



Plug-N-Harvest

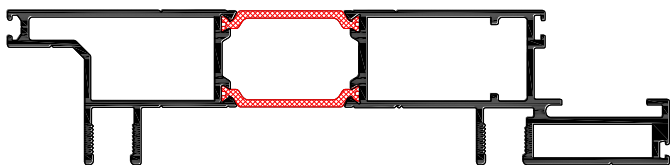
Module Fabrication & Installation Manual

CONTENTS

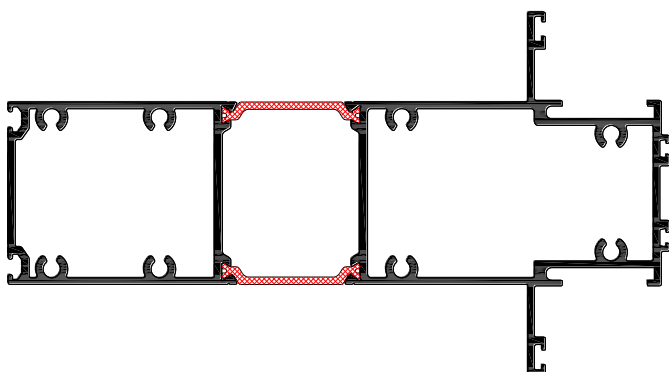
1. Profiles
2. Accessories
3. Module Types , Sections, BOM's , Cutting lists
4. Milling and Framing
5. Installation



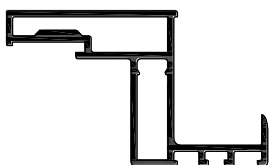
PROFILES



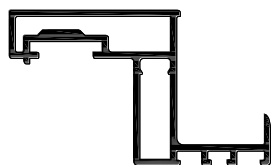
Profile:	PNH 001
Descript. :	Frameprofile
Weight :	2760 gr/m
X / Y :	181,50 / 42,20 mm



Profile:	PNH 002
Descript. :	T-profile
Weight :	3623 gr/m
X / Y :	181,50 / 100 mm



Profile:	PNH 003
Descript. :	Fixed Sash Profile
Weight :	1014 gr/m
X / Y :	71,50 / 42,50 mm



Profile:	PNH 004
Descript. :	Opening Sash Profile
Weight :	1064 gr/m
X / Y :	71,50 / 42,50 mm

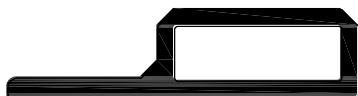
PROFILES



Profile:	PNH 005
Descript. :	Reinforcement profile
Weight :	859 gr/m
X / Y :	33 / 22 mm



Profile:	M71201
Descript. :	Spacer Profile
Weight :	249 gr/m
X / Y :	22,20 / 10 mm



Profile:	PNH 006
Descript. :	Bracket Profile
Weight :	2764 gr/m
X / Y :	105 / 26,50 mm



Profile:	M7010
Descript. :	Mesh Profile
Weight :	315 gr/m
X / Y :	29,70 / 24,70 mm



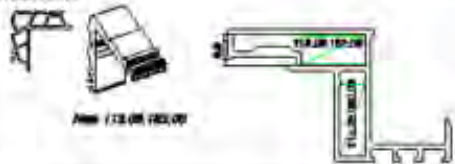
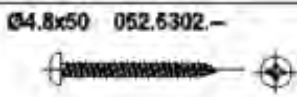
Profile:	PNH 007
Descript. :	Corner 40X20X2
Weight :	313 gr/m
X / Y :	40 / 20 mm

ACCESSORIES

Gaskets

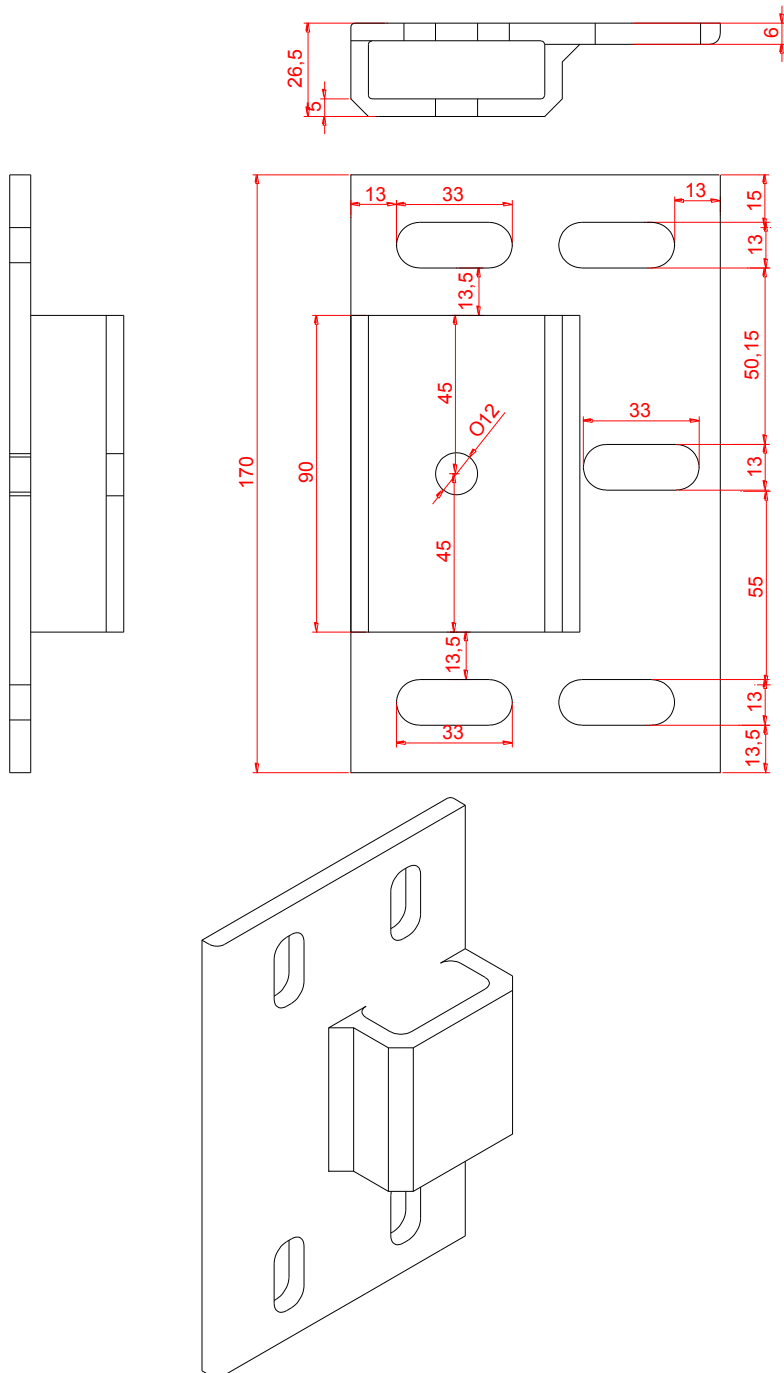
	Frame gasket 230.85002.03
	Sliding gasket 230.85003.03
	Glass gasket 200.04067.01
	Vertical support gasket
	Sash gasket 230.85001.03
	Spacer gasket 230.94110.01
	Frame gasket 230.99550.01
	Frame gasket 220.64800.01

Corner cleat Connectors and screws

	Screw corner connectors for frame profile
	Crimp nail corner connectors for frame profile
	Crimp nail corner connectors for sash profile
	Hex bolt M8X45 for Hook supports 4 pcs per support
	Screw 4,8X50 for T-Profiles
	Concrete anchor M12X100 4 pcs per Bracket

