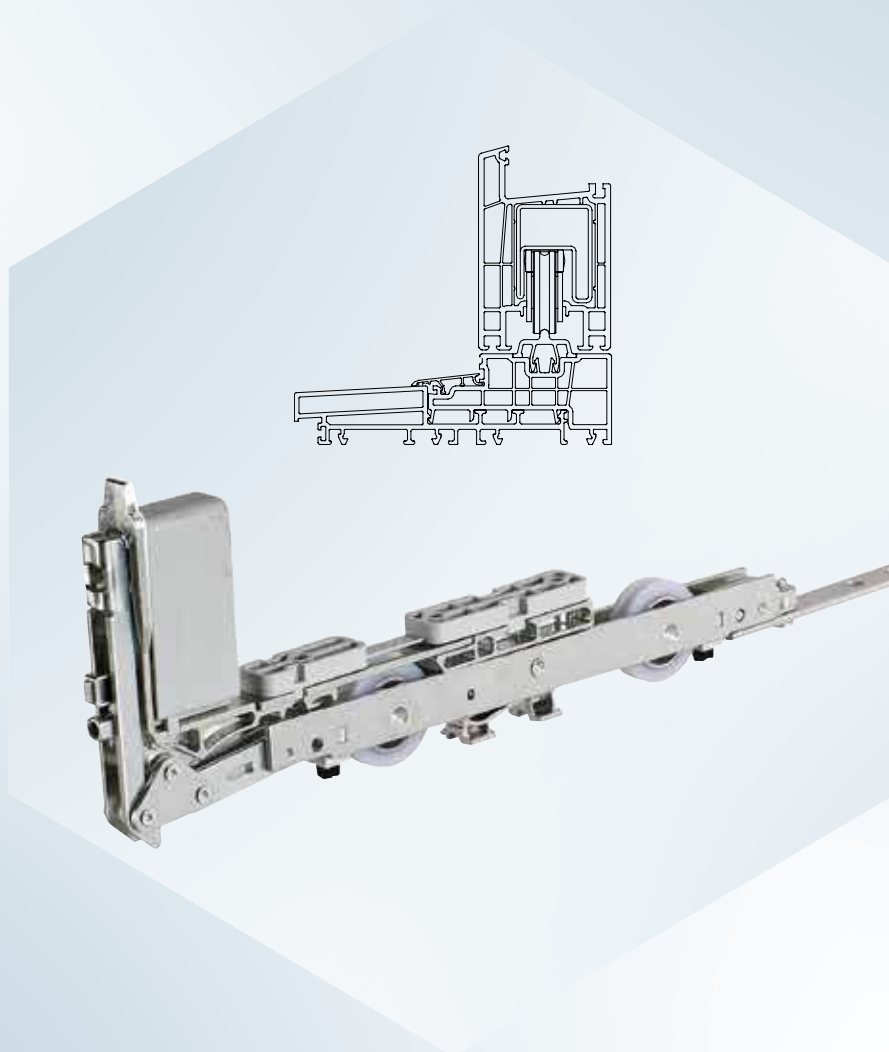


ASSEMBLY INSTRUCTIONS

L&S hardware

L&S Profine

PremiDoor 70 PVC



ONLY
FOR USE BY CERTIFIED SPECIALISTS!



Contents

Important information	3 - 4
Key	5
Design and application range	7
Hardware combination	8 - 9
Installation on sash	10 - 18
Drilling and milling on the sash	10
Drilling and milling on hook drive gear	11
Drilling and milling jig for L&S handle	12
Roller assembly	13
Underlay assembly	14
Drive gear assembly	15
Handle fitting	16
Slider assembly	17
Sash positioner L&S assembly	18
Installation on sash and frame	19 - 25
Locking bolt system A	19
Locking bolt system C	20
Striker plate for hook gear	21
Striker plate for hook gear system C, F	22
Locking block system C, F	23
Gasket bridge assembly	24
Buffer stop	25
Vertical section 70 of sliding sash	26
Horizontal section 70 system A	27
Horizontal section 70 system C	28



Important information

Target group

This documentation is intended exclusively for specialist companies and certified specialists. The work described may only be carried out by specialist personnel.

Instructions for use and safety

Assemble all hardware parts professionally as described in this manual and observe all safety instructions.

Overloading or improper operation of the lift and slide hardware may cause the sash to jump out of its guide, fall out and cause serious injury. If overloading of the lift and slide hardware is expected under special circumstances, such as in Schools, Kindergartens etc., this must be prevented using the appropriate measures,

e.g.

- Adjustment of the buffer stop to reduce the opening width, or
- Installation of a profile cylinder to prevent improper use.

Please observe the terms of our functional warranty (<https://www.maco.eu/assets/757813>) as well as the conditions of our surface warranty for MACO TRICOAT-PLUS hardware (<https://www.maco.eu/assets/757713>).

Observe the “Guidelines and Instructions on Product and Liability (GIPL)” of the Quality Association of Locks and Hardware. This policy describes all safety-related issues for end-users for window and balcony door topics. (Download available on the website of the Quality Association of Locks and Hardware).

For MACO lift and slide hardware HS, the application ranges given on page 7 must not be exceeded. In addition, PROFINE’s specifications for the lift and slide door hardware, in particular on possible restrictions on sash dimensions and sash weight, must be strictly adhered to.

Assemble the complete hardware only from MACO hardware parts and the required PROFINE accessories.

When using Accoya (registered trademark of Titan Wood Limited) and acid-treated woods (e.g. Oak, Teak, Larch), use only the TRICOAT-PLUS fittings.

Use the specified screw sizes as specified in this guide.

Turn the screws straight (unless otherwise stated) and do not over-tighten, otherwise smooth operation of the hardware may be impaired.

Fix the screws of the supporting components (e.g. rollers, running rail and guide rail) in the reinforcement profile.

Around the rollers, ensure a positive transfer of the compressive forces onto the reinforcement profile!

With the spacer-block setting, observe the technical guideline No. 3 of the glazier trade “Blocking of glazing units”.

Do not use acid-curing sealants, as these can lead to corrosion of the hardware parts.



Keep the runner of the roller track, the threshold and all folds free of deposits and dirt, and in particular of cement or plaster residues. Avoid direct moisture on the hardware and contact of the hardware with acidic cleaning agents.

Attach the operating label in a clearly visible manner to the built-in lift and slide sash. The operating label can be found in the base carton.

Do not make any constructive changes to the hardware parts.

If you are not sure, please ask your MACO contact person for advice.

Certification

The MACO hardware mentioned in the assembly instructions are tested and regularly monitored in standardised tests in accordance with EN 13126. The achieved standards Class H3 does not refer to the individual element system. Due to a wide range of influencing factors, individual element systems may experience minor deviations from standardised testing, such as:

- the influence of processing tolerances
- the effect of assembly tolerances after the installation of the element in the building
- the use of accessories (e.g. weather seals, sealing rails, handles, etc.)
- the use of additional equipment (e.g. sliding damper, swing-check damper, operating force reduction, etc.) and/or attachments (e.g. Aluminium shells, sun protection on the sash, insect protection)
- External environmental influences (e.g. humidity, sunlight, high or low temperatures, temperature fluctuations, etc.) or
- room-side influences (moisture, aggressive cleaning agents, etc.)

Key



HS Lift&slide unit



FH Sash height



FB Sash width



RAB Frame outer width



RAH Frame outer height



L Total length



GM Handle height



DM Backset drive gear



O Optional

{ } Dimensions for flat roller track

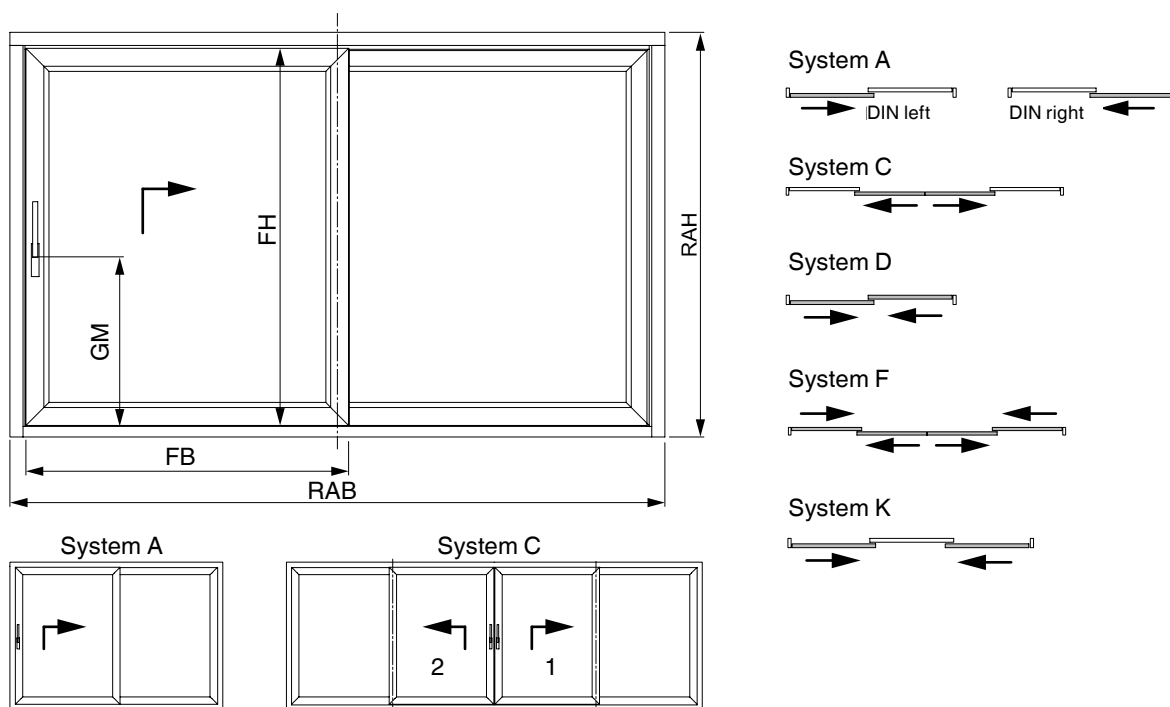
Dimensions in [mm]: All dimensions without units are specified in [mm]



Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes.

