

**SPW600e**

**SPW600e Door**

**Product Assembly  
Manual 2012  
Door**



## Scope

*This specification covers the materials, sections and accessories generally available from stock through the Senior Architectural Systems group of companies. It illustrates typical recommendations for the fabrication of our SPW600e Door system. The sections and fittings described in this manual are not definitive or exclusive in application but show typical assemblies using standard materials and accessories.*

*Identical main line extrusions are used for both single and dual colour finishes.*

*These details are suitable for installations in both new buildings and re-furbishments.*

## Construction

*SPW600e Doors are constructed using mitred and mechanically crimped corners, with support chevrons and cleats. Integral transoms and mullions are installed by scribing the ends and then either screw fixing or bracket fixing into the outer frames.*

*A proprietary sealant to protect against water entry should be used on all metal-to-metal joints and cleat insertion points at assembly.*

*Opening door frames are designed to be inserted directly into the outer frames using face mounted hinges and hook locks.*

*Glazing is double glazing 28mm standard, although other options are available.*

*At all times good working practices should be employed.*

## Accessories

*All accessories shown in this manual are deemed to be both typical, and suitable for, the installations intended. They are generally standard items which carry with them the manufacturers guarantees and are components which are held in stock.*

*Handing is referred to the position of the lock stile as the door opens towards you.*

## Testing

*The SPW600e Doors are tested in accordance with BS6375 Part 1, 2004.*

Air Permeability	600Pa (class C)
Water Tightness	50Pa
Wind Resistance	1200Pa

*Separate figures are available for Thermal U-values depending on type of frame and glazing material.*

*SPW600 Doors have been security tested in accordance with PAS-23/24.*

## Materials

*Extruded aluminium is Aluminium Alloy 6063.T6 to BS EN 755 part9: 2008.*

*Polyamide thermal barriers PA66 GF25.*

*Anodising: i) Natural (Silver) anodised to BS3987, 1991. and ii) Anolok Bronze Colour 547 anodised to BS3987, 1991. Anodising is to a minimum of 25 microns (AA25).*

*Powder Coating is to BS EN 12206-1:2004..*

*Gasketry is manufactured in accordance with BS3734.*

## Glazing

*Note: All Glazing should be carried out to the recommendations of BS6262.*

*Internal Double Glazing to 28mm may be installed as standard into this door system. Other options available.*

*Each pane of glass is individually inserted into a fully rebated and prepared opening.*

*Glass is retained in position with beads. Captive gaskets are inserted into the frame rebates, wedge gaskets are to the inside of the glass to assist with security.*

## Site Installation

*Site fixing of finished frames should take into account all applicable standards with regard to both the method employed and safe working practices.*

*Frame fixings should be suitable for the purpose given site conditions and materials into which the installation is to be made. If in doubt, please check with your fixings supplier regarding type and method to be used.*

## Size Limitations

*Size limitations for each type of window varies. The following schedule is an indication of the SPW600 system capabilities.*

	W	x	H
Single Door	1000	x	2400 O/Frame
Double Door	2000	x	2400 O/Frame

Sash Rebate Sizes For 2400mm O/Frame =	
Fully Rebated (SPW64740)	2286mm
Low Threshold (SPW66170)	2318mm

*Use SBE19 Shoot Bolt Extension When Sash Rebate is over and above 2230mm.*

Min. Sash Height	1940mm
Max. Weight Per Door Leaf	75Kgs

*Please refer to limitations data within the manual and supplementary documents.*

**Multi-lights:** *all mullions and transoms over 1200mm high or wide should be checked for lxx value stability to loadings provided by the specifier, or to BS6399 part 2:1997*  
*The above schedule is based on nominal test results and assumes that adequate care regarding the location and exposure of the window is taken by the fabricator.*  
*Due regard should be given to the maximum recommended sizes, as published by the hardware manufacturers.*

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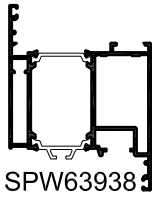
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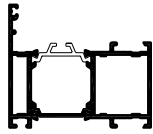
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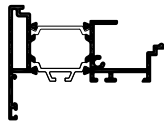
### Open In



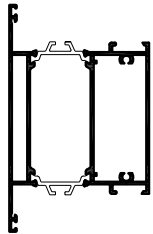
SPW63938  
Door Sash - Inward Opening



SPW64740  
Door Frame - Inward Opening

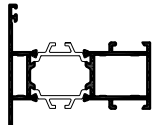


SPW633370  
Double Door Adaptor  
Inward Opening

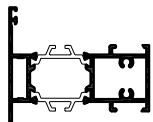


SPW65455  
Door Midrail - Inward Opening

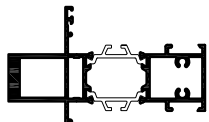
### Transom/Mullions



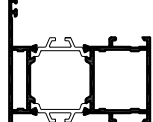
SPW61813  
Transom/Mullion



SPW61817  
Transom/Mullion Screwport

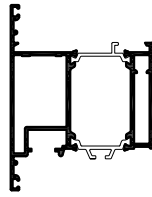


SPW600417  
Reinforced  
Transom/Mullion Screwport

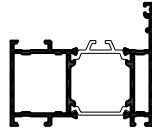


SPW61940  
Transom/Mullion Heavy Duty

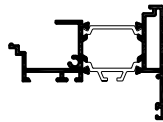
### Open Out



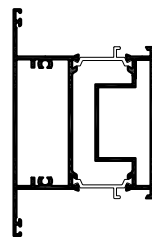
SPW66867  
Door Sash - Outward Opening



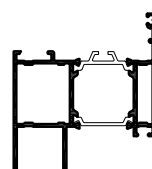
SPW64047  
Door Frame - Outward Opening



SPW370633  
Double Door Adaptor  
Outward Opening



SPW68182  
Door Midrail - Outward Opening



SPW68047  
Door Frame O/Out 28mm C/W

### Thresholds



SPW66170  
Low Threshold  
Open In



SPW67061  
Low Threshold  
Open Out



SPW684  
Commercial Threshold



SPW663  
Low Threshold Ramp

### Ancillaries



SPW657  
Corner Cleat



SW446  
Corner Cleat



SAE25X4  
Georgian Bar



SPW664  
Door Sealed Drip Bar



SXTW216  
Drip Section



SD557  
Brush Seal Carrier



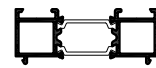
SRA 011  
PVC Cover Strip



SPW683  
Bottom Door Adaptor

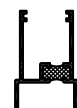


SPW695  
28mm Curtain Wall Glazing Spacer



SPW65353  
25mm Add-On

### Trickle Vents

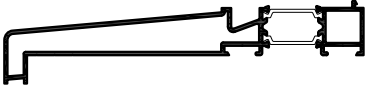


SXTW204T  
28mm Vent Carrier

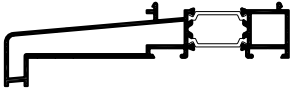
# SPW600e Door

## Section Identification

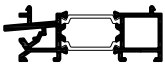
### Cills, Couplers & Beads



SPW499653  
190mm Cill



SPW65653  
150mm Cill



SPW68553  
Drainage Cill



SPW34827  
SPW600e To SPW300 Coupling



SPW65994  
T Coupling Section



SPW69494  
H Coupling Section



SPW65959  
Coupling Section



SPW629358  
Reinforced Coupling Section

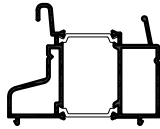


SPW643  
28mm Int. Glazed Bead

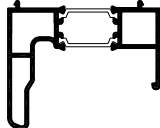


SPW624  
32mm Int. Glazed Bead

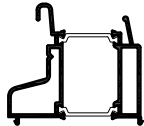
### Kingspan Adaptors



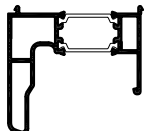
SPW67173  
Kingspan  
80mm Head Adaptor



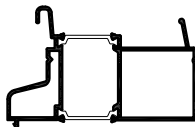
SPW67476  
Kingspan  
80mm Cill Adaptor



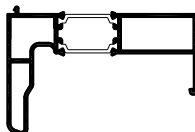
SPW67172  
Kingspan  
70mm Head Adaptor



SPW67475  
Kingspan  
70mm Cill Adaptor



SPW671382  
Kingspan  
100mm Head Adaptor

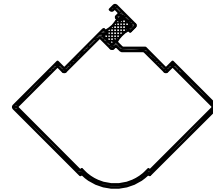


SPW674381  
Kingspan  
100mm Cill Adaptor

# SPW600e.4.ix

04.12

### Ancillaries



STC7357  
Corner Post



## Manual Update

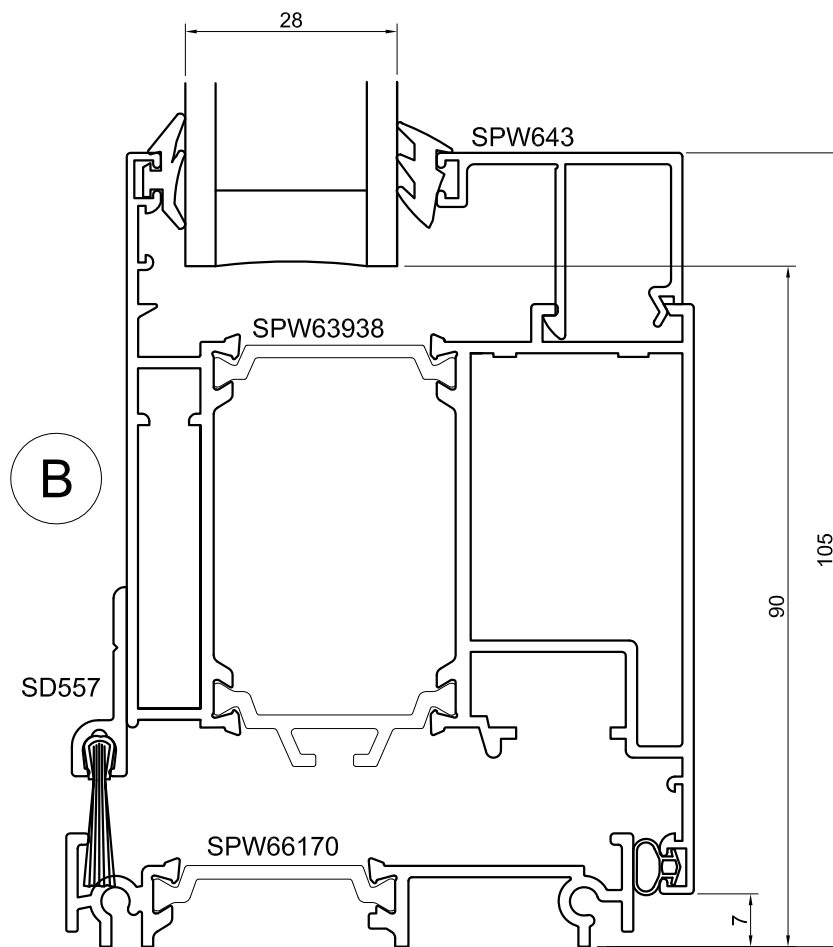
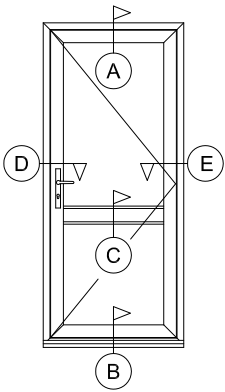
Page No	Update Description	Date

SPW600e.A.4101

04.12

# SPW600e Door

Vertical Cross Section - Threshold Open In



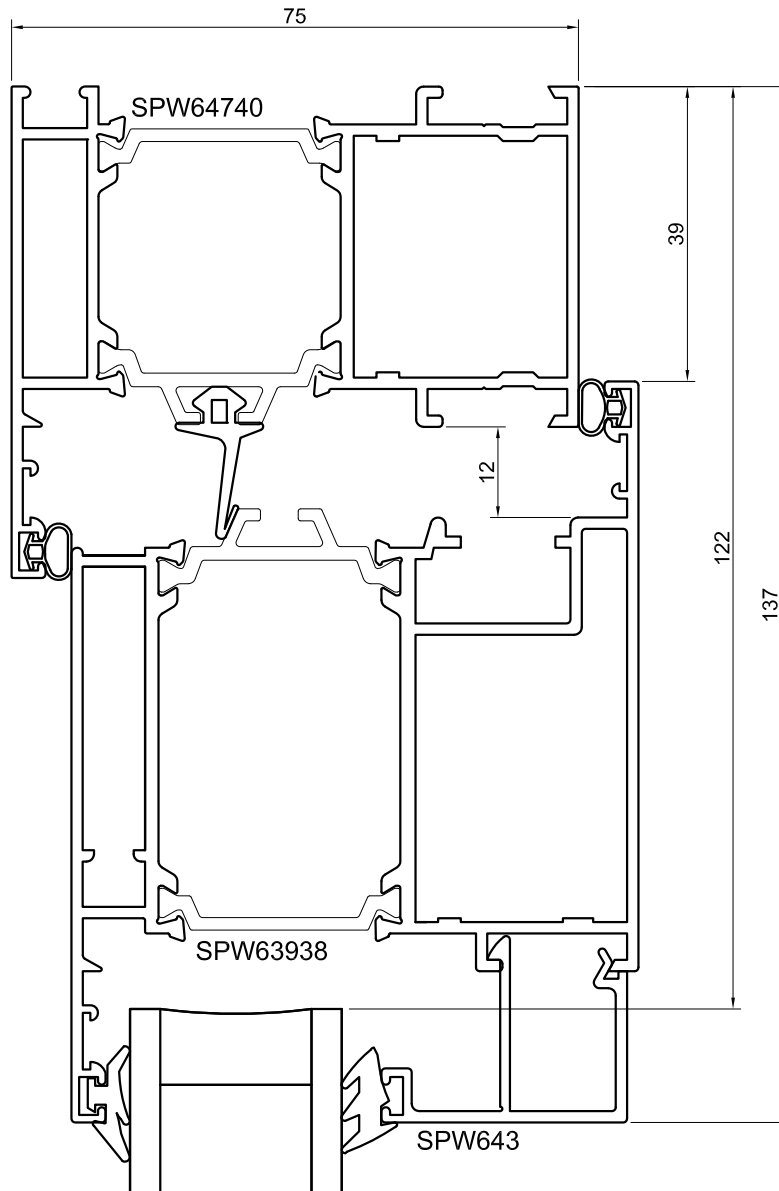
# SPW600e Door

SPW600e.A.4102

Vertical Cross Section - Head Open In

04.12

A

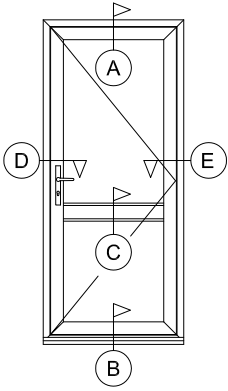


SPW600e.A.4103

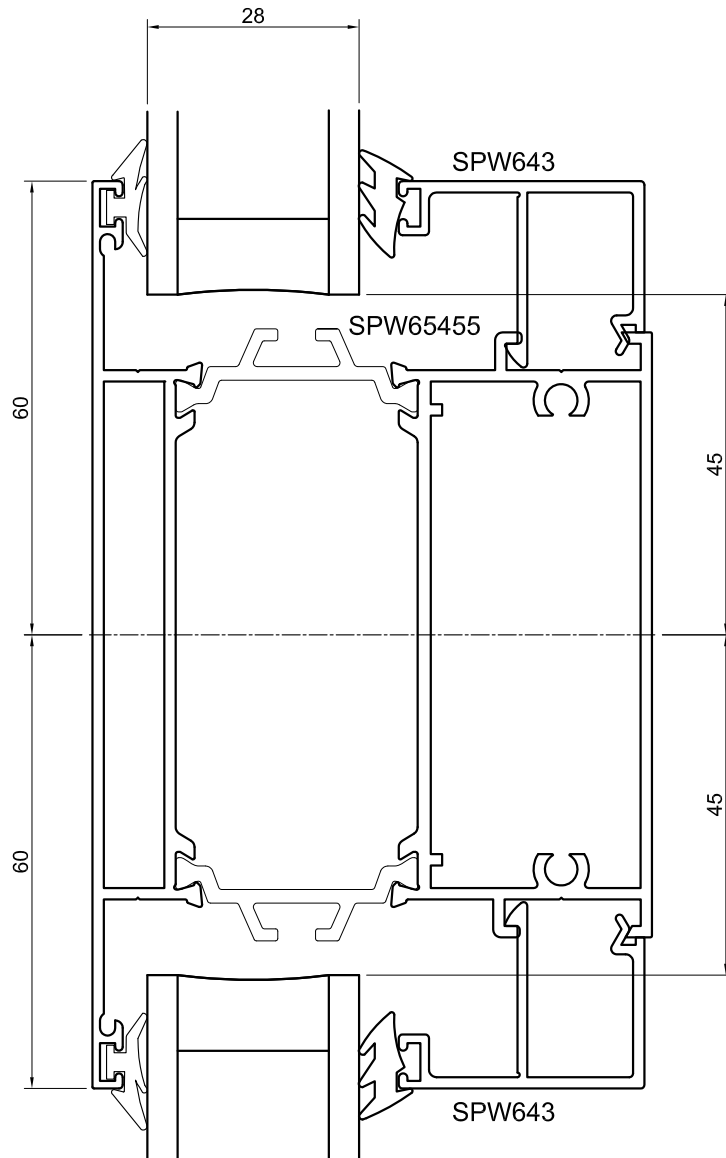
04.12

# SPW600e Door

Vertical Cross Section - Midrail Open In



C

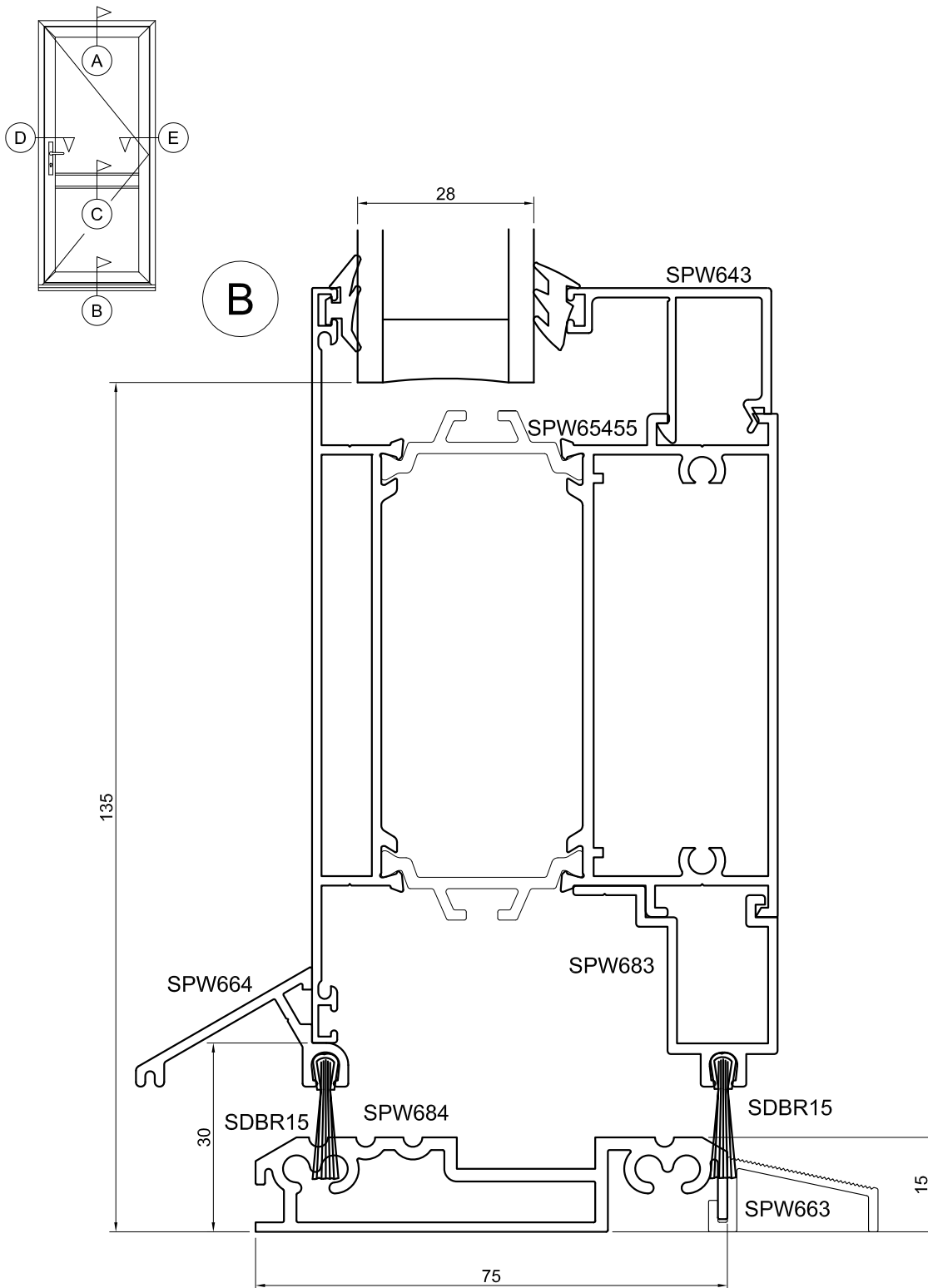


# SPW600e Door

SPW600e.A.4104

Vertical Cross Section - Threshold Open In

04.12

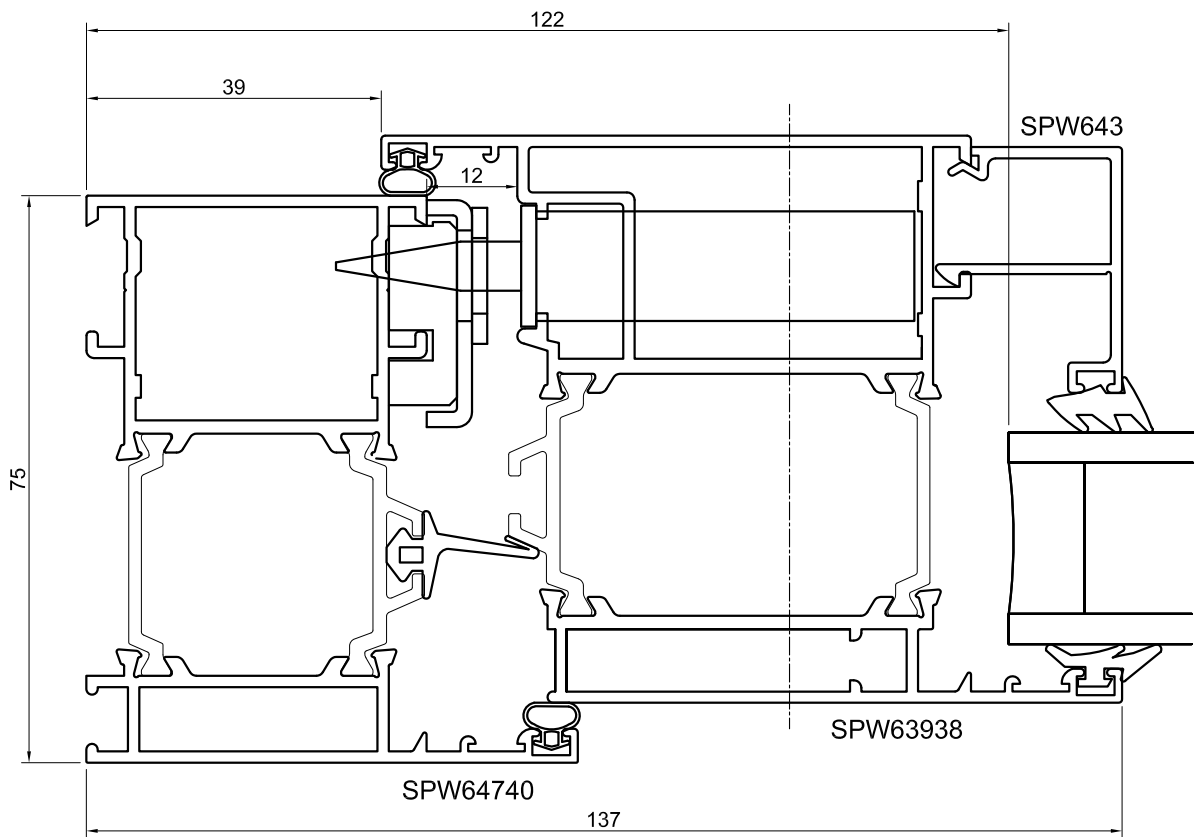
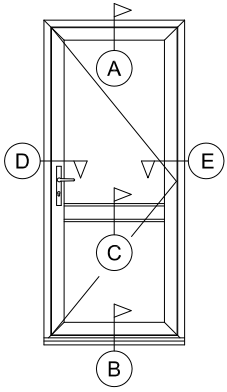


SPW600e.A.4105

# SPW600e Door

04.12

Horizontal Cross Section - Lock Stile Open In



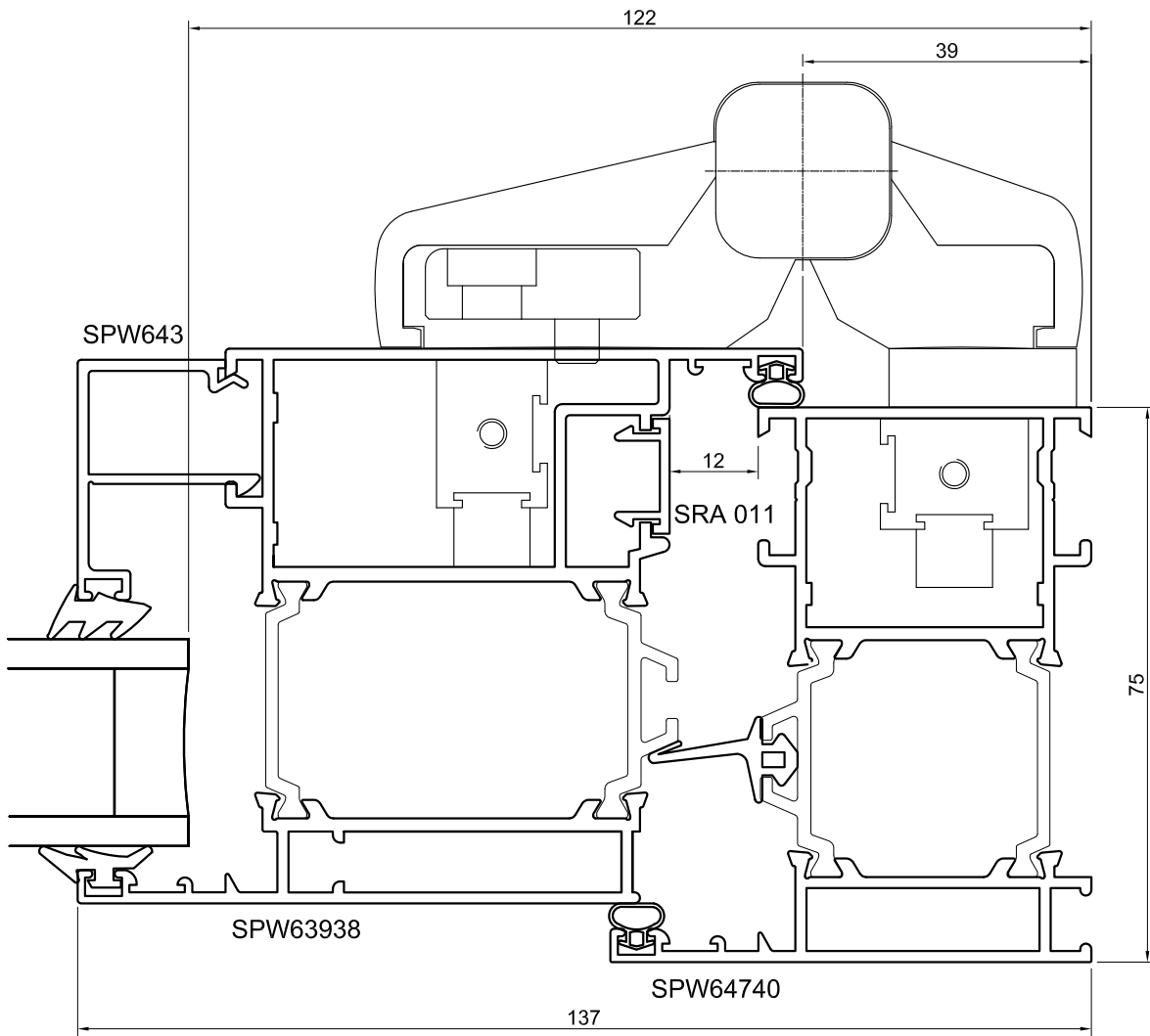
D

# SPW600e Door

SPW600e.A.4106

Horizontal Cross Section - Hinge Stile Open In

04.12

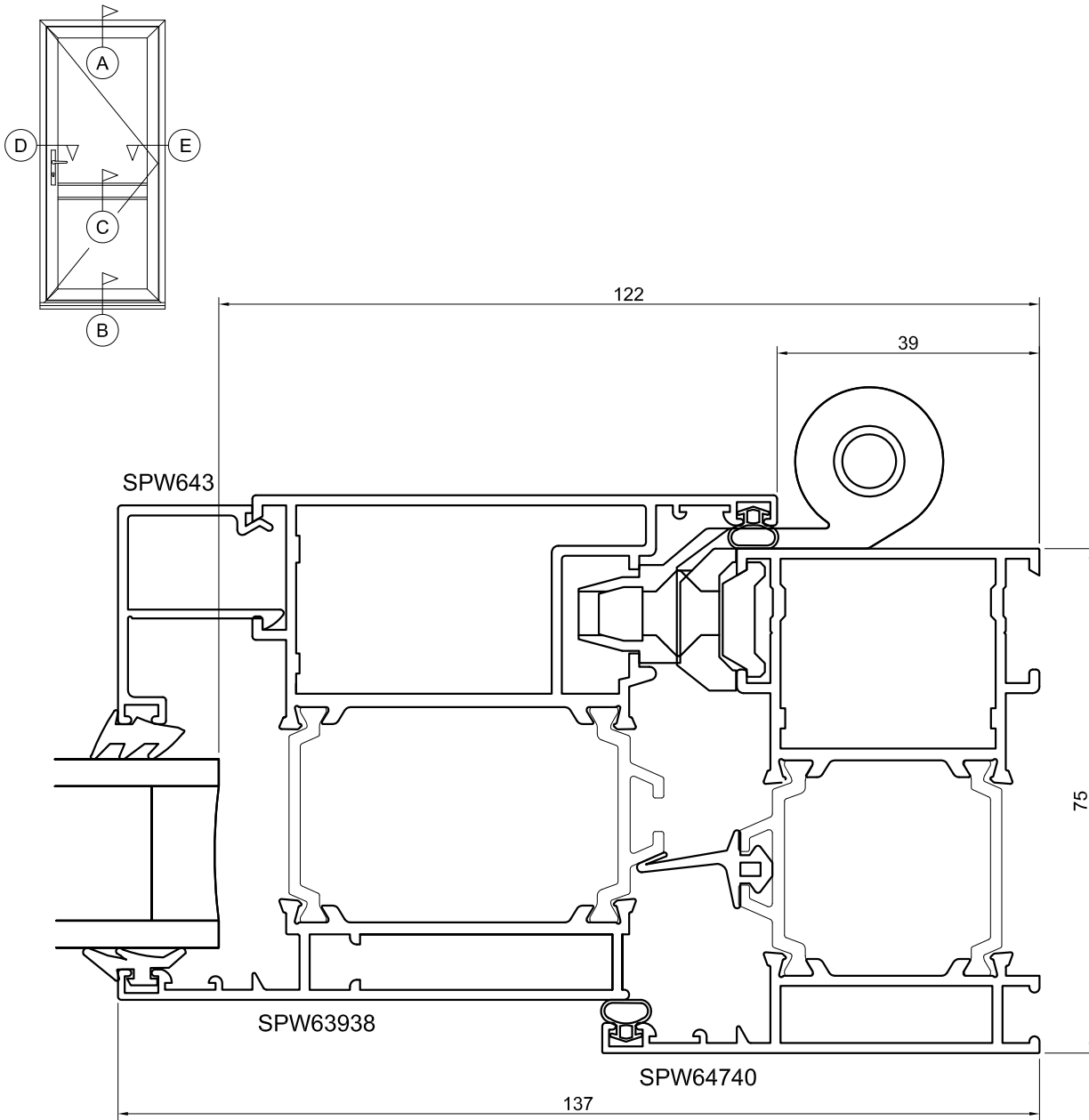


E

# SPW600e.A.4107

# SPW600e Door

04.12 Horizontal Cross Section - Hinge Stile - Clamp on Hinge - Open In



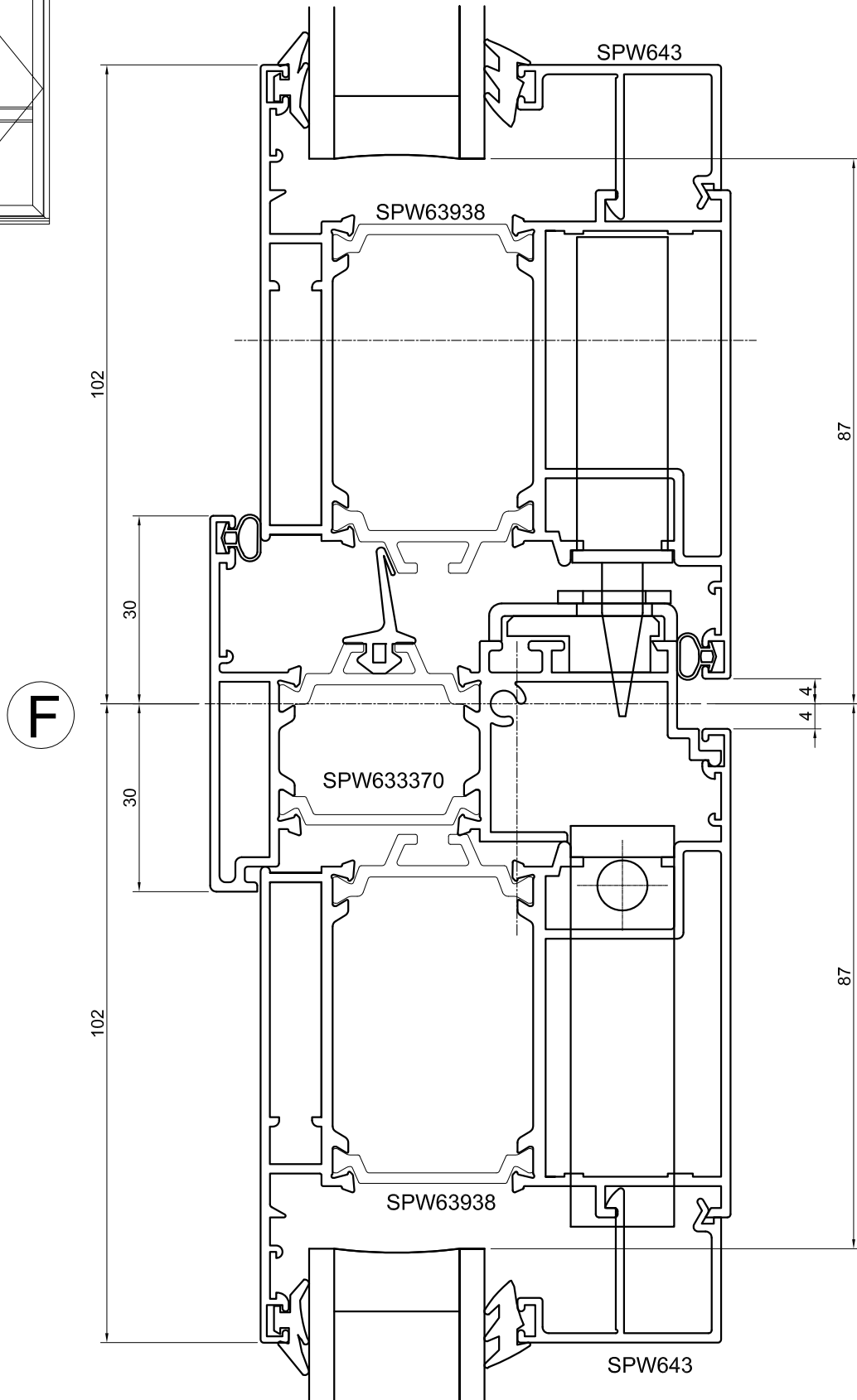
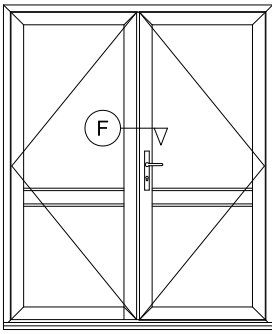
E

# SPW600e Door

SPW600e.A.4108

Horizontal Cross Section - Double Door - Open In Gl In

04.12

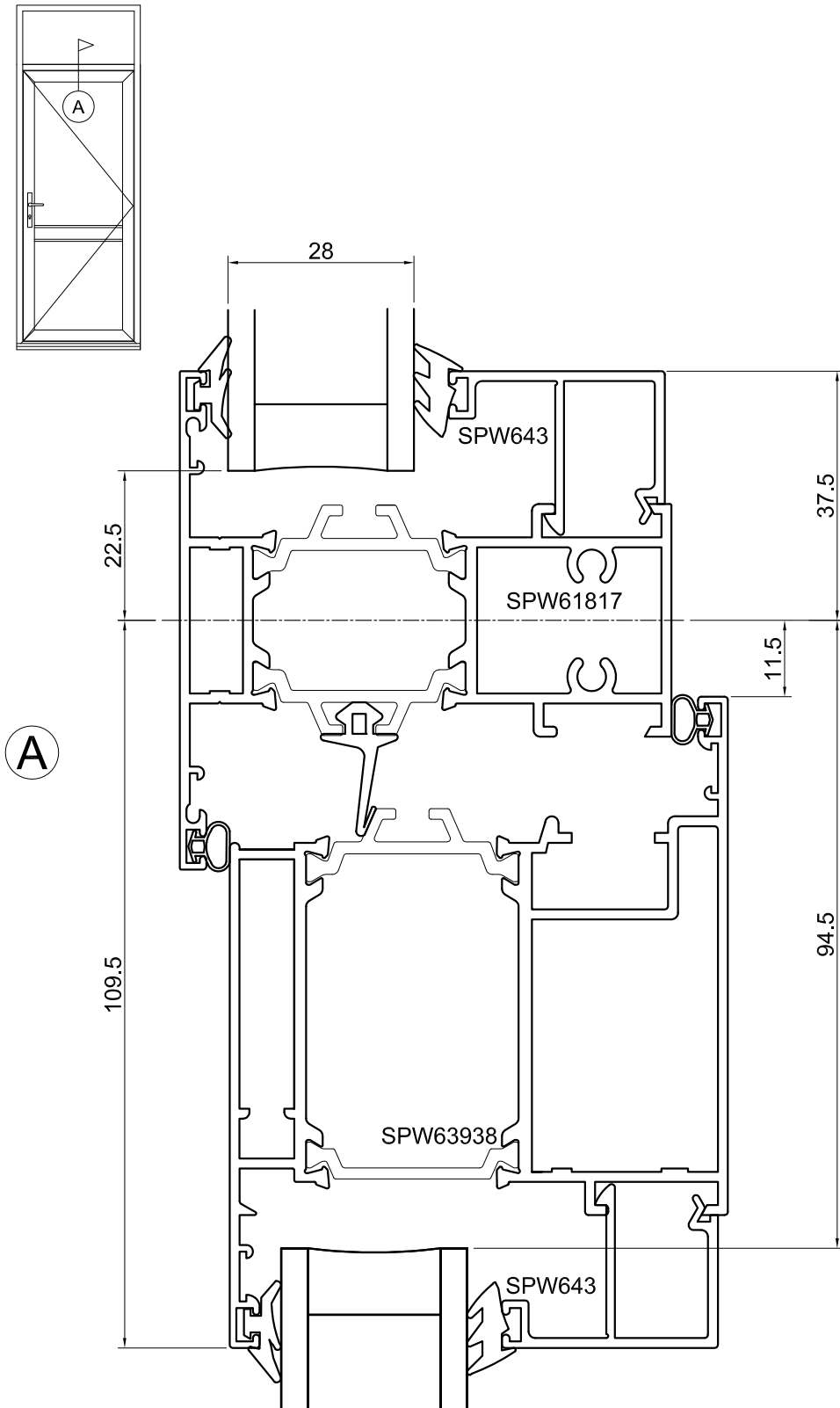


SPW600e.A.4109

# SPW600e Door

04.12

Vertical Cross Section - Head Fan Light - Open In

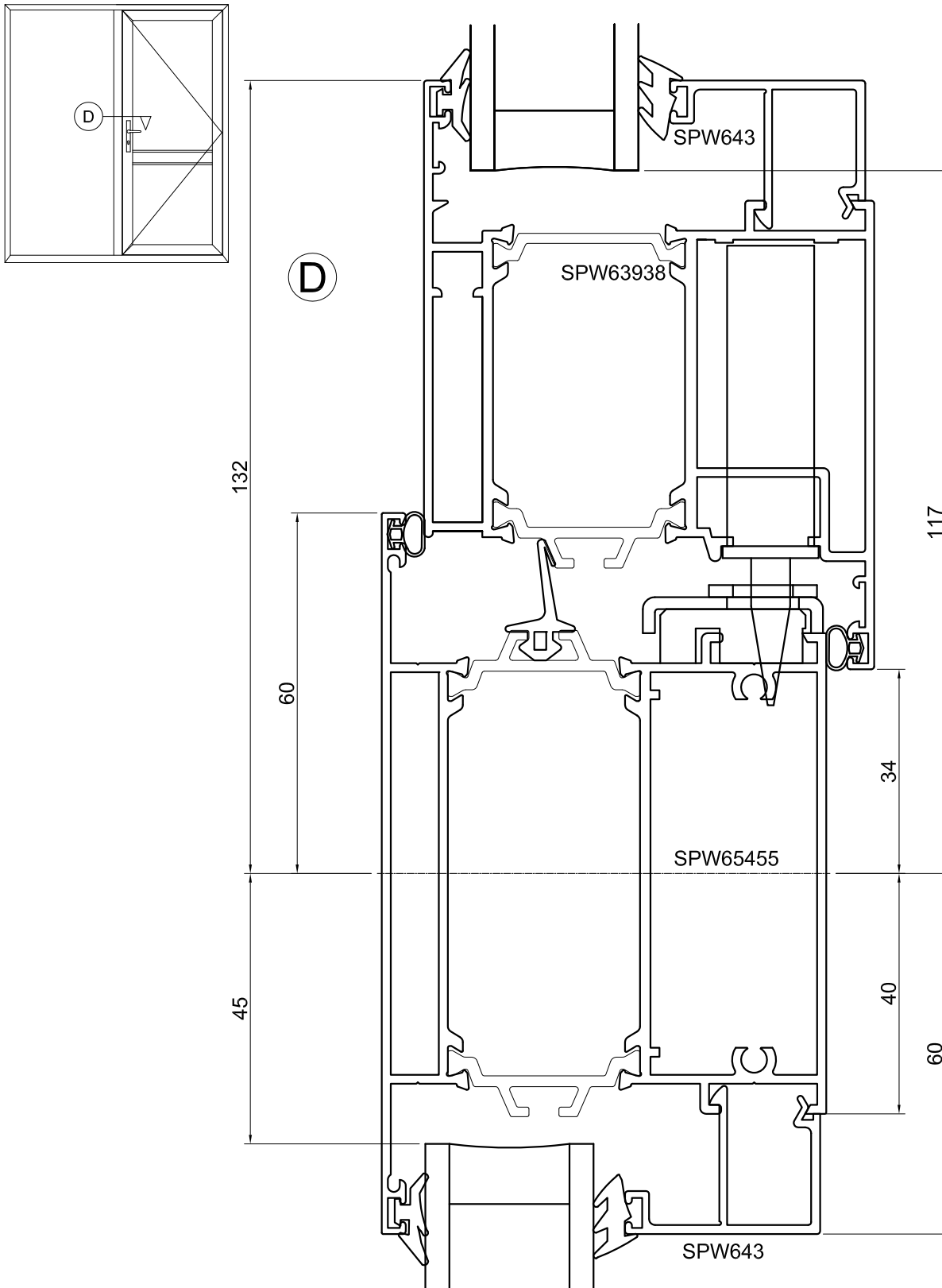


# SPW600e Door

SPW600e.A.4110

Horizontal Cross Section - Side Light Mullion - Open In

04.12

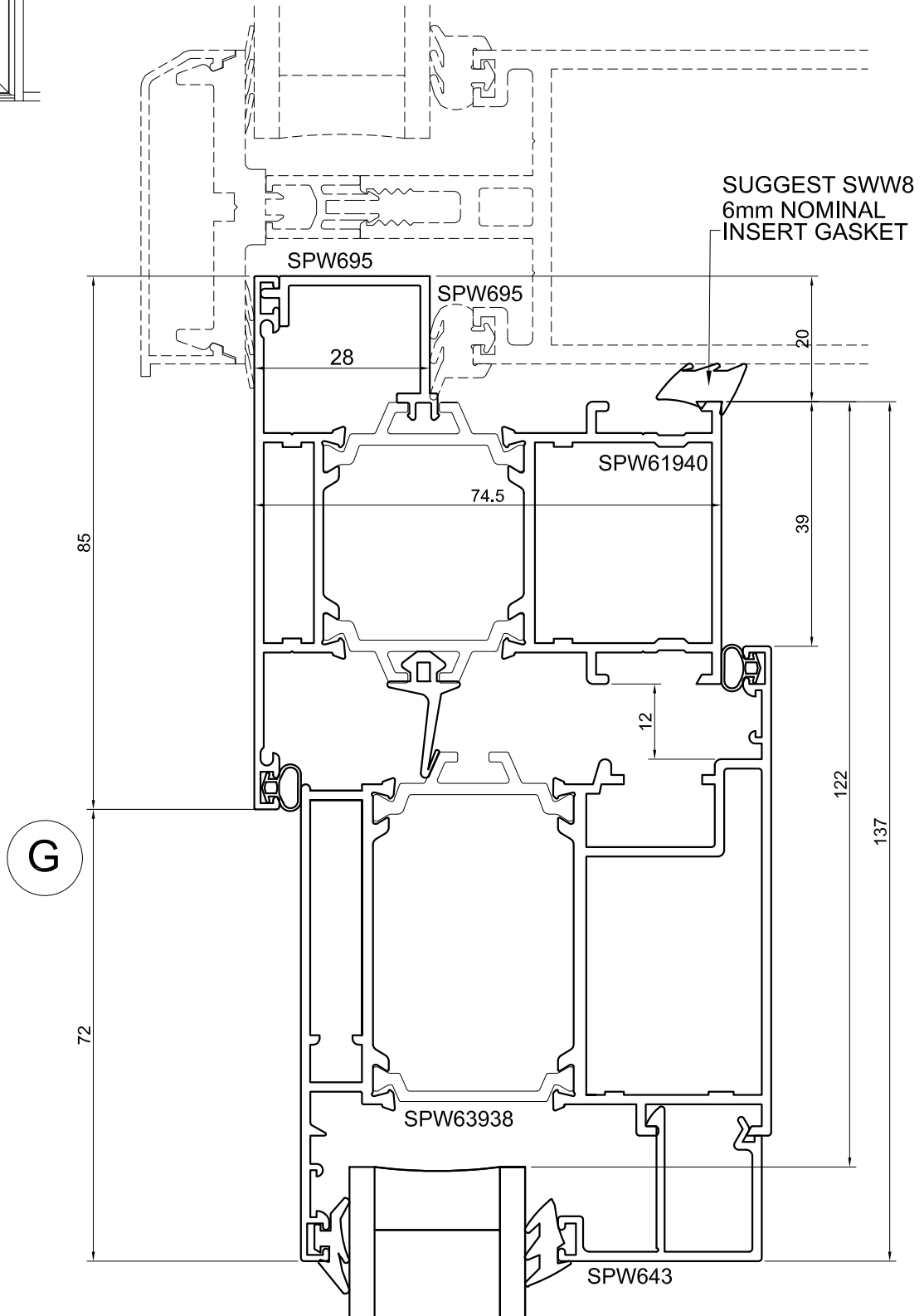
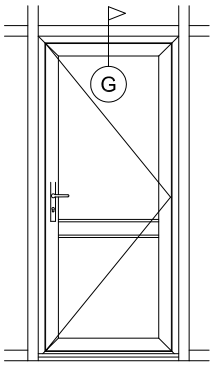


