regard to this system.

The use of anti-magnetic stainless steel screws and aluminium pop rivets is recommended to reduce galvanic corrosion in harsh environments.

Fixing lugs on frames must be positioned as per the user manual and used in accordance to the AAMSA specifications. When profiles are screwed together the screw centres must also be according to the user manual or as specified by an engineer.

All glass used within Wispeco products must comply with SAGGA regulations. Laminated glass must not stand in water.

By continuing to use this documentation you acknowledge that you understand and accept the legal disclaimer.

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Index	ii
Legal Disclaimer.....	1

General System

Profile Identification.....	3-4
Hardware Components	5-6
Maintenance of Friction Stay.....	7
Butterfly Gasket & Wedge Codes	8
Sash Limitation Guides	9
Typical Configurations	
Standard Top Hung Window	10
Standard Side Hung Window	11
Cottage Pane Fixed Panel	12
Cottage Pane Top Hung & Side Hung	13
Fastening Positions.....	14
Typical Cross Sectional Details.....	
Double Top Hung Over Fixed.....	15
Side Hung Over Fixed.....	16
Cottage Pane 2x2 Top Hung Over 2x1 Fixed Panel.....	17
Cottage Pane Side Hung Over Fixed Panel.....	18
Outer Frame Construction	19
Sash Frame Construction	20
Outer Frame Machining Details	
Equal Leg	21
Unequal Leg	22
54mm	23
70mm	24
Lite Equal Leg.....	25
Mullion Machining Details	
Standard Machining Detail for End Milling on Equal Leg Outer Frame	26
Standard Machining Detail for End Milling on Unequal Leg Outer Frame	27
Standard Machining Detail for End Milling on 54mm Outer Frame	28
Standard Machining Detail for End Milling on 70mm Outer Frame.....	29
Standard Machining Detail for End Milling on Lite Equal Leg Outer Frame	30
Transom with W/Bar Machining Details	
for End Milling on Equal Leg Outer Frame	31
for End Milling on Unequal Leg Outer Frame	32
for End Milling on 54mm Outer Frame	33
for End Milling on 70mm Outer Frame	34
for End Milling on Lite Equal Leg Outer Frame	35
54mm Mullion Machining Detail	
for End Milling on Equal Leg Outer Frame	36
for End Milling on Unequal Leg Outer Frame.....	37
for End Milling on 54mm Outer Frame.....	38
for End Milling on 70mm Outer Frame.....	39
for End Milling on Lite Equal Leg Outer Frame.....	40

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

CASEMENT 30.5 WINDOW (30.5mm)

70mm Mullion Machining Detail	
for End Milling on Equal Leg Outer Frame	41
for End Milling on Unequal Leg Outer Frame	42
for End Milling on 54mm Outer Frame	43
for End Milling on 70mm Outer Frame	44
for End Milling on Lite Equal Leg Outer Frame	45
Cottage Pane Mullion Machining Detail.....	
for End Milling on Equal Leg Outer Frame	46
for End Milling on Unequal Leg Outer Frame	47
for End Milling on 54mm Outer Frame	48
for End Milling on 70mm Outer Frame	49
for End Milling on Lite Equal Leg Outer Frame	50
Lite Mullion Machining Detail.....	
for End Milling on Equal Leg Outer Frame	51
for End Milling on Unequal Leg Outer Frame	52
for End Milling on 54mm Outer Frame	53
for End Milling on Lite Equal Leg Outer Frame	54
Corner Cleat Assembly Detail.....	
for Lite Sash.....	55
Mullion Packer Assembly Detail.....	56
Cross Joint Assembly Detail.....	
Lite Mullion.....	57
Cottage Pane Mullion.....	58
Friction Stay Assembly Detail.....	59
Handle Assembly Detail.....	60
Bead Cut-Out for Setting Block.....	61
Euro Sash	
Cross-Sectional Details.....	62
Corner Joint Detail.....	
Option A - Using the Joining Corner.....	63
Option B - Using the Corner Connector.....	64
Machining Detail.....	
Sash & Locking Bar.....	65
Handle.....	66
Fitting of Euro-Sash Handles.....	67
Cutting Detail for Bead	68
Assembly Detail.....	
Corner Joint.....	69
Corner Connector.....	70
Locking Angle Detail.....	71
Outer Frame Drainage Detail.....	72
Position of Locking Bar.....	73
Fitting of Sash Spacer.....	74
Glazing Procedure.....	75-76

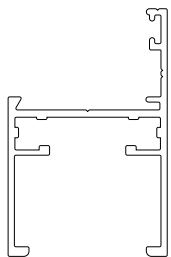
CASEMENT 30.5

WINDOW (30.5mm)

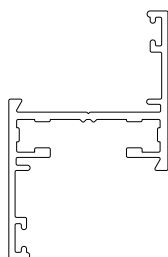
PRODUCT MANUAL

Profile Identification

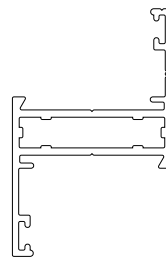
Case30.5 Window Profiles



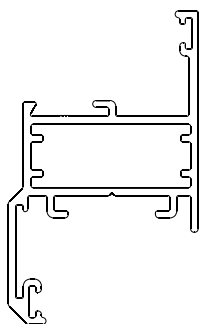
DIE No. W32028A Cas30.5 Frame
30mm Equal Leg



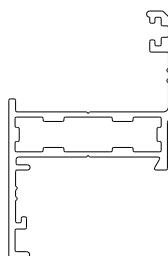
DIE No. W32027 Cas30.5 Frame
30mm Unequal Leg



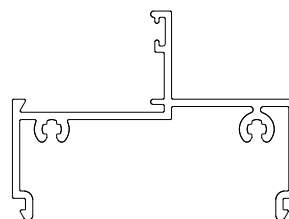
DIE No. W55684A Cas30.5
Sash Tubular



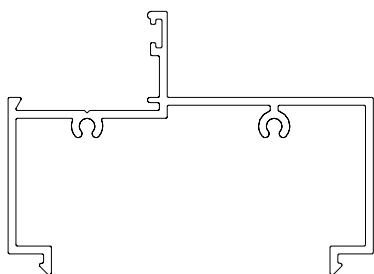
DIE No. W57602 Cas30.5 Sash
Euro



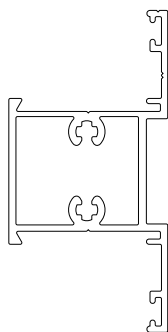
DIE No. W55441 Sash
Picture Frame



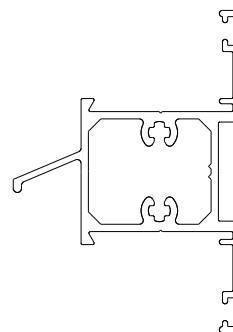
DIE No. W28481 Frame
54mm



DIE No. W70968 Frame 70mm



DIE No. W55685A Cas30.5 Mullion
30mm Standard



DIE No. W53630 Cas30.5 Mullion
30mm Weather Bar

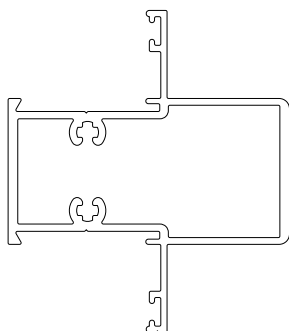
CASEMENT 30.5

WINDOW (30.5mm)

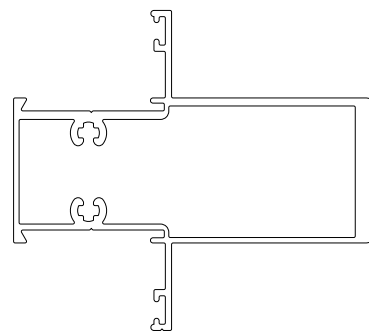
PRODUCT MANUAL

Profile Identification

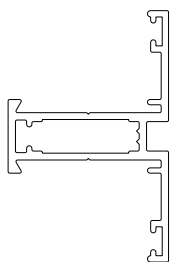
Case30.5 Window Profiles



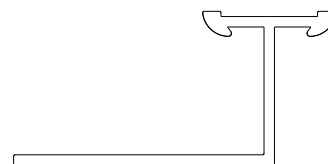
DIE No. W54651A Cas 30.5 Mullion
54mm



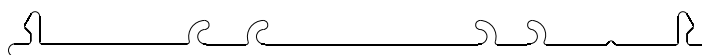
DIE No. W54652A Cas30.5 Mullion
70mm



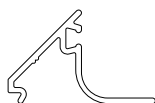
DIE No. W54867 Cas30.5 Mullion
30mm Cottage Pane



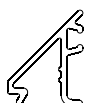
DIE No. W28002 Cas30.5 Fixing
Lug Twist In



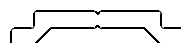
DIE No. W30607 Fixing Lug



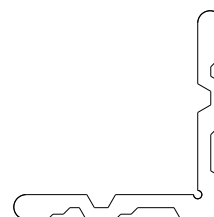
DIE No. W31139A Cas30.5 Bead
Multi 13mm Gap



DIE No. W35620 Cas30.5 Bead
Euro 13mm Gap



DIE No. W29131 Locking Bar



DIE No. W27989 Cas30.5 Corner
Cleat 40mm

CASEMENT 30.5

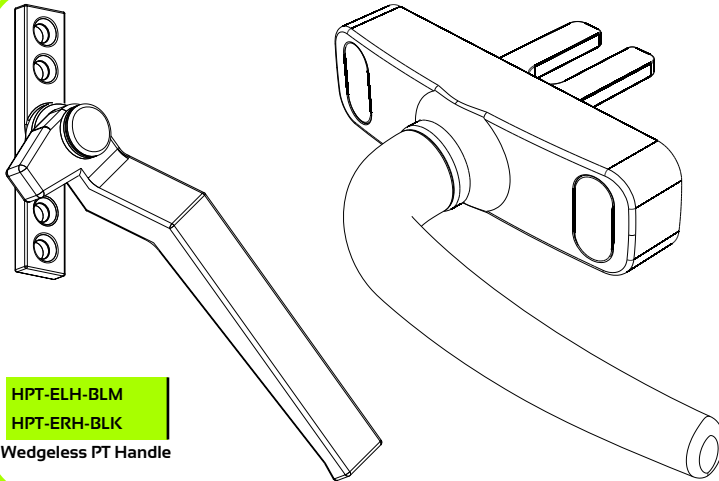
WINDOW (30.5mm)

PRODUCT MANUAL

Hardware Components

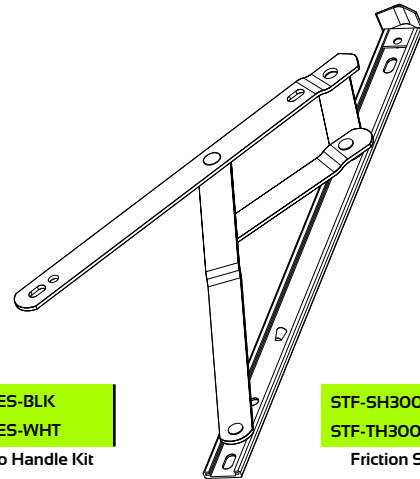
RECOMMENDED CASEMENT 30.5 COMPONENTS

All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com

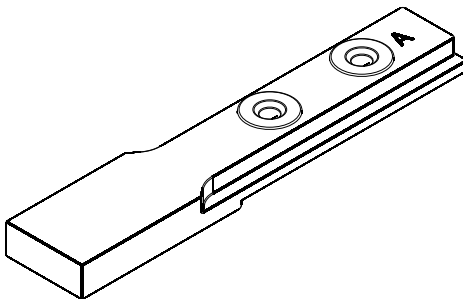


HPT-ELH-BLK
HPT-ERH-BLK
Wedgeless PT Handle

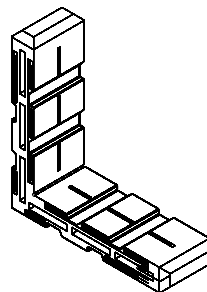
HPT-ES-BLK
HPT-ES-WHT
Euro Handle Kit



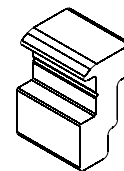
STF-SH3005-304
STF-TH300R-304
Friction Stay



TLP-CJ
Euro Sash Jig



LGR-CCES
Euro Sash Corner Connector



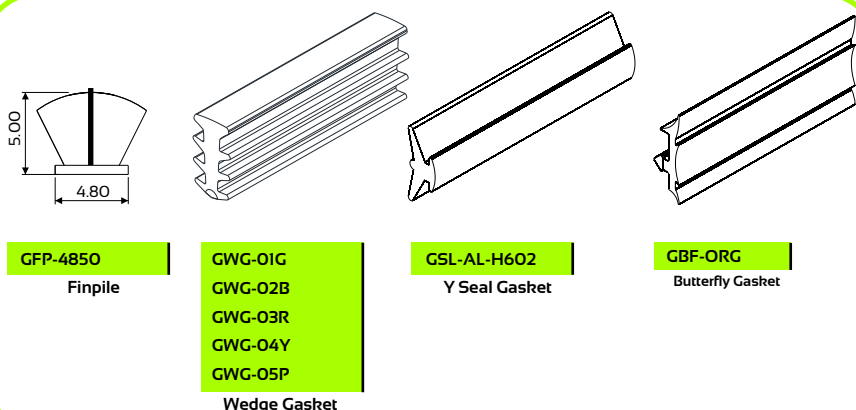
HPT-ESS
Euro Sash Spacer



SGD-FM48
Frame Mitre Guide



SGD-FMG520
Alignment Mitre Corner

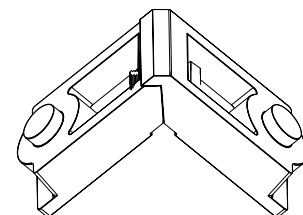


GFP-4850
Finpile

GWG-01G
GWG-02B
GWG-03R
GWG-04Y
GWG-05P
Wedge Gasket

GSL-AL-H602
Y Seal Gasket

GBF-ORG
Butterfly Gasket



LGC-J24ION
Joining Corner

CASEMENT 30.5

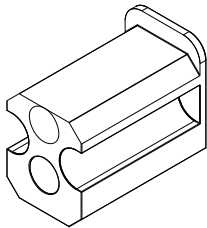
WINDOW (30.5mm)

PRODUCT MANUAL

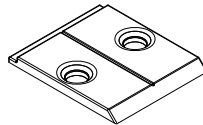
Hardware Components

RECOMMENDED CASEMENT 30.5 COMPONENTS

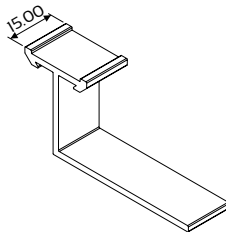
All hardware is available through our Stockists as well as through Crealco Components, and can be viewed on www.crealco-components.com



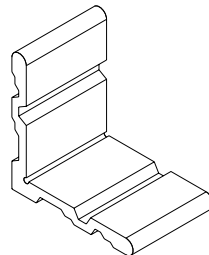
LGR-CC305B
30.5 Cross
Connector (Black)



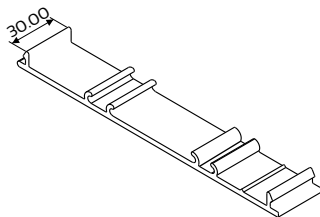
LGR-MP305B
Casement 30.5
Glazing Bar Packer (Black)



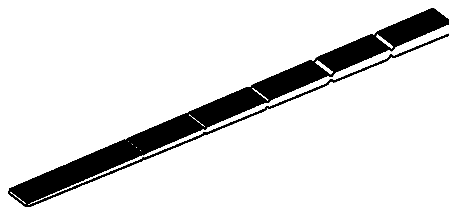
W3142
28 Fixing Lug
Alum 15mm



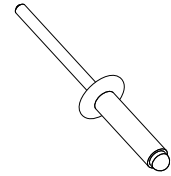
LGC-52695-28
30.5 Caselite
Corner Cleat



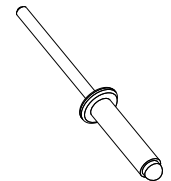
W30607
Multi Fixing Lug
Alum 15mm



FSN-CSB
Glass Setting Blocks



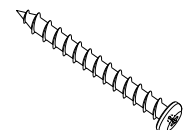
FRC-410
C/Sunk Rivet



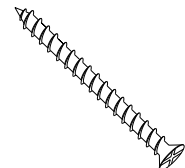
FRD-4810
Dome Rivet



FSC-0809HBP
Handle Screw - Blunt Point
8x9 C/S



FSP-0830P-SS
P/Head POSI
8x30 S/S Screw



FSC-0840P-SS
Countersunk POSI
8x40 S/S Screw

CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

Maintenance of the Friction Stay

With a minimal amount of care and maintenance your CREALCO CASEMENT windows will stay looking good and performing superbly for many years to come - a valuable, long lasting asset giving continued satisfaction and pride.

Basics of a Friction Stay

A friction stay is a type of hinge that controls the opening of the window so that it will stay open at the width you decide to open it to, not closing under its own weight or being too difficult to open and close.

Friction Stay Maintenance

As the name implies, a friction stay needs a level of friction to operate correctly. Too much friction and the friction stay arms can be bent in operation and the window will be stiff and difficult to open. Too little friction and the window will not stay at its required level.

Key to the correct sealing of the casement sash is the top alignment guide which maintains the friction stay in the closed and sealed position. If the shape of the guide is altered or flared it can result in poor sealing of the sash as well as incorrect alignment of the friction stay.

Track Maintenance

Ensure that the track is free from dirt and debris which can alter the friction of the hinge. It is best not to add lubricants as this can alter the friction as well as collect more debris which can cause wear within the track.

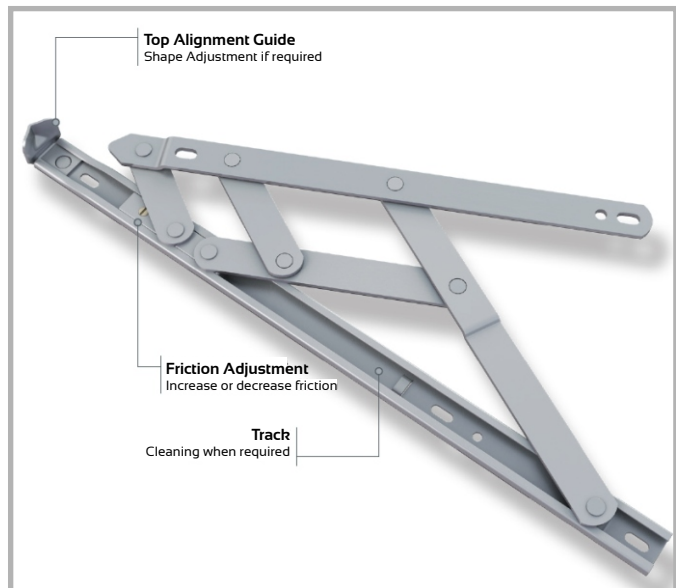
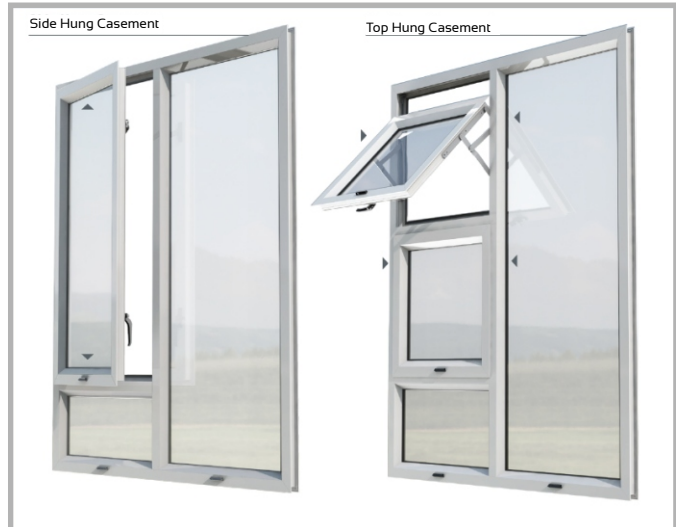
Friction Adjustment

The hinge is factory set and may after continue use become loose. Should this occur using a small flat bladed screwdriver turn the screw on the friction hinge clockwise to increase the amount of friction.

The same adjustment should be made to both the hinges on the window. Also should the window be stiff in operation turn the screw anti-clockwise until the desired result is achieved.

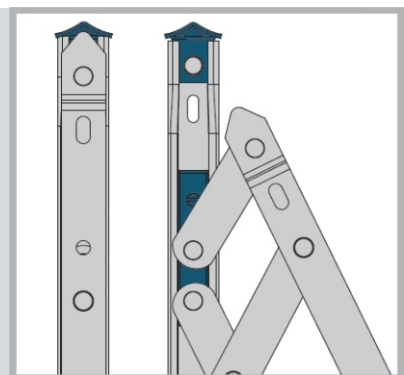
Top Alignment Guide

The top alignment guide can flare or distort due to a number of issues. For correct operation it is important to bend the alignment guide back into position.



Correct Shape and Seating for Top Alignment Guide

Straighten the Guide with pliers or suitable tool

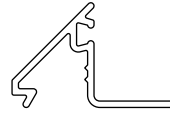




Butterfly Gasket



GBF-ORG



W31139 BEAD



Wedge Gasket



GWG-01G



Wedge Gasket



GWG-02B



Wedge Gasket

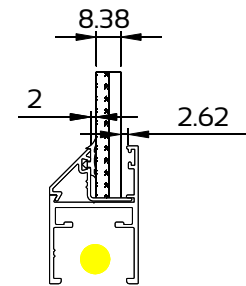
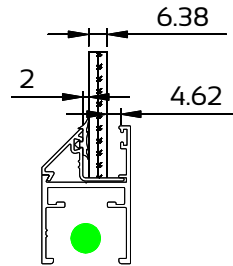
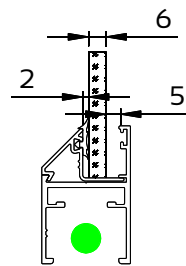
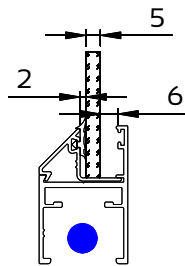
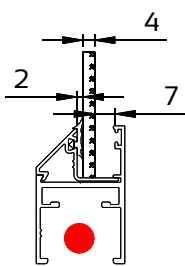


GWG-03R



GWG-04Y

WEDGES



CASEMENT 30.5 WITH W31139 BEAD

CASEMENT 30.5

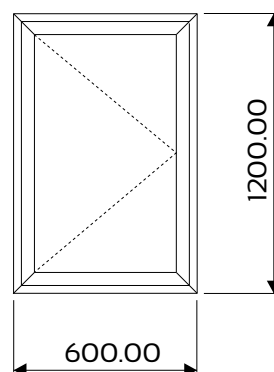
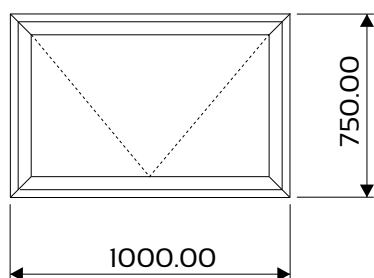
WINDOW (30.5mm)

PRODUCT MANUAL

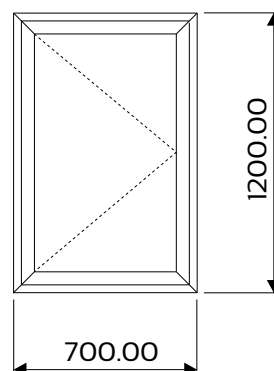
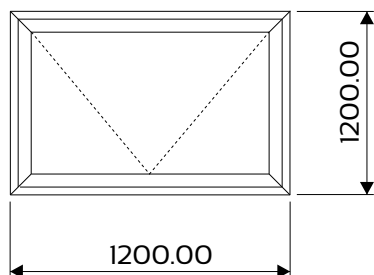
Sash Limitation Guide

The sash limitations of the system are strictly calculated in accordance to AAMSA guidelines and take into account the aluminium specifications as well as the glass used. Please ensure that these are adhered to as any product produced outside of these limitations will not adhere to AAMSA regulations.

STANDARD SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W55684	1000	750
Side Hung		600	1200

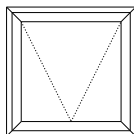


EURO SASH		Maximum Vent Width in mm	Maximum Vent Height in mm
Top Hung	W57602	1200	1200
Side Hung		700	1200

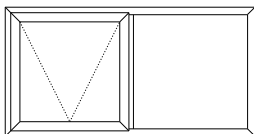


Typical Configurations

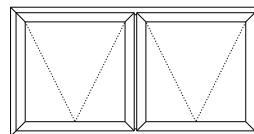
Standard Top Hung Window



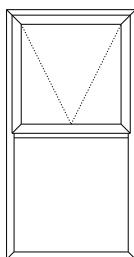
A
SINGLE TOP HUNG



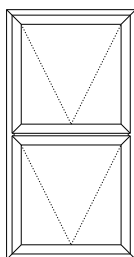
BB
TOP HUNG
NEXT TO FIXED



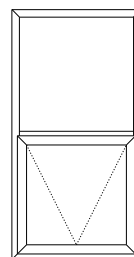
CC
TOP HUNG NEXT
TO TOP HUNG



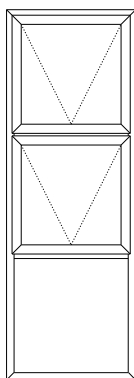
B
TOP HUNG
OVER FIXED



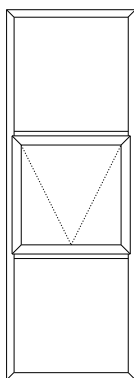
C
TOP HUNG
OVER TOP HUNG



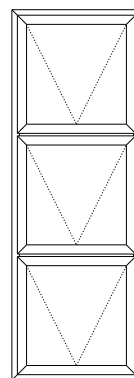
E
FIXED OVER
TOP HUNG



D
DOUBLE TOP HUNG
OVER FIXED



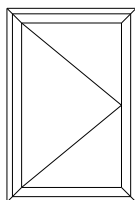
DD
FIXED OVER
TOP HUNG
OVER FIXED



EE
TRIPLE TOP HUNG

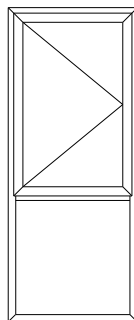
Typical Configurations

Standard Side Hung Window



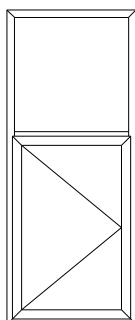
A

SINGLE SIDE HUNG



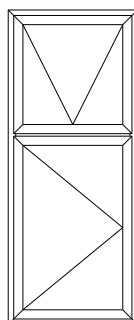
B

SIDE HUNG
OVER FIXED



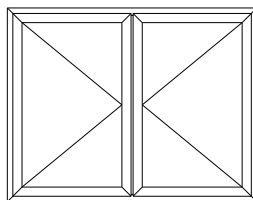
C

FIXED OVER
SIDE HUNG



D

TOP HUNG
OVER SIDE HUNG

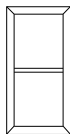


CC

SIDE HUNG NEXT
TO SIDE HUNG

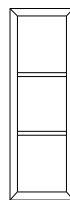
Typical Configurations

Cottage Pane Fixed Panel Window



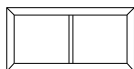
A

1 x 2 FIXED PANEL



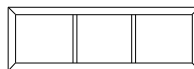
B

1 x 3 FIXED PANEL



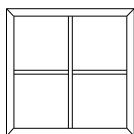
C

2 x 1 FIXED PANEL



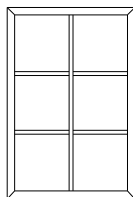
D

3 x 1 FIXED PANEL



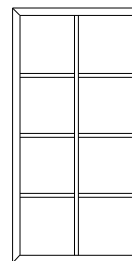
E

2 x 2 FIXED PANEL



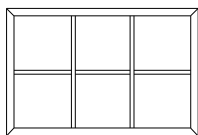
F

2 x 3 FIXED PANEL



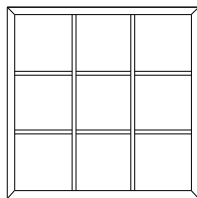
G

2 x 4 FIXED PANEL



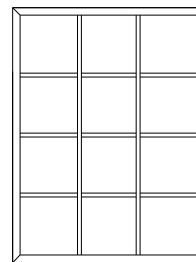
H

3 x 2 FIXED PANEL



I

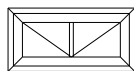
3 x 3 FIXED PANEL



J

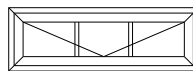
3 x 4 FIXED PANEL

TOP HUNG



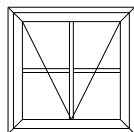
P

2 x 1 PANE
SINGLE TOP HUNG



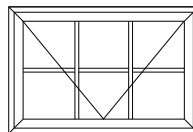
R

3 x 1 PANE
SINGLE TOP HUNG



Q

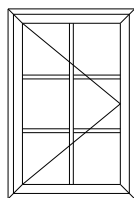
2 x 2 PANE
SINGLE TOP HUNG



S

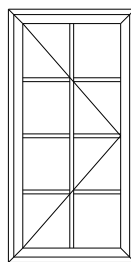
3 x 2 PANE
SINGLE TOP HUNG

SIDE HUNG



P

2 x 3 PANE
SINGLE SIDE HUNG



Q

2 x 4 PANE
SINGLE SIDE HUNG

CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

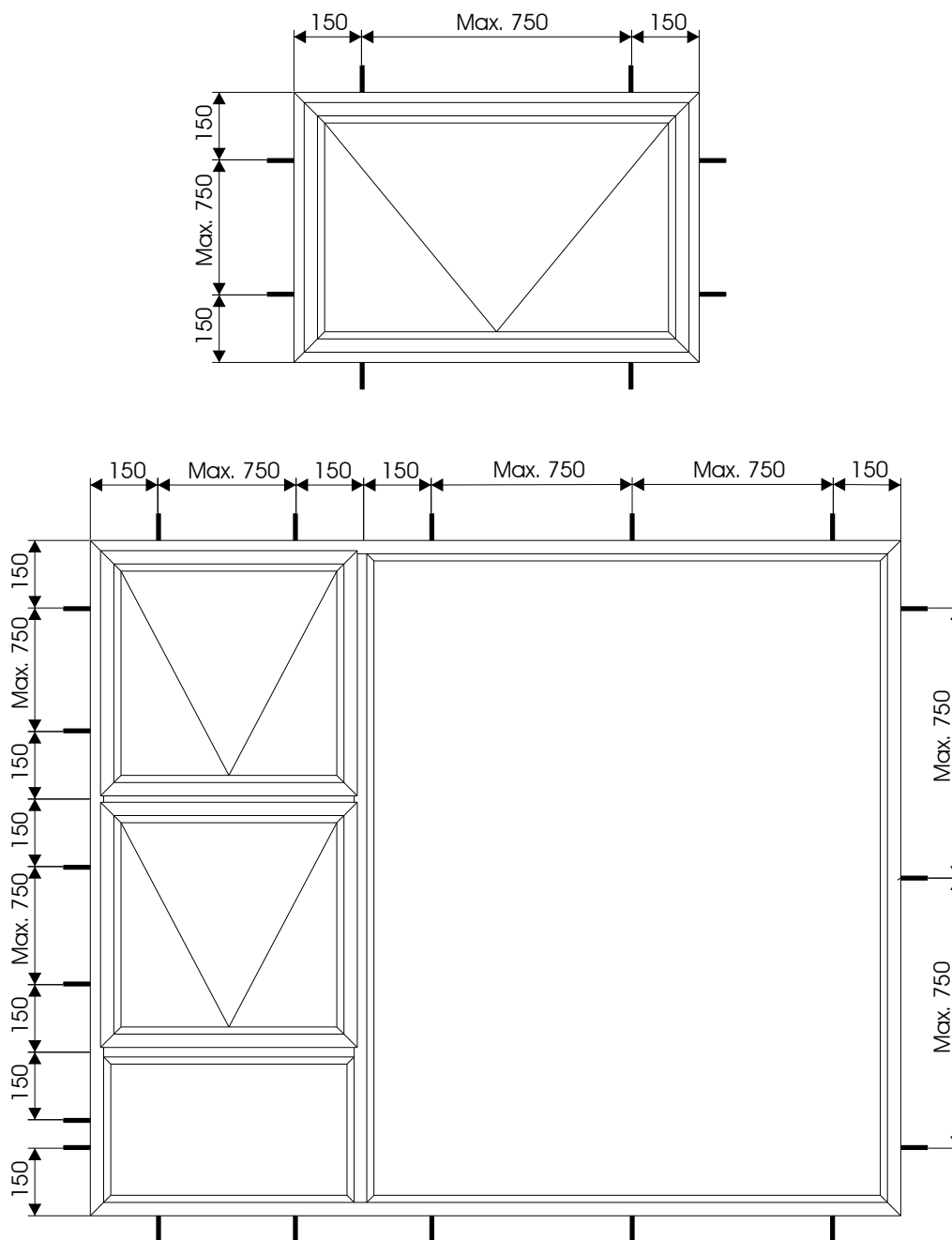
Fastening Positions

IMPORTANT:

As there are many different methods of fixing the window to the structure, the illustration below is a general fixation detail. The illustration defines the general method and hole fixing. Before installation or machining of the holes, please ensure that you have checked the required fixing method with the appropriated building engineer and that your chosen methods meets their specifications

Failure to fix the window to correct building or engineer specifications will result in the door not meeting the required specifications.

