



# INVISI-GARD

## SECURITY SCREENS



# INVISI-GARD

## 316 STAINLESS STEEL SECURITY

### Technical Manual

August 2025 | ISSUE P

**alspec**<sup>®</sup>  
EVERYTHING ALUMINIUM  
& HARDWARE



## COMPLIANCE STATEMENT

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Alspec systems are tested and certified using specific components and hardware. To ensure the product performs as specified, all fabrication must strictly follow the configuration outlined in the relevant Alspec test reports.

Any substitution of tested components, including hardware, framing elements, or sealing systems, will result in a deviation from the approved system and is not supported by Alspec. Alspec does not warrant, endorse, or accept responsibility for the performance of any system assembled with unapproved or substitute parts.

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## Contents

|                                                          |            |
|----------------------------------------------------------|------------|
| <b>1. TECHNICAL MANUAL RELEASE NOTES</b>                 | <b>1.1</b> |
| <b>2. TECHNICAL SPECIFICATIONS</b>                       | <b>2.1</b> |
| <b>4. TEST SUMMARY</b>                                   | <b>4.1</b> |
| <b>5. EXTRUSIONS</b>                                     | <b>5.1</b> |
| Invisi-Gard Frame                                        | 5.1        |
| Invisi-Scape Frame                                       | 5.5        |
| <b>6. HARDWARE &amp; COMPONENTS</b>                      | <b>6.1</b> |
| Accessories                                              | 6.1        |
| SL200 Compliant Lock Hardware - Hinged Door              | 6.5        |
| SL200 Compliant Lock Hardware - Sliding Door             | 6.7        |
| SL100 Compliant Lock Hardware                            | 6.9        |
| Lock Hardware - Cylinders                                | 6.10       |
| Fasteners                                                | 6.11       |
| Mesh Sizes                                               | 6.12       |
| <b>7. TYPICAL ELEVATION</b>                              | <b>7.1</b> |
| <b>8. TYPICAL DETAILS</b>                                | <b>8.1</b> |
| Hinged Door - Side Detail                                | 8.1        |
| Hinged Door - Hardware Layout & Locking Points           | 8.3        |
| Sliding Door - Top Detail                                | 8.4        |
| Sliding Door - Hardware Layout & Locking Points          | 8.6        |
| Window Screen                                            | 8.7        |
| Typical Fixed Fire Attenuation Screen Installation       | 8.8        |
| Escape Screen - Open Out                                 | 8.9        |
| Escape Screen - Open In                                  | 8.10       |
| <b>9. CUTTING FORMULAS</b>                               | <b>9.1</b> |
| Hinged / Sliding Door                                    | 9.1        |
| Hinged / Sliding Door - ICPDF                            | 9.2        |
| Hinged / Sliding Door - Horizontal Mid Rail              | 9.3        |
| Fixed Screen                                             | 9.4        |
| Fixed Screen - IWF1E and IWF2E                           | 9.5        |
| Fixed Screen - Horizontal Mid Rail                       | 9.6        |
| Fixed Screen - Vertical Mid Rail                         | 9.7        |
| Invisi-Scape Outward Opening Screen - Top Hung           | 9.8        |
| Invisi-Scape Outward Opening Screen - Side Hung          | 9.9        |
| Invisi-Scape Inward Opening Screen - Top Hung            | 9.10       |
| Invisi-Scape Inward Opening Screen - Horizontal Mid Rail | 9.11       |
| Invisi-Scape Inward Opening Screen - Vertical Mid Rail   | 9.12       |

