

# FITTING INSTRUCTIONS

COMMERCIAL HINGES

SECTION 2.1 SHEET 1 of 14

ISSUE: May, 2003

## FITTING INSTRUCTIONS: Position and Clearances

### STERLING® and Sterling STORM® Standard Hinge Series

2.1.1 Storm Standard hinges are designed to be fitted between two flat and parallel rigid faces that conform to the measurements shown below. If the cavity height is greater than 0.63" - 0.71" (16 - 18 mm), use a highland hinge of similar specification.

2.1.2 The vent and outer frame hinge location recess or upstaged, if any, must be as shown below. On profiles where the two parallel faces are not flat use packers to fill any recess to bring the cavity to 0.63" - 0.71" (16 - 18mm). (See sheet 2.1.7 for notes on fitting packers)

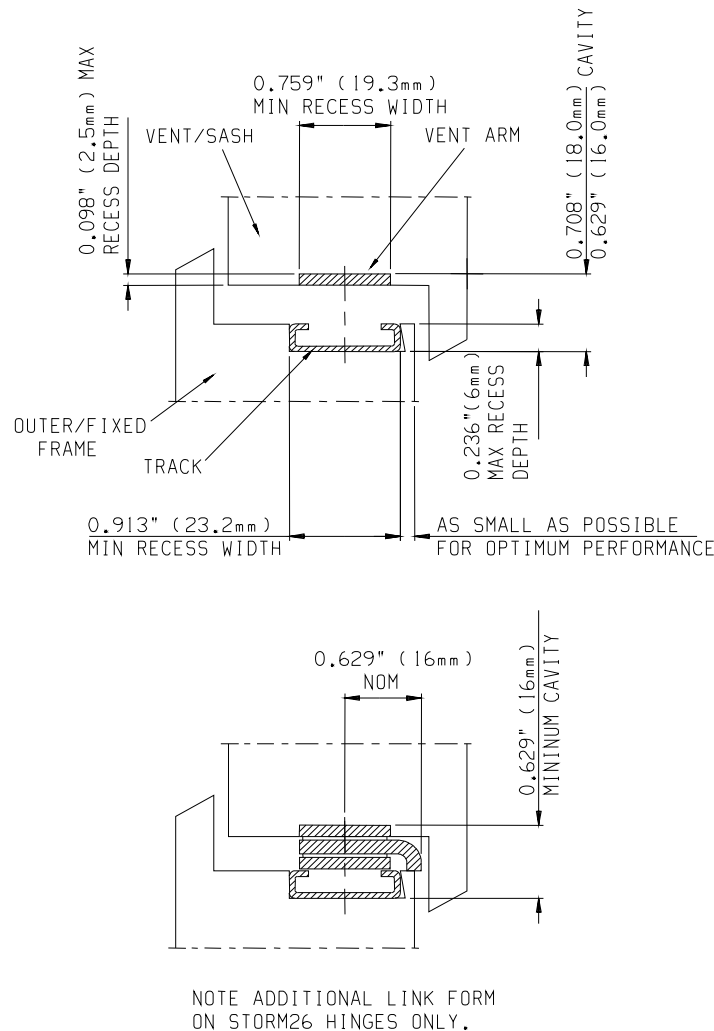


Fig. 1

2.1.3 The hinge should be fitted with the end cap located into the internal corner of the outer frame (except when using adjustment device (S7275 imperial or S7280 metric) fit 0.078" (2mm) away). Use all holes and slots to ensure optimum performance and weather sealing.

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## FITTING INSTRUCTIONS: Position and Clearances

### STERLING® and Sterling STORM® H Shim Hinge Series

2.1.4 The STORM H Shim Series hinges are designed to be fitted between two flat and parallel rigid faces that conform to the measurements shown below. If the cavity height is less than 0.748" - 0.827" (19 - 21mm), use a hinge of similar specification from the Standard series.

2.1.5 The vent and outer frame hinge location recess or up stand, if any, must be as shown below. On profiles where the two parallel faces are not flat use packers to fill any recess to bring the cavity to 0.748" - 0.827" (19 - 21mm). (See sheet 4 for notes on fitting packers)

