

VISS SG

Verarbeitung und Montage

VISS SG

Usinage et montage

VISS SG

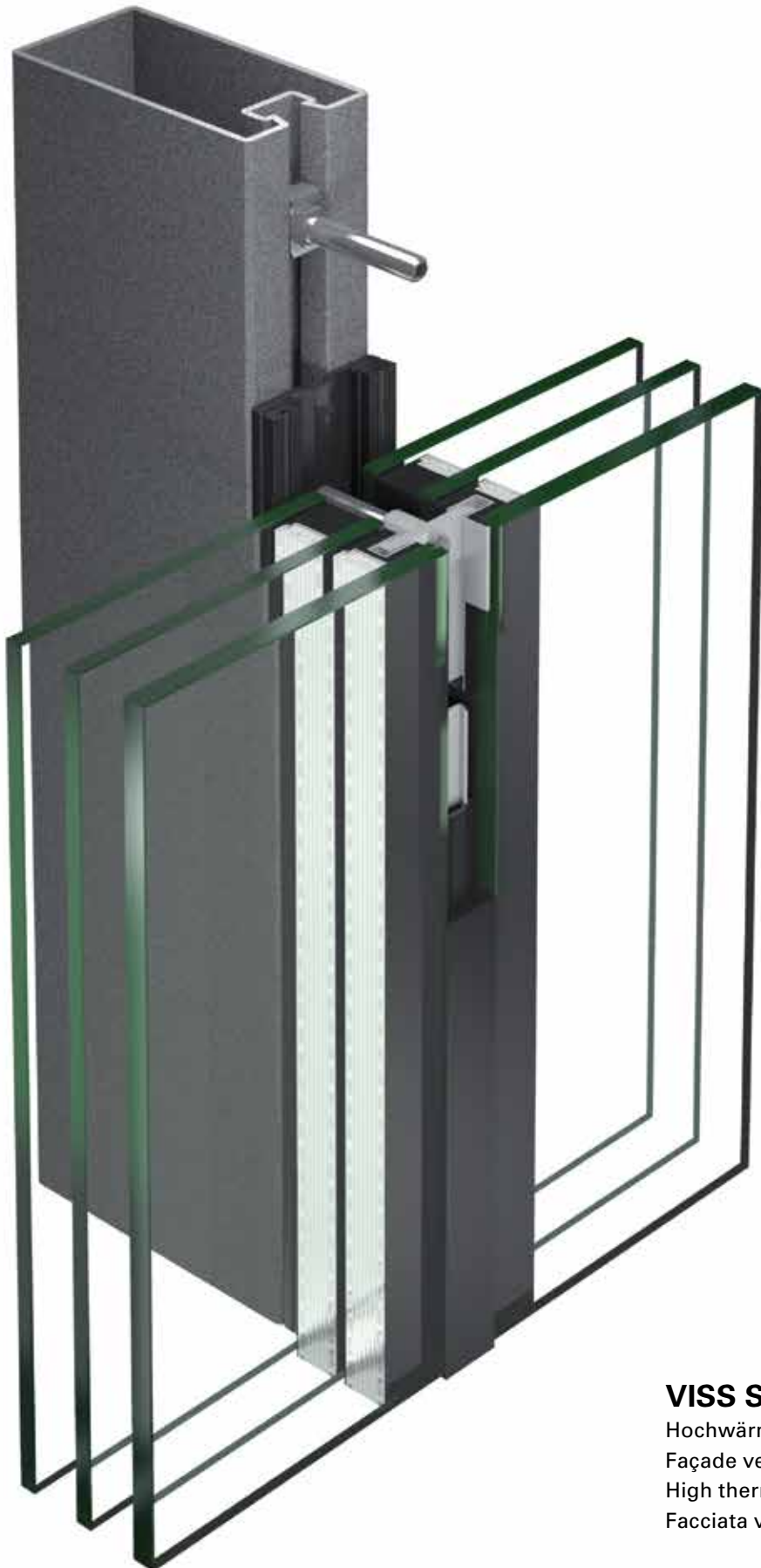
Processing and assembly

VISS SG

Lavorazione e montaggio

VISS SG
VISS SG
VISS SG
VISS SG

VISS SG Fassaden
VISS SG façades
VISS SG façades
VISS SG facciate



VISS SG

Hochwärmegedämmte Vertikalfassade
Façade verticale à haute rupture de pont thermique
High thermally insulated vertical façade
Facciata verticale con elevato isolamento termico

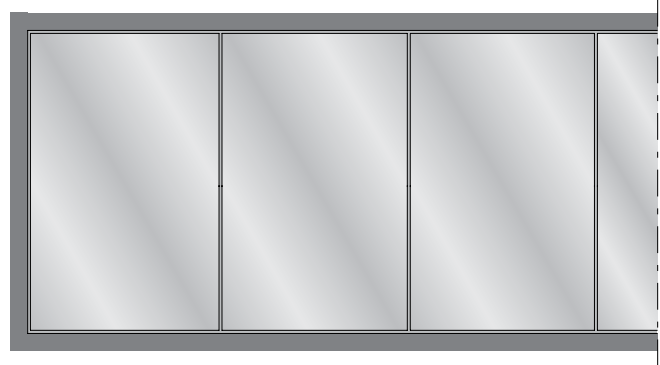
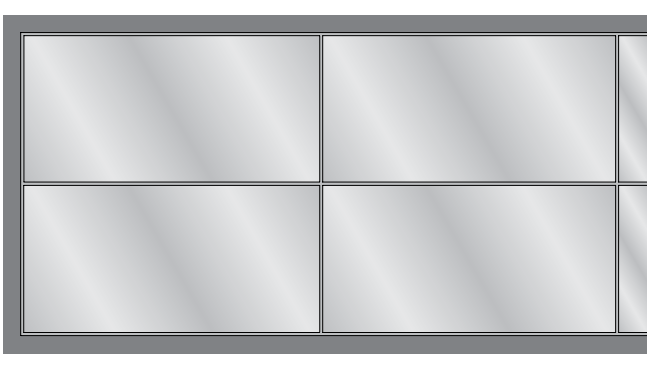
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All the information contained in this documentation is given to the best of our knowledge and ability. However, we decline all responsibility for the use made of these suggestions and data. Current version available at www.jansen.com

Abbiamo dedicato la massima cura alla preparazione della presente documentazione. Decliniamo tuttavia ogni responsabilità per l'uso delle proposte e dei dati da noi forniti. Versione corrente su www.jansen.com



In einzelnen Ländern (z.B. Deutschland oder Österreich) muss die äussere Scheibe von Ganzglasfassaden mechanisch gesichert werden. Für VISS SG stehen hierzu grundsätzlich diese beiden Varianten zur Verfügung.

Beide Verglasungen erfüllen die «Technischen Regeln für die Verwendung von absturzsichernden Verglasungen» (TRAV), wie sie in Deutschland gefordert ist.

Dans certains pays (par ex. Allemagne ou Autriche), il faut assurer un calage mécanique de la vitre extérieure de façades entièrement vitrées. Dans le cas de VISS SG, il existe à cet effet les deux variantes suivantes.

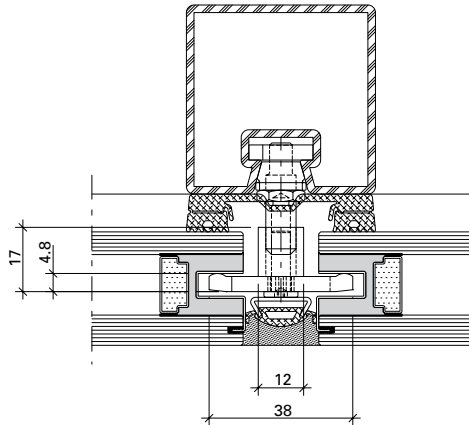
Les deux types de vitrage satisfont au «Règlement technique pour la sécurité anti-chute des vitrages» (TRAV), exigé en Allemagne.

In some countries (e.g. Germany and Austria) the exterior pane of all-glass facades must be secured mechanically. For VISS SG the following two options are available.

Both types of glazing fulfil the «Technical regulations for protecting glazing against falling out» (TRAV) required in Germany.

In alcuni paesi (es. Germania e Austria) la lastra esterna delle facciate interamente in vetro deve essere assicurata meccanicamente. Per VISS SG sono disponibili generalmente entrambe queste varianti.

Entrambe le vetrate soddisfano le «Regole tecniche per l'impiego di vetrate anticaduta» (TRAV), come richiesto in Germania.

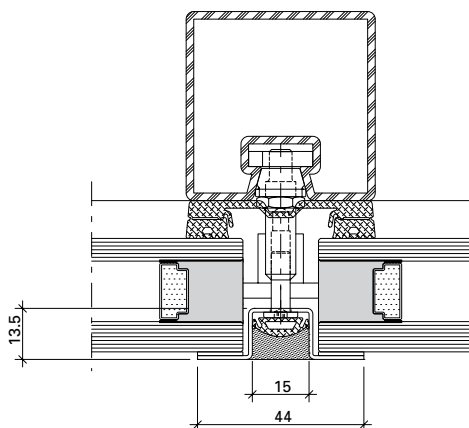


Sicherung der Aussenscheibe durch integrierte Nothalter mit VARIO DZ bzw. VARIO S-FOR. Vorteil dieser Lösung: die mechanische Sicherung ist praktisch unsichtbar.

Securing the exterior pane using integrated fastening devices with VARIO DZ or VARIO S-FOR. Advantage of this solution: the mechanical anchor is almost completely concealed.

Blocage de la vitre extérieure avec des cales de sécurité intégrées avec VARIO DZ ou VARIO S-FOR. L'avantage de cette solution est de rendre le calage mécanique pratiquement invisible.

Fissaggio della lastra esterna tramite ritegno di emergenza integrato con VARIO DZ o VARIO S-FOR. Vantaggio di questa soluzione: il dispositivo di fissaggio meccanico è praticamente invisibile.

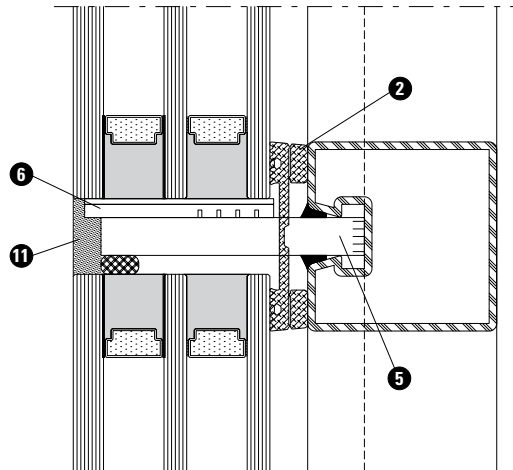
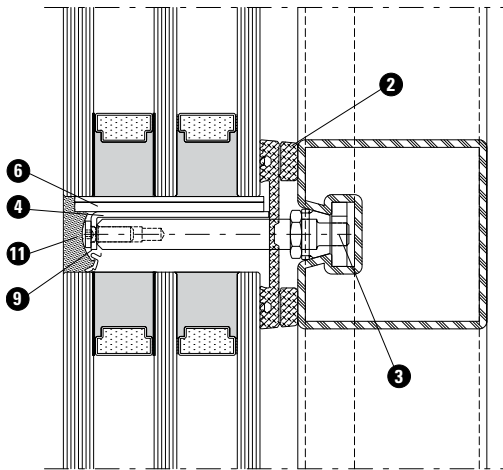
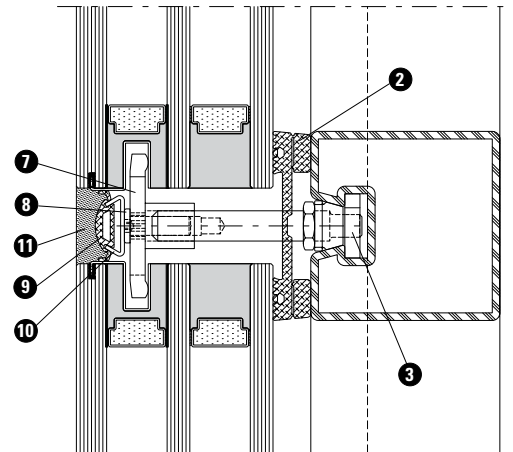
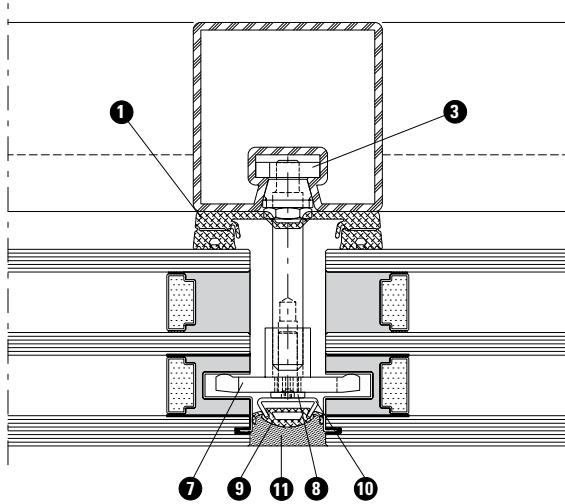


Sicherung der Aussenscheibe durch eine mechanische Aussenklammer in Verbindung mit VARIO II. Kostengünstige Alternative, wobei die mechanische Sicherung dezent sichtbar ist.

Securing the exterior pane using a mechanical external bracket in combination with VARIO II. An economical alternative; the elegant mechanical bracket is visible.

Blocage de la vitre extérieure avec une attache extérieure mécanique en association avec VARIO II. Alternative économique, le blocage mécanique se caractérisant par une visibilité discrète.

Fissaggio della lastra esterna tramite una clip meccanica esterna in combinazione con VARIO II. Alternativa più economica, dove il dispositivo di fissaggio meccanico è visibile ma discreto.



Pos. Artikel

- 1 Innendichtung vertikal
- 2 Innendichtung horizontal
- 3 Befestigungsanker
- 4 Glasauflager
- 5 Glasauflager (Sonderlösung)
- 6 Tragklotz
- 7 Glashalter
- 8 Schraube
- 9 Dichtung
- 10 Glasfalzprofil
- 11 Silikon

Pos. Article

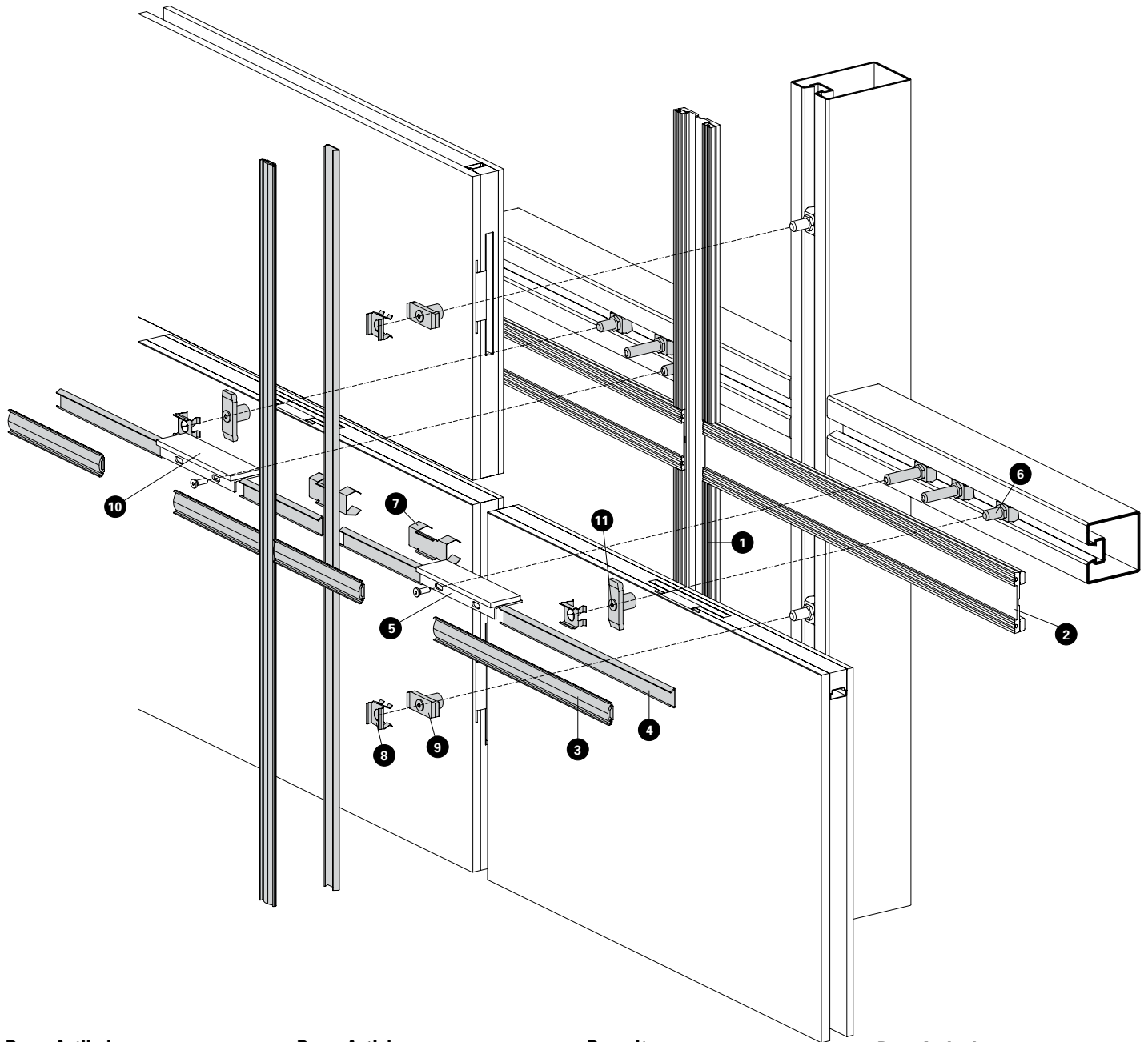
- 1 Joint intérieur vertical
- 2 Joint intérieur horizontal
- 3 Boulon-support
- 4 Support de verre
- 5 Support de verre (Solution spéciale)
- 6 Cale de remplissage
- 7 Clip de vitrage
- 8 Vis
- 9 Joint
- 10 Profilé de feuillure de verre
- 11 Silicone

Pos. Item

- 1 Inner gasket vertical
- 2 Inner gasket horizontal
- 3 Supporting bolt
- 4 Glazing support
- 5 Glazing support (Customised solution)
- 6 Glazing bridge
- 7 Fixing glazing clip
- 8 Screw
- 9 Weatherstrip
- 10 Glazing rebate profil
- 11 Silicone

Pos. Articolo

- 1 Guarnizione interna verticale
- 2 Guarnizione interna orizzontale
- 3 Bullone di supporto vetro
- 4 Supporto vetri
- 5 Supporto vetri (Soluzione speciale)
- 6 Blocco di supporto vetro
- 7 Pinza fermavetro
- 8 Vite
- 9 Guarnizione
- 10 Profilo d'appoggio
- 11 Silicone



Pos. Artikel	Pos. Article	Pos. Item	Pos. Articolo
1 Innendichtung vertikal	1 Joint intérieur vertical	1 Inner gasket vertical	1 Guarnizione interna verticale
2 Innendichtung horizontal	2 Joint intérieur horizontal	2 Inner gasket horizontal	2 Guarnizione interna orizzontale
3 Dichtung	3 Joint	3 Gasket	3 Guarnizione
4 Glasfalzprofil	4 Profilé de feuillure de verre	4 Glazing rebate profile	4 Profilo d'appoggio
5 Glasauflage	5 Support de verre	5 Glazing support	5 Blocco di supporto vetro
6 Befestigungsanker	6 Boulon d'ancrage	6 Fastening anchor	6 Bullone di supporto vetro
7 Befestigungsfeder Endbereich	7 Ressort de fixation zone terminale	7 Fixing spring for end area	7 Molla di fissaggio area terminale
8 Befestigungsfeder	8 Ressort de fixation	8 Fixing spring	8 Molla di fissaggio
9 Glashalter	9 Clip de vitrage	9 Fixing glazing clip	9 Pinza fermavetro
10 Glasklotz	10 Cale de vitrage	10 Glazing bridge	10 Blocco di supporto vetro
11 Schraube	11 Vis	11 Screw	11 Vite

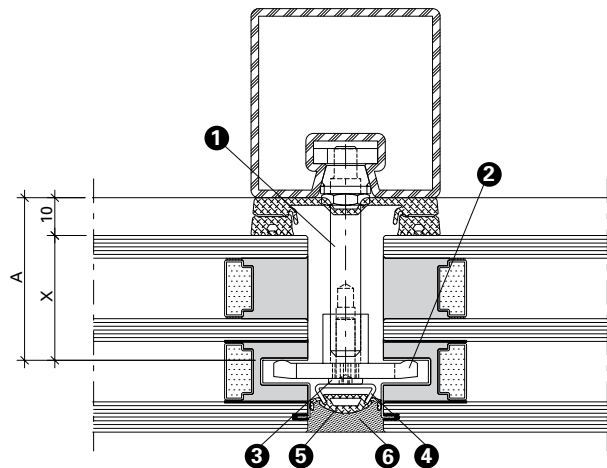
Artikel in Abhängigkeit der Füllelementstärke

Items depending on thickness of infill elements

Articles en fonction de l'éléments de remplissage

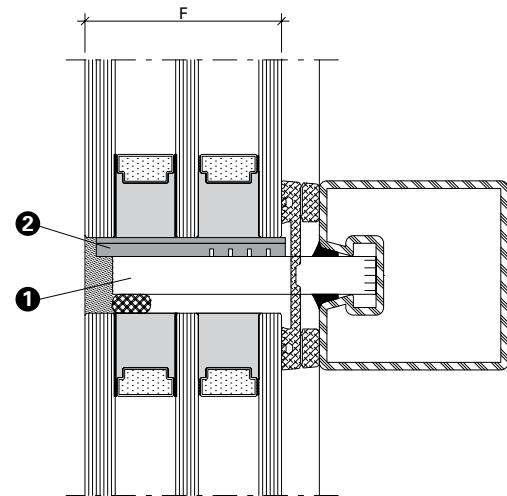
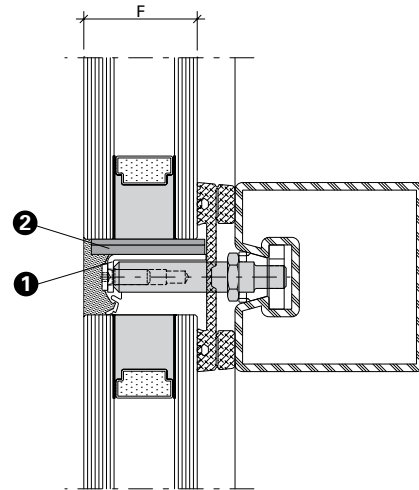
Articoli in funzione dello spessore degli elementi di riempimento

A mm	X mm	Befestigungsanker Boulon d'ancrage Fastening anchor Bullone di supporto vetro
21	11	452.434
22	12	452.162
23	13	
24	14	
25	15	
26	16	
27	17	452.435
28	18	
29	19	
30	20	
31	21	
32	22	
33	23	452.436
34	24	
35	25	
36	26	
37	27	
38	28	452.437
39	29	
40	30	
41	31	
42	32	
43	33	
44	34	
45	35	
46	36	
47	37	
48	38	452.423
49	39	
50	40	
51	41	
52	42	
53	43	452.424
54	44	
55	45	
56	46	
57	47	



- 1 Befestigungsanker
 - 2 Glashalter (452.165/166)
 - 3 Schraube M5x16 (452.433)
 - 4 Glasfalzprofil (400.856)
 - 5 Dichtung (455.989)
 - 6 Silikon (z.B. Dow Corning 791)
-
- 1 Boulon d'ancrage
 - 2 Clip de vitrage (452.165/166)
 - 3 Vis M5x16 (452.433)
 - 4 Profilé de feuillure de verre (400.856)
 - 5 Joint (455.989)
 - 6 Silicon (p.ex. Dow Corning 791)
-
- 1 Fastening anchor
 - 2 Fixing glazing clip (452.165/166)
 - 3 Screw M5x16 (452.433)
 - 4 Glazing rebate profile (400.856)
 - 5 Gasket (455.989)
 - 6 Silicon (e.g. Dow Corning 791)
-
- 1 Bullone di supporto vetro
 - 2 Pinza fermavetro (452.165/166)
 - 3 Vite M5x16 (452.433)
 - 4 Profilo d'appoggio (400.856)
 - 5 Guarnizione (455.989)
 - 6 Silicone (p.es. Dow Corning 791)

F mm	Glasauflage Support de verre Glazing support Supporto vetri	1	Glasklotz Cale de vitrage Glazing bridge Blocco di supporto vetro	2
30 31 32	452.560		453.050	
33 34 35	452.561		453.050	
36 37 38	452.562		453.050	
39 40 41	452.563		453.050	
42 43 44	452.564		453.050	
45 46 47	452.565		453.050	
48 49 50	452.566		453.050	
51 52 53 54	452.567		453.051	
55 56 57	452.568		453.051	
58 59 60	452.569		453.051	
30 - 50	Flachstahl Fer plat Flat steel Piastra in acciaio		453.052	
51 - 70	Flachstahl Fer plat Flat steel Piastra in acciaio		453.053	



1



Die äussere Scheibe muss mindestens 2/3 ihrer Dicke durch den Glasklotz gestützt werden.

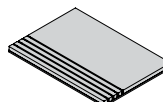
Au moins 2/3 de l'épaisseur de la vitre extérieure doivent être étayés par une cale de vitrage.

The outer pane must be supported over a minimum of two-thirds of its thickness by the glazing bridge.

1



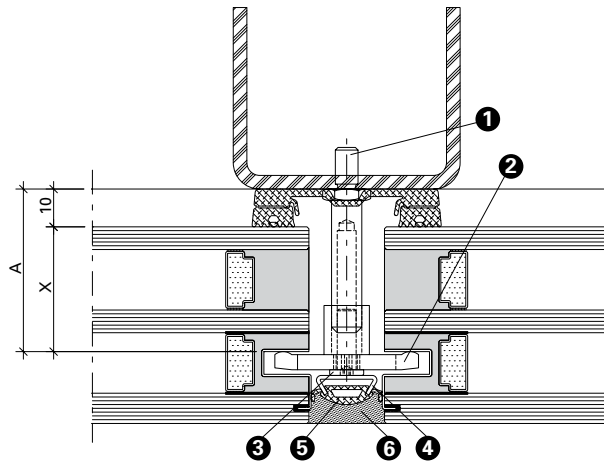
2



La lastra esterna del vetro isolato deve appoggiare minimo 2/3 sul supporto vetro.

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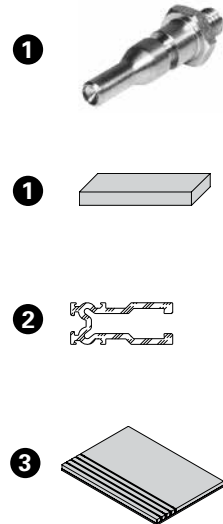
A mm	X mm	Schraubbolzen Goujon à visser Screw bolt Bullone filettato
21 22	11 12	452.512
23 24 25 26 27	13 14 15 16 17	452.513
28 29 30 31 32 33	18 19 20 21 22 23	452.514
34 35 36 37 38	24 25 26 27 28	452.515
39 40 41 42 43	29 30 31 32 33	452.511
44 45 46 47 48	34 35 36 37 38	452.516
49 50 51 52 53	39 40 41 42 43	452.420
54 55 56 57 58	44 45 46 47 48	452.517



- | | | | |
|---|--------------------------------|---|---|
| 1 | Schraubbolzen | 1 | Goujon à visser |
| 2 | Glashalter (452.165/166) | 2 | Clip de vitrage (452.165/166) |
| 3 | Schraube M5x16 (452.433) | 3 | Vis M5x16 (452.433) |
| 4 | Glasfalzprofil (400.856) | 4 | Profilé de feuillure de verre (400.856) |
| 5 | Dichtung (455.989) | 5 | Joint (455.989) |
| 6 | Silikon (z.B. Dow Corning 791) | 6 | Silicon (p.ex. Dow Corning 791) |
-
- | | | | |
|---|-----------------------------------|---|----------------------------------|
| 1 | Screw bolt | 1 | Bullone filettato |
| 2 | Fixing glazing clip (452.165/166) | 2 | Pinza fermavetro (452.165/166) |
| 3 | Screw M5x16 (452.433) | 3 | Vite M5x16 (452.433) |
| 4 | Glazing rebate profile (400.856) | 4 | Profilo d'appoggio (400.856) |
| 5 | Gasket (455.989) | 5 | Guarnizione (455.989) |
| 6 | Silicon (e.g. Dow Corning 791) | 6 | Silicone (p.es. Dow Corning 791) |

VISS Basic SG

F mm	Schraub-Traganker Boulon-support à visser Screw support bolt Bullone di supporto filettato ①	Falzprofil Profilé de feuillure Rebate section Profilo d'appoggio ②	Glasklotz Cale de vitrage Glazing bridge Blocco di supporto vetro ③
30 31 32 33	452.521	407.812	453.052
34 35 36 37 38	452.521	407.813	453.052
39 40 41 42	452.521	407.814	453.052
30 - 50	Flachstahl Fer plat Flat steel Piastra in acciaio		453.052
51 - 70	Flachstahl Fer plat Flat steel Piastra in acciaio		453.053

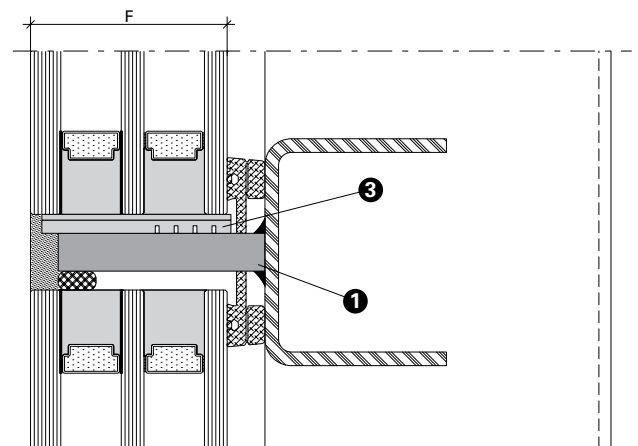
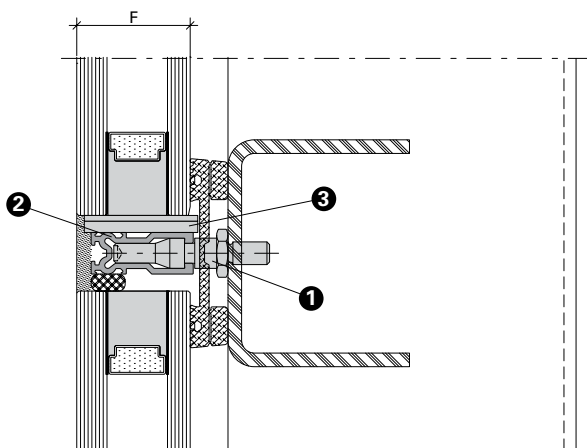


Die äussere Scheibe muss mindestens 2/3 ihrer Dicke durch den Glasklotz gestützt werden.

Au moins 2/3 de l'épaisseur de la vitre extérieure doivent être étayés par une cale de vitrage.

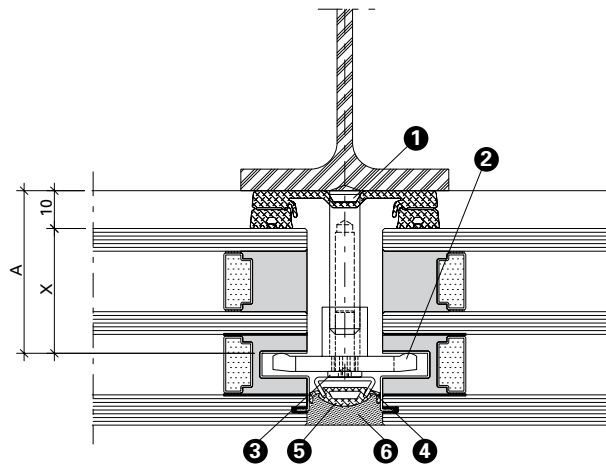
The outer pane must be supported over a minimum of two-thirds of its thickness by the glazing bridge.

La lastra esterna del vetro isolato deve appoggiare minimo 2/3 sul supporto vetro.



VISS Basic SG

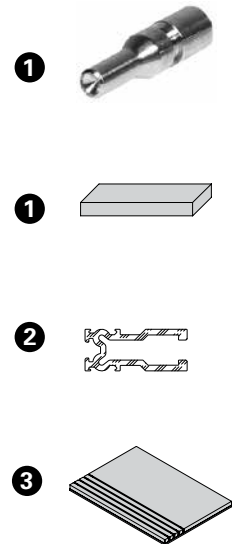
A mm	X mm	Schweissbolzen Goujon à souder Welding stud Bullone a saldare
21 22	11 12	452.500
23 24 25 26 27	13 14 15 16 17	452.501
28 29 30 31 32 33	18 19 20 21 22 23	452.502
34 35 36 37 38	24 25 26 27 28	452.503
39 40 41 42 43	29 30 31 32 33	452.510
44 45 46 47 48	34 35 36 37 38	452.504
49 50 51 52 53	39 40 41 42 43	452.417
54 55 56 57 58	44 45 46 47 48	452.505



- | | |
|---|--|
| <ol style="list-style-type: none"> 1 Schweissbolzen 2 Glashalter (452.165/166) 3 Schraube M5x16 (452.433) 4 Glasfalzprofil (400.856) 5 Dichtung (455.989) 6 Silikon (z.B. Dow Corning 791) | <ol style="list-style-type: none"> 1 Goujon à souder 2 Clip de vitrage (452.165/166) 3 Vis M5x16 (452.433) 4 Profilé de feuillure de verre (400.856) 5 Joint (455.989) 6 Silicon (p.ex. Dow Corning 791) |
| <ol style="list-style-type: none"> 1 Welding stud 2 Fixing glazing clip (452.165/166) 3 Screw M5x16 (452.433) 4 Glazing rebate profile in stainless steel (400.856) 5 Gasket (455.989) 6 Silicon (e.g. Dow Corning 791) | <ol style="list-style-type: none"> 1 Bullone a saldare 2 Pinza fermavetro (452.165/166) 3 Vite M5x16 (452.433) 4 Profilo d'appoggio (400.856) 5 Guarnizione (455.989) 6 Silicone (p.es. Dow Corning 791) |

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F mm	Schweiss-Traganker Boulon-support à souder Welding support bolt Bullone di supporto a saldare	Falzprofil Profilé de feuillure Rebate section Profilo d'appoggio	Glasklotz Cale de vitrage Glazing bridge Blocco di supporto vetro
30 31 32 33	452.509	407.812	453.052
34 35 36 37 38	452.509	407.813	453.052
39 40 41 42	452.509	407.814	453.052
30 - 50	Flachstahl Fer plat Flat steel Piastra in acciaio		453.052
51 - 70	Flachstahl Fer plat Flat steel Piastra in acciaio		453.053

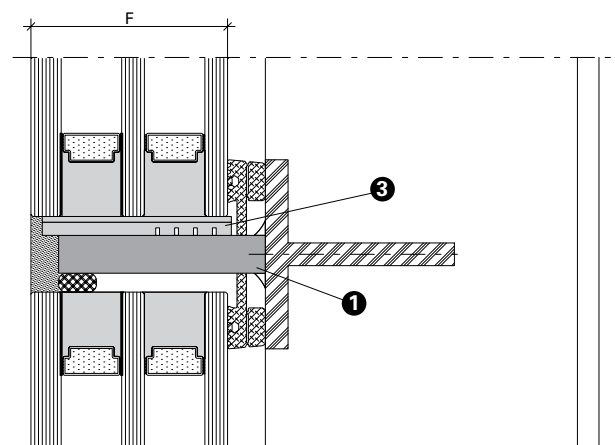
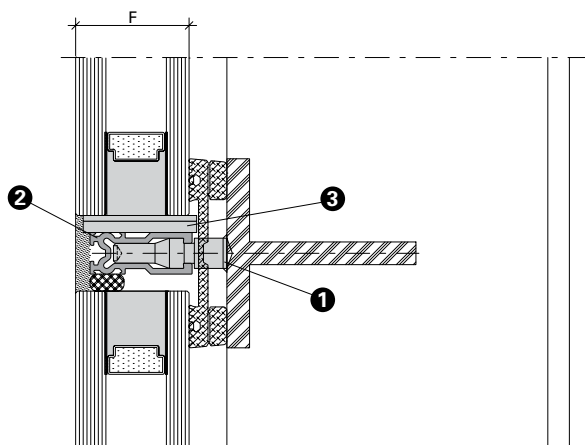


Die äussere Scheibe muss mindestens 2/3 ihrer Dicke durch den Glasklotz gestützt werden.

