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		ISO 14001:2015
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<i>MSD</i>	Confirmed: 	Date: 06.07.2020.



Date, 06.07.2020.

Recipients:

- Quality Director
- Technical director
- Head of Development, Standardization and Programming Service

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.

PROGRAM OF PROFINE FOILS FOR 2020. - DELIVERIES IN LK1-LK3 BLACK GASKETS									
Wood imitation and Uni colors	IR Reflex	Profile Color	Color Name	Similarity	Basic profile body - both sides foiled	System 76 / 76	K-VISION **		
Golden Oak	da	32	167	-	Oliv braun	LK1	LK3		
Nussbaum		52	167	-	Schwarzbraun	LK1	LK3		
Sagefl		24	167	-	Schwarzbraun	LK1	LK3		
Anthraxgrau		16	167	7016	Anthraxgrau	LK1	LK3		
Anthraxziti		UD	047	7016	Anthraxgrau	LK1	LK3		
Anthraxziti Uni Matt *		SG	083	7015	Anthraxgrau	LK1	LK3		
Schiefergrau glatt		GD	167	7039	Anthraxgrau	LK1	LK3		
Quarzgrau		92	167	7012	Anthraxgrau	LK1	LK3		
Basaltgrau		CQ	167	9001	Weiß	LK1***	LK3		
Cremeweiss		15	167	-	Schwarzbraun	LK3	LK3		
Eiche (dunkel) grau		21	167	7001	Weiß	LK3	LK3		
Grau	da	27	167	8022	Schwarzbraun	LK3	LK3		
Schneebraun		31	167	-	Schwarzbraun	LK3	LK3		
Braun Maron 8093		34	167	-	Schwarzbraun	LK3	LK3		
Eiche dunkel FL-F1		37	167	-	Schwarzbraun	LK3	LK3		
Eiche rustikal	da	38	167	-	Oliv braun	LK3	LK3		
Bergkeller	da	39	167	-	Oliv braun	LK3	LK3		
Oregon 4		42	167	-	Schwarzbraun	LK3	LK3		
Maicore		44	167	3005	Schwarzbraun	LK3	LK3		
Weinrot		46	167	3011	Schwarzbraun	LK3	LK3		
Dunkelrot 308 1		50	083	7004	Weiß	LK3	LK3		
Signalgrau glatt	da	53	167	6005	Schwarzbraun	LK3	LK3		
Moesgrün		58	167	6009	Schwarzbraun	LK3	LK3		
Dunkelgrün		76	167	-	Oliv braun	LK3	LK3		
Moerliche	da	78	167	-	Schwarzbraun	LK3	LK3		
Schwarzbraun		80	167	8022	Schwarzbraun	LK3	LK3		
Erntelila		85	167	6007	Weiß	LK3	LK3		
Stahlblau		88	167	5011	Schwarzbraun	LK3	LK3		
Black Cherry		90	167	-	Schwarzbraun	LK3	LK3		
Achgrau	da	93	167	7038	Weiß	LK3	LK3		
Lichtgrau	da	94	167	7035	Weiß	LK3	LK3		
Alux DB 703 *		AL	-	-	Anthraxgrau	LK3	LK3		
Metbrun Silver	da	AR	-	-	Weiß	LK3	LK3		
Achgrau glatt	da	GA	083	7038	Weiß	LK3	LK3		
Betongrau 7023	da	GE	167	7023	Anthraxgrau	LK3	LK3		
Irish Oak	da	IO	148	-	Oliv braun	LK3	LK3		
Metbrun Platin	da	MP	-	-	Weiß	LK3	LK3		
Metbrun Quarzgrau		MQ	-	-	Anthraxgrau	LK3	LK3		
Metbrun Anthrazitgrau		MT	-	-	Anthraxgrau	LK3	LK3		
Quarzgrau SFTN matt *		QB	-	7039	Anthraxgrau	LK3	LK3		
Rosa Cherry		RC	166	-	Oliv braun	LK3	LK3		
Siena PR 40827		SC	148	-	Schwarzbraun	LK3	LK3		
Schwarzgrau SFTN matt *		SM	-	7021	Anthraxgrau	LK3	LK3		
Black Uni Matt *		US	047	9011	Schwarzbraun	LK3	LK3		
Winchester XA 46830	da	WI	148	-	Oliv braun	LK3	LK3		
Weiß 9152		WX	168	9010	Weiß	LK3	LK3		

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Program folija PROFINE za 2020. _ isporuke LK1-LK3_ dihtung crni											
Imitacije drveta i uni boje	IR Reflex	profine Broj	Izvedba- struktura ili glat	Slično RAL-u	Osnovno tijelo obostrano folirano	System 76 AD/MD			K-VISION **		
						System 76 AD/MD	System 88 MD	PremiDor 76/88	PremiSlide 76	■ ■ ■	■ ■ ■
Eiche dunkel ST		71	167	-	Schwarzbraun	LK4	LK4	LK4	LK4	LK4	LK4
Bergeiche	da	74	167	-	Olivbraun	LK4	LK4	LK4	LK4	LK4	LK4
Kobalblau 5013		87	167	5013	Weiß	LK4	LK4	LK4	LK4	LK4	LK4
Anthrazitgrau STYLO		AA	-	7016	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
AntEAK		AN	-	-	Weiß	LK4	LK4	LK4	LK4	LK4	LK4
Anthrazitgrau SFTN matt *		AU	-	7016	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Basaltgrau SFTN *		BD	-	7012	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Basaltgrau SFTN matt *		BQ	-	7012	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Cherry amaretto		CA	-	-	Olivbraun	LK4	LK4	LK4	LK4	LK4	LK4
Cherry Blossom		CB	195	-	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Gale Grey Finesse 49122 *		GY	013	7016	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Hazy Grey Finesse 49124 *	da	HZ	013	7001	Weiß	LK4	LK4	LK4	LK4	LK4	LK4
Quarzgrau SFTN *		QA	-	7039	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Quarz Platin		QP	-	-	Schwarzbraun	LK4	LK4	LK4	LK4	LK4	LK4
Schwarzgrau SFTN *		SE	-	7021	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Schwarzbraun SFTN matt *		SF	-	8022	Schwarzbraun	LK4	LK4	LK4	LK4	LK4	LK4
Slate Grey Finesse 49229 *		SL	013	7015	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Siena PN 46828		SN	148	-	Schwarzbraun	LK4	LK4	LK4	LK4	LK4	LK4
Umbragrau glatt		UG	083	7022	Anthrazitgrau	LK4	LK4	LK4	LK4	LK4	LK4
Winchester XC 46843		WC	148	-	Schwarzbraun	LK4	LK4	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 upitu zarok i cijenu											
* Profili se biti isporučeni sa bijelom zaštitnom folijom bez natpisa.											
** K-VISION - Jednostrano ili obostrano foliranje ovisi o izboru na bijeloj ili krem podlozi sa crnim dihtungima.											
*** Osnovno tijelo "CC": Rok isporuke od LK3; Izuzima se: CCPC i 16CC u 76AD, K-VISION i PremiDor76											
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. Osnov no tijelo jednostrano folirano vani - bijelo -K-Vision osnov no tijelo bijelo ili krem. Osnov no tijelo obostrano folirano - vidi tabelu ; K-Vision osnovno tijelo bijelo ili krem. Opcija foliranja na drugim osnovnim tijelima isporučivo u LK4 Opcija foliranja na drugim osnovnim tijelima isporučivo u LK4 ■ ■ ■ = Obostrano folirano											

PROGRAM OF PROFINE FOILS FOR 2020. - DELIVERIES IN LK1-LK3 BLACK GASKETS									
Wood imitation and Uni colors	IR Reflex	Profile Color no.	Color type area / MAT	Smaller y is BAL	Basic profile body - both side foiled	System 78 AD / MD			
						System 88 MD		PremiDoor 78 / 88	
						■	■	■	■
K-VISION **						PremiSide 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
Antrazitgrau STYLO		AA	-	7016	Antrazitgrau	LK4	LK4	LK4	LK4
AnTEAK		AN	-	-	Weiß	LK4	LK4	LK4	LK4
Antrazitgrau SFTN matt *		AU	-	7016	Antrazitgrau	LK4	LK4	LK4	LK4
Basaltgrau SFTN *		BD	-	7012	Antrazitgrau	LK4	LK4	LK4	LK4
Basaltgrau SFTN matt *		BQ	-	7012	Antrazitgrau	LK4	LK4	LK4	LK4
Cherry amarelo		CA	-	-	Olivbraun	LK4	LK4	LK4	LK4
Cherry Blossom		CB	195	-	Olivbraun	LK4	LK4	LK4	LK4
Gale Grey Finesse 49122 *		GY	013	7016	Antrazitgrau	LK4	LK4	LK4	LK4
Hazy Grey Finesse 49124 *	da	HZ	013	7001	Weiß	LK4	LK4	LK4	LK4
Quarzgrau SFTN *		QA	-	7039	Antrazitgrau	LK4	LK4	LK4	LK4
Quarz Platin		QP	-	-	Schwarzbraun	LK4	LK4	LK4	LK4
Schwarzgrau SFTN *		SE	-	7021	Antrazitgrau	LK4	LK4	LK4	LK4
Schwarzbraun SFTN matt *		SF	-	8022	Schwarzbraun	LK4	LK4	LK4	LK4
Slate Grey Finesse 49229 *		SL	013	7015	Antrazitgrau	LK4	LK4	LK4	LK4
Siena PN 46828		SN	148	-	Schwarzbraun	LK4	LK4	LK4	LK4
Umbragrau glatt		UG	083	7022	Antrazitgrau	LK4	LK4	LK4	LK4
Winchester XC 46843		WC	148	-	Schwarzbraun	LK4	LK4	LK4	LK4

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

*** Basic profile body "CC": Delivery period for LK3, Excluding: COCC and SECC in 78AD, K-VISION AND PREMIEDOOR 76

* 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 SECC in 78AD, K-VISION AND PREMIEDOOR 76

LK1 Wood imitation = One side or both sides foiled
LK1 Uni 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 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
■ = one side foiled outside
■ = one side foiled outside
■ = 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).
Antrazitgrau, Dark brown Order 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

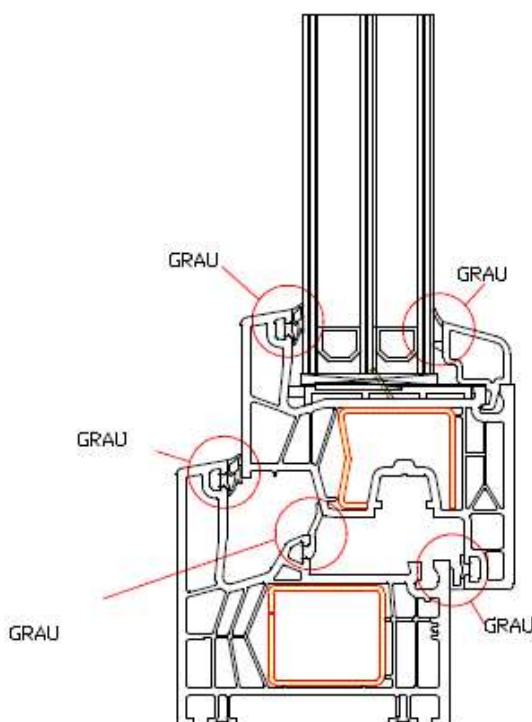
No.	Color of foil Outside	C of foil Inside	Outside color of the parts (water caps ,stulp caps,...)	Inside color of the parts (water caps ,stulp caps,...)
308	Quarzgrau	Quarzgrau	7039	grey
309	Dunkelgrün	Dunkelgrün	6009	grey
310	Cremeweiß DECOR	Cremeweiß DECOR	cream	cream
311	Eiche dunkel_15	Eiche dunkel_15	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	Tannengrün	weiss	6009	white
909	Zwartblau	weiss	5004	white
913	Lichtivör	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:

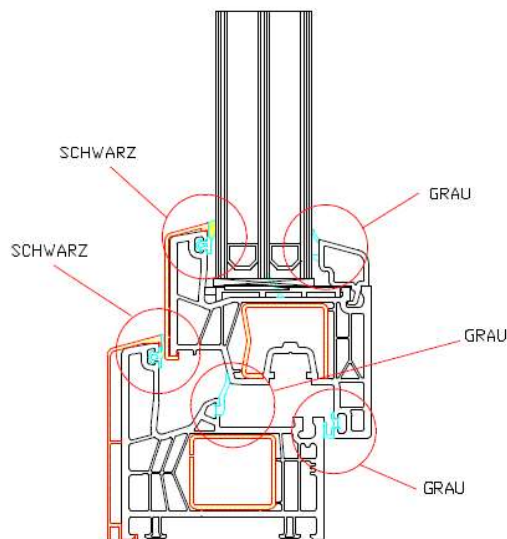
PVC profile series **76AD, 76MD, 88MD,**

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

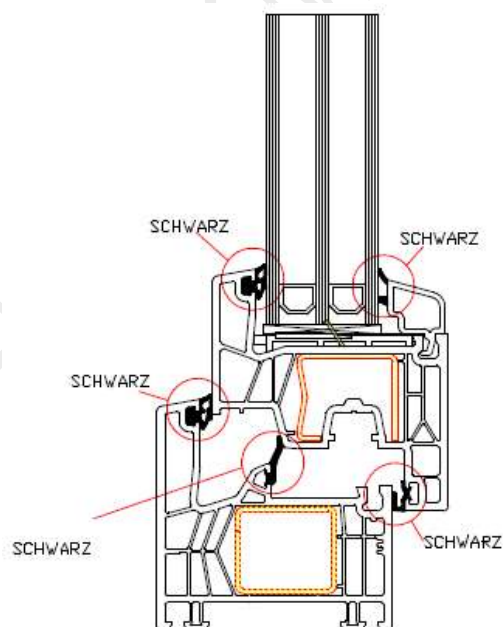


Picture 1.

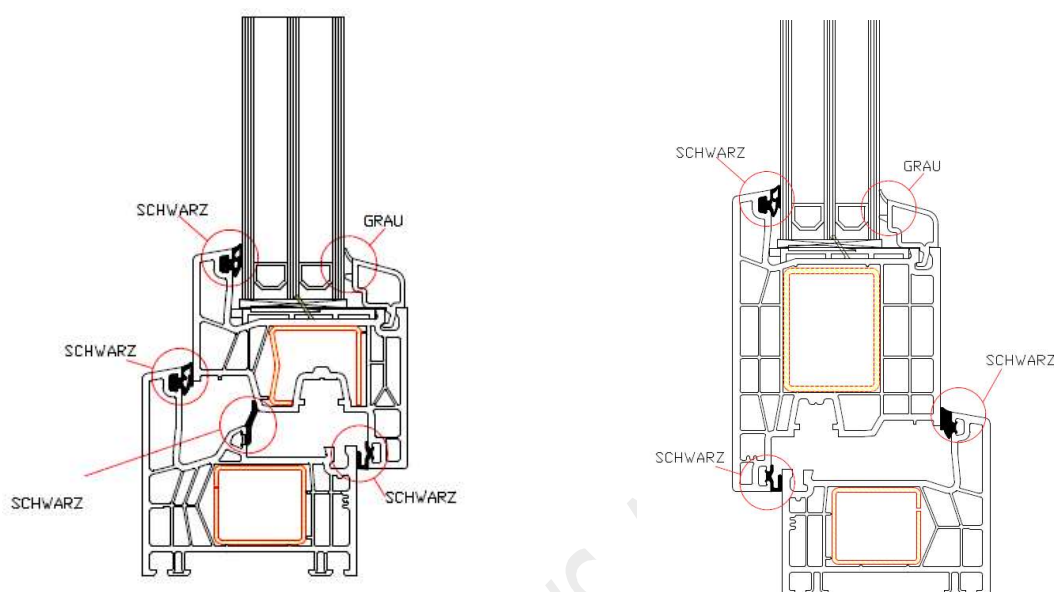
- If the PVC profile is white with ALU cover profile, regardless of the color of the ALU cover profile, all gaskets are gray (GRAU) except for the gasket in the part of the ALU cover profile which is black (SCHWARZ) (Picture. 2)



- 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 molding 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 molding 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 molding on the inside of the position.

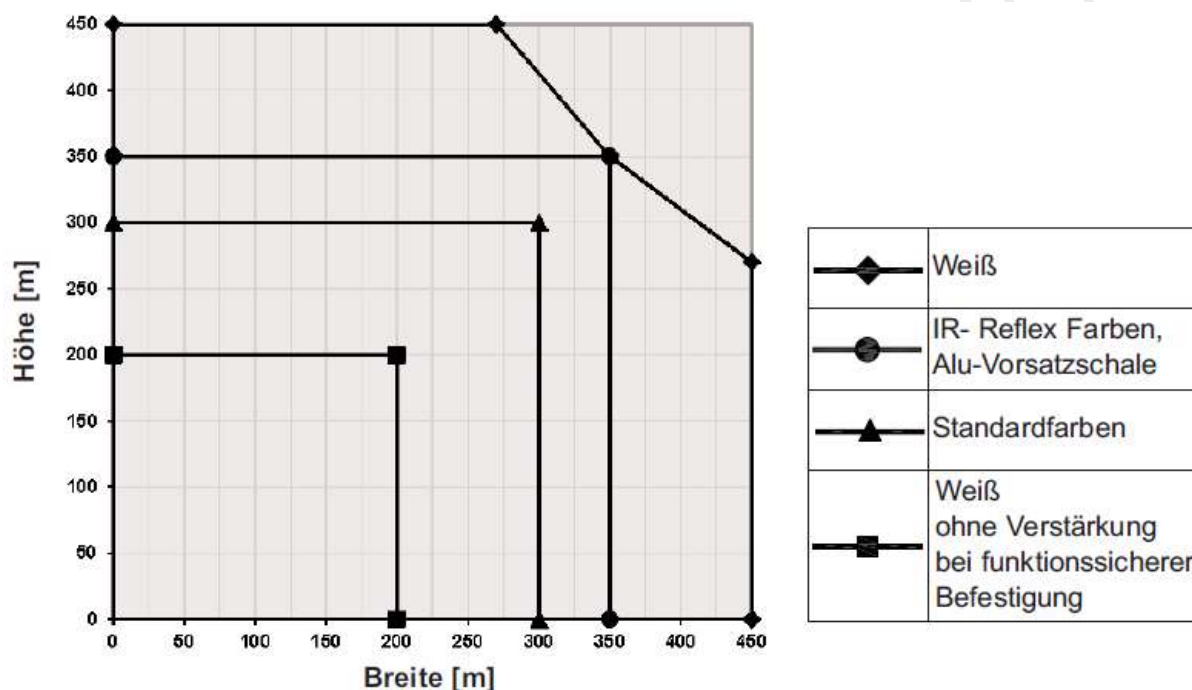
PVC profile series **K-vision 76**

- 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.

