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RECORD OF CHANGES

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1. SUBJECT

The standard serves as a guide in defining the order and assessing product quality.

It consists of four parts:

1. Standard of product elements
2. Product quality standard
3. Product mounting standard
4. Standard of use and maintenance

The standard of product elements defines the product range (series, colors and profile elements, profile dimensions, locks, glass, etc).

The product quality standard is a separate document, and it is an integral part of the Herceg product standard.

The mounting standard prescribes the manner in which the product is packaged, transported and installed in the facility.

The standard of use and maintenance prescribes rules for treatment by end customers / users of products, in order to maintain product quality and long-term use.

2. SCOPE

This standard is applied in all organizational parts of Herceg d.o.o. and in relations with third parties.

3. RESPONSIBILITIES

The Head of the Development, technology and informatics Department is responsible for the establishment, implementation and maintenance of these procedures.

4 Standard of product elements

4.1 Assortment of products

The product assortment of Herceg d.o.o. is divided into the following categories:

1. PVC program
2. AL program
3. Roller shutters
4. Mosquito nets
5. Window sills

PVC assortment of products is divided into:

- windows
 - Profine 76 AD system
 - Profine 76 MD system
 - Profine 88 MD system
 - Profine K Vision 76 system
- doors
 - Profine 76 AD system
 - Profine 88 MD system
 - Profine K Vision 76 system
- Sliding systems
 - Profine PSK 76 AD system
 - Profine PSK 76 MD system
 - Profine PSK 88 MD system
 - Profine PremiDooor 76 system
 - Profine PremiSlide 76 system
 - Profine PremiLine system

AL assortment of products is divided into:

- windows
 - Aliplast Futural system
 - Aliplast ST1000 system
 - Aliplast Star75 system
 - Aliplast MaxLight system

- Feal Termo 85 system
- Feal Termo 85 S+ system
- Feal Termo 85 SK system
- Feal Mill 45 system (cold profile)
- SCHÜCO AWS75

- Door
 - Aliplast Futural system
 - Aliplast ST1000 system
 - Aliplast Star75 system
 - Aliplast MaxLight
 - Feal Termo 85 system
 - Feal Termo 85 VS system
 - Feal Mill 45 system (cold profile)
 - Feal AD 60 system (cold profile)
 - SCHÜCO ADS75
 - SCHÜCO 76 AD UP

- Sliding systems
 - Aliplast VG500 system
 - Aliplast UltraGlide system
 - Feal Termo 120 system
 - Feal Termo 120D system
 - FealTermo 150 system
 - SCHÜCO ASS70

- Harmo doors, facade systems, winter gardens and shutters are offered on request.

Assortment of roller shutters is divided into:

1. PVC roller shutter with internal box KÖMMERLING RolaPLus system
 2. ALU roller shutter with external box
 3. ALU roller shutter with box under facade
- (* all systems of roller shutters has the following propulsions : belt, crank, motor – swich, motor – remote controler)

Assortment of mosquito nets is divided into:

1. Rollo mosquito nets
2. Plise mosquito nets
3. Fixed mosquito nets

Assortment of windows sills is divided into:

1. PVC internal windows sills
2. ALU external windows sills

4.2 PVC SYSTEMS

4.2.1 Series of systems

In the PVC systems we have the following series:

- 76AD
- 76AD AluClip
- 76MD
- 76MD AluClip
- 88MD
- 88MD AluCLip
- K-vision 76
- PremiDoor 76
- PremiDoor76 AluClip
- PremiDoor 76 Lux
- PremiDoor76 AluClip Lux
- PremilidSe 76
- PremiSlide 76 AluClip
- PremiLine

4.2.2 Colors of profiles and product elements

Products colored in bulk are characterized by a material that is uniformly distributed over the cross-sectional areas of the profile. For environmental reasons, it is possible that recycled profiles are used in addition to clean materials. Recycled profiles are made up of two layers of base material. The visible part of the profile by structure is made of pure material, and the remaining part of the profile is made of recycled material.

Foiled profiles are characterized by a material that is lined with foil on the visible outer or inner surface of the profile. The body of the profile is a material colored in mass (white, cream, ocher, ...).

Profiles with ALU cover profile are characterized by a material that is basically PVC (colored in bulk or foiled only on the inside) with a built-in ALU cover profile on the

outside of the position. The ALU cover profile in this case was plasticized to the appropriate RAL.

HERCEG WINDOWS AND DOORS

PROGRAM OF PROFINE FOILS FOR 2020. - DELIVERIES IN LK1-LK3 BLACK GASKETS									
Wood imitation and Uni colors	IR Reflex	Profile Color Pn.	Color name MAT	Semi- Y or BAL	Basic profile body - both side foiled	K-VISION **		K-VISION **	K-VISION **
						●	■		
Golden Oak	da	32	167	-	Oliv braun	LK1	LK3	LK3	
Hussbaum		52	167	-	Schwarzbraun	LK1	LK3	LK3	
Sappell		24	167	-	Schwarzbraun	LK1	LK3	LK3	
Anthrazitgrau		16	167	7016	Anthrazitgrau	LK1	LK3	LK3	
Anthrazit UHI Matt *		UD	047	7016	Anthrazitgrau	LK1	LK3	LK3	
Schiefergrau glatt		SG	083	7015	Anthrazitgrau	LK1	LK3	LK3	
Quarzgrau		GD	167	7039	Anthrazitgrau	LK1	LK3	LK3	
Basaltgrau		92	167	7012	Anthrazitgrau	LK1	LK3	LK3	
Cremeweiss		CQ	167	9001	Weiss	LK1**	LK3	LK3	
Eiche (dunkel) grau		15	167	-	Schwarzbraun	LK3	LK3	LK3	
Grau		21	167	7001	Weiss	LK3	LK3	LK3	
Schokbraun	da	27	167	8022	Schwarzbraun	LK3	LK3	LK3	
Braun Maron B093		31	167	-	Schwarzbraun	LK3	LK3	LK3	
Eiche dunkel FL-F1		34	167	-	Schwarzbraun	LK3	LK3	LK3	
Eiche rustikal		37	167	-	Schwarzbraun	LK3	LK3	LK3	
Bergkeller	da	38	167	-	Oliv braun	LK3	LK3	LK3	
Oregon 4	da	39	167	-	Oliv braun	LK3	LK3	LK3	
Milcore		42	167	-	Schwarzbraun	LK3	LK3	LK3	
Weinrot		44	167	3005	Schwarzbraun	LK3	LK3	LK3	
Dunkelrot 208 1		46	167	3011	Schwarzbraun	LK3	LK3	LK3	
Signalgrau glatt	da	50	083	7004	Weiss	LK3	LK3	LK3	
Mosogrün		53	167	6005	Schwarzbraun	LK3	LK3	LK3	
Dunkelgrün		58	167	6009	Schwarzbraun	LK3	LK3	LK3	
Moerliche	da	76	167	-	Oliv braun	LK3	LK3	LK3	
Moerliche		78	167	-	Schwarzbraun	LK3	LK3	LK3	
Schwarzbraun		80	167	8022	Schwarzbraun	LK3	LK3	LK3	
Emilblau		85	167	5007	Weiss	LK3	LK3	LK3	
Stahlblau		88	167	5011	Schwarzbraun	LK3	LK3	LK3	
Black Cherry		90	167	-	Schwarzbraun	LK3	LK3	LK3	
Acanthgrau	da	93	167	7038	Weiss	LK3	LK3	LK3	
Lichtgrau	da	94	167	7035	Weiss	LK3	LK3	LK3	
Alux D16 703 *		AL	-	-	Anthrazitgrau	LK3	LK3	LK3	
Metbruh Silver	da	AR	-	-	Weiss	LK3	LK3	LK3	
Acanthgrau glatt	da	GA	083	7038	Weiss	LK3	LK3	LK3	
Betongrau 7023	da	GE	167	7023	Anthrazitgrau	LK3	LK3	LK3	
Irish Oak	da	IO	148	-	Oliv braun	LK3	LK3	LK3	
Metbruh Platin	da	MP	-	-	Weiss	LK3	LK3	LK3	
Metbruh Quarzgrau		MQ	-	-	Anthrazitgrau	LK3	LK3	LK3	
Metbruh Anthrazitgrau		MT	-	-	Anthrazitgrau	LK3	LK3	LK3	
Quarzgrau SFTN matt *		CB	-	7039	Anthrazitgrau	LK3	LK3	LK3	
Basic Cherry		RC	166	-	Oliv braun	LK3	LK3	LK3	
Siena PR 40827		SC	148	-	Schwarzbraun	LK3	LK3	LK3	
Schwarzgrau SFTN matt *		SM	-	7021	Anthrazitgrau	LK3	LK3	LK3	
Black UHI Matt *		US	047	9011	Schwarzbraun	LK3	LK3	LK3	
Winchester XA 46630		WI	148	-	Oliv braun	LK3	LK3	LK3	
Weiss 9152		WX	168	9010	Weiss	LK3	LK3	LK3	

BLColor = LK4 - Geometry and colors are from standard program
 Basic profile body color is defined by inside color of both side foiled profile.
 Color of profile body for one side foiled inside: White and cream (depending on the system).
 Anthrazitgrau, Dark brown Ocher with AL cover profile from the outside.
 Inside foiled profile with dark profile body can be used only in case of combination with AL cover profile from the outside.

LK1 Wood imitation = One side or both sides foiled
 LK1 U = colors = One side foiled, or LK3 = both sides colored
 LK3 - LK4 wood imitation and uni colors = one side and both side foiled
 Basic profile body both sides - white, K-Vision basic profile body white or cream
 Basic profile body one side foiled outside - white, K-Vision basic profile body white or cream
 Foiling on other profile body colors will be delivered in LK4
 ■ □ = one side foiled outside
 ■ □ = one side foiled inside
 ■ ■ = both side foiled

LK1 = delivery in 7 working day from the warehouse
 LK3 = delivery in 14 working day from the warehouse
 LK4 = information about delivery period and price on request
 * Profiles will be delivered with white protection foil without brandname
 ** K-VISION - One side or both side foiled only on the white or cream profile body and with black gaskets
 *** Basic profile body "CC": Delivery period for LK3, Excluding: CDC and SEC in 7540, K-VISION AND PREMIDDOOR 76

Program folija PROFINE za 2020. _ isporuke LK1-LK3_ dihtung crni									
Imitacije drveta i uni boje	IR Reflex	profine Broj boje	Izvedba- struktura ili glat	Slično RAL-u	Osnovno tijelo obostrano folirano	K-VISION **		System 76 AD/MD System 88 MD PremiDoor 76/88 PremiSlide 76	K-VISION **
						■ □	■ ■		
Eiche dunkel ST		71	167	-	Schwarzbraun	LK4	LK4	LK4	LK4
Bergeiche	da	74	167	-	Olivbraun	LK4	LK4	LK4	LK4
Kobalblau 5013		87	167	5013	Weiß	LK4	LK4	LK4	LK4
Anthrazitgrau ST YLO		AA	-	7016	Anthrazitgrau	LK4	LK4	LK4	LK4
ANTEAK		AN	-	-	Weiß	LK4	LK4	LK4	LK4
Anthrazitgrau SFTN matt *		AU	-	7016	Anthrazitgrau	LK4	LK4	LK4	LK4
Basalgrau SFTN *		BD	-	7012	Anthrazitgrau	LK4	LK4	LK4	LK4
Basalgrau SFTN matt *		BQ	-	7012	Anthrazitgrau	LK4	LK4	LK4	LK4
Cherry amaretto		CA	-	-	Olivbraun	LK4	LK4	LK4	LK4
Cherry Blossom		CB	195	-	Olivbraun	LK4	LK4	LK4	LK4
Gale Grey Finesse 49122 *		GY	013	7016	Anthrazitgrau	LK4	LK4	LK4	LK4
Hazy Grey Finesse 49124 *	da	HZ	013	7001	Weiß	LK4	LK4	LK4	LK4
Quarzgrau SFTN *		QA	-	7039	Anthrazitgrau	LK4	LK4	LK4	LK4
Quarz Platin		QP	-	-	Schwarzbraun	LK4	LK4	LK4	LK4
Schwarzgrau SFTN *		SF	-	7021	Anthrazitgrau	LK4	LK4	LK4	LK4
Schwarzbraun SFTN matt *		SF	-	8022	Schwarzbraun	LK4	LK4	LK4	LK4
Slate Grey Finesse 49229 *		SL	013	7015	Anthrazitgrau	LK4	LK4	LK4	LK4
Siena PN 46828		SN	148	-	Schwarzbraun	LK4	LK4	LK4	LK4
Umbra-grau glatt		UG	083	7022	Anthrazitgrau	LK4	LK4	LK4	LK4
Winchester XC 46843		WC	148	-	Schwarzbraun	LK4	LK4	LK4	LK4

LK1 = Isporuke u roku 7 radnih dana sa lagera
 LK3 = Isporuke u roku 14 radnih dana sa lagera
 LK4 = Isporuke po uptu za rok i cijenu
 * Profili će biti isporučeni sa bijelom zaštitnom folijom bez natpisa.
 ** K-VISION - Jednostrano ili obostrano folirano (isključivo na bijele) ili kren podizni sa crnim dihtunzima.
 *** Osnovno tijelo "CC": Rok isporuke od LK3; Izlazna se: CCCC i FCCC u 76AD, K-VISION i PremiDoor76

LK1 Imitacije drveta = Jednostrano ili obostrano folirano
 LK1 Uni boje = Jednostrano folirano a obostrano folirano = LK3
 LK3 - LK4 Imitacije drveta i uni boje = Jednostrano i obostrano folirano.
 Osnovno tijelo jednostrano folirano v ani - bijelo ; K-Vision osnovno tijelo bijelo ili kren.
 Osnovno tijelo obostrano folirano - v dti tabelu ; K-Vision osnovno tijelo bijelo ili kren.
 Opcija foliranja na drugim osnovnim tijelima isporučivo u LK4
 ■ □ = Jednostrano folirano v ani
 □ □ = Jednostrano folirano v ani
 ■ ■ = Obostrano folirano

Bicolor = LK4 - Geometrije i boje su iz standardnog programa.
 Osnovno tijelo određuje se po unutrašnjim boj folije kod obostranog foliranja.
 Boga osnovnog tijela za jednostrano foliranje umura.Bijelo ili kren (zavisno od sistema) Anthrazitgrau,
 Tamnobraun ili Oker kod upotrebe alu-obloga sa vanjske strane.
 Unutrašnje folirani profili na laminiranim tijelima smiju se koristiti samo u slučaju u kombinaciji sa
 Alu-oblogama sa vanjske strane.

PROGRAM OF PROFINE FOILS FOR 2020. - DELIVERIES IN LK1-LK3 BLACK GASKETS										
Wood imitation and Uni colors	IR Reflex	Profile Color no.	Color type anodize / MLT	Smalbit VAK BAL	Basic profile body - both side foiled	System 78 AD / MD		K-VISION **		BIColor = LK4 - Geometry and colors are from standard program
						System 88 MD PremiDoor 78 / 88	PremiSlide 78	■ ■ ■ ■	■ ■ ■ ■	
Eiche dunkel ST		71	167	-	Schwarzbraun	LK4	LK4	LK4	LK4	
Bergeiche	da	74	167	-	Olivbraun	LK4	LK4	LK4	LK4	
Kobaltblau 5013		87	167	5013	Weiß	LK4	LK4	LK4	LK4	
Anthrazitgrau STYLO		AA	-	7016	Anthrazitgrau	LK4	LK4	LK4	LK4	
AnTEAK		AN	-	-	Weiß	LK4	LK4	LK4	LK4	
Anthrazitgrau SFTN matt *		AU	-	7016	Anthrazitgrau	LK4	LK4	LK4	LK4	
Basaltgrau SFTN *		BD	-	7012	Anthrazitgrau	LK4	LK4	LK4	LK4	
Basaltgrau SFTN matt *		BQ	-	7012	Anthrazitgrau	LK4	LK4	LK4	LK4	
Cherry amareto		CA	-	-	Olivbraun	LK4	LK4	LK4	LK4	
Cherry Blossom		CB	195	-	Olivbraun	LK4	LK4	LK4	LK4	
Gale Grey Finesse 49122 *		GY	013	7016	Anthrazitgrau	LK4	LK4	LK4	LK4	
Hazy Grey Finesse 49124 *		HZ	013	7001	Weiß	LK4	LK4	LK4	LK4	
Quarzgrau SFTN *	da	QA	-	7039	Anthrazitgrau	LK4	LK4	LK4	LK4	
Quarz Platin		QP	-	-	Schwarzbraun	LK4	LK4	LK4	LK4	
Schwarzgrau SFTN *		SE	-	7021	Anthrazitgrau	LK4	LK4	LK4	LK4	
Schwarzbraun SFTN matt *		SF	-	8022	Schwarzbraun	LK4	LK4	LK4	LK4	
Slate Grey Finesse 49229 *		SL	013	7015	Anthrazitgrau	LK4	LK4	LK4	LK4	
Siena PN 46828		SN	148	-	Schwarzbraun	LK4	LK4	LK4	LK4	
Umbregrau glatt		UG	083	7022	Anthrazitgrau	LK4	LK4	LK4	LK4	
Minchester XC 46843		WC	148	-	Schwarzbraun	LK4	LK4	LK4	LK4	

LK1 = delivery is 7 working days from the warehouse
 LK3 = delivery is 14 working days from the warehouse
 LK4 = information about delivery period and price on request

* Profiles will be delivered with white protection foil without brandname
 ** K-VISION - One side or both sides foiled only on the white or cream profile body and with black gaskets
 *** Basic profile body "CC" - Delivery period for LK3. Excluding: COCC and BECC in 764D, K-VISION AND PREMIDOOR 76

LK1 Wood imitation = One side or both sides foiled
 LK1 Uni colors = One side foiled or LK3 = both sides covered
 LK3 - LK4 wood imitation and uni colors = one side and both side foiled
 Basic profile body one side foiled outside - white, K-Vision basic profile body white or cream
 Basic profile body both sides - see the table, K-Vision basic profile body white or cream
 Foiling on other profile body colors will be delivered in LK4
 Foiling on other profile body colors will be delivered in LK4
 ■ ■ = one side foiled outside
 ■ ■ ■ = both side foiled

BIColor = LK4 - Geometry and colors are from standard program
 Basic profile body color is defined by inside color of both side foiled profile.
 Color of profile body for one side foiled inside: White and cream (depending on the system).
 Anthrazitgrau, Dark brown Other with AL cover profile from the outside.
 Inside foiled profile with dark profile body can be used only in case of combination with AL cover profile from the outside.

The color of the elements visible from the outside or inside of the product is defined on the basis of the color of the profile or the design of the foil from the outside, ie. inside. The product may contain visible elements such as wasser caps, snap handle, gasket, semi-oil, window fittings on the inside, etc.