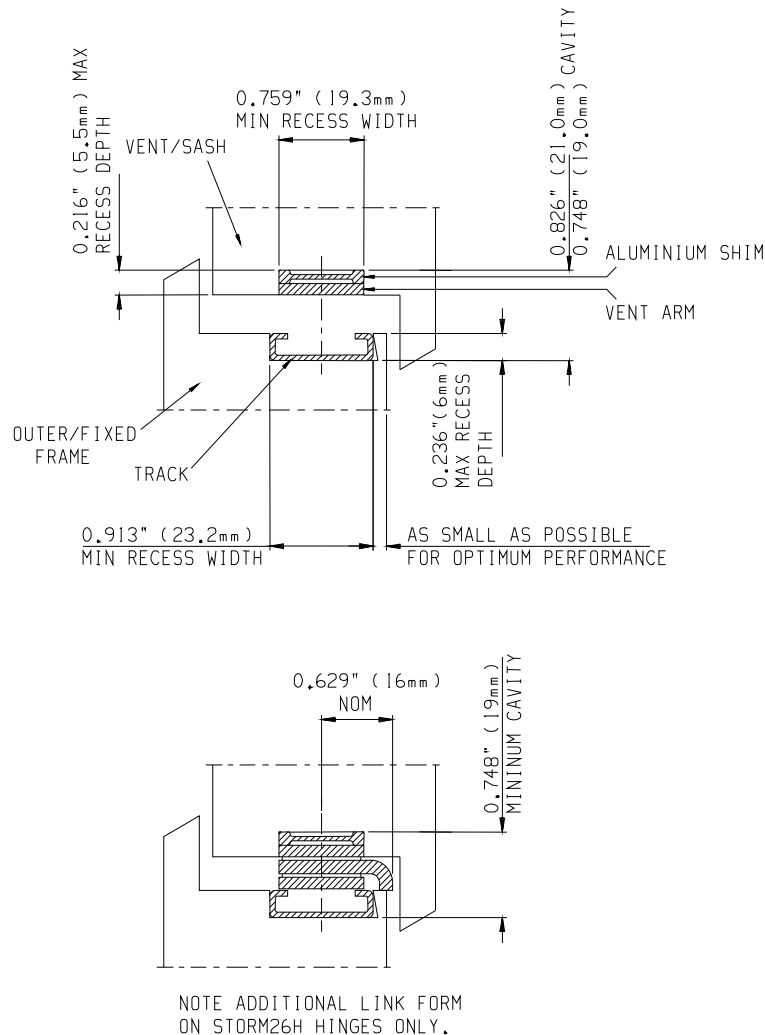


Fig. 2

2.1.6 The hinge should be fitted with the end cap located into the internal corner of the outer frame (except when using adjustment device (S7275 imperial or S7280 metric) fit 0.078" (2mm) away). Use all holes and slots to ensure optimum performance and weather sealing.

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## FITTING INSTRUCTIONS: Position and Clearances

### STERLING® and Sterling STORM® Offset Hinge Series

2.1.7 The STORM Offset Series hinges are offset by 0.072" (1.85mm), designed to be fitted between two flat and parallel rigid faces that conform to the measurements shown below. If the cavity height is greater than 0.63" - 0.71" (16 - 18 mm), use a hinge of similar specification from the Offset H Shim series.

2.1.8 The vent and outer frame hinge location recess or up stand, if any, must be as shown below. On profiles where the two parallel faces are not flat use packers to fill any recess to bring the cavity to 0.63" - 0.71" (16 - 18mm). (See sheet 2.1.7 for notes on fitting packers)

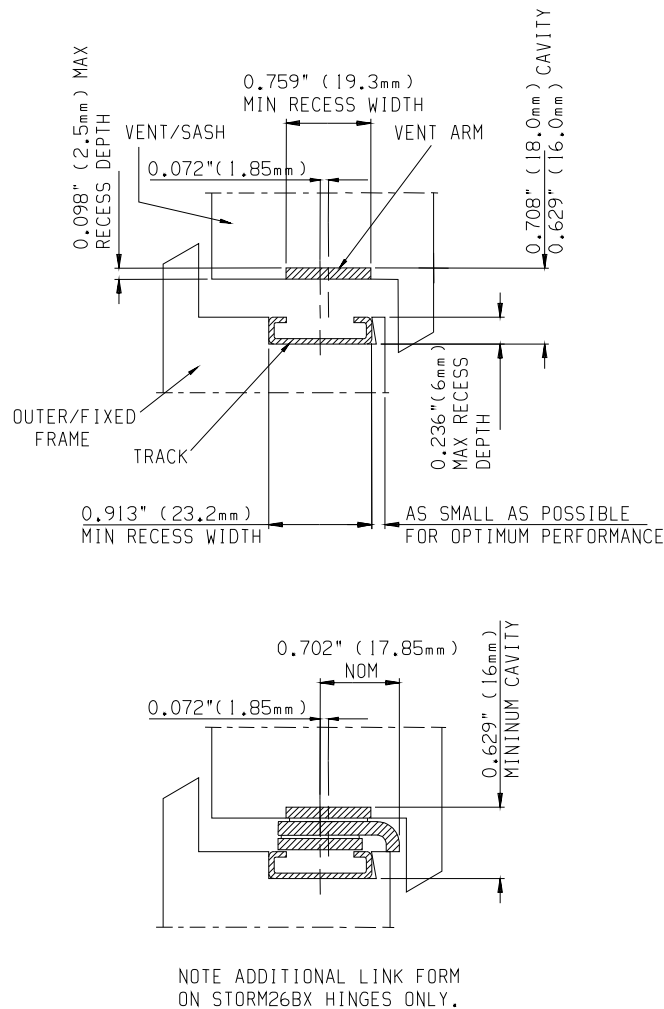


Fig. 3

2.1.9 The hinge should be fitted with the end cap located into the internal corner of the outer frame (except when using adjustment device (S7275 imperial or S7280 metric) fit 0.078" (2mm) away). Use all holes and slots to ensure optimum performance and weather sealing.

