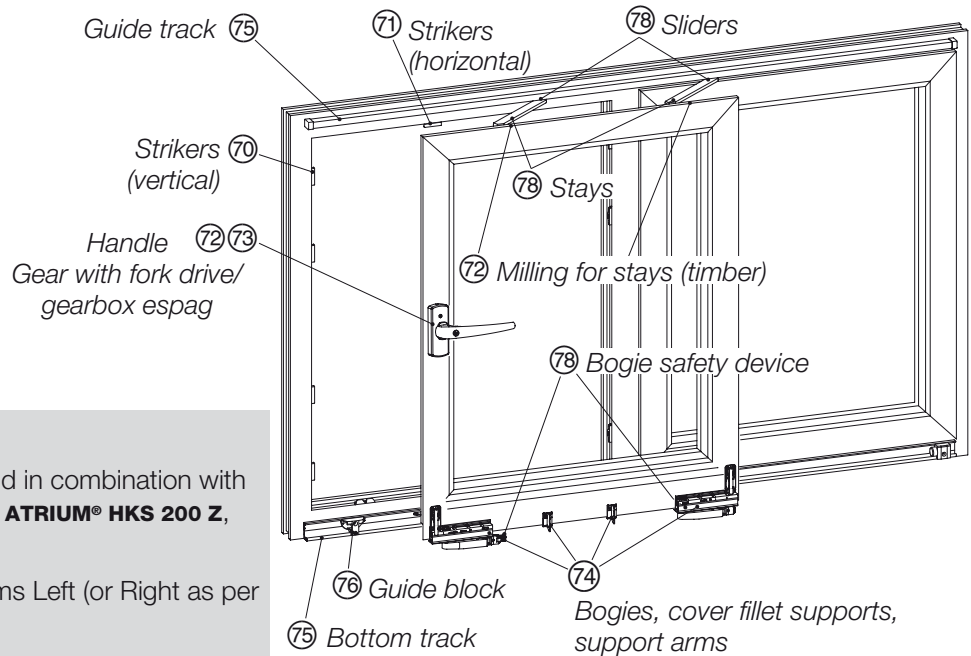


ATRIUM® HKS 200 Z

Use of drilling jigs/tools



Drilling jigs/tools for ...

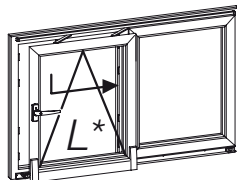


NOTE:

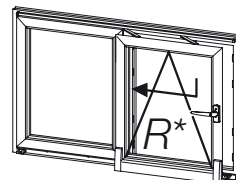
This document is only valid in combination with the mounting instructions **ATRIUM® HKS 200 Z**, article code: 220869.

The figures refer to systems Left (or Right as per DIN EN 12519).

For systems right (or left as per DIN EN 12519), the dimensions have to be adapted mirrored.



*DIN EN 12519 Right
(right-opening)



*DIN EN 12519 Left
(left-opening)

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Handle for gearbox espag	3	73 215247 / 90 221756 (optional)
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Sliders	10	78 215283
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Bogie safety device	12	78 215283
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All measurements in these instructions are indicated in millimetres (mm).

Handle for gear with fork drive/ Milling for stays (timber)

1 Adjust jig at sash

FFH	900 - 1300	1301 - 1700	1701 - 2700
X	450	650	950

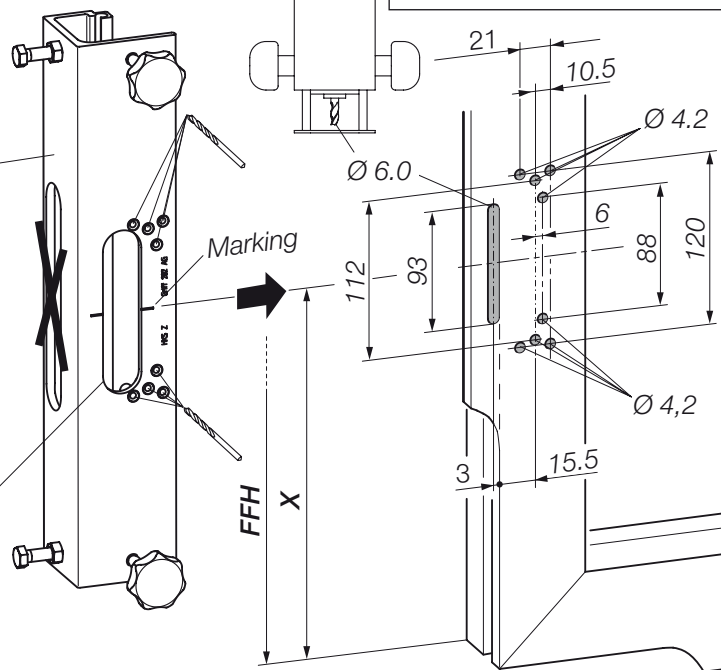
⑦ Drilling/milling jig 214629

Sash rebate edge

For milling for stays (see below)

Milling guide, thrust ring Ø 27 mm

2 Drill bore holes for handle



only for timber stiles:



