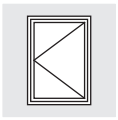
ALU 5200-D

Assembly instructions




Single-sash square turn-only

Aluminium eurogroove 15/20

Chamber dimension 21

Versions A0004/A0006/A0022

Hinge clearance (BD) 3.5

Size range

		Windows	Patio doors
Sash width	(mm)	365 – 1600	365 – 1300
Sash height	(mm)	550 – 2000	2000 – 2400
Sash weight	(kg)	max. 100/130	max. 100/130

The following application diagrams apply:

-max. 100 kg	document Nr.: H58.AWDLS003EN
-max. 130 kg	document Nr.: H58.AWDLS004EN

The following documentation is required:

-Profile recommendation ALU20	document Nr.: H45.ALUS001EN
-ALU Maintenance instructions	document Nr.: H49.ALUS001EN
-ALU Service instructions	document Nr.: H47.ALUS001EN
-ALU Operating instructions	document Nr.: H47.ALUS002EN
-ALU Important notices	Document Nr.: H45.ALUS003EN

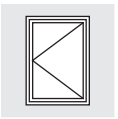
Please observe:

Guidelines/notes on the product and on liability (VHBH directive as well as the further applicable documents)!
Specifications from the profile manufacturers or system owners for windows and patio doors!

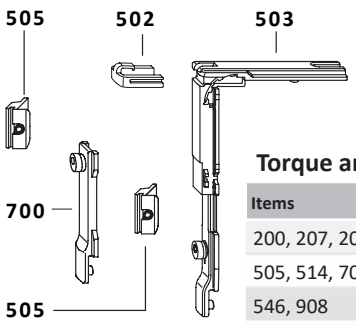
See SIEGENIA download portal for all documentation!

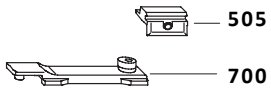
Hardware overview

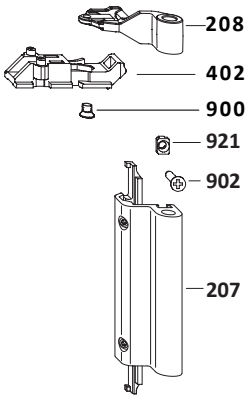
Single-sash square turn-only
hinge side ALU 5200 130 kg BD3.5





