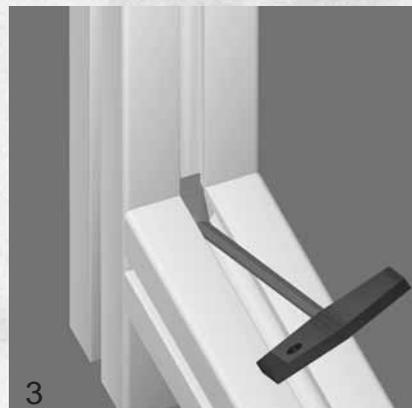
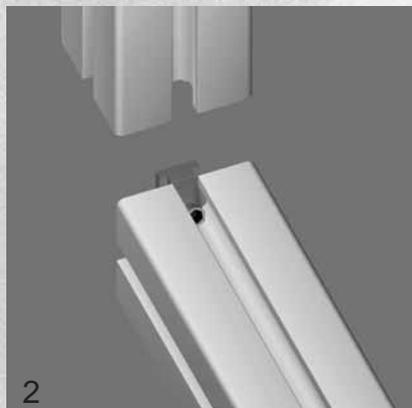
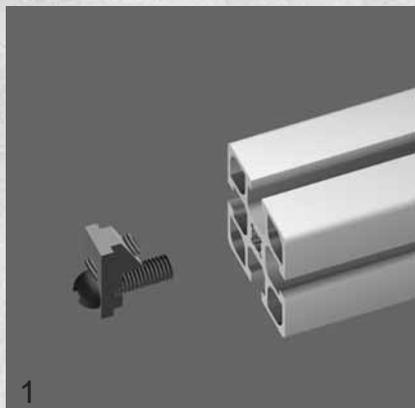


MINITEC - POWER-LOCK FASTENER

Applications Extremely strong power-lock connection. Accurate location of the profiles, integrated mounting aid, moveable, low-cost due to minimal processing. Can be used for all types of constructions.

Assembly For direct self-tapping of screw M8 into core bore or processing by using a thread former



Assembly

- 1 Screw the fastener by hand into the end of the profile 1.
- 2 Bring 2nd profile to the required position.
- 3 Tighten the set-screw M8 with hexagon key 4 A/F with T-handle. Recommended locking torque: ~12 Nm

Advantages

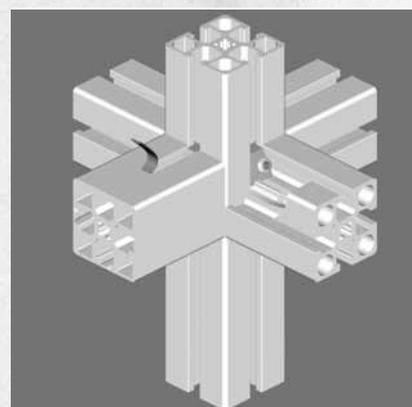
- The groove of the profile connection remains free for panels, etc.
- The connection is invisible from outside.
- Subsequently easily adjustable
- Power-locked in correct position
- Static load: 6000 N (UL profile: 4000 N)
- Easy construction of cross-joints
- Electrically conductive connection

Variants

Power lock fastener(standard): Part N° 21.1018/0 For profile connections that need to be electrically conducting. Profile needs to be tapped (thread M8).

