TECHNOLOGY IN MOTION

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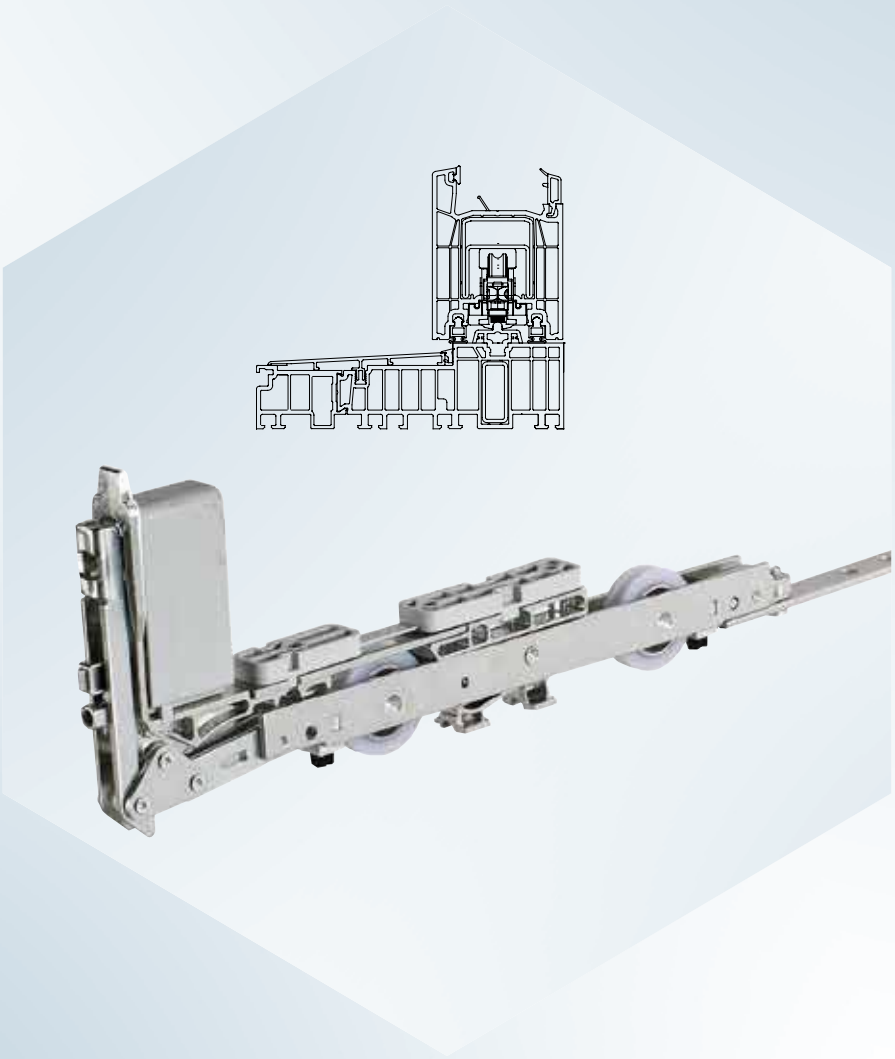
ASSEMBLY INSTRUCTIONS

HS-Hardware

HS Profine

PremiDoor 76 PVC



Use

exclusively for specialists!

Table of Contents

Key

 **HS** Lift & Slide part

 **FH** Sash Height

 **FB** Sash Width

 **RAB** Frame outer width

 **RAH** Frame outer height

L **L** Total length

 **GM** Handle height

 **DM** Backset drive

O Optional

{ } Dimensions for roller track flat

Dimensions in [mm]: All dimensions without a unit definition are given in mm

Important Information

- For MACO lift and slide hardware HS, the application ranges given on page 5 must not be exceeded. In addition, the Profine specifications apply to the lift and slide door hardware, in particular for possible restrictions on sash dimensions and sash weight. If special manufacturing regulations or processing guidelines exist, these must be observed. Information on screw-in speeds and torques must be observed.
- The hardware parts described in this guide are made of stainless steel or galvanically passivated steel and sealed in accordance with DIN EN 12329. They must not be used in environments with aggressive, corrosive air content.
- Assemble the complete hardware only from MACO hardware parts and the required Profine accessories. Otherwise, damage may occur for which we assume no liability.
- Mount all hardware parts professionally as described in this manual and observe all safety instructions.
- Use only the specified screw sizes.
- Turn the screws straight (unless otherwise stated) and not too tight, otherwise the smooth operation of the hardware may be impaired.
- Fix the screws of the supporting components (e.g. rollers, running rail and guide rail) in the reinforcement profile.
- Around the rollers, ensure a positive transfer of the compressive forces onto the reinforcement profile.
- The lift and slide elements may only be surface-treated before the hardware is installed. Any subsequent surface treatment may restrict the functionality of the hardware. In this case, no warranty claims can be made against the hardware manufacturer.
- With the spacer-block setting, observe the technical guideline No. 3 of the glazier trade „Blocking of glazing units“.
- Do not use acid-curing sealants, as these can lead to corrosion of the hardware parts.
- Keep the runner of the roller track, the threshold and all folds free of deposits and dirt, and in particular of cement or plaster residues. Avoid direct moisture on the hardware and contact of the hardware with acidic cleaning agents.
- Observe the „Guidelines and instructions for product and liability (VHBE)“
- Inform the end user about the contents of the „Guidelines and instructions for End Users (VHBE)“
- Attach the operating label in a clearly visible manner to the built-in lift and slide sash. The operating label can be found in the base carton.
- Do not make any constructive changes to the hardware parts.
- Overloading or improper operation of the lift and slide hardware may cause the sash to jump out of its guide, fall out and cause serious injury. If overloading of the lift and slide hardware is expected under special circumstances, such as in Schools, Kindergartens etc., this must be prevented using the appropriate measures e.g.:

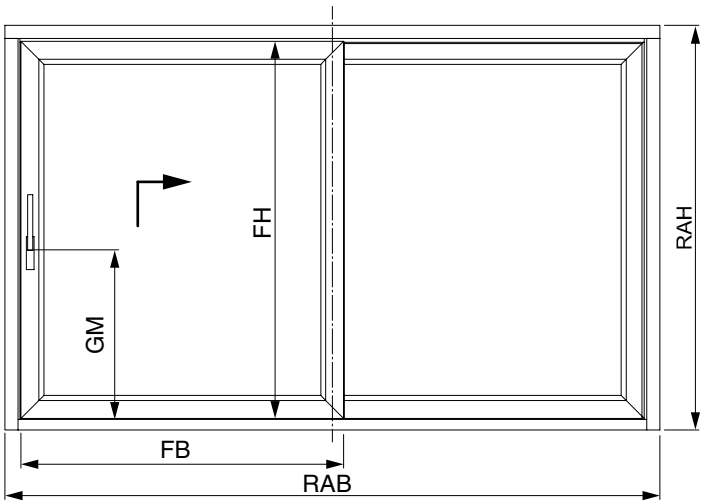
  – Adjustment of the buffer stop to reduce the opening width, or
  – Installation of a profile cylinder to prevent improper use.

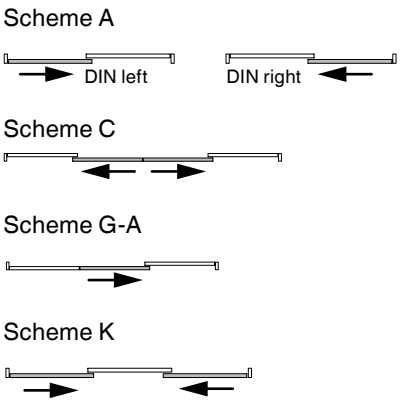
If you are not sure, please ask your MACO contact person for advice.

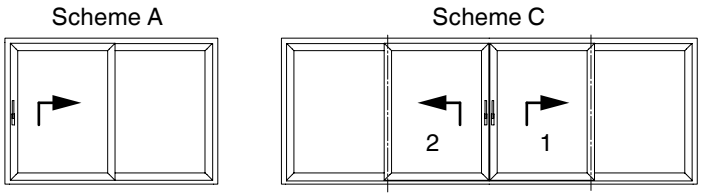
Disclaimer

We are not liable for malfunctions and damage to the hardware, as well as the lift and slide elements caused by inadequate tendering, failure to follow these instructions or extreme force on the hardware (e.g. due to improper use).

