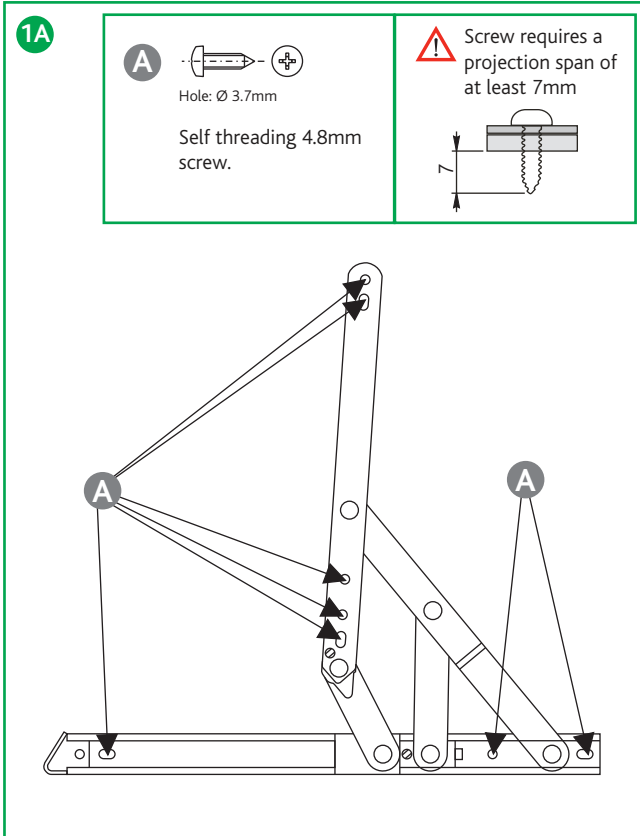


Heavy Duty Type C, Side Hung Friction Stay Fitting Instructions



Notes:

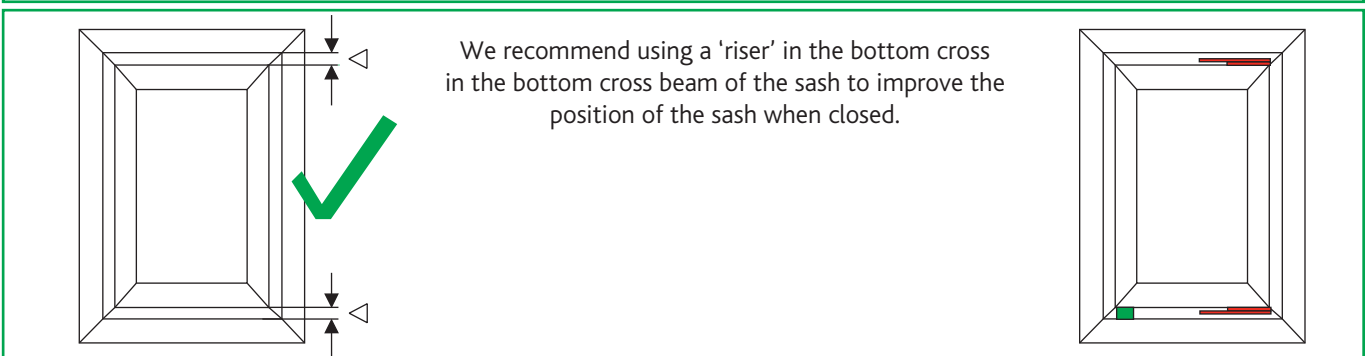
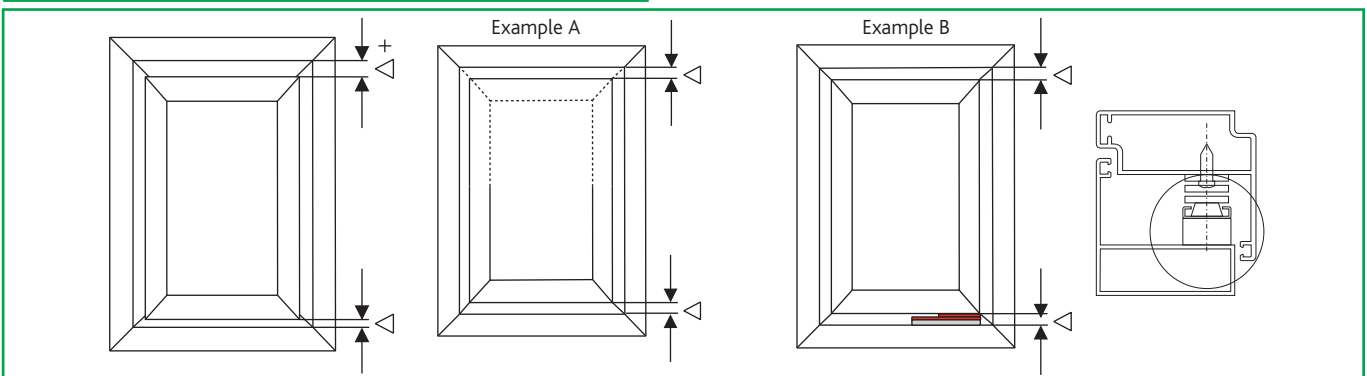
Please note screws are not included. See Fig 1A for the type of screw to use.

