

Accompanying information to the
online event of Gütegemeinschaft



Technologie Forum Zukunft

Modern welding processes for
quality-assured PVC windows

#02/2021



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After successful registration, the QR code will take you to the live event on 30 September 2021:
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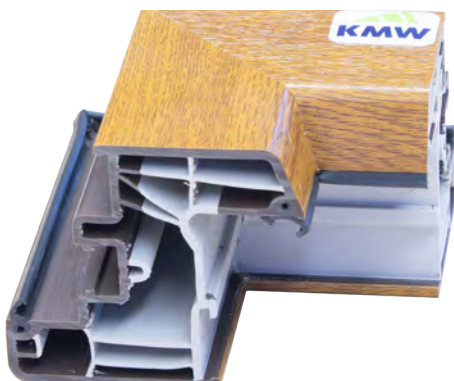




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FOREWORD

PVC windows have been welded since the 1960s. To this day, both window profiles and welding technology have been continuously developed. In addition to the conventional process, machine manufacturers offer alternatives like seamless welding for some years now.

Do the modern welding processes match with the current requirements in RAL-GZ 716 and how can the quality-determining characteristics be incorporated into the window manufacturer's factory production control?

These and other questions concerning the most important welding processes are dealt with by the GKFP working group Profile/Machines, in which experts from profile and machine manufacturers meet and, among other things, solutions for interface problems in window construction are worked out.

In the context of our event TechnologieForumZukunft „Modern Welding Processes for Quality-Assured PVC Windows“, the advantages and disadvantages of the various processes are presented and discussed by experts of the value chain. Furthermore, the relevant topic of quality assurance and innovation of welding processes is highlighted.

With this booklet accompanying this event, members of the Gütegemeinschaft present interesting facts of the most important welding processes and their current product portfolio, which is designed for both modern and conventional welding processes.

RAL Gütegemeinschaft Kunststoff-Fensterprofilsysteme

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System supplier

DRIVING FORCE IN THE WINDOW INDUSTRY

Innovations have a long tradition at aluplast GmbH. The claim: to supply window manufacturers all over the world with products with unique selling points. With representatives in 80 countries worldwide, the company is one of the driving forces in the international window industry.

aluplast is launching a new system platform neo with extremely slim profile views. With energeto® neo, the company has succeeded in combining timeless design with proven technologies (bonding, powerdur, foam inside, saftec).

energeto® neo enables the customers to build commercial or architectural windows on the basis of one platform. Compatibility and compatibility were at the forefront of the new development, which is why energeto® neo is just as suitable for large properties as it is for an architect's house. The innovative aluplast technologies guarantee thermal insulation, burglary protection and ease of use at the highest level.

REDUCING THE CO₂ FOOTPRINT

In its almost 40-year history, aluplast has launched many innovations. First and foremost, the bonding technology or the energeto® system, with which steel can be largely dispensed with thanks to bonding and powerdur technology. The system can thus boast a 15 percent lower CO₂ footprint compared to a conventional, steel-reinforced window. energeto® neo combines all the advantages of the well-known energeto® systems with a resource-saving platform and naturally meets all performance requirements.

THE WINDOW FOR EVERY HOME

The energeto® neo platform has a broad spectrum in which aluplast offers a flush variant as well as a recessed variant. The flush, closed variant enables a uniform, self-contained appearance and reduces the window to the essentials. Recessed windows give a façade more depth and spatiality. Nevertheless, due to the slim frame-sash combination, they do not appear too bulky and integrate perfectly into any house shape.

NEW SURFACES: RESOURCE-SAVING ALTERNATIVE

Increasingly, windows are also becoming part of the furnishings and are included in the room planning. Two main trends determine the design: the natural look of wood and the noble aluminium look.

aluplast picks up on both trends with the woodec and aludec surfaces. The woodec surface convinces with a deep grain and a pleasant feel – it looks and feels like real wood. The four wood tones from light to dark were inspired by the Scandinavian furnishing style. aludec is characterised by a perfect structure with a sand-matt feel. The surface can hardly be distinguished visually and tangibly from a real powder coating. The colour palette ranges from white to shades of grey and black.

The new surfaces offer many advantages in addition to their appearance. They are scratch-resistant, resist mechanical stress and are easy to clean – water and mild cleaners are enough.