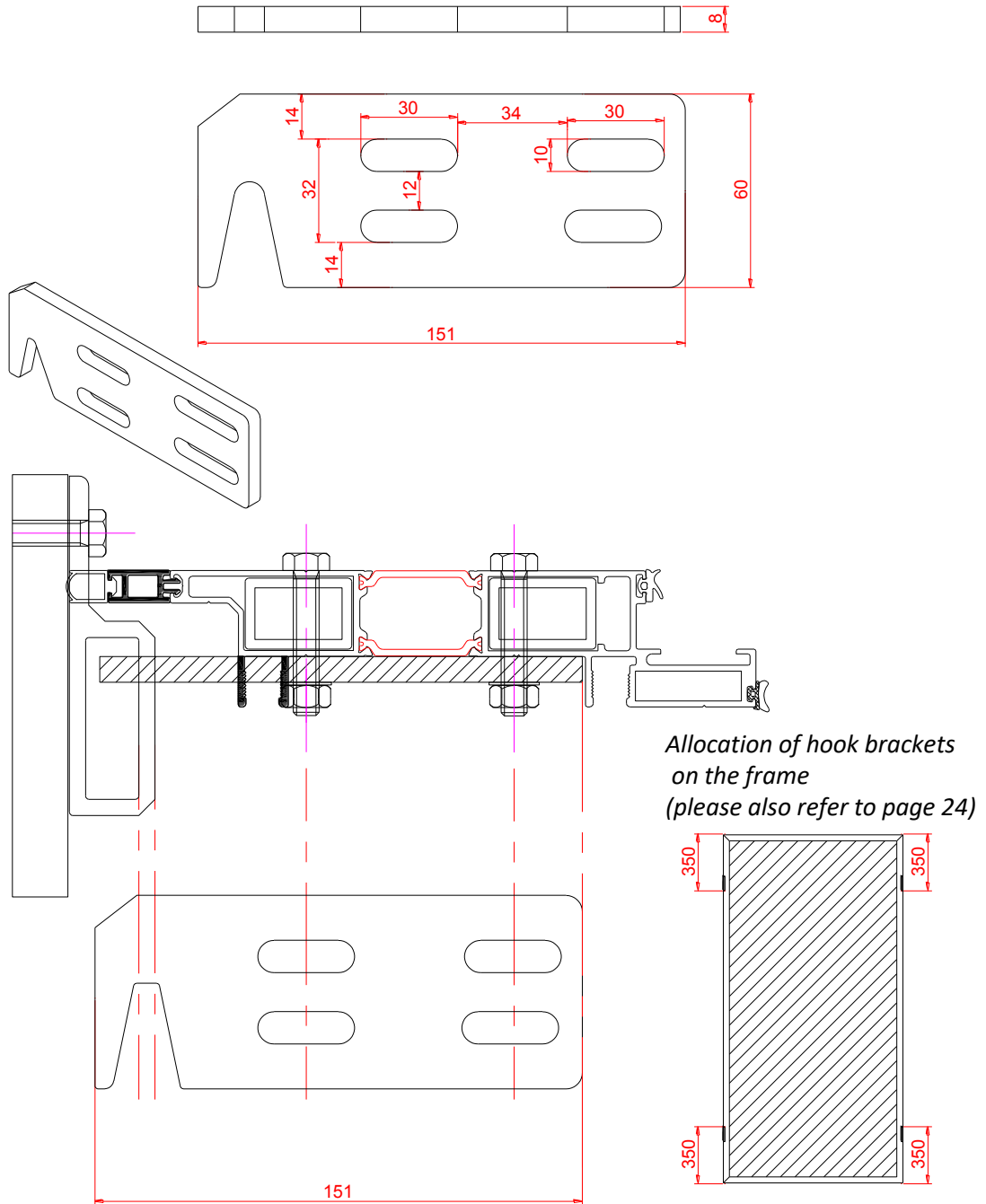
ACCESSORIES

Wall connection bracket



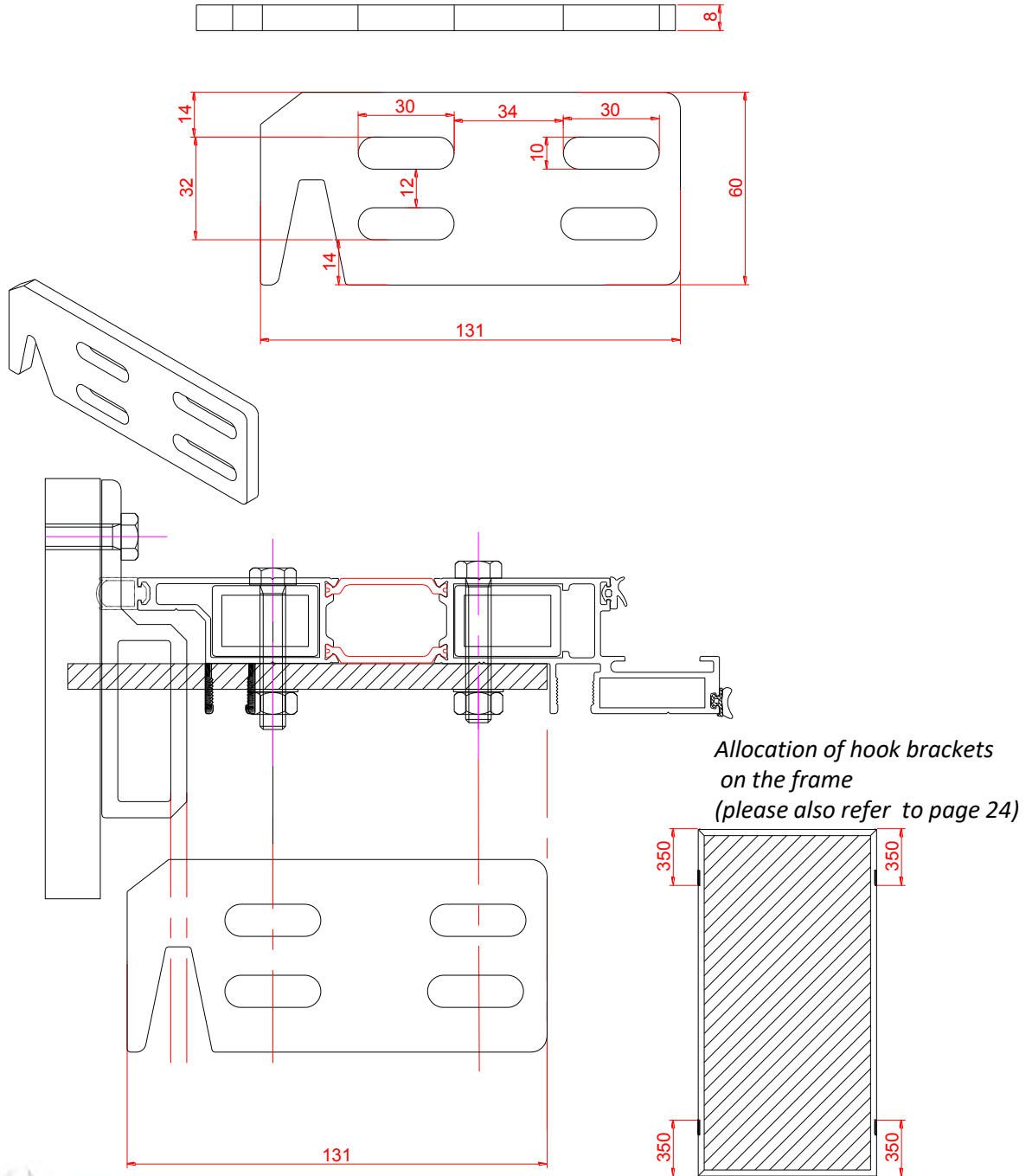
ACCESSORIES

Hook connection bracket for frame
profile with spacer profile



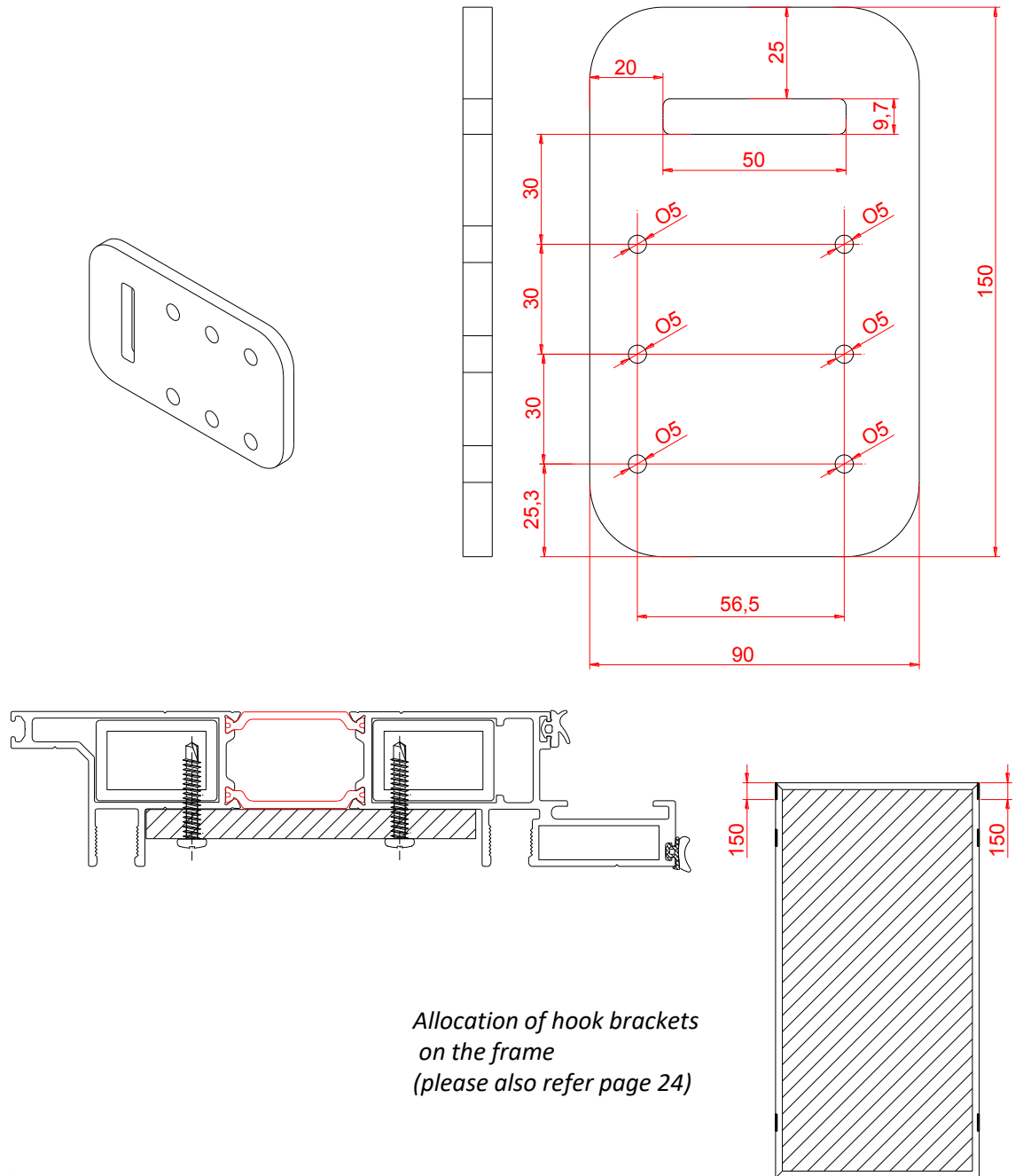
ACCESSORIES

Hook connection bracket for frame
profile without spacer profile



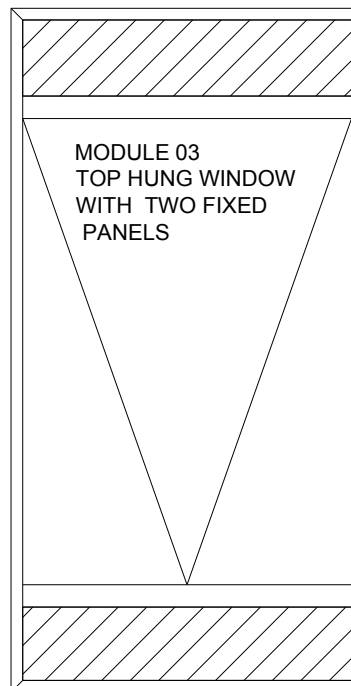
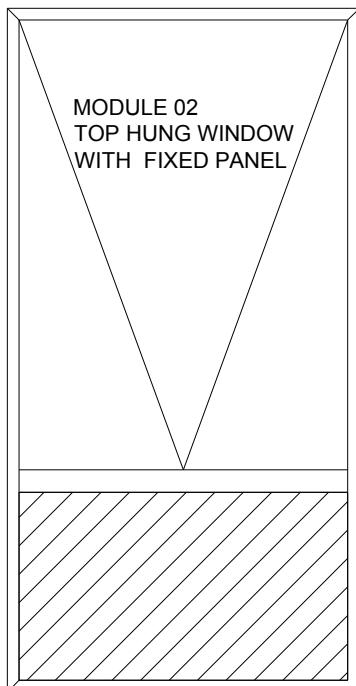
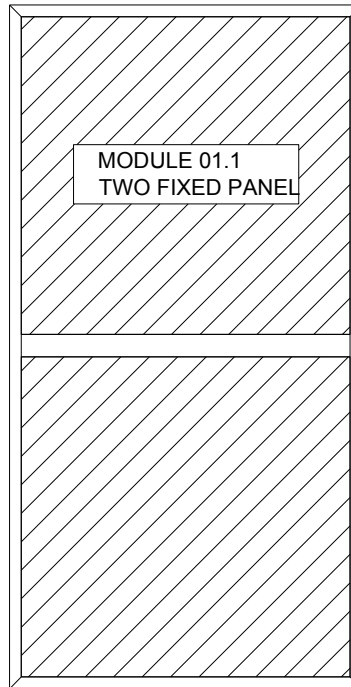
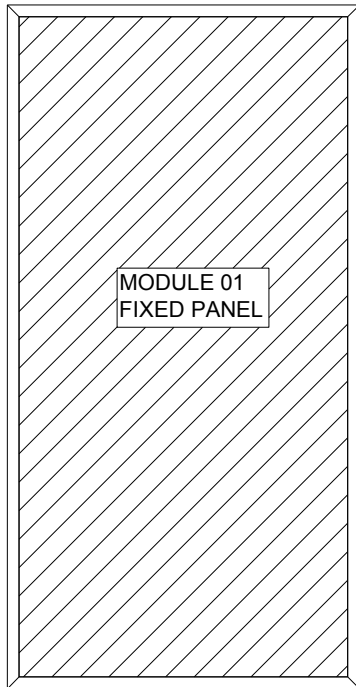
ACCESSORIES

Lifting plate for installation assistance



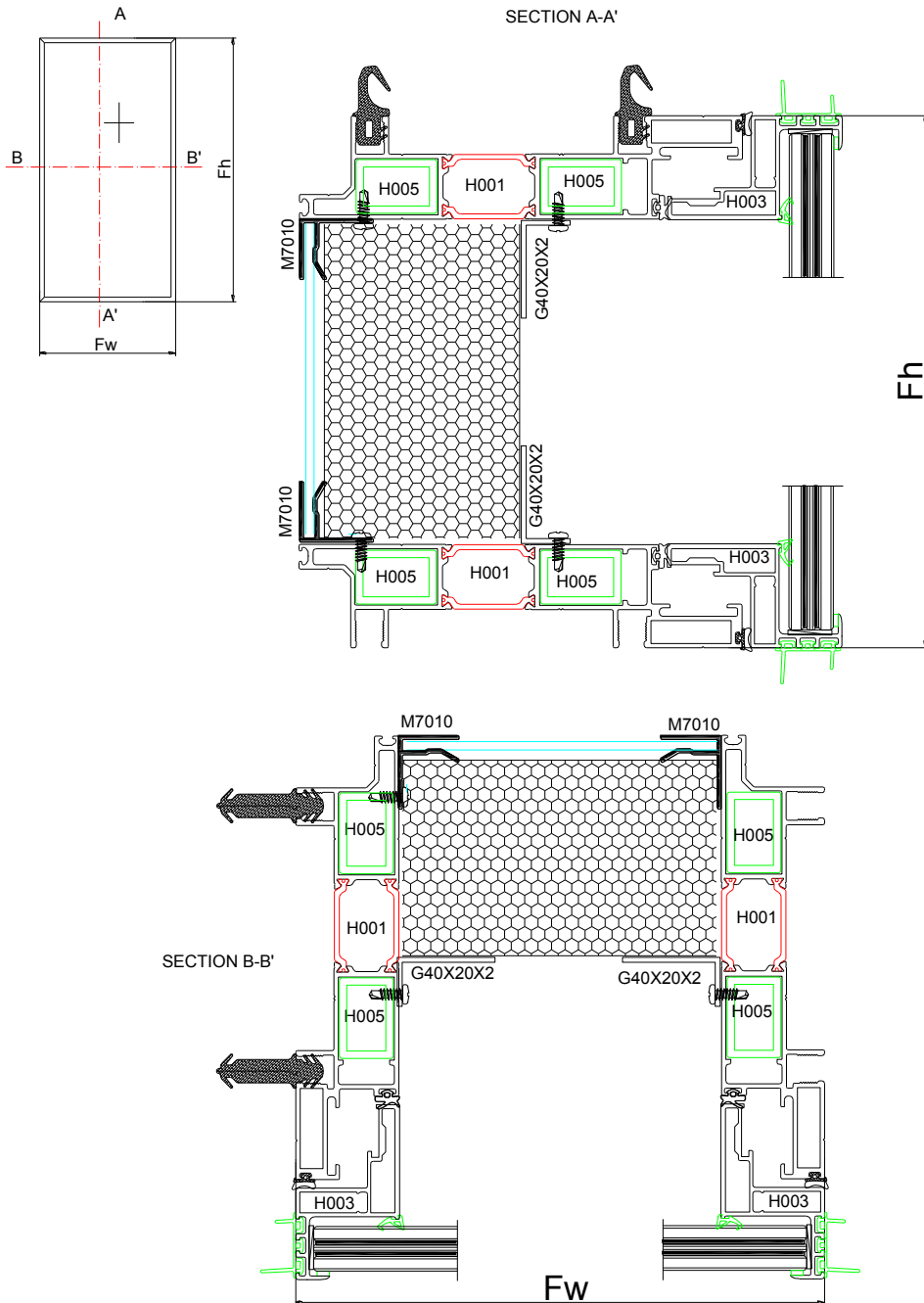
*Allocation of hook brackets
on the frame
(please also refer page 24)*

MODULE TYPES



MODULE TYPES

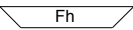
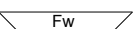
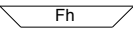
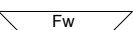
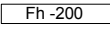
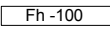
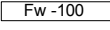
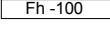
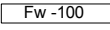
MODULE 01 Sections



MODULE TYPES

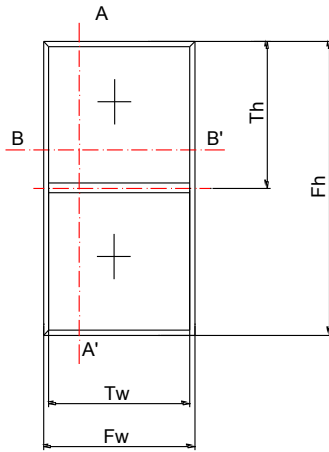
MODULE 01 Accessories / Cuttings

ACCESSORIES			
CODE	DESCRIPTION		QUANTITY
113.23.325.00		CONNECTION CORNER	8
113.09.320.00		CONNECTION CORNER	4
113.23.080.00		CONNECTION CORNER	4
113.09.183.00		CONNECTION CORNER	4
230.65002.01		Gasket	2XFw
230.85003.03		Gasket	2XFh
230.85001.03		Gasket	(2XFh) + (2XFw)
230.99550.01		Gasket	(2XFh) + (2XFw)
220.64800.01		Gasket	(2XFh) + (2XFw)
200.04067.01		Gasket	(2XFh) + (2XFw)
		Gasket	(2XFh) + (2XFw)
230.94110.01		Gasket	2XFh

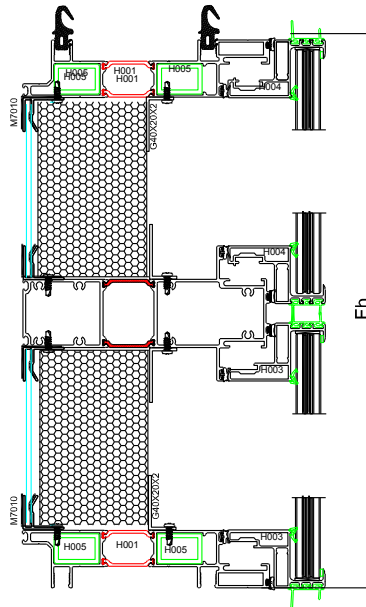
CUTTINGS		
CODE	CUTTING	QUANTITY
H001		2
		2
H003		2
		2
H005		2
M7010		2
		2
G40X20X2		2
		2
Mesh	(Fw -100) X (Fh-100)	1
Glazingpanel	(Fw -16) X (Fh-16)	1

MODULE TYPES

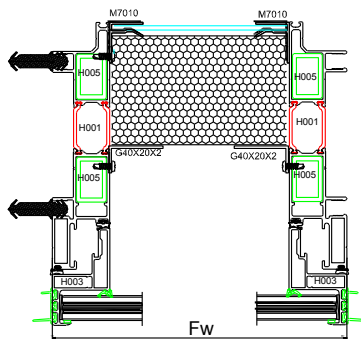
MODULE 01.1 Sections



SECTION A-A'
scale 1:2



SECTION B-B'
scale 1:2



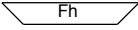
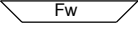
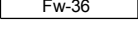
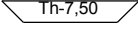
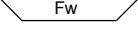
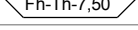
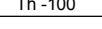
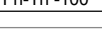
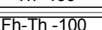
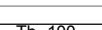
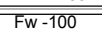
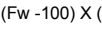
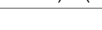
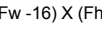
MODULE TYPES

MODULE 01.1 Accessories / Cuttings

ACCESSORIES

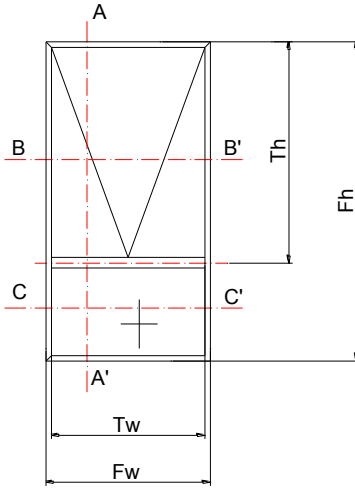
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113.23.325.00		CONNECTION CORNER	8
113.09.320.00		CONNECTION CORNER	4
113.23.080.00		CONNECTION CORNER	8
113.09.183.00		CONNECTION CORNER	8
230.65002.01		Gasket	2XFw
230.85003.03		Gasket	2XFh
230.85001.03		Gasket	(2XFh) + (4XFw)
230.99550.01		Gasket	(2XFh) + (4XFw)
220.64800.01		Gasket	(2XFh) + (4XFw)
200.04067.01		Gasket	(2XFh) + (4XFw)
		Gasket	(2XFh) + (4XFw)
230.94110.01		Gasket	2XFh

