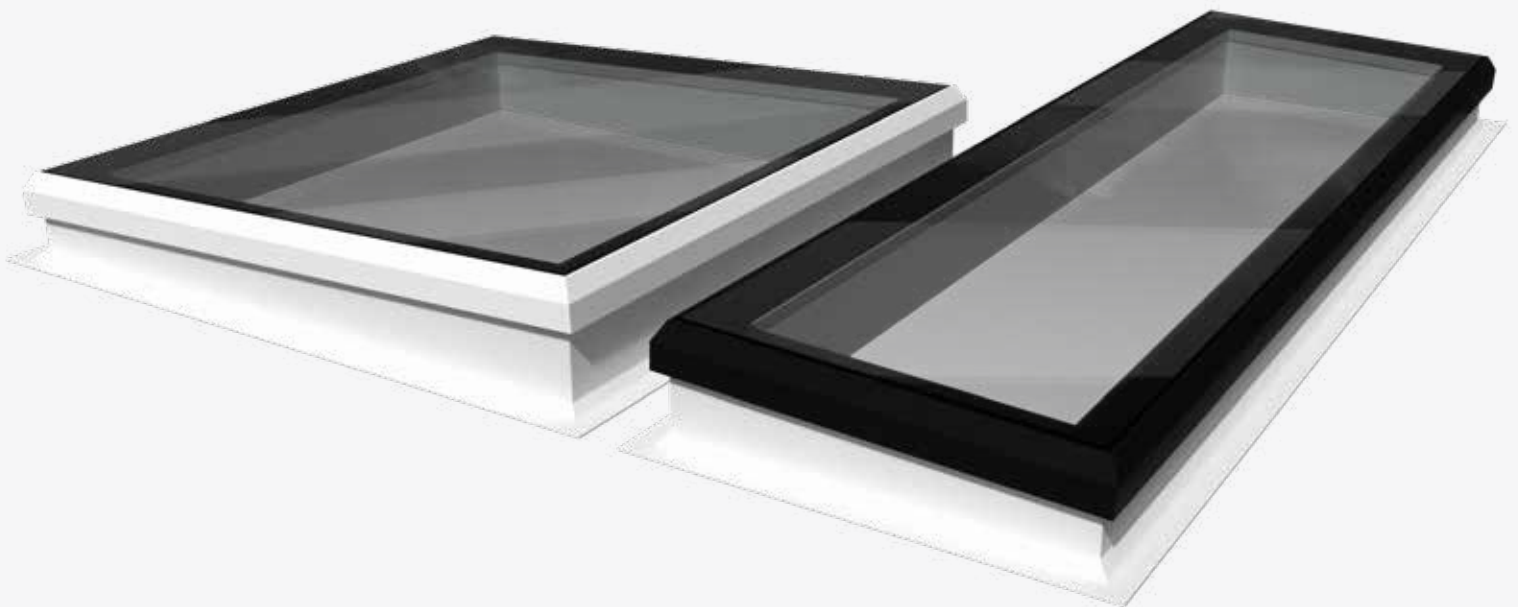


# LUMA FLAT ROOFLIGHT FABRICATION GUIDE

Issue 1



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### If in doubt at any stage

Please contact our Technical Support  
for additional support or advice.



**01773 842100**



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For purchasing products please telephone  
01773 842222 and ask for Eurocell Sales Department.



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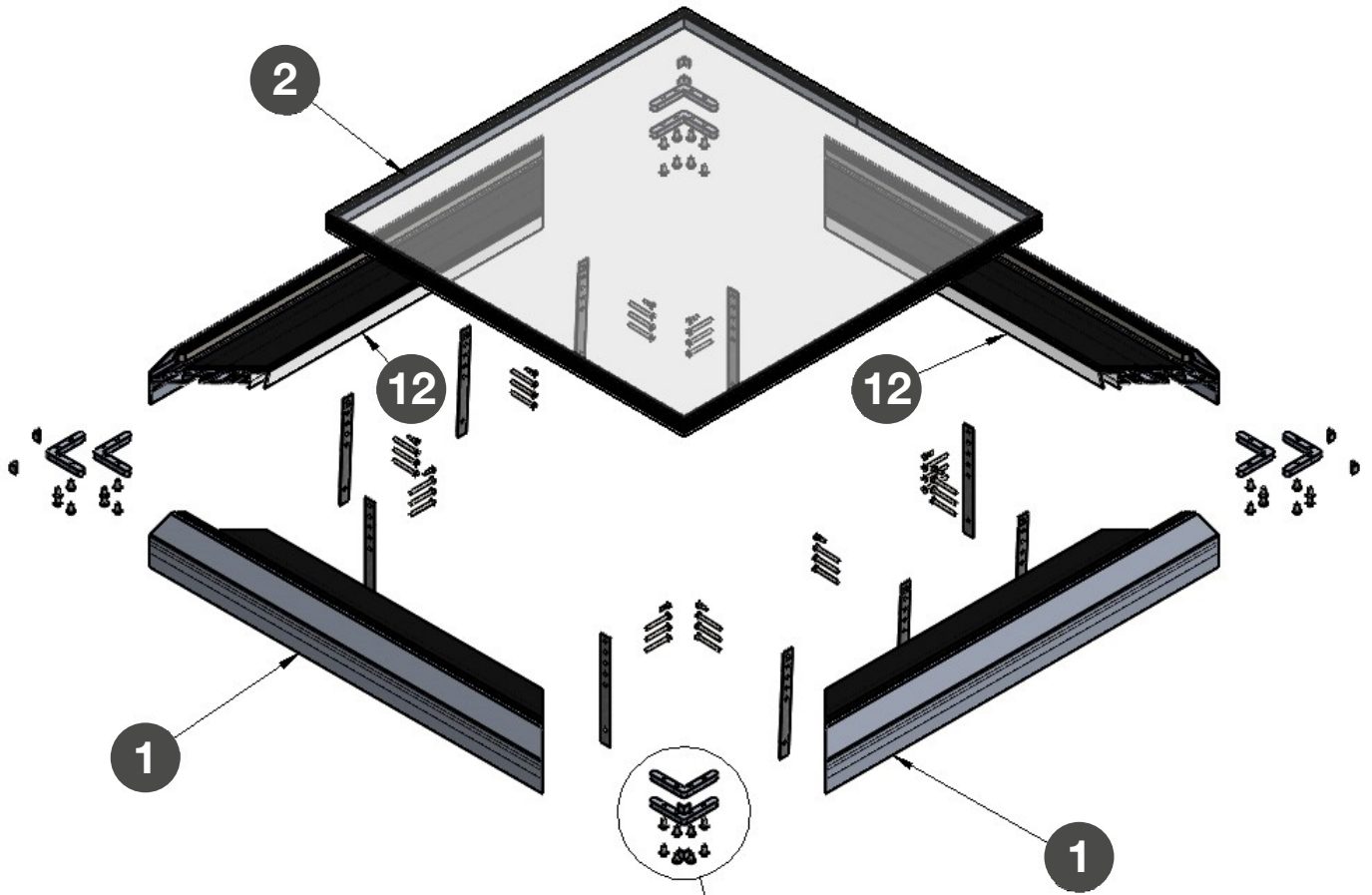
## UPDATING OF PRODUCT MANUAL

To ensure that the product manual is kept up to date, all registered holders of the said manual will be supplied with current amendments immediately upon their release.

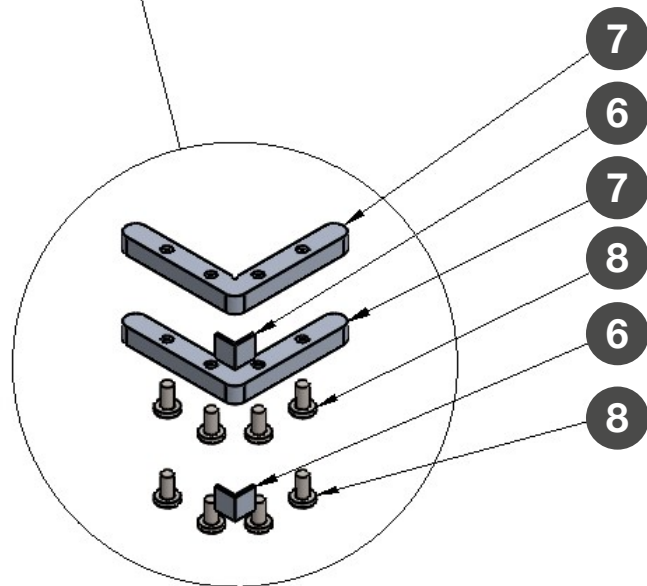
It is the responsibility of the appointed holder of the manual to ensure that the information supplied is correctly inserted into the manual and acceptance returned.

