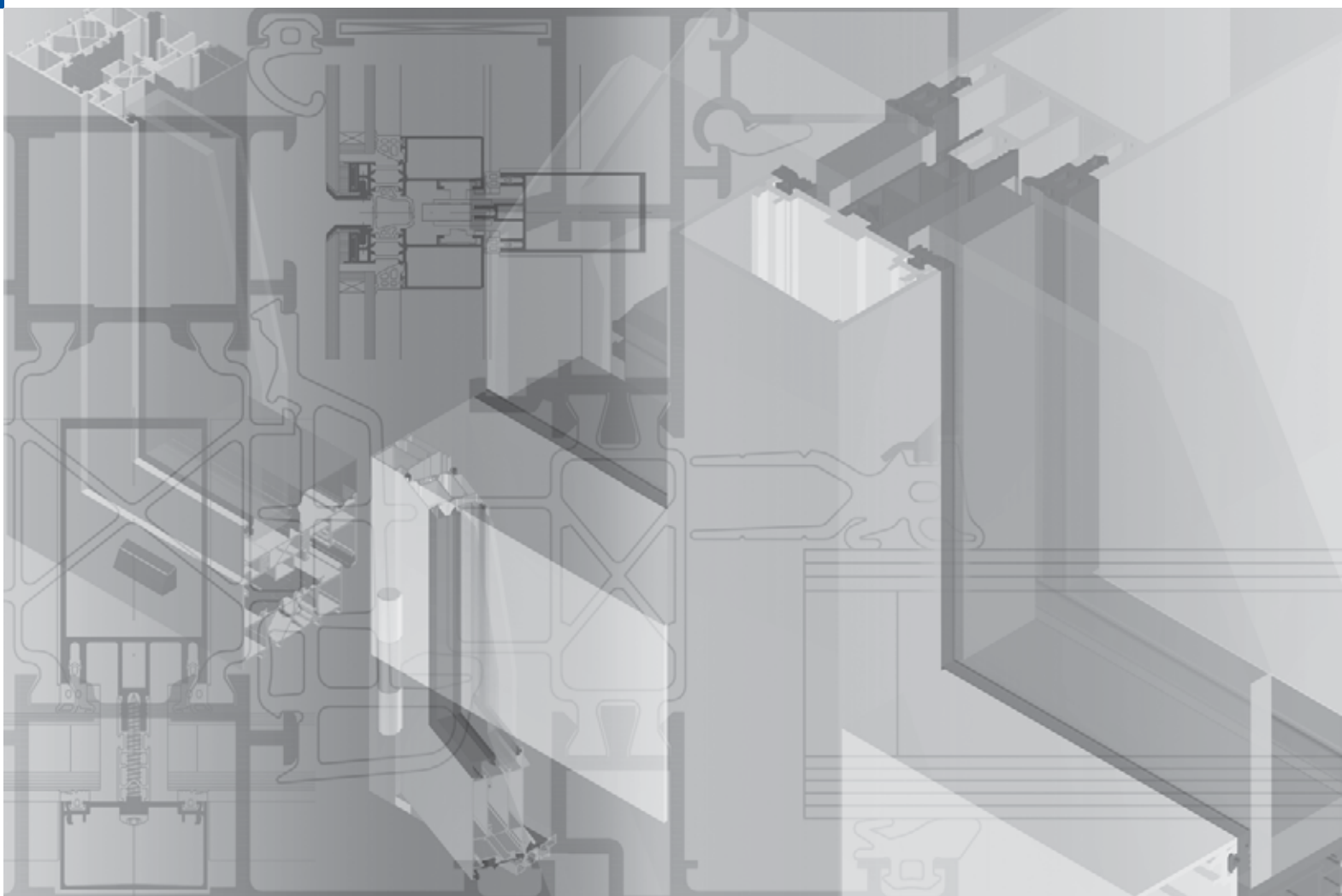


WICONA®



WICTEC® 50

Façade assembly



Façade assembly WICTEC 50

On the following pages we have put together an extract from the actual processing guidelines for the stick construction facade WICTEC 50 enlarged with industrial façades, integrated pressure plate and burglary resistant façades.

Here we present the most important mounting instructions, transom junctions, gasket junctions and essential construction points.

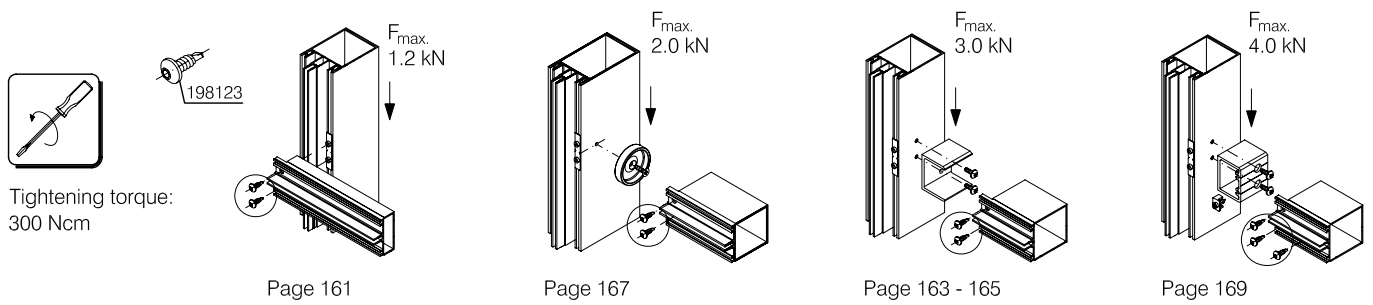
On page 1 to 6 we indicate page numbers from the detailed processing guidelines for WICTEC 50.



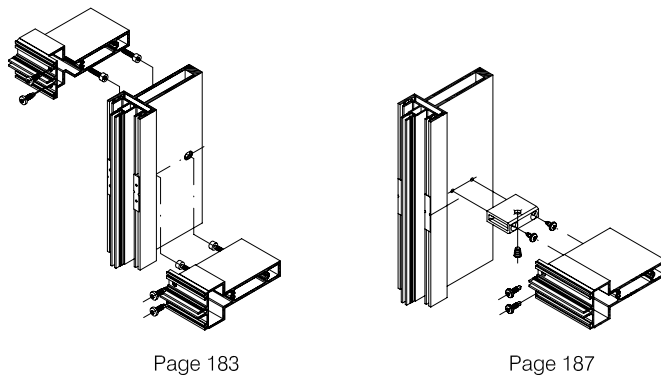
Stick construction

1. Screwing transom on mullion

1.1 Standard

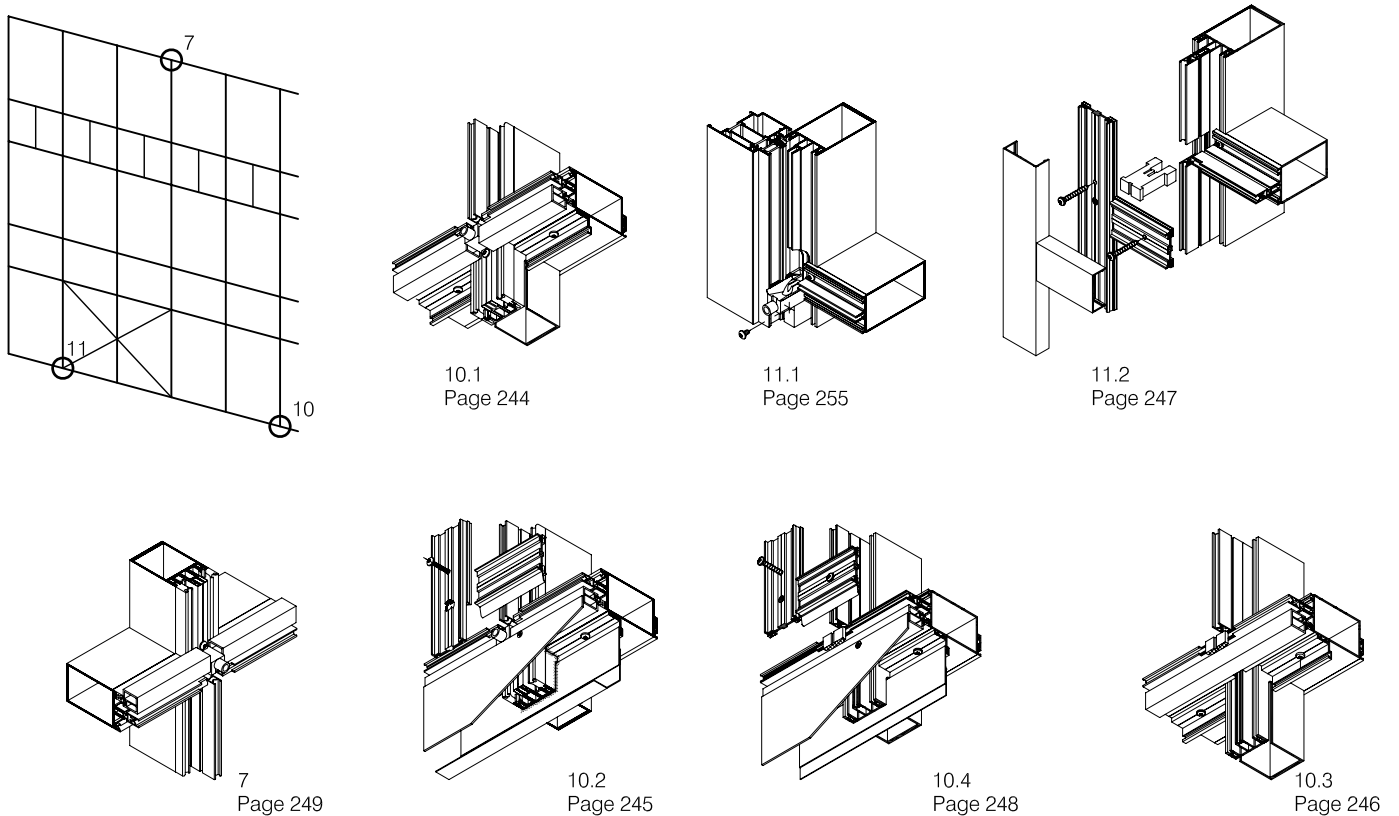


1.2 Industrial facade

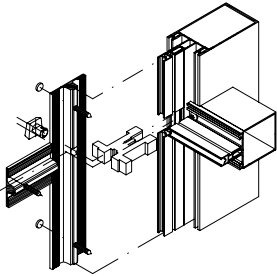


2. Drainage and ventilation of glazing rebate

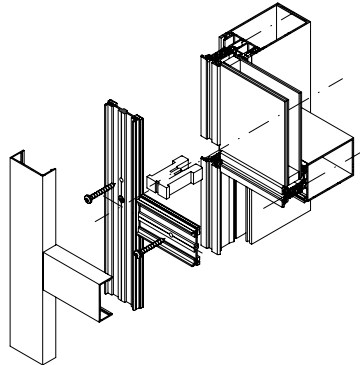
2.1



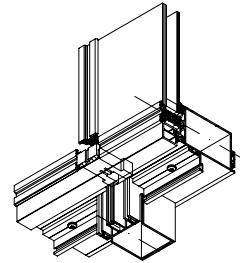
2. Drainage and ventilation of glazing rebate



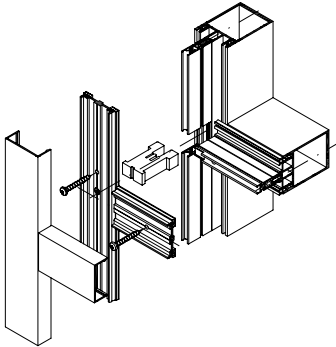
Page 256 (Integrated pressure profile)



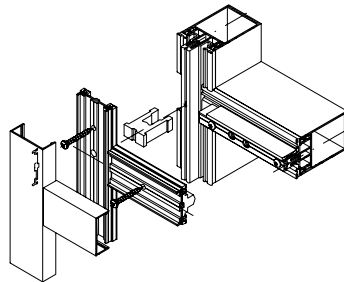
Page 269.2 (WICTEC 50HI)



Page 269.1 (WICTEC 50HI)

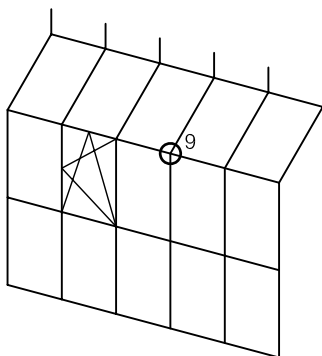


Page 247.1 (WICTEC 50P)

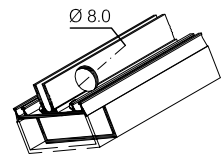
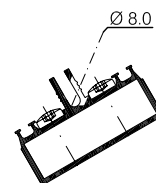
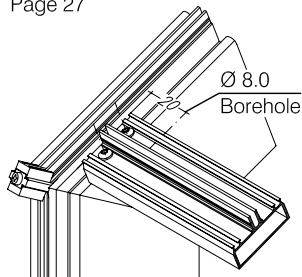


Page 247.2 (WICTEC 50E)

2.2 Kinked area



9
Page 27

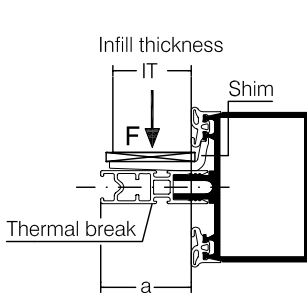


Channel opening

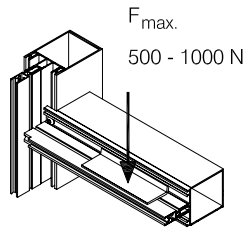
Stick construction

3. Load on glazing shim

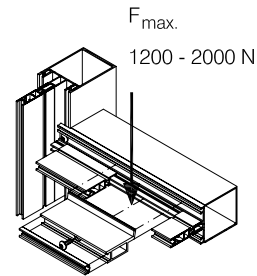
3.1 Standard



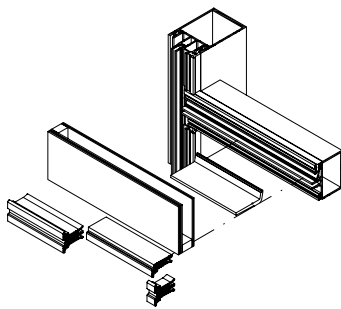
Maximum glass load = 2 x F (N)



Normal
Page 258

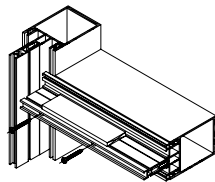


Increased
Page 258



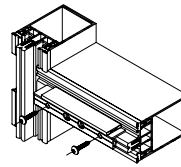
3.2 WICTEC 50HI

Page 269



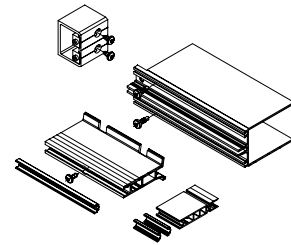
3.3 WICTEC 50P

Page 258.1



3.4 WICTEC 50E/50A

Page 258.2, 258.3



3.5 WICTEC 50DH

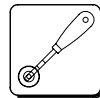
Page 263

4. Inner glazing gasket in corner area Page 280 - 299

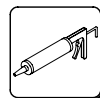
Sealing material for 4.1 / 4.2 / 4.3

Material	Cleaning agent	Sealing material
EPDM	esco no. 92-537705	esco no. 92-537683
EPDM		esco no. 92-232009

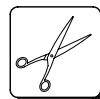
Recommendation of auxiliary means:



Rolling tool:

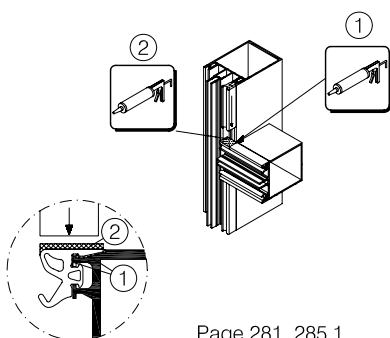


Apply cleaning agent esco no. 92-537705 and thereafter sealing material esco no. 92-537683 or esco no. 92-232009 just before mounting glass.



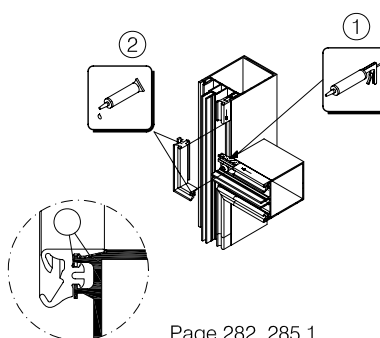
Cutting gaskets:
see chapter Cutting gasket

4.1 Metre ware



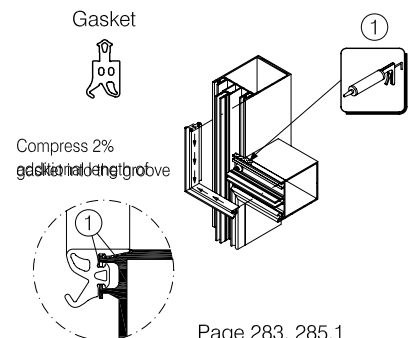
Page 281, 285.1

4.2 Moulded gasket angle



Page 282, 285.1

4.3 Vulcanized gasket frame

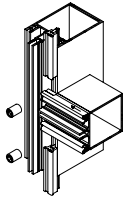


Page 283, 285.1

Stick construction

4.4 Gasket joint with sealing cord

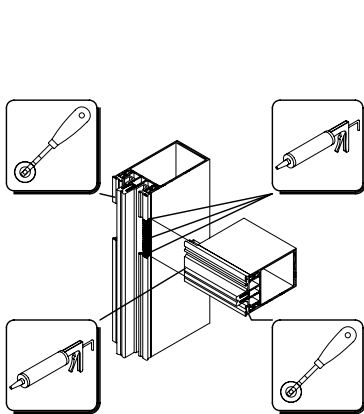
New !
free from
sealing
material



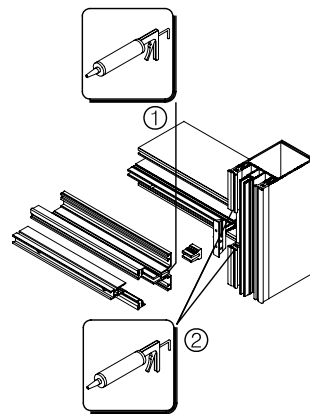
Page 284, 285

192661, length 11 m
Sealing cord,
Foam core with
Butyl coating,
black.

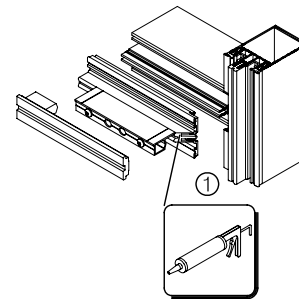
To seal gasket
joints.
Cut transom gasket
with scissors
5060084.



4.5 Notched gasket metre ware
WICTEC 50E/50A
Page 285.2, 285.3

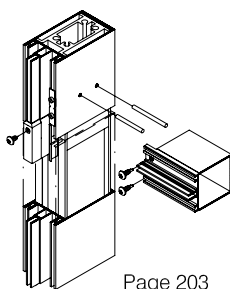
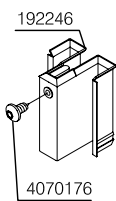


4.6 Sealing transom joint
WICTEC 50P
Page 296

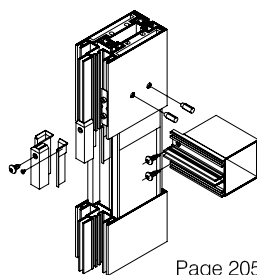


4.6 Sealing transom joint
WICTEC 50E
Page 297

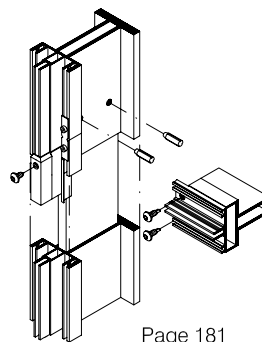
5. Safeguarding joint of sealing part (drainage part)



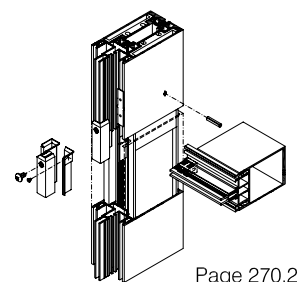
Page 203



Page 205



Page 181



Page 270.2

Stick construction

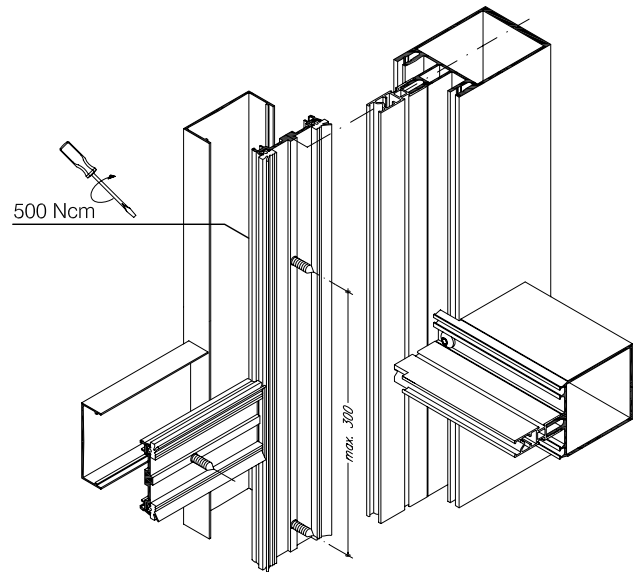
6. Tightening torque of screw



Attention:

Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm



7. Glazing

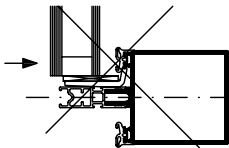


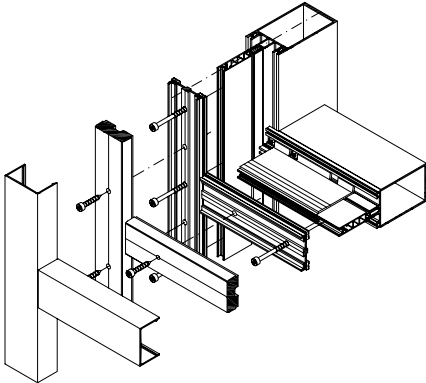
Figure 1
Position infills to the surface
of gaskets, Page 30.

For further informations contact
Hydro Building Systems GmbH
Söflinger Str. 70
89077 Ulm / Donau
Tel. 07 31 / 39 84 - 0
Fax. 07 3 / 39 84 - 241
www.wicona.de

- Place infills on supporting shims with the help of appropriate auxiliary tools such as suction apparatus, glazing lever or similar (see figure 1).
- Position infills to the surface of inner gaskets without partial or point loads on glass edge or on single glass pane of insulation glass!
- In general, the infills, especially overhanging infills, overweight infills should not be pushed towards the inner gasket layers with the pressure system of facade. The pressure profiles are part of dry glazing system and are aligned for the necessary pressure to the gasket per running centimetre.
- The pressure profiles should not be used as infill assembly help for final stop against gasket.
- Experienced facade builder use appropriate auxiliary tools for mounting infills e.g. emergency glazing, i.e. securing infill prior to final assembly.
- Therewith the assemblers can position the infills controlled and do not damage the whole glazing system.

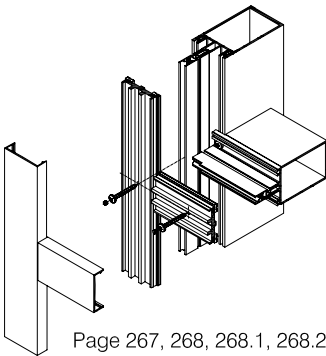
8. Assembly security constructions/ fixture constructions

8.1 WICTEC 50 bullet resistant

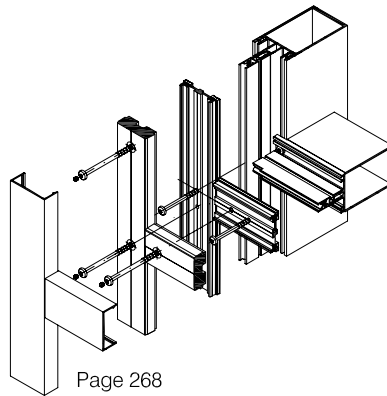


Page 259, 265

8.2 WICTEC 50 burglar resistant

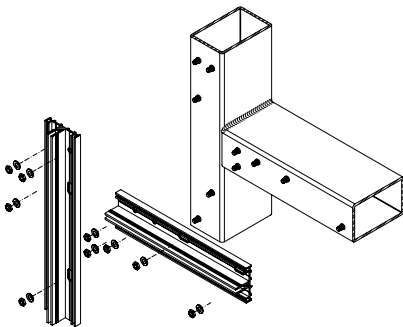


Page 267, 268, 268.1, 268.2, 268.3

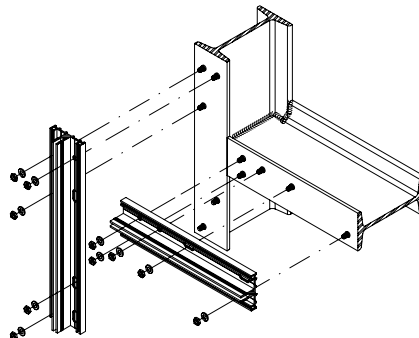


Page 268

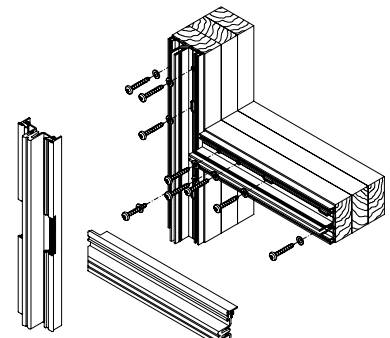
8.3 WICTEC 50A (profile 135327)



Page 270.5

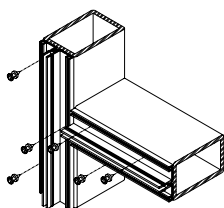


Page 270.6

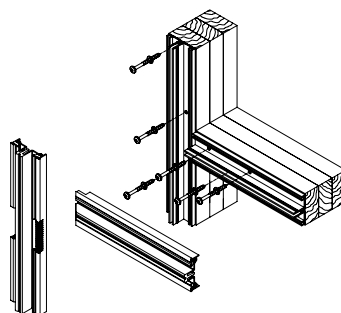


Page 270.7

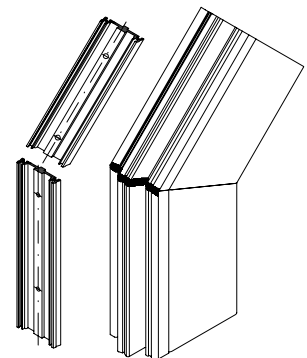
8.4 WICTEC 50A (profile 135340)



Page 270.9, 270.10



Page 270.11, 270.12, 270.13



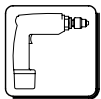
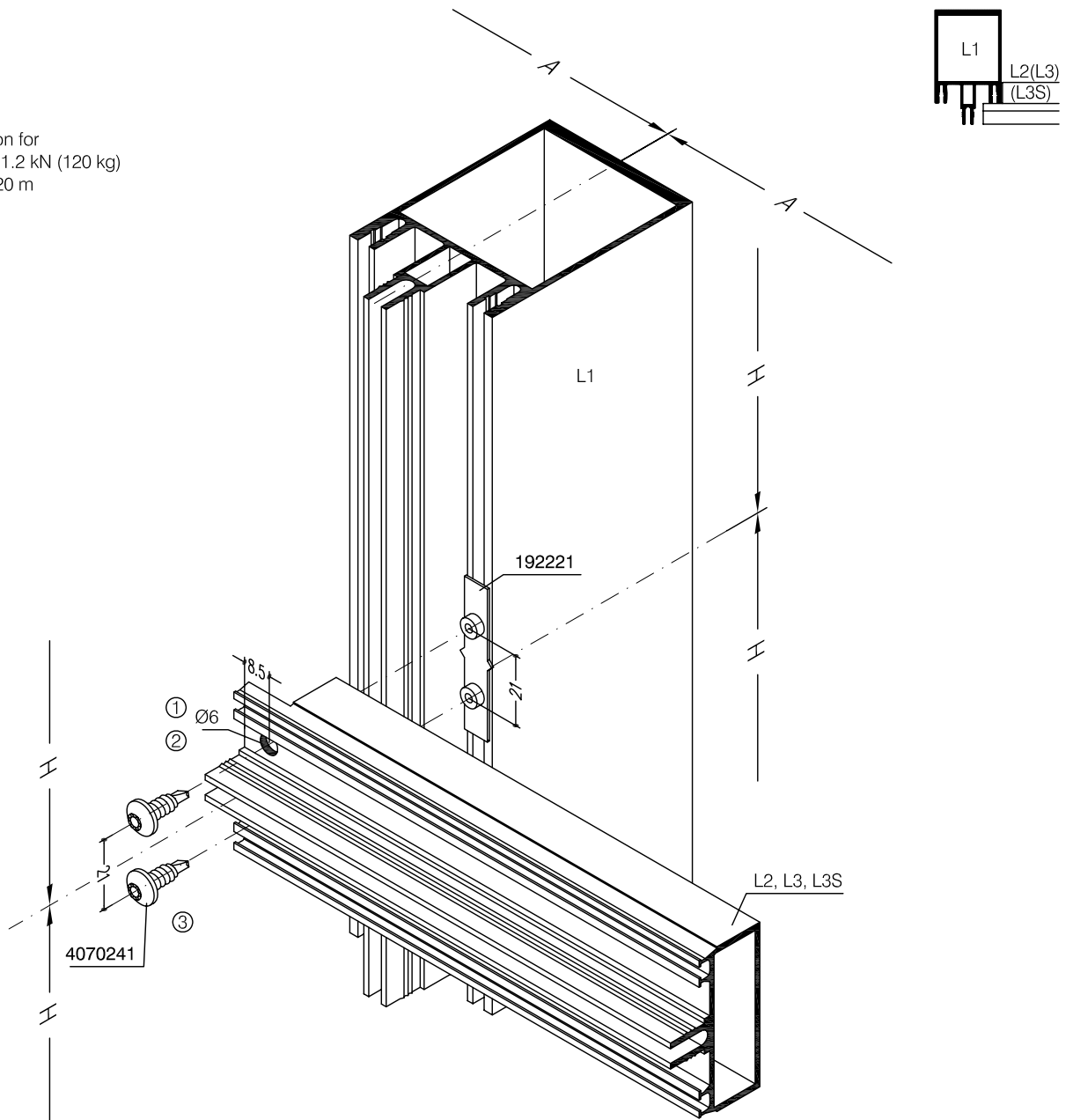
Page 285.4

WICTEC 50

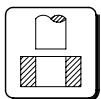
Stick construction
Transom joint without connector

Note:

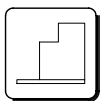
- Infill weight up to 1.2 kN (120 kg)
- Mullion axis ≤ 1.20 m



Drill template
5010367 esco-no. 91-411540) ①



Punching tool:
5040046 ②



Notching transom profile:
see chapter Transom Cutting

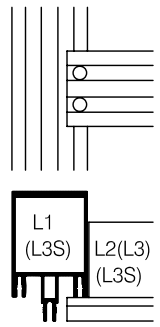
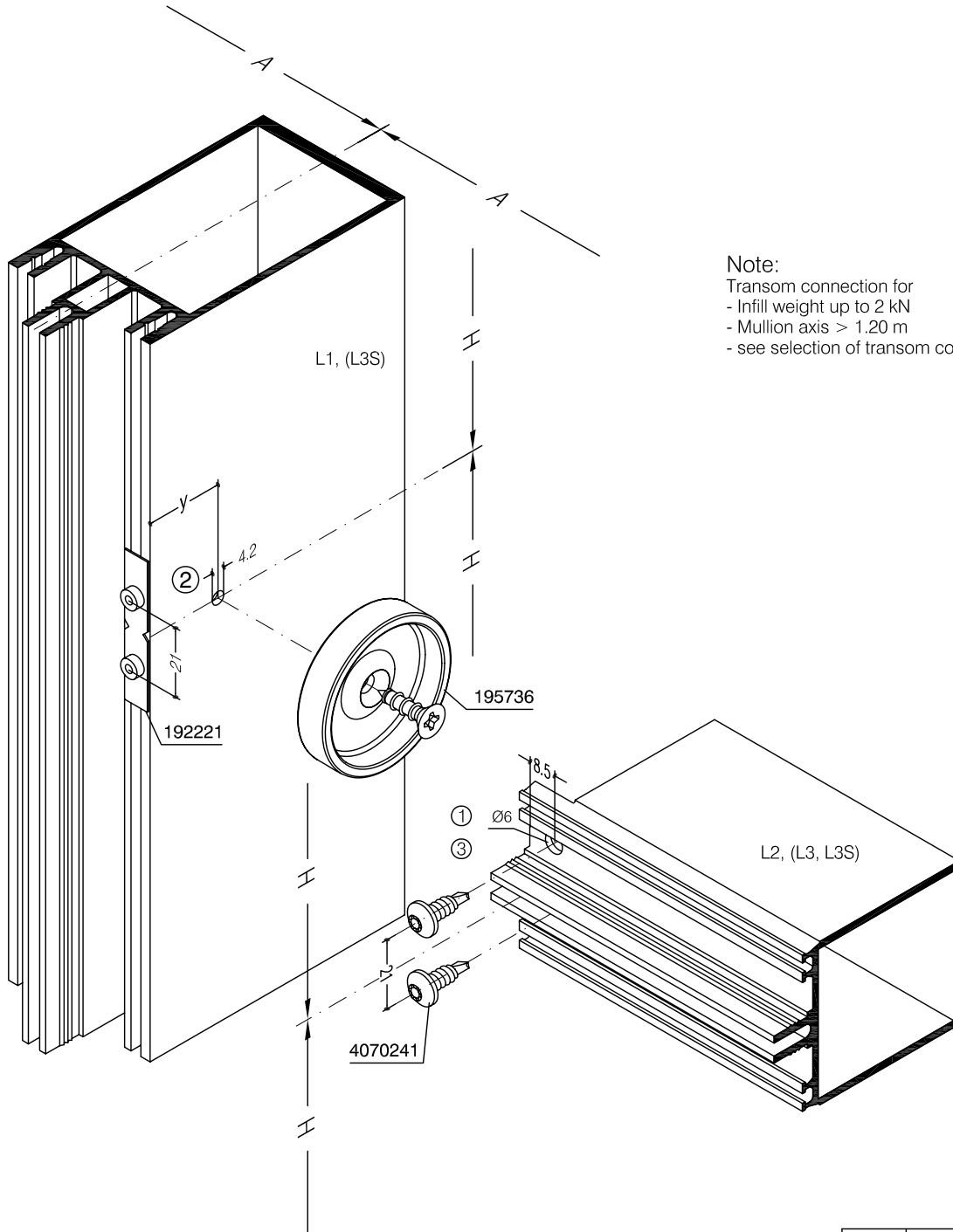


Tightening torque of screw
4070241 = 500 Ncm ③

WICTEC 50

Stick construction

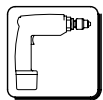
Transom joint with connector 195736



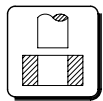
L = Level

Note:

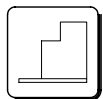
- Infill weight up to 2 kN
- Mullion axis > 1.20 m
- see selection of transom connectors



Drill template:
5010367 (esco no. 91-411540) ①
5010206 ②



Punching tool:
5040046 ③



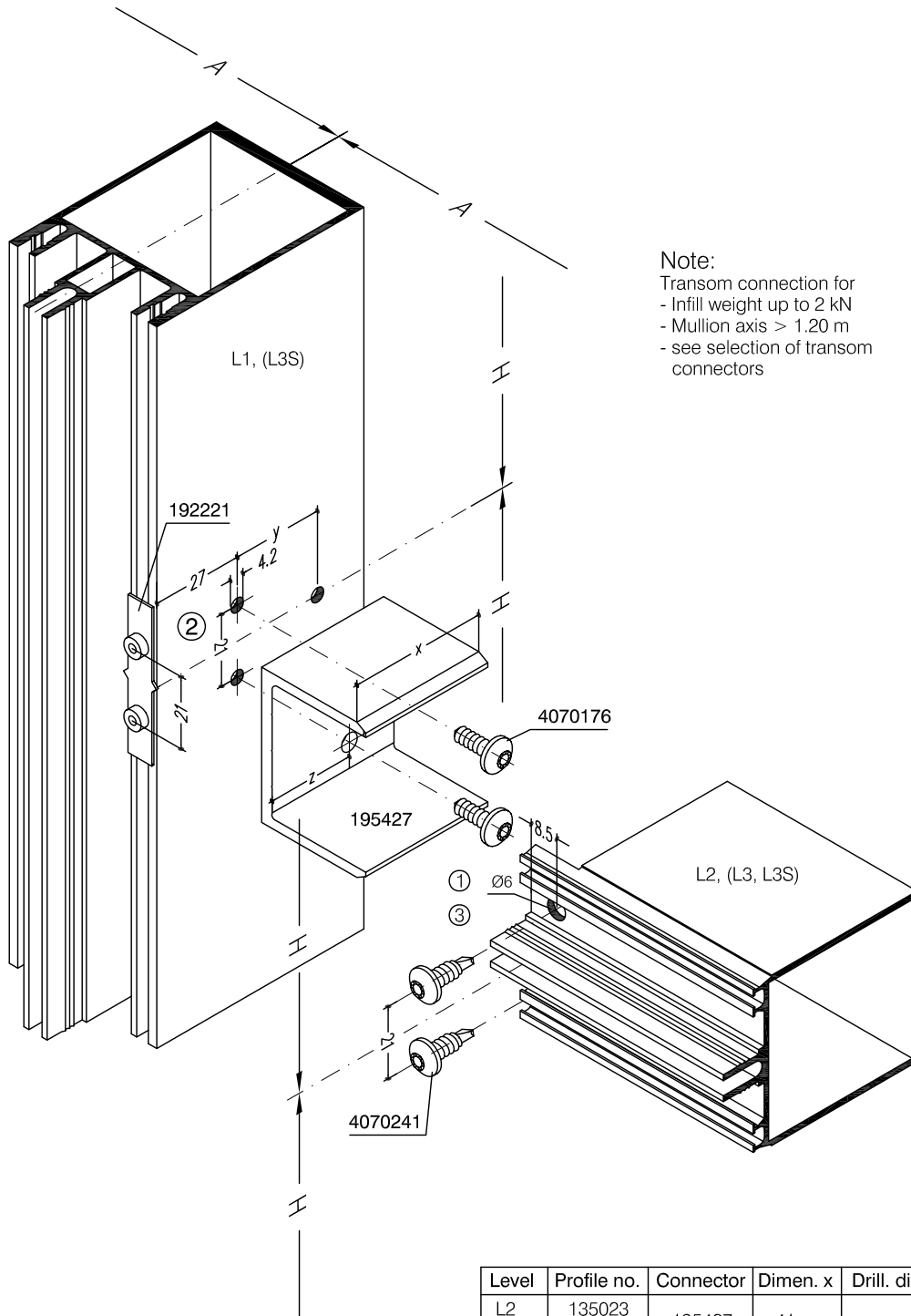
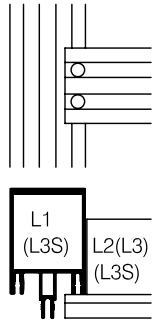
Notching transom profile:
see chapter Transom Cutting

Level	Profile no.	Drill.dimen.y
L2	135024	36 ±0.2
L3	135033	36 ±0.2
L2	135025	36 ±0.2
L3	135034	36 ±0.2
L3S	135036	42 ±0.2
L2	135026	76 ±0.3
L3	135035	76 ±0.3
L2	135027	76 ±0.3
L3S	135037	82 ±0.3
L3S	135038	82 ±0.3
L2	135028	116 ±0.3
L2	135313	116 ±0.3
L3S	135039	122 ±0.3
L2	132485	156 ±0.4

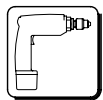
WICTEC 50

Stick construction

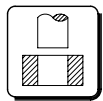
Transom joint with connectors 195427-195432



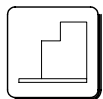
Note:
 Transom connection for
 - Infill weight up to 2 kN
 - Mullion axis > 1.20 m
 - see selection of transom connectors



Drill template:
 5010367 (esco-no.91-411540) ①
 5010373 (esco-no.91-429740) ②



Punching tool:
 5040046 ③

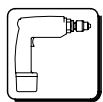
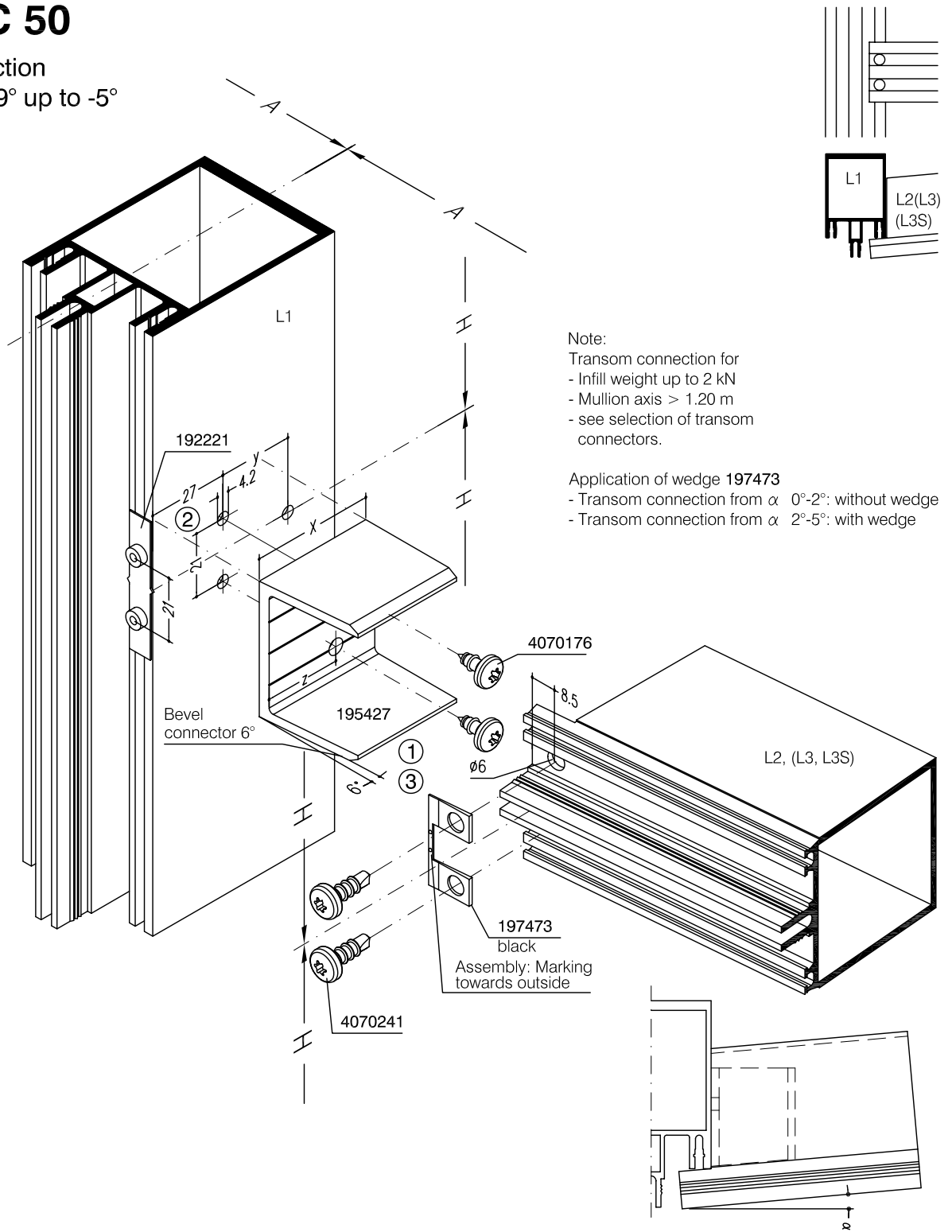