* Standard colors of window parts are in one of the system versions as follows in the following table

PROFILE	Outside color of the parts (water caps ,stulp caps,...)	Inside color of the parts (caps of hignes, fittings, handles,...)
White glat	white	white
cream glat	cream	cream
Foil wood imitation	brown	brown
UNI colors (according to RAL)	grey (elox F1)	grey (elox F1)

- For Belgium and the Netherlands, the parts of the windows that come from outside are painted according to the customer's request in a certain RAL or are in one of the standard colors depending on the color, ie. profile foils as follows in the following table.

STANDARD COLORS OF WINDOW PARTS DEPENDING ON THE FOIL VERSION FOR BELGIUM AND THE NETHERLANDS				
No.	Color of foil Outside	C of foil Inside	Outside color of the parts (water caps ,stulp caps,...)	Inside color of the parts (water caps ,stulp caps,...)
301	Golden Oak	Golden Oak	brown	brown
302	Nussbaum	Nussbaum	brown	brown
303	Sapeli	Sapeli	brown	brown
304	Anthrazitgrau	Anthrazitgrau	7016	grey
305	Grau	Grau	7001	grey
307	Schiefergrau glatt	Schiefergrau glatt	7015	grey

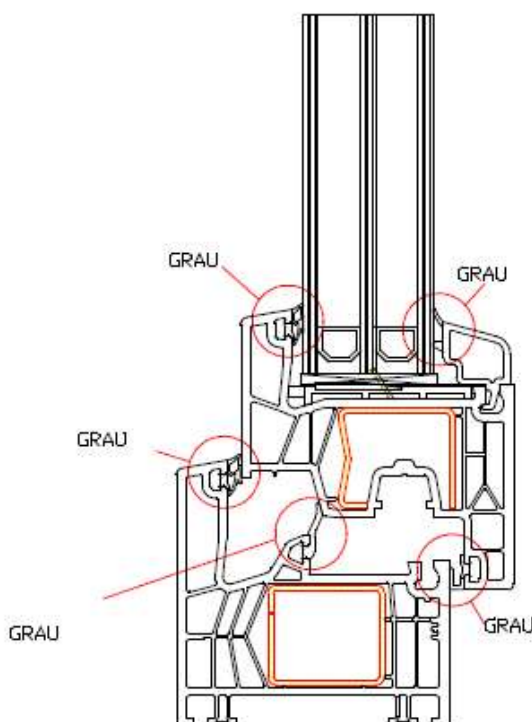
No.	Color of foil Outside	C of foil Inside	Outside color of the parts (water caps ,stulp caps,...)	Inside color of the parts (water caps ,stulp caps,...)
308	Quarzgrau	Quarzgrau	7039	grey
309	Dunkelgrün	Dunkelgrün	6009	grey
310	Cremeweiß DECOR	Cremeweiß DECOR	cream	cream
311	Eiche dunkel_15	Eiche dunkel_15	brown	brown
312	Schwarzbraun	Schwarzbraun	brown	brown
313	Eiche rustikal	Eiche rustikal	brown	brown
314	Bergkiefer	Bergkiefer	1011	brown
315	Mooreiche	Mooreiche	brown	brown
316	Eiche dunkel FT-F1	Eiche dunkel FT-F1	brown	brown
317	Oregon 4	Oregon 4	TB1	brown
318	Schokobraun	Schokobraun	brown	brown
319	Braunmaron	Braunmaron	brown	brown
320	Signalgrau glatt	Signalgrau glatt	7004	grey
321	Macore	Macore	brown	brown
322	Stahlblau	Stahlblau	5011	grey
323	Eiche dunkel ST	Eiche dunkel ST	brown	brown
324	Streifen-Douglasie	Streifen-Douglasie	brown	brown
325	Moosgrün	Moosgrün	6005	grey
326	Weinrot	Weinrot	3005	grey
327	Achatgrau glatt	Achatgrau glatt	7038	grey
328	Basaltgrau	Basaltgrau	7012	grey
329	Betongrau	Betongrau	7023	grey
330	Brillantblau	Brillantblau	5007	grey
331	Kobaltblau	Kobaltblau	5013	grey
332	Irish Oak	Irish Oak	1011	brown
333	Dunkelrot	Dunkelrot	3011	grey
334	Metbrush Silver	Metbrush Silver	TB3	grey
335	Metbrush Platin	Metbrush Platin	TB4	grey

No.	Color of foil Outside	C of foil Inside	Outside color of the parts (water caps ,stulp caps,...)	Inside color of the parts (water caps ,stulp caps,...)
337	Metbrush Quarzgrau	Metbrush Quarzgrau	TB5	grey
338	Metbrush Anthrazitgrau	Metbrush Anthrazitgrau	TB6	grey
339	Bergeiche	Bergeiche	TB7	brown
340	Black Cherry	Black Cherry	TB8	brown
341	Achatgrau	Achatgrau	7038	grey
342	Rustic Cherry	Rustic Cherry	brown	brown
343	Cherry Blossom	Cherry Blossom	TB10	brown
344	Siena PR	Siena PR	brown	brown
345	Weiss foliert	Weiss foliert	white	white
346	Alux DB 703	Alux DB 703	TB9	grey
347	Anthrazit ULTI MATT	Anthrazit ULTI MATT	7016 LC	grey
348	Schwarzgrau SFTN mat	Schwarzgrau SFTN mat	7021 LC	grey
349	Black ULTI MAT	Black ULTI MAT	9011 LC	grey
350	Quarzgrau SFTN matt	Quarzgrau SFTN matt	7039 LC	grey
351	SchwartzBlack-Deckor	SchwartzBlack-Deckor	brown	grey
901	Sikkens decor	weiss	6009	white
905	Tannengrun	weiss	6009	white
909	Zwartblau	weiss	5004	white
913	Lichtivor	weiss	1015	white
1000	Weiss foliert	Cream	white	cream

In PVC production, PVC profiles are used as standard with the following color of the seal in series:

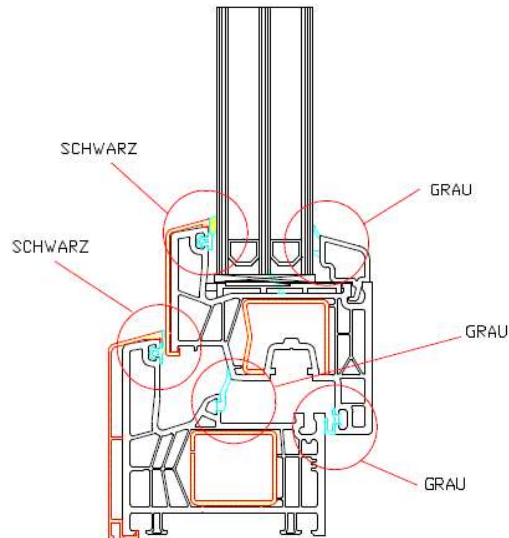
PVC profile series **76AD, 76MD, 88MD,**

- If the profile is in its basic version - white, all seals on the profile would be gray (GRAU) (Picture 1.)

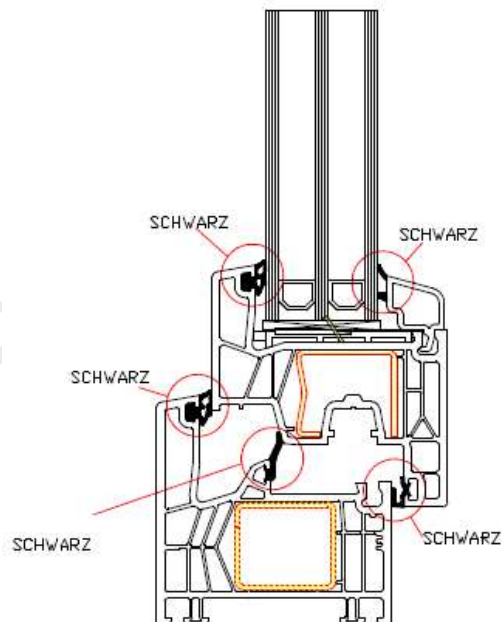


Picture 1.

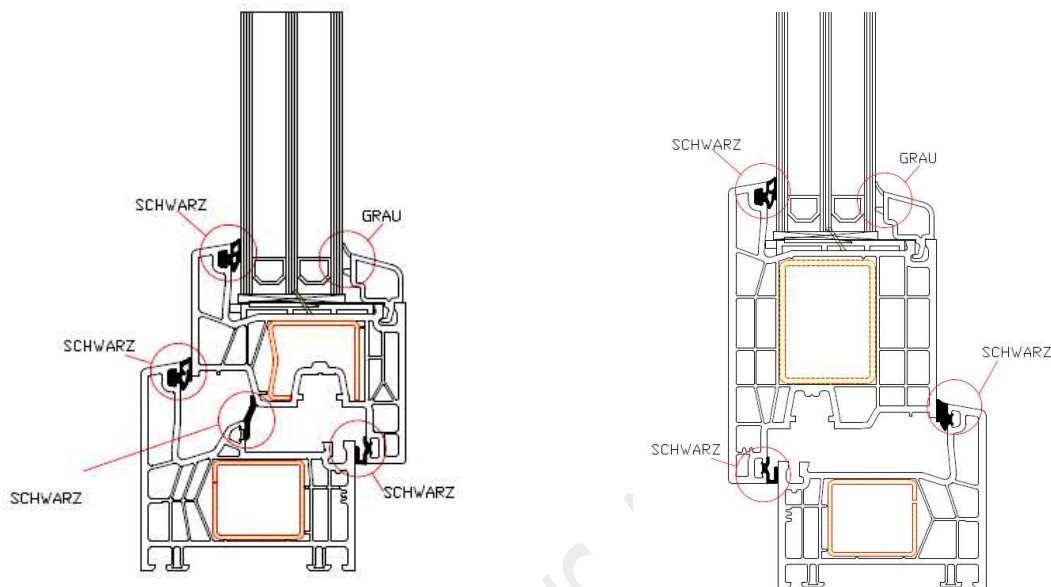
- If the PVC profile is white with ALU cover profile, regardless of the color of the ALU cover profile, all gaskets are gray (GRAU) except for the gasket in the part of the ALU cover profile which is black (SCHWARZ) (Picture. 2)



- If the PVC profile is white with ALU cover profile, regardless of the color of the ALU cover profile, all gaskets are gray (GRAU) except for the gasket in the part of the ALU cover profile that is black (SCHWARZ) (Picture 3.)



- If the customer wants a gray seal on the inside on the foiled profiles and foiled profiles with ALU cover profile, then all position profiles would be supplied with a black seal (SCHWARZ) except the seal on the glazing strip inside which would be in gray (GRAU), (Picture 4.)



Picture 4.

PVC profile series **PremiDoor 76**

For PremiDoor 76 positions, the color of the gasket that comes in the PremiDoor 76 set is the color in which the color of the gasket on the glazing strip is on the inside of the position.

PVC profile series **Premi Slide 76**

The PremiSlide 76 positions use an additional frame gasket and comes in the Z141 set. The color of the gasket in set Z141 is the same as the color of the glazing gasket on the outside of the position.

The PremiSlide 76 positions use an additional wing seal and comes in the Z142 set. The color of the gasket in set Z142 is the same as the color of the gasket on the glazing strip on the inside of the position.

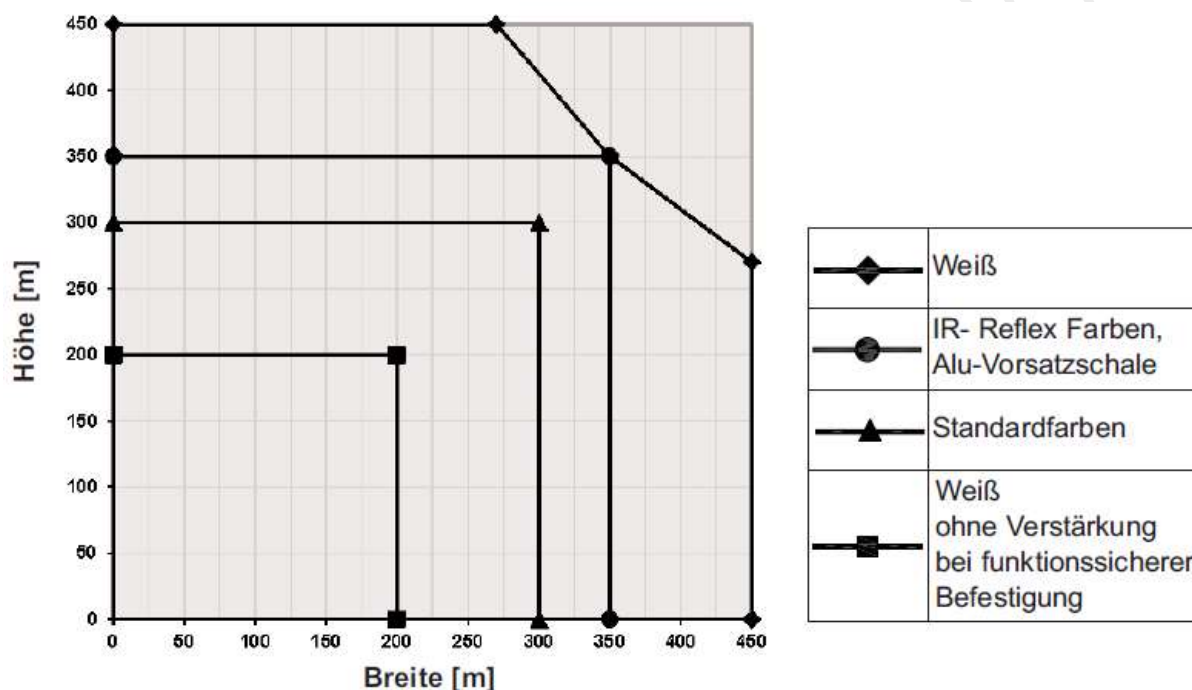
PVC profile series **K-vision 76**

- Svi profili K-vision 76 rade se standardno sa crnim dihtungom bez obzira na boju profila ili boju Al obloge -All K-vision 76 profiles are made as standard with black gasket regardless of the profile color or the color of the ALU cover profile

4.2.3 Dimensions of outerframe and wings

Minimal dimension	Wing	Outerframe
Height	450mm	250mm
Widht	450mm	250mm

The maximum dimensions of the outerframe depending on the color of the profile can be seen from the following diagram.



IR-Reflex paints are foils with a special thermo-reflective pigment that allows less heating of the profile. With standard foils and with IR-Reflex paints with a combination of different reinforcements it is possible to produce positions of larger dimensions. The following table and diagram presents the PROFINE foil program and the possible dimensions of the wing positions.

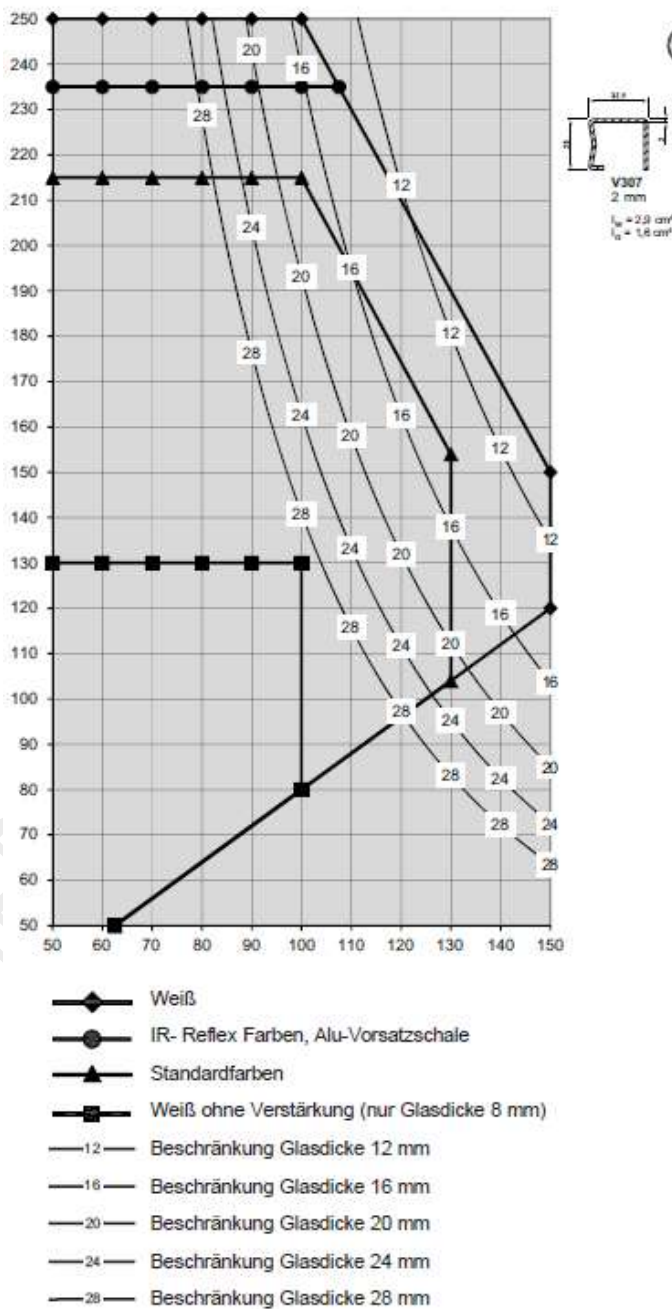
Aluminum cover profile can be made as large as “IR-Reflex paints”.

