



Engineering progress
Enhancing lives

RAUCERO ARTEVO®

Technical information



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01 Information and safety information

Validity

This Technical Information is valid worldwide.

Currentness of the Technical Information

For your safety and to ensure correct use of our products, please check regularly whether an updated version of this technical information is available. You can obtain the current version of the document from your local dealer or your REHAU sales office. Alternatively, you can download it from the REHAU customer portal (www.rehau.de).

Navigation

At the beginning of this Technical Information, you will find a detailed table of contents with the hierarchical headings and corresponding page numbers.

Intended use

The RAUCERO ARTEVO system may only be planned, processed and installed as described in this technical information. Any other use is deemed to be outside the scope of intended use and therefore is not permitted.

Suitability of the material

The latest valid Technical Information must be observed in the processing/installation and use of RAUCERO ARTEVO. Our Technical Information is based on tests carried out and knowledge acquired up to the time of printing. The sharing of this information includes no guarantee of the properties of the products described. No explicit or implicit guarantee may be derived from it.

The information does not release the user/purchaser from its duty to properly and competently assess this product as to its suitability for the respective conditions of the object and for the intended purposes.

Sharing of information

It is essential to ensure that your customers, also including end customers, are informed of the necessity to observe the current Technical Information as well as instructions for care and use for RAUCERO ARTEVO products. The care and usage instructions must be made available to the end customer either by you or by your customers.

Pictograms and logos



Important information



Colour: black



Colour: grey



Color: white



Non-rusting steel types—stainless steel



Natural anodised aluminum



Laminated version



Non-standard, delivery time on request



Packaging unit (for details, see Article directory)



Wall thickness in mm



With weldable gasket



Right-hand version



Left-hand version



Seal with silicone



Glue with PVC adhesive



Drilling and cutting jigs



Drilling



Distance from the corner or edge distance in mm



Distance in mm

02 System description

With our RAUCERO ARTEVO, we make barrier-free access the standard solution

- Our tested, thermally separated RAUCERO ARTEVO threshold system with extensive accessories is the perfect basis for a rational and flexible zero-barrier solution that satisfies all requirements.

Your benefits at a glance:

- Barrier-free, floor level access without threshold upstand.
- Versatile usage options for side entrance, balcony and tilt and turn doors, as well as dummy mullion doors.
- Locking in the threshold possible!
- Circumferential hardware in the sash possible!
- Thermally separated adapter profile below the sash with track for lowerable floor seal and replaceable weather rail profiles
- No door threshold seal on the floor or the threshold.
- Drainage in optimised external drainage.
- Water drainage is outside the building seal with permanent protection against moisture in the masonry.

Technical properties:

Single-sash tilt and turn French door:

- Air permeability to DIN EN 12207: Class 4
- Resistance to driving rain as per DIN EN 12208: Class 9A
- Wind resistance to DIN EN 12210: Class B4/C4

Two-sash tilt and turn French door without fixed center mullion:

- Air permeability to DIN EN 12207: Class 4
- Resistance to driving rain as per DIN EN 12208: Class 8A
- Wind resistance to DIN EN 12210: Class B3/C2

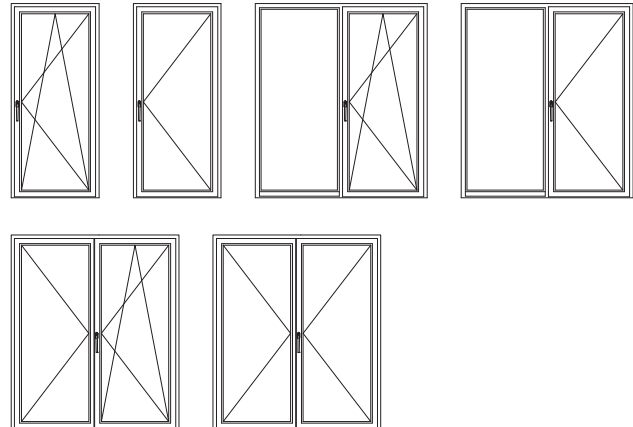
Sound insulation up to 43 dB

Size limits

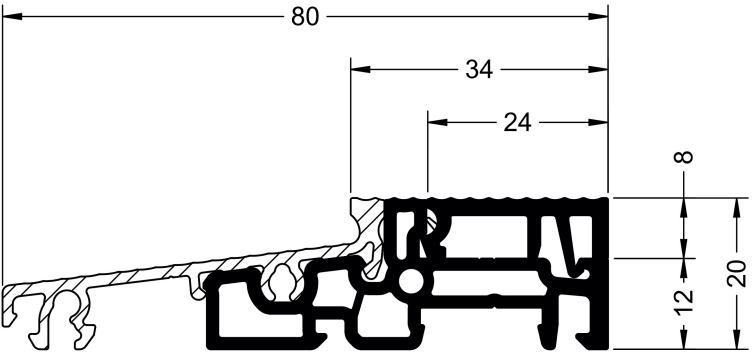
The size limits according to the "ARTEVO size limits" chapter apply.

Opening styles

French doors:

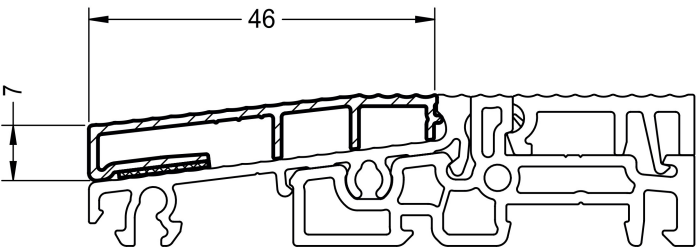


03 Profile print



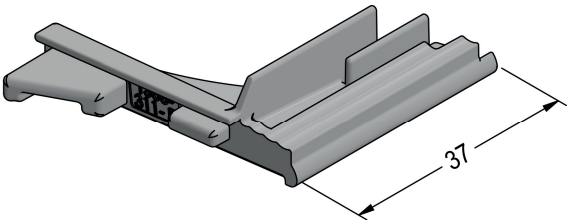
Set threshold 80/80 ARTEVO®

1368280  
 6



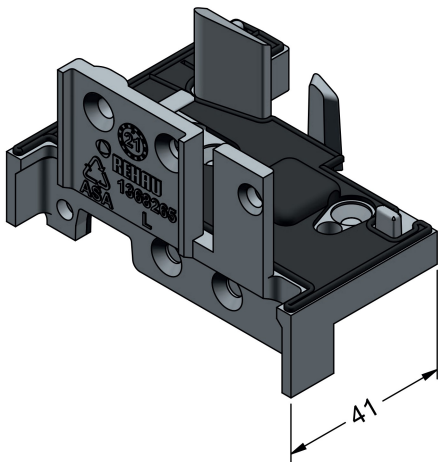
Drainage profile RAUCERO ARTEVO®

1358221 
 6



Drainage profile end cap RAUCERO ARTEVO®

TPE
1368311  
1368312  
 10



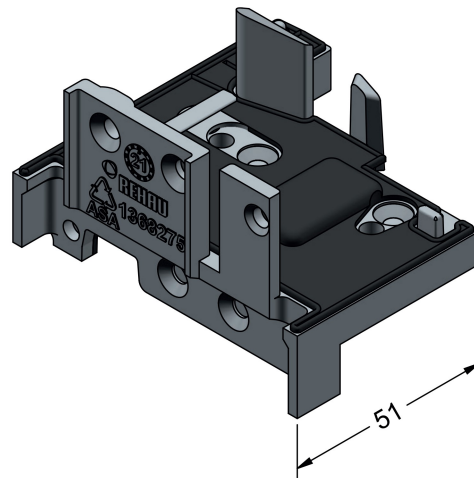
Frame threshold support 65 ARTEVO®

ASA/TPE

1368264  

1368265  

 50



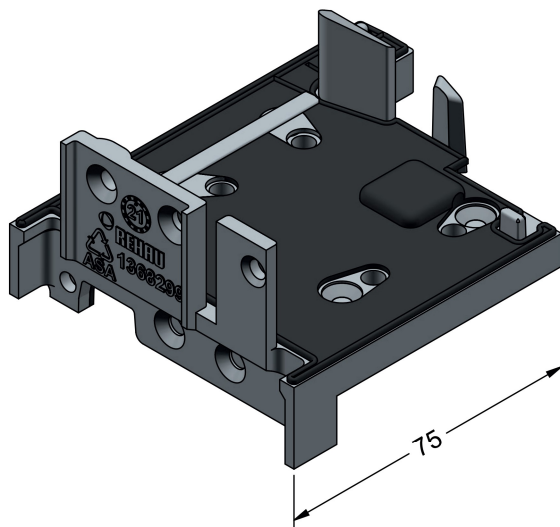
Frame threshold support 75 ARTEVO®

ASA/TPE

1368274  

1368275  

 50



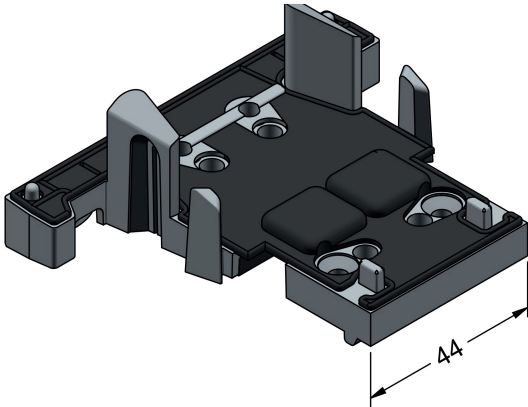
Frame threshold support 99 ARTEVO®

ASA/TPE

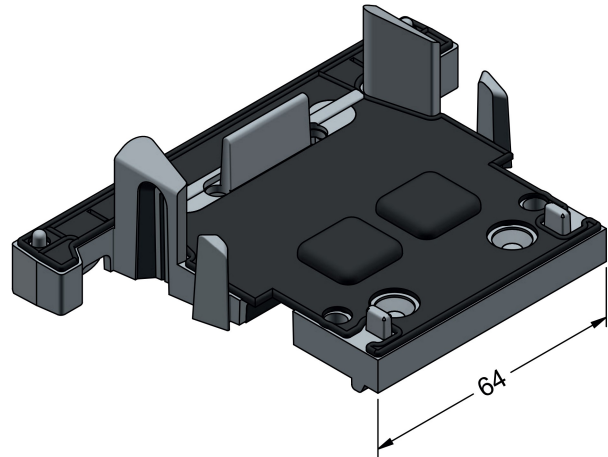
1368298  

1368299  

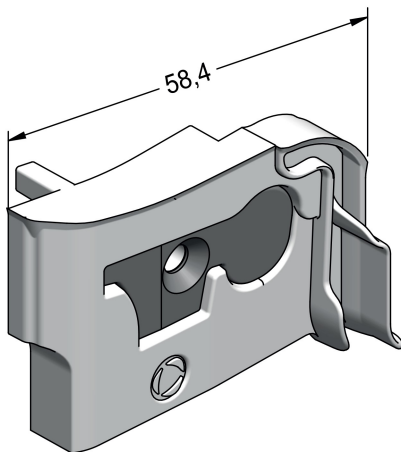
 50



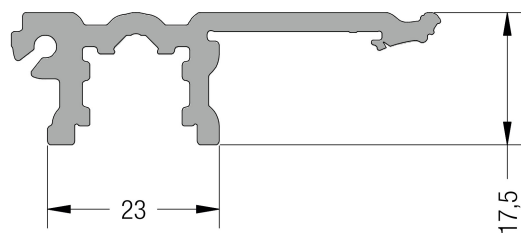
Mullion threshold support 92 ARTEVO®
ASA/TPE
1368292 
 50



