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ARCHITECTURAL ALUMINIUM SYSTEMS

ISO 9001
REGISTERED FIRM

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# CONTENTS

## COMAR 5Pi ECO WINDOW

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# CONTENTS (continued)

## COMAR 5Pi ECO WINDOW

comar5Pi

TITLE

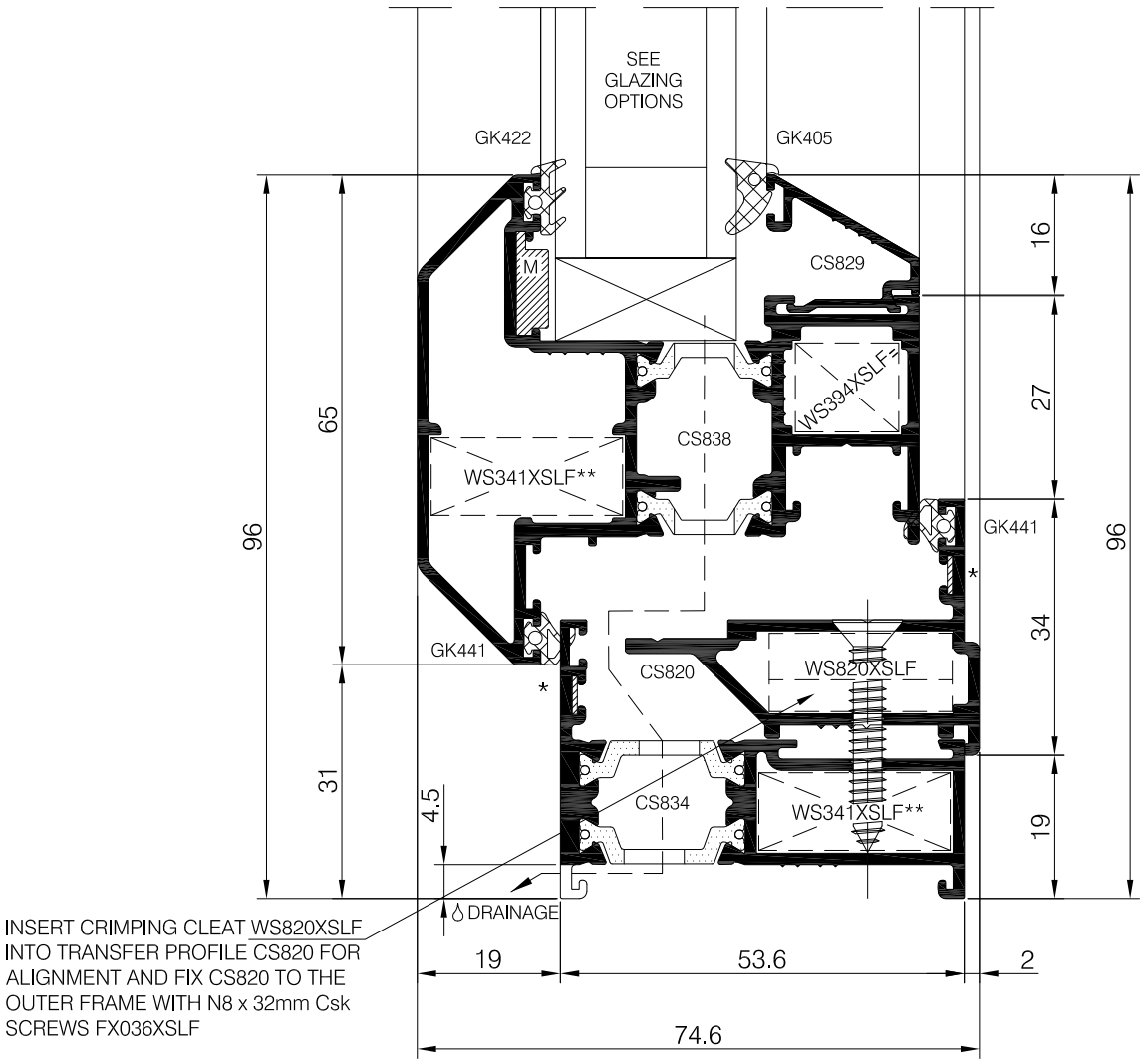
# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

**ECO 3.10**

SUB TITLE

## OPEN OUT CASEMENT WINDOW
## 55mm SILL DETAIL INTERNALLY BEADED WITH TRANSFER PROFILE




| | |
|---|---|
| M DENOTES WS416XSLF | ALIGNMENT SQUARE |
| * DENOTES WS515XSLF | CHEVRON |
| ◊ FOR DRAINAGE DETAIL | SEE DRAINAGE DETAILS PAGES |
| ** OPTIONAL CRIMPING CLEAT | WS846XSLF INSTEAD OF WS341XSLF |
| = OPTIONAL CRIMPING CLEAT | WS847XSLF INSTEAD OF WS394XSLF |

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| | |
|---|---|
| SCALE | 1:1 @ A4 |
| DATE | 31/03/2010 |
| DRAWN | VM/APW |
| DRG. No. | C5-Pi-ECO-3.10 |

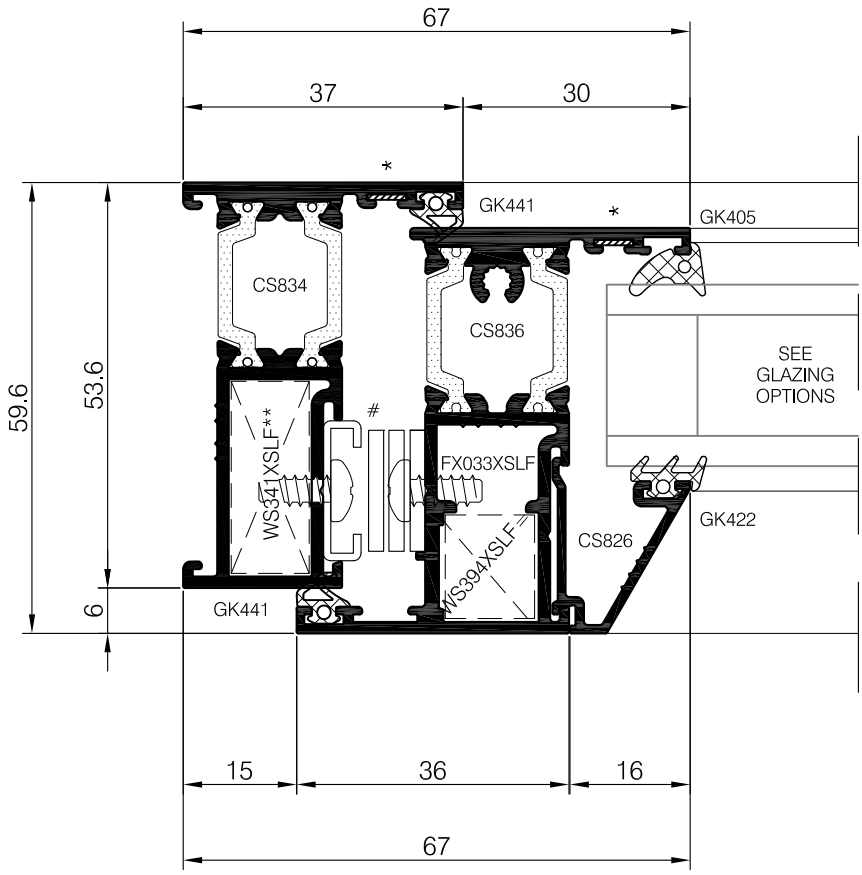
comar5Pi

TITLE
**POLYAMIDE INSULATED WINDOWS**
**ECO 55mm & 75mm WINDOW SYSTEM**

SHEET No.
**ECO 3.11**

SUB TITLE
**OPEN OUT CASEMENT WINDOW**
**55mm JAMB DETAIL VENT EXTERNALLY BEADED**

VENT (FLAT)
COCKSPUR LOCKING




* DENOTES WS515XSLF CHEVRON
** OPTIONAL CRIMPING CLEAT WS846XSLF INSTEAD OF WS341XSLF
= OPTIONAL CRIMPING CLEAT WS847XSLF INSTEAD OF WS394XSLF
\# FOR JIG TOOLING OPTIONS SEE JIG PAGES

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|---|---|
| SCALE | 1:1 @ A4 |
| DATE | 12/08/2013 |
| DRAWN | VM/APW (IS) |
| DRG. No. | C5-Pi-ECO-3.11 R2 |

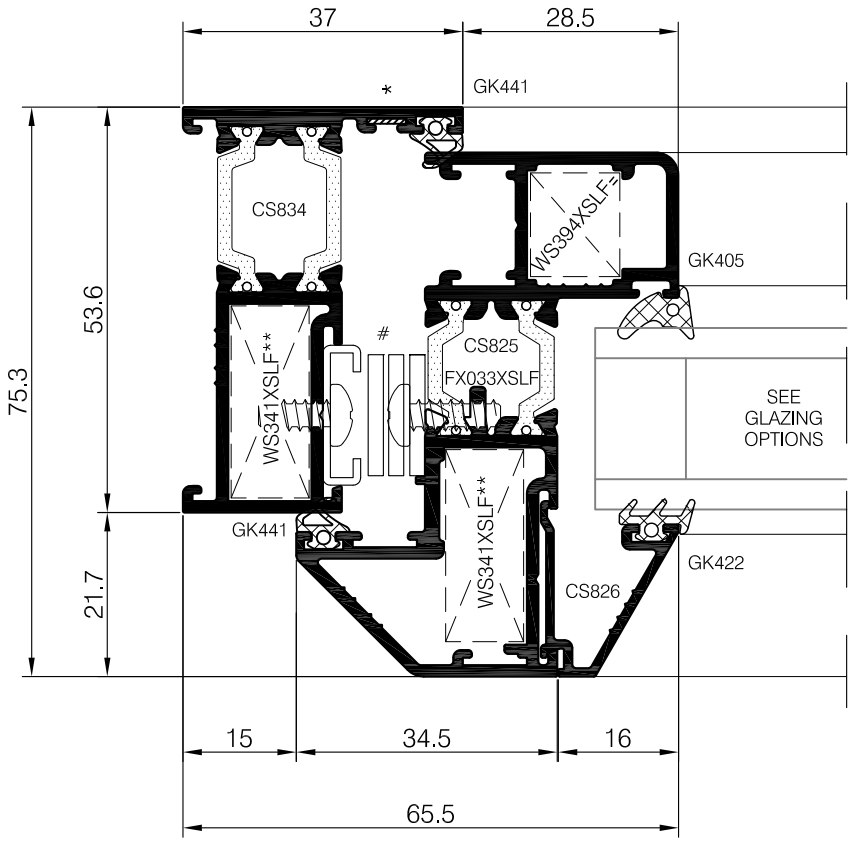
comar5Pi

TITLE
**POLYAMIDE INSULATED WINDOWS**
**ECO 55mm & 75mm WINDOW SYSTEM**

SHEET No.
**ECO 3.12**

SUB TITLE
**OPEN OUT CASEMENT WINDOW**
**55mm JAMB DETAIL VENT EXTERNALLY BEADED**

VENT (FEATURE)
SHOOTBOLT & COCKSPUR LOCKING




* DENOTES WS515XSLF CHEVRON
** OPTIONAL CRIMPING CLEAT WS846XSLF INSTEAD OF WS341XSLF
= OPTIONAL CRIMPING CLEAT WS847XSLF INSTEAD OF WS394XSLF
# FOR JIG TOOLING OPTIONS SEE JIG PAGES