SPW600e.A.4111

# SPW600e Door

04.12

Vertical Cross Section - Head Open In Curtain Wall Insert



# SPW600e Door

Blank

SPW600e.A.4112

04.12

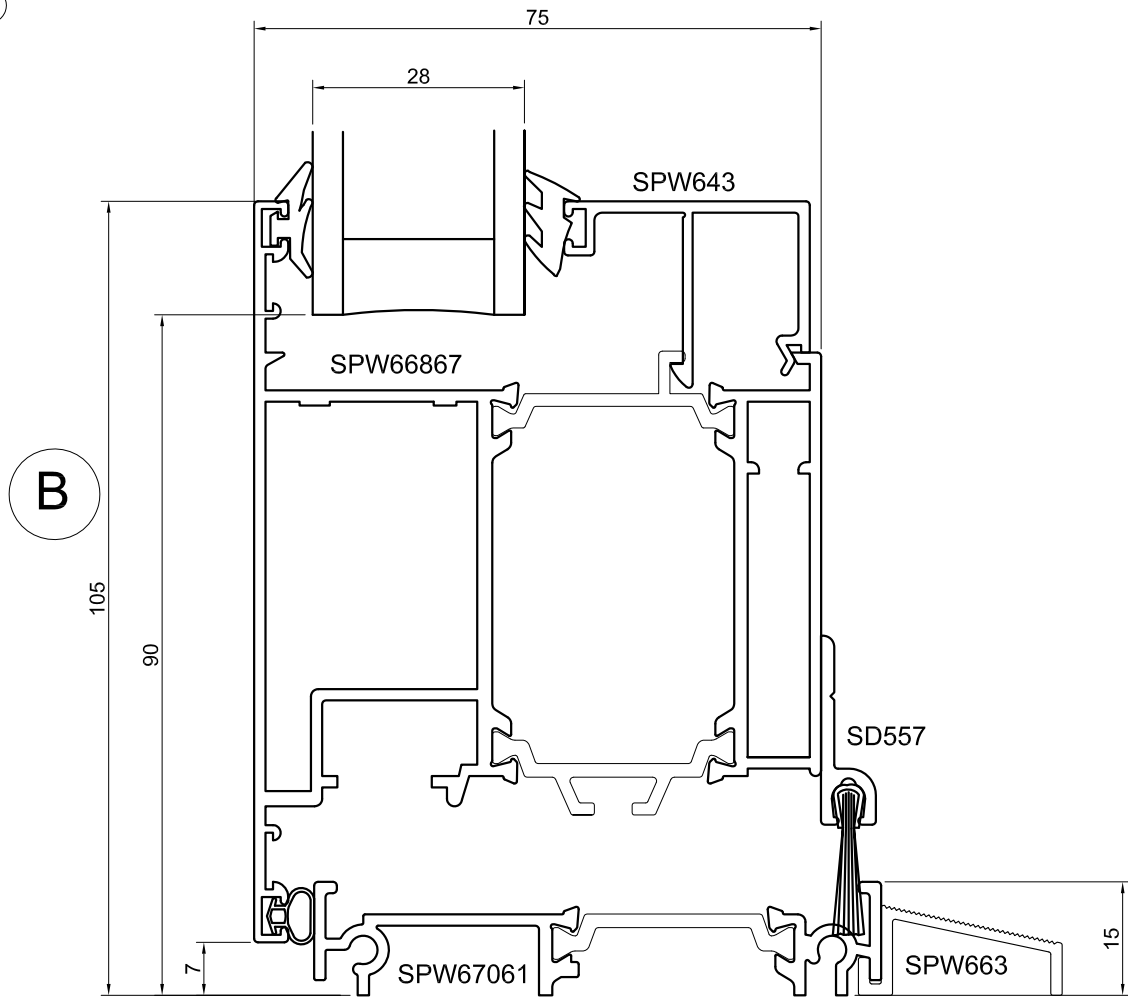
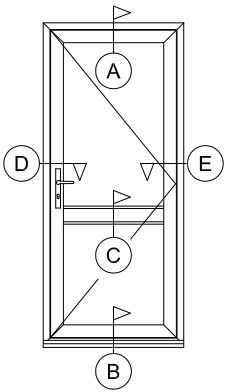
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SPW600e.A.4201

04.12

# SPW600e Door

Vertical Cross Section - Threshold Open Out

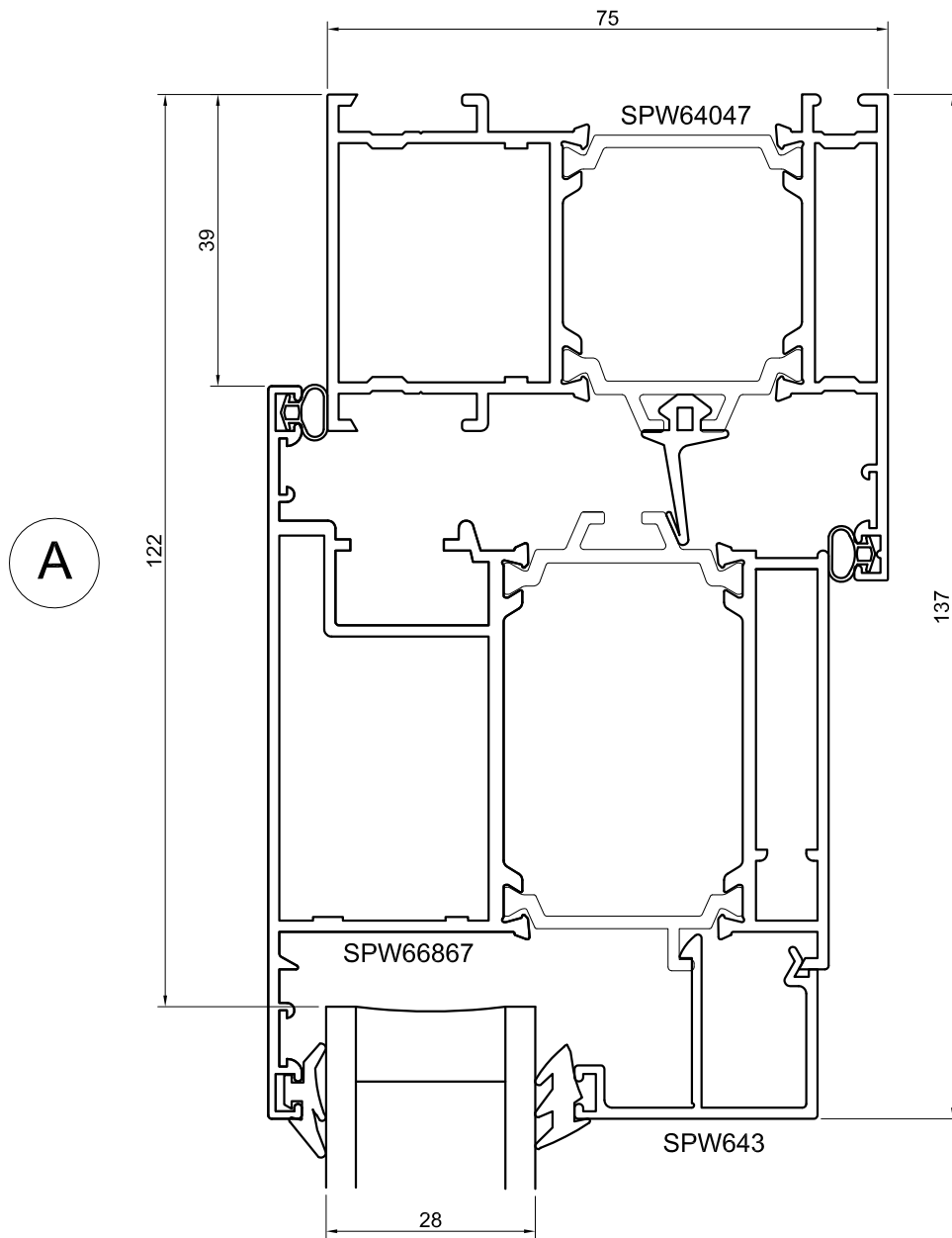


# SPW600e Door

SPW600e.A.4202

Vertical Cross Section - Head Open Out

04.12

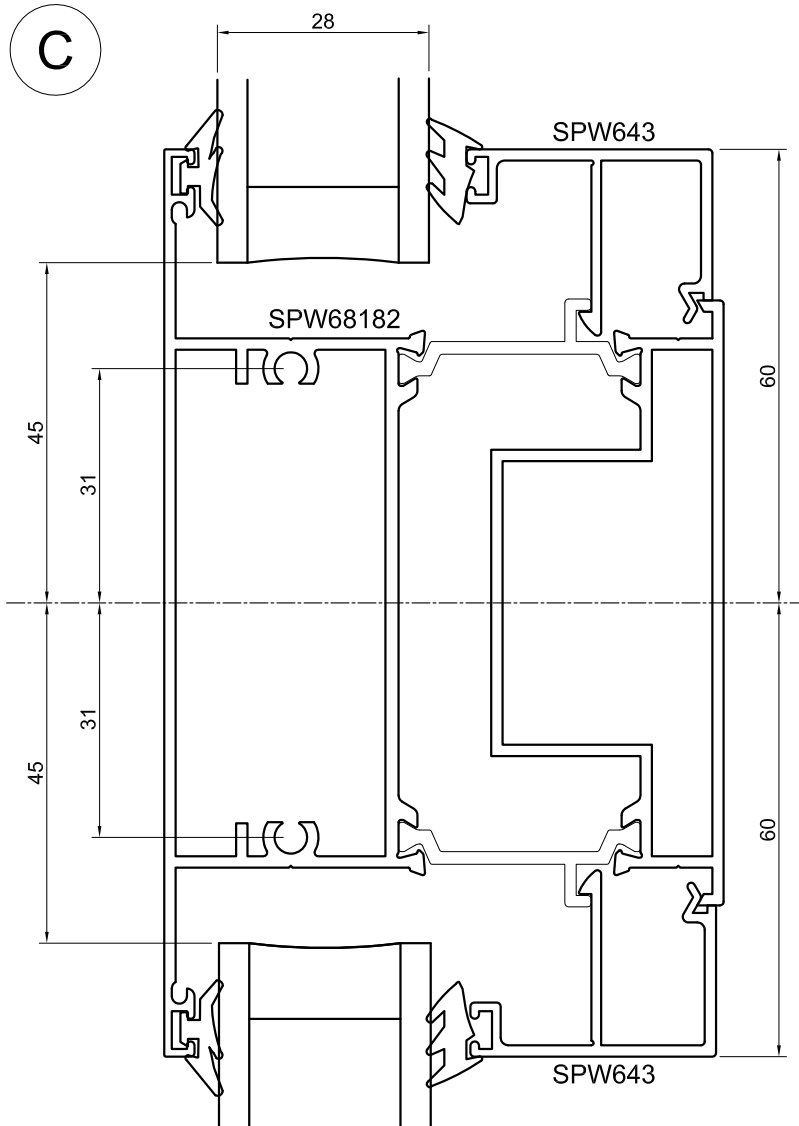
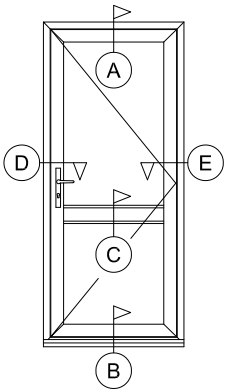


SPW600e.A.4203

04.12

# SPW600e Door

Vertical Cross Section - Midrail Open Out

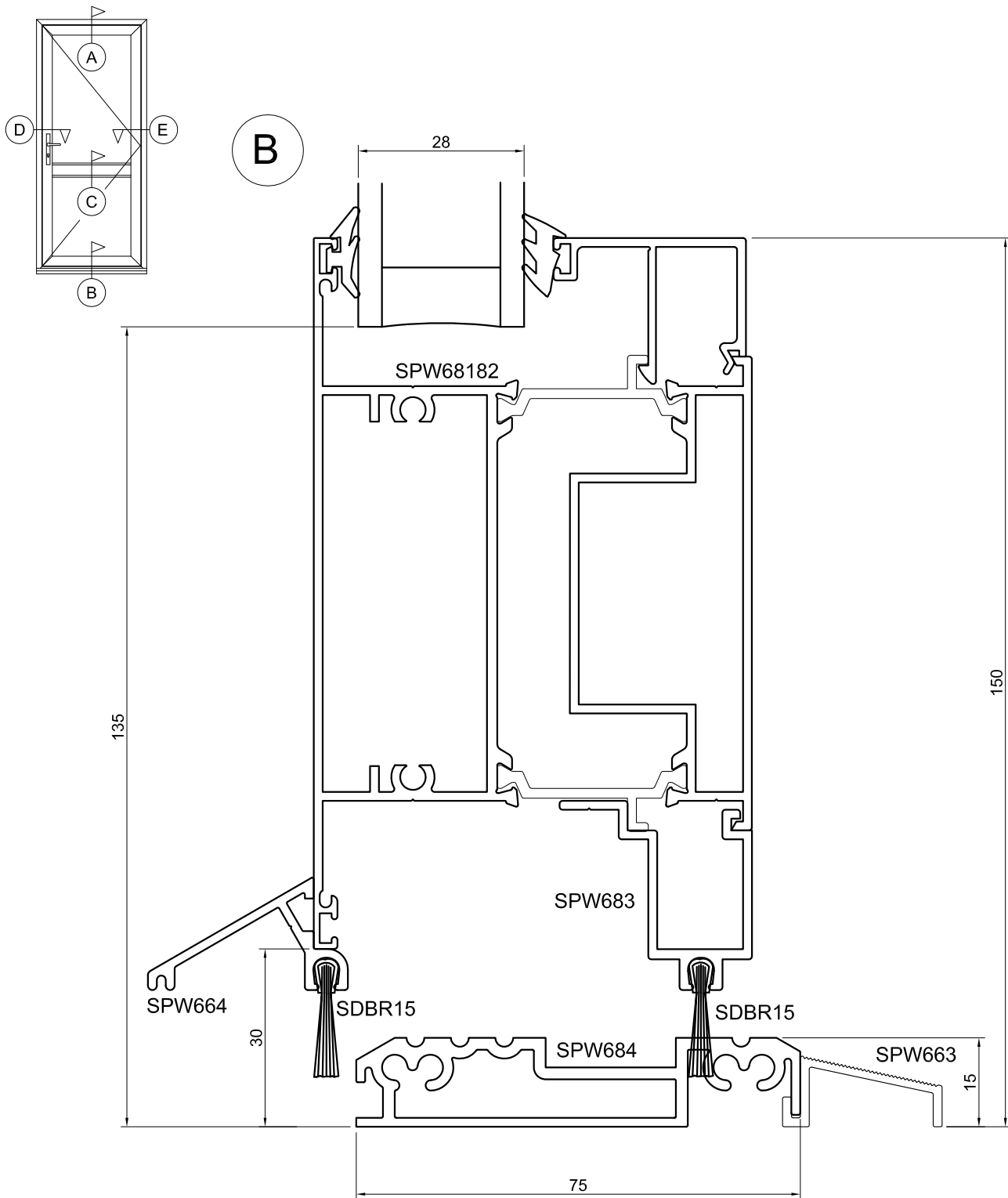


# SPW600e Door

SPW600e.A.4204

Vertical Cross Section - Threshold Open Out

04.12

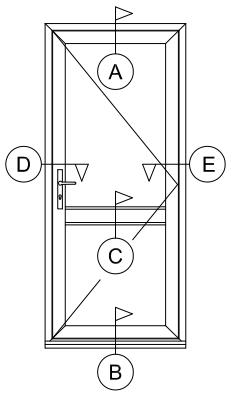


SPW600e.A.4205

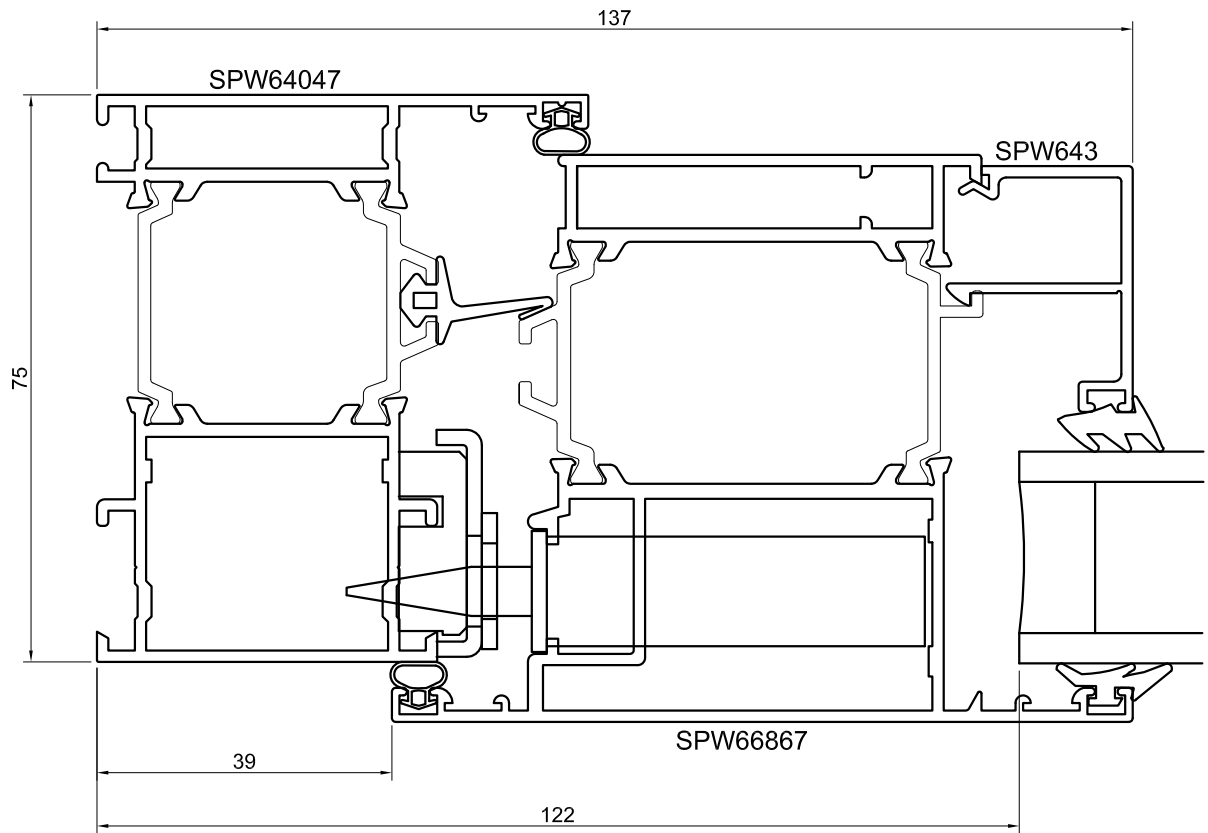
# SPW600e Door

04.12

Horizontal Cross Section - Lock Stile Open Out



D



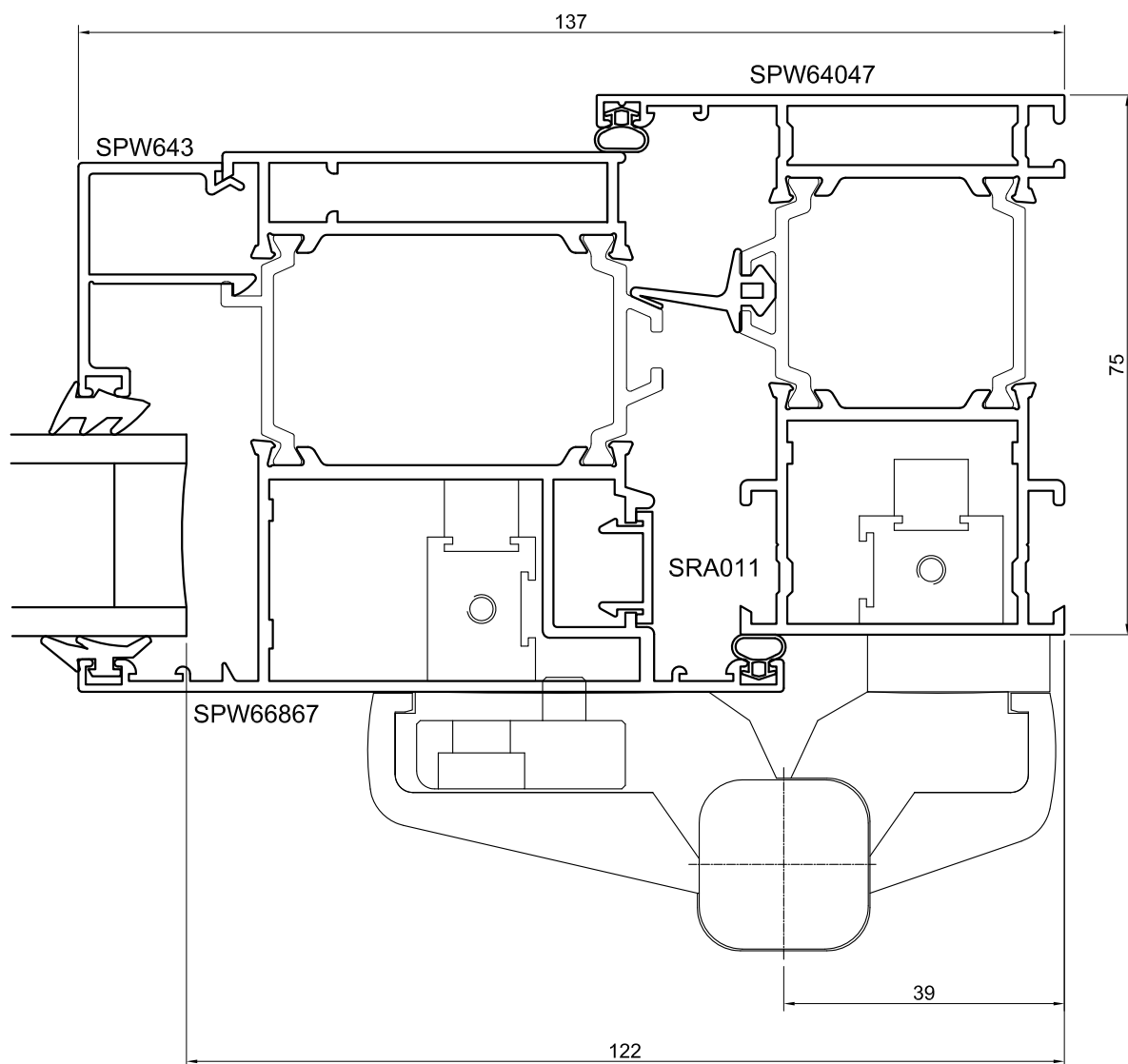
# SPW600e Door

SPW600e.A.4206

Horizontal Cross Section - Hinge Stile Open Out

04.12

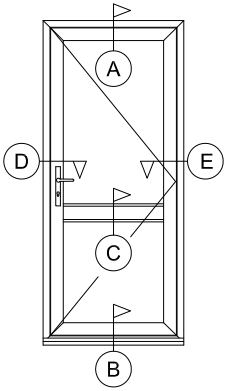
E



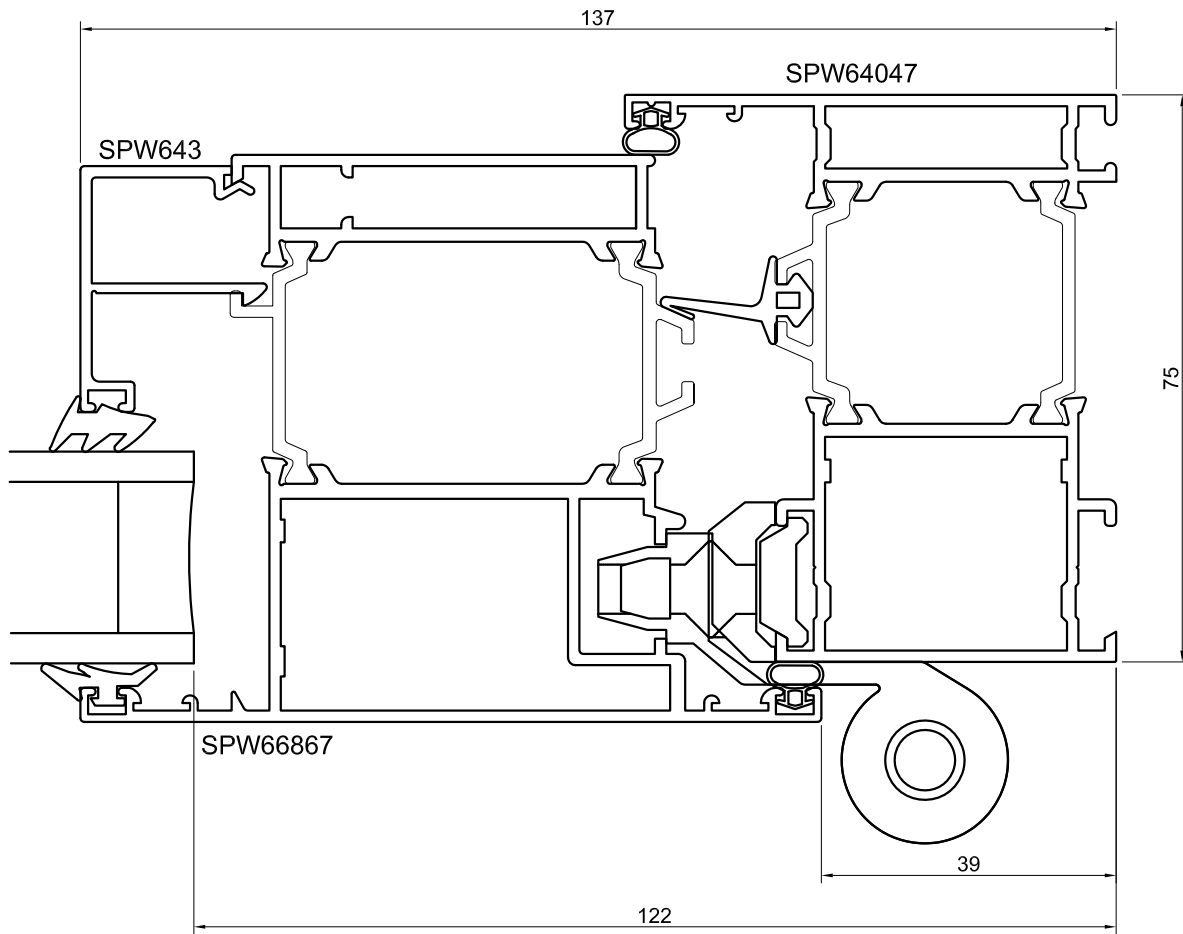
# SPW600e.A.4207

# SPW600e Door

04.12 Horizontal Cross Section - Hinge Stile - Clamp On Hinge Open Out



**E**

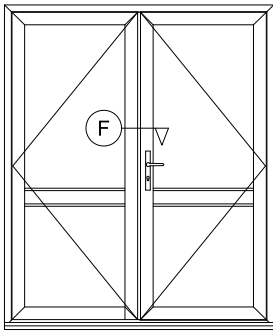


# SPW600e Door

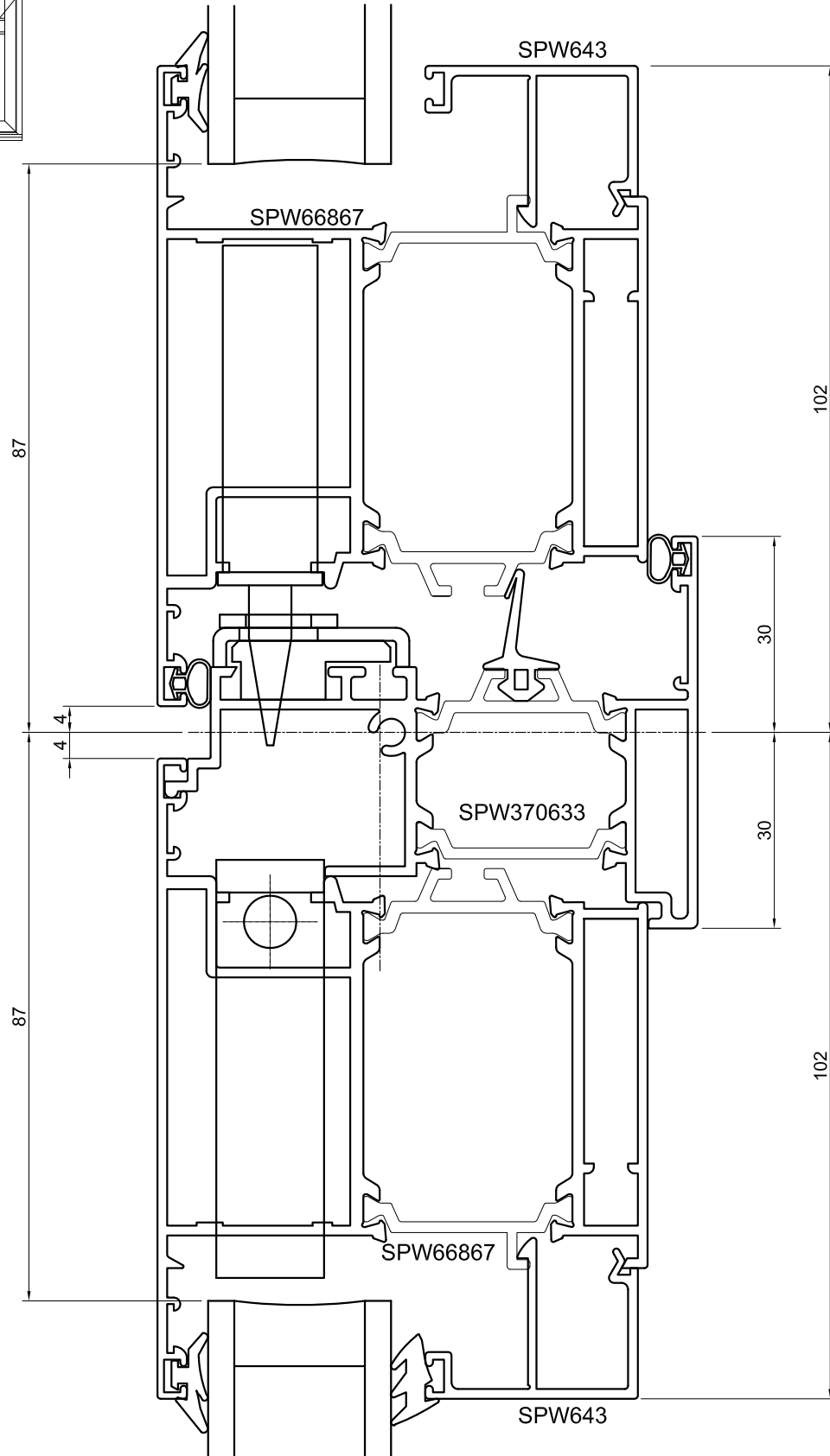
SPW600e.A.4208

Horizontal Cross Section - Double Door - Open Out

04.12



F

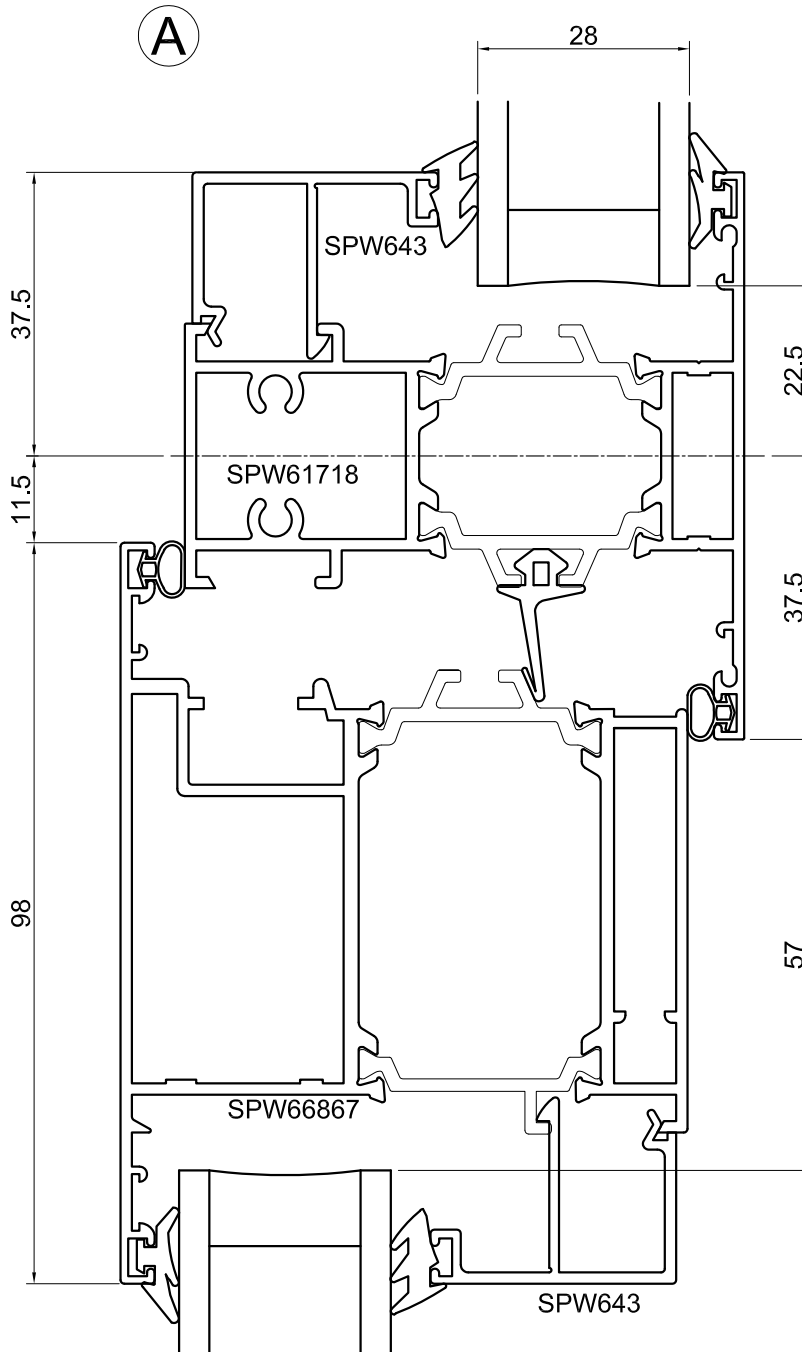
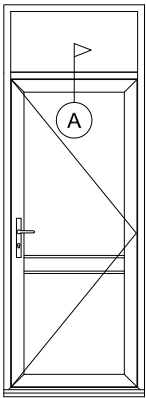


SPW600e.A.4209

# SPW600e Door

04.12

Vertical Cross Section - Head Fan Light - Open Out

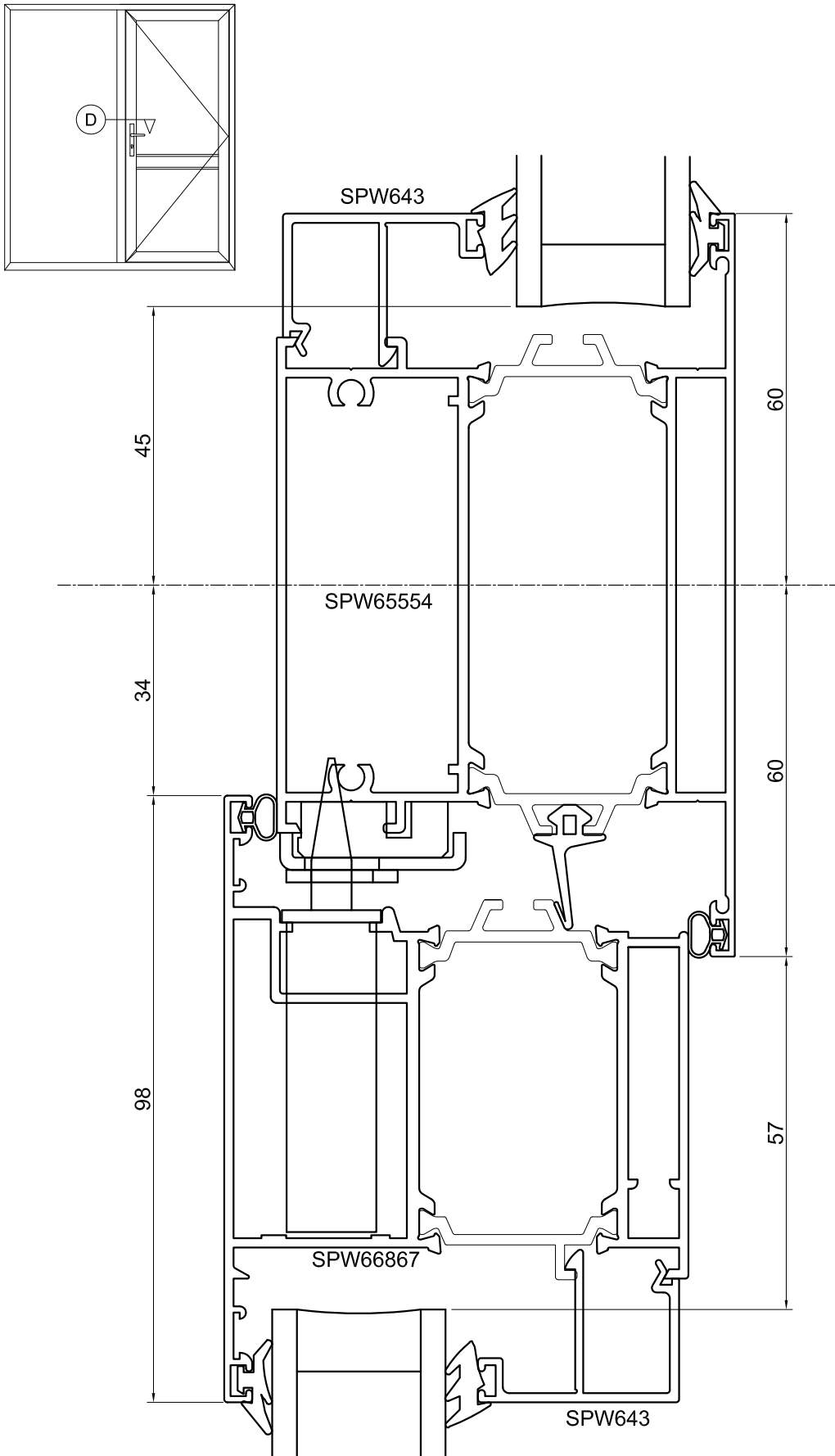


# SPW600e Door

SPW600e.A.4210

Horizontal Cross Section - Side Light Mullion - Open Out

04.12

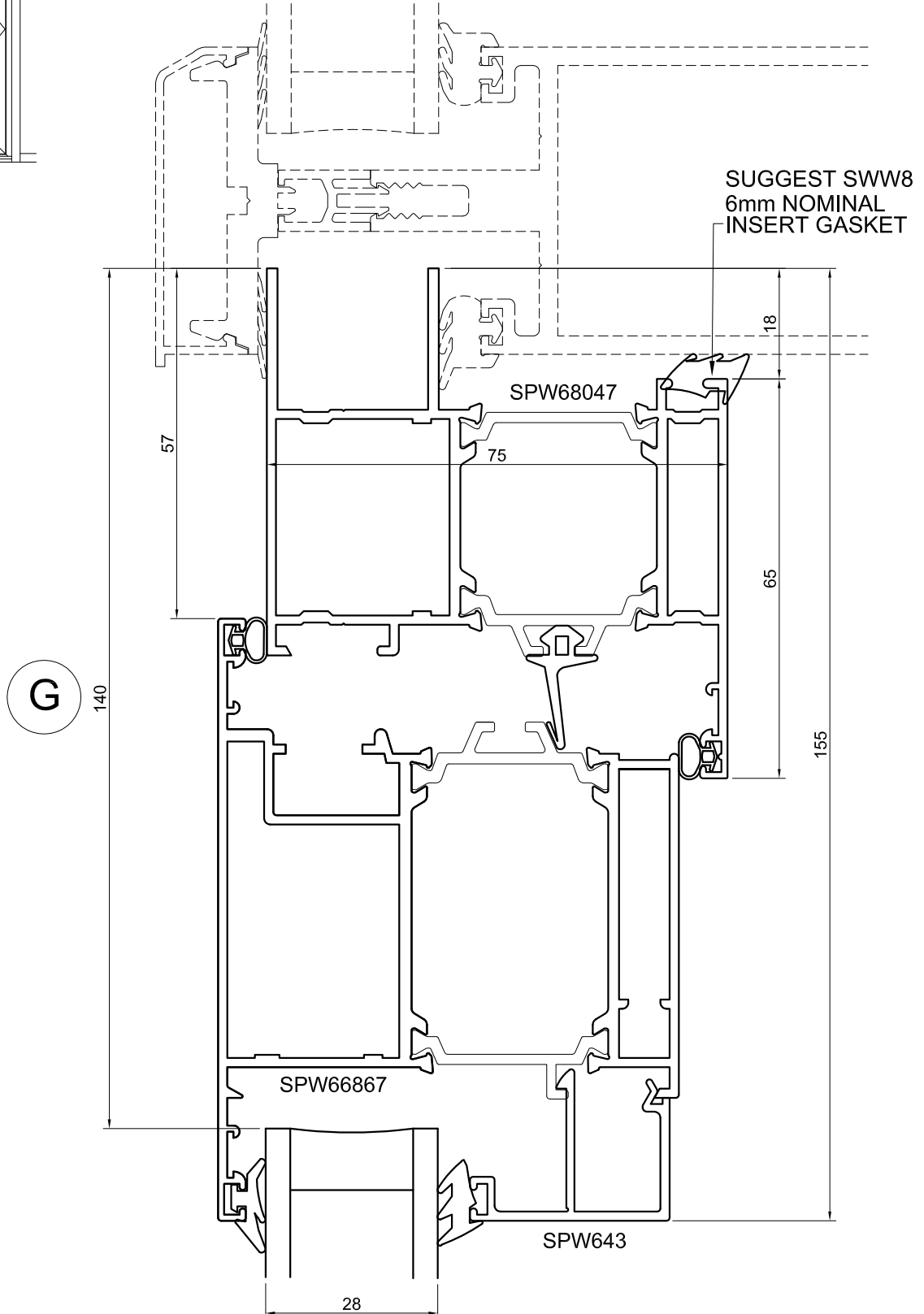
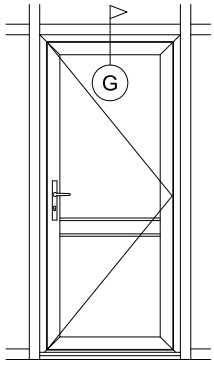


# SPW600e.A.4211

# SPW600e Door

04.12

## Vertical Cross Section - Head Open Out Curtain Wall Insert



# SPW600e Door

Blank

SPW600e.A.4212

04.12

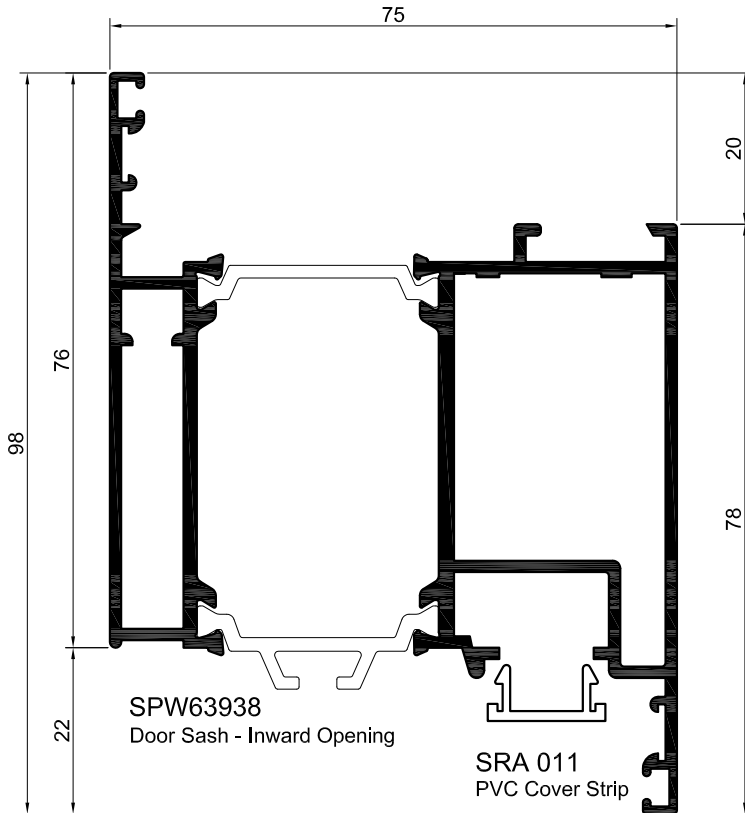
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# SPW600e.B.401





04.12

# SPW600e Door

## Section Identification

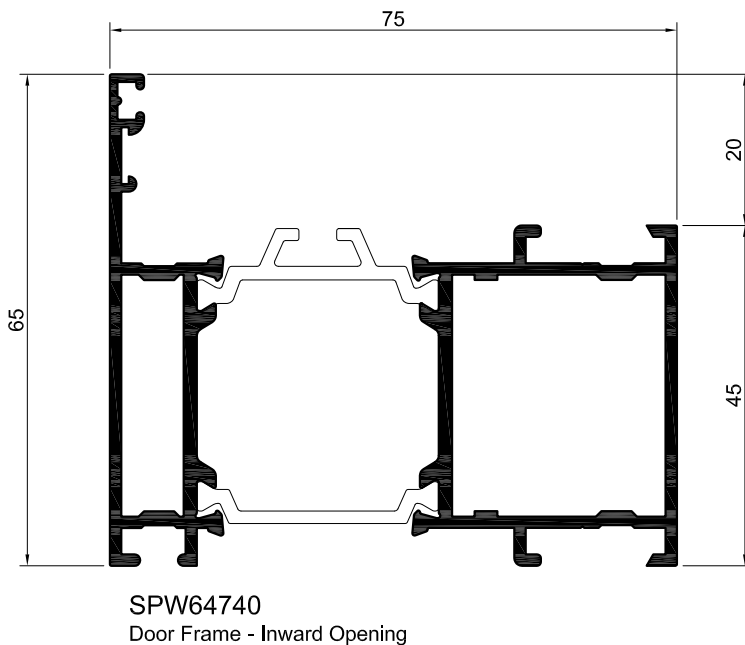


### Door Sash - Inward Opening





ALUMINIUM INNER	SPW638
ALUMINIUM OUTER	SPW639
EXTERNAL PERIMETER INNER	200mm
INTERNAL PERIMETER INNER	75mm
EXTERNAL PERIMETER OUTER	204mm
INTERNAL PERIMETER OUTER	102mm
OVERALL EXTERNAL PERIMETER	344mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW289100
	PV04
	PH10
CHEVRON	SW4CH7
	SPW657CT28
	SPW657CT8
Ixx ←	55.7392cm <sup>4</sup>
Iyy ↑	33.6717cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS007
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### Door Frame - Inward Opening

ALUMINIUM INNER	SPW640
ALUMINIUM OUTER	SPW647
EXTERNAL PERIMETER INNER	200mm
INTERNAL PERIMETER INNER	75mm
EXTERNAL PERIMETER OUTER	238mm
INTERNAL PERIMETER OUTER	102mm
OVERALL EXTERNAL PERIMETER	414mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700
	PV02
	PH05
CHEVRON	SW4CH7
	SW446CT28
	SW446CT8
Ixx ←	39.3964cm <sup>4</sup>
Iyy ↑	13.9351cm <sup>4</sup>

### EPS Insert

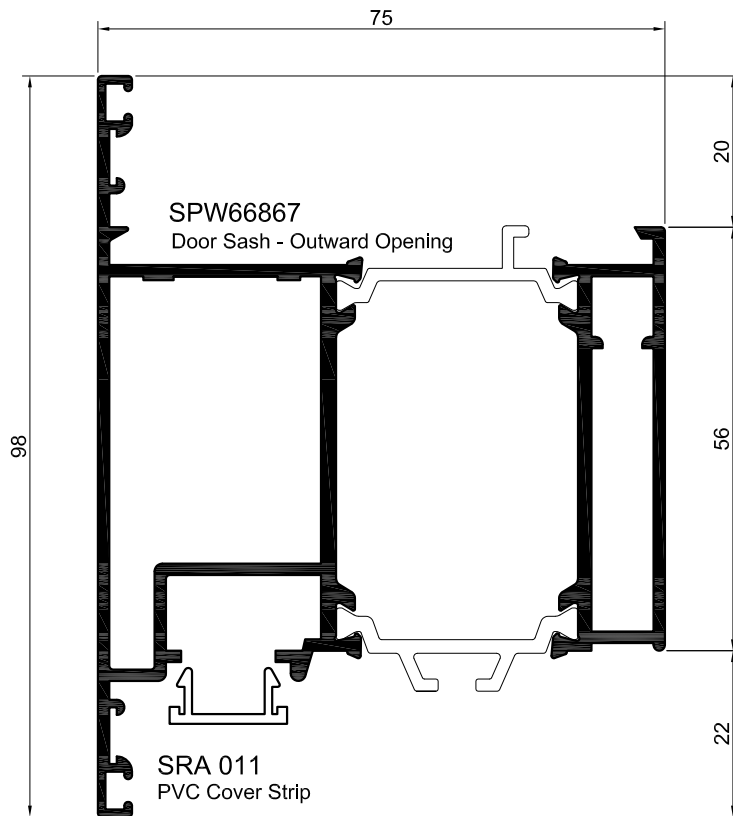
EPS Into Section	EPS001
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# SPW600e Door