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## FITTING INSTRUCTIONS: Position and Clearances

### STERLING® and Sterling STORM® Offset H Shim Hinge Series

2.1.10 The STORM Offset H Shim Series hinges are offset by 0.072" (1.85mm), designed to be fitted between two flat and parallel rigid faces that conform to the measurements shown below. If the cavity height is less than 0.748" - 0.827" (19 - 21mm), use a hinge of similar specification from the Standard series.

2.1.11 The vent and outer frame hinge location recess or up stand, if any, must be as shown below. On profiles where the two parallel faces are not flat use packers to fill any recess to bring the cavity to 0.748" - 0.827" (19 - 21mm). (See sheet 4 for notes on fitting packers)

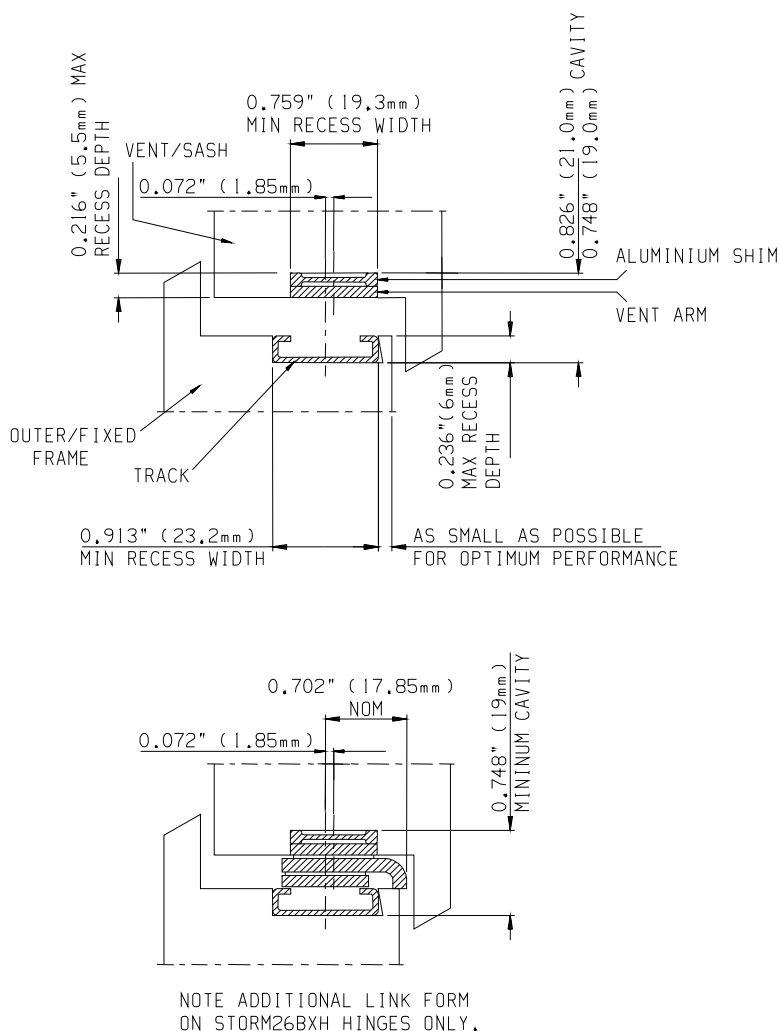


Fig. 4

2.1.12 The hinge should be fitted with the end cap located into the internal corner of the outer frame (except when using adjustment device (S7275 imperial or S7280 metric) fit 0.078" (2mm) away). Use all holes and slots to ensure optimum performance and weather sealing.

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## FITTING INSTRUCTIONS: Packers

### Notes on using Packers for hinge fitting

2.1.13 If the profile does not have two flat parallel faces on which to fit the hinge, packers must be used to fill any recess and to bring the hinge cavity to between 0.63" - 0.71" (16 - 18mm) for standard hinges or 0.748" - 0.827" (19 - 21mm) for H series. See Fig. 5 below.

