

Drilling jigs and accessories

Application technology made easy...



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Installation aids



Starting with a simple manual drilling jig for simultaneous fitting to the rational serial drilling jig, the various means of installing SIMONSWERK hinges are indicated in detail and clearly below.

The correct function of a hinge requires professional installation with the use of the appropriate tools, drilling jigs, milling templates and accessories. Precise and rational fitting is possible with the aid of the precise SIMONSWERK drilling jig technology.

The relevant fitting aids for the respective hinges are specified under **"For fitting with"** in all SIMONSWERK product literature.



Structure and contents

The choice of the correct drilling jig and the suitable accessories for each hinge can be made according to different criteria and requirements:

- from the hinge to the drilling jig
- from the milling template to the hinge
- from the drilling jig to the hinge

From the hinge to the drilling jig

You have chosen a hinge and are looking for the matching fitting aid. To simplify the search, we have included the corresponding assignments to our product range in table form on Pages 6 to 21.

From the milling template to the hinge

You are in possession of various milling templates. The overview on Page 22 will show you the hinges assigned to the respective milling template. Several hinges can often be fitted with the same template.

From the drilling jig to the hinge

You know which fitting aids you need or already possess a drilling jig. Pages 24 to 73 contain extensive technical information on the individual drilling jigs and accessories with additional explanations of the individual fitting steps.

with professional knowledge is essential for this. Application technology and sample fittings at the fabricator's premises and presentations at distributors are daily items in the schedules of our technical consulting representatives.

Of course, SIMONSWERK offers the associated fitting aid for each hinge and production process. If you require our support, our technical advisors will make all endeavours to be of assistance.

If required, please contact the Application Technology department, which you can reach by e-mail at anwendungstechnik@simonswerk.de.

Drilling and milling diagrams in DXF format can be downloaded directly from the Internet on our websites in the "Service" menu.

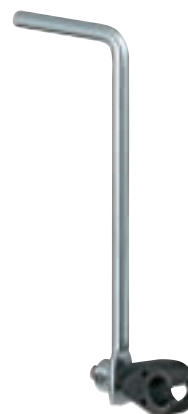


Service

Careful order processing is one task, extensive information and consulting to determine the best solutions for our customers by endeavours at all levels is another. Our technical field service on site

Accessories

The extensive range of accessories also includes the milling frame no. 118 as a universal fitting aid for numerous fittings, the special blind rivet tongs GBM 30 for retrofitting the blind rivet nut M 10 receiver in existing steel frames and the wind-in cup for simple and rational installation of hinges.



Special designs

We elaborate individual suggestions for special drilling jigs for particular fitting situations.

Please contact us.

VX hinges 100 mm

Hinge	Milling template
VX 7728/100	11812731
VX 7729/100	11812724
VX 7939/100	11812722
VX 7939/100 FD	11812737
VX 7939/100 FD-27	11812743

VX hinges 120 mm

Hinge	Milling template
VX 7728/120	11812720
VX 7729/120	11812720
VX 7859/120	11822727
VX 7939/120	11812723

VX hinges 160 mm

Hinge	Milling template
VX 7728/160	11812719
VX 7729/160	11812719
VX 7729/160-4	11812719
VX 7859/160	11822729
VX 7939/160	11812718
VX 7939/160-4	11812718
VX 7939/160 FD	11812738
VX 7939/160-4 FD	11812738

Example:

You want to mount the hinge VX 7939/160 S.
The table shows the milling template no.: 11812718
and the VARIANT drilling jig S-dowel.
You find the detailed description on page 27.

VX security hinges 160 mm

Hinge	Milling template	VARIANT
VX 7939/160 S	11812718	Drilling jig
VX 7939/160 FD S	11812738	S-dowel

Receivers

Hinge	Milling template
VX 7601 3D	11812734
	11812735
	11812736
VX 7601-4 3D	11812734
	11812735
	11812744
VX 7602 3D	11812734
	11812736
VX 7602-4 3D	11812734
	11812744
VX 7605 3D	11812734
	11812735
	11812736
	11812742

VN hinges 100 mm

		VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT
		Serial drilling	Serial drilling	Serial drilling	Drilling/milling	Serial jig	Milling jig	Serial jig	Drilling jig
		jig hinge	jig PA hinge	jig	jig	clamping block	clamp	clamping block	reinforcing-
		pocket (metal)	pocket	V 4600	V 3604	V 3604	V 3605	V 3607	dowel
Hinge	Milling template	Page 37	Page 38	Page 42	Page 32	Page 39	Page 33	Page 40	Page 28
VN 1939/100	11822742 frame								
	11812722 sash								
VN 1939/100 FD	11822742 frame								
	11812737 sash								
VN 2828/100	11812731								
VN 2929/100	11812724								
VN 3839/100	11812722	Special jig on request							
VN 3839/100 FD	11812737	Special jig on request							
VN 3849/100	11812724	Special jig on request							
VN 3939/100	11812722	•	•		•	•	•	•	
VN 3939/100 FD	11812737	•	•		•	•	•	•	
VN 3939/100 FD-27	11812743	•	•		•	•	•	•	
VN 3939/100 FV	11812722	•	•		•	•	•	•	•
VN 3939/100 FV FD	11812743	•	•		•	•	•	•	•
VN 4739/100	11812722			•					
VN 4739/100 FD	11812737			•					
VN 4739/100 FV	11812722			•					•
VN 4739/100 FV FD	11812743			•					•
VN 3949/100	11812724	•	•		•	•	•		
VN 7748/100	11812724								
VN 7938/100	11812722								
VN 7938/100 FD	11812737								
VN 8849/100	11812724								
VN 8939/100	11812722								
VN 8939/100 FD	11812737								
VN 8939/100 FD-27	11812743								
VN 8939/100 FV	11812722								•
VN 8939/100 FV FD	11812743								•
VN 9939/100	11812722								
VN 9949/100	11812724								

VN hinges 120 mm

Hinge	Milling template
VN 1939/120	11822721 frame 11812723 sash
VN 2828/120	11812720
VN 2929/120	11812720
VN 5959/120	11822728 frame 11822727 sash
VN 7728/120	11812720
VN 7729/120	11812720
VN 7859/120	11822727
VN 7939/120	11812723

VN hinges 160 mm

Hinge	Milling template	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT
		Serial drilling jig	Serial drilling jig hinge	Serial drilling jig	Drilling/milling jig	Serial jig clamping block	Milling jig clamp	Serial jig clamping block
		VN / VS 3800/160	pocket (metal)	PA hinge pocket	V 3604	V 3604	V 3605	V 3607
		Page 25	Page 37	Page 38	Page 32	Page 39	Page 33	Page 40
VN 1939/160	11822717 frame 11812718 sash							
VN 1939/160 FD	11822717 frame 11812738 sash							
VN 2828/160	11812719							
VN 2929/160	11812719							
VN 3838/160	11812718	•						
VN 3838/160 FD	11812738	•						
VN 3848/160	11812719	•						
VN 3938/160	11812718		▲	▲	•	■	•	■
VN 3938/160 FD	11812738		▲	▲	•	■	•	■
VN 3948/160	11812719		▲	▲	•	■	•	
VN 5959/160	11822730 frame 11822729 sash							
VN 7728/160	11812719							
VN 7729/160	11812719							
VN 7859/160	11822729							
VN 7939/160	11812718							
VN 7939/160 FD	11812738							
VN 8938/160	11812718							
VN 8938/160 FD	11812738							
VN 8948/160	11812719							
VN 9938/160	11812718							
VN 9948/160	11812719							

- Standard version
- ▲ Standard version, 2 drilling jigs and 2 distance tubes additionally necessary
- Special version

VN replacement hinges

VARIANT	VARIANT	* VARIANT	Blind rivet
serial drilling jig	drilling jig	serial drilling jig	tongs GBM 30
	VN 8900/160 U		
VN / VS		VS 4600	
3700/160			

Hinge	Milling template	Page 24	Page 26	Page 43	Page 71
VN 3738/160	11812718	•		•	•
VN 3738/160 FD	11812738	•		•	•
VN 3748/160	11812719	•			•
VN 8938/160 U	11812718		•		•
VN 8948/160 U	11812719		•		•

VN security hinges 160 mm

VARIANT	VARIANT	* VARIANT	Blind rivet
drilling jig	serial drilling	serial drilling	tongs GBM 30
S-dowel	jig	jig	
	VN / VS	VS 4600	
	3700/160		

Hinge	Milling template	Page 27	Page 24	Page 43	Page 71
VN 7939/160 S	11812718	•			
VN 3738/160 S	11812718	•	•	•	•
VN 8938/160 S	11812718	•			
VN 3738/160 FD S	11812738	•	•	•	•
VN 7939/160 FD S	11812738	•			
VN 8938/160 FD S	11812738	•			

* for wooden casing frame

VARIANT sash parts for rebated doors

	BAKA	VARIANT	Serial	VARIANT	VARIANT	VARIANT
	universal	PA	drilling jig	Replacement	drilling jig	drilling jig
	drilling jig	drilling jig	sash 13/15	drilling jig	S-dowel	reinforcing-
	13/15			V 0026		dowel

Hinge	Milling template	Page 45	Page 29	Page 34/35	Page 31	Page 27	Page 28
V 0020		•	•	•			
V 0020 RK		•	•	•			
V 0026 (WF)			•	▲	•		
V 0026 RK WF			•	▲	•		
V 0030	11812701						
V 0036	11812713						
V 0037	11812703						
V 0037 WF	11812727						
V 0037 RK WF	11812727						
V 0037 WF S	11812727					•	
V 0037 WF FV	11812727						•
V 0037 WF FV S	11812727					•	

- Standard version
- ▲ Standard version, 2 drilling jigs and 2 distance tubes additionally necessary

VARIANT sash parts for unrebated doors

Hinge	Milling template
V 0046	11812714
V 0080	11812725
V 0087	11812726
V 0087 WF	11812728

VARIANT frame parts for wooden frames

	BAKA	VARIANT	Serial	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT
	universal	PA	drilling jig	serial drilling	serial	drilling/milling	serial jig	milling jig	serial jig	serial
	drilling jig	drilling jig	frame	jig hinge	drilling jig	jig	clamping block	clamp	clamping block	drilling jig
	13 / 15		13 / 15	pocket (metal)	PA hinge	V 3604	V 3604	V 3605	V 3607	V 4600
				pocket						

Hinge	Page 45	Page 29	Page 36	Page 37	Page 38	Page 32	Page 39	Page 33	Page 40	Page 42
V 3100 (WF)	•	•	•	•	•	•	•	•	•	
V 3200 (WF)	•	•	•							
V 3400 (WF)	•	•	•	•	•	•	•	•	•	
V 3400 RK WF	•	•	•	•	•	•	•	•	•	
V 4100 (WF)		•	•	•	•	•	•	•	•	
V 4200 WF		•	•							
V 4400 (WF)		•	•	•	•	•	•	•	•	
V 4400 WF FV		•	•	•	•	•	•	•	•	
V 4700 WF										•
V 4700 WF FV										•

VARIANT frame parts for steel frames

	Receiver	VARIANT	Blind rivet			Receiver	VARIANT	Blind rivet
	steel frame	serial	tongs GBM 30			steel frame	serial	tongs GBM 30
		drilling jig					drilling jig	
		V 8100 WF U /					V 8100 WF U /	
		V 8000 WF U					V 8000 WF U	

Hinge	Page 41	Page 71	Hinge	Page 41	Page 71
V 8000 (WF)	•		V 8100 RK WF	•	
V 8000/18 WF	•		V 8100 WF U	•	•
V 8000 WF FV	•		V 8700	•	
V 8000 WF U		•	V 9000 (WF)	•	
V 8100 (WF)	•		V 9100 (WF)	•	
V 8100/18 WF	•				

VARIANT rising hinges

	BAKA	VARIANT	Serial	Serial	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT
	universal	PA	drilling jig	drilling jig	serial drilling	serial	drilling/milling	serial jig	milling jig
	drilling jig	drilling jig	sash	frame	jig hinge	drilling jig	jig	clamping block	clamp
	13 / 15		13 / 15	13 / 15	pocket (metal)	PA hinge	V 3604	V 3604	V 3605
					pocket				

Hinge	Milling template	Page 45	Page 29	Page 34	Page 36	Page 37	Page 38	Page 32	Page 39	Page 33
V 5135	11812703	•	•		•	•	•	•	•	•
V 5150		•	•	•	•	•	•	•	•	•
V 8535	11812703									
V 8550		•	•	•						

VARIANT-3D hingesystem

Hinge	Milling template
V 7888 WF	11812728
V 7602 3D	11822743

Door bolt

Door bolt	Milling template
no. 205	11822731
no. 206	11822731
no. 207	11822731

Receivers

VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT
serial drilling	serial drilling	PA	drilling/milling	serial jig	milling jig	serial jig	serial drilling	rebate-hole	
jig hinge	jig	drilling jig	jig	clamping block	clamp	clamping block	jig	drilling jig	
pocket (metal)	PA hinge		V 3604	V 3604	V 3605	V 3607	V 4600		
	pocket								

Receiver

Receiver	Page 37	Page 38	Page 29	Page 32	Page 39	Page 33	Page 40	Page 42	Page 30
Serie V 3600	•		•						•
Serie V 3610	•		•						•
Serie V 3630		•	•						•
Serie V 3650		•	•						•
V 3604				•	•				
V 3604/20				■	■				
V 3604/21,5				■	■				
V 3605	•		•			•			
V 3607							•		
V 3608							■		
V 4600								•	

- Standard version
- Special version

VS hinges

	VARIANT	VARIANT	VARIANT	Blind rivet
	serial	serial drilling	serial drilling	tong GBM 30
	drilling jig	jig VN / VS	jig VN / VS	
	VS 4600	3700/160	3800/160	

