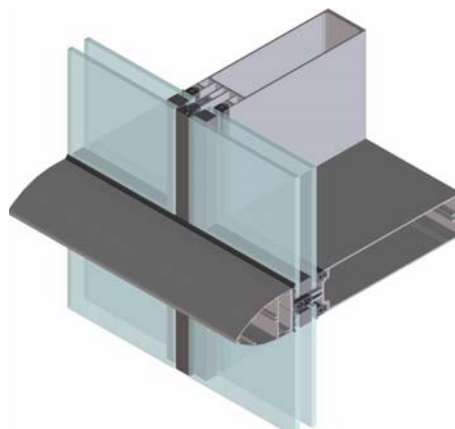
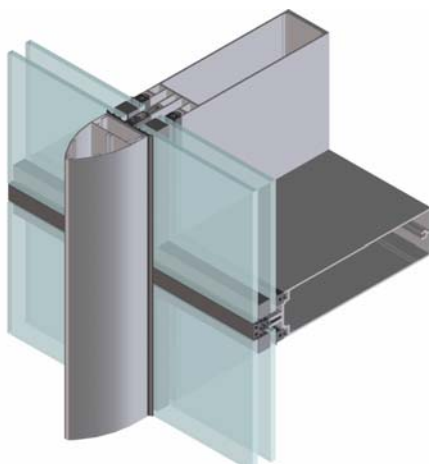


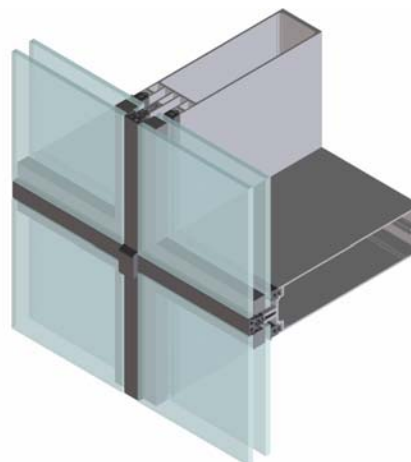
Capped



2sided SGH



2sided SGV

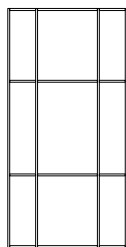


4sided SG

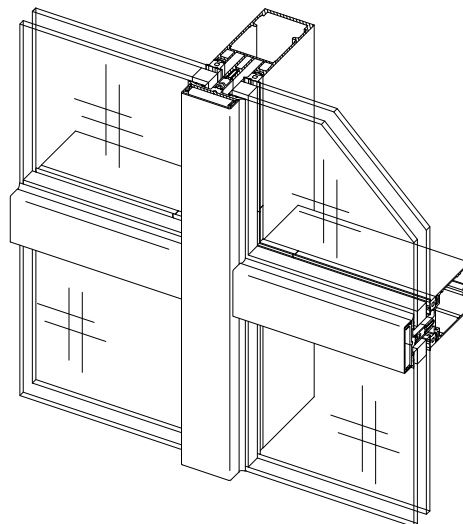
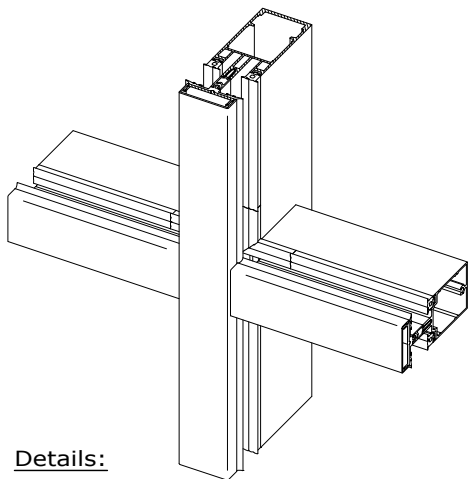
## Fabrication

6

## Comar 6EFT

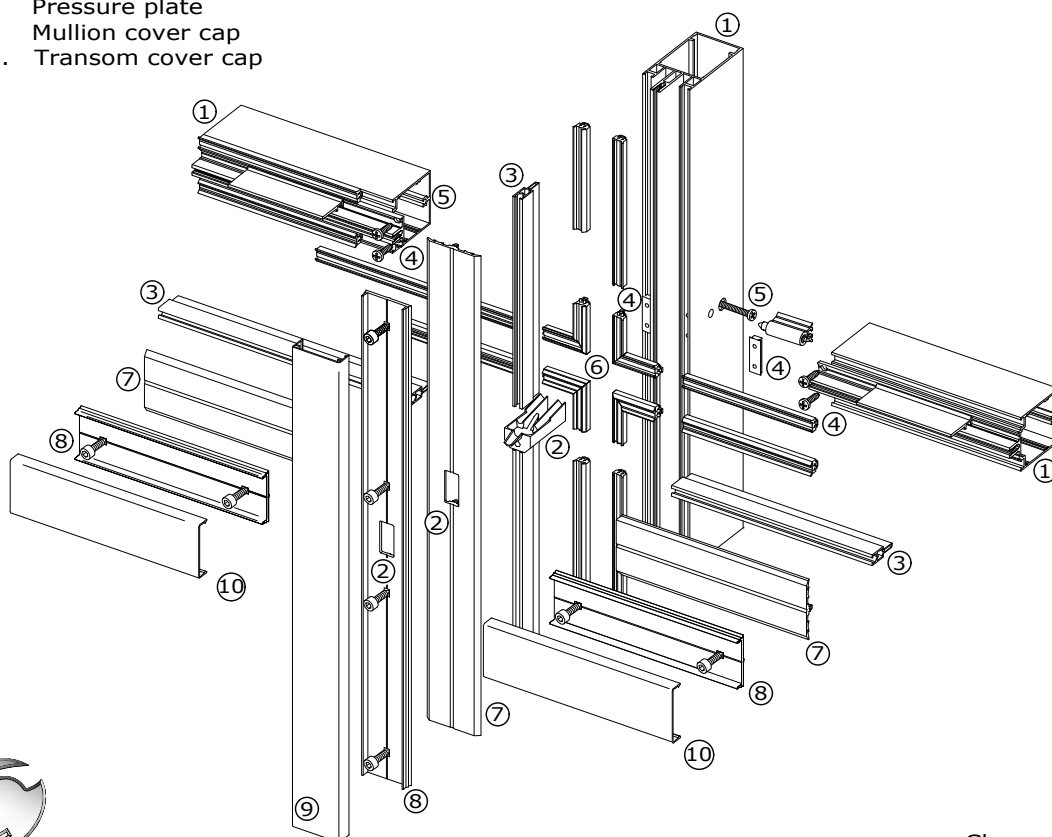


6.00

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
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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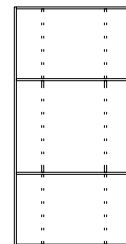
comar

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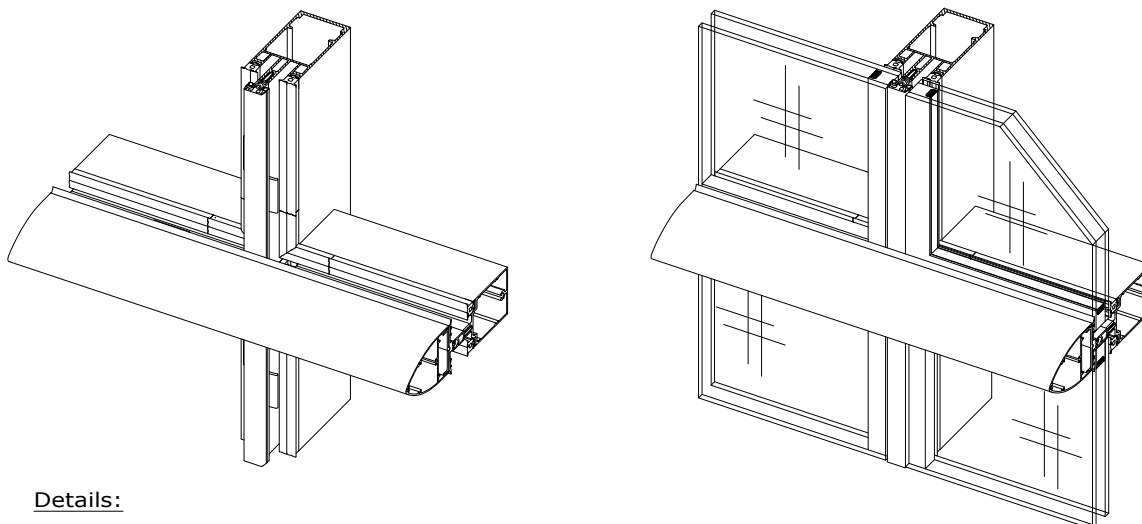
Changes reserved  
Sous reserve de modifications  
Änderungen vorbehalten

Issue: 05  
Date : 10-16

## Exploded typical details Horizontal cover cap (2sided SGH)

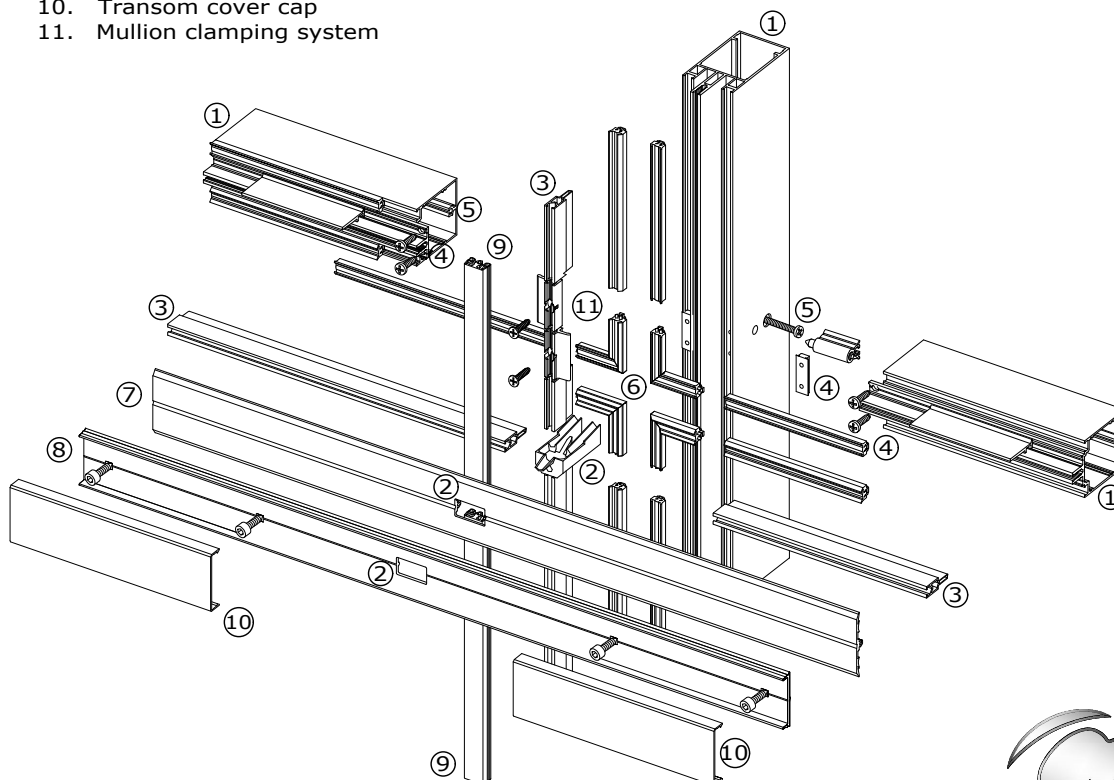


6.01



### 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



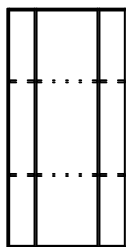
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Issue: 05  
Date: 10-16

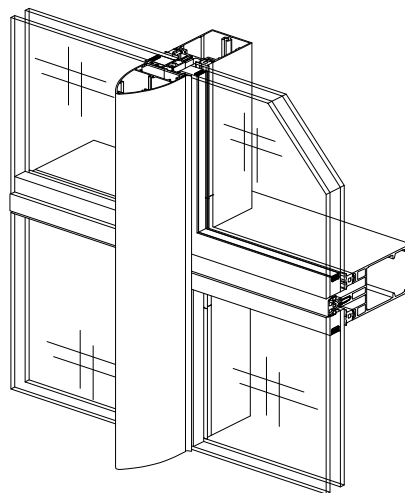
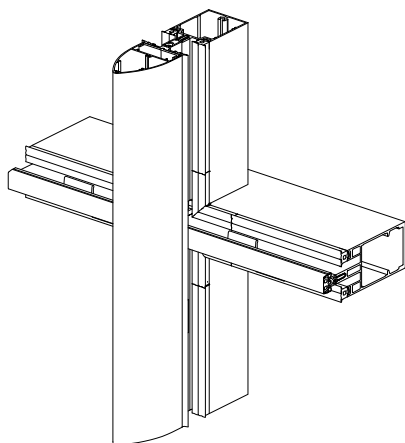
## Fabrication

6

## Comar 6EFT

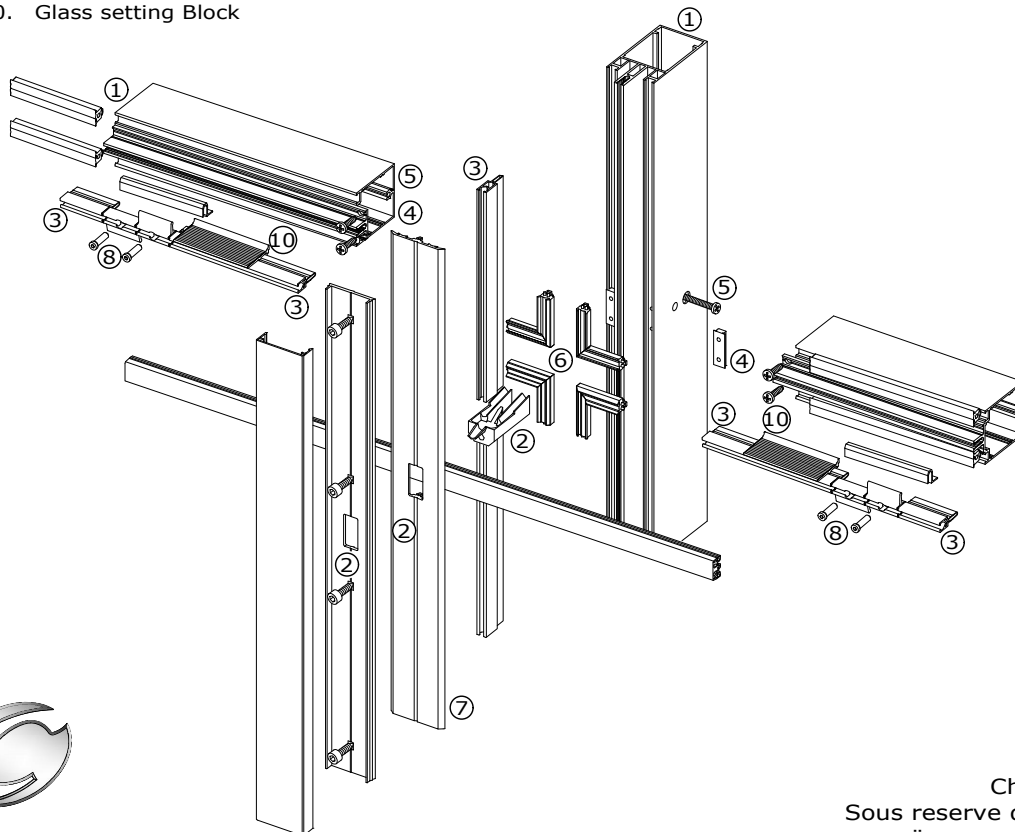


6.02

Exploded typical detail  
Vertical cover cap  
(2Sided SGV)

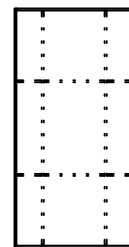
## Details:

1. One substructure for all curtain wall types, Fully Capped, 2sided SGH, 2sided SGV & 4sided SG.
2. Controlled drainage system (mullion drained) drainage diverter
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

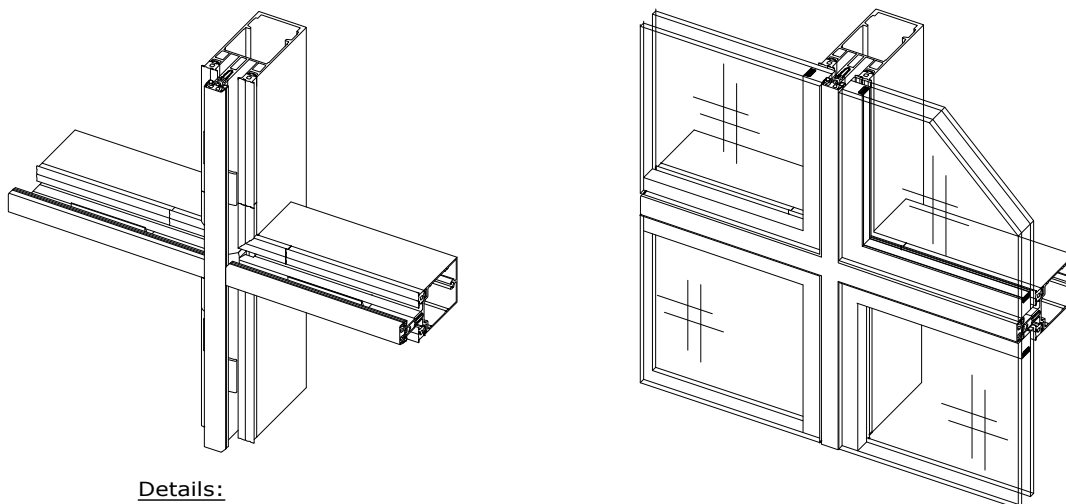


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## Exploded typical details Four sided structural EFT (4sided SG)

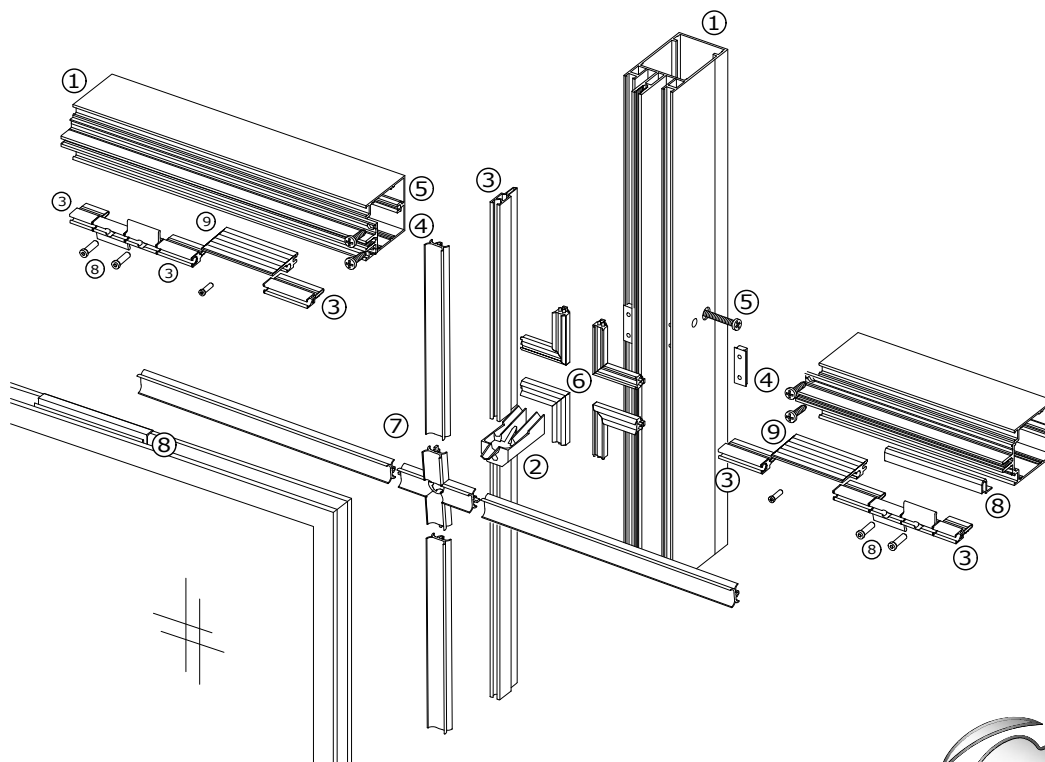


6.03



### 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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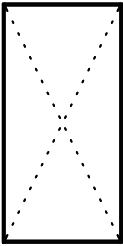
Issue: 05  
Date: 10-16

# Fabrication

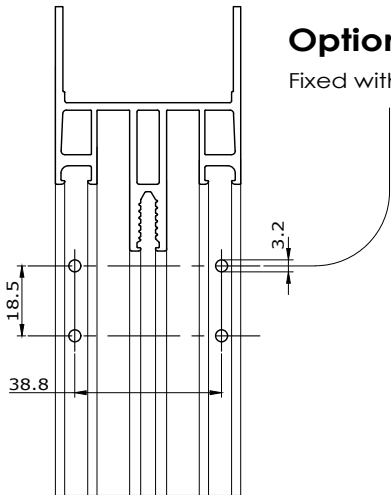
## 6

Comar 6EFT

### Mullion - Transom Connection



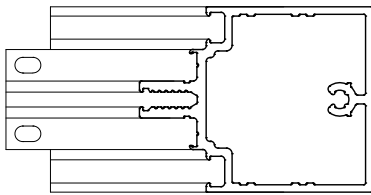
6.04



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

Fixed with 2 screws EFT 3021 (3.9x16)

