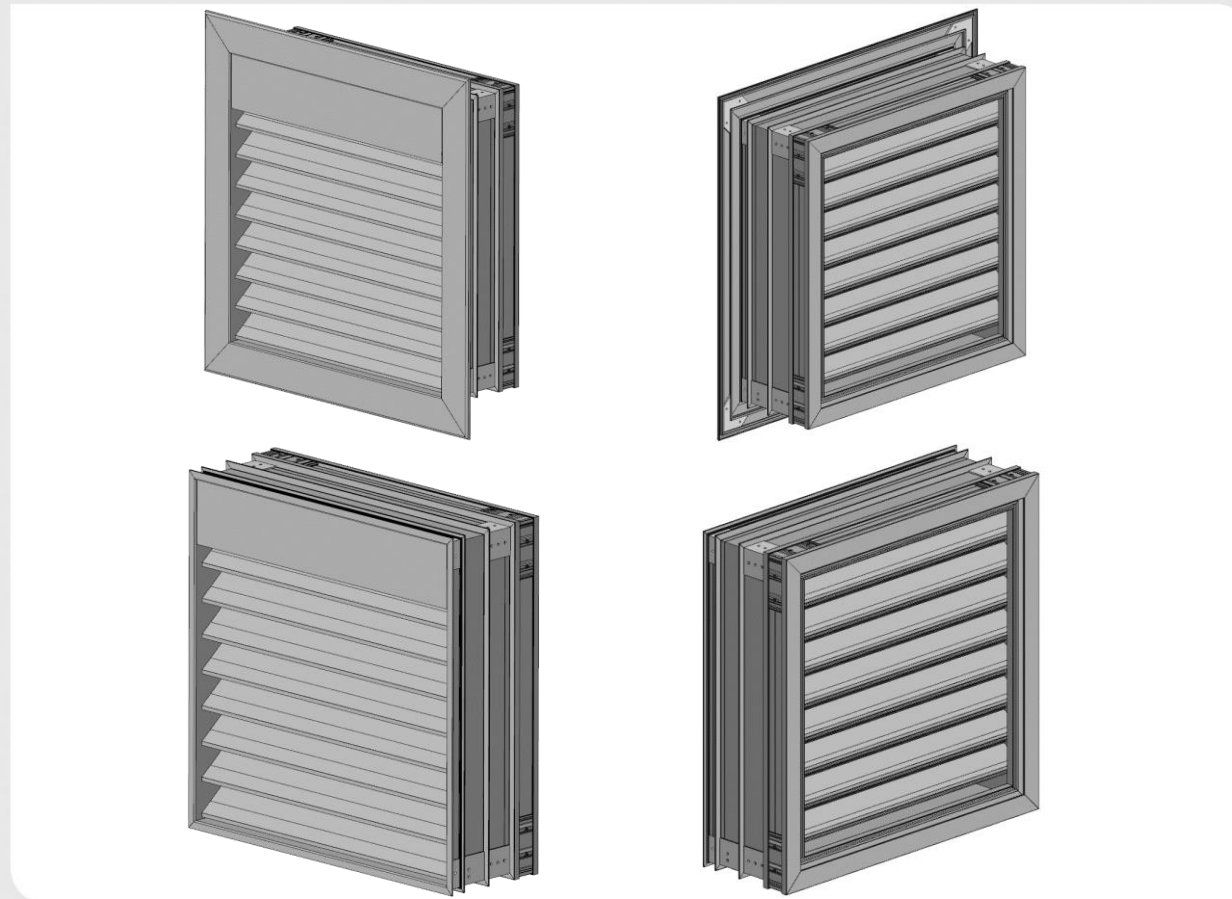


Assembly instructions

DucoGrille Classic 130HP Basic

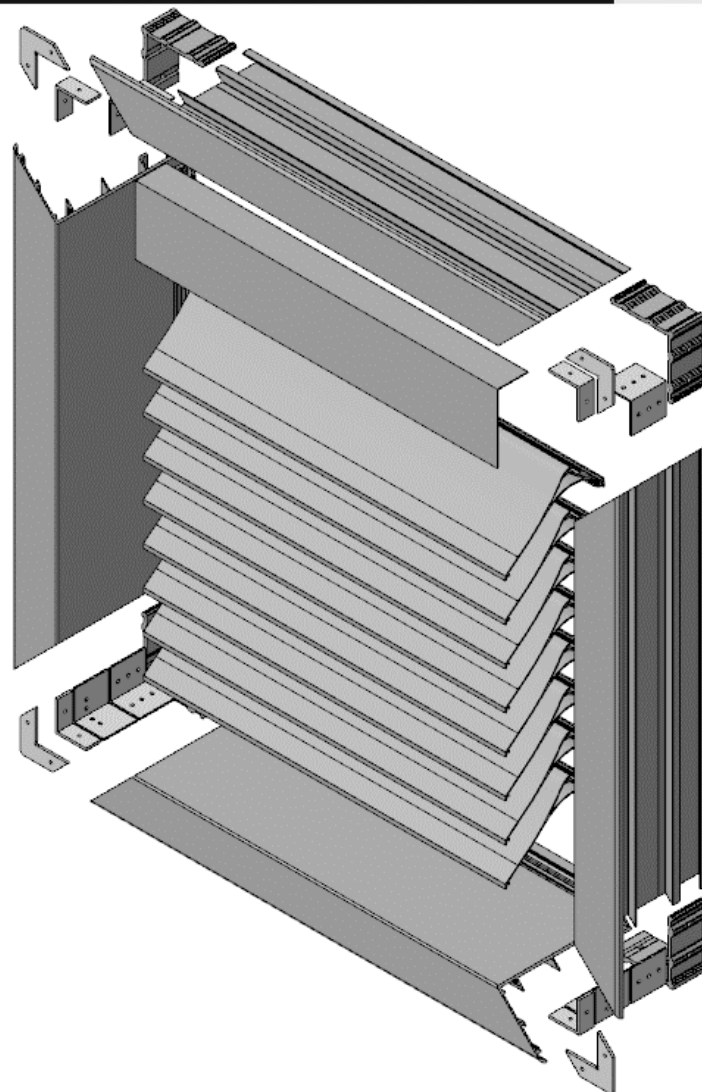
29/11/2022



CONTENT

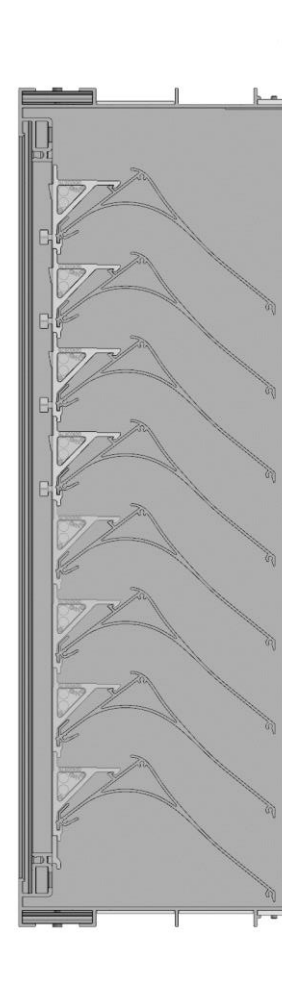
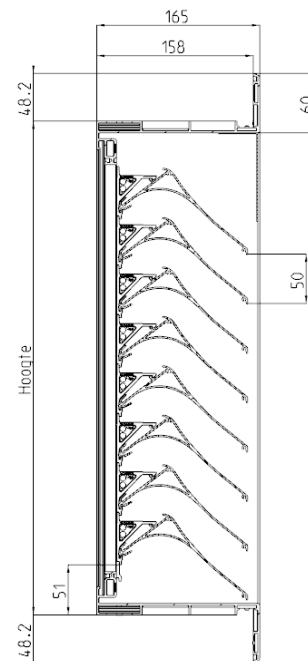
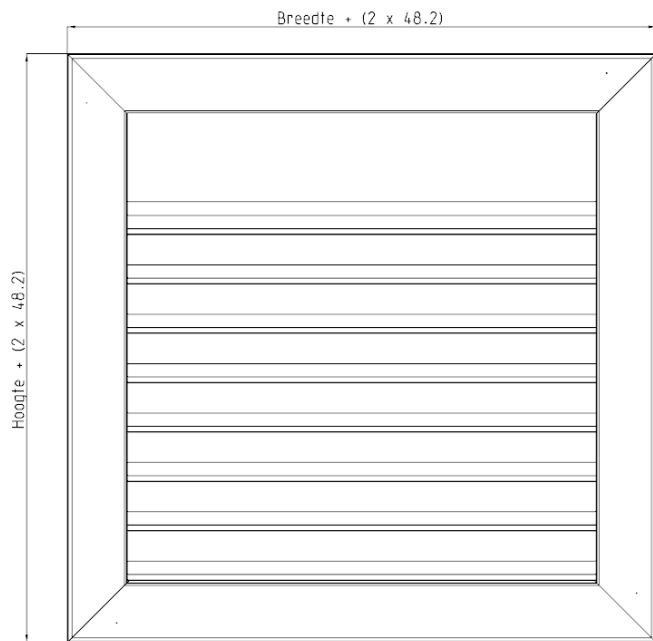
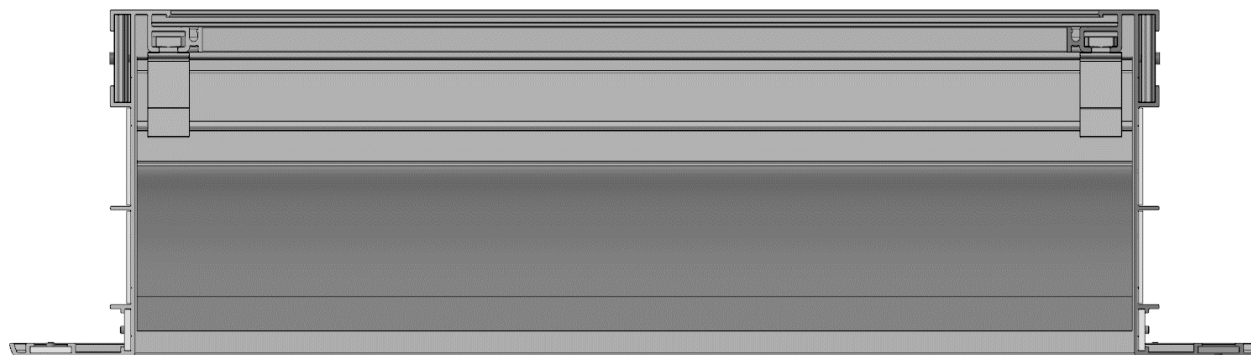
1. Exploded view
2. BOM
3. Components list
4. Assembly
5. Packaging

1 Exploded view