VERY GOOD WELDABILITY ACROSS ALL SYSTEMS

aluplast profile systems meet the highest quality standards, also when it comes to weldability. The profiles can be easily and efficiently processed with all common welding machines.



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deceuninck



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ELEGANT PVC-U WINDOW PROFILE SYSTEMS WITH GLASS FIBRE TECHNOLOGY

The Deceuninck Group is one of the top two manufacturers of PVC window series and building products and is active in 91 countries. Deceuninck develops modern and sustainable solutions for doors and windows, roller shutters, terraces, façades and roof cladding. All products are recyclable and are now largely made from recycled PVC.

ELEGANT WINDOW PROFILE SYSTEM – POWERED BY ICOR

iCOR, the world's first building block system for window and door profiles, enables Deceuninck to reduce the levels of complexity significantly, since all the different sashes and frames can be combined with each other. This new development includes three different frame depths – 76, 84 and 115 mm – and five sash designs, which gives fabricators a wide range of combination options.

The 76-mm variant of the Elegant system has an outstanding U_f value of up to $0.93 \text{ W/m}^2\text{K}$. The unsurpassed slim "Elegant Abstract" design has received many accolades, including the Red Dot Award and the German Design Award. The small rebate of just 9 mm is unique for PVC windows. With its narrow, flush-fitting design, cubic glazing beads and anthracite-coloured window profiles, Elegant Abstract could easily be mistaken for an aluminium window.

Material that has been recycled using state-of-the-art technology is used in the core of the Elegant profiles, which makes the system especially sustainable. Capped with fresh PVC for outdoor applications, the result is a window profile of the highest quality that meets its functional demands.

THERMOFIBRA GLASS-FIBRE TECHNOLOGY

The iCOR core allows use of the new ThermoFibra fibre-glass technology. Endless glass fibres lend the windows an enormous degree of stability, making the use of steel reinforcement superfluous. The thermal insulation values are also improved by up to $U_f 0.88 \text{ W/m}^2\text{K}$ and, in addition, the weight is reduced considerably.

ThermoFibra has additional benefits for fabricators: Inventories are reduced and, since no steel or corner welding connectors are needed with Elegant Infinity front doors with ThermoFibra, fabrication time is reduced significantly. At the end of their service life, profiles with ThermoFibra can be completely recycled – for example, at the company's own recycling plant in Diksmuide, Belgium.

The Elegant system, also including ThermoFibra technology, is designed to be used with all modern welding processes on the market.



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NEW TRENDS COMPATIBLE WITH TRUSTED TOOLS AND SYSTEMS

The GEALAN group of companies is one of Europe's leading manufacturers of plastic profiles for window systems and doors. GEALAN profiles are designed, manufactured and distributed in-house. As an innovative system provider, GEALAN can offer its partners a comprehensive range of services and supports them in their everyday work with practice-related training and intelligent tools.

New developments complement proven systems and techniques. With award-winning digital planning support and useful enhancements for windows and doors, GEALAN offers its partners a broad and perfectly coordinated portfolio.

GEALAN's unrivalled surface technology acrylcolor has been proven in millions of profile metres for more than 40 years. Thanks to consistent and ongoing technological and material developments, as well as an expansion in the range of systems and colours, acrylcolor from GEALAN is in a better position than ever. Whether in modern architecture or in historic old buildings: With acrylcolor, GEALAN offers protection for surfaces in all building situations.

GEALAN-LINEAR® AND GEALAN-KUBUS®

With GEALAN-LINEAR®, the new development in the 74 mm segment, the GEALAN range will be expanded with a technically sophisticated profile system based on a consistently sleek design language, that is currently setting the tone in architecture, easy to process and designed with customer needs in mind.

With its classics such as the system platform S 9000, whose spectrum ranges from economical windows with rebate seal to high quality windows with a stable central gasket bar, or the design-oriented central gasket system GEALAN-KUBUS®, GEALAN

provides systems that allow window manufacturers the best possible differentiation in the market.

GEALAN-CAIRE® AND GEALAN-SENSE®

The product portfolio is complemented by versatile ventilation solutions from the GEALAN-CAIRE® family, some of which are smart-home compatible, as well as the retrofittable GEALAN-SENSE® intrusion sensors, which add an additional benefit to the window.