Version and Application Areas







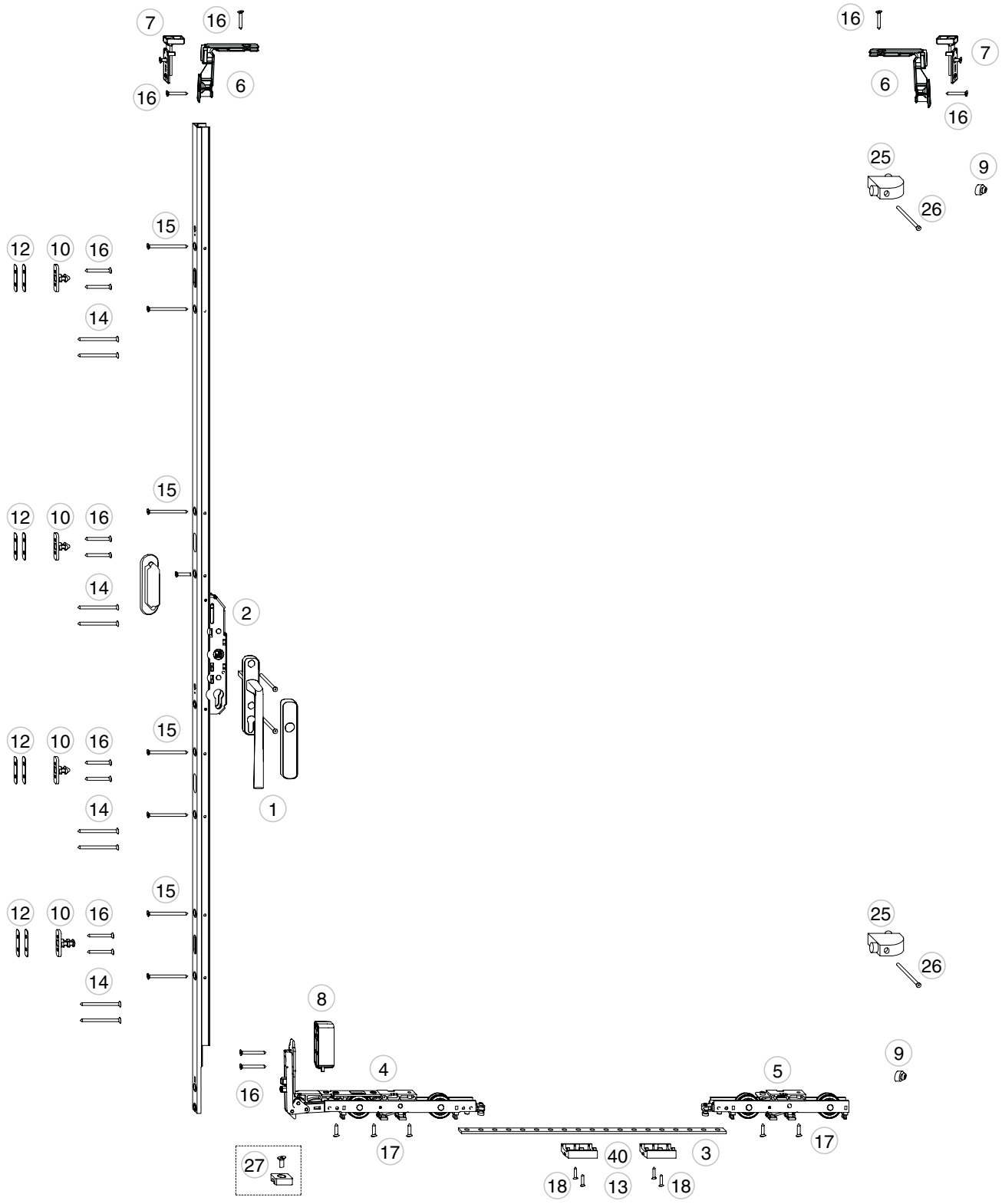
Application Areas

For MACO HS 300 the application areas as per the following table apply.
For the handling of the profile, the maximum areas of application and maximum weights apply, as per the specifications of the profile manufacturer and these must be adhered to.

Item	Unit	Area	
		Roller track high	Roller track flat
FB	(mm)	700 - 3280	
FH	(mm)	815 - 2920	807 - 2912
Sash weight sliding sash	(kg)	max. 400*	
DM	(mm)	37,5	
GM drive Size 1 - 2	(mm)	408	400
GM drive Size 3 - 4	(mm)	1008	1000

*From a sash weight of over 200kg, we recommend installing a drive damper.
(The drive damper can be ordered via the Technical Online Catalogue (TOM) or via the Catalogue.)

Hardware Composition

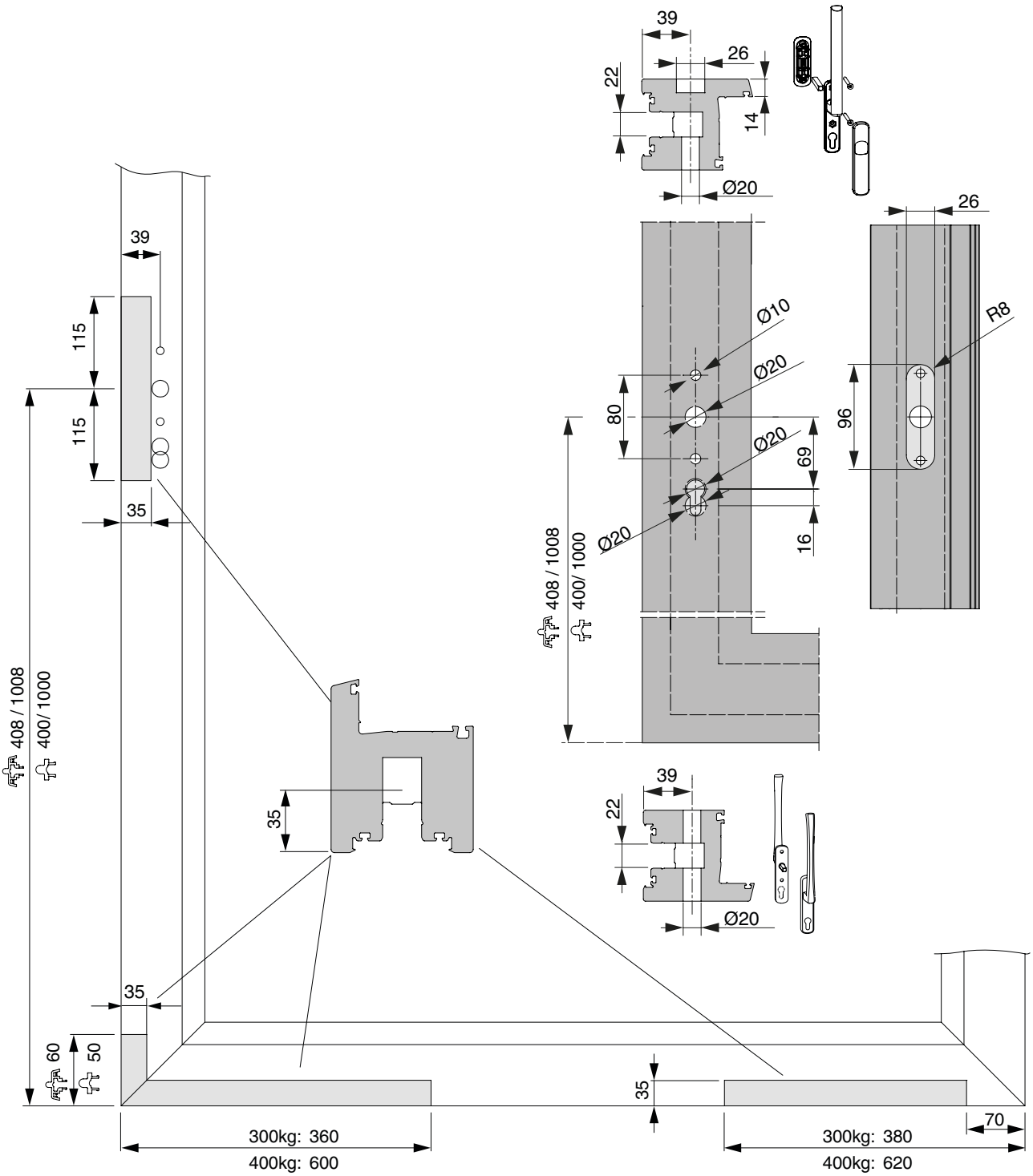


Hardware Composition

Pos.	Item Name
1	HS Handle Set
2	Lift drive locks DM 37.5 PZ
3	Connecting rod with holes HS 16.4 x 4
4	Front roller HS with brush 300 kg silver
5	Rear roller HS with brush 300 kg silver
6	Basic profile for slider 10 x 22 mm gap silver
7	HS-KU Slide shoe 16.4 mm with cap
8	Packer for HS-KU roller 26.5 mm height Silver drive-side
9	Rubber buffer HS silver
10	Lock
12	Packer for. HS-KU locking bolts Thickness = 0.5 + 1 mm silver
13	Rod guide
14	Countersunk self-tapping screw B 4.8 x 80
15	Countersunk self-tapping screw B 4.8 x 65
16	Countersunk self-tapping screw B 4.8 x 45
17	Countersunk self-tapping screw B 4.8 x 22
18	Countersunk self-tapping screw 3.5 x 32
25	Shim buffer stop 28 mm gap
26	Countersunk self-tapping screw B 4.8 x 80
27	HS locking block 300/400 kg

