

**sapa:**

# DUALFRAME

## PRODUCT MANUAL SUPPLEMENT

(To be read in conjunction with Version L6.0 of 75mm Casement Manual, 55mm Casement Manual, 55mm Tilt Before Turn Manual)

**Sapa Building Systems Limited**

Address **Alexandra Way, Ashchurch, Tewkesbury, Gloucestershire, GL20 8NB**

Telephone **01684 853500** Fax **01684 851850**

E-mail **info.buildingsystems.uk@sapagroup.com** Website **www.sapagroup.com/uk/buildingsystems**

**DUALFRAME**

55mm & 75mm Systems

**Index**

**75mm Casement**

DF309 Square Standard Frame	2-1	04.04
DF326 66mm Flat Mullion/Transom	2-1	04.04
DF327 66mm Softline Mullion/Transom	2-1	04.04
Additional Lockable Restrictors	2-2	04.04
DF729 Heavy Duty Coupler	2-3	04.04
New Internal Wedge Gasket	2-4	06.04
Trickle Vent Head Extender End Plug	2-4	06.04
Revised 57mm Flat Mullion/Transom	2-5	04.04
Miscellaneous Notes	2-5	04.04

**55mm Casement**

DF239 32mm Glazing Bead	3-1	04.04
DF328 66mm Flat Mullion/Transom	3-1	04.04
Additional Lockable Restrictors	3-2	04.04
Fixing Lugs and Braces	3-3	04.04
New Internal Wedge Gasket	3-4	06.04
Revised 57mm Flat Mullion/Transom	3-4	06.04
DFC379 5 Position Press Tool	3-5	04.04
Miscellaneous Notes	3-5	04.04

**55mm Tilt Before Turn**

DF239 32mm Glazing Bead	4-1	04.04
DF328 66mm Flat Mullion/Transom	4-1	04.04
Fixing Lugs and Braces	4-2	04.04
New Internal Wedge Gasket	4-3	06.04
Revised 57mm Flat Mullion/Transom	4-3	06.04
Miscellaneous Notes	4-4	04.04

Sapa's policy is one of continual system development and we reserve the right to incorporate design improvements and changes. Every effort is made to ensure that all details are correct at time of publication. However, it is the responsibility of the customer to check the accuracy of the relevant facts and information before entering into any contract or other commitment. Up to date information is freely available from the Sapa Building Systems Webshop. All Products and systems which Sapa supply are supplied subject to Sapa's standard Terms and Conditions of Sale current from time to time.

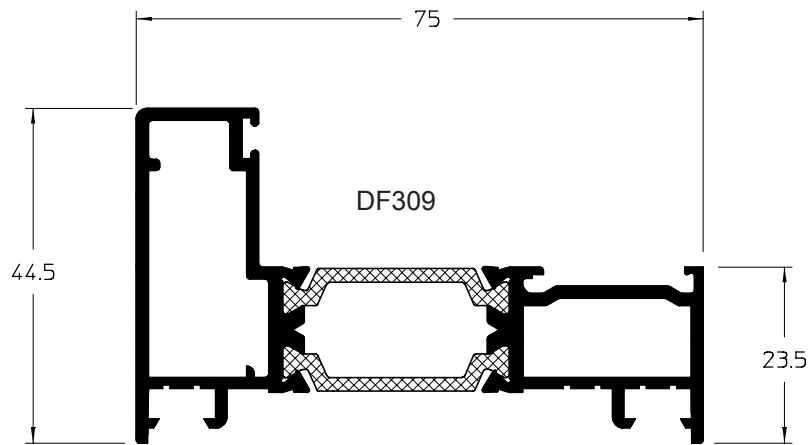
**This Page Intentionally Left Blank**

## 75mm Casement

### Standard Square Outerframe

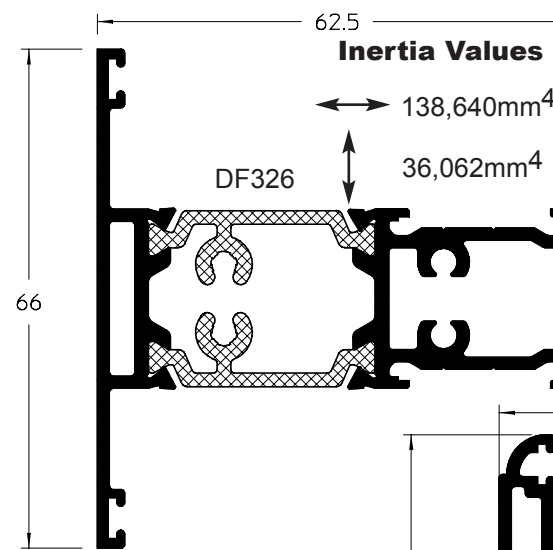
Below is shown the standard square outerframe DF309, which has been added to the 75mm Dualframe Casement range.

All cutting calculations, machining and assembly details are exactly the same as for Standard Softline Outerframe DF304 shown in the current Dualframe 75mm Casement Manual.



### 66mm Mullion/Transoms

Below are shown the 66mm Flat and Softline Mullion/Transoms DF326 & DF327, which have been added to the Dualframe 75mm Casement range.

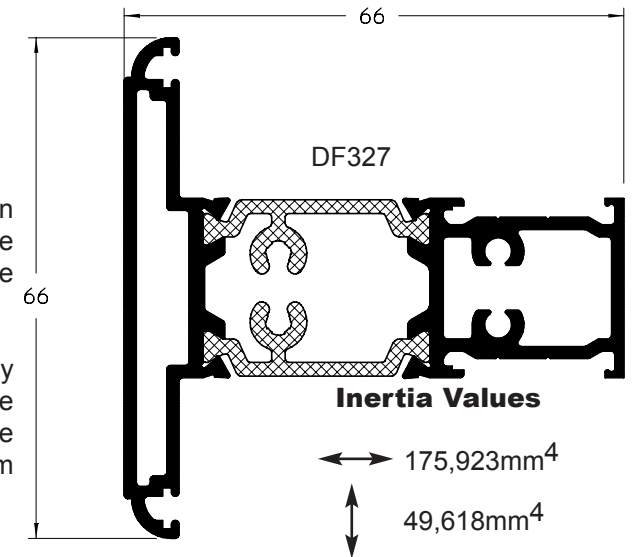


The Basic 'B' allowance is 24mm (i.e. 12mm either side of centreline)

The cutting length for all mullion/transoms is Basic Size B. For further explanation of 'B' sizes see current Dualframe 75mm Casement Manual pages 4-1 to 4-6.