Design and application range



Application range

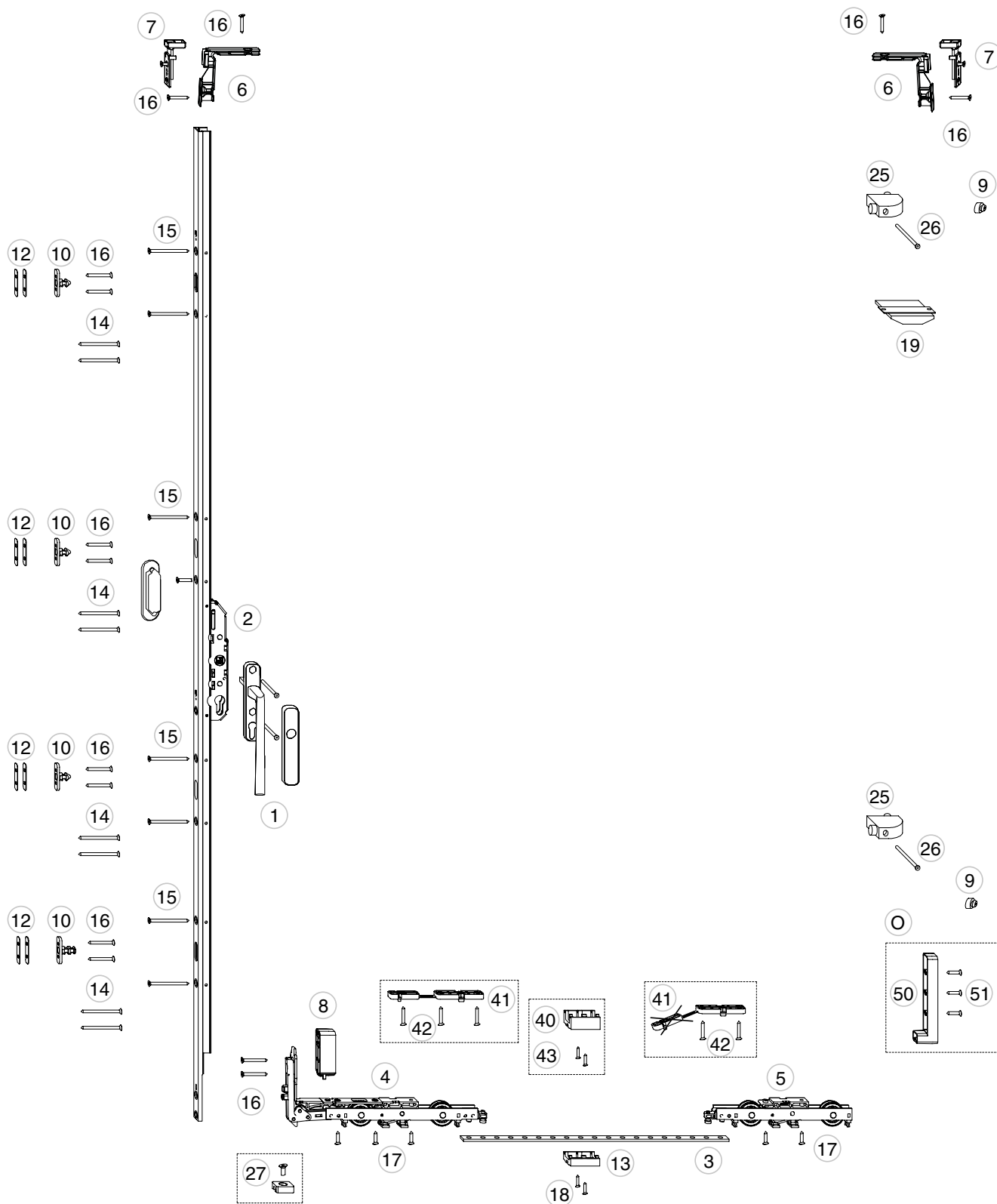
The application ranges stated in the table apply for MACO L&S 300.

The maximum application ranges and weights specified by the profile manufacturer apply when processing the profiles and must be observed.

Designation	Unit	Department	
		Tall roller track	Flat roller track
FB	(mm)	700 - 3280	
FH	(mm)	815 - 2920	807 - 2912
Weight of sliding sash	(kg)	max. 400	
DM	(mm)	37,5	
GM drive gear size 1 - 2	(mm)	408	400
GM drive gear size 3 - 4	(mm)	1008	1000

*From a sash weight of over 200kg, we recommend installing a drive damper.
(The drive damper can be ordered via the Technical Online Catalogue (TOM) or via the Catalogue.)

Hardware combination



Hardware combination

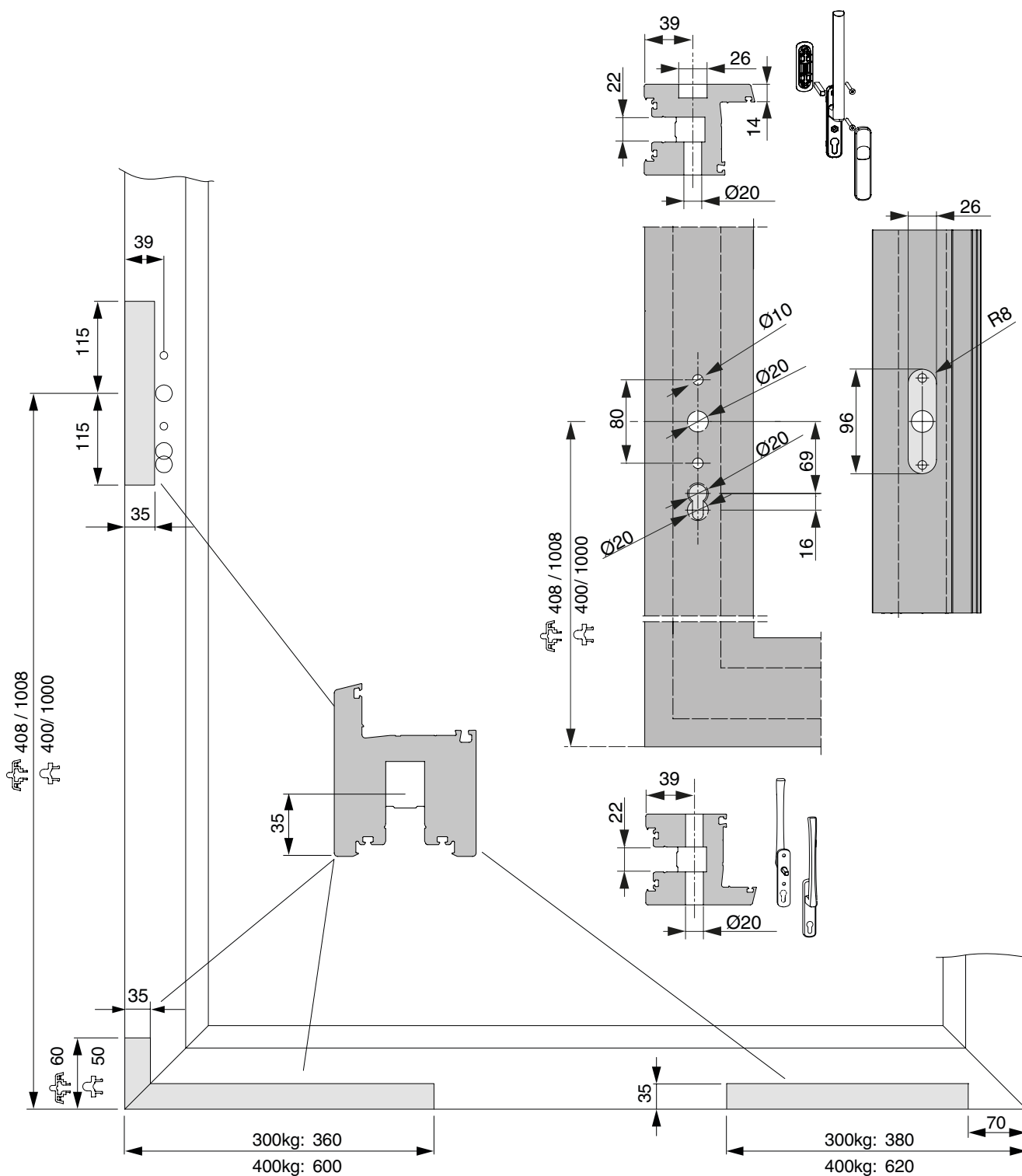
Pos.	Item designation
1	L&S handle set
2	Lift drive gear lock case DM 37.5 PZ
3	Perforated connecting rod L&S 16.4 x 4
4	300 kg front L&S roller with brushes, silver
5	300 kg back L&S roller with brushes, silver
6	Basic profile for slider, 10 x 22 mm spacing, silver
7	L&S KU 16.4mm slider shoe with cover
8	Underlays for L&S KU 26.5 mm high roller silver drive gear side
9	Rubber stopper L&S, silver
10	Tilt lock
12	Underlay for L&S KU lock. bolt thickness = 0.5 + 1mm, silver
13	Rod guide for roller track, silver
14	Countersunk self-tapping screw B 4.8 x 80
15	Countersunk self-tapping screw B 4.8 x 65
16	Countersunk self-tapping screw B 4.8 x 45
17	Countersunk self-tapping screw B 4.8 x 22
18	Countersunk self-tapping screw 3.5 x 32
19	Sealing bridge
25	Buffer stop pack 28mm gap
26	Countersunk self-tapping screw B 4.8 x 80
27	L&S locking block 300/400 kg

OPTIONAL

Pos.	Item designation
40	Stangenführung Laufschiene flach
41	L&S roller underlay, 8 mm, stackable in silver
42	Countersunk self-tapping screw B 4.8 x 32
43	Chip board screw 3.5 x 35
50	Sash positioner L&S PVC, silver
51	Countersunk self-tapping screws B 4.8 x 22