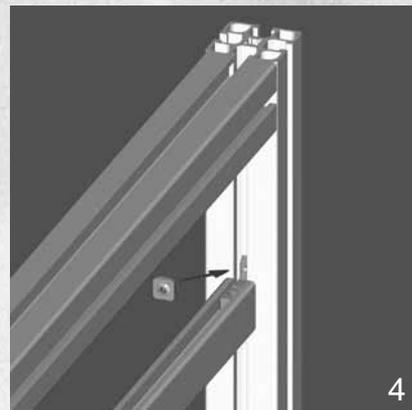
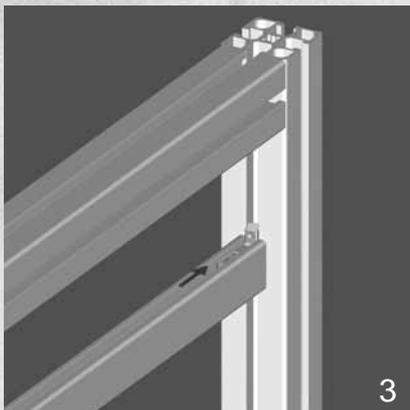
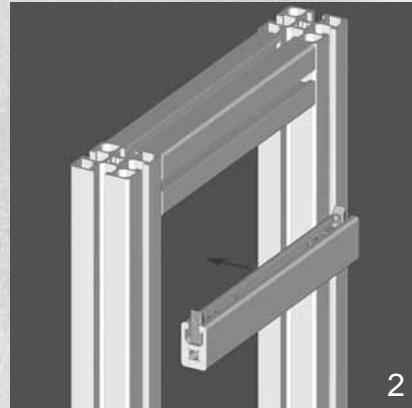
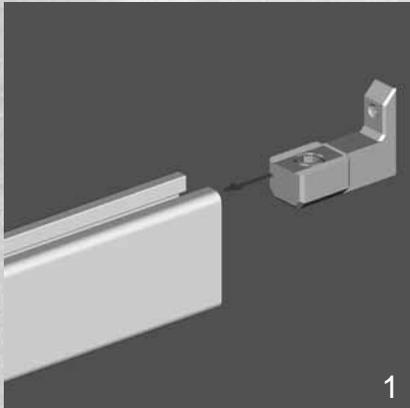
Power lock fastener SF: Part N° 21.0818/0 For profile connections that need to be electrically conducting. With self-cutting screw, so tapping is not necessary.

Power lock fastener H: Part N° 21.1018/1 For corrosion resistant profile connections. Profile needs to be tapped (thread M8).



MINITEC - POWER-LOCK FASTENER N

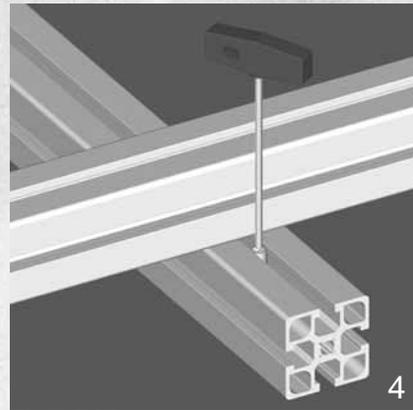
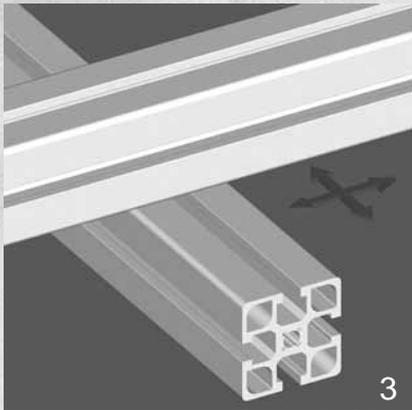
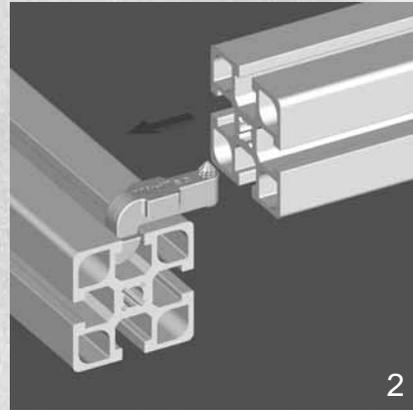
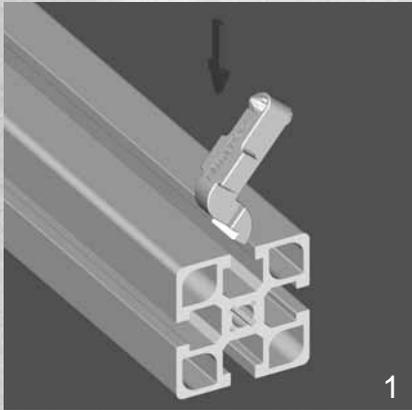
Applications For subsequent insert of profiles in existing frames



- Assembly**
1. Insert Power-lock fastener N into profile
 2. Set profile in the required position
 3. Insert fastener in the existing profile
 4. Slide nut over the L-shape end of the fastener and tighten with hex-key. Than tighten set screw (both 10 Nm).