Drill Jig DFC172 has been updated to Issue 4 to include additional holes for these profiles.

All assembly details are exactly the same as those shown for the 72mm Mullion/Transoms in the current Dualframe 75mm Casement Manual.



**Inertia Values**  
 ↔ 175,923mm<sup>4</sup>  
 ↑↓ 49,618mm<sup>4</sup>

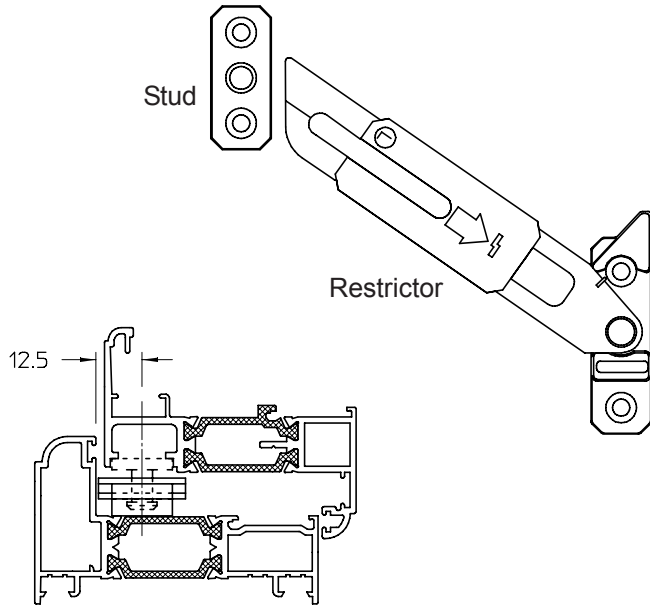
## 75mm Casement

### Lockable Restrictors

The following details show fitting instructions for Lockable Restrictors.

Part Number	Description
DFP576-50	Casement Window Lockable Restrictor - LH (Pack 50)
DFP577-50	Casement Window Lockable Restrictor - RH (Pack 50)
DFP578-50	HD Casement Window Lockable Restrictor - LH (Pack 50)
DFP579-50	HD Casement Window Lockable Restrictor - RH (Pack 50)

Restrictors apply to both external and internal glaze vents.

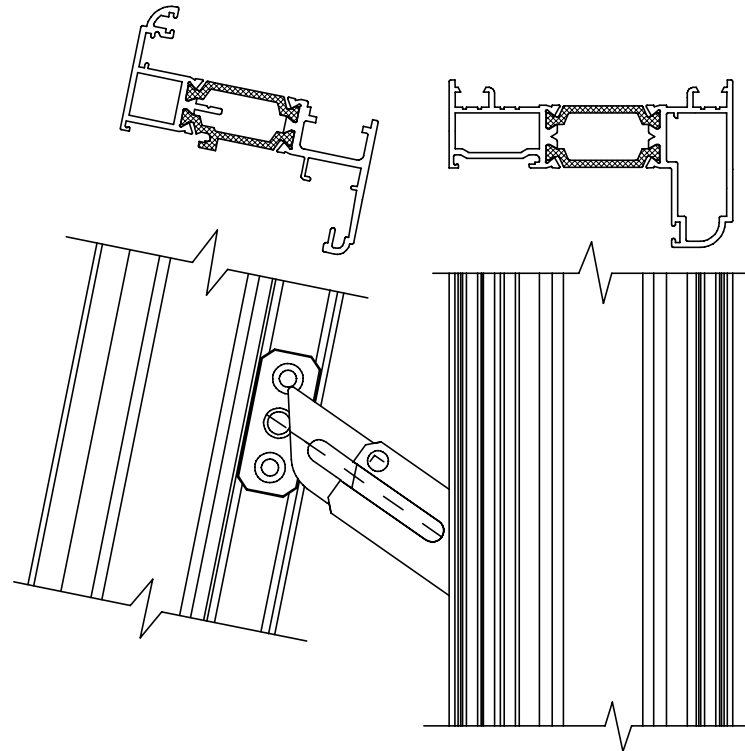


Select correct hand of restrictor for application (LH shown). Restrictor must not interfere with friction stay. Position restrictor to give required amount of opening.

Drill through holes in restrictor 3.5dia. Open up holes in frame to 6.0dia and fit M4 nutserts (DFP166-100). Fit restrictor to frame using M4 x 16 csk machine screws (DFP181-100).

Open vent slightly as shown below. Position stud in Eurogroove and align with centre of slot on restrictor. Drill 3.5dia and fix using No. 8 x3/4" csk self tapping screw (AF302).

Check that restrictor opens and automatically re-engages when window is shut.