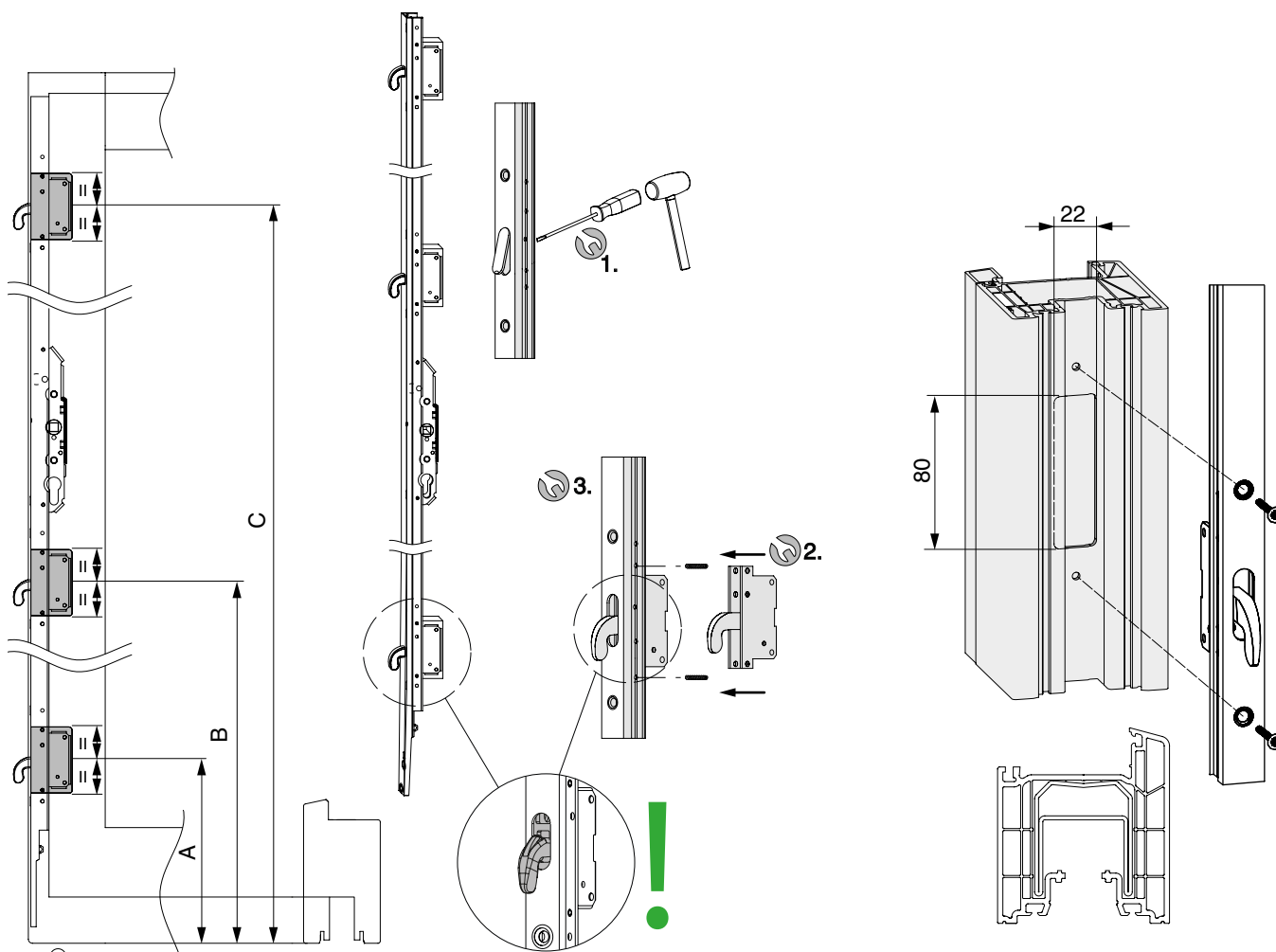
Installation on sash

Drilling and milling on the sash



Installation on sash

Drilling and milling on hook drive gear

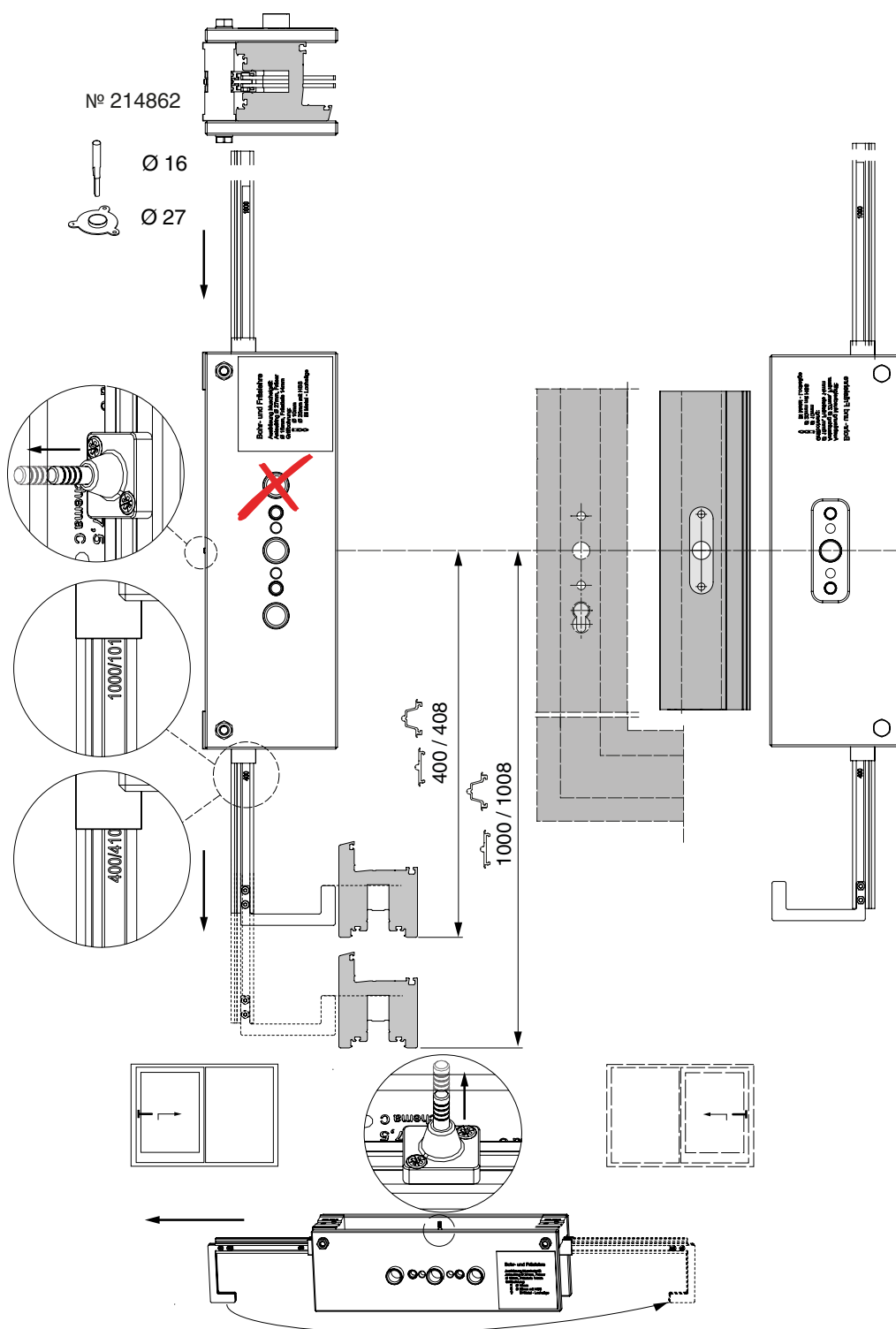


	A	B	C
Gr. 1	219	589	-
Gr. 2-3	219	1089	-
Gr. 4	219	807	1687
Gr. 5	219	1219	2119

	A	B	C
Gr. 1	211	581	-
Gr. 2-3	211	1081	-
Gr. 4	211	799	1679
Gr. 5	211	1211	2111

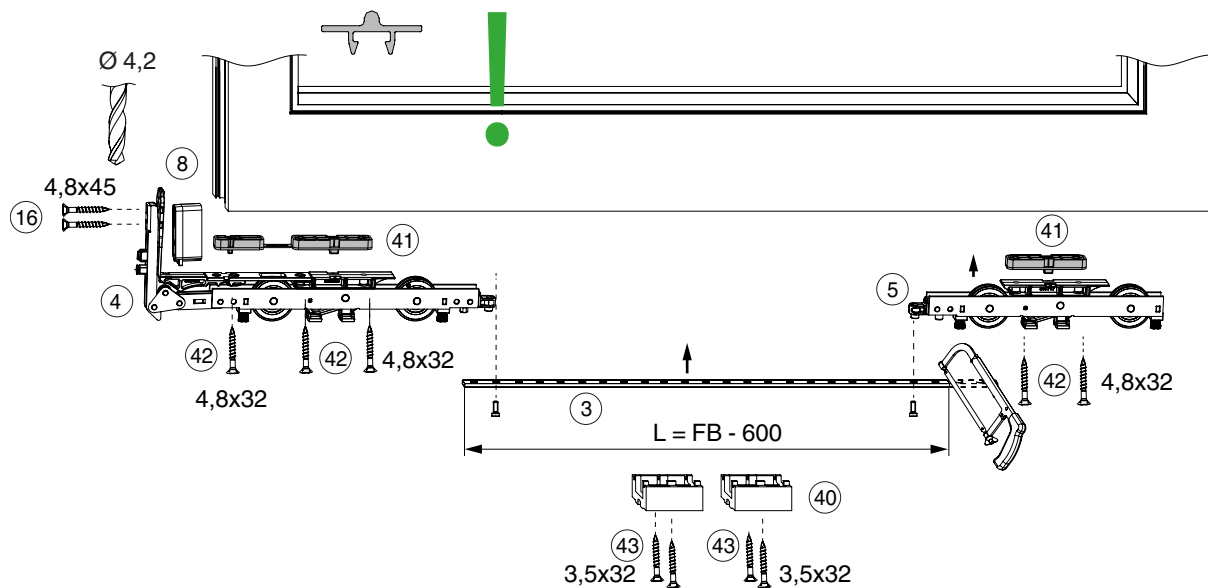
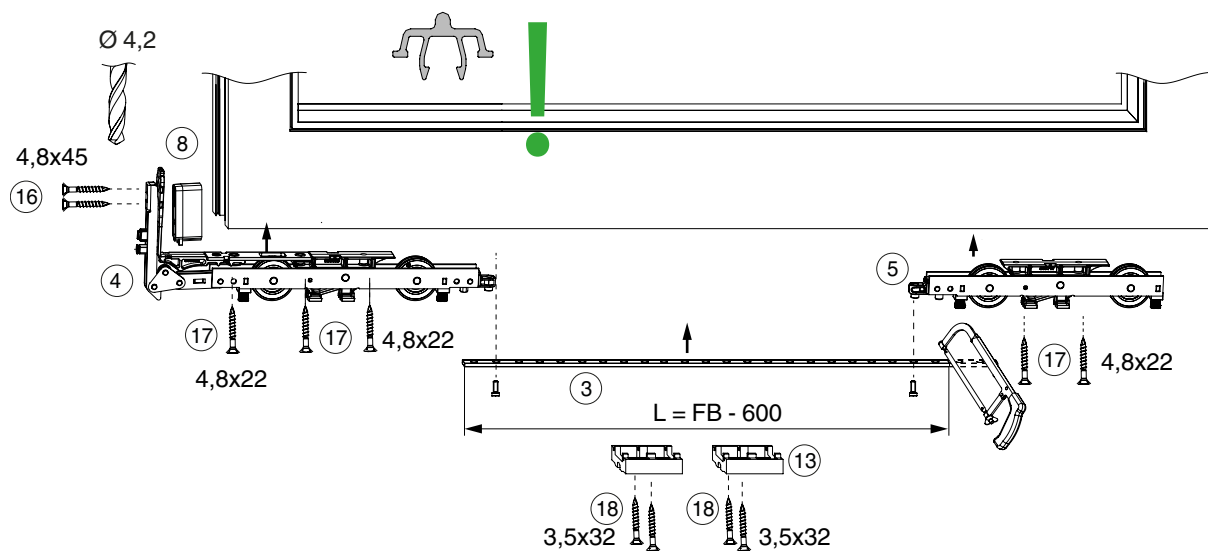
Installation on sash