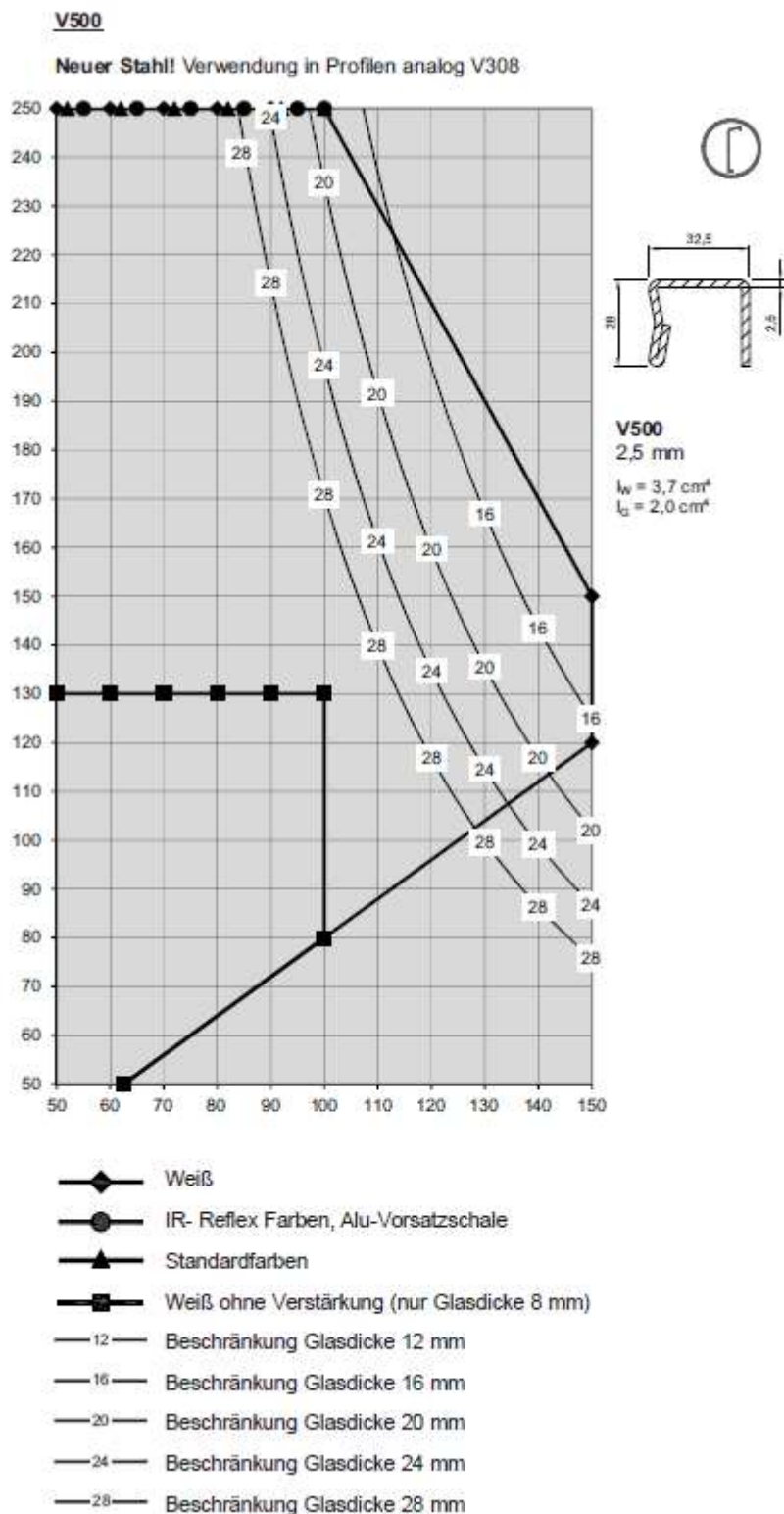
The maximum dimensions of the wings are determined depending on the reinforcement. The reinforcements in the 76AD, 76MD and 88MD series are largely compatible. In the following diagrams, it is possible to check the permitted window sash dimensions depending on the selected reinforcement.

(For the final product, it is necessary to look at the allowed dimensions of the hardware, depending on the dimensions of the wings).

V307

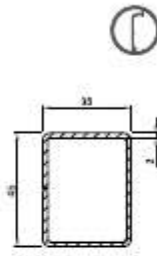
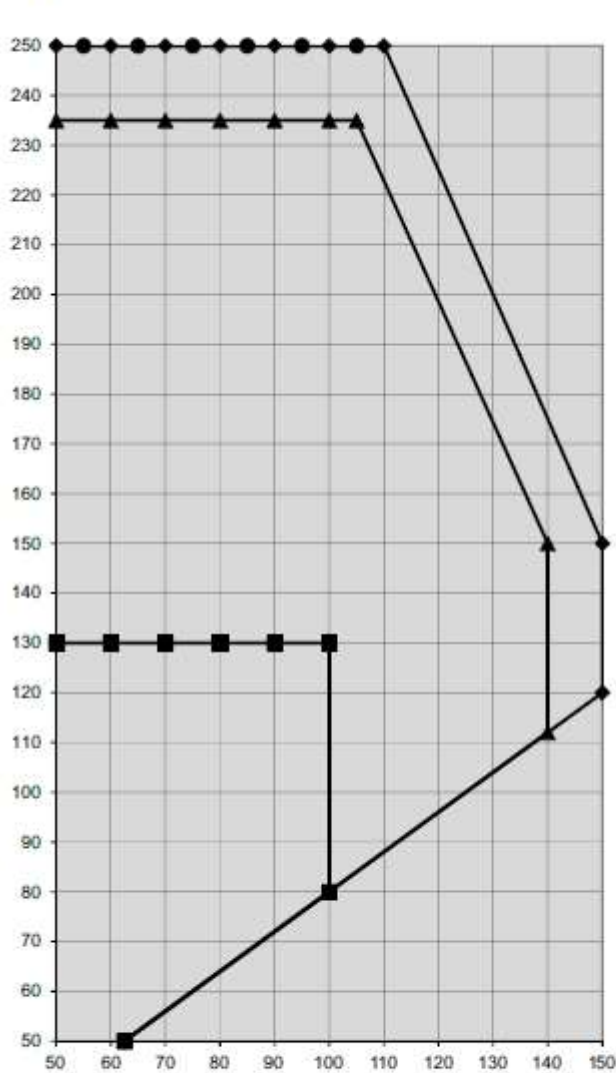
Neu





V314

Neu

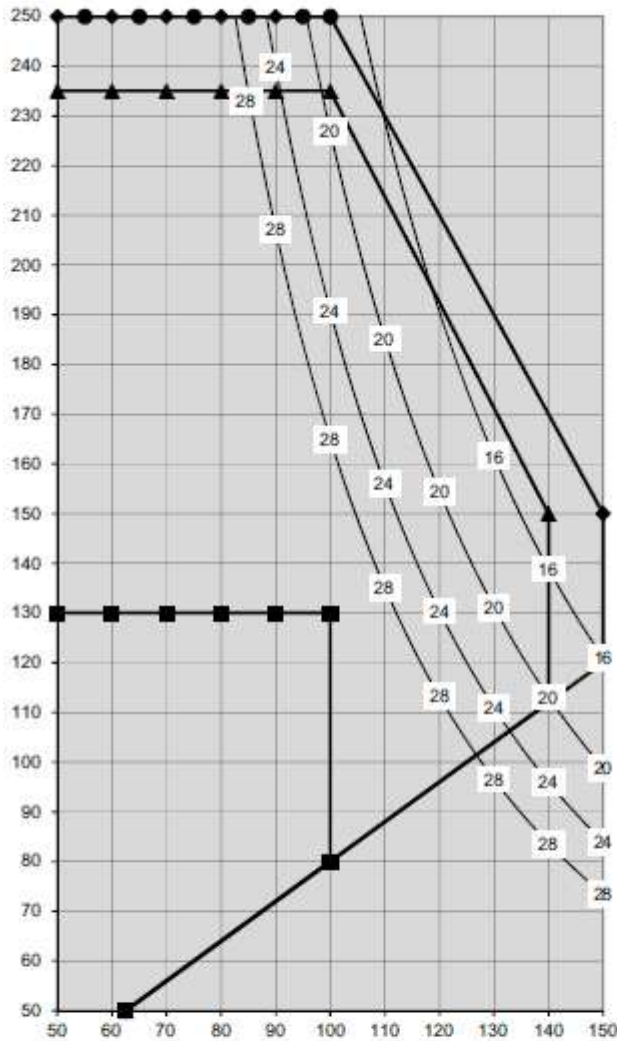


V314
2 mm
 $I_w = 5,7 \text{ cm}^4$
 $I_s = 8,4 \text{ cm}^4$

-  Weiß
-  IR- Reflex Farben, Alu-Vorsatzschale
-  Standardfarben
-  Weiß ohne Verstärkung

V308


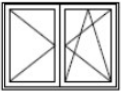
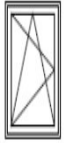
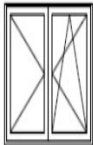

Neu



- ◆ Weiß
- IR- Reflex Farben, Alu-Vorsatzschale
- ▲ Standardfarben
- Weiß ohne Verstärkung (nur Glasdicke 8 mm)
- 12— Beschränkung Glasdicke 12 mm
- 16— Beschränkung Glasdicke 16 mm
- 20— Beschränkung Glasdicke 20 mm
- 24— Beschränkung Glasdicke 24 mm
- 28— Beschränkung Glasdicke 28 mm

4.2.4 Maximum dimensions of products by systems

System 76AD, 76MD, 88MD

Opening type	Description	Sash white	Sash colored (foiled)
	Turn tilt windows	1,50 x 1,50 m	1,50 x 1,50 m
	Window with stulpprofile	1,35 x 1,80 m	1,35 x 1,80 m
	Turn-Turn tilt balcony door	1,00 x 2,50 m	1,00 x 2,50 m
	Balcony door with stulpprofile	1,10 x 2,50 m	1,10 x 2,50 m
	Door	1,20 x 2,40 m	1,10 x 2,20 m (1,20 x 2,4 m) *

* - With IR-Reflex paint (foil)

** pay attention to the necessary reinforcement in the sash

** pay attention to the permitted dimensions of the sash depending on the type of opening that the hardware allows.

4.2.5 Fittings for windows

We use fittings according to the Winkhaus system of the AktivPilot series to create window positions.

According to the design, the hardware is divided into:

1. AktivPilot Concept (visible fitting)
2. AktivPilot Select (hidden fitting)

According to the security (anti-burglary) classes, the hardware is divided into:

1. BASIC (basic security)
2. RC
3. SKG

Visible fitting (ActivPilot Concept)

- 100 ili 130 kg load capacity
- minimum number of additional items for RC and SKG safety
- possibility of irregular shapes (oblique and arched positions)
- possible dimensions: width from 270 to 1725 FFB, height from 230 to 2800 FFH (according to the diagram)

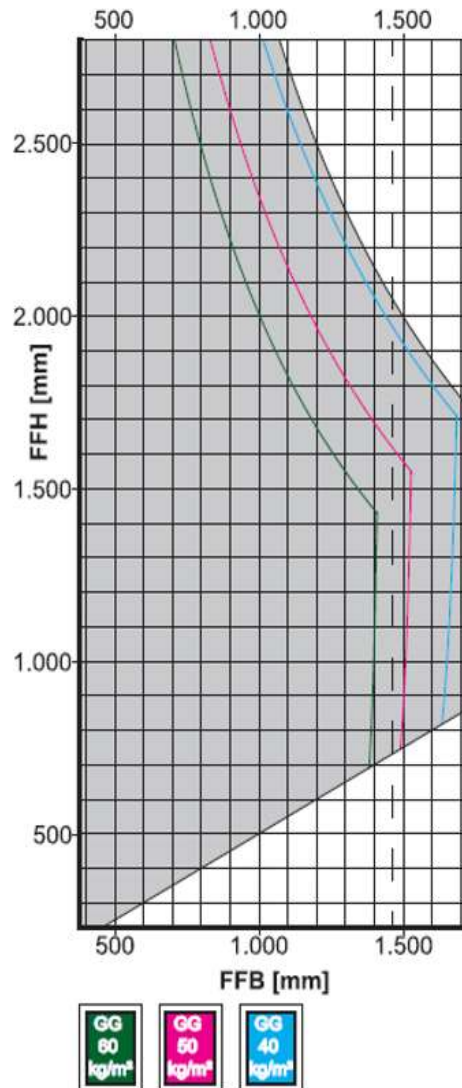
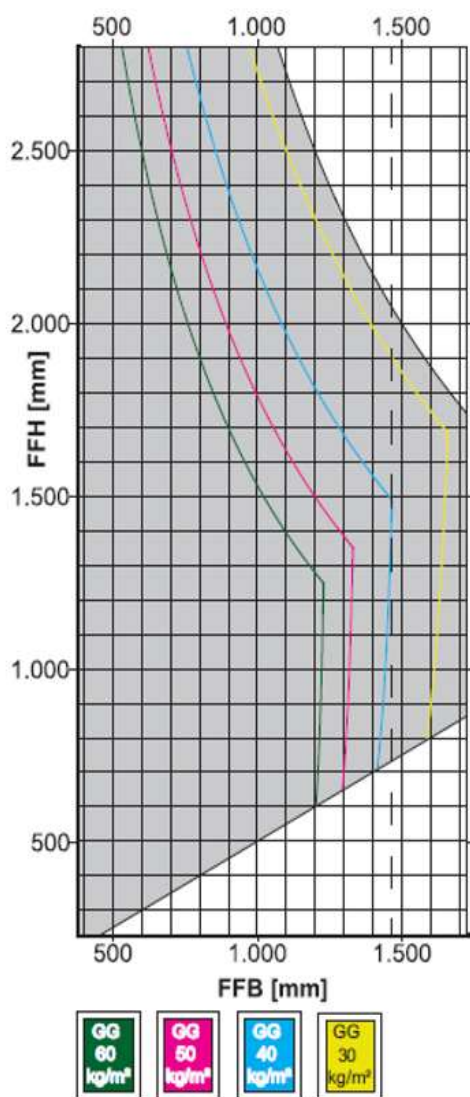


Diagram of load capacity up to 100kg

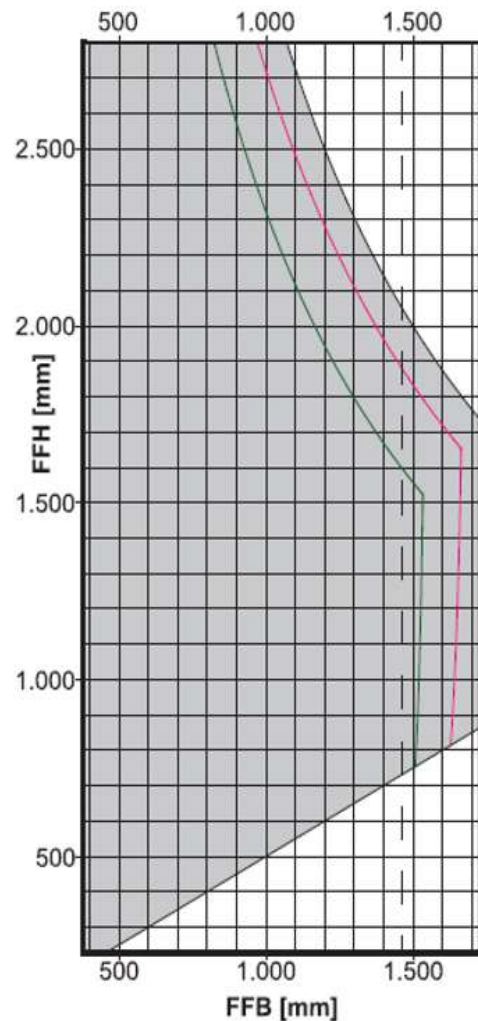
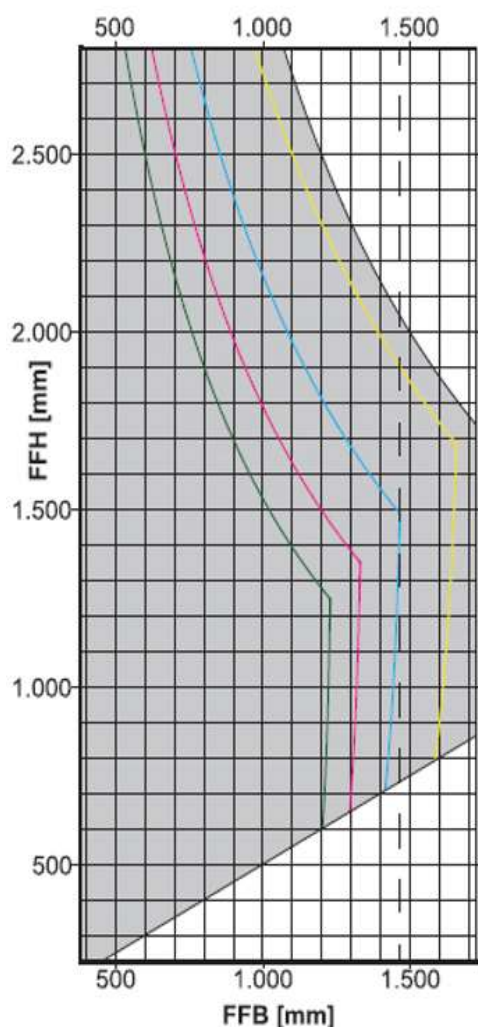
Diagram of load capacity up to 130kg

Hidden fitting - hidden bearing side (ActivPilot Select)

- 100 ili 150 kg load capacity
- minimum number of additional items for RC and SKG safety
- except for bearings, identical to the activPilot concept
- possible dimensions: width from 370 to 1725 FFB, height from 230 to 2800 FFH (according to the diagram)

Diagram of load capacity up to 100kg


Diagram of load capacity up to 150kg



The position of the handle on the window sash (GK) depends on the height of the sash.

All measurements refer to the wing fold.

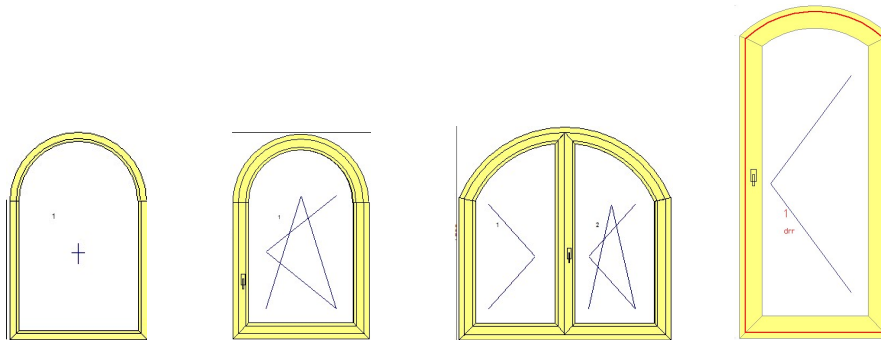
Example: For a window whose height per fold is $FFH = 950\text{mm}$, a handle of the window would be installed as standard at 375mm from the lower edge of the sash per fold.



230 - 420	GAK.465 +E3	GK = 114
421 - 460	GAK.465	GK = 210
461 - 695	GAK.710	GK = 210
696 - 850	GAK.945-1	GK = 260
851 - 860	GAK.1100-1	GK = 375
861 - 1100	GAK.1100-1	GK = 375
1101 - 1285	GAK.1325-1	GK = 550
1286 - 1325	GAK.1325-1	GK = 550
1326 - 1525	GAK.1550-1	GK = 550
1526 - 1775	GAK.1775-2	GK = 550
1776 - 1785	GAK.2000-2	GK = 1050
1786 - 2000	GAK.2000-2	GK = 1050
2001 - 2035	GAK.2225-2	GK = 1050
2036 - 2225	GAK.2225-2	GK = 1050

4.2.6 Arc positions

Only certain profiles and individual PVC series of profiles can be bent for arched positions.



