

Easy and stable frame handling. The ultimate best choice for mixed productions in combination with aluminum spacer



Standard length  
5,000 & 6,000 mm ± 10 mm

## DIMENSIONS

Sizes	B [mm] +/-0.15	H [mm] +/-0.15
THERMIX TX Pro 8	7.6	6.85
THERMIX TX Pro 9	8.6	6.85
THERMIX TX Pro 10	9.6	6.85
THERMIX TX Pro 12	11.6	6.85
THERMIX TX Pro 13	12.6	6.85
THERMIX TX Pro 14	13.6	6.85
THERMIX TX Pro 15	14.6	6.85
THERMIX TX Pro 16	15.6	6.85
THERMIX TX Pro 18	17.6	6.85
THERMIX TX Pro 20	19.6	6.85
THERMIX TX Pro 22	21.6	6.85
THERMIX TX Pro 24	23.6	6.85

## ACCESSORIES

### Connectors



Plastic/Nylon



Steel

### Corner keys



Plastic/Nylon

Other accessories as flexible corners etc. are also available

## COLORS

### WHITE

≈ RAL 9016



### LIGHT GREY

≈ RAL 7035



### WINDOW GREY

≈ RAL 7040



### BLACK

≈ RAL 9005



### LIGHT BROWN

≈ RAL 8003



### DARK BROWN

≈ RAL 8016



## MATERIALS

### Stainless Steel

The wall thickness is standard 0.09 mm

### PP

Thickness of top 0.90 mm

## EN1279 Normative test references and other methods



### Pull force

Depends on chosen connector



### Rectitude from production

Sideways max. 5 mm/m  
Up/down max. 10 mm/m



### Two box model characteristic value

IFT WA-17/1  
 $\lambda_{eq,2B} = 0.31 \text{ W/mK}$



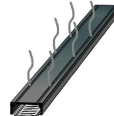
### Perforation holes size

Checked with airflow  
Allowed humidity uptake 1-5wt% pr. 24 hours



### Compression data (16 mm spacer)

Max. 60 N/cm static pressure



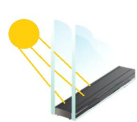
### Volatile elements / Fogging

EN 1279  
 $M_v < 0.05\%$  / No fogging 60°C and 80°C



### Thermal linear expansion

$T_{\alpha, \text{metal}}$  16 mm spacer =  $2.08 \times 10^{-5} \text{ 1/K}$   
 $T_{\alpha, \text{polymer}}$  16 mm spacer =  $4.44 \times 10^{-5} \text{ 1/K}$



### UV stability

EN ISO 4892-2/A  
3,000 hours of radiation with no significant color change

## QUALITY ASPECTS

### Quality management

EN ISO 9001 for Quality Management Systems.

### Tests of the product

Processes and routines are established to secure the quality of the delivered material. During production the spacers are continuously monitored through systematic and random checks. Data will be available for a period of 10 years.

### Full filing external demands according to:

- EN 1279
- Passive House Component Class phB for cold climate
- RAL gütezeichen
- DTA for use in France under Cekal

## CUSTOMER FOCUS AND WARRANTY

On all spacers we offer a 5 years' product warranty. The warranty covers free exchange of spacers in case of a defect. The warranty does not cover any other cost than the mere exchange of the defect spacers, and the warranty expressly does not cover installation of the spacers. The spacers must have been stored, installed and used according to present norms and technical standards. Special solutions and **usage that are not standardized** will need prior approval in writing from us in order to be covered. Related to temperature standardized condition for IG is -30°C/+70°C. Additional 10°C is allowed for Thermix TX Pro.

### Storage and use

To secure the performance of the spacers, the stock conditions must be acceptable. Broken packaging, humidity and variation in temperature will have an effect on the spacer in general. Make sure the spacer is conditioned at room temperature before use.

Preferred conditions will be temperatures over 15°C and humidity RH of minimum 45%. Avoid having an environment with high concentration of dust.

General handling and attention according to safety data sheet for the spacer. Use gloves when handling the spacer/frames and make sure there is exhausting when cutting the spacer.

### System performance

The user (the IG producer) must secure the whole system consisting of spacer, connector/corner key, bending machine, desiccant, butyl and sealant works well together in the chosen setup. Focus on compatibility, adhesion, dust and corner quality.