3 Carry out milling for stays

⑦ Drilling jig/milling jig 214629

Ø 6 mm

A9

A13

Milling guide, thrust ring Ø 27 mm

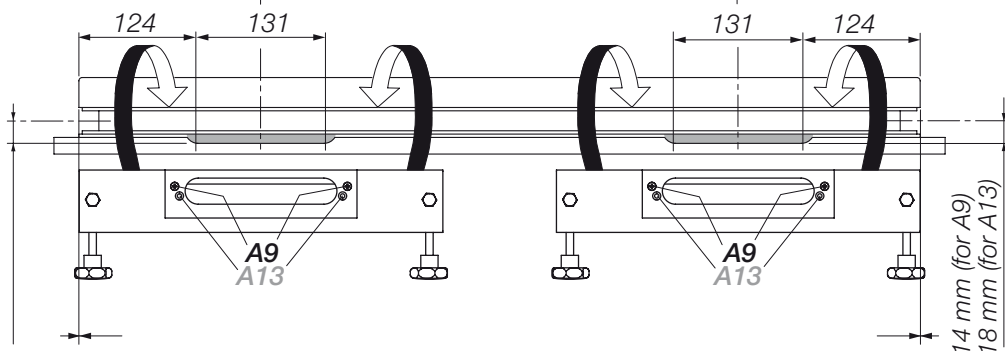
Adjusting device

Adjusting device

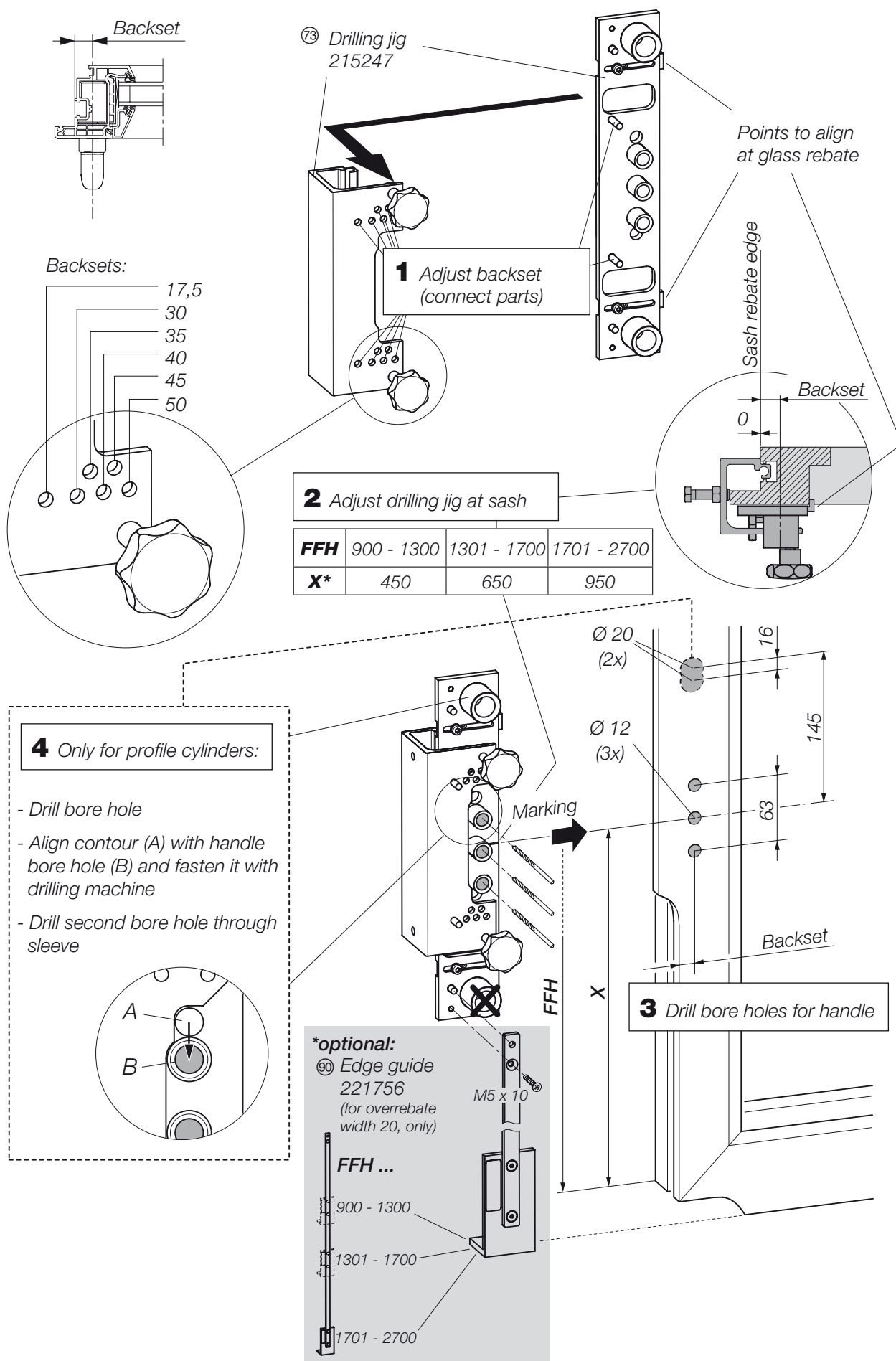
Sash rebate edge

Sash rebate = milling depth

14 mm (for A9)
18 mm (for A13)