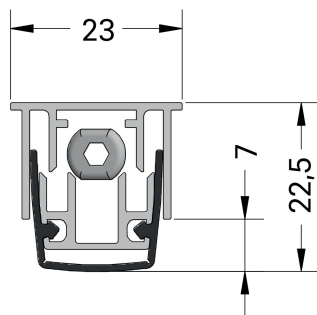
Mullion threshold support 112 ARTEVO®
ASA/TPE
1368294 
 50



Set wind stop RAUCERO ARTEVO®
- TPE/PA6 frame sealing  piece
- TPE/PA6 frame sealing  piece
- ISO 7050—3.5 x 19 A2 screw
1368313
 10



Adapter profile RAUCERO ARTEVO®
PVC
1358224 
 6



Lowerable floor seal RAUCERO ARTEVO®
PVC/EPDM

1358097 ■ length - 460 mm

1358098 ■ length - 585 mm

1358099 ■ length - 710 mm

10

1358228 ■ length - 835 mm

1358229 ■ length - 960 mm

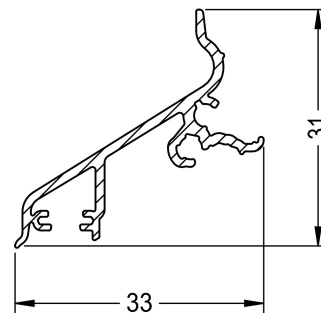
1358231 ■ length - 1,085 mm

1358232 ■ length - 1,210 mm

1358233 ■ length - 1,335 mm

1358234 ■ length - 1,460 mm

5



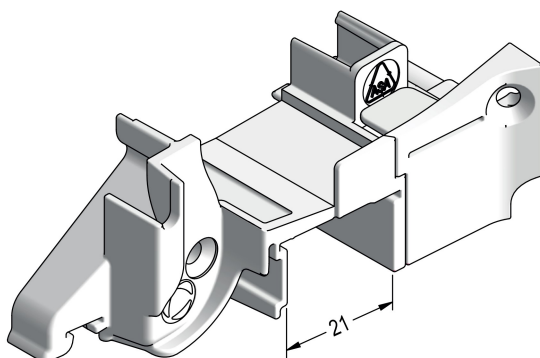
Weather rail RAUCERO ARTEVO®

1368308 ■

6



The floor seal may be shortened by a maximum of 125 mm!



Set weather rail end cap RAUCERO ARTEVO®:

▪ 1 x Weather rail end cap left ■

▪ 4 x VA2 3.5 x 32 screws

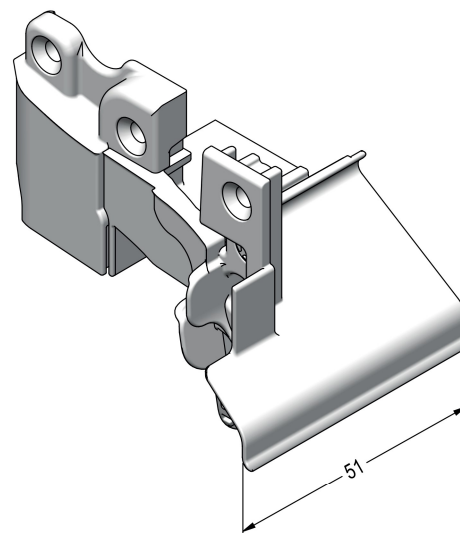
▪ 2 x VA2 3.5 x 19 screws

▪ 1 x EPDM sealing pad

1368287 ■

1368288 ■

10



Set weather rail end cap for dummy mullion RAUCERO ARTEVO®:

▪ 1 x Weather rail end cap left ASA ■

▪ 1 x VA2 3.5 x 32 screws

▪ 5 x VA2 3.5 x 19 screws

▪ 1 x Sealing end plug for moving sash ■

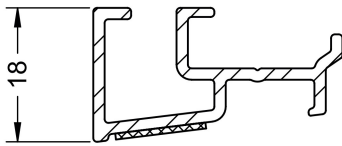
▪ 1 x Sealing end plug for two-sash window, shootbolt-operated ■

▪ 1 x EPDM sealing pad ■

1368289 ■

1368290 ■

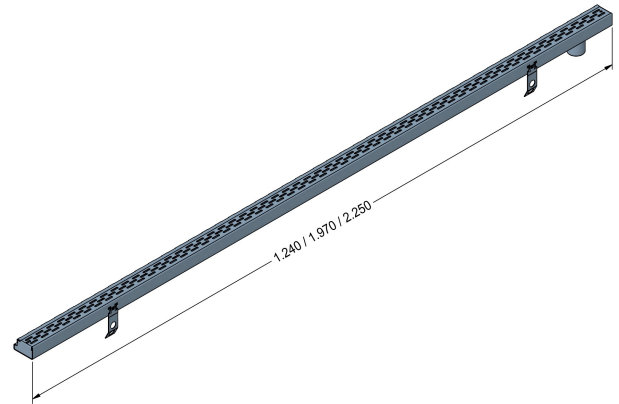
10



Compensation profile ARTEVO®

1368317 

 6



Set drainage channel RAUCERO ARTEVO®:

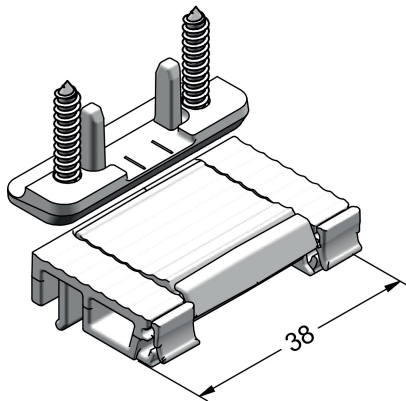
- Drainage channel with perforated grate
- End pieces
- Two or three concrete anchors
- Drainage nozzle DN 50