## Section Identification

SPW600e.B.402

04.12

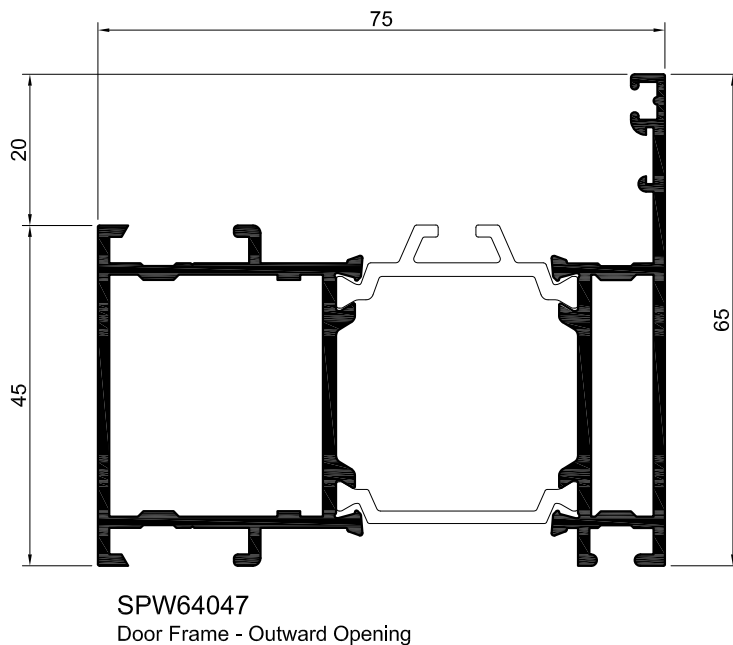


### Door Sash - Outward Opening





ALUMINIUM INNER	SPW667
ALUMINIUM OUTER	SPW668
EXTERNAL PERIMETER INNER	168mm
INTERNAL PERIMETER INNER	124mm
EXTERNAL PERIMETER OUTER	376mm
INTERNAL PERIMETER OUTER	175mm
OVERALL EXTERNAL PERIMETER	495mm
POLYAMIDE UPPER	PAW2161HKN
POLYAMIDE LOWER	PAW289100
	PV04
	PH10A
CHEVRON	SW4CH7
	SPW657CT28
	SPW657CT8
Ixx ←	51.2677cm <sup>4</sup>
Iyy ↑	32.5598cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS007
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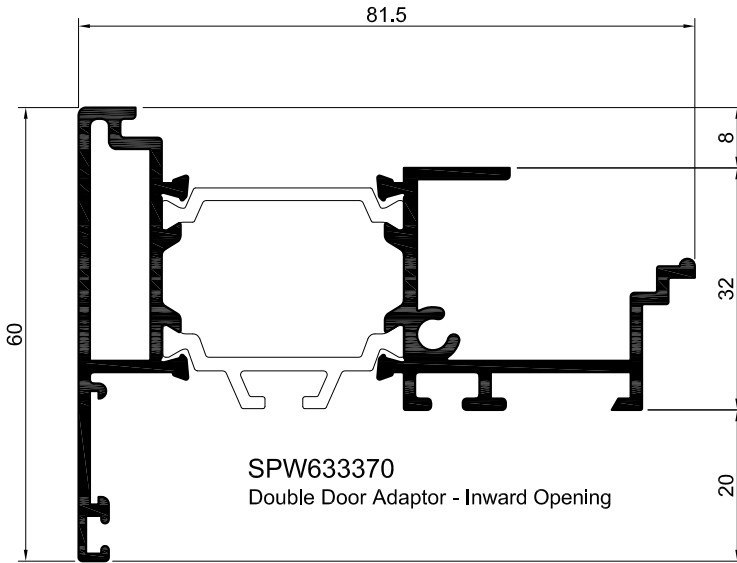
### Door Frame - Outward Opening

ALUMINIUM INNER	SPW647
ALUMINIUM OUTER	SPW640
EXTERNAL PERIMETER INNER	200mm
INTERNAL PERIMETER INNER	75mm
EXTERNAL PERIMETER OUTER	238mm
INTERNAL PERIMETER OUTER	102mm
OVERALL EXTERNAL PERIMETER	414mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW939700
	PV02
	PH05
CHEVRON	SW4CH7
	SW446CT28
	SW446CT8
Ixx ←	39.3964cm <sup>4</sup>
Iyy ↑	13.9351cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS001
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Please Note Suffix "A" On Tooling Code Indicates Inverted Knives

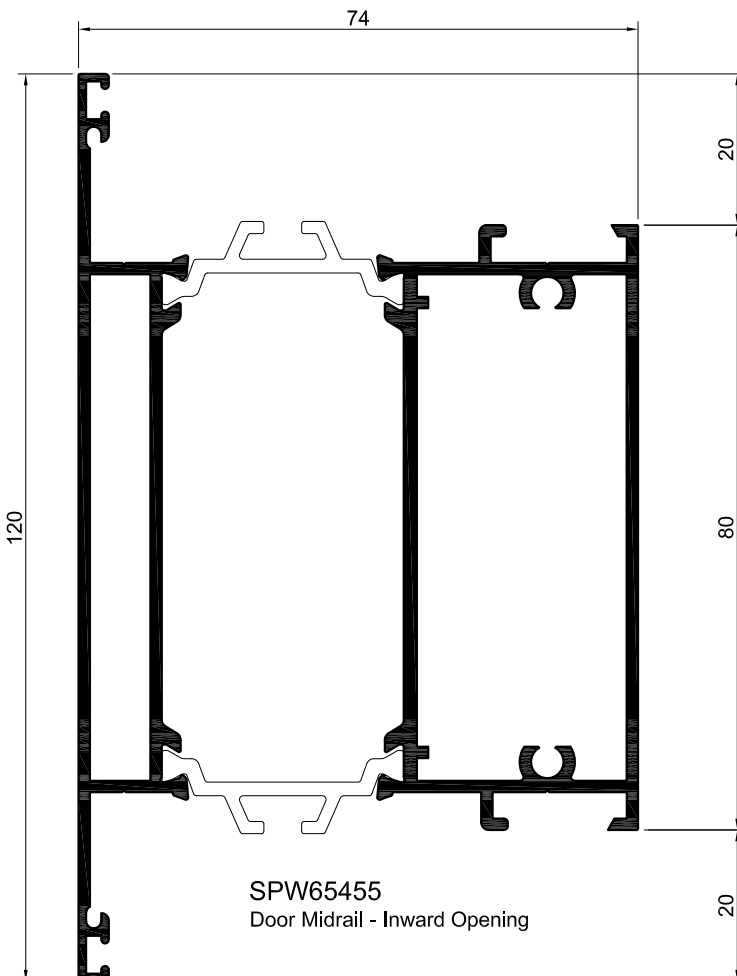


### Double Door Adaptor - Inward Opening

ALUMINIUM OUTER	SPW633
ALUMINIUM INNER	SPW370
EXTERNAL PERIMETER OUTER	193mm
INTERNAL PERIMETER OUTER	79mm
EXTERNAL PERIMETER INNER	264mm
OVERALL EXTERNAL PERIMETER	443mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW939700
$I_{xx}$ ←	29.3168cm <sup>4</sup>
$I_{yy}$ ↑	7.6153cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS008
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### Door Midrail - Inward Opening & Side Light Mullion

ALUMINIUM INNER	SPW655
ALUMINIUM OUTER	SPW654
EXTERNAL PERIMETER INNER	284mm
INTERNAL PERIMETER INNER	232mm
EXTERNAL PERIMETER OUTER	325mm
INTERNAL PERIMETER OUTER	150mm
OVERALL EXTERNAL PERIMETER	535mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW289100

 SPW650CT66

 SPW352CT58

$I_{xx}$ ←	60.0313cm <sup>4</sup>
$I_{yy}$ ↑	66.3946cm <sup>4</sup>

### EPS Insert

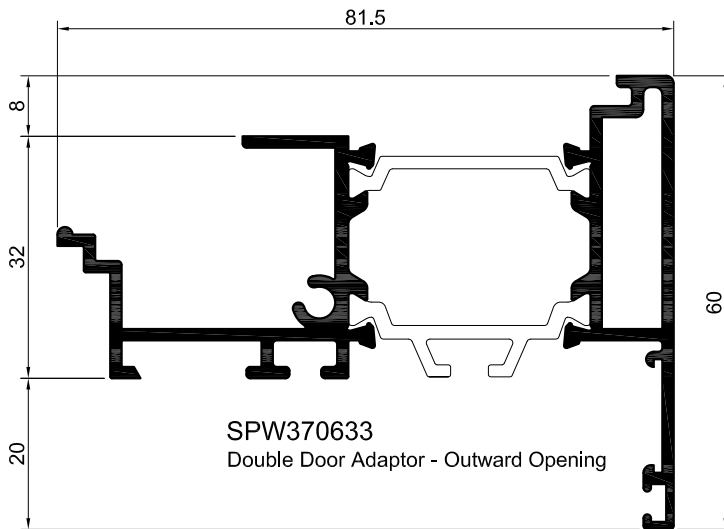
EPS Into Section	EPS007 + EPS008
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# SPW600e Door

# SPW600e.B.404

## Section Identification

04.12

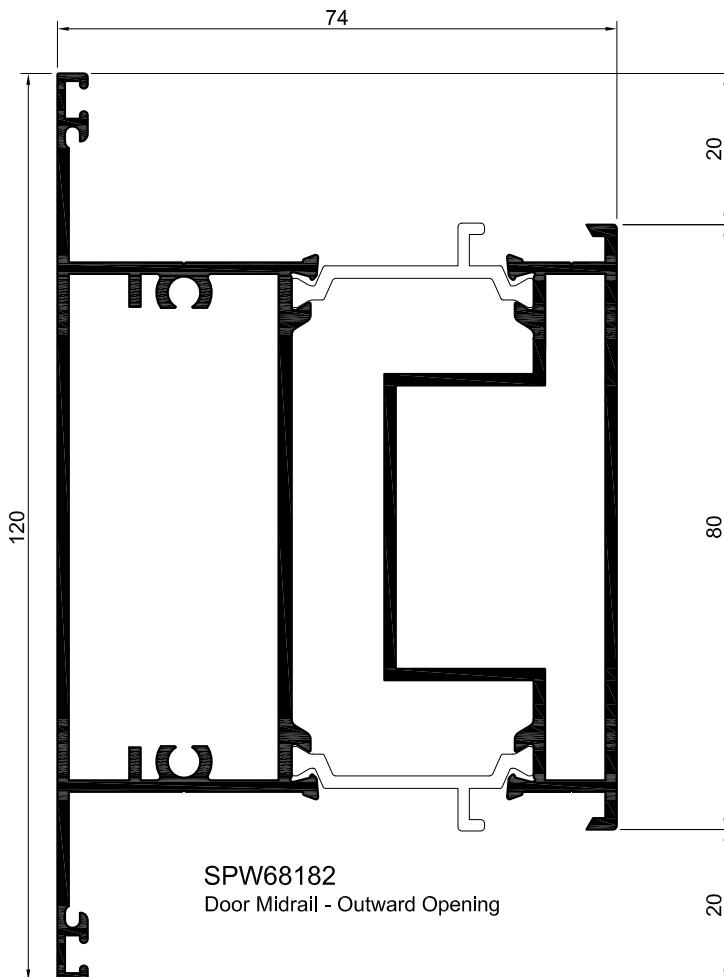


### Double Door Adaptor - Outward Opening

ALUMINIUM OUTER	SPW370
ALUMINIUM INNER	SPW633
EXTERNAL PERIMETER OUTER	193mm
INTERNAL PERIMETER OUTER	79mm
EXTERNAL PERIMETER INNER	264mm
OVERALL EXTERNAL PERIMETER	443mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW939700
Ixx ←	29.3168cm <sup>4</sup>
Iyy ↑	7.6153cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS008
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### Door Midrail - Outward Opening

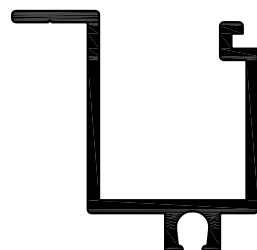
ALUMINIUM INNER	SPW682
ALUMINIUM OUTER	SPW681
EXTERNAL PERIMETER INNER	256mm
INTERNAL PERIMETER INNER	189mm
EXTERNAL PERIMETER OUTER	366mm
INTERNAL PERIMETER OUTER	238mm
OVERALL EXTERNAL PERIMETER	500mm
POLYAMIDE UPPER	PAW2161HKN
POLYAMIDE LOWER	PAW2161HKN

	SPW650CT66
	SPW352CT31
Ixx ←	66.0093cm <sup>4</sup>
Iyy ↑	57.6102cm <sup>4</sup>

### EPS Insert

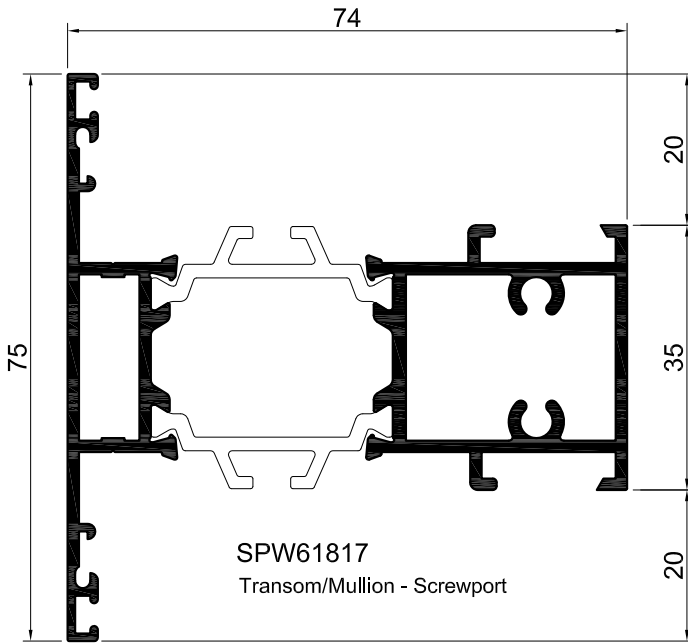
EPS Into Section	EPS004 (x4)
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SPW683  
Bottom Door Adaptor



### Bottom Door Adaptor

EXTERNAL PERIMETER INNER	196mm
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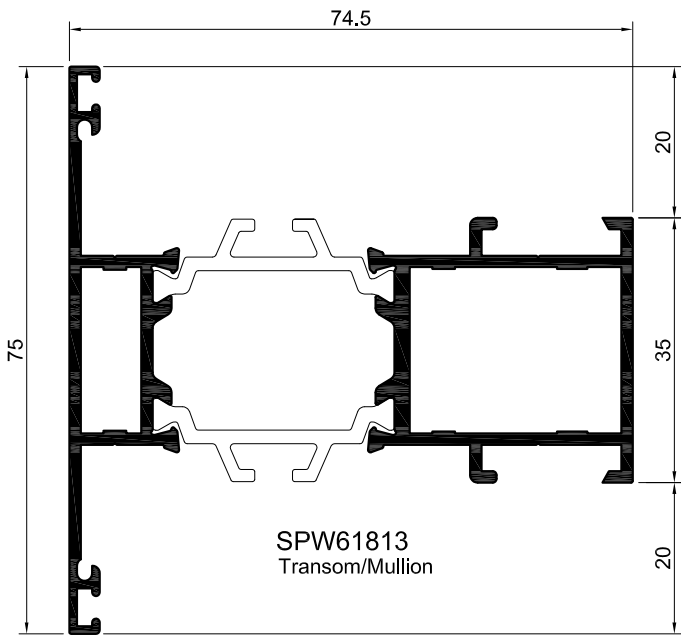
### Transom/Mullion - Screwport

ALUMINIUM INNER	SPW617
ALUMINIUM OUTER	SPW618
EXTERNAL PERIMETER INNER	194mm
INTERNAL PERIMETER INNER	138mm
EXTERNAL PERIMETER OUTER	235mm
INTERNAL PERIMETER OUTER	61mm
OVERALL EXTERNAL PERIMETER	442mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW289100
CHEVRONS	SW4CH7 CHEV7P



	SPW650CT21
Ixx ←	37.4910cm <sup>4</sup>
Iyy ↑	10.2891cm <sup>4</sup>




### EPS Insert

EPS Into Section	EPS008
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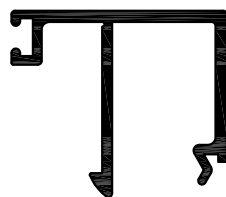
### Transom/Mullion

ALUMINIUM INNER	SPW613
ALUMINIUM OUTER	SPW618
EXTERNAL PERIMETER INNER	196mm
INTERNAL PERIMETER INNER	102mm
EXTERNAL PERIMETER OUTER	235mm
INTERNAL PERIMETER OUTER	61mm
OVERALL EXTERNAL PERIMETER	450mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW289100
	PV02
	PH01

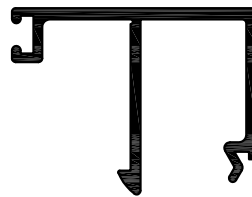
	SW445CT28
	SW445CT8
	SPW650CT21
	SPW652CT21
Ixx ←	35.6030cm <sup>4</sup>
Iyy ↑	10.1499cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS008
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SPW624  
32mm Int. Glazed Bead  
EXTERNAL PERIMETER 174mm



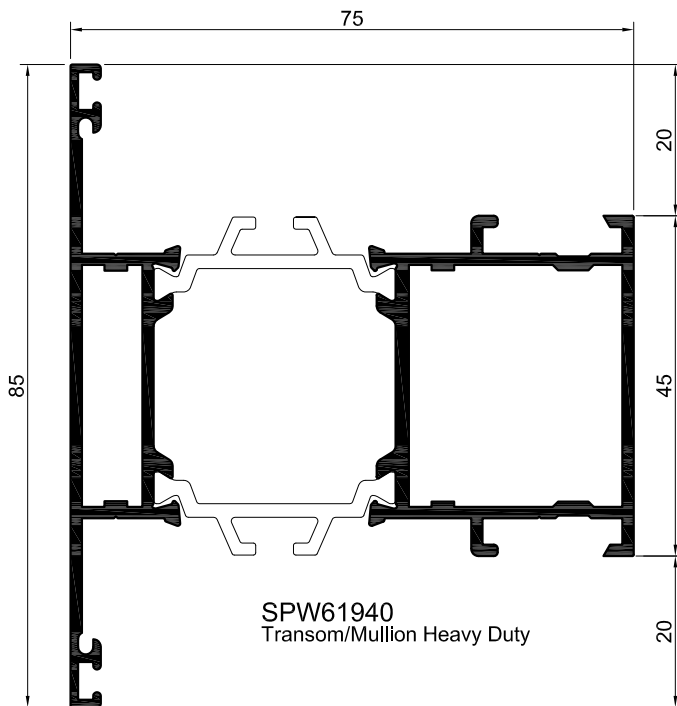
SPW643  
28mm Int. Glazed Bead  
EXTERNAL PERIMETER 185mm

# SPW600e Door

# SPW600e.B.406


## Section Identification

04.12



### Transom/Mullion Heavy Duty

ALUMINIUM INNER	SPW640
ALUMINIUM OUTER	SPW619
EXTERNAL PERIMETER INNER	217mm
INTERNAL PERIMETER INNER	125mm
EXTERNAL PERIMETER OUTER	256mm
INTERNAL PERIMETER OUTER	83mm
OVERALL EXTERNAL PERIMETER	468mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW289100

	SPW650CT30
	SPW652CT30
Ixx ←	40.8522cm <sup>4</sup>
Iyy ↑	17.1353cm <sup>4</sup>

### EPS Insert





EPS Into Section	EPS001
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### 28mm C/Wall Glazing Spacer

ALUMINIUM INNER	SPW695
OVERALL EXTERNAL PERIMETER	126mm

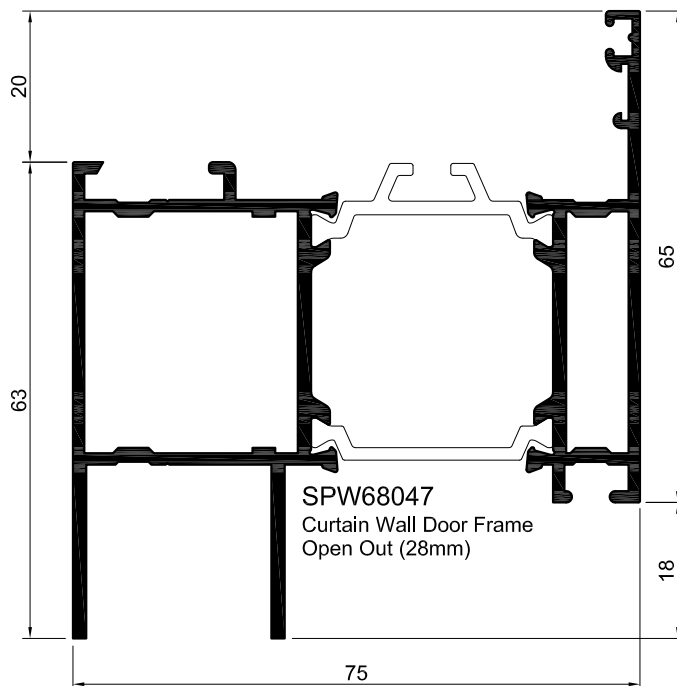
### Curtain Wall Door Frame Open Out (28mm)

ALUMINIUM INNER	SPW647
ALUMINIUM OUTER	SPW680
EXTERNAL PERIMETER INNER	218mm
INTERNAL PERIMETER INNER	82mm
EXTERNAL PERIMETER OUTER	282mm
INTERNAL PERIMETER OUTER	124mm
OVERALL EXTERNAL PERIMETER	470mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW939700

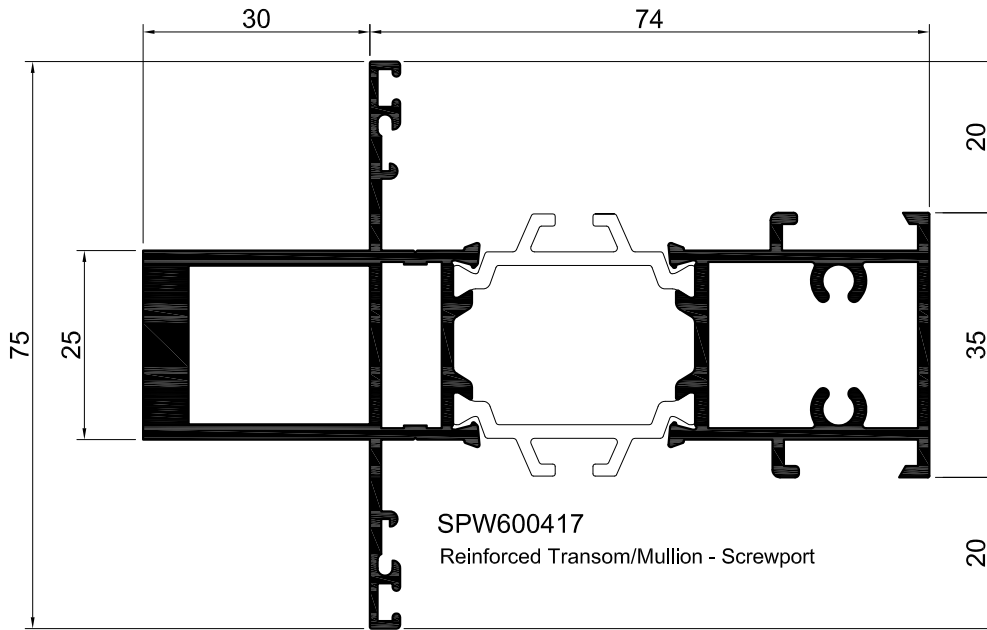
	PV02A
	PH05A
	SW446CT28
	SW446CT8
Ixx ←	46.7002cm <sup>4</sup>
Iyy ↑	17.5336cm <sup>4</sup>

### EPS Insert

EPS Into Section	EPS001
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Please Note Suffix "A" On Tooling Code Indicates Inverted Knives



**Reinforced Mullion/Transom - Screwport**

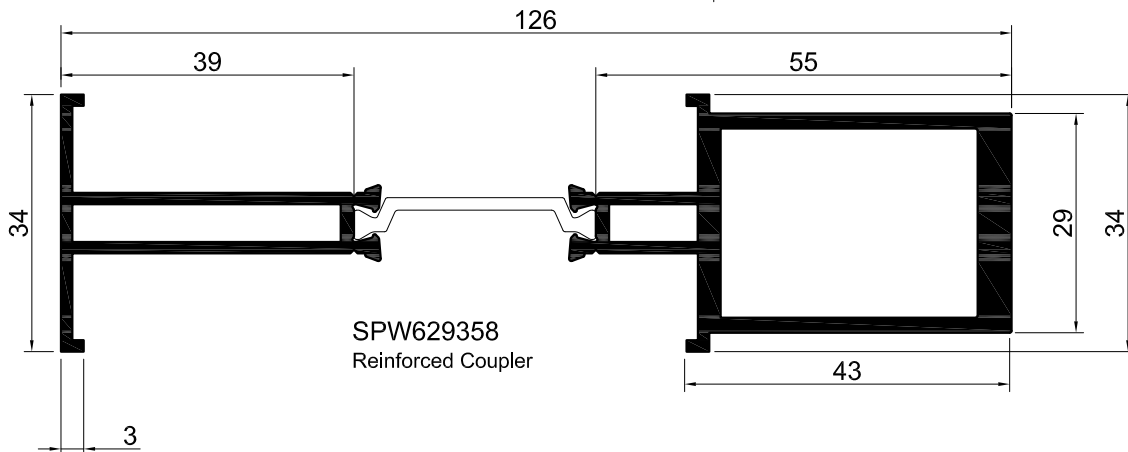
ALUMINIUM INNER	SPW617
ALUMINIUM OUTER	SPW6004
EXTERNAL PERIMETER INNER	194mm
INTERNAL PERIMETER INNER	138mm
EXTERNAL PERIMETER OUTER	320mm
INTERNAL PERIMETER OUTER	130mm
OVERALL EXTERNAL PERIMETER	527mm
POLYAMIDE UPPER	PAW289100
POLYAMIDE LOWER	PAW289100
CHEVRONS	SW4CH7 CHEV7P

	SPW650CT21
Ixx ←	89.4000cm <sup>4</sup>
Iyy ↑	12.6295cm <sup>4</sup>

<b>EPS Insert</b>	
EPS Into Section	EPS008

**Reinforced Coupler**

ALUMINIUM OUTER	SPW629
ALUMINIUM INNER	SPW358
EXTERNAL PERIMETER OUTER	171mm
INTERNAL PERIMETER OUTER	81mm
EXTERNAL PERIMETER INNER	203mm
INTERNAL PERIMETER INNER	118mm
OVERALL EXTERNAL PERIMETER	290mm
POLYAMIDE UPPER	PAW939700
Ixx ←	113.3932cm <sup>4</sup>
Iyy ↑	5.1255cm <sup>4</sup>

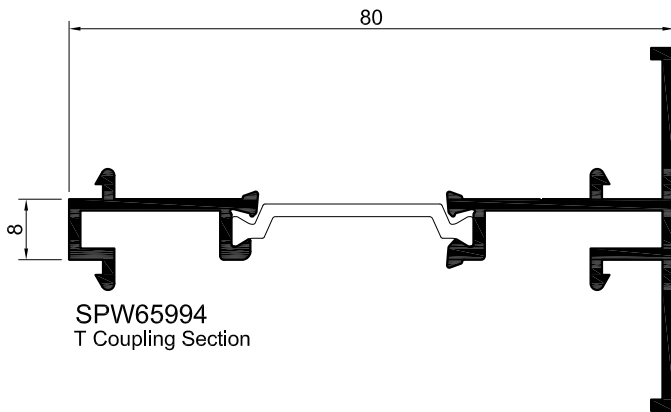


# SPW600e Door

# SPW600e.B.408

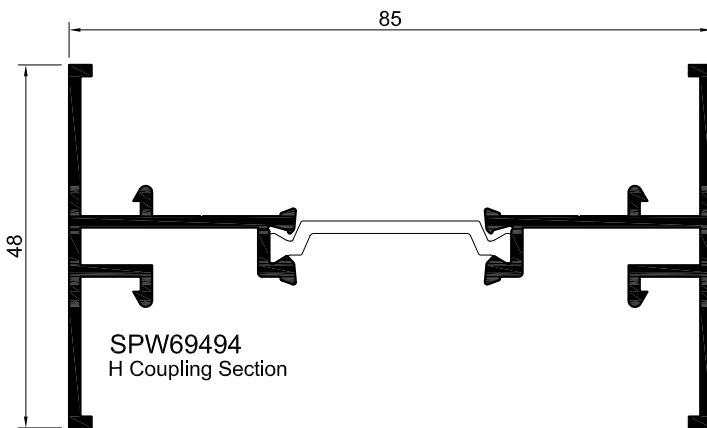
## Section Identification

04.12



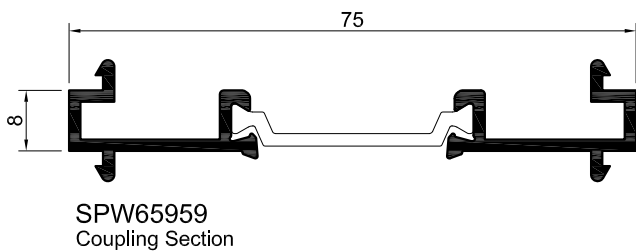
### T Coupling Section

ALUMINIUM INNER	SPW694
ALUMINIUM OUTER	SPW659
EXTERNAL PERIMETER INNER	130mm
EXTERNAL PERIMETER OUTER	225mm
OVERALL EXTERNAL PERIMETER	382mm
POLYAMIDE LOWER	PAW939700
$I_{xx}$ ←	22.2960cm <sup>4</sup>
$I_{yy}$ ↑	1.8482cm <sup>4</sup>



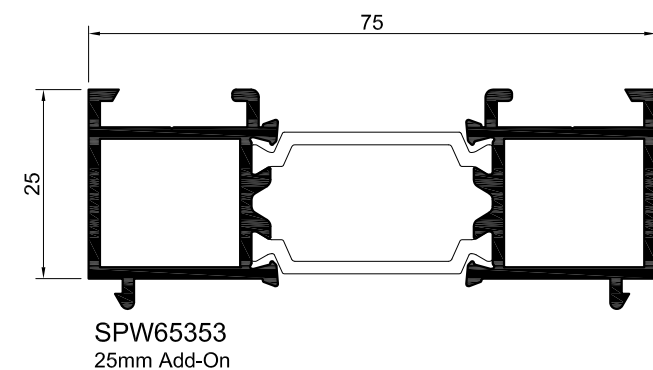
### H Coupling Section

ALUMINIUM INNER	SPW694
ALUMINIUM OUTER	SPW694
EXTERNAL PERIMETER INNER	130mm
EXTERNAL PERIMETER OUTER	130mm
OVERALL EXTERNAL PERIMETER	471mm
POLYAMIDE LOWER	PAW939700
$I_{xx}$ ←	40.6309cm <sup>4</sup>
$I_{yy}$ ↑	3.4880cm <sup>4</sup>



### Coupling Section

ALUMINIUM INNER	SPW659
ALUMINIUM OUTER	SPW659
EXTERNAL PERIMETER INNER	130mm
EXTERNAL PERIMETER OUTER	130mm
OVERALL EXTERNAL PERIMETER	270mm
POLYAMIDE LOWER	PAW939700

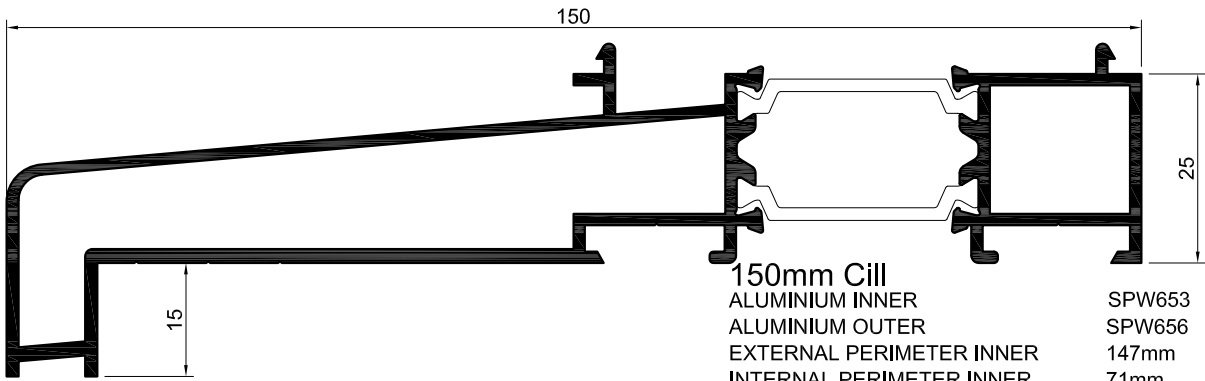


### 25mm Add-On

ALUMINIUM INNER	SPW653
ALUMINIUM OUTER	SPW653
EXTERNAL PERIMETER INNER	147mm
INTERNAL PERIMETER INNER	71mm
EXTERNAL PERIMETER OUTER	147mm
INTERNAL PERIMETER OUTER	71mm
OVERALL EXTERNAL PERIMETER	265mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700
$I_{xx}$ ←	24.4084cm <sup>4</sup>
$I_{yy}$ ↑	2.5396cm <sup>4</sup>

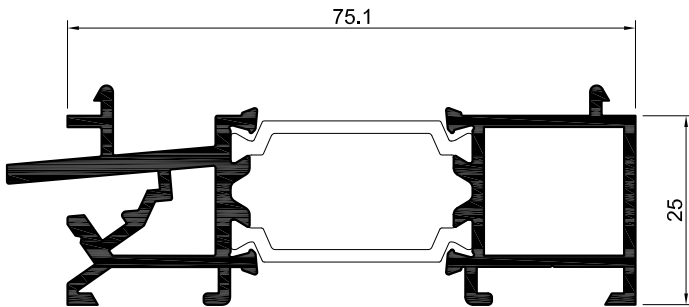
### EPS Insert

EPS Into Section	EPS004
------------------	--------



SPW65653  
150mm Cill

<b>150mm Cill</b>	
ALUMINIUM INNER	SPW653
ALUMINIUM OUTER	SPW656
EXTERNAL PERIMETER INNER	147mm
INTERNAL PERIMETER INNER	71mm
EXTERNAL PERIMETER OUTER	342mm
INTERNAL PERIMETER OUTER	238mm
OVERALL EXTERNAL PERIMETER	460mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700



SPW68553  
Drainage Cill

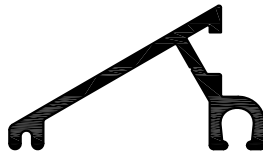
<b>EPS Insert</b>	
EPS Into Section	EPS004

<b>Drainage Cill</b>	
ALUMINIUM INNER	SPW653
ALUMINIUM OUTER	SPW685
EXTERNAL PERIMETER INNER	147mm
INTERNAL PERIMETER INNER	71mm
EXTERNAL PERIMETER OUTER	165mm
INTERNAL PERIMETER OUTER	48mm
OVERALL EXTERNAL PERIMETER	283mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700

<b>EPS Insert</b>	
EPS Into Section	EPS004



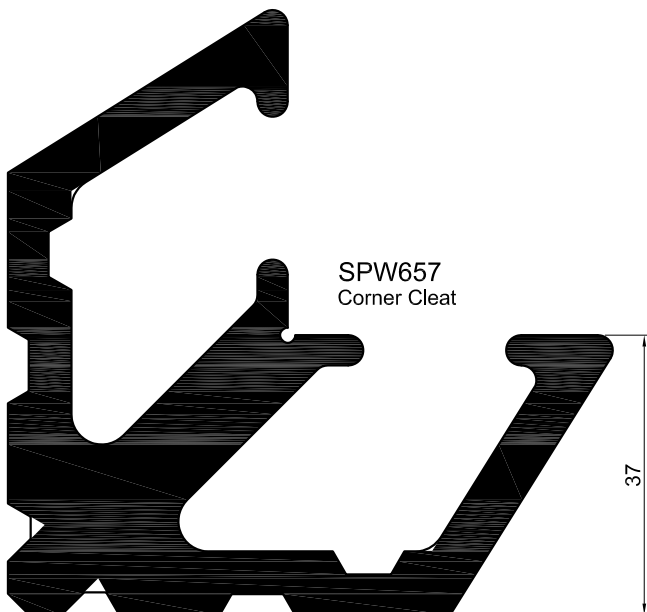
SD557  
Brush Seal Carrier  
EXTERNAL PERIMETER 75mm



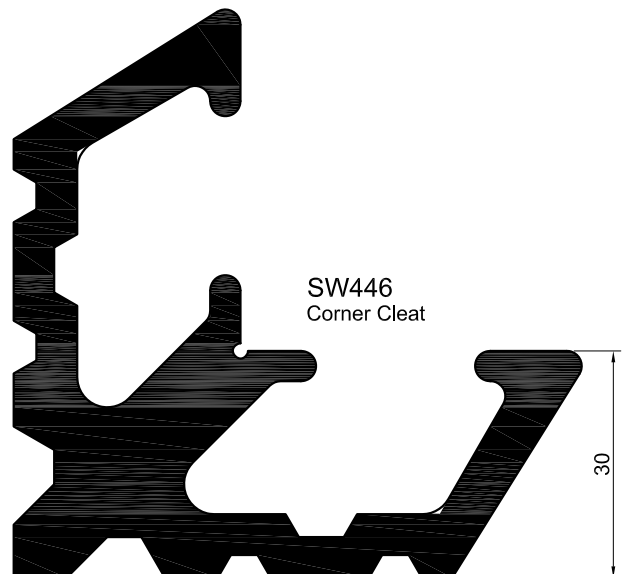
SPW664  
Door Sealed Drip Bar  
EXTERNAL PERIMETER 131mm



SXTW216  
Drip Section  
EXTERNAL PERIMETER 88mm



SPW657  
Corner Cleat



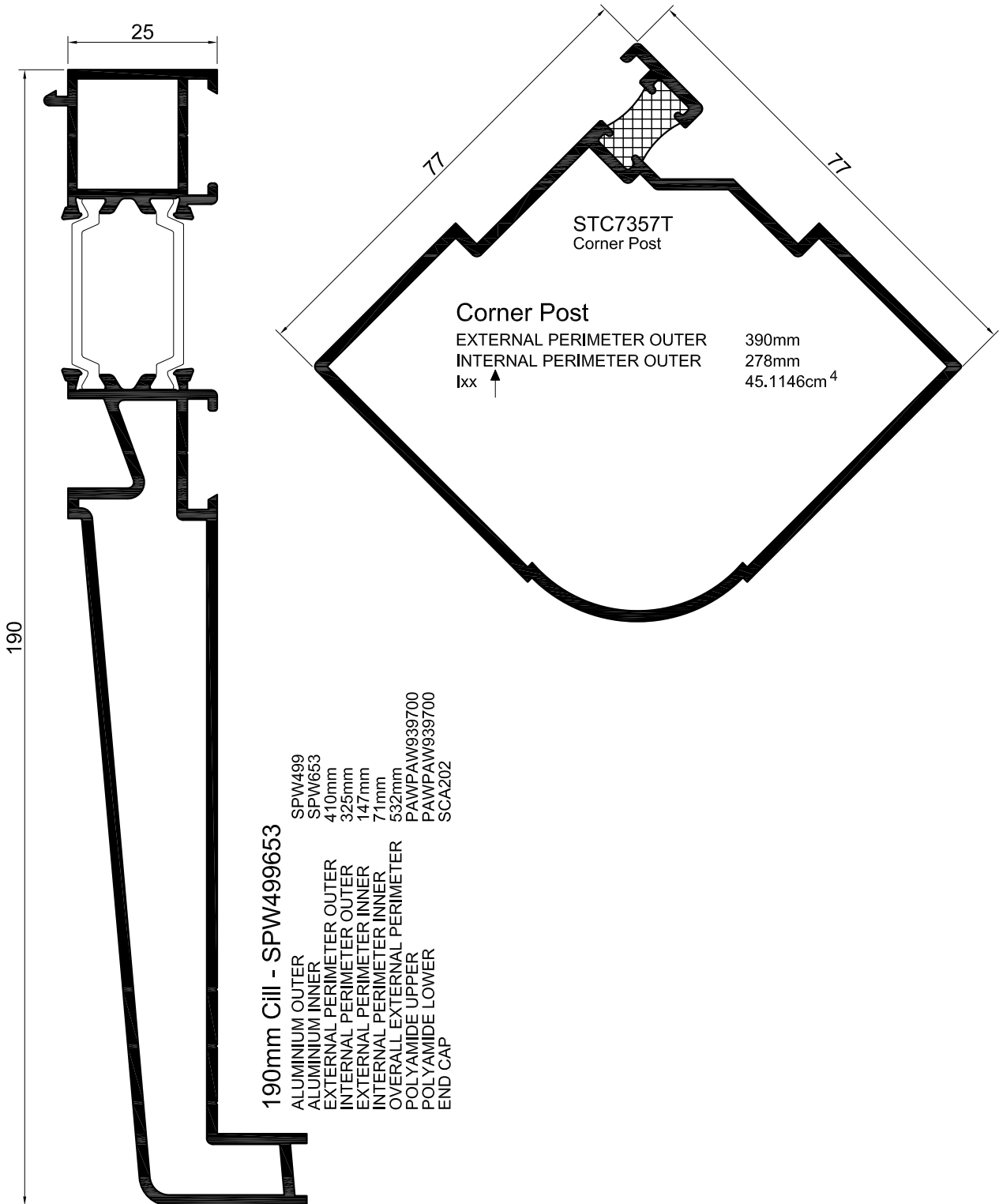
SW446  
Corner Cleat

# SPW600e Door

## Section Identification

SPW600e.B.410

04.12

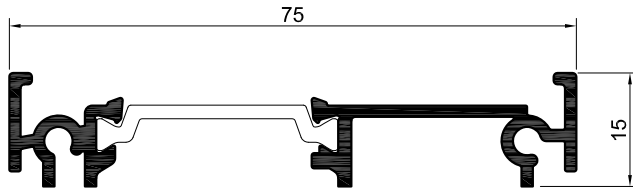


# SPW600e.B.411

04.12

# SPW600e Door

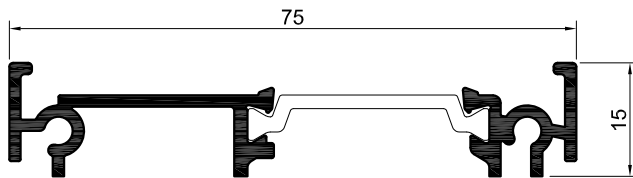
## Section Identification



**SPW66170**  
Low Threshold  
Open In

### Low Threshold

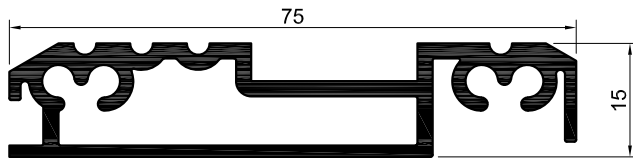
ALUMINIUM INNER	SPW670
ALUMINIUM OUTER	SPW661
EXTERNAL PERIMETER INNER	150mm
EXTERNAL PERIMETER OUTER	99mm
OVERALL EXTERNAL PERIMETER	289mm
POLYAMIDE UPPER	PAW939700



**SPW67061**  
Low Threshold  
Open Out

### Low Threshold Open Out

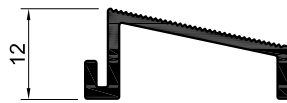
ALUMINIUM INNER	SPW661
ALUMINIUM OUTER	SPW670
EXTERNAL PERIMETER INNER	150mm
EXTERNAL PERIMETER OUTER	99mm
OVERALL EXTERNAL PERIMETER	289mm
POLYAMIDE UPPER	PAW939700



**SPW684**  
Commercial Threshold

### Commercial Threshold

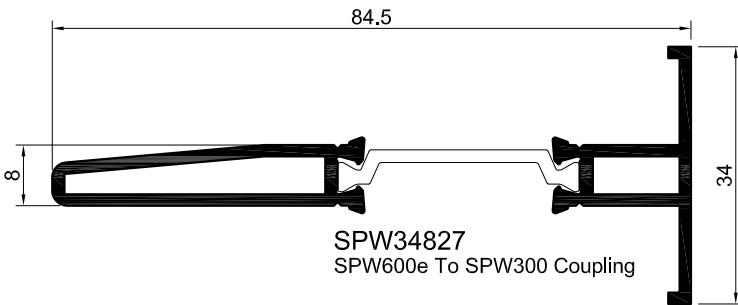
ALUMINIUM INNER	SPW684
OVERALL EXTERNAL PERIMETER	256mm
OVERALL INTERNAL PERIMETER	137mm



**SPW663**  
Low Threshold Ramp

### Low Threshold Ramp

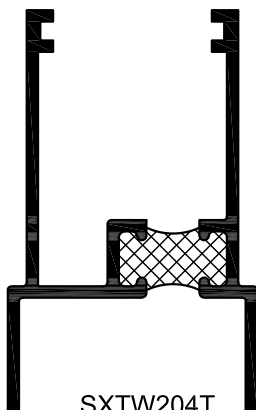
OVERALL EXTERNAL PERIMETER	77mm
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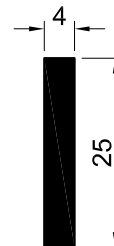
**SPW34827**  
SPW600e To SPW300 Coupling

### SPW600e To SPW300 Coupling

ALUMINIUM INNER	SPW327
ALUMINIUM OUTER	SPW348
EXTERNAL PERIMETER INNER	123mm
EXTERNAL PERIMETER OUTER	107mm
INTERNAL PERIMETER INNER	33mm
INTERNAL PERIMETER OUTER	77mm
OVERALL EXTERNAL PERIMETER	250mm
POLYAMIDE	PAW939700
I <sub>xx</sub>	23.1173cm <sup>4</sup>
I <sub>yy</sub>	0.7849m <sup>4</sup>



**SXTW204T**  
28mm Vent Carrier  
EXTERNAL PERIMETER 322mm



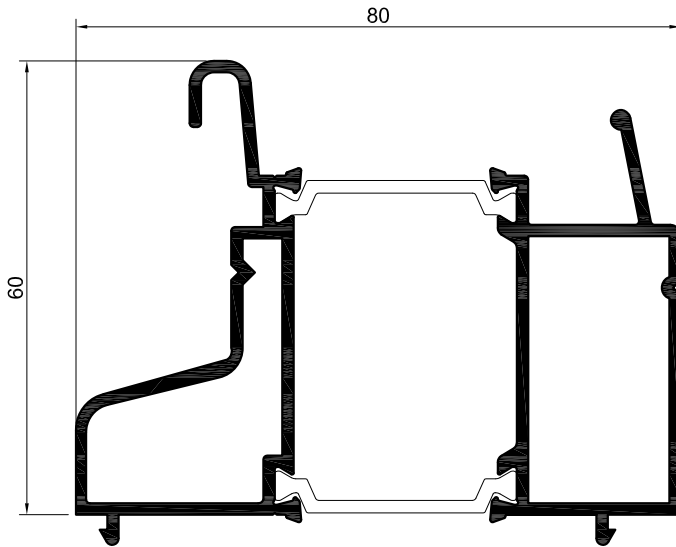
**SAE25X4**  
Georgian Bar  
EXTERNAL PERIMETER 58mm

# SPW600e Door

## Section Identification

SPW600e.B.412

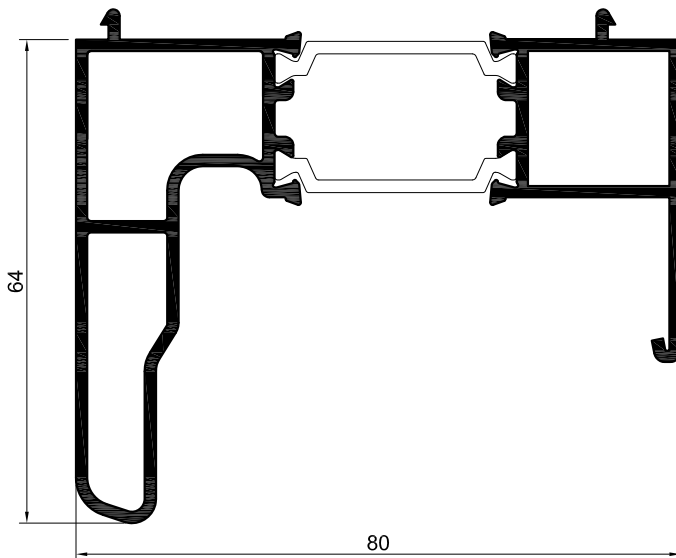
04.12



SPW67173  
Kingspan  
80mm Head Adaptor

### Kingspan 80mm Head Adaptor

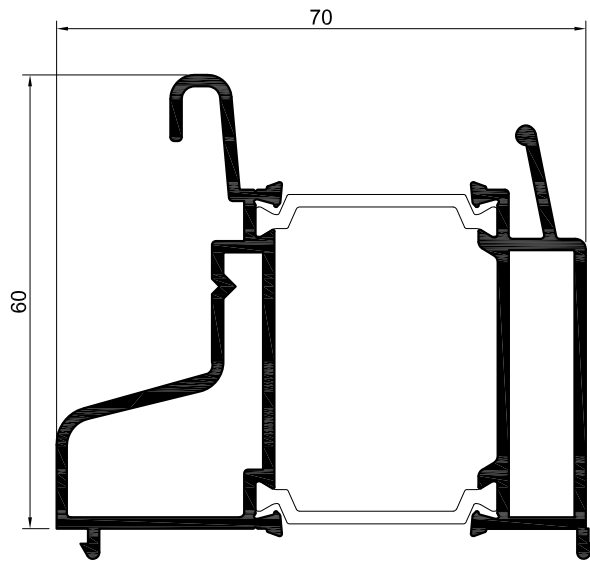
ALUMINIUM INNER	SPW673
ALUMINIUM OUTER	SPW671
EXTERNAL PERIMETER INNER	203mm
INTERNAL PERIMETER INNER	108mm
EXTERNAL PERIMETER OUTER	231mm
INTERNAL PERIMETER OUTER	115mm
OVERALL EXTERNAL PERIMETER	363mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700