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| DRAWN | VM/APW (IS) |
| DRG. No. | C5-Pi-ECO-3.12 R2 |

comar5Pi

TITLE

# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

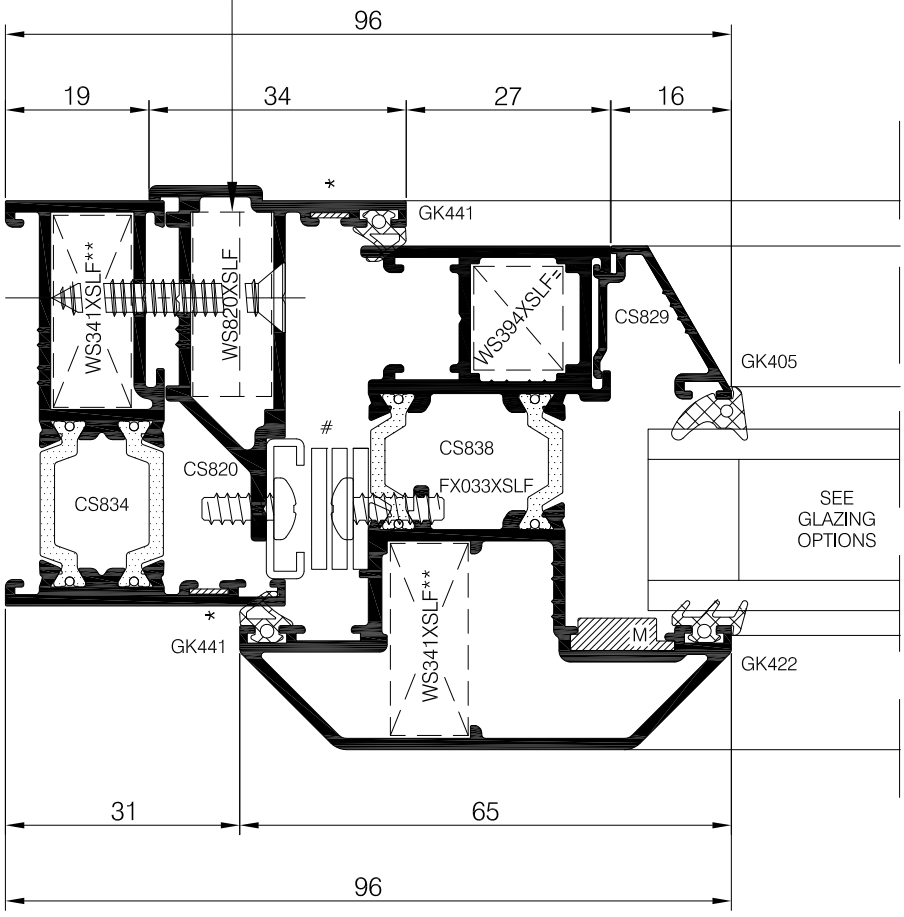
SHEET No.

**ECO 3.13**

SUB TITLE

## OPEN OUT CASEMENT WINDOW
## 55mm JAMB DETAIL INTERNALLY BEADED WITH TRANSFER PROFILE

INSERT CRIMPING CLEAT WS820XSLF INTO TRANSFER PROFILE CS820 FOR ALIGNMENT AND FIX CS820 TO THE OUTER FRAME WITH N8 x 32mm Csk SCREWS




M DENOTES WS416XSLF ALIGNMENT SQUARE
* DENOTES WS515XSLF CHEVRON
** OPTIONAL CRIMPING CLEAT WS846XSLF INSTEAD OF WS341XSLF
= OPTIONAL CRIMPING CLEAT WS847XSLF INSTEAD OF WS394XSLF
# FOR JIG TOOLING OPTIONS SEE JIG PAGES

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| DATE | 12/08/2013 |
| DRAWN | VM/APW (IS) |
| DRG. No. | C5-Pi-ECO-3.13 R2 |

comar5Pi

TITLE

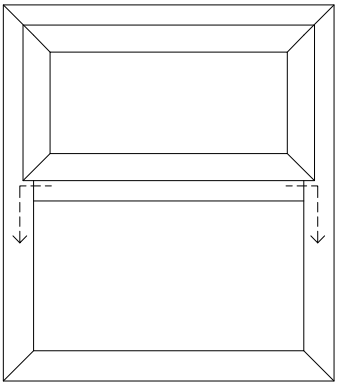
# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

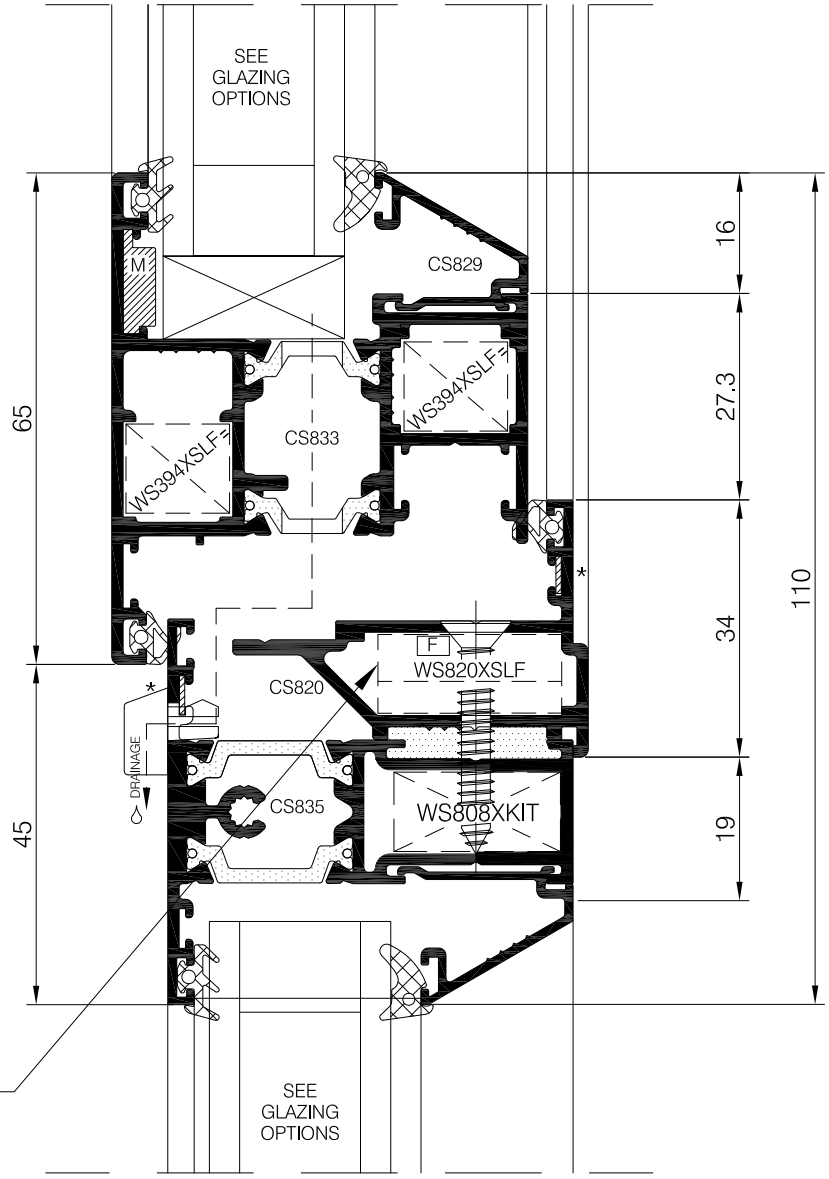
**ECO 3.22**

SUB TITLE

## OPEN OUT CASEMENT WINDOW
## 55mm TRANSOM DETAIL INT. BEADED VENT WITH TRANSFER PROFILE



DRAINAGE SHOWN IS OPTIONAL.
DRAIN TO TRANSOM ENDS IS STANDARD.




INSERT CRIMPING CLEAT WS820XSLF INTO TRANSFER PROFILE CS820 FOR ALIGNMENT AND FIX CS820 TO THE OUTER FRAME WITH CSK SCREWS N8 x 32mm FX036XSLF

M DENOTES WS416XSLF
* DENOTES WS515
◊ FOR DRAINAGE DETAIL
= OPTIONAL CRIMPING CLEAT

ALIGNMENT SQUARE
CHEVRON
SEE DRAINAGE DETAIL PAGES
WS847XSLF INSTEAD OF WS394XSLF

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| SCALE | 1:1 @ A4 |
| DATE | 12/08/2013 |
| DRAWN | VM/DGN |
| DRG. No. | C5-Pi-ECO-3.22 R1 |

comar5Pi

TITLE

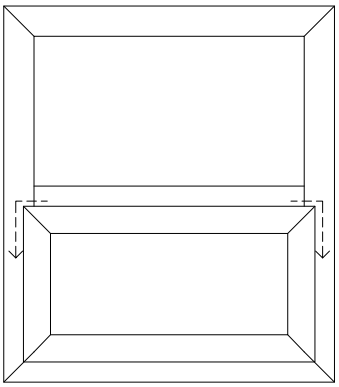
# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

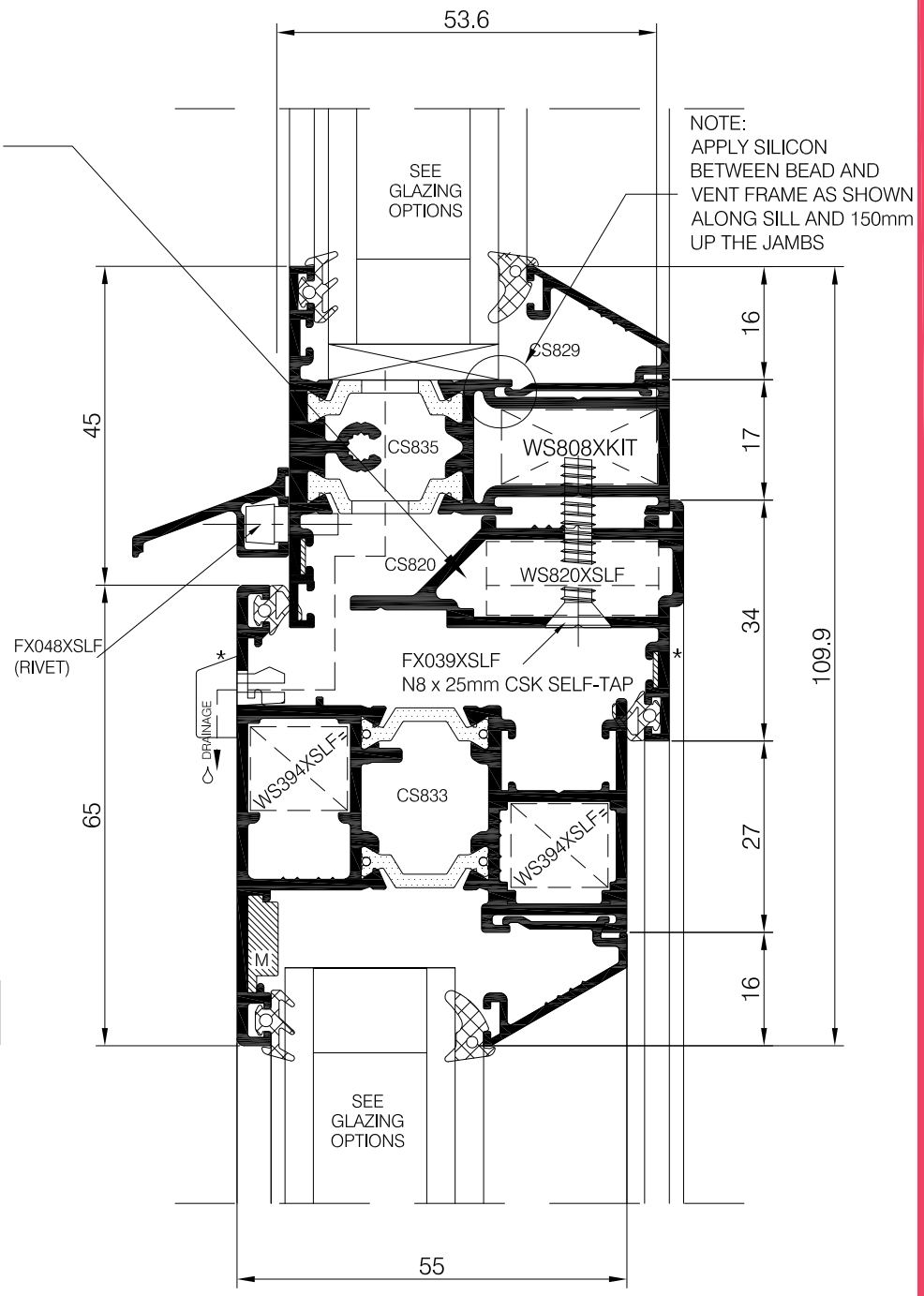
**ECO 3.23**

SUB TITLE

## OPEN OUT CASEMENT WINDOW
## 55mm TRANSOM DETAIL INT. BEADED VENT WITH TRANSFER PROFILE



DRAINAGE SHOWN IS OPTIONAL.
DRAINTO PROFILE ENDS IS STANDARD.




