SPILKA OPUS ™
Profile design and Fitting instructions

Updated: 19.01.2017

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2	END KEEP HEAD	17	CENTRE SASH ASSEMBLY
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		23	HANDLES AND ACCESORIES
		24	ESPAGNOLETTE RODS
			CLIPS FOR BARS AND ACCESSORIES

COMPONENTS
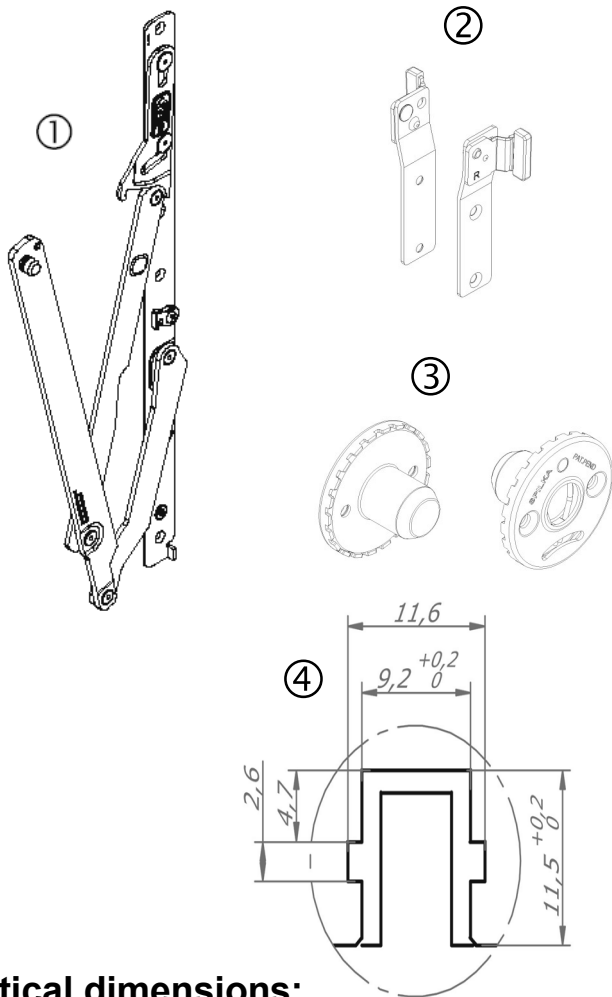
Hinges ①
There are 6 hinge sizes (A1-A6), depending on the window height. The hinges are fixed by screws into the frame jambs. All sizes have a safety catch and sizes A3-A6 also include a device to prevent the sash blowing closed.
Spilka has also developed to additional sizes in HD (heavy duty) that allows a higher weight, A5 and A6.

Head slides ②
These components couple the sash to the frame. It is important that the head slide's rotation point is as far out as possible so the sash does not foul the weather-strip when reversed.

Rondo Centre sash assemblies ③
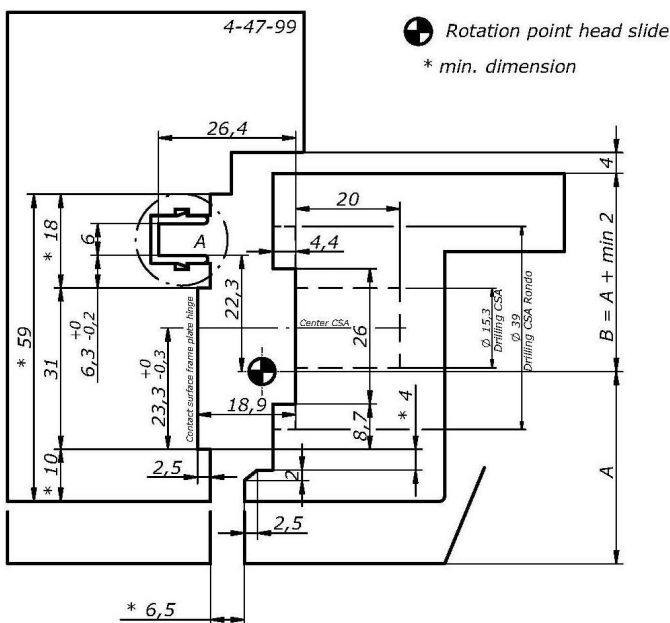These fittings attach the hinge to the sash.

U-profile ④
PP (polypropylene) deformable profile supplied on 500 m rolls.
Drawing 4 shows channel required and profile dimensions.