CUTTINGS

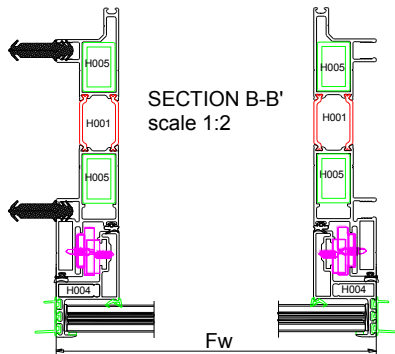
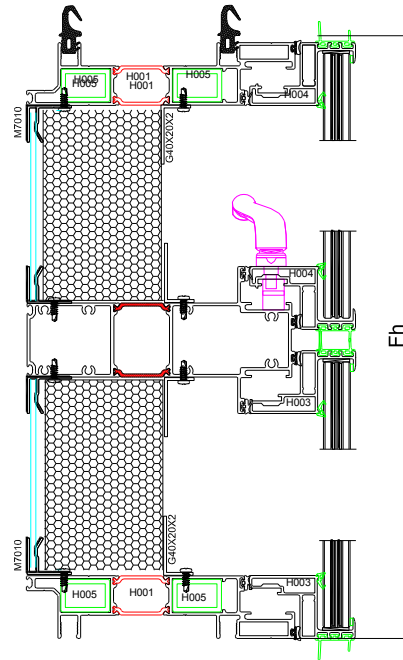
CODE	CUTTING	QUANTITY
H001		2
		2
H002		1
H003		2
		4
		2
H005		2
		2
M7010		2
		2
		4
G40X20X2		2
		2
		4
Mesh	(Fw -100) X (Th-100)	1
	(Fw -100) X (Fh-Th-100)	1
Glazingpanel	(Fw -16) X (Th-23)	1
	(Fw -16) X (Fh-Th-23)	1

MODULE TYPES

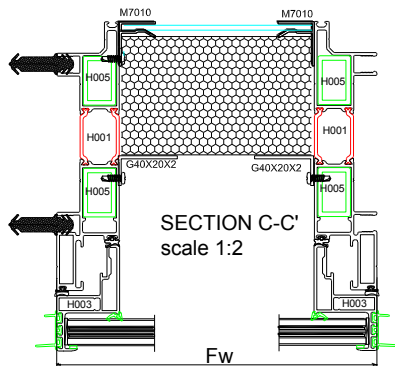
MODULE 02 Sections



SECTION A-A'
scale 1:2



SECTION B-B'
scale 1:2



SECTION C-C'
scale 1:2

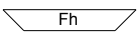
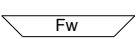
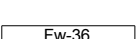
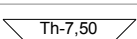
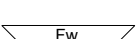
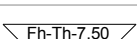
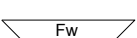
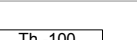
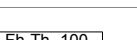
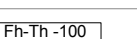
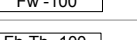
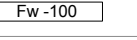
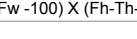
MODULE TYPES

MODULE 02 Accessories / Cuttings

ACCESSORIES

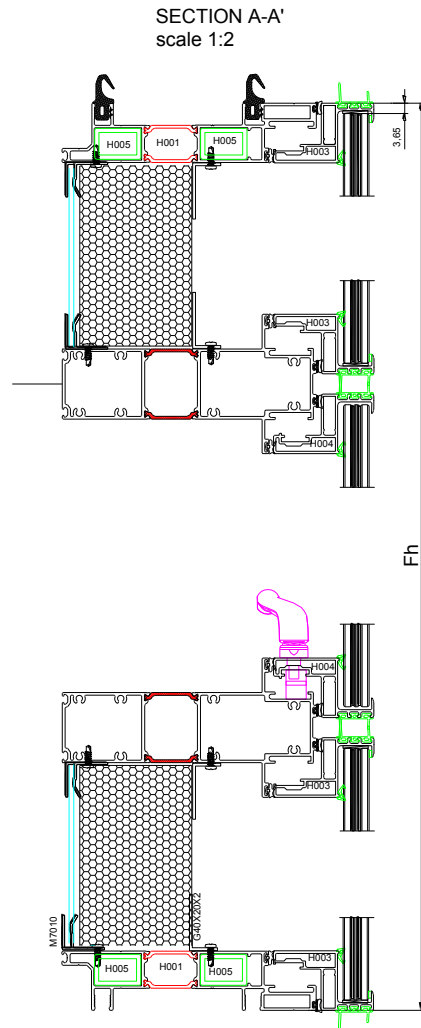
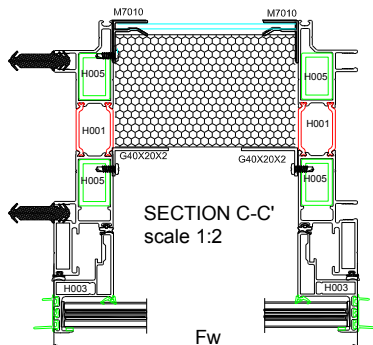
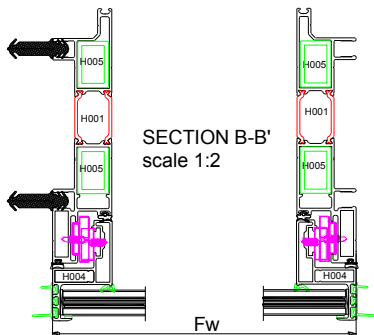
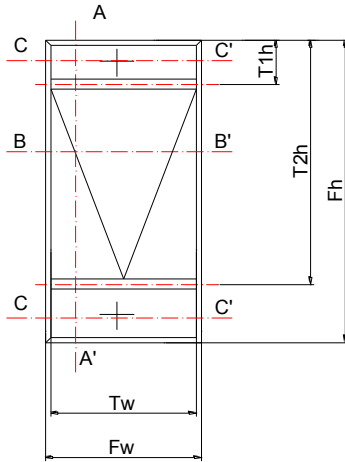
CODE	DESCRIPTION		QUANTITY
113.23.325.00		CONNECTION CORNER	8
113.09.320.00		CONNECTION CORNER	4
113.23.080.00		CONNECTION CORNER	8
113.09.183.00		CONNECTION CORNER	8
230.65002.01		Gasket	2XFW
230.85003.03		Gasket	2XFh
230.85001.03		Gasket	(2XFh) + (4XFW)
230.99550.01		Gasket	(2XFh) + (4XFW)
220.64800.01		Gasket	(2XFh) + (4XFW)
200.04067.01		Gasket	(2XFh) + (4XFW)
		Gasket	(2XFh) + (4XFW)
230.94110.01		Gasket	2XFh

CUTTINGS

CODE	CUTTING	QUANTITY
H001		2
		2
H002		1
H004		2
		4
H003		2
		2
H005		2
		2
M7010		2
		2
G40X20X2		2
		4
Mesh	(Fw -100) X (Fh-Th-100)	1
Glazingpanel	(Fw -16) X (Th-23)	1
	(Fw -16) X (Fh-Th-23)	1

MODULE TYPES

MODULE 03 Sections



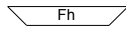
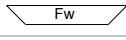
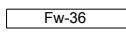
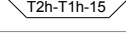
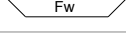
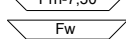
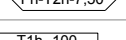
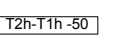
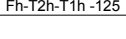
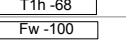
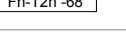
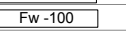
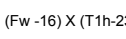
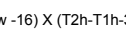
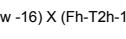
MODULE TYPES

MODULE 03 Accessories / Cuttings

ACCESSORIES

CODE	DESCRIPTION	QUANTITY
113.23.325.00	 CONNECTION CORNER	8
113.09.320.00	 CONNECTION CORNER	4
113.23.080.00	 CONNECTION CORNER	12
113.09.183.00	 CONNECTION CORNER	12
230.65002.01	 Gasket	2XFw
230.85003.03	 Gasket	2XFh
230.85001.03	 Gasket	(2XFh) + (8XFw)
230.99550.01	 Gasket	(2XFh) + (8XFw)
220.64800.01	 Gasket	(2XFh) + (8XFw)
200.04067.01	 Gasket	(2XFh) + (8XFw)
	 Gasket	(2XFh) + (8XFw)
230.94110.01	 Gasket	2XFh

CUTTINGS

CODE	CUTTING	QUANTITY
H001	 Fh	2
	 Fw	2
H002	 Fw-36	2
H004	 T2h-T1h-15	2
	 Fw	2
H003	 T1h-7,50	2
	 Fw	4
	 Fh-T2h-7,50	2
H005	 T1h -100	2
	 T2h-T1h -50	2
	 Fh-T2h-T1h -125	2
M7010	 T1h -68	2
	 Fw -100	4
	 Fh-T2h -68	2
G40X20X2	 T1h -68	2
	 Fw -100	4
	 Fh-T2h -68	2
Mesh		1
Glazingpanel	(Fw -16) X (T1h-23)	1
	(Fw -16) X (T2h-T1h-30)	1
	(Fw -16) X (Fh-T2h-15)	1

MODULE TYPES

Module Fabrication

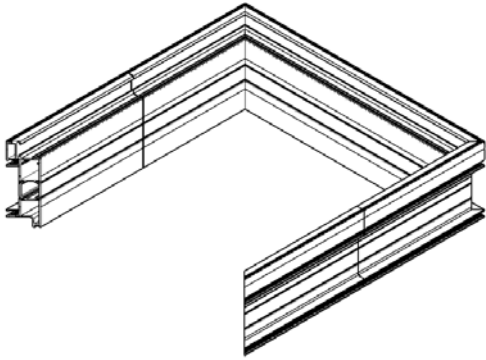
MAIN FRAME

- Fabrication methodology
- Cutting and milling of Frame and T-profiles
- Framing
- Pin Installation
- Hook bracket and lifting plate installation
- Gasket installation
- In case of top hung window, Scissors installation

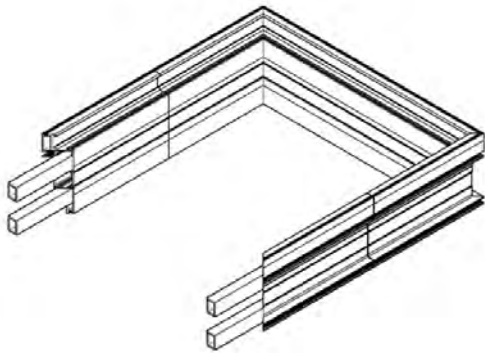
SASH FRAME

- Fabrication methodology
- Cutting
- Framing- Grazing
- Hook Installation (not necessary by openings)
- Gasket installation
- In case of top hung window, handle installation
- Sash installation in the main frame