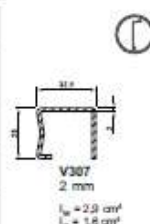
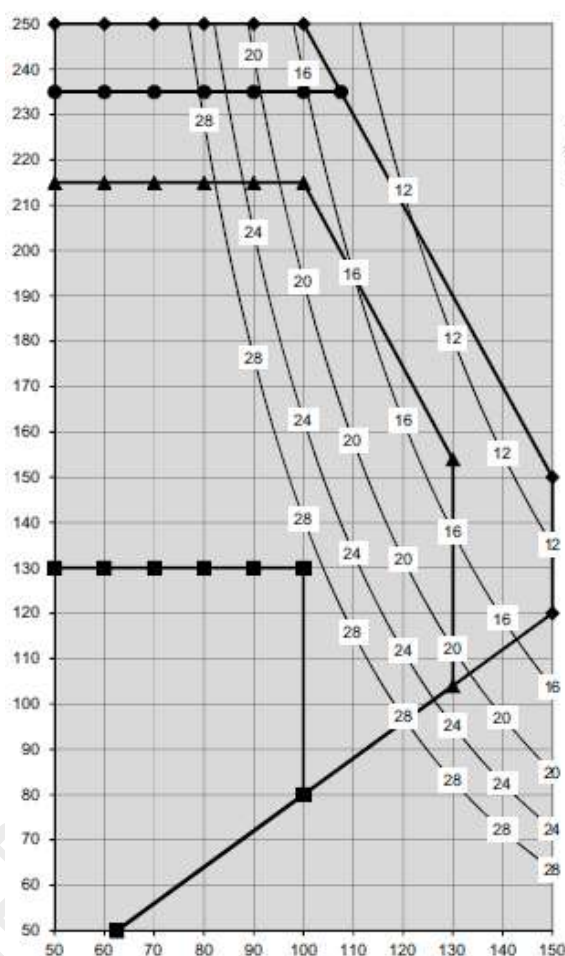
Aluminum cover profile can be made as large as “IR-Reflex paints”.

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

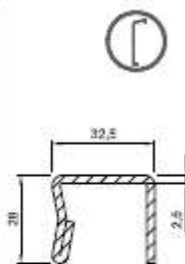
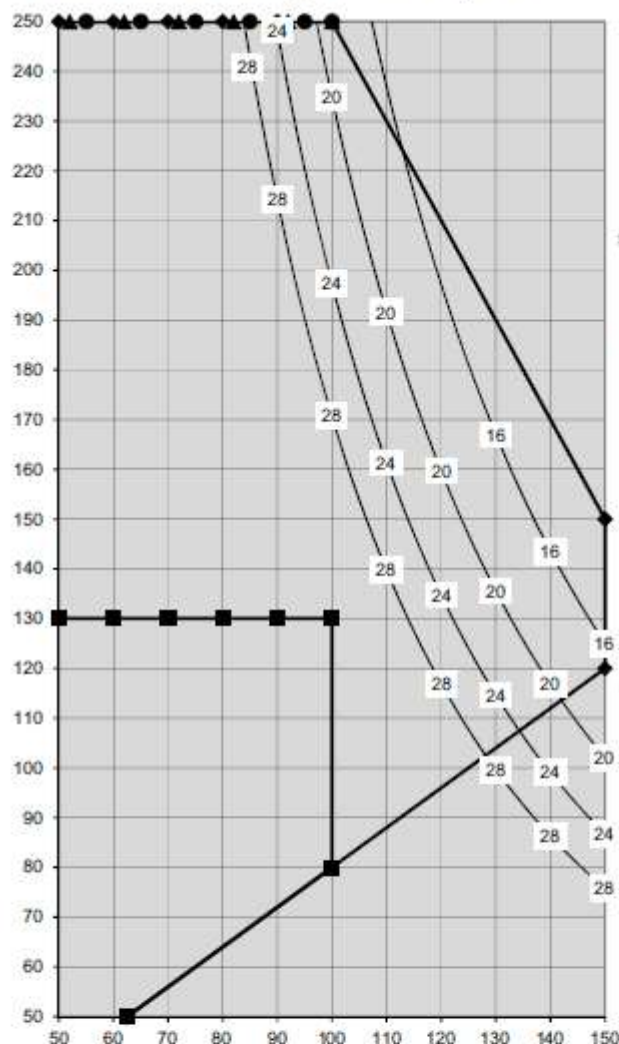
Neu



- ◆— 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

V500

Neuer Stahl! Verwendung in Profilen analog V308



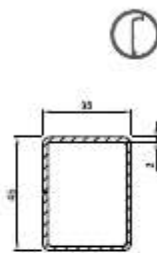
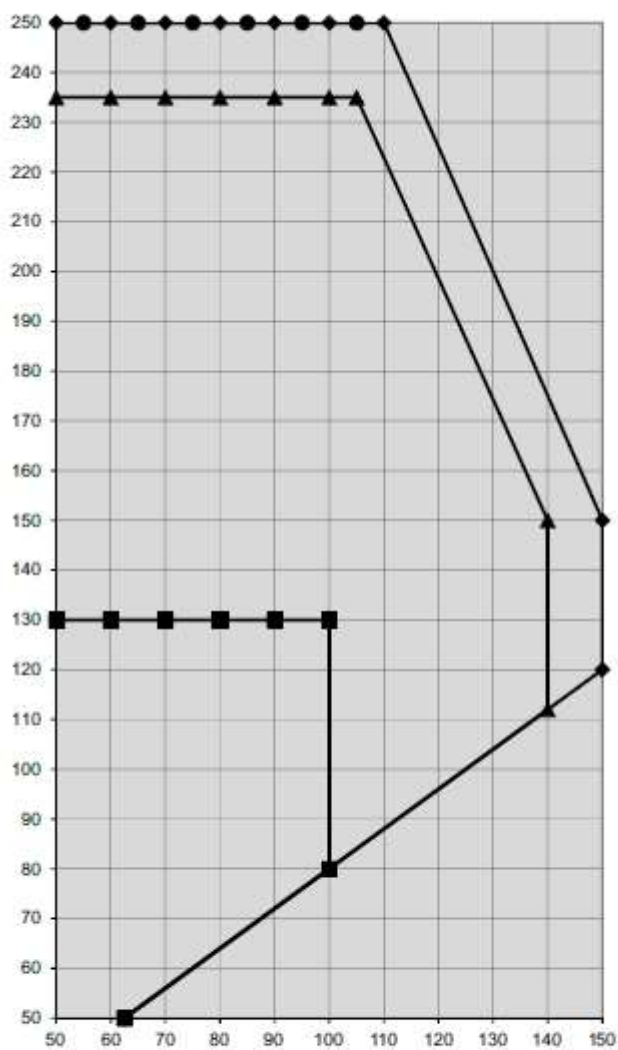
V500
2,5 mm

$I_w = 3,7 \text{ cm}^4$
 $I_G = 2,0 \text{ cm}^4$

- ◆— 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

V314

Neu

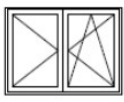
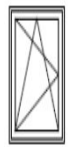
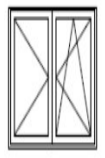
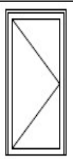


V314
2 mm
l_W = 5,7 cm²
l_D = 8,4 cm²

- ◆— Weiß
- IR- Reflex Farben, Alu-Vorsatzschale
- ▲— Standardfarben
- Weiß ohne Verstärkung

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)

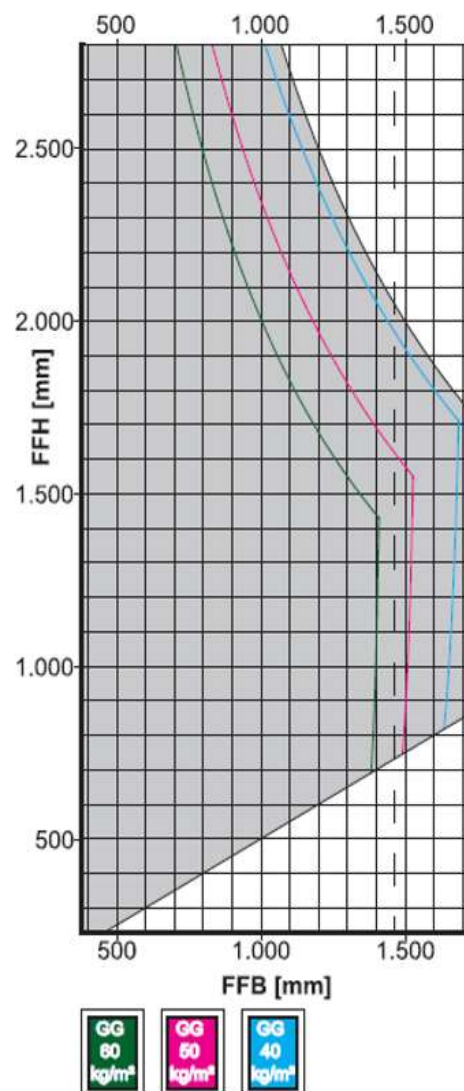
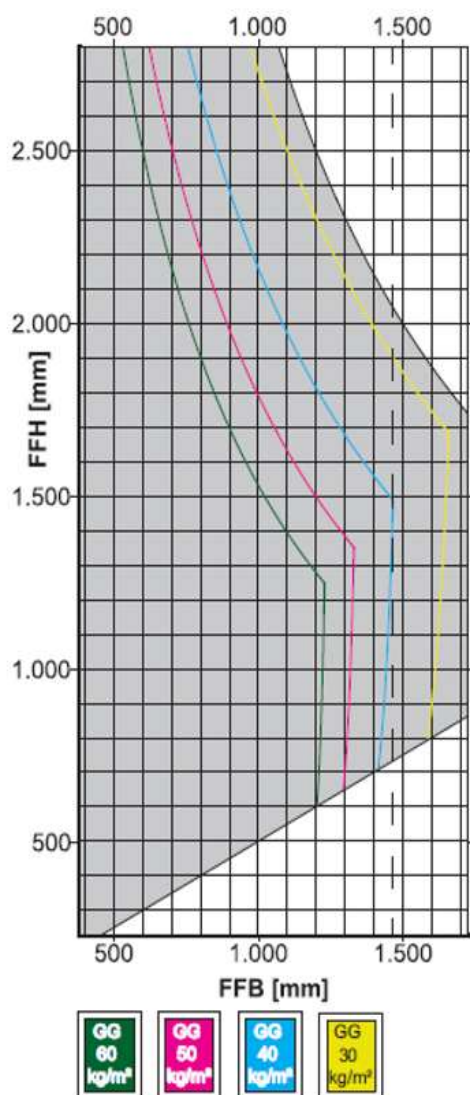


Diagram of load capacity up to 100kg

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

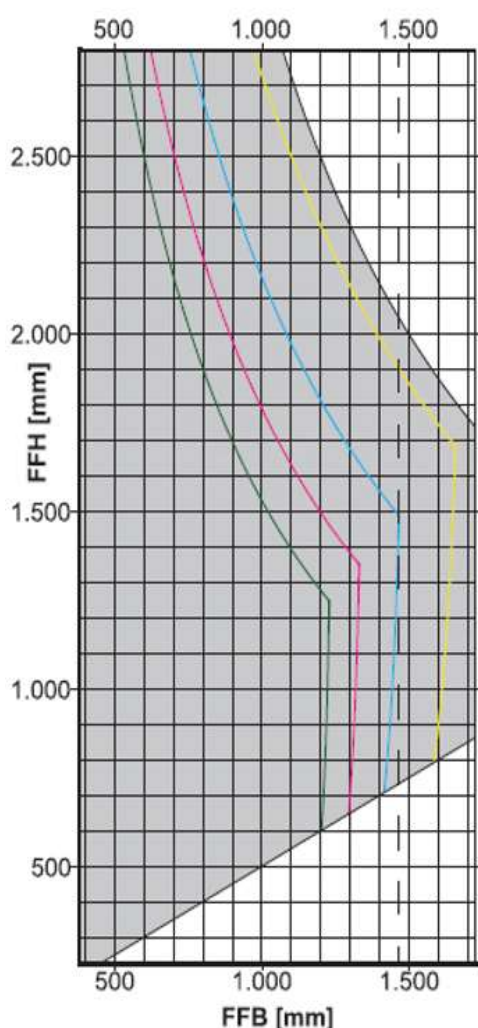
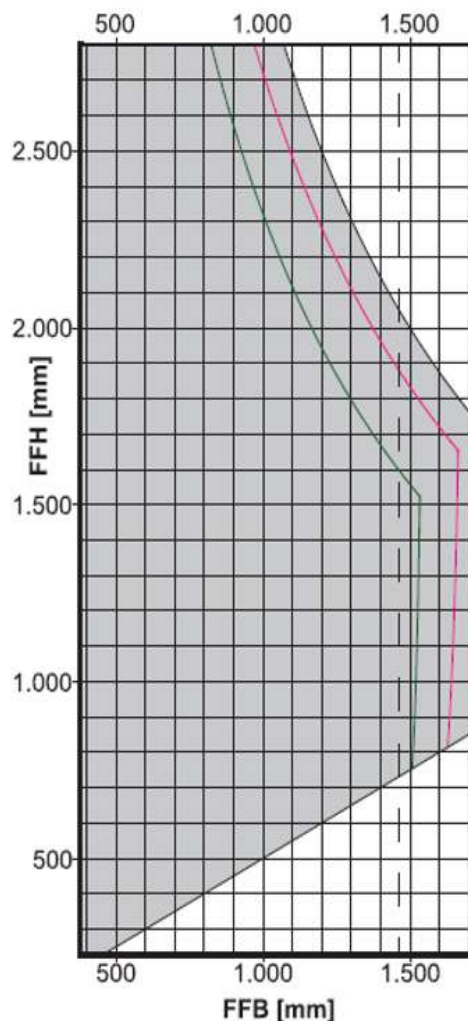


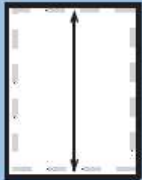
Diagram of load capacity up to 150kg



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

All measurements refer to the wing fold.

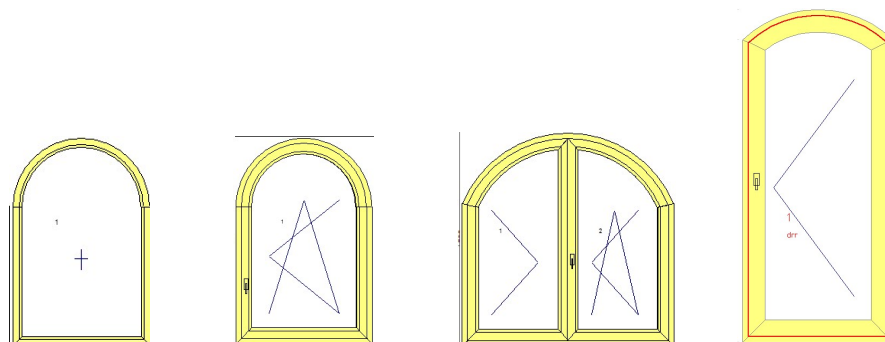
Example: For a window whose height per fold is $FFH = 950\text{mm}$, a handle of the window would be installed as standard at 375mm from the lower edge of the sash per fold.



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.



