TECHNOFORM

Unless otherwise noted, use pocket Ⓐ

+Denotes PA 66 GF40
*Denotes article added in 2025

12 mm

259700

958241

13 mm
13.5 mm

969505*

14 mm
14.22 mm Ⓚ

514300

14.6 mm

259600

Ⓑ
259900

263400

313000

355700

14.8 mm

216800

259500

486100

945500

953241

948500

15 mm

Ⓗ
432100

16 mm

270000

Ⓔ
277600

925100

955900

16.6 mm

Ⓒ
420800

17 mm

Ⓓ
286600

17.8 mm

325300

18 mm

270200

357400

550500

908300

955000

18.6 mm

279200

279300

19 mm
19.23mm

514200

20 mm

279400

279500

297800

361000

301700

439500

516100

590100

924900

20.8 mm

541300

21 mm

357500

21.17 mm

474700

22 mm

245800

413700

439100

Ⓔ
599800*

978700

24 mm

279600

279700

418200

439400

448400

546100

599600

24.21 mm

Ⓚ
512000

25 mm

946700

25.98 mm

Ⓚ
514400

26 mm

978800

26.99 mm

567800

27 mm

271900

971605

27.75 mm

Ⓚ
578100

28 mm

223500

271600

321300

975100

29 mm

640005*

29.15 mm

379700

30 mm

279800

540500

547500

31 mm
31.9 mm

541800

32 mm

216100

259800

Ⓕ
306200

355800

587200

619600

619700

34 mm

384200

581700

590500

949200 / 623300+

986200

986300

35 mm

310700

310800

310900

311000

311100

386400

423500

423700

606900

611200

612100*

35.59 mm

Ⓚ
550100

35.98 mm

Ⓚ
579700

36 mm

412100

37 mm

394400

394500

394600

38 mm

266700

335900 / 463400+

>39 mm

589800*

589900*

Ⓚ
550200

412000

592900*

332500 / 613000+

391500

301800

470800

629400*

583900*

463500

328600

Ⓚ
567900

261000

Application solutions

Standard pressure plates

518800+

449500+

Standard curtainwall clip profiles

Ⓖ
472500 / 489800+

Pocket Filler

405900*

Sash Trim

405800*

Standard operating rod profiles

222400

Profiles for sliding doors

Ⓕ
306200

587200

306300

311300

354300

Shearless solution

20 mm

598700

24 mm

554715

32 mm

584815

34 mm

584715

Thermal isolator clip

41.65 mm

567700+

88.27 mm

540200+

Reglet design

Strip reglets

Ⓐ **4.20 mm Standard Head Dual Strips**

Variable distance per application

Recommended minimum separation is 2mm (0.08")

Ⓑ **5.77 mm Special Head Hollow Strip**

Ⓒ **6.48 mm Special Head Hollow Strip**

Hammers are different, due to strip contact.

Ⓓ **6.70 mm Special Head Hollow Strip**

Ⓔ **8.27 mm Special Head Hollow Strip**

Ⓕ **5.20 mm Special Head Special Strip**

Variable distance per application

Clip interface for 472500

Aluminum shown for reference only. Customer to verify actual tolerance required.

Ⓗ **5.77 mm Special Head Special Strip**

Ⓚ **2.31 mm Special Head Special Strip**

Radius = 0.20mm [0.008"]
Typical Radius = 0.30mm [0.012"]

** Reglet design for use with Aluminum Alloy 6063. All other alloys require design team review. **

Scale 10:1

Reglets setup

4:1

The standard reglet should be used for any strip with a standard head (4.2mm).

Interior of the reglet should not be changed.

The exterior can be modified some, but the 20° angle should not. This angle is critical to the crimping process.

Correct strip positioning

Steps for converting from a Hammer / Anvil reglet to a two hammer reglet.

Steps for hammer rotation

Correct rotation of hammers helps when designing systems and it's a very good way to check for clearance and assembly.

During the crimping process, the hammer outer edge will pressed by a crimp disc. Hammers will rotate until the two surfaces are parallel.
Rotation will be 20°.

Two methods can be use for rotation, first is a quick check and the second is a more accurate but will take a little longer.

Method one

Method two

Two lines are used for the second method, one is drawn from bottom/ left vertical. The other is the small vertical on right.

As you see in the overlay, there is a slight difference between the two.
It is best to use the second method for design work.

NORTH AMERICA

Technoform North America
1755 Enterprise Parkway, Suite 300,
Twinsburg, Ohio 44087 U.S.A
Phone 330-487-6600, Fax 330-487-6680, www.technoform.com

Issue Date: 11/04/2025

2025