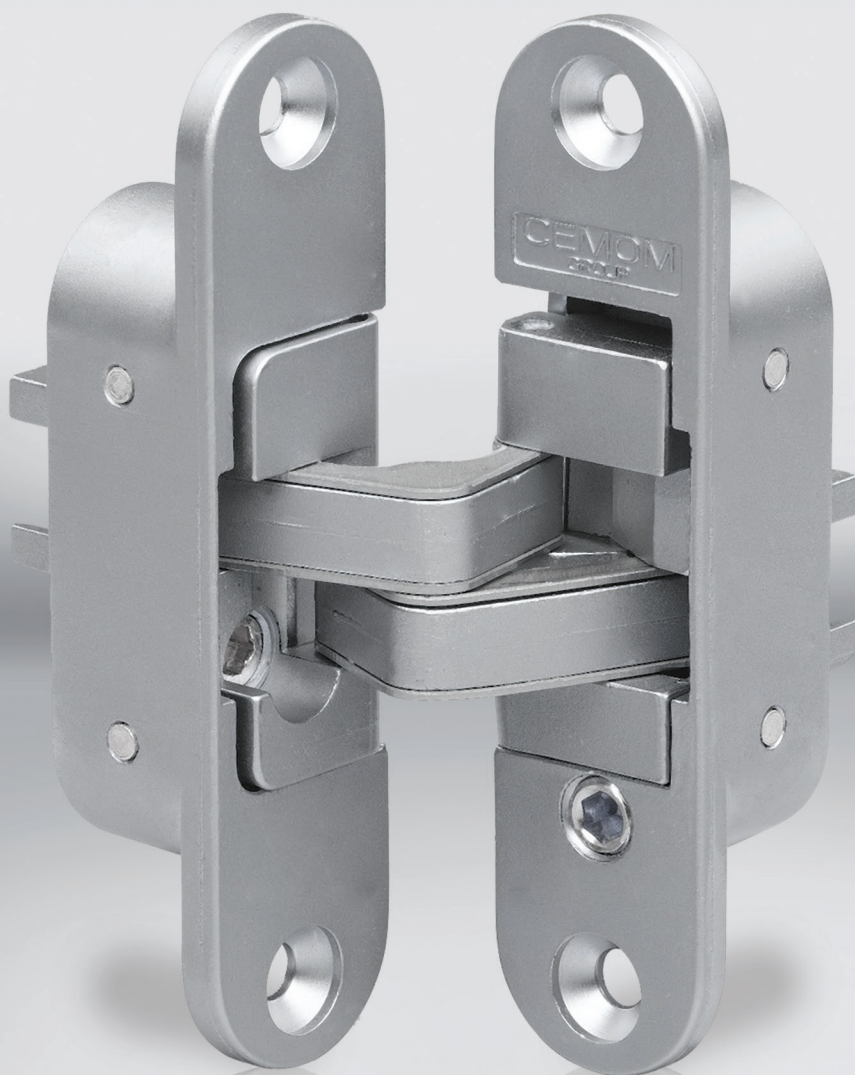


D-SIGN

Concealed Hinge
W 978-00-00 R(L)



FINISHING



BRASS 8031



BRONZE 8033



OLD BRASS 8034



BRUSHED BRASS 8036



SPECIAL BRONZE 8038



CHROME 8040



SATIN BRASS 8046



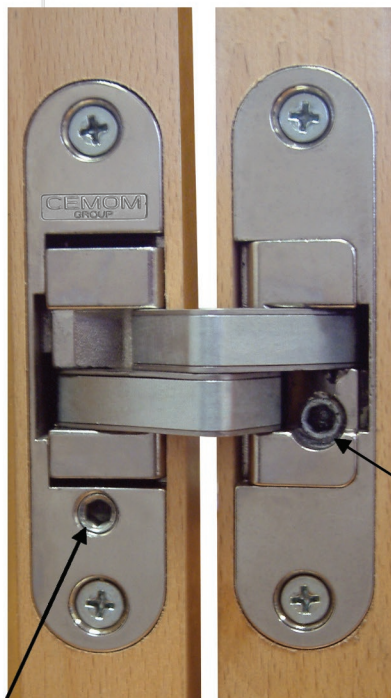
NICKEL 8050



NICKEL SATIN 8054



CHROME SATIN 8060

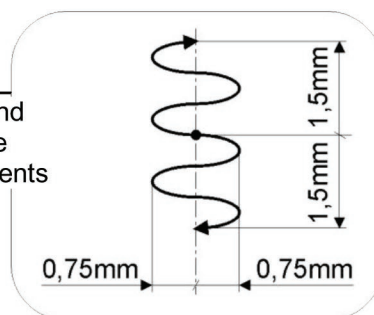


Description:

W 978-00-00 R(L) is a hinge earmarked for internal flush doors. The hinge enables the wing to open 180° and be adjusted in three directions (height, width, pressure on seal), the hinge is invisible when the wing is closed. The adjustment is made by screwing in the screw with hexagonal wrench S = 4mm; screw „1” is used to adjust the height, and screw „2” is used to adjust the width and the pressure on seal simultaneously. The hinge does not need to be lubricated before putting into operation, or during the planned period of use. In case the lubrication is necessary (due to the working conditions or prolonged period of operation) oil aerosol should be used. The hinge body is plated with galvanic NICKEL, and the plates exposed to friction are made of INOX steel.