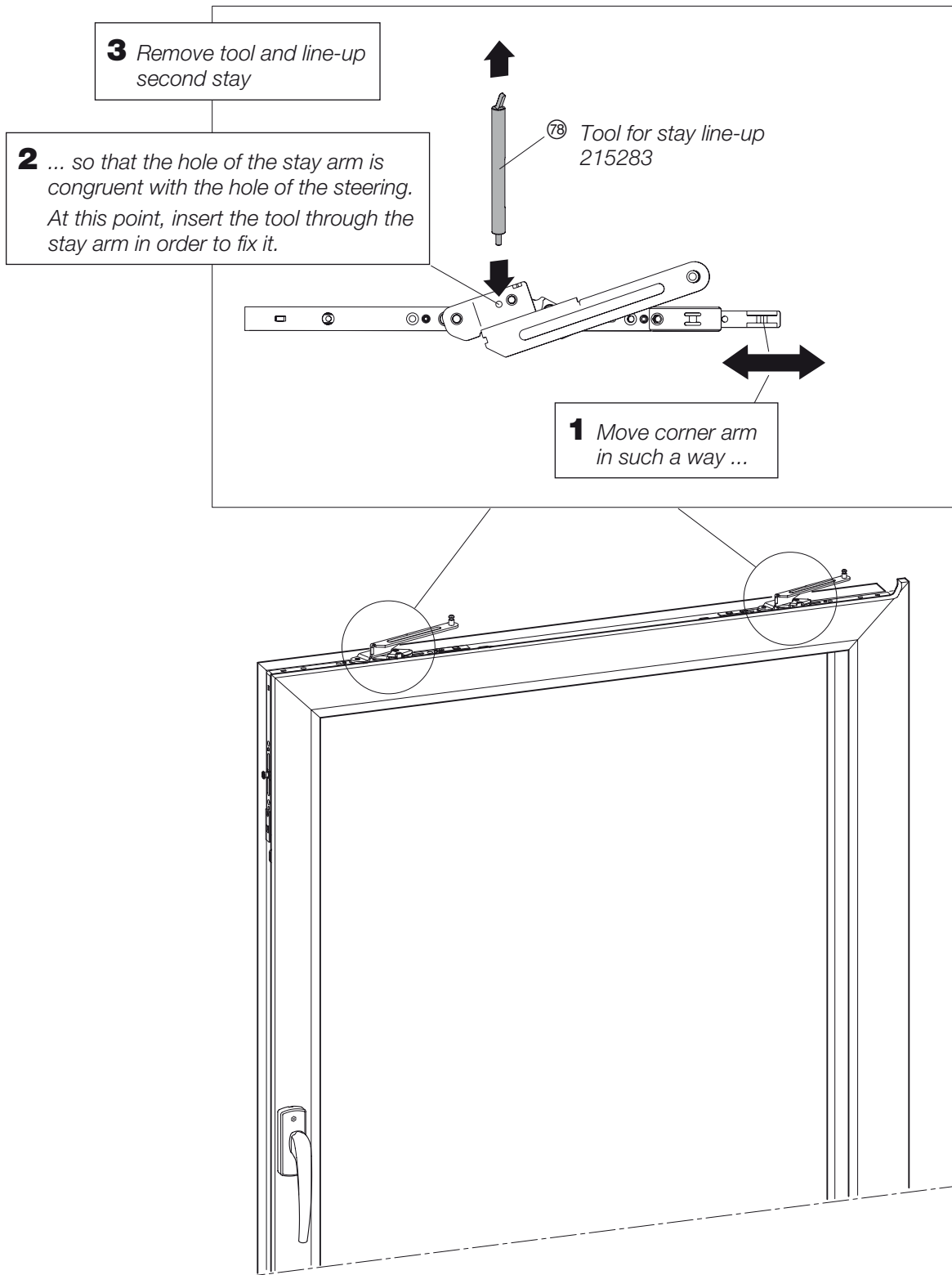


Handle for gearbox espag



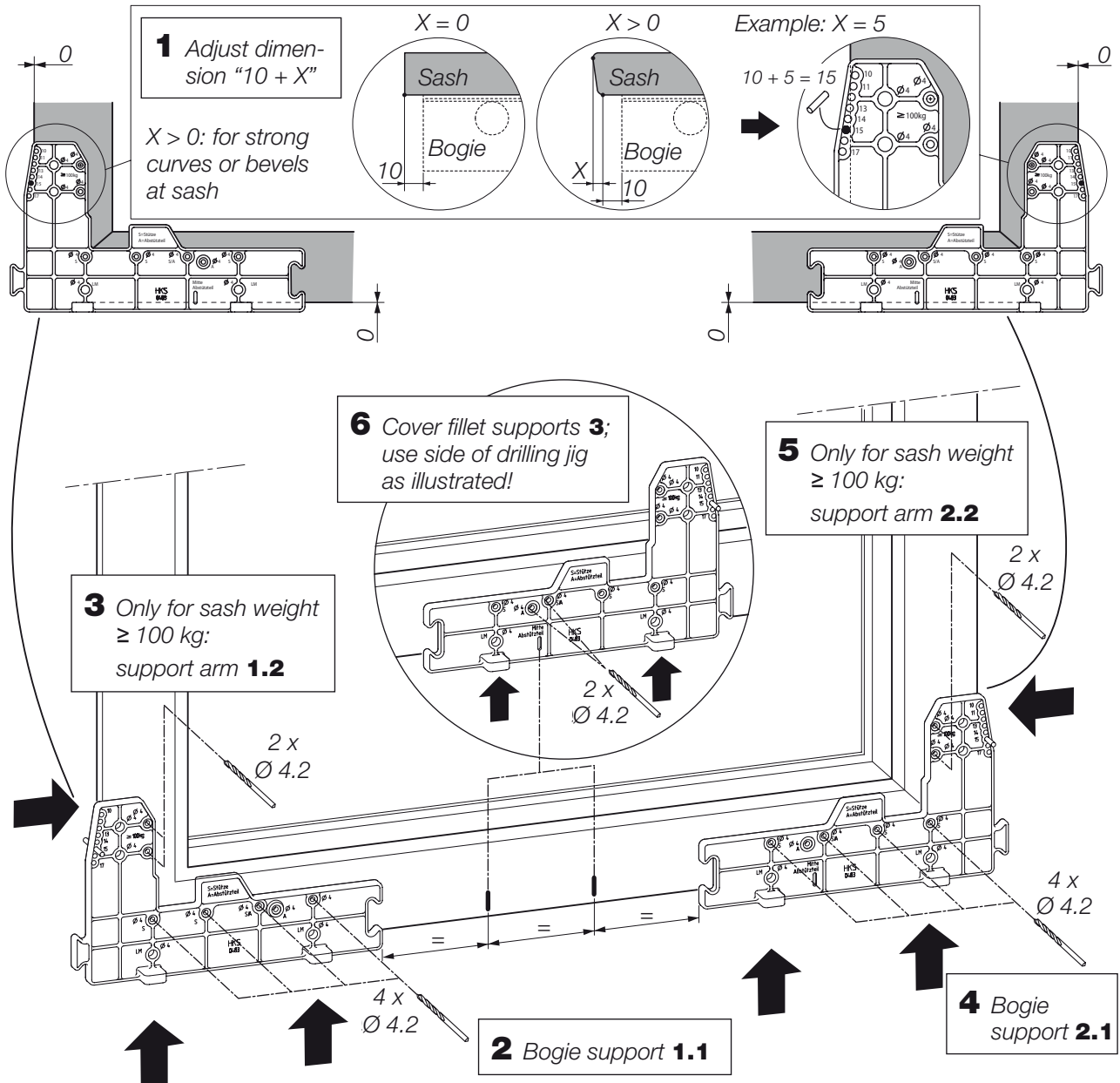
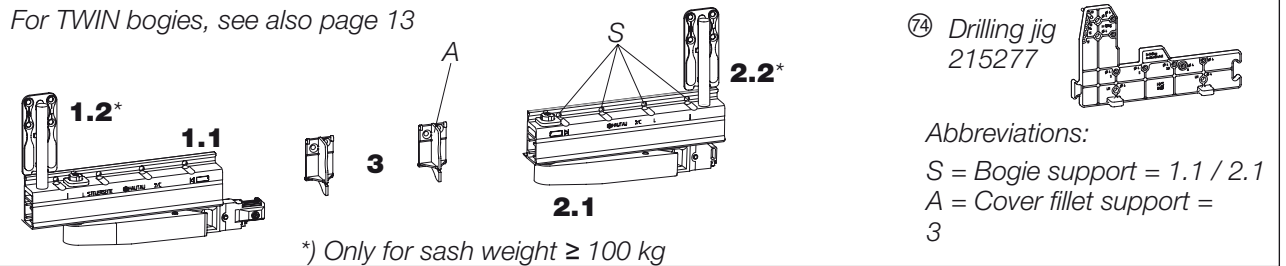
Stays

The tool for slider release can be also used for stay line-up when mounting the central locking.