Au moins 2/3 de l'épaisseur de la vitre extérieure doivent être étayés par une cale de vitrage.

The outer pane must be supported over a minimum of two-thirds of its thickness by the glazing bridge.

La lastra esterna del vetro isolato deve appoggiare minimo 2/3 sul supporto vetro.

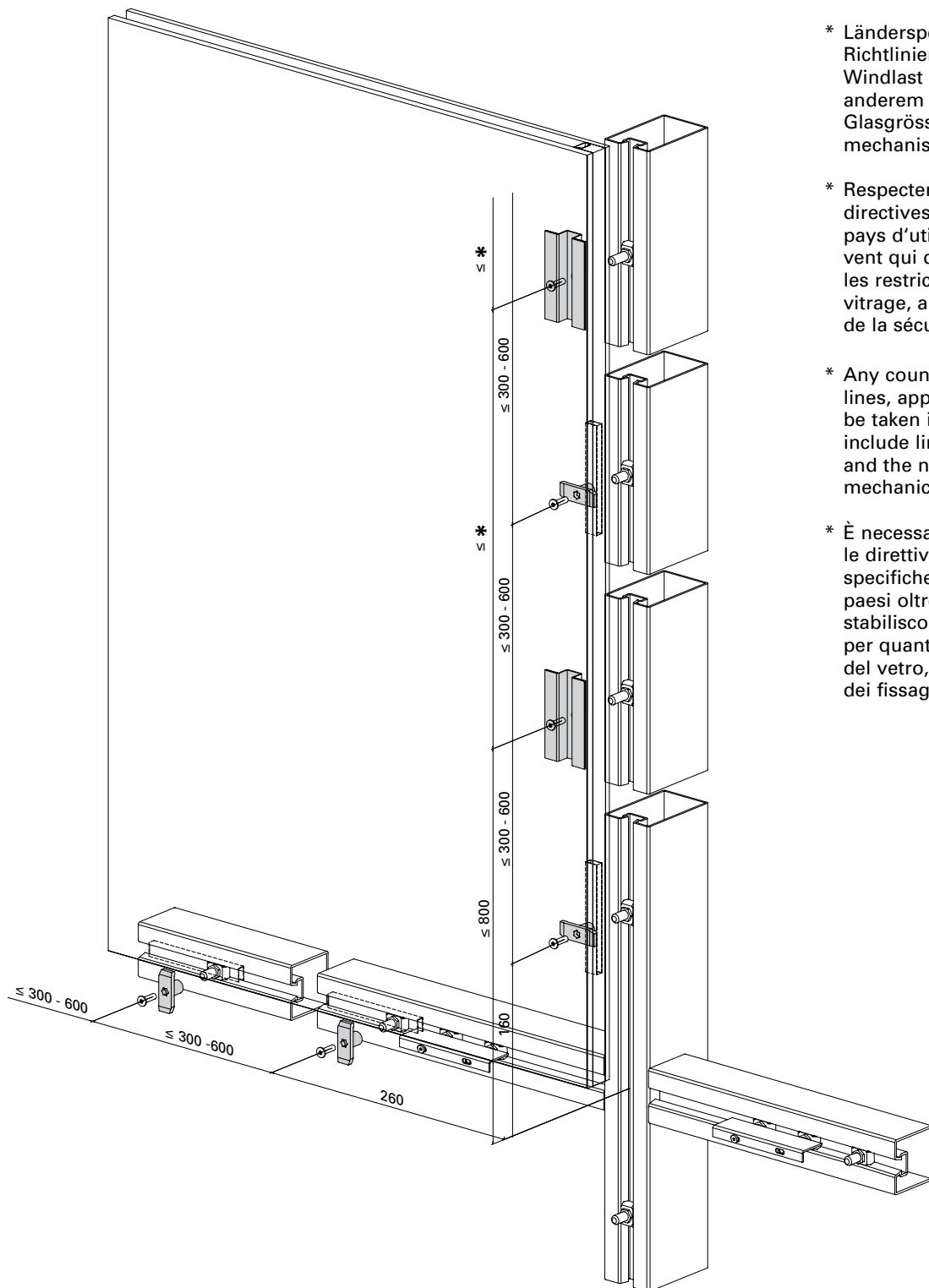


Mechanische Sicherung der äusseren Glasscheibe
mit Glashalter 452.167

Mechanical fixing of outer pane with glazing clip 452.167

Sûreté mécanique de la vitre extérieure avec clip de
vitrage 452.167

Fissaggio meccanico della lastra di vetro esterna tramite
pinza fermavetro 452.167



* Länderspezifischen Gesetze,
Richtlinien und Zulassungen sowie
Windlast sind zu beachten, die unter
anderem Einschränkungen in der
Glasgrösse, Anzahl und Position der
mechanischen Sicherung definieren.

* Respecter la législation, les
directives, les autorisations du
pays d'utilisation et pression du
vent qui définissent entre autres
les restrictions relatives à la taille du
vitrage, au nombre et à la position
de la sécurité mécanique.

* Any country-specific laws, guide-
lines, approvals and wind load must
be taken into account; these may
include limitations in the glass size
and the number and position of
mechanical securing devices.

* È necessario osservare le leggi,
le direttive e le omologazioni
specifiche vigenti nei singoli
paesi oltre al carico del vento, che
stabiliscono tra l'altro limitazioni
per quanto concerne lo spessore
del vetro, il numero e la posizione
dei fissaggi meccanici.



Sofern die mechanische Sicherung der Aussenscheibe mittels Glashalter 452.167 durchgeführt wird, sind je nach Ausführung und Glasstärke, zusätzlich die nachstehenden Artikel in Abhängigkeit der Füllelementstärke zu wählen. Hierbei ist zu beachten, dass es sich dabei nur um die zusätzlichen Artikel für die mechanische Aussensicherung handelt. Die Artikel auf den Seiten 14-17 sind ebenfalls zu wählen. Die Anzahl der Glashalter kann aus der nebenstehenden Zeichnung errechnet werden. Wobei die Glashalter nur vertikal einzusetzen sind.



Where the external glass pane is mechanically secured using glass holder 452.167, the following articles have to be selected depending on the version and glass thickness and on the thickness of the fill elements. It is important to note that these are only the additional articles for securing the elements externally. The articles on pages 14-17 must also be selected. The number of glass holders can be calculated from the adjacent drawing. Please note that the glass holders are only to be used for vertical holding.



Dans la mesure où la sécurité mécanique de la vitre extérieure est obtenue au moyen du clip de vitrage 452.167, les articles suivants sont de plus nécessaires selon l'exécution et l'épaisseur de verre en fonction de l'épaisseur de l'élément de remplissage. Veuillez observer qu'il ne s'agit que des articles supplémentaires relatifs à la sécurité mécanique extérieure. Les articles aux pages 14-17 doivent également être choisis. Le dessin ci-contre permet de calculer le nombre de clips de vitrage nécessaires en sachant qu'ils ne s'utilisent qu'à la verticale.



Se il fissaggio meccanico della lastra esterna è effettuato tramite la pinza fermavetro 452.167, a seconda dell'esecuzione e dello spessore del vetro selezionare i seguenti articoli in relazione allo spessore degli elementi di riempimento. Ricordare in proposito che si tratta esclusivamente degli articoli supplementari per il fissaggio meccanico esterno. Devono essere selezionati anche gli articoli alle pagine 14-17. Il numero delle pinze fermavetro può essere calcolato sulla base del disegno a fianco. Le pinze fermavetro possono essere utilizzate soltanto verticalmente.

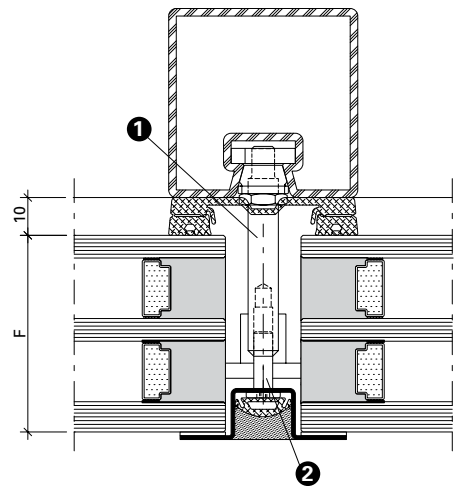
Artikel in Abhängigkeit der Füllelementstärke

Items depending on thickness of infill elements

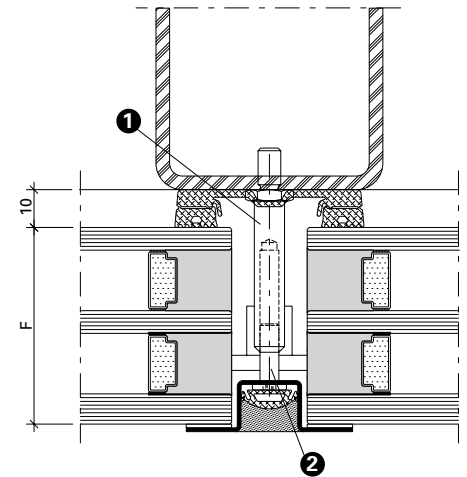
Articles en fonction de l'éléments de remplissage

Articoli in funzione dello spessore degli elementi di riempimento

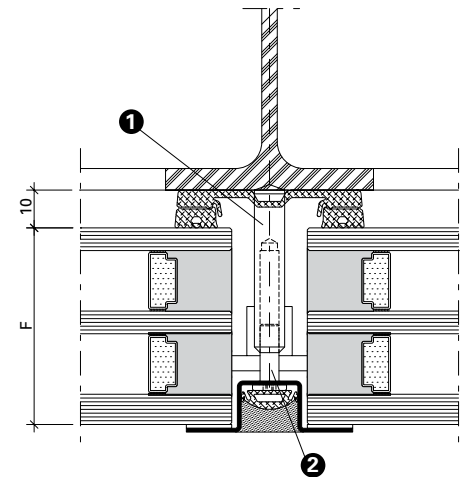
VISS SG	Befestigungsanker Boulon d'ancrage Fastening anchor Bullone di supporto vetro								Schraube Vis Screw Viti		
	①								②		
F mm	452.162	452.435	452.436	452.437	452.438	452.423	452.424	452.425	452.433		
30 – 32	●								●		
33 – 37		●							●		
38 – 42			●						●		
43 – 47				●					●		
48 – 52					●				●		
53 – 57						●			●		
58 – 62							●		●		
63 – 70								●	●		



VISS Basic SG	Schraubbolzen Goujon à visser Screw bolt Bullone filettato							Schraube Vis Screw Viti	
	①							②	
F mm	452.513	452.514	452.515	452.511	452.516	452.420	452.517	452.433	
30 - 32	●							●	
33 - 37		●						●	
38 - 42			●					●	
43 - 47				●				●	
48 - 52					●			●	
53 - 57						●		●	
58 - 62							●	●	



VISS Basic SG	Schweissbolzen Goujon à souder Welding stud Bullone a saldare							Schraube Vis Screw Viti	
	①							②	
F mm	452.501	452.502	452.503	452.510	452.504	452.417	452.505	452.433	
30 - 32	●							●	
33 - 37		●						●	
38 - 42			●					●	
43 - 47				●				●	
48 - 52					●			●	
53 - 57						●		●	
58 - 62							●	●	

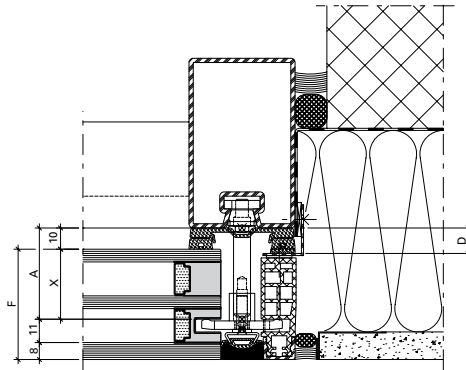
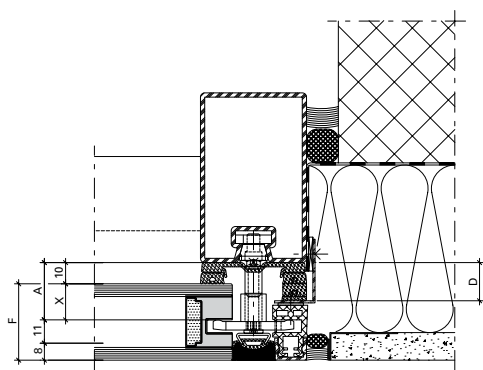










Auswahl der Ausgleichsdichtungen und den Distanzprofilen in der Fassade in Abhängigkeit von der Füllelementstärke

Selection of the compensating weatherstrips and the distance profiles in the façade depending on the infill unit thickness

Choix des joints de compensation et les profilés de distance dans la façade en fonction de l'épaisseur de l'élément de remplissage

Selezione delle guarnizioni di compensazione e dei profili distanziali nella facciata in relazione allo spessore degli elementi di riempimento



F *	A	X	Innendichtung Joint interieure Inside gasket Guarnizione interna	Distanzprofil Profilé de distance Distance profile Profilo distanziale	Ausgleichsdichtung Joint de compensation Compensating gasket Guarnizione di compensazione	D	
mm	mm	mm				mm	
30-31	21	11	455.537 (10 mm) 50 mm 455.538 (10 mm) 60 mm	452.273	455.566 (4 mm)	14	 455.566
32-33	23	13			455.567 (6 mm)	16	 455.567
34-35	25	15			455.567 + 455.565 (8 mm)	18	 455.567 455.565
36-37	27	17			455.567 + 455.566 (10 mm)	20	 455.567 455.566
38-51**							
52-53	43	33	455.537 (10 mm) 50 mm 455.538 (10 mm) 60 mm	452.274	455.566 (4 mm)	14	 455.566
54-55	45	35			455.567 (6 mm)	16	 455.567
56-57	47	57			455.567 + 455.565 (8 mm)	18	 455.567 455.565
58-59	49	39			455.567 + 455.566 (10 mm)	20	 455.567 455.566
60-70**							

* mit Aussenscheibe 8 mm

** Distanzprofil (druckfeste Unterlage) ist durch Metallbauer zu erstellen.
 Das Mass A und X ist analog dem Mass A und X des Füllelementes.
 Beim Einsatz des Distanzprofiles und entsprechender Ausgleichdichtungen ist darauf zu achten, dass eventuelle Anschlussbleche, welche die Dichtungshöhe sowie den Aufbau verändern, nicht mit eingerechnet sind.

* avec vitre extérieure de 8 mm

** Le profilé de distance (cale incompressible) doit être réalisé par le constructeur métallique.
 Les cotes A et X sont analogues aux cotes A et X de l'élément de remplissage.
 En cas d'utilisation du profilé de distance et des joints de compensation correspondant, veiller à ce que les éventuelles tôles de raccordement, qui modifient la hauteur du joint et son montage, ne soient pas comprises dans le calcul.

* with 8 mm outer pane

** Spacer profile (compression-resistant liner) must be created by the metal fabricator.
 The dimensions A and X are the same as the dimensions A and X of the infill unit.
 When using the spacer profile and corresponding compensating gaskets, it must be noted that any joint plates that alter the gasket size as well as the construction are not included in the calculations.

* Con lastra esterna 8 mm

** Il profilo distanziale (resistente alla compressione) deve essere realizzato dall'azienda di costruzioni metalliche.
 La misura A e X è analoga alla misura A e X dell'elemento di riempimento.
 Se si utilizza un profilo distanziale e le relative guarnizioni di compensazione assicurarsi che nel calcolo non siano incluse eventuali lamiere di giunzione che aumentano l'altezza della guarnizione e quindi la struttura.

Einsatz Dämmprofile VISS SG HI

Utilisation gaines isolante VISS SG HI

Application insulating cores VISS SG HI

Utilizzo di profili isolanti VISS SG HI

Füllelementstärke Epaisseurs d'élément Infill unit thicknesses Spessore elementi di riempimento	Einsatz Utilisation Application Utilizzo	Artikelnummer Numéro d'article Part no. Numero di articolo
40 - 55 mm	Pfosten und Riegel Montant et traverse Mullion and transom Montanti e traversi	450.065
56 - 70 mm	Pfosten und Riegel Montant et traverse Mullion and transom Montanti e traversi	450.067

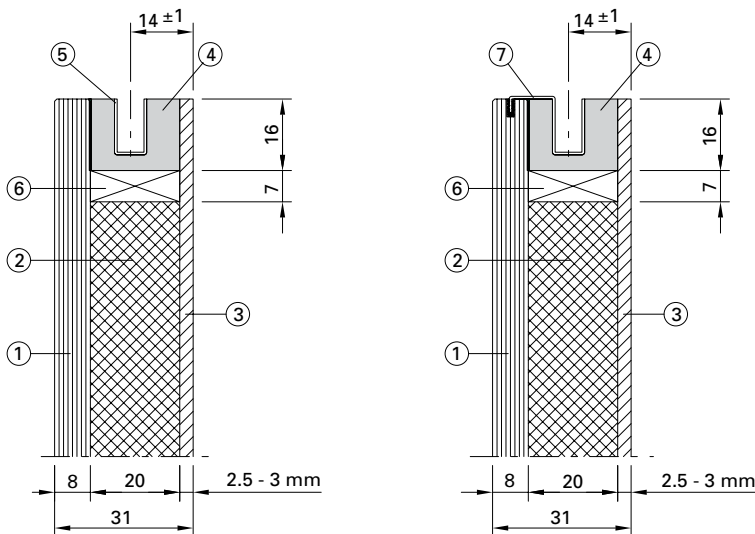
Herstellung von Glaspaneelen

Gemäss der Europäischen technischen Zulassung (ETA) 13/0015 kann ein Glaspaneel gefertigt werden sofern folgende Bedingungen erfüllt sind:

1. Das Paneel muss wie in Anlage 18 der ETA 13/0015 aufgebaut sein bzw. darf wie folgt abweichen:
 - a. Anstatt eines 3-fach Aufbaus darf auch ein 2-fach Aufbau gewählt werden.
 - b. Der Aufbau kann gemäss den Empfehlungen der Firma Eckelt erfolgen
2. Das verwendete Aluminiumblech bzw. die Kleboberfläche (bevorzugt eloxierte Oberfläche) ist vom Kunden beizustellen und der Nachweis «Prüfung einer Structural Glazing-Klebung auf anorganischer Oberfläche nach ETAG 002» muss erbracht sein. Bevorzugt sollte hier ein Eloxalwerk werden, welches diese Prüfung vorweisen kann. Im Auftragsfall werden zusätzlich Blechmuster für projektbezogene Haftprüfungen sowie Eigen- und Fremdüberwachung benötigt.
 Auf Grund, dass hier die Verklebung Glas – Silikon – Aluminiumblech erfolgt ist die Verklebung mit einem Structural Glazing Silikon (z.B. DC 993) auszuführen. Eine Erstprüfung, durch das ift Rosenheim für die Verklebung von Email nach ABZ Z-70.1-75 mit Silikon DC 993 liegt der Firma Eckelt vor.

Das Unternehmen welche die Verklebung zwischen Glas und Randverbund sowie zwischen Randverbund und Aluminiumblech übernimmt, muss entsprechend zugelassen und zertifiziert sein. Ein Nachweis über die Verklebung ist vom ausführenden Unternehmen zu erbringen.

Paneelaufbau Vario DZ Composition du panneau Vario DZ Panel composition Vario DZ Struttura pannello Vario DZ



Pose de panneaux vitrés

Selon l'Agrément Technique Européen (ETA) 13/0015, il est possible de poser un panneau vitré dans la mesure où les conditions suivantes sont remplies:

1. Le panneau doit être composé comme indiqué dans l'annexe 18 de l'ETA 13/0015 et les divergences suivantes sont autorisées:
 - a. Le vitrage peut être double au lieu de triple.
 - b. Le montage peut être effectué selon les recommandations de la société Eckelt
2. La tôle en aluminium utilisée et la surface à coller (de préférence surface anodisée) doivent être fournies par le client avec l'attestation «Contrôle d'un collage tout en verre sur une surface anorganique selon ETAG 002». Il devrait s'agir de préférence d'une usine de traitement Eloxal en mesure de fournir le contrôle. En cas de commande, des modèles de tôle pour les essais d'adhérence relatifs au projet et un contrôle interne et extérieur sont de plus nécessaires.
 En raison du collage verre – silicone – tôle d'aluminium, ce dernier doit être effectué avec du silicone pour tout verre (p. ex. DC 993). La société Eckelt dispose d'un essai type qui a été réalisé par ift Rosenheim pour le collage d'émail selon ABZ Z-70.1-75 avec du silicone DC 993.

L'entreprise qui se charge du collage entre verre et scellement ainsi qu'entre scellement et tôle d'aluminium doit posséder l'autorisation et la certification qui y est nécessaire. L'entreprise exécutante du collage doit fournir une attestation pour le collage.

Bezeichnung Werkstoff

1. EMAILT	Glas
2. Isolierung	EPS W30
3. Aluminium	Aluminium
4. Silikon	DC-993
5. VAR 101	AlMgSi05 F22
6. Abstandhalter	Aluminium
7. VAR 102-8	1.4016-S235

Achtung:

Bis 2 m² Blechdicke 2.5 mm
 Bis 4 m² Blechdicke 3 mm

Désignation Matériau

1. EMAILT	Verre
2. Isolation	EPS W30
3. Aluminium	Aluminium
4. Silicone	DC-993
5. VAR 101	AlMgSi05 F22
6. Pièce d'écartement	Aluminium
7. VAR 102-8	1.4016-S235

Attention:

jusqu'à 2 m² d'épaisseur de tôle 2.5 mm
 jusqu'à 4 m² d'épaisseur de tôle 3 mm

Manufacturing glass panels

A glass panel can be fabricated in accordance with the European Technical Approval (ETA) 13/0015 as long as the following conditions are met:

1. The panel must be constructed as in Appendix 18 of ETA 13/0015; otherwise it may deviate as follows:
 - a. A double glazing composition can be selected instead of a triple glazing composition.
 - b. Construction can be carried out in accordance with the recommendations from Eckelt
2. The sheet aluminium used on the bonding surface (preferably an anodised surface) must be provided by the customer and proof of «testing of structural glazing bonding to an inorganic surface in accordance with ETAG 002» must be provided. This should preferably be an anodising plant that can provide proof of this test. If an order is placed, additional sheet samples are required for project-specific adhesion tests, as well as in-house and third-party monitoring.
 Due to the fact that glass, silicone and aluminium sheets are being bonded here, bonding must be carried out with a structural glazing silicone (e.g. DC 993). An initial type test by ift Rosenheim for the bonding of enamel in accordance with general building authority approval ABZ-70.1-75 with silicone DC 993 is available from Eckelt.

The company that carries out the bonding between glass and edge seal and between edge seal and aluminium sheet must be approved and certified accordingly. Proof of bonding must be provided by the company contracted to do the work.

Produzione di pannelli di vetro

In base alla Omologazione tecnica europea (ETA) 13/0015 per realizzare un pannello in vetro devono essere soddisfatte le seguenti condizioni:

1. Il pannello deve essere costruito come specificato nell'allegato 18 dell'ETA 13/0015 o può presentare i seguenti scostamenti:
 - a. Invece di una vetratura tripla può essere selezionata una vetratura doppia.
 - b. La costruzione deve essere realizzata secondo le raccomandazioni della ditta Eckelt
2. La lamiera di alluminio o la superficie di adesione utilizzata (preferibilmente una superficie anodizzata) deve essere fornita dal cliente e deve essere presentato il certificato della «Prova di incollaggio di vetrate strutturali su superficie inorganica secondo l'ETAG 002». Deve essere data preferenza a un impianto di anodizzazione in grado di fornire un certificato di prova. In caso di attribuzione degli ordini, saranno necessari anche campioni di lamiera per prove di incollaggio specifiche per i progetti e monitoraggio in azienda e tramite terze parti.
 Poiché in questo caso l'incollaggio interessa vetro, silicone e lamiera di alluminio deve essere realizzato con un silicone per facciate strutturali (es. DC 993). È disponibile una prova iniziale di tipo della ditta Eckelt realizzata dall'ift Rosenheim per l'incollaggio di smalto con silicone DC 993 secondo approvazione dell'Istituto Tedesco per le costruzioni ABZ Z-70.1-75.

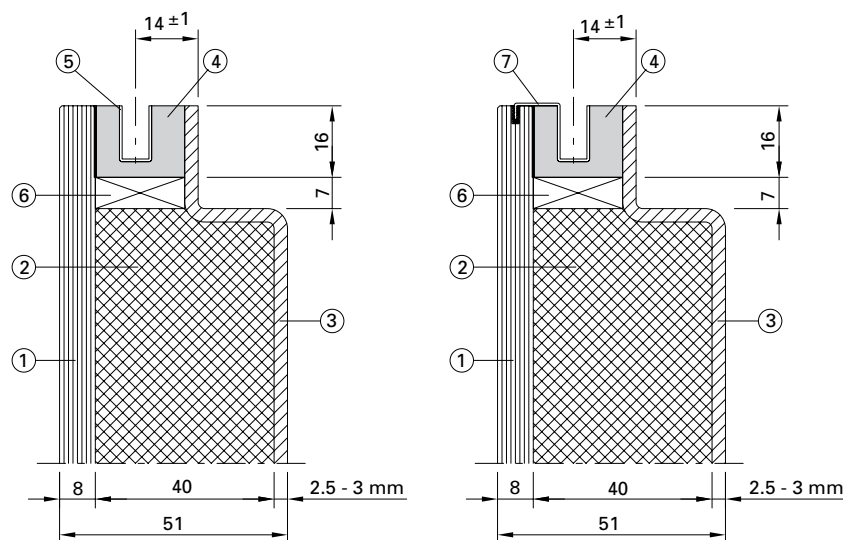
L'azienda che si occupa dell'incollaggio tra vetro e giunto perimetrale e tra giunto perimetrale e lamiera in alluminio deve disporre della necessaria autorizzazione e certificazione. Deve essere fornito un attestato di incollaggio da parte dell'azienda che esegue i lavori.

Paneelaufbau Vario S-For

Composition du panneau Vario S-For

Panel composition Vario S-For

Struttura pannello Vario S-For



Description	Material
1. EMAILT	Glass
2. Insulation	EPS W30
3. Aluminium	Aluminium
4. Silicone	DC-993
5. VAR 101	AlMgSi05 F22
6. Spacer	Aluminium
7. VAR 102-8	1.4016-S235

Note:

Up to 2 m², sheet thickness 2.5 mm
 Up to 4 m², sheet thickness 3 mm

Denominazione	Materiale
1. EMAILT	Vetro
2. Isolante	EPS W30
3. Alluminio	Alluminio
4. Silicone	DC-993
5. VAR 101	AlMgSi05 F22
6. Distanziale	Alluminio
7. VAR 102-8	1.4016-S235

Attenzione:

Fino a 2 m² di lamiera spessa 2,5 mm
 Fino a 4 m² di lamiera spessa 3 mm

Hinweise
Remarques
Information
Avvertenze

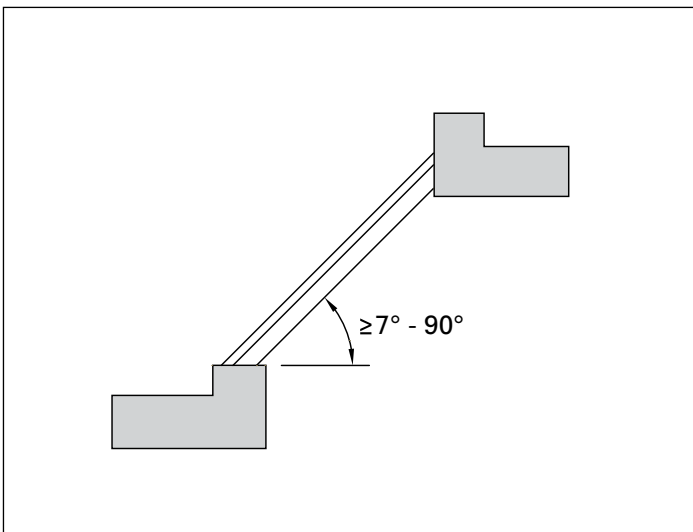
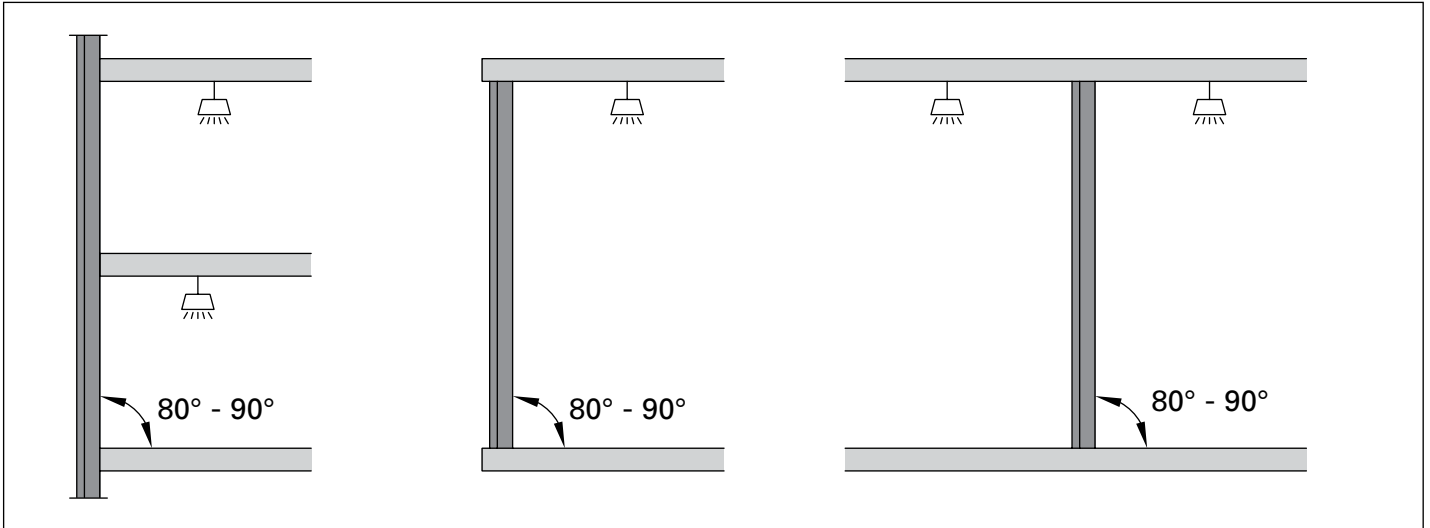
VISS SG Fassaden
VISS SG façades
VISS SG façades
VISS SG facciate

Anwendungsbereich

Scope of application

Domaine d'application

Campo d'applicazione



Achtung:
Aussteifung nur ohne Riegel

Attention:
Rigidification uniquement sans traverse

Important:
Reinforcement only without bolt

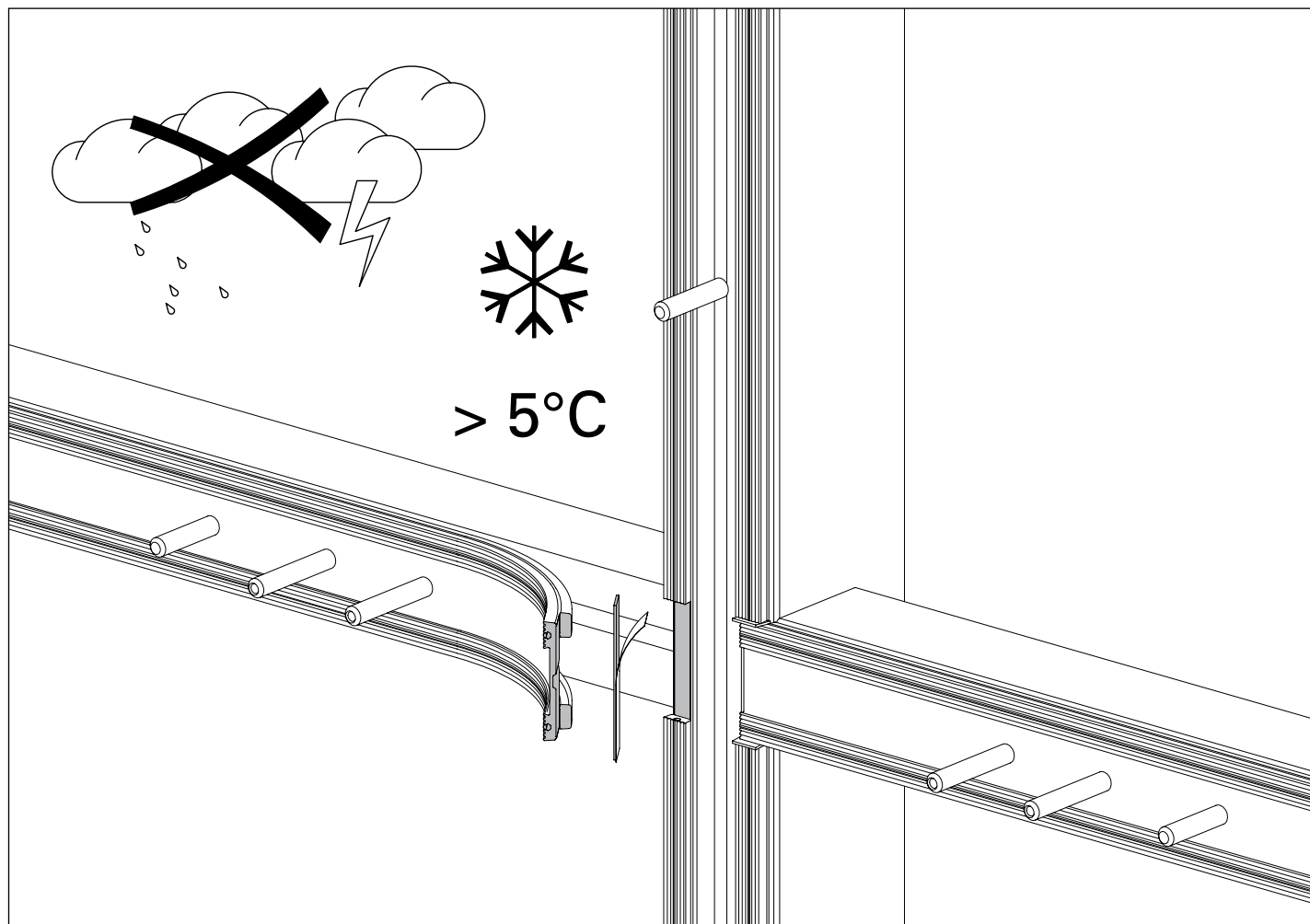
Attenzione:
Rinforzo solo senza traverso

Verarbeitungs- und Montagebedingungen

Processing and assembly conditions

Conditions de montage et d'usage

Condizioni di lavorazione e montaggio



Eine einwandfreie Verklebung ist nur bei trockenen Dichtungen und Umgebungstemperaturen von $> 5^{\circ}\text{C}$ gewährleistet

Un collage parfait n'est assuré que quand les joints sont secs et les températures ambiantes $> 5^{\circ}\text{C}$

Proper bonding can only be ensured with dry gaskets and ambient temperatures of $> 5^{\circ}\text{C}$

Il corretto incollaggio è garantito solo con guarnizioni asciutte e temperature esterne superiori a $> 5^{\circ}\text{C}$

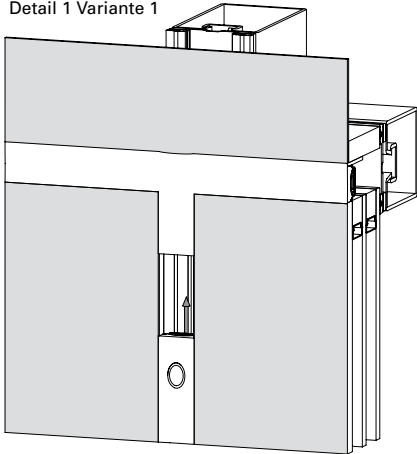
Glasfalz-Belüftung/Glasfalz-Entwässerung

