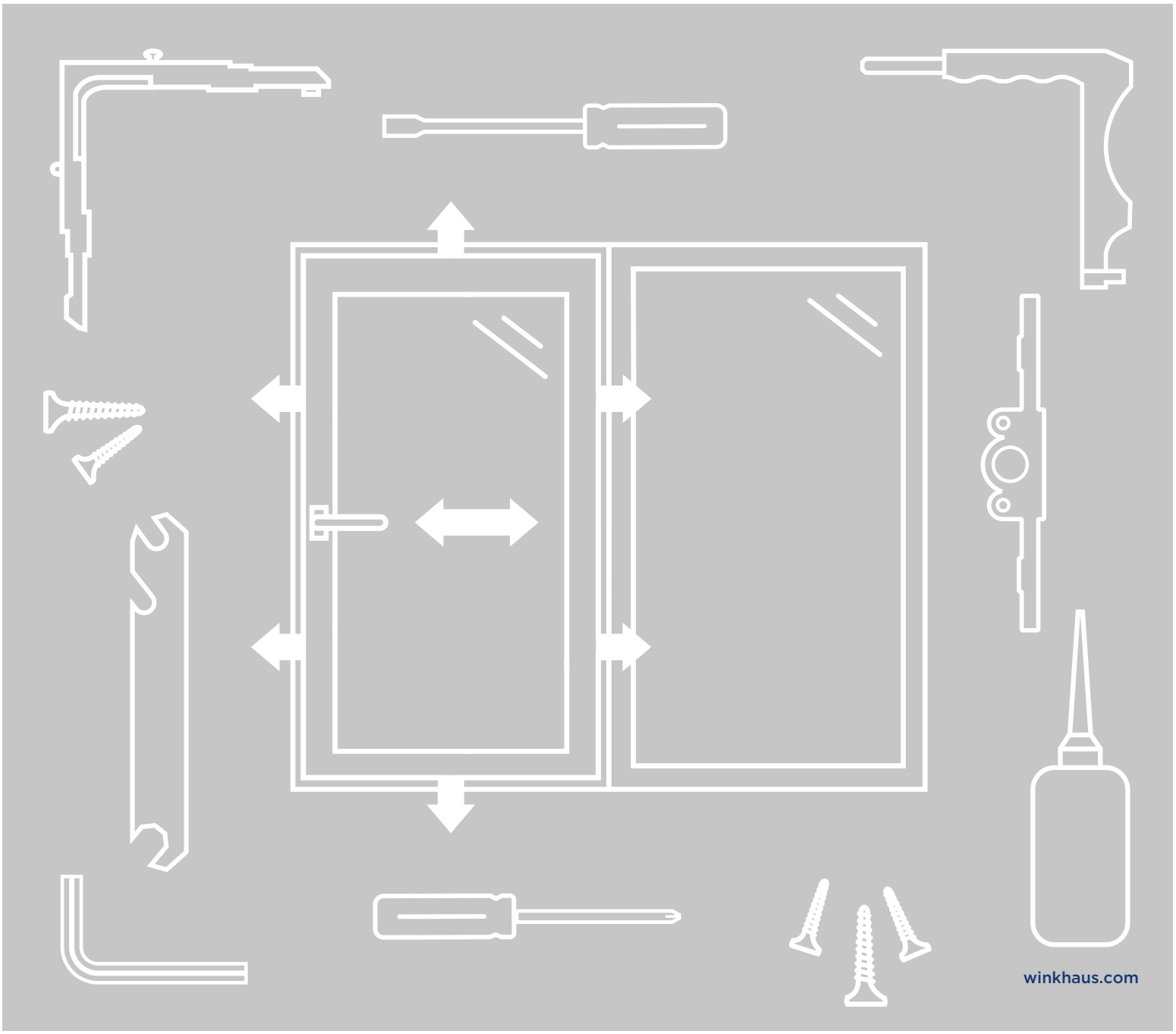
Mounting instructions
10/2026 I EN
PVC-U
For specialist companies

primePort AS

The retract-slide fitting system.



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Table of contents

1 General information 5
1.1 Information on the target group and their responsibilities 5
1.1.1 Target group description 5
1.1.2 Responsibilities of the target groups 6
1.2 About these instructions 7
1.3 Marking of notes and symbols 8
1.4 Explanation of abbreviations 9
1.5 Explanation of designations 9
1.6 Declaration of symbols 10
1.7 Manufacturer and contact 10
1.8 Other applicable documents 11
2 Safety instructions 13
2.1 General safety notices 13
2.2 Intended use 15
2.3 Use contrary to the intended purpose 15
2.4 Safe operation of sliding elements 16
2.5 Exclusion of liability 17
3 Transport 18
3.1 Advice on transport 18
3.2 Installation of transport protection 18
3.3 Dismounting of transport protection 18
4 Delivery and storage 19
4.1 Information on delivery 19
4.2 Checking the scope of delivery 19
4.3 Information on storage 19
5 Product overview 20
5.1 Technical data 20
5.2 Design variants (schematic) 21
5.3 Overview graphics and descriptions 22
6 Installation 24
6.1 Assembly information 24
6.2 Conditions for installation 25
6.3 Preparing the installation 29
6.3.1 Dimensional drawings sash profile/sash adapter rail 29
6.3.2 Dimensional drawings of gear case 30
6.4 Mounting of fittings on sash 32
6.4.1 Cutting to length of fittings (Somatec fitting punch) 32
6.4.2 Cutting to length of fittings (Reiplinger fitting punch) 35
6.4.3 Installing the central locking system for the primePort AS 200 and primePort AS 250 variants 37
6.4.4 Installation of bogies 40
6.4.5 Installing the locking devices 43
6.4.6 Installing the locking devices for the centre stile (opposite side of the drive rod) 47
6.5 Mounting of fittings on the window frame 51
6.5.1 Positions of frame parts – tabular presentation 51
6.5.2 Installing the slide rail 53
6.5.3 Installing the guide rail 54
6.5.4 Fitting the sash 56
6.5.5 Mounting of the sash profile covers 56
6.5.6 Installing the keep rail 57
6.5.7 Mounting the locking keeps on the drive side using a jig 58
6.5.8 Fitting the locking keeps on the centre stile using a jig 61
6.5.9 Installing the stoppers 63
6.5.10 Installing the anti-tilt protection device (drive side and centre stile side) 65
6.6 Adjustment 67
6.6.1 Adjust bogies in horizontal position 67
6.6.2 Octagonal bolt regulation of contact pressure 67

6.6.3 Adjusting the deadbolt ... 68
6.7 Starting operation ... 69
6.7.1 Assembly of sliding elements ... 69
6.8 Handover to the end user/builder ... 71
7 Operation ... 72
8 Cleaning and maintenance ... 73
9 Spare parts and accessories ... 76
10 Dismounting ... 77
11 Proper disposal ... 79

1 General information

1.1 Information on the target group and their responsibilities

1.1.1 Target group description

These instructions are intended for the following groups of people:

- Hardware dealers
- Manufacturers of windows and patio doors
- Component dealers/assembly companies

In addition to the information in this document, the following target groups must be included in the chain of communication:

- Builders
- Operators
- End users

Further information given by Gütegemeinschaft Schlösser und Beschläge e.V.

Further information on the target group description is provided in detail in the VHBH guideline by Gütegemeinschaft Schlösser und Beschläge in numerous languages.
The guideline **Guidelines/advice on the product and on liability (VHBH)** can be accessed at the following hyperlink:
Hardware for windows and balcony doors – Guidelines/advice on the product and on liability (VHBH)

https://www.guetegemeinschaft-schloss-beschlag.de/Pruefen-Zertifizieren/Richtlinien/VHBH/

1.1.2 Responsibilities of the target groups

Each target group must fulfil their instruction obligation without restriction.

Unless otherwise specified below, the transfer of the documents and information may take place, for example, as a printed version, via internet access or a data carrier.
According to previous case law, the documents and information intended for the end user should be made available in printed form.

Responsibility of the hardware manufacturer
The hardware manufacturer must provide the following documents to the fittings dealer or the manufacturer of windows and patio doors:

1. Catalogue
2. Operating/maintenance instructions (focus on fittings)
3. Assembly instructions for the fitting system (installation guidelines)
4. Guidelines/advice on the product and on liability (VHBH; for openable, fall-protection building elements additionally the information document ISAB)
5. Guidelines/advice for end users (VHBE)

Responsibility of the hardware dealer
The hardware dealer must provide the following documents to the manufacturer of windows and balcony doors:

1. Catalogue
2. Operating/maintenance instructions (focus on fittings)
3. Assembly instructions for the fitting system (installation guidelines)
4. Guidelines/advice on the product and on liability (VHBH; for openable, fall-protection building elements additionally the information document ISAB)
5. Guidelines/advice for end users (VHBE)

Responsibility of window and balcony door manufacturers
The manufacturer of windows and balcony doors must make the following documents available to the building element dealer or the builder, even if other subcontractors (in particular assembly companies) are acting as an intermediary:

1. Operating/maintenance instructions (focus on fittings)
2. Assembly instructions for the fitting system (installation guidelines)
3. Guidelines/advice on the product and on liability (VHBH; for openable, fall-protection building elements additionally the information document ISAB)
4. Guidelines/advice for end users (VHBE)

Responsibility of the building element dealer/assembly company
The building element dealer must pass on the following documents to the builder, even if a subcontractor (assembly company) is intermediary:

1. Operating/maintenance instructions (focus on fittings)
2. Guidelines/advice on the product and on liability (VHBH; for openable, fall-protection building elements additionally the information document ISAB)
3. Guidelines/advice for end users (VHBE)

Responsibility of the builder *
The builder must forward the following documents to the end user/operator:

1. Operating/maintenance instructions (focus on fittings)
2. Guidelines/advice for end users (VHBE)

   * The builder can also be an operator and/or end user. An operator may also be between the builder and the end user.

   Irrespective of the specific constellation of the participants “builder”, “operator” and “end user”, the communication in the information chain must ensure that the guidelines/advice for end users (VHBE) or alternatively the user instructions adapted by the window manufacturer to windows and balcony doors according to the version in question (window type) are made available!

1.2 About these instructions

These instructions ensure safe handling of the product. Observing the information in these instructions can help to prevent accidents and material damage.

Read these instructions carefully to familiarise yourself with the installation and handling of this product and to avoid errors and hazards.

These instructions are intended exclusively for the installation of Winkhaus fittings in window/door elements made of approved window materials. The information and instructions in this manual refer to the product segments, materials and target groups mentioned on the front page. The numerical assignment of the document including the issue date helps with orientation.

The chapter "Product overview" of these instructions contains important information such as technical specifications, including the maximum sash sizes and sash weights as well as article descriptions in the form of an overview graphic.

Remarks

- Read the instructions before starting any work.
- Always observe all information in these instructions, other applicable documents and the instructions on the product.
- The sequence of all steps in these instructions must be observed.

The following subchapter "Other applicable documents" lists other applicable and supplementary guidelines.

Concerning this document, please draw special attention to:

1. Product catalogues
2. Application diagrams
3. Lists of fittings
4. Product data sheets in the Winkhaus Portal

Sharing of documents and data

It must be ensured that when the product is passed on, the data in the instructions and other applicable documents are also passed on in accordance with the preceding definition "Information on the target groups and their responsibility".

Retention of documents/data access

The data in these instructions and other applicable documents are an important part of the product. The data in these instructions as well as data access to the other applicable documents must be provided or stored for future use.

Illustrations

The illustrations are provided to ensure basic understanding and may differ from the actual version that you have.

Dimensions

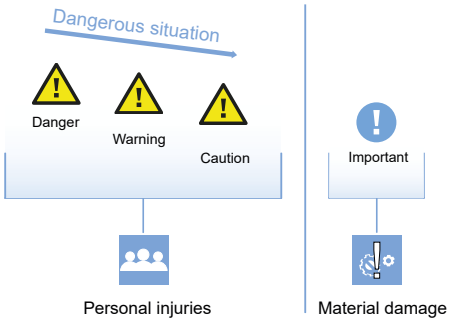
Some of the indicated dimensions are rounded measures!

1.3 Marking of notes and symbols

Basic data for safety-related information

Safety instructions in accordance with DIN EN IEC/IEEE 82079

These instructions have been developed on the basis of the basic standard of the technical documentation DIN EN IEC/IEEE 82079.
Safety instructions are identified in this guideline by a symbol and are introduced by a signal word. Obey all safety instructions and act carefully to avoid accidents, personal injury and property damage.
The figure on the right gives an overview of the safety-related information used in this manual.



Warnings and their meaning

CAUTION

This warning symbol and signal word is used to indicate a hazard with low risk, which could result in minor or moderate injury if it is not avoided.

WARNING

This warning symbol and signal word is used to identify a hazard with medium risk which, if not avoided, could result in death or serious injury.

DANGER

This warning symbol and signal word is used to identify a hazard with a high risk, which will result in death or serious injury if it is not avoided.

Other information

IMPORTANT

This symbol and signal word is used to indicate possible material damage.

This symbol highlights important additional information for efficient and trouble-free operation.

This symbol indicates useful tips and recommendations for your product.

Environment

This symbol and signal word is used to identify a possible hazard to the environment.

1.4 Explanation of abbreviations

The following abbreviations are used in this manual:

Abbreviation	Designation
D	Backset
FFB	Size-dependent fitting parts (in relation to the sash rebate width)
FFH	Size-dependent fitting parts (in relation to the sash rebate height)
GAK	Drive rod activPilot, constant handle position
GAM	Drive rod activPilot, central handle position
GAKA	Drive rod activPilot, constant handle position, lockable
GAMA	Drive rod activPilot, central handle position, lockable
max. x kg	Maximum sash weight
max. x m²	Maximum sash size
PZ lock case	Lock case for profile cylinder

1.5 Explanation of designations

The following designations are used in this manual:

Designation	Explanation
Design variants (schematic)	Describe the positioning of sliding sashes in different element versions.
Application diagram	Used to determine the permissible application range – (limitation of the sash formats for different glass thicknesses)
Softclose damper system	Damper components ensure improved and smooth sash entry from the sliding position. The external locks at the top can optionally be equipped with a softclose damper system.
Corner drive	Corner drives as central parts of the window fitting system are subjected to particularly high loads.
Guide rail	Takes over the guiding of the primePort AS sash components
Bogie	The bogies are mounted on the window sash element. They are the connecting link between the sliding sash and the slide and guide rails.
Centre stile locking device	The centre stile locking devices lock the window sash element at the central joint and generate the seal pressure in the closed position.
Opening direction	Determination of the opening direction for retract-slide elements in accordance with DIN EN 12519.
Top/bottom stopper	Is attached to the guide rail/slide rail and synchronously dampens the end position of the sliding sash when the maximum sliding opening width is reached.
Locking device	The locking devices are mounted on the window sash element. They are the connecting link between the sliding sash and the slide and guide rails and generate the seal pressure in the closed position.
Central locking system	Components from the Winkhaus activPilot modular system

1.6 Declaration of symbols

Technical content or specific information is supplemented in this documentation by various symbols.

Symbol	Usage/meaning	Symbol	Usage/meaning
	Retract-slide element		Cutting to length of a component
	Maximum sash rebate width (FFB)		Cross-reference to further information
	Maximum sash rebate height (FFH)		Hexagon socket - here size 4 mm
	Profile material PVC-U		Optional component
	Sash weights up to 200 kg		Sash weights up to 250 kg

1.7 Manufacturer and contact

Manufacturer and contact details

The manufacturer and contact details can be found on the back of this manual.

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1.8 Other applicable documents

Introduction

Further documents and documentation apply in connection with these instructions. These are listed below.

General terms and conditions of business

Unless otherwise agreed in an individual contract, all our deliveries, performances and offers are made exclusively on the basis of these General Terms and Conditions of Business and Delivery (GTC). The current General Terms and Conditions can be found on the Winkhaus homepage under the following hyperlink:
General Terms and Conditions

https://www.winkhaus.com/agb

The Winkhaus Portal

The Winkhaus Portal – versatile and practical: Our market partners can find a wide range of services with media downloads, product configurators, order management tools and much more in the Winkhaus Portal.

After entering a Winkhaus article number or designation, a data sheet download can be started. For example, relevant dimensions for assembly such as screw dimensions and positions or routing dimensions can be found here.

For the specific articles a multi-page data sheet is available in several languages:

- For download in Winkhaus Portal or on request

https://partnerportal.winkhaus.com

Guidelines of Gütegemeinschaft Schlösser und Beschläge e.V.

Gütegemeinschaft Schlösser und Beschläge e.V. publishes guidelines that provide assistance in the application of locks and hardware in windows, balcony doors and doors.

Guidelines of Gütegemeinschaft Schlösser und Beschläge e.V.
https://www.guetegemeinschaft-schloss-beschlag.de/Pruefen-Zertifizieren/Richtlinien/

The following guidelines also apply:

VHBH guideline

The guideline **Guidelines/advice on the product and on liability (VHBH)** can be accessed via the following hyperlink:
Hardware for windows and balcony doors – Guidelines/advice on the product and on liability (VHBH)
https://www.guetegemeinschaft-schloss-beschlag.de/Pruefen-Zertifizieren/Richtlinien/VHBH/

VHBE guideline

The guideline **Guidelines/advice for end users (VHBE)** can be accessed via the following hyperlink:
Hardware for windows and balcony doors – Guidelines/advice for end users (VHBE)
https://www.guetegemeinschaft-schloss-beschlag.de/Pruefen-Zertifizieren/Richtlinien/VHBE/

Verband Fenster + Fassade (Association of Window and Facade Manufacturers, Frankfurt)

Plenty of information (e.g. guidelines and data sheets) is available on the following website as a reliable source of information for manufacturers, architects, planners and builders:

Verband Fenster + Fassade
https://www.window.de

Other guidelines and standards

- The specifications of the profile manufacturers (application sizes, manufacturing specifications and processing guidelines) must be observed.
- Specifications and information of the fitting screw manufacturers
- Relevant European standards or parts thereof

2 Safety instructions

2.1 General safety notices

Introduction

These safety instructions are essential for the installation, operation and maintenance of the fitting system.

Advice on specialised staff

Assembly/repair of a fitting system requires specialist knowledge, which is why this work should only be carried out by specialists or instructed persons.

Persons involved in mounting fittings must have read and understood this fitting guide. Observe production liability information for all work with fittings. Manufacturer will accept no liability in cases of failure to comply with this guide, deployment of insufficiently qualified staff and unauthorised alterations.

Configuration of fittings

The manufacturer's instructions with regard to the composition of fittings (e. g. number of bogies to be installed per sash, number of centre stile locking devices) are mandatory.

Sash sizes and notes regarding application

The maximum sash weights for the individual fitting versions may not be exceeded. The component with the lowest permissible loading capacity determines the maximum weight of the sash. Please observe the diagrams and component installation instructions.

The graphs in the application diagrams show the permitted sash rebate height to width ratios, as determined by different weights of glass and/or overall glass thickness. The resulting sash rebate dimensions or sash formats (portrait/landscape) as well as the maximum sash weight may under no circumstances be exceeded.

Regular product maintenance

Security-relevant fitting parts are to be inspected at least once a year to check for wear and to ensure they are firmly secured in position. Fastening screws must be tightened and faulty components must be replaced as required. In addition, maintenance/cleaning work must be carried out at least once a year. All mobile parts and locking points of fittings should be greased and tested for function. Only oils and greases not affecting the materials of the fitting may be used. The only cleaning and maintenance materials to be used are those which will not adversely affect the corrosion-resistant properties of the fittings components.

For more information, see "Cleaning and maintenance", page 73.



CAUTION

Adjustment work may only be carried out by a specialist company.
Adjustment work on the fittings – especially in the area of load-bearing fitting parts – as well as the replacement of parts and mounting and removal of the opening sashes must be carried out by a specialist company.

Maintaining surface quality

- The fittings and rebate spaces must be adequately ventilated, particularly during the construction stage, so that they are not exposed to the direct effects of moisture or condensation. It must be ensured in any case by appropriate measures that there is no possibility for (permanently) humid room air to condense in the rebate area.
- The fittings must be kept free from deposits and soiling due to building materials (building dust, gypsum plaster, cement etc). Possible soiling from plaster, mortar etc. must be removed prior to bonding with water.
- Corrosive vapours (e.g. formic acid, acetic acid, ammonia, amine and ammonia compounds, aldehydes, phenols, chlorine, tannic acid etc.) combined with even a small amount of condensation can cause rapid corrosion of the fittings. Therefore, such evaporation in the area of the windows must be avoided at all costs.
- Furthermore no sealants that cure with acetic or other acids, or sealants containing any of the above-mentioned substances, must be used. Both direct contact with the sealant and vapours released from it can damage the surface.
- Only use a mild and pH neutral detergent in diluted form to clean the fittings. Under no circumstances use aggressive acidic cleaners or scouring agents containing the substances listed above.

Obligations regarding information and instructions

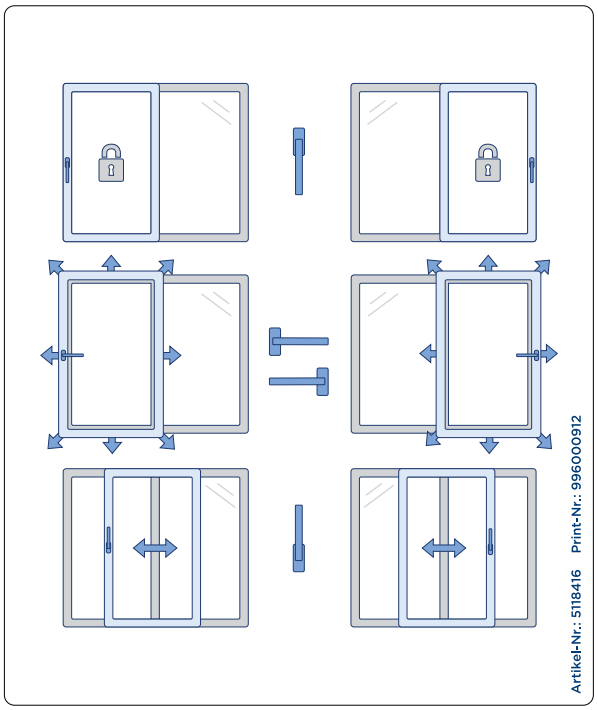
Detailed information on the implementation of the information and instruction obligations, which must be passed on via every (intermediary) dealer and processor to the end customer, as well as on the execution of maintenance work, is available on the homepage Guidelines of Gütegemeinschaft Schlösser und Beschläge e.V.in particular in the guideline VHBH, chapter “Safety”, subchapter “Instruction obligation”.

https://www.guetegemeinschaft-schloss-beschlag.de/Pruefen-Zertifizieren/Richtlinien/VHBH/

User information/operating instructions

primePort AS

An instruction sticker for operating the retract-slide element can be ordered separately. It is to be positioned on the window glass within easy reach of the end user. Further information on ordering is available from your Winkhaus contact person.