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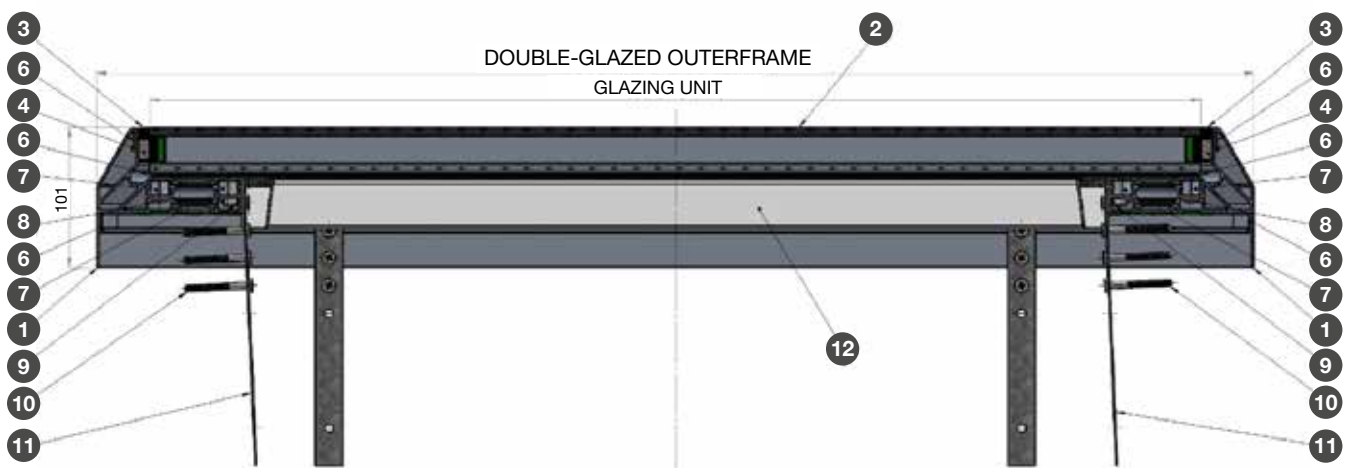
# EXPLODED VIEW



# DETAIL VIEW



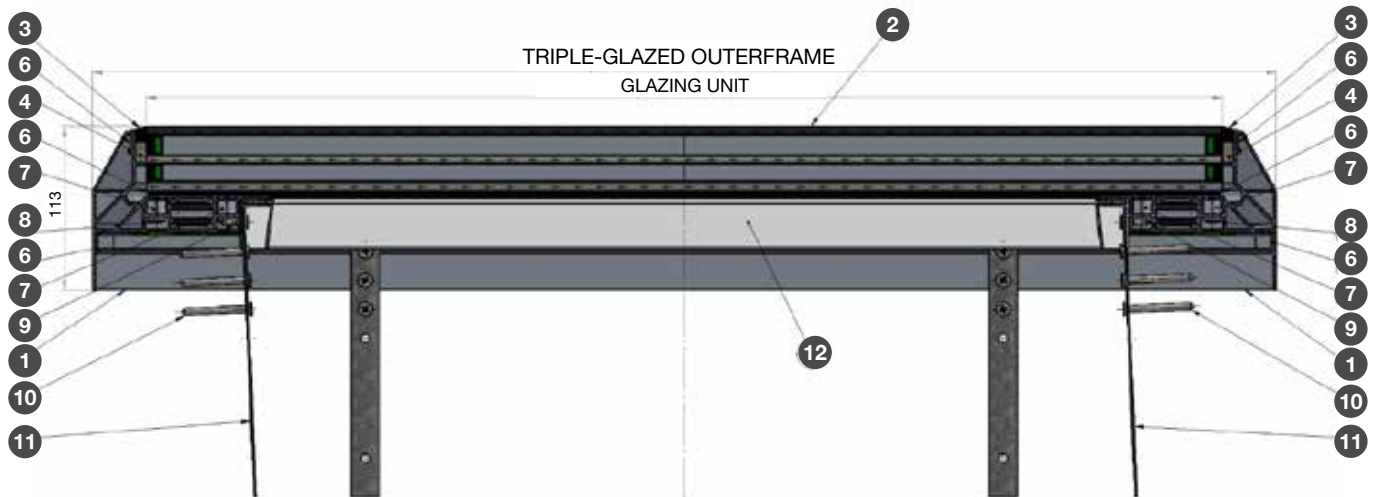
## CROSS SECTION - DOUBLE-GLAZED



## PARTS LIST

ITEM	PART No.	DESCRIPTION
1	FRL5501ABKM	FRL OUTER FRAME - DOUBLE-GLAZED - MATT BLACK
1	FRL5501AW	FRL OUTER FRAME - DOUBLE-GLAZED - WHITE
2	N/A	TRIPLE-GLAZED IGU
3	FRL5403BK	FORMOA 066 WEATHER SEAL
4	FRL5401GY	BACKING ROD - Ø10MM
5	FRL5402BK	STRUCTURAL GLAZING TAPE
6	FRL5504A	ANGLE CLEAT
7	FRL5503A	CORNER BRACKET
8	FRL5602	PAN HEAD SETSCREW M6 x 12MM
9	FRL5603	SELF DRILLING SCREW 4.8 x 16MM
10	FRL5604	WOODSCREW 5.0 x 50MM
11	FRL5601S	FIXING PLATE
12	ET12564	INTERNAL TRIM

# CROSS SECTION - TRIPLE-GLAZED



## PARTS LIST

ITEM	PART No.	DESCRIPTION
1	FRL5502ABKM	FRL OUTER FRAME - TRIPLE-GLAZED - MATT BLACK
1	FRL5502AW	FRL OUTER FRAME - TRIPLE-GLAZED - WHITE
2	N/A	TRIPLE-GLAZED IGU
3	FRL5403BK	FORMOA 066 WEATHER SEAL
4	FRL5401GY	BACKING ROD – Ø10MM
5	FRL5402BK	STRUCTURAL GLAZING TAPE
6	FRL5504A	ANGLE CLEAT
7	FRL5503A	CORNER BRACKET
8	FRL5602	PAN HEAD SETSCREW M6 x 12MM
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10	FRL5604	WOODSCREW 5.0 x 50MM
11	FRL5601S	FIXING PLATE
12	ET12564	INTERNAL TRIM

# SPECIFICATION

## FRAME SPECIFICATION

- ▶ Thermally broken T5-6063 aluminium frame sections combine strength with lightweight construction.
- ▶ Frame design includes internal drainage feature in case external weatherseal becomes compromised.
- ▶ Marine grade powder coated surface finish to withstand harshest weather conditions. All powder coating to QUALICOAT standards and specifications which generally exceeds the BS EN 12206 specification for powder coating.

Standard Colours:

Black	RAL 9005 CM
White	RAL 9003

(Special colours available on request, special colours are sprayed onto White profile)

## PITCH RANGE

This document and information contained herein is based upon an installation pitch of 2.5°.

**PLEASE NOTE:** Luma units can be installed up to a maximum pitch of 10°. Please seek technical advice to confirm order sizes on any Luma units to be installed at a pitch angle greater than 2.5°.

# MAXIMUM SIZE

Luma rooflights maximum sizes are restricted by glass maximum area of 2.5m<sup>2</sup> for double glazed and 2m<sup>2</sup> for triple glazed or maximum length of 3200m.

Maximum rectangular size    Opening 3000mm x 650mm

Maximum square size        Opening 1440mm x 1440mm

		LENGTH ORDER SIZE													
		500	600	700	800	900	1000	1100	1200	1300	1400	1500	1600	1650	1700
DEPTH ORDER SIZE (RECOMMEND WIDTH IS SMALLEST SIDE)	500	0.406	0.469	0.533	0.597	0.661	0.724	0.788	0.852	0.915	0.979	1.043	1.106	1.138	1.170
	550	0.438	0.506	0.575	0.644	0.712	0.781	0.850	0.919	0.987	1.056	1.125	1.193	1.228	1.262
	600	0.469	0.543	0.617	0.691	0.764	0.838	0.912	0.985	1.059	1.133	1.206	1.280	1.317	1.354
	650	0.501	0.580	0.659	0.737	0.816	0.895	0.974	1.052	1.131	1.210	1.288	1.367	1.406	1.446
	700	0.533	0.617	0.701	0.784	0.868	0.952	1.035	1.119	1.203	1.286	1.370	1.454	1.496	1.538
	750	0.565	0.654	0.742	0.831	0.920	1.009	1.097	1.186	1.275	1.363	1.452	1.541	1.585	1.629
	800	0.597	0.691	0.784	0.878	0.972	1.065	1.159	1.253	1.346	1.440	1.534	1.628	1.674	1.721
	850	0.629	0.727	0.826	0.925	1.024	1.122	1.221	1.320	1.418	1.517	1.616	1.714	1.764	1.813
	900	0.661	0.764	0.868	0.972	1.075	1.179	1.283	1.386	1.490	1.594	1.698	1.801	1.853	1.905
	950	0.692	0.801	0.910	1.019	1.127	1.236	1.345	1.453	1.562	1.671	1.779	1.888	1.942	1.997
	1000	0.724	0.838	0.952	1.065	1.179	1.293	1.406	1.520	1.634	1.748	1.861	1.975	2.032	2.089
	1050	0.756	0.875	0.994	1.112	1.231	1.350	1.468	1.587	1.706	1.824	1.943	2.062	2.121	2.181
	1100	0.788	0.912	1.035	1.159	1.283	1.406	1.530	1.654	1.778	1.901	2.025	2.149	2.211	2.272
	1150	0.820	0.949	1.077	1.206	1.335	1.463	1.592	1.721	1.849	1.978	2.107	2.236	2.300	2.364
	1200	0.852	0.985	1.119	1.253	1.386	1.520	1.654	1.788	1.921	2.055	2.189	2.322	2.389	2.456
	1250	0.884	1.022	1.161	1.300	1.438	1.577	1.716	1.854	1.993	2.132	2.271	2.409	2.479	2.548
1300	0.915	1.059	1.203	1.346	1.490	1.634	1.778	1.921	2.065	2.209	2.352	2.496	2.568	2.640	
1350	0.947	1.096	1.245	1.393	1.542	1.691	1.839	1.988	2.137	2.286	2.434	2.583	2.657	2.732	
1400	0.979	1.133	1.286	1.440	1.594	1.748	1.901	2.055	2.209	2.362	2.516	2.670	2.747	2.823	