Hinge	Milling template	Page 43	Page 24	Page 25	Page 71
VS 1939	11812711 frame				
	11812710 sash				
VS 2929	11812709				
VS 3739	11812710	•	•		•
VS 3839	11812710			•	

	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT	VARIANT
	serial drilling	serial drilling	drilling/milling	serial jig	milling jig	serial jig
	jig hinge	jig	jig	clamping block	clamp	clamping block
	pocket (metal)	PA hinge	clamping block	V 3604	V 3605	V 3607
		pocket	V 3604			

Hinge	Milling template	Page 37	Page 38	Page 32	Page 39	Page 33	Page 40
VS 3939	11812710	▲	▲	•	■	•	■
VS 3949	11812709	▲	▲	•	■	•	
VS 7749	11812709						
VS 7939	11812710						
VS 8939	11812710						
VS 8949	11812709						
VS 9939	11812710						
VS 9949	11812709						

- Standard version
- ▲ Standard version, 2 drilling jigs and 2 distance tubes additionally necessary
- Special version

VS security hinges

	VARIANT	VARIANT	VARIANT	VARIANT
	serial drilling	serial drilling	drilling jig	serial drilling
	jig	jig VN / VS	S-dowel	jig VN / VS
	VS 4600	3700/160		3800/160

Hinge	Milling template	Page 43	Page 24	Page 27	Page 25
VS 3739 S	11812710	•	•	•	
VS 3839 S	11812710			•	•
VS 7939 S	11812710			•	
Receiver VS 4600/7		•			
Receiver VS 4600/9		•			

BAKA hinges 8 / 10

BAKA
universal
drilling jig
8 / 10

Hinge

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BAKA A 1– 8
BAKA B 1– 8
BAKA A 1–10
BAKA B 1–10

•
•
•
•

BAKA hinges 13 / 15

BAKA BAKA BAKA Serial Serial
universal drilling jig PA drilling jig drilling jig
drilling jig KR drilling jig sash frame
13 / 15 13 / 15 13 / 15 13 / 15

Band

Page 45 Page 48 Page 46 Page 34 Page 36

BAKA A 1–13
BAKA A 2–13
BAKA A 1–15
BAKA A 2–15
BAKA B 1–13
BAKA B 1–15
BAKA B 2–15
BAKA C 1–15 WF
BAKA C 2–15 WF

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• • • •
• • • •
• • • •
• • • •

BAKA pivot sash hinges

BAKA BAKA BAKA Serien- Serien- BAKA
Universal- Bohrlehre Kunststoff- bohrlehre bohrlehre Bohrlehre
bohrlehre KR bohrlehre Flügel Rahmen C 5-15
13 / 15 13 / 15 13 / 15 13 / 15

Hinge

Page 45 Page 48 Page 46 Page 34 Page 36 Page 49

BAKA B 1 K–13
BAKA C 1–13
BAKA C 3–15
BAKA C 5–15
BAKA C 5–15/18,5

• • • • •
• • • • •
• • • • •
• • • • •
• • • • •

- Standard version
- Special version

BAKA entrance door hinges

	BAKA	BAKA	BAKA	BAKA	BAKA	BAKA	BAKA	BAKA	BAKA	BAKA
	PA	Plug-in	Plug-in	ball bearing	milling jig	ball bearing	drilling jig	serial	Drilling/milling	ball bearing
	drilling jig 20	drilling jig	drilling jig	location	2D 20	location	3D 20	drilling jig	jig	location
		2D 20	2D 20 FD	drilling jig	sash	milling jig	sash	sash 20	3D 20	drilling/milling
		frame	frame	Rahmen 20		2D 20 sash			frame	jig 3D 20 frame

Hinge	Page 47	Page 54	Page 54	Page 55	Page 52	Page 53	Page 50	Page 51	Page 56	Page 57
BAKA C 1-20 WF	•			•				•		
BAKA C 2-20 WF	•			•				•		
BAKA 2D 20		•		•	•	•				
BAKA 2D 20 FD			•	•	•	•				
BAKA 2D 20 RZ 57		•		•	•	•				
BAKA 2D 20 FD RZ 57			•	•	•	•				
BAKA 3D 20 A							•	•	•	•
BAKA 3D 20 Plus					•	•			•	•
BAKA 3D 20 FD Plus					•	•			•	•

BAKA protect 3D entrance door hinges

	BAKA	BAKA	BAKA	BAKA
	milling jig	ball bearing	drilling/milling	ball bearing
	2D 20	location	jig	location
	sash	milling jig	protect	drilling/milling
		2D 20 sash	frame	jig frame

Hinge	Page 52	Page 53	Page 58	Page 59
BAKA protect 3D	•	•	•	•
BAKA protect 3D FD	•	•	•	•

SIKU 3D hinges

	SIKU 3D	SIKU 3D	SIKU 3D	SIKU 3D
	drilling jig	ball bearing	ball bearing	Telescope
	simultaneous	location	location	serial
	fitting	drilling jig	drilling jig	drilling jig
		simultaneous	separate	simultaneous
		fitting	fitting	fitting
Hinge	Page 61	Page 62	Page 63	Page 64
K 1010	●	●	●	●
K 1110	●	●	●	●
K 1210	●	●	●	●
K 1015	●	●	●	●
K 1115	●	●	●	●
K 1215	●	●	●	●
K 2020	●	●	●	●
K 2120	●	●	●	●
K 2025	●	●	●	●
K 2125	●	■	■	■

- Standard version
- Special version

Multi 3D hinges

	Multi 3D drilling jig	Multi 3D drilling jig			
	VN 3030 simultaneous fitting	VN 3041 simultaneous fitting			
Hinge	Page 65	Page 66			
VN 3030	•				
VN 3032			Special jig		
VN 3040			Special jig		
VN 3041		•			
VN 3130			Special jig		
VN 3330			Special jig		

Multi 2D hinges

	Multi 2D drilling jig				
	VN 5046 simultaneous fitting				
Hinge	Page 67				
VN 5045	■				
VN 5046	•	Special jig for ER profile			
VN 5133	■				
VN 5134	■				

From the hinge to the drilling jig...

profile overview drilling jigs for K hinges (A-L)

Hinge	K 3172 WF		K 3172/7 WF		K 3174 WF		K 3176 WF			K 3177	K 3178
	K 3172	K 3172/7	K 3173	K 3173/7	K 3174	K 3175 WF	K 3176	K 3176/L			
Profil											
Accord	156		151		165	167	157	157	169	170	
Actual	155		152		165	167	257/5,5	257/5,5	170	170	
Aluplast – Ideal 2000	156		151		166	168	158	158	169	169	
Ava-System	155		152								
Austroplast		155/7		152/7	165	167			170	170	
Bewaplast	155		152		165	167	157	157	170	170	
Braas	156		151		165	167	157	157	170	170	
Brüggmann 2001		156/7		151/7	165	167	157	157	170	170	
Brüggmann Serie 81		255/7-6,5	252/6,5	152/7	165	267/6,0	257/6,5	257/6,5	170	170	
Combidur AV		155/7		152/7	166	▪	258/6,5	258/6,5		▪	
Combidur Tritec	156		151		165	167	157	157	169	170	
Deceuninck	255/5,0	255/7-5,0		252/7-5,0	165		257/6,0	257/6,0			
Deceuninck-Mondial		256/7-8,0		251/7-8,0	165	167	157	157		170	
Dimat	155		152								
Durette	154		153		165		257/5,0	257/5,0	170	170	
Edil		256/7-6,5									
Eurodur MPF		155/7		152/7	166	168	158	158	169	169	
Eurodur 3S		156/7		151/7	166	168	158	158	169	169	
Exte	156		151		165	167	257/5,5	257/5,5	170		
Fersina	156		151		165	167	157	157	170	170	
Finstral	255/5,0	155/7		152/7	165		157	157	170	170	
Forbo Helmitin		255/7-5,0		252/7-5,0	265/4,5		258/5,0	258/5,0			
Gardinia		156/7		151/7	165				170	170	
Gealan	256/7,5	156/7	251/7,5		165	167	257/7,0	257/7,0	170	170	
Gealan S 3000		256/7-6,5		151/7	165		157	157	169	170	
Golde Ideal	156		151		165	167	157	157	170	170	
Gromatic	156		151		165	167	157	157	169	170	
Helling		156/7		151/7	165						
Hocoplast		155/7		152/7	166	168	158	158		169	
Illerplastic	156		151		165	167	157	157	170	170	
Inefa	155		152		165						
Isoferm		155/7			165					170	
KBE-central sealing	272/6,5		173		166	168	158	158	169	169	
KBE-rim sealing					165		157	157		170	
Komarek Riva 1	156		151		166	168	157	157		169	
Komarek Riva 2	156		151		165	167	157	157		169	
Lifty-Lux	155		152		166	168	158	158	169	169	
Lucobay 2000	156		151						169		
Lucobay 2200		156/7		151/7	165						
Lucobay 3000	156		151		165	167	157		169	170	
LB-Profile PAD, PMD		156/7		151/7	165		157	157	169		

Example:

You want to mount the hinge K 3172/7 on the profile Eurodur 3S (Kömmerling). According to the table the drilling jig 156/7 fits exactly for this attachment.

From the hinge to the drilling jig...

profile overview drilling jigs for K hinges (A-L)

INSTALLATION
AIDS

K 3179	K 3273	K 3273/7	K 3276	K 3276/L	K 3283	K 3285	K 3285/18,5	K 3281 K 3282	K 3281/C K 3282/C	K 3150
181	160		183	183	160	160	190	162		
	160		283/6,0	283/6,0	160	160	190	262/7,0		185
182	160		184	184	161	161	191		162	
	160				160	160	190	162		
					160	160	190	162		
181	160		183	183	160	160	190	162		
181	160		183	183	160	160	190	162		185
181	160		183	183	160	160	190	162		
281/5,5		260/7-7,0	183	183	160	160	190	279/7,5		
								■	162	
181	160		183	183	160	160	190	162		185
			183	183	160	160	190	162		
	160				160	160	190	162		
181	160		183	183	160	160	190	262/6,0		
	174									
182	260/7,0		283/6,0	283/6,0	161	161	191		262/6,5	
182		260/7-6,5	283/6,0		161	161	191		262/6,5	
181	160		183	183	160	160	190	162		185
181	160		183	183	160	160	190	162		185
181	160		183	183	160	160	190	162		
282/5,0	160	260/7-5,5	283/5,0			160		262/6,5		
		160/7			160	160	190	262/7,0		
281/5,5	160		183	183	160	160	190	162		185
181			183		160	160	190	162		
181	160		183	183	160	160	190	162		185
	161		183	183	160	160	190	162		185
		160/7			160	160	190	162		
			184	184	161	161	191			
181	160		183	183	160	160	190	162		185
	160		183	183		160	190	162		185
		160/7			160	160		162		
182	174		184	184	161	161	191		162	
			183	183	160	160	190	162		185
181	161		183	183	161	161	191		162	185
181	160		183	183	160	160	190	162		185
182	161		184	184	161	161	191		162	
	161								162	185
	160					160		162		
	160				160	160		162		185
	160		183	183	160	160	190	162		185/7

■ Special jig

This overview does not claim to be complete. For unlisted profiles we kindly ask for your inquiry with attached cross-section drawing and profile sample.

From the hinge to the drilling jig...

profile overview drilling jigs for K hinges (M-Z)

Hinge	K 3172 WF		K 3172/7 WF		K 3173		K 3173/7		K 3174 WF		K 3175 WF		K 3176 WF		K 3176/L WF		K 3177 WF		K 3178 WF	
	K 3172	K 3172/7	K 3172/7	K 3173	K 3173/7	K 3174	K 3175 WF	K 3176	K 3176/L	K 3177 WF	K 3178 WF									
Profil																				
Marquardt			156/7			151/7		166		168		158		158			169			
Miran																				
Osmo-pane compress	172				173			165		167		257/7,5		257/7,5		■				170
Osmo-pane comtess	172		172/7		173		173/7		165		167		157		157		■			170
Petal			156/7			151/7		165				157		157						170
Phoenolit	156				151			165		167		157		157			170			170
Pirnat			156/7			151/7		166		168		158		158			169			169
Plastalum	155		155/7		152		152/7		165											
Plus Plan			155/7			152/7		166				158		158						169
Polyval			172/7					166		168		158		158						169
Pozzi			155/7			152/7		165												
PRIMO		256/6,5						266/7,0												
PURAL																		169		170
Rehau 701	156				151			166		168		258/6,0		258/6,0			169			169
Rehau 702	156				151			165		167		257/6,0		257/6,0			170			170
Rehau 703	156				151			165				157		157			170			170
Rehau 705												257/5,5		257/5,5						
Rehau 709			156/7																	
Rehau 730			156/7			151/7		165		167		257/6,5		257/6,5						170
Rehau 735			172/7			173/7														
Roplasto			256/7-6,5									257/6,0		257/6,0			170			
Roth PU	155				152			166		168										169
Salamander-universal	156				152			165		167		257/6,5		257/6,5			169			170
Salamander-central sealing	156				151			165		167		257/8,0		257/8,0			169			170
Schüco AS, M + A			255/7-6,0			152/7		266/6,0		168		258/6,0		258/6,0			169			169
Siku-Plast	156				151			165		167		157		157			170			170
Stabidur			156/7			151/7		165				157		157						
Stöckel-Twin Step			156/7			151/7		165		167		157		157			169			170
Tehalit			256/7-6,0									257/6,5		257/6,5						
Thyssen-rim sealing			156/7			151/7		165		167		257/6,5		257/6,5			169			170
Thyssen-compact			156/7			151/7		165		167		257/6,5		257/6,5			169			170
Thyssen-central sealing			156/7			151/7		165		167		257/6,5		257/6,5			169			170
Thermetic			156/7			151/7		165		167		157		157			170			170
Trocal 900	256/6,5		155/7		152			165		167		257/6,5		257/6,5						170
Vekaplast-Softline			155/7			152/7		165				257/5,5		257/5,5			169			
Vollkutherm			155/7			152/7						157		157						

Example:

You want to mount the hinge K 3173 on the profile Vekaplast-Softline (Veka). According to the table the drilling jig 152 fits exactly for this attachment.