Notching transom profile:
 see chapter Transom Cutting

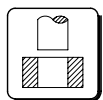
Level	Profile no.	Connector	Dimen. x	Drill. dim. y	Dimen. z
L2	135023	195427	41±0.2	-	26±0.2
L3	135032				
L2	135024	195428	61±0.2	25±0.2	26±0.2
L3	135033				
L2	135025	195429	81±0.25	45±0.25	26±0.25
L3	135034				
L2	135026	195430	101±0.3	65±0.3	26±0.3
L3	135035				
L2	135027	195431	121±0.3	85±0.3	26±0.3
L2	135028	195432	141±0.4	105±0.4	26±0.4
L2	135313	195432	141±0.4	105±0.4	26±0.4
L2	132485	195432	141±0.4	105±0.4	26±0.4
L3S	135036	195442	61±0.2	45±0.2	10±0.2
L3S	135037	195443	81±0.25	65±0.25	10±0.25
L3S	135038	195444	101±0.3	85±0.3	10±0.3
L3S	135039	195445	121±0.3	105±0.3	10±0.3

WICTEC 50

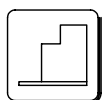
Stick construction
Outer corner 9° up to -5°



Drill template:
5010367 (esco-no.91-411540) ①
5010373 (esco-no.91-429740) ②



Punching tool:
5040046 ③

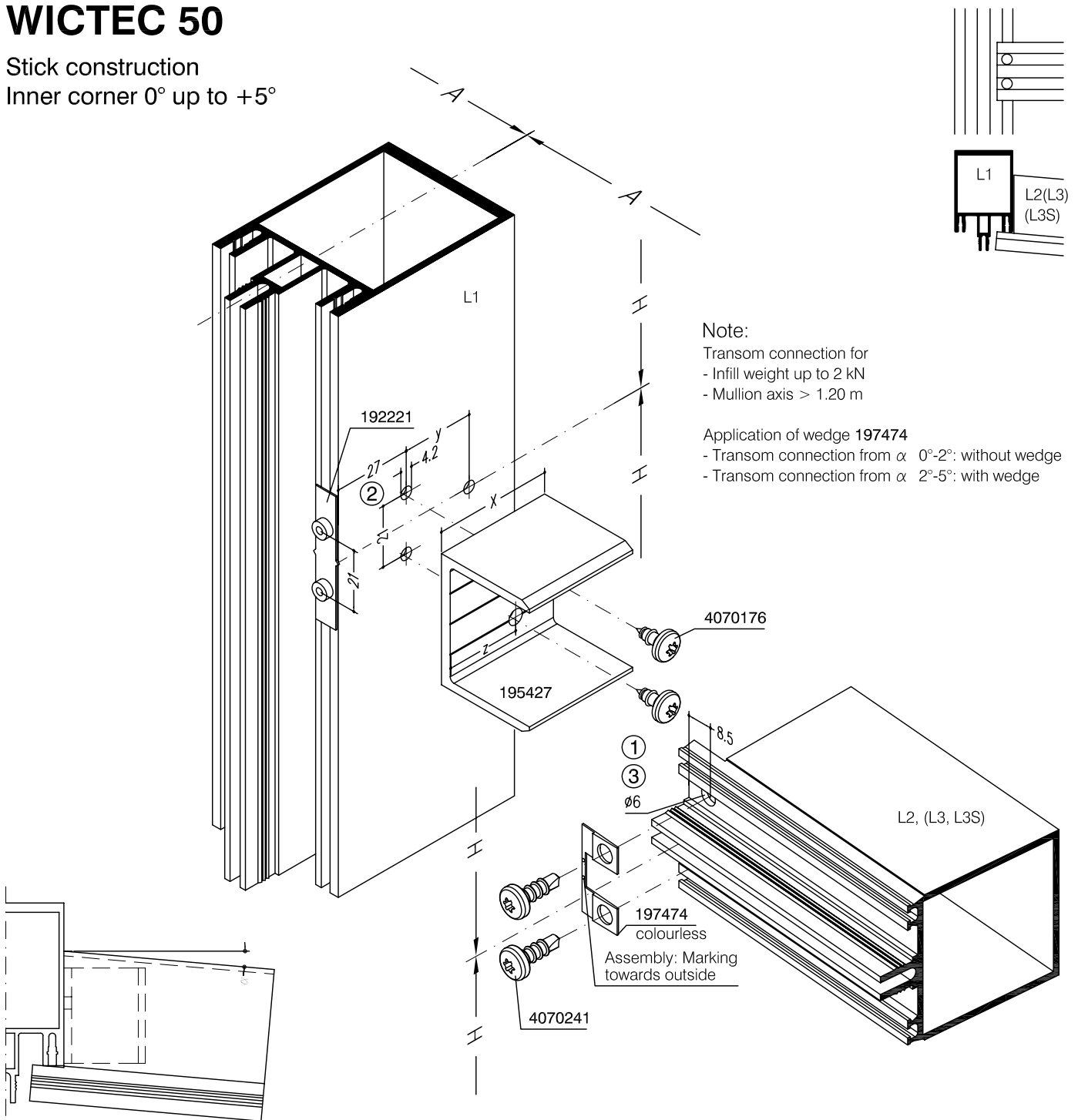


Notching transom profile:
See chapter Transom Cutting
for polygon (0° up to -5°)

Level	Profile no.	Connector	Dimen. x	Drill. dim. y	Dimen. z
L2	135023	195427	41 ±0,2	-	26 ±0,2
L3	135032				
L2	135024	195428	61 ±0,2	25 ±0,2	26 ±0,2
L3	135033				
L2	135025	195429	81 ±0,25	45 ±0,25	26 ±0,25
L3	135034				
L2	135026	195430	101 ±0,3	65 ±0,3	26 ±0,3
L3	135035				
L2	135027	195431	121 ±0,3	85 ±0,3	26 ±0,3
L2	135028	195432	141 ±0,4	105 ±0,4	26 ±0,4
L2	132485	195432	141 ±0,4	105 ±0,4	26 ±0,4
L2	135313	195432	141 ±0,4	105 ±0,4	26 ±0,4
L3S	135036	195442	61 ±0,2	45 ±0,2	10 ±0,2
L3S	135037	195443	81 ±0,25	65 ±0,25	10 ±0,25
L3S	135038	195444	101 ±0,3	85 ±0,3	10 ±0,3
L3S	135039	195445	121 ±0,3	105 ±0,3	10 ±0,3

WICTEC 50

Stick construction
Inner corner 0° up to +5°

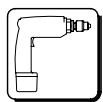


Note:

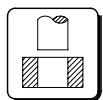
Transom connection for
- Infill weight up to 2 kN
- Mullion axis > 1.20 m

Application of wedge 197474

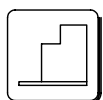
- Transom connection from α 0°-2°: without wedge
- Transom connection from α 2°-5°: with wedge



Drill template:
5010367 (esco-no.91-411540) ①
5010373 (esco-no.91-429740) ②



Punching tool:
5040046 ③



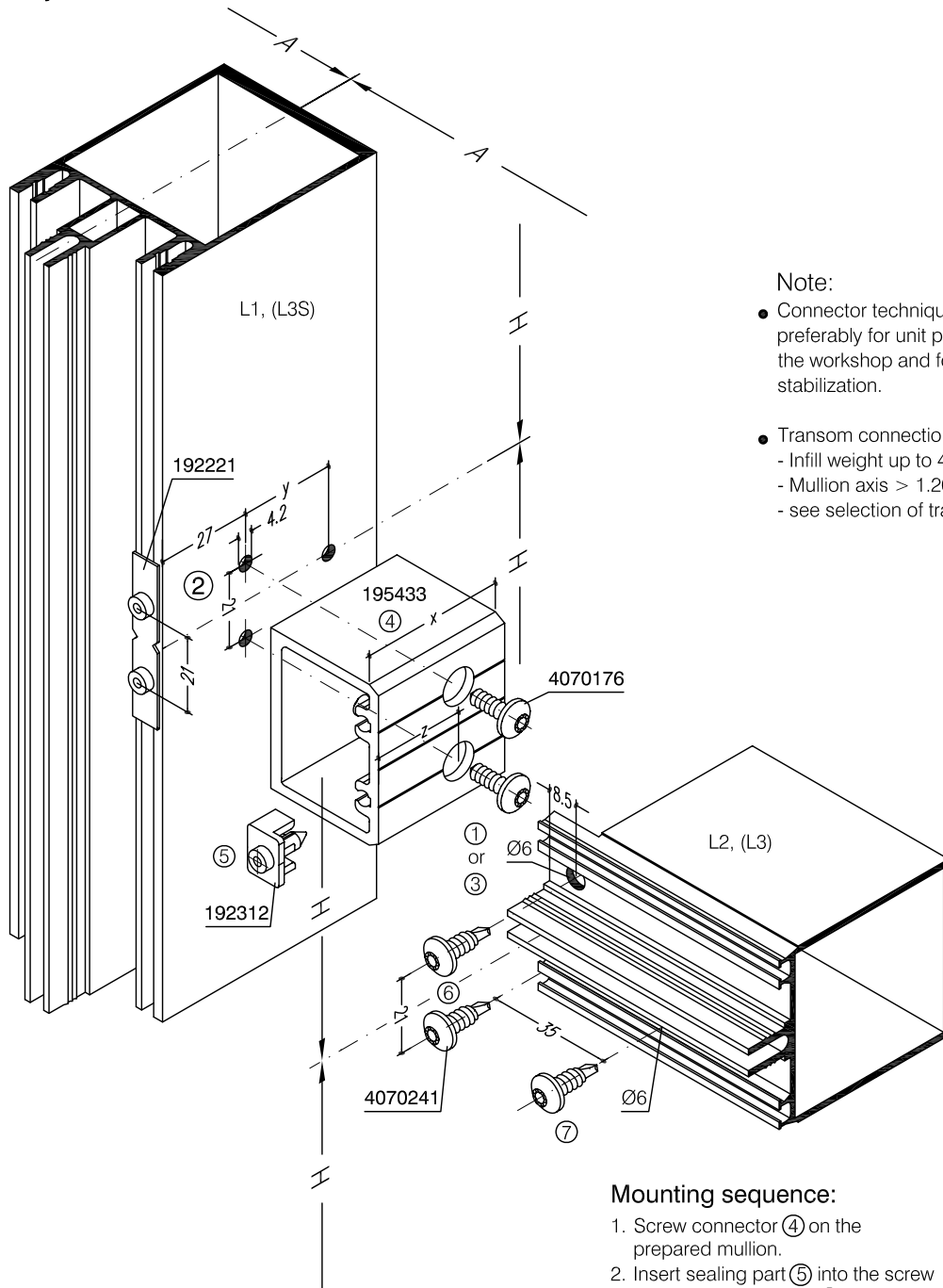
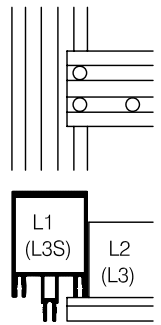
Notching transom profile:
See chapter Transom Cutting
for polygon (0° up to +5°)

Level	Profile no.	Connector	Dimen. x	Drill dim. y	Dimen. z
L2	135023	195427	41 ±0,2	-	26 ±0,2
L3	135032				
L2	135024	195428	61 ±0,2	25 ±0,2	26 ±0,2
L3	135033				
L2	135025	195429	81 ±0,25	45 ±0,25	26 ±0,25
L3	135034				
L2	135026	195430	101 ±0,3	65 ±0,3	26 ±0,3
L3	135035				
L2	135027	195431	121 ±0,3	85 ±0,3	26 ±0,3
L2	135028	195432	141 ±0,4	105 ±0,4	26 ±0,4
L2	132485	195432	141 ±0,4	105 ±0,4	26 ±0,4
L2	135313	195432	141 ±0,4	105 ±0,4	26 ±0,4
L3S	135036	195442	61 ±0,2	45 ±0,2	10 ±0,2
L3S	135037	195443	81 ±0,25	65 ±0,25	10 ±0,25
L3S	135038	195444	101 ±0,3	85 ±0,3	10 ±0,3
L3S	135039	195445	121 ±0,3	105 ±0,3	10 ±0,3

WICTEC 50

Stick construction

Transom joint with connectors 195433-195438

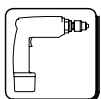


Note:

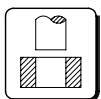
- Connector technique suitable preferably for unit pre-assembly in the workshop and for transport stabilization.
- Transom connection for
 - Infill weight up to 4 kN
 - Mullion axis > 1.20 m
 - see selection of transom connectors

Mounting sequence:

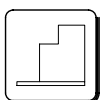
1. Screw connector ④ on the prepared mullion.
2. Insert sealing part ⑤ into the screw channel of connector ④.
3. Mount transoms on connectors.
4. Screw transoms on mullion profile ⑥.
5. Screw transoms to the connector ⑦.



Drill template:
5010367 (esco no. 91-411540) ①
5010373 (esco no. 91-429740) ②



Punching tool:
5040046 ③



Notching transom profile:
see chapter Transom Cutting



Tightening torque of screw
4070241= 500 Ncm ⑥

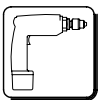
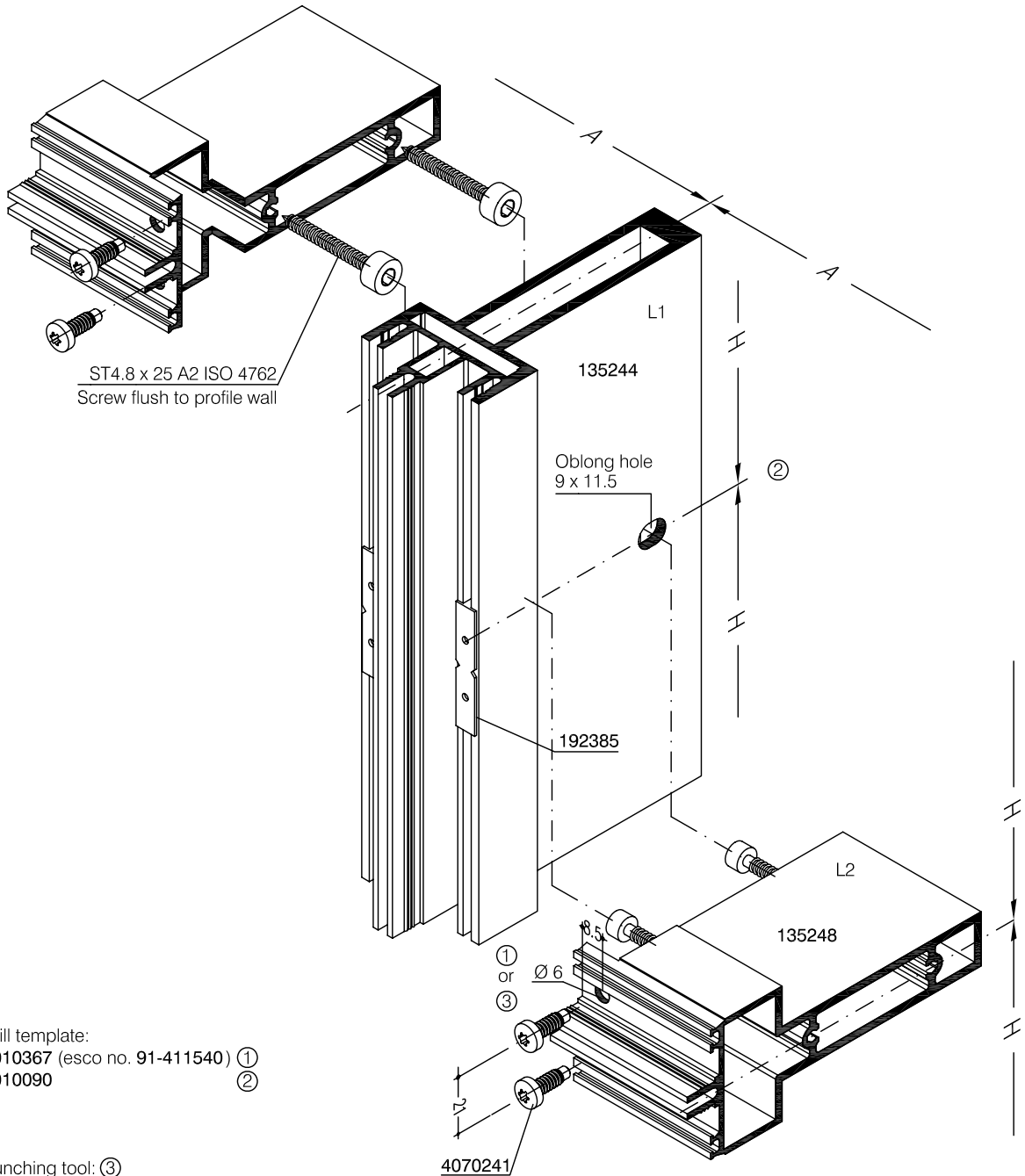
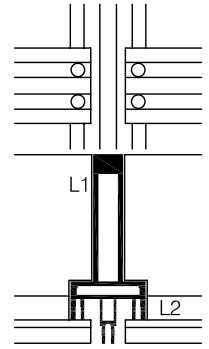
Level	Profile no.	Connector	Dimen. x	Drill. dimen. y	Dimen. z
L2	135023				
L3	135032	195433	41 ±0,2	-	26 ±0,2
L2	135024	195434	61 ±0,2	25 ±0,2	26 ±0,2
L3	135033				
L2	135025	195435	81 ±0,25	45 ±0,25	26 ±0,25
L3	135034				
L2	135026	195436	101 ±0,3	65 ±0,3	26 ±0,3
L3	135035				
L2	135027	195437	121 ±0,3	85 ±0,3	26 ±0,3
L2	135028	195438	141 ±0,4	105 ±0,4	26 ±0,4
L2	135313	195438	141 ±0,4	105 ±0,4	26 ±0,4
L2	132485	195438	141 ±0,4	105 ±0,4	26 ±0,4

WICTEC 50

Stick construction
Industrial facade
Transom joint without connector

Note:

- Transom connection for
- Infill weight up to 2 kN (200 kg)
- Mullion axis > 1.20 m



Drill template:
5010367 (esco no. 91-411540) ①
5010090 ②



Punching tool: ③
5040046 or
5040047 (esco no. 94-449385)



Notching transom profile:
see chapter Transom Cutting

WICTEC 50

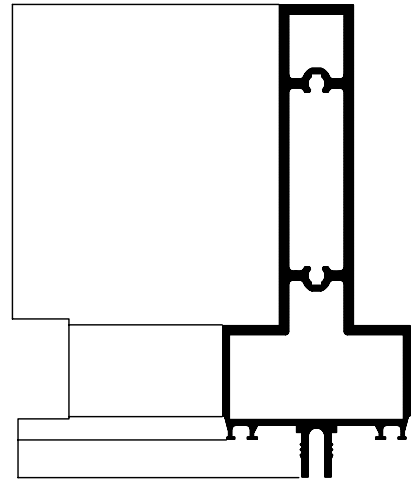
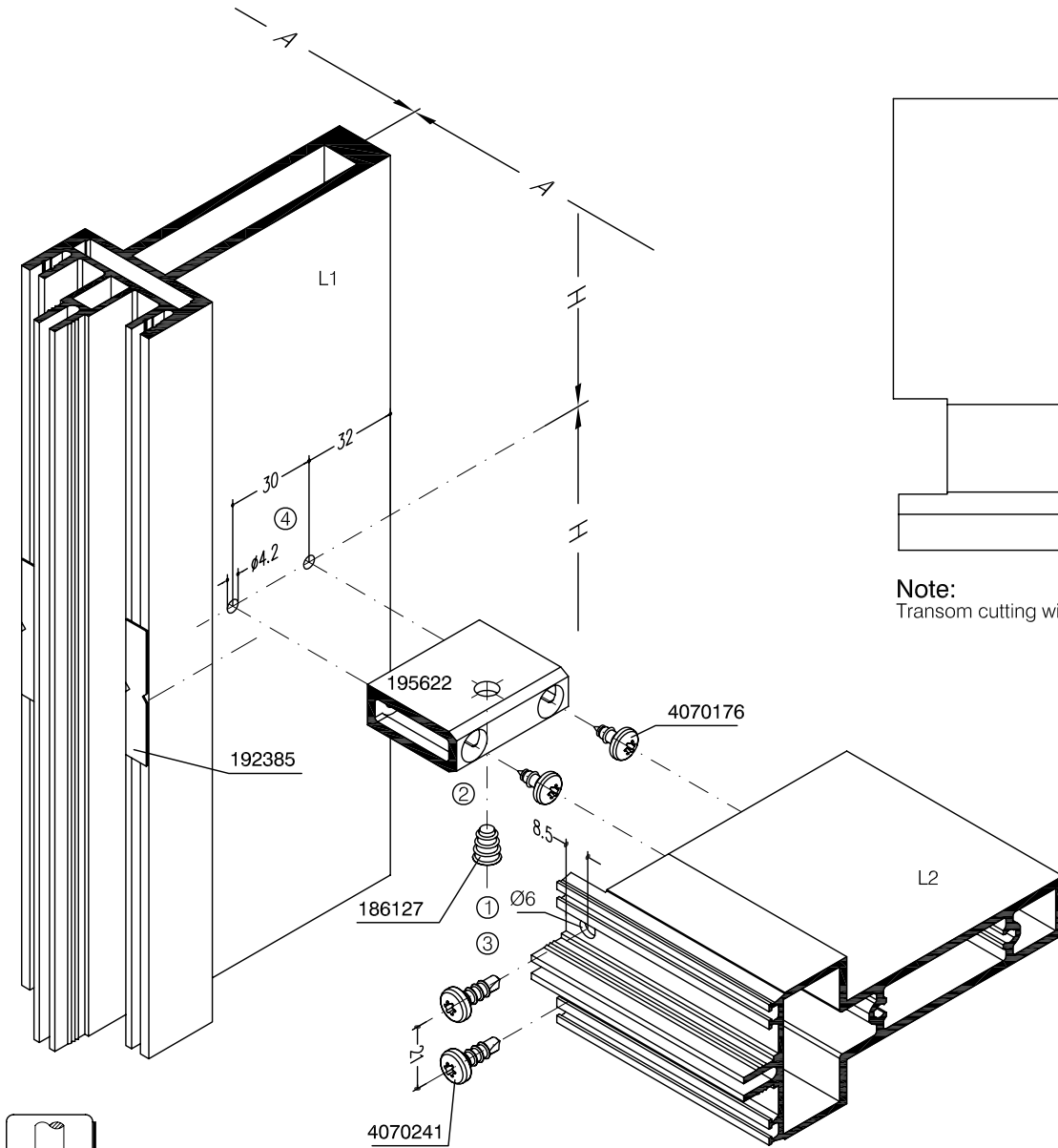
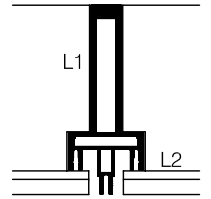
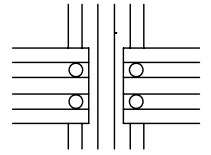
Stick construction

Industrial facade

Transom joint with connector 195622

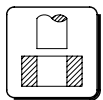
Note:

- Transom connection for
- Infill weight up to 2 kN (200 kg)
- Mullion axis > 1.20 m

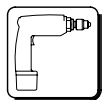


Note:

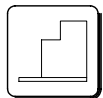
Transom cutting without expansion gap



Punching tool:
5040046 ③



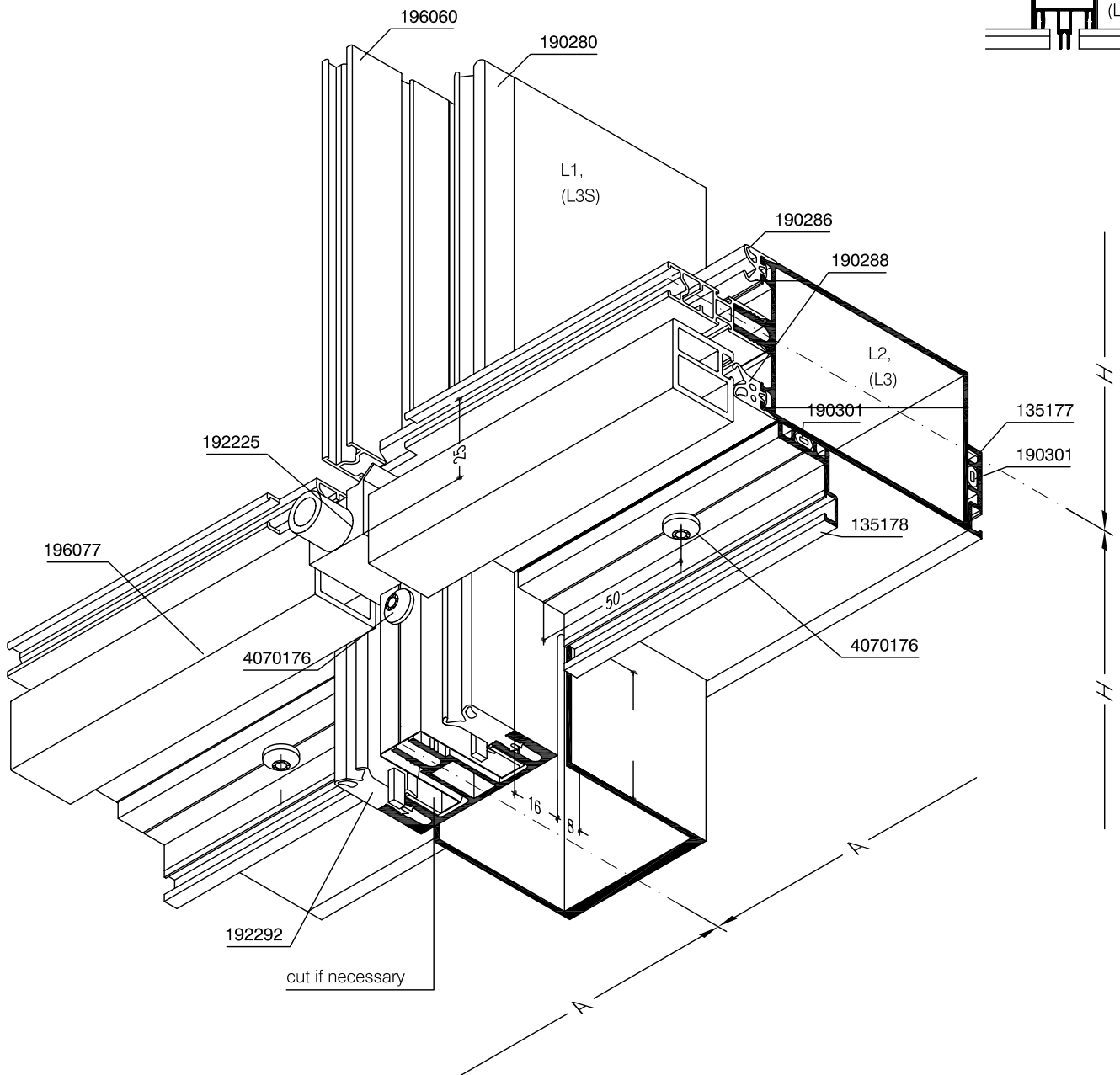
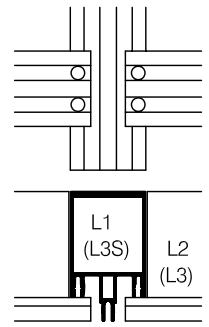
Drill template:
5010367 (esco-no. 91-411540)
5010091 ②
5010092 ④



Notching transom profile:
see chapter Transom Cutting

WICTEC 50

Stick construction
Base point



Use drainage parts 192225, 192241, 192242 also at mullion joint.



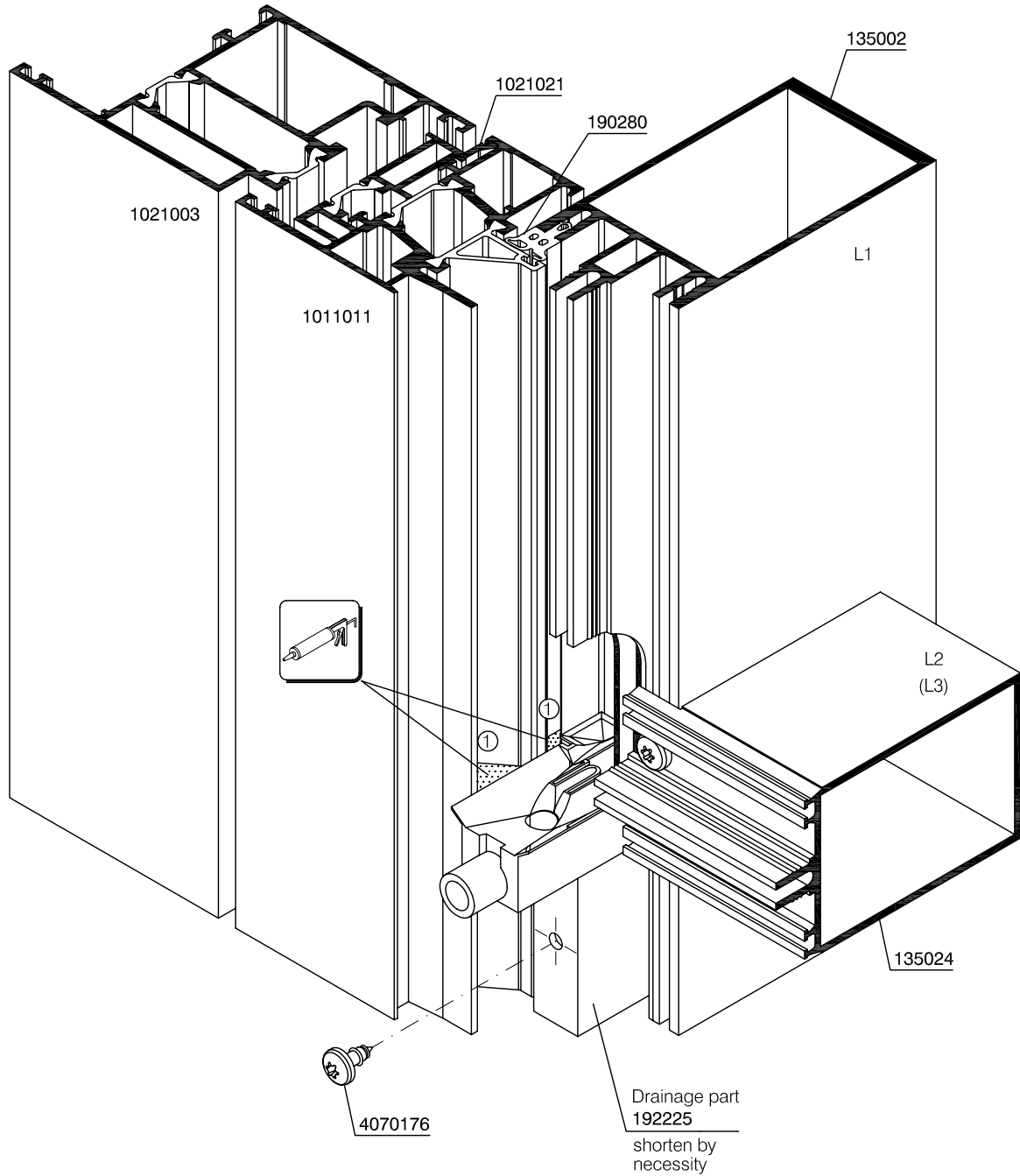
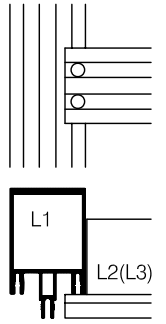
For cutting gaskets and profile 196077 see Cutting List.



Notching transom profile: see chapter Transom Cutting

WICTEC 50

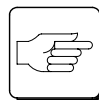
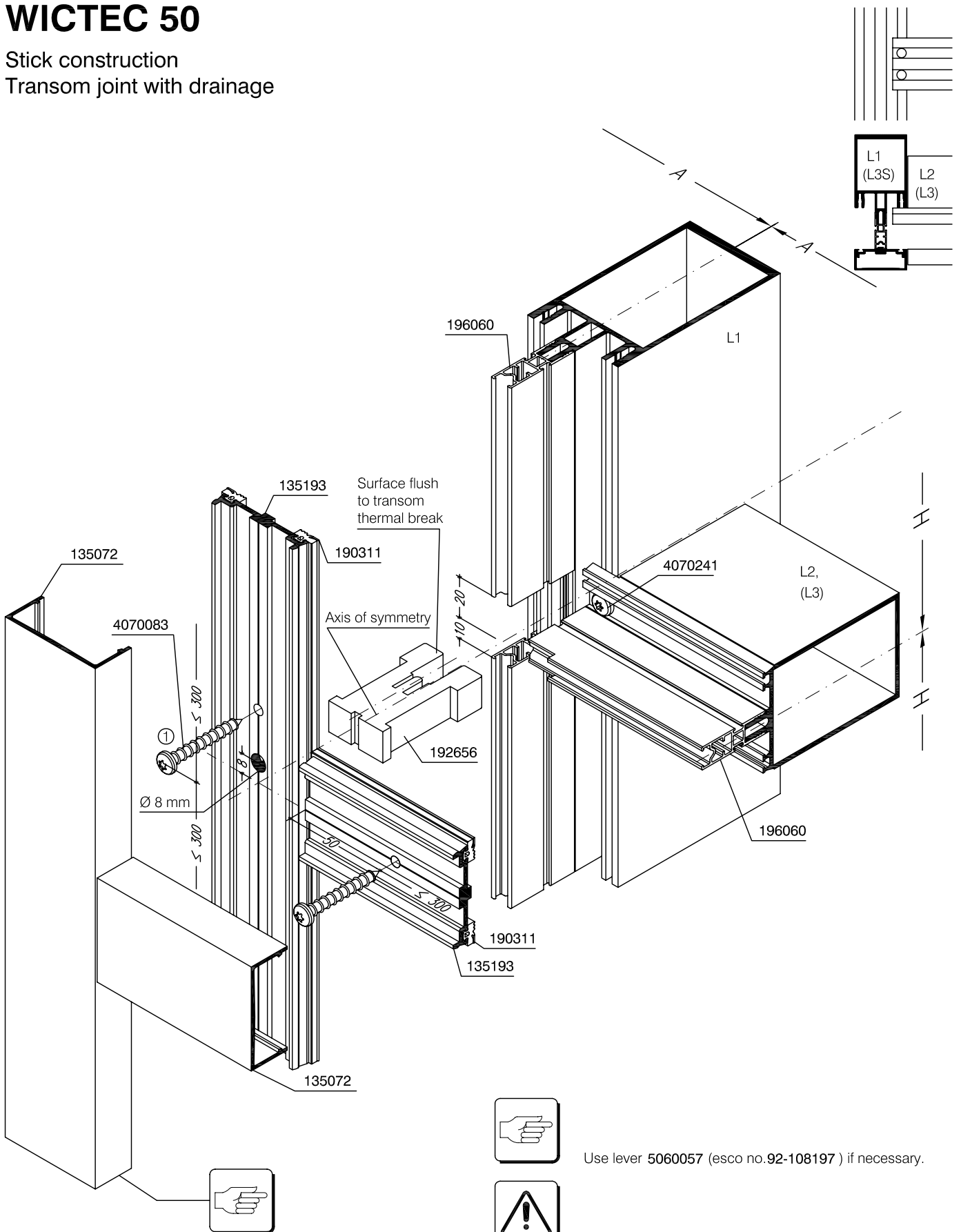
Stick construction
Junction to door element
Base point



Seal open areas to the profile
with esco no. 92-537683
or esco no. 92-232009 ①.

WICTEC 50

Stick construction
Transom joint with drainage

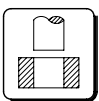


Use lever 5060057 (esco no.92-108197) if necessary.



Attention:
Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm



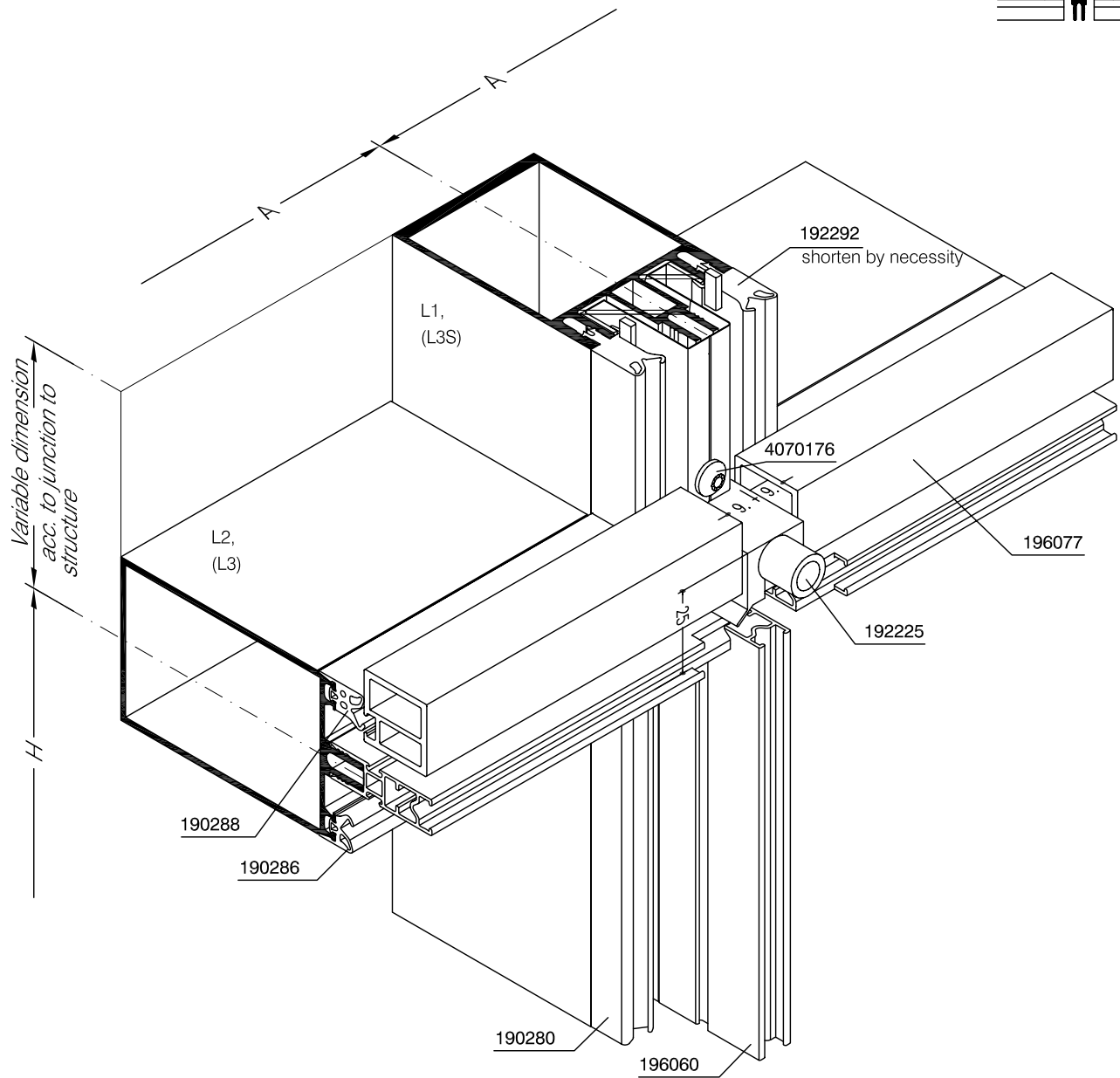
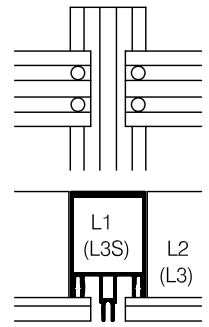
Punching tool:
5040044 ①



Cutting thermal break, pressure and cover profiles:
see chapter Cutting

WICTEC 50

Stick construction
Top point



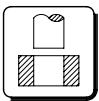
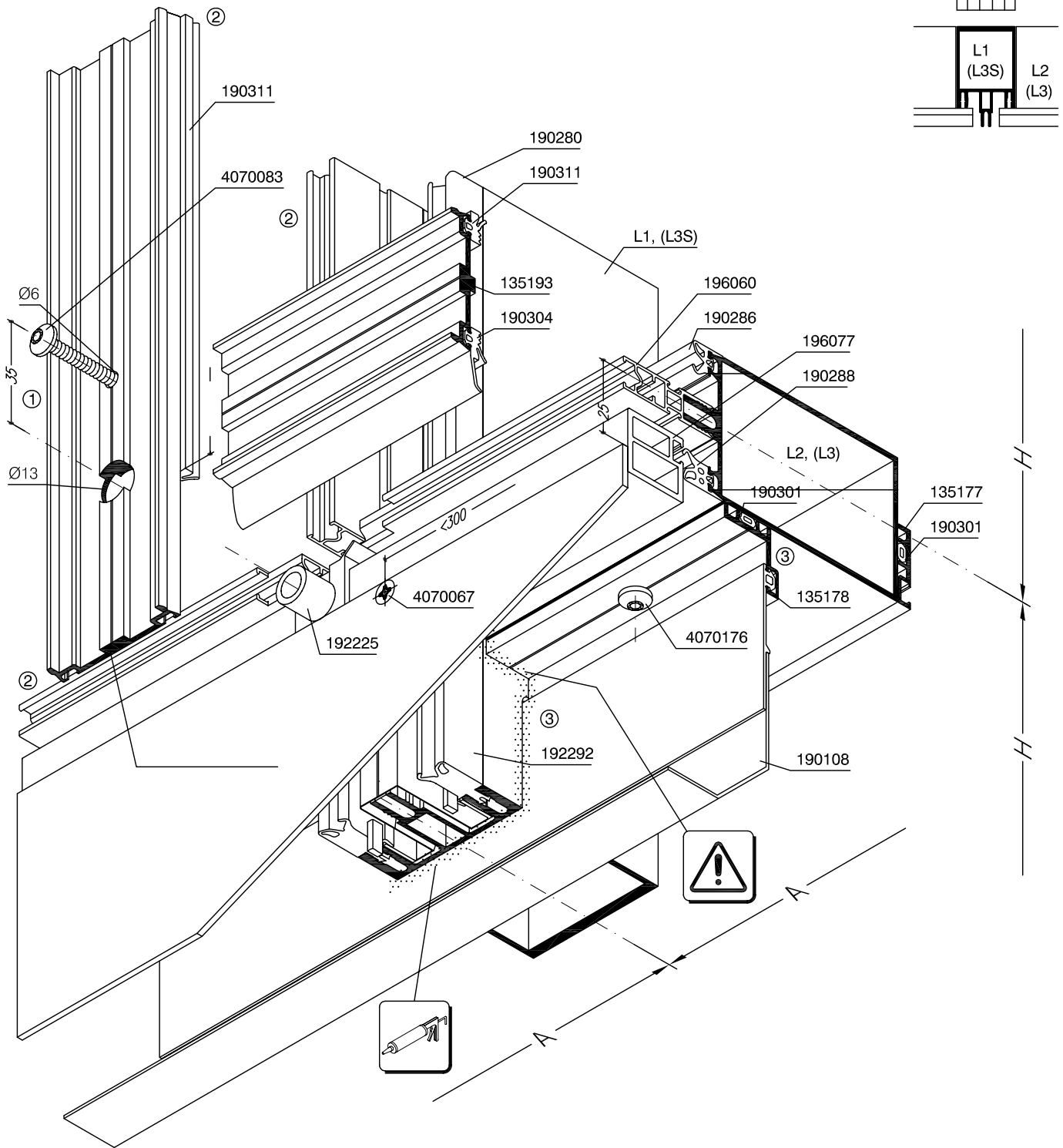
For cutting gaskets
see Cutting List



Notching transom profile:
see chapter Transom Cutting

WICTEC 50

Stick construction
Base point



Punching tool:
5040044 ①



For cutting gaskets and profiles ②
see Cutting List.