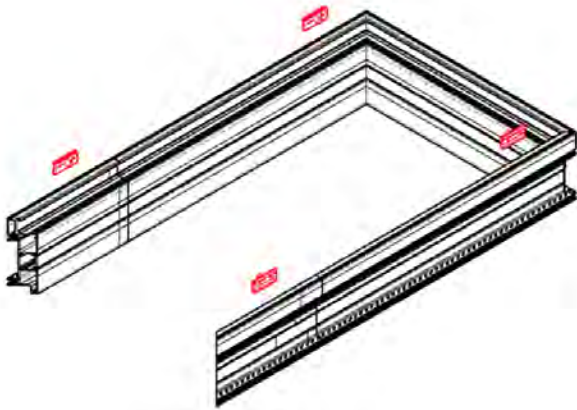
MAIN FRAME FABRICATION METHODOLOGY



1. U-Shape creation
The machined parts of the frame are fabricated in a U-shaped form

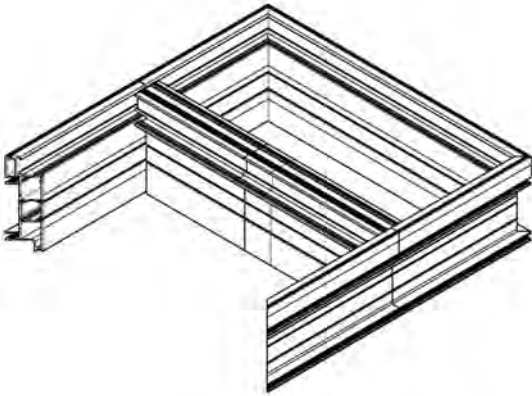


2. Insertion of inner core profile

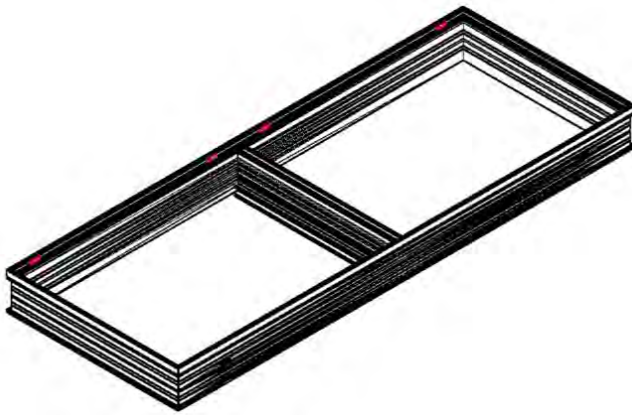


3. Pin Accessory Installation

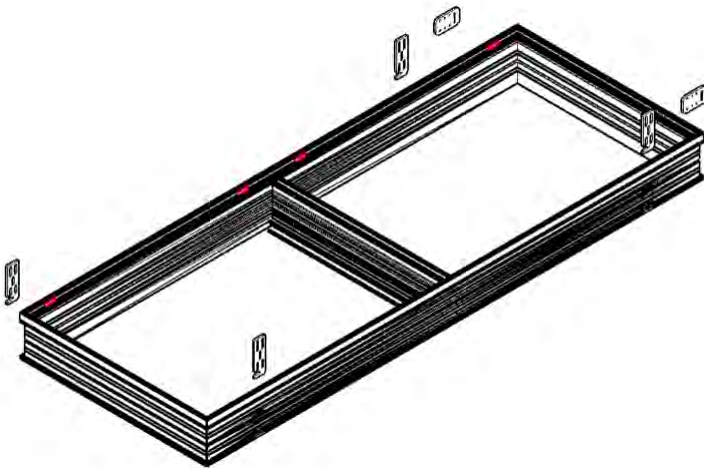
FABRICATION METHODOLOGY OF FRAME



4. T-profile installation

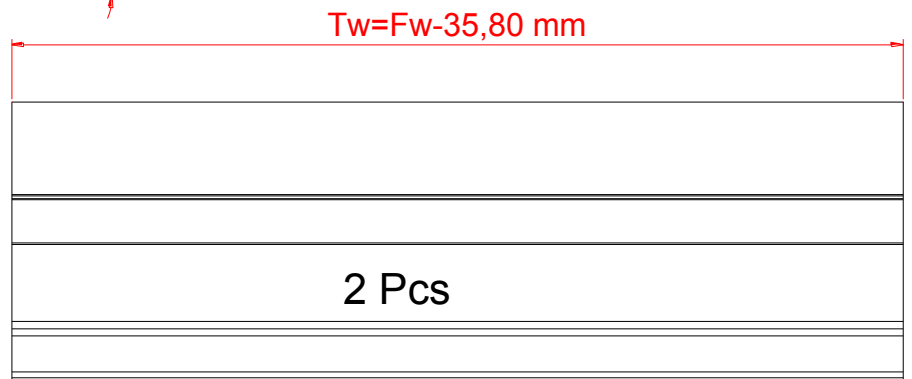
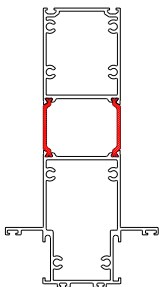
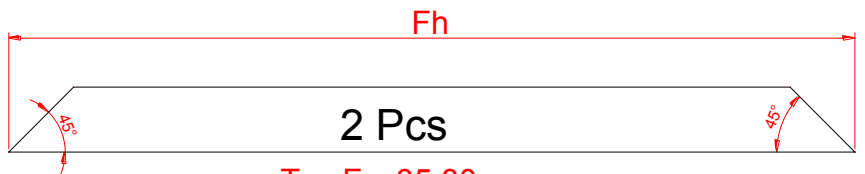
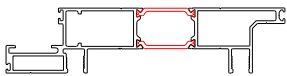
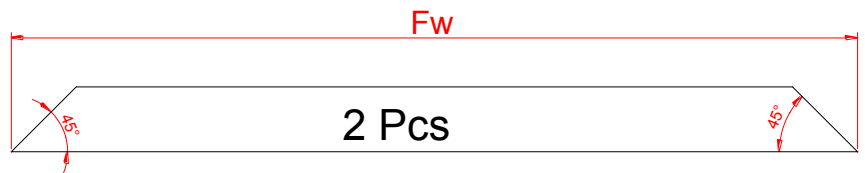
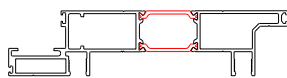
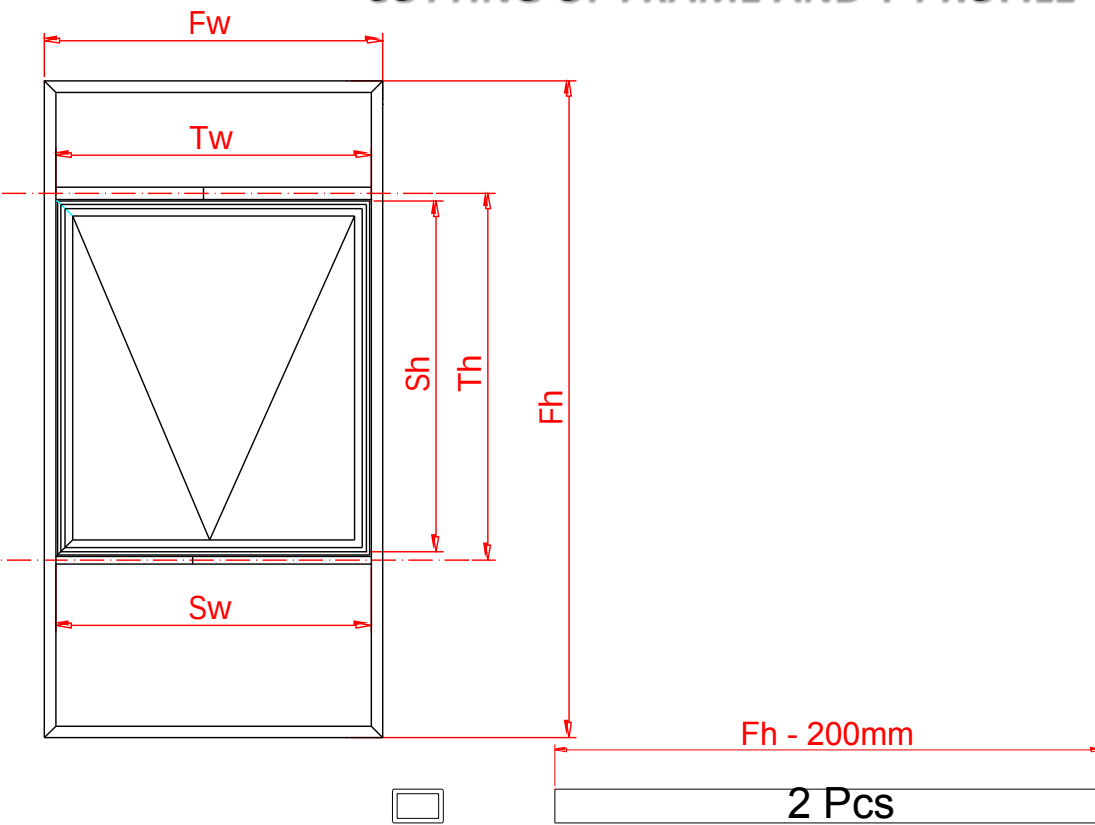


5. Frame completion

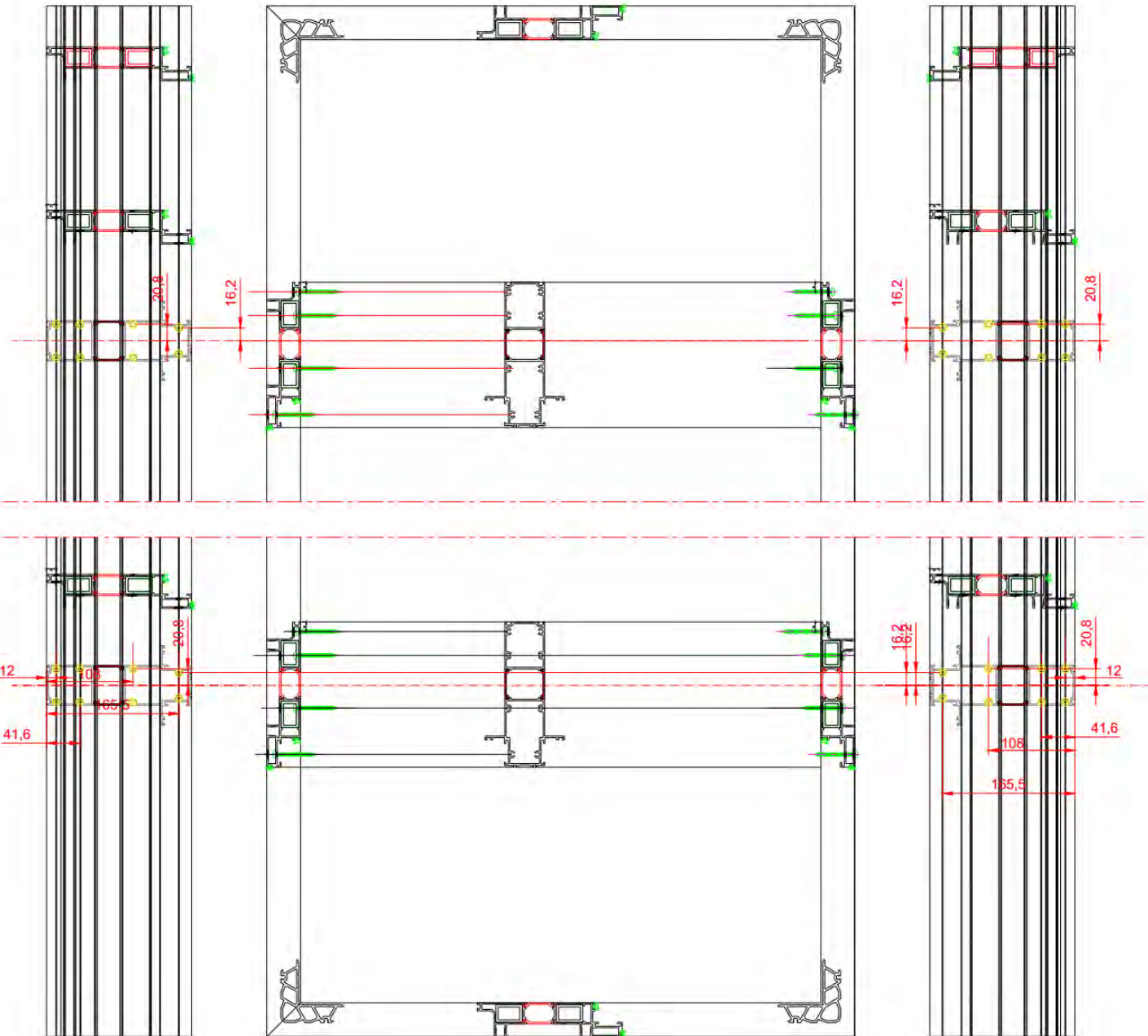


6. Bracket and hook plates installation

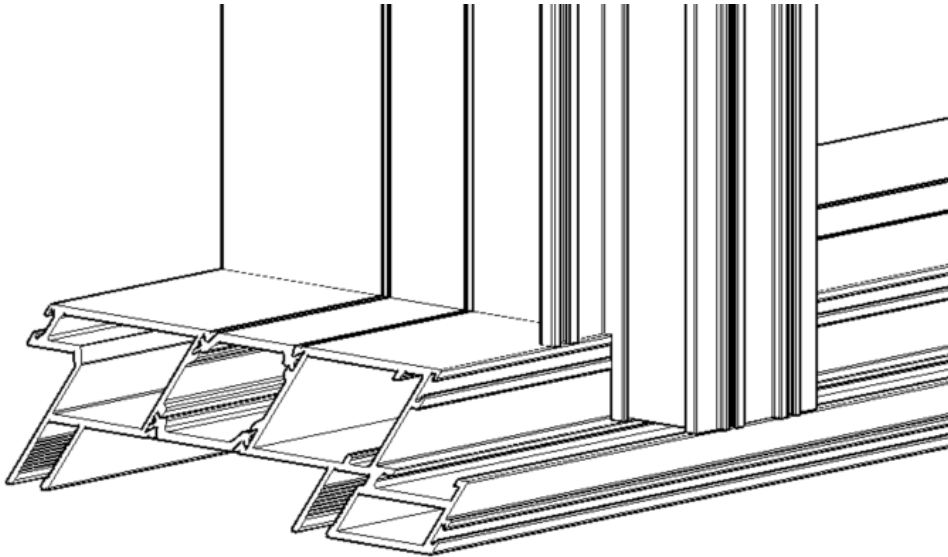
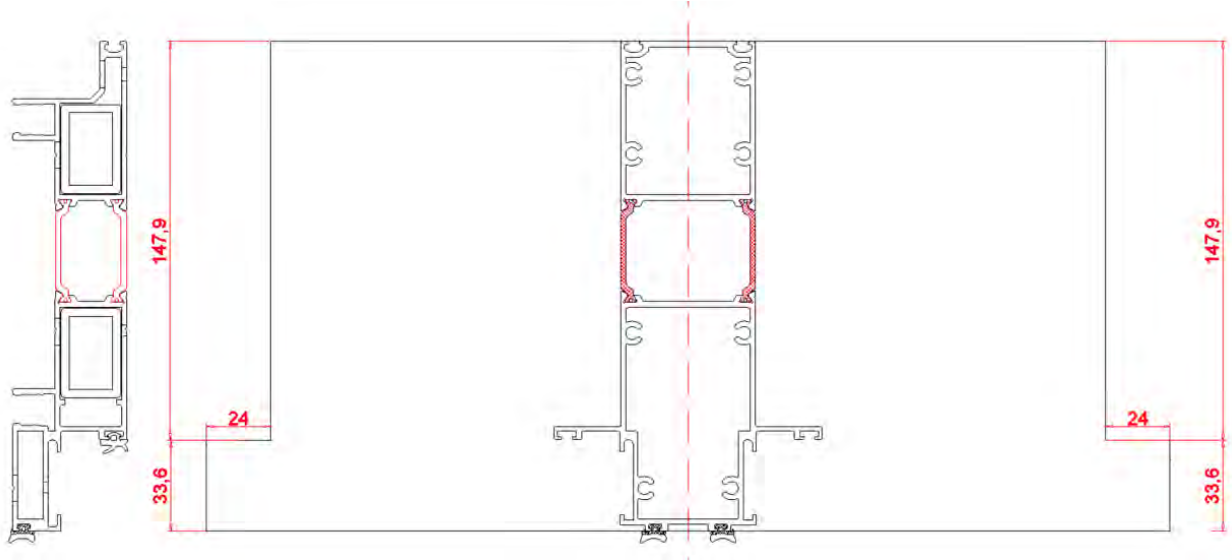
CUTTING OF FRAME AND T-PROFILE