„1” 0÷3mm
Height adjustment

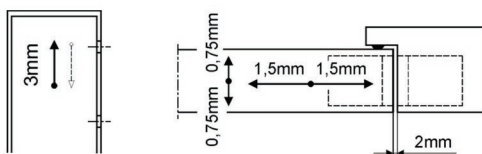
„2”
Width and
pressure
adjustments



CERTIFICATIONS



Fire rating : PN-EN 1634-1 : 2009



Number of hinges	Width of window wing [mm]				
	600	700	800	900	1000
2	50 kg	46 kg	42 kg	40 kg	36 kg
3	56 kg	51 kg	48 kg	45 kg	40 kg
4	63 kg	57 kg	53 kg	50 kg	45 kg

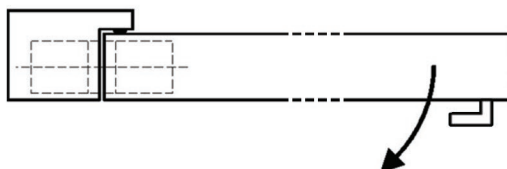
According to EN1935 the classification is as follows:

1 4 2 0 1 1 0 6

With correct adjustment (all hinges carrying the load), the suggested admissible weight of a wing depending on the number of hinges and the wing width, at the wing height of 2000 mm minimum has been presented in the table. The first wing should always be checked.

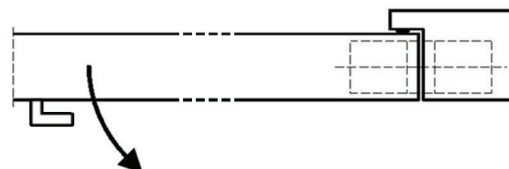
W 978-00-00 L

The W 978-00-00 L hinge should be used for left opening door.



W 978-00-00 R

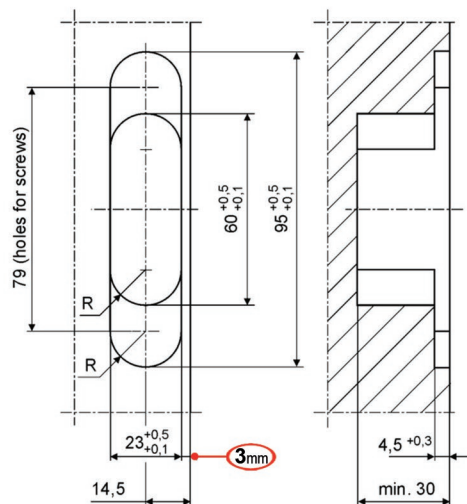
The W 978-00-00 R hinge should be used for right opening door.



External dimensions of the W 978-00-00 R hinge and all functional dimensions are shown in the drawing included in the offer.



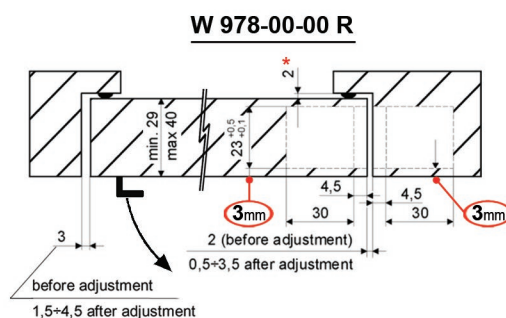
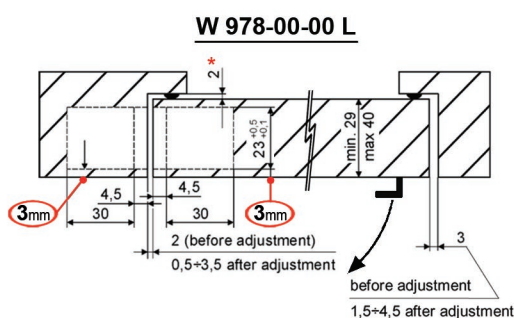
Milling cutter dimensions of sockets. The diameters of holes for screws shall be determined depending on the dimensions of the screws and the type of wood used. The diameter of the screws may not exceed 5 mm.



3mm = 3mm to be absolutely respected

Position of the hinge in relation to the required dimensions of the wing and frame.

