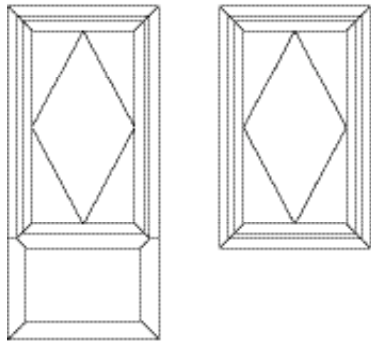
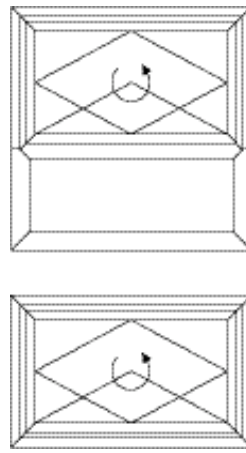


5. Pivot windows

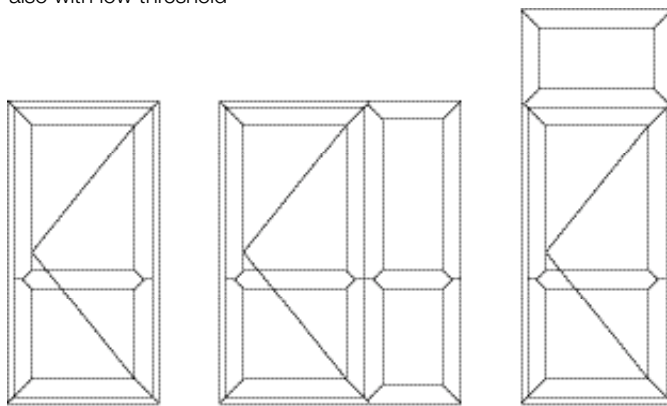


6. Fully reversible windows

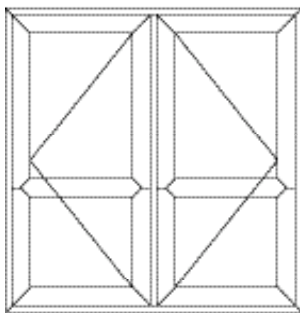


Door styles and shapes

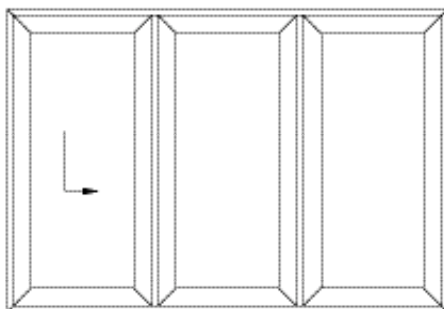
1. Residential doors – inward or outward opening; also with low threshold



2. French doors – inward or outward opening; also with low threshold



3. Tilt and slide doors



S706/REHAU-Edge – max. sizes for elements and units

S706/REHAU-Edge		Windows														
		Outward Side hung			Outward Top hung			Tilt and Turn			Pivot/Fully reversible					
Sash Style	Colour	w x h(m)	a (m²)	m (kg)	w x h(m)	a (m²)	m (kg)	w x h(m)	a (m²)	m (kg)	w x h(m)	a (m²)	m (kg)			
T sash	white	0.85x1.5	1.28	40	1.2x1.2	1.44	40									
	woodgrain	0.85x1.5	1.28	40	1.2x1.2	1.44	40									
Z sash	white	0.85x1.5	1.28	40	1.2x1.2	1.44	40									
	woodgrain	0.85x1.5	1.28	40	1.2x1.2	1.44	40									
Tilt and Turn	white													1.2x1.5	1.8	60
	woodgrain													1.2x1.5	1.8	60
Fully reversible	white										1.5x1.5	2.25	60			
	woodgrain										1.5x1.5	2.25	60			

S706/REHAU-Edge		Doors								
		Residential door			French door			Tilt and Slide		
Sash Style	Colour	w x h(m)	a (m²)	m (kg)	w x h(m)	a (m²)	m (kg)	w x h(m)	a (m²)	m (kg)
T door sash	white	1.0x2.2		100	0.8x2.2		100			
	woodgrain	1.0x2.1		100	0.7x2.1		100			
Z door sash	white	1.0x2.2		100	0.8x2.2		100	1.5x2.3		100
	woodgrain	1.0x2.1		100	0.7x2.1		100	1.1x2.3		100

Notes:

Sizes are subject to instructions given by the fitting suppliers.

Max. profile length for fixed lights = 3.0m; max. area = 6.0m²

Max. profile length for elements = 4.0m; max. area = 6.0m²

Tilt and Slide Patio Door; max. area = 8.0m²

French doors: max. sizes are calculated for a windpressure of 1600Pa and steelreinforcements with 2mm wall thicknesses

Because of the bevelled upstands on the main profiles, the relation between frame height and frame width should not be less than 2.14:1.