|                                                   |             |
|---------------------------------------------------|-------------|
| <b>10. MANUFACTURING DETAILS</b>                  | <b>10.1</b> |
| Roller Machining Detail                           | 10.1        |
| Rail Preparation                                  | 10.2        |
| Invisi-Scape Open Out Details                     | 10.3        |
| Invisi-Scape Open In Details                      | 10.3        |
| <b>11. ASSEMBLY DETAILS</b>                       | <b>11.1</b> |
| Invisi-Gard Assembly - Step One                   | 11.1        |
| Invisi-Gard Assembly - Step Two                   | 11.2        |
| Invisi-Gard Assembly - Step Three                 | 11.3        |
| Invisi-Gard Assembly - Step Four                  | 11.4        |
| Invisi-Gard Assembly - Door Tensioning Method     | 11.5        |
| Invisi-Gard Assembly - Mid Rail Assembly          | 11.6        |
| Invisi-Gard Disassembly                           | 11.7        |
| Invisi-Scape Outward Open                         | 11.8        |
| Invisi-Scape Outward Open Assembly - Step One     | 11.9        |
| Invisi-Scape Outward Opening Assembly - Step Two  | 11.10       |
| Invisi-Scape Outward Open Assembly - Step Three   | 11.11       |
| Invisi-Scape Outward Opening Assembly - Step Four | 11.12       |
| Invisi-Scape Outward Open Assembly - Step Five    | 11.13       |
| Invisi-Scape Outward Opening Assembly - Step Six  | 11.14       |
| Invisi-Scape Outward Open Assembly - Step Seven   | 11.15       |
| Invisi-Scape Inward Opening                       | 11.16       |
| Invisi-Scape Inward Opening - Step One            | 11.17       |
| Invisi-Scape Inward Opening - Step Two            | 11.18       |
| Invisi-Scape Inward Opening - Step Three          | 11.19       |
| Invisi-Scape Inward Opening - Step Four           | 11.20       |
| Invisi-Scape Inward Opening - Step Five           | 11.21       |
| Invisi-Scape Inward Opening - Step Six            | 11.22       |
| Invisi-Scape Inward Opening - Step Seven          | 11.23       |
| <b>13. CARE &amp; MAINTENANCE</b>                 | <b>13.1</b> |







## 2. Technical Specifications

The **INVISI-GARD 316 STAINLESS STEEL SECURITY** range of products has been fully TESTED and APPROVED in accordance with all of the relevant Australian Standards. This product range includes Stainless Steel Security Doors, Window Screens and Escape Window Screens.

The **INVISI-GARD** Dealership network is required to produce these products to the exact conditions detailed in the NATA CERTIFIED TEST REPORTS. They must also INSTALL these products in accordance with AS5040.

### Invisi-Gard Technical Specification

|                      |                                       |                                 |                   |
|----------------------|---------------------------------------|---------------------------------|-------------------|
| <b>Mesh</b>          | Marine Grade 316 Stainless Steel      | <b>Average Velocity Drop</b>    | 44.21%            |
| <b>Wire Diameter</b> | 0.8mm                                 | <b>Average Drag Coefficient</b> | 0.6998 $C_D$      |
| <b>Mesh Count</b>    | 11 x 11 strands per 25mm <sup>2</sup> | <b>Wire Tensile Strength</b>    | 900 MPa (Nominal) |
| <b>Aperture Size</b> | 1.6mm x 1.6mm                         | <b>Open Area</b>                | 44 %              |

### Maximum Build Sizes

|                                  | HEIGHT (mm) | WIDTH (mm) | AREA (m <sup>2</sup> ) |
|----------------------------------|-------------|------------|------------------------|
| <b>SLIDING DOORS</b>             |             |            |                        |
| <b>Without Midrails</b>          | 2400        | 1200       | 2.8                    |
| <b>With Midrails</b>             | 3000        | 1500       | 4                      |
| <b>HINGE DOORS</b>               |             |            |                        |
| <b>Without Midrails</b>          | 2400        | 1000       | 2.4                    |
| <b>With Midrails</b>             | 3000        | 1000       | 2.6                    |
| <b>WINDOW SCREENS</b>            |             |            |                        |
| <b>Fixed Screen</b>              | 1500        | 1800       | 2.7                    |
| <b>Escape Screen - Top Hung</b>  | 1500        | 1800       | 2.7                    |
| <b>Escape Screen - Side Hung</b> | 1800        | 1500       | 2.7                    |

Midrails are recommended in larger screen sizes to improve the rigidity of the mesh, large screen sizes without midrails can suffer mesh tension issues.

For the best results, the top and bottom rail of all door frames should be bowed approx. 5mm using a clamping system prior to wedging in the mesh, this will create pre-tension on the frame which will pull the mesh taut upon release of the clamp. Refer to page 11.5 for more information.



4. Test Summary

Security

Dynamic Impact Test



Australian Standard AS5039/5041-2008 Security Screen Doors and Security Windows Grilles

| Dynamic Impact Test                                             | Test No.   | PASS |
|-----------------------------------------------------------------|------------|------|
| Hinged Security Screen Door                                     | 2012042-5  | ✓    |
| Sliding Security Screen Door                                    | 2012042-3  | ✓    |
| Security Window Grille                                          | 2012042-1  | ✓    |
| Security Screen Door x 50 impacts (10x the Australian Standard) | OT.SS21-08 | ✓    |

The patented EGP (Extreme Grip Protection) retention system allows Invisi to easily absorb the impact energy required by Australian Security Screen Standards. In fact Invisi-Gard® far exceeds this requirement and can resist in excess of 50 consecutive impacts, each of 100 Joules without failure, up to 10 times the Australian Standard requirement.