		LENGTH ORDER SIZE												
		1800	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000
DEPTH ORDER SIZE (RECOMMEND WIDTH IS SMALLEST SIDE)	500	1.234	1.298	1.361	1.425	1.489	1.552	1.616	1.680	1.743	1.807	1.871	1.935	1.998
	550	1.331	1.399	1.468	1.537	1.606	1.674	1.743	1.812	1.880	1.949	2.018	2.086	2.155
	600	1.428	1.501	1.575	1.649	1.722	1.796	1.870	1.943	2.017	2.091	2.165	2.238	2.312
	650	1.524	1.603	1.682	1.761	1.839	1.918	1.997	2.075	2.154	2.233	2.311	2.390	2.469
	700	1.621	1.705	1.789	1.872	1.956	2.040	2.123	2.207	2.291	2.375	2.458	2.542	2.626
	750	1.718	1.807	1.896	1.984	2.073	2.162	2.250	2.339	2.428	2.516	2.605	2.694	2.783
	800	1.815	1.909	2.002	2.096	2.190	2.283	2.377	2.471	2.565	2.658	2.752	2.846	2.939
	850	1.912	2.011	2.109	2.208	2.307	2.405	2.504	2.603	2.701	2.800	2.899	2.998	3.096
	900	2.009	2.112	2.216	2.320	2.423	2.527	2.631	2.735	2.838	2.942	3.046	3.149	3.253
	950	2.106	2.214	2.323	2.432	2.540	2.649	2.758	2.866	2.975	3.084	3.193	3.301	3.410
	1000	2.202	2.316	2.430	2.543	2.657	2.771	2.885	2.998	3.112	3.226	3.339	3.453	3.567
	1050	2.299	2.418	2.537	2.655	2.774	2.893	3.011	3.130	3.249	3.368	3.486	3.605	3.724
	1100	2.396	2.520	2.643	2.767	2.891	3.015	3.138	3.262	3.386	3.509	3.633	3.757	3.880
	1150	2.493	2.622	2.750	2.879	3.008	3.136	3.265	3.394	3.523	3.651	3.780	3.909	4.037
	1200	2.590	2.723	2.857	2.991	3.125	3.258	3.392	3.526	3.659	3.793	3.927	4.060	4.194
	1250	2.687	2.825	2.964	3.103	3.241	3.380	3.519	3.658	3.796	3.935	4.074	4.212	4.351
1300	2.783	2.927	3.071	3.215	3.358	3.502	3.646	3.789	3.933	4.077	4.220	4.364	4.508	
1350	2.880	3.029	3.178	3.326	3.475	3.624	3.773	3.921	4.070	4.219	4.367	4.516	4.665	
1400	2.977	3.131	3.285	3.438	3.592	3.746	3.899	4.053	4.207	4.360	4.514	4.668	4.822	

# GLAZED UNITS

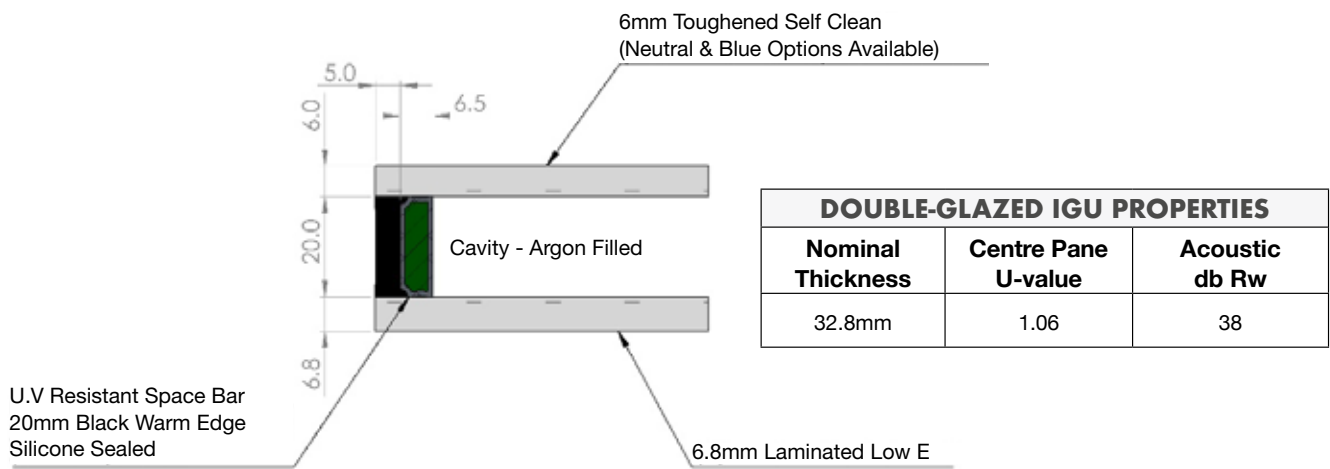
Luma glazing units consist of toughened and laminated glazing panes allowing installation above 5 metres above floor level and swimming pools / hot tubs.

Manufacturing standards for Glazed Units

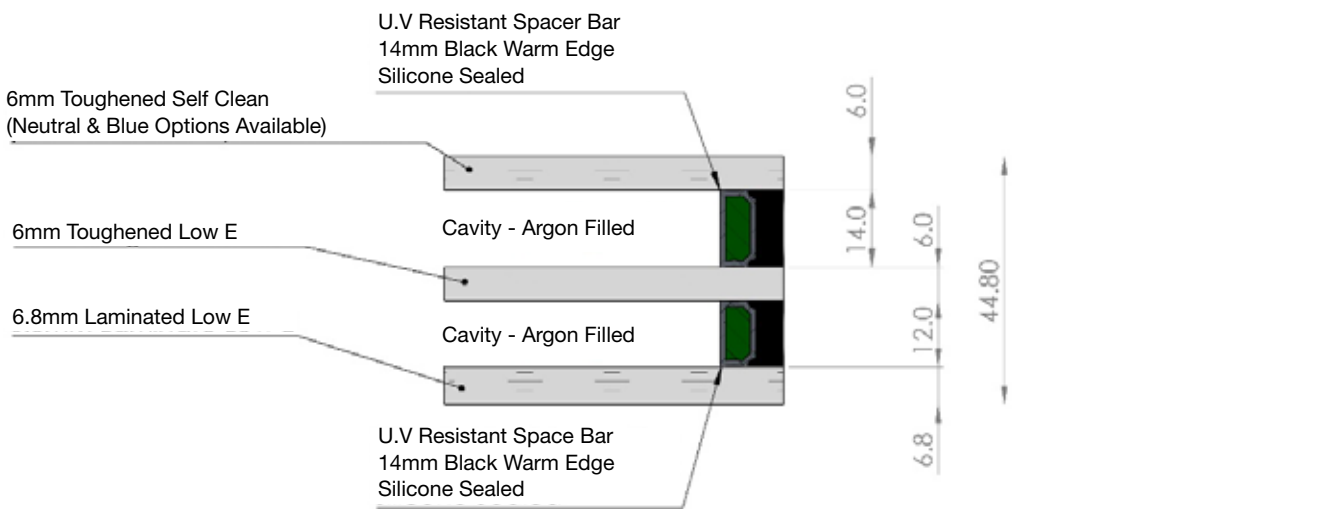
- ▶ Toughened to BS EN 12150
- ▶ Manufactured to BS EN 1279 Part 2 & 3

Easy Clean glass on all products as standard – keeps glass cleaner longer and minimises cleaning effort.