If it is less, a mechanically jointed transom must be fitted into its frame before the welding process is finished.

Our verbal and written application engineering advice is based upon experience and the best of our knowledge. However it is to be regarded as non-binding information. Working conditions and use under conditions for which the product was not intended and over which we have no influence exclude any claim resulting from our information. We recommend that a suitable check is made as to whether the REHAU product is suitable for the envisaged purpose. Application, use and processing of the products is carried out beyond the scope of our control and are therefore carried out exclusively at your own responsibility. If liability should still apply, then this is restricted, in the case of all damage, the value of the goods supplied by us and used by you. Our warranty applies to the consistent quality of our products as per our specification and in accordance with our general terms and conditions of delivery and payment. This document is protected by copyright. All rights based on this are reserved. No part of this publication may be translated, reproduced or transmitted in any form or by any similar means, electronic or mechanical, photocopying, recording or otherwise, or stored in a data retrieval system.

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REHAU S706 and REHAU-Edge® System Description



Windows
make
houses



General Description

The REHAU S706/REHAU-Edge Window and Door System comprises of a range of multi-chambered profiles that are designed to meet the requirements of the new build, commercial and domestic refurbishment markets.

There are two aesthetic options to choose from S706 is predominantly a chamfered system with a sculptured 'T' Sash option and REHAU-Edge is a suite of fully sculptured profiles.

The main profiles are three-chamber construction with a depth of 70mm. They allow for combinations of most windows and doors to be manufactured in customised styles to the following window types/styles:

- Internally beaded casement window
- Externally beaded casement window *
- Doors – residential, tilt/slide and French doors
- Tilt and turn window
- Pivot window-horizontal *
- Fully reversible window-horizontal and vertical *
- Conservatory

The whole range of profiles is available in an un-gasketed and in a pre-gasketed (S706 IG) versions. The S706 IG system is fully weldable and our integrated gaskets can be replaced if necessary as it is cold rolled inserted gasket and therefore easy to remove.

Windows are generally fully welded, however transom/mullion/ door mid-rails can be mechanically jointed (if required) using dedicated injection mouldings *.

Glazing thickness from 4 to 42mm can be accommodated (double or triple glazing) with either internal or externally * fitted glazing beads, 28mm is the more common option. Single glazing can be incorporated as an internally beaded option.

Galvanised steel reinforcement sections are available for all main profiles to meet most specification requirements.

The REHAU S706 system has been proven over many years. The main profiles are extruded in accordance with BS7413/BS EN 12608. The system holds both the BSI (Kitemark) and is BBA approved.

Range of Colours

REHAU S706/REHAU-Edge is available in white and a range of woodgrain laminate options as follows:

- Mahogany *, rosewood and golden oak one side on a white base
- Mahogany * and rosewood both sides on a brown base
- Golden oak both sides on an acorn base

- A further range of woodgrain and solid colour laminate options are available on special order.

REHAU-Edge is also available in Mahogany on special order.

- Profiles can also be finished in over 150 RAL colours using the REHAU Acryl II Colour Coating System.

Fittings

All modern standard fittings and hardware (including shootbolts, hook locks and 'dog' bolts) can be used and are available from various fitting suppliers.

Product Options

The various window and door options can be manufactured in custom styles, sizes and finishes. Product differentiation can be achieved with the use of different shaped low level glazing beads (putty line/ogee) and/or glazing gasket colours (black/white).

Material

REHAU window profiles are manufactured from high performance, weather-resistant and impact modified RAU-PVC 1406, a material that has proven itself in twenty five years of window system production and that has all of the physical characteristics laid down by DIN7748 as PVC U-D-E080-25-28 and in the BS7413/BS EN 12608 requirements.

Quality Assurance

REHAU profiles are subjected to the most stringent in-house quality controls incorporating a quality assurance system to BS EN/ISO 9001 ensuring consistency of quality. The following procedures are carried out, starting with checks on incoming raw materials and finishing with inspections on finished goods.

a) Goods Inward Control

All raw materials delivered to us are sampled and subjected to stringent tests as laid down by a set of required standards. Any products that do not meet these requirements are sent back to the supplier.

b) Control of the blending process

A sealed system ensures the consistent quality of the blending process. This is achieved by an automatic process that constantly monitors the system and updates the mixture.

c) Profile checks for correct dimensions and surface quality

- Profile dimensional checks
- Checks on surface flatness and smoothness
- Colour consistence checks
- Checks on profile twist or bow

d) Checks on the chemical and physical properties of the profile

- Deviation checks from required dimensions
- Impact resistance at low temperatures
- Notched impact strength
- Methyl-chloride test
- Corner weld strength test
- Weather resistance tests

Quality control of independent bodies

In order to confirm the values produced by ourselves, we invite independent test institutes to test both our profiles and our windows.