M DENOTES WS416XSLF
* DENOTES WS515
◊ FOR DRAINAGE DETAIL
= OPTIONAL CRIMPING CLEAT

ALIGNMENT SQUARE CHEVRON
SEE DRAINAGE DETAIL PAGES
WS847XSLF INSTEAD OF WS394XSLF

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| DRAWN | VM/DGN |
| DRG. No. | C5-Pi-ECO-3.23 R1 |

comar5Pi

TITLE

# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & ECO 75mm WINDOW SYSTEM

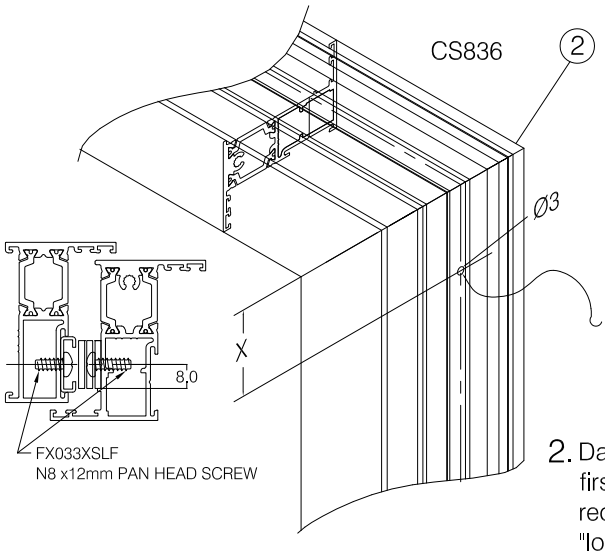
SHEET No.

**ECO 5.18**

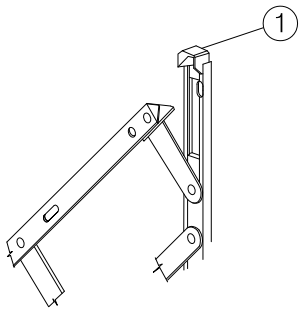
SUB TITLE

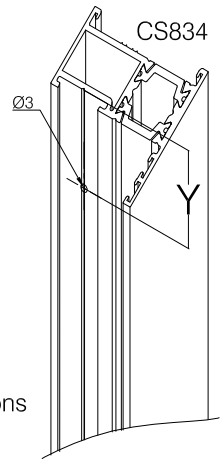
**OPEN OUT CASEMENT- PREPARATION AND ASSEMBLY**
**PROJECTED MULTI-LIGHT WITH EXTERNAL GLAZING BEADS**

## PROFILE PREPARATION




1. Datum for hinge fixing to outer frame. For 'X' & 'Y' dimensions see tables below.




2. Datum for hinge fixing to sash. Mark hole positions first, drill to centre of slots, fit hinge, adjust if required, then drill datum hole and fit screw to "lock" hinge position.

| SECURISTYLE HINGE TYPE | VENT HOLE POSITION 'X' |
|---|---|
| 12" SH R & NR | 24 |
| 16" SH NR | 24 |
| 16" SH R | 24 |
| 12" TH R | 24 |
| 16" - 24" TH R | 24 |
| 8" - 24" TH NR | 24 |
| EASY CLEAN | 24 |

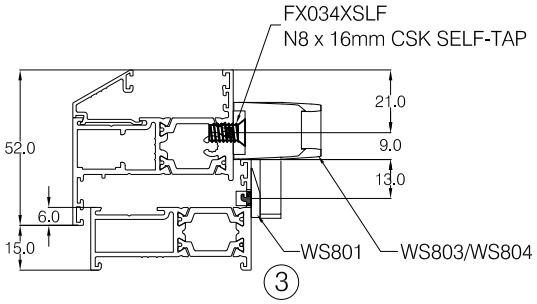
| SECURISTYLE HINGE TYPE | OUTER FRAME HOLE POSITION 'Y' |
|---|---|
| ALL TYPES | 30 |
| HEAVY DUTY | 30 |
| EASY CLEAN | 30 |

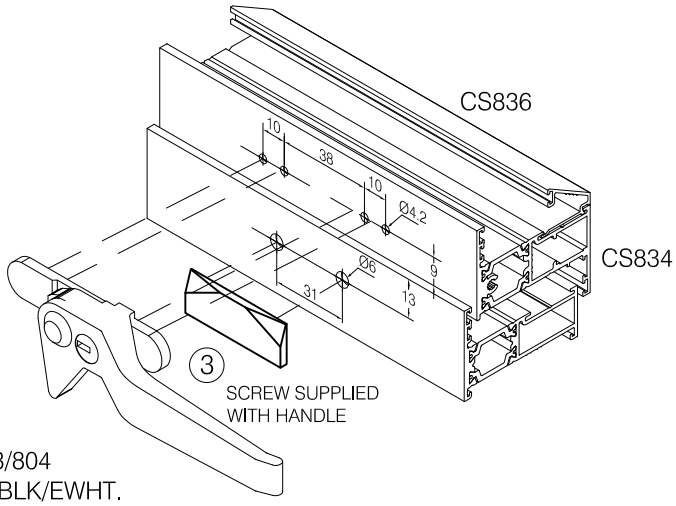
Drilling positions for Comar Friction Hinges (SECURISTYLE). Jigs available from Comar Ref. COM5-JIG9.

| COTSWOLD HINGE TYPE | VENT HOLE POSITION 'X' |
|---|---|
| 12" SH R & NR | 32.6 |
| 16" SH NR | 32.6 |
| 16" SH R | 36.2 |
| 12" TH R | 32.6 |
| 16" - 24" TH R | 36.2 |
| 8" - 24" TH NR | 36.2 |
| EASY CLEAN | 20.8 |

| COTSWOLD HINGE TYPE | OUTER FRAME HOLE POSITION 'Y' |
|---|---|
| ALL TYPES | 15.5 |
| HEAVY DUTY | 36.5 |
| EASY CLEAN | 31.3 |

Drilling positions for NON-STOCK Friction Hinges (COTSWOLD). Jigs available on request Ref. COM5-JIG3.




3. Preparation for Cockspur handle WS803/804 BSVR/EWHT and 3mm wedge WS801DBLK/EWHT.

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| DATE | 12-08-2013 |
| DRAWN | VM / SA (IS) |
| DRG. No. | C5-Pi-ECO 5.18 R3 |

comar5Pi

TITLE

# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & ECO 75mm WINDOW SYSTEM

SHEET No.

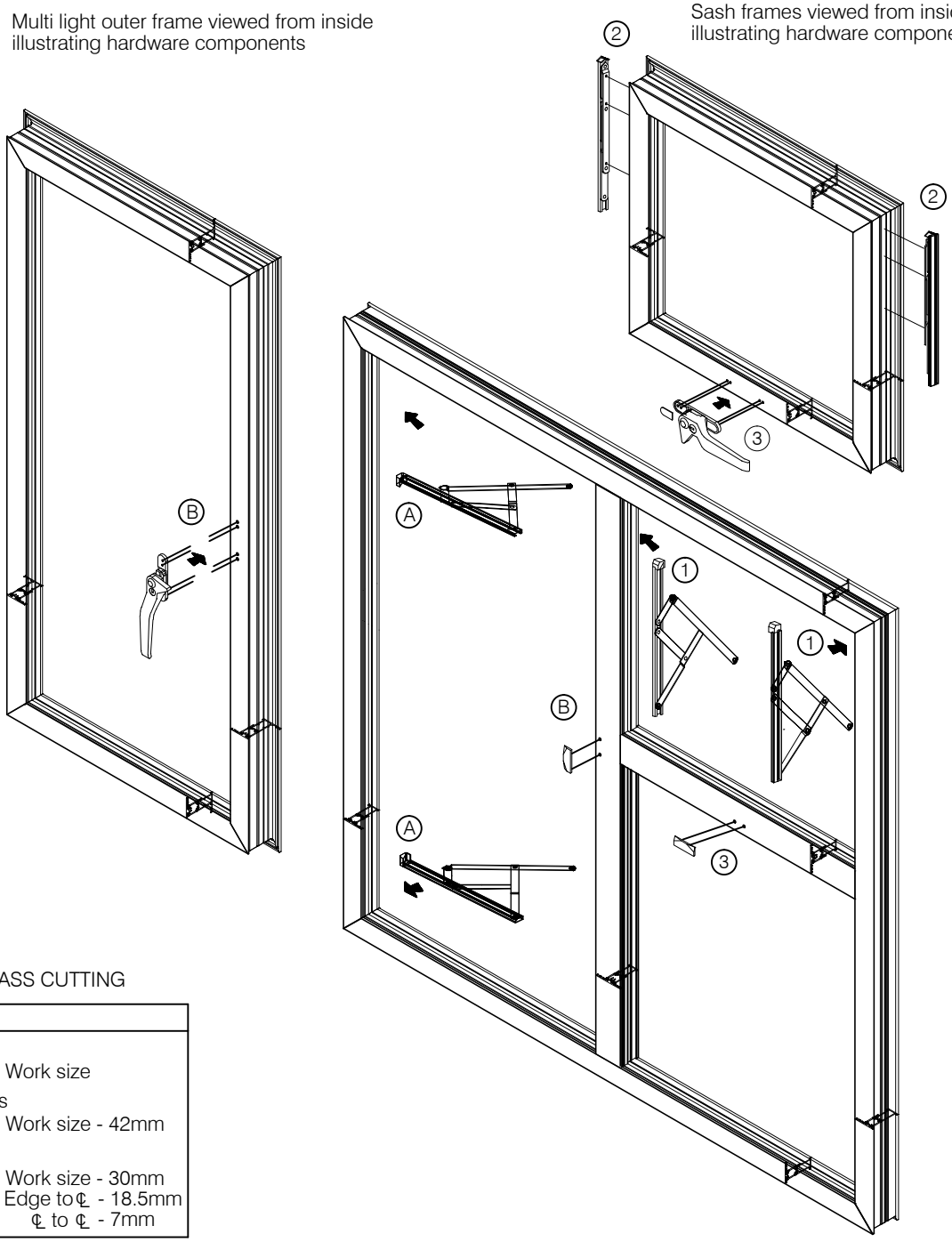
**ECO 5.18.1**

SUB TITLE

## OPEN OUT CASEMENT- PREPARATION AND ASSEMBLY
## PROJECTED MULTI-LIGHT WITH EXTERNAL GLAZING BEADS

Multi light outer frame viewed from inside illustrating hardware components

Sash frames viewed from inside illustrating hardware components.