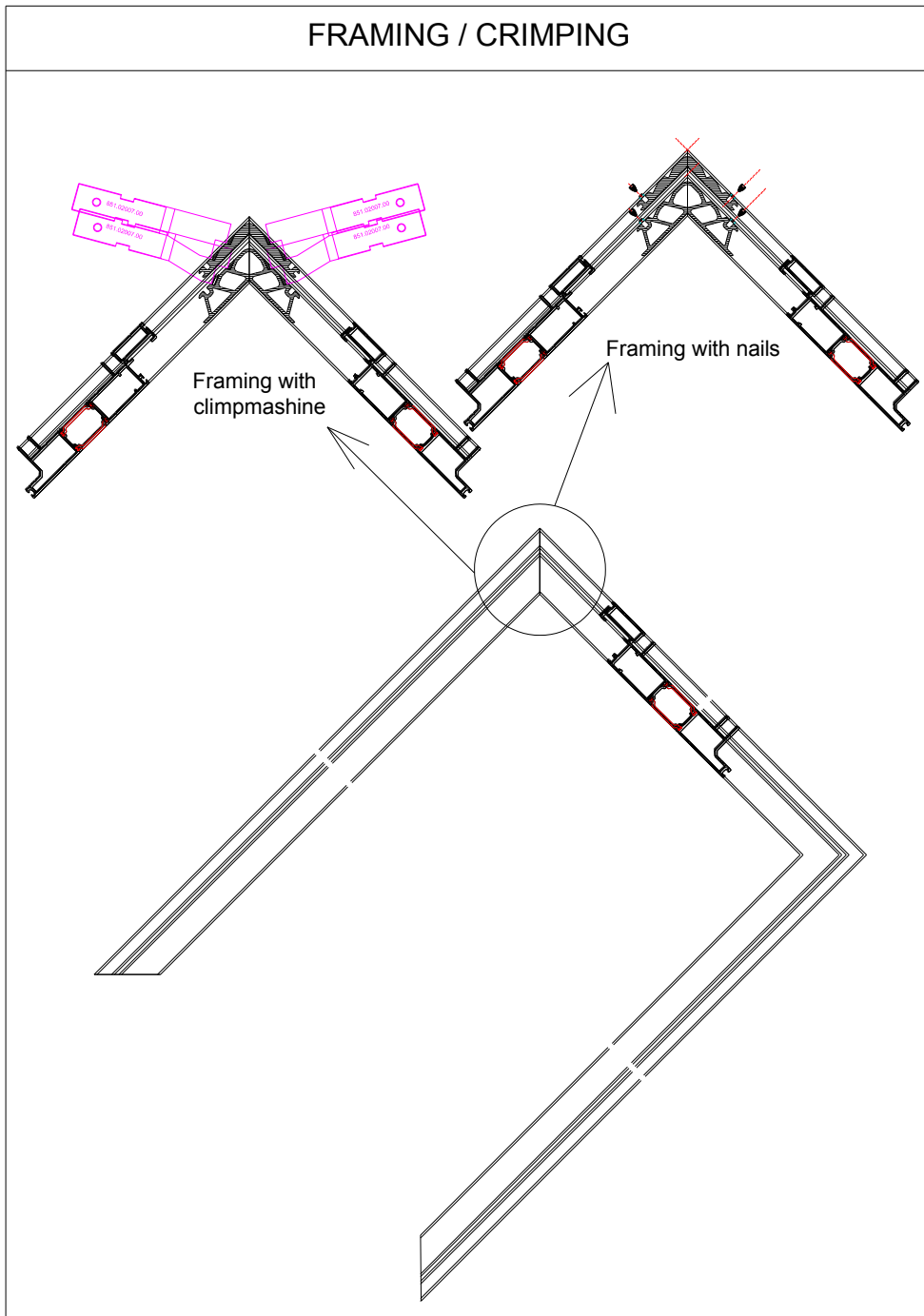
FRAME MILLING



T-PROFILE MILLING

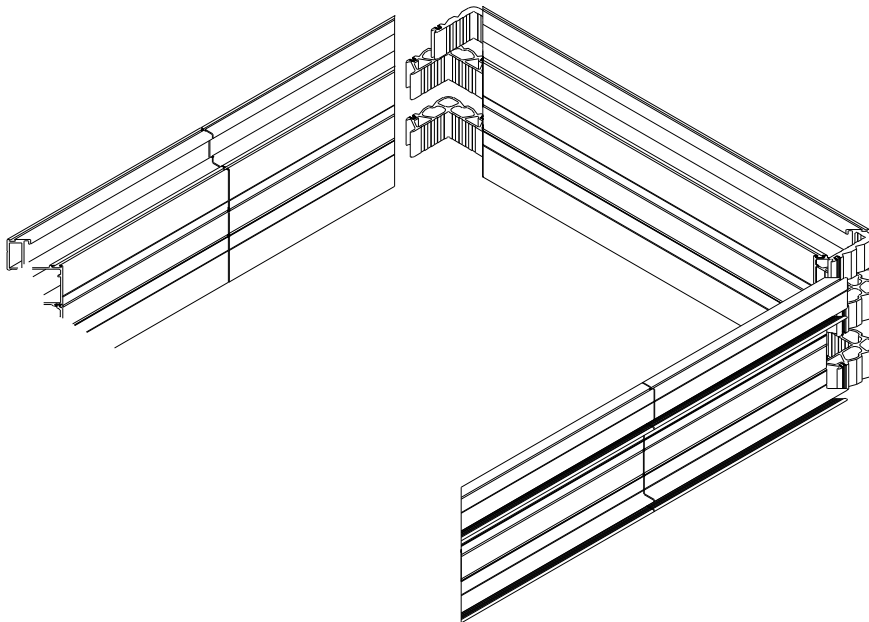
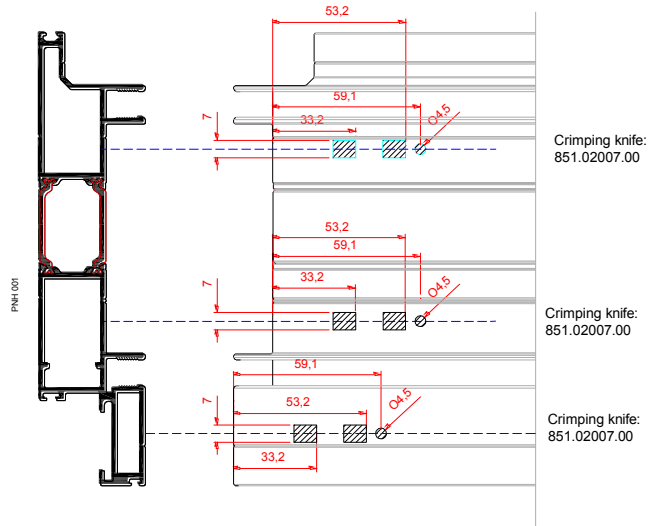


FRAMING

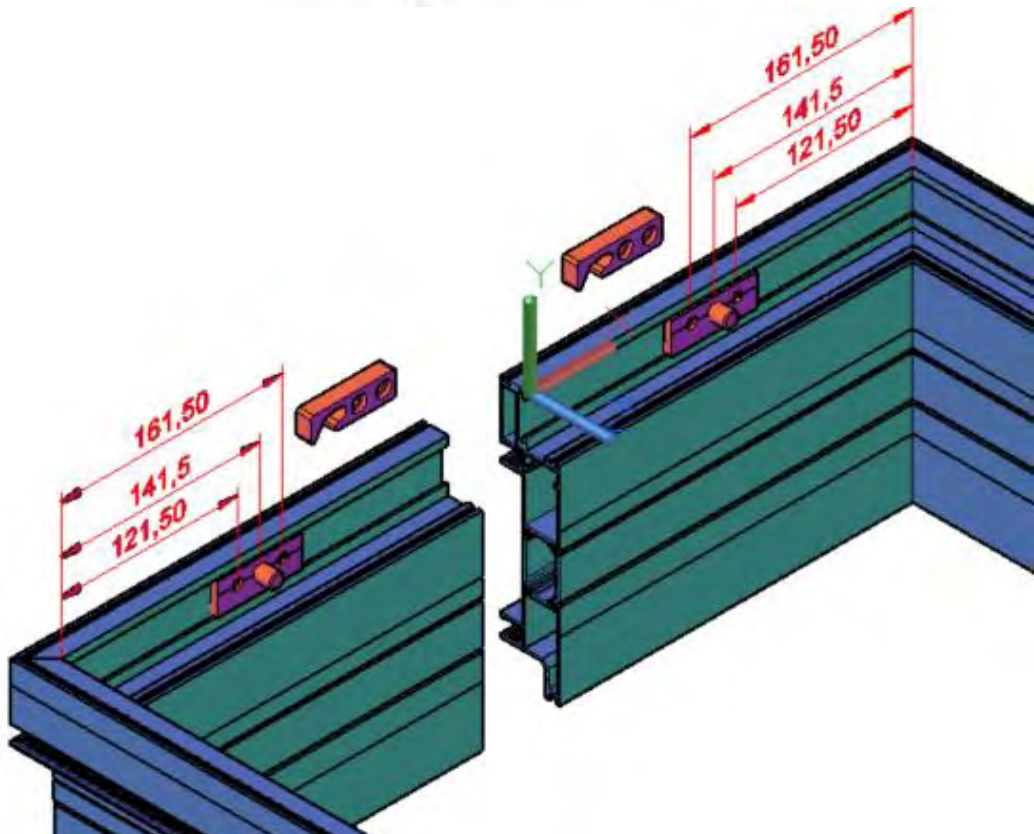
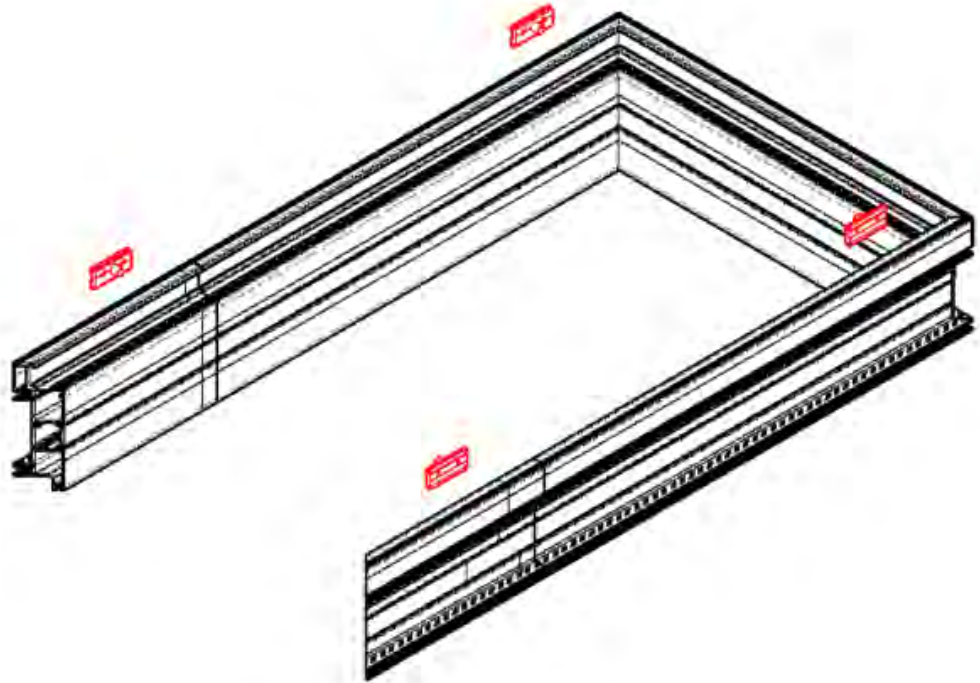