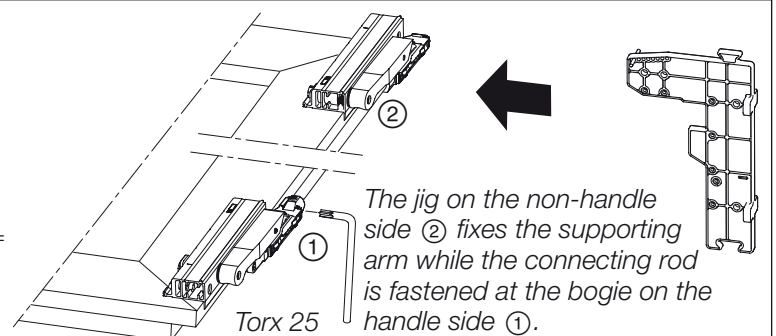
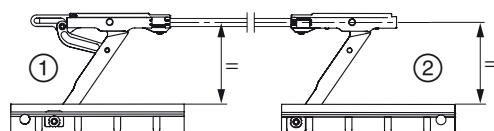
Bogies, cover fillet supports, support arms

For TWIN bogies, see also page 13

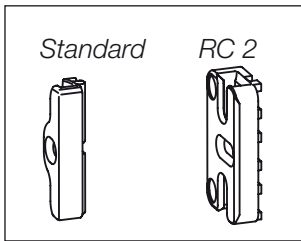


Jig for supporting parallel alignment of bogies

(see also mounting instructions, section "Alignment of bogies")



Strikers (vertical)



5 Fasten all strikers with screws in the appropriate positions at frame (arrow --> orientated to top), except striker "Oben Alle Gr." (= Top all sizes, see marking at jig).

Please use:



1 Choose inserting jig 70/70a (size 1 or size 2)

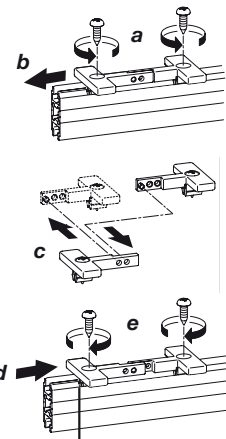
Size 2:

70a 232306
(FFH 1701 ... 2400)

Size 1:

70 232303
(FFH 900 ... 1700)

2 in case of RC2:
shift insertions



For dimensions refer to mounting instructions

6 Push inserting jig upwards against the stop in the frame corner

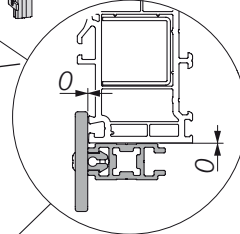
7 Fasten striker at position "Oben alle Gr." (= Top all sizes) with screw at frame (arrow --> orientated to bottom)

3 Choose side
("Griffseite" = handle side or
"NGR Seite" = non-handle side)

"Griffseite"
= handle side

"NGR Seite"
= non-handle side

4 Position jig with lettering of chosen side at bottom corner of frame



Example: the adjacent striker position is valid for ...

...handle side ...

... for frames with a FFH of
1901 ... 2400 mm

... for jig positioned at the top
for all sizes;
dimension = 155 mm

1901 - 2400

Oben Alle Gr.
155

...non-handle side ...

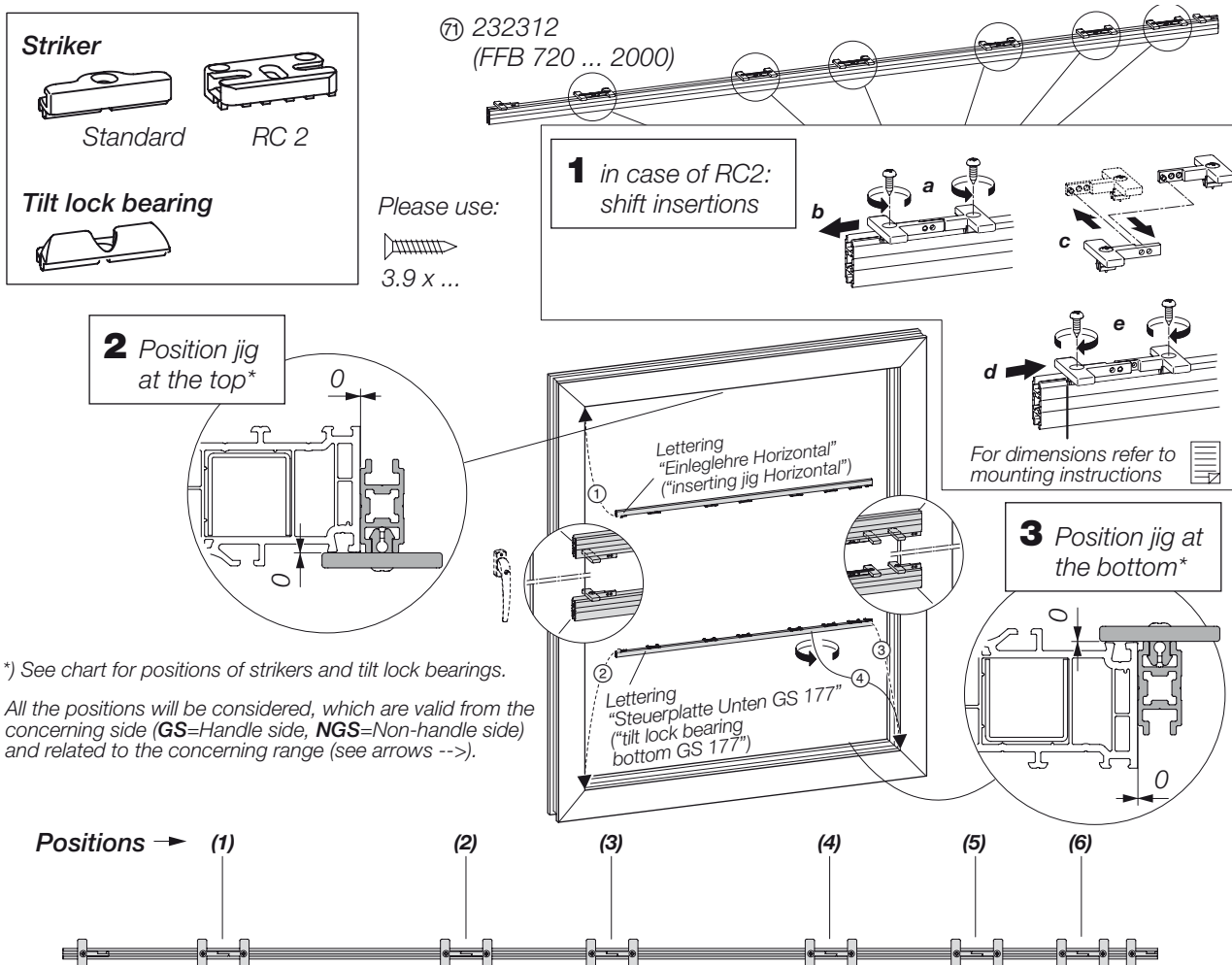
Alle Gr.

