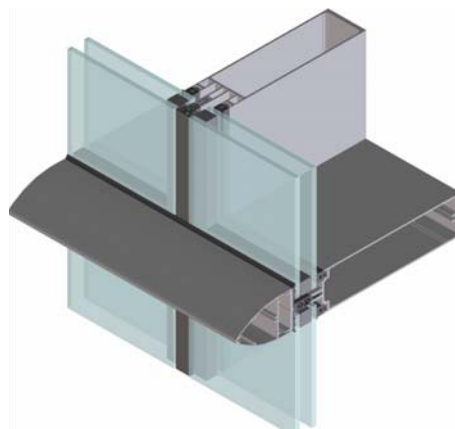
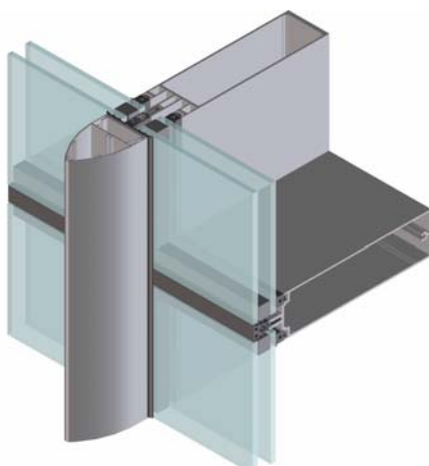


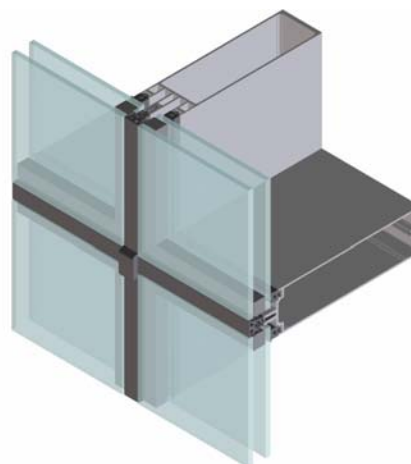
Capped



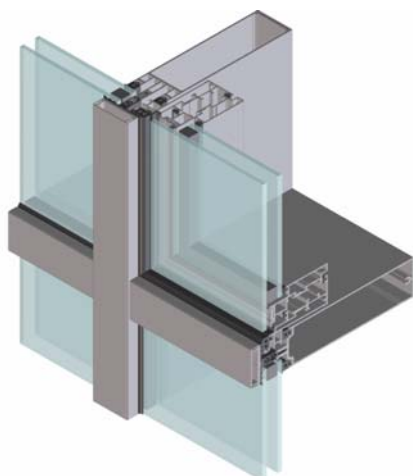
2sided SGH



2sided SGV



4sided SG



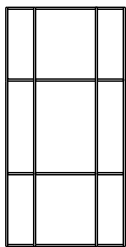
Concealed Vent

Fabrication

6

Comar 6EFT

Future additions



6.00

Fabricators Guide

FUTURE
ADDITION

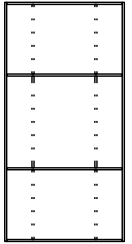
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Future additions

6

Fabrication

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6.01

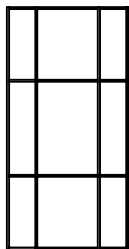
FUTURE
ADDITION

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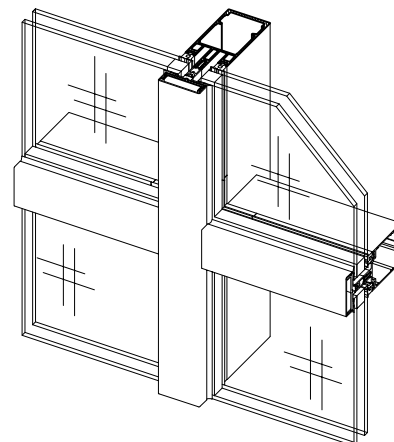
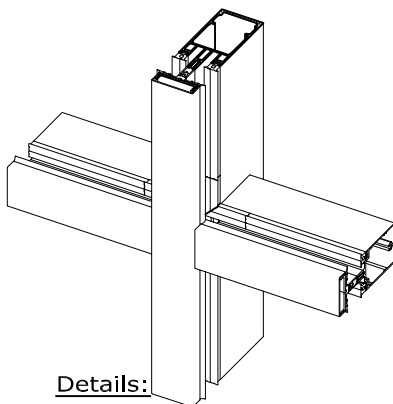
Issue: 04
Date :01-14

Comar 6EFT



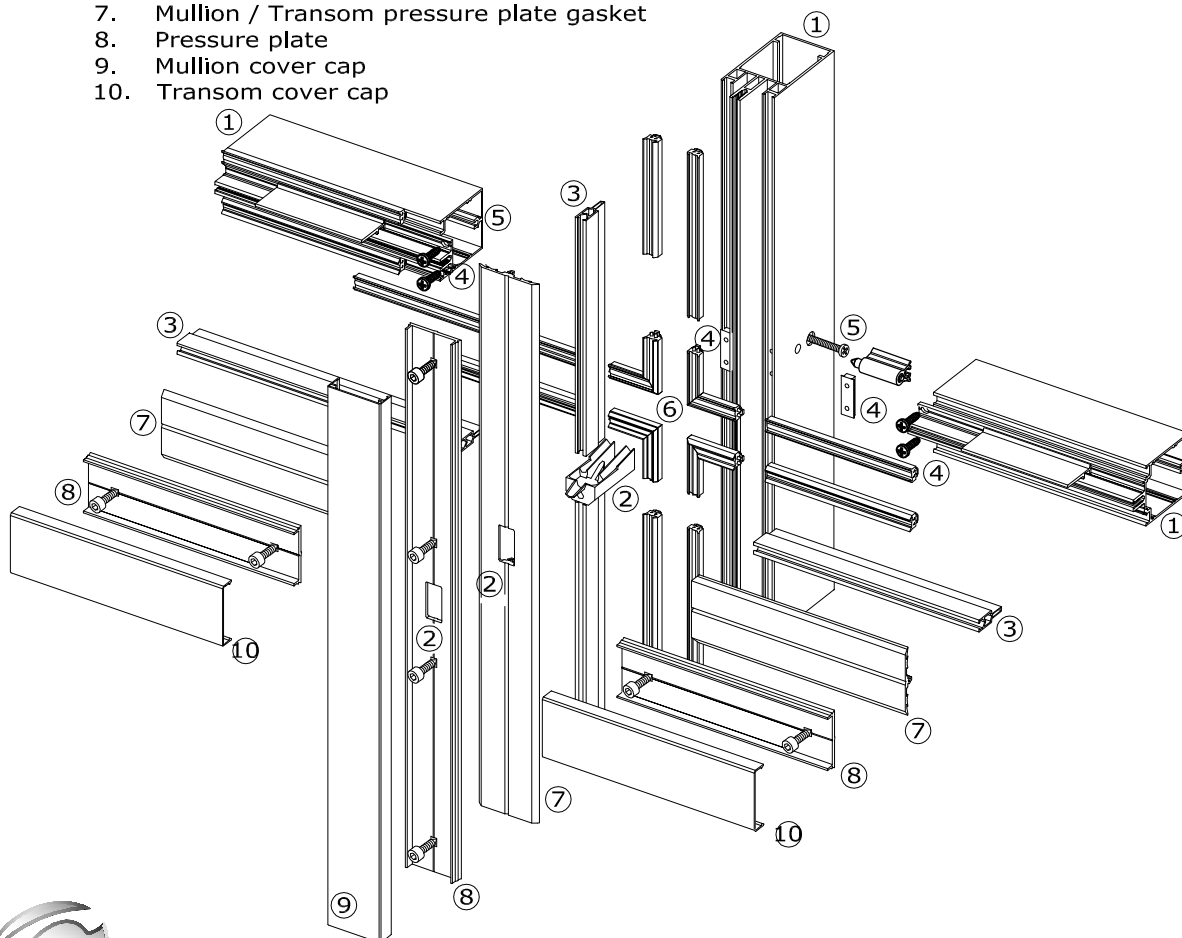
6.02

Exploded Typical Detail Fully Capped



Details:

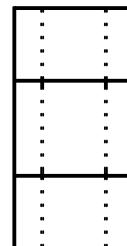
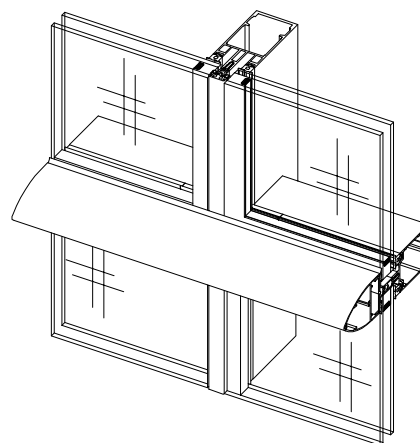
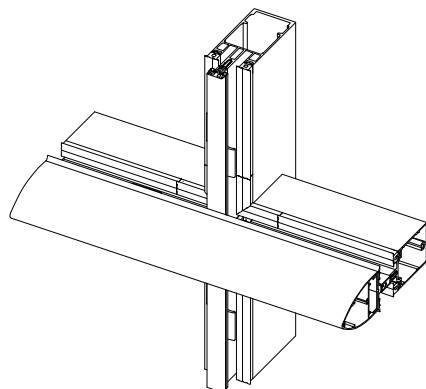
1. One substructure for all curtain wall types (Fully Capped / 2sided SGH / 2sided SGV / 4sided SG)
2. Controlled drainage system (mullion drained) - drainage diverter & cover
3. Thermal break
4. Mullion-Transom step-cut & sealed by EPDM moulding
5. Ladder (unit) construction or stick build
6. Moulded EPDM corners available
7. Mullion / Transom pressure plate gasket
8. Pressure plate
9. Mullion cover cap
10. Transom cover cap



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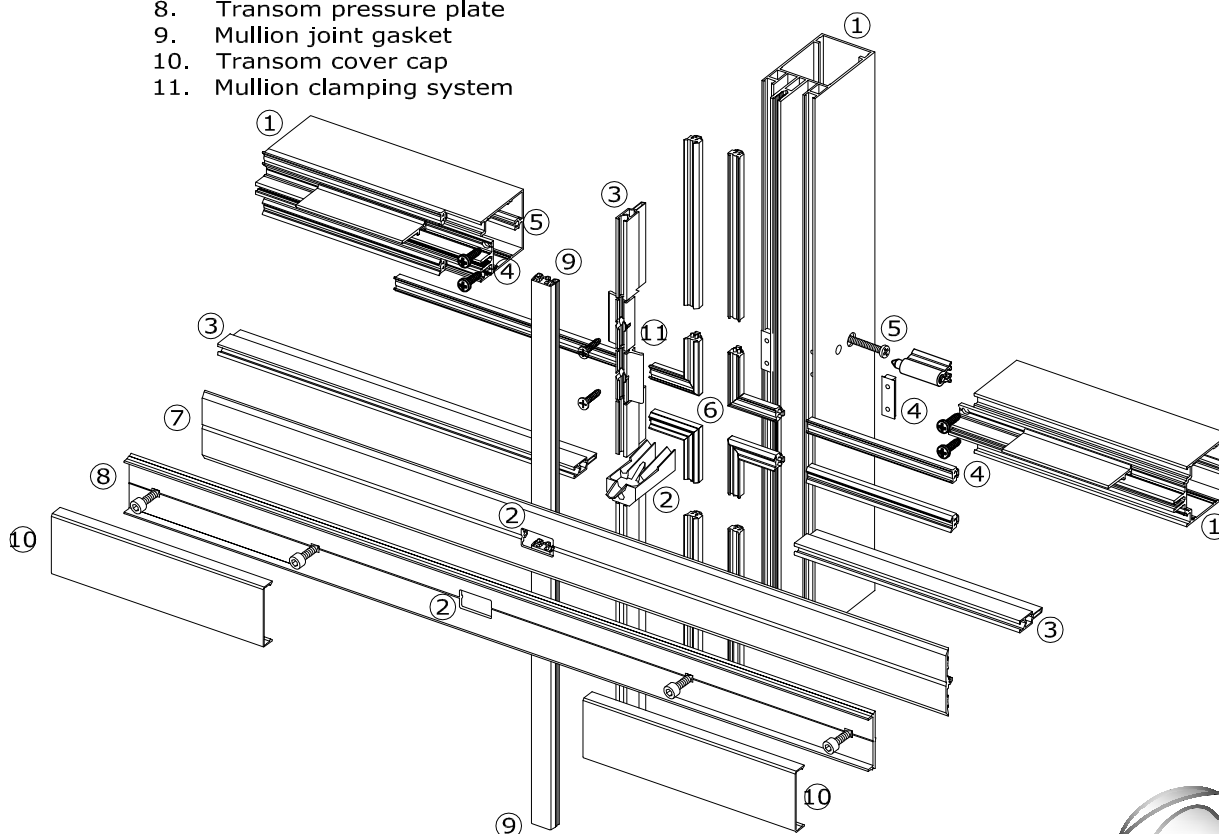
Exploded typical details Horizontal cover cap (2sided SGH)



6.03

Details:

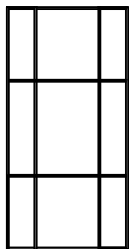
1. One substructure for all curtain wall types (Fully Capped / 2sided SGH / 2sided SGV / 4sided SG)
2. Controlled drainage system (mullion drained) - drainage diverter & cover
3. Thermal break
4. Mullion-Transom step-cut & sealed by EPDM moulding.
5. Ladder (unit) construction or stick build
6. Moulded EPDM corners available
7. Transom pressure plate gasket
8. Transom pressure plate
9. Mullion joint gasket
10. Transom cover cap
11. Mullion clamping system



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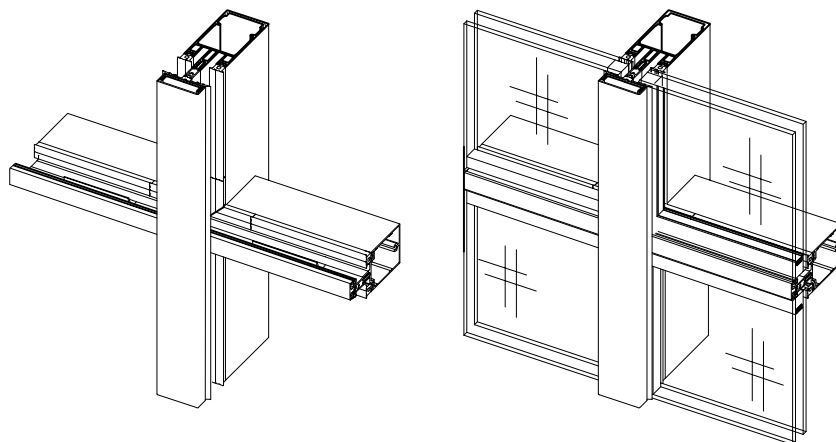
Issue: 04
Date :08-15

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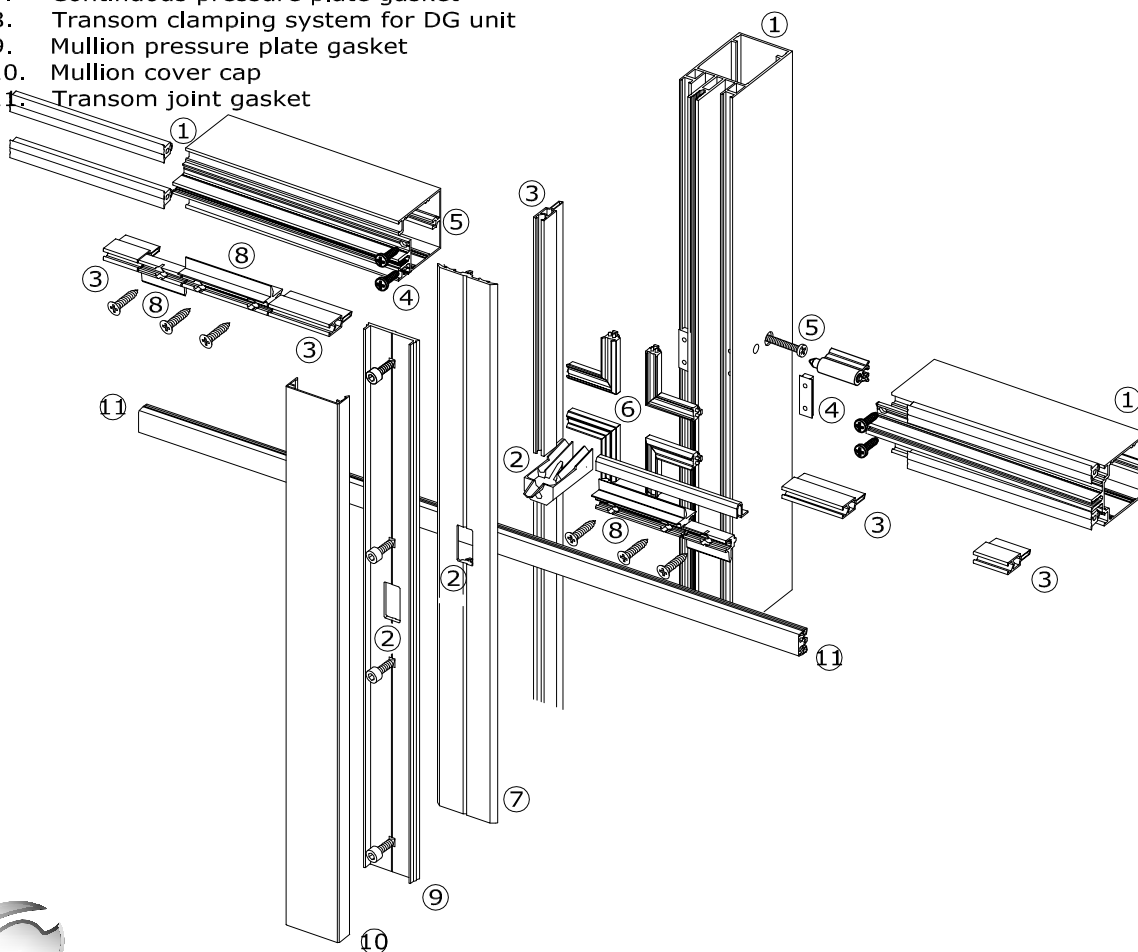
6.04

Exploded Typical Detail Vertical cover cap (2sided SGV)



Details:

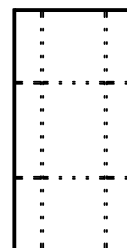
1. One substructure for all curtain wall types,
(Fully Capped, 2sided SGH, 2sided SGV & 4sided SG)
2. Controlled drainage system (mullion drained) drainage diverter & cover
3. Thermal Break
4. Mullion-Transom step-cut & sealed by EPDM moulding
5. Ladder (unit) construction or stick build
6. Moulded EPDM corners available
7. Continuous pressure plate gasket
8. Transom clamping system for DG unit
9. Mullion pressure plate gasket
10. Mullion cover cap
11. Transom joint gasket



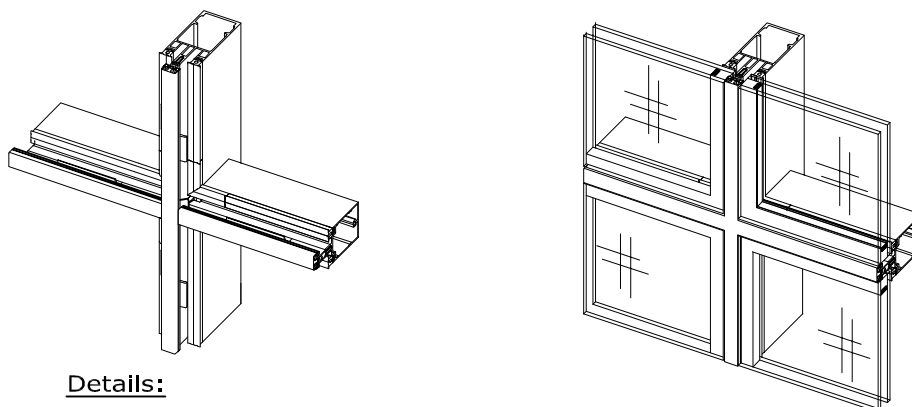
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Exploded typical details Four sided structural EFT (4sided SG)

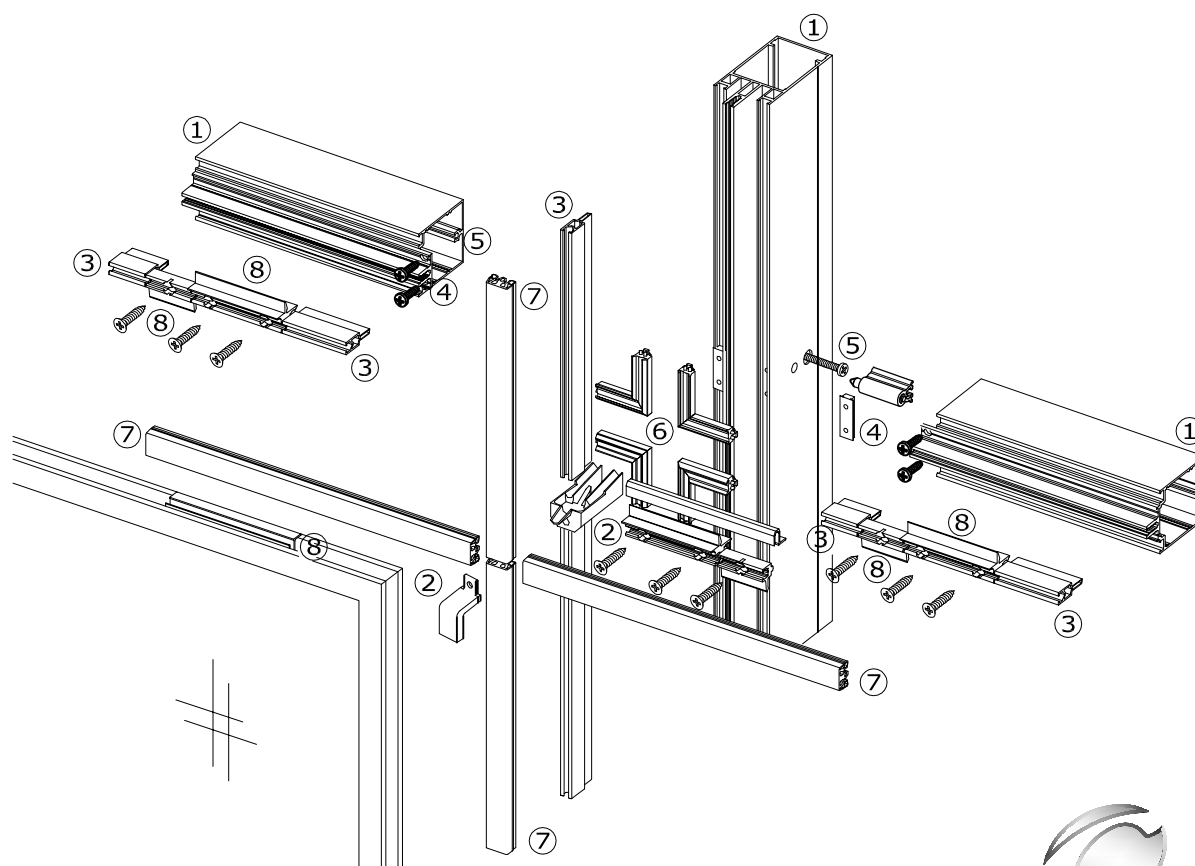


6.05



Details:

1. One substructure for all curtain wall types, Fully Capped, 2sided SGH, 2sided SGV & 4sided SG
2. Controlled drainage system (mullion drained) drainage diverter & cover
3. Thermal break
4. Mullion-Transom step-cut & sealed by EPDM moulding
5. Ladder (unit) construction or stick build
6. Moulded EPDM corners available
7. Mullion / Transom joint gasket
8. Glazing clamping system for DG unit



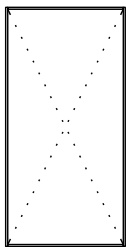
Profiles Identification

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Issue:04
Date :08-15

Comar 6EFT

Mullion - Transom connection (Option 1)