From the hinge to the drilling jig...

profile overview drilling jigs for K hinges (M-Z)

INSTALLATION
AIDS

K 3179 WF	K 3273	K 3273/7	K 3276	K 3276/L	K 3283	K 3285	K 3285/18,5	K 3281 K 3282	K 3281/C K 3282/C	K 3150
182			184	184	161	161	191		162	
					160	160	190	162		
181	174		183	183	160	160	190	162		
181	174		183	183	160	160	190	162		
181	160		183	183	160	160	190	162		
181	160		183	183	160	160	190	162		185
182			283/7,5	283/7,5	161	161	191	162		
	160				160	160	190	162		
		161/7	184	184	161	161	191			
		174/7			161	161	191		162	
	160				160	160	190	162		
										■
					260/7,5	260/7,5		262/8,0		
	161	161/7			161	161	191		162	185
181	160		183	183	160	160	190	162		185
181	160		183	183	160	160	190	162		185
	174							162		
	174	174/7						162		
181		274/7-8,0	183	183	260/8,5	260/8,5	190	262/8,0		
		174/7	183	183						
	160				160	160	190	162		
	161				161	161	191		162	
181	160		283/7,5	283/7,5	160	160	190	162		185
181	160		183	183	160	160	190	162		185
182	161		184	184	161	161	191		262/6,0	
181	160		183	183	160	160	190	162		185
181	160		183	183	160	160	190	162		
		160/7	183	183	160	160	190	162		
	160				160	160	190	162		
	160		283/7,5	283/7,5	160	160	190	162		
	160		283/7,5	283/7,5	160	160	190	162		
	160		283/7,5	283/7,5	160	160	190	262/8,0		
181	160		183	183	160	160	190	162		
281/5,5	260/8,5		283/7,0	283/7,0	260/7,5	160	190	262/8,0		
		260/7-7,5	283/6,5	283/6,5	160	160	190	262/7,0		
181			183	183	160	160	190	163		

■ Special jig

This overview does not claim to be complete. For unlisted profiles we kindly ask for your inquiry with attached cross-section drawing and profile sample.

From the milling template to the hinge...

Hundreds of milling jigs are designed for the different types of fittings. There are more than 40 different types only for SIMONSWERK hinges. The table below shows the suitable hinges for the jigs. The required cutter Ø are determined in the technical data of the hinges. The jigs are designed for collar ring Ø 30 mm.

Example: You own the milling jig no. 11812719. According to the table you can mill the pockets for the sash parts VX 0028/160, VX 0029/160, VN 0028/160, VN 0029/160 and VN 0048/160 with it.

Milling template Hinge	
11812701	V 0030
11812703	V 0034
	V 0035
	V 0037
11812704	QR 100
11812709	VS 0049
	VS 2929
11812710	VS 0039
11812711	VS 1900
11812713	V 0036
11812714	V 0046
11812718	VX 0039/160
	VN 0038/160
	VN 0039/160
11812719	VX 0028/160
	VX 0029/160
	VN 0028/160
	VN 0029/160
	VN 0048/160
11812720	VX 0028/120
	VX 0029/120
	VN 0028/120
	VN 0029/120
	VN 2800/120
	VN 2900/120
11812722	VX 0039/100
	VN 0038/100
	VN 0039/100
	VN 0039/100 FV
11812723	VX 0039/120
	VN 0039/120
11812724	VX 0029/100
	VN 0029/100
	VN 0048/100
	VN 0049/100
	VN 2900/100
11812725	V 0080
11812726	V 0087
11812727	V 0037 WF
	V 0037 WF FV

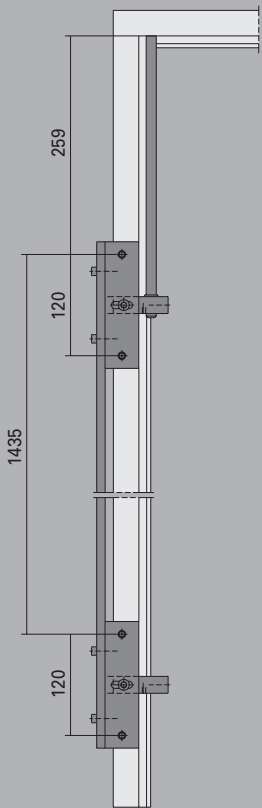
Milling template Hinge	
11812728	V 0087 WF
	V 7888 WF
11812731	VX 0028/100
	VN 0028/100
	VN 2800/100
11812733	QR 70
11812734	VX 7601 3D
11812735	VX 7601-4 3D
11812736	VX 7602 3D
	VX 7602-4 3D
	VX 7605 3D
11812737	VX 0039/100 FD
	VN 0039/100 FD
11812738	VX 0039/160 FD
	VN 0038/160 FD
	VN 0039/160 FD
11812741	BAKA 3D 20
11812742	VX 7605 3D
11812743	VX 0039/100 FD-27
	VN 0039/100 FD-27
	VN 0039/100 FD FV
11812744	VX 7601-4 3D
	VX 7602-4 3D
11822717	VN 1900/160
11822721	VN 1900/120
11822727	VX 0059/120
	VN 0059/120
11822728	VN 5900/120
11822729	VX 0059/160
	VN 0059/160
11822730	VN 5900/160
11822731	Door bolt 205
	Door bolt 206
	Door bolt 207
11822732	BAKA 2D 20
11822742	VN 1900/100
11822743	V 7602 3D

From the drilling jig to the hinge...

Possibilities of application with fitting steps and accessories

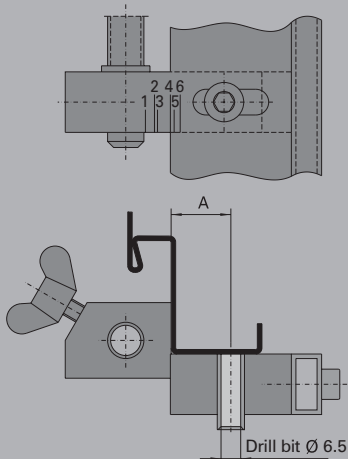
INSTALLATION
AIDS

INSTALLATION AIDS



Dimensions according to DIN 18111

Adjusting dimensions



	A	sash part
1	11.25	VN 0048/160
3	15.5	VS 0049
4	19.75	VN 0038/160
5	20.75	VS 0039



Serial drilling jig VN/VS 3700/160

With this VARIANT serial drilling jig, the drilling for new receivers (blind rivet nuts M 10) can be made on steel frames existing in the building.

The jig set consists of:

- 2 drilling jigs
- 1 connecting rod
- 2 stops
- 1 stop-tube
- 1 drill bit Ø 6.5 mm
- 1 fitting instruction

Fitting steps:

1. Adjust serial drilling jig to corresponding sash part (see adjustment-table). The clearance on the hinge side is given by the jig.
2. Set stop-tube according to right- or left-hand application.
3. Pre-drill frame with drill bit Ø 6.5 mm, remove jig and proceed with drill bit 12.1 mm.
4. Scrape out drilling holes for blind rivet nut.
5. Install blind rivet nut M 10 by using blind rivet tongs. Press tongs firmly against the frame.
6. Put steel ring on frame pins and screw in tightly.
7. Hang on door.

To be used for:

- VN 3738/160
- VN 3738/160 S
- VN 3738/160 FD
- VN 3738/160 FD S
- VN 3748/160
- VS 3700

Serial drilling jig VN/VS 3800/160

With this VARIANT serial drilling jig, the frame drilling for VARIANT VN- and VS-hinges can be made on block frames and blind frames.

The jig set consists of:

- 2 drilling jigs
- 1 connecting rod
- 2 stops
- 1 stop-tube
- 1 drill bit Ø 8.8 mm
- 1 set ring
- 1 fitting instruction

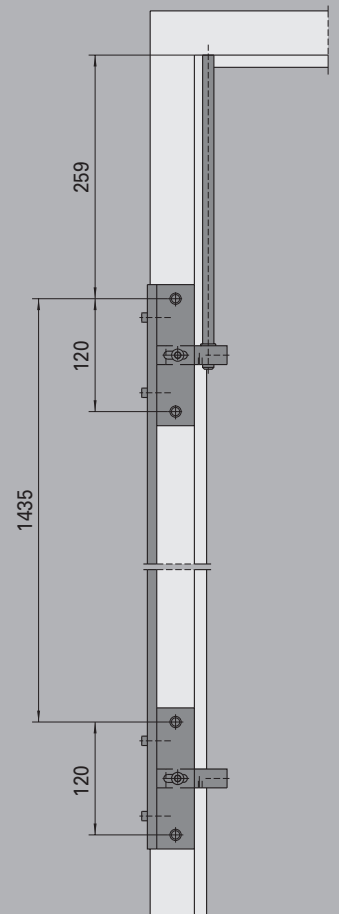
Fitting steps:

1. Adjust serial drilling jig to corresponding sash part (see adjustment-table). The clearance on the hinge side is given by the jig.
2. Set stop-tube according to right- or left-hand application.
3. Drill frame with drill bit Ø 8.8 mm.
4. Screw in and align frame parts.
5. Hang-on door.



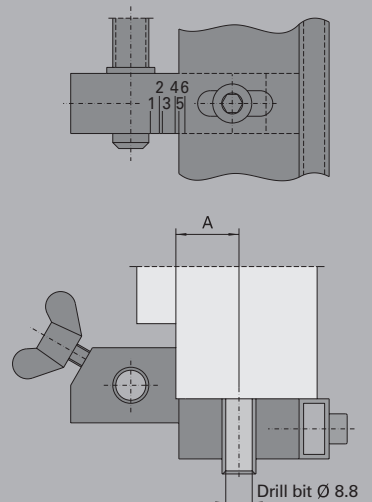
To be used for:

- VN 3838/160
- VN 3838/160 FD
- VN 3848/160
- VS 3800

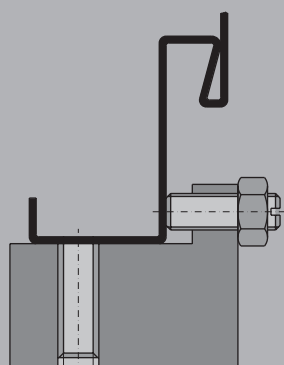


Dimensions according to DIN 18101

Adjusting dimensions



	A	sash part
2	14.25	VN 0048/160
3	15.5	VS 0049
5	20.75	VS 0039
6	22.75	VN 0038/160



Drill bit Ø 6.5



Drilling jig VN 8900/160 U

With this drilling jig, the drilling for an additional receiver (blind rivet nut M 10) can be made on an existing steel frame.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 6.5 mm
- 1 fitting instruction

Fitting steps:

1. Fix new frame part in steel frame.
2. Place drilling jig in installed frame part and align vertically by means of set screw.
3. Pre-drill frame with drill bit Ø 6.5 mm, remove drilling jig and proceed with drill bit 12.1 mm.
4. Scrape out drilling holes for blind rivet nut.
5. Install blind rivet nut M 10 by using blind rivet tongs.
6. Put steel ring on frame pins and screw in tightly.
7. Hang-on door.

To be used for:

VN 8938/160 U

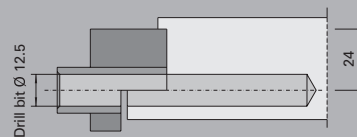
VN 8948/160 U

Drilling jig security-dowel

With this drilling jig, the drilling for the security-dowels of VARIANT S-hinges can be made.

The jig set consists of:

- 1 drilling jig
- 1 drill bit \varnothing 12.5 mm
- 1 fitting instruction



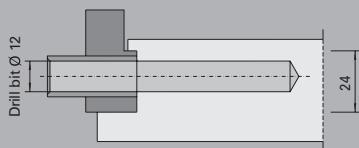
Fitting steps:

1. Position drilling jig in milling-slot.
2. Drill holes for S-dowels by using drill bit \varnothing 12.5 mm.

To be used for:

V 0037 WF S	VN 8938/160 S
V 0037 WF FV S	VN 8938/160 FD S
VS 0039 S	VX 7939/160 S
VN 3738/160 S	VX 7939/160 FD S
VN 3738/160 FD S	
VN 7939/160 S	
VN 7939/160 FD S	

Please specify hinge type when ordering.



Drilling jig reinforcing-dowel

With this drilling jig, the drilling for the reinforcing-dowels of VARIANT VX, VN, VS and VARIANT FV hinges can be made.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 12.0 mm
- 1 fitting instruction

Fitting steps:

1. Position drilling jig in milling-slot.
2. Drill holes for reinforcing-dowels by using drill bit Ø 12.0 mm.

To be used for:

- VARIANT hinges for heavy duty doors VX
- VARIANT hinges for heavy duty doors VN
- VARIANT hinges for heavy duty doors VS

Please specify hinge type when ordering.

