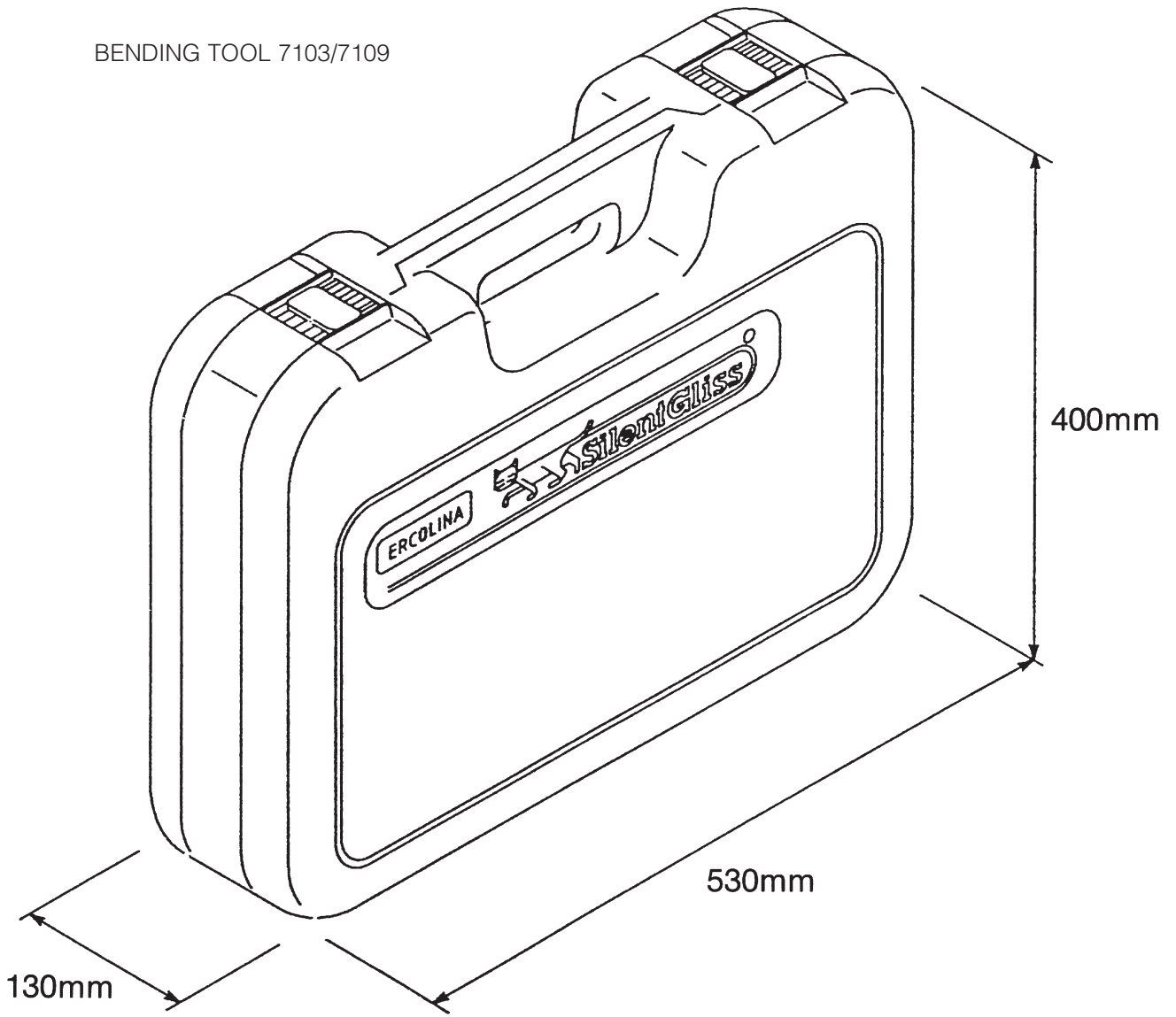


# **Silent Gliss 7103/7109**

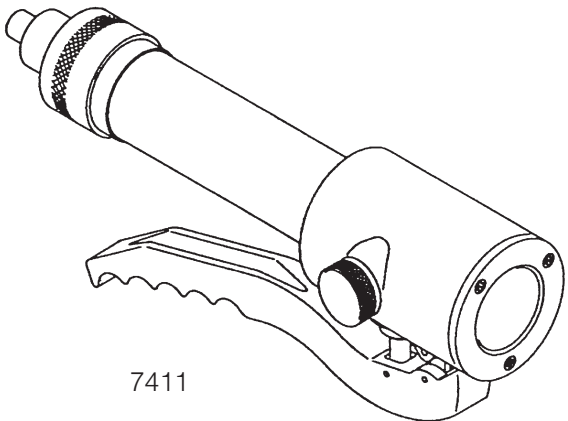
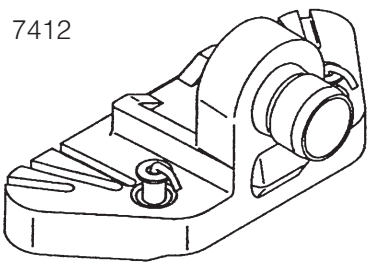
## **Operating Instructions**