## DOUBLE-GLAZED OPTION – 30KG/M<sup>2</sup>



## TRIPLE-GLAZED OPTION – 45KG/M<sup>2</sup>

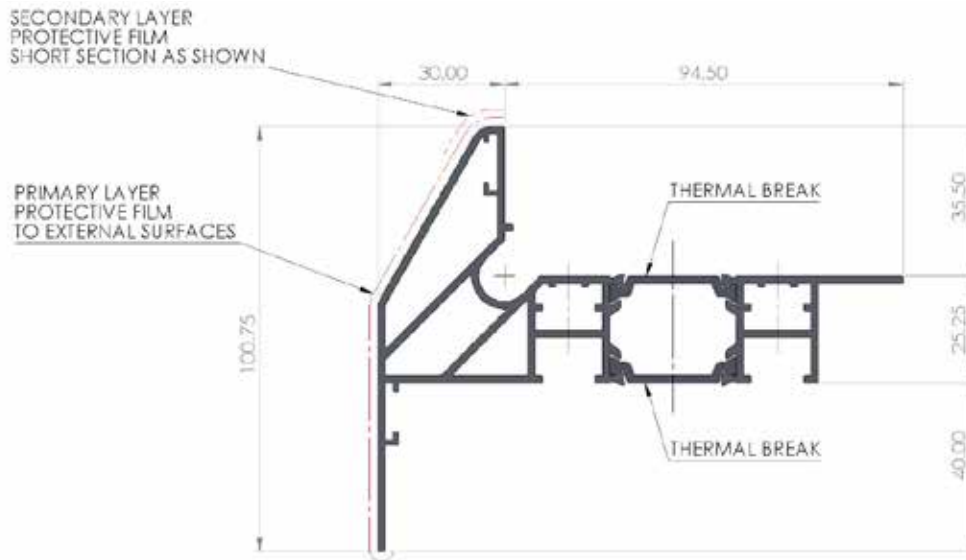


TRIPLE-GLAZED IGU PROPERTIES		
Nominal Thickness	Centre Pane U-value	Acoustic db Rw
44.8mm	0.62	40



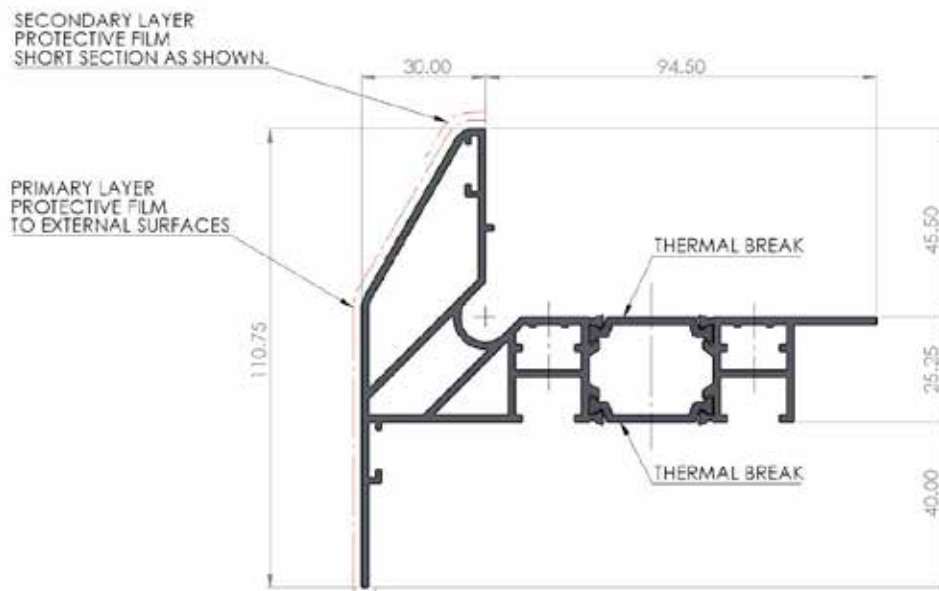
# COMPONENTS

## ITEM 1 (DOUBLE-GLAZED)



Item	Part No.	Description	Length
1	FRL5501ABKM	FRL OUTER FRAME - DOUBLE-GLAZED - MATT BLACK	6.5M
1	FRL5501AW	FRL OUTER FRAME - DOUBLE-GLAZED - WHITE	6.5M

## ITEM 1 (TRIPLE-GLAZED)



Item	Part No.	Description	Length
1	FRL5502ABKM	FRL OUTER FRAME - TRIPLE-GLAZED - MATT BLACK	6.5M
1	FRL5502AW	FRL OUTER FRAME - TRIPLE-GLAZED - WHITE	6.5M

## ITEM 2

Formoa® 066 Black is a 3-in-1 Sealant Adhesive (Grabs, Bonds & Seals). Unique adhesion on virtually any material, without the need for any mechanical fixings. Formoa® 066 primary function is for bonding, but it is also more than capable as a sealant too with proven compatibility for use with self-cleaning glass systems. This self-cleaning glass sealant must be used when installing a Eurocell self-cleaning glass system for a professional finish.

Item	Part No.	Description	Pack QTY
2	FRL5403BK	FORMOA 066 WEATHER SEAL 290ml	1



## ITEM 3

FRL5401GY is a closed cell polyethylene (PE) circular foam suitable for providing a backer to sealant joints, avoiding three-sided adhesion. FRL5401GY is rot-proof and chemically neutral and is used as a foam backing rod behind the sealant joint, for quality sealant work. When positioned correctly it ensures correct joint dimensions.

Item	Part No.	Description	Pack QTY
3	FRL5401GY	BACKING ROD – Ø10MM 1150M	1 ROLL



## ITEM 4

FRL5402BK is a high-quality structural glazing spacer tape. It is coated on both sides with high tack acrylic adhesive with blue filmic liner for easy release. It has an open cell structure to allow curing of structural silicones on all sides of the joint.

Item	Part No.	Description	Pack QTY
4	FRL5402BK	STRUCTURAL GLAZING TAPE 85mm x 3mm – 15M	1 ROLL



## ITEM 5

Item	Part No.	Description	Pack QTY
5	FRL5504A	ANGLE CLEAT	8



## ITEM 6

Item	Part No.	Description	Pack QTY
6	FRL5503A	CORNER BRACKET	8



## ITEM 7



## ITEM 8



## ITEM 9



Item	Part No.	Description	Pack QTY
7	FRL5602	PAN HEAD SETSCREW M6 x 12MM	100
8	FRL5603	SELF DRILLING SCREW 4.8 x 16MM	100
9	FRL5604	WOODSCREW 5.0 x 50MM	100

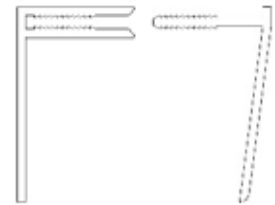
## ITEM 10



Item	Part No.	Description	Pack QTY
10	FRL55601S	FIXING PLATE	16

## ITEM 11

Item	Part No.	Description	Pack QTY
11	ET12654	INTERNAL TRIM 5M	1



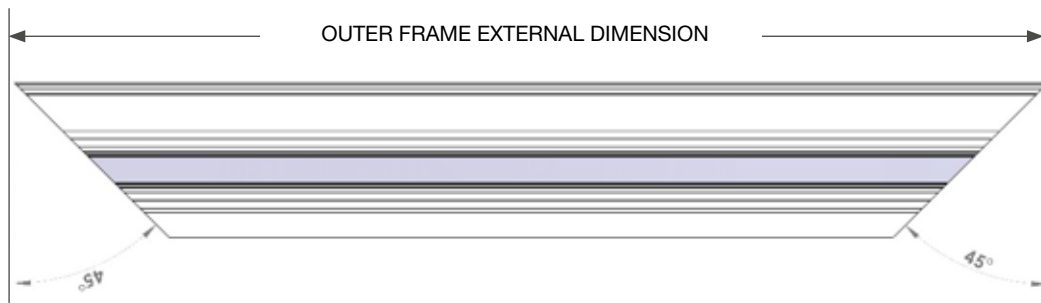
# TOOLS & EQUIPMENT

PART No.	DESCRIPTION	
N/A	Power Drill	
N/A	Ø7.0mm HSS DRILL BIT	
N/A	Ø8.0mm HSS DRILL BIT	
N/A	Power Driver	
SGPOWER	Caulking Gun	
ESJ17001	FRL Corner Cleat Drill Jig	
ESJ17004	FRL IGU Assembly Guide Pack	
N/A	Hand Roller – 100mm	
STA033719	Tape Measure	
STA210122	Retractable Knife	
N/A	Combination Square	
N/A	Frame Clamp	

# FABRICATION

## OUTER FRAME

1.0

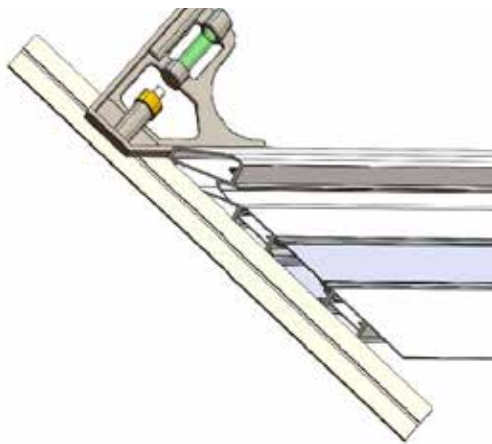


Cut four sections of FRL Outer Frame profiles to length incorporating 45° mitre faces to each end.