2.2 Intended use

Basic definition of sliding fittings

Sliding hardware is used for sliding sashes of windows and balcony doors which are principally used as barriers to the outside, and which are mostly glazed. In combination with the sliding sashes, fixed fields and other sashes can be arranged in a window element. Sliding hardware is equipped with a closure which locks the sliding sash. In addition, sliding hardware has rollers which are generally positioned on the lower horizontal profile-piece of the sliding sash. Projecting shears for tilting, and mechanisms for lifting or parallel positioning of the sash may be provided. The hardware is used to lock the sash, bring it into the ventilation position, and push it to the side.

Source: Guidelines of Gütegemeinschaft Schlösser und Beschläge e.V.

https://www.guetegemeinschaft-schloss-beschlag.de/Pruefen-Zertifizieren/Richtlinien/VHBH/

2.3 Use contrary to the intended purpose

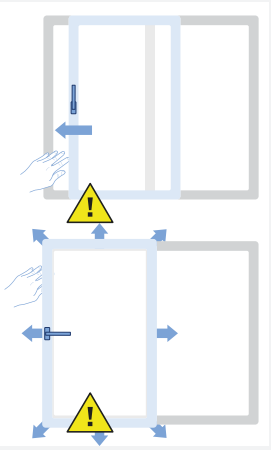
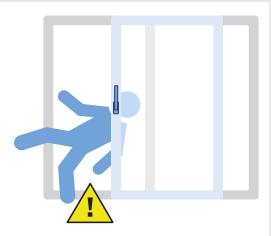
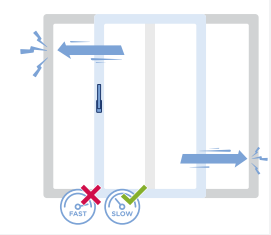
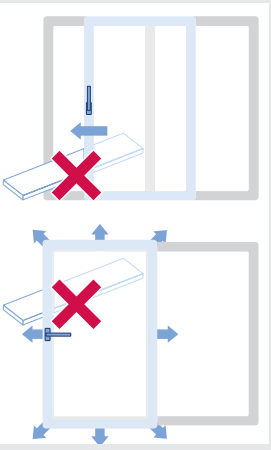
Misuse

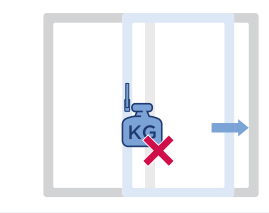
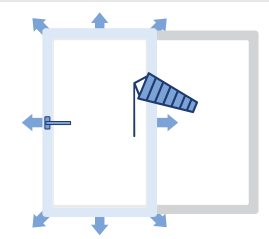
Misuse – i.e. the use of a product in a manner contrary to the intended use – of slide fittings for sashes of windows and patio doors occurs

1. if obstacles are placed in the opening area preventing the intended use.
2. if additional charges act on sashes of windows or patio doors
3. if someone grasps in the gap between the frame and sash when sliding or closing the window or if there are any persons or body parts in this area when the sash is closed.

2.4 Safe operation of sliding elements

The following safety symbols and markings and the associated warnings apply to the safe operation of windows and patio doors.

Symbol	Meaning
	**Danger of injury through trapping of body parts in the opening gap between sash and frame** • When closing windows and balcony doors, never reach between sash and frame, and always act with care. • Keep children and people who cannot estimate the dangers away from the point of danger.
	**Danger of injury from falling through open windows and balcony doors** • Behave with care near to open windows and balcony doors. • Keep children and people who cannot estimate the dangers away from the point of danger.
	**Risk of injury and material damage due to uncontrolled closing and opening of the sash.** • Make sure that the sash is guided slowly by hand over the entire movement range to the absolute closing or opening position.
	**Danger of injury and material damage from insertion of obstructions into the opening gap between sash and frame** • Do not insert obstructions into the opening gap between sash and frame.

Symbol	Meaning
	**Danger of injury and material damage from overloading the sash** • Do not place any additional load on the sash.
	**Danger of injury from the effect of wind** • Prevent wind from acting on the open sash. • During wind and drafts, close and lock windows and balcony door sashes.

2.5 Exclusion of liability

These instructions form part of the product. The manufacturer is not liable for any damage resulting from non-observance of these instructions or damage that could have been avoided by following them.

The respective complete fitting must be selected from the original Winkhaus fitting components range. Winkhaus accepts no liability if non-original or unauthorised system accessory parts are used.

CAUTION

The screw connections of the load-bearing fitting parts such as e.g. sliding rails, guide rails, bogies and locks must be adapted to accommodate the respective load situation.

IMPORTANT

Window/door frames are to be installed with appropriate pressure-resistant packers for further load transfer to the building structure.

For further information see "Assembly of sliding elements", page 69.

3 Transport

3.1 Advice on transport

In addition to the relevant information on stable and shatter-proof transport of window and door elements, the following note must be observed in particular:

IMPORTANT

Damage to Winkhaus components due to missing transport protection

Missing transport protection can cause damage to the window system and the fitting parts.

- Insert transport protection between the sash profile and the frame profile.
- Lock the window system.
- Make sure that the bogies are free of load during transport, otherwise damage may occur, especially to the rollers.
- Safe transport must be ensured within the window manufacturer's area of responsibility (if necessary, separate transport of frame and sash frame or also by means of glazing on site).

3.2 Installation of transport protection

Airgap limiters for window and door elements

Airgap limiters are available in various versions as accessories. If airgap limiters are used as transport protection, the number and positioning vary. Care should be taken here to ensure even load distribution.

3.3 Dismounting of transport protection

Removal of airgap limiters

Airgap limiters that have only been installed as transport protection must be removed after delivery of the window/door element.

For certain element designs (e.g. burglary-resistant elements), it may be necessary for airgap limiters to remain in place even after transport.

4 Delivery and storage

4.1 Information on delivery

Delivery of the goods

Details on the delivery of the goods can be found in the General Terms and Conditions of Business and Delivery (GTC) of **Aug. Winkhaus SE** at the following hyperlink:
General Terms and Conditions

https://www.winkhaus.com/agb

4.2 Checking the scope of delivery

Liability for defects

Details on liability for defects can also be found under the aforementioned hyperlink.

4.3 Information on storage

Storage of fittings

The storage location of the fitting parts must meet the following conditions:

- Protection from moisture (in particular condensation)
- Fitting parts should be stored on a level surface until installation.
- Protection against heat and sunlight
- Protection against access by unauthorised persons.

5 Product overview

5.1 Technical data

Product characteristics

primePort AS 200

Sash rebate width	510-2000 mm
Sash rebate height	510-2700 mm
Maximum sash weight	200 kg
Bogie design	Standard bogie with 2 rollers each
Opening width	8 mm
Design variants	Schematic A and C

primePort AS 250

Sash rebate width	510-2000 mm
Sash rebate height	510-2700 mm
Maximum sash weight	250 kg
Bogie design	Standard bogie with 4 rollers each
Opening width	8 mm
Design variants	Schematic A and C

Other product features

- Resistance to wind load: C5 (3000 pa)
- Seal against driving rain: A9
- Air permeability: class 4
- Corrosion class 5 (480 h)
- Burglary protection: RC2
- Secured ventilating position (handle position at 90°)

Information on sash sizes and sash weights

Observe the specifications in the application diagrams!

The graphs in the application diagrams show the permitted sash rebate height to width ratios, as determined by different weights of glass and/or overall glass thickness. The resulting sash rebate dimensions or sash formats (portrait/landscape) as well as the maximum sash weight may under no circumstances be exceeded.

Observe instructions on window profile!

You must specifically take into account information provided by the profile manufacturer or system owner when determining the maximum sash sizes and sash weights!

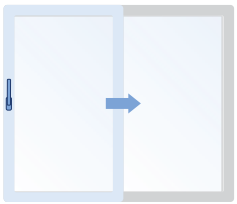
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5.2 Design variants (schematic)

Two-panel element

Schematic A

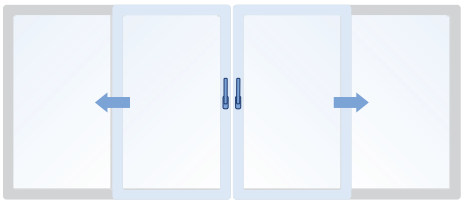
1 sliding sash (left or right), glazed frame:



Four-panel element

Schematic C

2 sliding sashes (left and right), glazed frame:
(also for elements without fixed window posts)



Three-panel element

Schematic K

2 sliding sashes (left and right), glazed frame:

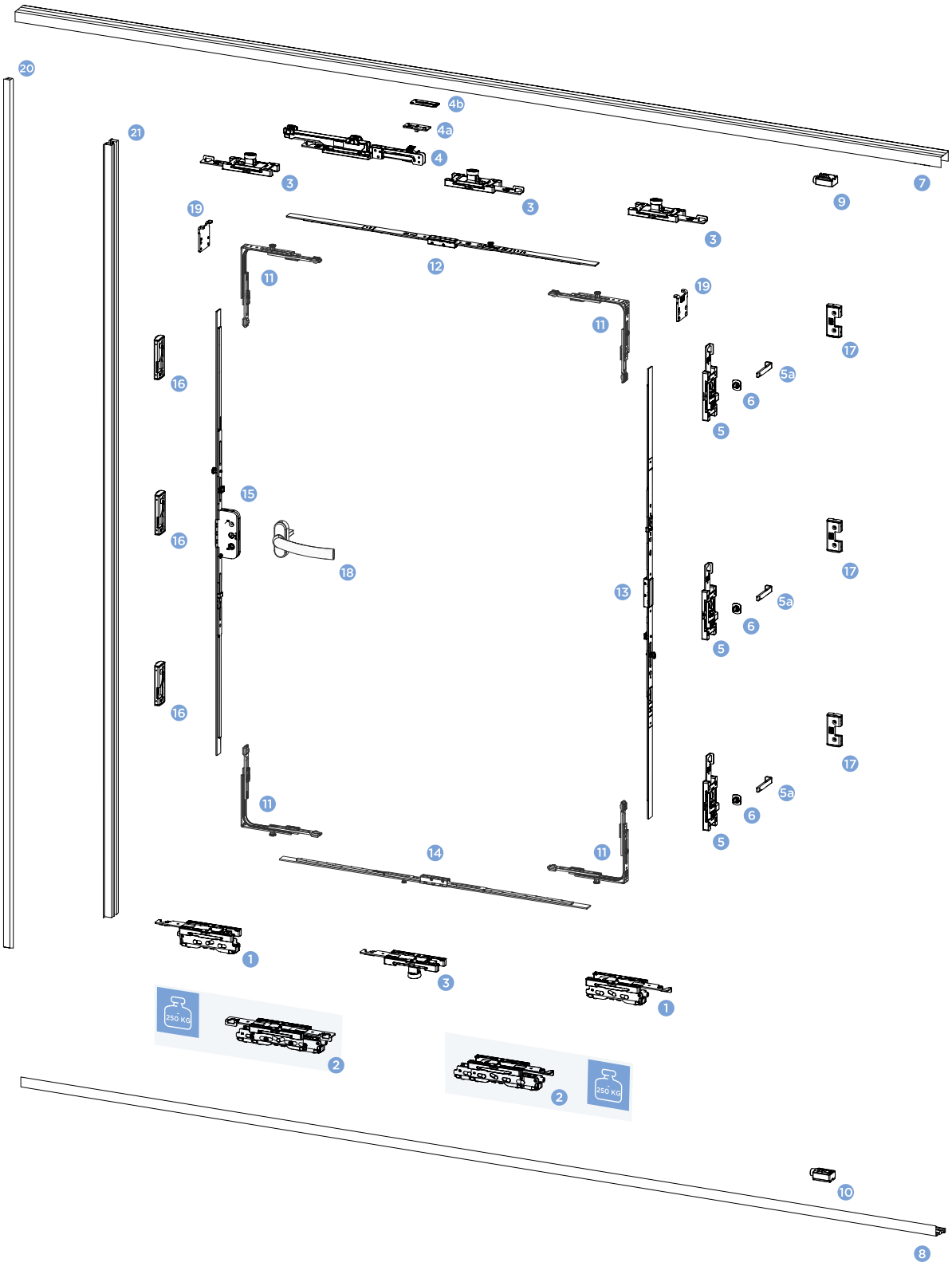


Determination of the opening direction for sliding elements in accordance with DIN EN 12519

The opening direction is determined from the inside.
When looking at a closed, *“right opening”* sash, it is a “left sash”.

5.3 Overview graphics and descriptions

Overview of primePort AS variants up to 200 kg and up to 250 kg



No.	Item designation	Assembly step
1	Bogie	page 40
2	Tandem bogie (up to 250 kg sash weight)	page 40
3	Lock right/left, top/bottom	page 43
4	Softclose damper system (optional component)	page 45
4a	Trigger for softclose damper system (optional component)	page 51
4b	Spacer plate for trigger (optional component)	page 46
5	Locking device centre stile	page 47
5a	Deadbolt	page 49
6	Bolt guide	page 49
7	Guide rail	page 54
8	Slide rail	page 53
9	Top stopper	page 63
10	Bottom stopper	page 64
11	Corner drive	page 37
12	Top connection rod	page 38
13	Connection rod opposite the drive rod	page 39
14	Bottom connection rod	page 39
15	Drive rod	page 38
16	Keep drive side	page 58
17	Keep centre stile	page 61
18	Handle	page 50
19	Anti-tilt protection	page 65
20	Keep rail	page 57
21	Sash adapter rail	page 29

This fitting list is merely a system illustration. Detailed fitting lists are available separately.

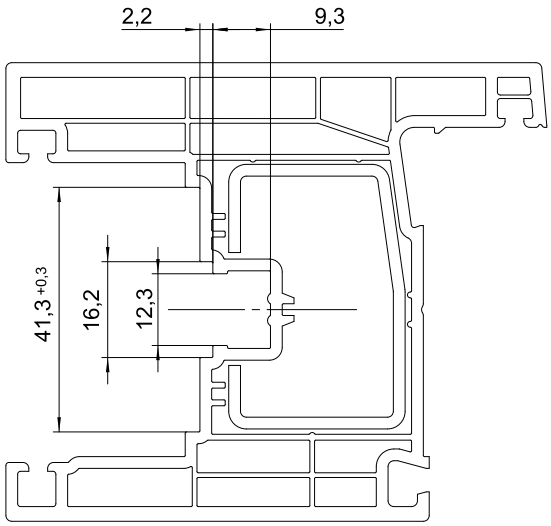
6 Installation

6.1 Assembly information

Profile designs

Profile design PVC-U window systems

The fitting system can be used for PVC-U windows with a standard fitting groove and is designed to hold retract-slide components with a width of 41.3 + 0.3 mm.



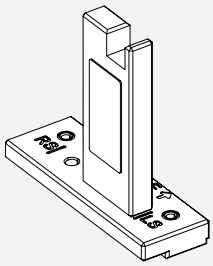
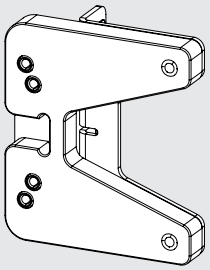
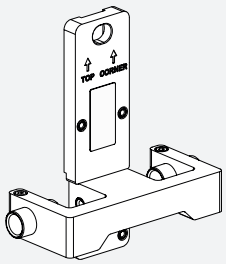
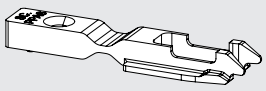
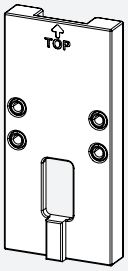
Blocking of glazing units

Within the framework of Guideline *Blocking of Glazing Units*, the German Federation of Glazers has compiled all relevant recommendations for the proper execution of blocking based on current practice and taking into account the requirements of the European standard EN 12488. This guideline can be a very good aid for expanding knowledge in this area.

6.2 Conditions for installation

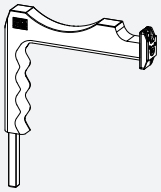
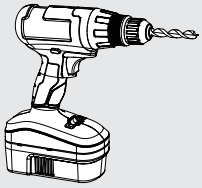
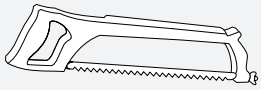
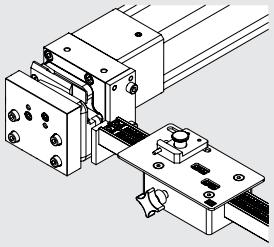
Mounting tools

The mounting tools shown in the table are required for mounting the primePort AS:

	Article description	Tool
	Jig for frame parts on drive side LE.RT.GS.PPAS	Drill bit ø 3.2 mm
	Jig for frame parts on centre stile LE.RT.MST.PPAS	Drill bit ø 3.2 mm hexagon socket 4 mm
	Jig for bogies/locking device/bolt guide LE.FL.PPAS.41 LE.FL.PPAS.51	Drill bit ø 3.2 mm Drill bit ø 12 mm
	Clamping hook (softclose damper system) SC.PPAS	-
	Jig for anti-tilt protection LE.KS.PPAS.23 LE.KS.PPAS.26 LE.KS.PPAS.29	Drill bit ø 3.2 mm

Tools

The tools shown in the figure are required for assembly:

	Tool
	Hexagonal key size 4 mm
	Winkhaus HV adjustment key for octagonal mushroom head bolts
	Handle 7 mm square
	Drill with drill bit
	Saw
	Fittings punch

Assembly aids and tools are not included in the scope of delivery.

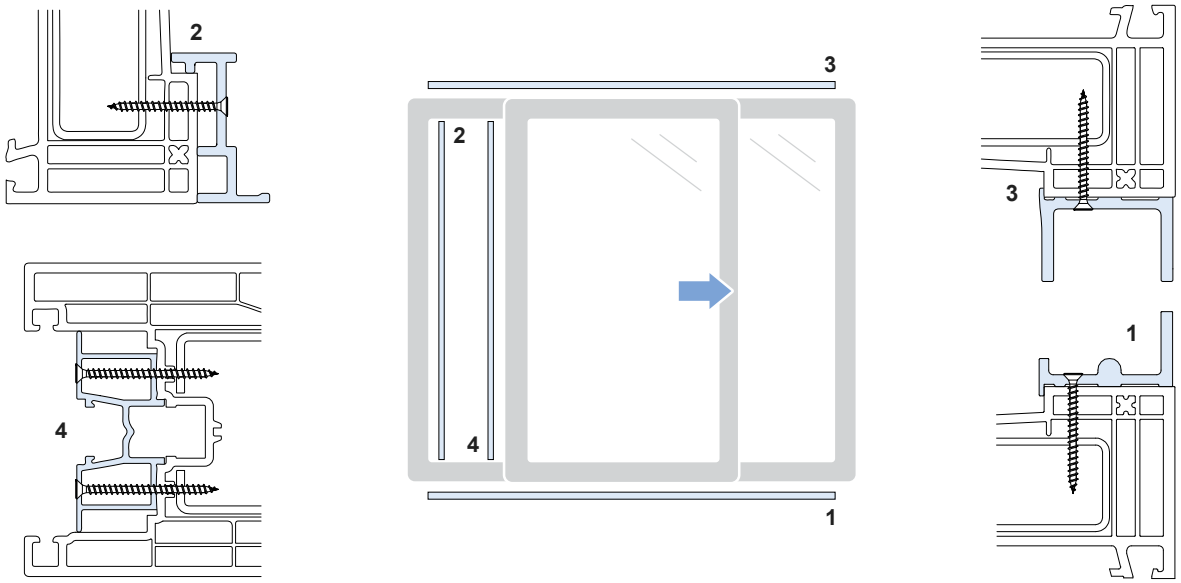
For further assembly aids and corresponding instructions, please address your Winkhaus contact person for comprehensive advice. Alternatively, further information is provided in the Winkhaus Portal. See "Other applicable documents", page 11

Attachment of load-bearing components/torques

IMPORTANT

In general, it is recommended to use high-quality screws of sufficient dimensions. The screws used must be matched to the respective window material. The specifications in this documentation as well as those of the screw manufacturer must be implemented.

In the case of PVC-U profiles, load-bearing components must generally be bolted down to the steel reinforcement. The screw length must be selected in that way that the screwing depth in steel is at least 5 mm.

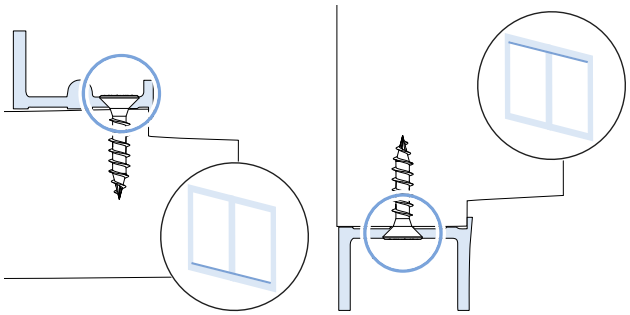


(1) slide rail; (2) keep rail; (3) guide rail; (4) sash adapter rail

Screw dimensions

Component	Screw type/dimensions [mm]	Drill diameter (pre-drilling) [mm]
Bogies	Fitting screw ø 3.9-4.2	3.2
Locking devices	Fitting screw ø 3.9-4.2	3.2
activPilot central locking system – sash components	Fitting screw ø 3.9	-
Window handle	M5 x ..., DIN 965	-
Anti-tilt protection	Drilling screw ø 3.9-4.2	3.2
Slide rail	Fitting screw ø 3.9-4.2	3.2
Guide rail	Fitting screw ø 3.9-4.2	3.2
Keep rail	Fitting screw ø 3.9-4.2	3.2
Sash adapter rail	Fitting screw ø 3.9-4.2	3.2

Winkhaus does not provide fastening screws for fitting. Always use fastening screws suitable for the window type and window dimensions.



The slide rail (bottom) and guide rail (top) must be fastened with fitting screws with a head diameter of at least ø 6.9 mm and at most ø 7.5 mm. The specifications of the profile manufacturers or system owners must be strictly observed!
The screw heads must be flush with the rail surfaces!