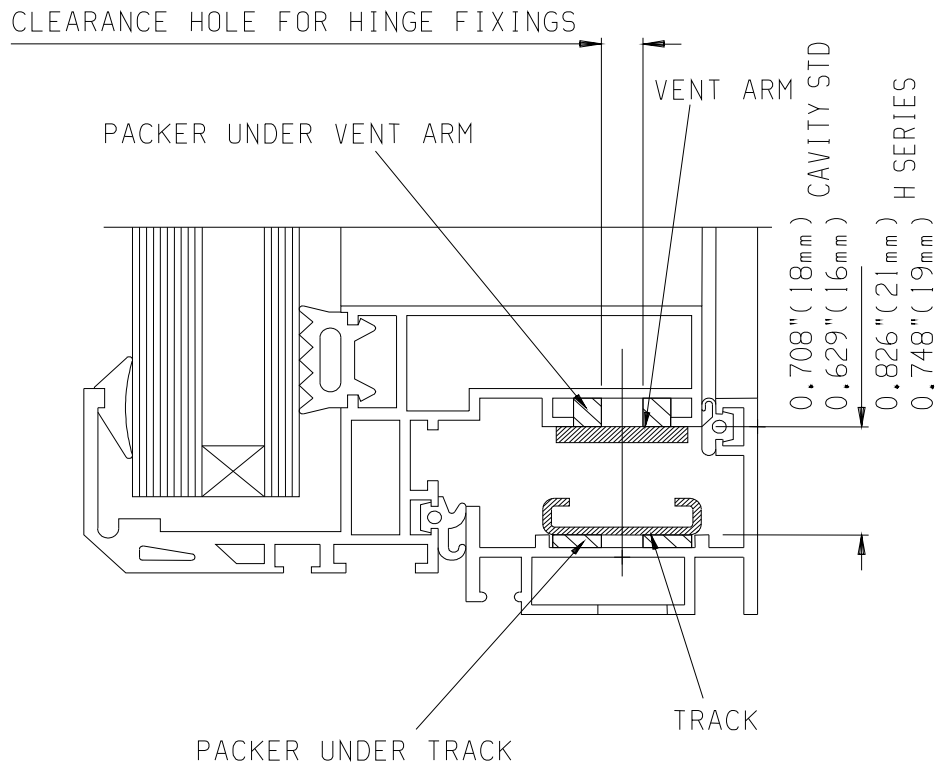


Fig. 5

**WARNING:** It is important to attach the hinge to the window section and **NOT THE PACKER**. In some cases this may mean fixing into the corner cleat.

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## FITTING INSTRUCTIONS: Vent and Frame Preparation and Fitting

### Vent Preparation and Fitting

#### 2.1.14 If using a drill jig:

- 2.1.14.1 Drill the first fixing hole using a single hole drill jig, (JIGDV). If subsequent adjustment is required, e.g. during installation, drill only the holes which correspond to the slotted hinge fixing holes.
- 2.1.14.2 Place the hinge onto the vent with its fixing top slots aligned with the previously drilled hole. Insert fixing screw and lightly tighten. Align hinge with profile and spot drill other fixing hole through the hinge slots.
- 2.1.14.3 Insert the fixings, to the fixing manufacturer's recommendations, into the slotted fixing holes only, if subsequent adjustment is required, or all fixing holes, if subsequent adjustment is not required.
- 2.1.14.4 If adjustment has taken place, when complete, use the hinge as a template to drill the remaining fixing holes if necessary, and insert fixings into all fixing holes/slots.

#### 2.1.15 If not using a drill jig:

- 2.1.15.1 Position the hinge vent arm against any sideways hinge location features or in the hinge location channel on the vent. If the vent does not have hinge location features, determine the correct position by referring to the profile manufacturers fabrication manual and measuring/markling, ('See 2.1.17.1; Fig.1 at 2.1.2 & Fig.2 at 2.1.5).
- 2.1.15.2 **EITHER:** Determine the correct longitudinal hinge position 'x': As shown in Fig. 6

**Tip:** Make a pencil mark on the vent as a visual check to confirm that the hinge has not moved from its correct position.

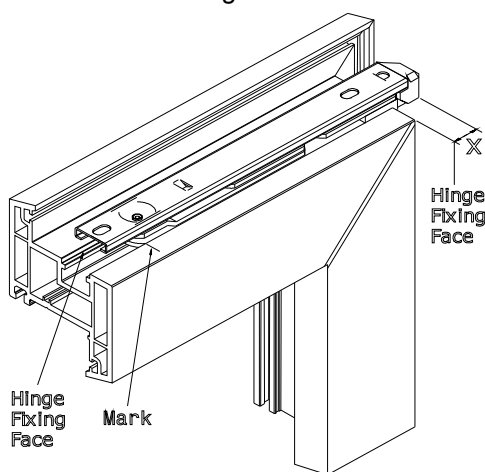


Fig. 6

STERLING® and Sterling STORM® Hinges	'x'
0.629" Stack Height	0.629"-0.708"
H - 0.748" Stack Height	0.748"-0.826"
STERLING® and Sterling STORM® Hinges	'x'
16mm Stack Height	16 to 18mm
H19 - 19mm Stack Height	19 to 21mm