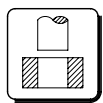
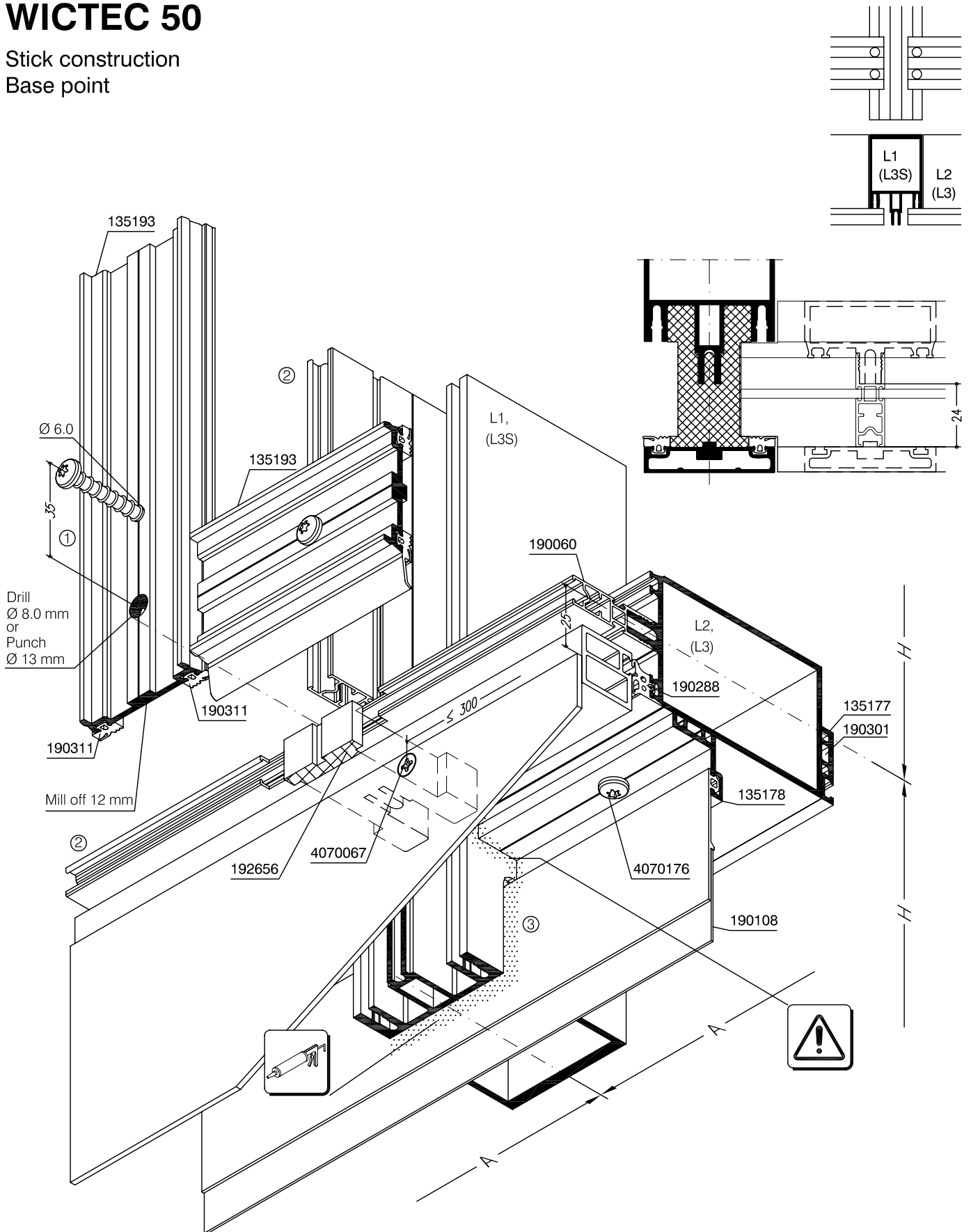
Seal profile 135178 with sealing material 92-537683
or 92-232009 (also on the front side).



Seal foil to the mullion:
92-537683 or 92-232009 ③

WICTEC 50

Stick construction
Base point



Punching tool:
5040044 ①



For cutting gaskets and profiles
see Cutting List ②



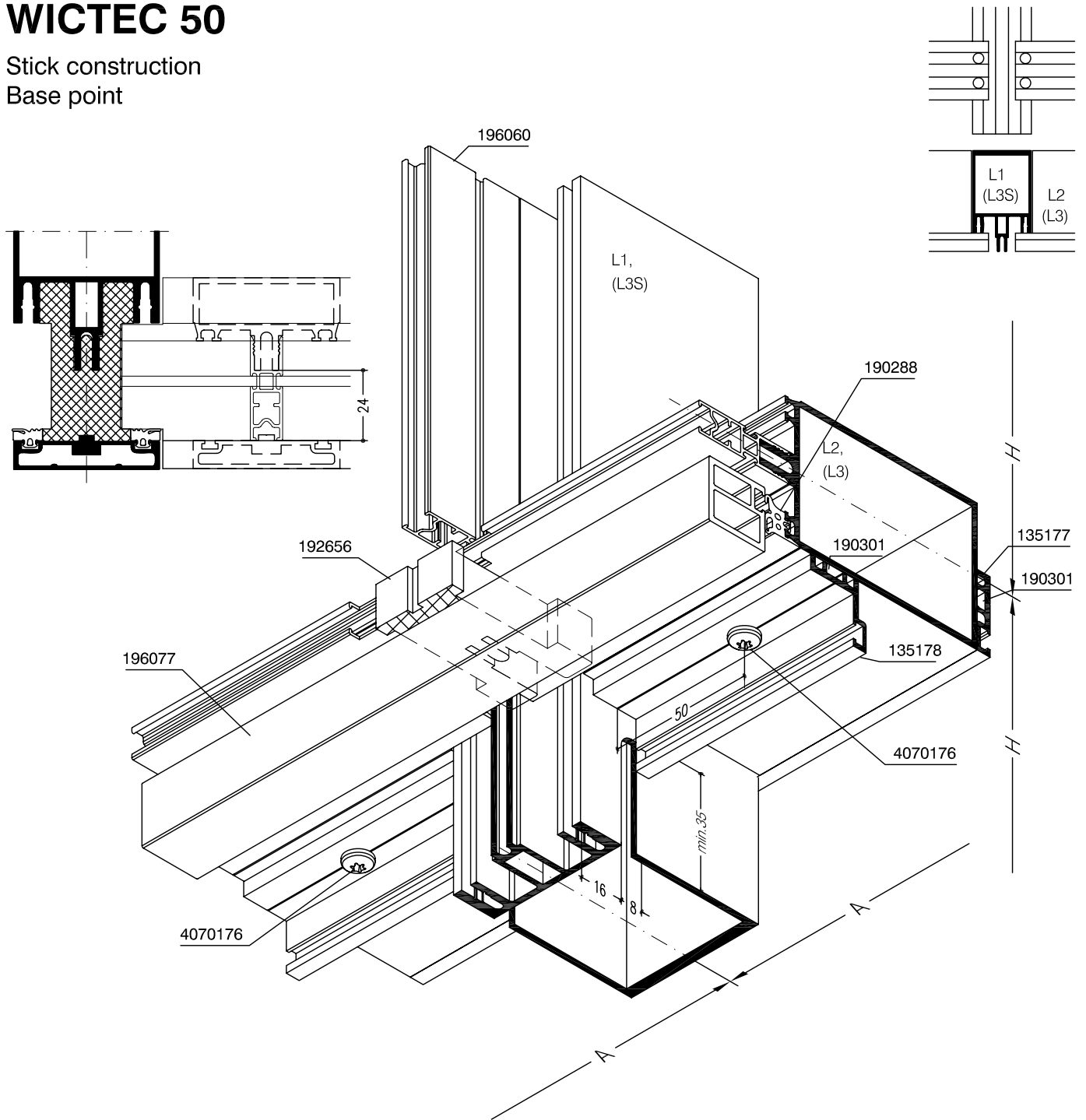
Seal profile 135178 with sealing material 92-537683
or 92-232009 (also on the front side).



Seal foil to the mullion:
92-537683 or 92-232009 ③

WICTEC 50

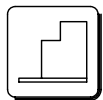
Stick construction
Base point



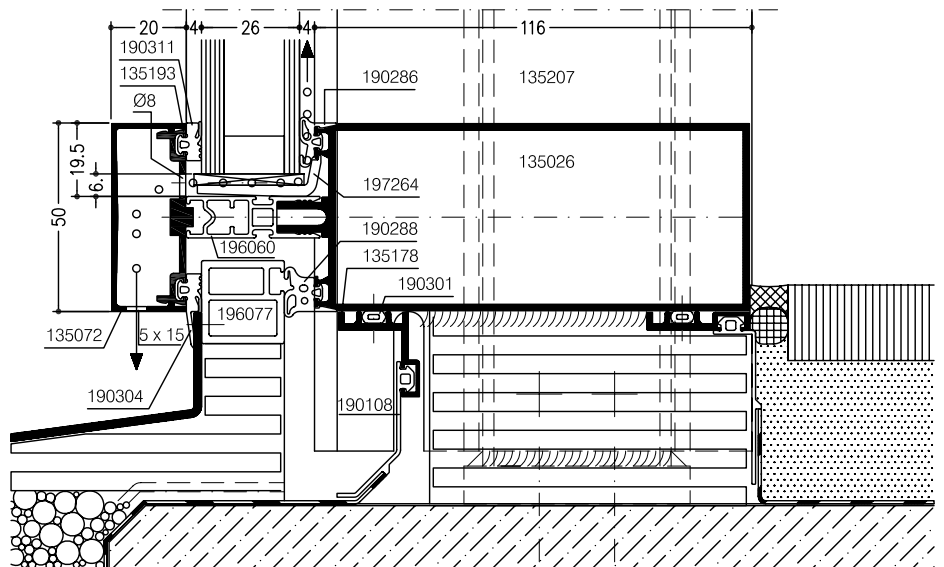
Drainage parts
192654, 192655, 192656, 192657,
192658, 192659, 192660
use also at mullion joints.



For cutting gaskets and profile
196077 see Cutting List

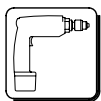
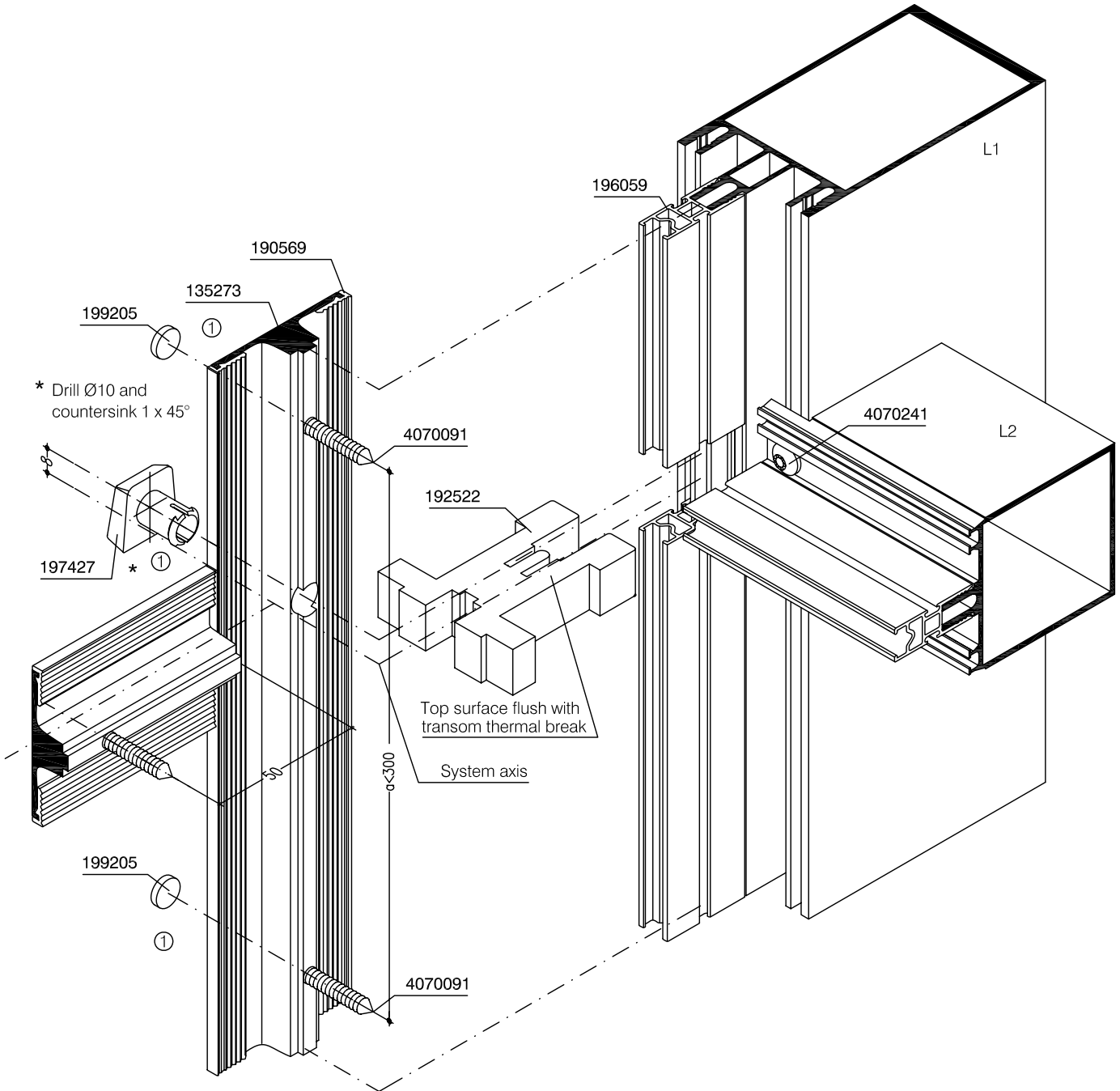
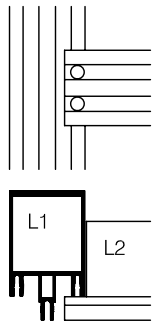


Notching transom profile:
see chapter Transom Cutting



WICTEC 50

Stick construction
 Integrated pressure profiles
 Transom joint with drainage
 Pressure profile 135273



Drill template:
 5010383 (esco no. 91-515639) ①
 5010373 (esco no. 91-429740) ②



Cutting thermal break and pressure profiles:
 see chapter Cuttings

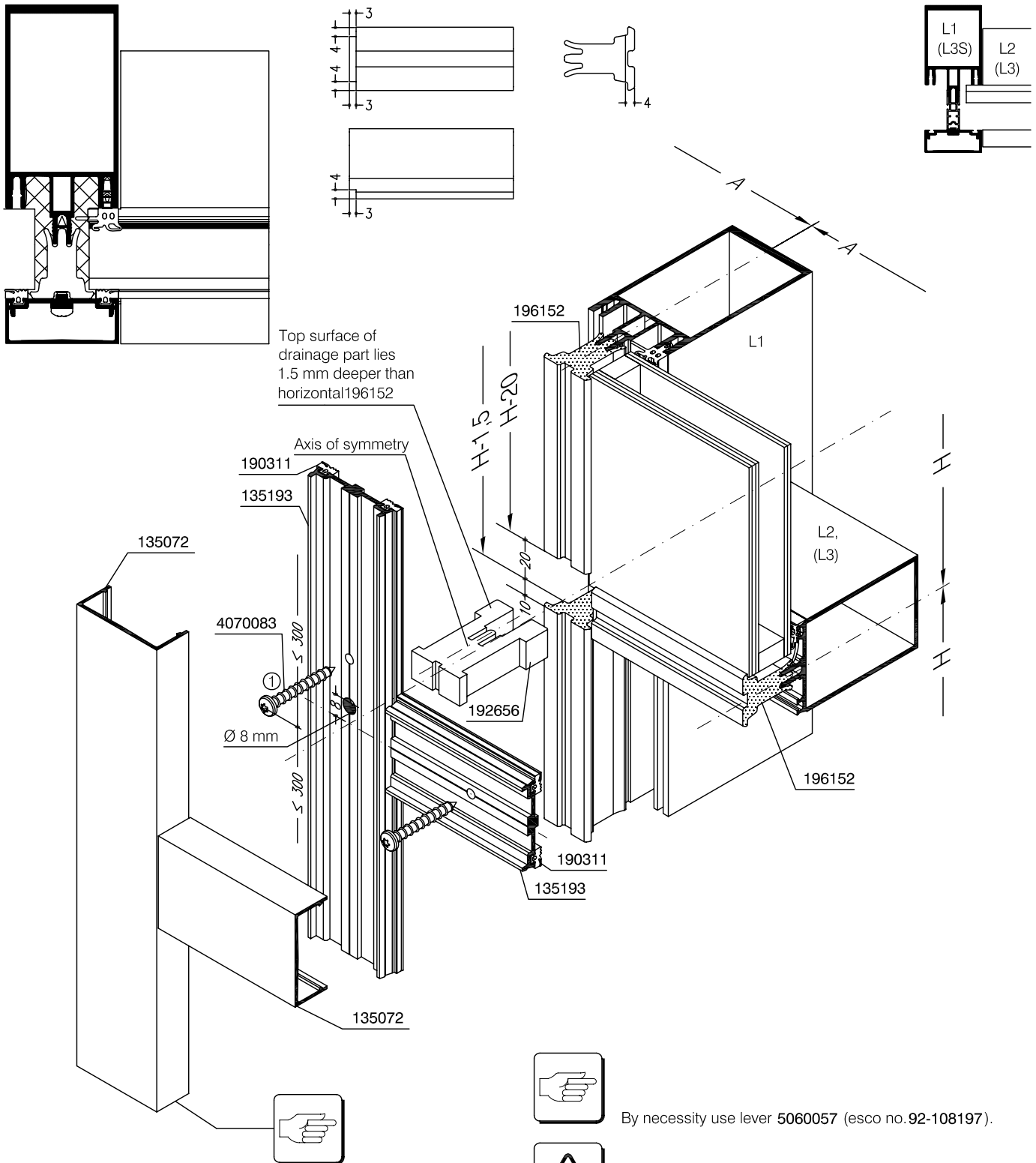


Attention:
 Tightening torque of screw for pressure profile: 500 Ncm.
 Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
 20 m assembly height = $a < 300$ mm
 above 20 m assembly height = $a < 150$ mm

WICTEC 50HI

Stick construction
Transom joint with drainage



Top surface of drainage part lies 1.5 mm deeper than horizontal 196152

Axis of symmetry

By necessity use lever 5060057 (esco no.92-108197).



Attention:
Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m Assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm



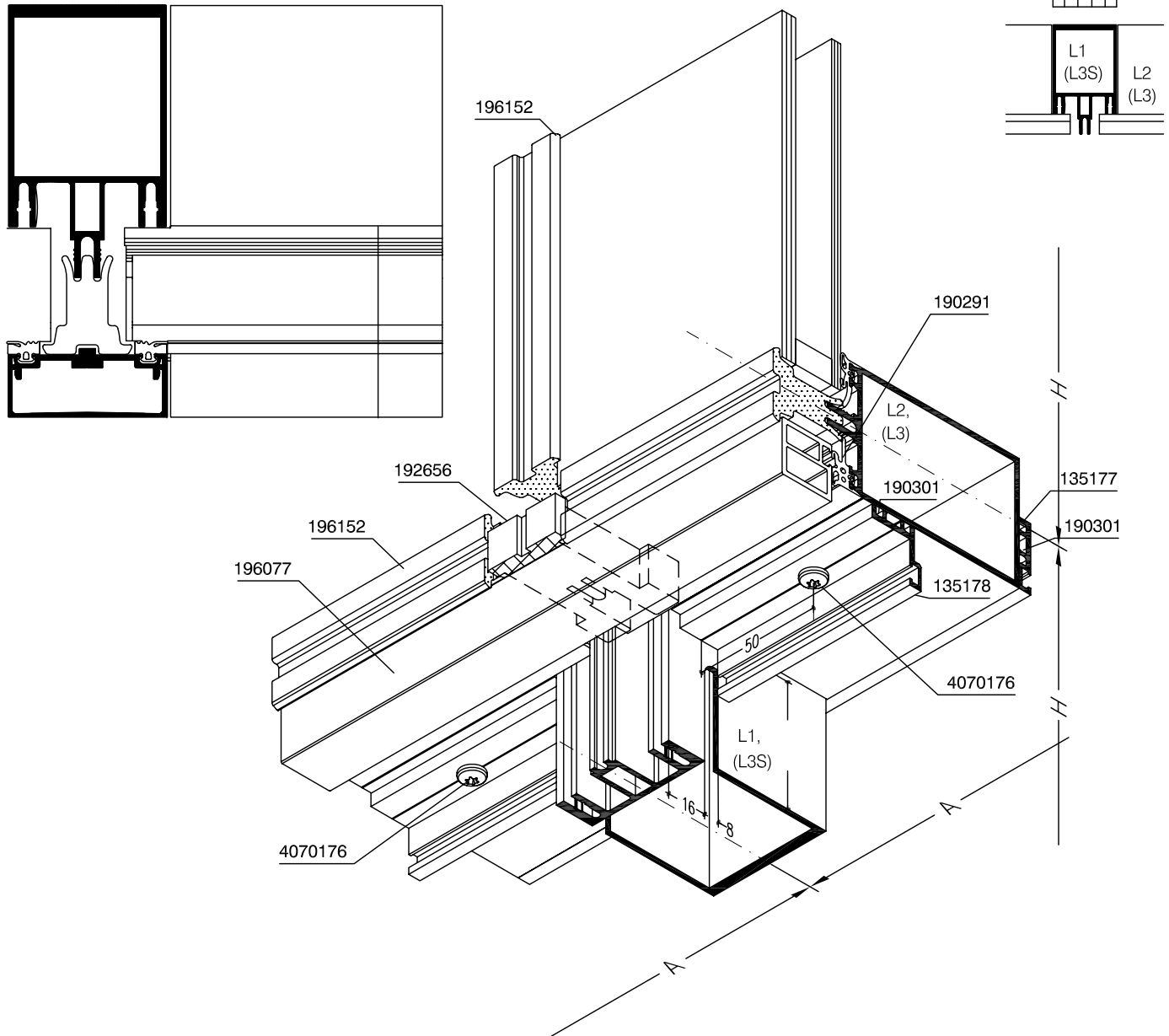
Punching tool:
5040044 ①



See chapter Cutting for cutting thermal break, pressure and cover profiles.

WICTEC 50HI

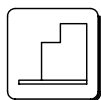
Stick construction
Base point



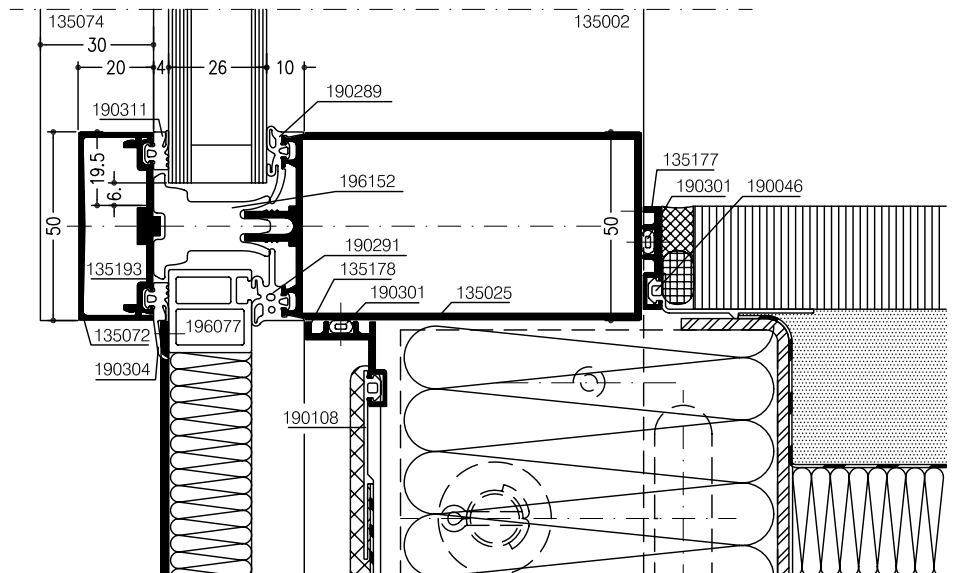
Use drainage parts
192656, 192657, 192658
also at mullion joint.



See Cutting list for cutting
gaskets and profile 196077



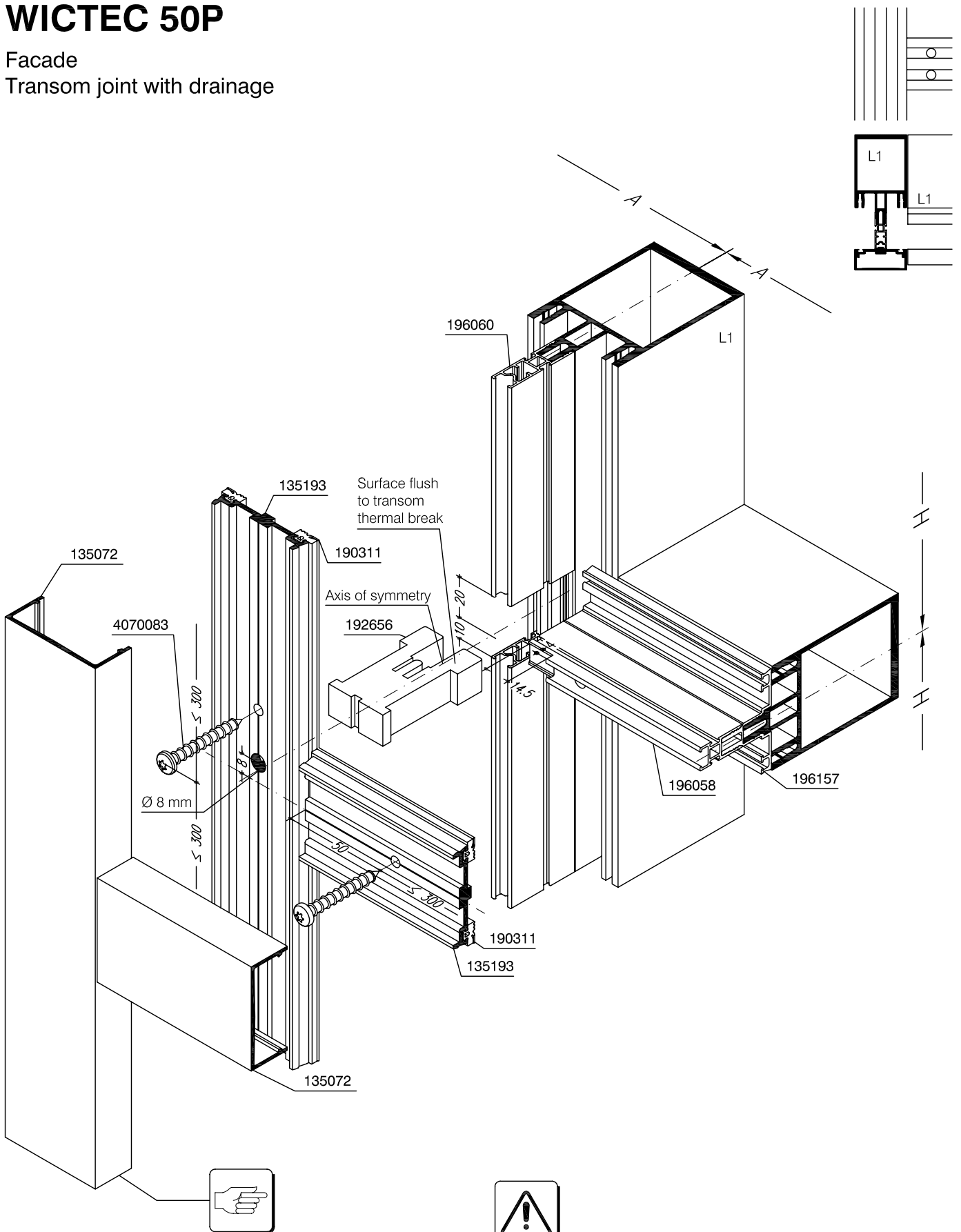
See chapter Transom cutting
for notching transom profile



WICTEC 50P

Facade

Transom joint with drainage



Cutting thermal break, pressure and cover profiles: see chapter Cutting



Use lever 5060057 (esco no. 92-108197) if necessary .



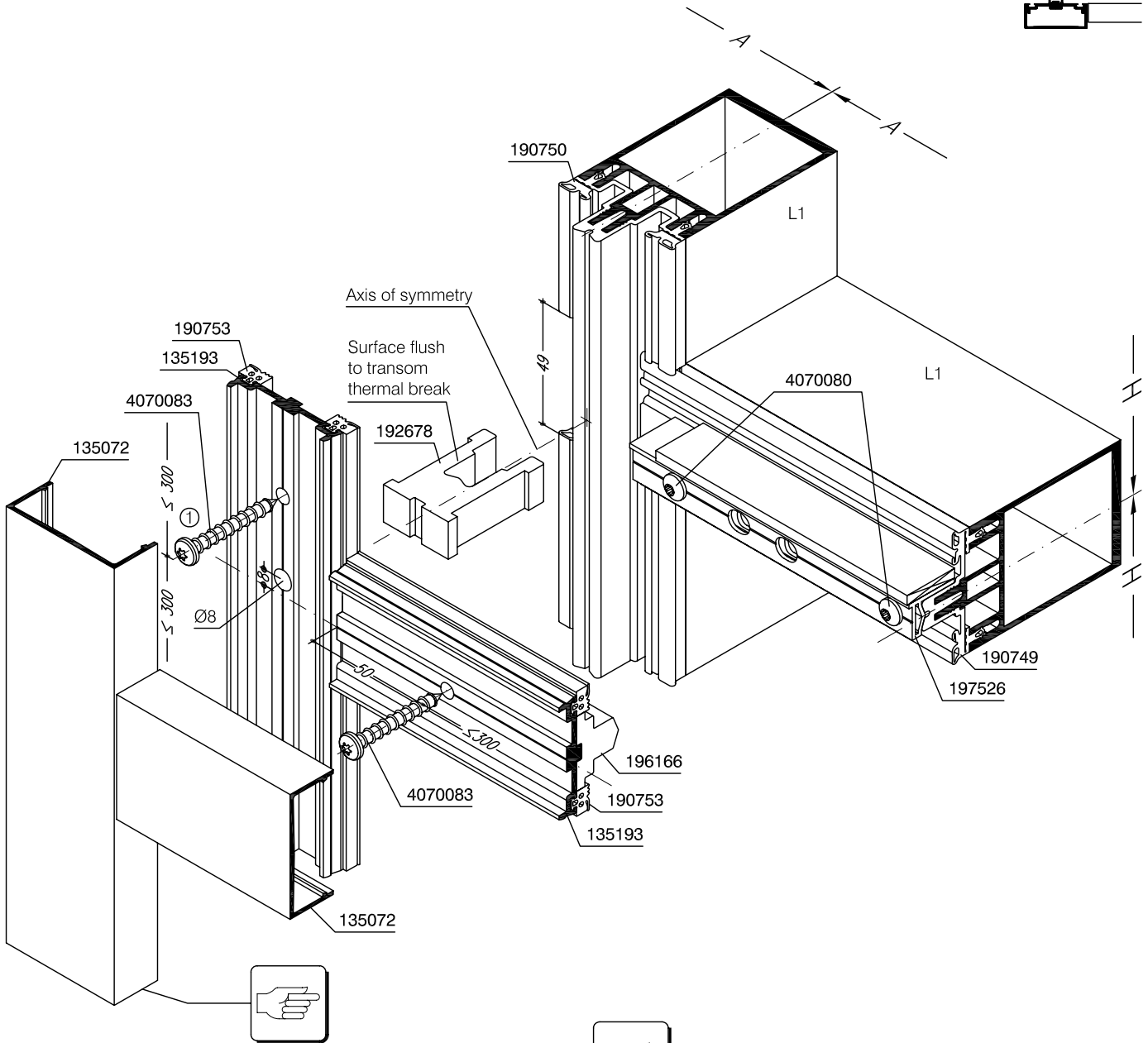
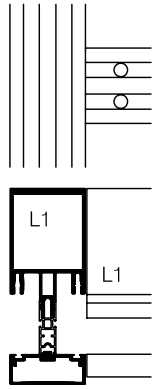
Attention:
Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm

WICTEC 50E

Facade

Transom joint with drainage

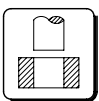


Use lever 5060057 (esco no. 92-108197) if necessary.



Attention:
Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm



Punching tool:
5040044 ①

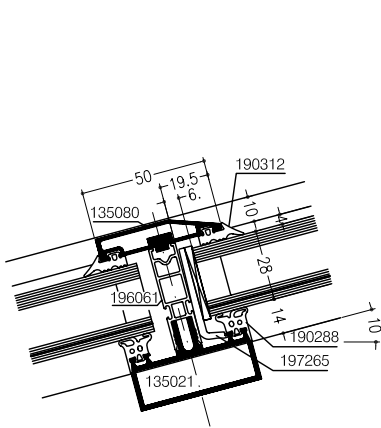


See chapter Cuttings for cutting thermal break, pressure profiles and cover profiles.

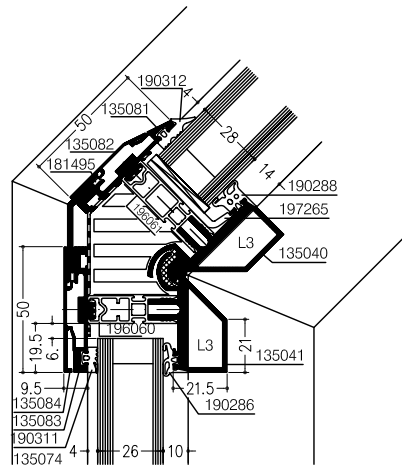
WICTEC 50

Stick construction
Additional openings in transom profile

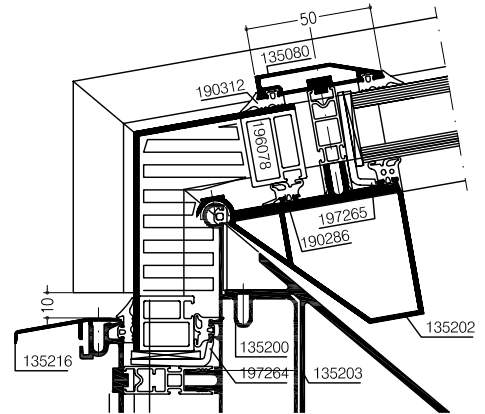
Air pressure equalization and drainage



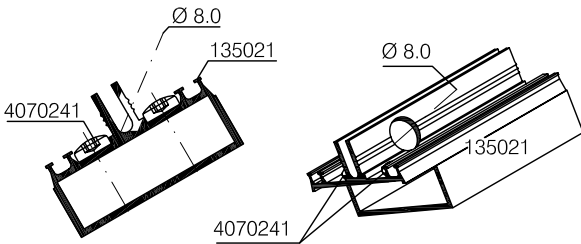
Cross transom in roof



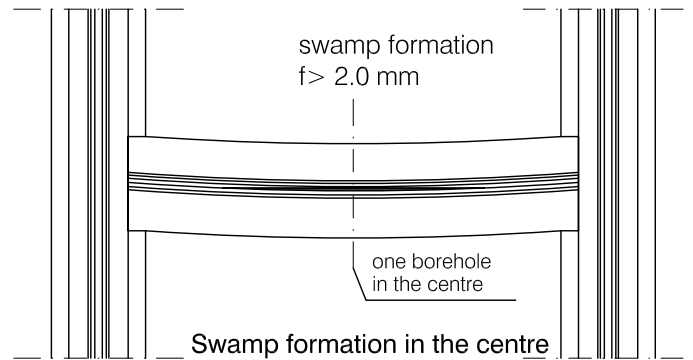
Eaves transom



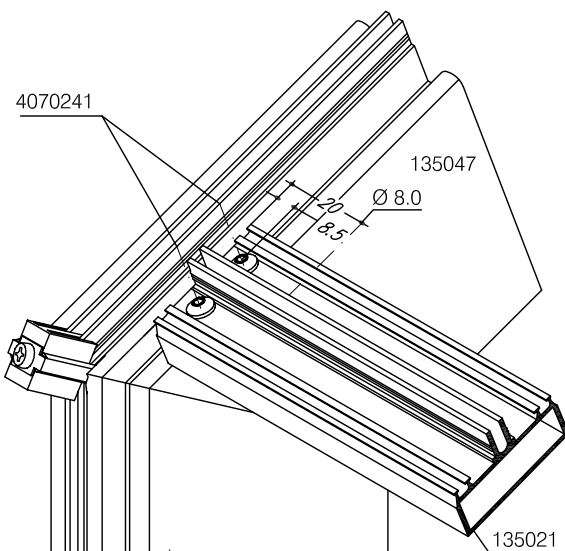
Eaves transom



Channel opening



Swamp formation in the centre

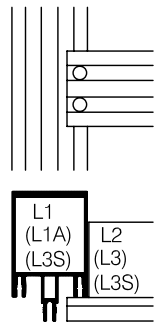


Supplementing the guidelines and arrangements of openings for air pressure equalization and drainage in glazing rebate, WICONA recommends additional drainage boreholes for slightly sloped transom profiles of spatial structures:

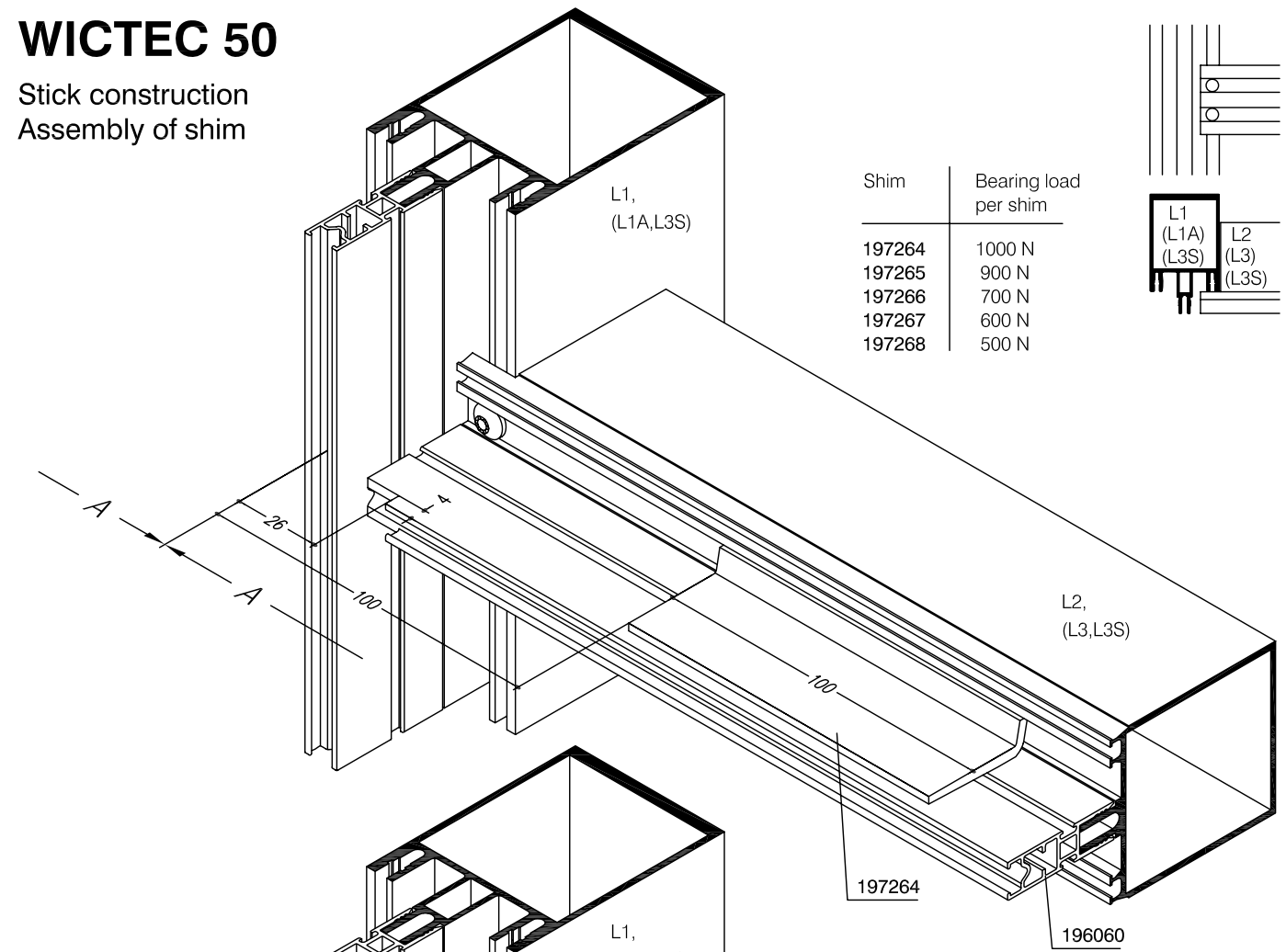
1. For vertical and horizontal positioned, slightly inclined transom profiles ($\alpha < 20^\circ$) additionally approx. 20 mm from transom profile beginning, in front of transom connecting screws and the first pressure profile screwing (approx. 50 mm from profile bar beginning) in top glazing rebate base a $\varnothing 8$ mm borehole for drainage in the transom screw channel is recommended.
2. Also for drainage of a possible swamp formation at the point of largest profile deflection > 2 mm due to shim load a $\varnothing 8$ mm borehole in screw channel from the top is recommended. The screw channel is occupied by pressure cover profile screws and cannot be used for drainage.