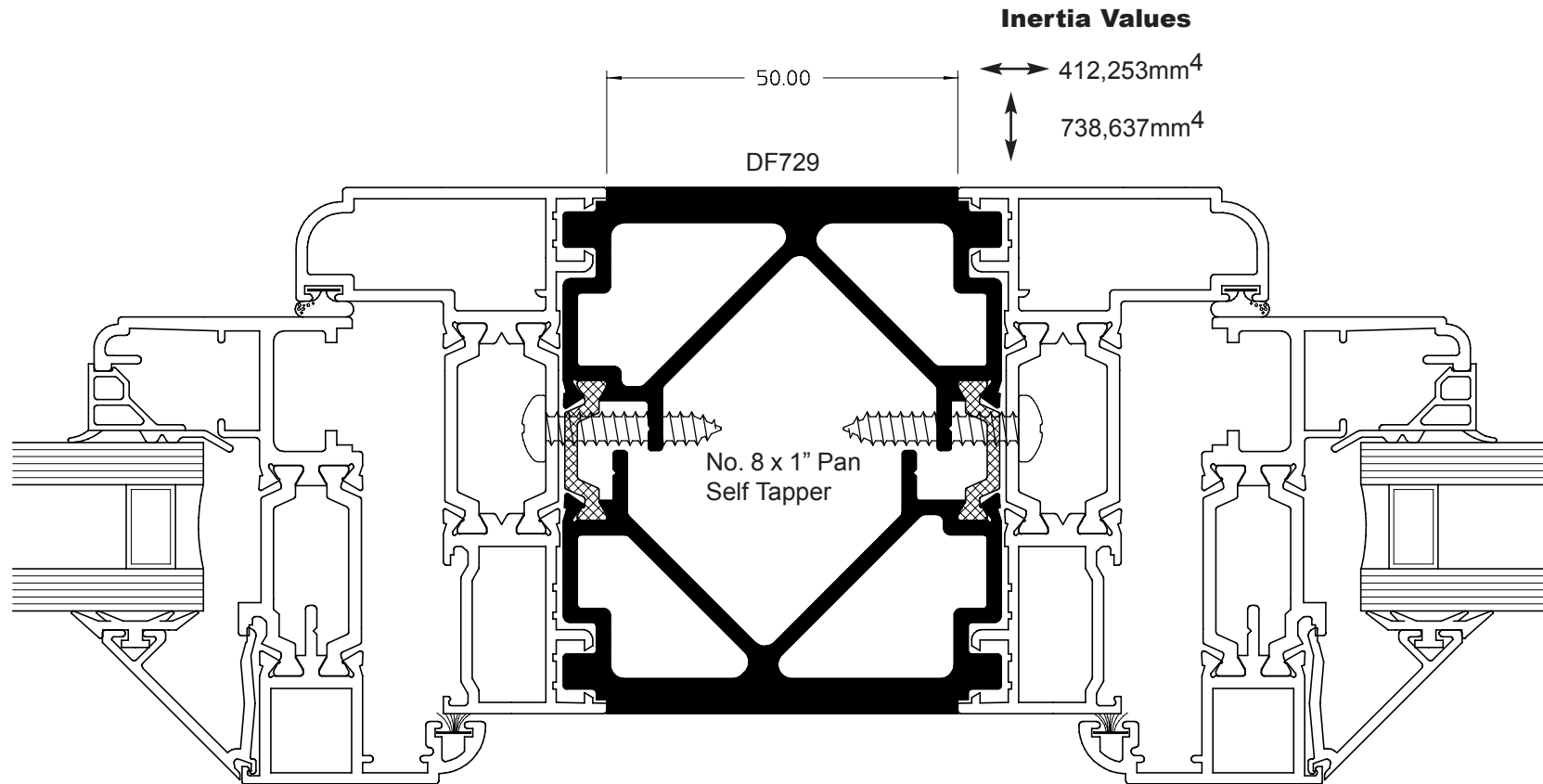
**DUALFRAME**

55mm & 75mm Systems

## 75mm Casement

### 50mm In-Line Heavy Duty Post

Below is shown the 50mm In-Line Heavy Duty Post DF729, which has been added to the 75mm Dualframe Casement range.



**DUALFRAME**

55mm & 75mm Systems

# 75mm Casement

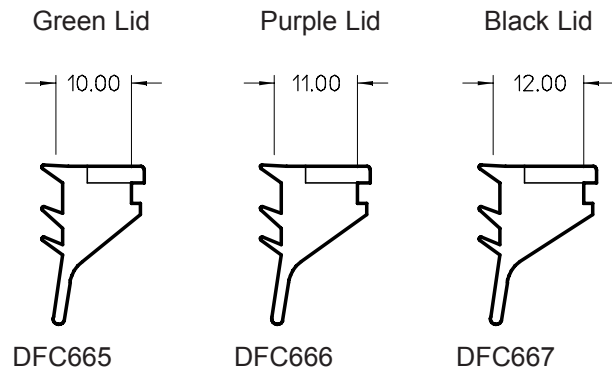
**& part numbers New Internal Wedge Gaskets**

The wedge gaskets shown below are being introduced as an alternative to the existing DFC266 internal trim.

Three sizes are available to cater for glazing/metal tolerances. The 11mm version is recommended where all tolerances are to nominal size.

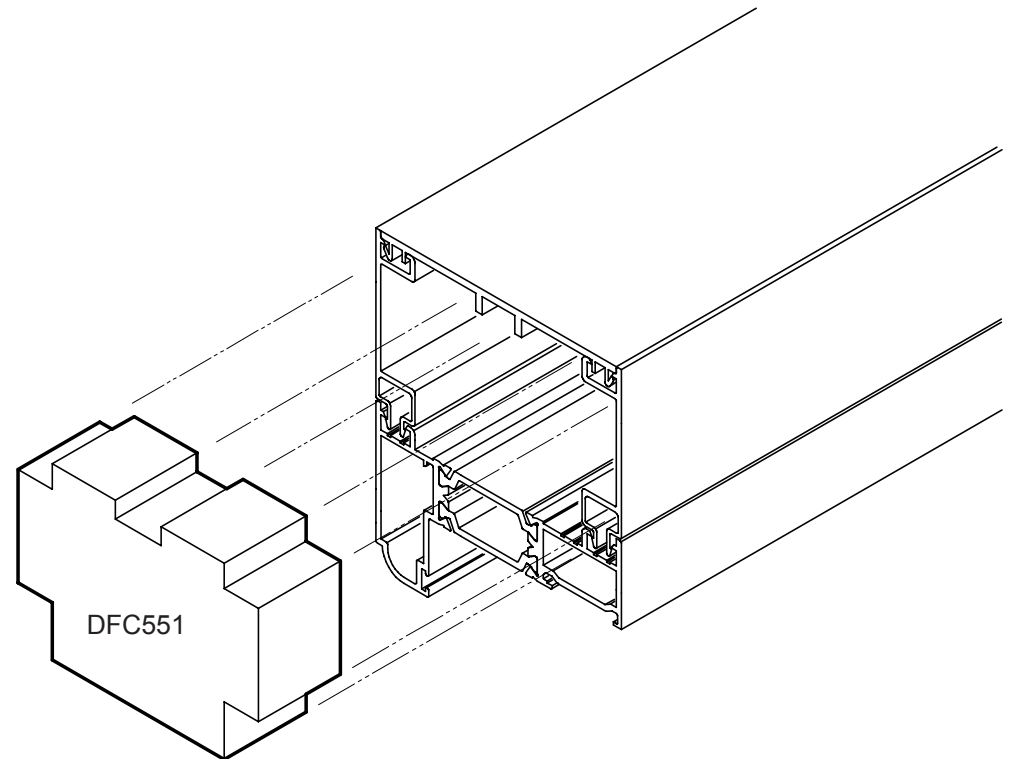
The gasket looks similar to the trim once installed, but is delivered in flexible 50 metre coils. To aid identification and keep the white gasket clean, the coils will be supplied in buckets with different coloured lids (See below for colours). Make a hole in the centre of the lid and feed the gasket from the centre of the coil through the lid.