GEALAN partners also get digital support when it comes to window planning: planners, window manufacturers and installers can rely on the tried-and-tested planner software 2.0, which also provides new functions. The integration of BIM-capable file formats for the entire product portfolio is a standard feature.

This means that GEALAN covers the entire value chain for windows, front doors and sliding elements. With a portfolio consisting of proven tools and systems, constantly being refined and meaningfully supplemented by compatible system and product solutions, the system house sets real trends and forms the framework for the world of windows.



GEALAN Fenster-Systeme GmbH

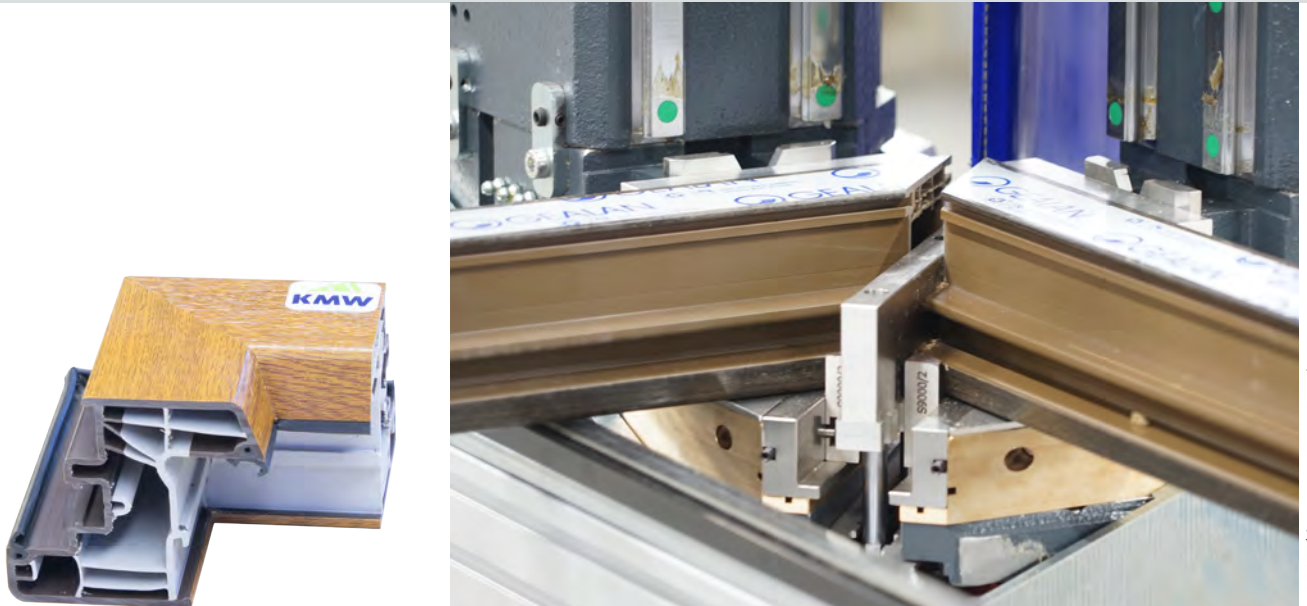
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SOLUTIONS ARE OUR COMMITMENT

In the tradition of engineering Saxony, KMW Engineering can look back on 70 years of experience in mechanical engineering. New services and innovative technologies have emerged and are continuously evolving and expanding.

In 1999, we added window machinery to our portfolio, and it soon became a mainstay of the company. It also benefits from the innovations of our special engineering department. Tailored to the customer's individual requirements, we design and manufacture complex production lines, which can be assembled and set up on 7,000m². Window manufacturing companies of any size appreciate this individual approach and KMW's expertise.

WELDING OF A SEAMLESS FOIL FINISH

It all started in 2012 when KMW first introduced a method to colour the shadow groove automatically in the corner cleaner.

2016, the welding machine for a seamless foil finish followed. The process, which is patented by KMW, uses hydraulic units to generate a suitably high joining pressure, so that the resulting welding bead is removed flush and creates a seamless foil finish.

High standards were set when the welder was developed:

- The common welding cycle shall be maintained, as almost all productions are based on a two-minute cycle, and even quick welding may be used for standard white elements.
- No material is removed from the bars to be joined before heating. This results in excellent corner stability and breaking patterns.
- Hinge drillings and machining of flying mullions are still possible with the corner cleaner.