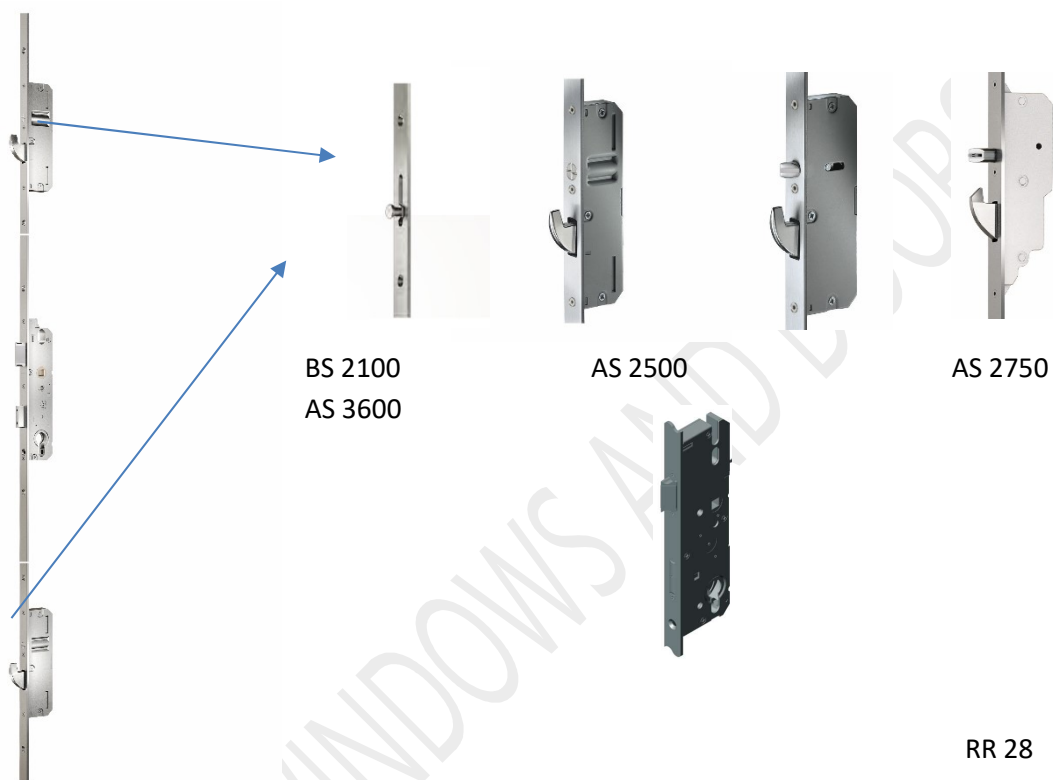
The minimum width of the position arc is calculated as: **profile face width (mm) x 10**

The profiles for which there are bending templates are as follows:

Profile	Description	The profile face width (mm)	SERIES
76101	Outerframe	67	76AD
76201	Window sash	78	
76204	Balcony sash	110	
76301	Transom	84	
76171	Outerframe	74	76MD
76271	Window sash	78	
76371	Transom	98	
88171	Outerframe	78	88MD
88270	Window sash	74	
88271	Window sash	78	
76106	Outerframe	81	K-vision 76

4.2.7 Locks

With PVC doors, it is possible to use locks equipped with a central or combined with security closing elements.

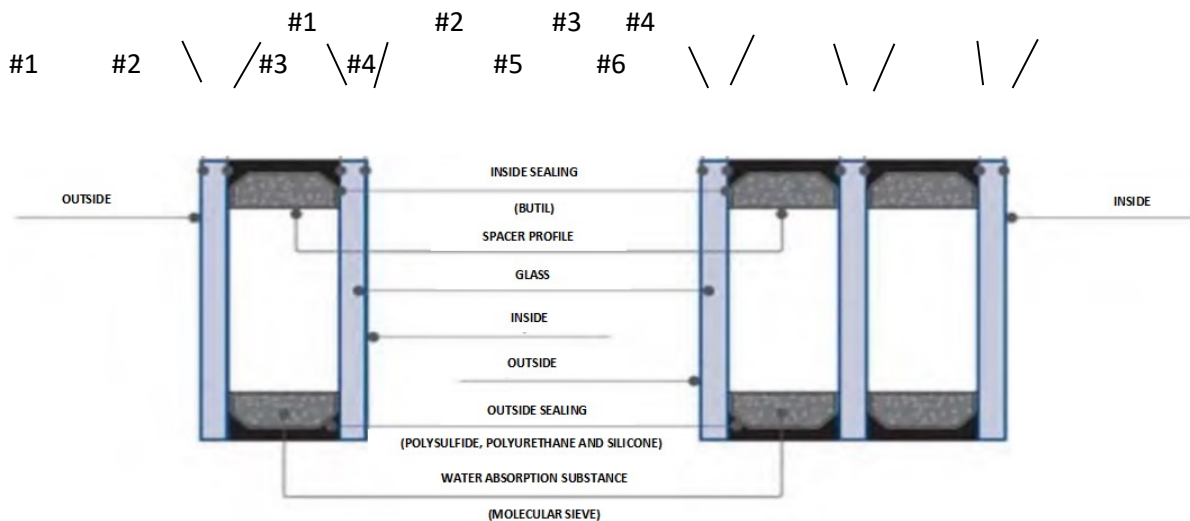


Lock	Security elements	No. Of locking places	Mechanical and electrical opener	Motor propulsion	KABA cylinder
RR 28		1	*		
BS 2100	mushroom	1+4	*		
AS 2500	hooks	1+2	Yes		
AS 2750	hooks i bolcne	1+2	*		Yes
AS 3600	hooks i wedge	1+2	*	Yes	Yes

(* function on request)

4.2.8 Glasses

Thermal insulation glass is standardly produced as a thermal package of double or triple glass.



The glasses we use in the products are:

No.	Description	Max. Surface of the glass outside(m2)	Max. Surface of the glass inside(m2)
1	Float 4mm	2,25	4
2	Float 5mm	3,1	5
3	Float 6mm	4	7,5
4	Float 8mm	7,2	9
6	Low-e 4mm 1.0	2,25	4
7	Low-e 6mm 1.0	4	7,5

The distance of the molding (spacer) used in the glass package is of the Chromatech ultra F type.



The strip spacer is used in dimensions of 10, 12, 14, 15, 16, 18 and 20mm width.

Standard colors of spacer:

- for PVC products, the color of the spacer is Light Gray RAL 7035 (gray)
- for ALU products the color of the spacer is Black RAL 9004 (black)

4.2.9 Panels

Standard types of panels:

Description	Color
	Outside / Inside
Panel 36mm	Antrazitgrau 1S Decor / Cremweiss glat
Panel 36mm	Antrazitgrau 2S Decor
Panel 36mm	Tahnnengrin 1S Decor / Cremweiss glat
Panel 36mm	Cremweiss 1S Decor / Cremweiss glat
Panel 36mm	Stahlblau 1S Decor / Cremweiss glat
Panel 36mm	white glat / white glat
Panel 36mm	cream glat / cream glat

5. Product quality standard

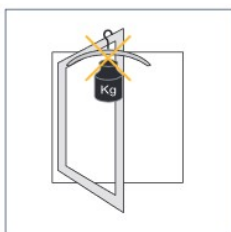
The product quality standard is a separate document, and it is an integral part of the Herceg product standard. The product quality standard describes the method of identification and quality control of the product by an expert, as follows:

- visual assessment of frame material
- quality assessment of insulating glass
- installation and control of sun protection elements on the window
- performance characteristics of the elements in the installed state
- installation and inspection criteria
- definition of the label for quality and certification
- cleaning, care and maintenance
- formation of condensation and mold

6. Standard of mounting and using the product

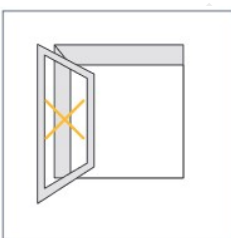
6.1 RESPONSIBILITIES AND WARNINGS

If you want a long life of product and its technical correctness and functionality, it is necessary to adhere to the stated instructions and guidelines.



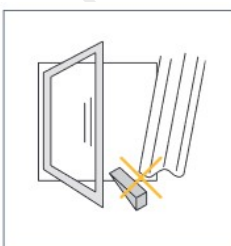
The window sash must not be additionally loaded

- Do not overload the wing, as this may damage the hardware and the sash may fall out of its bearing and injure you.



The sash wing must not extend beyond the fittings

- The wind must not strike or press the edge of the wall



Danger of placing an obstacle between the sash and the frame

- Improperly inserted materials (eg wedges or similar) to block the locking function may result in damage to the fittings and other parts of the product. !!



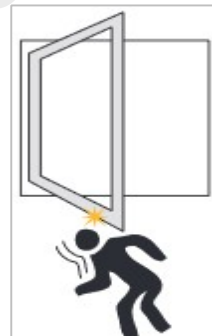
Danger of trapping body parts when closing

- When the windows are open, body parts can be pinched between the sash and the frame and injuries can occur. When closing the window, do not push your hands between the sash and the frame



Risk of injury due to falling through doors, windows, sliding walls and other construction openings.

- Use caution near open windows, doors, sliding positions and similar openings, especially when the window / door / sliding position is located on higher floors. Children and persons who are not able to independently recognize the danger and risk should be kept away from construction openings



Risk of damaging from strong gusts of wind

- During windy weather, the windows must be closed. Care should be taken that when closing windows, doors, sliding walls, etc. there are no obstacles between the sash and the frame. The openings must be locked. The manufacturer's liability for damage is excluded.



Danger of braking glass

- Standard glass can break easily. The resulting sharp edges of glass and glass debris are a potential risk of injury.



Burglar protection

- Entrance doors that are not properly locked (eg only locked via a tab) do not meet the requirements of anti-burglary protection



Atmospheric influences on carpentry

- Pollen, soot, insect droppings, iron dust (traffic, industry, etc.) and similar things can, in combination with rain and intense UV radiation, cause stains on frame surfaces that are difficult to remove. It should be cleaned as soon as possible with an adequate product.



Window, glass and fittings has to be protected before mounting from damage and plaster - activate the position functionally after the time.

- Positions that contain wings in their construction, ie. allow opening, closing and locking, should be used at least once a month to maintain the functionality of the fittings and avoid damage due to non-use (especially corrosion and stiffness).



Installation of windows and doors should be performed by qualified and professional persons

- In case of installation by unprofessional persons, we are not responsible for damage and errors.



Protective folis must be removed

- Right after the mounting, ie, within three weeks at the latest, remove the adhesive tapes, protective foil on the profiles and labels on the glass.

6.2 TRANSPORTATION AND WAREHOUSING OF WINDOWS

The products are transported on a metal pallet in the position in which they will be mounted later.

When handling with a crane or forklift, handle carefully, avoiding sudden jerks due to the risk of breakage and impact damage to the product.

Herceg d.o.o. is not responsible for any damage during transport, unloading and storage organized by a third party.

Time until installation, the products should be stored in a dry, well-ventilated (ventilated) room. In order to prevent the deposition of dust on the products, it is necessary to cover them with cardboard or protective foil



6.3 MOUNTING THE PRODUCTS

After removing the protective transport foil from the window, the following must first be checked before installation:

- Check window dimensions (DIN 18201)
- Are all the windows properly delivered? (DIN 18201)
- Is the corresponding window located at the intended installation site (DIN18201) - -
- Can the window be installed in an existing opening or it must be some additional finishings? (DIN 18202)
- Have the agreed tolerances been respected? (DIN 18203)
- Did the client receive parts of the building? (DIN 18203)
- Is the minimum joint width respected?
- Is there room to place a carrying and spacer block?
- Is the window in the horizontal and vertical position in the same plane?

DIN 18201 Measurement tolerances in construction, concepts, principles, applications, verification.

DIN 18202 Tolerances in building construction (buildings)

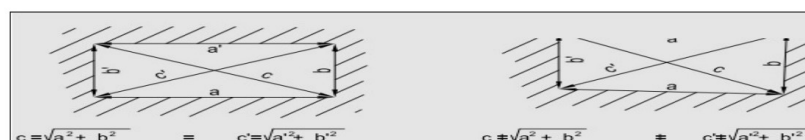
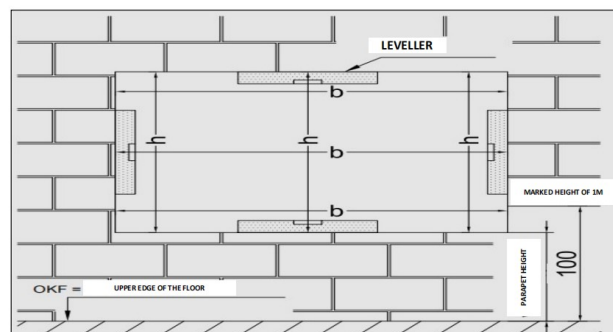
DIN 18203 Tolerances in building construction (prefabricated concrete parts, reinforced concrete.)



NOTE:

IF THE MINIMUM JOINT WIDTH IS NOT PROVIDED, INSTALLATION MUST NOT BEGIN!

The correctness of the installation opening is checked with the help of a meter and a libela. One of the methods of checking whether the joist is built at a right angle is to check the diagonal of the opening. If diagonals of different dimensions are measured, then it is not an angle of 90°.

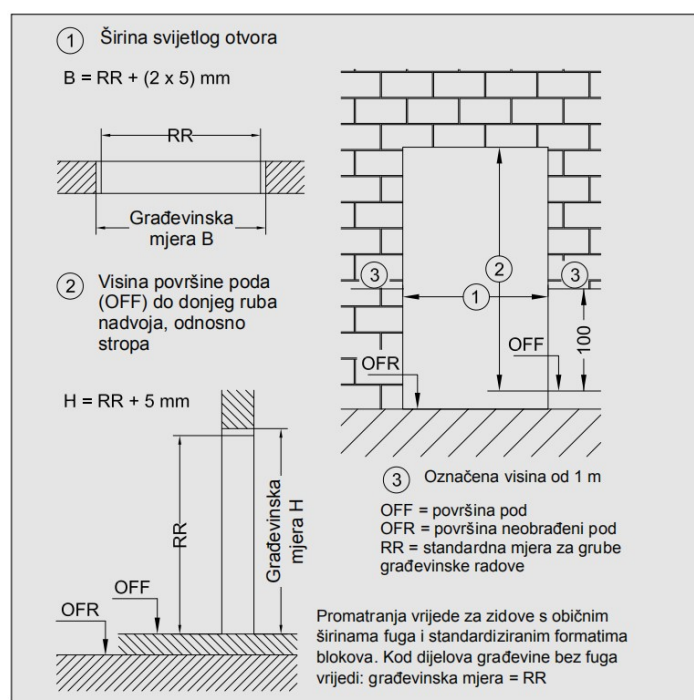


Picture 1. *Instructions for checking the accuracy of the mounting hole dimensions*

The reference measure for checking the accuracy of openings and mounting according to DIN 18100 is determined and marked by the person performing the rough construction work.

The height mark of 1 [m] is a mark located exactly 1000 [mm] above the surfaces of the finished floor (OFF).

It is made in all rooms near doors and windows using leveling devices and laser devices and is marked with visible color.

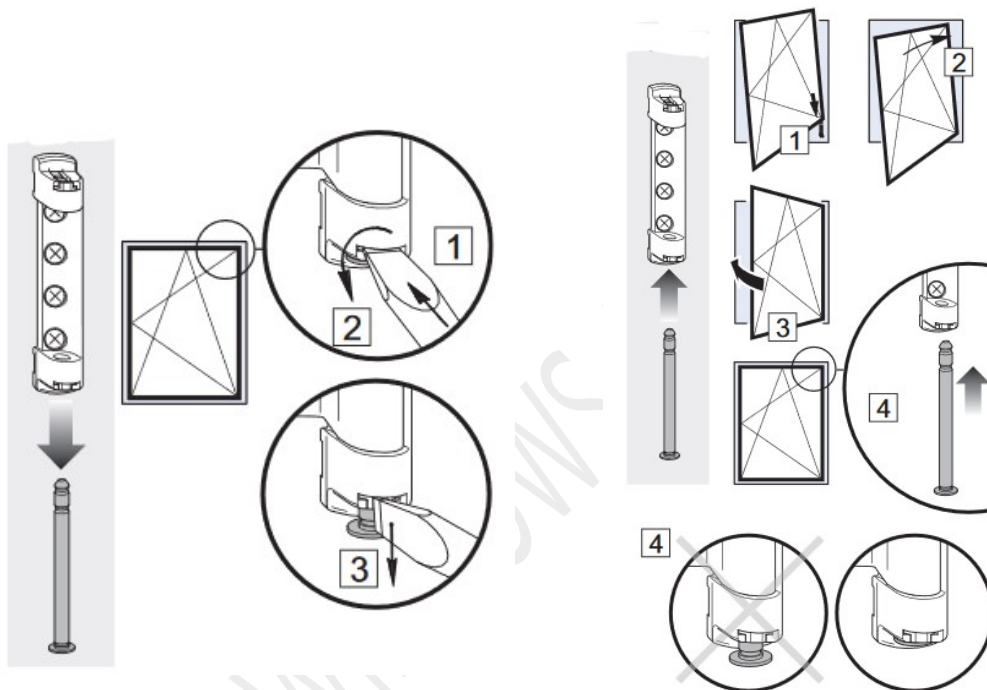


Picture 2. *Essential measures for assembly preparation*

6.3.1 Demounting of PVC window wing

Considering that the fittings are not the same for ALU and PVC windows, demounting method also is not the same.