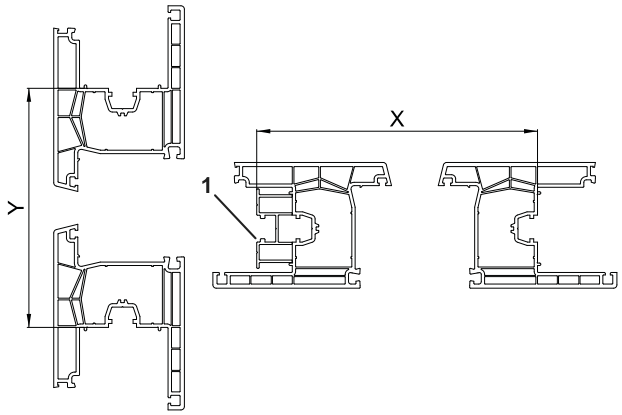
6.3 Preparing the installation

6.3.1 Dimensional drawings sash profile/sash adapter rail

Definition of sash rebate width (FFB) and sash rebate height (FFH)

X = sash rebate width (FFB) including sash adapter rail (1), drive side

Y = sash rebate height (FFH)



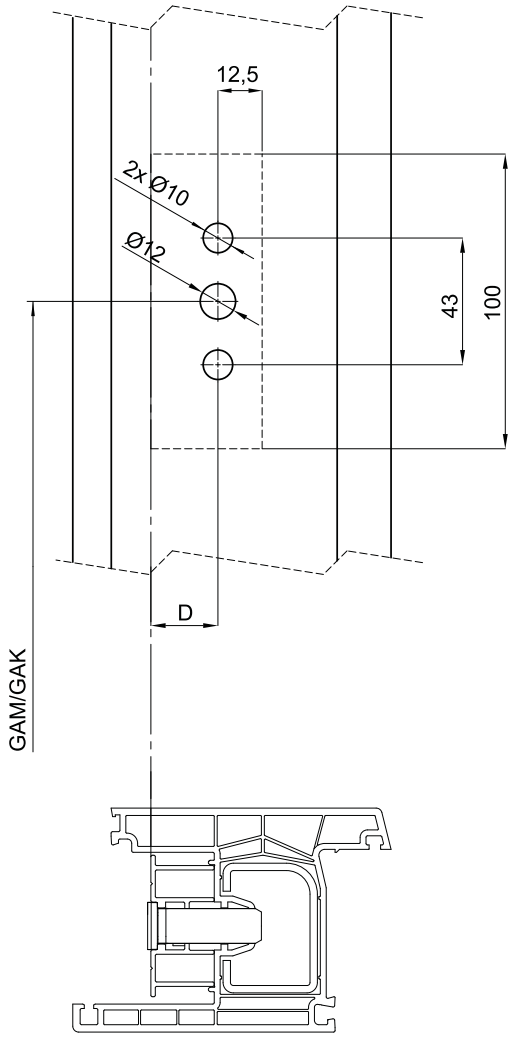
The drive-side add-on profiles must be fastened in the sash profile in accordance with the system provider's specifications (distances, bore diameter, number of screws, etc.).

6.3.2 Dimensional drawings of gear case

Drive rod GAK ... and GAM ... D = Backset

Drilling and milling pattern Gear case
Backset 25 - 50 mm

PVC-U profile

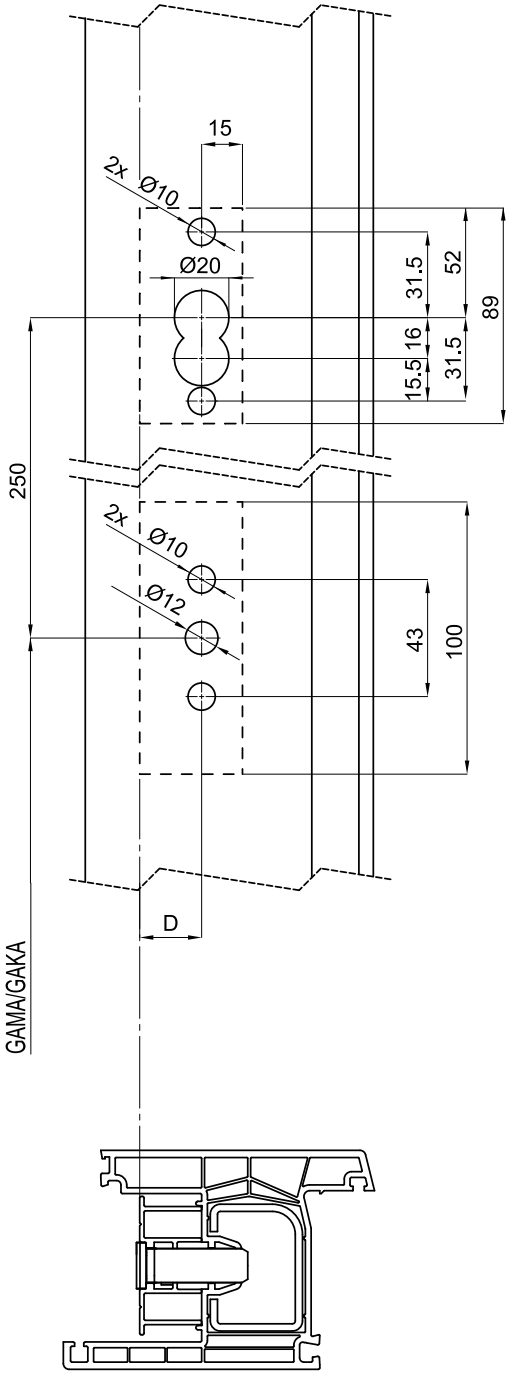


GAM - Drive rod, central handle position
GAK - Drive rod, constant handle position

Drive rod GAKA.PP ... and GAMA.PP ... D 25-40

Drilling and milling pattern Gear case and cylinder lock case Backsets 25, 30, 35 or 40 mm

PVC-U profile



GAMA - drive rod central handle position, lockable
GAKA - drive rod constant handle position, lockable

6.4 Mounting of fittings on sash

6.4.1 Cutting to length of fittings (Somatec fitting punch)

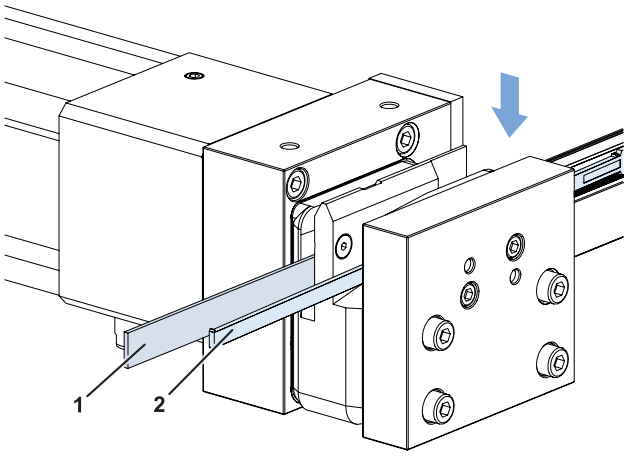
Here you will find a detailed description of how to cut to length the fittings, which is referred to in the Mounting Instructions.

The following Somatec fitting punching tools are available:

- PUNCH CROPPER SOMATEC GE.LS (shown here)
- PUNCH CROPPER SOMATEC GE.RS

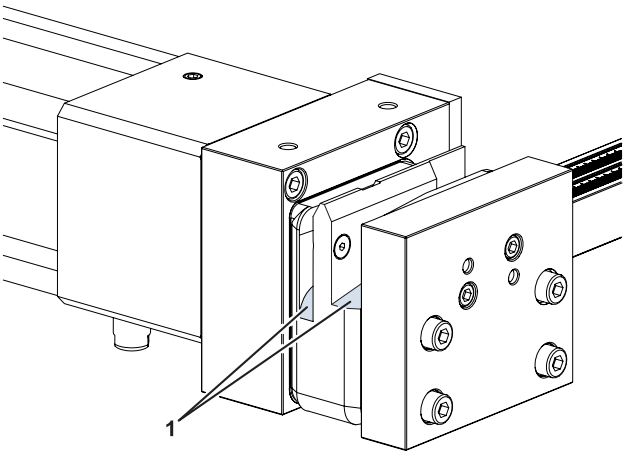
Cutting to length

1. Insert the component to be cut to length into the punch.
2. Always insert the face plate (1) and drive rod (2) perpendicularly from the top with the face plate (1) pointing to the pressure cylinder.
3. Adjust the sash rebate size with the help of the ruler.
4. Press the foot switch to cut to length.
5. After punching, always remove the face plate (1) and drive rod (2) perpendicularly in an upwards direction.



IMPORTANT

Always keep the supporting surfaces of the punch (1) clean.



Ruler description

The ruler must be adjusted to cut to length the components. To do this, move the slider to the correct position and select the correct scale.

Position the slider (1)

Position: VSM-ASG

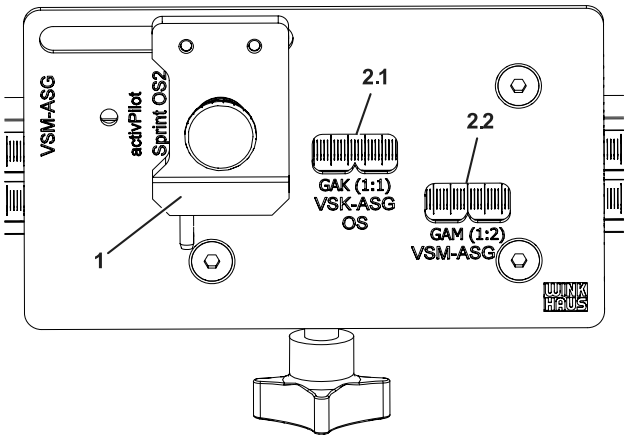
- For connection rod VSM-ASG...

Position: activPilot

- For all activPilot components

Position: Sprint OS2

- For top rods activPilot Sprint OS2....E2....



Select scale (2.1/2.2) and set to the correct sash rebate size.

Scale (2.1): GAK (1:1), VSK-ASG and OS

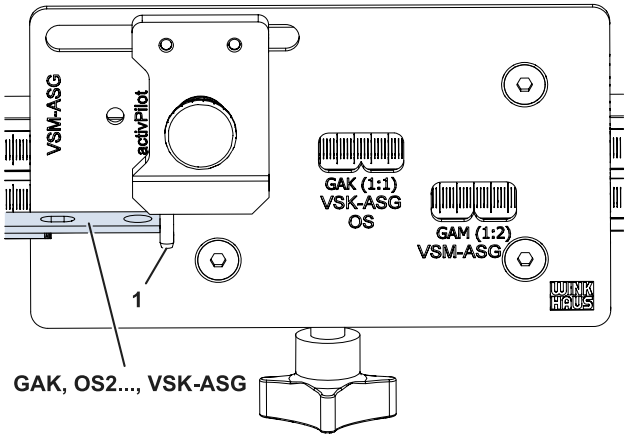
- For all components with constant handle position / if cut to length on one side

Scale (2.2): GAM (1:2) and VSM-ASG

- For all components with central handle position / if cut to length on both sides
- If the GAM (1:2) and VSM-ASG scale is moved by one graduation line, this corresponds to a real change in length of 2 mm.

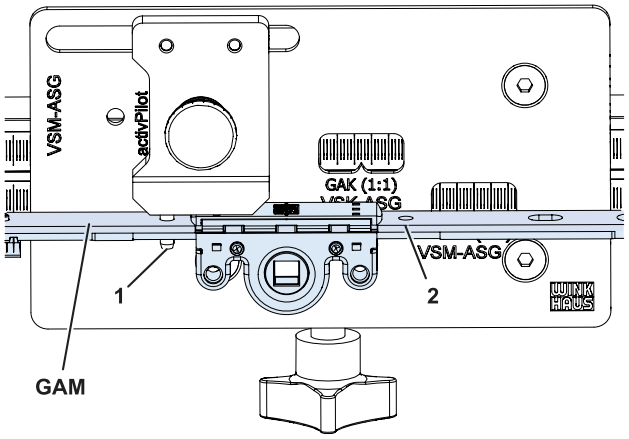
Cutting to length of drive rod GAK/GASK (constant handle position), top rod OS2 and connection rod VSK-ASG

1. Set the slider to the “activPilot” position.
2. Set the scale “GAK (1:1), VSK-ASG, OS” to the correct sash rebate size.
3. Place drive rod GAK, top rod OS2 or connection rod VSK-ASG on positioning pin (1) and cut to length.



Shorten the drive rod GAM (central handle position)

1. Set the slider to the “activPilot” position.
2. Set the scale “GAM (1:2), VSM-ASG” to the correct sash rebate size.
3. Place drive rod on positioning pin (1) and cut to length.
4. After cutting to length the first side (1), turn the drive rod 180° and repeat cutting (2).



6.4.2 Cutting to length of fittings (Reiplinger fitting punch)

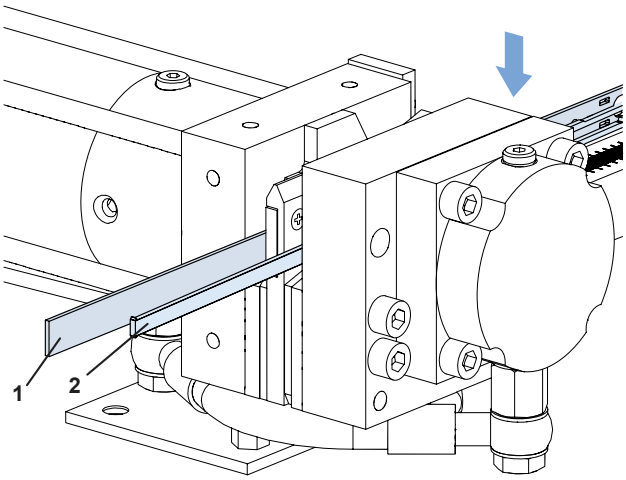
Here you will find a detailed description of how to cut to length the fittings, which is referred to in the Mounting Instructions.

The following Reiplinger fitting punching tools are available:

- PUNCH CROPPER AP/FS LS (shown below)
- PUNCH CROPPER AP/FS RS

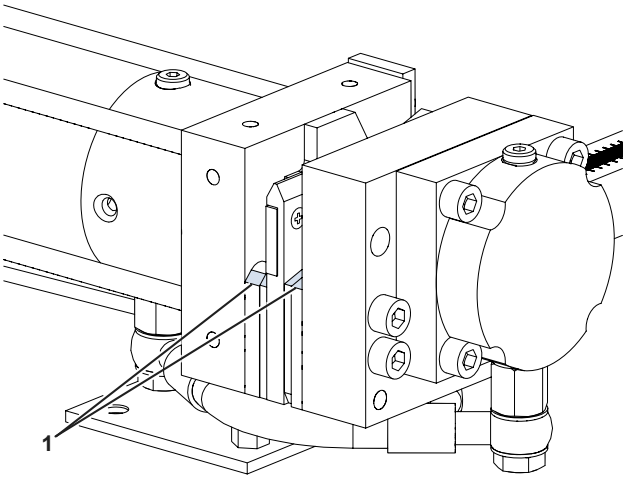
Cutting to length

1. Insert the component to be cut to length into the punch.
2. Always insert the face plate (1) and drive rod (2) perpendicularly from the top with the face plate (1) pointing to the pressure cylinder.
3. Adjust the sash rebate size with the help of the ruler.
4. Press the foot switch to cut to length.
5. After punching, always remove the face plate (1) and drive rod (2) perpendicularly in an upwards direction.



IMPORTANT

Always keep the supporting surfaces of the punch (1) clean.



Ruler description

The ruler must be adjusted to cut to length the components. Select the correct scale for this purpose.

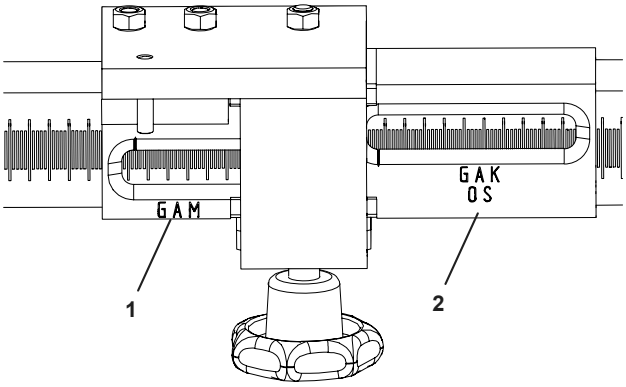
Select scale and set to the correct sash rebate size.

Scale (1): GAM

- For all components with central handle position / if cut to length on both sides
- If the GAM scale is moved by one graduation line, this corresponds to a real change in length of 2 mm.

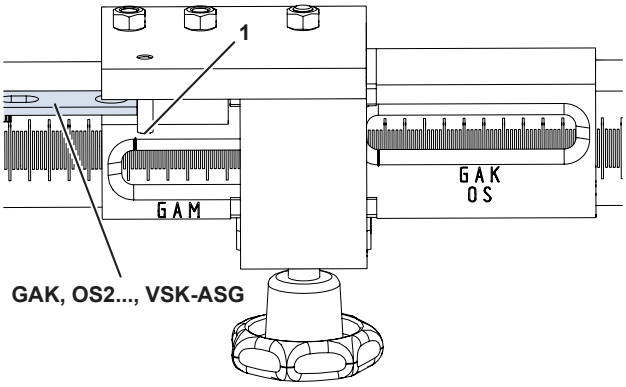
Scale (2): GAK/OS

- For all components with constant handle position / if cut to length on one side



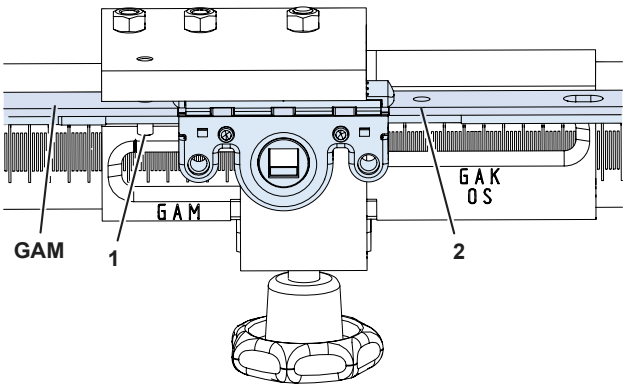
Cutting to length of drive rod GAK/GASK (constant handle position), top rod OS2 and connection rod VSK-ASG

1. Set the scale “GAK/OS” to the correct sash rebate size.
2. Place drive rod GAK, top rod OS2 or connection rod VSK-ASG on positioning pin (1) and cut to length.



Shorten the drive rod GAM (central handle position)

1. Set the scale “GAM” to the correct sash rebate size.
2. Place drive rod on positioning pin (1) and cut to length.
3. After cutting to length the first side (1), turn the drive rod 180° and repeat cutting (2).



6.4.3 Installing the central locking system for the primePort AS 200 and primePort AS 250 variants

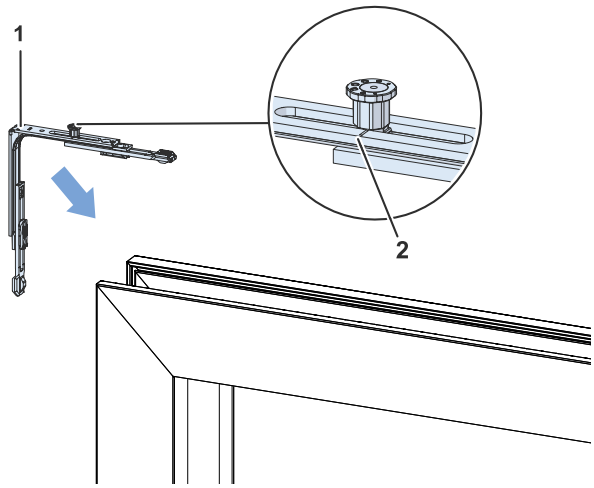
Note: The following diagrams show the version for a left-hand handle position (looking at the window from the inside). When fitting a window for right-hand use, the figures will be mirror-inverted.

Note: All installation parts of the central locking system are centrally locked. The centre position is indicated by a notch mark; see close-up diagram (2).

The drive side add-on profiles must be fastened in the sash profile in accordance with the system provider's specifications (distances, bore diameter, number of screws, etc.).

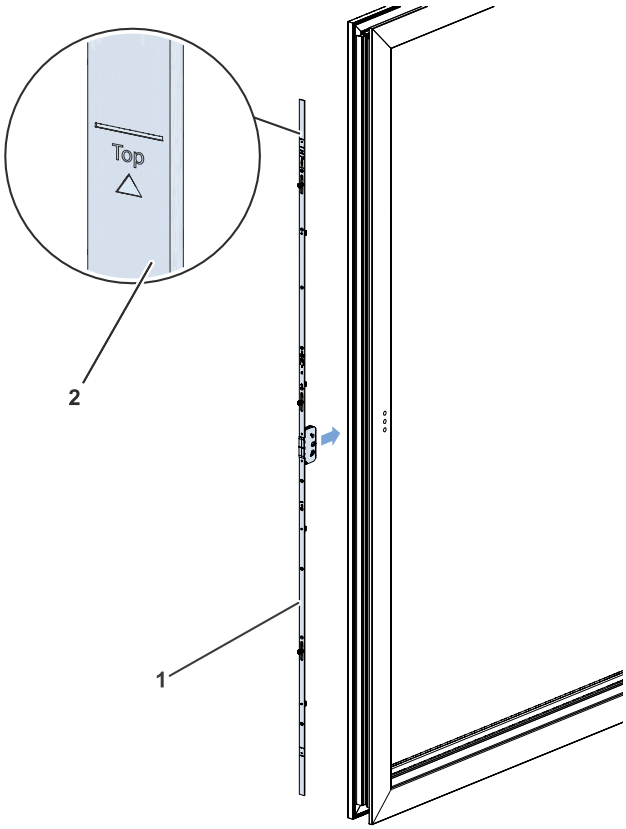
Installing corner drives

1. Insert corner drive (1) into the fitting groove and fix with 2 screws.
2. Fit the other corner drives in the same way.