**Note:** When using adjustment device Minus 0.078" (2mm)

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# FITTING INSTRUCTIONS

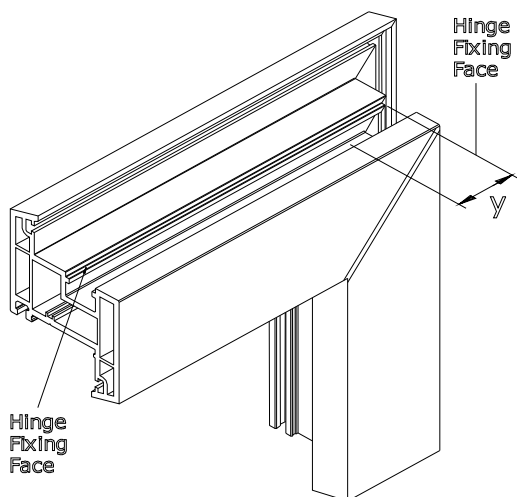
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## FITTING INSTRUCTIONS: Vent and Frame Preparation and Fitting

**OR:** Measure/mark the position 'y' of the first fixing hole from the corner of the vent, to the dimensions shown in Fig. 7 and pre-drill.



Sterling STORM® Hinges	'y'
0.629" Stack Height	0.708" ± 0.019"
H - 0.748" Stack Height	0.590" ± 0.019"
Sterling STORM® Hinges	'y'
16mm Stack Height	18.0 ± 1.0mm
H19 - 19 mm Stack Height	15.0 ± 1.0mm
STERLING® Hinges	'y'
16mm Stack Height	18.0 ± 1.0mm
H19 - 19mm Stack Height	15.0 ± 1.0mm

**Note:** When using adjustment device  
Add 0.078" (2mm)

Fig. 7

2.1.15.3 Hold the hinge in place and use it as a template to drill the fixing holes, if the fixings need pre-drilled holes. If subsequent adjustment is required, e.g. During installation, drill only the holes which correspond to the slotted hinge fixing holes.

2.1.15.4 Hold the hinge in place and follow steps 2.1.14.3 & .4

**Note:** For Sterling STORM® hinges only the handing of the hinge is indicated by colour coding of the end caps. A left hand hinge has a silver end cap and the right hand hinge has a black end cap. Also the direction in which the hinge opens is indicated by an arrow on the vent arm.

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## FITTING INSTRUCTIONS: Vent and Frame Preparation and Fitting

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### Frame Preparation and Fitting

#### 2.1.16 If using a drill jig:

- 2.1.16.1 Drill the first fixing hole using a single hole drill jig, (JIGDF). If subsequent adjustment is required, e.g. during installation, drill only the holes which correspond to the slotted hinge fixing holes.
- 2.1.16.2 Place the hinge onto the frame with its fixing top slot aligned with the previously drilled hole. Insert fixing screw and lightly tighten. Align hinge with profile and spot drill other fixing hole through the hinge slots.
- Note:** When fitting Adjustment device space the frame jig and hinge 0.078" (2mm) from the inside corner of the frame before drilling holes to allow for adjustment.
- 2.1.16.3 Insert the fixings, to the fixing manufacturers recommendations, into the pre-drilled holes which correspond with the slotted fixing holes only, if subsequent adjustment is required, \* or all fixing holes, if subsequent adjustment is not required.
- \* **Note:** Use the hinge as a template to drill any holes not previously drilled as required.
- 2.1.16.4 If adjustment has taken place, when complete, use the hinge as a template to drill the remaining fixing holes if necessary, and insert fixings into all fixing holes/slots.

#### 2.1.17 If not using a drill jig:

- 2.1.17.1 Position the hinge track against any sideways hinge location features or in the hinge location channel on the frame, commonly the glazing bar clip channel. If the profile does not have hinge location features, determine the correct position by measuring/markings, (Fig. 1 at 2.1.2 & Fig. 2 at 2.1.5 will help).
- 2.1.17.2 Position the hinge so that its end cap is located fully into the corner of the outer frame.
- Note:** When fitting an Adjustment Device position the hinge so that the end cap is located 0.078" (2mm) from the corner of the outer frame.
- 2.1.17.3 Hold the hinge in place and use it as a template to drill the fixing holes, if the fixings need pre-drilled holes. If subsequent adjustment is required, e.g. during installation, drill only the holes which correspond to the slotted hinge fixing holes.
- 2.1.17.4 Hold the hinge in place and follow steps 2.1.16.3 & .4 above.

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## FITTING INSTRUCTIONS: Vent and Frame Preparation and Fitting

### Use of the Hinge Adjustment Device

**Note:** It is important to drill and fix the device into position whilst installing the hinge, recommended drill for spigot 0.275" (7.0mm), (see fixing hole reference chart for details).

