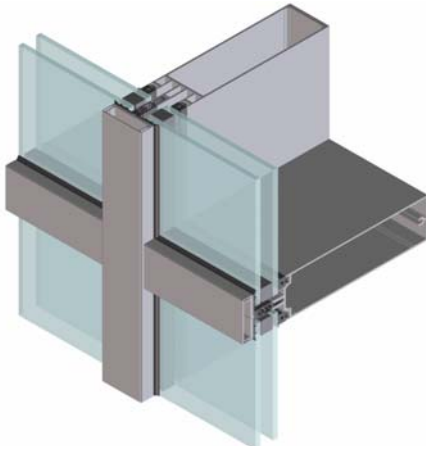


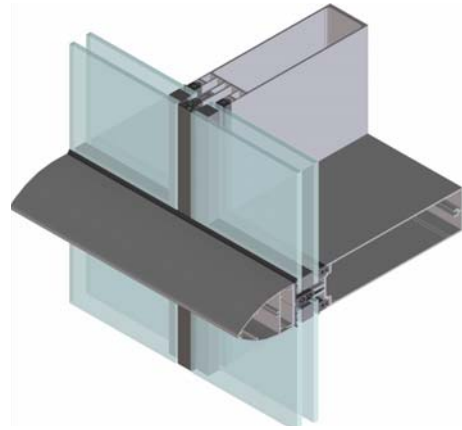
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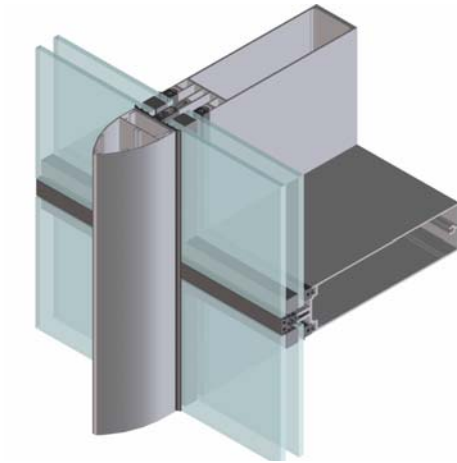
Fabrication
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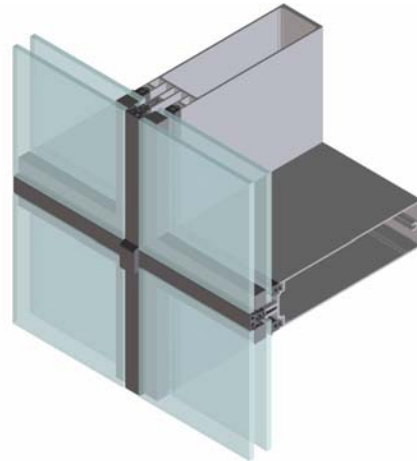
Capped



2sided SGH



2sided SGV



4sided SG

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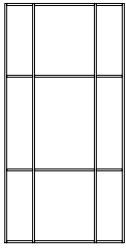
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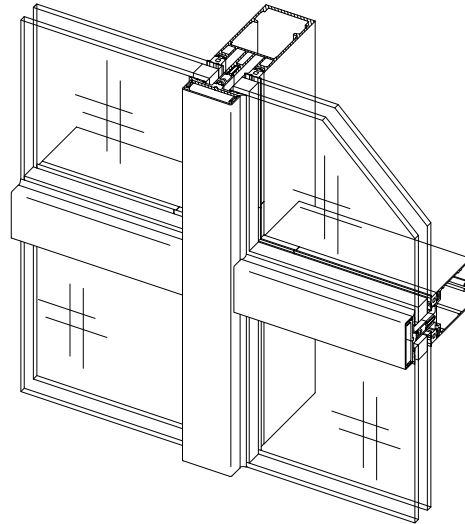
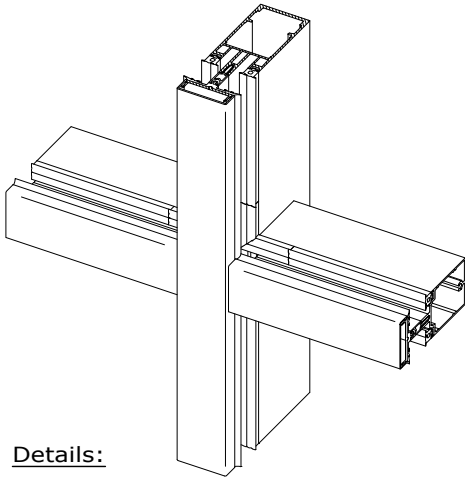
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Exploded typical detail Fully capped

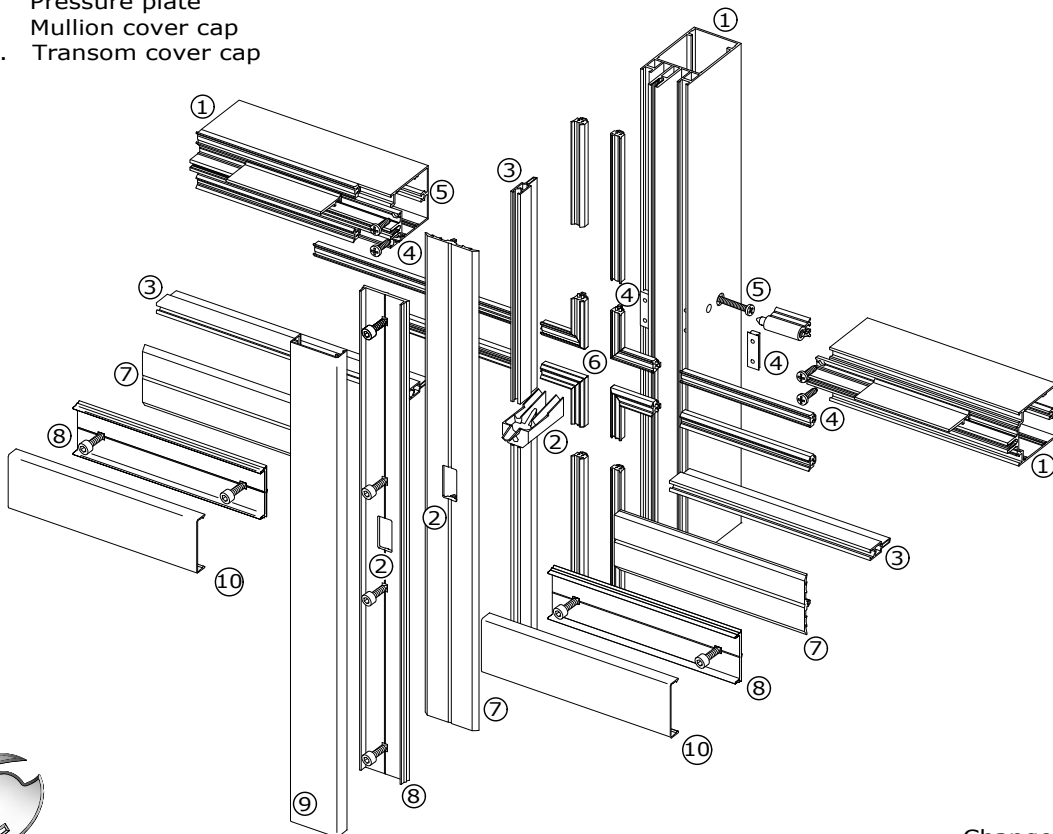


6.00



Details:

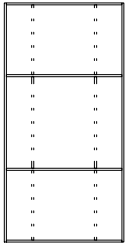
1. One substructure for all curtain wall types (Fully Capped / 2sided SGH / 2sided SGV / 4sided SG)
2. Controlled drainage system (mullion drained) - drainage diverter
3. Thermal break
4. Mullion-Transom step-cut & sealed by EPDM moulding
5. Ladder (unit) construction or stick build
6. Moulded EPDM corners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



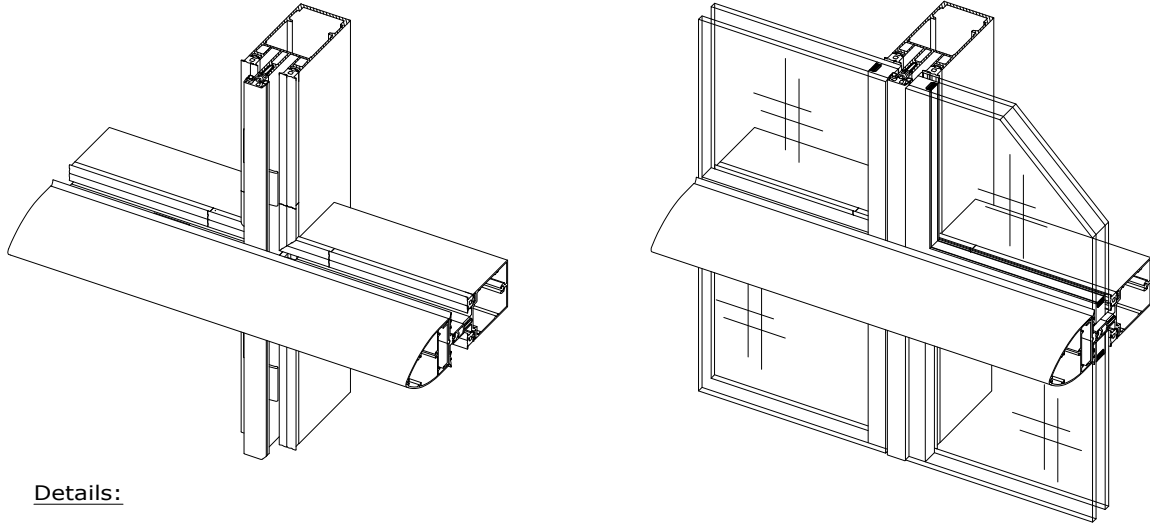
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Exploded typical details Horizontal cover cap (2sided SGH)

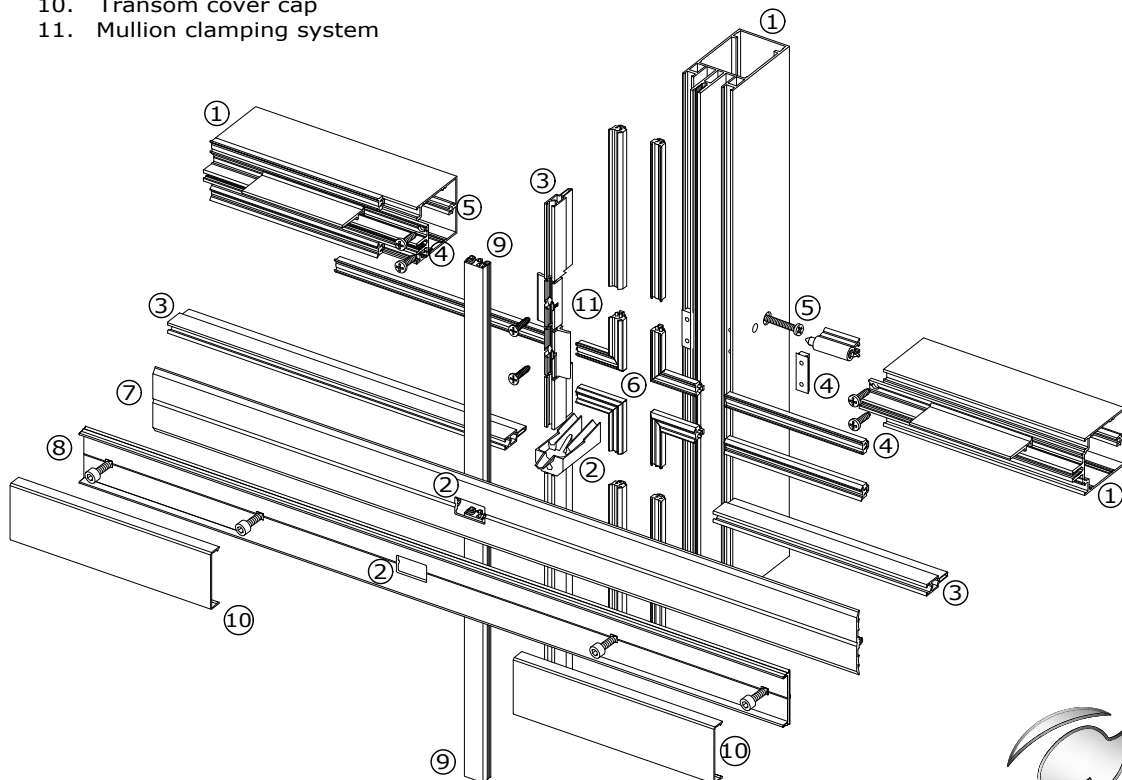


6.01



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
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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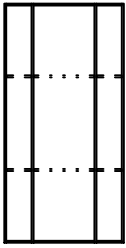
Issue: 05
Date: 10-16

Fabrication

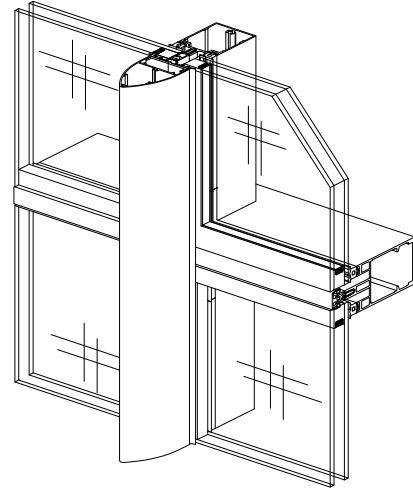
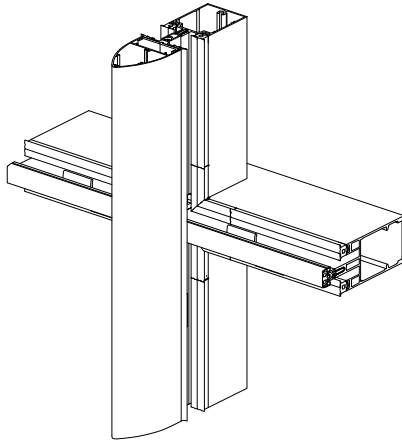
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Exploded typical detail Vertical cover cap (2Sided SGV)

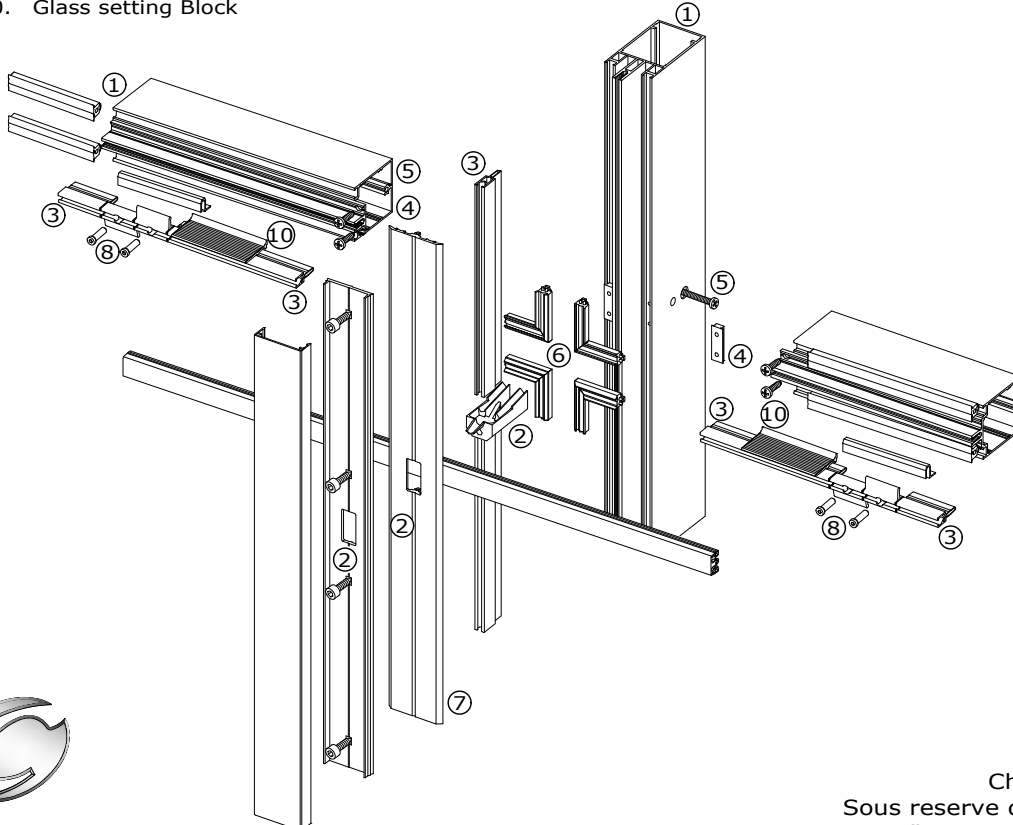


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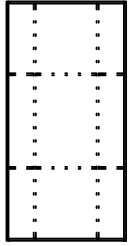
Details:

1. One substructure for all curtain wall types, Fully Capped, 2sided SGH, 2sided SGV & 4sided SG.
2. Controlled drainage system (mullion drained) drainage diverter
3. Thermally broken.
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. Glazing clamping system into DG unit.
9. Continuous pressure plate gasket.
10. Glass setting Block

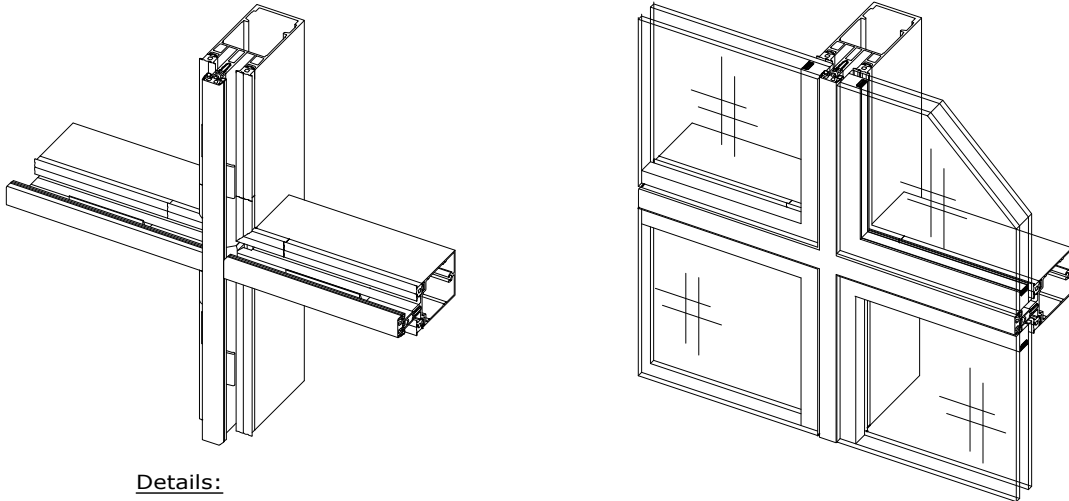


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Exploded typical details Four sided structural EFT (4sided SG)

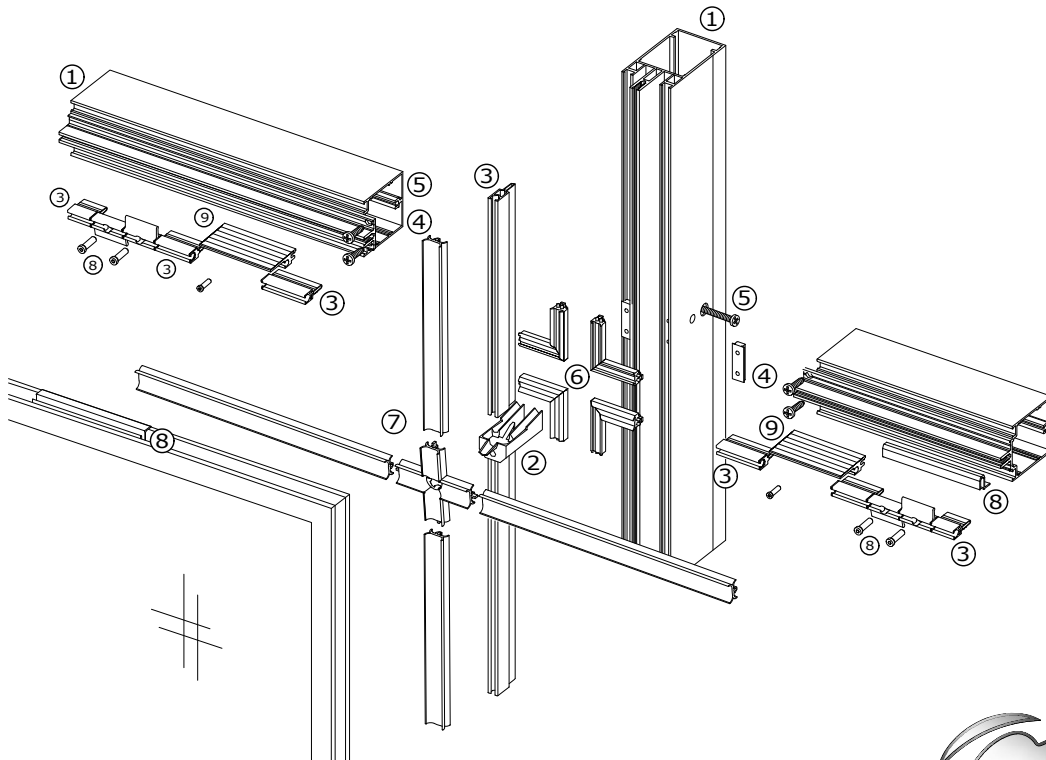


6.03



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. Thermally broken.
4. Mullion-Transom step-cut & sealed by EPDM gasket.
5. Ladder (unit) construction or stick build.
6. Moulded EPDM corners available.
7. Joint cruciform gasket.
8. Glazing clamping system into DG unit.
9. Glass setting block



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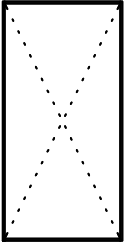
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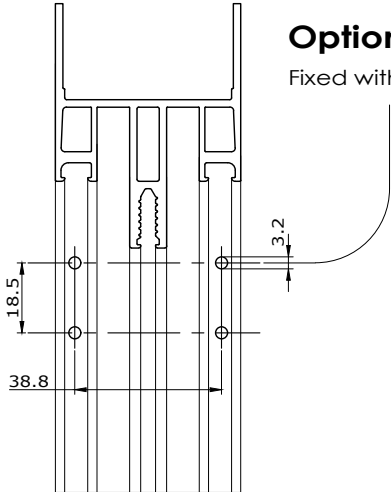
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Mullion - Transom Connection



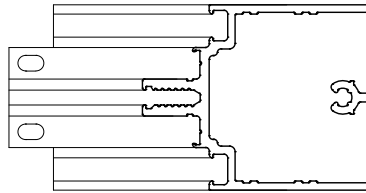
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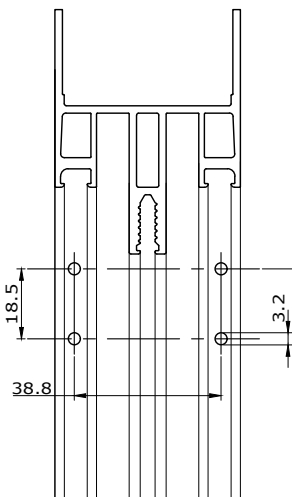
Option 1 (for 45mm Transoms only)

Fixed with 2 screws EFT 3021 (3.9x16)