FRAMING

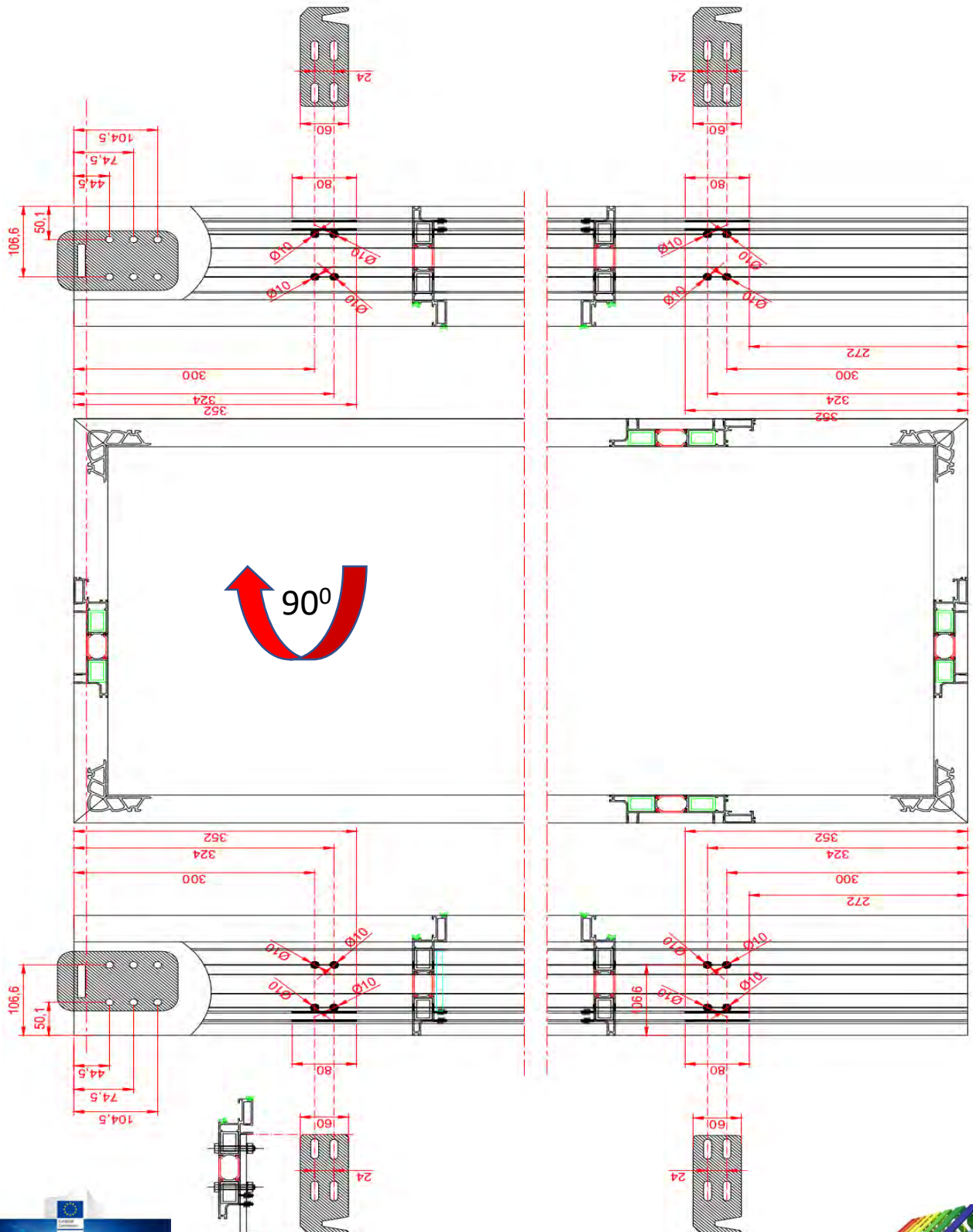
FRAME



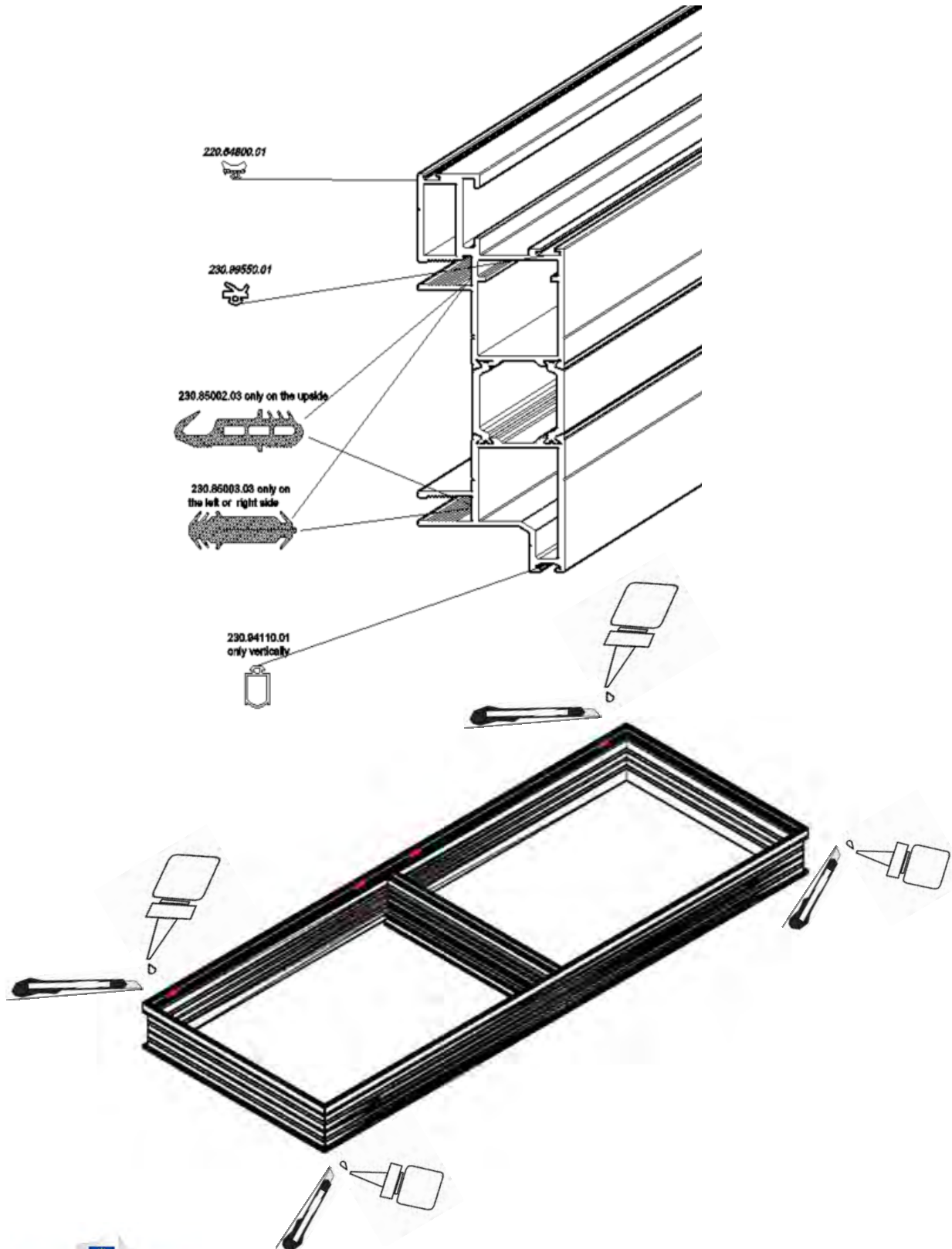
PIN INSTALLATION DETAIL



HOOK BRACKETS AND AND LIFTING PLATES INSTALLATION

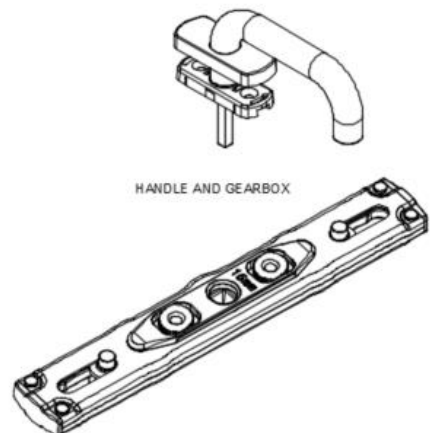
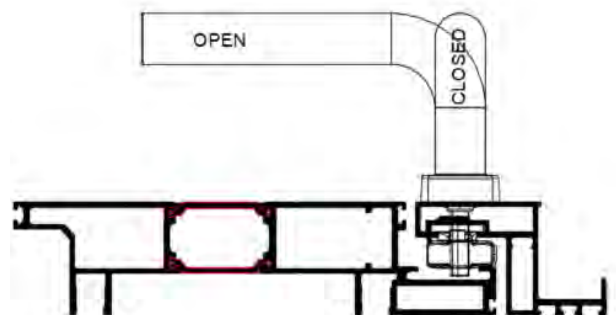
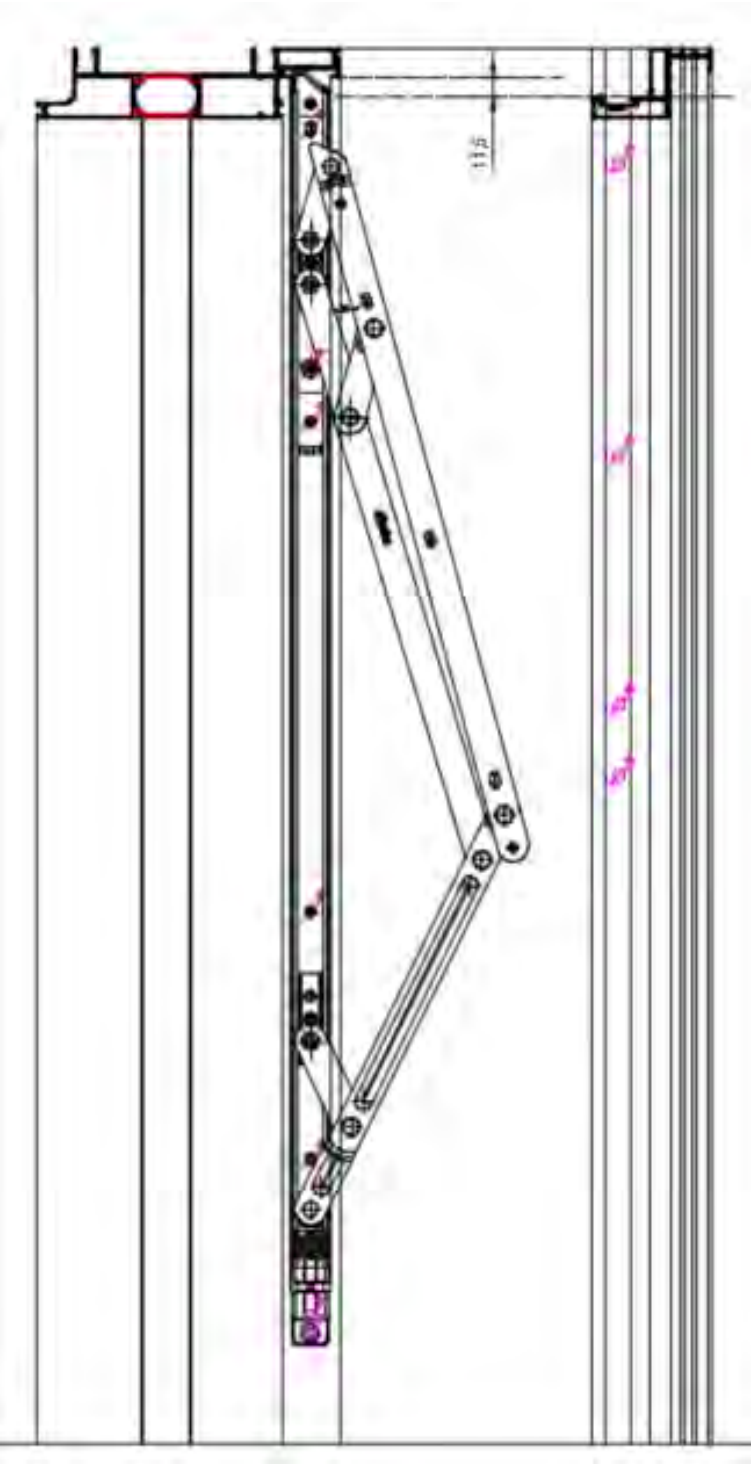


GASKET INSTALLATION

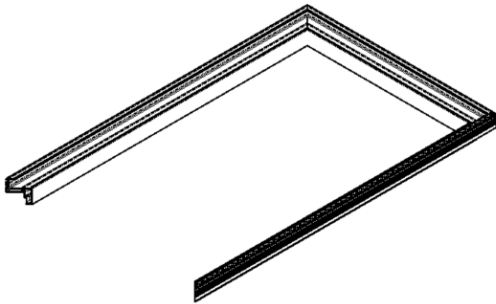


MILLING AND FRAMING

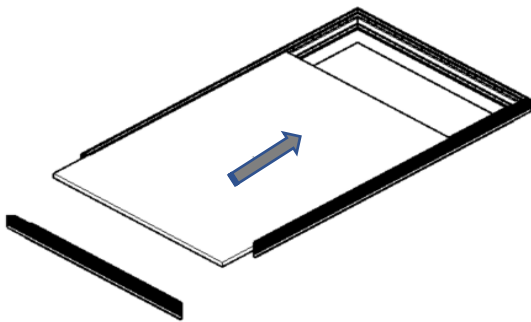
Top hung window,
Scissors and handle installation



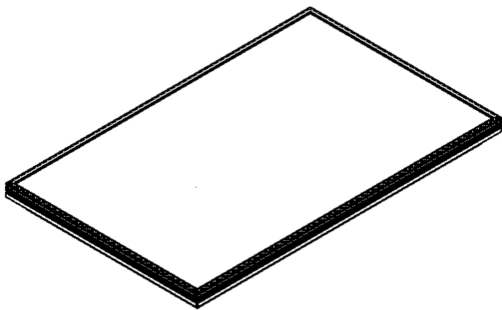
FABRICATION METHODOLOGY OF SASH PANEL



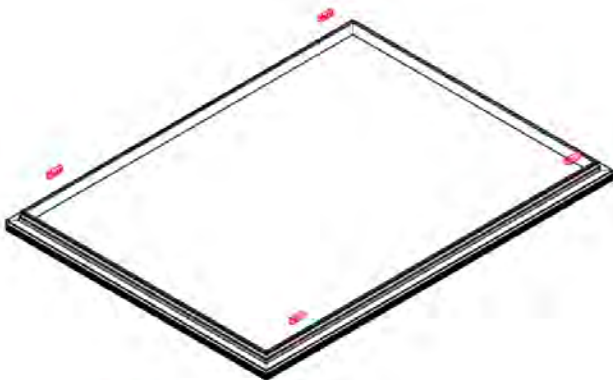
1. U-Shape creation



2. Glazing

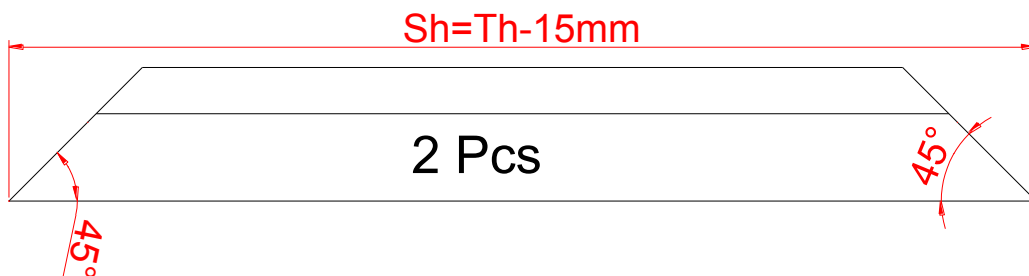
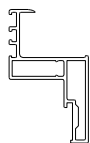
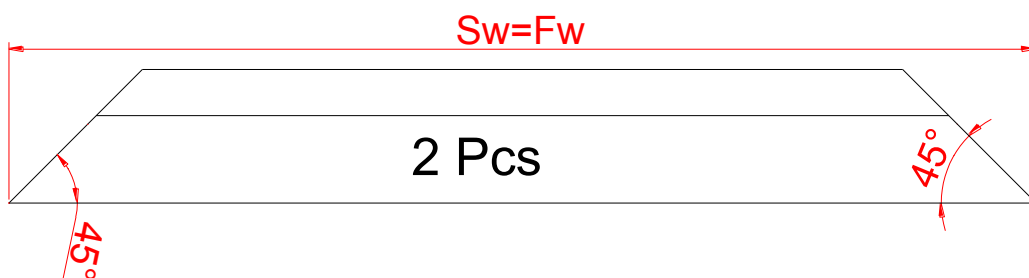
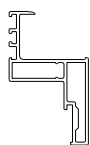
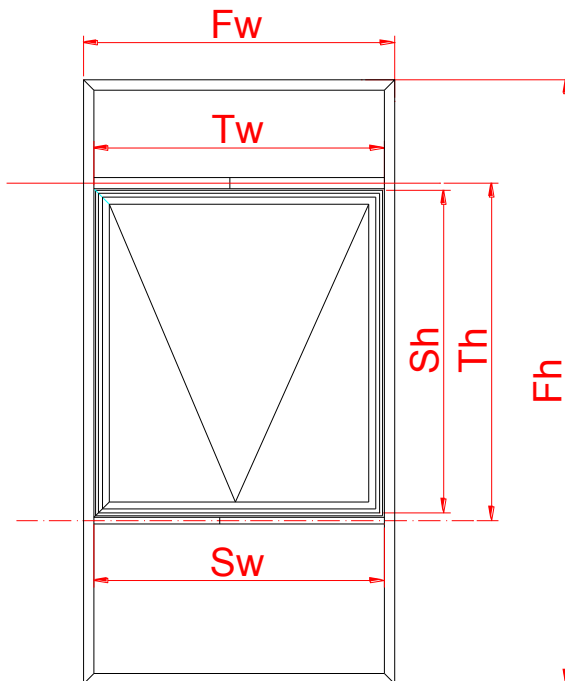


3. Frame completion



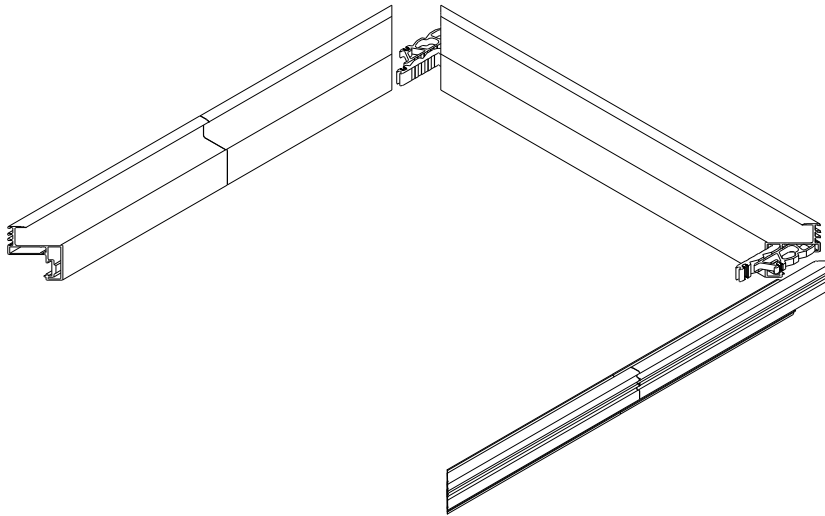
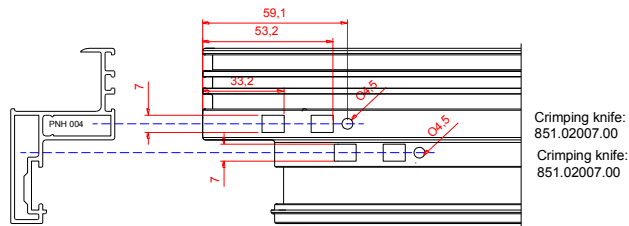
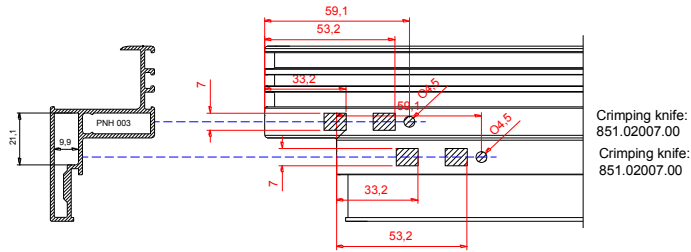
4. Hook installation