1

Exploded view



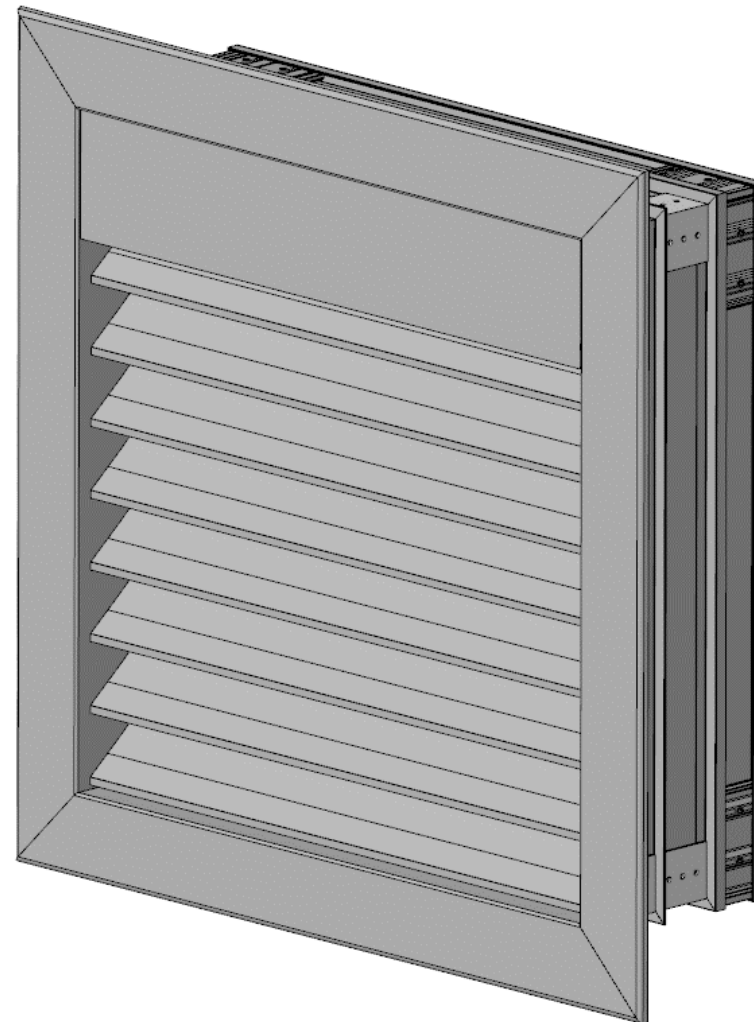
Mesh not shown.
N-frame: overall dimensions = width x height

Width: minimum 250mm
Height: minimum 250mm

Mesh: insect-resistant 2.3x2.3mm
vermin-resistant 6x6mm
bird-resistant 20x20mm

Frame: Fitting frame without flange (N) or
fitting frame with flange (G)

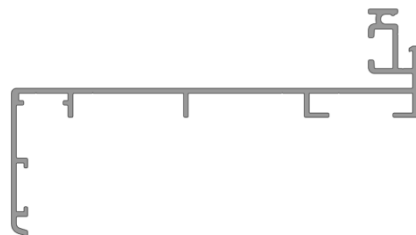
Colour: RAL colour of choice or anodised.