QTY	LOCATION	DEDUCTION	TOLERANCE
2	HEAD/BASE	$L = (\text{ORDER LENGTH}) + 209\text{mm}$	+/- 1.0mm
2	SIDE JAMBS	$L = (\text{ORDER HEIGHT}) + 209\text{mm}$	+/- 1.0mm

Deburr where necessary to ensure clean face to face joint.

1.1



Check all measurements and angle cut faces are correct and in accordance with cutting list

1.2



Invert outer frame section and locate FRL Corner Cleat Drill Jig into position one ensuring angle faces fully connect and secure in place with tension screw.

Drill two Ø7.0mm clearance holes through single aluminium wall only.

Remove FRL Corner Cleat Jig.

### 1.3



Locate FRL Corner Cleat Drill Jig into position two ensuring angle faces fully connect and secure in place with tension screw

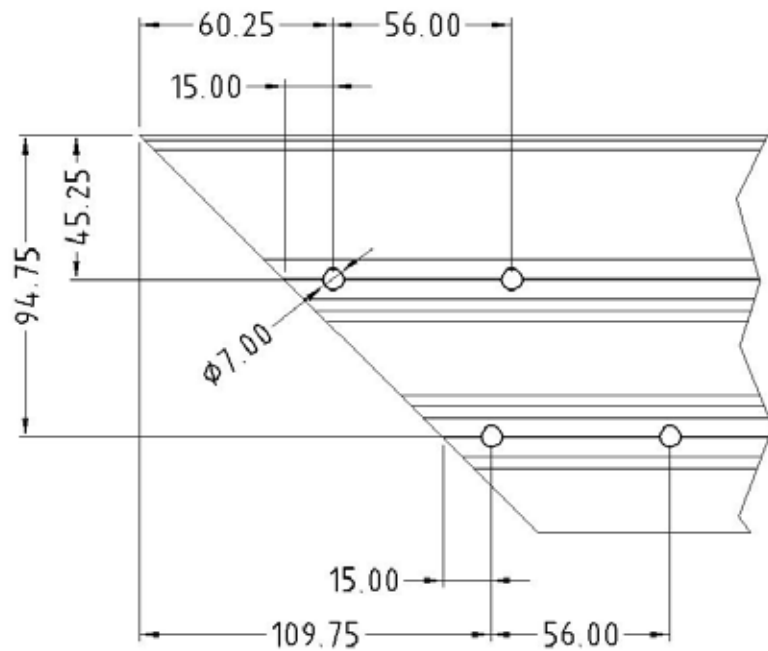
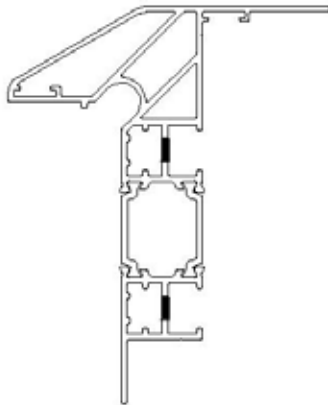
Drill two  $\text{\O}7.0\text{mm}$  clearance holes through single horizontal flange only.

Remove FRL Corner Cleat Jig.

Deburr where necessary and remove all swarf.

Repeat above process to all mitred ends of outer frame sections.

### 1.4



Below shows Outer Frame corner cleat hole positions.

# BASE PROFILE

2.0

Locate the base profile and identify by applying label to protective tape on external surface so it is clearly visible

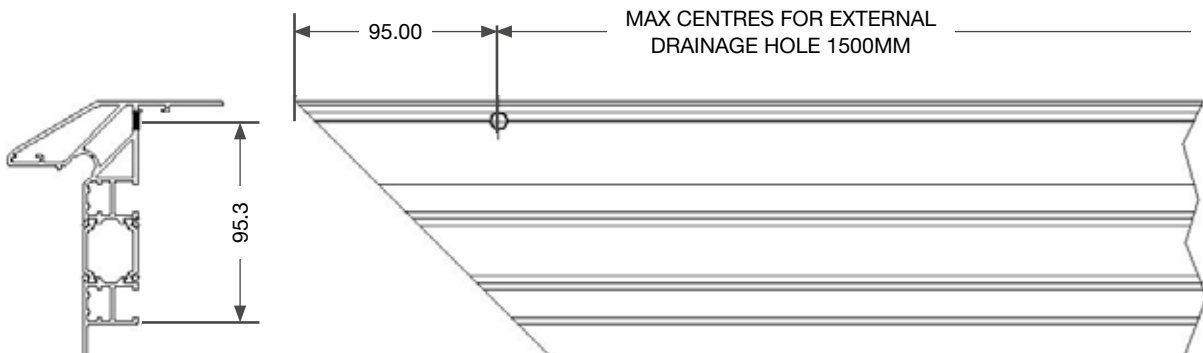
## Luma Base/Drainage Section



On the head and base outer frame, using the v groove as a positional guide, drill  $\varnothing 8.0\text{mm}$  drainage holes at 95mm away from both ends on the underside of profile through a single aluminium wall only.

If the distance between both holes exceeds 1500mm then add further intermediate holes, ensuring maximum 1500mm centres.

Deburr where necessary and remove all swarf.



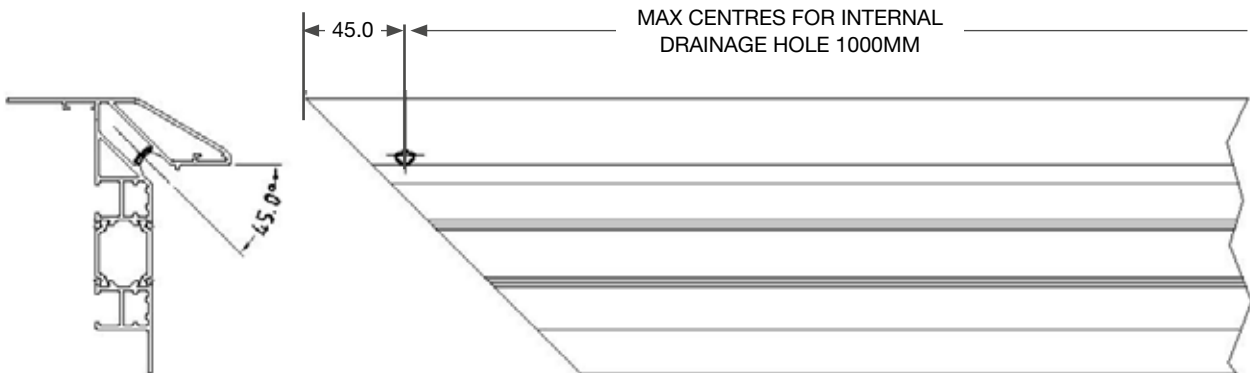
## 2.1



On the head and base outer frame, using the v groove as a positional guide, drill  $\text{Ø}8.0\text{mm}$  drainage holes at 45mm away from both ends on the upperside of profile through a single aluminium wall only.

If the distance between both holes exceeds 1000mm then add further intermediate holes, ensuring maximum 1000mm centres.

**Ensure any intermediate holes are positioned a minimum of 75mm away from drainage holes on the underside.**

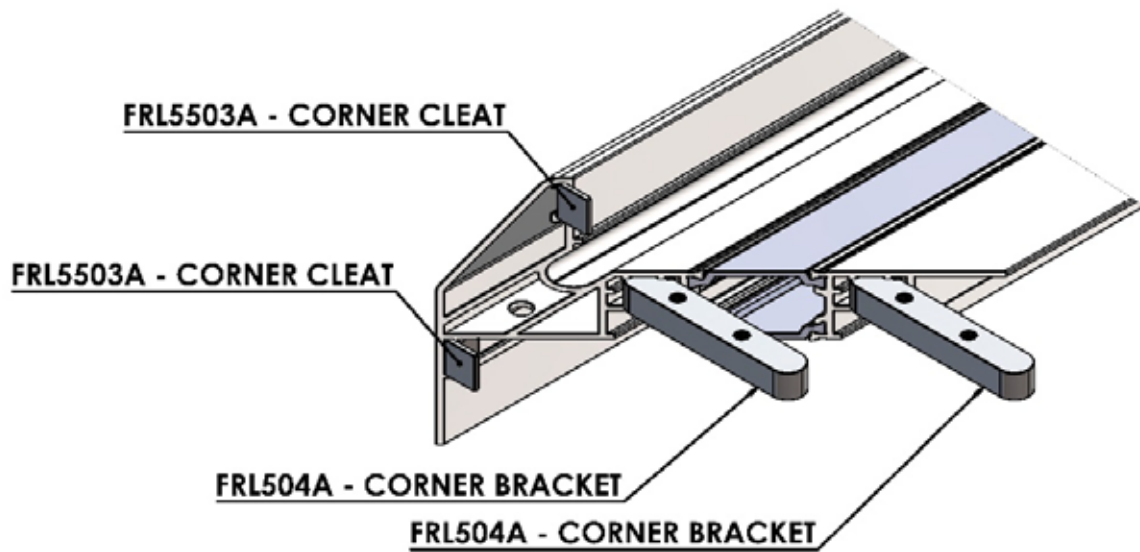


Deburr where necessary and remove all swarf.