VARIANT PA drilling jig

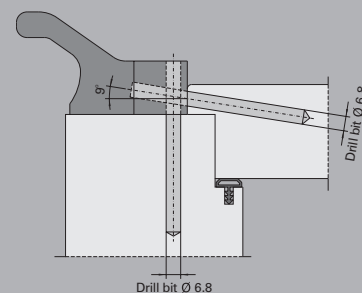
A solid drilling jig made of high-quality material with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 6.8 mm
- 1 set ring
- 1 wind-in cup Ø 15 mm
- 1 fitting instruction

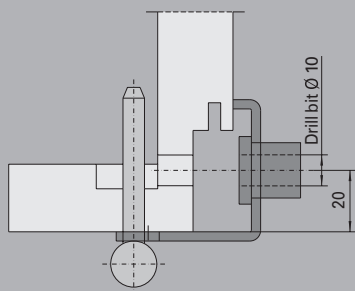
Fitting steps:

1. Place sash in frame, pull completely to hinge side and clamp. The clearance on the hinge side is given by the jig.
2. Determine hinge position, place drilling jig and drill holes for threaded pins.
3. Remove sash and screw in sash parts with wind-in crank or electric drill.
4. If necessary, drill rebate-holes with rebate-hole drilling jig and drill bit Ø 10 mm (see page 30).
5. Clamp frame parts in hinge pocket or screw on. Drive in frame parts V 3200 (WF) and V 4200 WF.
6. Align hinge parts and hang-on sash.



To be used for:

V 0020	V 4400 (WF)
V 0026 (WF)	V 5150
V 3100 (WF)	V 5135
V 3200 (WF)	V 8550
V 3400 (WF)	V 9550
V 4100 (WF)	
V 4200 WF	



Rebate-hole drilling jig

With this jig, the rebate-hole can be drilled in casing frames for the use of hinge pockets.

The jig set consists of:

- 1 drilling jig

Fitting steps:

1. Drill frame holes, rebore to $\text{Ø } 7.2$ mm if necessary.
2. Insert frame part in drilling holes.
3. Slide on drilling jig and carry out drilling by using drill bit $\text{Ø } 10$ mm.

Note:

Drill the 2 pin holes for the frame parts first with VARIANT drilling jig.

To be used for:

Hinge pockets series:

V 3600

V 3610

V 3630

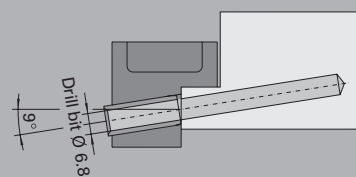
V 3650

Replacement drilling jig V 0026

With this VARIANT replacement drilling jig, doors with VARIANT V0020 hinges can be replaced by 3-part VARIANT hinges V 0026 WF and V 0026.

The jig set consists of:

- 1 drilling jig
- 1 fixing mandrel
- 1 drill bit Ø 6.8 mm
- 1 set ring
- 1 fitting instruction



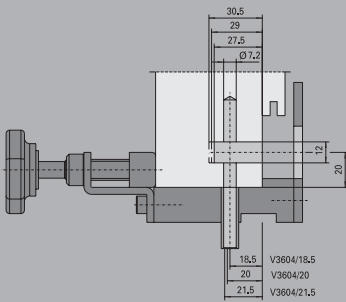
Fitting steps:

1. Remove sash part V 0020.
2. Place drilling jig on the overlap.
3. Fix drilling jig by means of the supplied mandrel through the upper drilling bush.
4. Clamp drilling jig and drill 2nd hole for V 0026 WF or V 0026. (drill bit Ø 6.8 mm, distance 71 mm)
5. Screw in V 0026 WF or V 0026.

To be used for:

V 0026 WF

V 0026



Drilling/milling jig V 3604

With this drilling/milling jig, the drilling and milling for clamping block V 3604 can be made.

The jig set consists of:

- 1 drilling/milling jig
- 1 drill bit $\varnothing 7.2$ mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. Determine hinge position on frame.
2. Place and clamp drilling/milling jig according to right- or left hand-application. The clearance on the hinge side is given by the jig.
3. Drill holes for frame parts with drill bit $\varnothing 7.2$ mm.
4. Mill frame by using cutter $\varnothing 12$ mm (collar ring $\varnothing 30$ mm).
5. Put-in clamping block.
6. Insert frame part and clamp with allen screw.

Note:

Order special jig to attach V 3604/20 and V 3604/21.5!

When ordering drilling/milling jig, please specify width of frame-lining.

To be used for:

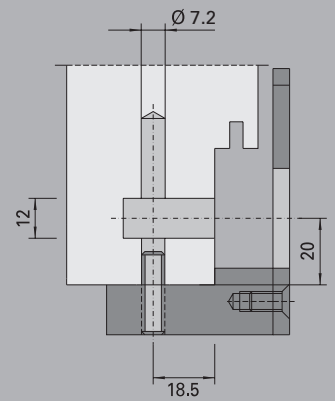
V 3100 (WF)	VN 3939/100
V 3400 (WF)	VN 3939/100 FD
V 4100 (WF)	VN 3939/100 FD-27
V 4400 (WF)	VN 3949/100
V 5150	VN 3938/160
V 5135	VN 3938/160 FD
VS 3900	VN 3948/160

Milling jig clamp V 3605

With this milling jig, the milling for clamp V 3605 can be made.

The jig set consists of:

- 1 milling jig
- 1 fitting instruction



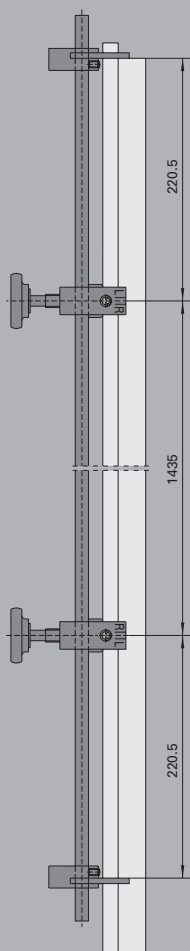
Fitting steps:

1. Drill frame holes (\varnothing 7.2 mm) for pins of frame part with VARIANT serial drilling jig for metal hinge pockets.
2. Insert pins of milling jig into bore hole \varnothing 7.2 mm.
3. Mill frame with routing machine.
 - cutter: \varnothing 12 mm
 - collar ring: \varnothing 30 mm

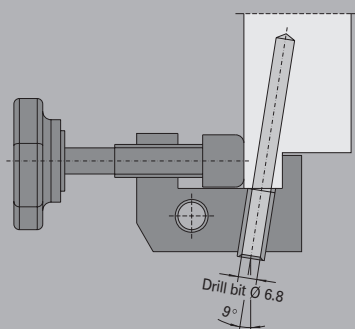
To be used for:

V 3100 (WF)	VN 3939/100
V 3400 (WF)	VN 3939/100 FD
V 4100 (WF)	VN 3939/100 FD-27
V 4400 (WF)	VN 3949/100
V 5150	VN 3938/160
V 5135	VN 3938/160 FD
VS 3900	VN 3948/160

Serial drilling jig



Dimensions according to DIN 18101



Note:

Additional drilling jigs for the application of a 3rd hinge are available on request.



Serial drilling jig sash 13/15

With this serial drilling jig, door and window sashes can be drilled separately.

The jig set consists of:

- 2 drilling jigs
- 1 connecting rod 12 x 2200 mm
- 2 swivelling stops
- 1 drill bit Ø 6.8 mm
- 1 set ring
- 1 wind-in cup Ø 13 mm
- 1 wind-in cup Ø 15 mm
- 1 fitting instruction

Fitting steps:

1. For interior doors, adjust drilling jig according to DIN (see illustration). This drilling jig can be works adjusted according to DIN 18101 on request.
2. For windows and patio doors, adjust the drilling jig to the frame jig.
3. If the stops are set at equal distances, the drilling jig is suitable for right- and left-hand application. In connection with the frame jig, this produces a clearance of 3 mm.

To be used for:

V 0020	B 1-13
V 5150	B 1K-13
V 8550	B 1-15
A 1-13	B 2-15
A 2-13	C 1-15 WF
A 1-15	C 2-15 WF
A 2-15	

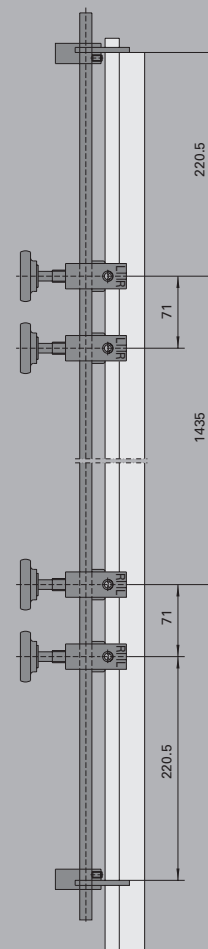
Serial drilling jig

INSTALLATION AIDS

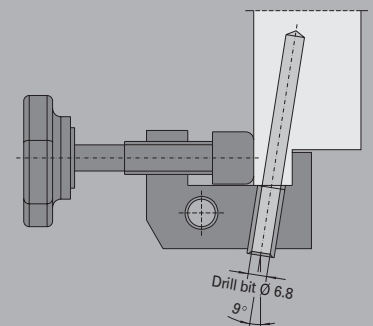
Serial drilling jig sash 13/15

Application as drilling jig sash 13/15 (page 34), but with 2 additional drilling jigs for the mounting of V 0026 (WF).

Please order 2 drilling jigs and 2 spacer tubes separately!



Dimensions according to DIN 18101



To be used for:

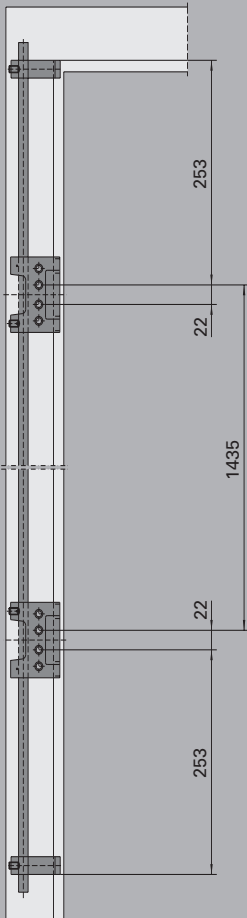
V 0020	A 2-15
V 0026 (WF)	B 1-13
V 5150	B 1K-13
V 8550	B 1-15
A 1-13	B 2-15
A 2-13	C 1-15 WF
A 1-15	C 2-15 WF

Note:

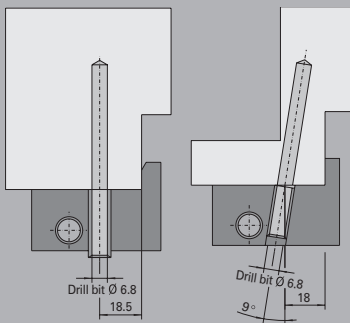
Additional drilling jigs for the application of a 3rd hinge are available on request.

Serial drilling jig

INSTALLATION AIDS



Dimensions according to DIN 18101



Note:

Additional drilling jigs for the application of a 3rd hinge are available on request.



Serial drilling jig frame 13/15

With this serial drilling jig, door and window frames can be drilled separately.

The jig set consists of:

- 2 drilling jigs
- 1 connecting rod 12 x 2200 mm
- 2 stops
- 1 drill bit \varnothing 6.8 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. Position drilling jigs and stops onto connecting rod.
2. Align first stop to upper door rebate and fasten. This drilling jig can be works adjusted according to DIN 18101 on request.
3. Adjust both drilling jigs to the position as requested and fasten also. The clearance on the hinge side is given by the jig.
4. Fix the second stop at the same distance from the lower drilling jig as the first stop from the upper drilling jig. The jig is thereby adjusted for right- and left-hand application. If necessary, open frame drilling to 7.2 mm if receivers are to be used.

To be used for:

V 3100 (WF)	V 5150	B 1-15
V 3200 (WF)	A 1-13	B 2-15
V 3400 (WF)	A 2-13	C 1-15 WF
V 4100 (WF)	A 1-15	C 2-15 WF
V 4200 WF	A 2-15	
V 4400 (WF)	B 1-13	
V 5135	B 1K-13	

Note:

Specify requested drilling bushing position!

- **Drilling bushes vertical:** Upwards of 26 mm casing-frame thickness
- **Drilling bushes in 9° position:** Up to 26 mm casing-frame thickness

Serial drilling jig hinge pocket (metal)

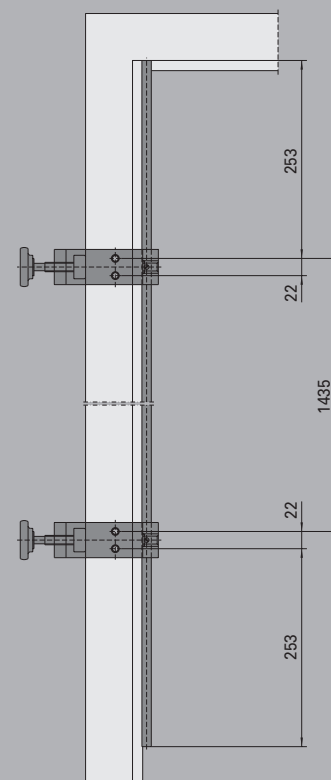
With this serial drilling jig, the drilling for VARIANT hinge pockets of series V 3600 and V 3610 can be made.

The jig set consists of:

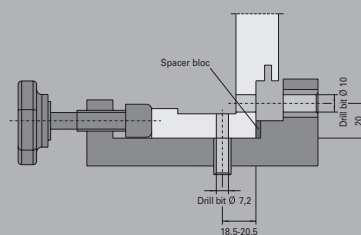
- 2 drilling jigs
- 1 drill bit Ø 7.2 mm
- 1 drill bit 10 mm
- 1 connecting rod 12 x 1963 mm
- 1 fitting instruction

Fitting steps:

1. Glue inlays on drilling jig. The thickness of the inlay depends on the frame-construction and the height of the applied hinge pocket. Drilling measure for mill-in hinges (sashes): 18.5 mm!
 2. Push drilling jig onto connecting rod, adjust to specified measure and fasten. See drawing for standard measure. The connecting rod lies on the rebate and serves as upper stop.
- Applicable for right- and left-hand, in case jig is adjusted to German standard. The clearance on the hinge side is given by the jig. This drilling jig can be works adjusted according to German standard DIN 18101.