1358400  length - 1,240 mm

1358500  length - 1,970 mm

1358600  length - 2,250 mm

 1

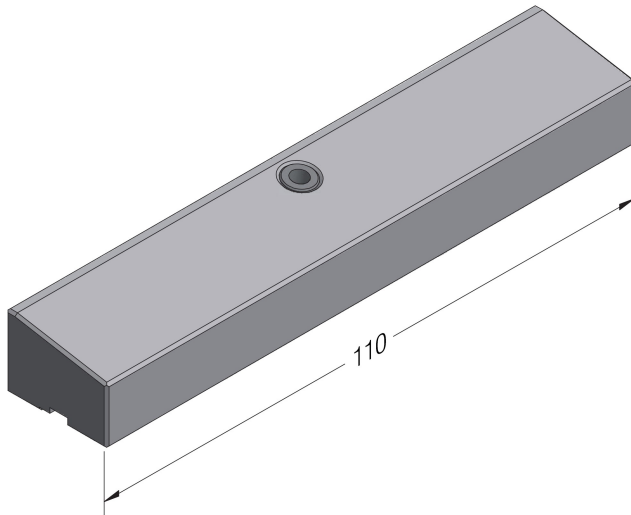


Set closing aid RAUCERO ARTEVO®

- Closing aid 2-piece PA6 GF30 
- 2 x Screws 3,5 x 32 A2

1368297

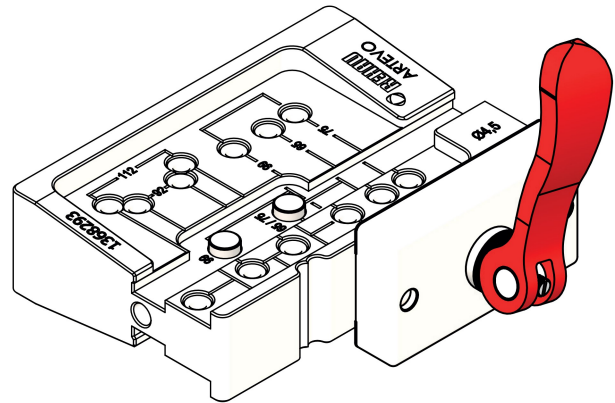
 10



Drilling jig for lowerable floor seal RAUCERO ARTEVO®

1358239 

 1

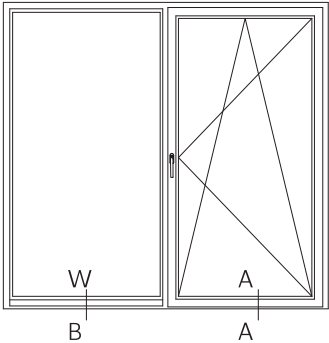


Drilling jig for threshold support

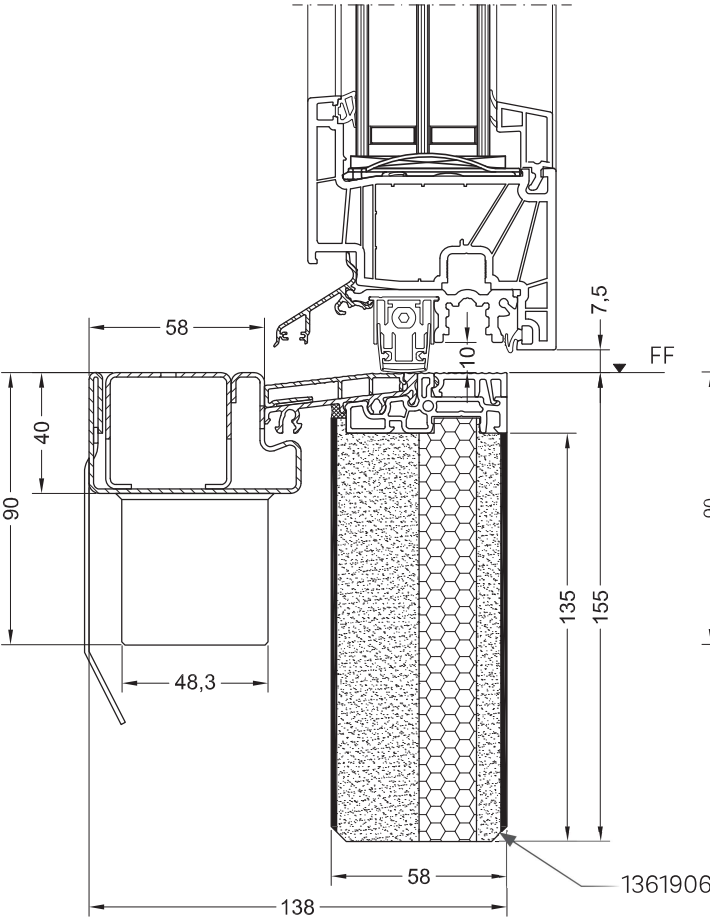
1368293

 1

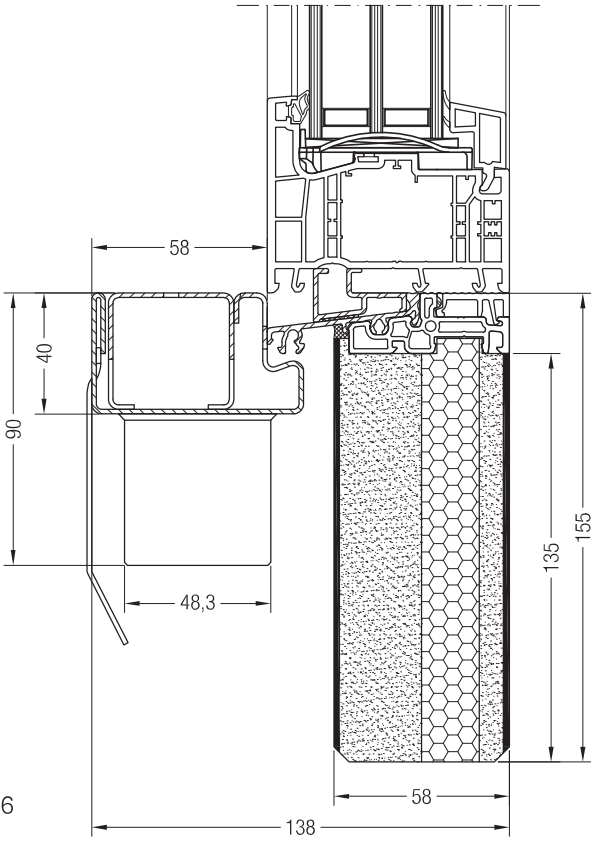
04 Detail drawings



A-A



B-B



i The distance between the lowest point of the sash (end cap of the weather rail) and the upper threshold edge is 5 mm.

05 Construction manual

01 Instructions for installing single-sash elements

01.01 Before installation:

- Cut, weld and clean the frame and sash profiles according to the specifications in the cutting sizes (page 22).
- The frame profile must be 6.5 mm longer at the bottom than the sash frame when the sash is hinged (without threshold).
- The threshold supports must be installed to the RAUCERO ARTEVO® threshold in advance in accordance with the instructions (page 14). The threshold, including the threshold support, must not yet be fitted to the frame!
- The weather rail 1368308 extends the fitting groove downwards by 17.5 mm. This must be taken into account when designing the handle/fitting hole and the hardware.
- The lock or hardware must not yet be installed on the sash!
- If a lock is to be installed in the threshold, the necessary cut-outs must be made in the sash and adapter profile.

Attention: To improve airtightness, seal the steel chamber as follows. Drill out the lower sash corners from below, left and right with an 8 mm diameter hole (fig. Sash corner details) and fill the corners with PU foam.

- Apply pressure equalization to the frame in accordance with the "ARTEVO® production drawings" chapter. With RAUCERO ARTEVO®, pressure equalization is always necessary for both French and side entrance doors!

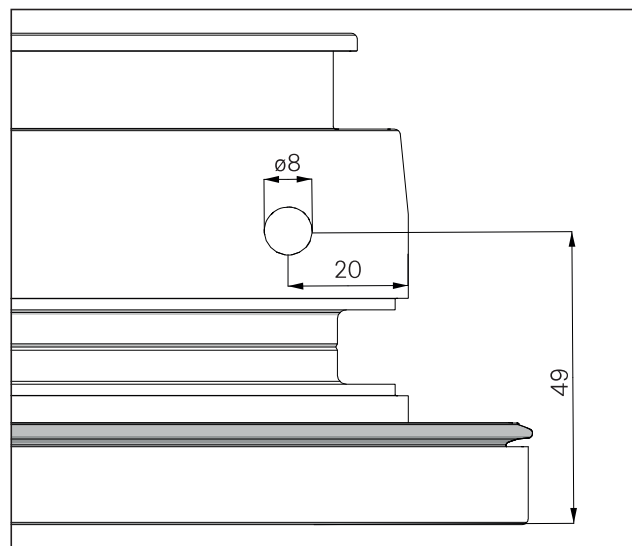


Fig. Sash corner details

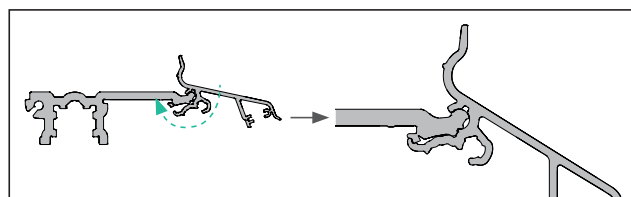


Fig. 1: Installation of weather rail 1368308 to adapter profile 1358224

01.02 Installation on the sash:

- Cut the adapter profile 1358224 and the weather rail 1368308 to size. Length = sash rebate dimension – 52 mm.
- Snap weather rail onto the adapter profile. To do this, turn the two parts together until you hear them click into place (fig. 1). The weather rail is secured later on by being screwed to the sash.
- Each end cap for the adapter profile consists of two parts (fig. 2). Seal part of 1 the end caps 1368287/1368288 to the adapter profile and install with the stainless-steel screws (fig. 3). Part 2 of the end caps will be installed later. The end caps are installed 1 on both sides. Note: Both parts of the end cap are connected to each other for production reasons and must be separated from each other.
- Cut the lowerable floor seal to length. Length (aluminum profiles) = sash rebate dimension – 2 mm.

Attention: Do not cut to length on the release side! The floor seal may be shortened by a maximum of 125 mm!

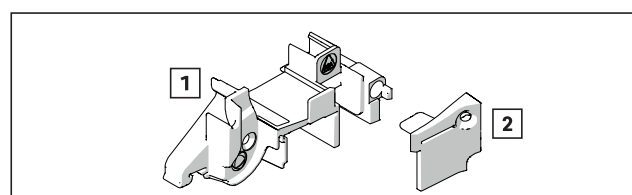


Fig. 2: Two-piece weather rail end cap 1368287/1368288

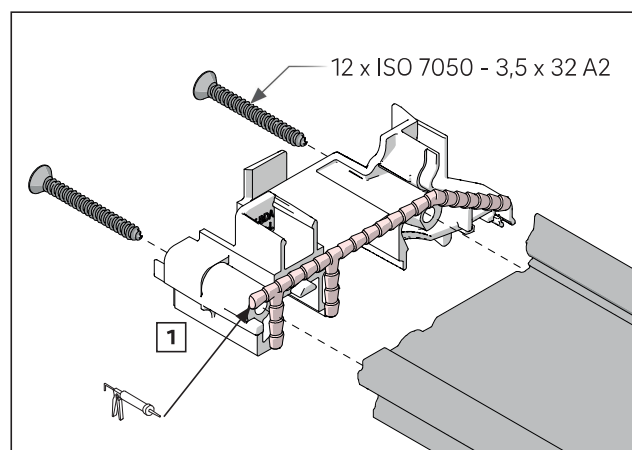


Fig. 3: Installation of the weather rail end cap on the weather rail and adapter profile

- Deburr the cut surfaces and slide the lowerable floor seal into the groove provided in the adapter profile. Floor seal must be flush with the weather rail end cap on both sides (fig. 4).

Attention: Make sure that the release is on the hinge side! Insertion is possible from either side.

- Apply silicone to the adapter profile as shown in fig. 5 and all surfaces which contact the sash. Then position the adapter profile, including the already installed end caps, at the bottom of the sash.
- Pre-drill the adapter profile in the fitting groove as shown in fig. 5 with 4.5 mm diameter; one hole each approx. 50 mm starting from the edge of the weather rail and additional holes at 300 mm intervals. Pre-drilling in the area of the weather rail  is carried out using the drilling jig 1358239. Now screw the adapter profile into the pre-drilled holes using window construction screws  and A2 sheet metal screws . The screw connection also secures the lowerable floor seal in the groove and secures it against movement (fig. 5 and 6).
- Then seal the floor seal to the adapter profile and the end caps with silicone over the entire length (fig. 6).
- **Attention: Very important!** Make sure that silicone does not get into the floor seal or onto the sealing surface!
- *For corner drive, glue the enclosed sealing pad (15 x 12 x 7 mm) on the lock side at the bottom into the hardware groove flush with the end of the weather rail end cap (fig. Sealing pad details).

01.03 Installation with French doors:

- The hardware is now installed according to the manufacturer's instructions.
- **Attention:** Using the RAUCERO adapter profile increases the sash rebate height by 17.5 mm:
Sash rebate height ± 17.5 mm!
- Once the hardware has been installed, part 2 of the end cap can now be pushed from the top to the bottom of the sash upstand and through the fitting groove onto the already installed end cap and screwed tight. The tab (fig. 7) on the hardware side must be removed for this purpose.