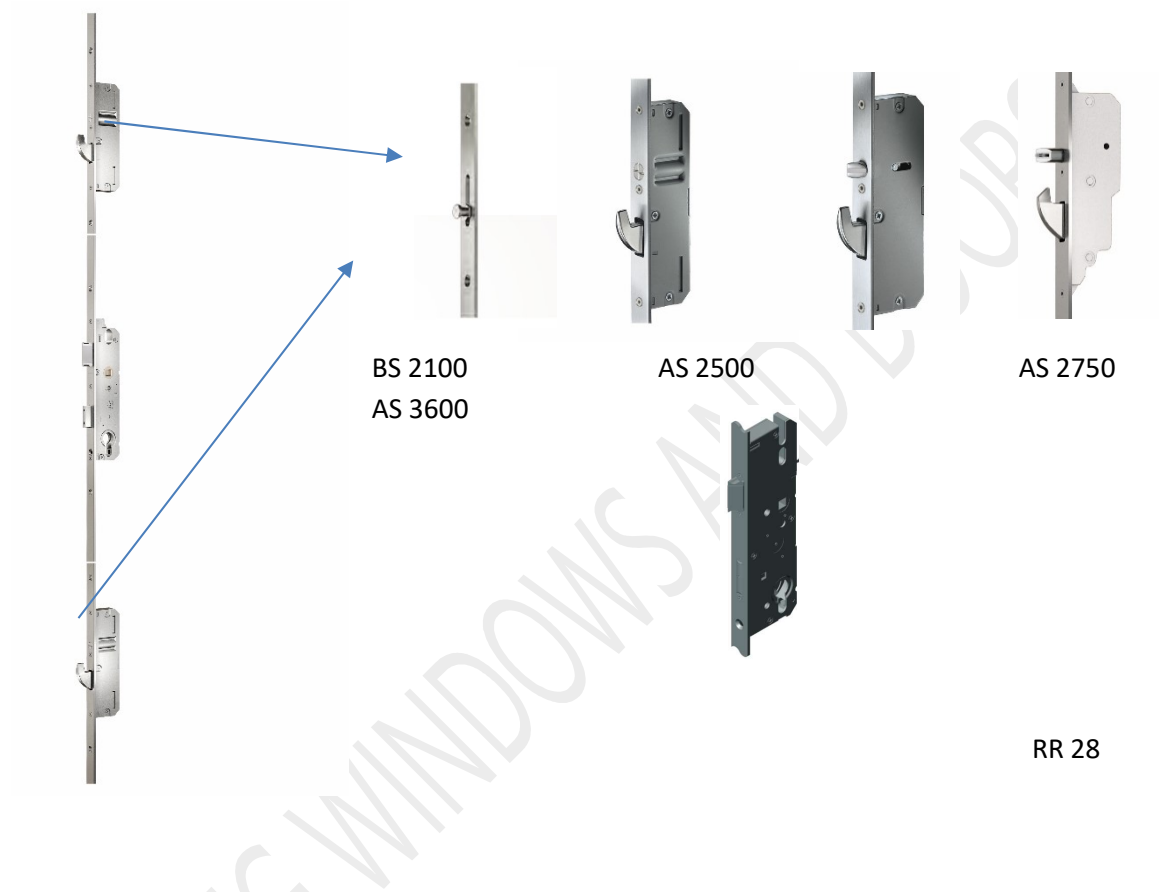
The minimum width of the position arc is calculated as: **profile face width (mm) x 10**

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.

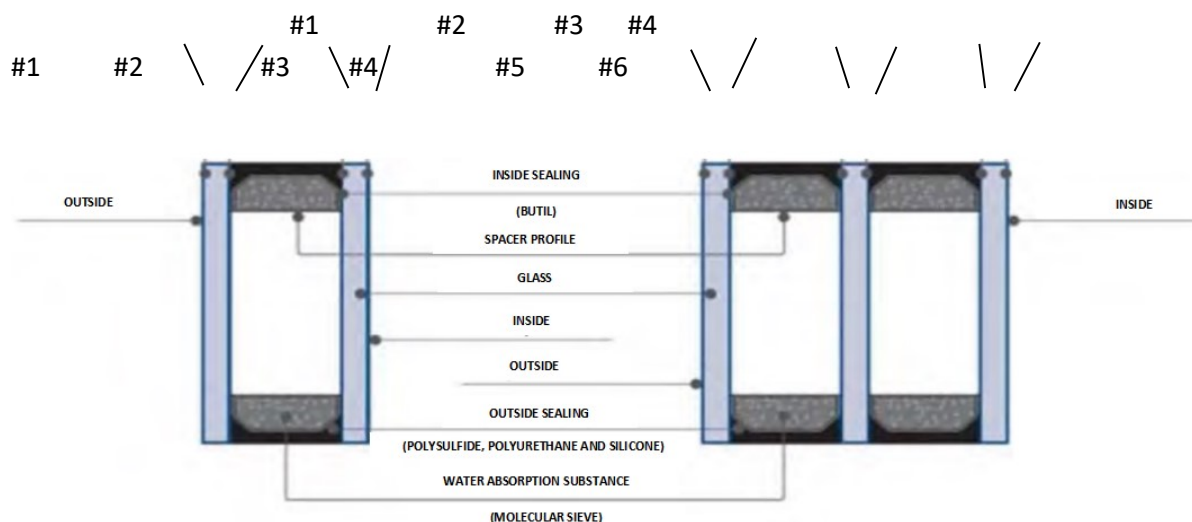


Lock	Security elements	No. Of locking places	Mechanical and electrical opener	Motor propulsion	KABA cylinder
RR 28		1	*		
BS 2100	mushroom	1+4	*		
AS 2500	hooks	1+2	Yes		
AS 2750	hooks i bolcne	1+2	*		Yes
AS 3600	hooks i wedge	1+2	*	Yes	Yes

(* 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 molding 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

4.3 TIMBER AND TIMBER-ALUMINIUM SYSTEMS

4.3.1 Raw Materials – Timber Selection

We believe that high-quality joinery starts with high-quality raw materials. At Herceg Wood, we use only proven timber species, selected to meet different customer requirements and climatic conditions.

Wood species	Characteristics and applications
Spruce	Lightweight timber with excellent thermal insulation, ideal for classic window designs.
Fir	Uniform structure and lower resin content; suitable for light translucent stain tones.
Oak	Exceptionally strong and durable, with a distinctive grain. Used for prestigious entrance doors and premium windows.
Pine	Resin-rich timber with natural resistance to moisture; a popular choice for rustic designs.
Meranti	An exotic reddish timber species, dimensionally stable and weather-resistant, often used for the Benelux markets.
Larch	Highly resistant to weathering and decay; often used for exterior elements with less need for intensive chemical protection.
Note: In addition to the standard species listed above, production in other species is available on request (e.g. ash, teak, mahogany).	

4.3.2 Grades of Laminated Timber Scantlings

To ensure profile stability and prevent warping, we use laminated timber scantlings in the following quality grades:

DKD (Highest Quality): Premium grade. Knot-free and free from visible defects. Used for surfaces finished with transparent wood stains.

KKK (Standard Quality): Standard grade. Small, sound knots are permitted. The standard choice for most windows and doors.

DDK (Timber-Aluminium Quality): Specifically intended for **timber-aluminium** profiles. Minor surface imperfections are permitted because the timber is protected by aluminium cladding.

4.3.3 Surface Finishing (Coating and Protection)

Proper surface finishing is essential for the long service life of windows and doors. At Herceg Wood, we offer three protection systems:

a) Translucent wood stains (transparent coatings)

Effect: Enhances the natural grain and texture of the timber.

Process: 4-layer system (Impregnation -> Primer -> Topcoat 1 -> Topcoat 2).

Colour charts: Two predefined colour charts are available (on **spruce** and **meranti**), while colour matching to a customer sample is also possible.

Spruce



Meranti



b) Opaque coatings (RAL)

Effect: Completely covers the natural colour of the timber.

Process: Also a 4-layer system (same principle as for translucent stains).

Colours: Any RAL shade. Semi-matt finish, 30% gloss.



c) Hybrid oil

Effect: Natural appearance, matt finish; the product “breathes”.

Process: 3 coats (Impregnation + 2 oil coats).

Note: This finish provides a more natural appearance, but comes with a **reduced warranty** compared with standard coating systems.

4.3.4 Product Range and Systems (Klaes Codes)

We offer three profile depths (**68 mm, 78 mm, 90 mm**) to meet different thermal insulation and structural requirements. Below is a detailed overview of all systems we manufacture, including the most complex variants.

<i>Klaes code</i>	<i>System description</i>	<i>Product type</i>	<i>Material</i>
WINDOW SYSTEMS			
B68 / B78	Timber Belgium (Classic/Rustic)	Window	Timber
H68 / H78	Timber Netherlands (Classic)	Window	Timber

H68R / H78R	Timber Netherlands + BUVA aluminium strip	Window	Timber
D78C / D90C	Classic, non-continuous drip rail (with end caps)	Window	Timber
D78C_X / D90C_X	Classic, continuous NP702 drip rail	Window	Timber
D78C_CH / D90C_CH	Classic, Swiss-type drip rail	Window	Timber
DA78C / DA90C	Timber-Aluminium Classic	Window	Timber-Alumi nium
DA78F / DA90F	Timber-Aluminium Flat (straight-line design)	Window	Timber-Alumi nium
DACH78F / DACH90F DACH78C / DACH90C	Timber-Aluminium CH (Swiss systems – Flat/Flat, Flat/Classic)	Window	
ENTRANCE DOORS			
DV68C / DV78C / DV90C	Timber Classic	Entrance door	Timber
DV78F / DV90F	Timber Flat	Entrance door	Timber
DAV78F / DAV90F	Timber-Aluminium Flat	Entrance door	Timber-Alumi nium
LIFT-AND-SLIDE SYSTEMS			
DHS68 / DHS78 / DHS90	Timber lift-and-slide (HS)	Lift-and-slide door	Timber
DAHS78 / DAHS90	Timber-Aluminium HS	Lift-and-slide door	Timber-Alumi nium
DAHSP78 / DAHSP90	Timber-Aluminium Panorama HS	Lift-and-slide door (Panorama)	Timber-Alumi nium

4.3.5 Arched Profiles – Architectural Freedom

In addition to standard rectangular windows and doors, our department specialises in manufacturing **arched and angled profiles**. These elements add architectural value to the building and provide complete design freedom.

Depending on the hardware system (Winkhaus, etc.) and the dimensions, we manufacture the following arch shapes:

Types of arches we manufacture:

1. **Full Arch (True Arch / Radius Arch):** A classic semicircular shape. Ideal above entrance doors or as a decorative window (also known as a lunette).
2. **Segmental Arch:** A shallow arch with a rise of less than a semicircle. Used where ceiling height is limited or in wide window compositions.
3. **Elliptical Arch:** An oval-shaped arch that gives the façade a distinctive, elegant appearance.
4. **Compound / Gothic Arches:** Arches formed from **multiple radii** (e.g. an “ogee” arch – a combination of two S-curves). These are among our most demanding products and require exceptional manufacturing precision.
5. (Note: The feasibility of individual arch types depends on the dimensions and the limitations specified by the hardware manufacturer.)

4.3.6 Hardware and Certifications

High-quality joinery requires premium hardware and verified performance.

Hardware application:

Windows: Winkhaus hardware, Goll gaskets, GU thresholds, Herceg Feal aluminium cladding, Autera components.

Doors: KfV locks, GU hinges and thresholds, Goll gaskets.

Lift-and-slide doors: Siegenia hardware, Goll gaskets, GU thresholds.

Certifications and testing:

Physical performance: **Resistance to wind load, watertightness and air permeability** have been tested for all window systems and timber-aluminium lift-and-slide systems (Panorama 78/90).

Security: Tested **burglar resistance – RC2 class** for window systems (enhanced security).

Thermal performance: Thermal transmittance (U-values) has been tested for selected window system types.

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:

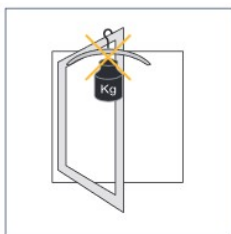
- visual assessment of frame material
- quality assessment of insulating glass
- installation and control of sun protection elements on the window
- performance characteristics of the elements in the installed state
- installation and inspection criteria
- definition of the label for quality and certification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

6. Standard of mounting and using the product

6.1 RESPONSIBILITIES AND WARNINGS

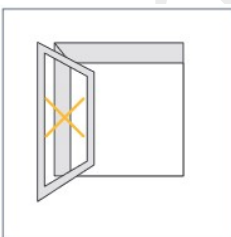
6.1.1 Odgovornosti i upozorenja za prozore

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.



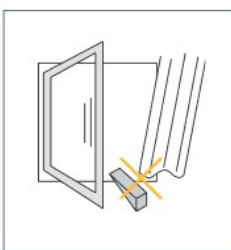
The window sash must not be additionally loaded

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



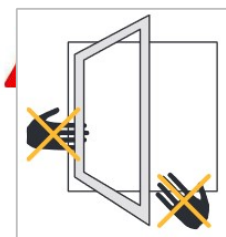
The sash wing must not extend beyond the fittings

- 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. !!



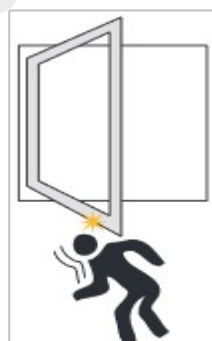
Danger of trapping body parts when closing

- 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.

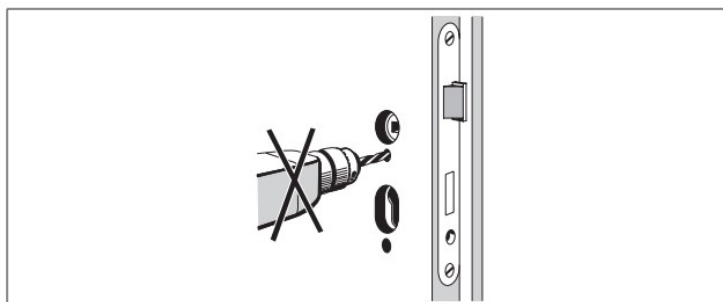


Protective folis must be removed

- 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.

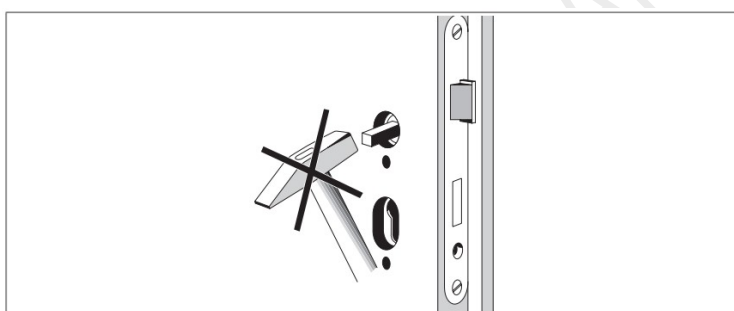
6.1.2 Responsibilities and warnings for doors

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

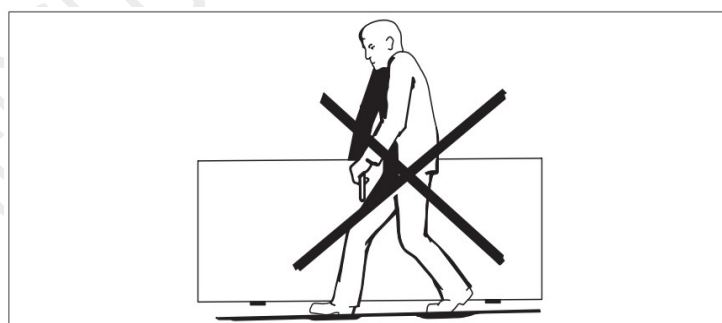


Do not drill the door leaf in the lock box area.

- If the door leaf is drilled in the area of the lock box, the main lock as well as the multi-part lock may be damaged.

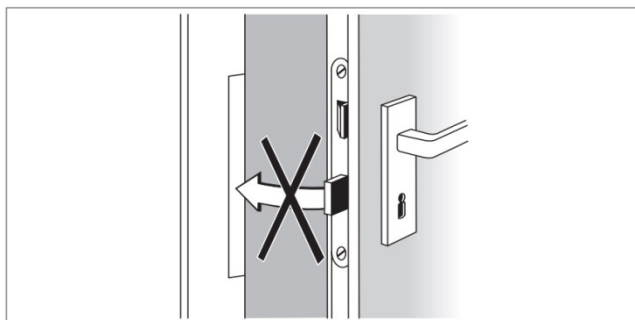


Do not strike the square awl with a tool (eg. hammer) by applying great force through the nut.



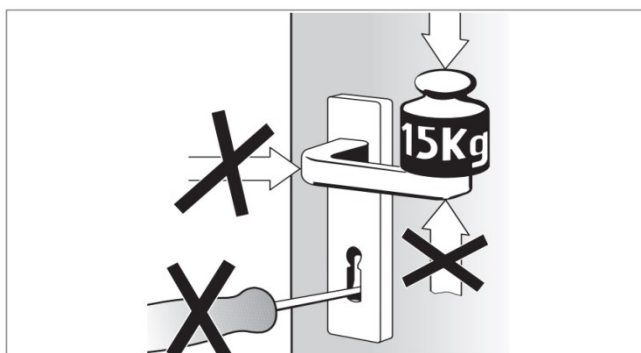
Use suitable aids when carrying the wings.

- If the door wing is held by the handle during transport, the shutter may be damaged.



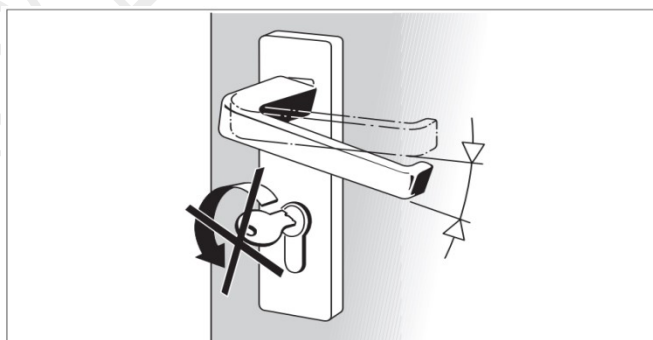
Place the locking elements when the door is open in the unlocked position .

- If the locking elements are in the locked position when the door is open, the shutter may be damaged.



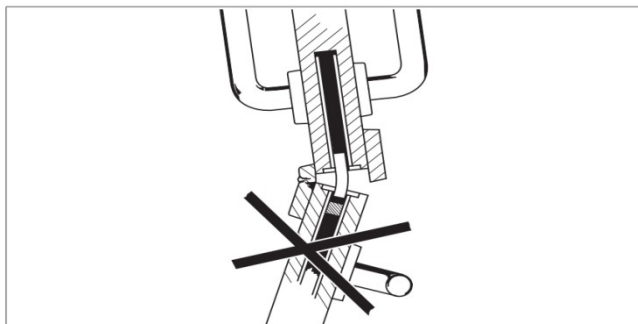
Load the handle only by turning it normally. Do not apply more than 150 N in the direction of activation. Lock the lock or the multiple lock only with the corresponding key .