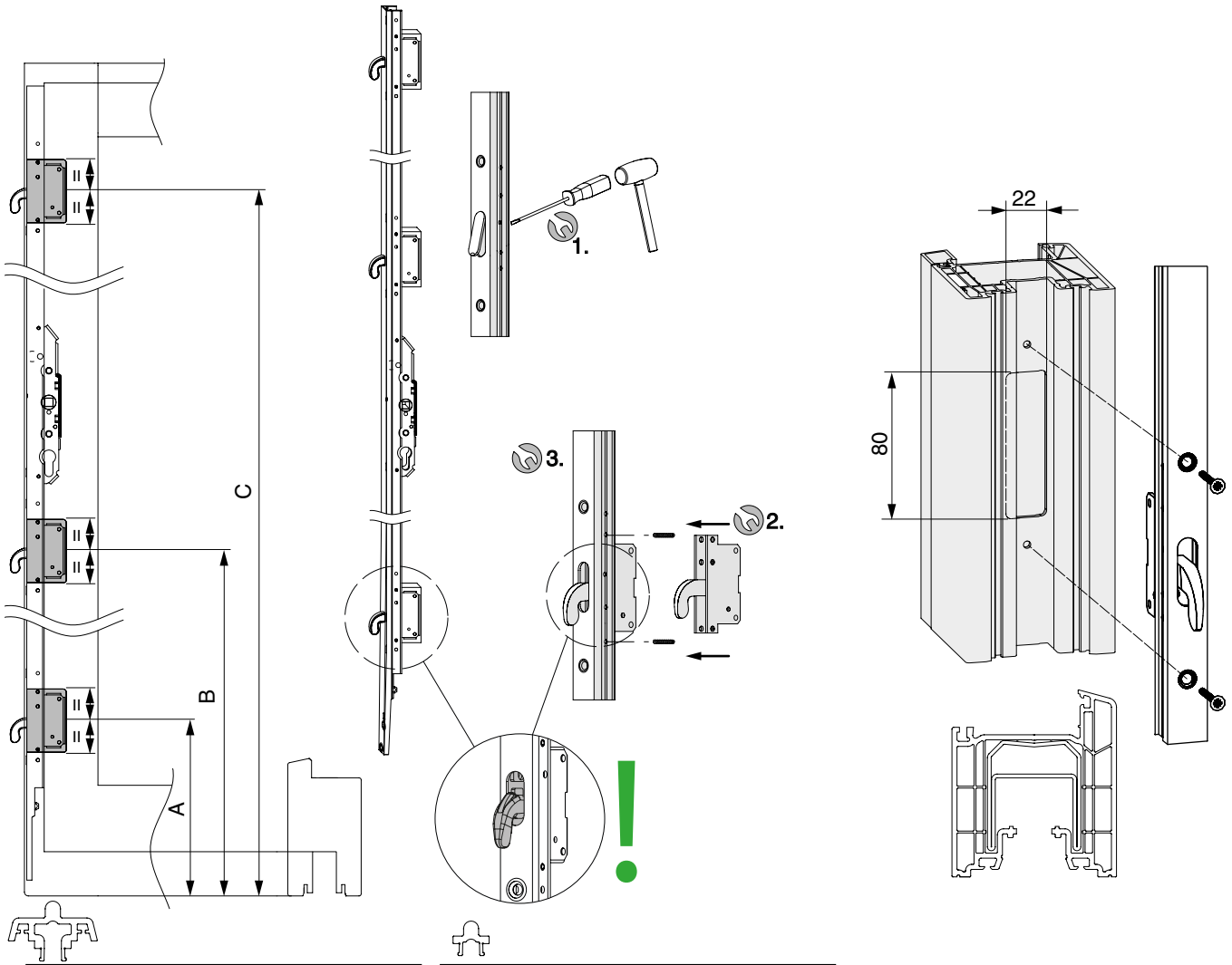
Assembly on the sash

Drilling and milling on the sash



Assembly on the sash

Drilling and milling for hook drive

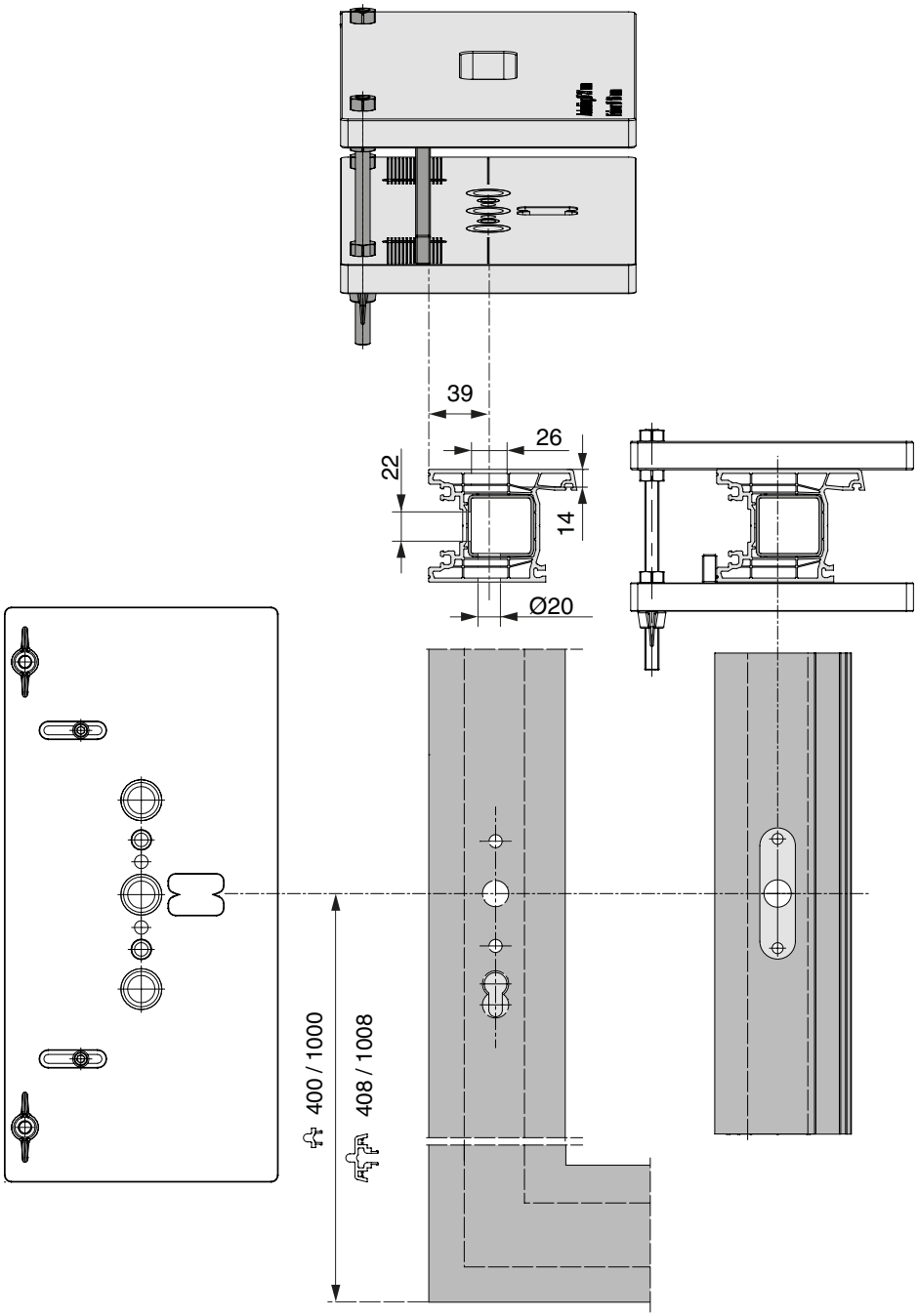


	A	B	C
Size 1	219	589	-
Size 2-3	219	1089	-
Size 4	219	807	1687
Size 5	219	1219	2119

	A	B	C
Size 1	211	581	-
Size 2-3	211	1081	-
Size 4	211	799	1679
Size 5	211	1211	2111