Ventilation de feuillures de verre/Drainage de la feuillure à verre

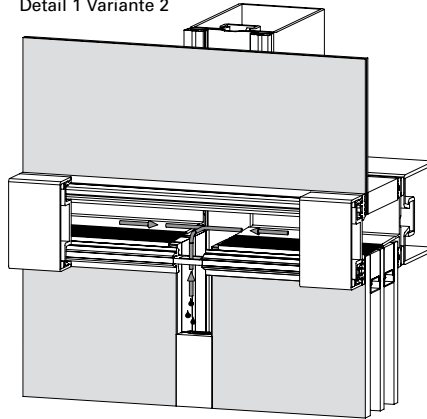
Glazing rebate ventilation/Glazing rebate drainage

Aerazione vetro/drenaggio vetro

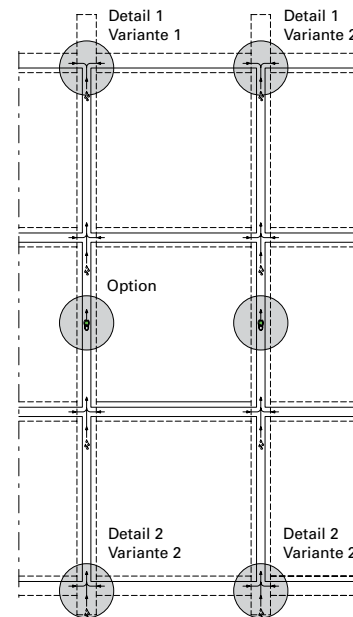
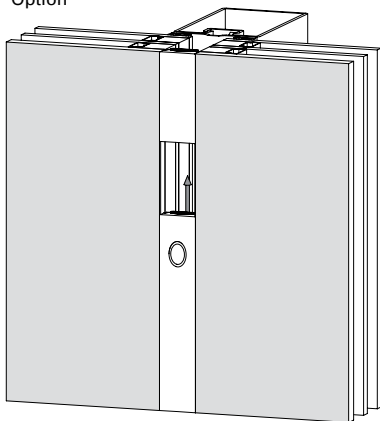
Detail 1 Variante 1



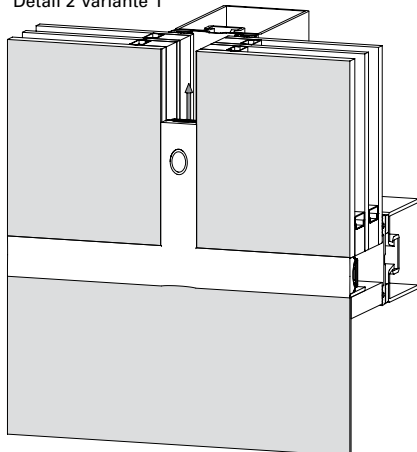
Detail 1 Variante 2



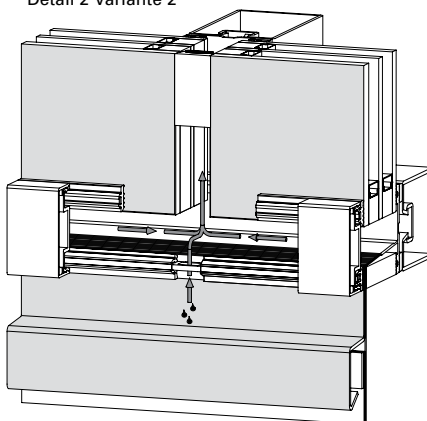
Option*



Detail 2 Variante 1



Detail 2 Variante 2



* Belüftung siehe Seite 60
* Ventilation voir page 60
* Ventilation see page 60
* Aerazione vedi pagina 60

Ablaufschritte: Verarbeitung und Montage

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Sequenza di lavorazione e montaggio

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1. Anordnung und Montage Befestigungsanker

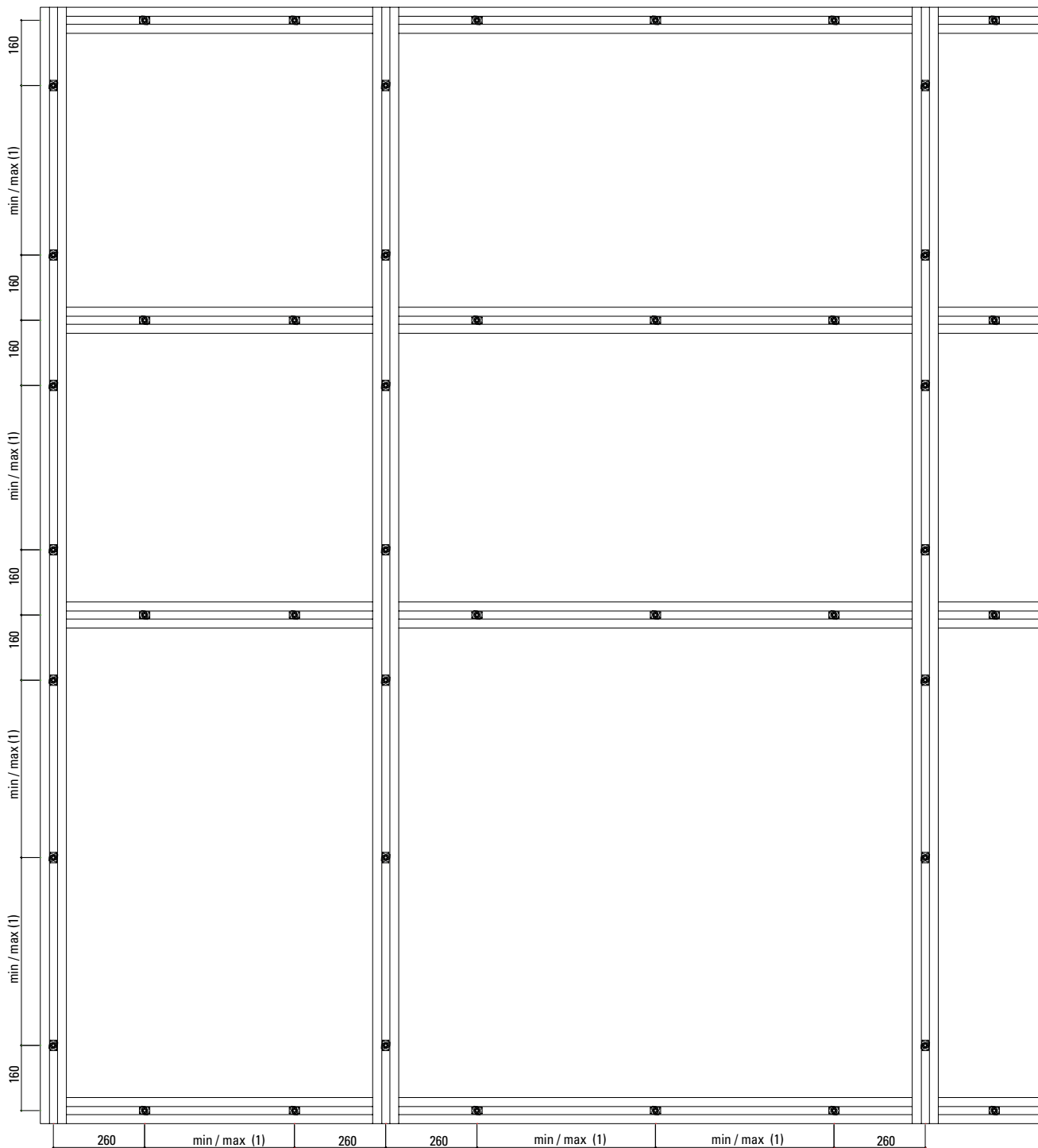
1. Positioning and assembly fastening anchor

1. Disposition et montage boulon d'ancrage

1. Disposizione e montaggio di bullone di supporto vetro

- 1.1 Anordnung
- 1.1 Disposition

- 1.1 Positioning
- 1.1 Disposizione



(1) Wird von Glaslieferant bestimmt (min. 300 mm / max. 600 mm)

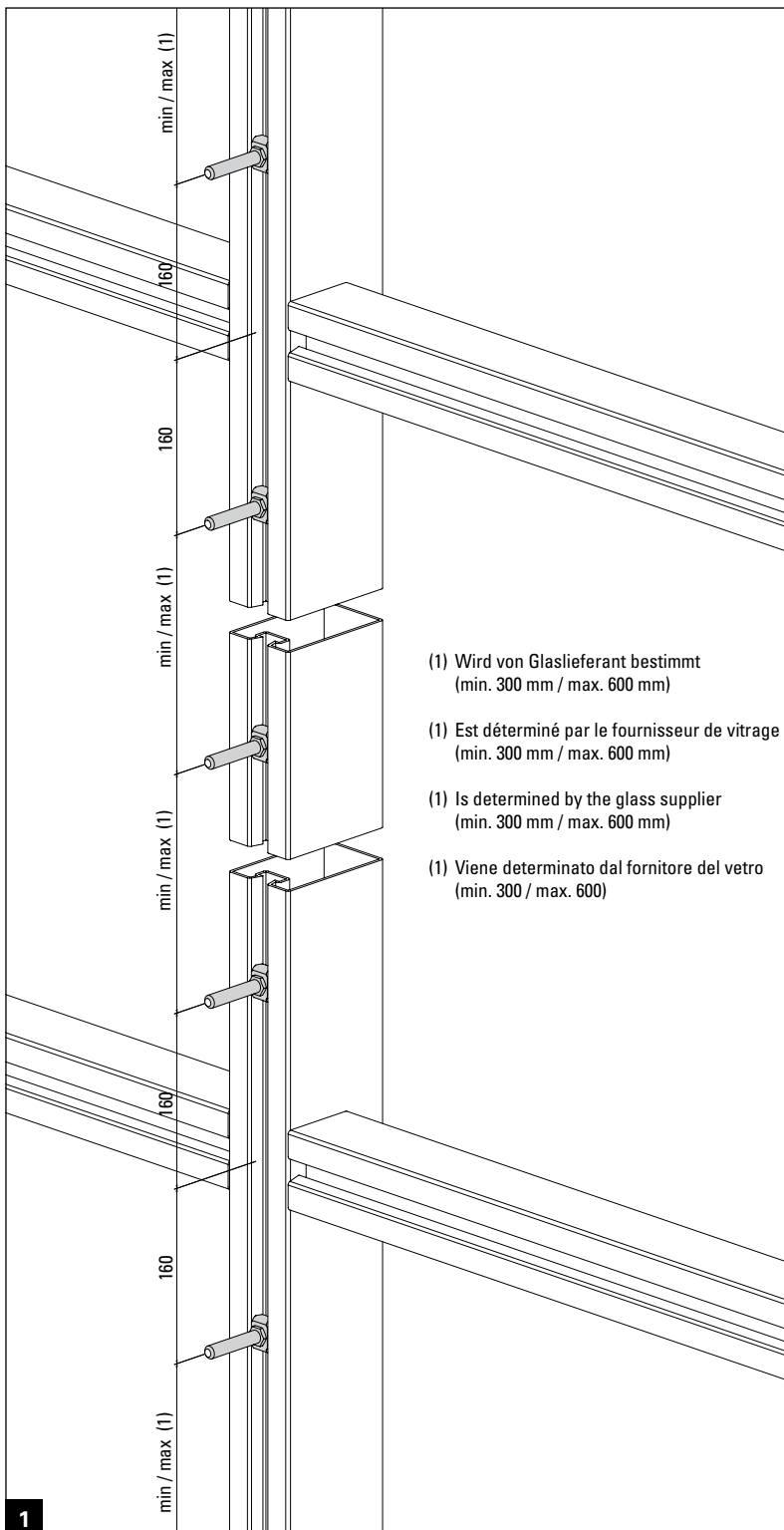
(1) Is determined by the glass supplier (min. 300 mm / max. 600 mm)

(1) Est déterminé par le fournisseur de vitrage (min. 300 mm / max. 600 mm)

(1) Viene determinato dal fornitore del vetro (min. 300 / max. 600)

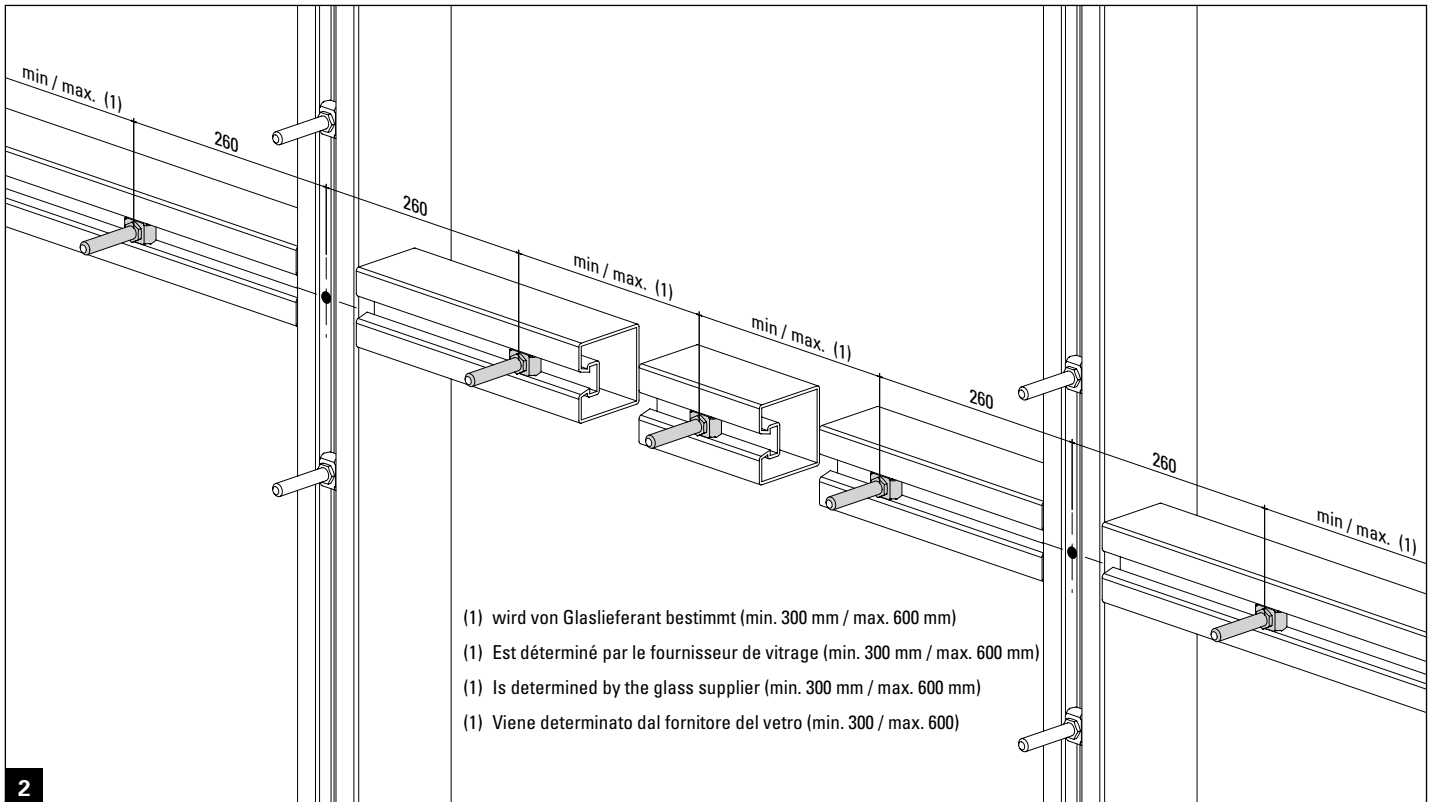
1.2 Positionierung Befestigungsanker im Pfostenbereich
1.2 Positionnement du boulon d'ancrage dans la zone du montant

1.2 Positioning of fastening anchor in the mullion area
1.2 Posizione del bullone di supporto vetro sul montante



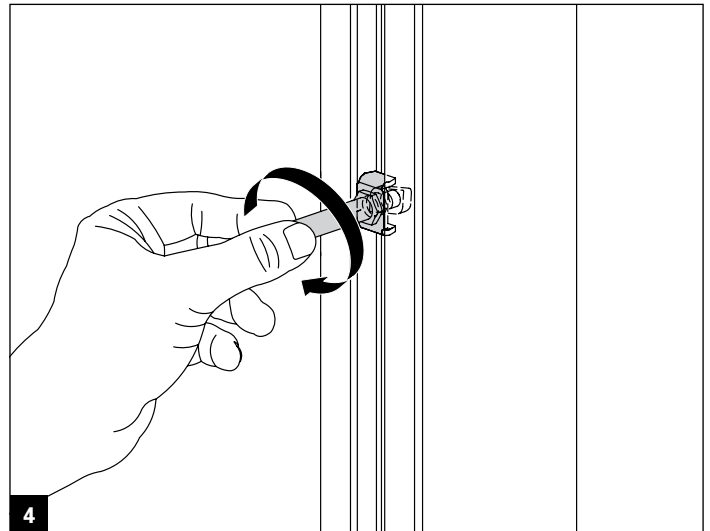
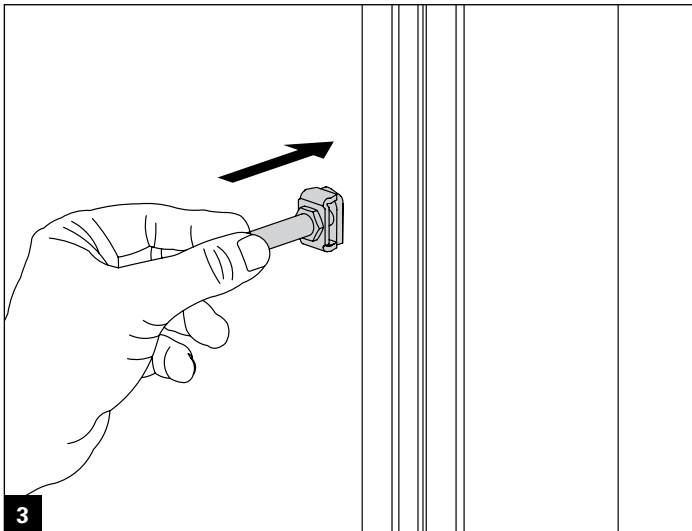
1.3 Positionierung Befestigungsanker im Riegelbereich
1.3 Positionnement du boulon d'ancrage dans la zone de la traverse

1.3 Positioning of fastening anchor in the transom area
1.3 Posizione del bullone di supporto vetro sul traverso

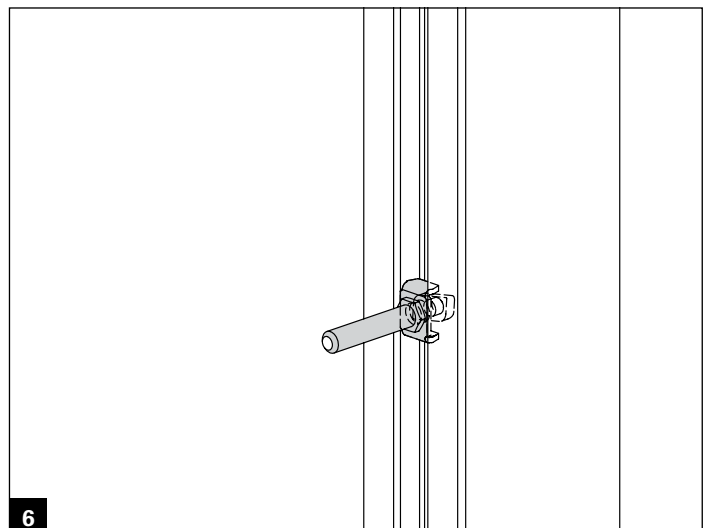
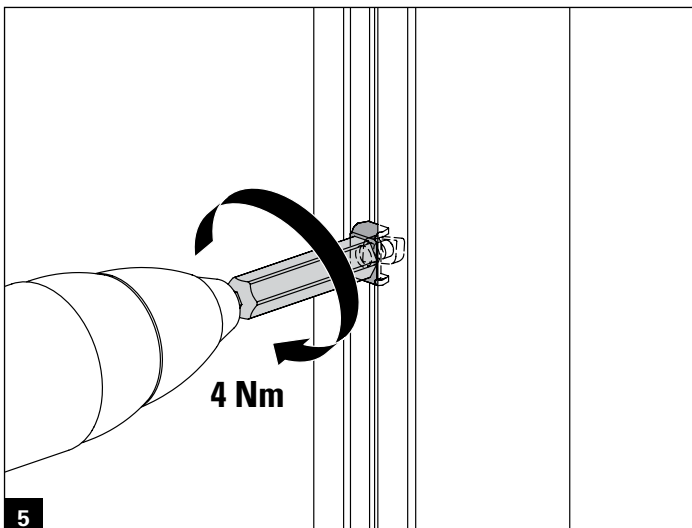


1.4 Montage Befestigungsanker
1.4 Disposition boulon d'ancrage

1.4 Installation of fastening anchor
1.4 Montaggio bullone di supporto vetro



Befestigungsanker in Nute drücken und 90° drehen
Presser le boulon d'ancrage dans la rainure et tourner à 90°
Insert fastening anchor into groove and rotate 90°
Premere il bullone di supporto vetro nella scanalatura,
quindi ruotarlo di 90°



Befestigungsanker fertig montiert (Ankerteil ist blockiert)
boulon d'ancrage monté (l'ancre est bloquée)
Installation of fastening anchor complete (anchor component
is blocked)
Bullone di supporto vetro montato (ancoraggio bloccato)

2. Anordnung und Montage Glasauflagen

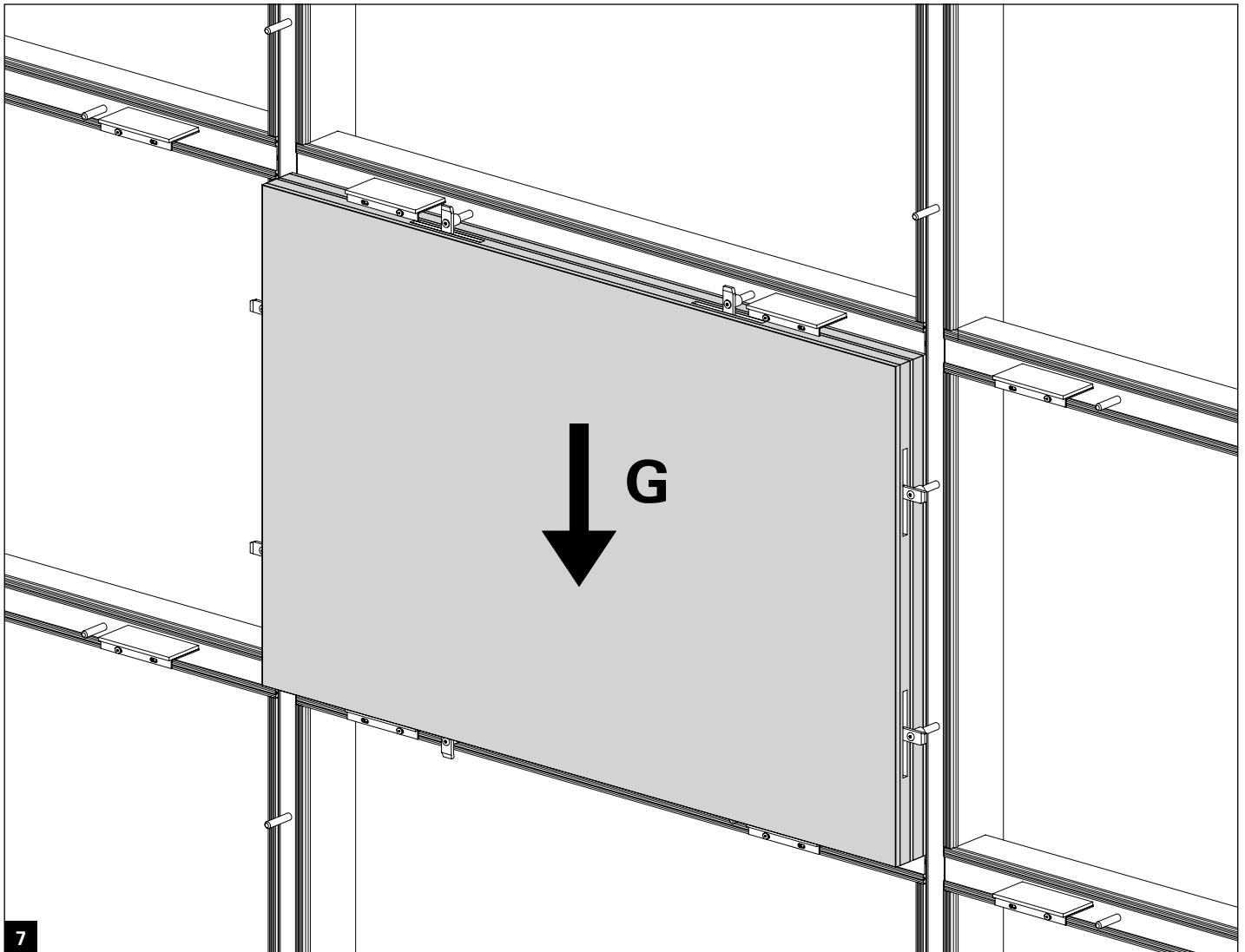
2. Positioning and assembly glazing supports

2. Disposition et montage supports de verre

2. Disposizione e montaggio supporto vetri

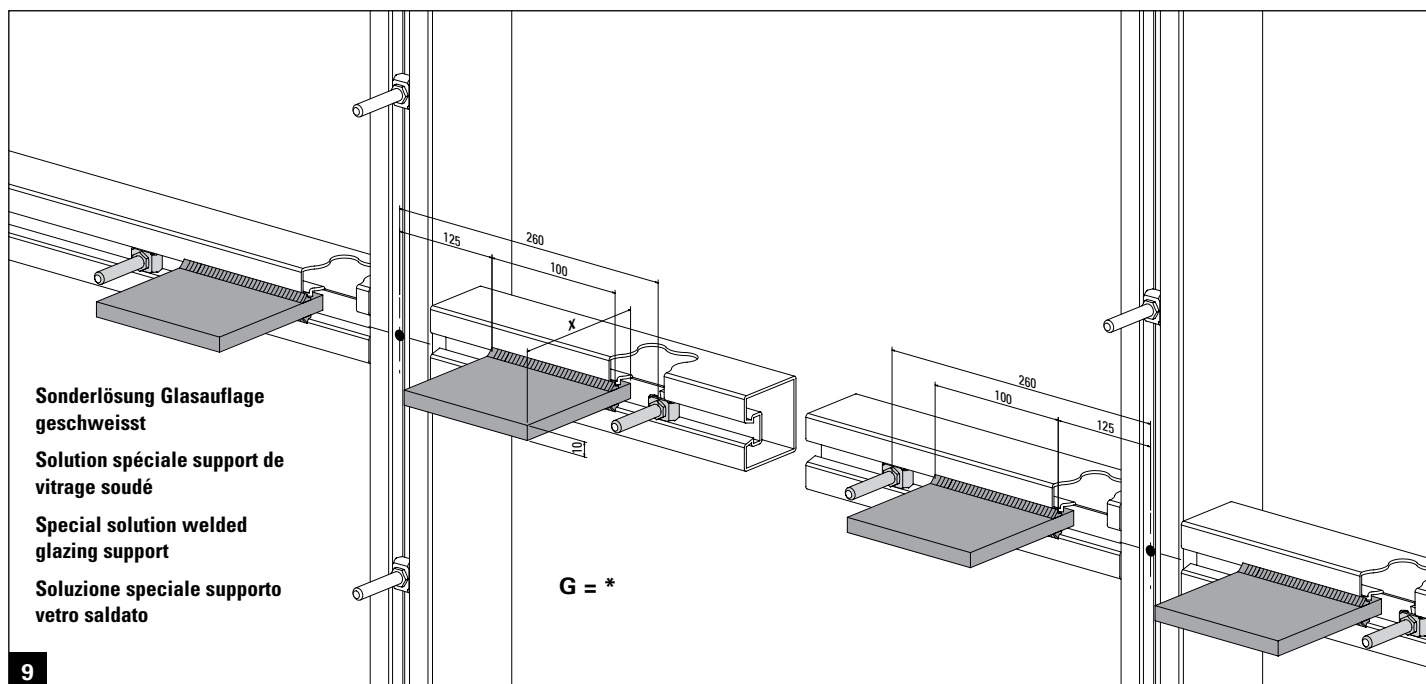
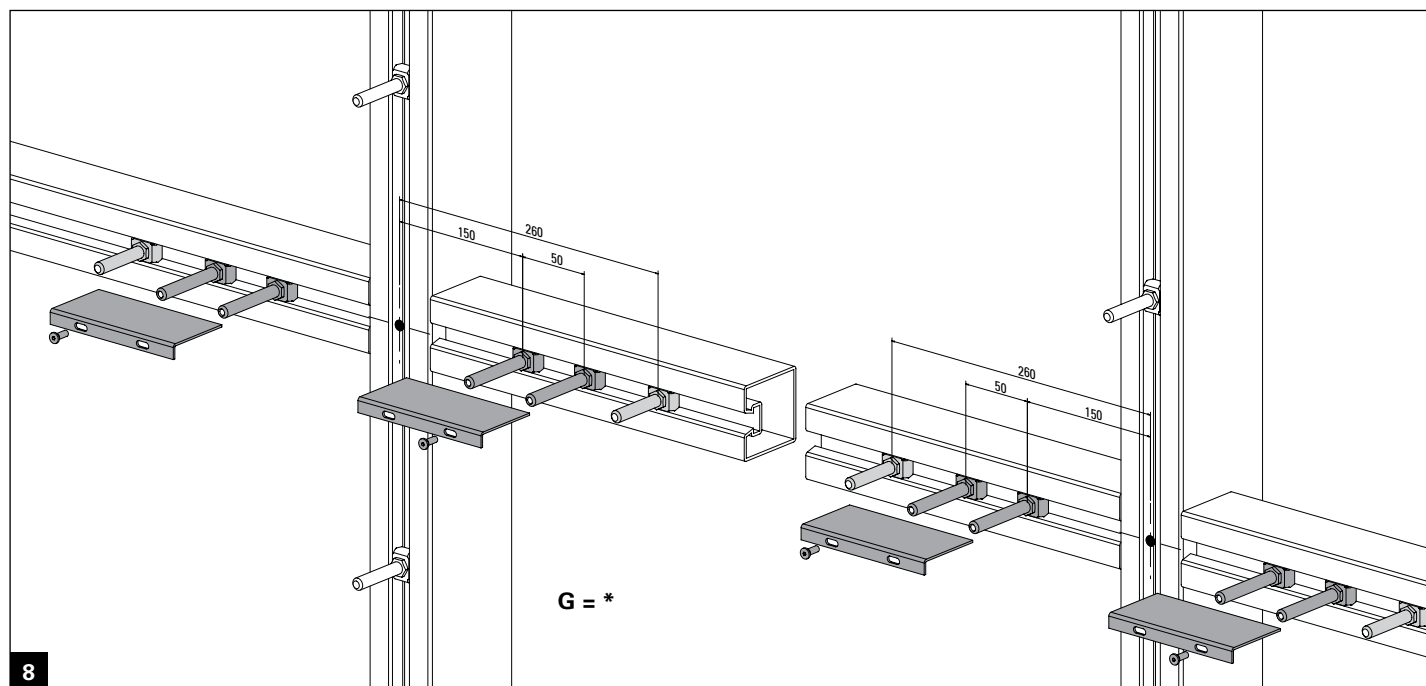
- 2.1 Anordnung und Anzahl Glasauflagen
- 2.1 Disposition et nombre de supports de vitrage

- 2.1 Positioning and quantity of glazing supports
- 2.1 Posizionamento e montaggio supporti vetro



G = Gewicht Füllelement
G = poids élément de remplissage

G = weight infill unit
G = peso elemento di riempimento



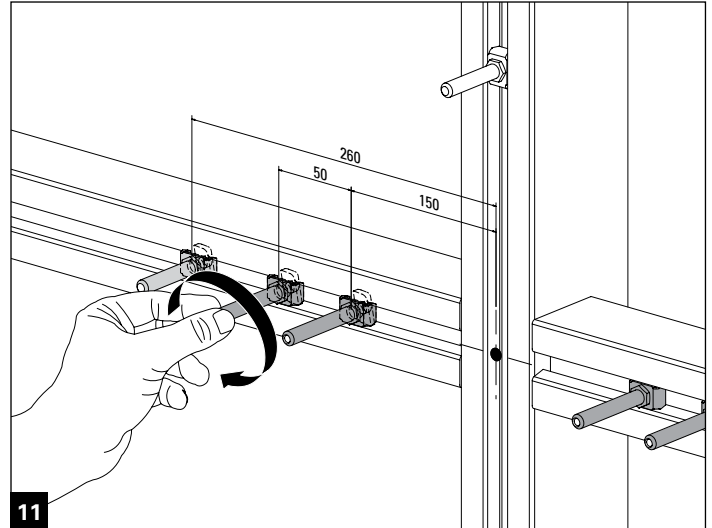
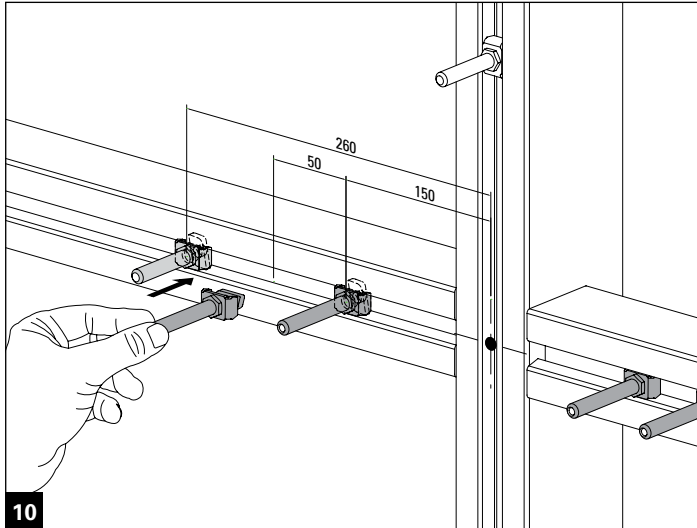
**Sonderlösung Glasauflage
 geschweisst**
**Solution spéciale support de
 vitrage soudé**
**Special solution welded
 glazing support**
**Soluzione speciale supporto
 vetro saldato**

* siehe «Verarbeitung und Montage VISS Tragkonstruktion»
 * voir «Usinage et montage Construction porteuse VISS»

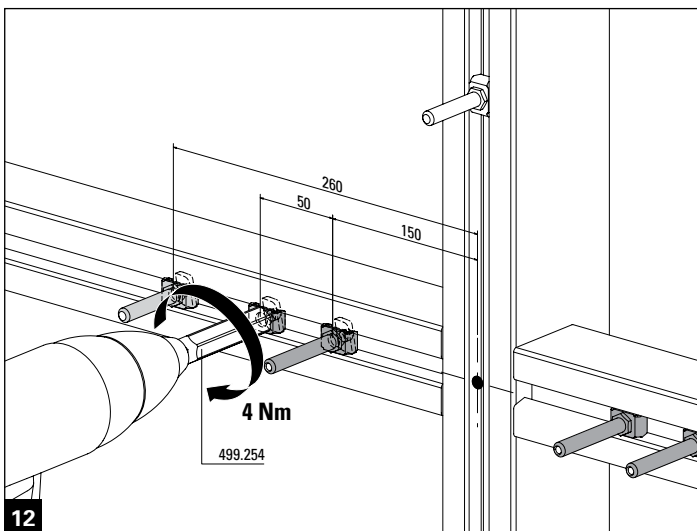
* see «Processing and assembly VISS supporting structure»
 * vedi «Lavorazione e montaggio Struttura portante VISS»