WICTEC 50

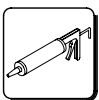
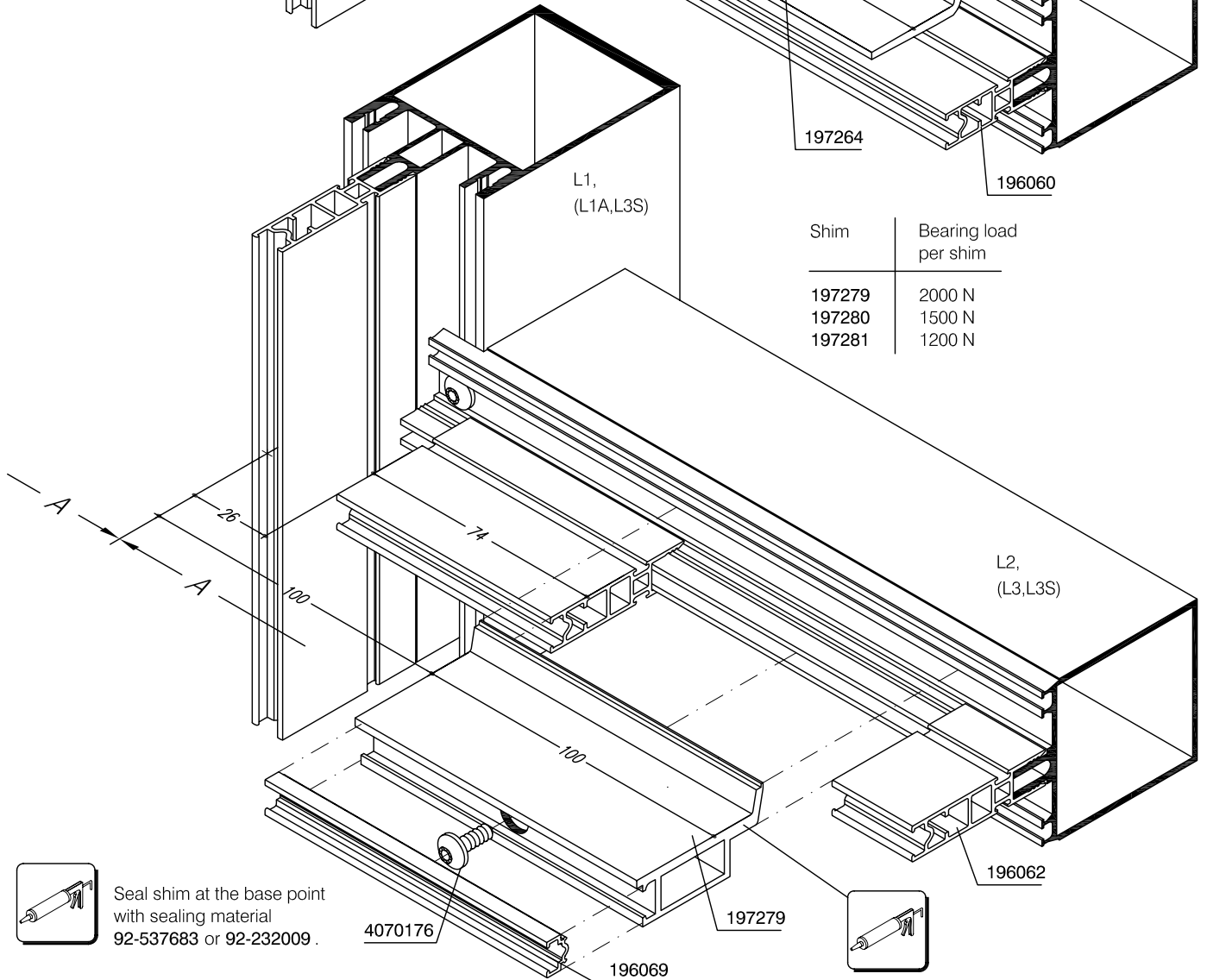
Stick construction
Assembly of shim



Shim	Bearing load per shim
197264	1000 N
197265	900 N
197266	700 N
197267	600 N
197268	500 N



Shim	Bearing load per shim
197279	2000 N
197280	1500 N
197281	1200 N



Seal shim at the base point with sealing material 92-537683 or 92-232009.

4070176

197279

196069

196062



Cutting thermal break profile: see chapter Cutting Thermal Break Profile.

WICTEC 50HI

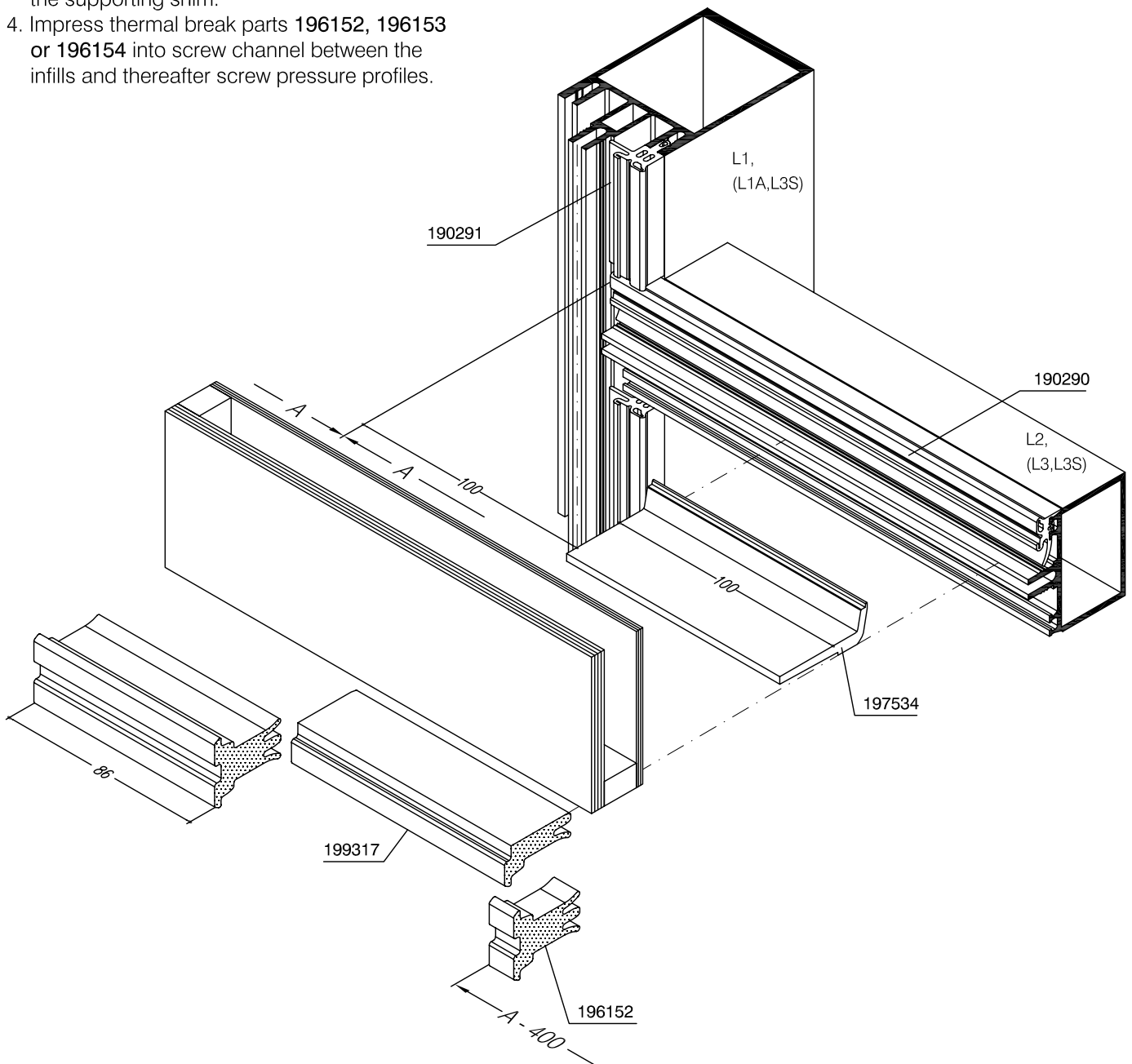
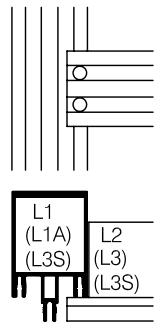
Stick construction

Assembly of shim and thermal break parts 196152, 196153, 196154

Mounting sequence:

1. Hook **197534** into transom profile.
2. Lay glazing shim on supporting shim **197534**, insert infill and secure with short pieces of pressure profile.
3. Impress **199317**, **199318** or **199319** under the supporting shim.
4. Impress thermal break parts **196152**, **196153** or **196154** into screw channel between the infills and thereafter screw pressure profiles.

Shim	Bearing load per shim
197534	1000 N
197535	900 N
197536	700 N
197279	2000 N
197398	2000 N



Pressure profile screwing:
 - Screw distance ≤ 300 mm,
 - from each profile bar beginning ≤ 50 mm,
 - Tightening torque of screw ≤ 500 Nm.

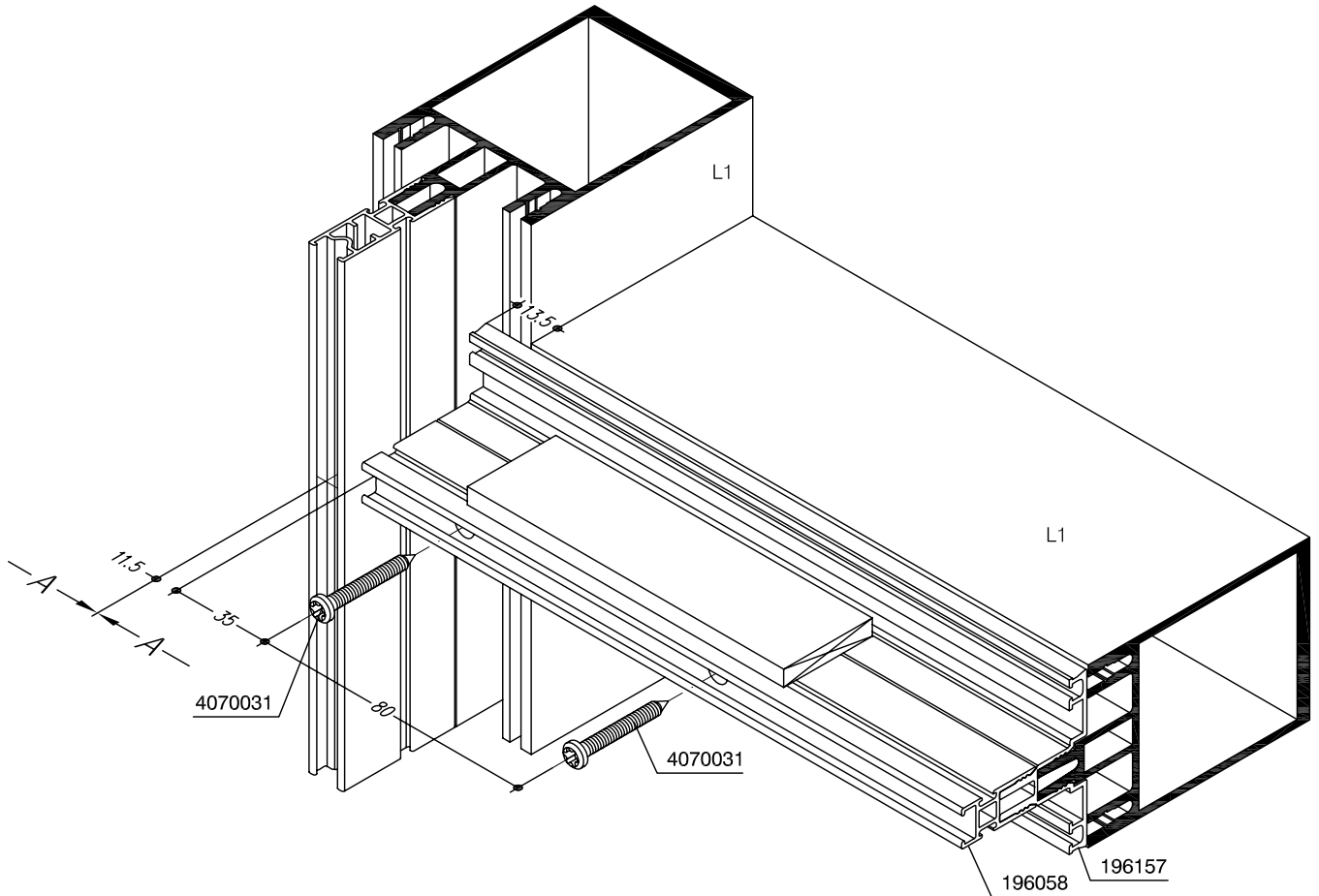
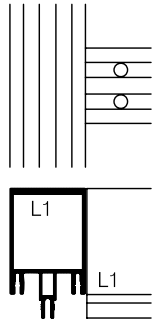


Cutting thermal break part:
 See chapter Thermal break cutting

WICTEC 50P

Facade

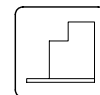
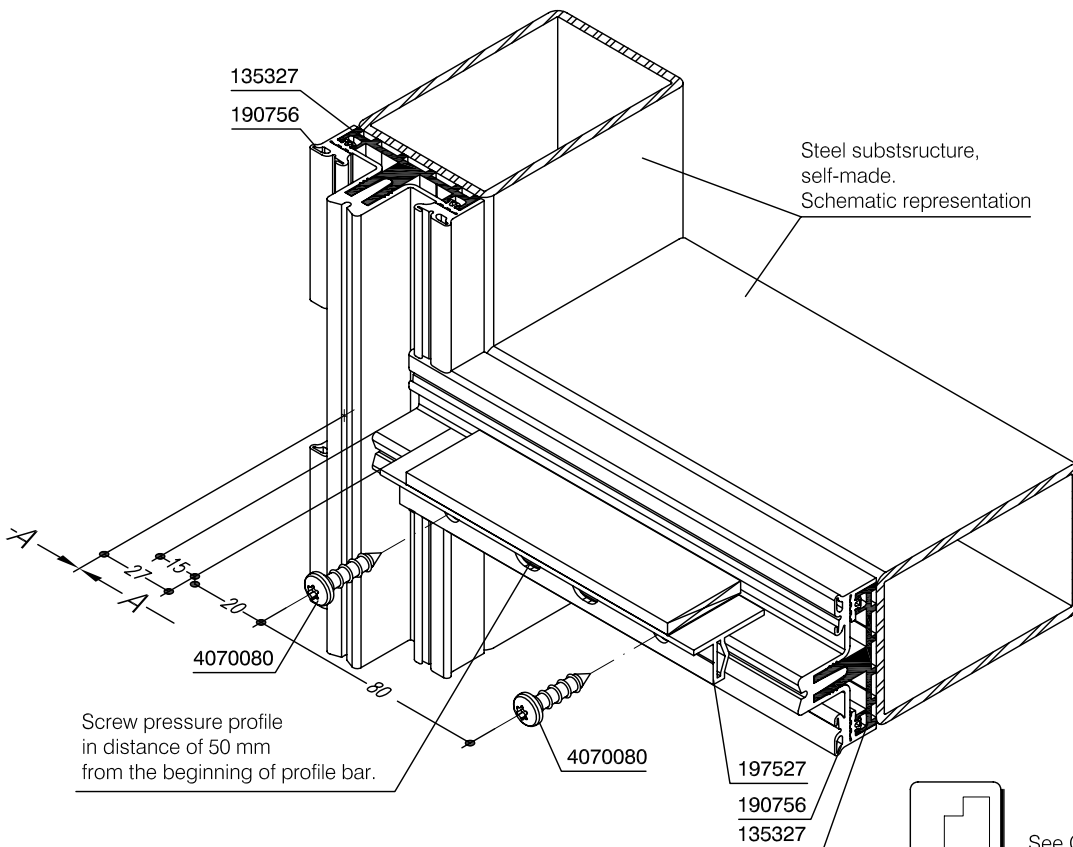
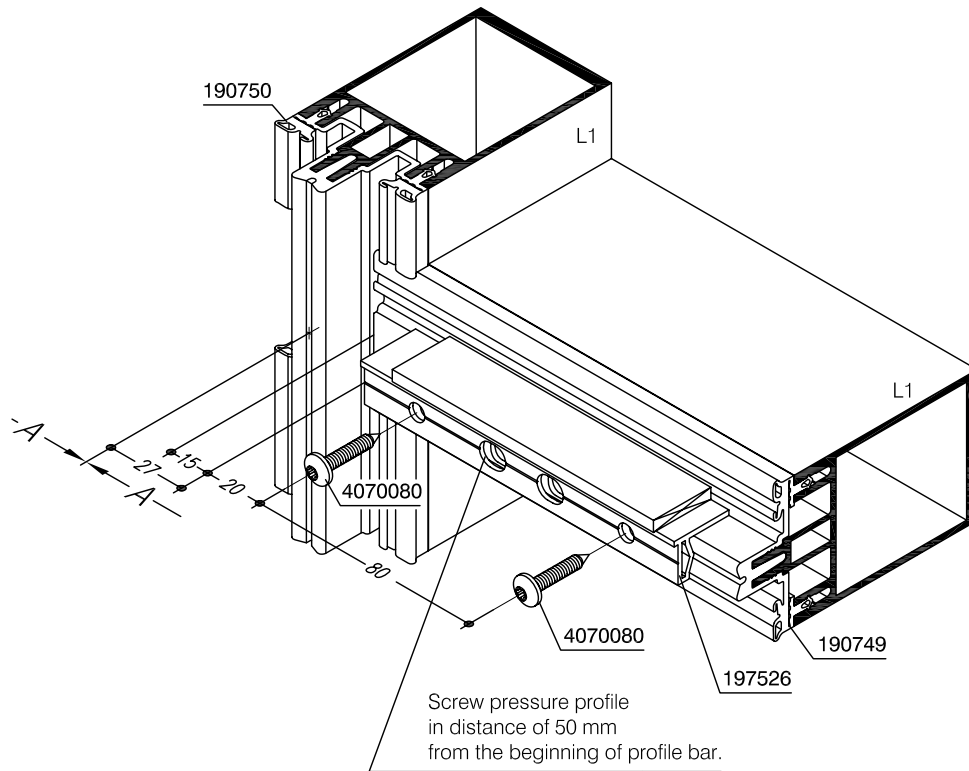
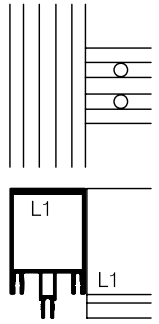
Installation of glass load bearing screw



Glass load bearing screw	Bearing load per shim
2 pieces	1000 N

WICTEC 50E/50A

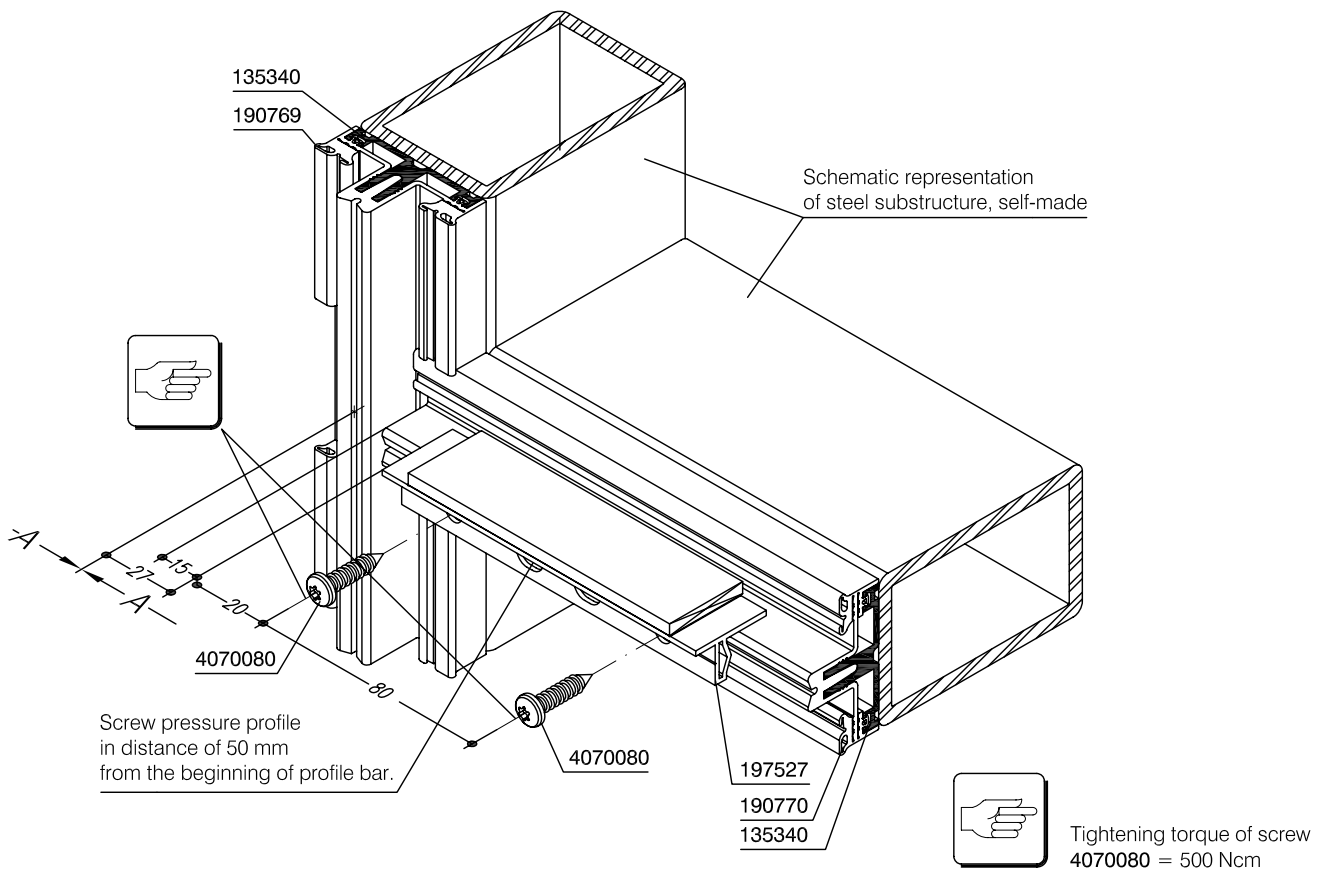
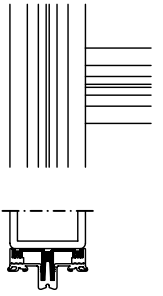
Facade
Assembly of shim



See Gasket Assembly for notching
gasket profile.

WICTEC 50A

Facade
Mounting glazing shim



WICTEC 50

Mounting glazing support (shim)

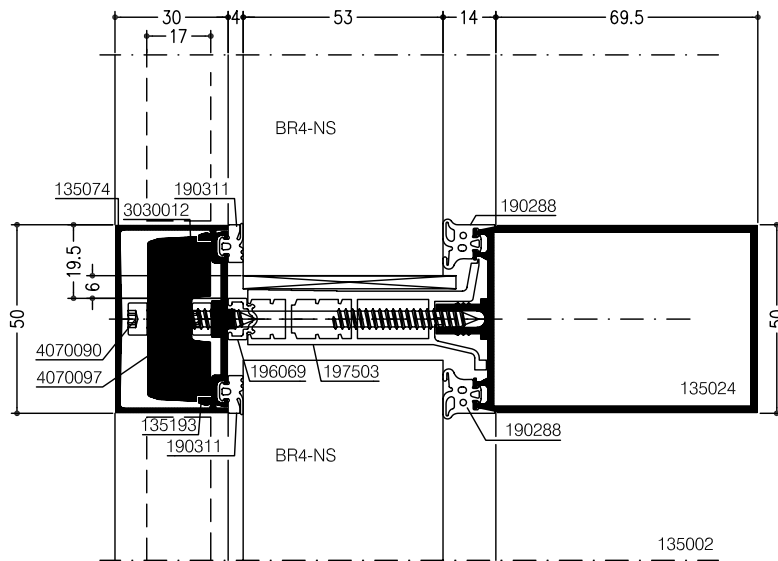
Stick construction

Bullet resistant according to DIN EN 1522

Resistance Class FB4



Transom cross-section



Bullet resistance measures:

- Back-feeding spacer shim (pressure resistant) in area of every pressure profile screwing with 0.5 mm clearance (gap) between glass pane and shim.



- Secure back-feeding against slipping with non-setting sealing compound.



- Screwing pressure profile:
 - Screw distance ≤ 300 mm
 - ≤ 50 mm from the beginning of profile bar.
 - Tightening torque of screw ≤ 500 Ncm

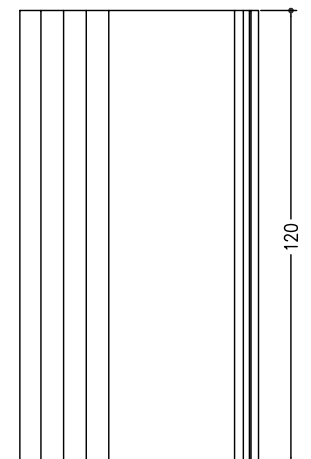
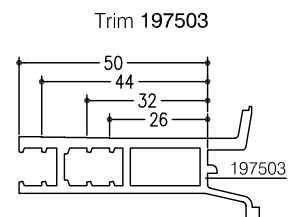
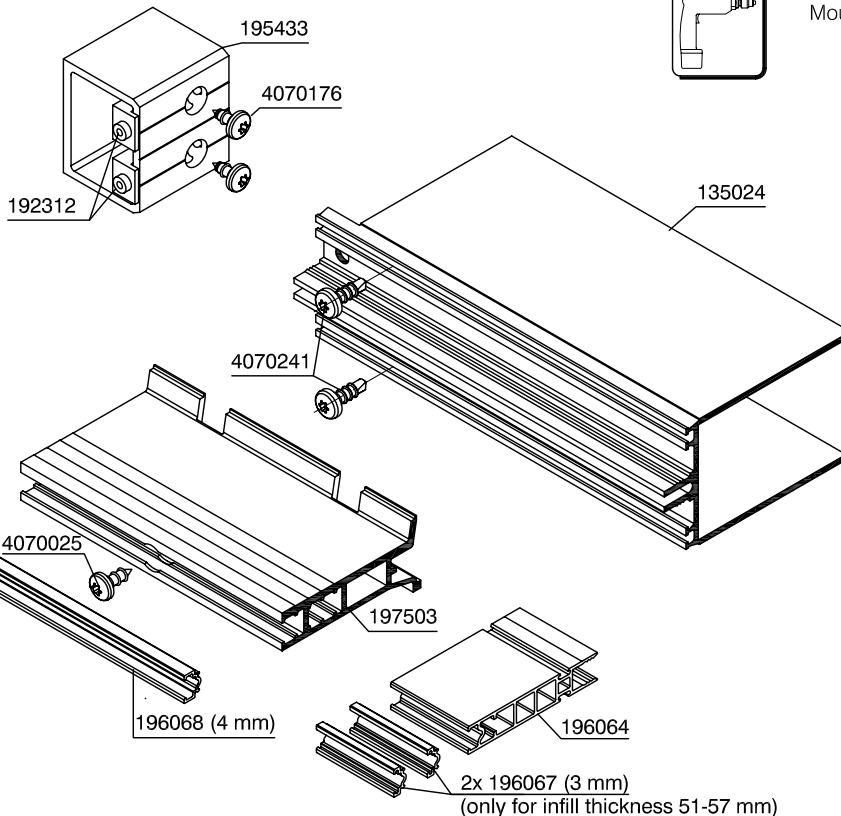


- Drill borehole for fixing glazing support. Mount insulation strips.



Note:

Fix transom always with two additional screws.
Screw 4070241, Sealing part 192312.



WICTEC 50

Stick construction

Gasket assembly, inside

1. Mullion-Transom joint

1.1 Cleaning aluminium profiles

Cleaning EPDM gaskets

The cut and contact surfaces as well as profile joints must be dust and grease-free. Degreasing agent according to specifications of adhesive or sealing material manufacturer. WICONA supplies suitable agent which is compatible to anodized or coated surfaces. We draw your attention to some commercial products available in the market which could attack the colour coated surfaces. Therefore, the compatibleness of cleaning agent should be tested on a coated specimen.

Recommendation of auxiliary means:

Aluminium untreated and anodized	Cleaner esco no. 92-537705
----------------------------------	--------------------------------------

Aluminium Powder lacquer Wet lacquer	esco no. 92-537705
---	---------------------------

Glass	esco no. 92-537691
-------	---------------------------

EPDM	esco no. 92-537705
------	---------------------------

1.2 Gluing

The cleaned cut and contact surfaces of EPDM-gaskets are smeared with appropriate adhesives and joined.

Recommendation of auxiliary means:



EPDM-glue:
esco no. 5070012

1.3 Sealing with non-setting sealing materials

The contact surfaces are to be prepared according to the sealing material product (make).
Use cleaning agent 92-537705 for sealant 92-537683.

Recommendation of auxiliary means:

Material	Cleaner	Sealant
EPDM	esco no. 92-537705	esco no. 92-537683
EPDM	without Primer	esco no. 92-232009

1.4 Gasket joints of WICTEC 50/WICTEC 60

- A Metre ware with butt-joint
- B Moulded gasket corner angle
- C Vulcanized gasket frame
- D Simplified gasket joint with bias cut
- E Simplified gasket joint with notched cut
- see following pages

General hints:

Variants D and E suitable specially for unfavourable climatic marginal conditions, e.g. rain, coldness (temperature under 5°C) if a sealing with silicone cannot be done.

Recommendation of auxiliary means:



Rolling tool:
5060058 (92-411310)

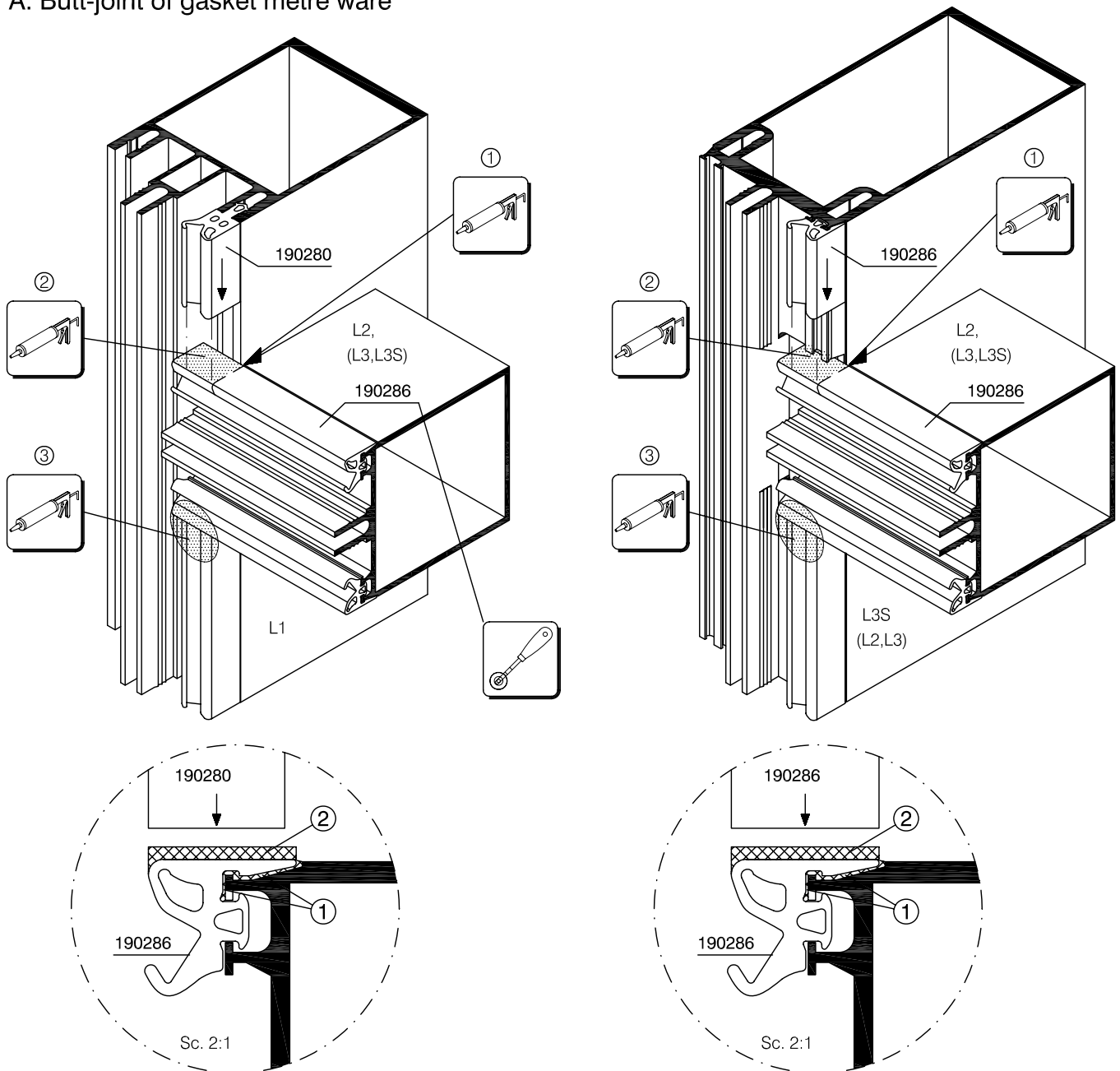


Apply cleaning agent **92-537705** and sealant esco no. **92-537683** or esco no. **92-232009** just before mounting glass.



Cutting gaskets:
see chapter Gasket Cutting.

A. Butt-joint of gasket metre ware

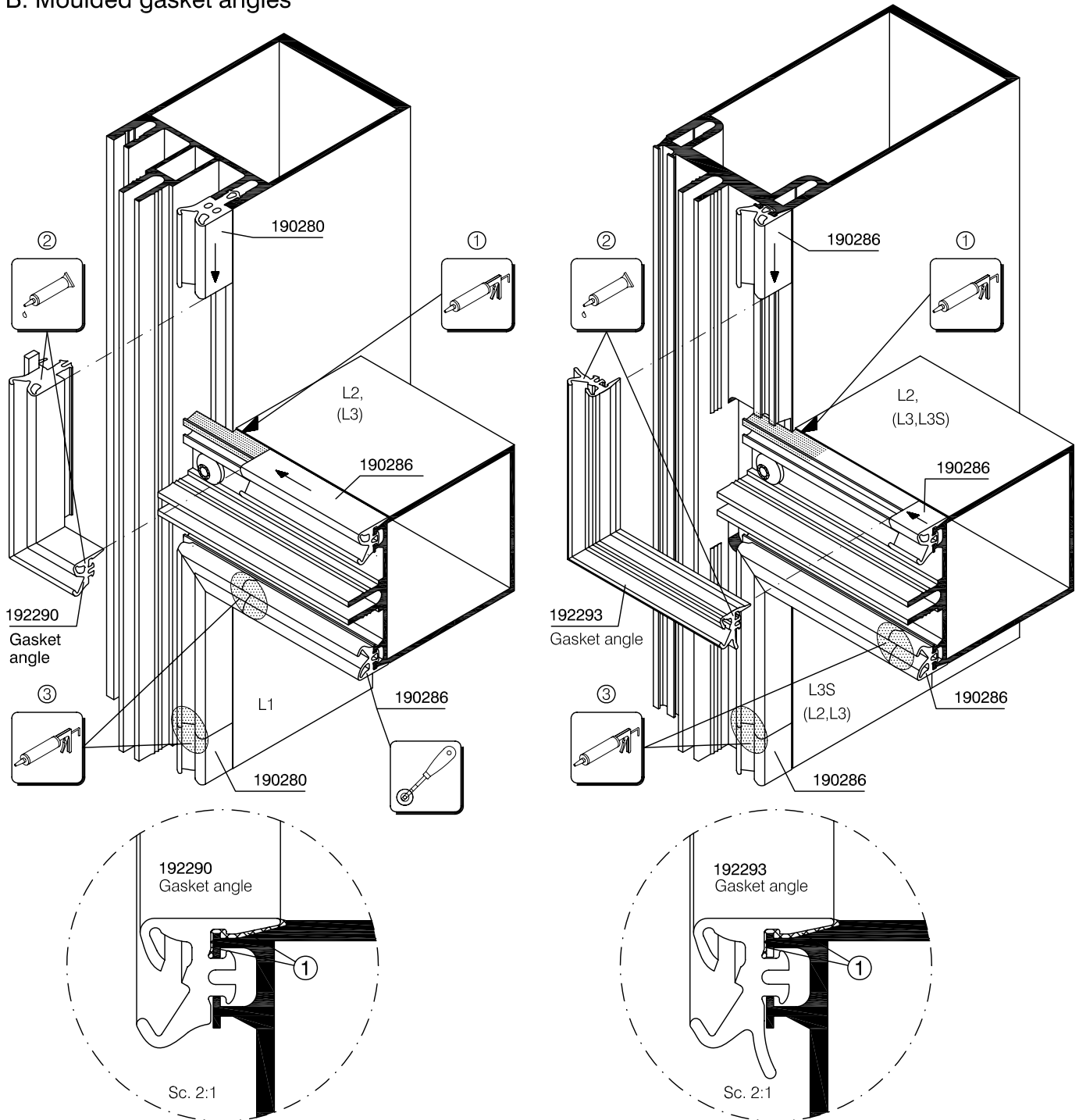


Processing sequence:

- Clean aluminium profiles and EPDM gaskets in mullion/transom joint area as described under 1.1 (page 280).
- Pretreat EPDM-gasket joint area with cleaning agent as described under 1.3 (page 280) while using sealing material esco no. **92-537683** or similar.
- ① Apply sealing material on transom profile under the gasket lip up to approx. 15 mm from the transom beginning.
 - Insert transom gasket in wet condition of sealing material and press gasket lip in the sealing material bed.
- ② Apply sealing material on transom gasket lip. Fill notched gap between mullion and transom profile with sealing material while using profiles of levels L2, L3, L3S. Press mullion gasket on transom gasket.
- ③ Apply sealing material just before infill assembly.

