

# Installation instructions

for curtain wall system

# ALTF50

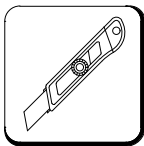
2023

[www.alutech-group.com](http://www.alutech-group.com)





Press on



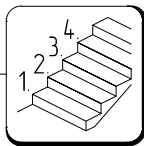
Cut with a knife



Tightening torque



Unscrew



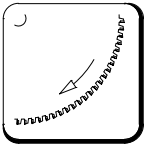
Step-by-step



Attention



Can be replaced



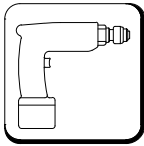
Cut



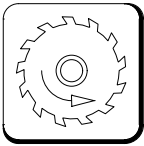
Illbruck OT015



Perform the indicated operation



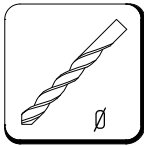
Screw in



Mill



Clean the surface



Drill



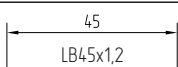
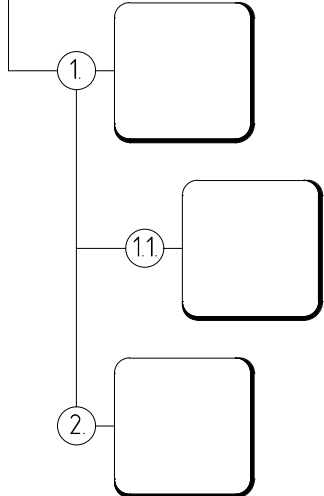
COSMO HD-100.412



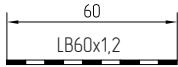
Cut/Scissor out



Use a wrench

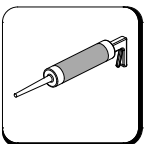


ALUTECH facade tape  
Tape length – 15 m  
Qty in pack – 60 m



ALUTECH facade tape  
Tape length – 15 m  
Qty in pack – 60 m

Waterproof self-adhesive tape on the base of butyl rubber, ready to use, which does not require any special tools. Sealing surfaces of the glass units should be cleaned and degreased. For degreasing it is recommended to use isopropyl alcohol or toluene and two cloths (one to remove dirt and grease and the other to wipe the surface dry). The tape should be glued tightly along its entire length, with overlapping joints.  
Standard tape thickness: 0.8 mm  
Application temperature: +10 °C... +40 °C (min –15 °C)  
Operating temperature: –40 °C... +80 °C.



COSMO HD-100.412  
Cartridge 310 ml

COSMO HD-100.412 is a resistant to aging and weatherproof sealant. It is used for gluing rubber gaskets, sealing profile joints, drainage spout and plug fitting areas, etc. Use COSMO CL-310.110 before applying on coated profiles. Use COSMO CL-300.150 cleaner to remove fresh, uncured mass from surfaces and tools.  
Application temperature: +5 °C... +40 °C  
Operating temperature, –40 °C... +100 °C

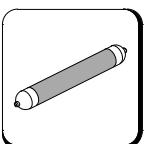


ALUTECH metallized tape  
Tape length – 15 m  
Qty in pack – 60 m



Not recommended for clamp bar profiles

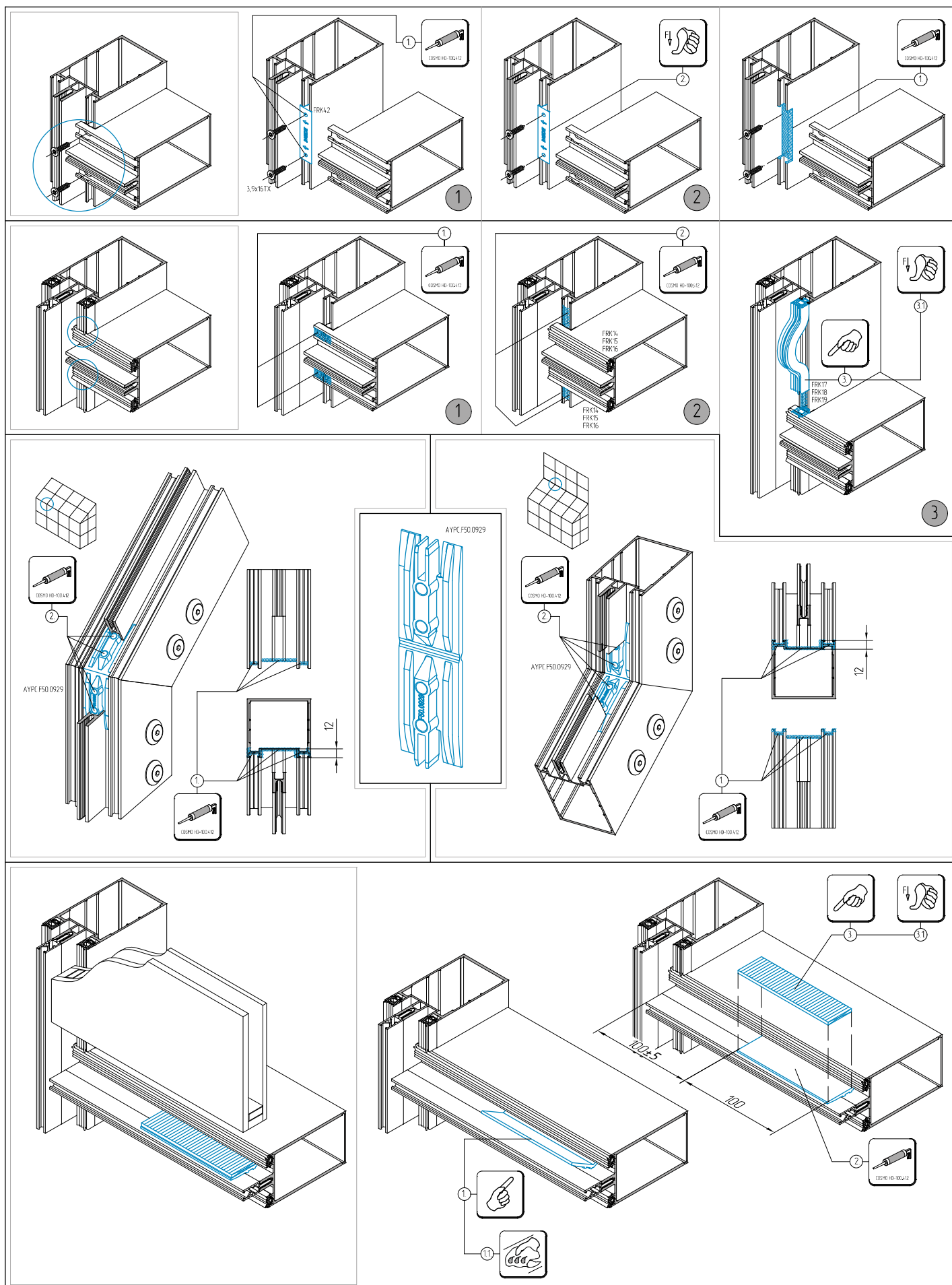
ALUTECH facade tape is a waterproof self-adhesive tape on the base of butyl rubber, ready to use, which does not require any special tools.  
The tape should be glued tightly along its entire length.  
Standard tape thickness: 0.8 mm  
Application temperature: +10 °C... +40 °C (min –15 °C)  
Operating temperature: –40 °C... +80 °C  
Attention! Not recommended for clamp bar profiles.

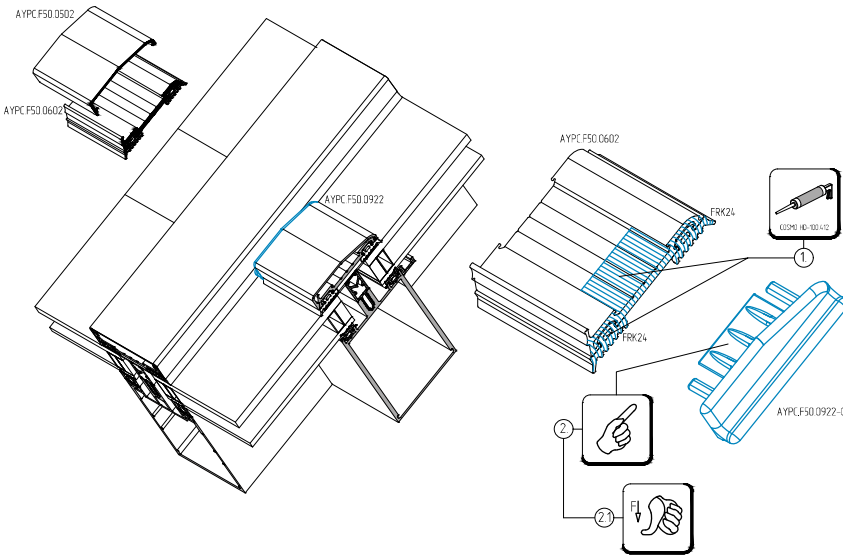
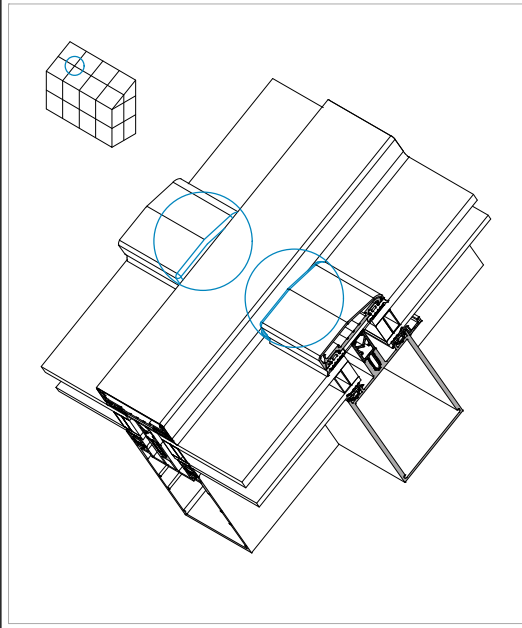
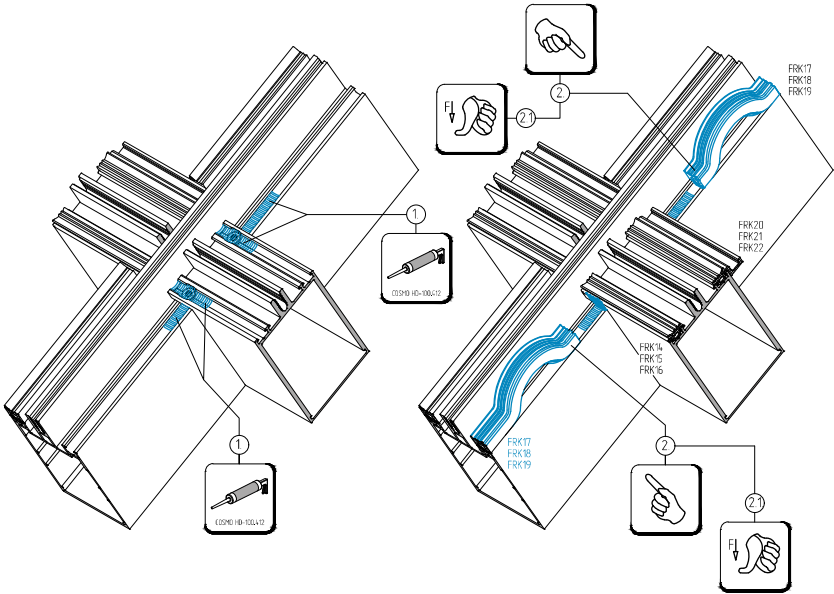
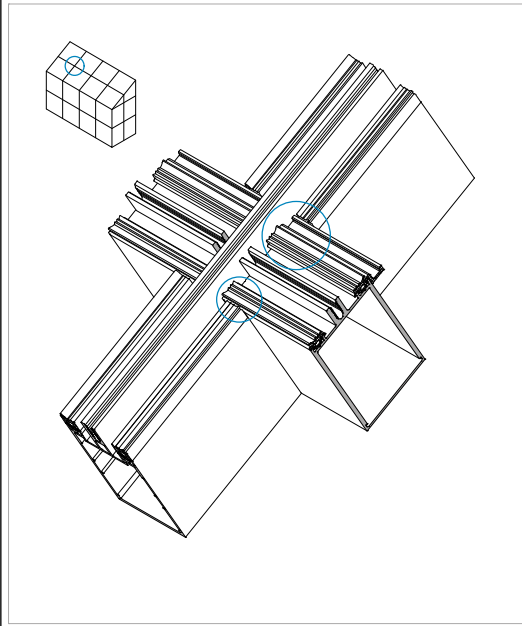
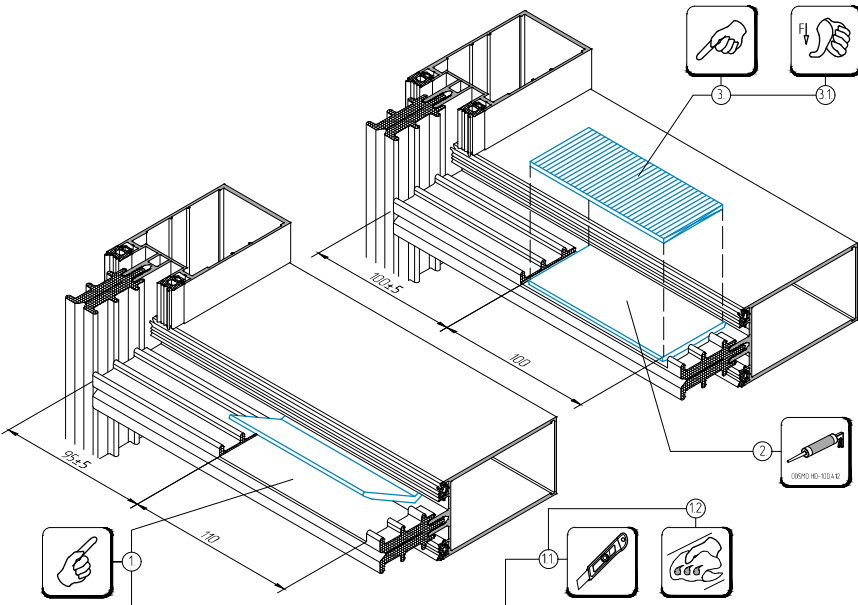
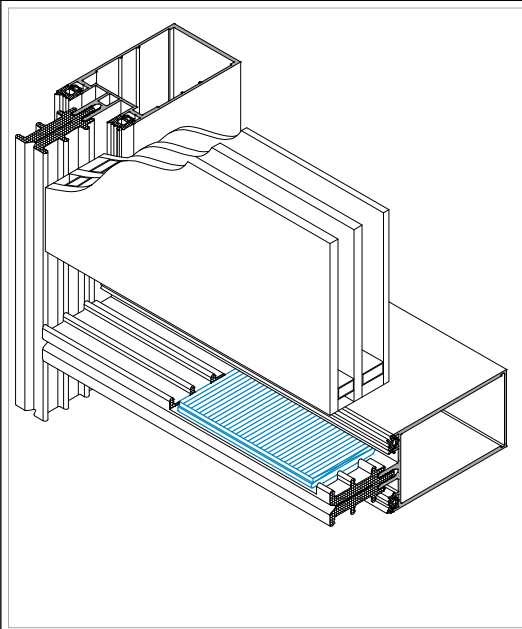