Dimensions according to DIN 18101



To be used for:

V 3100 (WF)	VN 3939/100
V 3400 (WF)	VN 3939/100 FD
V 4100 (WF)	VN 3939/100 FD-27
V 4400 (WF)	VN 3949/100
V 5135	VN 3938/160*
V 5150	VN 3938/160 FD*
VS 3900*	VN 3948/160*

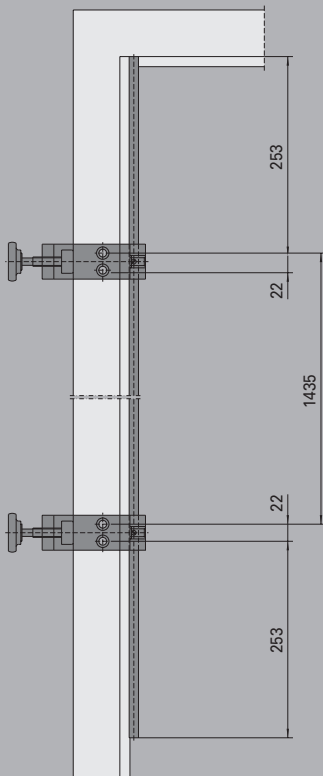
* To drill VS 3900, VN 3938/160, VN 3948/160, VN 3938/160 FD, order 2 drilling jigs, 2 spacer tubes "long" and 1 connecting rod 2200 mm additionally.

Note:

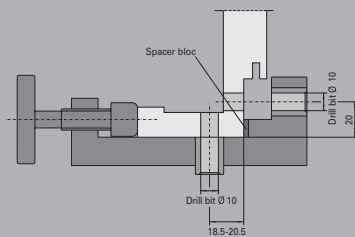
When ordering drilling jig, please specify width of frame-lining.

Individual drilling jigs for the mounting of other hinges are available on request.

INSTALLATION AIDS



Dimensions according to DIN 18101



Note:

When ordering drilling jig, please specify width of frame-lining.

Individual drilling jigs for the mounting of other hinges are available on request.



Serial drilling jig PA hinge pocket

With this serial drilling jig, the drilling for VARIANT hinge pockets of series V 3630 and V 3650 can be made.

The jig set consists of:

- 2 drilling jigs
- 1 drill bit Ø 10 mm
- 1 connecting rod 12 x 1963 mm
- 1 fitting instruction

Fitting steps:

1. Glue inlays on drilling jig. The thickness of the inlay depends on the frame-construction and the height of the applied hinge pocket. Drilling measure for mill-in hinges (sashes): 18.5 mm!
2. Push drilling jig onto connecting rod, adjust to specified measure and fasten. See drawing for standard measure. The connecting rod lies on the rebate and serves as upper stop. Applicable for right- and left-hand, in case jig is adjusted to German standard. The clearance on the hinge side is given by the jig.

This drilling jig can be works adjusted according to German standard DIN 18101.

To be used for:

V 3100 (WF)	VN 3939/100
V 3400 (WF)	VN 3939/100 FD
V 4100 (WF)	VN 3939/100 FD-27
V 4400 (WF)	VN 3949/100
V 5135	VN 3938/160*
V 5150	VN 3938/160 FD*
VS 3900*	VN 3948/160*

* To drill VS 3900, VN 3938/160, VN 3948/160, VN 3938/160 FD, order 2 drilling jigs, 2 spacer tubes "long" and 1 connecting rod 2200 mm additionally.

Serial jig clamping block V 3604

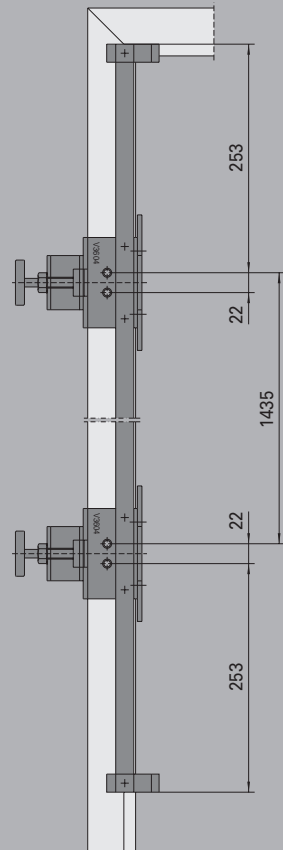
With this serial drilling jig, the drilling and milling for clamping block V 3604 can be made.

The jig set consists of:

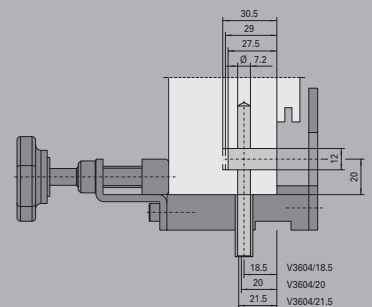
- 2 drilling/milling jigs
- 1 square tube
- 2 stops
- 1 drill bit \varnothing 7.2 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. Clamp serial jig on the frame. The clearance on the hinge side is given by the jig.
2. Drill holes for frame parts with drill bit \varnothing 7.2 mm.
3. Mill frame with cutter \varnothing 12 mm (collar ring \varnothing 30 mm).
4. Put-in clamping blocks.
5. Insert frame parts and fasten with Allen screw.



Dimensions according to DIN 18101



To be used for:

V 3100 (WF)	VN 3939/100
V 3400 (WF)	VN 3939/100 FD
V 4100 (WF)	VN 3939/100 FD-27
V 4400 (WF)	VN 3949/100
V 5135	VN 3938/160*
V 5150	VN 3938/160 FD*
VS 3900*	VN 3948/160*

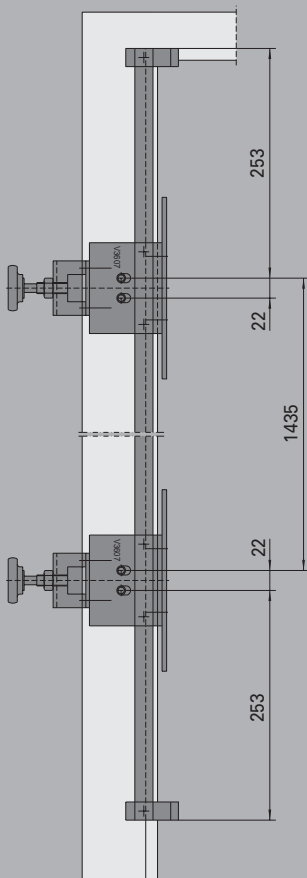
* Order special jig for drilling VS 3900,
VN 3938/160, VN 3948/160, VN 3938/160 FD!

Note:

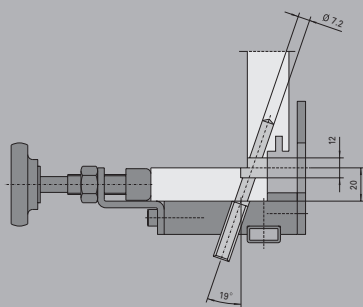
Order special jig for fitting
V 3604/20 and V 3604/21.5!

When ordering drilling jig, please
specify width of frame-lining.

This serial jig will be works adjusted
according to German standard DIN 18101.



Dimensions according to DIN 18101



Note:

Order special jig for fitting V 3608!

When ordering drilling jig, please specify width of frame-lining.

This serial jig will be works adjusted according to German standard DIN 18101.



**Serial jig
clamping block V 3607**

With this serial drilling jig, the drilling and milling for clamping block V 3607 can be made.

The jig set consists of:

- 2 drilling/milling jigs
- 1 square tube
- 2 stops
- 1 drill bit Ø 7.2 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. Clamp serial jig on frame. The clearance on the hinge side is given by the jig.
2. Drill holes for frame parts with drill bit Ø 7.2 mm.
3. Carry through milling with cutter Ø 12 mm (collar ring Ø 30 mm).
4. Put-in clamping blocks.
5. Insert frame parts and fasten with Allen screw.

To be used for:

V 3100 (WF)	VN 3939/100 FD-27
V 3400 (WF)	VN 3938/160*
V 4100 (WF)	VN 3938/160 FD*
V 4400 (WF)	
VS 3900*	
VN 3939/100	
VN 3939/100 FD	

* Order special jig for drilling VS 3900, VN 3938/160, VN 3948/160, VN 3938/160 FD!

Serial drilling jig V 8100 WF U/V 8000 WF U

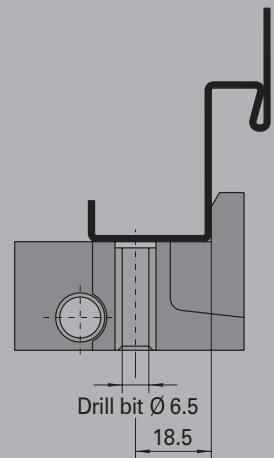
With this VARIANT serial drilling jig, the drilling for new receivers (blind rivet nut M 10) can be made on steel frames existing in the building.

The jig set consists of:

- 2 drilling jigs
- 1 connecting rod 12 x 1963 mm
- 2 stops
- 1 drill bit \varnothing 6.5 mm
- 1 fitting instruction

Fitting steps:

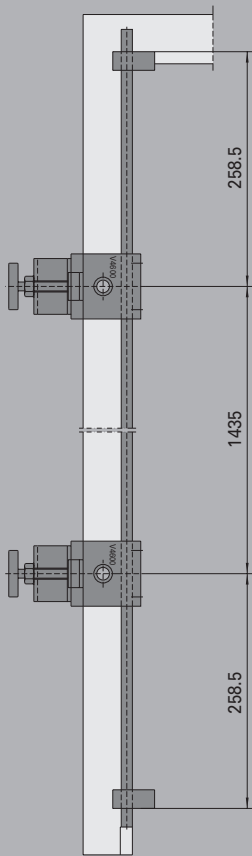
1. Adjust drilling jig.
2. Clamp adjusted drilling jig on the the steel frame. The clearance on the hinge side is given by the jig.
3. Pre-drill frame with drill bit \varnothing 6.5 mm, remove drilling jig and proceed with drill bit \varnothing 12.1 mm.
4. Scrape out drilling hole for blind rivet nut.
5. Install blind rivet nut M 10 by using blind rivet tongs.
6. Put steel ring on frame pins and screw in tightly.
7. Hang-on door.



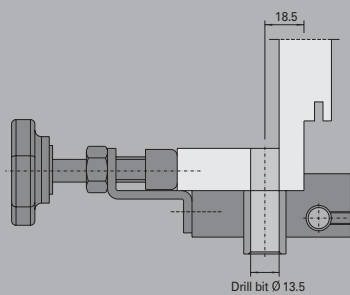
To be used for:

V 8100 WF U

V 8000 WF U



Dimensions according to DIN 18101



Serial drilling jig V 4600

With this serial drilling jig, the frame drilling for hinge receiver V 4600 can be made.

The jig set consists of:

- 2 drilling jigs
- 1 connecting rod 12 x 2200 mm
- 2 stops
- 1 drill bit Ø 13.5 mm
- 1 fitting instruction

Fitting steps:

1. Clamp drilling jig on frame. The clearance on the hinge side is given by the jig.
2. Drill holes with drill bit Ø 13.5 mm.
3. Assemble hinge receiver V 4600 on casing frame and screw in frame parts.
4. Hang-on door.

To be used for:

- V 4700 WF
- V 4700 WF FV
- VN 4739/100

When ordering drilling jig, please specify width of frame-lining.

Serial drilling jig VS 4600

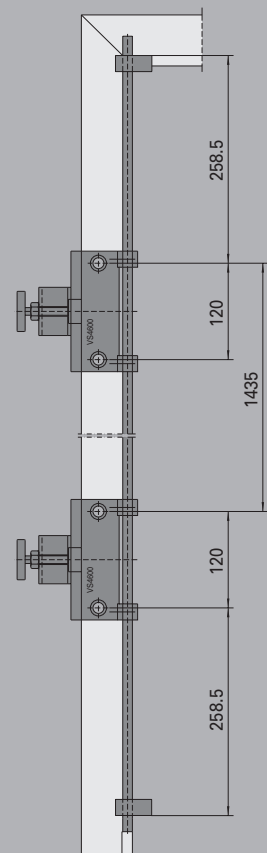
With this serial drilling jig, the frame drilling for hinge receiver VS 4600 can be made.

The jig set consists of:

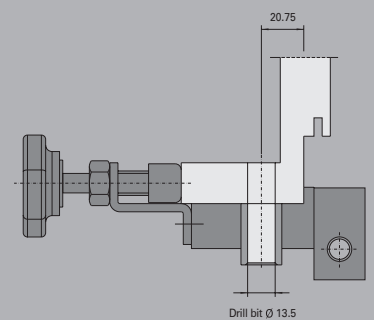
- 2 drilling jigs
- 1 connecting rod 12 x 2200 mm
- 2 stops
- 1 drill bit \varnothing 13.5 mm
- 1 fitting instruction

Fitting steps:

1. Clamp drilling jig on frame. The clearance on the hinge side is given by the jig.
2. Drill holes with drill bit \varnothing 13.5 mm.
3. Assemble hinge receiver VS 4600 on casing frame and screw in frame parts.
4. Hang-on door.