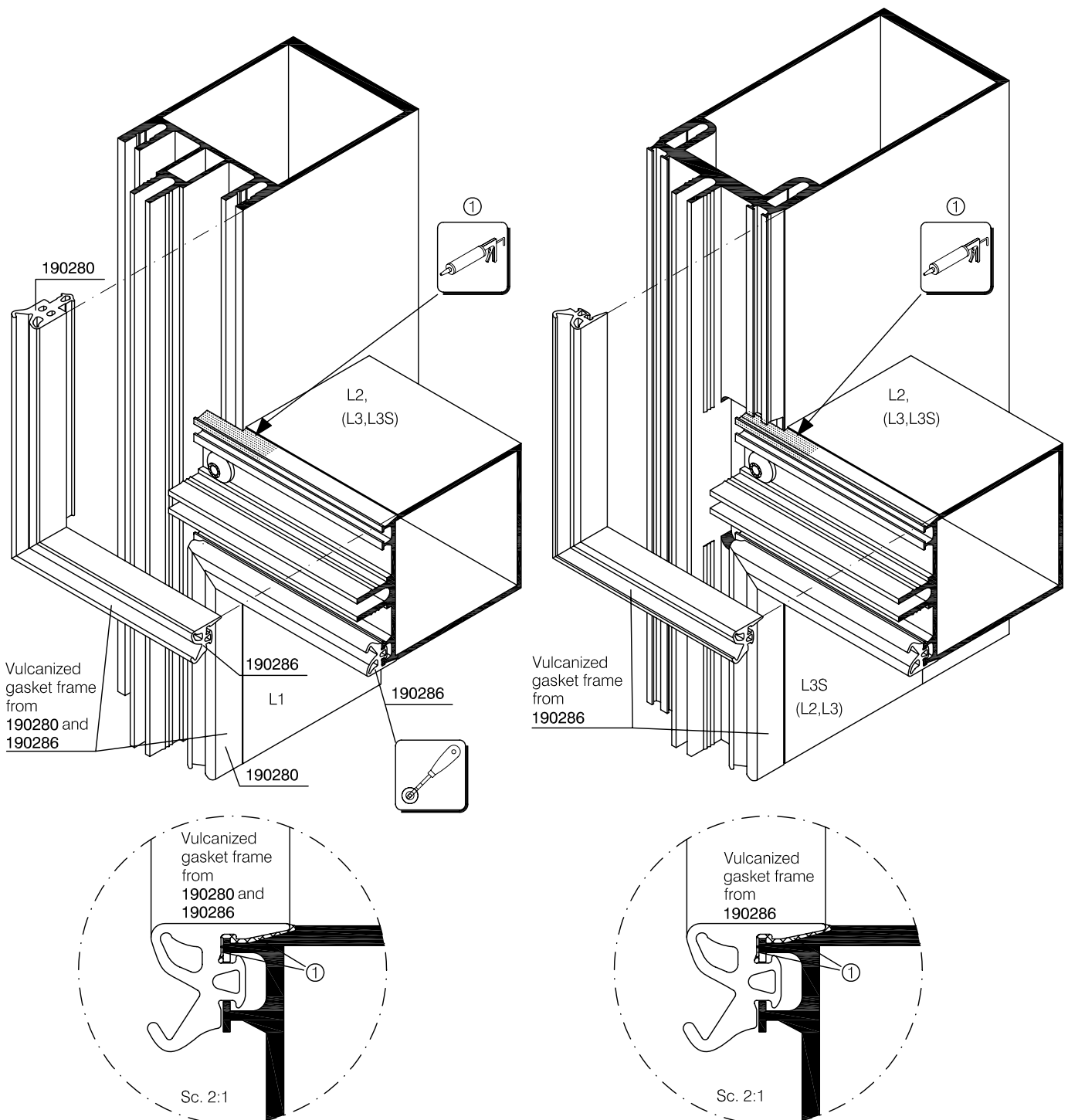
Stick construction

B. Moulded gasket angles



Processing sequence:

- Clean aluminium profiles and EPDM gaskets in mullion-transom joint area as described under 1.1.
- While using sealing material esco-no. **92-537683** and similar, pretreat EPDM-gasket joint areas with cleaning agent as described under 1.3.
- ① Apply sealing material on transom profile under the gasket angle lip up to approx. 30 mm from the transom beginning. While using profiles of levels L2, L3, L3S, fill the notched gap between mullion and transom profile with sealing material.
- Insert corner angle in wet condition of sealing material and press gasket angle lip in the sealing material bed.
- ② Smear the cleaned cut and face surfaces of gasket angle and EPDM-gaskets with appropriate adhesive and join together (see 1.2).
- ③ After appropriate pretreatment (see 1.3), apply sealing material just before infill assembly.



Processing sequence:

- Clean aluminium profiles and gaskets in mullion-transom joint area as described under 1.1.
- While using sealing material esco-no. 92-537683 and similar, pretreat EPDM-gasket joint areas with cleaning agent as described under 1.3.
- ① Apply sealing material on transom profile under the vulcanized gasket frame lip up to approx. 30 mm from the transom beginning. While using profiles of levels L2, L3, L3S, fill the notched gap between mullion and transom with sealing material.
- Insert vulcanized gasket frame in wet condition of sealing material and press gasket frame lip in the sealing material bed.

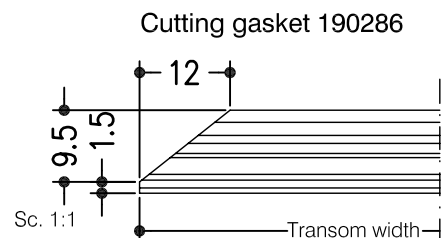
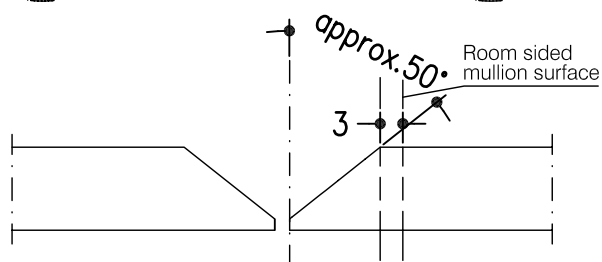
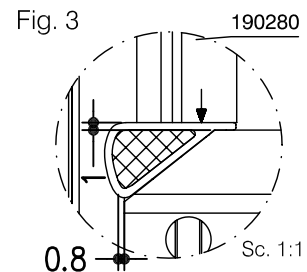
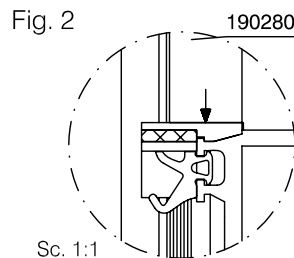
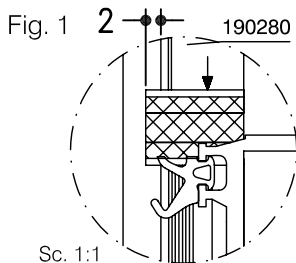
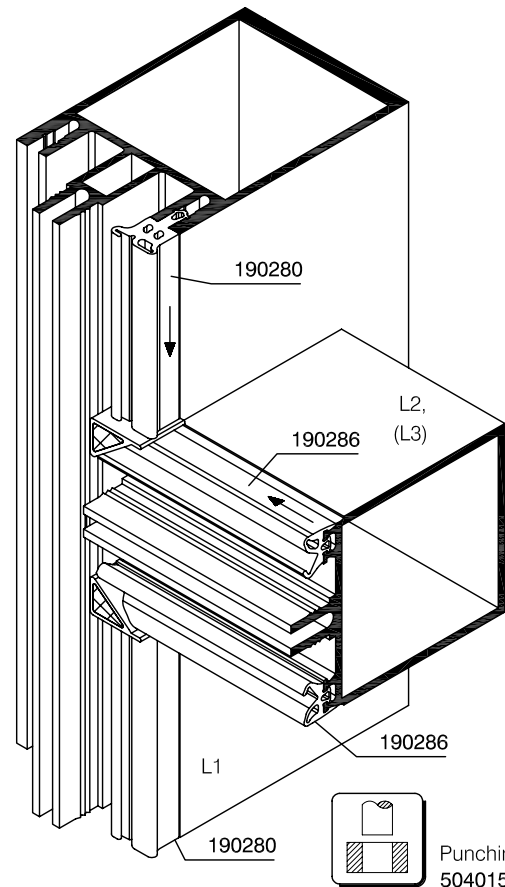
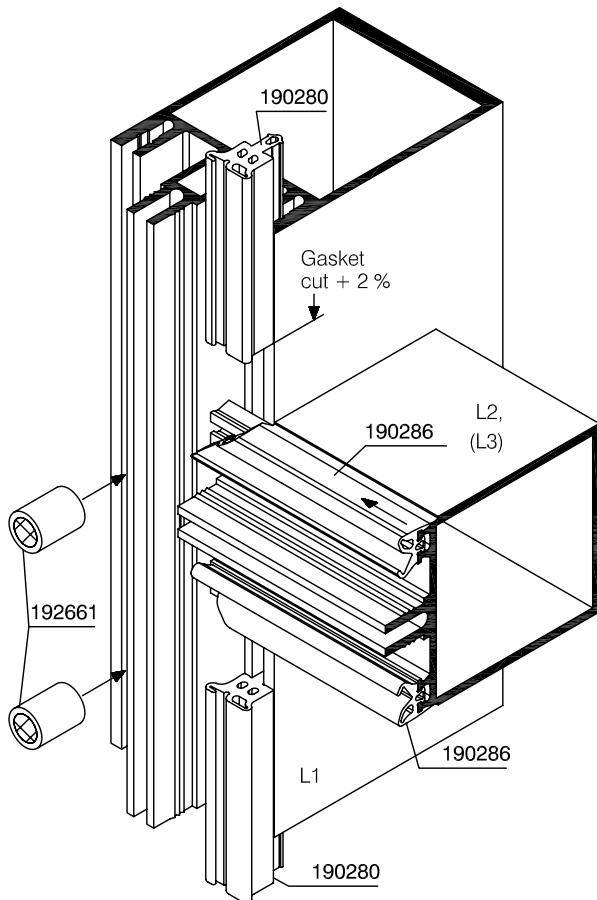
WICTEC 50

Gasket assembly, inside

Stick construction

D. Simplified gasket joint with bias cut

Cutting with punching tool 5040150



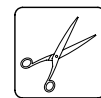
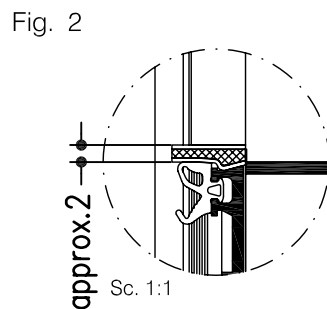
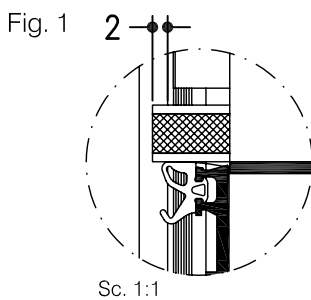
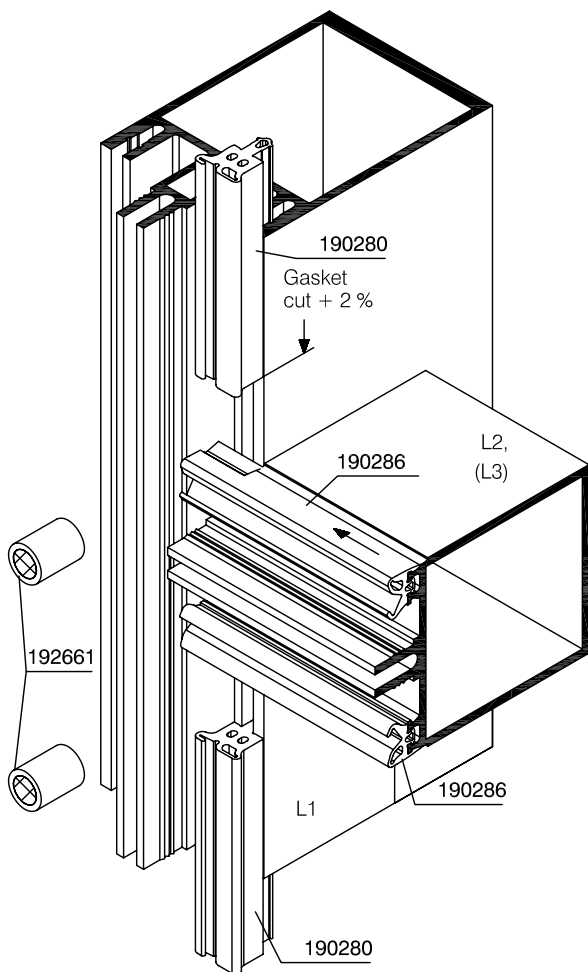
Processing sequence:

1. Clean aluminium profiles and gaskets in mullion-transom joint area as described under 1.1.
2. Mount the cut transom gasket 190286 (or 190287/190288), with the top bevelled cut edge approx. 3 mm behind the room sided mullion surface, staggered in rebate direction.
3. Lay approx. 10-20 cm long cut short pieces from the sealing cord 192661 frontally to mullion rebate edge in the level of transom joint edge and the bevelled gasket cut (Fig. 1).
4. Mount mullion gasket 190280 (or 190281/190282) cut up to 2% oversize and press against sealing cord 192661 until it fills up the bevelled cut of transom gasket (Fig.3).
5. Cut out rebate sided sealing cord 192661 protruding 2 mm (Fig.1).
6. Cut out the protruding stowed sealing cord at the room sided visible joint with a sharp knife when required.

Stick construction

E. Simplified gasket joint with notched cut

Cutting gaskets with gasket cutter 5060084



Cutting gaskets
5060084

Processing sequence:

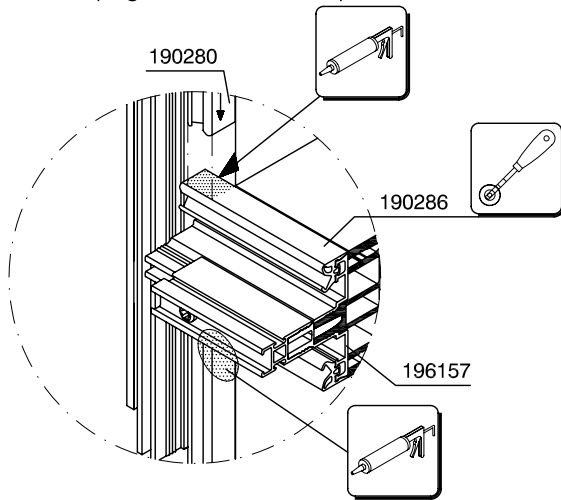
1. Clean aluminium profiles and gaskets in mullion-transom joint area as described under 1.1
2. Cut transom gasket 190286 (or 190287/190288) with gasket cutter 5060084 to the required length and carry out simultaneously notched cut.
3. Mount transom gasket flush to transom.
4. Cut approx. 10-20 cm long short pieces of 192661 and lay on the notched cut of gasket frontally to mullion rebate edge.
5. Mount mullion gasket 190280 (or 190287/190288) cut up to 2% oversize and press against sealing cord 192661 until the notched cut is covered and filled (Fig.2), stowed condition approx. 2 mm.
6. Cut out rebate sided sealing cord 192661 protruding 2 mm (Fig. 1).
7. Cut out protruding stowed sealing cord at the room sided visible joint with a sharp knife when required.

WICTEC 50P

Facade

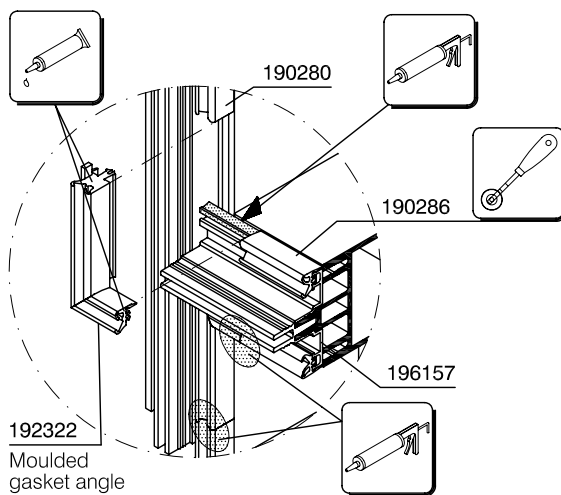
A. Butt-joint of gasket metre ware

see page 281 of Workshop Manual



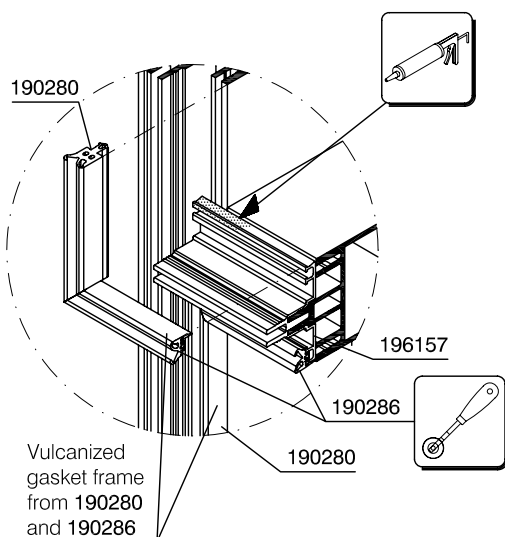
B. Moulded gasket angle

see page 282 of Workshop Manual



C. Vulcanized gasket frame

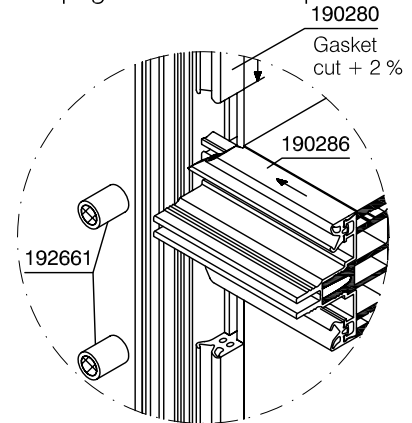
see page 283 of Workshop Manual



Gasket assembly, inside

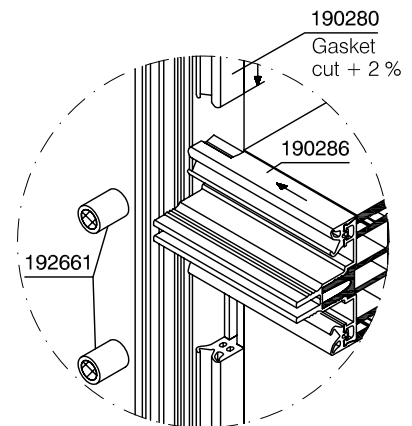
D. Simplified gasket joint with bias cut

see page 284 of Workshop Manual



E. Simplified gasket joint with notched cut

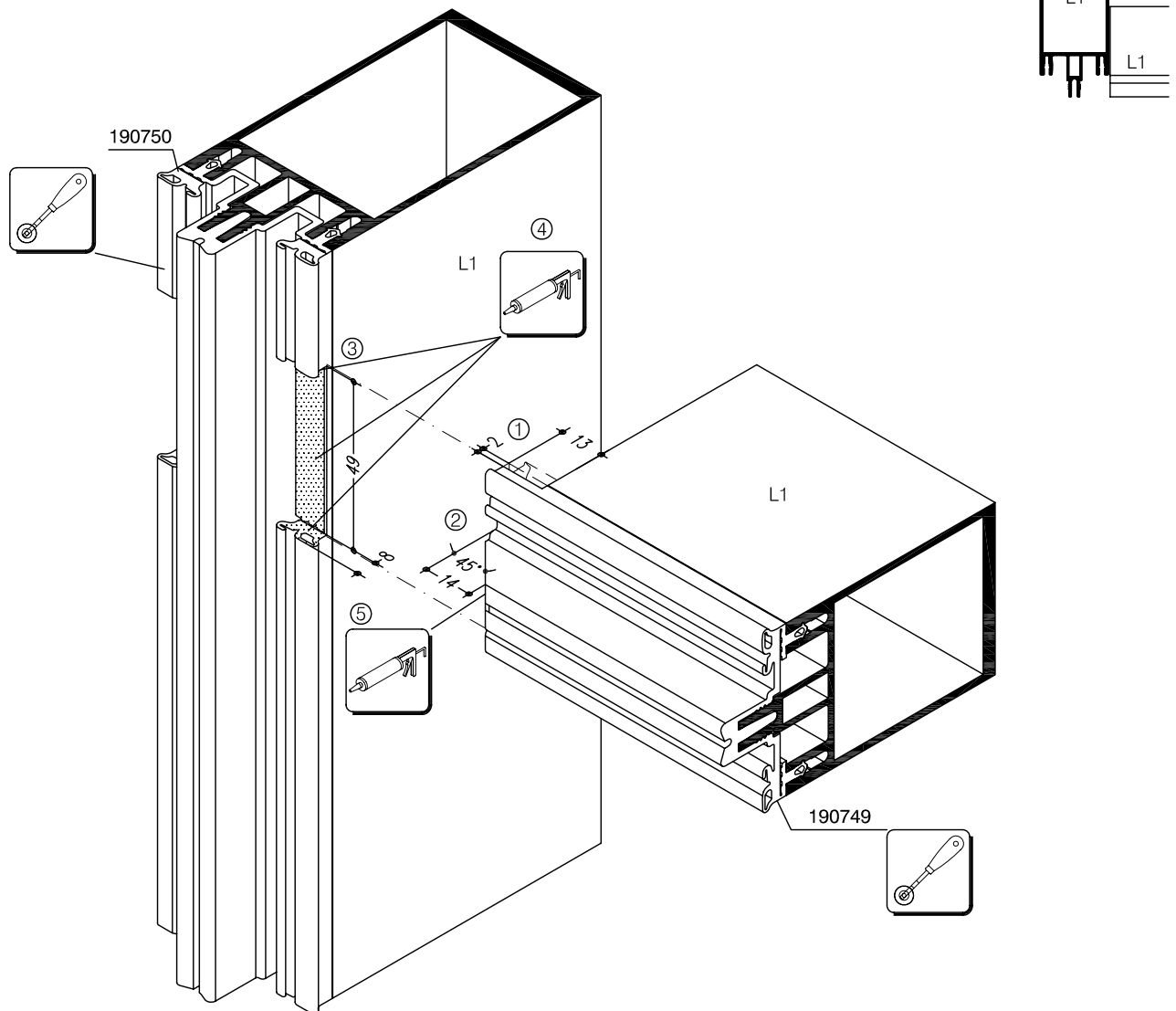
see page 285 of Workshop Manual



WICTEC 50E

Facade

A. Notched metre ware gasket

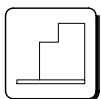


Processing sequence:

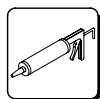
- Clean aluminium profiles and EPDM gaskets in mullion/transom joint area as described under 1.1 (page 280).
- Pretreat EPDM-gasket joint area with cleaning agent as described under 1.3 (page 280) while using sealing material esco no. **92-537683** or similar.

- ① Cut to length and notch transom gasket **190749** with cutting die **5060214**.
- ② Notch 14 mm x 45°.
- ③ Cut mullion gasket **190750** to length with cutting die **5060214** and notch with notching tool **5040160**.
- ④ Seal notchings in mullion gasket all around with sealing material.
- ⑤ Seal notching.

- Seal just before mounting infills.



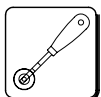
Notching tool:
5060214 ①
5040160 ③



Seal transom gasket **190749**
on mullion gasket **190750**
with sealing material.



Note:
See WICTEC 50P/50E Workshop Manual
for connector assembly
"Transom joint with connector"



Rolling tool:
5060215

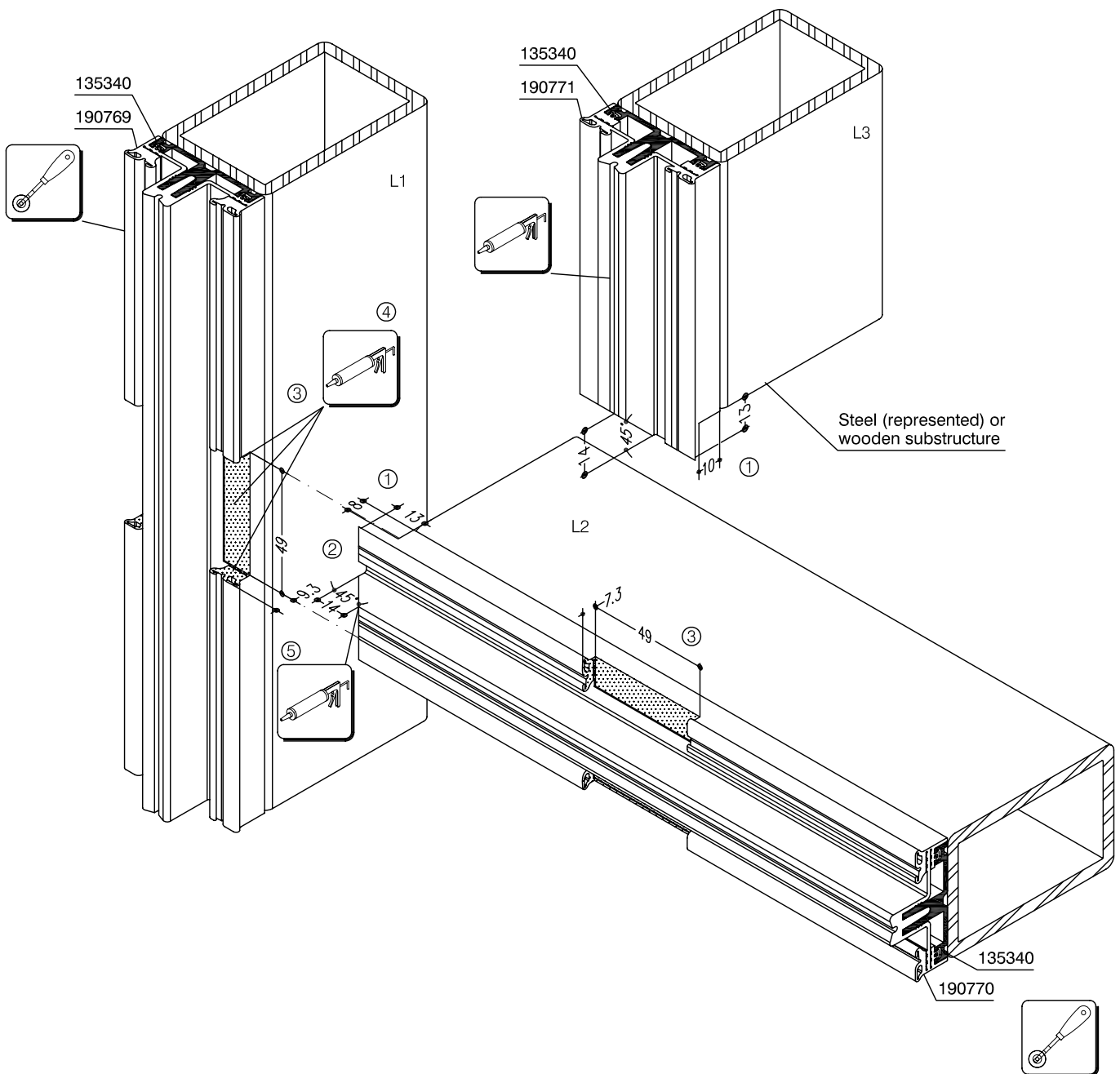
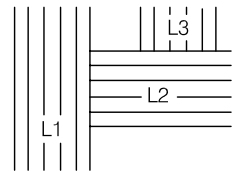


Cutting die:
5060214 ①

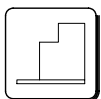
WICTEC 50A

Facade

Notched gasket metre ware



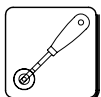
Note: Apply sealant prior to installation of infills



Notching tool:
5060086 ①
5040167 ③



Pretreat with primer. ④ ⑤



Rolling tool:
5060215

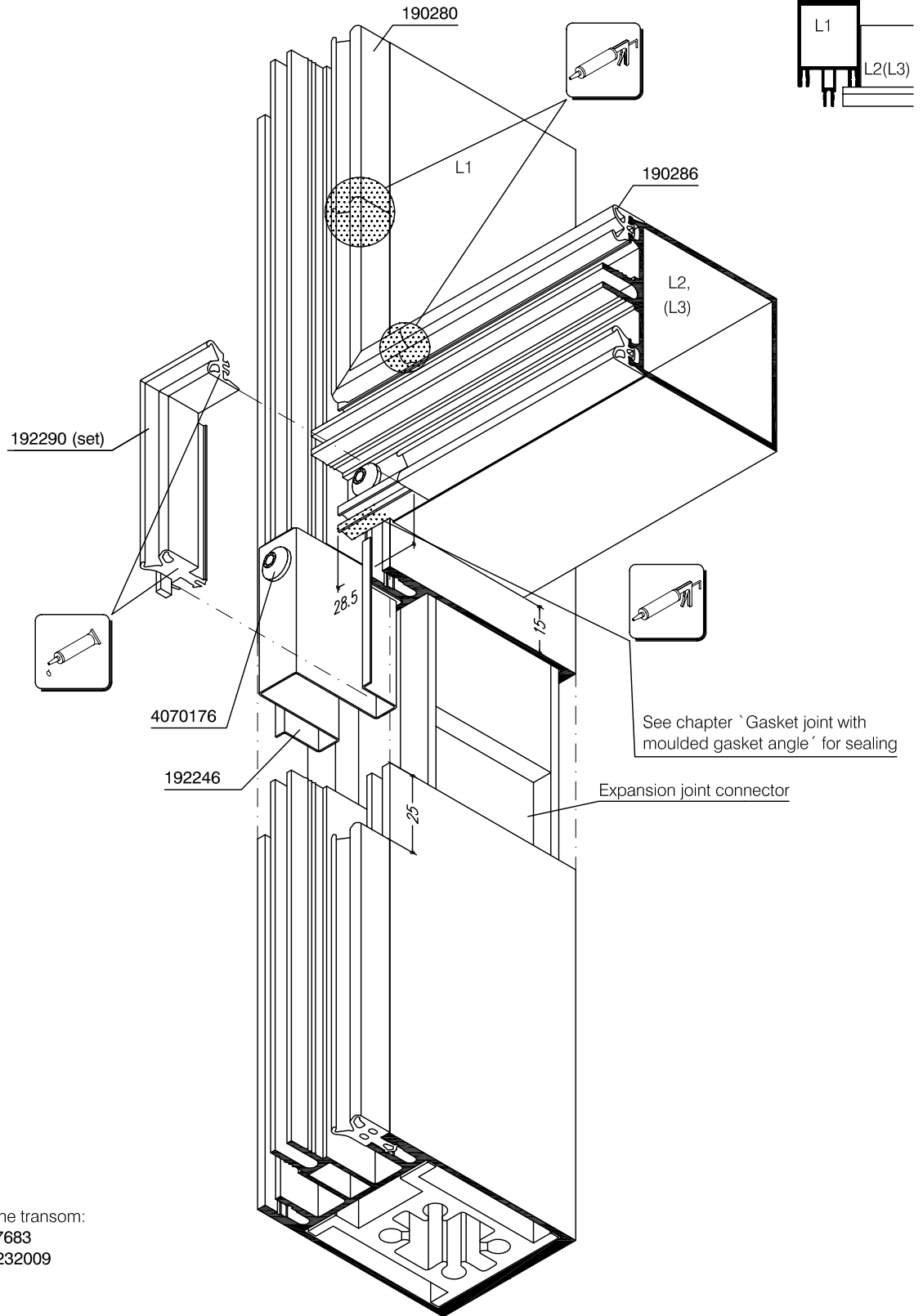


Cutting die (matrix):
5060086 ①

WICTEC 50

Stick construction

Assembly of gasket angle at mullion expansion joint



Seal gasket to the transom:
esco no. 92-537683
or esco no. 92-232009



Gasket adhesive:
5070012

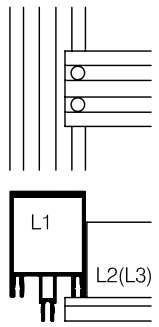


Cutting gaskets:
see chapter Gasket Cutting.

WICTEC 50

Stick construction

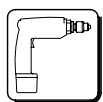
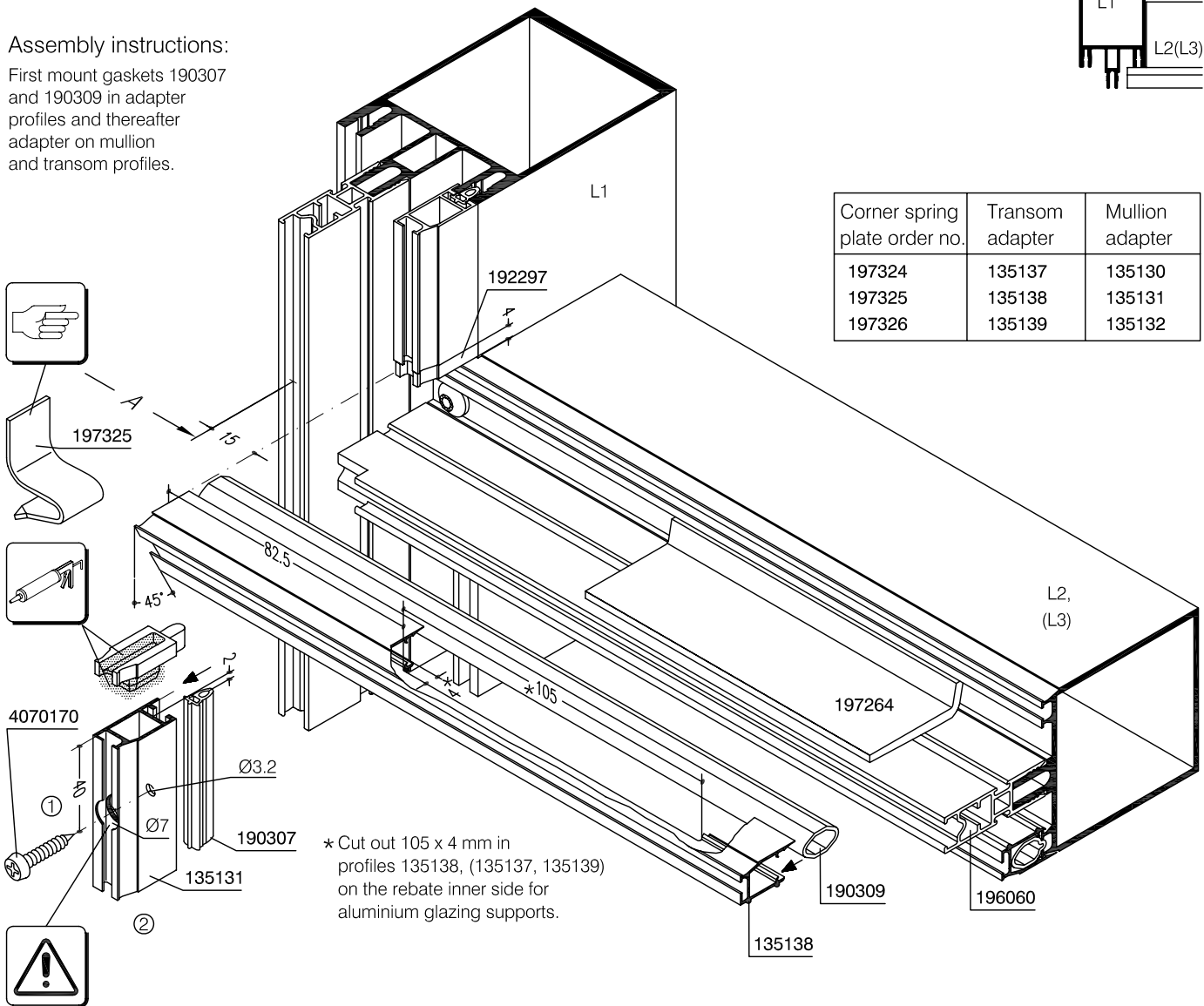
Assembly of adapter profiles 135131 and 135138 with sleeve 192297 and corner spring plate 197325



Assembly instructions:

First mount gaskets 190307 and 190309 in adapter profiles and thereafter adapter on mullion and transom profiles.

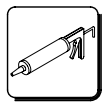
Corner spring plate order no.	Transom adapter	Mullion adapter
197324	135137	135130
197325	135138	135131
197326	135139	135132



drill template:
5010375 (esco no. 91-436666) ①
Step drill:
5060007 (esco no. 92-446181)



A third borehole is necessary in the rebate centre of bottom glazing rebate above 2 m axis dimension. ②



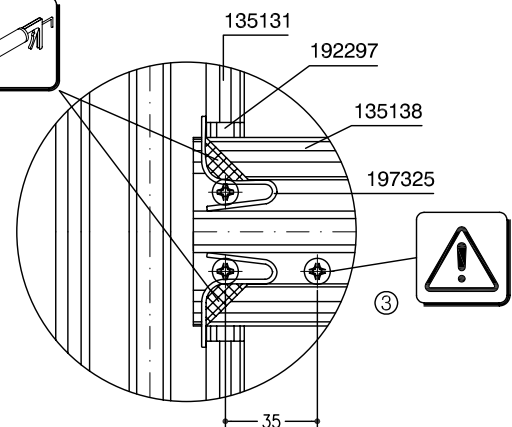
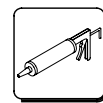
Apply cleaning agent 92-537705 and esco no. 92-537683 or 92-232009 to adapter sleeve at the top and bottom.



Cutting thermal break profile:
see chapter Cutting Thermal Break Profile



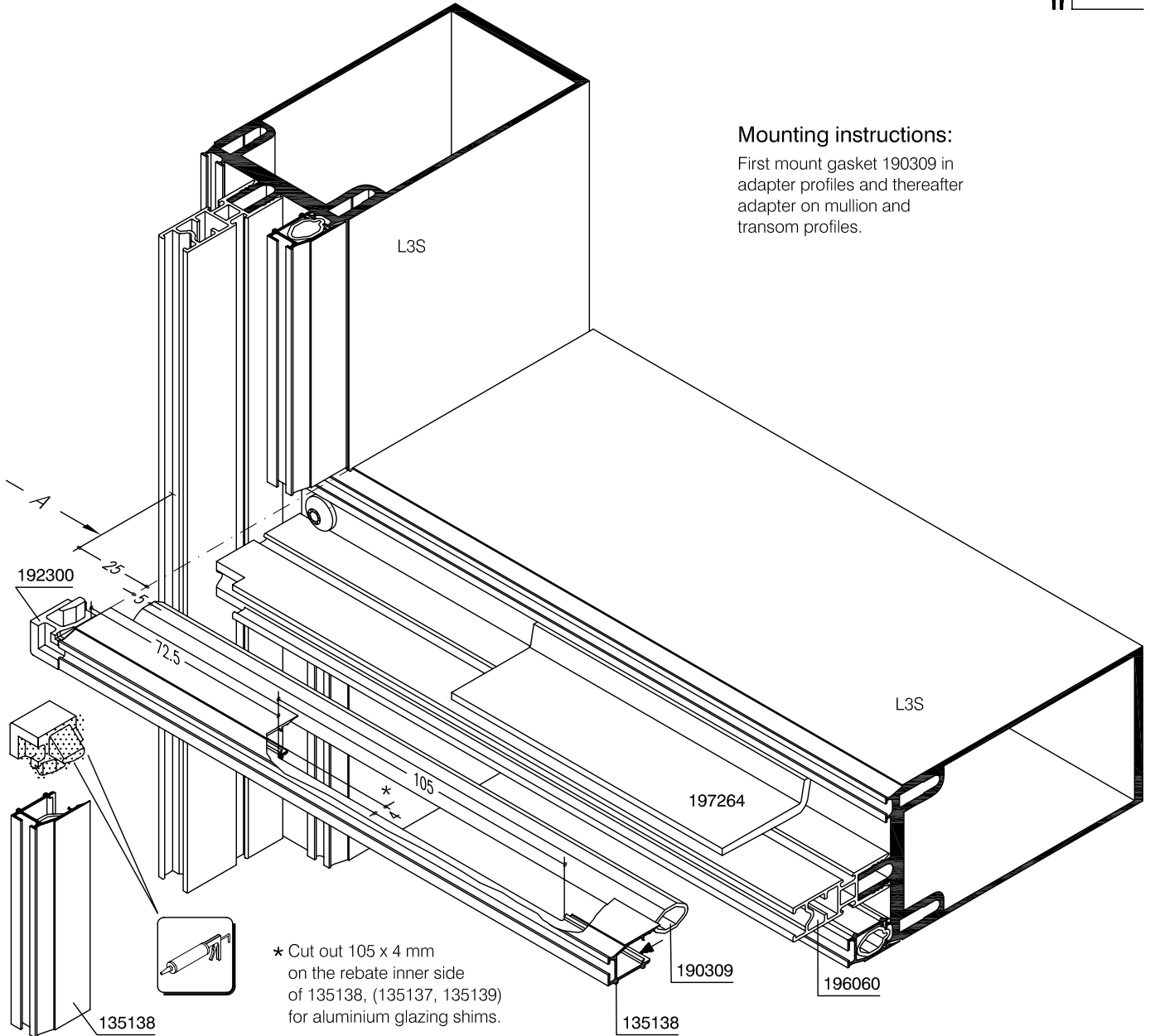
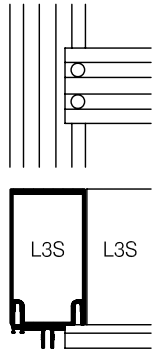
Insert corner spring plate 197325 into snapped adapter profiles and fill with sealing material 92-537683 or 92-232009



Notch adapter profile for application of connectors 195433 - 195438 ③

WICTEC 50

Stick construction
 Mounting adapter profile 192300
 with sleeve 192300



Mounting instructions:

First mount gasket 190309 in adapter profiles and thereafter adapter on mullion and transom profiles.

* Cut out 105 x 4 mm on the rebate inner side of 135138, (135137, 135139) for aluminium glazing shims.



Pretreat gasket groove with cleaner 92-537705 and apply sealant esco no. 92-537683 or esco no. 92-232009 on adapter sleeve.



Cutting thermal break profile: see chapter Cutting thermal break profile.