We have test certificates for the REHAU S706 window system with BSI and BBA. Furthermore the fully reversible system has been tested by MACDATA. Further requirements to meet BS6375 Part 1 (Wind resistance and weather performance), BS7950 (Security) and PAS 23/24 (Security performance for doors) have been achieved.

Performance of REHAU S706/REHAU-Edge

■ Thermal Insulation

As a three-chamber system S706/REHAU-Edge meets all the modern requirements for thermal performance including complying fully Part L (England and Wales) Part J (Scotland) Building Regulations for Conservation of Fuel and Power.

The current values achieved with the REHAU S706 profiles are:

Main Frame with Sash:
(Un-reinforced) 1.4 W/m²K (U-value)
(Reinforced) 1.7 W/m²K (U-value)

REHAU is currently working towards BRFC Energy Ratings and the results will be available soon.

■ Sound Insulation

For windows and doors, the sound insulation largely depends on the glazing units used, in particular the variation of glass thickness and air space dimensions.

For example:

Double glazing 4-12-4mm: 30dB
Double glazing 6-12-4mm: 34dB

Why 70mm?

- REHAU S706/REHAU-Edge 70mm frames cover the old mastic line left when replacing the majority of timber windows (less trimming up).
- Large windows and elements can be manufactured
- Fittings and hardware can be fixed into steel if required
- Good thermal efficiency (low U-value)
- Can incorporate a wide range of single, double and triple glazing 4-42mm
- Can incorporate heavy-duty hardware.

* Doesn't apply to REHAU-Edge

Technical notes/ technical sales arguments

All main profiles are triple chamber, which ensures good thermal insulation (low U-value) while keeping the drainage route separate from the reinforcement chamber.

A large reinforcement chamber enables galvanised steel to be inserted for additional strength/rigidity when necessary.

Screw ports are extruded to secure fastenings of espagnolettes and/or hinges when required. Hardware can also be fastened into steel reinforcement.

The height of the REHAU S706/REHAU-Edge glazing rebate optimises edge cover to give good protection to the sealed units.

An 8mm sash to frame overlap allows the whole seal to remain in contact with the PVCu. The twin compression seals in EPDM, Integral gasket or high quality

silicone gaskets ensure excellent air and water tightness even after many years of use, which exceed the requirements of BS4255 and BS7412.

Sashes and frames can be concealed drained/vented through dedicated internal chambers via drilling or routing.

The leg details of the REHAU S706/REHAU-Edge are compatible and allow the use of a wide range of REHAU supplementary and connection profiles.

Single leg glazing beads clip in along their whole length and are available in a wide range of different styles and sizes.

There is also a choice of sills available, which allow concealed drainage and are available in a width of 95mm, 150mm and 180mm and use a standard stack height of 30mm to simplify window size calculations.

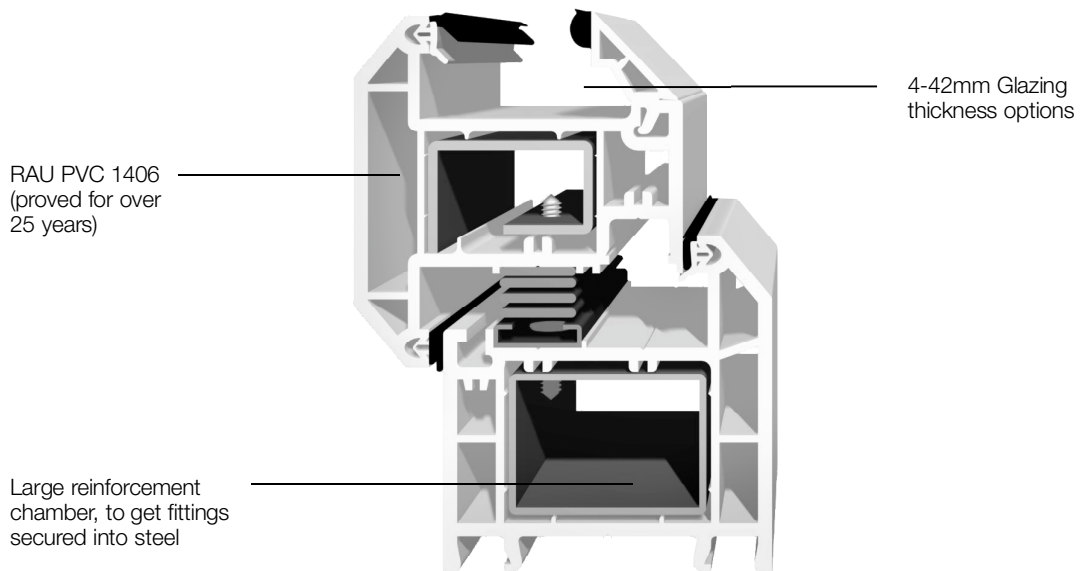
All main profiles are delivered with

protective tape covering the visible faces – including the chamfered and sculptured details.