CUTTING OF SASH PROFILE

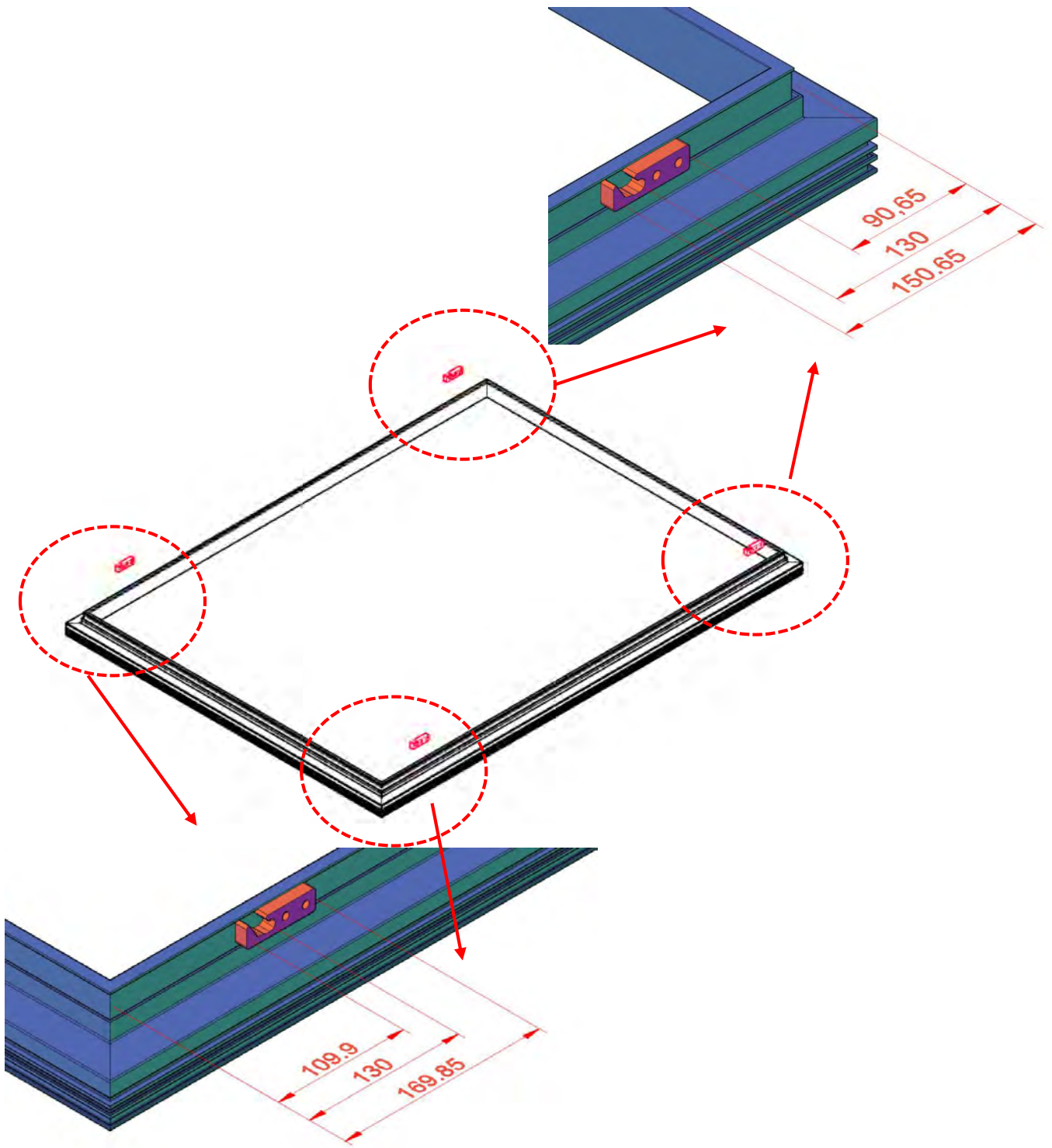


SASH FRAMING

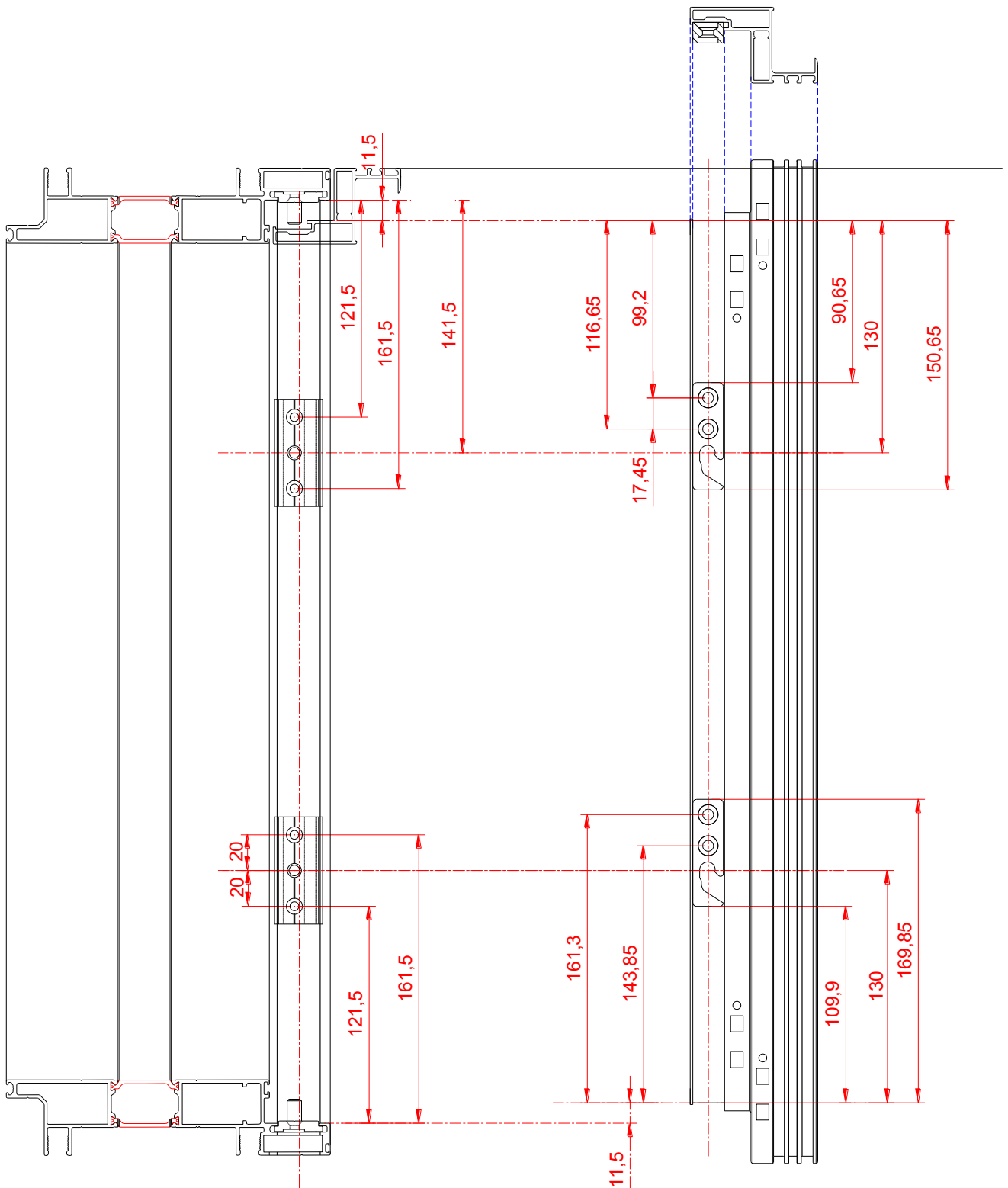
SASH



HOOK INSTALLATION

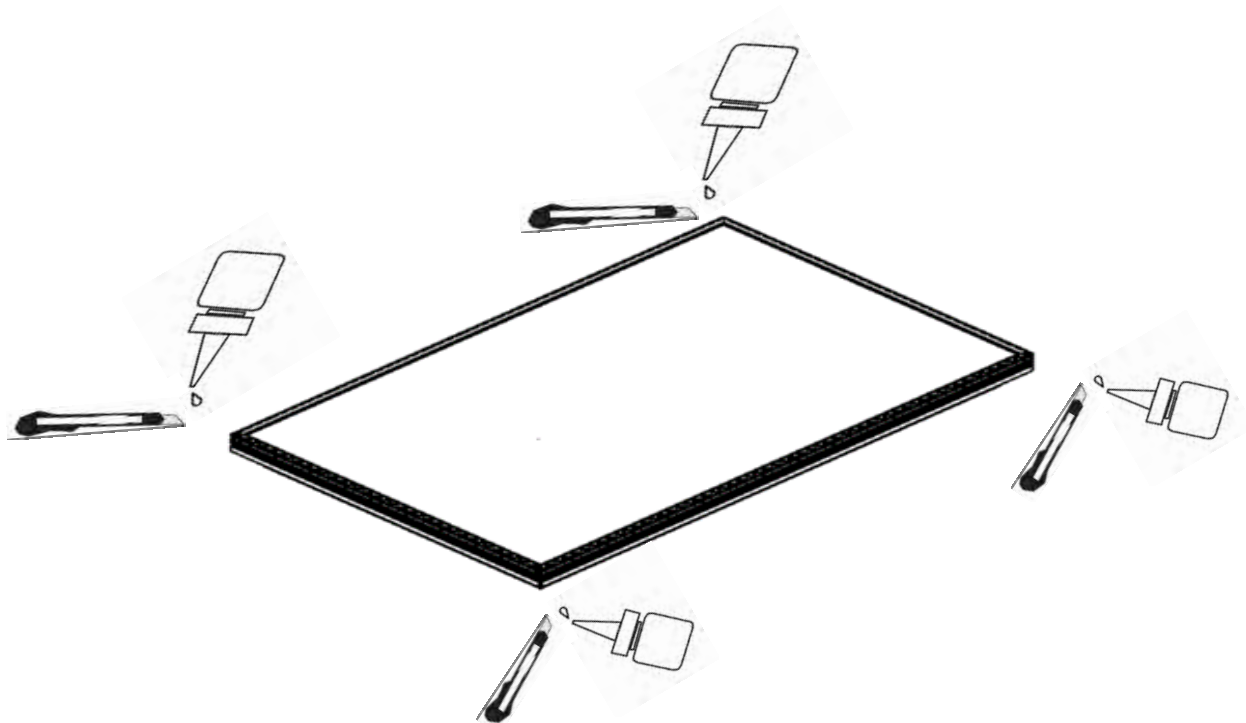
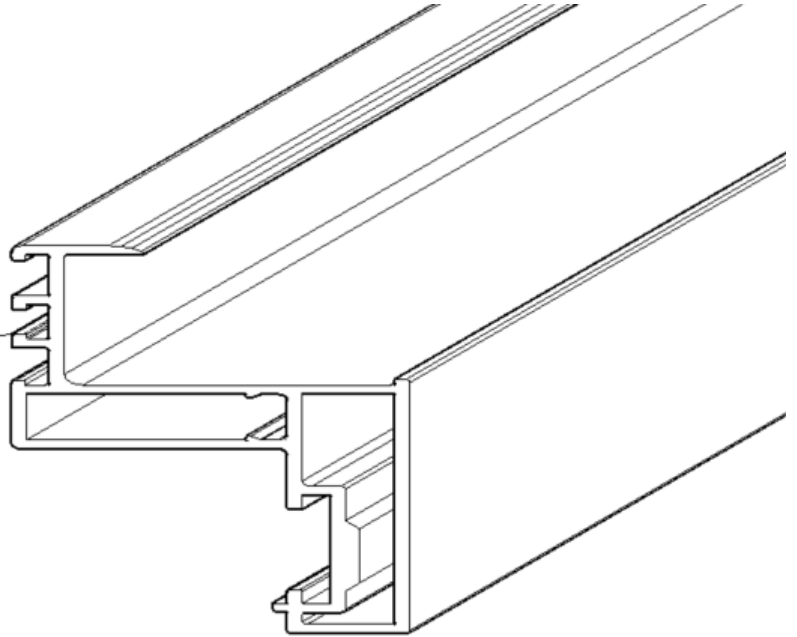