Due to the design, it is not necessary to cut these gaskets too much oversize when fitting.



**Trickle Vent Head Extender End Plug**

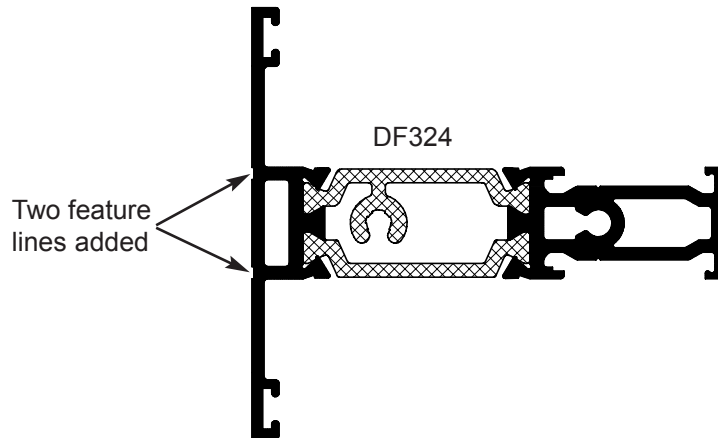
The plug shown below (DFP551-50) must be fitted to the end of all trickle vent extenders. Seal any remaining gaps with silicone.



## 75mm Casement

### Revised 57mm Flat Mullion/Transom

Due to extrusion difficulties, we are revising the inner profile of the 57mm flat mullion/transom (DF324). This change is for aesthetic purposes only and does not affect any other aspect (e.g. assembly etc). Other mullion/transoms in the range are not affected.



### Miscellaneous Notes

#### Weatherbars

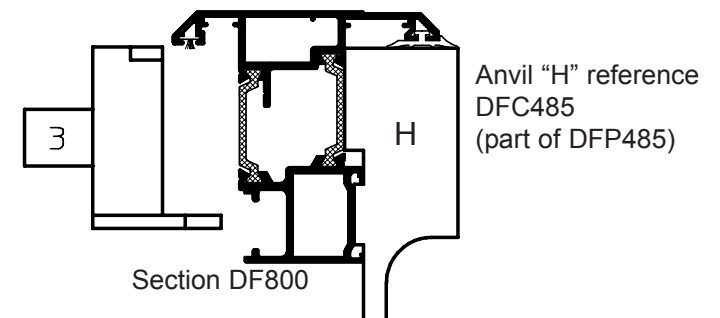
Please note, that where opening lights do not have protection at the head (e.g. a soffit or similar) a weatherbar must always be fitted to achieve the performance levels quoted in the current Product Manual. A weatherbar must also be fitted at the transom immediately above any opening lights unless another opening light occurs immediately above.

#### Variable Baypoles DF723, DF724 & DF725

Attention is drawn to the angle limitations shown in the current manual parts list on page 3-3. Where opening lights are required outside these limitations, either use Extended Frame DF305 or DF310, or use frame extender CDP11 at jambs where they meet baypoles.

#### Correction to Manual Illustration

The illustration of the internal glaze vent crimper anvil (DFC485) on page 3-20 of the current Dualframe 75mm Casement Manual is incorrect. Please see below corrected illustration.



**This Page Intentionally Left Blank**

**DUALFRAME**

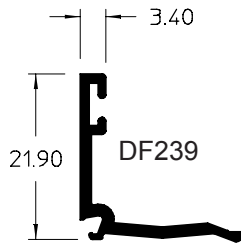
55mm & 75mm Systems

## 55mm Casement

### 32mm Glazing Bead

Below is shown the 32mm Glazing Bead DF239, which has been added to the 55mm Dualframe Casement range.

All cutting calculations, are exactly the same as for square glazing beads shown in the current Dualframe 55mm Casement Manual.

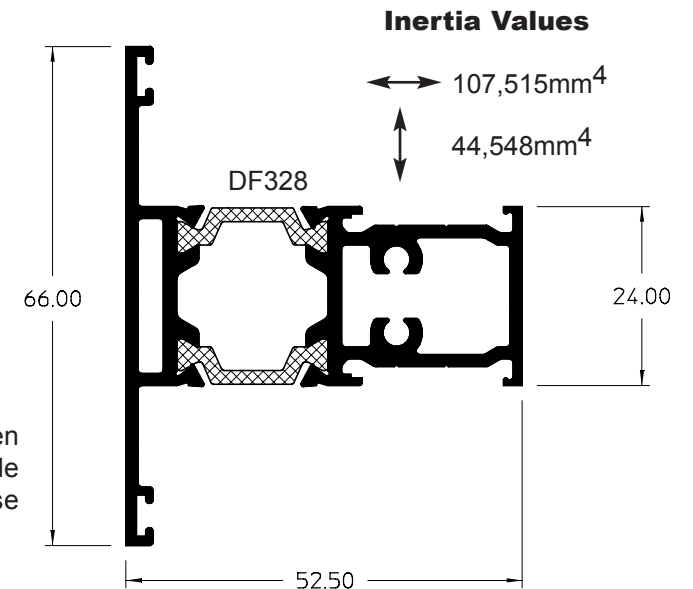


### 66mm Mullion/Transoms

Below is shown the 66mm Mullion/Transom DF328, which has been added to the Dualframe 55mm Casement range.

