

# INSTRUCTIONS FOR ASSEMBLAGE AND MARK CE

## Preliminary statement

The following instructions are necessary for the application of the CE label on the ready-made rolling shutter. Shouldn't these rules be respected, the opportunity of marking CE Croci rolling shutters will be consequently lost. N.B. Mark CE only refers to the ready-made rolling shutter with Croci guide rails complete of all original Croci accessories; on the other hand, the mark doesn't include all the accessories to be installed, which the installer have to supply. It is necessary to specify every time the size of the rolling shutter and the belonging class requested by the rule according to the widths and to the type of guide rails used (*see the schedule in the declaration of conformity for Croci rolling shutter profiles*).

## ASSEMBLAGE OF THE ROLLING SHUTTER

- 1) edge the profiles (about 1 cm.) to remove eventual production defects;
- 2) establish the finished sizes of the rolling shutter and the cut to measure of the profiles.

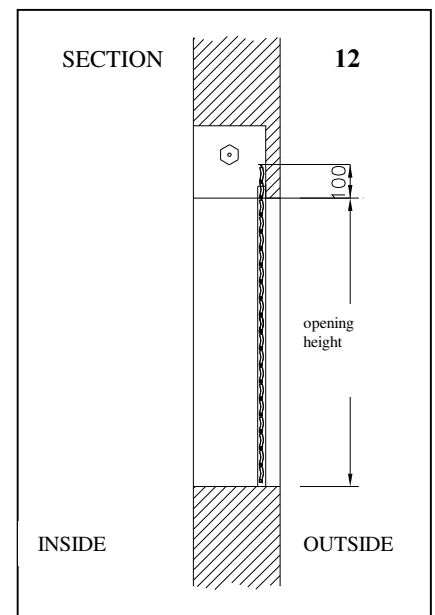
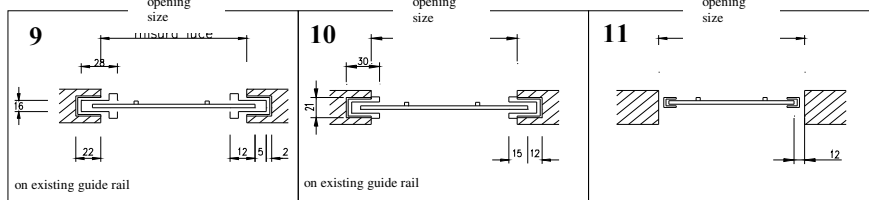
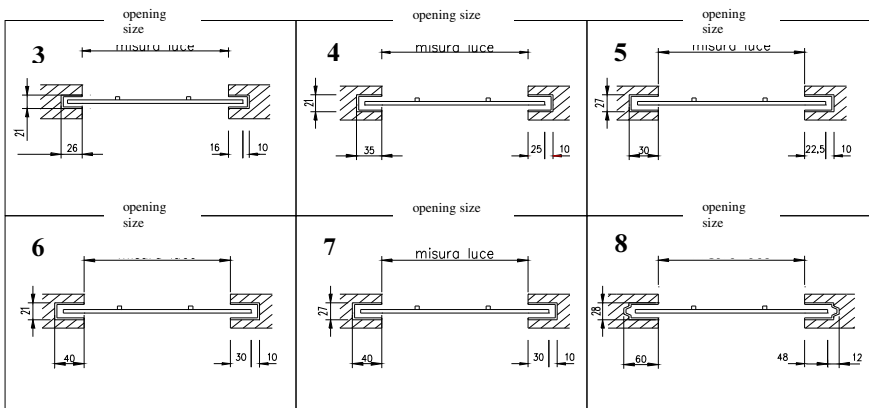
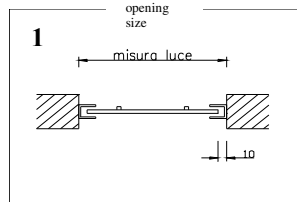
## TRADITIONAL SYSTEM

### rolling shutter width (side plugs included if assembled)

GUIDE RAILS POSITION	GUIDE RAIL type	ROLLING SHUTTER WIDTH	PICTURE
External guide rails in opening size	Any types	Opening width -20mm.	1
Embedded guide rails	GE26x21	Opening width + 32mm.	3
	GE35x21	Opening width + 50mm.	4
	GE30x27	Opening width + 45mm.	5
	GE40x21	Opening width + 60mm.	6
	GE40x27	Opening width + 60mm.	7
	GE60x28	Opening width + 96mm.	8