Inserting the drive rod

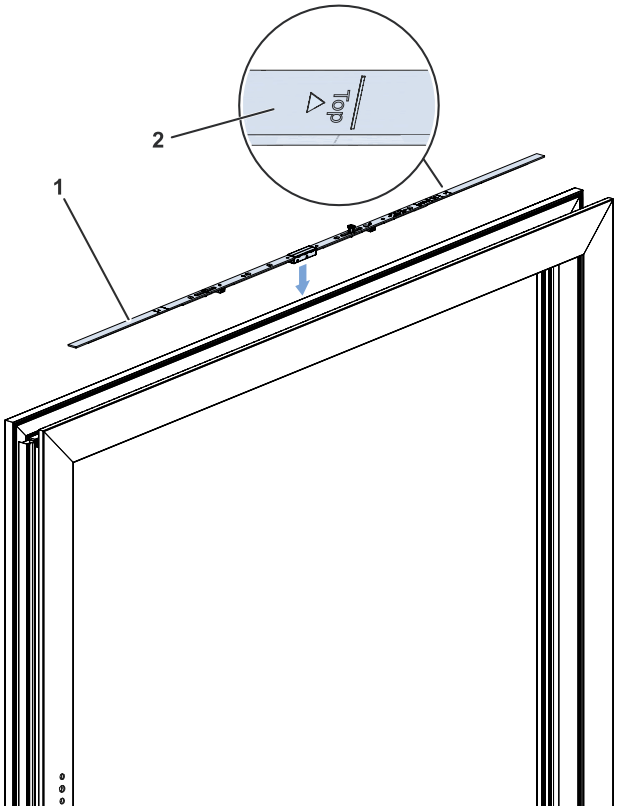
1. Measure sash rebate height (FFH), then cut to length drive rod (1) and screw on.
2. Pay attention to marking “arrow” for correct installation direction (2).



Mounting the top connection rod

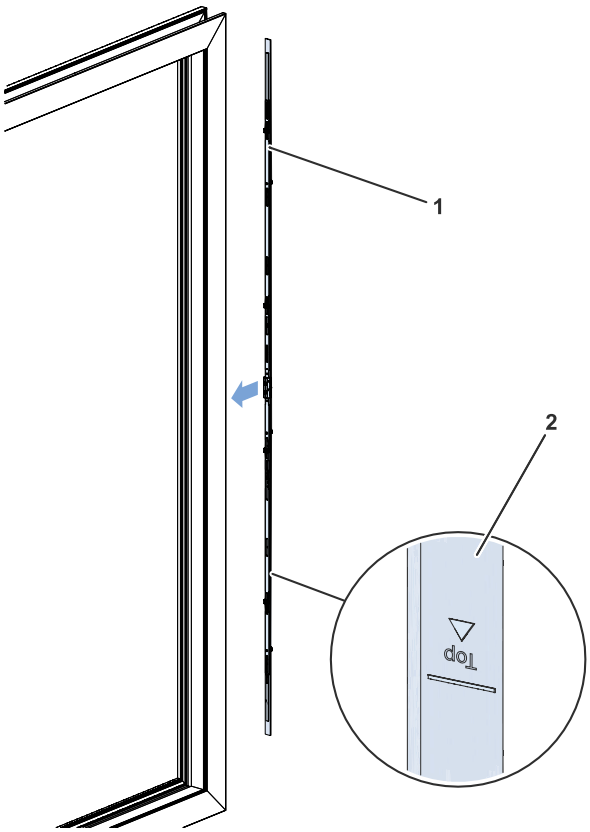
1. Measure sash rebate width (FFB), then cut to length connection rod (1) and screw on.
2. Pay attention to marking “arrow” for correct installation direction (2).

   The arrow points to the side opposite the drive rod.



Mounting the connection rod opposite the drive rod

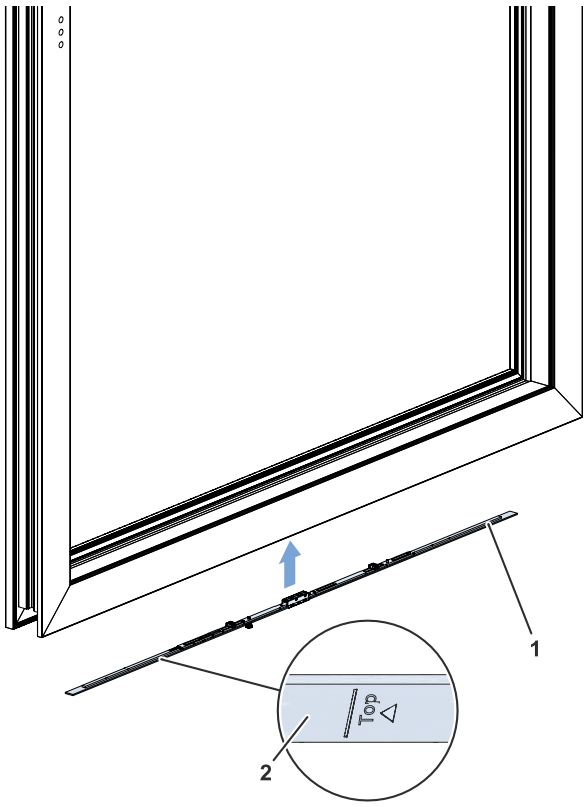
1. Measure sash rebate height (FFH), then cut to length connection rod (1) and screw on.
2. Pay attention to marking “arrow” for correct installation direction (2).



Mounting the bottom connection rod

1. Measure sash rebate width (FFB), then cut to length connection rod (1) and screw on.
2. Pay attention to marking “arrow” for correct installation direction (2).

   The arrow points to the side of the drive rod.



6.4.4 Installation of bogies

General mounting instructions

IMPORTANT

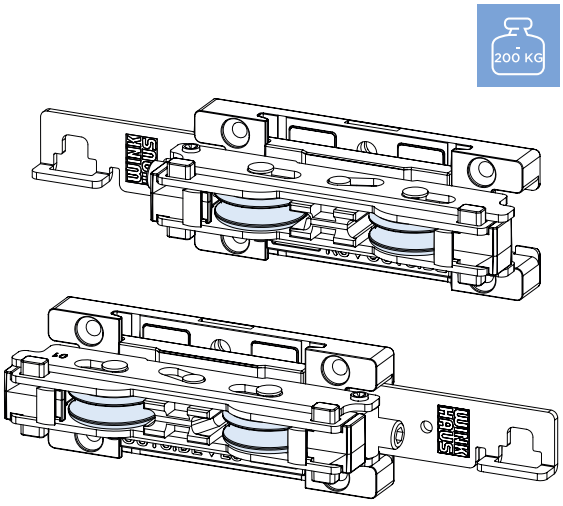
The bogies must generally be screwed down to the steel reinforcement in PVC-U profiles.
The screw length must be selected so that the screw-in depth in steel is at least 5 mm.

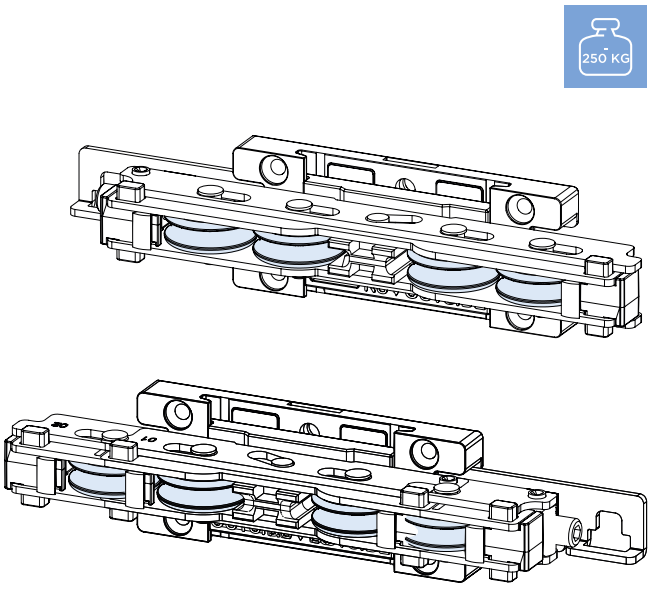
For this reason:

- Drill holes generally through the first walls of the PVC-U profile and steel reinforcement.

Type of bogies depending on sash weight

Sash weight [kg]	Number of bogies	Number of rollers
up to 200	2 bogies with 4 holes each	standard bogie with 2 rollers each
up to 250	2 bogies with 4 holes each	tandem bogie with 4 rollers each





Standard and tandem bogies are available in right and left versions. Please pay attention to the component markings RS and LS.

When positioning the bogie, make sure that the indication “OUTSIDE” points in the direction of the arrow to the outside of the sash.

The following illustrations show the mounting of the bogies on the handle side. For the opposite side, the illustration is to be seen the other way round.

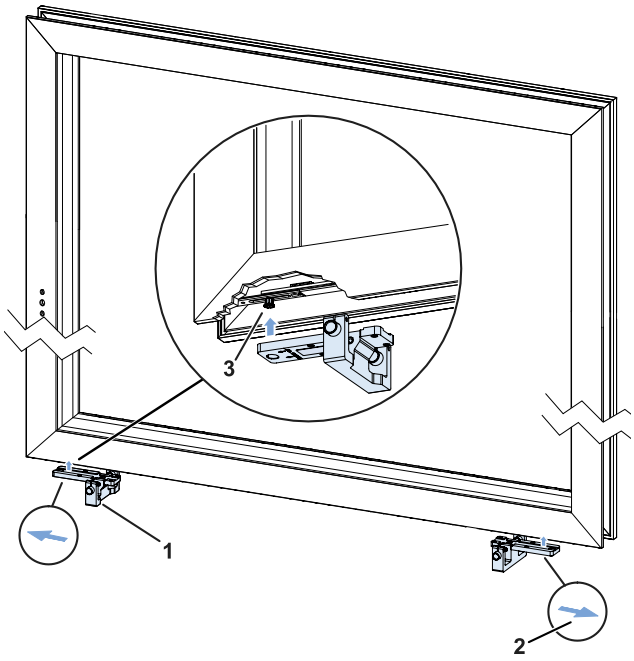
The central locking system must be in the centre position (default delivery state) during the entire assembly of the sash procedure.

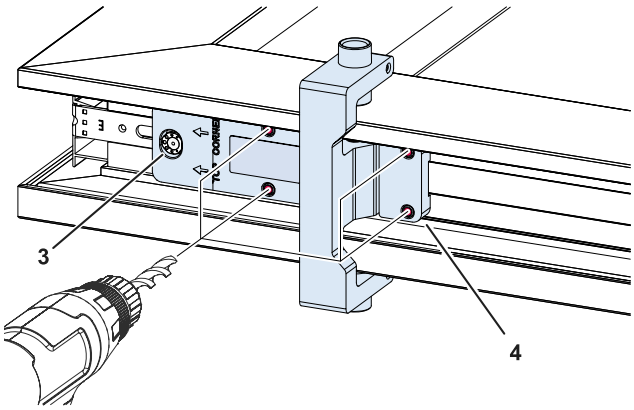
Positioning the drilling jig for bogies

For mounting the bogies use the drilling jig (1) to pre-drill.

1. Insert the drilling jig (1) into the profile and place it on the octagonal bolt of the corner drive (3).
2. Drill the holes (4).

When positioning the jig, make sure that the arrow with the indication “CORNER” points in the direction of the sash corner (2).

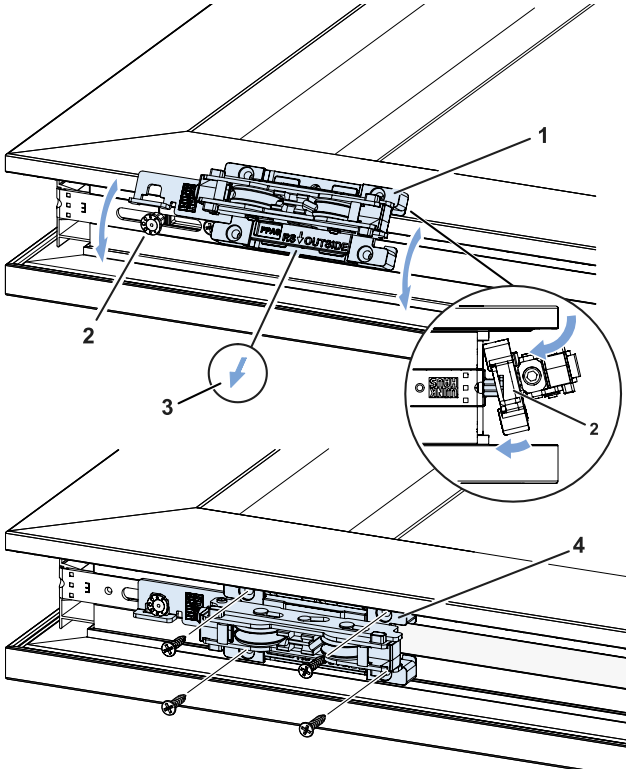




Installation of bogies

1. Place the bogie (1) with the coupling rod on the octagonal bolt of the corner drive from above and screw it into the profile section (2).
2. Screw on the bogie (4).

When positioning the bogie, make sure that the indication “OUTSIDE” points in the direction of the arrow to the outside of the sash (3).



6.4.5 Installing the locking devices

Positioning the drilling jig for locking devices

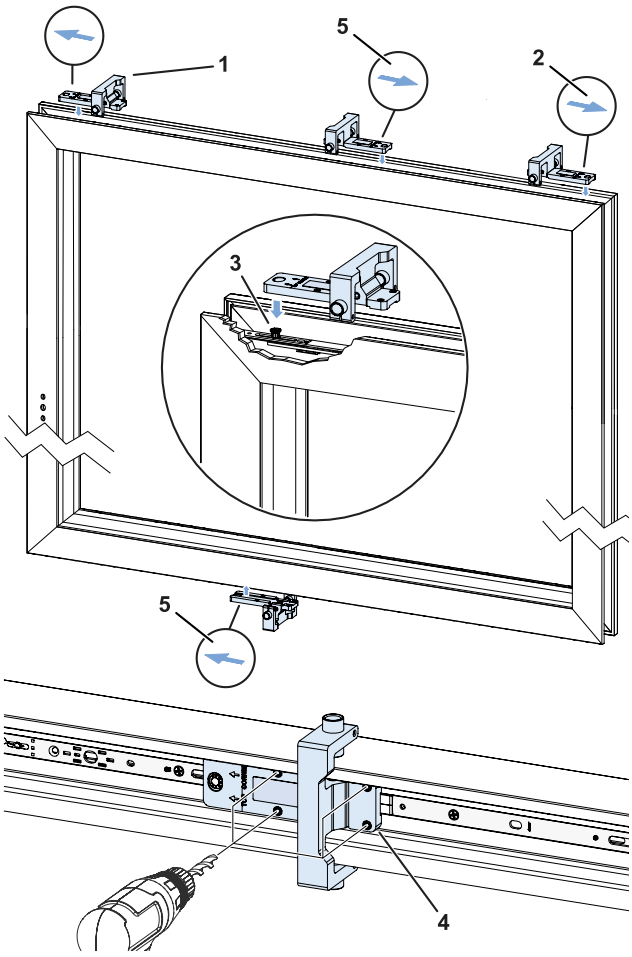
For mounting the locking devices use drilling jig (1) to pre-drill.

1. Insert the drilling jig (1) into the profile and place it on the available octagonal bolts (3).
2. Drill the holes (4).

When positioning the jig for the outer locking devices, make sure that the arrow with the indication “CORNER” points towards the corners of the sash (2).

When positioning the jig for the central locks at the top, make sure that the arrow with the indication “CORNER” points in the direction opposite the drive side.

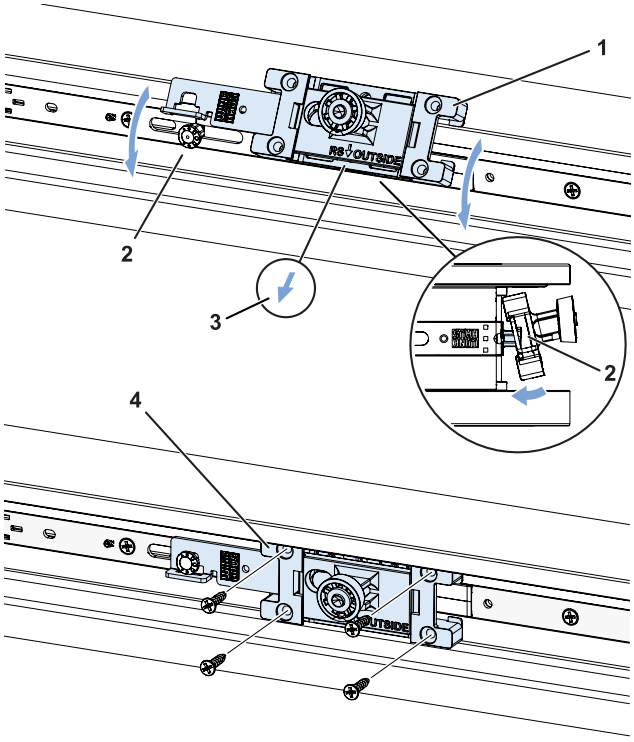
For the central locks at the bottom, make sure that the arrow with the indication “CORNER” points towards the drive side (5).



Installing the locking devices

1. Place the locking device (1) with the coupling rod on the available octagonal bolts from above and screw into the profile section (2).
2. Screw on the locking device (4).

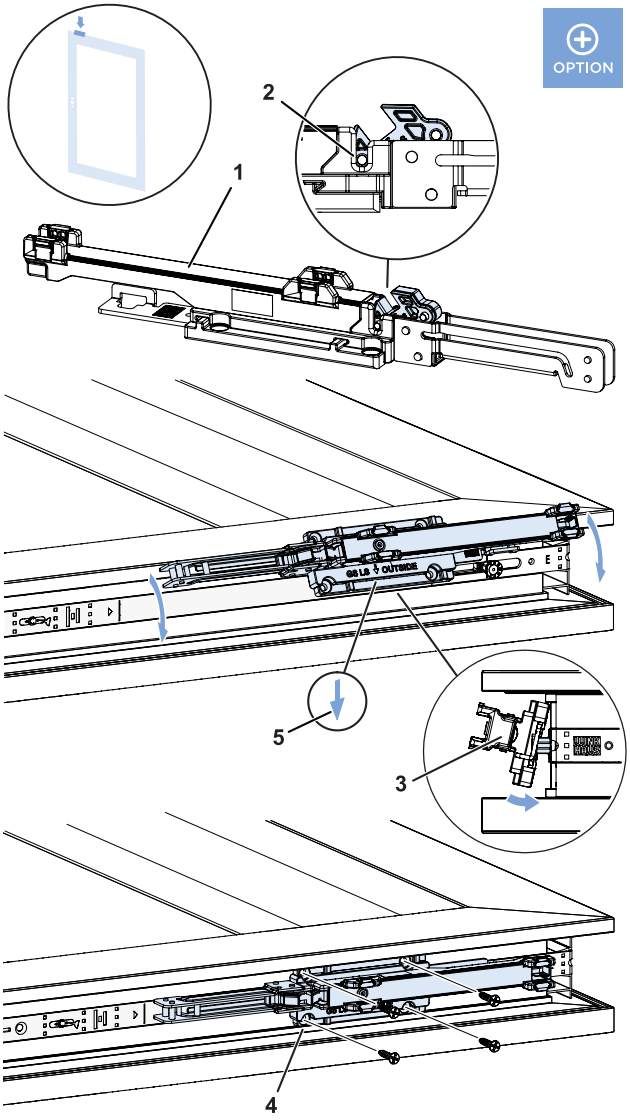
When positioning the locking device, make sure that the indication “OUTSIDE” points in the direction of the arrow to the outside of the sash (3).



Installing the optional softclose damper system

1. Place the softclose damper system with the coupling rod (1) from above in tensioned position (2) on the available octagonal bolt and screw into the profile (3).
2. Screw on softclose damper system (4).

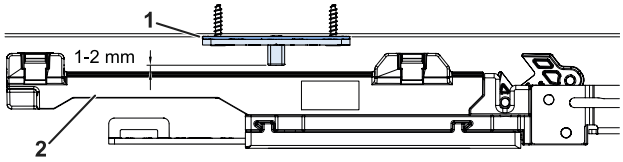
When positioning the softclose damper system, make sure that the indication “OUTSIDE” points in the direction of the arrow to the outside of the sash (3).

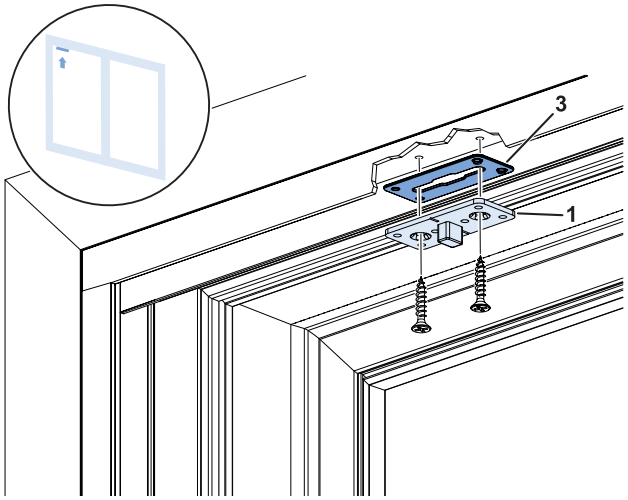


Mounting the trigger of the softclose damper system

When installing the frame-side trigger (1), the installation height can be individually modified depending on the profile geometry using spacer plates (3). Spacer plates (3) are available in predefined sets.

To achieve the specified distance between the trigger (1) and the soft-close damper system (2), the number of spacer plates (3) must be selected accordingly.