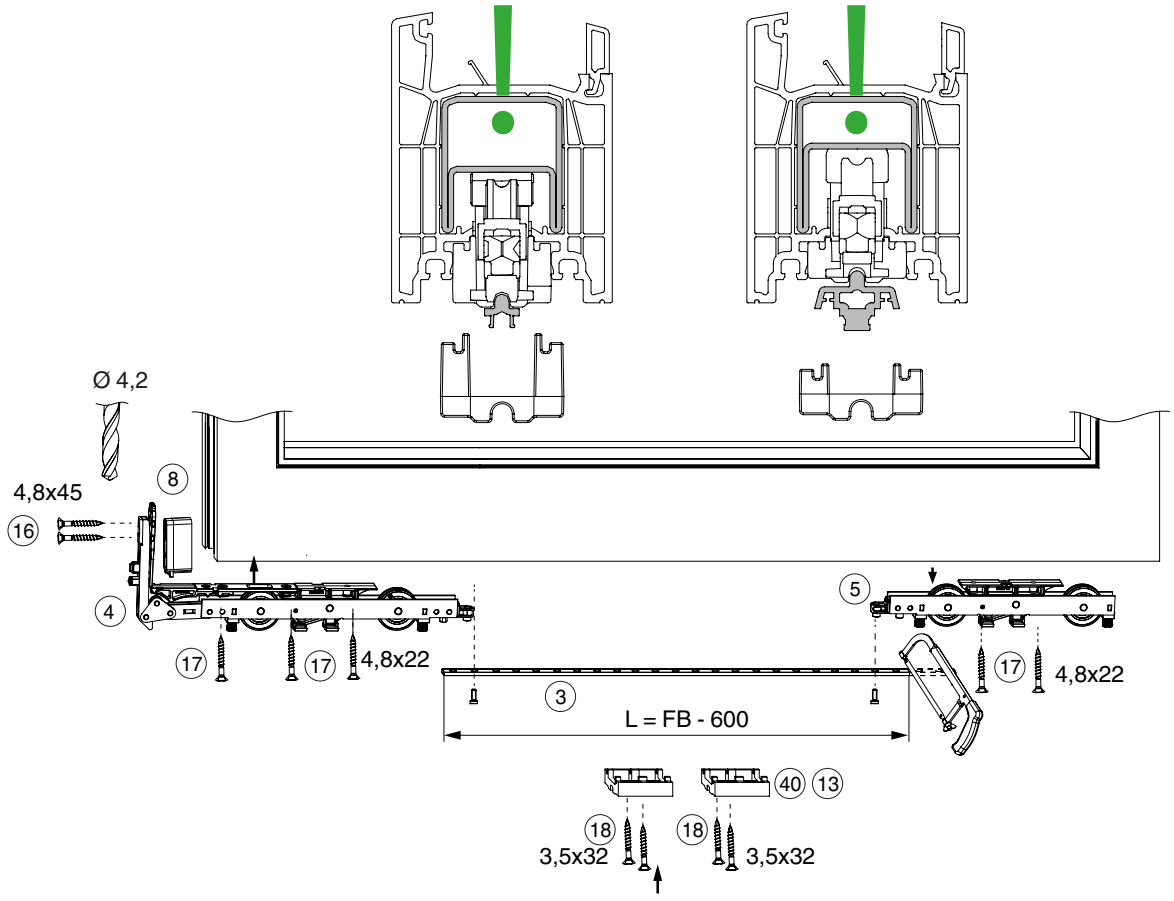
Assembly on the sash

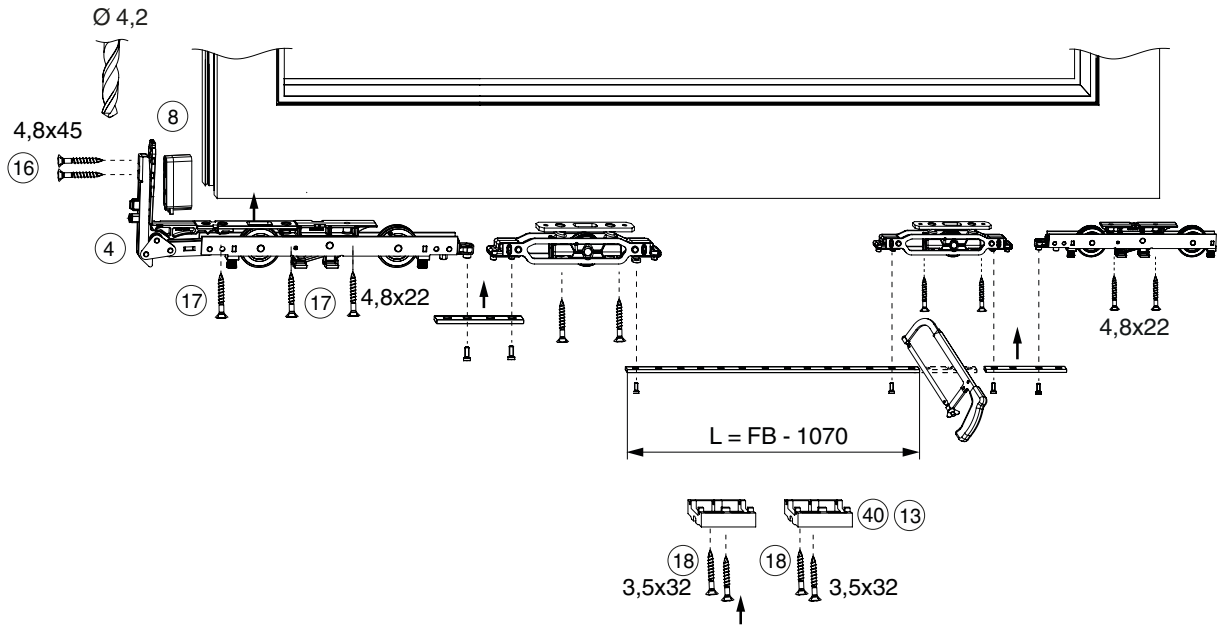
Drill and milling jig for HS handle



Assembly on the sash

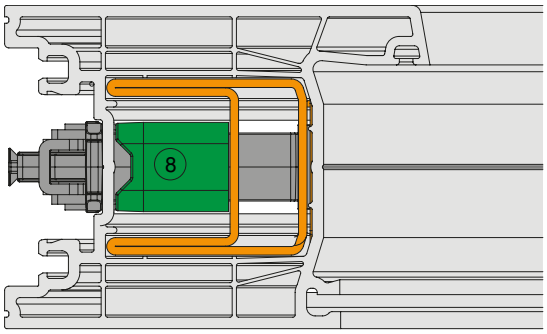
Roller assembly

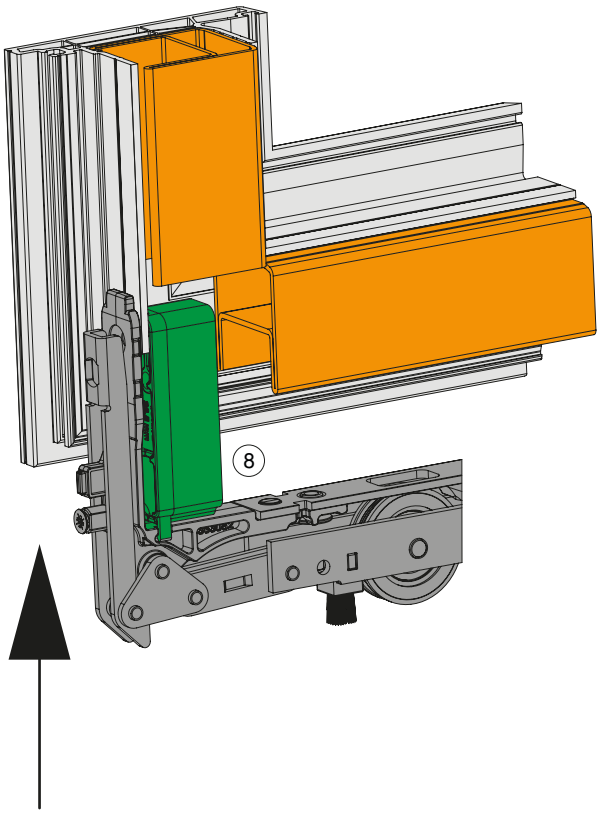




Assembly on the sash

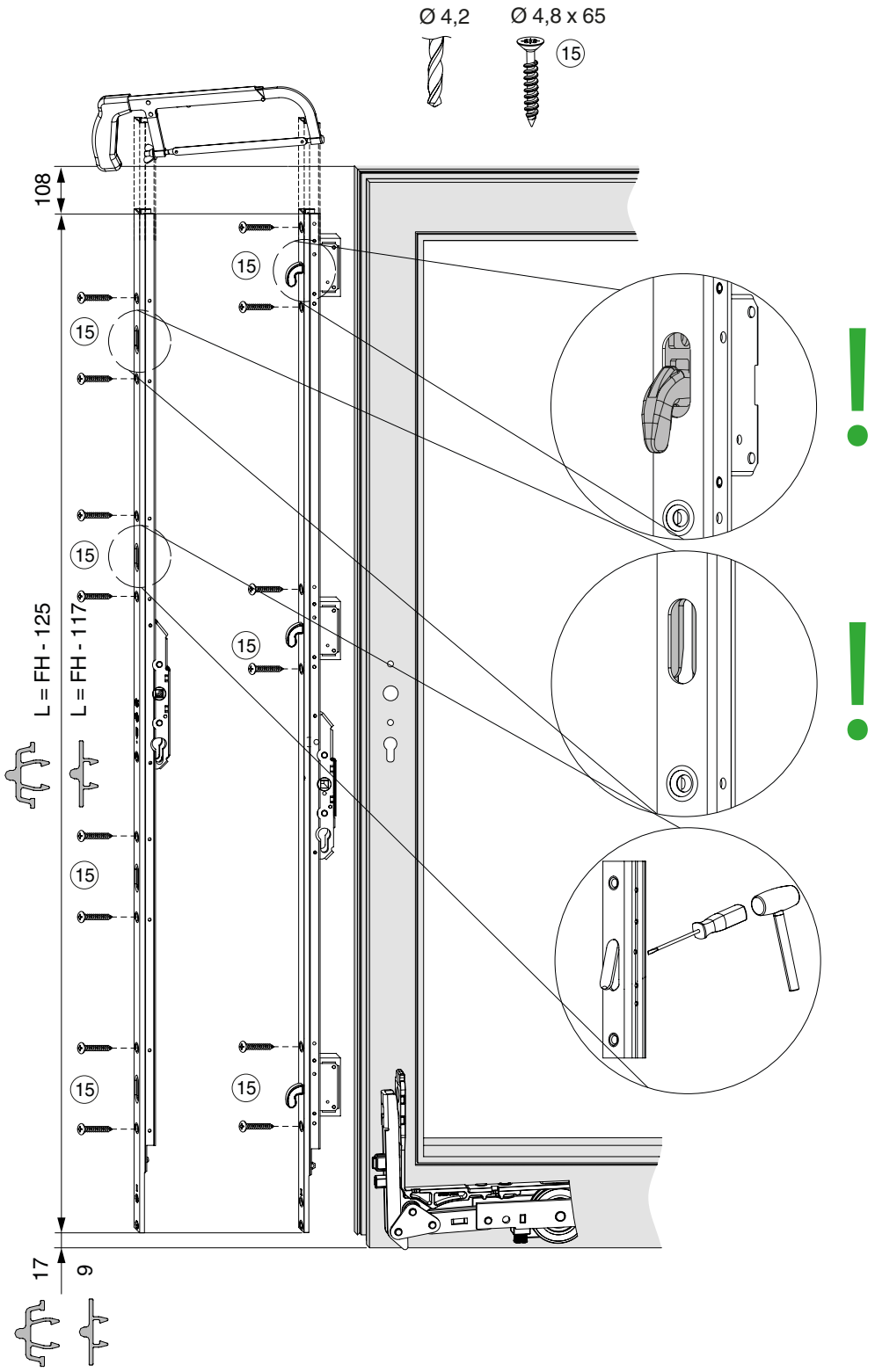
Packer assembly





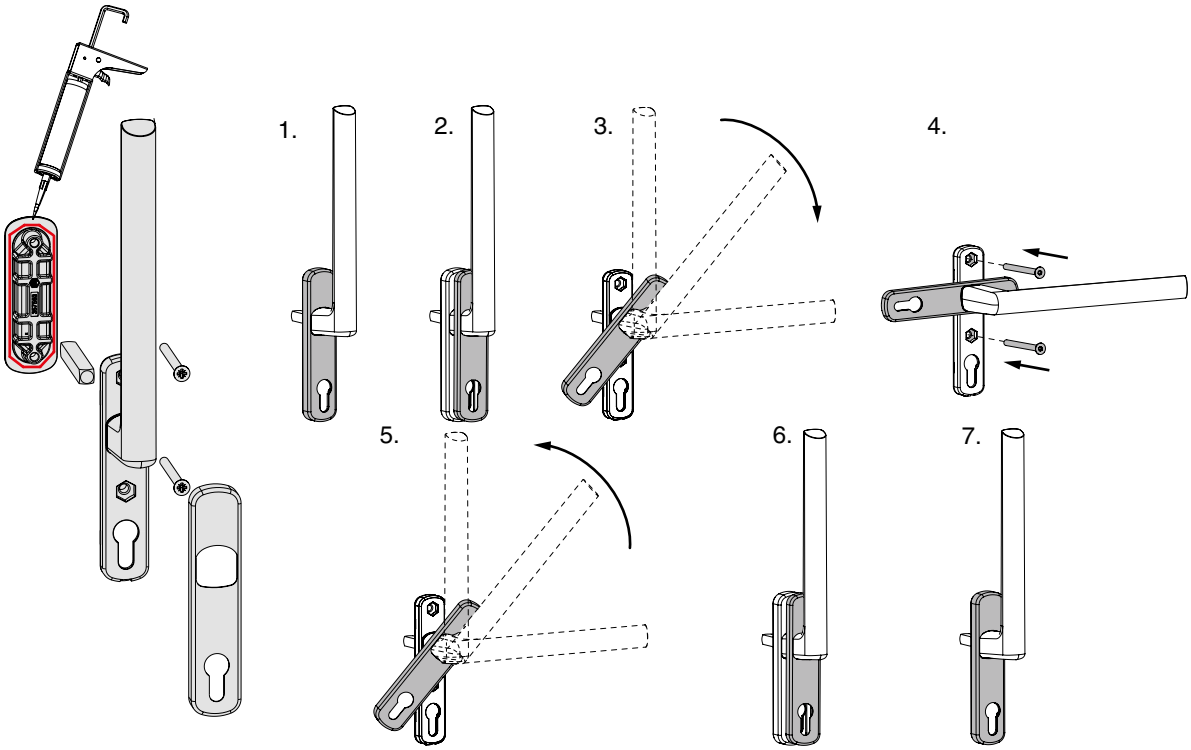