2.2 Montage Glasauflagen
 2.2 Montage supports de verre

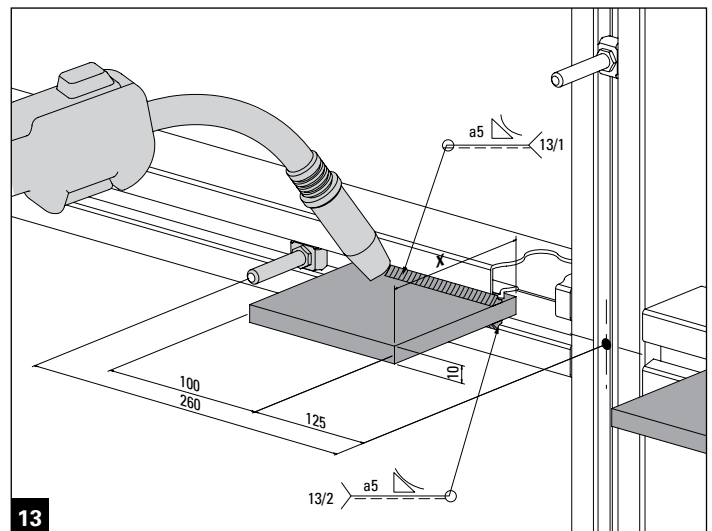
2.2 Assembly glazing supports
 2.2 Montaggio supporto vetri



Traganker in Nute drücken und eindrehen
 Presser le boulon-support dans la rainure et visser
 Insert anchor bolts in groove and tighten
 Premere il bullone di supporto nella scanalatura e ruotarlo



Traganker mit einem Drehmoment von 4 Nm anziehen
 Serrer le boulon-support avec un couple de 4 Nm
 Tighten anchor bolts with a torque of 4 Nm
 Serrare il bullone di supporto con una coppia di 4 Nm



Variante Glasauflage geschweisst:
 Stahlflach (min. S235) umlaufend anschweißen
 X = Füllelementstärke + 19 mm
 Variante support de vitrage soudé:
 Acier plat (min. S235) soudé sur toute la périphérie
 X = épaisseur de l'élément de remplissage + 19 mm

Option - welded glazing support:
 Weld on steel flat (min. S235) all around
 X = infill unit thickness + 19 mm

Variante supporto vetro saldato: saldare una piastrina di acciaio (min. S235) su tutto il proprio perimetro
 X = spessore elemento di riempimento + 19 mm

3. Zuschnitt / Montage / Ausklinkung Innendichtung vertikal

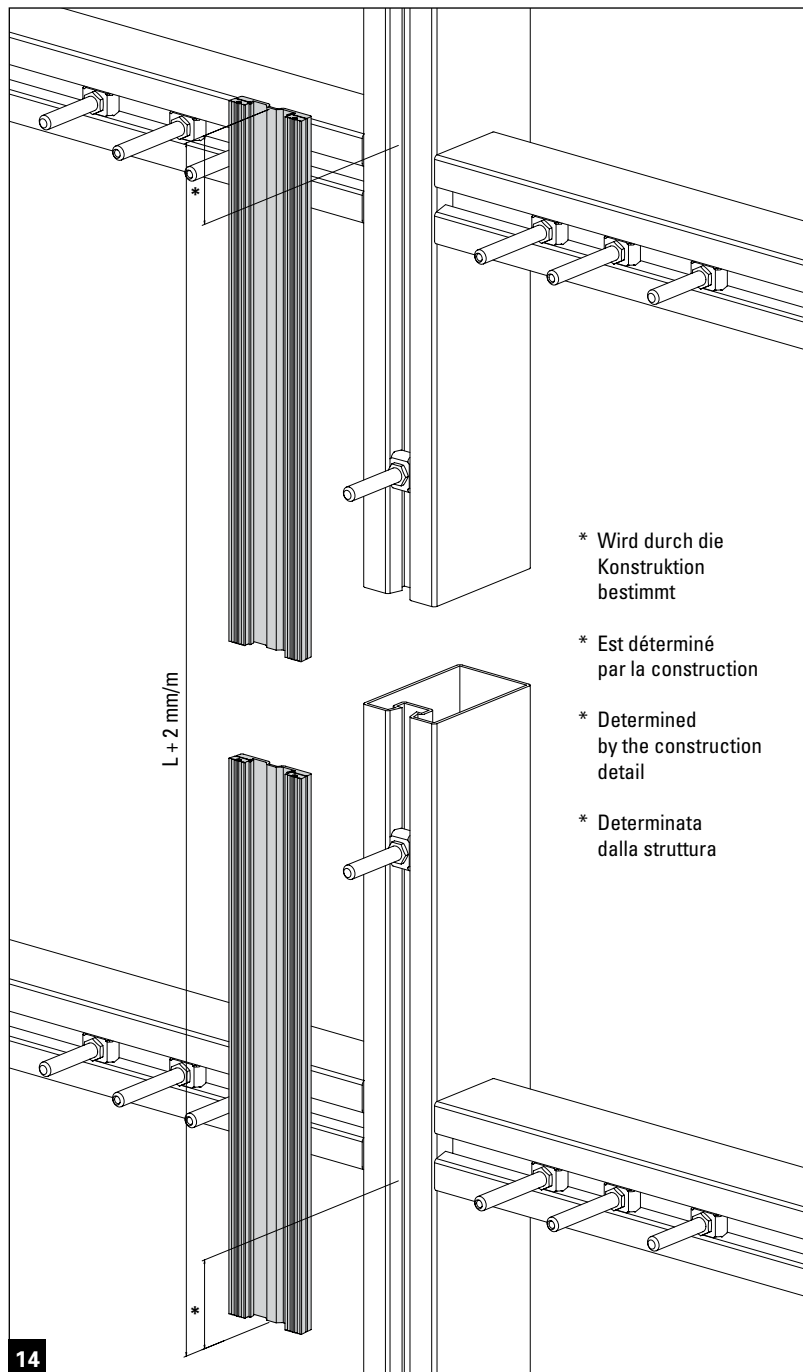
3. Cutting / assembly / notching the vertical internal gasket

3. Découpe / montage / entaille de joint intérieur vertical

3. Taglio/montaggio/intaglio delle guarnizione interna verticale

3.1 Zuschnitt Innendichtung vertikal
3.1 Découpe du joint intérieur vertical

3.1 Cutting the vertical internal gasket
3.1 Taglio della guarnizione interna verticale



Längenzuschlag von 2 mm/m beachten

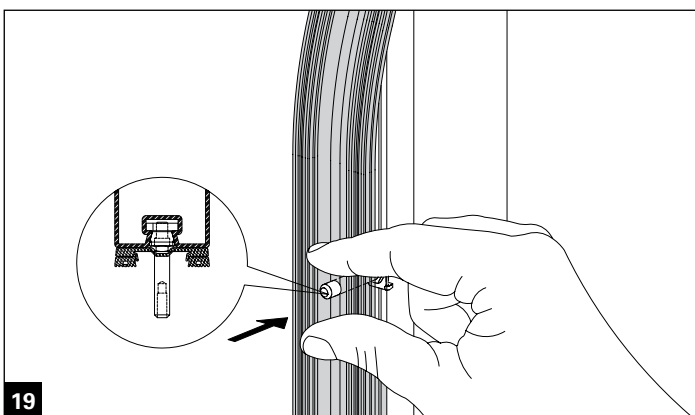
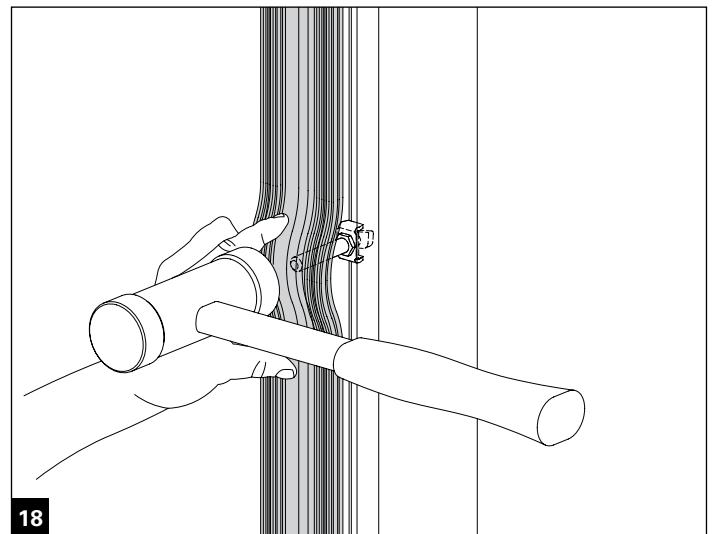
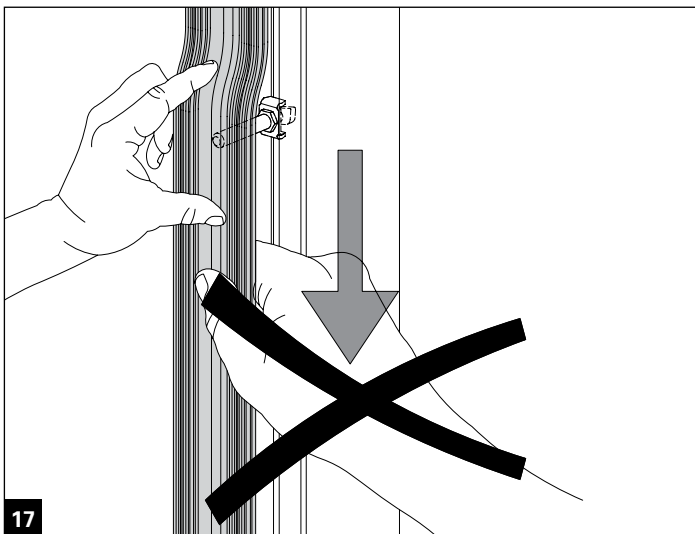
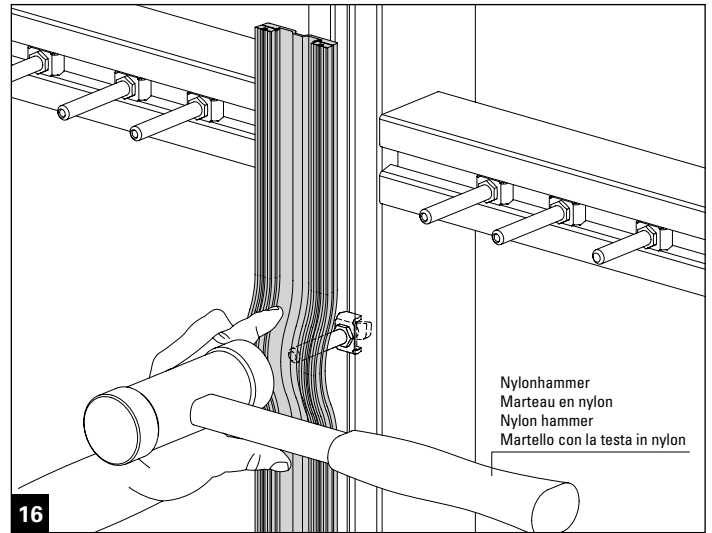
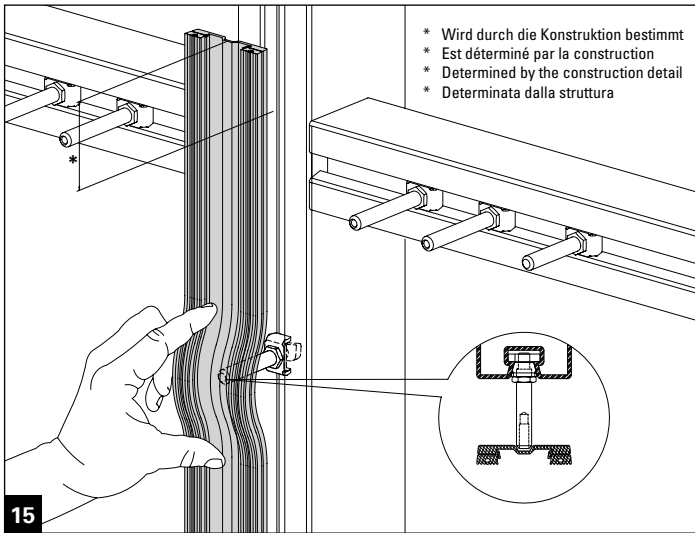
Tenir compte du supplément de longueur de 2 mm/m

Note length allowance of 2 mm/m

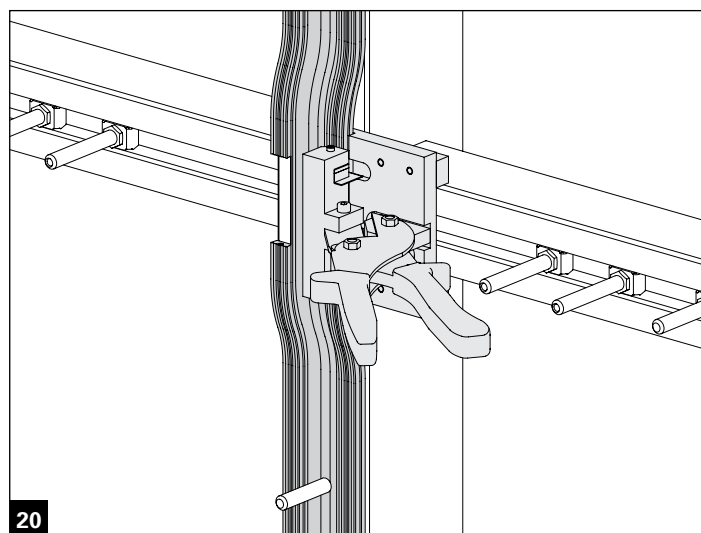
Considerare la maggiorazione in lunghezza di 2 mm/m

3.2 Montage Innendichtung vertikal
3.2 Montage du joint intérieur vertical

3.2 Assembly the vertical gasket
3.2 Montaggio della guarnizione interna verticale

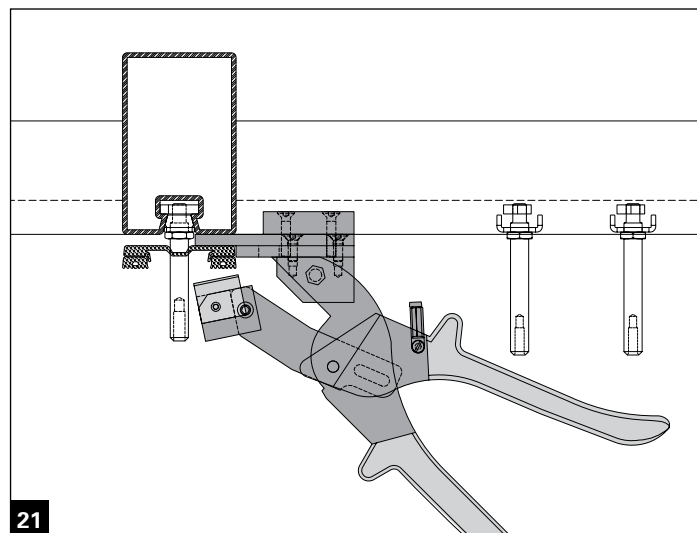


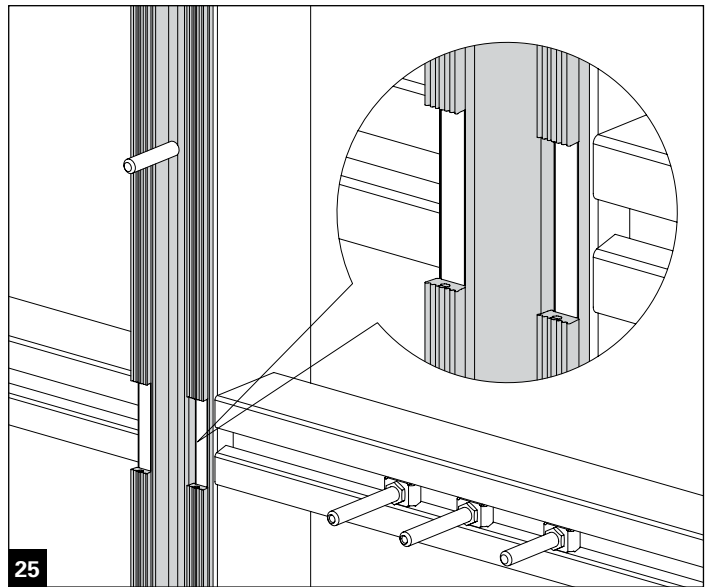
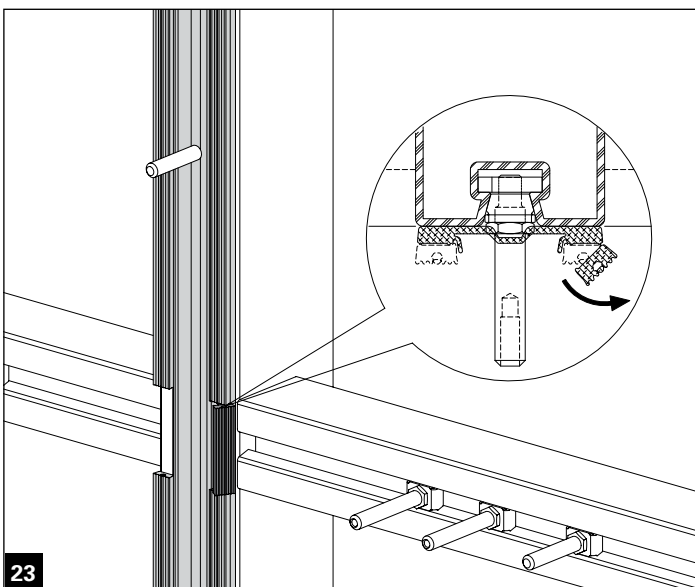
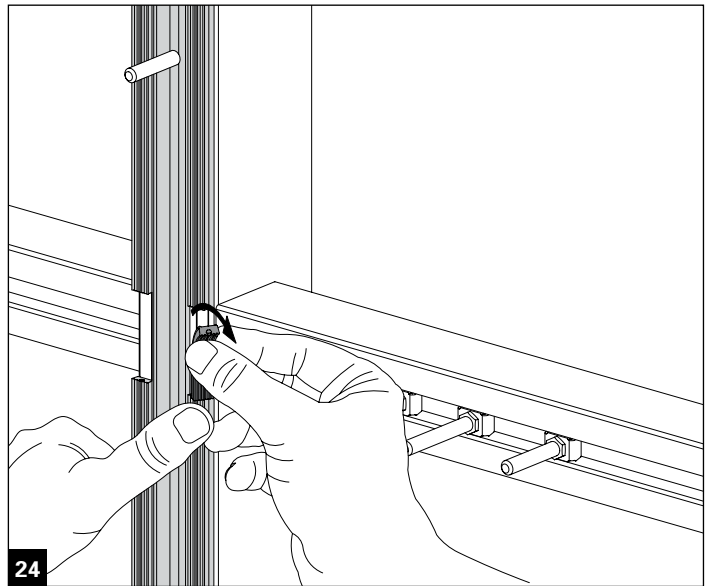
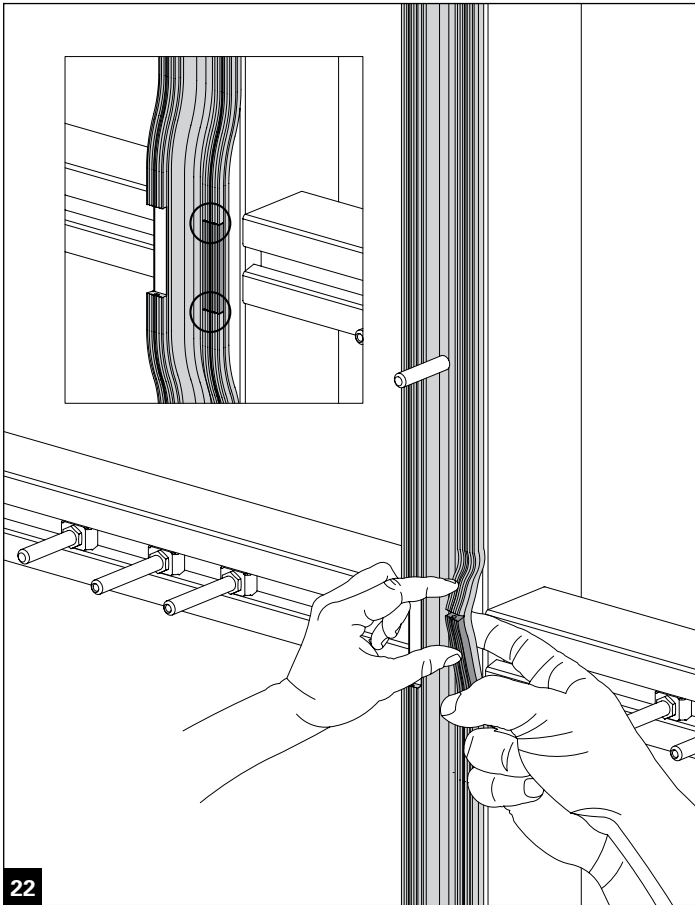
3.3 Ausklinkung Innendichtung vertikal Kreuzpunkt
3.3 Entaille de joint intérieur vertical point d'intersection



Ausklinkung mit Dichtungsstanze 499.263
Entaille avec poinçon à joints 499.263
Notching with gasket punch 499.263
Intaglio della guarnizione con l'apposita punzonatrice 499.263

3.3 Notching the vertical weatherstrip intersection
3.3 Intaglio della guarnizione interna verticale punto di intersezione





4. Zuschnitt und Ausklinkung Innendichtung horizontal

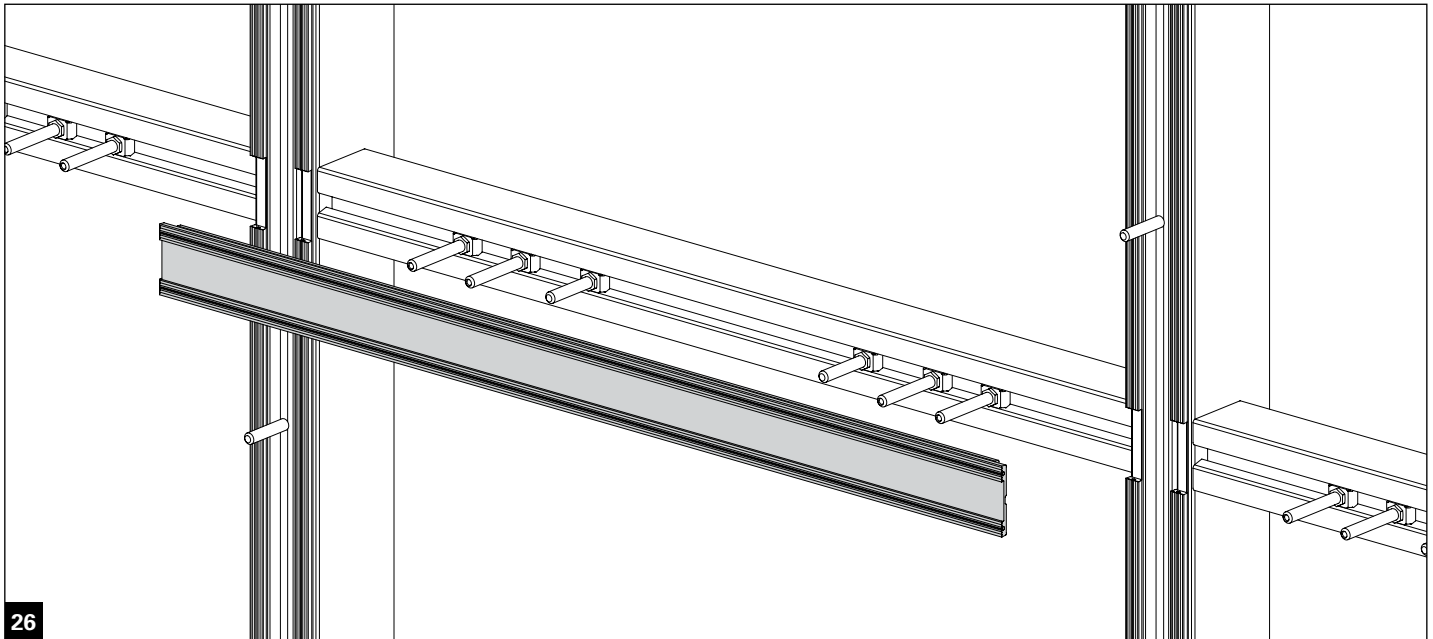
4. Cutting and notching the horizontal internal gasket

4. Découpe et entaille de joint intérieur horizontal

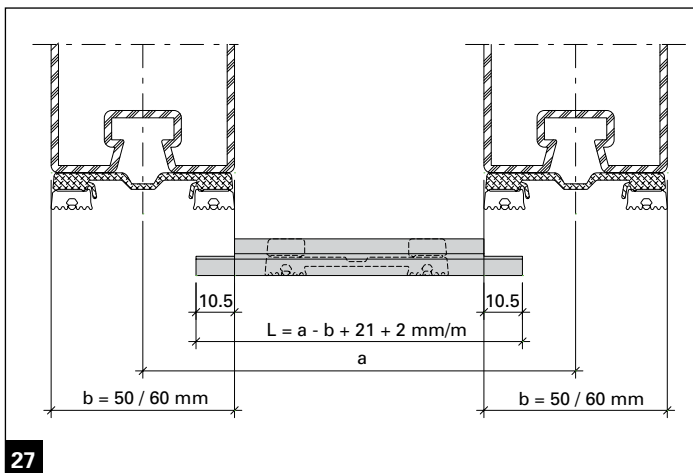
4. Taglio e intaglio delle guarnizioni interna orizzontale

4.1 Zuschnitt Innendichtung horizontal
 4.1 Découpe du joint intérieur horizontale

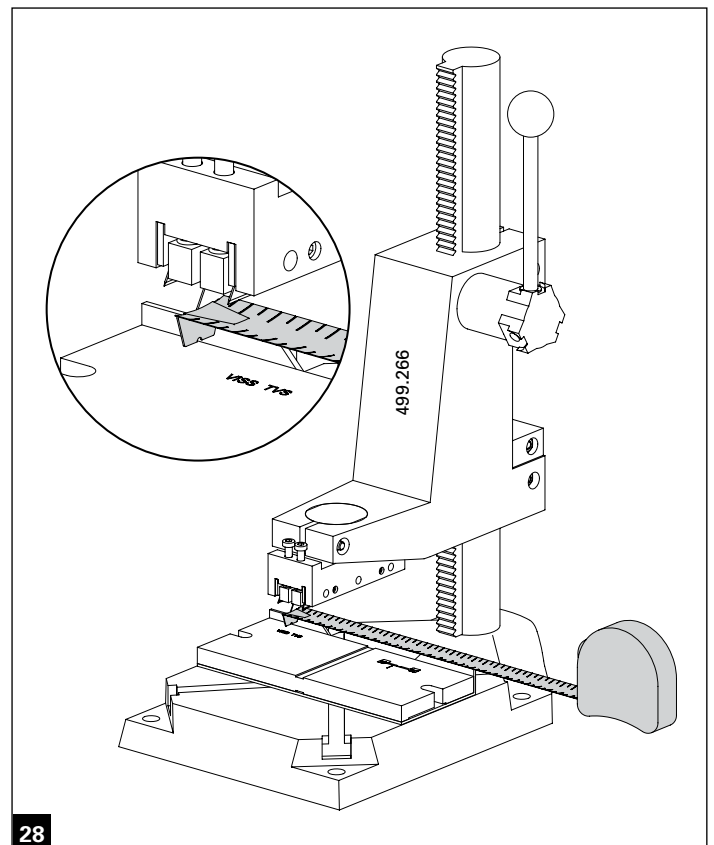
4.1 Cutting the horizontal internal gasket
 4.1 Taglio della guarnizione interna orizzontale



26



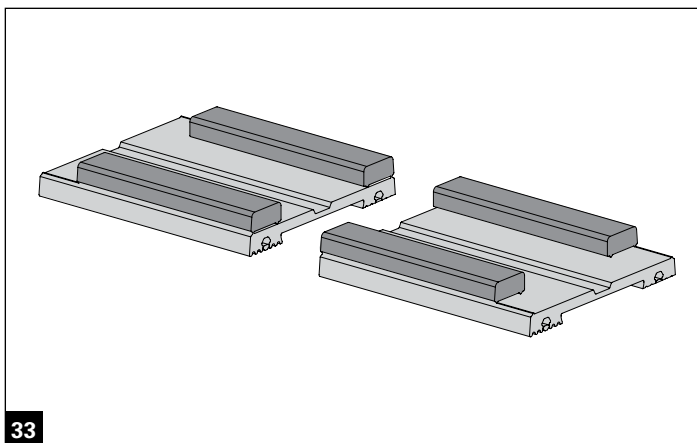
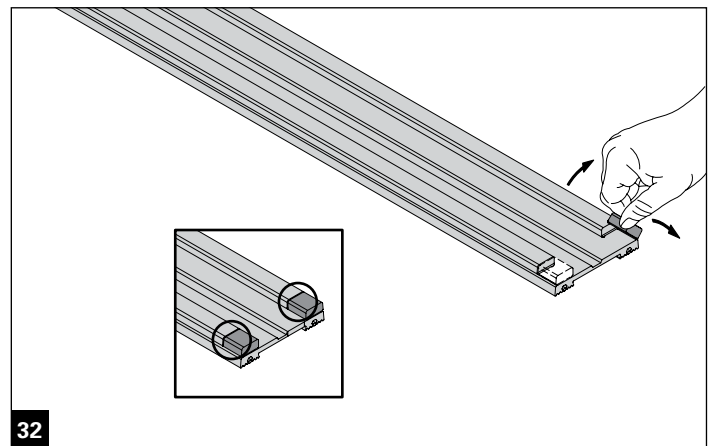
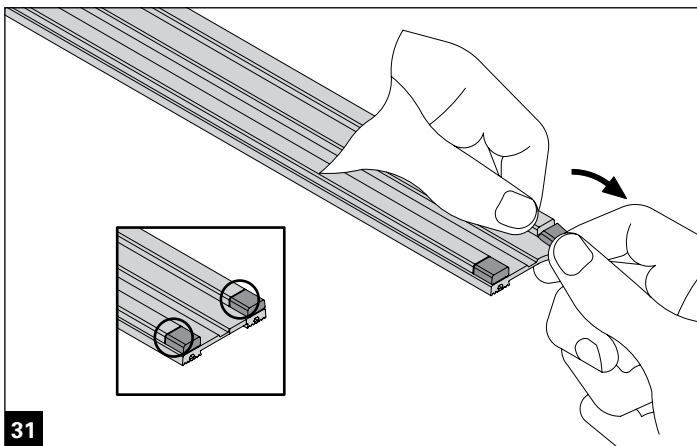
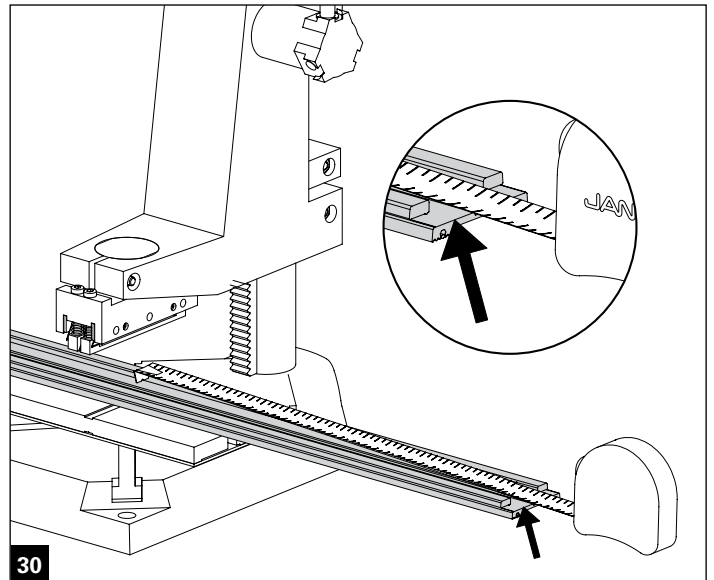
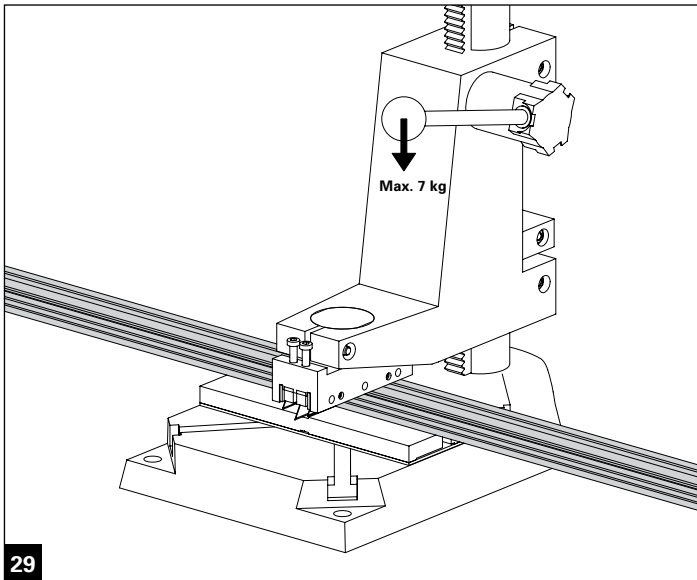
27



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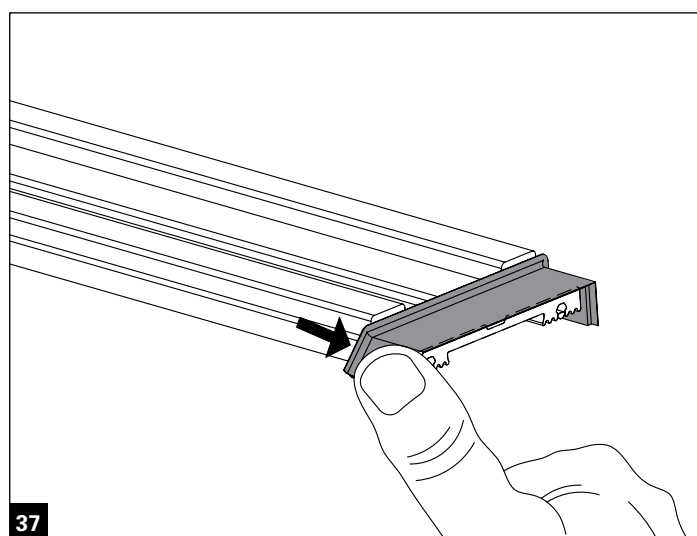
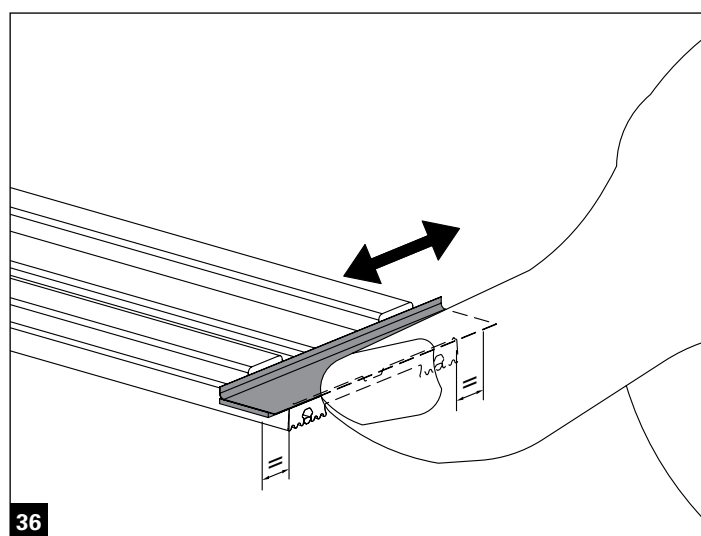
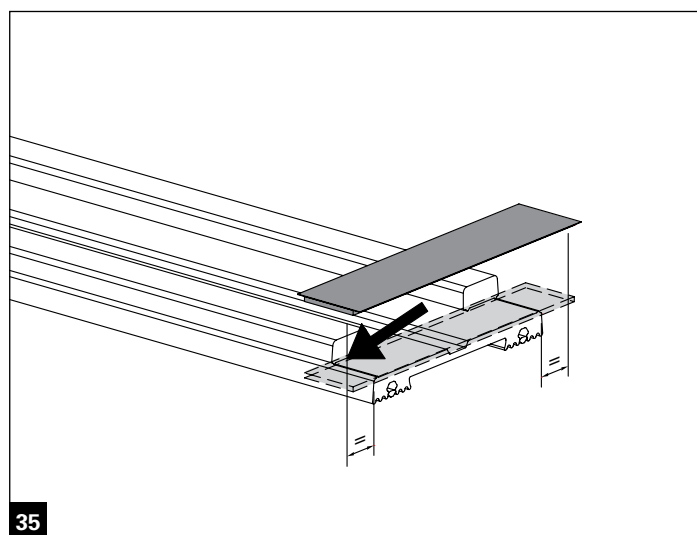
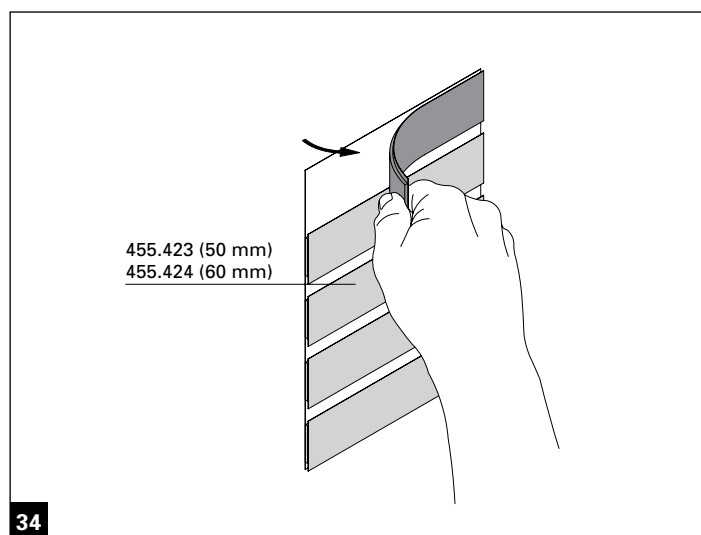
4.2 Ausklinkung Innendichtung horizontal
4.2 Entaille de joint intérieur horizontal