- If the handle is not loaded by normal rotation and if a force in the direction of activation greater than 150 N is applied to the handle and the lock is activated by foreign objects, the shutter may be damaged.



Do not press the handle and key at the same time.

- If the handle and key are activated at the same time, the main lock may be damaged.



7) Do not forcibly open the double doors via the second wing.

HERCEG WINDOWS AND DOORS

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 film from the window, the following must first be checked before installation:

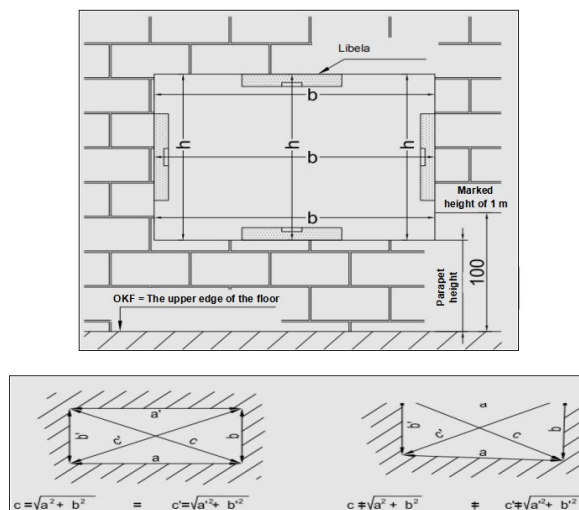
- Checking the dimensions of the windows (DIN 18201¹)
- Are all the windows properly delivered ? (DIN 18201)
- Is the appropriate window located at the intended installation site? (DIN18201) - Whether the window can be installed in an existing hole or must be done finishing (DIN 18202²)
- Have the agreed tolerances been respected? (DIN 18203³)
- Did the client accept parts of the building? (DIN 18203)
- Is the minimum joint width observed?
- Is there a place to place a load-bearing and space bars?
- Is the window in the horizontal and vertical position in the same plane?



NOTE:

UNLESS THE MINIMUM WIDTH OF THE JOINT 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

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

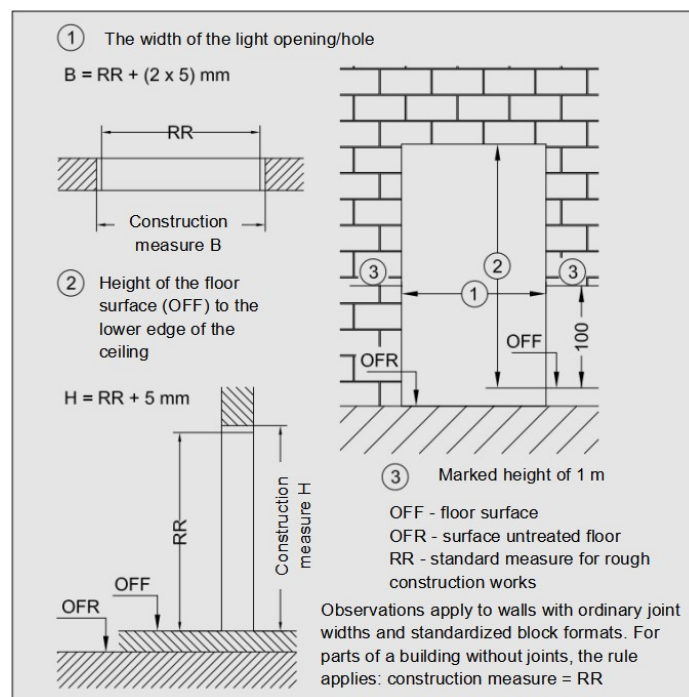
2 DIN 18202 Tolerances in building construction

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

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.

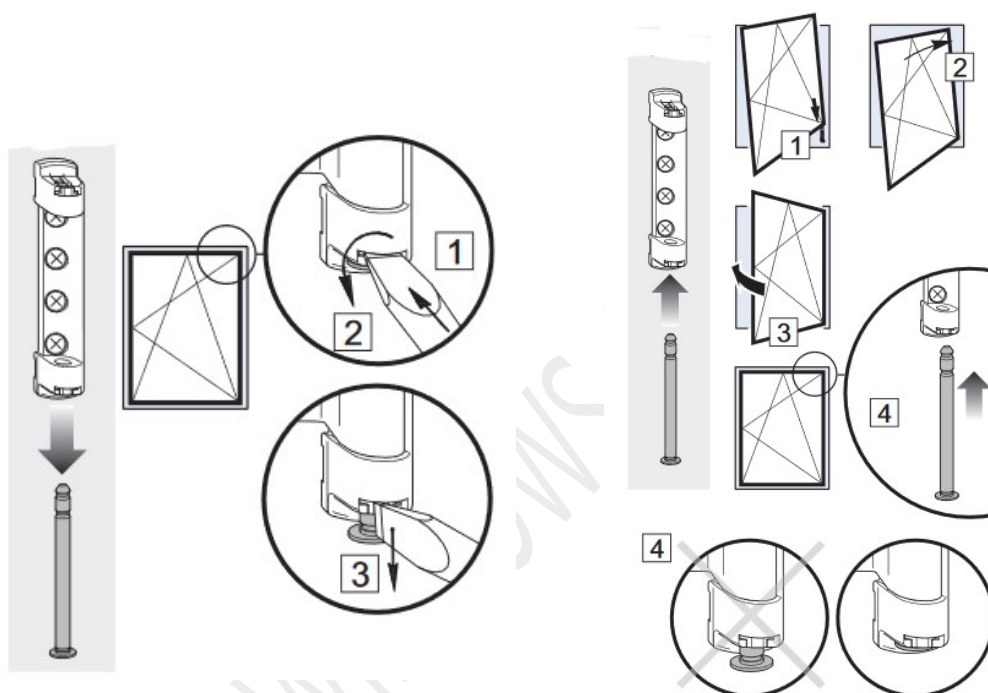


Picture 2. Essential measures for assembly preparation

6.3.1 Demounting of PVC window sash

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

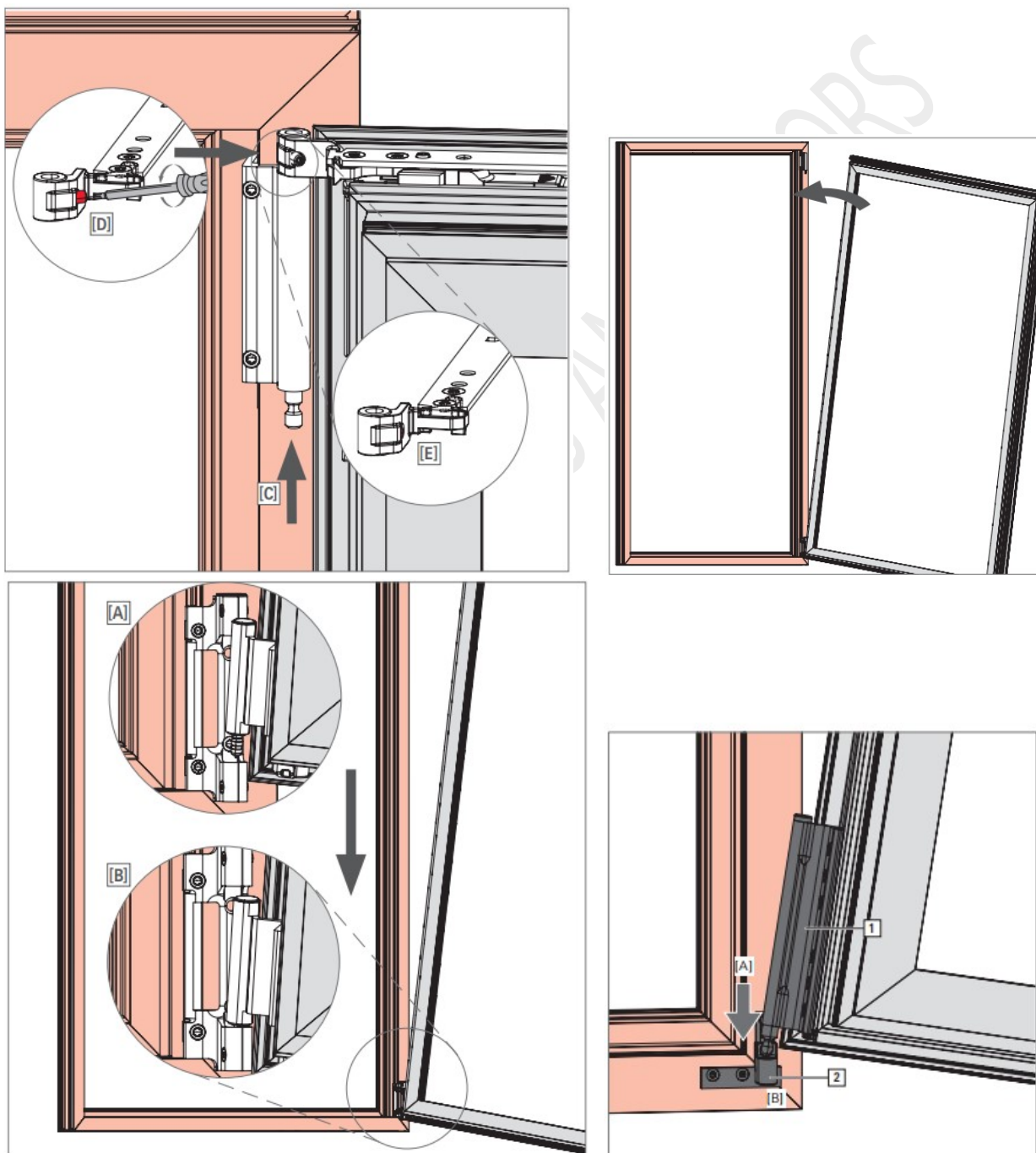
In the case of PVC windows, it is necessary to open the window and turn the handle to the closed position. When the wing is closed, pull the wedge down. Then open the wing carefully. Then wing has already been removed from the upper hinge. After that lift the sash up, tilt it and separate it from the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



Picture 3. Instruction for mounting and demounting of PVC wing

6.3.2 Demounting of ALU window wing

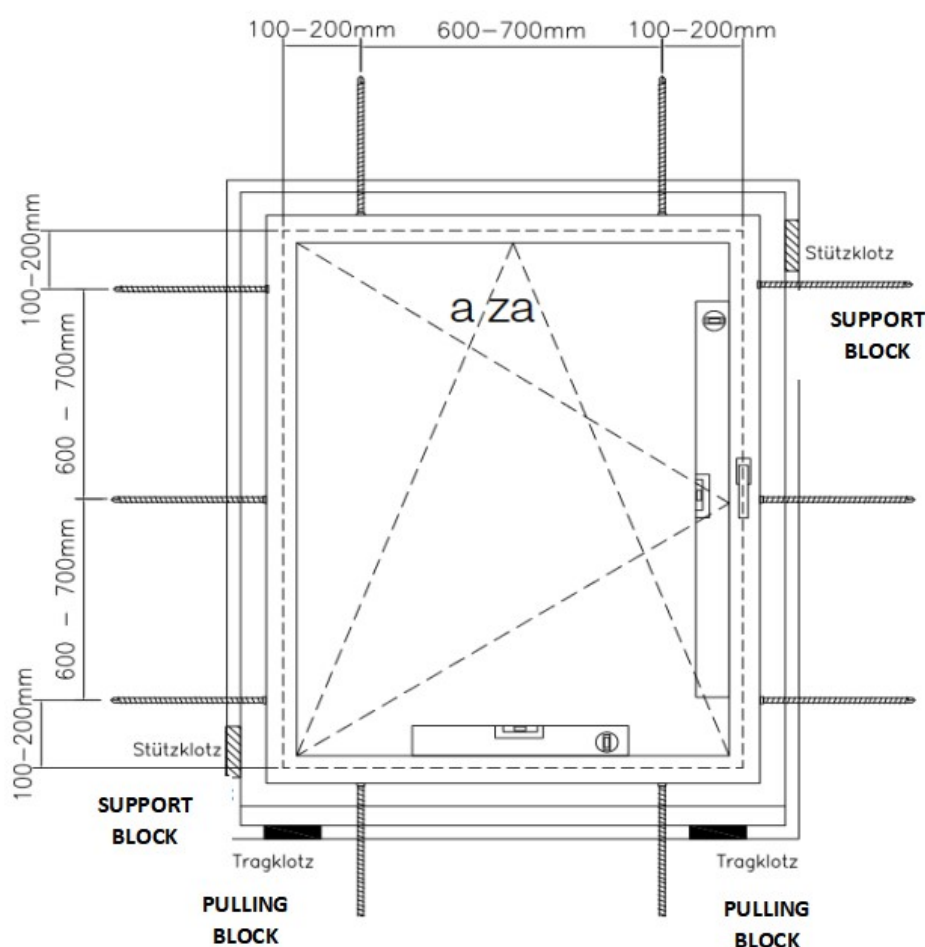
In the case of ALU window it is necessary to close the window and turn the handle in rotating position. After loosening the screw from the bearing, pull the pin down. Open the wing. The wing has already removed from the upper hinge bearing. After that lift the wing up and separate it from the outer frame.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



Picture 4. Instruction for demounting of ALU window

6.3.3 Mounting of window wing

Instal the outer frame into the hole in the wall. Outerframe is placed in a masonry opening and fixed with wooden wedges, and it must 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!