Glass weight: max. 100 kg



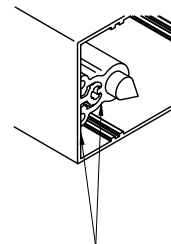
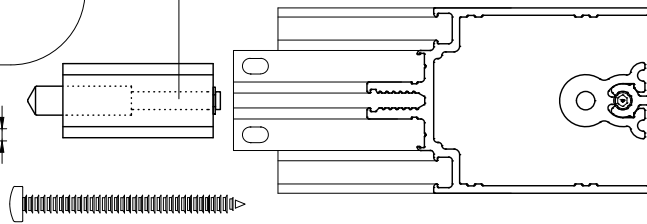
Fabricators Guide



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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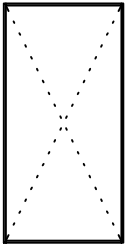
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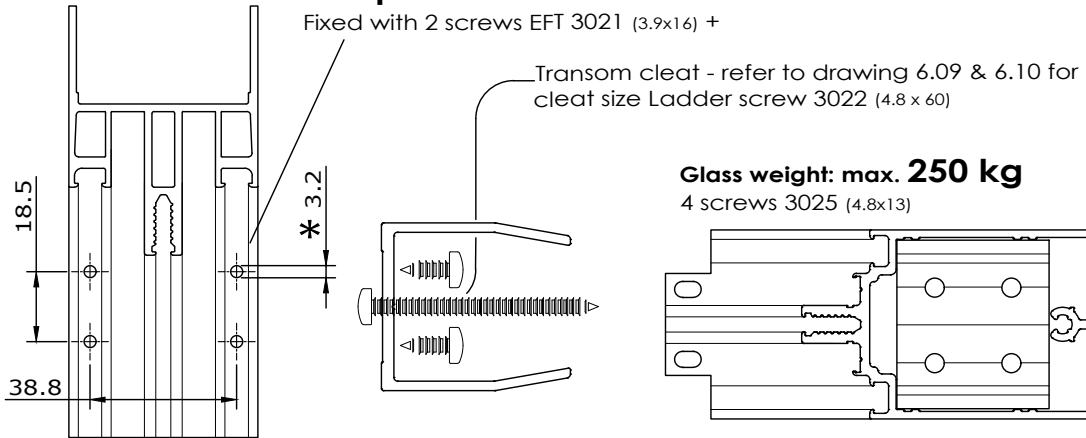
Fabrication

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Mullion - Transom Connection



Option: 3



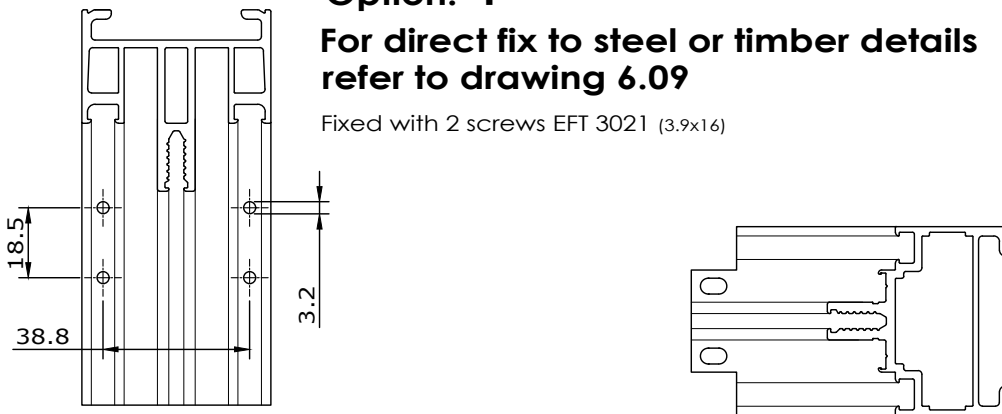
6.05

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

Option: 4

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

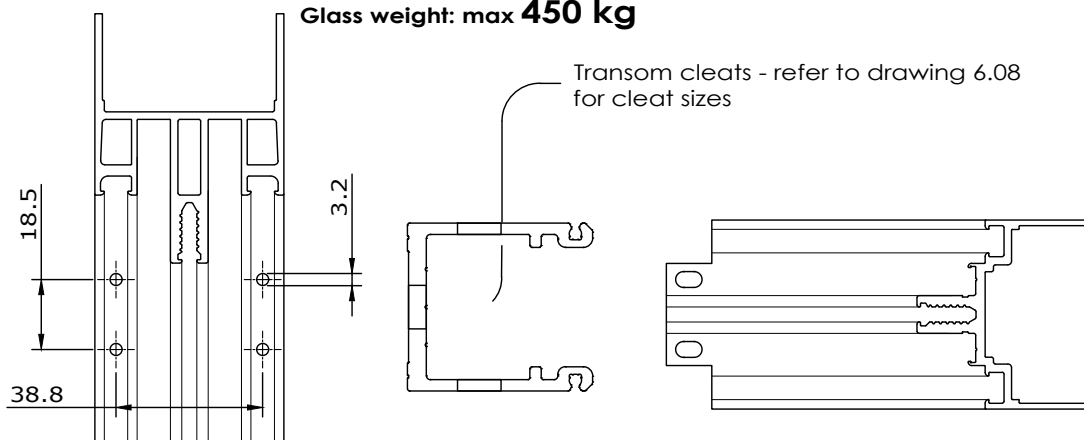
Fixed with 2 screws EFT 3021 (3.9x16)



Option: 5

Glass weight: max 450 kg

Transom cleats - refer to drawing 6.08 for cleat sizes



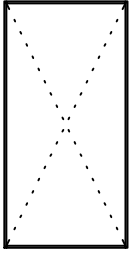
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Fabrication

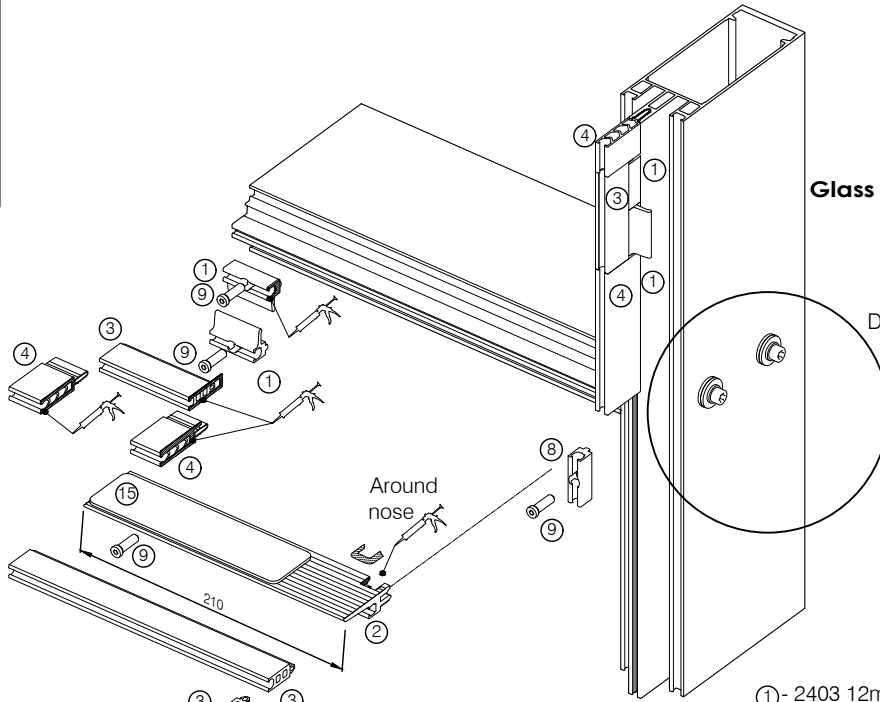
6

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Heavy glass support Jamb detail

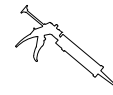
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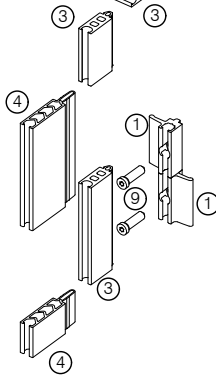
Option: 5

Glass weight: Max 450 kg

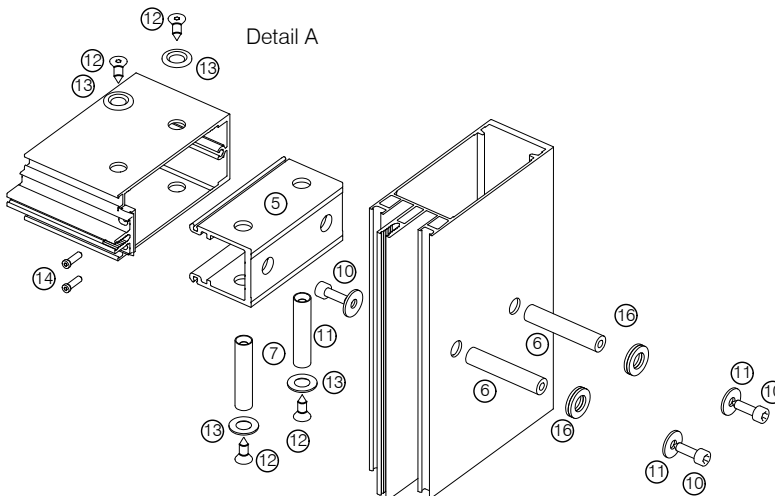
Detail A



APPLY SEALANT
TO ALL JOINTS



- ①- 2403 12mm double glazing clamp
- ②- 140x series 12mm glass setting block
- ③- 2155 22mm extension gasket
- ④- 2203 34mm thermal break
- ⑤- 1305 transom cleat
- ⑥- 1891 11x3 59.5mm aluminium tube
- ⑦- 1890 11x3 50mm aluminium tube
- ⑧- 2409 setting block support
- ⑨- 3029 5.5x23mm special screw
- ⑩- 3004 5.5x19mm socked screw
- ⑪- 3095 M6 DIN9021SS washer
- ⑫- 3017 5.5x16 countersink screw
- ⑬- 3094 SS countersink washer
- ⑭- 3021 3.9x16 special screw
- ⑮- 150mm wide glass shims
- ⑯- M12 SS washers by Others



Detail A

Fabricators Guide

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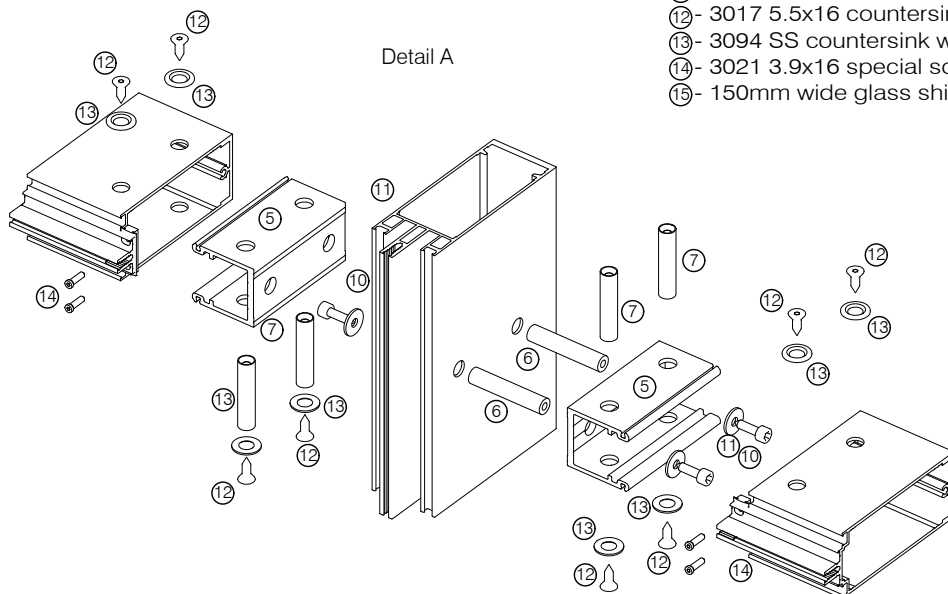
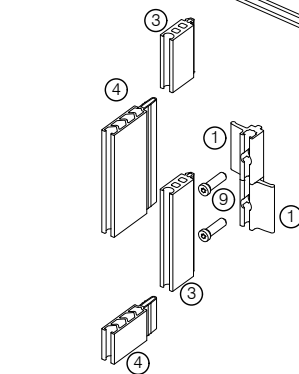
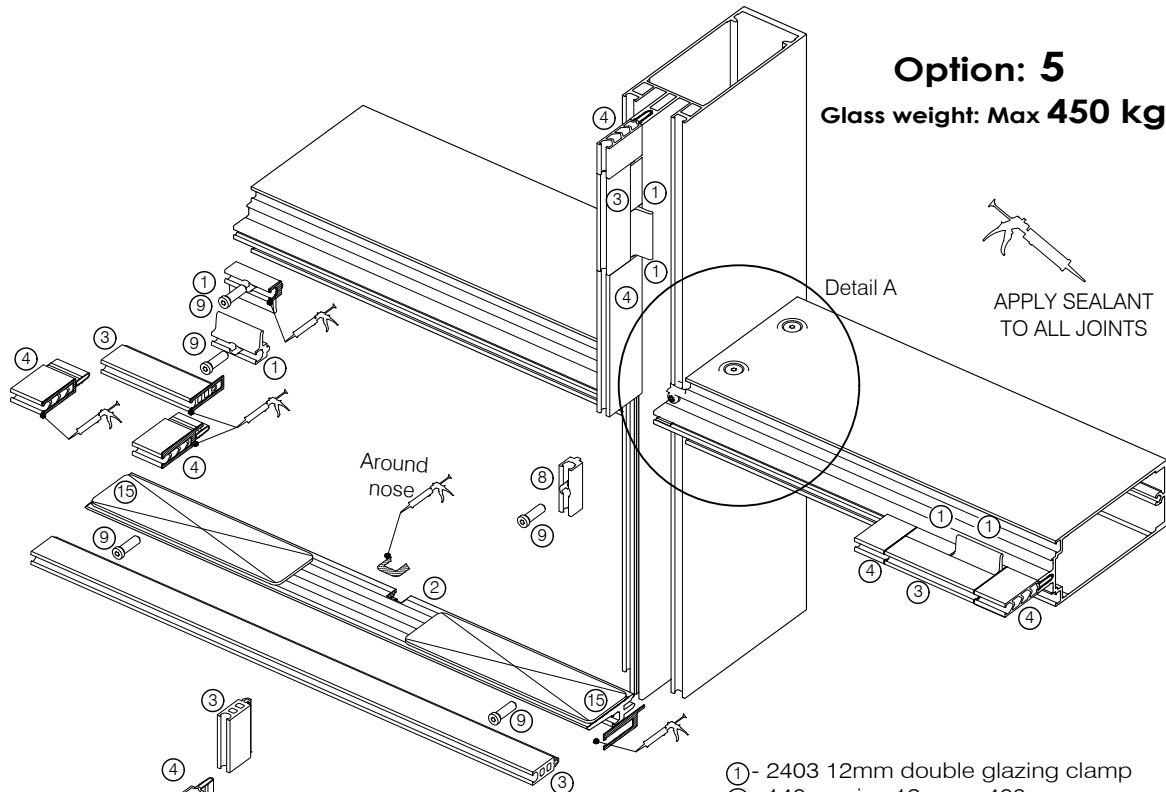
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Heavy glass support Mullion Detail

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- ①- 2403 12mm double glazing clamp
- ②- 140x series 12mm x 400mm glass setting block
- ③- 2155 22mm extension gasket
- ④- 2203 34mm thermal break
- ⑤- 1305 transom cleat
- ⑥- 1891 11x3 59.5mm aluminium tube
- ⑦- 1890 11x3 50mm aluminium tube
- ⑧- 2409 setting block support
- ⑨- 3029 5.5x23mm special screw
- ⑩- 3004 5.5x19mm socked screw
- ⑪- 3095 M6 SS DIN9021 washer
- ⑫- 3017 5.5x16 countersink screw
- ⑬- 3094 SS countersink washer
- ⑭- 3021 3.9x16 special screw
- ⑮- 150mm wide glass shims

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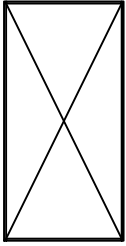


Installation

6

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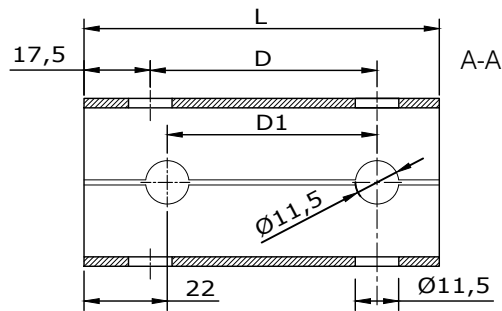
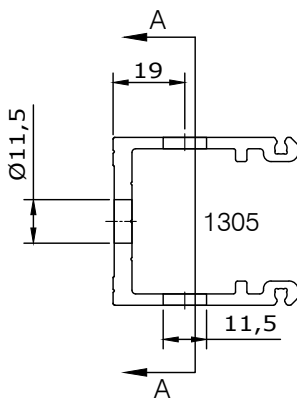
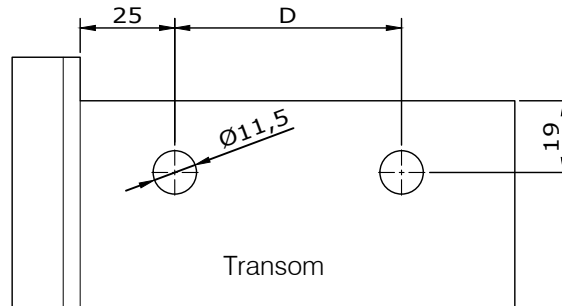
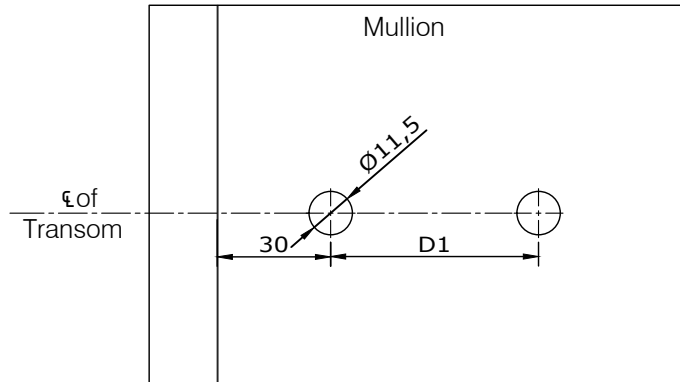
Mullion - Transom Connection



6.08

Option: 5

Glass weight max **450 kg**



Fabricators Guide

Note:
Cut cleats are for project only and are not held in stock. Cut cleats will be subject to a longer lead time.

Cleat Reference	Transom	L (mm)	D (mm)	D1(mm)
2566	1152 - 135mm	114	75	70
2567	1145 & 1154 -150mm	129	100	95
2568	1147 - 175mm	154	125	120
2569	1156 - 180mm	159	130	125
2570	1157 - 195mm	174	145	140
2571	1148 - 200mm	179	145	140
2572	1158 - 210mm	189	160	156

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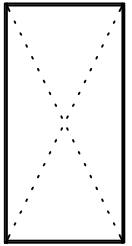
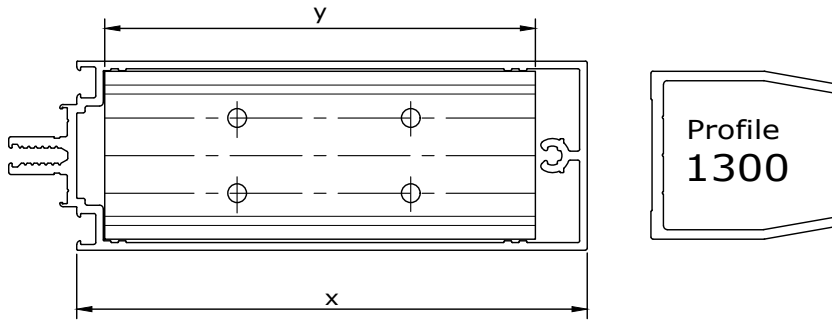
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Fabrication

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Transom cleat size



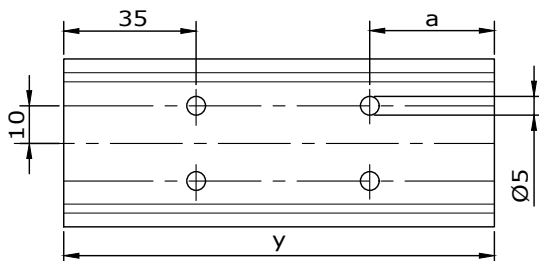
Cleat length (y) = Transom size (x) - 21mm

6.09

Transom number	Transom Size (x)	Cleat part no.	Cleat length (y)	Hole Ctr (a)
1149	45mm	N/A	N/A	N/A
1150	60mm	N/A	N/A	N/A
1151	85mm	2551	64mm	N/A
1143	85mm	2551	64mm	N/A
1164	105mm	2564	84mm	20mm
1144	115mm	Cut by Fab	94mm	See 6.10
1152	135mm	2552	114mm	35mm
1145	150mm	2554	129mm	20mm
1154	150mm	2554	129mm	20mm
1147	175mm	Cut by Fab	154mm	See 6.10
1156	180mm	2556	159mm	25&50mm
1157	195mm	2557	174mm	25mm
1148	200mm	Cut by Fab	179mm	See 6.10
1158	210mm	2558	189mm	25mm

Fabricators Guide

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



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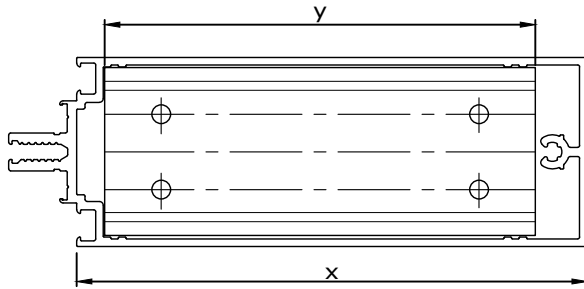
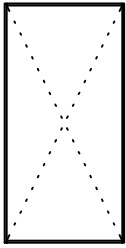
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Fabrication