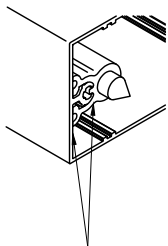
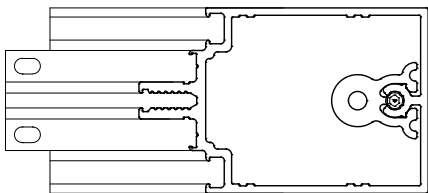
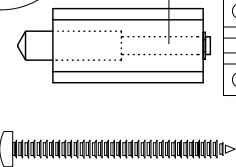
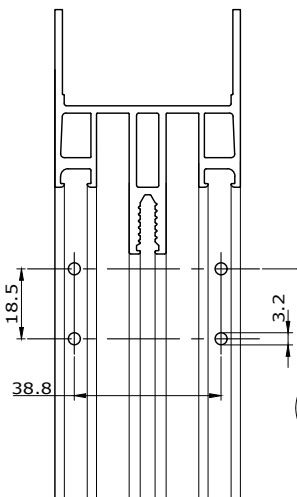
Glass weight: max. 100 kg



#### 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

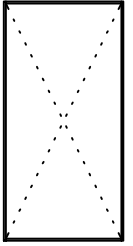
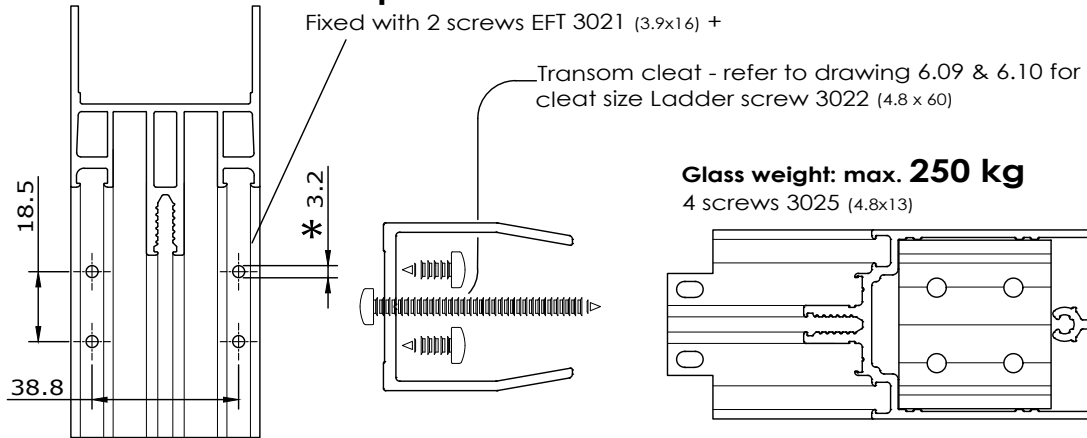


Transom cleat  
2310 body to be  
positioned flush  
to prepared  
edge of transom  
and super glued

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## Mullion - Transom Connection

### Option: 3

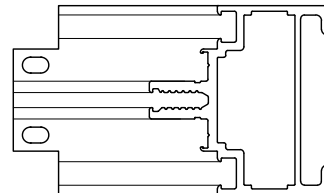
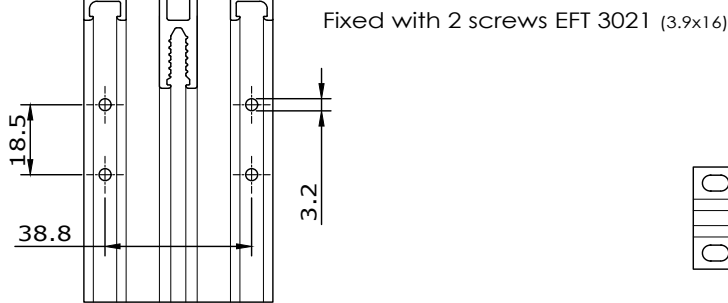


6.05

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

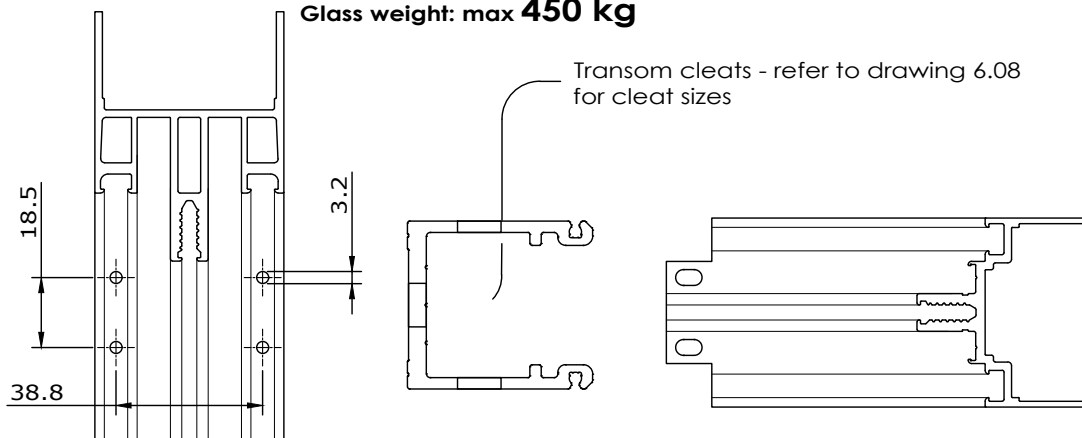
### Option: 4

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



### Option: 5

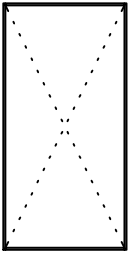
**Glass weight: max 450 kg**



# Fabrication

6

## Comar 6EFT



## Heavy glass support Jamb detail

**Option: 5**

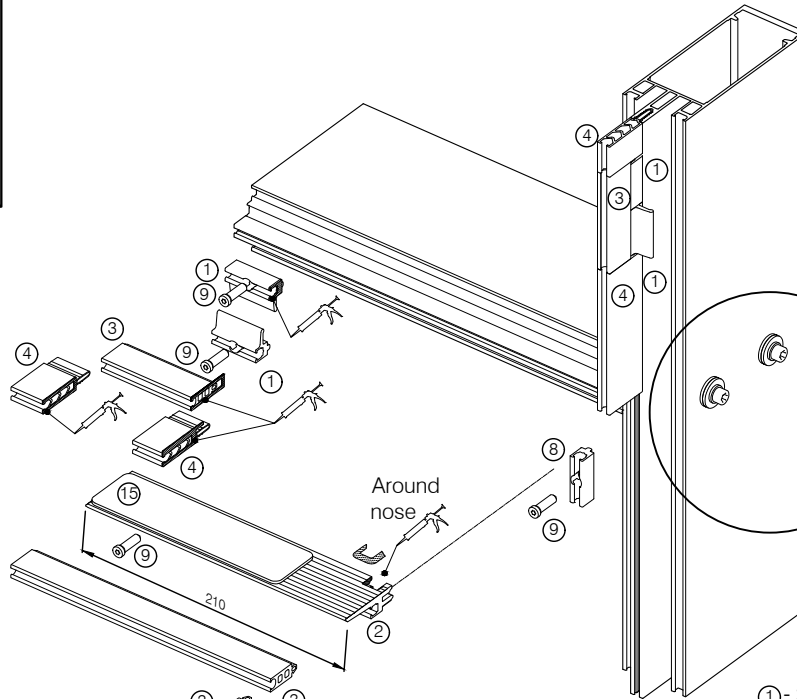
**Glass weight: Max 450 kg**

Detail A



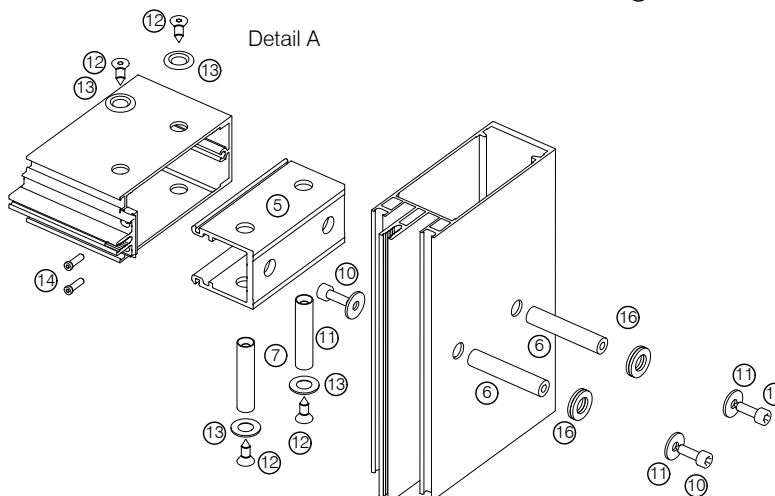
APPLY SEALANT  
TO ALL JOINTS

6.06



- 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

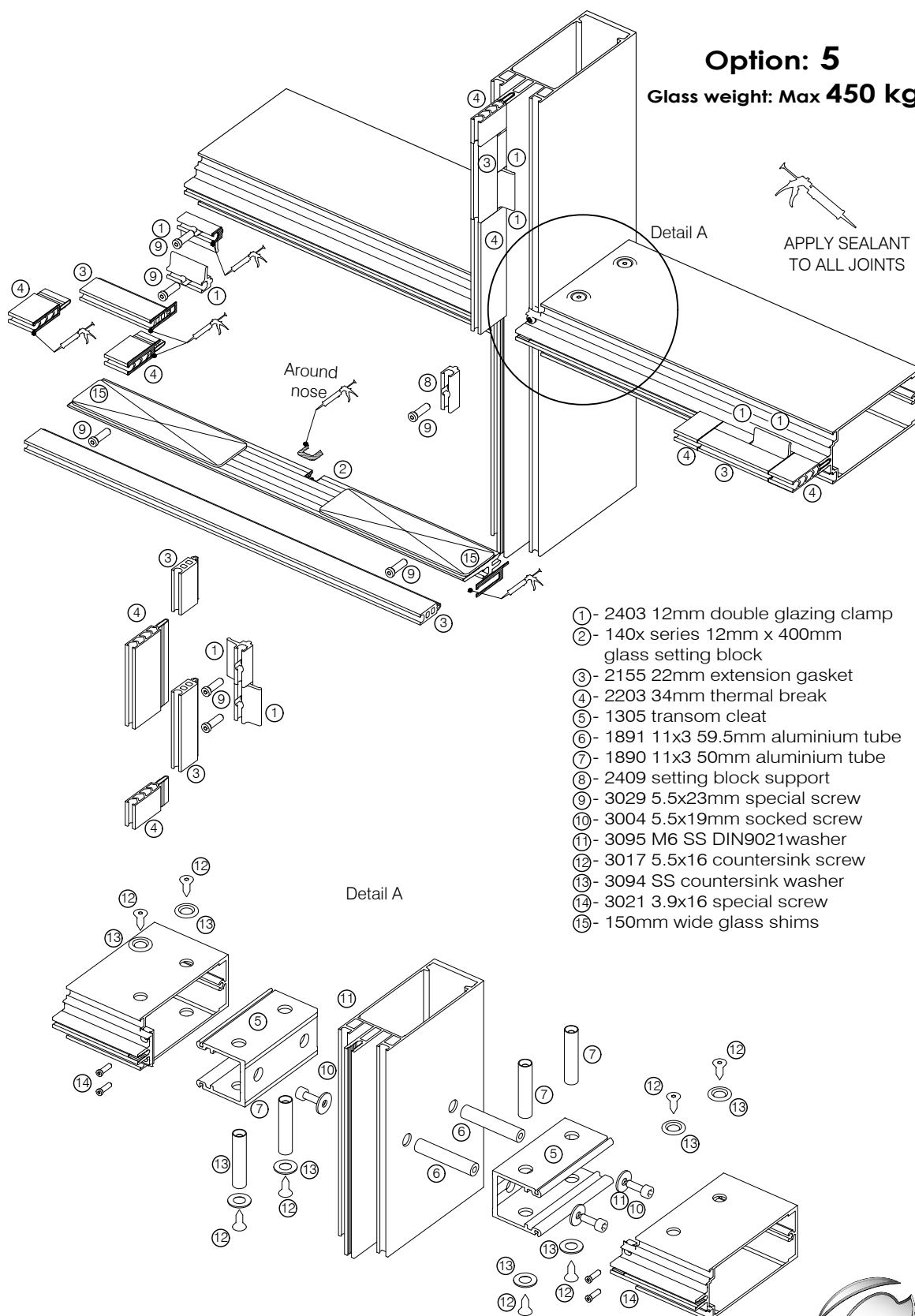
Detail A





## Heavy glass support Mullion Detail

**Option: 5**
**Glass weight: Max 450 kg**

**6.07**


- 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

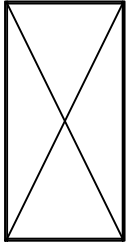
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Issue: 05  
Date: 10-16

# Installation

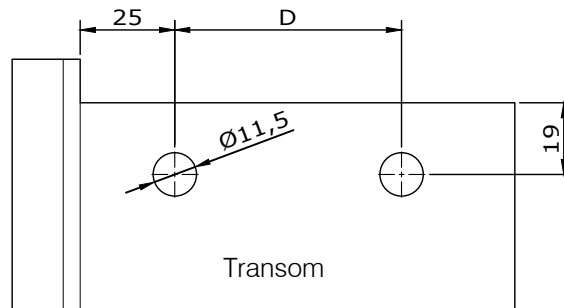
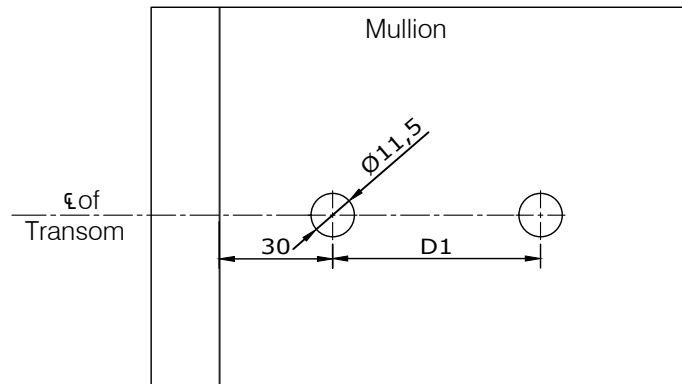
6

## Comar 6EFT

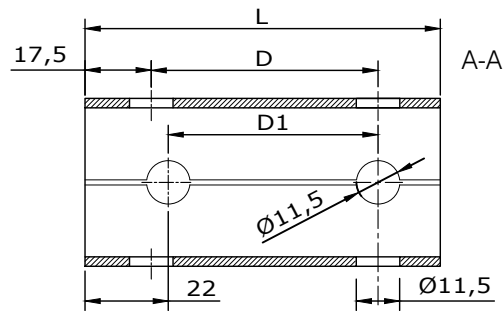
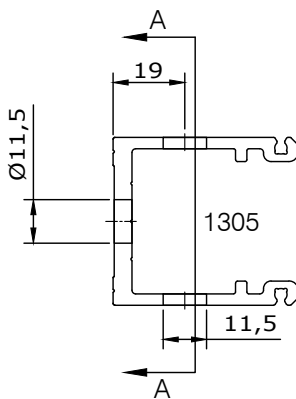


6.08

## Mullion - Transom Connection



**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



**comar**  
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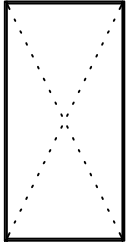
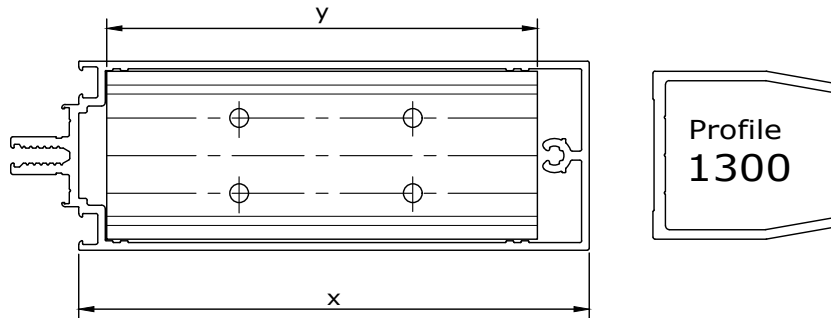
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6

Fabrication

Comar 6EFT

## Transom cleat size

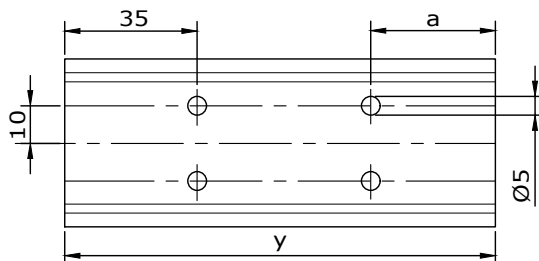


Cleat length (y) = Transom size (x) - 21mm

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

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



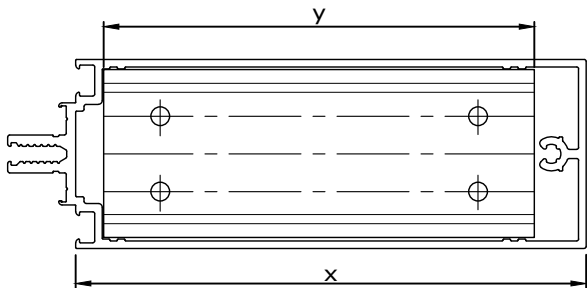
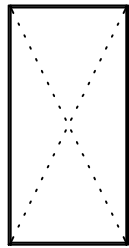
Fabricators Guide

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Comar 6EFT

Transom cleat sizes



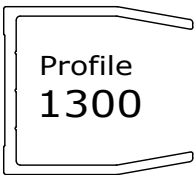
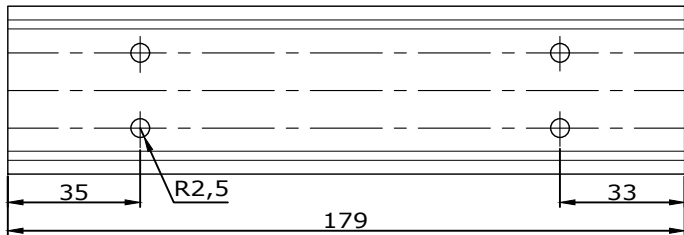
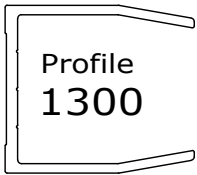
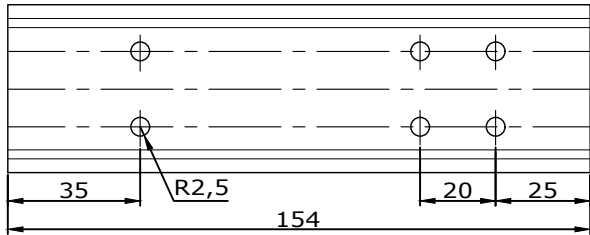
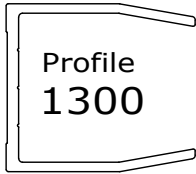
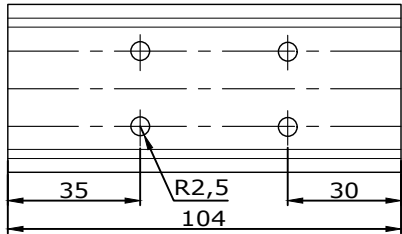
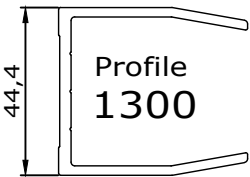
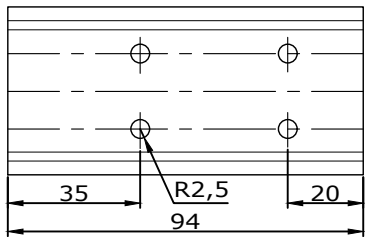
6.10

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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Fabricators Guide



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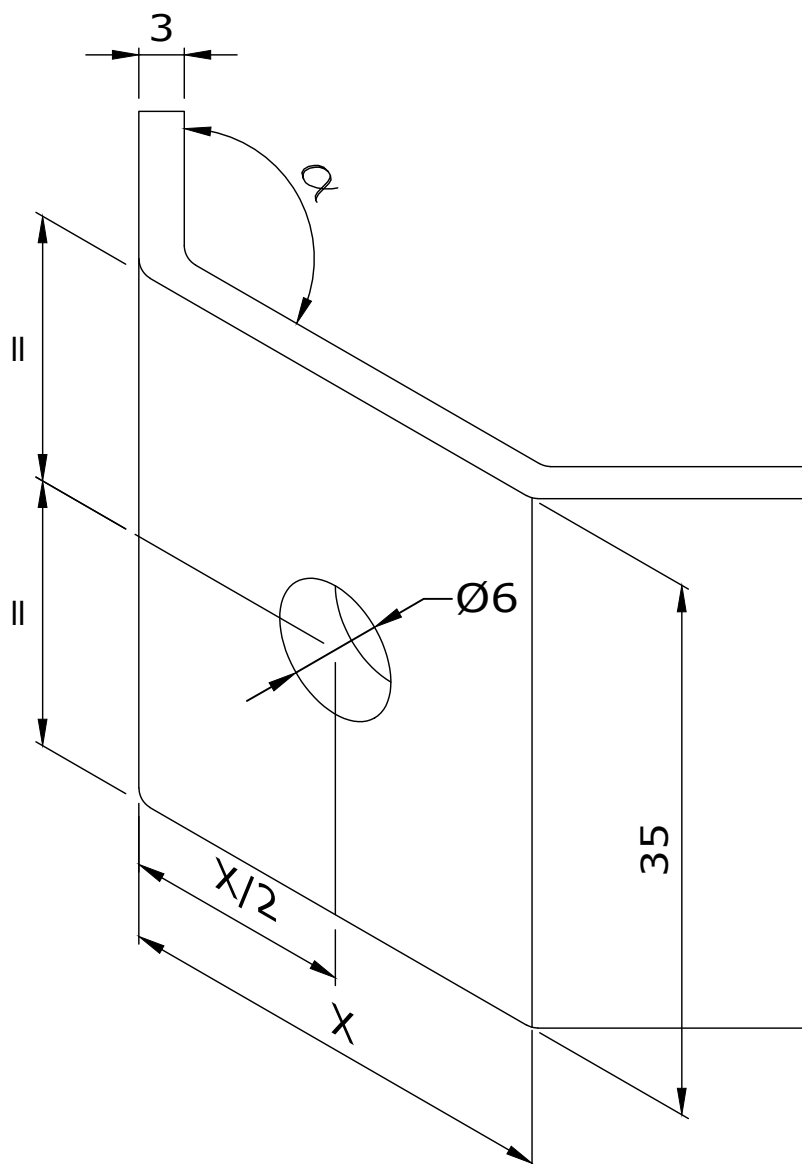
Fabrication

Comar 6EFT

## Facetted clamp



6.11



Facetted clamps to be made to required angle  $\alpha$ .