The Basic 'B' allowance is 24mm (i.e. 12mm either side of centreline)

The cutting length for all mullion/transoms is Basic Size B. For further explanation of 'B' sizes see current Dualframe 55mm Casement Manual pages 4-1 to 4-5.



Drill Jig DFC465 has been updated to Issue 2 to include additional holes for these profiles.

All assembly details are exactly the same as those shown for the 72mm Mullion/Transoms in the current Dualframe 55mm Casement Manual.

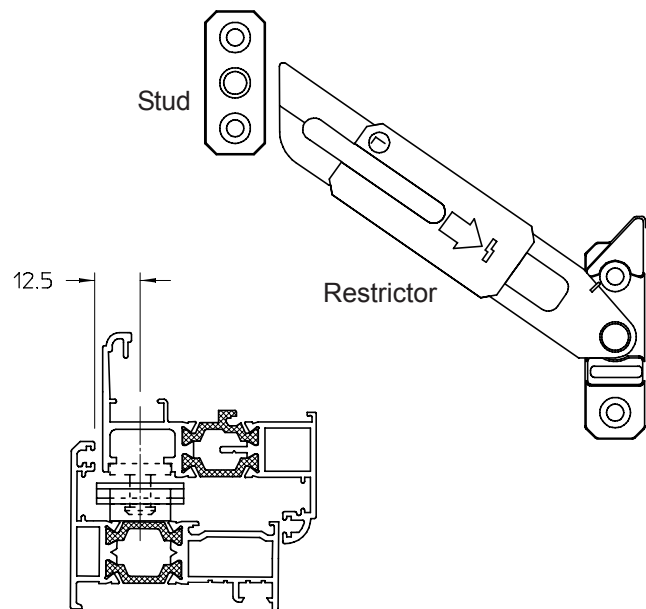
## 55mm Casement

### Lockable Restrictors

The following details show fitting instructions for Lockable Restrictors.

Part Number	Description
DFP576-50	Casement Window Lockable Restrictor - LH (Pack 50)
DFP577-50	Casement Window Lockable Restrictor - RH (Pack 50)
DFP578-50	HD Casement Window Lockable Restrictor - LH (Pack 50)
DFP579-50	HD Casement Window Lockable Restrictor - RH (Pack 50)

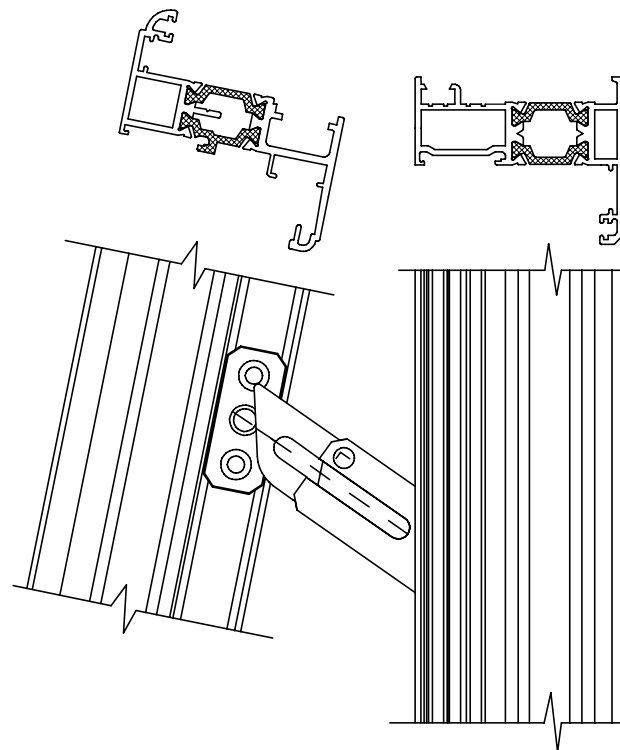
Restrictors apply to both external and internal glaze vents.



Drill through holes in restrictor 3.5dia. Open up holes in frame to 6.0dia and fit M4 nutserts (DFP166-100). Fit restrictor to frame using M4 x 16 csk machine screws (DFP181-100).

Open vent slightly as shown below. Position stud in Eurogroove and align with centre of slot on restrictor. Drill 3.5dia and fix using No. 8 x3/4" csk self tapping screw (AF302).

Check that restrictor opens and automatically re-engages when window is shut.