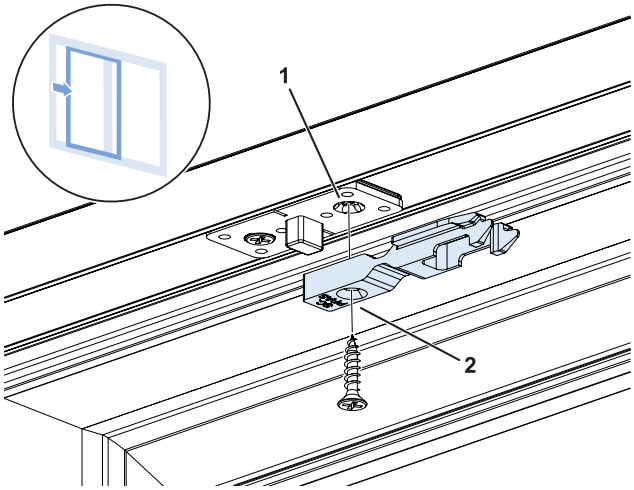




> For dimensions for positioning the trigger (1) on the frame see "Retract-slide element primePort AS – GAM", page 51

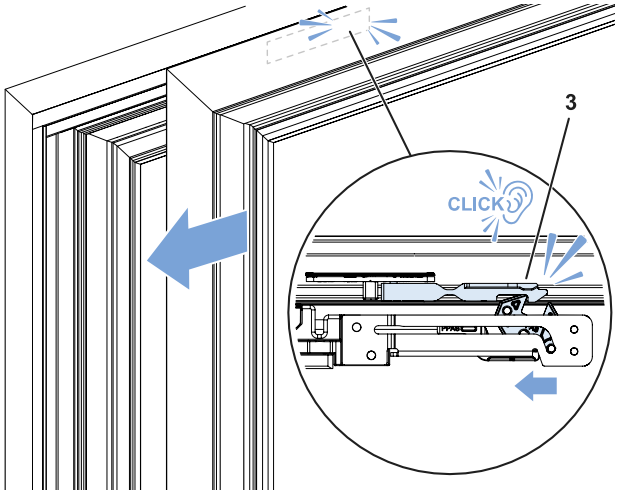
Subsequent tensioning of the softclose damper system with the clamping hook

> If the sliding sash has already been installed and the distance between the softclose damper system and trigger is subsequently adjusted using the spacer plates, it may be necessary to re-tighten the system with the clamping hook.

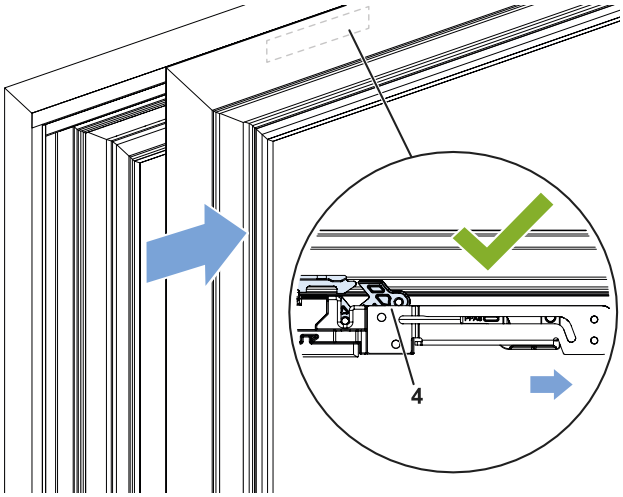


1. Open the sash by sliding and loosen the trigger screw (1) facing the handle.
2. Place the clamping hook on the trigger and screw them together (2).

3. Slowly close the sash again enabling the clamping hook to grip the driver of the softclose damper system (not visible) (3).



4. Slowly open the sash. This tensions the softclose damper system which is now operational again (4).
5. After that remove the clamping hook and screw the trigger back in place.



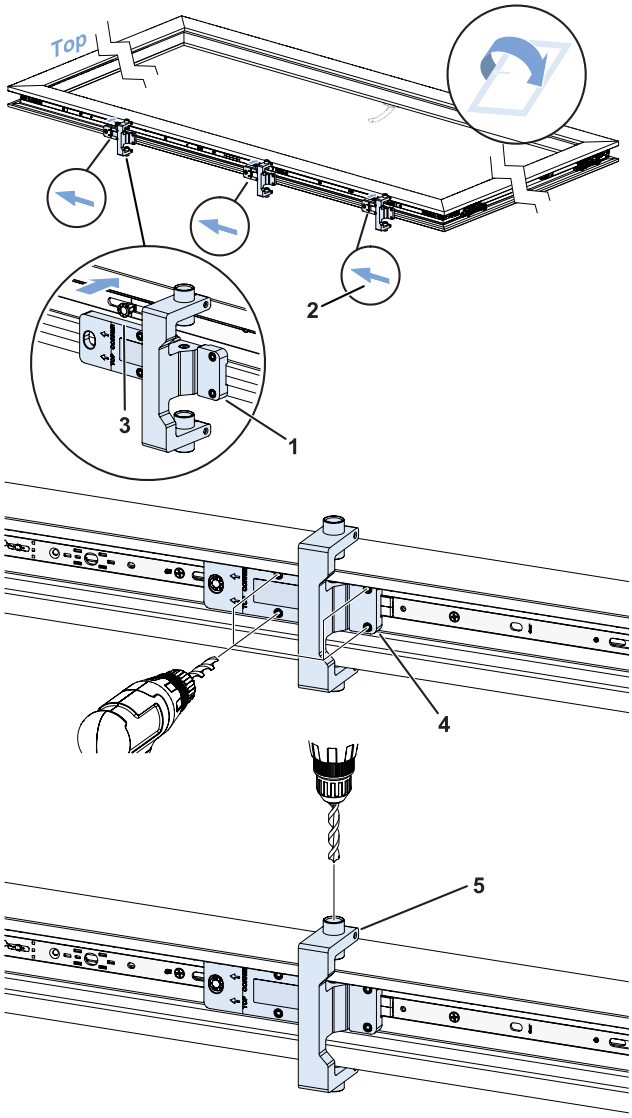
6.4.6 Installing the locking devices for the centre stile (opposite side of the drive rod)

Positioning the drilling jig for centre stile lock and bolt guides

For pre-drilling the centre stile locking devices and bolt guides use drilling jig (1).

1. Insert the drilling jig (1) into the profile and place it on the available octagonal bolts (3).
2. Drill the holes (4) (5).

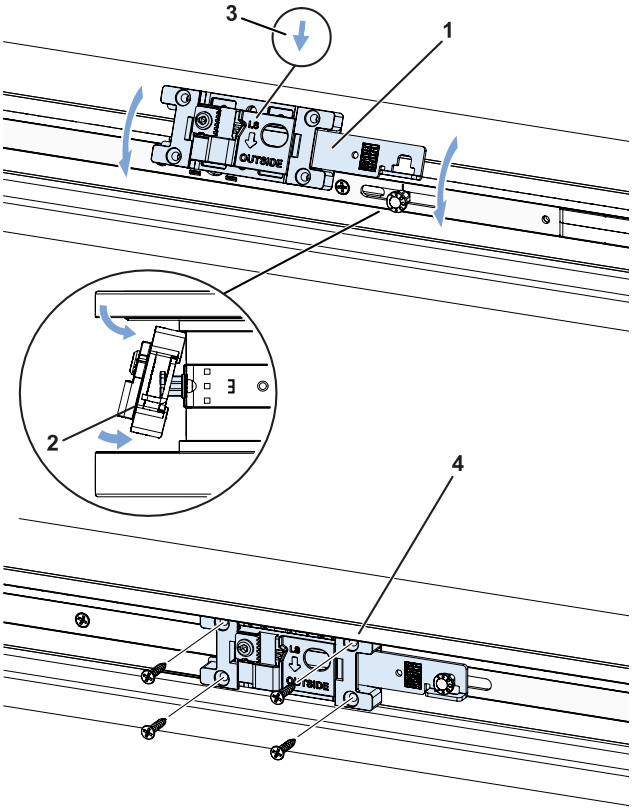
When positioning the jig, make sure that the arrow with the “TOP” marking points towards the top of the sash (2).



Installing the centre stile locking devices

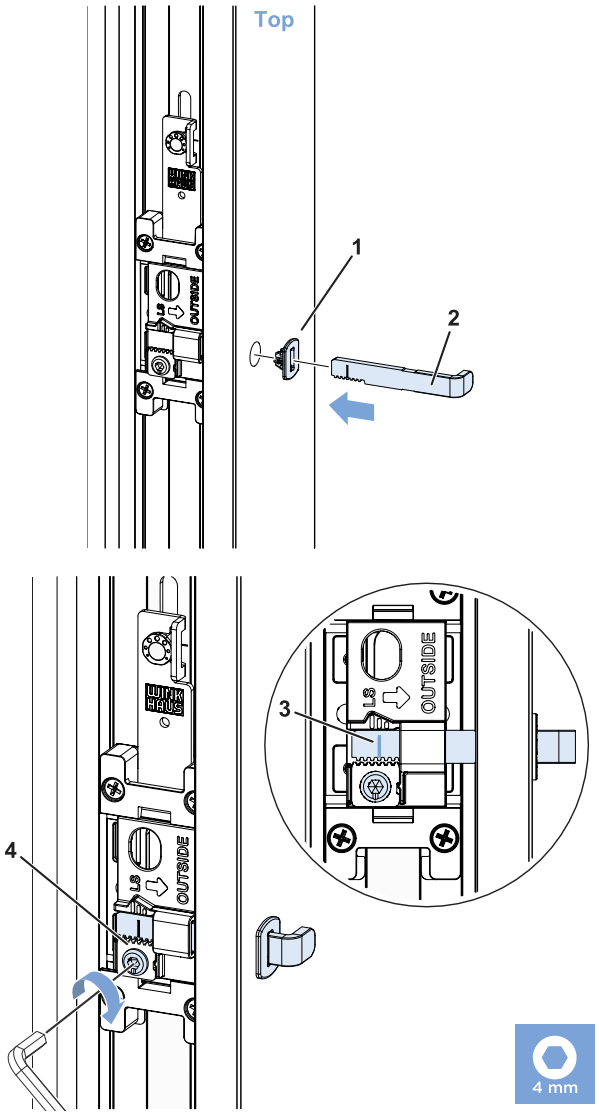
1. Place the centre stile locking device (1) with the coupling rod on the available octagonal bolts from above and screw into the profile section (2).
2. Screw on the centre stile locking device (4).

When positioning the centre stile lock, make sure that the indication “OUTSIDE” points in the direction of the arrow to the outside of the sash.



Installing deadbolts and bolt guide

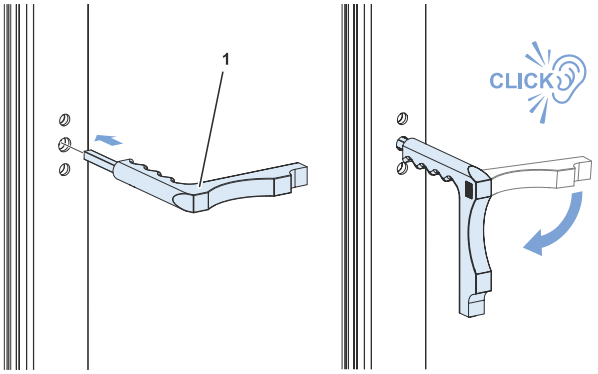
1. Insert the bolt guide (1).
2. Place the deadbolt (2) into the bolt guide (1).
3. To position the deadbolt in the zero position, the indentations on the deadbolt and centre stile lock must be aligned as shown in the adjacent detail drawing (3).
4. The deadbolt is fixed by means of the eccentric cam (4).



Initial operation of central locking system

The 7 mm square handle can be used for the initial actuation of the central locking system. The handle set belonging to the product range can be installed on site at a later date.

1. Move the handle (1) to the 90° position and insert the square pin into the drive retainer.
2. Turn the handle to release the central fastening.

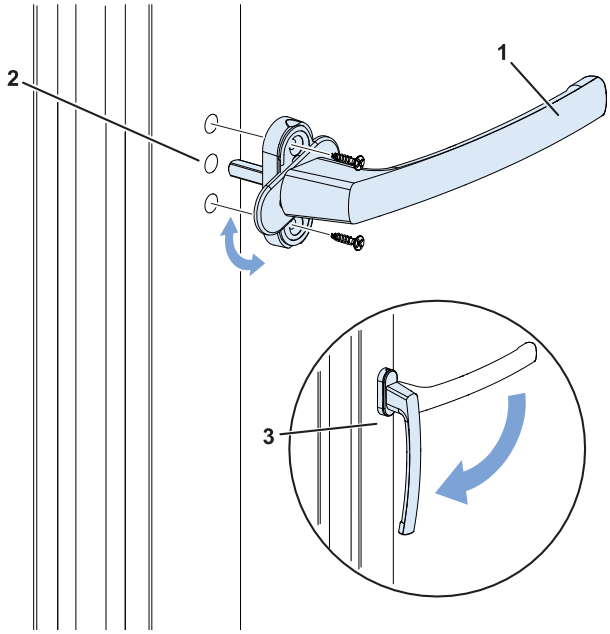


The handle will be stiffer than normal the first time it is used. A clicking noise will be heard during actuation.

Mounting the handle of the primePort AS variant

The handle set belonging to the product range can also be installed on site at a later date.

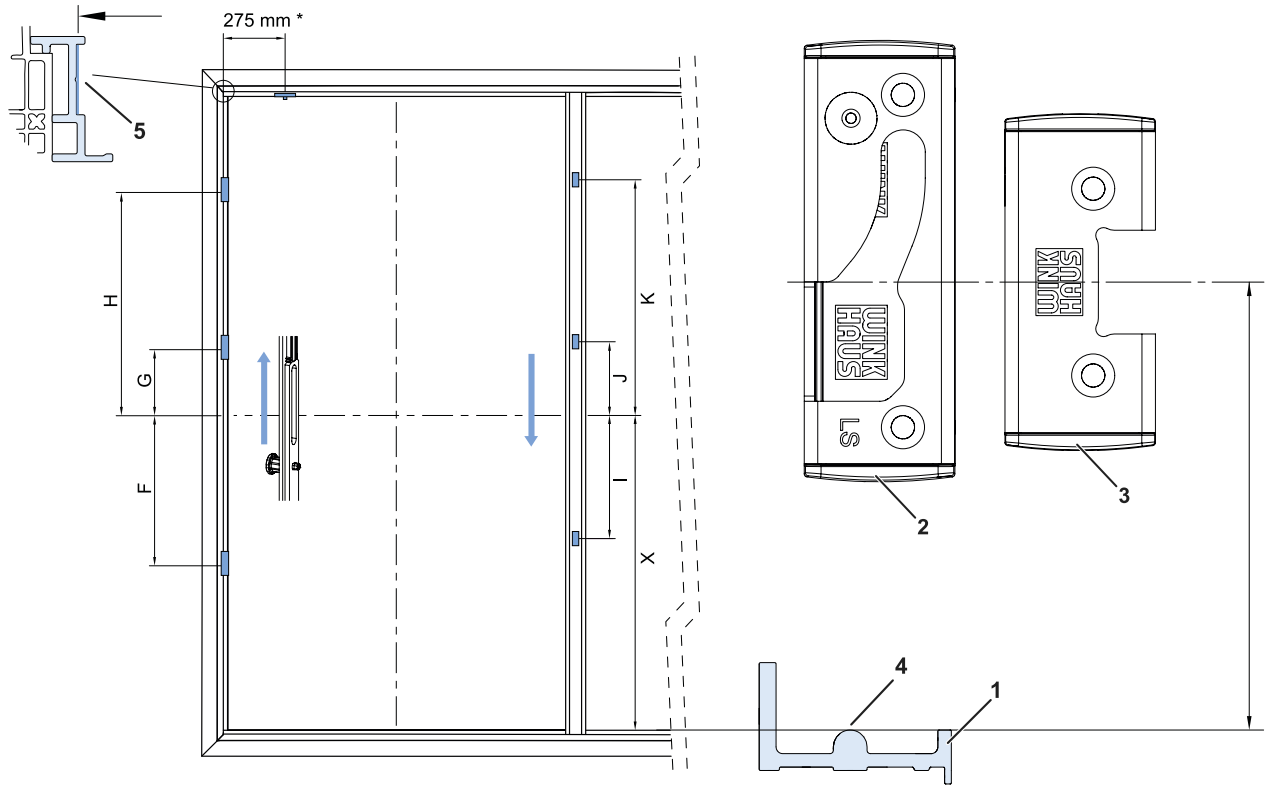
1. Move handle (1) to 90° position.
2. Position the handle set on the sash, insert it into the drive retainer (2) with the square pin and screw in place.
3. Turn the handle to release the central fastening (3).



6.5 Mounting of fittings on the window frame

6.5.1 Positions of frame parts – tabular presentation

Retract-slide element primePort AS – GAM



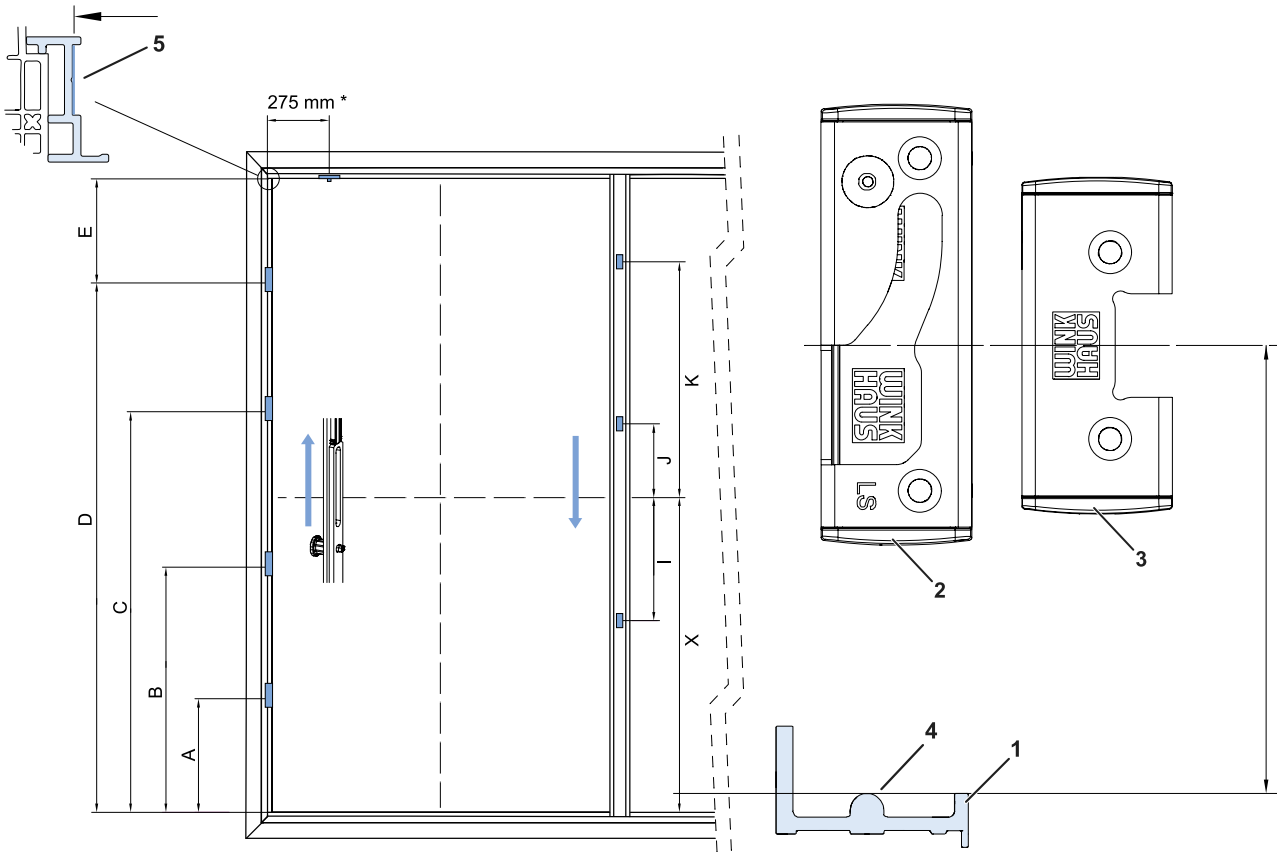
slide rail (1); keep, drive side (2); keep, centre stile (3); reference point (4);
* = fixed trigger dimension for the softclose damper system (reference point: inner side of profile of keep rail (5))

	FFH min. [mm]	FFH max. [mm]	Dim. F [mm]	Dim. G [mm]	Dim. H [mm]
GAM.1050-1	800	1050	-	112	-
GAM.1400-1	1051	1400	-	112	-
GAM.1400-2	1051	1400	238.5	112	-
GAM.1800-2	1401	1800	356	244	-
GAM.2300-3	1801	2300	534	112	676.5
MK.250-0 + GAM.2300-3 + MK.250-0	2301	2700	534	112	676.5

	FFH min. [mm]	FFH max. [mm]	Dim. I [mm]	Dim. J [mm]	Dim. K [mm]
VSAM.1050-1	800	1050	-	218	-
VSAM.1400-1	1051	1400	-	218	-
VSAM.1800-2	1401	1800	250	350	-
VSAM.2300-3	1801	2300	428	218	782.5
MK.250-0 + VSAM.2300 + MK.250-0	2301	2700	428	218	782.5

For positioning of frame parts, the reference dimensions are derived from the variable X. This dimension is calculated as follows: **Dimension (Dim.) X = FFH/2 + 35 mm.** This dimension applies from reference point (4).

Retract-slide element primePort AS – GAK



slide rail (1); keep, drive side (2); keep, centre stile (3); reference point (4);
* = fixed trigger dimension for the softclose damper system (reference point: inner side of profile of keep rail (5))

	FFH min. [mm]	FFH max. [mm]	Dim. A [mm]	Dim. B [mm]	Dim. C [mm]	Dim. D [mm]	Dim. E [mm]
GAK.1325-1	1100	1325	-	758.5	-	-	-
GAK.1325-1 + MK.250-1	1326	1575	-	758.5	-	-	246
GAK.1325-1 + MK.500-1	1576	1775	-	758.5	-	-	496
GAK.2000-4	1776	2000	393.5	758.5	1258.5	1508.5	-
GAK.2225-4	2001	2225	393.5	758.5	1258.5	1758.5	-
GAK.2225-4 + MK.250-0	2226	2475	393.5	758.5	1258.5	1758.5	-
GAK.2225-4 + MK.500-0	2476	2725	393.5	758.5	1258.5	1758.5	-

	FFH min. [mm]	FFH max. [mm]	Dim. I [mm]	Dim. J [mm]	Dim. K [mm]
VSAM.1050-1	800	1050	-	218	-
VSAM.1400-1	1051	1400	-	218	-
VSAM.1800-2	1401	1800	250	350	-
VSAM.2300-3	1801	2300	428	218	782.5
MK.250-0 + VSAM.2300 + MK.250-0	2301	2700	428	218	782.5

Refer to the reference dimensions in the table for positioning the frame parts on the drive side. These dimensions apply from reference point (4).