6

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Transom cleat sizes



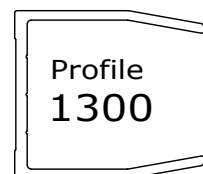
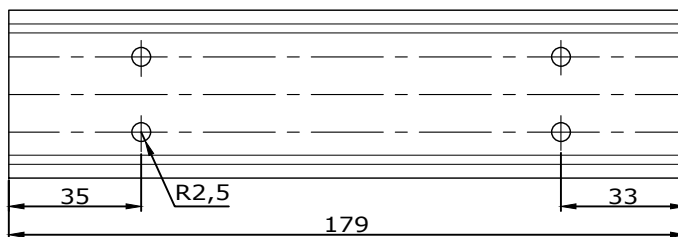
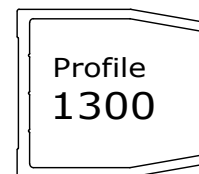
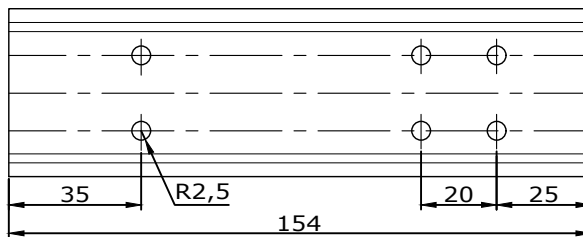
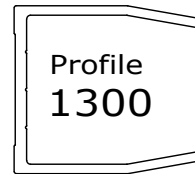
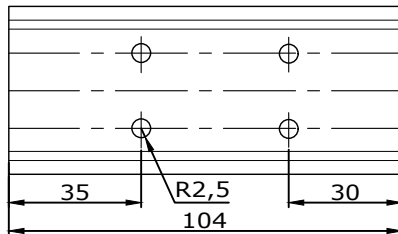
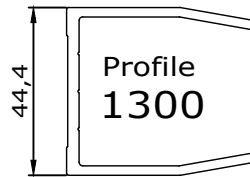
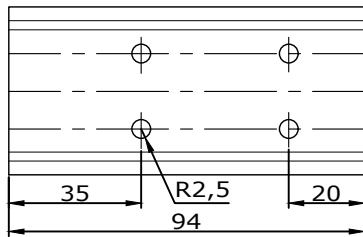
6.10

Transom number	Transom Size (x)	Cleat length (y)
1144	115mm	94mm
1147	175mm	154mm
1148	200mm	179mm

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

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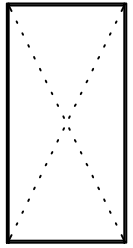
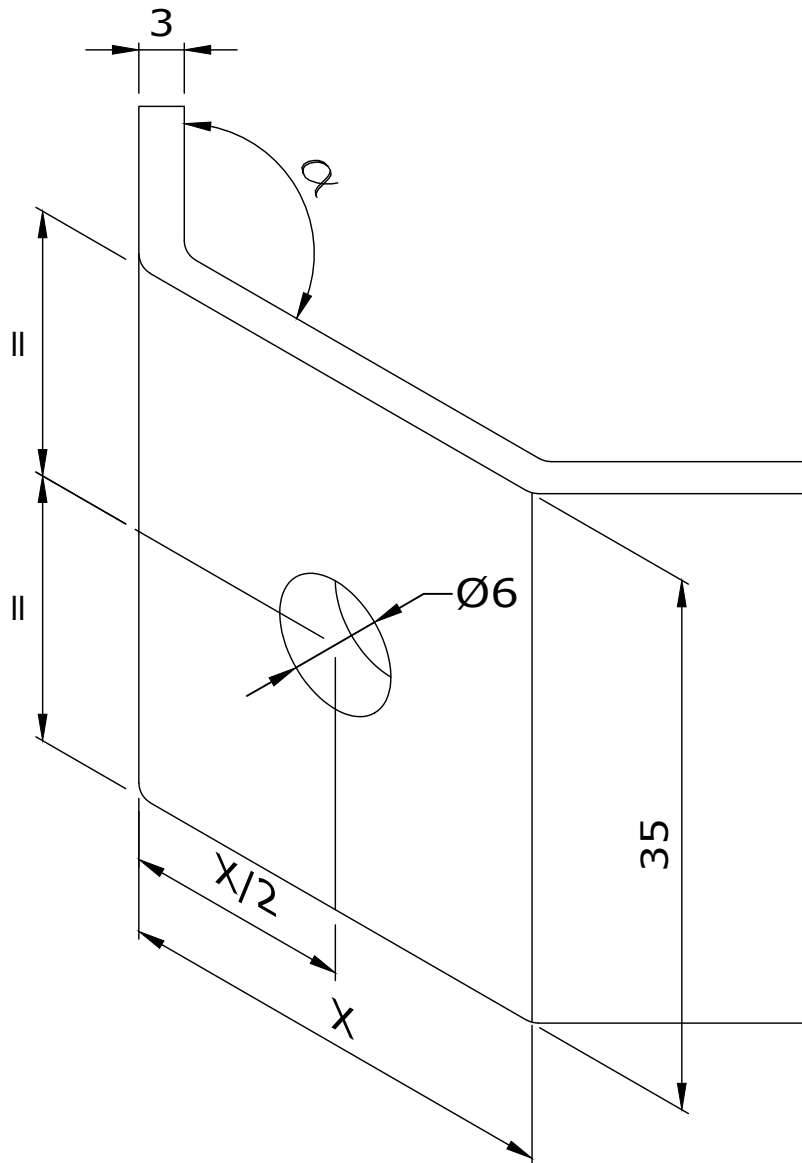


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6

Fabrication
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Facetted clamp



6.11

Fabricators Guide

Facetted clamps to be made to required angle α .

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 contact Comar's technical department.

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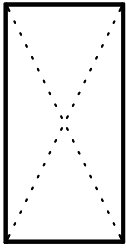
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Profile Sections

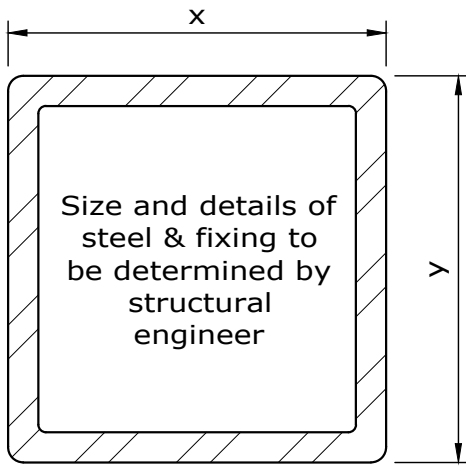
6

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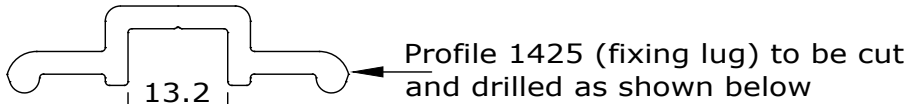
Direct fix to steel
fixing lug preparation



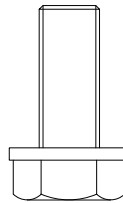
6.12



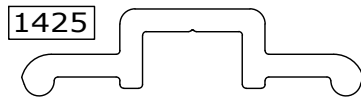
Aluminium to steel isolator
(supplied by others)



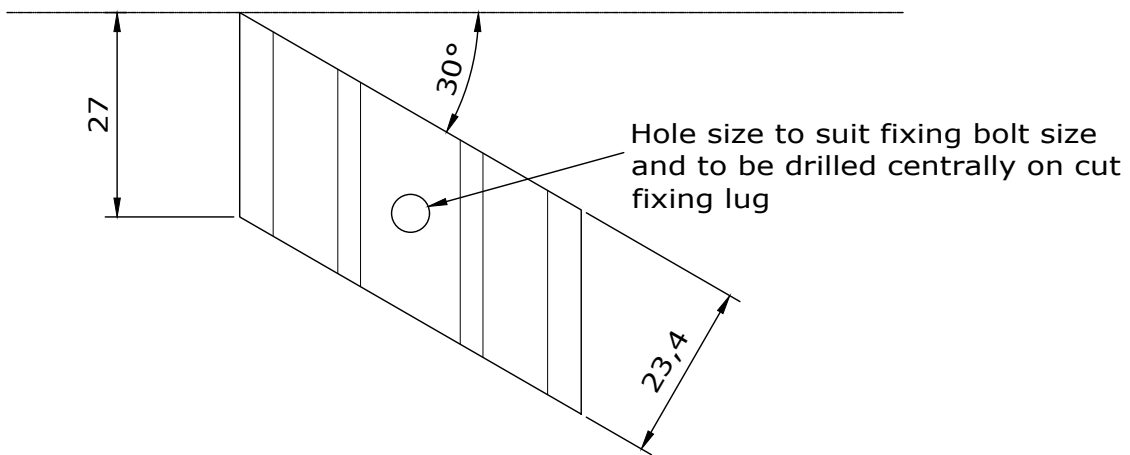
1mm spring washer
(supplied by others)



Fixing bolt (supplied by others) to
structural engineers specification



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



Fabricators Guide

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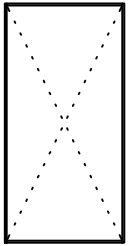
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6

Fabrication

Comar 6EFT

Mullion sleeve plate
85 mm (1070)
105 mm (1072)



6.13

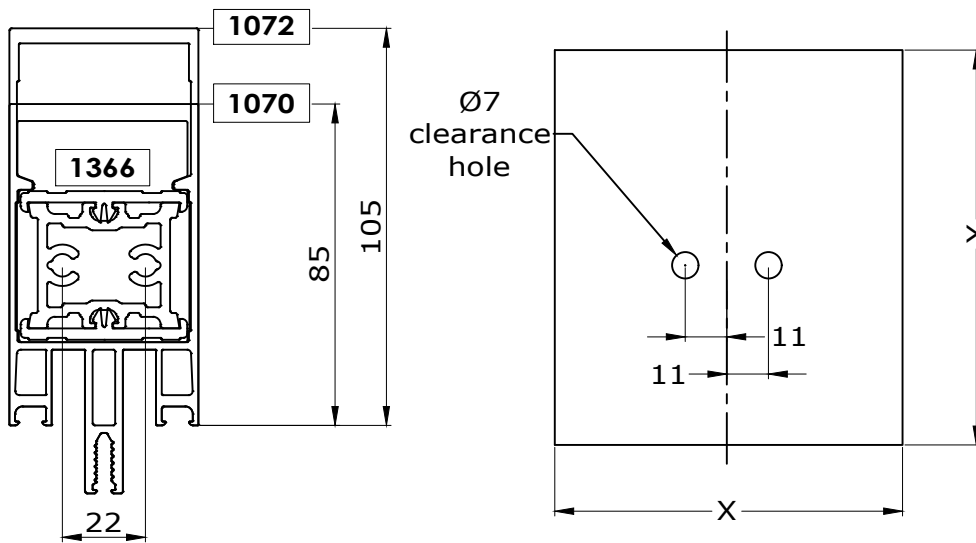
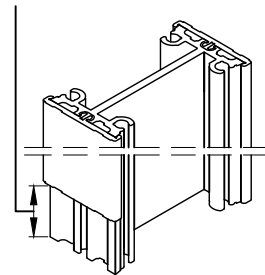


Plate supplied by others

Use Ø6.3mm number 14 x 25mm self tapping screw, countersunk (supplied by others) or plate can be welded.

Length & width of plate and anchor bolts to be determined by site conditions and to structural engineers specification.

Front plastic cover cap cut back as needed to fit EPDM



Fabricators Guide

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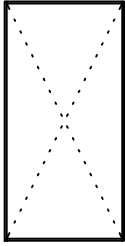
Issue: 05
Date: 10-16

Fabrication

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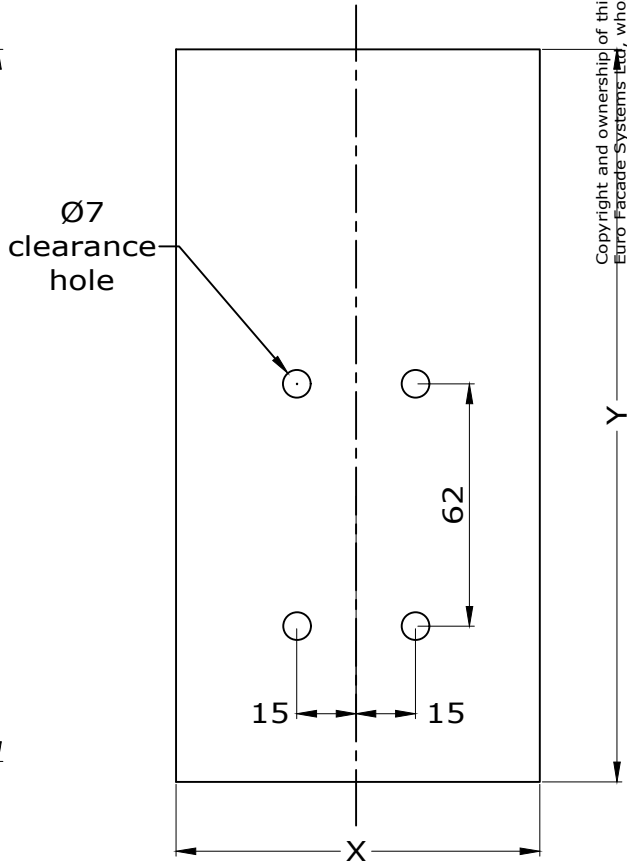
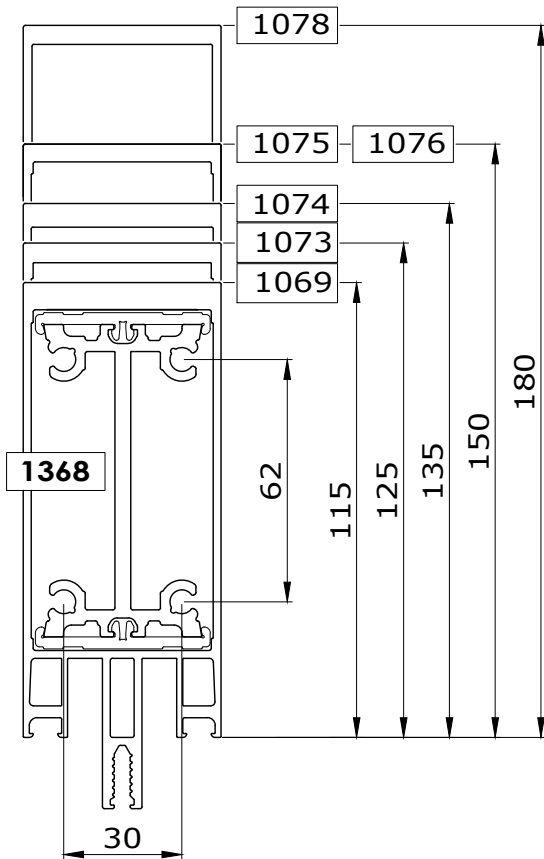
Comar 6EFT

Mullion Sleeve Plate 115mm(1069),125mm(1073) 135mm(1074),150mm(1075) 150mm(1076),180mm(1078)



6.14

Fabricators Guide



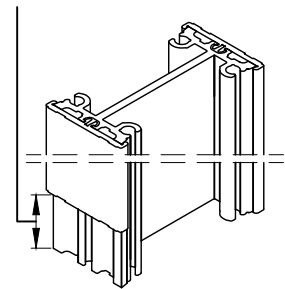
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Plate supplied by others

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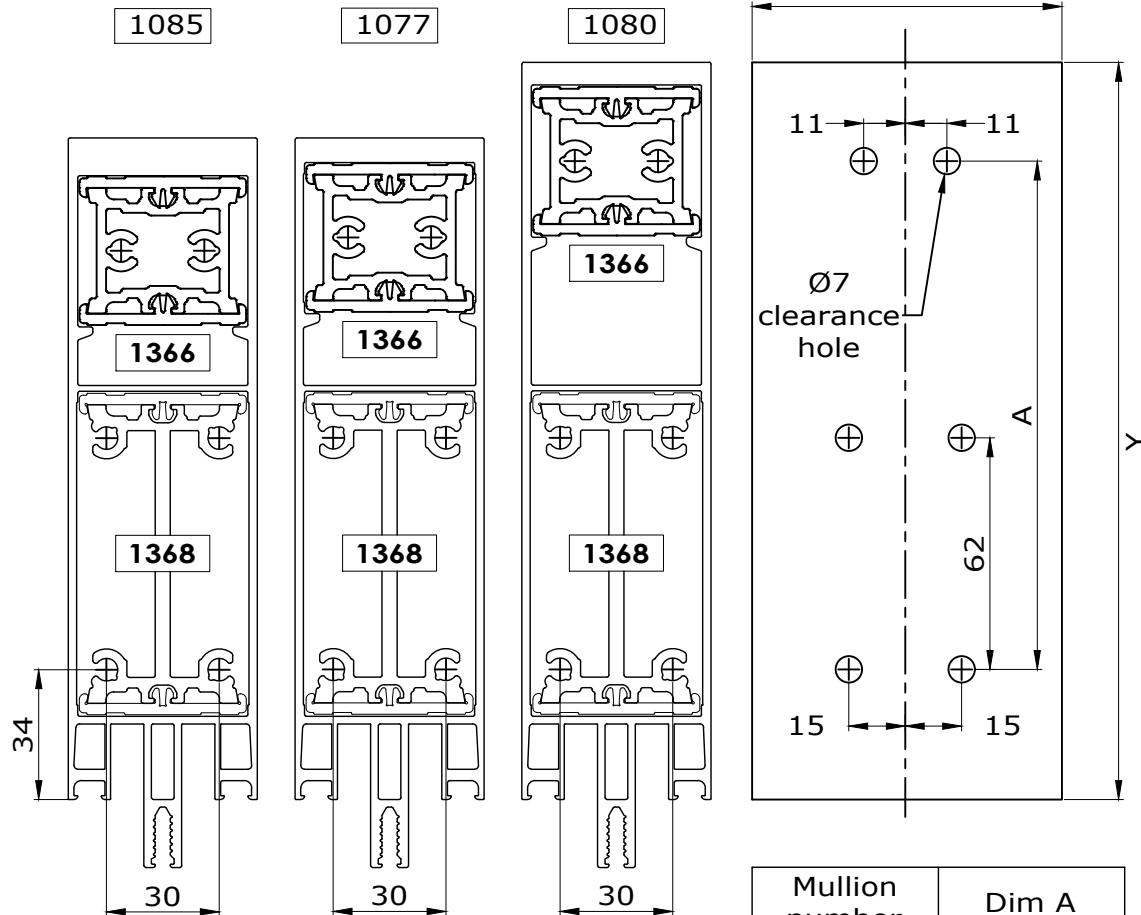
Length & width of plate and anchor bolts to be determined by site conditions and to structural engineers specification.

Front plastic cover cap cut back as needed to fit EPDM



Mullion sleeve plate
175mm (1085), 175mm (1077)
195 mm (1080)

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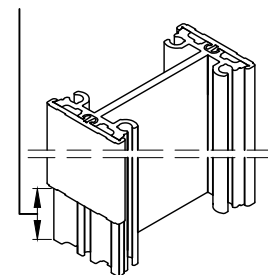
Mullion number	Dim A
1085	111
1077	114
1080	134

Plate supplied by others

Use $\text{Ø}6.3\text{mm}$ number 14 x 25mm self tapping screw, countersunk (supplied by others) or plate can be welded.

Length & width of plate and anchor bolts to be determined by site conditions and to structural engineers specification.

Front plastic cover cap cut back as needed to fit EPDM

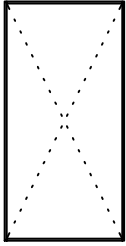


Fabrication

6

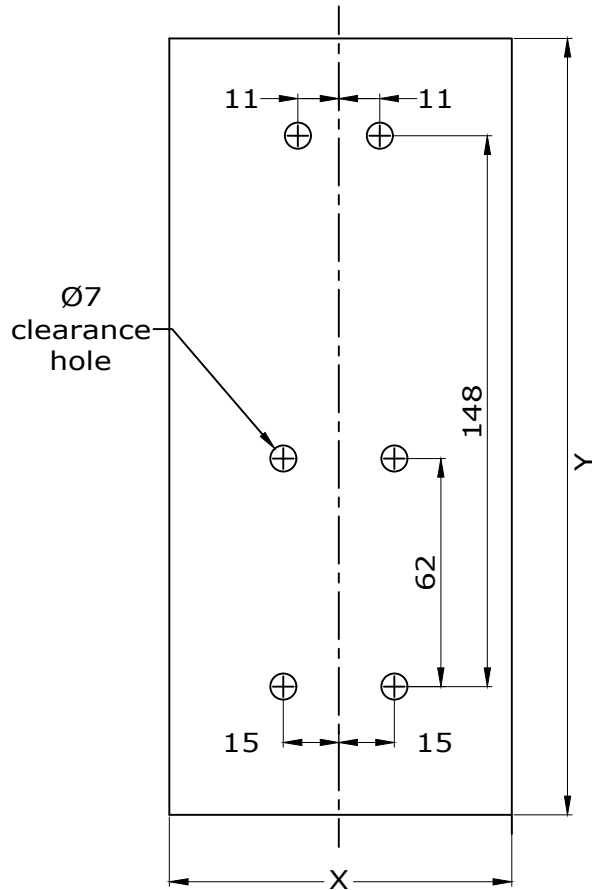
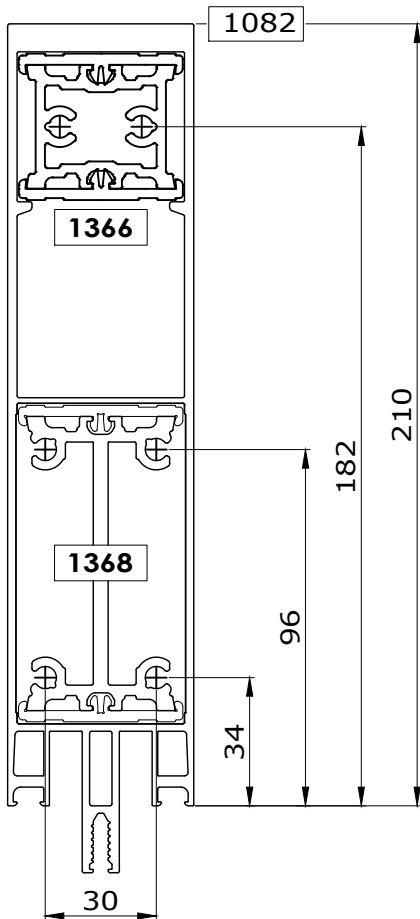
Comar 6EFT

Mullion sleeve plate 210 mm (1082)



6.16

Fabricators Guide



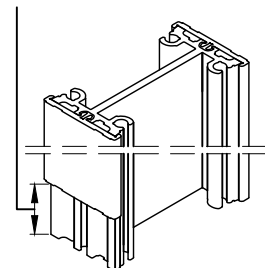
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5mm thick aluminium plate supplied by others

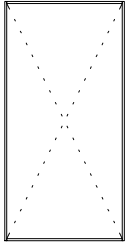
Use Ø6.3mm number 14 x 25mm self tapping screw, countersunk (supplied by others) or plate can be welded.

Length & width of plate and anchor bolts to be determined by site conditions and to structural engineers specification.