Illbruck OT015  
Adhesive tape  
cartridge 600 ml

Illbruck OT015 is a synthetic rubber-based polymer adhesive. It is recommended for gluing curtain wall EPDM membranes to aluminium, steel, galvanized iron, hard PVC and porous surfaces.  
Illbruck OT015 rubber adhesive is applied in strips approximately 10 mm in diameter on one of the surfaces to be glued. It is recommended to use a seam roller to ensure a good bond between the two membranes. Final width of the bond surface after gluing should be approximately 2–3 cm. If stripes are heavier, the membrane should be mechanically fixed, e.g. with an adhesive tape or a scotch tape until the adhesive sets. Illbruck OT015 adhesive is not suitable for direct application with polystyrene due to its chemical content. In the case of bonding the membrane to polystyrene slabs, use Illbruck OT020 solvent-free rubber adhesive.  
Use in properly ventilated premises. Do not smoke in premises where OT015 adhesive is used. Before application, read the product safety card.

Glue spread: 7.6 m for Ø10 mm strip.  
Application temperature: +5 °C... +30 °C  
Operating temperature: –20 °C... +80 °C

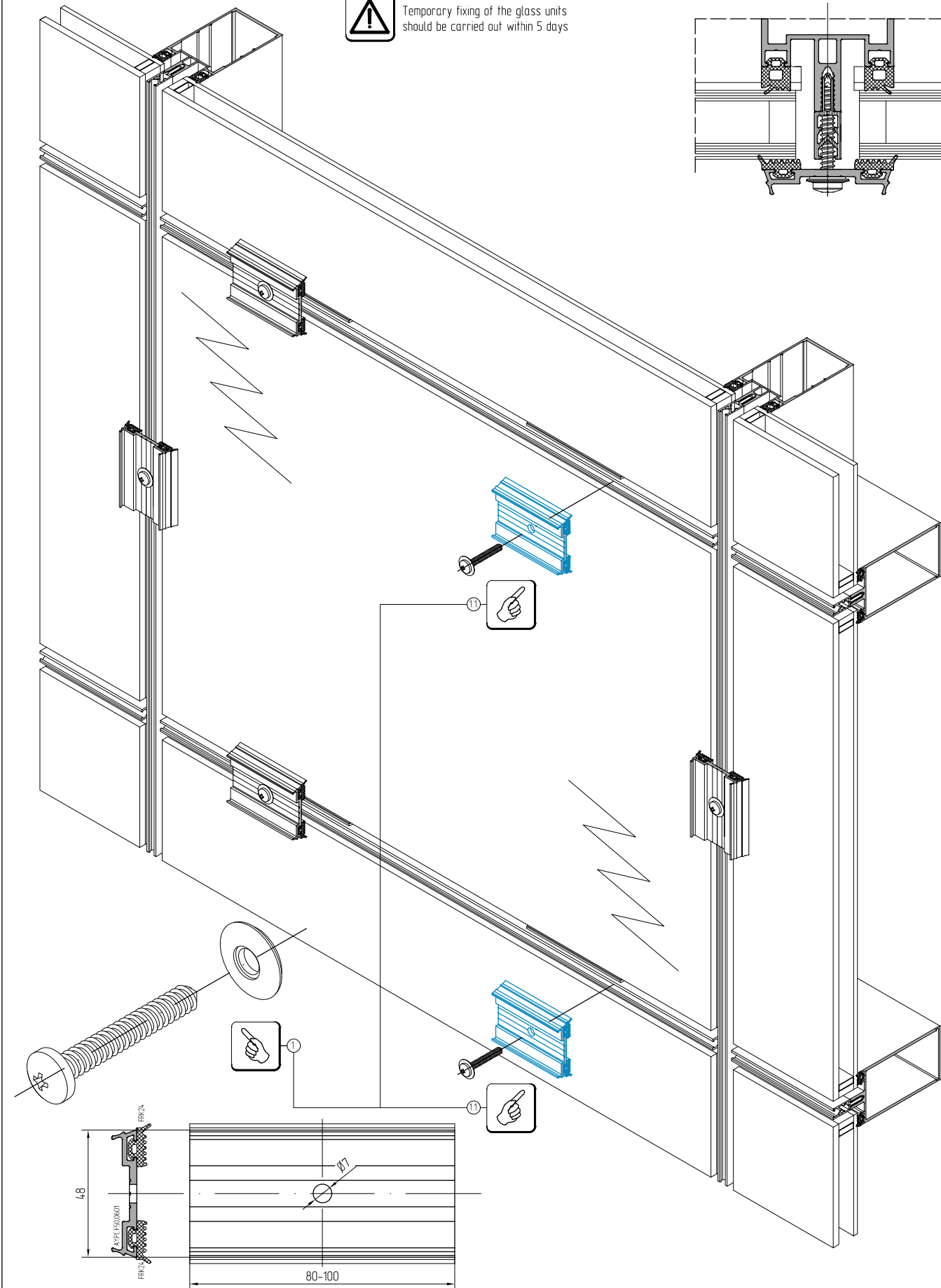
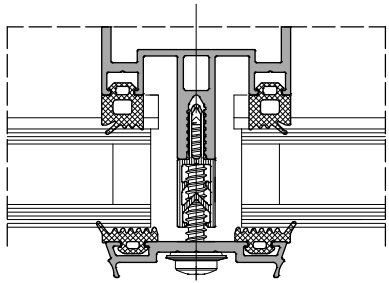