SPW67476  
Kingspan  
80mm Cill Adaptor

### Kingspan 80mm Cill Adaptor

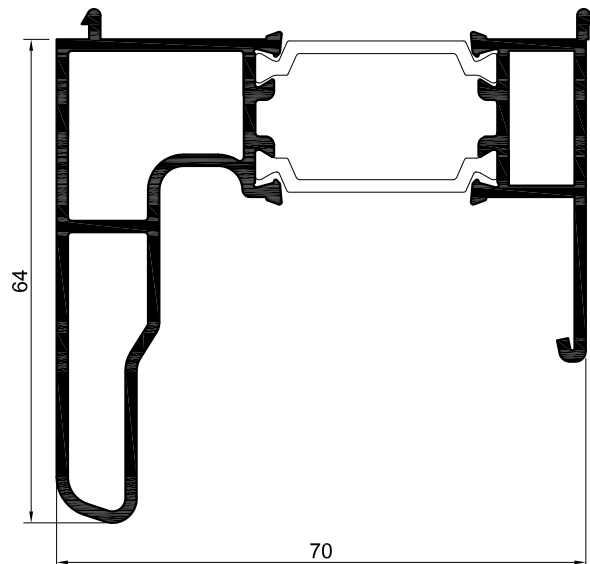
ALUMINIUM INNER	SPW676
ALUMINIUM OUTER	SPW674
EXTERNAL PERIMETER INNER	171mm
INTERNAL PERIMETER INNER	71mm
EXTERNAL PERIMETER OUTER	215mm
INTERNAL PERIMETER OUTER	181mm
OVERALL EXTERNAL PERIMETER	377mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700



SPW67172  
Kingspan  
70mm Head Adaptor

### Kingspan 70mm Head Adaptor

ALUMINIUM INNER	SPW672
ALUMINIUM OUTER	SPW671
EXTERNAL PERIMETER INNER	212mm
INTERNAL PERIMETER INNER	108mm
EXTERNAL PERIMETER OUTER	231mm
INTERNAL PERIMETER OUTER	112mm
OVERALL EXTERNAL PERIMETER	344mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700



SPW67475  
Kingspan  
70mm Cill Adaptor

### Kingspan 70mm Cill Adaptor

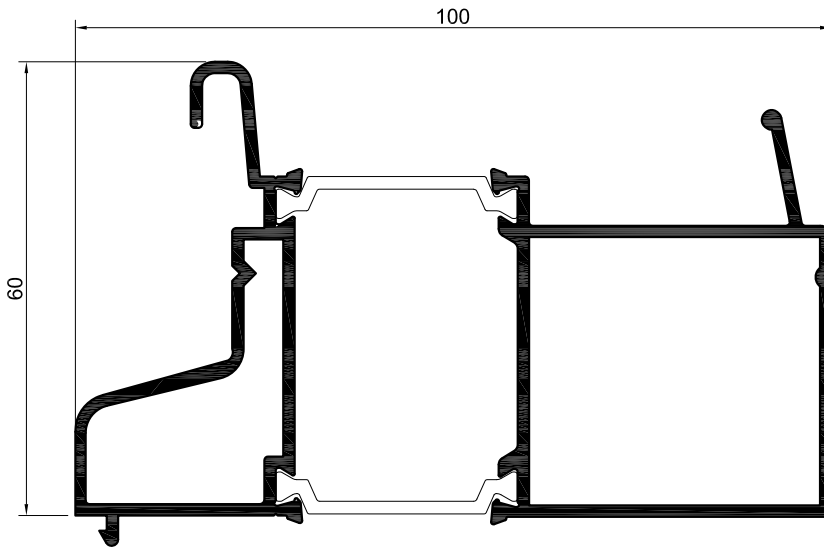
ALUMINIUM INNER	SPW675
ALUMINIUM OUTER	SPW674
EXTERNAL PERIMETER INNER	152mm
INTERNAL PERIMETER INNER	51mm
EXTERNAL PERIMETER OUTER	215mm
INTERNAL PERIMETER OUTER	181mm
OVERALL EXTERNAL PERIMETER	347mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700

# SPW600e Door

## Section Identification

SPW600e.B.414

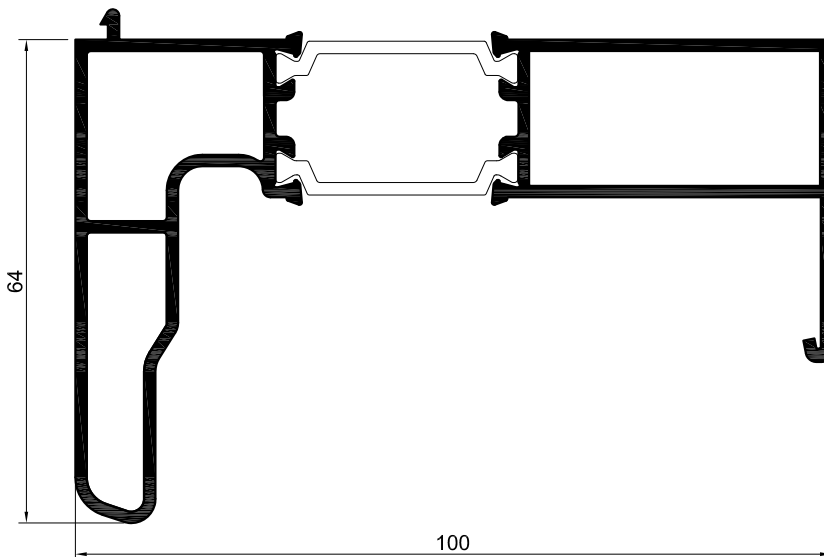
04.12



### Kingspan 100mm Head Adaptor

ALUMINIUM INNER	SPW382
ALUMINIUM OUTER	SPW671
EXTERNAL PERIMETER INNER	232mm
INTERNAL PERIMETER INNER	148mm
EXTERNAL PERIMETER OUTER	231mm
INTERNAL PERIMETER OUTER	115mm
OVERALL EXTERNAL PERIMETER	403mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700

SPW671382  
Kingspan  
100mm Head Adaptor



### Kingspan 100mm Cill Adaptor

ALUMINIUM INNER	SPW381
ALUMINIUM OUTER	SPW674
EXTERNAL PERIMETER INNER	202mm
INTERNAL PERIMETER INNER	112mm
EXTERNAL PERIMETER OUTER	215mm
INTERNAL PERIMETER OUTER	181mm
OVERALL EXTERNAL PERIMETER	417mm
POLYAMIDE UPPER	PAW939700
POLYAMIDE LOWER	PAW939700

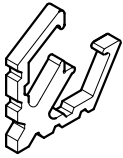
SPW674381  
Kingspan  
100mm Cill Adaptor

# SPW600e.C.401

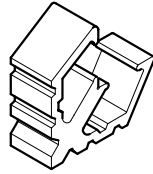
01.13

# SPW600e Door

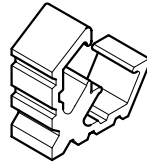
## Accessories



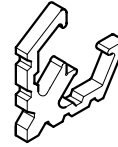
**SPW657CT8**  
Cut Corner Cleat



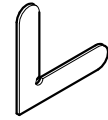
**SPW657CT28**  
Cut Corner Cleat



**SW446CT28**  
Cut Corner Cleat



**SW446CT8**  
Cut Corner Cleat



**SW4CH7**  
7mm Corner Chevron

**SFSPS1045**  
#10x45Lg P/Hd ST SS



**SFSCS1025**

Lock Screws  
#10x25Lg Csk ST SS



**SFSPS05**  
#10x19Lg P/Hd  
Self Tapping Screw



**SWTP**  
2Dia.x12Lg  
Celloc Pin

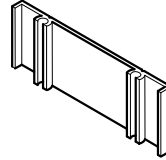


**SFSCS850**

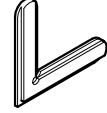
#8x50Lg Csk  
Self Tapping Screw



**SPW677CUT**  
Shear Block



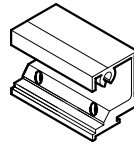
**SPW679CUT**  
Shear Block



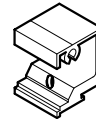
**CHEV7P**  
7mm Corner Chevron  
Plastic

**SFSGM37**

M5x10Lg Grub  
Screw Cone Point



**SPW352CT58**  
Shear Block



**SPW352CT31**  
Shear Block



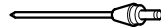
**SFSPS28**  
#8 x 12Lg  
P/HD Self Tapping Screw

**SPSPM36**  
M4x5Lg M/C Screw



**SFSCS1065**

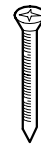
Lock Screws  
#10x65Lg Csk ST SS



**SWWBS**  
Weatherbar Stud Rivet  
for SXTW216



**SPW650CT66**  
Shear Block



**SFSCS1038**  
#10 x 38LG  
C/Sk Self Tapping Screw

**SPW650CT30**  
Shear Block

**SH050428LLW**  
Lever/Lever Furniture - White

**SH050420LLN**  
Lever/Lever Furniture - Silver

**SH050427LLB**  
Lever/Lever Furniture - Black

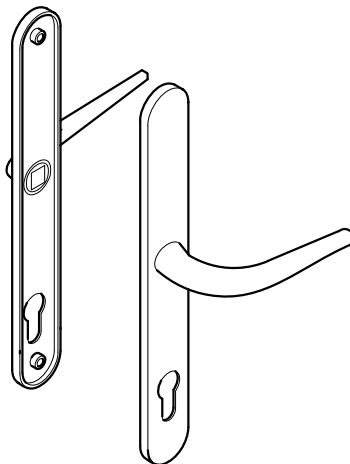
**SH050421LLC**  
Lever/Lever Furniture - Chrome

**SH050438LPW**  
Lever/Pad Furniture - White

**SH050430LPN**  
Lever/Pad Furniture - Silver

**SH050437LPB**  
Lever/Pad Furniture - Black

**SH050431LPC**  
Lever/Pad Furniture - Chrome



**S2671692**

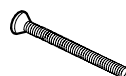
Security - Lever/Lever Furniture - Black

**S2671668**

Security - Lever/Lever Furniture - Silver

**S2671684**

Security - Lever/Lever Furniture - White



**SP690W**

90mm Standard Handle Fixing - White

**SP690B**

90mm Standard Handle Fixing - Black

**SP690S**

90mm Standard Handle Fixing - Standard



**M6X90MM**

90mm Security Handle Fixing - Silver

**M6X90MMB**

90mm Security Handle Fixing - Black

**M6X90MMW**

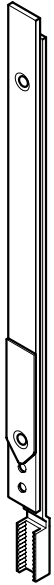
90mm Security Handle Fixing - White

# SPW600e Door

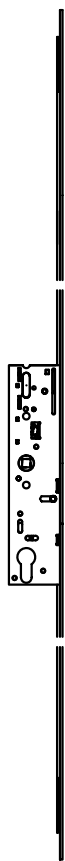
SPW600e.C.402

02.14

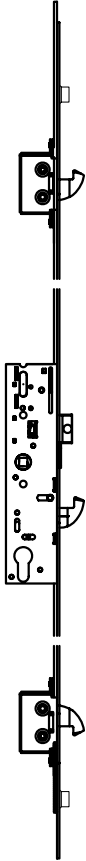
## Accessories



**SBE19**  
Slave Door Lock Shoot Bolt  
Extension (For Use On Doors  
With Sash Rebates Heights  
Of 2230mm And Above.)



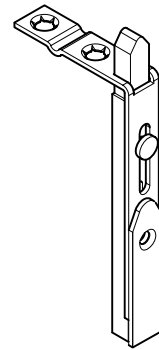
**SYSDL35B**  
Slave Door Lock



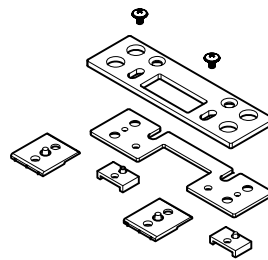
**SYMDL35B**  
35mm Back Set  
3 Point Hook Lock



**SY1PKLH3**  
L/Hand One Piece Keep  
**SY1PKRH3**  
R/Hand One Piece Keep

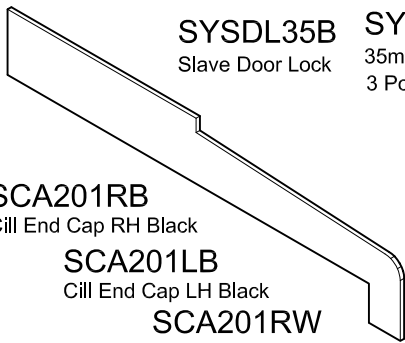


**SB100**  
Slave Door Lock  
Shoot Bolt



**SYKP101**  
Shoot Bolt Keep Set Complete

L/Hand One Piece Keep shown.  
R/Hand One Piece Keep Opposite Hand

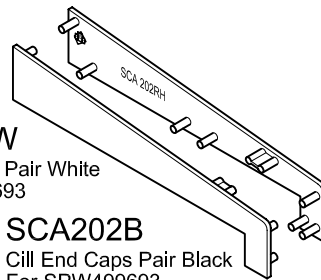


**SCA201RB**  
Cill End Cap RH Black

**SCA201LB**  
Cill End Cap LH Black

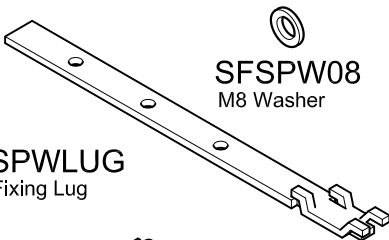
**SCA201RW**  
Cill End Cap RH White

**SCA201LW**  
Cill End Cap LH White



**SCA202W**  
Cill End Caps Pair White  
For SPW499693

**SCA202B**  
Cill End Caps Pair Black  
For SPW499693



**SPWLUG**  
Fixing Lug



**SFSPW08**  
M8 Washer



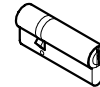
**SFSSM32**  
M8x50LG.SKT. HD.



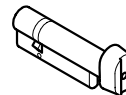
**SFSLN08**  
M8 Lock Nut



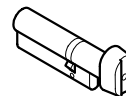
**SPWTRC**  
Connecting Sleeve



**SP7030**  
Yale Cylinder & 3 Keys



**SP7030TT00**  
Thumb Turn Outward Open

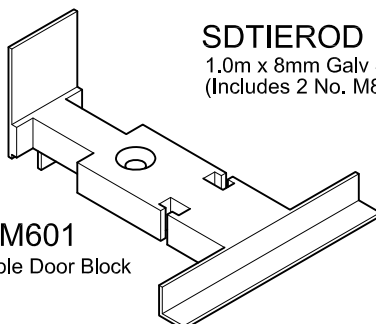


**SP7030TT0I**  
Thumb Turn Inward Open



**SW4D**  
Drain Hole Cover Black

**SW4DW**  
Drain Hole Cover White

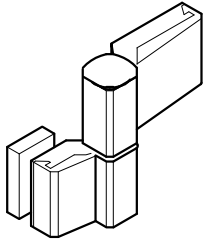


**SDTIEROD**  
1.0m x 8mm Galv Steel Tie Rod  
(Includes 2 No. M8 Nyloc Nuts)

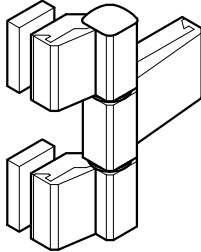


**SP7030AB**  
Yale Cylinder & 3 Keys  
Security/Anti-Bump

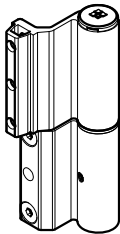
**SPM601**  
Double Door Block



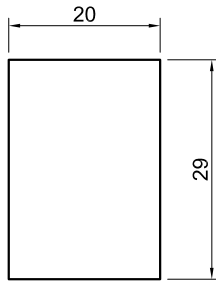
Reference	Description	Finish
SPWM	2 Part Knuckle Hinge	Mill
SPWN	2 Part Knuckle Hinge	Natural Anodised
SPWW	2 Part Knuckle Hinge	White Powder Coated
SPWP	2 Part Knuckle Hinge	P/C



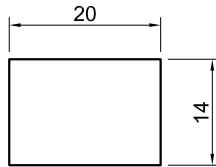
Reference	Description	Finish
SPW3M	3 Part Knuckle Hinge	Mill
SPW3N	3 Part Knuckle Hinge	Natural Anodised
SPW3W	3 Part Knuckle Hinge	White Powder Coated
SPW3P	3 Part Knuckle Hinge	P/C



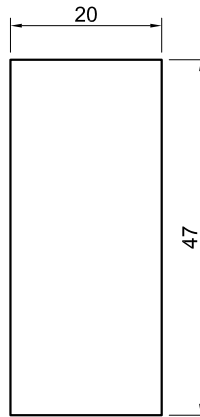
Reference	Description	Finish
SW2GDH0004	2 Part Clamp On Hinge	Mill
SW2GDH0001N	2 Part Clamp On Hinge	Silver
SW2GDH0003B	2 Part Clamp On Hinge	Black Powder Coated
SW2GDH0004P	2 Part Clamp On Hinge	P/C



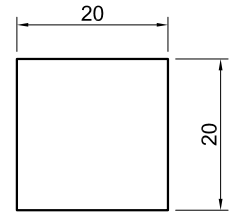
**EPS001**  
20mm x 29mm  
Foam Insert



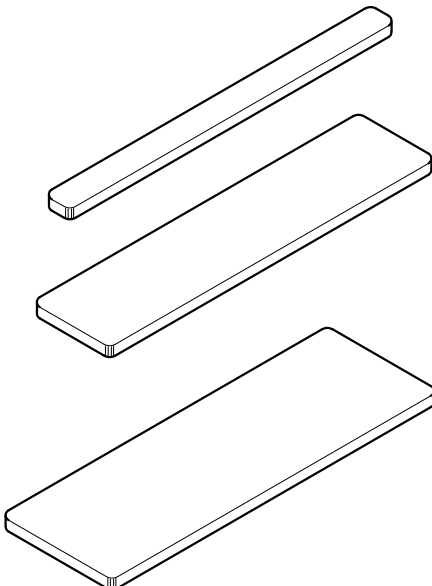
**EPS004**  
20mm x 14mm  
Foam Insert



**EPS007**  
20mm x 47mm  
Foam Insert



**EPS008**  
20mm x 20mm  
Foam Insert



**9mm DG Glass Packs**

SGP9x5mm 9mm x 100mm DG Glass Packer @ 5mm thick, Blue.

**28mm DG Glass Packs**

SGP28x1mm 28mm x 100mm DG Glass Packer @ 1mm thick, Green.  
 SGP28x2mm 28mm x 100mm DG Glass Packer @ 2mm thick, Black.  
 SGP28x3mm 28mm x 100mm DG Glass Packer @ 3mm thick, White.  
 SGP28x4mm 28mm x 100mm DG Glass Packer @ 4mm thick, Grey.  
 SGP28x5mm 28mm x 100mm DG Glass Packer @ 5mm thick, Blue.  
 SGP28x6mm 28mm x 100mm DG Glass Packer @ 6mm thick, Red.

**32mm DG Glass Packs**

SGP32x2mm 32mm x 100mm DG Glass Packer @ 2mm thick, Black.  
 SGP32x5mm 32mm x 100mm DG Glass Packer @ 5mm thick, Blue.

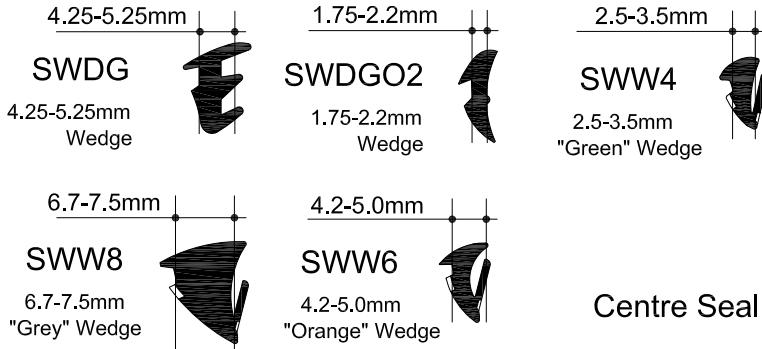
# SPW600e Door

SPW600e.C.404

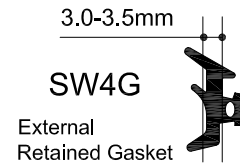
## Accessories

09.14

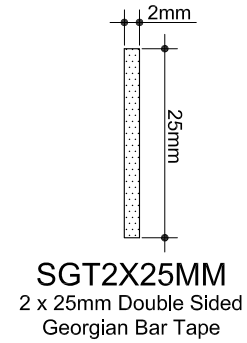
### Wedge Gaskets



### Captive Gasket

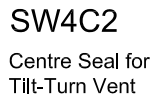


### Plant on Georgian Bar



NOTE: Sizes are nominal. Wedge gasket may need to accommodate tolerance in extrusion & glass units.

### Centre Seal

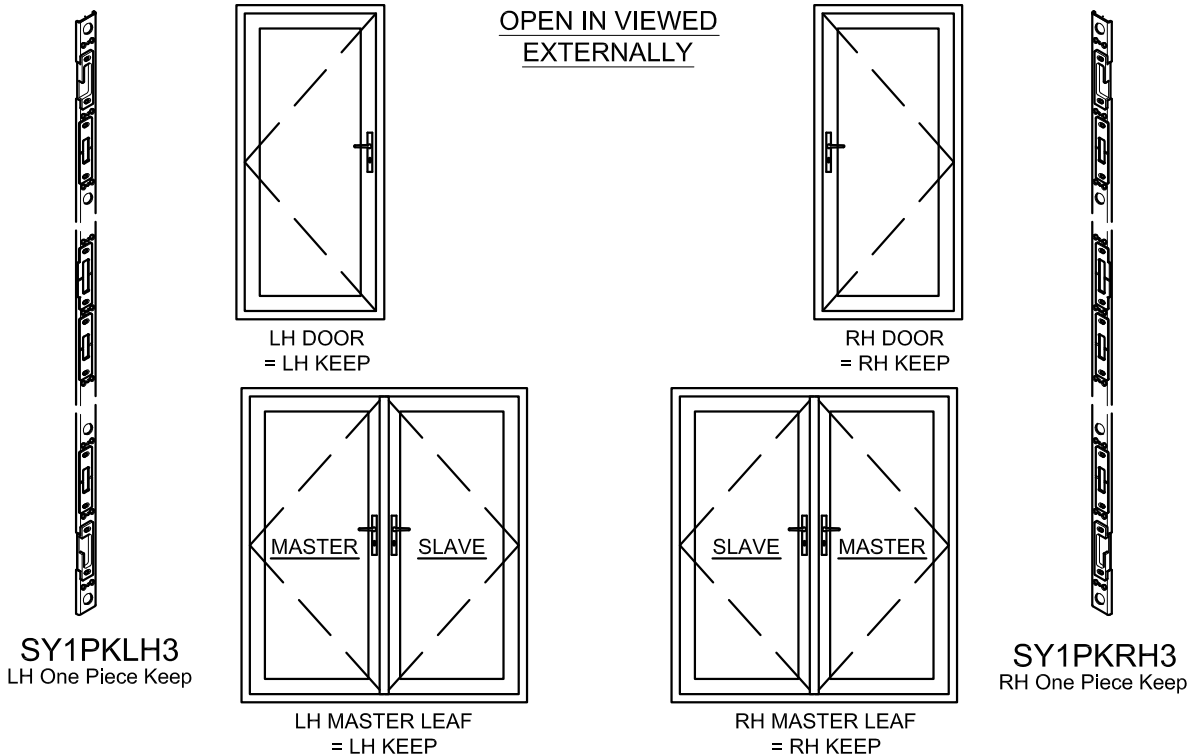
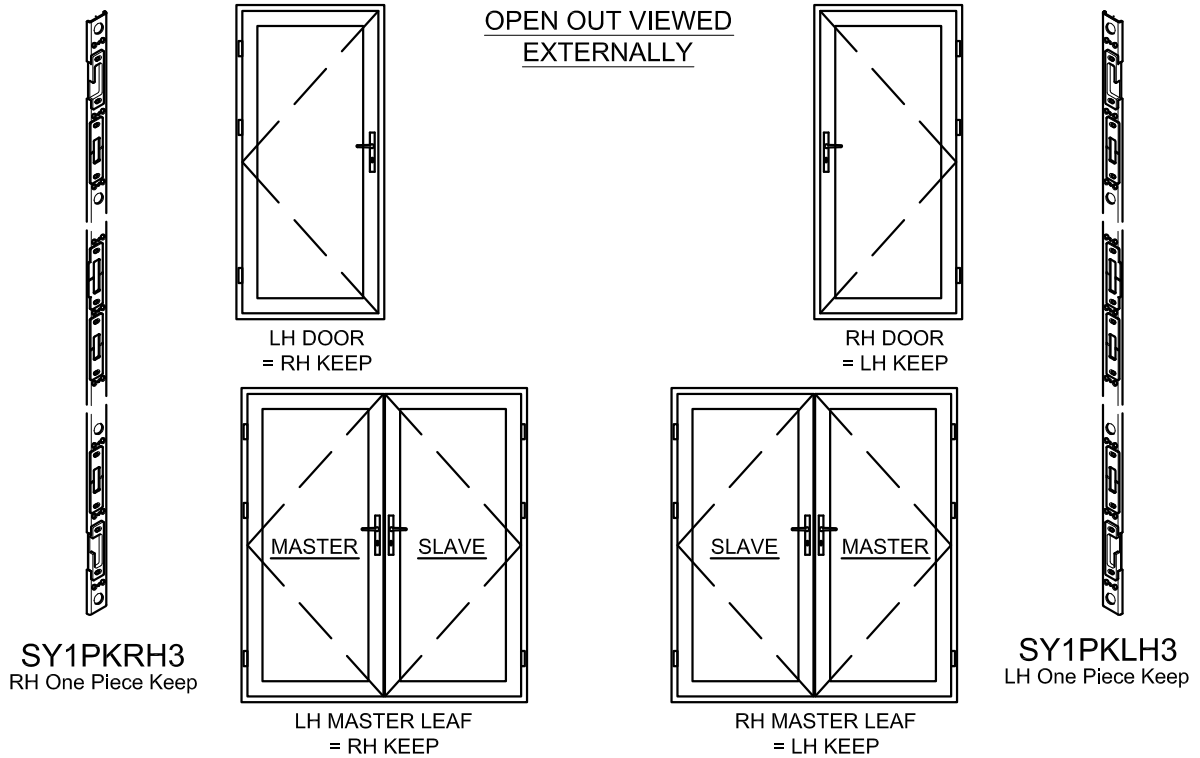


### 'Glazed In' SPW600e Outer Frames and Vents

Glass Thickness(mm)	Glazing Space	Bead Reference	Wedge Internal	Captive External
28.0	36.0	SPW643	SWDG	SW4G
30.0	38.5	†SW463	SWDG	SW4G
32.0	40.0	SPW624	SWDG	SW4G
36.0	44.0	†SW467	SWDG	SW4G
44.0	52.0	†SW462	SWDG	SW4G
48.0	56.0	†SW461	SWDG	SW4G
52.0	60.0	†SW464	SWDG	SW4G
56.0	64.0	†SW476	SWDG	SW4G

† Non Standard Beads May Not Be Available - Check With SAS  
Check Hardware Suitability When Using Heavy Glazing Panels

## One Piece Keep Handing - Open Out & Open In



# SPW600e Door

Blank

SPW600e.C.406

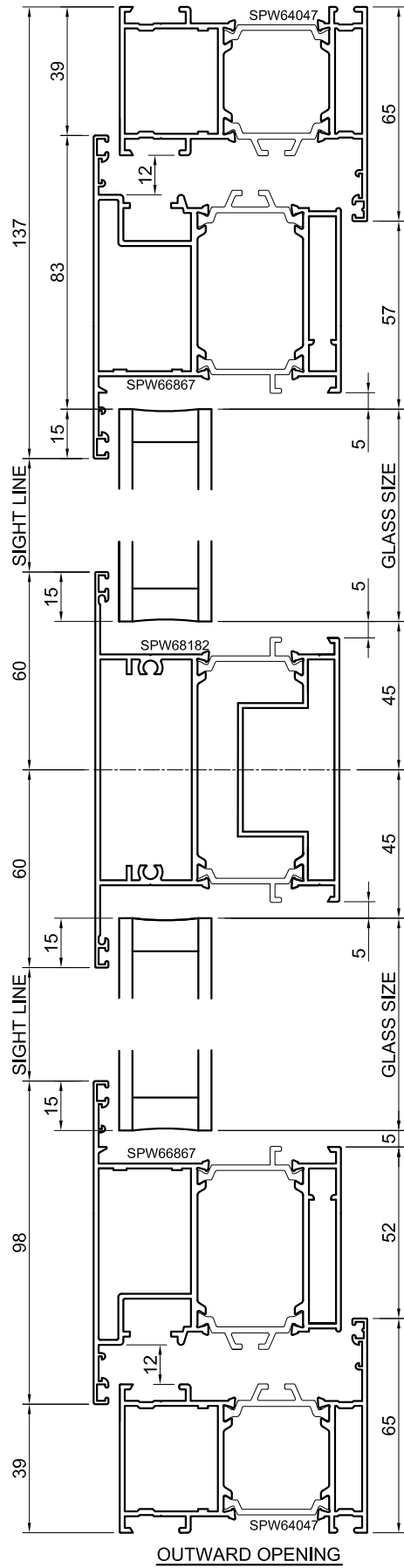
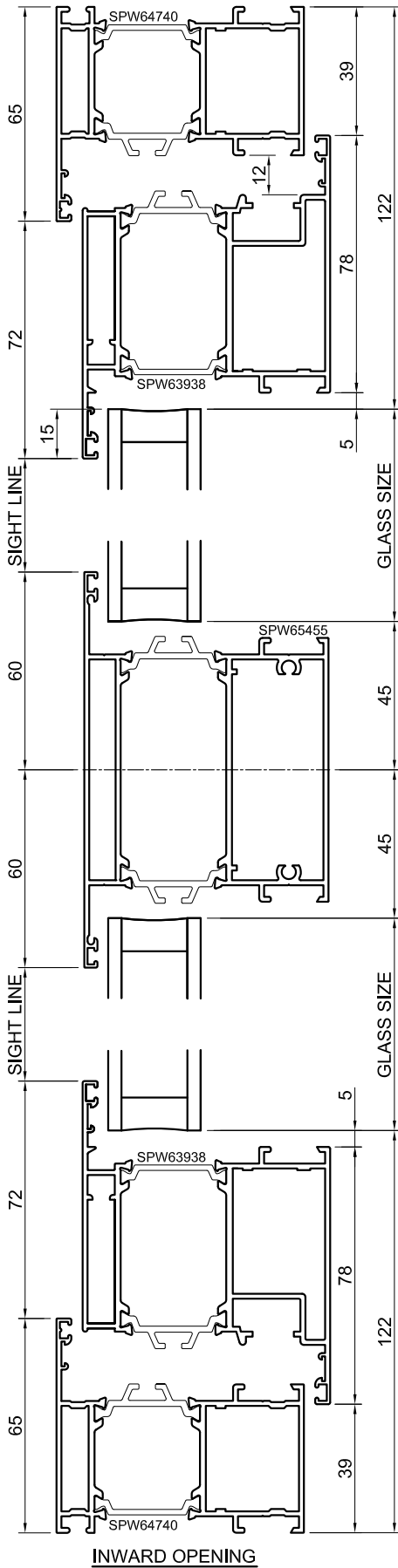
10.14

# SPW600e.D.401

04.12

# SPW600e Door

## Deductions- Frame And Glass

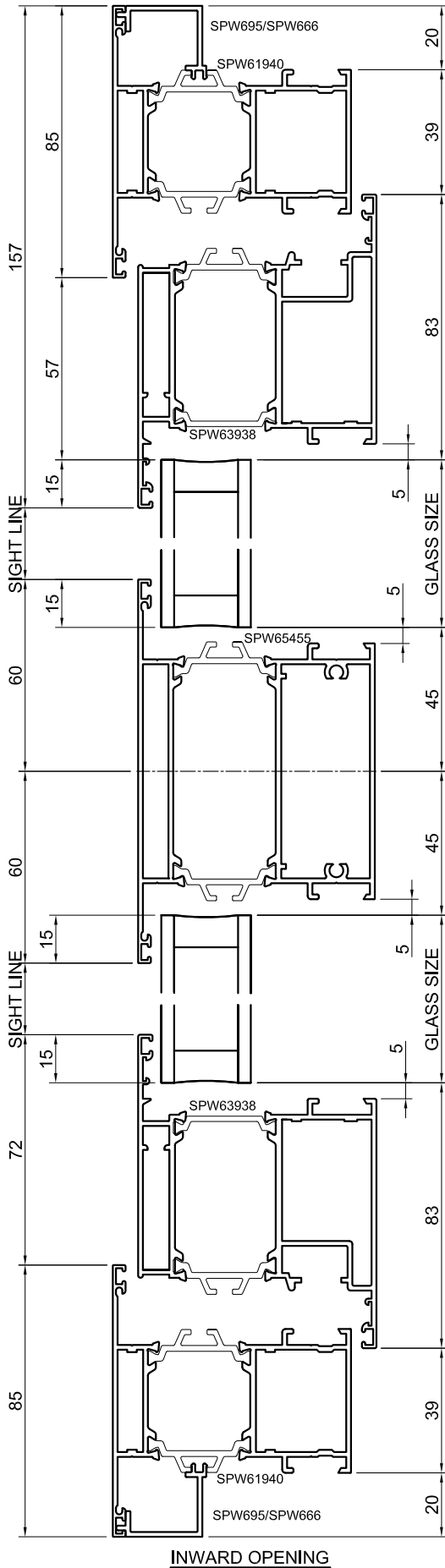


# SPW600e Door

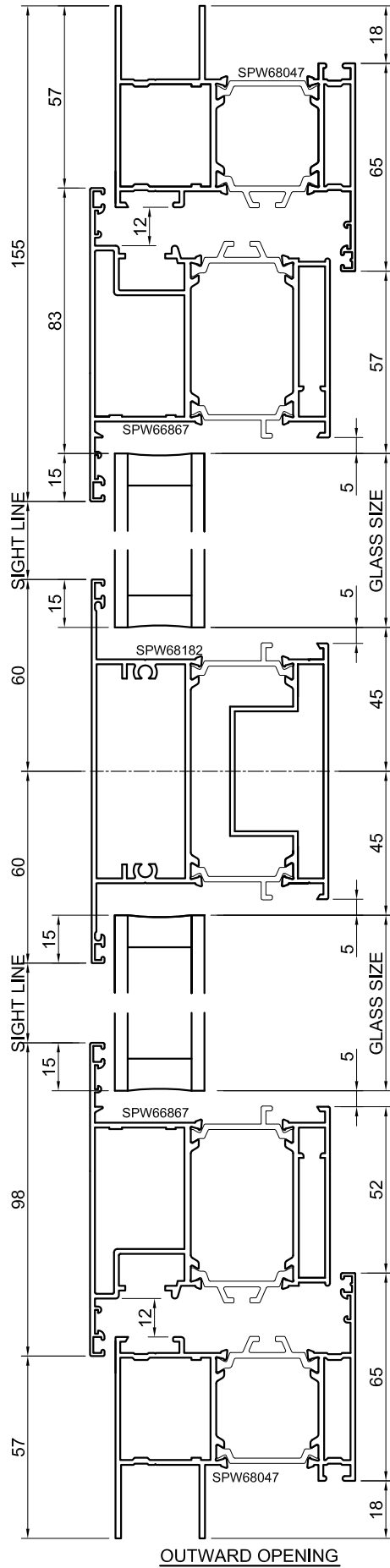
## Deductions- Frame And Glass

# SPW600e.D.402

04.12



INWARD OPENING



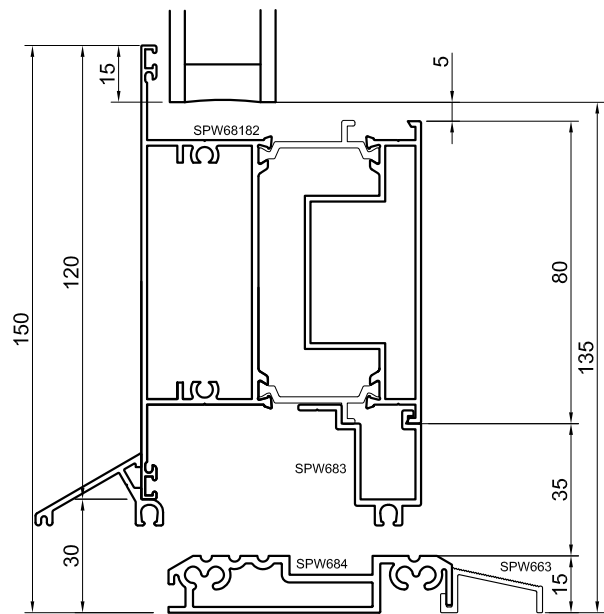
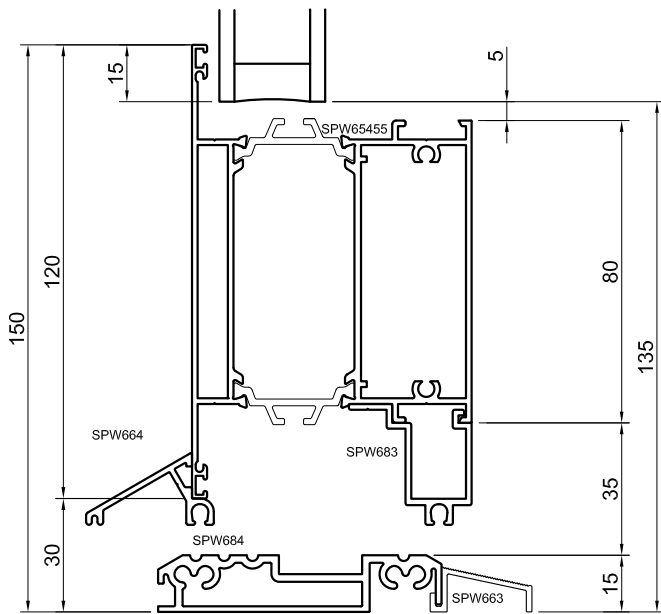
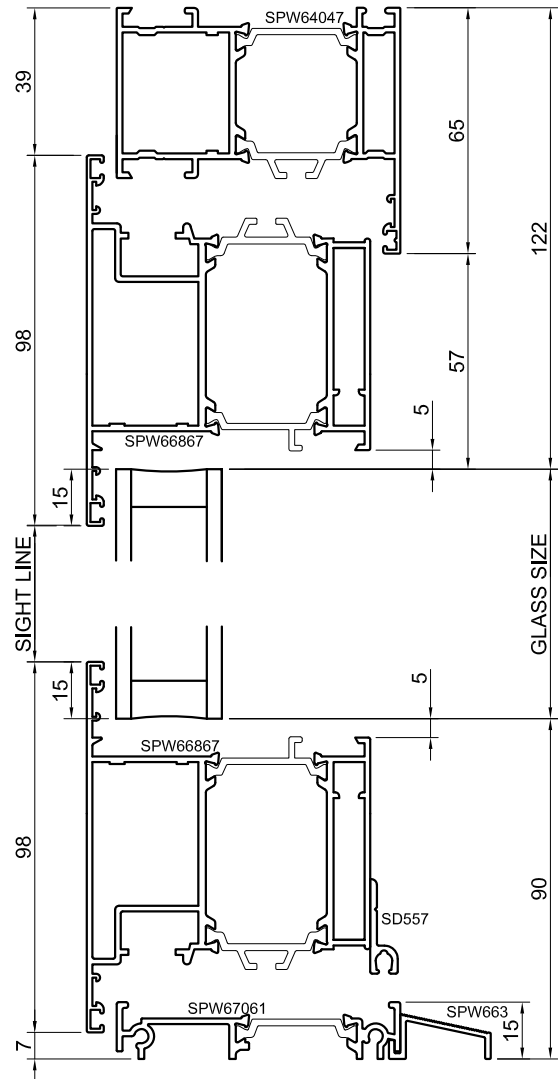
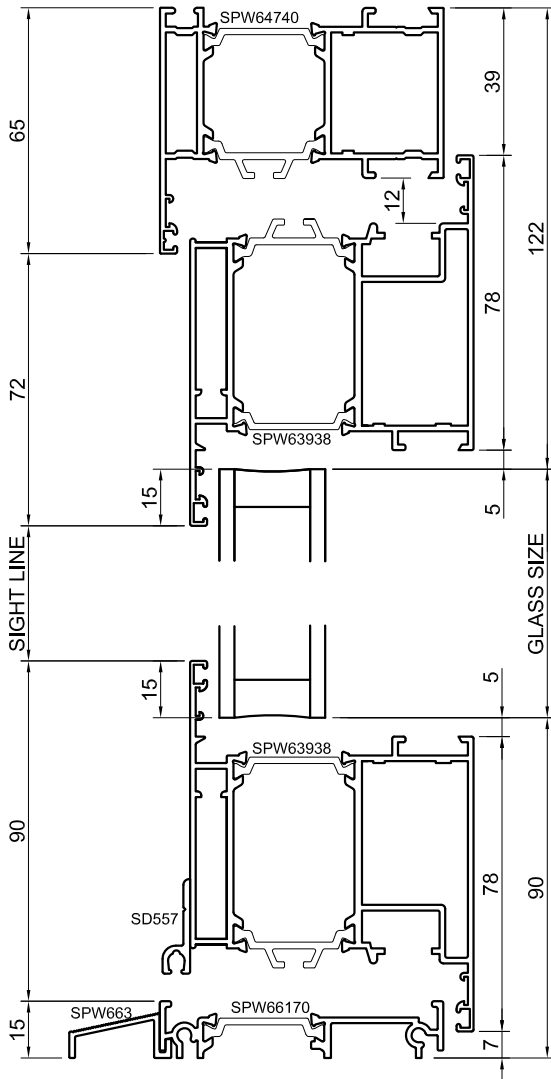
OUTWARD OPENING

# SPW600e.D.403

04.12

# SPW600e Door

## Deductions - Frame And Glass



INWARD OPENING

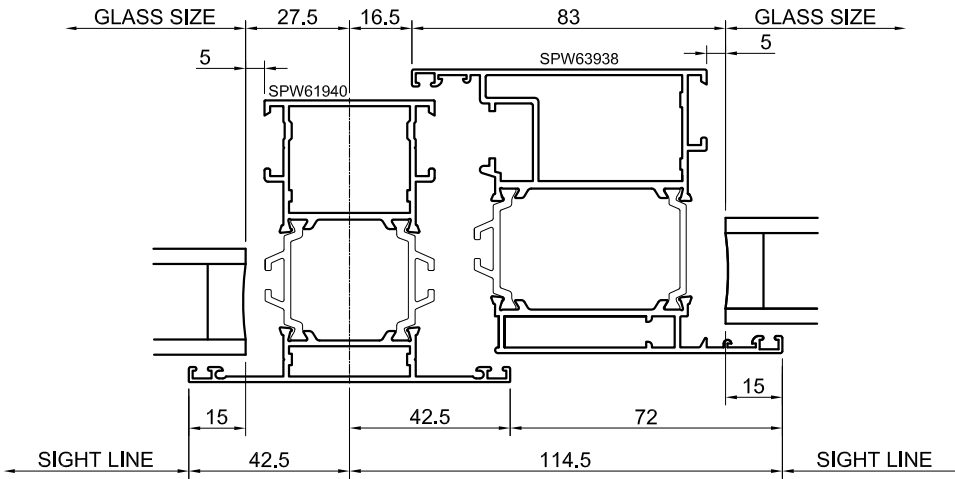
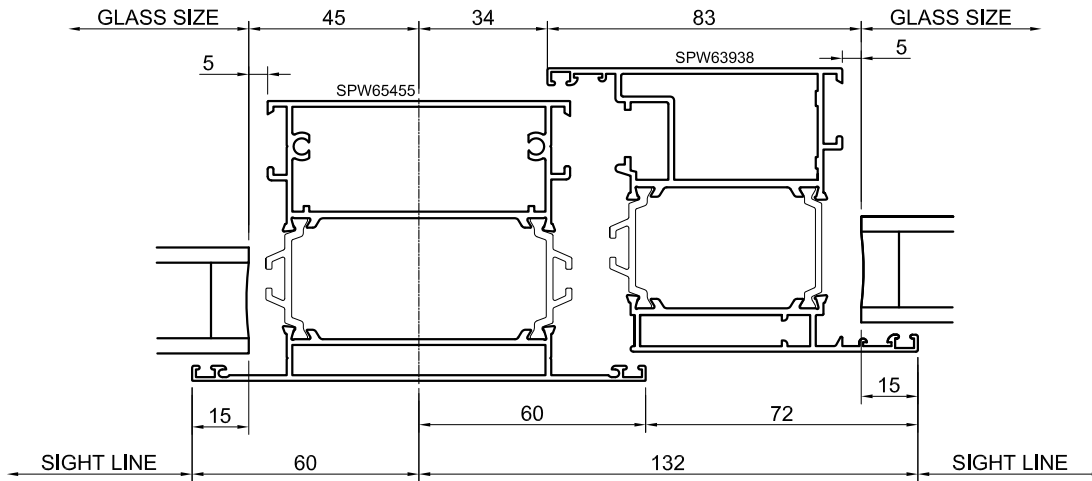
OUTWARD OPENING

# SPW600e Door

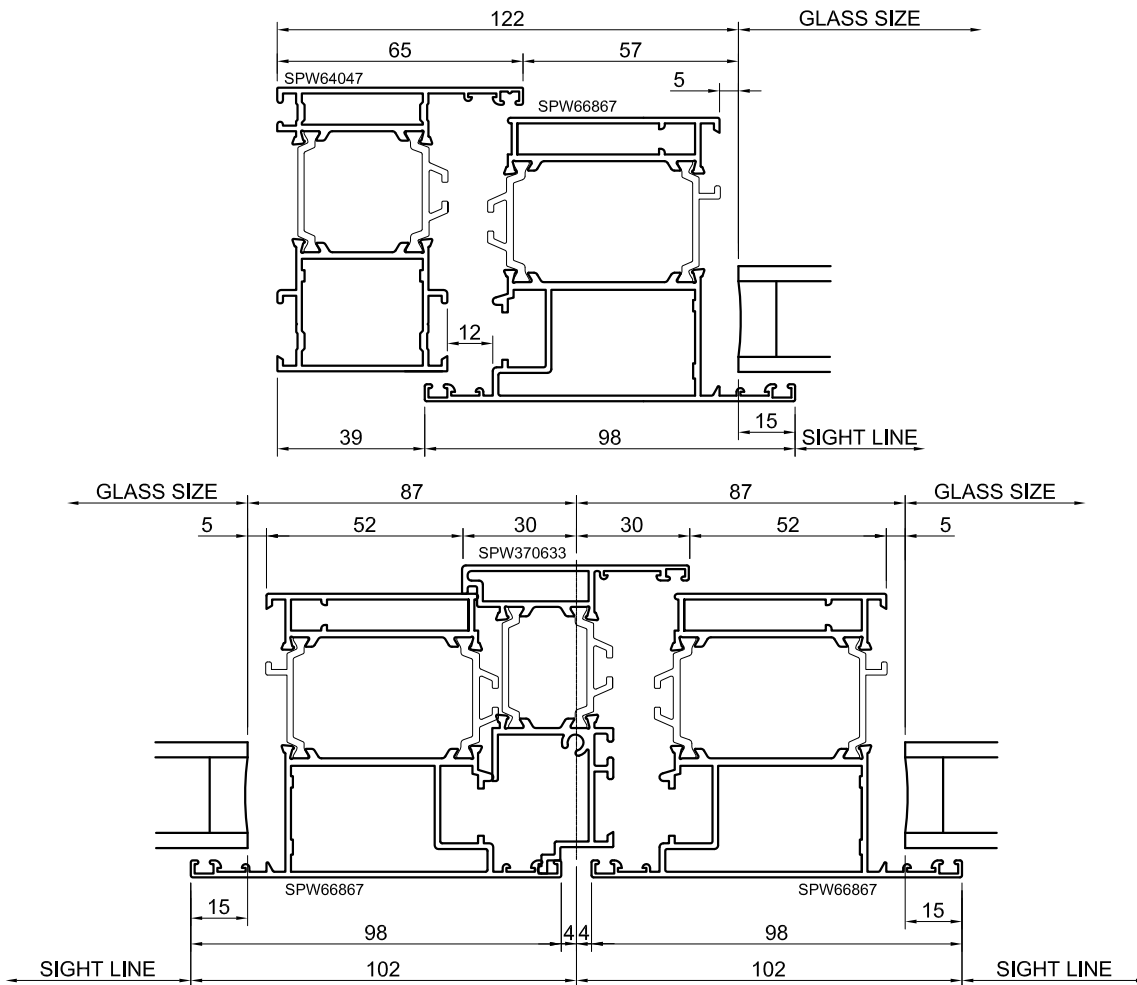
SPW600e.D.404

Deductions - Frame And Glass Open In

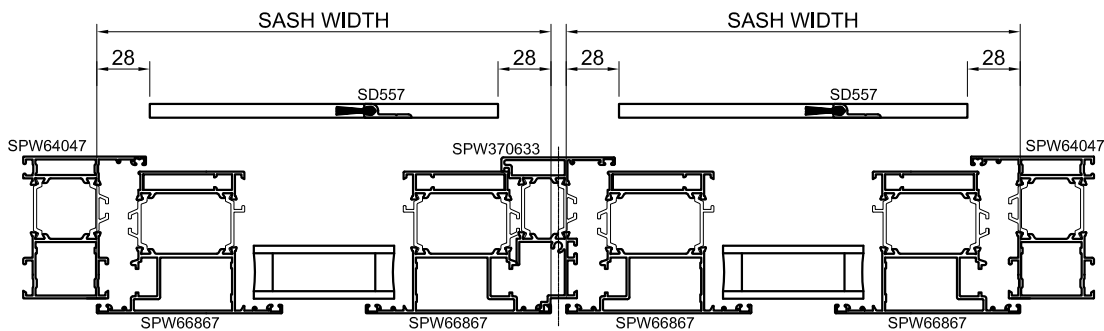
04.12



Deductions - Frame And Glass Open Out



Note: SPW370633 Double Door Mullion  
 For Low Threshold SPW67061 Cut At Sash Height - 56mm  
 For Full Frame SPW64047 Cut At Sash Height - 56mm  
 When Using SPW68182 Bottom Rail Cut At Sash Height - 28mm



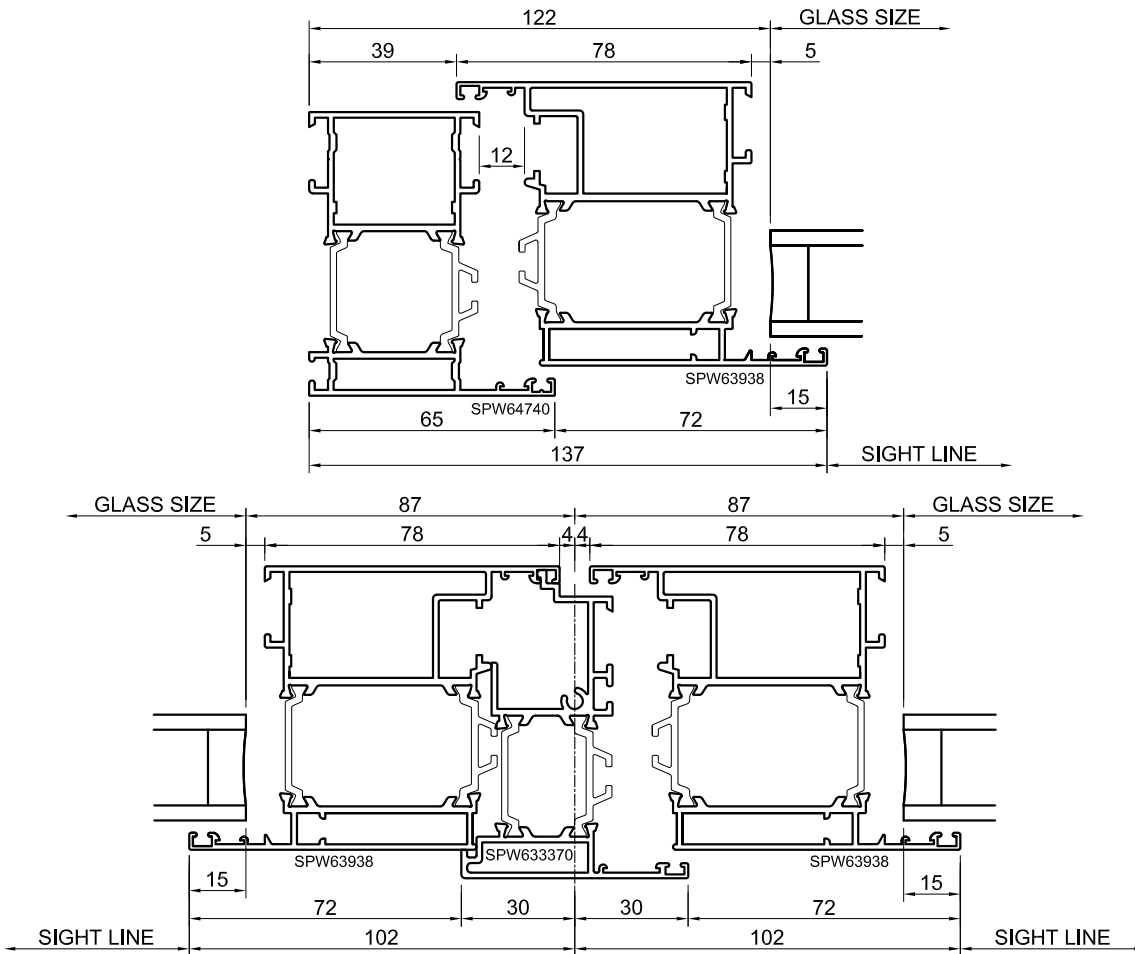
When Using SPW67061 & SPW66867 Cut SD577 At Sash Width - 56mm.