3mm = 3mm to be absolutely respected



* MINIMUM 2mm
(ACCORDING TO THE GASKET TYPE)

DECLARATION OF CONFORMITY
CERTIFICAT DE CONFORMITE; DEKLARACJA ZGODNOŚCI;
KONFORMITÄTSEKLRUNG; ДЕКЛАРАЦИЯ СООТВЕТСТВИЯ

DZ_1_2008

1. Product's manufacturer;

Fabricant du produit; Producent wyrobu; Warenhersteller; Производитель изделия

CEMOM 28, ALLEE DU PLATEAU, 93-250 VILLEMOMBLE – FRANCE www.cemom.com;
POL-SOFT Spółka z o.o. 77-400 Złotów, ul. Brzozowa 3 REGON: 001394449 ; KRS:0000183990 ; NIP:778-00-40-911 ; PL 7780040911

2. Product's name

Nom du produit; nazwa wyrobu; Warenname; Название изделия

Hinge with XYZ adjustment;

Charnière avec réglage XYZ; Zawiasa z regulacją XYZ; Band mit XYZ-Einstellung; Петля с регулировкой XYZ

**W 978-00-00 R NICKELE
W 978-00-00 L NICKELE**

3. 83 02 10 90 – code INTRASTAT; kod INTRASTAT ; обозначение по INTRASTAT

4. Use and scope of application in compliance with the reference document

Destination et domaine d'application conformément au document de référence; Przeznaczenie i zakres stosowania zgodnie z dokumentem odniesienia; Bestimmung und Anwendungsbereich nach dem Bezugsdokument; Назначение и область применения в соответствии с документом отнесения

CONSTRUCTION JOINERY

MENUISERIE DE BATIMENT; STOLARKA BUDOWLANA; HOLZBAUELEMENTE; СТОЛЯРНО-СТРОИТЕЛЬНЫЕ ИЗДЕЛИЯ

5. Reference documents

Documents de référence; Dokumenty odniesienia; Bezugsdokumente; Документ отнесения

EN 1935 SINGLE-AXIS HINGES;

CHARNIERES AXE SIMPLE; ZAWIASY JEDNOOSIOWE; EINACHSIGE AUFSCRAUBBANDER; ПЕТЛИ С ОДНОЙ ОСЬЮ

CLASSIFICATION acc to EN 1935

CLASSIFICATION selon; KLASYFIKACJA wg.; KLASSIFIKATION nach; КЛАССИФИКАЦИЯ в соответствии с нормой

1	4	2	0	1	1	0	6
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6. REMARQUES ; NOTE; UWAGI; BEMERKUNGEN; ПРИМЕЧАНИЯ

The hinge does not need to be lubricated before putting into operation, or during the planned period of use. In case the lubrication is necessary (due to the working condition or prolonged period of operation) oil aerosol should be used.

Zawias nie wymaga smarowania przed rozpoczęciem eksploatacji jak również w planowanym okresie eksploatacji.

W przypadku wystąpienia konieczności nasmarowania (ze względu na warunki pracy lub wydłużoną eksploatację) należy stosować aerozol olejowy.

7. Test report

Protocole des tests; Protokół z badań nr; Prüfzeugnis;

Сертификат исследования

POLSOFT D 1/2008

I hereby declare assuming full responsibility that the products comply with the reference documents mentioned in point 5 ;

Je déclare sous la pleine responsabilité que les produits sont conformes aux documents de référence mentionnés au point. 5; Deklaruję z pełną odpowiedzialnością, że wyroby są zgodne z dokumentami odniesienia wymienionymi w pkt 5; Ich erkläre mit voller Verantwortung, dass die Waren mit den unter Pkt. 5 genannten Bezugsdokumenten konform sind; Заявляю с полной ответственностью, что изделия соответствуют документам отнесения, указанным в пункте 5.