After handling and transport of the frames, it's important to check if the connector/corner keys are still in the correct position, if not there is a significant risk for desiccant dust inside the IG unit. Foam behind the connector/corner can be used to avoid such problems.

### Cleaning the plastic surface

If for some reason, the plastic surface is defiled by dust from other materials it can be cleaned again by use of water or air. Dust can easily be removed with antistatic loaded compressed air or a moist cloth. If solvent based cleaners are used, it is recommended to test influence on products.

*It is recommended to investigate and control all the specific points above.*

## ADDITIONAL SPECIFICATIONS AND INSTRUCTIONS

### Packaging, volumes and options

Packaging Sizes	Cardboard box		Stillages		Partitions stillage					
	5m	6m	5m	6m	1/3	2/3	1/2	1/3	2/3	1/2
						5 m			6 m	
8	990	1.188	24.200	29.040	7.920	16.500	12.540	9.504	19.800	15.048
9	990	1.188	22.880	27.456	7.260	14.850	11.550	8.712	17.820	13.860
10	880	1.056	22.000	26.400	6.270	13.200	9.900	7.524	15.840	11.880
12	660	792	18.480	22.176	5.390	11.000	8.250	6.468	13.200	9.900
13	660	792	15.400	18.480	4.510	9.625	7.425	5.412	11.550	8.910
14	550	660	15.400	18.480	4.510	9.625	7.425	5.412	11.550	8.910
15	550	660	13.200	15.840	4.180	8.800	6.600	5.016	10.560	7.920
16	550	660	13.200	15.840	4.070	8.525	6.435	4.884	10.230	7.722
18	440	528	12.320	14.784	3.630	7.425	5.445	4.356	8.910	6.534
20	440	528	11.440	13.728	2.970	6.600	4.950	3.564	7.920	5.940
22	330	396	10.560	12.672	2.970	6.600	4.620	3.564	7.920	5.544
24	330	396	9.680	11.616	2.970	6.050	4.290	3.564	7.920	5.148

Packaging Sizes	Quantity pcs. / box		
	Steel (DP*)	Plastic/Nylon (DP*)	Plastic/Nylon corner keys
8	2,500		2,000
9	2,500		
10	2,500		2,000
12	2,500	5,000	2,000
13	2,500	5,000	5,000
14	2,500	5,000	2,000
15	2,500	5,000	2,000
16	2,500	5,000	2,000
18	2,500	5,000	2,000
20	2,500	5,000	2,000
22	2,500	5,000	2,000
24	2,500	5,000	2,000

\*DP = Direct passage

All connectors are basically U-shaped and with passage for flow of desiccant during after filling.

The P-connector has a closed backside part (bridge) to prevent dust leak.

Note that there will be a difference in pull force between preinserted- and direct inserted connectors.

## Energy labeling

For thermal calculations, these values are given (according to EN 10077 and EN 10088). Ask for drawing.

Materials	$\lambda$ [W/mK]
Butyl	0.24
Desiccant	0.10
Secondary sealing	0.40
Stainless steel (At 20°C)	15
PP	0.22

## Thermal data

An overview of thermal data with different constructions. These data are calculated by Bauwerk according to IFT guideline WA-08/3.

### Frame: Aluminum profile – $U_f = 1.6 \text{ W/m}^2\text{K}$

Glass	Double IG - $U_g = 1.1 \text{ W/m}^2\text{K}$ (4-16-4)			Tripple IG - $U_g = 0.7 \text{ W/m}^2\text{K}$ (4-12-4-12-4)		
Parameters	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]
CHROMATECH	0.068	8.4 / 10.3	1.439	0.066	10.6 / 12.2	1.174
CHROMATECH plus	0.064	8.7 / 10.3	1.429	0.060	10.9 / 12.4	1.159
MULTITECH A	0.059	9.2 / 11.0	1.417	0.055	11.4 / 12.8	1.147
CHROMATECH ultra S	0.050	9.8 / 11.5	1.395	0.046	12.0 / 13.3	1.126
<b>THERMIX TX Pro</b>	<b>0.049</b>	<b>9.8 / 11.5</b>	<b>1.393</b>	<b>0.044</b>	<b>12.0 / 13.3</b>	<b>1.121</b>
CHROMATECH ultra F	0.048	9.9 / 11.6	1.390	0.043	12.1 / 13.4	1.118
MULTITECH G	0.035	10.9 / 12.4	1.359	0.030	13.0 / 14.2	1.087