3 Components list

Frame section G 130-150

Number: P1523410



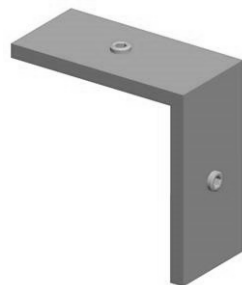
Frame section N 130-150

Number: P1524110



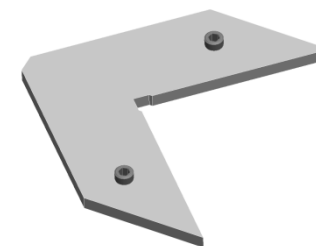
Angle bracket, small

Number: G0009686



Angle bracket flat

Number: G0009685



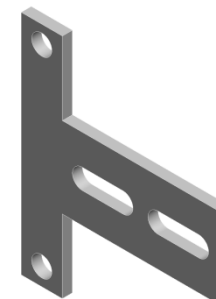
Bracing section 42/12

Number: P1142510



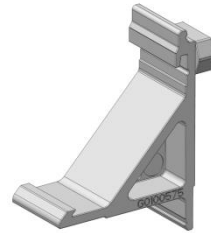
Connecting piece 45/45/2:

Number: P1123710



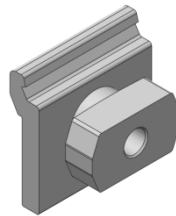
Louvre holder 50HP

Number:G0100575



End-piece for louvre holders

Number:G0009896



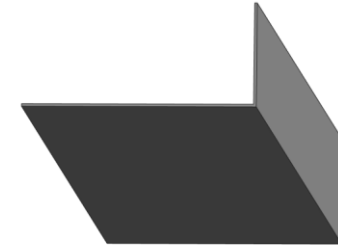
130 HP louvre

Number: P1520310



L- section 90x40x1,5

Number: P1122310



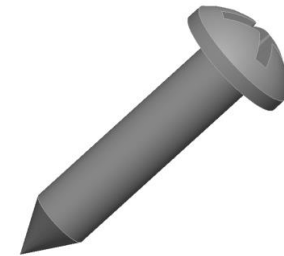
Aluminium blind rivet D4x12

Number: G0000065



Self-drilling screw 3.5x13mm
stainless steel

Number:G0000054



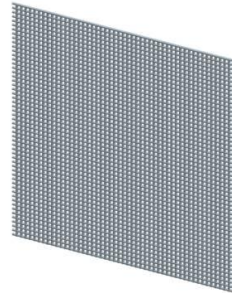
Large fixing dowel (set of 4)

Number: G0009678



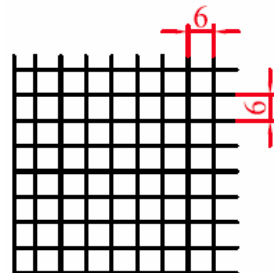
Stainless steel insect-mesh
2,3x2,3mm

Number: G0000800



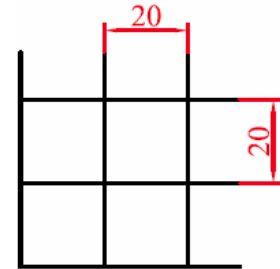
Stainless steel vermin-mesh
6x6mm

Number: G0000810



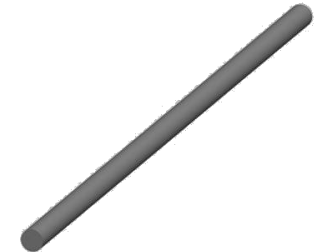
Stainless steel bird-mesh
20x20mm

Number: G0000830



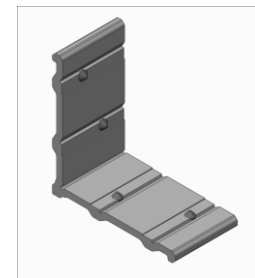
Round cord, 3,6mm dia.

Number: G0004060



Angle bracket, large (F50)

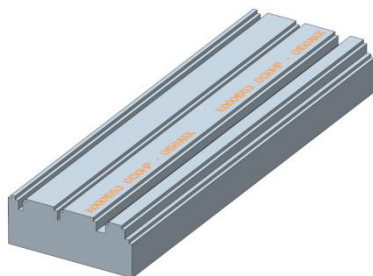
Number: G0009698



3 Components list

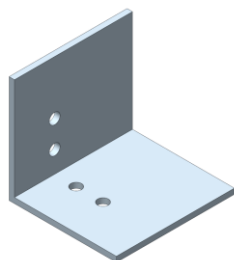
Saw jig G130HP

Number: K0001553



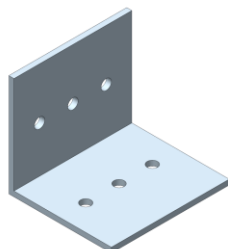
Angle bracket 44

Number: G0100791



Angle bracket 46

Number: G0100792



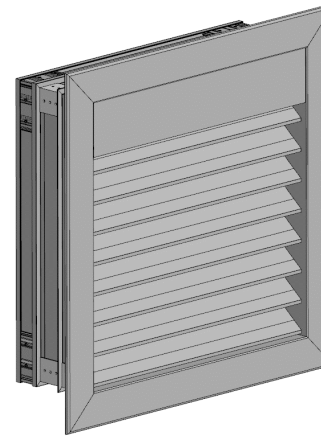
Preparation

This instruction will explain how to assemble a G 130HP (flanged) frame, it also applies to the construction of a N 130HP (flush-mounted) frame.

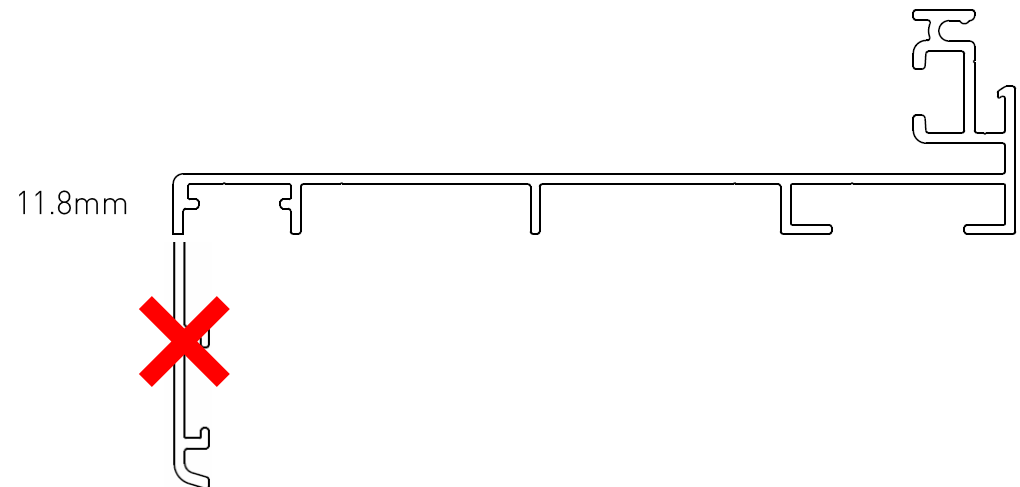
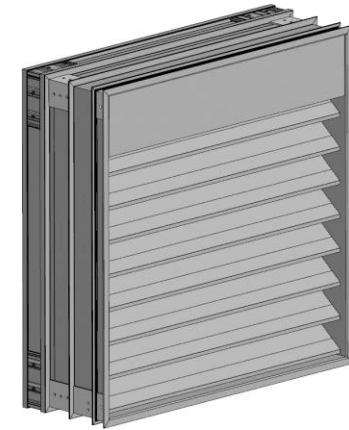
The Assembly for an N-frame (flush-mounted) is identical to that of a G-frame with the exception of that flat angle brackets (G0009685) are not used.