SASH HOOK INSTALLATION DETAIL

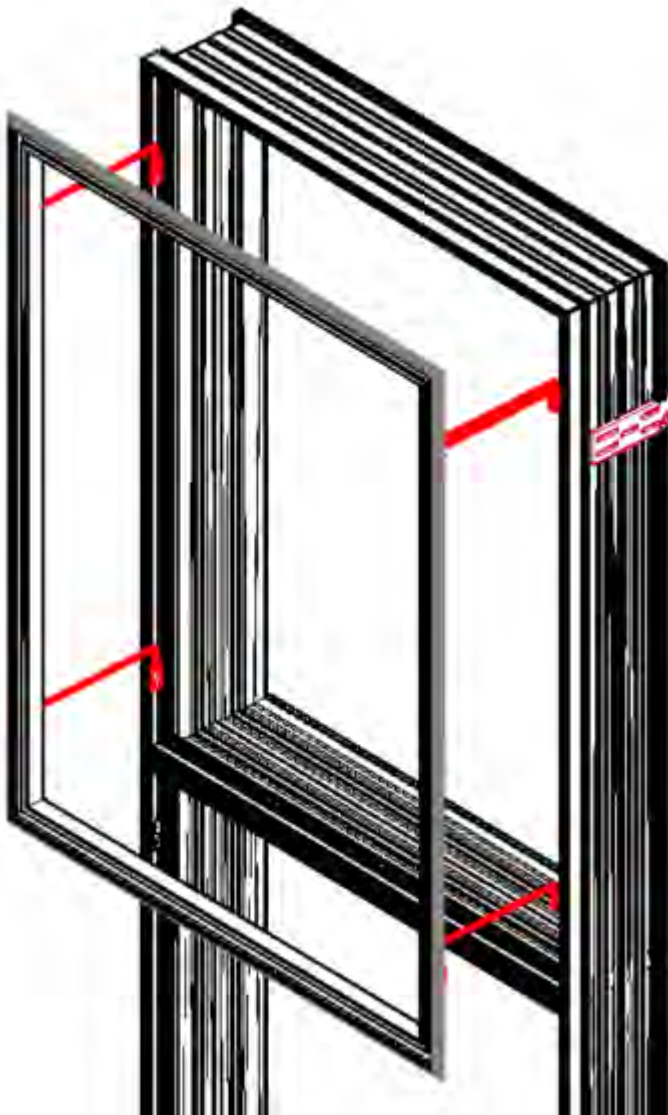


SASH GASKET INSTALLATION

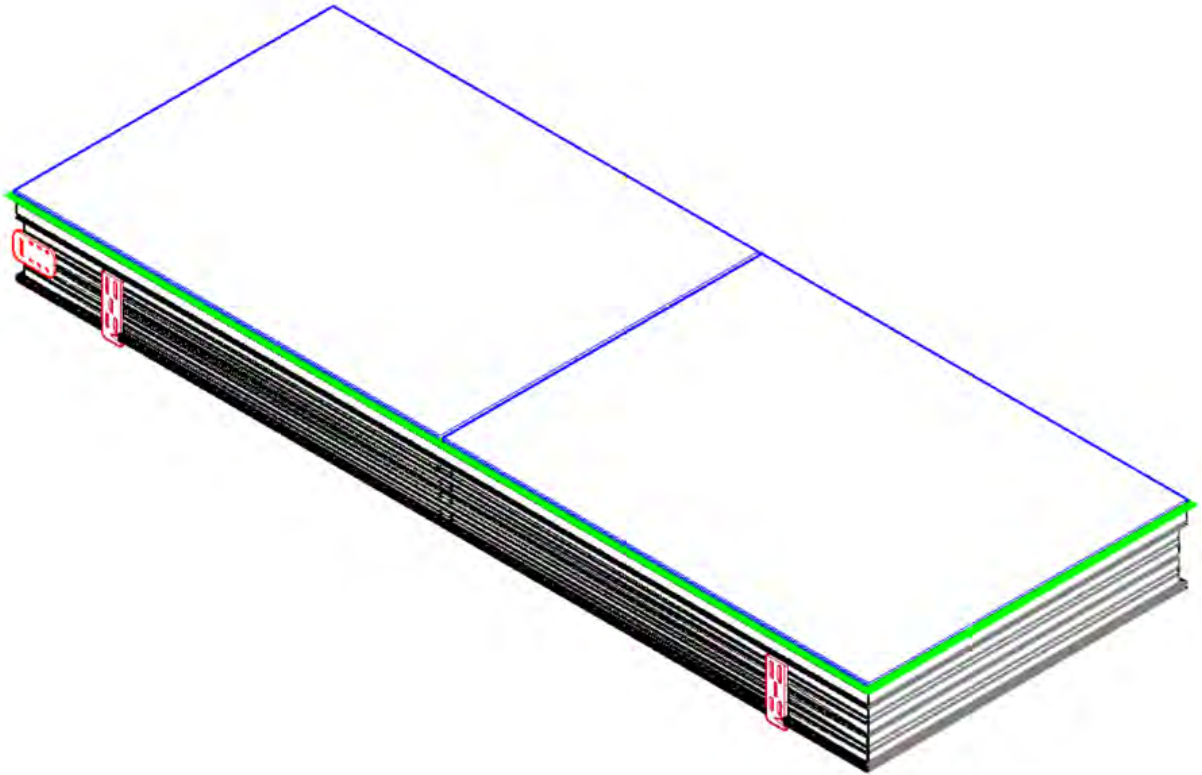
230.85001.03



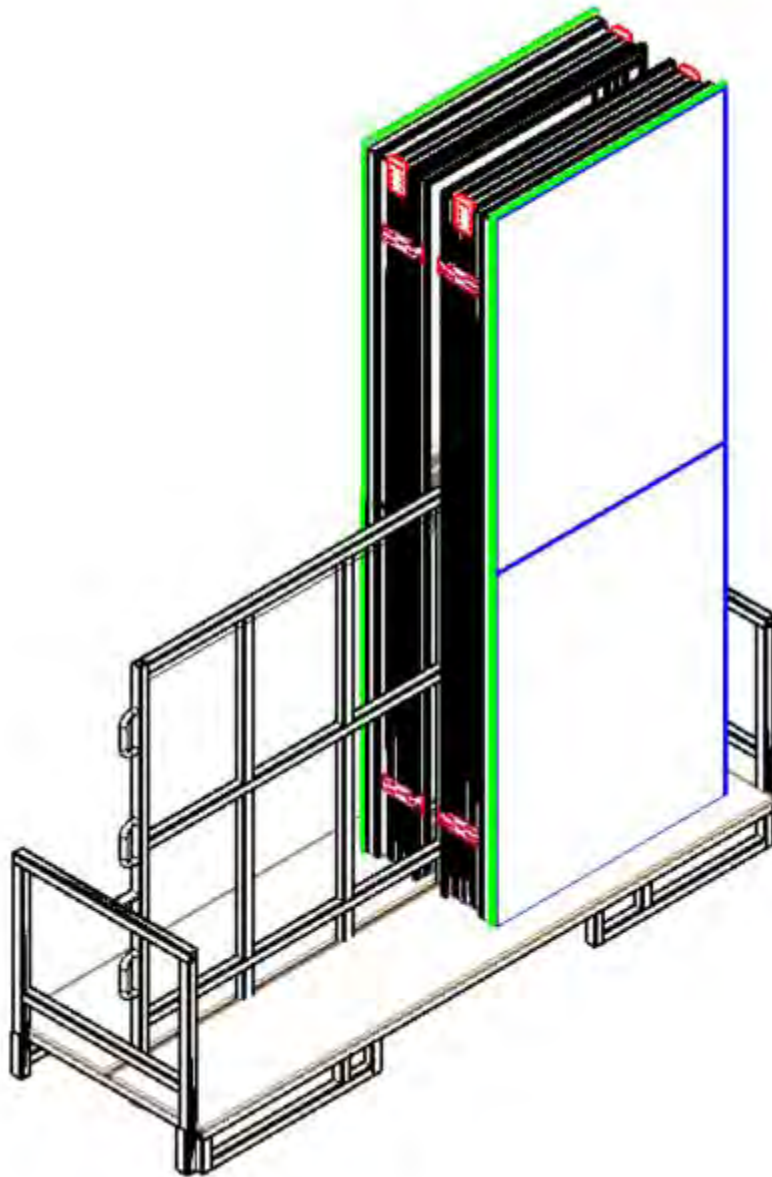
INSTALLATION OF SASH IN THE MAIN FRAME



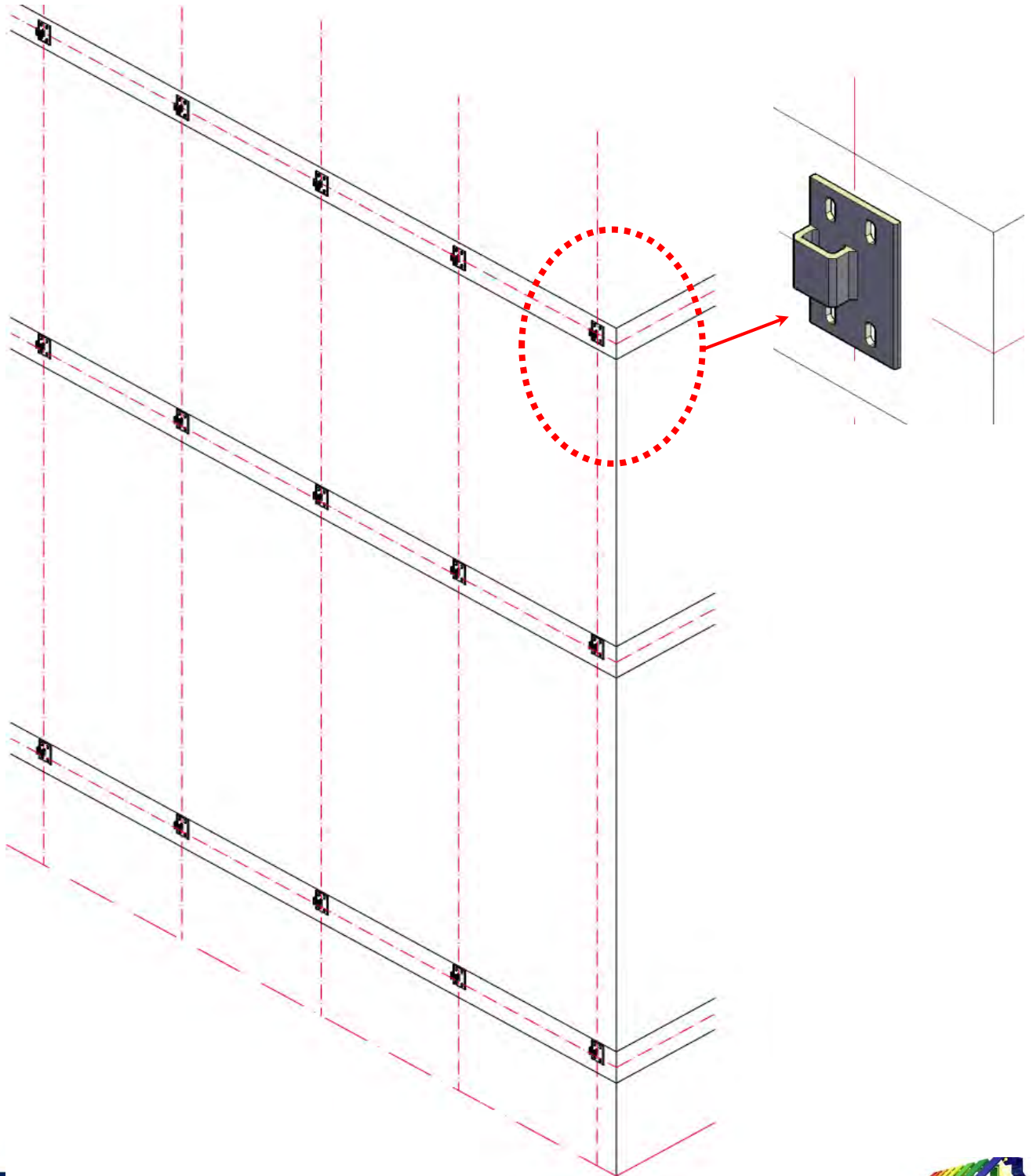
Finished Module



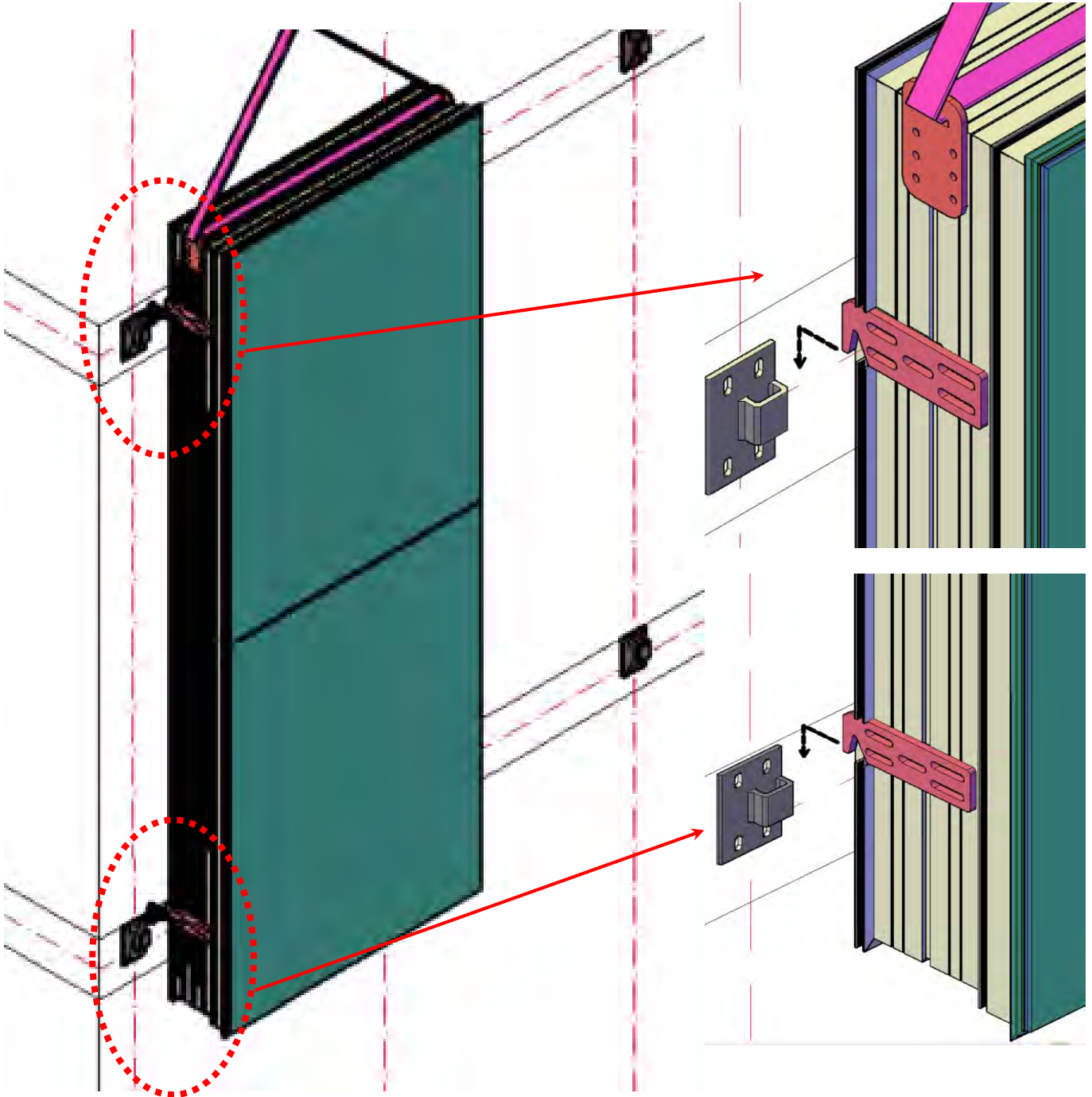
TRANSPORTATION



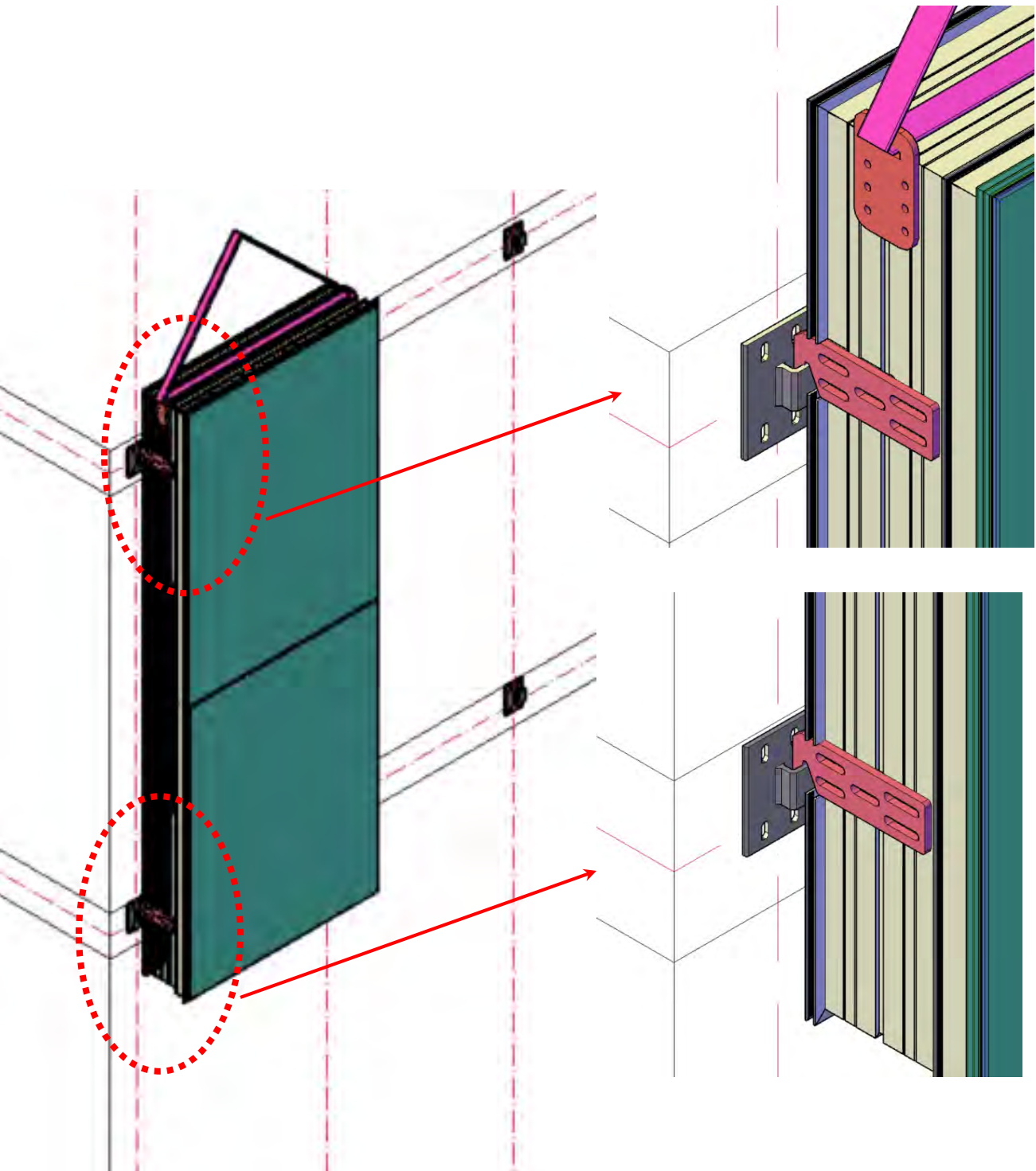
MODULE INSTALLATION ON TO BUILDING



MODULE INSTALLATION ON TO BUILDING



MODULE INSTALLATION ON TO BUILDING



MODULE INSTALLATION ON TO BUILDING