DISCLAIMER: Please note that fixation of the frame to the structure is an element which **MUST** be specified and certified by an appropriate engineer and is not the responsibility of Wispeco.



CASEMENT 30.5

WINDOW (30.5mm)

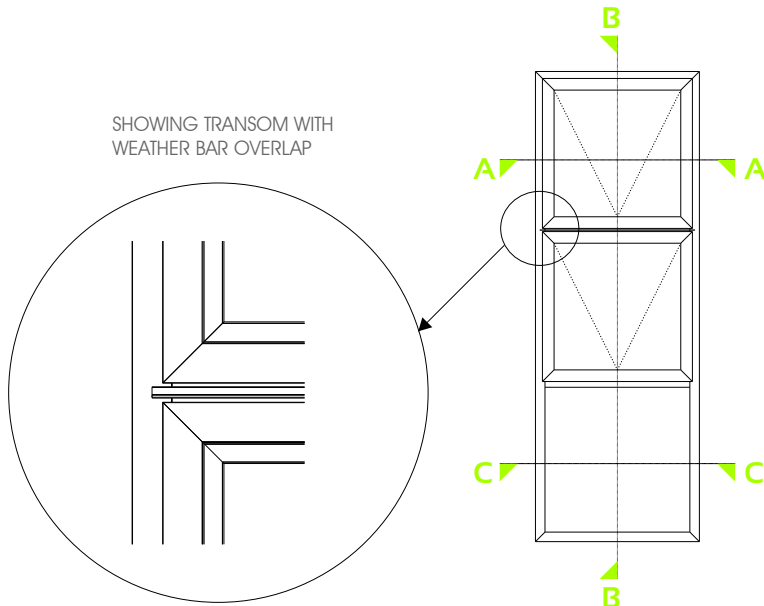
PRODUCT MANUAL

Typical Cross-sectional Details

Double Top Hung Over Fixed

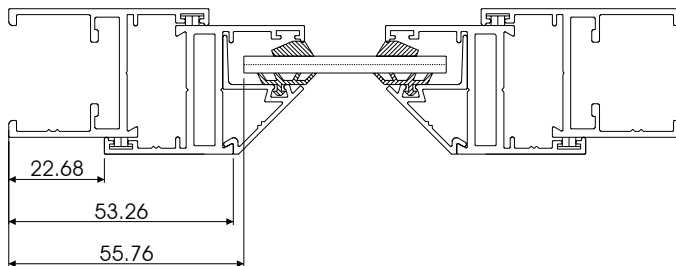
SECTION B-B

Section not to scale



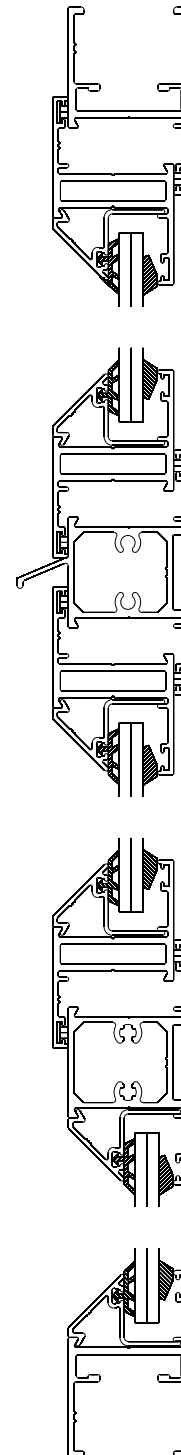
SECTION A - A

Section not to scale



SECTION C-C

Section not to scale



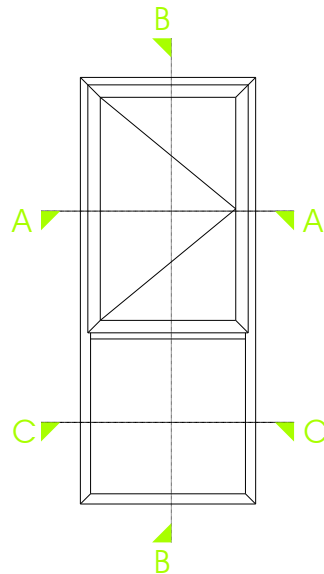
CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

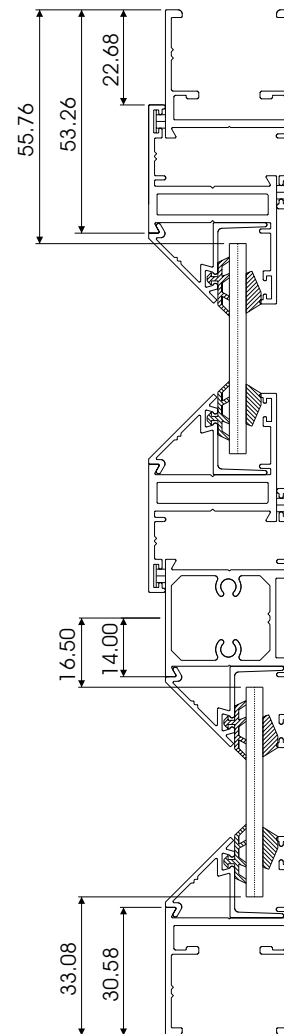
Typical Cross-sectional Details

Side Hung Over Fixed



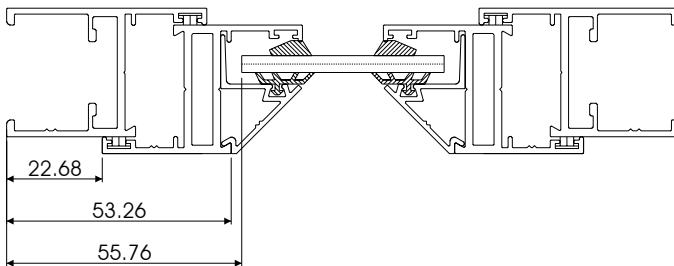
SECTION B-B

Section not to scale



SECTION A-A

Section not to scale



SECTION C-C

Section not to scale



This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Disclaimer: The right to make alterations is reserved
© 2013 Wispeco (Pty) Ltd, All Rights Reserved

CASEMENT 30.5

WINDOW (30.5mm)

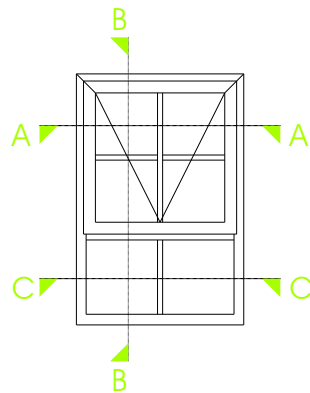
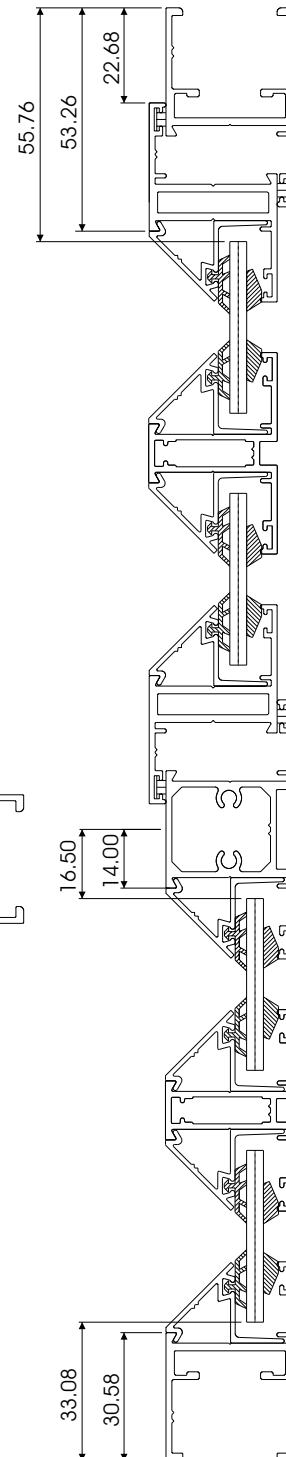
PRODUCT MANUAL

Typical Cross-sectional Details

Cottage Pane 2x2 Top Hung Over 2x1 Fixed Panel

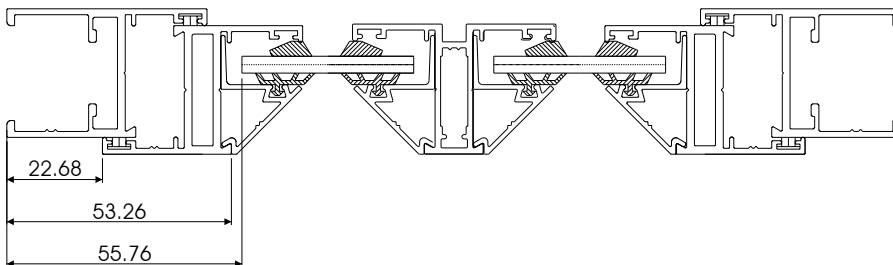
SECTION B-B

Section not to scale



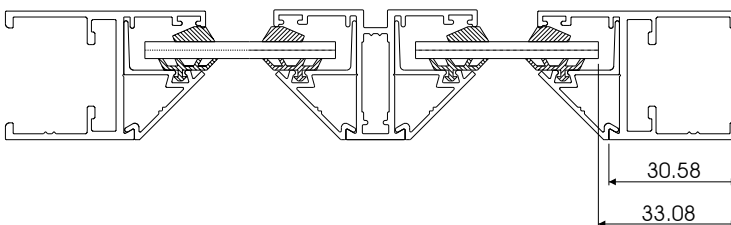
SECTION A - A

Section not to scale



SECTION C-C

Section not to scale



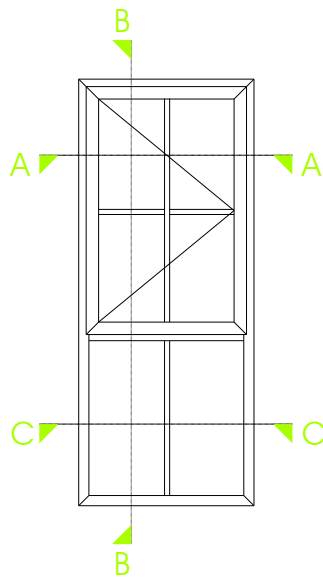
CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

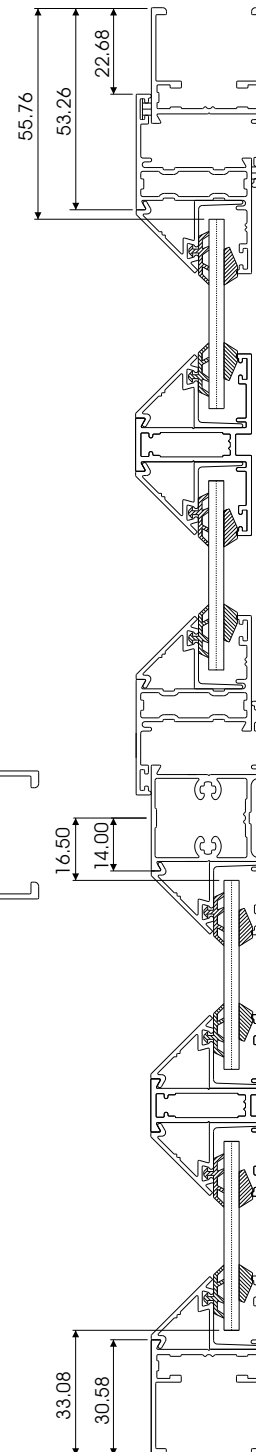
Typical Cross-sectional Details

Cottage Pane Side Hung Over Fixed Panel



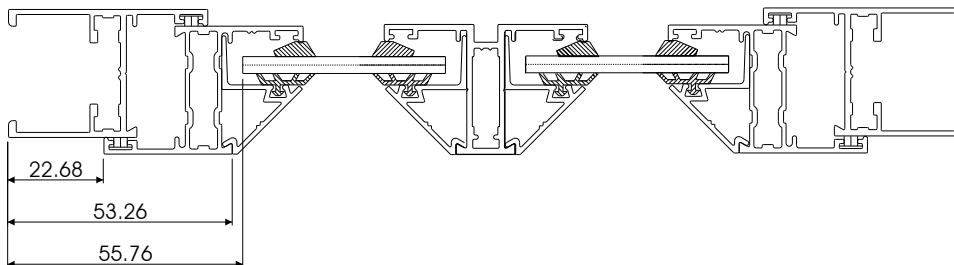
SECTION B-B

Section not to scale



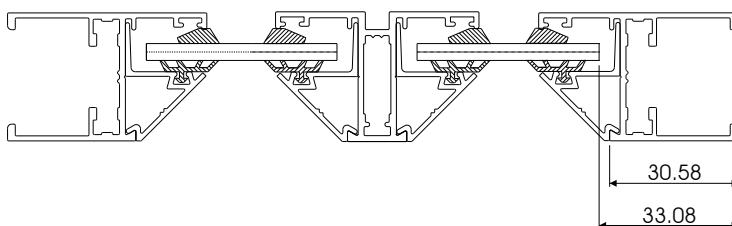
SECTION A - A

Section not to scale



SECTION C-C

Section not to scale



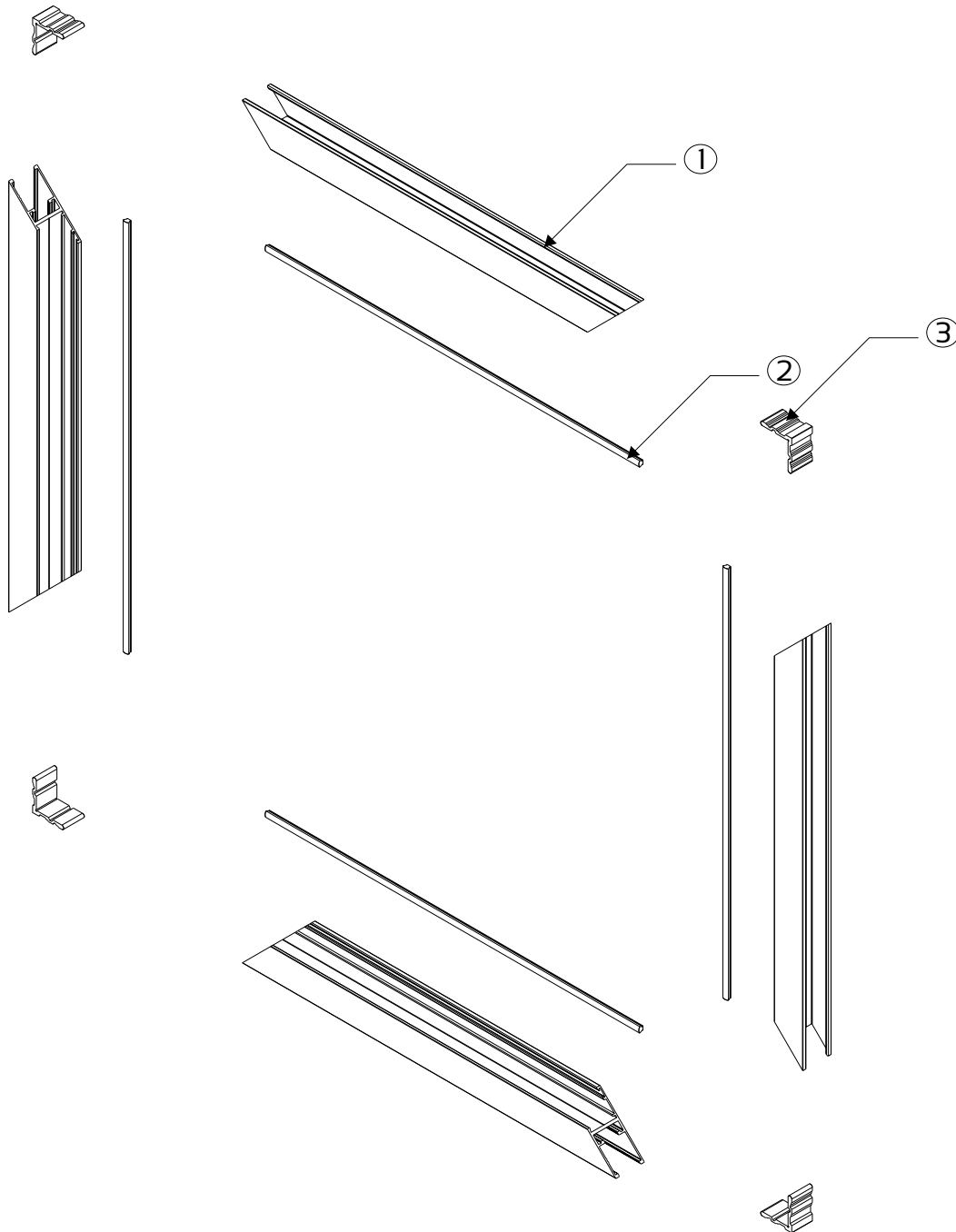
CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

Outer Frame Construction

Typical Configuration



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W32028	Frame 30mm Equal Leg Standard

Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Finpile	Finpile
3	4	Corner Cleat	Cas30.5 Corner Cleat 40mm



This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Disclaimer: The right to make alterations is reserved
© 2013 Wispeco (Pty) Ltd, All Rights Reserved

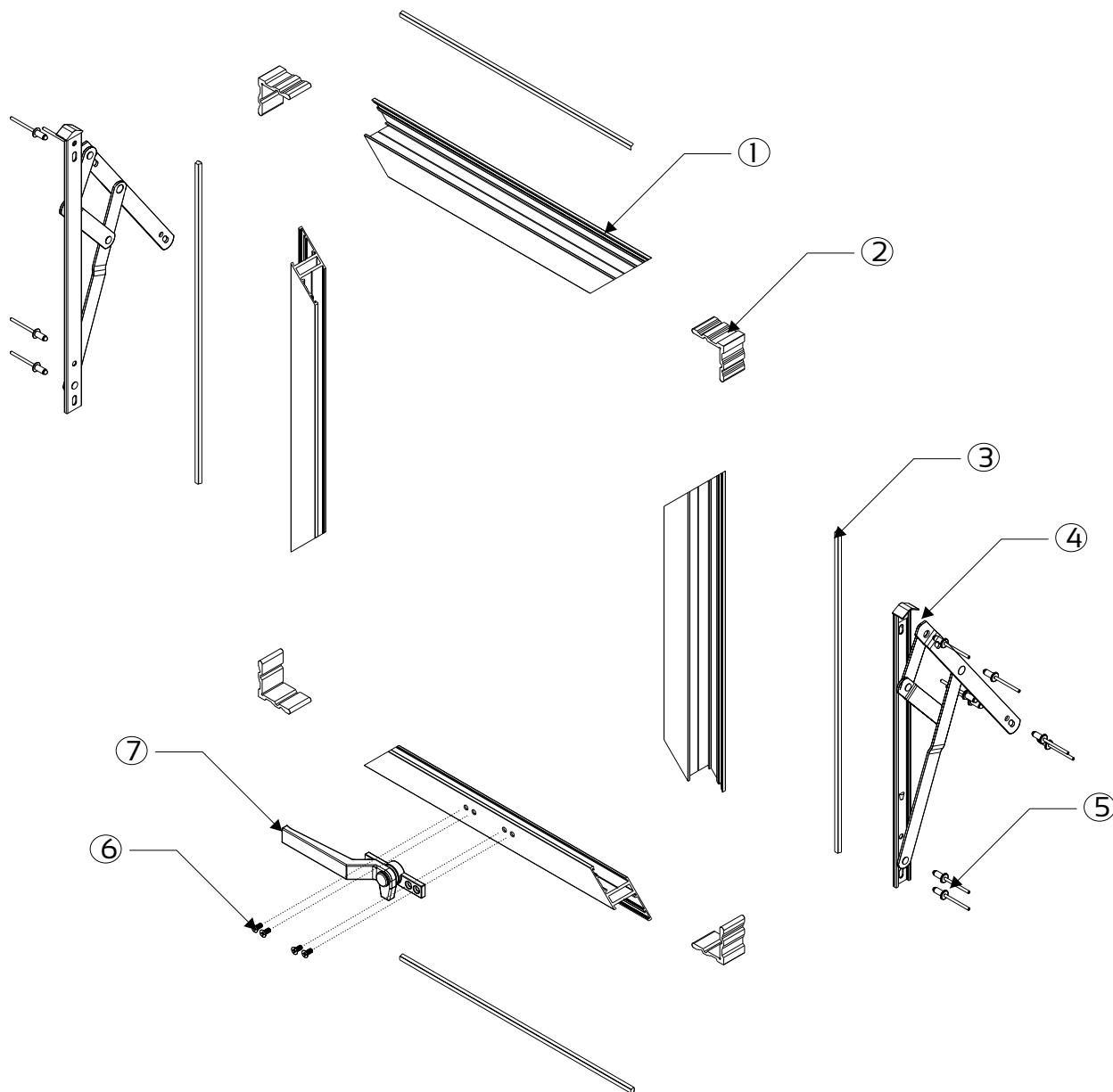
CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

Sash Frame Construction

Typical Configuration



System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	4	W55684	Sash Tubular Standard

Hardware

ITEM	QTY	COMPONENT	DESCRIPTION
2	4	Corner Cleat	Cas30.5 Corner Cleat 40mm
3	4	Finpile	Finpile
4	2	Friction Stay	Friction Stay
5	12	Pop Rivet	C/Sunk/Dome Rivet
6	4	Screw	Handle Screw Blunt Point
7	1	Handle	Euroline PT Handle

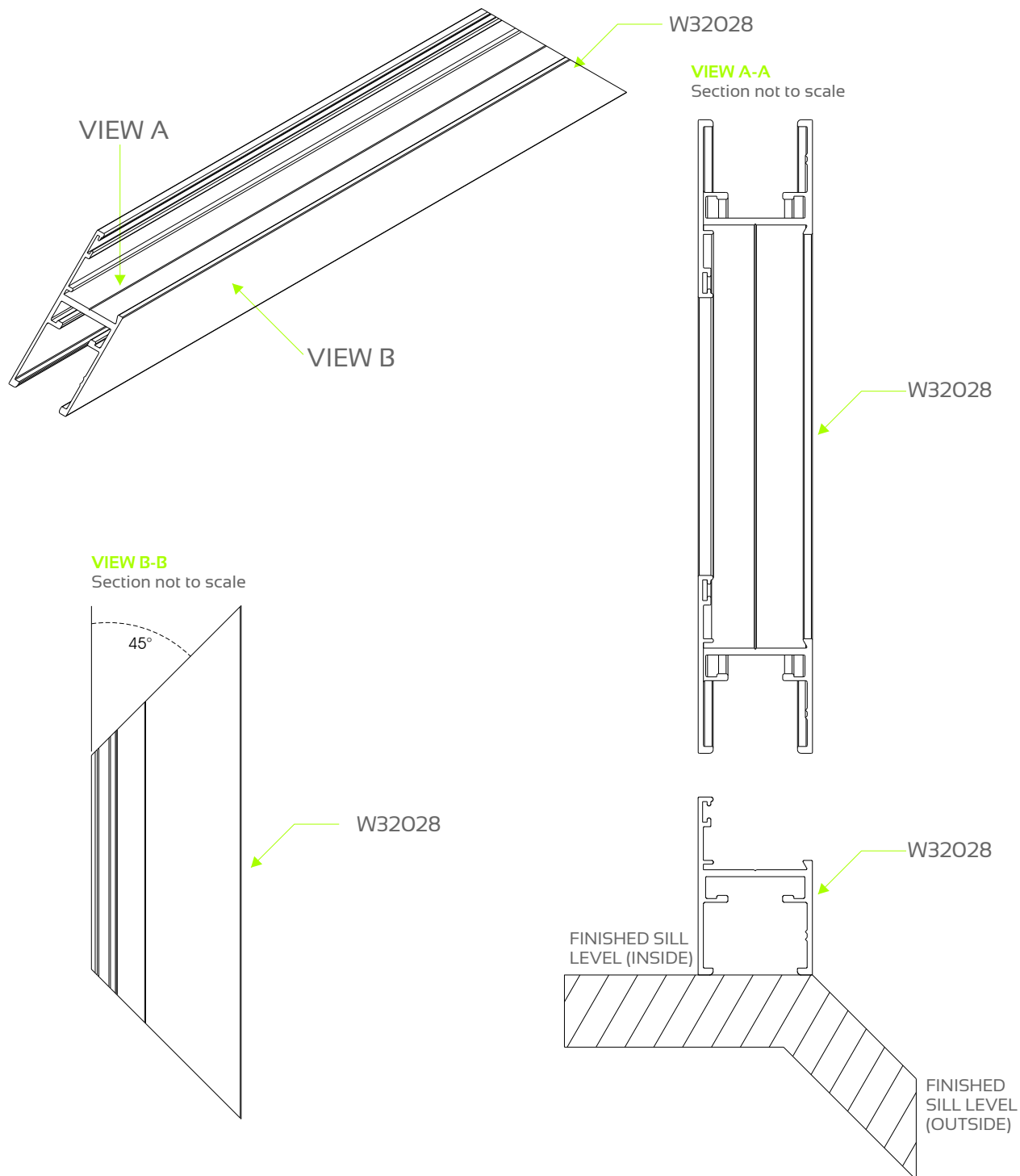


This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Outer Frame Machining Details

Equal Leg

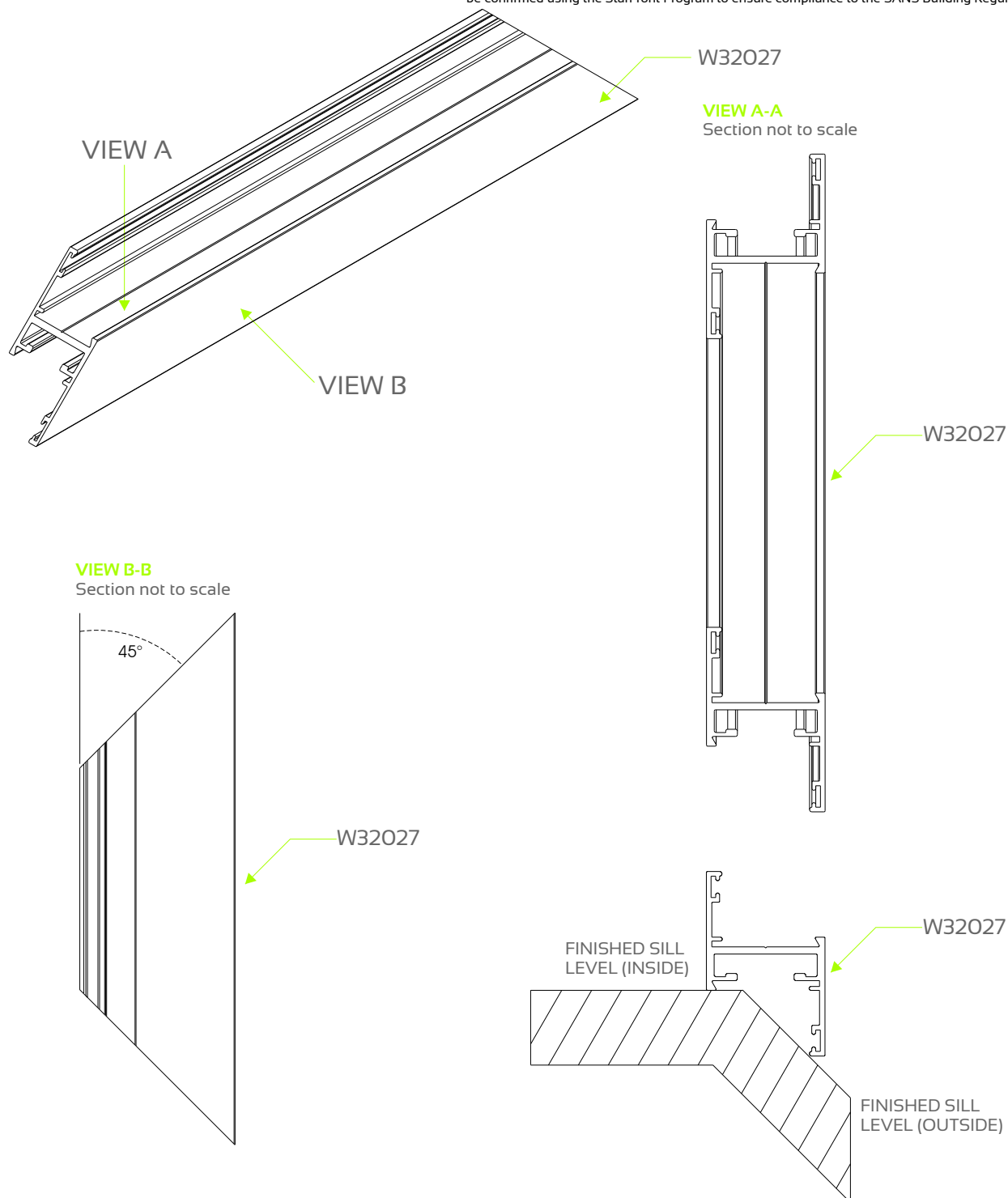
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



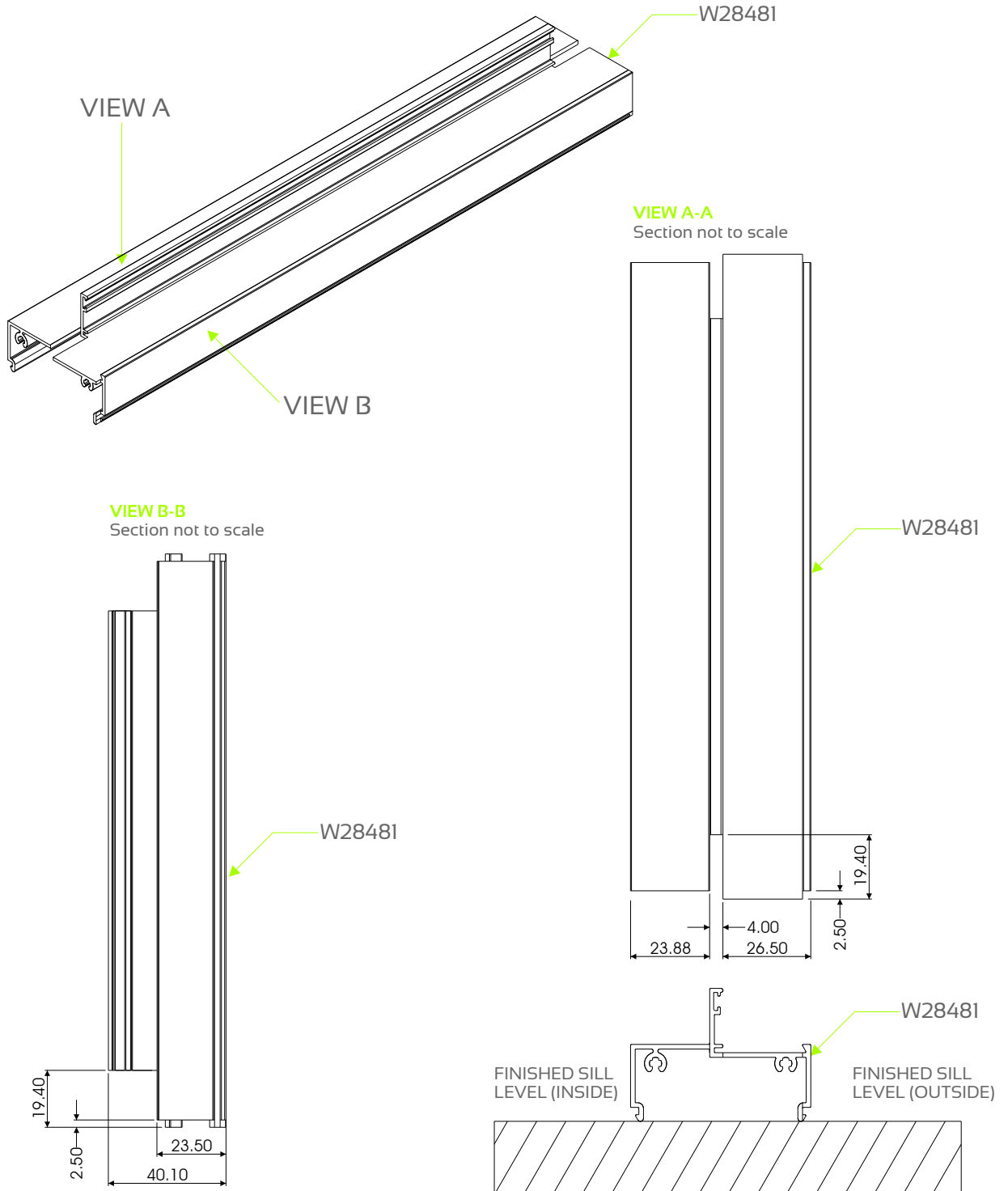
Outer Frame Machining Details

Unequal Leg

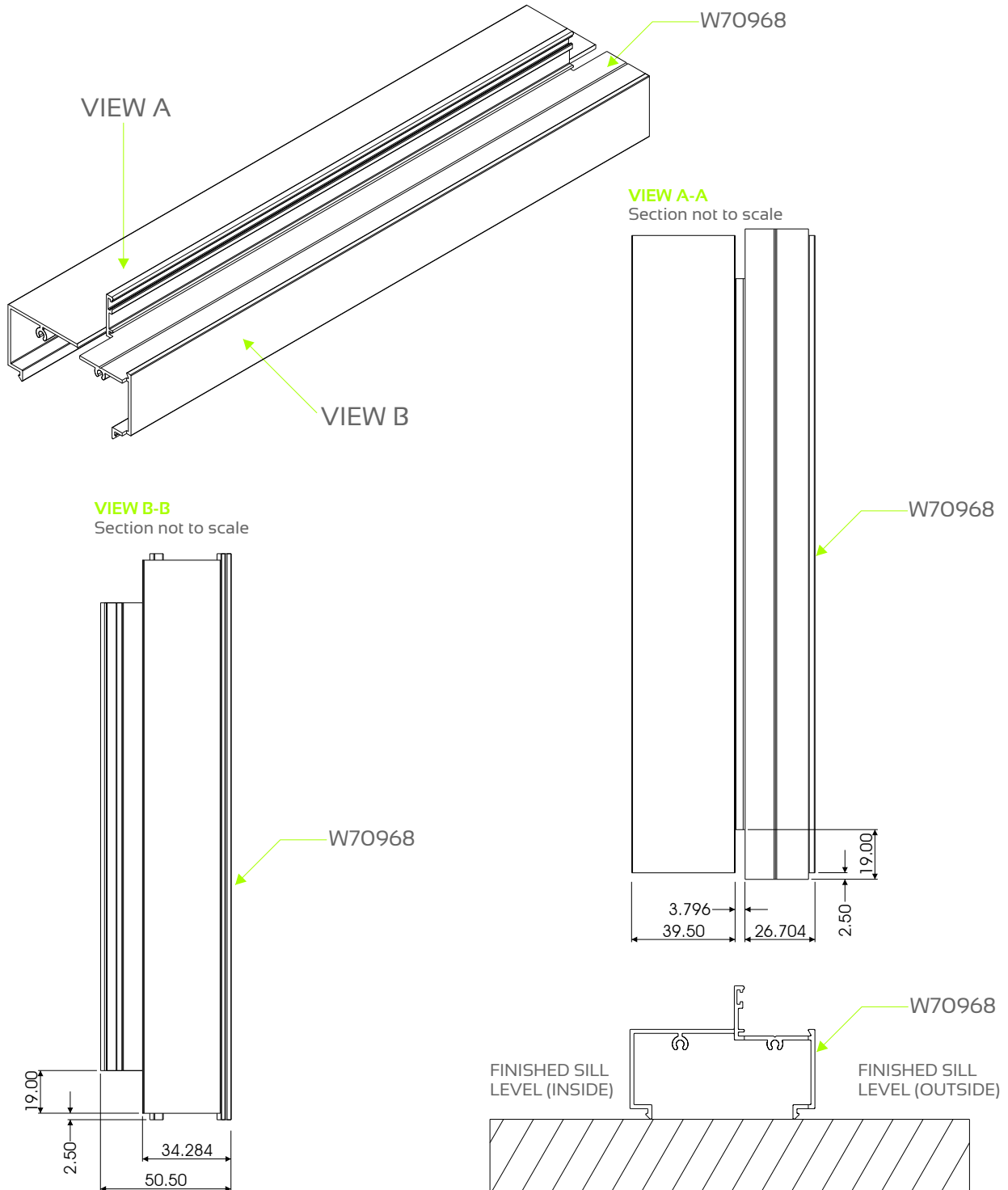
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