See below: Assembly step 6.

G - Frame



N - Frame



- Step 1:

Generate the parts and cutting list with the calculation program

- Step 2:

Collect the components required.

- Step 3:

Have all parts pre-painted.

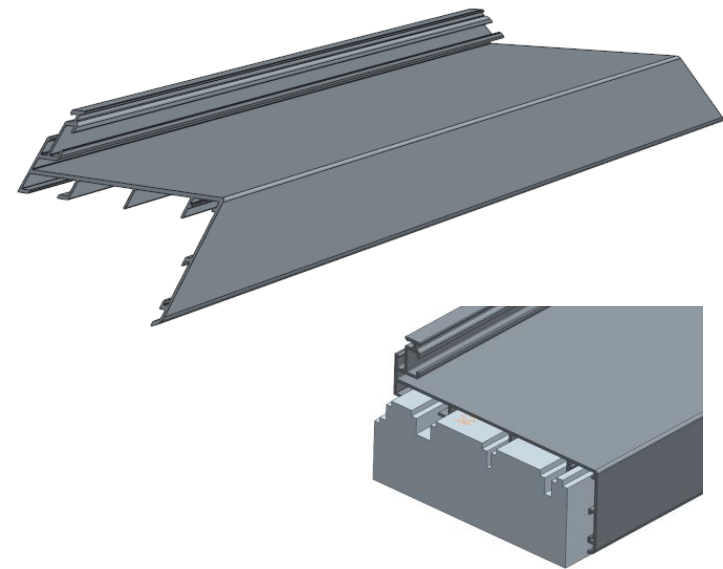
Please note: mounting holes have to be made in the short lip of the L-section so it can be hung up correctly in the paint shop, no mounting holes may be placed in the longer lip.

- Step 4:

Cut sections according to the required dimensions.

Pay attention to the mitre cuts.

Use sawing jig K0001553.



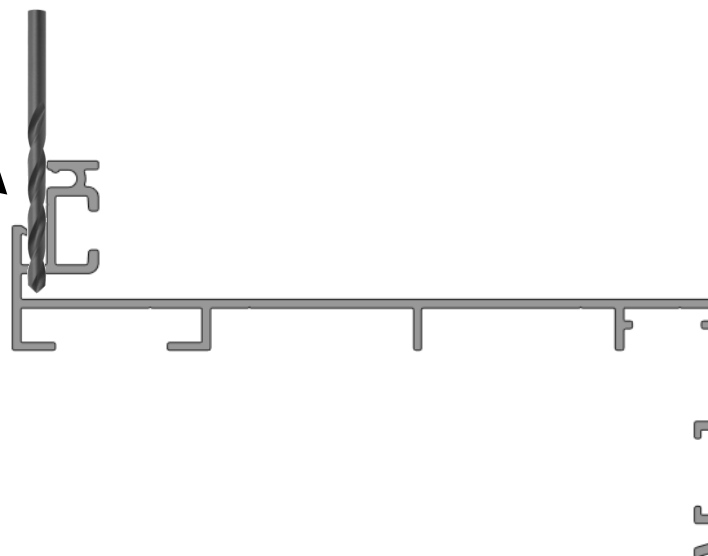
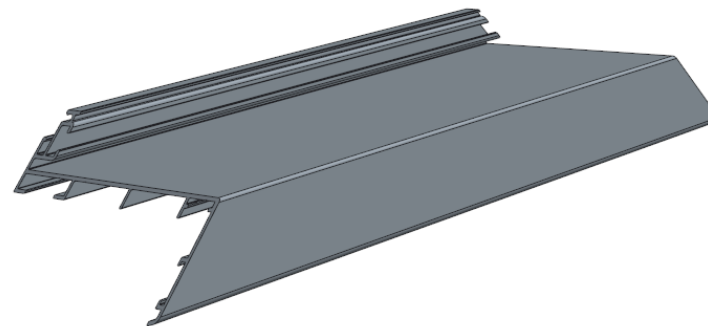
- Step 5:

Take the frame section (P1523410 or T152320) that is to be used at the bottom.

Drill drain holes as shown on the right.

Use a 4mm bit and make sure that only one wall is pierced.

Drill a hole approximately 20mm from each end. Then drill extra holes so that there is never more than 300mm between them



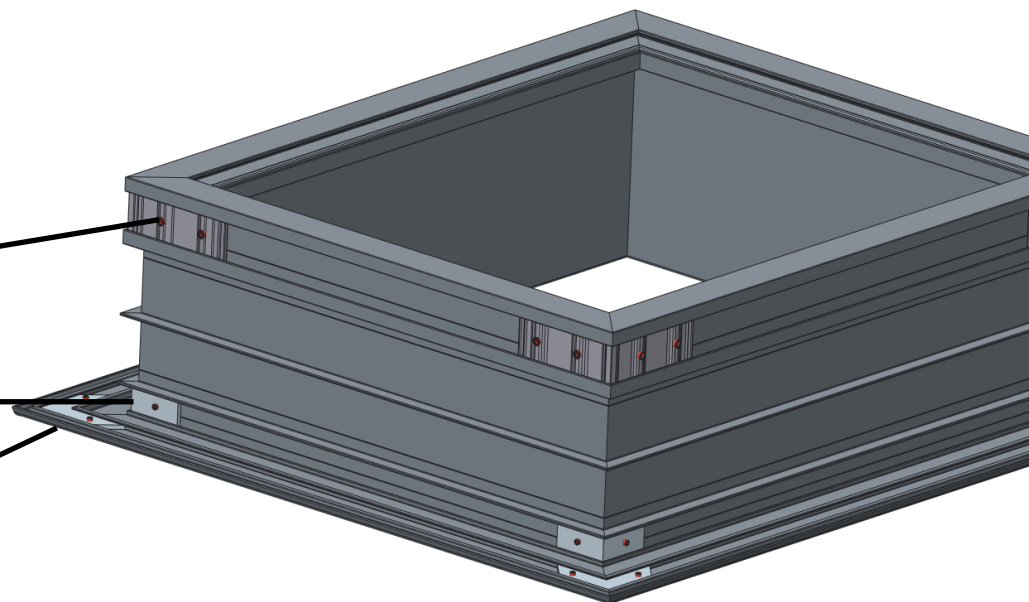
- Step 6:

Assemble the 4 frame sections using:

Large angle brackets F50 (G0009698)

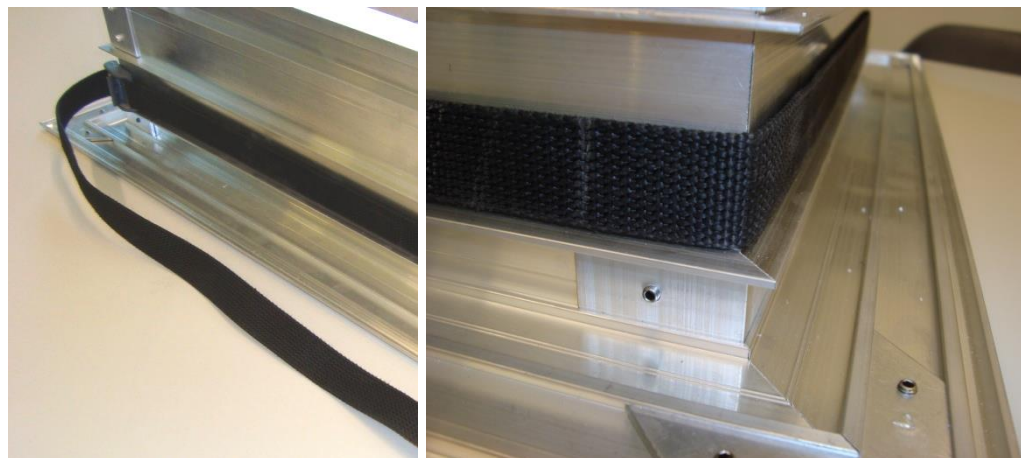
Small angle brackets (G0009686).

Flat angle brackets (G0009685) are also needed for G – flange frames.



- Step 7:

Secure the framework using a belt until there are no more visible openings in the corners.



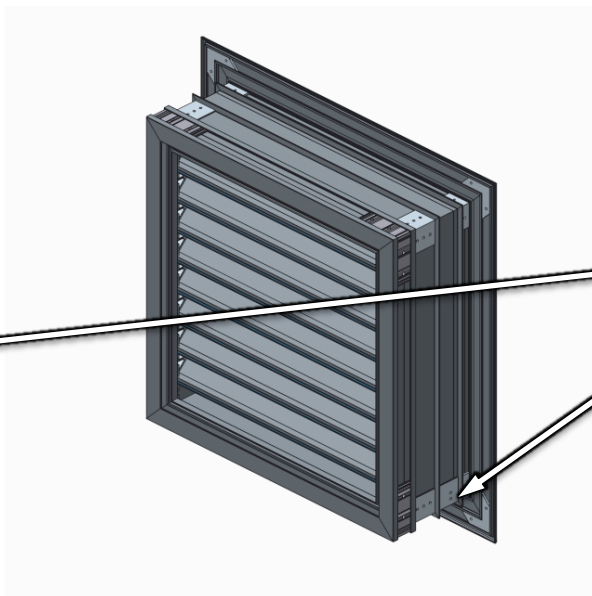
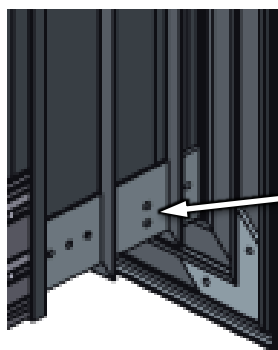
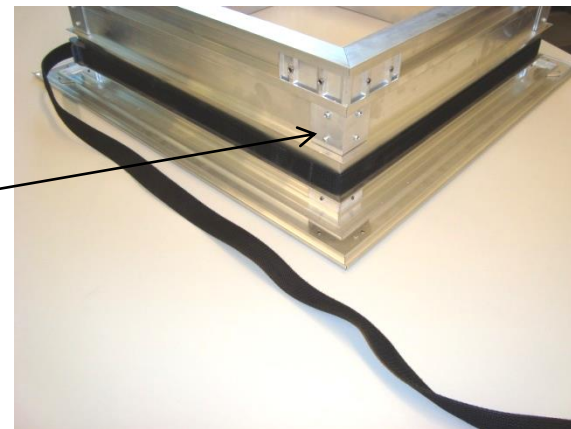
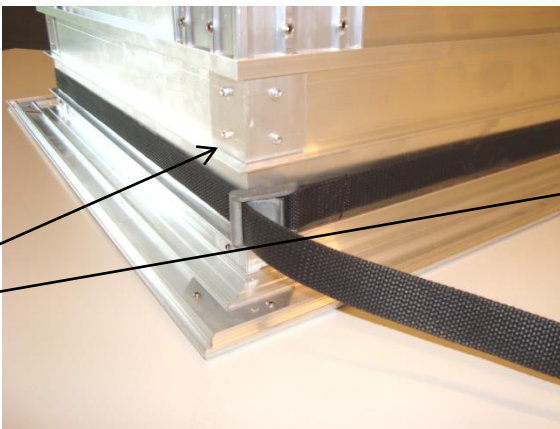
4

Assembly

- Step 8:
Use four angle brackets 46 (G0100792).

Place the angle brackets 46 on the four corresponding corners.

First pre-drill with a bit of 4mm.
- Use the outer holes to drill.
Then rivet the angle brackets.



- Step 9:
Release the belt.

Take two angle brackets 44 (G0100791)

Place the angle brackets 44 on the bottom frame,
positioning them with the holes as close as possible
to the flanges.

First pre-drill with a bit of 4mm.

Rivet the whole.