... for all sizes

NGR SEITE Unten
Vertikal GR. 2

Inserting jig of size 2 is used
and positioned on non-handle
side at the bottom

Strikers (horizontal), tilt lock bearings



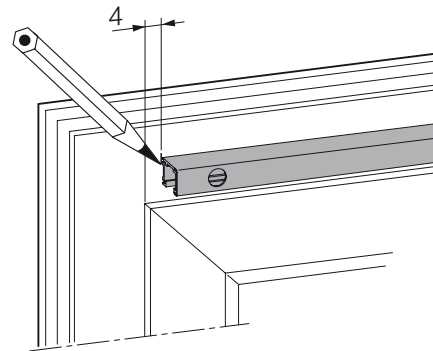
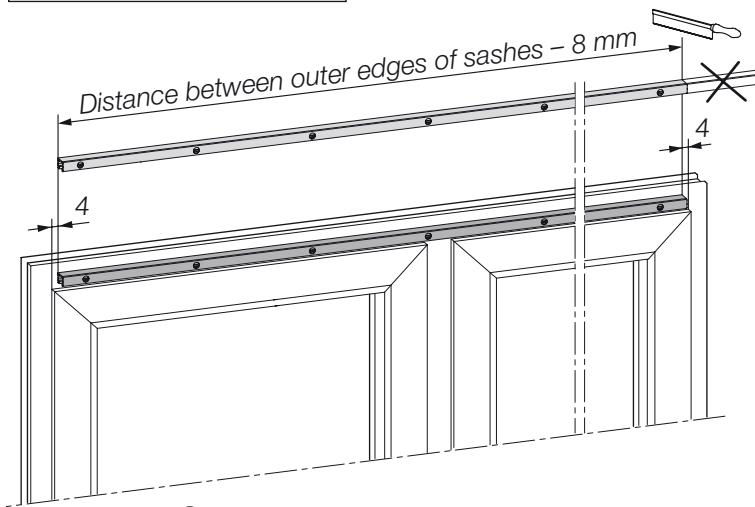
*) See chart for positions of strikers and tilt lock bearings.

All the positions will be considered, which are valid from the concerning side (**GS**=Handle side, **NGS**=Non-handle side) and related to the concerning range (see arrows -->).

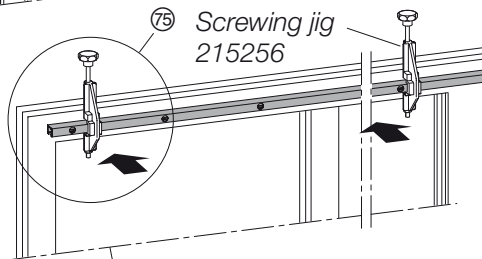
for FFB ...		Position jig at ...			
		... GS → Position NGS → Position ...	
720 ... 850	top	—	—	—	—
	bottom	② Tilt lock bearing	(1)	③ Tilt lock bearing	(5)
851 ... 1250	top	① Striker	(2)	—	—
	bottom	② Tilt lock bearing	(1)	④ Striker ③ Tilt lock bearing	(2) (5)
1251 ... 1450	top	① Striker	(3)	—	—
	bottom	② Tilt lock bearing	(1)	④ Striker ③ Tilt lock bearing	(3) (5)
1451 ... 1650	top	① Striker	(2) + (4)	—	—
	bottom	② Tilt lock bearing	(1)	④ Striker ③ Tilt lock bearing	(2) + (4) (5)
1651 ... 1850	top	① Striker	(3) + (5)	—	—
	bottom	② Tilt lock bearing	(1)	④ Striker ③ Tilt lock bearing	(3) + (5) (5)
1851 ... 2000	top	① Striker	(3) + (6)	—	—
	bottom	② Tilt lock bearing	(1)	④ Striker ③ Tilt lock bearing	(3) + (6) (5)