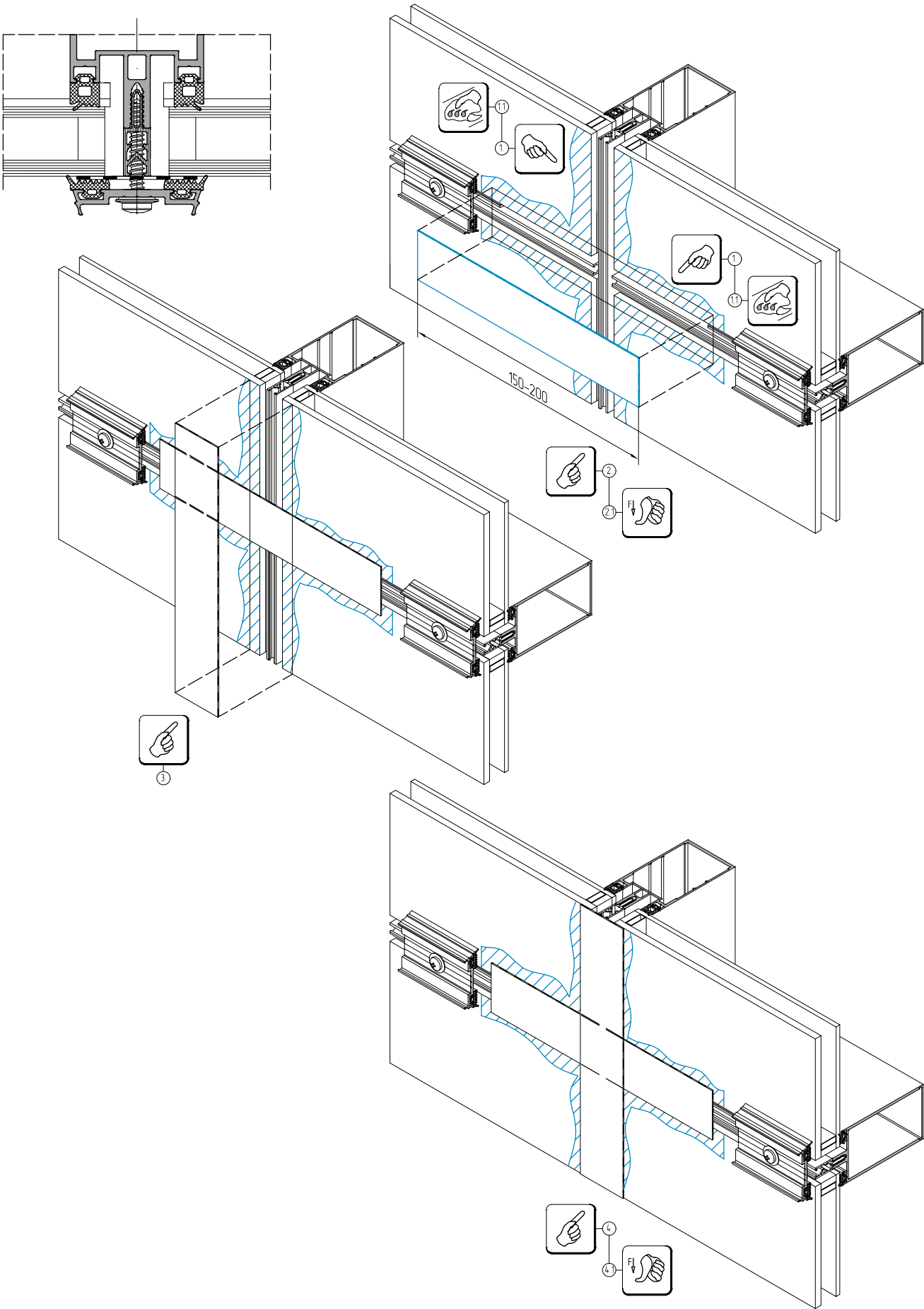


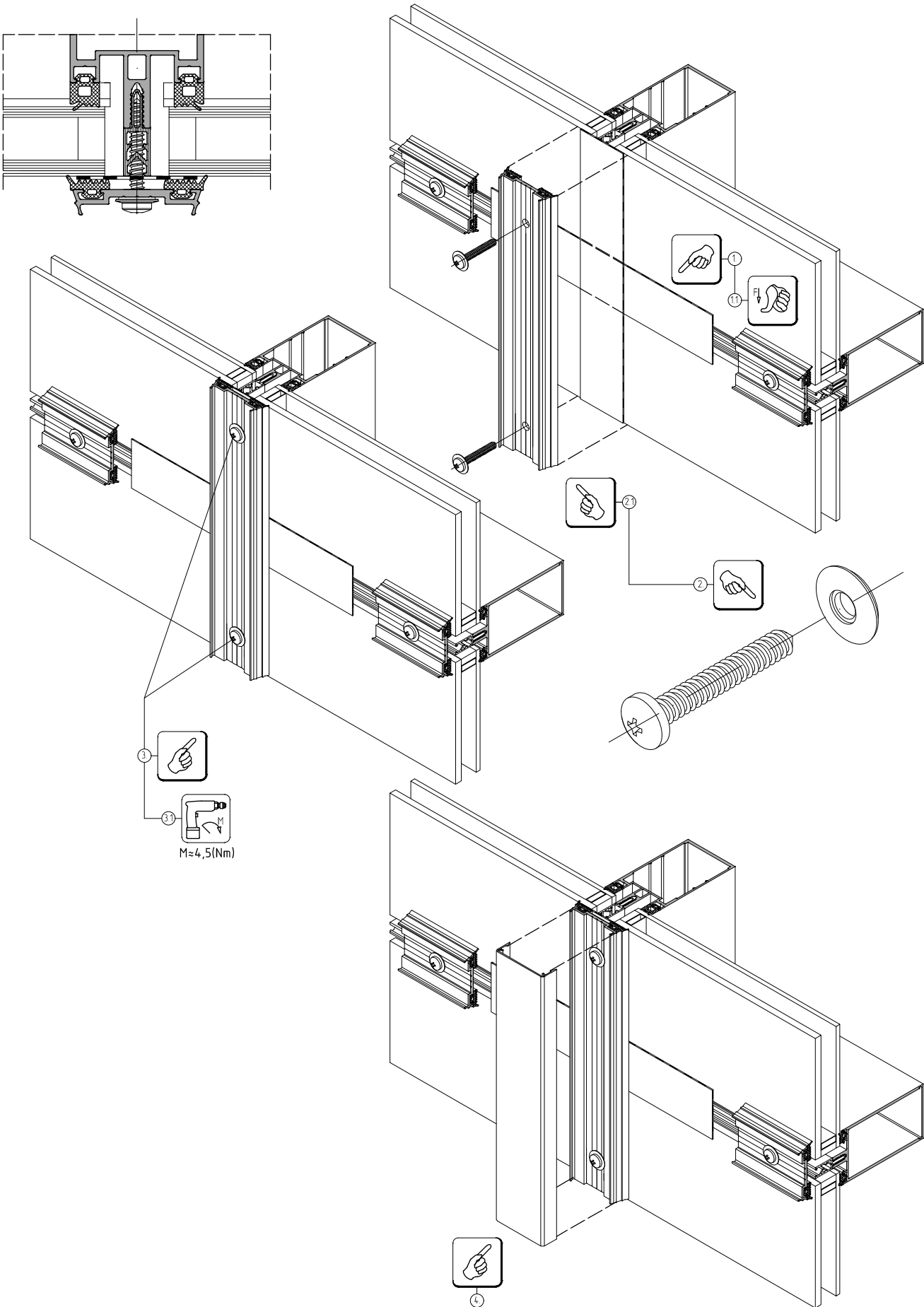




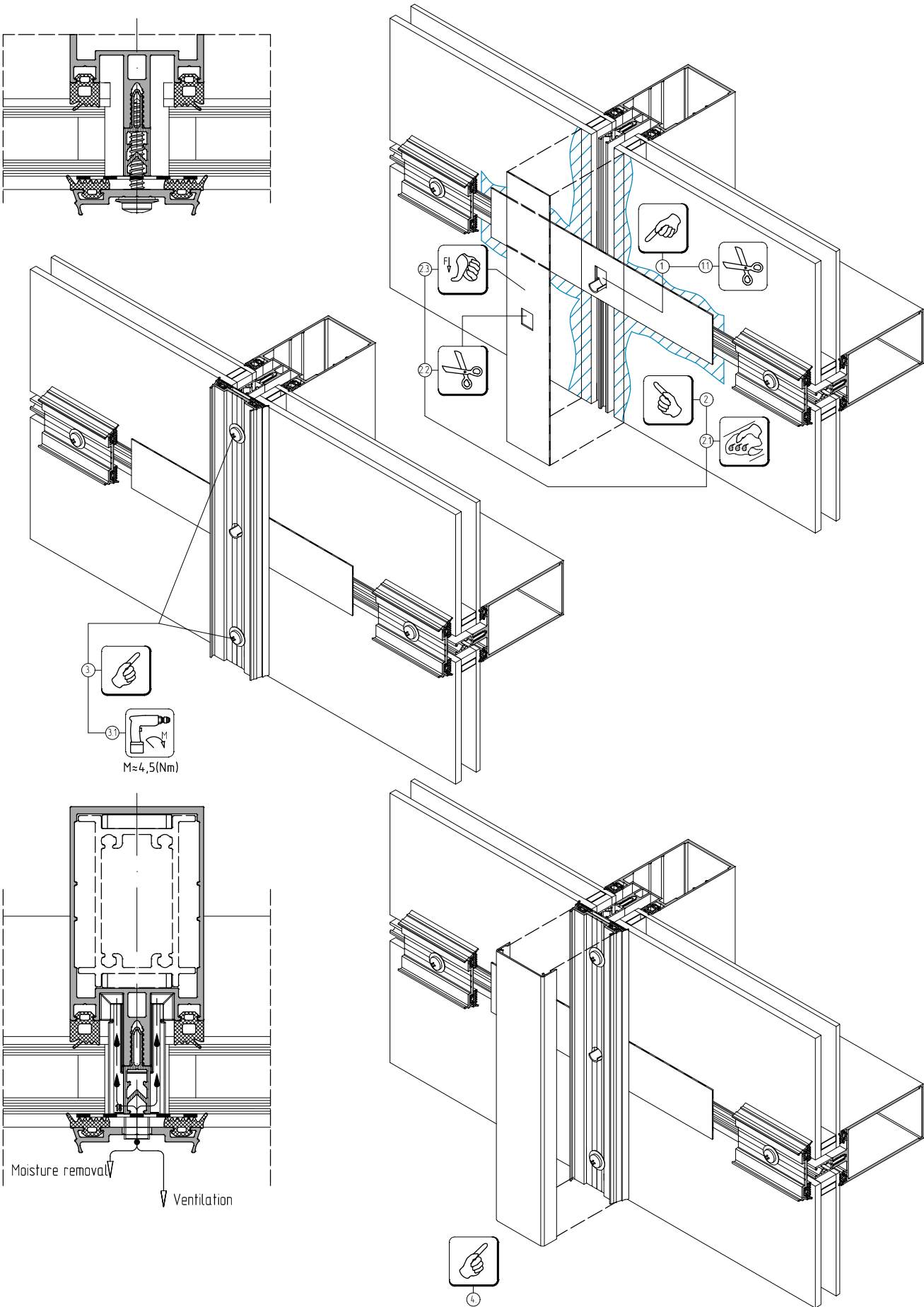
Temporary fixing of the glass units should be carried out within 5 days