**June 2018**

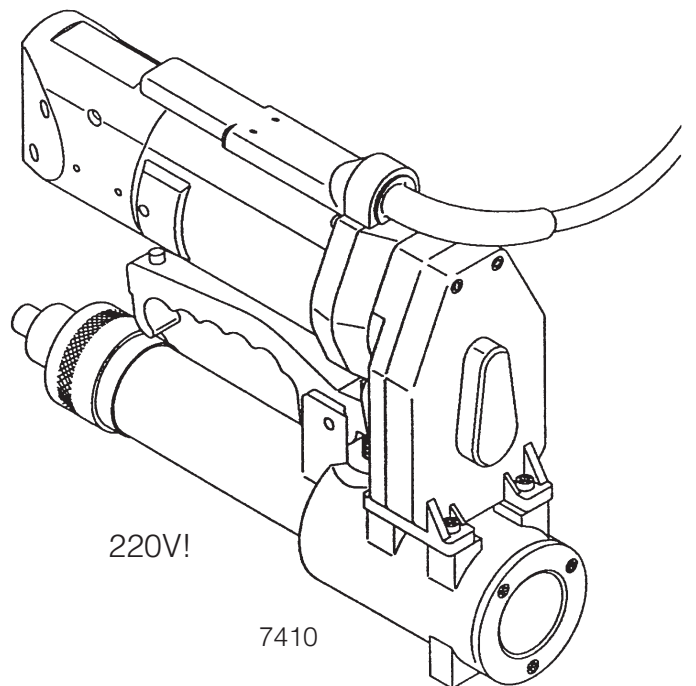
BENDING TOOL 7103/7109



7412

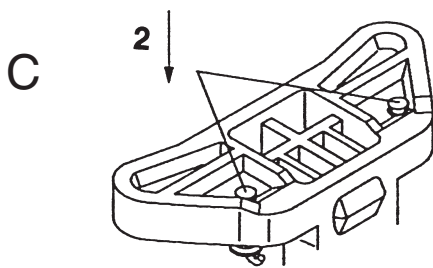
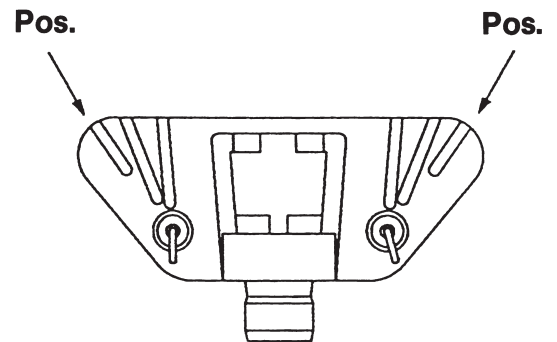
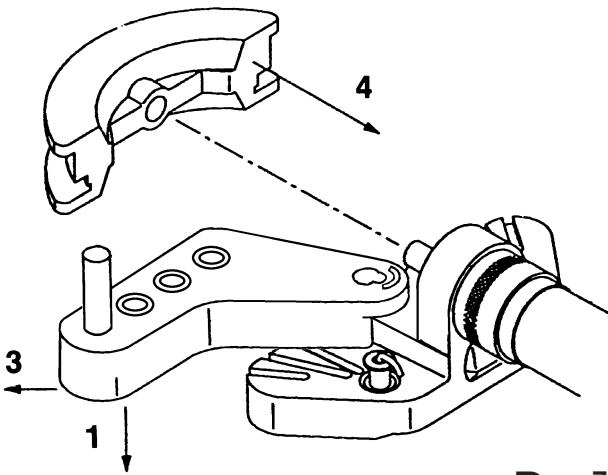
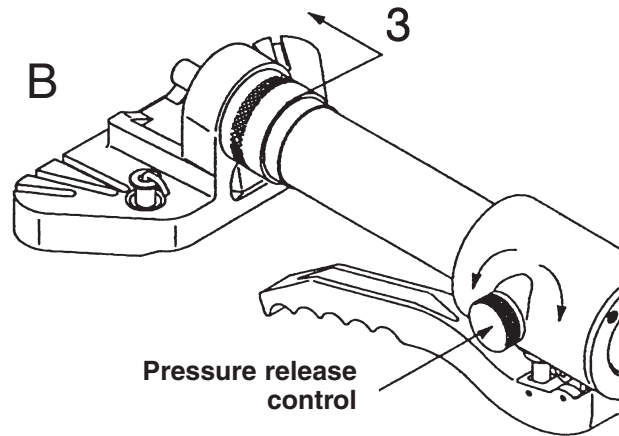
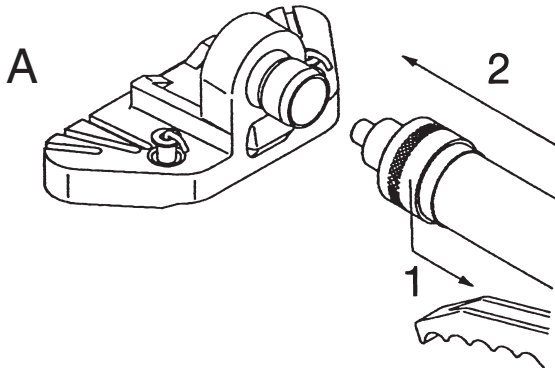
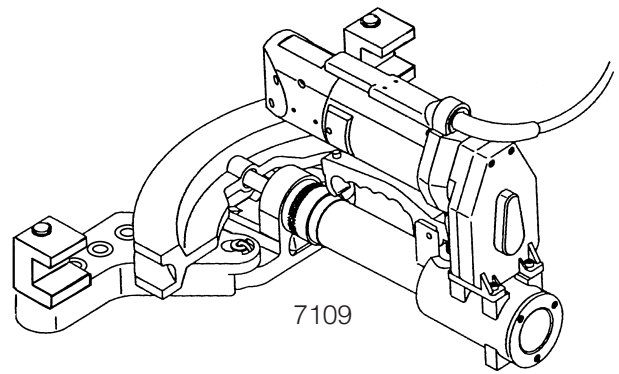