KMW also patented a system in the welding machine that creates high joining pressure by hydraulic units, so that the welding bead is removed flush and a seamless film finish.



KMW Engineering GmbH

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profine
INTERNATIONAL PROFILE GROUP



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System supplier

EXCELLENT WELDABILITY OF OUR SYSTEMS

profine GmbH – International Profile Group – is a worldwide leading manufacturer of PVC-U profiles for windows and doors and a renowned provider of shutter systems and PVC sheets. With its KBE, KÖMMERLING, and TROCAL brands, the Group supplies its products to more than 100 countries and has an excellent international standing at 29 sites in 23 countries. profine Group manufactures at production facilities in Germany, France, Italy, Spain, Russia, India, the UK, Ukraine, the USA and China, with its head office in Troisdorf, North Rhine-Westphalia, and a payroll of over 3,000.

We set standards worldwide with our premium systems. Our high quality approach applies at all levels and of course also includes the excellent weldability of our systems.

For decades we have been accompanying the welding process, which is so decisive to the success story of the PVC-U window, with great commitment, and we are in close contact with all well-known industry partners. profine is an active member of the Profile/Machines working group of the GKFP quality association.

profine systems are also optimally prepared for the new welding technologies. Many of our customers have been using corresponding welding systems from different machine manufacturers for a long time in series production and enjoy their advantages.

The central specification for the evaluation of the welded corners remains the individually determined corner break value provided by us. Due to our high quality standards, this requirement applies regardless of the welding technology used. This has the advantage that the window user can always rely on tried and

tested specifications, regardless of the welding machine used.

As a leading system provider we also actively support the current research project with the SKZ with great commitment. We are thus creating an even better scientific basis for evaluating the dynamic long-term behavior of welded corner connections. Last but not least, this also strengthens Germany as a country for innovation.

TREND TOWARDS “WELDING WITHOUT PLASTINATION”

In order to accompany the trend towards “welding without plastination” even more intensively, and to make further use of the new possibilities it offers, and to support our partners in a more targeted manner, profine will soon have a corresponding 4-head system based on the latest state of development in our Window Innovations Center.