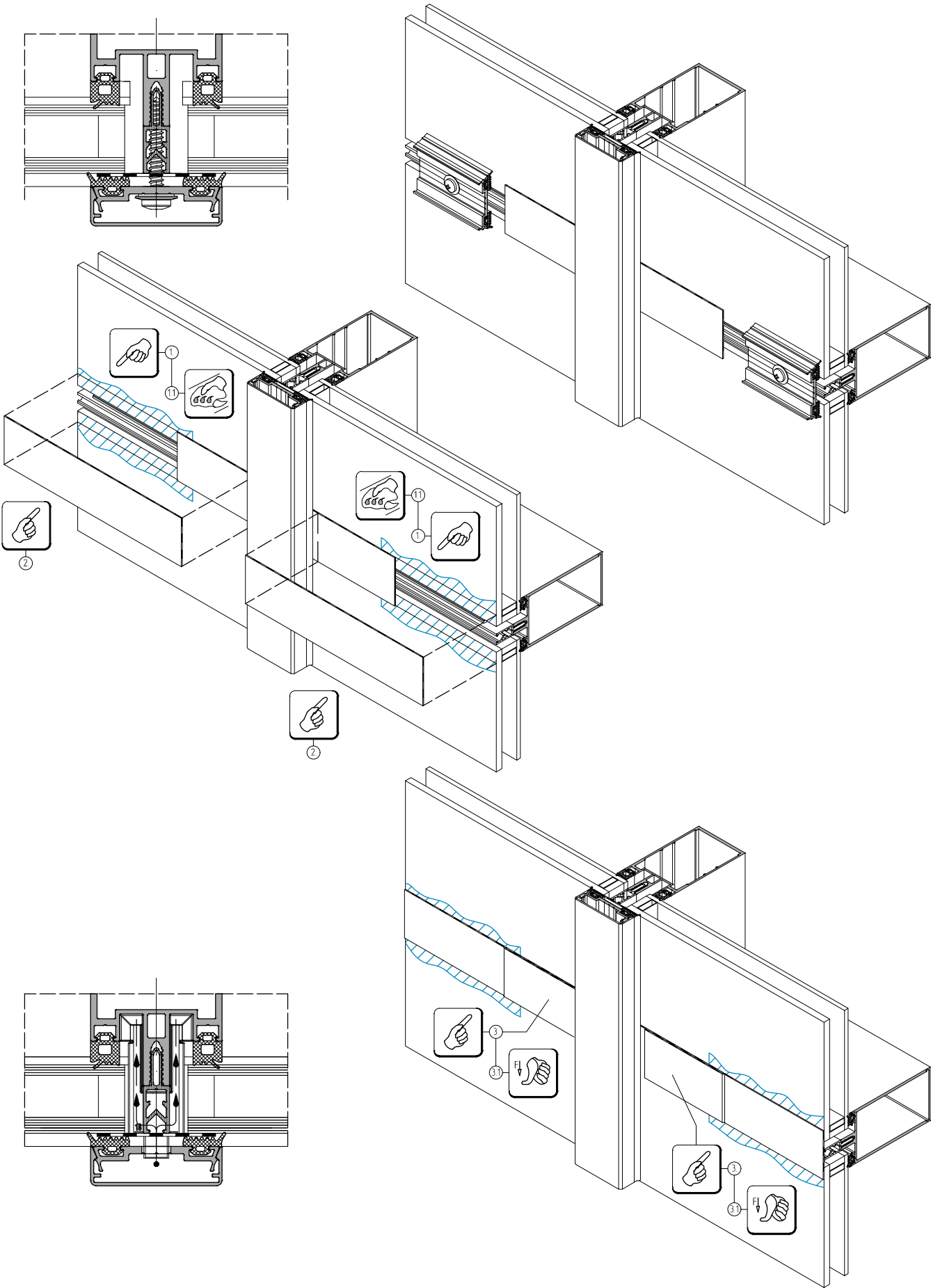


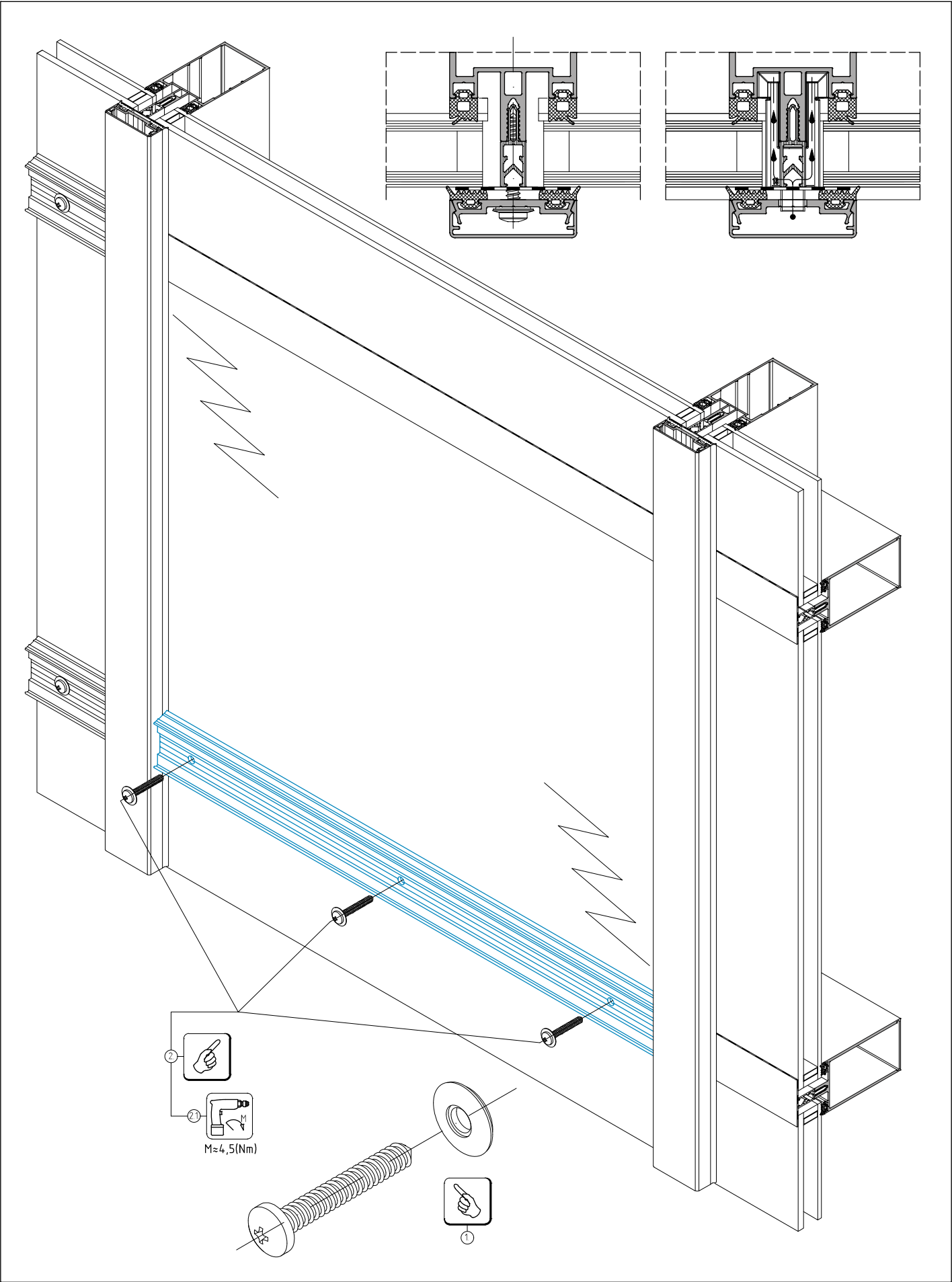


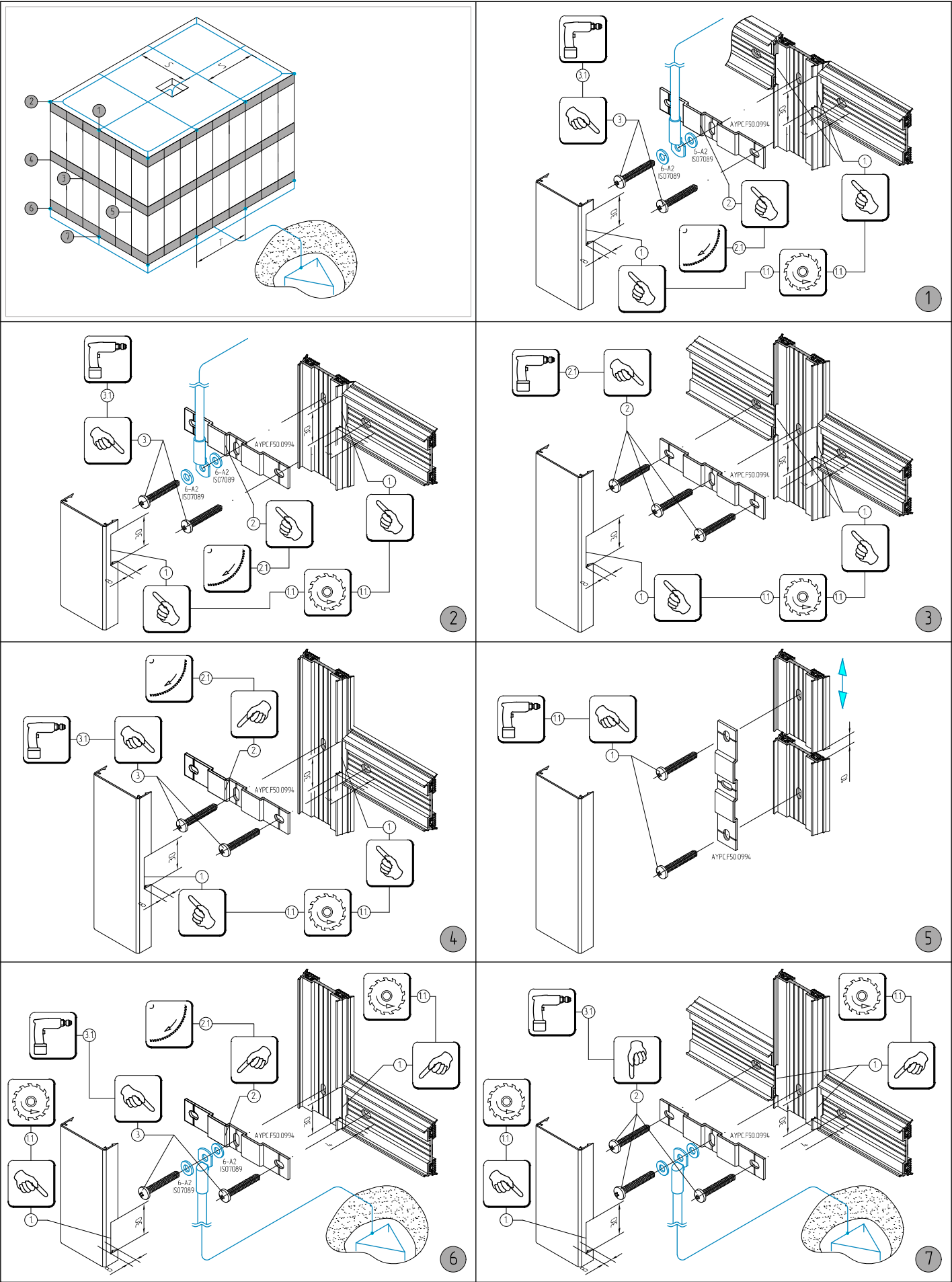


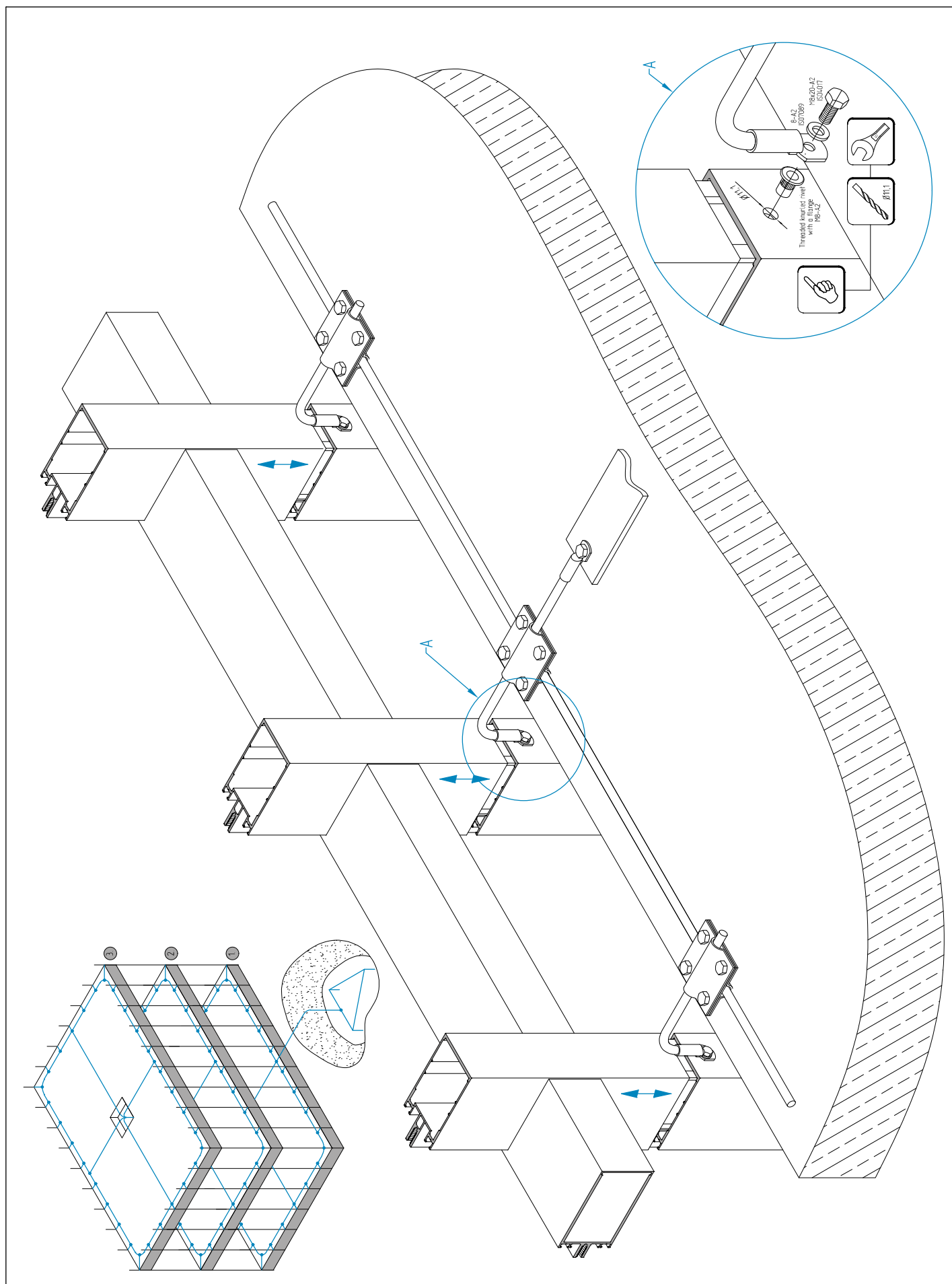




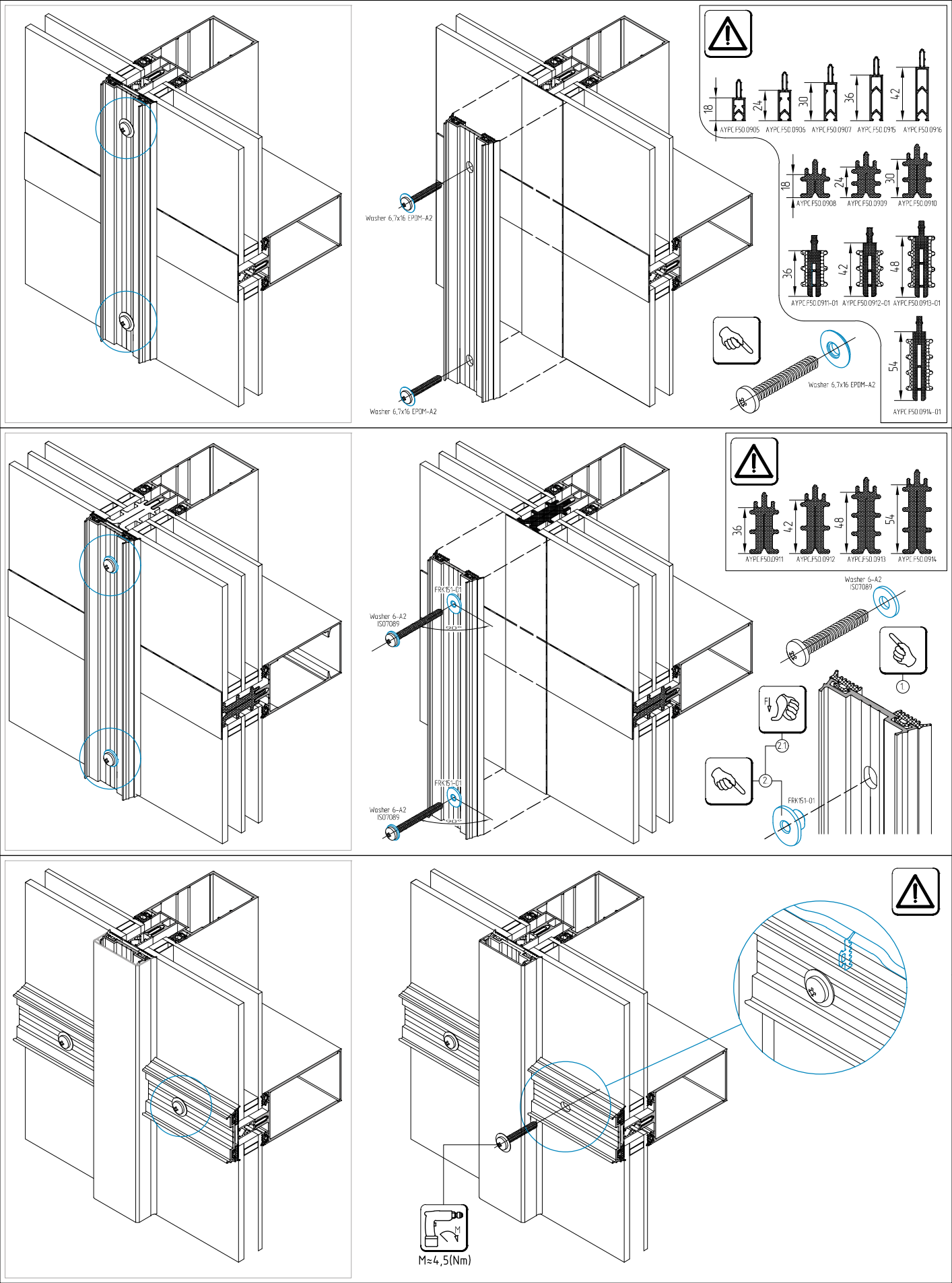


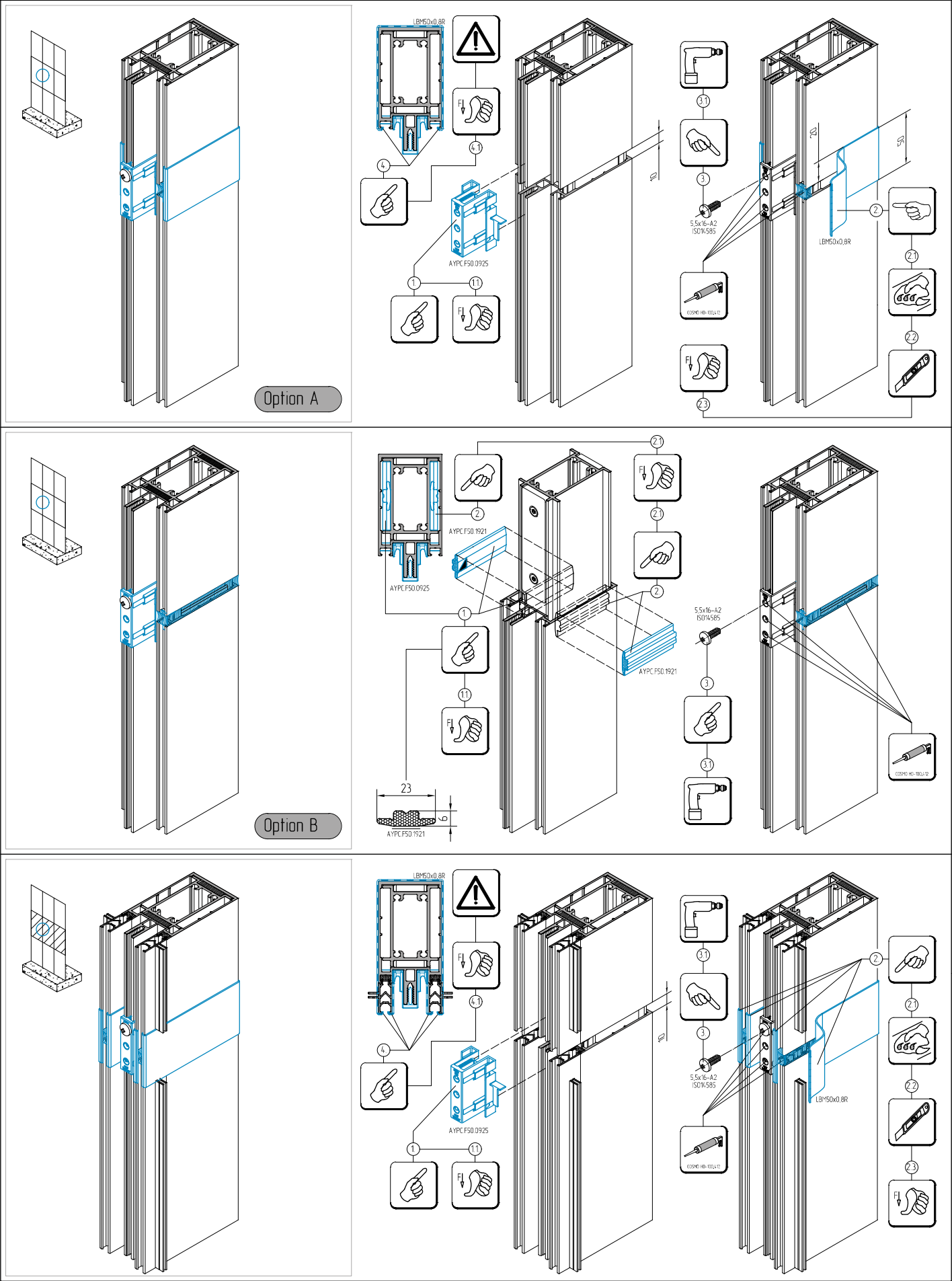