## LOCATE TOP AND BASE PROFILES

3.0



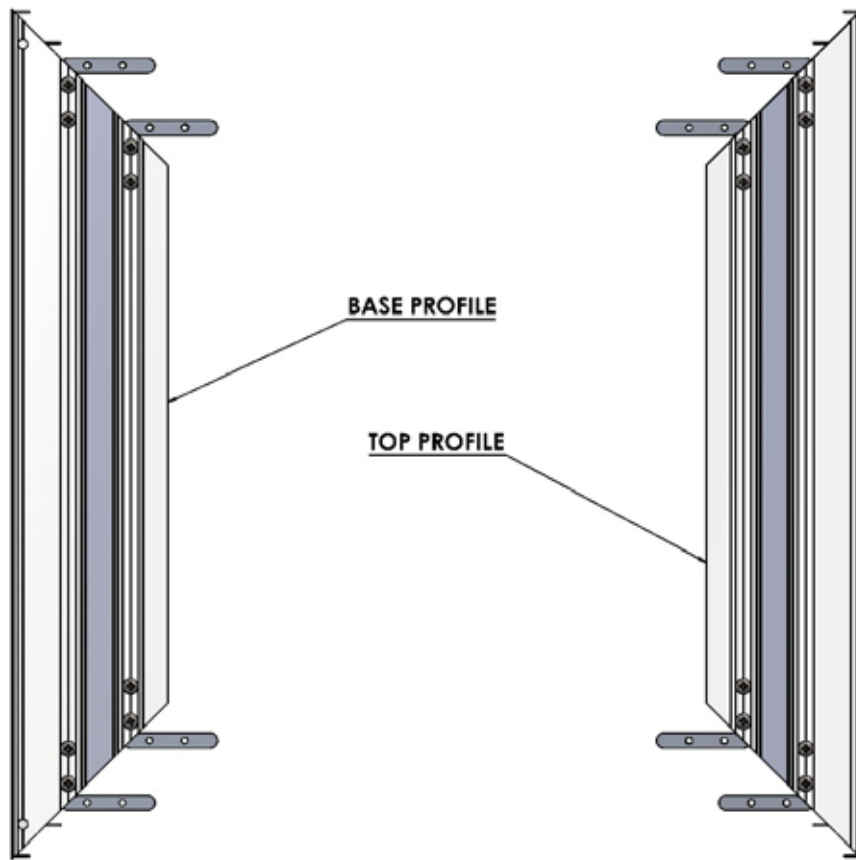
Insert FRL5504A-Corner Brackets and FRL5503A-Corner Cleats into both end of Top and Base profiles.

3.1



Secure FRL5504A-Corner Brackets in place using FRL602- PAN HEAD SETSCREW M6 x 12MM

### 3.2



At this stage, except for drainage holes, the Base and Top profiles should be the same.  
Locate side profiles.  
Clean and de-grease all cut angled faces.

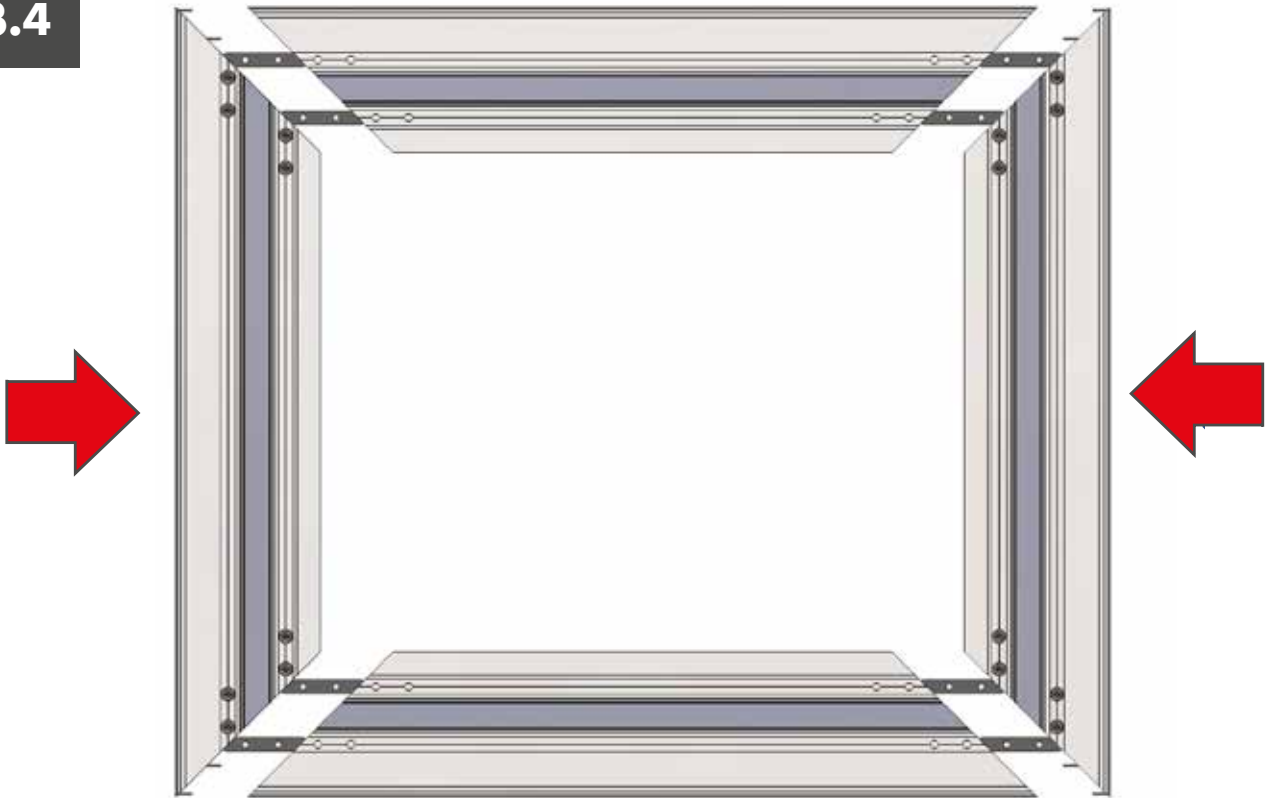
### 3.3



Carefully apply Forgeway Formoa 066 Black sealant to mitred faces of outer section only of side profiles.

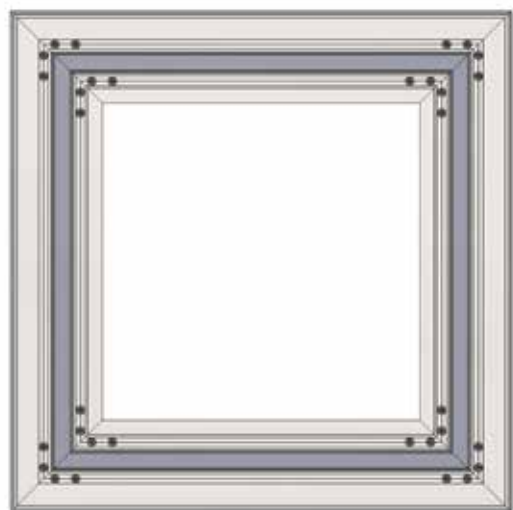
**NOTE: No sealant to be applied to the thermal breaks or inner section**

### 3.4



Carefully slide profiles to base and top profiles ensuring FRL5504A-Corner Brackets, FRL5503A-Corner Cleats and mitred faces are fully and accurately engaged.

### 3.5



Using a frame clamping tool compress the outer frame assembly and check squareness, then secure all corners using additional FRL5602- PAN HEAD SETSCREW M6 x 12MM

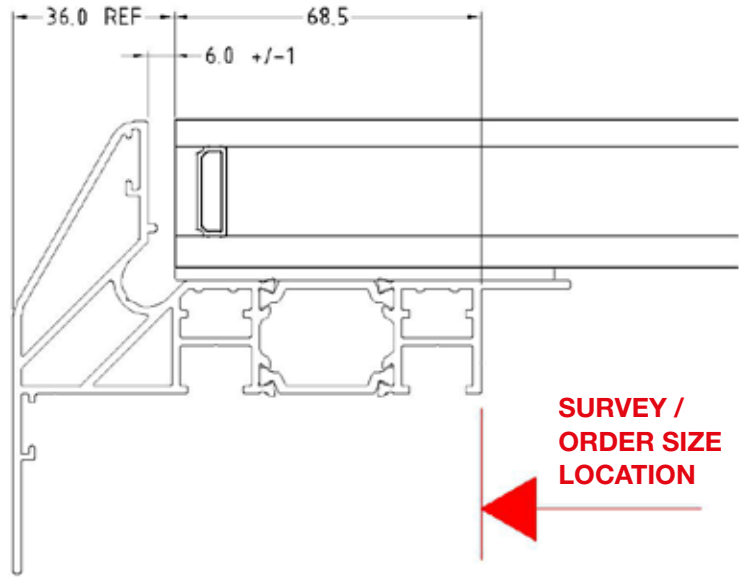
Clean away any excess sealant from corners.