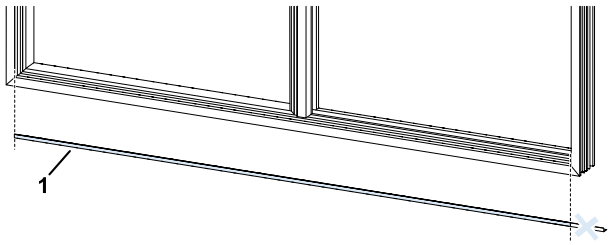
For positioning of frame parts on the centre stile, the reference dimensions are derived from the variable X. This dimension is calculated as follows: **Dimension (Dim.) X = FFH/2 + 35 mm.** This dimension applies from reference point (4).

6.5.2 Installing the slide rail

Cutting to length of the slide rail

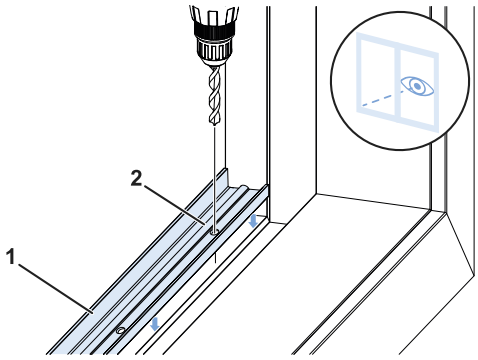
Length of slide rail (1) = internal frame width

1. Measure the internal frame width.
2. Mark length and cut to length the slide rail (1).



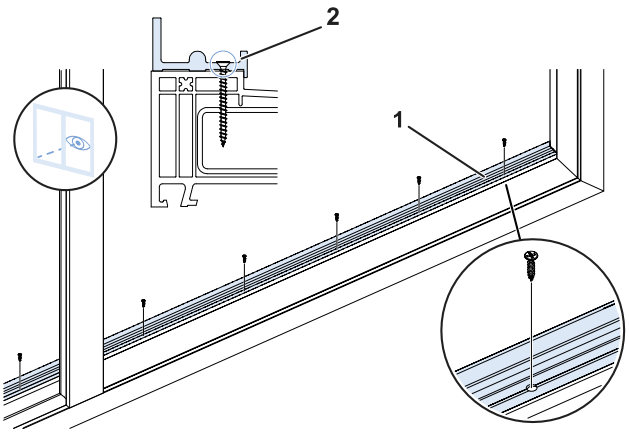
Holes for the slide rail

1. Position the slide rail (1) on frame.
2. Drill the holes (2).
3. Drill all other holes for fastening the slide rail in the same way.



Installing the slide rail

1. Fix slide rail (1) with screw using the pre-drilled hole.
2. Attach all other screws in the same way to fasten the slide rail.



The screw heads must be flush with the rail surfaces (2). For further information see "Attachment of load-bearing components/torques", page 27

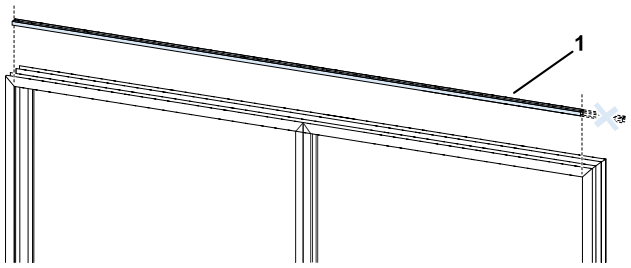
Further information on fastening the system-specific aluminium profiles is given in the documents of the system providers.

6.5.3 Installing the guide rail

Cutting to length of the guide rail

Length of guide rail (1) = internal frame width

1. Measure the internal frame width.
2. Mark length and cut to length the guide rail (1).

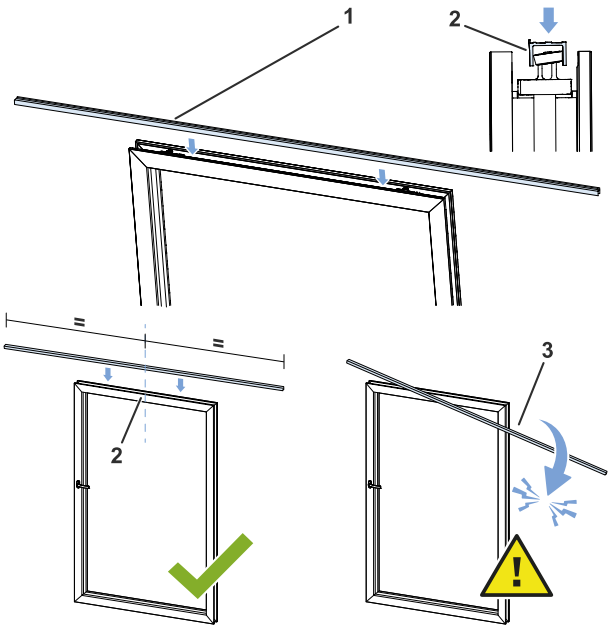


Fitting the guide rail

1. Place the cut-to-length guide rail (1) centrally in the central groove and on the sash locks (2).

CAUTION

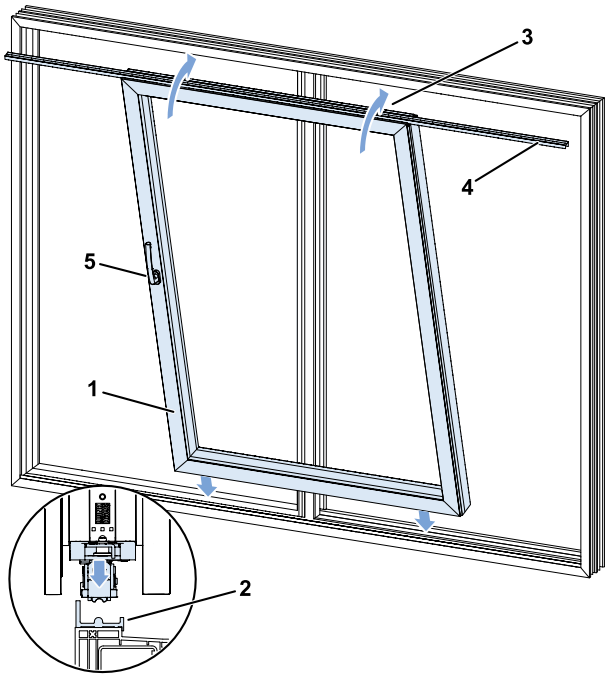
A guide rail (1) that is not positioned centrally can fall down when the sash is mounted and cause injury (3).



Installing the guide rail

The sash must be fitted to install the guide rail correctly.

1. Place the sash (1) with the rollers on the slide rail (2) at an angle of approx. 10°.
2. Check the correct position of the rollers by moving the sash back and forth.
3. Carefully set up the sash in a vertical position (3). Make sure that the guide rail remains centred on the sash and does not fall down (4).

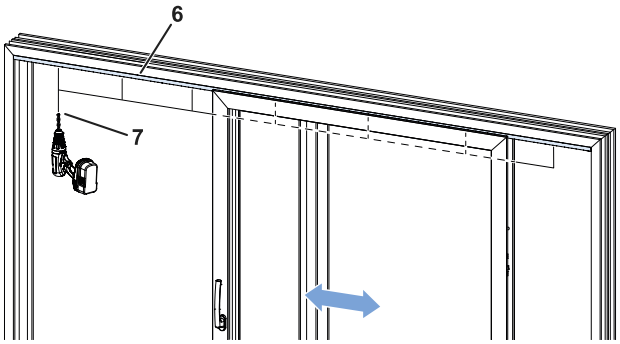


The handle (5) must be moved to the vertical position (sliding position).

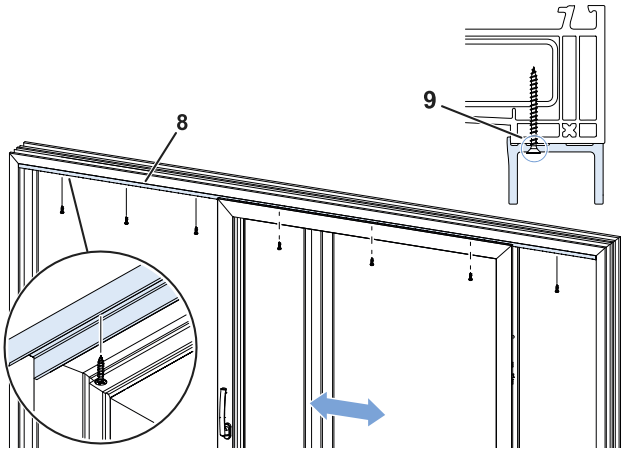
WARNING

Heavy sash weight. As the sash may be heavy, there is a risk of back injury when lifting and a risk of an accident if the sash falls. Carry the sash with two persons.

4. Position the guide rail (6) on frame.
5. Drill the holes (7).
6. Drill all other holes in the same way for fastening the guide rail.



7. Screw guide rail (8) into predrilled hole with a screw.
8. Attach all other screws in the same way to fasten the guide rail.



The screw heads must be flush with the rail surfaces (9). For further information see "Attachment of load-bearing components/torques", page 27

Further information on fastening the system-specific aluminium profiles is given in the documents of the system providers.

6.5.4 Fitting the sash

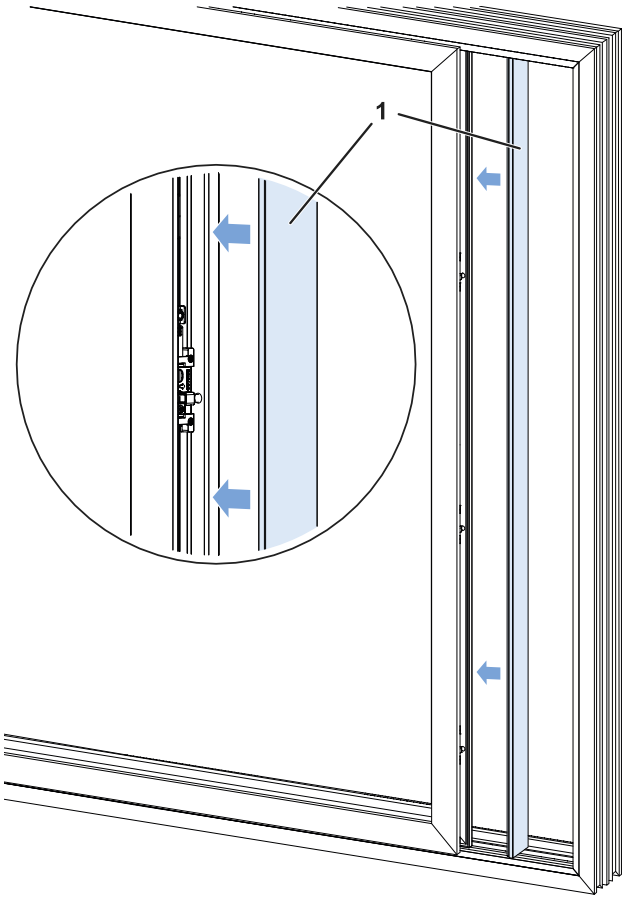
For this assembly step, see: "Installing the guide rail", page 55

IMPORTANT

Keep the slide rails clean at all times to ensure optimum smooth running of the sliding sashes.

6.5.5 Mounting of the sash profile covers

1. Clip the sash profile cover (1) into the profile on the side of the centre stile locking devices.

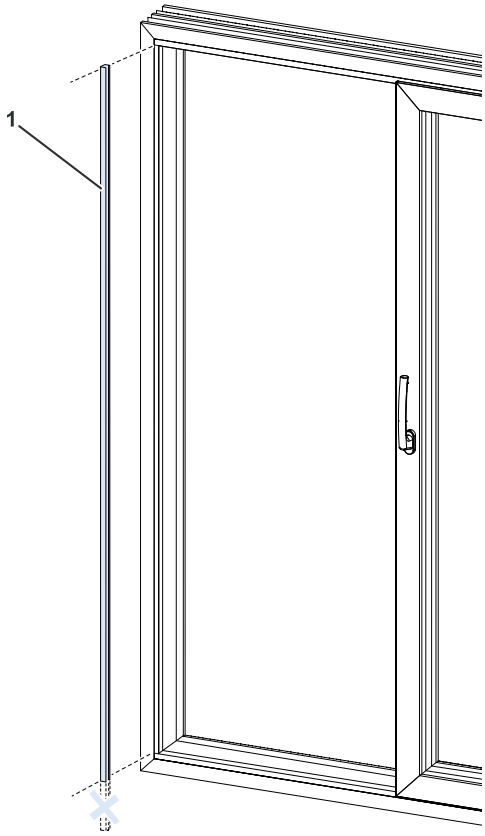


6.5.6 Installing the keep rail

Cutting to length the keep rail

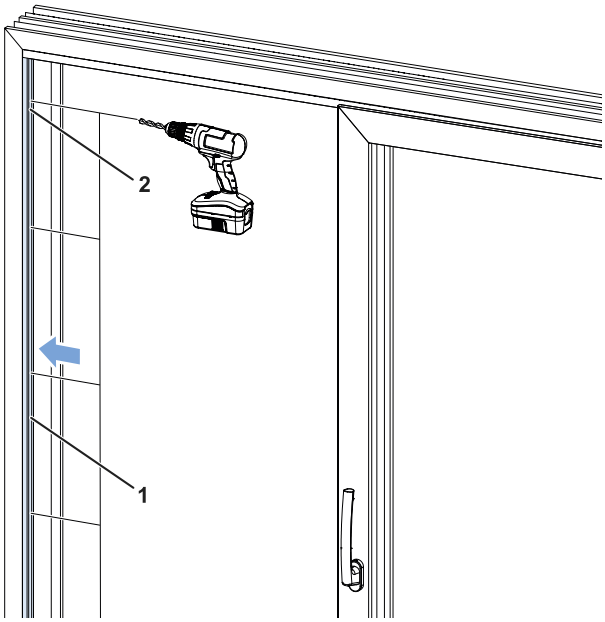
Length of keep rail (1) = internal frame height minus installation height of slide rail minus installation height of guide rail

1. Measure the internal frame height and subtract the height of the slide rail (bottom) and guide rail (top).
2. Mark length and cut to length the keep rail (1).



Drill holes for keep rail

1. If there are no holes in the keep rail, it must be pre-drilled evenly.
2. Position keep rail (1) on the frame.
3. Drill through the keep rail into the frame profile (2).
4. Drill all other holes for fastening the keep rail in the same way.

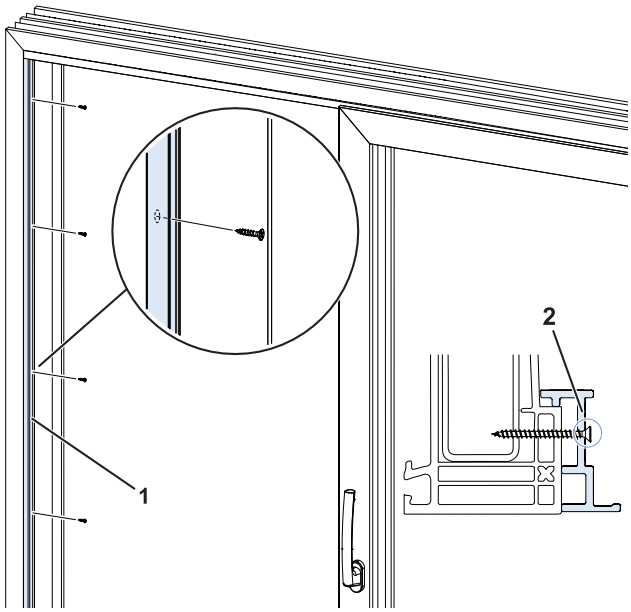


Installing the keep rail

1. Screw the keep rail (1) into the pre-drilled hole with a screw.
2. Insert all other screws for fastening the keep rail in the same way.

The screw heads must be flush with the rail surfaces (2). For further information see "Attachment of load-bearing components/torques", page 27

Further information on fastening the system-specific aluminium profiles is given in the documents of the system providers.



6.5.7 Mounting the locking keeps on the drive side using a jig

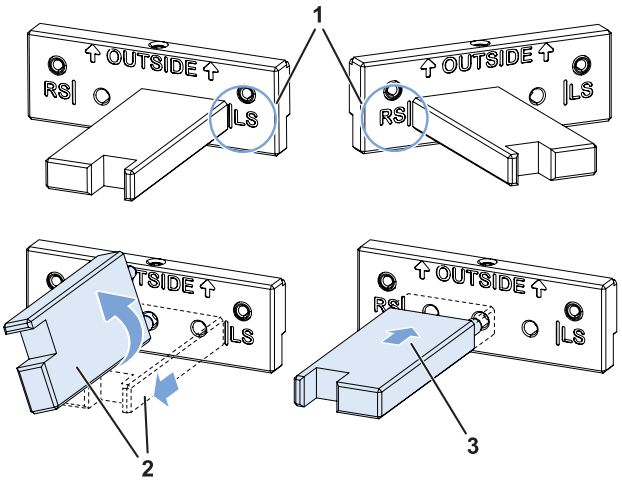
Adjusting the jig for mounting the locking parts on the drive side

The jig must be pre-adjusted for correct installation of the drive-side locking parts.
The jig can be used for both a left sash (right opening) and a right sash (left opening).

Make sure that the tactile piece of the jig is in contact with the marking LS (left sash) or RS (right sash) (1).

Changing the position of the tactile piece:

1. Pull the tactile piece out of the jig and turn it 180° (2).
2. Insert the tactile piece back into the two holes of the jig (3).

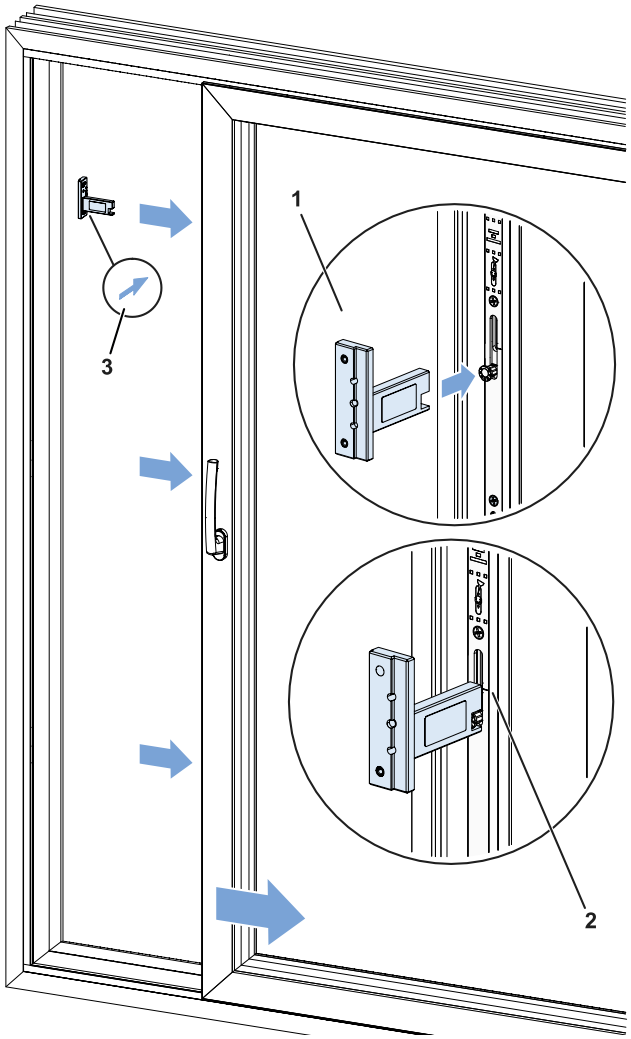


Positioning the jig for fitting the locking parts on the drive side

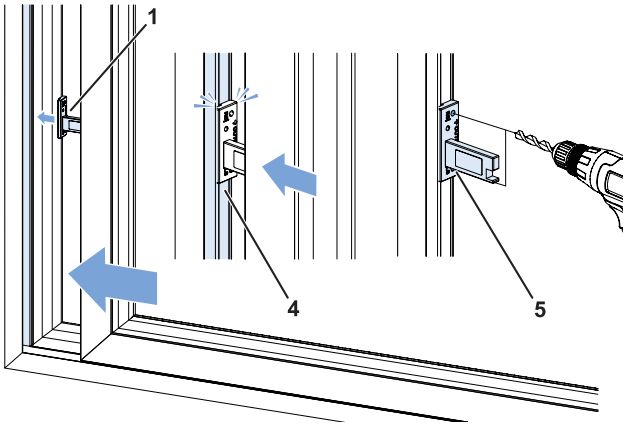
For installation of the locking parts on the drive side the jig is used as follows:

1. Push the sash slightly open and place the jig (1) with the recess on the octagonal bolt (2). Continue to hold the jig.

> When positioning the jig, make sure that the indication “OUTSIDE” points in the direction of the arrow to the outside of the sash (3).

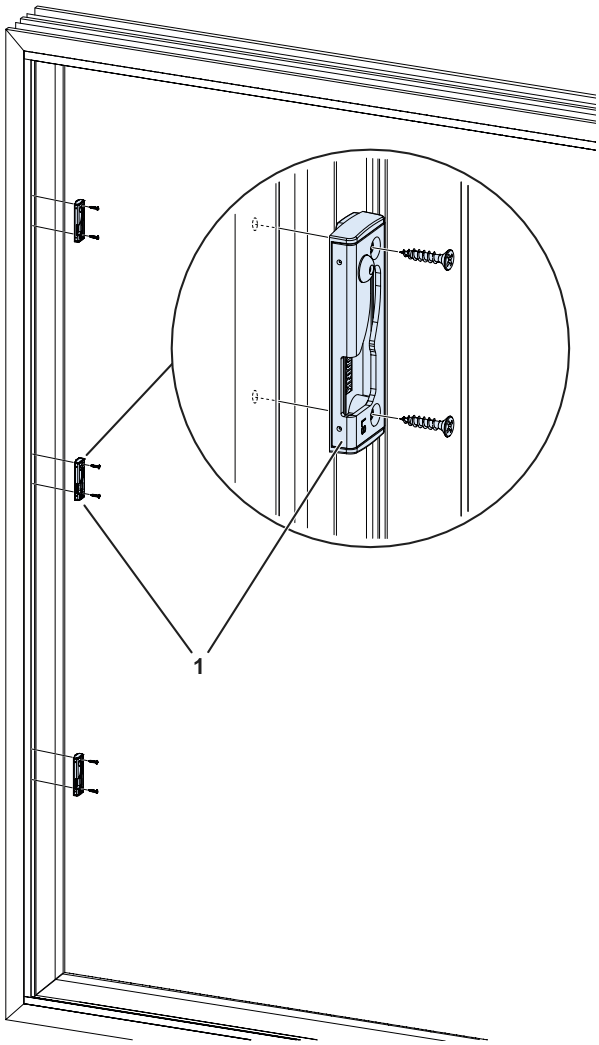


2. Slowly close the sash until the jig (1) rests on the keep rail (4).
3. Push the sash slightly open again; leave the jig in the keep rail and drill the holes through the two holes (5).
4. Install all other locking parts on the drive side in the same way.