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.

Fabricators Guide

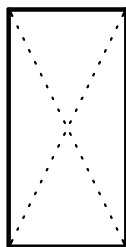
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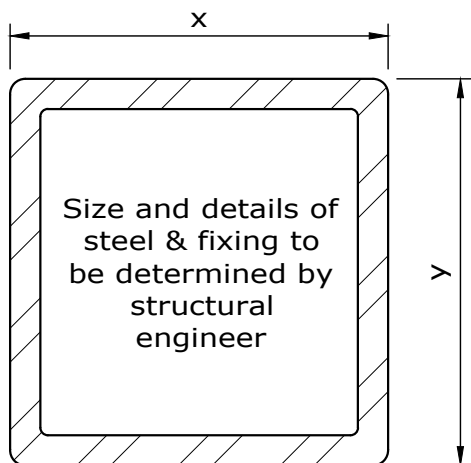
# Profile Sections 6


## Comar 6EFT

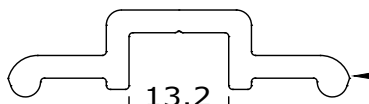
Direct fix to steel  
fixing lug preparation

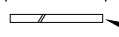



6.12

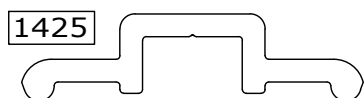


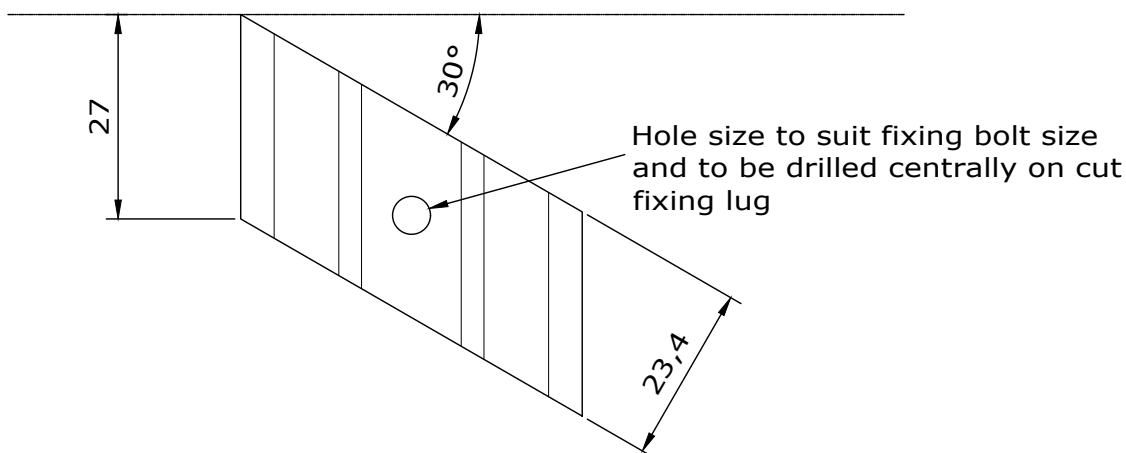
 Aluminium to steel isolator  
(supplied by others)

 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

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

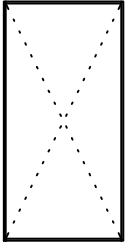


6

Fabrication

Comar 6EFT

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



6.13

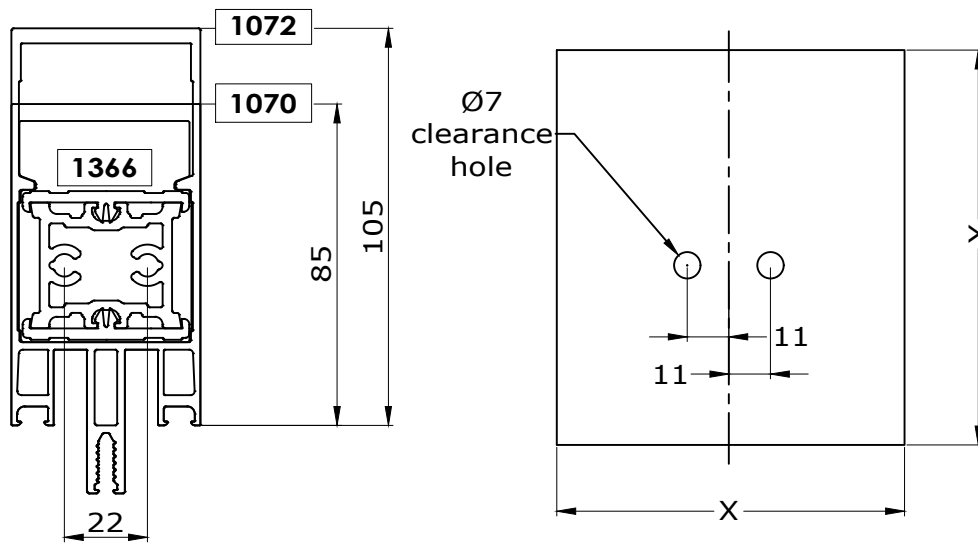
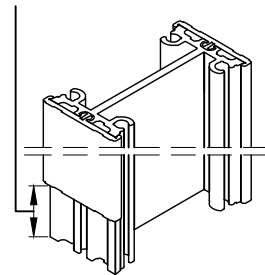


Plate supplied by others

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

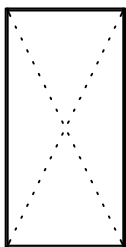
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## Fabrication

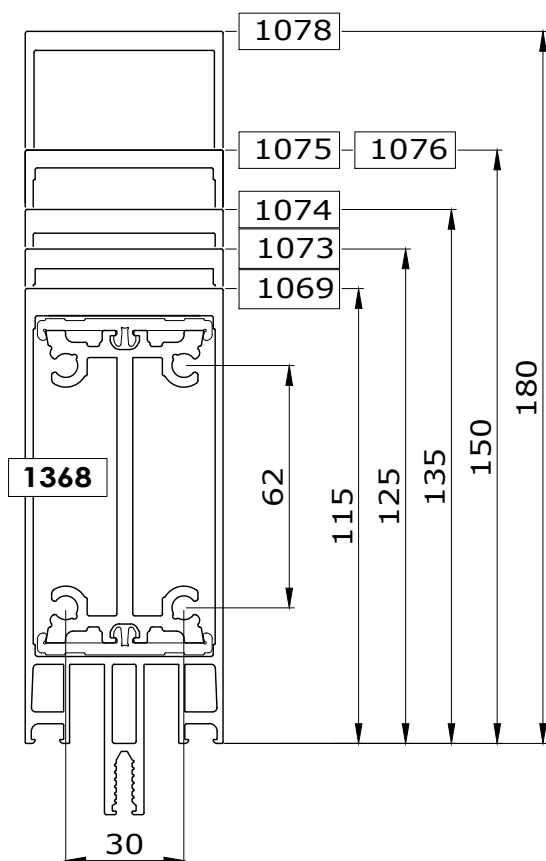
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## Comar 6EFT

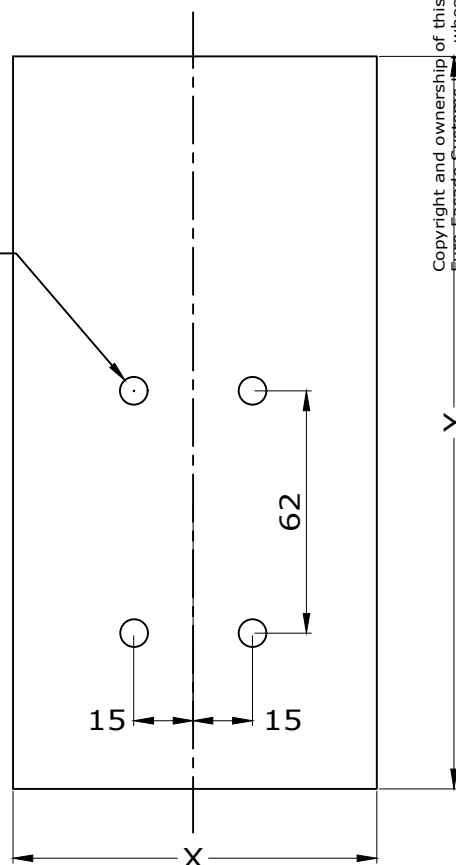


Mullion Sleeve Plate  
 115mm(1069), 125mm(1073)  
 135mm(1074), 150mm(1075)  
 150mm(1076), 180mm(1078)

6.14



Ø7  
 clearance  
 hole



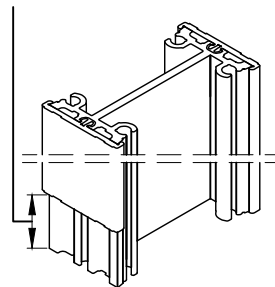
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Plate supplied by others

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

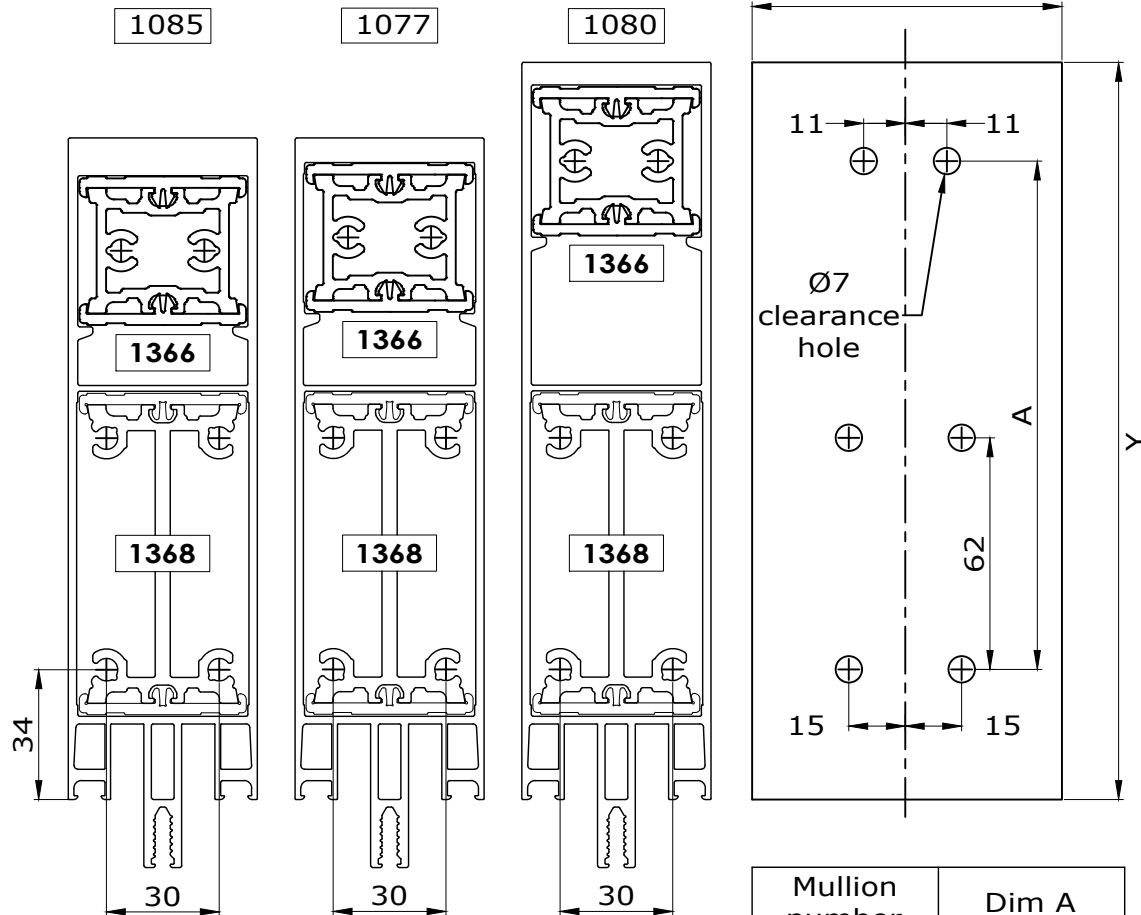
Length & width of plate and anchor bolts to be determined by site conditions and to structural engineers specification.

Front plastic cover cap cut back as needed to fit EPDM





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



6.15

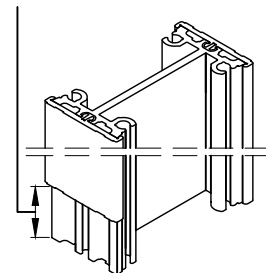
Fabricators Guide

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.

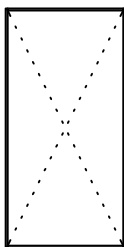
Front plastic cover cap cut back as needed to fit EPDM



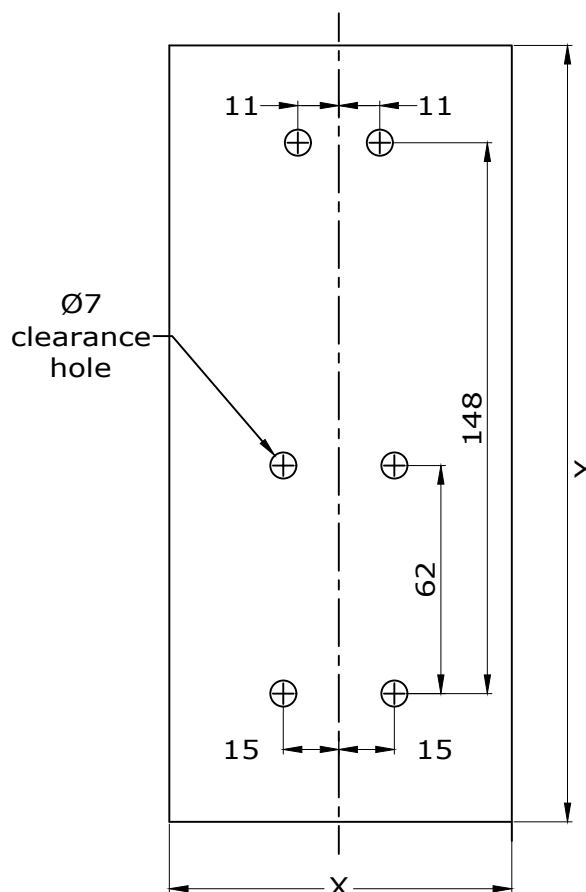
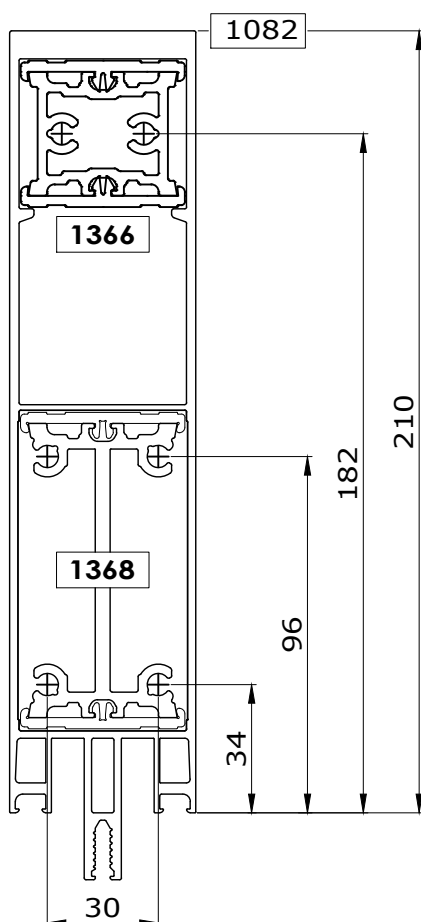
## Fabrication

6

## Comar 6EFT

Mullion sleeve plate  
210 mm (1082)

6.16

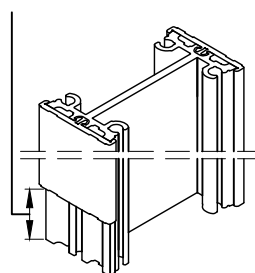


5mm thick aluminium plate supplied by others

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



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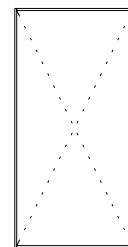


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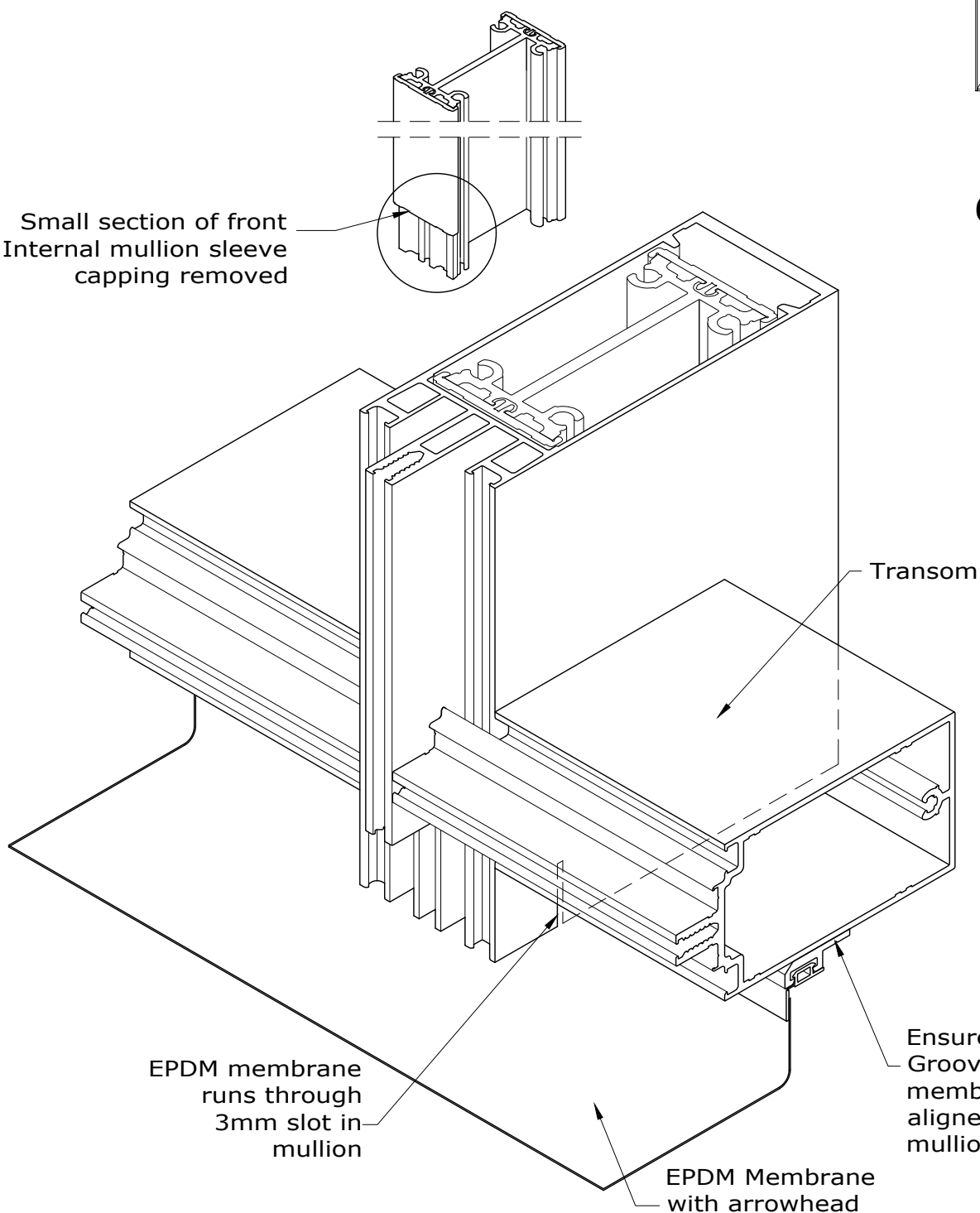
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# EPDM membrane Transom Sill, Head & Mullion preparation



6.17

Small section of front  
Internal mullion sleeve  
capping removed



Fabricators Guide

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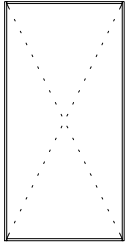
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# Fabrication