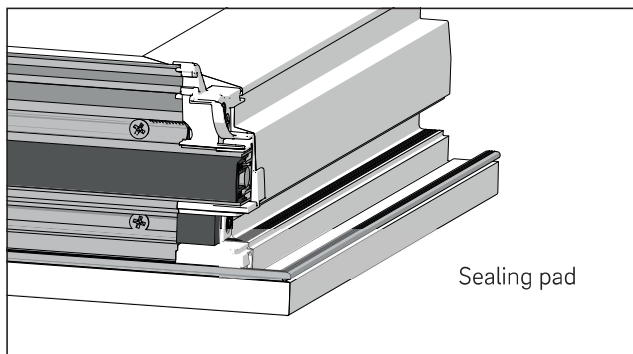


Fig. Sealing pad details: positioning of sealing pad

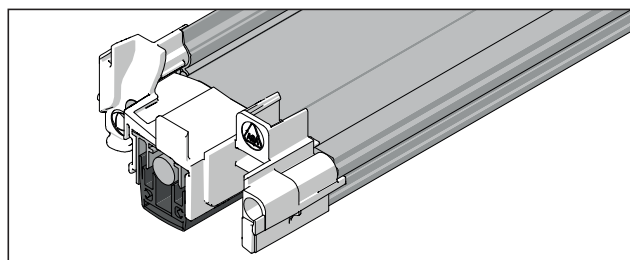


Fig. 4: Installation of lowerable floor seal

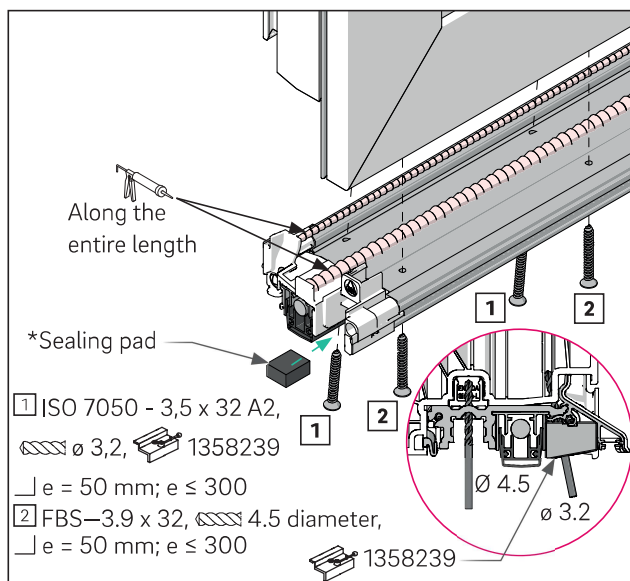


Fig. 5: Installation of the adapter profile with weather rail, weather rail end cap and floor seal on the sash

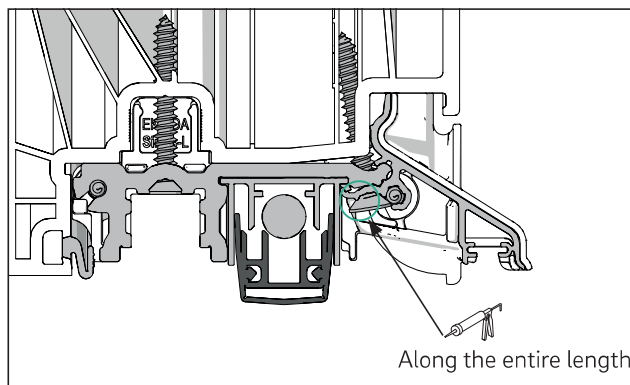


Fig. 6: Sealing the floor seal

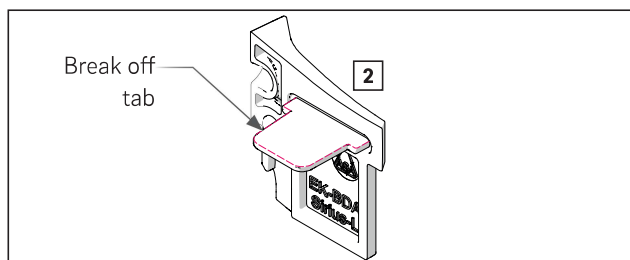


Fig. 7: Fabrication of weather rail end cap part 2

01.04 Installation with side entrance doors:

- Part 2 of the end cap can be pushed from top to bottom on the sash upstand and through the fitting groove onto the already installed end cap and screwed tight (fig. 8).
- Now the lock is to be installed. To do this, the lock must be shortened just enough so that it does not collide with the already installed end cap.

01.05 Installation of the threshold supports:

- The threshold supports are installed in accordance with the specifications in the "ARTEVO®production drawings" technical information.

01.06 Instalation on the frame profile:

- Before the threshold, including the threshold support, is attached to the frame, the drainage profile 1358221 with the drainage profile end caps 1368311/1368312 must now be glued to the sloping surface of the threshold.
- To do this, cut the drainage profile to length: Frame glass rebate —86 mm and attach the end caps. The joint between the end cap and the drainage profile must be sealed with silicone (fig. 9).
- Remove a short piece of the protective foil on both sides and bend it forward so that it protrudes towards the drainage strip. Then peel off the protective foil toward the front along the entire length and stick the drainage profile to the threshold with a little pressure.
- The threshold is then installed with pre-assembled threshold supports and the drainage profile on the frame profile in accordance with the specifications in the "ARTEVO®production drawings" technical information.
- Next, the two-part wind stop 1368313 is installed in the frame rebate (fig. 10).
- Seal the main part of the wind stop **1** to the threshold toward the bottom with silicone and then position it in the frame rebate. Press the secondary part **2** into the recess of the main part **1** of the wind stop and screw it in place using the enclosed 3.9 x 19 window construction screw (fig. 10).

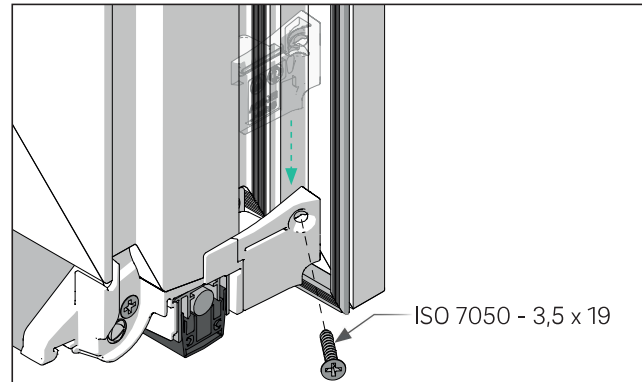


Fig. 8: Installation of weather rail end cap part 2

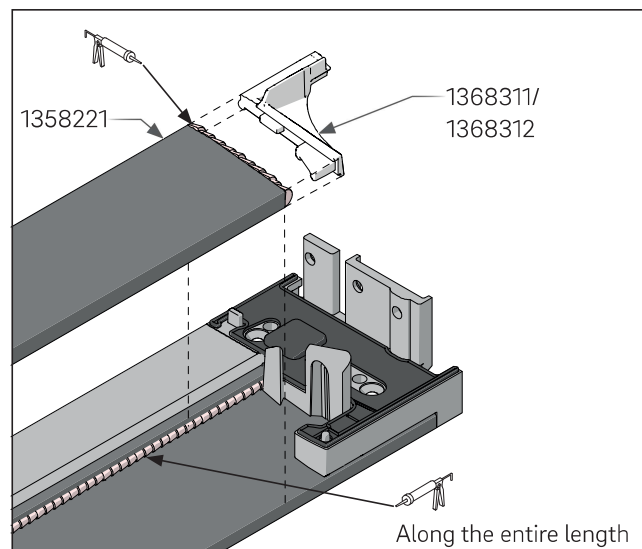


Fig. 9: Installation of the drainage profile 1358221

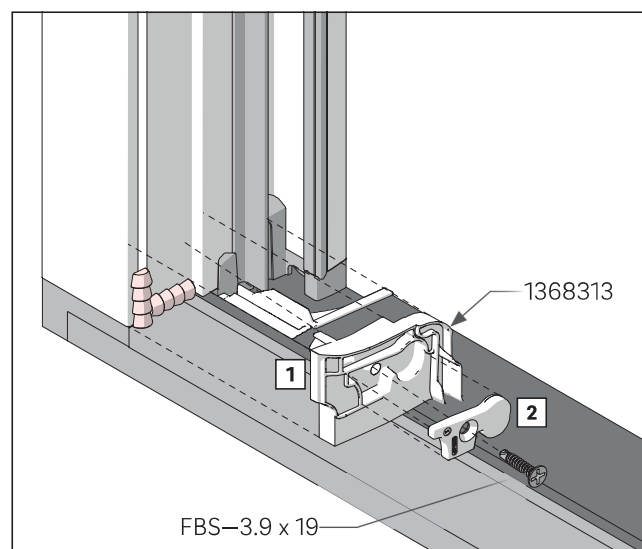


Fig. 10: Installation of the wind stop 1368313

01.07 Elements with fixed side section:

The fixed side section is constructed in accordance with the specifications for both French doors and side entrance doors in the "ARTEVO® production drawings" technical information:

- "Threshold ARTEVO® and mullion ARTEVO® – fixed side panel"

The length of the drainage channel corresponds to the total element width.

i After installation, the drainage grate must be removable to clean the drainage channel (note the installation situation)! For this reason, the drainage grate must be divided when using a roller shutter guide, for example. REHAU Drainage is used to drain the window and is not dimensioned for full-surface drainage. Surface drainage requires on-site drainage dimensioning.

For the elements with a threshold and fixed side section, the corresponding test reports from the ARTEVO® system apply to the area of the fixed side panel.

02 Instructions for installing a dummy mullion sash

02.01 Before installation:

- These instructions are for installation of the two-sash window, shootbolt-operated, (dummy mullion sash) in the case of a mullion element.
- In the case of a dummy mullion element, the frame (incl. threshold) and the moving sash are installed in accordance with Section "01. Instructions for installing single-sash elements." In contrast to the single-sash element, the front chamber at the bottom of the moving sash in the area of the mullion stop (fig. 11) must be ventilated with a 25 x 5 mm slot.

02.02 Installation on the mullion sash:

- Cut the adapter profile 1358224 and the weather rail 1368308 to size (sash rebate dimension = SRD):
 - Two-sash window, shootbolt-operated, with small dummy mullion profile: length = SRD – 27 mm.
 - Two-sash window, shootbolt-operated, with dummy mullion: length = SRD – 9 mm.
 - Two-sash window, shootbolt-operated, with dummy mullion sash: length = SRD – 43 mm.
- Snap weather rail onto the adapter profile. To do this, turn both parts together until you hear them click into place (see page 3, fig. 1). The weather rail is secured later on by being screwed to the sash.
- Each end cap for the adapter profile consists of two parts (see page 3, fig. 2). Seal part of  the end caps

1368287/1368288 to the adapter profile and install with the stainless-steel screws (see page 3, fig. 3). Part  of the end caps will be installed later. The end caps are installed  on both sides. Note: Both parts of the end cap are connected to each other for production reasons and must be separated from each other.