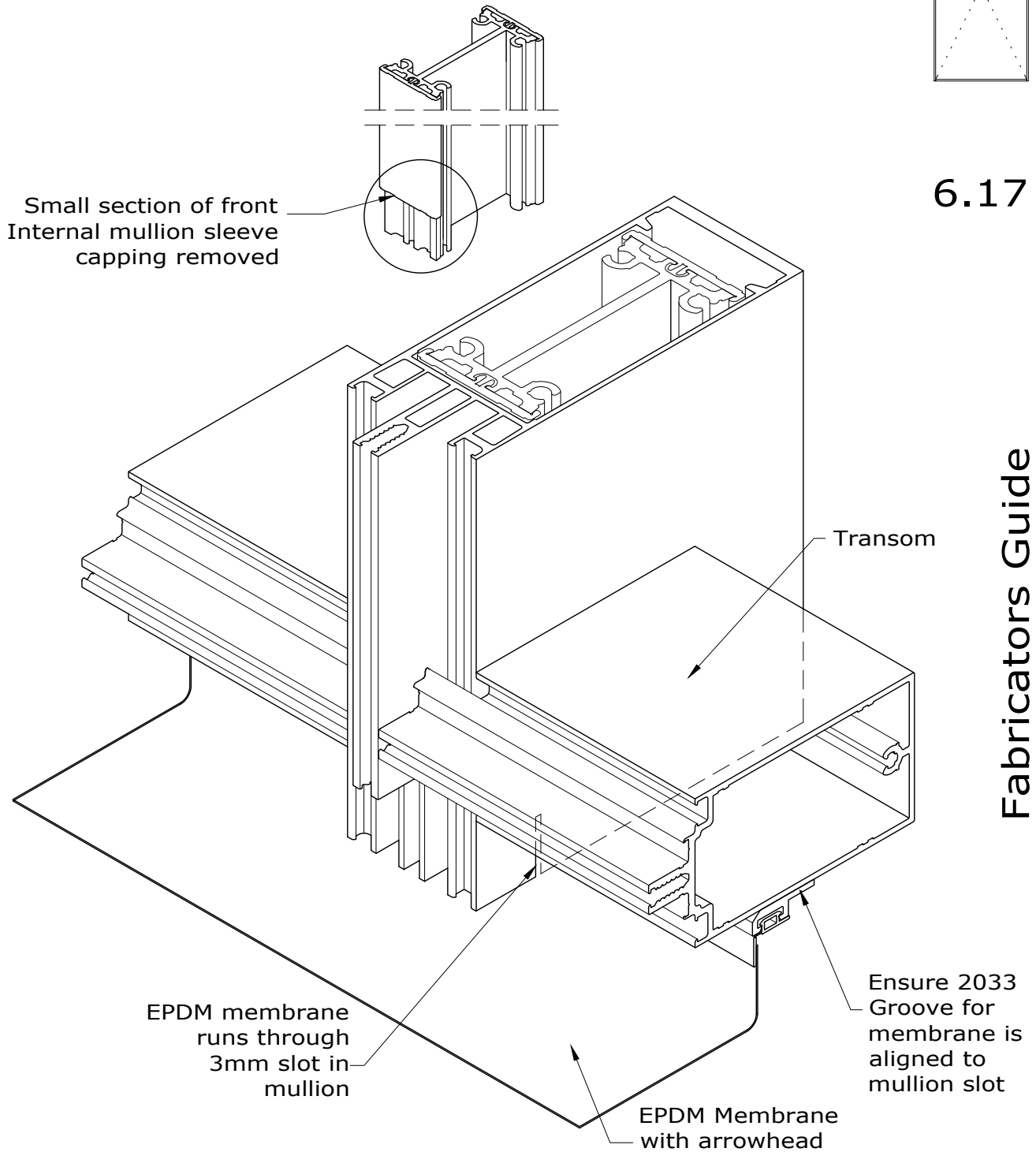
Front plastic cover cap cut back as needed to fit EPDM



EPDM membrane Transom Sill, Head & Mullion preparation



6.17

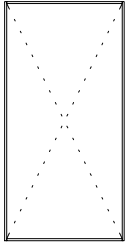


Fabrication

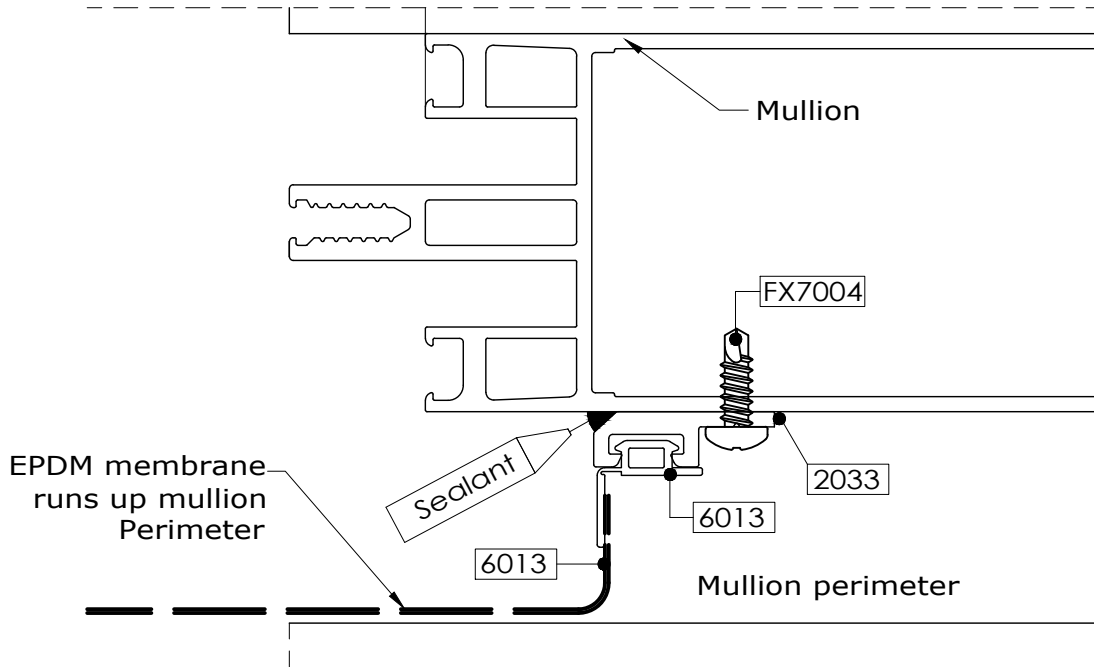
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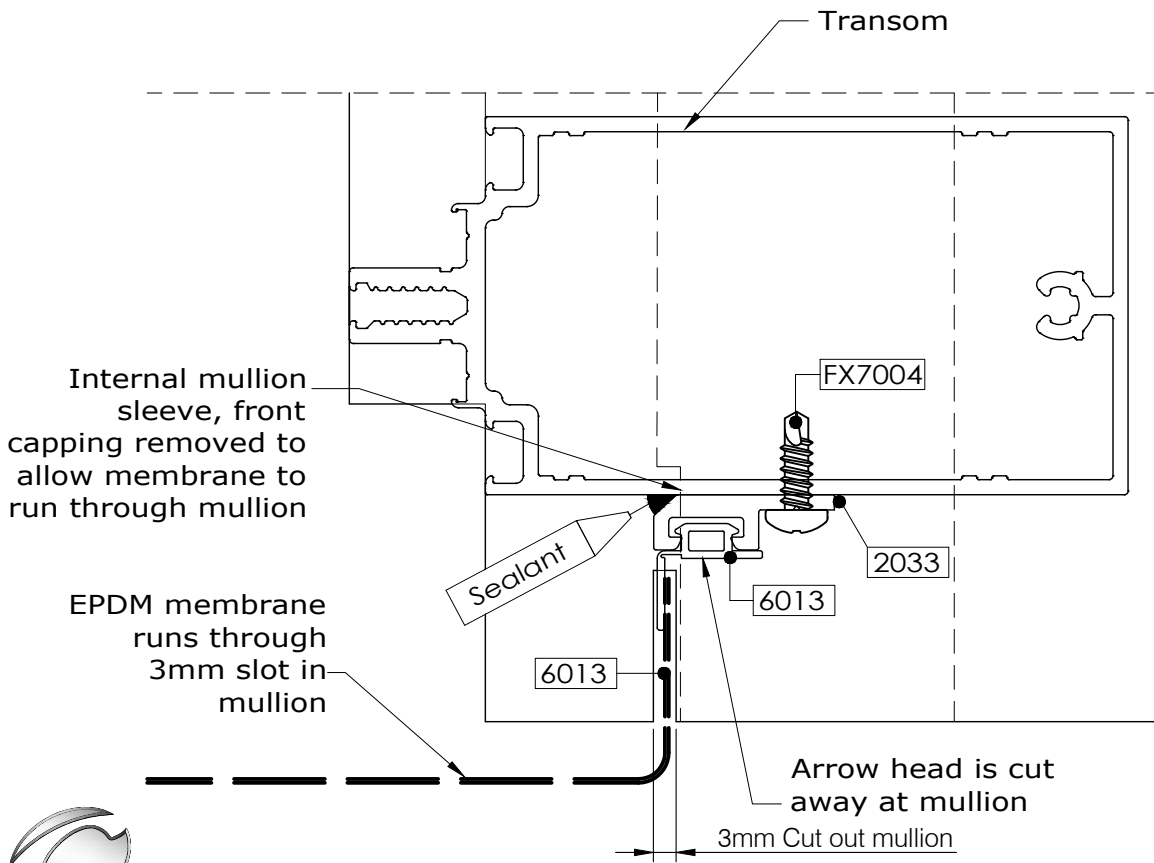
EPDM membrane Curtain wall perimeter Preparation



6.18



Fabricators Guide



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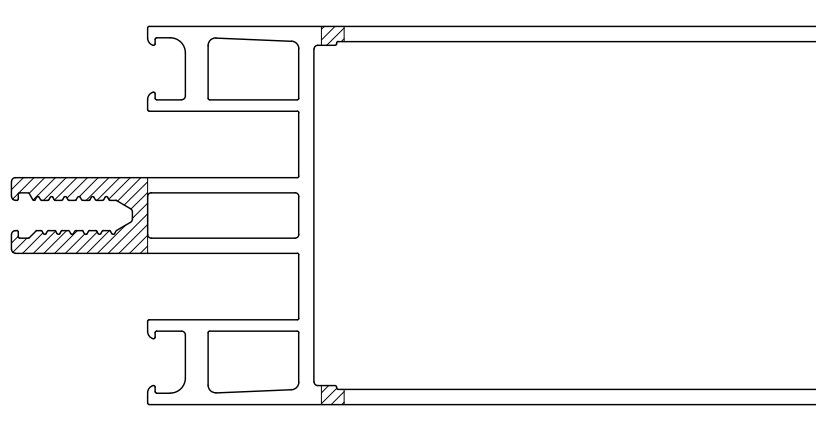
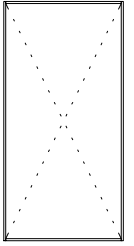


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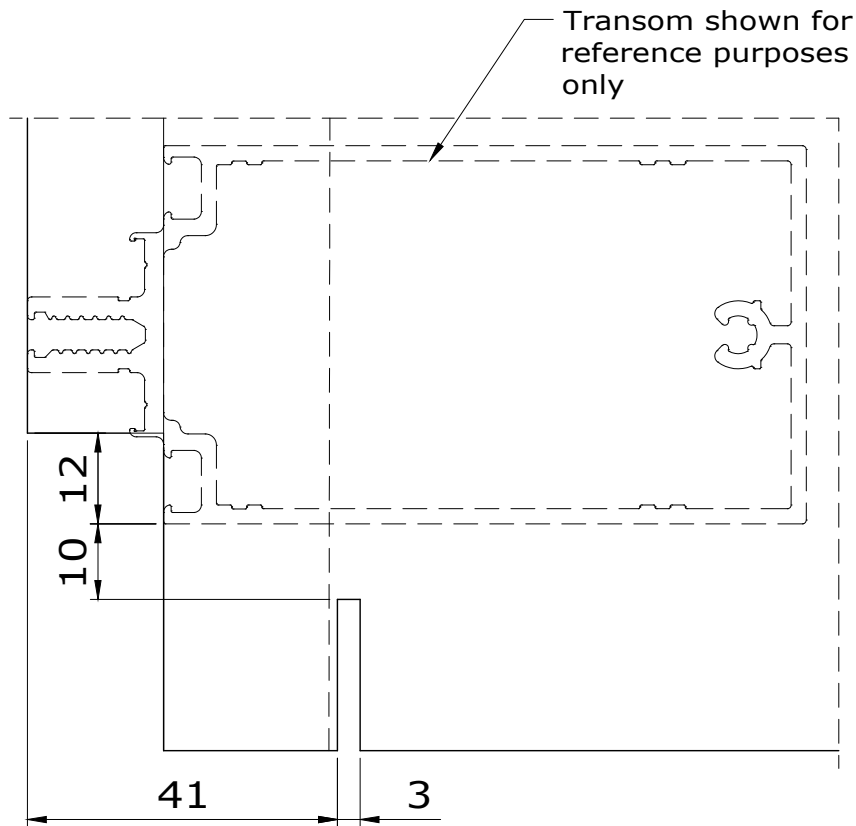
EPDM membrane Mullion preparation Slot cutting details

6

Fabrication
Comar 6EFT



6.19



Fabricators Guide

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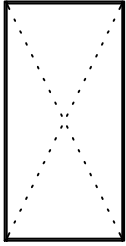
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Fabrication

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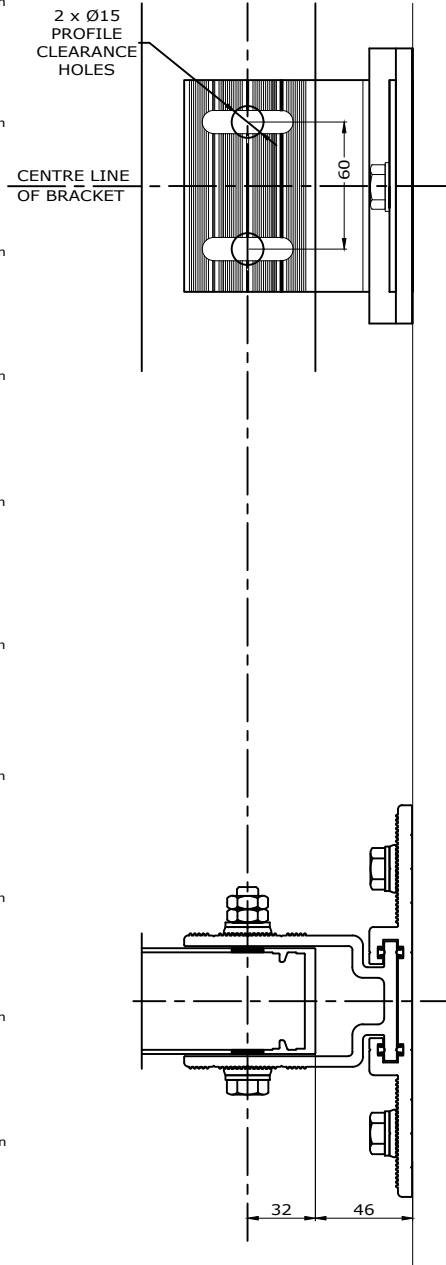
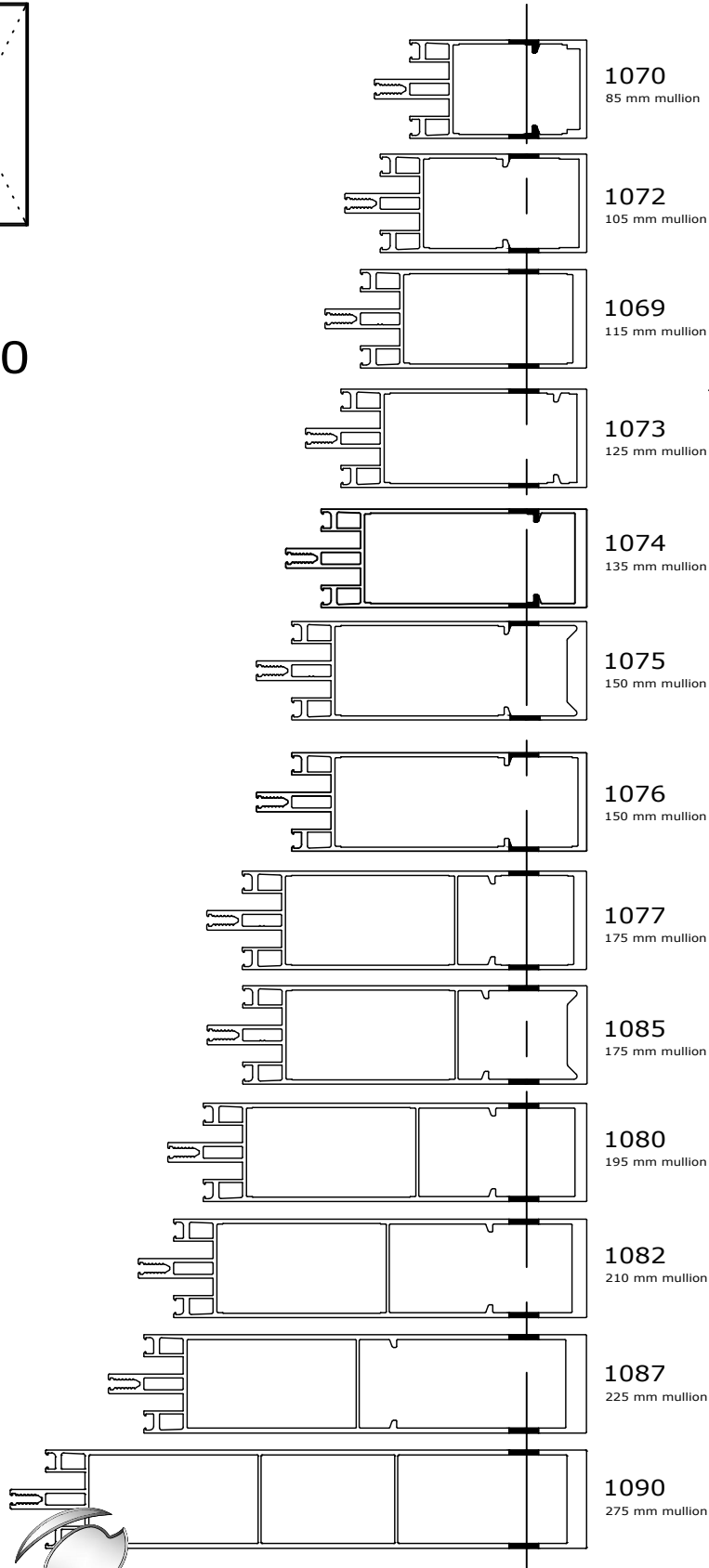
Comar 6EFT

Fixing bracket hole prep



6.20

Fabricators Guide



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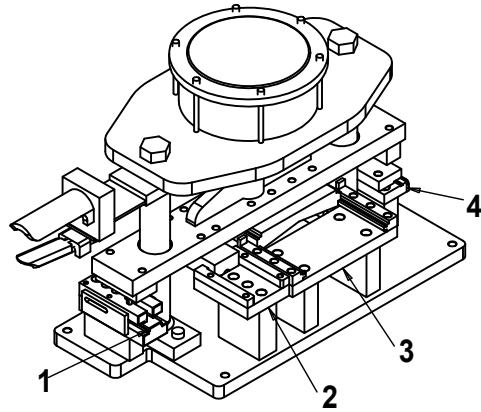
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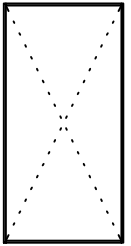
Fabrication

Comar 6EFT

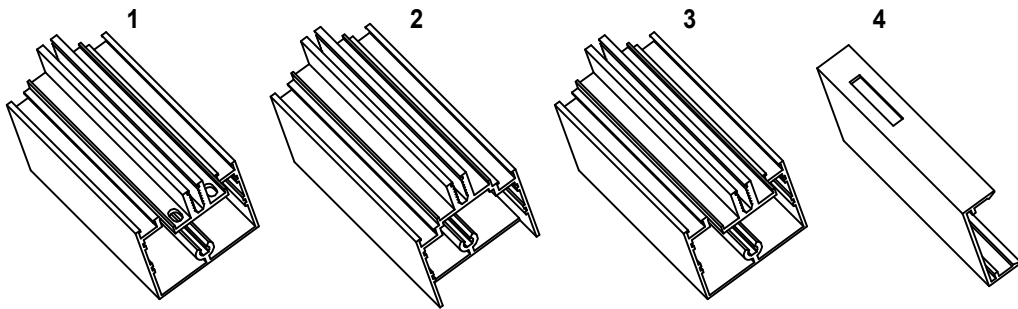
Tooling



Preparations:
As per drawing 6.23
transom end notch

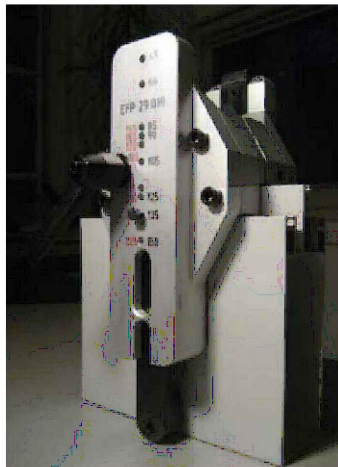
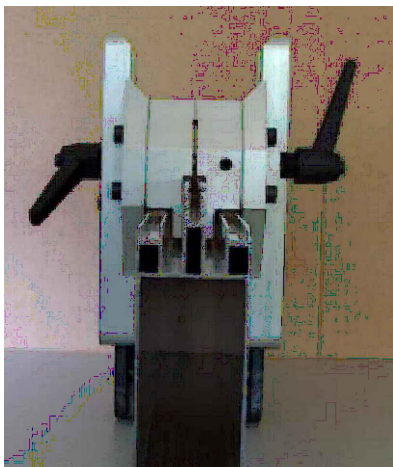


6.21



Tool: Pneumatic punch tool Com6-EFT-T13

Mullion - Transom connection



Tool: Com6-EFT-Jig 1

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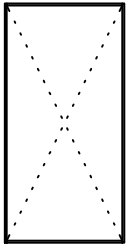


Fabrication

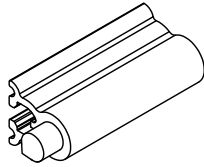
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Comar 6EFT

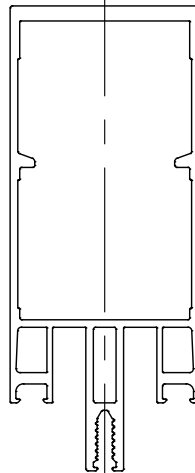
Mullion preparation



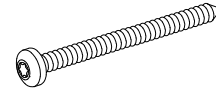
Transoms installed in between ladders



EFT 2310



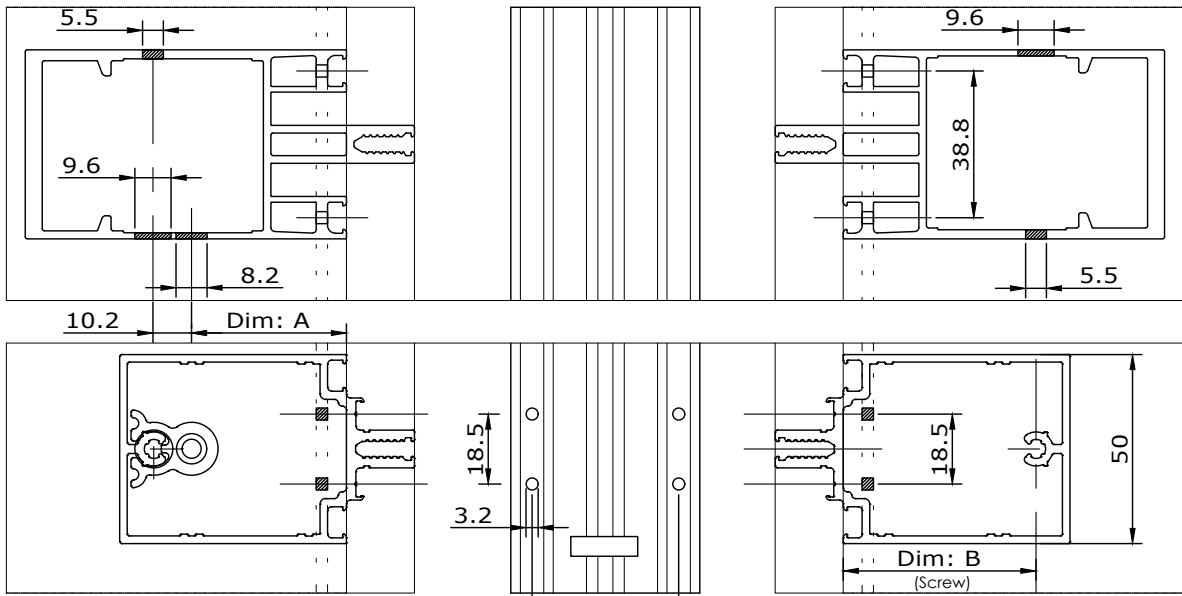
Ladder / unit



3022 (4.8 x 65)