# SPW600e Door

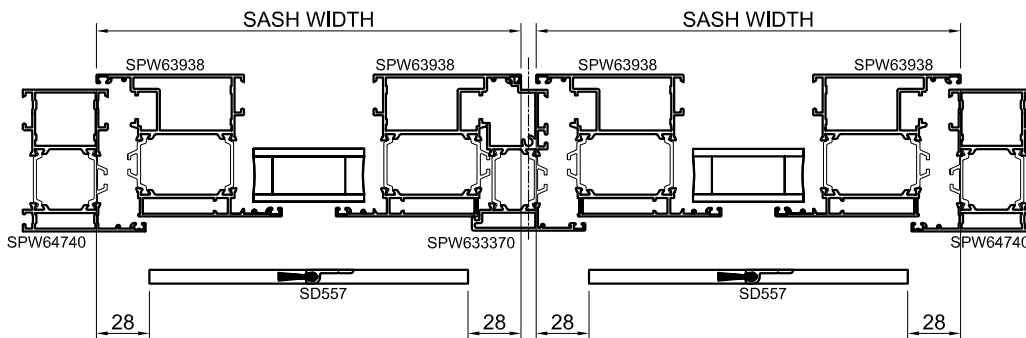
SPW600e.D.406

Deductions - Frame And Glass Open In

03.15



Note: SPW633370 Double Door Mullion  
 For Low Threshold SPW66170 Cut At Sash Height - 56mm  
 For Full Frame SPW64740 Cut At Sash Height - 56mm  
 When Using SPW65455 Bottom Rail Cut At Sash Height - 28mm



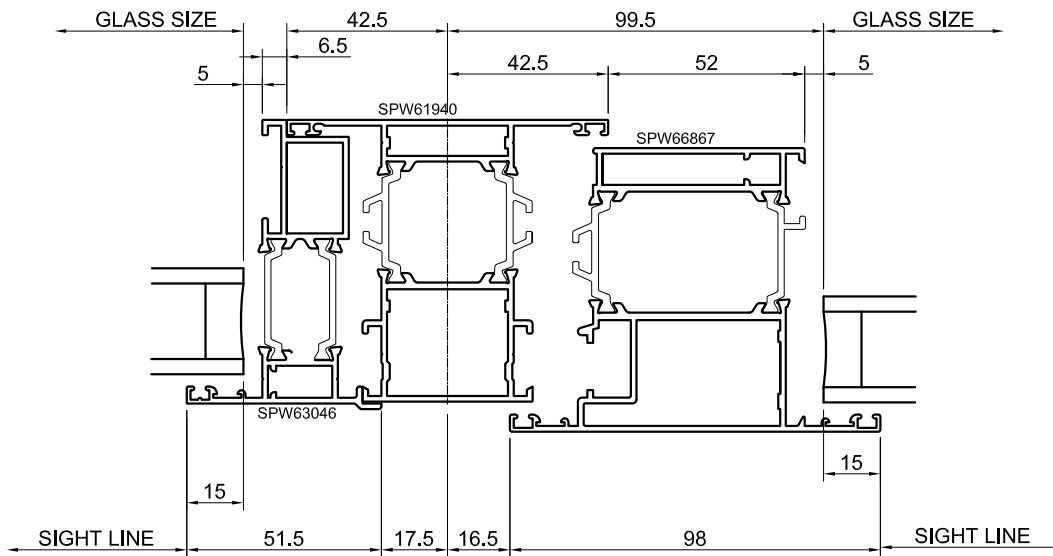
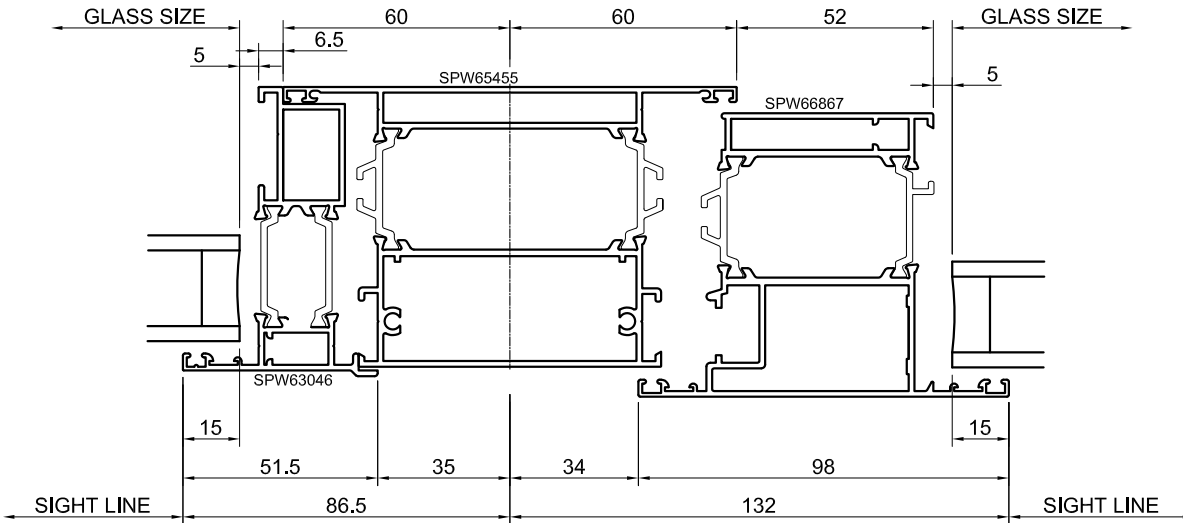
When Using SPW67061 & SPW63938 Cut SD577 At Sash Width - 56mm.

# SPW600e.D.407

04.12

# SPW600e Door

## Deductions- Frame And Glass - Open Out

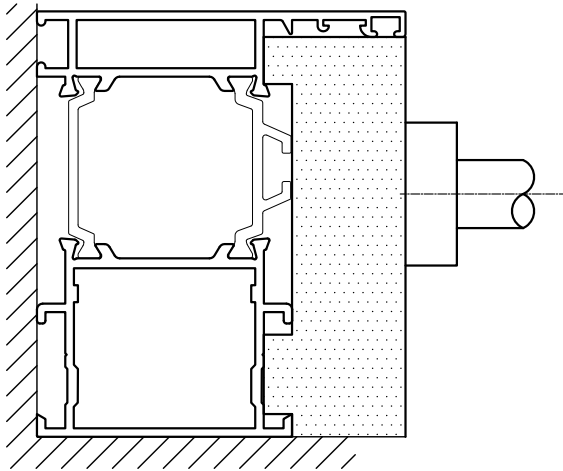


# SPW600e Door

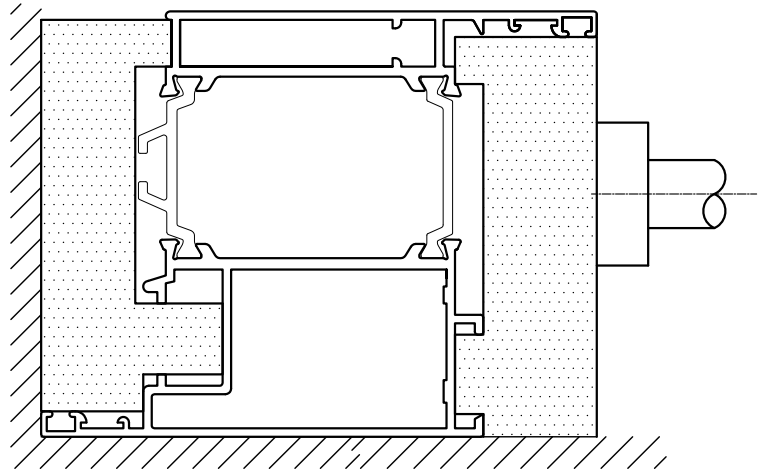
SPW600e.D.408

## Cutting - Clamping Profiles - Suggested Method Of Placement

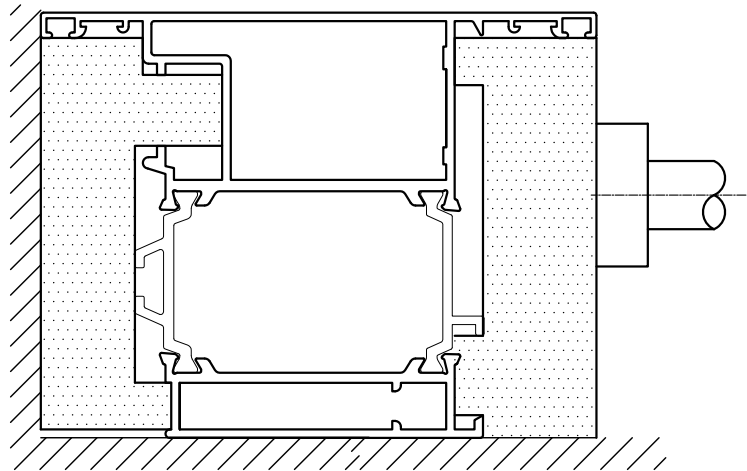
04.12



SPW64740/SPW64047  
Heavy Duty Outer Frame



SPW63938  
Door Sash - Open In

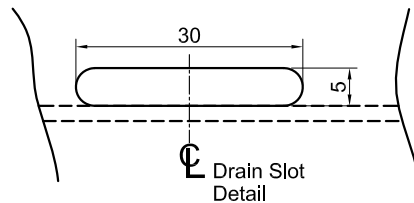
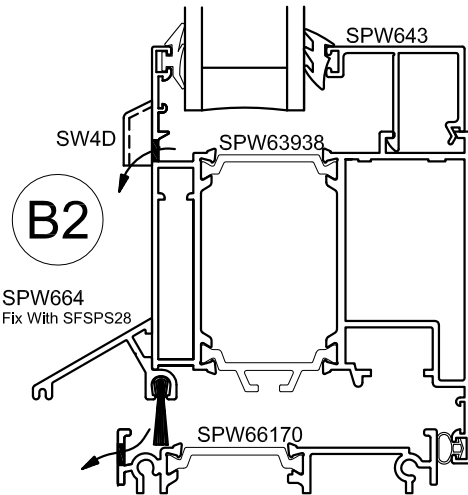
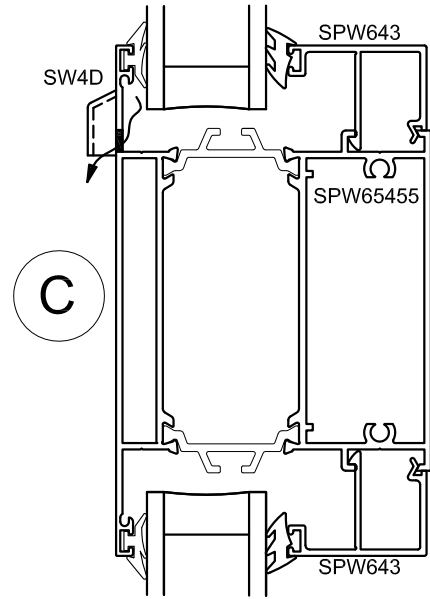
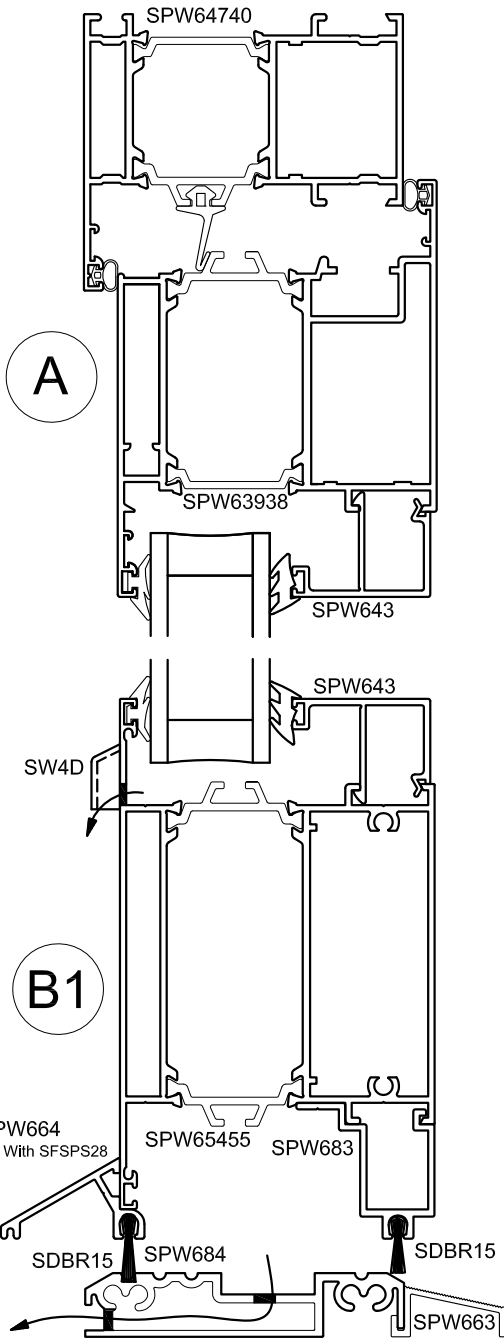
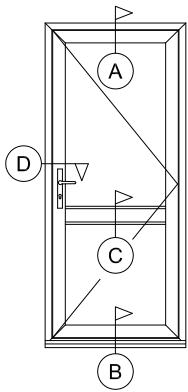


SPW66867  
Door Sash - Open Out

# SPW600e.D.409

04.12

# SPW600e Door Drainage - Inward Opening



SPW664 To Be Fixed 25mm From Each End And At 150mm Centres

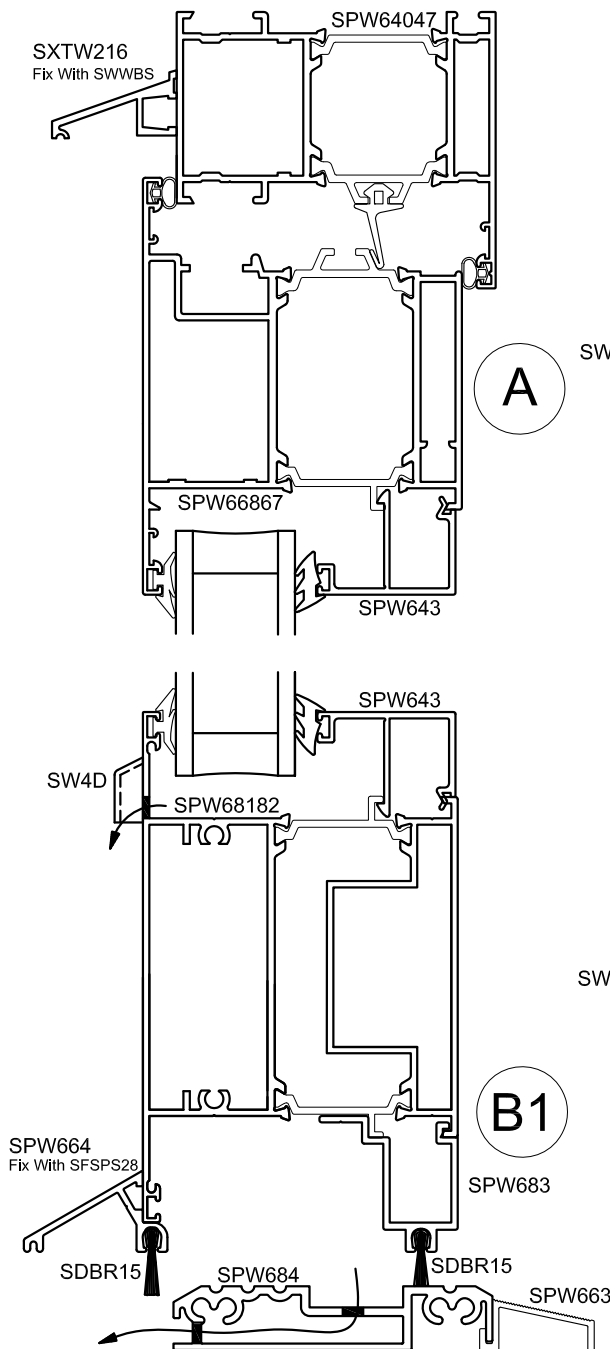
**MACHINE DRAINAGE SLOTS 65mm FROM CORNER OF GLAZING APERTURE AT A MINIMUM OF 600mm CENTRES**

# SPW600e Door

## Drainage - Outward Opening

SPW600e.D.410

04.12



SPW664 & SD557 To Be Fixed 25mm From Each End And At 150mm Centres

**MACHINE DRAINAGE SLOTS 65mm FROM CORNER OF GLAZING APERTURE AT A MINIMUM OF 600mm CENTRES**

# SPW600e.D.411

03.15

# SPW600e Door

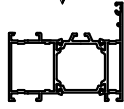
## Routing Details For Yale Lock - Open In

VIEWED FROM OUTSIDE

NOTE: MACHINING SHOWN FOR LEFT HUNG, RIGHT HUNG OPPOSITE (WHEN VIEWED FROM OUTSIDE).

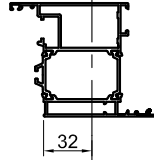
Frame profile  
SPW64740

View in section below



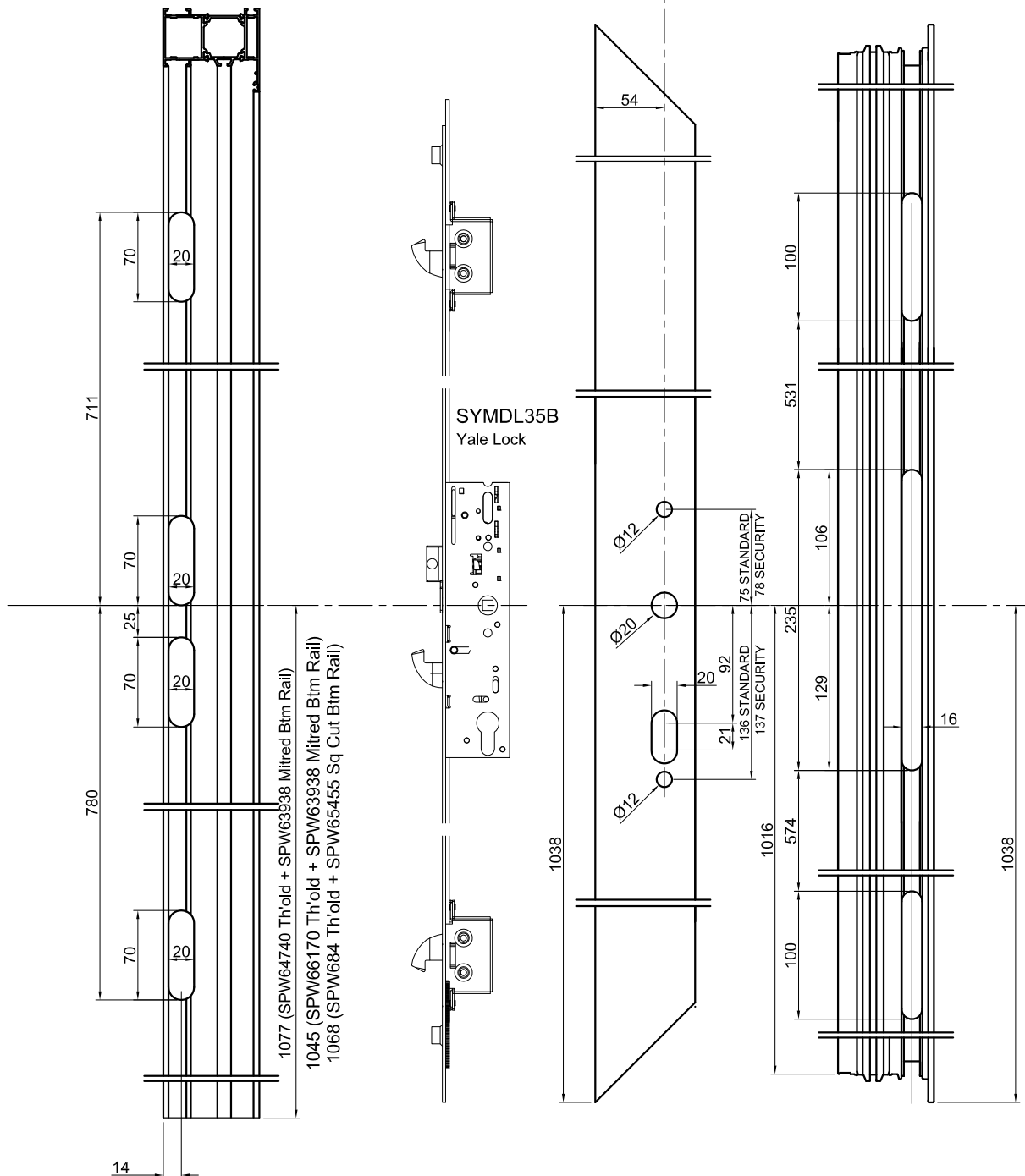
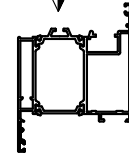
Slave Door Stile  
SPW63938

View in section below



Slave Door Stile  
SPW63938

View in section below

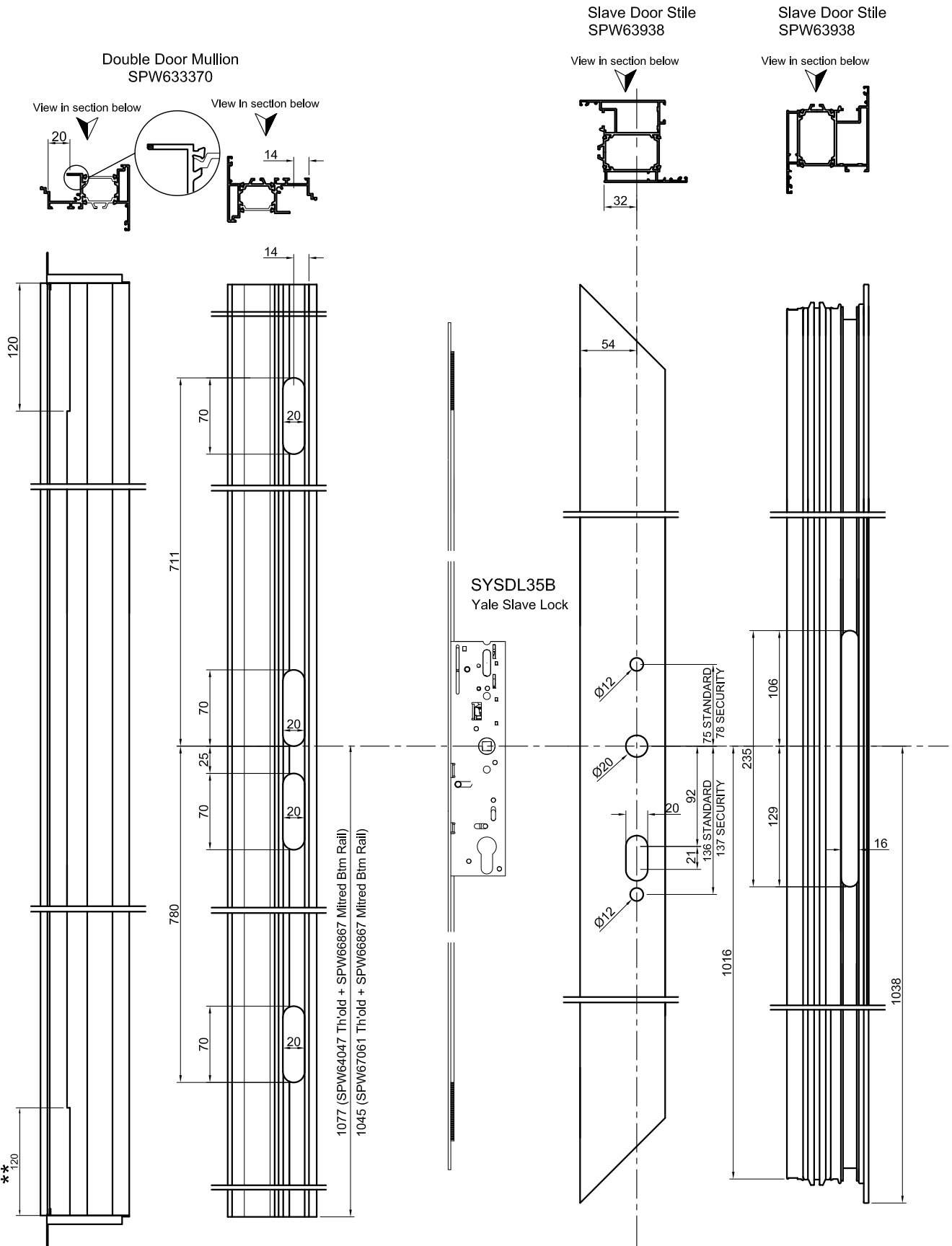


# SPW600e Door

SPW600e.D.412

## Routing Details For Yale Lock - Slave Stile Open In

03.15



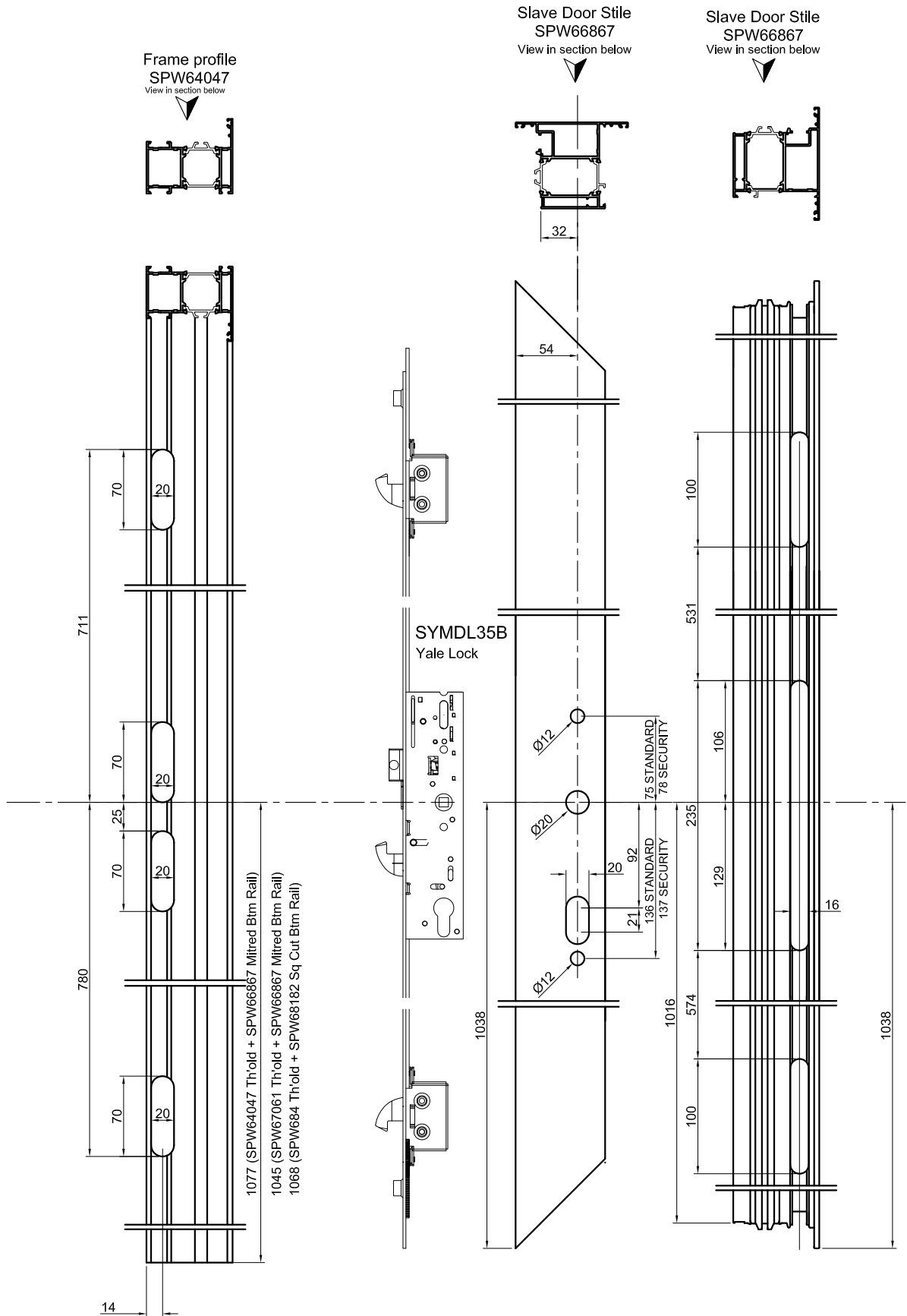
\*\* Machine With SPM601 End  
In Situ. End Caps Not Required  
With Commercial Threshold.  
Mark Out For Keeps Prior To  
Fitting End Caps

# SPW600e.D.413

03.15

# SPW600e Door

## Routing Details For Yale Lock - Open Out



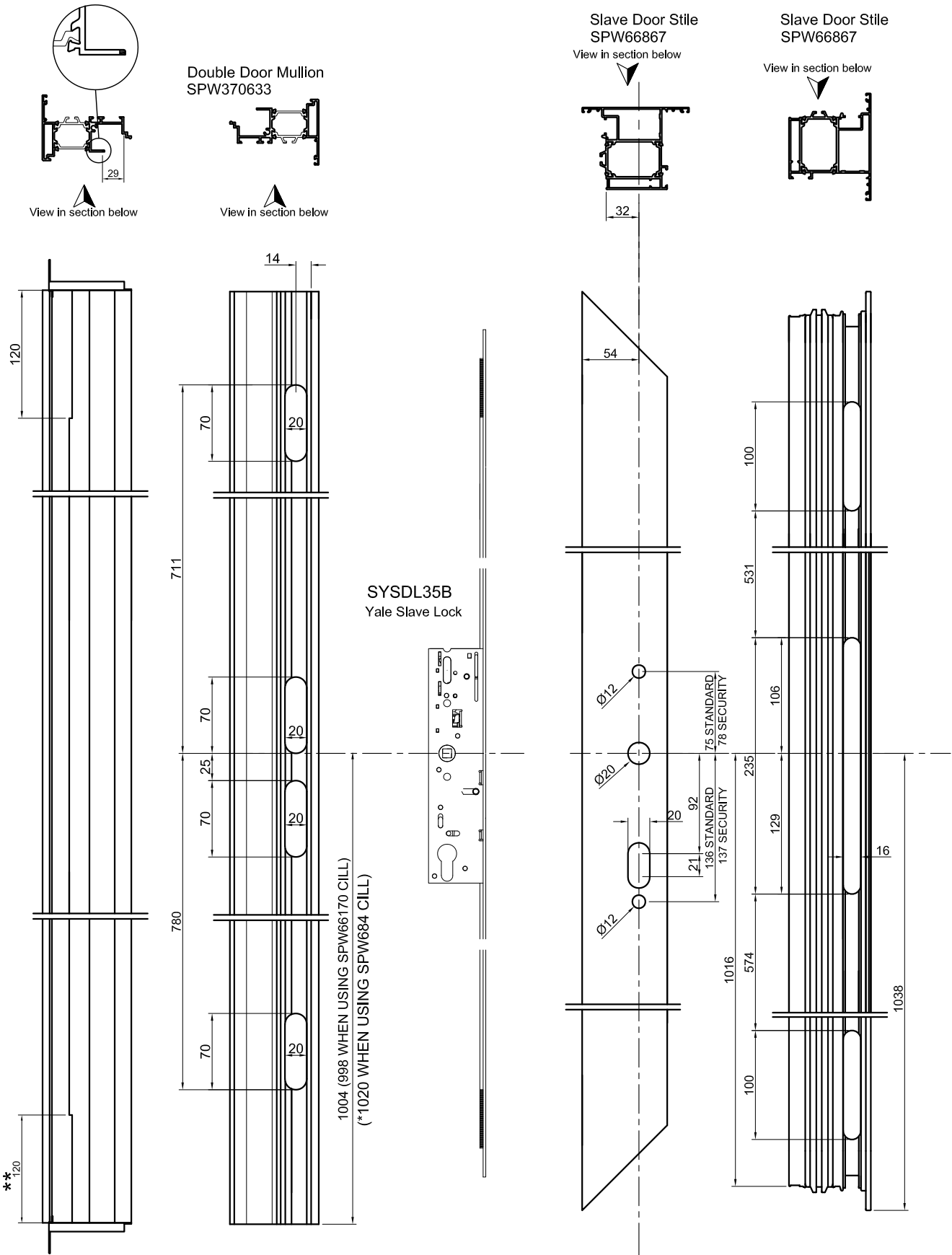
NOTE: MACHINING SHOWN FOR LEFT HUNG,  
RIGHT HUNG OPPOSITE (WHEN VIEWED  
FROM OUTSIDE).

# SPW600e Door

SPW600e.D.414

## Routing Details For Yale Lock - Slave Stile Open Out

03.15



\*\* Machine With SPM601 End  
In Situ. End Caps Not Required  
With Commercial Threshold.  
Mark Out For Keeps Prior To  
Fitting End Caps

SPW600e.D.415

01.13

SPW600e Door

Blank

# SPW600e Door

Blank

SPW600e.D.416

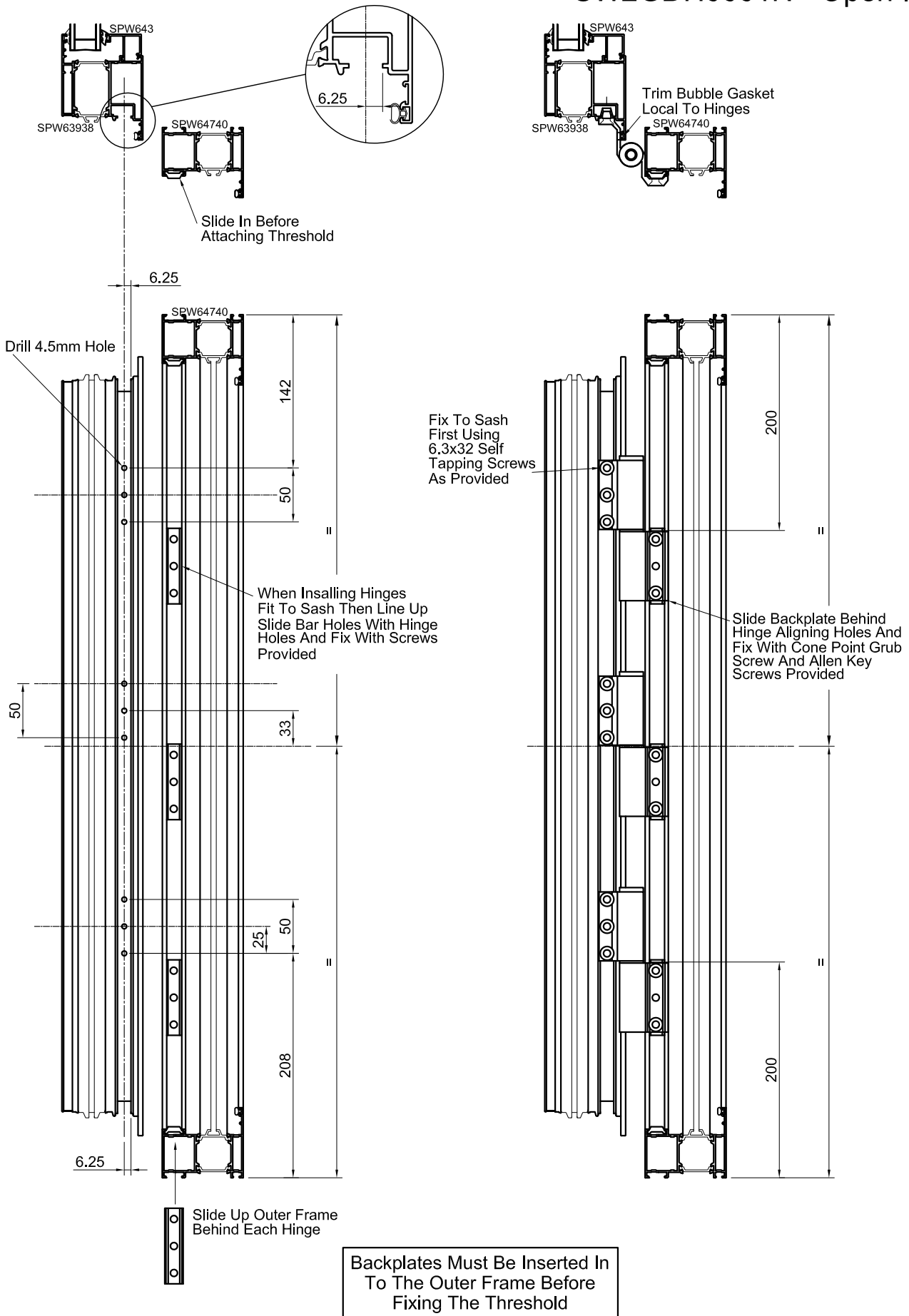
01.13

# SPW600e.D.417

04.12

# SPW600e Door

## Drilling Details For Clamp On Hinge SW2GDH0001N - Open In

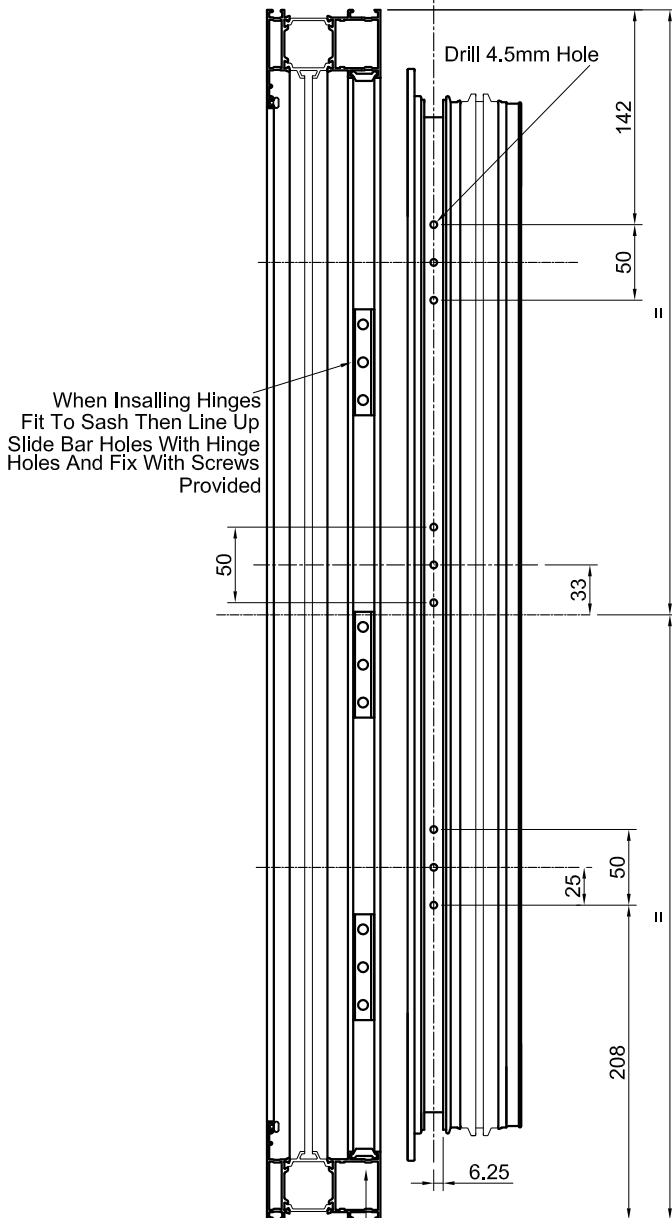
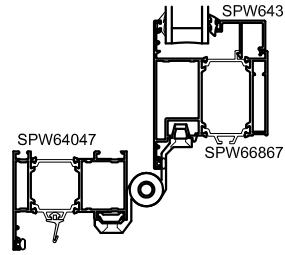
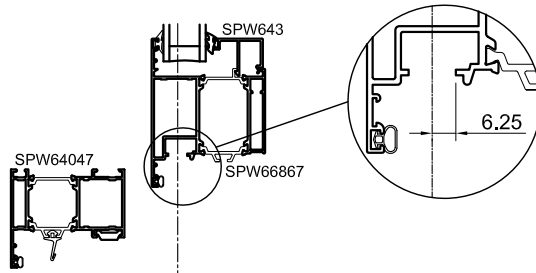


# SPW600e Door

## Drilling Details For Clamp On Hinge SW2GDH0001N - Open Out

SPW600e.D.418

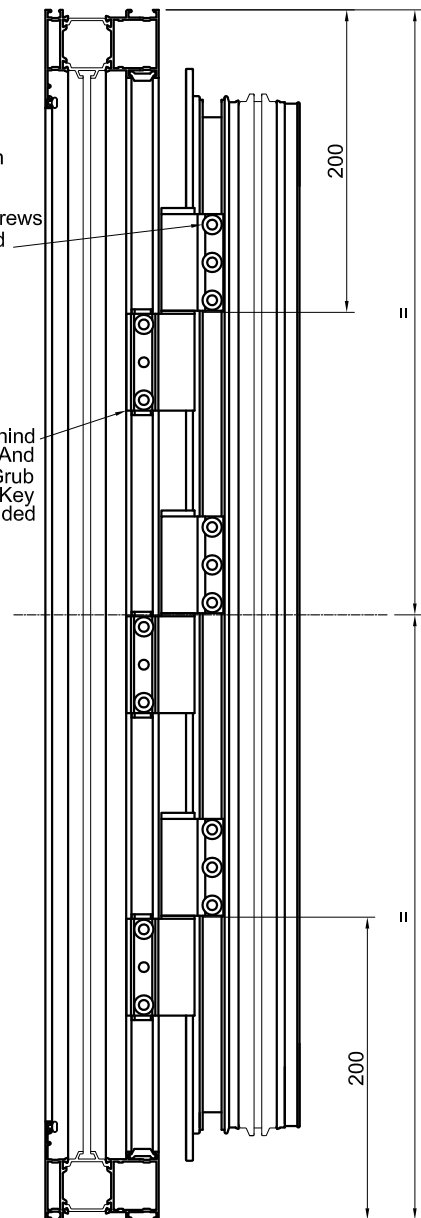
04.12



When Installing Hinges  
Fit To Sash Then Line Up  
Slide Bar Holes With Hinge  
Holes And Fix With Screws  
Provided

Slide Backplate Behind  
Hinge Aligning Holes And  
Fix With Cone Point Grub  
Screw And Allen Key  
Screws Provided

Fix To Sash  
First Using  
6.3x32 Self  
Tapping Screws  
As Provided

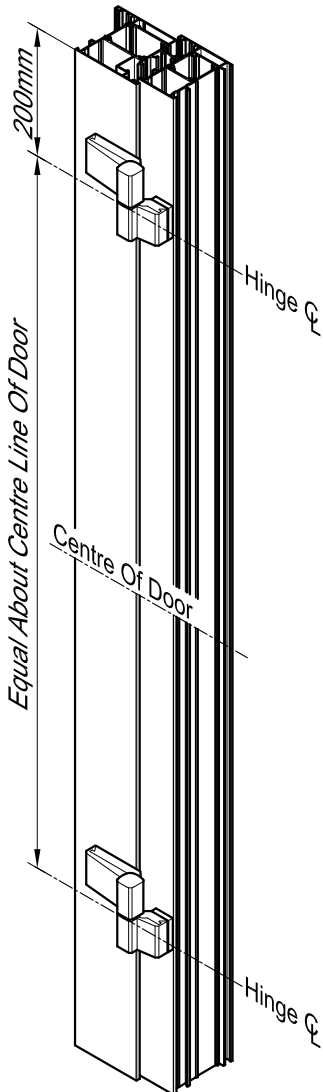


Slide Up Outer Frame  
Behind Each Hinge

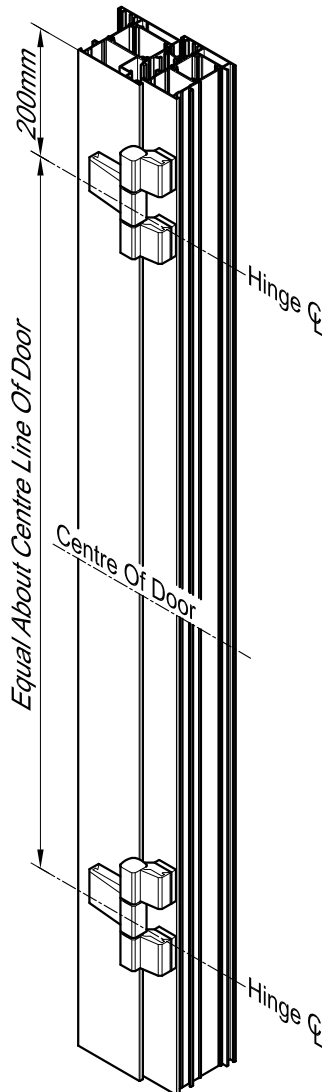


Backplates Must Be Inserted In  
To The Outer Frame Before  
Fixing The Threshold

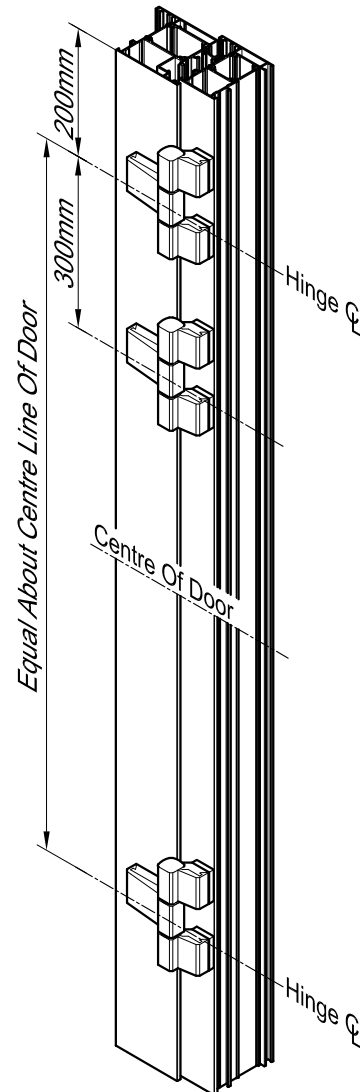
Single-Family Dwelling  
2x 2 Part Hinge  
Position As Shown



Multi-Family Dwelling  
2x 3 Part Hinge  
Position As Shown



School, Hospital, etc.  
3x 3 Part Hinge  
Position As Shown



Position Of Hinges Remains The Same Irrespective Of Opening Direction

Please Note:  
3-Flag Hinges (SPW3) Must Be Used  
If Door Is To Comply To PAS-24

Total Weight Of Door Must Not Exceed 75kg In All Applications

Tapping Blocks Must Be Positioned Prior To Crimping.