**DUALFRAME**

55mm & 75mm Systems

## 55mm Casement

### Fixing Lug

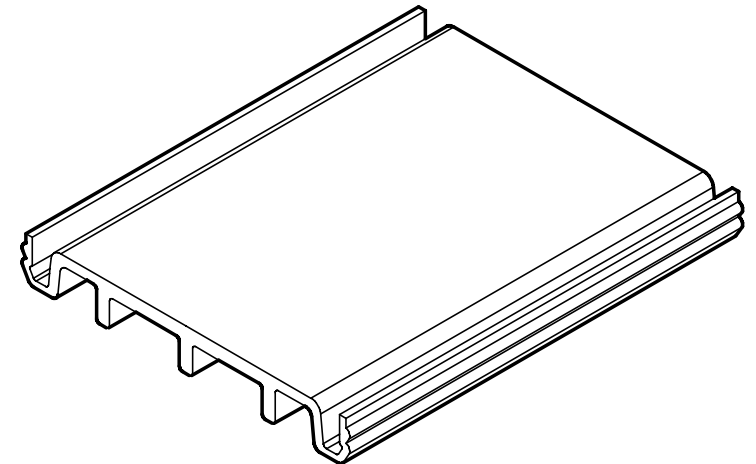
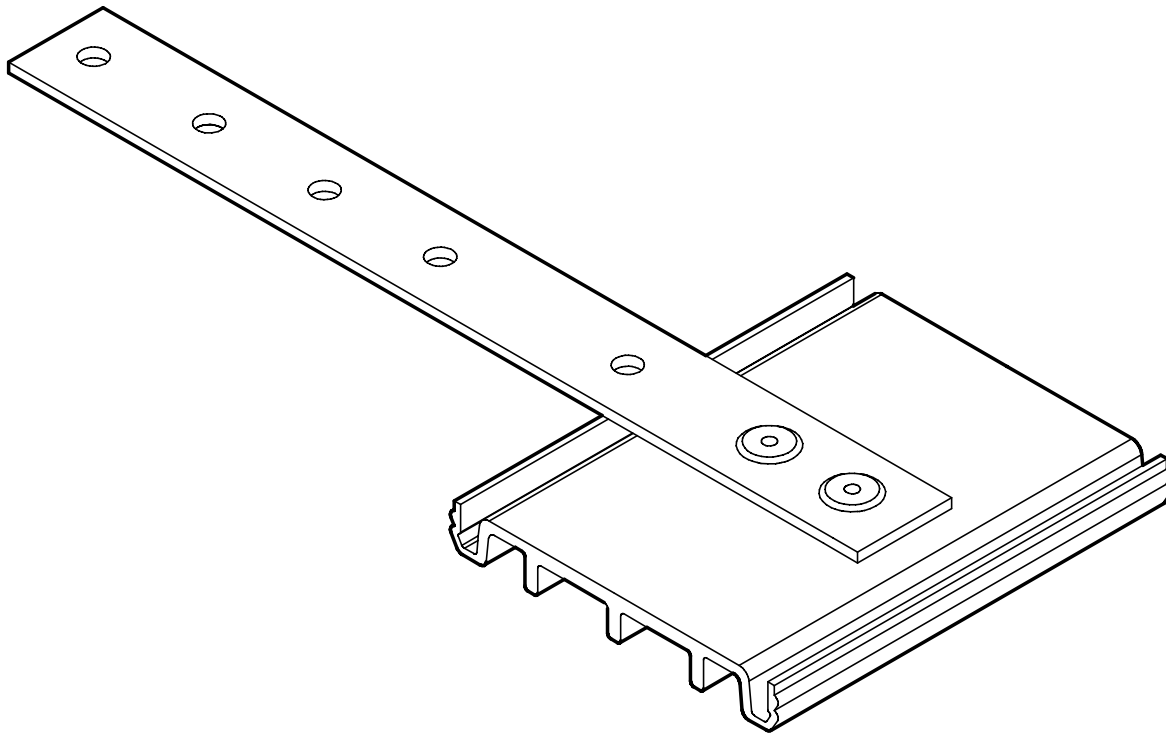
Below is shown the outerframe fixing lug DFP628-50, which has been added to the 55mm Dualframe range.

Fit at 150mm in from corners and at no more than 600mm centres. Packing about the lug is advisable to stabilize the frame.

### Fixing Brace

Below is shown the outerframe fixing brace DFP627-20, which has been added to the 55mm Dualframe range.

It is recommended that fixing braces are used at every screw fixing point for positive fixing.



## 55mm Casement

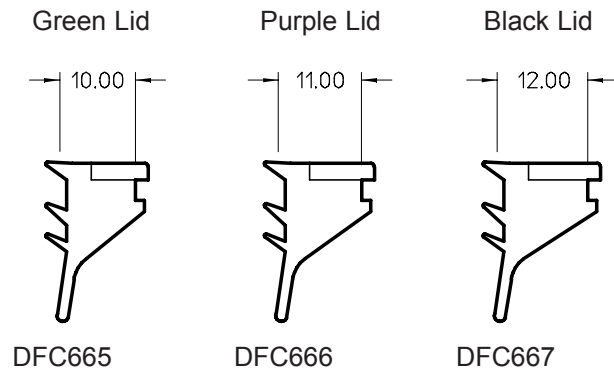
### New Internal Wedge Gaskets

The wedge gaskets shown below are being introduced as an alternative to the existing DFC266 internal trim.

Three sizes are available to cater for glazing/metal tolerances. The 11mm version is recommended where all tolerances are to nominal size.

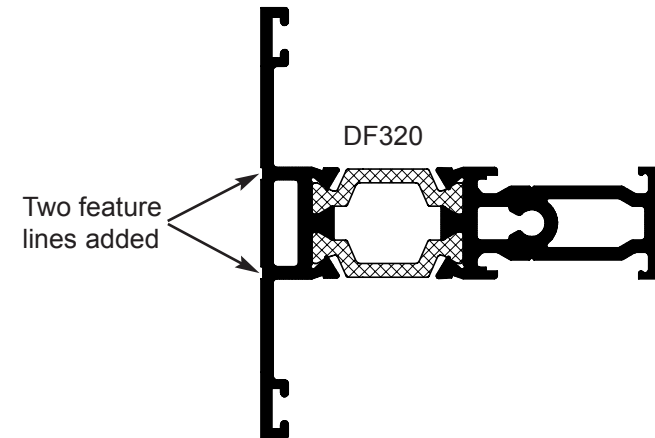
The gasket looks similar to the trim once installed, but is delivered in flexible 50 metre coils. To aid identification and keep the white gasket clean, the coils will be supplied in buckets with different coloured lids (See below for colours & part numbers). Make a hole in the centre of the lid and feed the gasket from the centre of the coil through the lid.

Due to the design, it is not necessary to cut these gaskets too much oversize when fitting.



### Revised 57mm Flat Mullion/Transom

Due to extrusion difficulties, we are revising the inner profile of the 57mm flat mullion/transom (DF320). This change is for aesthetic purposes only and does not affect any other aspect (e.g. assembly etc). Other mullion/transoms in the range are not affected.



**DUALFRAME**

55mm & 75mm Systems

## 55mm Casement

### 5 Position Press Tool

Below is an illustration of the 55mm Casement 5 Position Press Tool DFC379. The following operations are possible with this tool when used in conjunction with DFC390 Power Press.