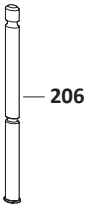


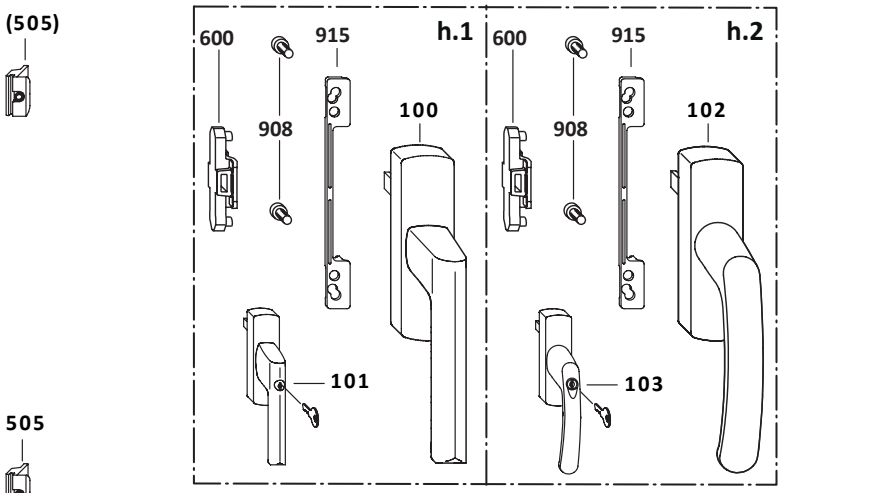


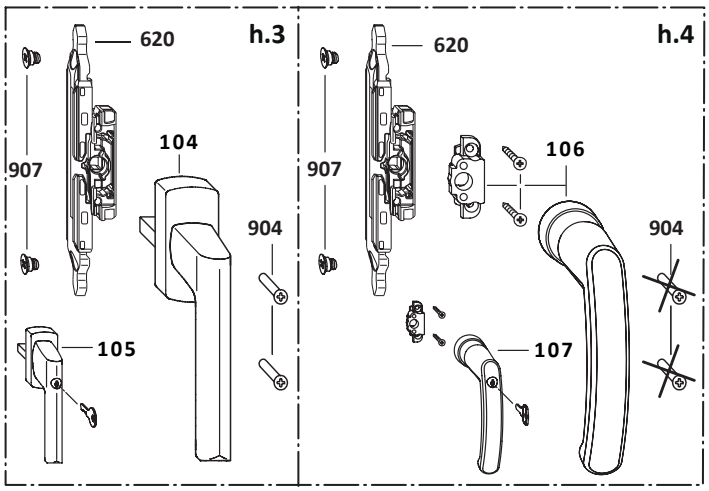


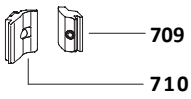
Torque and tooling information

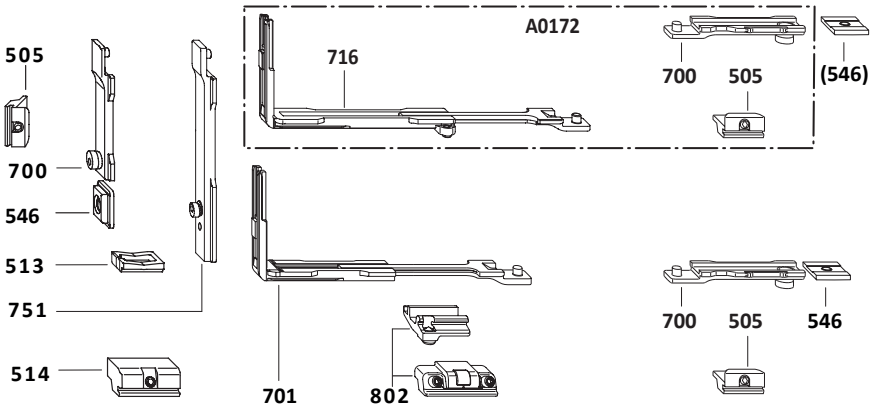
Items	Nm (± 0.25)	
200, 207, 208, 716, 900, 901	⬡ 2.5	2.5
505, 514, 709, 710, 802	⬡ 1.5	2.5
546, 908	⬡ 2.5	4
902, 904, 907	✱ 2.7	PZ2
106, 107	⊕ 2.5	PH2