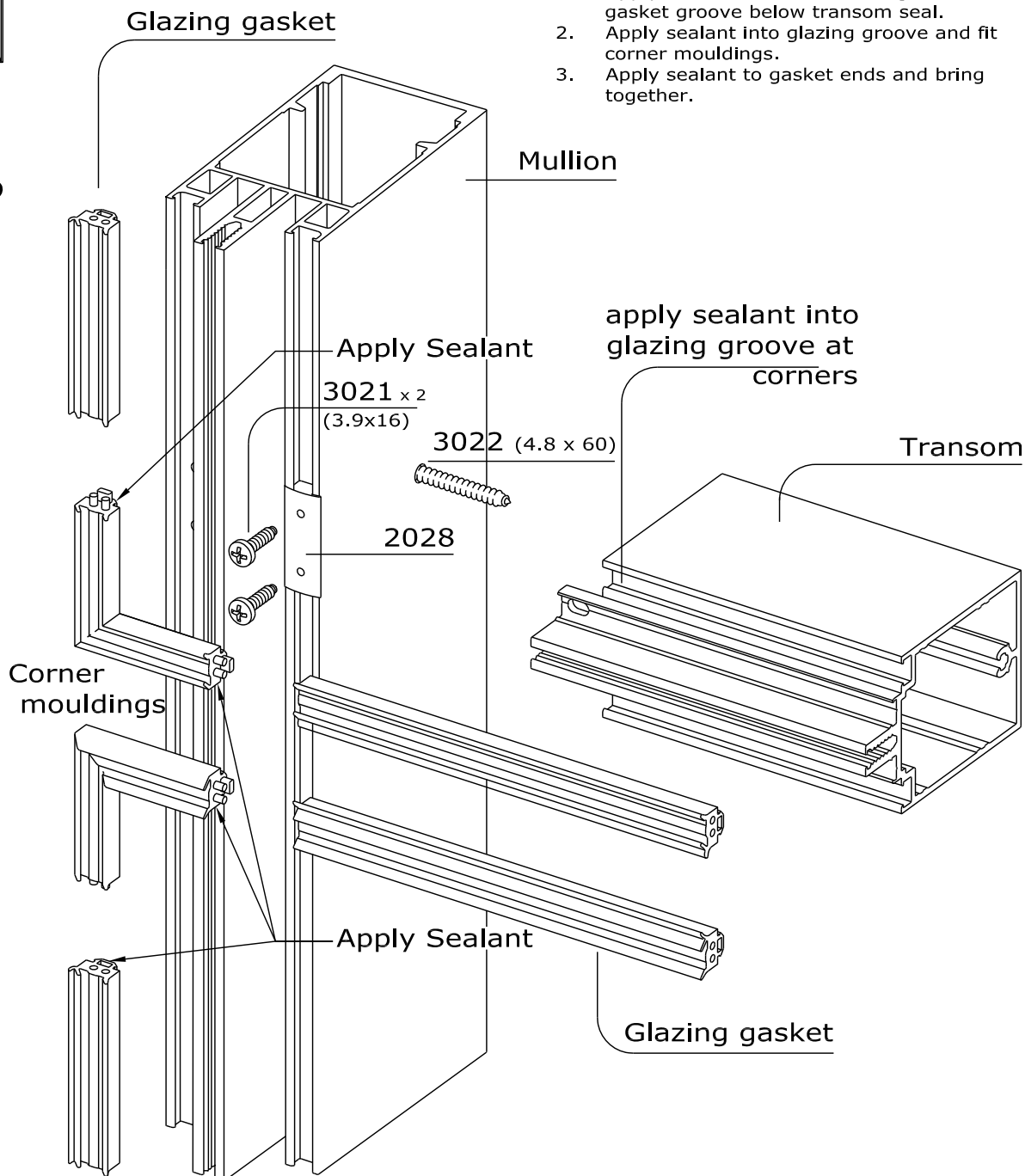
Notes:

1. Apply sealant to transom fixing screws and gasket groove below transom seal.
2. Apply sealant into glazing groove and fit corner mouldings.
3. Apply sealant to gasket ends and bring together.

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6.06

Fabrications Guide



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Issue: 04
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Mullion - Transom connection (Option 2)

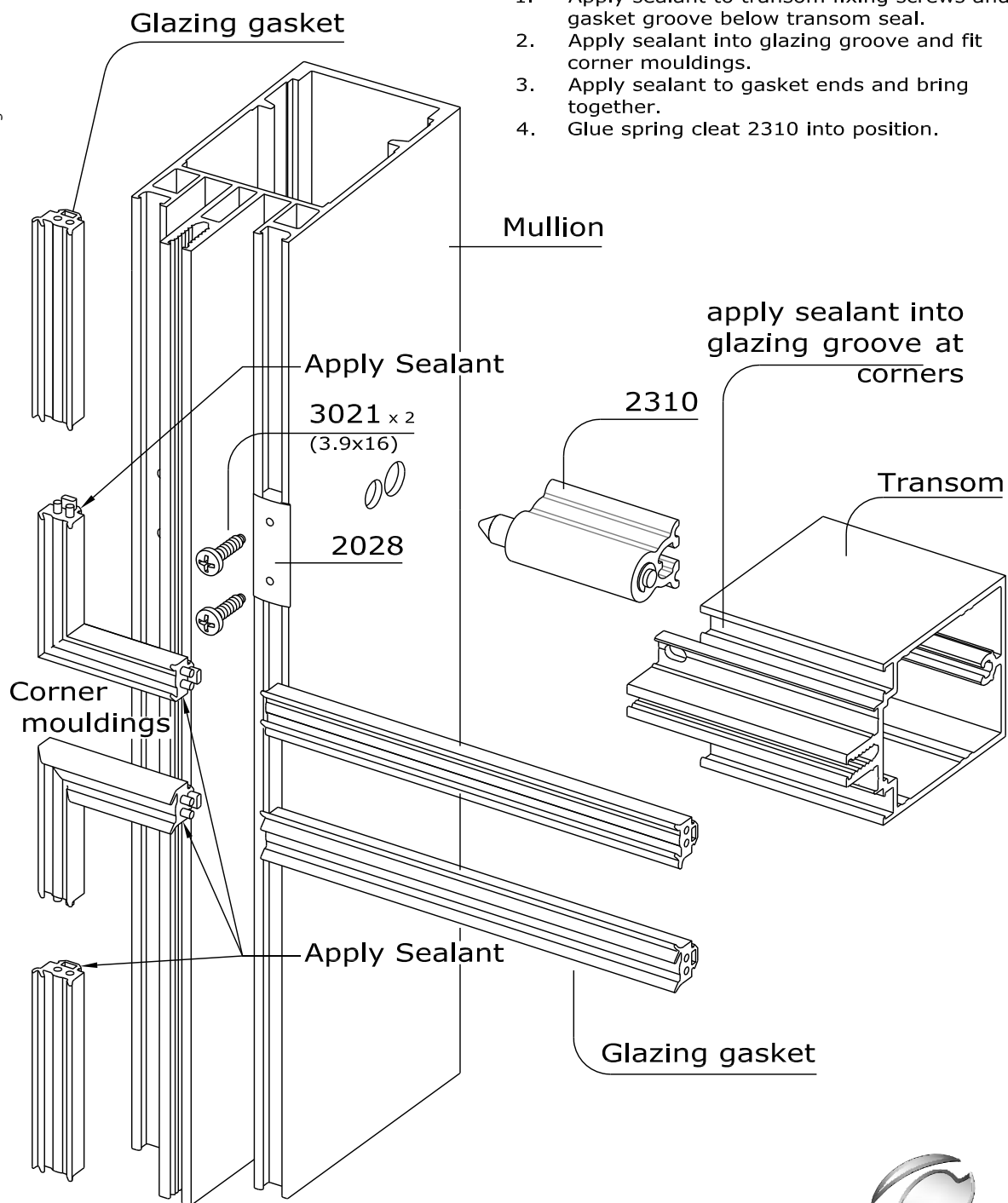
(with spring loaded transom cleat)



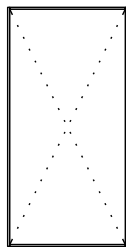
Notes:

1. Apply sealant to transom fixing screws and gasket groove below transom seal.
2. Apply sealant into glazing groove and fit corner mouldings.
3. Apply sealant to gasket ends and bring together.
4. Glue spring cleat 2310 into position.

6.07



Comar 6EFT



Mullion - Transom Connection (Option 3)

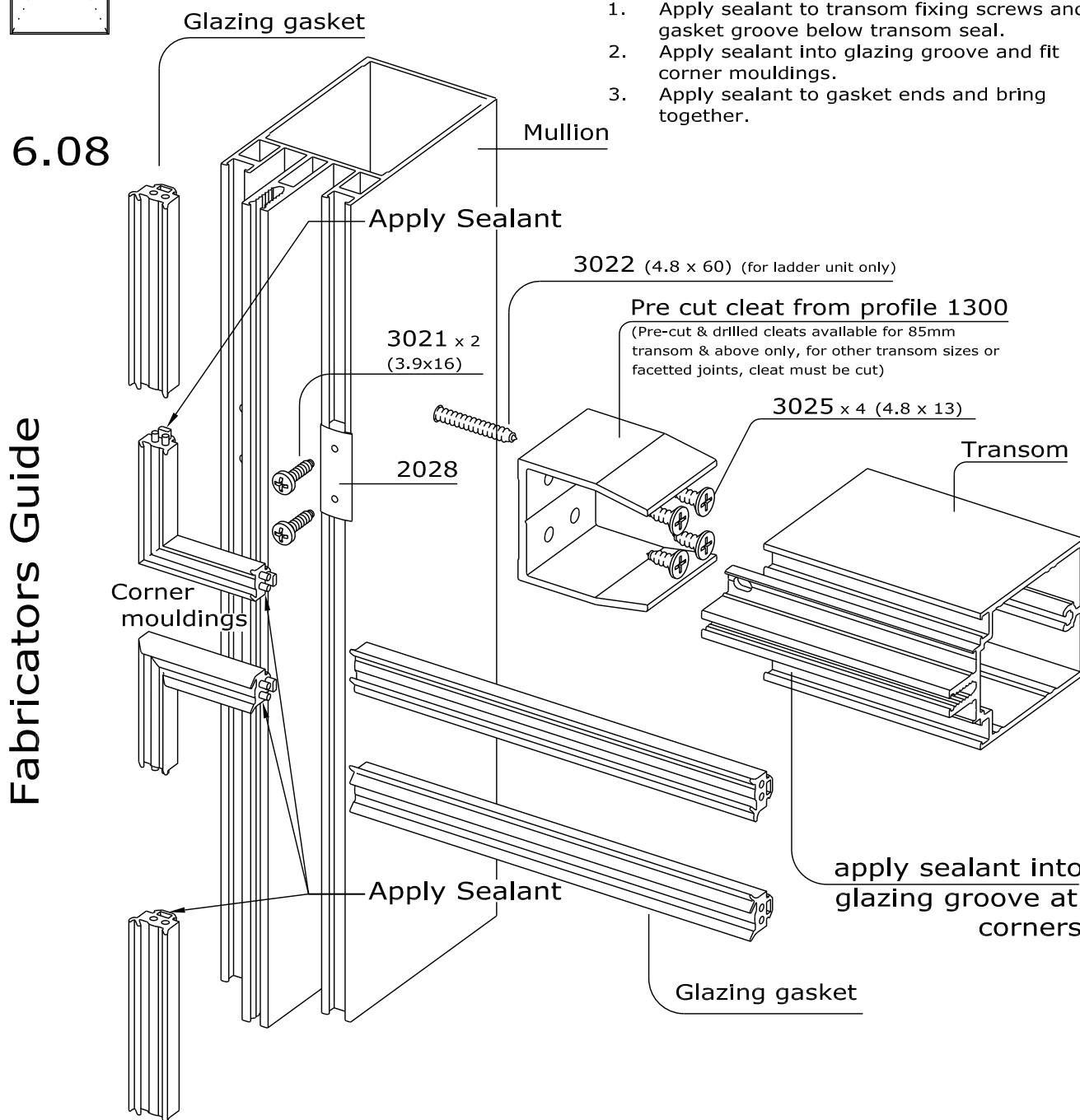
(for making ladder units)

(for transoms installed between mullions or ladders)

Notes:

1. Apply sealant to transom fixing screws and gasket groove below transom seal.
2. Apply sealant into glazing groove and fit corner mouldings.
3. Apply sealant to gasket ends and bring together.

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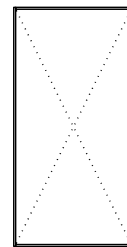
Issue: 04
Date : 01-14

Mullion - Transom Connection (Option 4)

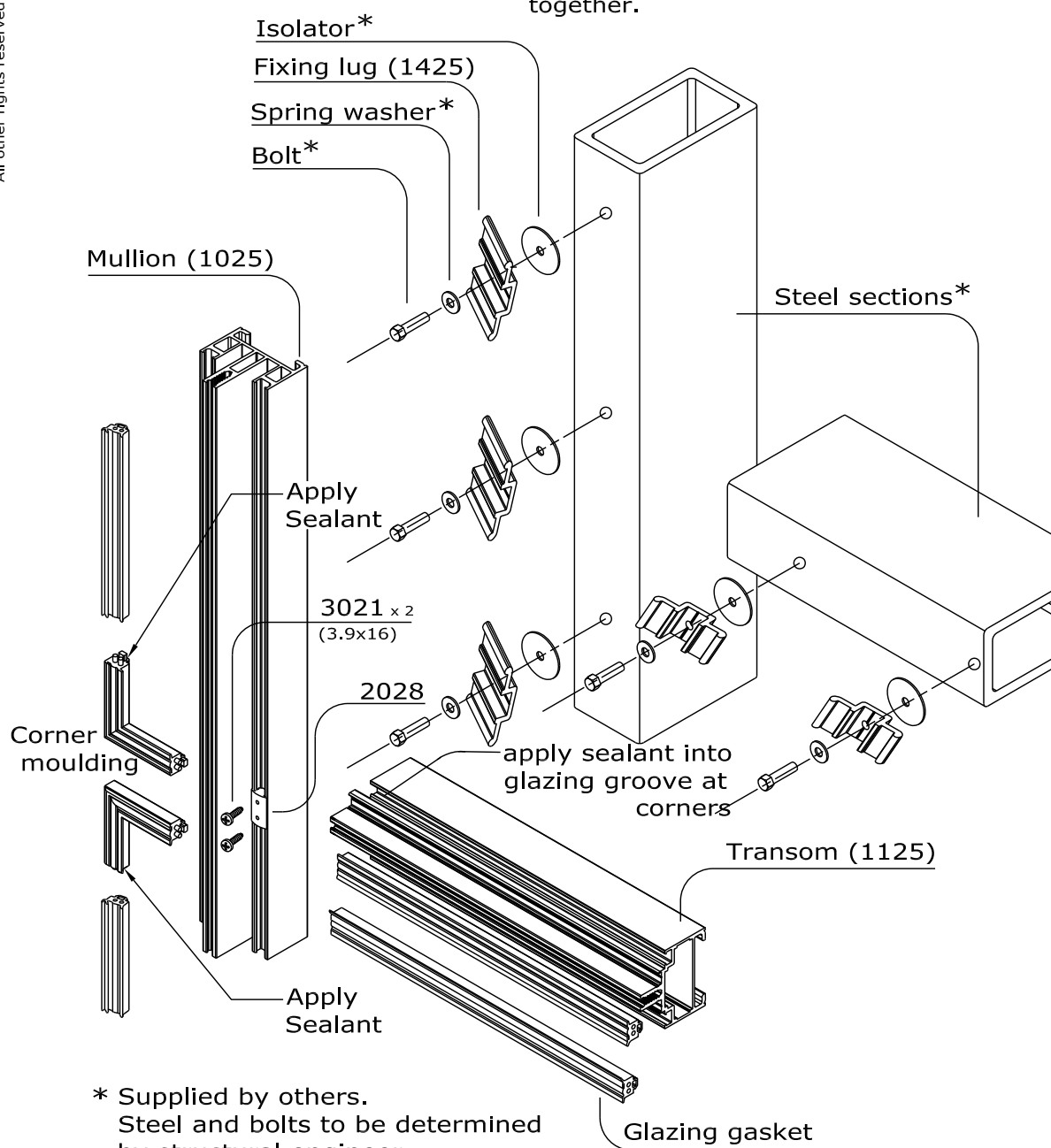
(Direct fix to steel or timber)

Notes:

1. Apply sealant to transom fixing screws and gasket groove below transom seal.
2. Apply sealant into glazing groove and fit corner mouldings.
3. Apply sealant to gasket ends and bring together.



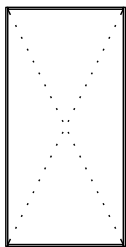
6.09



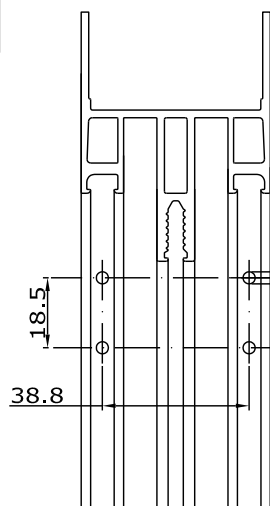
Fabrication

6

Comar 6EFT

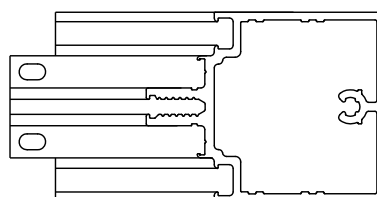
Mullion - Transom
Connection

6.10

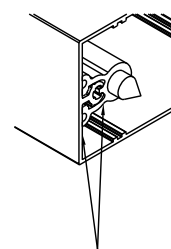
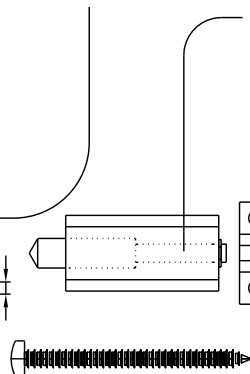
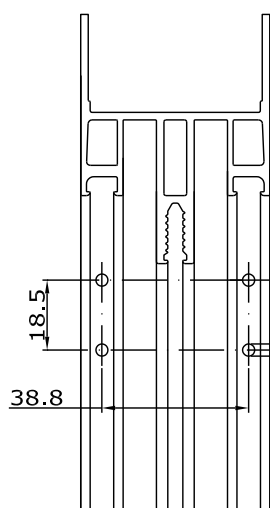
**Option 1** (for 45mm Transoms only)

Fixed with 2 screws EFT 3021 (3.9x16)

Glass weight: max. 100 kg

**Option 2** (for 60mm or deeper Transoms)Fixed with 2 screws EFT 3021 (3.9x16) +
Transom spigot EFT 2310 or
Ladder screw 3022 (4.8x60)

Glass weight: max. 150 kg

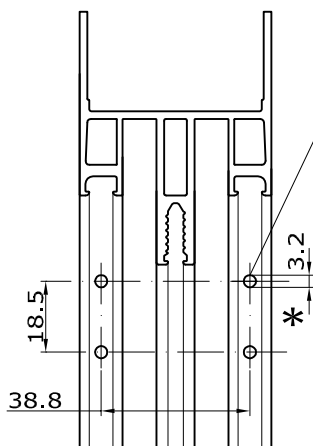
Transom cleat
2310 body to be
positioned flush
to prepared
edge of transom
and super glued

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ARCHITECTURAL ALUMINIUM SYSTEMS

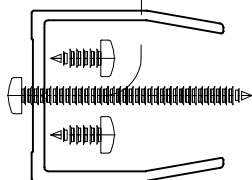
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Mullion - Transom Connection



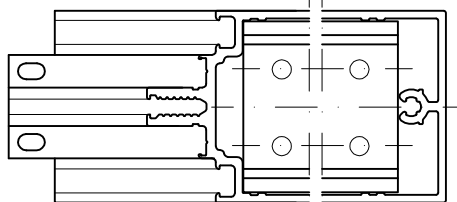
Option: 3

Fixed with 2 screws EFT 3021 (3.9x16) +
Transom cleat - refer to drawing 6.25 for cleat sizes
Ladder screw 3022 (4.8 x 60)



Glass weight: max. 250 kg

4 screws 3025 (4.8x13)



*
For ladder unit only, 3022 (4.8 x 60)

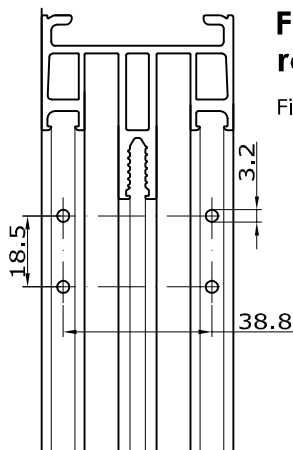
6.11

Option: 4

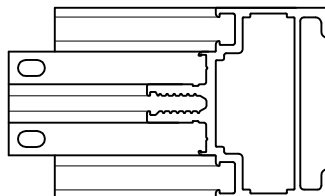
Direct fix to steel or timber

**For direct fix to steel or timber details
refer to drawing 6.09**

Fixed with 2 screws EFT 3021 (3.9x16)



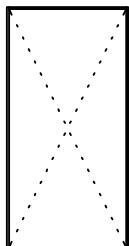
Glass weight: max. 250kg



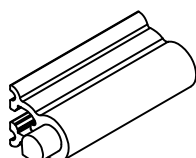
Comar 6EFT

Mullion preparation

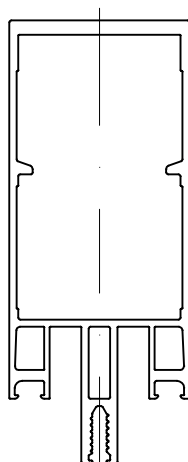
For loads up to max. 150kg



Transoms installed
in between ladders



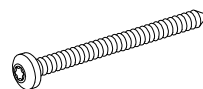
EFT 2310



For mullions over 150mm
extended bars are required

Refer to page 6.13

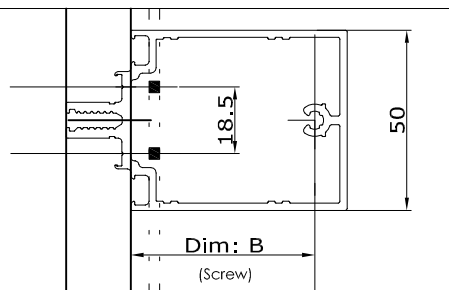
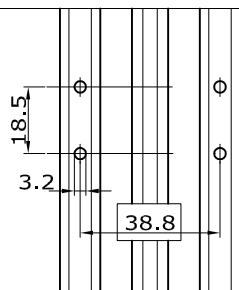
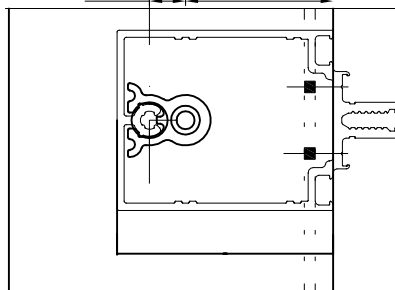
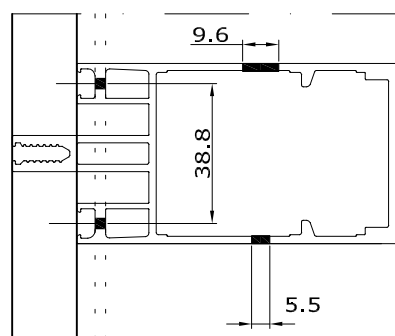
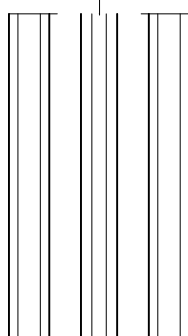
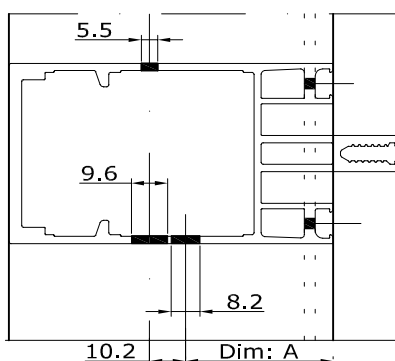
Ladder / unit



3022 (4.8 x 65)

6.12

Fabricators Guide



Transom no:	Dim: A
EFT 1150 60 mm	40.2
EFT 1151 85 mm	65.2
EFT 1143 85 mm	65.2
EFT 1164 105 mm	85.0
EFT 1144 115 mm	95.0
EFT 1152 135 mm	115.0
EFT 1145 150 mm	130.0
EFT 1154 150 mm	130.0
EFT 1147 175 mm	155.0
EFT 1156 180 mm	160.0
EFT 1157 195 mm	175.0
EFT 1148 200 mm	180.0
EFT 1158 210 mm	190.0

Note: For split mullions,
a transom cleat must be
used.