MINITEC - CROSS-CONNECTOR

Applications For subsequent insertion of profiles in existing constructions



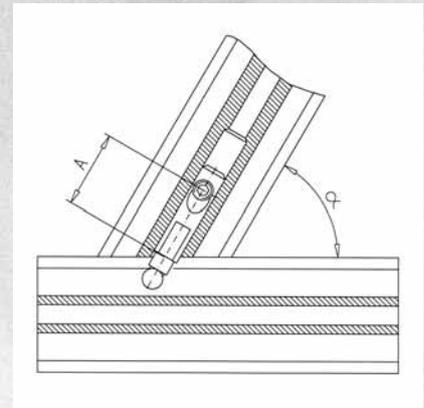
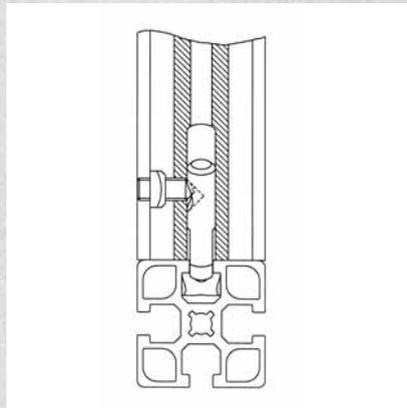
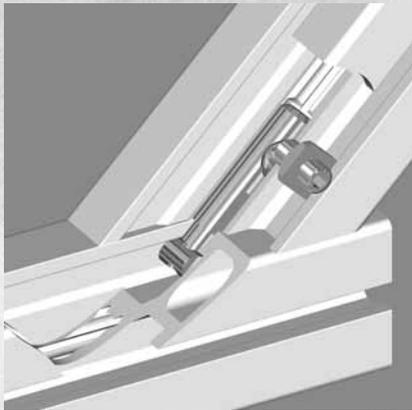
- Assembly**
1. Swivel the connector into any existing base frame
 2. Insert the profile to be connected over the connector
 3. Position the brace profile
 4. Tighten the set screw in the connector with a torque of 10 Nm

MITRE CONNECTIONS

Mitre connector N Drill \varnothing 10.2 mm bore in the profile core bore. Drill \varnothing 8.2 bore depending on the angle and at distance A from the profile end (see table). Insert the mitre connector in the open profile end, position the M8 square nut with the set screw and tighten it.

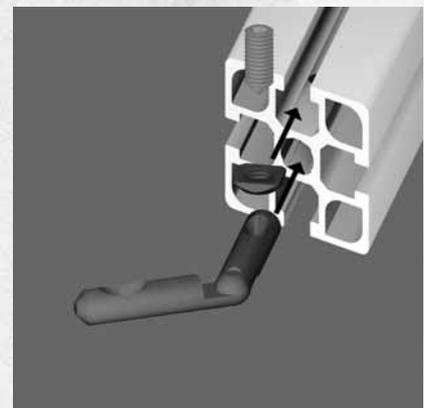
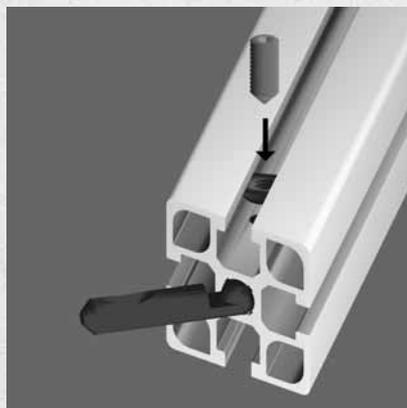
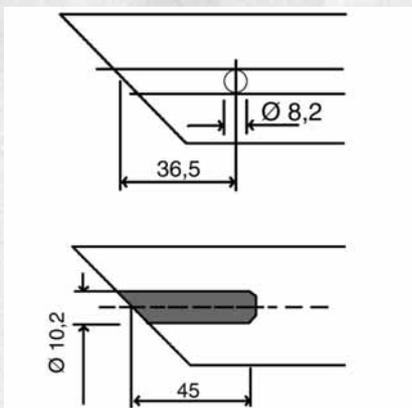
Use drilling jig for mitre connector N, Part N° 26.1060/0.