# SPW600e Door

# SPW600e.D.420

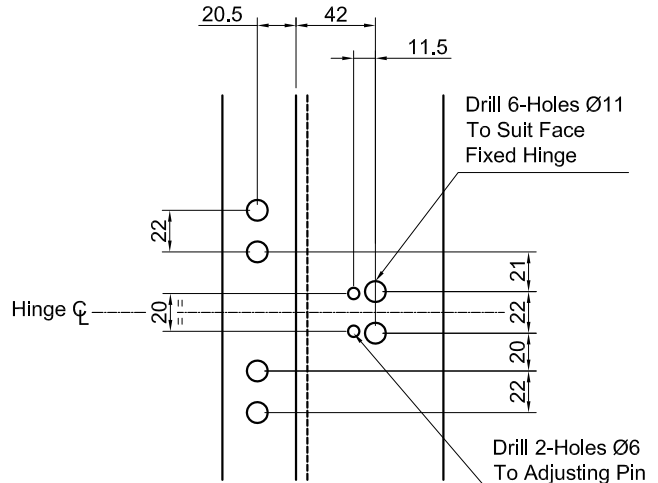
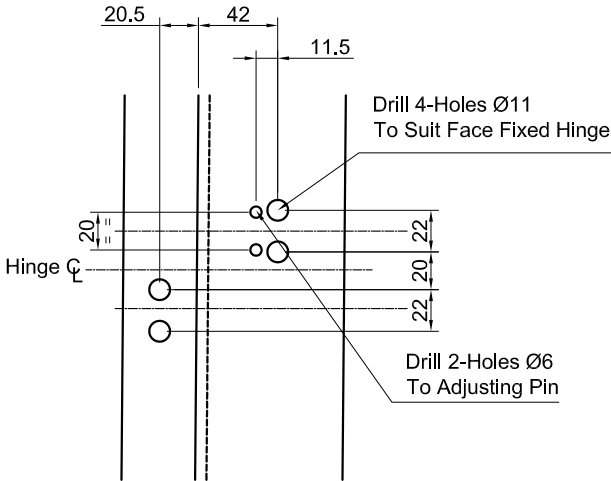
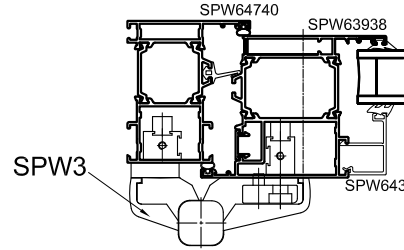
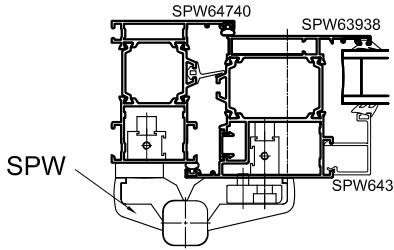
## Drilling Details For Face Hinge

03.14

### OPEN IN DOORS

Drilling Details For 2-Part Hinge

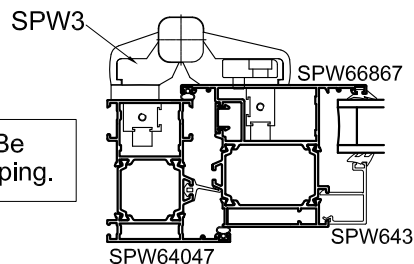
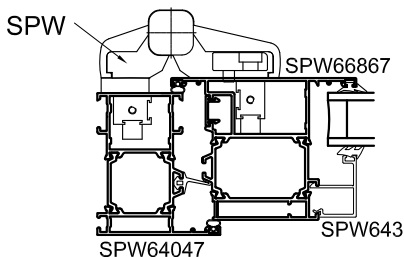
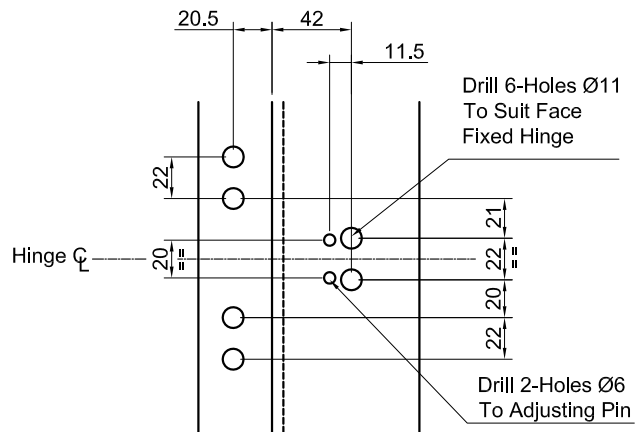
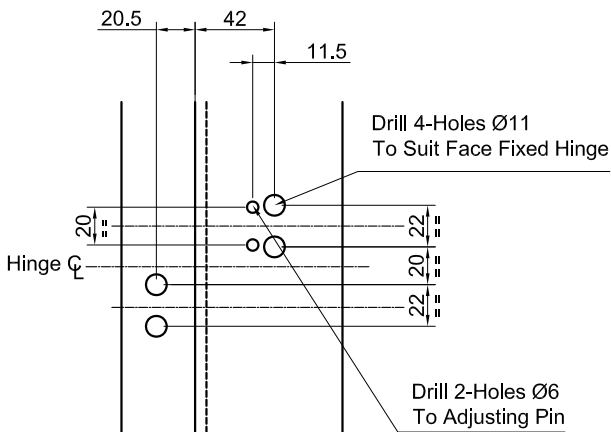
Drilling Details For 3-Part Hinge



### OPEN OUT DOORS

Drilling Details For 2-Part Hinge

Drilling Details For 3-Part Hinge



Tapping Blocks Must Be Positioned Prior To Crimping.

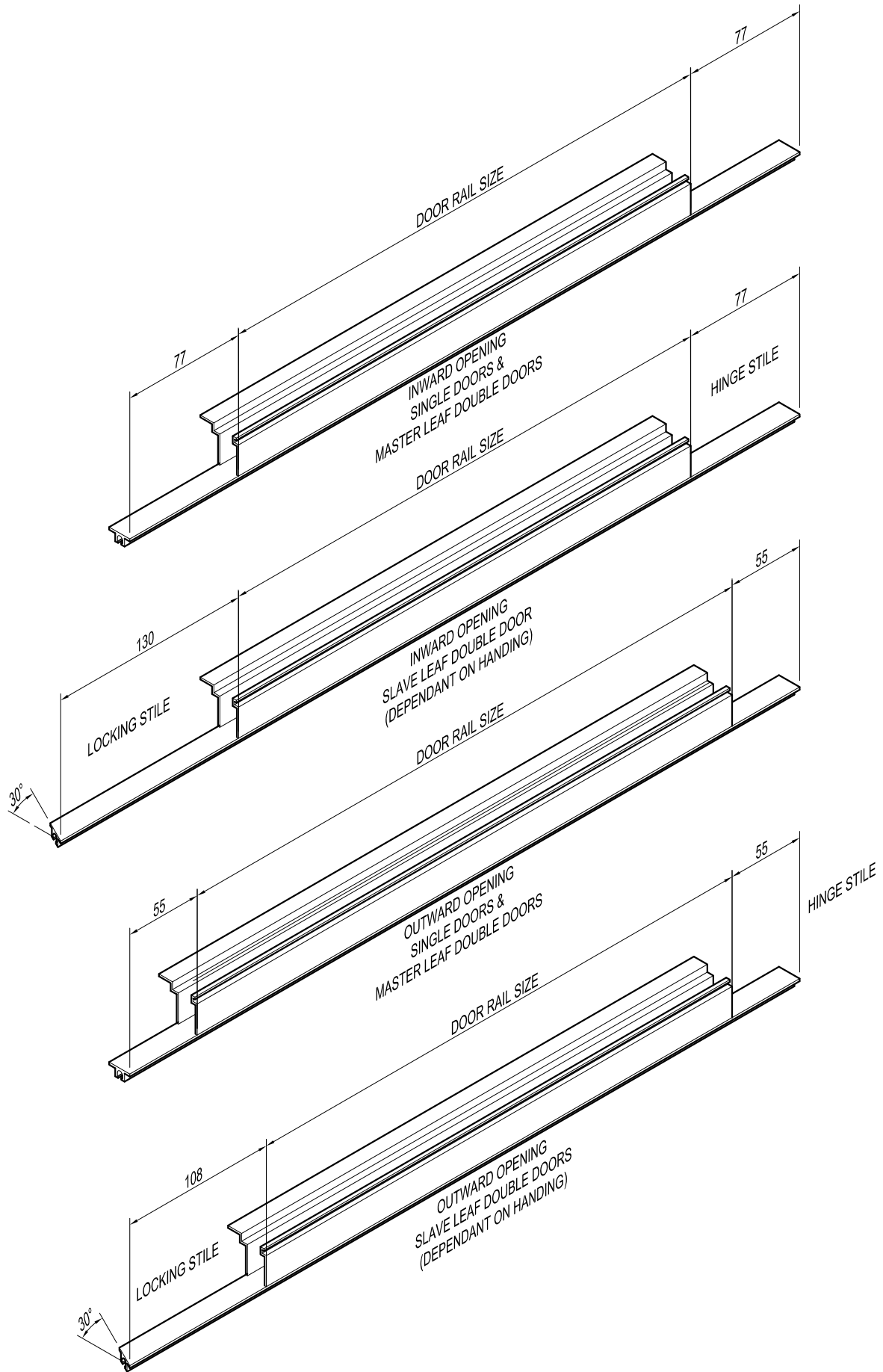
Please Note:  
3-Flag Hinges (SPW3) Must Be Used  
If Door Is To Comply To PAS-24

SPW600e.D.421

04.12

# SPW600e Door

Brush Carrier Machining Details - SPW683

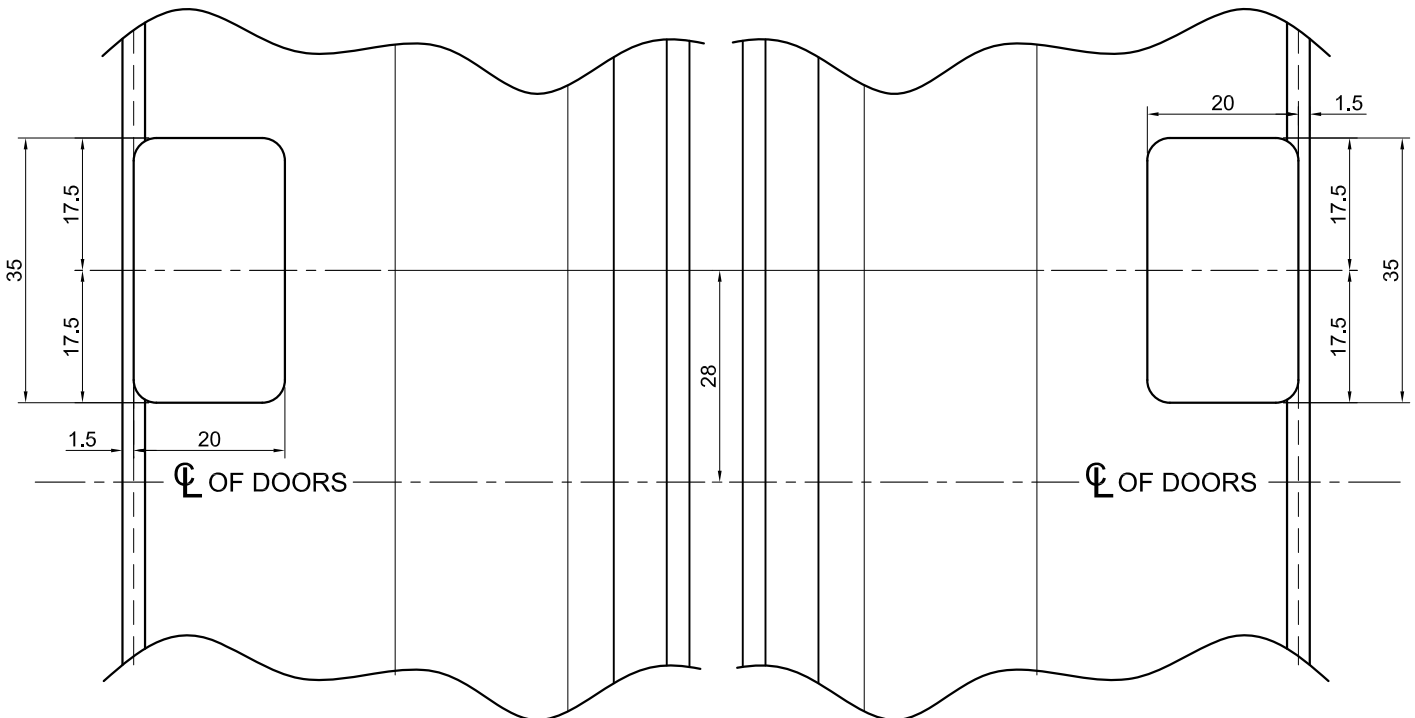
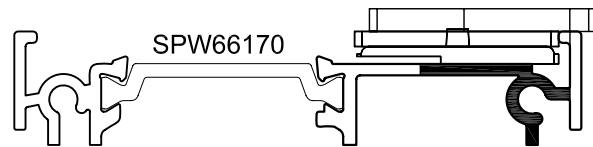
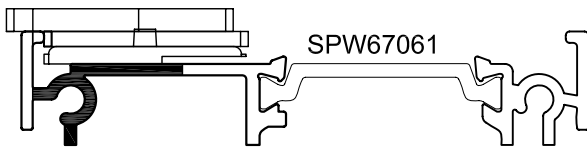
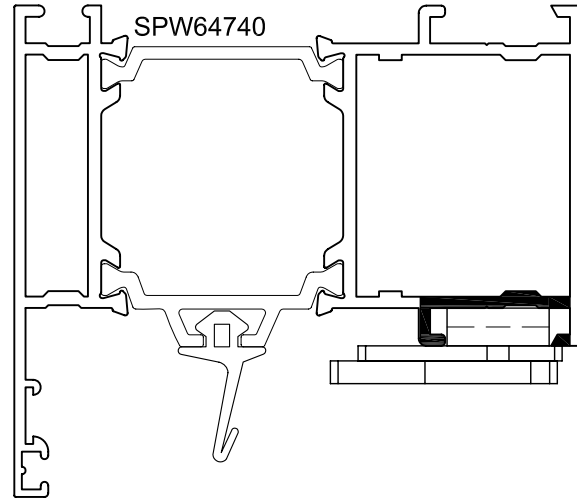
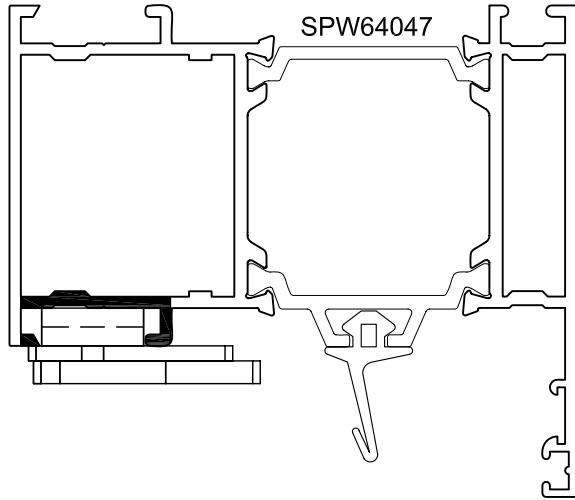


# SPW600e Door

SPW600e.D.422

## Routing Details For Shoot Bolt Head And Cill

02.14

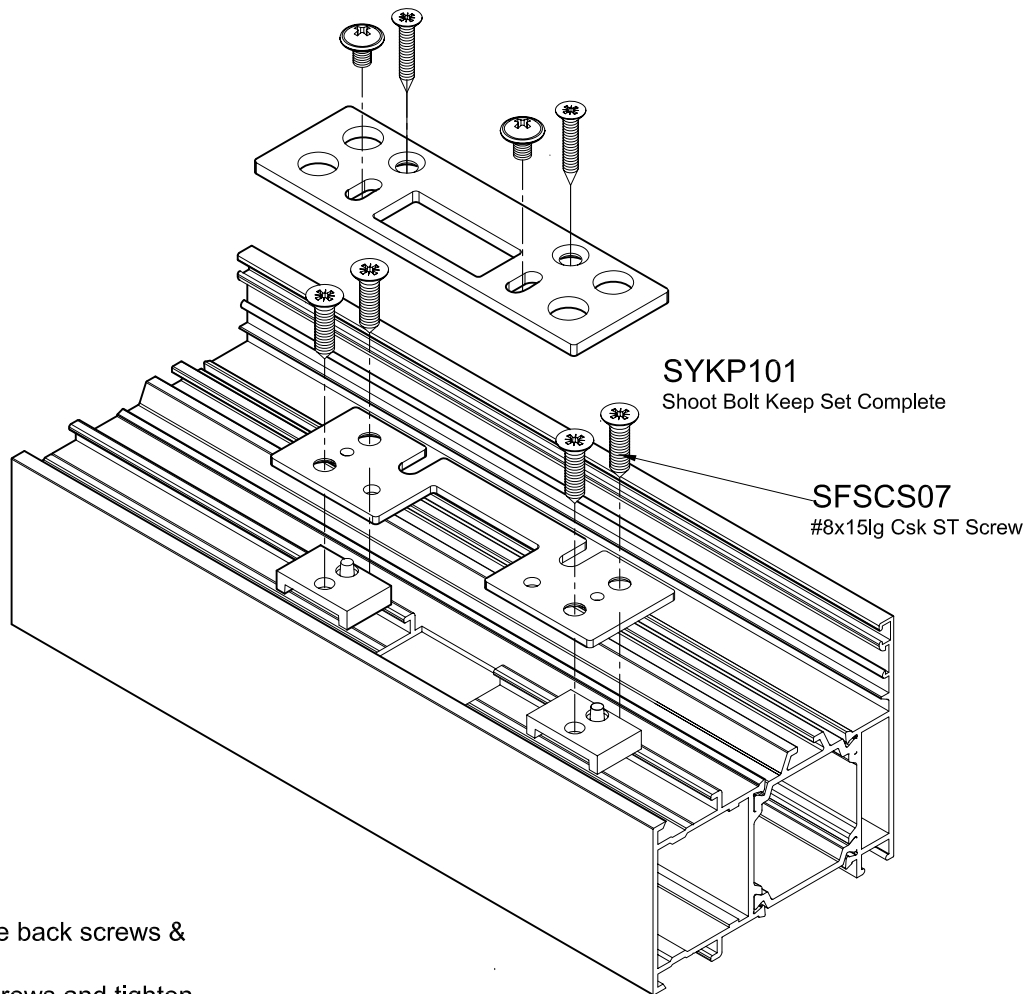


OPEN OUT

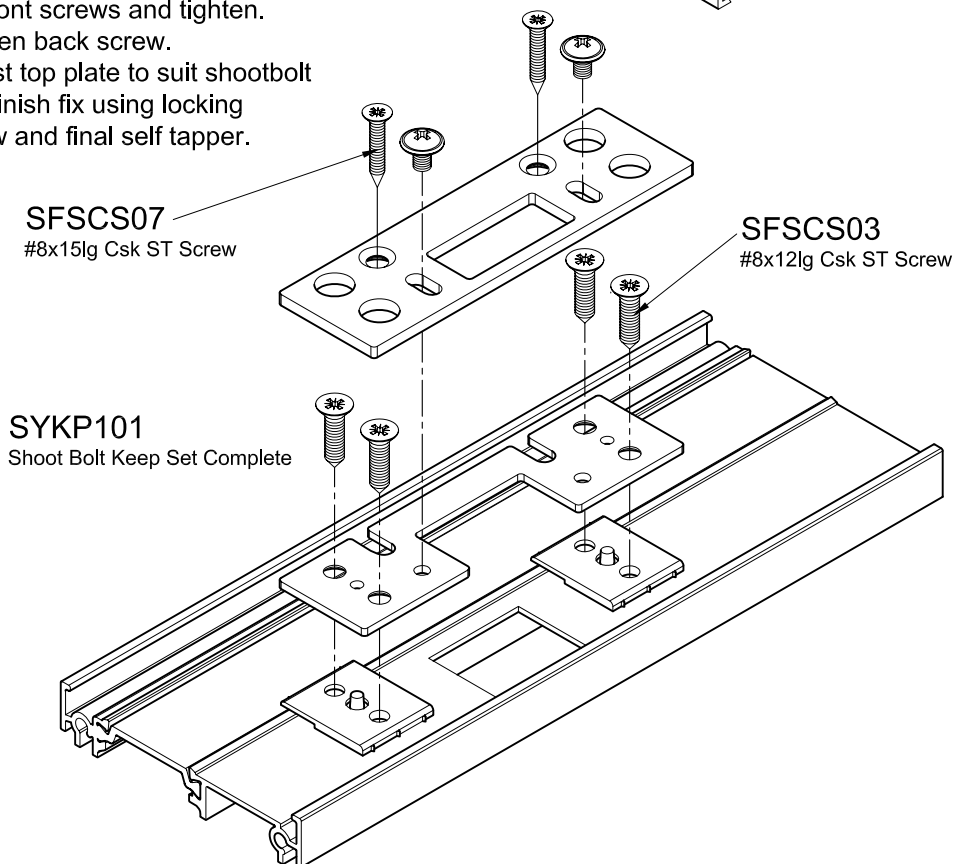
OPEN IN

NOTE: SHOOT BOLTS ARE ONLY REQUIRED ON SLAVE DOOR  
SHOOT BOLT KEEP PART NO - SYKP101

## Routing Details For Shoot Bolt Head And Cill



Position the back screws & loosely fix.  
Fix front screws and tighten.  
Tighten back screw.  
Adjust top plate to suit shootbolt and finish fix using locking screw and final self taper.



# SPW600e Door

Blank

SPW600e.D.424

02.14

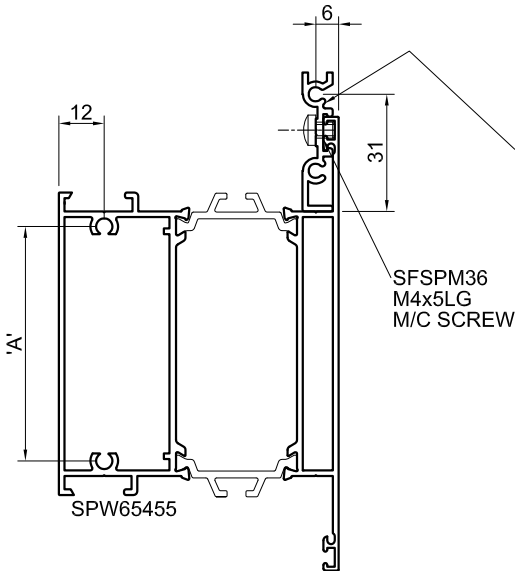
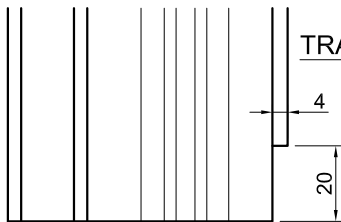
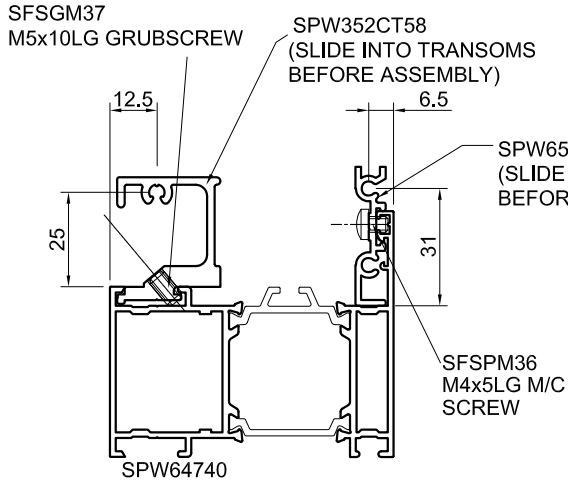
# SPW600e.E.401

04.12

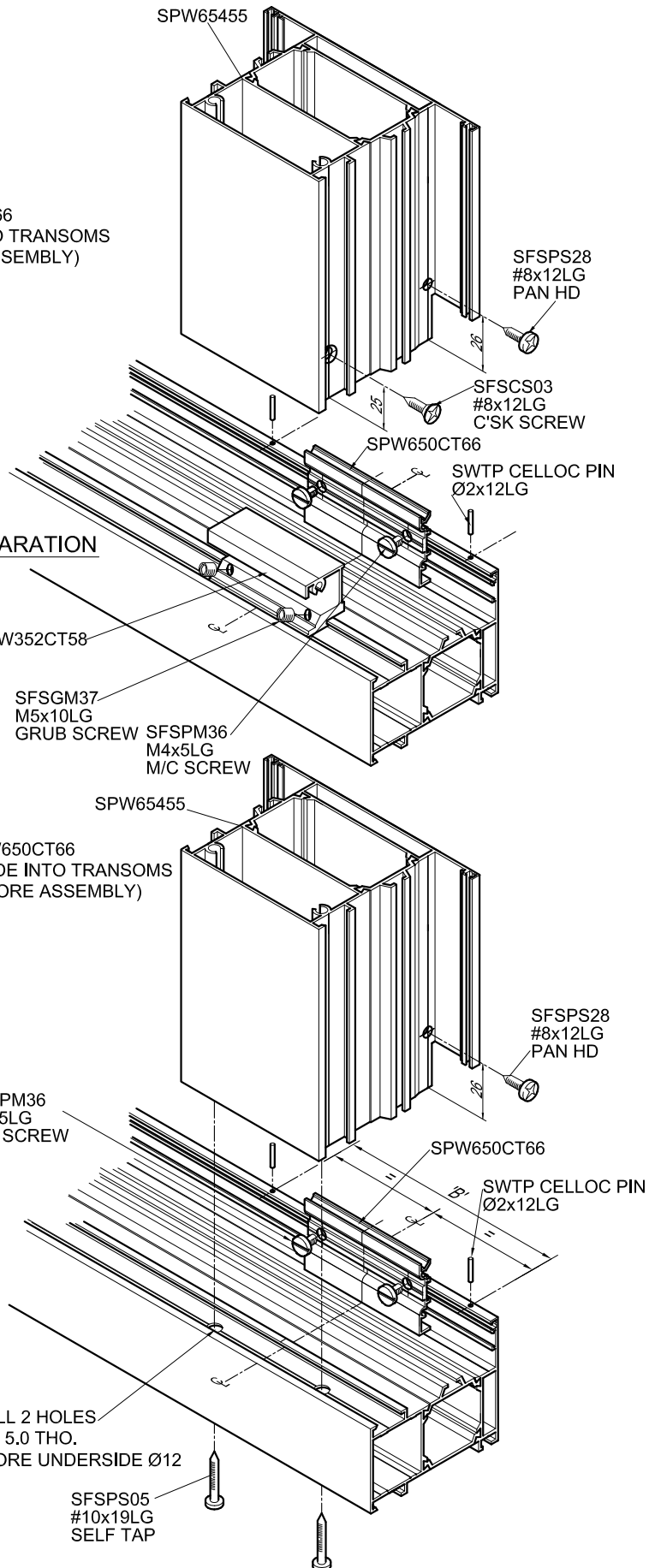
NOTE: CRUCIFORM JOINTS CAN ONLY BE FORMED USING SHEARBLOCKS

# SPW600e Door

## Transom / Mullion Shear Block and Screw Fix



### TRANSOM PREPARATION



TRANSOM	DIM 'A'	DIM 'B'	BLOCK INNER	BLOCK OUTER
SPW61940	N/A	68	SPW352CT31	SPW650CT30
SPW65455	62	103	SPW352CT58	SPW650CT66
SPW68182	62	103	SPW352CT31	SPW650CT66

DRILL 2 HOLES  
DIA. 5.0 THO.  
C'BORE UNDERSIDE Ø12

SFSPS05  
#10x19LG  
SELF TAP

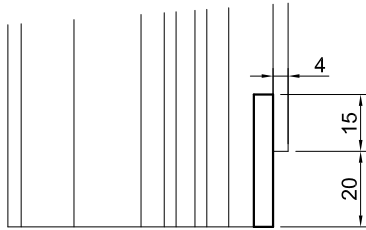
# SPW600e Door

Transom/Mullion

Shear Block and Screw Fix

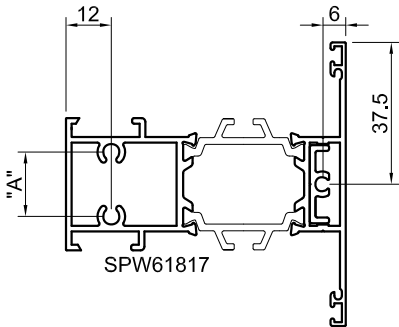
SPW600e.E.402

04.12

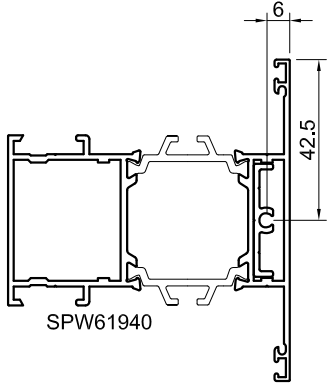


TRANSOM PREPARATION

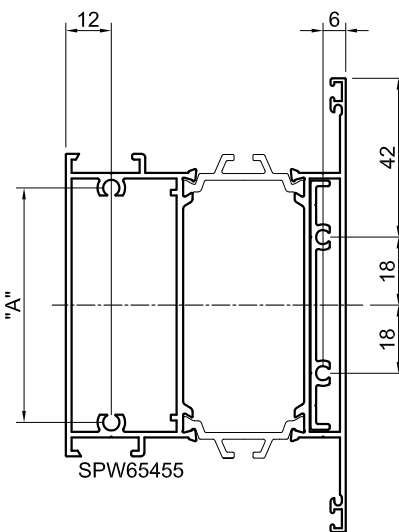
NOTE: CRUCIFORM JOINTS CAN ONLY BE FORMED USING SHEARBLOCKS



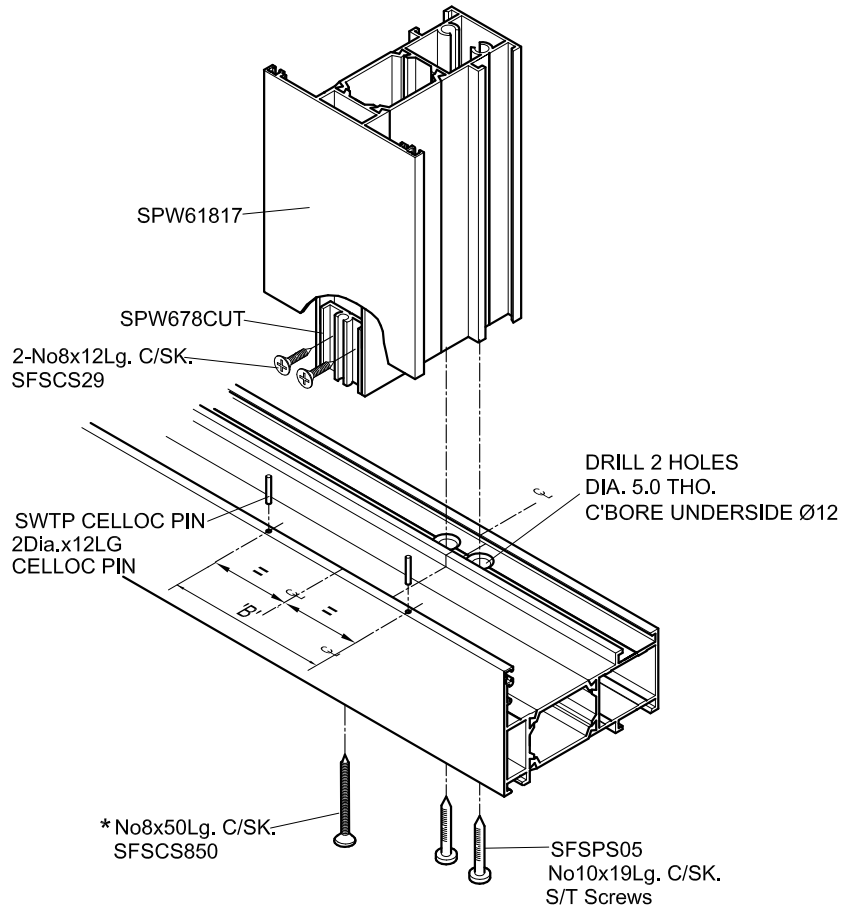
SPW61817



SPW61940



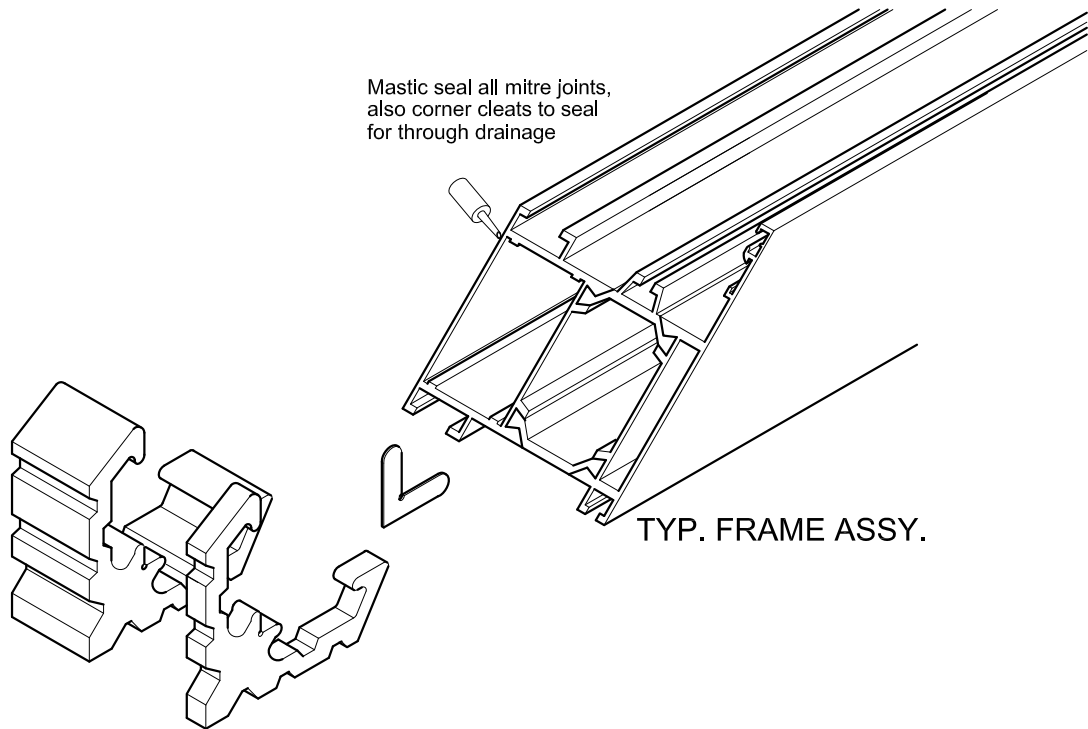
SPW65455



TRANSOM/MULLION OPTIONS				
TRANSOM	DIM 'A'	DIM 'B'	SHEAR BLOCK	BLOCK INNER/OUTER
SPW68182	62	103	SPW679CUT	SPW352CT58
SPW61940	N/A	68	SPW677CUT	SPW352CT31
*SPW65455	62	93	SPW679CUT	SPW352CT58
*NOTE: USE 2 SCREWS SFSCS850 18mm EITHER SIDE OF $\square$				

# SPW600e Door

## Corner Cleats & EPS Foam Inserts



Note: For Improved Strength, Use Cosmopur 819 (300ml) 3COS0073 Aluminium Glue On Cleats Before Assembly.

SECTION	INNER CLEAT	OUTER CLEAT	OUTER CHEVRON	INNER CHEVRON
SPW64740	SW446CT28	SW446CT8	SW4 CH7/CHEV7P	N/A
SPW63938	SPW657CT28	SPW657CT8	SW4 CH7/CHEV7P	SW4 CH7/CHEV7P
SPW61940	SW446CT28	SW446CT8	N/A	N/A
SPW66867	SPW657CT28	SPW657CT8	SW4 CH7/CHEV7P	SW4 CH7/CHEV7P
SPW64047	SW446CT28	SW446CT8	N/A	SW4 CH7/CHEV7P
SPW68047	SW446CT8	SW446CT28	N/A	SW4 CH7/CHEV7P

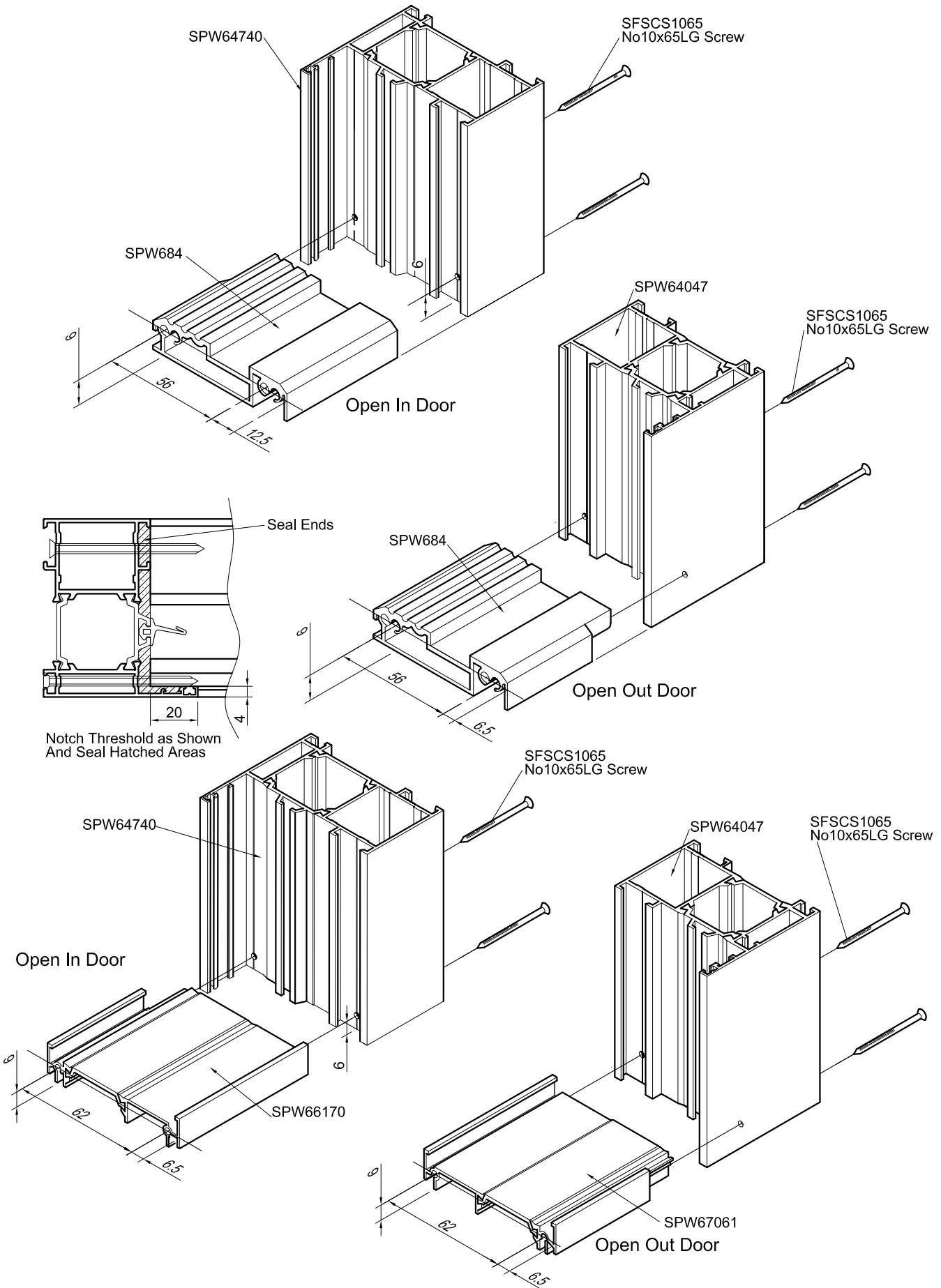
FOR ENHANCED THERMAL PERFORMANCE	
SECTION	INSERT
SPW64740E	EPS001
SPW63938E	EPS007
SPW61940E	EPS001
SPW66867E	EPS007
SPW64047E	EPS001
SPW68047E	EPS001

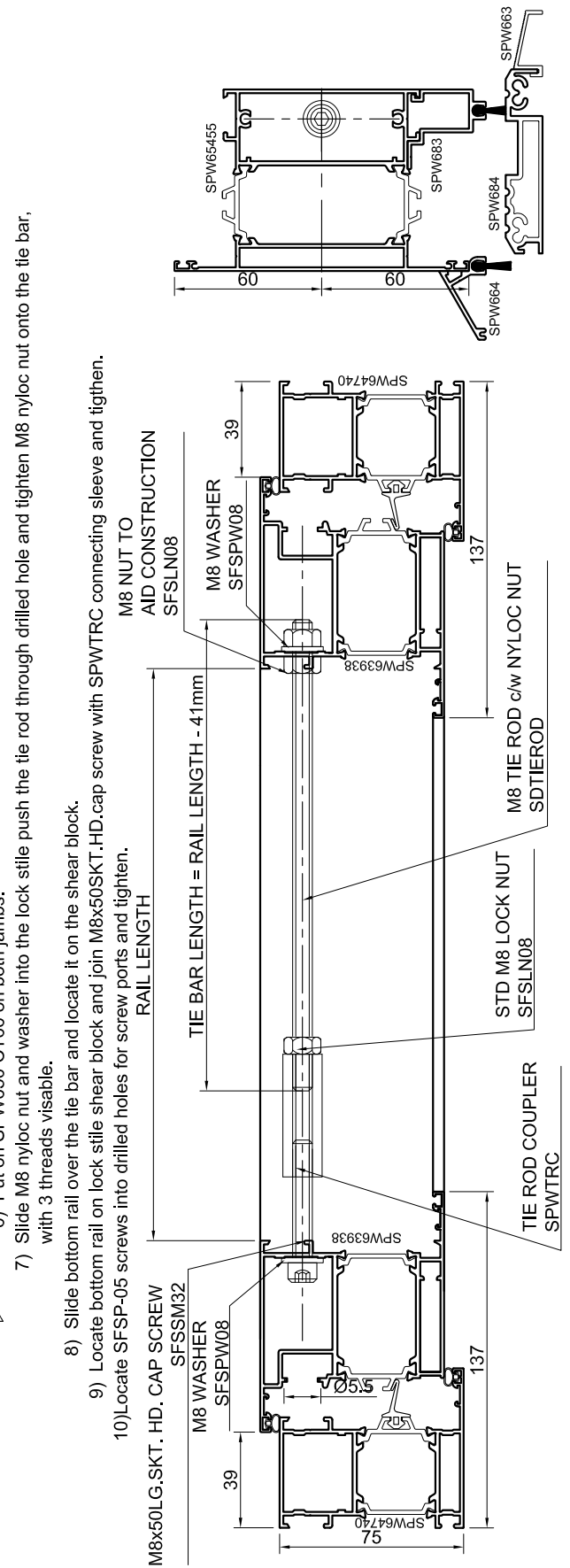
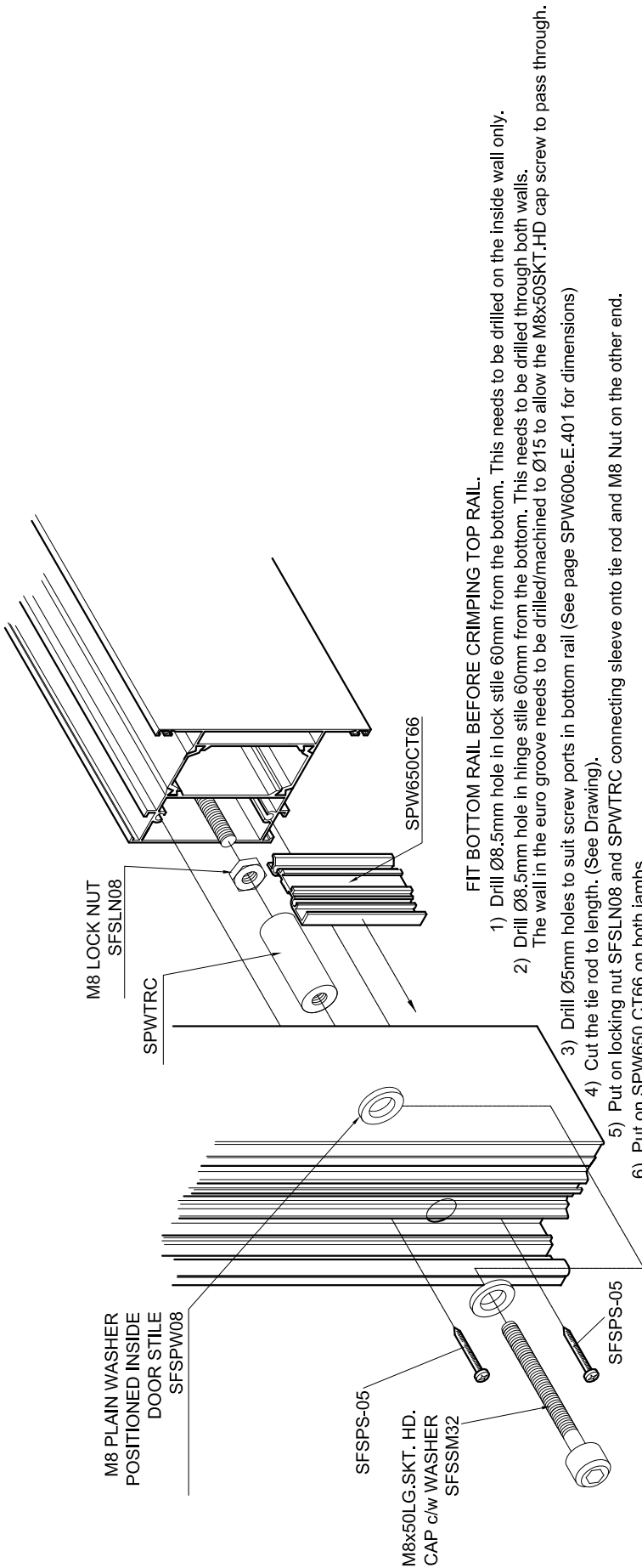
# SPW600e Door