### Frame: PVC profile – $U_f = 1.2 \text{ W/m}^2\text{K}$

Glass	Double IG - $U_g = 1.1 \text{ W/m}^2\text{K}$ (4-16-4)			Tripple IG - $U_g = 0.7 \text{ W/m}^2\text{K}$ (4-12-4-12-4)		
Parameters	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]
CHROMATECH	0.051	8.3 / 10.3	1.257	0.050	9.9 / 11.6	0.982
CHROMATECH plus	0.049	8.5 / 10.3	1.253	0.048	10.1 / 11.8	0.977
MULTITECH A	0.045	9.0 / 10.8	1.243	0.043	10.6 / 12.2	0.965
CHROMATECH ultra S	0.040	9.5 / 11.3	1.230	0.038	11.1 / 12.6	0.953
<b>THERMIX TX Pro</b>	<b>0.040</b>	<b>9.5 / 11.3</b>	<b>1.230</b>	<b>0.038</b>	<b>11.1 / 12.6</b>	<b>0.953</b>
CHROMATECH ultra F	0.039	9.6 / 11.3	1.228	0.037	11.2 / 12.7	0.950
MULTITECH G	0.031	10.5 / 12.1	1.218	0.029	12.1 / 13.4	0.931

### Frame: Wood profile – $U_f = 1.4 \text{ W/m}^2\text{K}$

Glass	Double IG - $U_g = 1.1 \text{ W/m}^2\text{K}$ (4-16-4)			Tripple IG - $U_g = 0.7 \text{ W/m}^2\text{K}$ (4-12-4-12-4)		
Parameters	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]
CHROMATECH	0.053	7.3 / 9.4	1.322	0.054	9.6 / 11.3	1.045
CHROMATECH plus	0.051	7.6 / 9.7	1.317	0.051	9.9 / 11.6	1.038
MULTITECH A	0.047	8.0 / 10.0	1.307	0.047	10.4 / 12.0	1.028
CHROMATECH ultra S	0.041	8.6 / 10.5	1.293	0.040	11.0 / 12.5	1.010
<b>THERMIX TX Pro</b>	<b>0.040</b>	<b>8.7 / 10.6</b>	<b>1.290</b>	<b>0.039</b>	<b>11.0 / 12.5</b>	<b>1.008</b>
CHROMATECH ultra F	0.039	8.8 / 10.7	1.288	0.038	11.2 / 12.7	1.005
MULTITECH G	0.030	9.8 / 11.5	1.265	0.028	12.2 / 13.5	0.980

### Frame: Wood aluminum profile – $U_f = 1.4 \text{ W/m}^2\text{K}$

Glass	Double IG - $U_g = 1.1 \text{ W/m}^2\text{K}$ (4-16-4)			Tripple IG - $U_g = 0.7 \text{ W/m}^2\text{K}$ (4-12-4-12-4)		
Parameters	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]	$\psi_g$ [W/mK]	$\Theta_{si(-10/-5^\circ\text{C})}$	$U_w$ [W/m <sup>2</sup> K]
CHROMATECH	0.059	6.1 / 8.4	1.342	0.060	8.7 / 10.6	1.075
CHROMATECH plus	0.056	6.4 / 8.7	1.335	0.056	9.0 / 10.8	1.065
MULTITECH A	0.051	6.9 / 9.1	1.323	0.051	9.5 / 11.3	1.053
CHROMATECH ultra S	0.045	7.6 / 9.7	1.308	0.043	10.2 / 11.8	1.033
<b>THERMIX TX Pro</b>	<b>0.043</b>	<b>7.6 / 9.7</b>	<b>1.303</b>	<b>0.042</b>	<b>10.3 / 11.9</b>	<b>1.031</b>
CHROMATECH ultra F	0.043	7.8 / 9.8	1.303	0.041	10.4 / 12.0	1.028
MULTITECH G	0.031	8.9 / 10.8	1.274	0.029	11.5 / 12.9	0.999