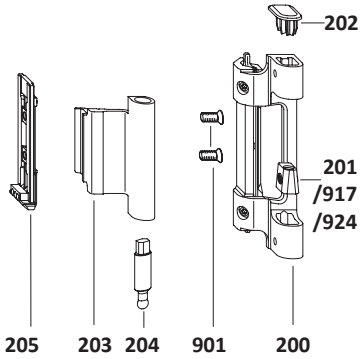












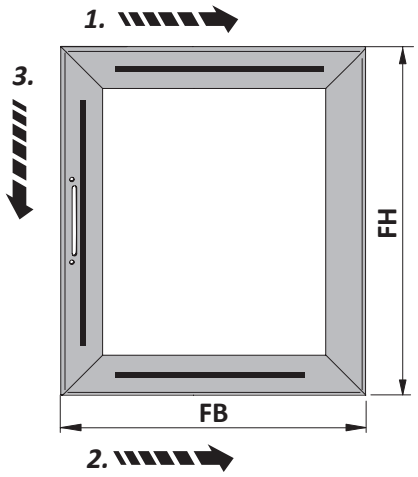
	Item	Pieces	Material description		Material number	VE	Material number	VE
h.1	100	1	**ALU Si-line handle**	(Only use in combination with coupling set)	See handle overview in download portal			
	101		**ALU Si-line lockable handle**					
h.2	102		**ALU Globe handle**					
	103		**ALU GLOBE lockable handle**					
h.3	104		**TITAN handle**	(Only use in combination with gear set)	□ 7 mm x 25 mm, cam Ø 10 mm Only use in combination with gear set			
	105		**TITAN lockable handle**					
h.4	106		**ALU Globe RR handle**		See handle ALU Globe RR in download portal			
	107		**ALU Globe RR lockable handle**					
		1	**Hinge side ALU 5200 BD3.5** (only for hinge clearance ≥ 3.5 mm < 5 mm)	**Silver**	**MMBS0220-52501_**	**1**	**MMBS0220-52502_**	**10**
				RAL 9010	**MMBS0220-50301_**	**1**	**MMBS0220-50302_**	**10**
				RAL 9016	**MMBS0220-50401_**	**1**	**MMBS0220-50402_**	**10**
				RAL 9005	**MMBS0220-52301_**	**1**	**MMBS0220-52302_**	**10**
				EV 1	**MMBS0220-52401_**	**1**	**MMBS0220-52402_**	**10**
				Mill finish	–	–	**MMBS0220-50012_**	**5**
	200	1	Bottom hinge					
	201	1	Adjusting piece					
	202	1	Cover cap					
	203	1	Corner hinge					
	204	1	Bottom hinge pin					
	205	1	Clamping piece E					
	206	1	Hinge pin					
	207	1	Top hinge					
	208	1	Stay hinge					
	900	1	Countersunk screw M5 x 7 (red screw lock)					
	901	2	Countersunk screw M5 x 8.5 (blue screw lock)					
		0...1	**Accessories set ALU 5200 > 100 kg**		–	**1**	**MZBS0110-00003_**	**20**
	902	1	Countersunk screw M5 x 13					
	921	1	Supporting piece					
	924	1	Adjusting piece S					
		1	**Locking side ALU-D SDF**		**MMVS0280-10001_**	**1**	**MMVS0280-10003_**	**20**
	402	1	Top stay ALU-D					
	505	2	Striker					
	513	1	Run-up block					
	514	1	TBT run-up block					
	700	2	Slider					
h.1 h.2		**0...1**	**ALU coupling set**	Only use with h.1/h.2	**MMKL0060-10001_**	**1**	**MMKL0060-10003_**	**20**
	600	1	Coupling bracket					
	908	2	Cheese head screw M5 x 12					
h.3 h.4		**0...1**	**ALU gear set**	Only use with h.3/h.4 (see SIEGENIA-download portal)	**MMGI0090-10001_**	**1**	**MMGI0090-10003_**	**20**
	620	1	M6 ESG					
	904	2	Countersunk screw M5 x 35					
	907	2	Coupling screw M6					
system-dependent		**0...1**	**MV ALU-D VS/BS**	FH > 1250	**857052**	**1**	**246986**	**20**
	505	1	Striker					
	709	1	Striker MV					
	710	1	Locking bolt					
dependent on system		**0...1**	**MV ALU-D VSU/VSO**	FB > 1250	**MMMV0040-10001_**	**1**	**MMMV0040-10003_**	**20**
	502	1	Clamping piece EUL					
	503	1	VSO corner drive					
	505	2	Striker					
	701	1	VSU/BSO corner drive					
	751	1	Locking bolt					
Recessed groove dependent on system		**0...1**	**MV ALU-D VSU/VSO A0172**	FB > 1250	**MMMV0080-10001_**	**1**	**MMMV0080-10003_**	**20**
	502	1	Clamping piece EUL					
	503	1	VSO corner drive					
	505	2	Striker					
	716	1	Corner drive VSU/BSO A0172					
	751	1	Locking bolt					

Hardware list and assembly instructions

Single-sash square turn-only
hinge side ALU 5200 130 kg BD3.5

	Item	Pieces	Material description		Material number	VE	Material number	VE
Accessories	546	0...1	**Stop**	For travel restriction (install horizontally from sash width > 1250)	**820544**	**1**	**222805**	**10**
	802	0...1	**Sash lifter ALU**	see SIEGENIA-download portal	**MMFH0010-10001_**	**1**	**MMFH0010-10003_**	**20**
	915	0...1	**ALU handle support**	Only use for h.1/h.2	–	–	(see table)	**200**
	917	0...1	**Adjusting piece AV**	For compression + 0.5 mm	**MXBS0100-00001_**	**1**	**MXBS0100-00002_**	**10**
	-	0...1	**Jig ALU 5200 additional screw connection**	for countersunk screw M5 x 13 (item 902) and supporting piece (item 921) > 100 kg (see page 8)	**MARB0050-00001_**	**1**	–	–

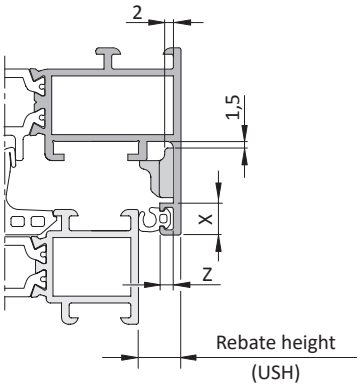
Observe assembly sequence!



sequence of installation in the sash:
-without centre lock (3.)
-with centre lock (1.-2.- 3.)