Assembly on the sash

Drive assembly



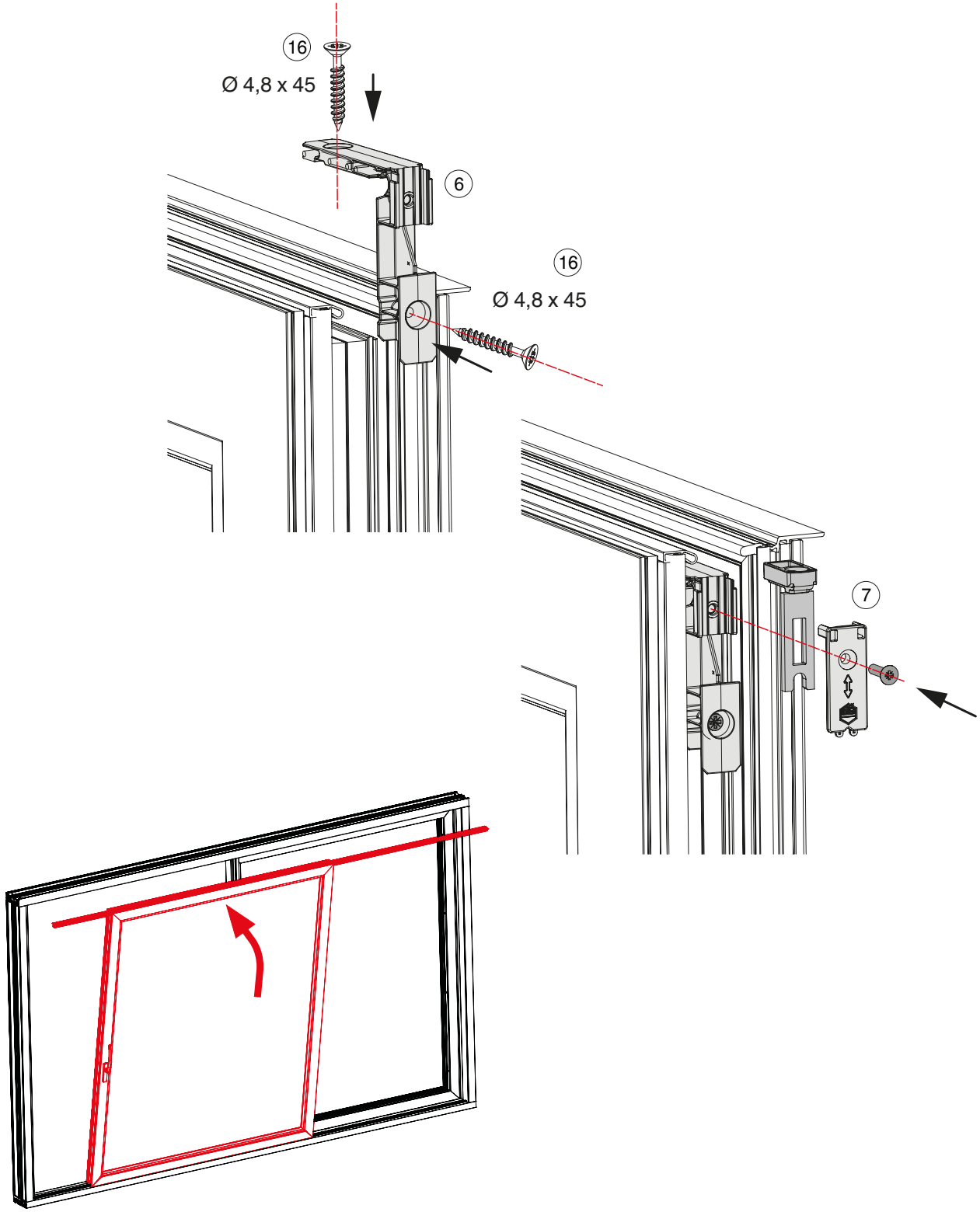
Assembly on the sash

Handle assembly



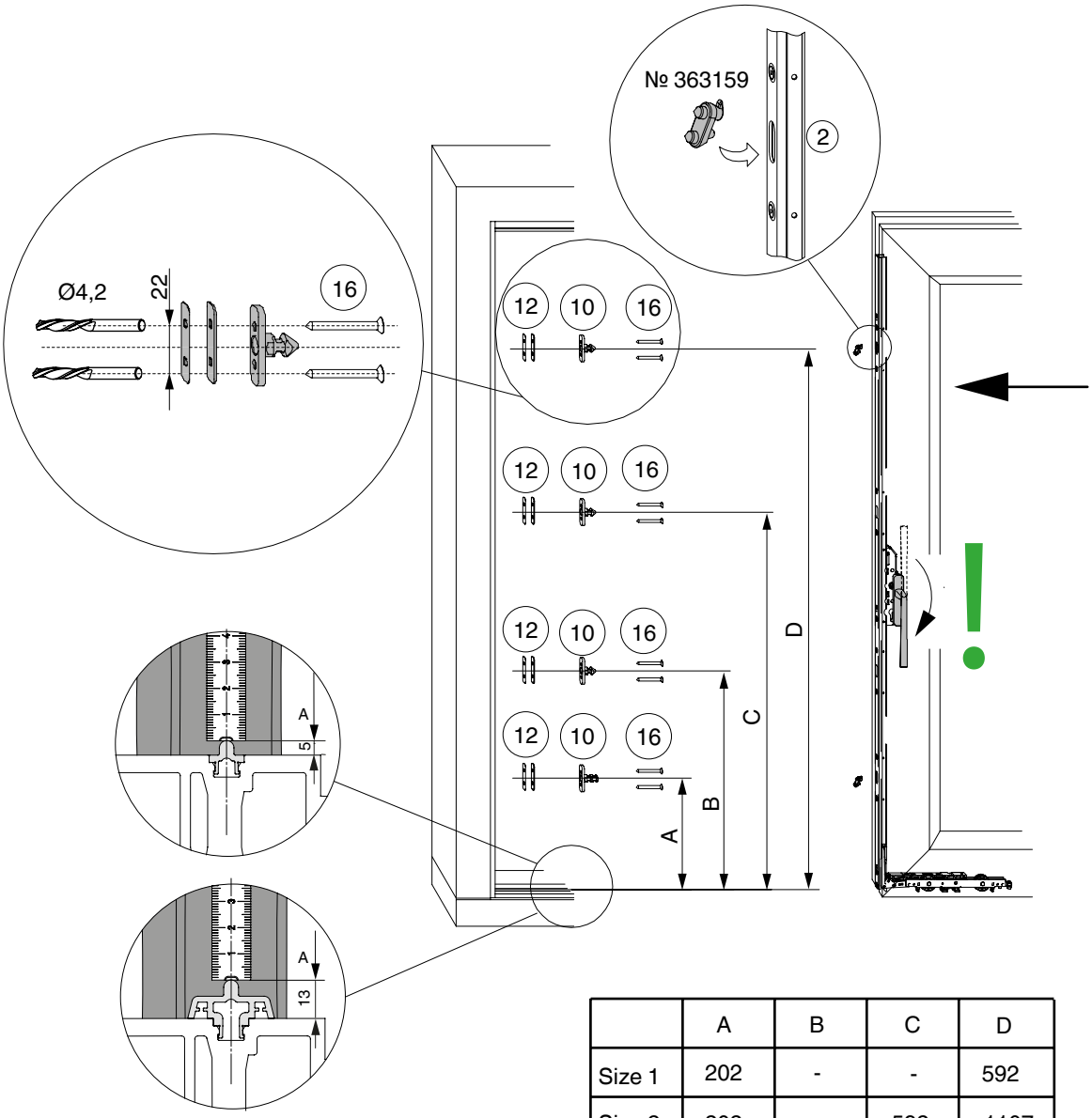
Assembly on the sash

Slider assembly



Assembly on the sash and frame

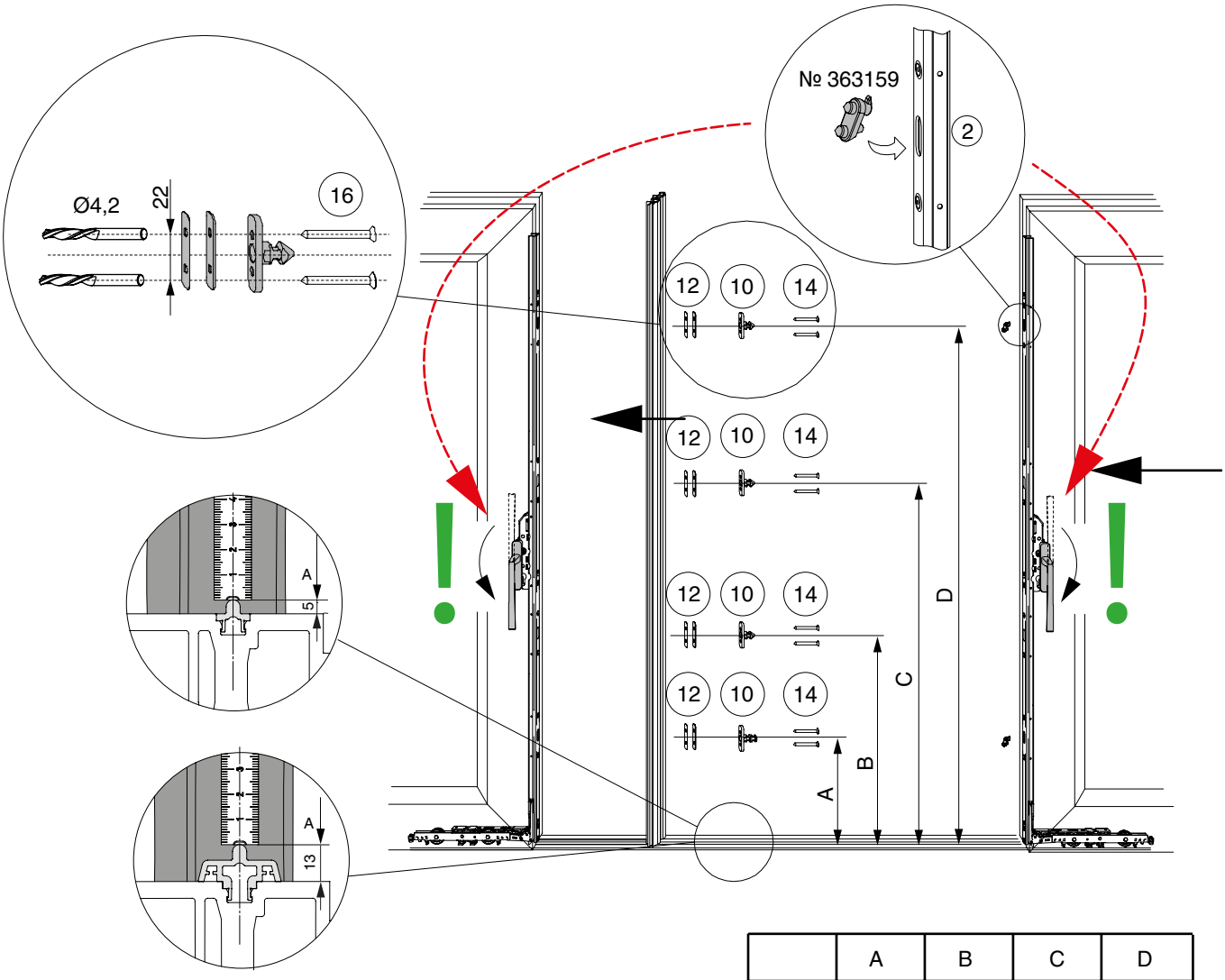
Locking bolt Scheme A



	A	B	C	D
Size 1	202	-	-	592
Size 2	202	-	592	1107
Size 3	202	702	1192	1507