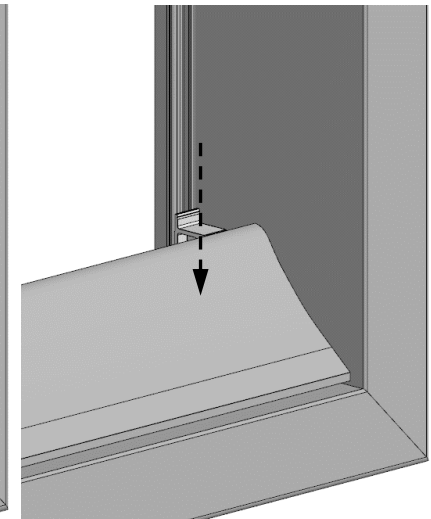
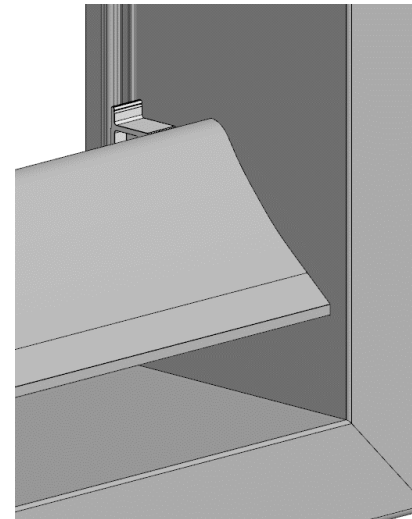
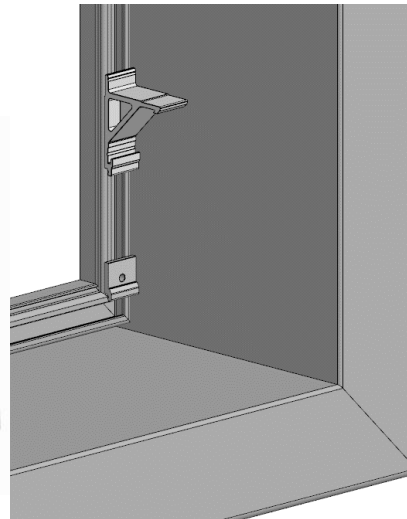
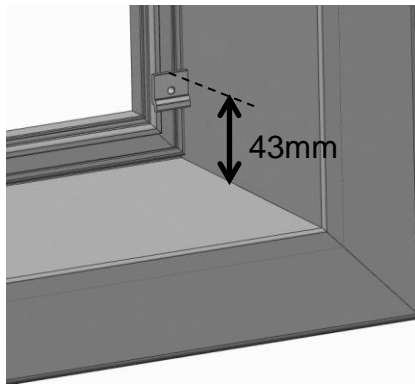
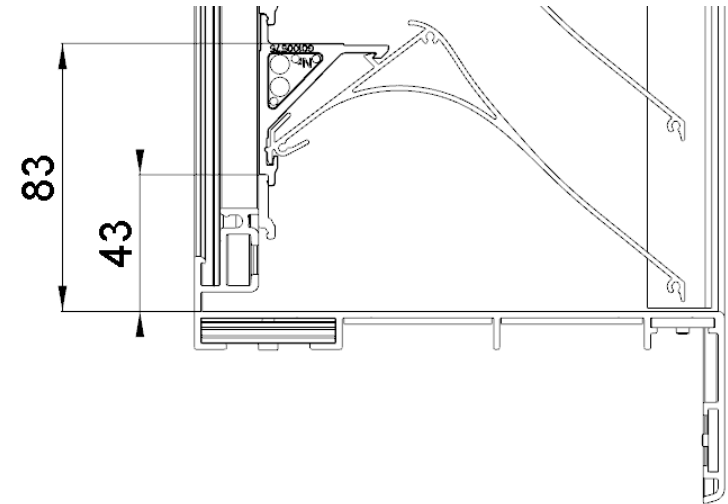
- Step 10:

Mount the endpiece left & right at 43mm. Place a 50HP clipholder G0100575 ± 20 mm above both end pieces.

Doing so be aware that the louvre holders are placed upside down compared to a 50HP assembly.

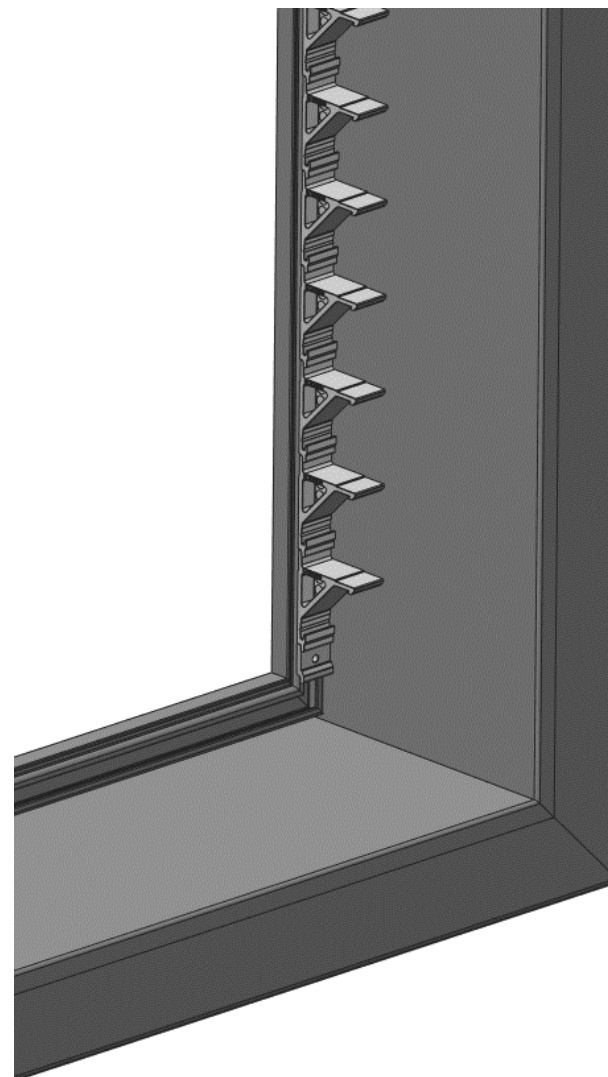
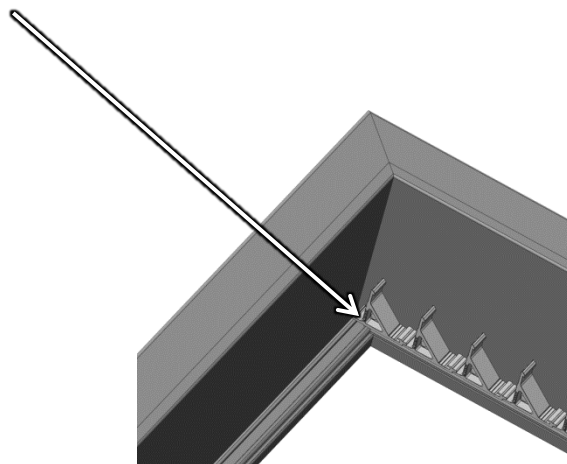
Clips a 130HP louvre in

Slide the clip with the blade downwards into the end pieces



- Step 11:
Fill the entire left and right side, slide all clips together well.

Also screw on the top clip with a self-drilling screw 3.5x13 to secure it.