Złotów, 11.01.2008

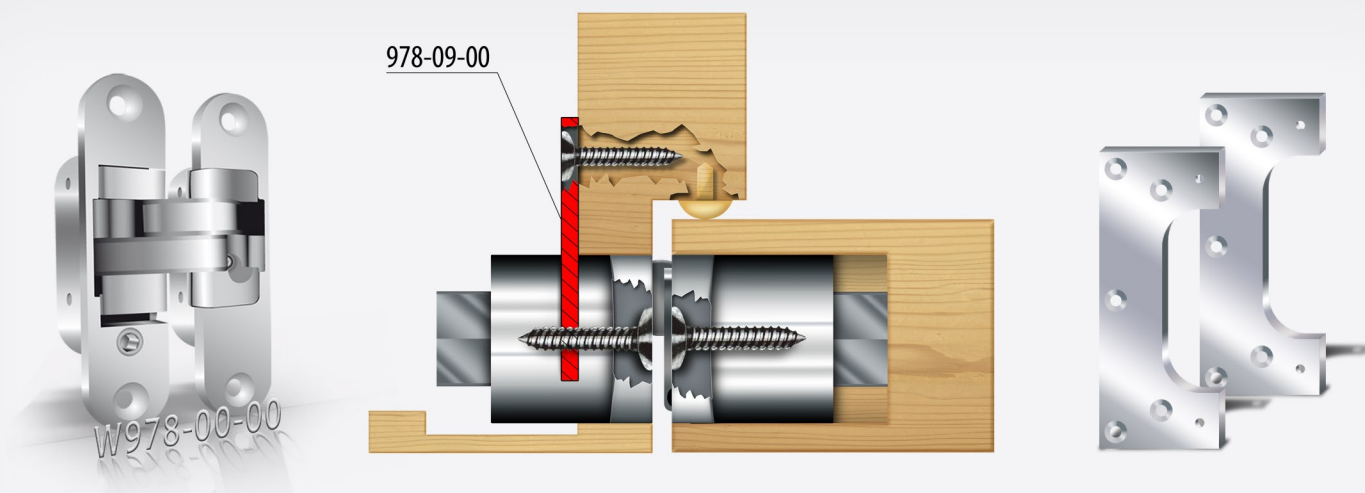
“POL-SOFT” Spółka z o.o.
77-400 ZŁOTÓW
ul. Brzozowa 3
tel. 067/ 263 30 08 fax: 067/ 263 30 09
REGON 001394449 NIP 778-00-40-911

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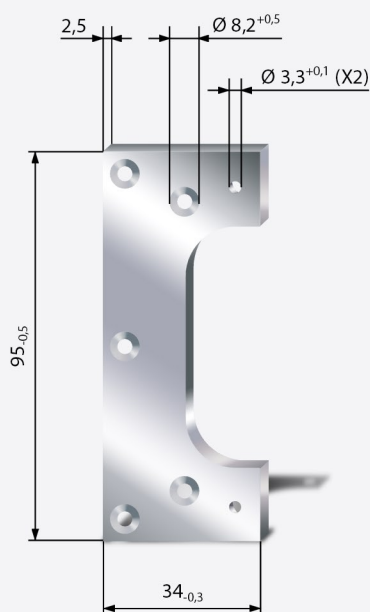
DYREKTOR
CZŁONEK ZARZĄDU
Spółki z o.o. „POL-SOFT”
W ZŁOTOWIE
(inż. Andrzej Brzeziński)

PLAQUE DE MONTAGE / MOUNTING PLATE / MONTAGEPLATTE / PŁYTA MONTAŻOWA / МОНТАЖНАЯ ПЛАСТИНА

978-09-00 & 978-09-00/A

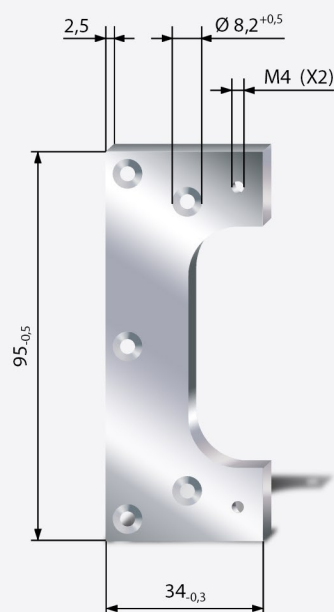


Emballage / Packaging / Verpackung / Opakowania / Упаковка



REF : 978-09-00

Q : 250



REF : 978-09-00/A

Q : 250

Vis / Screws / Schrauben / Wkręty / Винты

978-09-00/A
*w8005*9



978-09-00/A

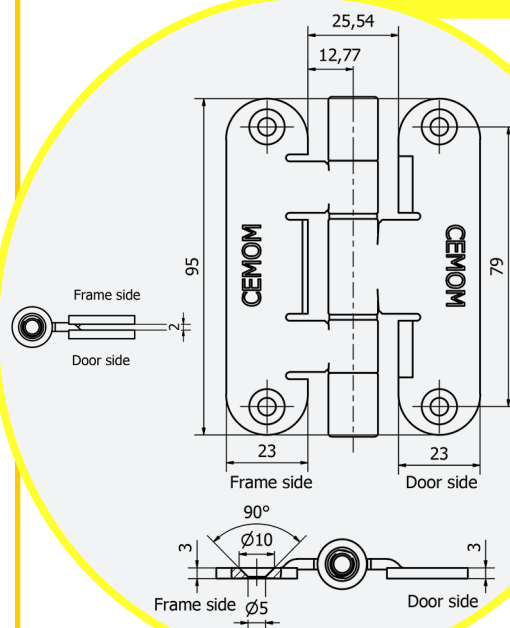
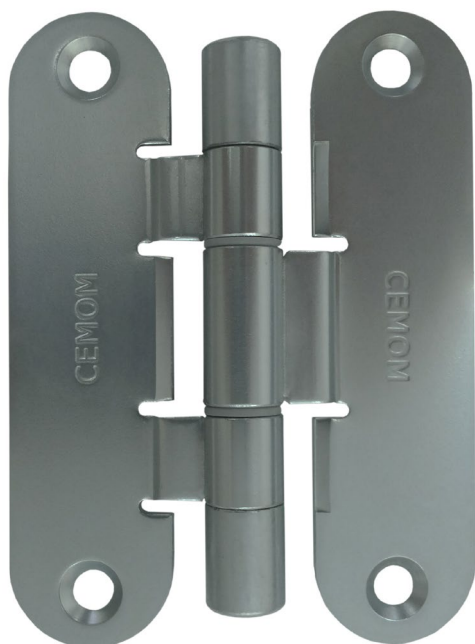