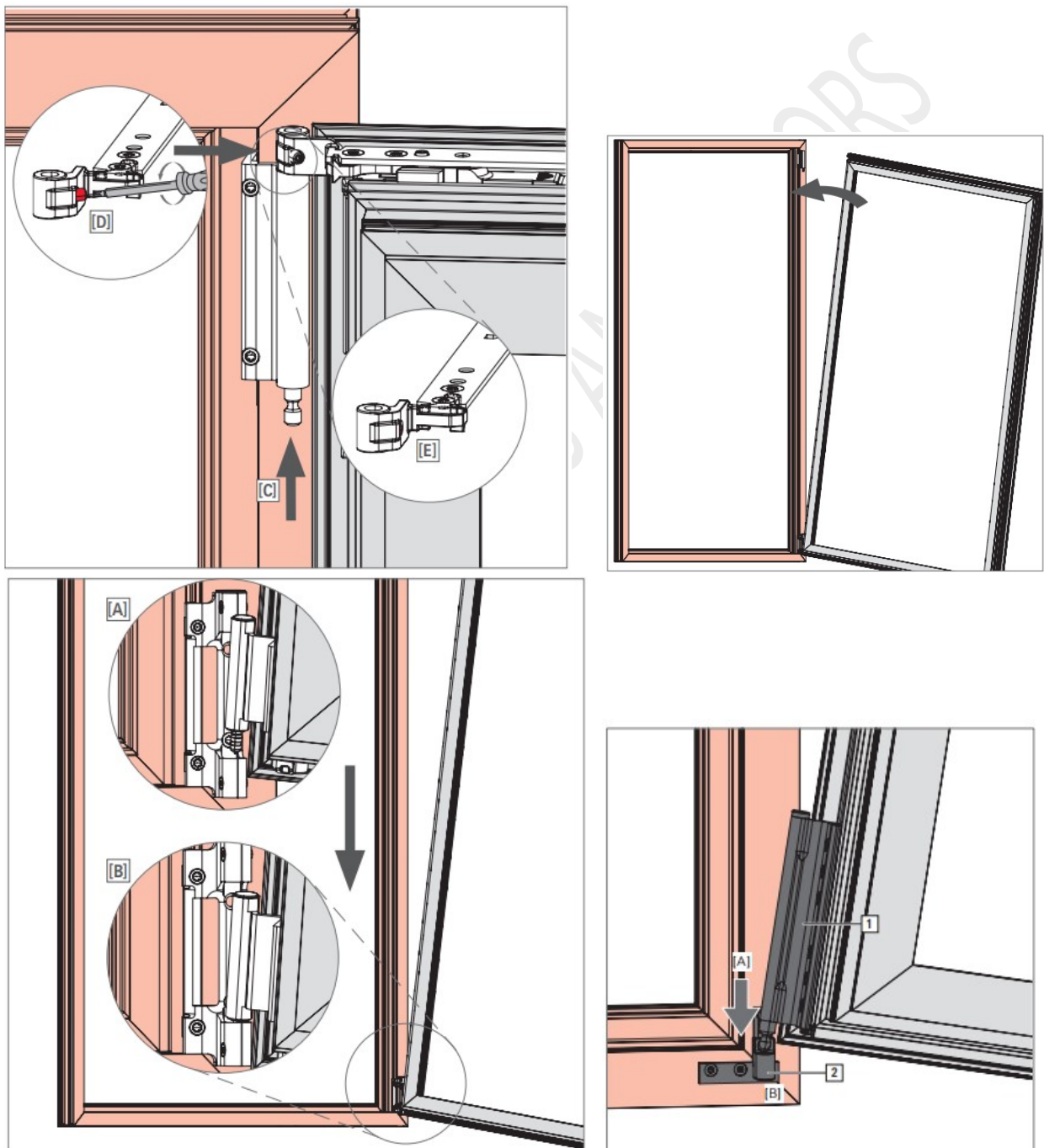
In the case of PVC windows, it is necessary to open the window and turn the handle to the closed position. When the wing is closed, pull the wedge down. Then open the wing carefully. Then wing has already been removed from the upper hinge bad. After that lift the sash up, tilt it and separate it from the outer frame. (Pic. 3)



Picture 3. Instruction for mounting and demounting of PVC wing

6.3.2 Demounting of ALU window wing

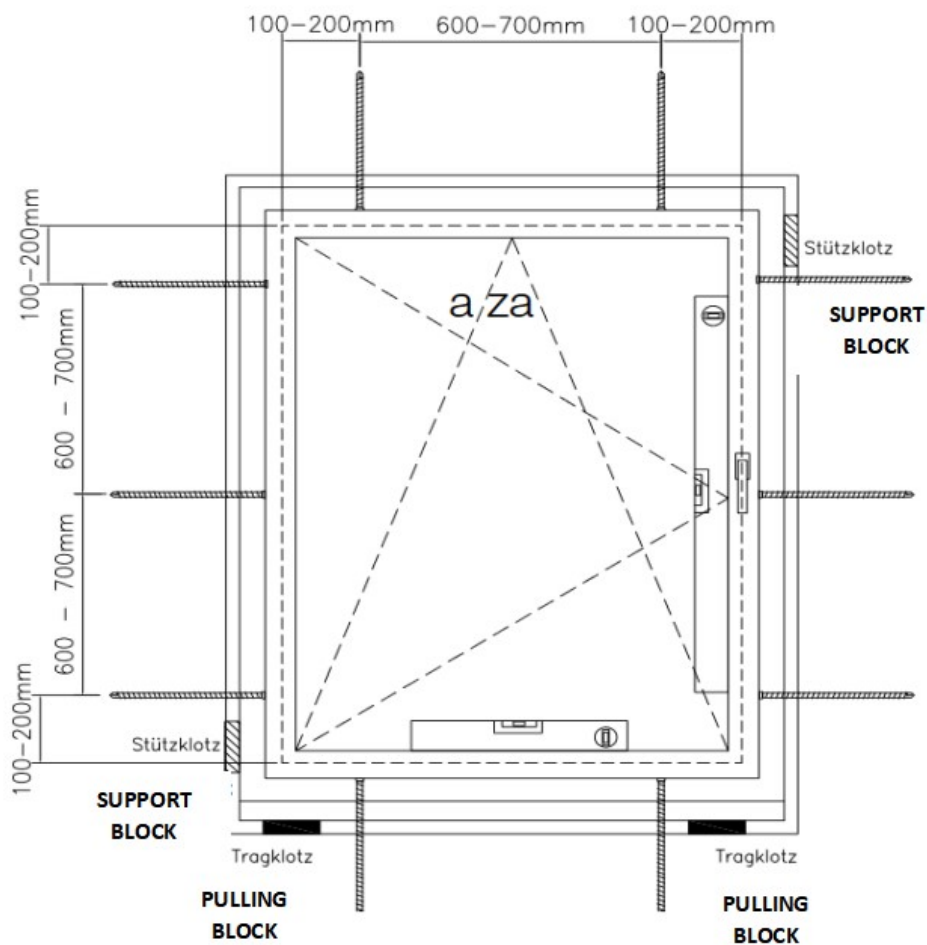
In the case of ALU window it is necessary to close the window and turn the handle in rotating position. After loosening the screw from the bearing, pull the pin down. Open the wing. The wing has already removed from the upper hinge bearing. After that lift the wing up and separate it from the outer frame. (Pic. 4)



Picture 4. Instruction for demounting of ALU window

6.3.3 Mounting of window wing

Install the outer frame into the hole in the wall. Outerframe is placed in a masonry opening and fixed with wooden wedges, and it must be placed in right vertical, horizontal and rectangular position with a libela. Observe the mounting intervals according to the recommendations as in the attached photo. Equalize the load in accordance with the recommendations to ensure the stability of the window. Supports or wedges are also placed on the side. The outerframe is then fastened with turbo bolts. Note: do not drill with a hammer drill in case of bricks!

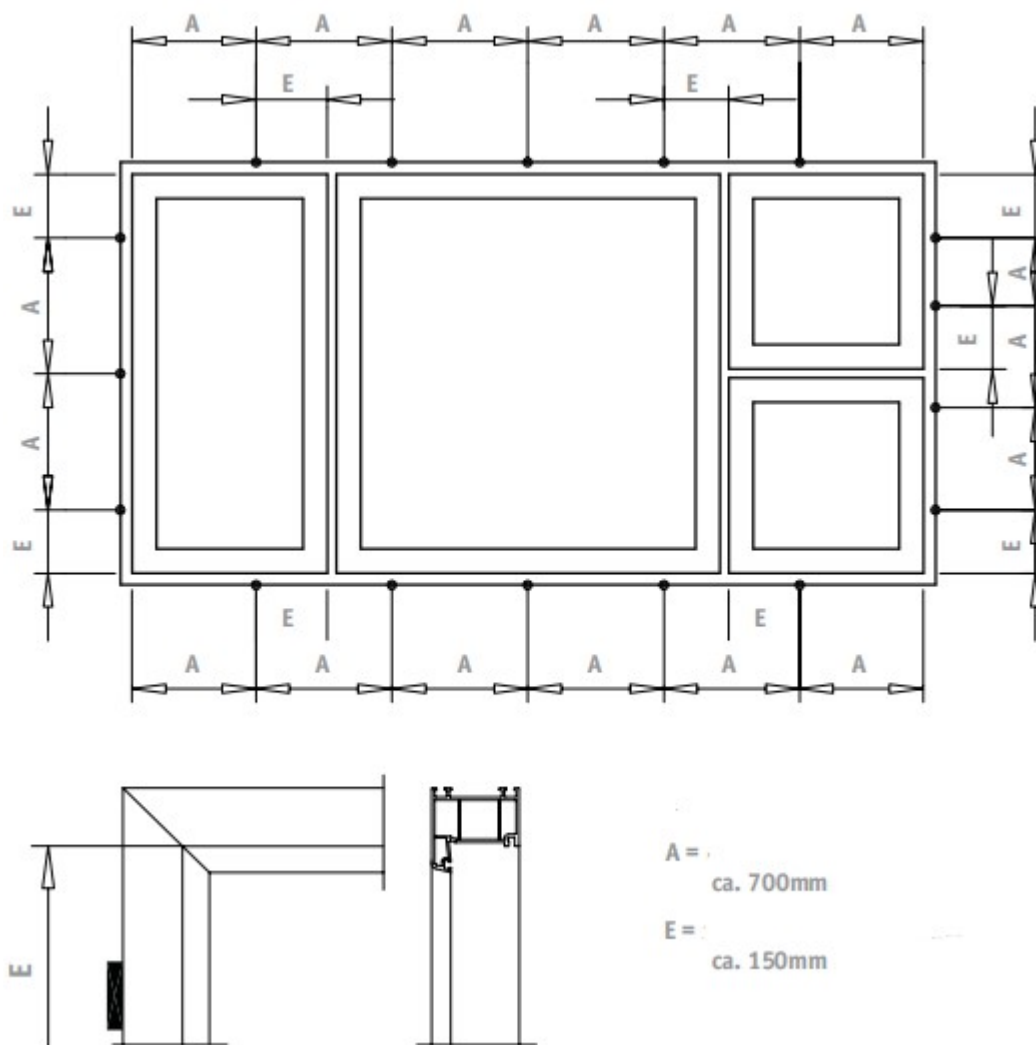


Picture 5. Arrangement of places provided for attaching the frame

When mounting with screws:

- Use screws with a small head diameter of 7.5 mm and adjust the length to the wall.
- Make sure that the screw head is aligned with the profile.
- If the screw is too tight, it should not be unscrewed. The profile can break! In this case, use the supplied 8 mm covers.

For large and heavy elements, such as balcony doors, house doors, parallel sliding doors and tilting doors, lifting and sliding doors or triple glazing, screw mounting is recommended. The mentioned mounting technique can directly and efficiently redirect the generated forces to the walls themselves.



Picture 6. Arrangement of fixing points for the complex position

When mounting positions of complex shape, it is necessary to take into account the position of the fastening points. The prescribed arrangement of screws is approximately every 700 mm, however in the case of complex position it is necessary to additionally fix the position at a distance of 150 [mm] from the end of the frame or the axis of the bar.

6.3.4 *Instaling the sash on the outerframe*

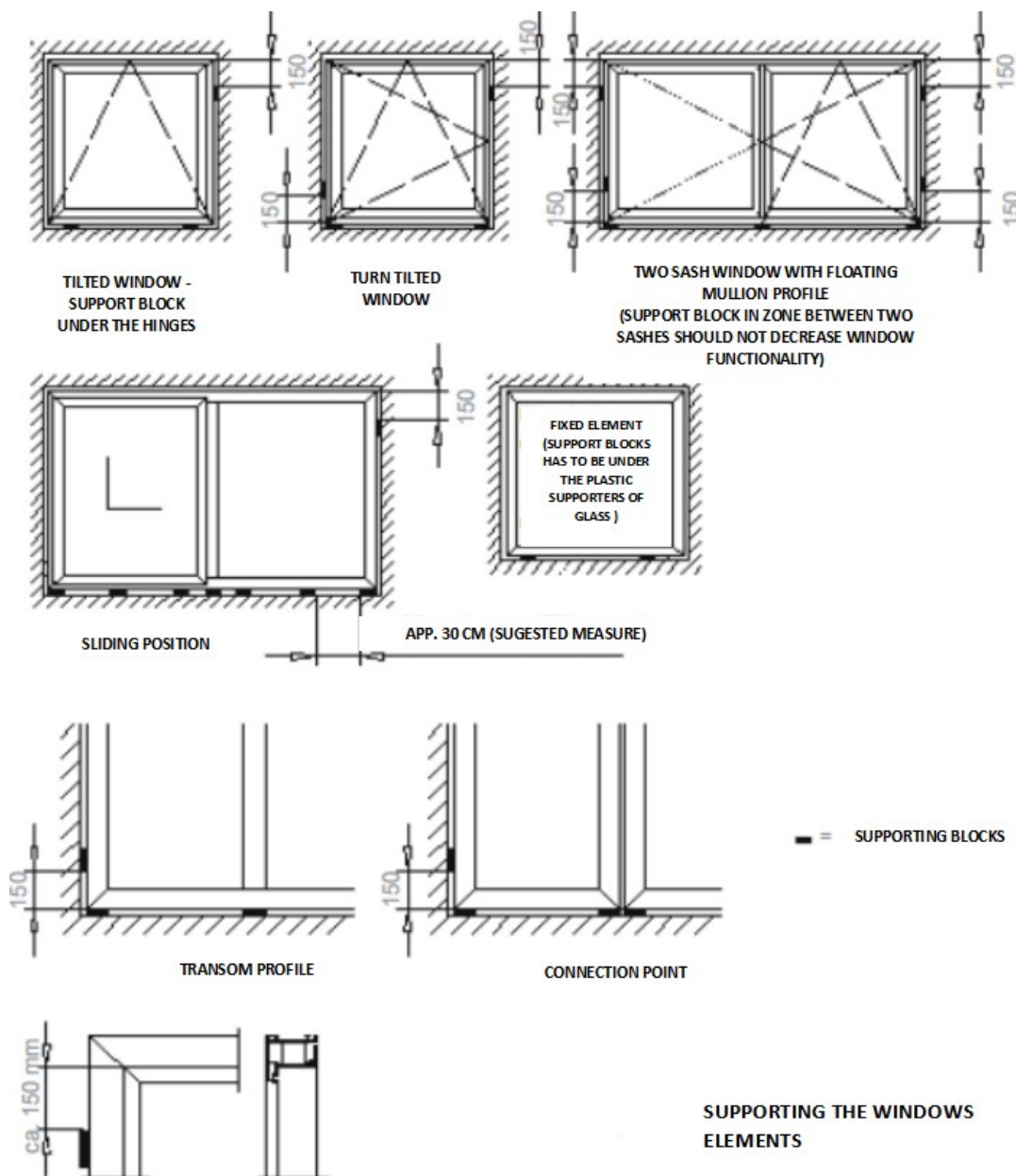
After mounting the frame it is necessary to return the sash to the frame. The wing install on the lower hinge and then attaches to the upper hinge returning the wedge to the bearing.

6.3.5 *Position of the cushion during installation of PVC, AL and sliding positions*

When installing windows and doors and using cushions, it is necessary to pay attention to the following:

1. The cushions must be of suitable material (pvc, wood, etc.)
2. The arrangement of the cushions must not affect the extensibility of the elements (dilation),
3. The cushions must remain in the construction gap (permanently installed) due to weight transfer
4. The position of the cushions must not interfere with the performed other construction works after installation

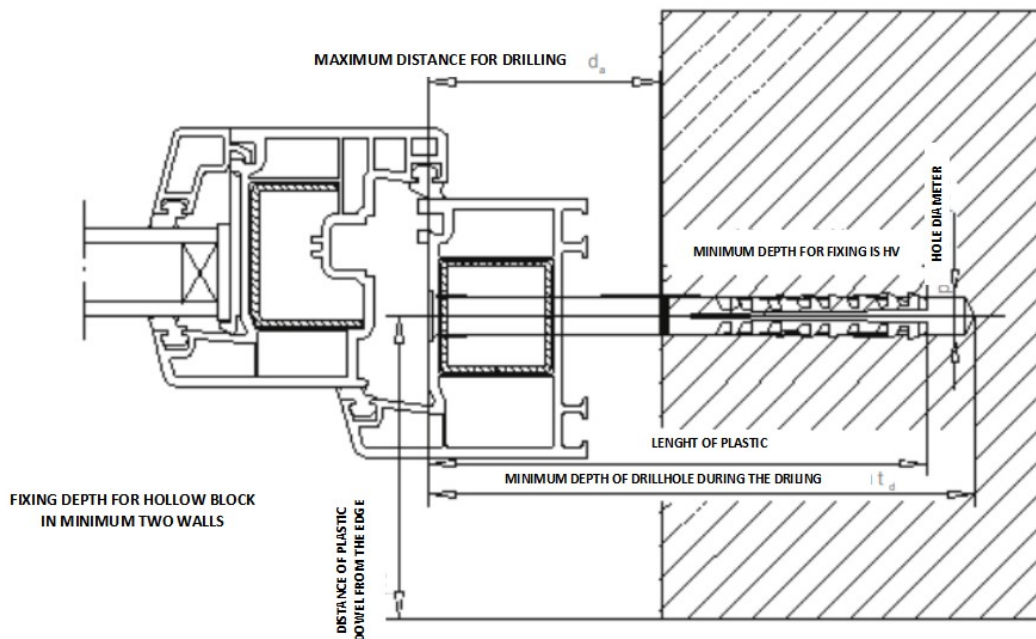
Note: when mounting the lifting and sliding position, it is mandatory to use cushions and position them every 300 mm.



Picture 7. Places provided for the installation of cushions during installation

6.3.6 Mounting materials

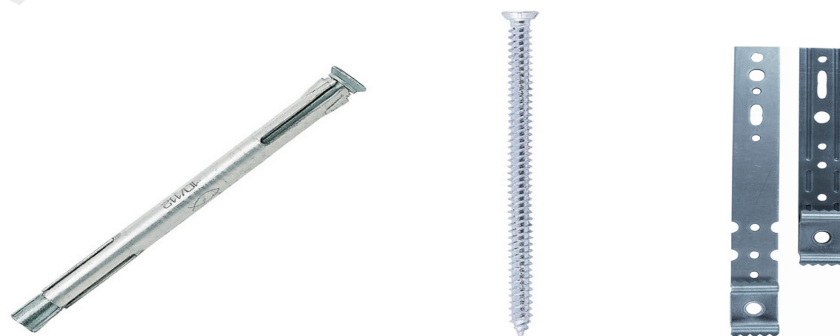
The situation in the construction (on the building) is relevant for the correct choice of fastening means. The wall and fasteners must be aligned. The choice of fastening means is chosen according to the method of wall construction. In the case of a wall made of hollow blocks, the space inside the block around the dowel must be filled (eg by injecting mortar).