Prior to assembling the frame and sash, please ensure any further drilling/ cutting for accessories is completed. When handling or shipping the finished sash, fit rigid shims between the sash and frame to avoid damaging any installed hardware.

To make the sash safer during fabrication please use the limiter. Ensure you do not exceed maximum carrying weights or sash sizes, it is the responsibility of the window manufacturer to check prior to fabrication (please refer to the data sheet for information).

Diameters of the holes are 'indicative' for aluminium thickness's of about 2mm. It is important that the diameter of the hole is determined according to the quality and the thickness of the material on which the arms must be fixed and according to advice from the screw manufacturer.

The pointed arm must be correctly lubricated. It is the responsibility of the window manufacturer to check for any differences between the top and bottom and take action if they are not deemed acceptable. If at the top of the window the Δ is greater than the Δ at the bottom, change the sash / frame sizes (example A) or shim the lower arm (example B).



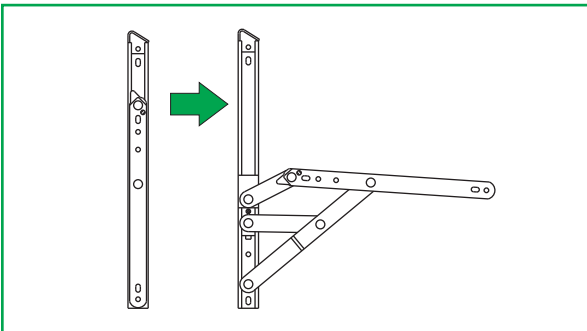
- 1** Check that the sash and frame profiles used are compatible with GS HD Type C stay arms. In particular check that the sash/frame distance ranges from 16.5 to 17mm (Fig 2A). If the frame clearance is > 17mm (>16.5 with arm 10"), the arms must be fitted with a shim of suitable thickness. (Fig 2B).
- 2** Establish the position of the horizontal axis along which the arm will be positioned, so as to ensure correct alignment of the sash when closed. This depends on the type of profile utilised (Fig 3).
- 3** According to the dimensions (height and width in mm) and the weight (in kg) of the sash, select the most suitable GS HD - Type C stay arm. In the event of sash dimensions and weights being at the upper limit, select a larger size.

Never fit stay arms to sashes of dimensions and weights exceeding the limit of the stay.

Installing a Type C Friction Stay

Frame Side: Marking the Slots

Open out the GS HD Type C Stay Arm, holding it at 2mm from the frame (see Fig 1 and using a pencil mark out all the slots). **Do not mark any of the other holes.**