### rolling shutter height

GUIDE RAILS POSITION	GUIDE RAIL type	ROLLING SHUTTER HEIGHT	PICTURE
in or out of opening size	Any types	Opening height +100mm.	12

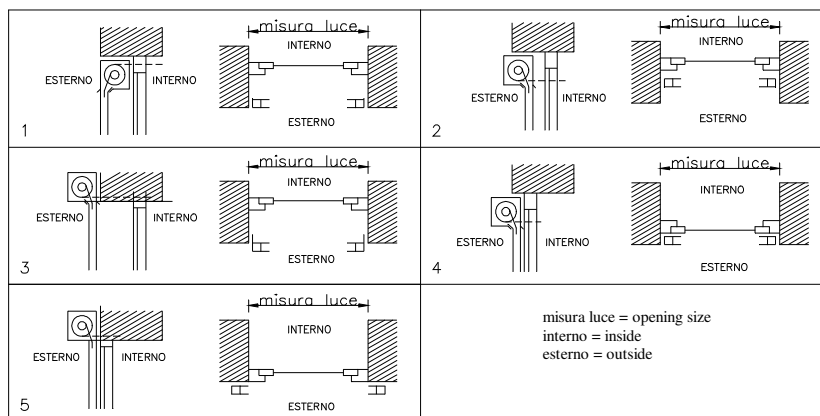


TER WIDTH	PICTURE
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Guide rails / shutter box in opening size (applications 1,2,3,4)	GE53x21, GE62x21 GE62x28 GE80x28	Opening width - 66mm	1,2,4
	GE53x21A GE62x21A		3
	GE458028(for maxi) GE458028A(for maxi)	Opening width - 84mm. Opening width - 84mm.	3
Guide rails / shutter box wall mount (application 5)	GE53x21 GE62x21 GE62x28 GE80x28 GE458028(for maxi) GE458028A(for maxi)	Opening width + 45mm. Opening width + 60mm. Opening width + 60mm Opening width + 94mm. Opening width + 76mm Opening width + 76mm	5

### **Rolling shutter height**

guide rails height + ½ shutter-box

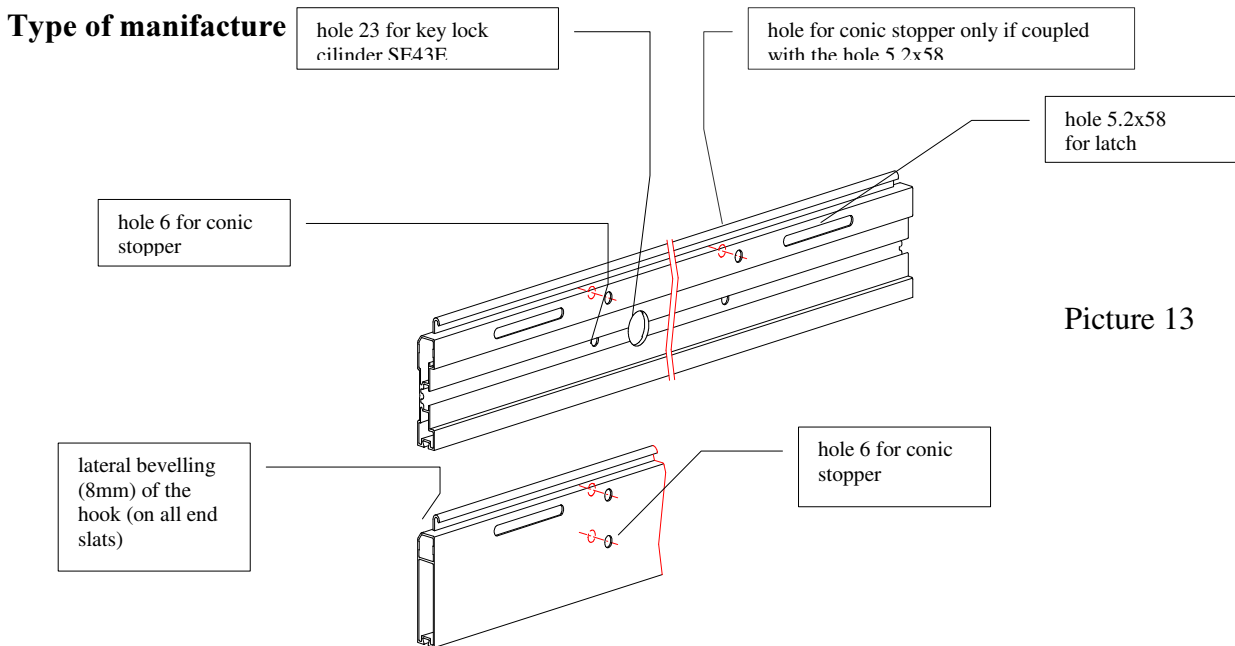


For the assemblage of the rolling shutter, it is necessary to use the accessories indicated in the schedule below, deducting from the finished width the opportune sizes:

PROFILE	SIDE PLUGS	<b><u>TOTAL SIZE TO BE DEDUCTED FROM THE LENGTH OF THE END SLAT = FINISHED WIDTH OF THE ROLLING SHUTTER</u></b>
AR/8	TLAR/8 + 2 staples PM703	-8mm.
AR/20	TLAR/20 + 2 staples PM705	-8mm.
AR/7	TLAR/7 + 2 staples PM704	-8mm.
AR/17	TLAR/17 + staples PM705	-8mm.
AR/16	TLAR/16 + 2 staples PM703	-8mm.
AR/32	TLAR/32 + staples PM704	-10mm.
AR/12	TLAR/12 + 2 staples PM703	-10mm.
SAR/120	-- without side plugs	0 (=shutter size)
SAR/117	TLSAR/117C (flat)	-10mm.
	steel nails	0 (=shutter size)
SAR/112	TLSAR/112C (with screws seat)	-13mm.
	TLSAR/112PC (flat)	-13mm.
	steel nails	0 (=shutter size)
SAR/132	TLSAR/132C (with screws seat)	-10mm
	TLSAR/132PC (flat)	-10mm.
	steel nails	0(=shutter size)
SAR/133	TLSAR/132C (with screws seat)	-10mm.
	TLSAR/132PC (flat)	-10mm.
AR/23	TLAR7+ 2 staples PM704	-8mm.
AR/33	TLAR32+ 3 staples PM704	-10mm.
SAR/115	TLSAR/115C (with insert)	-13mm.
ES/44	TLES/44 only inserted	-10mm.
ES/55	TLES/55 only inserted	-10mm.

3) Lay the cut slats on the bench with the concave side upwards excluding the end slat and the last upper slat. Employ the unpunched profiles in the upper part (about 1/3) and the punched ones in the lower part (about 2/3).

4) Work on the end slat (holes for conic stoppers, lateral bevelling, crushing of the pvc gasket on the extremities, eventual punches for latches, assemblage of latches or locks in the sliding seat. (Picture 13)



Picture 13

**LIST OF THE WORKINGS TO BE MADE ON END SLATS**

**Hole Ø5.2X58 for steel latch + hole Ø6 for conic stopper (cannot be used together)**

- n. 2 holes and n. 2 holes for each end slat
- the hole Ø6 has to be 15cm distant from the end slat extremity
- the centre of the hole Ø5.2X58 has to be 8cm distant from the end slat extremity
- for 13mm and 14mm end slats (TE14X56, TE14X56I, TE14X56U, TS12X55)

**Hole Ø6 for conic stopper**

- the hole has to be 15cm distant from the end slat extremity on all end slat types.

**Hole Ø23 for key lock cylinder**

- It must be made in axis of the end slat (TE14X56, TE14X56I, TE7X56, TE7X56I, TE12X55, TS12X55).

**Lateral bevelling of the hook**

- n. 2 bevellings for each end slat on all end slats

N.B. The proper end slats and accessories must be chosen according to the different profiles (see schedule 1)

(schedule 1)

END SLAT	ASSEMBLABLE ACCESSORIES	COUPLING PROFILES
TE 7X56	interior lock art.SE43I inside/outside lock art.SE43E alum. security latch art.CA42A steel security latch art.CA42AC conic stoppers TC40 PVC gasket art.GG35NOR	from 7,5 to 9mm (for normal rolling)
TE 7X56I	interior lock art.SE43I inside/outside lock art.SE43E alum. security latch art.CA42A steel security latch art.CA42AC conic stoppers art.TC40 PVC gasket art.GG35NOR	from 7,5 to 9mm (for exterior rolling)
TE 7X56U	conic stoppers art.TC40 PVC gasket art.GG35NOR	from 7,5 to 9mm (for inside/outside rolling)
TE 14X56I	interior lock art.SE43I inside/outside lock art.SE43E alum. security latch art.CA42A	from 12 -14mm (for exterior rolling)