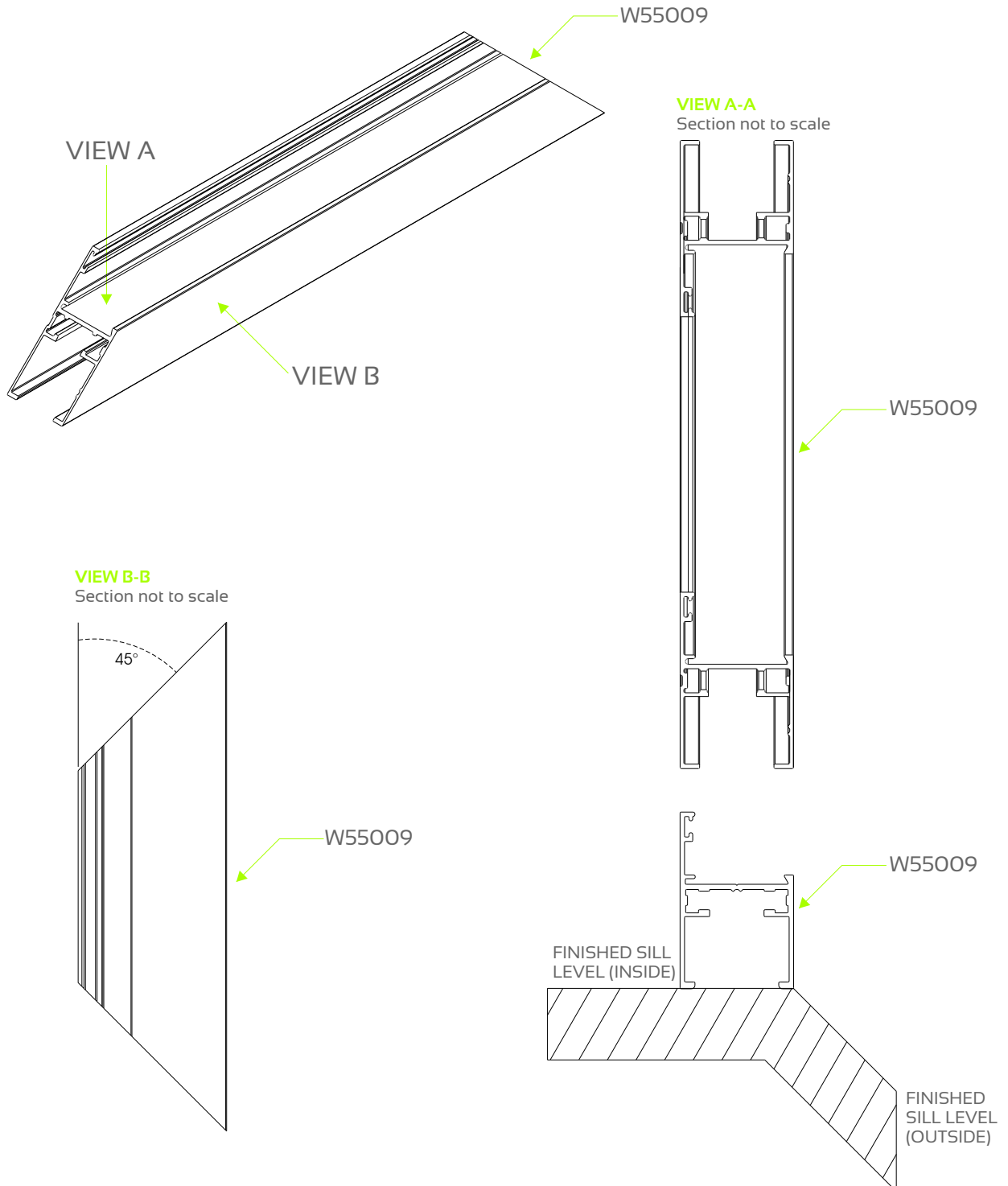
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Outer Frame Machining Details

Lite Equal Leg

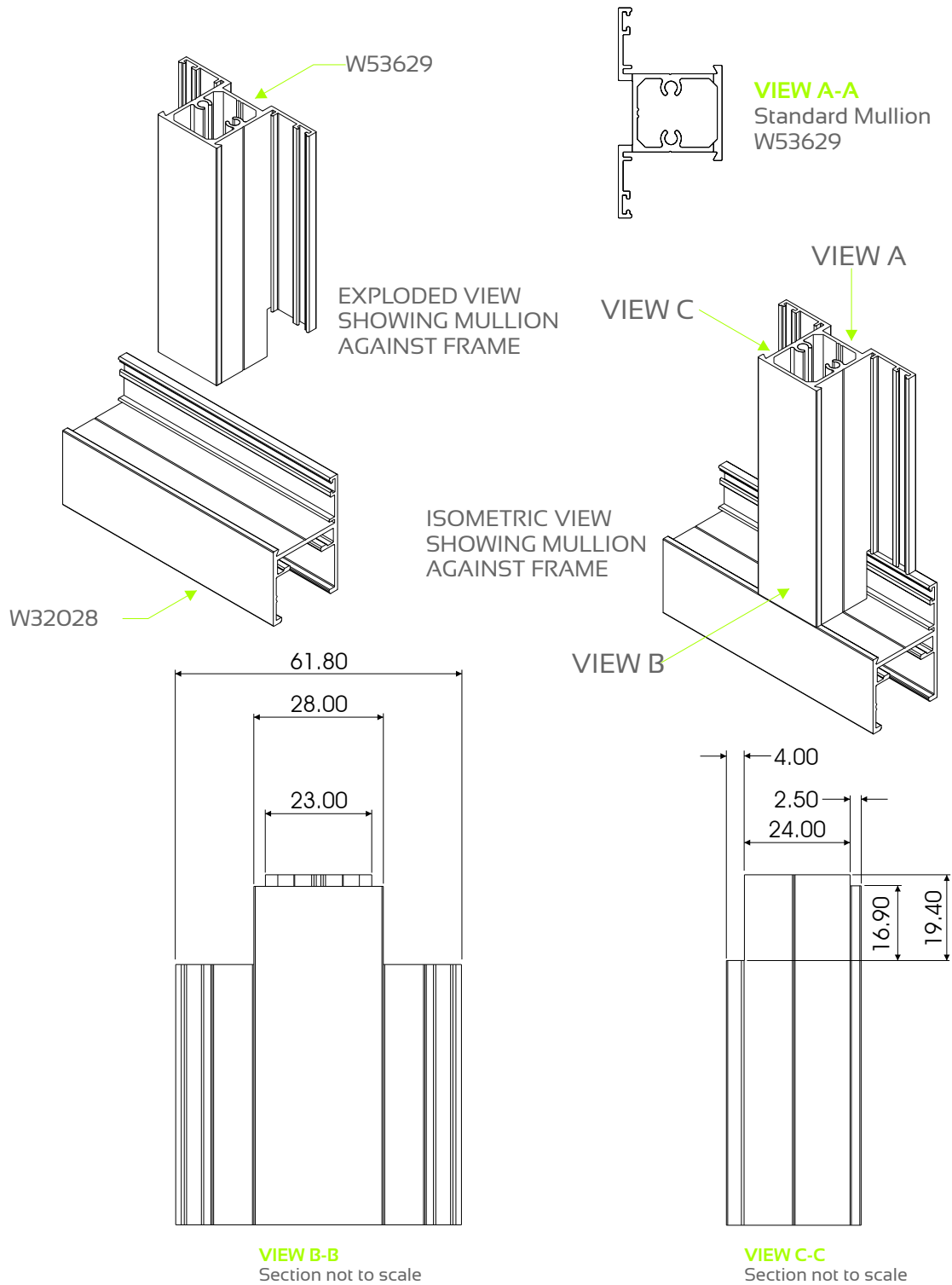
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Mullion Machining Details

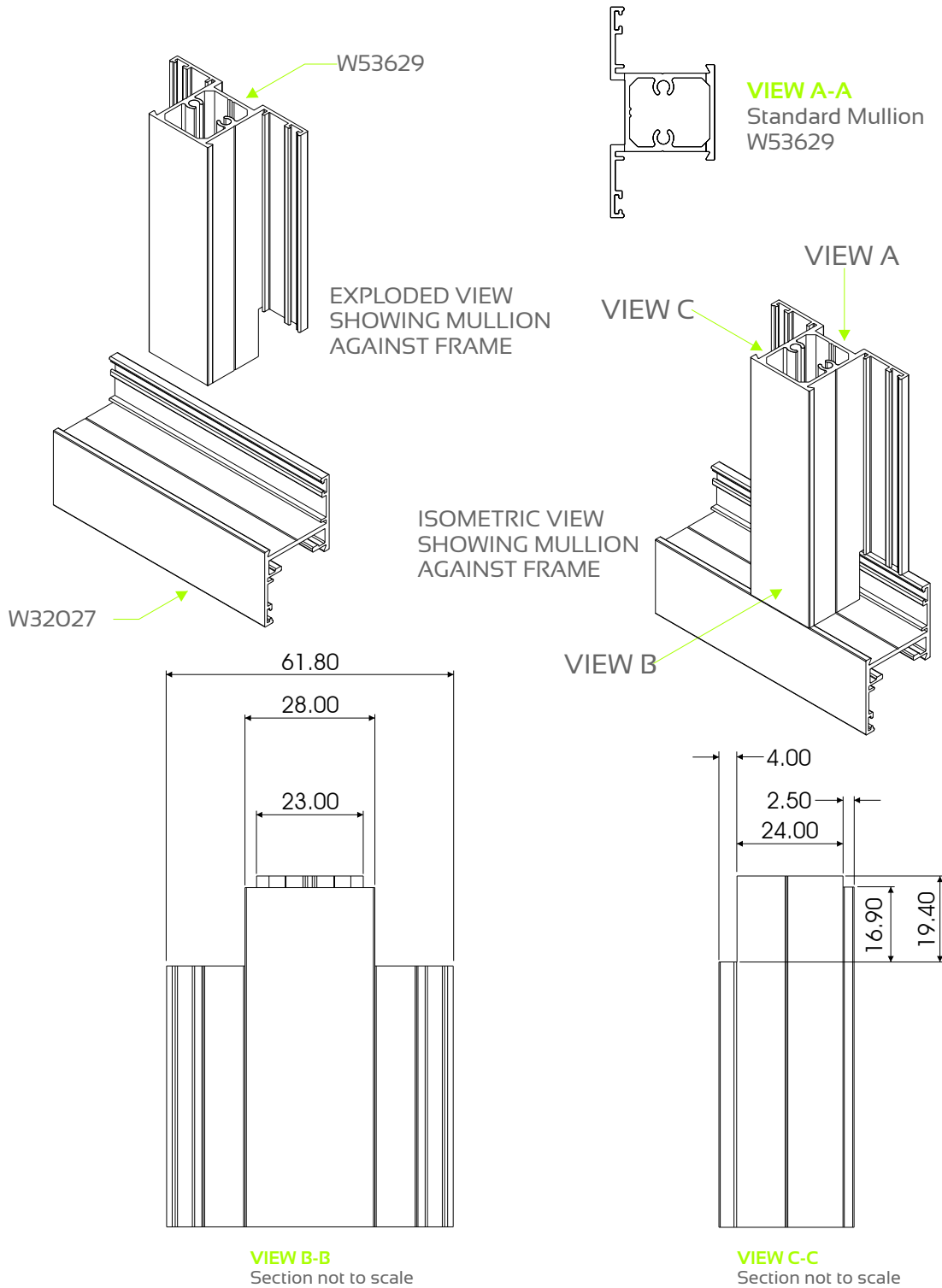
Standard Machining Detail for End Milling on Equal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Standard Machining Detail for End Milling on Unequal Leg Outer Frame

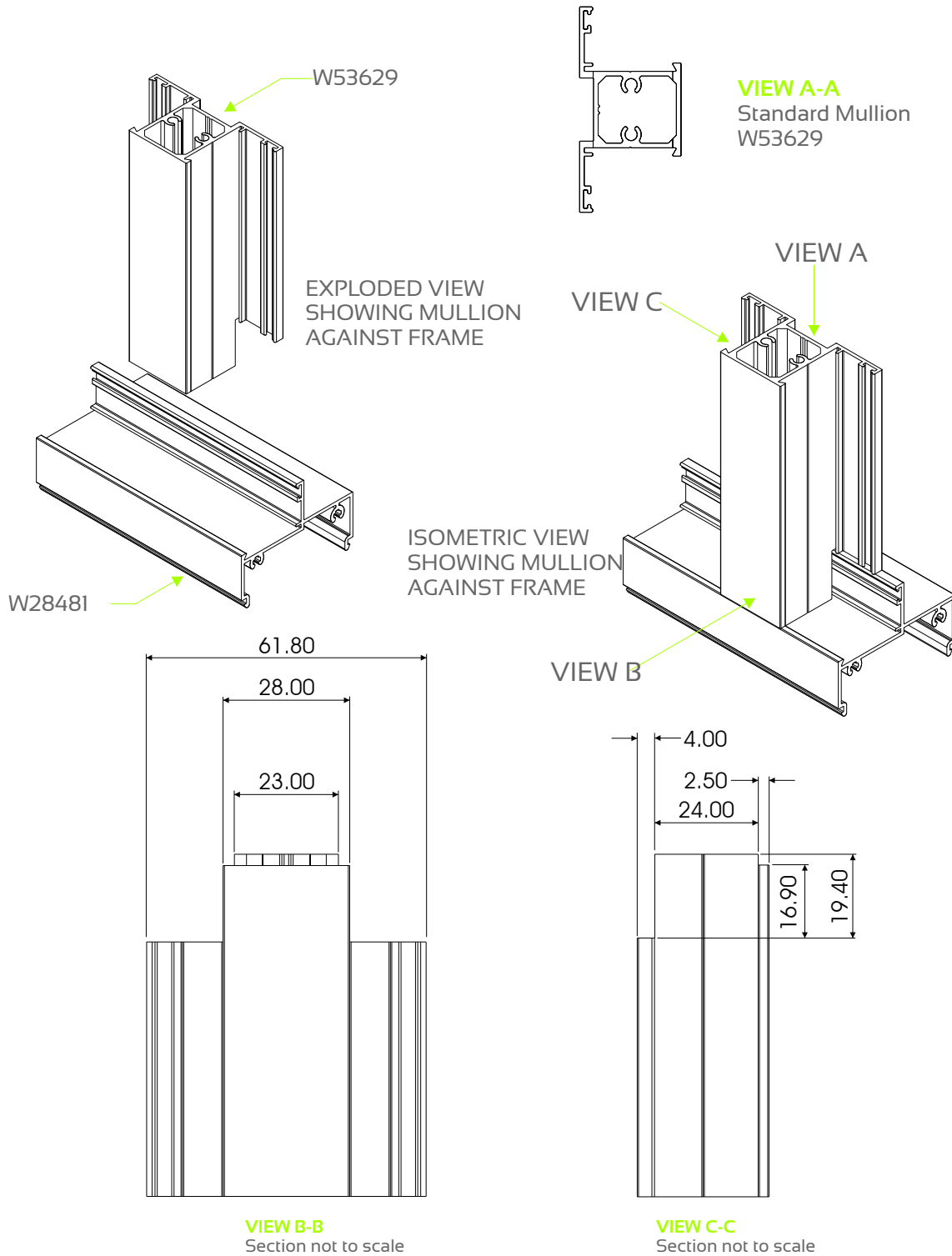
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Mullion Machining Details

Standard Machining Detail for End Milling on 54mm Outer Frame

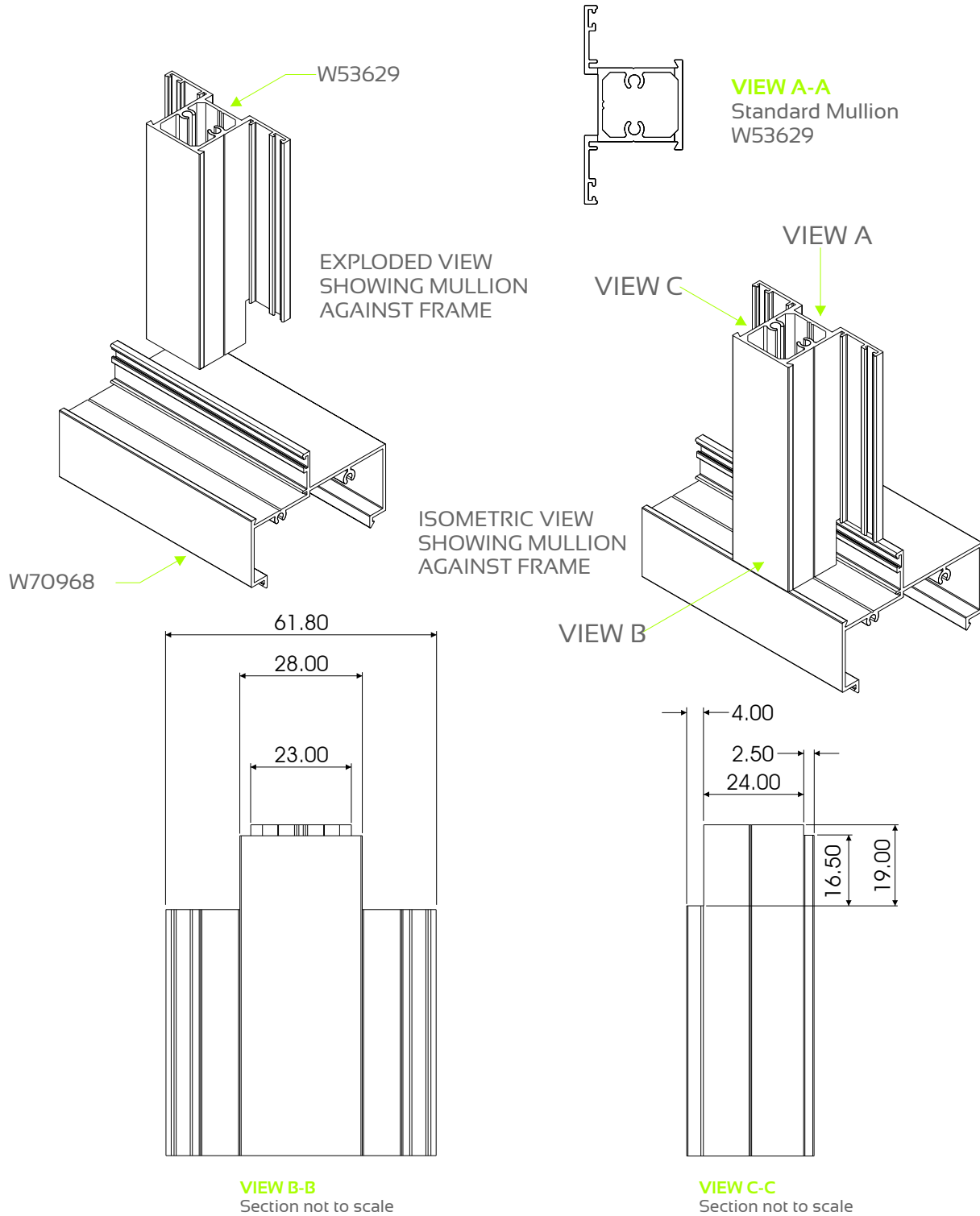
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Mullion Machining Details

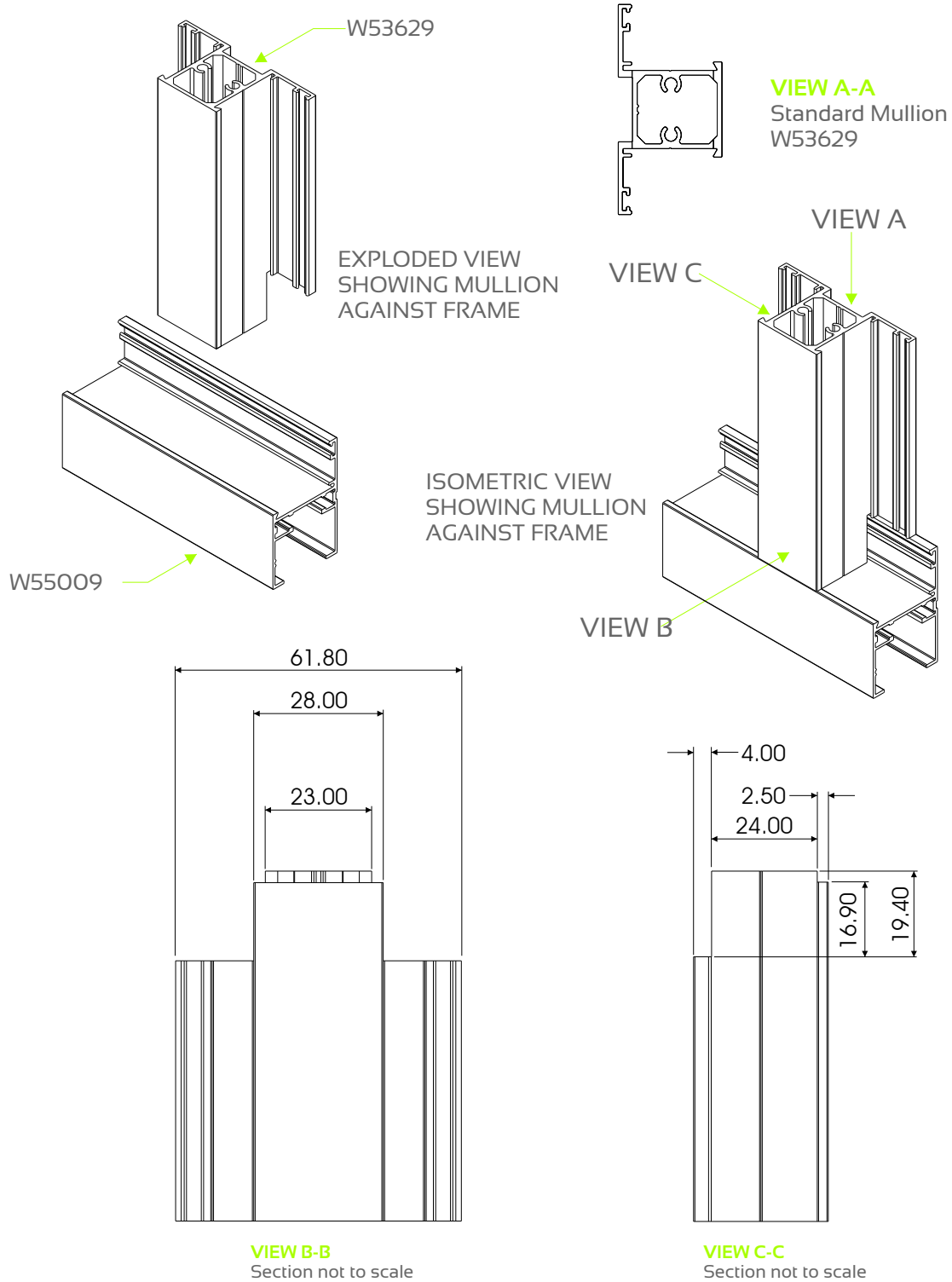
Standard Machining Detail for End Milling on 70mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Standard Machining Detail for End Milling on Lite Equal Leg Outer Frame

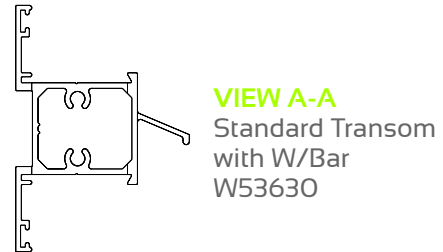
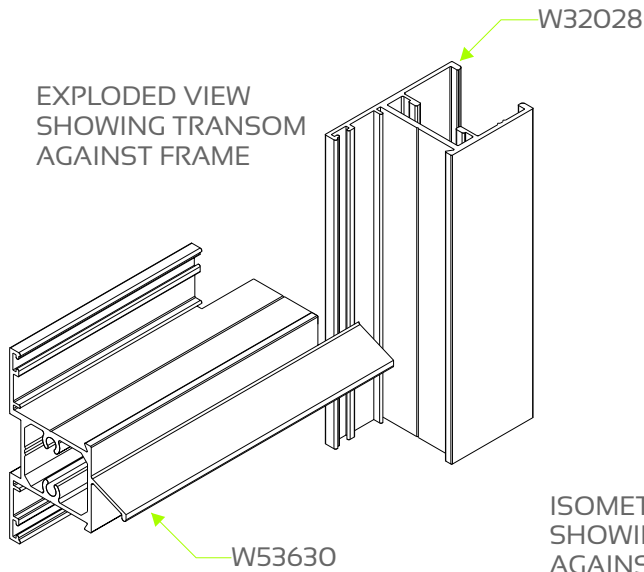
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



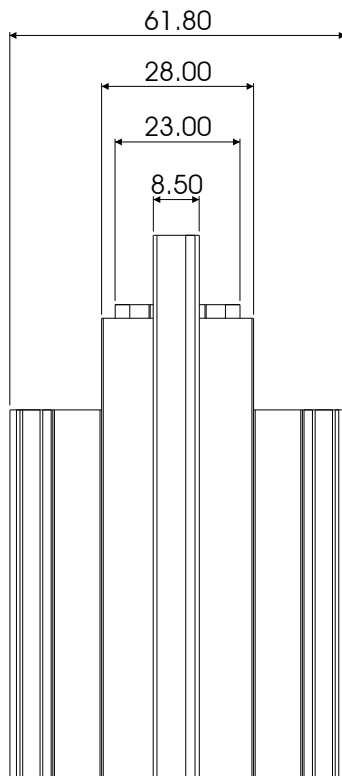
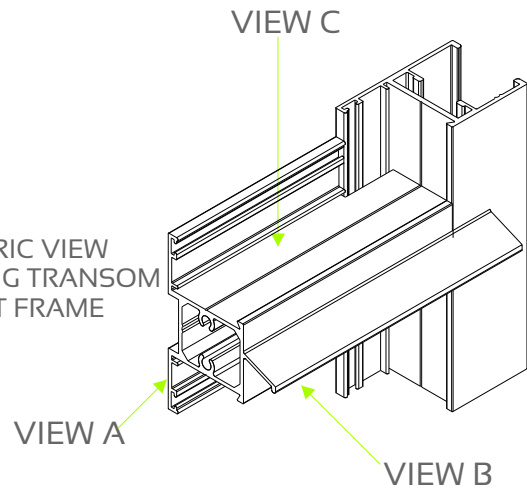
Transom with W/Bar Machining Detail

for End Milling on Equal Leg Outer Frame

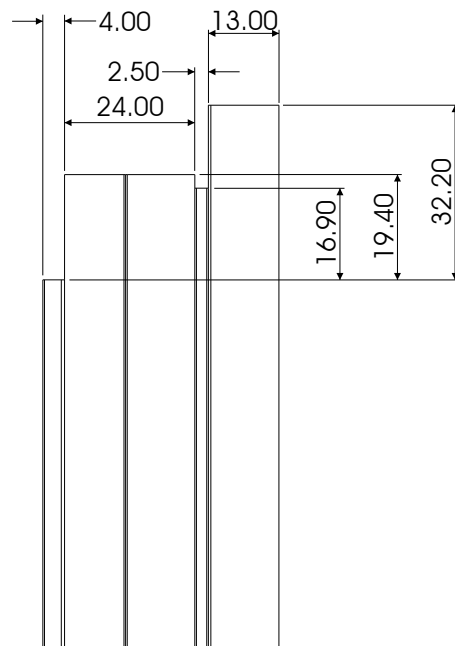
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale

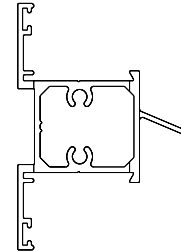
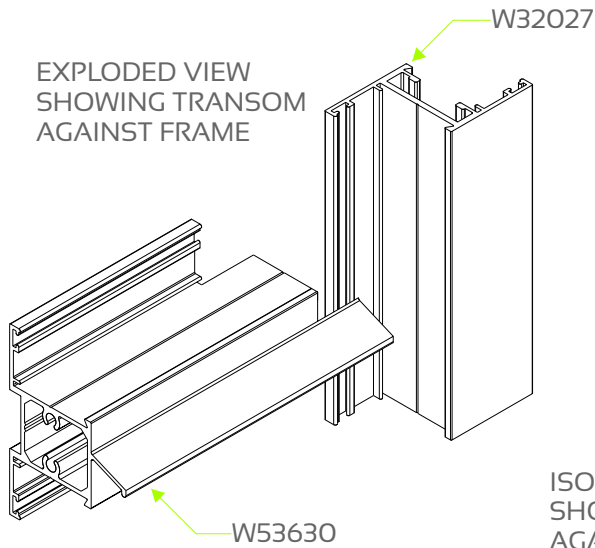