5X Ø5x25 + 2X M4x40



1 Bag

Holz Türen
Wooden Doors
Portes Bois
Drzwi drewniane
деревянные двери



REF / CODE : **I 978-00-00 / B**

Tragkraft 3-Bänder / Load-3-hinges / Charge 3-fiches / Obciążenie dla 3 zawiasy / Вес створки 3-петли: 45 kg (*)

EN 1.4.2.0.1.X.0.6

Verpackung Packing unit Emballage Pakowana Упаковка	Komplett / complete	50 St / pcs	1 Kartons / Box	7 kg
	Flügelteil / Sash part / P.Femelle / Łozyskowe / Створочная часть			
	Rahmenteil / Fram part / P.Mâle / czopowe / Рамная часть			

Beschichtung Coating Traitement surface Wykonczenie покрытия				

Schablone / Jig	Gabarit / Szablon	Шаблоны	Einzel / Single / Simple / Sztuk / Отдельно	Komplett / Set / Complet / Komplet / В комплекте
Gefälzt / Rebated	Recouvrement / Przylgowe	п / наплав		
Ungefälzt / Flush	A fleur / Bez przylgowe	б / наплава		

(*) nur zur Information
(laut Angaben der EN

(*) for information only
(under application of EN
specifications)

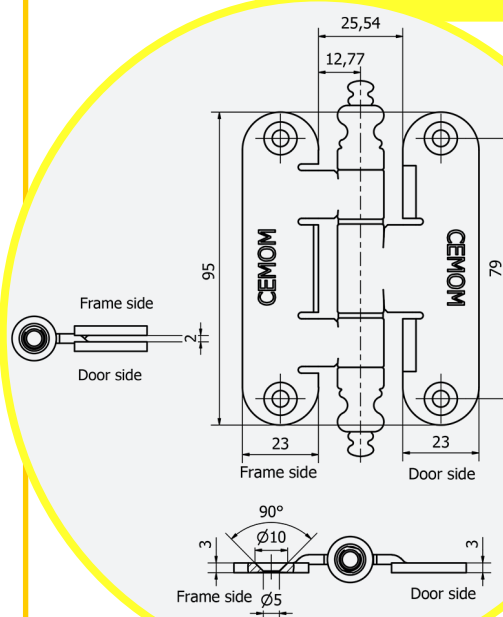
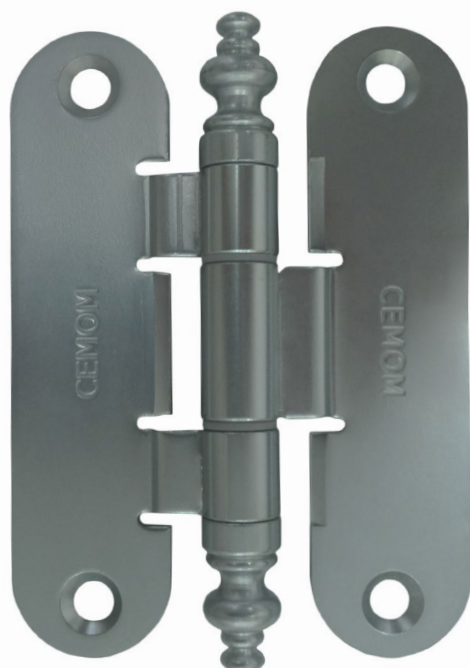
(*) valeur indicative
dans les conditions
d'application EN

(*)Wartość identyfikująca
zawarta jest w kodzie EN

(*) только для информации
(согл. данным EN)

 **POLSOFT**

Holz Türen
Wooden Doors
Portes Bois
Drzwi drewniane
деревянные двери



REF / CODE : **I 978-00-00 / BS**

Tragkraft 3-Bänder / Load-3-hinges / Charge 3-fiches / Obciążenie dla 3 zawiasy / Вес створки 3-петли: 45 kg (*)

EN 1.4.2.0.1.X.0.6

Verpackung Packing unit Emballage Pakowana Упаковка	Komplett / complete	50 St / pcs	1 Kartons / Box	7 kg
	Flügelteil / Sash part / P.Femelle / Łozyskowe / Створочная часть			
	Rahmenteil / Fram part / P.Mâle / czopowe / Рамная часть			