## Threshold Detail

SPW600e.E.404

04.12



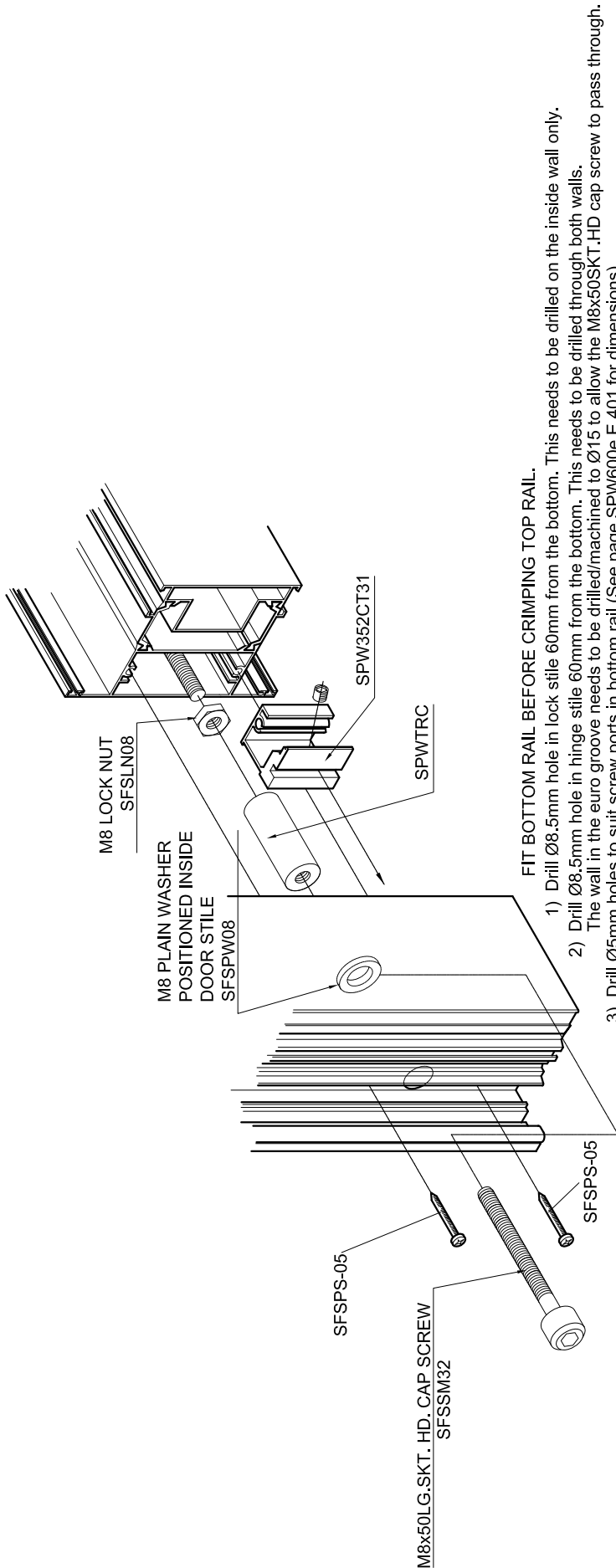


# SPW600e Door

# SPW600e.E.406

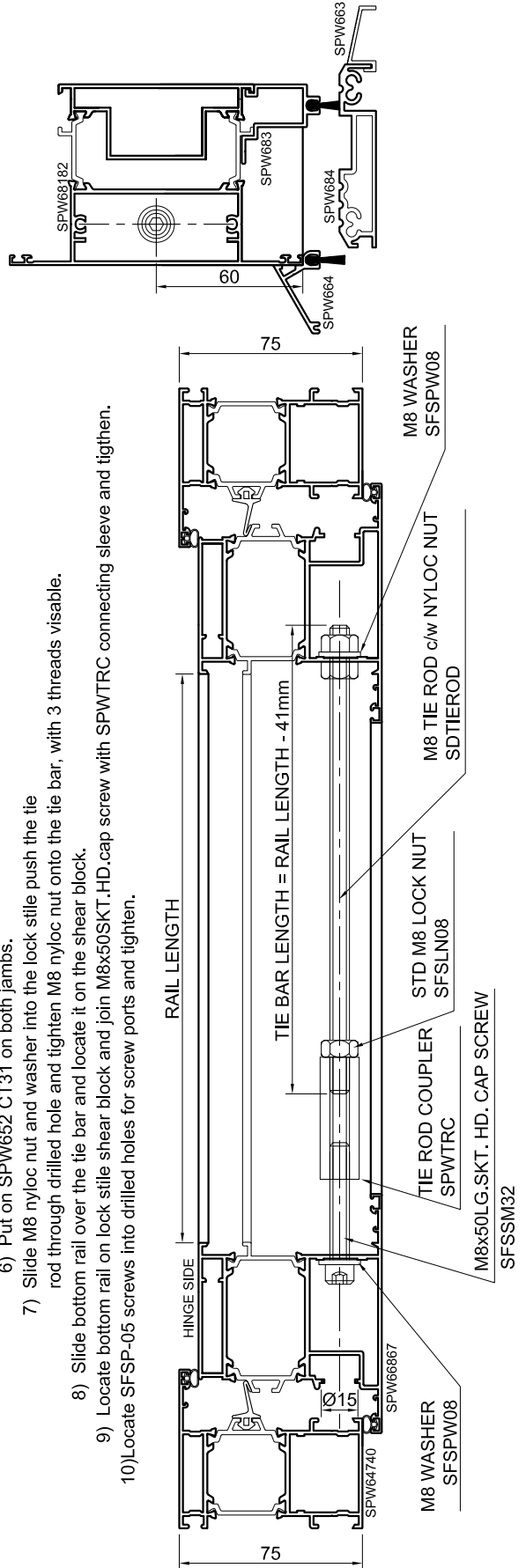
## Bottom Rail Assembly/Tie Bar - Outward Opening

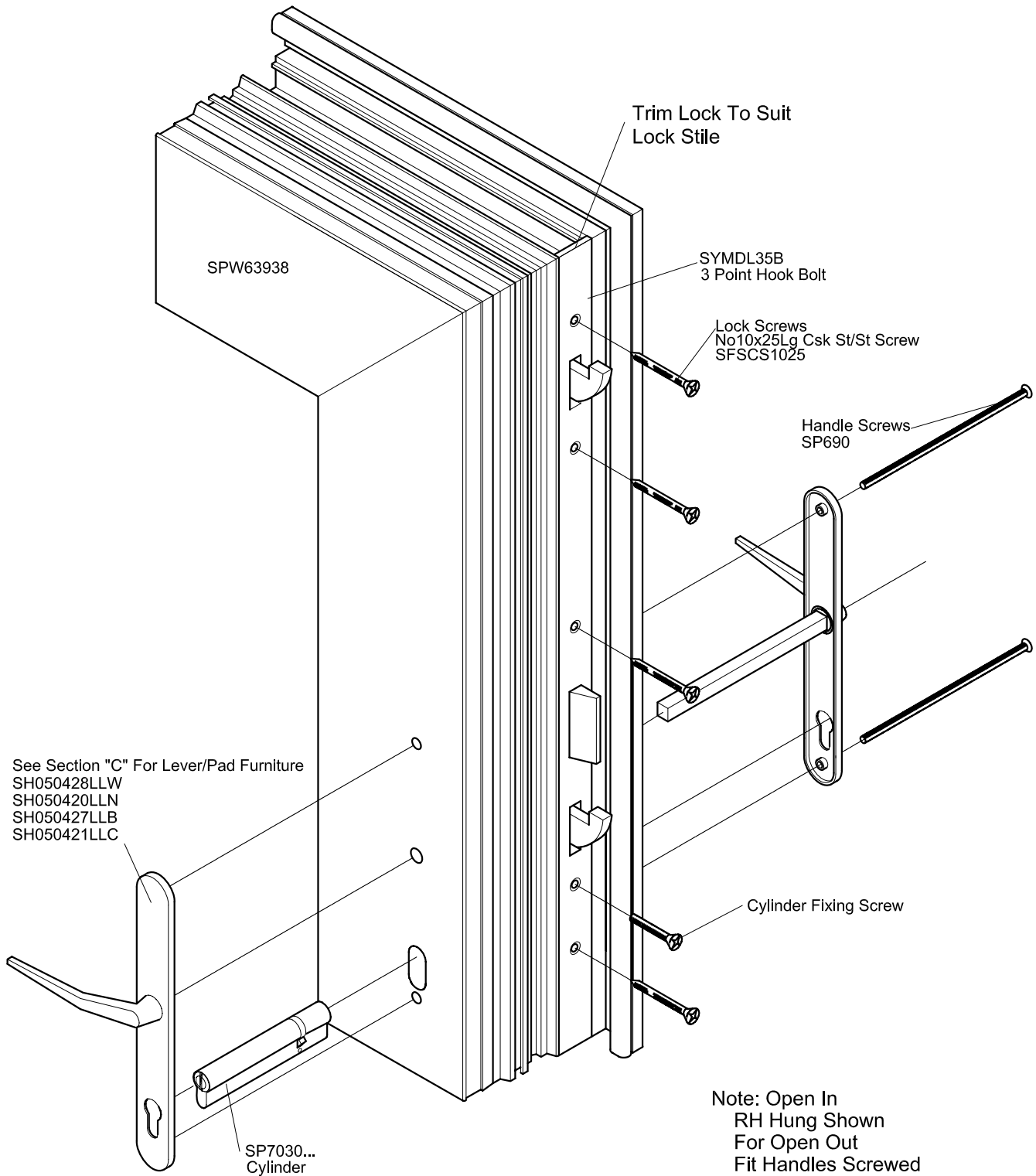
04.12



### FIT BOTTOM RAIL BEFORE CRIMPING TOP RAIL.

- 1) Drill Ø8.5mm hole in lock stile 60mm from the bottom. This needs to be drilled on the inside wall only.
- 2) Drill Ø8.5mm hole in hinge stile 60mm from the bottom. This needs to be drilled through both walls. The wall in the euro groove needs to be drilled/machined to Ø15 to allow the M8x50SKT.HD cap screw to pass through.
- 3) Drill Ø5mm holes to suit screw ports in bottom rail (See page SPW600e.E.401 for dimensions)
- 4) Cut the tie rod to length. (See Drawing).
- 5) Put on locking nut SFSLN08 and SPWTRC connecting sleeve onto tie rod and M8 Nut on the other end.
- 6) Put on SPW652 CT31 on both jambs.
- 7) Slide M8 nyloc nut and washer into the lock stile push the tie rod through drilled hole and tighten M8 nyloc nut onto the tie bar, with 3 threads visible.
- 8) Slide bottom rail over the tie bar and locate it on the shear block.
- 9) Locate bottom rail on lock stile shear block and join M8x50SKT.HD.cap screw with SPWTRC connecting sleeve and tighten.
- 10) Locate SFSP-05 screws into drilled holes for screw ports and tighten.



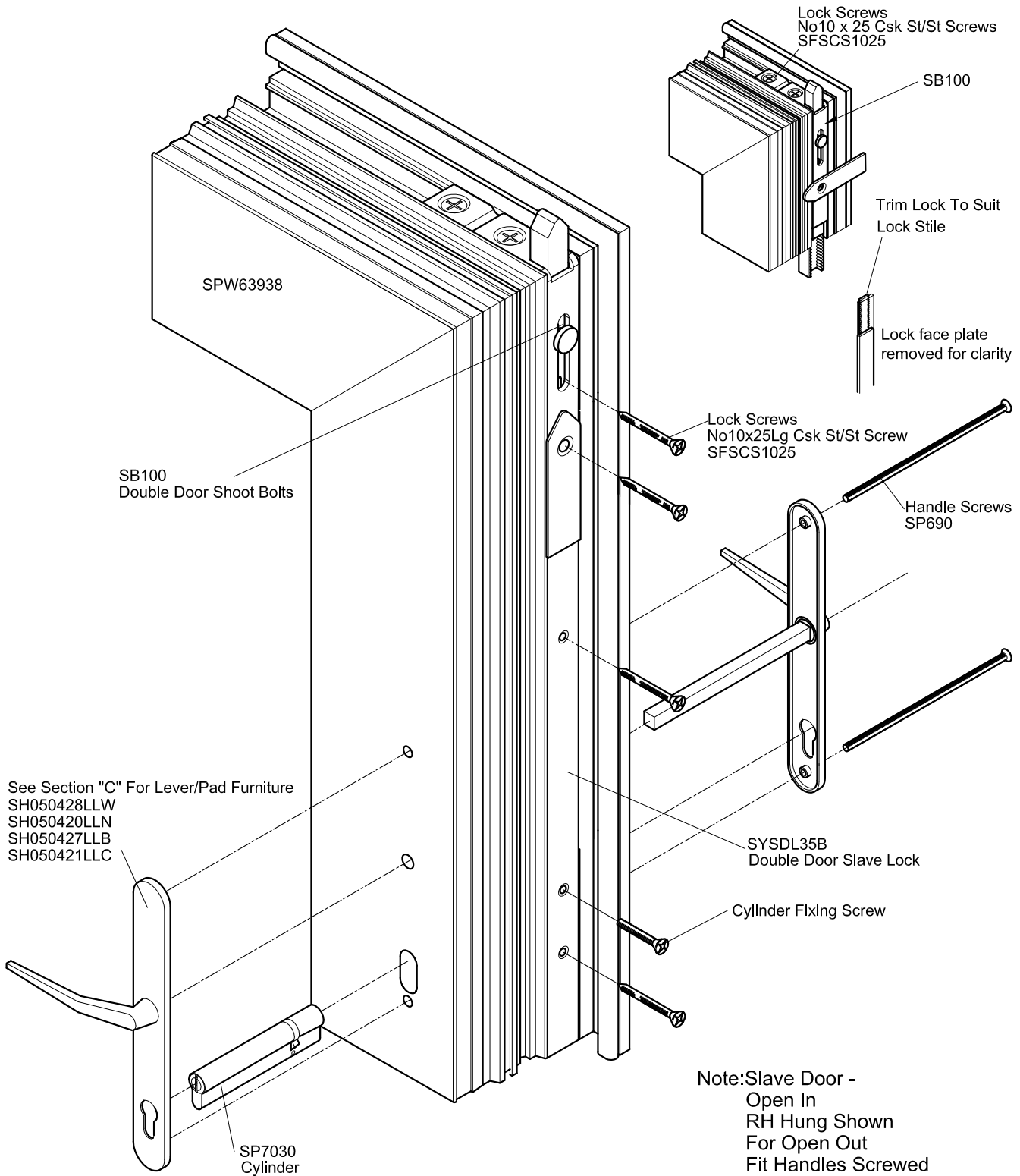


# SPW600e Door

## Assembly - Door Furniture - Shoot Bolt

SPW600e.E.408

03.15



SPW600e.E.409

01.13

SPW600e Door

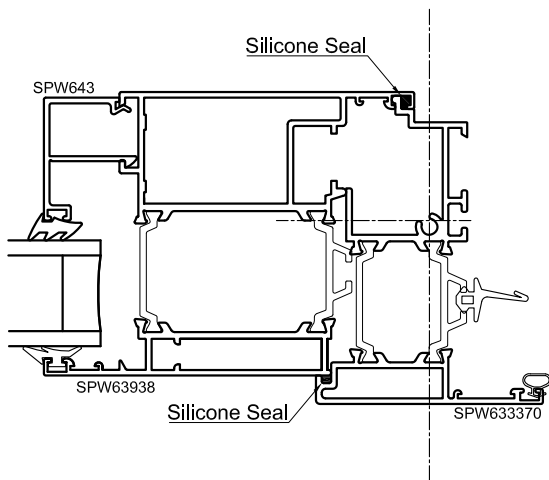
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# SPW600e Door

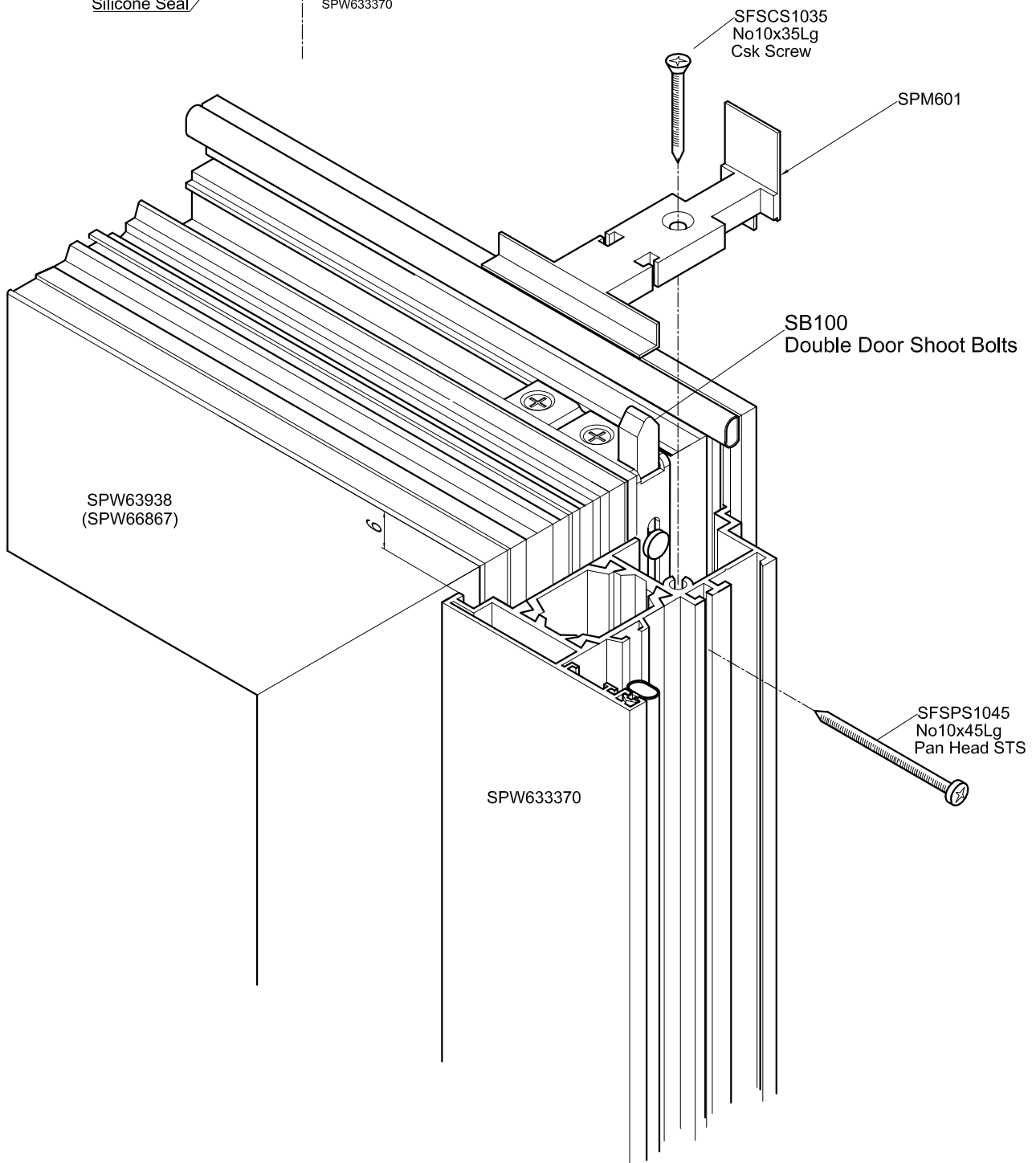
SPW600e.E.410

## End Moulding For Double Door Dummy Mullion

03.15



Note: Mouldings are symmetrical. SPW63370 May Be Attached To A Left Or Right Hand Slave Leaf. Fix To Slave Door With #10x45Lg Pan Head Self Tapping St/St Screws 25mm From Each End & 150mm Centres.



SPW600e.E.411

SPW600e Door

04.12 Installation For Adjustable Surface Closer AXFC1500BCAL - O/I

DETAILS IN DEVELOPMENT

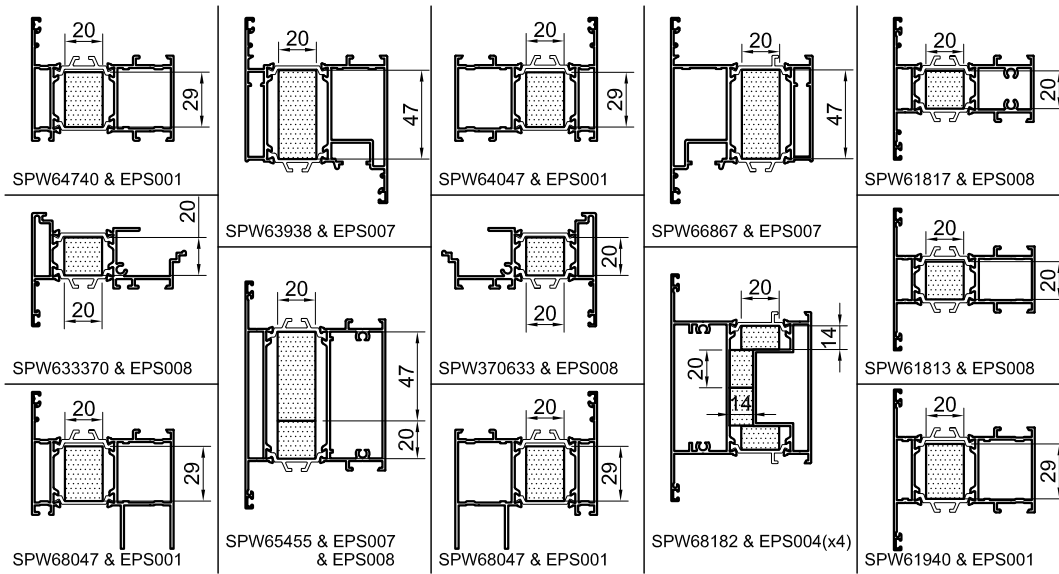
# SPW600e Door

SPW600e.E.412

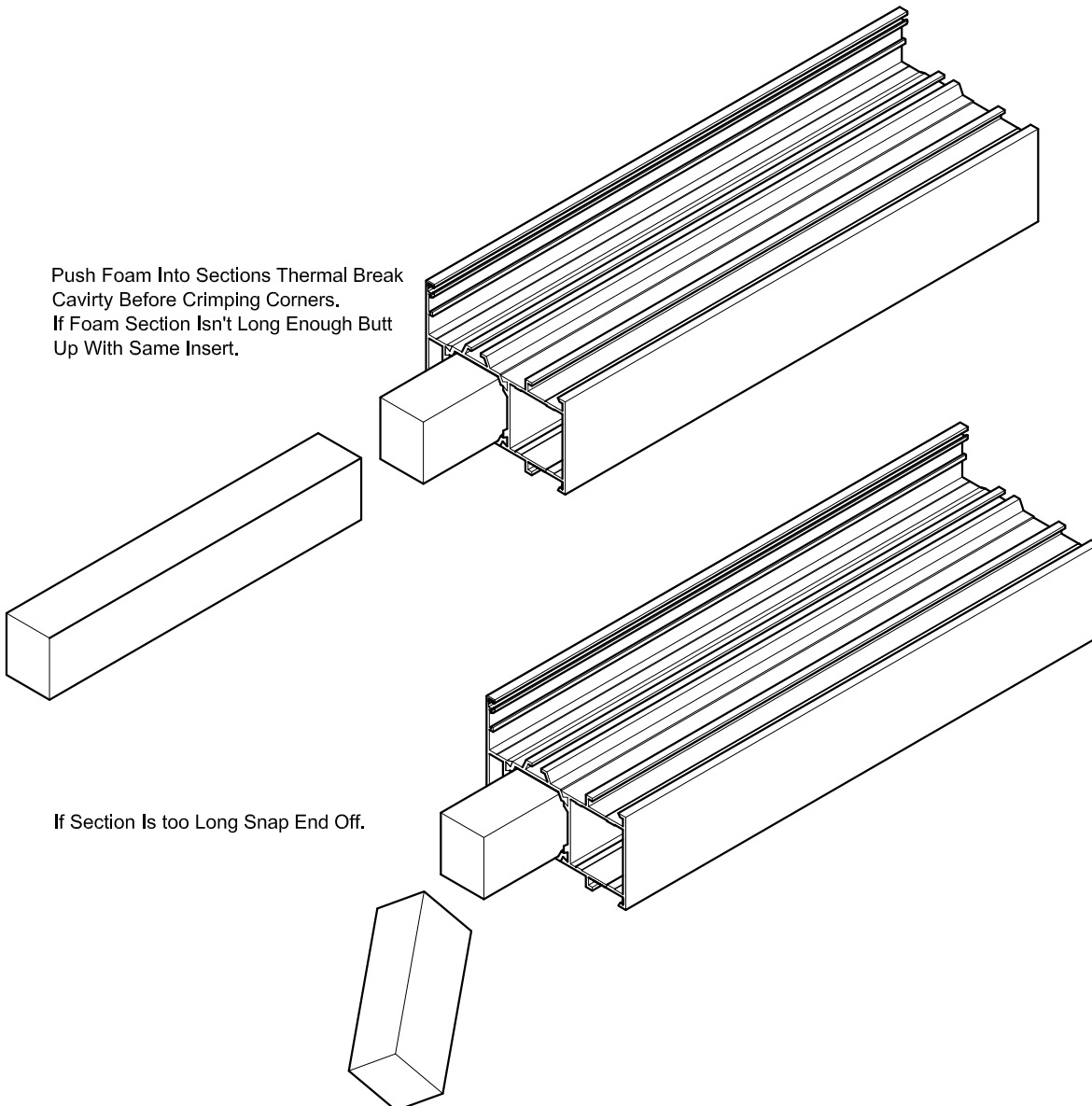
Installation For Adjustable Surface Closer AXFC1500BCAL - O/O

04.12

DETAILS IN DEVELOPMENT



Push Foam Into Sections Thermal Break Cavity Before Crimping Corners.  
If Foam Section Isn't Long Enough Butt Up With Same Insert.



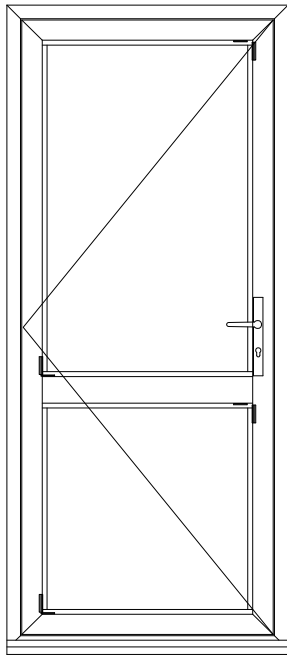
# SPW600e Door

Blank

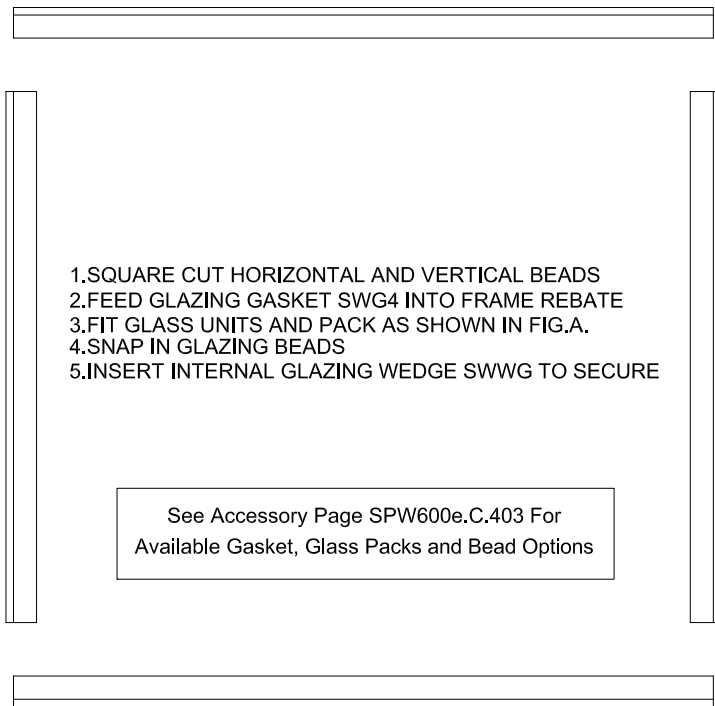
SPW600e.E.414

04.12

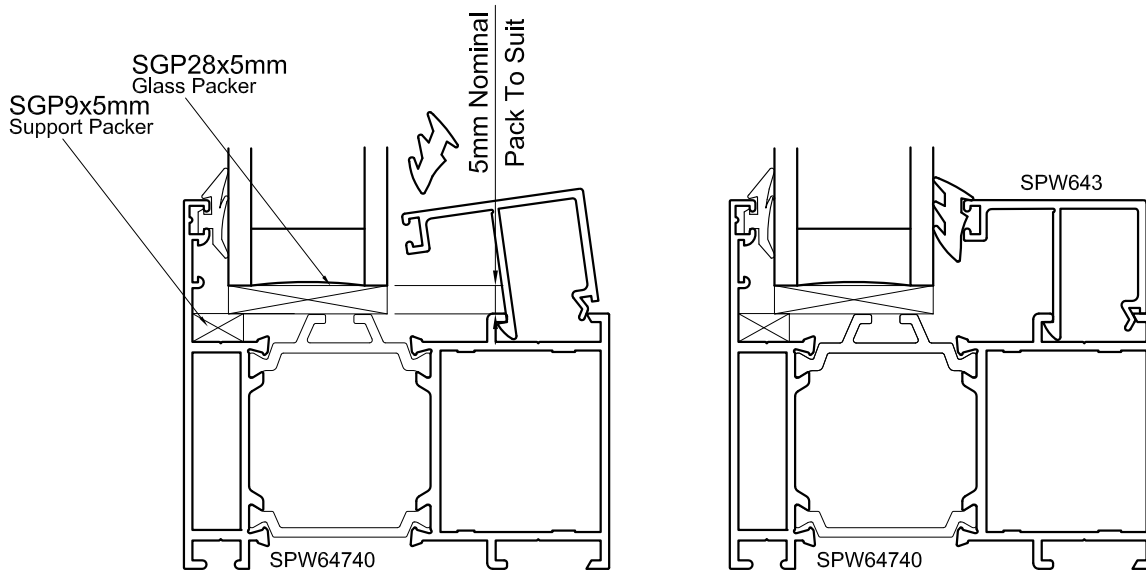
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**FIGURE A - CONVENTIONAL GLASS PACKING**



**FIGURE B - BEAD CUTTING**



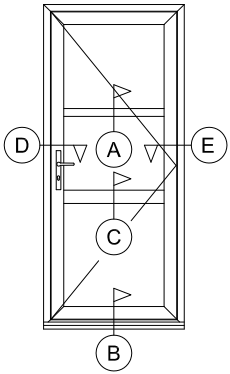
### Internal Glazing

# SPW600e Door

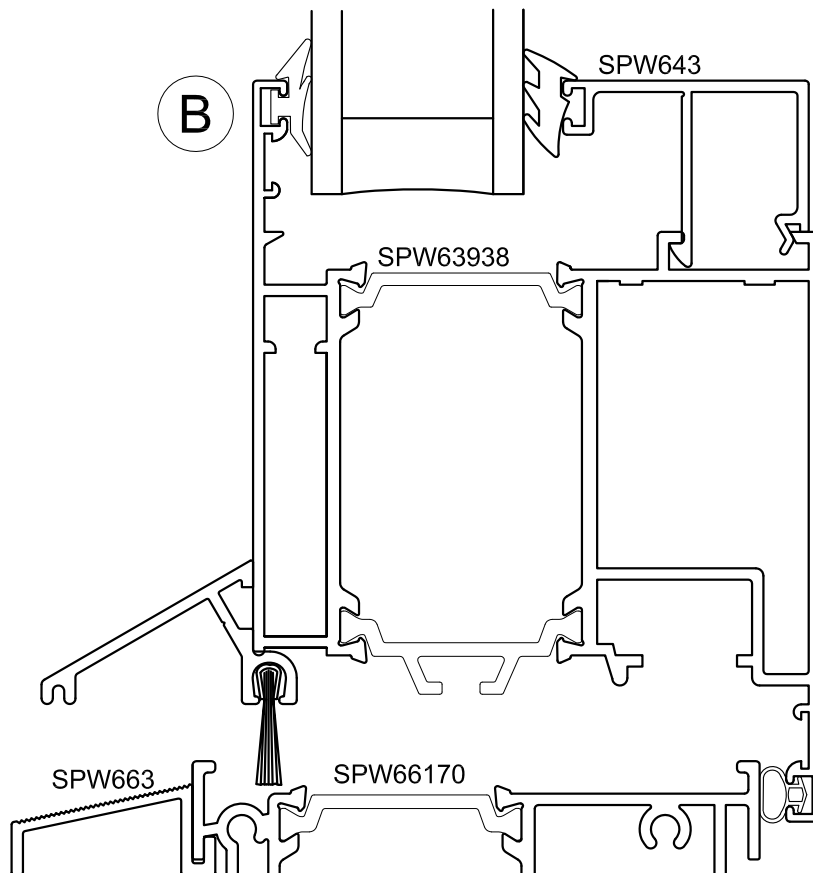
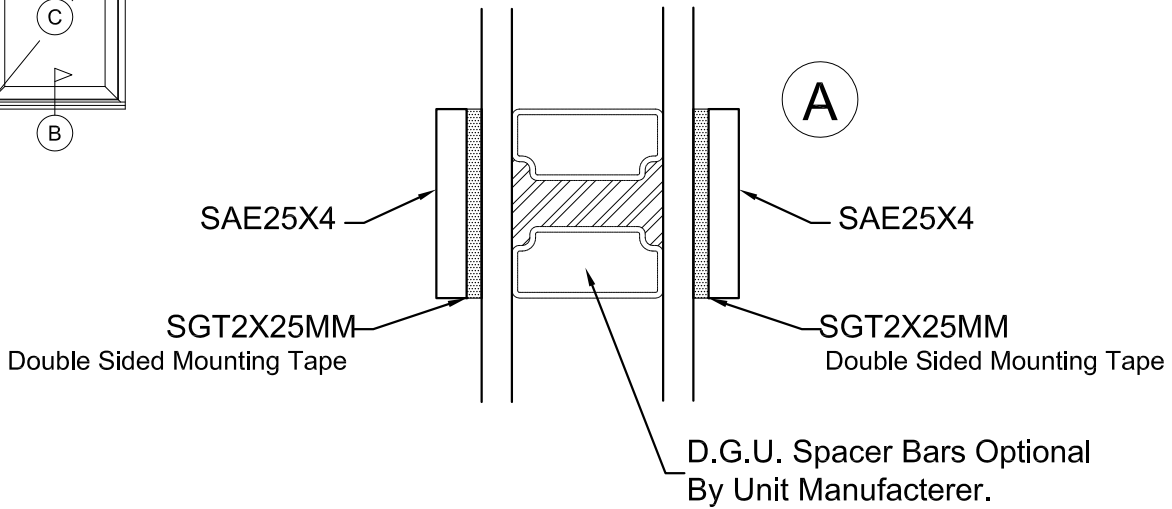
SPW600e.F.402

Georgian Bar

04.12



NOTE: LEAVE A 1MM GAP AT ALL JOINTS FOR EXPANSION. GLASS & BAR MUST BE CLEANED USING ANY INDUSTRIAL METHYLATED SPIRIT BEFORE APPLICATION. APPLY WITH A LINT FREE CLOTH. WHITE SPIRIT MUST NOT BE USED AS IT WILL AFFECT ADHESION.



# SPW600e.G.401

# SPW600e Door

## Slotted Trickle Vent Detail

04.12

Internal Vent Unit  
in Open Position

Overall Slot Size

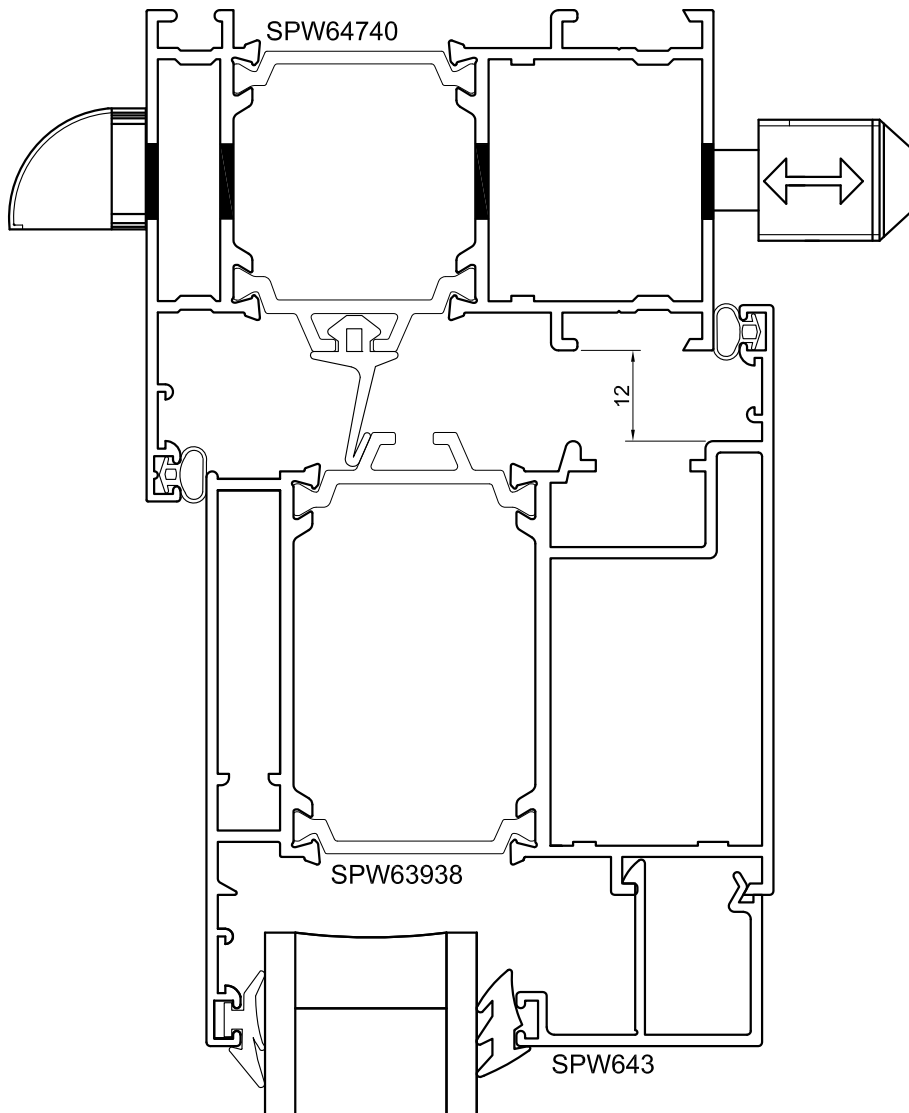
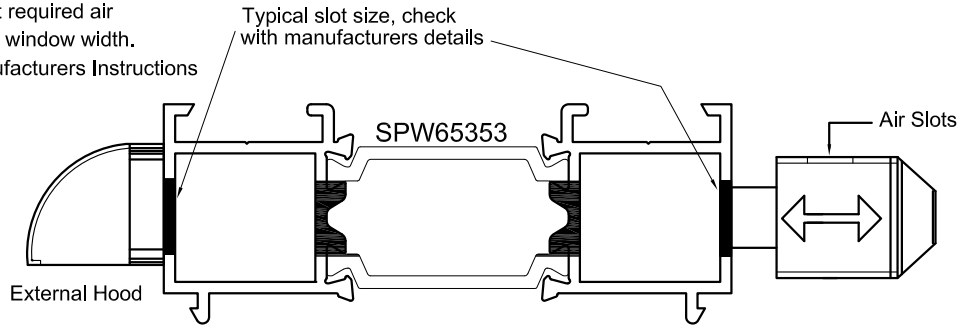
10mm x 205mm min.

10mm x 605mm max.

or to suit required air

flow and window width.

To Manufacturers Instructions

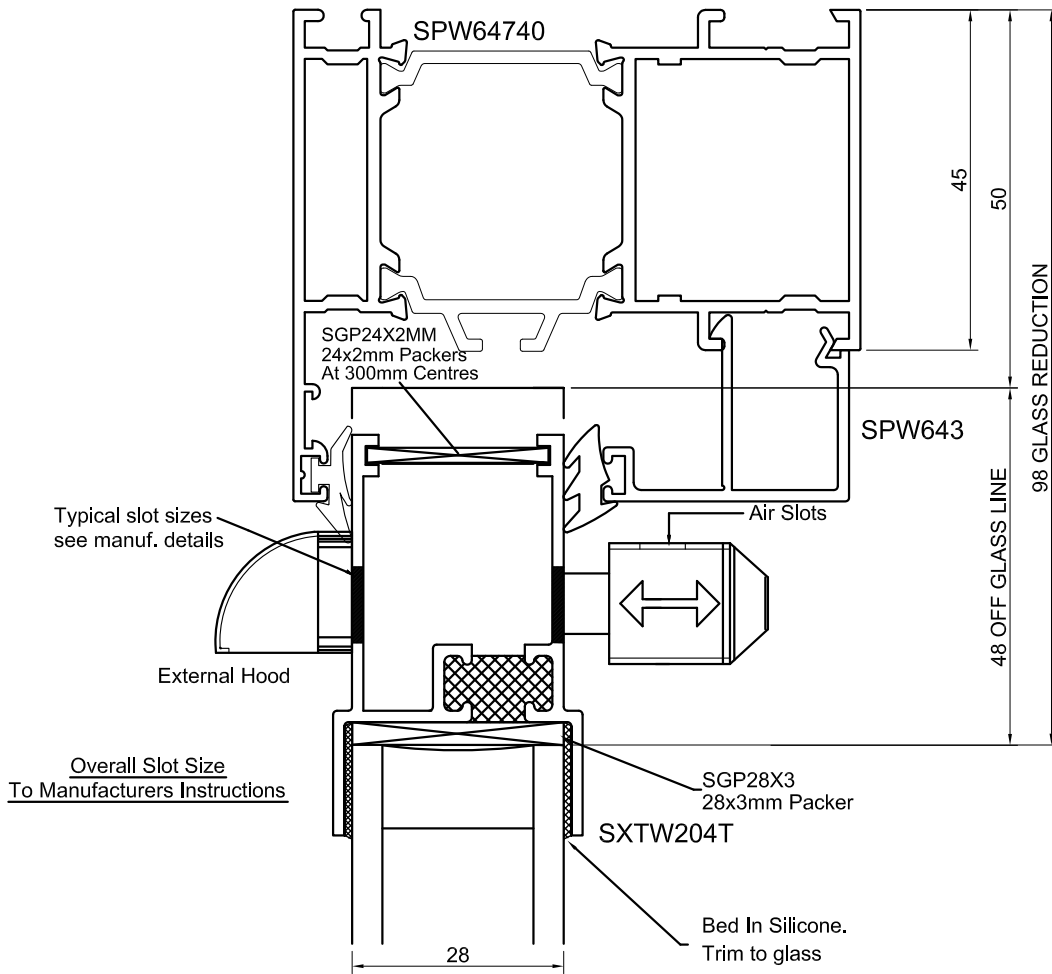


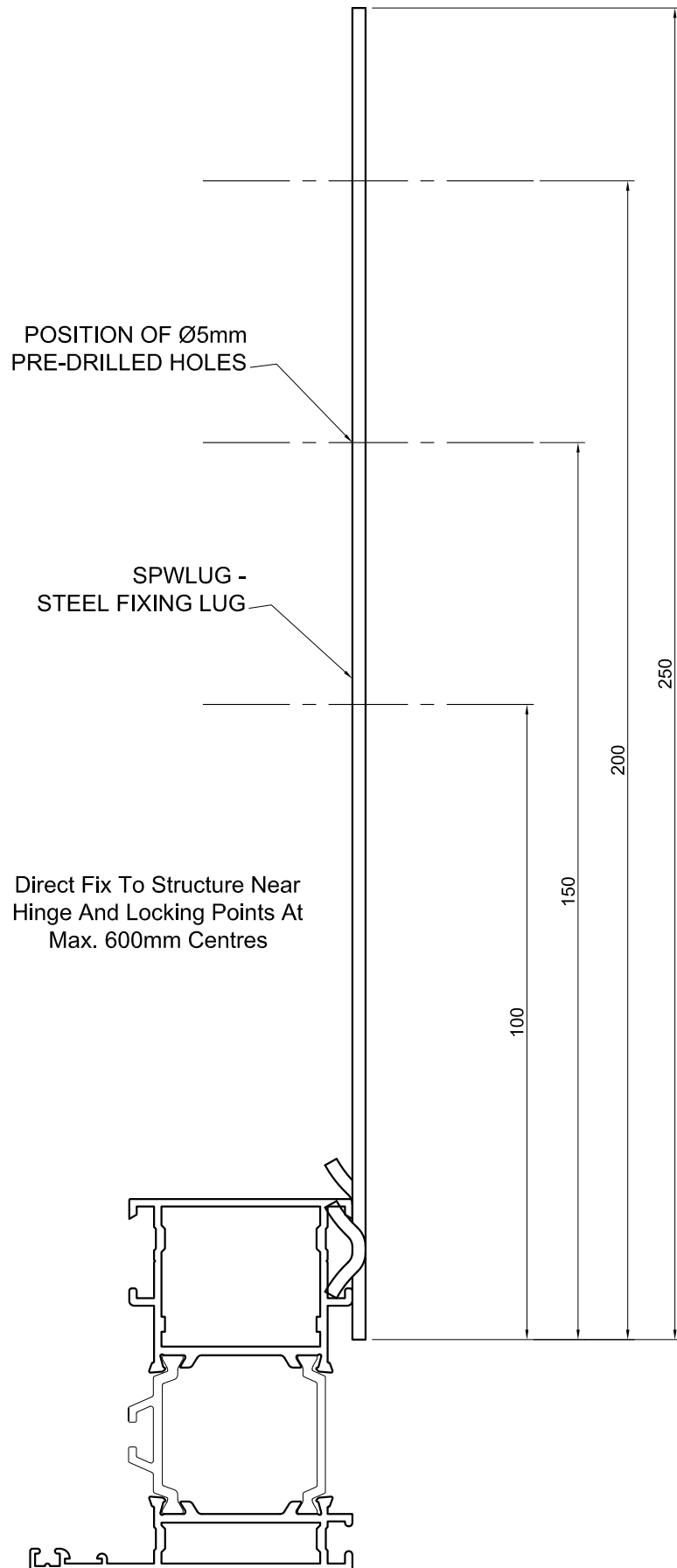
# SPW600e Door

SPW600e.G.402

## 28mm Overglass Trickle Vent Carrier Detail

04.12



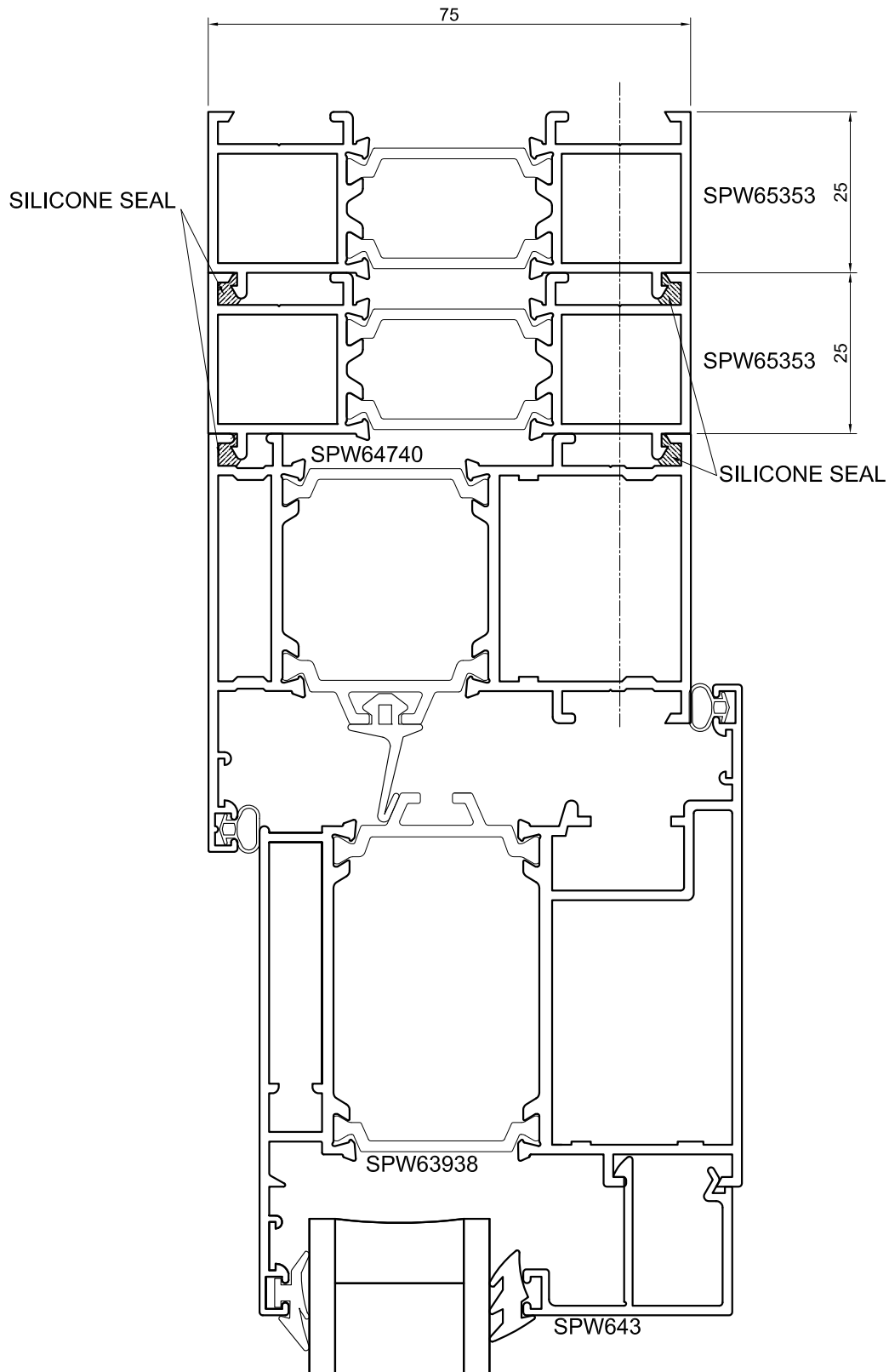


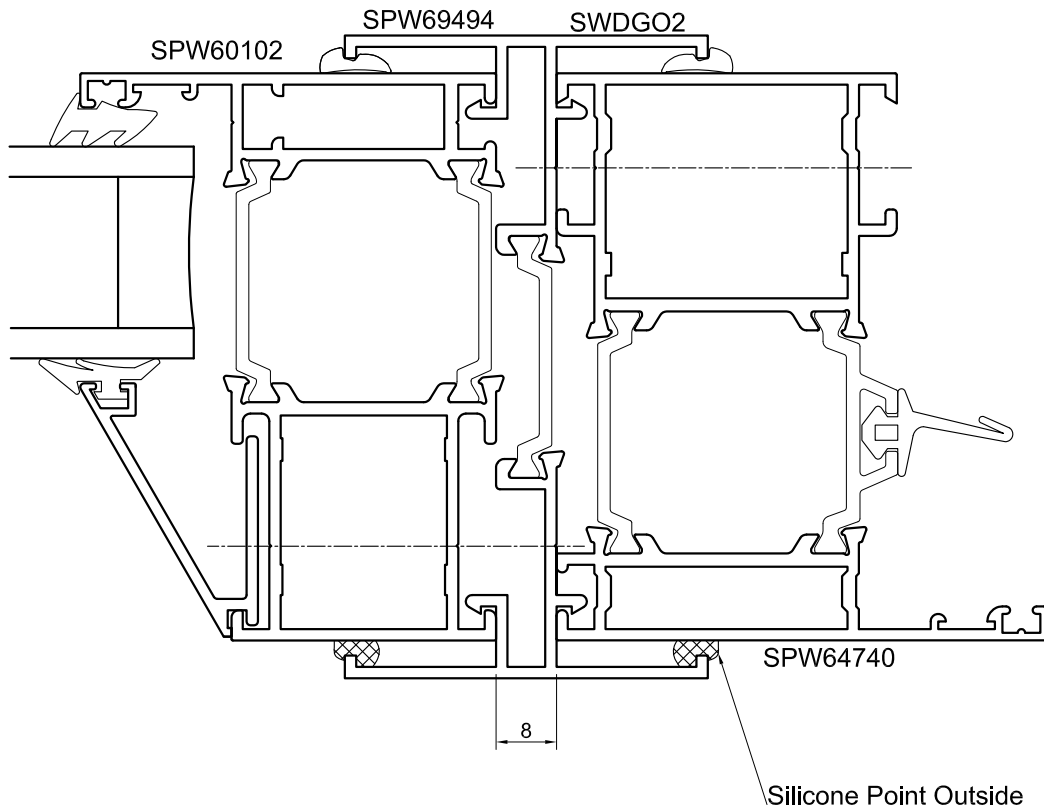
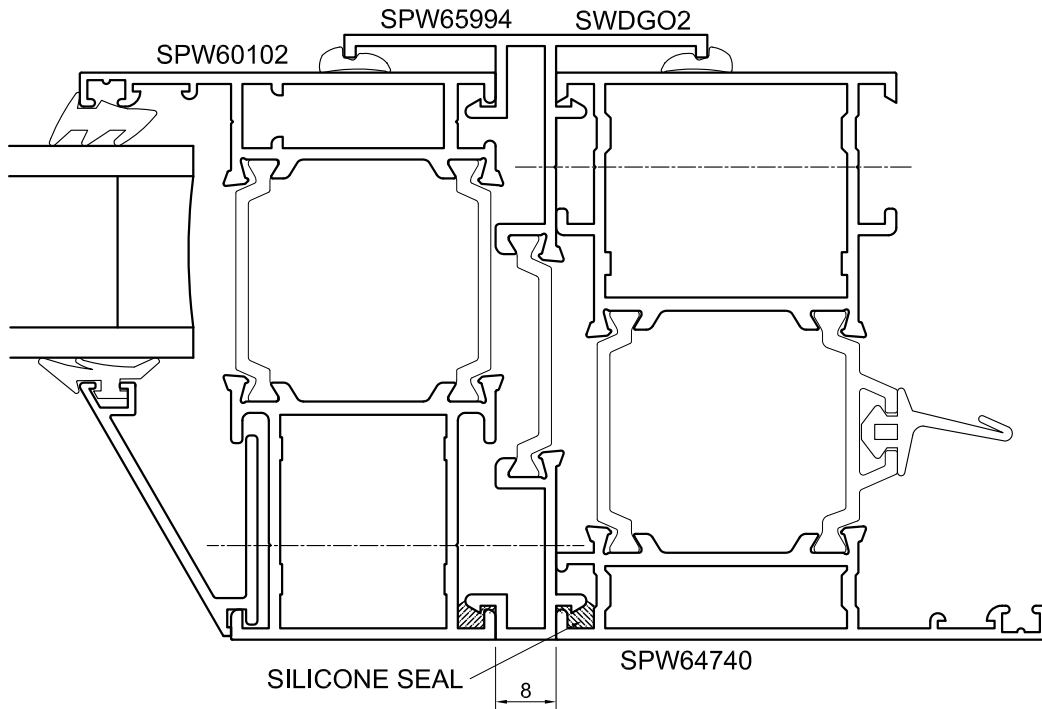
# SPW600e Door