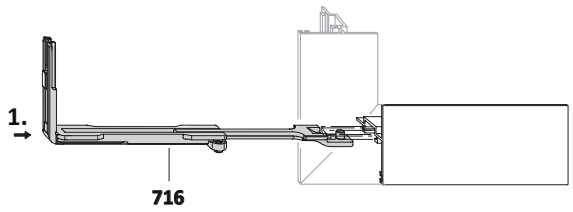
Design variations for handle support (item 915) (h.1/h.2)

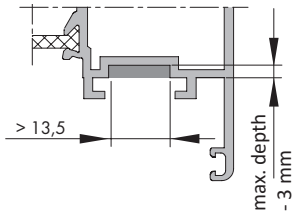
USH (mm)	Z (mm)	X ≤ 7 mm	X > 7 ≤ 8.5 mm
7 - 10	≤ 2	MFHA0010-10020_	MFHA0010-10020_
	> 2 ≤ 3		MFHA0020-10020_
	> 3		-

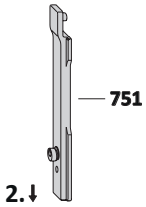


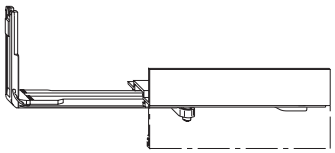
Assembly of the corner drive VSU/BSO A0172 (item 716) to the VSU

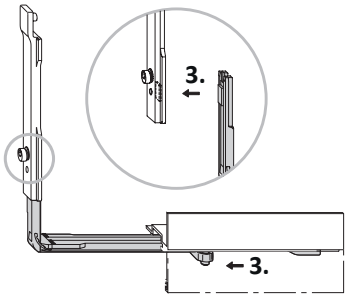
Note: For recessed sash groove from a width of > 13.5 mm and a recess of - 0.5 mm to - 3 mm, use “MV ALU-DK/TBT A0172“!