Angle α	25°	30°	35°	40°	45°	50°	55°	60°	65°	70°	75°	80°	85°
Distance A (mm)	21	24	26	28	29	30	30.5	31	31.5	32	32	32	32

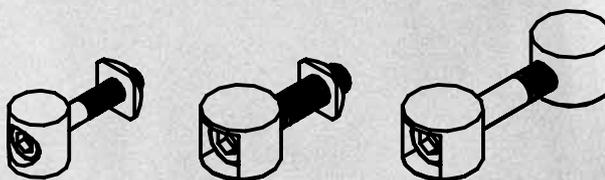


Mitre connector Drill \varnothing 10.2 mm bore in the profile core bore. Drill \varnothing 8.2 bore at the distance 36.5 mm from the profile end. Insert the mitre connector in both open profile ends, position the M8 square nut with the set screw, and tighten it.

Use drilling jig for mitre connector, Part N° 26.1050/0.



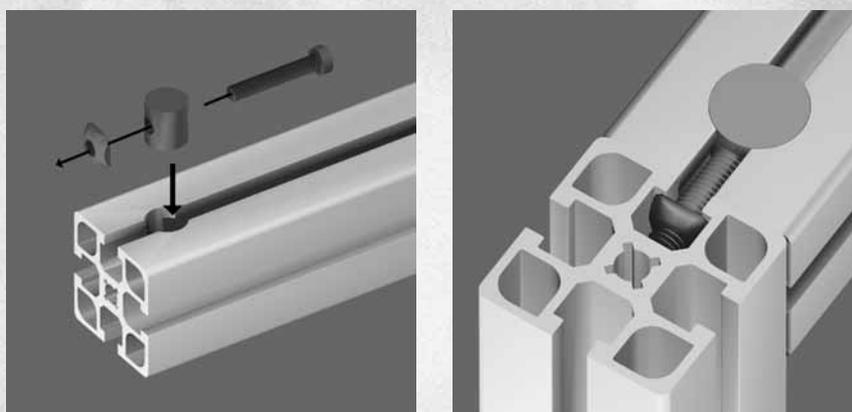
BOLT AND BUTT FASTENER



Application Subsequent assembly of profiles into existing frames, extension of profiles.

Processing Step drilling $\varnothing 7 / \varnothing 20$ mm, resp. $\varnothing 9 / \varnothing 15$ mm depth: 16 mm, position: middle of the groove, 20 mm from profile end.

- Subsequent mounting of profiles into existing frames.
- Adjustable
- Extension of profiles



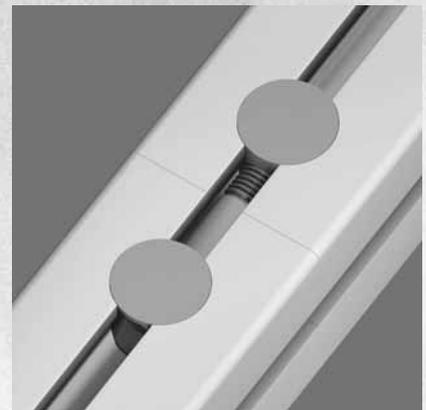
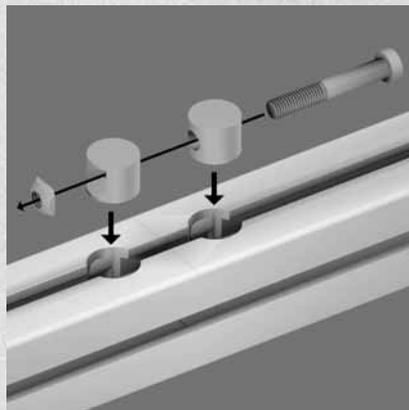
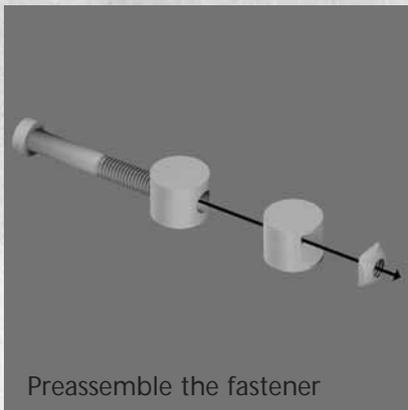
Assembly