6

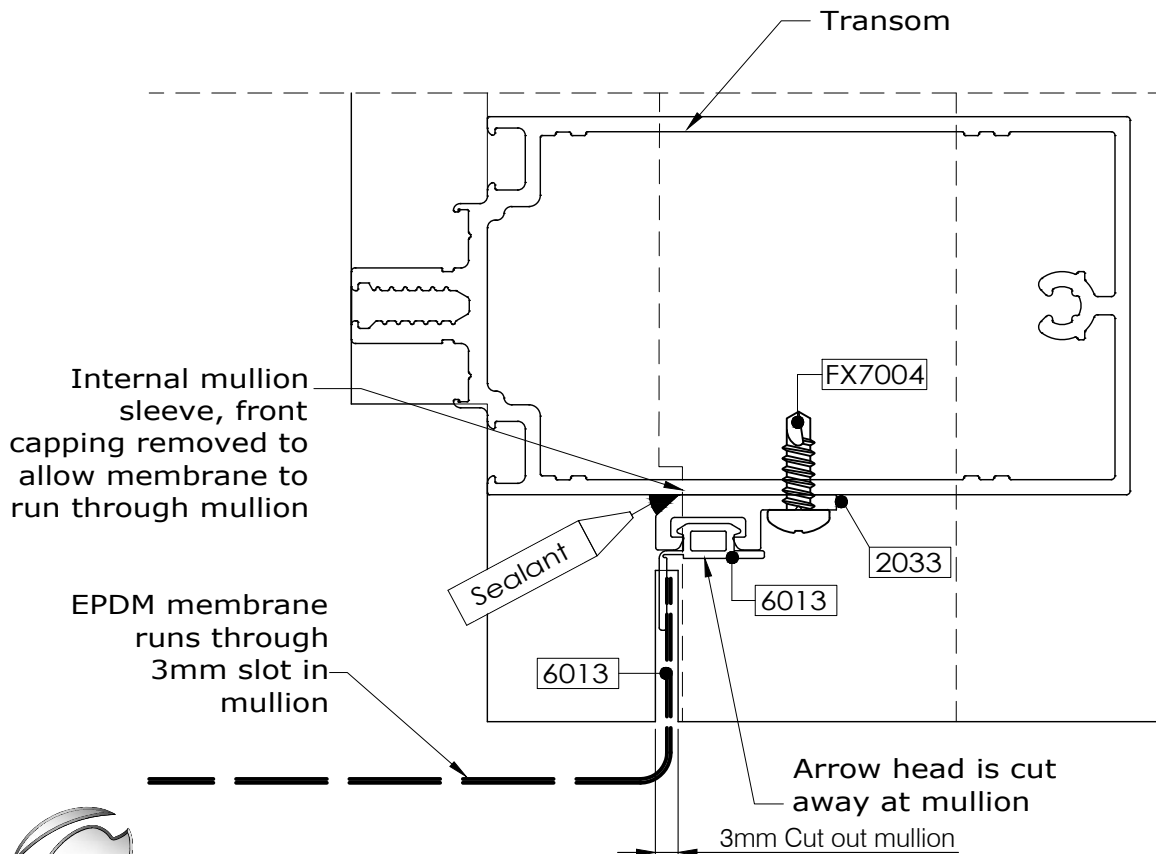
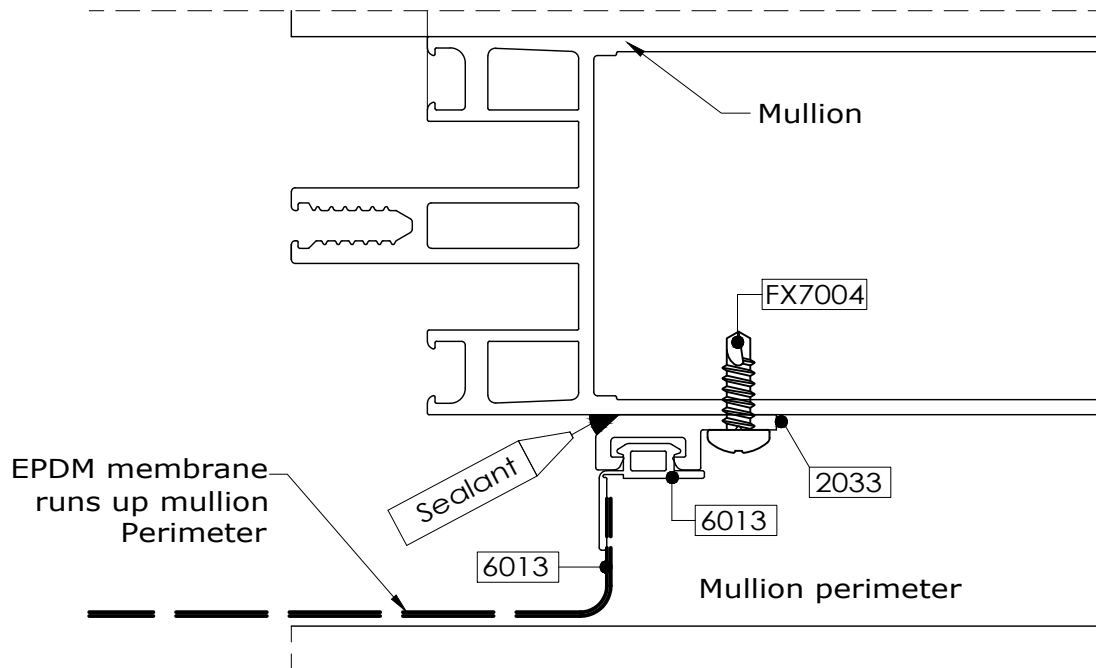
## Comar 6EFT



### EPDM membrane Curtain wall perimeter Preparation

6.18

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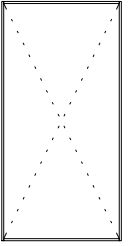
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## EPDM membrane Mullion preparation Slot cutting details

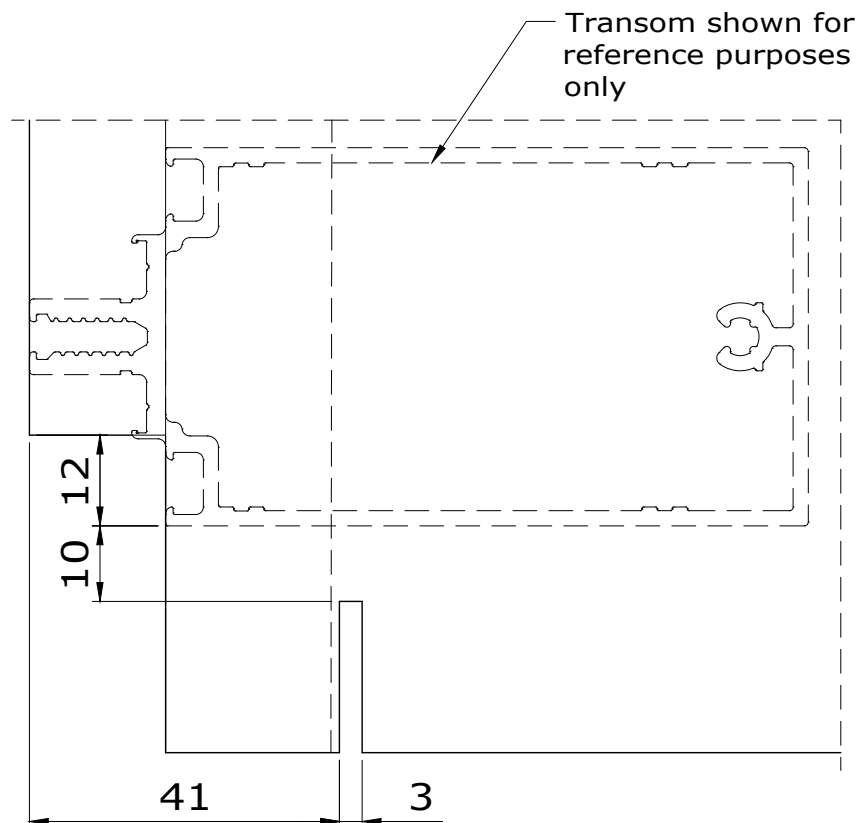
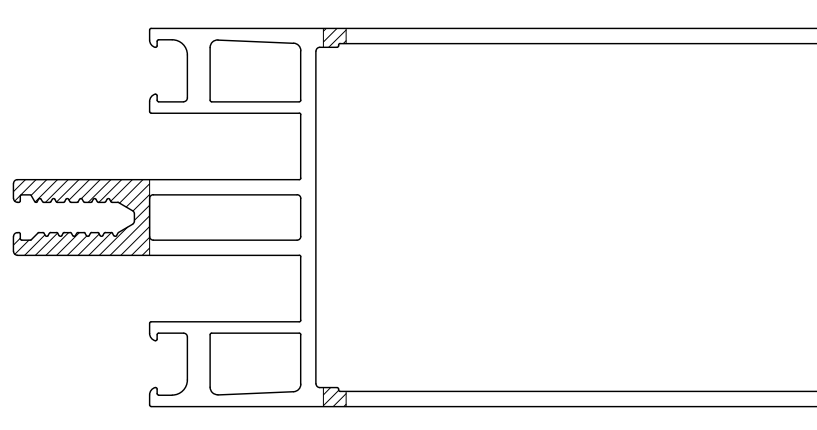
6

Fabrication

Comar 6EFT



6.19



Fabricators Guide

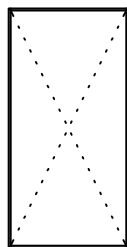
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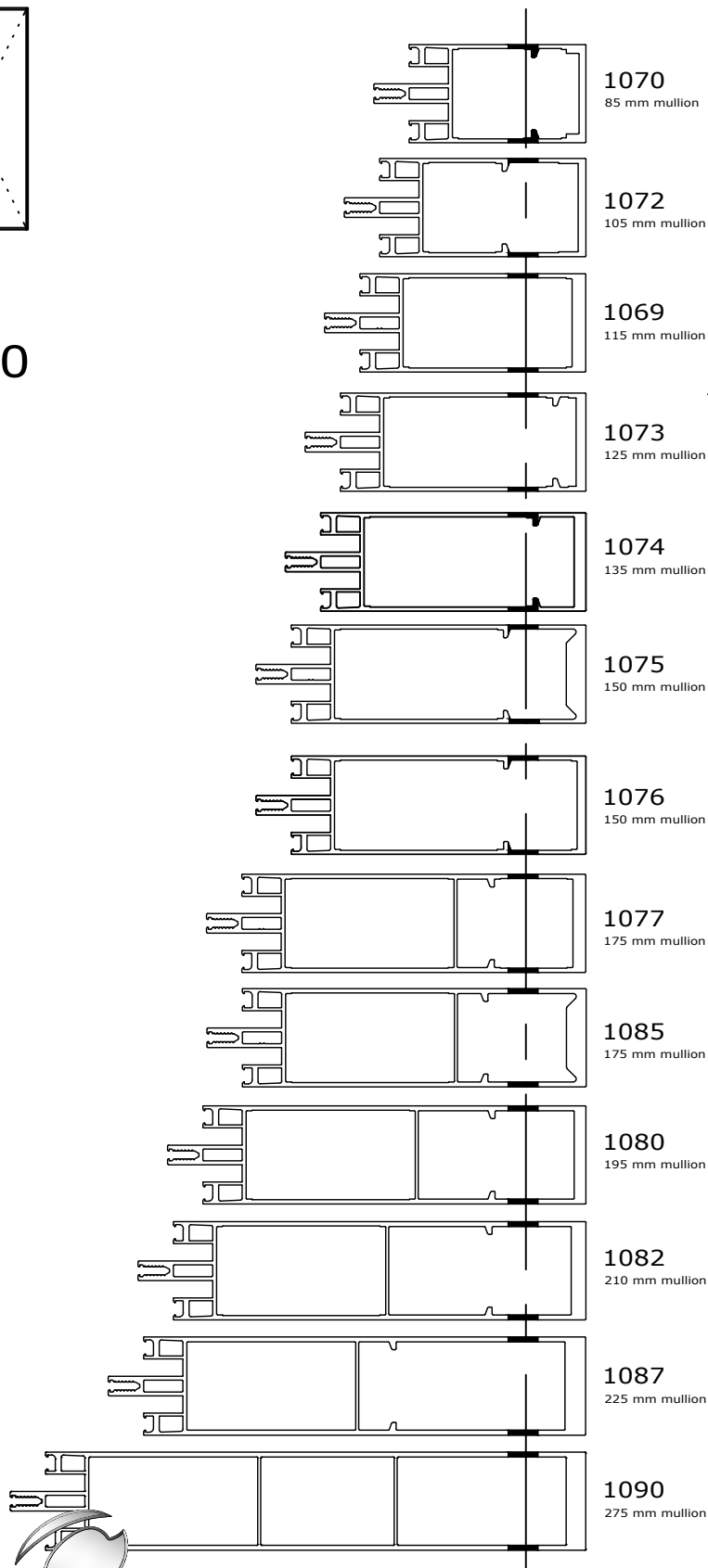
Fabrication

6

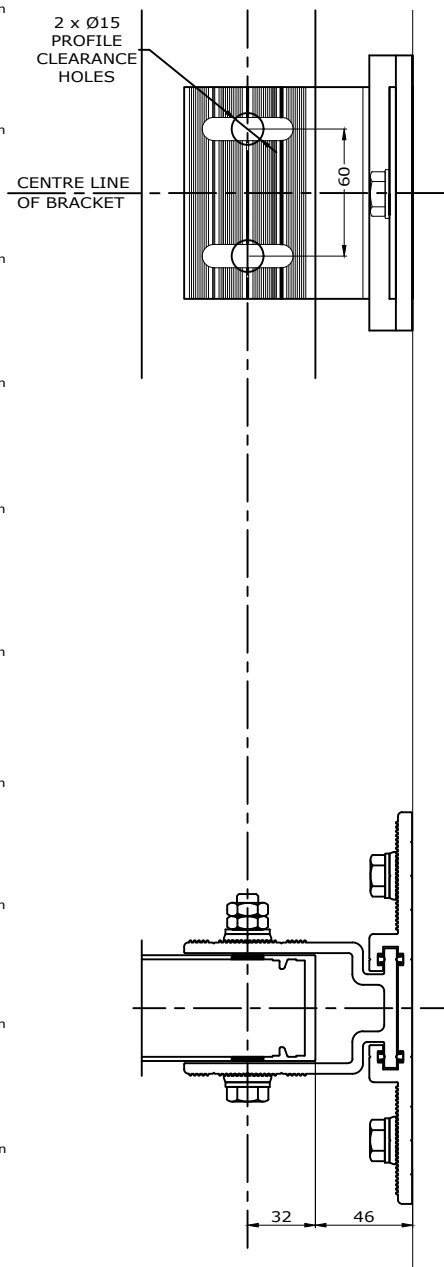
# Comar 6EFT



6.20

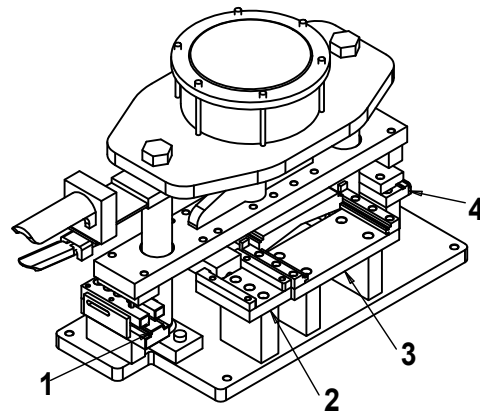


## Fixing bracket hole prep

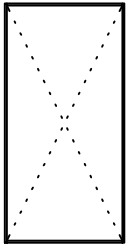


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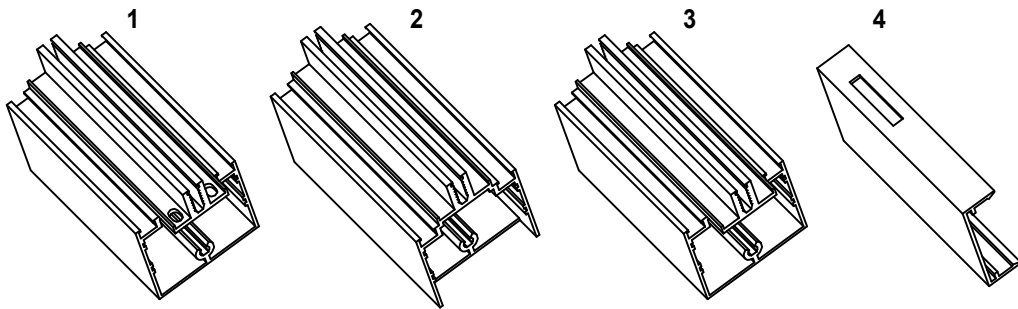
## Tooling



Preparations:  
As per drawing 6.23  
transom end notch

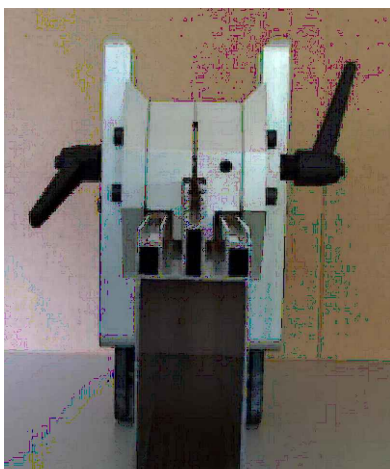


6.21



Tool: Pneumatic punch tool Com6-EFT-T13

## Mullion - Transom connection



Tool: Com6-EFT-Jig 1

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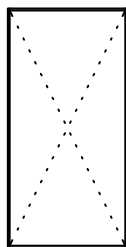
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## Fabrication

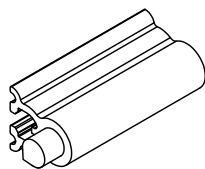
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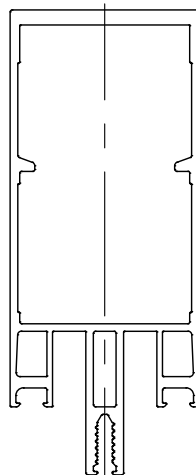
## Mullion preparation



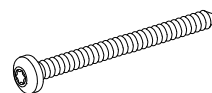
Transoms installed  
in between ladders



EFT 2310

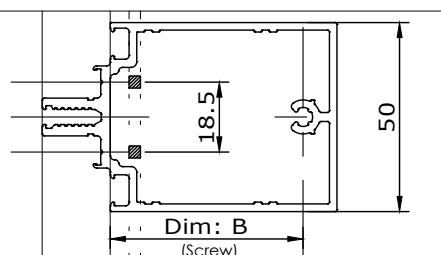
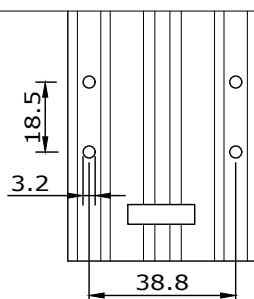
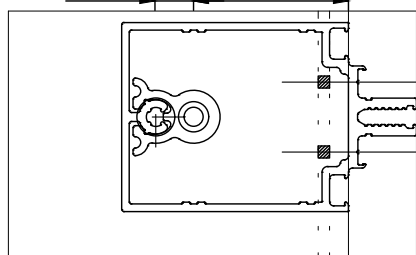
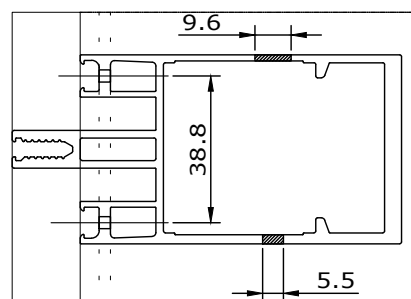
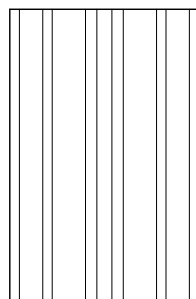
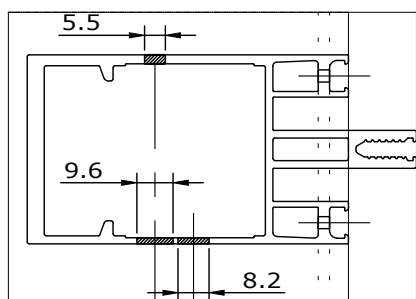


Ladder / unit



3022 (4.8 x 65)

6.22



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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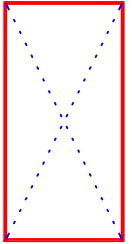
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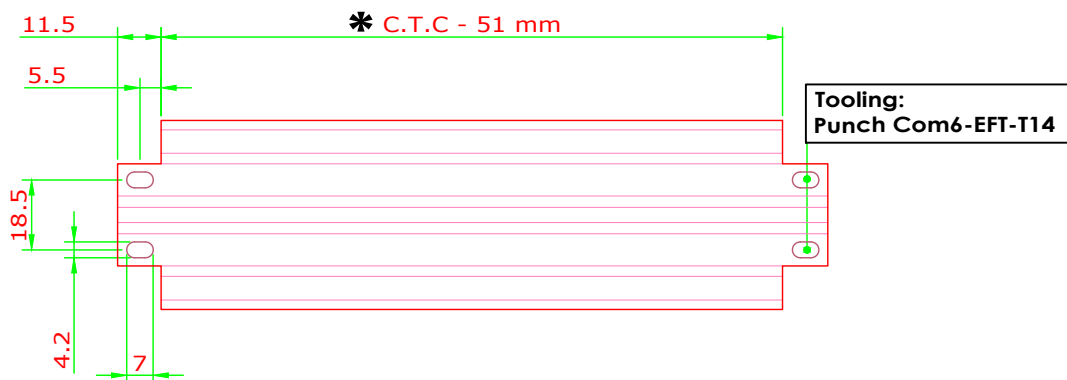
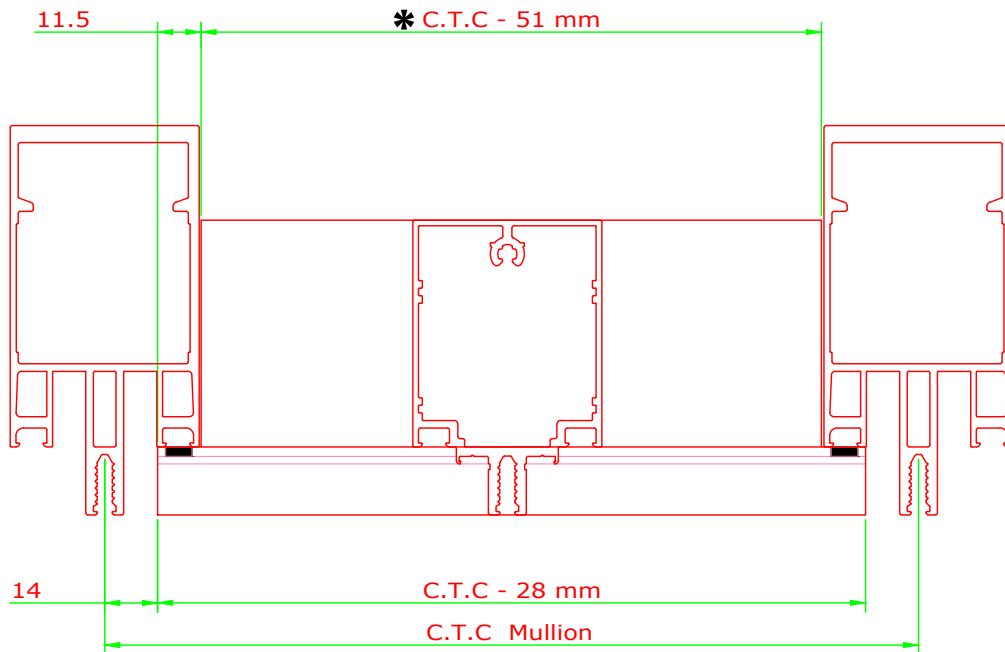
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Date: 03-17