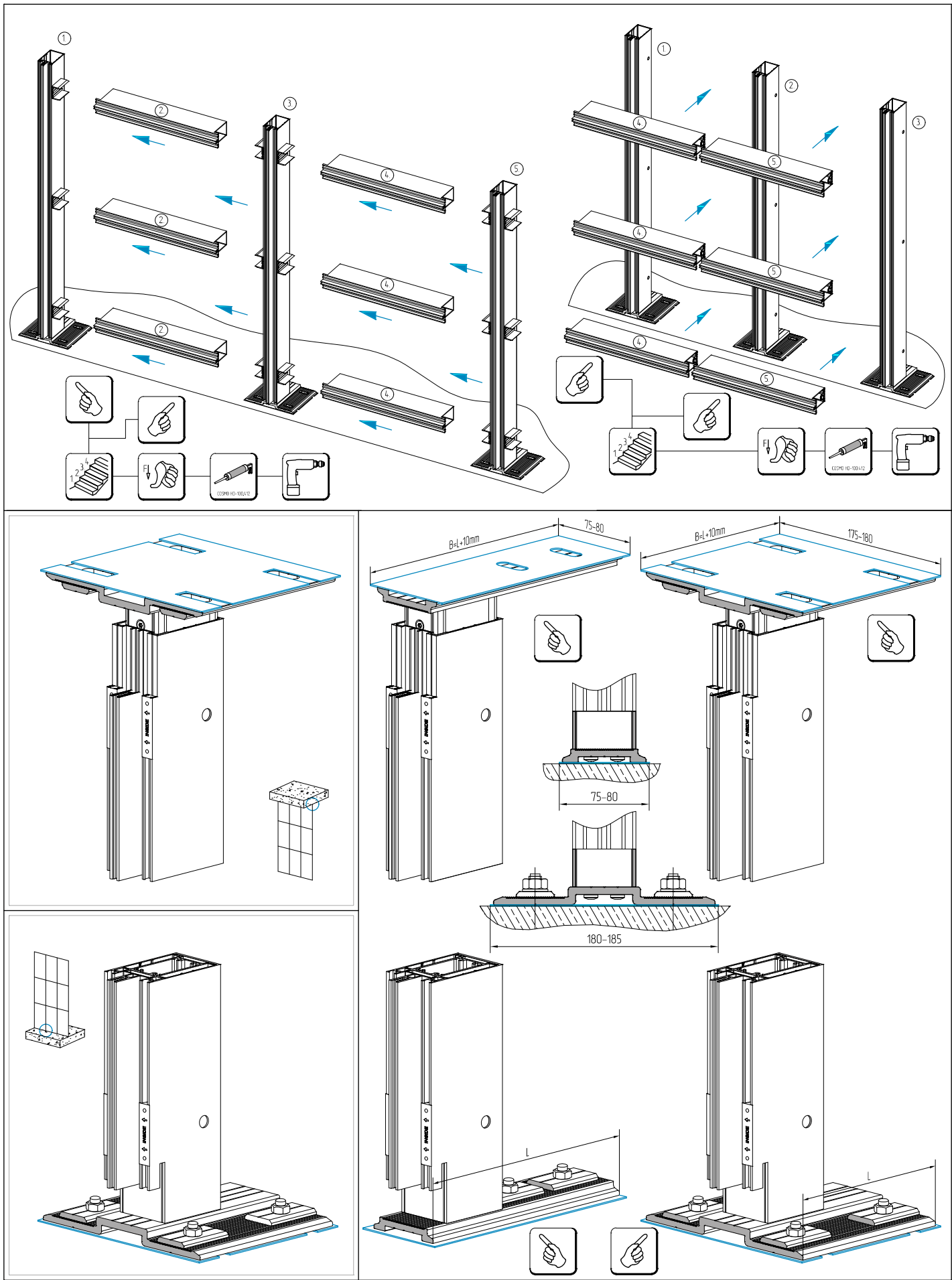


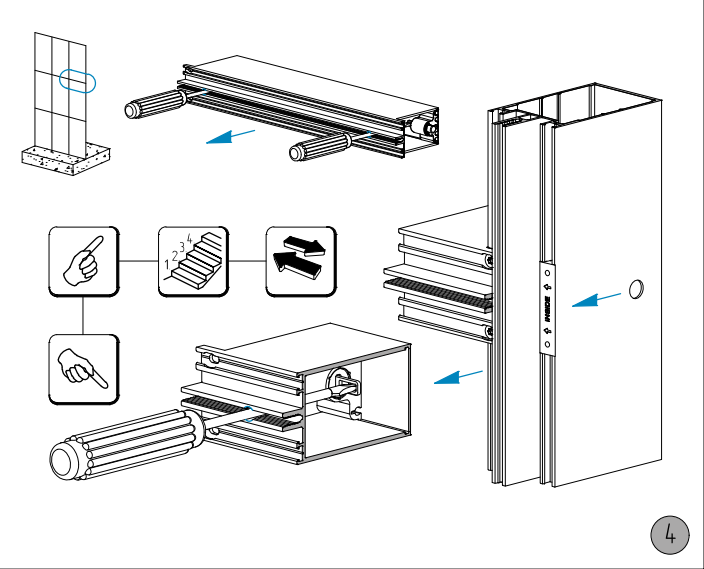
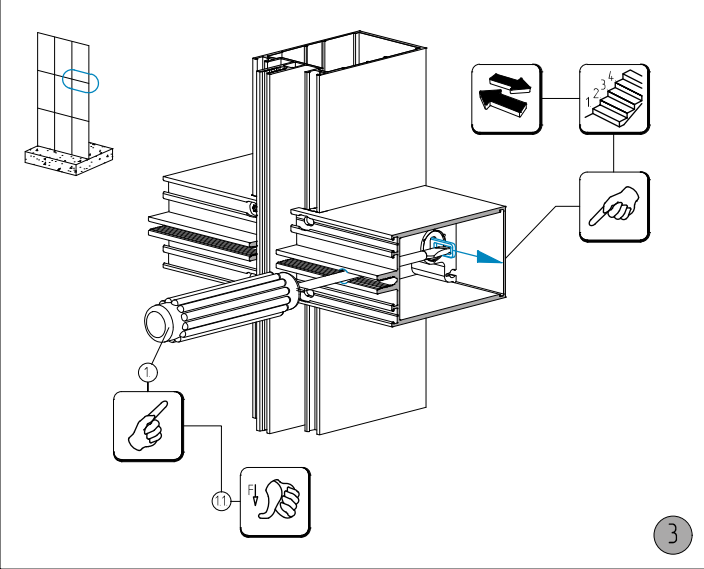
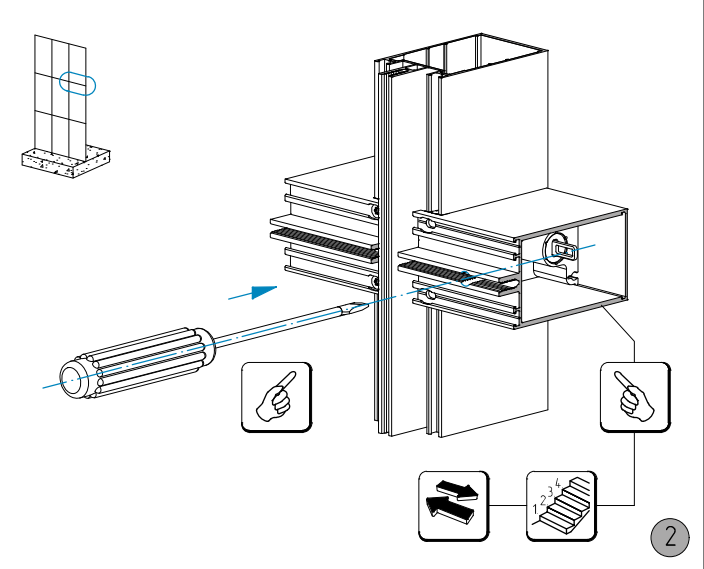
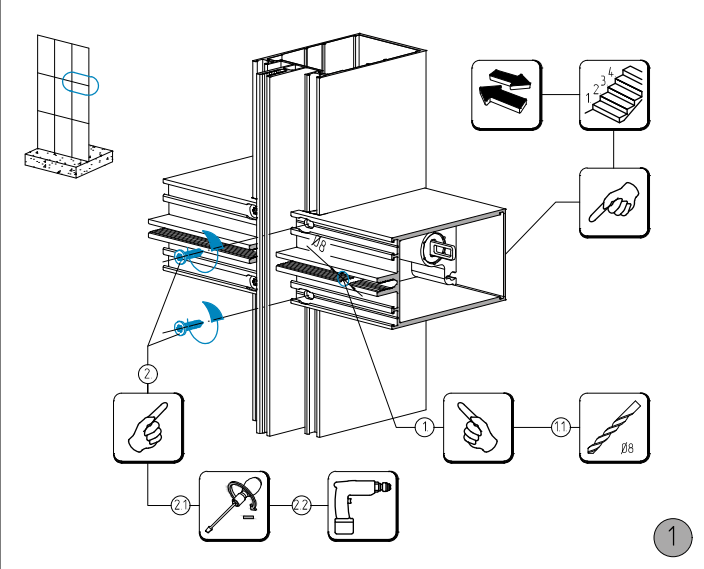
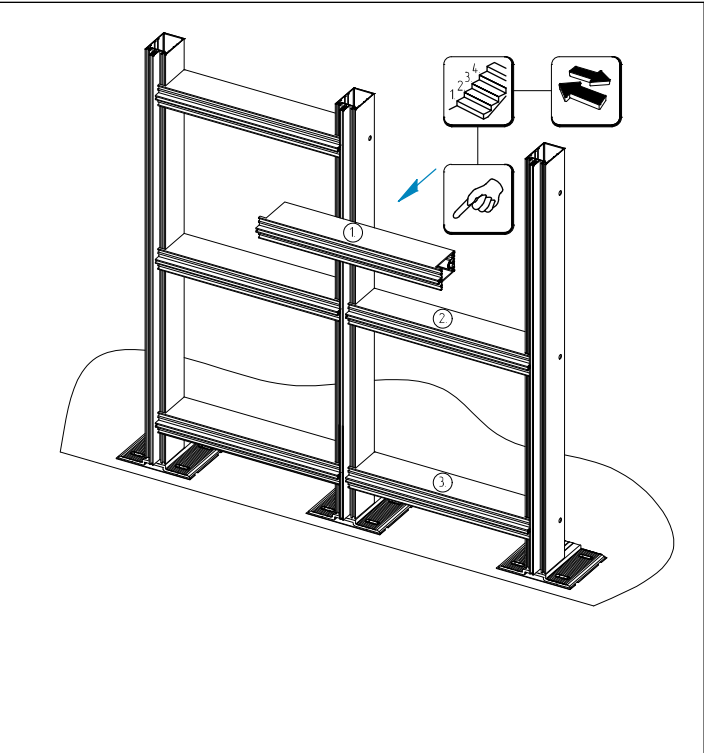
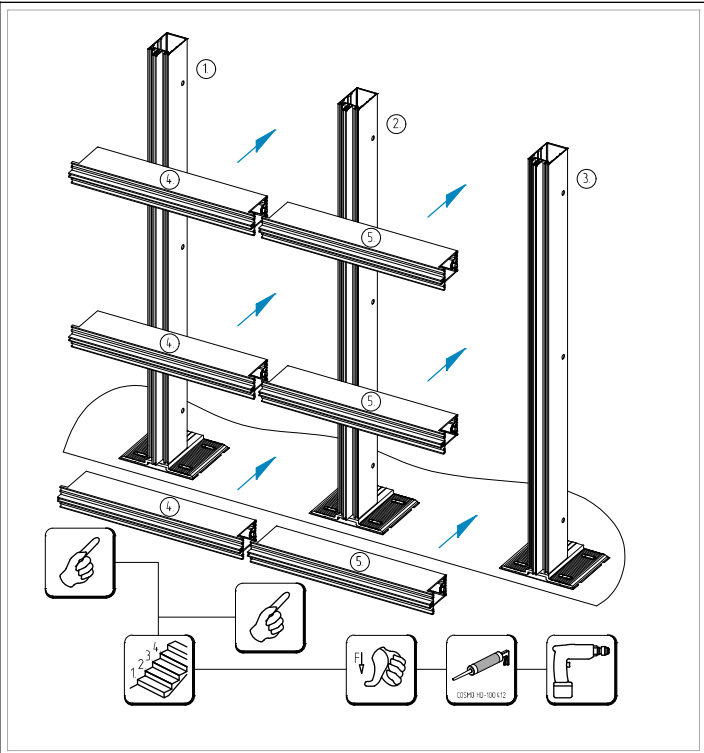