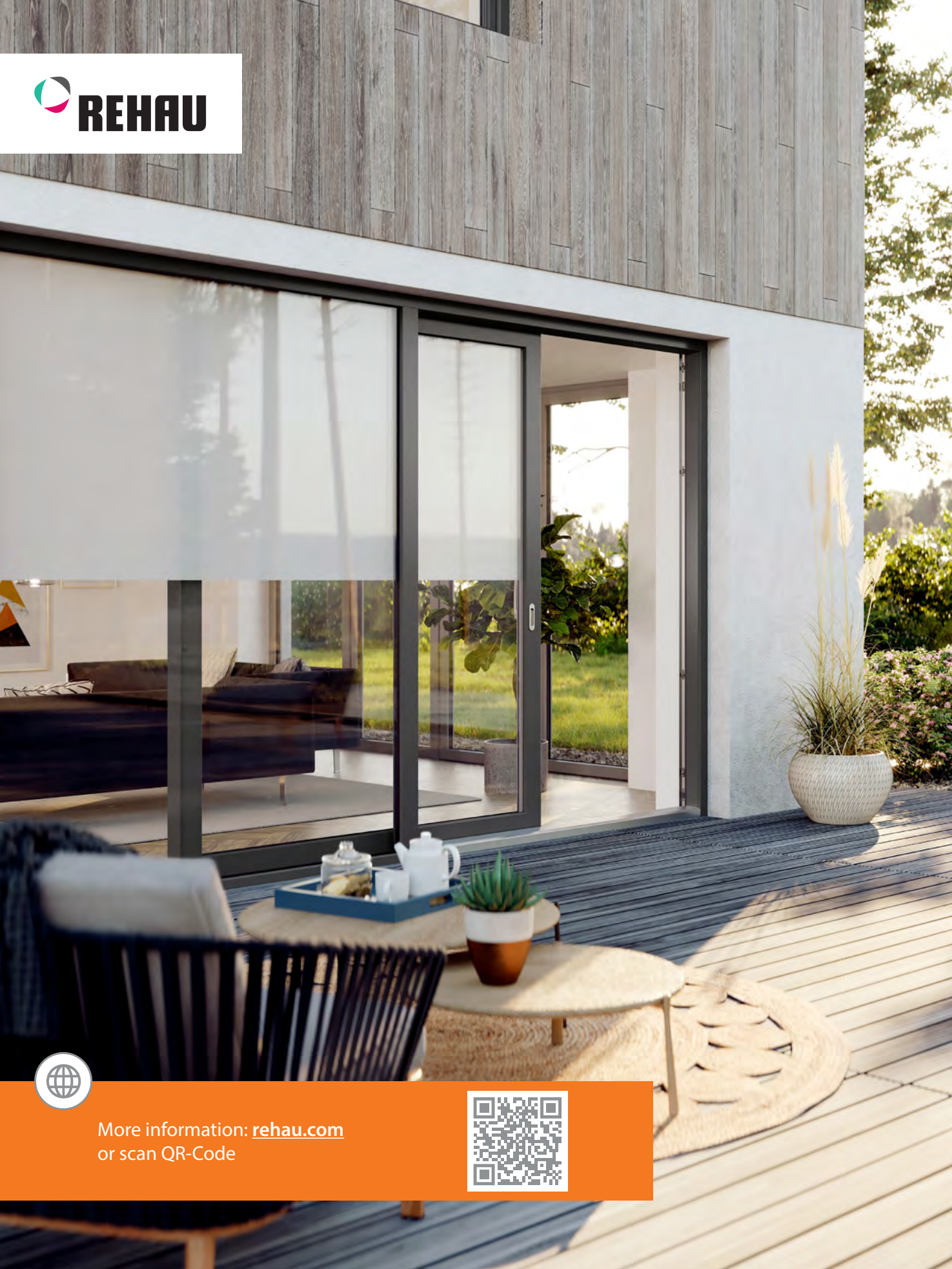
We are very pleased to be able to work with such a system and thank all our partners.



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System supplier

REHAU WINDOW SOLUTIONS. CREATE DIFFERENCE. GROW BUSINESS.

Competent in core business, smart solutions, digital services, successful accessories and a future-proof sustainability concept: REHAU Window Solutions reinvents windows and doors every day. For people and their lives. And with a unique recycling approach: EcoPuls stands for an unrivalled sustainability concept within the industry. As a pioneer and driver of sustainable industry solutions, REHAU Window Solutions continues to be the leading expert for material, system and service expertise - along the entire value chain and from one hand. Windows. Reinvented for modern life.

REHAU Window Solutions makes the difference. And thus ensures the success of window professionals with vision. Because products and services from REHAU Window Solutions consistently pursue the goal of designing future-proof and innovative solutions for windows and doors. These are oriented towards global megatrends such as sustainability, individualisation or security and therefore offer successful answers for economic added value in the long term. In keeping with the motto "Create Difference. Grow Business."

5 PILLARS FOR THE SUCCESS OF WINDOW PROFESSIONALS

Perfect profiles, smart solutions, digital services, successful accessories and a circular economy that is unrivalled in the industry: these five pillars make REHAU Window Solutions a stable partner for successful fabricators. Larger elements, greater stability and dimensional stability ensure growth and satisfied customers. Clever system additions, accessories for example, increase added value. This also applies to smart solutions such as the preventive burglary protection Smart Guard or Smart Privacy, a glass pane that darkens windows either completely or segment by segment at the touch of a button. Digital services additionally optimise

processes and quality. The digital window ID Window.ID makes the location of each window transparent and offers real added value, for example in terms of maintenance, personnel planning or sustainability.

SUSTAINABLE SUCCESS THROUGH CIRCULAR ECONOMY

Window systems from REHAU Window Solutions bear the EcoPuls label. It shows the commitment to and consistent implementation of the circular economy. This is the guiding principle of all responsible and sustainably successful window solutions. The constant optimisation and further development of the cycle ensures the superiority of the systems from REHAU Window Solutions and thus also earnings and sales at every point in the value chain.



REHAU Window Solutions

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ROTOX



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HIGH COMPETENCE IN WELDING AND FINISHING

With more than 400 employees and a production area of more than 27,000 sqm, ROTOX GmbH is one of the world's leading suppliers of machinery and equipment for the production of PVC and aluminium windows and doors.