- Cut the lowerable floor seal to length:
 - Two-sash window, shootbolt-operated, with small dummy mullion profile: length = SRD + 16 mm.
 - Two-sash window, shootbolt-operated, with dummy mullion: length = SRD + 34 mm.
 - Two-sash window, shootbolt-operated, with dummy mullion sash: length = SRD + 1 mm

Attention: Do not cut to length on the release side! The floor seal may be shortened by a maximum of 125 mm!

- Deburr the cut surfaces and slide the lowerable floor seal into the groove provided in the adapter profile. The floor seal must seal flush on the hinge side with the weather rail end cap (see page 13, fig. 5) and flush on the lock side
 - With sash rebate in the case of dummy mullion sashes
 - With mullion end cap in the case of small dummy mullion profile
 - With dummy mullion end cap for dummy mullion profile.

Attention: Make sure that the release is on the hinge side!

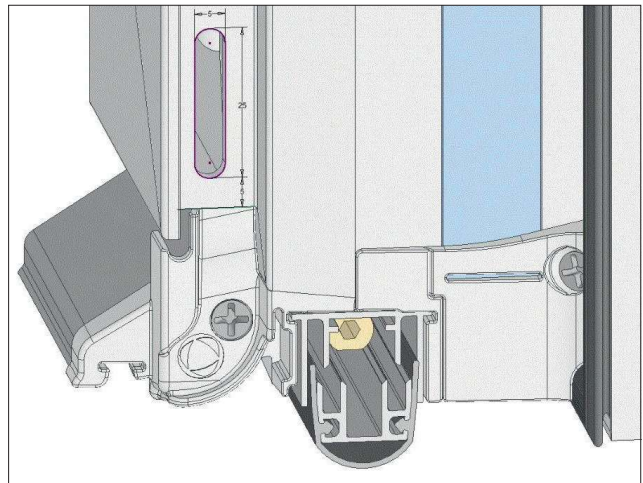


Fig. 11: Ventilation of the front chamber of the moving sash

- Apply silicone to the adapter profile as shown in fig. 5 (see page 13) and also seal the weather rail end cap to the sash with silicone. Then attach the adapter profile, including the already installed end cap, to the bottom of the sash and screw it through the end caps.
- Only pre-drill the adapter profile in the fitting groove and on the weather rail according to fig. 5 (see page 13) with 4.5 mm diameter or 3.2 mm diameter; one hole each starting approx. 50 mm from the outside and additional holes at 300 mm intervals. Select the drilling depth on the weather rail so that the weather rail and the adapter profile are drilled through, but the sash profile itself is not drilled into. Now screw the adapter profile into the pre-drilled holes using self-tapping or sheet metal screws (after pre-drilling with 2.5 mm diameter). This screw connection also secures the lowerable floor seal in the groove (fig. 5 and 6, see page) 13. Then seal the floor seal to the adapter profile and the end cap with silicone (fig. 6, see page 13).
- Make sure that silicone does not get into the floor seal or onto the sealing surface.
- The hardware can now be installed. Please observe the installation instructions for the second part of the weather rail end cap (hinge side) in items "01.03 Installation with French doors" (see page 13) and "01.04 Installation with side entrance doors" (see page 14).
- After the hardware and the second part of the weather rail end cap have been installed on the hinge side, the weather rail mullion end cap is installed on the lock side.
- First install the sealing end plugs enclosed with the weather rail mullion end caps to the respective drop-down seal (fig. 12.1 and fig. 12.2). Insert the sealing end plug into the drop-down seal as far as it will go and secure it with the screw provided.
- Then seal the end cap 1368289/1368290 to the adapter profile (silicone bead and PVC adhesive on the mullion end cap as shown in fig. 14) and install with the stainless-steel screws (fig. 13).

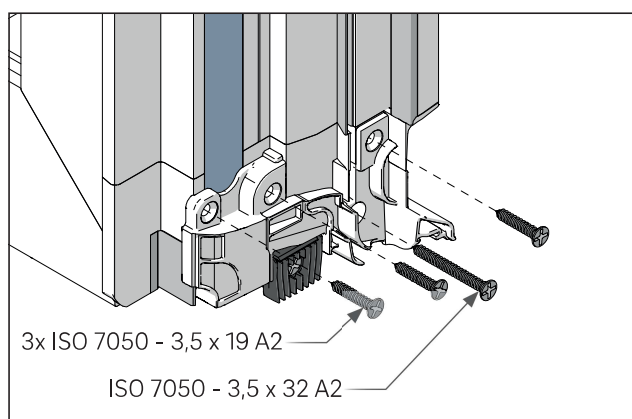


Fig. 13: Installation of the weather rail mullion end cap 1368289/1368290

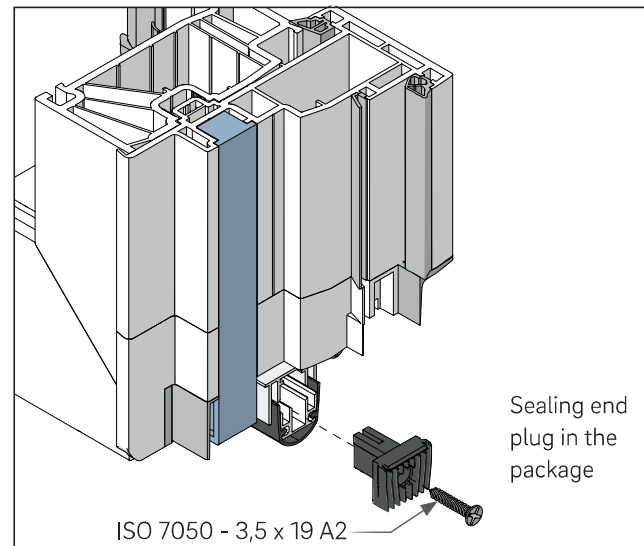


Fig. 12.1: Installation of the end cap for the floor seal – two-sash window, shootbolt-operated

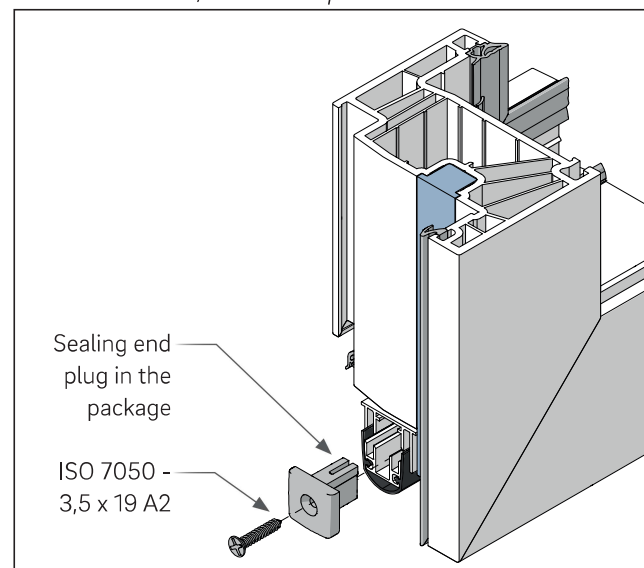


Fig. 12.2: Installation of the end cap for the floor seal – moving sash

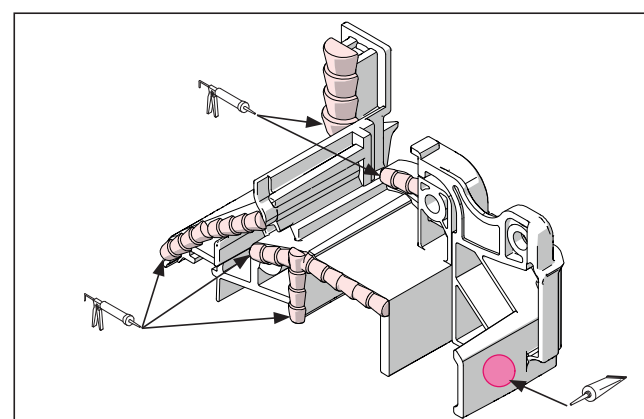


Fig. 14: Silicone and adhesive details: sealing of weather rail mullion end cap 1368289/1368290

- On the moving sash, glue the EPDM sealing pad enclosed in 1368287/1368288 into the fitting groove of the end cap at a distance of 12 mm from the sash rebate (fig. 15).
- Glue the sealing pad enclosed in 1368289/1368290 flush with the end of the adapter profile 1368308 in the fitting groove of the two-sash window, shootbolt-operated (fig. 15).