Installing the locking parts on the drive side

1. Tighten locking part (1) with screws in predrilled holes.
2. Insert all screws for fastening the other locking parts in the same way.



6.5.8 Fitting the locking keeps on the centre stile using a jig

IMPORTANT

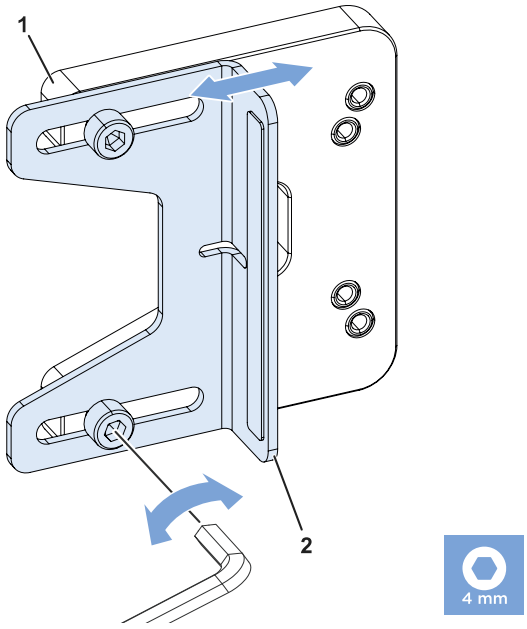
It is essential to start with the assembly step "Installing the locking parts on the drive side" in order to correctly adjust the "Jig for frame parts of centre stile"; (this is the way to bring the closed and locked sash into its end position and thus allow the keeps to be positioned correctly on the centre stile).

Adjusting the jig for mounting the locking parts on the centre stile

For correct mounting of the locking parts on the centre stile the drilling jig (1) can be variably adjusted with the help of the movable side stop (2).

1. Unfasten screws.
2. Move side stop (2) and after that tighten screws again.

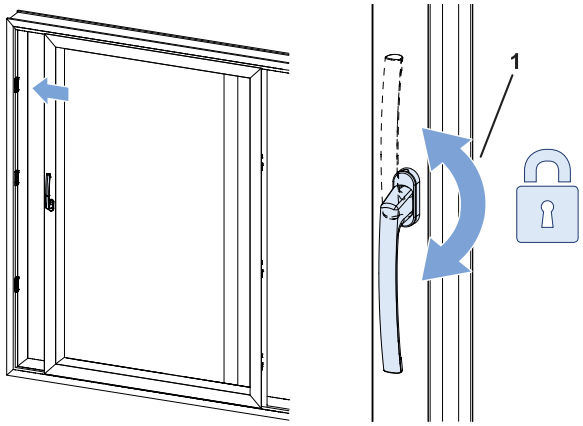
The side stop is adjusted once for each profile, provided that the sash has been correctly adjusted perpendicular to the frame.



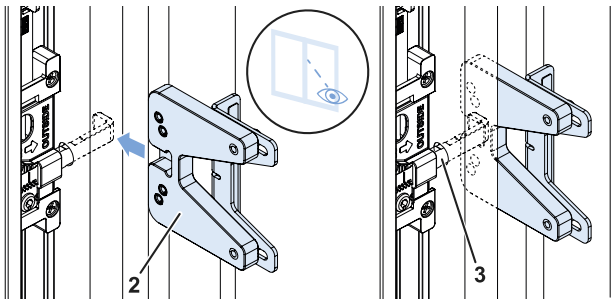
Positioning the jig for mounting the locking parts on the centre stile

The jig is used as follows to install the locking parts on the centre stile:

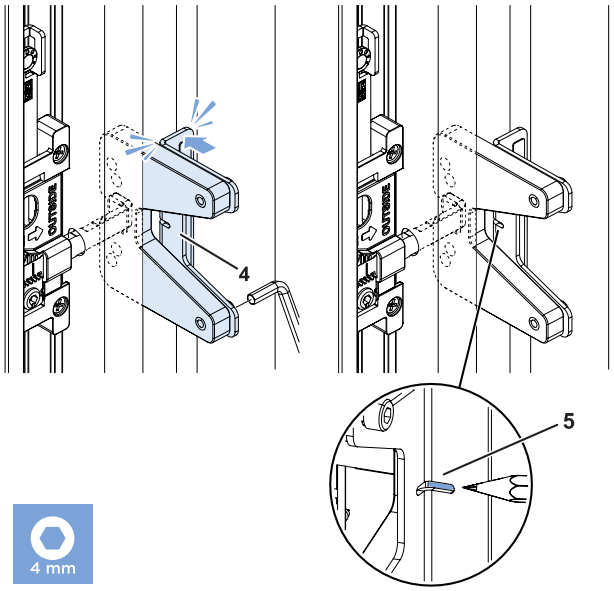
1. Slide the sash closed and lock (1).



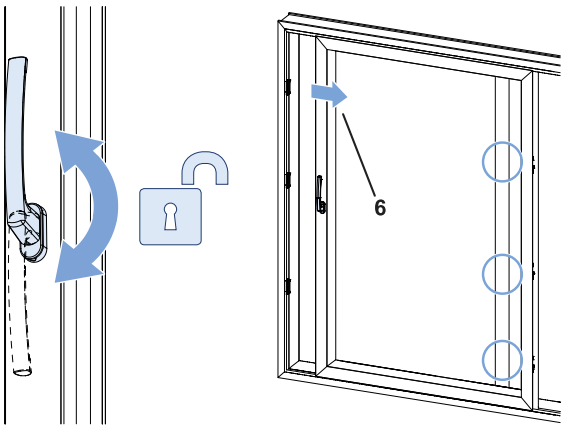
2. Place the drilling jig (2) on the deadbolt (3)between the closed sash and the centre stile.

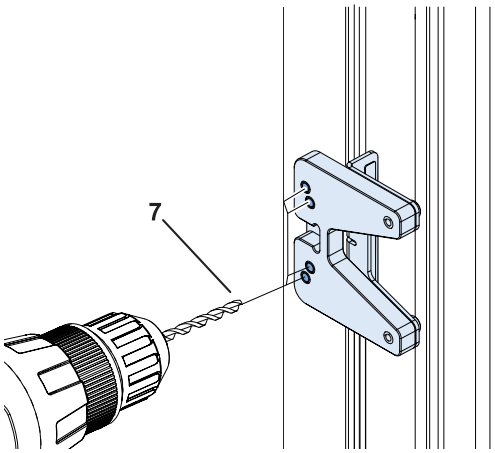


3. Push the side stop (4) up to the sash rebate edge of the centre stile and fix it with the screws.
4. Make a mark through the slot in the jig (5).



5. Remove the jig, unlock the sash and push open again (6).
6. Reposition the jig at the marking on the centre stile and drill the holes (7).
7. Proceed in the same way for all other locking parts on the centre stile.

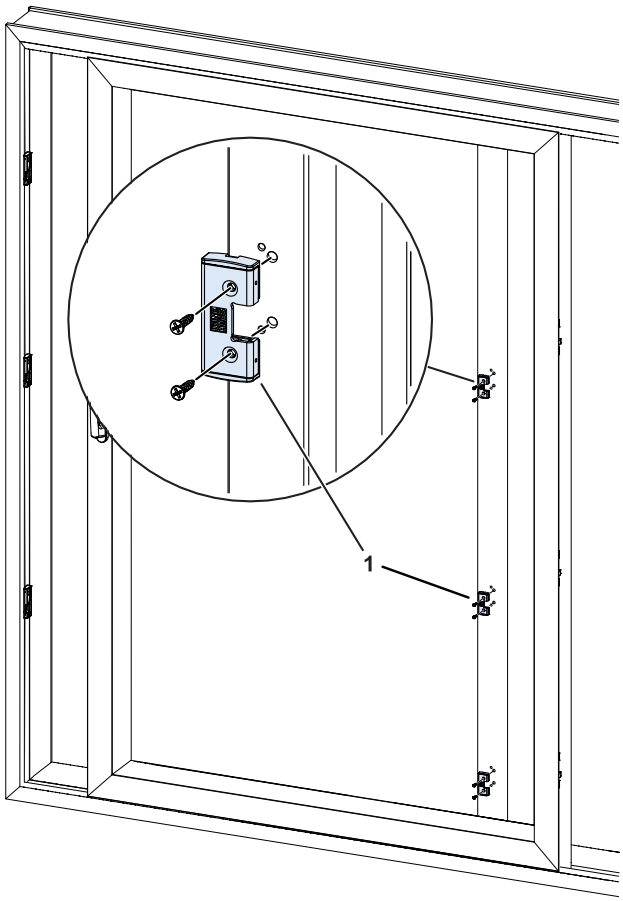




Installing the locking parts on the centre stile

1. Tighten locking part (1) with screws in predrilled holes.
2. Insert all screws for fastening the other locking parts in the same way.

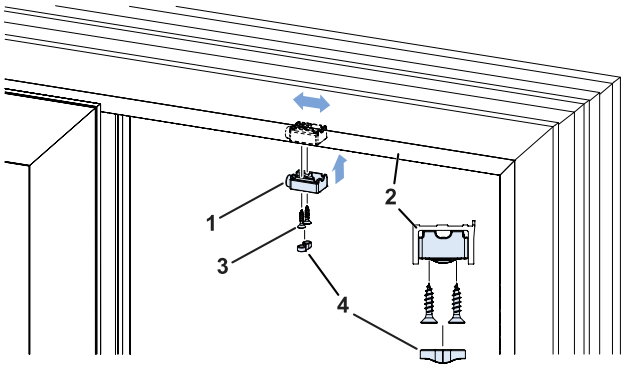
Cover caps for locking parts available in different colours for customisation of design.



6.5.9 Installing the stoppers

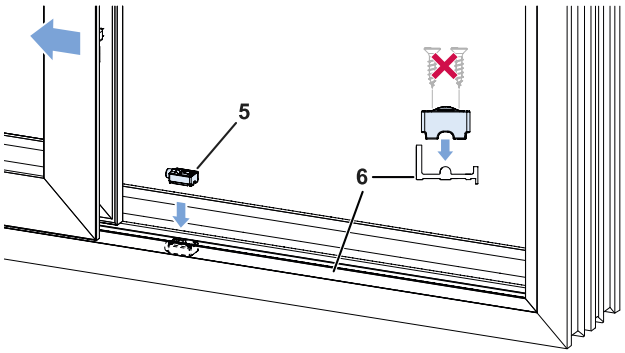
Top stopper

1. Insert the top stopper (1) into the guide rail (2) and screw it tight depending on the desired sash opening width (3).
2. Press on cap for covering the screws (4).

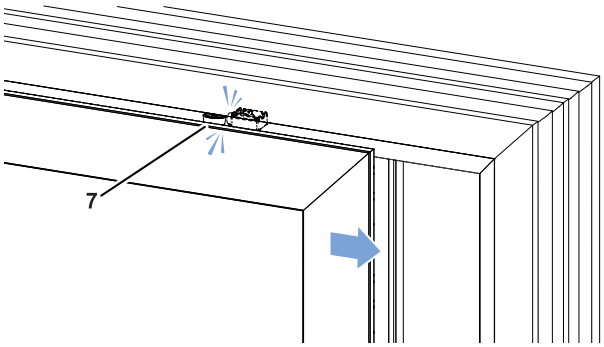


Bottom stopper

3. Insert bottom stopper (5) loosely into the slide rail (6) without fixing in place.



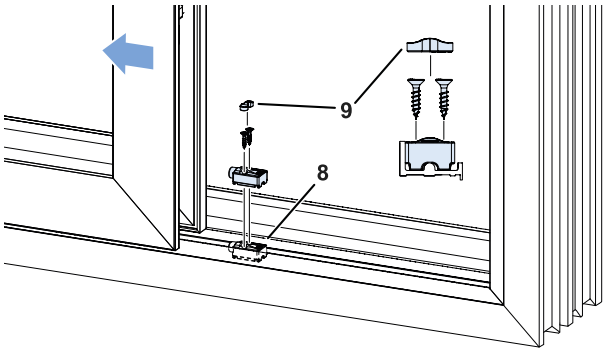
4. Open the sash and push it up to the end position against the fixed top stopper (7).



The sash moves the loose bottom stopper along with it in the slide rail.

Bottom stopper

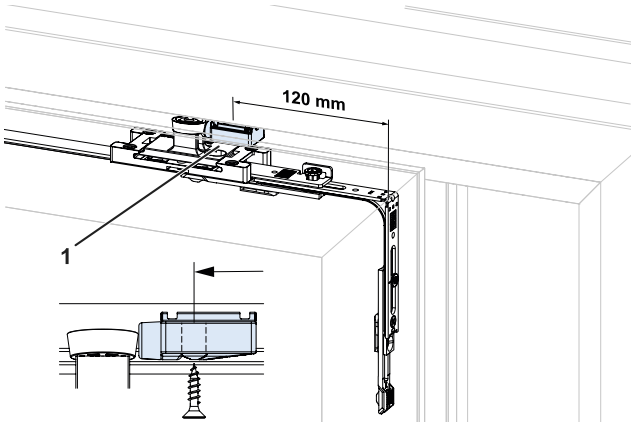
5. Tighten the bottom stopper (8).
6. Press on cap for covering the screws (9).



Positioning the stoppers with fixed dimensions

Top stopper:

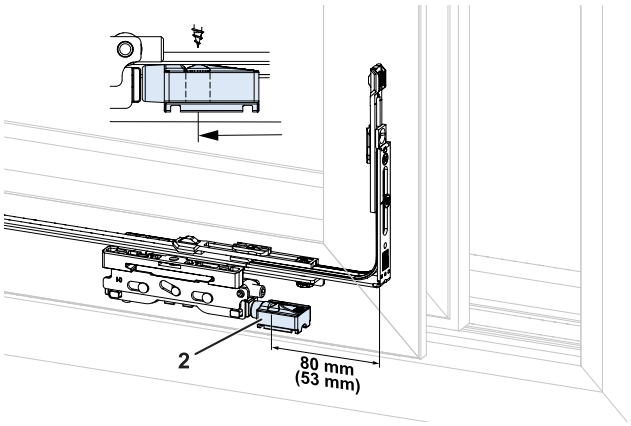
- from sash rebate to stopper drilling position 120 mm (1)



Bottom stopper:

- Sash weight up to 200 kg with standard bogies:
  from sash rebate to stopper drilling position 80 mm (2)

- Sash weight up to 250 kg with tandem bogies:
  from sash rebate to stopper drilling position 53 mm



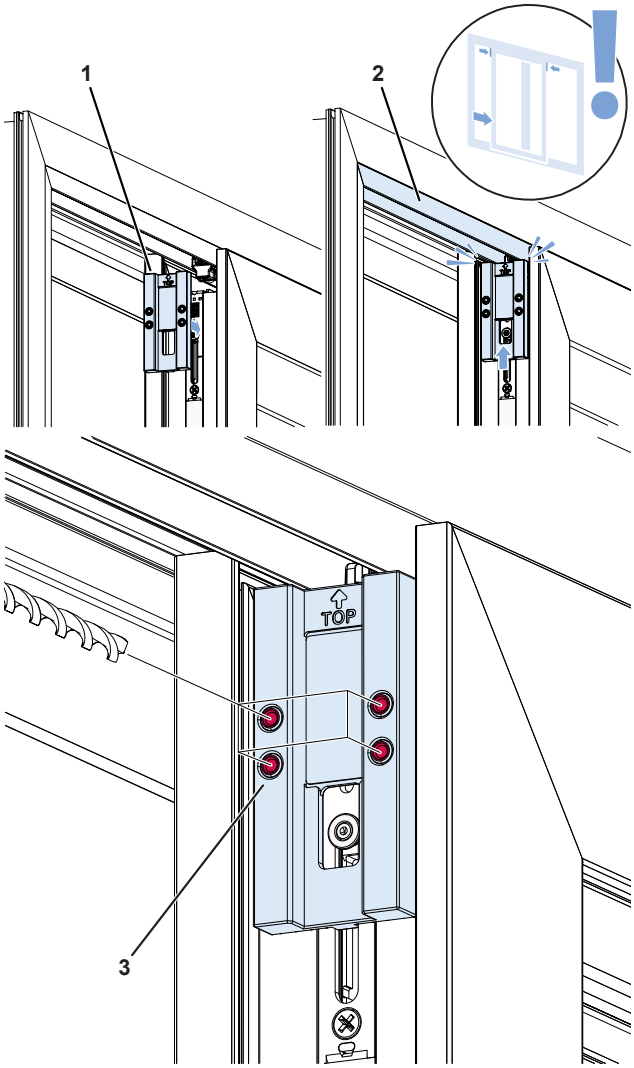
6.5.10 Installing the anti-tilt protection device (drive side and centre stile side)

Positioning the drilling jig for anti-tilt protection

To prevent the sash from tilting sideways or slipping out of the sliding rail, a tilt protection device must be fitted on both the drive side and the centre stile side.

1. Slide open the sash.
2. Place drilling jig (1) on the top corner drive on both the drive side and the centre stile side.
3. Slide drilling jig up to guide rail (2) and then predrill holes (3.2 mm) (3).

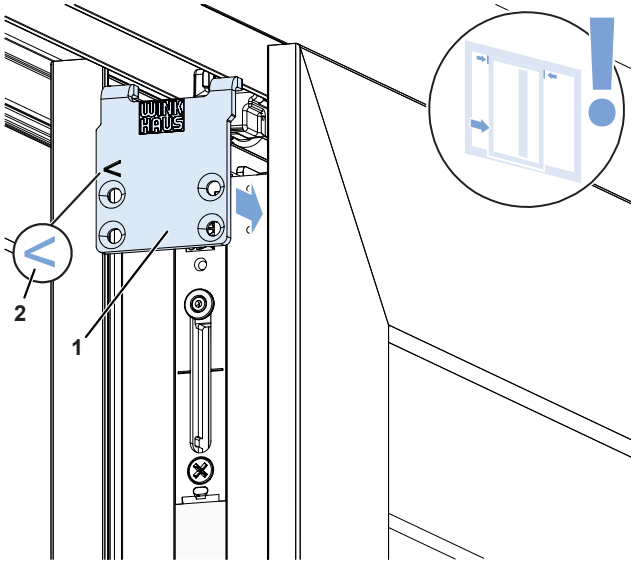
When positioning the jig, make sure that the arrow with the “TOP” marking points towards the top of the sash.

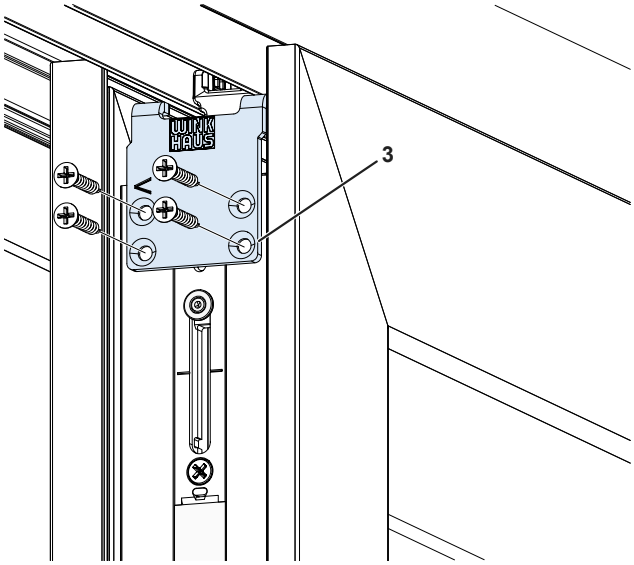


Installing the anti-tilt protection

1. Place the tilt protection device (1) on the top corner drive on both the drive side and the centre stile side.
2. Screw on the tilt protection device (3).

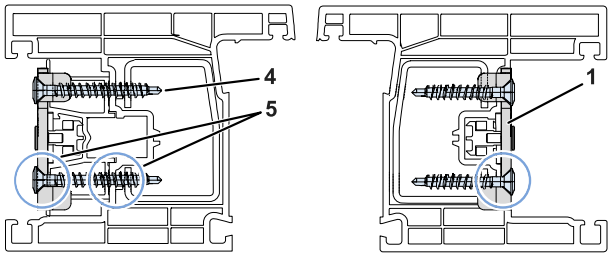
When positioning the anti-tilt device, make sure that the direction of the arrow points towards the outside of the sash (2).





IMPORTANT

Only drilling screws (4) may be used for screwing in place the anti-tilt protection device (1).
Screws must be used for all profile walls provided for this purpose (5).



6.6 Adjustment

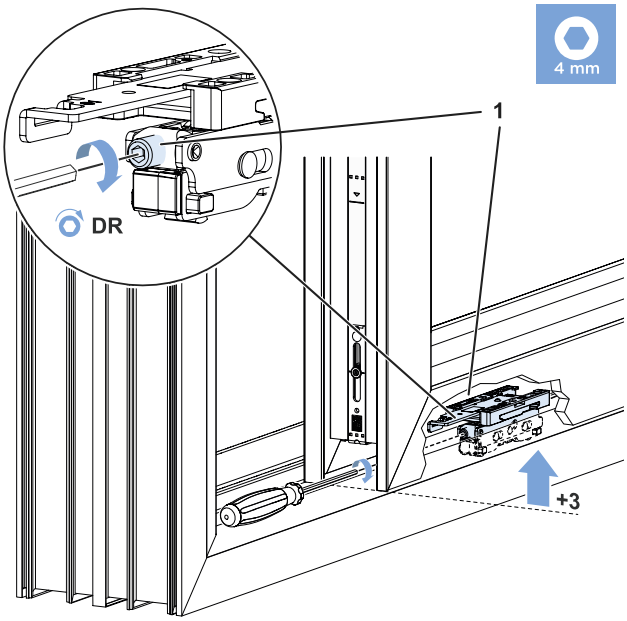
6.6.1 Adjust bogies in horizontal position

The bogies are height-adjustable. The sash can then be adjusted horizontally or vertically after it has been mounted.

1. Check the airgap on both sides of the sash.
2. Use the adjustment screw (1) to raise the bogie(s) until the sash is in its correct position.