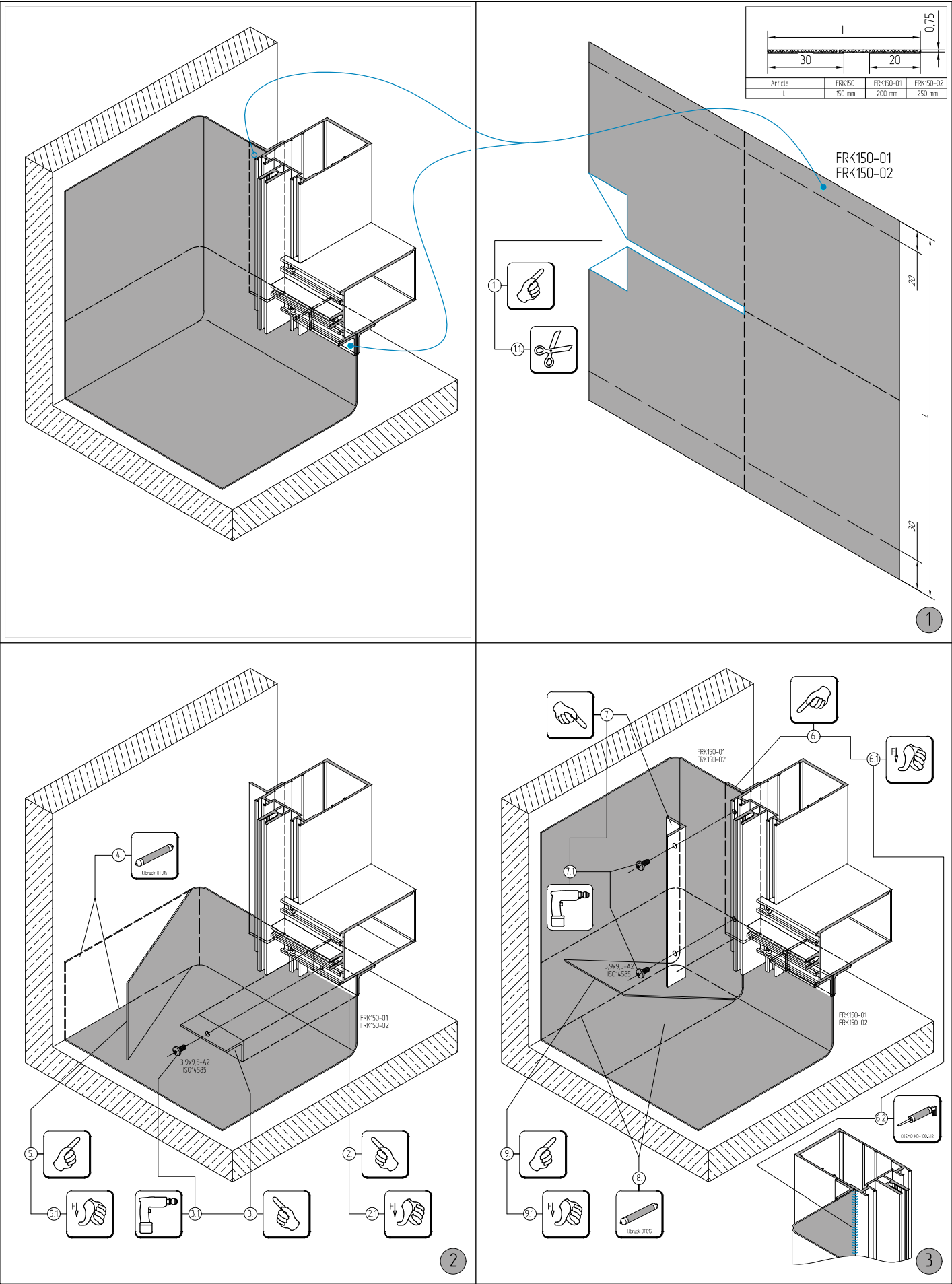


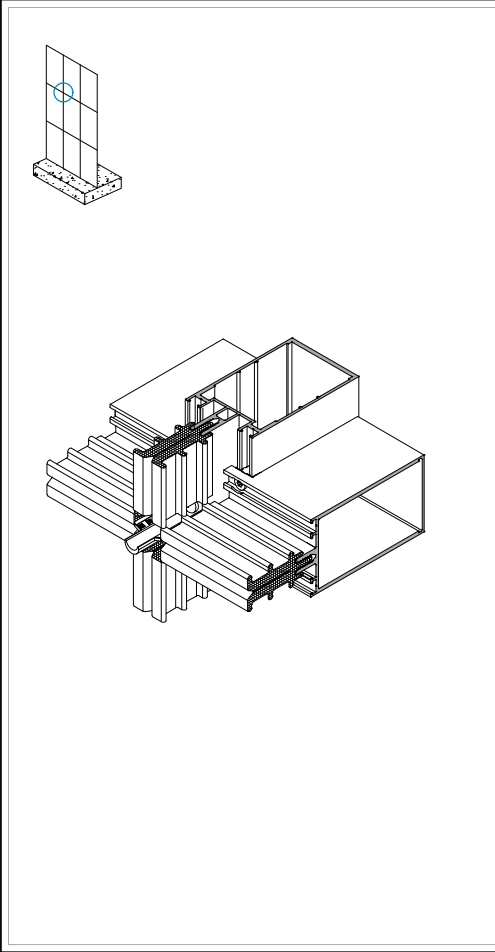
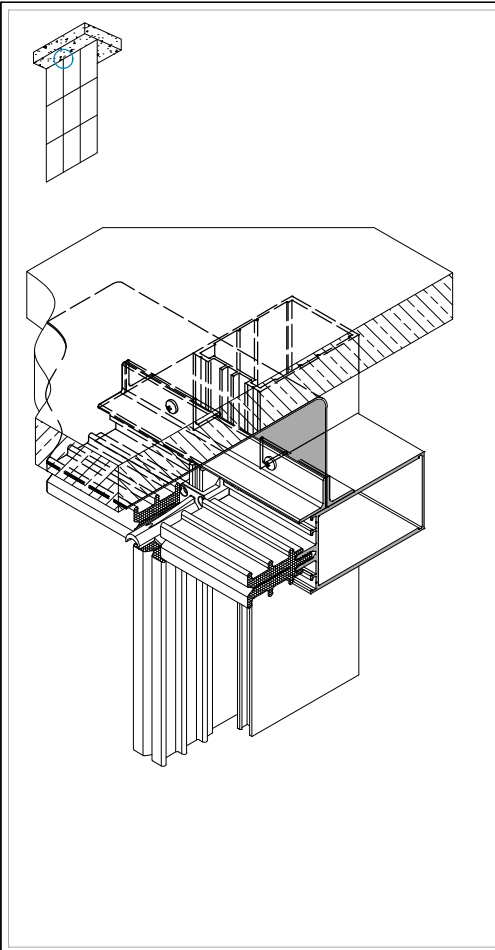























































































































































































































































































