Size 3.5	202	702	1192	1707
Size 4	202	702	1192	1907
Size 5	202	702	1192	2307

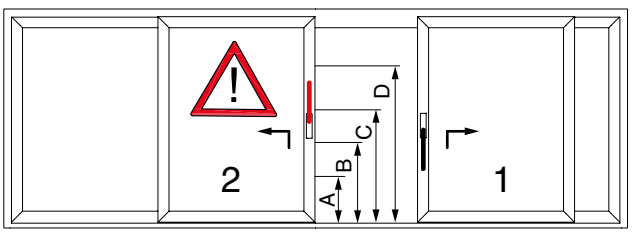
Assembly on the sash and frame

Locking bolt Scheme C



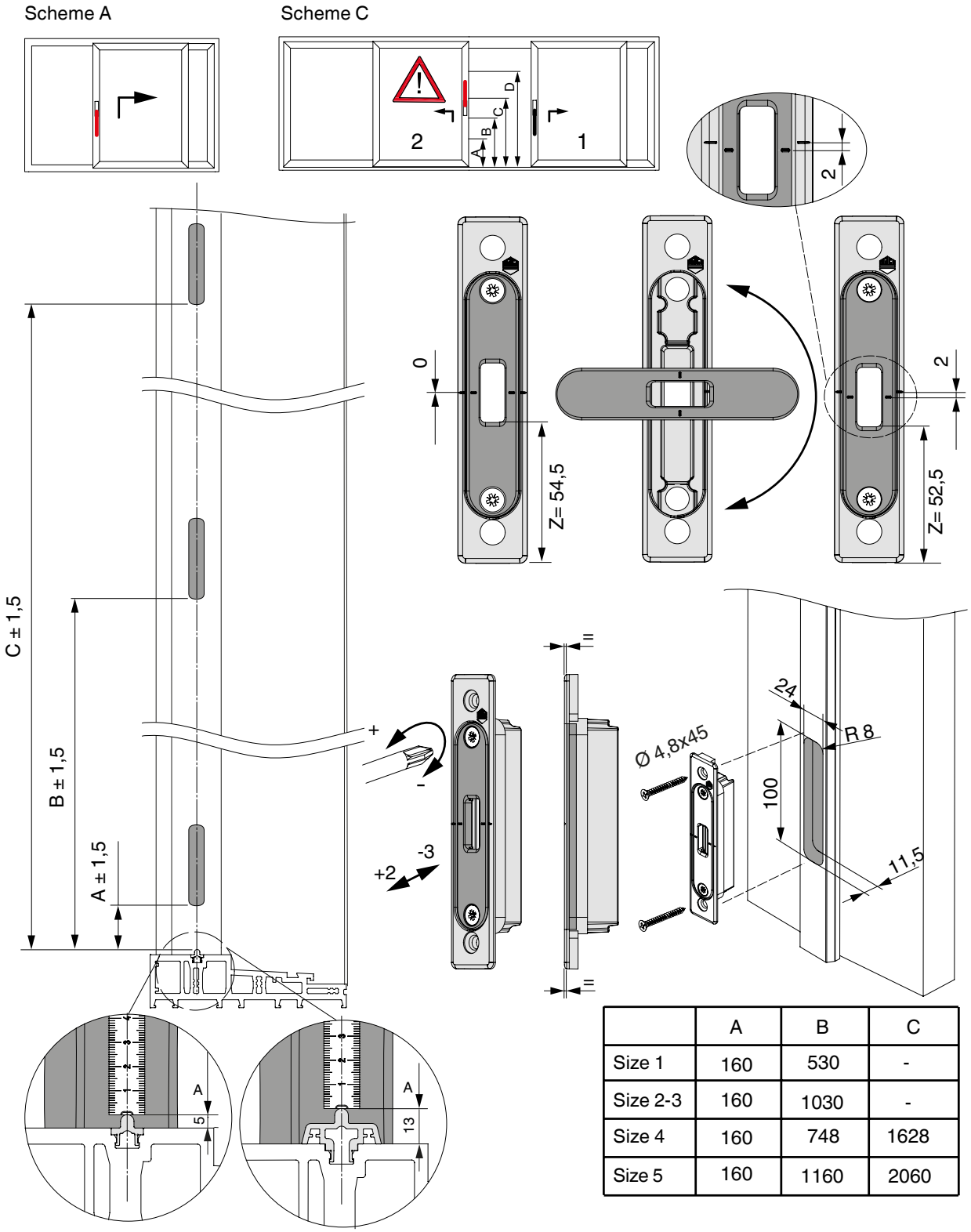
	A	B	C	D
Size 1	202	-	-	592
Size 2	202	-	592	1107
Size 3	202	702	1192	1507
Size 3.5	202	702	1192	1707
Size 4	202	702	1192	1907
Size 5	202	702	1192	2307