	steel security latch art.CA42AC reinforced sec. latch art.CA42F conic stoppers art.TC40 PVC gasket art.GG35NOR	
TE 14X56U	reinforced sec. latch art.CA42F conic stoppers art.TC40 PVC gasket art.GG35NOR	from 12-14mm (for inside/outside rolling)
TE 12X55	interior lock art.SE43I inside/outside lock art.SE43E alum. security latch art.CA42A steel security latch art.CA42AC conic stoppers art.TC40 PVC gasket art.GG35NOR	for SAR115
TE 12X55 (used as intermediate slat)	interm.alum.sec.latch. art.CA44A gasket art.GG12PVC gasket art.GG35NOR	for SAR115
TS12X55	interior lock art.SE43I inside/outside lock art.SE43E alum. security latch art.CA42A steel security latch art.CA42AC reinforced sec. latch art.CA32F conic stoppers art.TC40 PVC gasket art.GG35NOR	from 12-14mm (for normal rolling)
ES/37 (intermediate end slat)	alum.security latch art.CA44A	for AR20/SAR120

5) Execute the manufacturing for the intermediate security latch (if provided) (CAT.INT-CAT.INT12) with machine CAT-MATIC (only for typologies AR/12-32-33-SAR/132-112-133).

6) Insert the junctions to the roll tube on the last slat (see schedule 2); \*if security junctions ATSC are used, these must be separately assembled for on-site installation, for the selection of the model consult the Croci catalogue.  
(schedule 2)

PROFILES	JUNCTION STRAP
AR/20-7-17-16-23, SAR/120-117, ES44	part nr.5101* or part nr.5001*
AR/8-12-32, SAR/112-132	part nr.5102* or part nr.5002*
AR/33, SAR/133, SAR/115, ES/55	part nr.PT45ALL* according to rolling shutter size with strap CINY1 every 50cm

7) Insert the slats one by one, add the end slat and the last upper profile, assemble alternately with side plugs starting from the end slat;

8) When the rolling shutter is assembled, clean it with compressed air or with a rag, put on the polyethylene film on the inner side (concave or inner side of the rolling shutter) that will have to be longer than the rolling shutter height, in order to cover also the end slat.

9) The rolling shutter must be wrapped up with double coat of bubble wrap and packed with adhesive tape and, in case of special transports, it must be packed with carton boxes.

10) Conic stoppers (TC40) and other accessories to be assembled on-site must be separately packed in carton boxes or bubble wraps.

## **USE OF GUIDE RAILS FOR TRADITIONAL SYSTEM**

**FOR 7,5-9MM PROFILES.**  
 (SAR/120,SAR7117,AR/23,ES/44,AR/8,  
 AR/20,AR/7,AR/17,AR/16)

**FOR 12-14MM PROFILES.**  
 (SAR/112,SAR/132,AR/33,SAR/133,  
 AR/12,AR/32,SAR/115, ES/55)

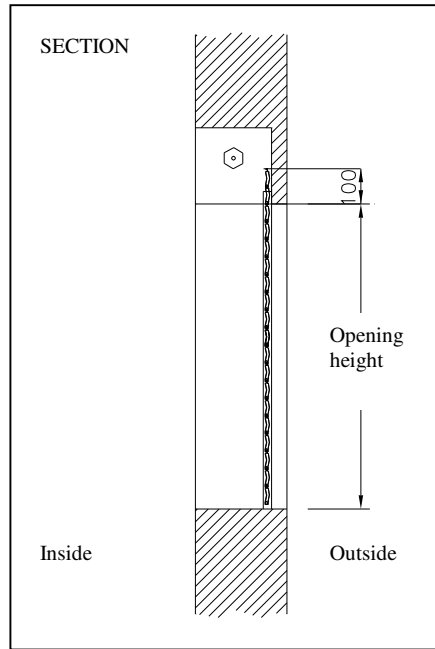
**TRADITIONAL**

PART NR.	MAX OPENING WIDTH	GG35NOR SP35NOR
GE28x17 for replacement	2.0mt.	For profiles: 7,5-9mm
GE26x21	1.5mt	
GE35x21	3.0mt.	
GE40x21/GE45X2	4.0mt.	
<b>GG35NOR</b> =normal PVC gasket <b>GG35MAG</b> =maxi PVC gasket <b>GG35SUP</b> =super PVC gasket <b>SP35NOR</b> =normal brush gasket <b>SP35MAG</b> =maxi brush gasket		