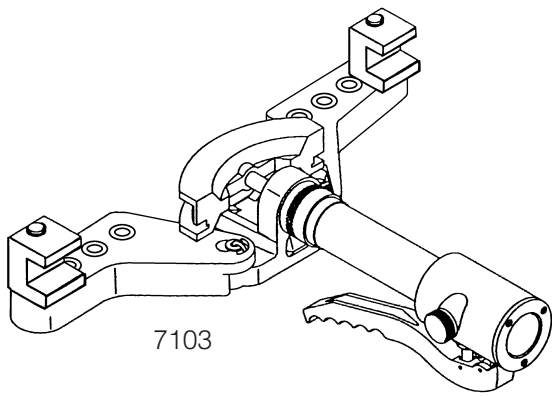


7411

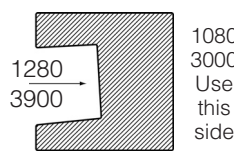


220V!

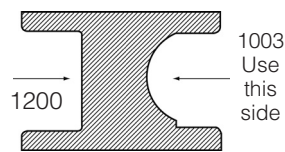
7410



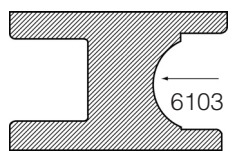
**D 7441 Blocks**  
(note correct way up)



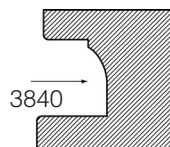
**7438 Blocks**  
(note correct way up)