Guide track

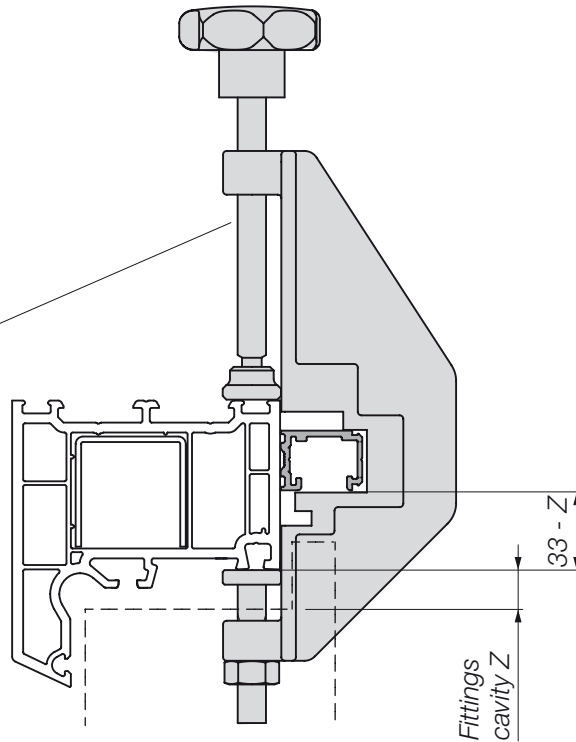
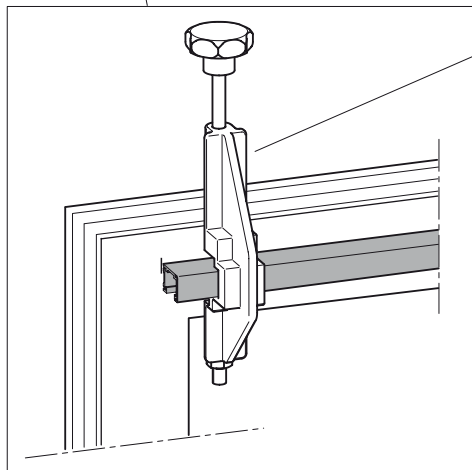
1 Cut guide track to size



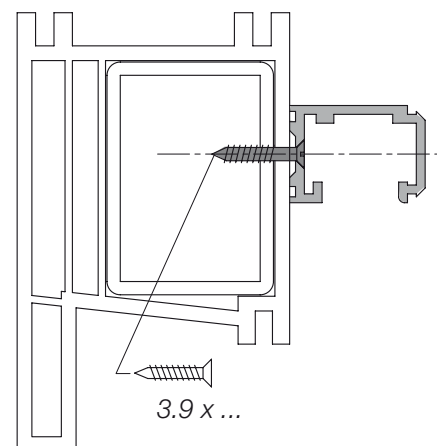
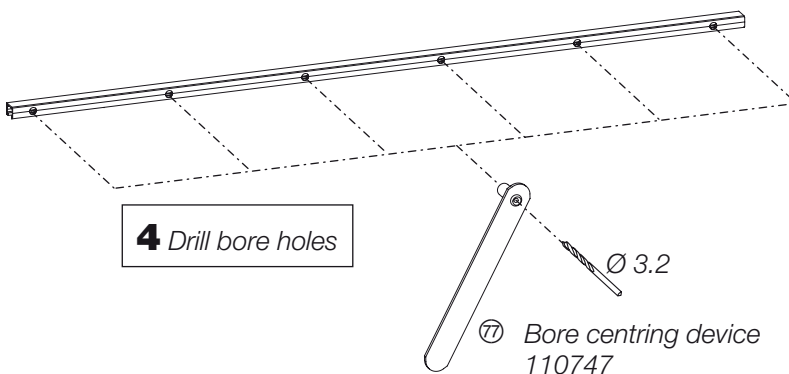
2 Mark lateral alignment of guide track on both sides



3 Fasten screwing jigs at frame

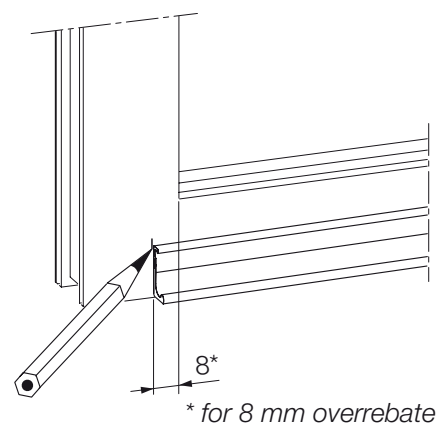
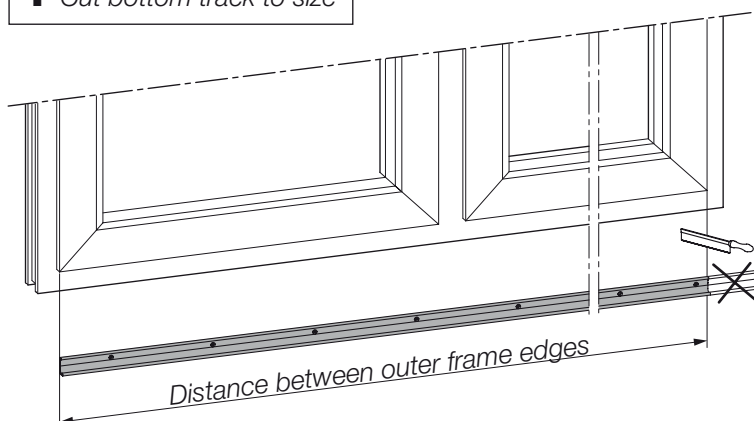