## Transom preparation



6.23



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

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

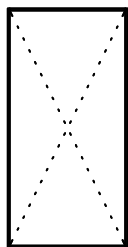
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Fabrication

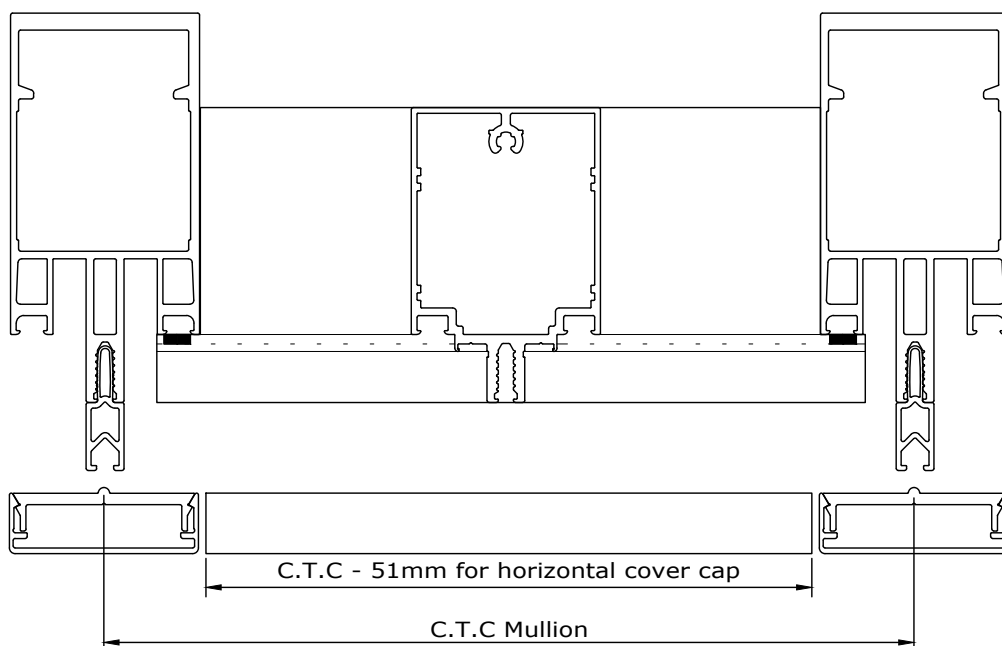
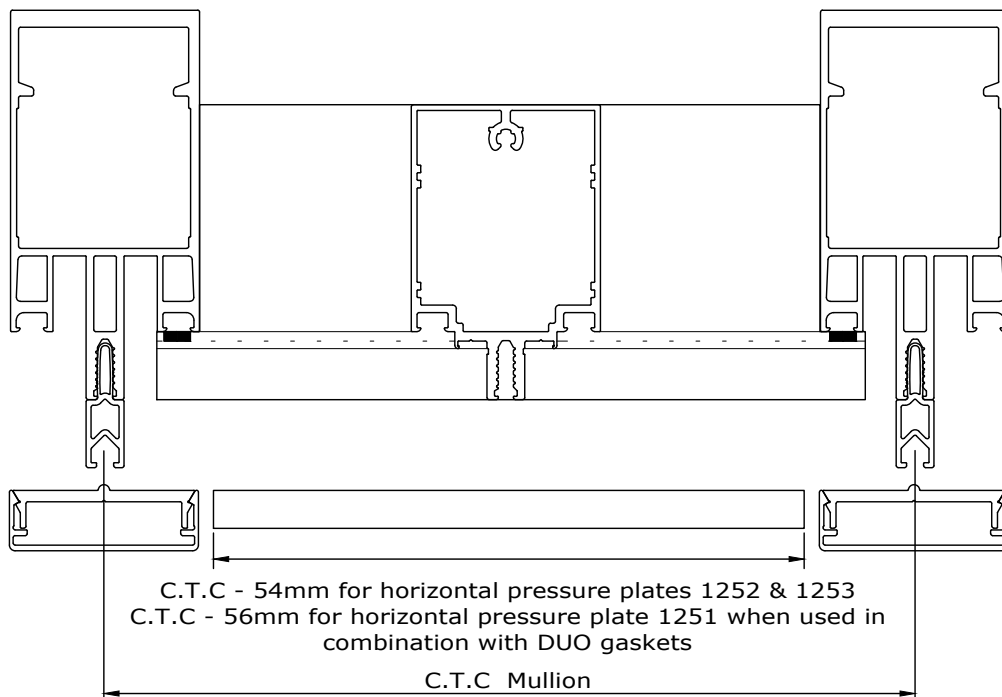
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Comar 6EFT



6.24

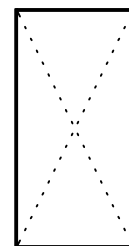
Horizontal pressure plate  
& horizontal cover cap



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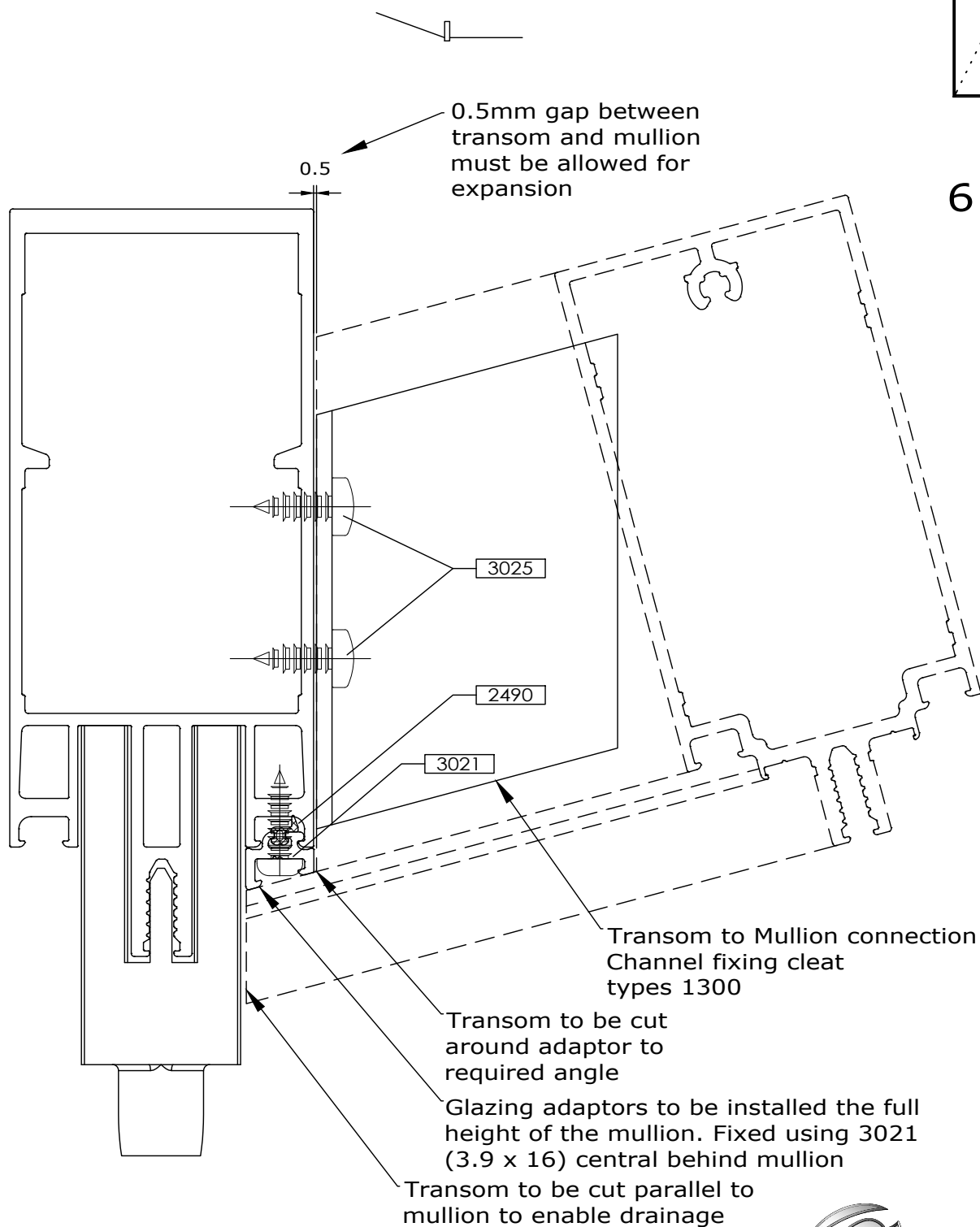


## Facetted transom preparation External Corner



6.25

Fabricators Guide

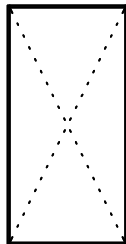


# Fabrication

6

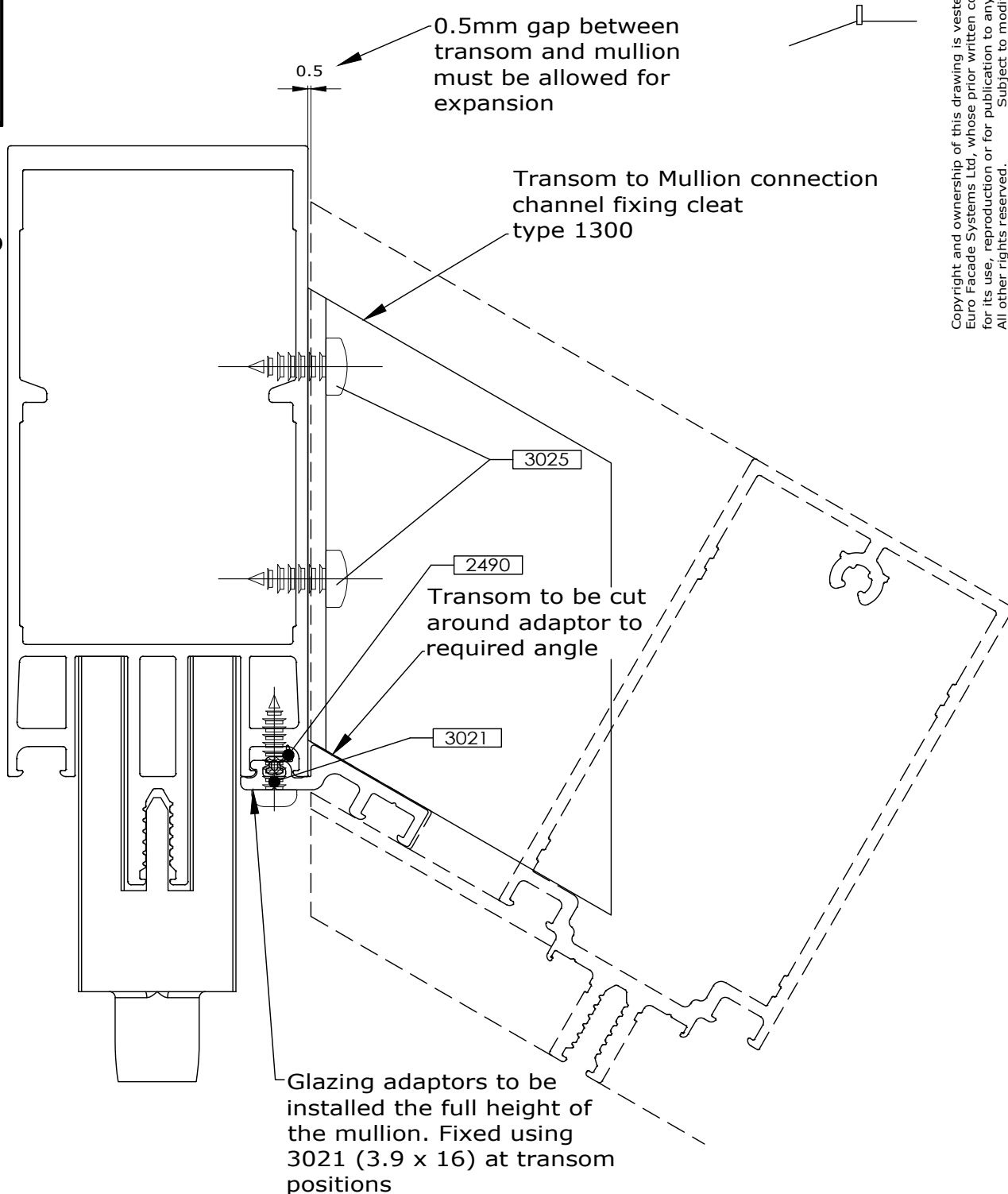
## Comar 6EFT

### Facetted transom preparation Internal Corner



6.26

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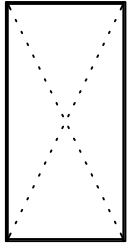
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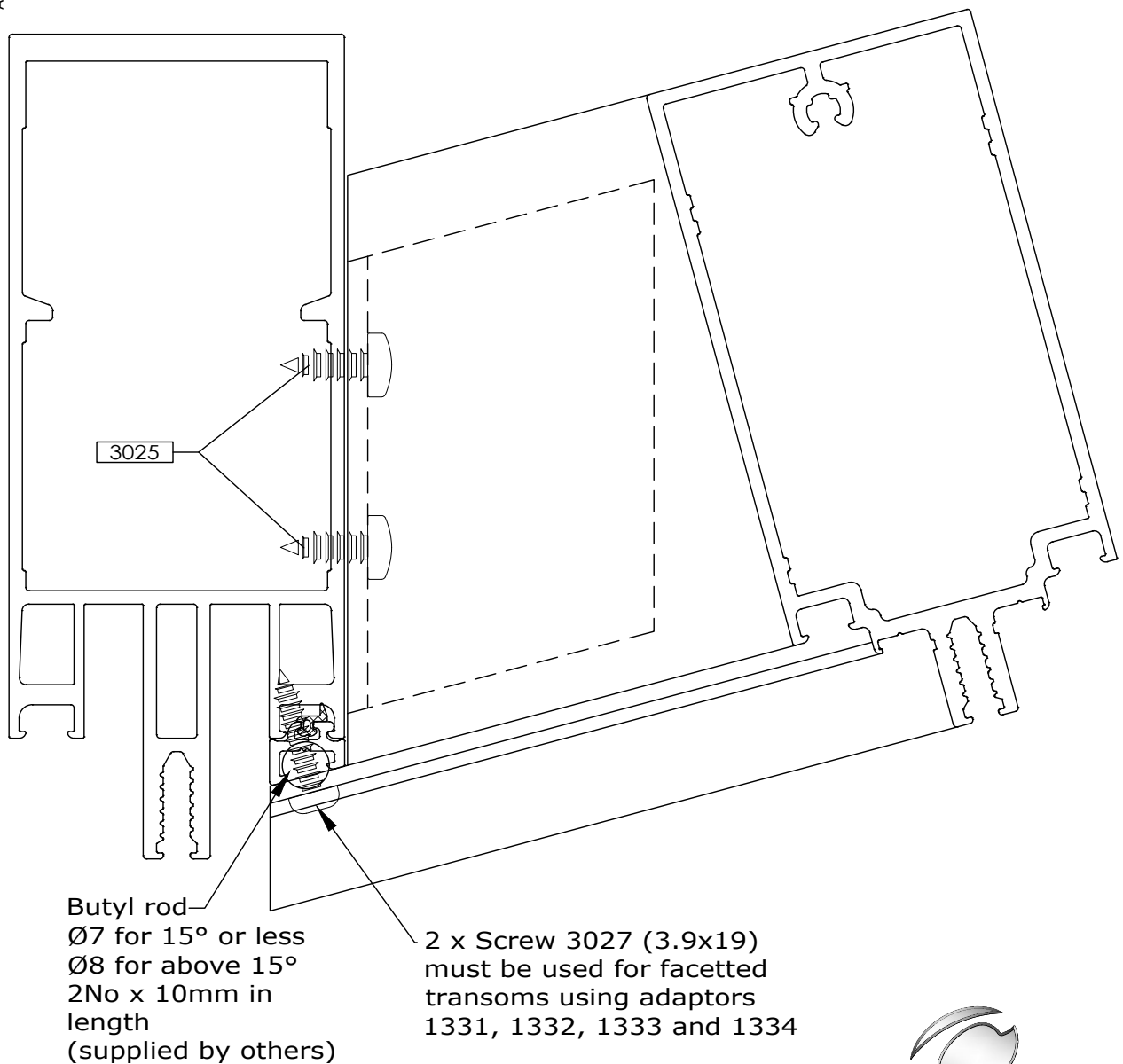
Fabrication

Comar 6EFT

## Fixing facatted transoms External Corner



6.27

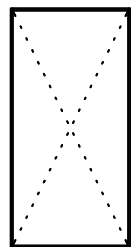


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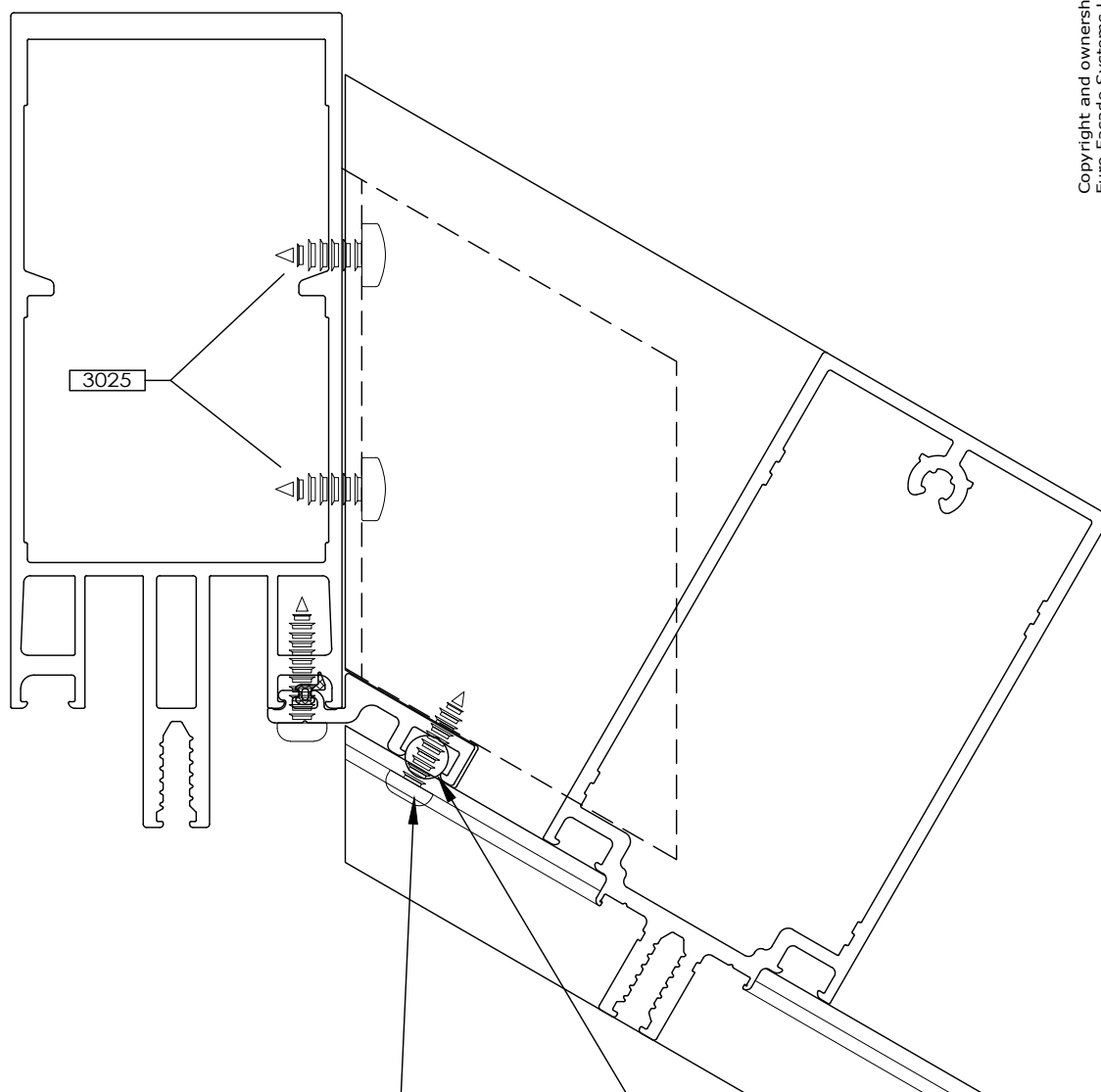
6.28