- 1 Insert hex screw M8 x 35 in bolt and – if possible – preassemble square nut into second profile
- 2 Insert bolt in step drilling and connect with square nut.
- 3 Pretighten with ball-headed key 5 A/F.
Final tightening with L-key 5 A/F.

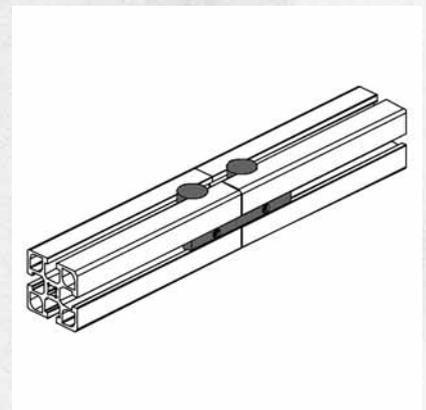
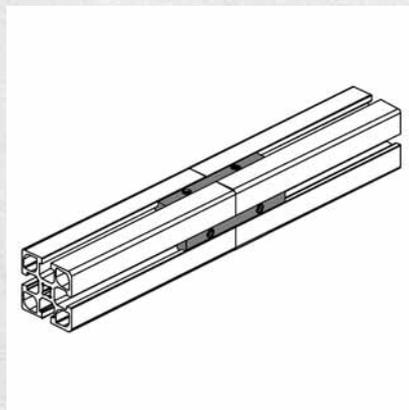
- Recommended locking torque: 15 Nm
- Static load: 3500 N

BUTT FASTENER

- Butt Fastener** Insert the fasteners into the bore holes $\varnothing 7 \times 20$ mm. Tighten the fasteners with L-key 5 A/F.
- Recommended locking torque: 15 Nm



- T-Slot Bars** Profile connection with steel t-slot bars. You can achieve optimum strength by combining the two extension methods.

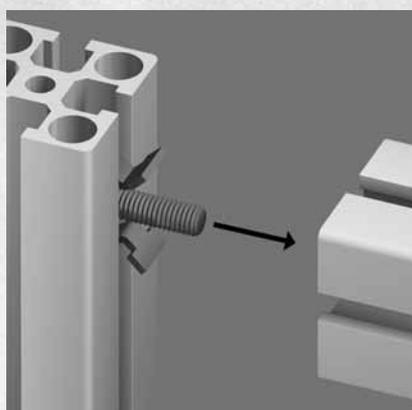
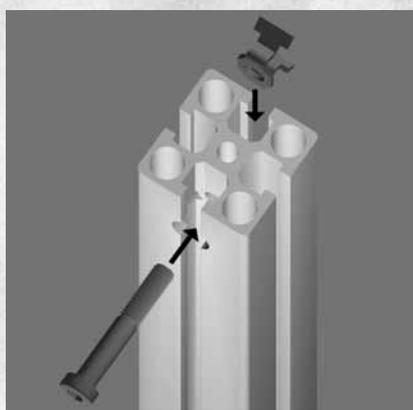


SCREW CONNECTION



Application Connections which must be secured against dislocation.