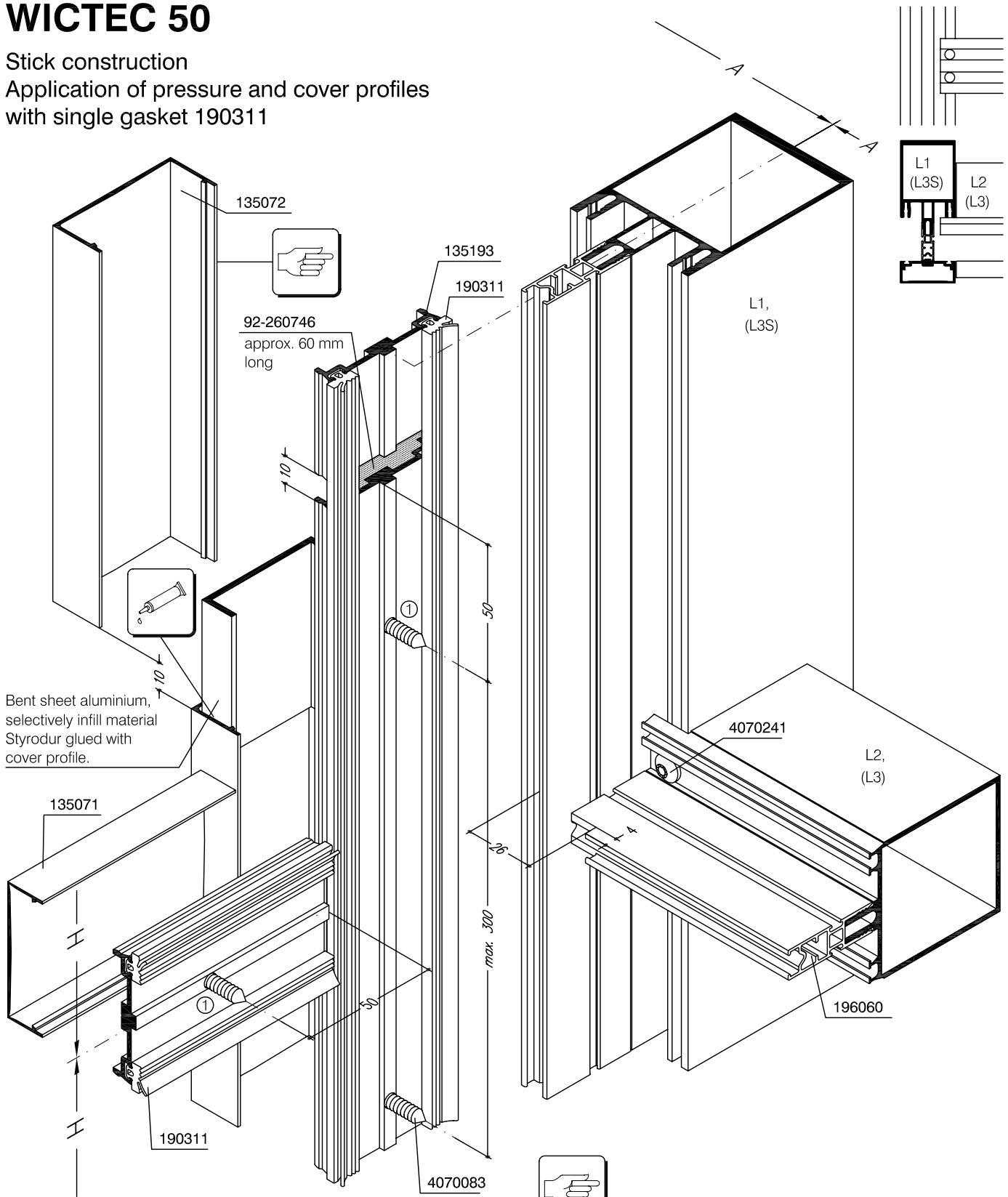


Insert sealing part (adapter sleeve) 192300 into the snapped adapter profile.

WICTEC 50

Stick construction

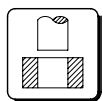
Application of pressure and cover profiles with single gasket 190311



Bent sheet aluminium, selectively infill material Styrodur glued with cover profile.



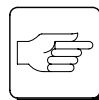
Metal adhesive:
5070002



Punching tool:
5040044 ①



Cutting thermal break, pressure and cover profiles:
see chapter Cuttings



Use lever, esco no. 92-108197 if necessary.



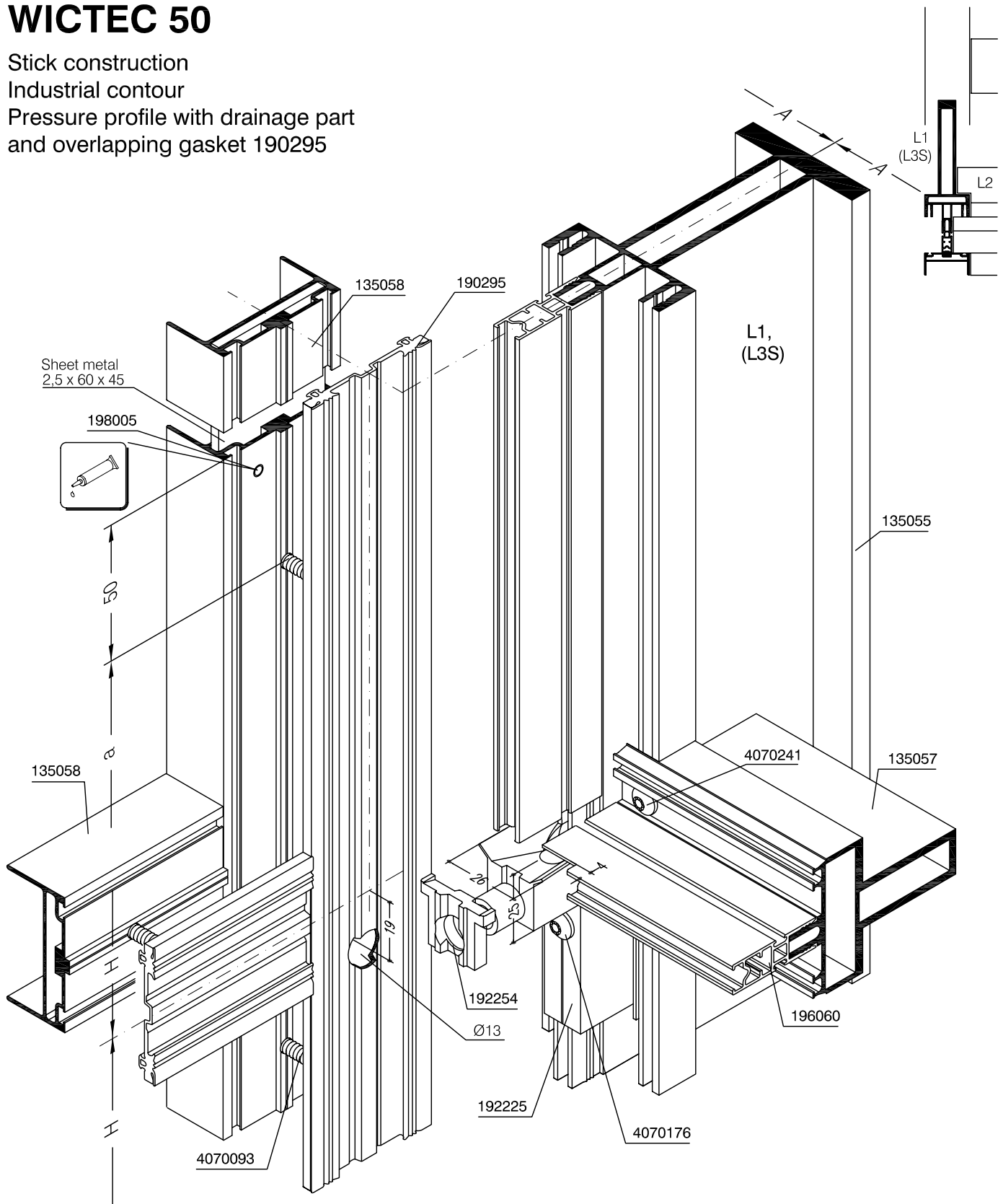
Attention:

Tightening torque of screw for pressure profiles: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm

WICTEC 50

Stick construction
Industrial contour
Pressure profile with drainage part
and overlapping gasket 190295



Metal adhesive:
5070002



Cutting thermal break and
pressure profiles:
see chapter Cuttings



Selection of drainage part:
see chapter Cuttings

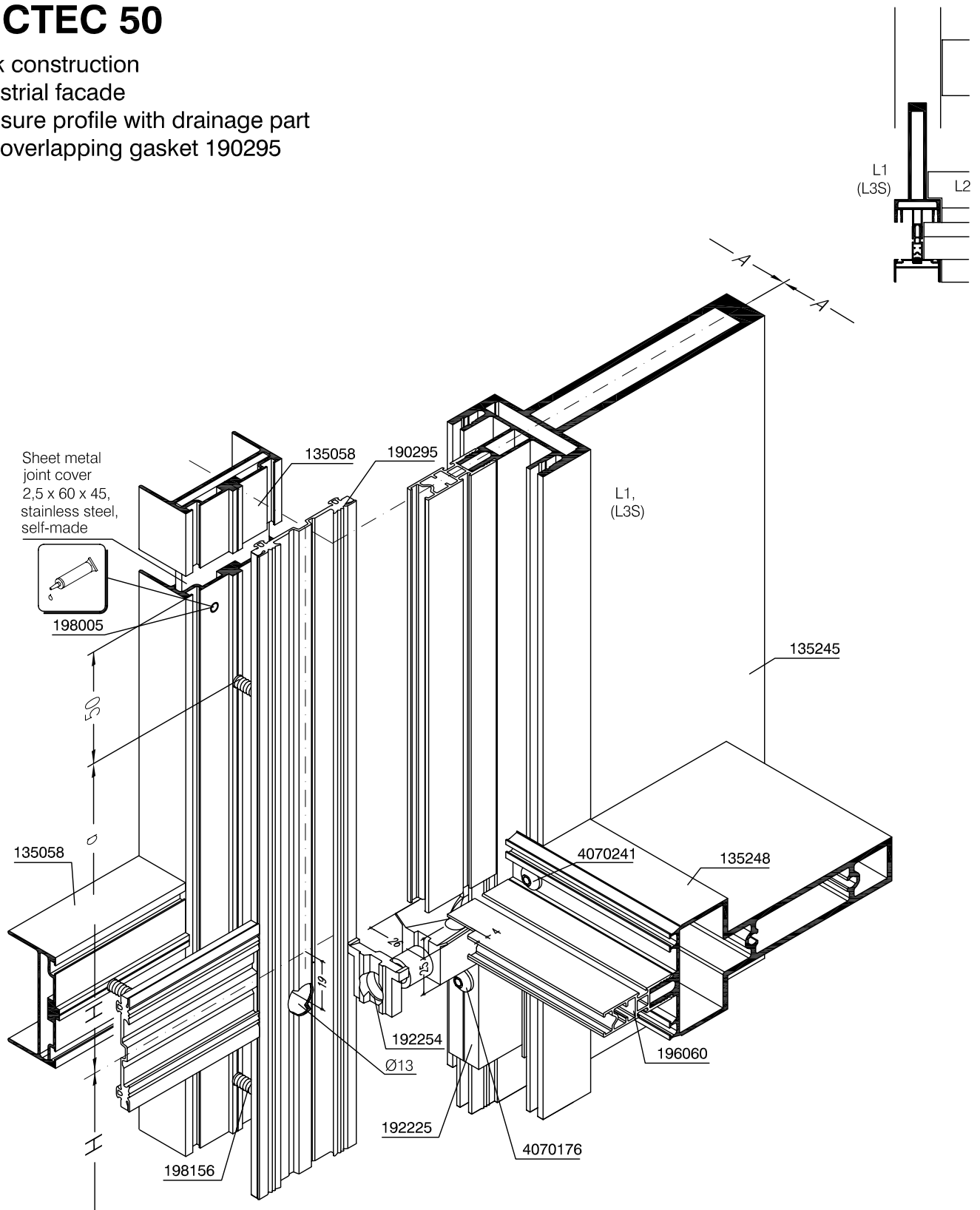


Attention:
Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning
of profile bar.

Screw distance in boundary area (edge distance 1.50 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm

WICTEC 50

Stick construction
Industrial facade
Pressure profile with drainage part
and overlapping gasket 190295



Metal adhesive:
5070002



Cutting thermal break and
pressure profiles:
see chapter Cuttings



Selection of drainage part:
see chapter Cuttings

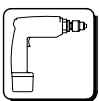
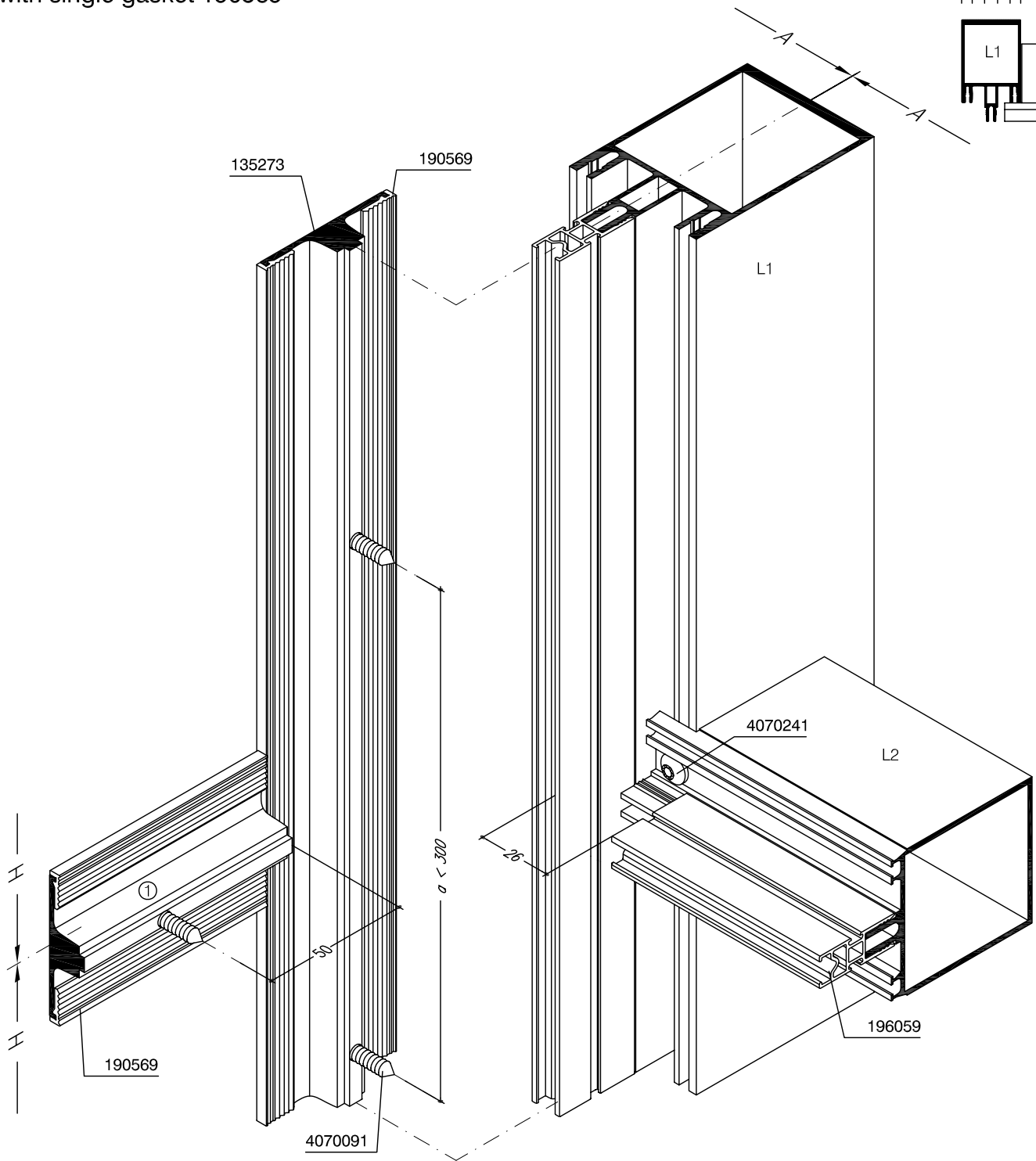
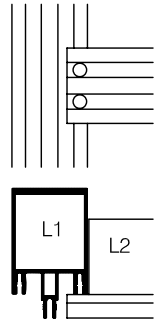


Attention:
Tightening torque of screw for pressure profile: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning
of profile bar.

Screw distance in boundary area (edge distance 1.50 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm

WICTEC 50

Stick construction
Integrated pressure profile
with single gasket 190569



Step drill 5060006 (92-414212) ①
Drill template:
5010383 (esco no. 91-5155639)



Cutting thermal break and pressure profiles:
see chapter Cuttings



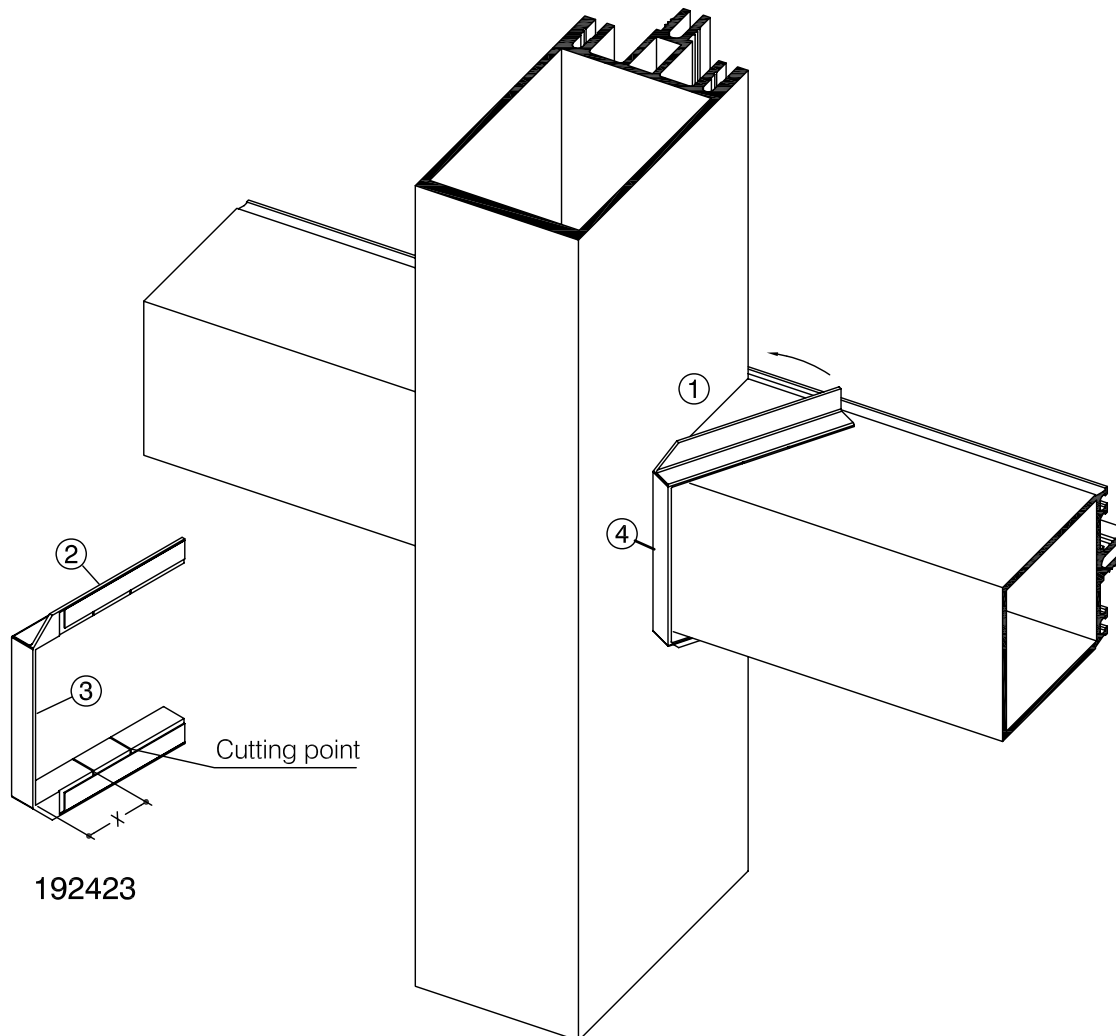
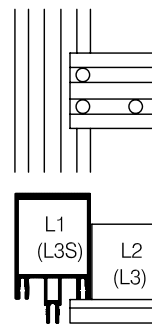
Attention:
Tightening torque of screw for pressure profiles: 500 Ncm.
Screw distances $a < 300$ mm, 50 mm from the beginning of profile bar.

Screw distances in boundary area (edge distance 2.0 m):
20 m assembly height = $a < 300$ mm
above 20 m assembly height = $a < 150$ mm

WICTEC 50

Stick construction

Assembly of transom sleeve 192423



192423

Mounting sequence:

1. Degrease mullion profile in area of transom sleeve.
2. Prepare transom sleeve according to application table.
3. Expansion gap between mullion and inwards staggered transom < 1mm., Cut web along the dashed line.
4. Lay transom sleeve on transom profile and swivel in direction of arrow and press.

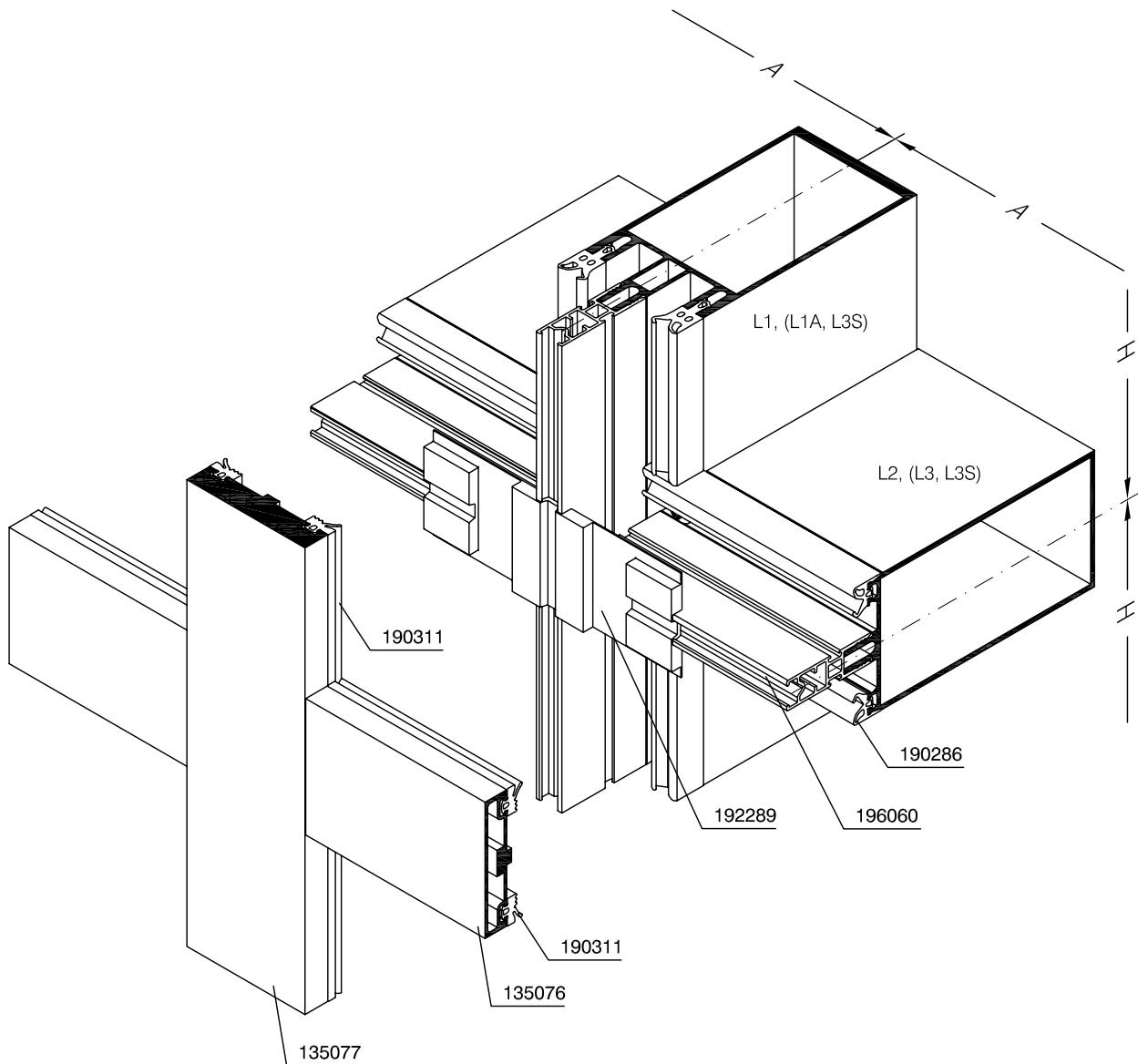
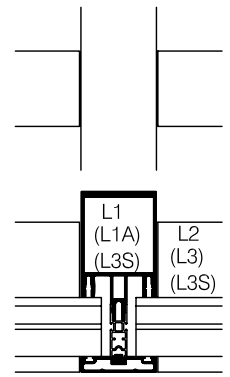
Application table

Transom profile	Profile no.	Cutting X	Cutting point
L2	135023	57 mm	3
L3	135032	57 mm	3
L2	135024	77 mm	4
L3	135033	77 mm	4
L2	135025	97 mm	5
L3	135034	97 mm	5
L2	135026	117 mm	6
L3	135035	117 mm	6
L2	135027	137 mm	7
L2	135028	147 mm	-

WICTEC 50

Stick construction

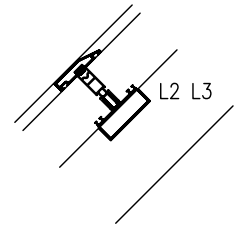
Assembly of outer sealing sleeve 192289



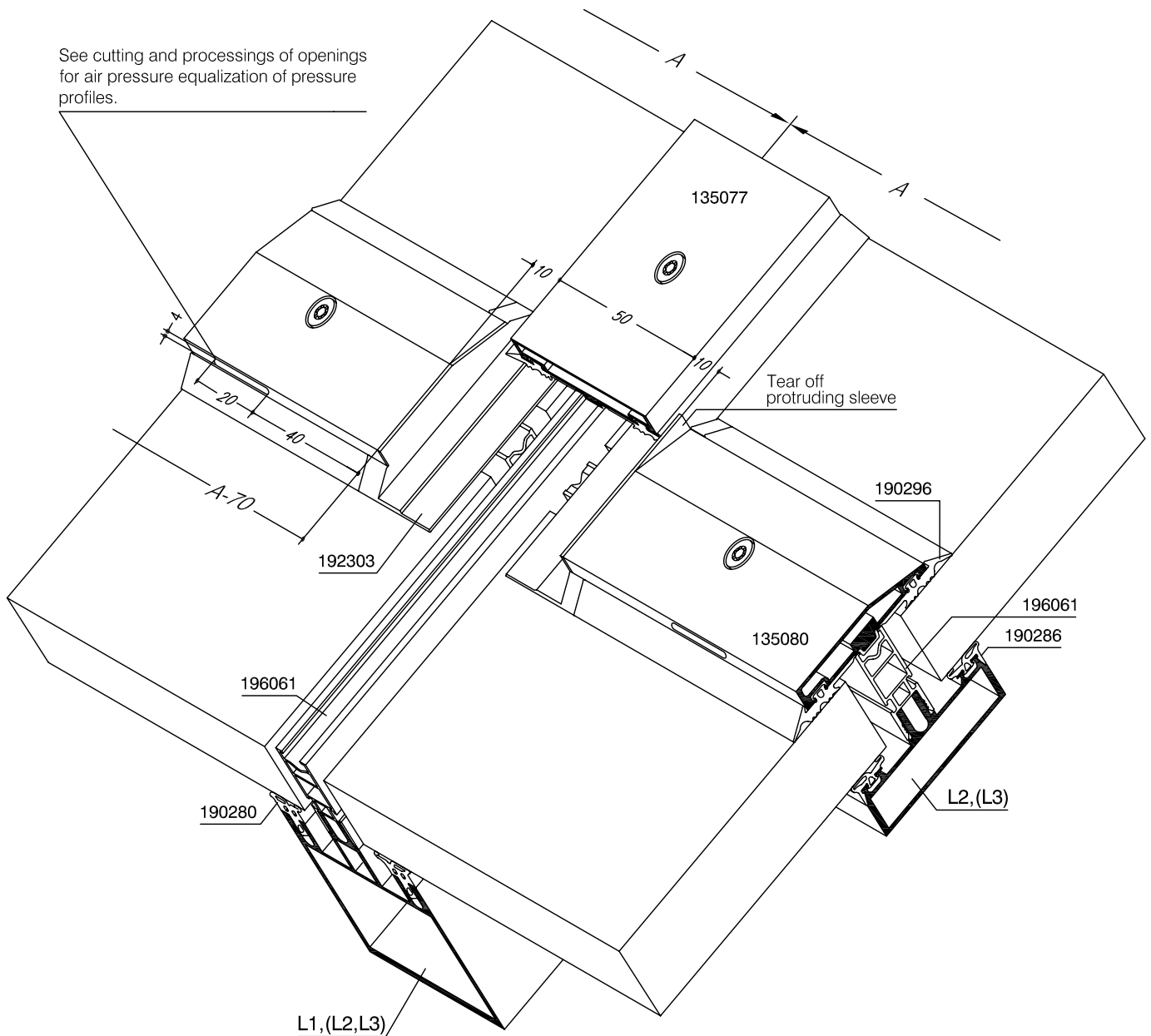
Cutting thermal break profile:
see chapter Thermal Break Cutting

WICTEC 50

Stick construction
Assembly of sealing sleeve 192303



Assembly of sealing sleeve 192303
with overlapping gasket 190296
for fixed glazings and roof light vent sash in the roof pitch

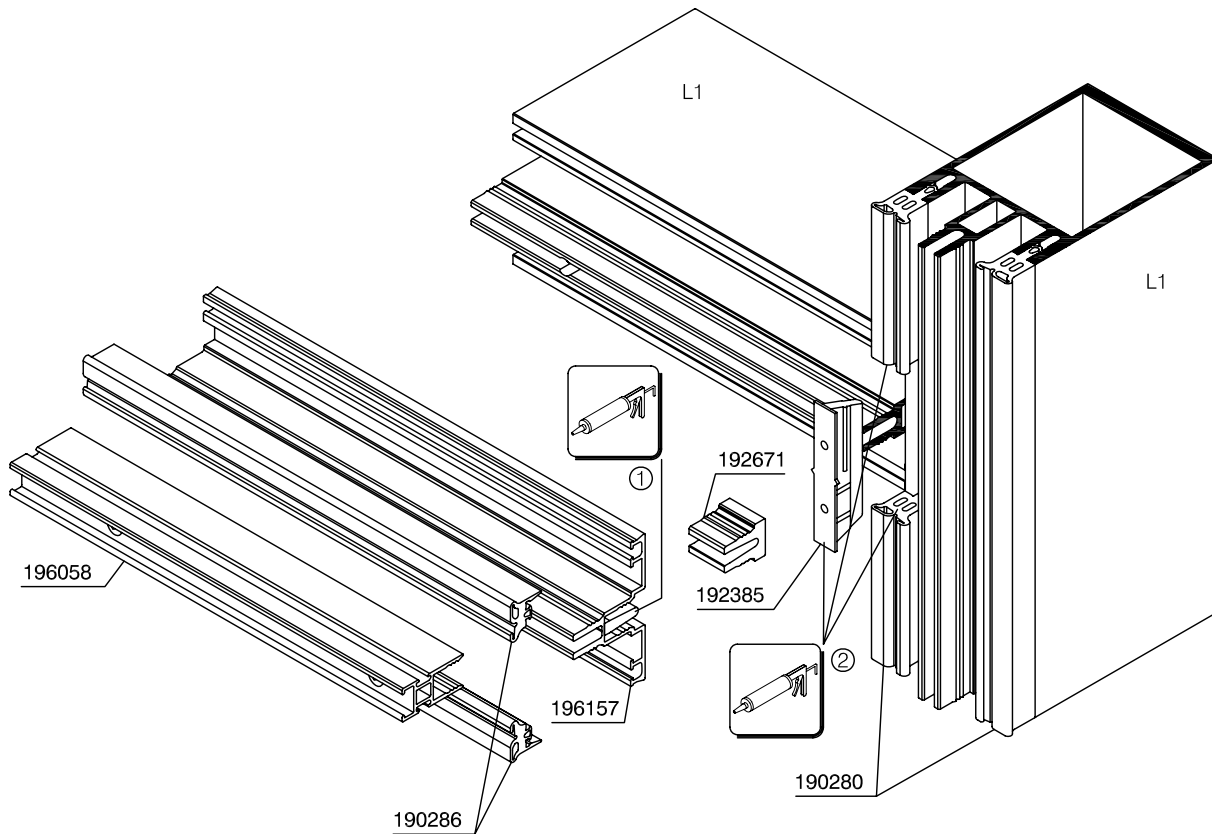
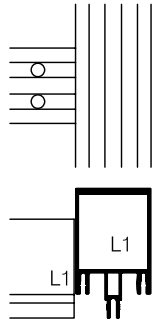


Cutting thermal break profiles:
see chapter Cuttings

WICTEC 50P

Facade
Sealing transom joint

Note:
Necessary assembly of sealing parts 192385
and 192671 prior to mounting profile 196157.



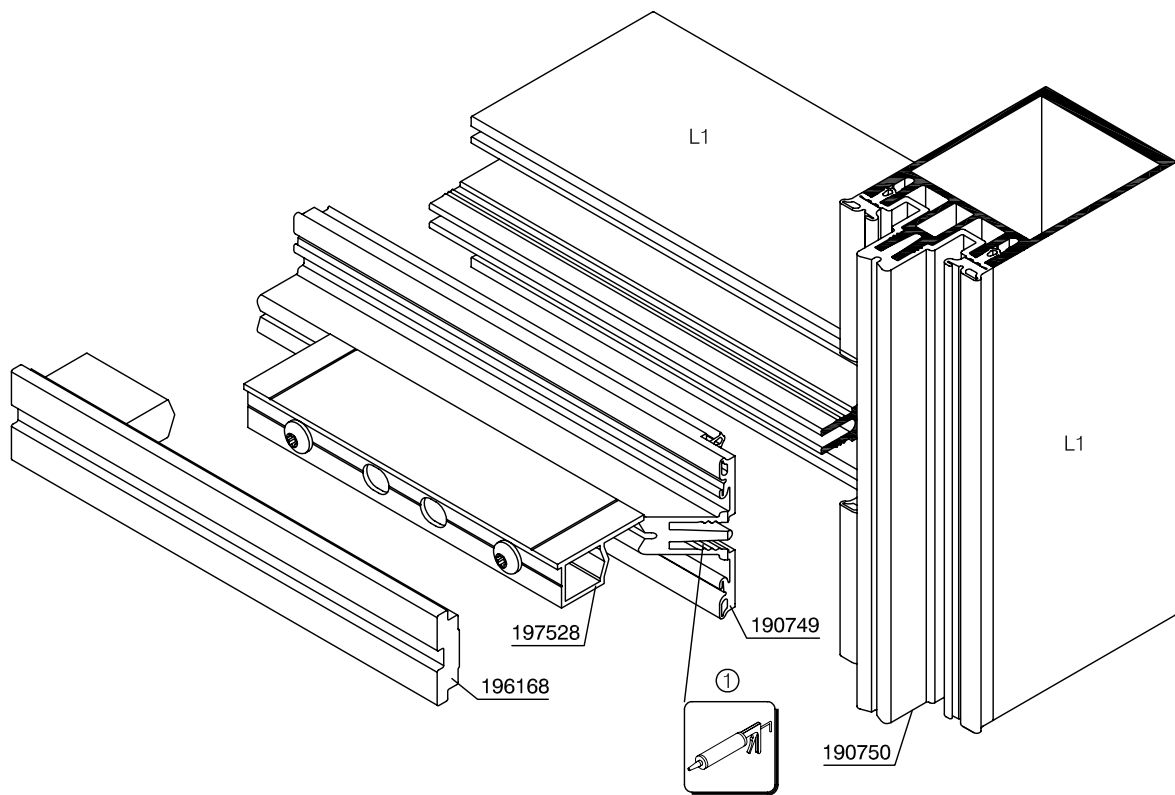
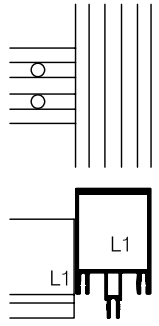
- ① Impress 192671 into sealant.
- ② Apply sealant on 196157 and 192671 prior to assembly.



Note:
See WICTEC 50P/50E Workshop Manual
for connector assembly
"Transom joint with connector"

WICTEC 50E

Facade
Sealing transom joint



① Apply sealant to the notching after assembly.



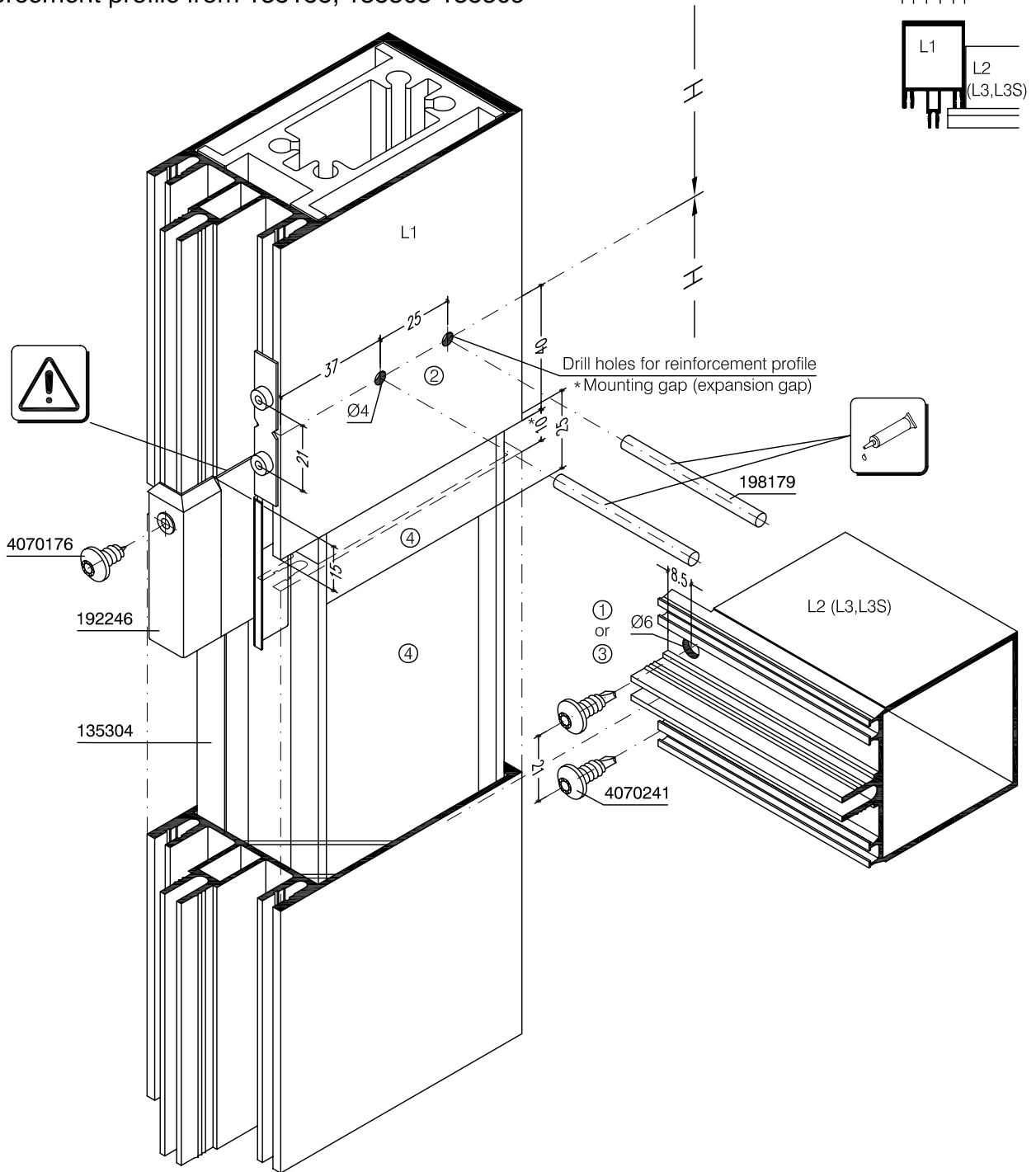
Note:
See WICTEC 50P/50E Workshop Manual
for connector assembly
"Transom joint with connector"

WICTEC 50

Stick construction

Mullion profile expansion joint

with reinforcement profile from 135155, 135303-135309



Secure cylindrical pin with safeguard (e.g. Loctite)



Drill template:
5010367 (esco no. 91-411540) ①
5010373 (esco no. 91-429740) ②



Pay attention to correct position of sealing lip. Seal sealing lip with sealant for sloped glazing.



Punching tool:
5040046 ③



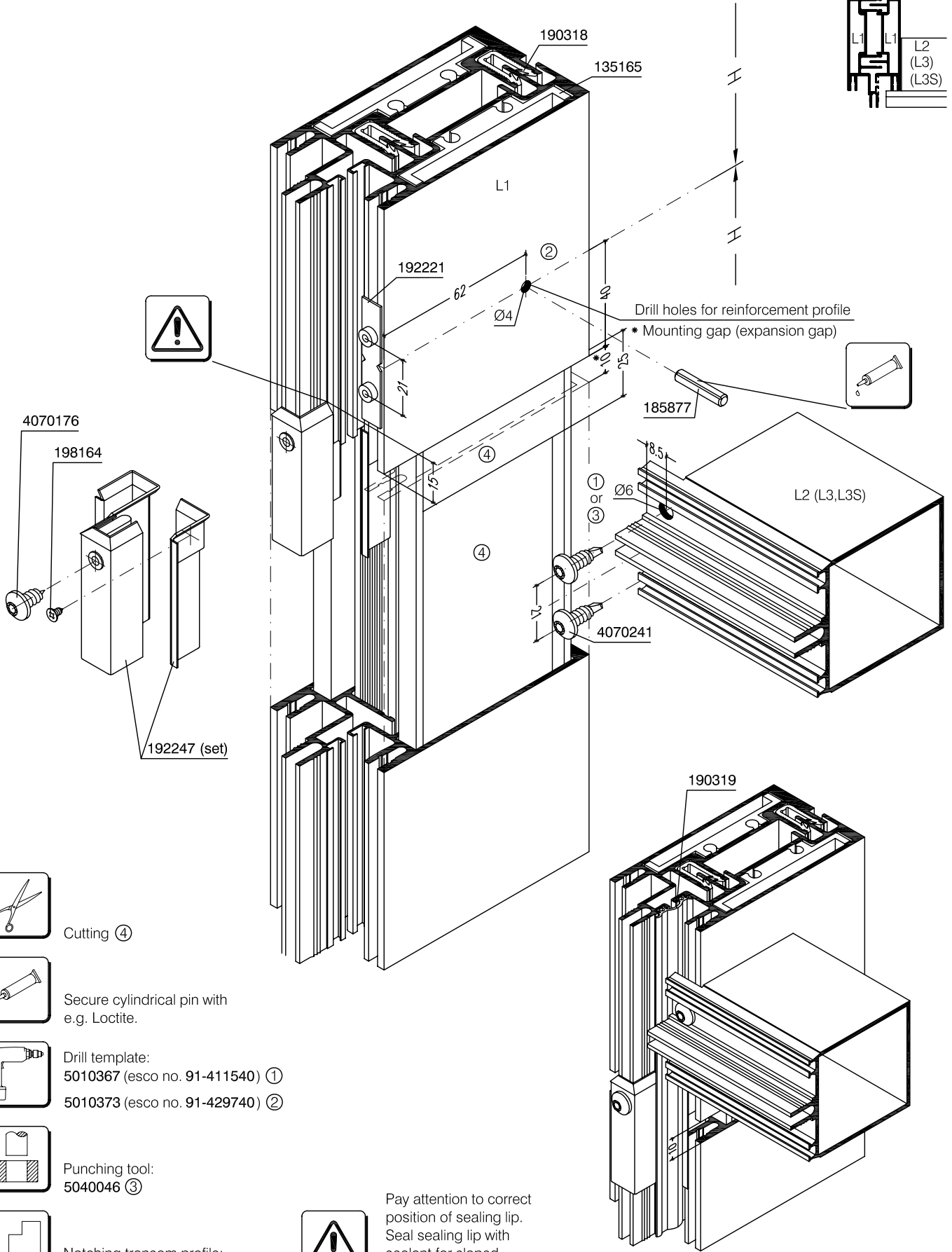
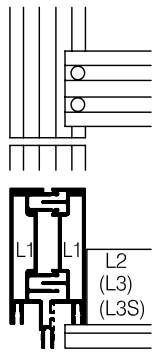
Cutting: ④



Notching transom profile: see chapter Transom Cutting

WICTEC 50

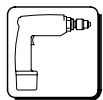
Stick construction
Expansion joint split mullion profile
with reinforcement profile from 135165-135168



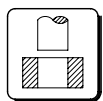
Cutting ④



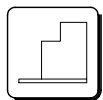
Secure cylindrical pin with e.g. Loctite.