Refer to pages 6.25 & 7.33

USE TOOL JIG:
Com6-EFT-Jig 1
Refer to page 6.13

Transom no:	Dim: B
EFT 1150 60 mm	50.4
EFT 1151 85 mm	75.4
EFT 1143 85 mm	75.4
EFT 1164 105 mm	95.2
EFT 1144 115 mm	105.2
EFT 1152 135 mm	125.2
EFT 1145 150 mm	140.2
EFT 1154 150 mm	140.2
EFT 1147 175 mm	165.2
EFT 1156 180 mm	170.2
EFT 1157 195 mm	185.2
EFT 1148 200 mm	190.2
EFT 1158 210 mm	200.2

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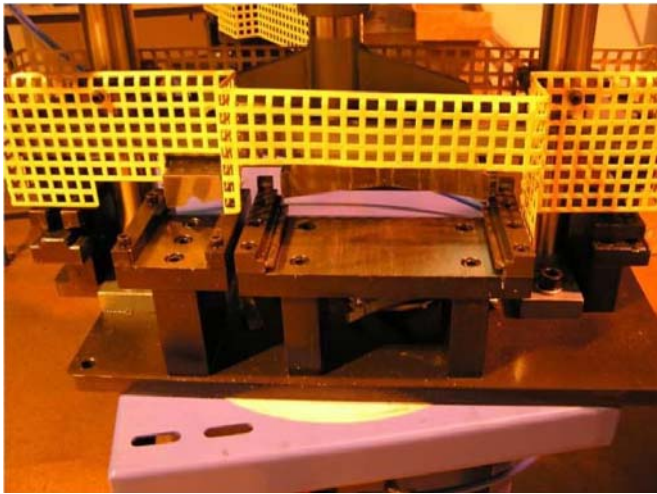
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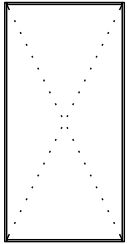
Issue: 04
Date : 12-15

Tooling

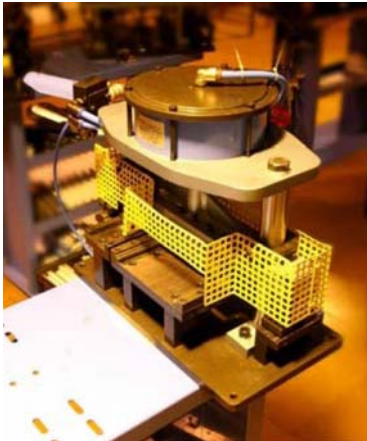


Preparations:
As per drawing 6.14

transom end notch

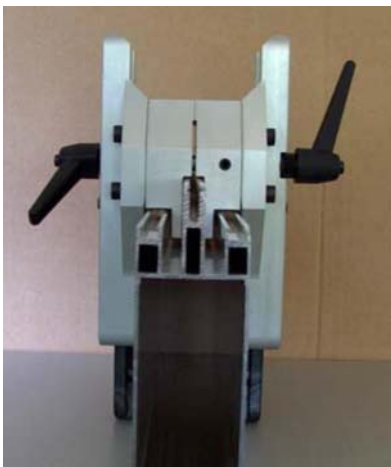


6.13



Tool: Pneumatic punch tool Com6-EFT-T13

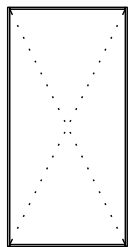
Mullion - Transom connection



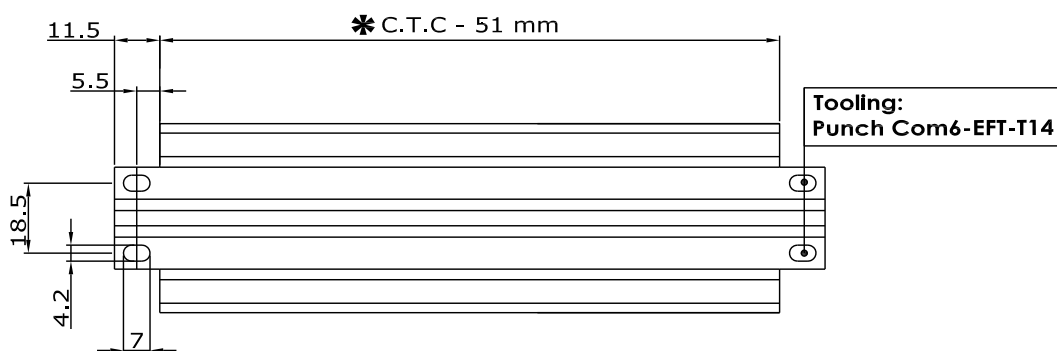
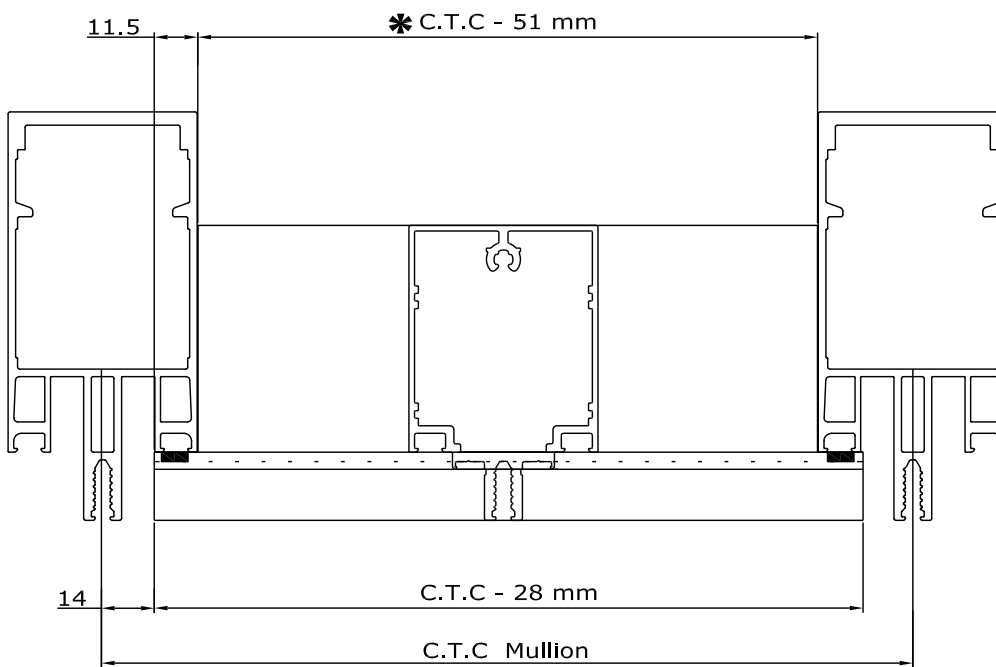
Tool: Com6-EFT-Jig 1

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Date :01-14



6.14



* For pre-fabricated units use C.T.C-50mm (ladders)

* For faceted transom preparation please contact Comar's technical department.



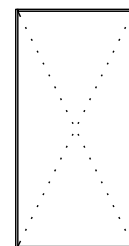
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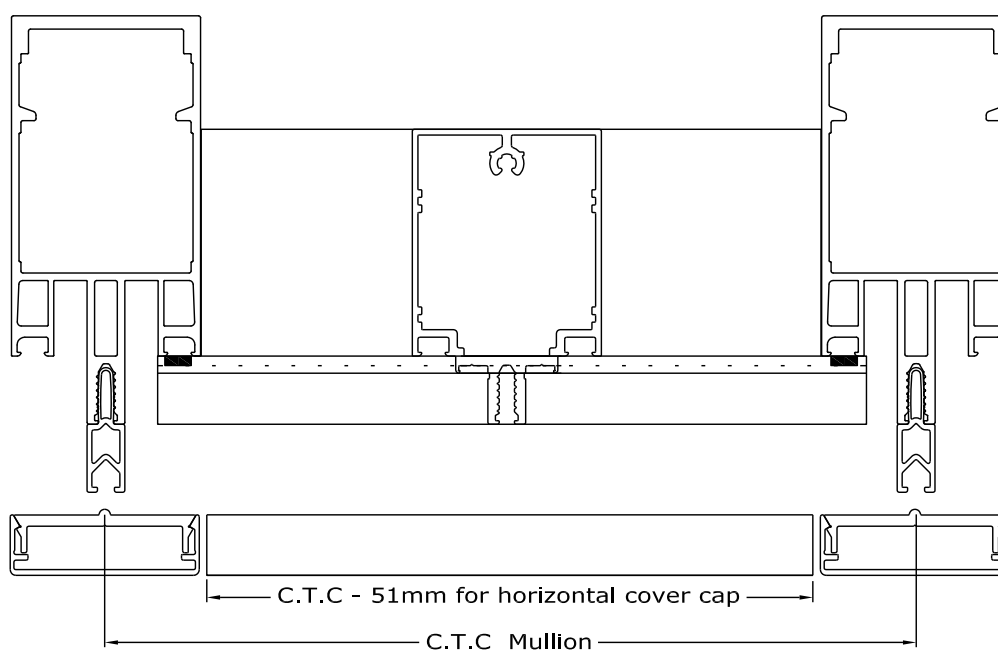
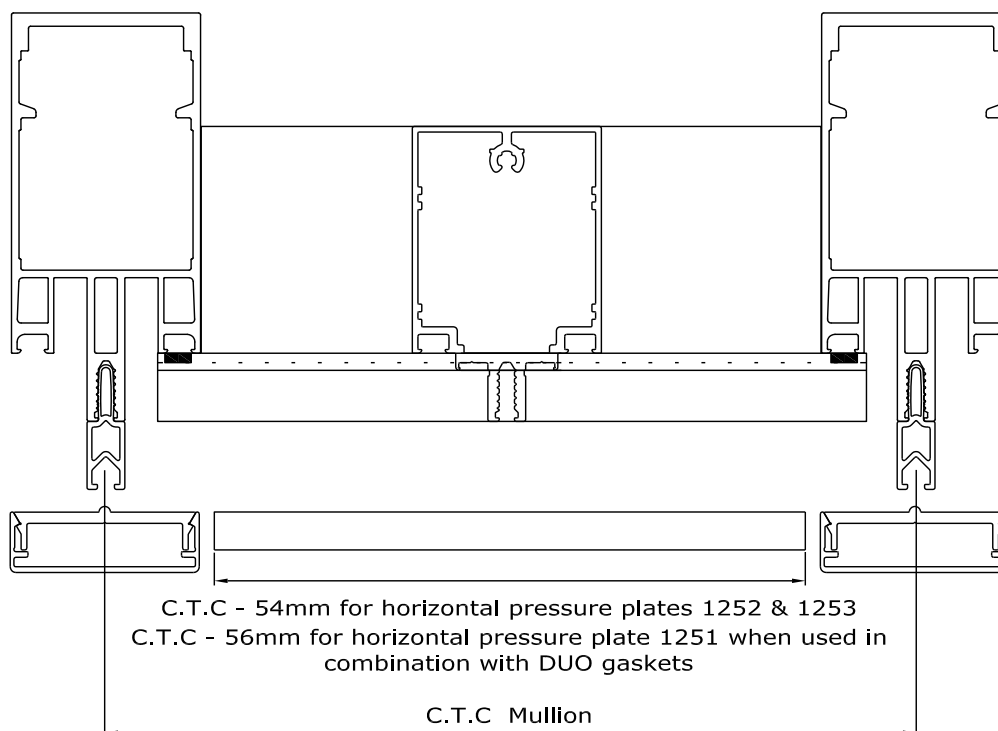
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Horizontal pressure plate & horizontal cover cap preparation



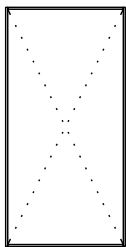
6.15



Fabrication

6

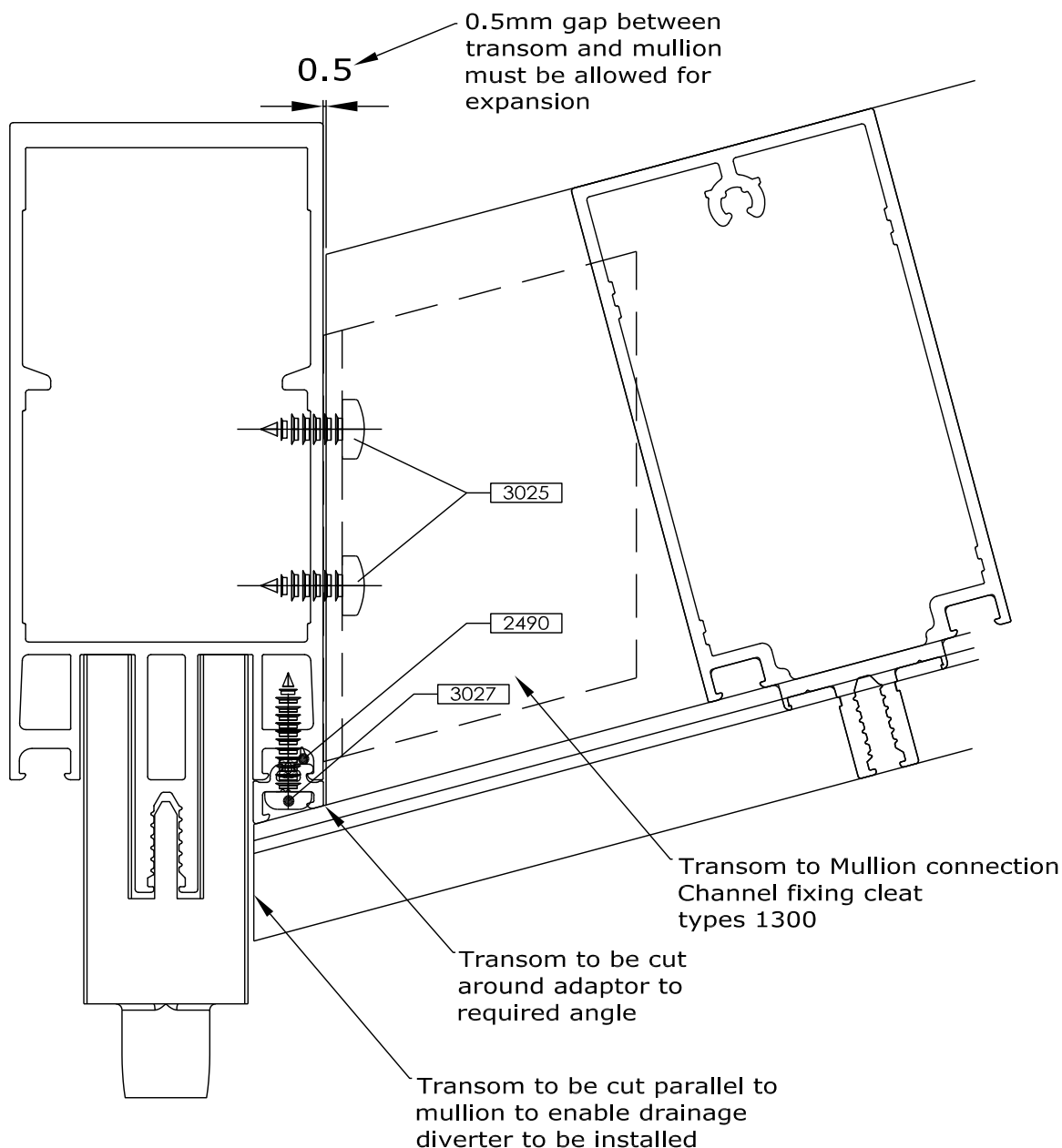
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Facetted transom preparation
Inward angles 'acute angle'

6.16

Fabricators Guide



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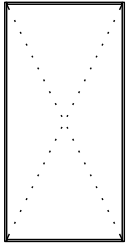
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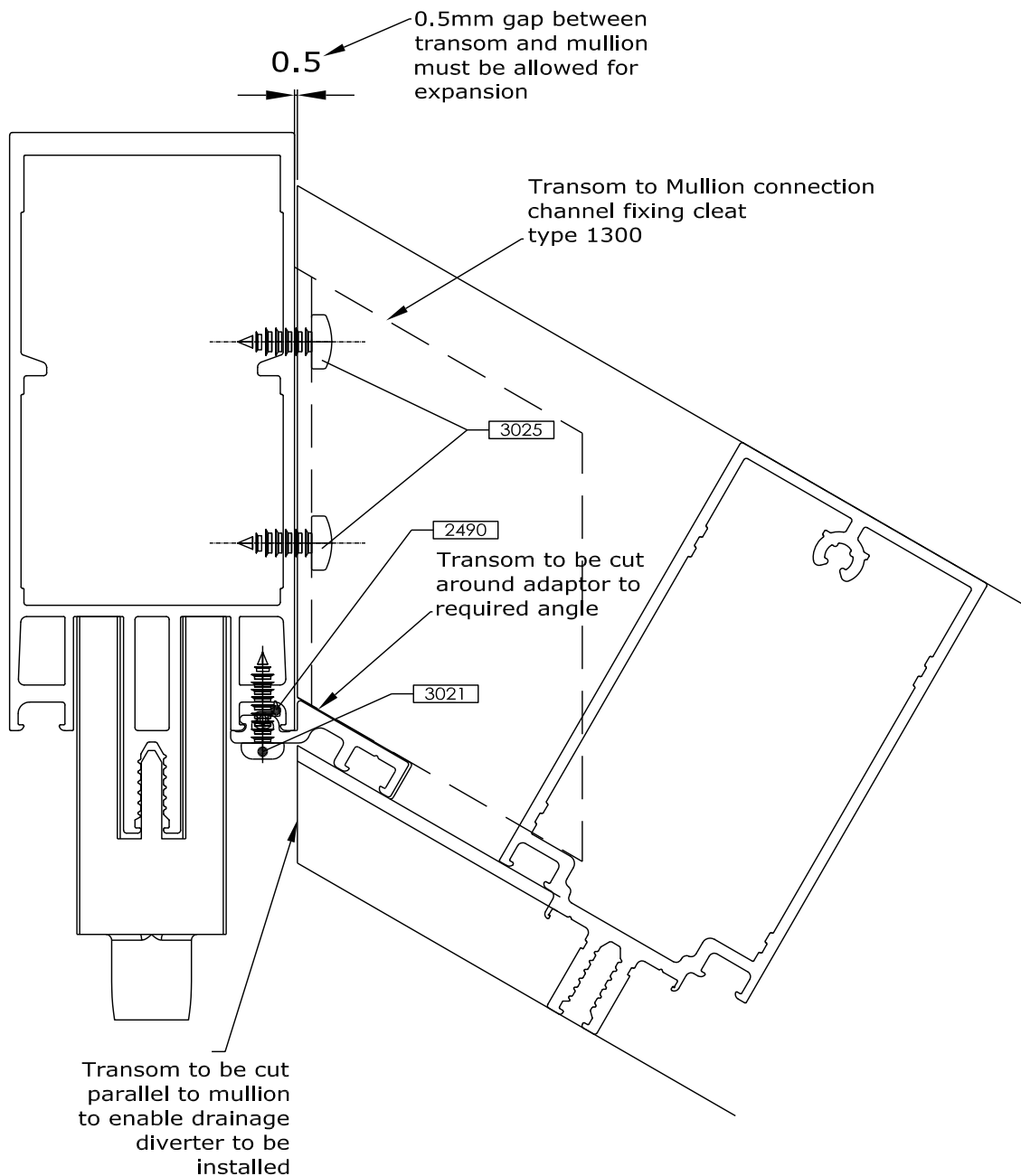
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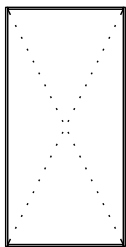
Facetted transom preparation Outward angles 'reflex angle'



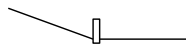
6.17



Comar 6EFT

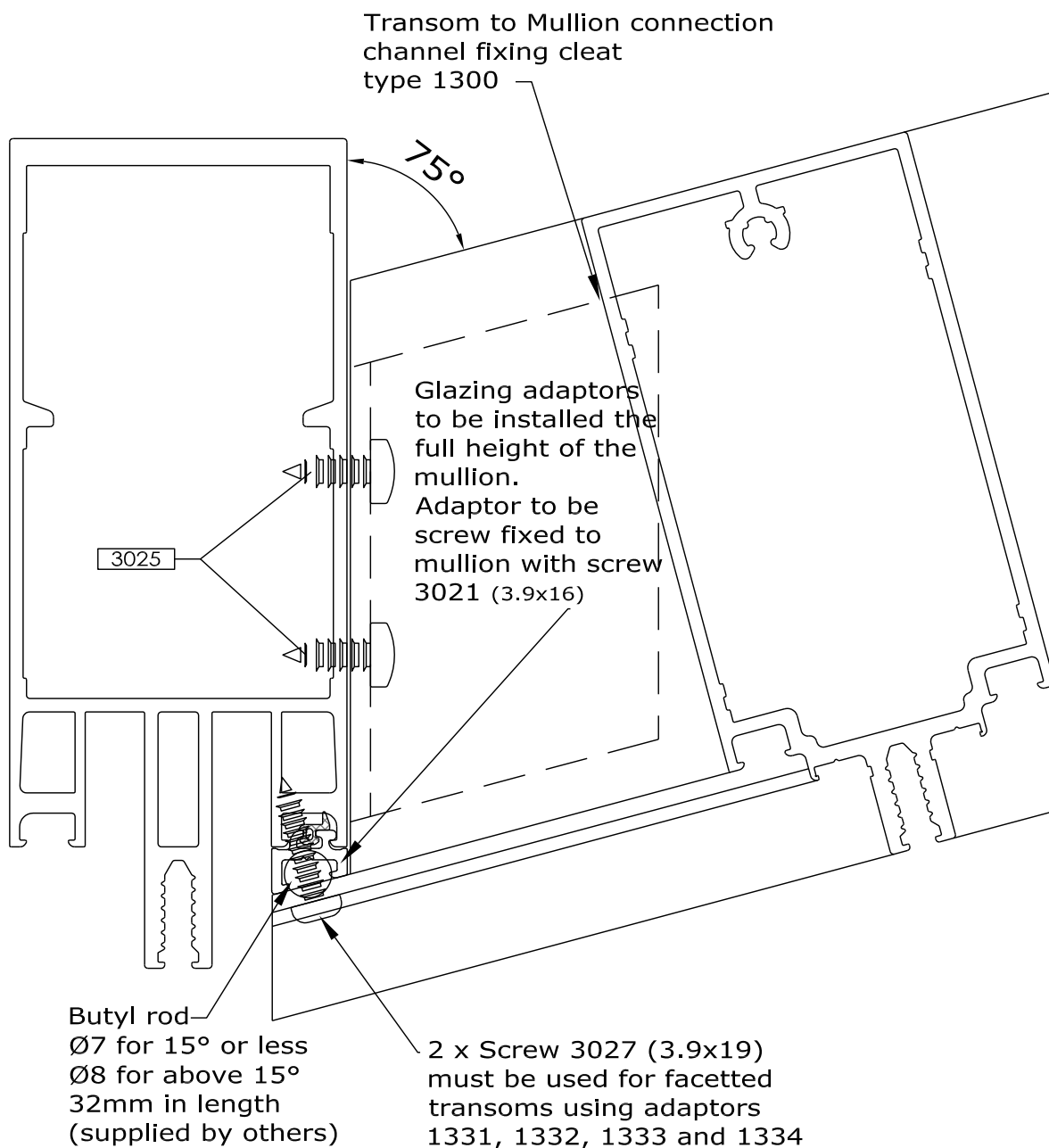


**Fixing faceted transoms
Inward angles
'acute angle'**



6.18

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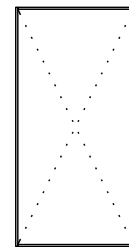
comar