Drilling and milling jig for L&S handle



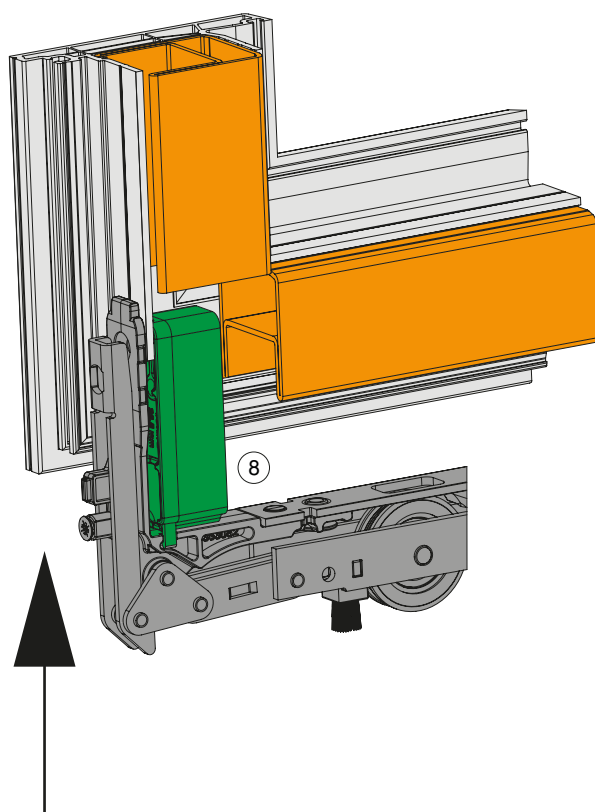
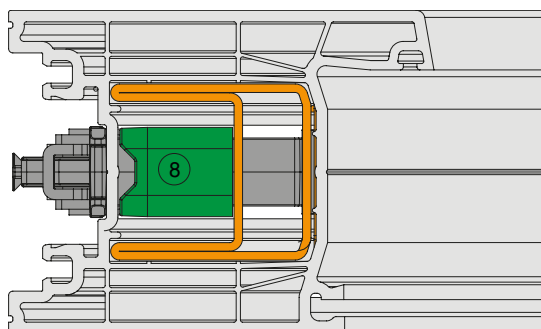
Installation on sash