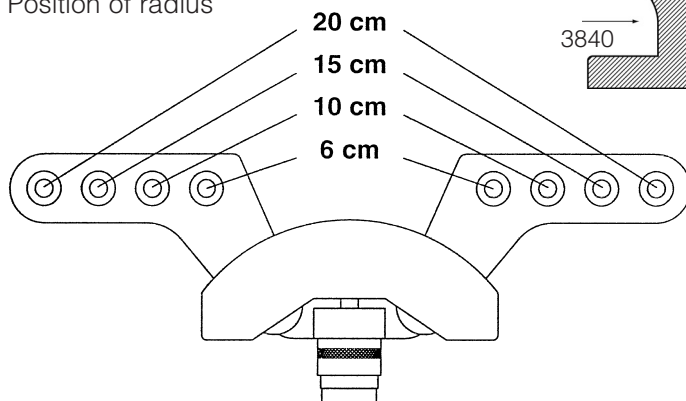
**7437 Blocks**  
(note correct way up)



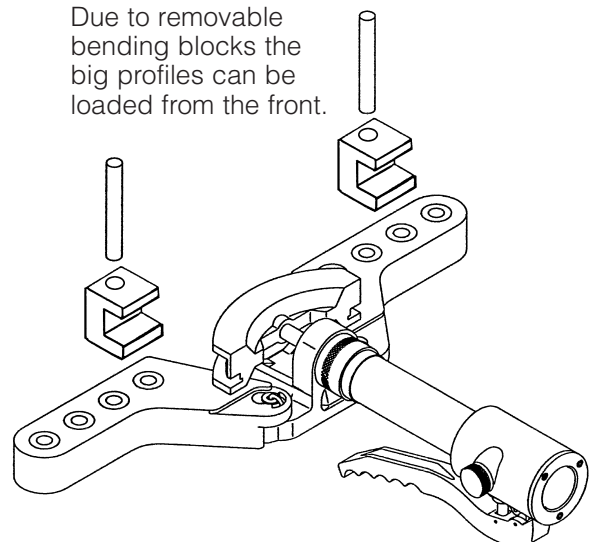
**7434 + 7435 Blocks**  
(note correct way up)



Position of radius



Due to removable bending blocks the big profiles can be loaded from the front.

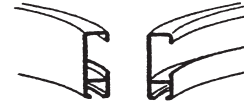


The above shows the pin positions for various radii that can be achieved using the 7101/7109 tool.

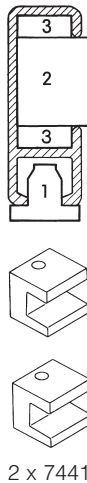
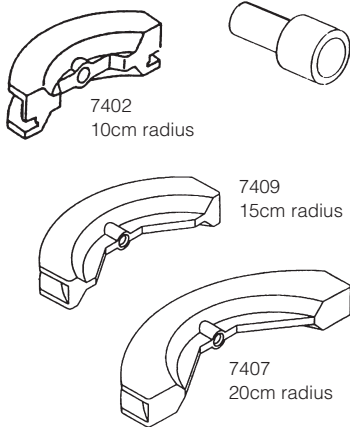
# Silent Gliss 1080/2116

10cm radius  
15cm radius  
20cm radius

Forward and Reverse Bends



See notes on Page 7



Filler Set Number	Number	Measurement	Part Number
7806			
	1	7.8 x 6.5 x 500	7903
	2	8 x 10 x 500	7920
	3	2 x 2.5 x 6 x 500	7901

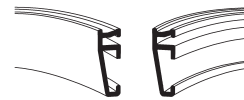
### 1080 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
10cm	17mm	14mm	7mm	3mm	0
15cm	33mm	22mm	12mm	7mm	0
20cm	46mm	30mm	18mm	12mm	0

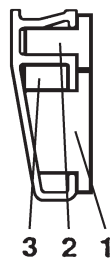
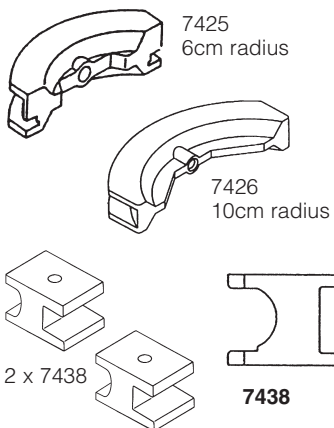
# Silent Gliss 1200

6cm radius  
10cm radius

Forward and Reverse Bends



See notes on Page 7



Filler Set Number	Number	Measurement	Part Number
7845			
	1	15 x 8.5 x 700	7795
	2	6.6 x 8.5 x 700	7796
	3	5.5 x 3 x 700	7797