Beschichtung Coating Traitement surface Wykonczenie покрытия				

Schablone / Jig	Gabarit / Szablon	Шаблоны	Einzel / Single / Simple / Sztuk / Отдельно	Komplett / Set / Complet / Komplet / В комплекте
Gefälzt / Rebated	Recouvrement / Przylgowe	п / наплав		
Ungefälzt / Flush	A fleur / Bez przylgowe	б / наплава		

(*) nur zur Information
(laut Angaben der EN

(*) for information only
(under application of EN
specifications)

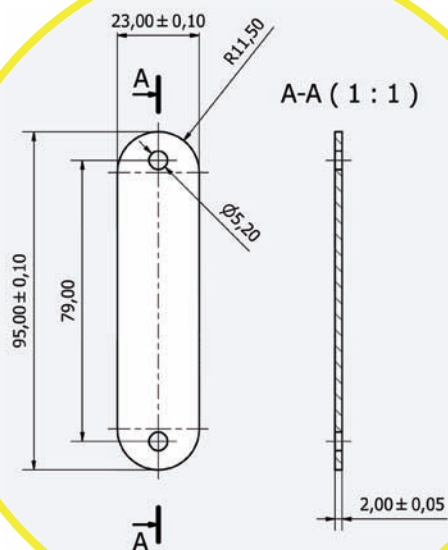
(*) valeur indicative
dans les conditions
d'application EN

(*)Wartość identyfikująca
zawarta jest w kodzie EN

(*) только для информации
(согл. данным EN)

POLSOFT

Holz Türen
Wooden Doors
Portes Bois
Drzwi drewniane
деревянные двери



REF / CODE : **978-10-00**

Verpackung Packing unit Emballage Pakowana Упаковка	Komplett / complete	100 St / pcs	1 Kartons / Box	0,8 kg
	Flügelteil / Sash part / P.Femelle / Łozyskowe / Створочная часть			
	Rahmenteil / Fram part / P.Mâle / szporowe / Рамная часть			

Beschichtung Coating Traitement surface Wykonczenie покрытия				

Schablone / Jig	Gabarit / Szablon	Шаблоны	Einzel / Single / Simple / Sztuk / Отдельно	Komplett / Set / Complet / Komplet / В комплекте
Gefälzt / Rebated	Recouvrement / Przylgowe	п / наплав		
Ungefälzt / Flush	A fleur / Bez przylgowe	б / наплава		

(*) nur zur Information
(laut Angaben der EN

(*) for information only
(under application of EN
specifications)

(*) valeur indicative
dans les conditions
d'application EN

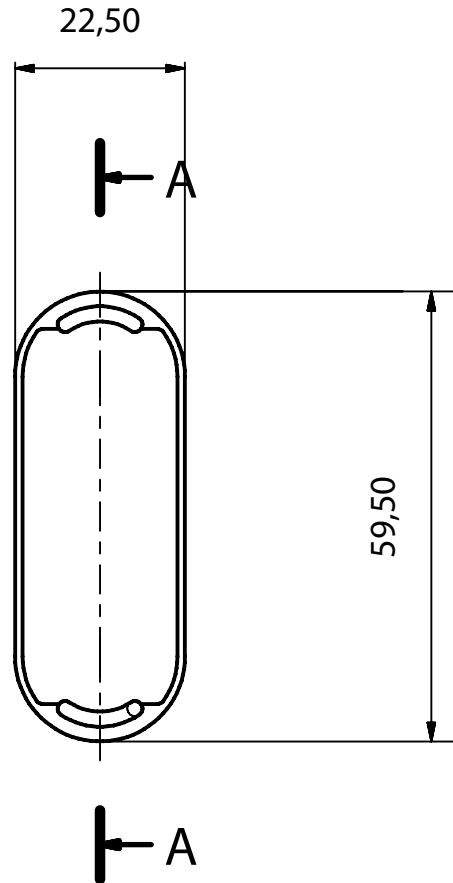
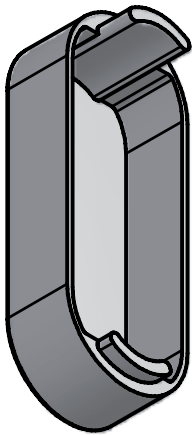
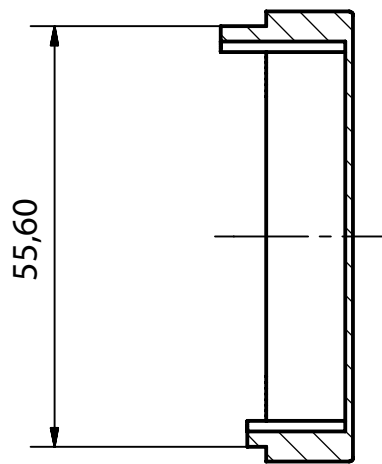
(*)Wartość identyfikująca
zawarta jest w kodzie EN