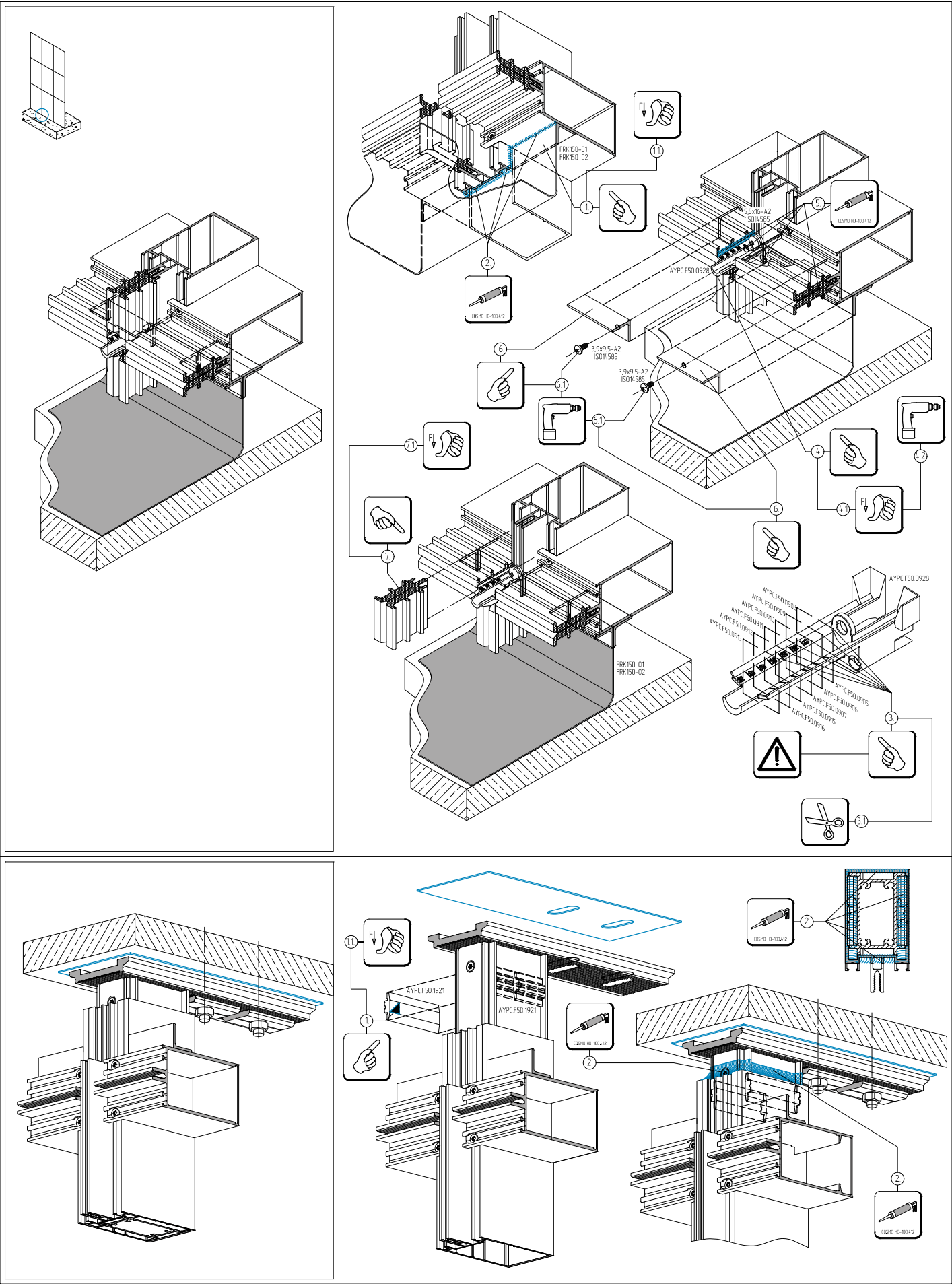


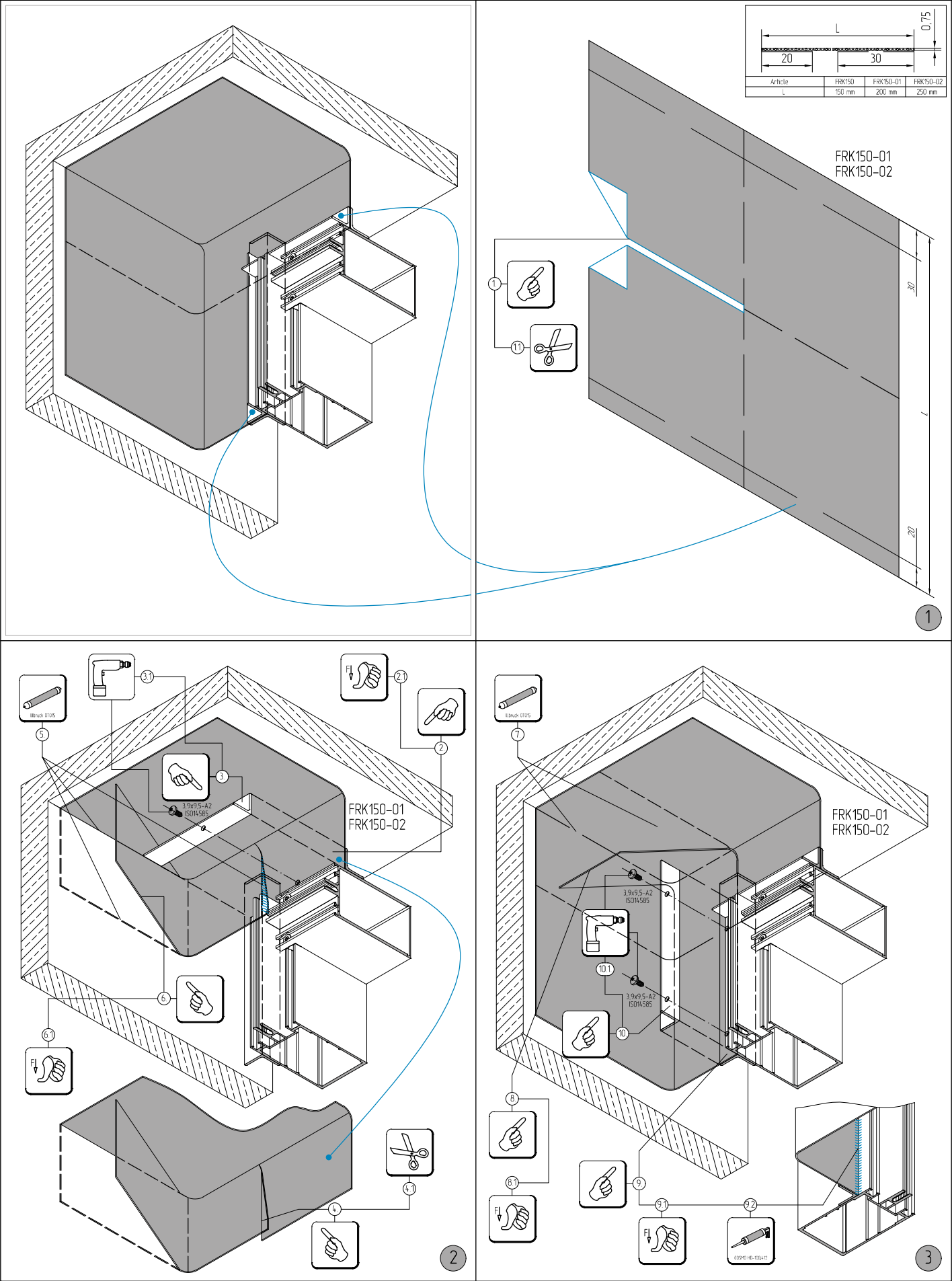




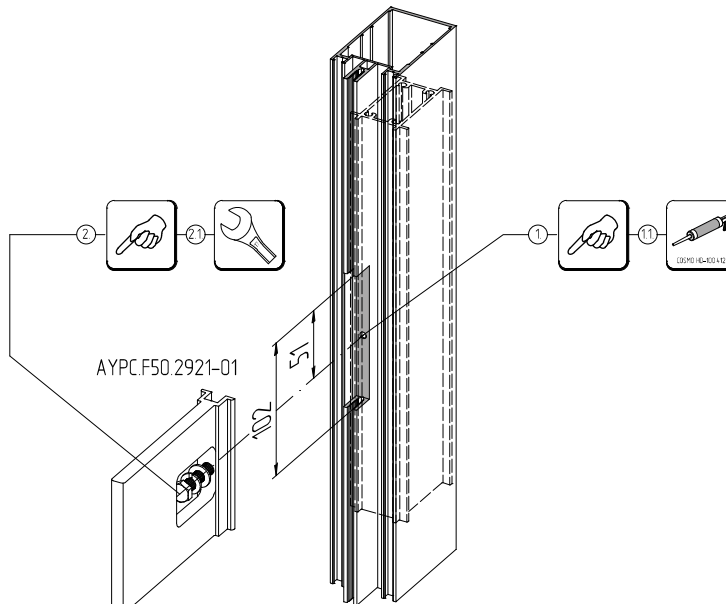
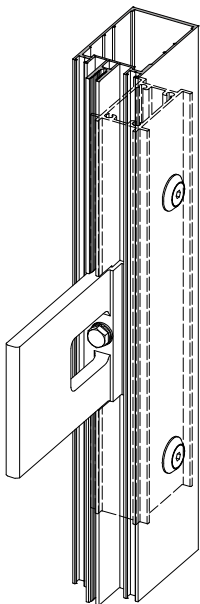
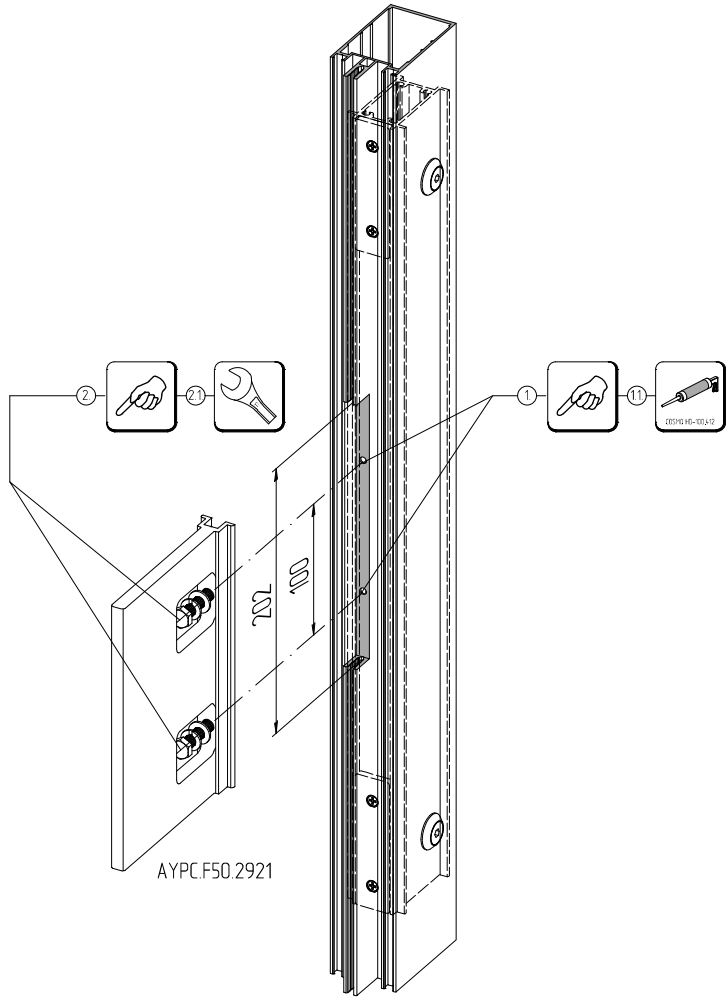
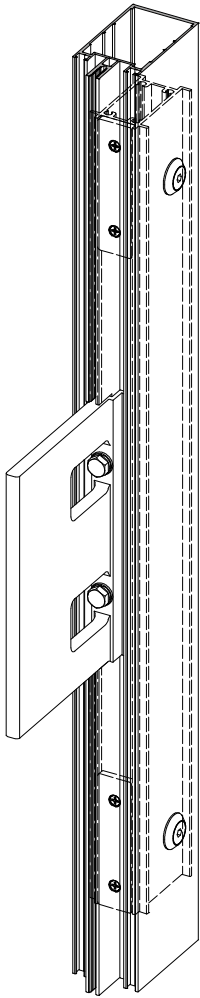




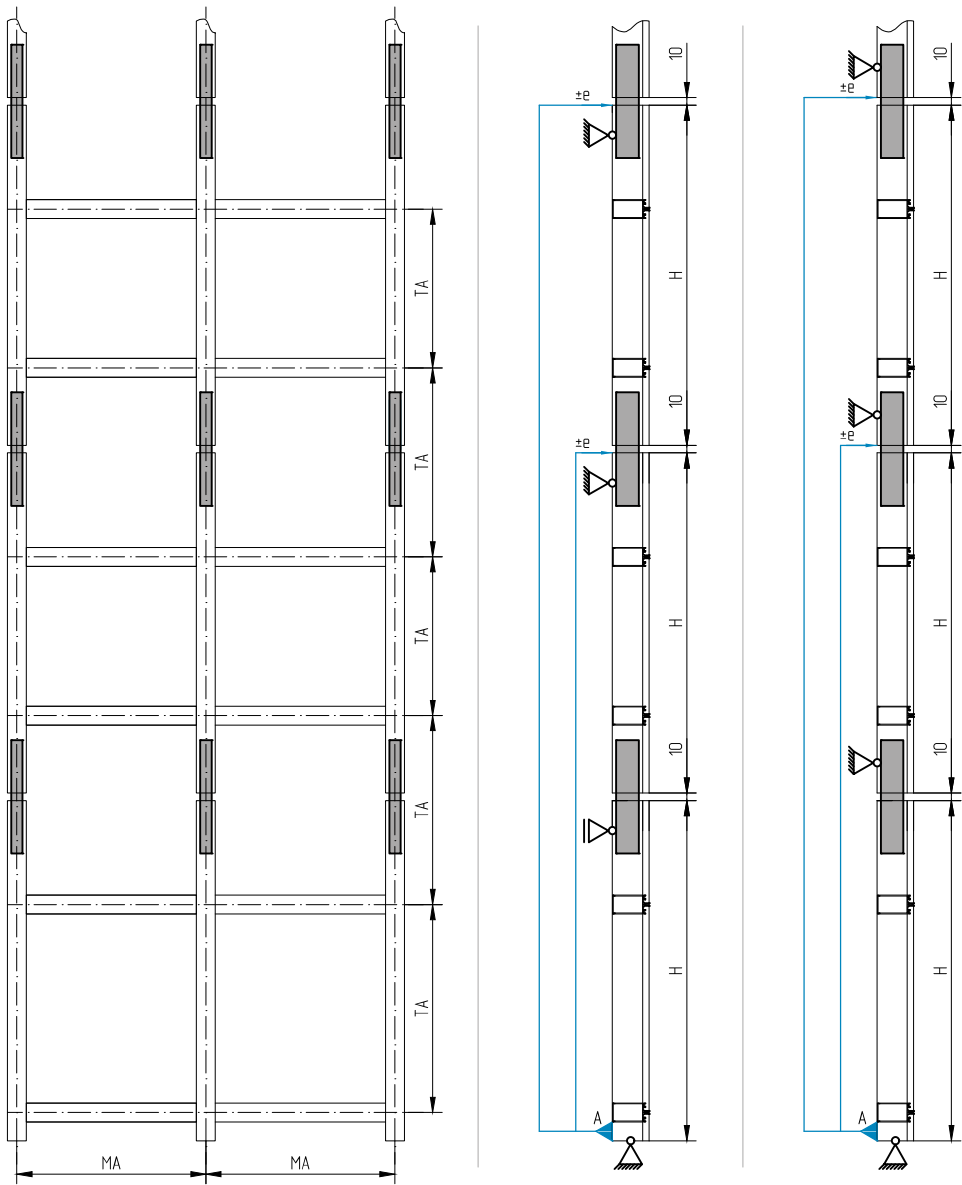








Maximum permissible deviation of a mullion in ALT F50 multi-span curtain wall system from the vertical line at base level 'A'



$$e = \sum H / 1000 \sqrt{n}$$

e - maximum permissible deviation of mullions (mm)  
H - span height (mm)  
n - number of spans

MA - mullion profile axis

TA - transom profile axis

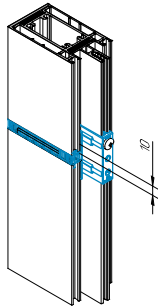
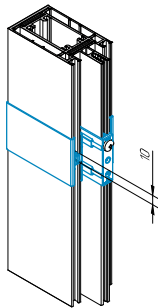
→ - deviation from the base

A - base

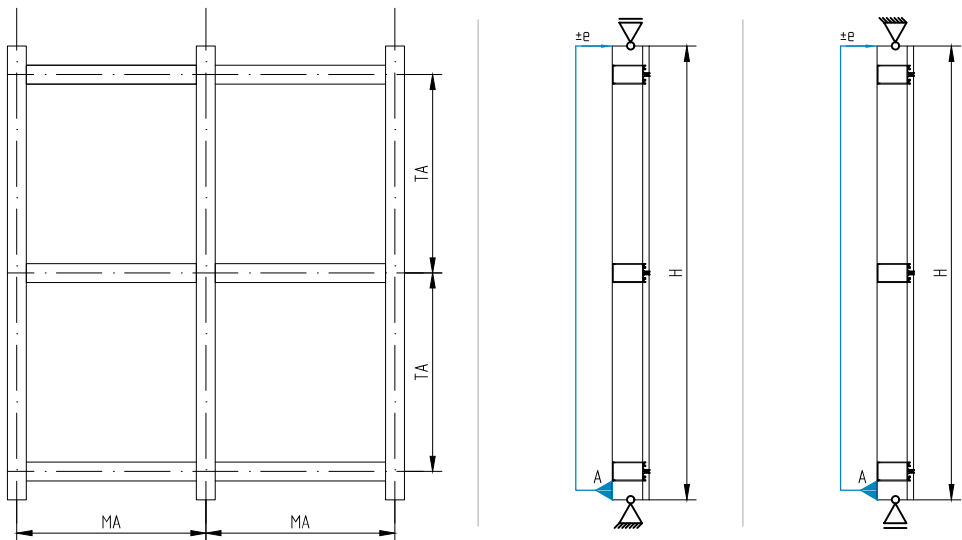
△ - immovable support

○ - movable support

■ - reinforcement profile



Maximum permissible deviation of a mullion in ALT F50 single-span curtain wall system from the vertical line at base level 'A'



$$e = H / 1000 < 3 \text{ mm}$$

e - maximum permissible deviation of mullions (mm)  
H - span height (mm)