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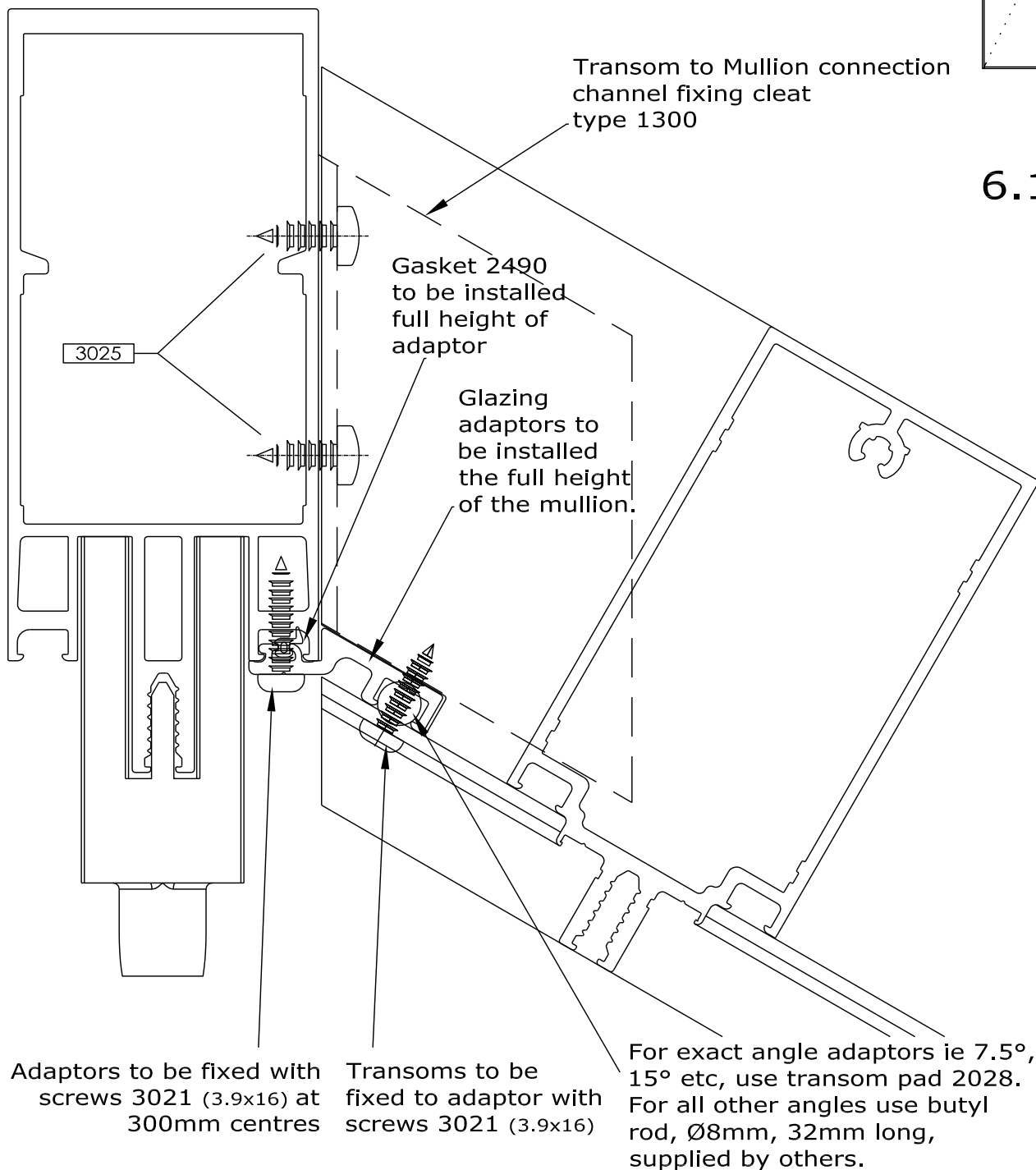
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Fixing faceted transoms Outward angles 'reflex angle'



6.19



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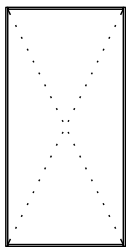
Issue: 04
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Fabrication

6

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Facetted transom cleat preparation

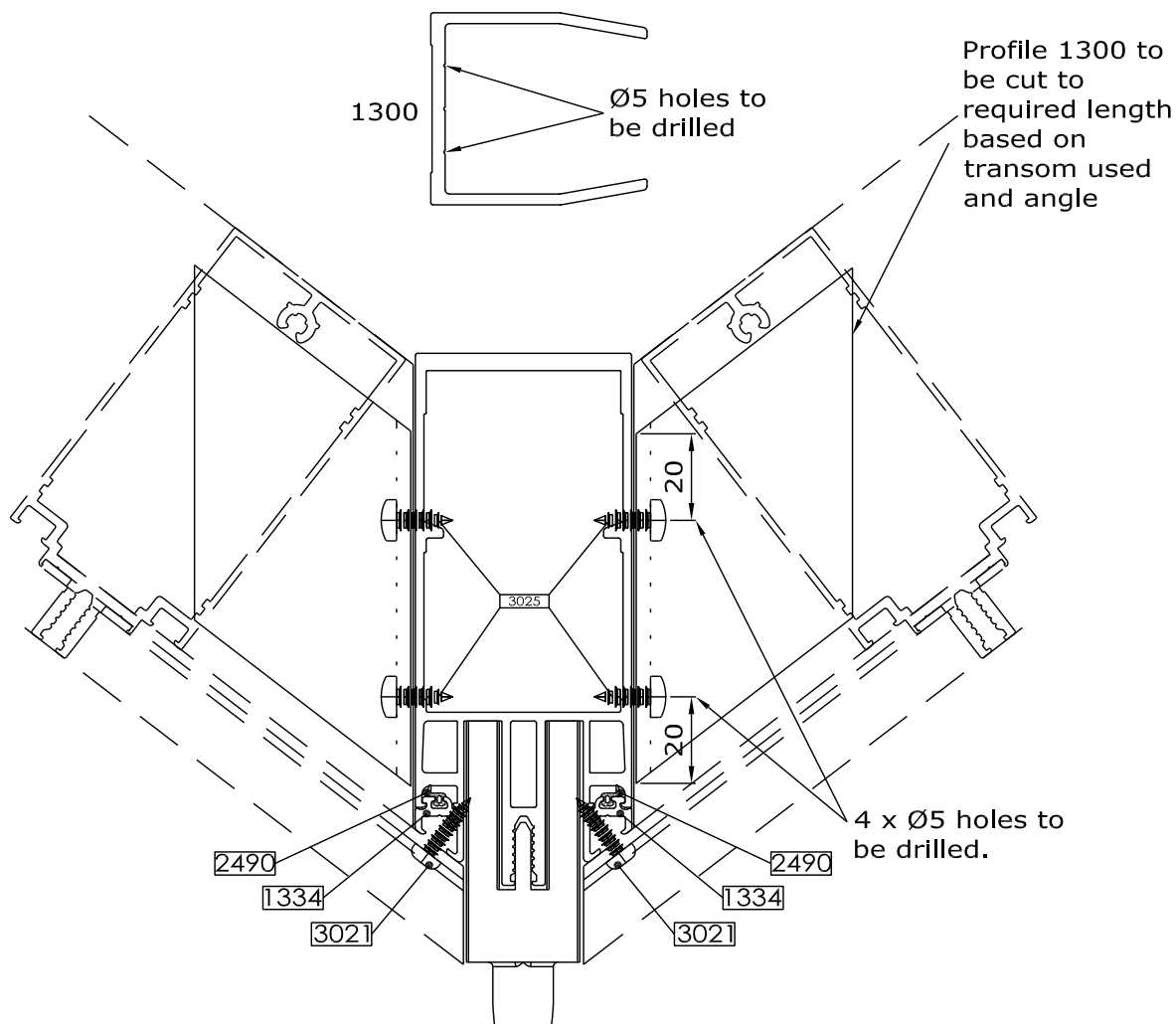


Any facetted transom must be held in place by cleats made from profile 1300 (or 1305 if specified)

6.20

Same cleat preparation can be used for outward (reflex) angles.

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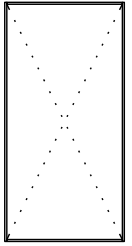
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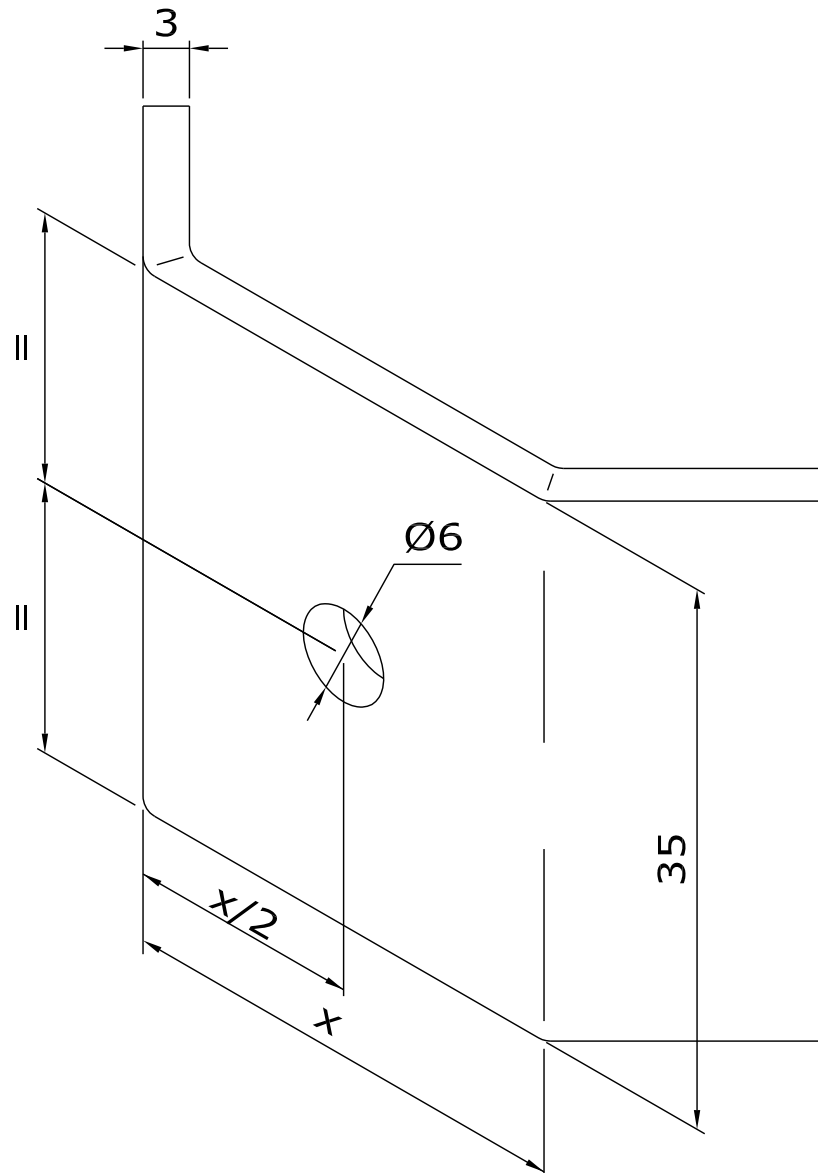
Fabrication

Facetted clamp information

Comar 6EFT



6.21



Facetted clamps to be made to required angle.

Material : Stainless steel

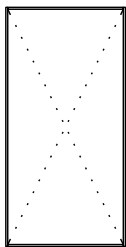
Clamps to be screwed to mullion with suitable length screw.
Length of screw is dependant on design of clamp and angle
of facetted joint.

For additional clamp information and screw size,
contact Comar's technical department.

Fabricators Guide

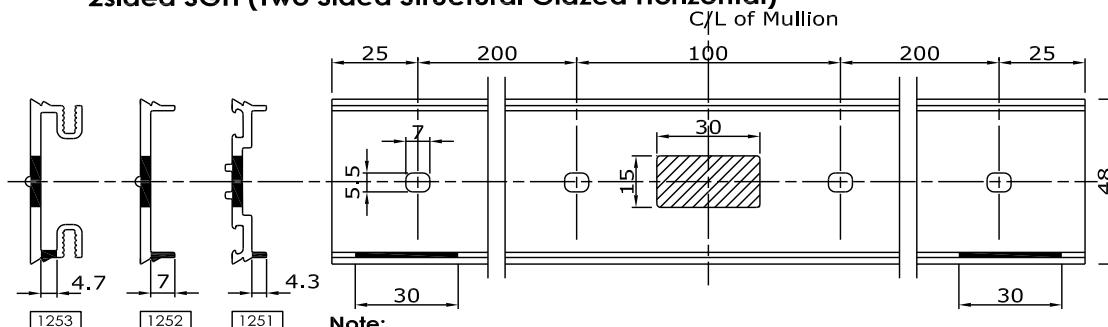
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6.22

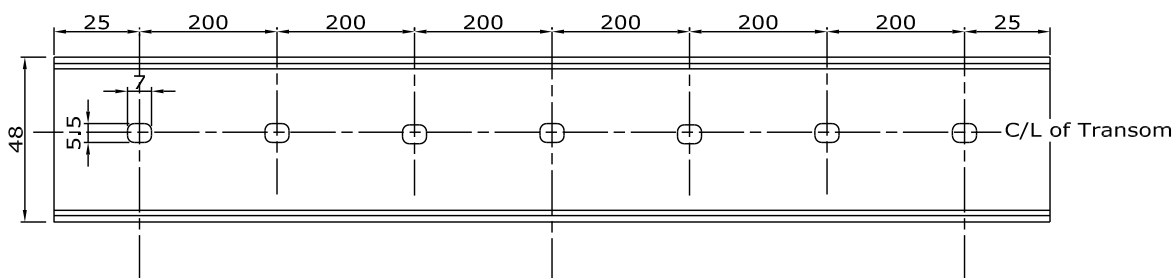
1A. Drainage slots & fixing holes Transom Pressure Plates 2sided SGH (Two Sided Structural Glazed Horizontal)



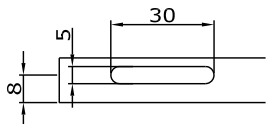
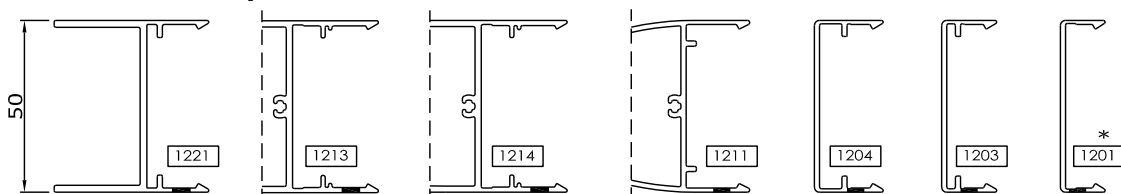
Note:

Fixing holes to be 25mm from edge and 200mm maximum centres.
Drainage slots to bottom of pressure plate to be 600mm cts. max.
30x15 drainage slot required at C/L of mullion positions.

1B. Fixing holes Transom Pressure Plates Curtain Walling (Fully Capped Curtain Walling)



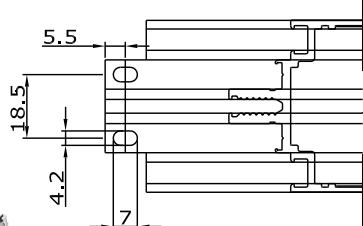
2. Drainage slots Transom Cover Caps 2sided SGH (Two Sided Structural Glazed Horizontal)



*

Note: To punch drainage slots in profile 1201, a plate must be unscrewed from the Punch tooling which will allow the profile to be positioned correctly

3. Fixing slots transom



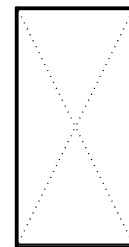
comar

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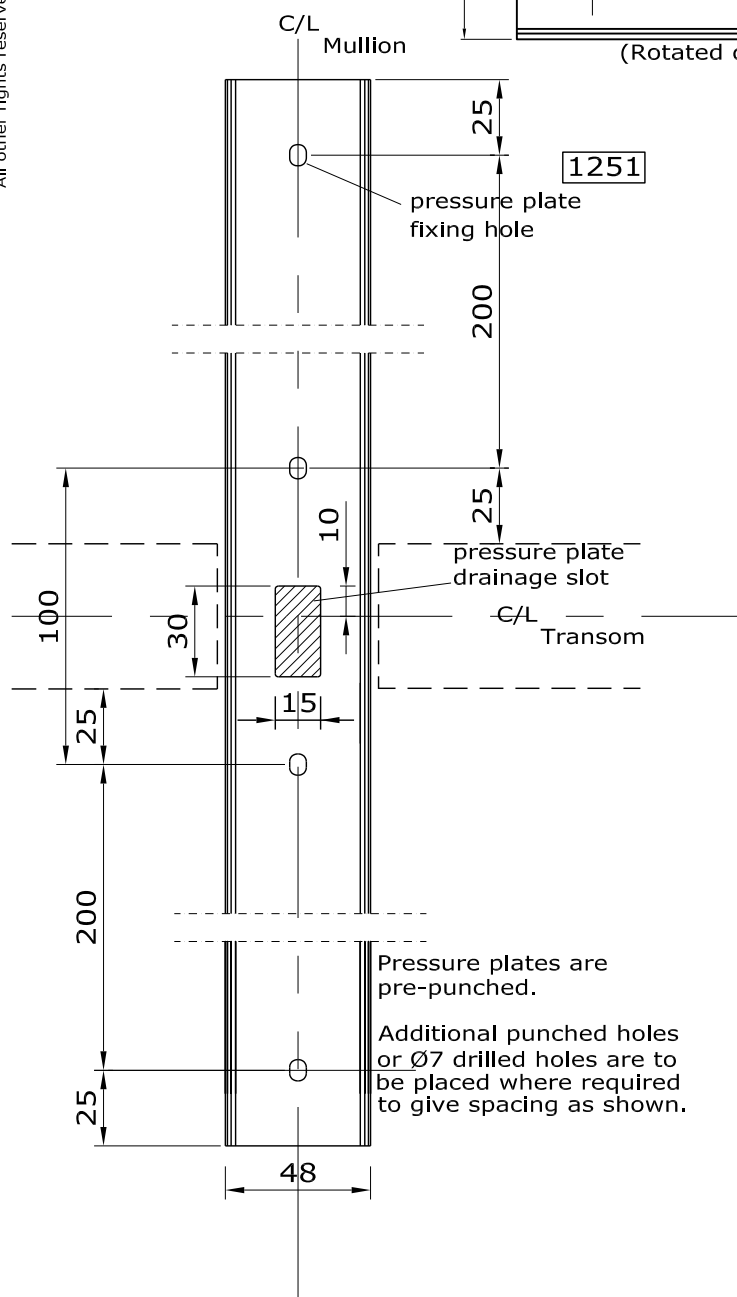
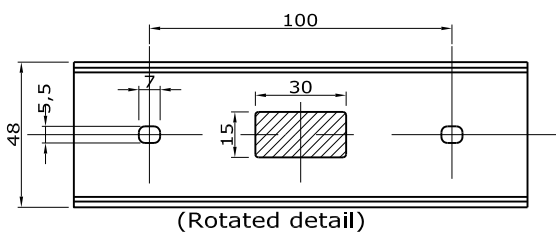
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Tooling: Punch Com 6 - EFT - T14



Drainage slots & fixing holes
Mullion Pressure Plates
2sided SGV
Fully Capped Curtain Walling



1251



1252



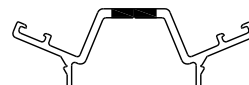
1253



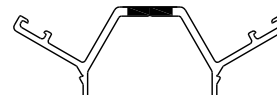
1260



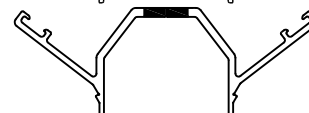
1261



1262



1263



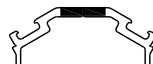
1266



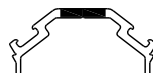
1267



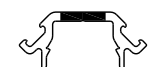
1268



1269

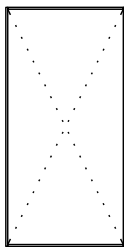


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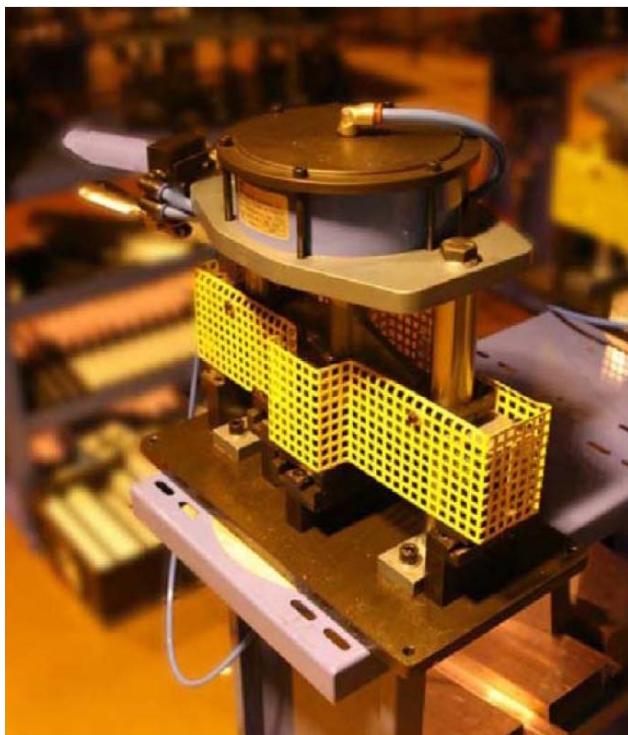


6.23

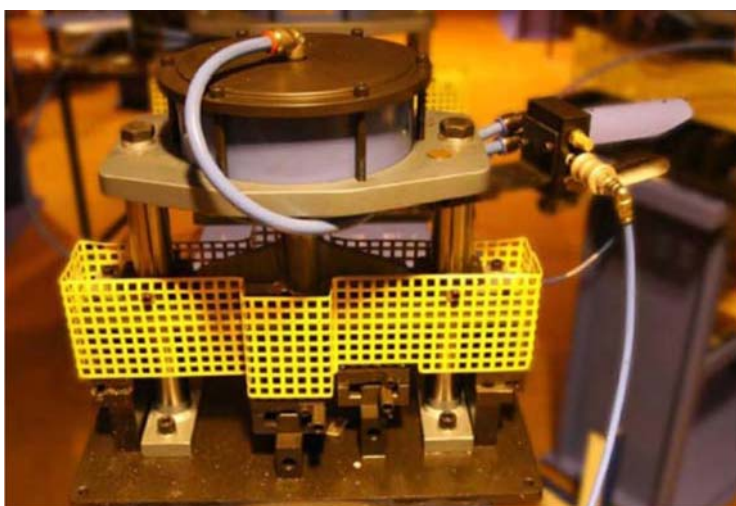
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6.24



Tool: Pneumatic punch tool Com6-EFT-T14



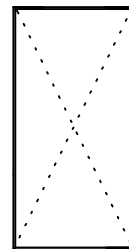
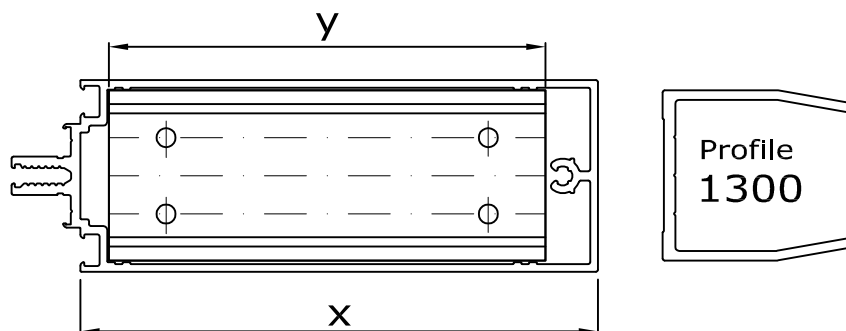
Preparations:

As per drawings: **6.22 & 6.23**

- * Pressure plate fixing holes
- * Pressure plate drainage slots
- * Cover cap drainage slots
- * Transom slots
(mullion - transom connection)

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Transom cleat sizes

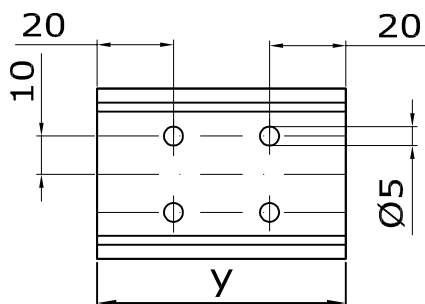


Cleat length (y) = Transom size (x) - 21mm

6.25

Transom number	Transom Size (x)	Cleat part no.	Cleat length (y)
1149	45mm	n/a	n/a
1150	60mm	n/a	n/a
1151	85mm	2551	64mm
1164	105mm	2564	84mm
1152	135mm	2552	114mm
1154	150mm	2554	129mm
1156	180mm	2556	159mm
1157	195mm	2557	174mm
1158	210mm	2558	189mm