# Fabrication

6

## Fixing faceted transoms Internal Corner



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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Fabrication

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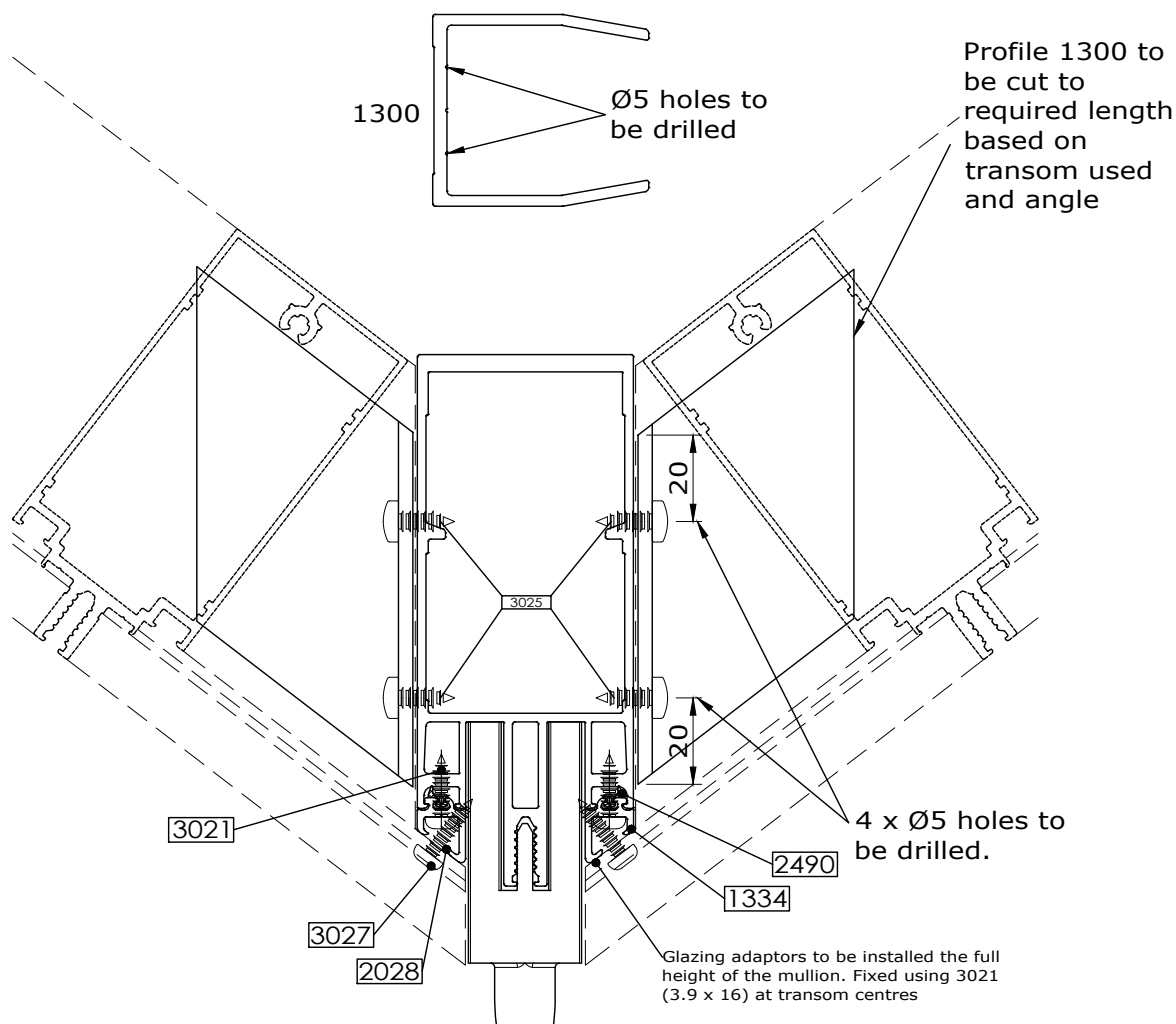
## Facatted transom cleat preparation



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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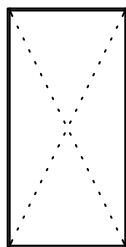
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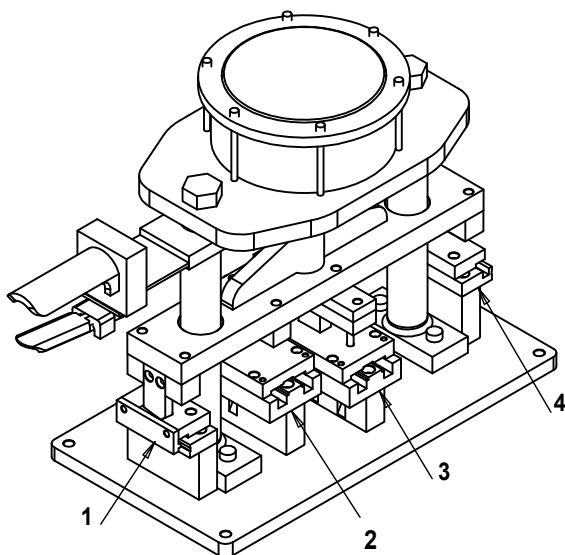
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## Comar 6EFT

## Tooling



6.30



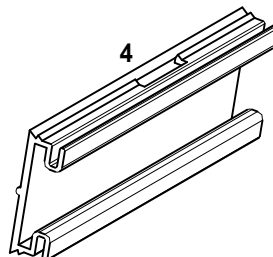
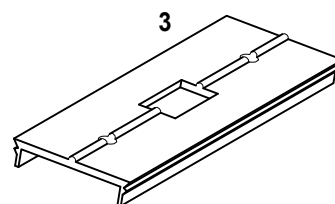
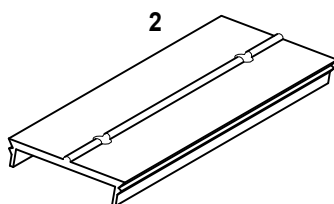
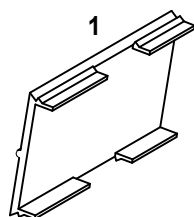
### Preparations:

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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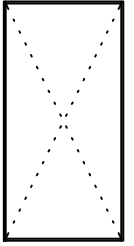


## Single gasket installation

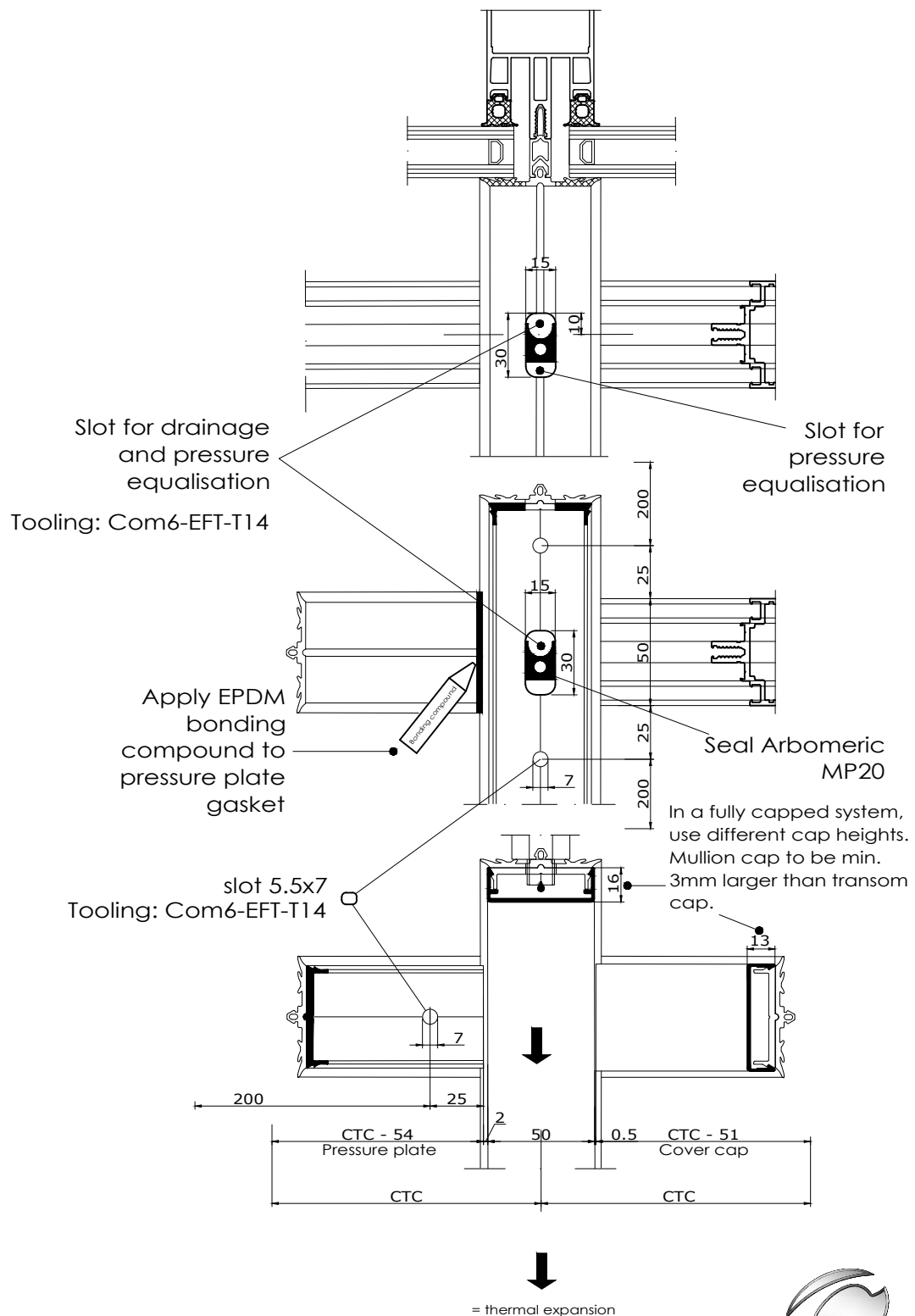
6

Fabrication

Comar 6EFT



6.31



Fabricators Guide

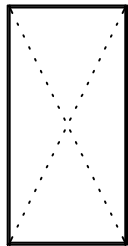
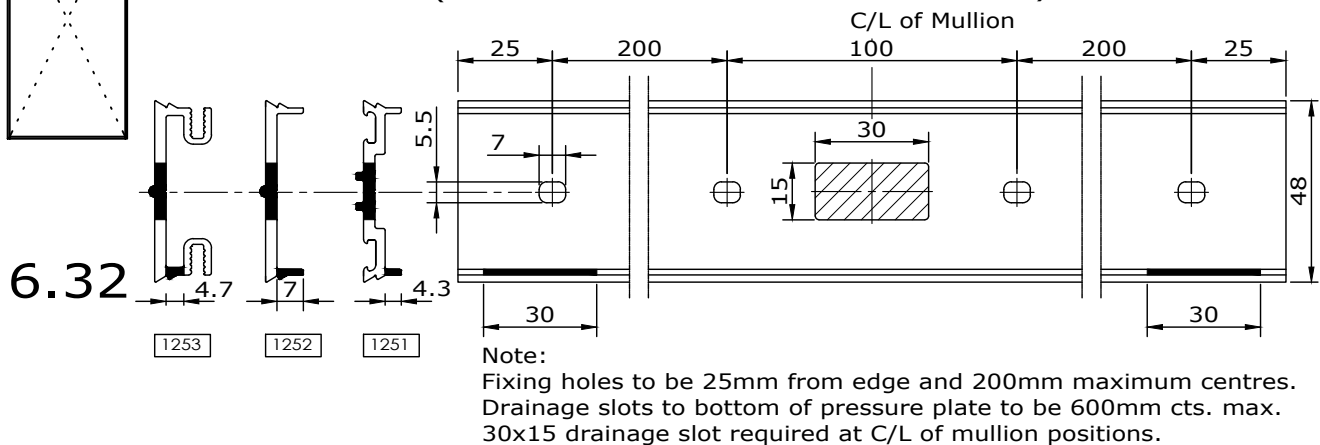
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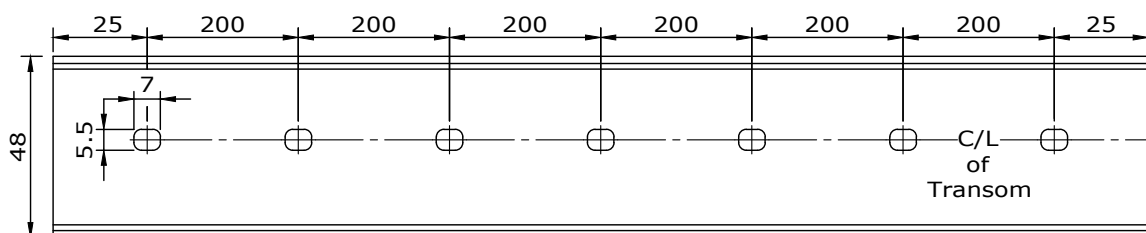
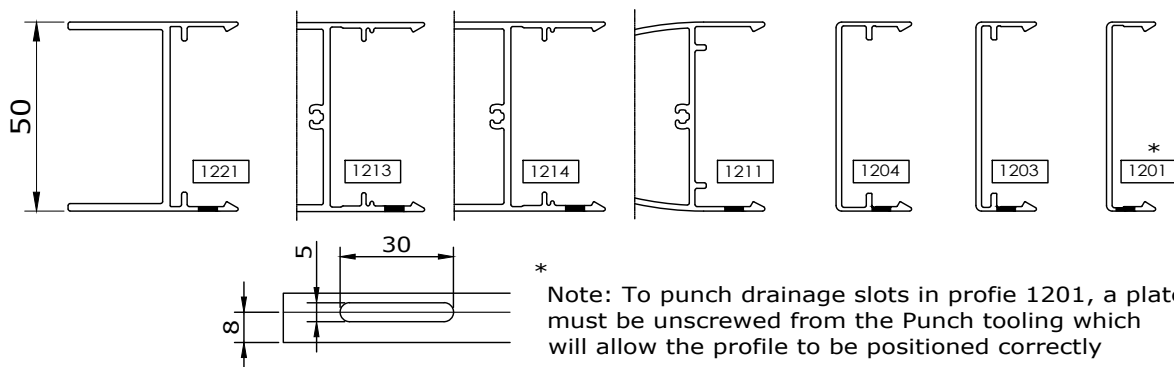
## Fabrication

6

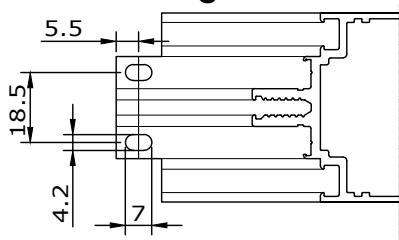
## Comar 6EFT

Tooling:  
Punch Com6-EFT-T141A. Drainage slots & fixing holes Transom Pressure Plates  
2sided SGH (Two Sided Structural Glazed Horizontal)

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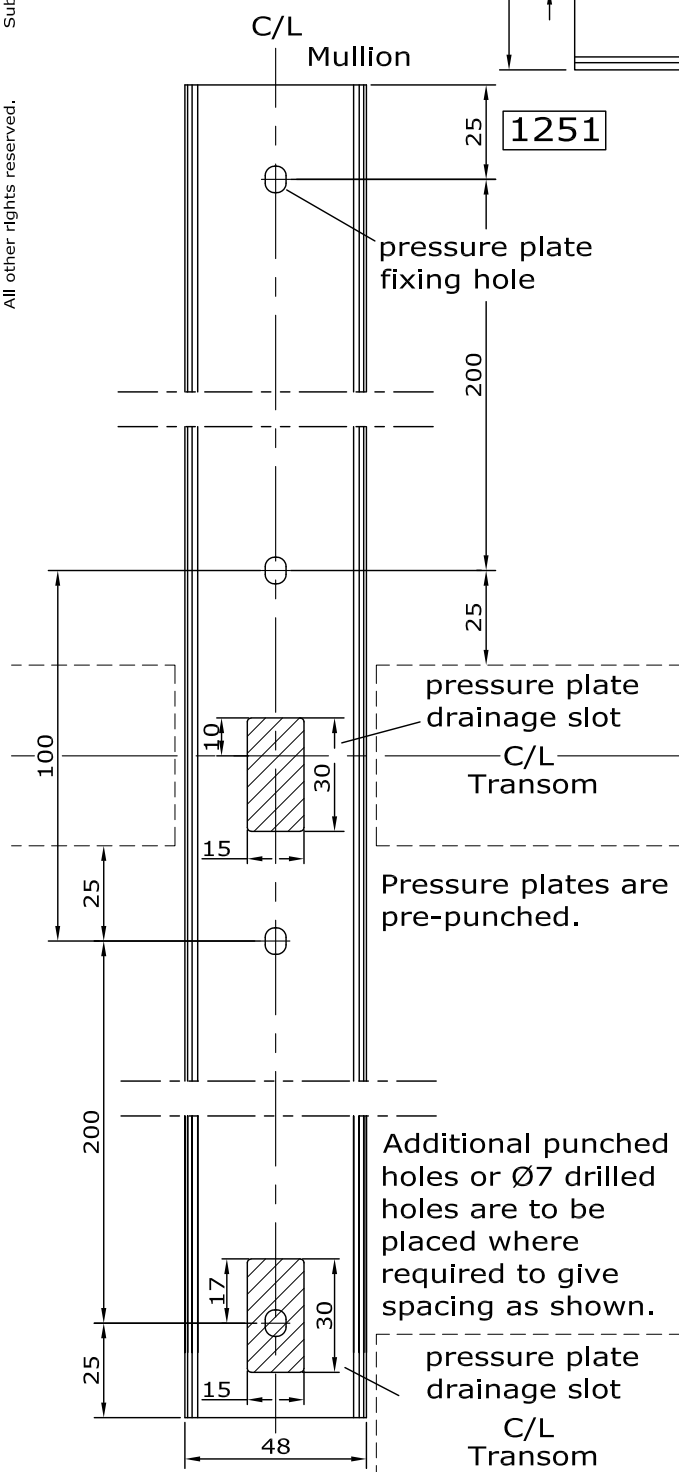
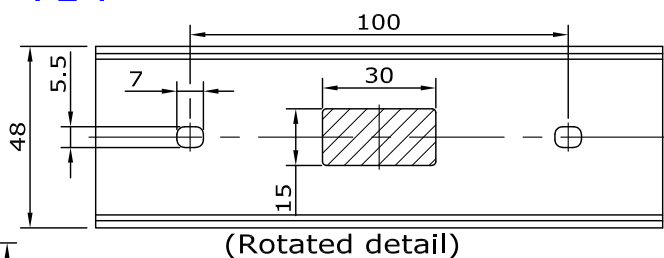
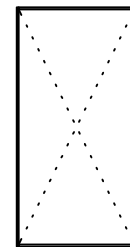
1B. Fixing holes Transom Pressure Plates  
Curtain Walling (Fully Capped Curtain Walling)2. Drainage slots Transom Cover Caps  
2sided SGH (Two Sided Structural Glazed Horizontal)

## 3. Fixing slots transom



## Tooling: Punch Com 6-EFT-T14

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



1251



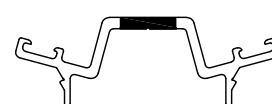
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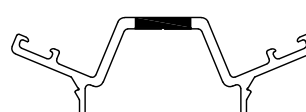
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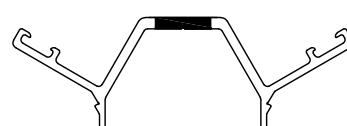
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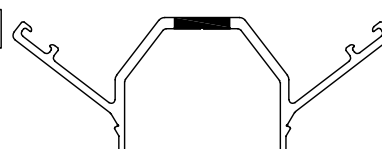
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1262



1263



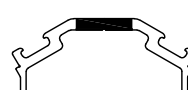
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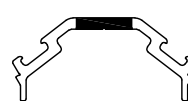
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1268



1269



1270



6.33

Fabricators Guide

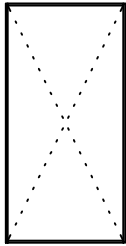
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Issue: 05  
Date : 12-18