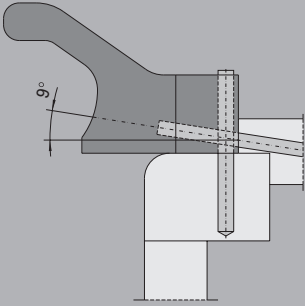
Dimensions according to DIN 18101



To be used for:

- VS 3739 VN 3748/160
- VS 3749
- VS 3739 S
- VN 3738/160
- VN 3738/160 FD
- VN 3738/160 S
- VN 3738/160 FD S

When ordering drilling jig, please specify width of frame-lining.



Universal drilling jig 8/10

Compact drilling jig made of solid light metal with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 4.5 mm
- 1 drill bit Ø 5.0 mm
- 1 set ring
- 1 wind-in cup Ø 8 mm
- 1 wind-in cup Ø 10 mm
- 1 fitting instruction

Fitting steps:

1. Verify that the handle of the drilling jig is correctly fitted. The drilling bushes to be used must be on **the right of the handle**. If not, refit handle.
2. Place sash in frame, pull completely to hinge side and clamp. The clearance of 3 mm on the hinge side is given by the jig.
3. Determine hinge position, place on drilling jig and drill holes for threaded pins.
4. Remove sash and screw in frame and sash parts by using wind-in crank or electric drill.
5. Align hinge parts and hang-on sash.

To be used for:

- A 1-8
- A 1-10
- B 1-8
- B 1-10

Note:

See page 70 for jig connector

Universal drilling jig 13/15

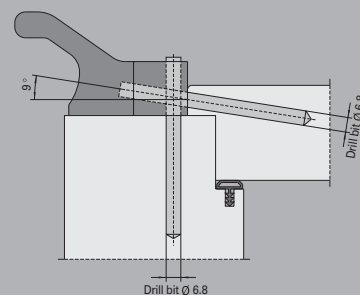
Compact drilling jig made of solid light metal with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 6.8 mm
- 1 set ring
- 1 wind-in cup Ø 13 mm
- 1 wind-in cup Ø 15 mm
- 1 fitting instruction

Fitting steps:

1. Verify that the handle of the drilling jig is correctly fitted. The drilling bushes to be used must be on **the right of the handle**. If not, refit handle.
2. Place sash in frame, pull completely to hinge side and clamp. The clearance of 3 mm on the hinge side is given by the jig.
3. Determine hinge position, place on drilling jig and drill holes for threaded pins.
4. Remove sash and screw in frame and sash parts by using wind-in crank or electric drill.
5. Align hinge parts and hang-on sash.



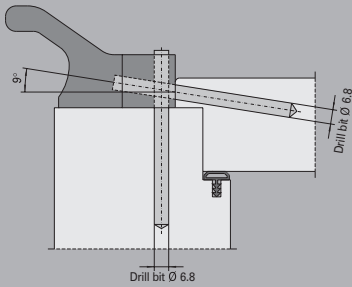
To be used for:

V 3120 (WF)	A 1-13	B 2-15
V 3220 (WF)	A 2-13	C 1-15 WF
V 3420 (WF)*	A 1-15	C 2-15 WF
V 5135*	A 2-15	
V 5150*	B 1-13	
V 8550*	B 1K-13	
	B 1-15	

* only for use with receiver

Note:

See page 70 for jig connector



PA drilling jig 13/15

Solid drilling jig made of high-quality material with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 6.8 mm
- 1 set ring
- 1 wind-in cup Ø 13 mm
- 1 wind-in cup Ø 15 mm
- 1 fitting instruction

Fitting steps:

1. Place sash in frame, pull completely to hinge side and clamp. The clearance of 3 mm is given by the jig.
2. Determine hinge position, place on drilling jig and drill holes for threaded pins.
3. Remove sash and screw in frame and sash parts with wind-in crank or electric drill.
4. Align hinge parts and hang-on sash.

Note:

See page 70 for jig connector

To be used for:

- | | |
|---------|-----------|
| A 1-13 | B 2-15 |
| A 2-13 | C 1-15 WF |
| A 1-15 | C 2-15 WF |
| A 2-15 | |
| B 1-13 | |
| B 1K-13 | |
| B 1-15 | |

PA drilling jig 20

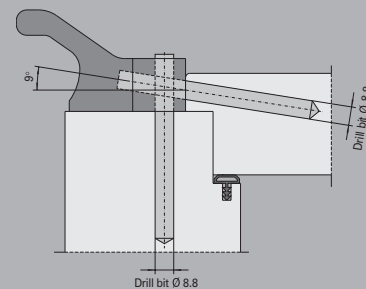
Solid drilling jig made of high-quality material with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 8.8 mm
- 1 set ring
- 1 wind-in cup Ø 20 mm
- 1 fitting instruction

Fitting steps:

1. Place sash in frame, pull completely to hinge side and clamp. The clearance of 3 mm is given by the jig.
2. Determine hinge position, place on drilling jig and drill holes for threaded pins.
3. Remove sash and screw in frame and sash parts with wind-in crank or electric drill.
4. Align hinge parts and hang-on sash.



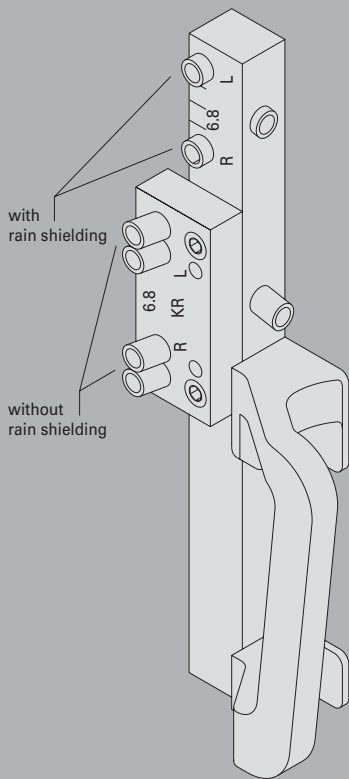
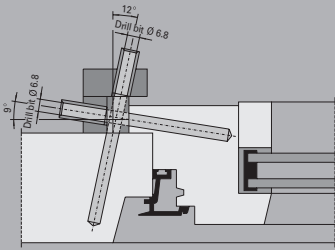
To be used for:

C 1-20 WF

C 2-20 WF

Note:

See page 70 for jig connector



Drilling jig KR

The BAKA drilling jig KR is designed specially for tilting sash windows with or without rain shielding.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 6.8 mm
- 1 set ring
- 1 wind-in cup Ø 13 mm
- 1 wind-in cup Ø 15 mm
- 1 fitting instruction

Fitting steps:

1. Clamp sash to the frame on the hinge side without spacer bloc. The clearance of 3 mm on the hinge side is given by the jig.
2. Determine hinge position and carry through drilling
3. The drilling pattern with attached drilling plate applies for windows **with** rain shielding when the frame pins need to be drilled diagonally. The right drilling pattern applies for tilting windows **without** rain shielding for C 1-13 and C 3-15 by vertical drilling of frame pins. The drilling must be made at one jig position.
4. Remove sash and screw in frame and sash parts with wind-in crank or electric drill.
5. Hang-on sash.

Note:

See page 70 for jig connector

To be used for:

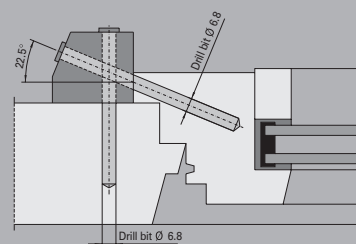
- C 1-13
- C 1-15 WF (for diagonal drilling only)
- C 3-15

Drilling jig C 5-15

The BAKA drilling jig C 5-15 is designed specially for lift-off tilting sash hinge BAKA C 5-15.

The jig set consists of:

- 1 drilling jig
- 1 drill bit \varnothing 6.8 mm
- 1 set ring
- 1 wind-in cup \varnothing 15 mm
- 1 fitting instruction



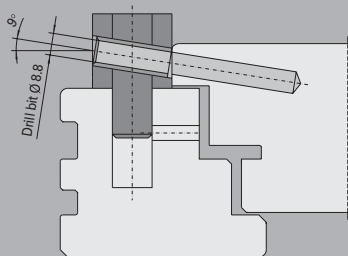
Fitting steps:

1. Clamp sash to the frame on the hinge side without spacer bloc. The clearance of 3 mm on the hinge side is given by the jig.
2. Determine hinge position.
3. Place drilling jig on the frame and press firmly to the overlap. Carry through drilling.
4. Remove sash and screw in frame and sash parts with wind-in crank or electric drill.
5. Hang-on sash.

To be used for:

C 5-15

A special jig is required for hinge C 5-15/18.5.



Drilling jig BAKA 3D 20 sash

With drilling jig BAKA 3D 20 sash, the sash drilling can be carried through specially for BAKA 3D 20.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 8.8 mm
- 1 set ring
- 1 wind-in cup Ø 20 mm
- 1 fitting instruction

Fitting steps:

1. Mill slots and drill holes in frame by using BAKA drilling/milling jig 3D 20.
2. Fix drilling jig BAKA 3D 20 sash in milling slot.
3. Place sash in frame, pull completely to hinge side and clamp.
4. Drill sash holes with drill bit Ø 8.8 mm, screw in sash parts with wind-in crank or electric drill.
5. Align hinge parts and hang-on sash.

To be used for:
BAKA 3D 20 A

Serial drilling jig sash 20

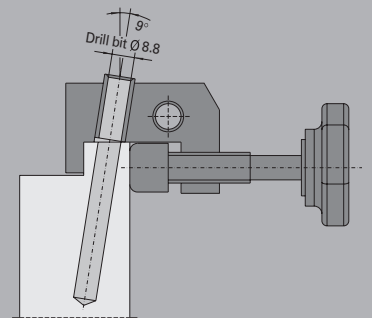
With this drilling jig, entrance doors can be drilled separately.

The jig set consists of:

- 3 drilling jigs
- 1 connecting rod 12 x 2200 mm
- 2 swivelling stops
- 1 drill bit \varnothing 8.8 mm
- 1 set ring
- 1 wind-in cup \varnothing 20 mm
- 1 fitting instruction

Fitting steps:

1. Push drilling jigs and stops onto connecting rod.
2. Align 1. stop to upper door rebate and fasten.
3. Adjust all drilling jigs to the position as requested and fasten also.
4. Fix 2. stop at the same distance from the lower drilling jig as the first stop from the upper drilling jig. The jig is thereby adjusted for right- and left-hand application.
5. Transfer adjustment measures to frame jig.



To be used for:

C 1-20 WF

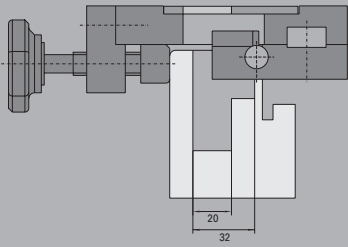
C 2-20 WF

BAKA 3D 20 A

Note:

Individual drilling jigs for the application of other hinges are available on request.

The drilling jig is suitable for overlap thicknesses up to max. 22 mm and produces a clearance of 3 mm in connection with the frame jig.



Milling jig BAKA 2D 20 sash

With the milling jig BAKA 2D 20 sash, the sash slots can be milled for the hinges listed below.

The jig set consists of:

- 1 milling jig
- 1 milling template 2D 20 sash 20/30
- 1 fitting instruction

Fitting steps:

1. Clamp milling jig on sash, insert milling template and mill 1st slot.
2. Shift milling template in the milling jig and mill 2nd slot.
3. After milling release the quick-release clamp and remove milling jig.
cutter: \varnothing 20 mm
collar ring: \varnothing 30 mm

To be used for:

- BAKA 2D 20
- BAKA 2D 20 FD
- BAKA 3D 20 Plus
- BAKA 3D 20 FD Plus
- BAKA protect 3D
- BAKA protect 3D FD

Note:

Templates for the following combinations (cutter/collar ring) are also available as accessories:
milling template 2D 20 sash 16/30
milling template 2D 20 sash 16/27
milling template 2D 20 sash 20/27

Ball bearing location milling jig 2D 20 sash

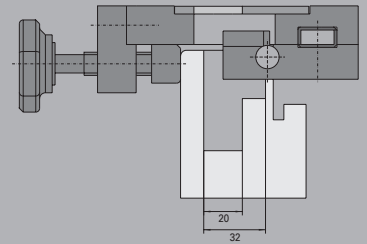
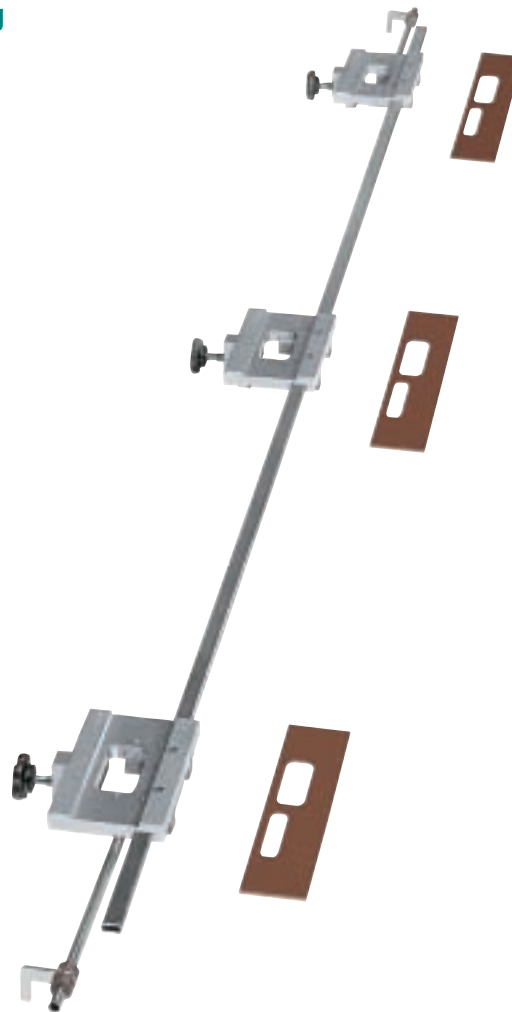
With this ball bearing location milling jig, entrance doors can be fitted rationally. Simple jig adjustment without measuring by means of ball bearing location catches. This serial jig can be used for right- and left-hand application due to swivelling stops.