MA - mullion profile axis

TA - transom profile axis

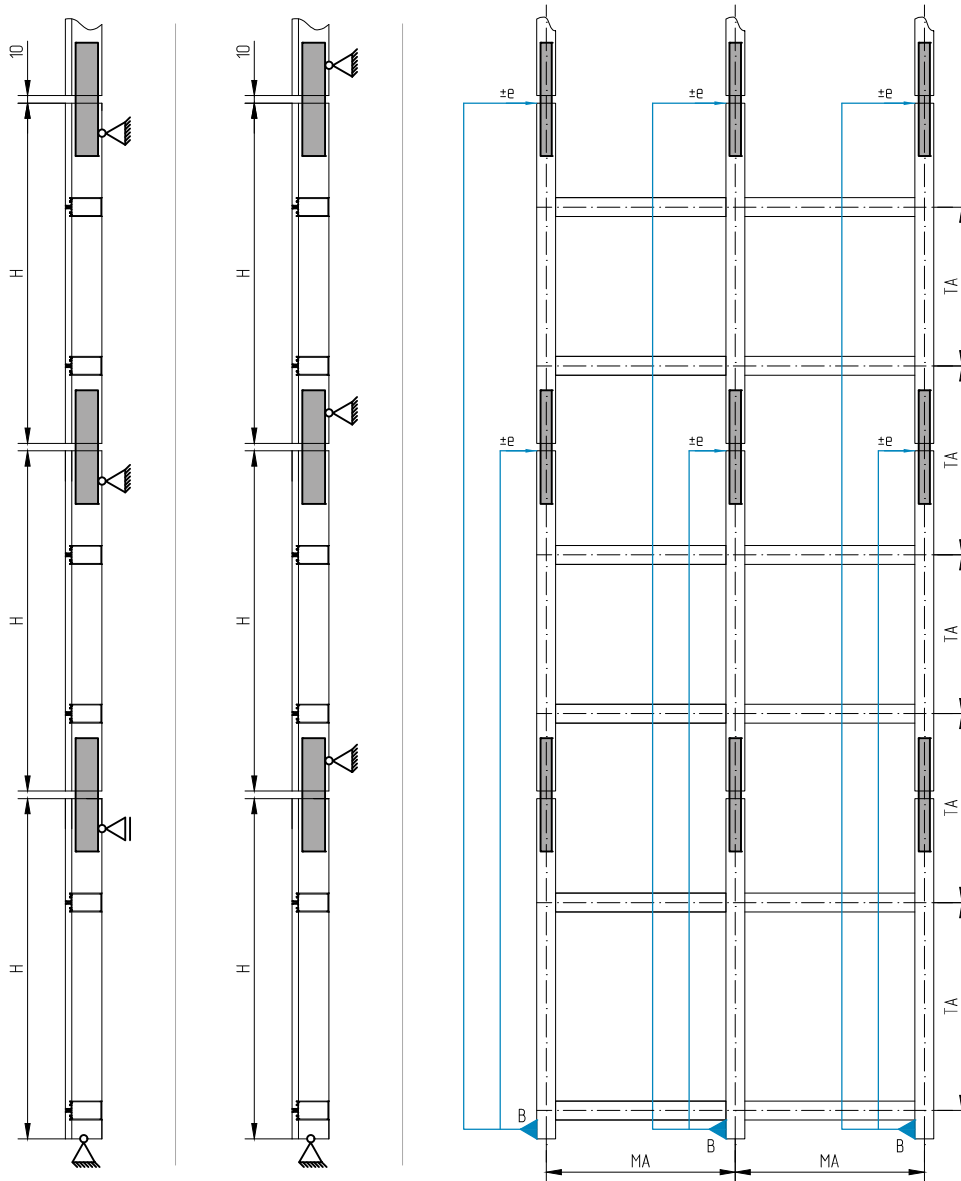
→ - deviation from the base

A - base

△ - immovable support

○ - movable support

Maximum permissible deviation of a mullion in ALT F50 multi-span curtain wall system from the vertical line at base level 'B'



$$e = \sum H / 1000 \sqrt{n}$$

e – maximum permissible deviation of mullions (mm)  
H – span height (mm)  
n – number of spans

MA – mullion profile axis

TA – transom profile axis

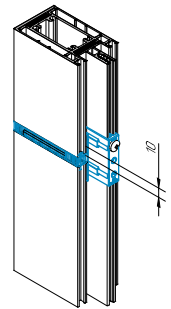
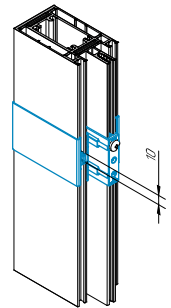
→ – deviation from the base

△ – base

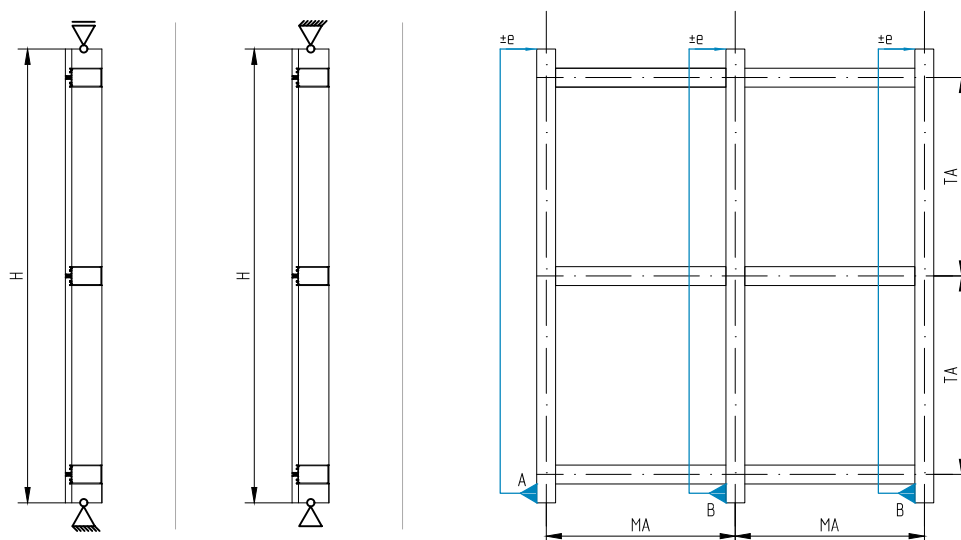
△ – immovable support

△ – movable support

■ – reinforcement profile



Maximum permissible deviation of a mullion in ALT F50 single-span curtain wall system from the vertical line at base level 'B'



$$e = H / 1000 < 3\text{mm}$$

e – maximum permissible deviation of mullions (mm)  
H – span height (mm)

MA – mullion profile axis

TA – transom profile axis

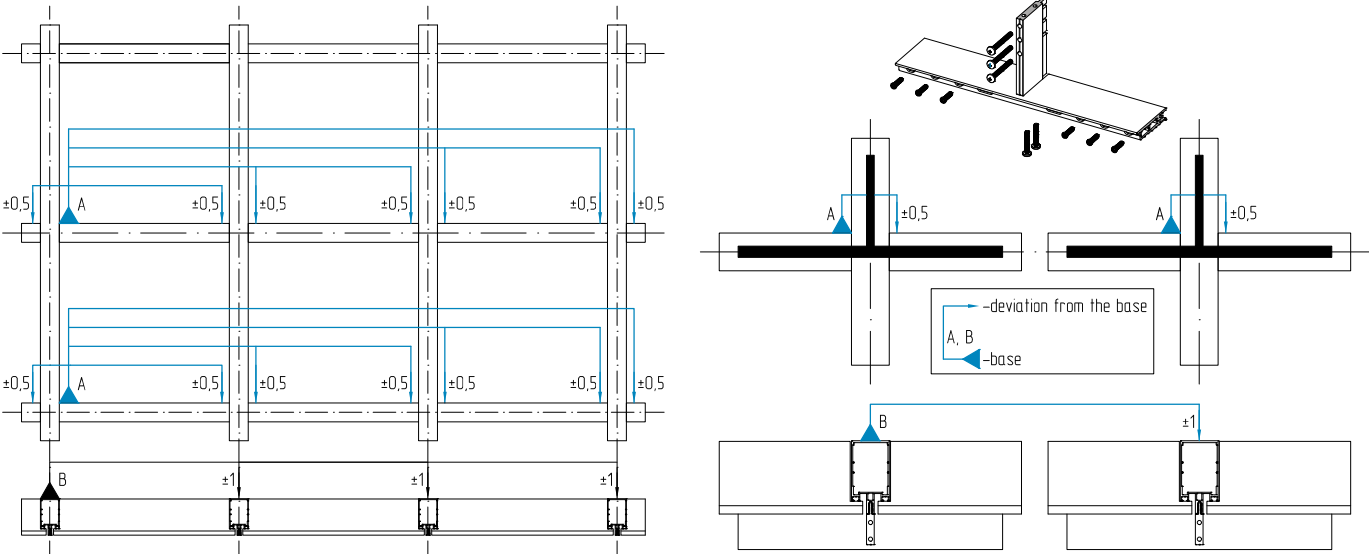
→ – deviation from the base

△ – base

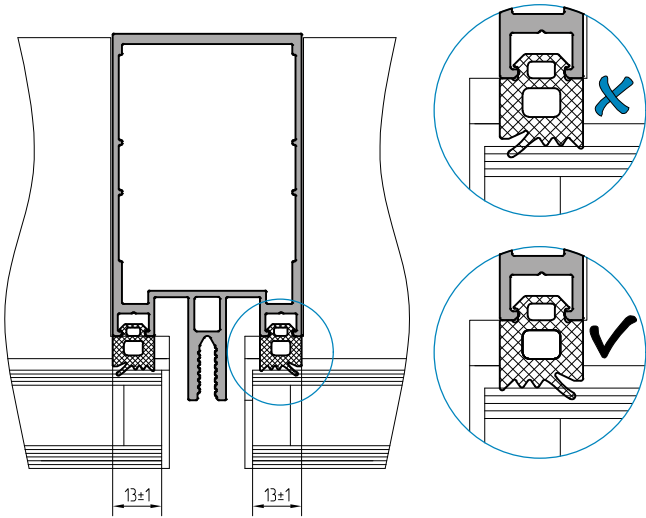
△ – immovable support

△ – movable support

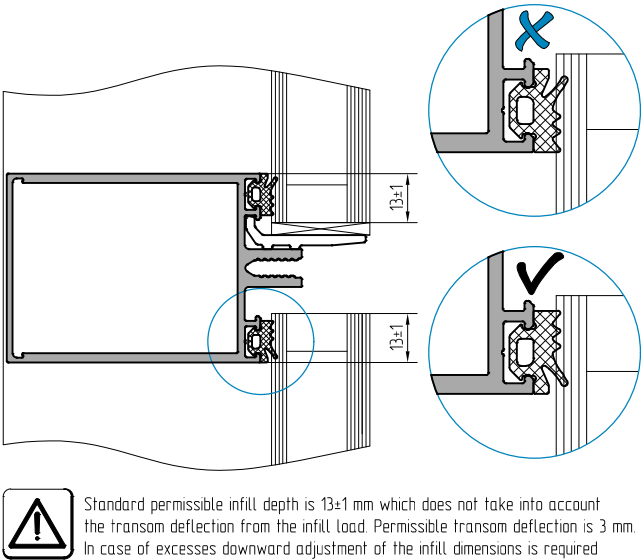
Maximum permissible deviation of transoms in ALT F50 curtain wall system from the horizontal line at base level 'A' and 'B'



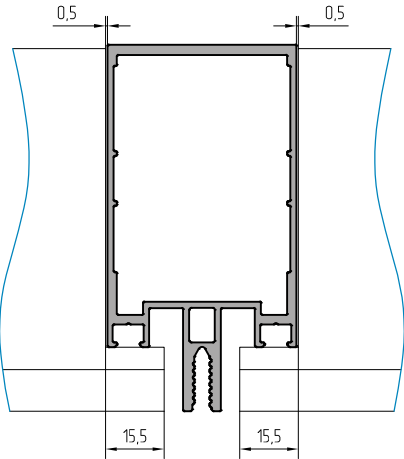
Permissible infill depth and correct position of the gasket in the mullion profile



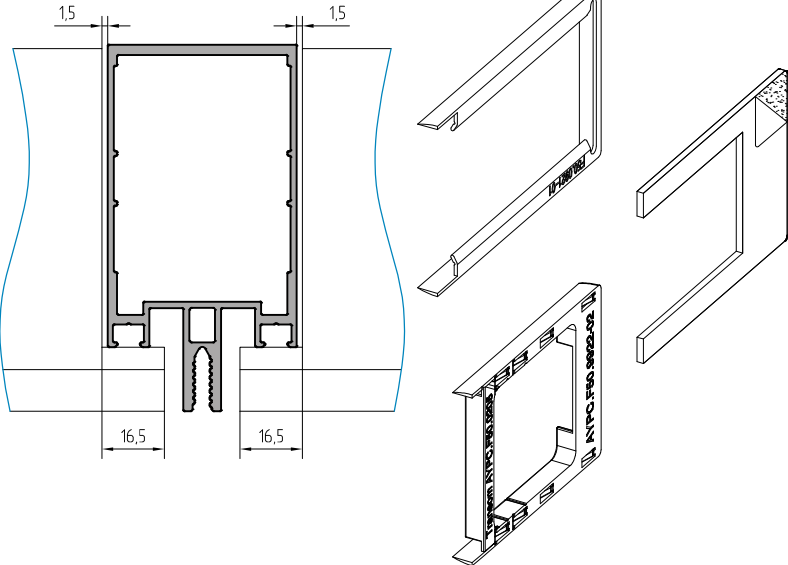
Permissible infill depth and correct position of the gasket in the transom profile



Required gap for mullion and transom connection without a plug



Required gap for mullion and transom connection with an end plug





**AluminTechno JLLC**  
tel.: +375 17 311 05 00  
fax: + 375 17 311 05 01  
e-mail: [market@alt.by](mailto:market@alt.by)