25mm Add-Ons

SPW600e.G.404

04.12



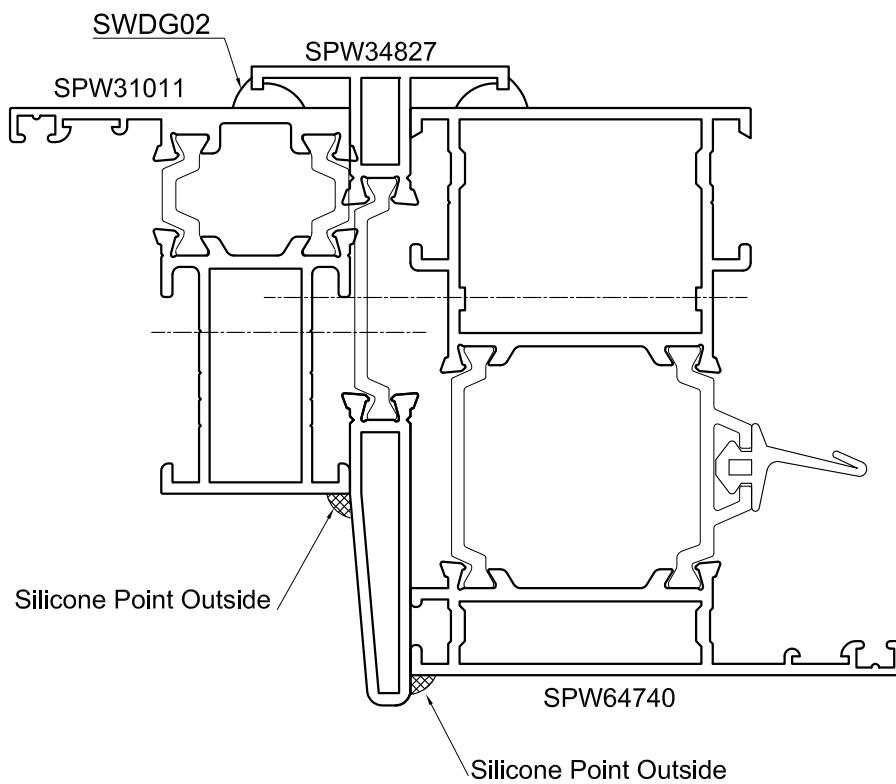
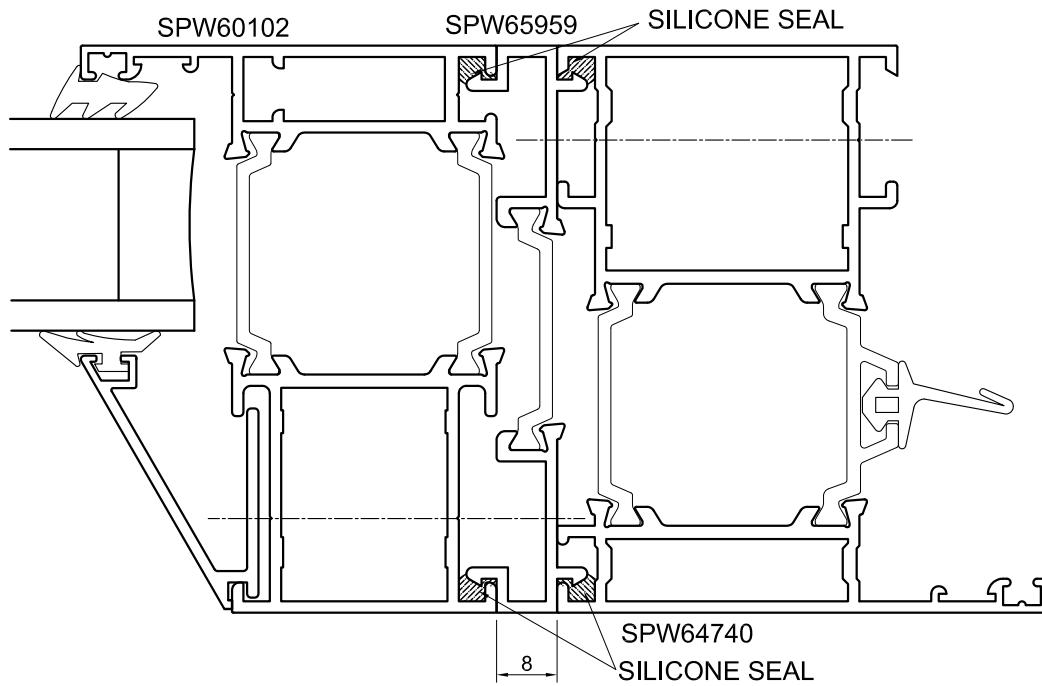


# SPW600e Door

Couplers

SPW600e.G.406

04.12

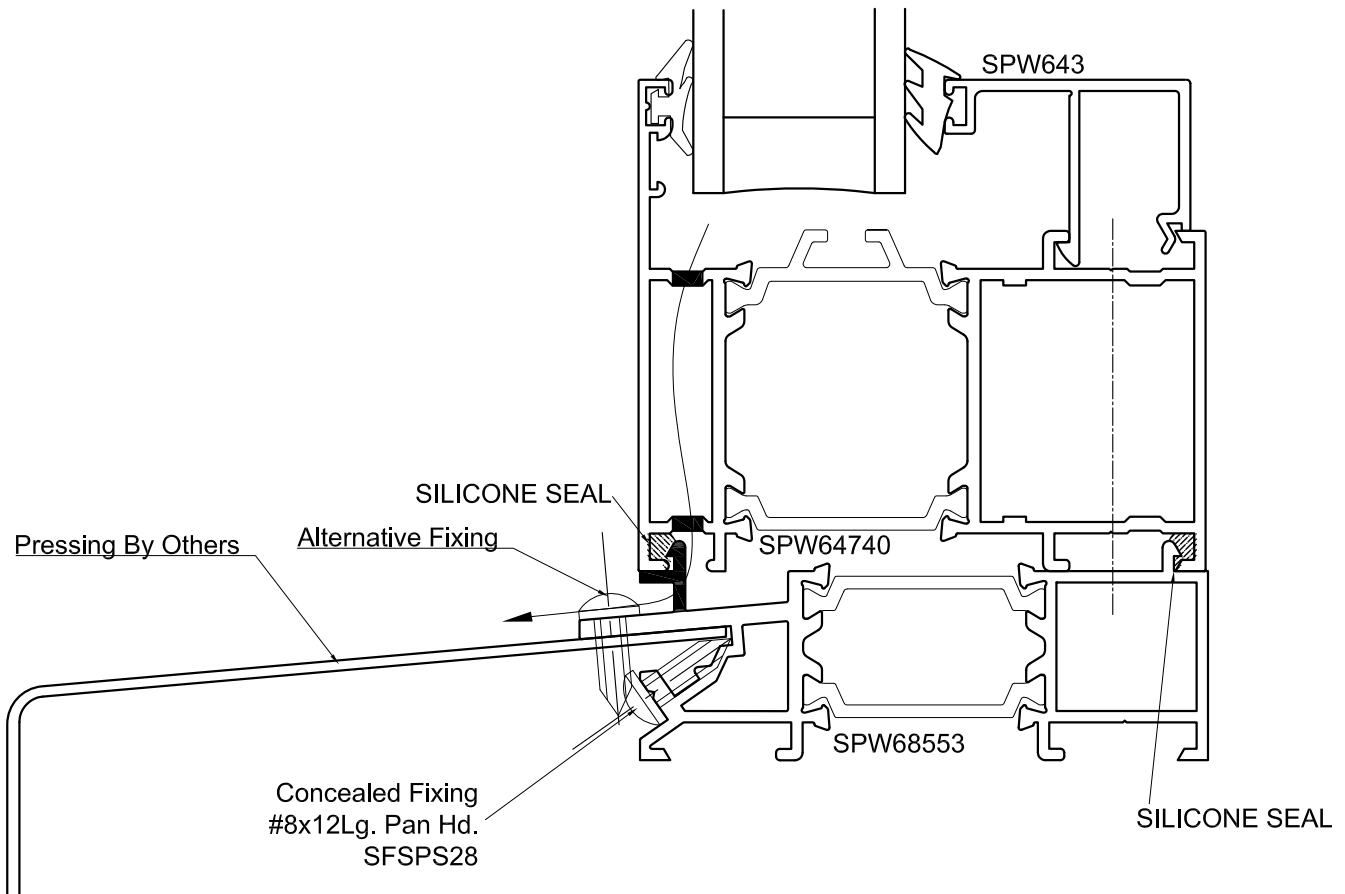
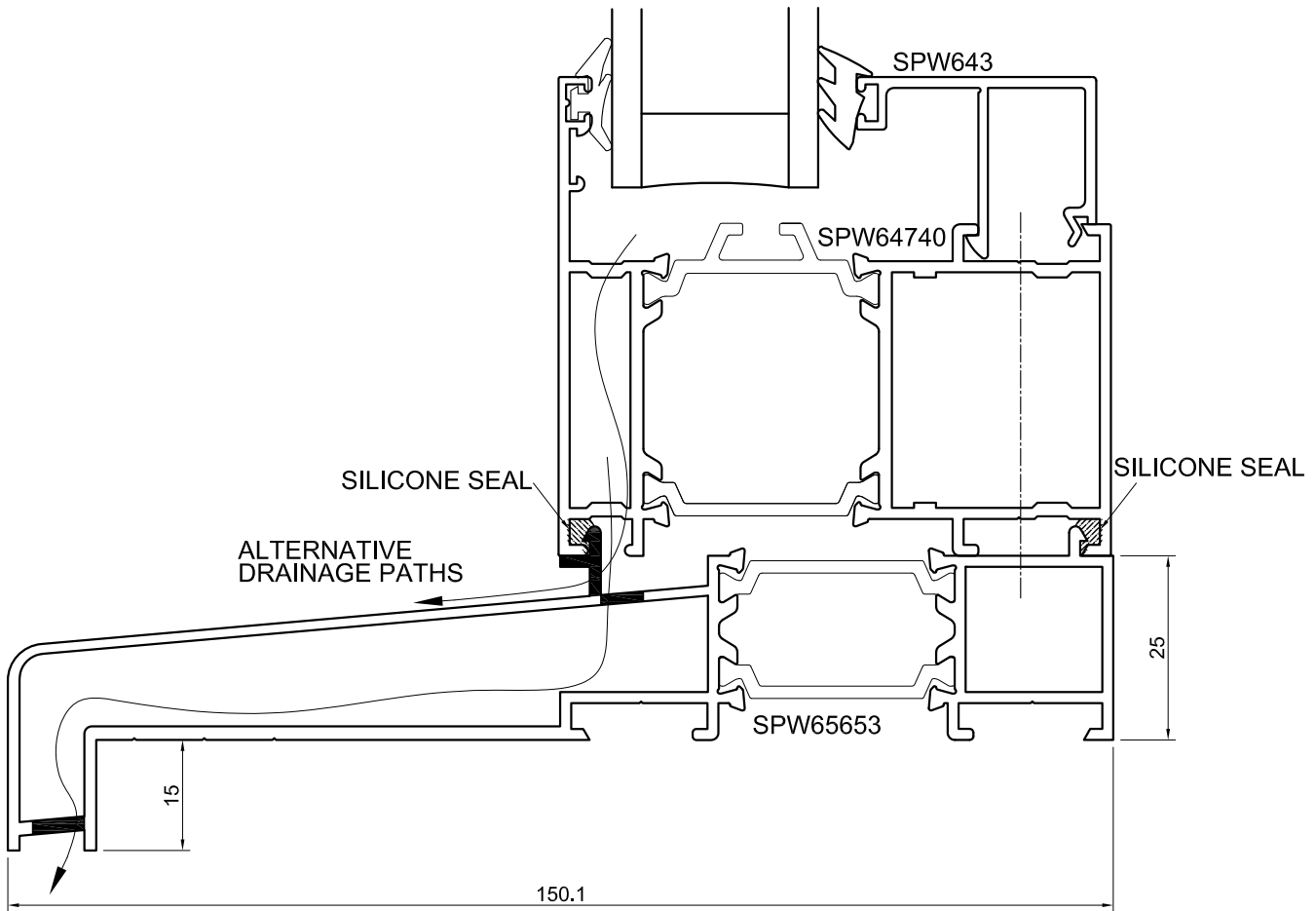


SPW600e.G.407

04.12

# SPW600e Door

150mm Cill & Drainage Tray

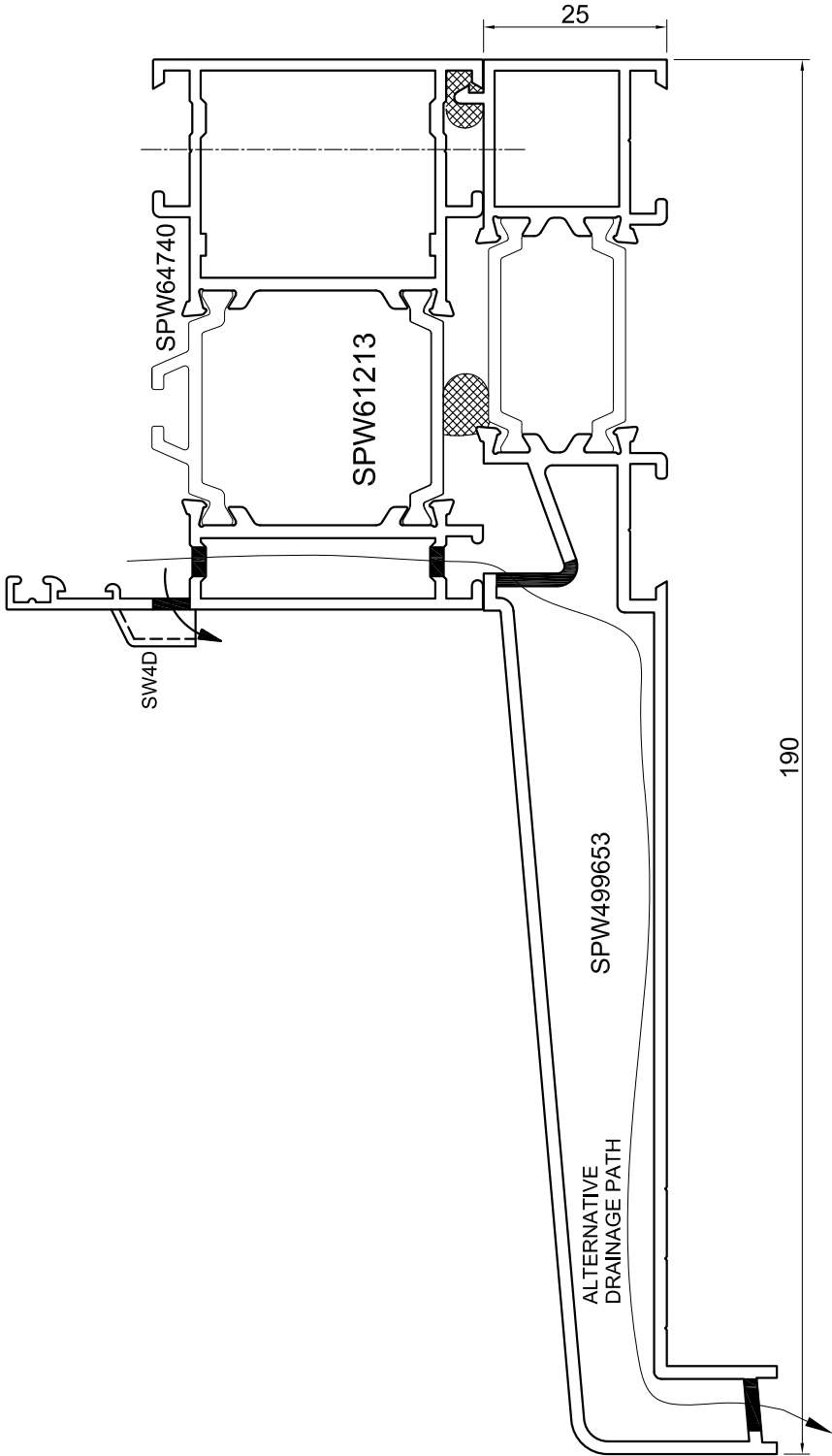


# SPW600e Door

190mm Cill

SPW600e.G.408

04.12

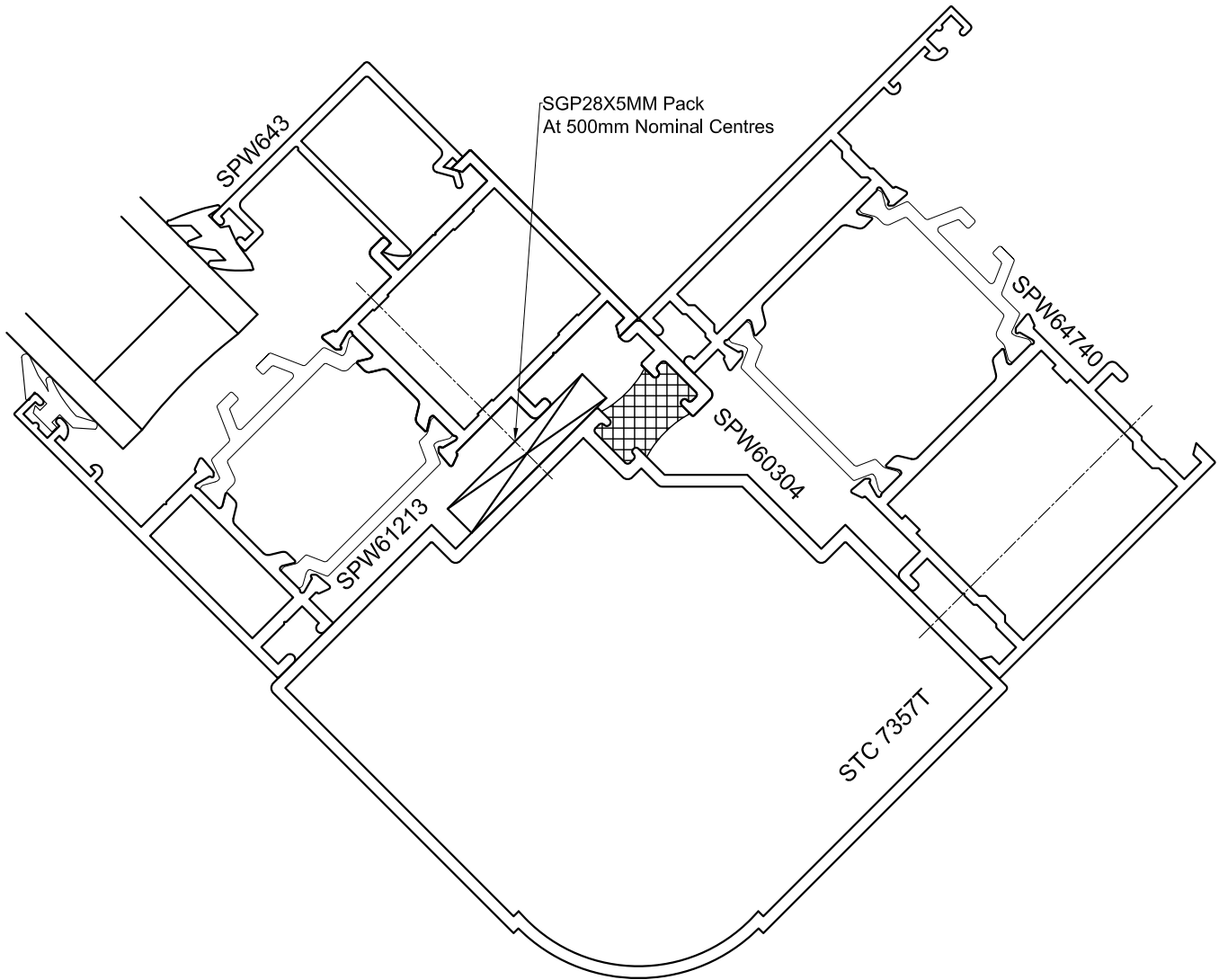


SPW600e.G.409

04.12

# SPW600e Door

Corner Post - STC7357T

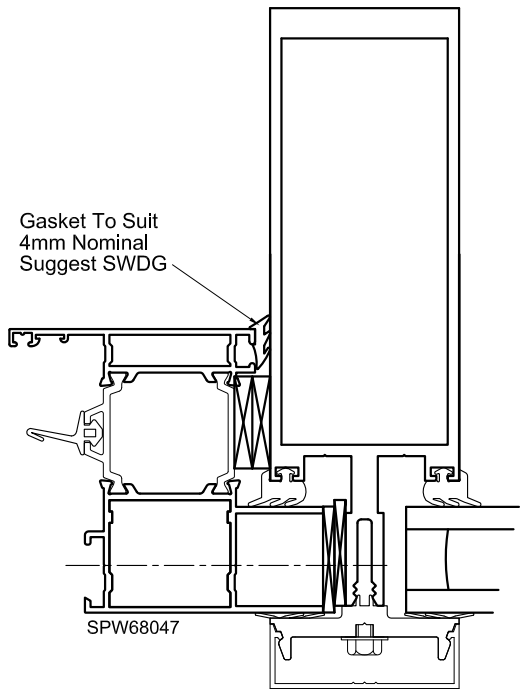


# SPW600e Door

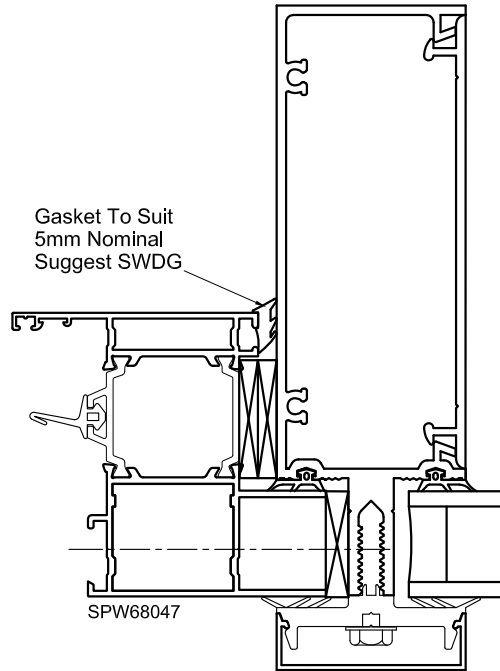
SPW600e.G.410

## Curtain Wall Inserts Fixing And Packing Positions

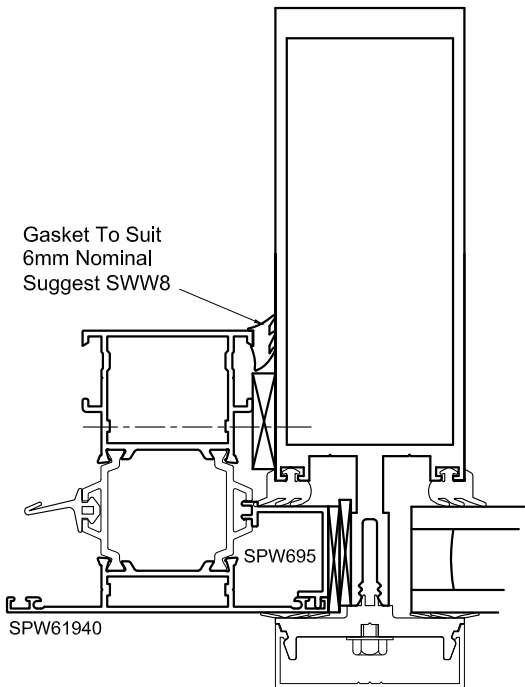
04.12



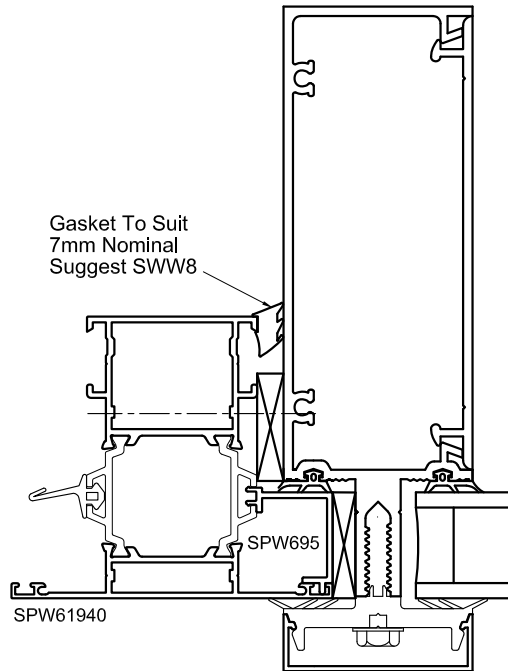
OPEN OUT INTO SMR900 SHOWN  
OPEN OUT INTO SMR800 SIMILAR



OPEN OUT INTO SCW SHOWN  
OPEN OUT INTO SCW+ SIMILAR



OPEN OUT INTO SMR900 SHOWN  
OPEN OUT INTO SMR800 SIMILAR



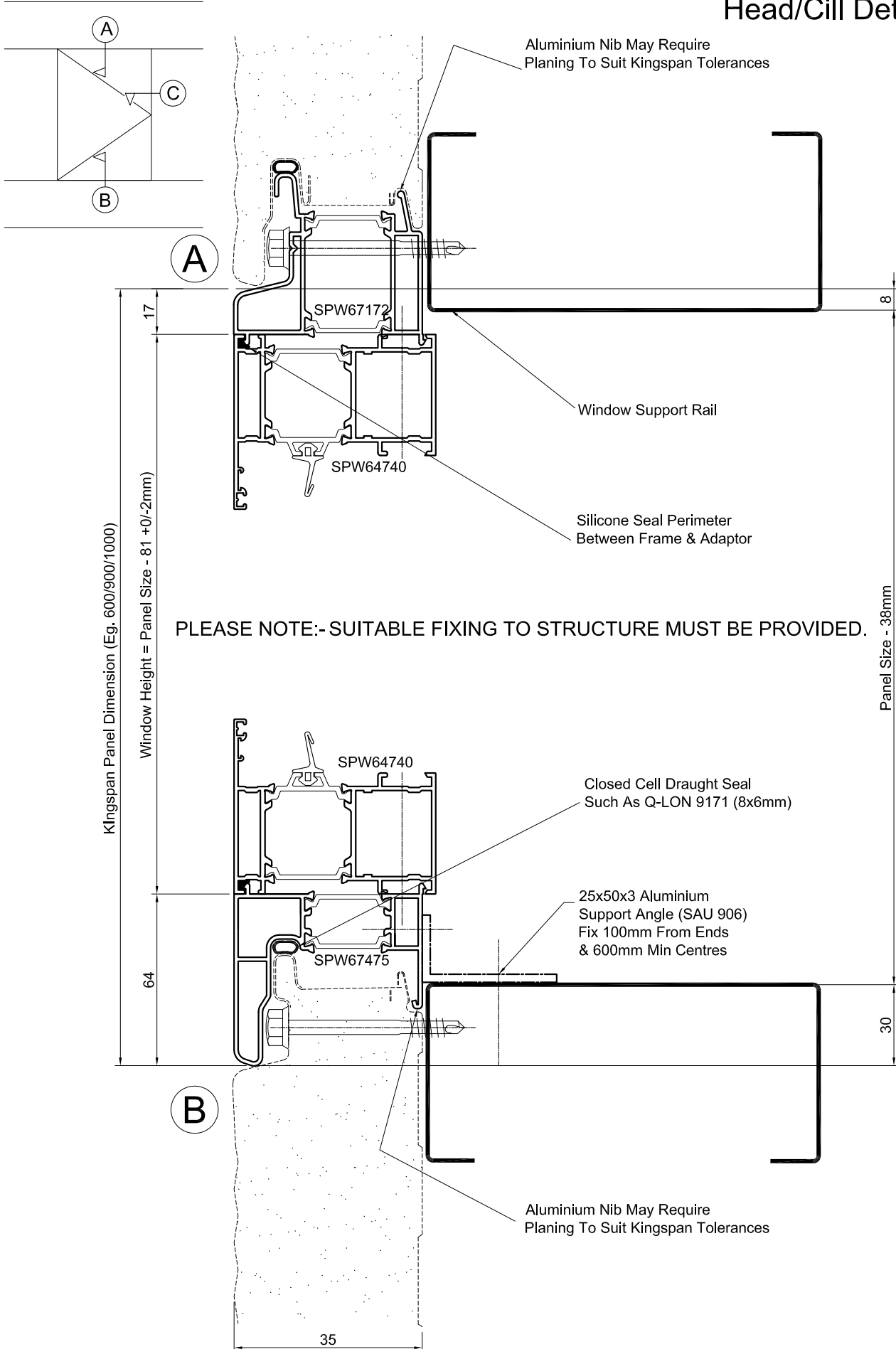
OPEN OUT INTO SCW SHOWN  
OPEN OUT INTO SCW+ SIMILAR

# SPW600e.H.401

04.12

# SPW600e Door

## Kingspan Adaptor - 70mm Head/Cill Detail



# SPW600e Door

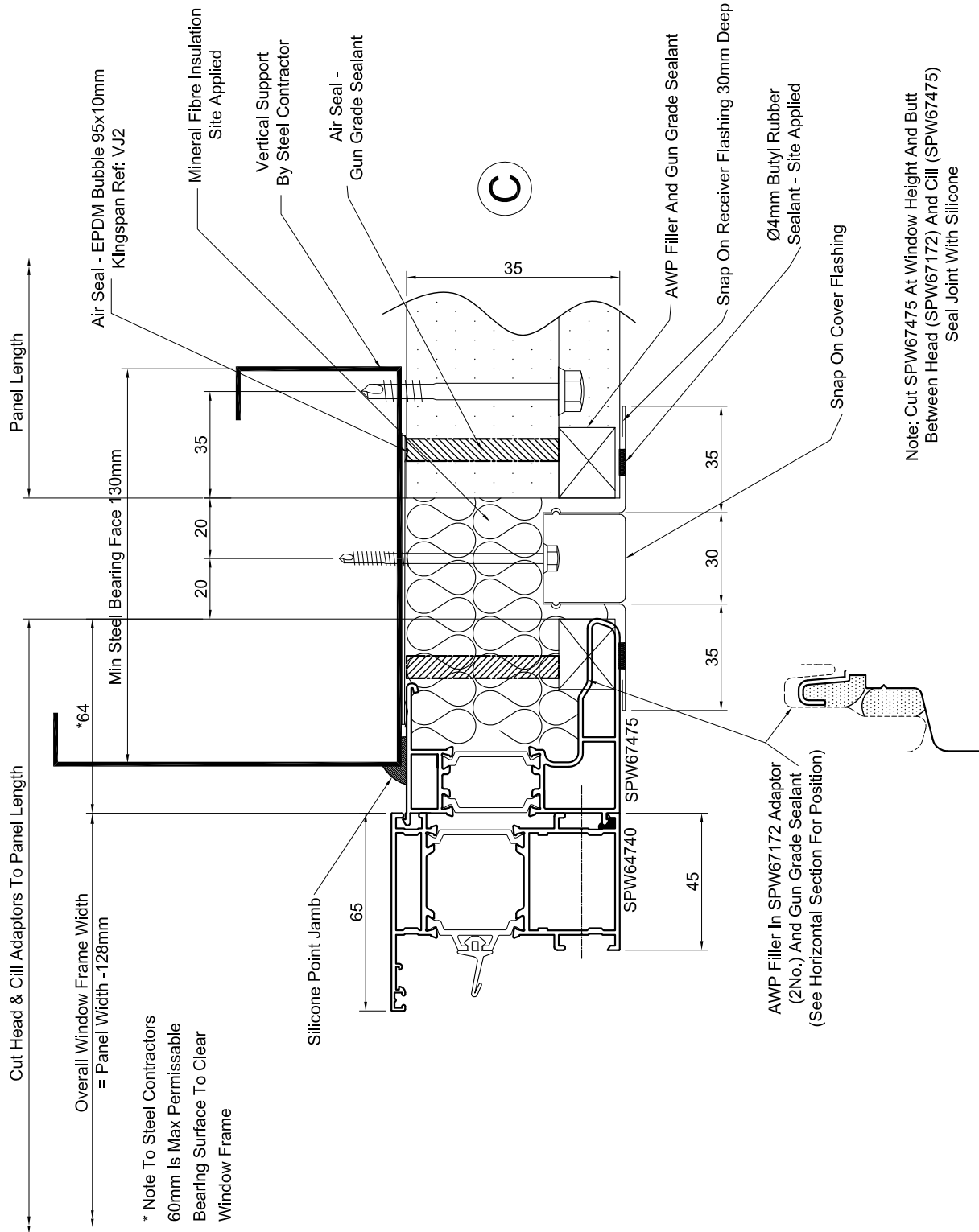
Kingspan Adaptor - 70mm

Side Jamb Detail

SPW600e.H.402

04.12

PLEASE NOTE:- SUITABLE FIXING TO STRUCTURE MUST BE PROVIDED.



Note: Cut SPW67475 At Window Height And Butt Between Head (SPW67172) And Cill (SPW67475) Seal Joint With Silicone

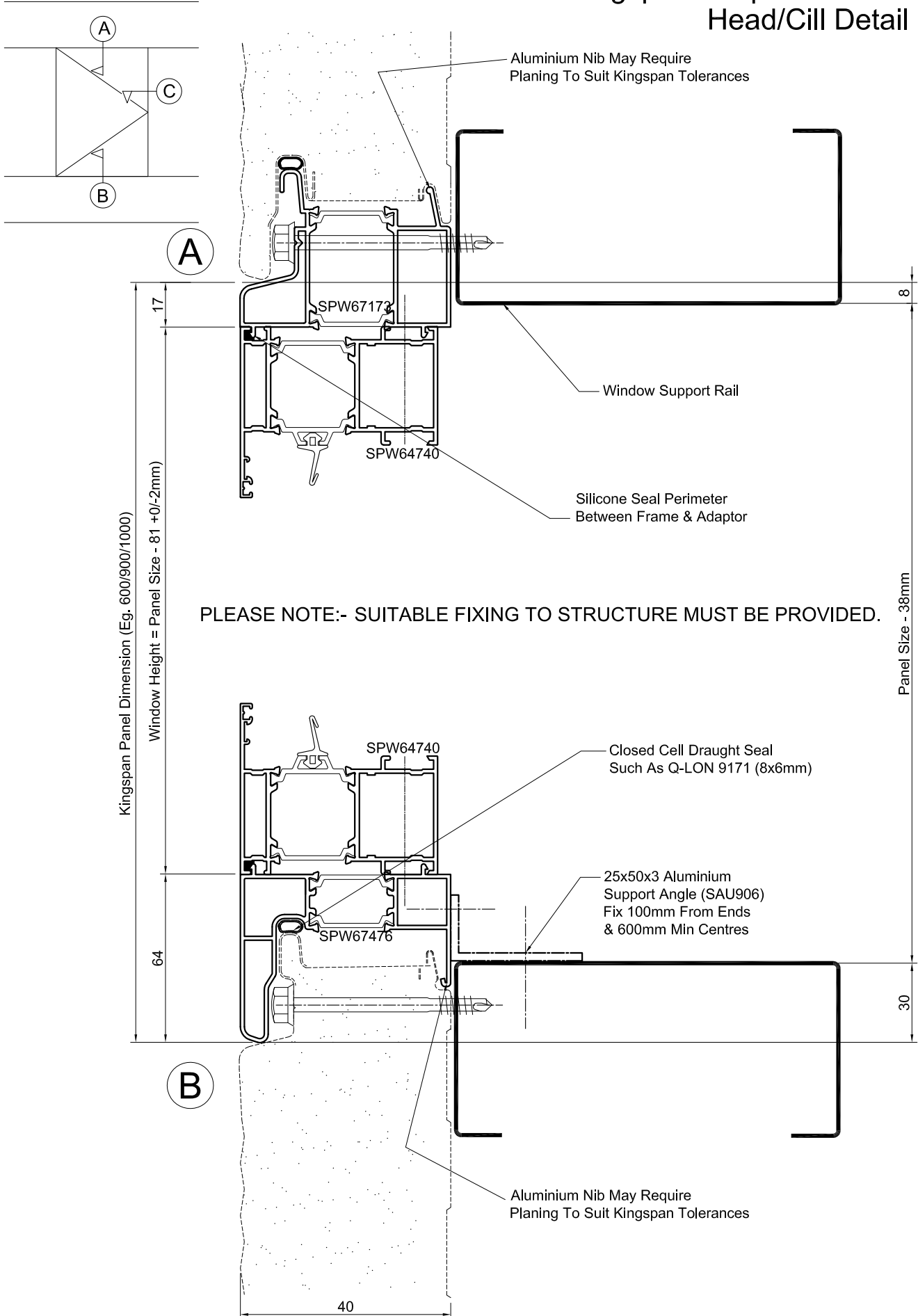
\* Note To Steel Contractors  
60mm Is Max Permissible  
Bearing Surface To Clear  
Window Frame

# SPW600e.H.403

04.12

# SPW600e Door

## Kingspan Adaptor - 80mm Head/Cill Detail



# SPW600e Door

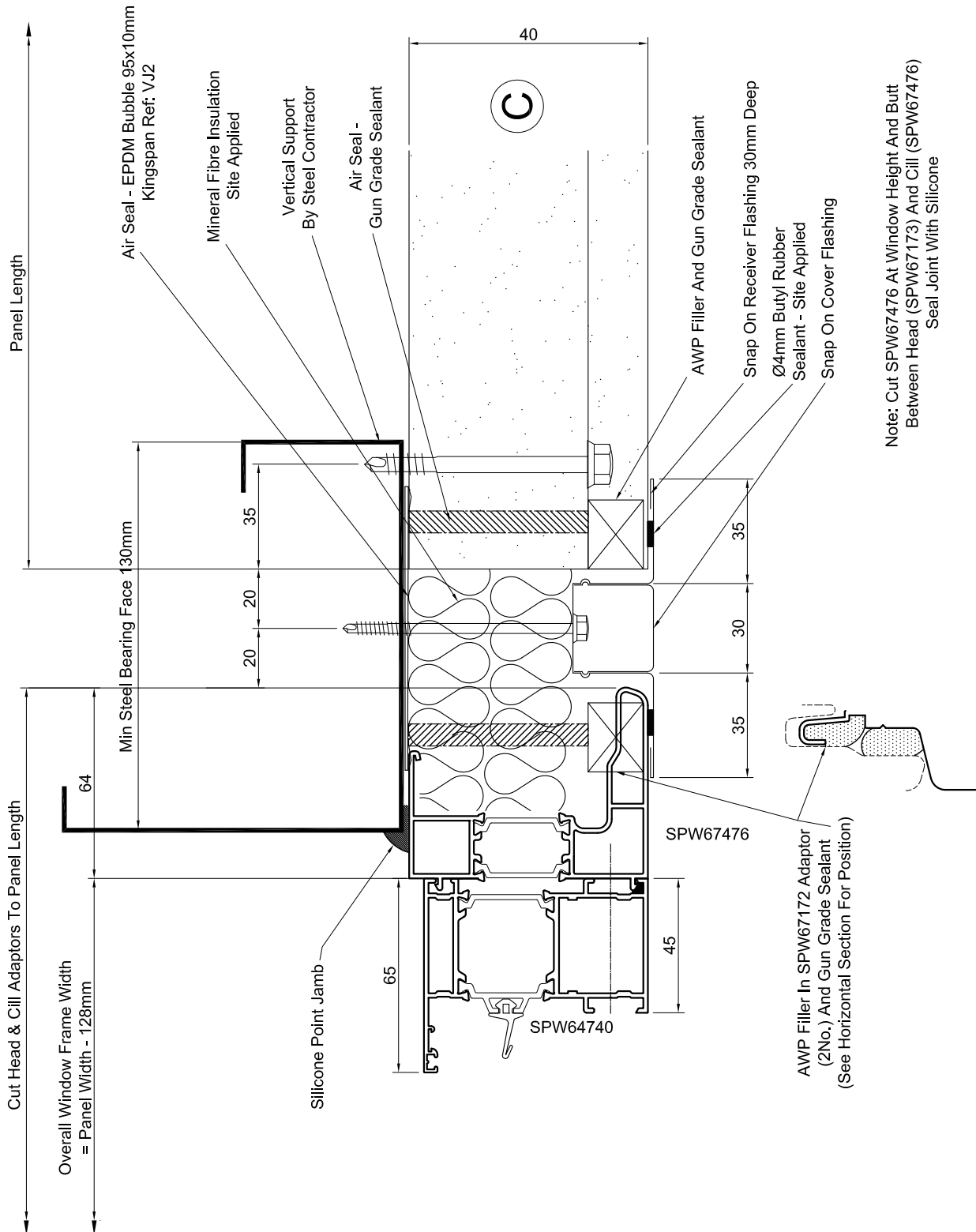
Kingspan Adaptor - 80mm

Side Jamb Detail

SPW600e.H.404

04.12

PLEASE NOTE:- SUITABLE FIXING TO STRUCTURE MUST BE PROVIDED.

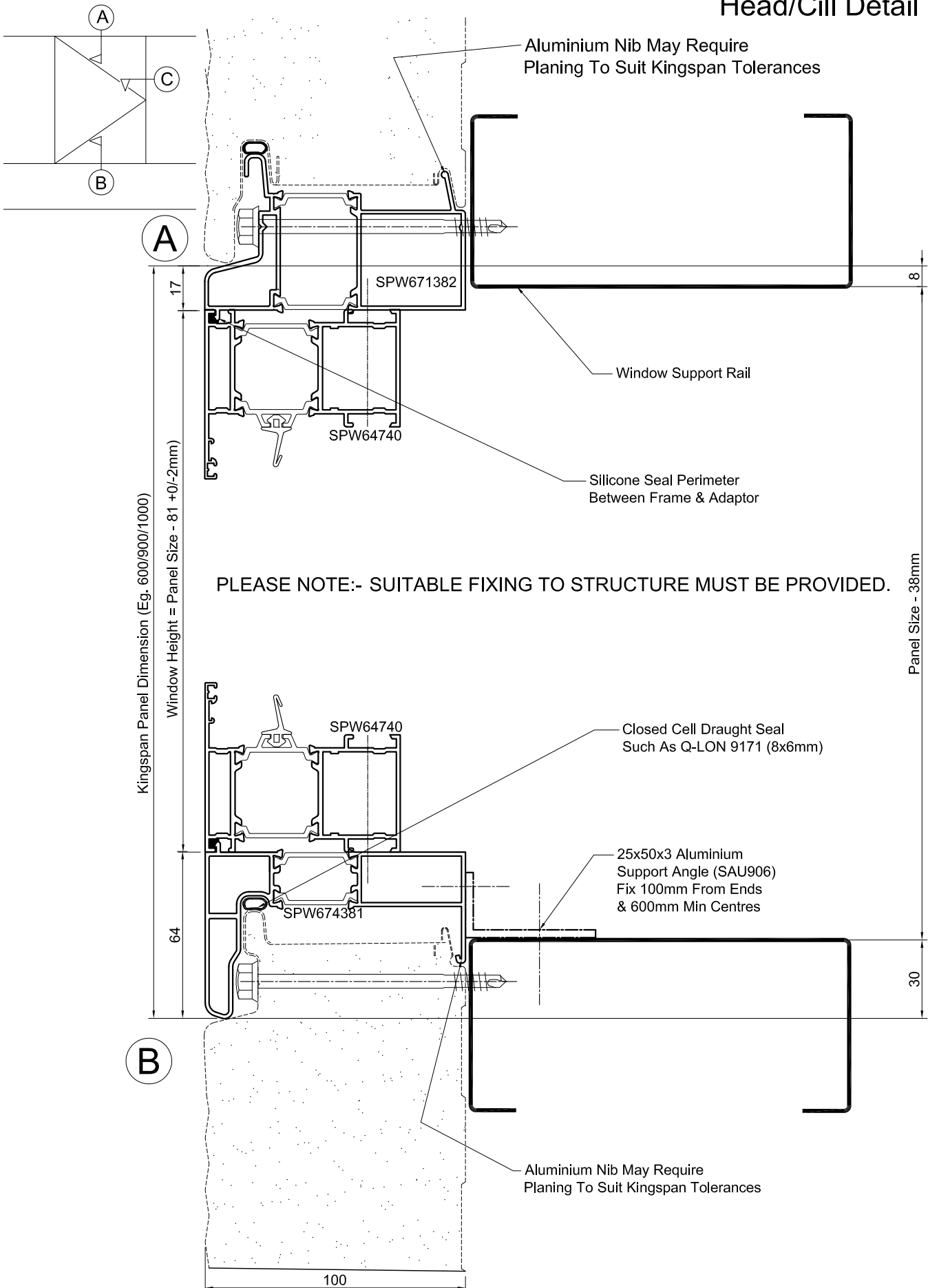


# SPW600e.H.405

04.12

# SPW600e Door

## Kingspan Adaptor - 100mm Head/Cill Detail



# SPW600e Door

Kingspan Adaptor - 100mm  
Side Jamb Detail

SPW600e.H.406

04.12

SUITABLE FIXING TO STRUCTURE MUST BE PROVIDED.