Drill template:
5010367 (esco no. 91-411540) ①
5010373 (esco no. 91-429740) ②



Punching tool:
5040046 ③



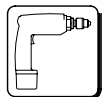
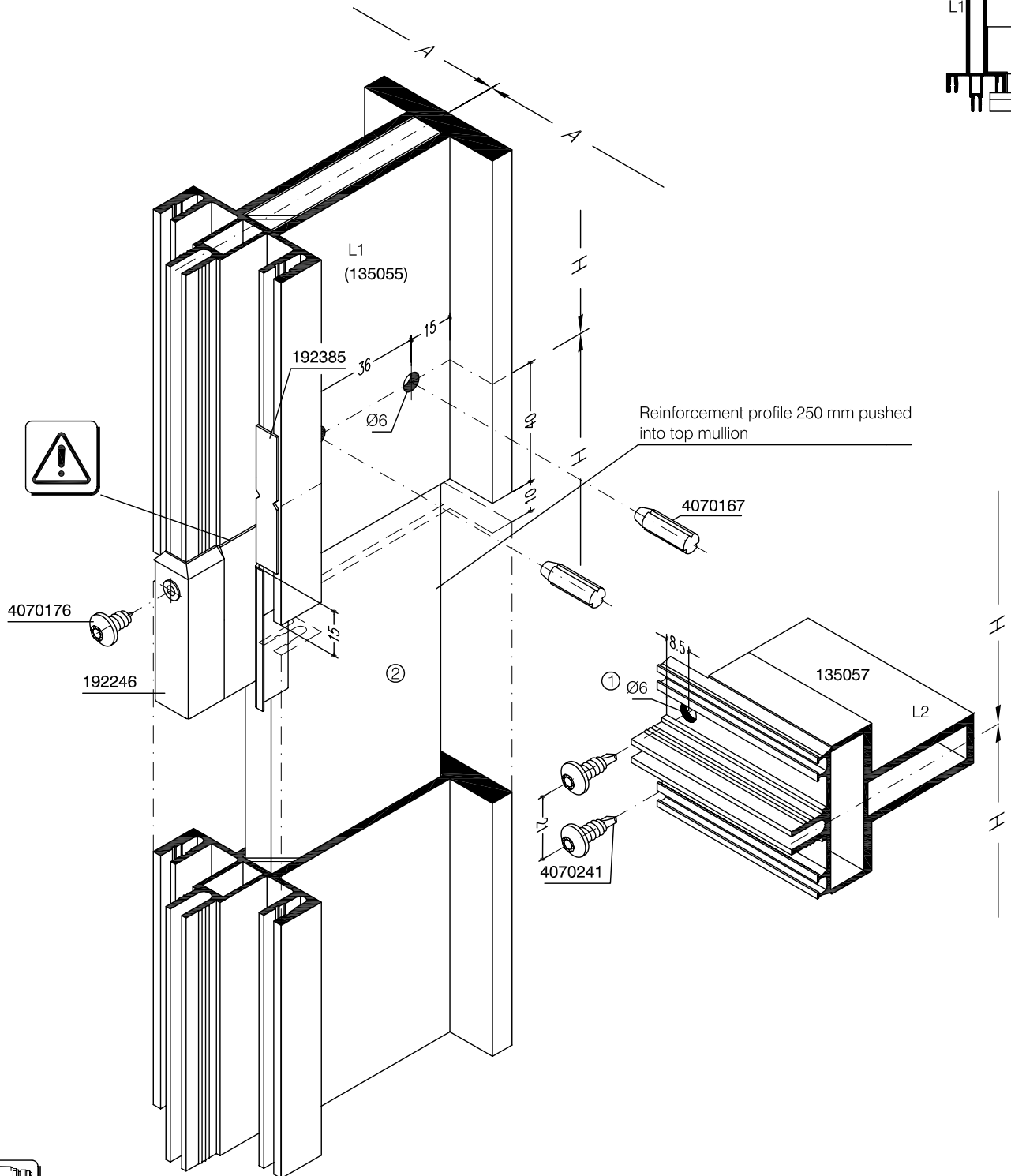
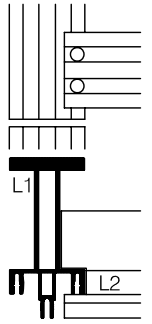
Notching transom profile:
see chapter Transom Cutting



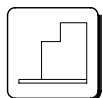
Pay attention to correct position of sealing lip.
Seal sealing lip with sealant for sloped glazing.

WICTEC 50

Stick construction
Mullion profile expansion joint



Drill template:
5010367 (esco no.91-411540) ①



Notching transom profile:
see chapter Transom Cutting



Cutting reinforcement profile:
Aluminium flat material 70 x 10 x 500 sawed up to 65.5 mm width ②.

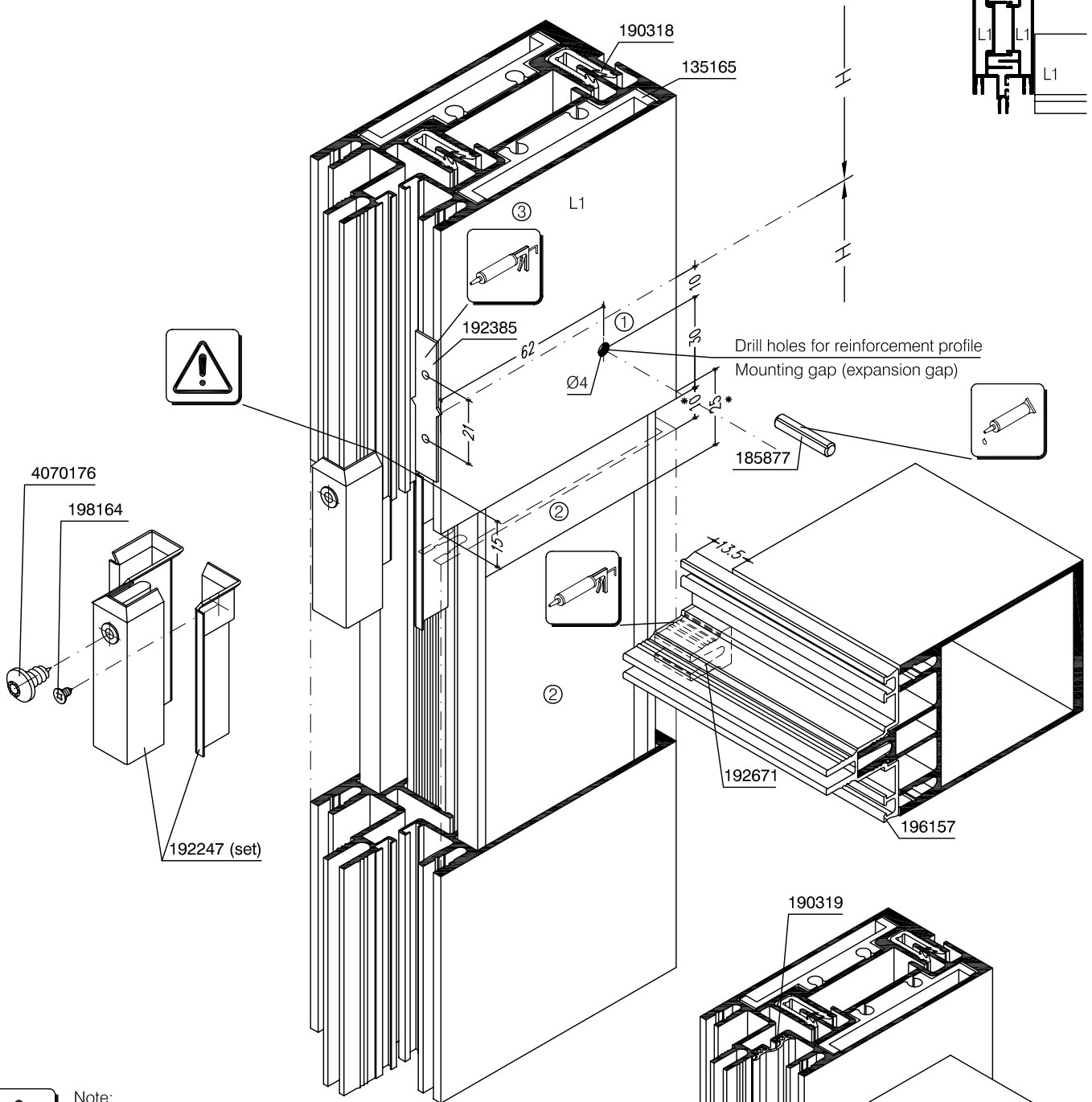
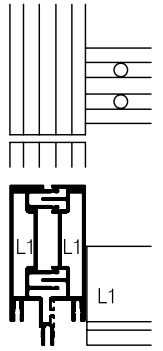


Pay attention to correct
position of sealing lip.
Seal sealing lip with
sealant for sloped
glazing.

WICTEC 50P

Facade

Split mullion profile expansion joint
with reinforcement profile from 135165-135168



Note:
See WICTEC 50P/50E Workshop Manual
for connector assembly
"Transom joint with connector"



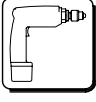
Cutting ②



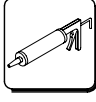
Secure cylindrical pin with
e.g. Loctite.



Pay attention to correct
position of sealing lip.
Seal sealing lip with
sealant for sloped
glazing.



Drill template:
5010394 ①



Seal 196157 prior
to assembly. ③

WICTEC 50

Stick construction

Bullet resistant according to DIN EN 1522

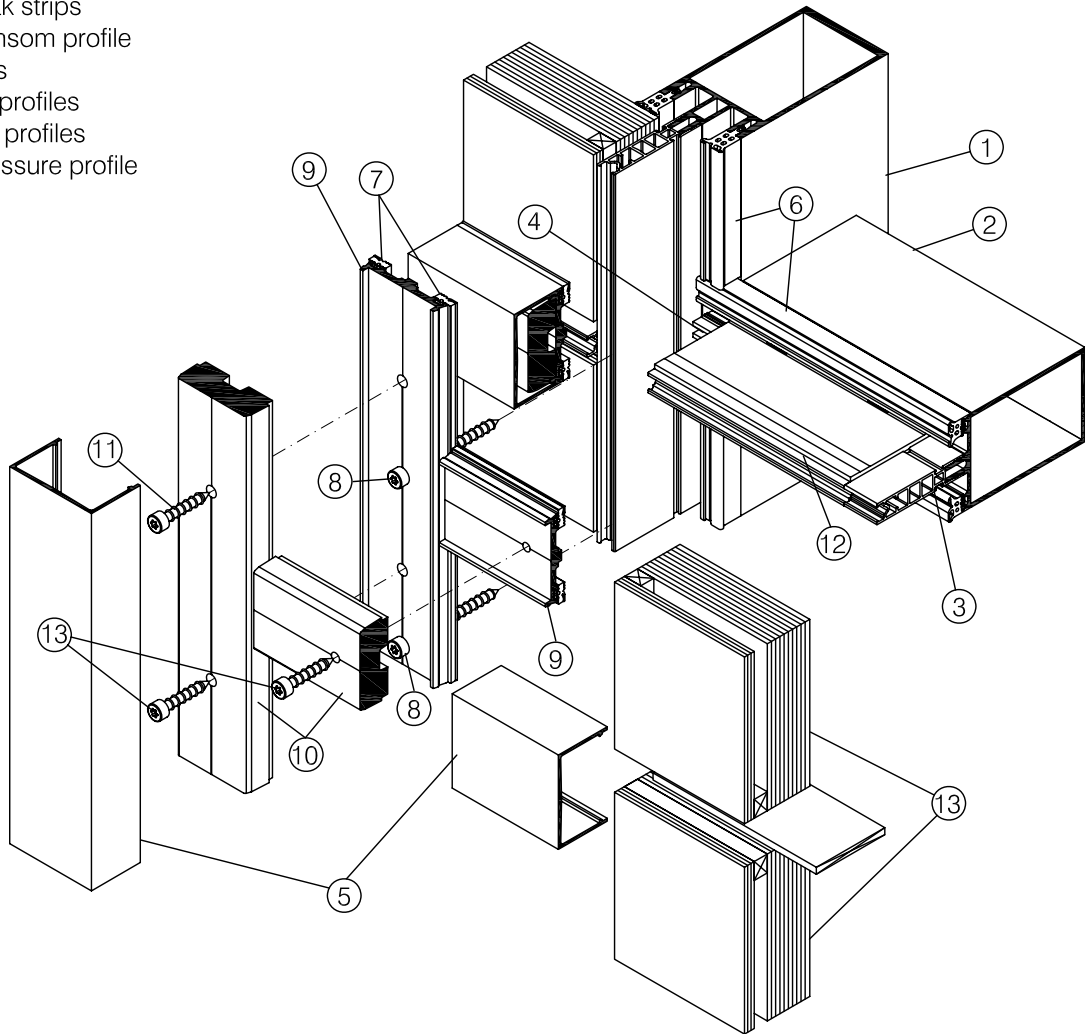
Resistance Class FB4

Construction points Survey



WICTEC 50 standard facade

1. Standard mullion profiles
2. Transom profiles
3. Thermal break strips
4. Screwing transom profile
5. Cover profiles
6. Inner gasket profiles
7. Outer gasket profiles
8. Screwing pressure profile



+ Bullet resistant special parts:

9. Pressure profile 135193
10. Aluminium planking 3030012
11. Screwing aluminium planking
12. Shim 197503
13. Infills:
 - Admissible glazings or panels

WICTEC 50

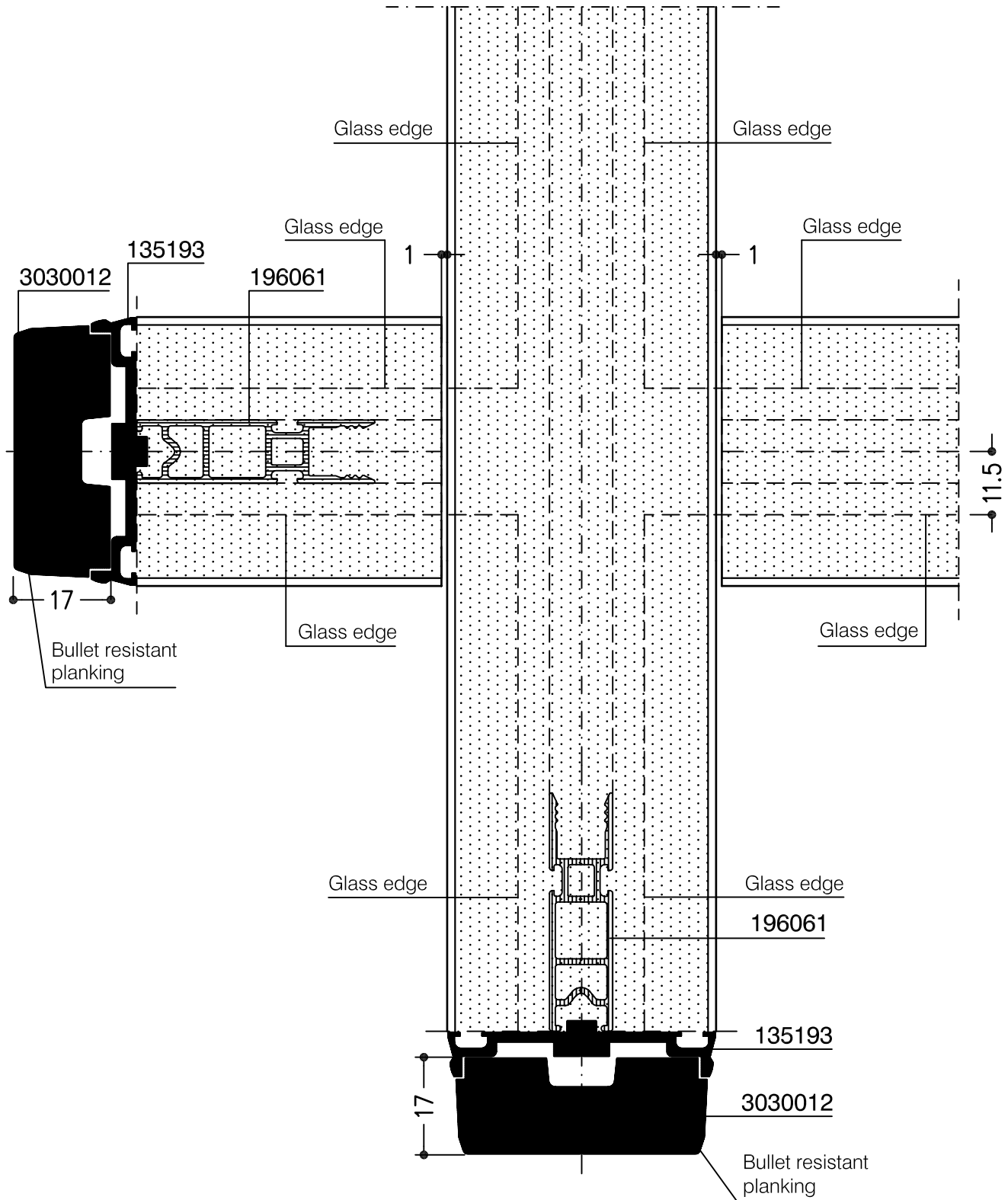
Stick construction

Bullet resistant according to DIN EN 1522

Resistance Class FB4



Cross joint Pressure and planking profiles



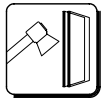
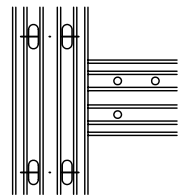
WICTEC 50

Stick construction

Burglar resistant according to DIN V ENV 1627

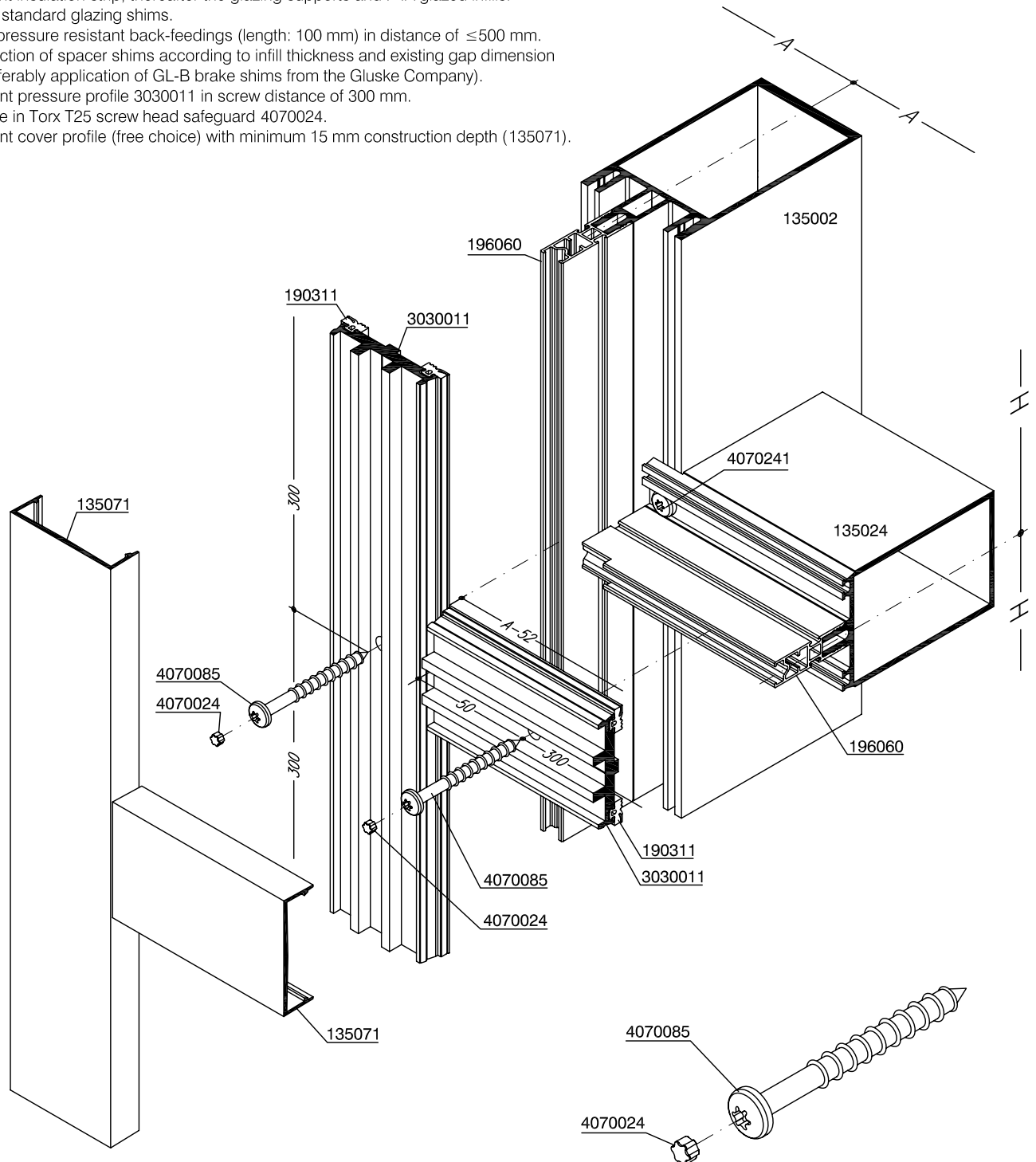
Resistance Class WK 2

Variant with pressure profile 3030011



Mounting instructions:

1. Mount insulation strip, thereafter the glazing supports and P4A glazed infills.
Use standard glazing shims.
2. Set pressure resistant back-feedings (length: 100 mm) in distance of ≤ 500 mm.
Selection of spacer shims according to infill thickness and existing gap dimension
(preferably application of GL-B brake shims from the Gluske Company).
3. Mount pressure profile 3030011 in screw distance of 300 mm.
4. Stave in Torx T25 screw head safeguard 4070024.
5. Mount cover profile (free choice) with minimum 15 mm construction depth (135071).



Attention!



Set Torx T25 screw head safeguard 4070024 with chamfer into the recess of self-tapping screw head and stave in with appropriate setting tool or $\varnothing 5$ mm punch.

WICTEC 50

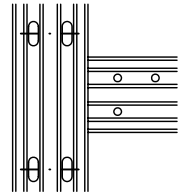
Stick construction

Burglar resistant according to DIN V ENV 1627

Resistance Class WK 3

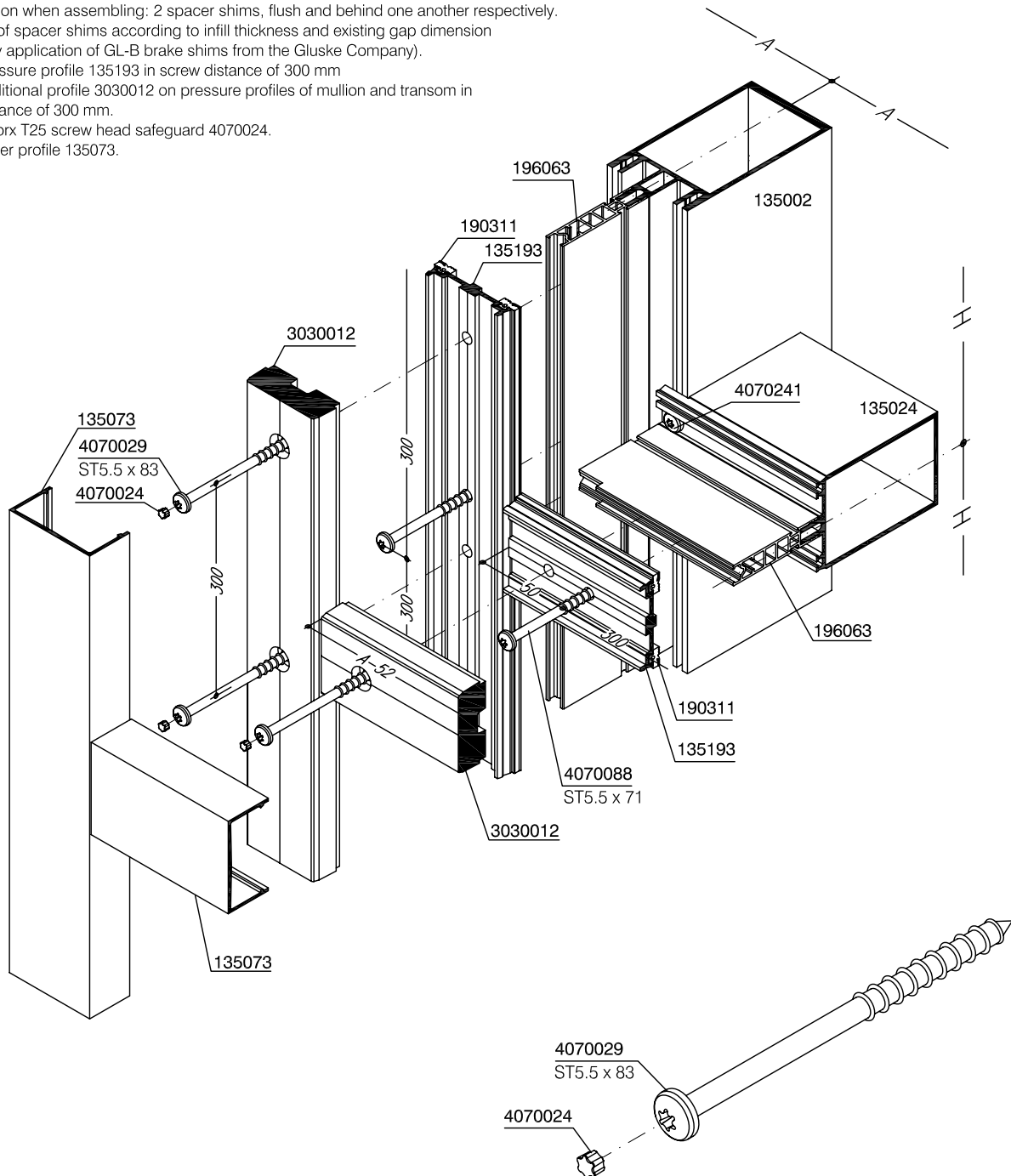
Detail of facade with mounting sequence

Variant with additional profile 3030012



Mounting instructions:

1. Glaze with P6B infills and glazing supports. Use standard glazing shims.
2. Set pressure resistant back-feedings in distance of ≤ 500 mm.
Pay attention when assembling: 2 spacer shims, flush and behind one another respectively.
Selection of spacer shims according to infill thickness and existing gap dimension
(preferably application of GL-B brake shims from the Gluske Company).
3. Mount pressure profile 135193 in screw distance of 300 mm
4. Screw additional profile 3030012 on pressure profiles of mullion and transom in screw distance of 300 mm.
5. Stave in Torx T25 screw head safeguard 4070024.
6. Mount cover profile 135073.



Attention!

Set Torx T25 screw head safeguard 4070024 with chamfer into the recess of self-tapping screw head and stave in with appropriate setting tool or $\varnothing 5$ mm punch.

WICTEC 50HI

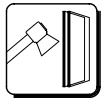
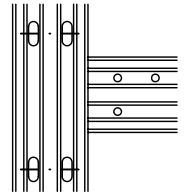
Stick construction

Burglar resistant according to DIN V ENV 1627

Resistance Class WK 2

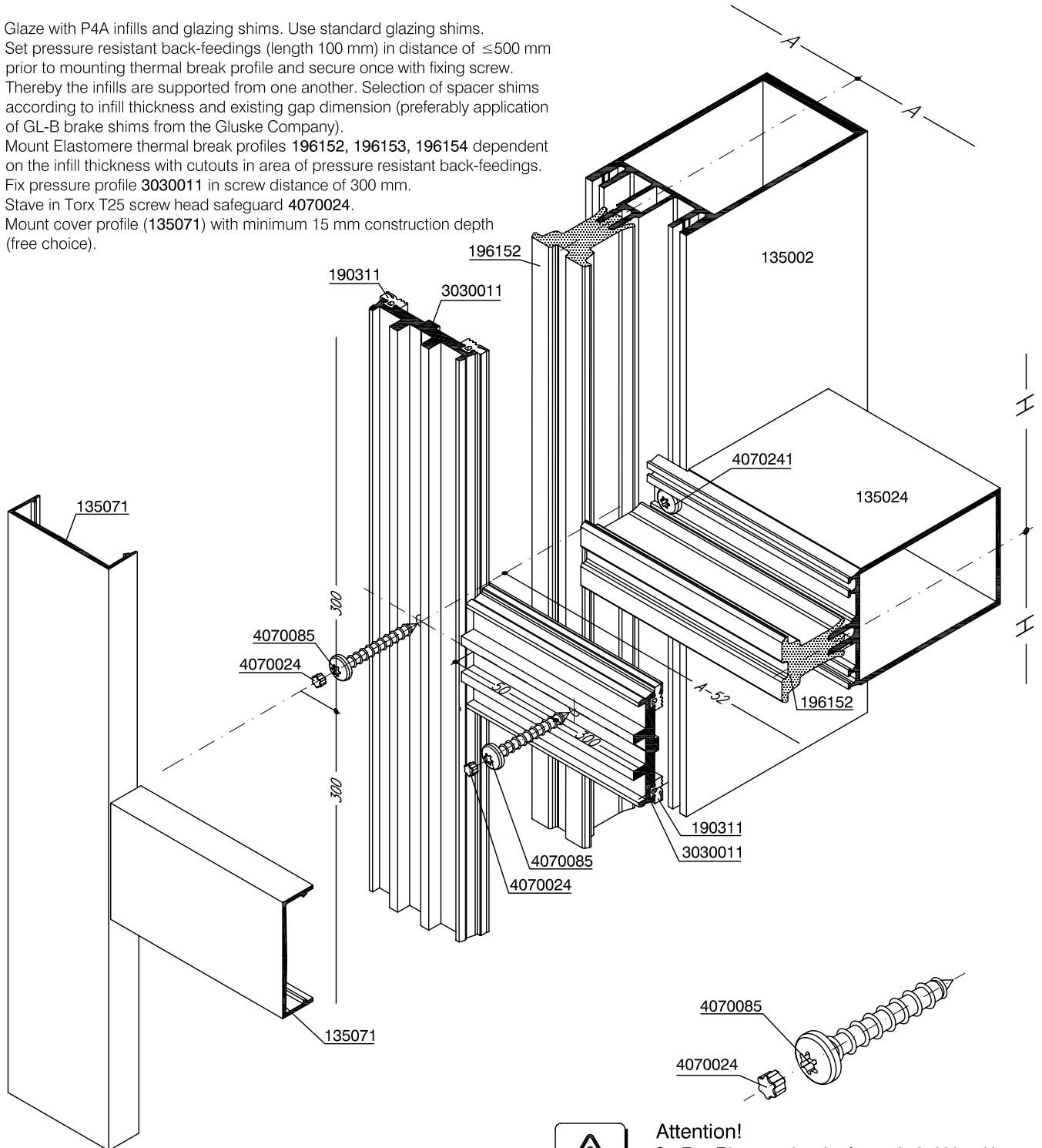
Detail of facade with mounting sequence

Variant with pressure profile 3030011



Mounting instructions:

1. Glaze with P4A infills and glazing shims. Use standard glazing shims.
2. Set pressure resistant back-feedings (length 100 mm) in distance of ≤ 500 mm prior to mounting thermal break profile and secure once with fixing screw. Thereby the infills are supported from one another. Selection of spacer shims according to infill thickness and existing gap dimension (preferably application of GL-B brake shims from the Gluske Company).
3. Mount Elastomere thermal break profiles **196152**, **196153**, **196154** dependent on the infill thickness with cutouts in area of pressure resistant back-feedings.
4. Fix pressure profile **3030011** in screw distance of 300 mm.
5. Stave in Torx T25 screw head safeguard **4070024**.
6. Mount cover profile (**135071**) with minimum 15 mm construction depth (free choice).



Attention!

Set Torx T25 screw head safeguard **4070024** with chamfer into the recess of self-tapping screw head and stave in with appropriate setting tool or $\varnothing 5$ mm punch.

WICTEC 50P

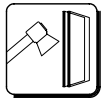
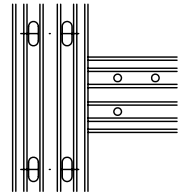
Facade

Burglar resistant according to DIN V ENV 1627

Resistance Class WK 2

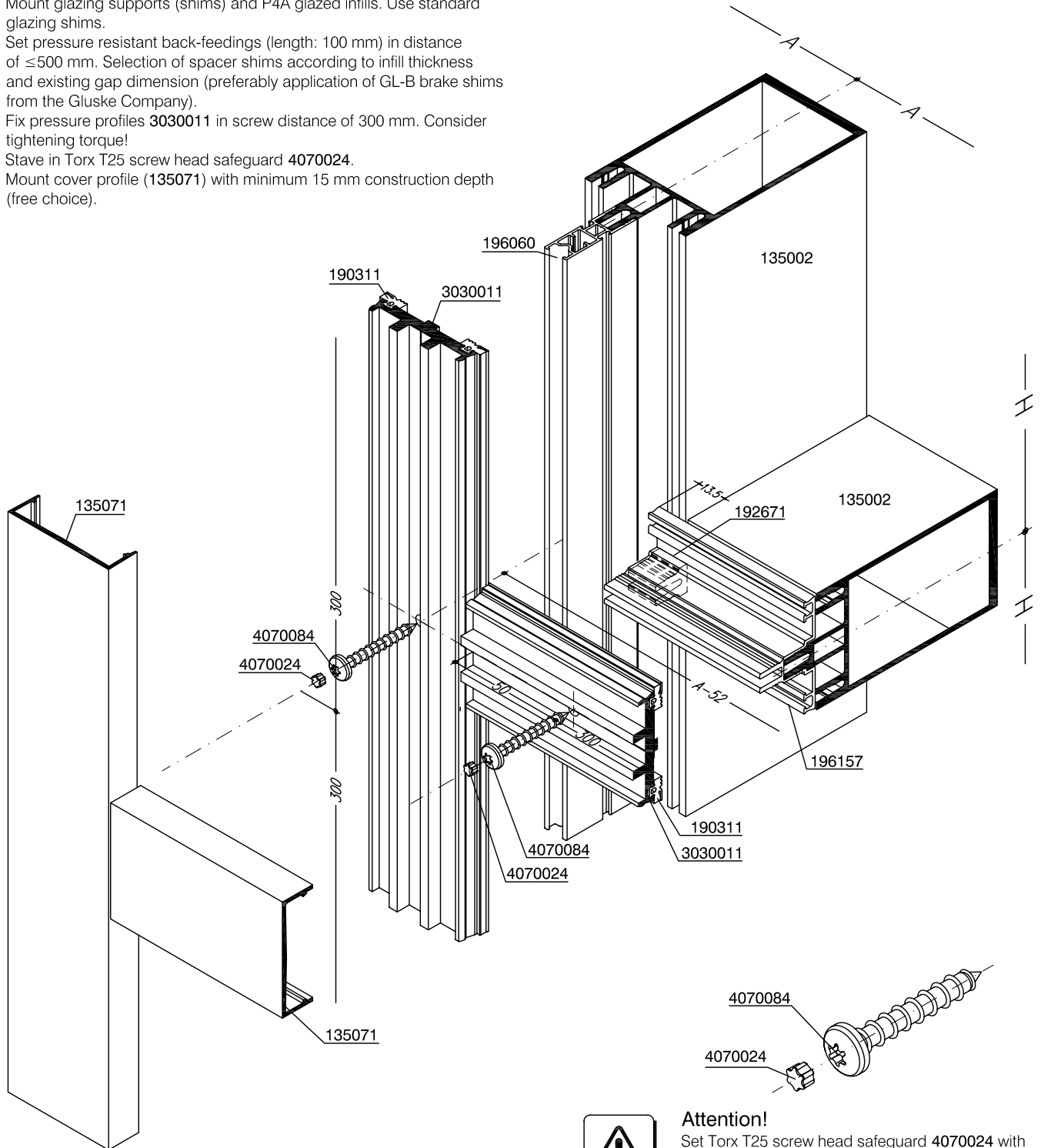
Detail of facade with mounting sequence

Variant with pressure profile 3030011



Mounting instructions:

1. Install mullion profile of Level 1 (L1) as transom with butt-joint.
2. Mount plastic supplementary profile **196157** on transom and execute all necessary sealing measures.
3. Mount thermal break profiles (insulation strips).
4. Mount glazing supports (shims) and P4A glazed infills. Use standard glazing shims.
5. Set pressure resistant back-feedings (length: 100 mm) in distance of ≤ 500 mm. Selection of spacer shims according to infill thickness and existing gap dimension (preferably application of GL-B brake shims from the Gluske Company).
6. Fix pressure profiles **3030011** in screw distance of 300 mm. Consider tightening torque!
7. Stave in Torx T25 screw head safeguard **4070024**.
8. Mount cover profile (**135071**) with minimum 15 mm construction depth (free choice).



Attention!

Set Torx T25 screw head safeguard **4070024** with chamfer into the recess of self-tapping screw head and stave in with appropriate setting tool or $\varnothing 5$ mm punch.

WICTEC 50A

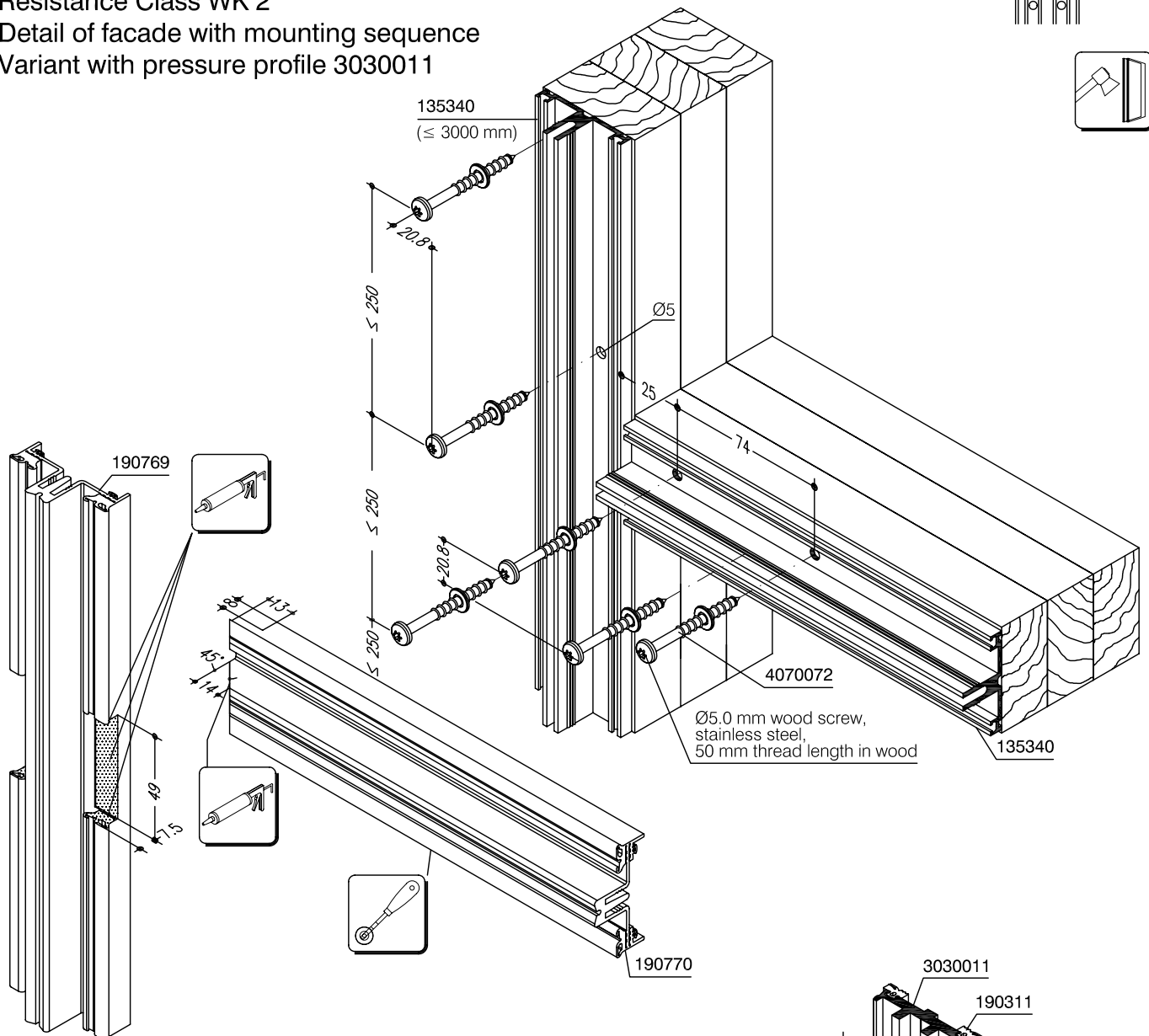
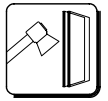
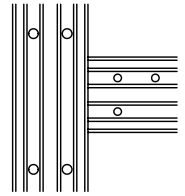
Facade

Burglar resistant according to DIN V ENV 1627

Resistance Class WK 2

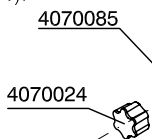
Detail of facade with mounting sequence

Variant with pressure profile 3030011



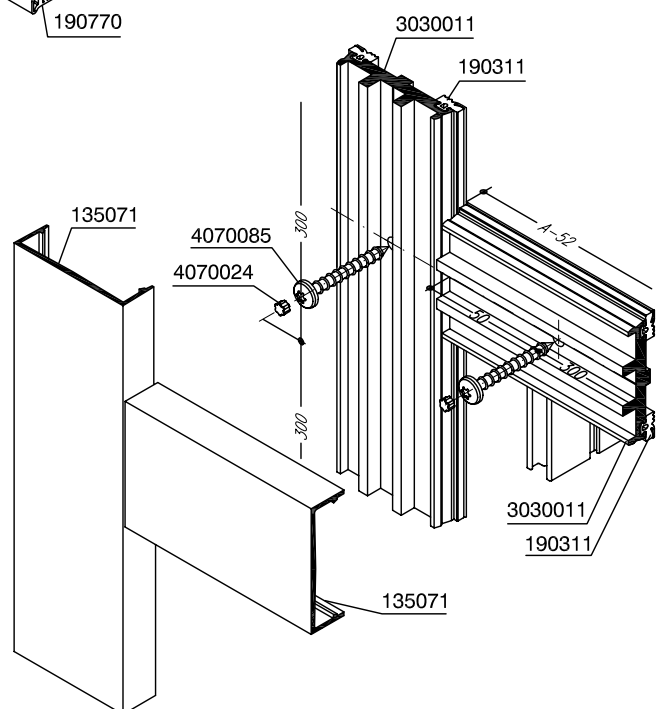
Mounting instructions:

1. Standard assembly of adapter profile 135340 with mullion gasket 190769 and transom gaske 190770 with the additional necessary measures.
2. Mount standard glazing supports and P4A glazed infills.
3. Set pressure resistant back-feedings (length: 100 mm) in distance of ≤ 500 mm. Selection of spacer shims according to infill thickness and existing gap dimension (preferably application of GL-B brake shims from the Gluske Company).
4. Mount pressure profile 3030011 in screw distance of 300 mm.
5. Stave in Torx T25 screw head safeguard 4070024.
6. Mount cover profile (free choice) of minimum 15 mm construction depth (135071).