Vent frame drainage holes. (DF330, DF332, DF334 & DF350)

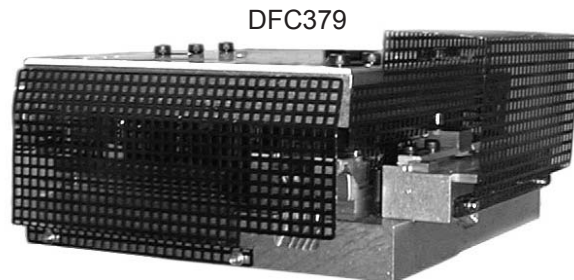
Bead drainage notch. (DF105 only)

Outerframe drainage crop-out. (DF300, DF301, DF306, DF307, DF320, DF328, DF340 & DF349)

Transom cruciform hole in polyamide. (DF320, DF328, DF340 & DF349)

Transom cruciform hole in metal. (DF320, DF328, DF340 & DF349)

**Important** - Safe operating procedures shown in current Dualframe 55mm Casement Manual Page 3-8 must be followed.



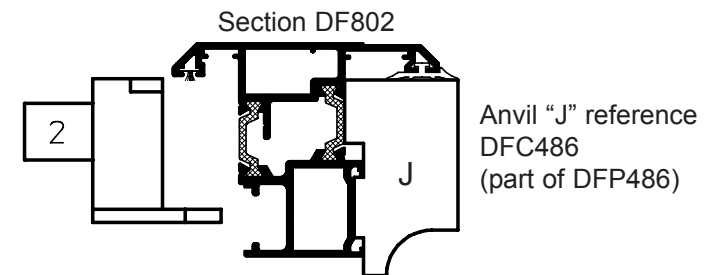
### Miscellaneous Notes

#### Weatherbars

Please note, that where opening lights do not have protection at the head (e.g. a soffit or similar) a weatherbar must always be fitted to achieve the performance levels quoted in the current Product Manual. A weatherbar must also be fitted at the transom immediately above any opening lights unless another opening light occurs immediately above.

#### Correction to Manual Illustration

The illustration of the internal glaze vent crimper anvil (DFC486) on page 3-13 of the current Dualframe 55mm Casement Manual is incorrect. Please see below corrected illustration. Also the punch head retaining screw will need to be replaced with a M8 x 30 socket grub screw to avoid the head of the screw clashing with the profile.



**This Page Intentionally Left Blank**

**DUALFRAME**

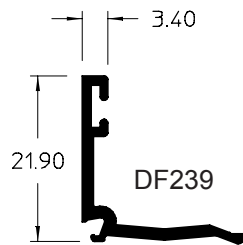
55mm & 75mm Systems

## 55mm Tilt Before Turn

### 32mm Glazing Bead

Below is shown the 32mm Glazing Bead DF239, which has been added to the 55mm Dualframe TBT range.

All cutting calculations, are exactly the same as for square glazing beads shown in the current Dualframe 55mm TBT Manual.

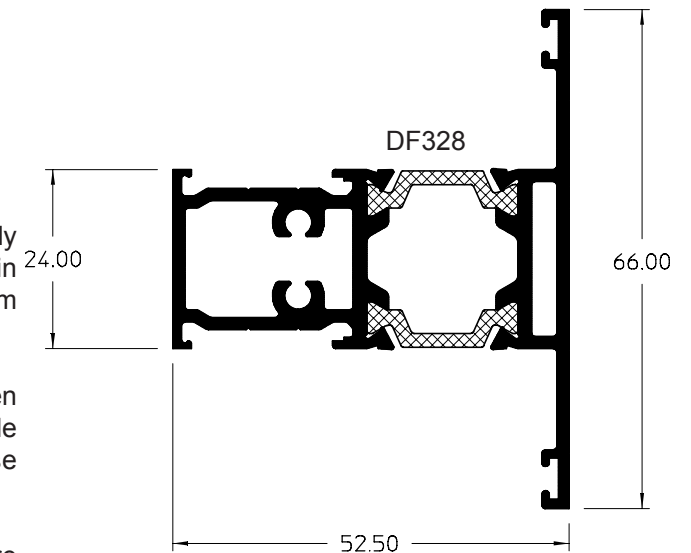


### 66mm Mullion/Transoms

Below is shown the 66mm Mullion/Transom DF328, which has been added to the Dualframe 55mm TBT range.

The Basic 'B' allowance is 24mm (i.e. 12mm either side of centreline)

The cutting length for all mullion/transoms is Basic Size B. For further explanation of 'B' sizes see current Dualframe 55mm TBT Manual page 4-1.



Drainage details are exactly the same as those shown in the current Dualframe 55mm Pivot Manual.

Drill Jig DFC465 has been updated to Issue 2 to include additional holes for these profiles.

All assembly details are exactly the same as those shown for the 72mm Mullion/Transoms in the current Dualframe 55mm TBT Manual.