6.22

Fabricators Guide



Transom no:		Dim: A
EFT 1149	45 mm	25.2
EFT 1150	60 mm	40.2
EFT 1151	85 mm	65.2
EFT 1143	85 mm	65.0
EFT 1164	105 mm	85.0
EFT 1144	115 mm	95.0
EFT 1152	135 mm	115.0
EFT 1154	150 mm	130.0
EFT 1145	150 mm	130.0
EFT 1147	175 mm	155.0
EFT 1156	180 mm	160.0
EFT 1157	195 mm	175.0
EFT 1158	210 mm	180.0
EFT 1148	200 mm	190.0

Transom no:		Dim: B
EFT 1149	45 mm	35.4
EFT 1150	60 mm	50.4
EFT 1151	85 mm	75.4
EFT 1143	85 mm	75.2
EFT 1164	105 mm	95.2
EFT 1144	115 mm	105.2
EFT 1152	135 mm	125.2
EFT 1154	150 mm	140.2
EFT 1145	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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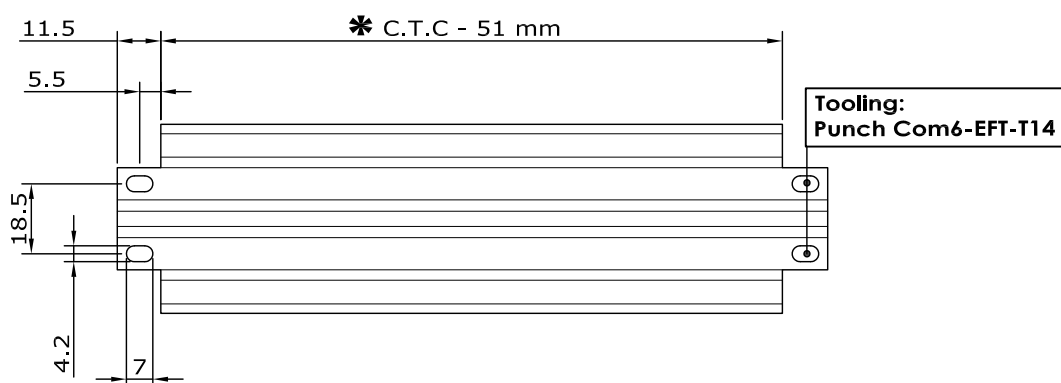
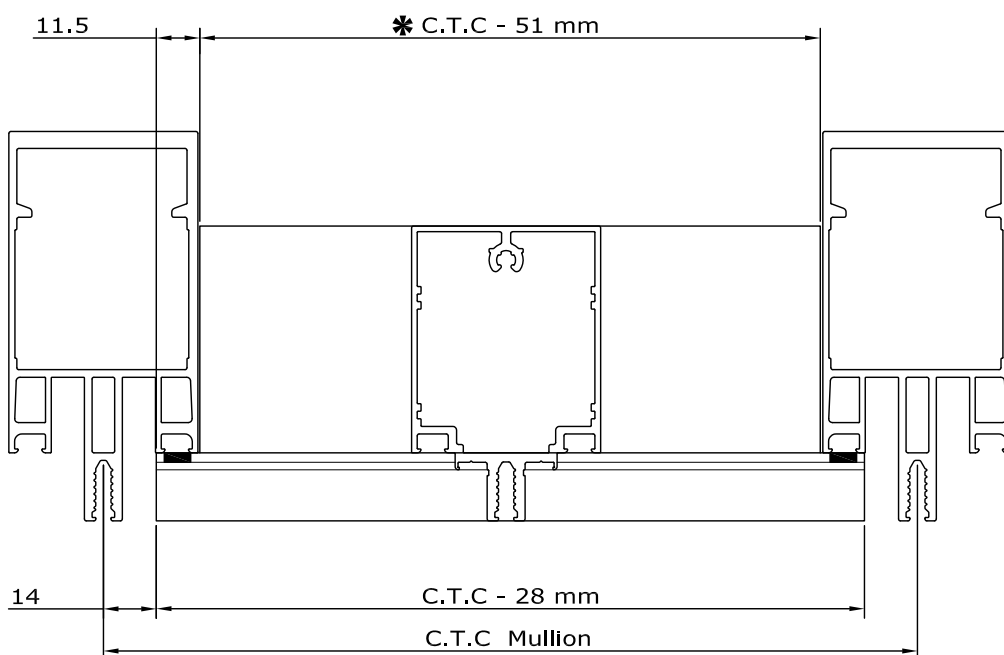
Fabrication
Comar 6EFT

Transom preparation

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6.23



Fabricators Guide

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

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



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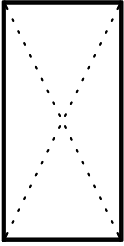
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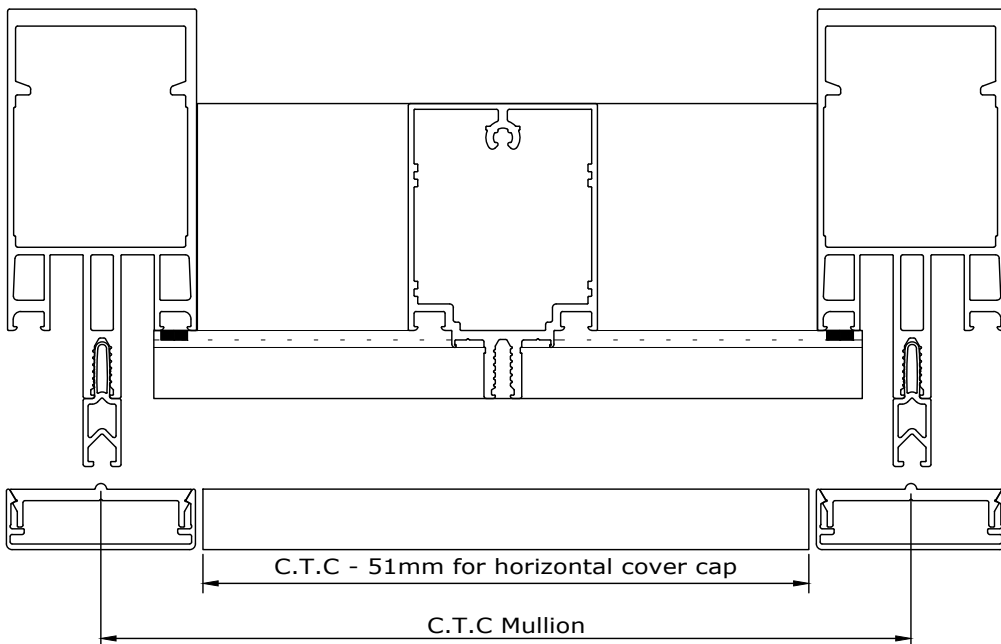
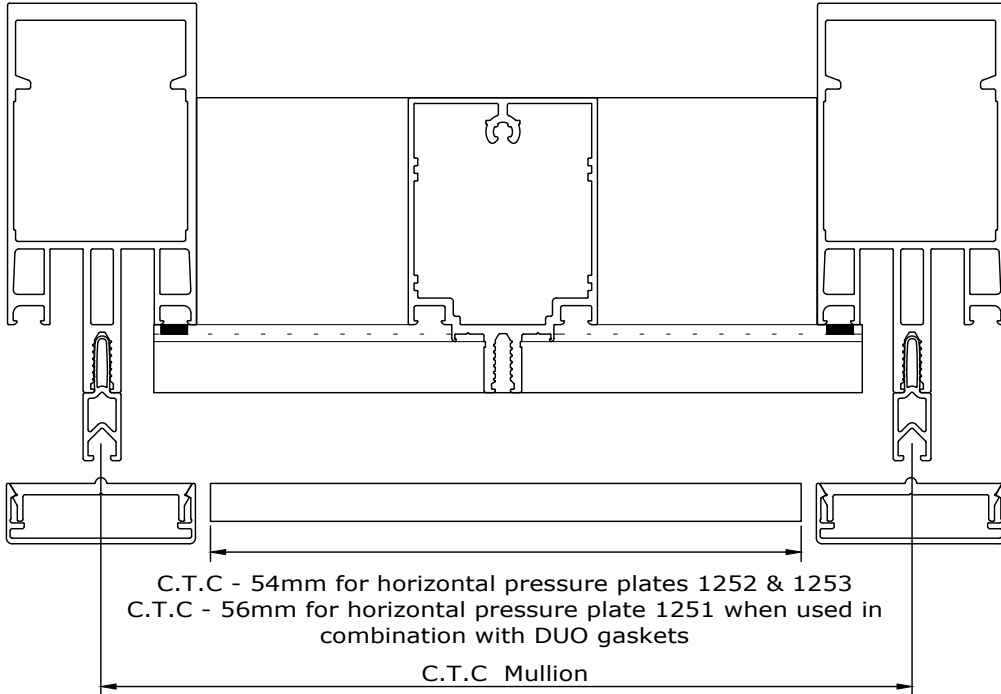
6

Comar 6EFT

Horizontal pressure plate & horizontal cover cap



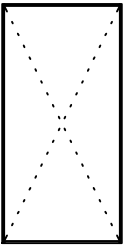
6.24



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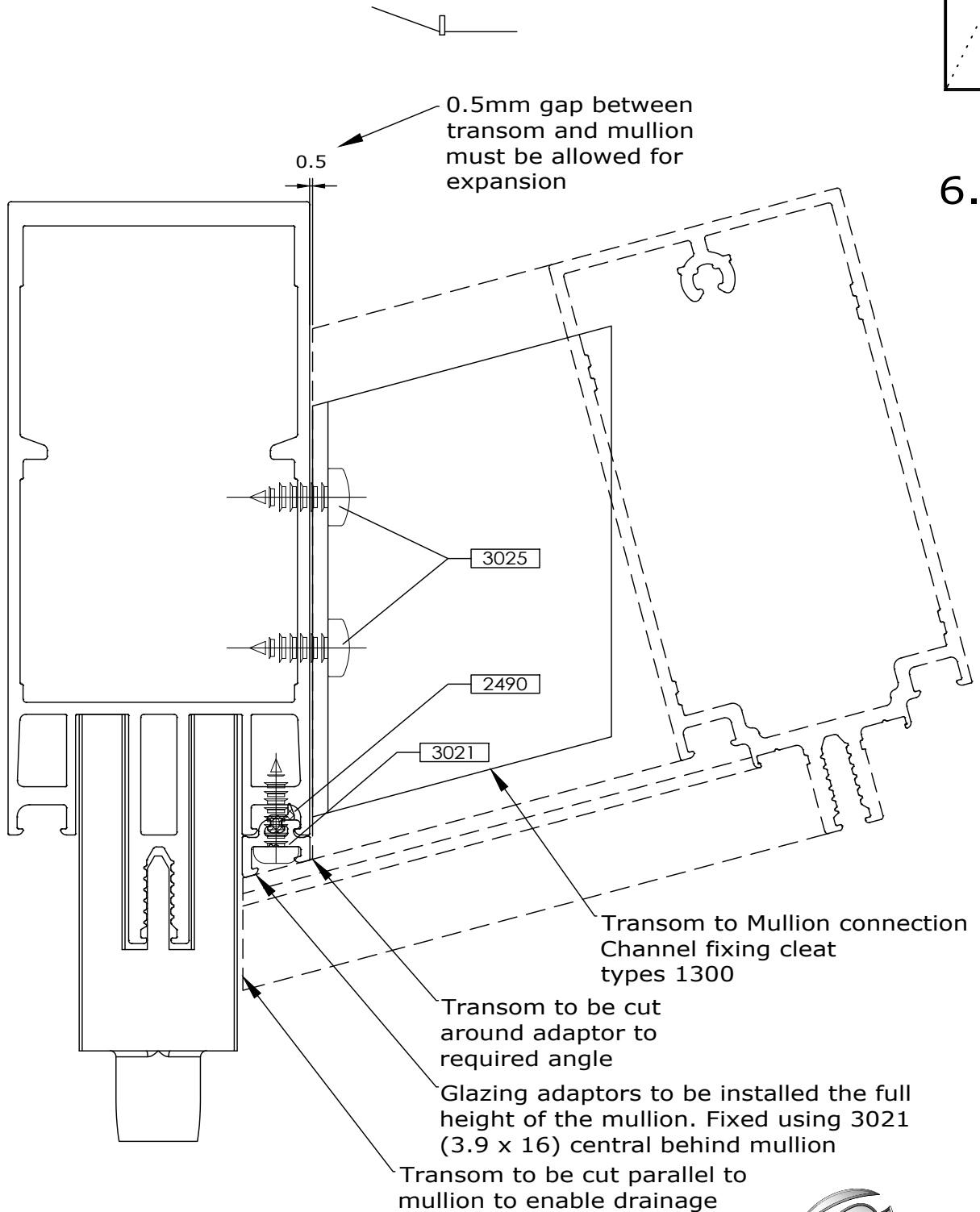
Facetted transom preparation
External Corner



6.25

Fabricators Guide

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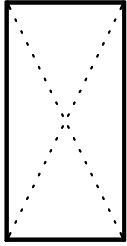
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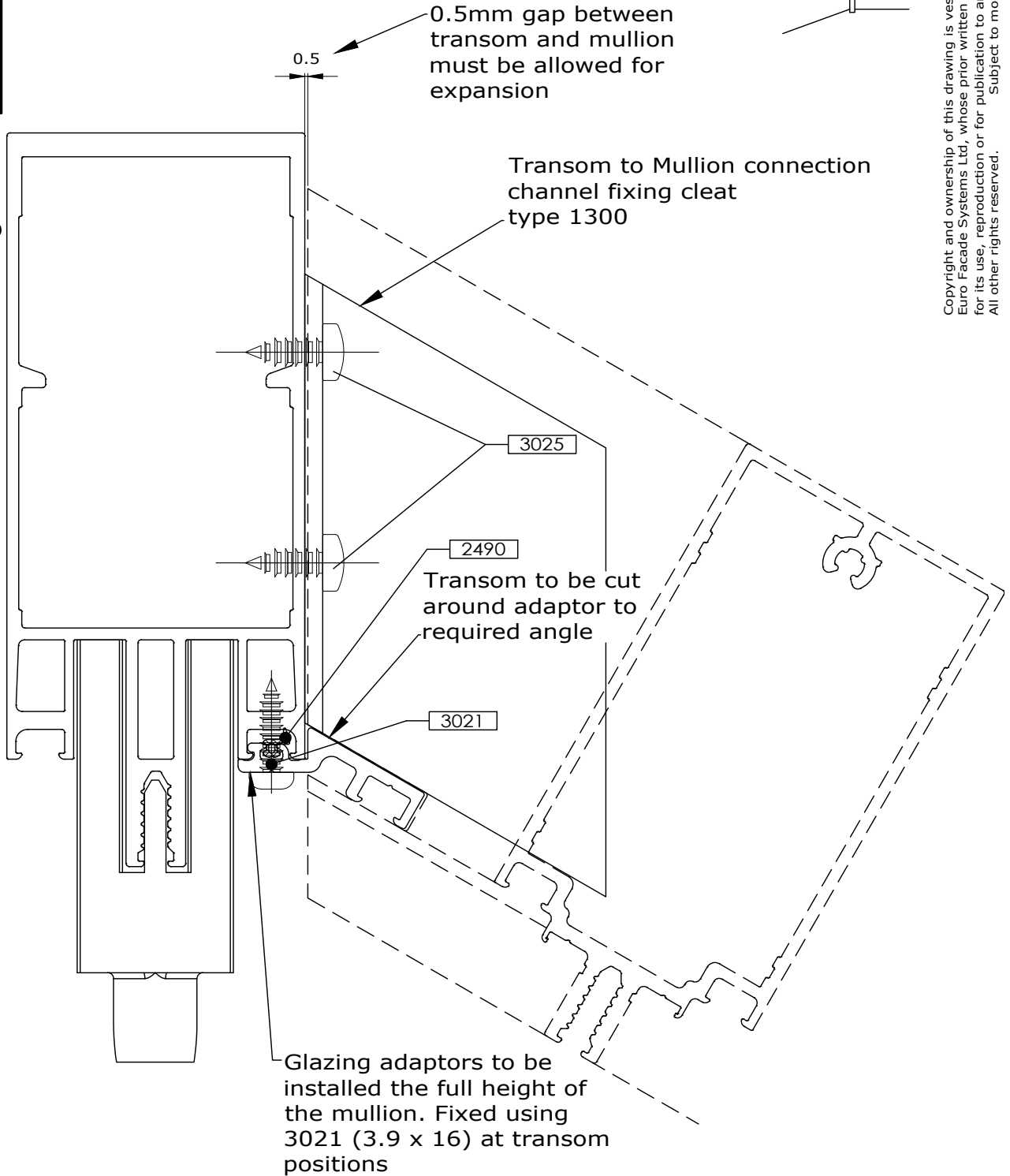
Comar 6EFT

Facetted transom preparation Internal Corner



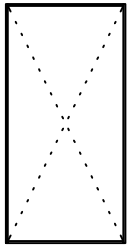
6.26

Fabricators Guide



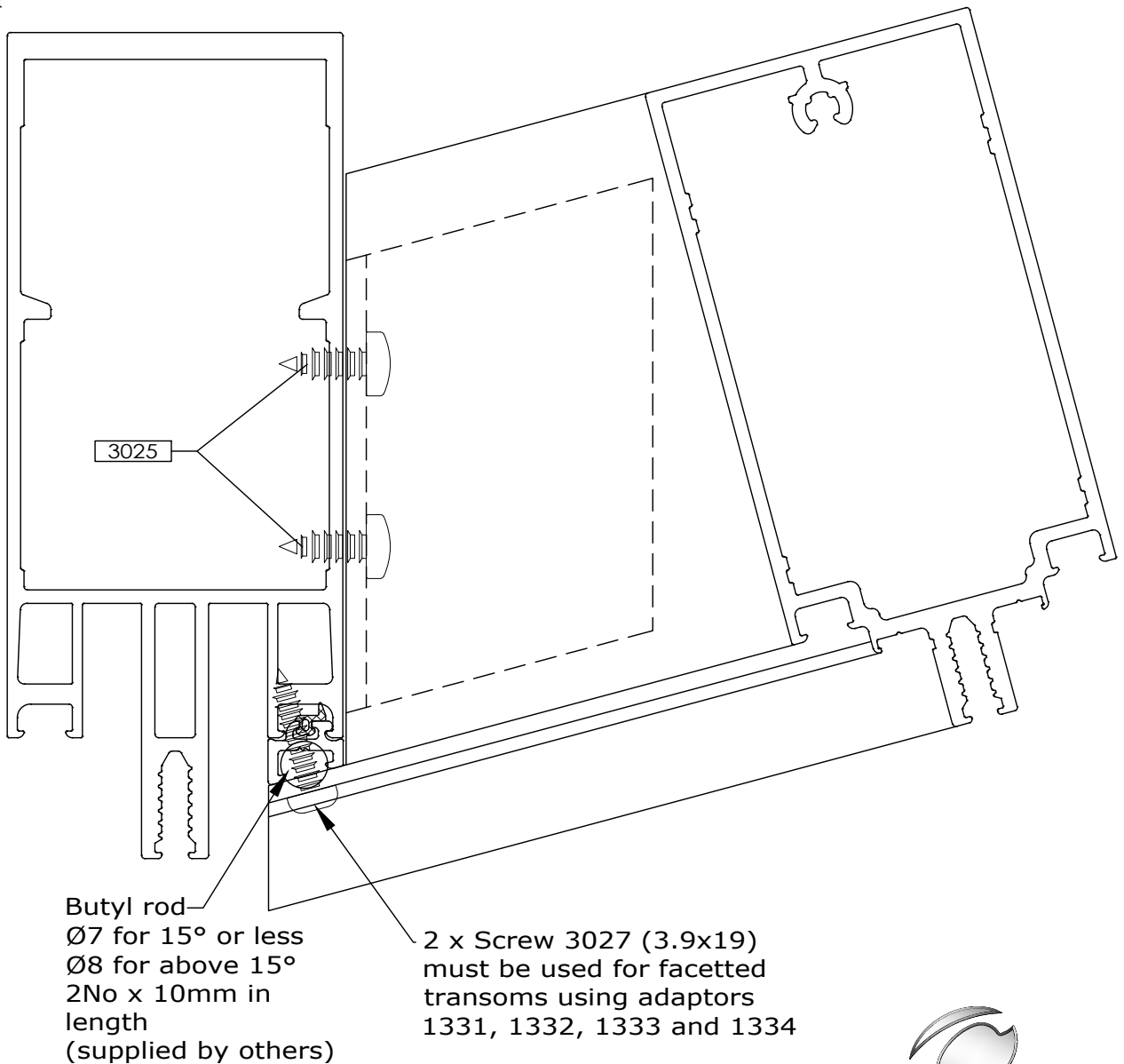
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Fixing facatted transoms
External Corner



6.27

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Butyl rod
Ø7 for 15° or less
Ø8 for above 15°
2No x 10mm in
length
(supplied by others)

2 x Screw 3027 (3.9x19)
must be used for facatted
transoms using adaptors
1331, 1332, 1333 and 1334

Fabricators Guide

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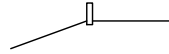
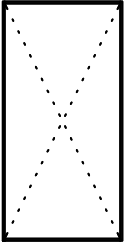
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Fabrication

6

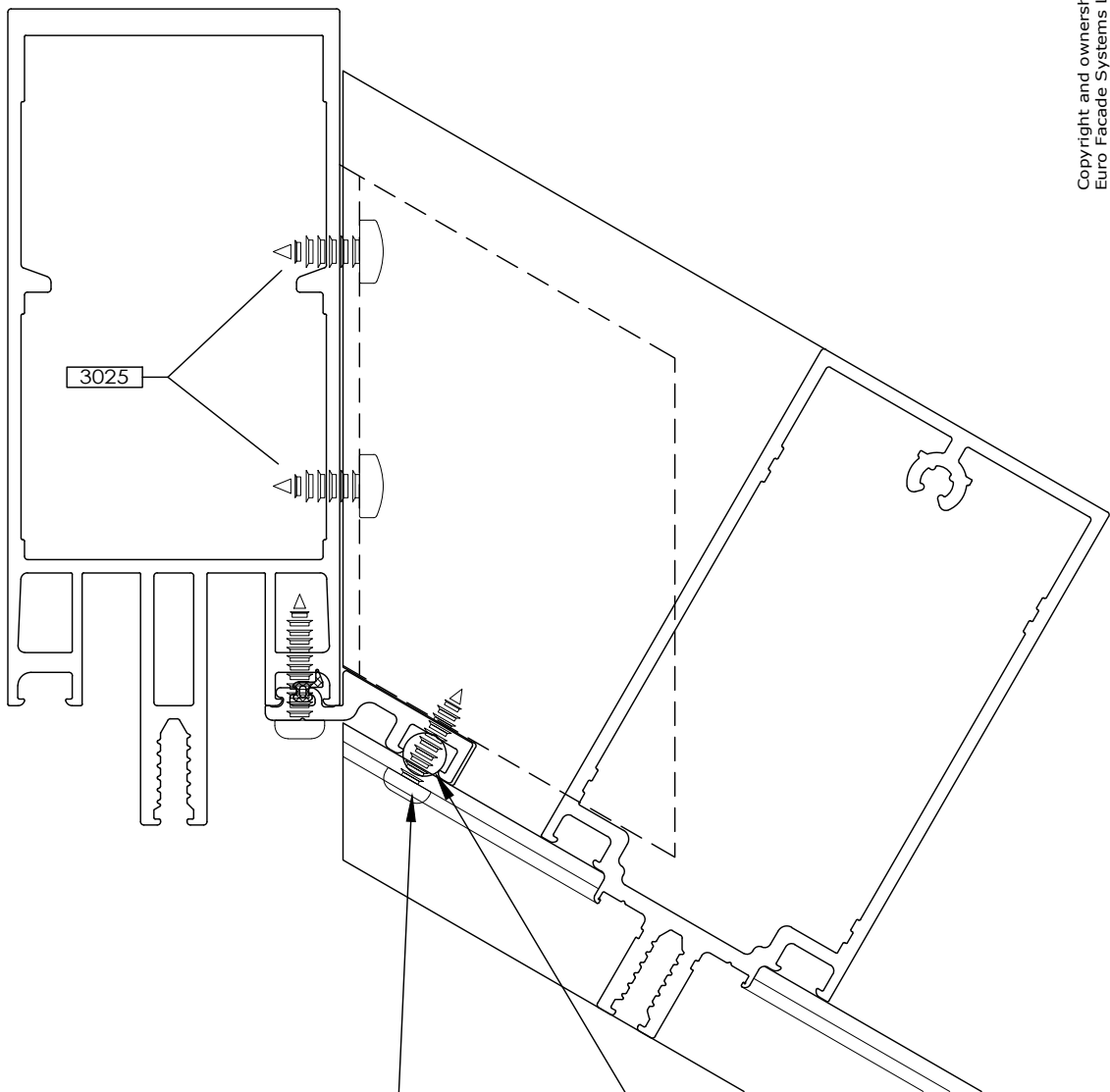
Comar 6EFT

Fixing faceted transoms Internal Corner



6.28

Fabricators Guide



Transoms to be fixed to adaptor with screws 3021 (3.9x16)

For exact angle adaptors ie 7.5°, 15° etc, use transom pad 2028. For all other angles use butyl rod, Ø8mm, 27mm long, supplied by others.