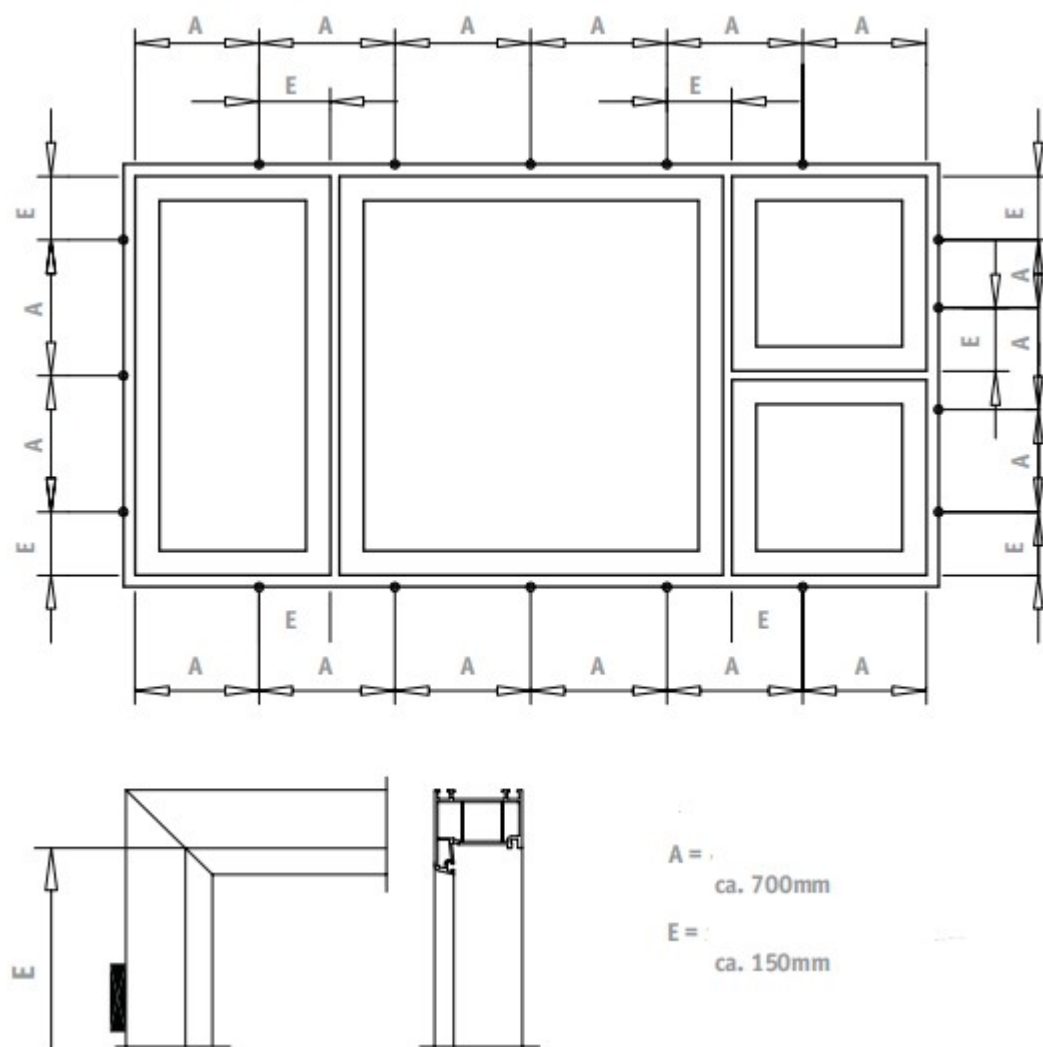


Picture 5. Arrangement of places provided for attaching the frame

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*

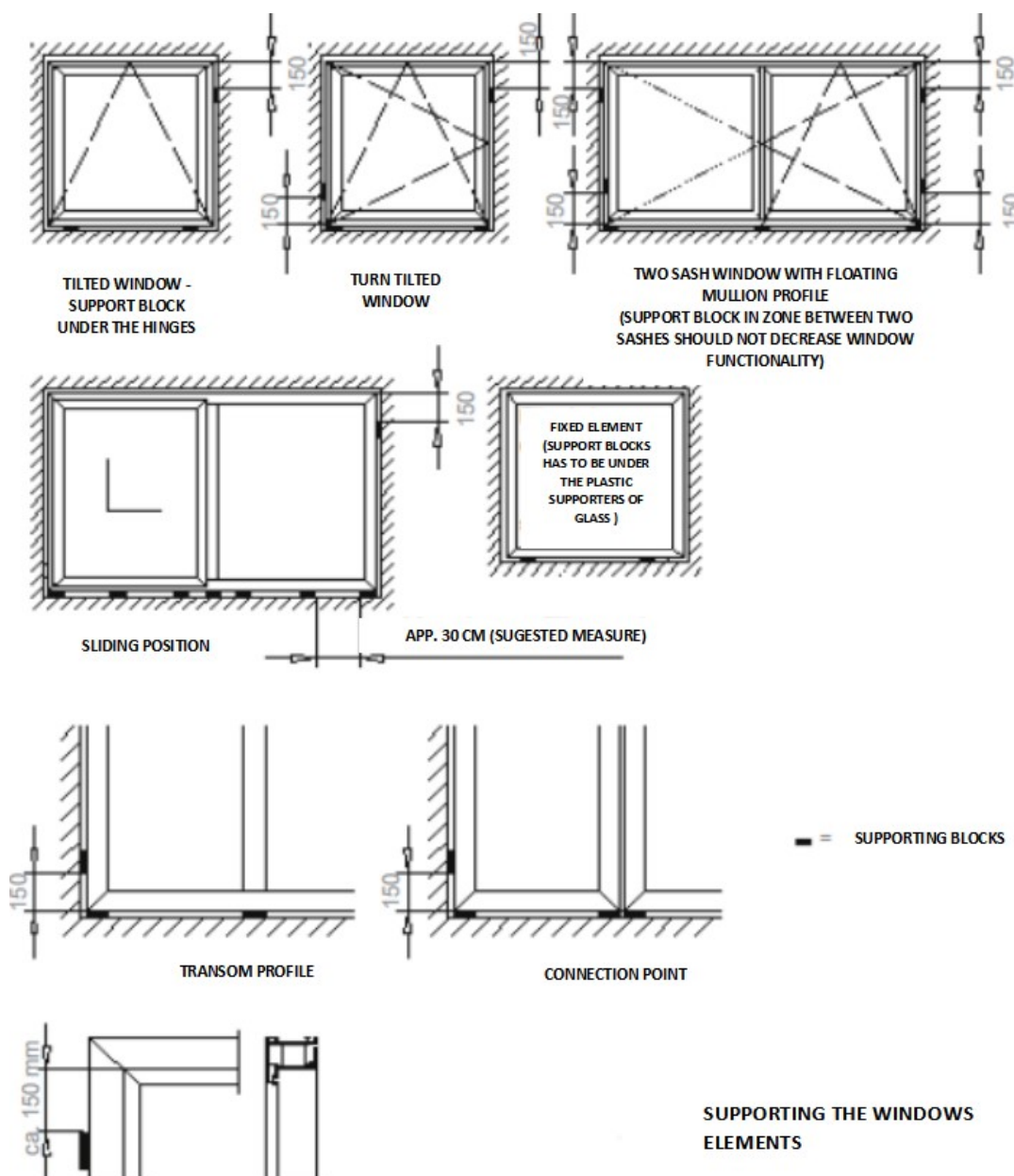
After mounting the frame it is necessary to return the sash to the frame. The wing install on the lower hinge and then attaches to the upper hinge returning the wedge to the bearing.

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

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

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

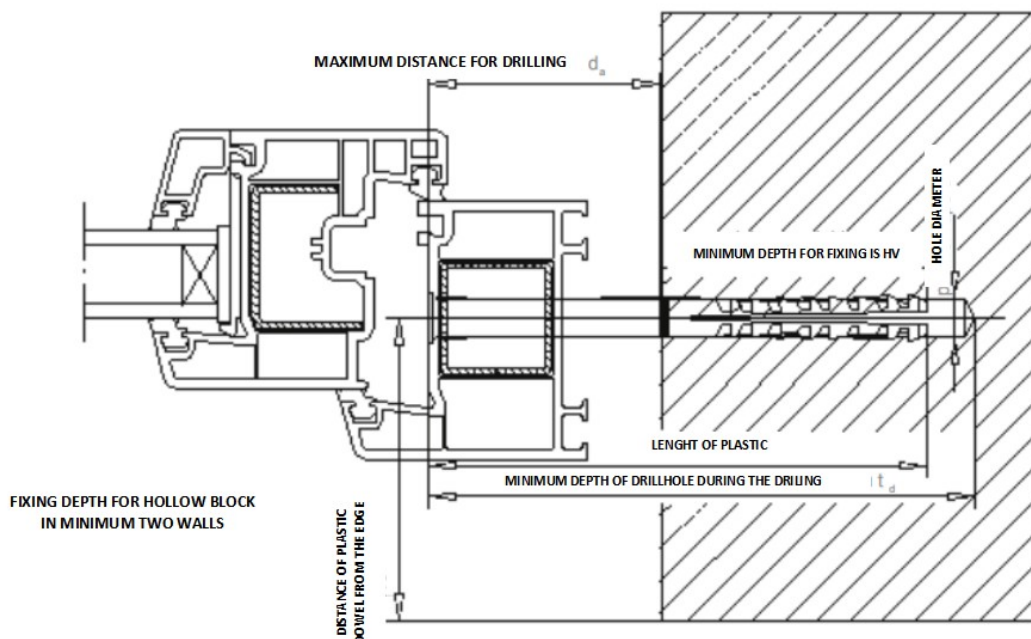
Note: when mounting the lifting and sliding position, it is mandatory to use washers and position them every 300 mm.



Picture 7. Places provided for the installation of washers 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:

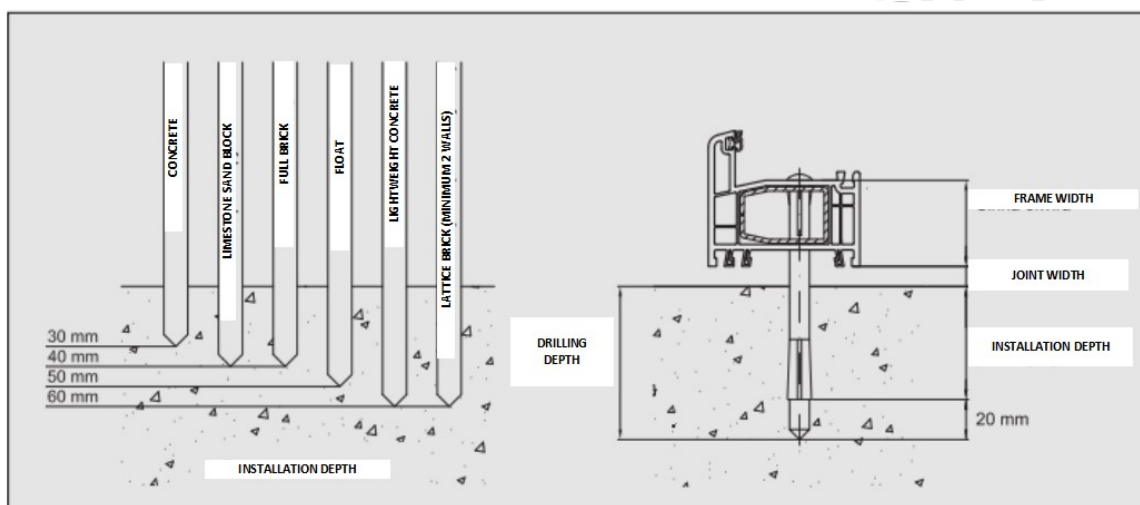
1. Frame dowels
2. Frame fasteners (turbo screws)
3. Masonry anchors



Picture 9. *Frame mounting materials*

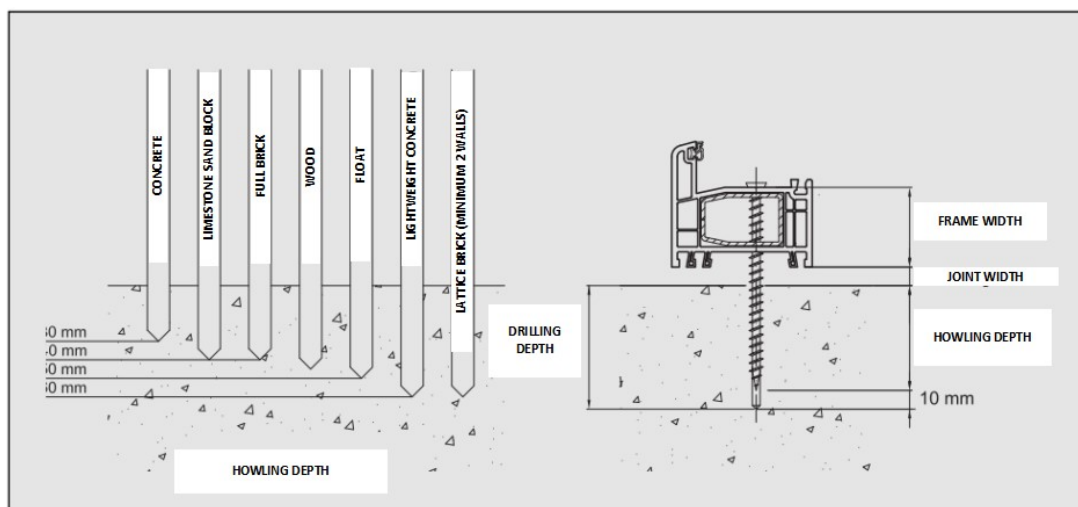
Frame dowels are loaded with shear and bending stresses. Therefore, the use of frame dowels, especially for heavy loads, is limited due to the required distance between the wall and the frame. The advantage of the frame dowels is that the frame can slide on the bushings and thus there is a possibility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

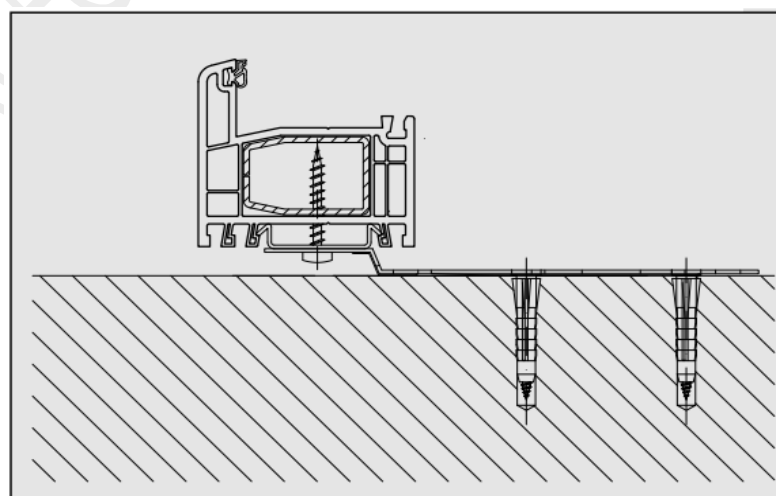
Frame fasteners are special screws that fasten the frame to the wall directly, without dowels. They are placed as normal dowel frames, but do not have to drill large holes. Installation and sizing can be found in the manufacturer's instructions. If they are used in a lower, horizontal frame, then the 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).

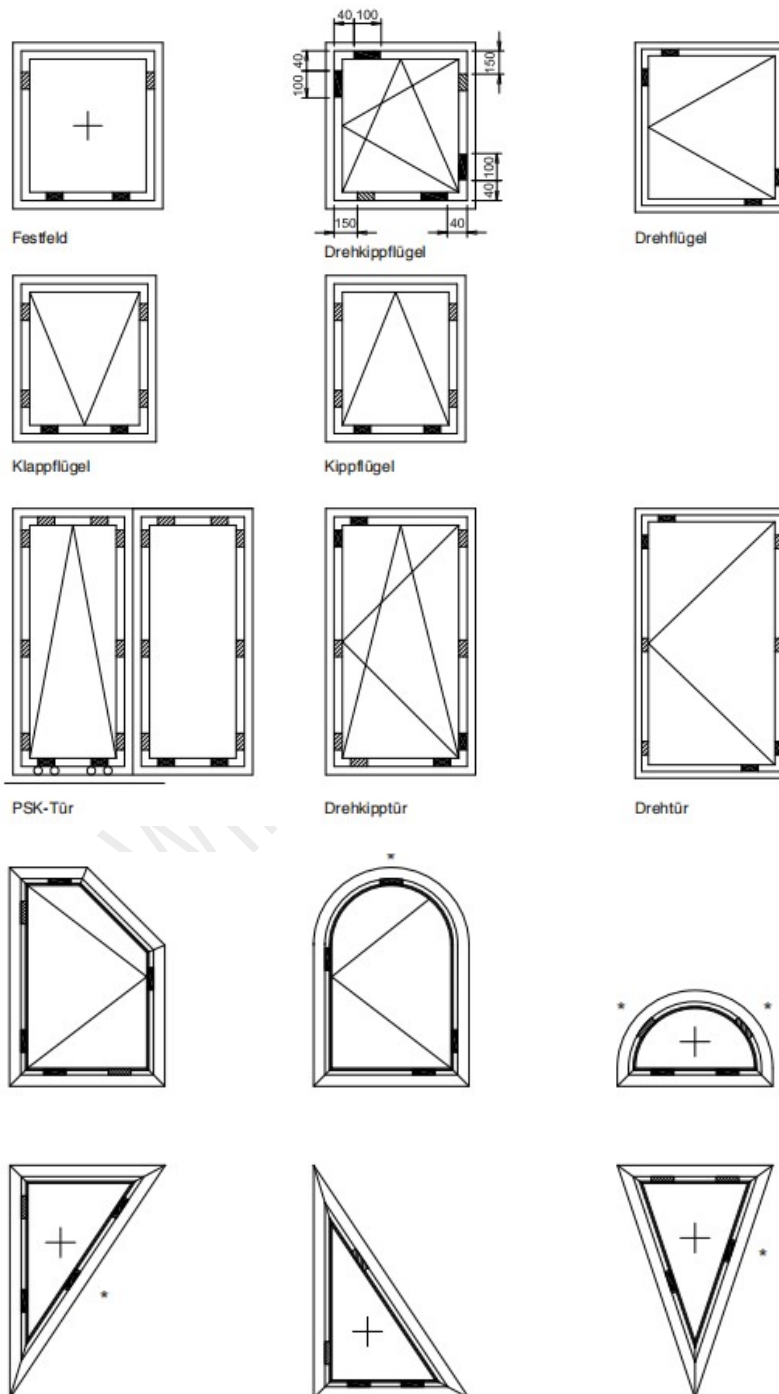
The masonry anchor is inserted obliquely into the back of the frame using a claw and pressed against the frame until the other claw is securely fastened. The foot should be additionally fastened to the frame with a screw. Now the console can be rotated, bent, and the window inserted. Masonry anchors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

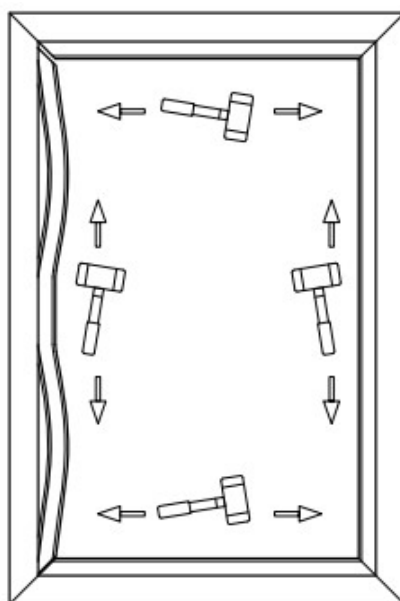
When glazing, it is necessary to install support blocks or glass supports. The horizontal support block on the side of the hinge is placed at a distance of 40 mm while the second support block is placed at a distance of 150 mm to allow smooth operation of the window elements due to tremor differences.