In the extensive production programme, from cutting to glazing, there is a suitable product for every size of business and for every desired degree of automation. Among other things, ROTOX is known for its high competence in welding and finishing.

With all products, the focus is on quality, simple operation and high availability. Modern Windows controls enable simple networking and a high degree of production transparency.

TOGETHER WITH AFS FEDERHENN MASCHINEN GMBH

AFS Federhenn Maschinen GmbH has been a competent and reliable supplier of high-quality systems for efficient window production to the window manufacturing industry for 50 years. Over the years, the product range has been continuously expanded and perfected. The development stages range from assembly turntables to glazing presses, sash stop stations and fully automatic fitting assembly on frames and sashes, as well as automatic transport and buffer systems. Profile processing centres for different sizes of operation complete the programme.

WELDING

In the field of welding, we also offer a wide product range of different machines. Adapted to the needs of our customers and their markets. From the simple 1-head welding machine to highly complex multi-head welding machines, both for the simple

craftsman's business and for industrial production. The well-tried heated element butt welding is constantly finding new dimensions: Be it the "high-temperature welding", which has been established for some years and which, depending on the selected settings, allows cycle time reductions of up to 50%, or a better appearance of the inner corners and softer sealing joints.

The fully automatic assembly of transom bars in one operation is also possible on an HTS machine. In this case, the prepared transom bars are inserted into the welding machine together with the remaining 4 profile bars. The outer bars are drilled during the welding process, the transom bars are positioned exactly and screwed together automatically.

This makes the sometimes time-consuming manual transom assembly a thing of the past. Depending on the transom connection, the drilling and screwing processes even take place without cycle time.



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SALAMANDER

WINDOW & DOOR SYSTEMS



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System supplier

ATTRACTIVE AND SUSTAINABLE DESIGN WINDOWS

Salamander Industrie-Produkte GmbH, headquartered in Türkheim/Unterallgäu, is one of Europe's leading quality providers of energy-saving, design-oriented window and door systems with its Salamander Window & Door Systems brand. The company, which is majority family-owned, supplies innovative, customisable and tangible products that are sustainable, durable and future-oriented. As an experienced partner of window manufacturers, Salamander aligns its high-performance product range and its app-based solutions precisely to the needs of window buyers.

With greenEvolution, Salamander has developed a multi-compatible modular system that allows a high degree of individualisation and offers design and materiality in tangible diversity. With greenEvolution, a large number of window variants can be manufactured – including constructions with stop and centre seals, particularly narrow constructions with a facing width of only 100 mm, but also flush constructions.

Every window sash can be combined with every frame. This enables the fabricator to produce a wide range of windows with just a few profiles. From this modular system, he can select the constructions that best suit his clientele.

GRETA® DESIGN WINDOWS AND REALMATERIAL SURFACES

Greta® combines the advantages of window profiles with ecological performance. This profile system is sustainably produced: 100% of the PVC used comes from old windows and production residues and is designed to be 100% recyclable. In addition, Greta® has insulation values at passive house level. The modern, natural texture in concrete look not only corresponds to current architectural trends, but also turns windows into a tangible design object.

Salamander offers a variety of colours, materials and design surfaces that can be experienced. These are applied to the profile using the laminating process. Instead of the usual decorative surfaces, Salamander Window & Door Systems now offers surfaces made of real wood veneer, aluminium in a brushed stainless steel look, copper as well as quality leather fibre fabric. Recyclability is guaranteed for all surfaces.

EVOCORE+ AND EVOLUTIONDRIVE PLUS+

evoCore+ is made from recycled PET bottles. The material can be reintroduced into the material cycle after use, and since there is almost no waste during production, production waste can be reduced to almost 0%. Windows can be built in the same size as standard processes and burglary protection up to RC2 can be achieved. Another argument in favour of the innovative foam core is the issue of weight saving: the dead weight of evoCore+ is approx. 75% lighter compared to steel reinforcement.

evolutionDrive Plus+ is a new sliding system from Salamander Window & Door Systems that seals in parallel with the frame by means of a stop motion. This results in greater ease of use compared to the parallel sliding tilt door. The system is also more space-saving compared to the classic lift-slide door, as it has a smaller installation depth.