- Step 12:

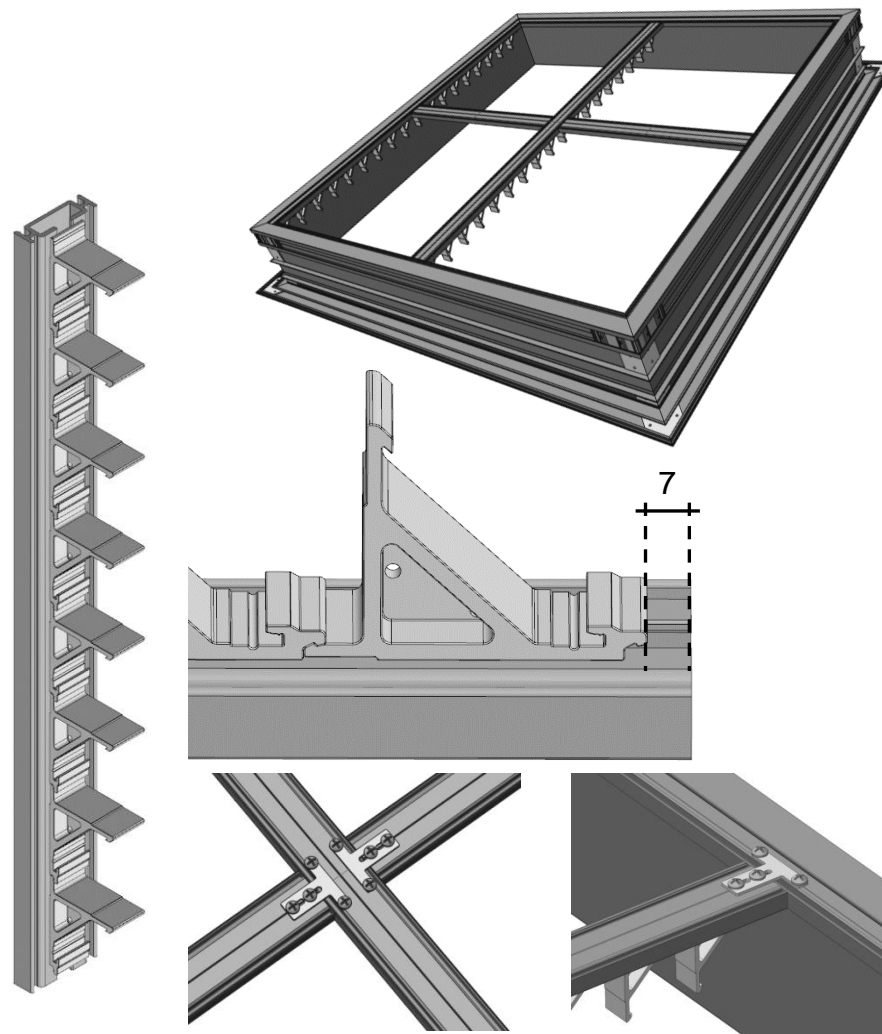
When width and/or height exceed 800mm, intermediate bracing has to be placed.

When both width and height exceed 800mm, as well horizontal as vertical bracing is needed. Vertical bracing is placed over the full height while horizontal bracing is placed in between them.

Take the vertical bracing sections (42/12 support section P1142510) and fit a full row of 50HP louvre holders.

Place the first clip at 22mm from the bottom of the profile. Drill it with a self-tapping screw 3,5x13 (G0000054).

Use T-shaped connecting pieces (P1123710) to fasten the support sections to the frame and to one another using self-drilling screws 3.5x13 (G0000054).



- Step 13:

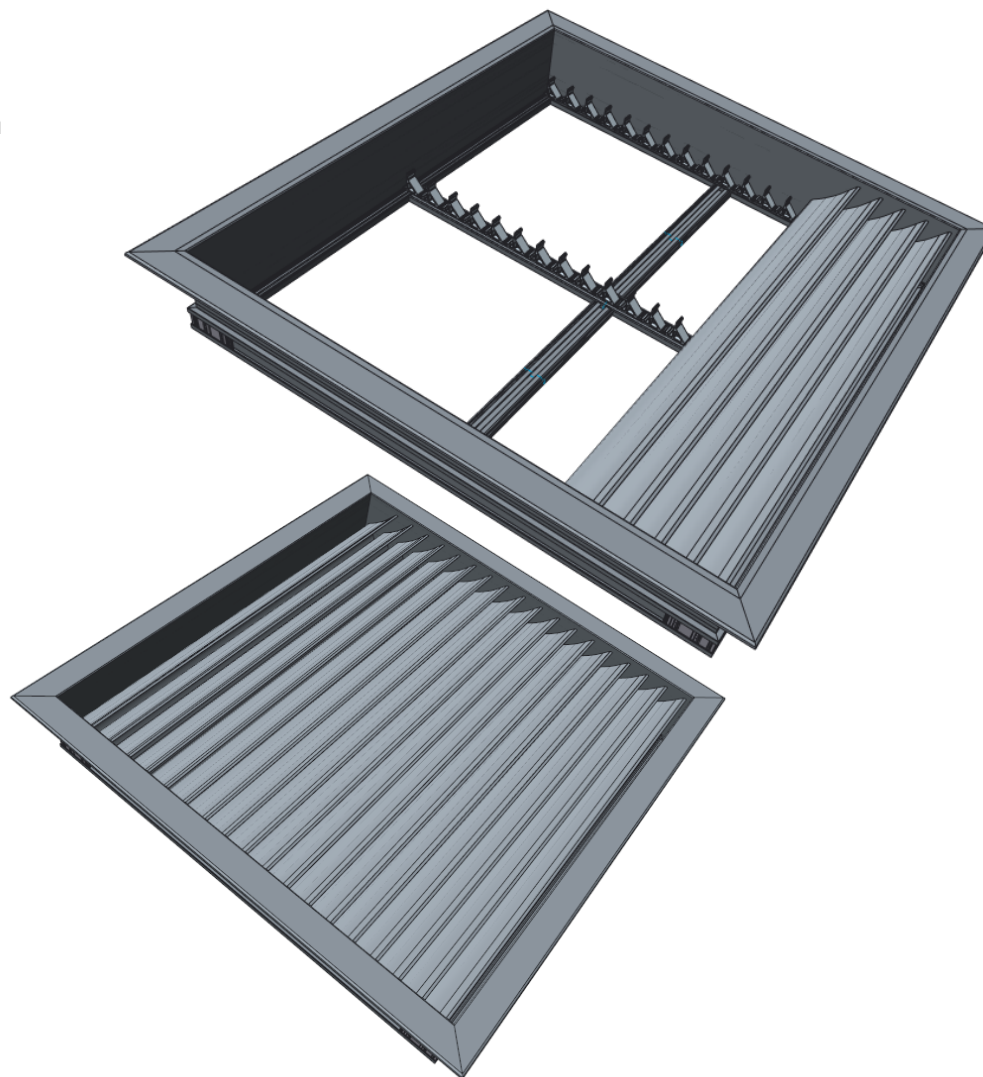
Take the 130HP louvres (P1520310) and click them securely onto the louvre holders.

Start from the bottom and work upwards.