Profiles
Hinges are fixed in a groove in the inside of the frame jambs, to the outside of the u-profile channel. This `u-channel` is 11,5 mm deep and 9,2 mm wide.

To allow the sash to reverse a groove on the outside of the sash jambs is used to correctly position the head slides.

The inner top edge of the sash is rounded (with a radius or chamfer) to allow the sash to easily slide past the weather-strip.

NB! Top and bottom profiles can be different to the side profiles

The outer gap at the sides between sash and frame should be a min 6,5 mm. We recommend a gap of 1-4 mm at the top and between 4-6 mm at the bottom.

Critical dimensions:

Rotation point head slide
* min. dimension

DIMENSIONS AND WEIGHTS
Min window heights:ca 427 mm outward sash
Max window heights:1588 mm outward sash
Max frame weight: A1 and A2 - 40 kg
                               A3 and A4 - 50 kg
                               A5 and A6 - 55 kg
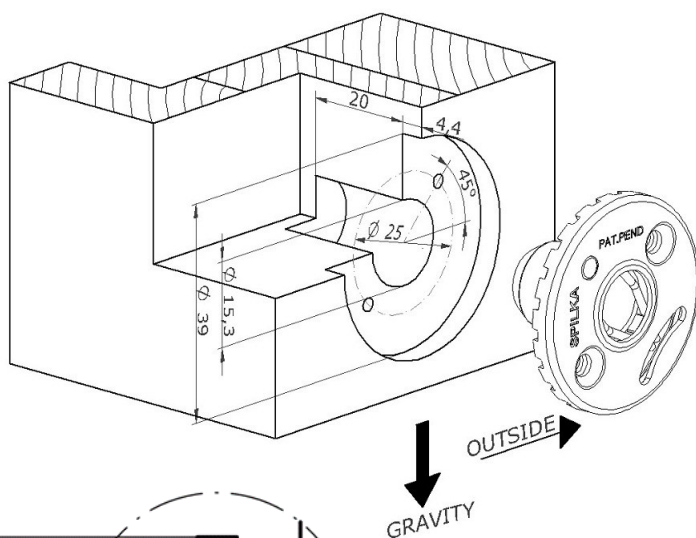HD (heavy duty)   A5 og A6 - 80 kg

DRILLING AND ROUTING
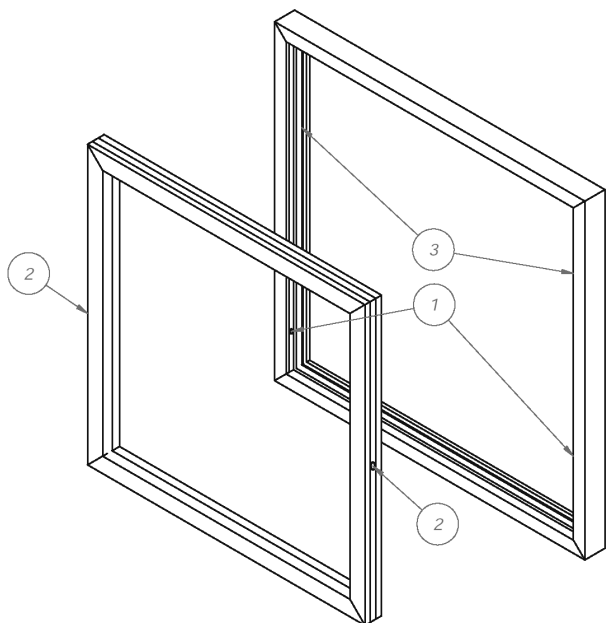
1. Hole Ø12,3 mm for frame plate adjustment point.
2. Hole Ø15,3 /Ø39 mm for Rondo centre sash assembly.
3. Grove for head slide.

Frame plate
Pre-drill a hole of Ø 12,3 mm for frame plate adjustment point. After positioning the hinge at the correct height it can be adjusted +/- 1,0 mm.

Centre sash assemblies
The starting point for positioning the hinge, is to centre the pivot point 10 mm over the centre of the sash. This will ensure any espagnolette end keeps will not be damaged by the head slide and the sash will remain within the overall window height when reversed.

Positioning may vary according to profile dimensions as will the top and bottom gaps between the sash and frame. Therefore specific calculation should be made for each profile.

Drill holes are shown on the drawing.