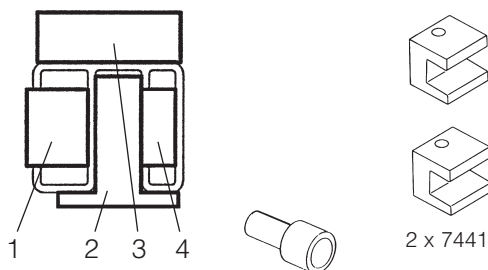
### 1200 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
6cm	15mm	10mm	4mm	4mm	0
10cm	20mm	13mm	10mm	5mm	0

# Silent Gliss 1280

15cm radius  
20cm radius

Forward and Reverse Bends



Filler Set Number	Pos	Measurement	Part Number
7844			
	1	8 x 10 x 700	7920
	2	16 x 17 x 700	7799
	3	20 x 6.5 x 700	7918
	4	4.5 x 10 x 700	7798

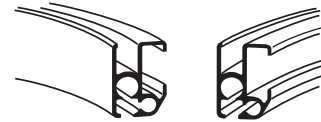
### 1280 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
15cm	23mm	10mm	8mm	0	0
20cm	32mm	20mm	12mm	5mm	0

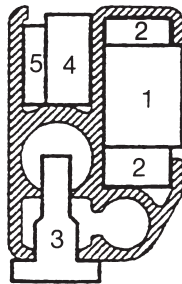
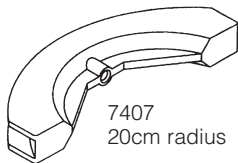
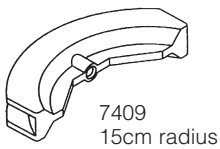
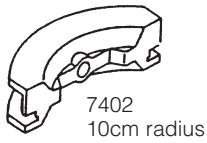
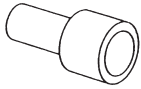
# Silent Gliss 3000

10cm radius  
15cm radius  
20cm radius

Forward and Reverse Bends



See notes on Page 7



2 x 7441

Filler Set Number	Number	Measurement	Part Number
7805	1	8 x 10 x 700	7904
	2	2.5 x 6 x 700	7910
	3	7.8 x 11 x 700	7146
	4	4 x 8 x 700	7875
	5	2.5 x 7.2 x 700	7909
	6	1 x 24 x 700	7035

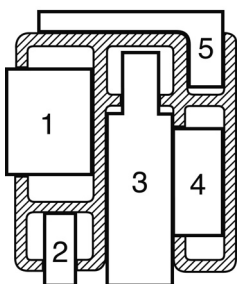
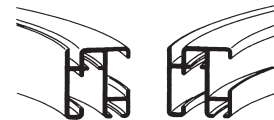
### 3000 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
10cm	14mm	9mm	4mm	4mm	0
15cm	25mm	14mm	9mm	2mm	0
20cm	43mm	22mm	12mm	5mm	0

# Silent Gliss 3900

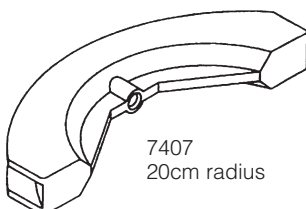
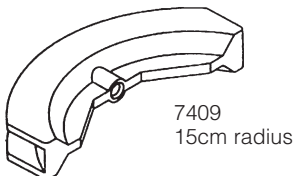
15cm radius  
20cm radius

Forward and Reverse Bends



#### Remarks

1. Make sure that filler No. 5 is fitted under both the former and blocks.



2 x 7441

Filler Set Number	Pos	Measurement	Part Number
7803	1	10 x 8 x 700	7920
	2	6.3 x 3 x 700	7917
	3	21.8 x 6.3 x 700	7792
	4	4.5 x 10 x 700	7798
	5	17 x 7 x 700	7932

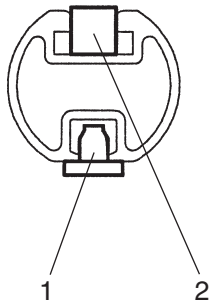
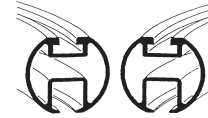
### 3900 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
15cm	26mm	15mm	8mm	2mm	0
20cm	35mm	22mm	12mm	10mm	0

# Silent Gliss 1003

15cm radius

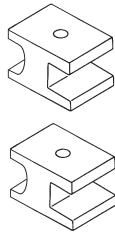
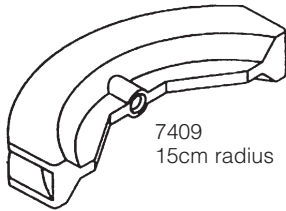
Forward and Reverse Bends