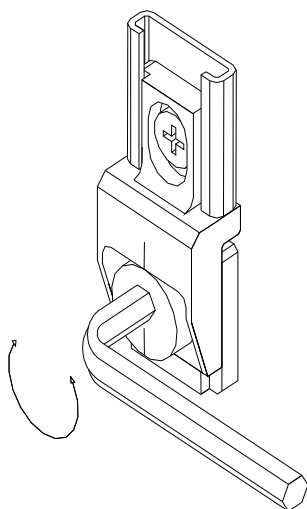


Fig. 8

2.1.18.1 When locating hinge onto frame insert adjustment device into track and push locating pin into the pre-drilled hole. (Note: For maximum adjustment in both directions  $\pm 0.078"$  ( $\pm 2\text{mm}$ ) the markings on the cam should be at  $90^\circ$  to the markings on the main body. If  $0.157"$  (4mm) adjustment is required to move the hinge in an upward direction only the marking on the cam should be at  $180^\circ$  to the markings on the main body, as shown in the diagram).

2.1.18.2 Once the window has been assembled open the vent and slacken off any fixings in slots from around the frame and completely remove screws from round holes.

2.1.18.3 Using a  $3/16"$  or 5mm Allen key rotate the screw clockwise to adjust up and anti-clockwise to adjust down to reposition the vent in the frame as required,  $0.157"$  (4mm) maximum travel.

2.1.18.4 When the vent is positioned correctly, fully open the vent and replace/tighten all of the frame fixings securely.

2.1.18.5 When the vent is aligned correctly, anchor it by fixing through the restricting stop (STORM26 only).

**Note:** Imperial or Metric Allen key location available. An identification mark as IMP or MM is pressed into the top face of the cam. Part Number S7275 for an imperial adjustment device and S7280 for a metric version.

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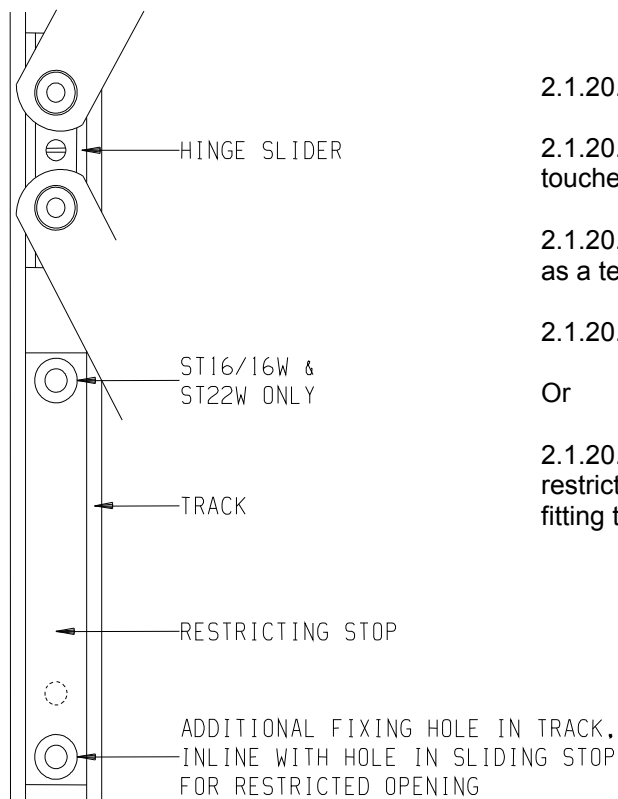
ISSUE: May, 2003

## FITTING INSTRUCTIONS: Restricting Stop STERLING® Hinges

### Notes on use of Restricting Stop (Top Hung Only)

2.1.19 If the maximum opening angle is required allow the sliding stop to drop to the bottom of its movement. Insert fixing screws in all of the visible holes.

2.1.20 If a restricted opening angle is required, fit the hinges normally. Only use the slots and the lower fixing hole on the track, then with restrictor stop moved clear, either:



2.1.20.1 Open the window to the required angle

2.1.20.2 Slide the restrictor stop up the track until it touches the underside of the slider

2.1.20.3 Drill holes through the track using the stop as a template

2.1.20.4 Insert all fixing screws.

Or

2.1.20.5 Establish the desired angle and pre-drill the restricted position fixing holes in the track before fitting the hinges

Fig. 9

**Note:** For all hinges incorporating a sliding stop, as the restricted angle is decreased and/or the vent height is increased the final stop will have a more cushioned feel. When an opening force is applied to an open, restricted vent, additional movement will take place until the cushion effect is absorbed. When the opening force is released the vent will return to the initial restricted position. This is a normal function of the hinge geometry.

2.1.21 If a solid opening stop is required additional restrictor devices can be fitted to the bottom of the vent e.g. SR8 and SR16 - see Special Hinges section.

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## FITTING INSTRUCTIONS: Restricting Stop Sterling STORM® Hinges

### Notes on use of Drop-in Limit Stop

2.1.22 If the maximum opening angle is required make sure all drop-in limit stops are removed. Do not insert a fixing screw into the hole above the crack stop in the track.