Attention!

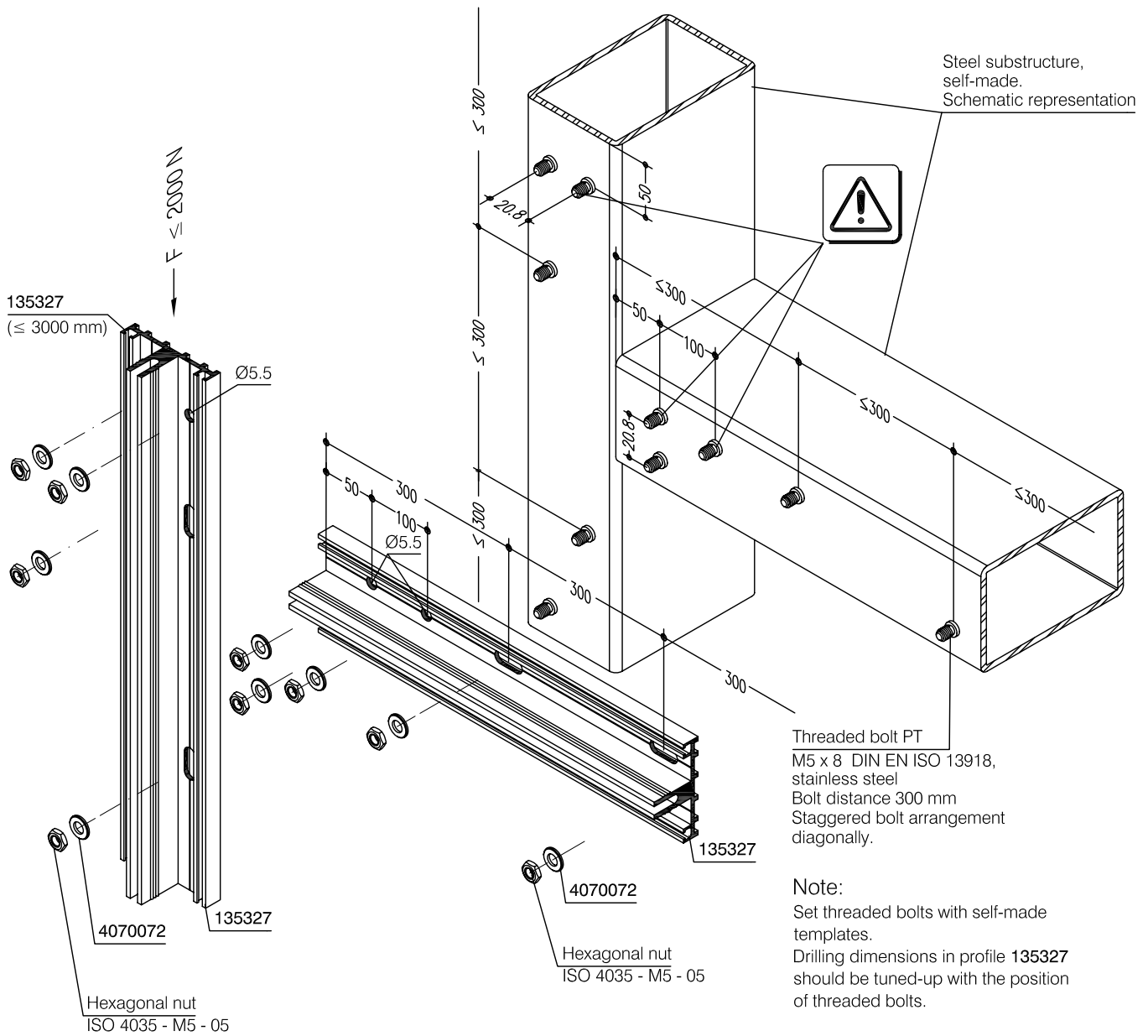
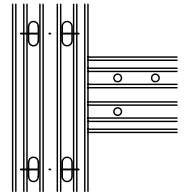
Set Torx T25 screw head safeguard 4070024 with chamfer into the recess of self-tapping screw head and stave in with appropriate setting tool or $\varnothing 5$ mm punch.



WICTEC 50A

Facade

Surface mounted construction on steel tube



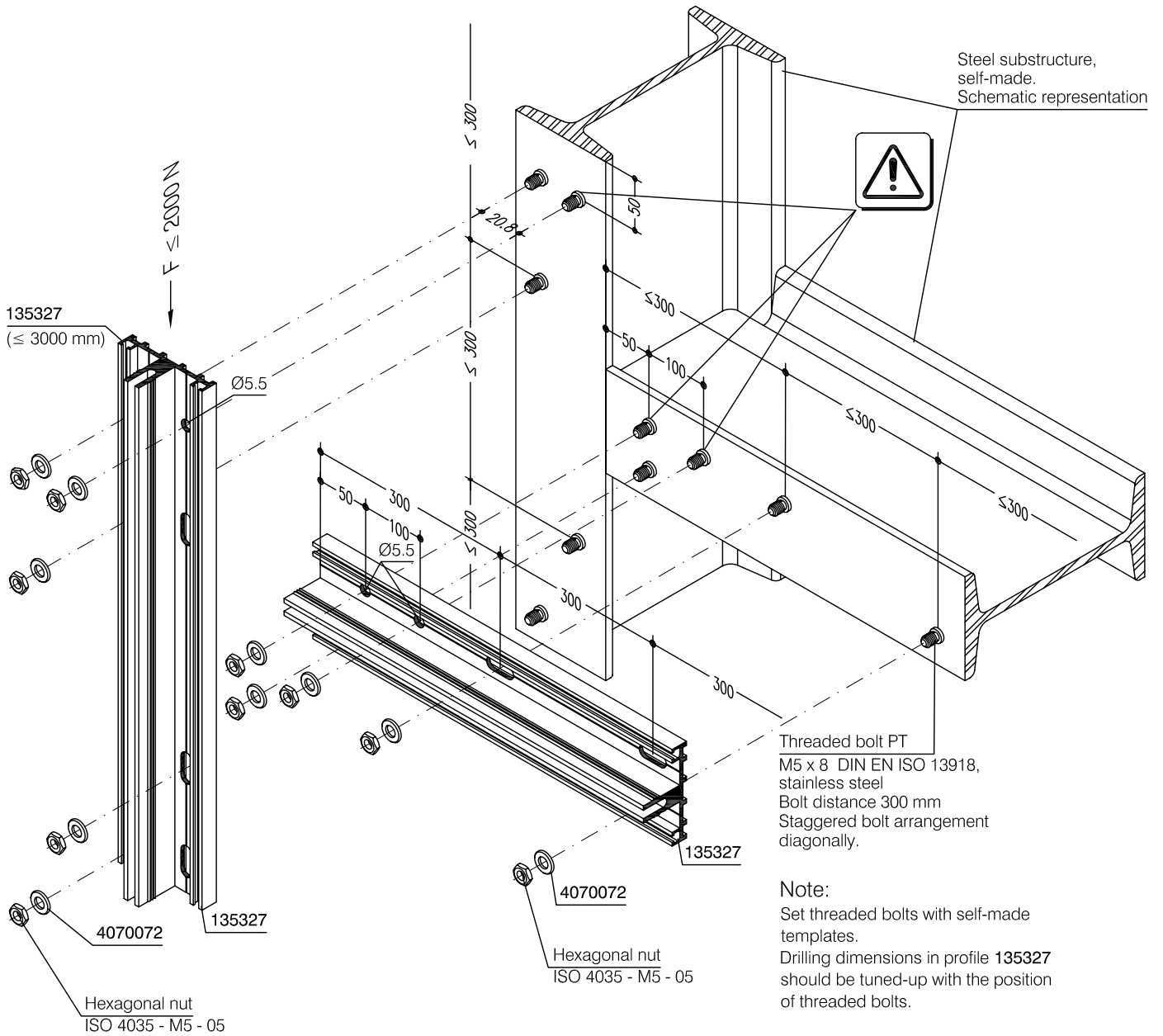
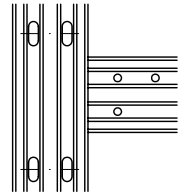
Set welded bolts as represented and drill boreholes in profile 135327 accordingly for additional fixing and load bearing (max. $\leq 2000\text{ N}$).

See WICTEC 50P or 50E for cover and gasket assembly.

WICTEC 50A

Facade

Surface mounted construction on T-girder

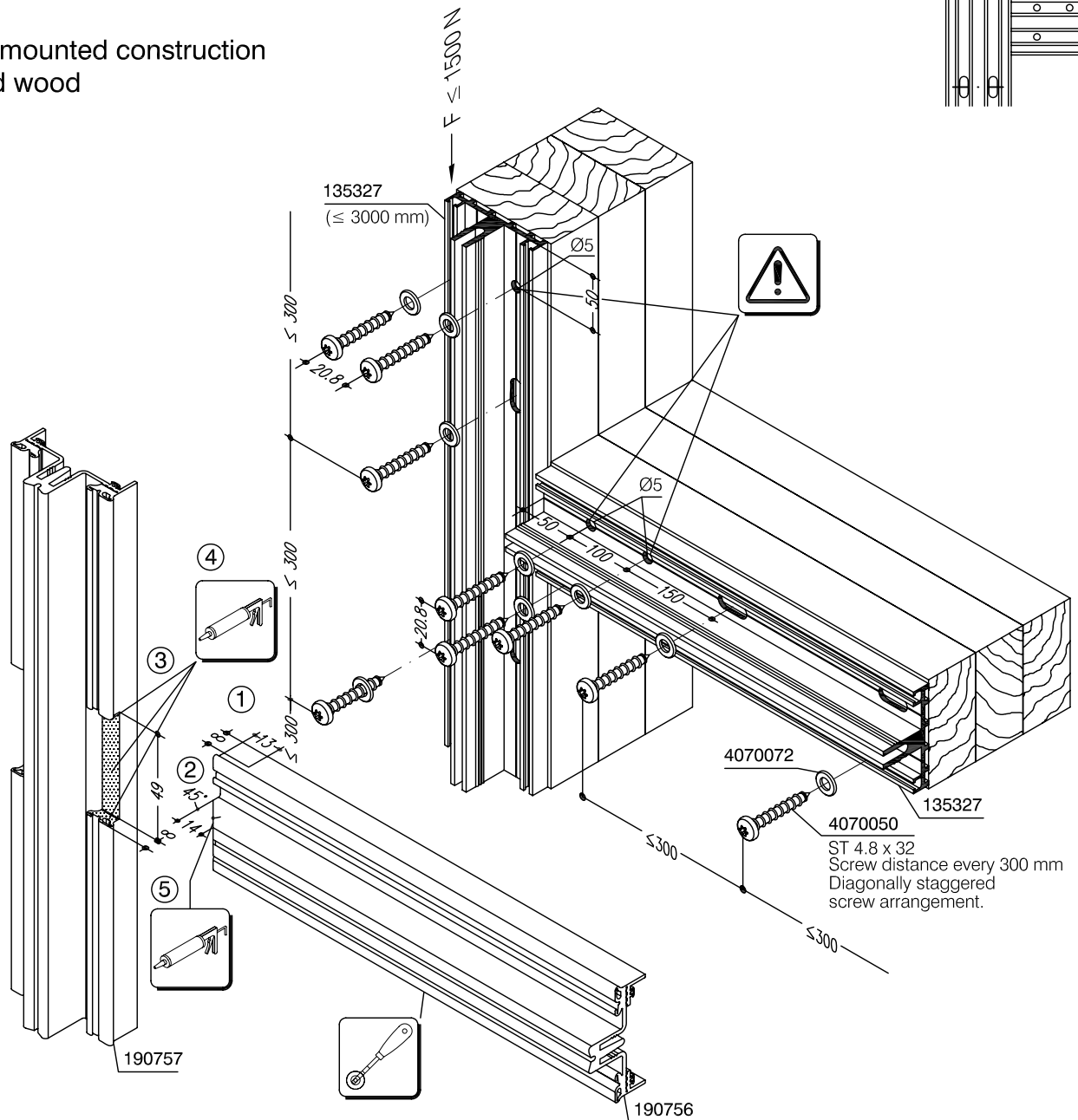
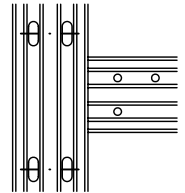


Set welded bolts as represented and drill boreholes in profile 135327 accordingly for additional fixing and load bearing (max. ≤ 2000N).

See WICTEC 50P or 50E for cover and gasket assembly.

WICTEC 50A

Facade
Surface mounted construction
on glued wood



Processing sequence:

- Clean aluminium profiles and EPDM gaskets in mullion/transom joint area as described under 1.1 (page 280).
- Among others pretreat EPDM-gasket joint area with cleaner as described under 1.3 (page 280) while using sealing material esco no. **92-537683** or similar.

- ① Cut to length and notch transom gasket **190756** with cutting die **5060214**.
- ② Notch 14 mm x 45°.
- ③ Cut mullion gasket **190757** to length with cutting die **5060214** and notch with notching tool **5040160**.
- ④ Seal notchings in mullion gasket all around with sealing material.
- ⑤ Seal notching.

- Seal just before mounting infills.



Notching tool:
5060214 ①
5040160 ③



Seal transom gasket **190756**
on mullion gasket **190757**
with sealing material.



Drill boreholes additionally for fixing i.e.
load bearing (max. ≤ 1500 N) in profile
135327.

See WICTEC 50P and WICTEC 50E
for cover assembly and thermal break part.



Rolling tool:
5060215



Cutting die:
5060214 ①

Predrill glued wood Ø3.0 mm, minimum
penetration depth of screw **4070050** ≥ 28 mm.

WICTEC 50A

Facade

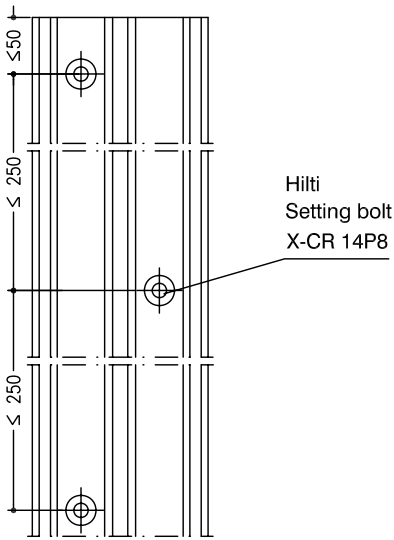
Surface mounted construction on steel tube with Hilti direct fixing system

Distances of setting bolts

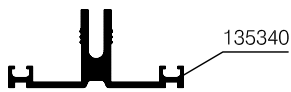
Application: - Bolt setting tool Hilti DX 450
 - Hilti setting bolt X-CR 14P8 (stainless steel)

Note: Approval Certificate of General Construction Supervision, No. Z - 14.4-456

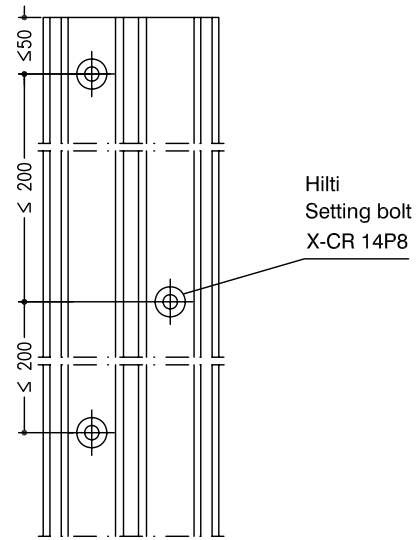
Standard: Mullion/Transom (Stick construction)



Hilti
Setting bolt
X-CR 14P8



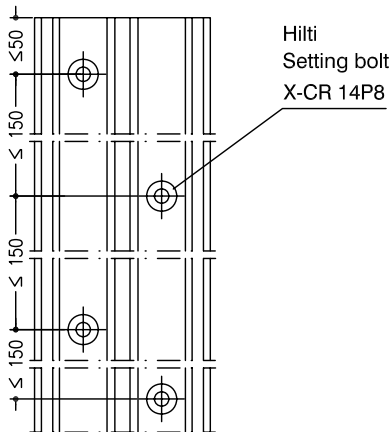
Corner area



Hilti
Setting bolt
X-CR 14P8



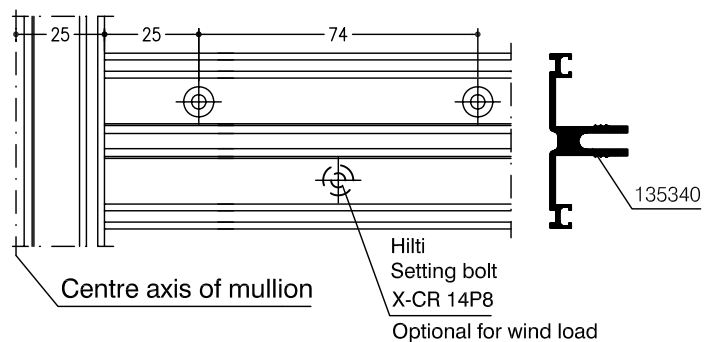
TRAV (Technical regulations for application of fall-prevention glazings)



Hilti
Setting bolt
X-CR 14P8



Glazing shim: Transom



Centre axis of mullion

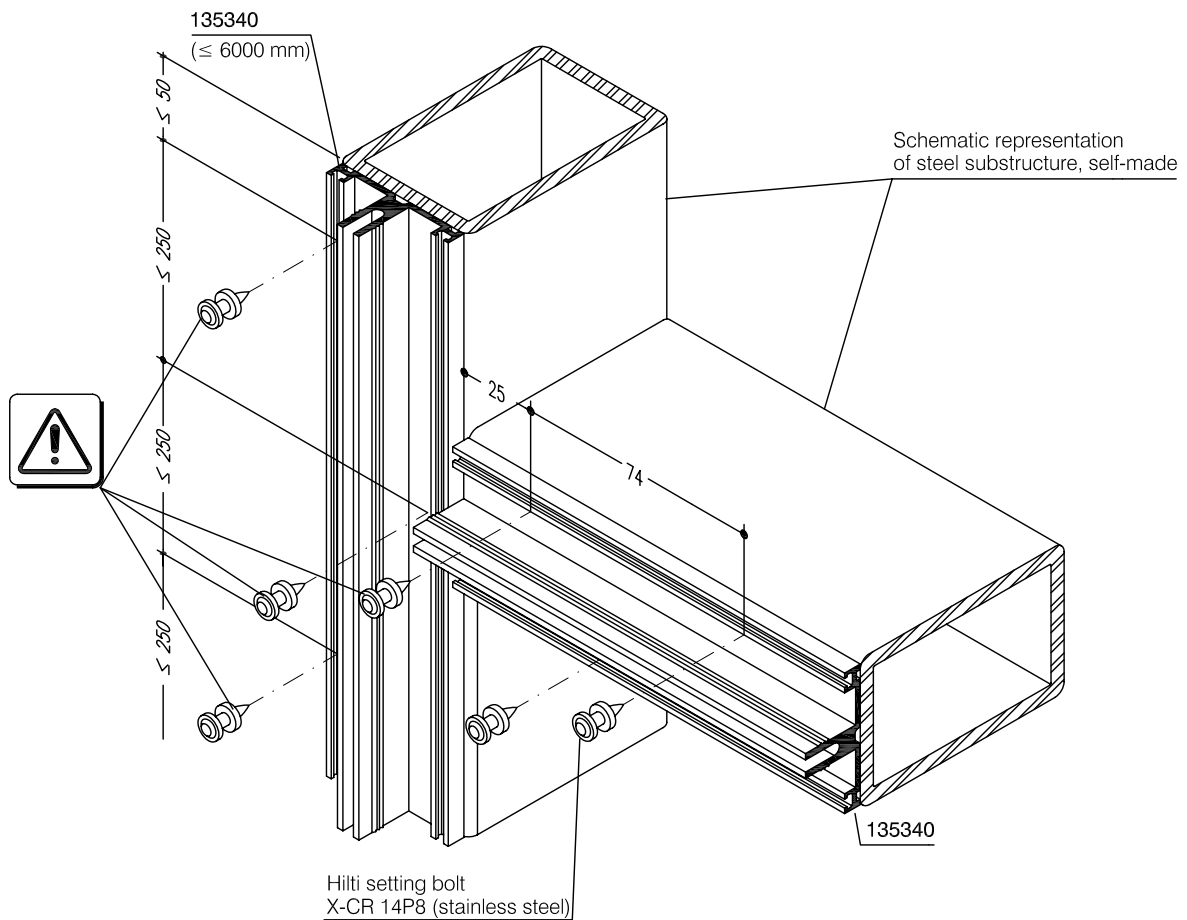
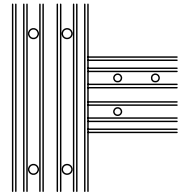
Hilti
Setting bolt
X-CR 14P8

Optional for wind load

WICTEC 50A

Facade

Surface mounted construction on steel tube

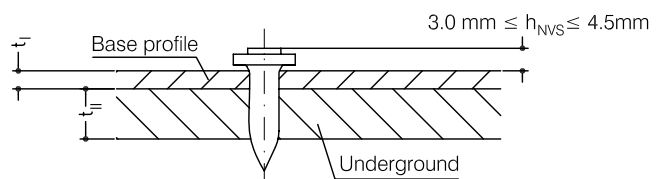


Note:



Setzbolzen mit Hilti Bolzensetzwerkzeug DX 450 auf Profil 135340 mit der Stahlunterkonstruktion setzen.

Setzbolzen durch die Wandung des Profils 135340 eintreiben.
 Vorbohren des Profils an der Eintreibstelle ist nicht erforderlich.
 Gestanzte oder gebohrte Löcher im Aufsatzprofil dürfen nicht verwendet werden.



Protrusion of bolt head (h_{NVS}) should be between min. 3.0 mm and max. 4.5 mm.

WICTEC 50A

Facade

Surface mounted construction on glued wood

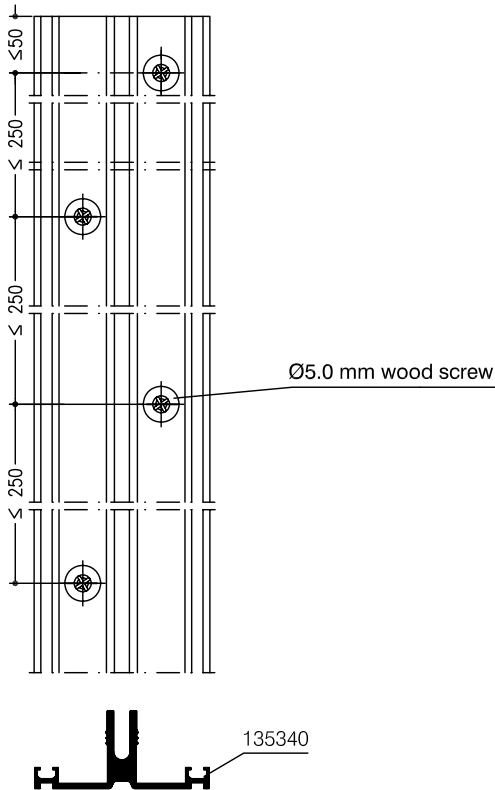
Screws distances

Application: - Ø5.0 mm wood screw, stainless steel. 50 mm thread length in wood.

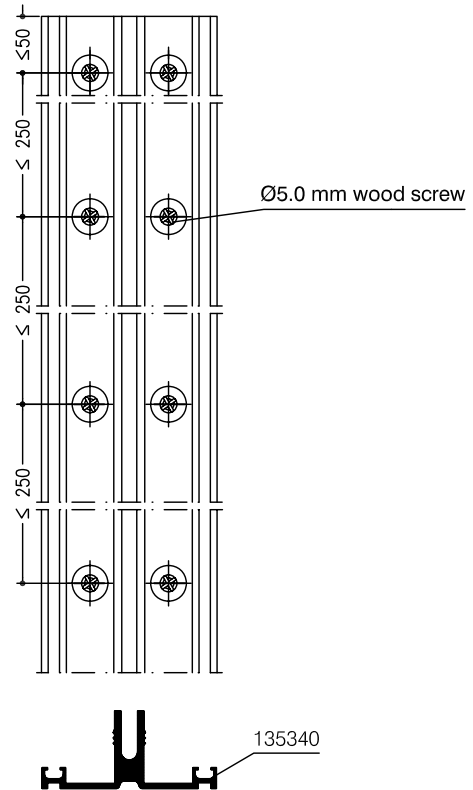
- Predrill Ø4.0 mm in glued wood.

- Predrill Ø6.0 mm in profile 135340.

Standard: Mullion/Transom (Stick construction)



Corner area / TRAV



TRAV = Technical regulations for application of fall-prevention glazings

WICTEC 50A

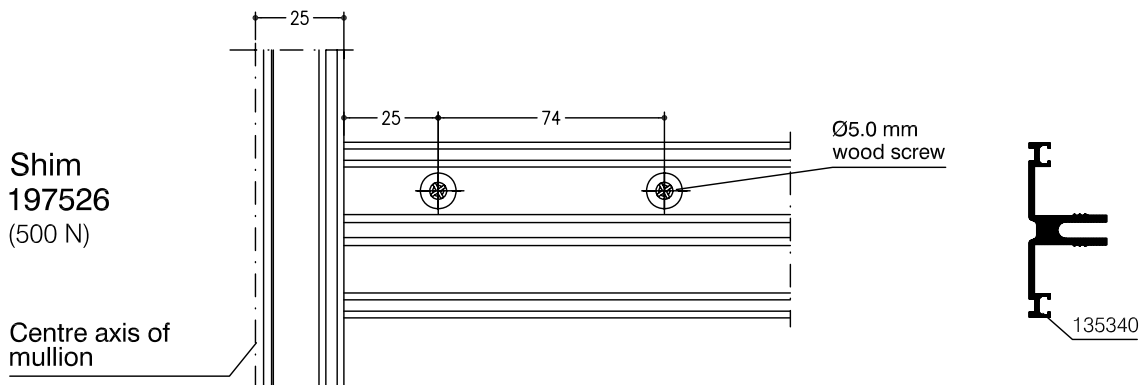
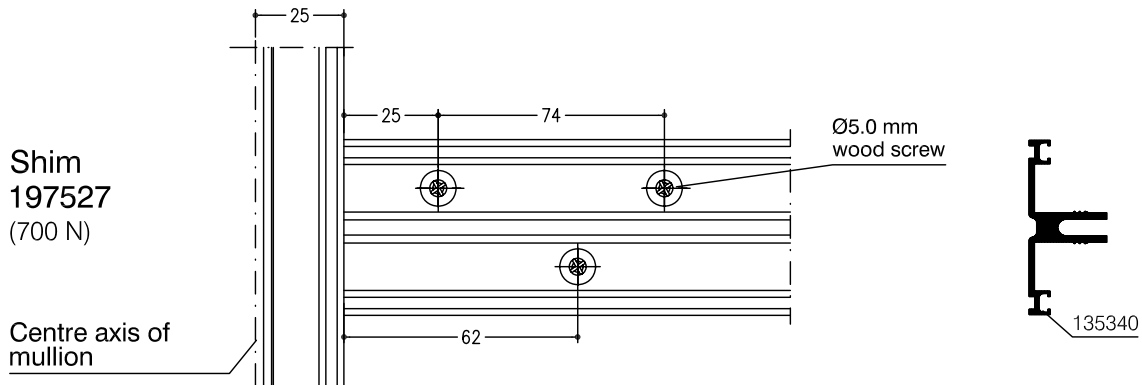
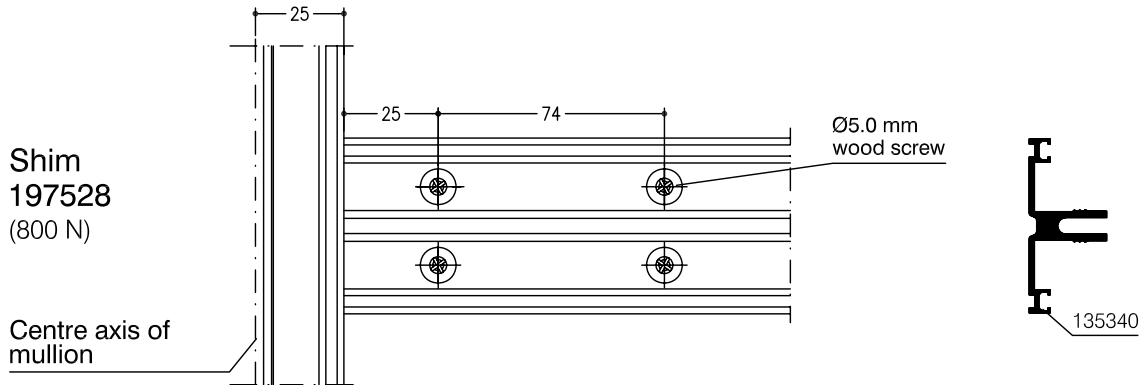
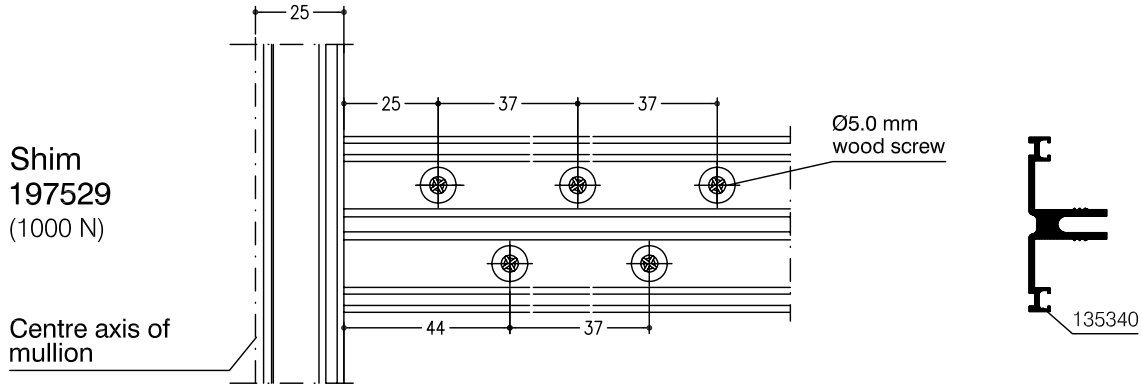
Facade

Surface mounted construction on glued wood

Fixing with screws in area of shim

- Application:
- Ø5.0 mm wood screw, stainless steel. 50 mm thread length in wood.
 - Predrill Ø4.0 mm in glued wood.
 - Predrill Ø6.0 mm in profile 135340.

Fastening for:

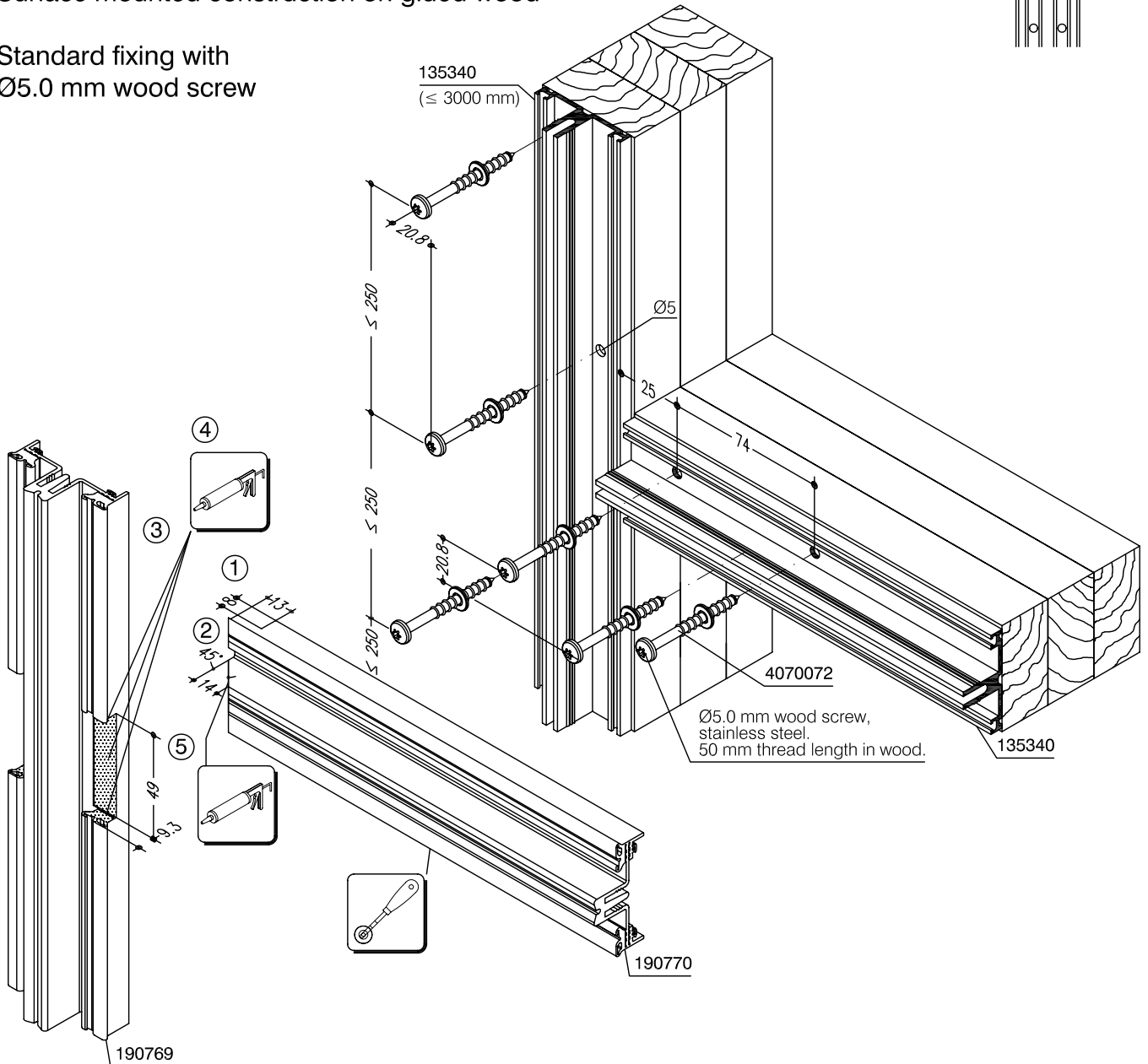
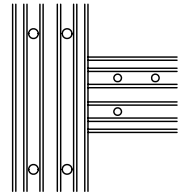


WICTEC 50A

Facade

Surface mounted construction on glued wood

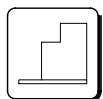
Standard fixing with
Ø5.0 mm wood screw



Processing sequence:

- ① Notch and cut transom gasket 190770 to length with cutting die (matrix) 5060086.
- ② Notch 14 mm x 45°.
- ③ Cut mullion gasket 190769 to length with cutting die 5060086 and notch with notching tool 5040167.
- ④ Seal notchings in mullion gasket all around with sealant.
- ⑤ Seal notching.

- Apply sealant just before mounting infill.



Notching tool:
5060086 ①
5040167 ③



Seal transom gasket 190770
on mullion gasket 190769
with sealing material.



See WICTEC 50P and 50E for assembly of
cover and thermal break part.
Predrill Ø4.0 mm in glued wood.



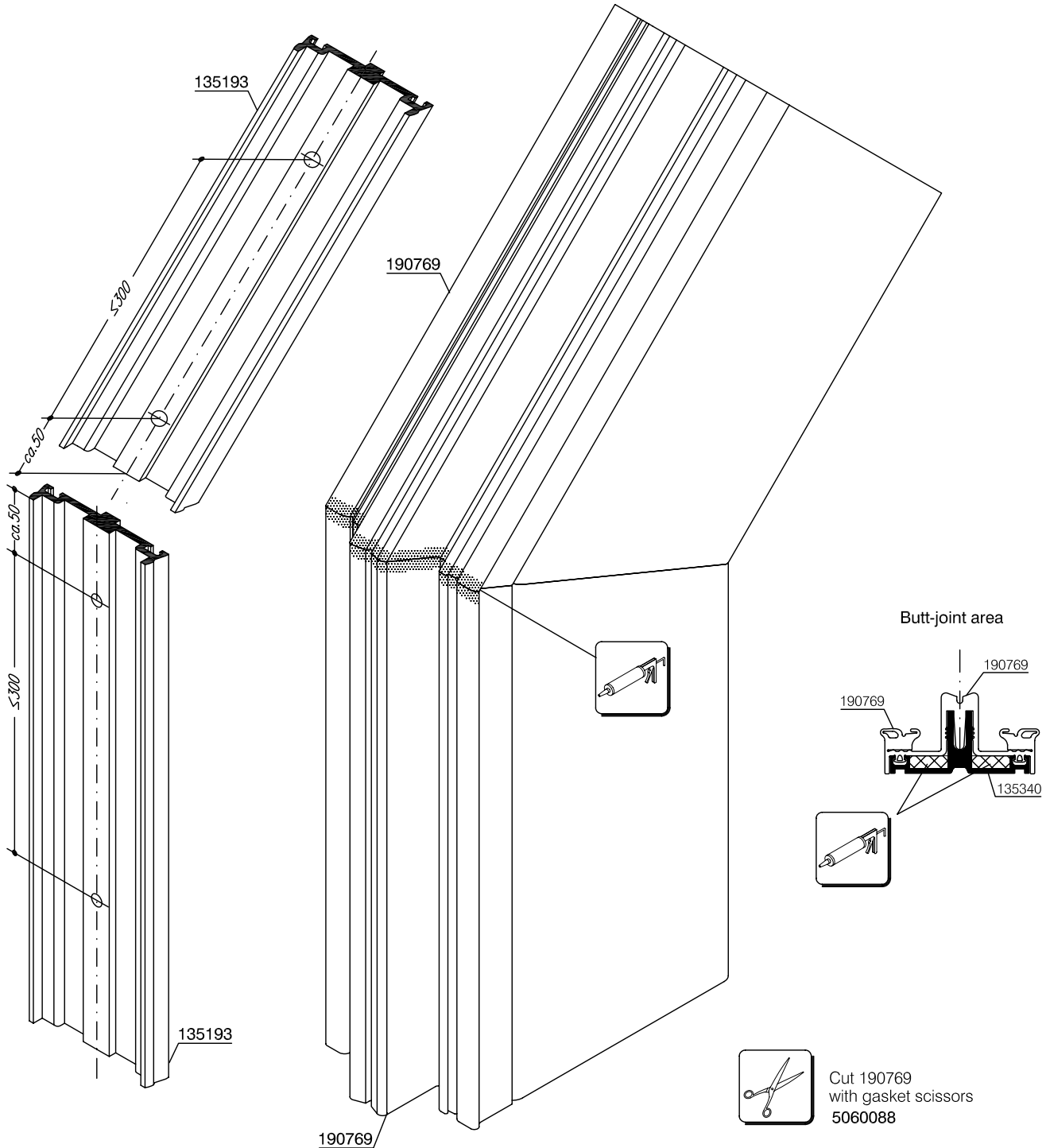
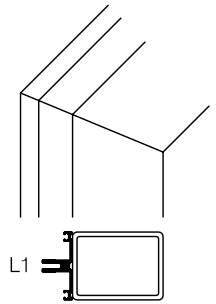
Rolling tool:
5060215



Cutting die:
5060086 ①

WICTEC 50A

Facade
Steel substructure
Angled mullion joint



Cut 190769
with gasket scissors
5060088



Attention:
Clean gasket joint with Primer,
esco no. 92-537705 at first.



Apply durable sealing compound
92-537683 or 92-232009 in joint area.





Hydro Building Systems

Box 120

SE-360 70 ÅSEDA

Sweden

Phone +46 474 480 80

Fax +46 474 102 15

www.wicona.se

Sales office Norway/Iceland

Postboks 153

NO-2831 RAUFOSS

Norway

Phone +47 61 15 91 20

Fax +47 61 15 91 21

www.wicona.no