# GLAZING

The Luma glazing should be ordered to the below glazing deductions.

## 4.0

DEDUCTION	TOLERANCE
GLAZING LENGTH = (ORDER LENGTH) + 137mm	+/- 1.0mm
GLAZING HEIGHT = (ORDER HEIGHT) + 137mm	+/- 1.0mm

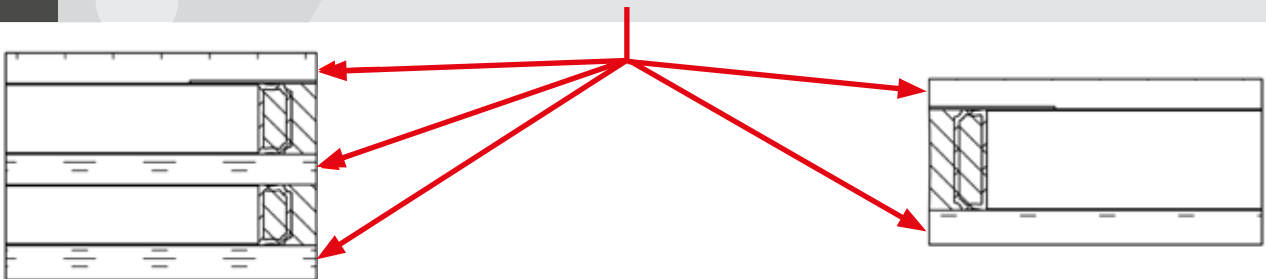


Now Luma outer frame is fully assembled clean and degrease inner aperture prior to inserting glazing unit.

Locate glazing unit and visually check for any damage and measure to ensure overall dimensions comply with dimensions specified in work pack.

## 4.1

**Important: Check peripheral edge glass surfaces are clean and free from any surface contamination. (Applies to all edge surfaces)**



Clean/degrease all surfaces of glazing unit ensuring cleaning/degreasing solution used is fully compatible with self-cleaning glass surfaces.

Position glazing unit with bottom/laminate pane facing upward.

Cut two (2) lengths of FRL5402BK-Structural Glazing Tape to match length of glazing unit and two (2) lengths to match width of glazing unit.

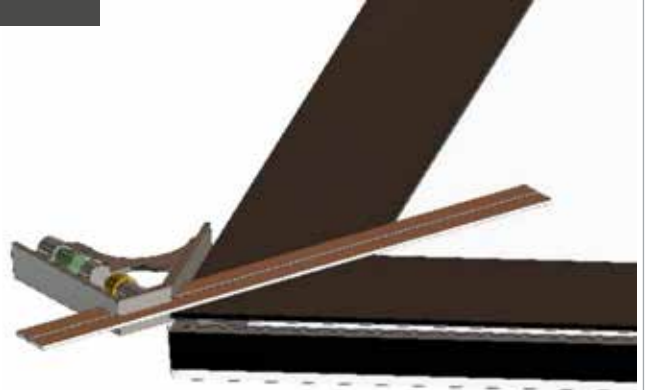
## APPLYING GLAZING TAPE

5.0



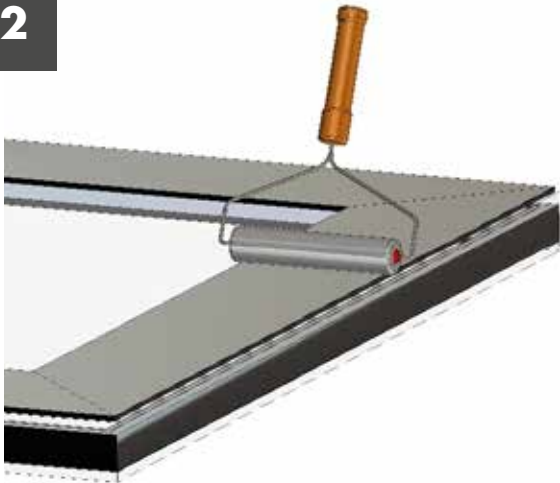
Using combination square and retractable knife neatly and carefully 45° mitre cut the ends of each section of FRL5402BK-Structural Glazing Tape before applying to glazing unit.

5.1



Ensuring glazing unit is positioned with bottom/laminate pane facing upward, take each section of FRL5402BK-Structural Glazing Tape remove lower section of adhesive backing film and position on corresponding edge of the glazing unit taking care to all edges and mitred corners are in-line and match.

5.2



Use hand roller to ensure FRL5402BK-Structural Glazing Tape is fully adhered to glazing unit and all air pockets between contact surfaces are disbursed.

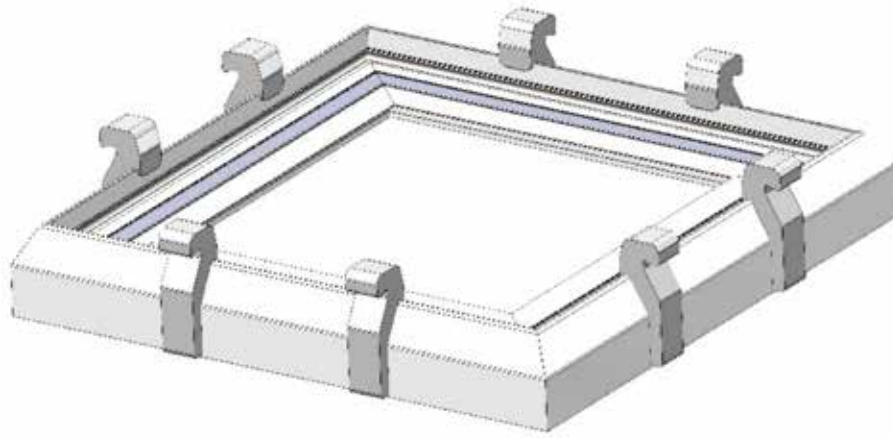
5.1



Locate ESJ17004-FRL IGU Assembly Guides and position on assembled Luma outer frame before inserting glazing unit – minimum two (2) guides per side.

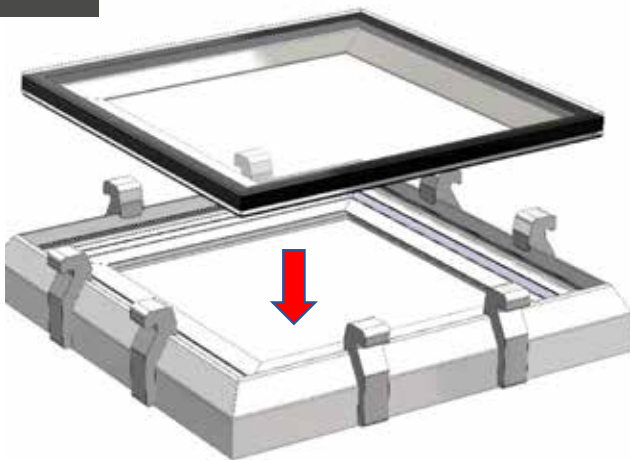
## ASSEMBLY GLAZING UNIT

### 6.0



Before actual assembly of glazing unit into outer frame, first perform test assembly to ensure dimensional accuracy of assembled outer frame and glazing unit.

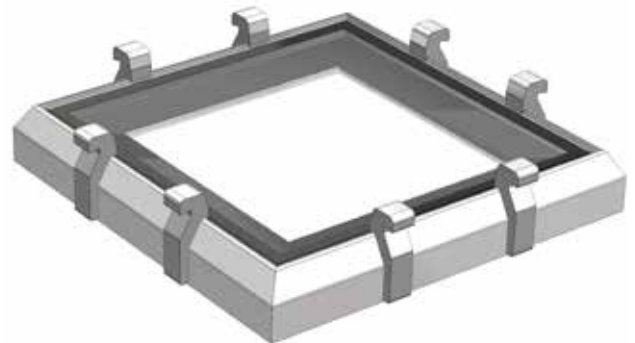
### 6.1



For test assembly carefully invert glazing unit to ensure self-clean glass pane is facing upward upper and laminate surface containing FRL5402BK-Structural Glazing Tape is facing downward.

Carefully lower and locate glazing unit into outer frame utilising ESJ17004-FRL IGU Assembly Guides to centralise glazing unit in the outer frame.