# Fabrication

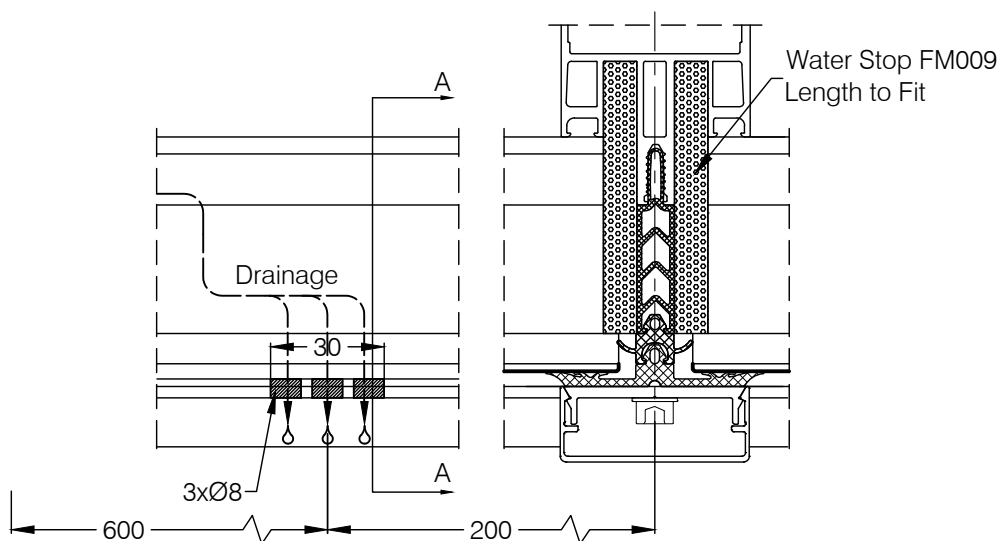
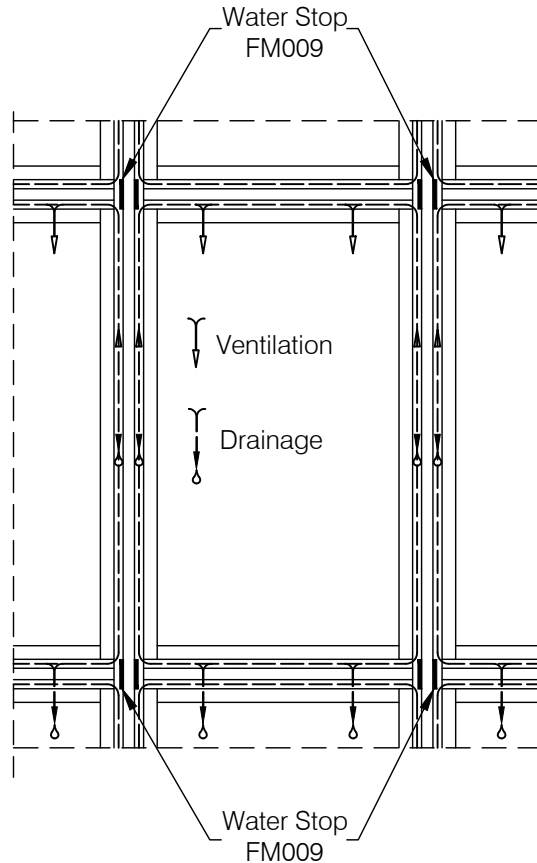
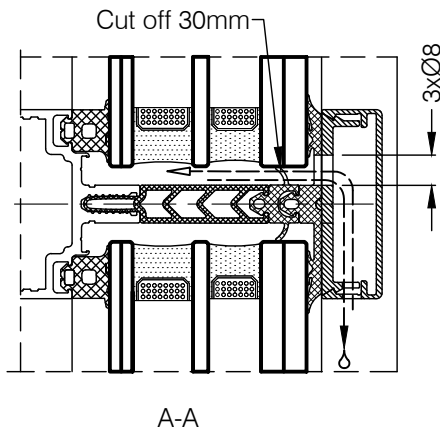
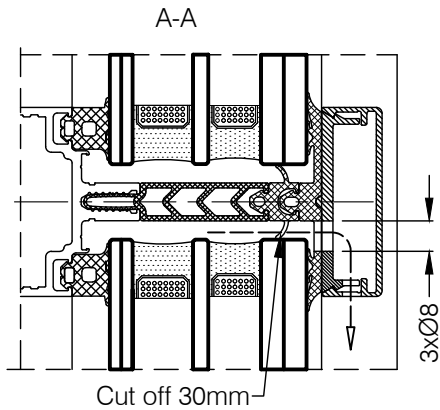
6

## Comar 6EFT



6.34

## Drainage & Ventilation by Individual Window



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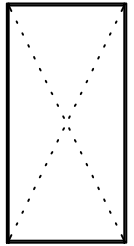
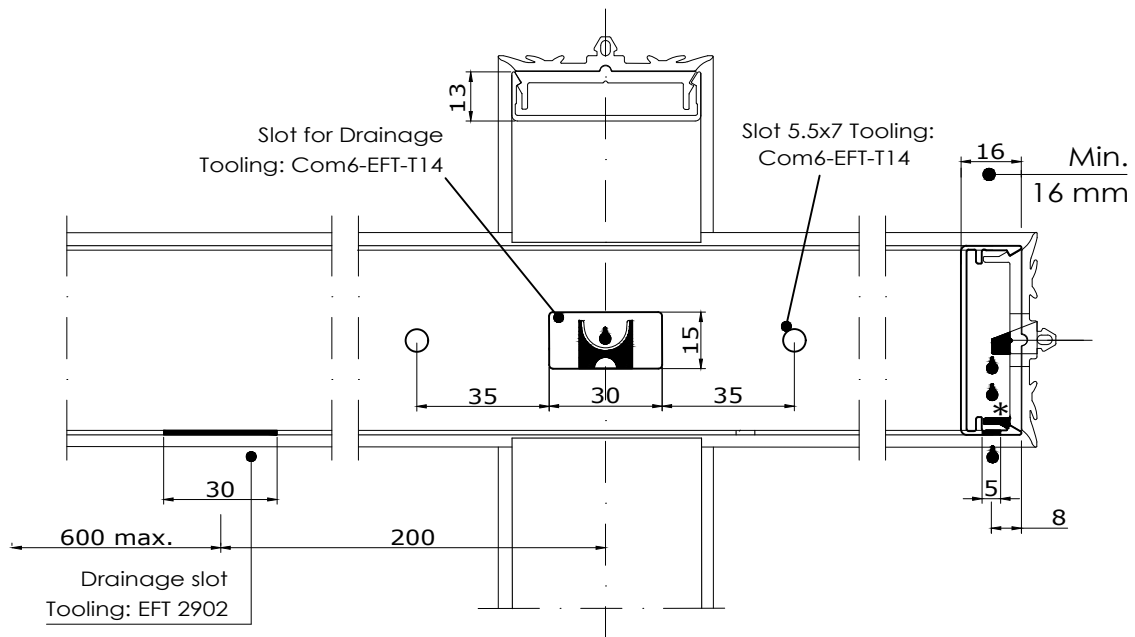
Issue: 05  
Date: 10-16

6

Fabrication

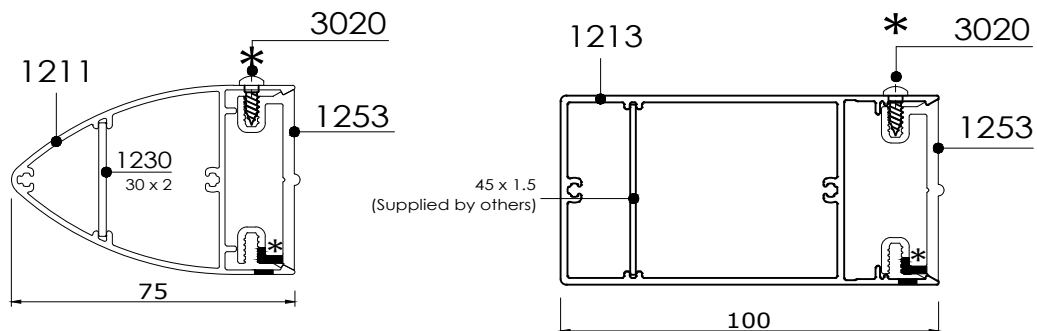
## Draining horizontal

Comar 6EFT

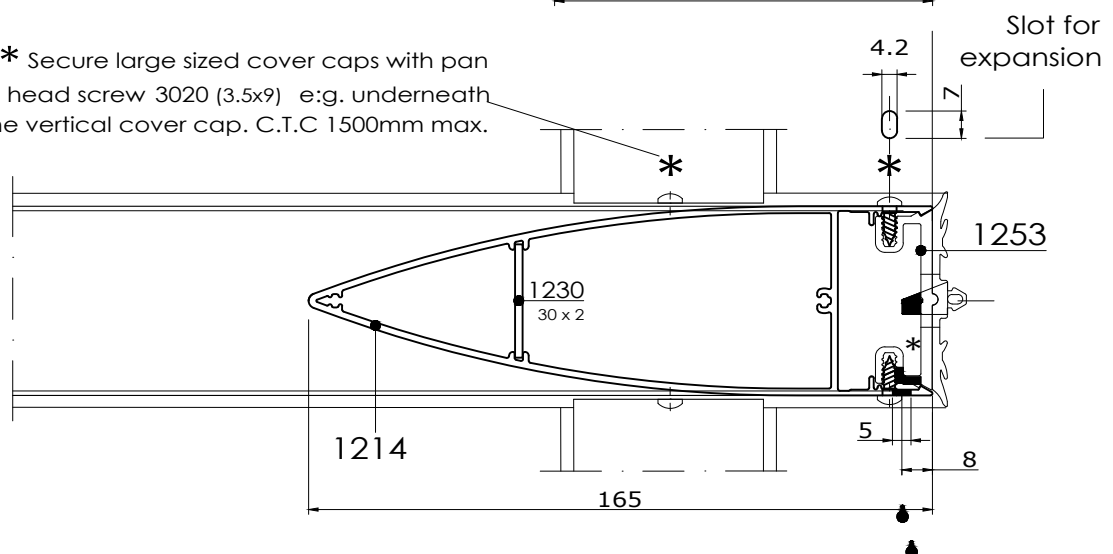


6.35

## 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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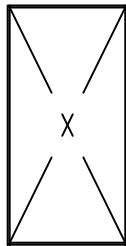
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Date: 10-16

## Fabrication

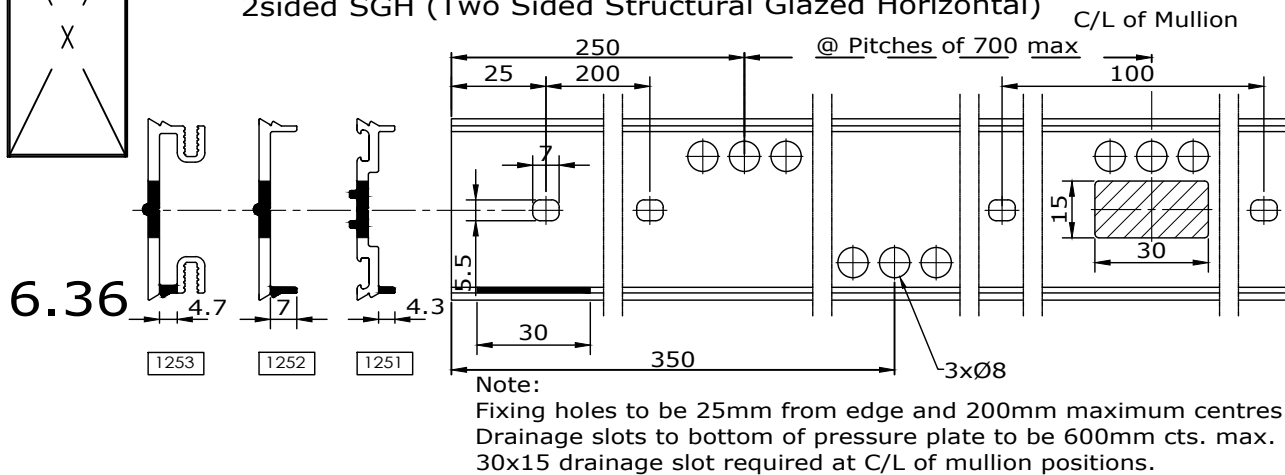
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## Comar 6EFT

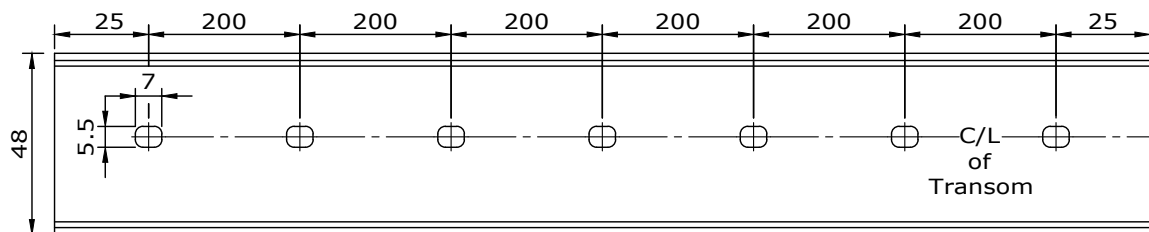
Tooling:  
Punch Com6-EFT-T14



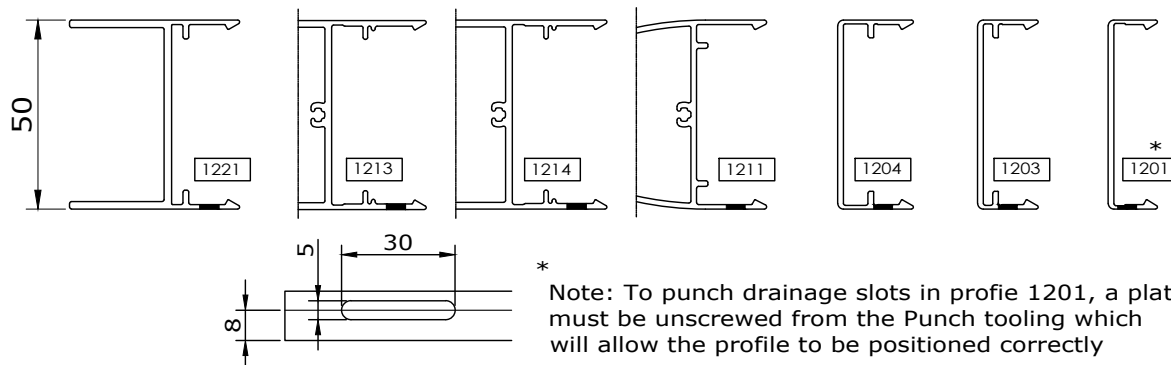
- 1A. Drainage slots & fixing holes Transom Pressure Plates  
2sided SGH (Two Sided Structural Glazed Horizontal)



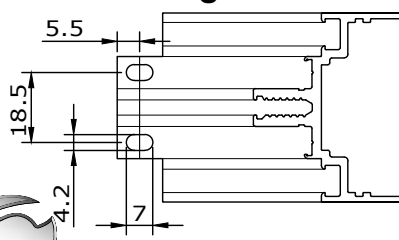
- 1B. Fixing holes Transom Pressure Plates  
Curtain Walling (Fully Capped Curtain Walling)



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



3. Fixing slots transom

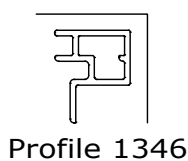


## Panel & Single glazed frames

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

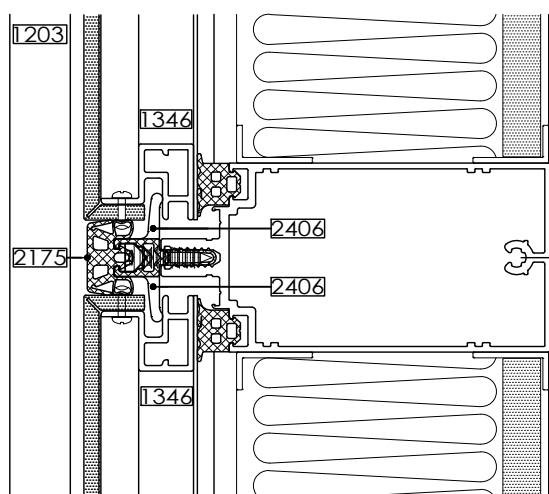
Between capped mullions/transoms: C.T.C - 22

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

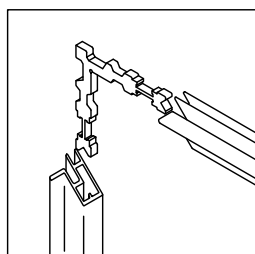


Profile 1346

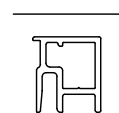
1346 between structural glazed joints when panels are required



EFT - 2539 Corner Cleat  
EFT - 1346

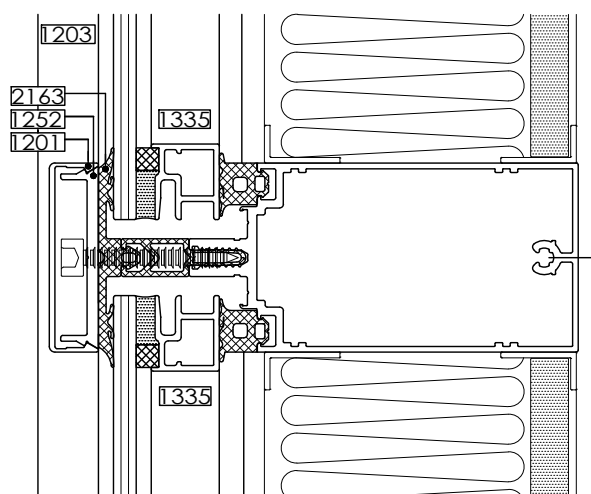


Frame lengths of 1346 to be mitred at 45° and crimped together using cleat 2539

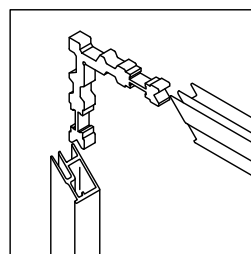


Profile 1335

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

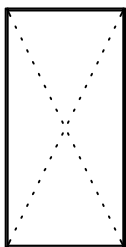
6.37

## Fabrication

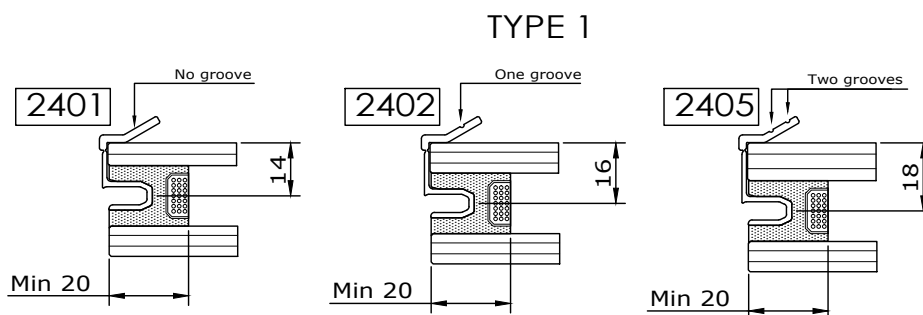
6

## Comar 6EFT

## Glass inserts

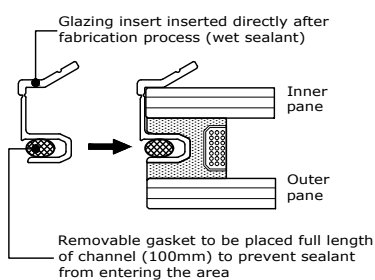


6.38

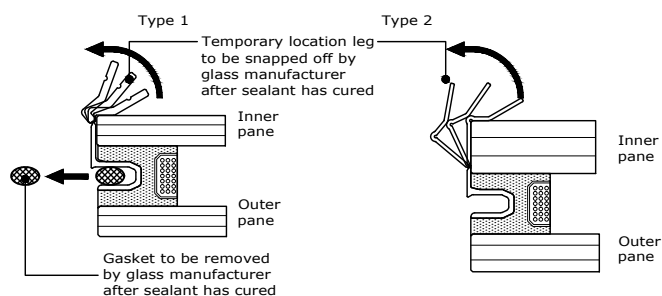


The Min.20mm to be set by your glass supplier according to standards and calculation.