Processing Thread M8; step drilling $\varnothing 9 / \varnothing 15$ mm with drilling jig
Part no. 26.1092/0 for insert screw M8 x 50

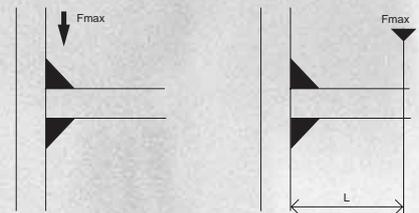


- Assembly**
- Form the tread M8 with thread former
 - Drill the through hole bore 9 x 15 at the position where the connection is required.
 - Insert the position fixing element and the screw.
 - Tighten the screw with hexagon key 5 A/F
- Definitely secured against dislocation
 - Static load: 18000 N
 - Recommended locking torque: 20 Nm

MOUNTING ANGLES



- No processing
- Suitable for subsequent mounting of profiles into existing frames
- Adjustable

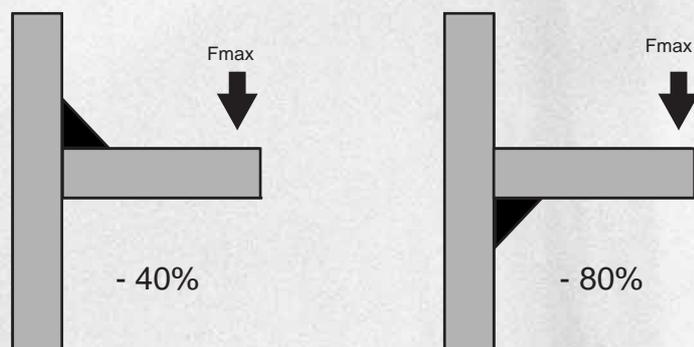


All values are including double safety.

Load Capacity:	Angle 19:	2 screws	3.600 N	280 Nm
	Angle 25:	2 screws	3.600 N	280 Nm
	Angle 45:	2 screws	3.600 N	280 Nm
	Angle 45 x 90:	4 screws	7.200 N	560 Nm
	Angle 90:	8 screws	14.400 N	1.120 Nm

These values are valid only for angles mounted in pairs (up and downside as shown in the pictures).

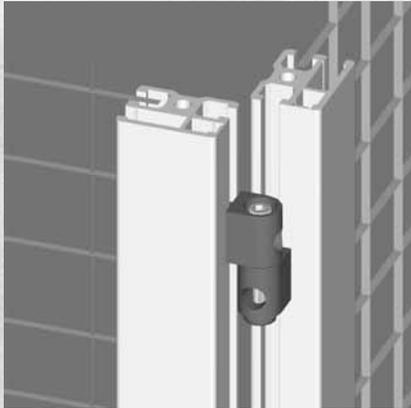
If used one-sided, the load reduces as follows:



Assembly

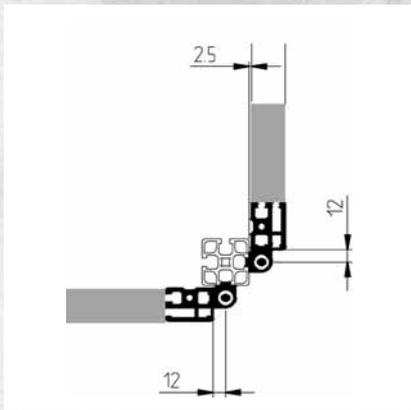
1. Preassemble the angle with necessary screws and nuts M8.
2. Fix the angle slightly at the vertical profile in the desired position.
3. Insert the horizontal profile and tighten all screws.
Recommended locking torque: 20 Nm

GUARD UNIT WITH ADJUSTABLE FIXING ANGLE

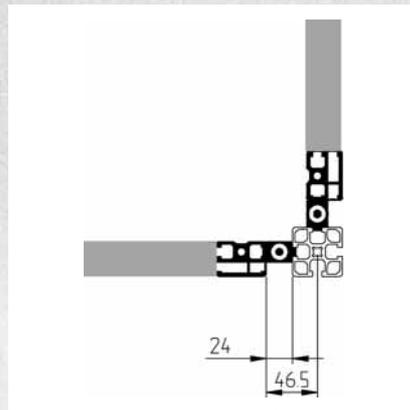


For fixing of MiniTec-aluminium profile guard units and erection of protective guard units at any angle.