4 screws 3025 (4.8 x 13)
Max. glass weight = 250kg



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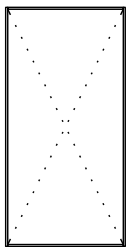
Issue: 04
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Fabrication

6

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Future Additions



6.26

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Fabrication

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6.27

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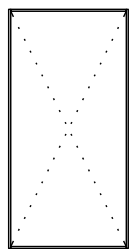
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Date :01-14

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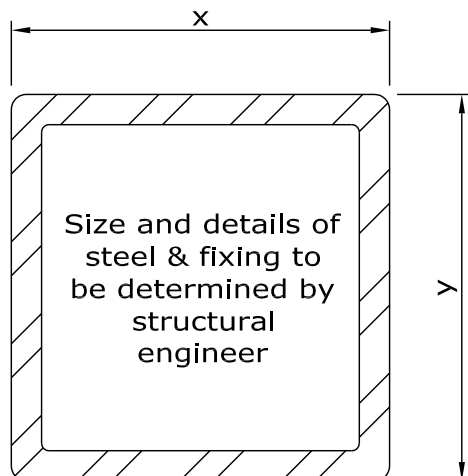
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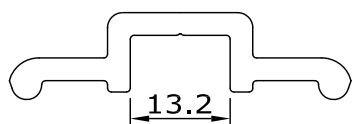
Direct fix to steel
Fixing lug preparation



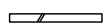
6.28



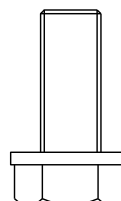
Aluminium to steel isolator
(supplied by others)



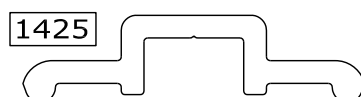
Profile 1425 (fixing lug) to be cut
and drilled as shown below



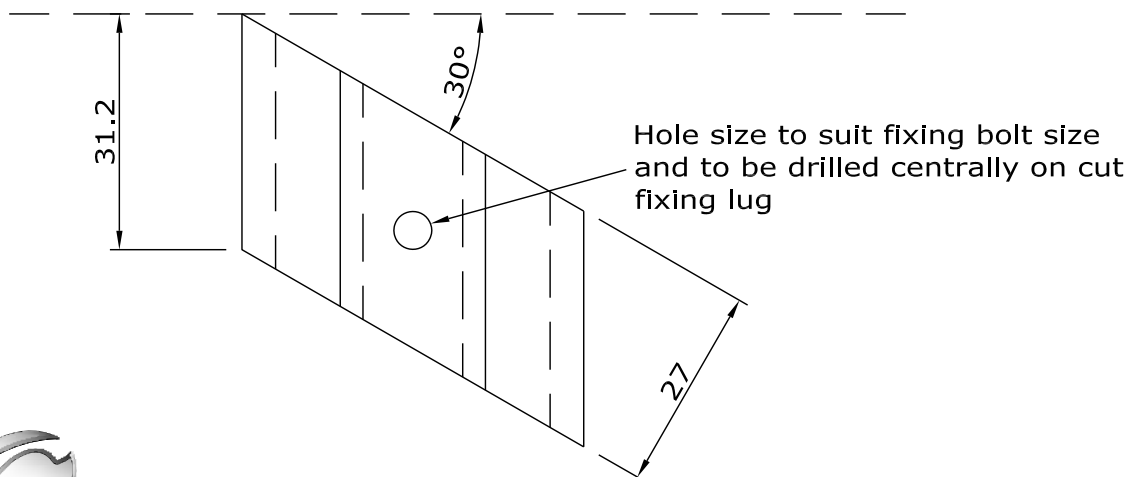
1mm spring washer
(supplied by others)



Fixing bolt (supplied by others) to
structural engineers specification



Profile 1425 to be cut and drilled
to create fixing lugs as shown



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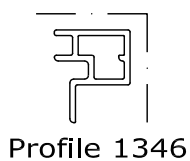
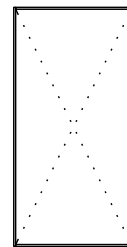
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Date : 01-14

Panel & Single glazed frames

Profiles 1335 & 1346 to be cut to same dimensions as glass or panel

Between capped mullions/transoms: C.T.C - 24

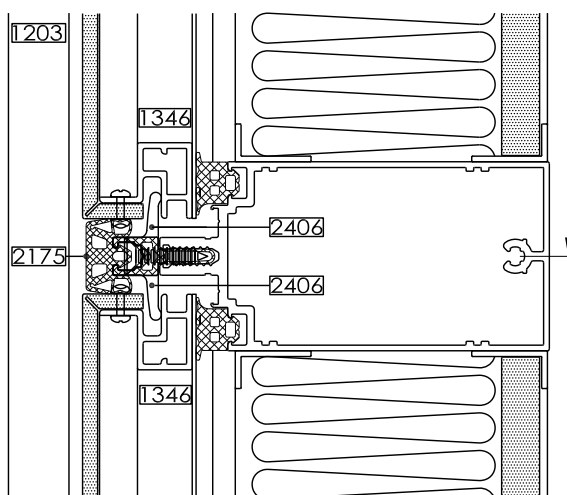
Between structural glazing mullions/transoms: C.T.C - 20



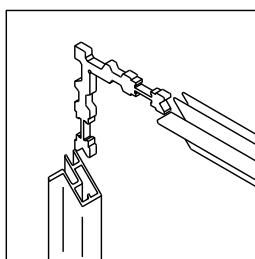
Profile 1346

1346 between structural glazed joints when panels are required

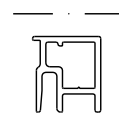
C.T.C - 20



EFT - 2539 Corner Cleat
EFT - 1346



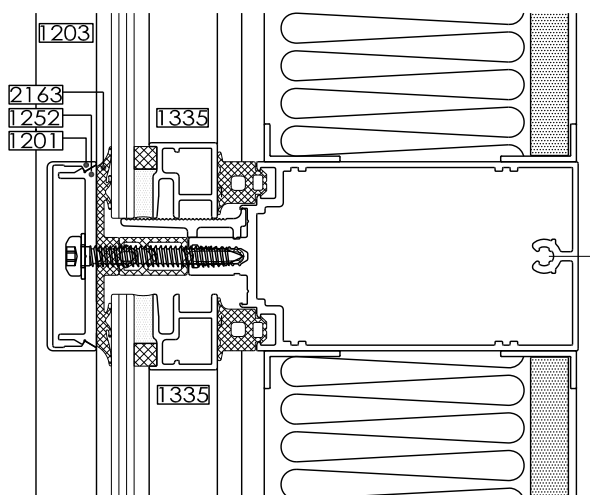
Frame lengths of 1346 to be mitred at 45° and crimped together using cleat 2539



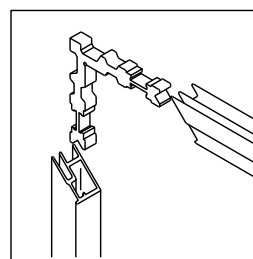
Profile 1335

1335 between capped joints when glazing joints are required

C.T.C - 24



EFT - 2538 Corner Cleat
EFT - 1335

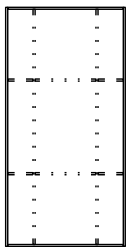


Frame lengths of 1335 to be mitred at 45° and crimped together using cleat 2538

6.29

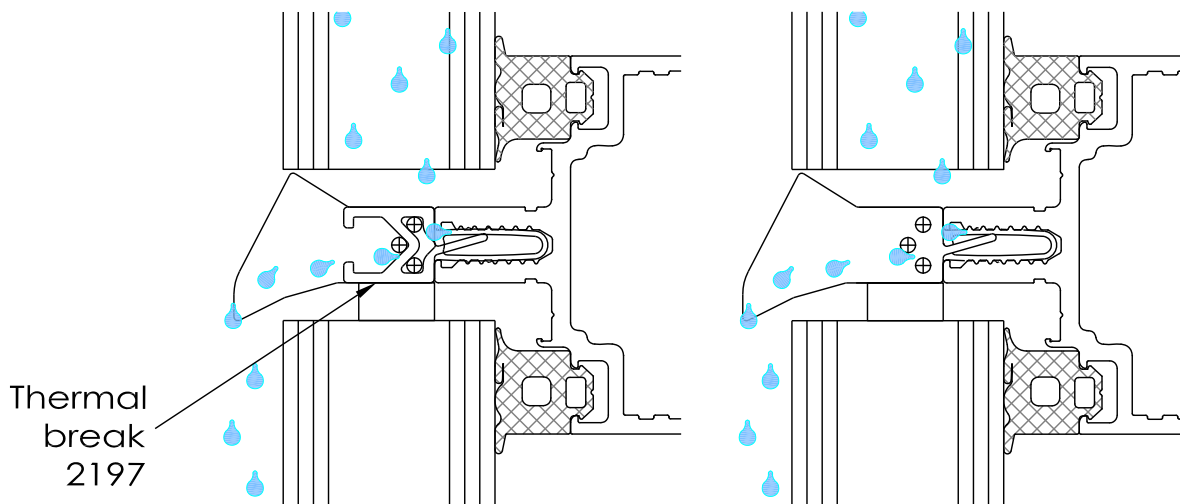
Comar 6EFT

Transom drainage diverter

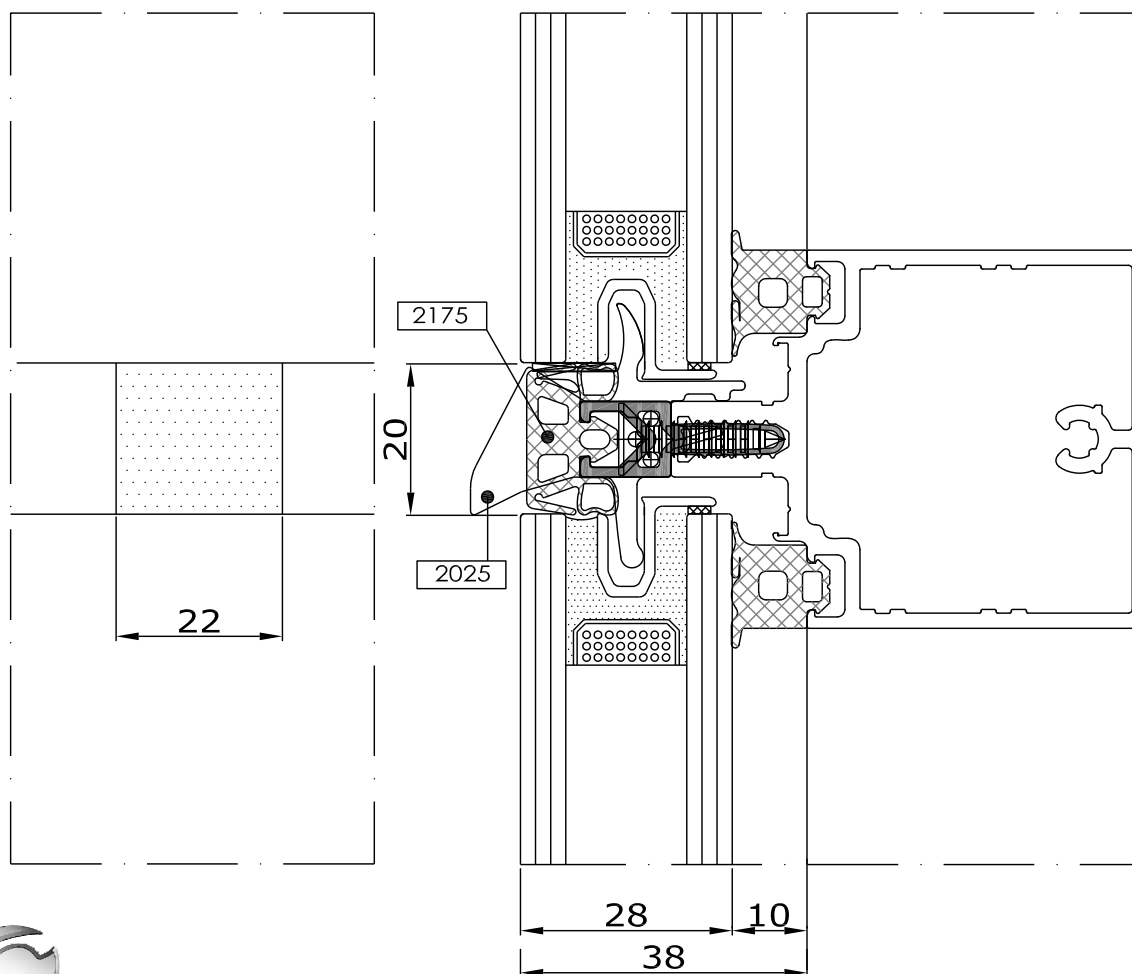


Transom drainage diverter 2025 to be used on 4sided SG facettted screens and any 4 sided SG corners.

6.30



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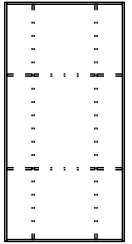
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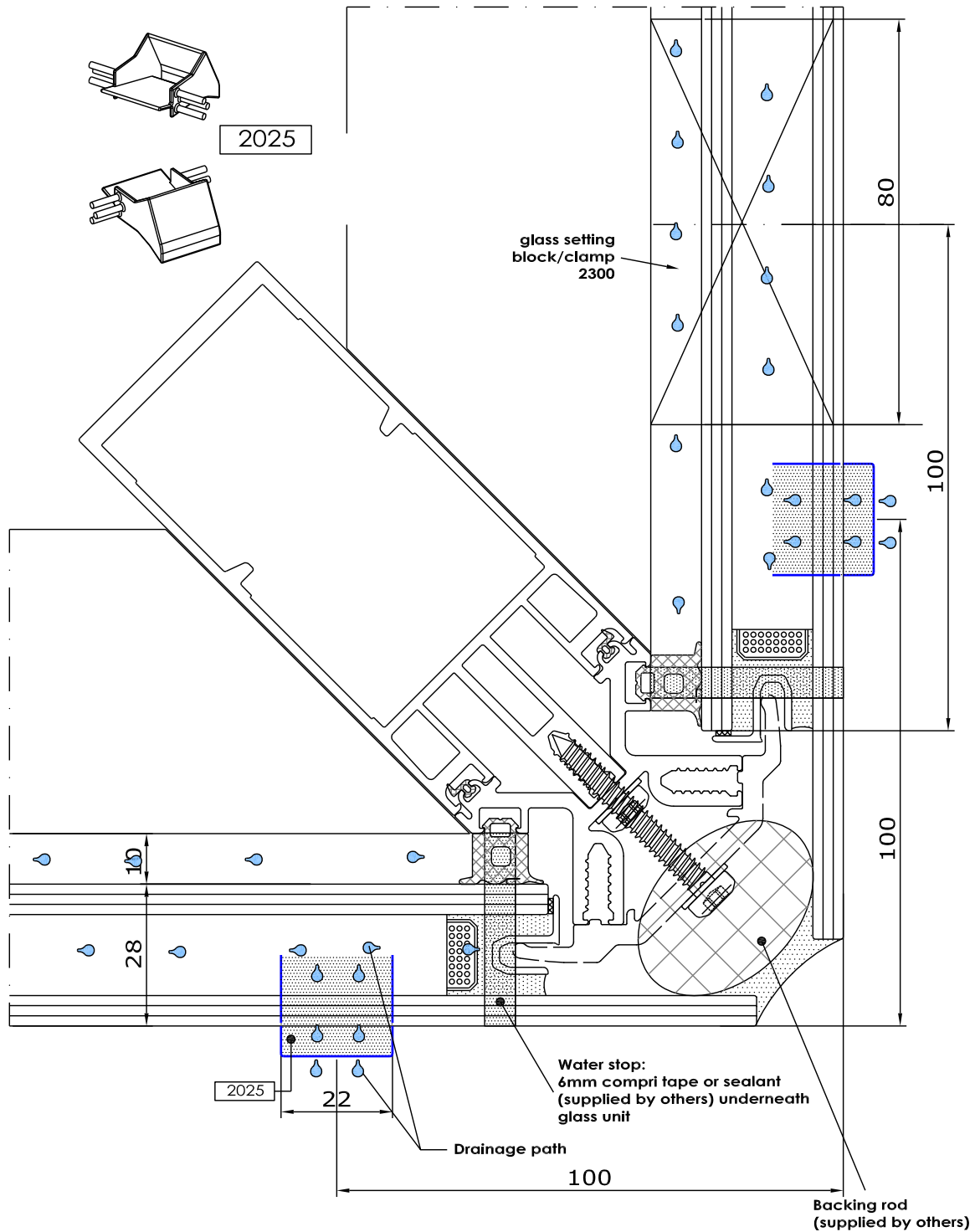
Transom drainage diverter

Transom drainage diverter 2025 to be used on 4sided SG facettted screens and any 4sided SG corners.



6.31

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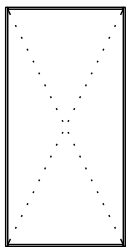
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Fabrication

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Comar 6EFT

Future Additions



6.32 - 6.60

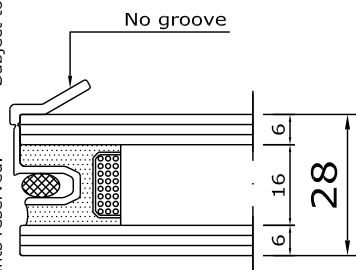
Fabricators Guide

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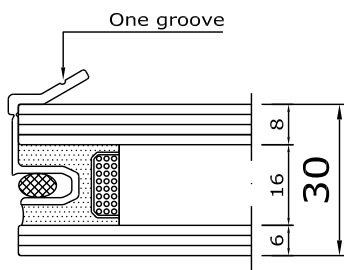
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Glass inserts

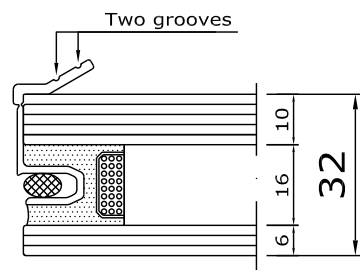
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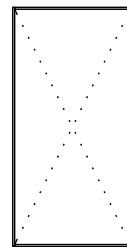
2401



2402



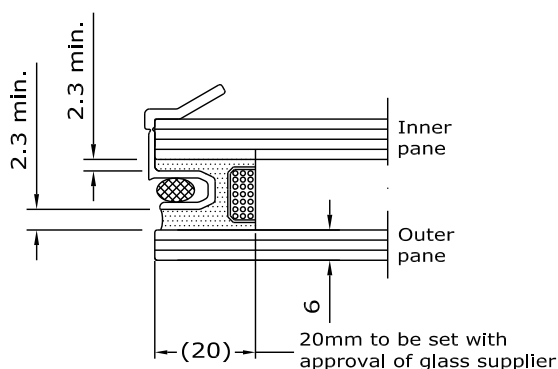
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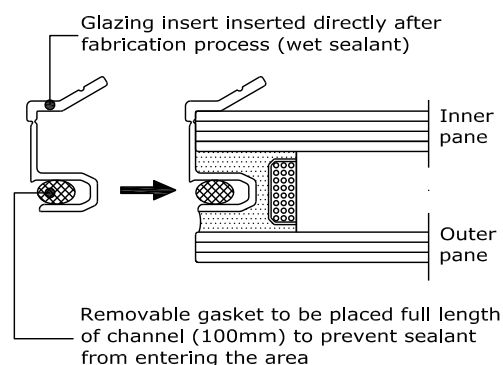
6.61

Note: In certain cases, a different size insert may have to be used ie the 30mm insert in a 32mm unit. Please contact Comar for advice

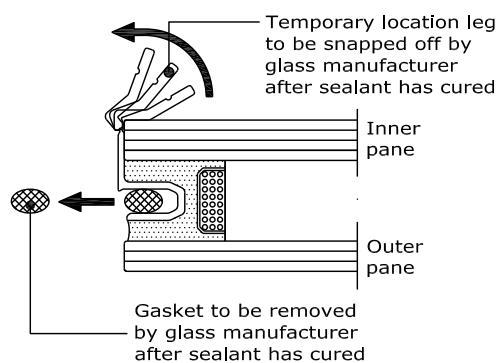
- 1 Checking glazing & spacer bar dimensions are within limits



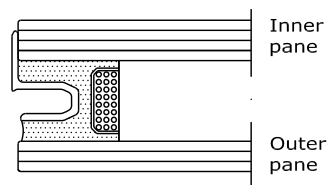
- 2 Placing insert into spacer bar



- 3 Removing snap off leg & gasket



- 4 Finished insert

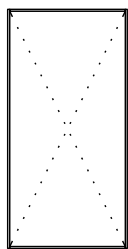


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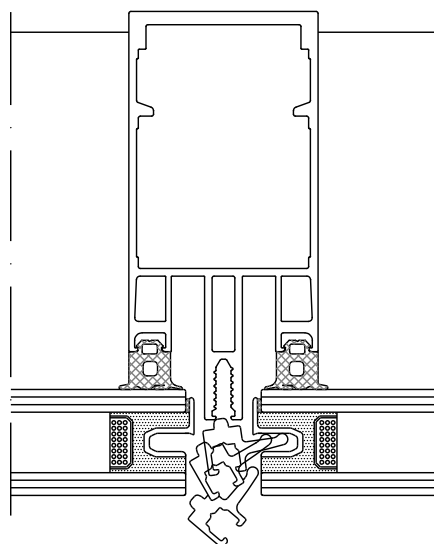
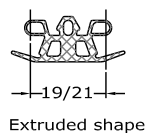
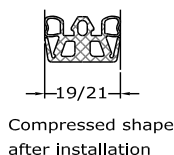
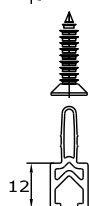
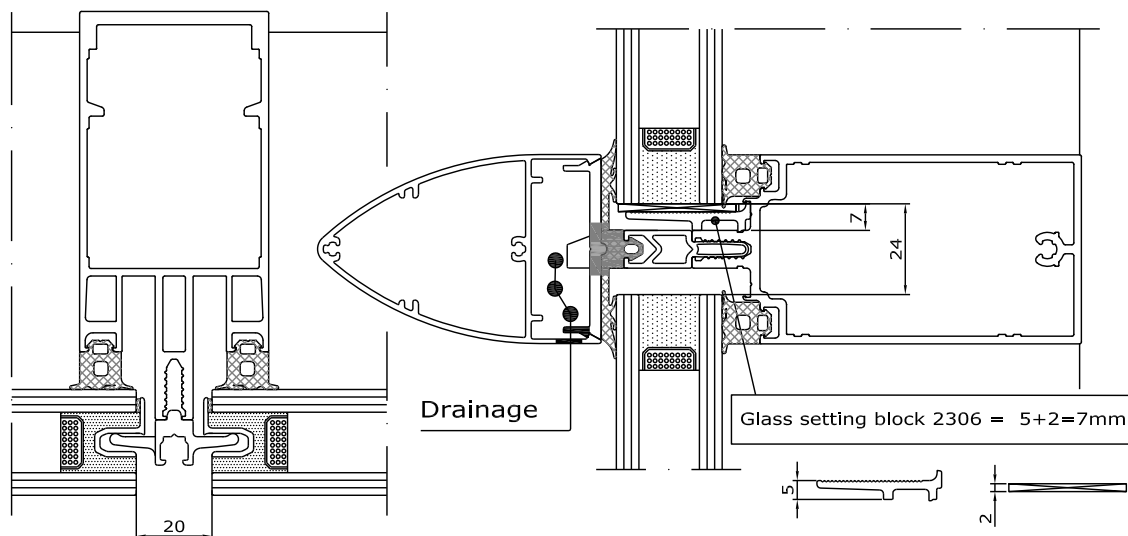
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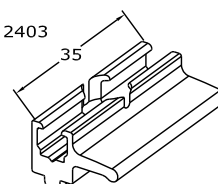
Fixing glazing insert and fixing clamp



6.62



Clamp EFT 2403



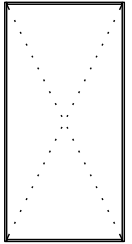
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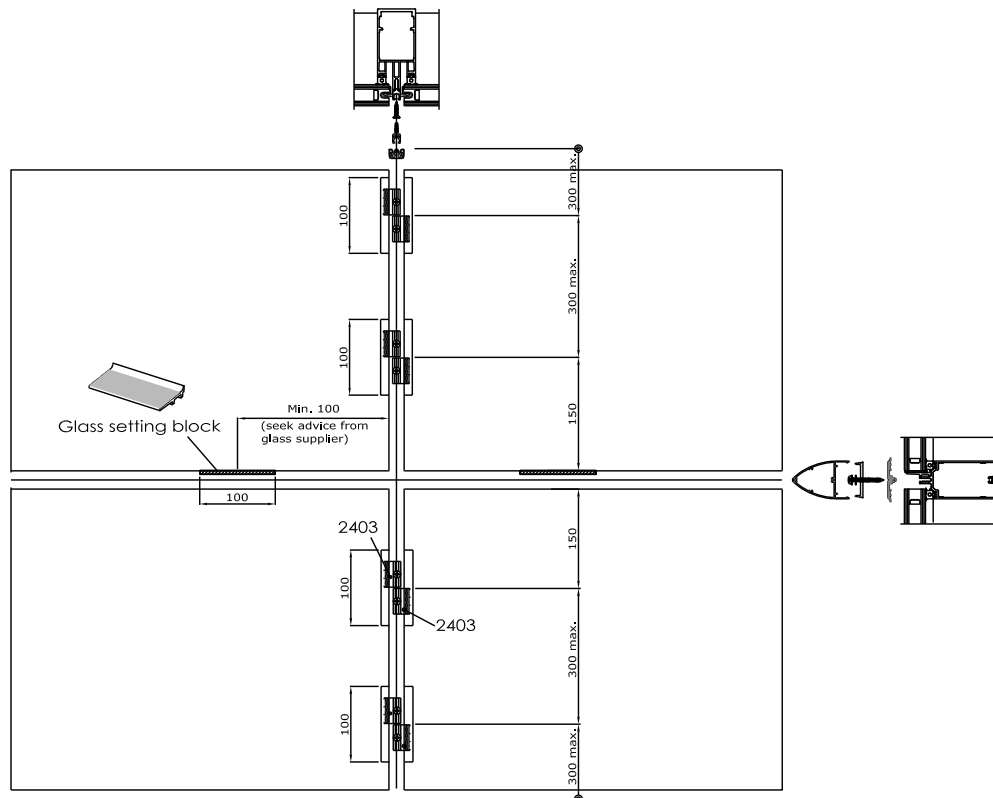
Fabrication

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Location of glazing inserts and fixing clamps



6.63



Location glazing insert and fixing clamps 2sided SGH (Two Sided Structural Glazed Horizontal cover cap)

1 Glazing inserts (EFT 2401, 2402 or 2405)

Left & right edges of glass: Glazing inserts to be located 150mm edge of glass to centre of glazing insert at either end. Inserts then spaced at 300mm max. centre to centre towards the centre of the glass unit.