Scheme C



Assembly on the sash and frame

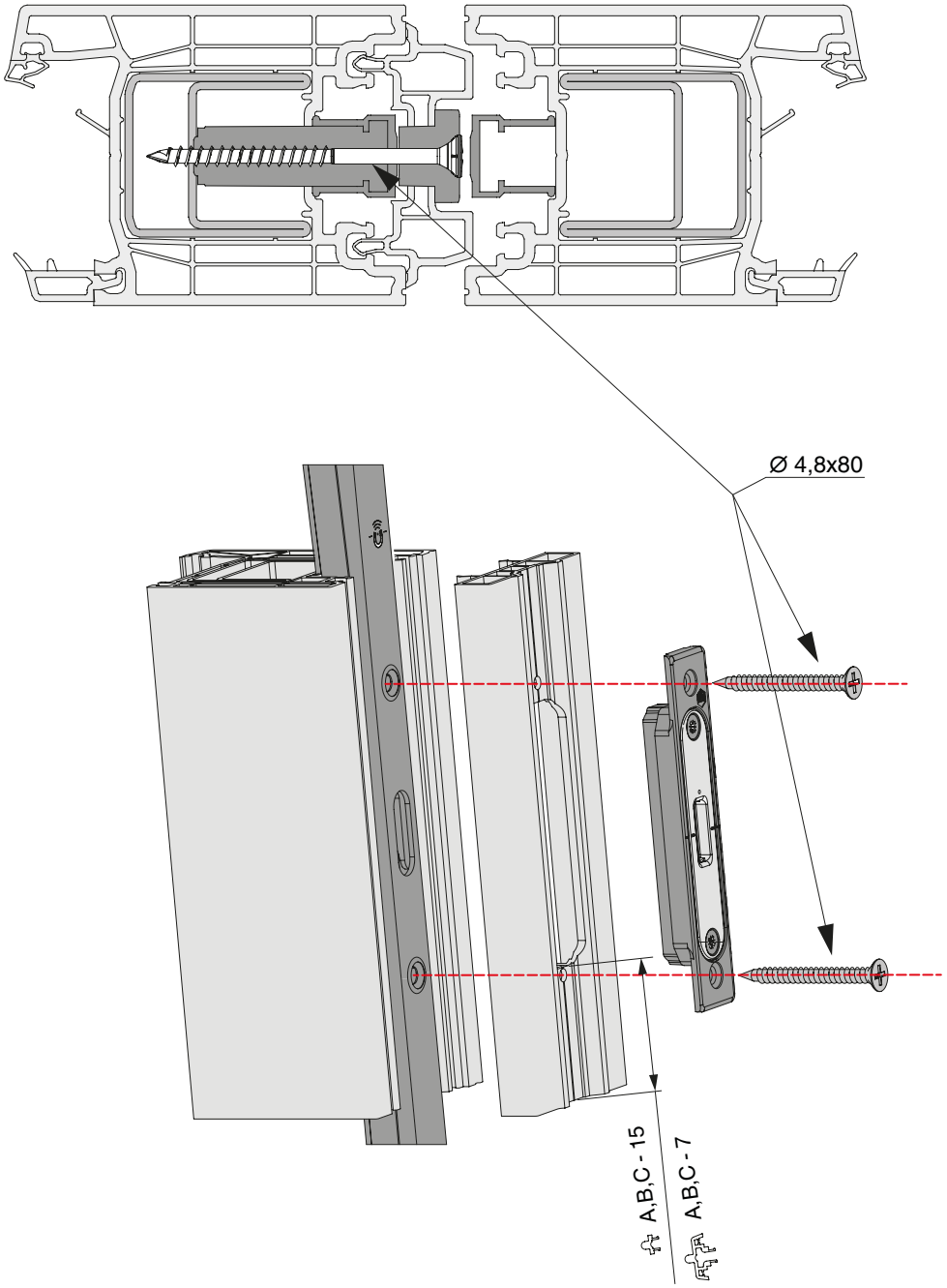
Hook striker plate



	A	B	C
Size 1	160	530	-
Size 2-3	160	1030	-
Size 4	160	748	1628
Size 5	160	1160	2060