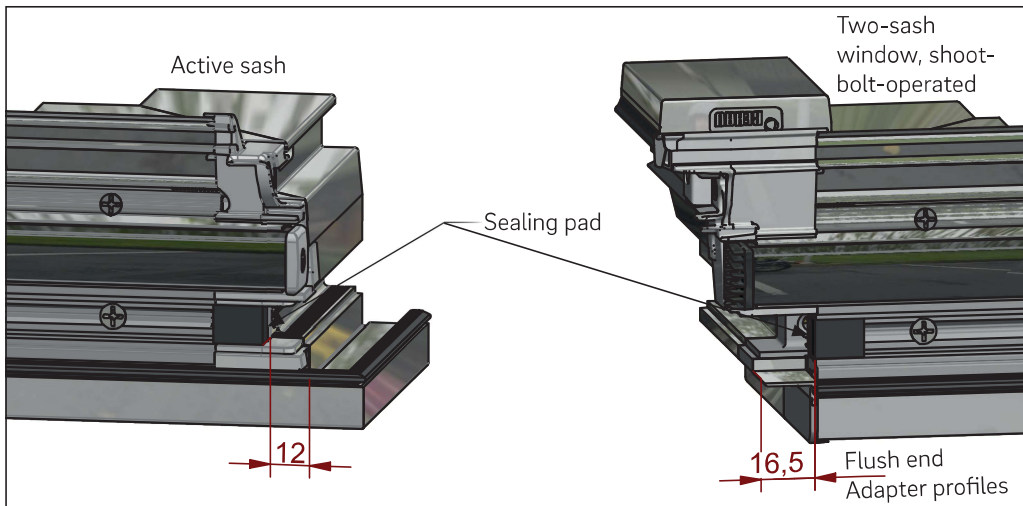
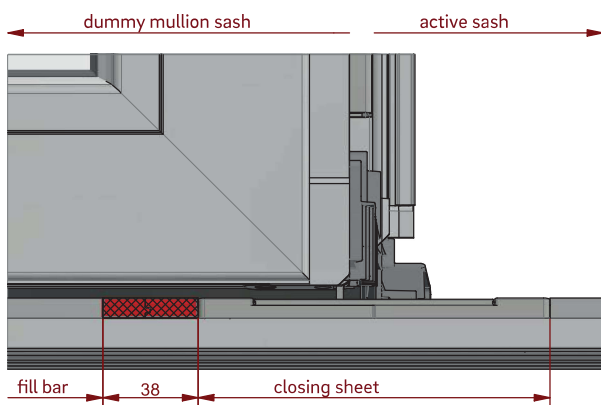
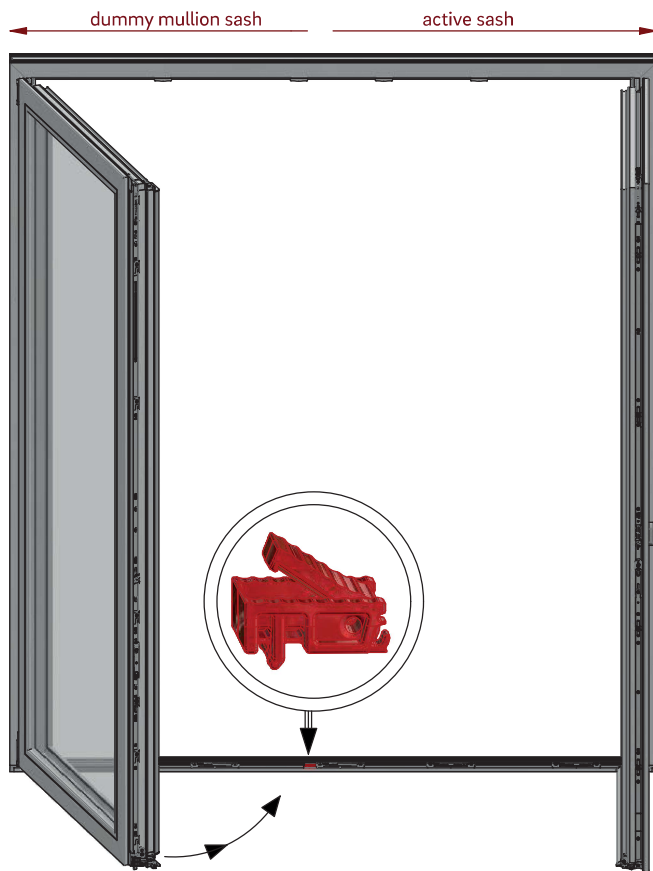
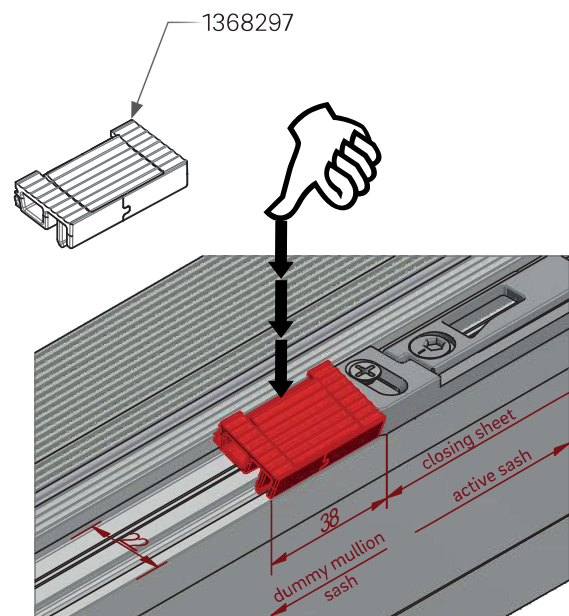


Fig. 15: EPDM sealing pad installation details

03 Instructions for installation of the closing aid 1368297



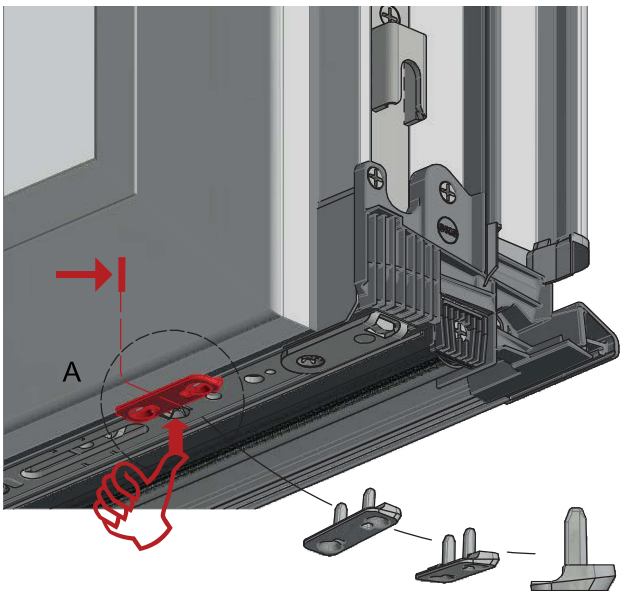
Position of the closing aid 1368297



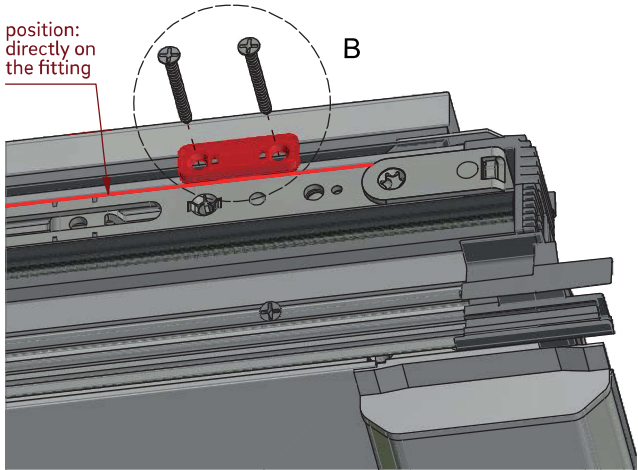
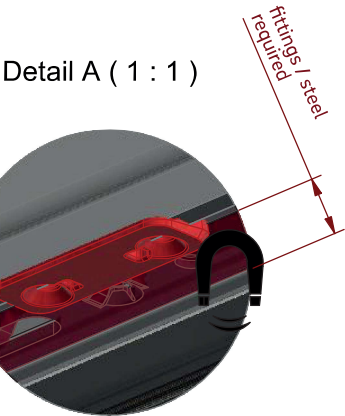
Insert closing aid 1368297



Mark position on mullion sash

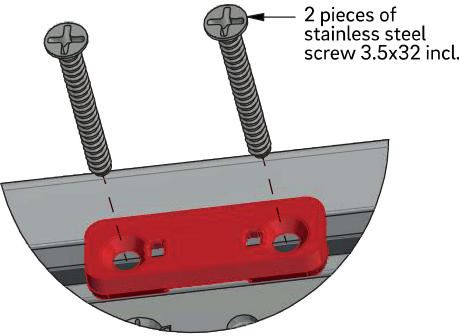


Positioning sash plate



Installing sash plate

Detail B (1 : 1)



06 Installation

Preparation of the drainage channel:

- Cut the drainage channel (base body and grate) to length as required. If a roller shutter guide is installed, the grate of the drainage channel must be divided accordingly so that it can be removed later for channel cleaning.
- Depending on the local conditions according to good engineering practice, either align and secure the drainage channel in the gravel bed or use the concrete anchors.
- If the concrete anchors are to be used, insert the 1 concrete anchor into the recess and secure it by pulling it downwards 2 (see Fig. 17). This secures the concrete anchor to the channel. Use a hammer to knock in the sheet metal bracket 3 to finally secure the concrete anchor (fig. 18).
- Align drainage channel with concrete anchor and secure it in sufficient concrete.

On the construction site.

- The element must be installed so that the top edge of the threshold and the top edge of the channel are level with the upper edge of the finished floor.
- The lowerable floor seal must be adjusted so that it presses lightly on the threshold across its entire width (see the "Lift setting of the floor seal" section for this).
- Outside, the drainage channel must be installed after the element has been fully connected to the building structure and sealed.
- The drainage channel must be connected to a drainage system.
- To prevent damage to the floor seal, we recommend first setting the floor seal so that it does not exert pressure when installed in the building shell.
- Otherwise, the release of the floor seal should protrude approx. 6–7 mm from the seal for an initial basic setting.
- The floor seal must be raised during transportation to prevent damage (for more information, visit www.planet.ag).

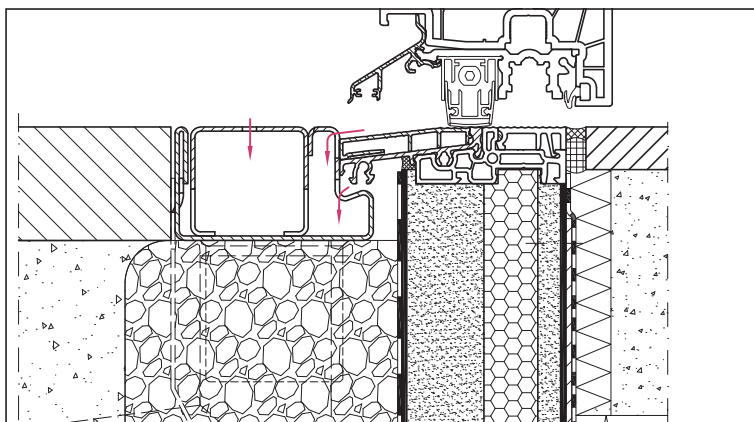


Fig. 18: RAUCERO ARTEVO floor connection (example)

i The drainage channel is used exclusively for draining the threshold and door. Exposed surfaces or the façade must be drained separately.

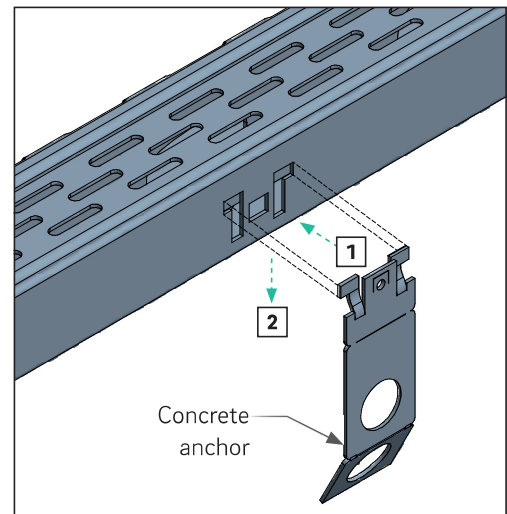


Fig. 16: Installation of the concrete anchor – inserting the concrete anchor

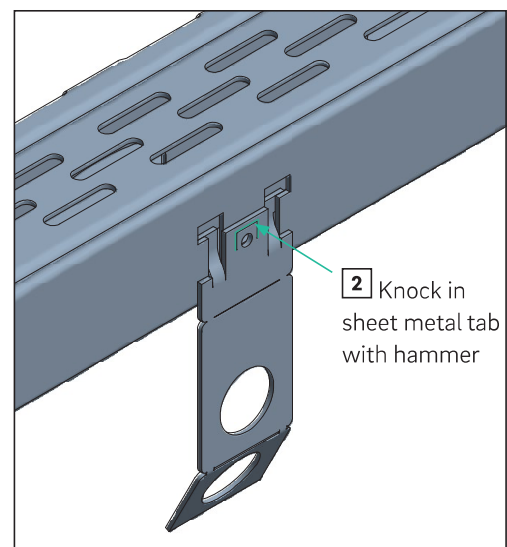


Fig. 17: Installation of the concrete anchor – securing the concrete anchor

i The formation of barrier-free thresholds can lead to condensation. Floor coverings adjacent to the threshold on the room side must be designed to be suitably moisture-resistant (see also RAL manual "Guidelines for installation").