VIEW C-C
Section not to scale

Transom with W/Bar Machining Detail

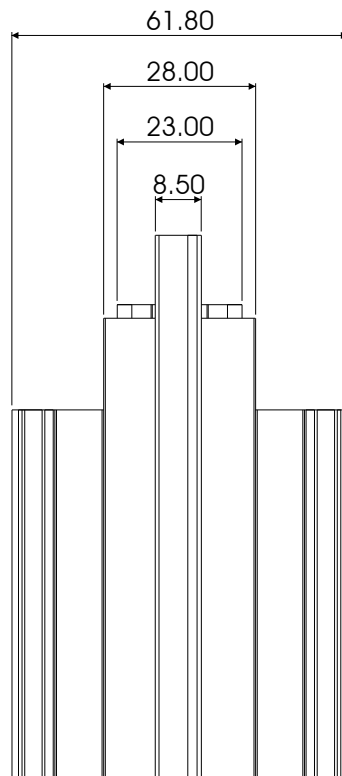
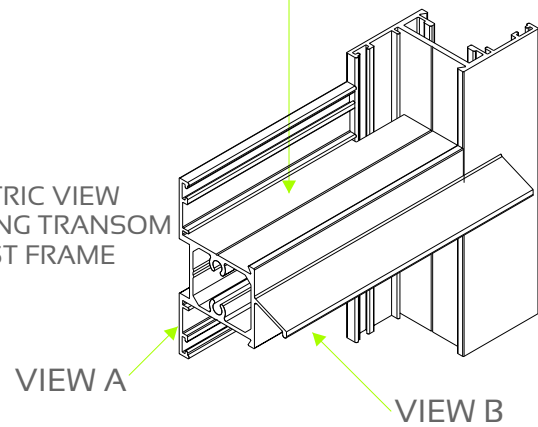
for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

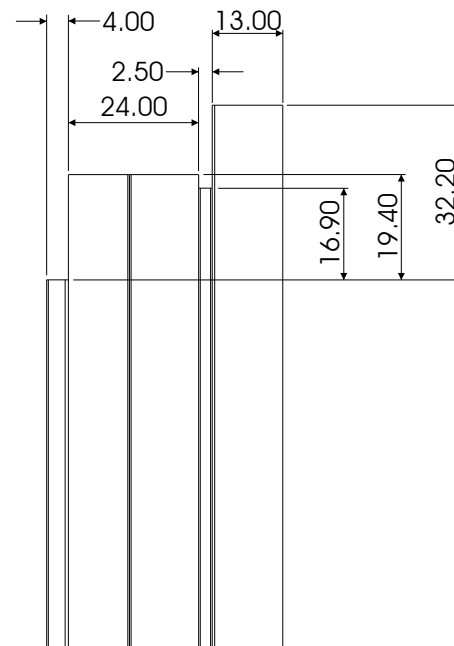


ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME

VIEW C



VIEW B-B
Section not to scale

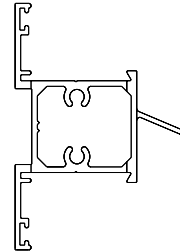
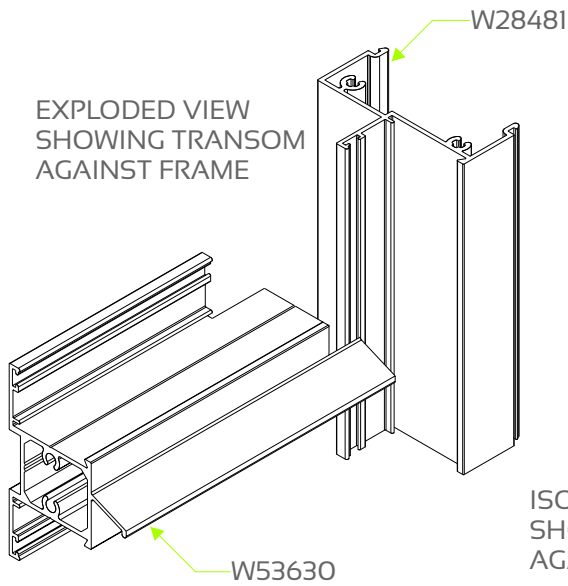


VIEW C-C
Section not to scale

Transom with W/Bar Machining Detail

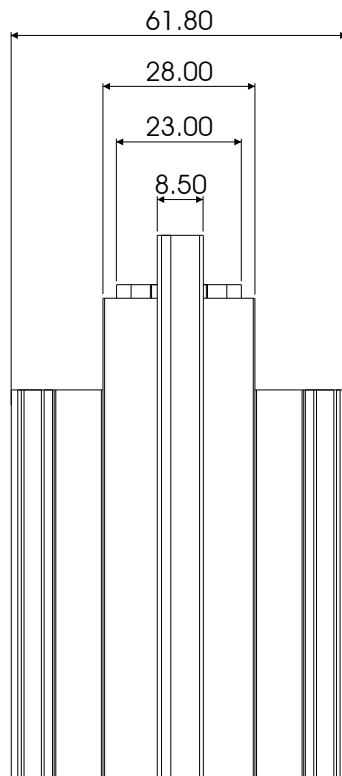
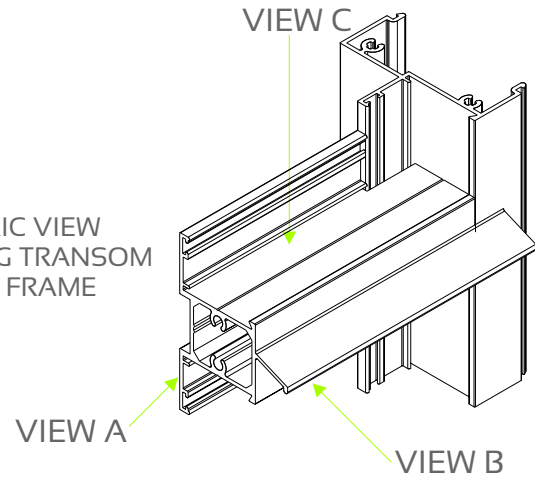
for End Milling on 54mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

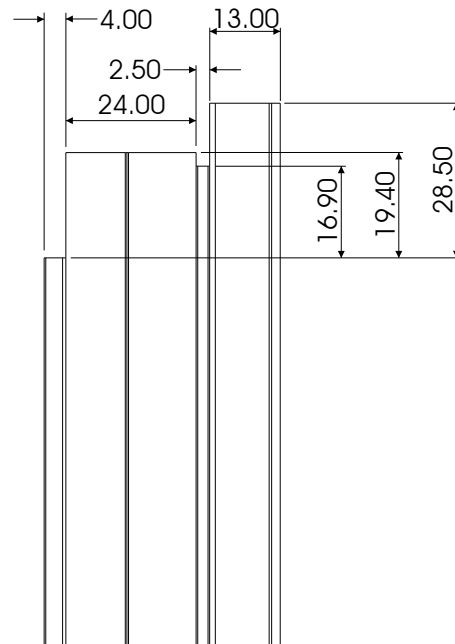


VIEW A-A
Standard Transom
with W/Bar
W53630

ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale

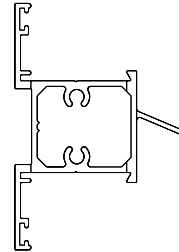
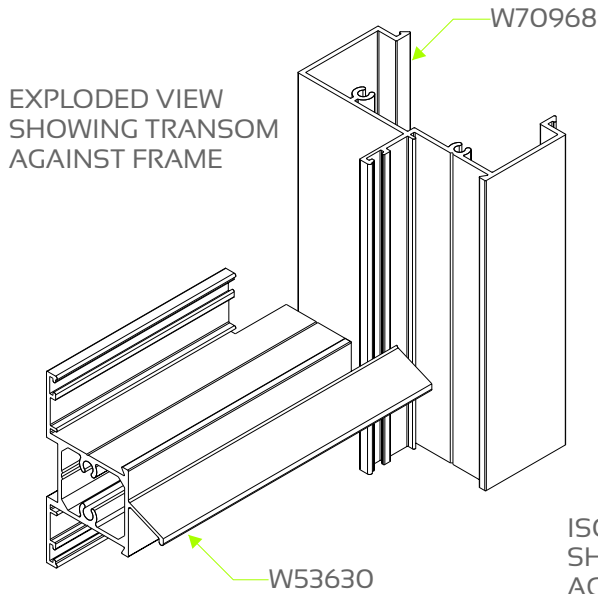


VIEW C-C
Section not to scale

Transom with W/Bar Machining Detail

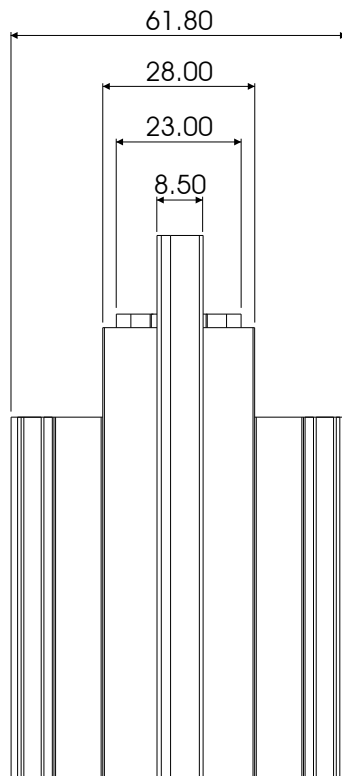
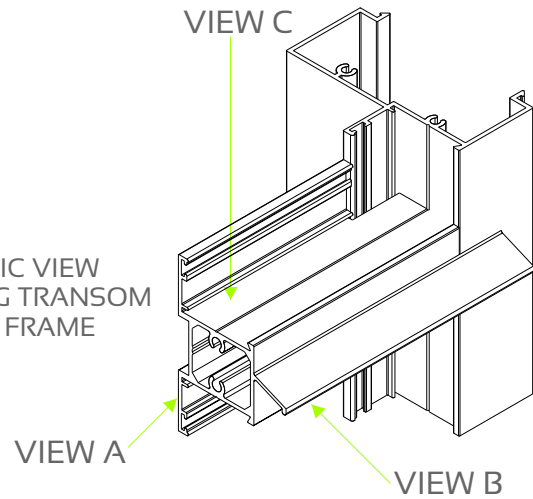
for End Milling on 70mm Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

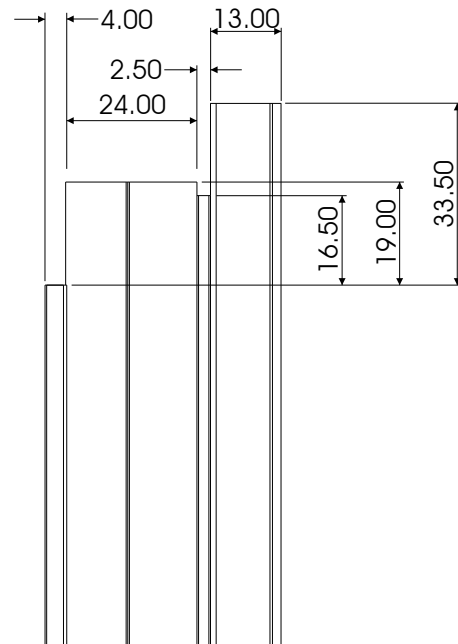


VIEW A-A
Standard Transom
with W/Bar
W53630

ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale

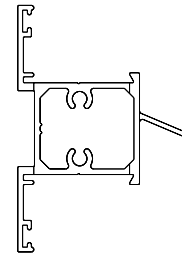
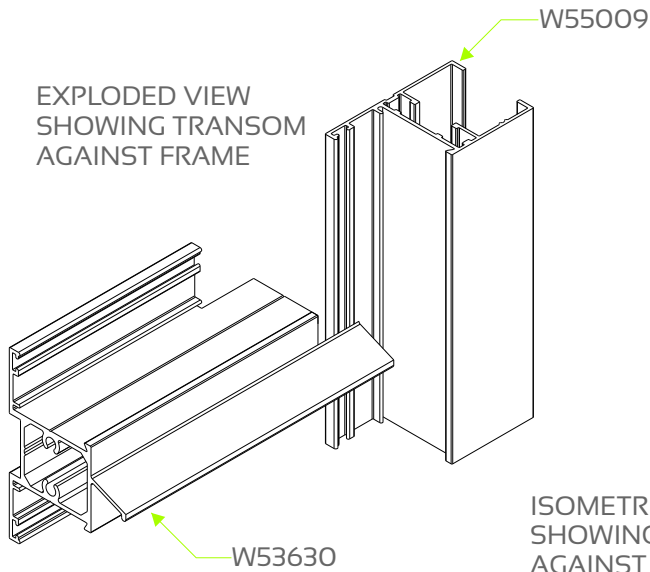


VIEW C-C
Section not to scale

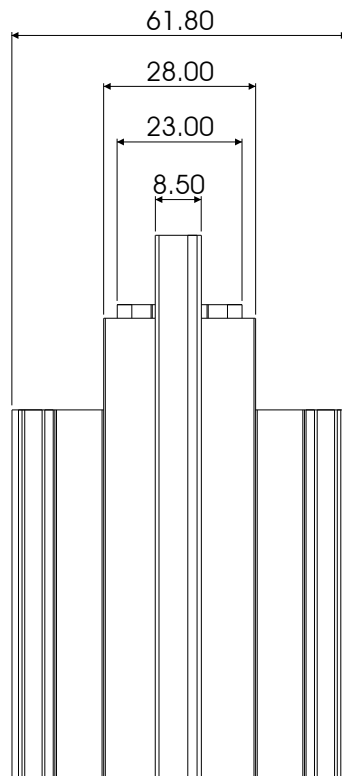
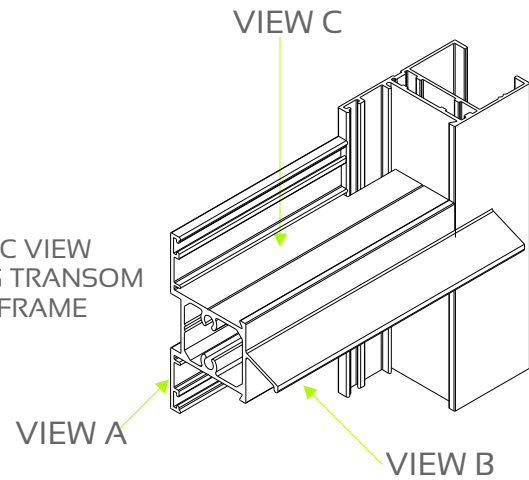
Transom with W/Bar Machining Detail

for End Milling on Lite Equal Leg Outer Frame

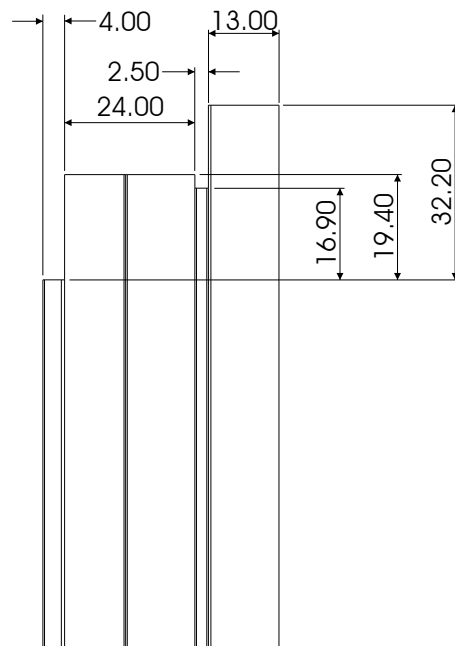
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



ISOMETRIC VIEW
SHOWING TRANSOM
AGAINST FRAME



VIEW B-B
Section not to scale

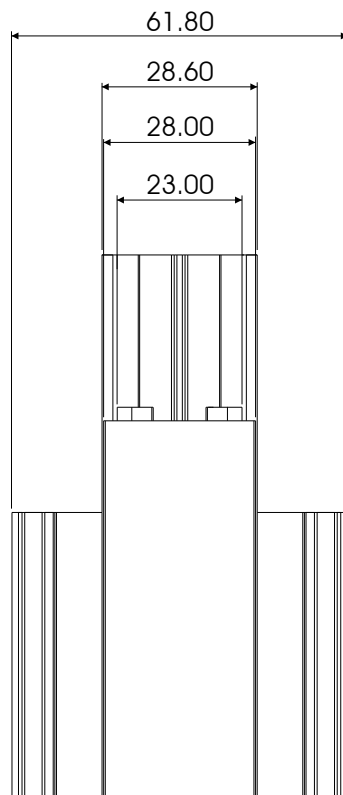
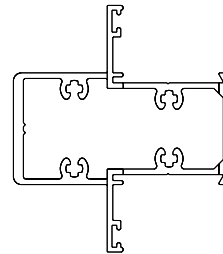
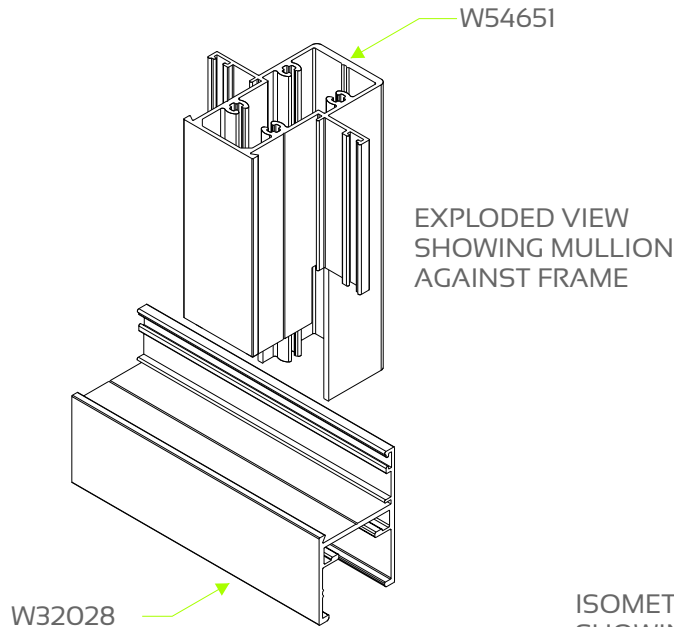


VIEW C-C
Section not to scale

54mm Mullion Machining Detail

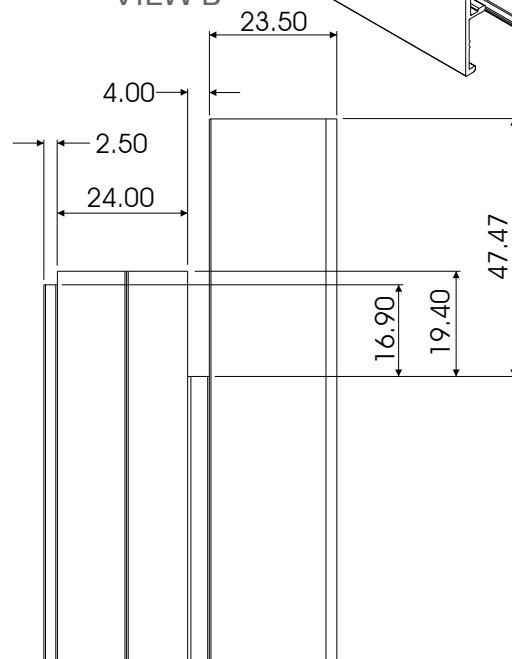
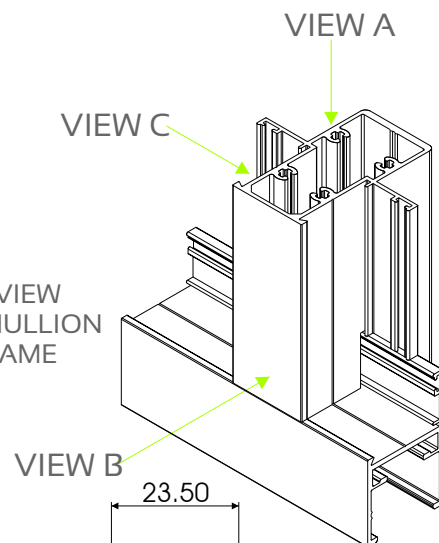
for End Milling on Equal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



VIEW B-B
Section not to scale

ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME

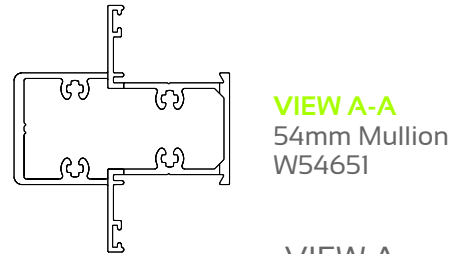
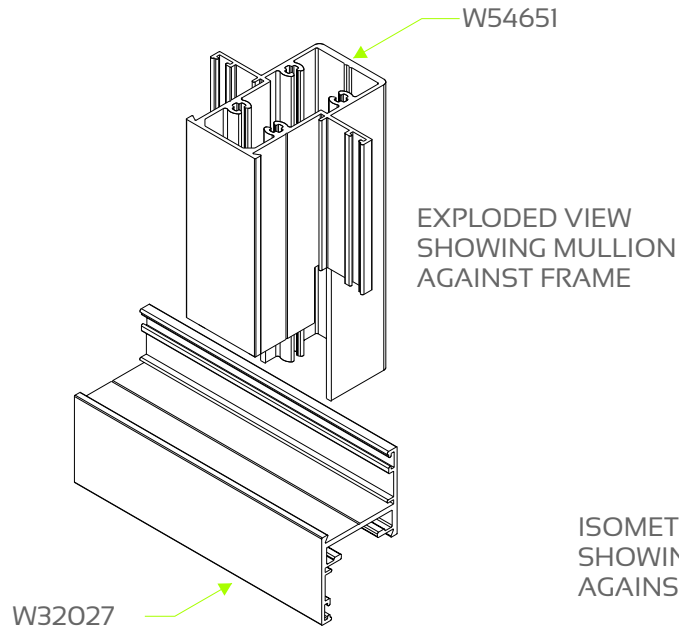


VIEW C-C
Section not to scale

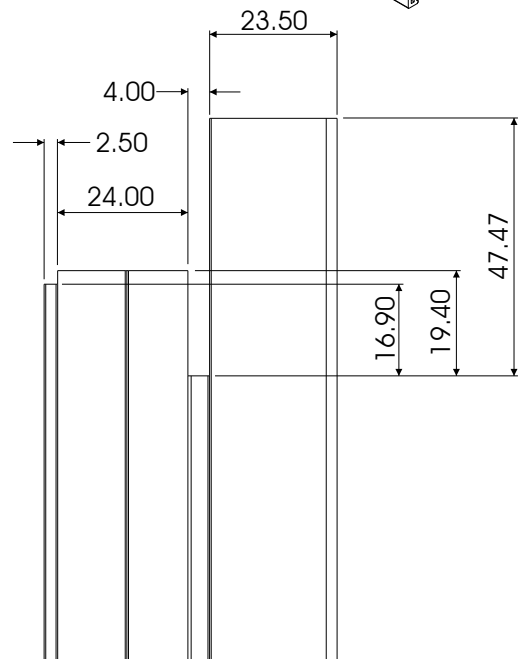
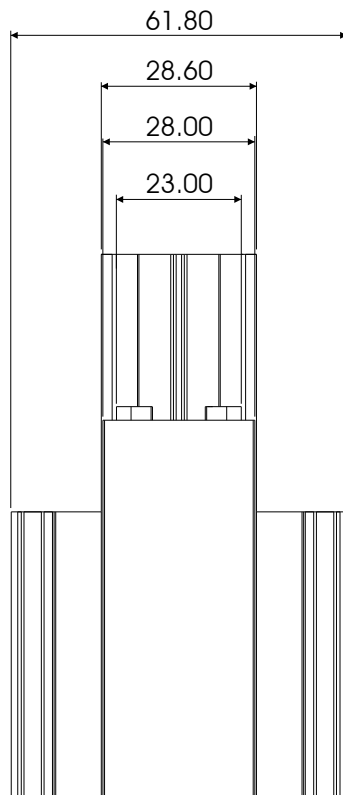
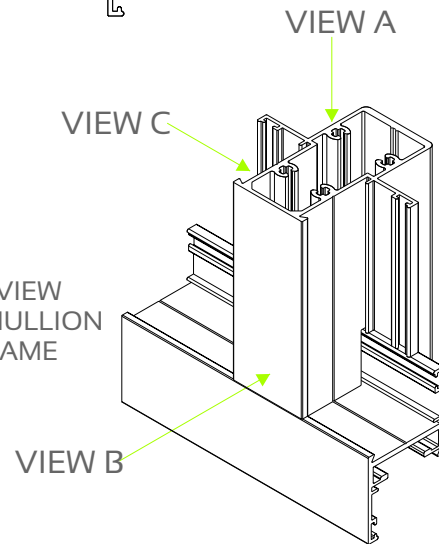
54mm Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



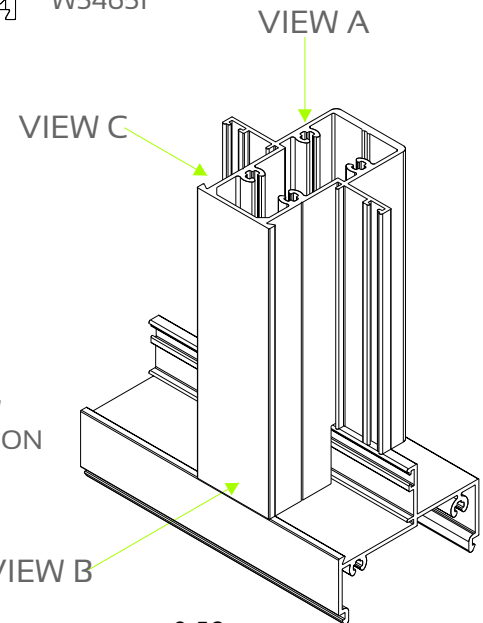
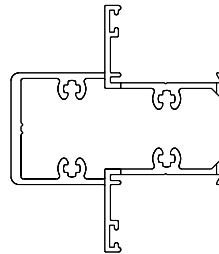
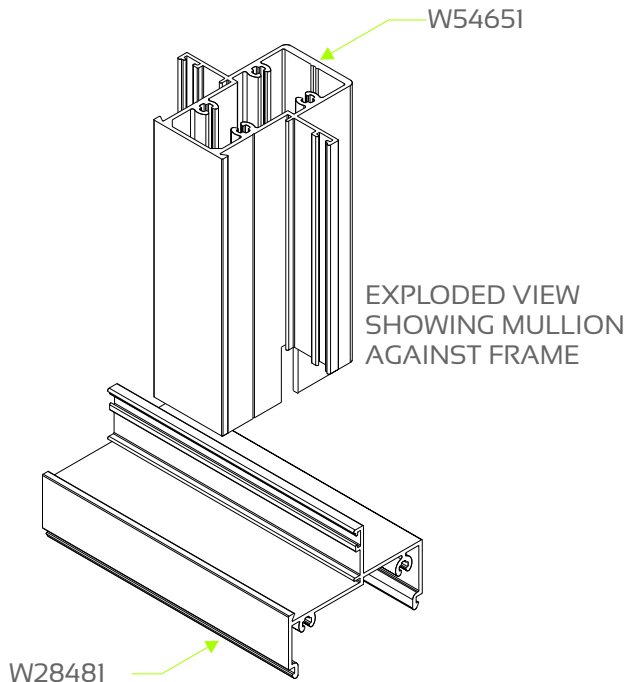
ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



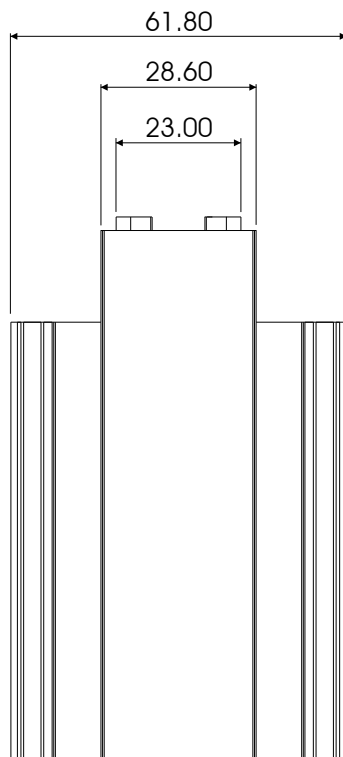
54mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

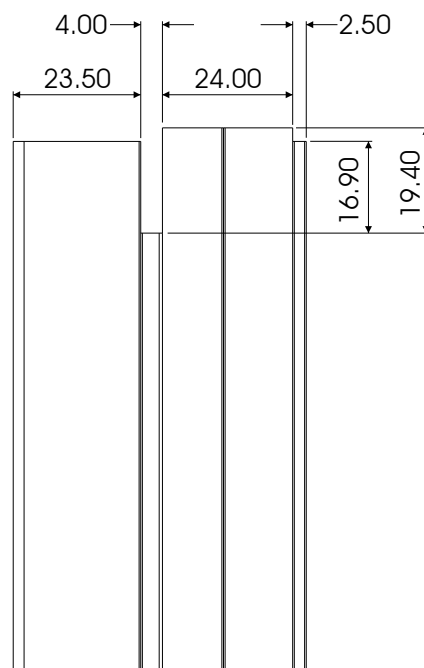
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale

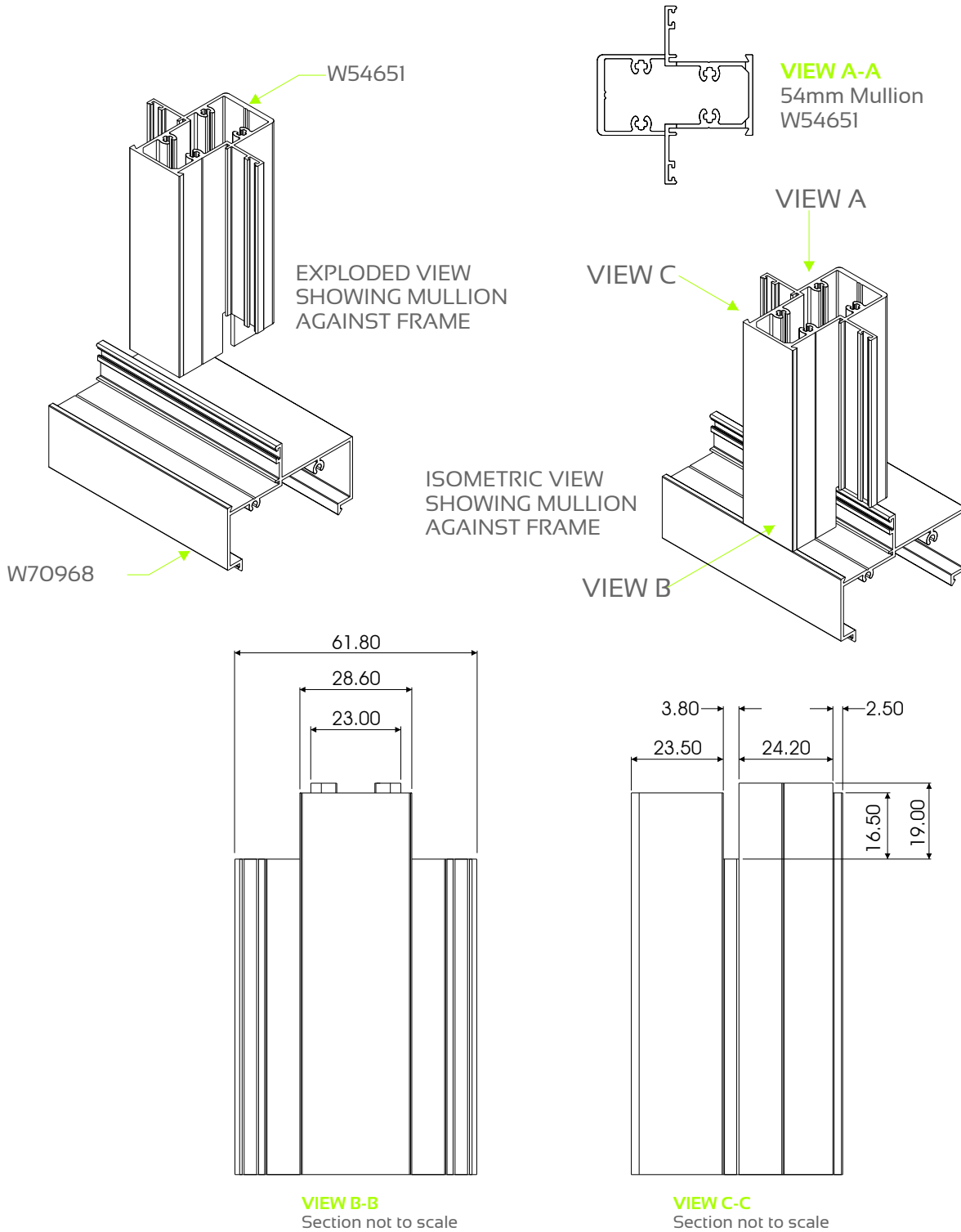


VIEW C-C
Section not to scale

54mm Mullion Machining Detail

for End Milling on 70mm Outer Frame

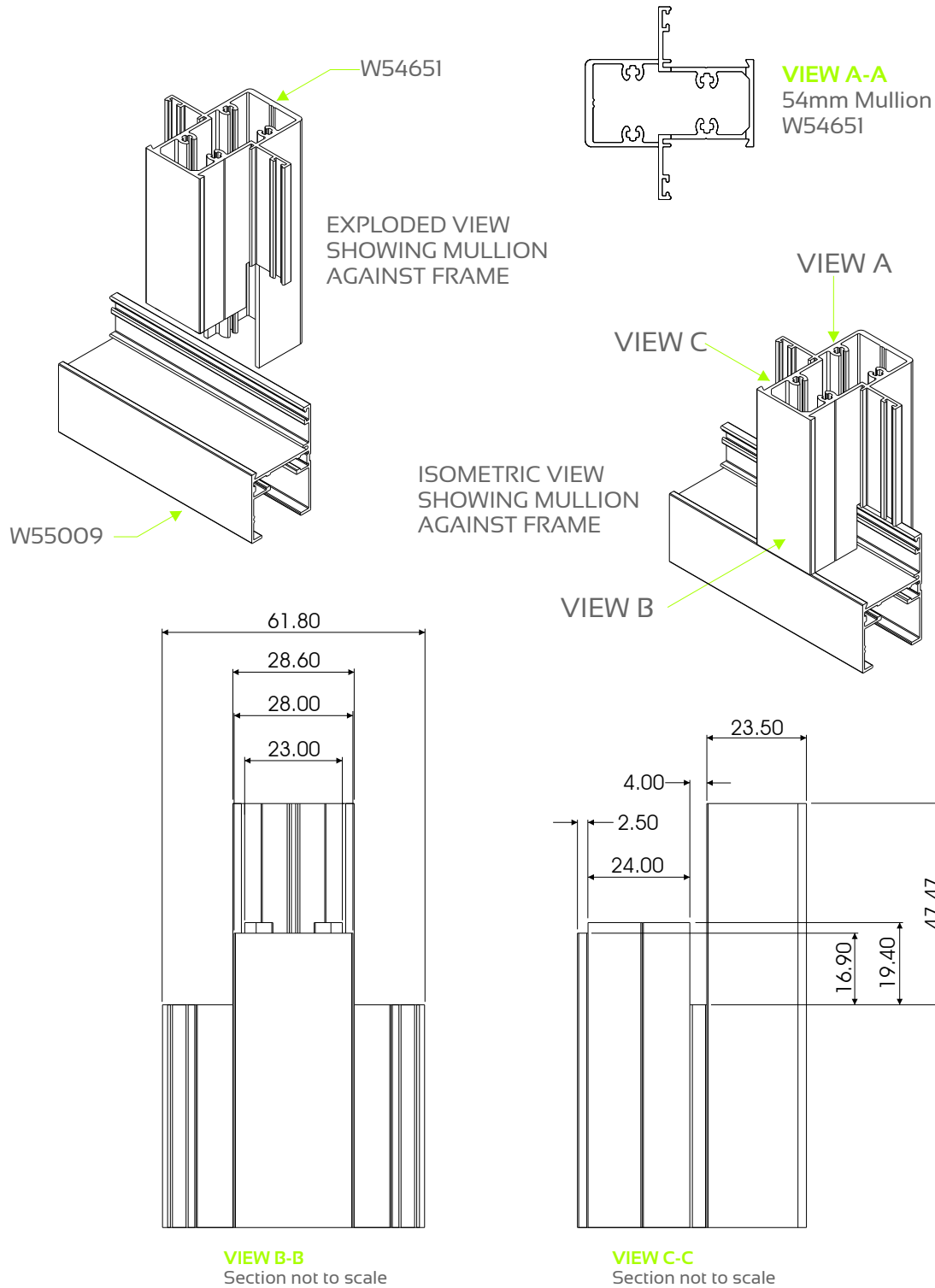
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