Frame Side: Drilling the frame upright

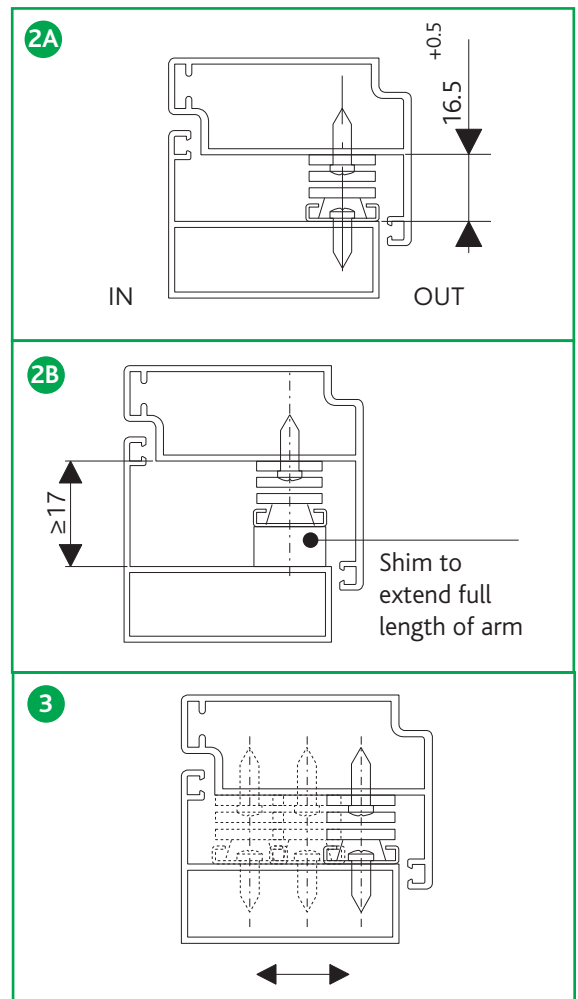
Drill Ø3.7mm holes in the centre of each slot (marked previously).

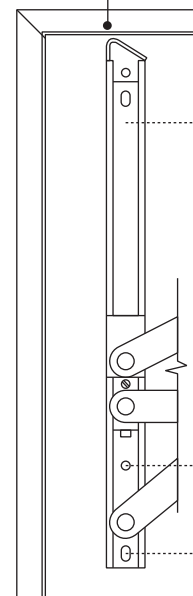



Sash side: Preparing to position the stay arm

Using a pencil, mark distance **A** on the sash side of the arm, where 'A' is the part of the arm that projects from the sash. The distance is calculated as follows:

$$A = X - 2.5$$

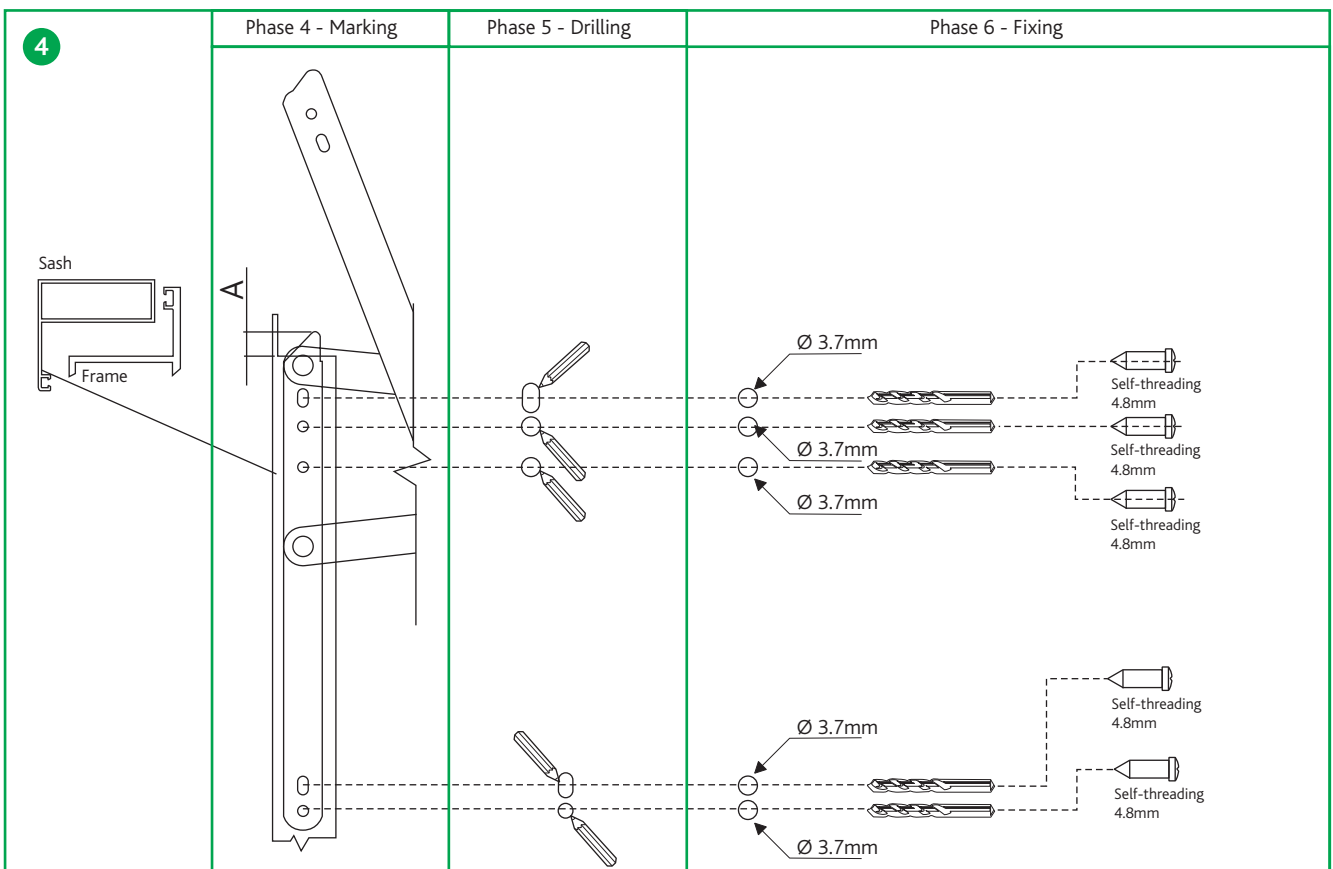
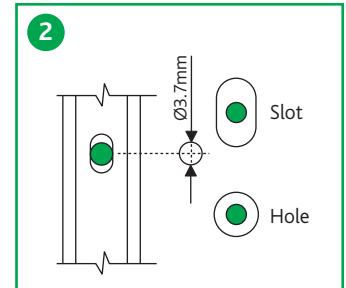
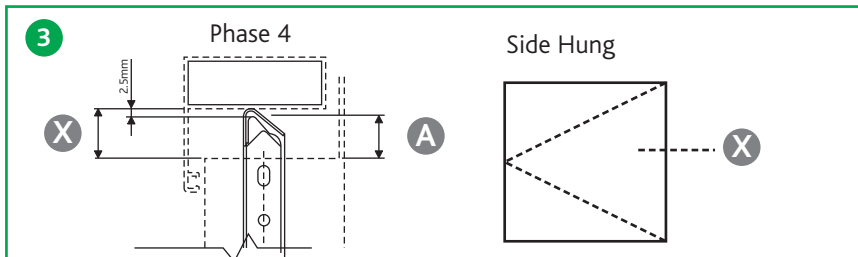
X = sash / frame distance envisaged for the type of profile (see Fig 6)



| 1 | Phase 1 Marking | Phase 2 Drilling | Phase 3 Fixing |
|--------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
|  |  |  |  |
| | | Ø 3.7 Self-threading 4.8mm | Self-threading 4.8mm |
| | | Ø 3.7 Self-threading 4.8mm | Self-threading 4.8mm |
| | | Ø 3.7 Self-threading 4.8mm | Self-threading 4.8mm |

Sash Side: Marking holes and slots

Offer the arm to the sash so that the mark on the main rod is in alignment with the start of the top part of the sash, as indicated in Fig 4. Using the arm as a template, mark out all holes and all slots on the sash side of the arm (see Fig 3).



Sash Side: Drilling the Sash upright

Drill Ø3.5mm and Ø3.7mm holes at the points marked previously (slots and holes). See Fig 4.

Sash Side: Fixing Arm to Sash

Open out the arm and secure it to the sash with the screws (see Fig 4).

Assembly of Sash and Frame

Locate the sash in the frame with the arms open. Check that the holes drilled previously in the frame are in alignment with the slots of the arm.

Frame Side - Fixing the Arm

Secure the stay arms to the frame (See Fig 1).

Frame Side - Adjusting the Sash

Close the sash and check that it is centred, referring to the sash/frame cross sections of the profiles utilised.

Frame Side - Stay Arm friction setting

The amount of resistance in the opening movement can be adjusted, as needed, by turning the screw 'V' on the arm (see Fig 6). Please ensure to balance the friction evenly between the two arms.