4.2 Notching the horizontal internal weatherstrip
4.2 Intaglio della guarnizione interna orizzontale



4.3 Aufbringung Butyl-Dichtstreifen
4.3 Pose d'une bande d'étanchéité en butyle

4.3 Application of the butyl sealing strips
4.3 Applicazione della striscia di sigillante butilico

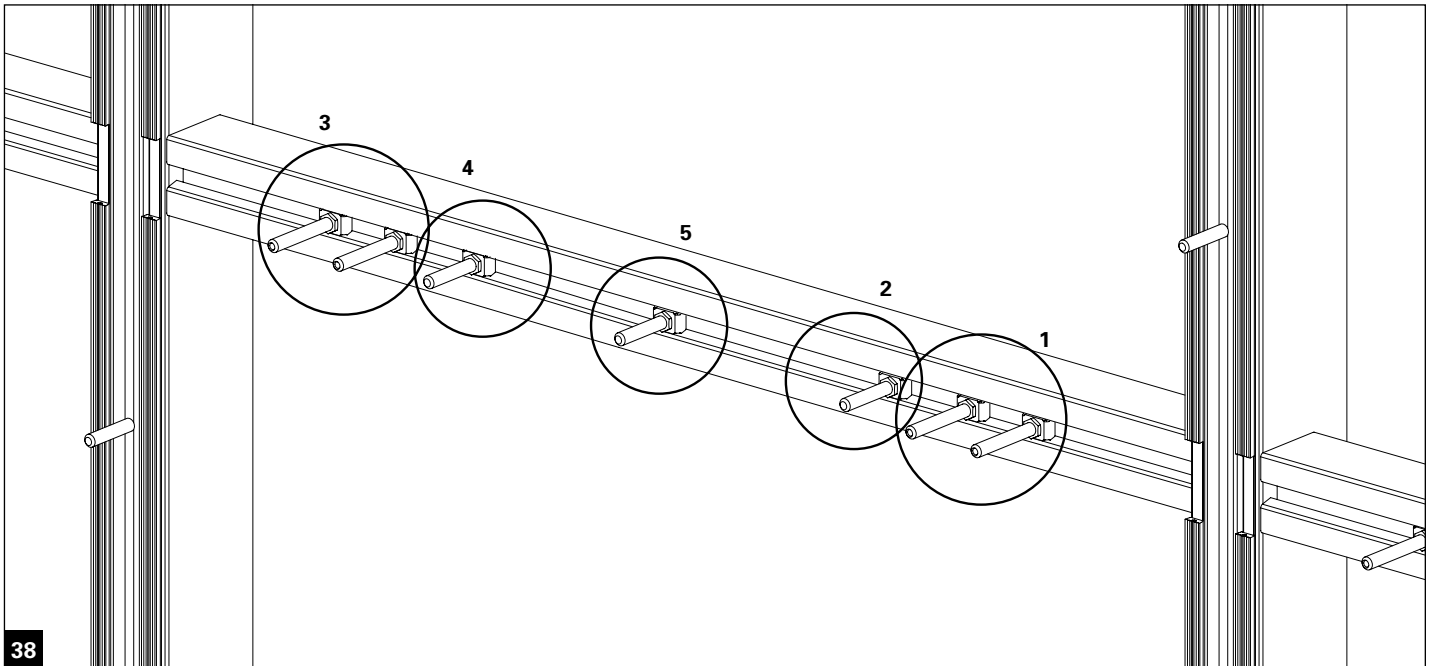


5. Montage Innendichtung horizontal

5. Assembly horizontal internal gasket

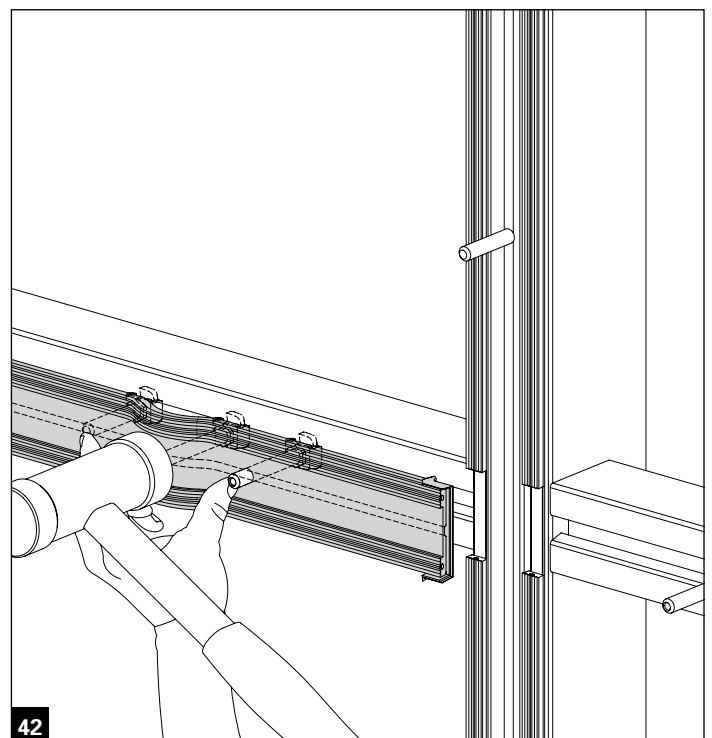
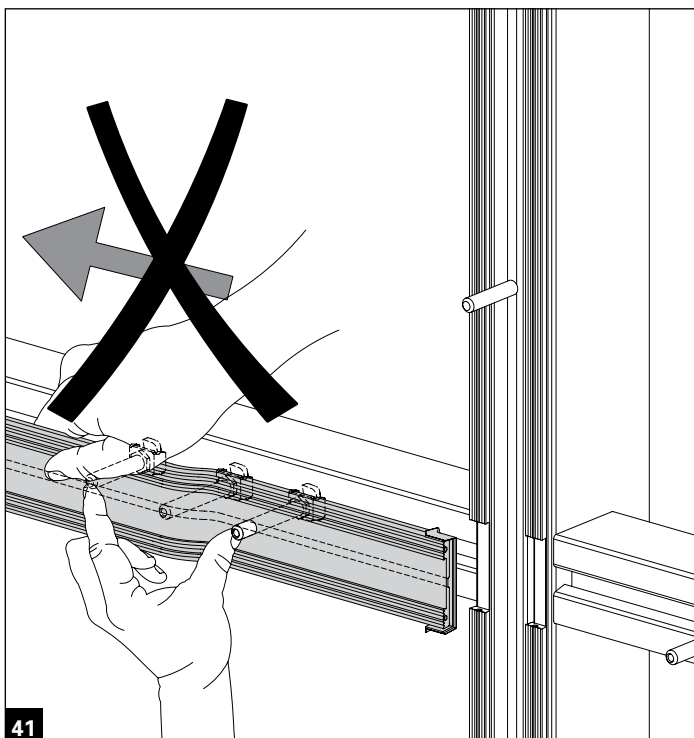
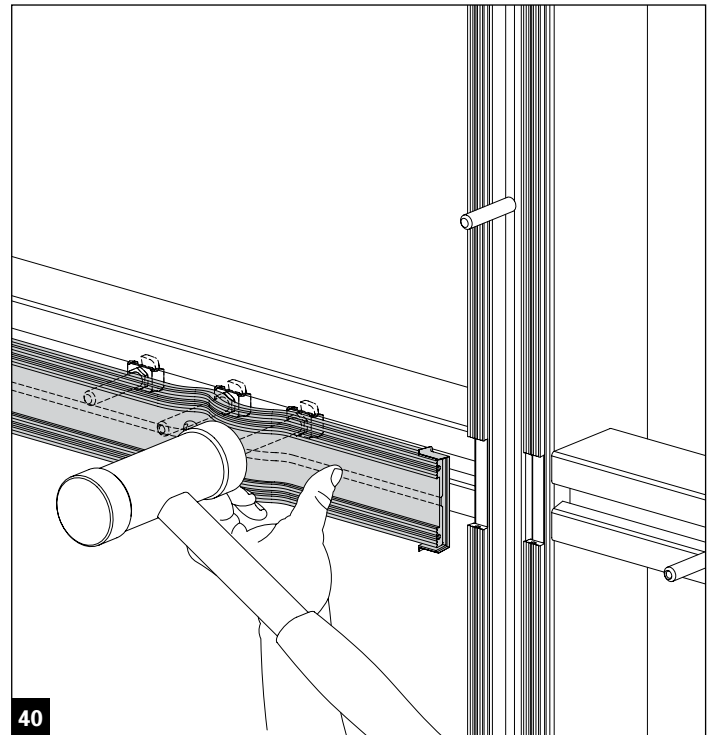
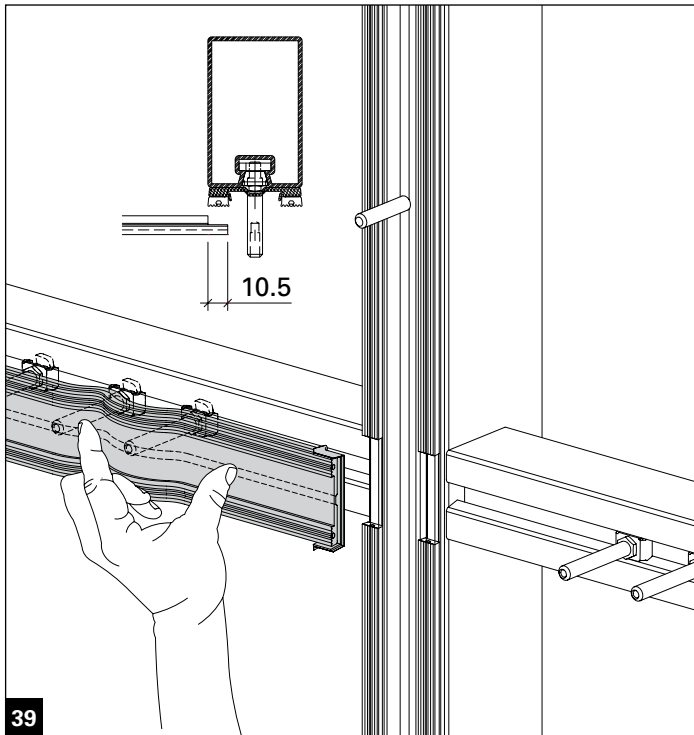
5. Montage joint intérieure horizontal

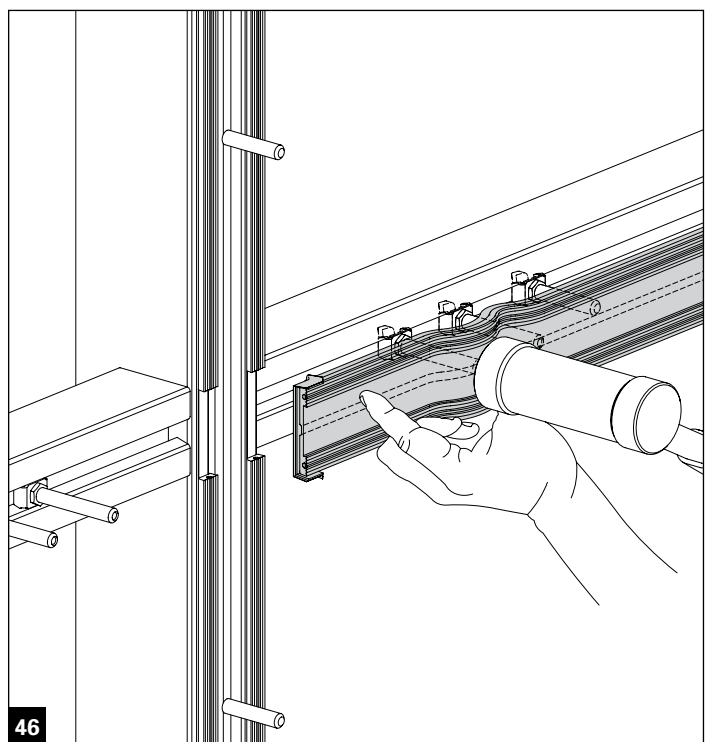
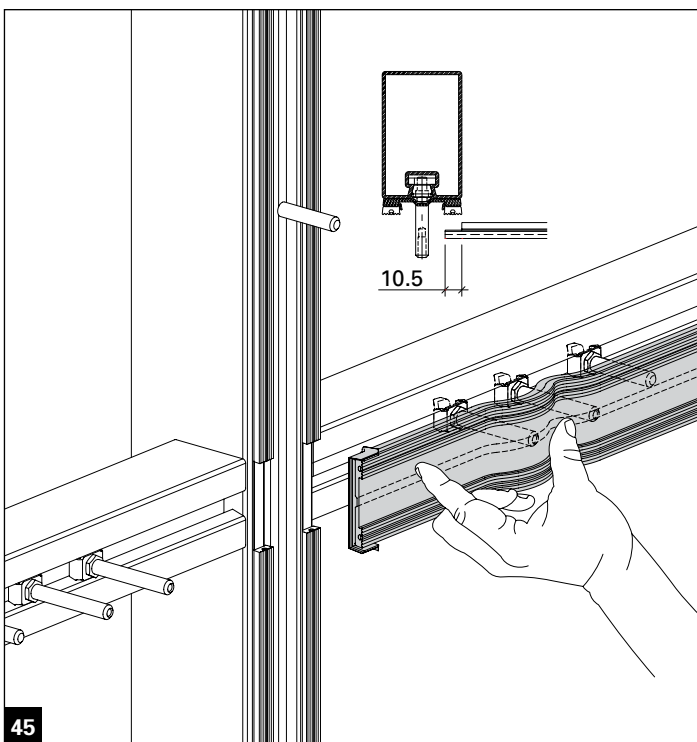
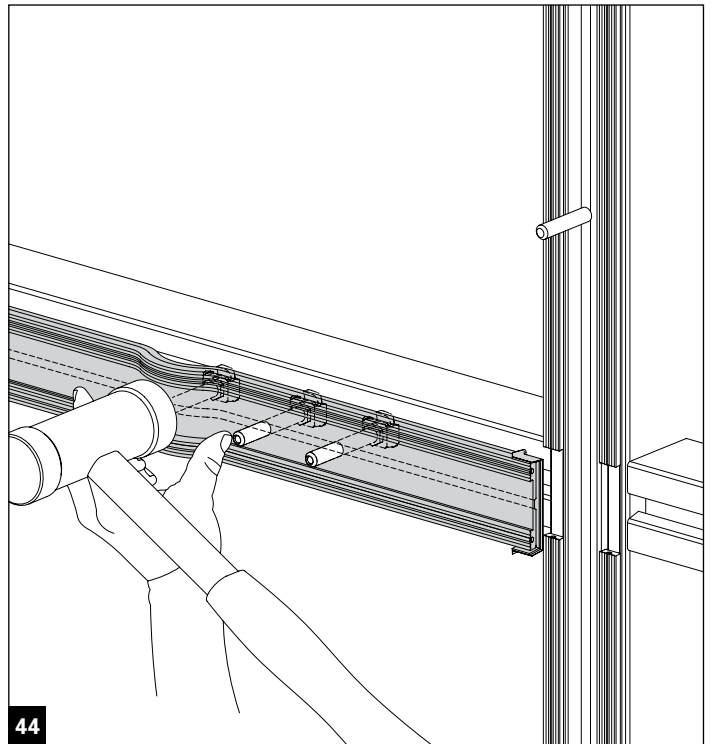
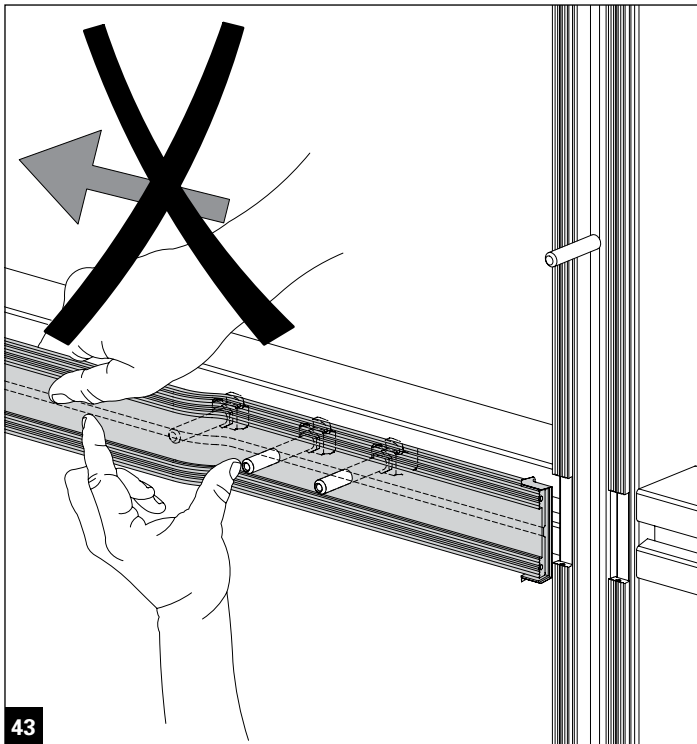
5. Montaggio guarnizione interna orizzontale

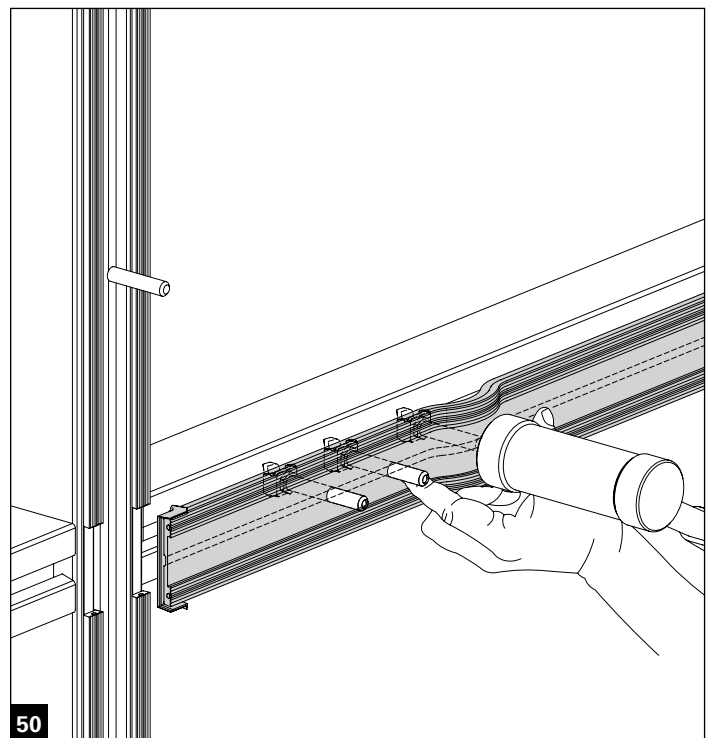
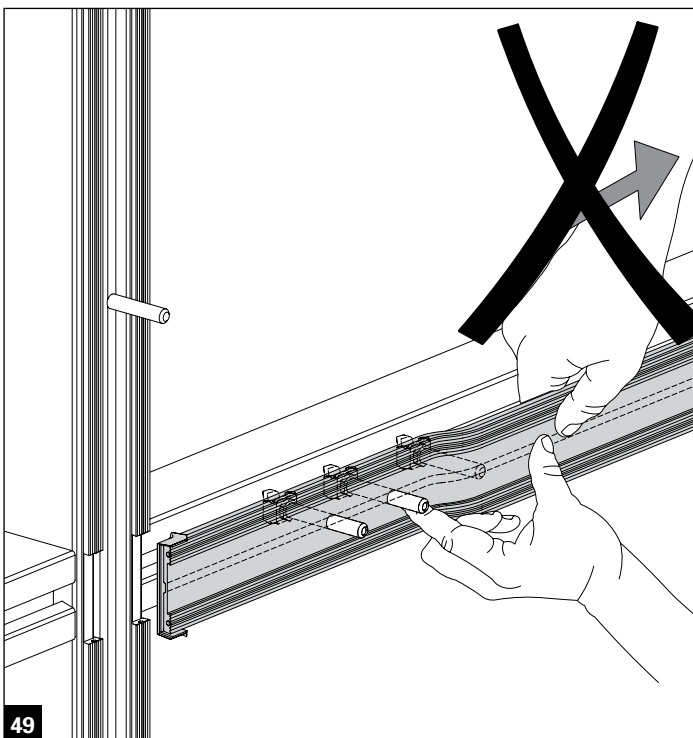
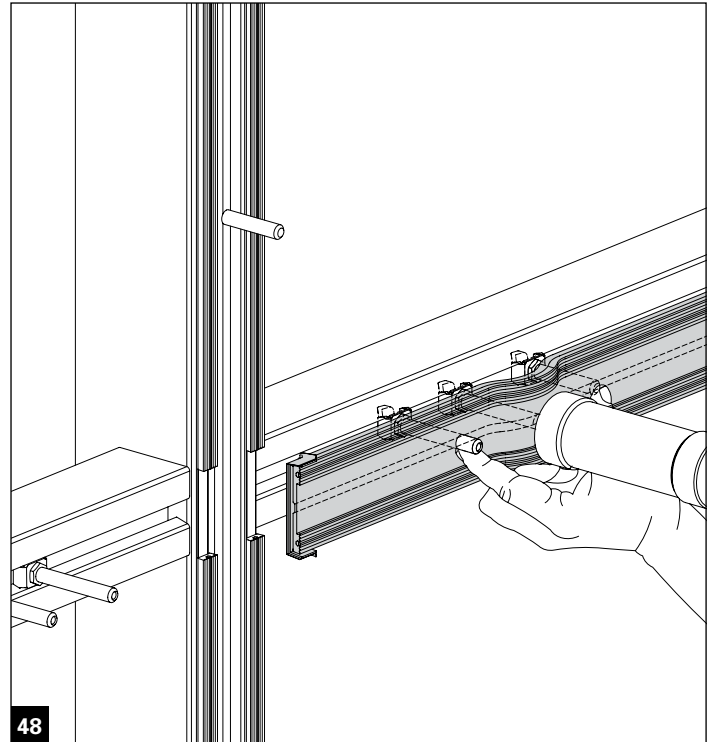
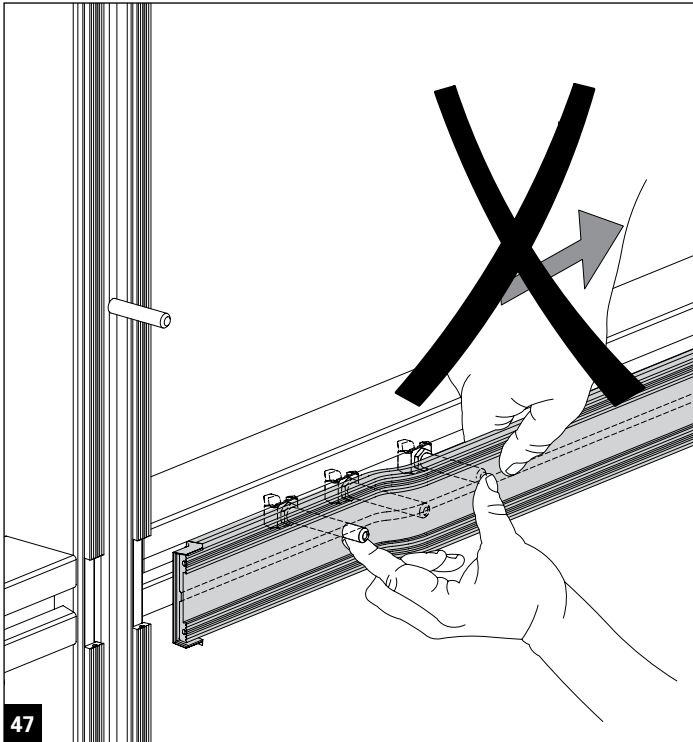


5.1 Montage Innendichtung horizontal
5.1 Montage joint intérieur horizontal

5.1 Assembly horizontal internal gasket
5.1 Montaggio guarnizione interna orizzontale

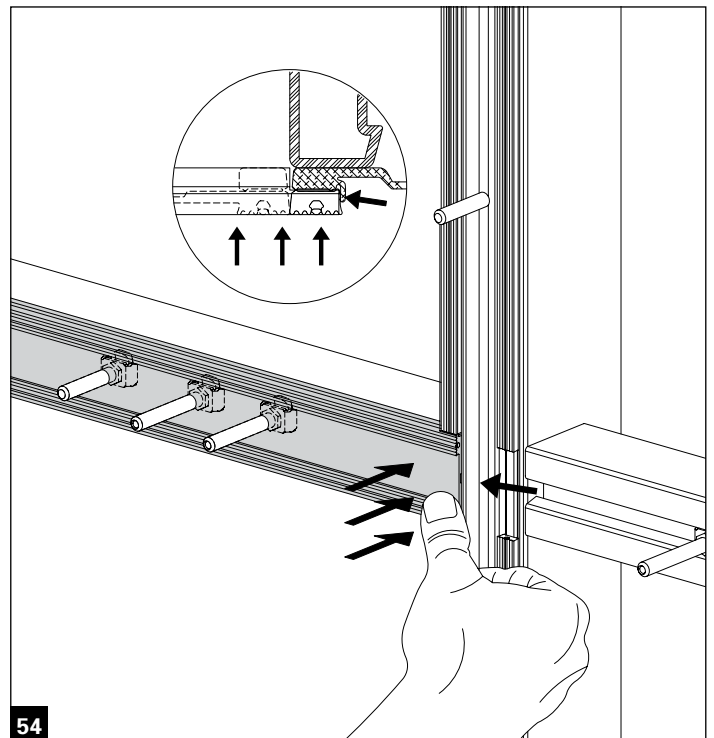
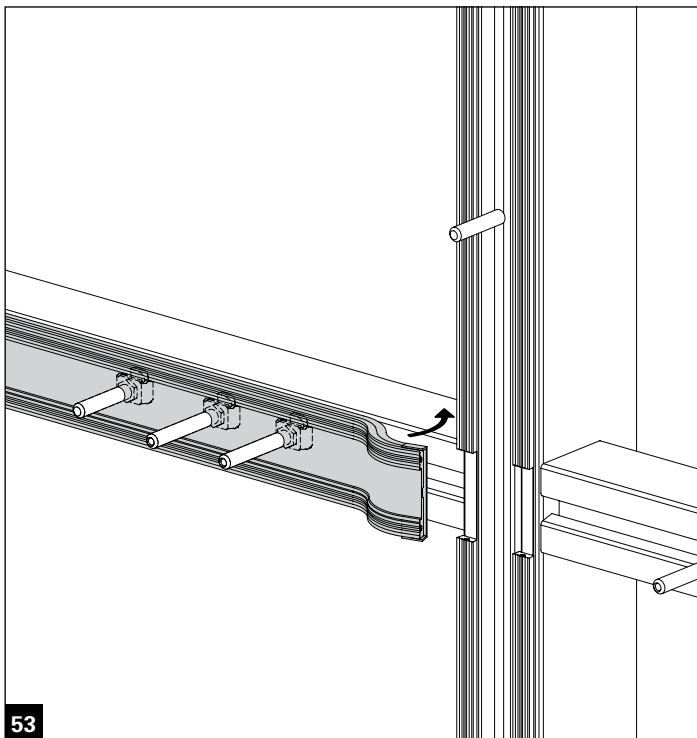
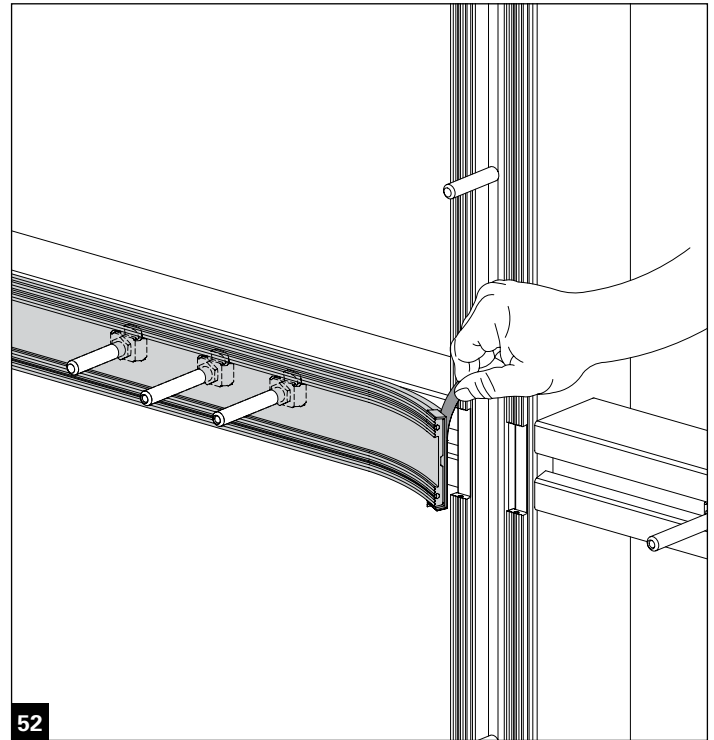
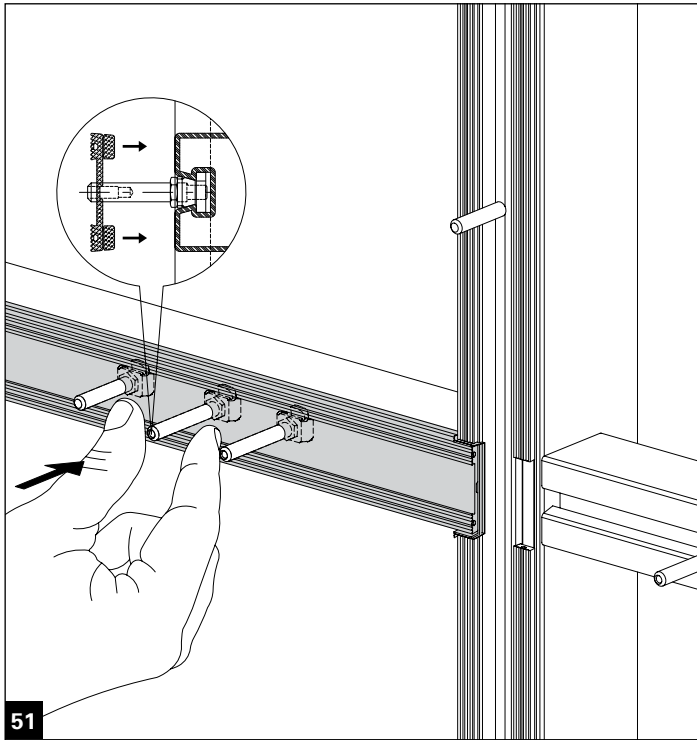






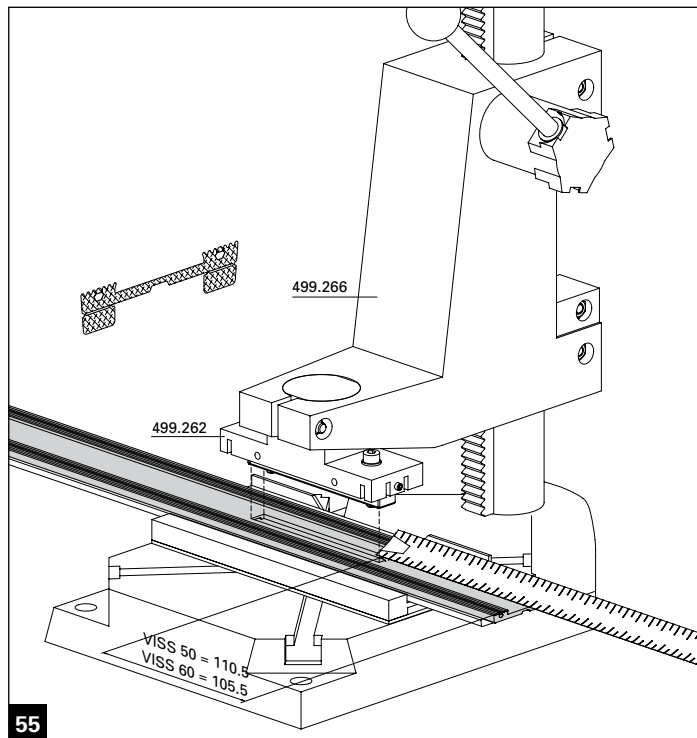
5.2 Verklebung der Innendichtung
5.2 Collage joint intérieur