PART NR.	MAX OPENING WIDTH	GG35MAG SP35MAG	GG35NOR SP35NOR	GG35SUP SP35MAG
GE30x19	2.5mt.	ES/55 AR/32- AR/33 SAR/132 SAR/133	AR/12 SAR/112	only for SAR/115
GE30x27	2.5mt.			
GE40x27/GE45x2	4.0mt.			
GE60x28	5.5mt.			
PART NR.	MAX OPENING WIDTH	PVC GASKET GG35NOR		
GS28x17 for replacement	2.0mt.	Only for AR/32-33, ES/55 SAR132-133		

Manufacture:

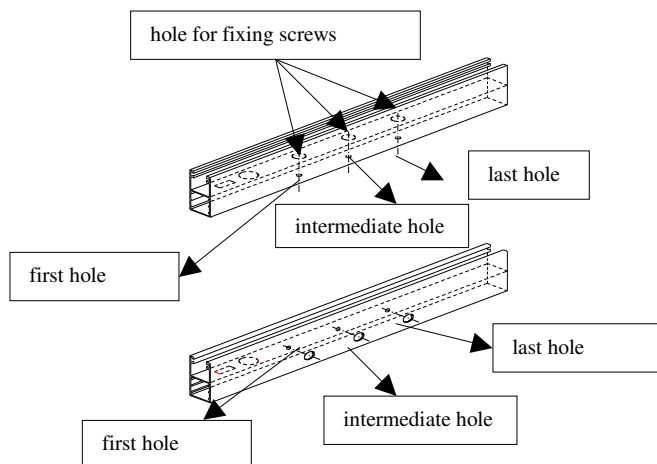
- 1) Cut to measure (opening height +100mm)



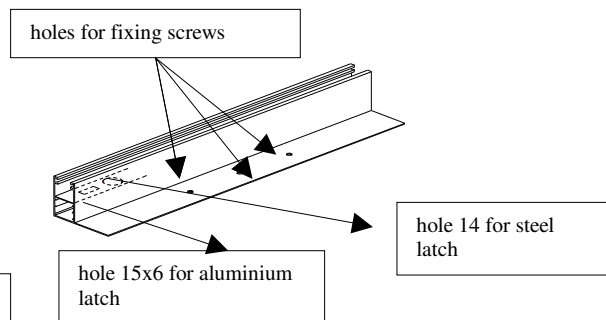
- 2) Make the holes for fixing the guide rails and the holes for assembling latches or key locks, split the upper part of the guide rail, insert gaskets or brushes and then press to avoid any outgoing;
- 3) Wrap up with pluriboll using adhesive tape. N.B. For transports by carrier, pack with carton boxes filling with polystyrene any possible empty area.



## Internal punching



## Manufacture typologies



## Lateral punching

### LIST OF THE WORKINGS TO BE MADE ON "GUIDE RAILS FOR SHUTTER BOX"

#### **9.0 holes with double diameter Ø4 and Ø10mm**

- for guide rails "type G – H – L" (GE62X28, GE80X28, GE458028, GE458028A, GE53X21, GE62X21, GE90X35)

#### **9.1 Internal punching of the guide rail (fig. 1)**

- the first and the last hole have to be 15cm distant from the extremity
- the intermediate holes have to be made at equal distances, adjustable between 50 and 70cm.

#### **9.2 Lateral punching (fig. 2)**

- the first and the last hole have to be 15cm distant from the extremity
- the intermediate holes have to be made at equal distances, adjustable between 50 and 70cm.

### LIST OF THE WORKINGS TO BE MADE ON "GUIDE RAILS FOR SHUTTER BOX"

#### **5.0 hole 15x7 for aluminium latch**

- for guide rails "type H – I" (GE53X21, GE62X21, GE53X21A, GE62X21A)

#### **6.0 hole 15x7 + hole Ø14 for steel latch (cannot be used together)**

- for guide rails "type G" (GE62X28, GE80X28, GE458028, GE458028A)

#### **7.0 the first and the last hole have to be 15cm distant from the extremity**

- the intermediate holes have to be made at equal distances, adjustable between 50 and 70cm.
- for guide rails with "L" "type I" (GE53X21A, GE62X21A)

#### **8.0 hole 23x8 for key lock**

- for guide rail "type L" (GE90X35)

2) Pack with plastic bubble wrap using adhesive tape. N.B. For transports by carrier pack with carton boxes filling with polystyrene any possible empty area.

## **IMPORTANT:**

In addition to the sales-documentation, enclose:

- **Declaration of Conformity CE Profiles for Rolling shutters (compiled by Croci S.p.A.)**
- **Declaration of Conformity CE Rolling shutters (compiled by the assembler)**
- **Label CE to be applied on the end slat of each rolling shutter**

**For anything not specified, always refer to the Croci catalogue and to its updates.**