54mm Mullion Machining Detail

for End Milling on Lite Equal Leg Outer Frame

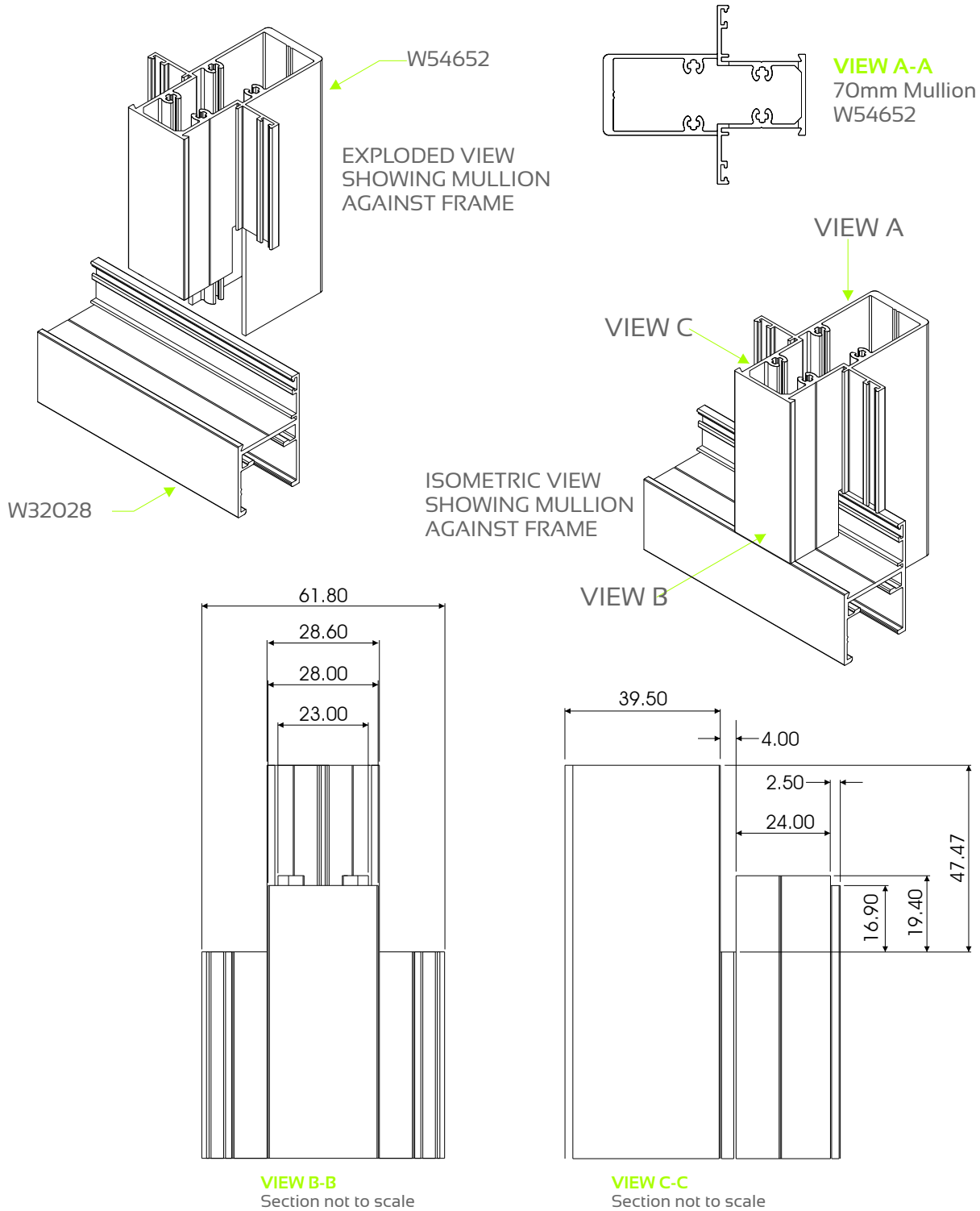
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



70mm Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

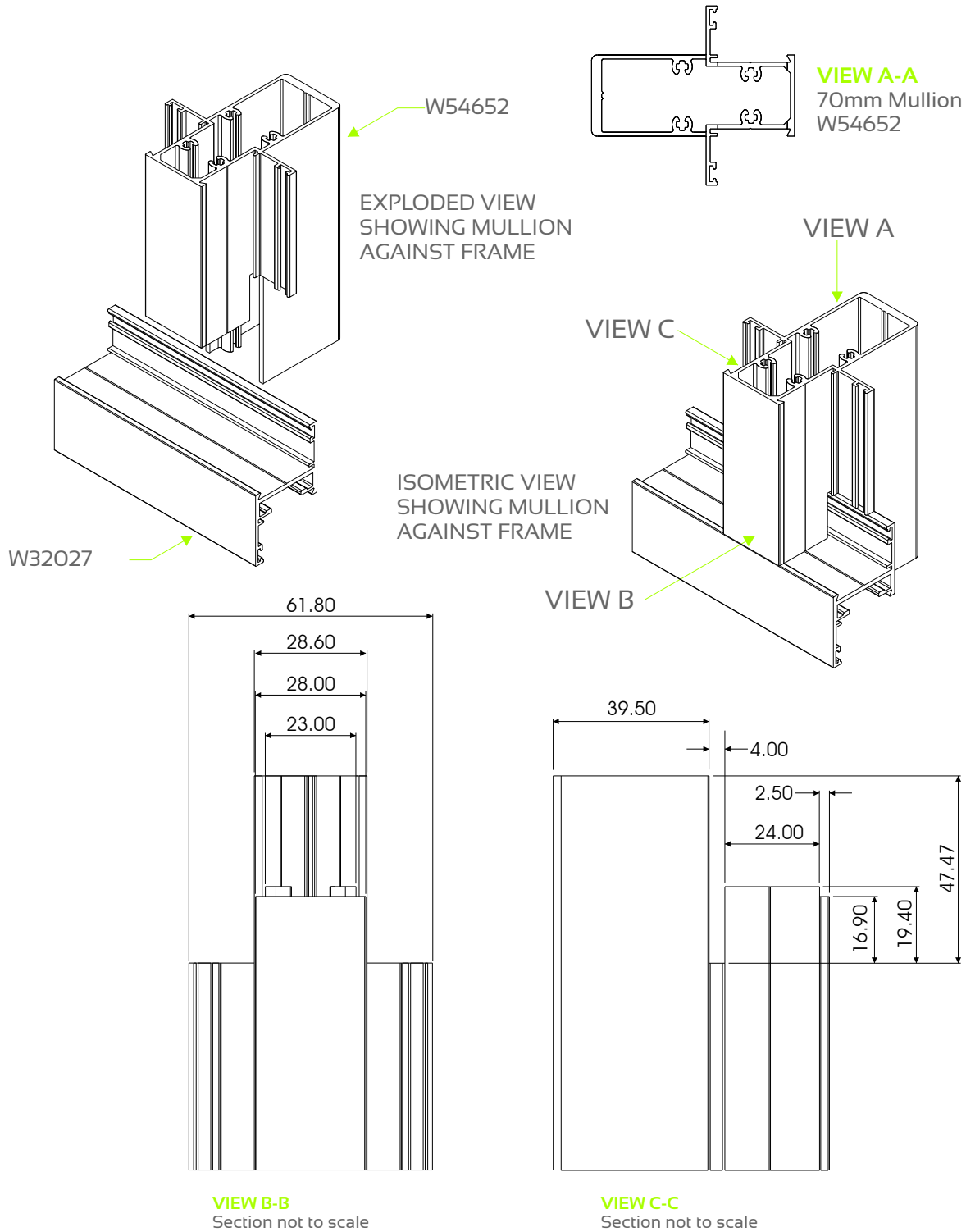
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



70mm Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

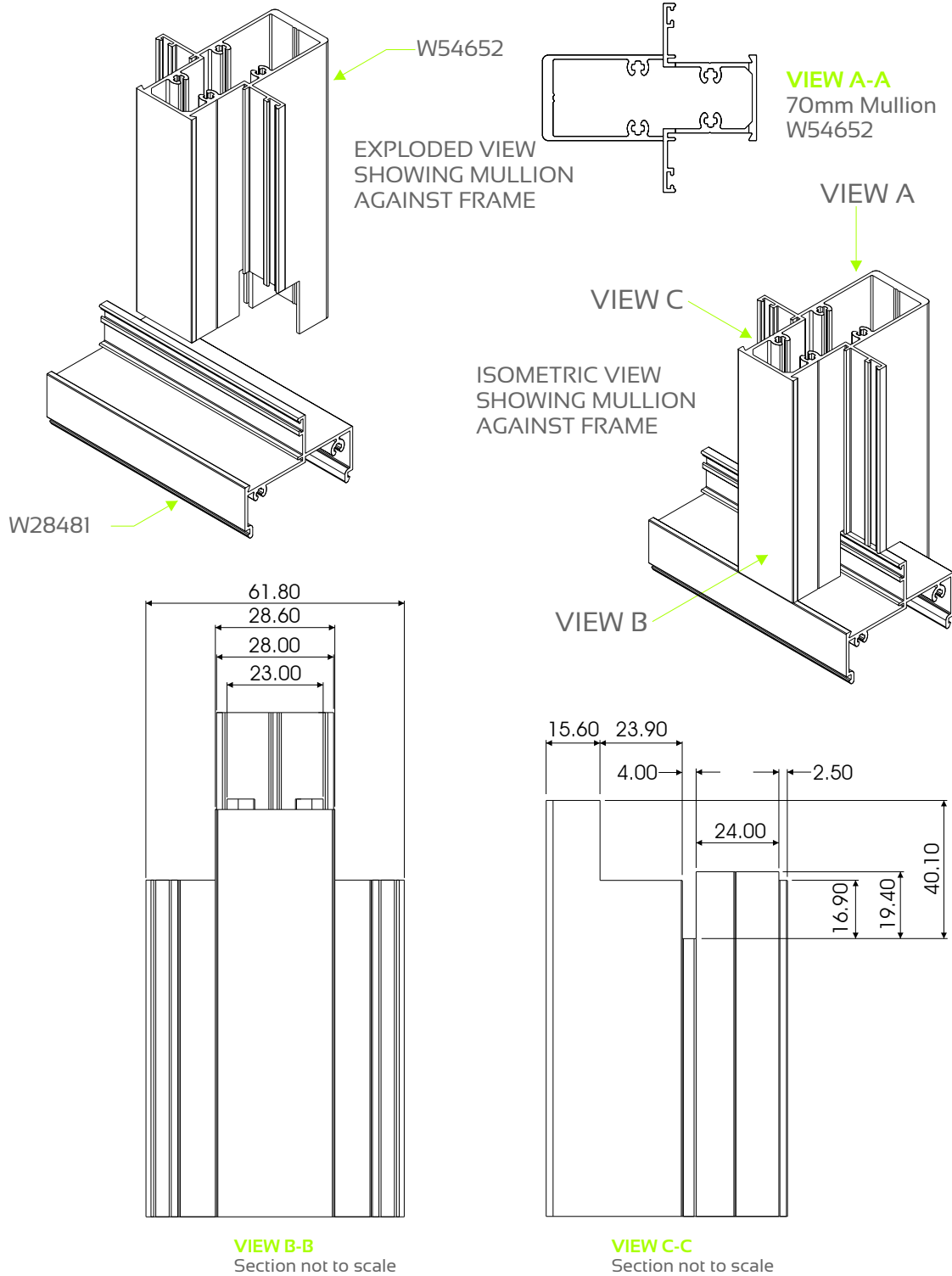
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



70mm Mullion Machining Detail

for End Milling on 54mm Outer Frame

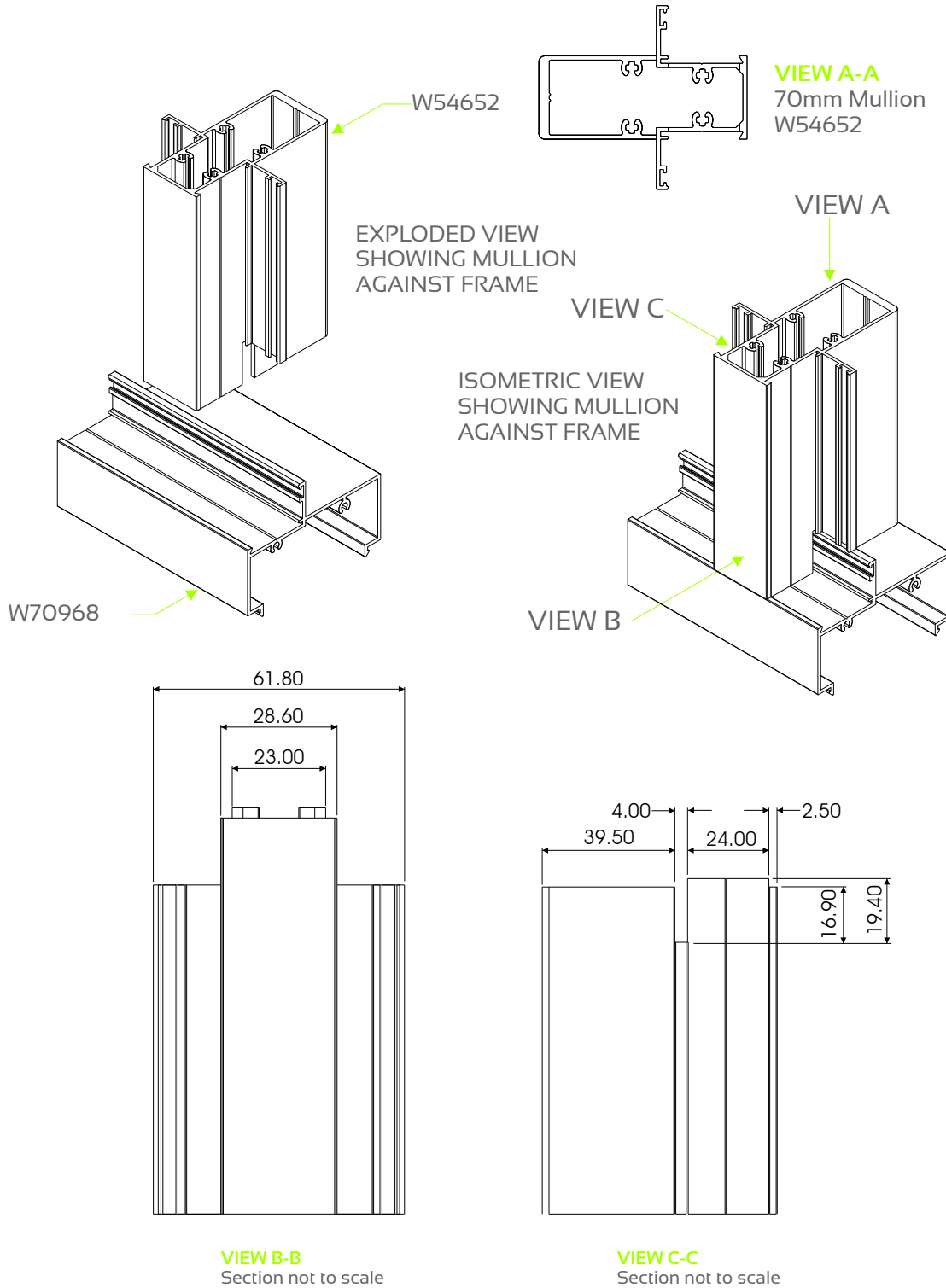
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



70mm Mullion Machining Detail

for End Milling on 70mm Outer Frame

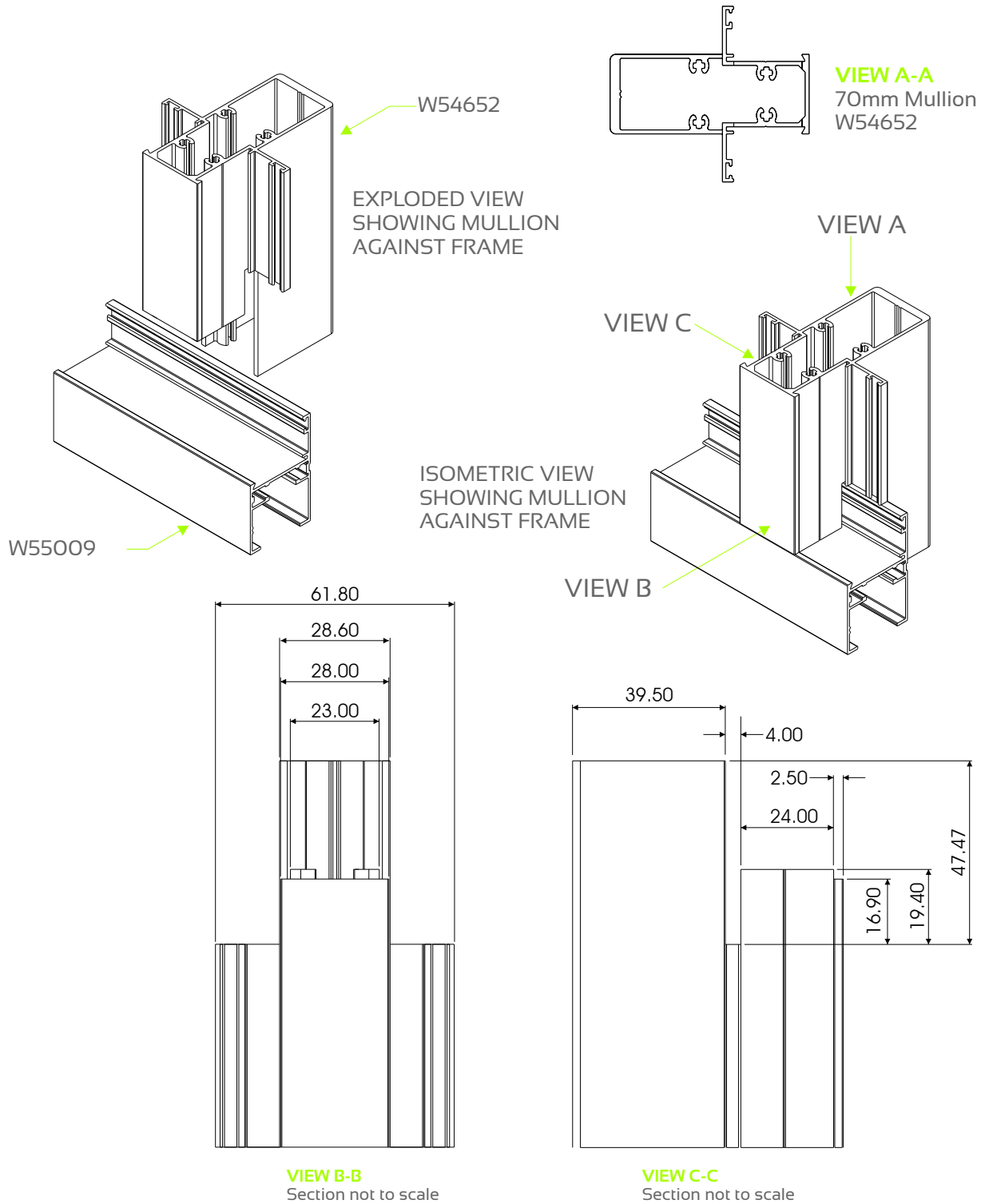
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



70mm Mullion Machining Detail

for End Milling on Lite Equal Leg Outer Frame

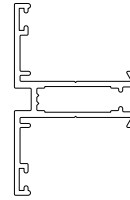
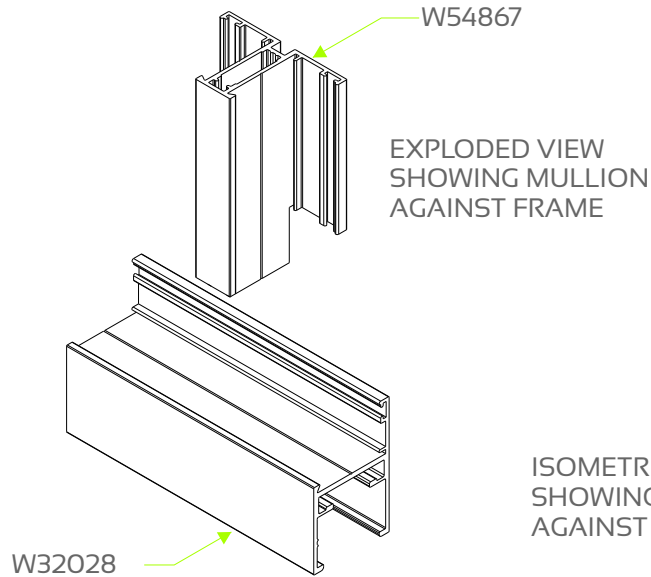
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Cottage Pane Mullion Machining Detail

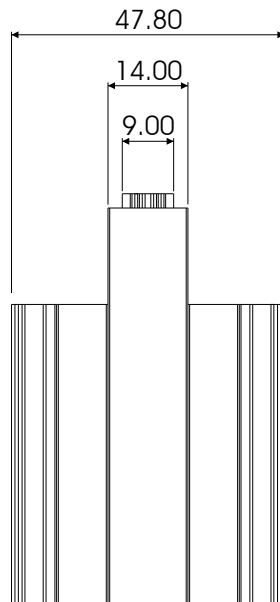
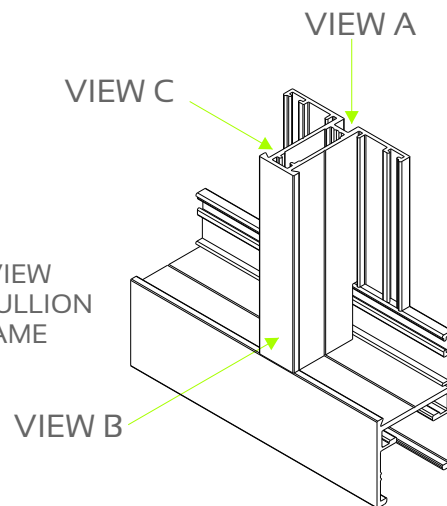
for End Milling on Equal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

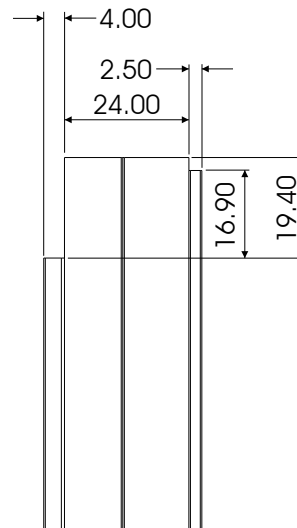


VIEW A-A
Cottage Pane Mullion
W54867

ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale

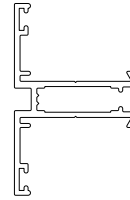
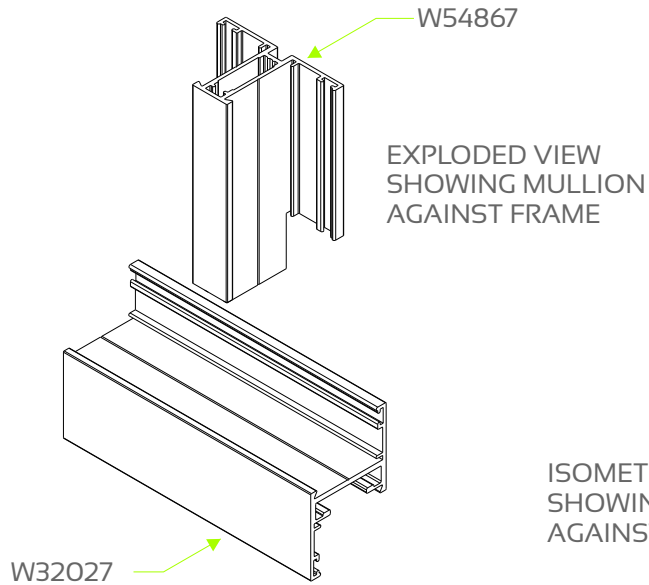


VIEW C-C
Section not to scale

Cottage Pane Mullion Machining Detail

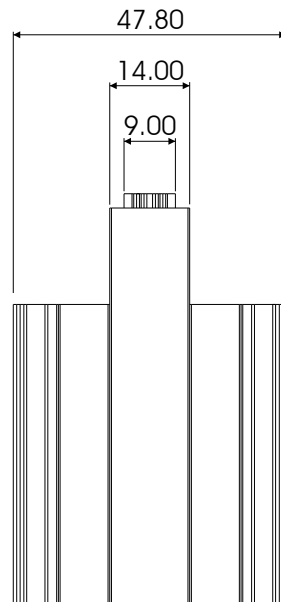
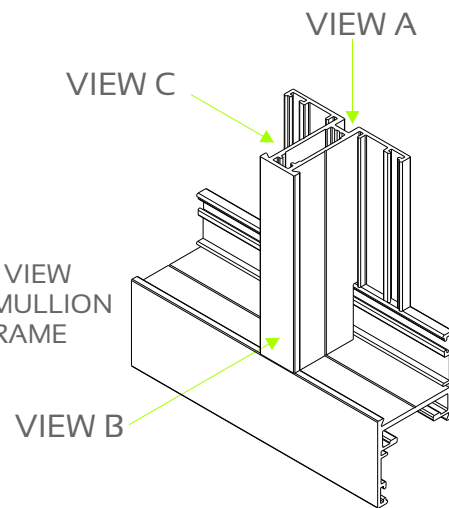
for End Milling on Unequal Leg Outer Frame

Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.