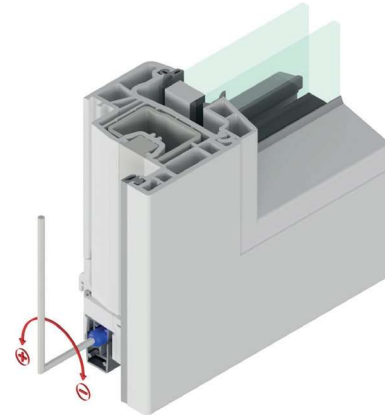
Lift setting of the drop-down seal



The release is always on the hinge side!

On the construction site.

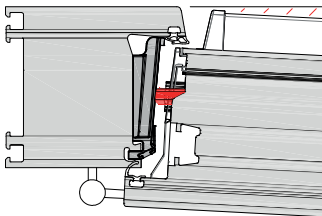
- To prevent damage to the floor seal in the building shell, the release must be fully screwed in. The floor seal does not release when closing.
- The floor seal is set on completion of the construction work. To do this, unscrew **+** the release with a 3 mm Allen key until the seal seals properly when the door is closed. The setting is correct as soon as the joint is airtight when the sash is closed.
- Excessive pressure on the seal must be avoided!
- After completion, a functional test of the drop-down seal must be carried out.



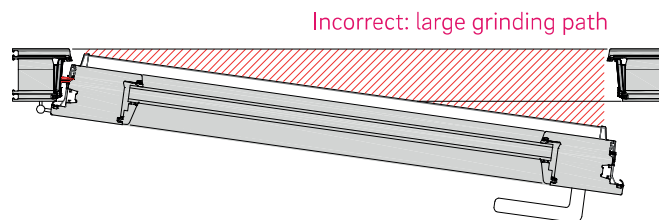
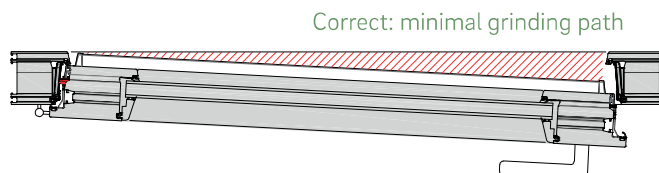
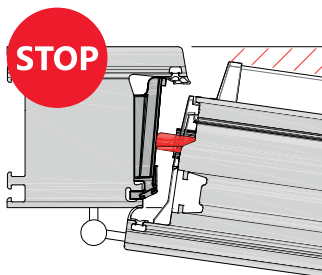
- +** Increase pressure (turn left)
- Reduce pressure (turn right)

Setting of the release head (only on completion):

- Optimal release



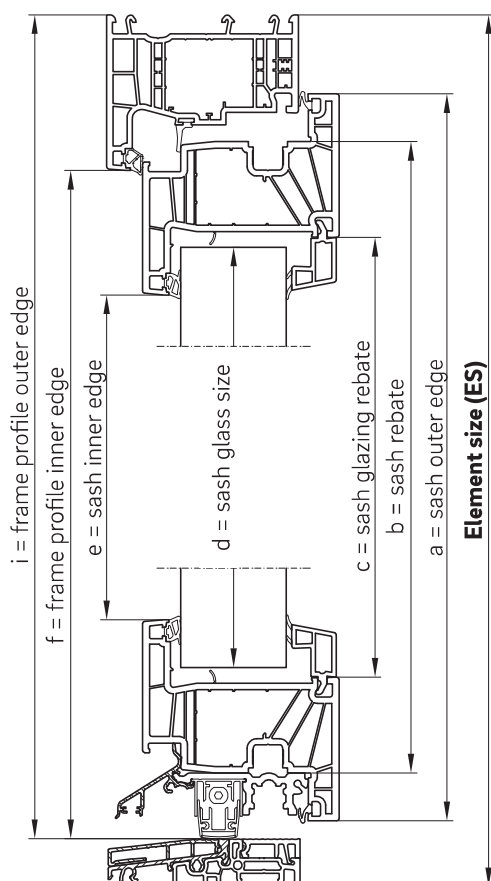
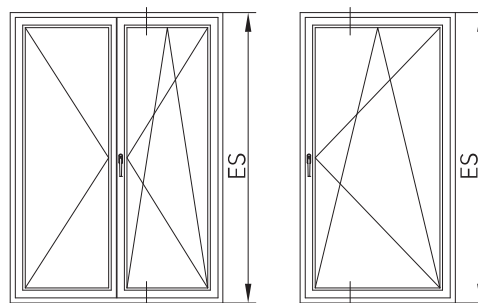
- Premature release!



07 Manufacturing dimensions

One-piece doors with RAUCERO ARTEVO threshold

Glazing rebate clearance, sash: 4 mm
Glass rebate clearance fixed light: 10 mm
Fittings rebate clearance (FRC): 12 mm top / 10 mm bottom



Profile

Cutting sizes

Frame profile	
Frame profile	ES - 20 mm
Frame profile with rebate adapter 1368257	Element size
Reinforcement frame with threshold	Frame profile glass rebate - 15 mm

Sash muntins	
Sash muntin 72	Sash glazing rebate + 8 mm
Georgian bar reinforcement	Sash glazing rebate - 20 mm

RAUCERO threshold area—single-sash element	
Threshold 80/80, 1356663	Element size - 24 mm
Cover rail threshold installation depth 80	Frame profile glass rebate
Weather rail, 1358225	Sash rebate - 52 mm
Adapter profile 1358224	Sash rebate - 52 mm
Drainage profile, 1358221	Frame glass rebate - 86 mm
Lowerable floor seal	Sash rebate - 2 mm
Drainage channel, 1358400, 1358500, 1358600	element width

RAUCERO threshold area—two-sash element	
Threshold construction depth 80, 1356663	Element size - 24 mm
Cover rail threshold installation depth 80	Frame profile glass rebate
Adapter profile 1358224—moving sash	Sash rebate - 52 mm
Adapter profile 1358224—two-sash window, shootbolt-operated, with mullion sash	Sash rebate - 43 mm
Adapter profile 1358224—two-sash window, shootbolt-operated, with mullion profile	Sash rebate - 27 mm
Adapter profile 1358224—two-sash window, shootbolt-operated, with dummy mullion	Sash rebate - 9 mm
Weather rail, 1358225 - moving sash	Sash rebate - 52 mm
Weather rail 1358225—two-sash window, shootbolt-operated, with mullion sash	Sash rebate - 43 mm
Weather rail 1358225—two-sash window, shootbolt-operated, with mullion profile	Sash rebate - 27 mm
Weather rail 1358225—two-sash window, shootbolt-operated, with dummy mullion	Sash rebate - 9 mm
Drainage profile, 1358221	Frame glass rebate - 86 mm
Lowerable floor seal—moving sash	Sash rebate - 6 mm
Lowerable floor seal—two-sash window, shootbolt-operated, with mullion sash	Sash rebate + 1 mm
Lowerable floor seal—two-sash window, shootbolt-operated, with mullion profile	Sash rebate + 17 mm
Lowerable floor seal—two-sash window, shootbolt-operated, with dummy mullion	Sash rebate + 35 mm
Drainage channel, 1358400, 1358500, 1358600	Element width



The specifications in the "ARTEVO cutting sizes" technical information apply for determining the cutting lengths in relation to the element width (horizontal cut).

One-piece elements with RAUCERO ARTEVO threshold
Elementmaß (EM) in mm

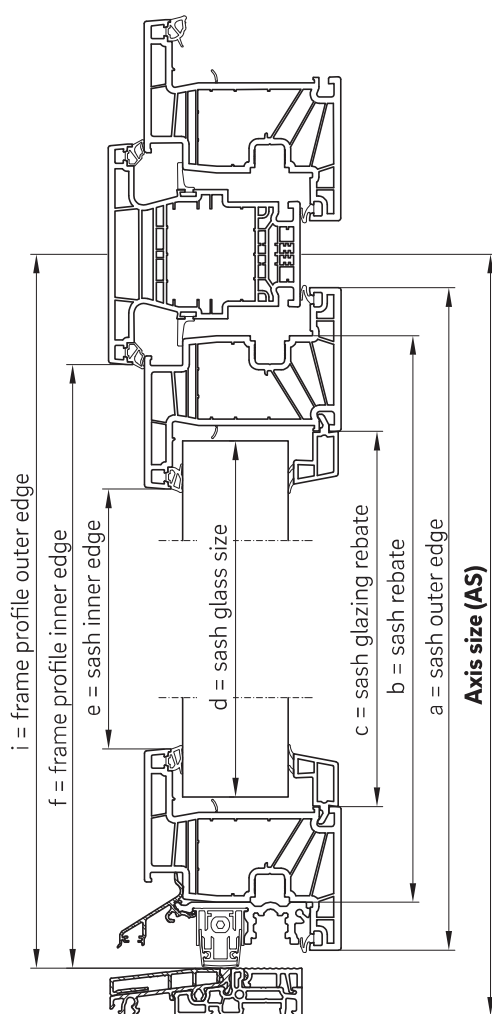
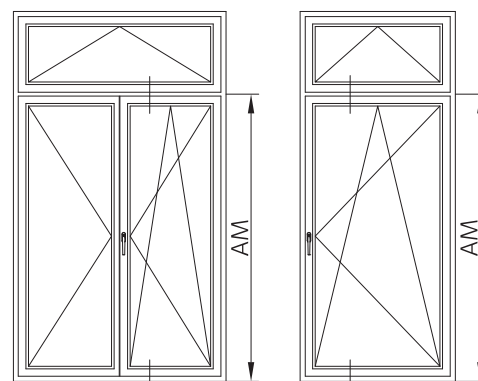
Profile name		Sash 53	Sash 64	Sash 86
Frame profile 65	a	- 60,5	- 60,5	- 60,5
	b	- 100,5	- 100,5	- 100,5
	c	- 158,5	- 180,5	- 224,5
	d	- 166,5	- 188,5	- 232,5
	e	- 206,5	- 2228,5	- 272,5
	f	- 85	- 85	- 85
	i	- 20	- 20	- 20
Frame profile 75	a	- 70,5	- 70,5	- 70,5
	b	- 110,5	- 110,5	- 110,5
	c	- 168,5	- 190,5	- 234,5
	d	- 176,5	- 198,5	- 242,5
	e	- 216,5	- 238,5	- 282,5
	f	- 95	- 95	- 95
	i	- 20	- 20	- 20
Frame profile 99	a	- 94,5	- 94,5	- 94,5
	b	- 134,5	- 134,5	- 134,5
	c	- 192,5	- 214,5	- 258,5
	d	- 200,5	- 222,5	- 266,5
	e	- 240,5	- 262,5	- 306,5
	f	- 119	- 119	- 119
	i	- 20	- 20	- 20



Final dimensions! When cutting the profiles to be welded, the weld allowance (burn-off: 2.5 to 3 mm on each side of the profile) must be added to the cutting length.