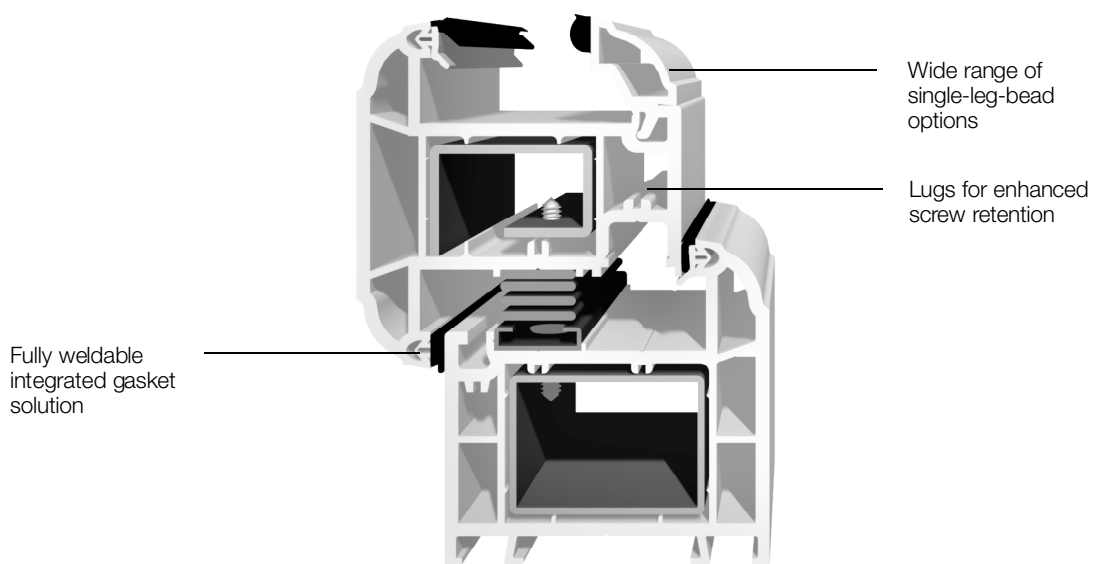
Comprehensive ranges of load bearing bay, bow bay and corner post details are available. A clever 'internal butt' system allows angles from 120° – 135° and 150° – 170° to be manufactured without change to the frame sizes. The popular 90° and 135° angles are also manufactured as fixed angle solutions.

The REHAU S706/REHAU-Edge window and door systems are tried and tested with third party accreditation and certification. They hold the prestigious BSI Kitemark, BBA approval and are extruded in accordance to BS7413/BS EN 12608.

S706 Internally beaded chamfered profile section:



S706 REHAU-Edge Internally beaded sculptured profile section:

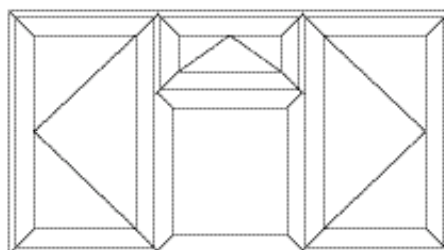
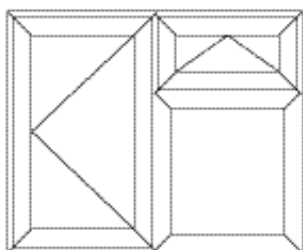
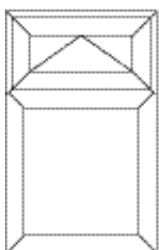
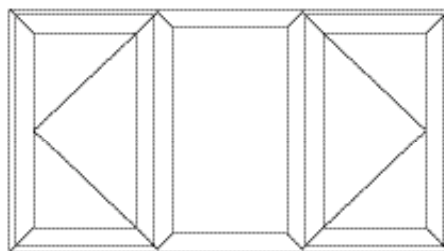
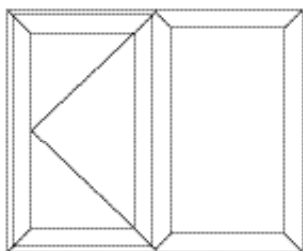
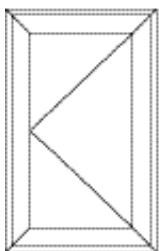


Window styles and shapes

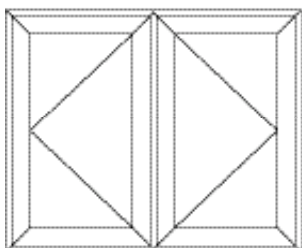
1. Fixed light



2. Casement windows



3. French windows



4. Tilt and turn windows