PROFILE AND GLASS CUTTING

| PROFILES | |
|---|---|
| Outer Frames | |
| Cut to | Work size |
| Mullions/transoms | |
| Cut to | Work size - 42mm |
| Sash size | |
| Mitre cut to | Work size - 30mm |
| or | Edge to ℄ - 18.5mm |
| or | ℄ to ℄ - 7mm |

| GLASS | |
|---|---|
| Sash Glass | |
| Cut to | Sash size - 82mm |

Note:
Items A & B are side projected window option details.

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| SCALE | NTS @ A4 |
| DATE | 05-04-2013 |
| DRAWN | VM / SA |
| DRG. No. | C5-EC-FL 5.18.1 |

comar5Pi

TITLE

# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & ECO 75mm WINDOW SYSTEM

SHEET No.

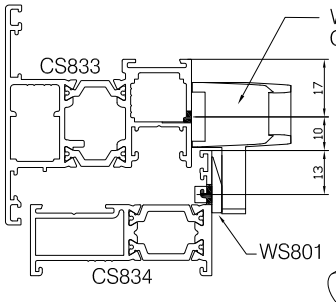
**ECO 5.19**

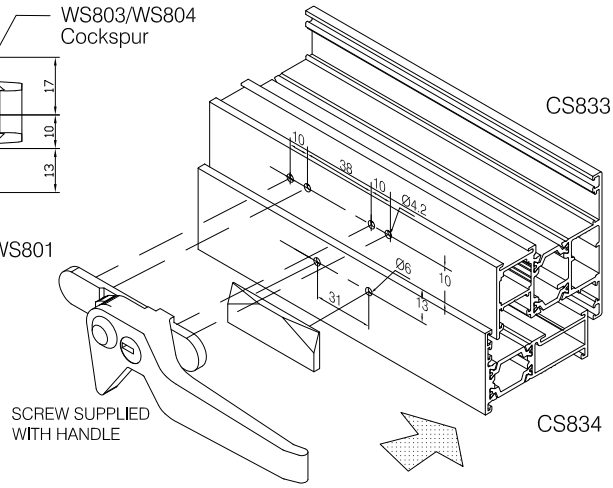
SUB TITLE

## OPEN OUT CASEMENT- PREPARATION AND ASSEMBLY
## PROJECTED VENT WITH INTERNAL BEADS

| Profiles | |
|---|---|
| Outer Frames<br>Cut to | Work size |
| Sash size<br>Mitre cut to | Work size - 30mm |

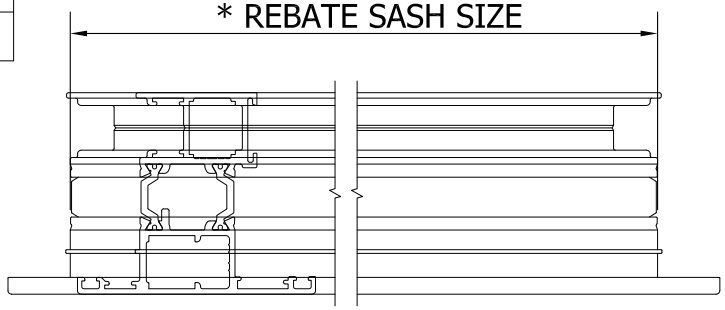
| Glass | |
|---|---|
| Sash Glass<br>Cut to | Sash size - 108mm |

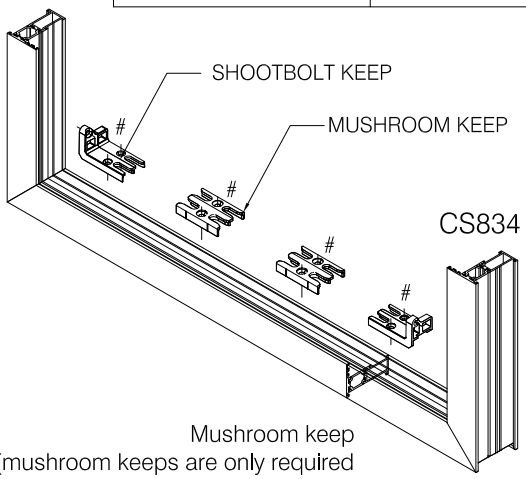


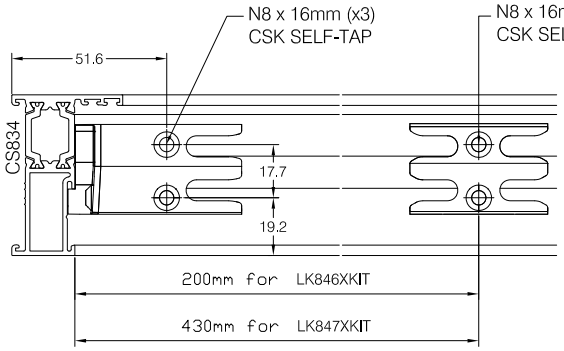

Preparation for Cockspur handle WS803/804 and 3mm wedge WS801.

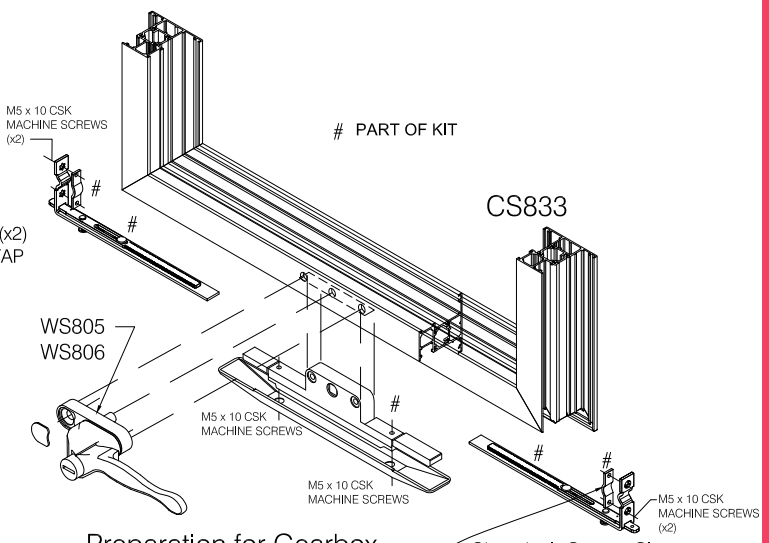
| LOCKING KIT | * REBATE SASH SIZE |
|---|---|
| LK843XKIT | 270 mm - 361 mm |
| LK844XKIT | 362 mm - 520 mm |
| LK845XKIT | 521 mm - 820 mm |
| LK846XKIT | 821 mm - 1120 mm |
| LK847XKIT | 1121mm - 1420 mm |




Mushroom keep
(mushroom keeps are only required for vents width ≥ 821 mm)




Preparation for Gearbox
Page Ref. 5.21

Shootbolt Corner Clamp
(Insert into vent profile prior to corner crimp)

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| DATE | 12-08-2013 |
| DRAWN | VM / SA |
| DRG. No. | C5-Pi-ECO 5.19 R4 |

comar5Pi

TITLE

# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

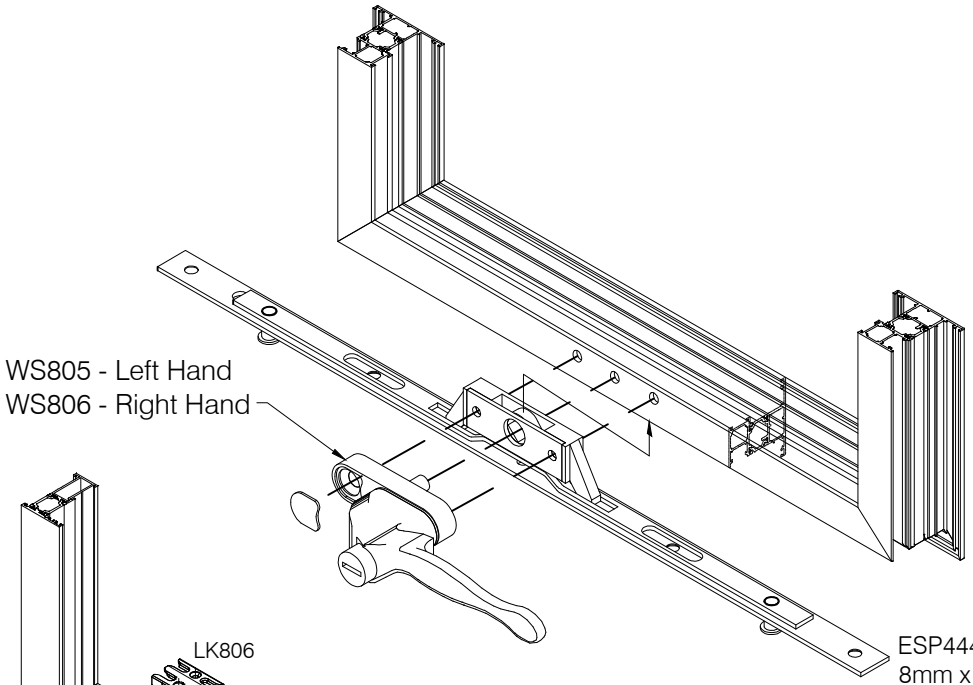
**ECO 5.20**

SUB TITLE

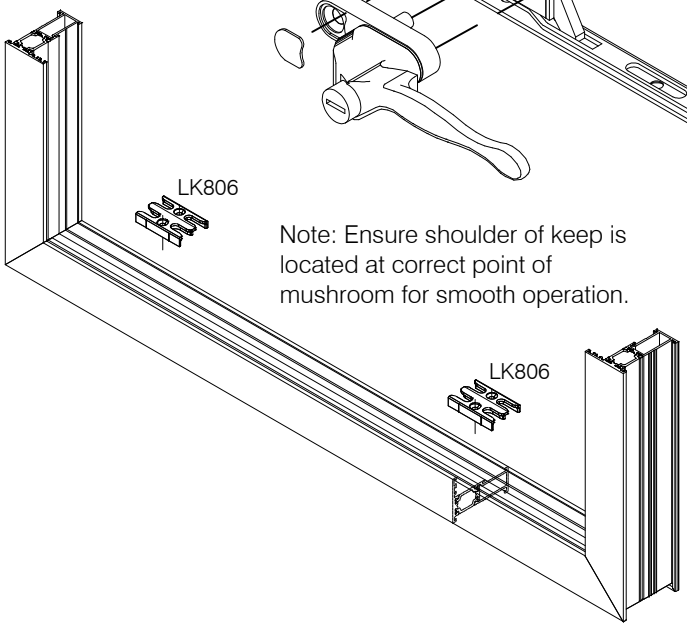
**OPEN OUT CASEMENT - PREPARATION AND ASSEMBLY**
**PROJECTED VENT WITH INTERNAL BEADS AND ESPAGNOL LOCKING**

## ESPAGNOL LOCKING RODS

| LOCK PART NUMBER | DESCRIPTION |
|---|---|
| ESP442XSLP | 8mm x 250mm |
| ESP444XSLP | 8mm x 400mm |
| ESP446XSLP | 8mm x 600mm |
| ESP448XSLP | 8mm x 800mm |
| ESP440XSLP | 8mm x 1000mm |