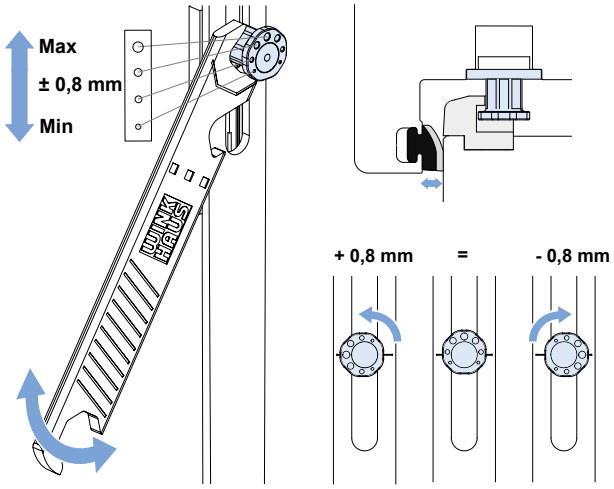
- **Turn direction DR:** Raising of the sash

From the basic setting, the adjustment screw of the bogies can be adjusted in the **turn direction DR** (clockwise).



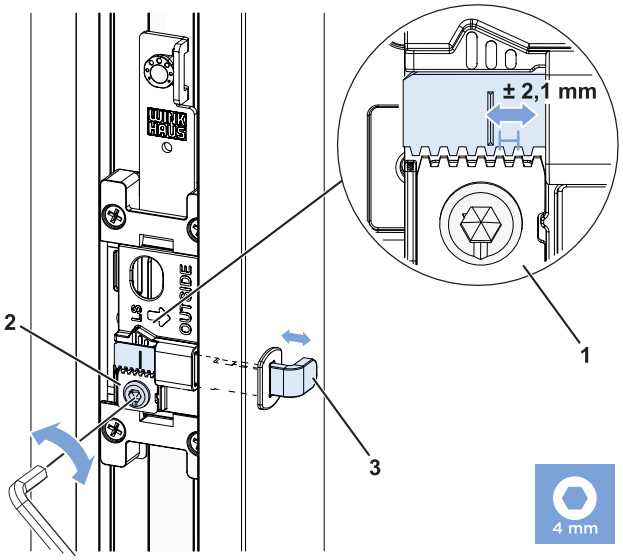
6.6.2 Octagonal bolt regulation of contact pressure

1. Adjustment between the sash and frame (0.8 mm) is possible by turning the octagonal bolt.
2. The adjustment can be carried out by means of the Winkhaus adjustment key (V.ST.SCH.HV-11).



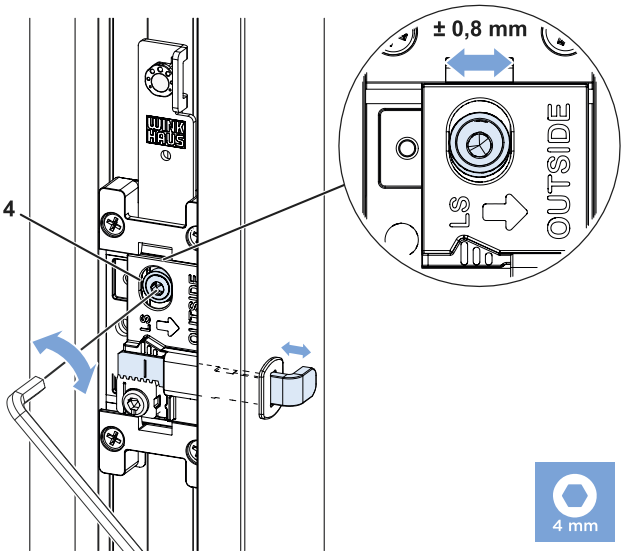
6.6.3 Adjusting the deadbolt

1. Use the eccentric cam (2) to lower the adjustment (1).
2. Move the released deadbolt (3) to the desired position by means of the gear teeth and raise the adjustment again with the eccentric cam.



1. Fine adjustment of the deadbolt (± 0.8 mm) is carried out via the upper eccentric cam (4).

   To reach the upper eccentric cam, the central locking system must be moved to the corresponding position.

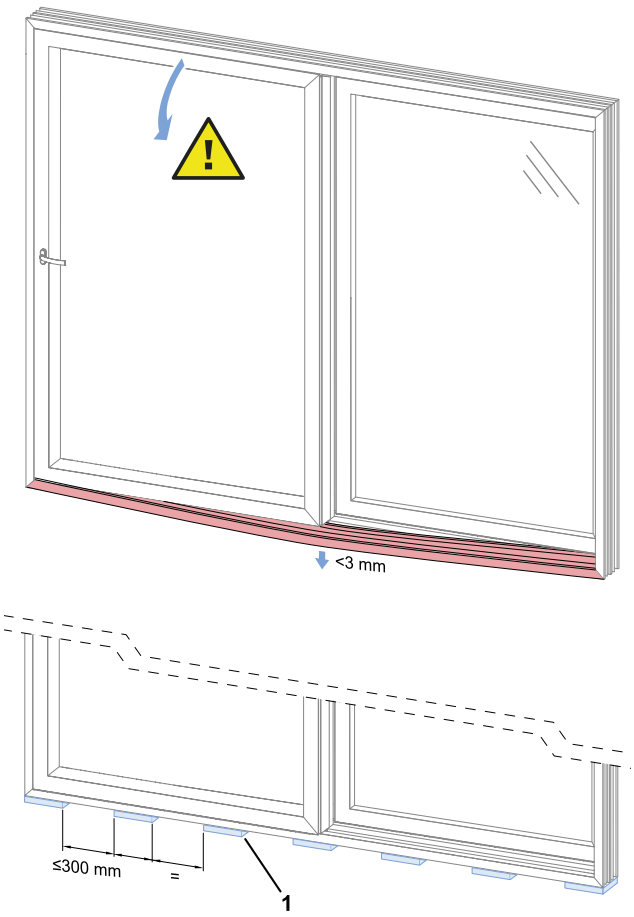


6.7 Starting operation

6.7.1 Assembly of sliding elements

When installing large-area window elements correctly, it is essential to ensure that the frame is installed in a horizontal and deflection-free manner.

The frame must be evenly filled with pressure-resistant material at a maximum distance of 300 mm and along the complete profile depth (1).



WARNING

In order to prevent any deflection, which may not exceed 3 mm, the frame must be installed on the building structure with appropriate pressure-resistant packers for further load transfer.
If this value is exceeded, functional restrictions may occur or the sash may fall out!

In addition to the basic knowledge of professional installation, the installation companies must also be familiar with the special installation properties of large-area window elements.
For installation planning, the *"Guidelines for the Installation of Windows and Doors"*, prepared by Gütegemeinschaft Fenster, Fassaden und Eingangstüren e.V., Frankfurt and the ift, Institut für Fenstertechnik, Rosenheim, can be helpful.

Start-up, use and maintenance

In order to be able to use the fitting parts on the sliding element safely and without errors, the following questions or notes must be observed:

After final assembly (target group: window manufacturers)

Have all fitting screws been fixed according to specifications?	☐
Check the tightness of the screw connections.	☐
Does the sliding sash run against the stoppers at the top and bottom simultaneously? "Installing the stoppers", page 63	☐
Keep the slide rails clean at all times to ensure optimum smooth running of the sliding sashes. It is not necessary to remove sliding sashes!	☐
Is the seal pressure optimally adjusted (adjustment options on octagonal bolt and deadbolt)?	☐

After final assembly on the construction site (target group: installation companies)

Has the frame at the bottom been installed with appropriate pressure-resistant packers for further load transfer to the building structure and thus secured against deflection?	☐
Check the tightness of the screw connections.	☐
Does the sliding sash run against the stoppers at the top and bottom simultaneously? "Installing the stoppers", page 63	☐
Keep the slide rails clean at all times to ensure optimum smooth running of the sliding sashes. It is not necessary to remove sliding sashes!	☐
Is the seal pressure optimally adjusted (adjustment options on octagonal bolt and deadbolt)?	☐
During commissioning, initial care and maintenance of the relevant fitting parts is recommended.	☐
Take measures to protect the fittings during the construction phase.	☐

After the construction phase (target group: end users)

In principle: Observance of the information in the Winkhaus operating and maintenance instructions for end users.	☐
Only clean the fittings with a soft cloth and mild, pH-neutral cleaning agents in diluted form. Never use aggressive, acidic cleaning agents or abrasives. These can cause damage to the fittings. To ensure trouble-free use, all moving fitting parts must be kept clean.	☐
Keep the slide rails clean at all times to ensure optimum smooth running of the sliding sashes. It is not necessary to remove sliding sashes!	☐
Fittings, windows and patio doors require expert, systematic maintenance/care and inspection to ensure their value retention, usability and safety. It is therefore recommended to conclude a maintenance contract with the specialist company in windows and patio doors.	☐

6.8 Handover to the end user/builder

Target group-specific documentation and handover

Target group and their responsibilities

Information on the target group and their responsibilities is presented in this manual in Chapter 1.1.

Documentation and handover

The corresponding documents must be submitted in accordance with the specifications from the above-mentioned subchapter “Information on the target group and their responsibilities”.

Unless the builder has precisely specified the components of the documentation, the minimum information of the documentation must include everything that the builder or user needs for proper operation and maintenance.

User information/operating instructions

Information stickers regarding operation can be ordered separately. It is to be positioned on the window glass within easy reach of the end user. Further information on ordering is available from your Winkhaus contact person.

7 Operation

Handle positions

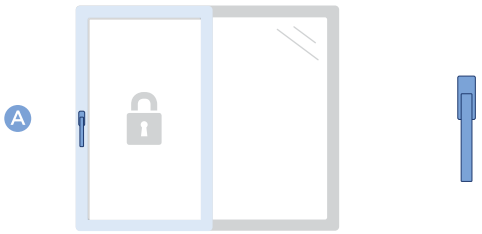
primePort AS

IMPORTANT

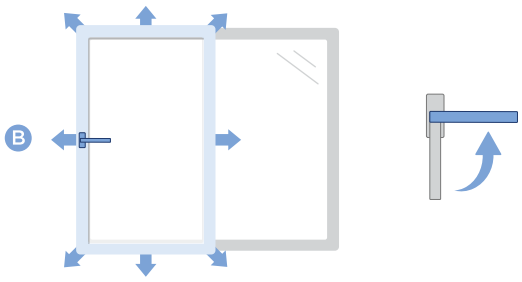
Determination of the opening direction for retract-slide elements in accordance with DIN EN 12519.

The opening direction is determined from the inside.
When looking at a closed, *“right opening sash”*, it is a “left sash”.

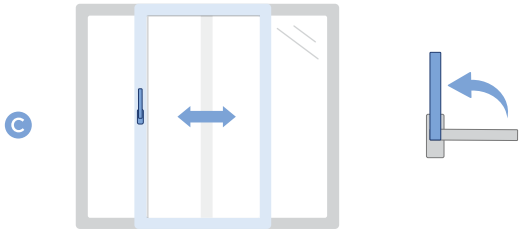
Handle position A: Locking position



Handle position B: Parallel position



Handle position C: Sliding position



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8 Cleaning and maintenance

Cleaning

Only clean the fittings with a soft cloth and mild, pH-neutral cleaning agents in diluted form. Never use aggressive, acidic cleaning agents or abrasives. These can cause damage to the fittings.

To ensure trouble-free use, all moving fitting parts or, if present, guide and sliding rails must be kept clean.

Maintenance

Fittings, windows and patio doors require expert, systematic maintenance/care and inspection to ensure their value retention, usability and safety. It is therefore recommended to conclude a maintenance contract with the specialist company in windows and patio doors.

The following minimum requirements must be observed in general and must be fulfilled for maintenance contracts:

- Grease all moving parts and all locking points of the fittings in accordance with the adjustment and maintenance instructions and check for proper function.
- Check fitting parts for secure fit and signs of wear.
- If necessary, have the fastening screws tightened by a specialist company, have adjustment work carried out on the fittings and locks and have worn components replaced.

Application of fittings	Service intervals
Schools, hotels, hospitals	every six months
Office or public building	every six months
General residential construction	annually

The following fitting diagram with marking of the relevant lubrication points does not necessarily correspond to the installed fitting system. The number of locking points will vary depending on size and type of the window sash.

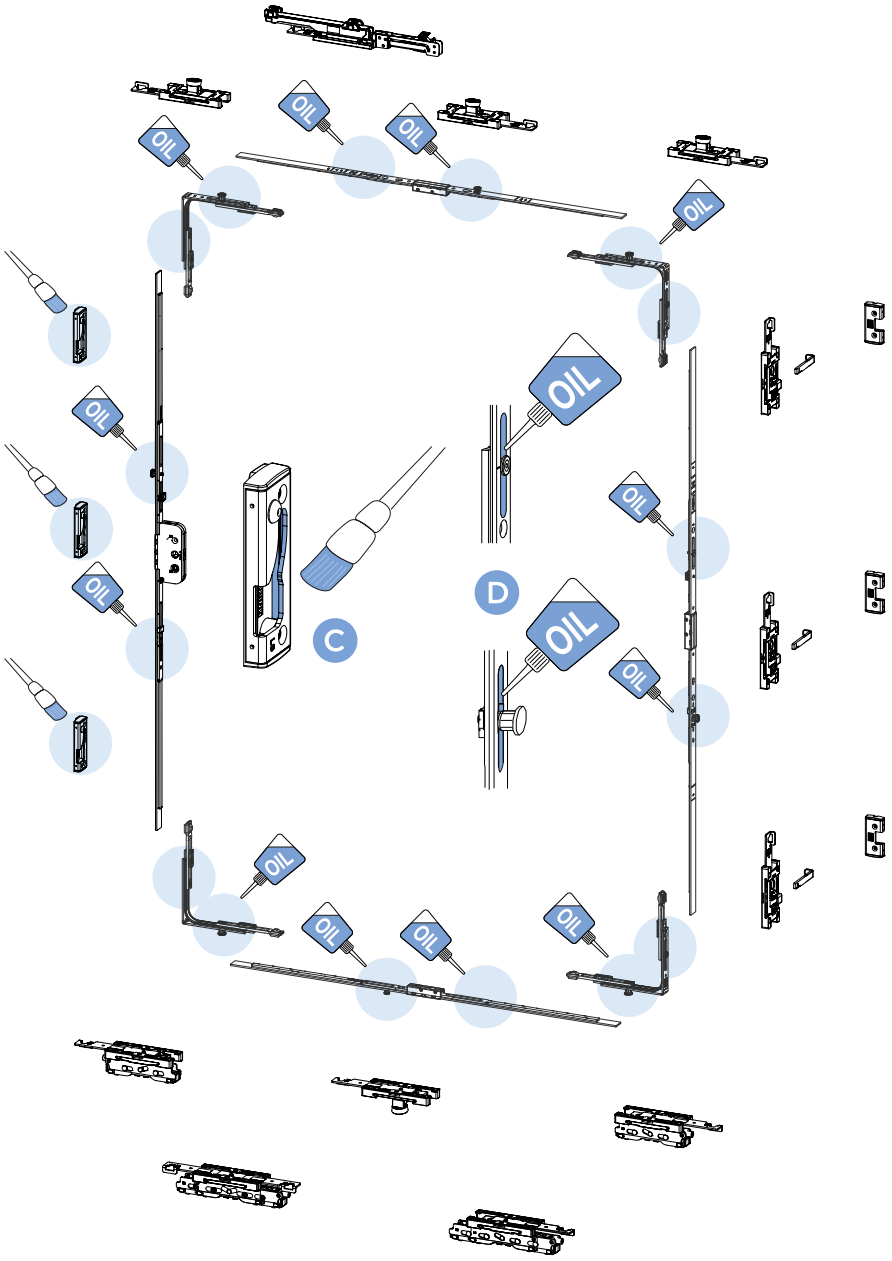
CAUTION

Risk of Injury! The window could fall on removal and thus injure persons. Do not remove the window for maintenance.

CAUTION

Adjustment work may only be carried out by a specialist company.
Adjustment work on the fittings – especially in the area of load-bearing fitting parts – as well as the replacement of parts and mounting and removal of the opening sashes must be carried out by a specialist company.

Lubrication points on the retract-slide hardware



Lubricate the locking keeps (C) at the run-in sides with technical Vaseline or another suitable grease.
Lubricate the sliding surfaces of the locking bolts (D) with a resin- and acid-free oil.

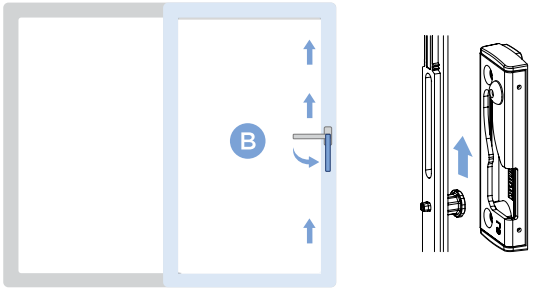
Ascertaining the run-in sides

By turning the handle to the locked position, the locking bolts of the activPilot fitting system move into the frame parts.

- Sliding sash with left handle position (opening to the right) - locked position by turning the handle clockwise (see A)



- Sliding sash with right handle position (opening to the left) - locked position by turning the handle anti-clockwise (see B)



9 Spare parts and accessories

Retrofitting, maintenance, repair, spare parts or other questions

On the Winkhaus homepage, specialist companies are listed. They are also competent contacts when it comes to e.g. retrofitting, maintenance, repair, spare parts or other questions. If questions arise regarding these topics, please also refer to the following address:

Find a partner near you
https://www.winkhaus.com/de/service/haendlersuche

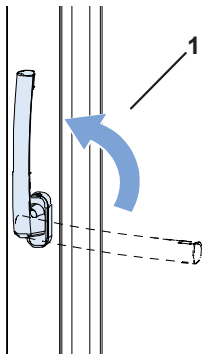
10 Dismounting

Removal of the sash

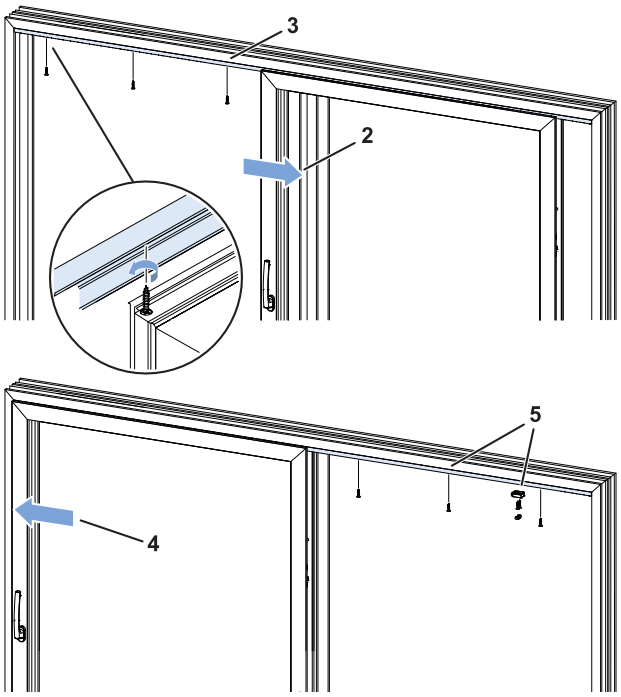
IMPORTANT

The window may only be removed by trained personnel of a window manufacturer.

1. Move the handle to the sliding position (1).



2. Slide open the sash (2).
3. Remove the screws of the guide rail on the accessible side (3).
4. Slide the sash to the other side (4).
5. Remove the remaining screws of the guide rail and the upper stopper (5).



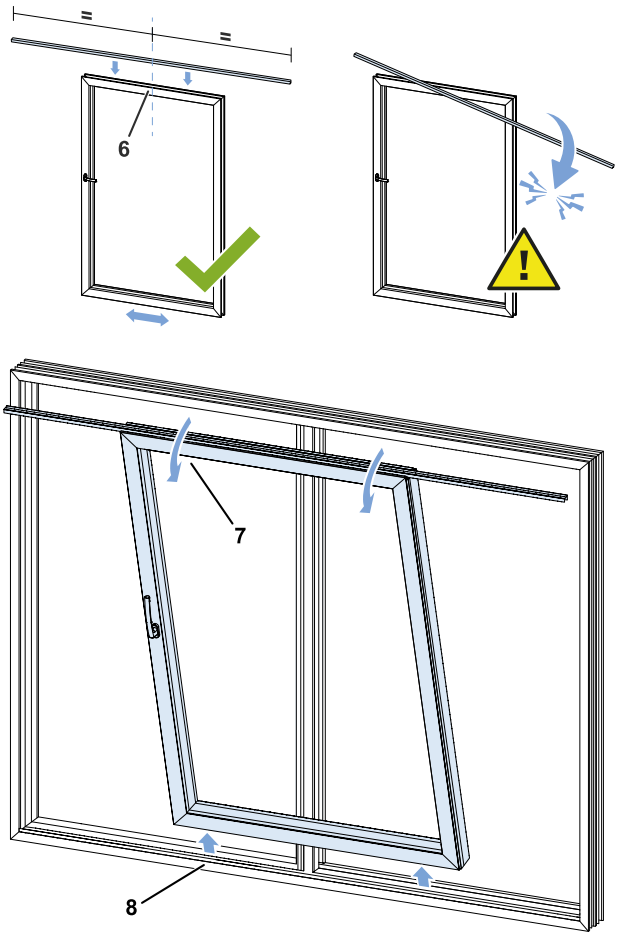
6. Slowly push the sash to the middle position so that the guide rail is in the middle of the sash (6).
7. Tilt the sash (7) and lift it off the slide rail (8).

CAUTION

The guide rail placed on the sash can fall down when the sash is removed and cause injury. Remove the sash with two persons.

WARNING

Heavy sash weight. As the sash may be heavy, there is a risk of back injury when lifting and a risk of an accident if the sash falls. Carry the sash with two persons.



Deviating from the description above, the guide rail can also be designed in several parts. In this way simplified removal of the sash can be achieved.

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11 Proper disposal

Environment

Proper disposal of fittings
When disposing of fittings, they must be recycled in an environmentally friendly manner as mixed scrap.

Environment

Disposal of packaging material
The packaging must be recycled separately in accordance with the separation regulations for packaging.

Manufactured and distributed by:
Aug. Winkhaus SE
August-Winkhaus-Straße 31
48291 Telgte
Germany

Contact:
T +49 2504 921-0
fenstertechnik@winkhaus.de

For UK imported by:
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