The jig set consists of:

- 3 milling jigs
- 3 milling templates 2D 20 sash 20/30
- 1 square tube with ball bearing location catch
- 2 end stops
- 1 fitting instruction

Fitting steps:

1. The end stops must be adjusted separately for right- and left-hand and then are to be placed in the sash rebate.
2. Adjust BAKA ball bearing location milling jig 2D 20 sash to the frame jig.
3. Clamp ball bearing location milling jig on profile and mill 1st slot.
4. Shift milling templates in milling jigs and mill 2nd slots.
5. After milling release the quick-release clamp and remove ball bearing location milling jig.
 - cutter: \varnothing 20 mm
 - collar ring: \varnothing 30 mm



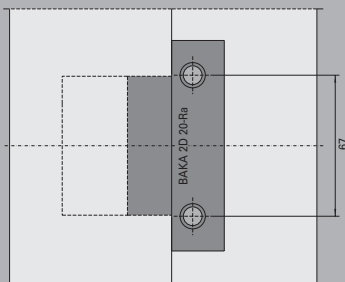
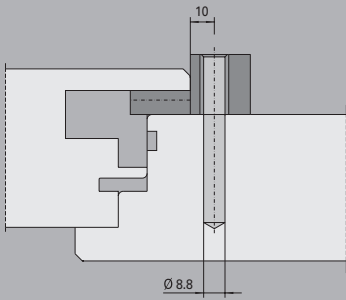
To be used for:

- BAKA 2D 20
- BAKA 2D 20 FD
- BAKA 3D 20 Plus
- BAKA 3D 20 FD Plus
- BAKA protect 3D
- BAKA protect 3D FD

Note:

Templates for the following combinations (cutter/collar ring) are also available as accessories:

- milling template 2D 20 sash 16/30
- milling template 2D 20 sash 16/27
- milling template 2D 20 sash 20/27



Plug-in drilling jig 2D 20 (FD) frame

With this drilling jig, the frame drilling for the hinges listed below can be made.

The jig set consists of:

- 1 drilling jig
- 1 drill bit \varnothing 8.8 mm
- 1 set ring
- 1 wind-in cup \varnothing 20 mm
- 1 fitting instruction

Fitting steps:

1. Determine hinge position on sash. Mill slot in sash with BAKA milling jig 2D 20.
2. Place sash in frame. The clearance of 4 mm on the hinge side is given by the jig.
3. Fix BAKA plug-in jig 2D 20 frame in the milling slot and drill frame holes.
Remove sash from frame, screw in frame parts according to required compression and align vertically, fasten sash part BAKA 2D 20 in milling slot. Insert sash and install pin.
4. For doors with sash acoustic seal (in the overlap), drilling jig and hinge type BAKA 2D 20 FD are required.
The installation is identical with BAKA 2D 20.
The seal is threaded through the receiver of the sash part.

To be used for:

- BAKA 2D 20
- BAKA 2D 20 FD

Please indicate hinge type at time of order!

Ball bearing location drilling jig frame 20

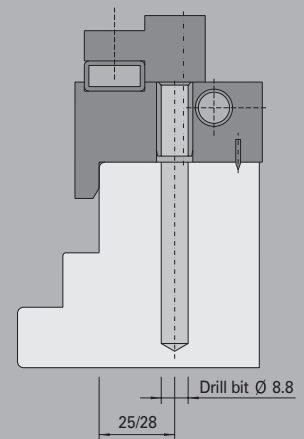
With this drilling jig, entrance door frames
can be drilled separately.

The jig set consists of:

- 3 drilling jigs
- 1 square tube with ball bearing location catch
- 2 stops
- 1 drill bit Ø 8.8 mm
- 1 set ring
- 1 wind-in cup Ø 20 mm
- 1 fitting instruction

Fitting steps:

1. The end stops must be adjusted separately for right- or left-hand and then are to be placed in the frame rebate.
2. Adjust ball bearing location drilling jig to sash jig.
3. Clamp ball bearing location drilling jig on profile. The clearance of 4 mm on the hinge side is given by the jig.
4. Carry through drilling (drill bit Ø 8.8 mm).
5. Screw in frame parts according to required compression and align vertically.
6. Insert sash and install pin.



To be used for:

C 1-20 WF

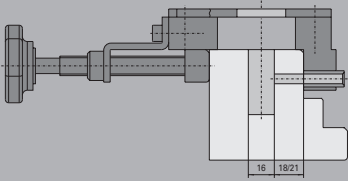
C 2-20 WF

BAKA 2D 20

BAKA 2D 20 FD

Note:

Individual drilling jigs for the application of other hinges are available on request.



Drilling/milling jig 3D 20 frame

With this drilling/milling jig, the 5 rebate holes and the milling slot can be made for the hinges listed below.

The jig set consists of:

- 1 drilling/milling jig
- 1 drill bit Ø 6.0 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. Determine hinge position.
2. Clamp drilling/milling jig on frame.
The clearance of 4 mm on the hinge side is given by the jig.
3. Drill frame holes (drill bit Ø 6.0 mm).
4. Mill slot with:
cutter: Ø 16 mm
collar ring: Ø 30 mm
5. Insert receiver and fix with fastening pins.

Note:

Overlap width 15 mm:
BAKA drilling/milling jig
3D 20 frame/15

Overlap width 18 mm:
BAKA drilling/milling jig
3D 20 frame/18

To be used for:

- BAKA 3D 20 A
- BAKA 3D 20 Plus
- BAKA 3D 20 FD Plus

Ball bearing location drilling/milling jig 3D 20 frame

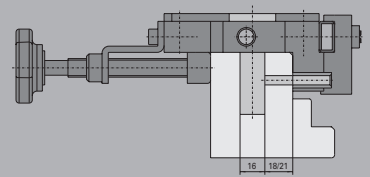
With this serial drilling/milling jig, the 5 rebate holes and the milling slots can be made for the hinges listed below. Simple jig adjustment without measuring due to ball bearing location catches.

The jig set consists of:

- 3 drilling/milling jigs
- 1 square tube with ball bearing location catch
- 2 stops
- 1 drill bit \varnothing 6.0 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. The end stops must be adjusted separately for right- and left-hand and then are to be placed in the frame rebate.
2. Adjust ball bearing location drilling/milling jig to sash jig.
3. Clamp ball bearing location drilling/milling jig on timber profile. The clearance of 4 mm on the hinge side is given by the jig.
4. Drill frame holes (drill bit \varnothing 6.0 mm).
5. Mill slot with:
 - cutter: \varnothing 16 mm
 - collar ring: \varnothing 30 mm
6. Insert receivers and fix with fastening pins.



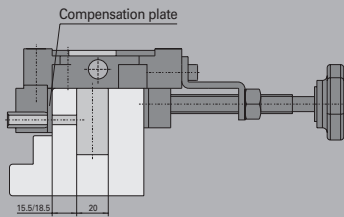
To be used for:

- BAKA 3D 20 A
- BAKA 3D 20 Plus
- BAKA 3D 20 FD Plus

Note:

Overlap width 15 mm:
BAKA ball bearing location
drilling/milling jig 3D 20 frame/15

Overlap width 18 mm:
BAKA ball bearing location
drilling/milling jig 3D 20 frame/18



Drilling/milling jig protect frame

With this drilling/milling jig, the 5 rebate holes and the milling slot can be made for the hinges listed below.

The jig set consists of:

- 1 drilling/milling jig
- 1 milling template protect frame 20/30
- 1 drill bit Ø 6.0 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. Determine hinge position.
2. The serial drilling/milling jig is designed for an overlap width of **15 mm**. For **18 mm** overlap width, remove the compensation plate (see cross-section).
3. Clamp drilling/milling jig on the frame profile. The clearance of 4 mm on the hinge side is given by the jig.
4. Drill frame holes (drill bit Ø 6.0 mm).
5. Mill slot with:
 - cutter: Ø 20 mm
 - collar ring: Ø 30 mm.
6. Insert receiver and fix with fastening pins.

To be used for:

BAKA protect 3D

BAKA protect 3D FD

Note:

Templates for the following combinations (cutter/collar ring) are also available as accessories:
 milling template protect 3D frame 16/30
 milling template protect 3D frame 16/27
 milling template protect 3D frame 20/27

Ball bearing location drilling/milling jig protect frame

With this serial drilling/milling jig, the 5 rebate holes and the slots can be made for the hinges listed below. Simple jig adjustment without measuring by means of ball bearing location catches.

The jig set consists of:

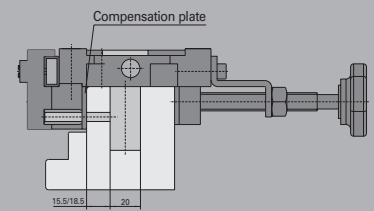
- 3 drilling/milling jigs
- 3 milling templates protect frame 20/30
- 1 connecting square tube with ball bearing location catch
- 2 end stops
- 1 drill bit \varnothing 6.0 mm
- 1 set ring
- 1 fitting instruction

Fitting steps:

1. The end stops must be adjusted separately for right- and left-hand and then are to be placed in the frame rebate.
2. The serial drilling/milling jig is designed for an overlap width of **15 mm**. For **18 mm** overlap width, remove the compensation plate (see cross-section).
3. Adjust ball bearing location drilling/milling jig to sash jig.
4. Clamp ball bearing location drilling/milling jig to the workpiece. The clearance of 4 mm on the hinge side is given by the jig.
5. Drill frame holes (drill bit \varnothing 6.0 mm).
6. Mill slot with:
 - cutter: \varnothing 20 mm
 - collar ring: \varnothing 30 mm.
7. Insert receivers and fix with fastening pins.

To be used for:

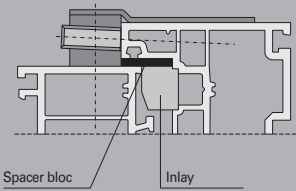
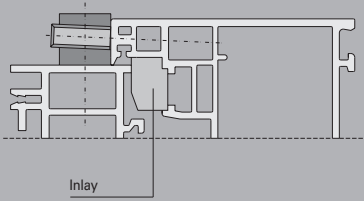
- BAKA protect 3D
- BAKA protect 3D FD



Note:

Templates for the following combinations (cutter/collar ring) are also available as accessories:

- milling template protect 3D frame 16/30
- milling template protect 3D frame 16/27
- milling template protect 3D frame 20/27



Drilling jig for hinges on PVCu profiles

With these drilling jigs, the drilling can be made for the combination of the corresponding PVCu profile and the associated hinge.

The jig set consists of:

- 1 drilling jig
- required drill bits
- 1 fitting instruction

Fitting steps:

1. Place sash in frame.
2. Apply spacer blocs for the required clearance as prescribed by the profile manufacturer.
3. In case the overlap is not placed on the frame surface due to the sealing, corresponding inlays must be inserted between overlap and frame.
4. Determine hinge position and drill holes.
5. Screw-on or screw-in hinges.

Note:

The drilling jigs must be adjoined to the PVCu profile and the individual hinge (see pages 18-21).

The drilling jigs can also be equipped with a stop-plate on request. The plate is placed on the sash for drilling.

See page 70 for jig connector

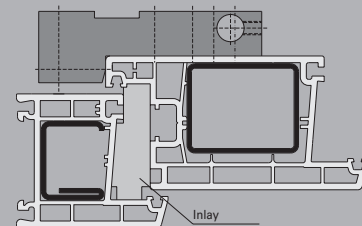
To be used for:
all K-hinges

Drilling jig simultaneous fitting

Solid drilling jig made of high-quality, fibreglass reinforced material with long-life, hardened steel bushes for simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 5 mm
- 1 Allen key SW 4 (blind plugs)
- 1 fitting instruction



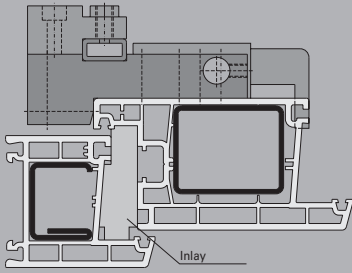
Fitting steps:

1. Place sash in frame. Apply spacer blocs for the clearance as prescribed by the profile manufacturer.
2. Determine hinge position and clamp drilling jig.
3. Drill holes by using drill bit Ø 5 mm.

To be used for:

K 1010	K 2020
K 1110	K 2120
K 1015	K 2025
K 1115	K 2125
K 1210	
K 1215	

Please indicate the hinge type at time of order!



Ball bearing location drilling jig simultaneous fitting

With this serial drilling jig the door leaf and frame can be fitted rationally and simultaneously. A rugged square tube connects 3 solid drilling jigs with integrated ball bearing location catch, automatically fixing the position. Applicable for right- and left-hand.

The jig set consists of:

- 3 drilling jigs
- 6 eye bolts
- 1 square tube
- 2 end stops
- 1 drill bit Ø 5 mm
- 1 Allen key SW 4 (blind plugs)
- 1 fitting instruction

Fitting steps:

1. Adjust the end stops so that they are the same in relation to the top and bottom jig. The jig can now be used for right- and left-hand.
2. Adjust the 3 drilling jigs individually according to the ball bearing location catch on the square tube.
3. Place sash in frame and apply spacer blocs for the clearance as prescribed by the profile manufacturer.
4. Position and clamp serial jig on sash.
5. Drill holes by using drill bit Ø 5 mm.