Roller assembly



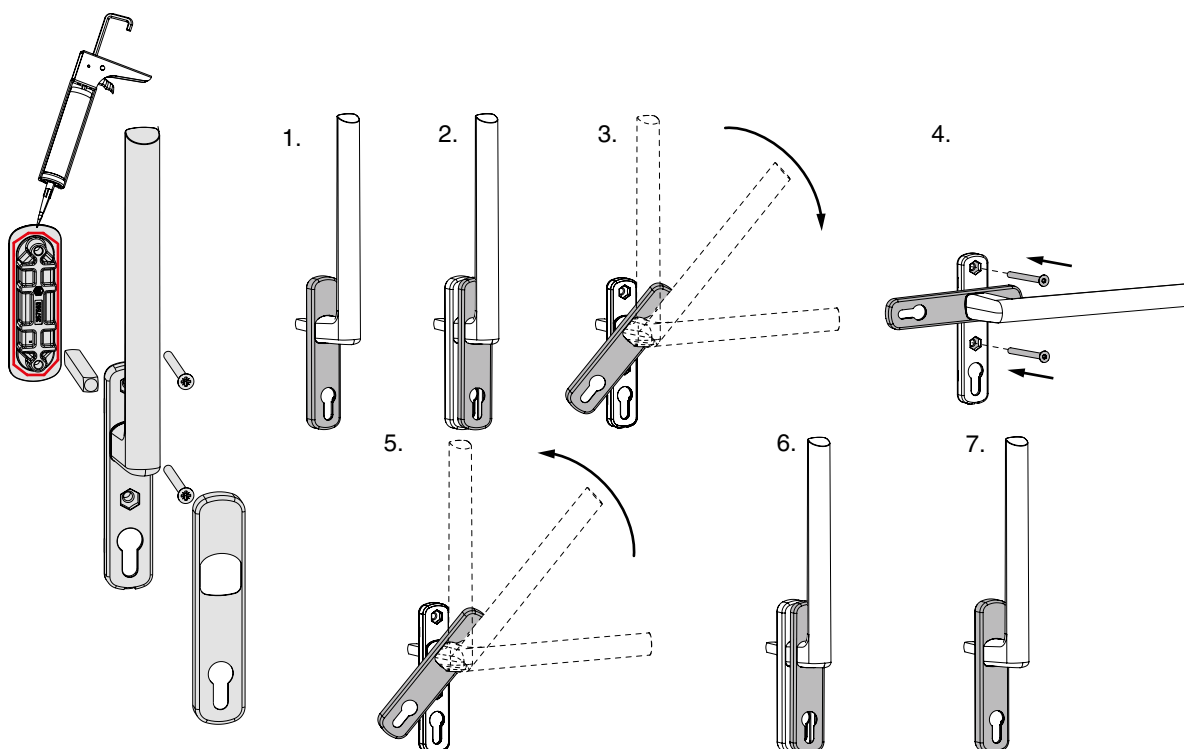
Installation on sash

Underlay assembly



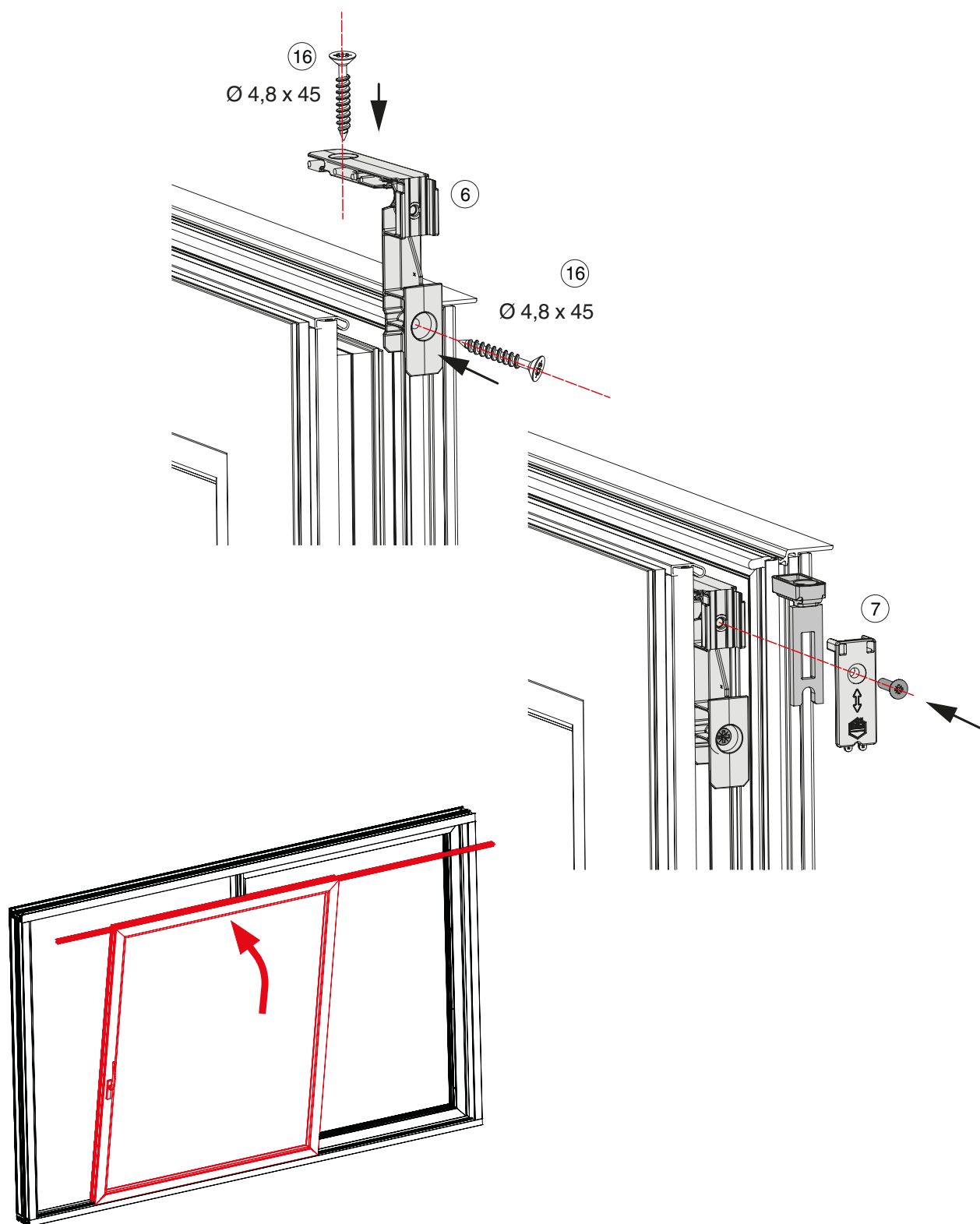
Installation on sash

Handle fitting



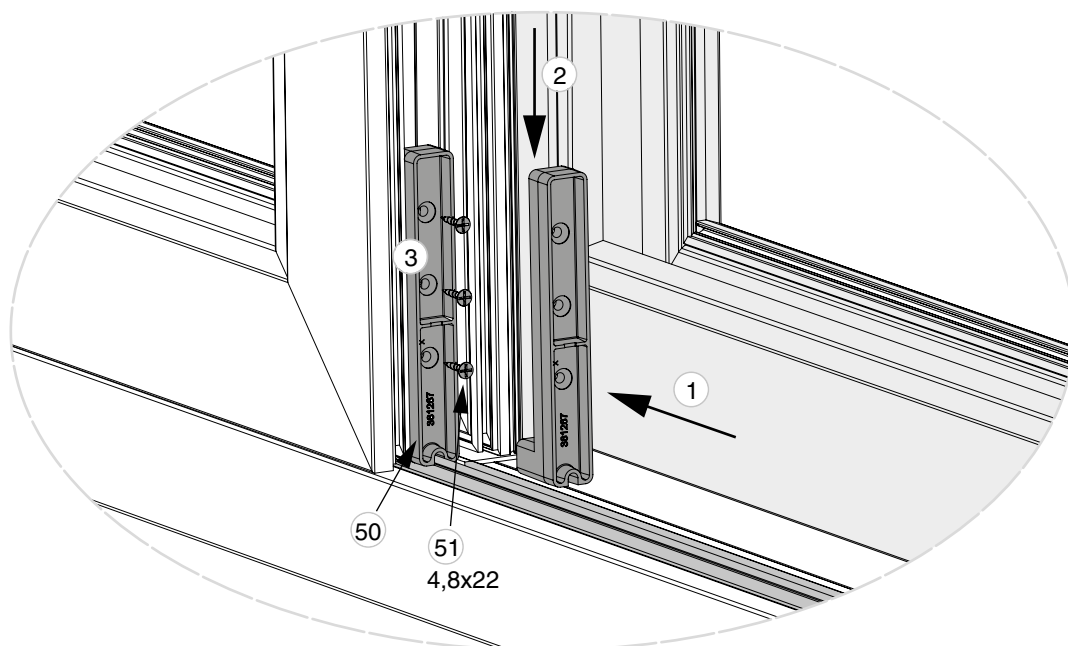
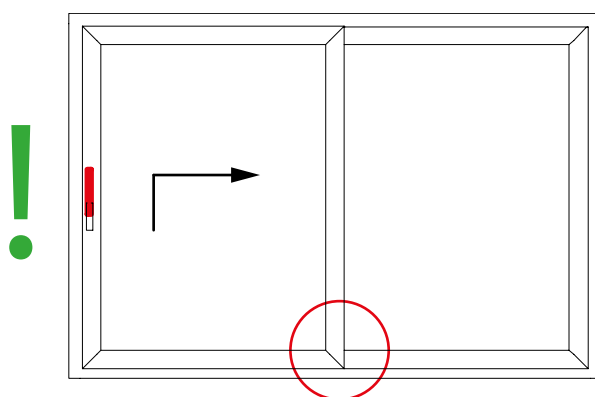
Installation on sash

Slider assembly



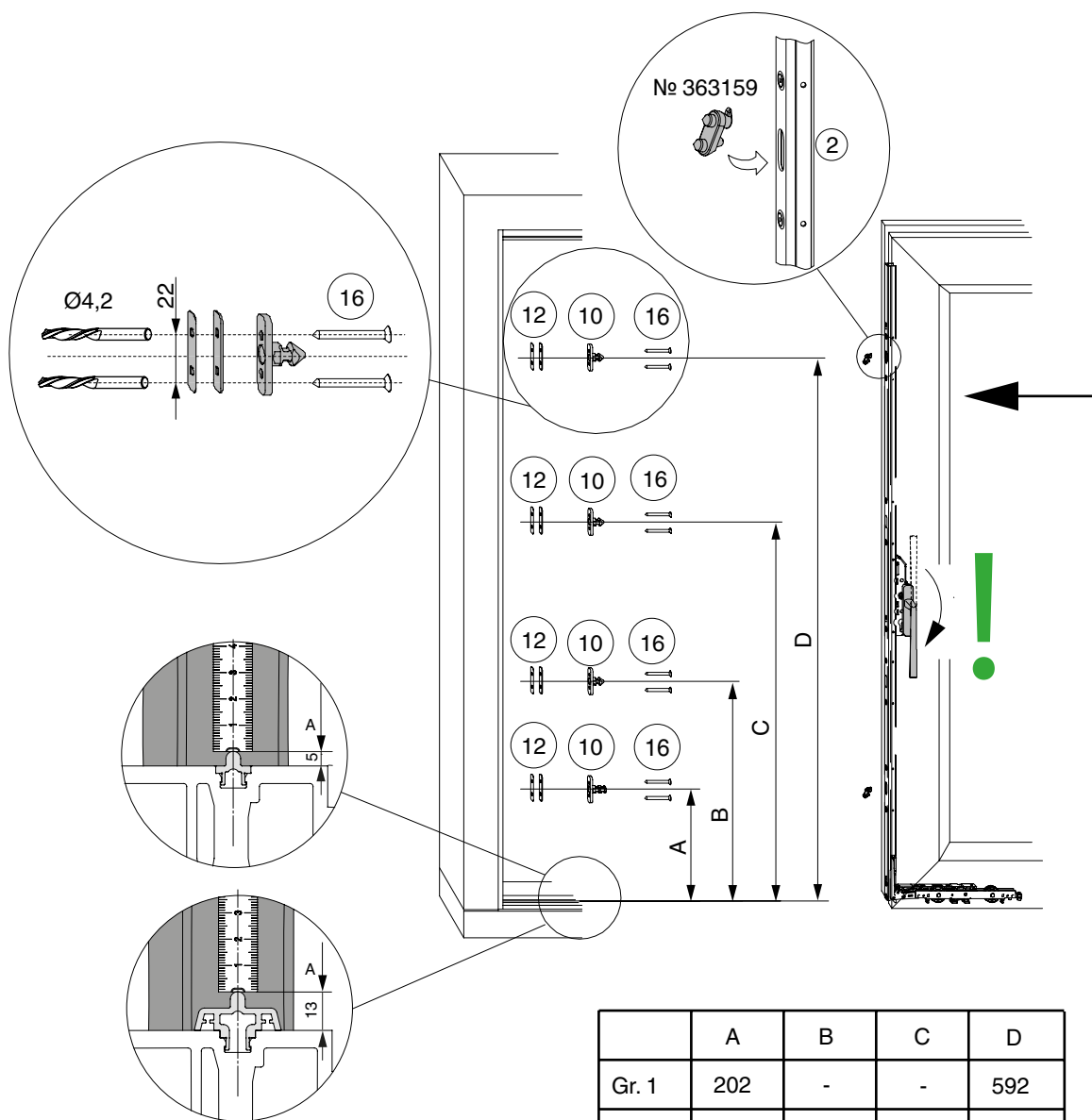
Installation on sash

Sash positioner L&S assembly



Installation on sash and frame

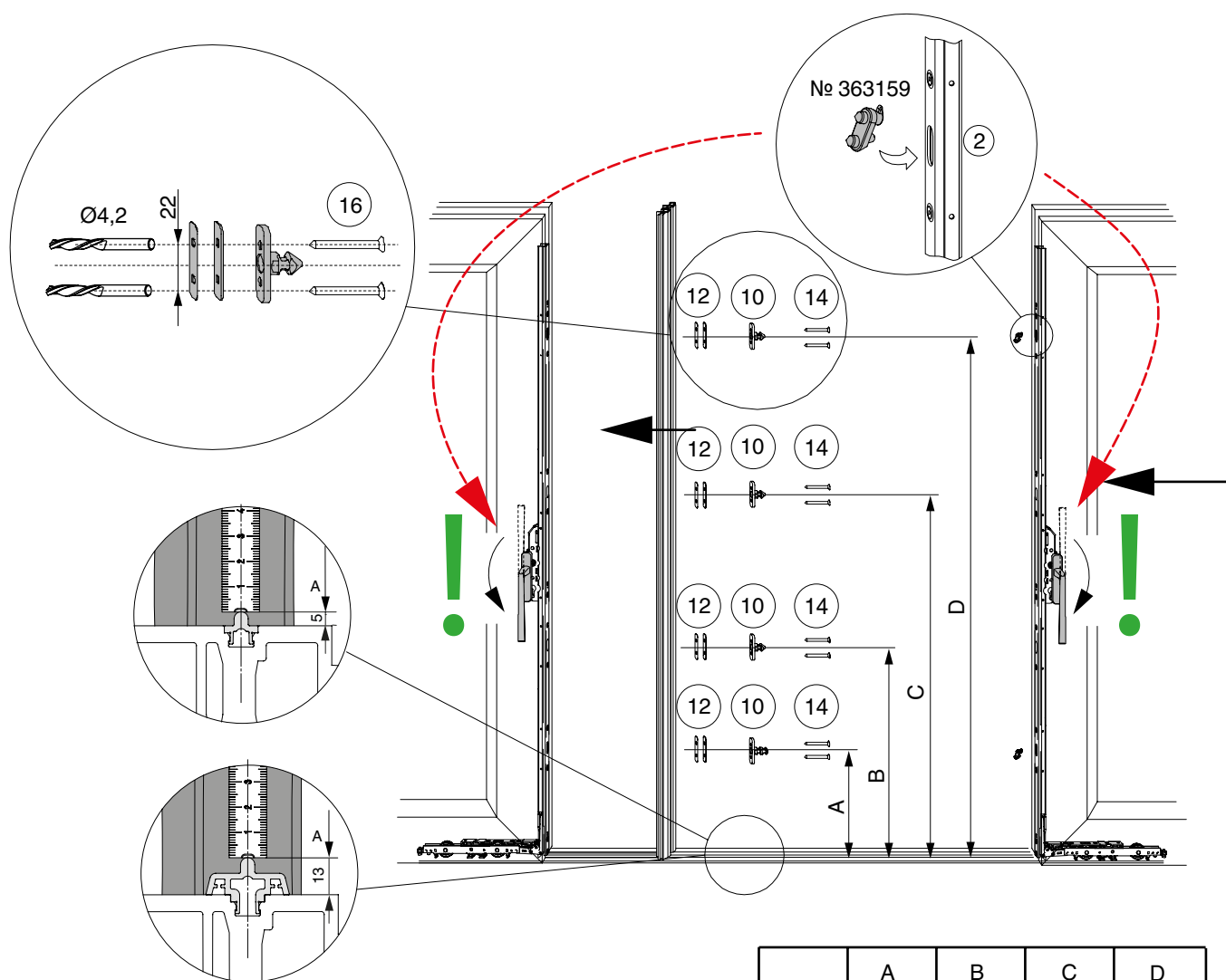
Locking bolt system A



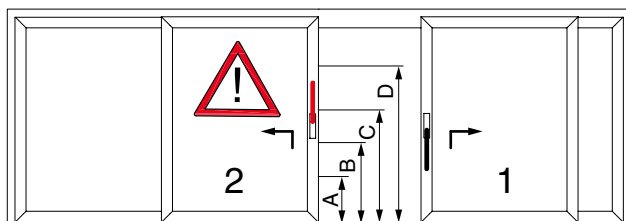
	A	B	C	D
Gr. 1	202	-	-	592
Gr. 2	202	-	592	1107
Gr. 3	202	702	1192	1507
Gr. 3,5	202	702	1192	1707
Gr. 4	202	702	1192	1907
Gr. 5	202	702	1192	2307