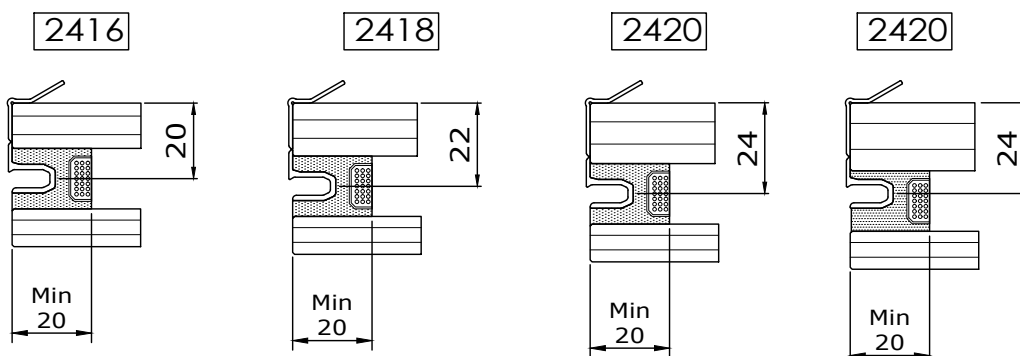
① Placing insert into spacer bar



② Removing snap off leg & gasket



## TYPE 2



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

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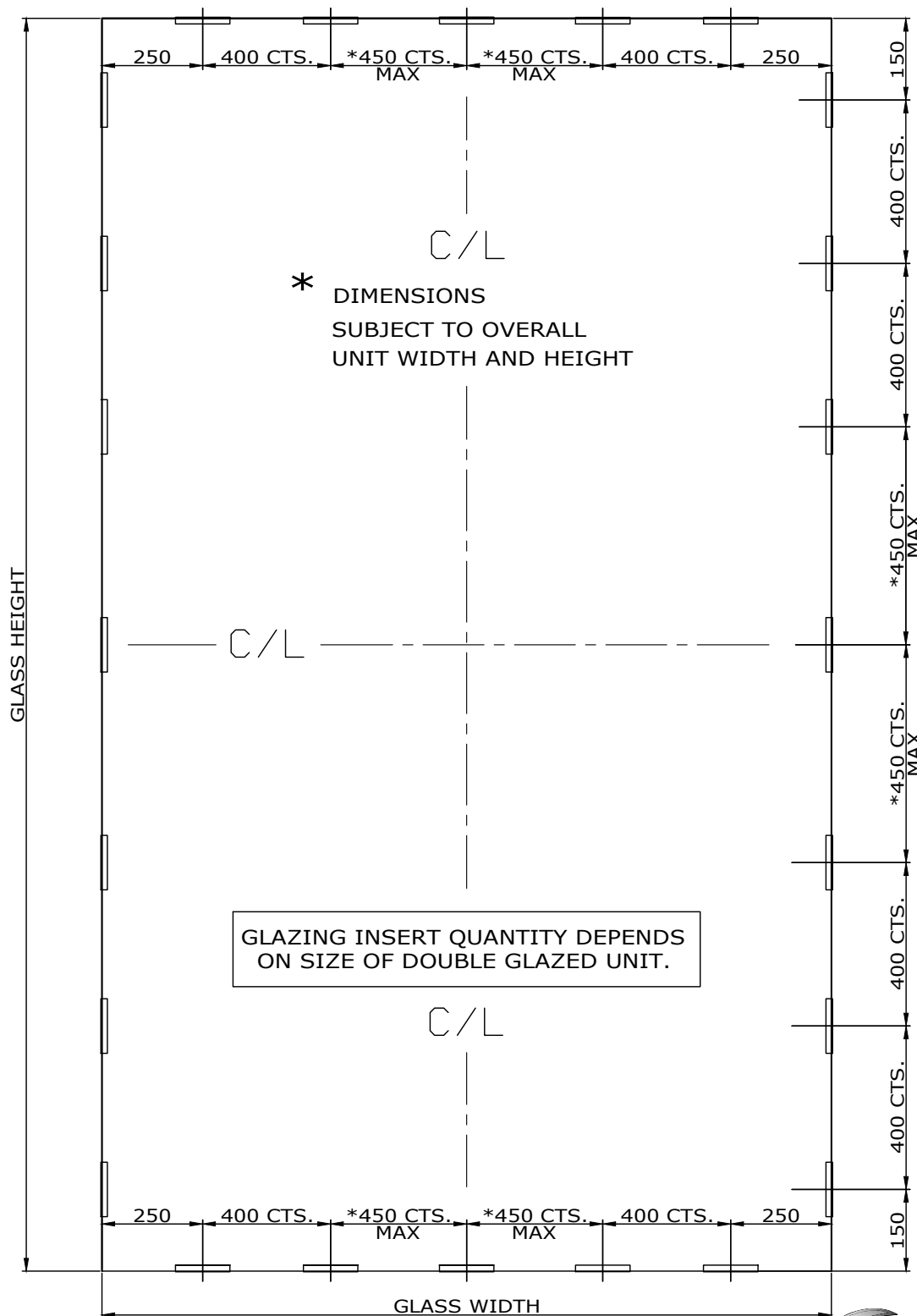


## Location of glazing inserts



6.39

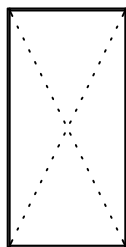
Fabricators Guide



# Fabrication

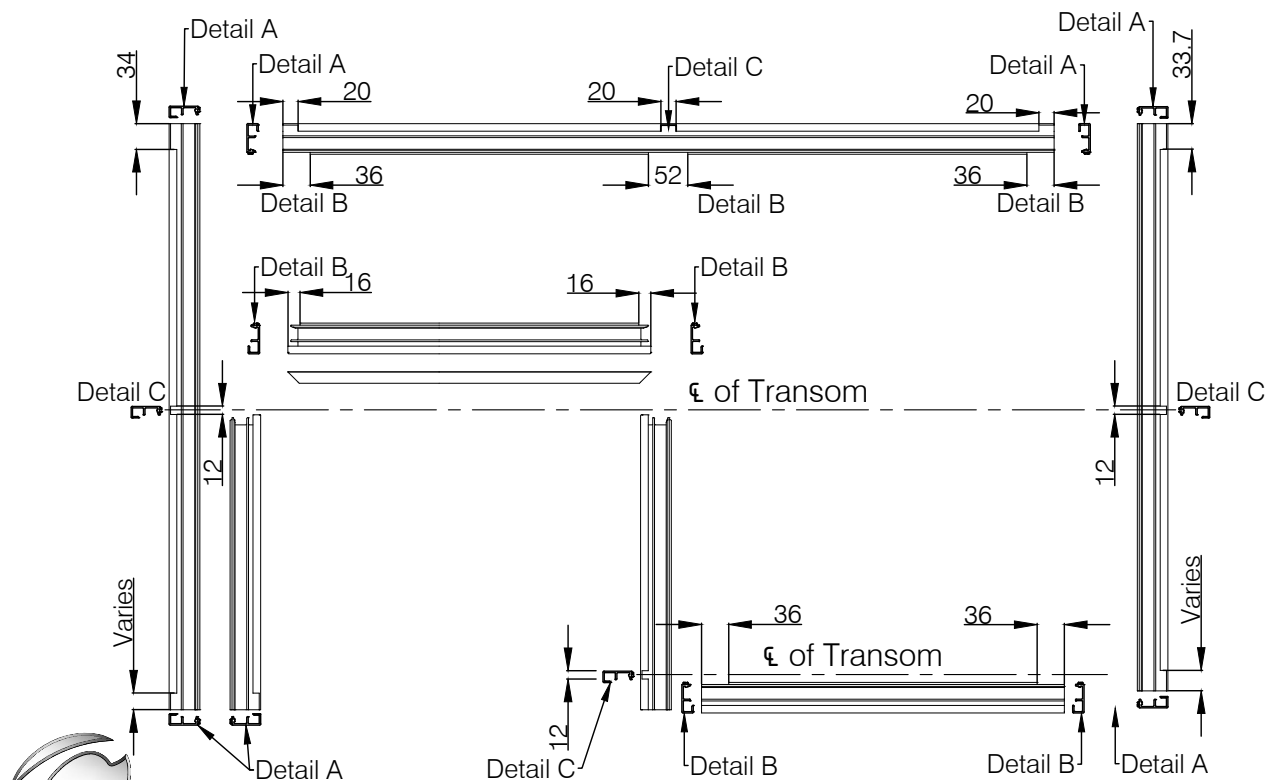
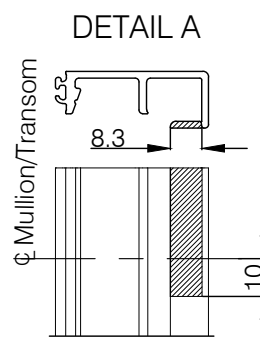
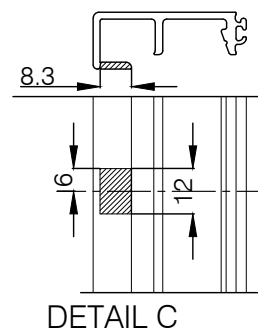
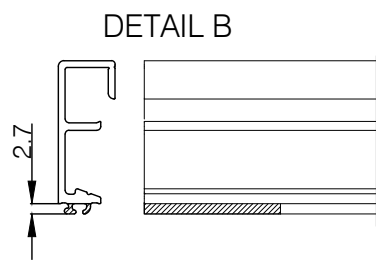
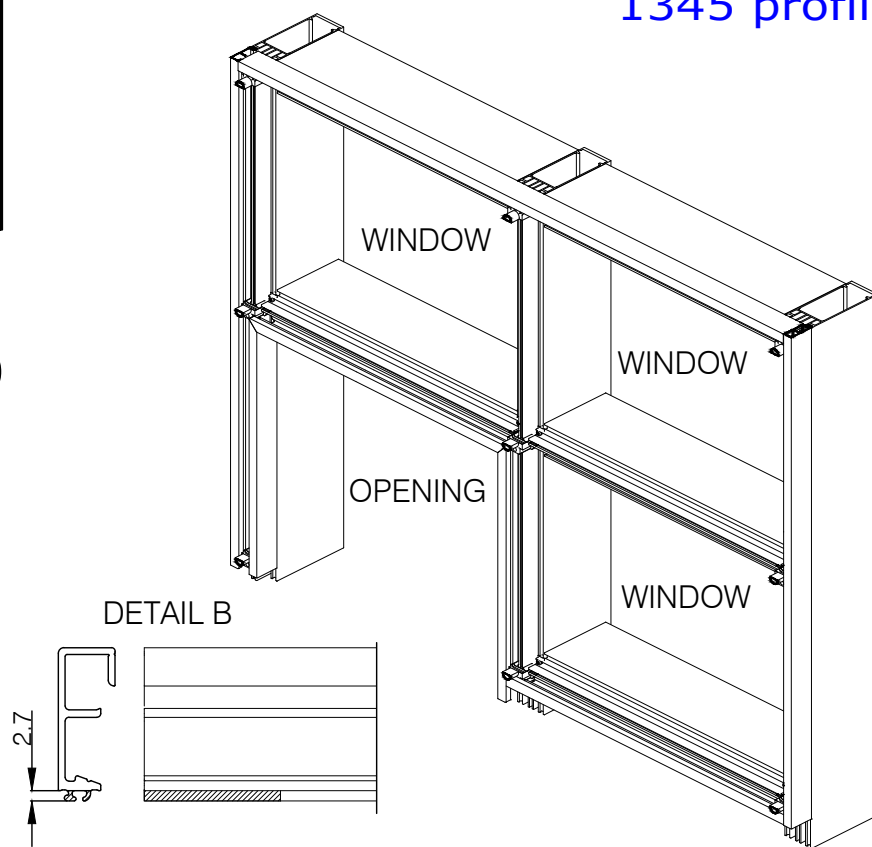
6

## Comar 6EFT



6.40

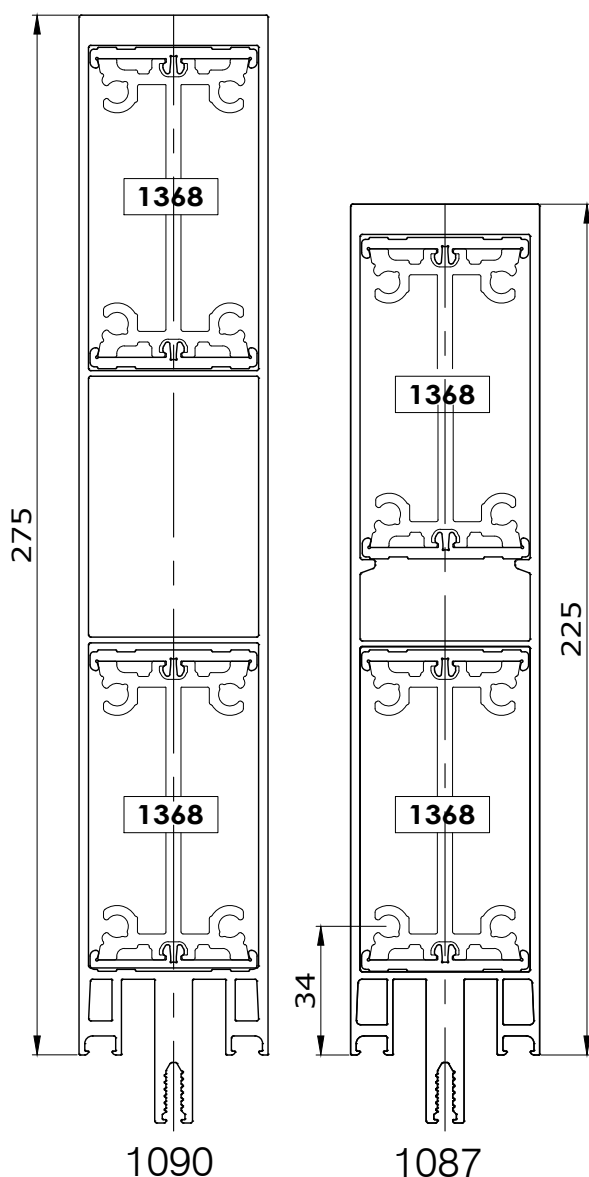
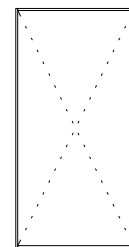
## Drainage diverter & 1345 profile preparation



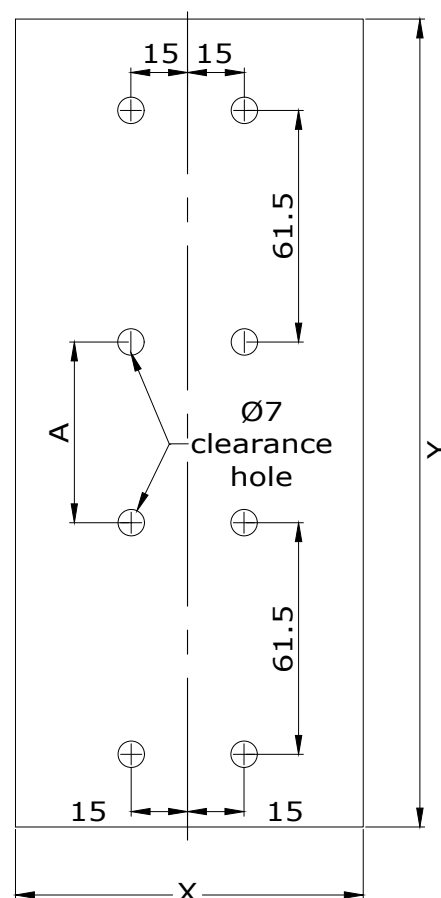
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## Mullion sleeve plate 1087- 225mm & 1090- 275mm



Mullion number	Dim A
1087	48
1090	98



6.41

Fabricators Guide

1090

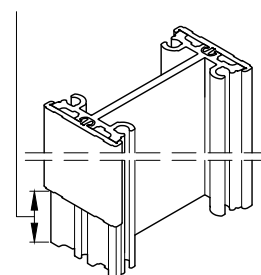
1087

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.

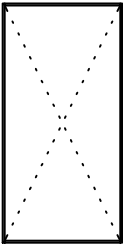
Front plastic cover cap cut back as needed to fit EPDM



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Comar 6EFT

Mullion shoe bracket

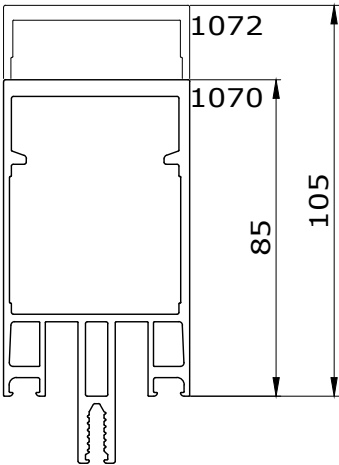
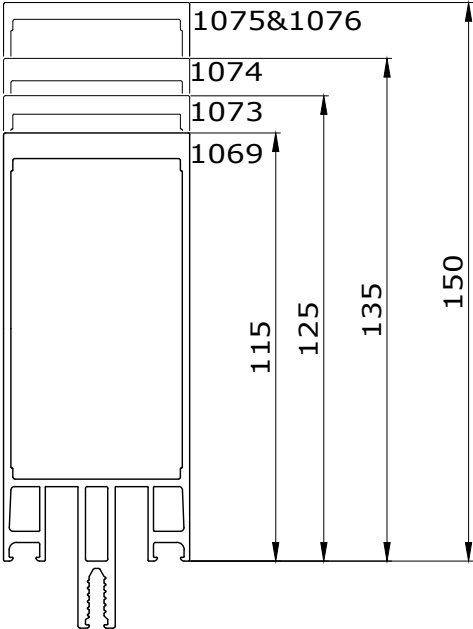


6.42

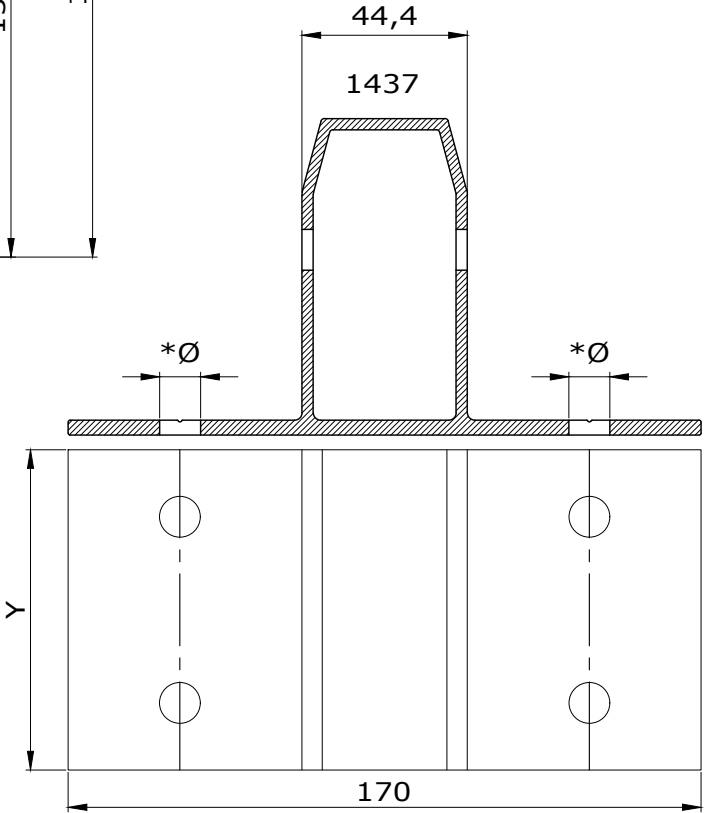
Mullion number	Size "Y" of Bracket	
	Bottom	Top
1070, 1072	36mm	39mm
1069, 1073 1074, 1075 1076	82mm	85mm
1077, 1080 1082, 1085	36mm 82mm	39mm 85mm
1087, 1090	2x 82mm	2x 85mm

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



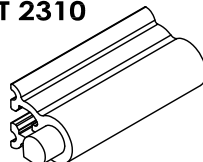
## Mullion 1087 & 1090 Preparation

### NOTE:

For transoms larger than  
225mm, mullion preps  
must be CNC cut.

Transoms installed in  
between ladders

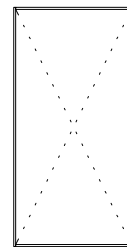
**EFT 2310**



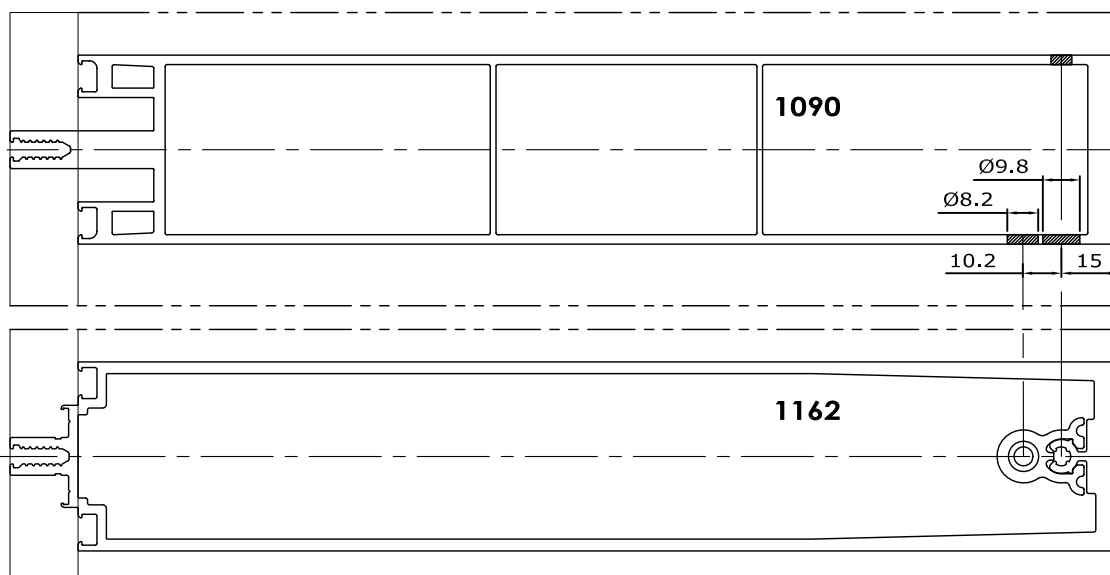
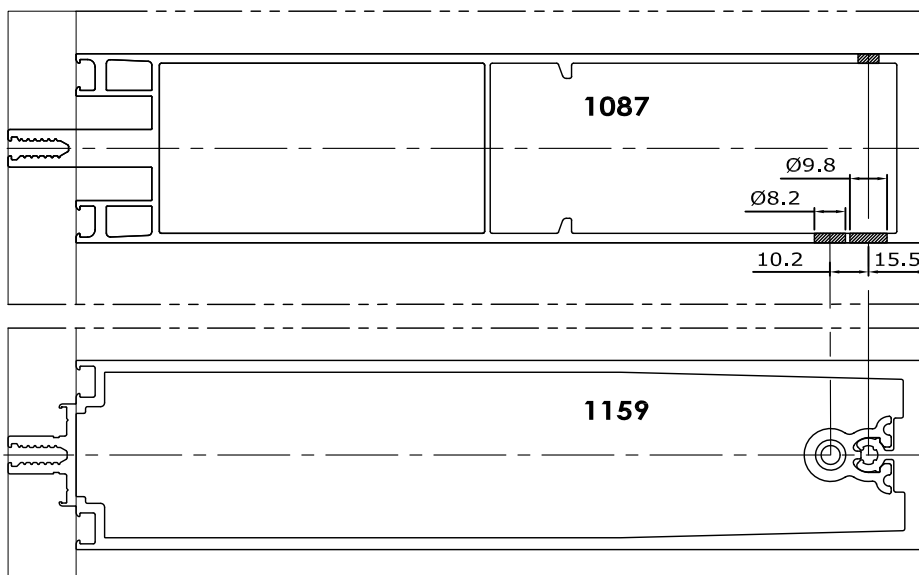
Ladder / unit



**3022 (4.8 x 65)**



6.43



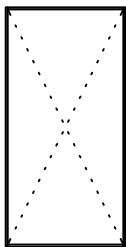
# Installation

6

## Comar 6EFT

## Mullion - Transom Connection

Option: 5 Glass weight max 450 kg



6.44