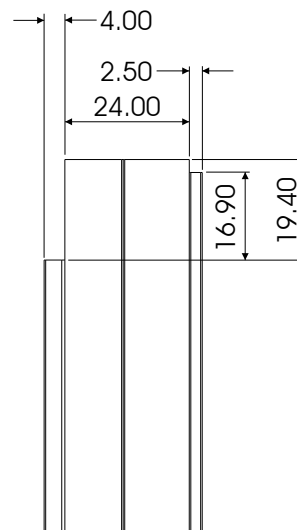


VIEW A-A
Cottage Pane Mullion
W54867

ISOMETRIC VIEW
SHOWING MULLION
AGAINST FRAME



VIEW B-B
Section not to scale

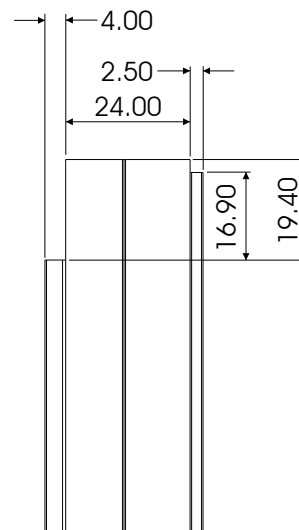
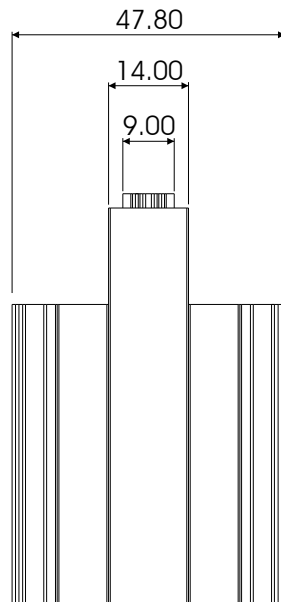
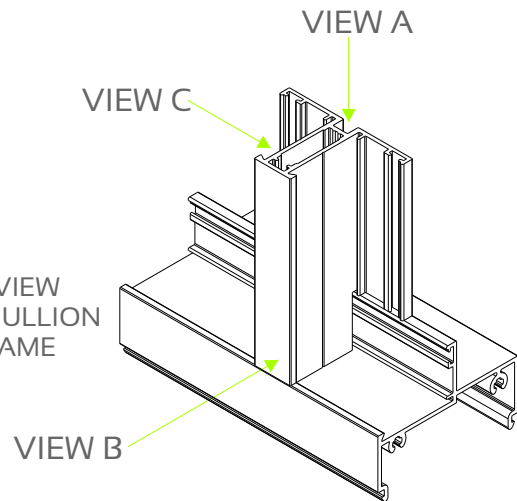
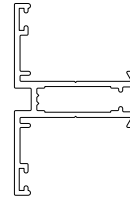
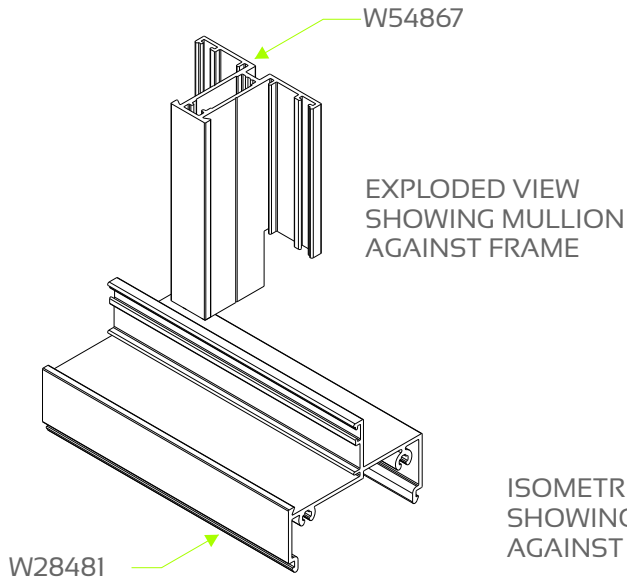


VIEW C-C
Section not to scale

Cottage Pane Mullion Machining Detail

for End Milling on 54mm Outer Frame

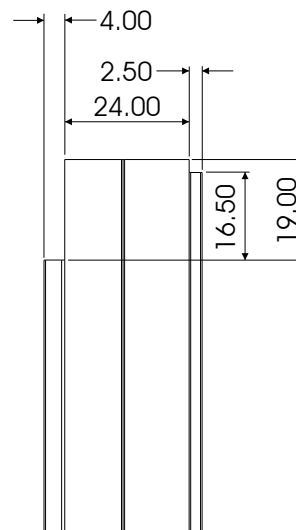
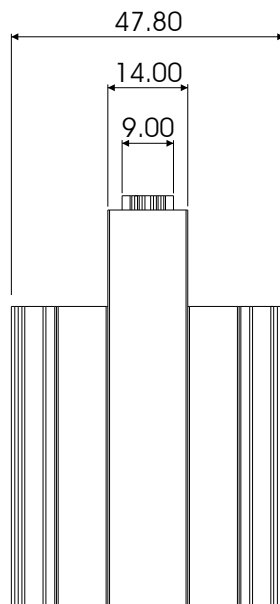
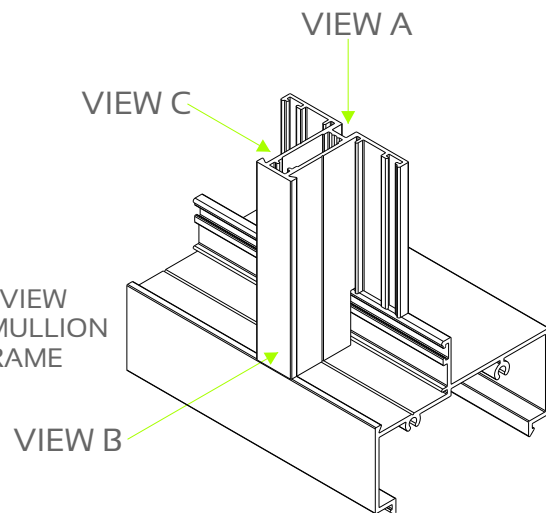
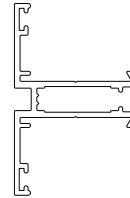
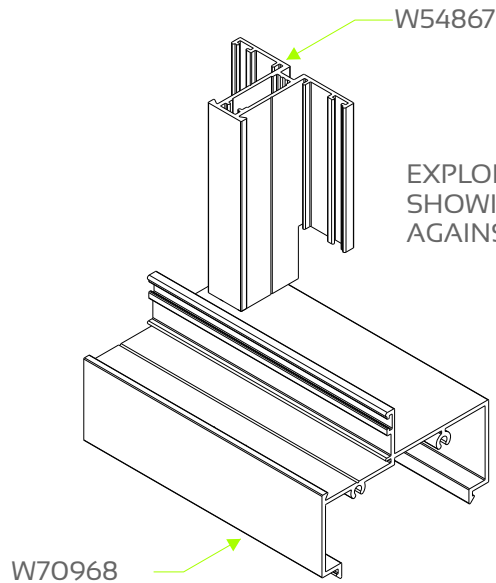
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Cottage Pane Mullion Machining Detail

for End Milling on 70mm Outer Frame

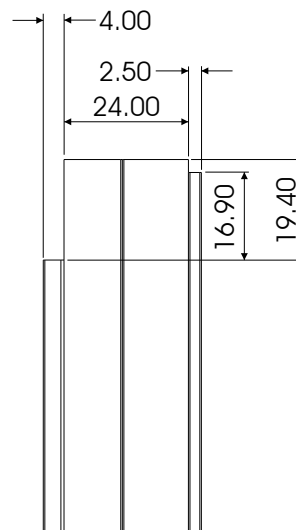
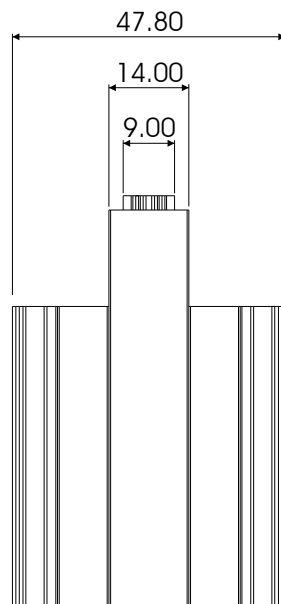
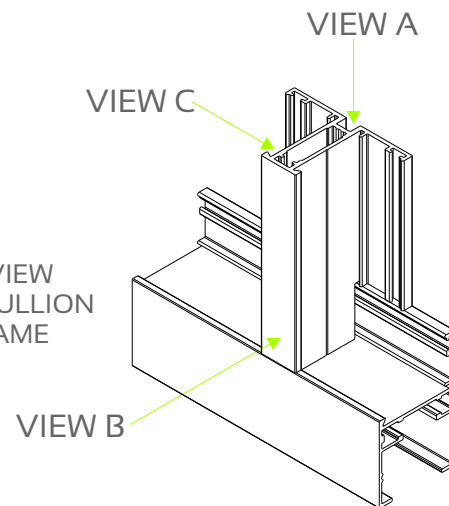
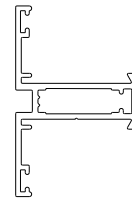
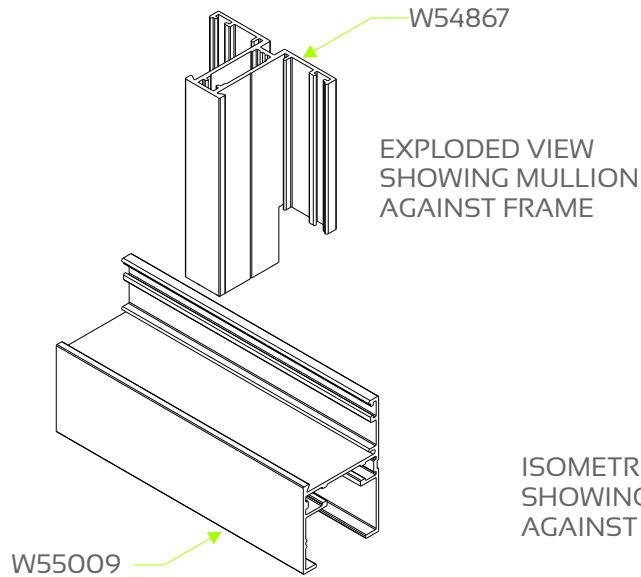
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Cottage Pane Mullion Machining Detail

for End Milling on Lite Equal Leg Outer Frame

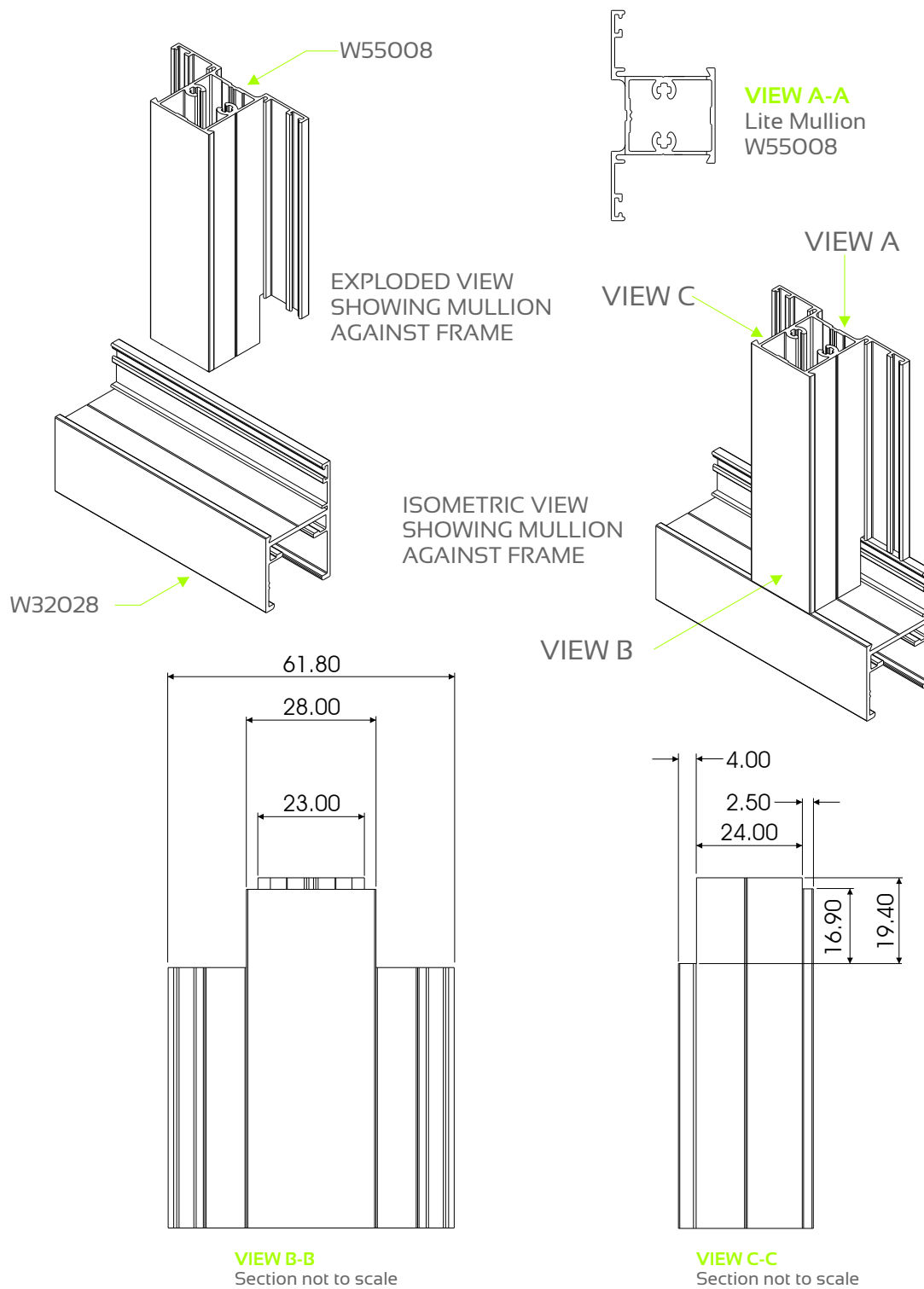
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Lite Mullion Machining Detail

for End Milling on Equal Leg Outer Frame

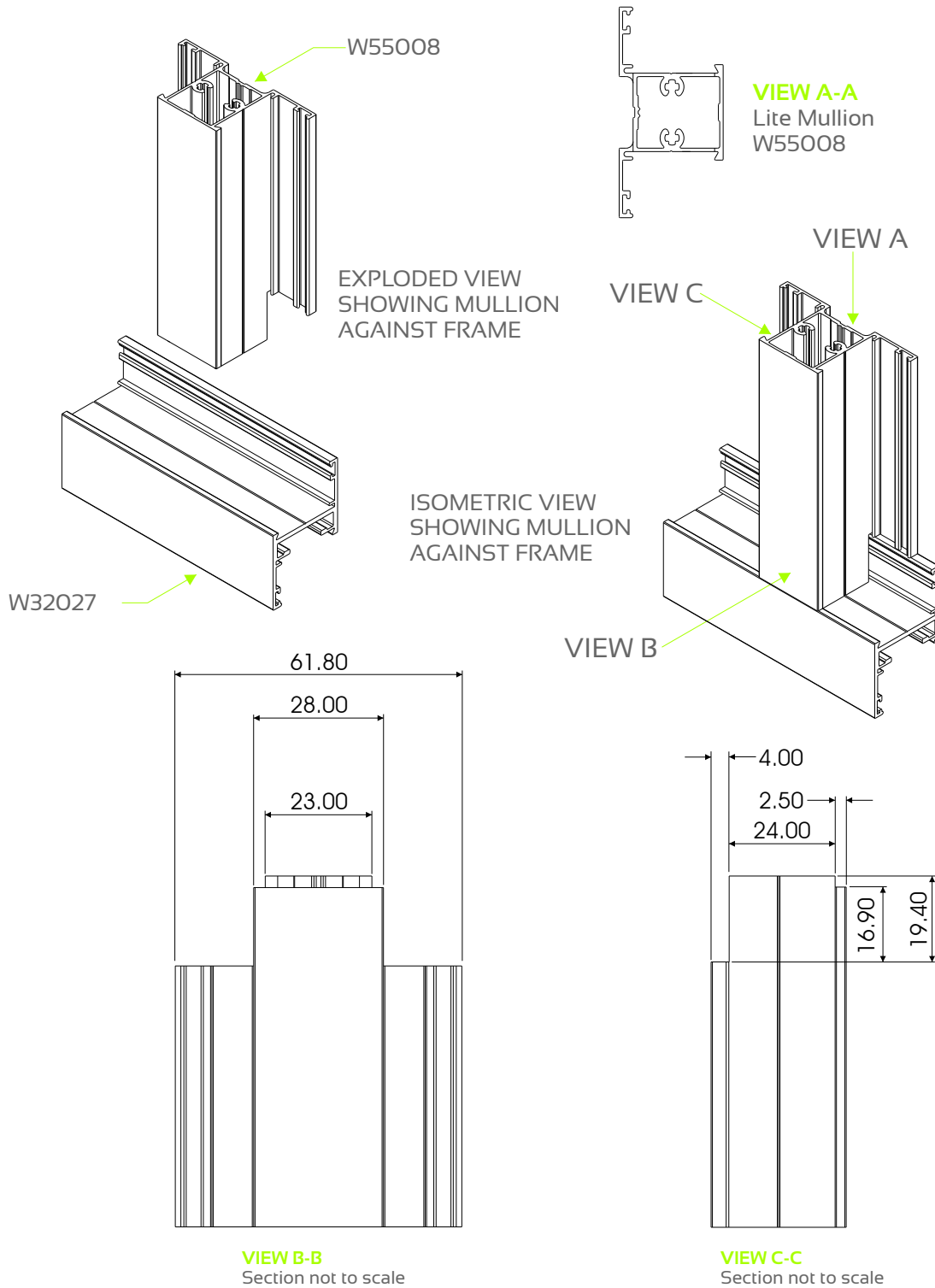
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Lite Mullion Machining Detail

for End Milling on Unequal Leg Outer Frame

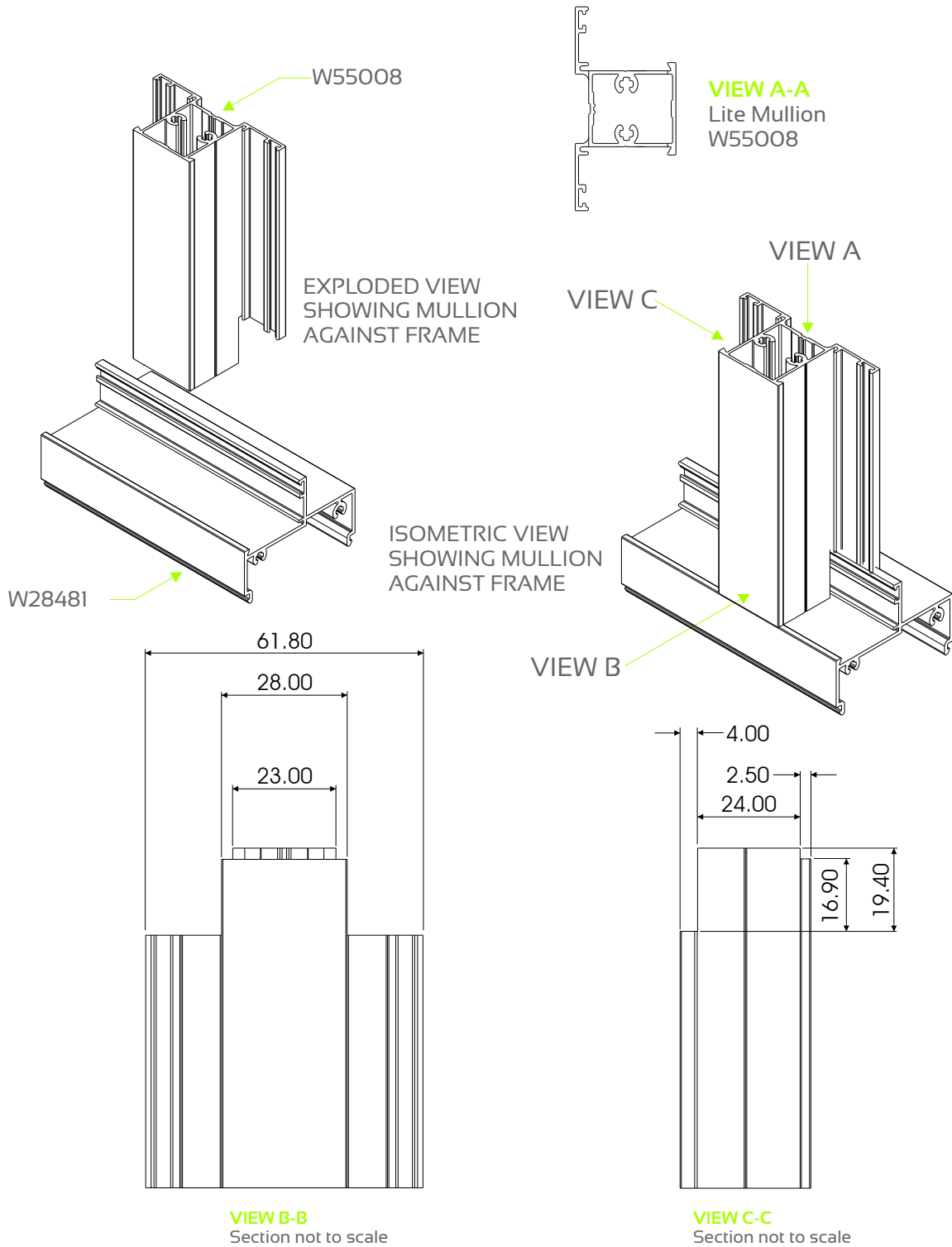
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Lite Mullion Machining Detail

for End Milling on 54mm Outer Frame

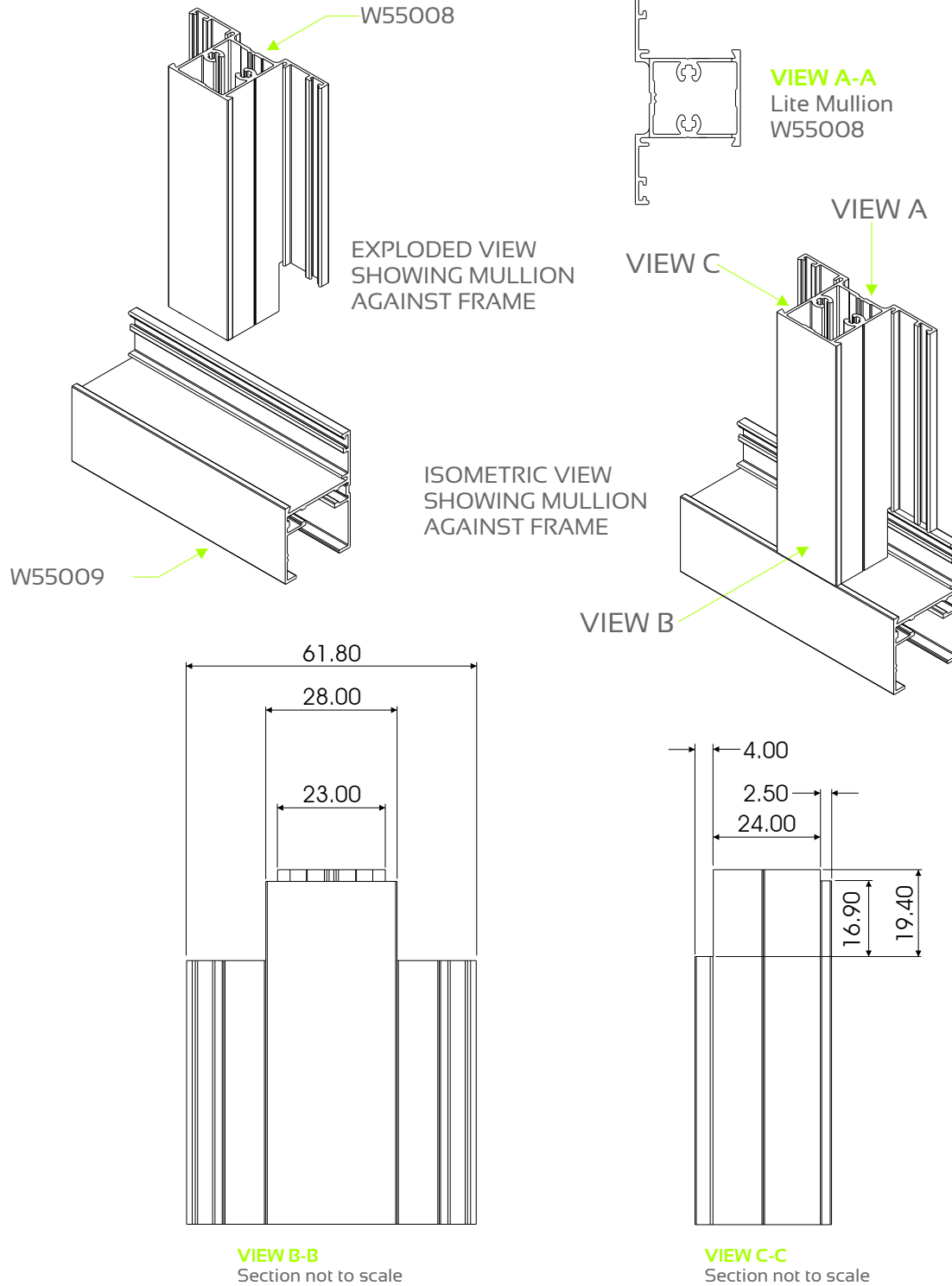
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



Lite Mullion Machining Detail

for End Milling on Lite Equal Leg Outer Frame

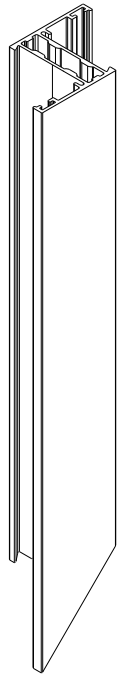
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



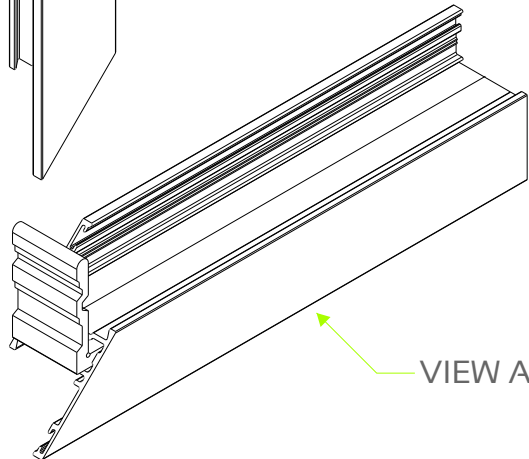
Corner Cleat Assembly Detail

for Lite Sash

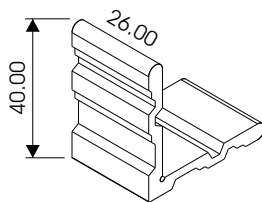
Please Note: These details pertain to the machining of profiles. Lengths of profiles and cutting lists need to be confirmed using the StarFront Program to ensure compliance to the SANS Building Regulations.



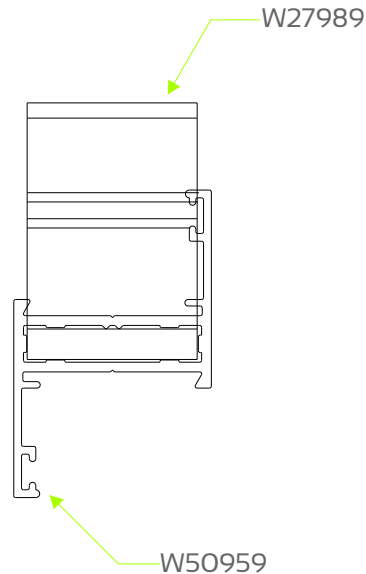
NOTE:
ALL JOINTS MUST BE SEALED WITH
SMALL JOINT SEALANT. FINPILE
MUST BE FITTED TO SASH AND
CORRESPONDING SURFACES OF
FRAME BEFORE CRIMPING (NOT
TO AREAS TO BE GLAZED)



VIEW A



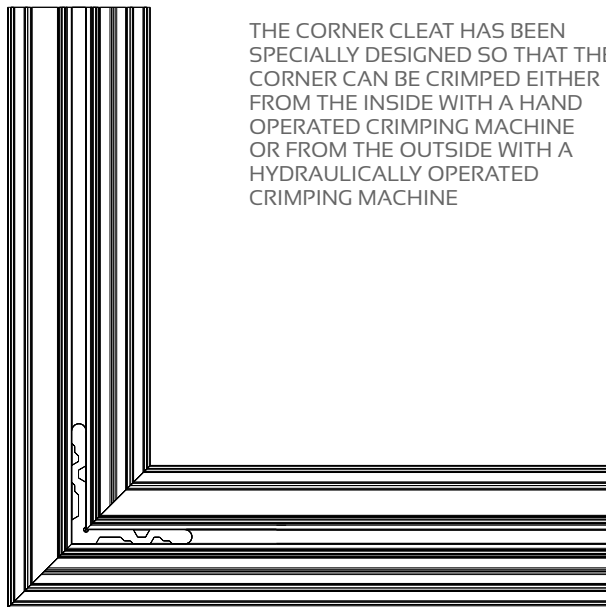
W27989



W27989

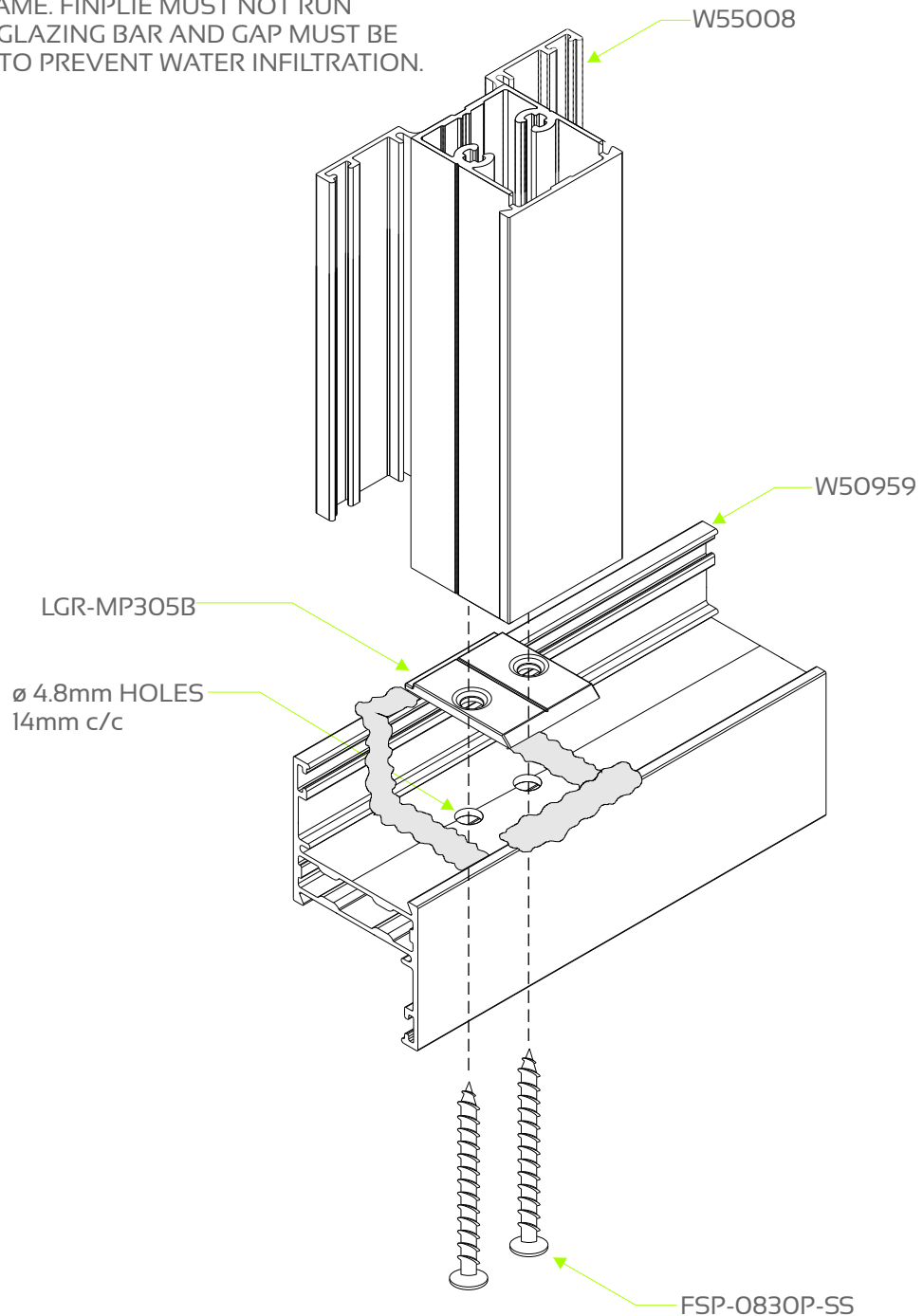
W50959

THE CORNER CLEAT HAS BEEN
SPECIALLY DESIGNED SO THAT THE
CORNER CAN BE CRIMPED EITHER
FROM THE INSIDE WITH A HAND
OPERATED CRIMPING MACHINE
OR FROM THE OUTSIDE WITH A
HYDRAULICALLY OPERATED
CRIMPING MACHINE