4 Drill bore holes

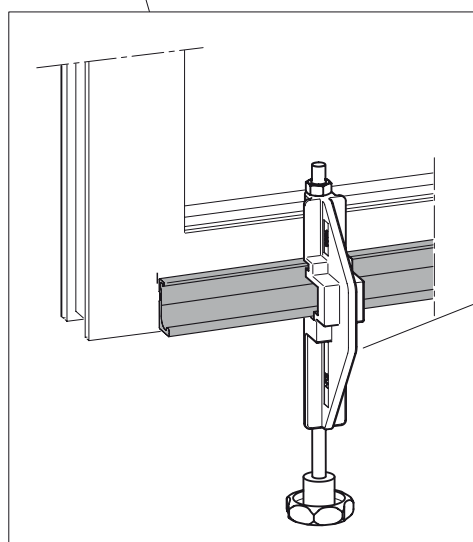
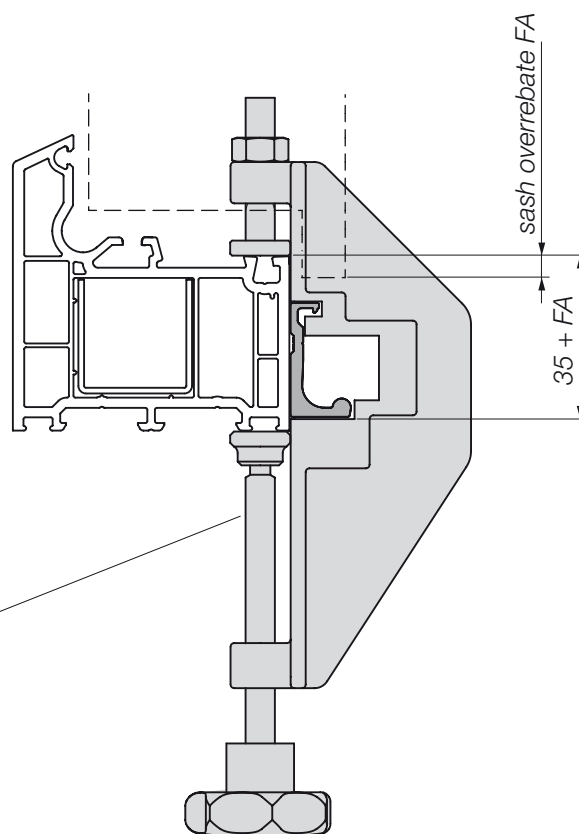
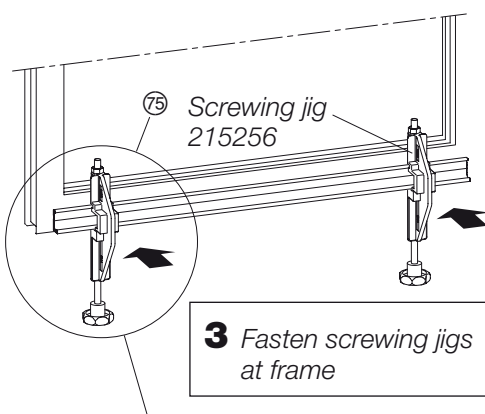


Bottom track

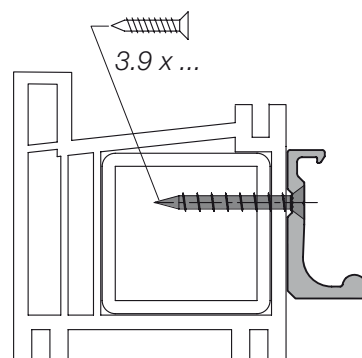
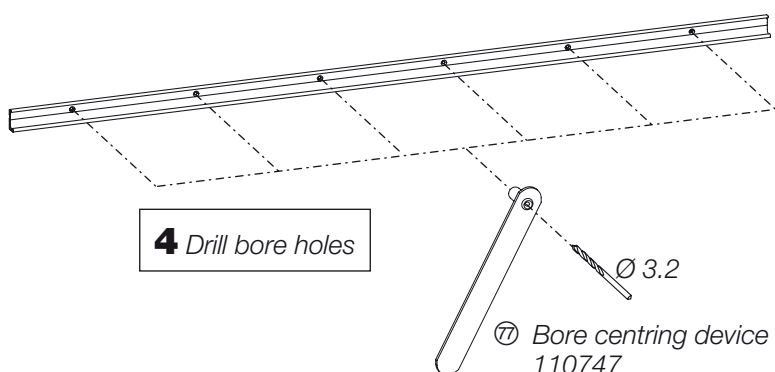
1 Cut bottom track to size



2 Mark lateral alignment of bottom track



4 Drill bore holes



Sliders

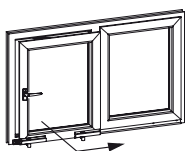


Warning:

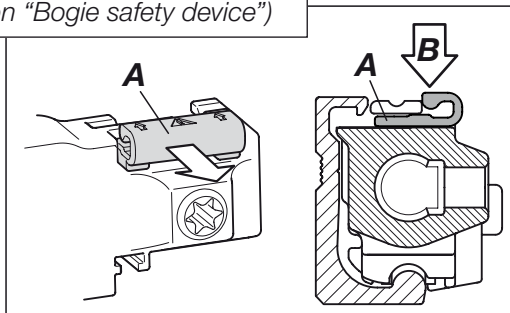
If the stay cams have not engaged safely in the sliders, the sash is not secured against falling out. Severe injuries could be the consequence.

During the mounting process, it may be necessary to remove the sash again. In this case, the stay cams have to be separated from the sliders in the following way:

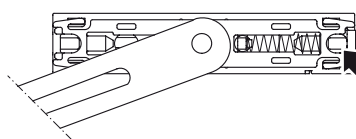
1 Open sash



2 Move bogie safety device (A) in unlocked position (B) (see also section "Bogie safety device")

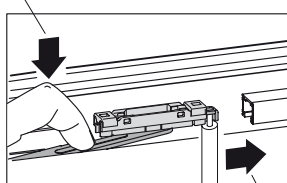


3 Push tool from below into slider opening beside safety pusher until flush positioning



⑦⑧ Tool for slider release 215283

5 Press stay cam downwards out of slider

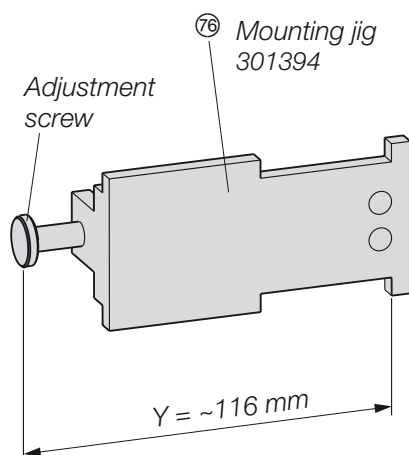


4 Pull safety pusher with tool sideways out of slider

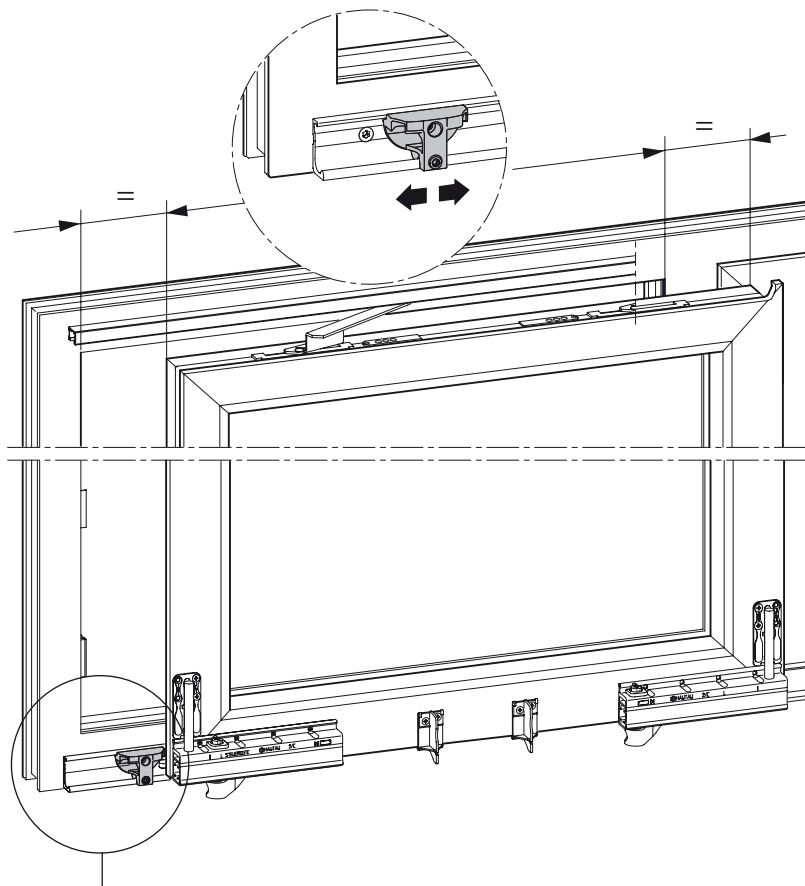
6 Repeat process with second slider. Slightly tilt the released sash and lift it from bottom track (not shown).

Guide block

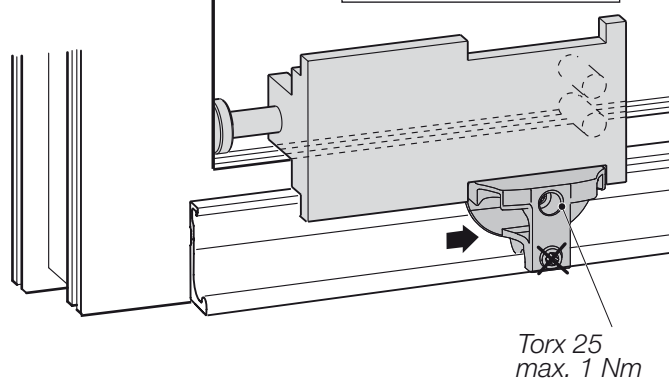
- 1** Adjust dimension Y by means of adjustment screw



- 5** Move sash into tilt position and control fittings cavity on both sides (12 mm or 4 mm); reset guide block, if necessary



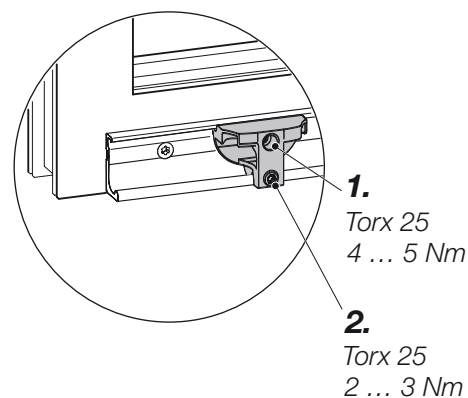
- 3** Place mounting jig as illustrated



- 2** Move guide block into bottom track on handle side

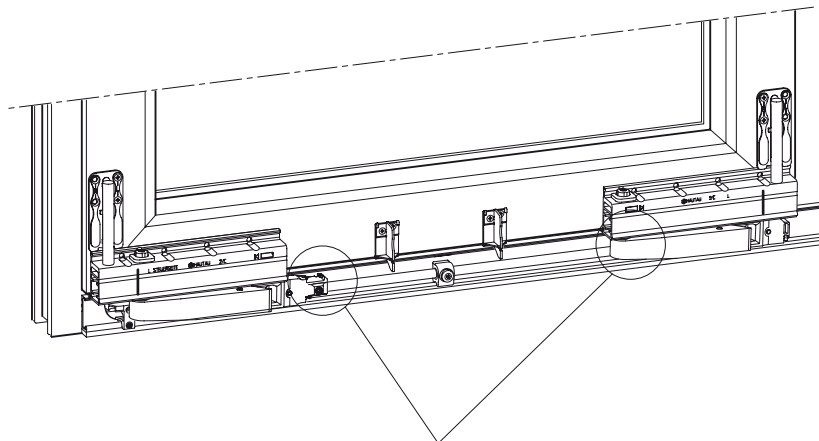
- 4** Slightly fasten top screw for guide block

- 6** Tighten both screws at guide block:
1. 4 ... 5 Nm
2. 2 ... 3 Nm



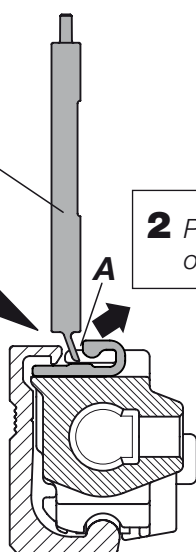
Bogie safety device

During the mounting process, it may be necessary to remove the sash again. In this case, the bogie safety devices have to be moved out of the safety position in the following way:



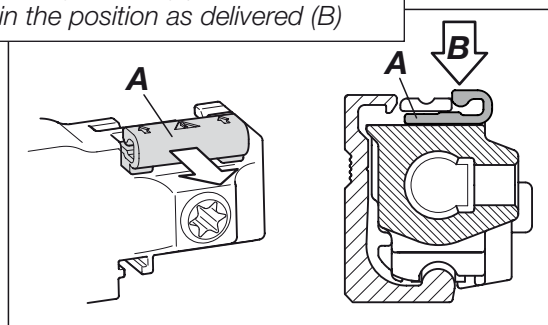
⑦ Tool for releasing the bogie safety device (A) 215283

1 Place tool behind bogie safety device (A)



2 Pull bogie safety device (A) out of safety position

3 Bogie safety device (A) must be moved back in the position as delivered (B)



TWIN bogies