If the centre of the glass unit is reached and there is more than a 300mm space between centre of inserts, you may go up to a max. of 450mm C.T.C. between those inserts.

Left & right edges of glass: Dependant on wind load, building height and local situation, the glass manufacturer may approve that less inserts can be used. Transom C.T.C < 700mm no clamps, C.T.C 700-1000mm 1 clamp, C.T.C 1000-1300mm 2 clamps, C.T.C 1300-1600mm 3 clamps etc.

2 Fixing clamp (EFT 2403)

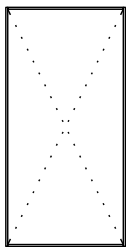
Clamps to be fixed (with screw 4.8 x 22, 3092)

Location and spacing of glazing inserts & glass setting blocks to be approved by glass manufacturer.

Fabrication

6

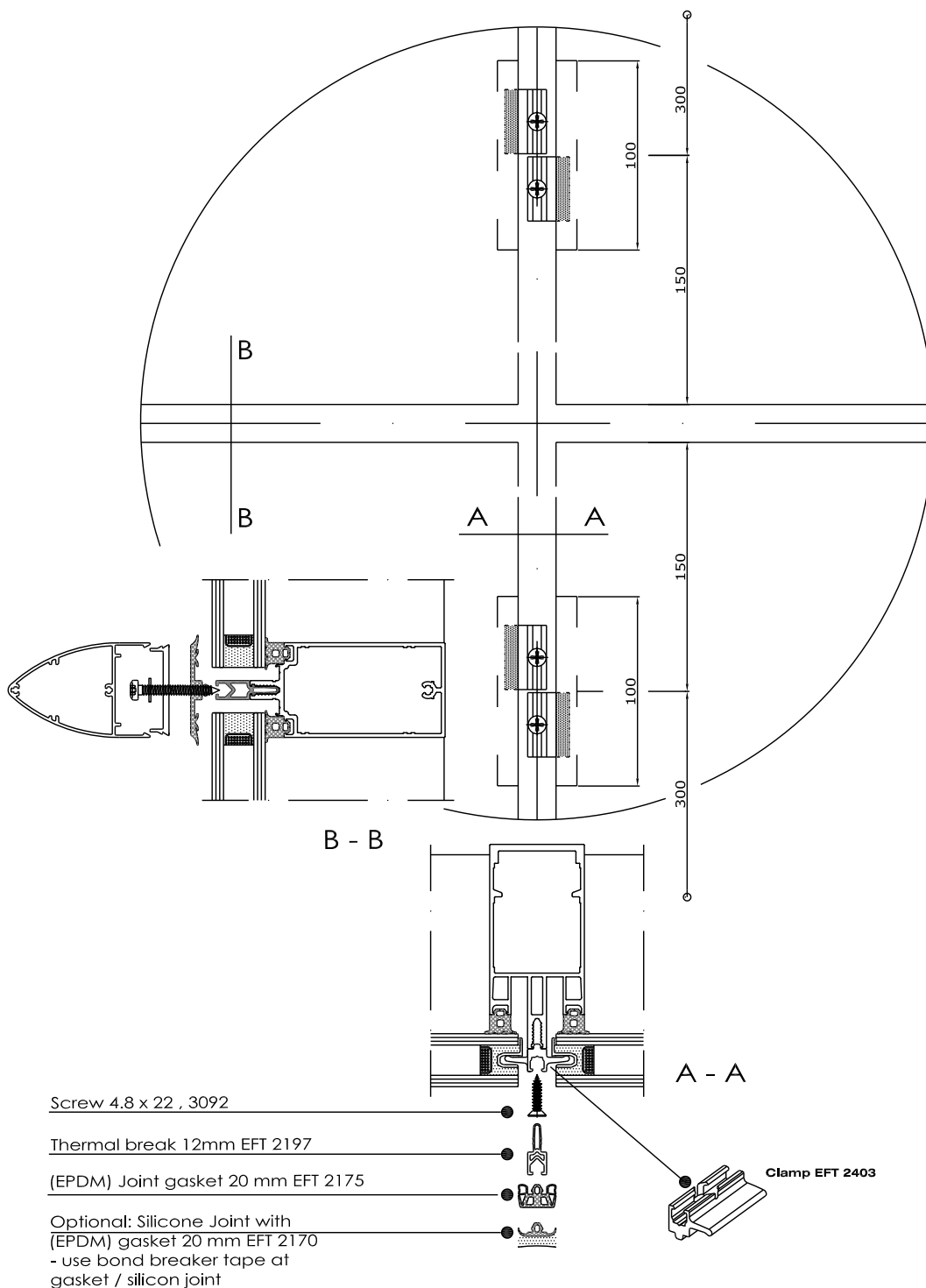
Comar 6EFT



Location of glazing inserts and fixing clamps

6.64

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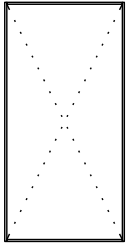
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Date : 01-14

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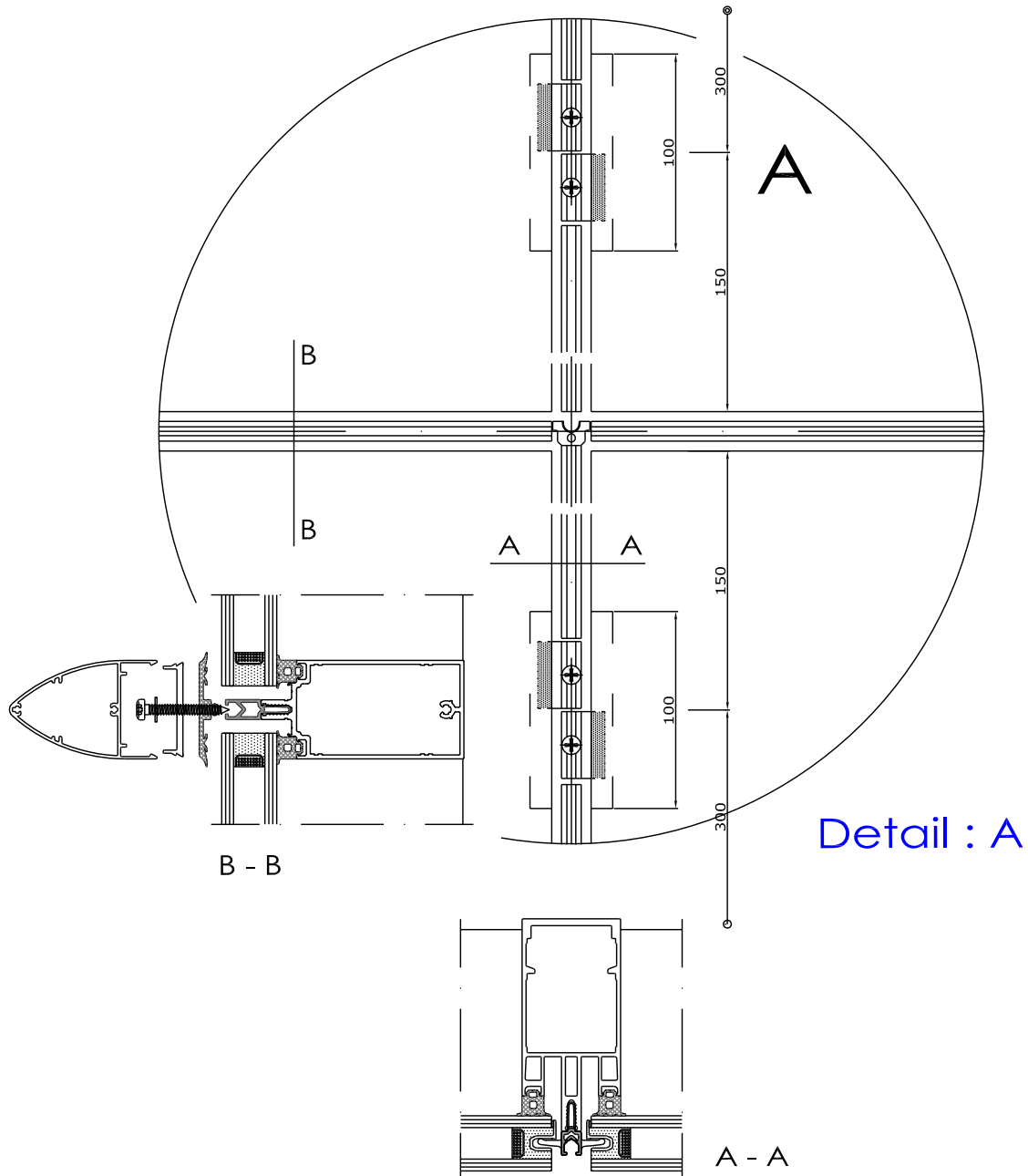
Fabrication

Comar 6EFT

Installation and sealing the thermal break



6.65



Fabricators Guide

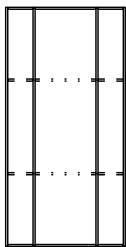
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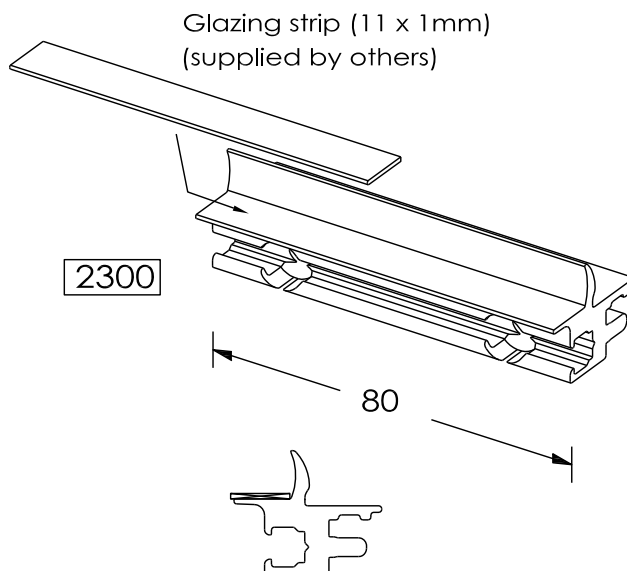
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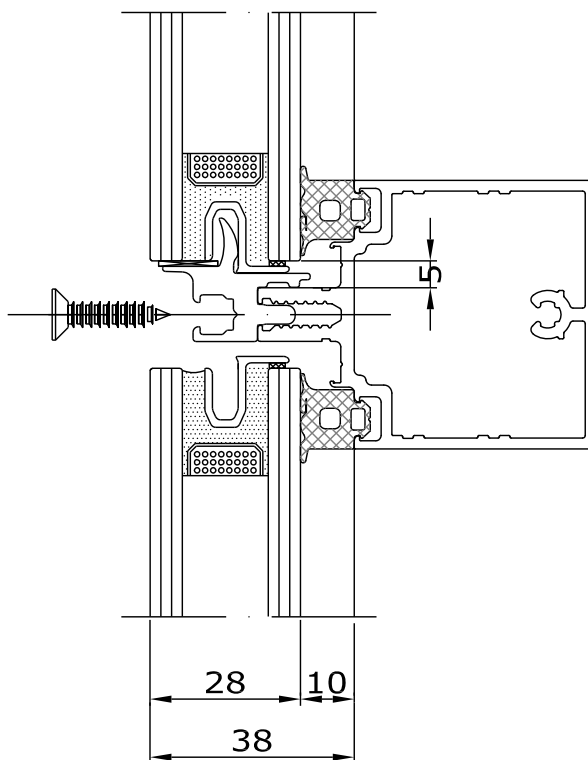
6.66

Glass support / Installation 2sided structural glazing with vertical cover cap



Glass setting block combi with clamp (EFT 2300)

- For easy installation and heavy glass units



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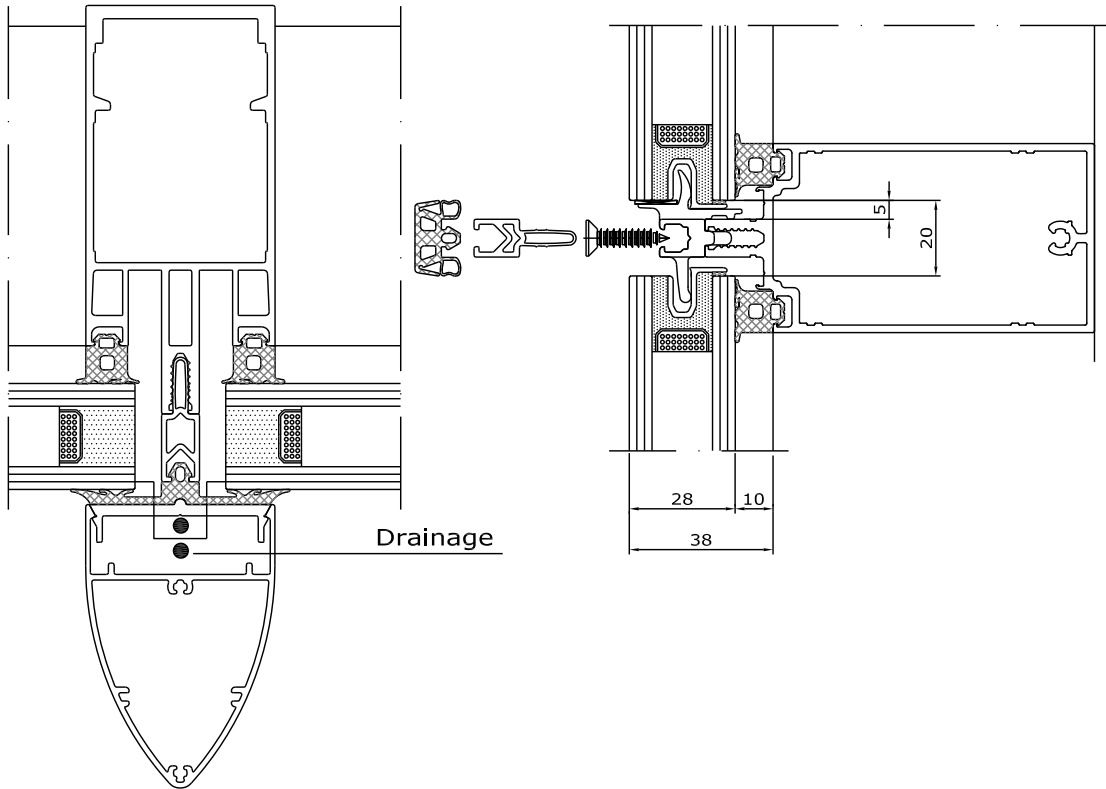
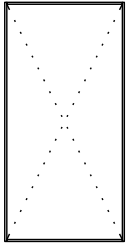
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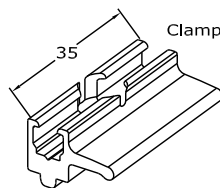
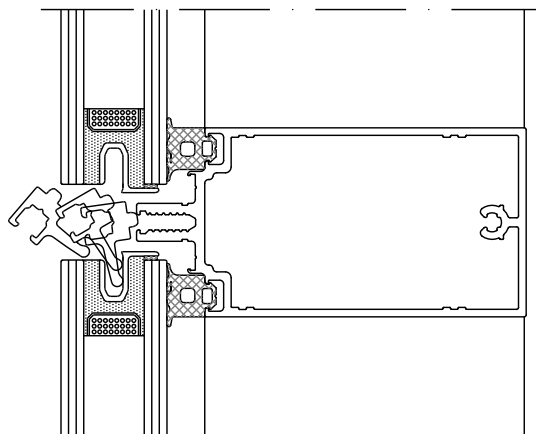
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Fixing glazing insert and fixing clamp



6.67



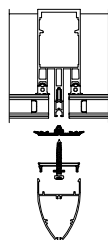
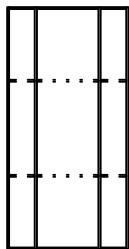
Clamp EFT 2403

Fabrication

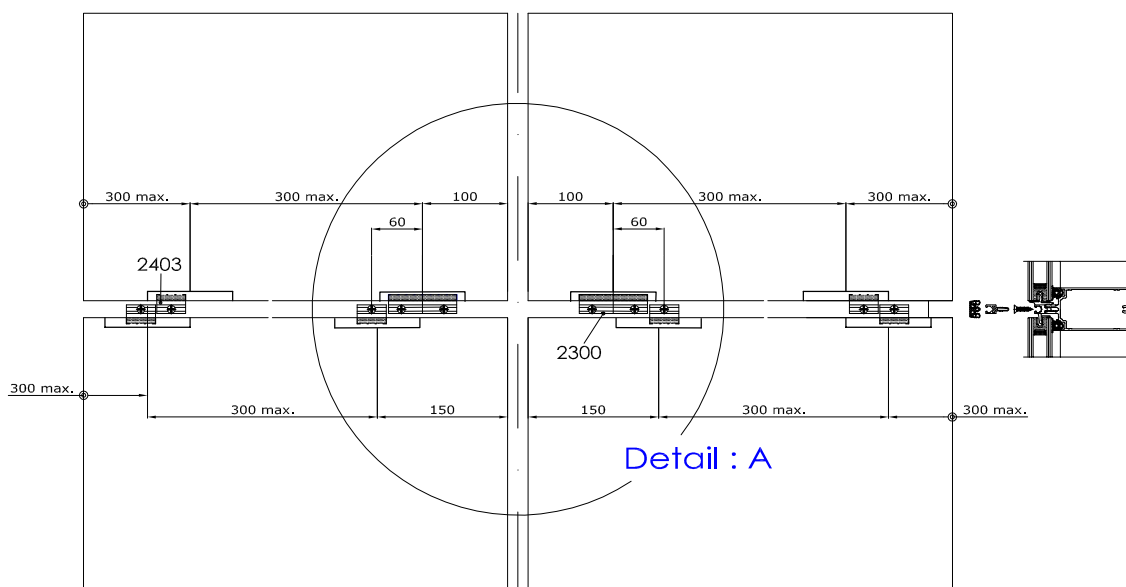
6

Comar 6EFT

Spacing of inserts and clamps



6.68



Location of glazing inserts and fixing clamps 2sided SGV (Two Sided Structural Glazed, vertical cover cap)

1 Glazing inserts (EFT 2401, 2402 or 2405)

Top edge of glass: Glazing inserts to be located 150mm edge of glass to centre of glazing insert at either end. Inserts then spaced at 300mm max. centre to centre towards the centre of the glass unit.

Bottom edge of glass: Glazing inserts to be located 100mm edge of glass to centre of glazing insert at either end. Inserts then spaced at 300mm max. centre to centre towards the centre of the glass unit.

If the centre of the glass unit is reached and there is more than a 300mm space between centre of inserts, you may go up to a max. of 450mm C.T.C. between those inserts.

2 Fixing clamp (EFT 2403)

Clamps to be fixed (with screw 4.8 x 22 , 3092)

3 Glass setting block combi fixing clamp (EFT 2300)

To be fixed (with 2 screws 4.8 x 22 , 3092)

Location and spacing of glazing inserts & glass setting blocks to be approved by glass manufacturer.