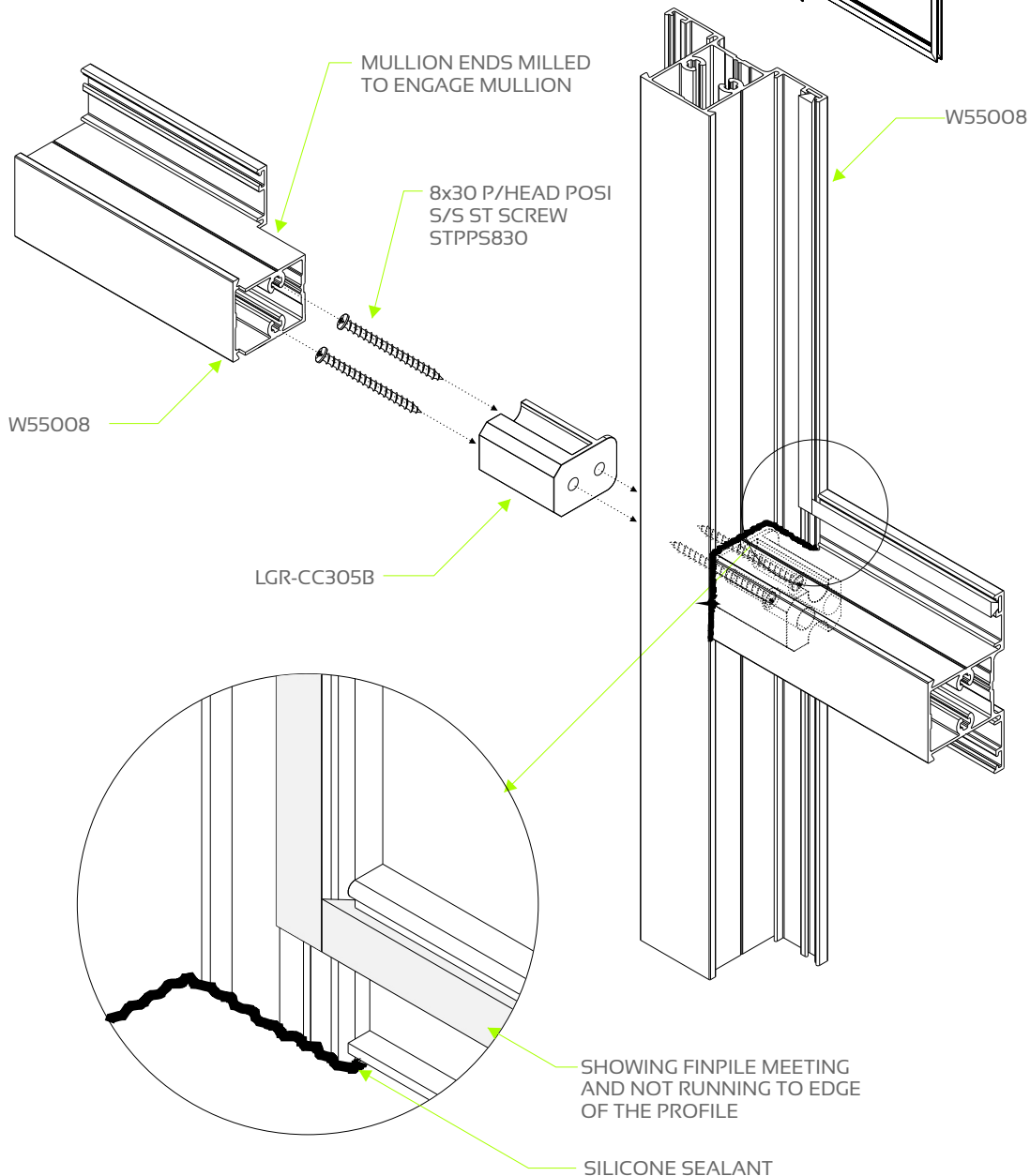


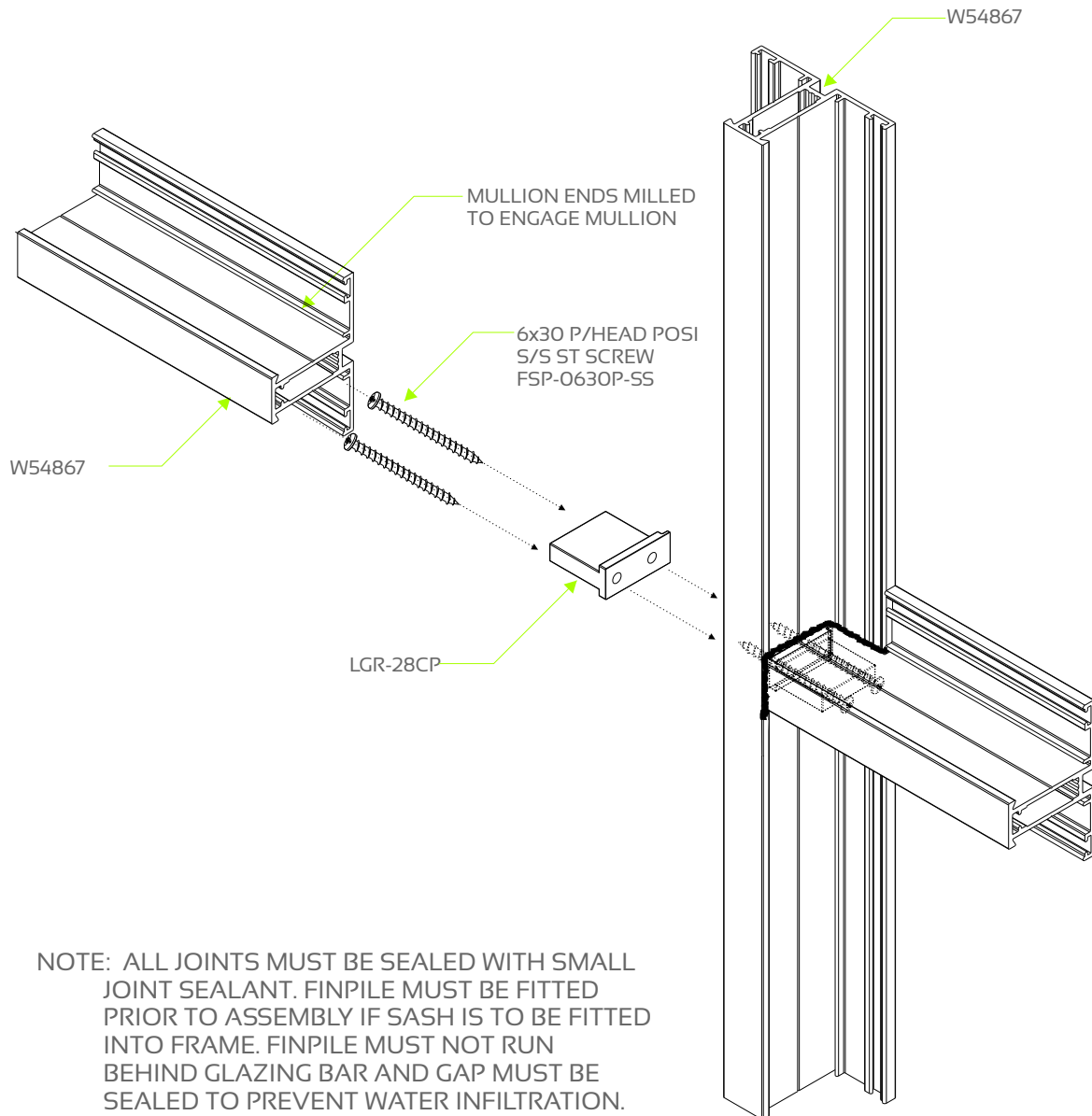
VIEW A-A

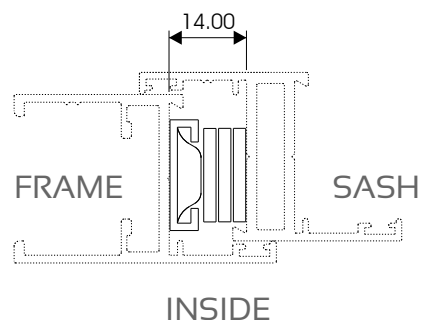
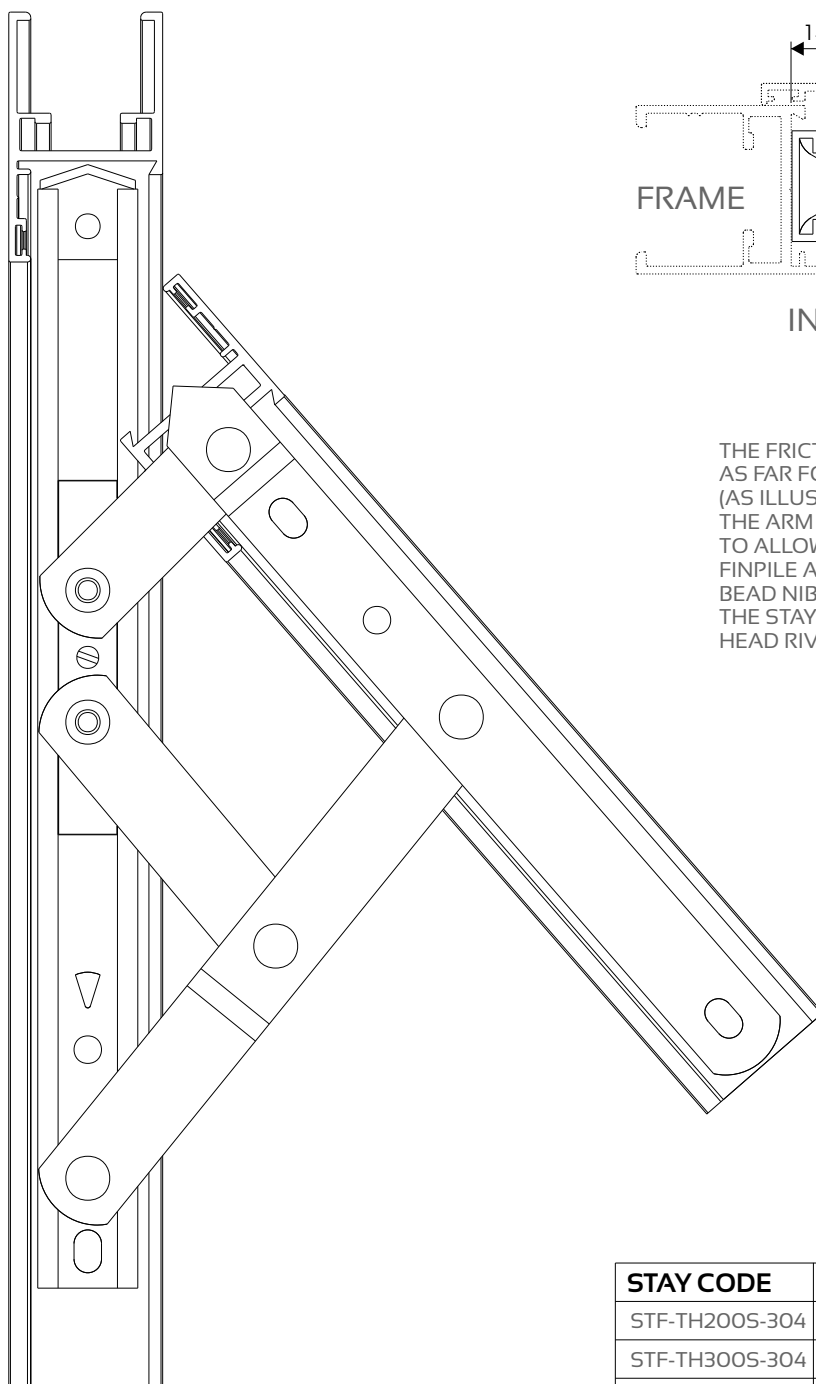
NOTE: ALL JOINTS MUST BE SEALED WITH SMALL JOINT SEALANT. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPLIE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.



NOTE: ALL JOINTS MUST BE SEALED WITH SMALL JOINT SEALANT. FINPILE MUST BE FITTED PRIOR TO ASSEMBLY IF SASH IS TO BE FITTED INTO FRAME. FINPILE MUST NOT RUN BEHIND GLAZING BAR AND GAP MUST BE SEALED TO PREVENT WATER INFILTRATION.

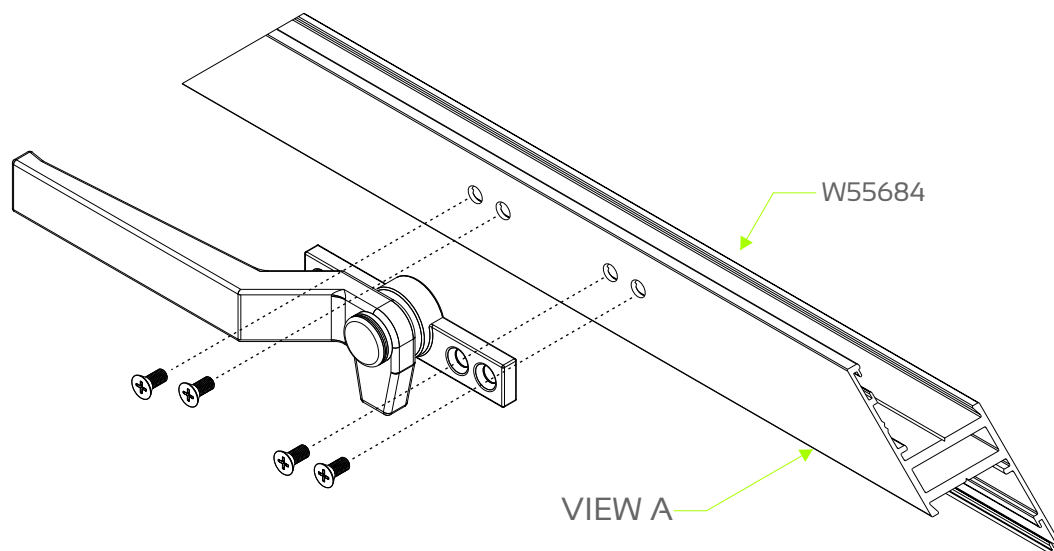




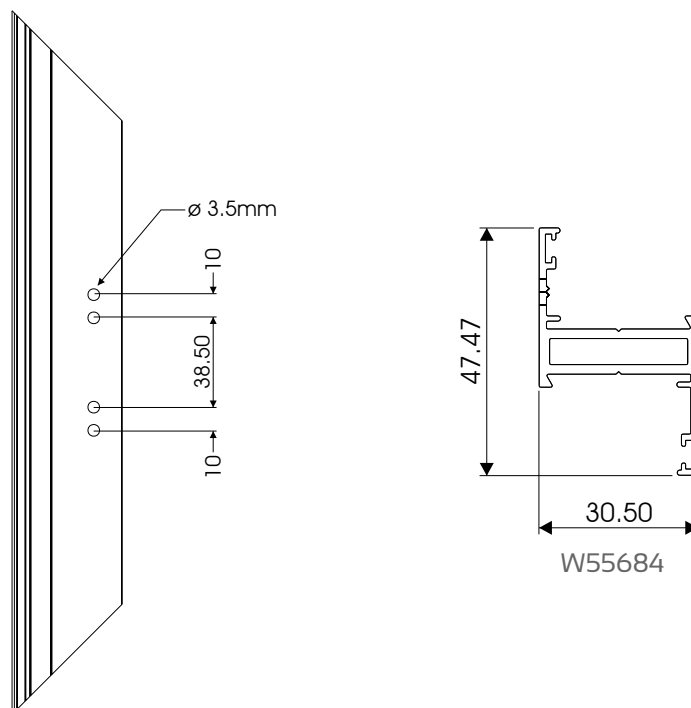


THE FRICTION STAY SHOULD ALWAYS BE FITTED AS FAR FORWARD IN THE FRAME AS POSSIBLE. (AS ILLUSTRATED)
THE ARM FIXED TO THE SASH SHOULD BE FITTED TO ALLOW CORRECT COMPRESSION OF THE FINPILE AND PACKED TO CLEAR GLAZING BEAD NIB.
THE STAYS ARE SECURED WITH 4.8 x 10 DOME HEAD RIVETS.

STAY CODE	TO BE USED FOR SASH SIZE
STF-TH200S-304	LESS THAN OR EQUAL TO 300mm
STF-TH300S-304	BETWEEN 301mm AND 450mm
STF-TH400S-304	BETWEEN 451mm AND 600mm
STF-TH500S-304	BETWEEN 601mm AND 750mm
STF-T600S-304	GREATER THAN 750mm



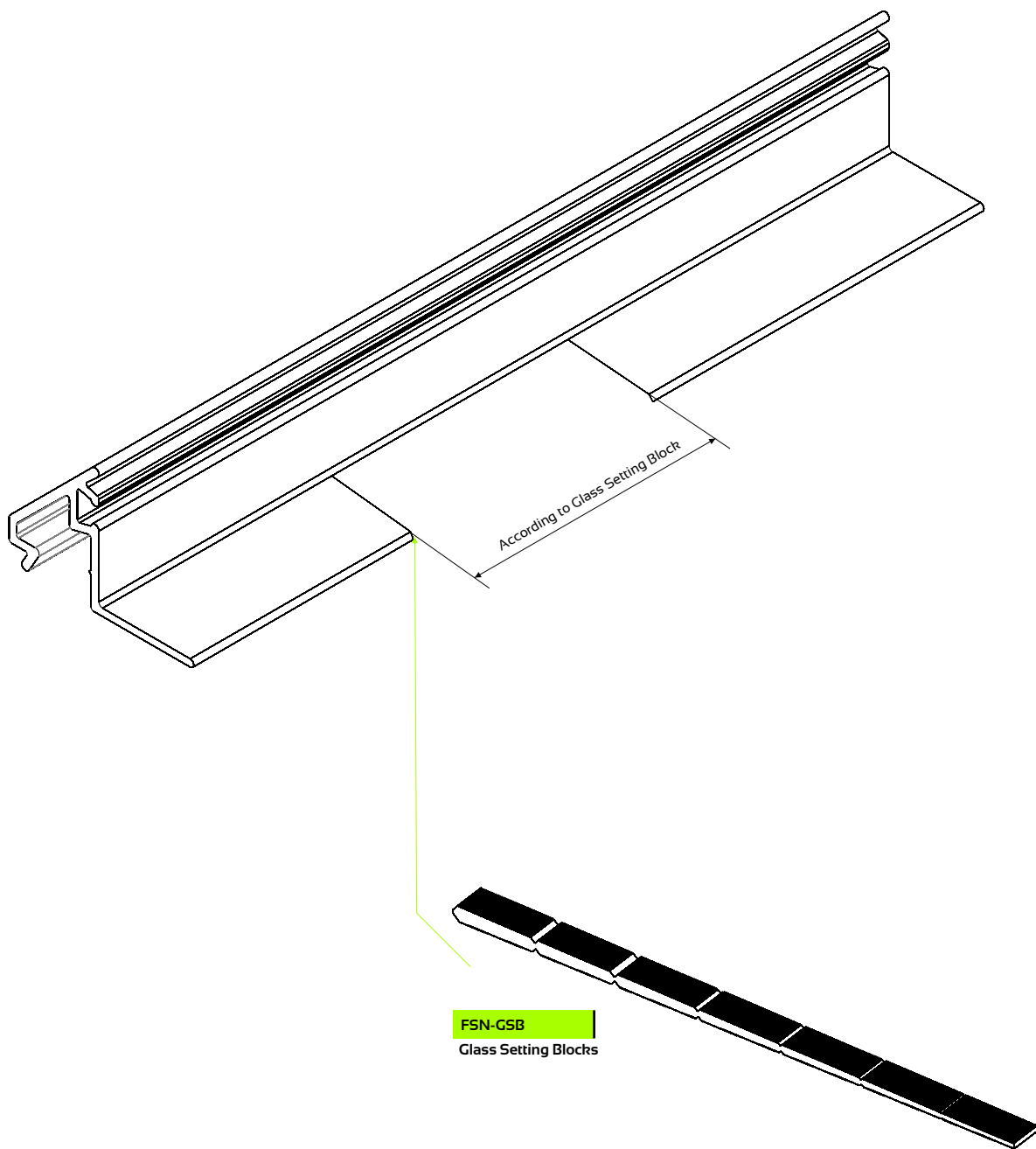
NO 8 x 10 COUNTERSUNK SELF-TAPPING
FLAT END SCREWS



VIEW A-A

Bead Cut-Out for Setting Block

Bead must be notched out at position of all glass setting blocks according to the length of the glass setting block used.



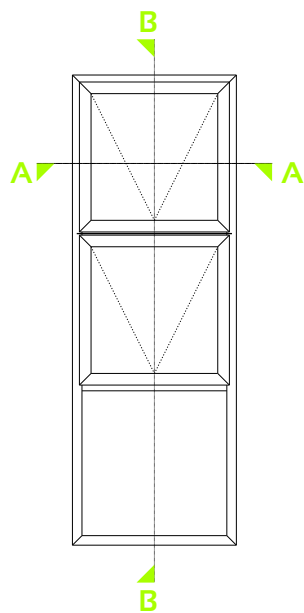
CASEMENT 30.5

WINDOW (30.5mm)

PRODUCT MANUAL

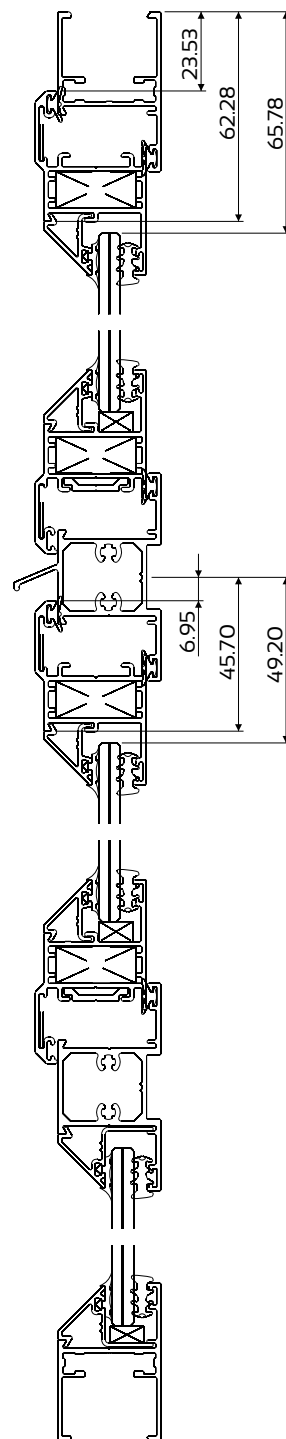
Typical Cross-sectional Details

Double Top Hung over Fixed



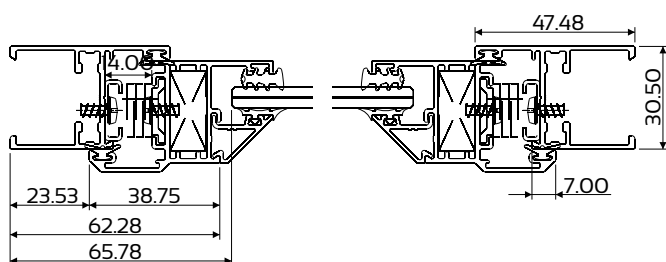
SECTION B-B

Section not to scale



SECTION A - A

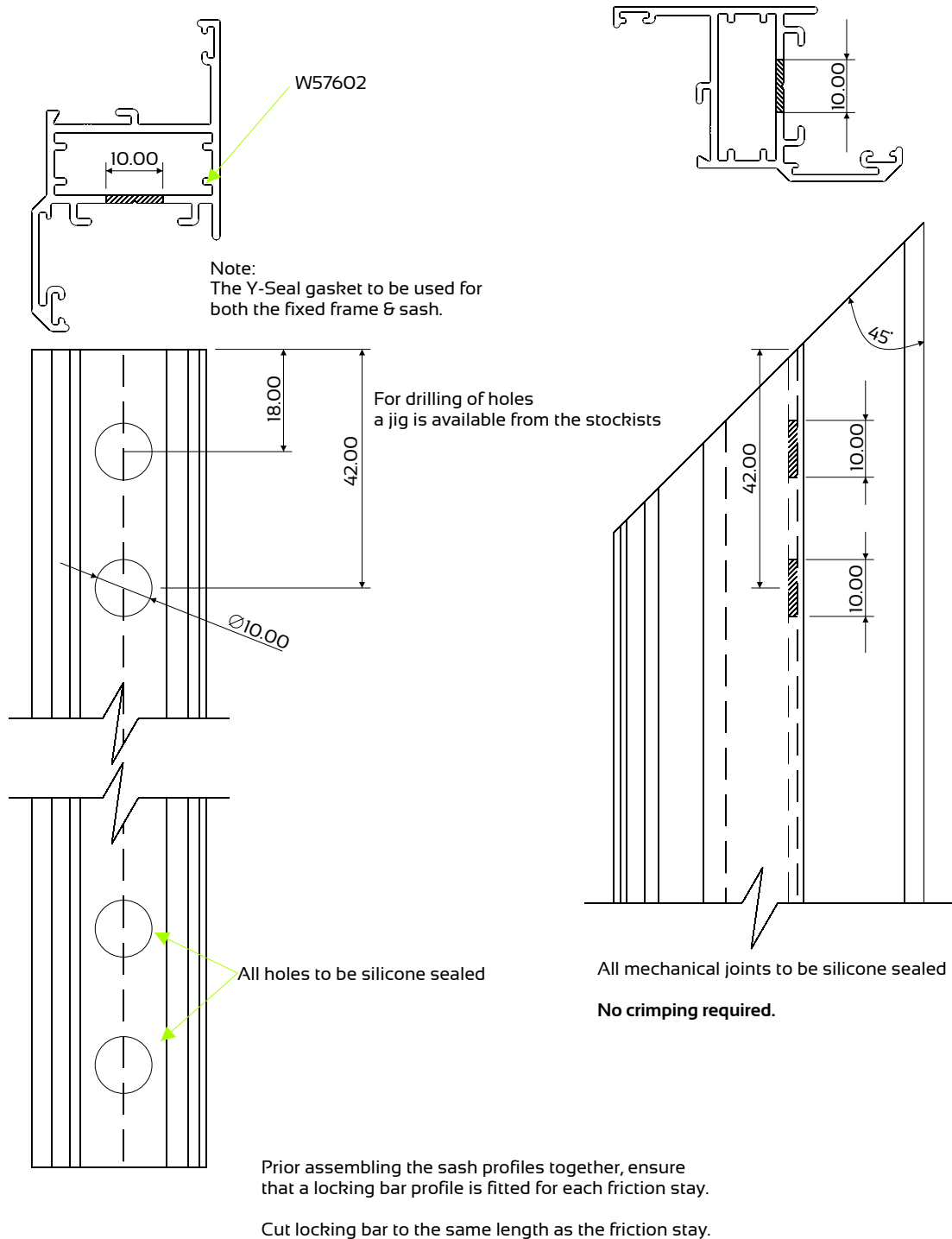
Section not to scale



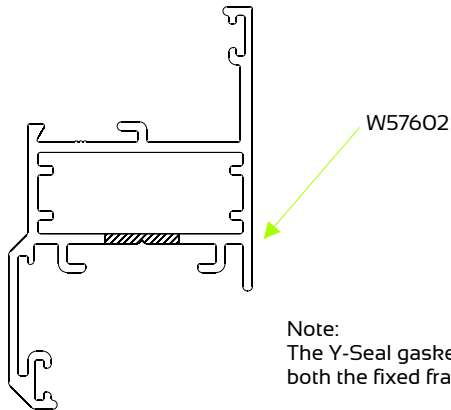
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

Disclaimer: The right to make alterations is reserved
© 2013 Wispeco (Pty) Ltd, All Rights Reserved

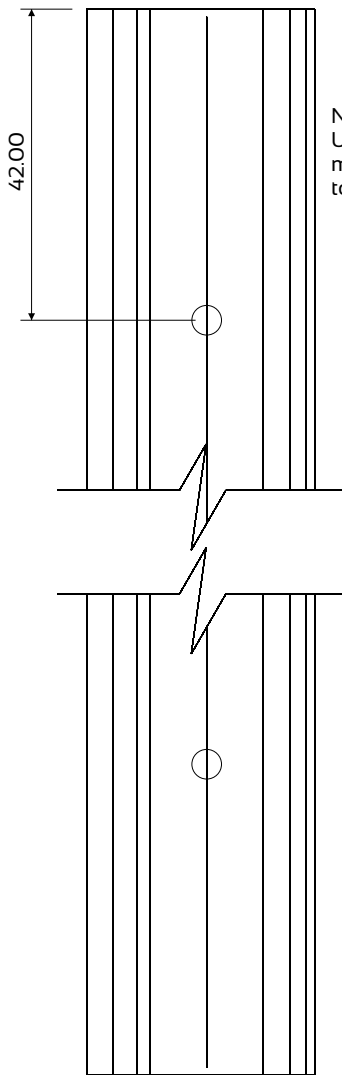
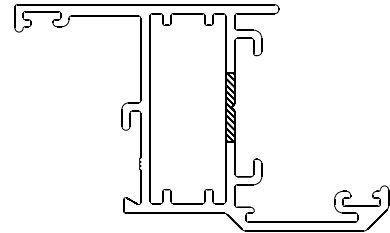
OPTION A - USING THE JOINING CORNER



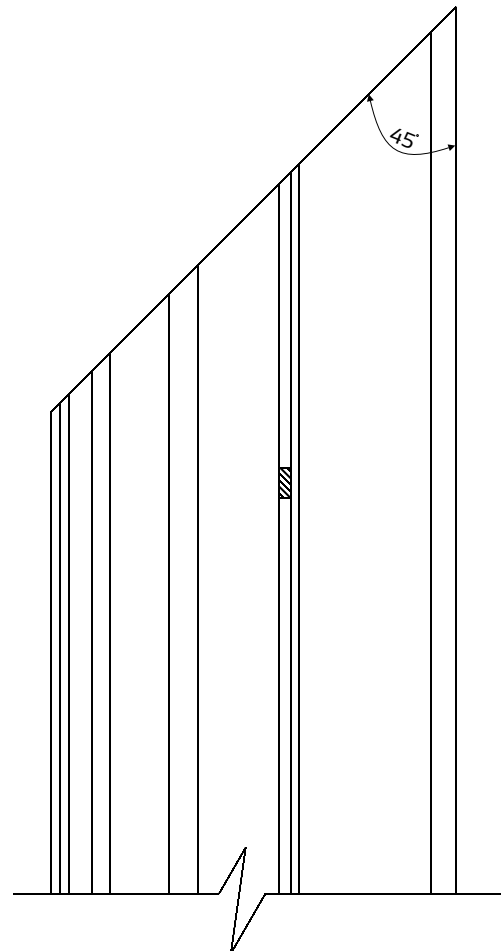
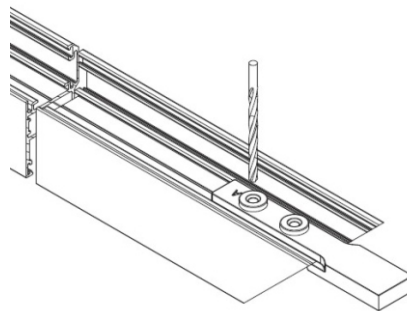
OPTION B - USING THE CORNER CONNECTOR



Note:
The Y-Seal gasket to be used for
both the fixed frame & sash.



Note:
Use the jig for drilling the holes
marked "A" to fix the pop rivet
to the corner connector.

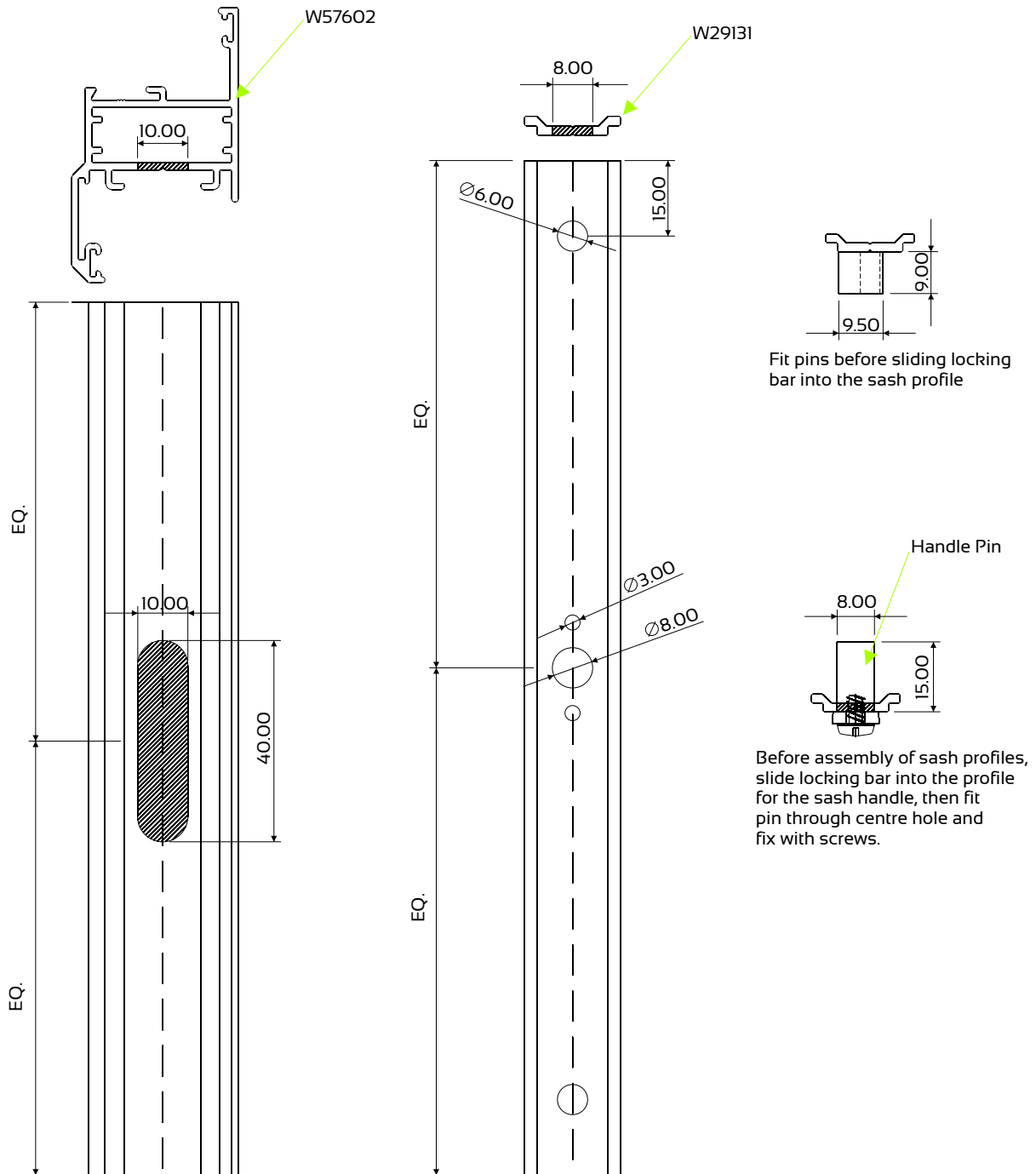


All mechanical joints to be silicone sealed

No crimping required.

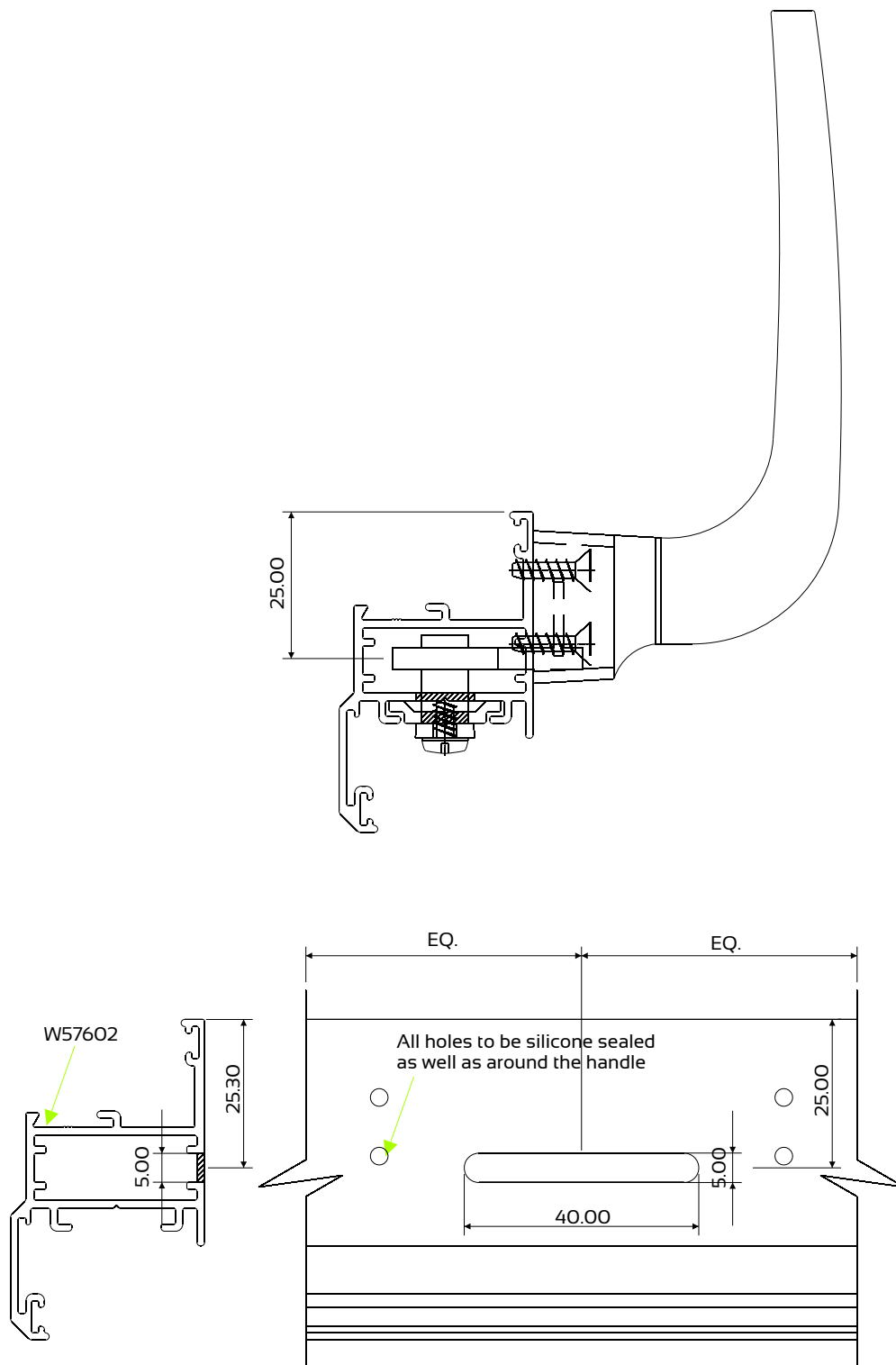
Prior assembling the sash profiles together, ensure
that a locking bar profile is fitted for each friction stay.