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SCHÜCO



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HIGH PRECISION IN PLANNING AND PROCESSING

Schüco Polymer Technologies KG has over 35 years of experience in the development, production and sale of innovative PVC-U system technology. As a wholly-owned Schüco subsidiary, it handles the strategically important PVC-U business division of the Group. Schüco Polymer Technologies is an expert and reliable partner in over 50 countries for PVC-U fabricators, distributors of ready-made units, architects and specifiers, housing development associations and investors as well as private clients. 960 employees and more than 3100 partner companies achieved a turnover of 280 million euros in 2020.

As a leader in technology, Schüco develops, produces and sells high-quality and sustainable system solutions for PVC-U windows, doors and sliding doors. In addition to profile systems, our product portfolio also includes fittings, ventilation solutions and other accessory components. Whether for residential or commercial projects, newbuilds or renovations, Schüco Polymer Technologies provides products for efficient building envelopes, which meet the highest requirements in terms of energy efficiency, security, comfort and design. And Schüco offers all of its partners a comprehensive service at every stage of the building process.

SCHÜCO MACHINERY SERVICE & WORKSHOP PLANNING

In order to ensure the same level of precision in fabrication as in the planning stage, Schüco Polymer Technologies KG also provides its partners with suitable machinery. Furthermore, Schüco designs custom fabrication concepts, which are adapted to suit the circumstances and needs of the Schüco partner. The result is long-term cost reduction and quality assurance through process optimisation and increased efficiency in all areas of fabrication.

WELDING TECHNOLOGY FROM SCHÜCO

With our comprehensive machinery portfolio, we offer different types of welding machinery for Schüco PVC-U systems. These are also configured for the welding of profiles with weldable EPDM gaskets. The machines can therefore also be used for fabricating our Schüco Living series.



Schüco Polymer Technologies KG

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U-R-B-A-N

Trust. Right from the start!



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READY FOR CHANGE AND THE FUTURE

URBAN GmbH is an esteemed global player and a reliable partner of the PVC window industry. Machines by Urban play an important part in the value-added chain „window“ and data exchange is materialized via interface with up- and downstream processes.

For some time we have been observing that many things are changing in view of the window product – software, technologies, processes, people: all these features are subject to extremely quick changes. We experience considerable changes which are already in reach now – directly at our customers.

We want to be part of this change and are already contributing to it for some time – no matter if a new technology is involved or another window manufacturing procedure or only simply as we are always willing to listen to our customers to deal with them individually. True to our motto „trust right from the start“.

READY FOR IDEAS OF THE FUTURE

How can productivity in window production be increased through the so called technology hub? How does smart manufacture revolutionize the future window production? And how can quality assessment be materialized sustainably although costs are supposed to be minimized at the same time for all processes?

These are only a few of the questions Urban GmbH & Co. Maschinenbau KG and further partners from industry and research are dealing intensively with.

On board are also the Kunststoff-Zentrum SKZ (Plastics Center SKZ) Urban is cooperating with for more than 30 years as well as the RAL Gütegemeinschaft Kunststoff-Fensterprofilssysteme.

For more than 30 years, Urban is a significant partner in the field of industry and development for the industry related research at the Würzburg based Kunststoff- Zentrum SKZ. Time and again, the machinery manufacturer and leading technology partner Urban participated in publicly subsidized research projects at the SKZ.

Also a number of direct research work had been commonly concluded by SKZ and Urban such as the project „welding process development for fibre-reinforced PVC window profiles“ (2011 to 2012) or the project „innovative technologies for welding of mineral-filled and fibreglass reinforced plastics“ (2011 to 2013).