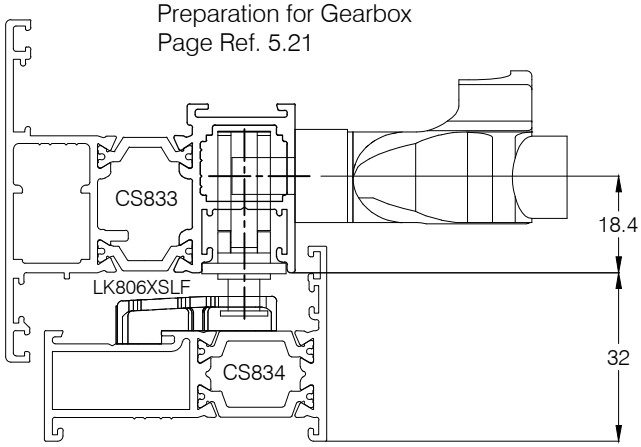


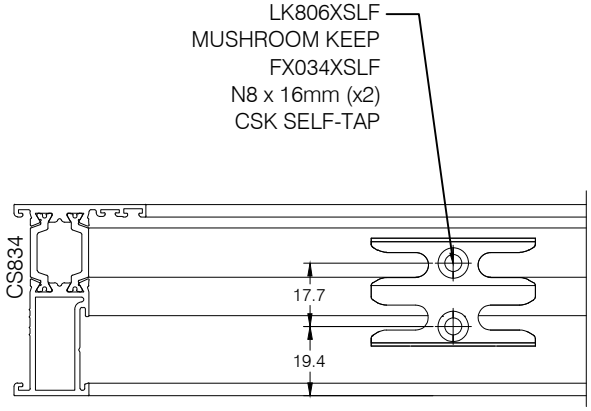

ESP444XSLP
8mm x 400mm Espag Lock

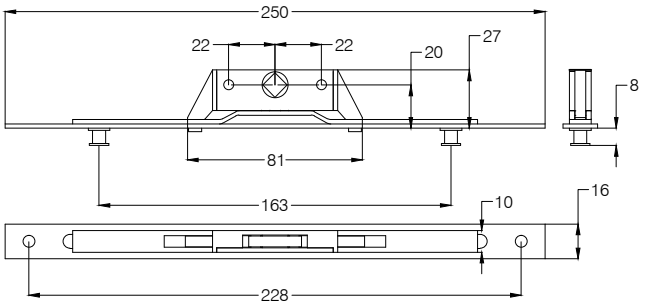



Note: Ensure shoulder of keep is located at correct point of mushroom for smooth operation.

Preparation for Gearbox
Page Ref. 5.21




ESP442XSLP ( 8mm x 250mmEspag Lock )

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| SCALE | N T S @ A4 |
| DATE | 05/04/13 |
| DRAWN | GMS (SA) |
| DRG. No. | C5-Pi-ECO-5.20 R2 |

comar5Pi

TITLE

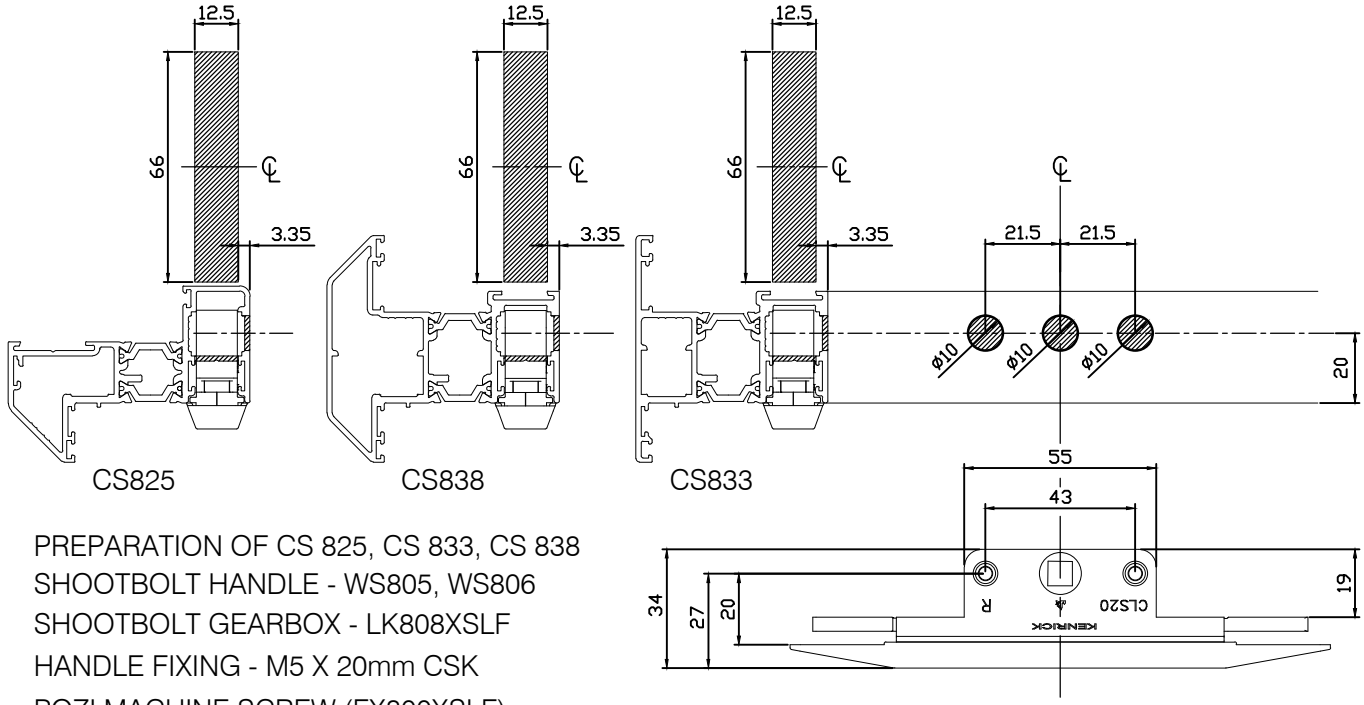
# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

**ECO 5.21**

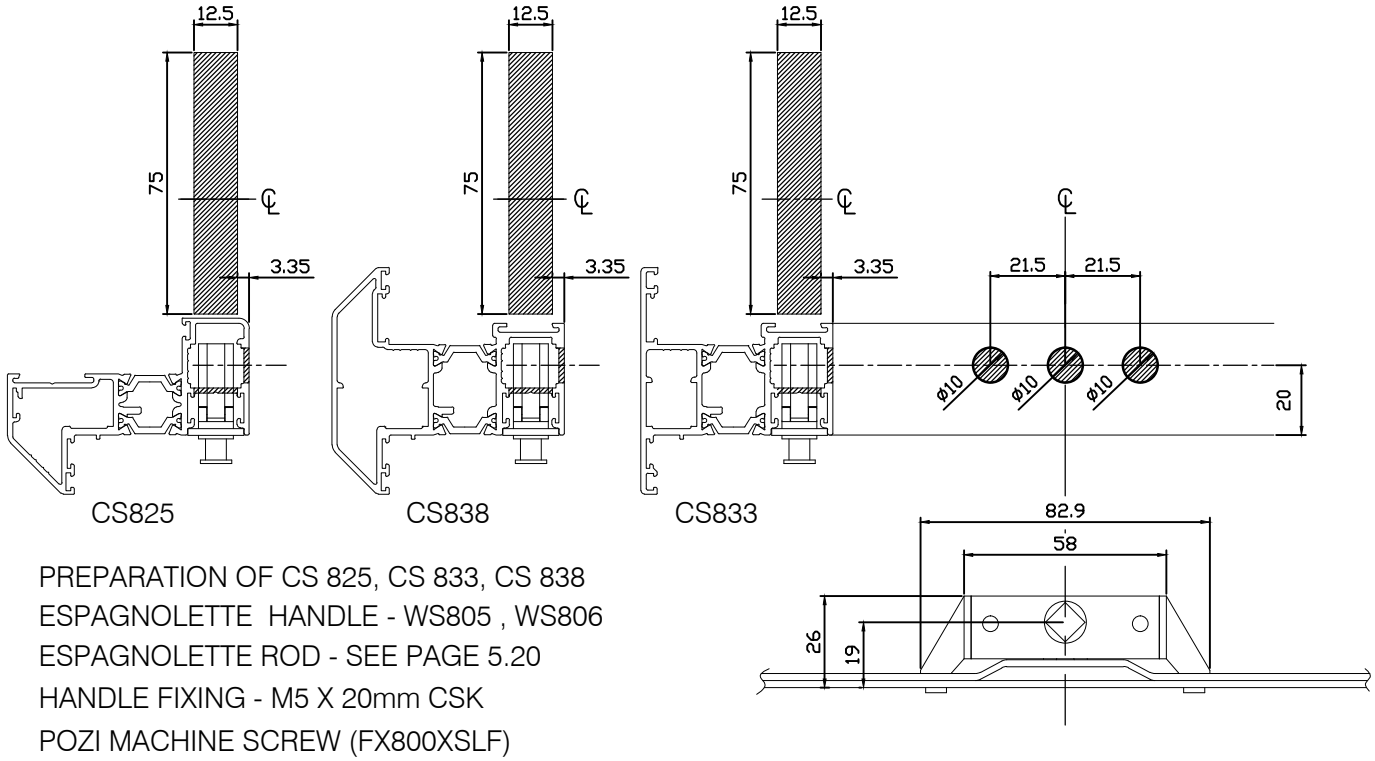
SUB TITLE

## PREPARATION OF VENTS FOR SHOOTBOLT & ESPAG HANDLE GEAR
## PROJECTED OPEN OUT VENT WITH INTERNAL BEADS




CS825 CS838 CS833

PREPARATION OF CS 825, CS 833, CS 838
SHOOTBOLT HANDLE - WS805, WS806
SHOOTBOLT GEARBOX - LK808XSLF
HANDLE FIXING - M5 X 20mm CSK
POZI MACHINE SCREW (FX800XSLF)




CS825 CS838 CS833

PREPARATION OF CS 825, CS 833, CS 838
ESPAGNOLETTE HANDLE - WS805 , WS806
ESPAGNOLETTE ROD - SEE PAGE 5.20
HANDLE FIXING - M5 X 20mm CSK
POZI MACHINE SCREW (FX800XSLF)

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| DATE | 10/04/2013 |
| DRAWN | GMS (SA) |
| DRG. No. | C5-Pi-ECO-5.21 R1 |

comar5Pi

TITLE

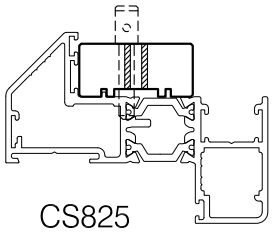
# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

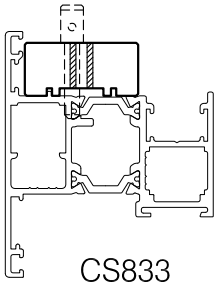
**ECO 5.22**

SUB TITLE

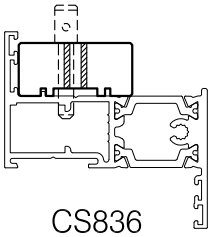
## COTSWOLD FRICTION HINGE FIXING
## COM5-JIG3 TOOLING OPTION