(*) только для информации
(согл.данным EN)

POLSOFT

Angle tolerance					Length tolerance						
Arm length	>10	>10-50	>50-120	>120-400	Section length	>3	>3-6	>6-10	>10-30	>30-120	>120
Dimension without tolerance	+/-1°	+/-30'	+/-20'	+/-10'	Dimension without tolerance	+/-0,1	+/-0,15	+/-0,18	+/-0,25	+/-0,35	+/-0,75
Toler. for approx. dimension	+/-4°	+/-2°	+/-1°	+/-30'	Toler. for approx. dimension	+/-0,5	+/-0,6	+/-0,75	+/-1,0	+/-1,7	+/-3,0

A-A (1 : 1)



				Ref: 978-12-00	
				Weight:	
				CEMOM <i>moatti</i> ☐ POL SOFT	
08.11.2011		D.J	was: Poliamid; now: Polietylen HD RAL7035	28 Allée du plateau 93250 Villemomble Tel. +33.1.49.35.08.54 Fax: +33.1.49.35.08.52	
P.O	27.06.2011	D.J	Creation of the plan		
Index	Date	By	Plan changes		
		Scale: 1:1	Range: Cap	Material: Polietylen HD RAL7035	Pol-Soft Sp. z o.o. Dział Handlowy Tel. 67 263 22 46 Fax: +48 67 263 30 09
Ref: 978-12-00				Design by: D.J	
					Verified by: D.J

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JIG. FOR W978

- JIG ALONE : S978

- JIG ON SLIDEWAY Sp2 978 (2 FRAMES)
- JIG ON SLIDEWAY Sp3 978 (3 FRAMES)
- JIG ON SLIDEWAY Sp4 978 (4 FRAMES)

Instruction for hand pocket milling
of W 978 hinges with the use of the Sp2-4 978 master

Purpose: **small batch production** (with lack of CNC milling machine)

1. Introductory information

- a) For manual making of hinge pockets W 978 R (L) in small batch production we offer the Sp2-4 978 master

The offered master enables pocket making, according to the recommendations in the HINGE INFORMATION CARD, without marking the place of hinges position on the door.

With the offered master it is possible to make pockets in left and right door alternately, separately in door leaves and frames provided that for the mating door leaves and frames the same arrangement of frames on the slideways is maintained.

The Sp2-4 978 master (Fig.1.) consists of:

- frames mounted on the slideways (2 or more frames) for hole milling 23x60x30;
- pocket milling frame 23x95x4,5 in bulk;
- milling cutter d.12 with a set of stabilizing and pilot sleeves;
- drill d. 12,5 with resistance sleeve;

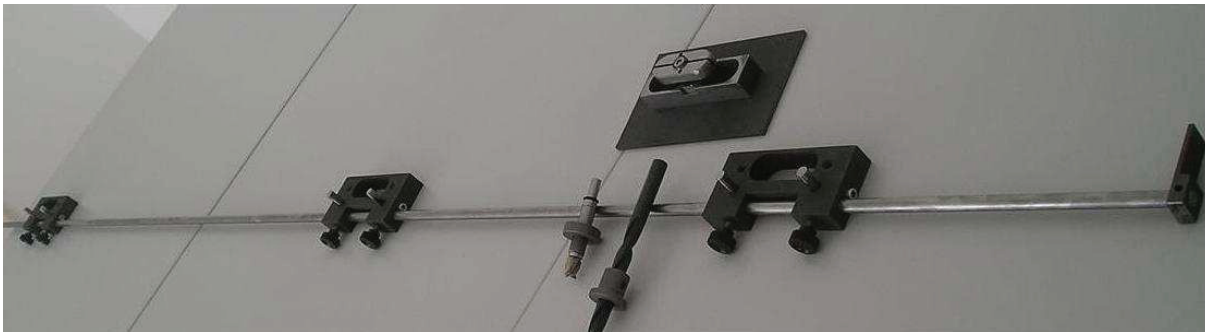


Fig.1. The Sp2-4 978 master

Depending on the number of frames mounted on the slideways the numbers of the complete master are as follows:

- with two frames – Sp2. 978;
- with three frames – Sp3. 978;
- with four frames – Sp4. 978;

- b) To make a pocket apart from above mentioned complete master you need:

- 2,5m measure tape with 1 mm scale
- hand mill enabling fixing the d. 8 milling cutters with cylindrical grip and equipped with a stand for milling depth adjusting,
- wood drill d.13;
- drill with the torque of min 10 Nm,
- self-drilling screws d.4x30 (you can use those screws to screw down the hinge)
- 6 sides allen keys 3 and 6
- scraper to chamfer hole edges in wood

(Fig.2.)



Fig.2. Tools needed to make pocket.