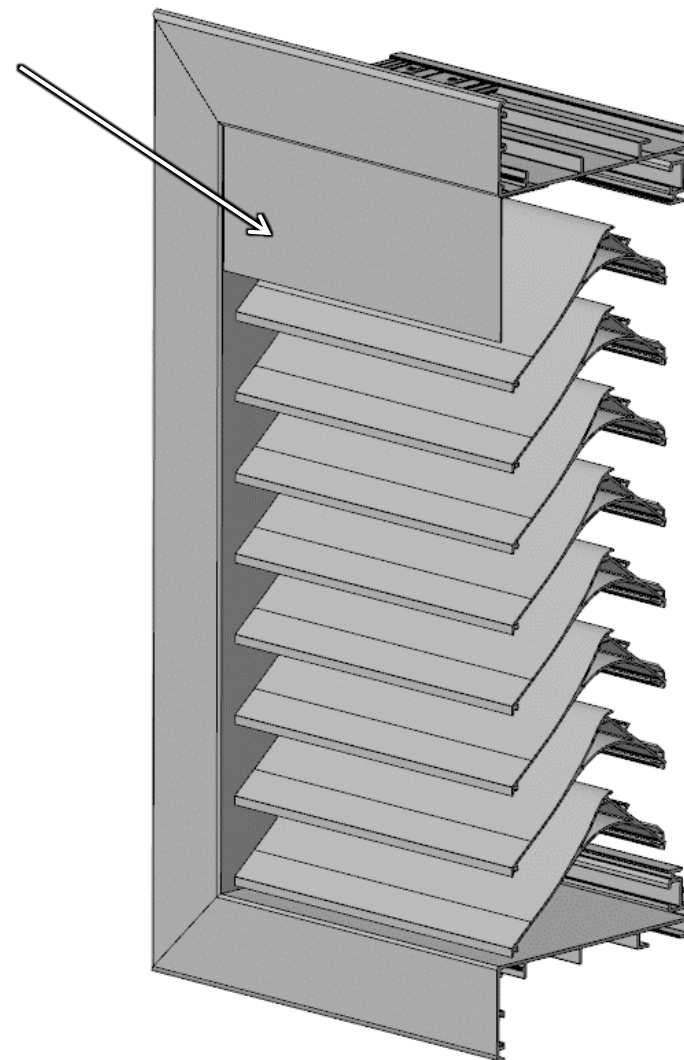
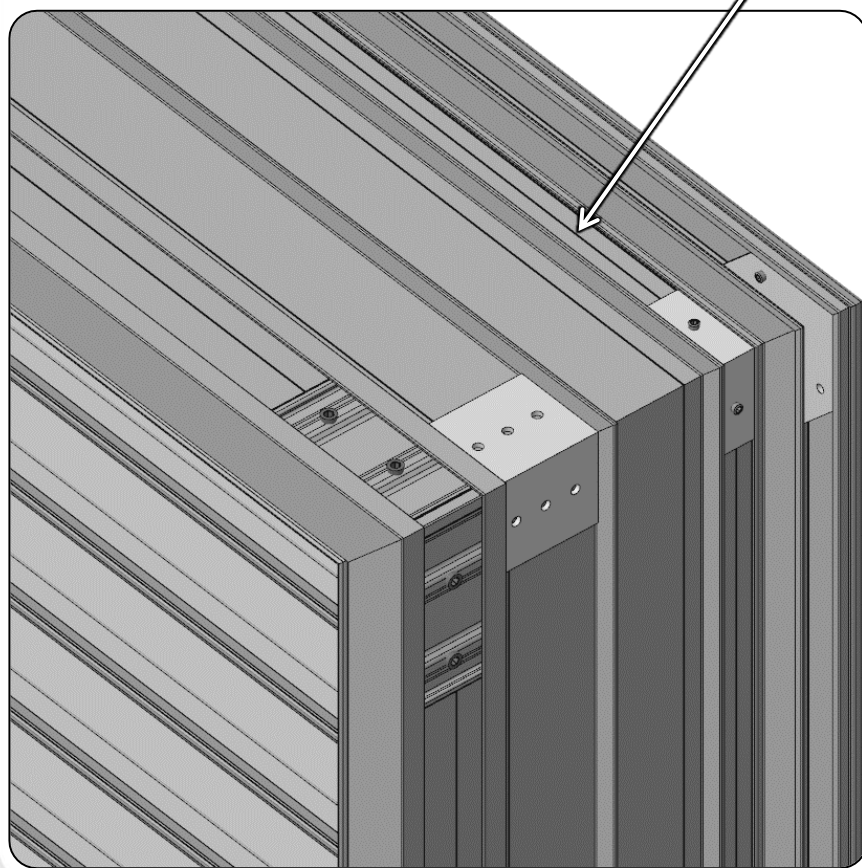
Once the louvre is set to hang horizontally centred there will be a clearance of 2.5mm between the louvres and the frame section on either side.

-Step 14:

Take L-profiles 90x40x1.5 (P1122310). Cut it to the length indicated in the calculation file



- Step 15:
Place the L-section (P1122310) above the top louvre in the frame.
Fasten it with rivets every 800mm, with a minimum of 3 fixing points.
Drilling and fastening positions as shown below.



5 Packaging

Packaging

Standard louvres are supplied packed in HDPE blown film. The blown film is 100 mm wider than the height of the louvre.

Where the height or the width is less than 700 mm, items are packed in blown film.

Where the height and the width are more than 700 mm, items are bubble wrapped for shipment.

Each louvre has a logo on the far left of the of the topmost frame profile.

Packaging Identification

Each standard louvre has a label on its blown film stretch wrap.

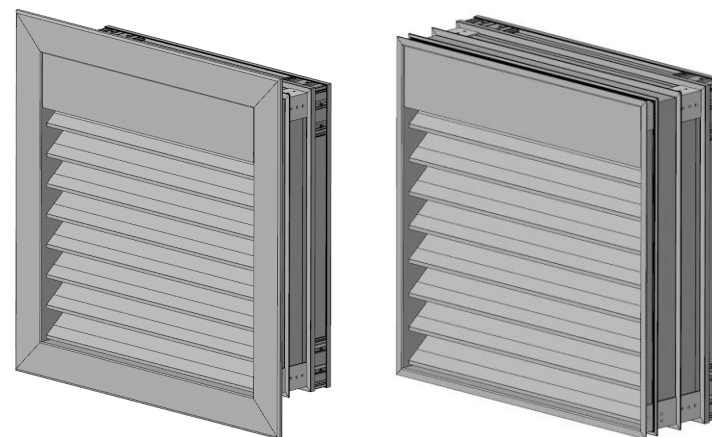
The label contains the following information :

Name of the louvre

Dimensions

Colour

Bar code



In addition, boxes or packaging units (of a number of louvres) have a large standard label sticker affixed to them containing the shipping address and the packaging contents.

Made-to-order products have a standard label affixed to the packaging for each louvre.

Tabel 5													
Aantal pakketjes van doken volgens Hoogte en breedte													
Hoogte rooster	Lengte rooster	0	<1000	1000	<2000	2000	<3000	3000	<4000	4000	<5000	5000	<6000
		0	<500	1		2		3		4		4	
500	<1000	1		2		3		4		4		5	
1000	<1500	2		3		3		4		5		6	
1500	<2000	2		3		4		5		5		6	
2000	<2500	3		4		4		5		6		7	
2500	<2800	3		4		4		5		6		7	