2.1.23 If a restricted opening angle is required, fit the hinges normally. Only use the slots and the lower fixing hole on the track, then with restrictor stop moved clear, either:

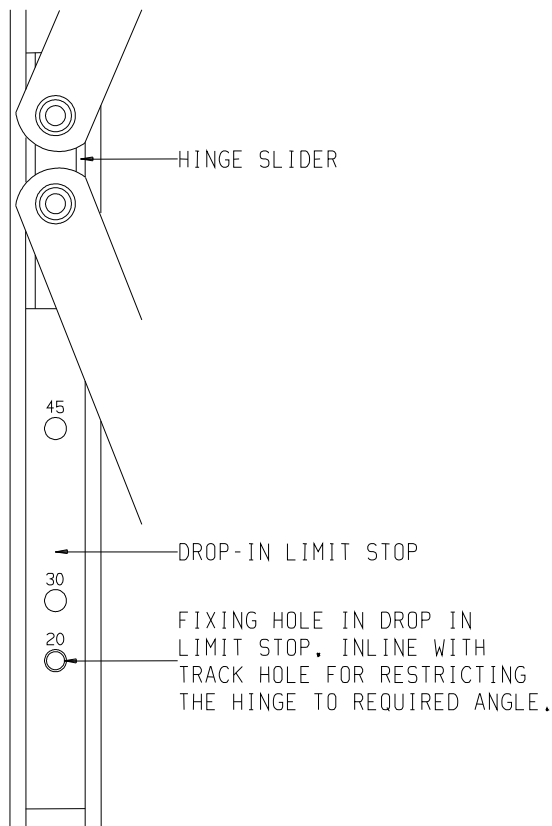


Fig. 10

2.1.23.1 Open the window to the required angle

2.1.23.2 Drop-in the limit stop and position the required opening angle hole i.e. 45° over the hole in the track

2.1.23.3 Insert a fixing into the desired position

2.1.23.4 Insert all fixing screw into desired position and tighten.

**Note:** Drop-in limit stops can be used on 10", 16" and 22" only. The 26" hinge has a built in limit stop.

**Note:** For all hinges incorporating a limit stop, as the restricted angle is decreased and/or the vent height is increased the final stop will have a more cushioned feel. When an opening force is applied to an open, restricted vent, additional movement will take place until the cushion effect is absorbed. When the opening force is released the vent will return to the initial restricted position. This is a normal function of the hinge geometry.

### 2.1.23.5 Limit Stop Chart

STORM Hinge & Degree of Restriction	Limit Stop Part Code
Storm 10 (20/30/45 Degree of Restriction)	C7251
Storm 16 (20/30/45 Degree of Restriction)	C7252
Storm 22 (20/30/45 Degree of Restriction)	C7253

2.1.24 If a solid opening stop is required additional restrictor devices can be fitted to the bottom of the vent e.g. SR8 and SR16 - see Ancillary Devices section.

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# FITTING INSTRUCTIONS

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## FITTING INSTRUCTIONS: Screws and Rivets

### Fixing Screws

2.1.25 Use No.10 self tapping screws or M5 screws and M5 Rivnuts or a specialist equivalent i.e. with special threads for PVCu.

The following constraints should be strictly adhered to:-

- 2.1.25.1 Pan, mushroom or standard dome head screws are the preferred option, except for the end fixing position on the STORM26 vent arm where countersunk screw heads must be used to ensure it is flush with the face.
- 2.1.25.2 Countersunk heads are acceptable but will not produce a neat appearance.
- 2.1.25.3 Screws with special combination countersunk/pan heads are also an acceptable head format. See Fig. 8 below.
- 2.1.25.4 Screw manufacturers recommended pilot hole sizes must be adhered to at all times and if any instructions are supplied by window system manufacturers/suppliers, such as "screw into reinforcement", it is important that they are followed.
- 2.1.25.5 When fitting hinges extreme care must be taken not to strip the thread as deterioration in performance will result.
- 2.1.25.6 It has been shown that Austenitic and certain types of Modified Martensitic fixings provide superior corrosion resistance when subject to BS 7479.

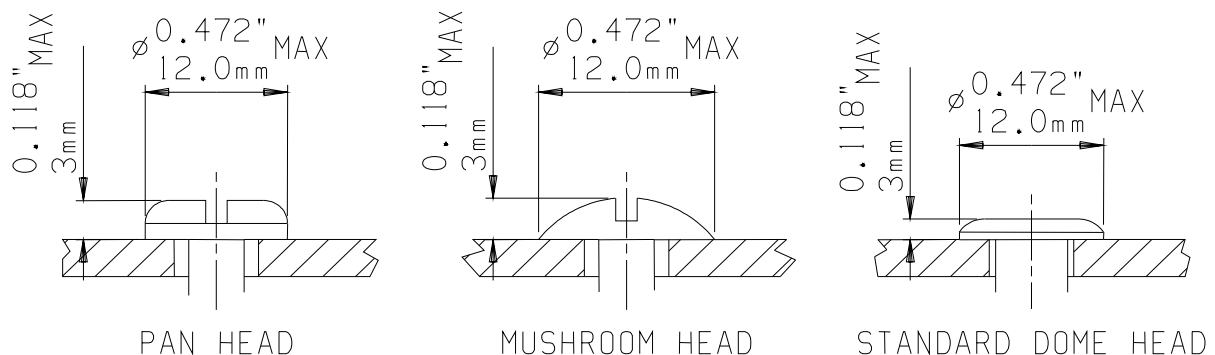


Fig. 11

**Note:** It is the responsibility of the window manufacturer to ensure that all fixing screws and rivets have adequate strength to support the weight of the window vent and the forces exerted upon it over the full life of the window.