Picture 13. Position of supports during glazing

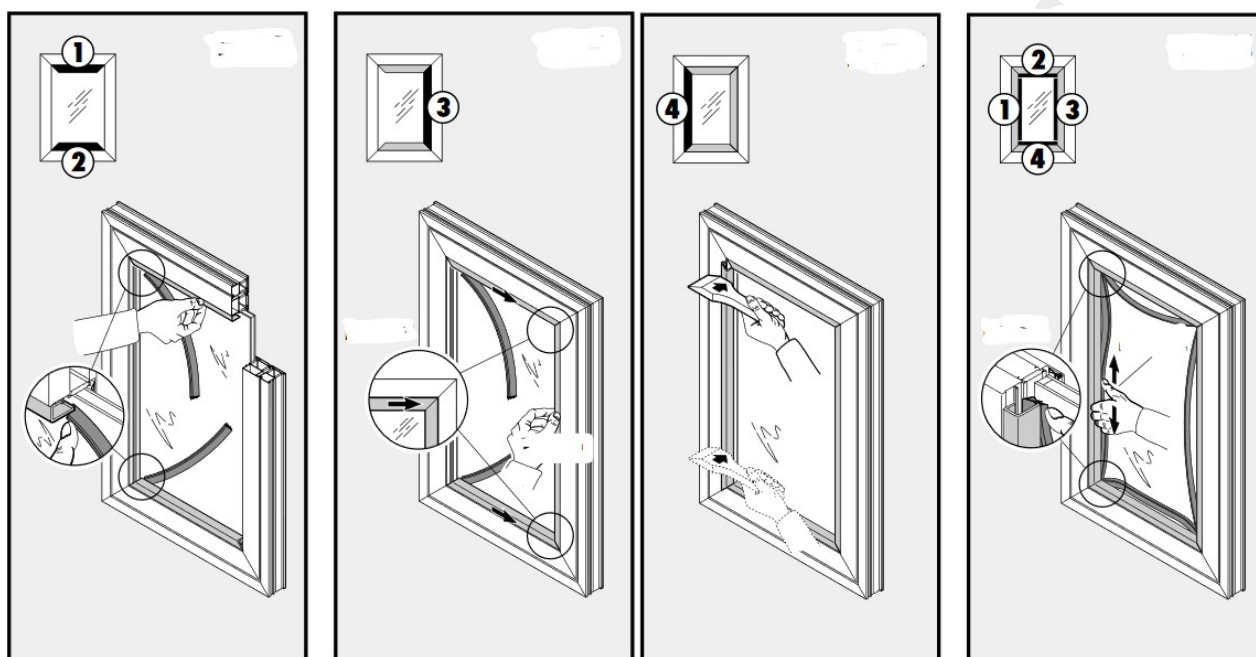
6.3.8 Installation of glazing moldings

When glazing the PVC positions, glazing moldings are placed in the slots and fastened with a rubber hammer. First, shorter moldings are placed in a horizontal position. After that longer vertical moldings are placed, which are bent in the middle and inserted between two horizontal moldings, 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*

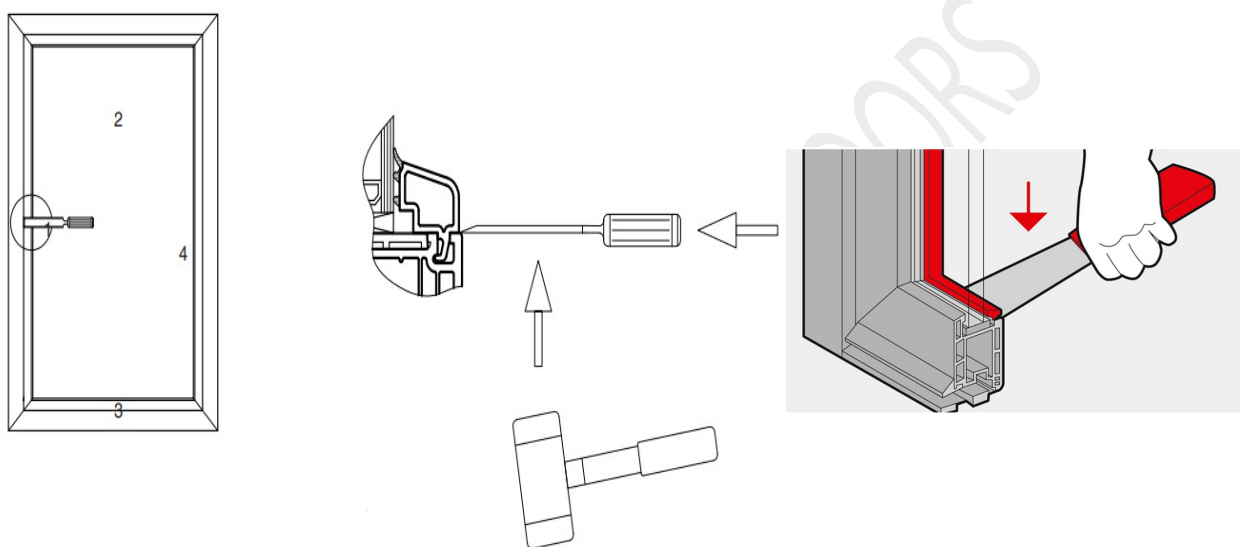
Installing a glazing molding in an ALU system requires a different approach. In the case of aluminum positions, glazing moldings are first installed, and then the seal is retracted. As with PVC, horizontal moldings are installed first, followed by left and right verticals. The sealant must be cut to 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 moldings

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.

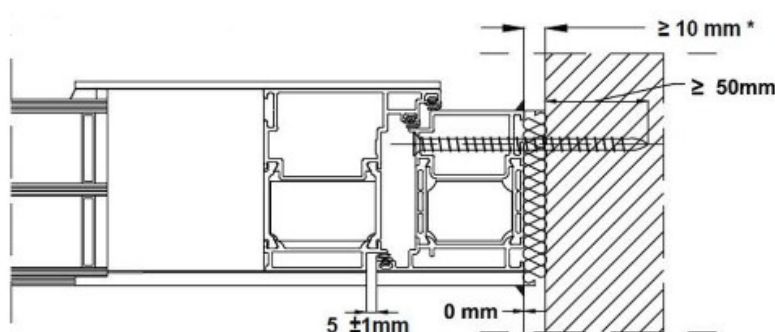


Picture 16. Display of demounting of the glazing molding

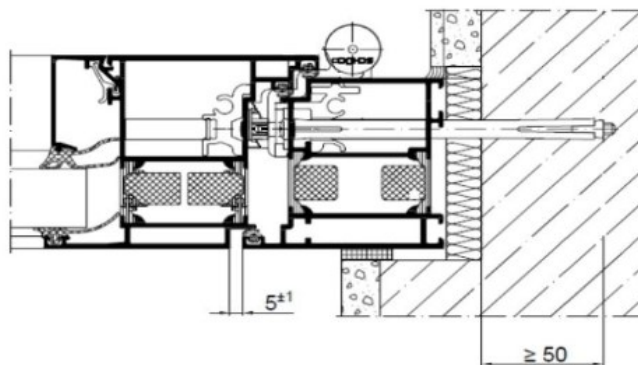
6.4 DOOR MOUNTING

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:

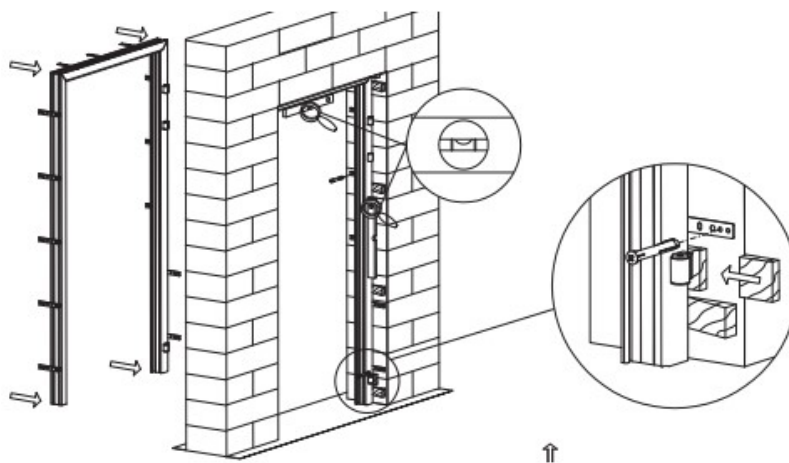
- 1) Frame fasteners (turbo bolts)
- 2) Frame dowels
- 3) Masonry anchors



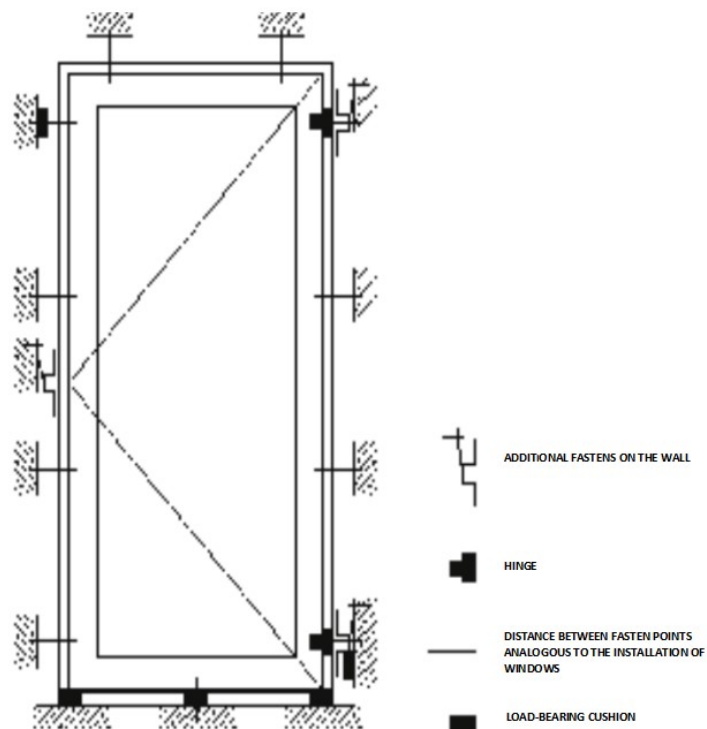
Picture 17. Fixing with frame fasteners (turbo bolts)



Picture 18. Fixing with a frame dowel

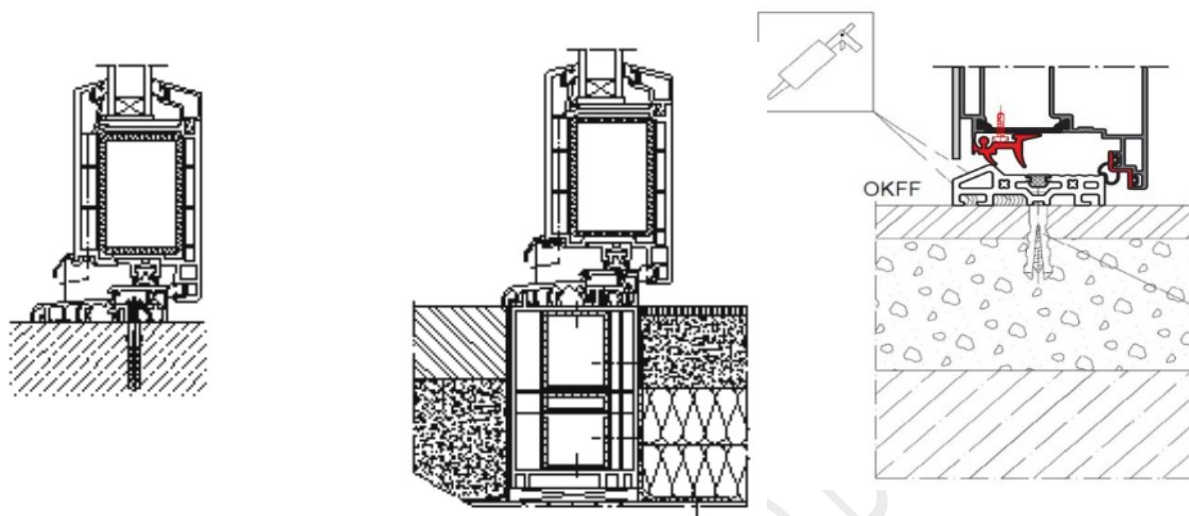


Picture 19. Fixing using masonry anchors

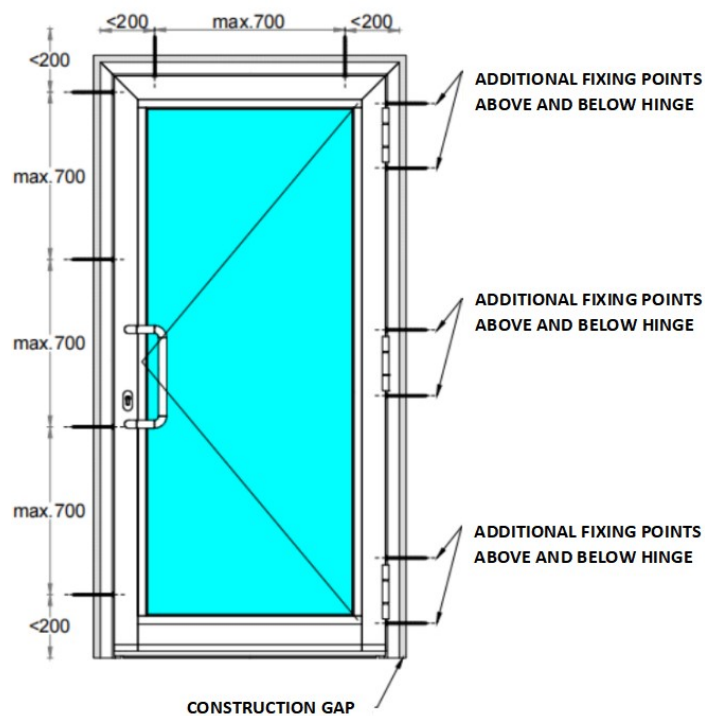


Picture 20. Arrangement of screws for fixing the front door

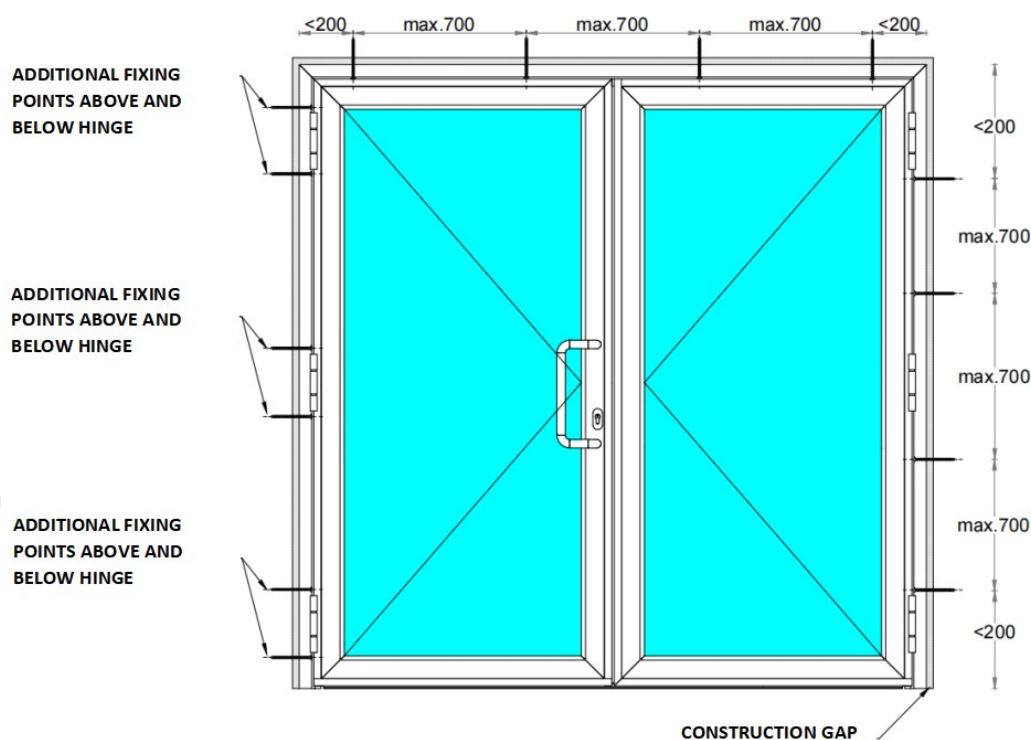
In the lower zone where the threshold is located, the attachment of the threshold is provided as follows:



Picture 21. Threshold fixing detail

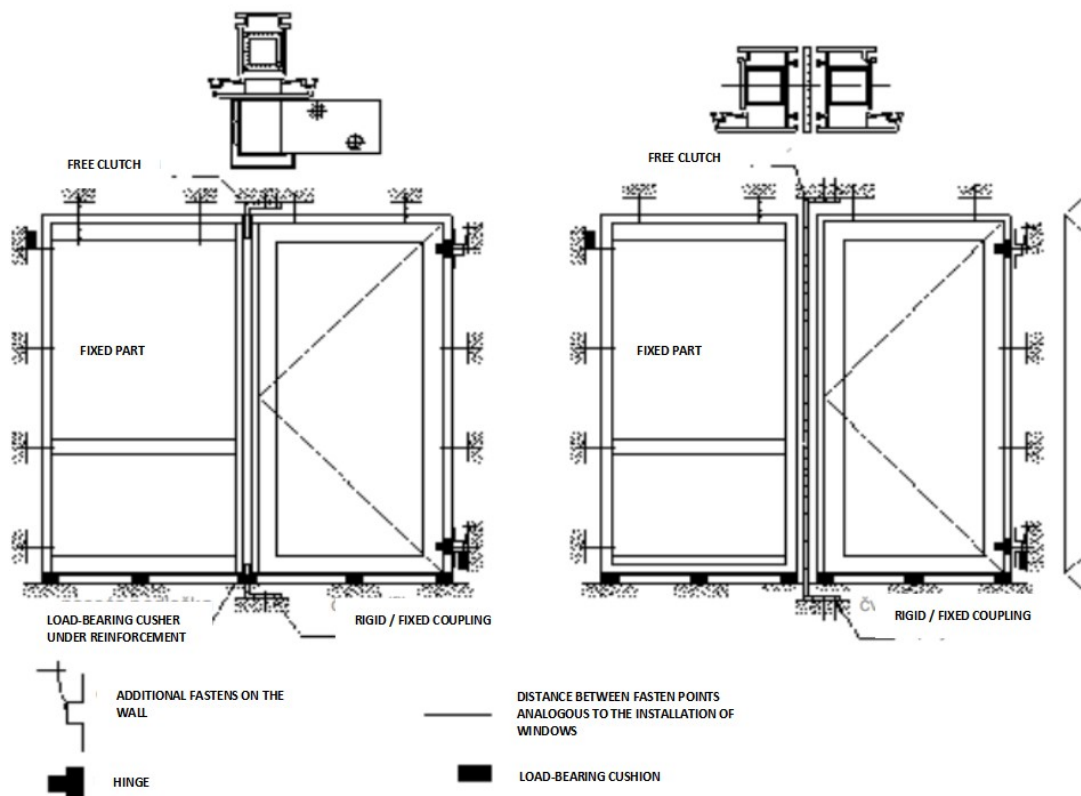


Picture 20a . Arrangement of screws for fixing single-leaf entrance doors



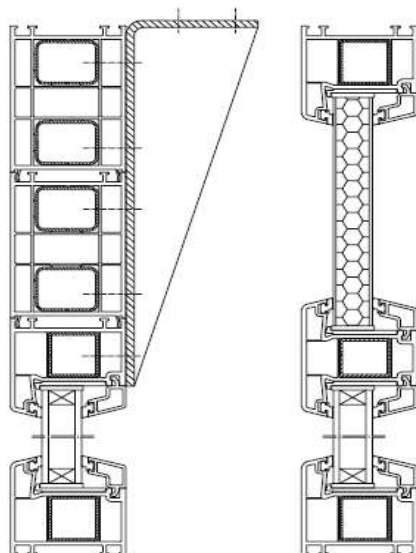
Picture 21 . Arrangement of screws for fixing double-leaf entrance doors

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

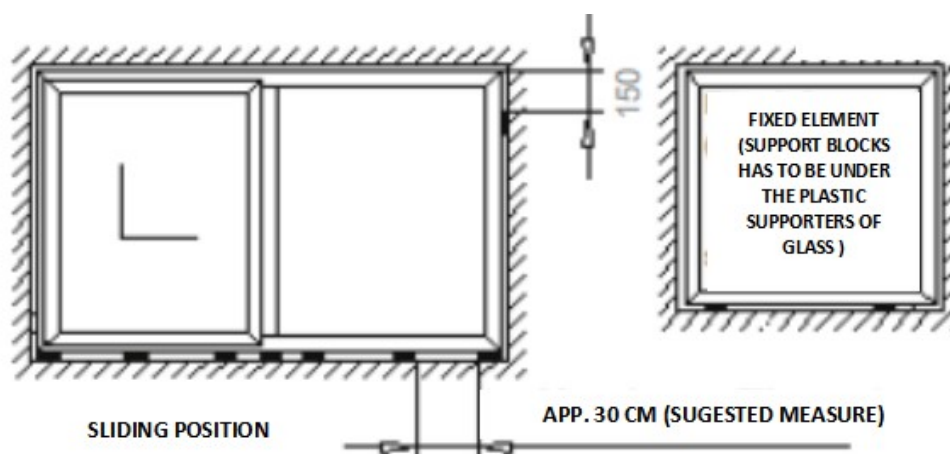
If extensions are used in positions and if the height of the extension exceeds a height of 60 mm, screw fastening is not sufficient and it is necessary to use an angular connection as additional static reinforcement.