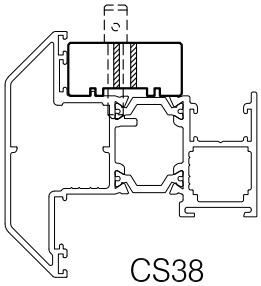
CS825



CS833

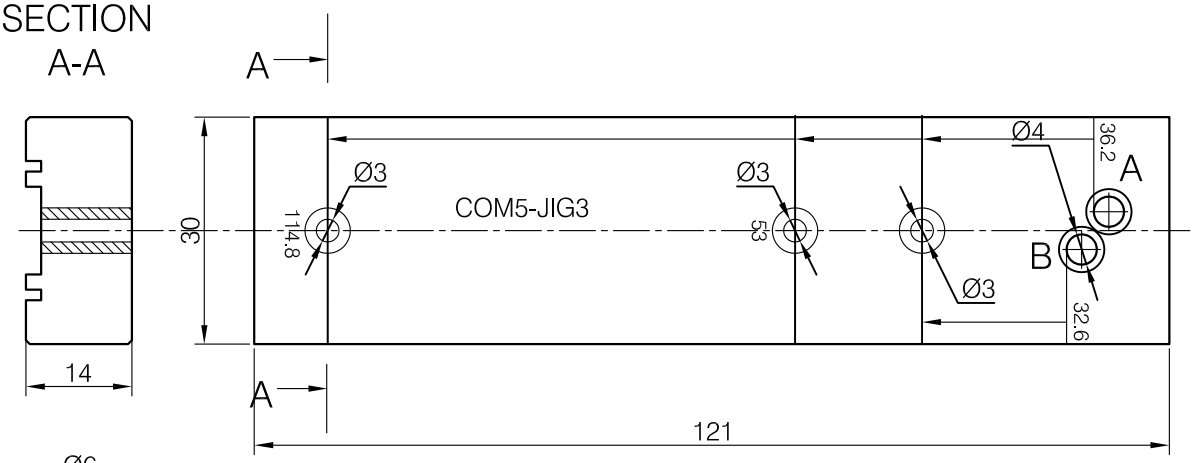


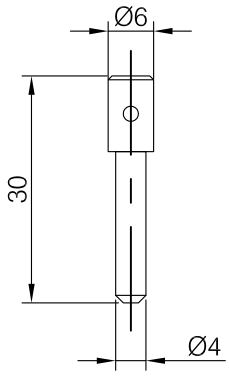
CS836



CS38

SECTION
A-A



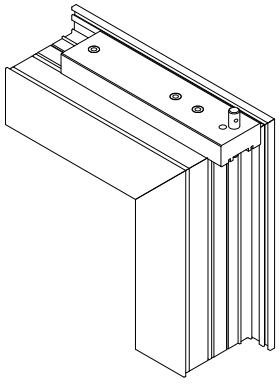



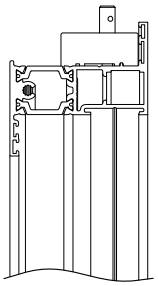

| HOLE GUIDE | | | |
|---|---|---|---|
| 12" SH R & NR | - 32.6 + 114.8 | 12" TH R | - 32.6 + 114.8 |
| 16" SH NR | - 32.6 + 53 | 16" - 24 " TH R | - 36.2 + 53 |
| 16" SH R | - 36.2 + 53 | 8" - 24" TH NR | - 36.2 + 53 |

USE Ø3mm HSS DRILL.

FOR THE POSITION 32.6 INSERT PIN INTO THE HOLE B.

FOR THE POSITIONS 36.2; 53; 114.8 INSERT PIN INTO THE HOLE A.





CS836

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| SCALE | NTS @ A4 |
| DATE | 12/08/2013 |
| DRAWN | VM/OP (IS) |
| DRG. No. | C5-Pi-ECO-5.22 |

comar5Pi

TITLE

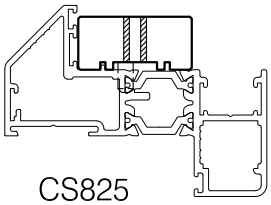
# POLYAMIDE INSULATED WINDOWS
# ECO 55mm & 75mm WINDOW SYSTEM

SHEET No.

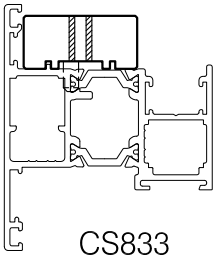
**ECO 5.22.1**

SUB TITLE

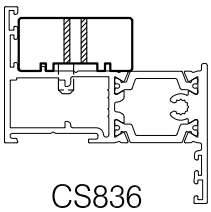
## SECURISTYLE FRICTION HINGE FIXING
## COM5-JIG9 TOOLING OPTION



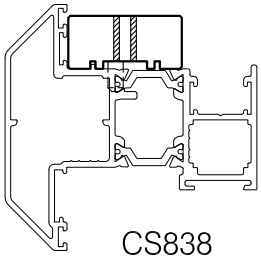
CS825



CS833

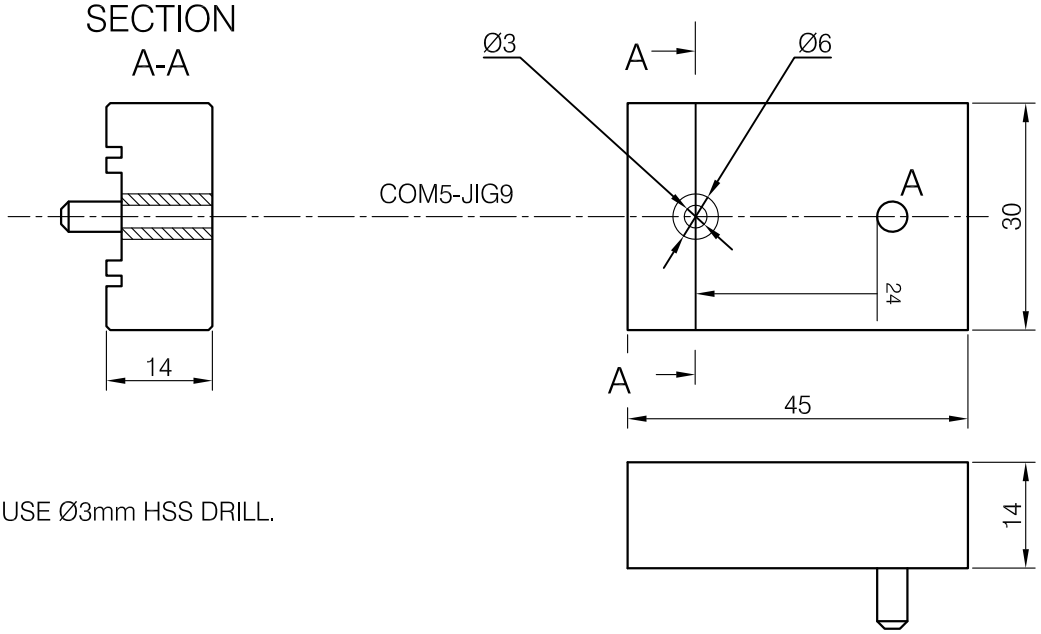


CS836

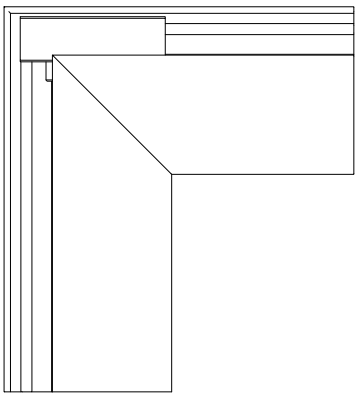


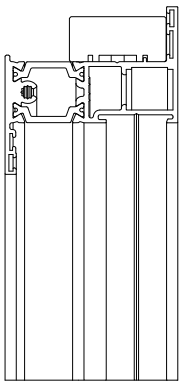
CS838

SECTION
A-A

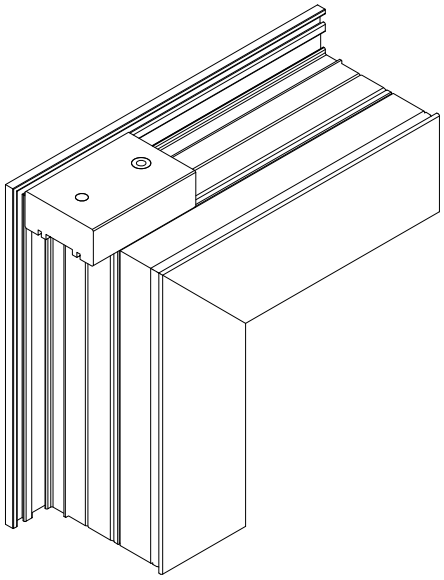



USE Ø3mm HSS DRILL.





CS836



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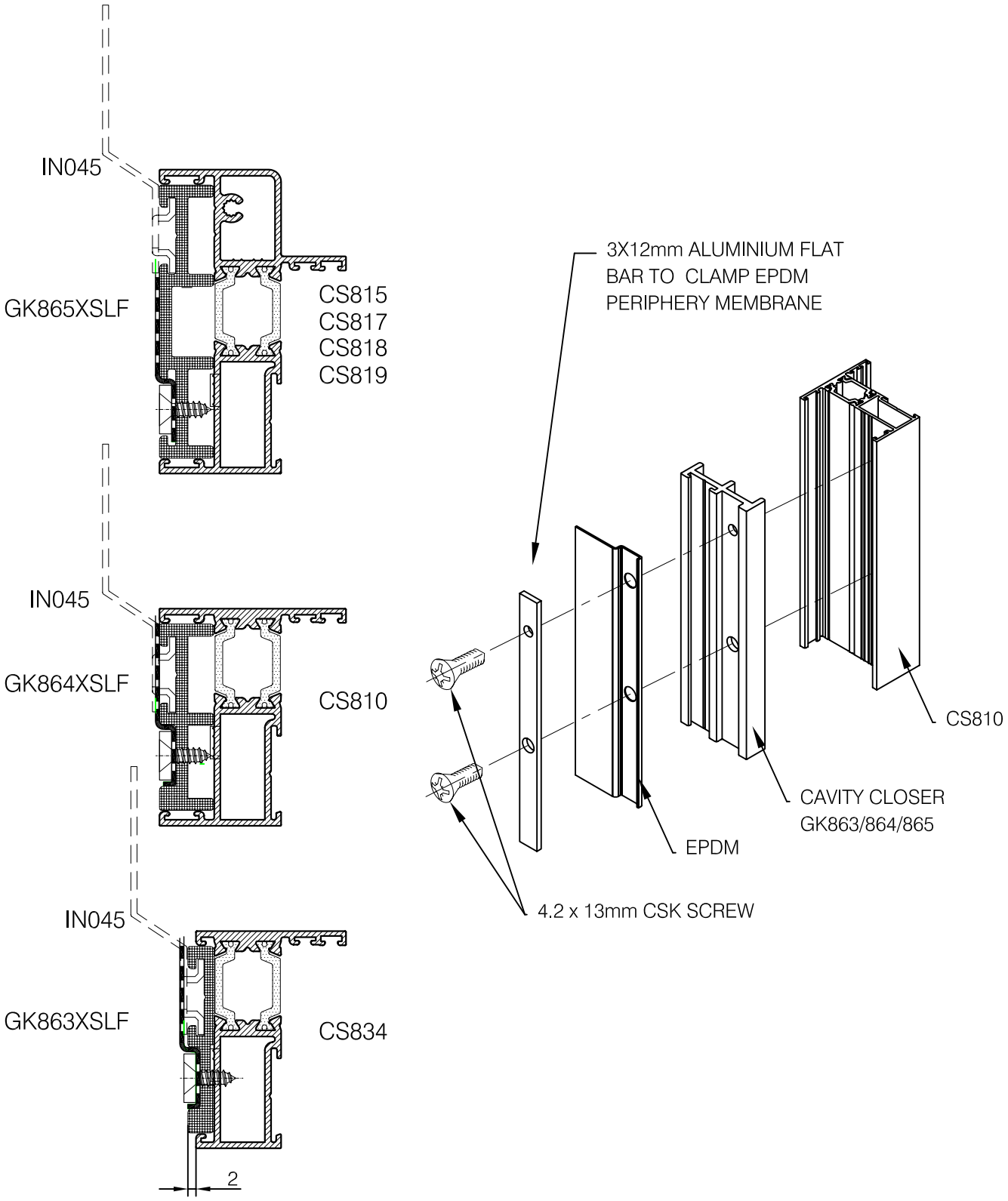
| DATE | 12/08/2013 |
| DRAWN | SA (IS) |
| DRG. No. | C5-Pi-ECO-5.22.1 |

comar5Pi

TITLE
**POLYAMIDE INSULATED WINDOWS**
**COMAR 5 Pi ECO WINDOW SYSTEM**

SHEET No.
**ECO 5.23**

SUB TITLE
**CAVITY CLOSER**
**FIXING DETAILS**

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| DATE | 31/03/2010 |
| DRAWN | VM/OP |
| DRG. No. | C5-Pi-ECO-5.23 |