Picture 8. *Essential fastening measures*

The following materials are used for the installation of windows and doors:

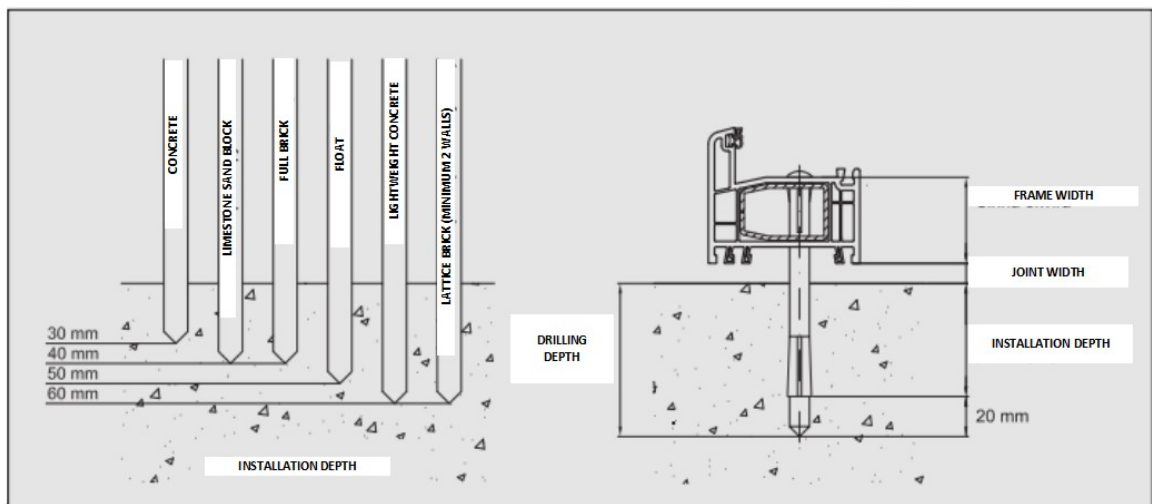
1. Frame dowels
2. Frame fasteners (turbo screws)
3. Masonry anchors



Picture 9. *Frame mounting materials*

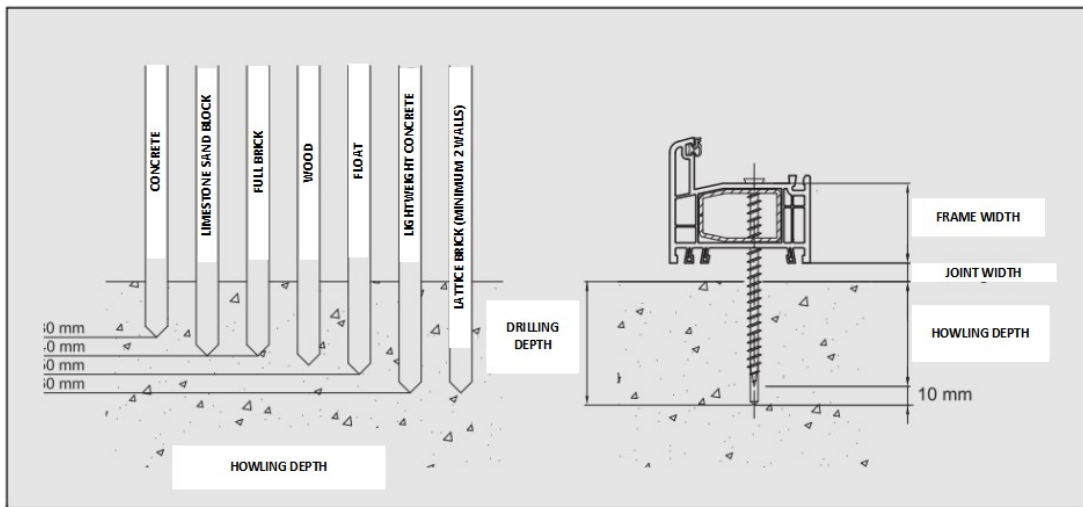
Frame dowels are loaded with shear and bending stresses. Therefore, the use of frame dowels, especially for heavy loads, is limited due to the required distance between the wall and the frame. The advantage of the frame dowels is that the frame can slide on the bushings and thus there is a possibility of expansion. Dowels with a metal sleeve from $\varnothing 8$ to $\varnothing 10$ mm proved to be especially good.

If they are used in the lower horizontal frame, then the dowels must seal particularly well in the glass slot. Otherwise, damage due to water penetrating inside is likely. Frame dowels are suitable for materials: concrete, solid bricks, limestone blocks, solid lime-sand blocks, hollow perforated bricks, perforated lime-sand bricks, hollow blocks, solid float, gas concrete, natural stone, etc.



Picture 10. *Mounting with frame dowel and length recommendations depending on the material*

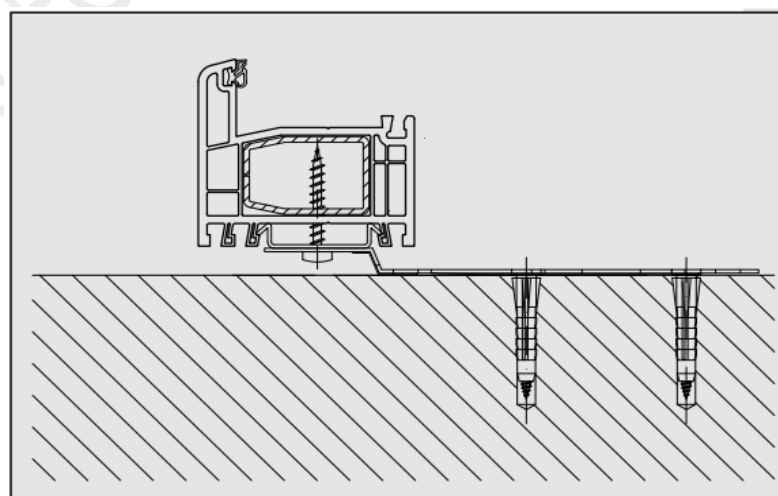
Frame fasteners are special screws that fasten the frame to the wall directly, without dowels. They are placed as normal dowel frames, but do not have to drill large holes. Installation and sizing can be found in the manufacturer's instructions. If they are used in a lower, horizontal frame, then the screw in the glass slot must seal particularly well. Otherwise, damage due to water penetrating inside is likely. Frame fasteners are suitable for: concrete, solid bricks, limestone blocks, hollow perforated bricks (min.2 walls), buoyancy, lightweight concrete, wood, etc.



Picture 11. *Mounting with frame fasteners and length recommendations depending on the material*

Masonry anchors (also called clamps or buckles) are relatively easily flexible. In this way, the movements of the frame material along the length are well absorbed. The masonry anchor can only absorb forces perpendicular to the plane of the window. The masonry anchor should always be used where the edge distance at the frame dowels would be too small or the sealing of the dowel in the glass groove would not be guaranteed (only below).

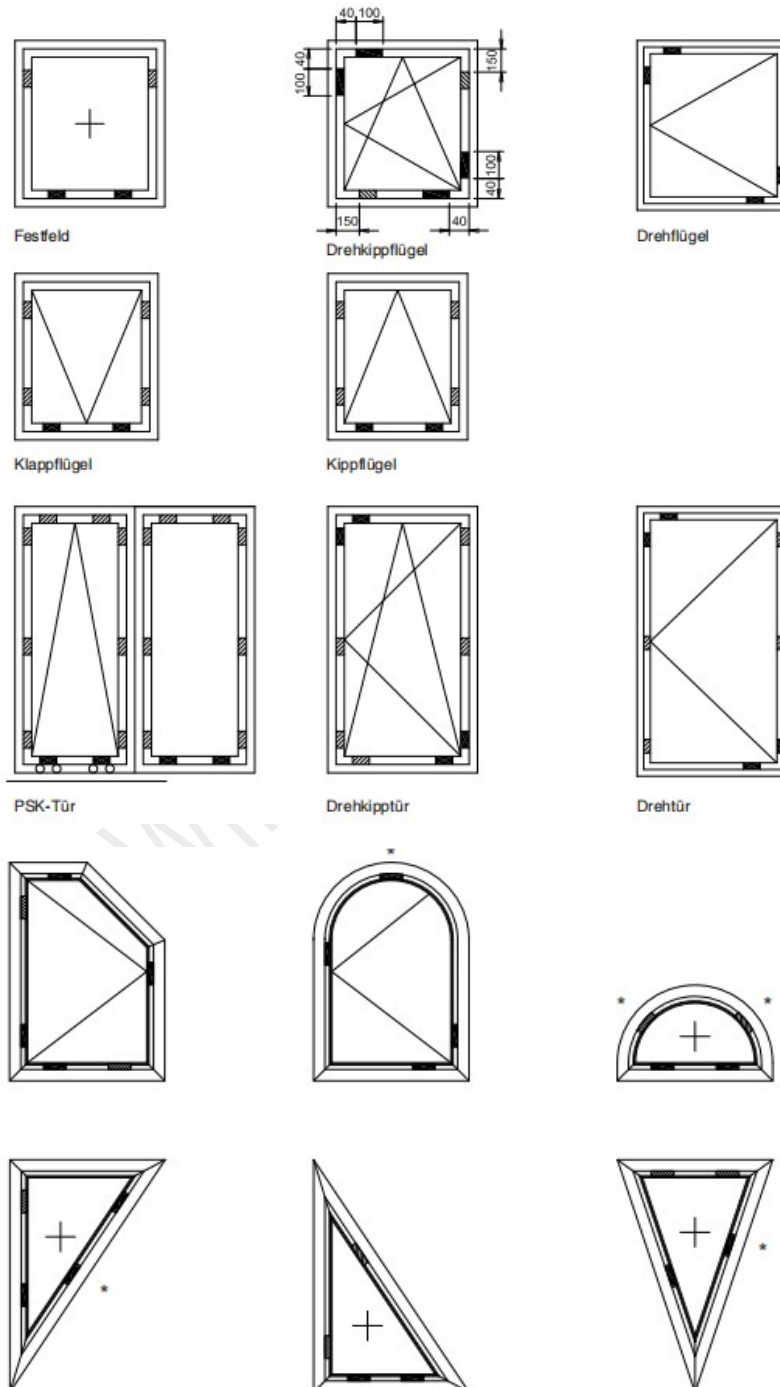
The masonry anchor is inserted obliquely into the back of the frame using a claw and pressed against the frame until the other claw is securely fastened. The foot should be additionally fastened to the frame with a screw. Now the console can be rotated, bent, and the window inserted. Masonry anchors are connected to the body of the building with suitable screws and dowels.



Picture 12. *Masonry anchor*

6.3.7 Instructions for glazing windows and doors

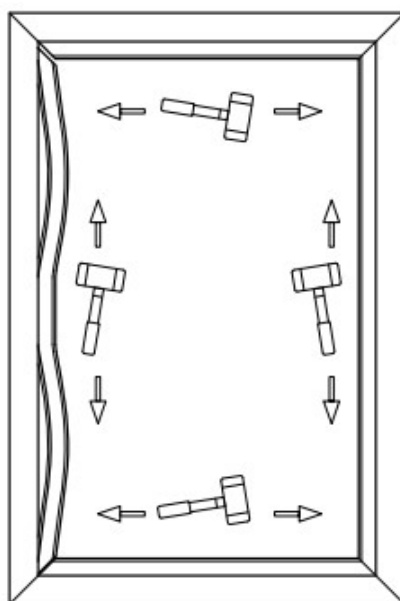
When glazing, it is necessary to install support blocks or glass supports. The horizontal support block on the side of the hinge is placed at a distance of 40 mm while the second support block is placed at a distance of 150 mm to allow smooth operation of the window elements due to tremor differences.



Picture 13. Position of supports during glazing

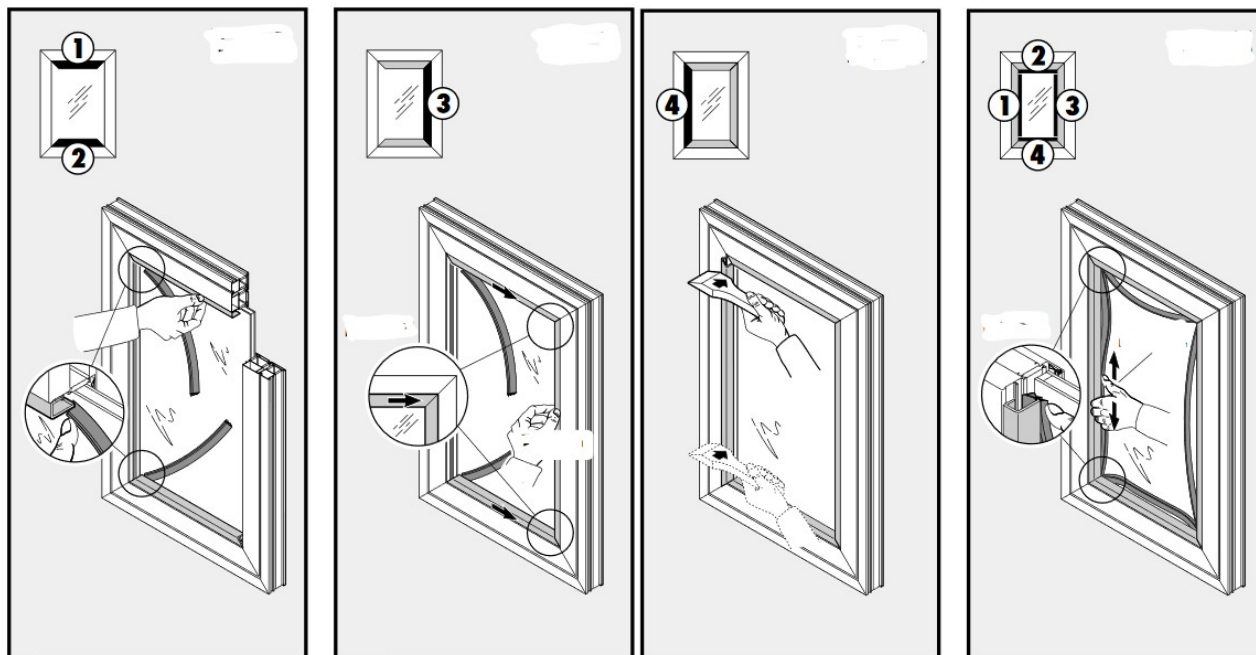
6.3.8 Installation of glazing moldings

When glazing the PVC positions, glazing strips are placed in the slots and fastened with a rubber hammer. First, shorter strips are placed in a horizontal position. After that longer vertical strips are placed, which are bent in the middle and inserted between two horizontal strips, and from the middle to the end they are aligned with light blows with a rubber hammer.



Picture 14. *Directions of movement with a rubber hammer when installing PVC moldings*

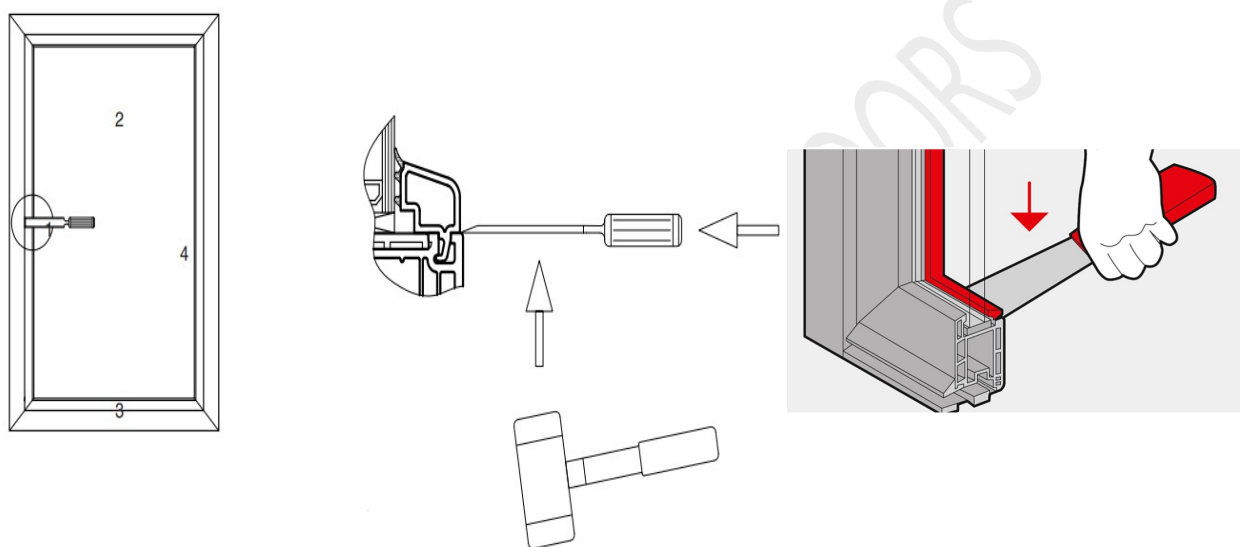
Installing a glazing strip in an ALU system requires a different approach. In the case of aluminum positions, glazing strips are first installed, and then the seal is retracted. As with PVC, horizontal strips are installed first, followed by left and right verticals. The sealant must be cut to size, ie at the joints it is cut at an angle of 45 degrees.



Picture 15. Sequence of work operations during glazing of ALU positions

6.3.9 Demounting of glazing strips

For demounting the glazing moldings, both aluminum and pvc, use a dieter. The top of dieter is placed horizontally between the glazing molding and the profile, and a light blow with a rubber hammer separates the molding from the profile.