5.2 Bonding of the internal weatherstrip
5.2 Incollaggio della guarnizione interna



5.3 Ausnehmung Glasaufleger eingeschweisst
5.3 Évidement soudé dans la zone du support de vitrage

5.3 Recess in area of welded glazing support
5.3 Asola per il supporto vetro saldato

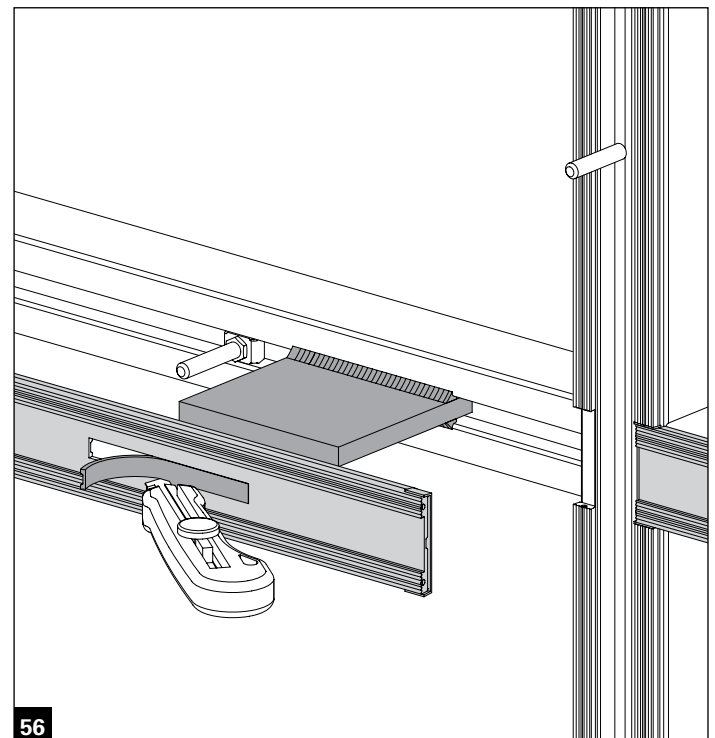


Ausklinkung mit Dichtungsstanze 499.266 und Stanzwerkzeug 499.262

Entaille avec poinçon à joints 499.266 et outil de poinçonnage 499.262

Notching with gasket punch 499.266 and punching tool 499.262

Intaglio della guarnizione con l'apposita punzonatrice 499.266 e trancia 499.262

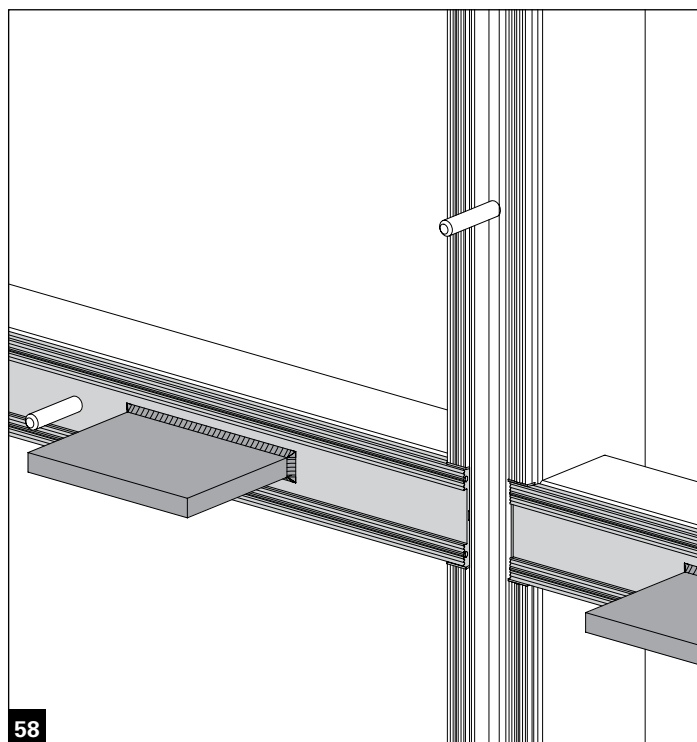
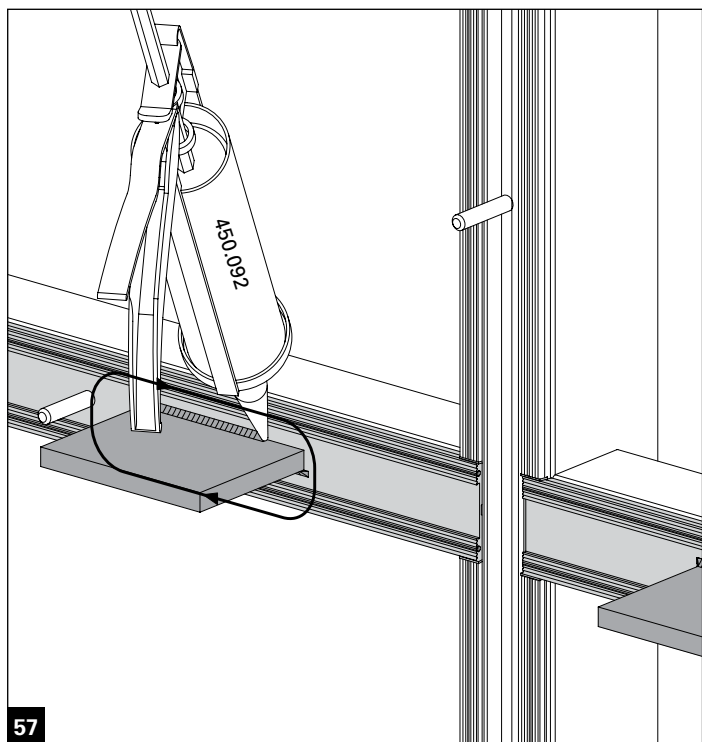


Alternative: Ausklinkung der Dichtung mit Cutter

Alternative: Entaille du joint avec couteau

Alternative: Notching gasket with cutter

In alternativa: Intaglio della guarnizione con un trincetto



Klebefläche reinigen mit 450.091

Nettoyer la surfaces de collage avec 450.091

Clean adhesive surface with 450.091

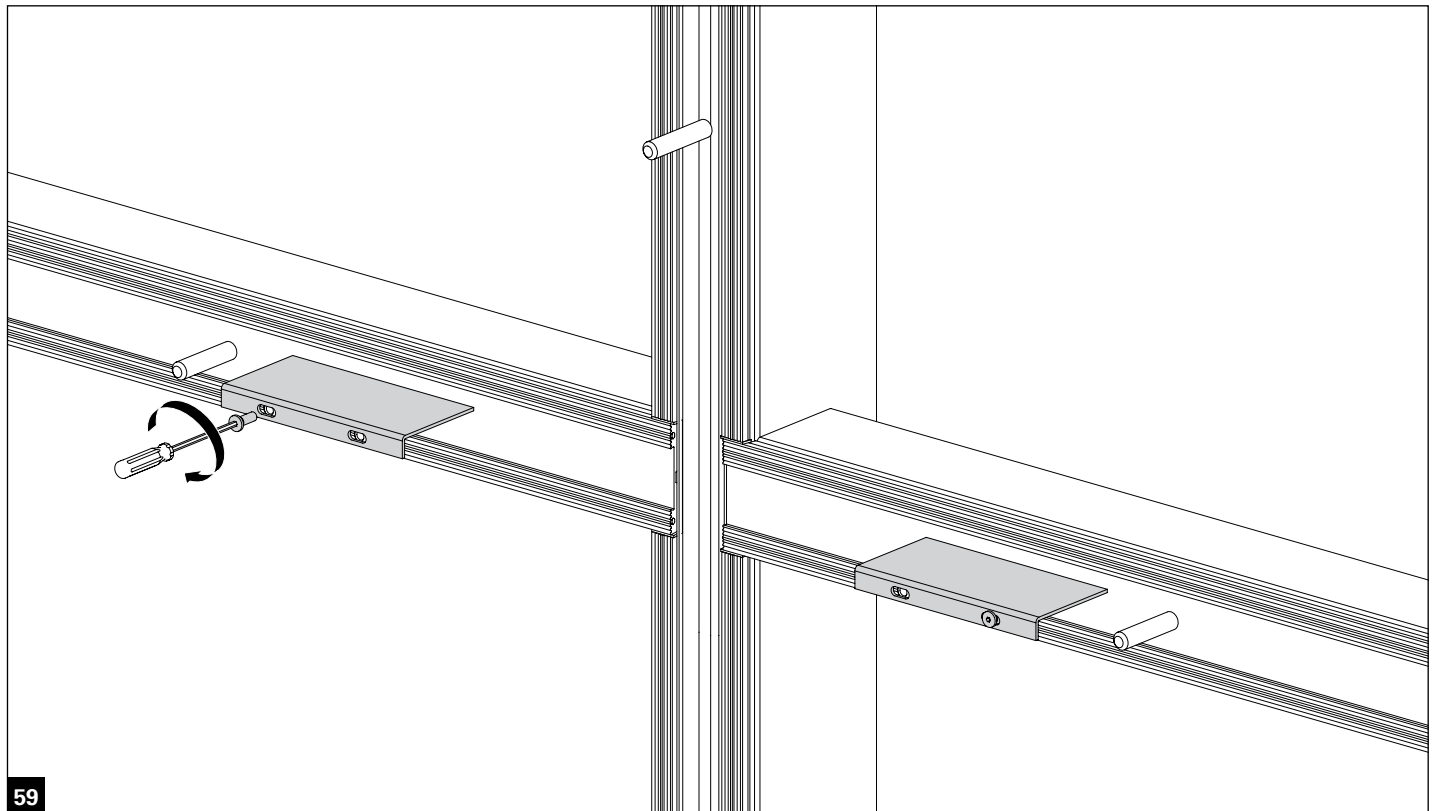
Pulire la superficie di incollaggio con 450.091

6. Montage Glasauflage und Glasklotz

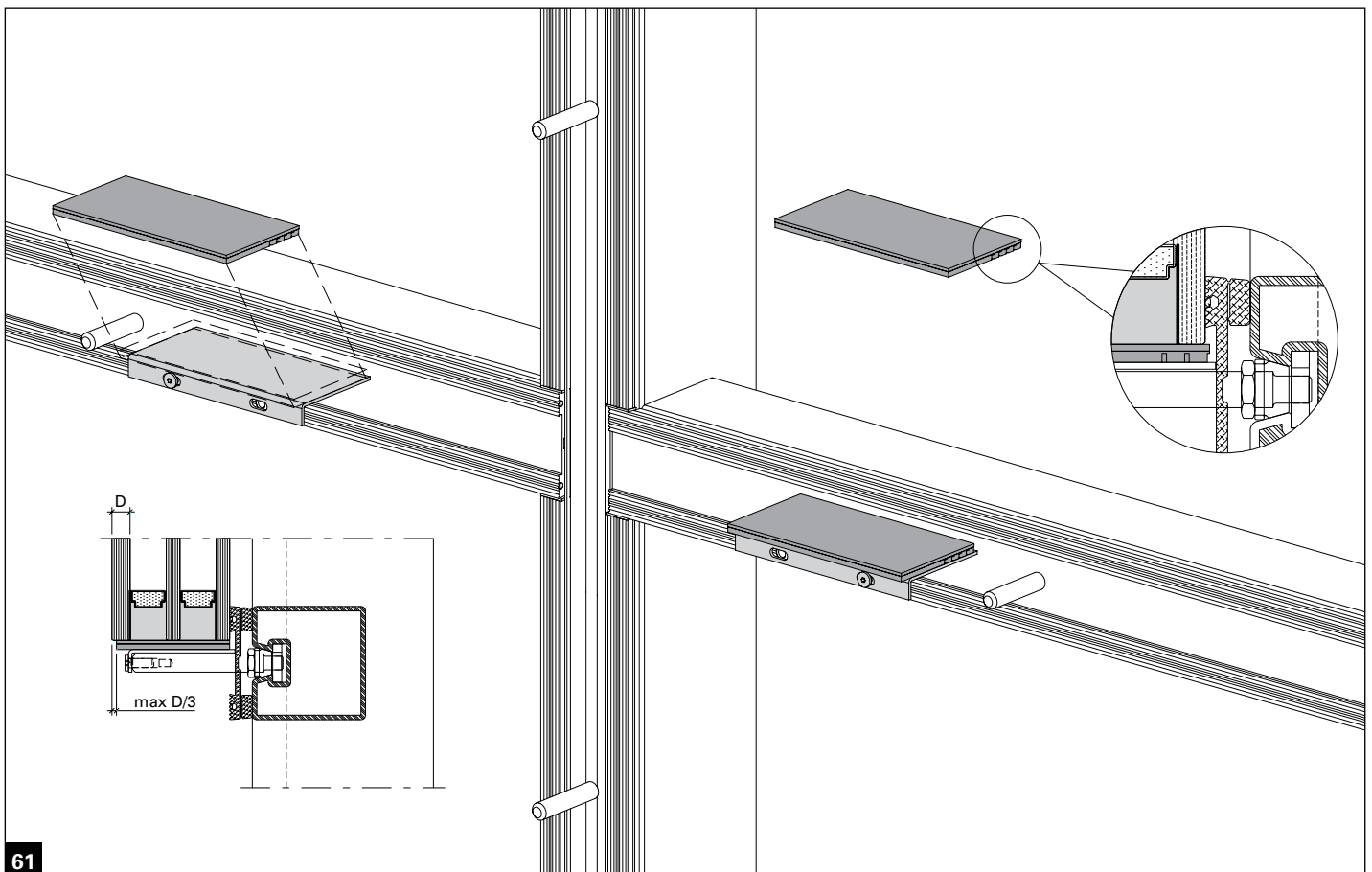
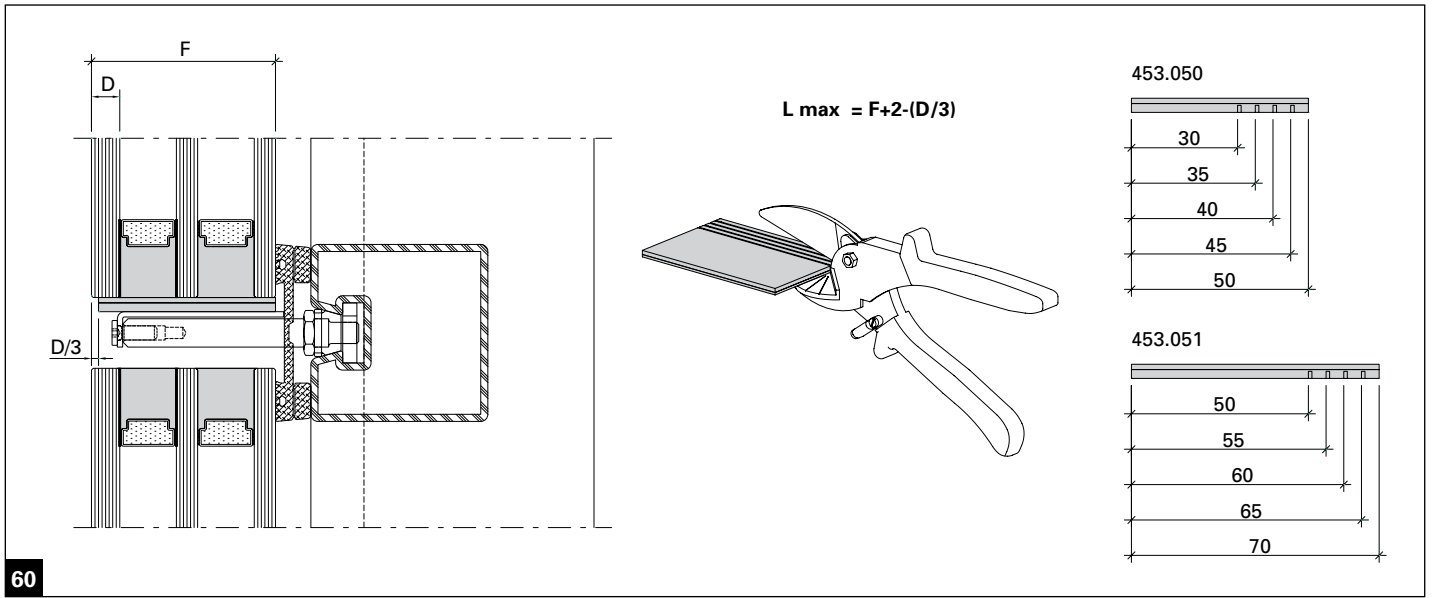
6. Installation of glass support and glazing block

6. Montage du support et de la cale de vitrage

6. Montaggio del supporto vetro e dello spessore vetro



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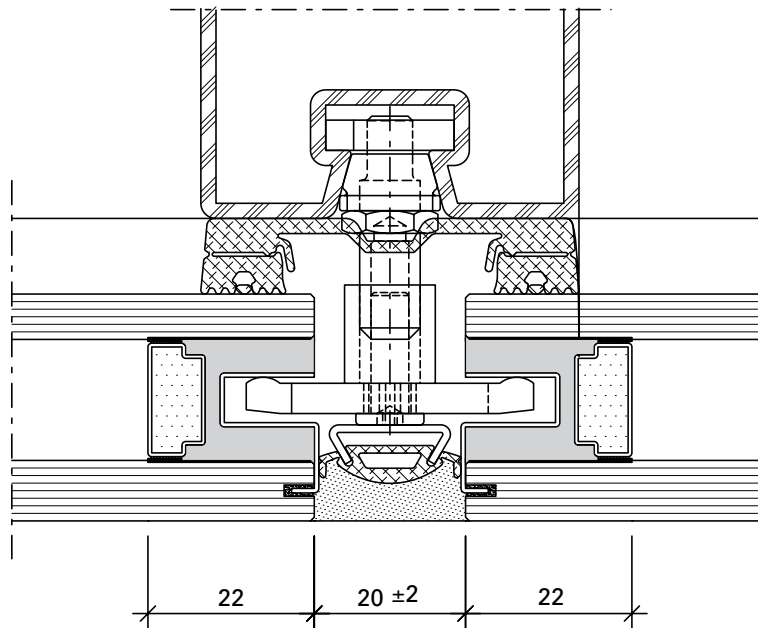
7. Glaseinstand

7. Glass edge cover

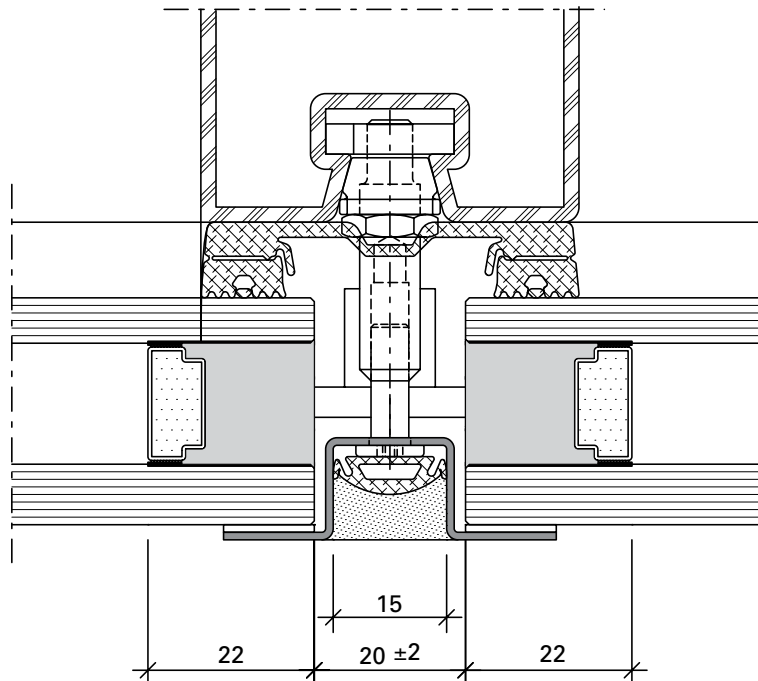
7. Prise en feuillure

7. Posizionamento del vetro

Variante 1



Variante 2

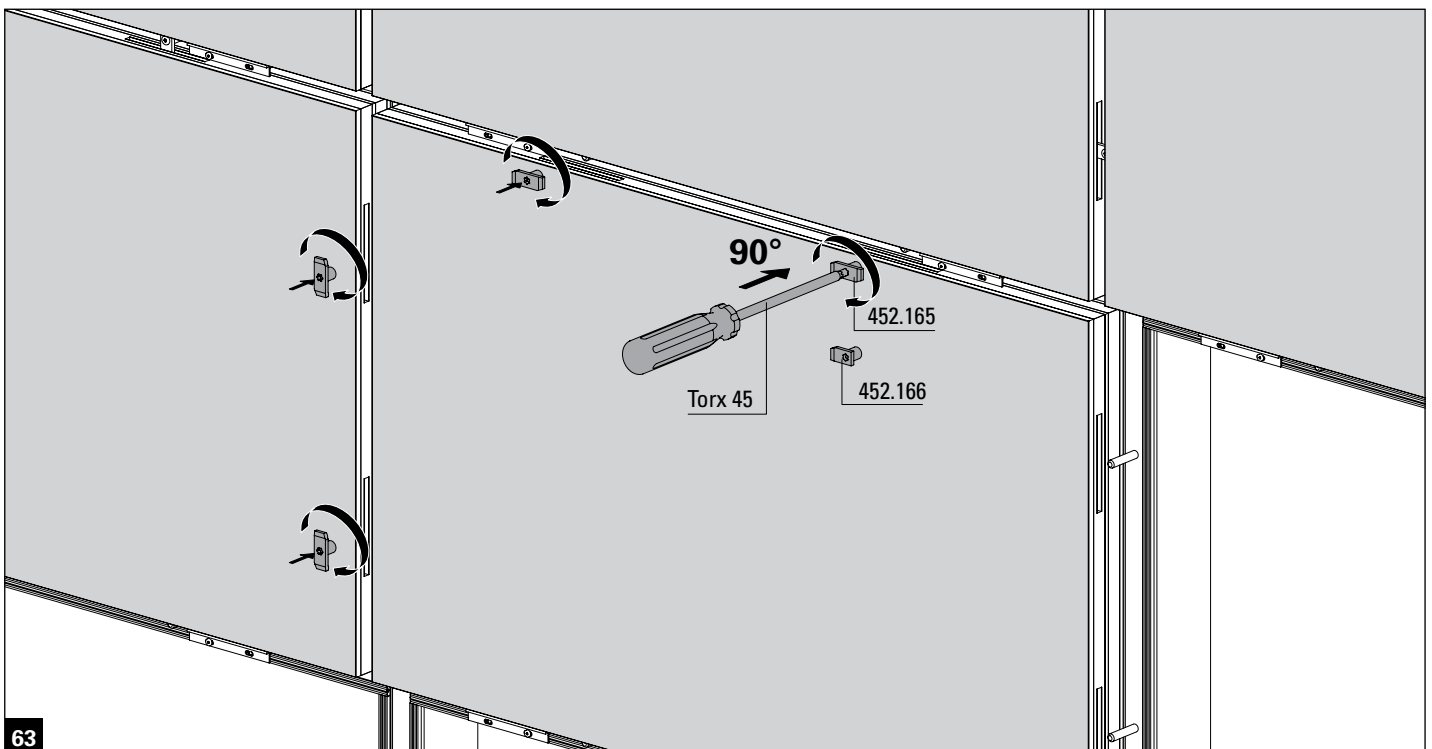
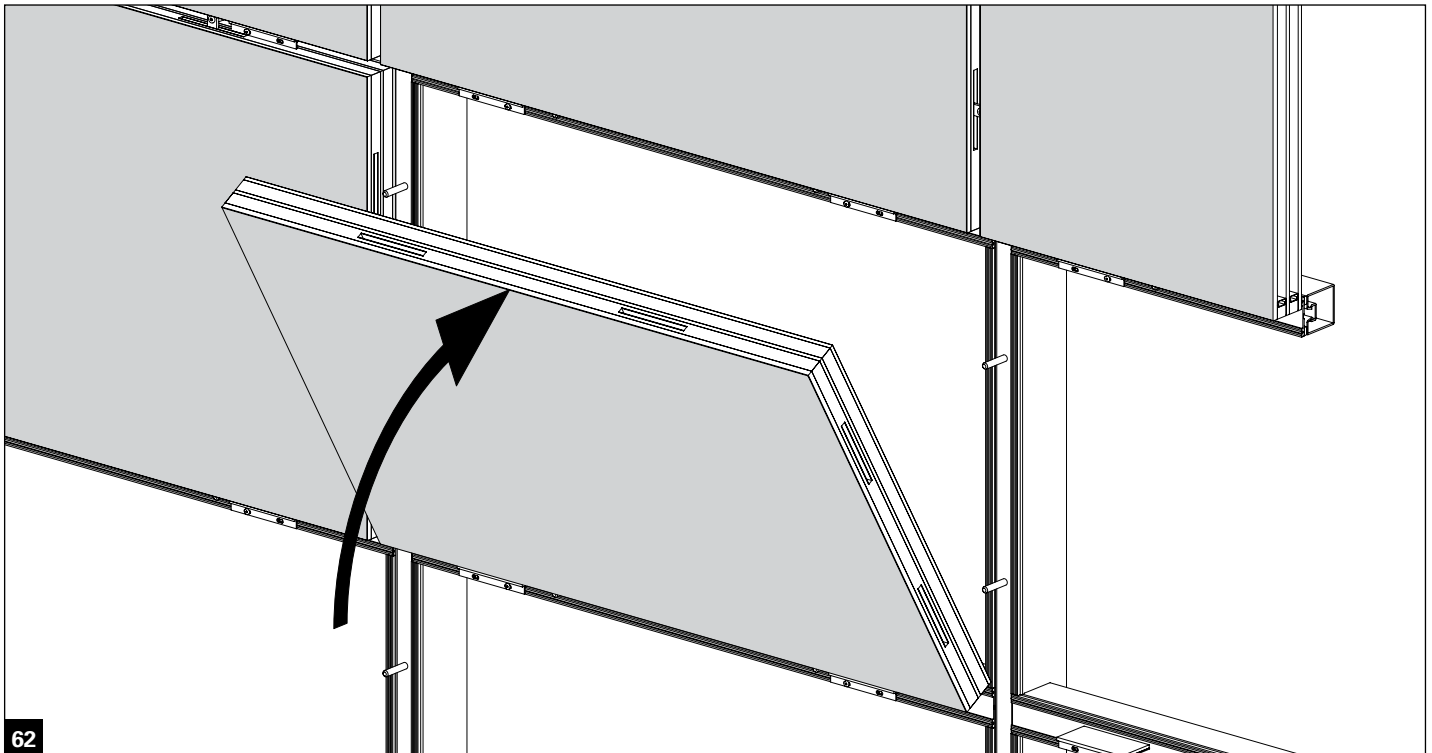


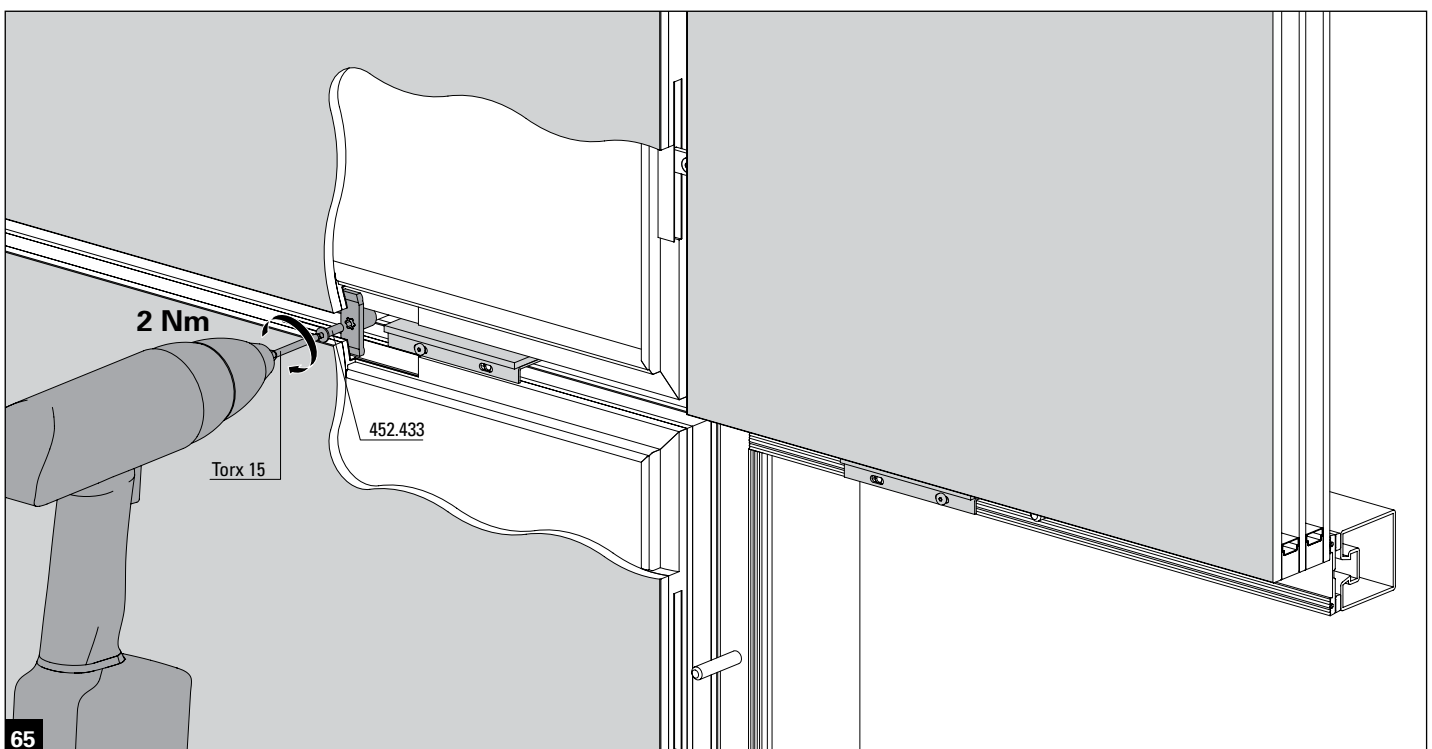
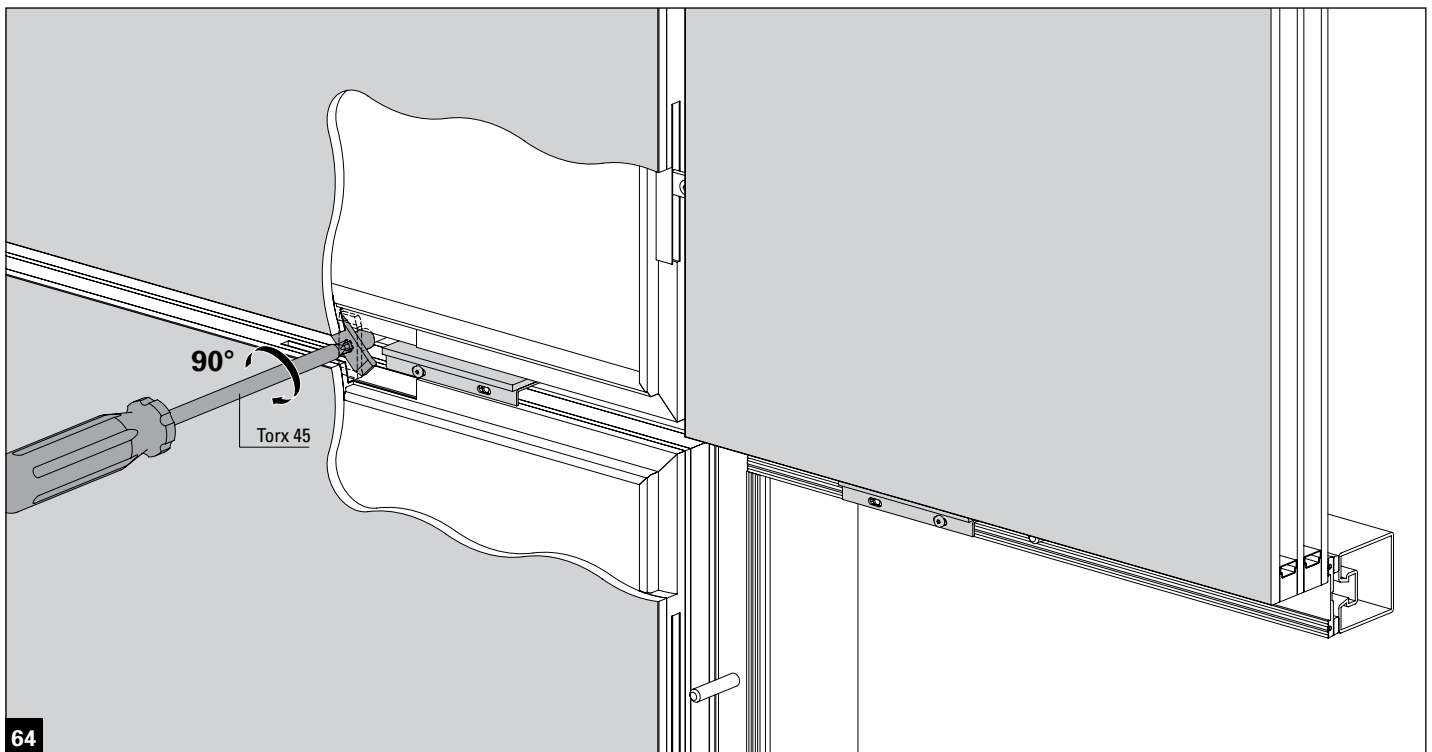
8. Einbau Füllelemente

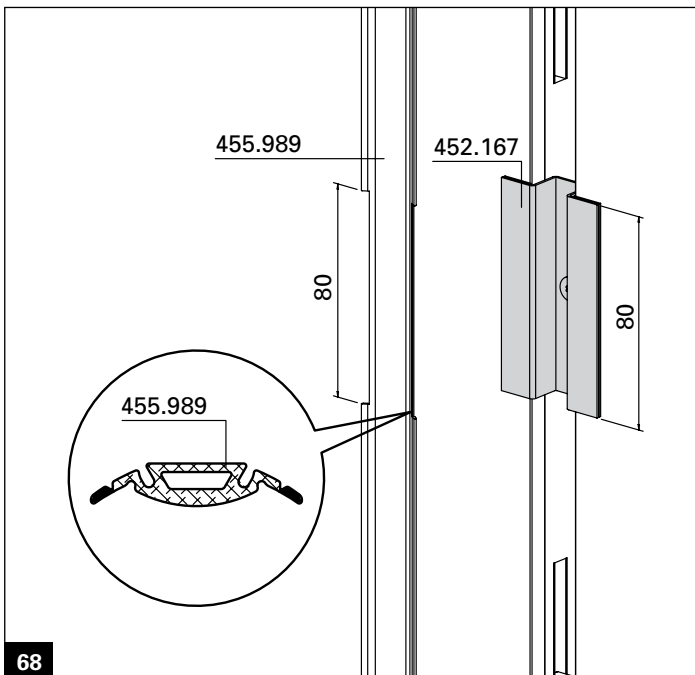
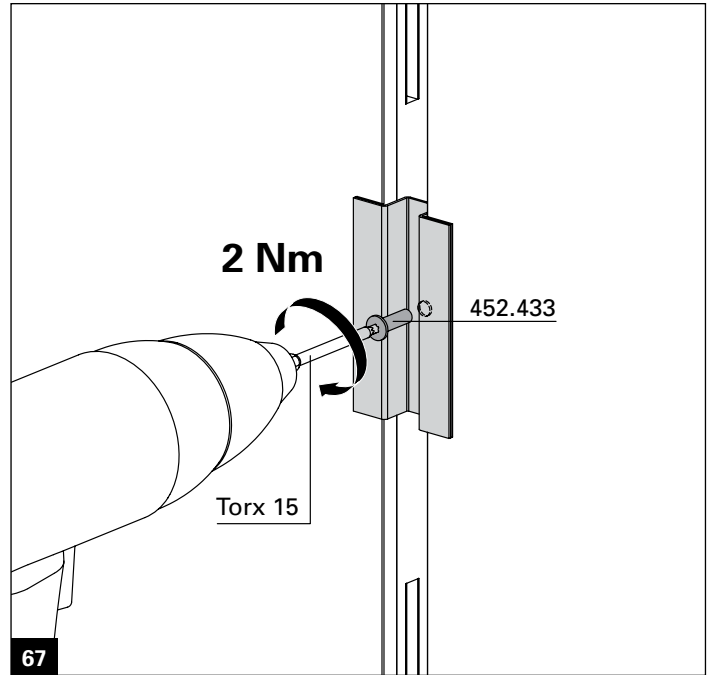
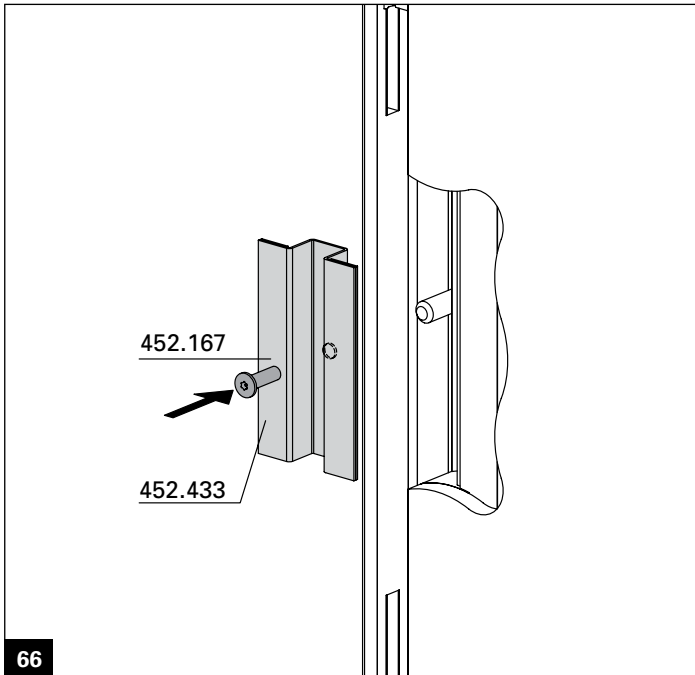
8. Inserting infill units