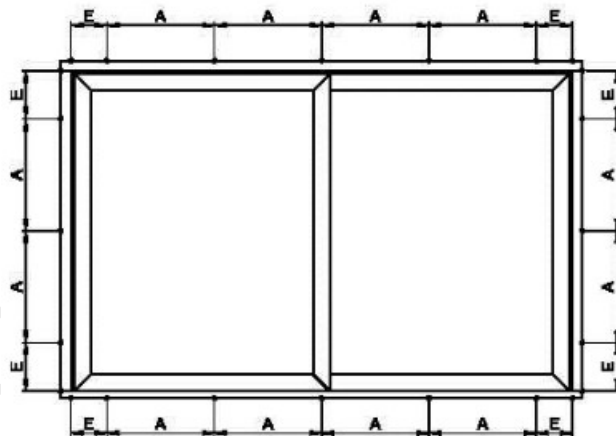
Picture 23. *Detail of placing the angular reinforcement on the extensions*

6.5 MOUNTING A SLIDING POSITIONS

When mounting the sliding positions, the maximum distance between the load-bearing washers must not exceed 30 cm. It is recommended that the washers 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.

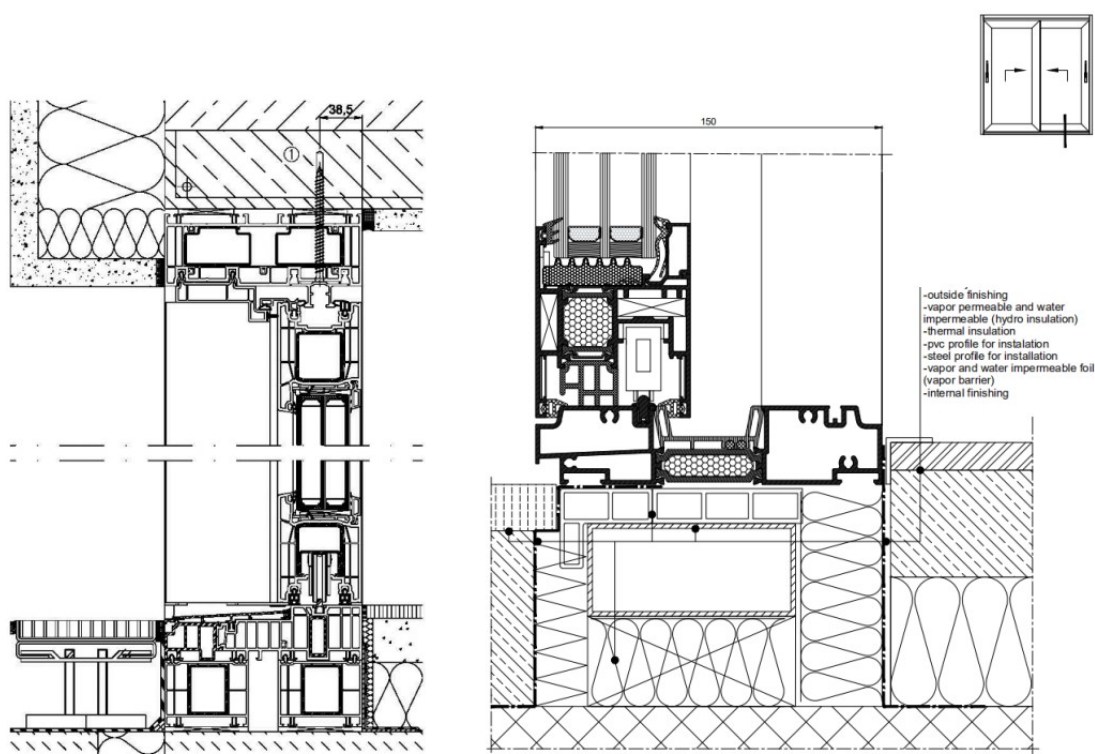


Picture 24. Position of laying the wedges when mounting the sliding positions

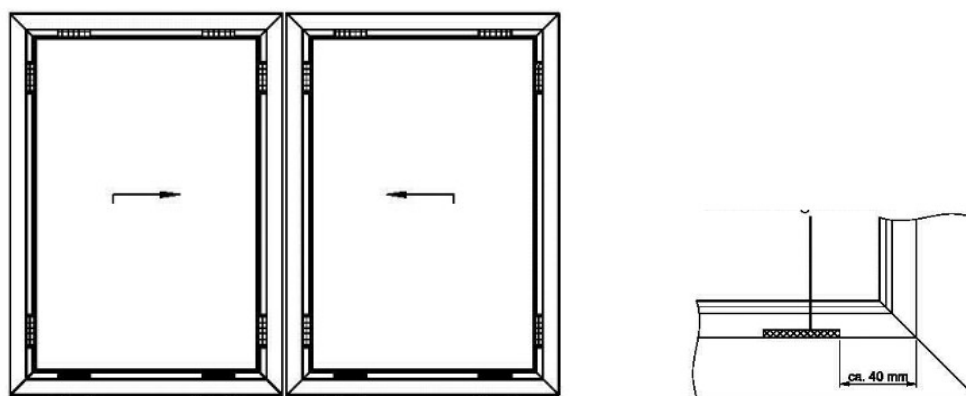




It is recommended to use a prepared substrate such as a metal pipe or a plastic mat when mounting the sliding positions.

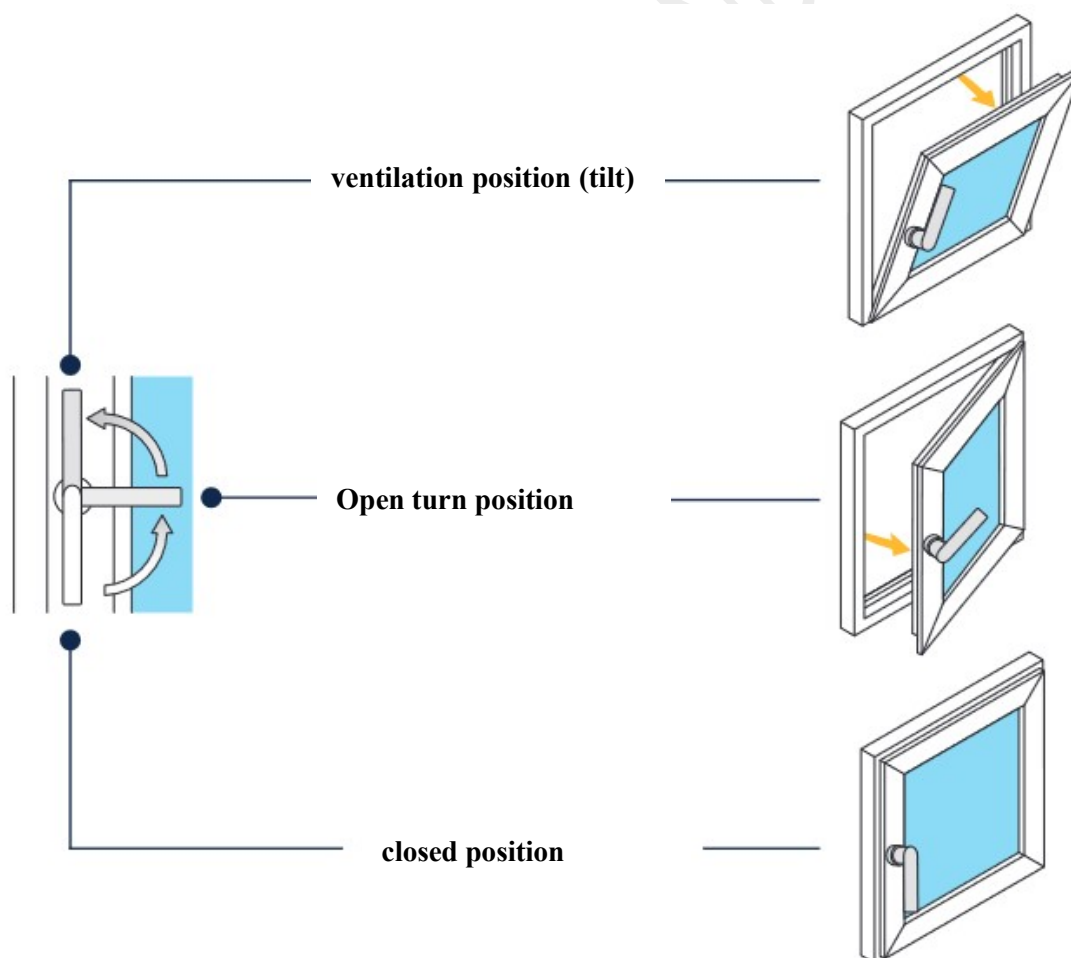


Picture 25. Detail of installation of sliding positions with metal or plastic pads

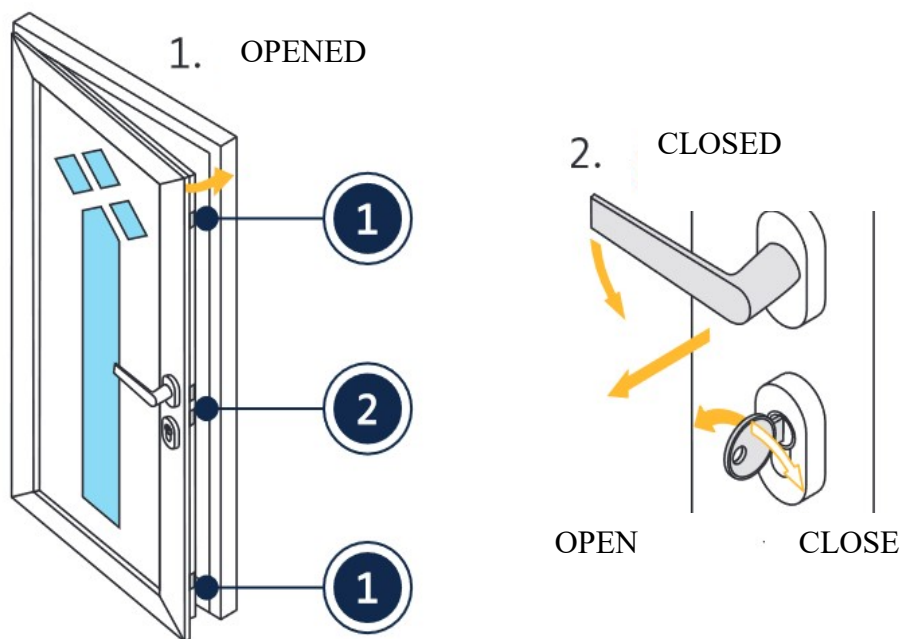


Picture 26. *Position of installation of glazing moldings*

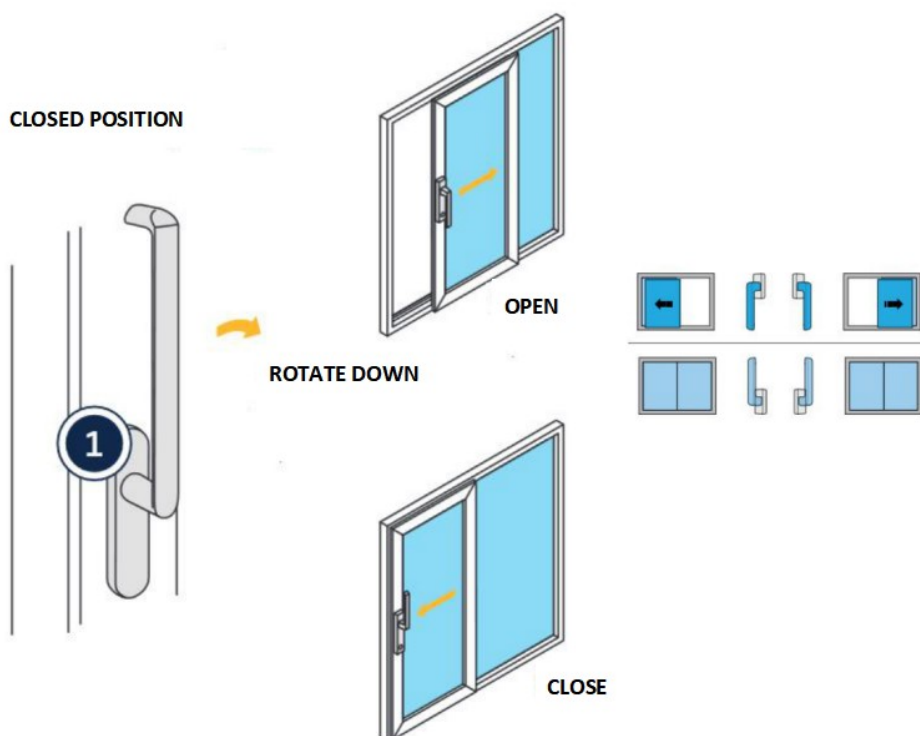
6.6 OPERATING INSTRUCTIONS (OPENING / CLOSING)



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



Picture 28. Demonstration of proper handling of the front door



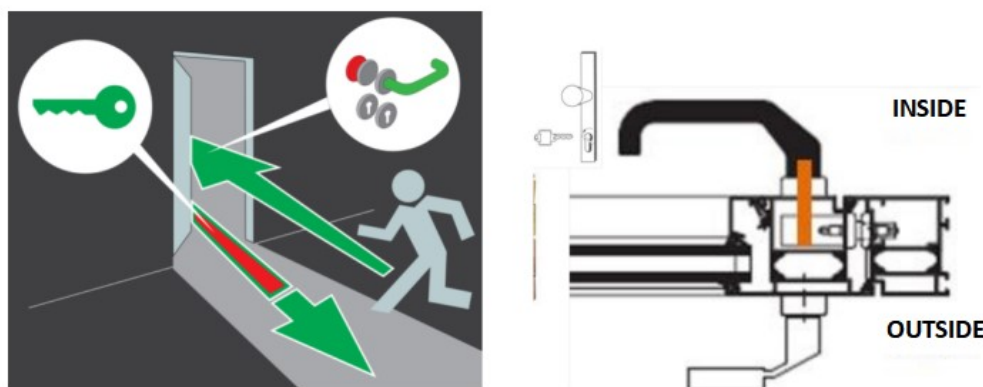
Picture 29. Demonstration of proper handling of lifting sliding positions

Handling with panic doors

Panic lock has a clearly defined system of operation : when the handle or panic bar is activated from the inside of the door , the door leaf must open abruptly with a defined required amount of force. Not only the latch is pulled here, but also the whole screw if necessary .

Panic Function E - Alternate function

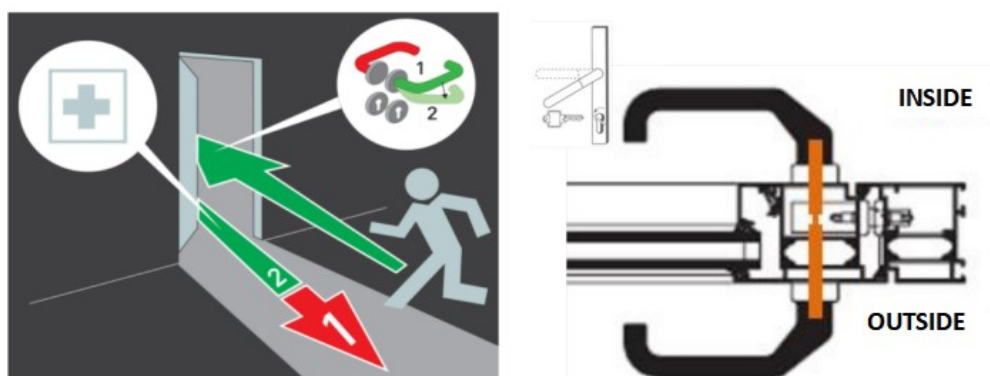
The panic function E is intended for objects that have access to a clearly defined group of people (key possession) . A fixed handle or handle mounted on the outside of the door can only be opened with a key. From the inside, the door is opened by pressing the keyless handle .