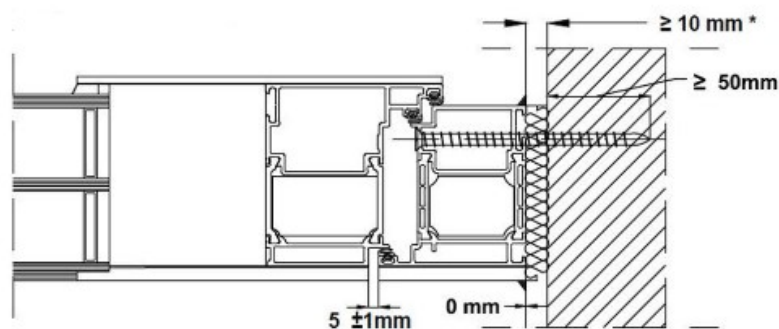


Picture 16. Display of demounting of the glazing strip

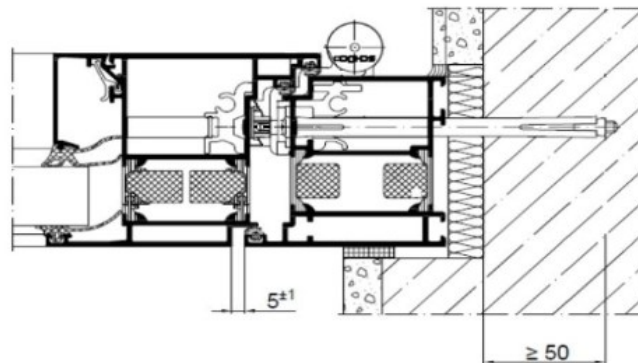
6.4 DOOR MOUNTING

In relation to windows, entrance doors are exposed to both static and dynamic loads. Due to the weight of the door sash itself, the smaller number of fastening points in relation to the windows or the stronger closing, the dynamic loads on the door are stronger than static. In addition to the intended mounting points during installation, additional fastenings must be made. The three most common ways to fix a door are:

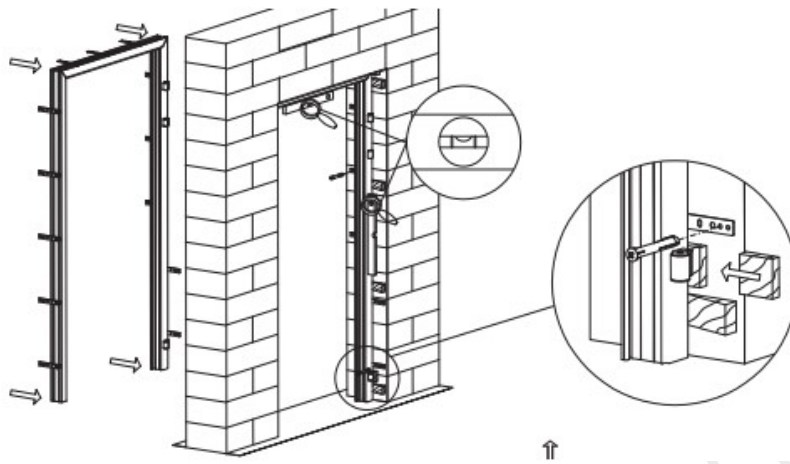
- 1) Frame fasteners (turbo bolts)
- 2) Frame dowels
- 3) Masonry anchors



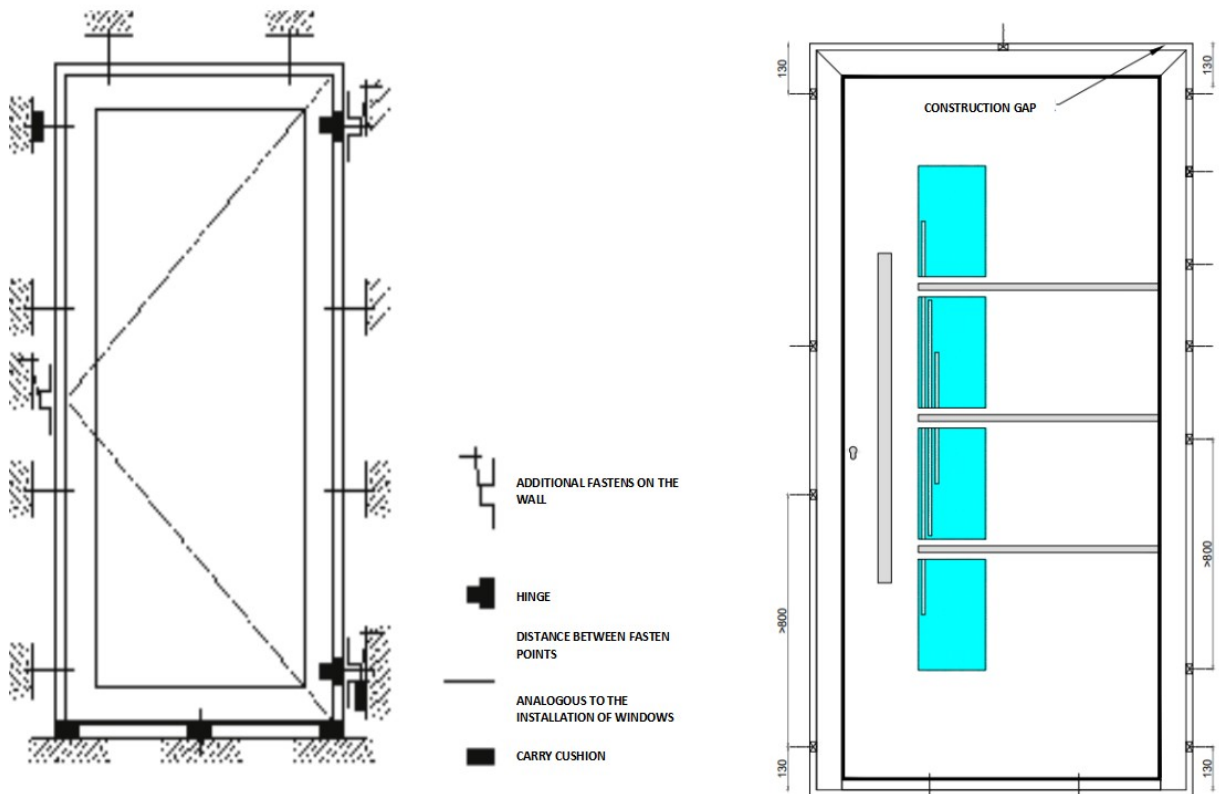
Picture 17. Fixing with frame fasteners (turbo bolts)



Picture 18. Fixing with a frame dowel

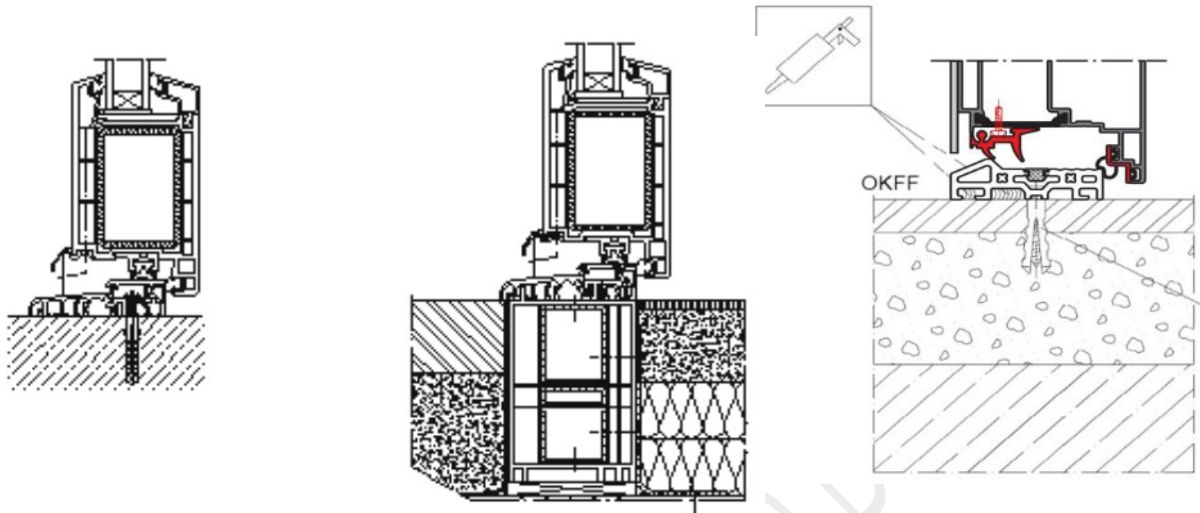


Picture 19. Fixing using masonry anchors



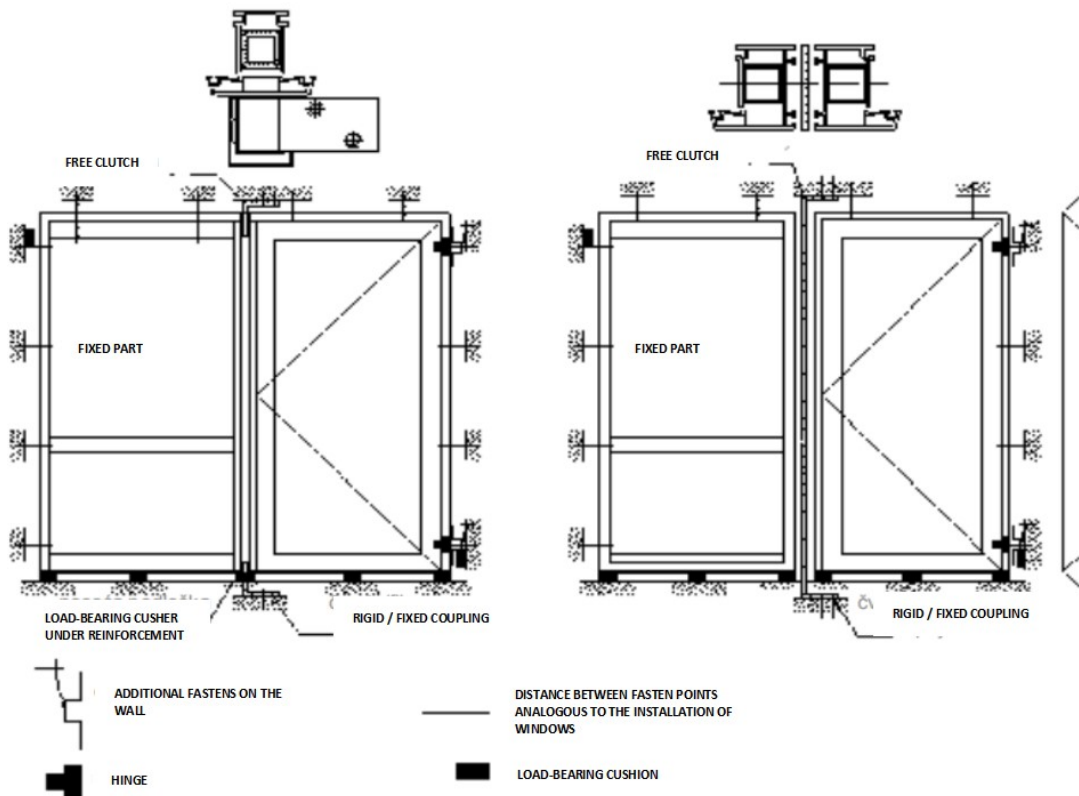
Picture 20. Arrangement of screws for fixing the front door

In the lower zone where the threshold is located, the attachment of the threshold is provided as follows:



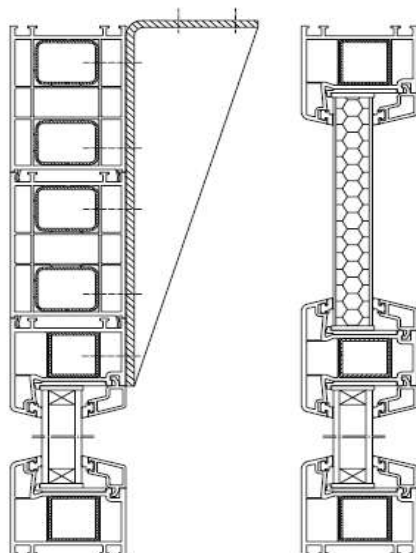
Picture 21. *Threshold fixing detail*

With multi-part entrance doors with connected individual parts or a column, it is possible to install additional static reinforcement to increase the stability of the position.



Picture 22. Multi-part door connection method

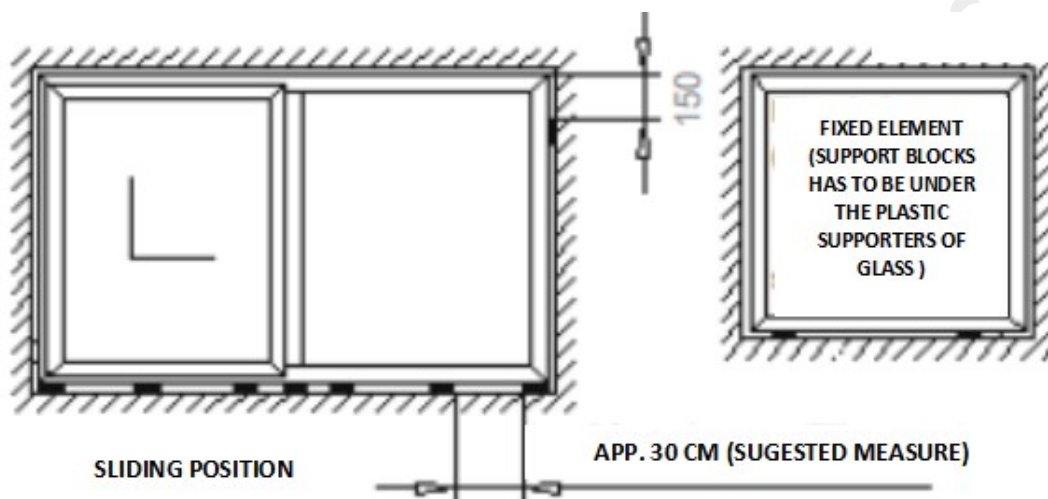
If extensions are used in positions and if the height of the extension exceeds a height of 60 mm, screw fastening is not sufficient and it is necessary to use an angular connection as additional static reinforcement.



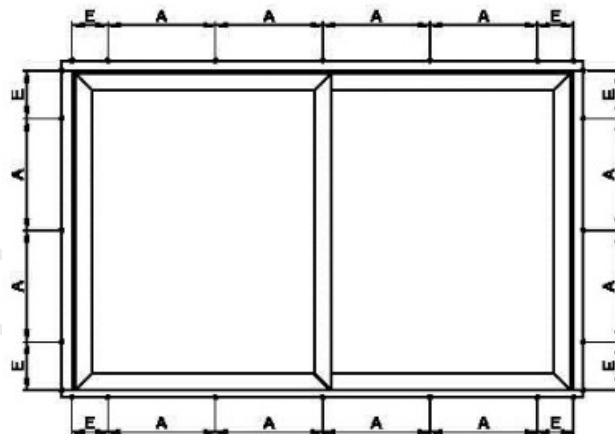
Picture 23. *Detail of placing the angular reinforcement on the extensions*

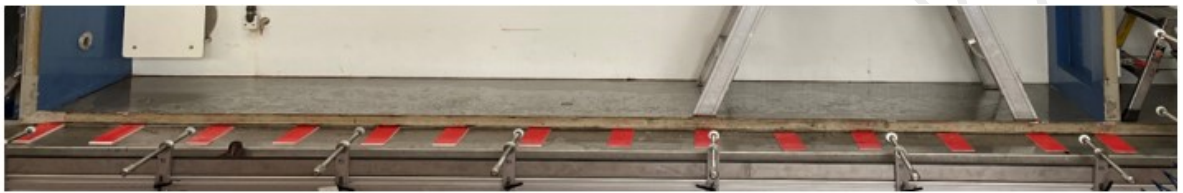
6.5 MOUNTING A SLIDING POSITIONS

When mounting the sliding positions, the maximum distance between the load-bearing cushions must not exceed 30 cm. It is recommended that the cushions be made of pvc material, dimensions 60 x 35 cm. Fasteners must be permanent carriers of the load, of suitable material and must not affect the growth of the element. Certainly the most important information when mounting a sliding rock is that the position must be fully brought into the scale.

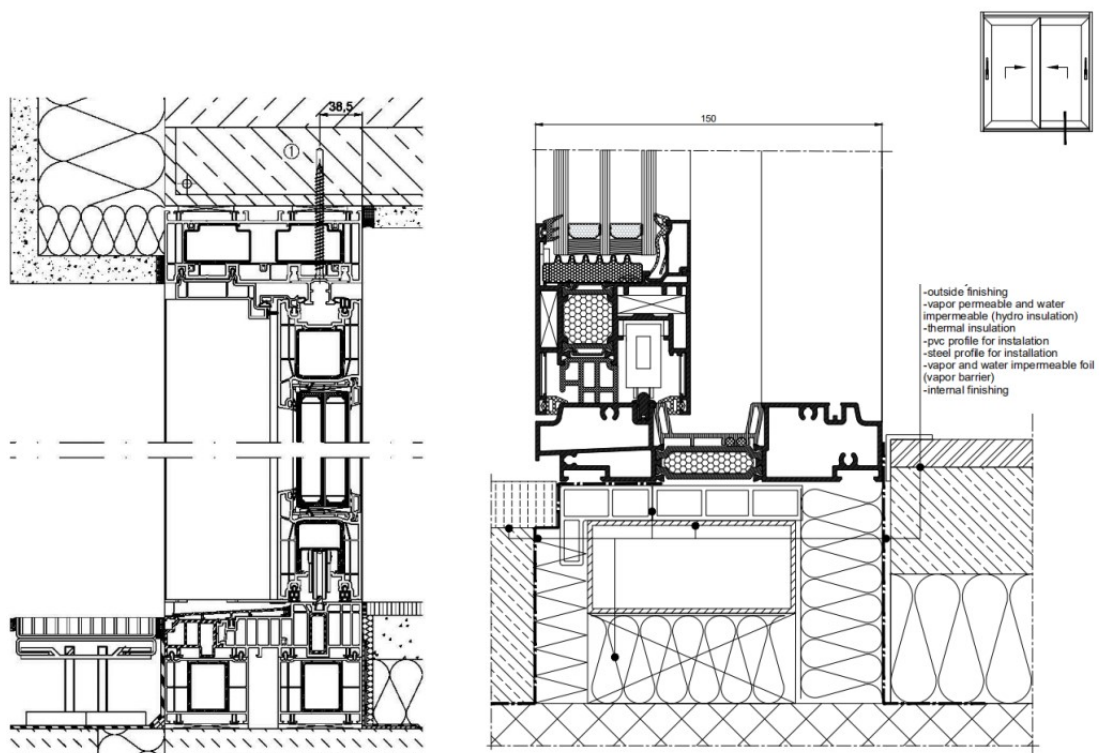


Picture 24. Position of laying the wedges when mounting the sliding positions

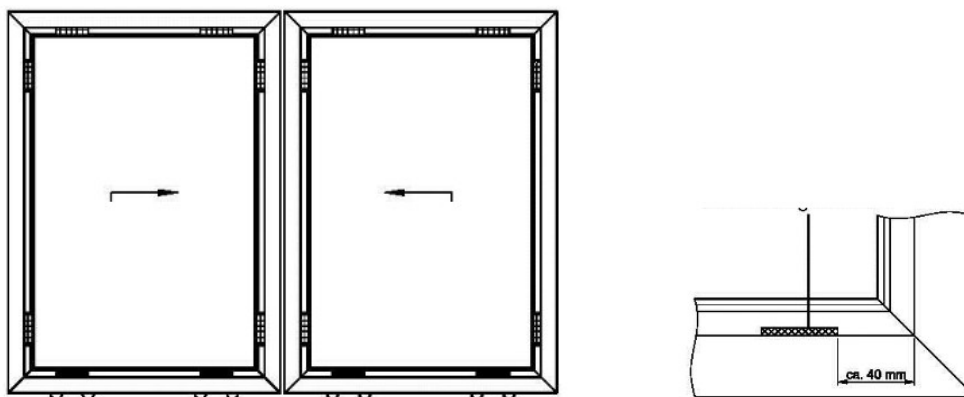




It is recommended to use a prepared substrate such as a metal pipe or a plastic mat when mounting the sliding positions.