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TITLE

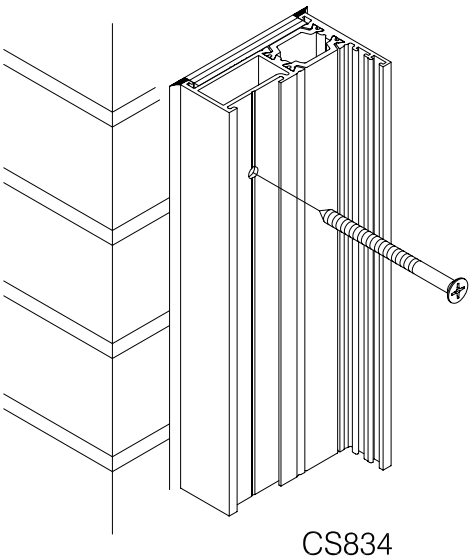
# POLYAMIDE INSULATED WINDOWS
# COMAR 5 Pi ECO WINDOW SYSTEM

SHEET No.

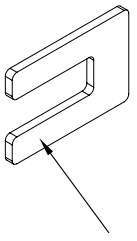
**ECO 5.24**

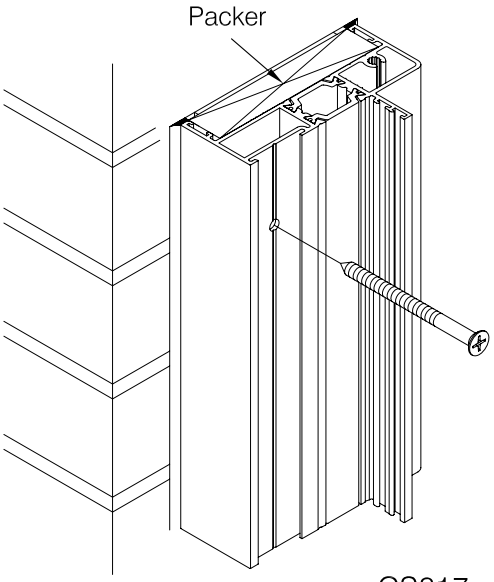
SUB TITLE

## FIXING DETAILS
## DIRECT FIXING TO MASONRY



CS834



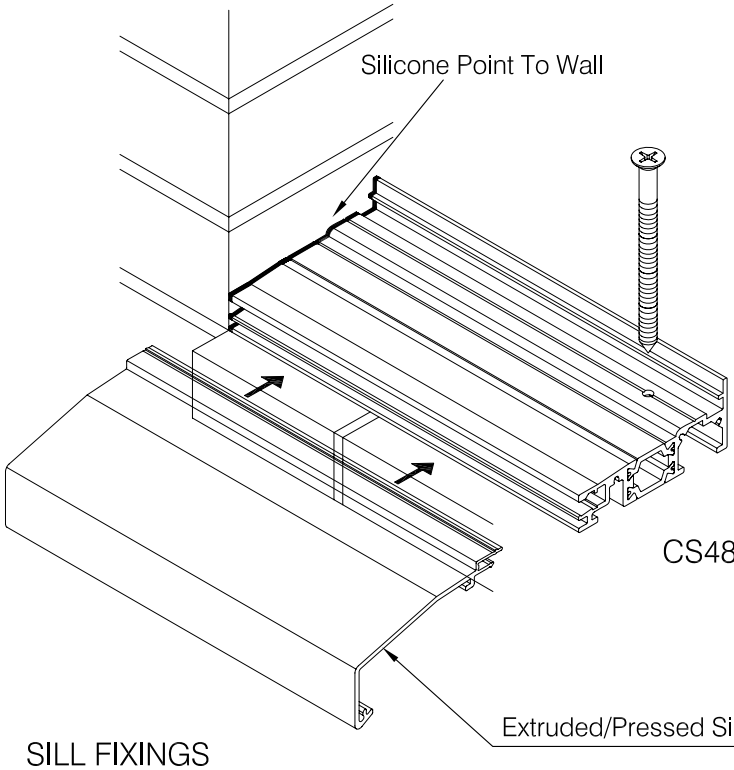




CS817

DIRECT FIXING TO MASONRY.

Use suitable fixings positioned no less than 100mm from corners/joints and not more than 600mm apart.

Spacer shims must be used between the frame and masonry to prevent profile distortion.




CS484/CS485

SILL FIXINGS

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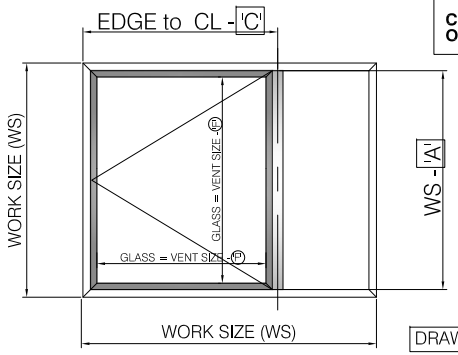
**POLYAMIDE INSULATED WINDOWS**
**ECO 55mm & 75mm WINDOW SYSTEM**

SHEET No. **ECO 5.25**

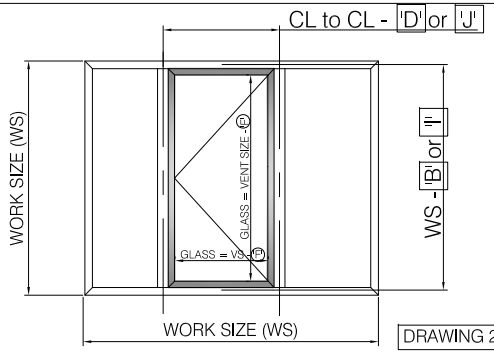
**CUTTING LIST**
**OUTER FRAME, MULLIOM/TRANSOMS, GLASS SIZES**

## MULLION/TRANSOM LENGTH

| | OUTER FRAME | WORK SIZE - 'A' (DRAWING 1) | | | | | |
|---|---|---|---|---|---|---|---|
| | | CS834 | CS810 | CS815 | CS817 | CS818 | CS819 |
| | | 'A' | 'A' | 'A' | 'A' | 'A' | 'A' |
| TRANSOM PROFILES | CS835 | -42 | -60 | -60 | -60 | -60 | -60 |
| | CS832 | -42 | -60 | -60 | -60 | -60 | -60 |
| | CS821 | - | - | - | -60 | -54 | - |
| | CS822 | - | - | -35 | - | - | -60 |




DRAWING 1

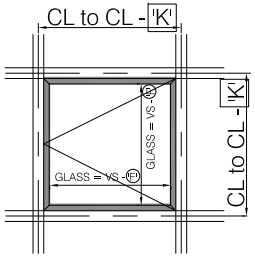



DRAWING 2

## VENT CUTTING OPTIONS & GLASS SIZES

DRAWING 1, 2 & 3

| | OUTER FRAME | WORK SIZE - 'B' | | EDGE TO ℄ - 'C' | | | | ℄ TO ℄ - 'D' | | WORK SIZE - 'I' | | ℄ TO ℄ - 'J' | | ℄ TO ℄ - 'K' | GLASS SIZE |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | CS834 | CS810,815, 817,818,819 | CS834 | | CS810,815, 817,818,819 | | | | CS834 | CS810,815, 817,818,819 | WITH TRANSFER CS 820 | | CURTAIN WALL INSERT CS813 | VENT SIZE (VS) - (F) |
| | TRANSOM/MULLION | | | CS835 | CS832,822, 821 | CS835 | CS832,822, 821 | CS835 | CS832,822, 821 | WITH TRANSFER CS 820 | | CS835 | CS832,822, 821 | | |
| VENT PROFILES | CS836 | -30 | -48 | -18.5 | -21.5 | -27.5 | -30.5 | -7 | -13 | -62 | -80 | -38.5 | -44.5 | -91.5 | -82 |
| | CS833 | | | | | | | | | | | | | | -108 |
| | CS825 | | | | | | | | | | | | | | -79 |
| | CS838 | | | | | | | | | | | | | | -108 |
| | CS820 | | | | | | | | | -38 | -56 | -14.5 | -20.5 | | |
| | CS813 | | | | | | | | | | | | | -19.5 | -36 x 2 |

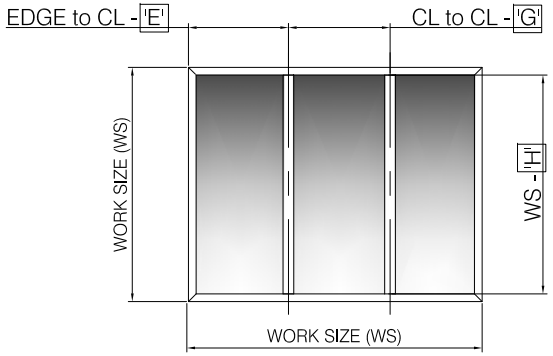



DRAWING 3

## FIXED LIGHT GLASS SIZES

DRAWING 4

| | TRANSOM/MULLION | WORK SIZE - 'H' | EDGE TO ℄ - 'E' | | ℄ TO ℄ - 'G' | |
|---|---|---|---|---|---|---|
| | | | CS835 | CS332,822, 821 | CS835 | CS332,822, 821 |
| OUTER FRAME | CS834 | -52 | -40.5 | -43.5 | -29 | -35 |
| | CS810, 815, 817, 818,819 | -70 | -49.5 | -52.5 | | |




DRAWING 4

### DENOTES:

OUTER FRAME CUT TO WORK SIZE

MULLION/TRANSOMS - WORK SIZE - 'A'

VENT SIZE CUT TO:
1) WORK SIZE - 'B' OR
WS - 'I' (with vent transfer CS820)
2) EDGE TO ℄ - 'C'
3) ℄ TO ℄ - 'D' OR
℄ TO ℄ - 'J' (with vent transfer CS820)
℄ TO ℄ - 'K' (with curtain wall insert CS813)

VENT GLASS SIZE:
1) VENT SIZE - 'F'

FIXED LIGHT GLASS SIZE:
1) WORK SIZE - 'H'
2) EDGE TO ℄ - 'E'
3) ℄ TO ℄ - 'G'

GLAZING BEADS:
SEE PAGE 5.24

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| DATE | 31/03/2010 |
| DRAWN | VM / OP |
| DRG. No. | C5-Pi-ECO-5.25 |

comar5Pi

TITLE

# POLYAMIDE INSULATED WINDOWS
# COMAR 5 Pi ECO WINDOW SYSTEM

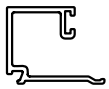
SHEET No.