Urban GmbH & Co. Maschinenbau KG

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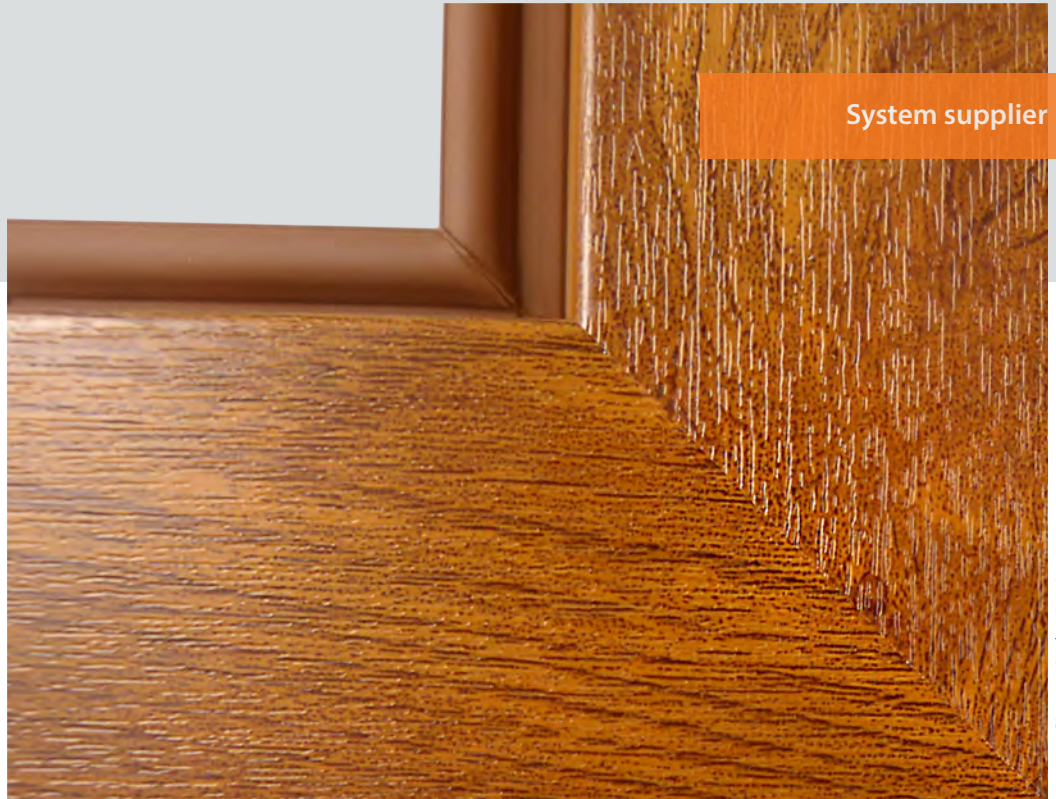


Das Qualitätsprofil
★★★★★★



More information: veka.de/en/system
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OUR PROMISE IS QUALITY

Since the company was founded in 1969, the VEKA brand has developed from a small regional business into a leading supplier of PVC-U profile systems for windows and doors. Today the family-run company from Westphalia is active on four continents: All over the world, quality-conscious fabricators and consumers rely on quality profiles produced in Sendenhorst when it comes to selecting profile systems for windows and doors. The internationally operating VEKA group is represented by 40 locations worldwide. 6,200 employees generated annual sales of 1.1 billion Euro in 2020. Currently 1,400 employees are working at the VEKA headquarters in Sendenhorst.

One key to the steady expansion of the company's competitive position is its consistent focus on products of the highest quality. In the profile sector, VEKA produces in Germany exclusively according to Class A quality level specifications.

Class A according to DIN EN 12608-1 is the highest European quality level for PVC-U window profiles. At VEKA, this is also a promise, because excellent material properties and high quality profile geometries ensure that our systems always meet the highest requirements. Especially when using new welding technologies such as beadless welding, where for example the PVC-welding-surface is milled back, our wall thicknesses and strict profile tolerances ensure corner strength and process reliability.

VEKA ALUCONNECT: ALUMINIUM WINDOW FOR WELDING

For the first time VEKA AluConnect enables to manufacture aluminium windows in the same way and almost as fast as PVC-U windows: by welding. This revolutionary approach opens up a wide range of practical and economic advantages. To manufacture aluminium windows with VEKA AluConnect, it is sufficient to weld the plastic cores together as usual. This only requires precisely milling back the aluminium profiles. When pressing them together, the mitre joint in the aluminium closes – the result is a high quality, almost gapless appearance.

EXCELLENT STATIC

VEKA AluConnect consists of high quality aluminium surfaces on a high-performance PVC-U core. The static bonding creates a permanent shear bond that gives windows a high level of stability.



VEKA AG

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DO YOU HAVE ANY QUESTIONS?

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