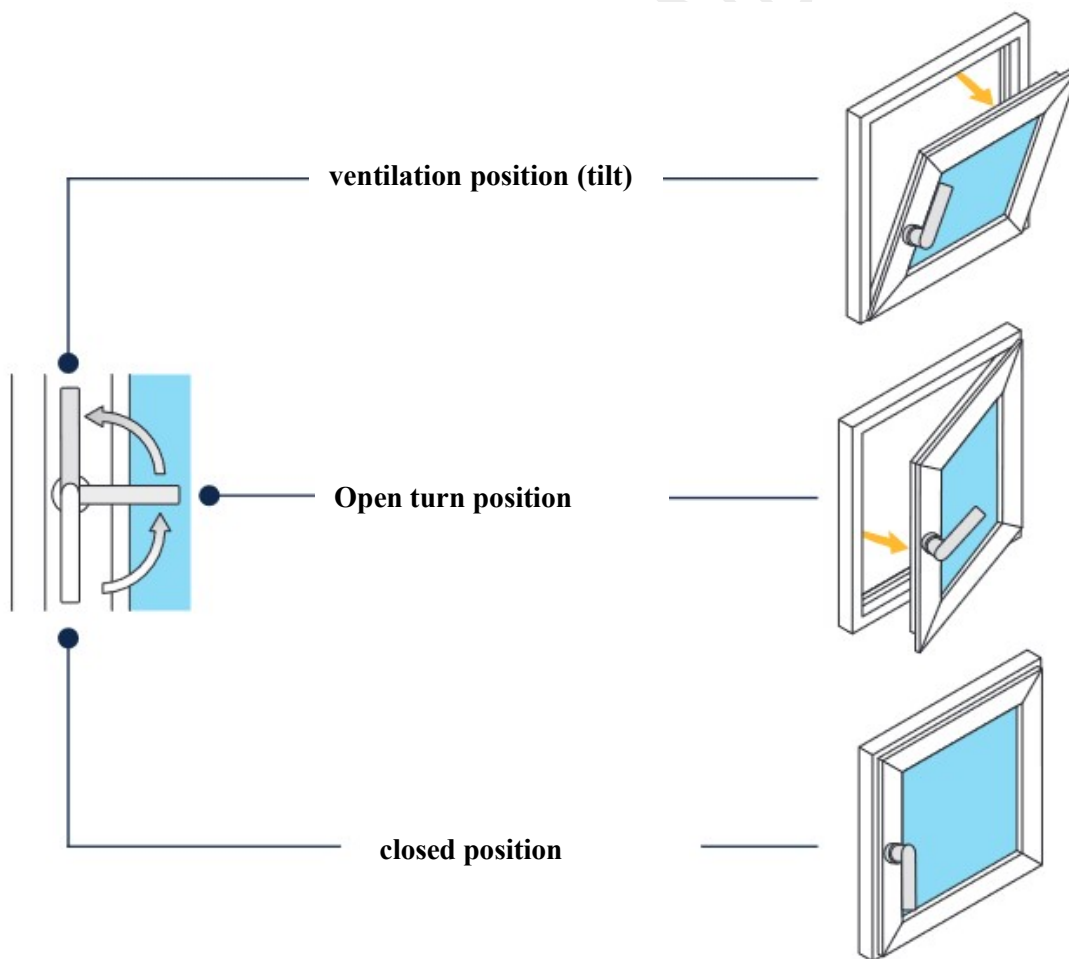


Picture 25. Detail of installation of sliding positions with metal or plastic pads

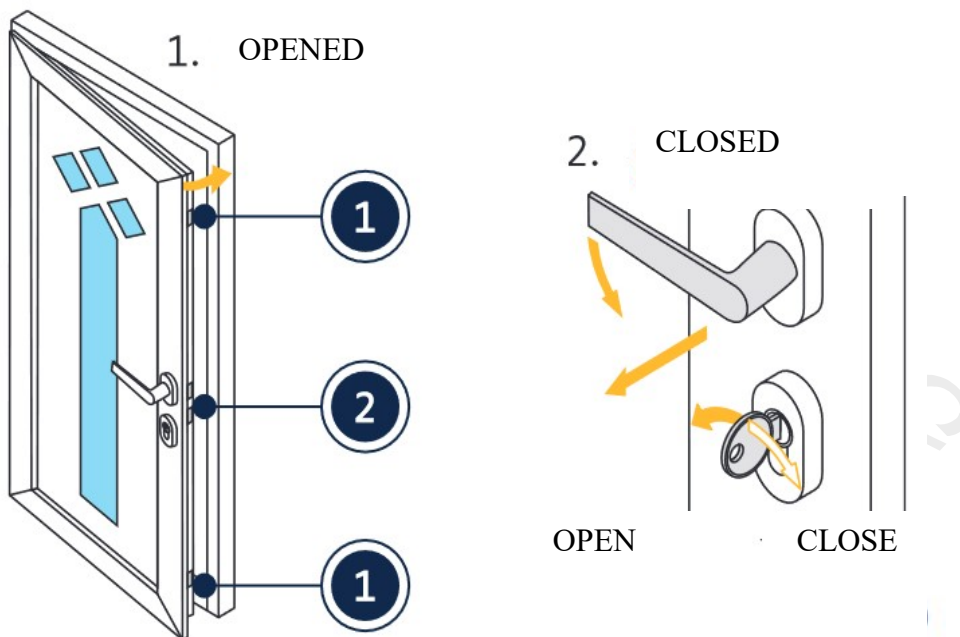


Picture 26. Position of installation of glazing strips

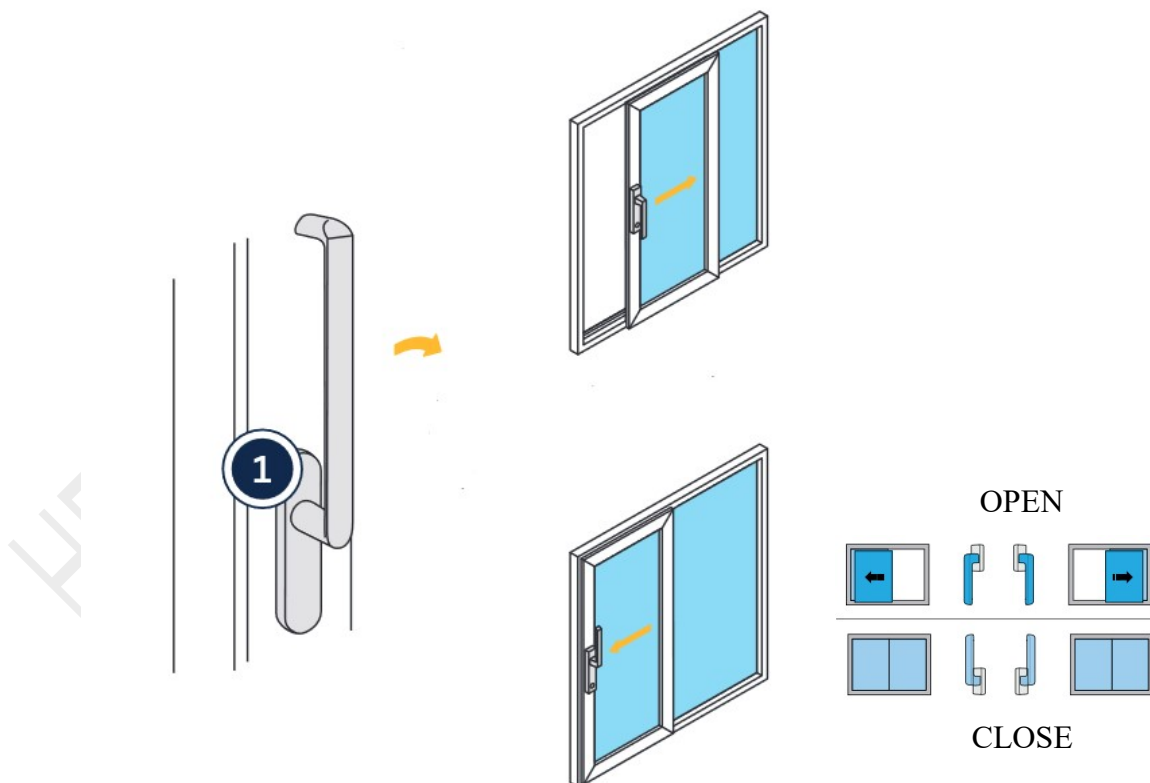
6.6 OPERATING INSTRUCTIONS (OPENING / CLOSING)



Picture 27. Demonstration of proper handling of the turn tilt window



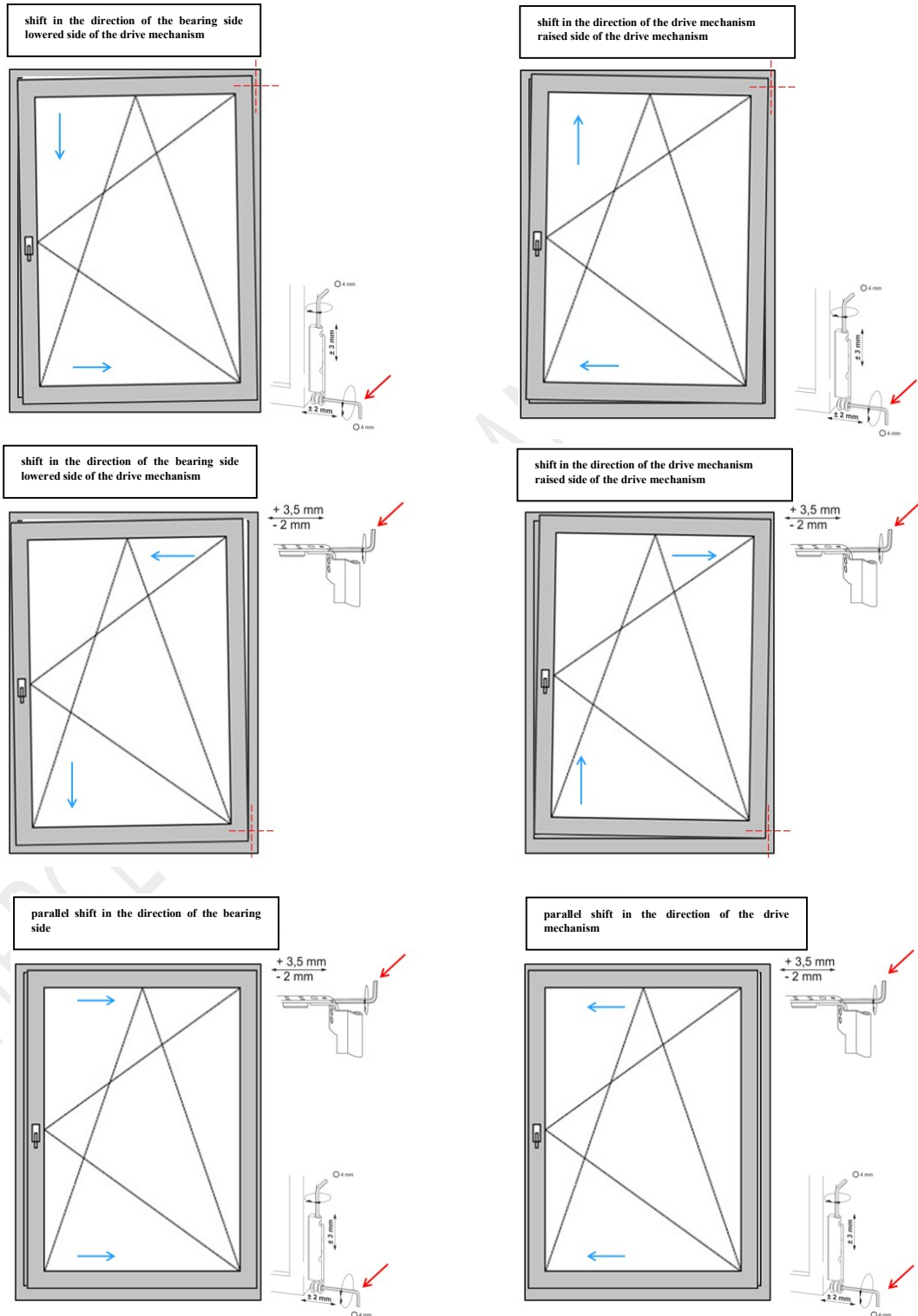
Picture 28. Demonstration of proper handling of the front door



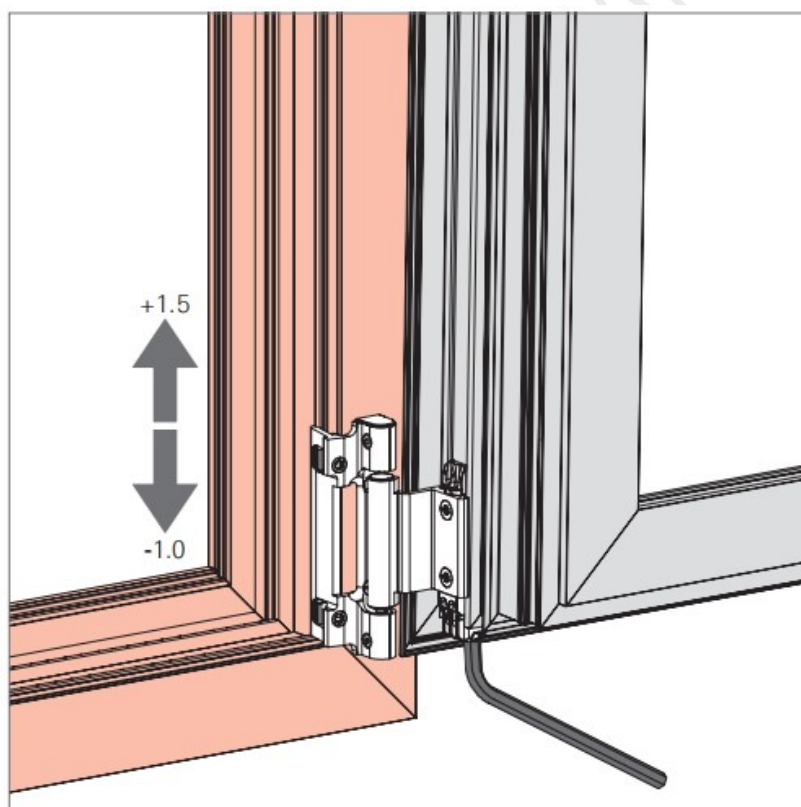
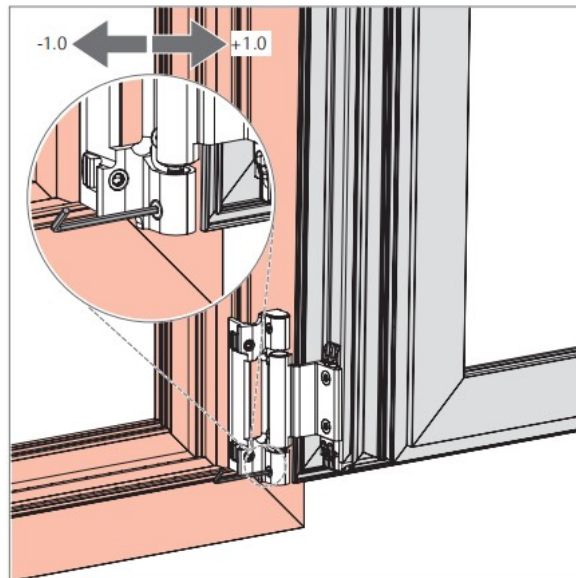
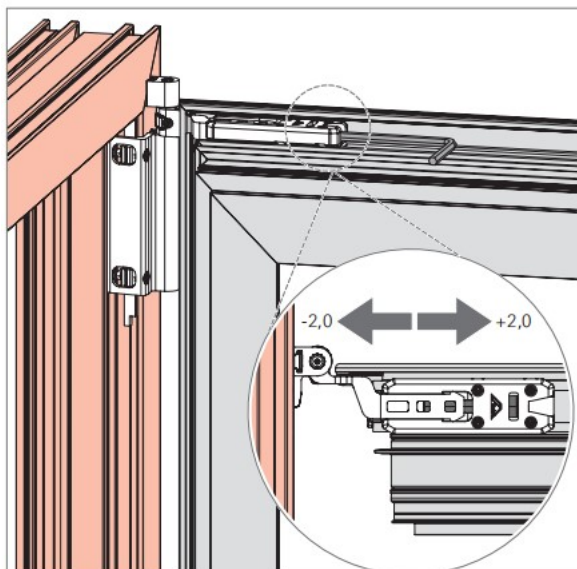
Picture 29. Demonstration of proper handling of lifting sliding positions

6.7 HARDWARE ADJUSTMENT INSTRUCTIONS

6.7.1 Fitting adjustment for PVC windows

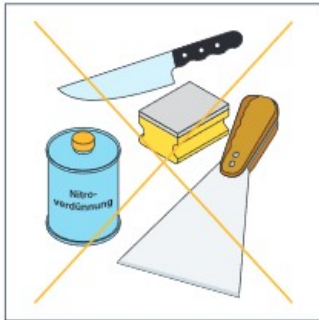


6.7.2 Fitting adjustment for ALU windows



7 USE AND MAINTENANCE STANDARD

7.1 CLEANING AND MAINTENANCE



Accessories that must not be used for cleaning

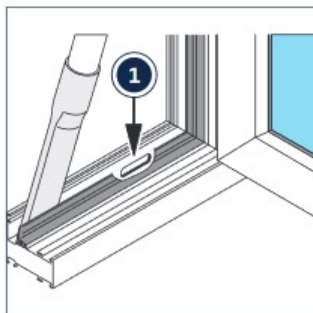
- Tools with sharp blades, such as knives,
- metal blades,
- steel wool,
- fish side of household sponges, etc.

The use of aggressive cleaning agents or solvents such as nitro thinners, varnish removers, also cause permanent damage to the surface of the element and is not recommended for cleaning.

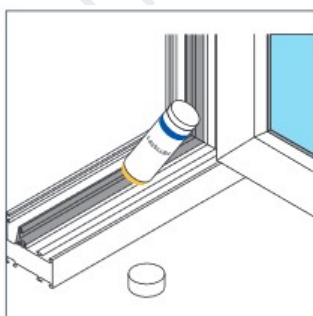


Optimal window care can be achieved by cleaning window frames and seals every time you wash the window. It is recommended to use a mild, non-rinsing cleaner.

"Solid stains" such as plaster, plaster residues or the like are best removed with a wooden or plastic spatula.

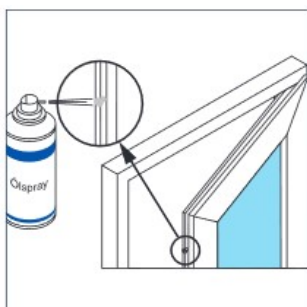


Use a vacuum cleaner to remove dust and debris from the space between the seal and the outside of the frame. Blocked water drains can be cleaned with a thin wooden or plastic stick. You also need to use a vacuum cleaner to remove dust and dirt from the guides at sliding positions to prevent the wheels from blocking.



Inspect and lubricate seals

All seals should be treated with a grease pen or Vaseline. This makes them supple and prevents them from sticking. Also take this opportunity to check for potential damage to the seals.



All moving parts of the hardware in your Herceg elements require almost no maintenance. But a little acid-free oil and grease keep the mechanics smooth and ensure ease of use over a longer period of time.



Spray the moving parts of the fittings with an oil spray or apply the lubricant directly and ensure the permanent functionality of the product. All points should have only a light film of lubricant. To avoid contamination and accumulation of dirt, wipe off any excess lubricant after lubrication.