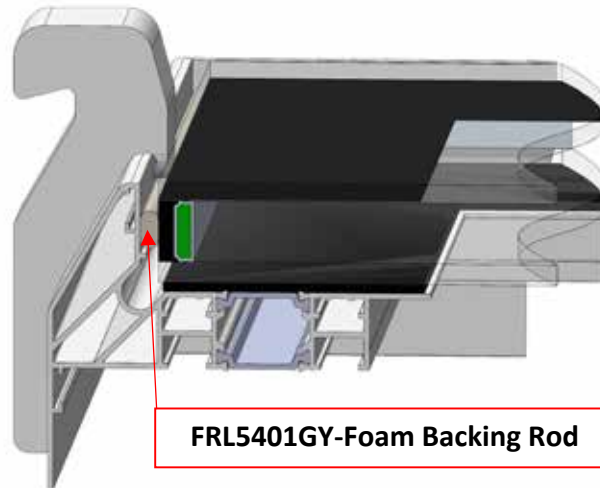
### 6.2



On satisfactory completion of test, carefully remove glazing unit from outer frame and remove outer section of adhesive backing film from all sections of FRL5402BK-Structural Glazing Tape and carefully lower and locate glazing unit into outer frame again, utilising ESJ17004-FRL IGU Assembly Guides to centralise glazing unit in the outer frame.

When glazing unit is securely in position, remove all ESJ17004-FRL IGU Assembly Guides.

## 6.3

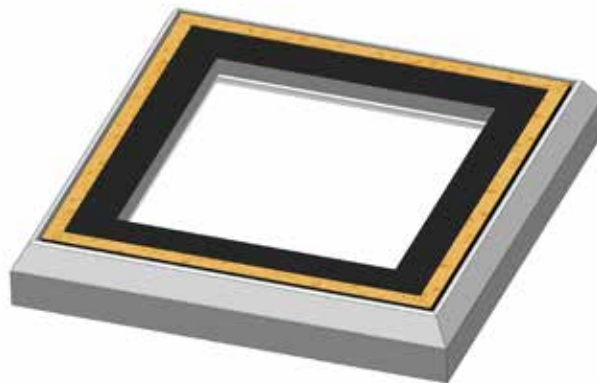


Locate FRL5401GY-Foam Backing Rod and carefully compress and introduce into the internal void between the glazing unit and the outer frame on all four (4) sides.

Use ESJ17004-FRL IGU Assembly Guide to set FRL5401GY-Foam Backing Rod to the required depth of 8mm from top edge of outer frame along the perimeter of the void.

When FRL5401GY-Foam Backing Rod has been successfully introduced to all voids remove ESJ17004-FRL IGU Assembly Guide and prepare for introduction of FRL5403BK-Weather Seal.

## 6.4



Carefully apply masking tape to outer perimeter of glazing unit ensuring edges of masking tape and glazing unit are in-line.

## 6.5



Any overlaps of masking tape to glass edge should be trimmed back to glass edge to ensure a continuous and even edge finish.

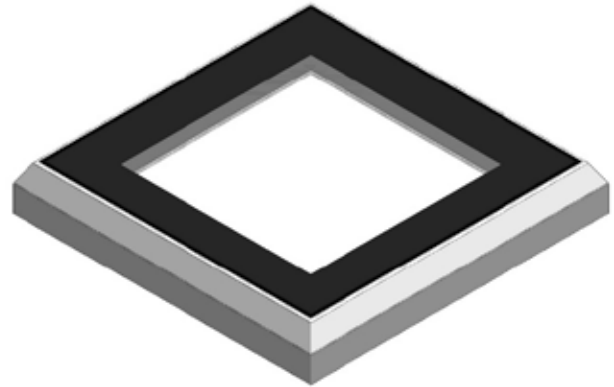
Proceed to apply FRL5403BK-Weather Seal to the internal void between the glazing unit and the outer frame on all four (4) sides.

Carefully apply the sealant in a smooth and even application movement slightly over filling the void to allow finishing.

When application of FRL5403BK-Weather Seal is complete remove any excess sealant with a silicone scrapper tool to ensure a smooth, even and continuous finish to all four (4) sides.

Leave sealant to stand for approximately 15 minutes before removing masking tape and secondary layer of protective tape on outer frame to leave a clean, neat and continuous seal finish

## 6.6



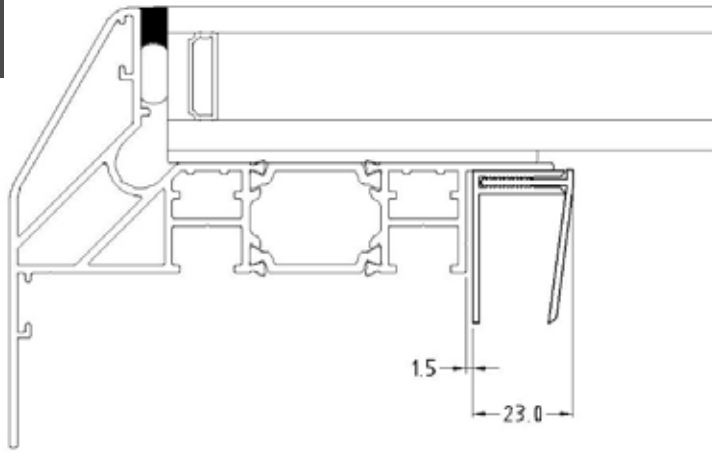
Completed units should be left in a stable and level position for seventy-two (72) hours to ensure necessary curing of weather seal.

On completion of curing period, finished units can be packaged, labelled, and prepared for delivery.



# CALCULATIONS

## 7.0

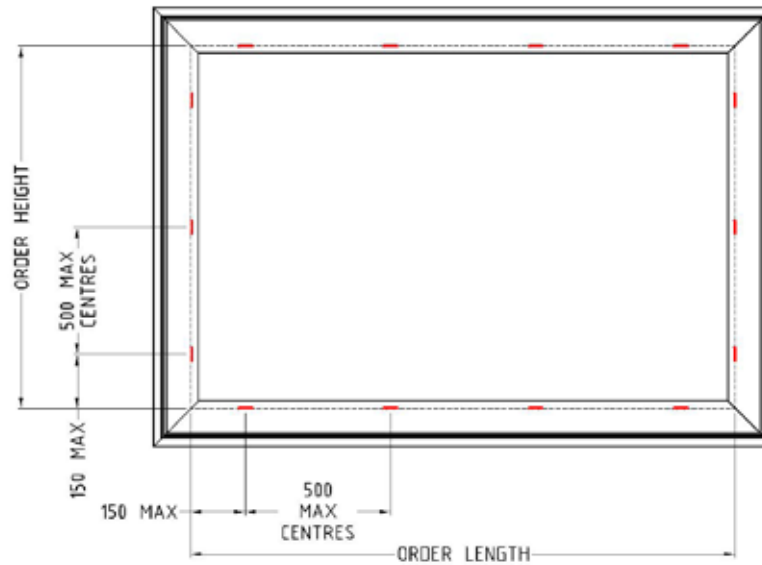


ET12564 Internal trim cutting constants shown below.

As ET12564 is a two part component, ET12564-F represents the F section and ET12564-M represents the male clip in section.

QTY	LOCATION	PART No.	DEDUCTION	PREP LEFT	PREP RIGHT	TOLERANCE
2	HEAD/BASE	ET12564-F	$L = (\text{ORDER LENGTH}) - 3\text{mm}$	SQUARE	SQUARE	+/- 1.0mm
2	HEAD/BASE	ET12564-M	$L = (\text{ORDER LENGTH}) - 45\text{mm}$	SQUARE	SQUARE	+/- 1.0mm
2	SIDE JAMBS	ET12564-F	$L = (\text{ORDER HEIGHT}) - 49\text{mm}$	SQUARE	SQUARE	+/- 1.0mm
2	SIDE JAMBS	ET12564-M	$L = (\text{ORDER HEIGHT}) - 49\text{mm}$	SQUARE	SQUARE	+/- 1.0mm

## 7.1



Fixing strap and fixing screws quantity calculations show below

Example.  $1500\text{mm} - (2 \times 150\text{mm}) = 1200\text{mm}$ ,  $1200\text{mm}/500\text{mm} = 2.4$ , therefore round down to 3 then add 2 giving total of 5 fixing plates for the calculated edge.

QTY	LOCATION	PART No.	DEDUCTION	PREP LEFT	PREP RIGHT	TOLERANCE
2	HEAD/BASE	ET12564-F	$L = (\text{ORDER LENGTH}) - 3\text{mm}$	SQUARE	SQUARE	+/- 1.0mm
2	HEAD/BASE	ET12564-M	$L = (\text{ORDER LENGTH}) - 45\text{mm}$	SQUARE	SQUARE	+/- 1.0mm
2	SIDE JAMBS	ET12564-F	$L = (\text{ORDER HEIGHT}) - 49\text{mm}$	SQUARE	SQUARE	+/- 1.0mm
2	SIDE JAMBS	ET12564-M	$L = (\text{ORDER HEIGHT}) - 49\text{mm}$	SQUARE	SQUARE	+/- 1.0mm

## CONTACT

For further information, contact the Eurocell Technical Team on **01773 842100**. Visit **[eurocell.co.uk](https://eurocell.co.uk)** to find installation guides and videos for Eurocell products.

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