8. Montage des éléments de remplissage

8. Montaggio degli elementi di riempimento







9. Zuschnitt und Montage Glasfalzprofil und Dichtung

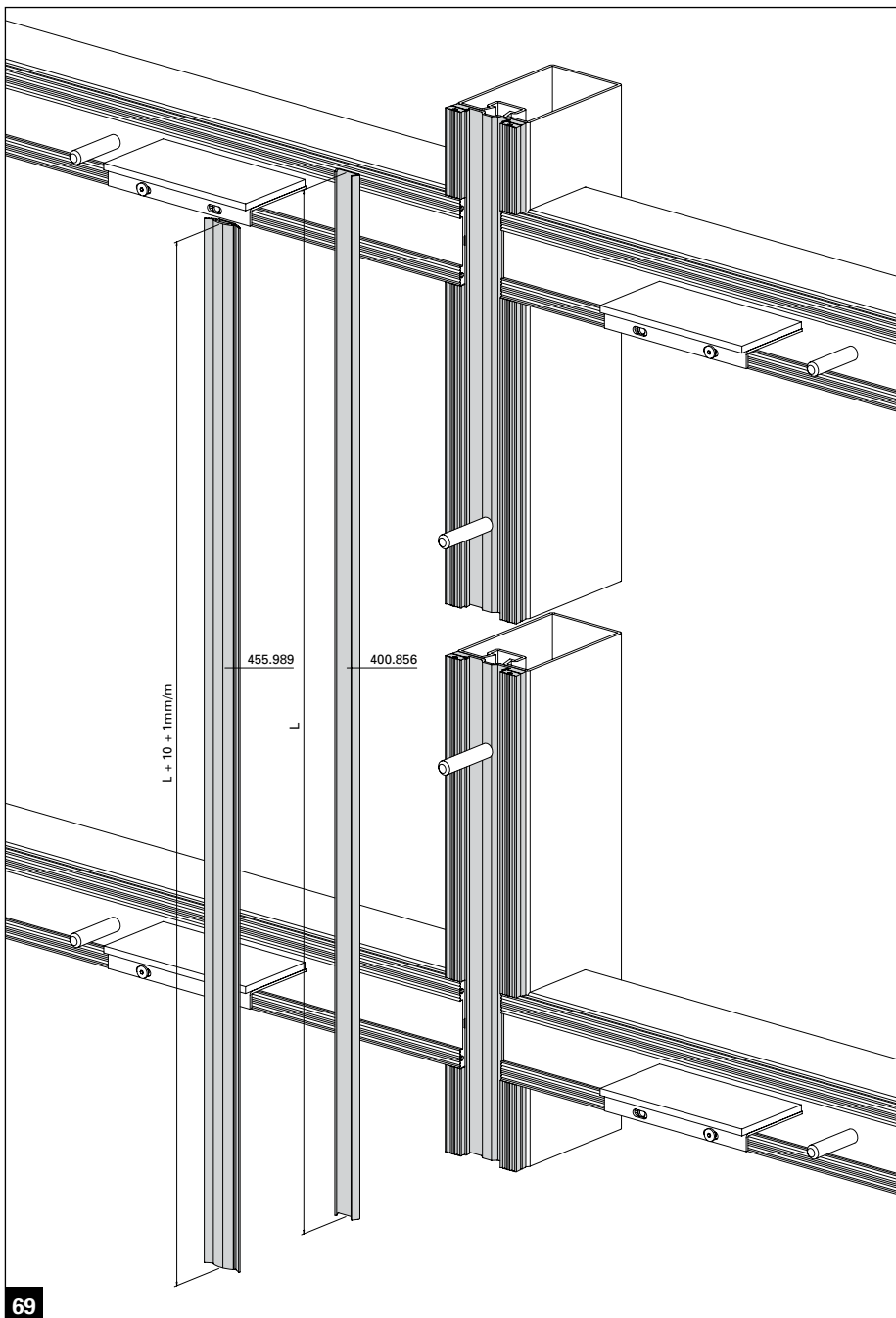
9. Cutting and installation glazing rebate profile and gasket

9. Découpe et montage profilé de feuillure de verre et joint

9. Taglio e montaggio del profilo d'appoggio e della guarnizione

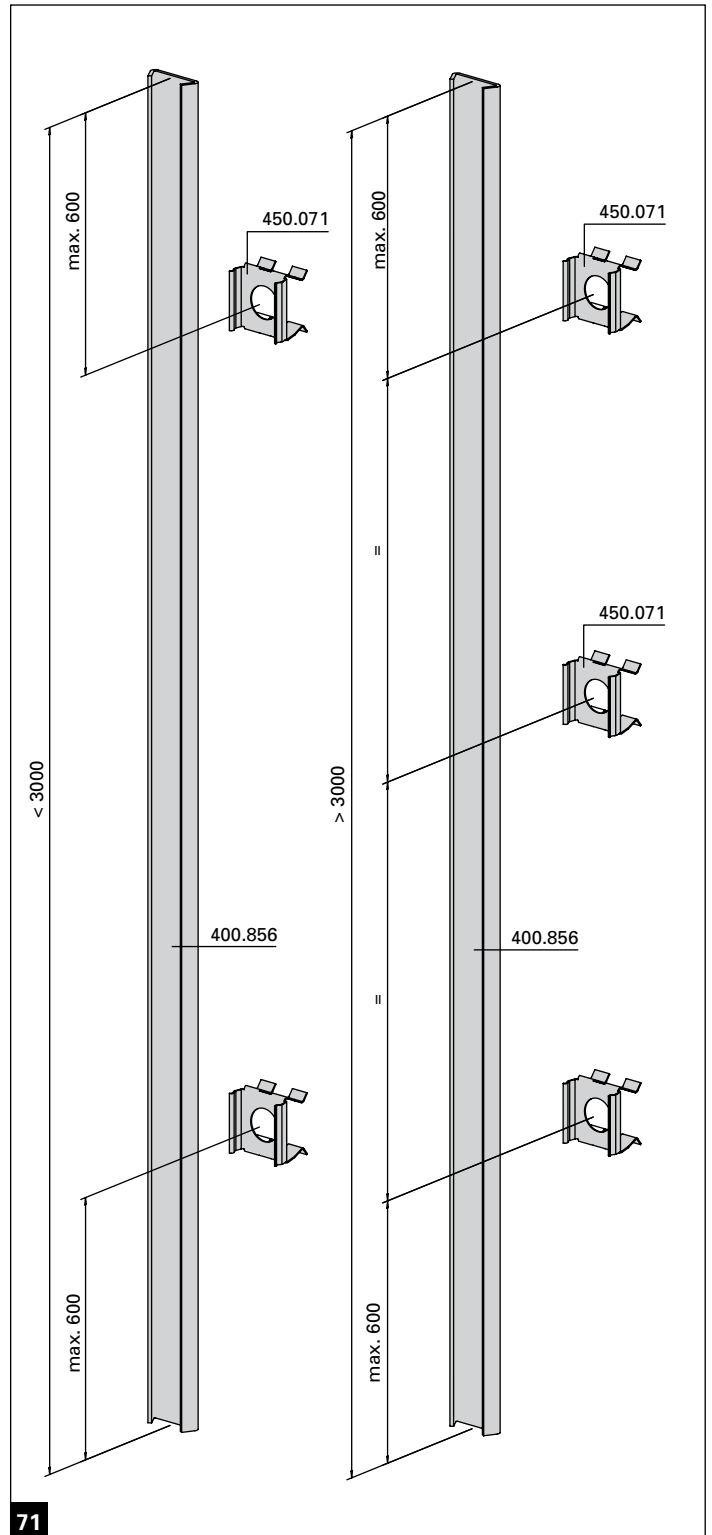
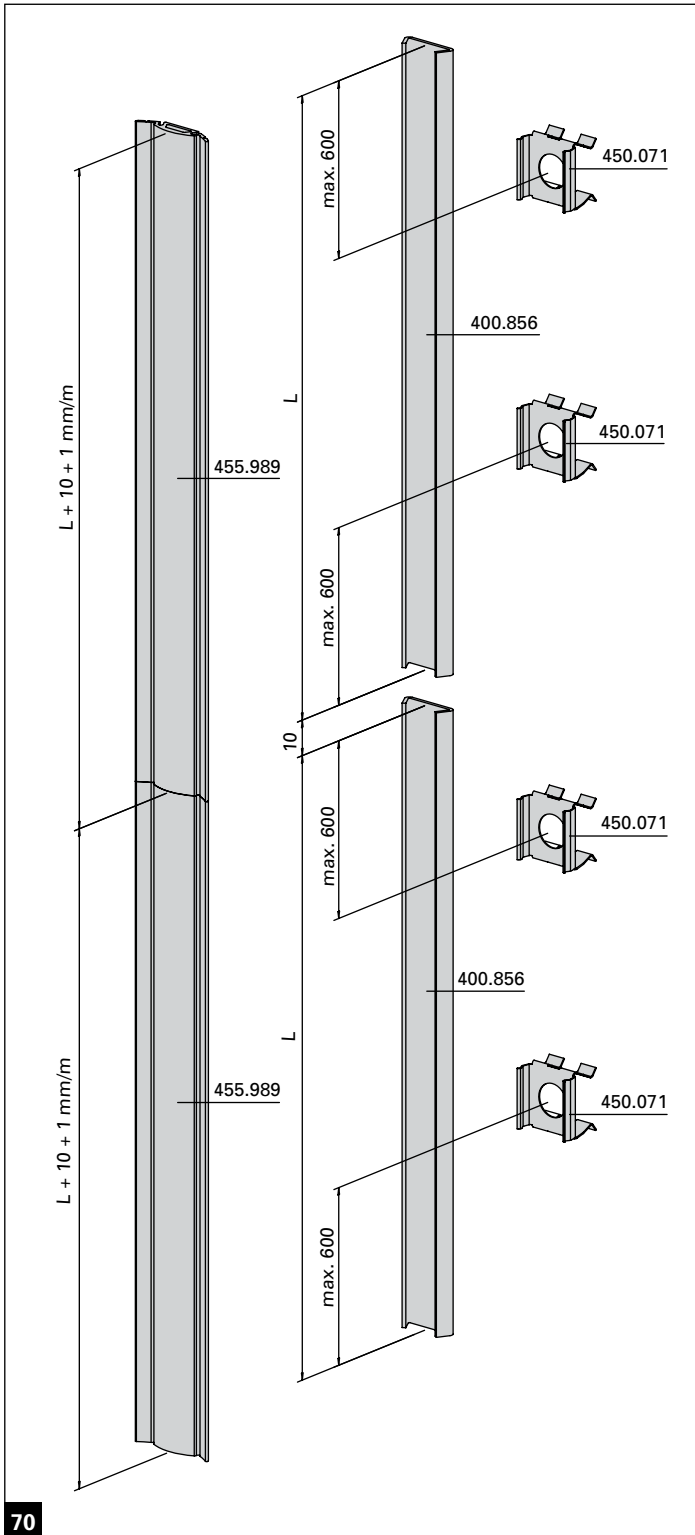
9.1 Zuschnitt Glasfalzprofil und Dichtung vertikal
9.1 Coupe de profilés de feuillure de verre et joint vertical

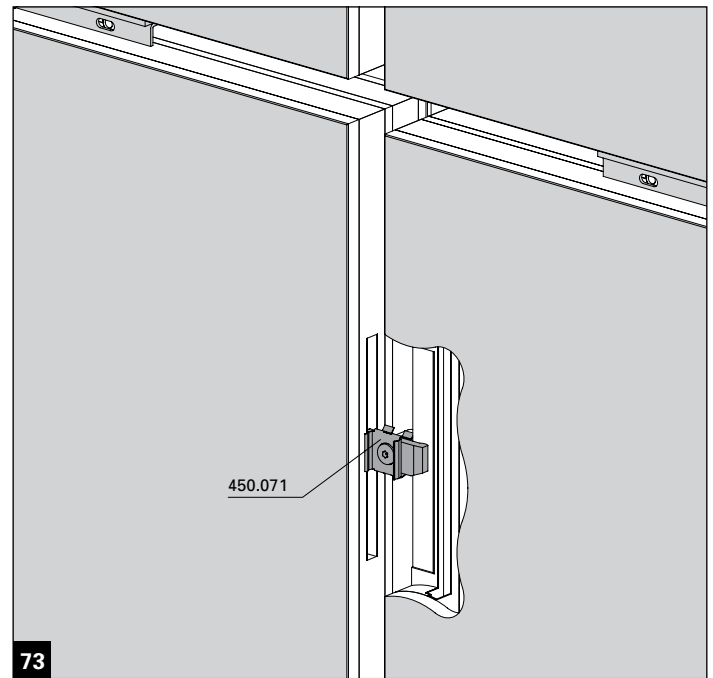
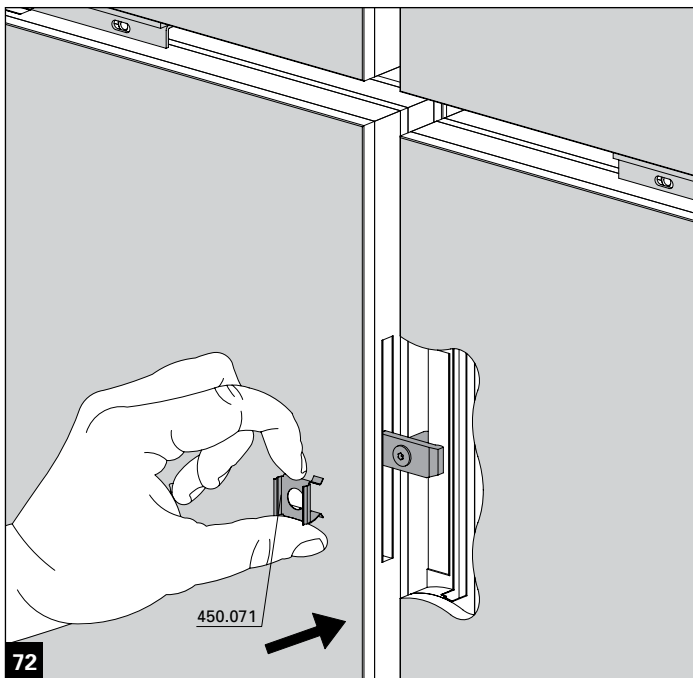
9.1 Cutting of vertical glazing rebate profile and gasket
9.1 Taglio del profilo d'appoggio e della guarnizione verticale



9.2 Ausbildung Vertikalstoss
 9.2 Réalisation joint vertical

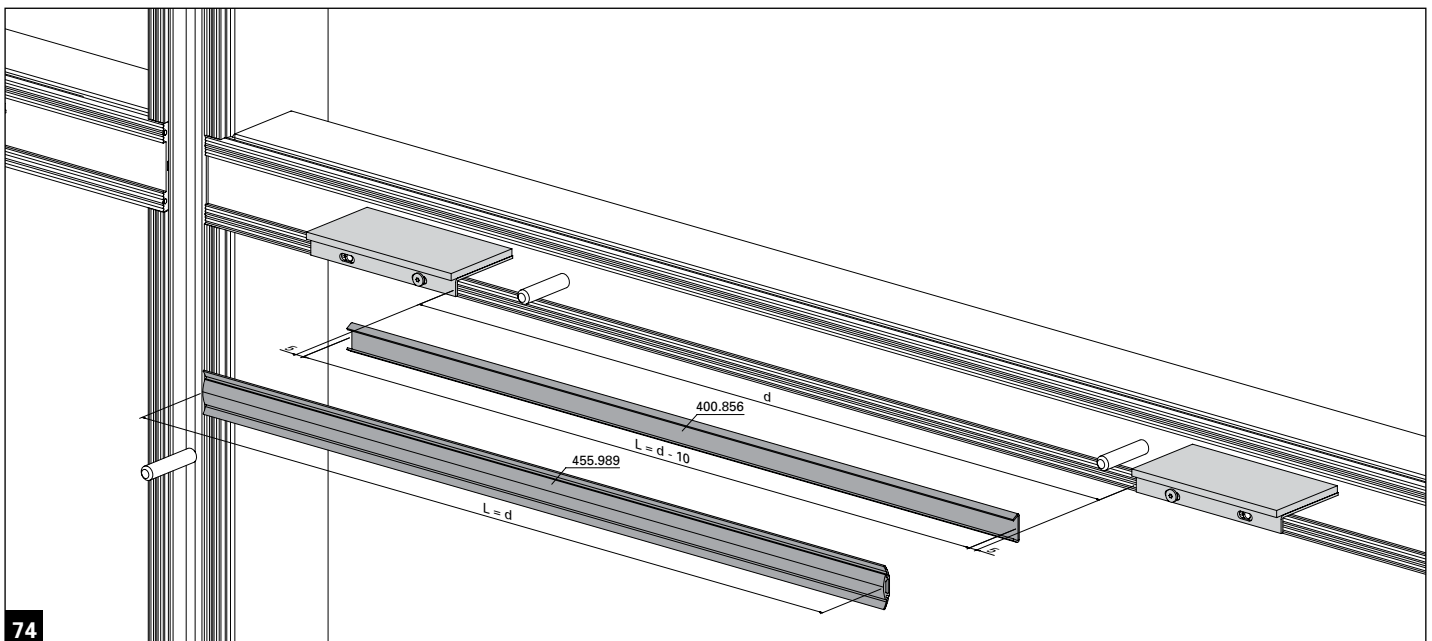
9.2 Forming the vertical joint
 9.2 Configurazione giunzione verticale

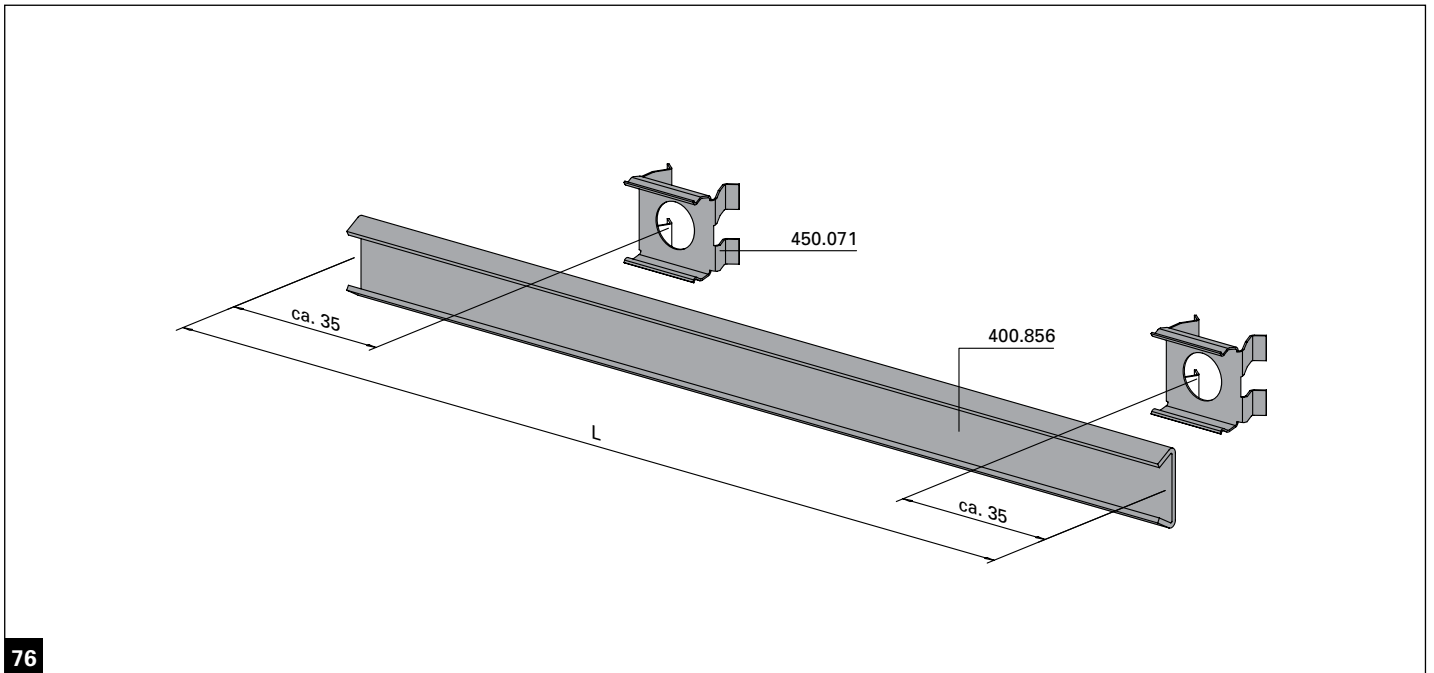
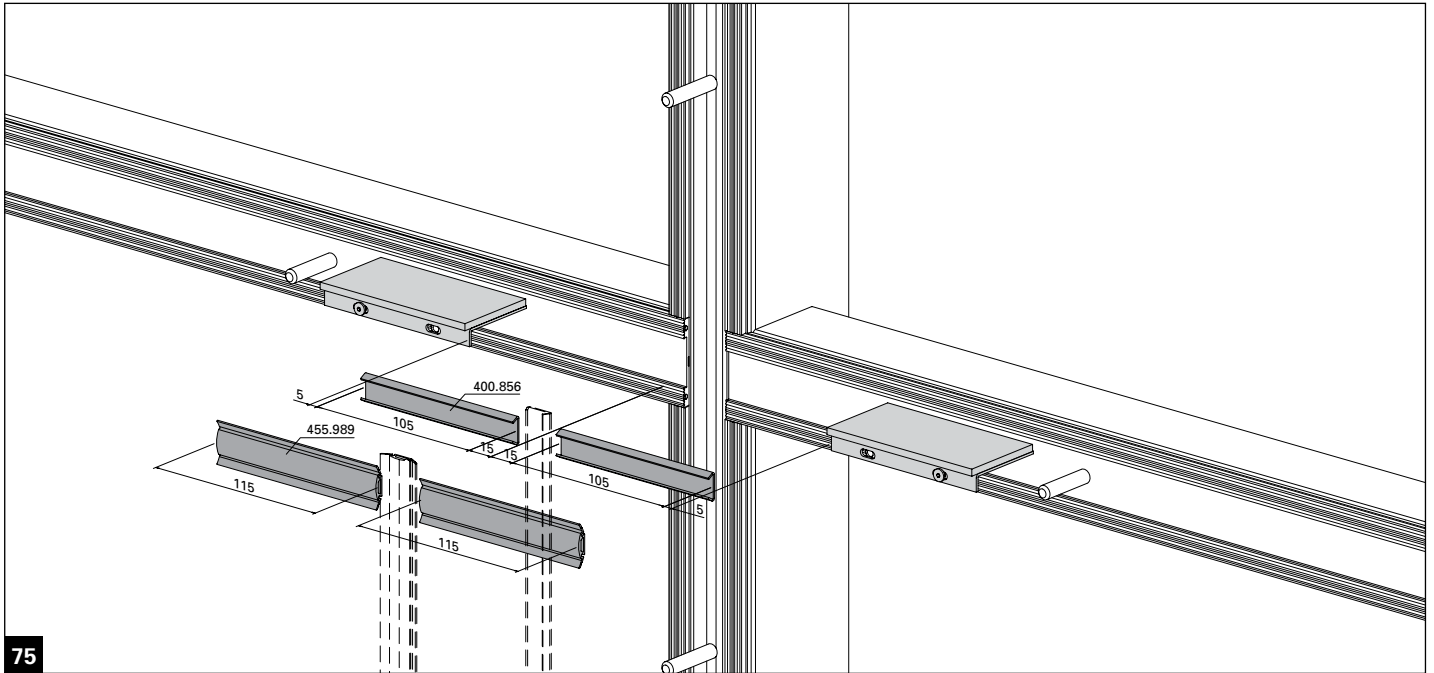


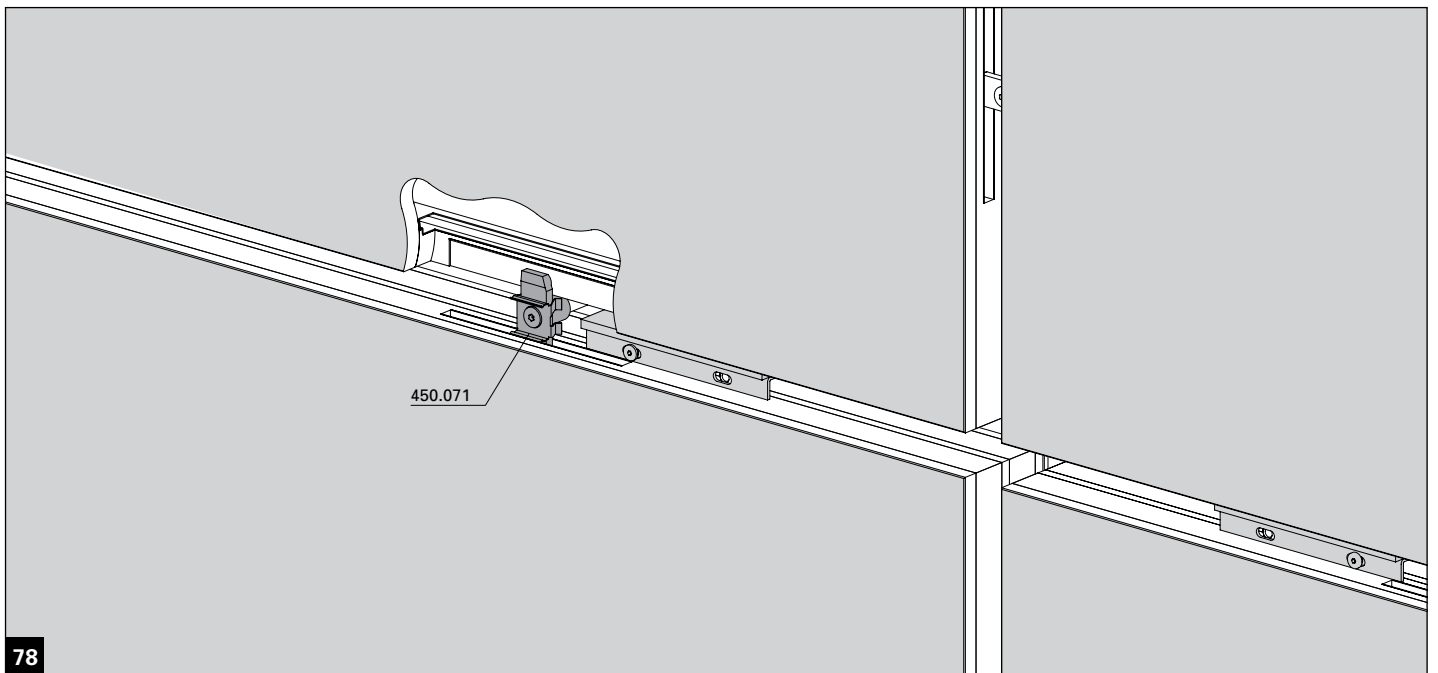
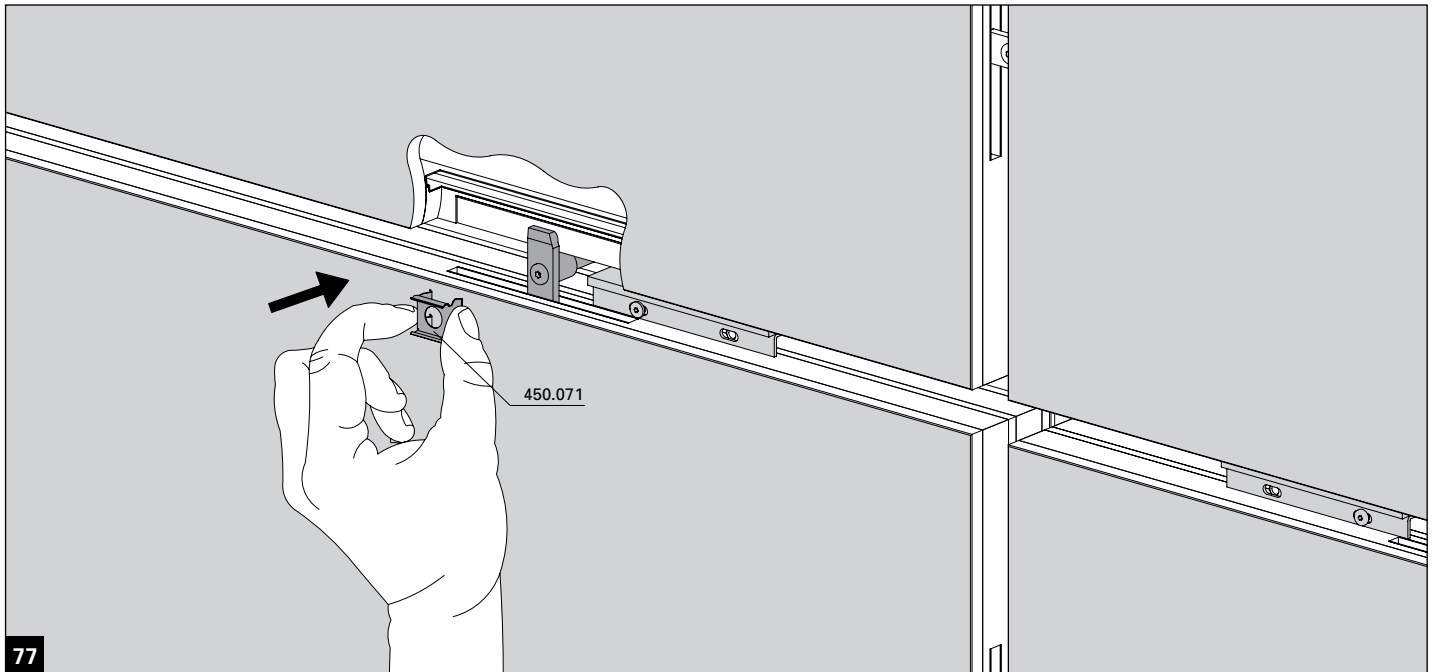


9.3 Ausbildung Horizontalstoss
 9.3 Réalisation joint horizontale

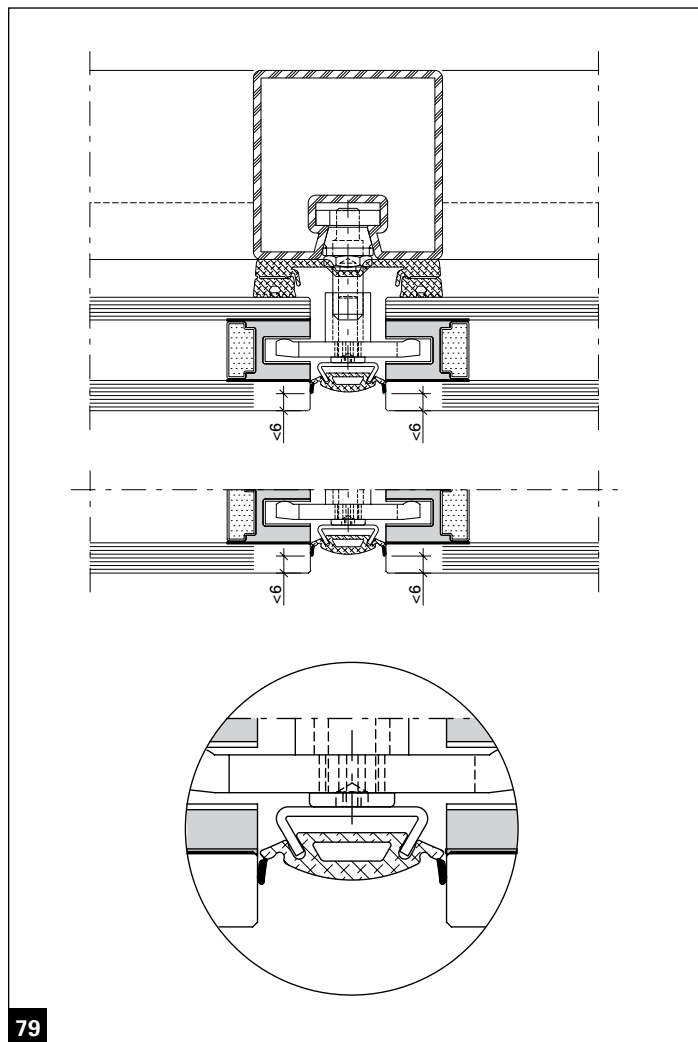
9.3 Forming the horizontal joint
 9.3 Configurazione giunzione orizzontale



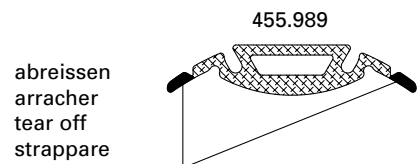




9.4 Anpassen der Dichtung im Glasfalz
 9.4 Ajustage du joint dans la feuillure de verre



79



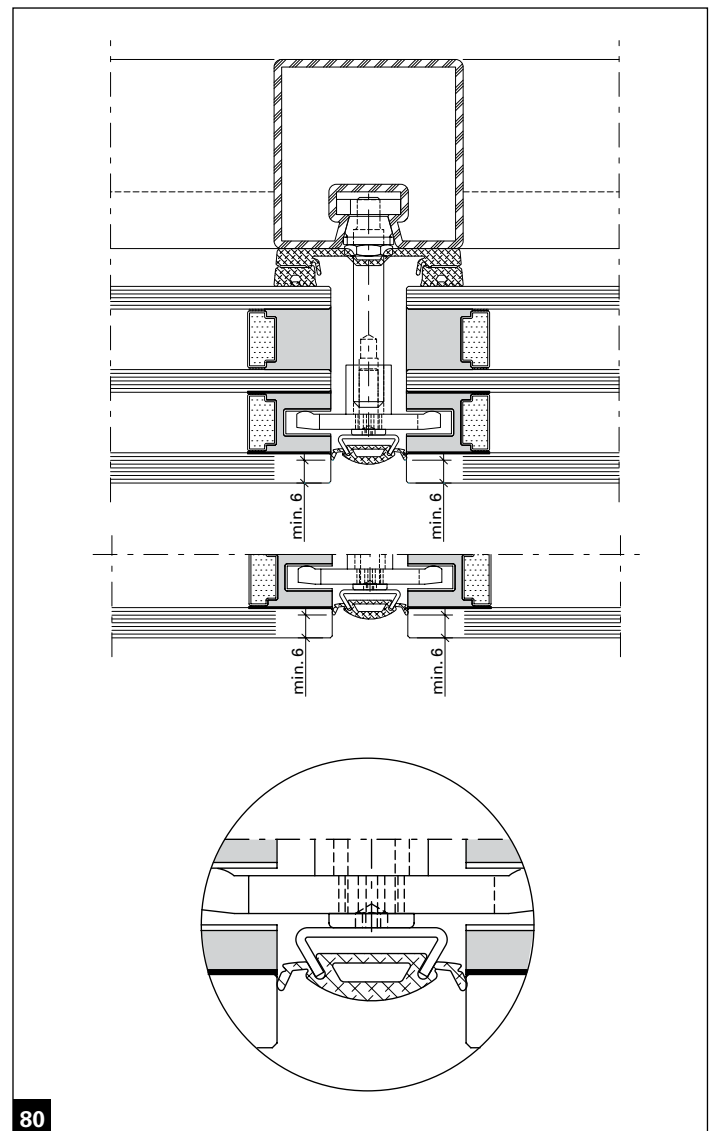
Bei Fugentiefe $<6\text{ mm}$ sind die Dichtungslappen abzureißen.

Les lèvres d'étanchéité doivent être arrachées quand la profondeur du joint est $<6\text{ mm}$.