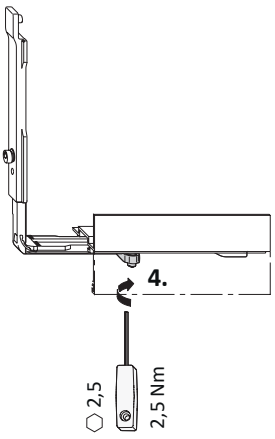








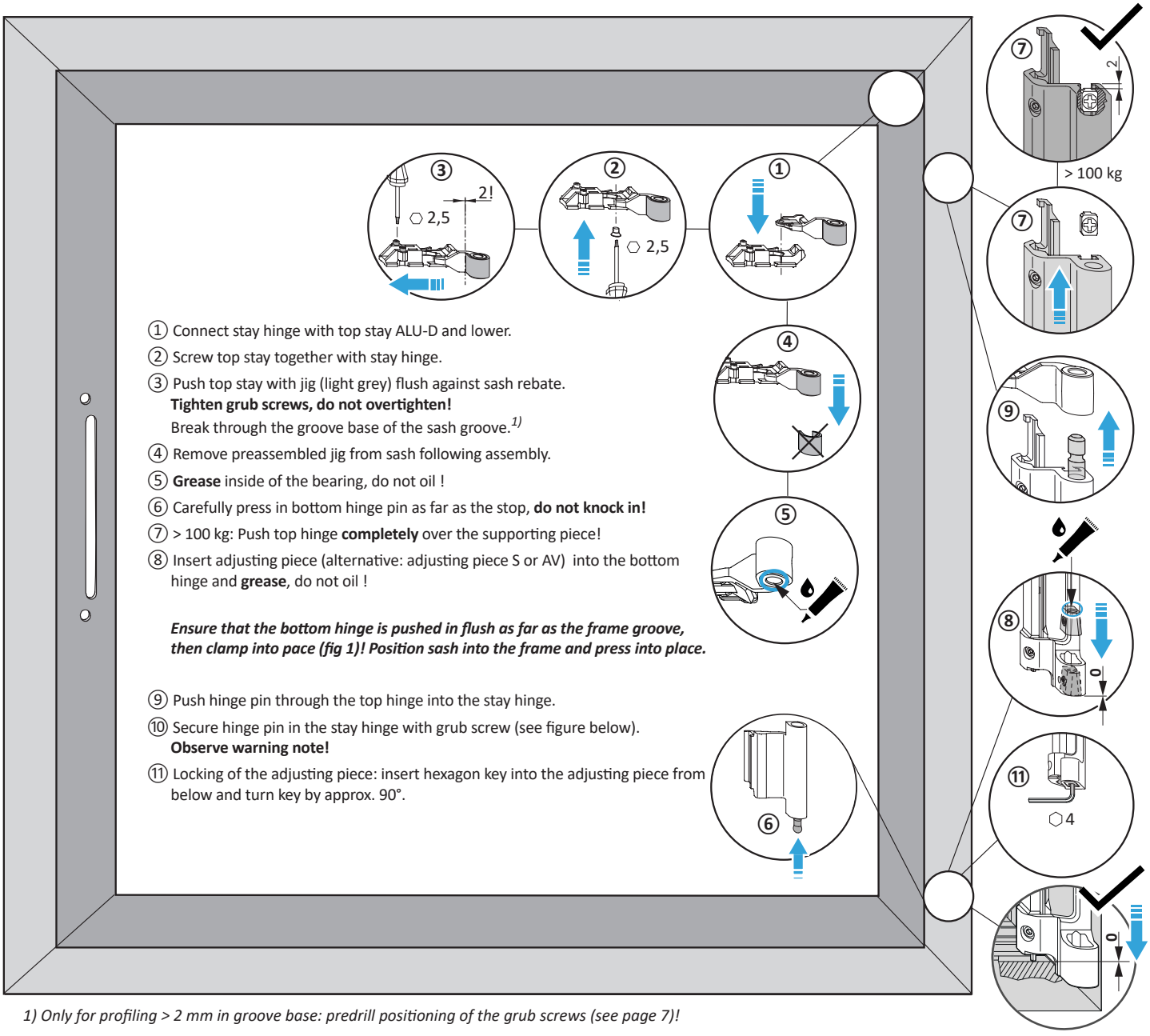




Assembly settings

Single-sash square turn-only
hinge side ALU 5200 130 kg BD3.5

Montagehinweise Schere und Beschlagteile Bandseite



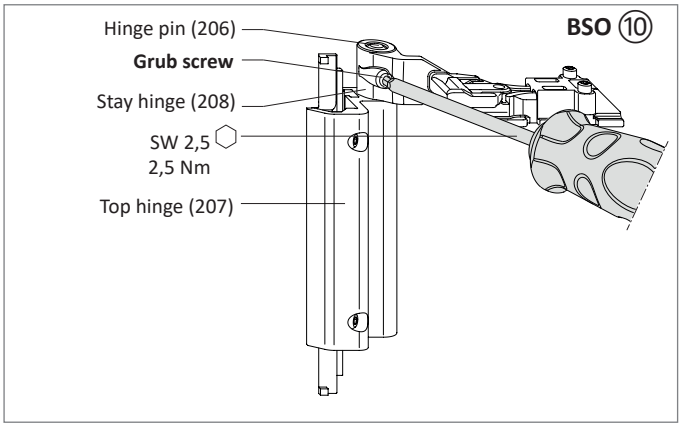
① Connect stay hinge with top stay ALU-D and lower.
② Screw top stay together with stay hinge.
③ Push top stay with jig (light grey) flush against sash rebate.
Tighten grub screws, do not overtighten!
Break through the groove base of the sash groove.[1)]
④ Remove preassembled jig from sash following assembly.
⑤ **Grease** inside of the bearing, do not oil !
⑥ Carefully press in bottom hinge pin as far as the stop, **do not knock in!**
⑦ > 100 kg: Push top hinge **completely** over the supporting piece!
⑧ Insert adjusting piece (alternative: adjusting piece S or AV) into the bottom hinge and **grease**, do not oil !

Ensure that the bottom hinge is pushed in flush as far as the frame groove, then clamp into pace (fig 1)! Position sash into the frame and press into place.

⑨ Push hinge pin through the top hinge into the stay hinge.
⑩ Secure hinge pin in the stay hinge with grub screw (see figure below).
Observe warning note!
⑪ Locking of the adjusting piece: insert hexagon key into the adjusting piece from below and turn key by approx. 90°.