2. Further steps in pocket making

- a) select the master (Fig.3) with proper number of frames mounted on the slideways (min. 2, max. 4);



Fig.3. Master with frames on the slideways.

- b) properly set frames on the slideways paying attention they are in the same plane and block them by screwing home,
- c) put the slideways with frames on the door frame (Fig.4) paying attention to the proper arrangement of the end stop and rest buttons – rest buttons always set up on the outside of door frame and leaf (Fig.5.) and screw down the frames with the screws (Fig.6.).



Fig.4. Slideway with frames on the door frame.



Fig.5. Proper arrangement of the end stop and rest buttons.

Then:

- drill lead hole (Fig.7.) with d.12,5 drill to the depth of min 30 mm (the maximum depth depends on the profile size) While setting up resistance sleeve take into account master's height of 20 mm;

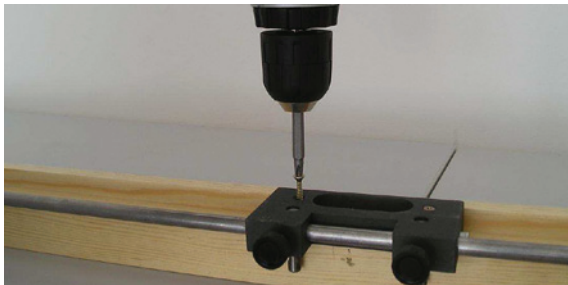


Fig.6. Screwing down frame with screws.

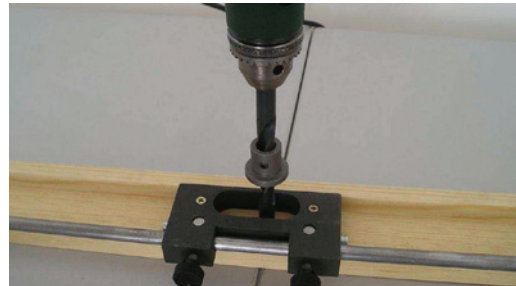


Fig.7. Drilling lead hole with d.12,5 drill.

- mill holes of 23x60x30 (Fig.8.) using three passes with properly protruding milling cutter (Fig.9.) for first pass 33 mm (Fig.10.), for second pass 45 mm (Fig.11), for third pass 50,5 mm (Fig.12.); (pay attention to precise cutter sleeve leading on hole track in the frame and after each pass remove the chips) Given dimensions include master's height;



Fig.8. Milling holes 23x60x30 using three passes.



Fig. 9. Properly protruding milling cutter.

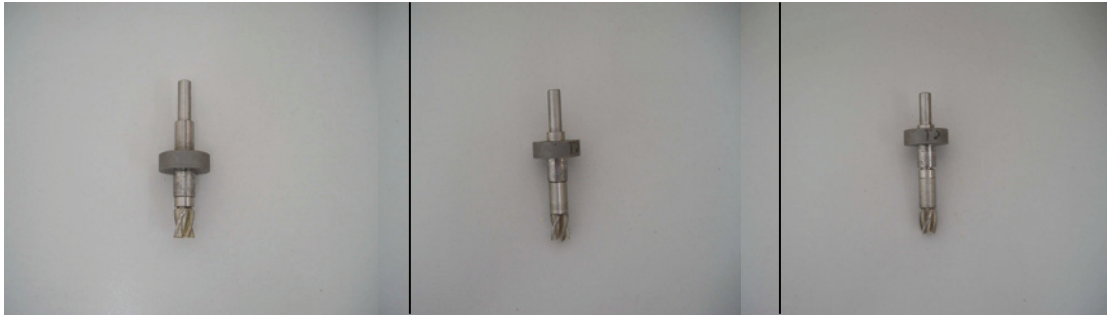


Fig.9. First pass.

Fig.10. Second pass.

Fig.11. Third pass.

- disassemble the master by screwing out fixing screws
- chamfer sharp hole edges

d) make analogical actions from point c on the door leaf (Fig.13a, Fig.13b)

Note: the order of points c and d is interchangeable



Fig.13a. Preparing for door leaf treatment.

Fig.13b. Slideway with frames on the door leaf.

e) successively in each of made pockets fasten the frame to make a hole of 23x95x4,5 (Fig.14.) and drill the hole (Fig.15.). For milling pull out the milling cutter for the distance of 24,5 mm – given dimension includes master's height (Fig.16.), (pay attention to precise cutter sleeve leading on hole tracks in the frame)

After particular hole making take off frame and chamfer sharp hole edges.



Fig.12. Frame mounting.

Fig.13. Hole milling.

Fig.14. Arrangement of milling cutter.

Work safety:

1. Apply all the work safety rules provided for working with hand moulding machine.
2. In view of master uniqueness, turn on the milling machine revolutions after inserting the milling cutter in the lead hole and torn off before removing the cutter from the frame hole.