Installation on sash and frame

Locking bolt system C



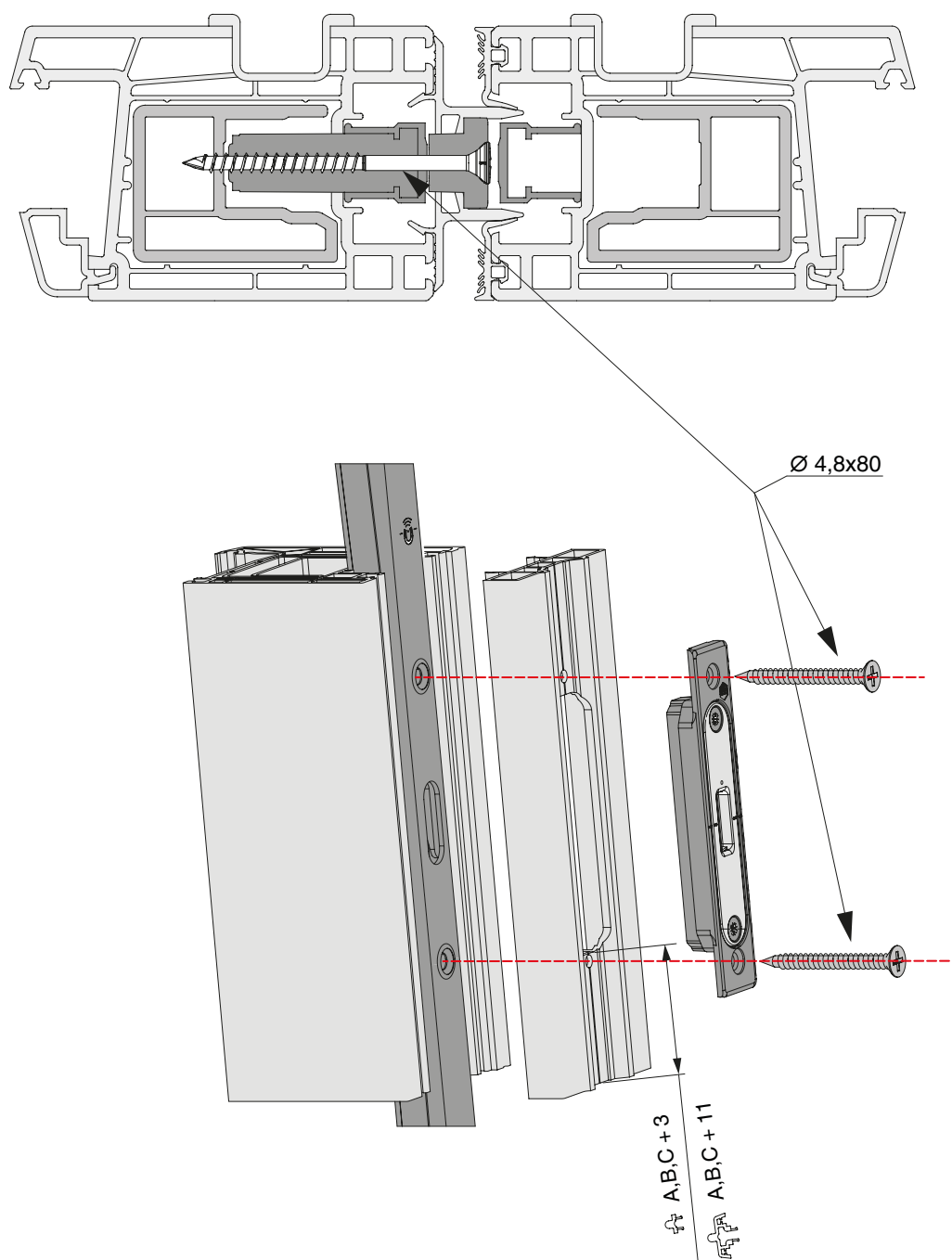
System C



	A	B	C	D
Gr. 1	202	-	-	592
Gr. 2	202	-	592	1107
Gr. 3	202	702	1192	1507
Gr. 3,5	202	702	1192	1707
Gr. 4	202	702	1192	1907
Gr. 5	202	702	1192	2307

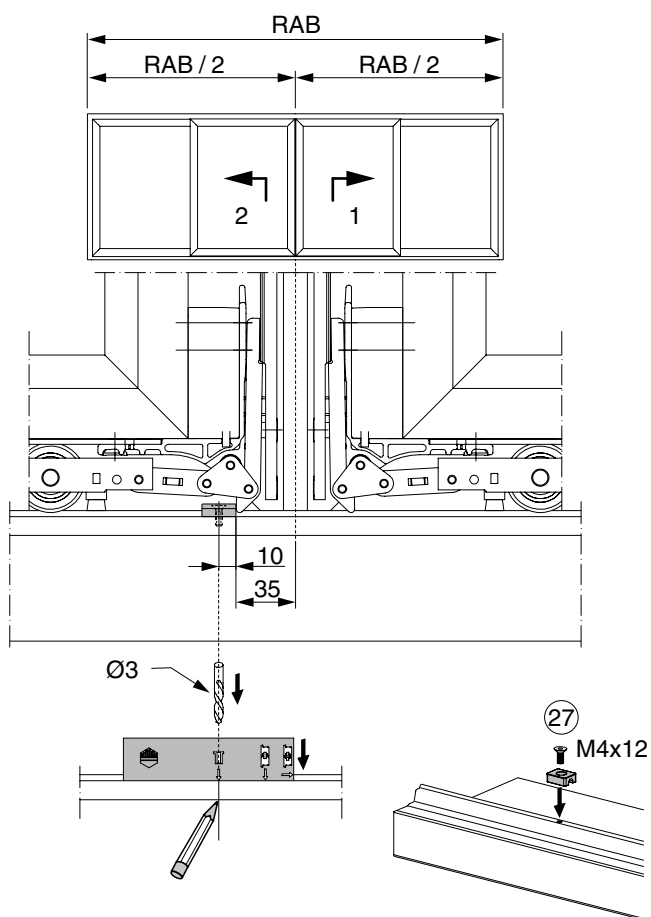
Installation on sash and frame

Striker plate for hook gear system C, F



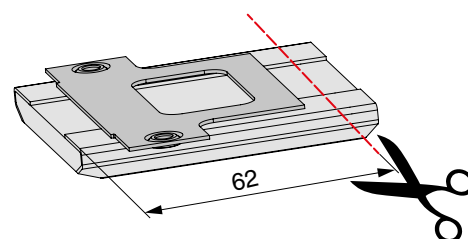
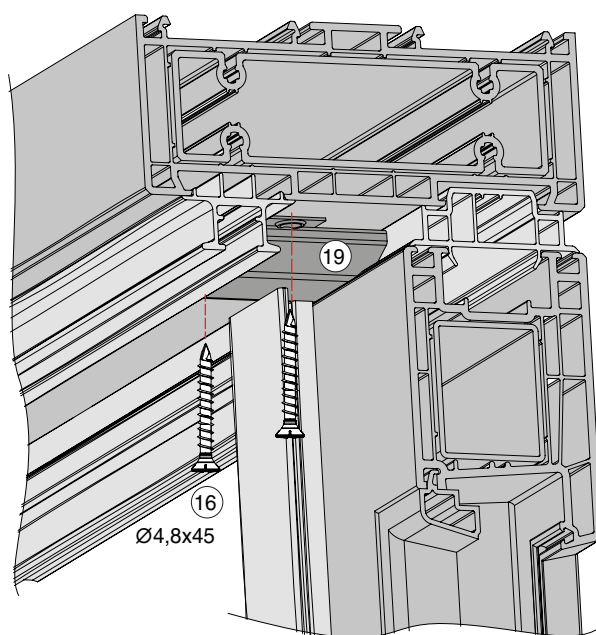
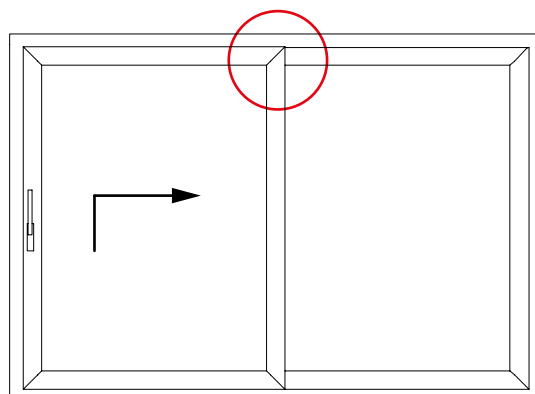
Installation on sash and frame