DETAIL A
2:1
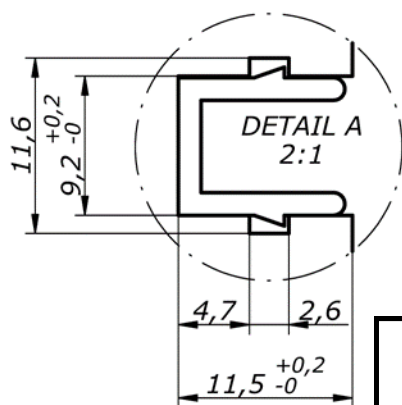
WINDOW SIZES AND RELEVANT HINGES							
		A1	A2	A3	A4	A5	A6
H min	[mm]	427	531	681	861	1091	1331
H max	[mm]	530	680	860	1090	1330	1588

H = overall frame height.
Measurements can vary according to profile dimensions

ASSEMBLY

1.   U-channel and hinges are fitted to frame jambs.
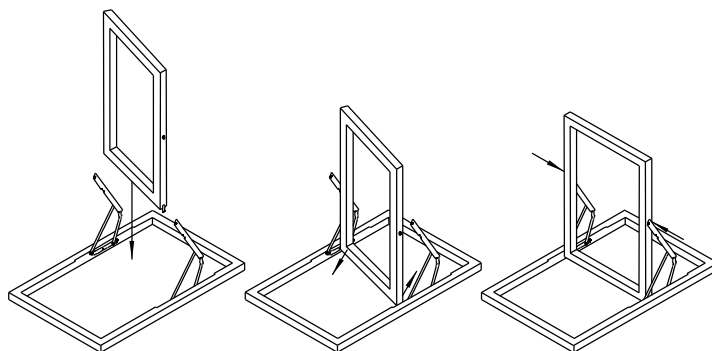2.   The head slides and centre sash assemblies are fitted to sash.

Fitting sash to frame:
1.   Frame is laid flat with inside down.
2.   Hinges are opened out.
3.   The sash is held vertically over frame with head slides down. Tilt the sash diagonally to allow the head slides to be fitted into the u-channel and fit the hinge pivot points into the centre sash assemblies.
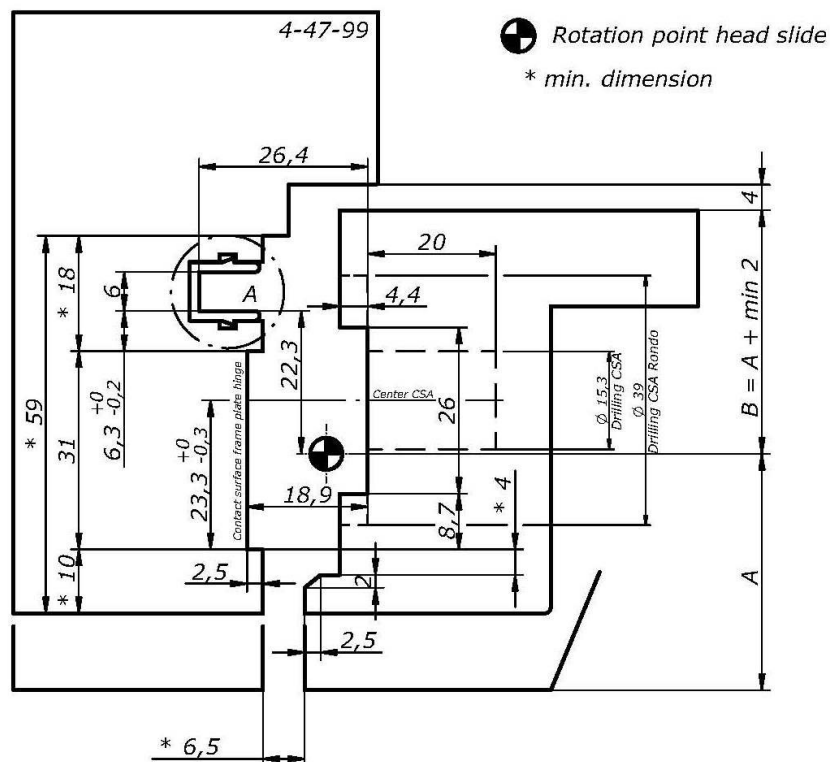
(Head slides are treated with a dab of glue to prevent them turning whilst the sash is being fitted into the frame, the bond is broken the first time the sash is reversed.)

Relevant screws

Hinges	Ø4,5 x 25 mm
Head slides	Ø4,5 x 25 mm
Centre sash assy.	Ø3,5 x 25 mm

Critical dimensions

4-47-99

⊕ Rotation point head slide

* min. dimension