To be used for:

K 1010	K 2025
K 1110	K 2120
K 1015	K 2025
K 1115	K 2125
K 1210	
K 1215	

Please indicate the hinge type at time of order!

Ball bearing location drilling jig separate fitting

With this serial drilling jig the door leaf and frame can be fitted separately. A rugged square tube connects 3 solid drilling jigs with integrated ball bearing location catch, automatically fixing the position.

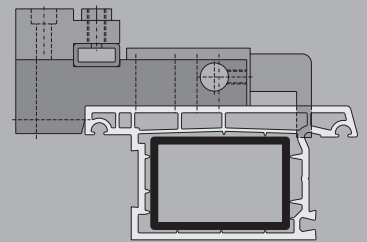
Applicable for right- and left-hand.

The jig set consists of 2 drilling jigs each with:

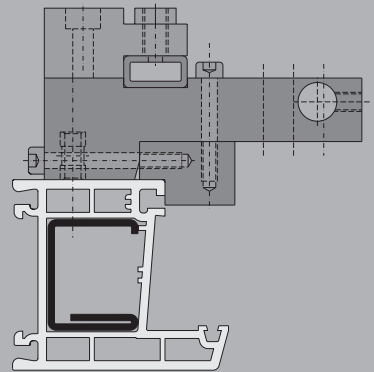
- 3 drilling jigs
- 6 eye bolts
- 1 square tube
- 2 end stops
- 1 drill bit Ø 5 mm
- 1 Allen key SW 4 (blind plugs)
- 1 fitting instruction

Fitting steps:

1. Adjust the end stops so that they are the same in relation to the top and bottom jig. The jigs can now be used for right- and left-hand.
2. Adjust the 3 drilling jigs individually according to the ball bearing location catch on the square tube.
3. Position and clamp sash jig on sash.
4. Drill sash by using drill bit Ø 5 mm.
5. Position and clamp frame jig on frame.
6. Drill frame by using drill bit Ø 5 mm.



sash



frame

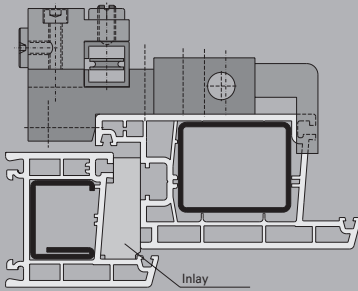
To be used for:

K 1010	K 2025
K 1110	K 2120
K 1015	K 2025
K 1115	K 2125
K 1210	
K 1215	

Note:

Please specify profile system when ordering the frame jig!

Please indicate the hinge type at time of order!



Telescope serial drilling jig simultaneous fitting

With this telescope serial drilling jig the door leafs and frames can be fitted rationally. The middle drilling jig is centred automatically by a pulley mechanism. Applicable for right- and left-hand.

The jig set consists of:

- 3 drilling jigs
- 6 eye bolts
- 1 square tube with pulley mechanism
- 2 end stops
- 1 drill bit Ø 5 mm
- 1 Allen key SW 4 (blind plugs)
- 1 fitting instruction

Fitting steps:

1. Adjust the outer end stops so that they are the same in relation to the top and bottom jig. The jig can now be used for right- and left-hand.
2. Place sash in frame and apply spacer blocs for the clearance as prescribed by the profile manufacturer.
3. Place telescope serial drilling jig on door leaf and slide the outer drilling jigs so that the stops lie against the top and bottom of the sash. (middle drilling jig is centred automatically.)
4. Clamp telescope serial drilling jig and drill holes by using drill bit Ø 5 mm.

To be used for:

K 1010	K 2020
K 1110	K 2120
K 1015	K 2025
K 1115	K 2125
K 1210	
K 1215	

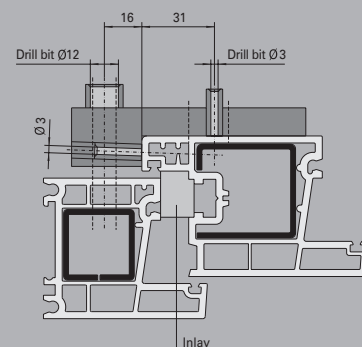
Please indicate the hinge type at time of order!

Drilling jig VN 3030 simultaneous fitting

Compact drilling jig made of solid light metal with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 12.0 mm
- 1 drill bit Ø 3.0 mm
- 1 Allen key 3 mm
- 1 Allen key 4 mm
- 1 fitting instruction

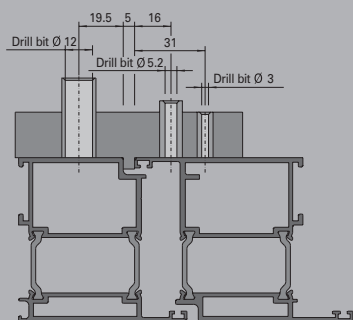


Fitting steps:

1. Place sash in frame. Insert spacer bloc for the clearance on the hinge side.
2. Determine hinge position, clamp-on drilling jig and drill holes.
3. Install frame and sash part. Tighten clamping screws.
4. Hang-on door.

To be used for:

Multi 3D hinge VN 3030



Drilling jig VN 3041 simultaneous fitting

Compact drilling jig made of solid light metal with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 12.0 mm
- 1 drill bit Ø 5.2 mm
- 1 drill bit Ø 3.0 mm
- 1 Allen key 3 mm
- 1 Allen key 4 mm
- 1 fitting instruction

Fitting steps:

1. Place sash in frame.
2. Determine hinge position, fix drilling jig by means of attached pins between sash and frame and drill holes.
3. Install frame and sash part. Tighten clamping screws.
4. Hang-on door.

To be used for:

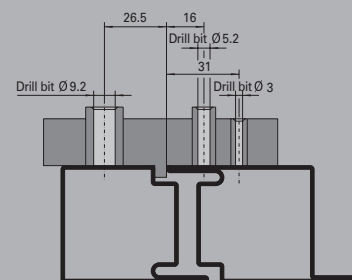
Multi 3D hinge VN 3041

Drilling jig VN 5046 simultaneous fitting

Compact drilling jig made of solid light metal with long-life, hardened steel bushes for fast simultaneous fitting.

The jig set consists of:

- 1 drilling jig
- 1 drill bit Ø 9.2 mm
- 1 drill bit Ø 5.2 mm
- 1 drill bit Ø 3.0 mm
- 1 Allen key 4 mm
- 1 fitting instruction



Fitting steps:

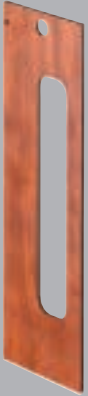
1. Place sash in frame.
2. Determine hinge position, fix drilling jig by means of attached pins between sash and frame and drill holes.
3. Install frame and sash part. Tighten clamping screws.
4. Hang-on door.

To be used for:

Multi 2D hinge VN 5046

Note:

Special drilling jig required for stainless steel profiles.



Milling template, single



Milling template, double

Note:

The milling templates must be ordered separately for each respective hinge.



Milling frame no. 118

The milling frame is a universal fixing aid for numerous fittings. Slots can be milled accurately for a particular hinge with the associated, special milling template.

The jig set consists of:

- 1 milling frame no. 118
- 2 side stops
- 1 clamping wheel

Fitting steps:

1. Slide the required milling template into the milling frame and fasten with the operating lever.
2. Adjust the side stops to the specified measure (see label on template, e.g.: strip 43 angle 23).
3. Clamp the milling frame to the workpiece and mill the slot.
4. The double milling template is moved forward by releasing the operating lever.
5. After milling, release the quick-release clamp and remove the milling frame.

To be used for:

all SIMONSWERK

- mill-in hinges
- receivers
- door bolts

Serial milling jig

With this milling jig, doors and windows can be fitted rationally and separately. Several milling frames can be connected with a robust tube. This serial jig can be used for right- and left-hand due to swivelling stops.

The jig set consists of:

- Milling frame no. 118
(the number of milling frames must be specified)
- 1 connecting tube 12 x 2200 mm
 - 2 end stops

Fitting steps:

1. Adjust both milling jigs to the desired position of the slots and fasten.
2. The stops must be adjusted individually to right- and left-hand.
3. The end stops are 3 mm thick and can therefore be used for the clearance.
4. For further fitting steps, see page 68 (milling frame no. 118).

To be used for:

- all SIMONSWERK**
- mill-in hinges
 - receivers
 - door bolts



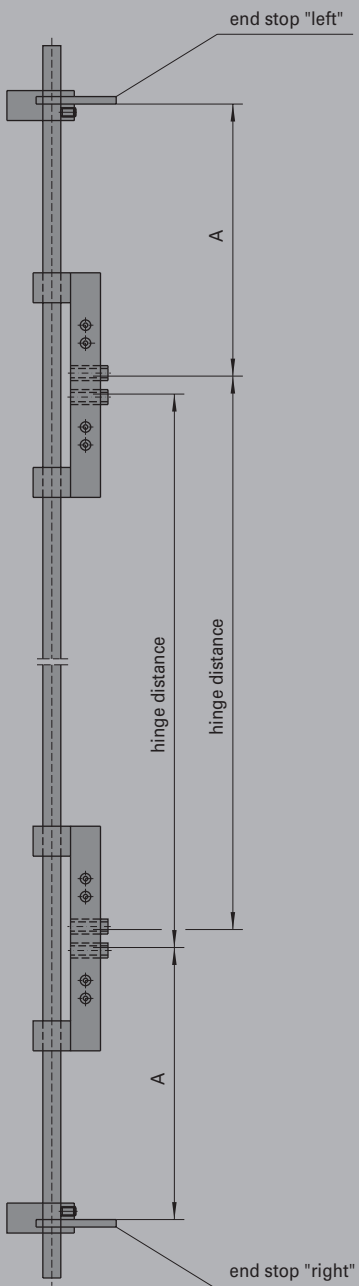
Milling template, single



Milling template, double

Note:

The milling templates must be ordered separately for each respective hinge.



Note:

One set is designed for 2 drilling jigs.

For further drilling jigs, 2 eye bolts each must also be ordered.



Jig connector

The jig connector is used to combine several drilling jigs and two stops on a tube to make up a serial jig and thereby to drill the hinge bores at the same vertical position in large series production.

The jig set consists of:

- 1 connecting tube 12 x 2200 mm
- 4 eye bolts for 2 drilling jigs
- 2 swivelling stops
- 1 fitting instruction

Fitting steps:

1. Screw the eye bolts to the drilling jigs and connect with the tube.
The drilling bushes to be used must be placed to the right or centre of the two eye bolts. Before a stop block is pushed onto each end of the tube, the swivelling stops must be combined with the stop blocks. When the stop is now fastened to the tube, the stop wings remain slewable.
Starting with one stop wing, adjust the drilling jigs to the desired hinge intervals and fasten.
As viewed from the last drilling jig, adjust the 2nd stop to the same distance "A" as the first stop, by which the drilling patterns for "right- or left-hand" must be taken into account (see drawing).
2. Place jig on the frame and press the drilling jigs firmly to the overlap. Ensure that the respective stop wings are in contact with the upper overlap of the door leaf. Fold back the stop wing which is not required. Drill all holes in one position of the jig, considering "right- or left-hand".

To be used for:

- all universal drilling jigs
- all K-drilling jigs
- BAKA PA drilling jig 13/15
- BAKA PA drilling jig 20
- VARIANT PA drilling jig

Blind rivet tongs GBM 30

With this special blind rivet tongs, the retrofitting receiver blind rivet nut M 10 is retrofitted to steel frames existing in buildings.

Fitting steps:

1. Close tongs completely.
2. Set threaded sleeve with scale to "zero" (red marking line is zero position).
3. Set the threaded sleeve with scale to the specified stroke (see nut pack), e.g. M 10 x 12 x 16 - 5 - 5.5; 3 1/4 revolutions; fasten threaded sleeve firmly with counternut.
4. Open tongs completely. Pull out drill spindle completely.
5. Press blind rivet nut with the head end to the threaded mandrel and hold firmly. Then push in the drill spindle, by which the blind rivet nut is screwed onto the threaded mandrel. (Caution: The nut must be screwed completely on.)
6. Insert the screwed-on blind rivet nut fully into the frame bore (at right angles). Press the tongs together. Riveting is complete and the blind rivet nut is fixed.
7. The threaded mandrel is released from the fastened blind rivet nut by pulling out the drill spindle.



To be used for:

VN 3738/160	VN 4739/100
VN 3738/160 FD	VS 3700
VN 3738/160 S	V 8100 WF U
VN 3738/160 FD S	V 8000 WF U
VN 3748/160	V 4700 WF
VN 8938/160 U	
VN 8948/160 U	



Wind-in cup

With the wind-in cup, hinges can be screwed in simply and rationally without scratching the surfaces of the hinges and the respective part.

Available for knuckle diameter:

- 8 mm
- 10 mm
- 13 mm
- 15 mm
- 20 mm

The wind-in cup can be used with the wind-in crank (see page 73) or with an electric drill.

To be used for:

VARIANT hinges

BAKA drill-in hinges

K hinges

Wind-in crank

The wind-in crank is available as an accessory for the wind-in cups supplied with the drilling jigs.

The wind-in crank matches all wind-in cups with diameter 8, 10, 13, 15 and 20 mm.



To be used for:

VARIANT hinges

BAKA drill-in hinges

K hinges

Your SIMONSWERK-partner:



 **simonswerk**

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