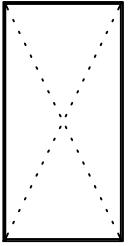
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Facatted transom cleat preparation

6

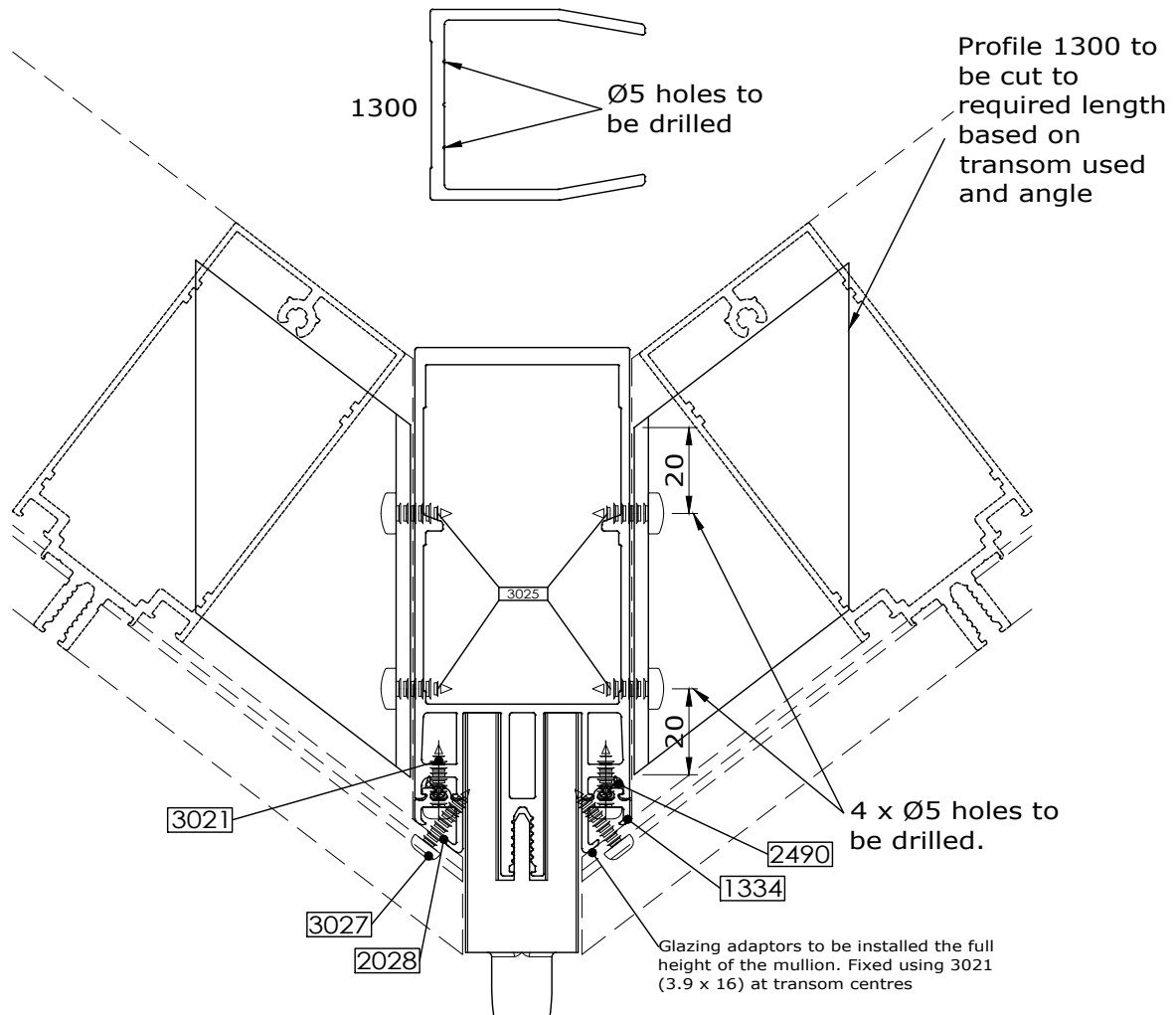
Fabrication
Comar 6EFT



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

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

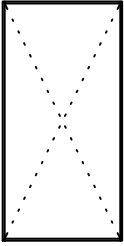
6.29



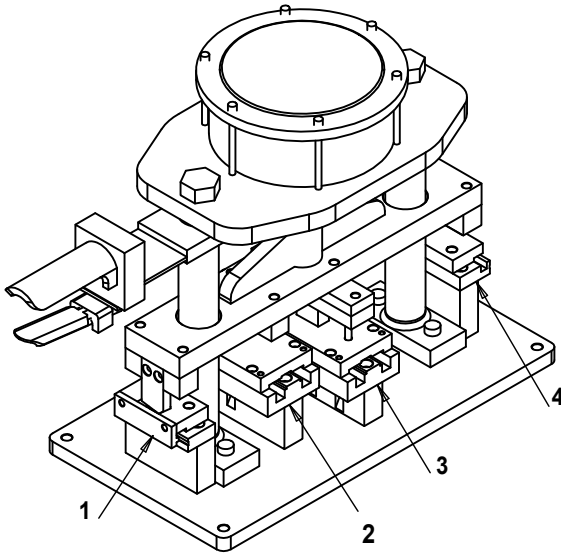
Fabricators Guide

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6.30



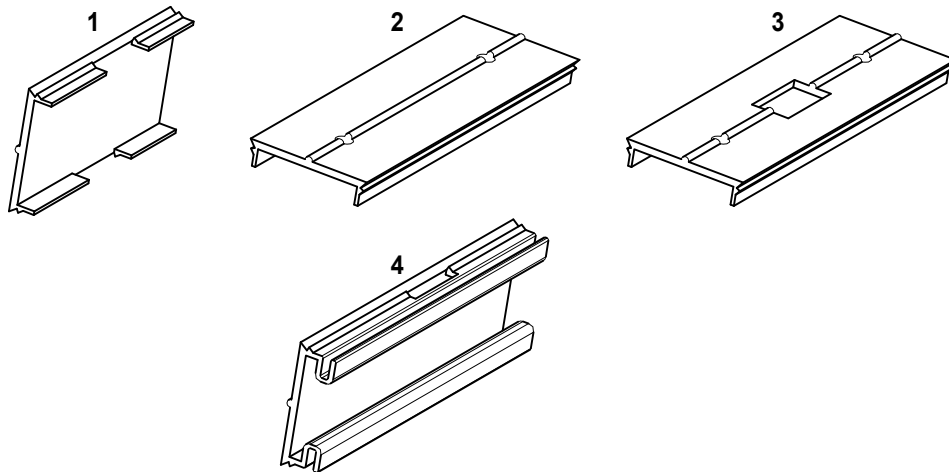
Preparations:

As per drawings: 6.31 & 6.36

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

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Tool: Pneumatic punch tool Com6-EFT-T14

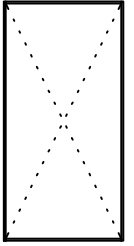


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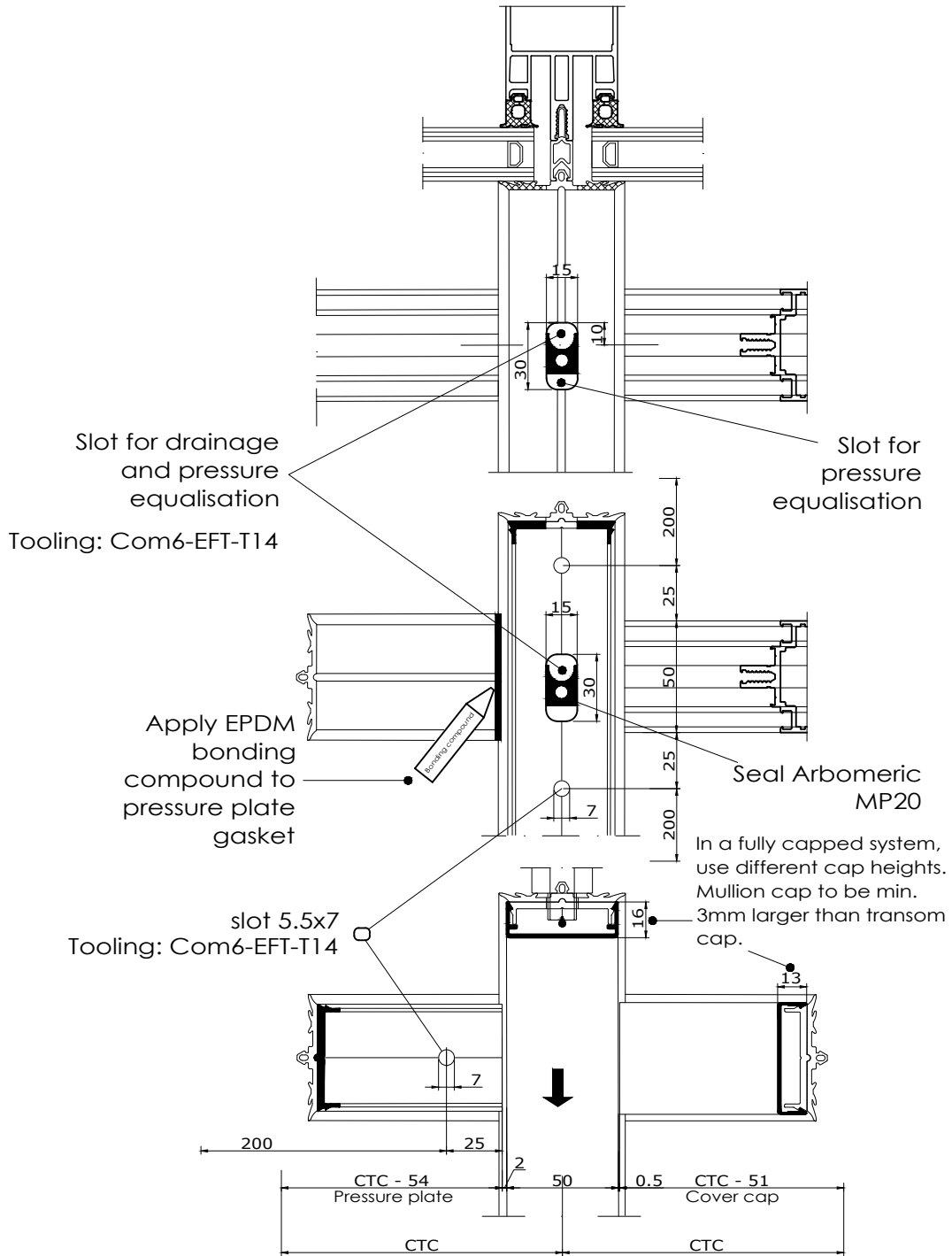
Single gasket installation

6

Fabrication Comar 6EFT



6.31



↓
= thermal expansion

Fabricators Guide

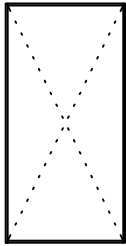
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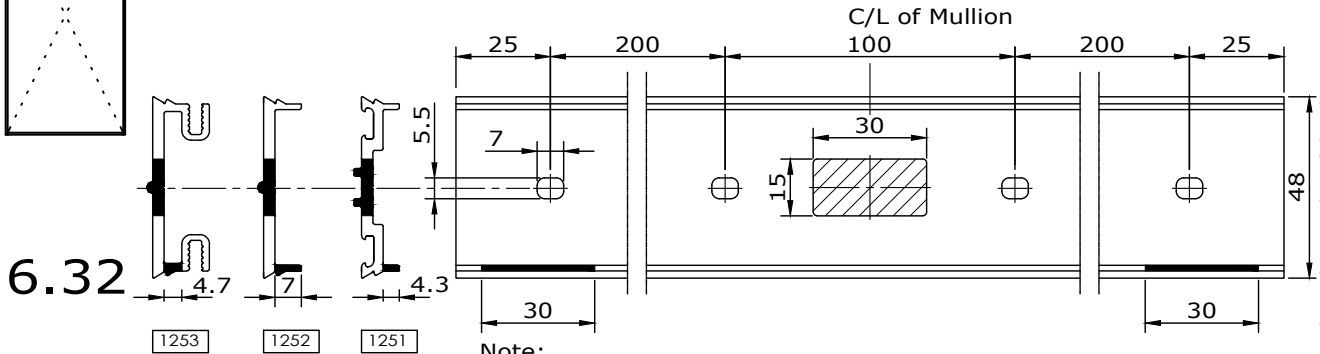


Comar 6EFT

Tooling:
Punch Com6-EFT-T14



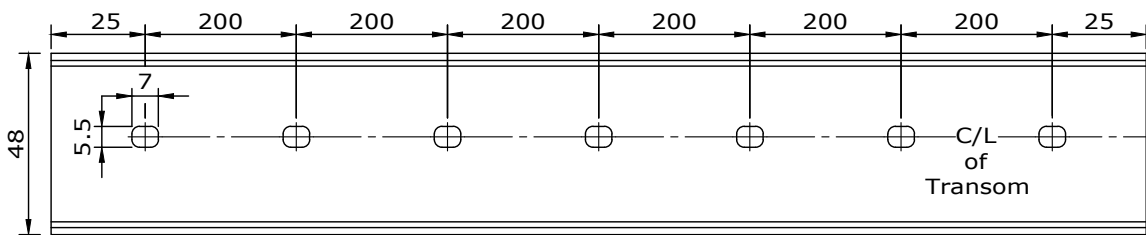
1A. Drainage slots & fixing holes Transom Pressure Plates
2sided SGH (Two Sided Structural Glazed Horizontal)



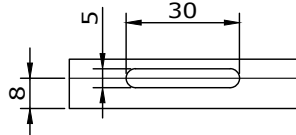
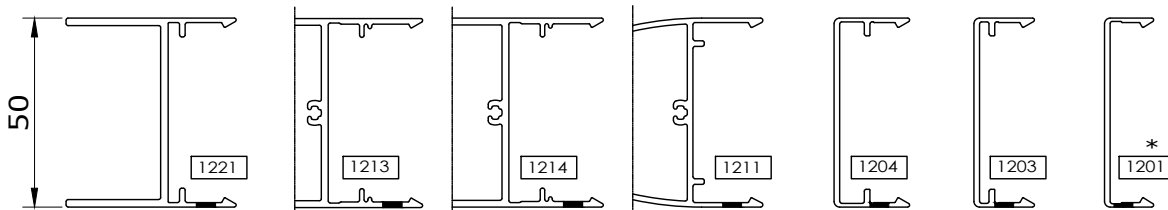
Note:
Fixing holes to be 25mm from edge and 200mm maximum centres.
Drainage slots to bottom of pressure plate to be 600mm cts. max.
30x15 drainage slot required at C/L of mullion positions.

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

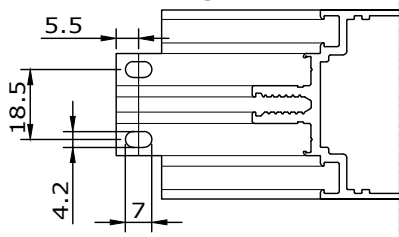


2. Drainage slots Transom Cover Caps
2sided SGH (Two Sided Structural Glazed Horizontal)



* 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

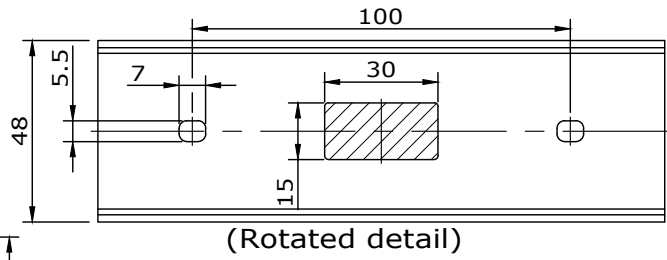
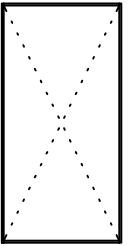


Fabricators Guide

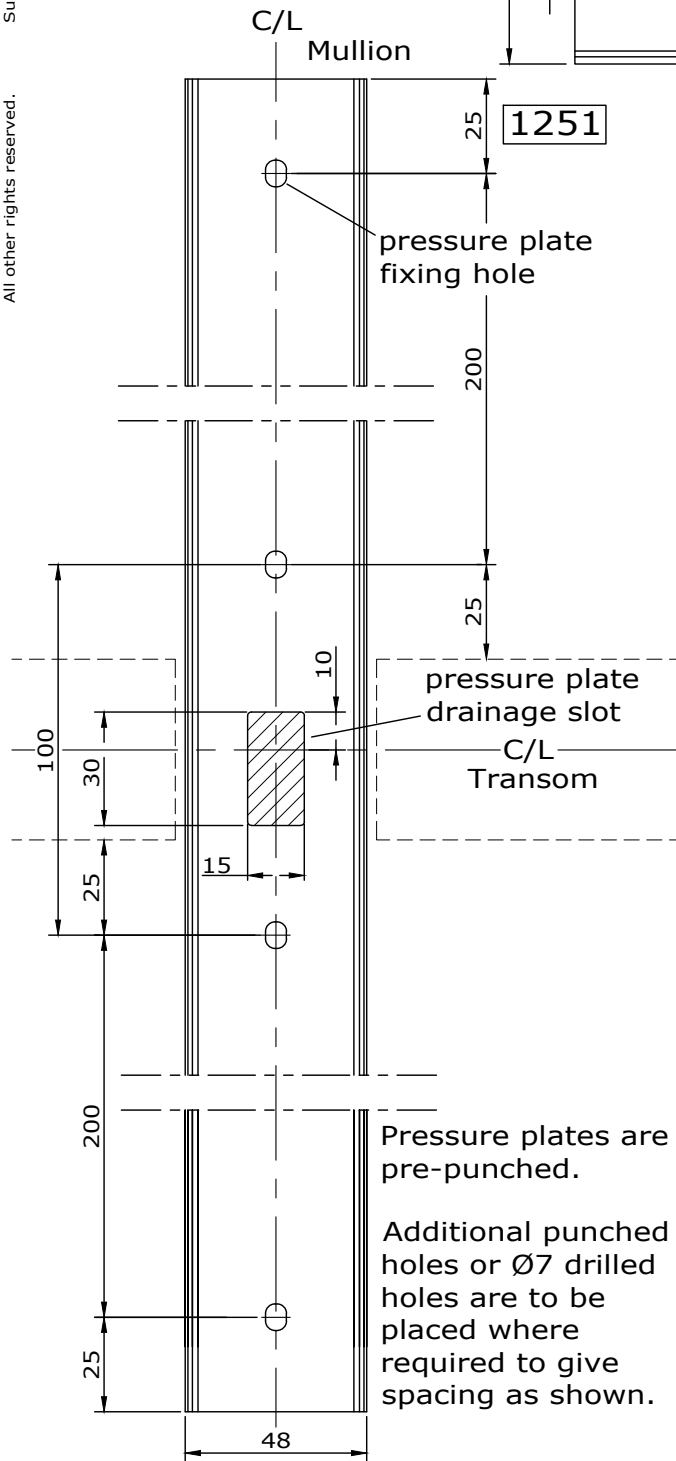


Tooling:
Punch Com 6-EFT-T14

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



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- 1251
- 1252
- 1253
- 1260
- 1261
- 1262
- 1263
- 1266
- 1267
- 1268
- 1269
- 1270

6.33

Pressure plates are pre-punched.
Additional punched holes or Ø7 drilled holes are to be placed where required to give spacing as shown.