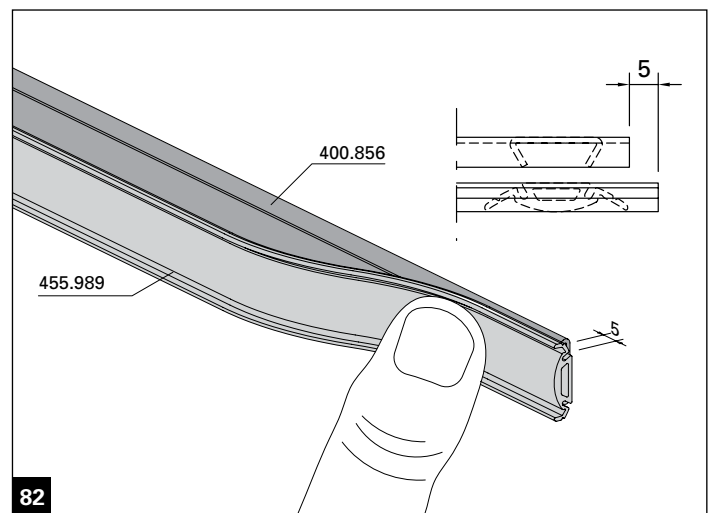
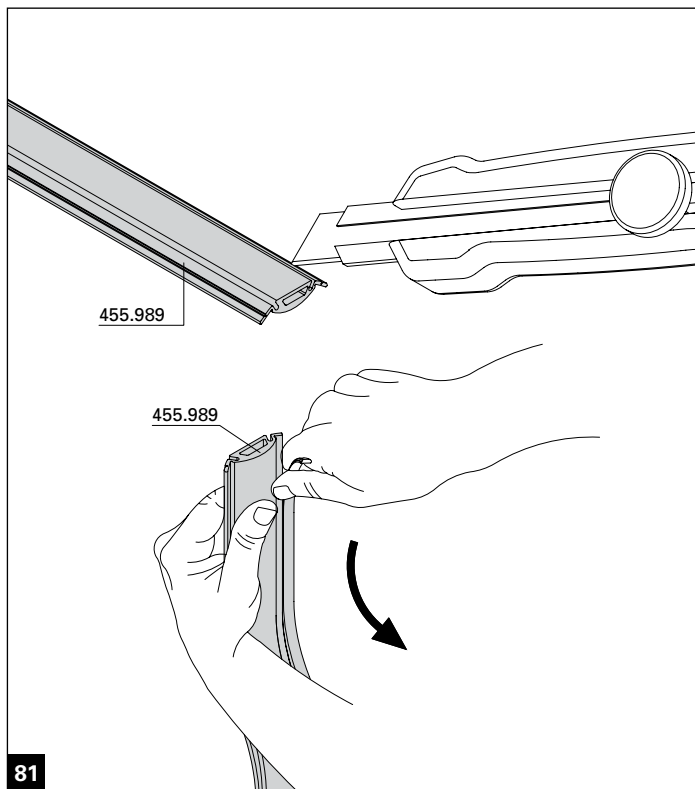
For joint depths $<6\text{ mm}$, the gasket lips must be torn off.

In caso di profondità giunture $<6\text{ mm}$ strappare i labbri della guarnizione.

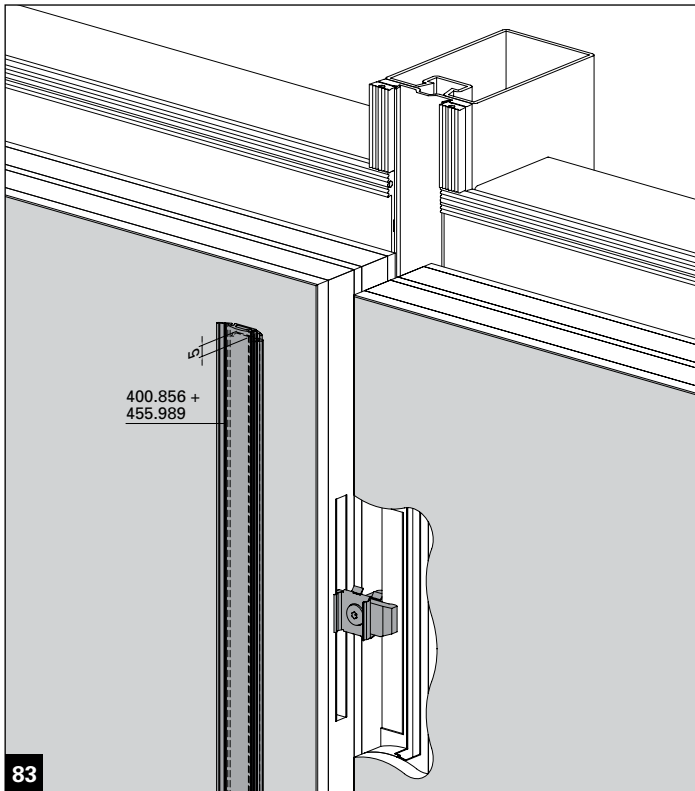
9.4 Adapting the gasket in the glazing rebate
 9.4 Adattamento della guarnizione nella scanalatura del vetro



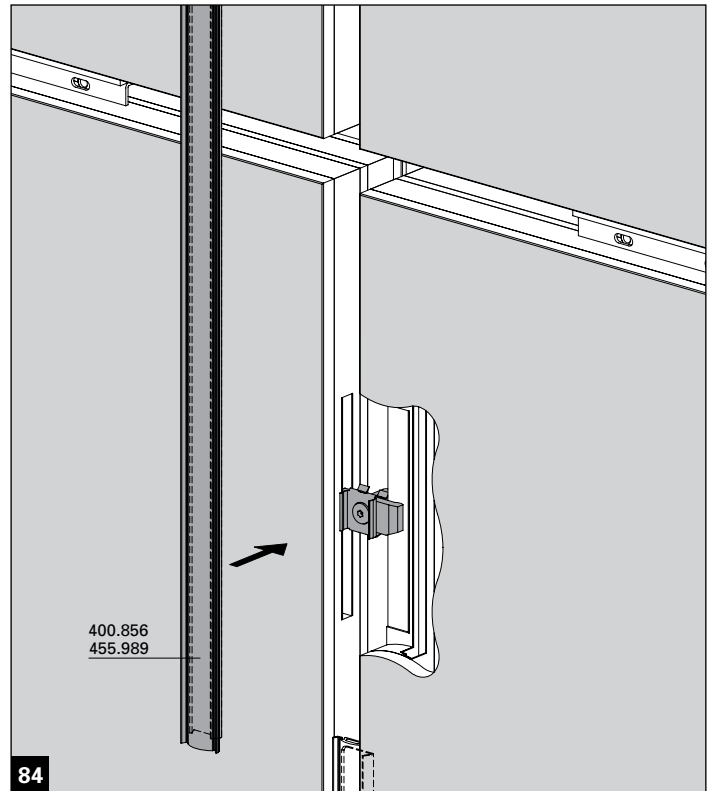
80



9.5 Montage Glasfalzprofil und Dichtung vertikal
9.5 Montage profilés de feuillure de verre et joint vertical

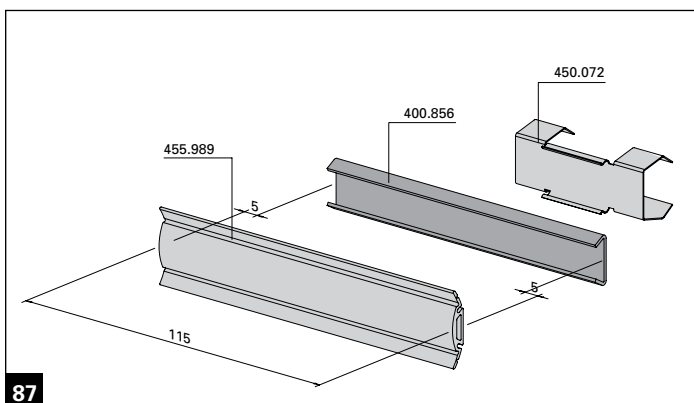
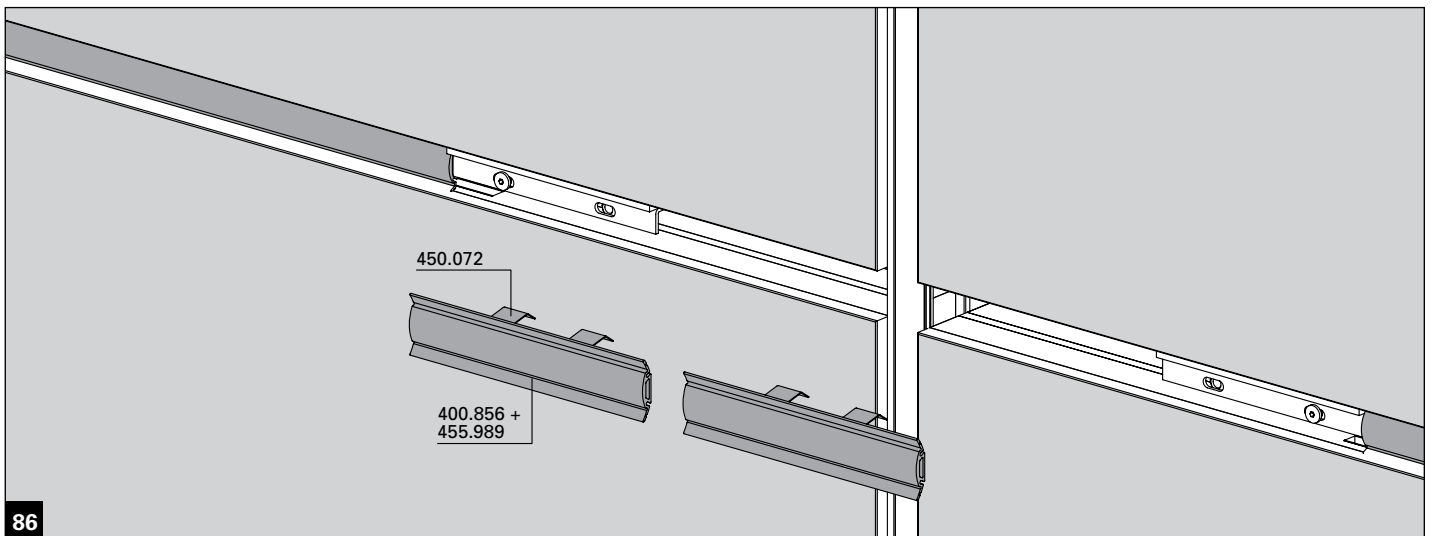
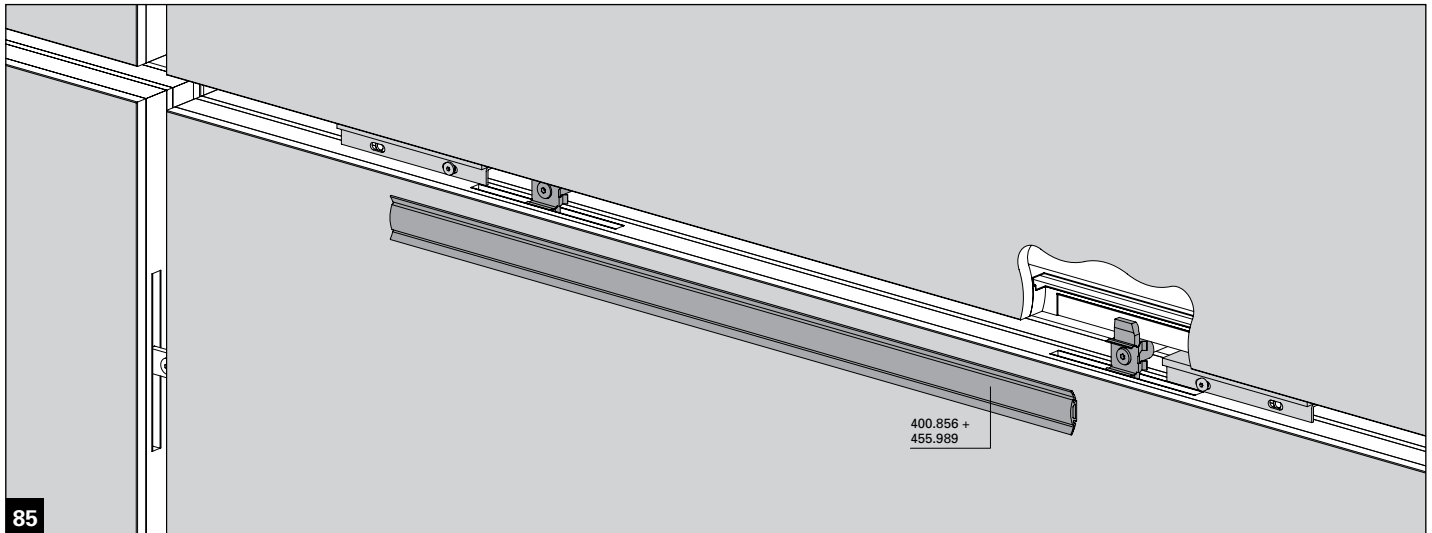


9.5 Assembly vertical glazing rebate profile and gasket
9.5 Montaggio del profilo d'appoggio e della guarnizione verticale



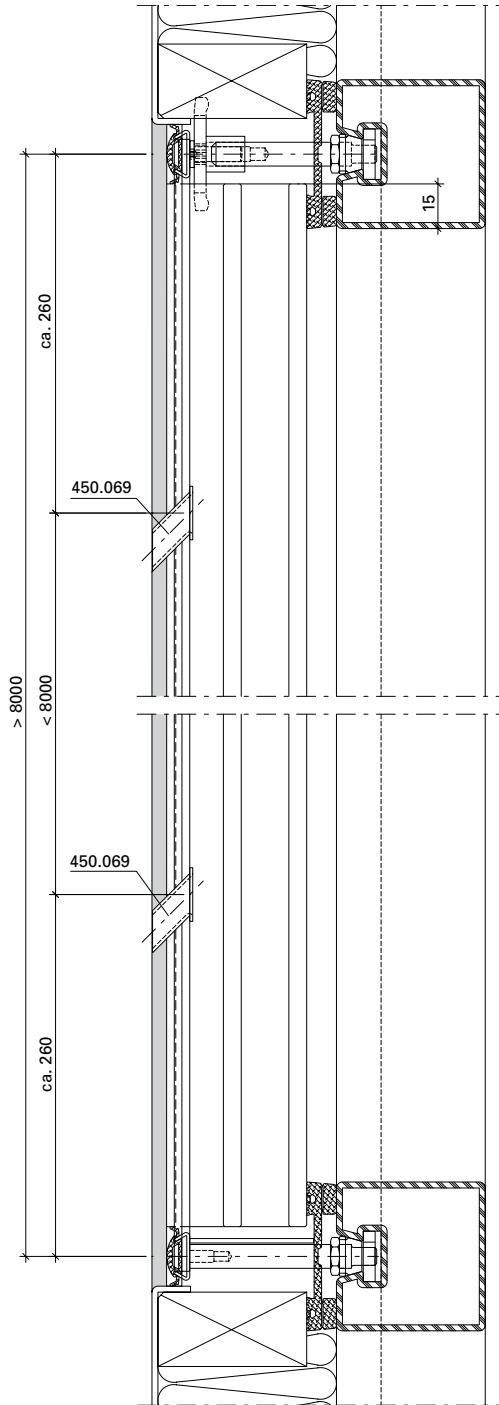
9.6 Montage Glasfalzprofil und Dichtung horizontal
9.6 Montage profilés de feuillure de verre et joint horizontal

9.6 Assembly horizontal glazing rebate profile and gasket
9.6 Montaggio del profilo d'appoggio e della guarnizione orizzontale

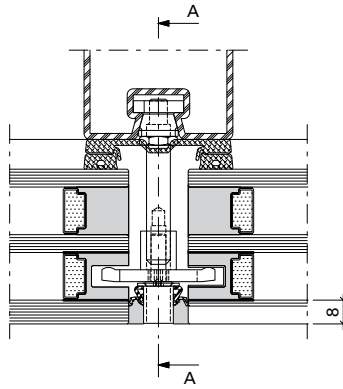


9.7 Belüftung Glasfalzbereich
 9.7 Ventilation zone du profilé de la feuillure de verre

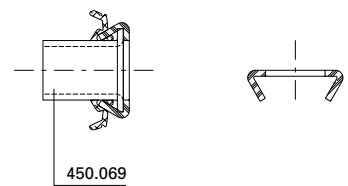
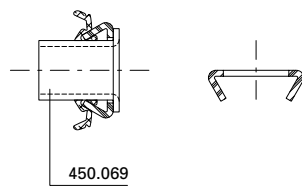
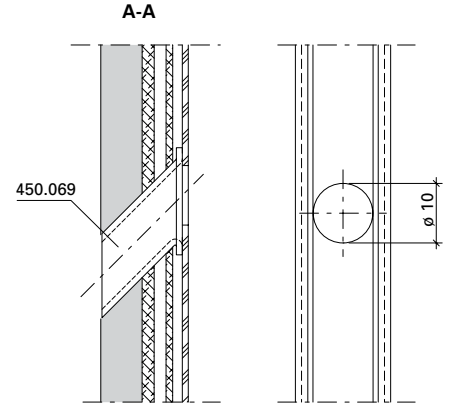
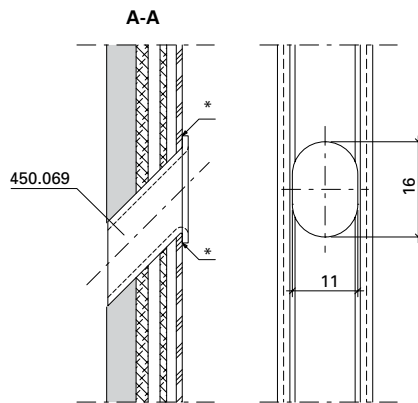
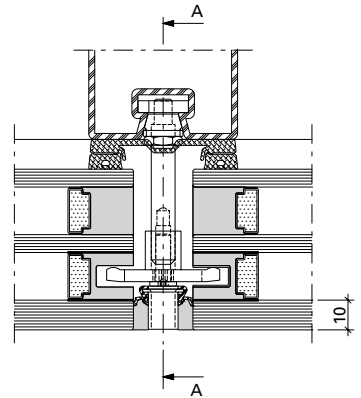
9.7 Ventilation in the glazing rebate area
 9.7 Aerazione dell'area della scanalatura vetro



Variante 1



Variante 2



* TIG-Punktschweissung

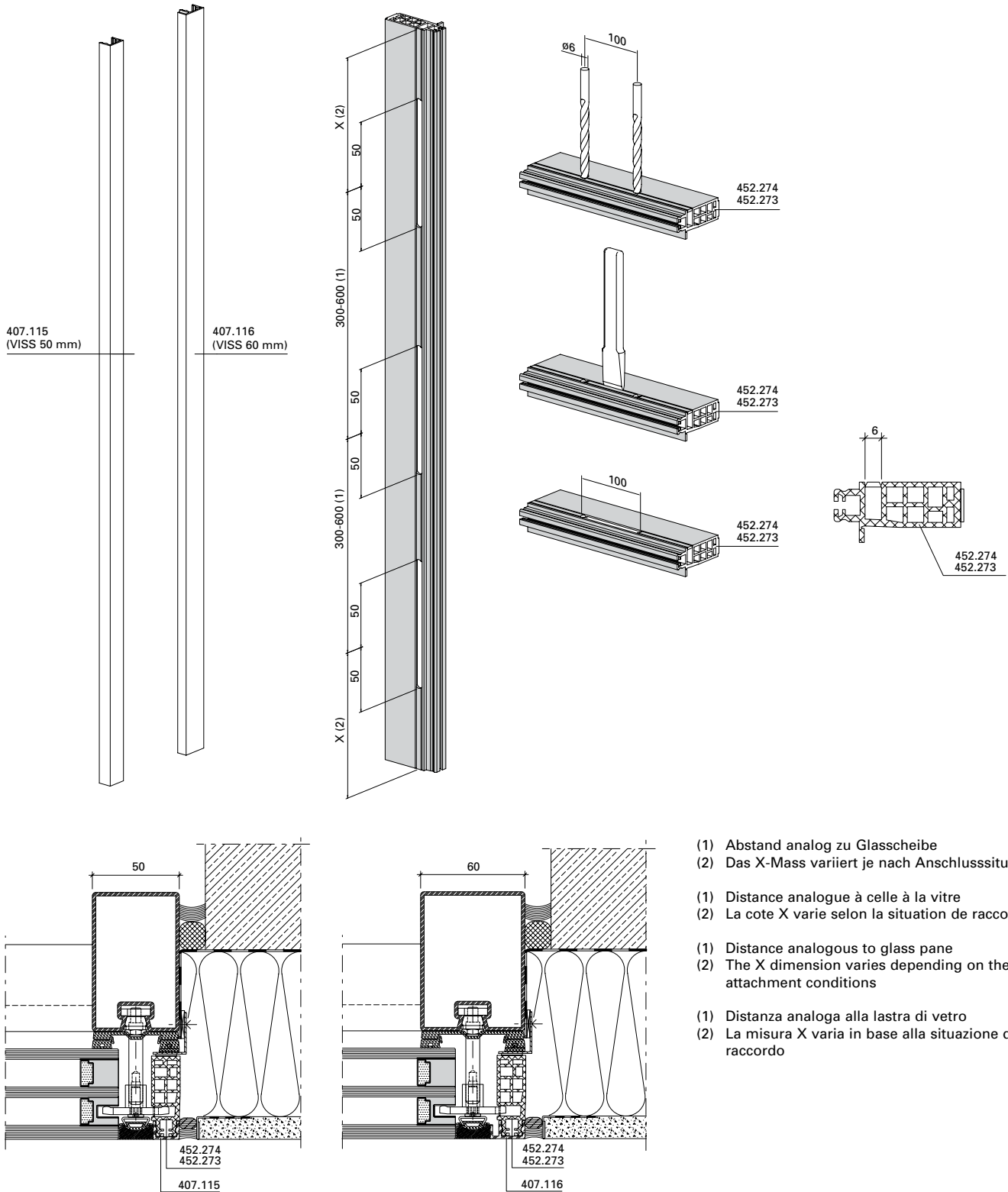
* Soudure à point TIG

* TIG Spot welding

* Saldatura a punti TIG

9.8 Zuschnitt Distanzprofil für Bauanschluss
 9.8 Découpe profilé de distance pour raccord au mur

9.8 Cutting spacer profile for attachment to building structure
 9.8 Taglio profilo distanziale per raccordo con l'opera di muratura

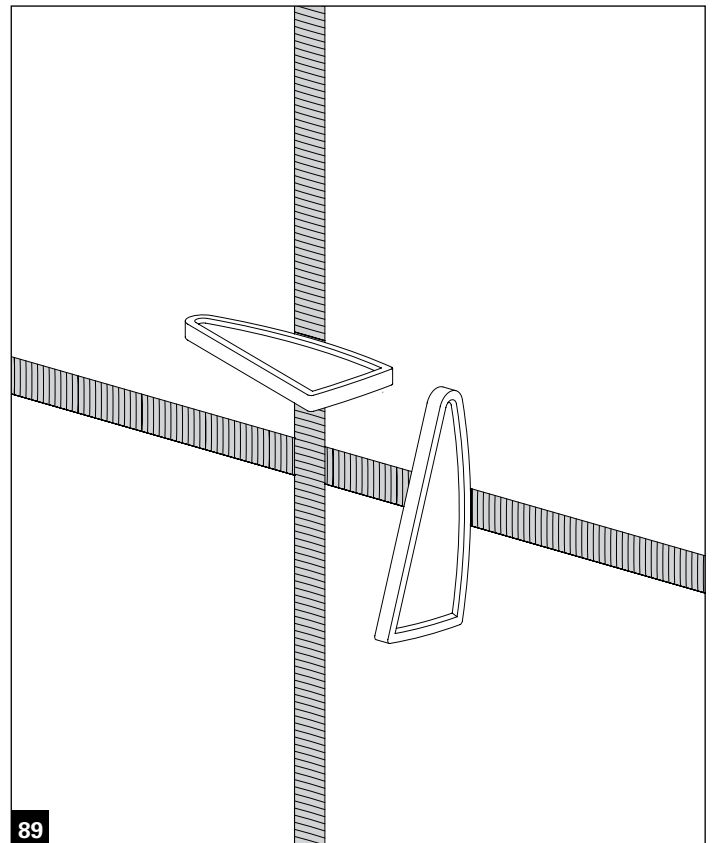
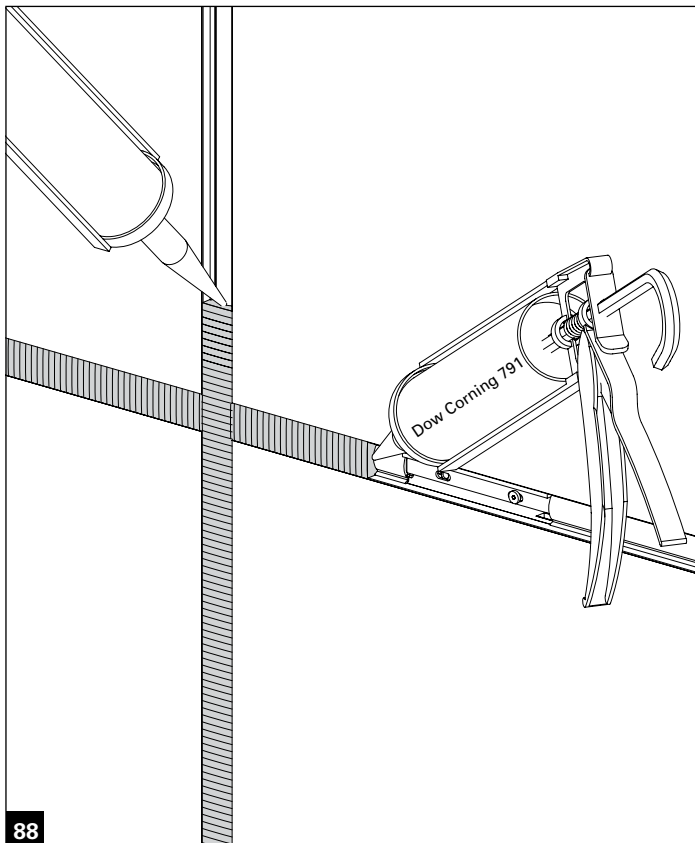


10. Versiegelung

10. Scellement

10. Sealing

10. Sigillatura



Informationen und Gebrauchsanweisung des Silikonherstellers sind zu beachten.

Tenir compte des informations et des instructions d'utilisation du fabricant de silicone.

Note the information and instructions from the silicone manufacturer.

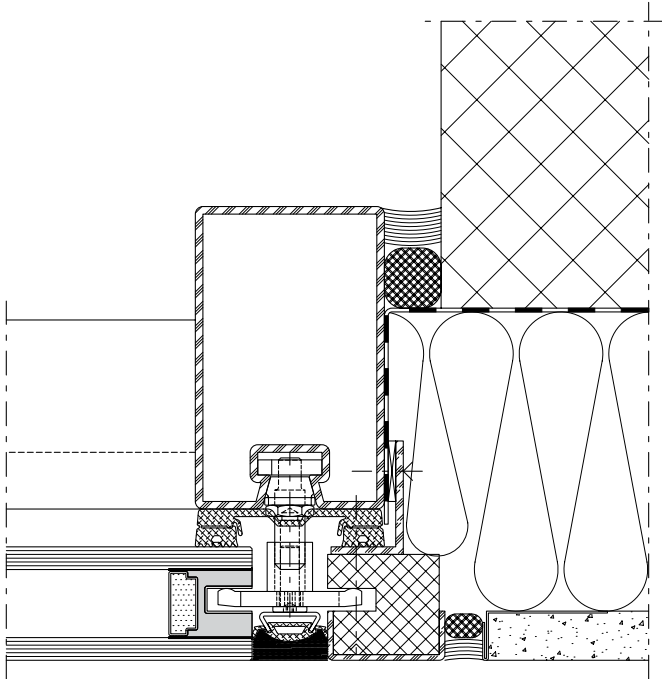
Osservare le informazioni e le istruzioni per l'uso fornite dal produttore del silicone.

11. Anschlüsse am Bau

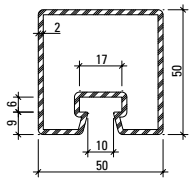
11. Attachment to structure

11. Raccords au mur

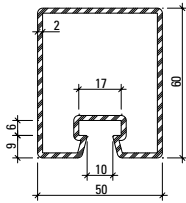
11. Raccordi alla muratura



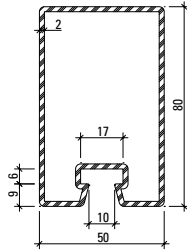
Profile 50 mm
 Profilés 50 mm
 Profiles 50 mm
 Profili 50 mm



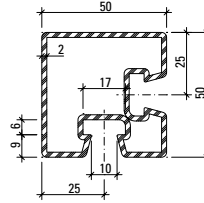
76.694
76.694 Z



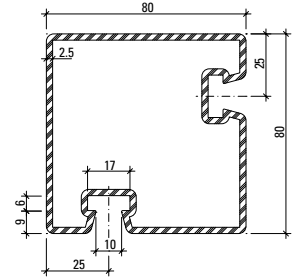
76.671
76.671 Z



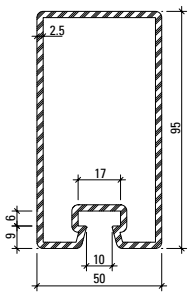
76.696
76.696 Z



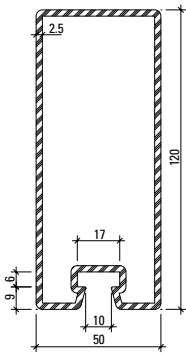
76.094



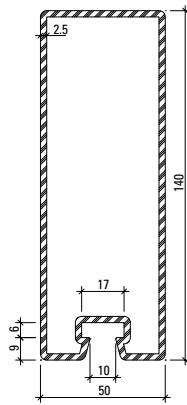
76.096



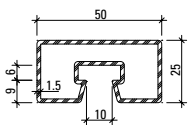
76.697
76.697 Z



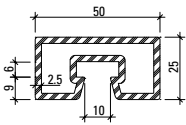
76.679
76.679 Z



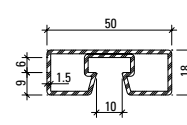
76.666
76.666 Z



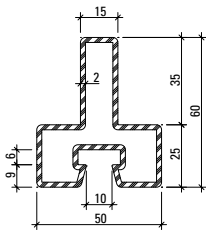
76.682



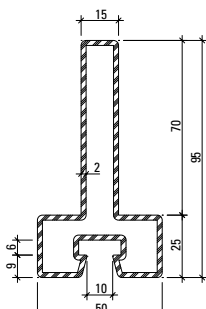
76.680



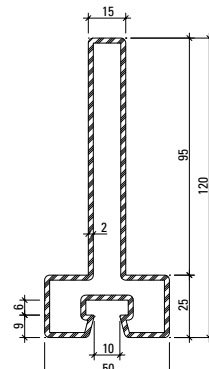
76.692



76.114

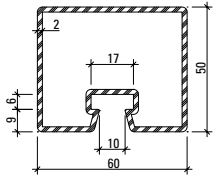


76.115

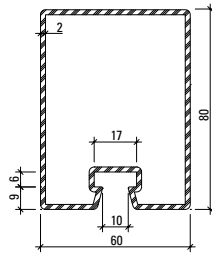


76.116

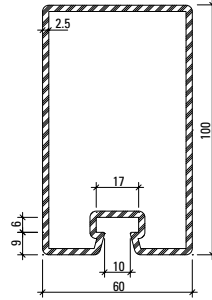
Profile 60 mm
 Profilés 60 mm
 Profiles 60 mm
 Profili 60 mm



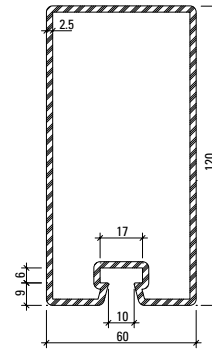
76.695
76.695 Z



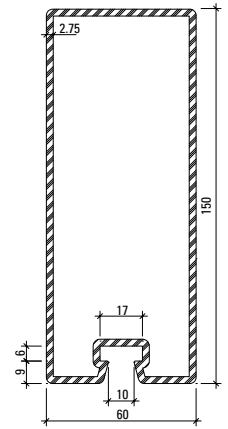
76.678
76.678 Z



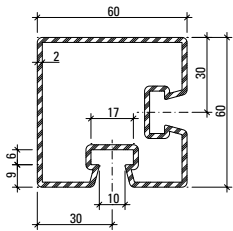
76.684
76.684 Z



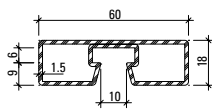
76.698
76.698 Z



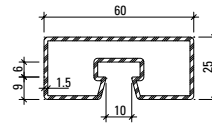
76.667
76.667 Z



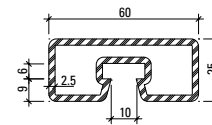
76.095



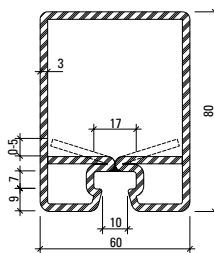
76.693



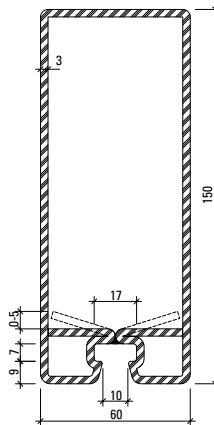
76.683



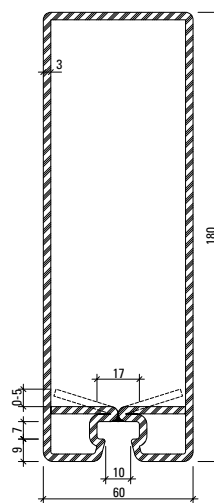
76.681



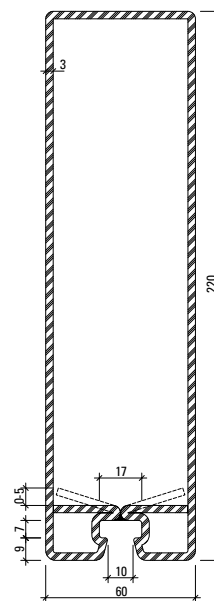
76.143 Z



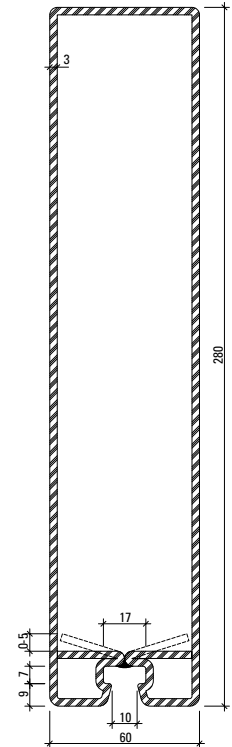
76.144 Z



76.140 Z



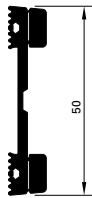
76.141 Z



76.142 Z



455.537



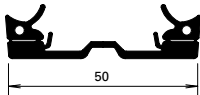
455.570



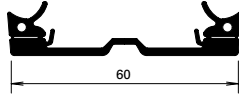
455.538



455.571



455.545



455.546



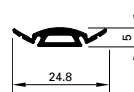
455.565



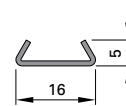
455.566



455.567



455.989



400.856



452.165



452.166



452.167



450.071



450.072



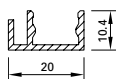
450.069



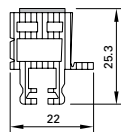
452.433



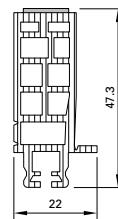
407.115



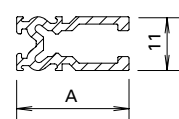
407.116



452.273



452.274



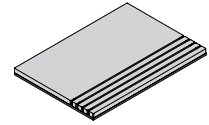
407.812
 407.813
 407.814



- 452.434 L = 17 mm
- 452.162 L = 22 mm
- 452.435 L = 28 mm
- 452.436 L = 33 mm
- 452.437 L = 38 mm
- 452.438 L = 43 mm
- 452.423 L = 48 mm
- 452.424 L = 53 mm
- 452.425 L = 60 mm



- 452.512 L = 17 mm
- 452.513 L = 22 mm
- 452.514 L = 28 mm
- 452.515 L = 33 mm
- 452.511 L = 38 mm
- 452.516 L = 43 mm
- 452.420 L = 48 mm
- 452.517 L = 53 mm



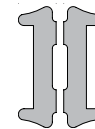
- 453.050
- 453.051
- 453.052
- 453.053



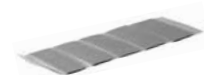
- 452.560 L = 33 mm
- 452.561 L = 36 mm
- 452.562 L = 39 mm
- 452.563 L = 42 mm
- 452.564 L = 45 mm
- 452.565 L = 48 mm
- 452.566 L = 51 mm
- 452.567 L = 54 mm
- 452.568 L = 58 mm
- 452.569 L = 61 mm



- 452.500 L = 17 mm
- 452.501 L = 22 mm
- 452.502 L = 28 mm
- 452.503 L = 33 mm
- 452.510 L = 38 mm
- 452.504 L = 43 mm
- 452.417 L = 48 mm
- 452.505 L = 53 mm



- 450.065
- 450.067



- 455.423
- 455.424



- 452.521 L = 30 mm



- 450.092



- 452.509 L = 30 mm



- 450.091



499.263



499.266



499.264



499.267



499.262

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VISS SG façades
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VISS SG facciate

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