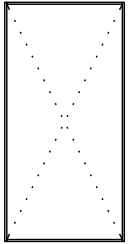
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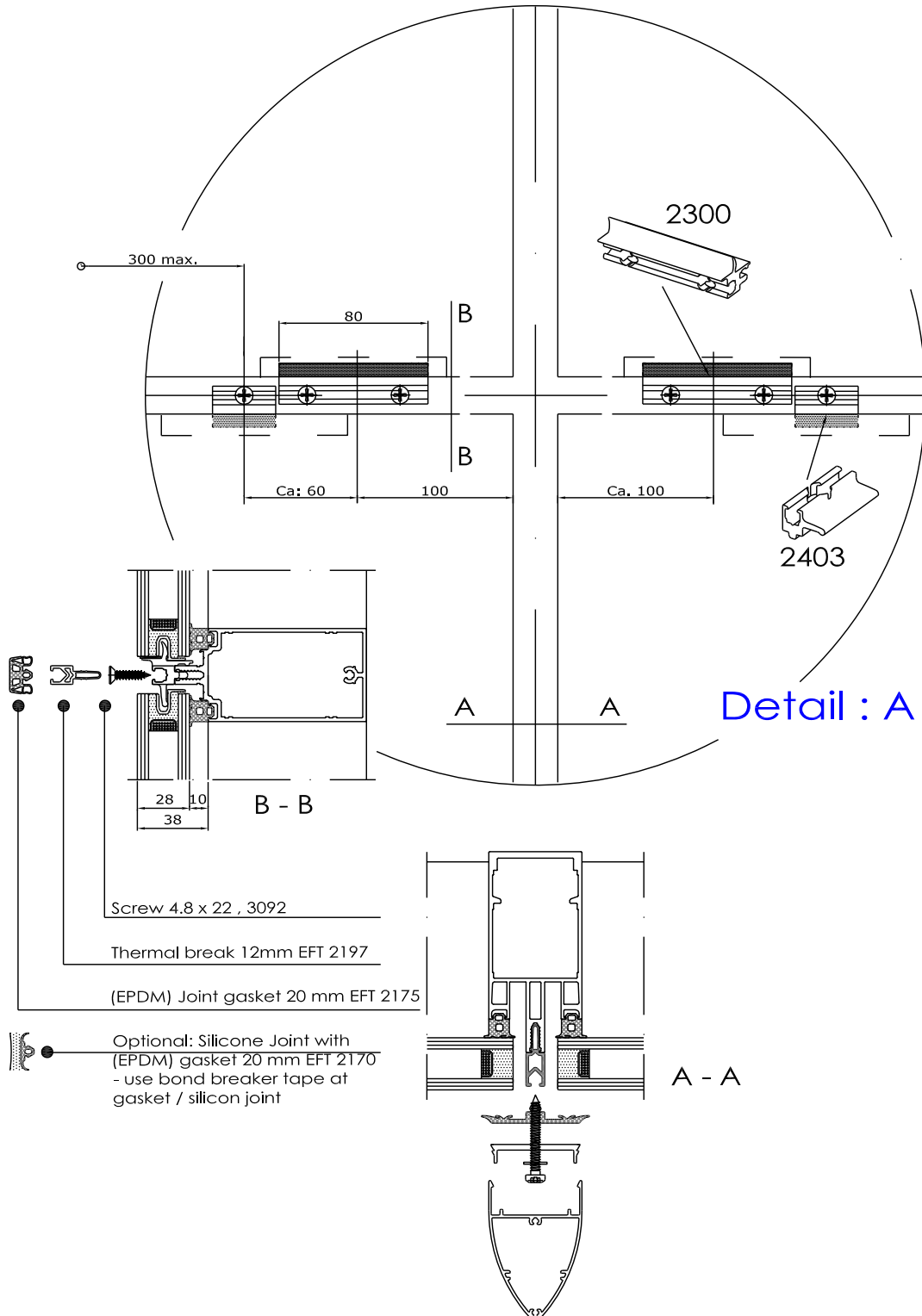
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Location of glazing inserts and fixing clamps



6.69

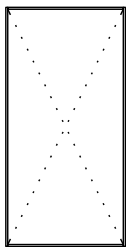


Fabrication

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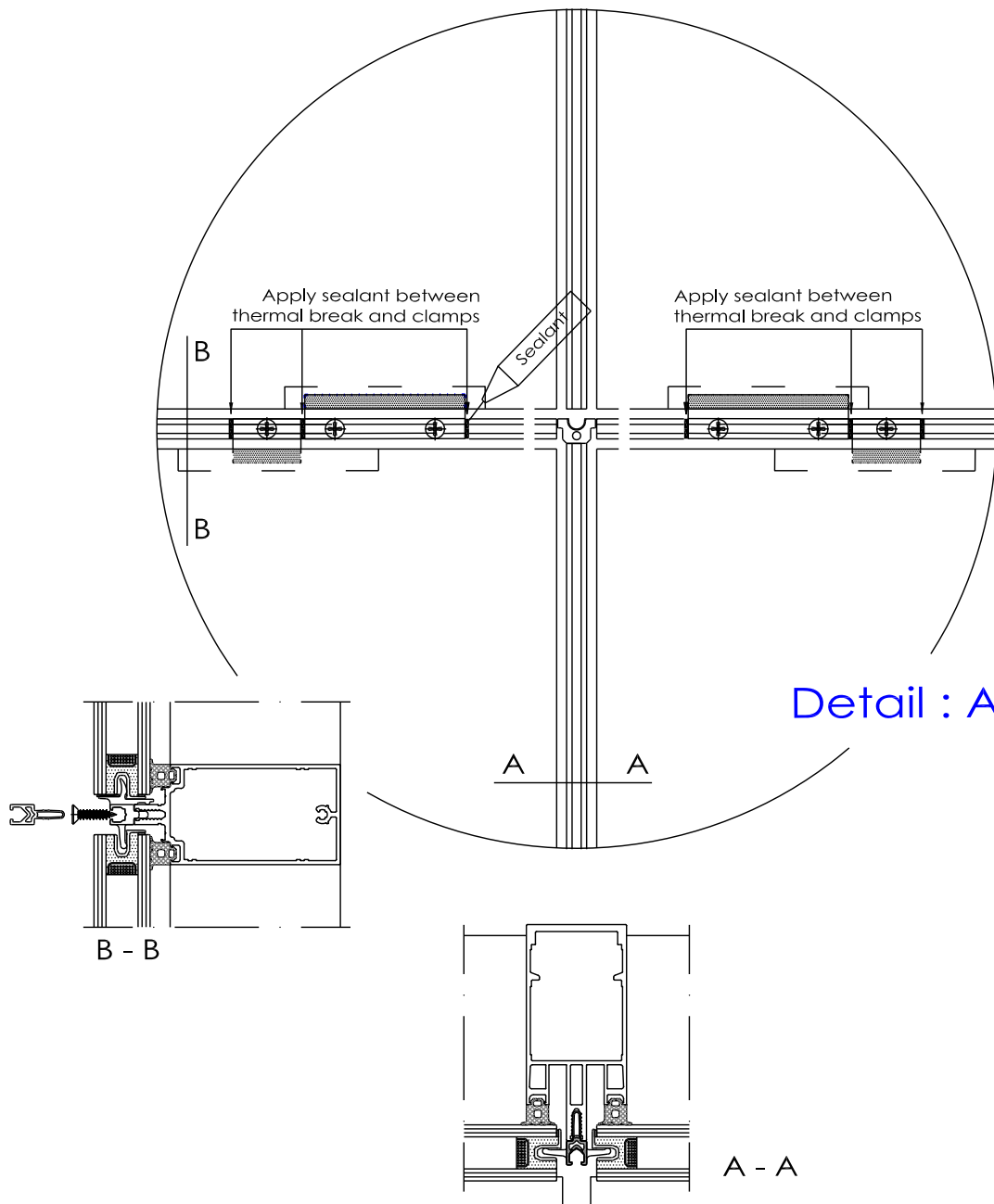
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Installation and sealing of thermal break



6.70

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6.71

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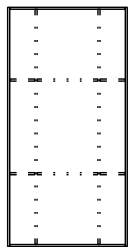
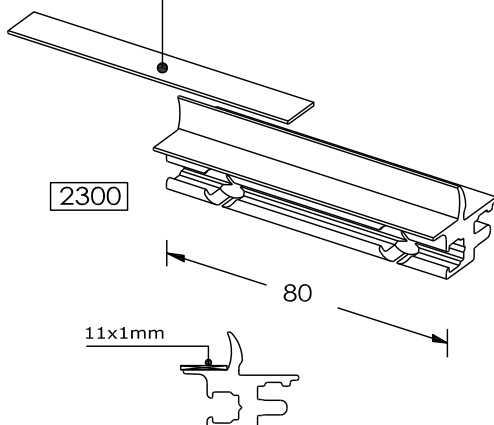
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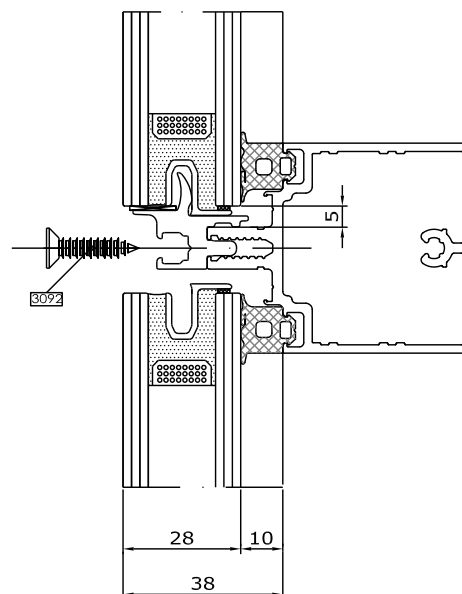
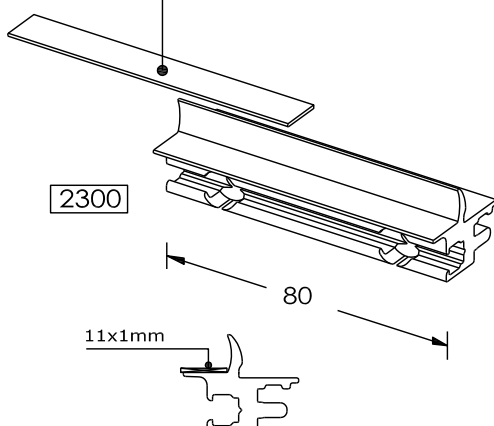
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Comar 6EFT

Glass support/intstallation
Four sided structural
glazing (4 sided SG)28mm unitsGlazing strip (11 x 1mm)
(Supplied by others)

Glass setting block EFT 2300

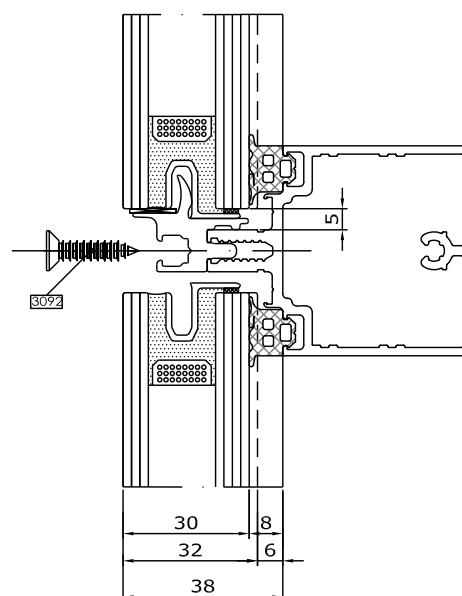
Glazing insert EFT 1389

30mm & 32mm unitsGlazing strip (11 x 1mm)
(Supplied by others)

Glass setting block EFT 2300

Glazing insert EFT 1388 (30mm)

Glazing insert EFT 1387 (32mm)



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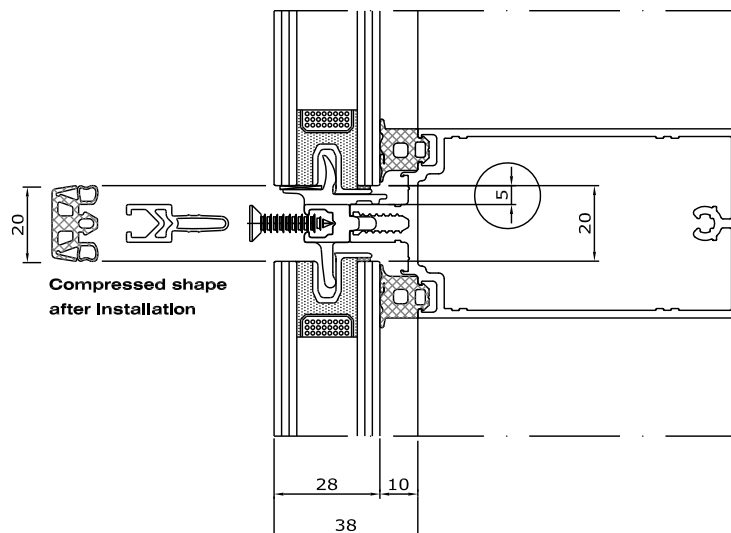
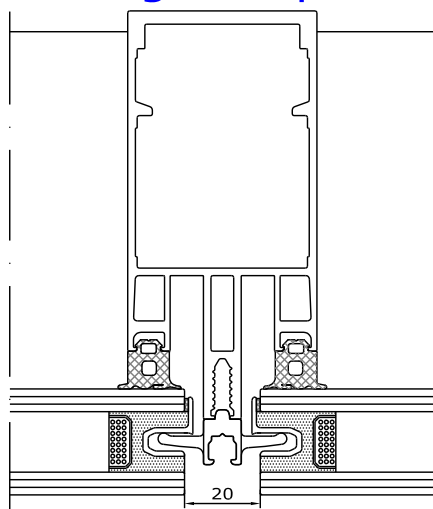
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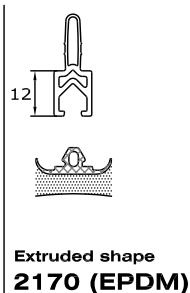
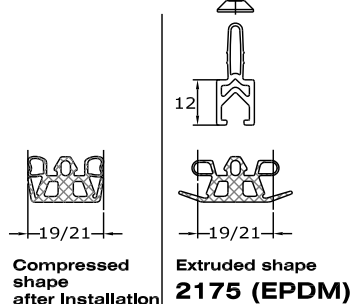
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Fixing glazing insert and fixing clamp

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6.73

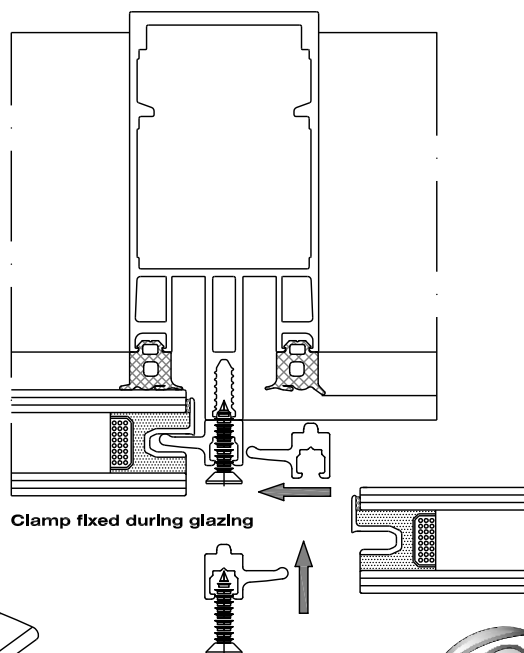
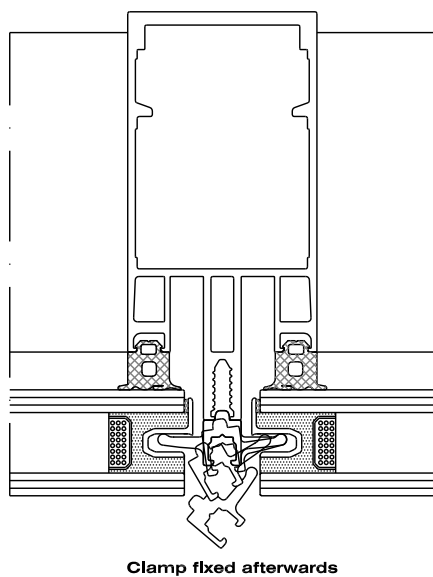


In case of choosing a silicone sealant joint seal, a UV-resistant sealing compound must be used. Please advise guidelines provided by compound supplier, this with regard to adhesion and compatibility with EPDM or silicone gaskets and glass units.

All combinations of glass, gaskets and sealants should be agreed with the glass, sealant and other suppliers (re: warranty)

Optional: Silicone Joint with (EPDM) gasket 20 mm EFT 2170
- use bond breaker tape at gasket / silicon joint

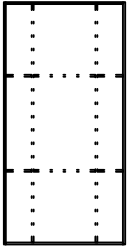
When choosing EPDM, please check compatibility with silicone glass bonding supplier



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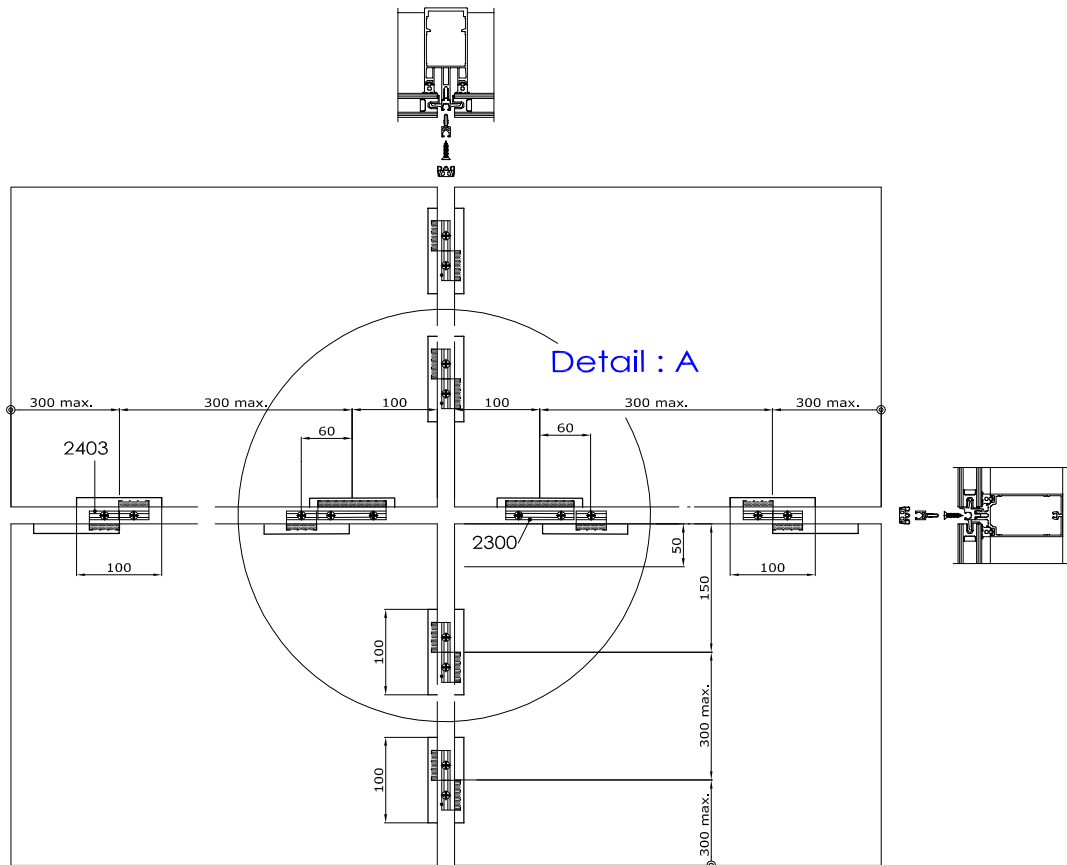
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Comar 6EFT



Location of glazing inserts and fixing clamps

6.74



Location glazing insert and fixing clamps - 4 sided Structural Glazing

1 Glazing inserts (EFT 2401, 2402 or 2405)

Top, left and right edges: Centre of first glazing insert to be located 150mm from the edge of the glass unit. Further inserts to be located at 300mm max. C.T.C towards the centre of the unit.

Bottom edge: Centre of first glazing insert to be located 100mm from the edge of the glass unit. Further inserts to be located at 300mm max. C.T.C towards the centre of the unit.

If the centre of the glass unit is reached and there is more than a 300mm space between centre of inserts, you may go up to a max. of 450mm C.T.C. between those inserts.

2 Fixing clamp (EFT 2403)

First clamp to be fixed (with screw 4.8 x 22 , 3092) 160mm centre of clamp to edge of glass. Further clamps to be fixed at 300mm max. C.T.C.

3 Glass setting block combi fixing clamp (EFT 2300)

To be fixed (with 2 screws 4.8 x 22 , 3092)

Location and spacing of glazing inserts and glass setting blocks to be approved by glass manufacturer.

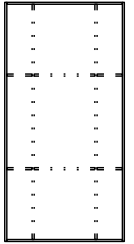


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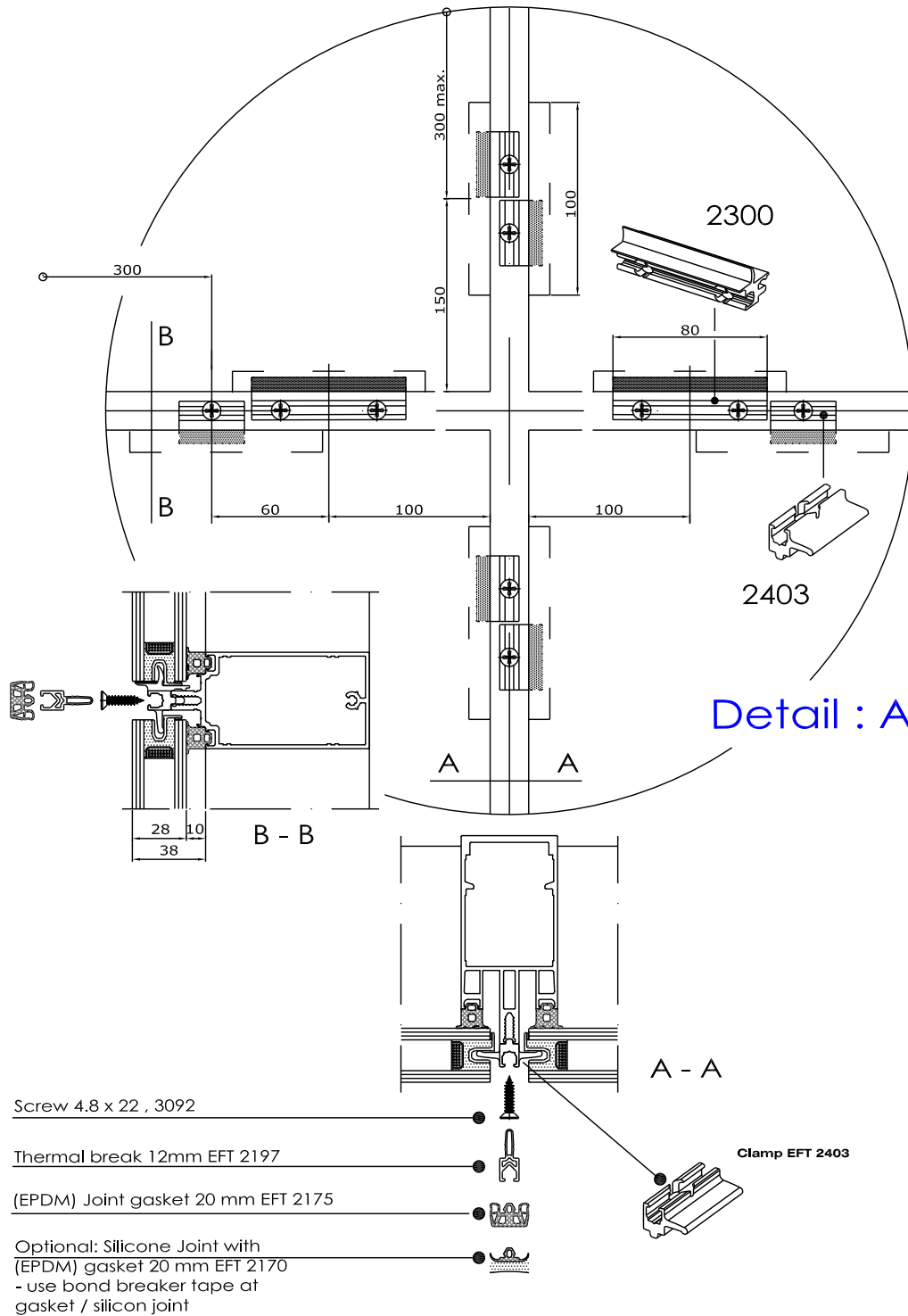
Fabrication

Comar 6EFT

Location of glazing inserts and fixing clamps



6.75



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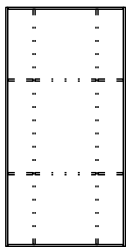
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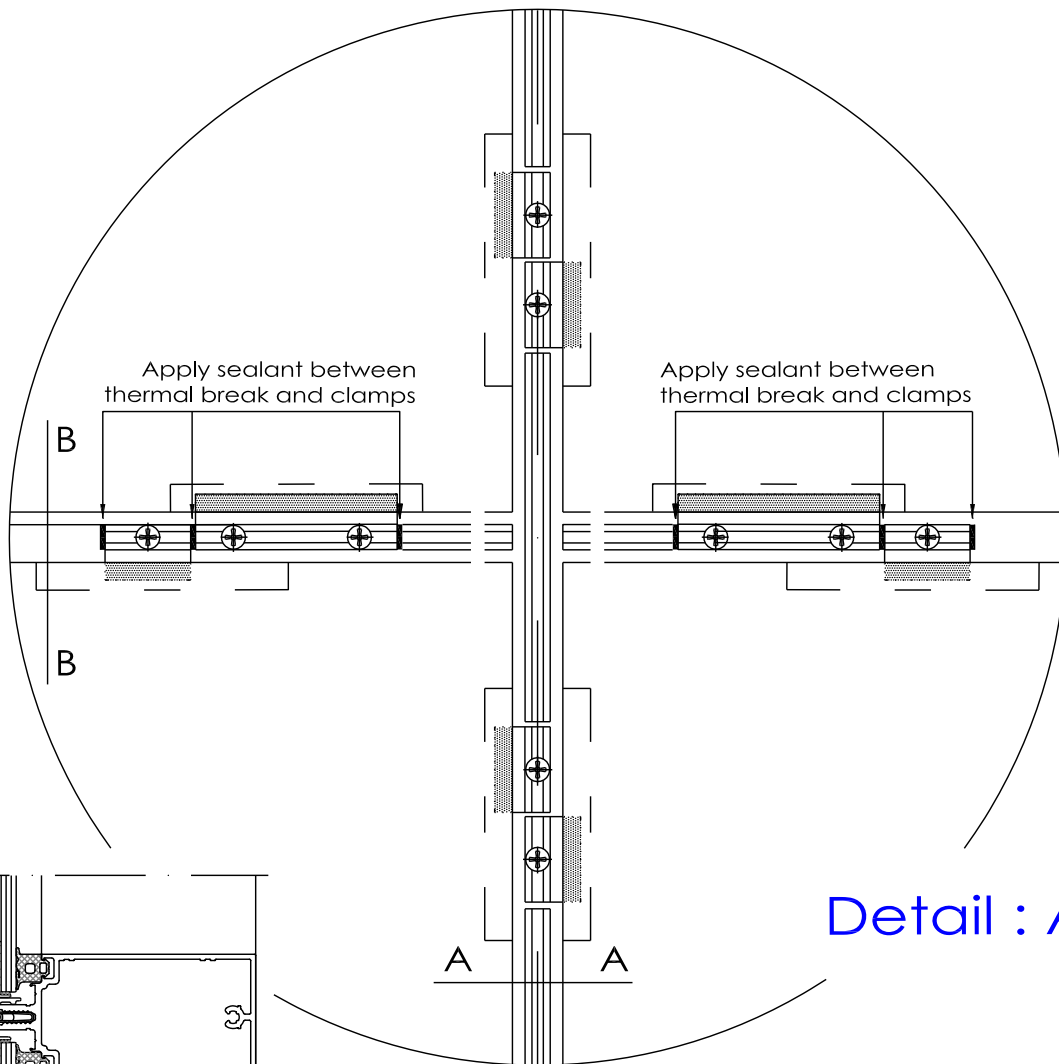
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Installing and sealing the thermal break

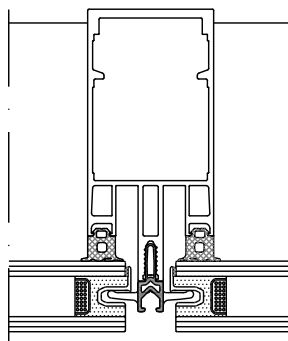
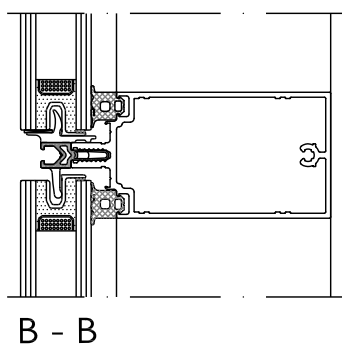


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Detail : A



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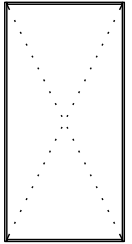
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Location of fixing clamps for 1335, 1346 & 1348

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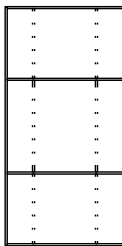


For frames made out of profiles 1335 and 1346, location, spacing, fixing and sealing of glass setting blocks/clamps 2300, 2403 & 2406 to be the same as double glazed units as detailed in this section.