1) Only for profiling > 2 mm in groove base: predrill positioning of the grub screws (see page 7)!

Bild 1

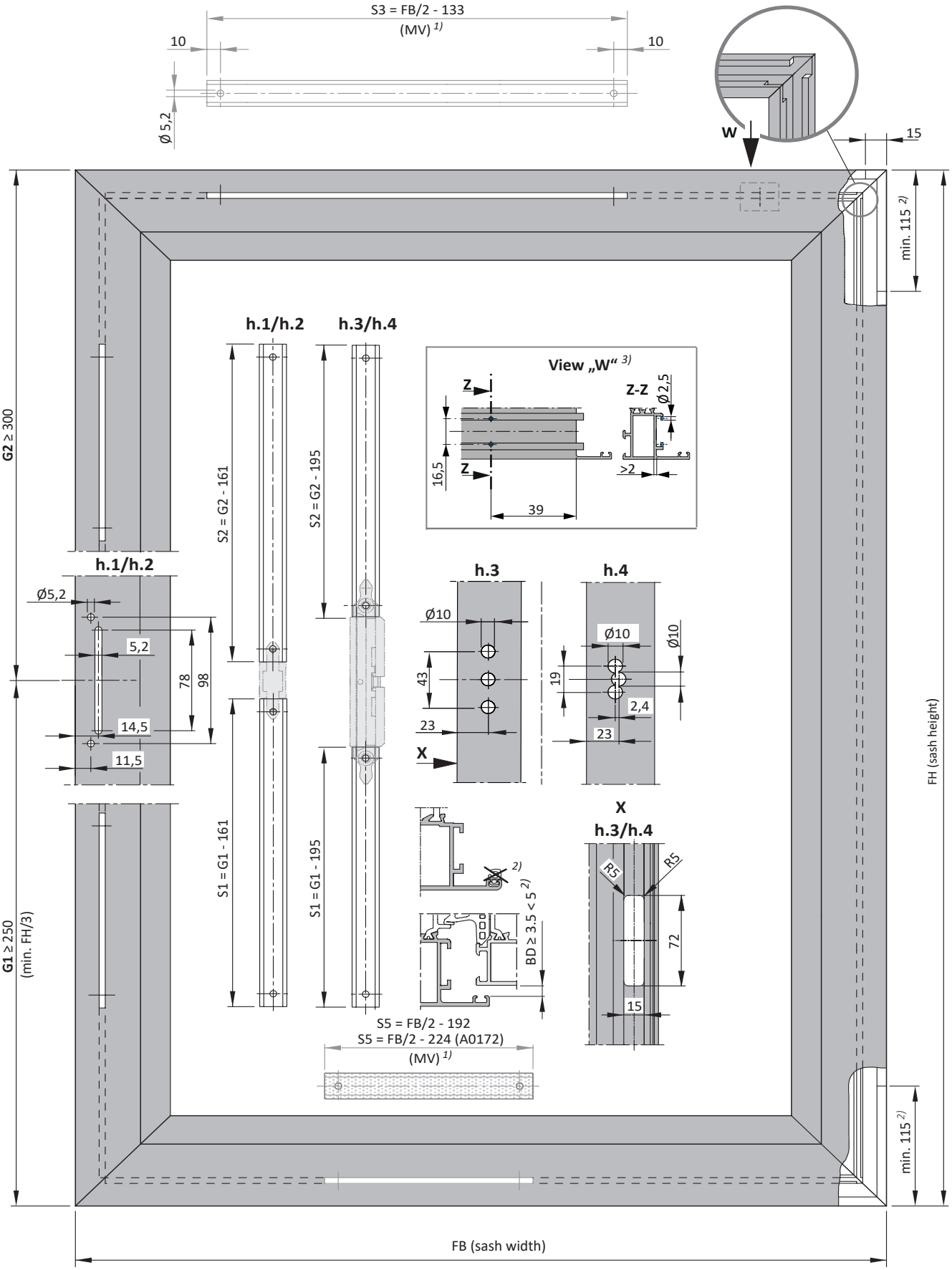


⚠ WARNING

Danger of window sash falling out due to unsecured grub screw

An unsecured hinge pin (206) slips out of the stay hinge (208) and can cause severe injuries.

- Insert hinge pin (206) into top hinge (207) from below and insert stay hinge (208) as far as the stop.
- Secure hinge pin (206) in the stay hinge (208) with grub screw (torque 2.5 Nm).