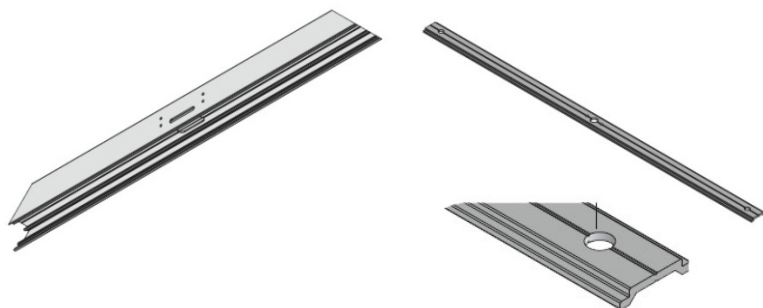
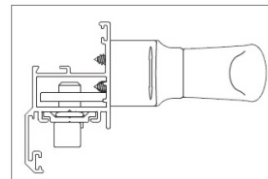
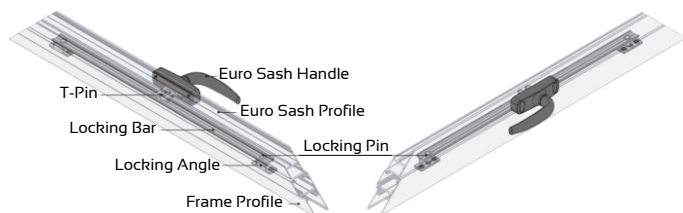
Cut locking bar to the same length as the friction stay.



Note:

Before assembly of the sash frame, the locking bar needs to be inserted into the bottom sash profile with the locking pins fitted & holes drilled to receive the handle pin.

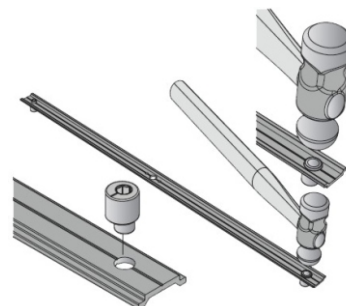




Once all frame profiles have been cut to length and deburred, machine the handle profile according to Maching details as shown on the previous page.

Cut the locking bar as per StarFront 6 machine as shown in diagram 2.

2



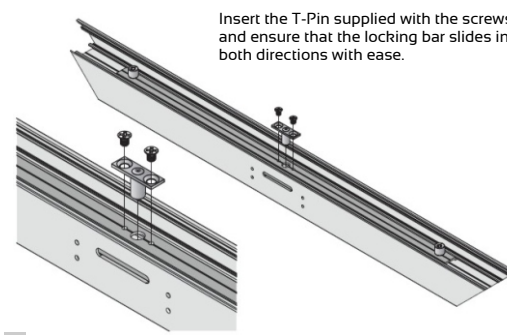
Insert the locking pins into the locking bar. Deform the protruding part of the pin using a ball peen hammer or punch to fix them onto the locking bar.

3



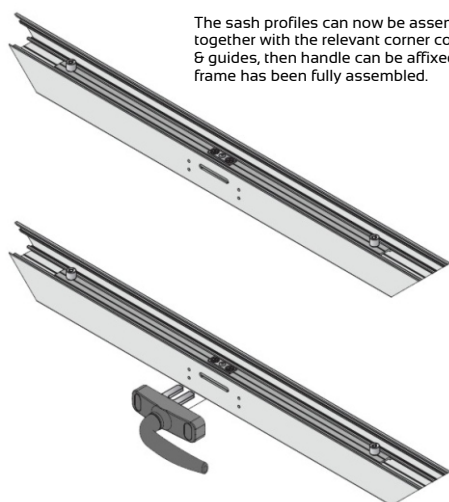
Insert the locking bar into the Sash Profile prior to any assembly of the sash profiles, as the Locking bar will not be able to be added later.

4



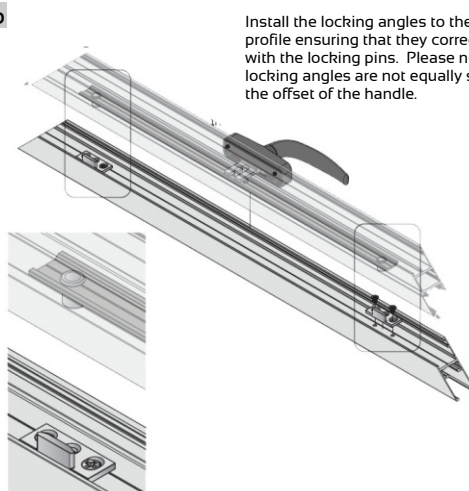
Insert the T-Pin supplied with the screws and ensure that the locking bar slides in both directions with ease.

5

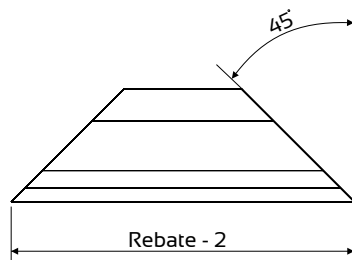
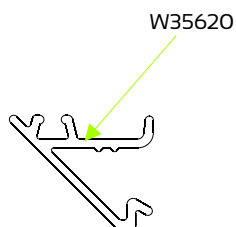


The sash profiles can now be assembled together with the relevant corner connectors & guides, then handle can be affixed after the frame has been fully assembled.

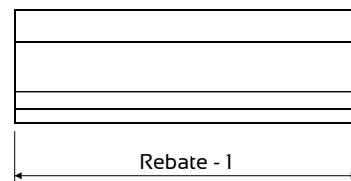
6



Install the locking angles to the outer frame profile ensuring that they correctly align with the locking pins. Please note that the locking angles are not equally spaced due to the offset of the handle.

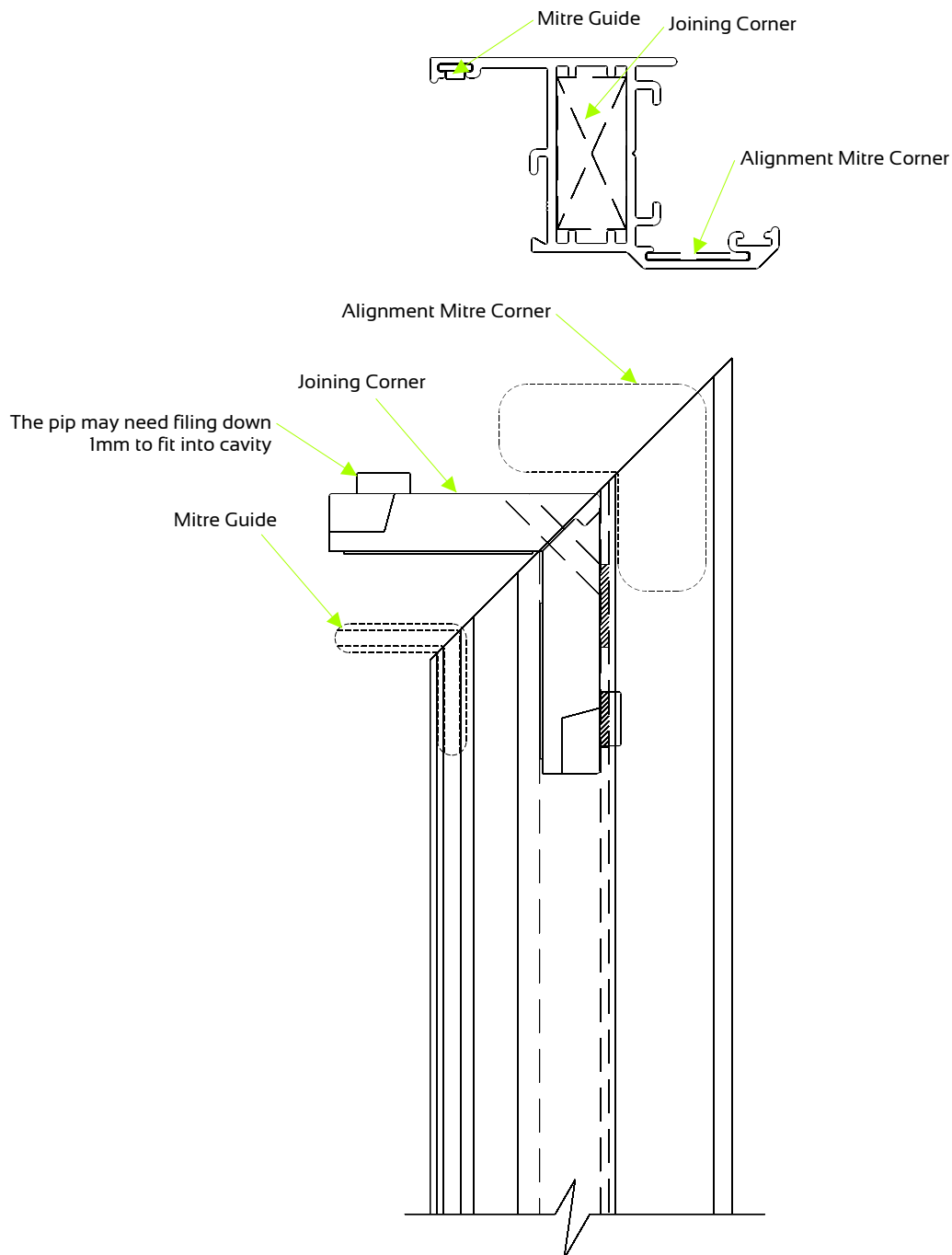


Vertical Glazing Bead



Horizontal Glazing Bead

OPTION A - USING THE JOINING CORNER

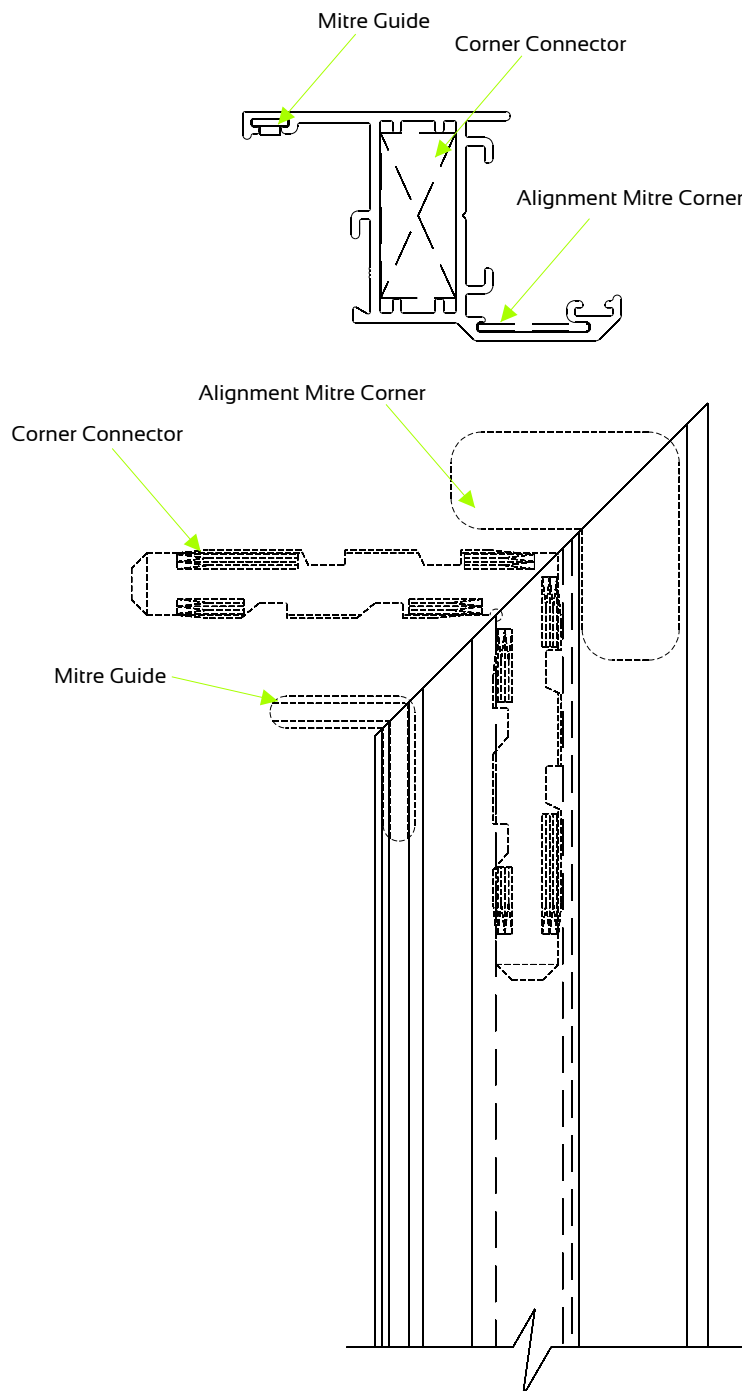


All mechanical joints to be Crealco silicone sealed

Note: Remember to fit the locking bars for friction stays before assembly of sash frame.

No crimping required.

OPTION B - USING CORNER CONNECTOR



All mechanical joints to be Crealco silicone sealed

Note: Remember to fit the locking bars for friction stays before assembly of sash frame.

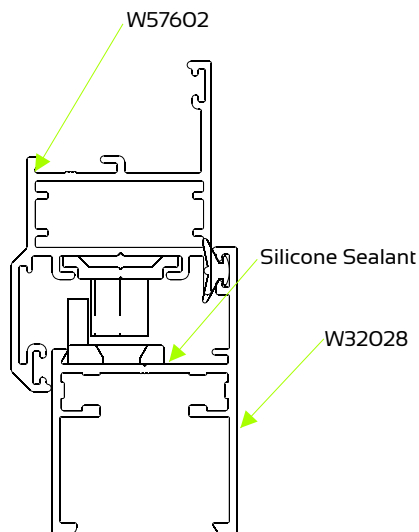
No crimping required.

CASEMENT 30.5

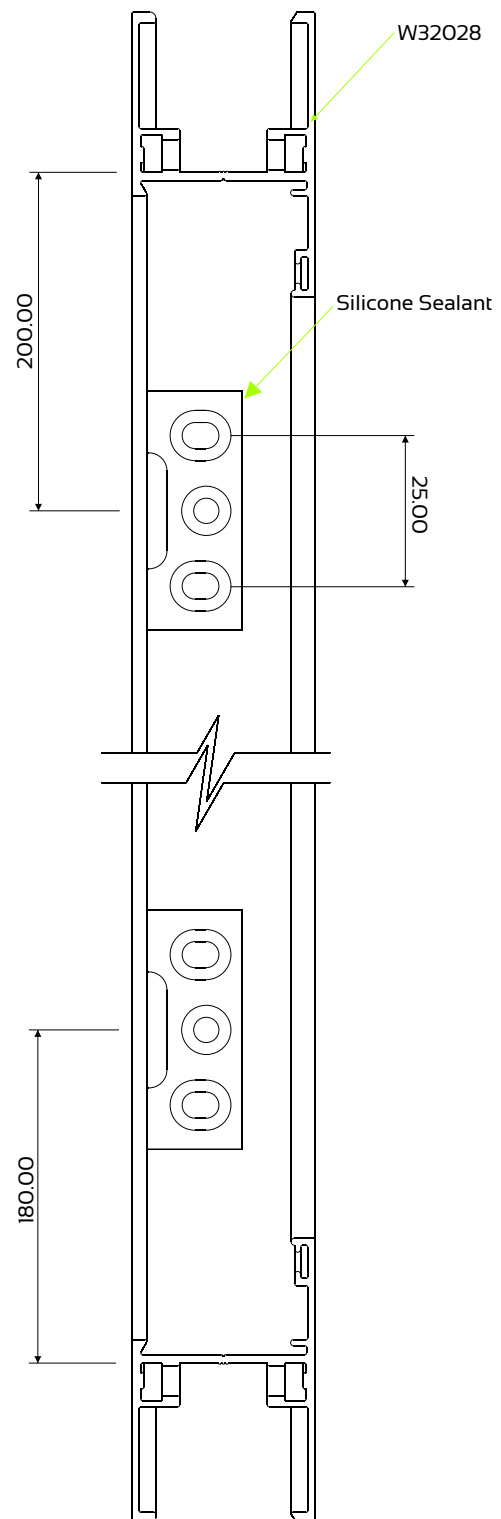
WINDOW (30.5mm)

PRODUCT MANUAL

Euro Sash Locking Angle Detail

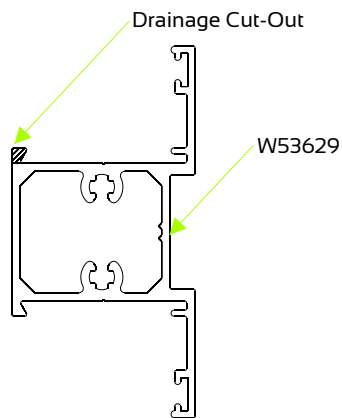
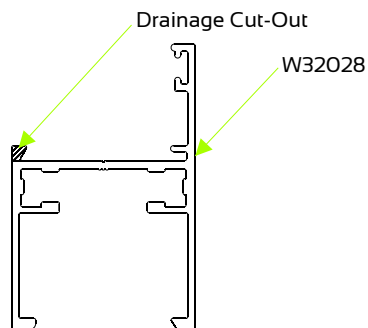


Note:
No Y-seal gasket to be fitted
for the bottom sash profile unless
the building is over 5 stories high.
Ensure the Y-seal gasket sits
between the drainage cut-out.

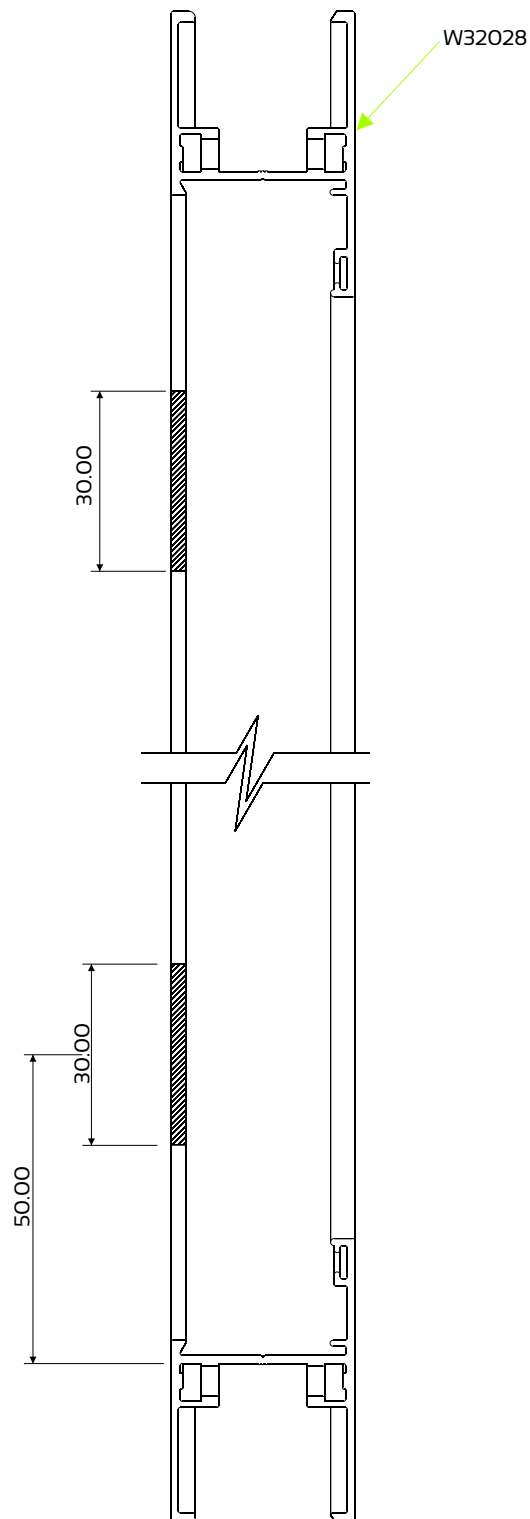


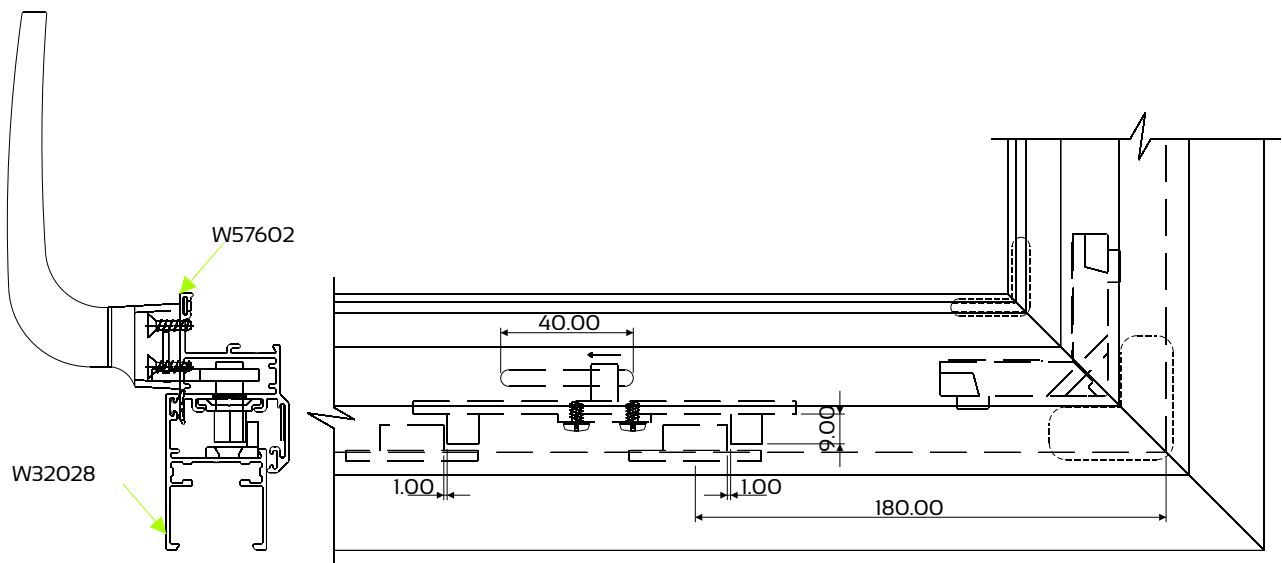
Euro Sash Outer Frame Drainage Detail

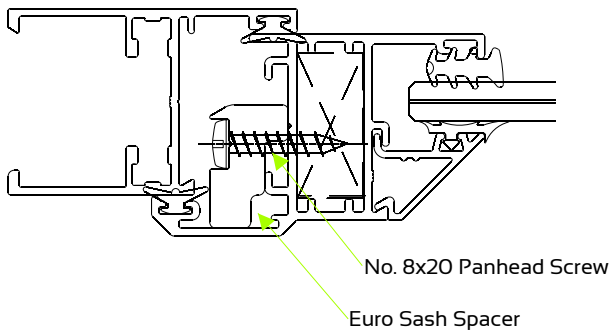
Detail for Severe Weather Conditions



Note:
The Y-seal gasket to be used for both the fixed frame & sash.

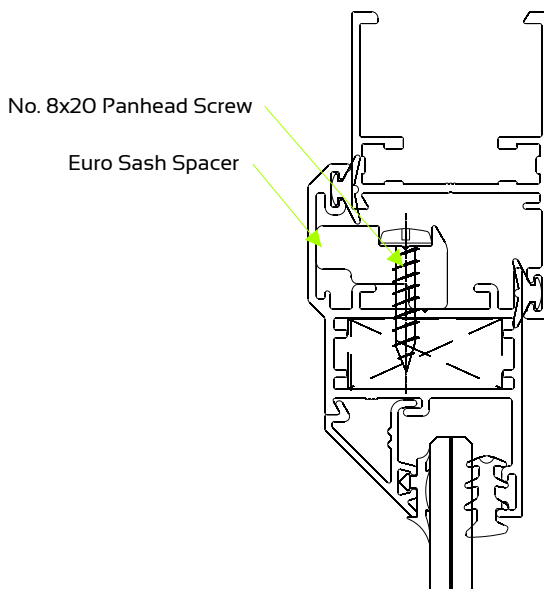
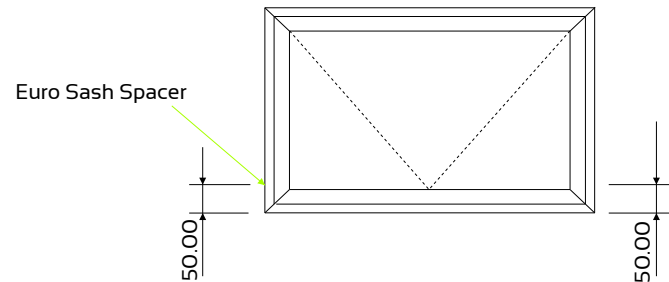






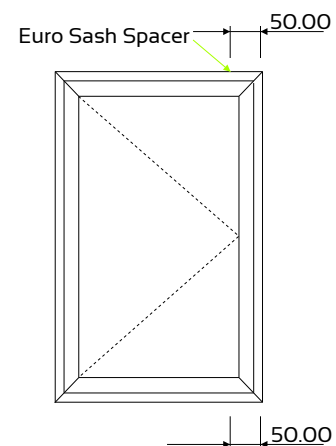
Note:

To assist the top hung sash in opening & closing squarely, a Euro sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.



Note:

To assist the top hung sash in opening & closing squarely, a Euro sash spacer needs to be fitted as shown on each side of the sash 50mm from the bottom edge.



Note:

For optimal performance against air & water infiltration, it is important to position friction stays as shown so that the sash fits almost right against the frame.

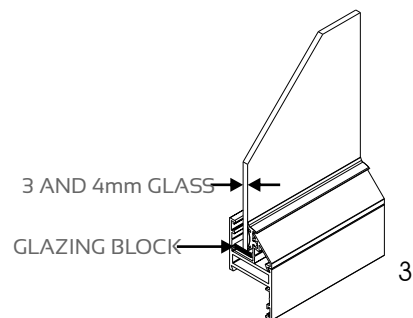
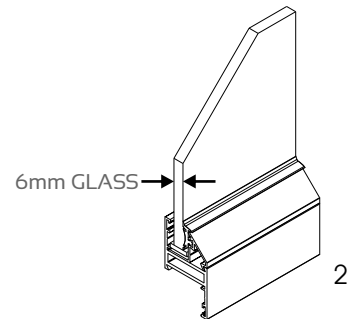
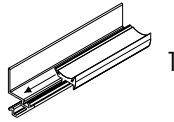
Insert the pull-in vinyl gasket into glazing beads by sliding or pressing it into the groove (1). Before cutting gasket, ensure that it has not stretched and cut 6mm longer so that corners are in compression at all times.

Position bottom glazing bead in glazing bead rebate (2).

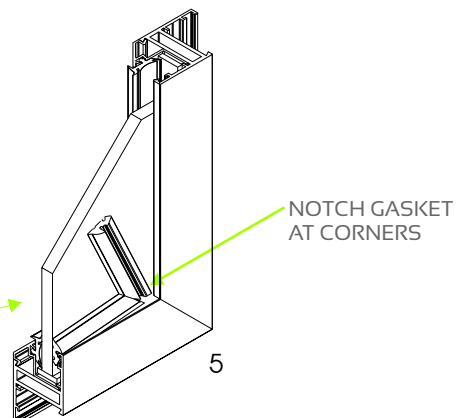
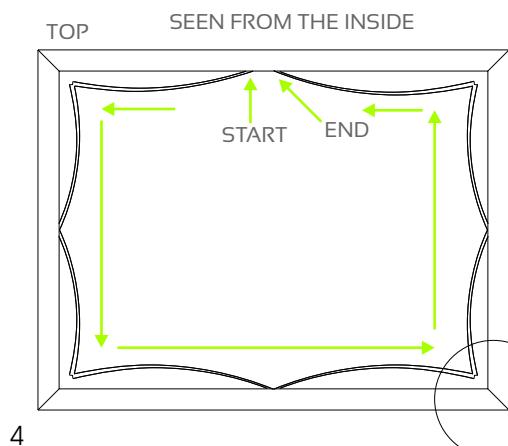
Place glass on glazing blocks (3).

Insert top and then side glazing beads ensuring that they are in correctly.

Starting from top centre, insert roll in gasket (4) without stretching it (5). Stop 150mm from corner and partly cut gasket 6mm longer than the edge of the vertical bead. Insert gasket at corner and then roll in remaining 150mm. Repeat this on the other sides. Where gasket ends meet, cut gasket 6mm longer. Insert cut ends first and complete.



ENSURE GASKETS ARE NOT STRETCHED AT ANY STAGE



GLAZING

1. SELECTION OF GLAZING METHODS

1.1 SETTING AND LOCATION BLOCKS

Glass-to-metal contact must be avoided at all times by using setting and location blocks having a hardness of 50° to 90° shore A durometer. Use only blocks made of Neoprene, EPDM, Silicone or other elastomeric material.

Setting blocks are to have a minimum thickness of 3mm and must be at least 27mm in length per square metre of glass area.

The position of the setting and location blocks is illustrated in Figure 2.

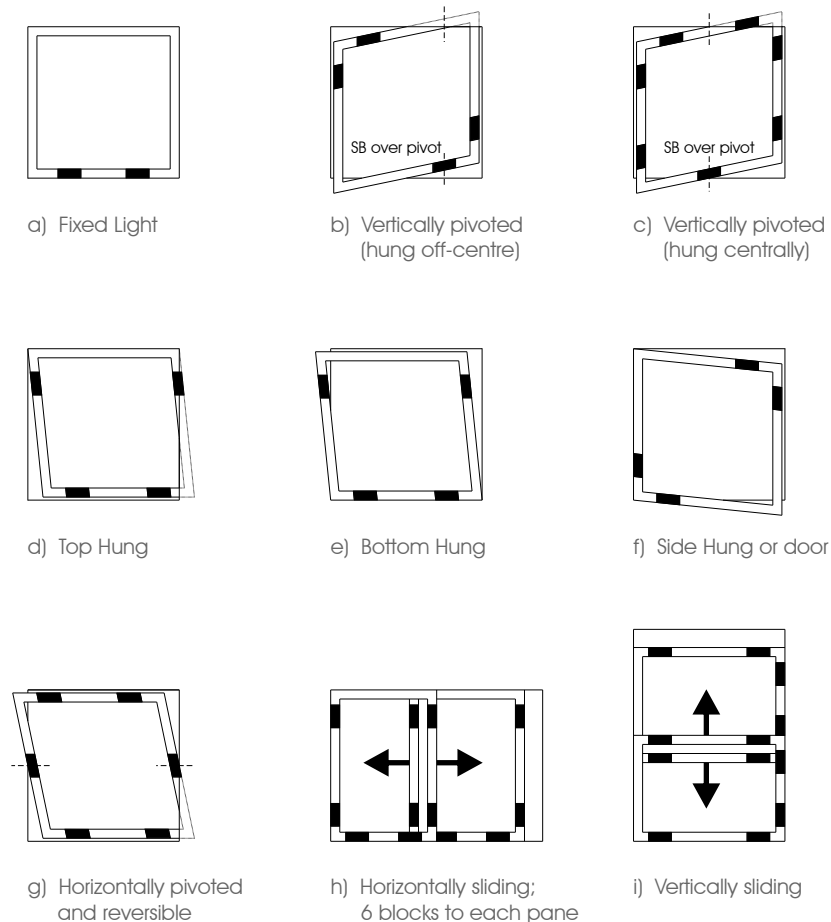


FIGURE 2 - POSITION OF SETTING AND LOCATION BLOCKS