**DUALFRAME**

55mm & 75mm Systems

## 55mm Tilt Before Turn

### Fixing Lug

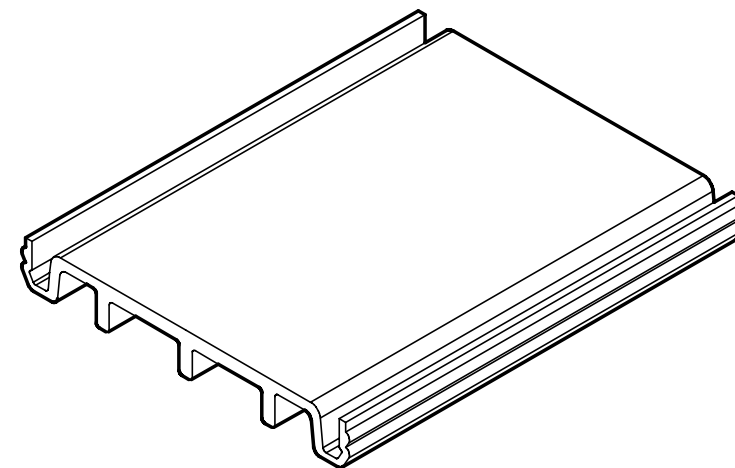
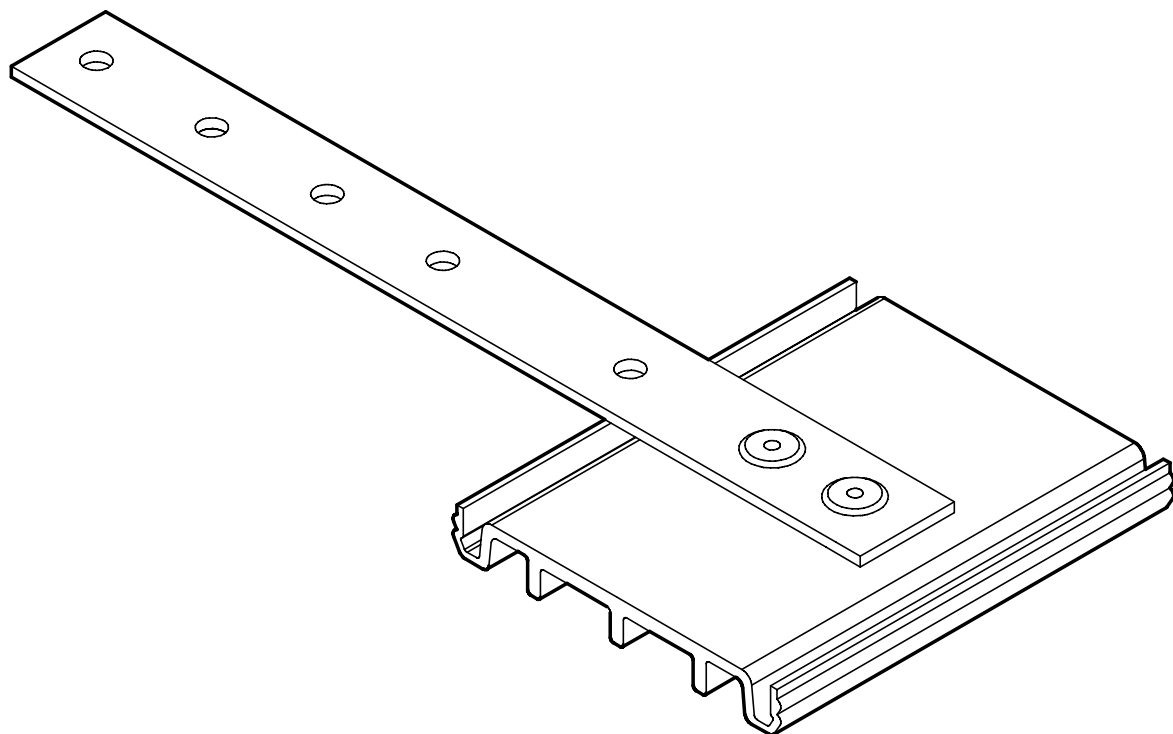
Below is shown the outerframe fixing lug DFP628-50, which has been added to the 55mm Dualframe range.

Fit at 150mm in from corners and at no more than 600mm centres. Packing about the lug is advisable to stabilize the frame.

### Fixing Brace

Below is shown the outerframe fixing brace DFP627-20, which has been added to the 55mm Dualframe range.

It is recommended that fixing braces are used at every screw fixing point for positive fixing.



**DUALFRAME**

55mm & 75mm Systems

## 55mm Tilt Before Turn

### New Internal Wedge Gaskets

The wedge gaskets shown below are being introduced as an alternative to the existing DFC266 internal trim.

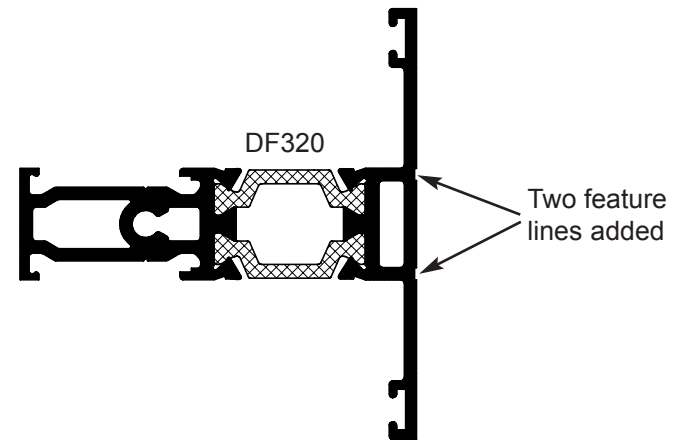
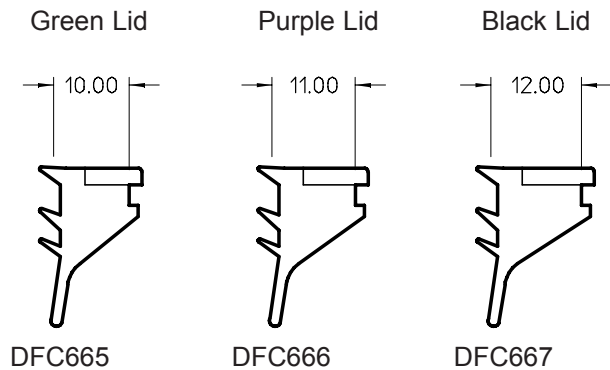
Three sizes are available to cater for glazing/metal tolerances. The 11mm version is recommended where all tolerances are to nominal size.

The gasket looks similar to the trim once installed, but is delivered in flexible 50 metre coils. To aid identification and keep the white gasket clean, the coils will be supplied in buckets with different coloured lids (See below for colours & part numbers). Make a hole in the centre of the lid and feed the gasket from the centre of the coil through the lid.

Due to the design, it is not necessary to cut these gaskets too much oversize when fitting.

### Revised 57mm Flat Mullion/Transom

Due to extrusion difficulties, we are revising the outer profile of the 57mm flat mullion/transom (DF320). This change is for aesthetic purposes only and does not affect any other aspect (e.g. assembly etc). Other mullion/transoms in the range are not affected.



**DUALFRAME**

55mm & 75mm Systems

## 55mm Tilt Before Turn

### Miscellaneous Notes

Please note that TBT opening lights cannot be fitted side by side with a 57mm mullion between. Where this configuration is required, use either a 66 or 72mm wide mullion.

### Glass Sizes Into Opening Lights

To improve the clearance around glass into TBT opening lights, an additional 3mm should be deducted from existing glass sizes. (i.e. The glass calculation in the manual should read 'B' size minus 97mm)

### Sub Cill Fixing Lugs

Fixing lugs for DF712 sub Cill are now available in packs of 50. Part Number DFP572-50.

### Correction to Drive Gear Description

The rebate height shown for drive gear DFP431 (Gr1a) should be 680-1180.