Filler Set Number	Pos	Measurement	Part Number
7848	1	7.8 x 6.5 x 700	7903
	2	6 x 6.2 x 700	7923

### 1003 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
15cm	24mm	14mm	6mm	3mm	0

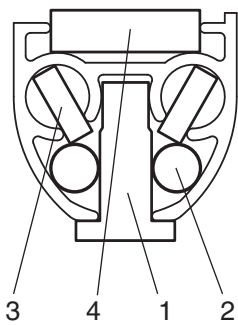


2 x 7438

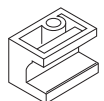
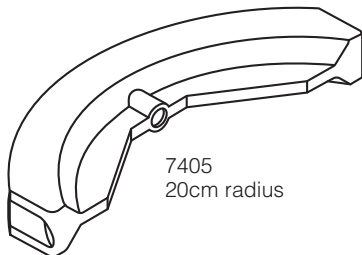
# Silent Gliss 3840

20cm radius

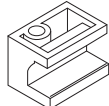
Forward and Reverse Bends



Filler Set Number	Number	Measurement	Part Number
7802			
	4		
	1	6.4 x 16 x 700	7906
	2	∅ 5 x 700	7927
	3	2.6 x 7.6 x 700	7907
	4	4.2 x 15 x 700	7908



1 x 7434



1 x 7435

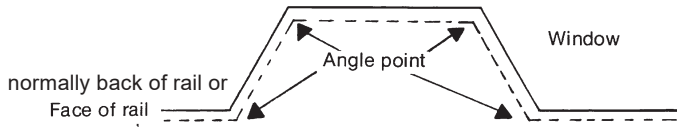
### 3840 Back Mark Allowances

Degrees	90°	100°	110°	120°	135°
Radius					
20cm	36mm	23mm	11mm	0	0

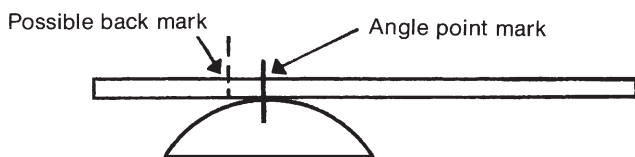
# Off Site Bending Instruction

# Bracket Allowance Chart

- 1) Draw out the window shape full scale on a bench or floor.
- 2) Draw the rail positions allowing for whatever size brackets are being used. (See BRACKET ALLOWANCE CHART).



- 3) It is advisable to cut the profile slightly longer than the track length to trim once bending complete
- 4) Place fillers in the rail as per the 7103 instruction book.  
(NB) A FULL RANGE OF FILLERS 200cm LONG IS AVAILABLE AT AN EXTRA COST.
- 5) Line the track up with one end of the rail line and mark the angle point onto the track. Put the rail into the bending tool with the mark in the centre of the former. (Remember at this point whether you are forward or reverse bending.)



Back marks are required as shown on the back marks allowance chart. These allow for the spring back in the rail.

- 6) Now squeeze the trigger until the rail begins to bend.
- 7) Bend the rail over the drawing, slightly over bending to allow for the natural spring-back in the rail. When everything is in line release the former allowing the track to spring back and line up the rail onto the drawing. Bend more if needed.,
- 8) Remove the bent rail from the tool and line up on the drawing ready to mark the next angle point onto, the rail and repeat the process. Remember to use the back marks if required.

### NOTE:

1. The forward bending on System 3000 & 3900 should be 20cm radius only to prevent the overlap arm from travelling under the profile on the bend:  
Therefore use the 10cm and 15cm rad. only for reverse bending of 3000/3900.
2. When bending between 90° and 120° you will need to make an allowance to reduce the 'gain' on the rail.  
Above 120° no allowance is needed.