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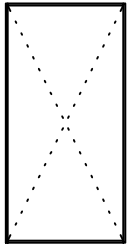
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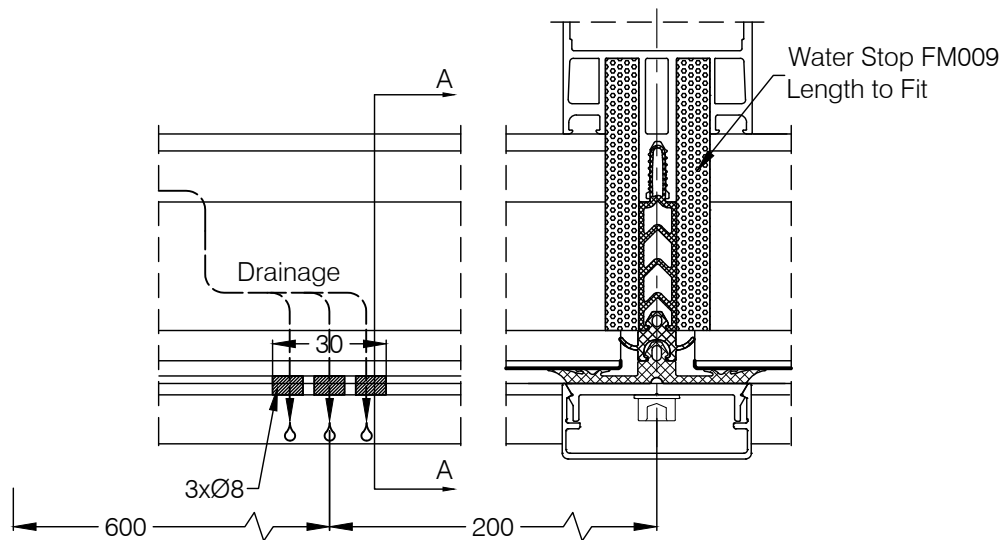
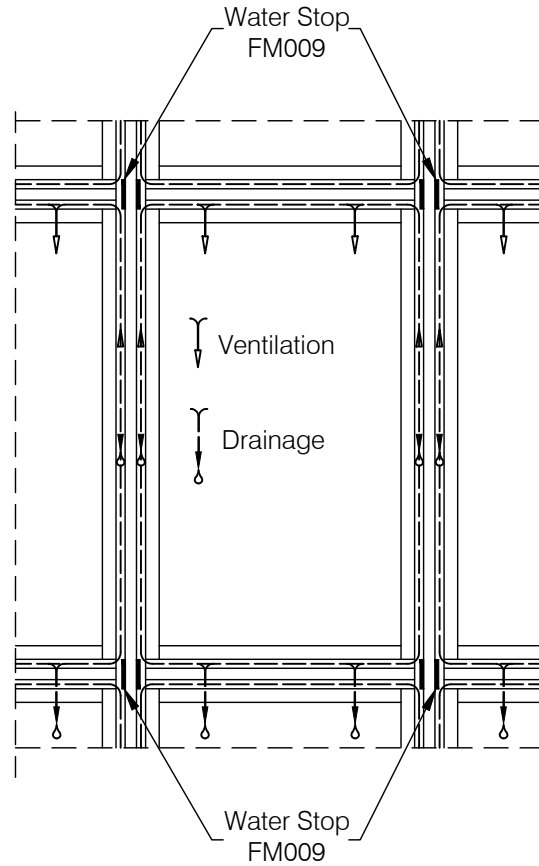
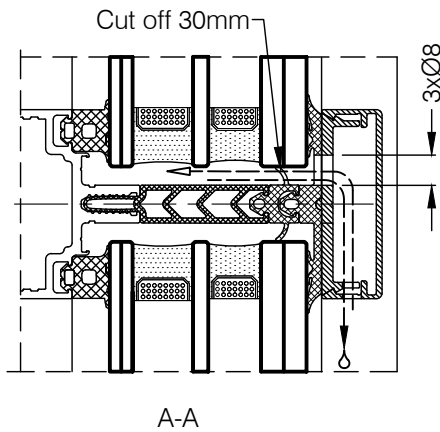
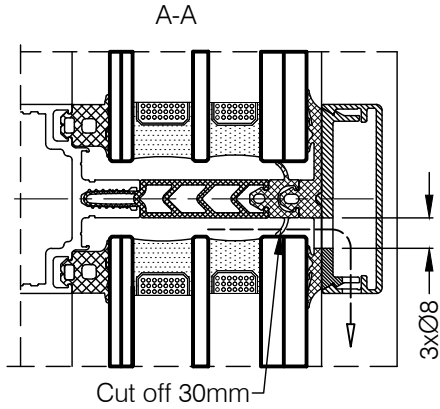
6

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6.34

Drainage & Ventilation by Individual Window



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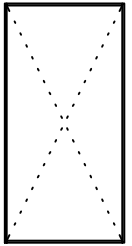
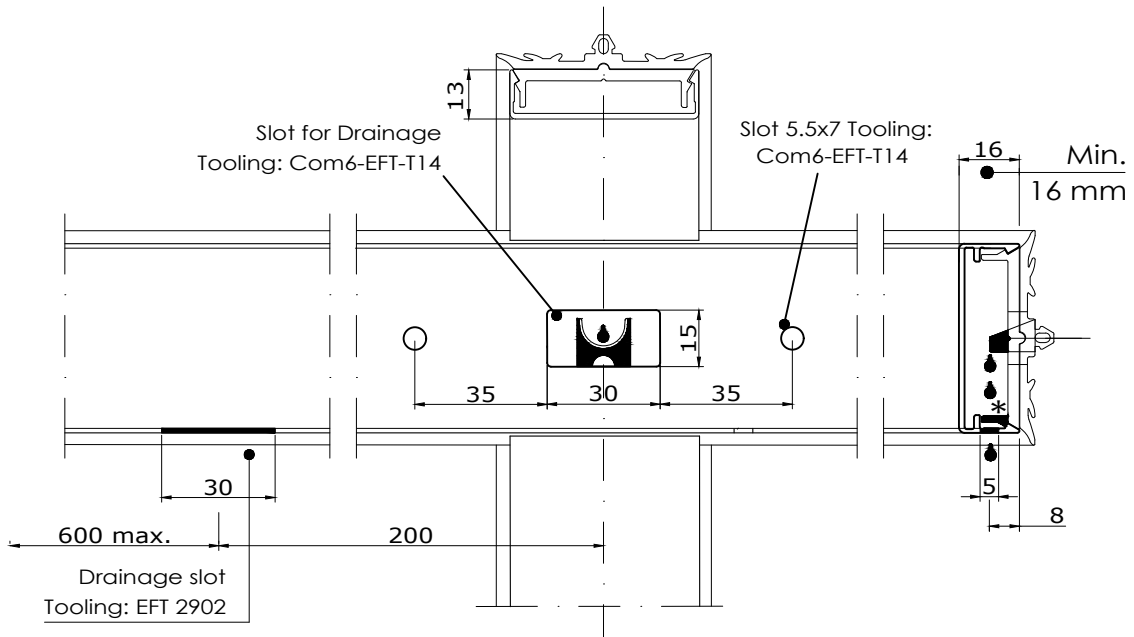
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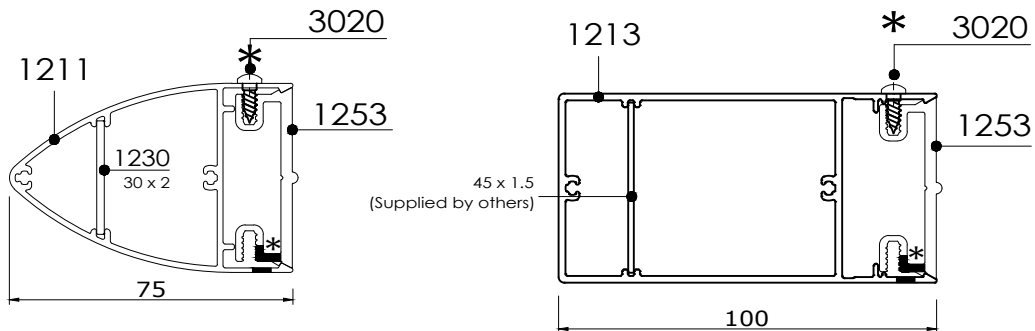
Draining horizontal

Comar 6EFT

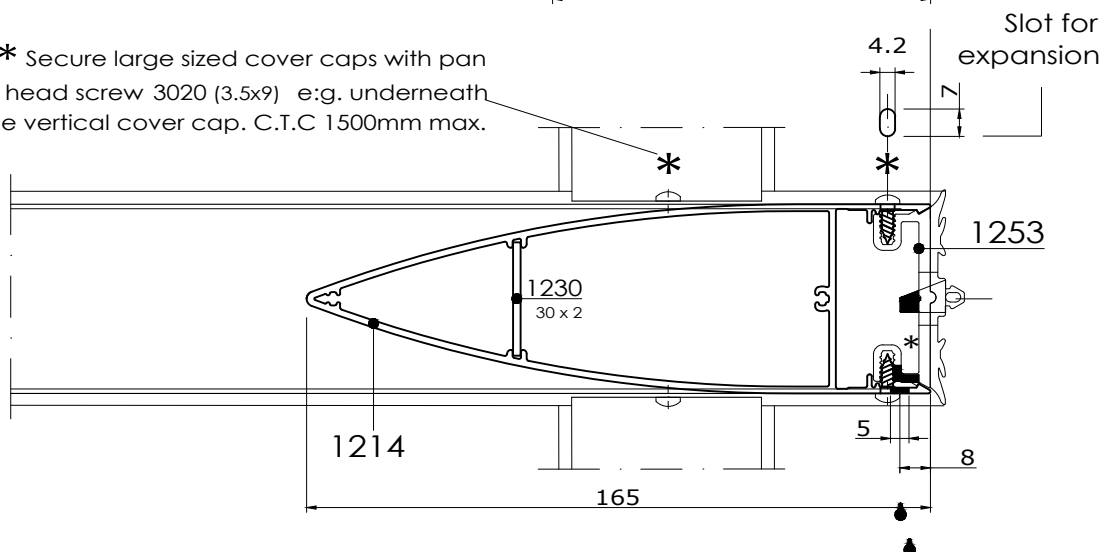


6.35

FIXING LARGE COVER CAPS



* Secure large sized cover caps with pan head screw 3020 (3.5x9) e.g. underneath the vertical cover cap. C.T.C 1500mm max.



Fabricators Guide

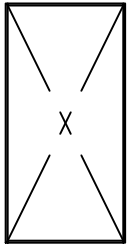
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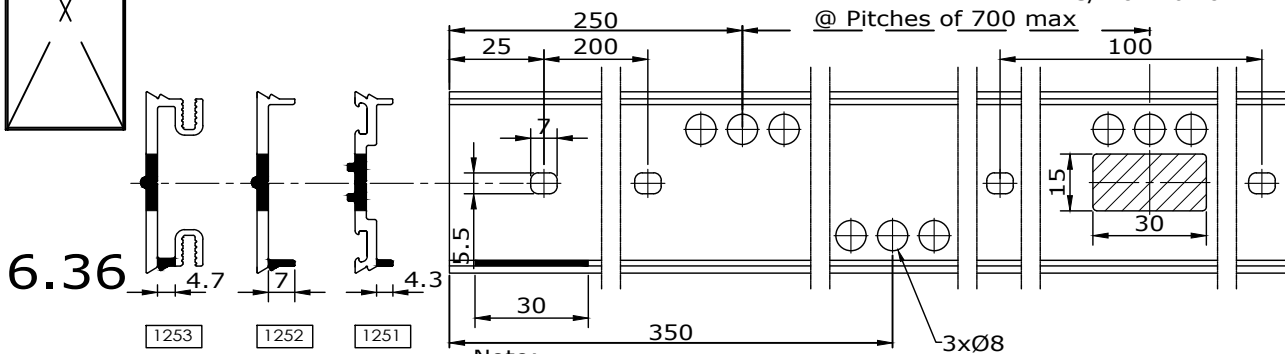


Comar 6EFT

Tooling:
Punch Com6-EFT-T14

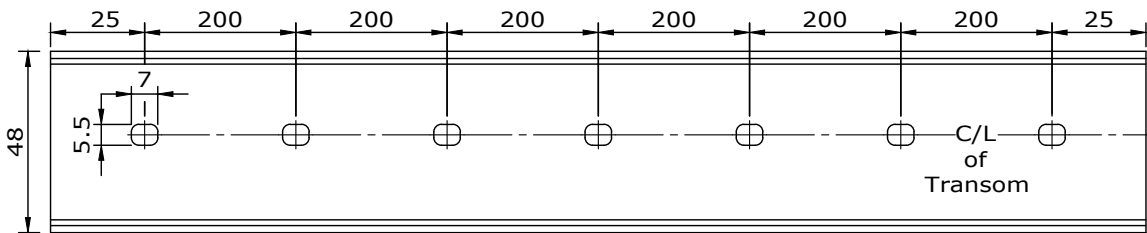


1A. Drainage slots & fixing holes Transom Pressure Plates
2sided SGH (Two Sided Structural Glazed Horizontal)

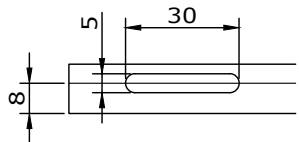
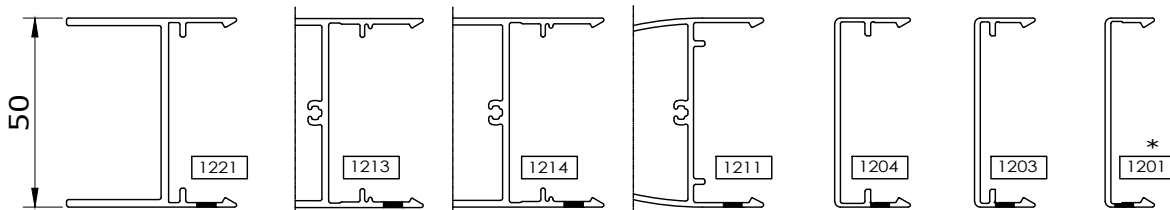


Note:
Fixing holes to be 25mm from edge and 200mm maximum centres.
Drainage slots to bottom of pressure plate to be 600mm cts. max.
30x15 drainage slot required at C/L of mullion positions.

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

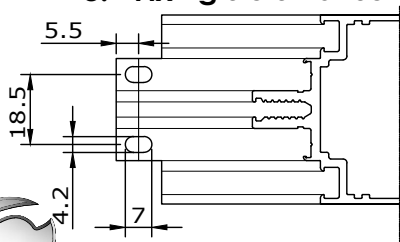


2. Drainage slots Transom Cover Caps
2sided SGH (Two Sided Structural Glazed Horizontal)



* 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

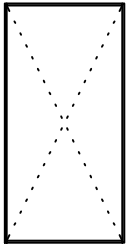
3. Fixing slots transom



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Panel & Single glazed frames

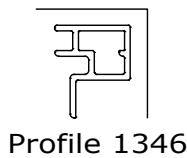


Profiles 1335 & 1346 to be cut to same dimensions as glass or panel

Between capped mullions/transoms: C.T.C - 22

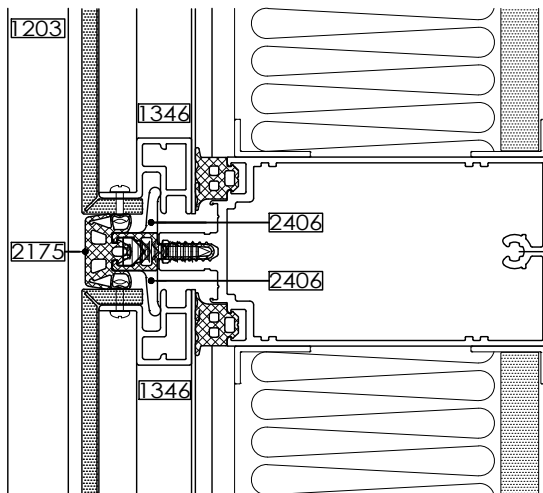
Between structural glazing mullions/transoms: C.T.C - 20

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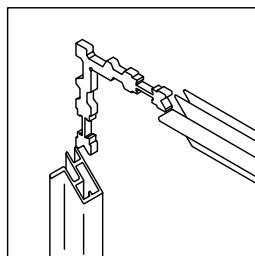


Profile 1346

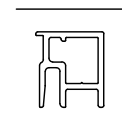
1346 between structural glazed joints when panels are required



EFT - 2539 Corner Cleat
EFT - 1346

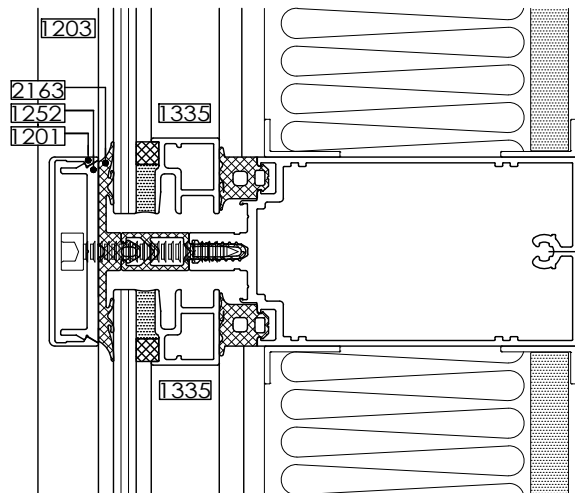


Frame lengths of 1346 to be mitred at 45° and crimped together using cleat 2539

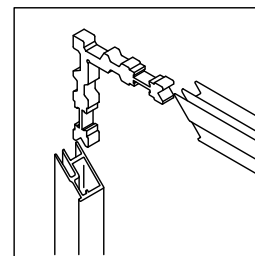


Profile 1335

1335 between capped joints when glazing joints are required



EFT - 2538 Corner Cleat
EFT - 1335



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

C.T.C - 20

C.T.C - 22

6.37

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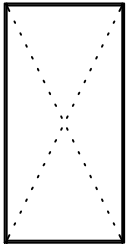
Issue: 05
Date: 10-16

Fabrication

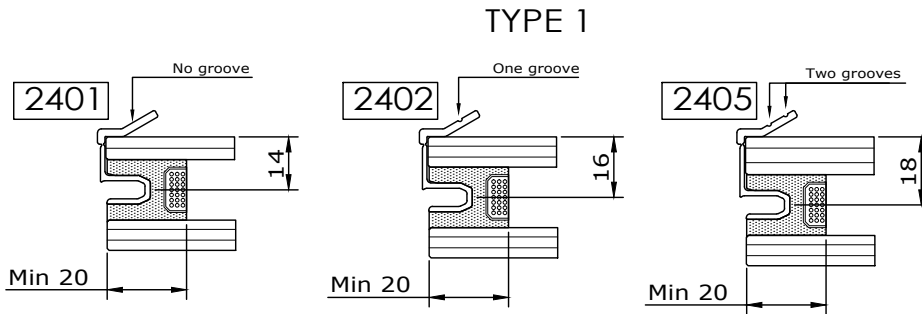
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Comar 6EFT

Glass inserts



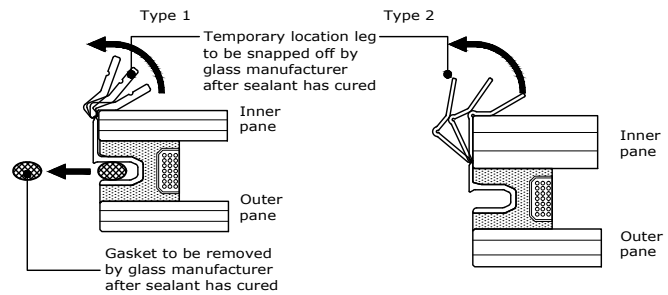
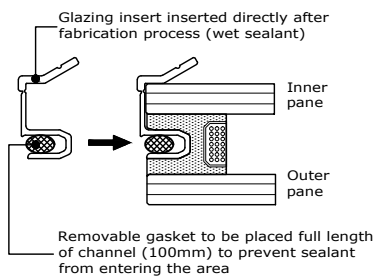
6.38



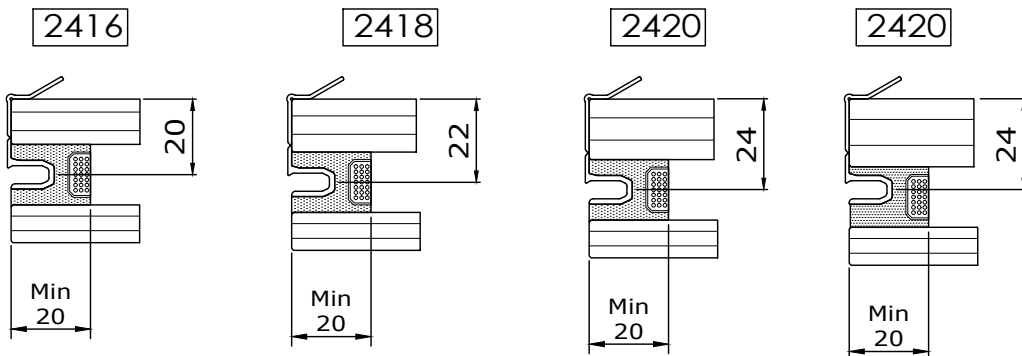
The Min.20mm to be set by your glass supplier according to standards and calculation.

1 Placing insert into spacer bar

2 Removing snap off leg & gasket



TYPE 2



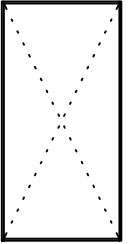
The Min.20mm to be set by your glass supplier according to standards and calculation.