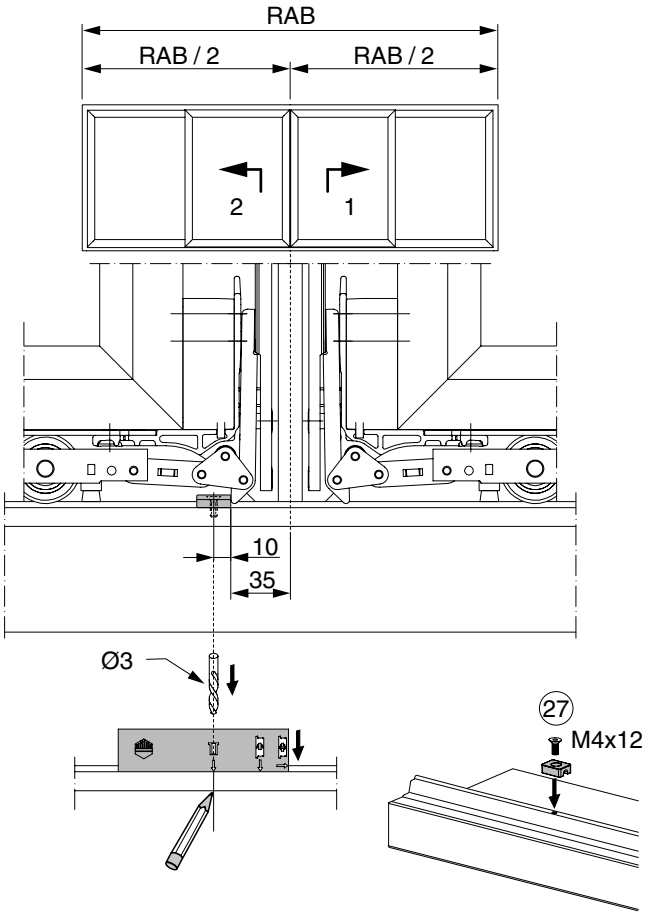
Assembly on the sash and frame

Striker plate for hook Scheme C, G-A



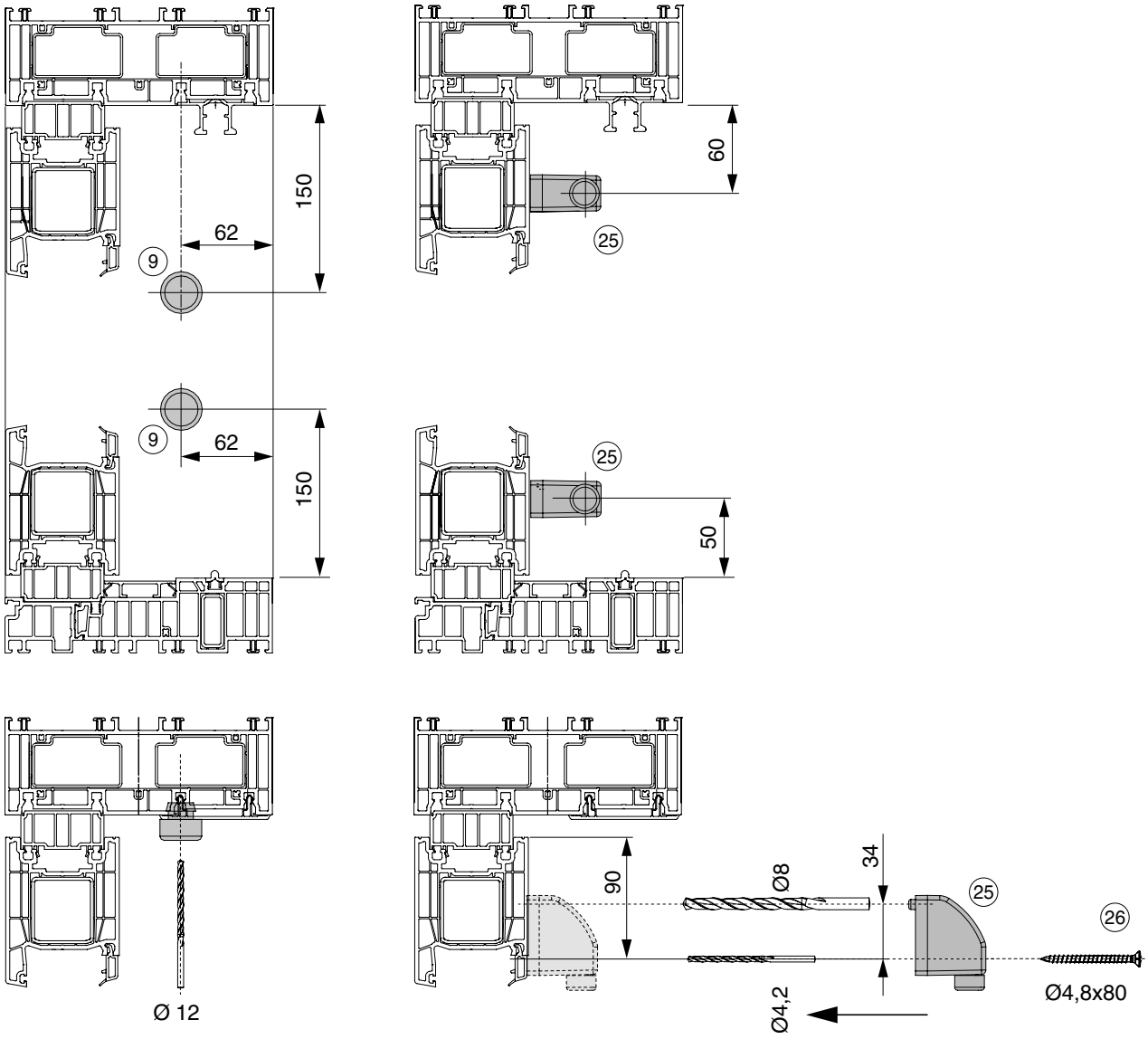
Assembly on the sash and frame

Locking block Scheme C

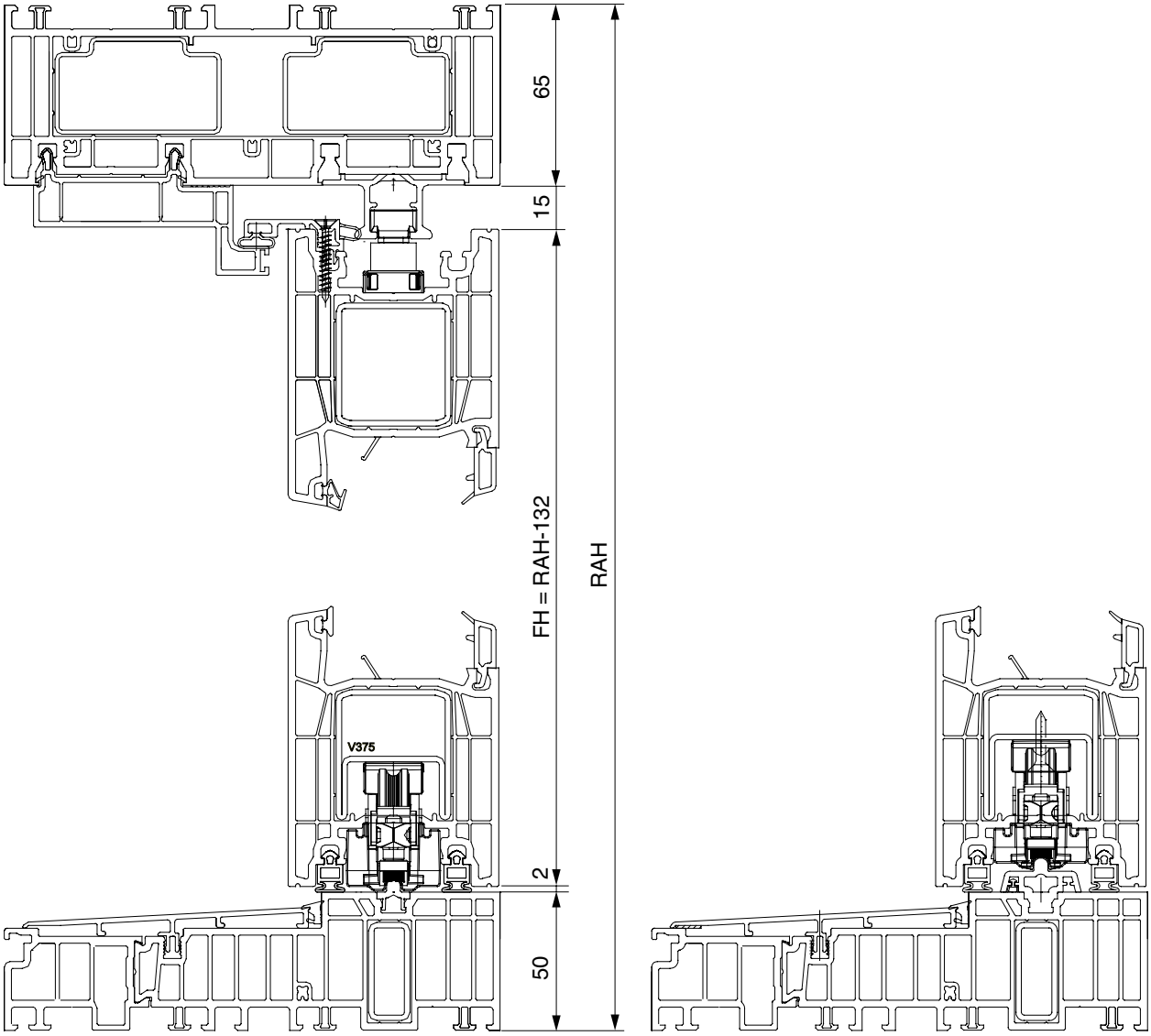


Assembly on the sash and frame

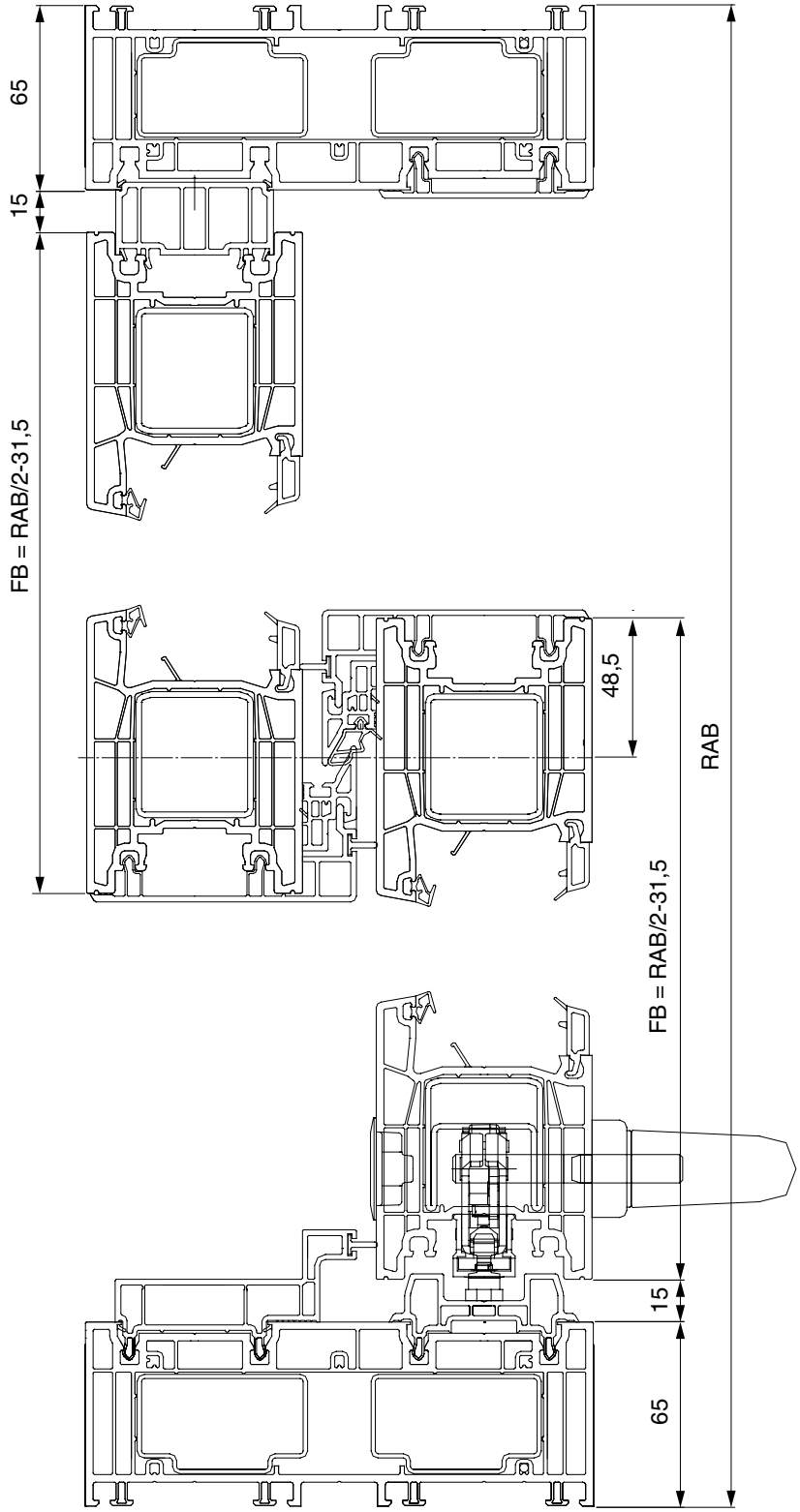
Buffer stop



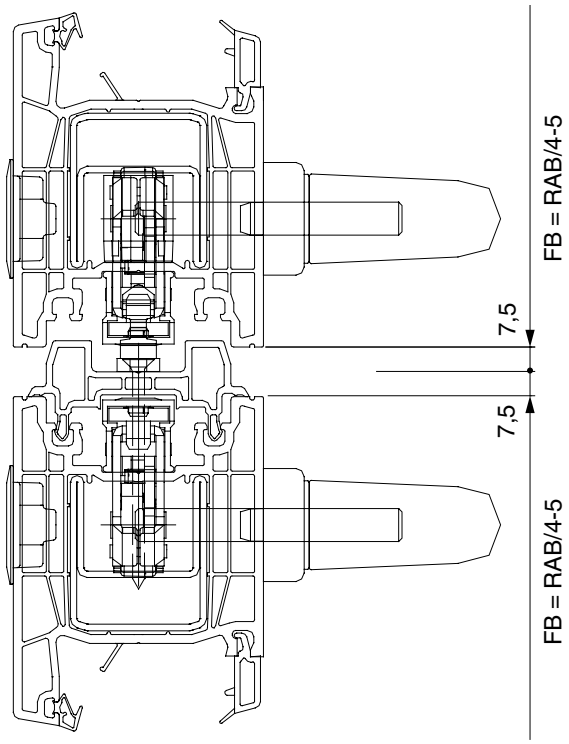
Vertical section 76 sliding sash



Horizontal section 76 Scheme A



Horizontal section 76 Scheme C



Notes

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RAIL-SYSTEMS

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