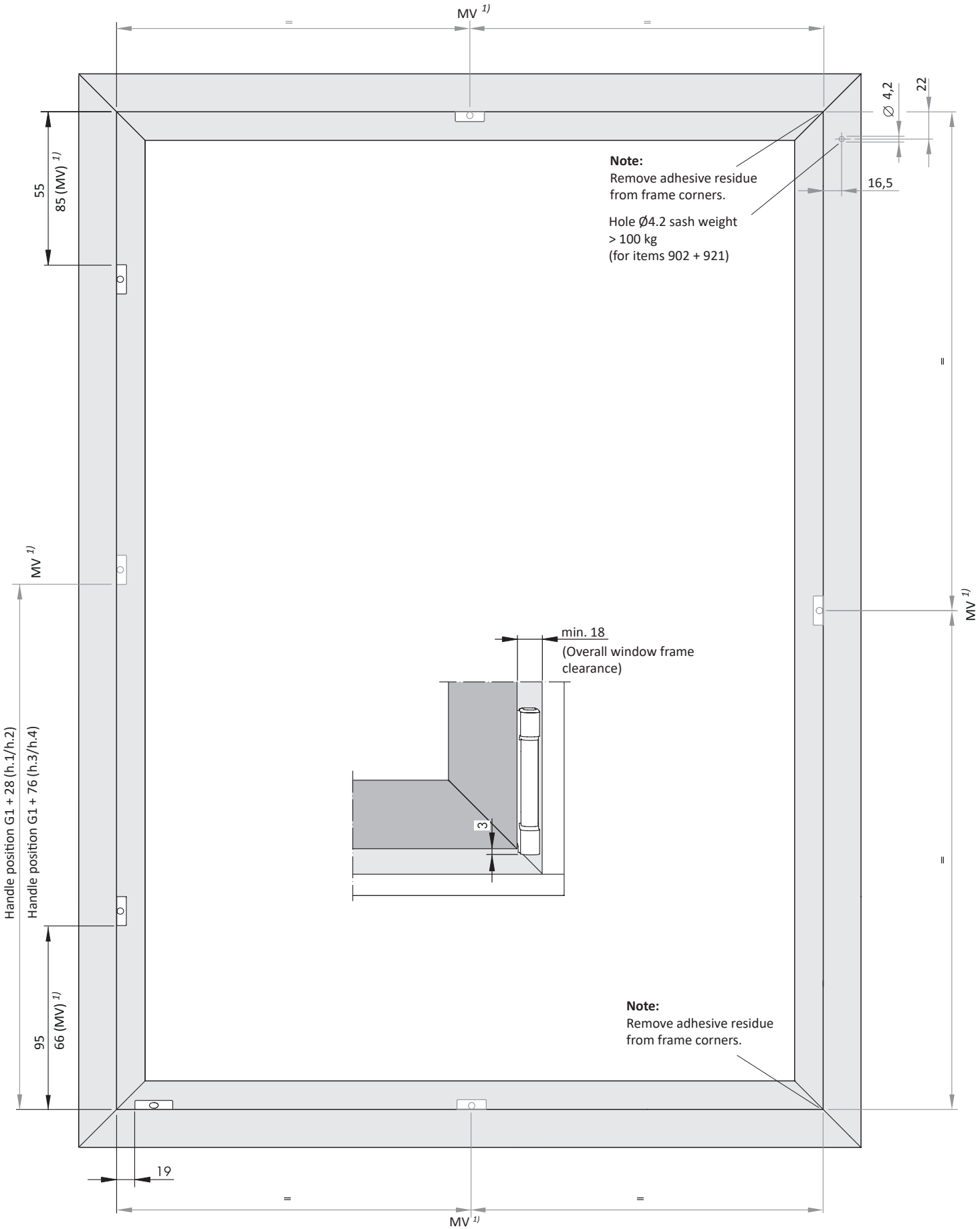
1) See page 3 and 4 for installation recommendation of centre locks and additional locks

2) Remove the rebate seal in the hinge gap area (minimum gap area 3.5 mm).

3) Only for profiling > 2 mm in groove base: predrill positioning punching screws stay ALU-D!

Frame dimensions

Single-sash square turn-only
hinge side ALU 5200 130 kg BD3.5



1) For installation of the centre locks and additional locks see page 3.