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## FITTING INSTRUCTIONS: Screws and Rivets

### Fixing Rivets

2.1.26 Fixing rivets (pop and peel blind rivets) should be 5mm or 3/16 inch diameter and of a length to suit the total riveting thickness as recommended by the rivet manufacturer. The following additional constraints must be adhered to:-

- 2.1.26.1 Head maximum sizes must not exceed those shown below.
- 2.1.26.2 All rivet manufacturers recommendations must be observed.
- 2.1.26.3 Only stainless steel rivets are recommended for use by SECURISTYLE® Ltd.

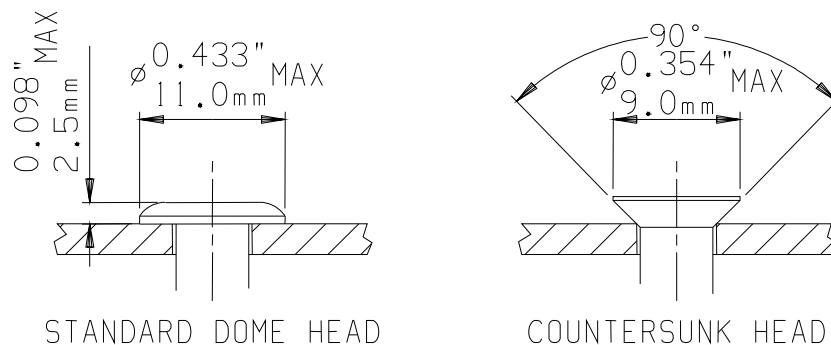


Fig. 12

**Note:** It is the responsibility of the window manufacturer to ensure that all fixing screws and rivets have adequate strength to support the weight of the window vent and the forces exerted upon it over the full life of the window.

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# FITTING INSTRUCTIONS

COMMERCIAL HINGES

SECTION 2.1 SHEET 14 of 14

ISSUE: May, 2003

## FITTING INSTRUCTIONS: Screws and Rivets

### Vent Arm End Fixings:

2.1.27 The end vent arm fixing hole for the STORM26 must be fitted with a countersunk head screw of a length to ensure that the head is flush/sub-flush in order to maintain a clear, flat surface. Where the vent arm is being fixed directly onto the face the following are recommended:

2.1.27.1 5/16" (M5) countersunk screw screwed into a rivnut

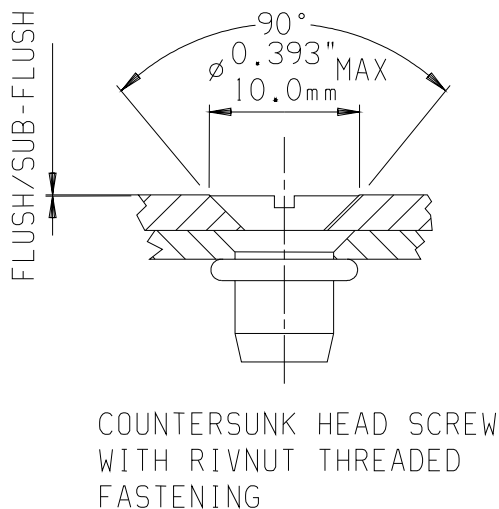


Fig. 13

2.1.27.2 No.10 self tapping truncated countersunk head screw for fixing into a section.

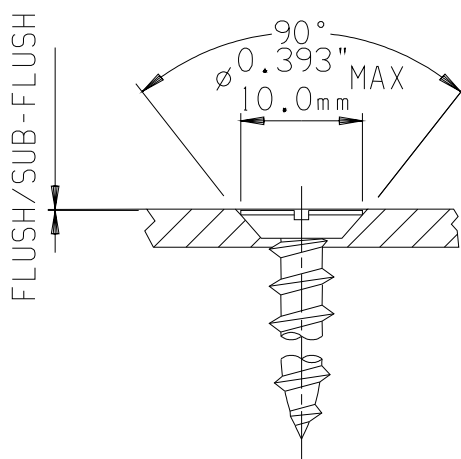


Fig.14

**Note:** It is the responsibility of the window manufacturer to ensure that all fixing screws and rivets have adequate strength to support the weight of the window vent and the forces exerted upon it over the full life of the window.

**Not to Scale, All dimensions in inches & mm**

It is the responsibility of the user to ensure that this document is at the latest issue.

Due to our policy of continual product improvement we reserve the right to alter specifications without notice.

It is the responsibility of the window manufacturer to ensure that the finished window meets the required performance and safety specification.

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