Multi-part doors with RAUCERO ARTEVO threshold

Glazing rebate clearance, sash: 4 mm
Glass rebate clearance fixed light: 10 mm
Fittings rebate clearance (FRC): 12 mm top / 10 mm bottom



Profile

Cutting sizes

Frame profile

Frame profile	ES – 20 mm
Frame profile with rebate adapter 1368257	Element size
Reinforcement frame with threshold	Frame profile glass rebate - 15 mm

Sash muntins

Sash muntin 72	Sash glazing rebate + 8 mm
Georgian bar reinforcement	Sash glazing rebate – 20 mm

RAUCERO threshold area—single-sash element

Threshold 80/80, 1356663	Element size – 24 mm
Cover rail threshold installation depth 80	Frame profile glass rebate
Weather rail, 1358225	Sash rebate – 52 mm
Adapter profile, 1358224	Sash rebate – 52 mm
Drainage profile, 1358221	Frame glass rebate - 86 mm
Lowerable floor seal	Sash rebate - 2 mm
Drainage channel, 1358400, 1358500, 1358600	Element width

RAUCERO threshold area—two-sash element

Threshold construction depth 80, 1356663	Element size – 24 mm
Cover rail threshold installation depth 80	Frame profile glass rebate
Adapter profile 1358224—moving sash	Sash rebate – 52 mm
Adapter profile 1358224—two-sash window, shootbolt-operated, with mullion sash	Sash rebate - 43 mm
Adapter profile 1358224—two-sash window, shootbolt-operated, with mullion profile	Sash rebate – 27 mm
Adapter profile 1358224—two-sash window, shootbolt-operated, with dummy mullion	Sash rebate - 9 mm
Weather rail, 1358225 - moving sash	Sash rebate – 52 mm
Weather rail 1358225—two-sash window, shootbolt-operated, with mullion sash	Sash rebate - 43 mm
Weather rail 1358225—two-sash window, shootbolt-operated, with mullion profile	Sash rebate – 27 mm
Weather rail 1358225—two-sash window, shootbolt-operated, with dummy mullion	Sash rebate - 9 mm
Drainage profile, 1358221	Frame glass rebate - 86 mm
Lowerable floor seal—moving sash	Sash rebate - 6 mm
Lowerable floor seal—two-sash window, shootbolt-operated, with mullion sash	Sash rebate + 1 mm
Lowerable floor seal—two-sash window, shootbolt-operated, with mullion profile	Sash rebate + 17 mm
Lowerable floor seal—two-sash window, shootbolt-operated, with dummy mullion	Sash rebate + 35 mm
Drainage channel, 1358400, 1358500, 1358600	Element width



The specifications in the "ARTEVO cutting sizes" technical information apply for determining the cutting lengths in relation to the element width (horizontal cut).

Multi-part doors with RAUCERO ARTEVO threshold

Axis size (AS) in mm

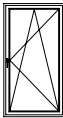
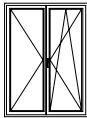
Profile name		Sash 53	Sash 64	Sash 86
Mullion 92	a	- 41,5	- 41,5	- 41,5
	b	- 81,5	- 81,5	- 81,5
	c	- 139,5	- 161,5	- 205,5
	d	- 147,5	- 169,5	- 213,5
	e	- 187,5	- 209,5	- 236
	f	- 66	- 66	- 66
	i	- 20	- 20	- 20
Mullion 112	a	- 51,5	- 51,5	- 51,4
	b	- 91,5	- 91,5	- 91,5
	c	- 149,5	- 171,5	- 215,5
	d	- 157,5	- 179,5	- 223,5
	e	- 197,5	- 219,5	- 263,5
	f	- 76	- 76	- 76
	i	- 20	- 20	- 20



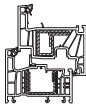
Final dimensions! When cutting the profiles to be welded, the weld allowance (burn-off: 2.5 to 3 mm on each side of the profile) must be added to the cutting length.

08 Overview of test reports

Water tightness, air permeability, wind resistance ability

Element	Sash size W x H (mm)	Profiles/colour	Reinforcements	Glazing (mm)	Fittings	Test report	Resistance against driving rain EN 12208	Air permeability EN 12207	Resistance to wind load EN 12210
	1.050 x 2.350	Sash Z64 Frame profile 65 white	- -	44	Maco Multi-Zero	ift 22-003047-PR53	9A	4	C4/B4
	863 x 2.325	Sash Z64 Frame profile 75 Small dummy mullion white	1358167 - 1358169	44	Maco Multi-Zero	ift 22-003047-PR54	8A	4	C2/B2

Sound insulation tests conforming to EN ISO 140-1

Profile combination	Glazing/infill panel			Sound insulation factor of window		
	Manufacturer/type/structure	R _w (C, Ctr) [dB]	Thick- ness [mm]	Test report	R _w (C, Ctr) [dB] EN ISO 717-1	Test report
	Saint-Gobain 6 / 18 (Ar) / 4 / 16 (Ar) / 4	37 (-1; -5)	48	On the basis of comparable superstructures see ift PB 23-001897- PR04	37 (-2; -4)	ift 24-001588-PR01
	Saint-Gobain 8 VSG acoustics / 18 (Ar) / 4 / 16 (Ar) / 8	46 (-2; -7)	54,76	On the basis of comparable superstructures see ift PB 23-001897- PR04	42 (-2; -4)	ift 24-001588-PR01
	Saint-Gobain 12 LSG SG / 14 (Ar) / 4 / 14 (Ar) / 8 LSG SG	51 (-2; -7)	53,52	ift PB 12-002463- PR01	43 (-1; -4)	ift 24-001588-PR01

09 Inspection, maintenance and care

Barrier-free thresholds, in particular what is known as zero thresholds, require increased maintenance to ensure that they are permanently watertight.

The following points are important to maintain the quality of the product:

- Take the maintenance contract into account.
- Regular inspection and service work to determine in particular whether the parts (e.g., window sashes) can still move freely.
- Cleaning of the sealing components such as drop-down seals and drainage (drainage channel with grate) also required outside the inspection intervals if soiled.

General information and supplements on the use, operation and maintenance of lowerable floor seals can be found in the "Planet general catalog" at www.planet.ag.

10 Article directory

Article no.	Designation	Make-up length / Pack or bundle in m	Stillage (LGP) in m	Carton/ Bag in units	Page
1358097	Lowerable floor seal, length RAUCERO ARTEVO®: 460 mm			10	8
1358098	Lowerable floor seal, length RAUCERO ARTEVO®: 485 mm			10	8
1358099	Lowerable floor seal, length RAUCERO ARTEVO®: 710 mm			10	8
1358221	Drainage profile RAUCERO ARTEVO®	6/60			5
1358224	Adapter profile RAUCERO ARTEVO®	6/60			7
1358228	Lowerable floor seal, length RAUCERO ARTEVO®: 835 mm			5	8
1358229	Lowerable floor seal, length RAUCERO ARTEVO®: 960 mm			5	8
1358231	Lowerable floor seal, length RAUCERO ARTEVO®: 1,085 mm			5	8
1358232	Lowerable floor seal, length RAUCERO ARTEVO®: 1,210 mm			5	8
1358233	Lowerable floor seal, length RAUCERO ARTEVO®: 1,335 mm			5	8
1358234	Lowerable floor seal, length RAUCERO ARTEVO®: 1,460 mm			5	8
1368264	Right threshold support for frame profile 65 ARTEVO® right			50	6
1358239	Drilling jig for RAUCERO ARTEVO® lowerable floor seal			1	10
1358400	Lowerable floor seal, length RAUCERO ARTEVO®: 1,240 mm			1	9
1358500	Lowerable floor seal, length RAUCERO ARTEVO®: 1,970 mm			1	9
1358600	Lowerable floor seal, length RAUCERO ARTEVO®: 2,250 mm			1	9
1368265	Threshold support for frame profile 65, left ARTEVO®			50	6
1368274	Threshold support for frame profile 75, right ARTEVO®			50	6
1368275	Threshold support for frame profile 75, left ARTEVO®			50	6
1368298	Threshold support for frame profile 99, right ARTEVO®			50	6
1368299	Threshold support for frame profile 99, left ARTEVO®			50	6
1368280	Threshold set 80/80 ARTEVO®	6		50	5
1368287	Weather rail end cap set, right RAUCERO ARTEVO®			10	8
1368288	Weather rail end cap set, left RAUCERO ARTEVO®			10	8
1368289	Weather rail end cap mullion set, right RAUCERO ARTEVO®			10	8
1368290	Weather rail end cap mullion set, left RAUCERO ARTEVO®			10	8
1368292	Mullion threshold support 92 ARTEVO®			50	7
1368293	Drilling jig for threshold support			1	10
1368294	Mullion threshold support 112 ARTEVO®			50	7
1368297	Set closing aid RAUCERO ARTEVO®			10	9
1368308	Weather rail RAUCERO ARTEVO®	6/60			8
1368311	Drainage profile end cap, right RAUCERO ARTEVO®			10	5
1368312	Drainage profile end cap left RAUCERO ARTEVO®			10	5
1368313	Wind stop set RAUCERO ARTEVO®			10	7
1368317	Compensating profile ARTEVO®	6			9

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