Track	Bracket	To Back mm	To Front mm
1080	11200 / 11210	66	74
1080	11201 / 11211	86	94
1080	11202 / 11212	106	114
1080	11203 / 11213	126	134
1080	11204 / 11214	156	164
1080	11205 / 11215	206	214
1080	3630	29	37
1080	3655	44	52
1080	3660	59	67
1200	11200 / 11210 + 3176	64	73
1200	11201 / 11211 + 3176	84	93
1200	11202 / 11212 + 3176	104	113
1200	11203 / 11213 + 3176	124	133
1200	11204 / 11214 + 3176	154	163
1200	11205 / 11215 + 3176	204	213
1200	3175	27	36
1280	11200 / 11210	70	91
1280	11201 / 11211	90	111
1280	11202 / 11212	110	131
1280	11203 / 11213	130	151
1280	11204 / 11214	160	181
1280	11205 / 11215	210	231
1280	3630	32	53
1280	3655	47	68
1280	3660	62	83
3000	11200 / 11210	68	85
3000	11201 / 11211	88	105
3000	11202 / 11212	108	125
3000	11203 / 11213	128	145
3000	11204 / 11214	158	175
3000	11205 / 11215	208	225
3000	3630	30	47
3000	3655	46	63
3000	3660	61	78
3900	11200 / 11210	66	88
3900	11201 / 11211	86	108
3900	11202 / 11212	106	128
3900	11203 / 11213	126	148
3900	11204 / 11214	156	178
3900	11205 / 11215	206	228
3900	3630	27	49
3900	3655	42	64
3900	3660	57	79
3840	11200 / 11210	41	63
3840	11201 / 11211	61	83
3840	11202 / 11212	81	103
3840	11203 / 11213	101	123
3840	11204 / 11214	131	153
3840	11205 / 11215	181	203

# Spacers

## SPECIAL NOTES FOR BENDING PROFILES 3000 & 1080 AT 90 DEGREES 20CM RADIUS

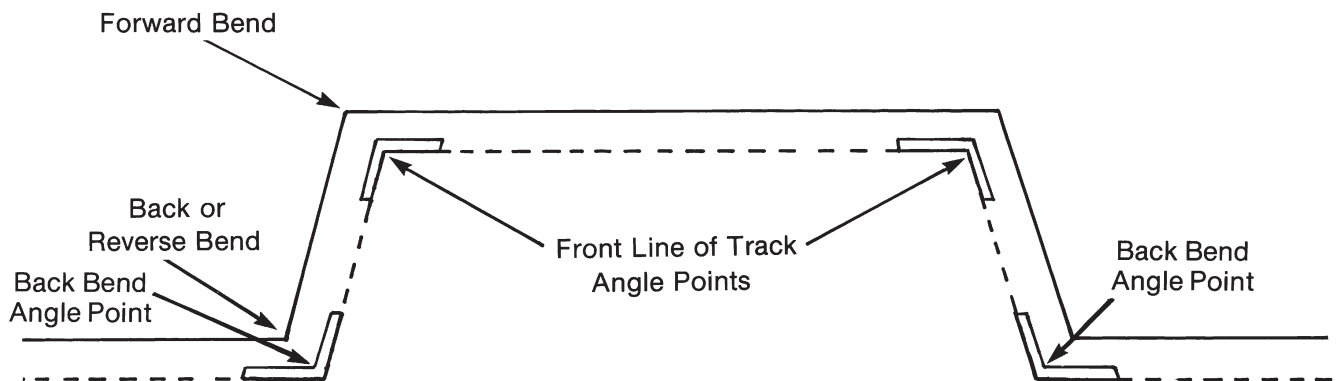
### 3000 20cm Radius 90 Degrees (1 Spacer Required)

A. Place small spacer onto end of 'Pump Ram' on machine, inserting also into hole in 7407 beinding ring, pump machine until 90° angle is achieved.3000 20cm Radius 90 Degrees (1 Spacer Required)

### 1080 20cm Radius 90 Degrees (1 Spacer Required)

B. Place one spacer onto end of 'Pump Ram' on machine, inserting also into hole on 7407 beinding ring. Bend the profile using one spacer, continue to bend until 90° is achieved.

## Typical Bay Window



1. For the Back bends use a scrap piece of profile to find the 'Back' of the angle point, and mark this on the 'Back' of the profile to be bent. Now allow for any Back Mark using chart provided.
2. For the Forward bends mark the 'Front' of the profile to be bent with the angle point then allow for any Back Mark using chart provided.

## SAFETY ADVICE

- Pump to be connected only on 220V alternating current (AC).
- On assembling:
  - to check whether bending arm and pump have snapped in correctly.
  - to check correct position of holder and former.
- On bending:
  - mains cable must be out of bending area.
  - to use only accessories proven by Silent Gliss.
  - on the left and right side of the tool must be enough room for the profile.
- In case that the tool is wrongly operated or used for other purposes no responsibility can be accepted.

### Silent Gliss Limited

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