6

Fabrication

Comar 6EFT

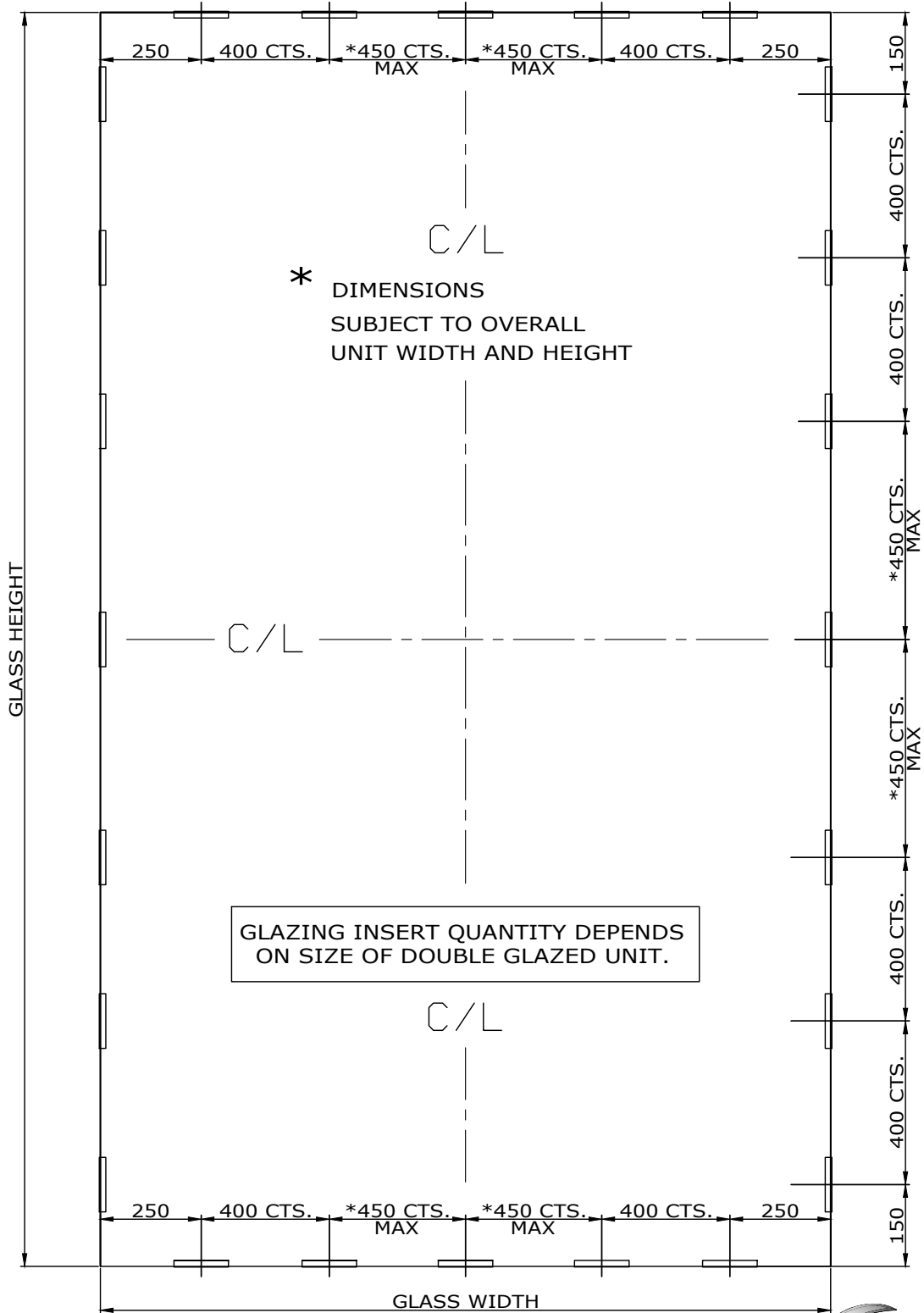
Location of glazing inserts



6.39

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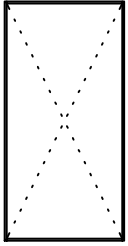
Issue: 05
Date: 10-16

Fabrication

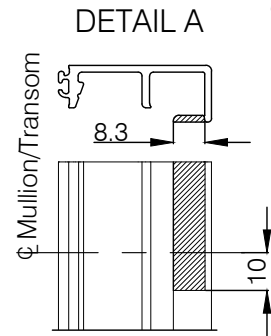
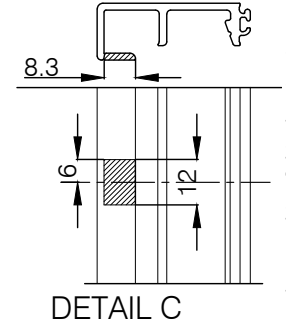
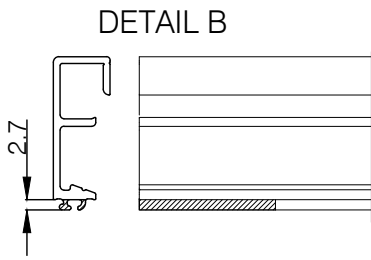
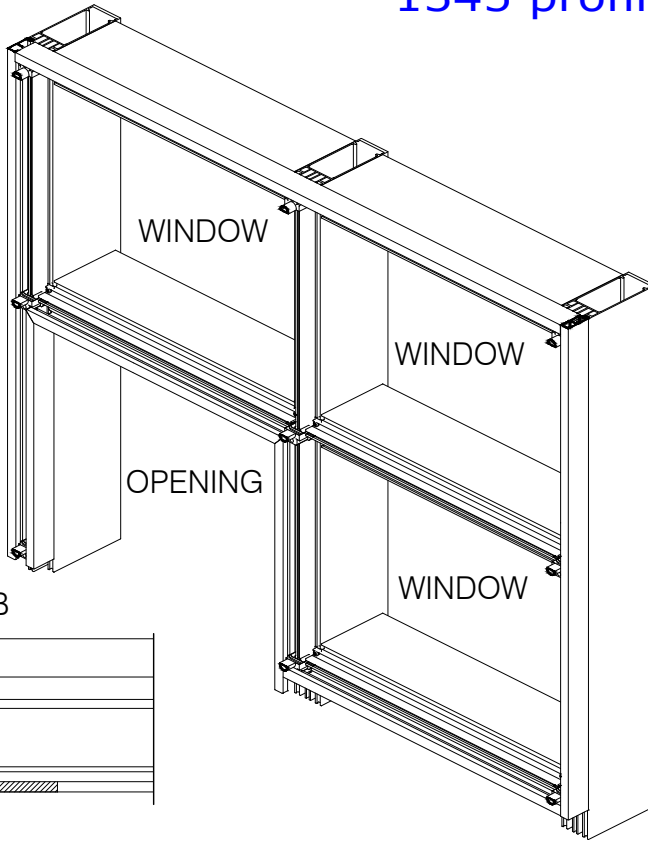
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Drainage diverter & 1345 profile preparation

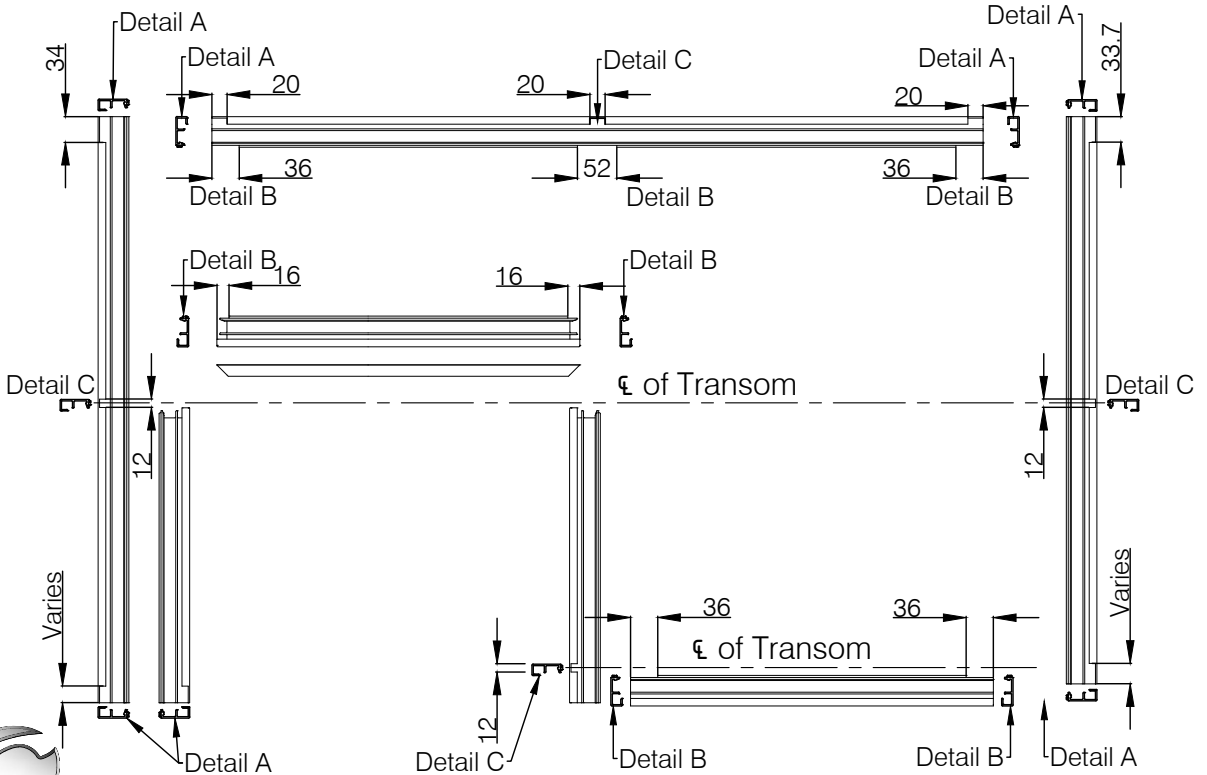


6.40

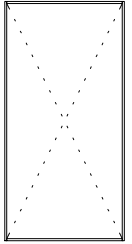


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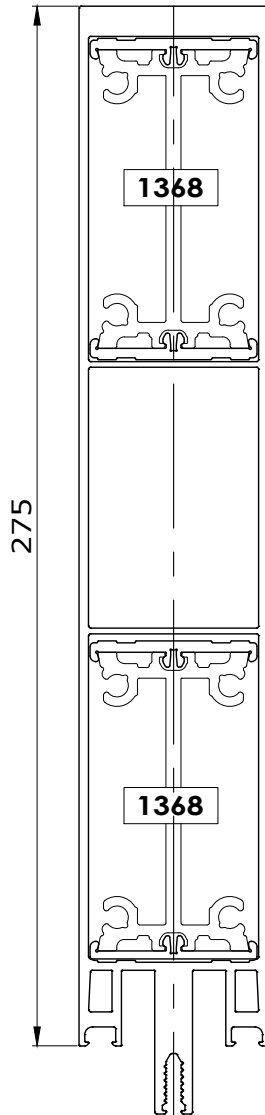
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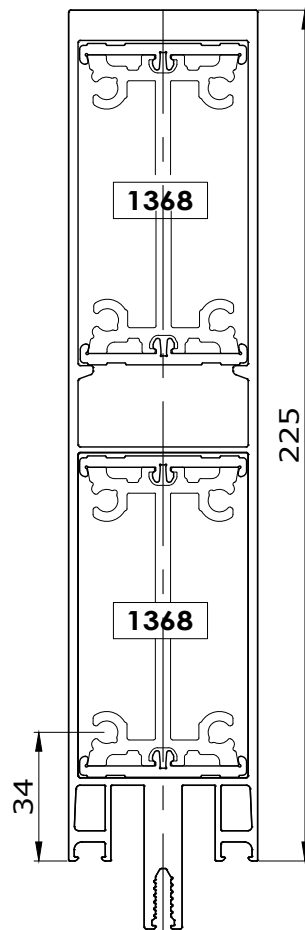
Mullion sleeve plate 1087- 225mm & 1090- 275mm



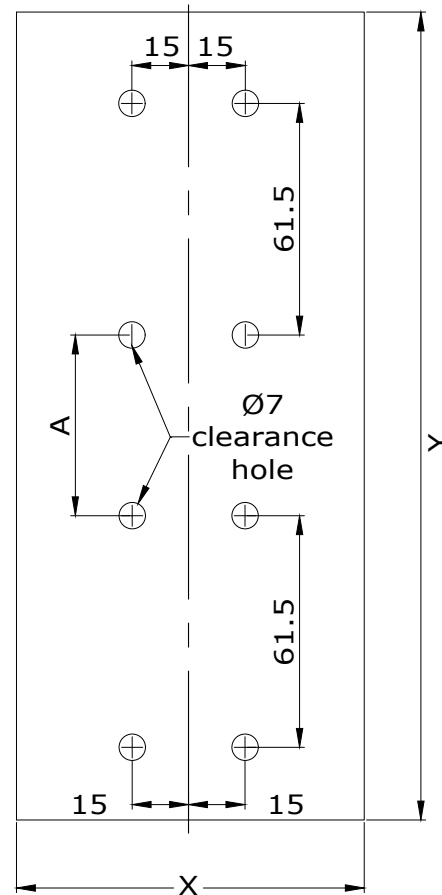
Mullion number	Dim A
1087	48
1090	98



1090



1087



6.41

Front plastic cover
cap cut back as
needed to fit EPDM

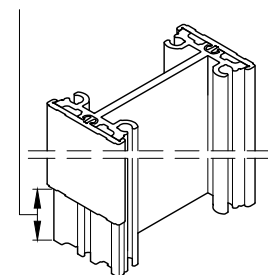


Plate supplied by others

Use $\text{Ø}6.3\text{mm}$ number 14 x 25mm self tapping screw, countersunk (supplied by others) or plate can be welded.

Length & width of plate and anchor bolts to be determined by site conditions and to structural engineers specification.

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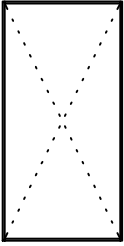
Issue: 05
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Fabrication

6

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Mullion shoe bracket

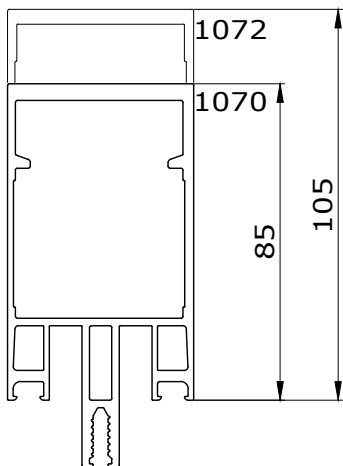
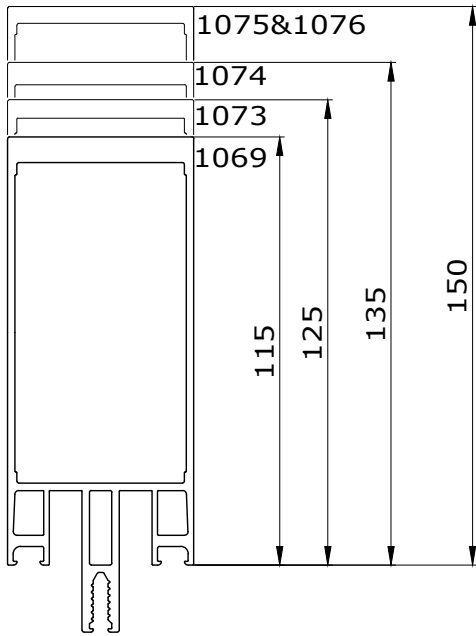


6.42

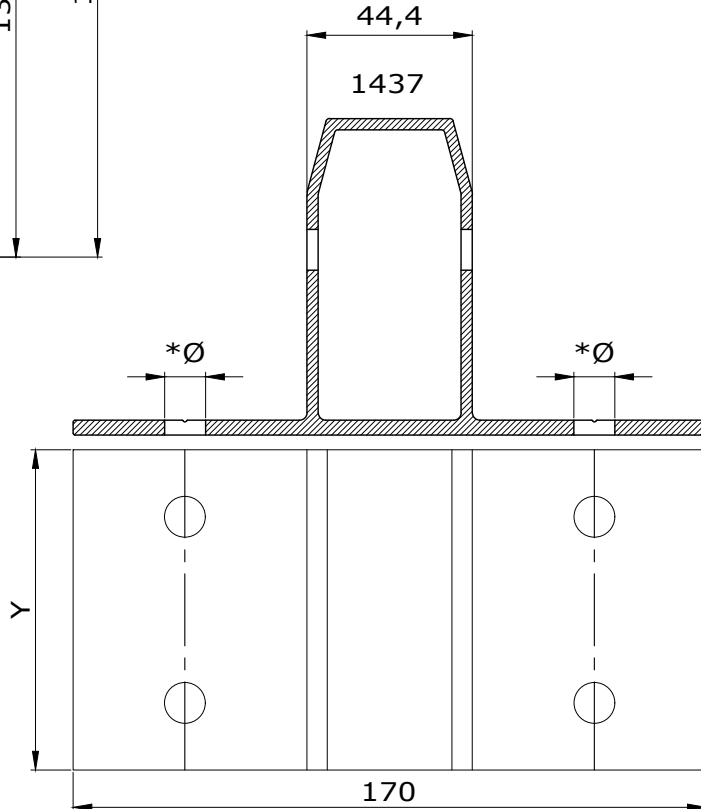
Mullion number	Size "Y" of Bracket	
	Bottom	Top
1070, 1072	36mm	39mm
1069, 1073 1074, 1075 1076	82mm	85mm
1077, 1080 1082, 1085	36mm 82mm	39mm 85mm
1087, 1090	2x 82mm	2x 85mm

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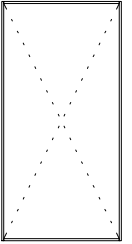
Fabricators Guide



*Size of anchor bolts to be determined by site conditions and to structural engineers specification.



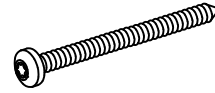
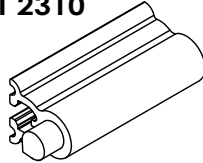
Mullion 1087 & 1090
Preparation



Transoms installed in
between ladders

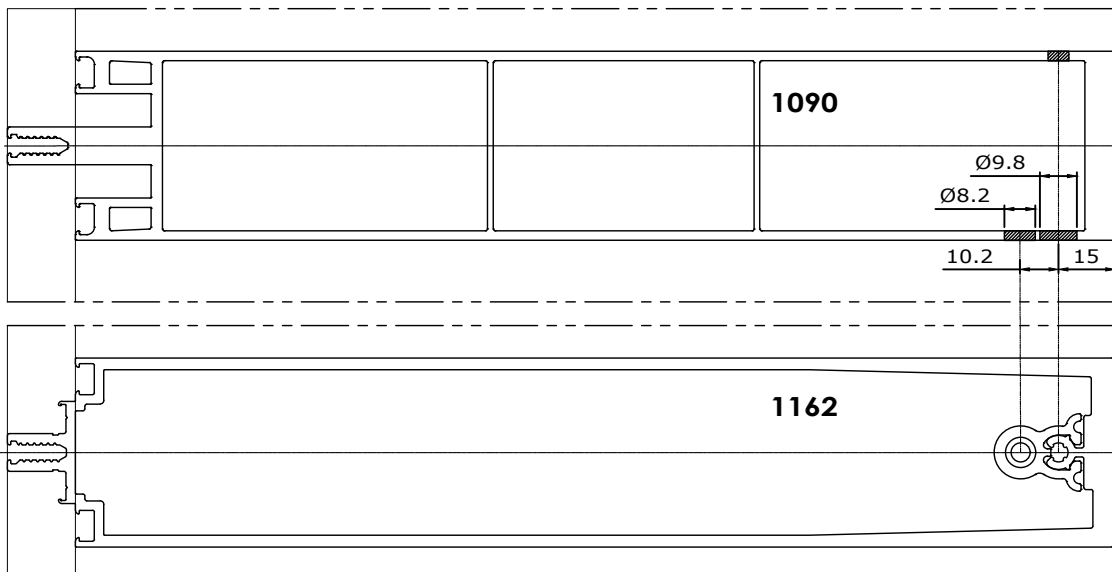
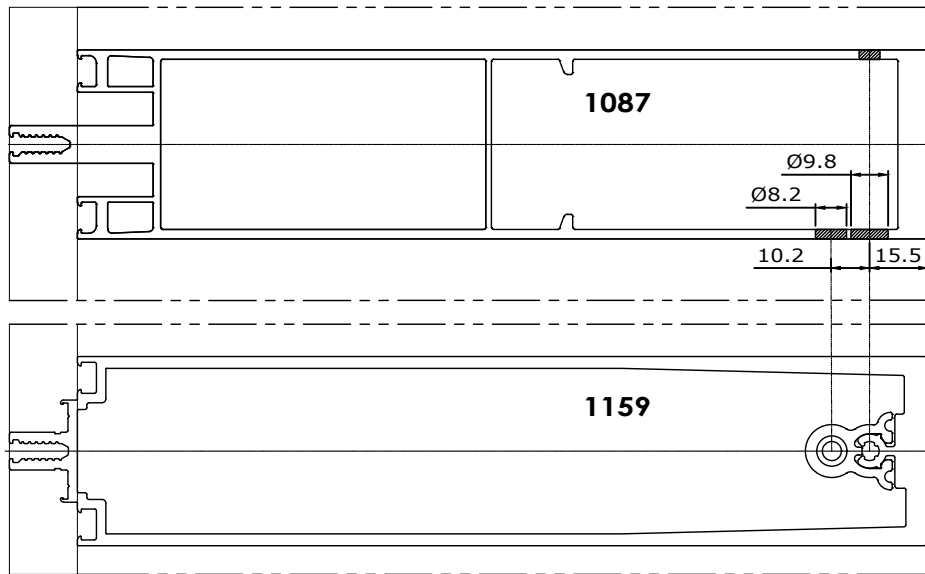
Ladder / unit

EFT 2310



3022 (4.8 x 65)

6.43



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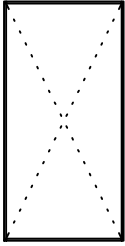
Installation

6

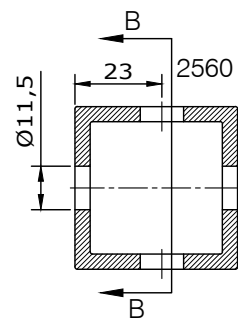
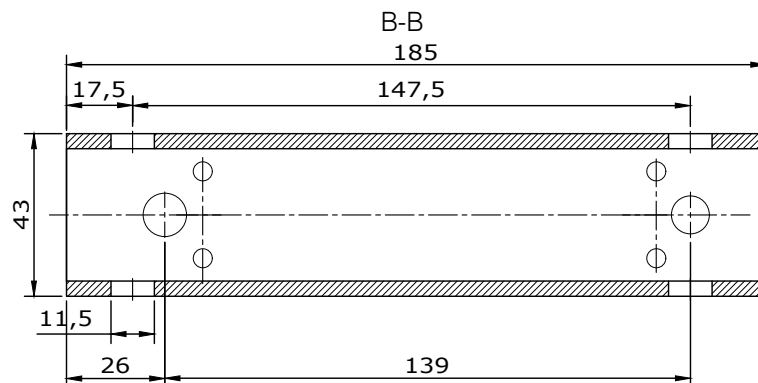
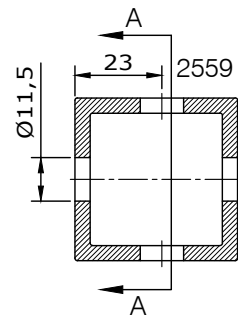
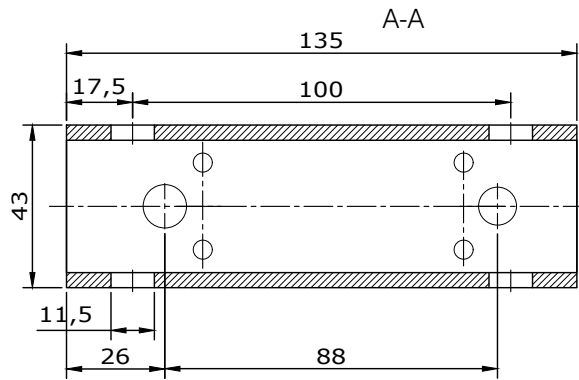
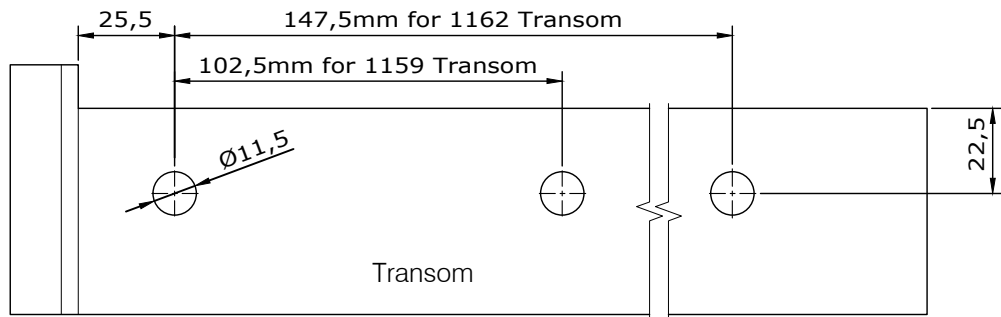
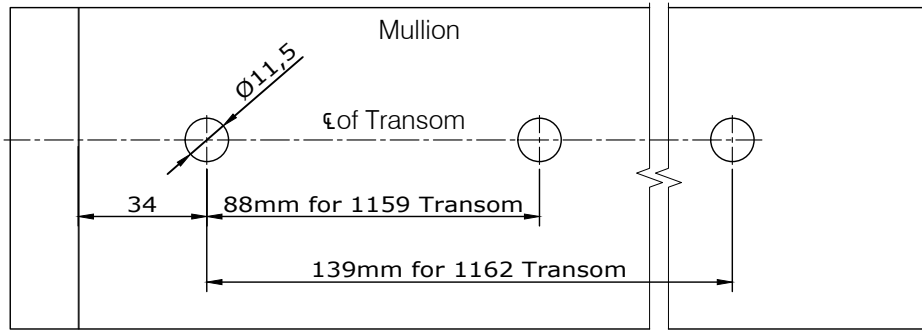
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Mullion - Transom Connection

Option: 5 Glass weight max 450 kg



6.44



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