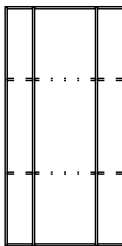
Perimeter profiles 1345 & 1348 should also be held in place by clamps 2403 and these should be located, spaced, fixed and sealed as double glazed units as detailed in this section.

6.77

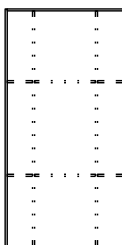
Any frames or perimeter profiles covered by cover caps do not need fixing clamps. Refer to drawings below for details.



2sided SGH - Two sided structural glazing, horizontal cover caps
Refer to drawings



2sided SGV - Two sided structural glazing, vertical cover caps
Refer to drawings



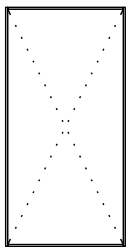
4sided SG - Four sided structural glazing, no cover caps
Refer to drawings

Fabrication

6

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Future Additions



6.78

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ADDITION

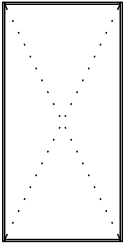
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6.79 - 6.89

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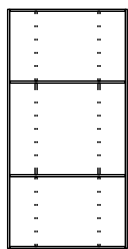
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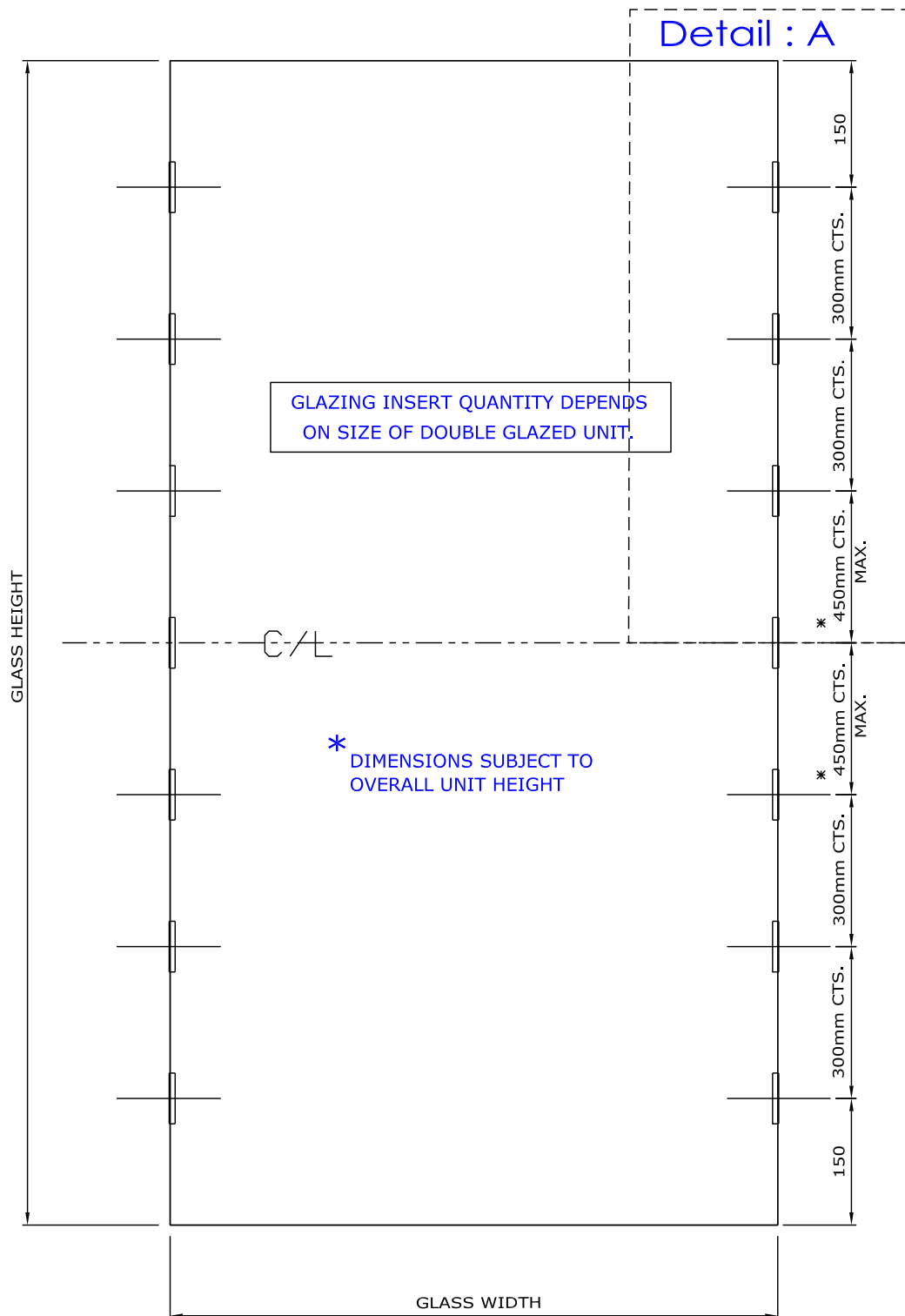
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Location of glazing inserts and fixing clamps



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Spacing of inserts and clamps

Detail : A

GLAZING INSERT

GLAZING INSERT QUANTITY DEPENDS
ON SIZE OF DOUBLE GLAZED UNIT.

*
DIMENSIONS SUBJECT TO
OVERALL UNIT HEIGHT

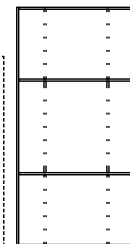
150

300mm CTS.

300mm CTS.

450mm CTS.

MAX.



6.91

Fabrications Guide

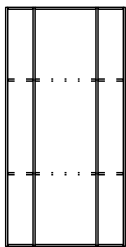

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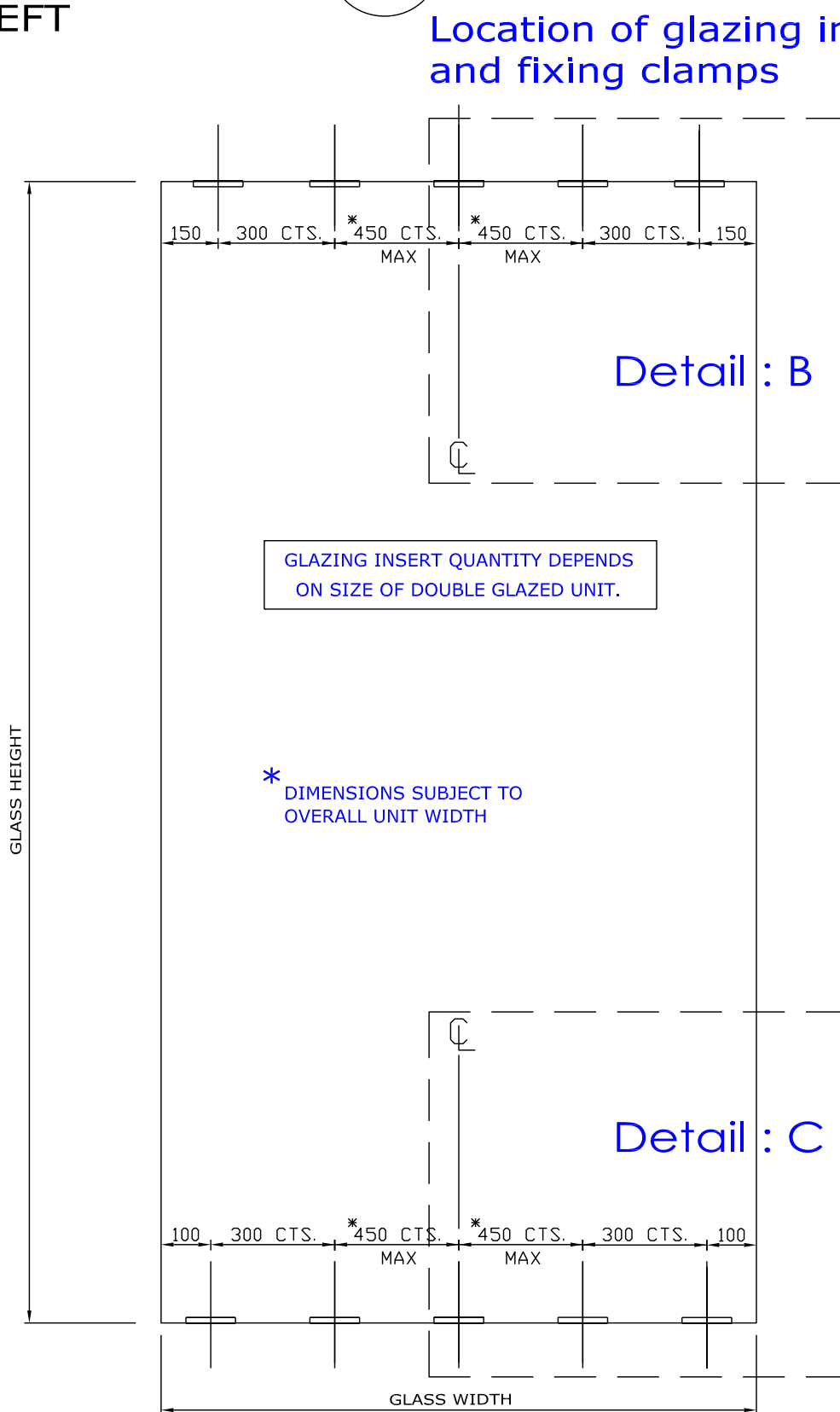
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6.92



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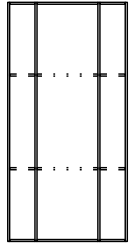
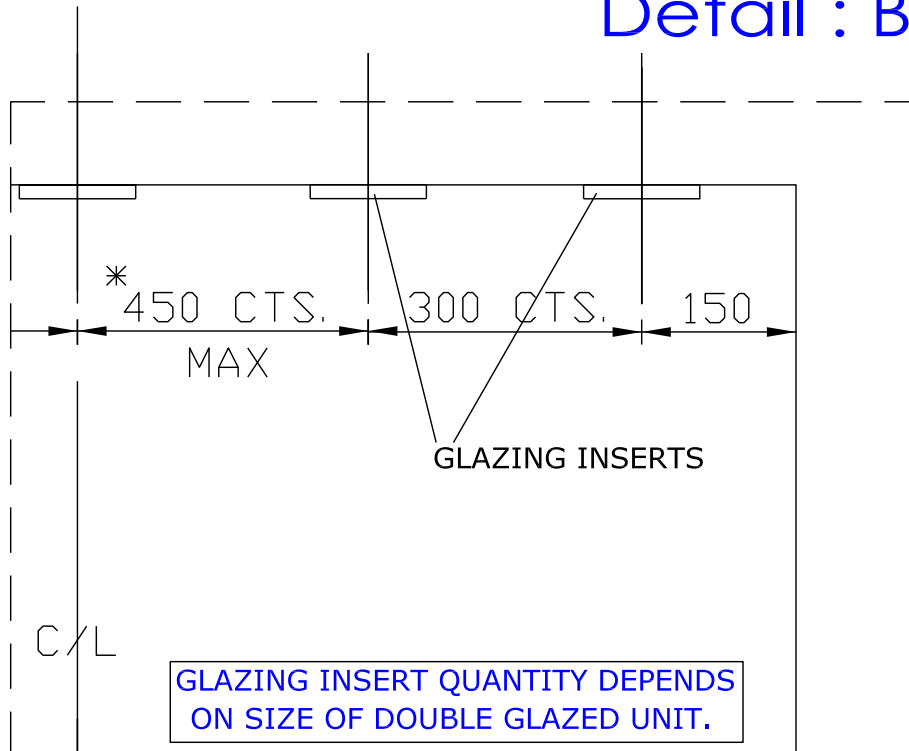
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Fabrication

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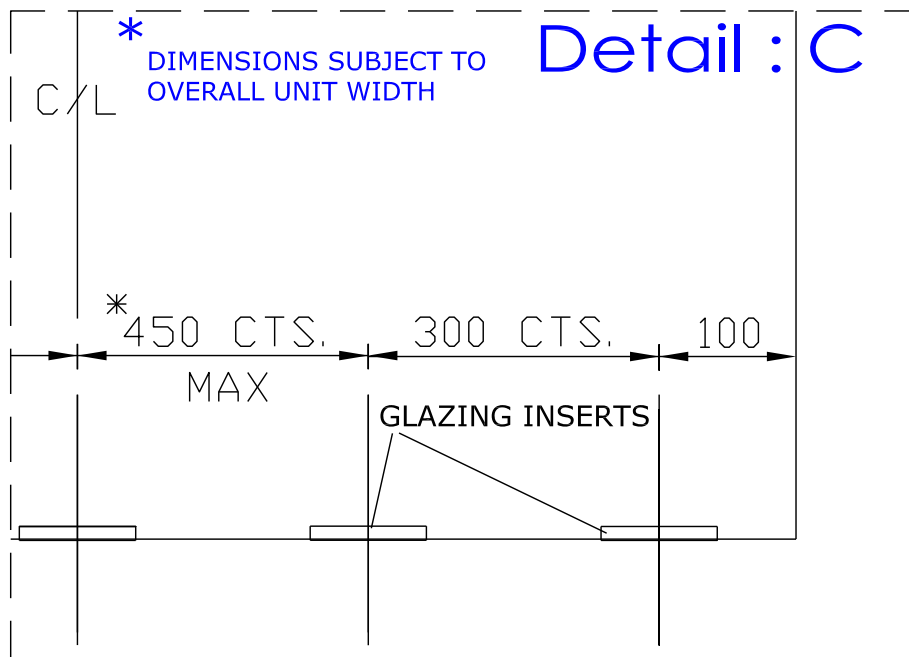
Spacing of inserts and clamps

Detail : B



6.93

Detail : C

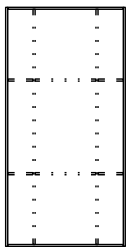


Fabrication

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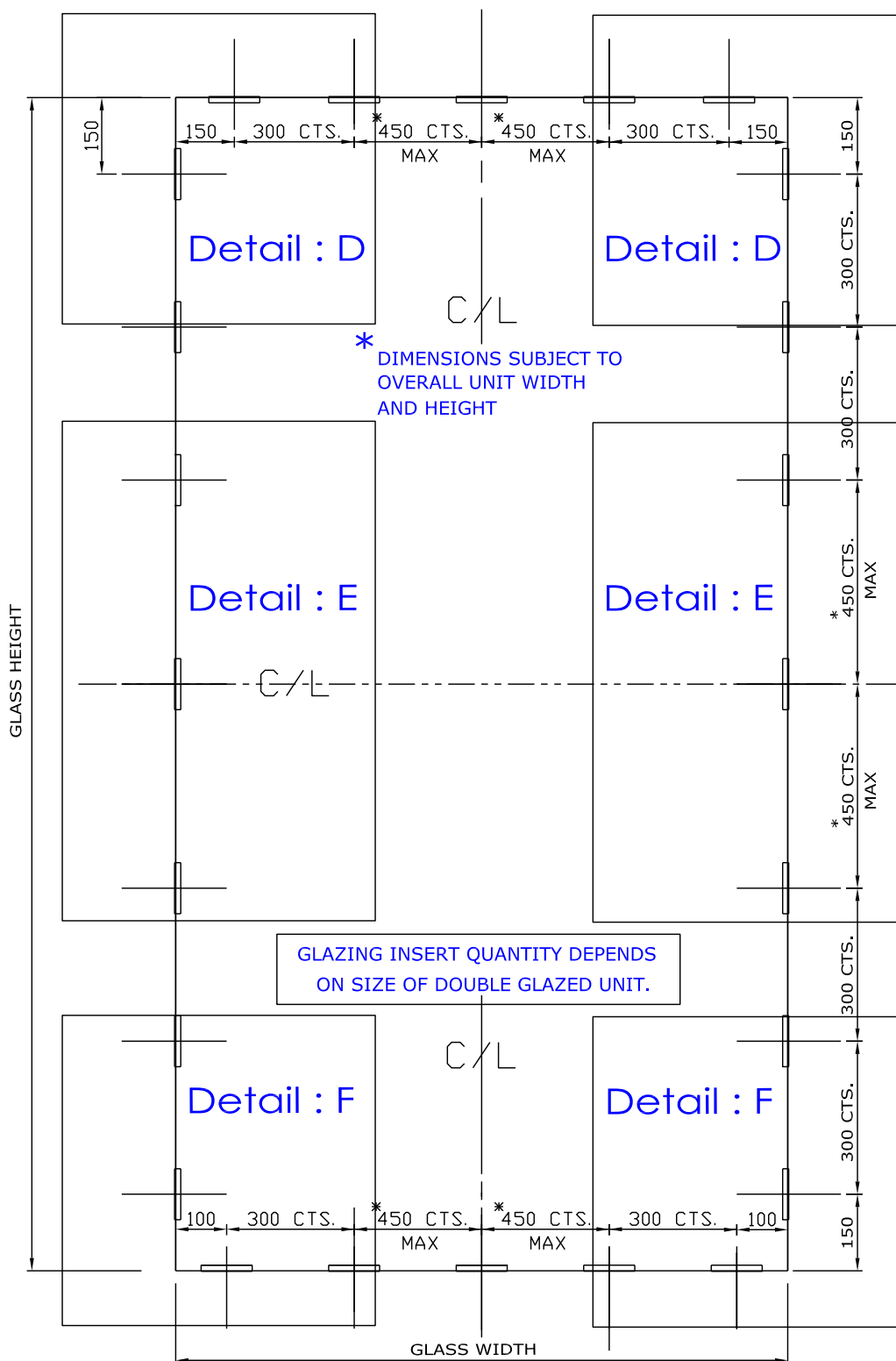
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Location of glazing inserts and fixing clamps



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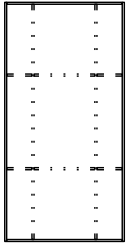
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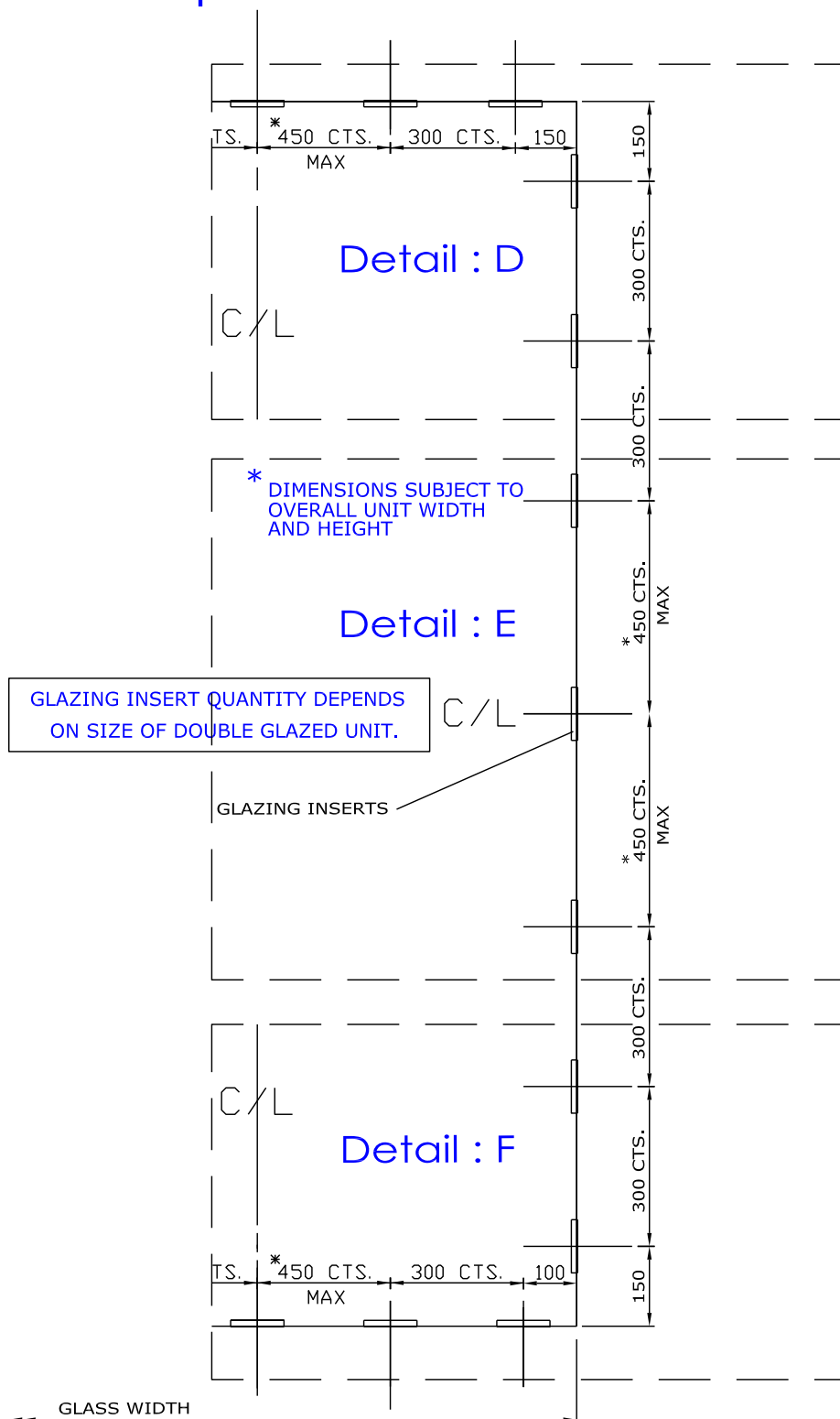
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Spacing of inserts and clamps



6.95

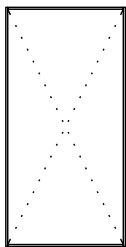


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Future Additions



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