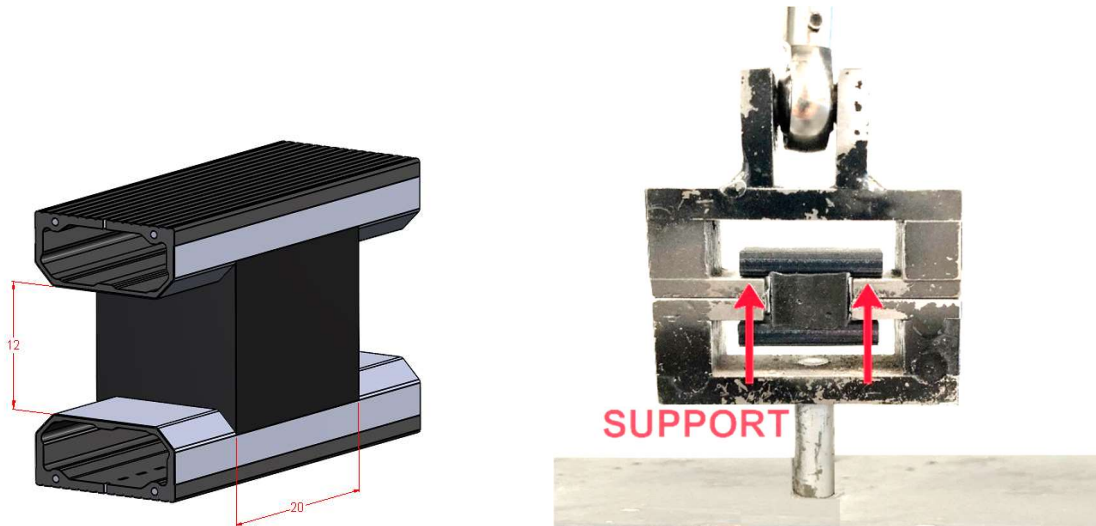
Θ Internal glass temperature

To calculate with other U-values for glass please refer to our homepage where a calculator can be found (<https://www.winuw.de/rolltech/>). Is also available as an app "WinUw ROLLTECH". Access it by Apple store or on Google play.

## Adhesion check

According to EN1279-6 D.2 the following test must be done in order to check mixing and secure the adhesion between spacer and sealant. A pull of 0.3 MPa shall be applied for 10 minutes. No adhesive breakage is allowed (slip to surface).

The following is a guide to achieve the correct results for our spacers. The sealant shall cover 20 mm of the spacer back as shown on the drawing. No precleaning of spacer is allowed. It is important to secure a proper contact between sealant and spacer back. The support from the test machine shall be as close as possible to the sealant and direct to the spacer back as illustrated.



Ask actual sealant supplier for the conditions required during curing. Here some general guidelines:

- For PS curing at 20°C over a period of 24 to 48 hours is normally enough.
  - For PU curing at 20°C can take much longer depending on the PU version. 28 days or more is quite normal.
- Ask sealant supplier for guidelines, it might be possible to accelerate the curing at a higher temperature.

Check the samples for type of breakage. Adhesive breakage is not allowed, and if seen analyzing is needed. Sources to failure: Wrong mix of sealant (A+B), insufficient application, contamination, or deformation of spacers.

## Bending

- Use bending tools recommended by bending machine supplier
- Adjust side pressure until correct corner width is obtained (max +0.3 mm)
- Over bending due to resilience is to be adjusted for perfect 90° corners
- Cut with stainless steel saw blade or abrasive wheel
- Room temperature during processing > 15°C

For further bending instructions, contact your bending machine supplier.

## Saw blades and saws

Use tools suitable for cutting and drilling stainless steel. A saw blade for aluminum and steel can't be used for stainless steel. Contact supplier of machines/saws first to be advised for the best possible fit to the spacer bar or alternatively ask your spacer supplier for support in case of not finding suitable solutions. Make sure all particles and dust are removed.

## IMPORTANT:

It is essential that the spacer is fixed during sawing and without vibrations – if not – the lifetime of the blade/wheel will be shortened dramatically.