Picture 30 . *Panic function E*

Panic Function D - Transit Function

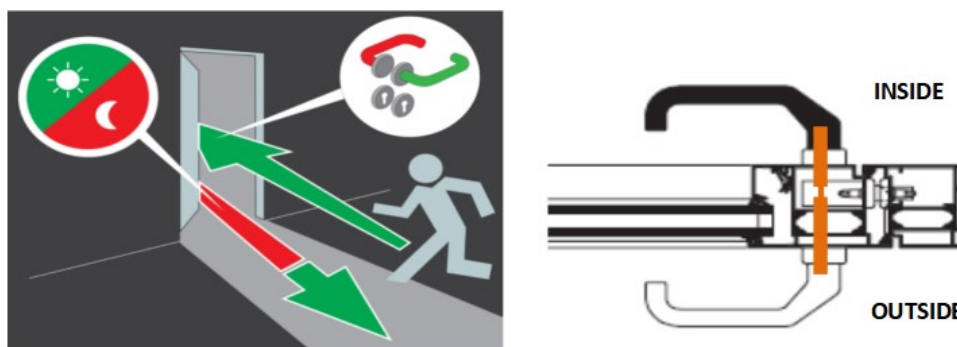
This panic function is intended for doors with a free escape function, which is not used often in practice. When the panic function is activated from the inside by pressing the handle, the door opens and the outer handle is also switched on. In this panic function, the door is not an obstacle when entering or escaping from the building.



Picture 31 . *Panic function D*

Panic Function B - Switch Function

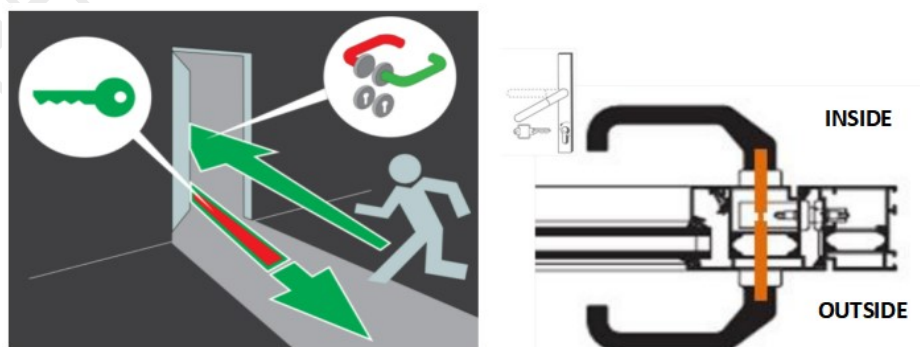
The Panic B function with handle on both sides is designed for administrative or business facilities. While the handle on the inside has the usual panic function, the outer handle can be mechanically turned on or off as needed. The handles are connected to a divisible square shaft. When the lock is unlocked, permanent double-sided passage is possible with the handle. The divisible square shaft of the handle is connected on both sides, ie. the handle is connected and functional on both sides, and the lock tab is retracted by pressing the handle. When the panic function is activated, the keyless passage in the direction of evacuation (inside out) is enabled when the lock is in the locked position. After activating this function, the outer handle returns to the detached position and it is not possible to enter from the outside again without the key, although the latch is no longer locked. When the lock is locked from the outside, it is only possible to enter with a key. The divisible square shaft of the handle is disconnected from the outside, the outer handle is idling and the latch is in the locked position.



Picture 31 . *Panic function B*

Panic function C - Forced closing function

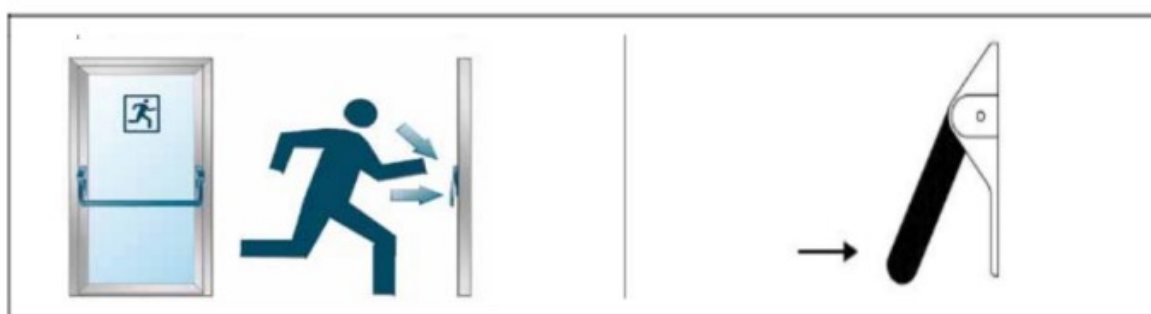
The Panic C feature with handle on both sides is designed for buildings open to the general public. While the handle on the inside has the usual panic function, the handle on the outside is off by default (idle function) and involves the use of a key (open position) to turn on or release (forcibly close). However, the key can only be removed after resetting the sleep function.



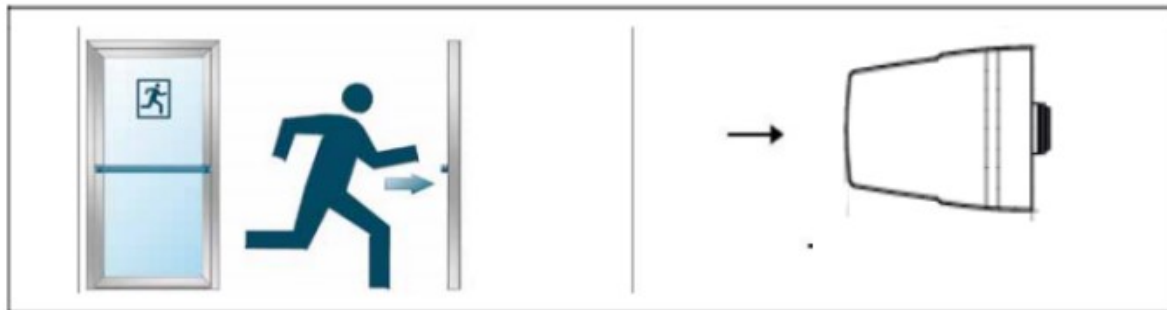
Picture 31 . *Panic function C*



Picture 32. How to open a panic door with a push handle according to EN 179



Picture 33. How to open a panic door with a push handle according to EN 1125



Picture 34. How to open a panic door with a push handle according to EN 1125



**DO NOT BLOCK THE DOOR
FREE MOVEMENT OF THE DOOR**

Picture 35. "Do not block the door / free movement of the door" label



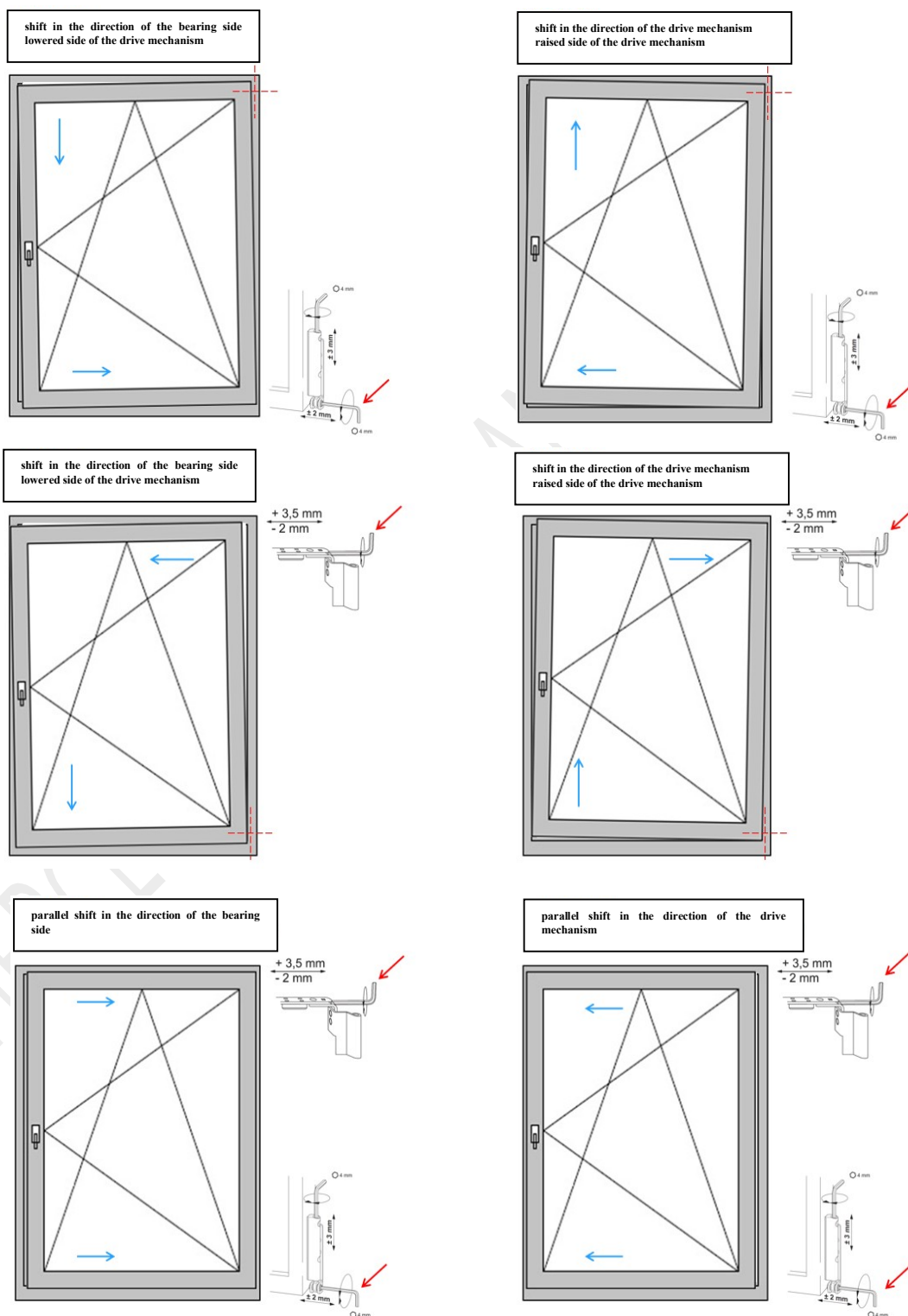
Picture 36. Labels “panic door standard EN179” and “panic door standard EN125”

All panic doors must have the following stickers:

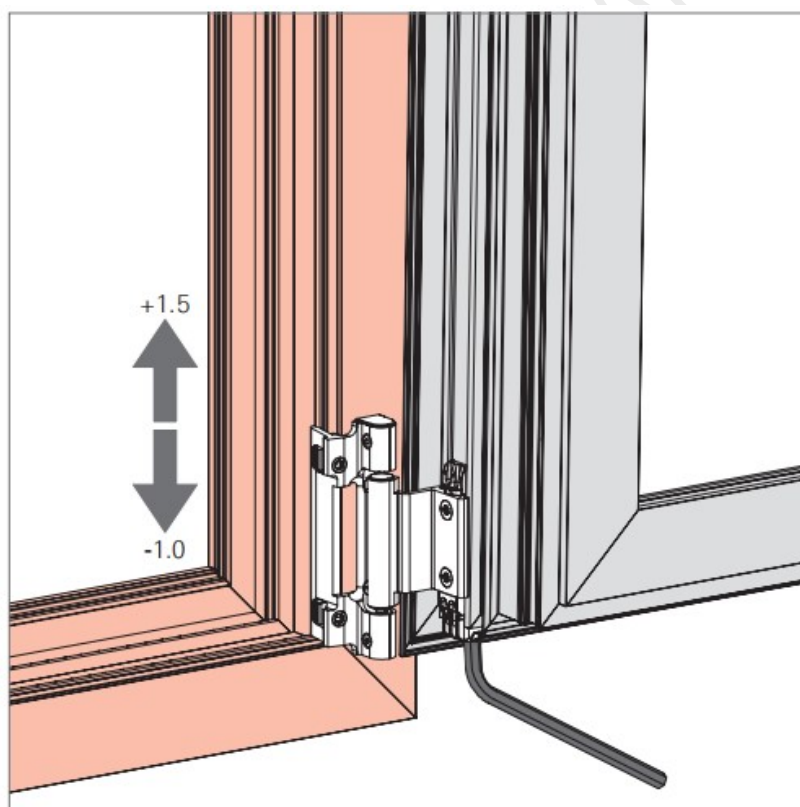
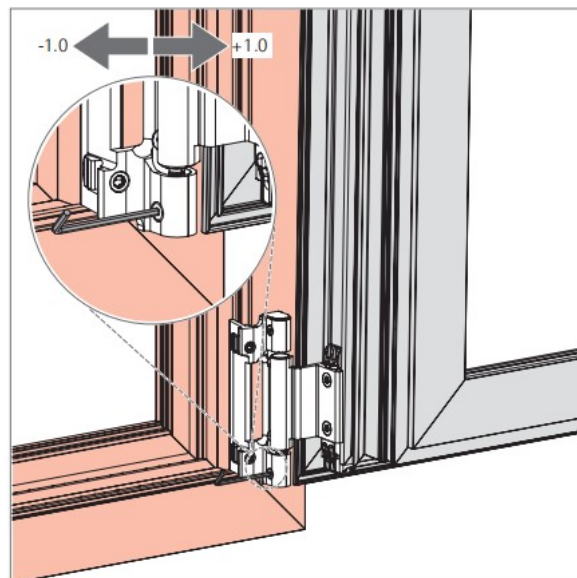
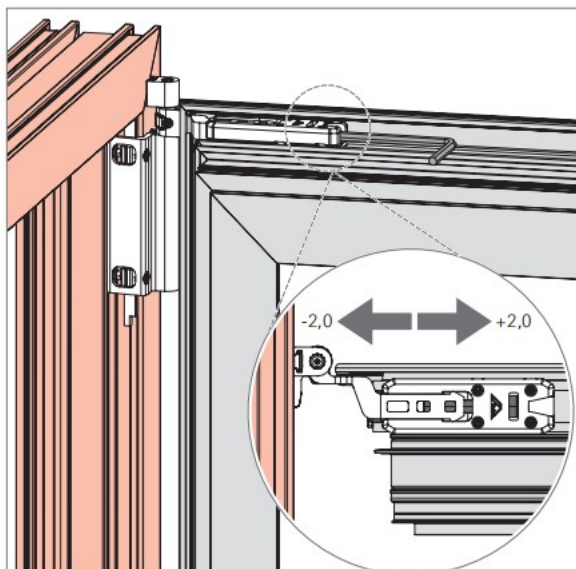
- Panic door label and norm
- Panic door opening method and
- blocking prohibition sign

6.7 HARDWARE ADJUSTMENT INSTRUCTIONS

6.7.1 Fitting adjustment for PVC windows

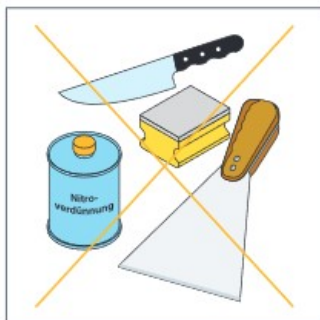


6.7.2 Fitting adjustment for ALU windows



7 USE AND MAINTENANCE STANDARD

7.1 CLEANING AND MAINTENANCE



Accessories that must not be used for cleaning

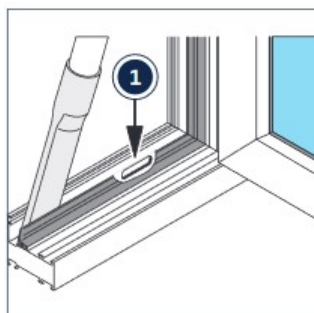
- Tools with sharp blades, such as knives,
- metal blades,
- steel wool,
- fish side of household sponges, etc.

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.

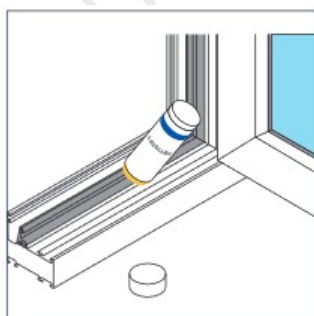


Optimal window care can be achieved by cleaning window frames and seals every time you wash the window. It is recommended to use a mild, non-rinsing cleaner.

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

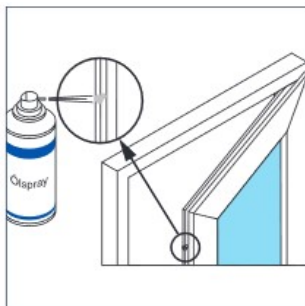


Use a vacuum cleaner to remove dust and debris from the space between the seal and the outside of the frame. Blocked water drains can be cleaned with a thin wooden or plastic stick. You also need to use a vacuum cleaner to remove dust and dirt from the guides at sliding positions to prevent the wheels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

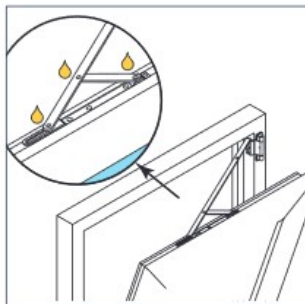


Inspect and lubricate seals

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.