Locking block system C, F



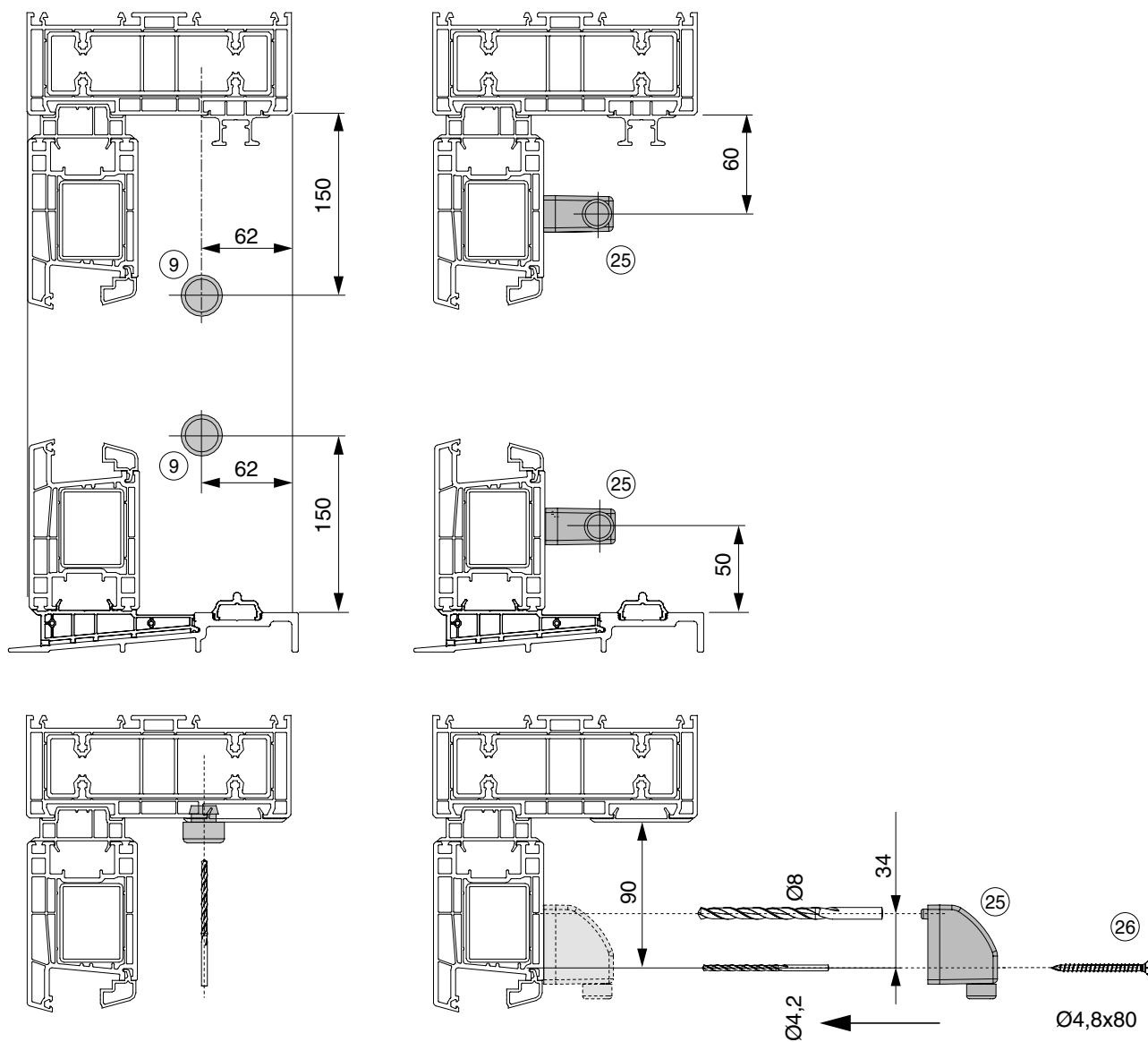
Installation on sash and frame

Gasket bridge assembly

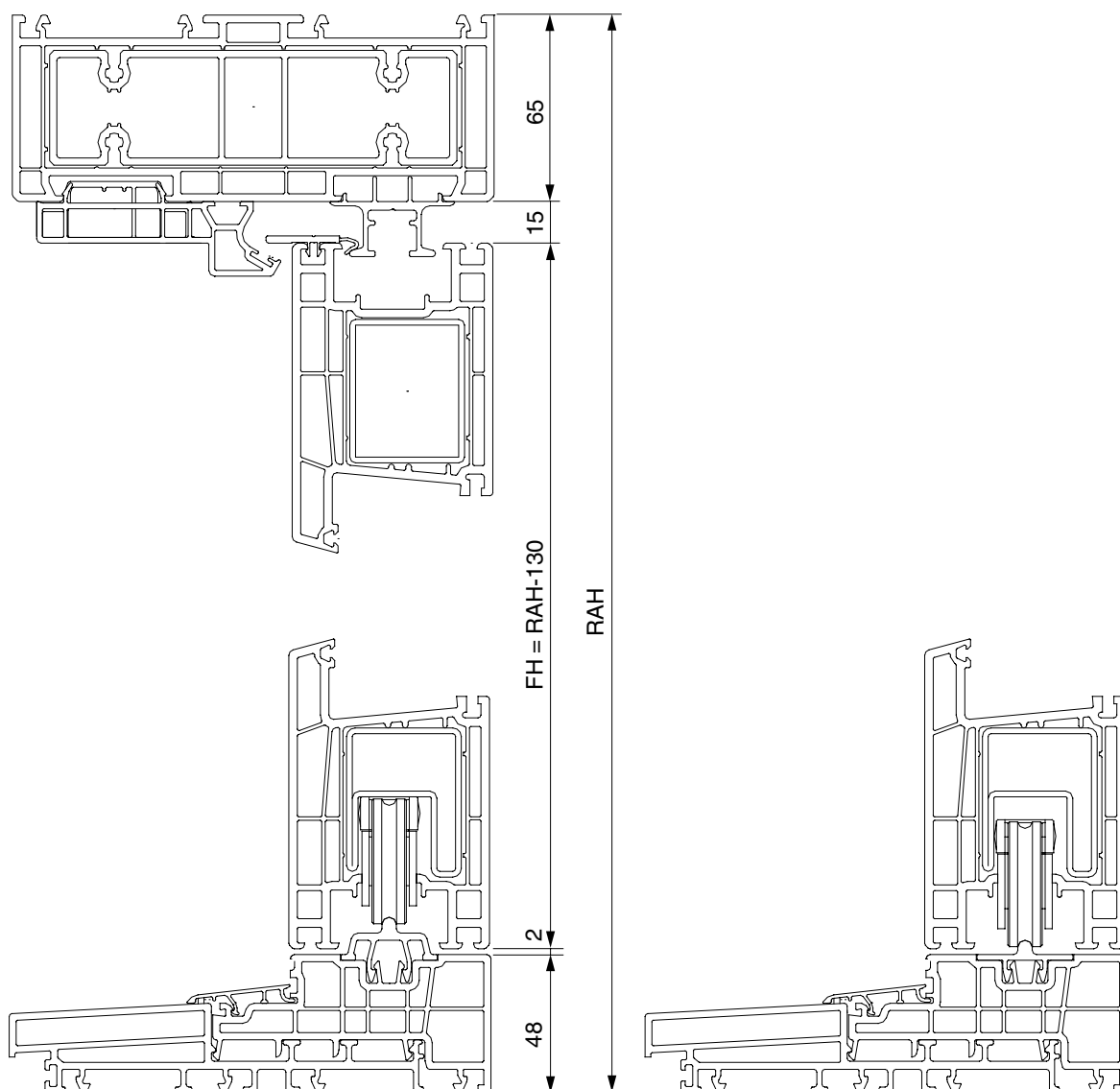


Installation on sash and frame

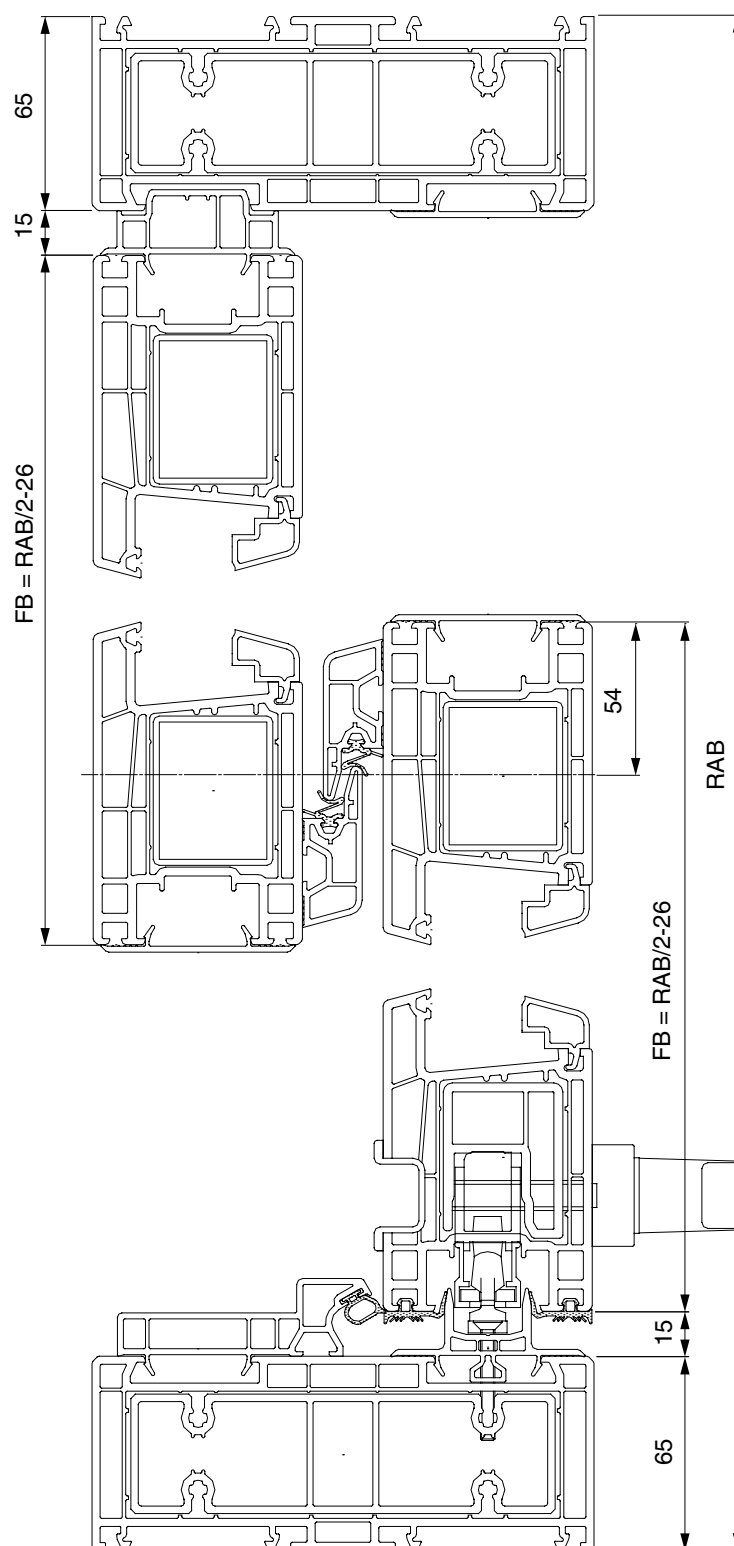
Buffer stops



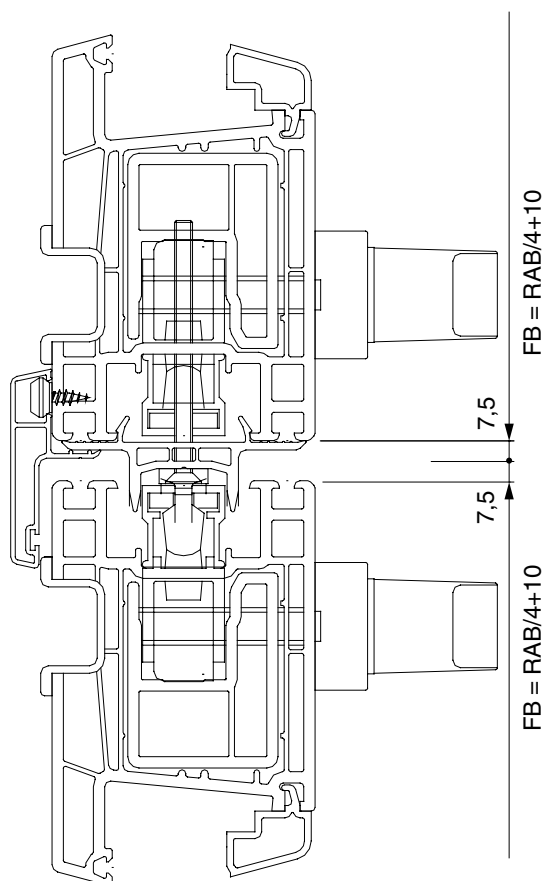
Vertical section 70 of sliding sash



Horizontal section 70 system A



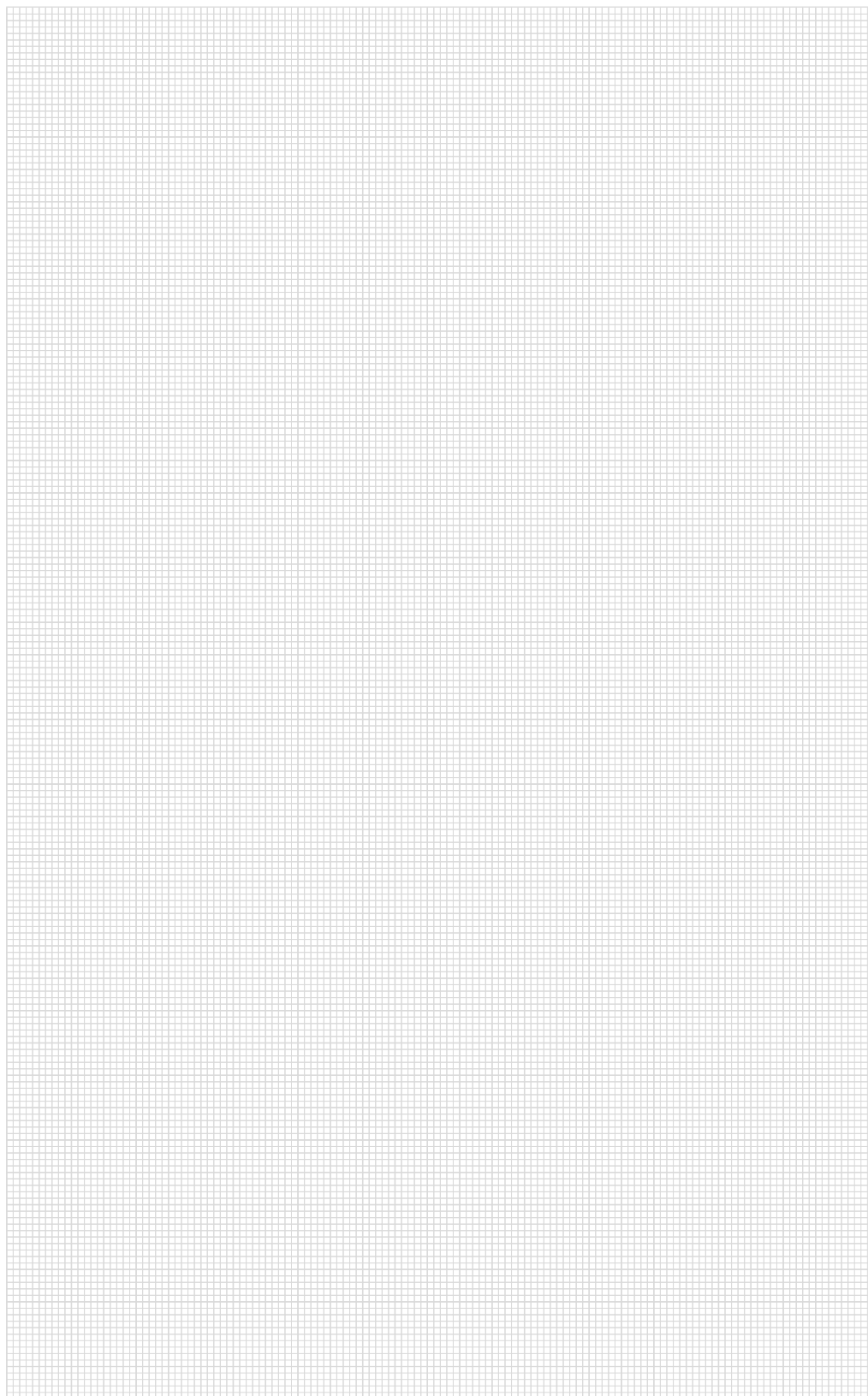
Horizontal section 70 system C