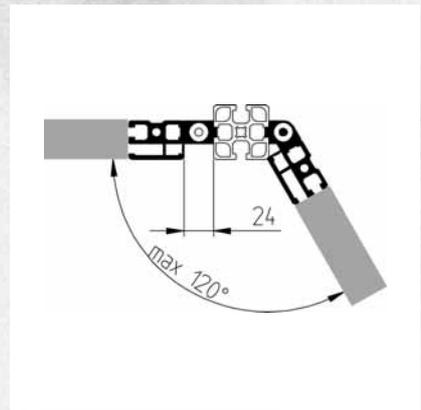
Assembly options:



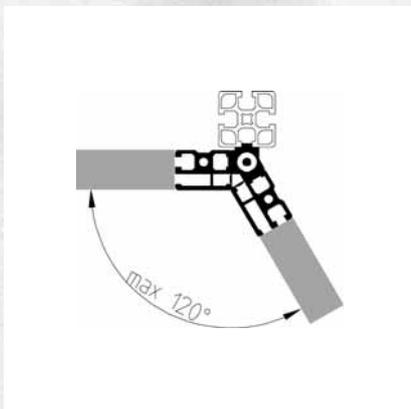
Without gap between guard unit and post



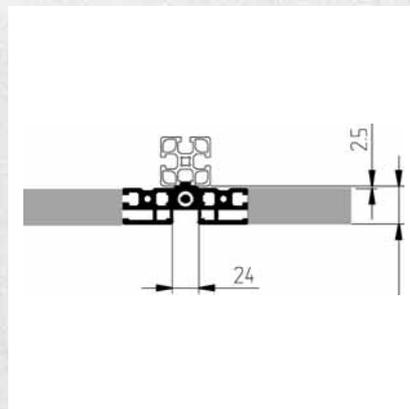
24 mm gap between guard unit and post



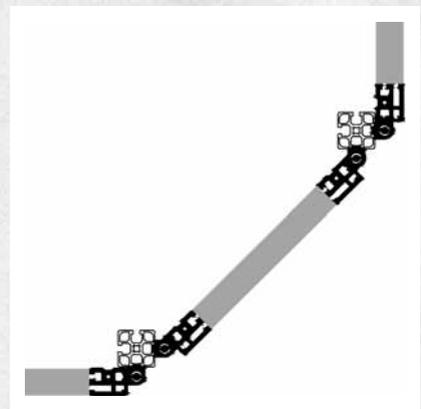
24 mm gap between guard unit and post



No gap between guard unit and post

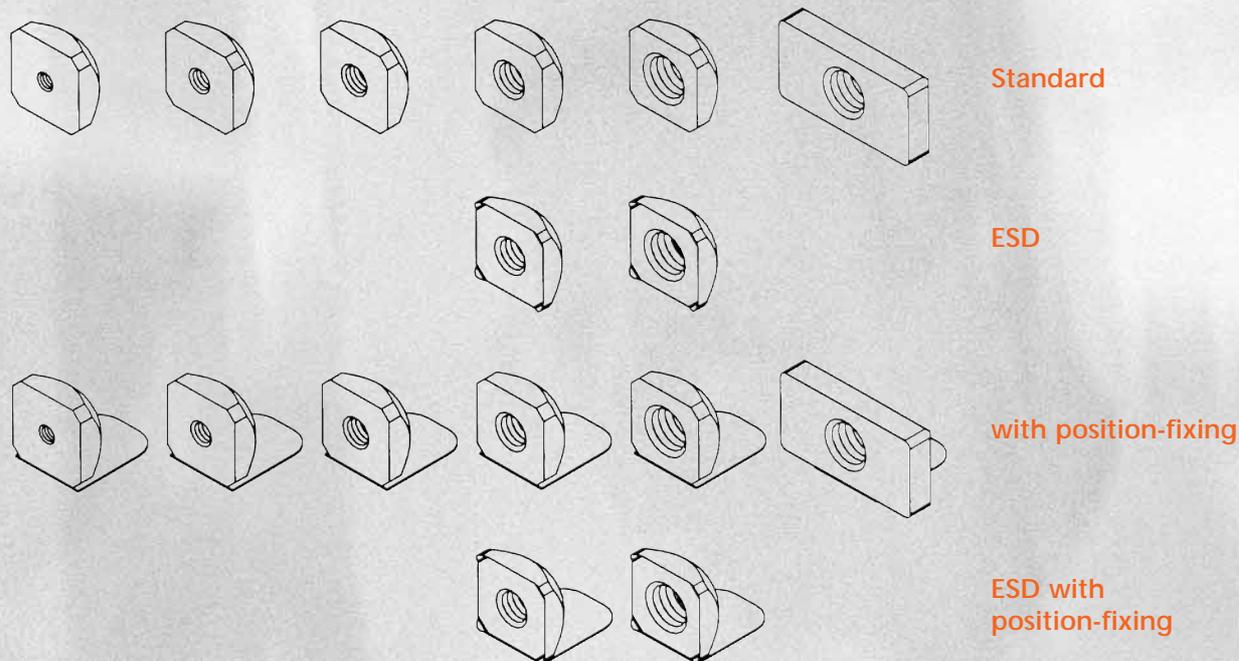


No gap between guard unit and post

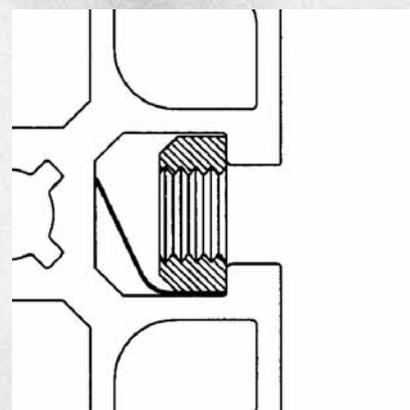
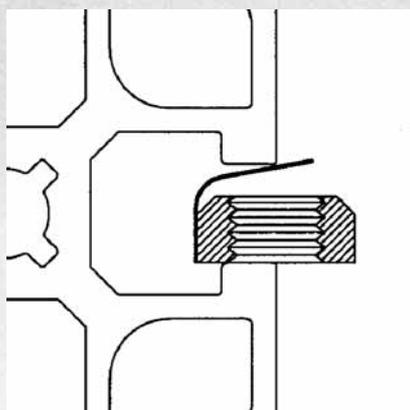
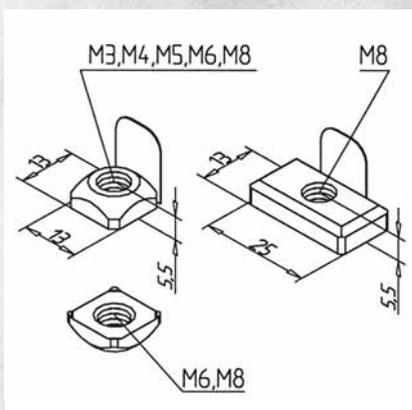


No gap between guard unit and post

SQUARE NUTS

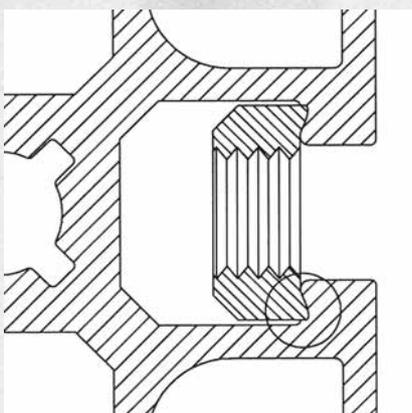


Application Economical and easy fixing of fasteners and elements available with threads M3, M4, M5, M6 and M8.



Assembly For applications in vertical profiles use special nuts with position-fixing. The spring metal keeps the nut in the desired position. Moveable by screw-driver.

- Insertable into the profile groove at any desired point.



With nuts M6 Z and M8 z the integrated noses intrude the anodizing and secure electrical conductivity.