**ECO 5.26**

SUB TITLE

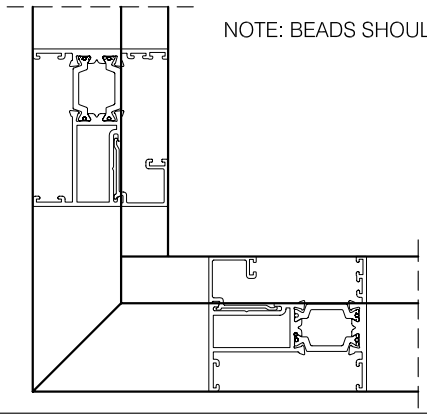
## CUTTING FORMULA
## GLAZING BEADS

28mm



**CS823**
BEAD
EXTERNAL
GLAZED VENT

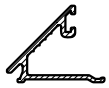
**CS824**
BEAD
INTERNAL
GLAZED VENT



NOTE: BEADS SHOULD BE CUT IN FOR EACH WINDOW FOR ACCURATE FIT.

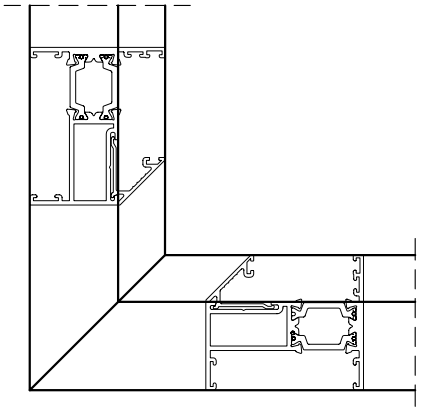
1. HORIZONTAL BEAD - SQUARE CUT
GLASS SIZE + 14.6mm
2. VERTICAL BEAD - SQUARE CUT
GLASS SIZE - 21.8mm

28mm



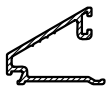
**CS827**
BEAD
EXTERNAL
GLAZED VENT

**CS830**
BEAD
INTERNAL
GLAZED VENT



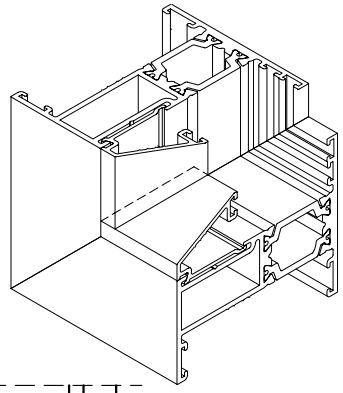
1. HORIZONTAL BEAD - SQUARE CUT
GLASS SIZE + 14.6 mm
2. VERTICAL BEAD - GLASS SIZE+0.52mm
4.7 MM SQUARE CUT AT EACH END
THEN SLOPED PART CUTS AT 45°

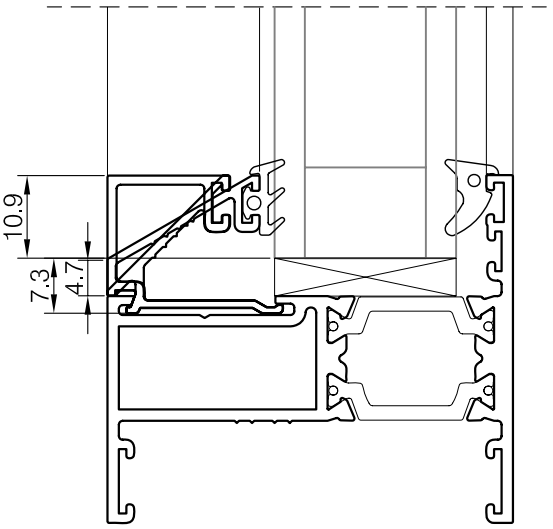
24mm



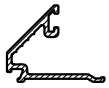
**CS826**
BEAD
EXTERNAL
GLAZED VENT

**CS829**
BEAD
INTERNAL
GLAZED VENT



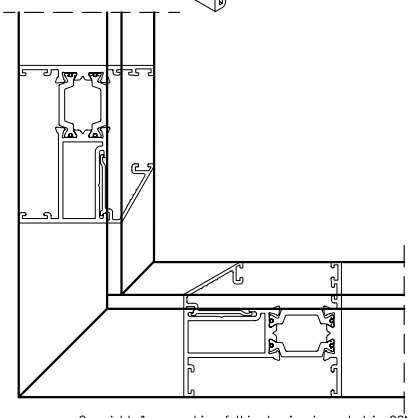



32mm



**CS828**
BEAD
EXTERNAL
GLAZED VENT

**CS831**
BEAD
INTERNAL
GLAZED VENT



1. HORIZONTAL BEAD - SQUARE CUT
GLASS SIZE + 14.6 mm
2. VERTICAL BEAD - GLASS SIZE+0.52mm
4.7 MM SQUARE CUT AT EACH END
THEN SLOPED PART CUTS AT 30°

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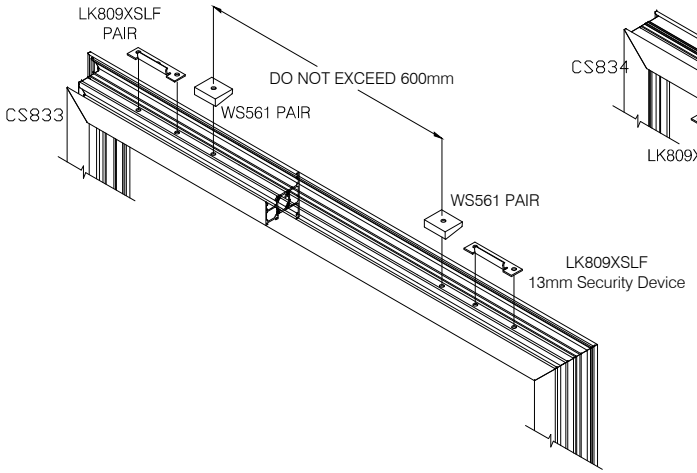
|---|---|
| SCALE | 1:1 @ A4 |
| DATE | 31/03/2010 |
| DRAWN | VM/OP |
| DRG. No. | C5-Pi-ECO-5.26 |

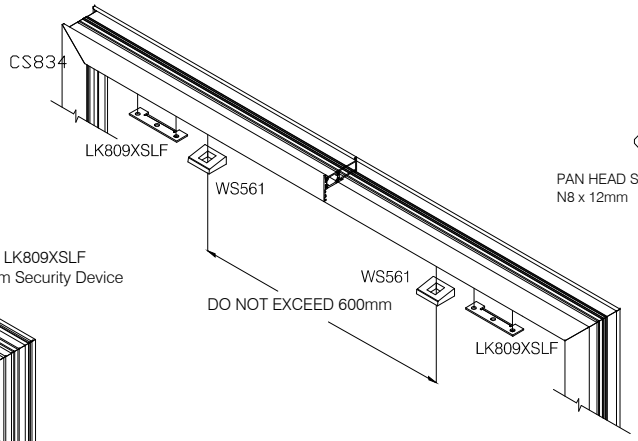
comar 5P.i

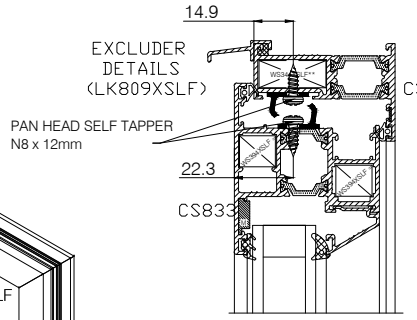
**POLYAMIDE INSULATED WINDOWS**
**ECO 55mm & 75mm WINDOW SYSTEM**

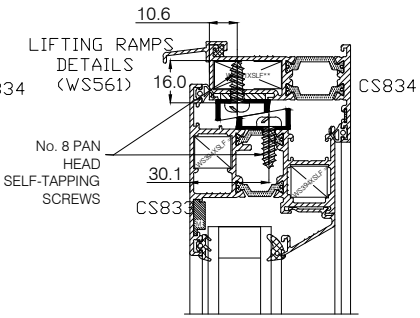
SHEET No.
**ECO 5.27**

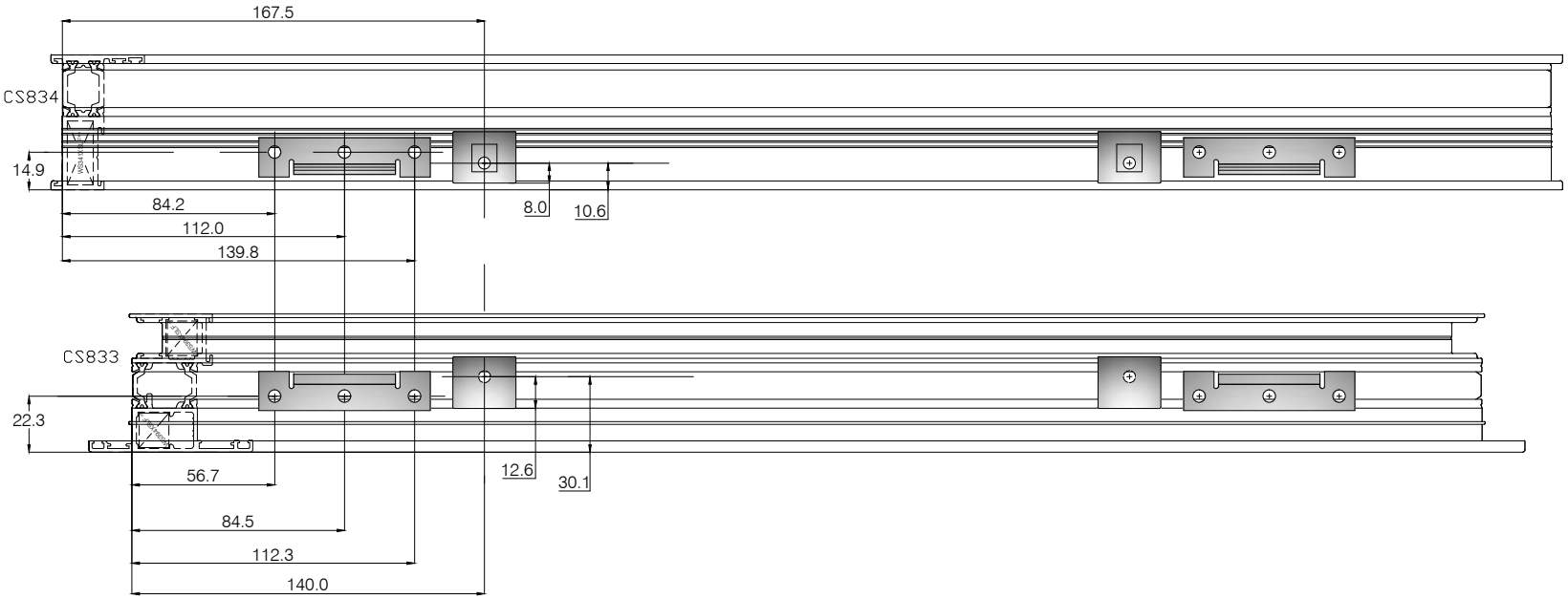
**WINDOW EXCLUDER & LIFTING RAMPS DETAILS**
**FABRICATION & ASSEMBLY**

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| DATE | 15/05/2013 |
| DRAWN | VM / OP (IS) |
| DRG. No. | C5-Pi-ECO-5.27 R1 |