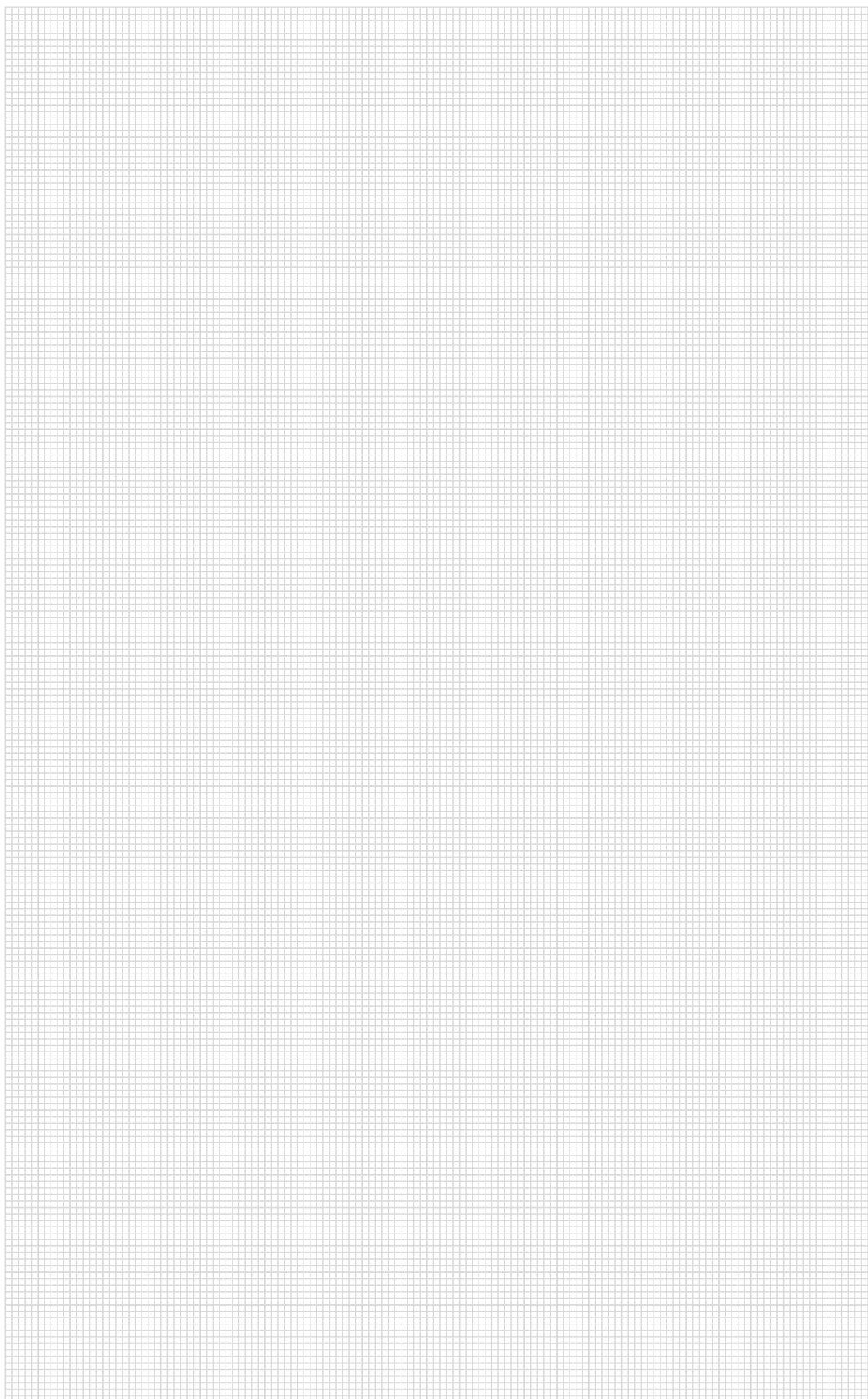




Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes.





**MACO
RAIL-SYSTEMS**



**MAYER & CO
BESCHLÄGE GMBH**

Alpenstraße 173
A-5020 Salzburg

Tel.: +43 662 6196-0
E-Mail: maco@maco.eu
www.maco.eu

Created: 07/2010 - Changed: 06.03.2020
Order no. 756724EN
All rights reserved and subject to change.

This print document is revised regularly.
The latest version is available at
<https://www.maco.eu/assets/756724en>
or scan the QR code.