Jemmy Test



Australian Standard AS5039/5041-2008 Security Screen Doors and Security Windows Grilles

| Jemmy Test                   | Test No.  | PASS |
|------------------------------|-----------|------|
| Hinged Security Screen Door  | 2012042-5 | ✓    |
| Sliding Security Screen Door | 2012042-3 | ✓    |
| Security Window Grille       | 2012042-1 | ✓    |

Invisi-Gard® is tested to withstand jemmy attacks from levers, such as large screwdrivers, used to apply large amounts of torque to locks and hinges.

Knife Shear Test



Australian Standard AS5039-2008 Security Screen Doors and Security Windows Grilles

| Knife Shear Test                | Test No.   | PASS |
|---------------------------------|------------|------|
| Knife Shear test on Invisi Mesh | AZT0371.23 | ✓    |

Invisi-Gard® successfully repels intruder attacks using utility knives or similar bladed tools used by a burglar seeking entry into your home.

Child Fall Prevention



Australian Standard AS5203 - Protection Of Openable Window Fall Prevention Test

| Outward Force Test        | PASS |
|---------------------------|------|
| Resist 250N outward force | ✓    |

Invisi-Gard® window screens provide protection against children falling out of second floor windows.

Bushfire



Australian Standard AS1530.8.1 Methods Of Fire Tests On Building Materials - Radiant Heat And Small Flaming Sources

| Bushfire Test                                            | Test No. | PASS |
|----------------------------------------------------------|----------|------|
| BAL40 rating for Invisi-Gard                             | FE2548B  | ✓    |
| BAL40 rating for Invisi-Gard and Breezway Altair Louvres | FSZ1662A | ✓    |

Invisi-Gard® is bushfire rated and protects your property from floating embers and reduces heat intensity of radiant heat flux. Invisi-Gard® meets the deemed to satisfy requirements of AS3959 for screening of openable parts of windows and doors up to BAL FZ conditions.

Fire Attenuation



Australian Standard AS1530.4-2014 Appendix B7

| Fire Attenuation Test                                                      | Test No.  | PASS |
|----------------------------------------------------------------------------|-----------|------|
| Achieves a fire attenuation rating of up to 55% at 40kW/m² incident energy | 52577300a | ✓    |

Invisi-Gard® provides protection to limit the potential for fire spread to occur between buildings via flames and/or radiant heat.

Energy Efficiency



Window Energy Rating Scheme (WERS)

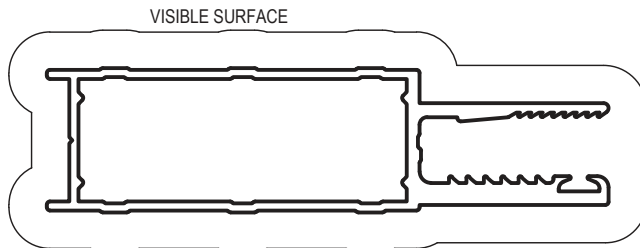
| WERS Test                                                                                    | SHGC | Improvement |
|----------------------------------------------------------------------------------------------|------|-------------|
| WERS rating for a Generic Aluminium Window with 3mm clear glass fitted with an Invisi Screen | 0.38 | 51%         |

Fitting Invisi-Gard® Security Screens over the outside of your window can improve the energy efficiency of your window by up to 51%.



## 5. Extrusions

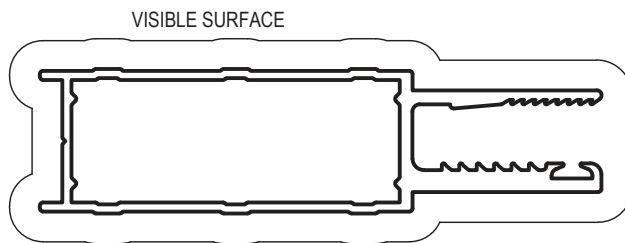
### Invisi-Gard Frame



#### **IDF1**

##### INVISI DOOR FRAME

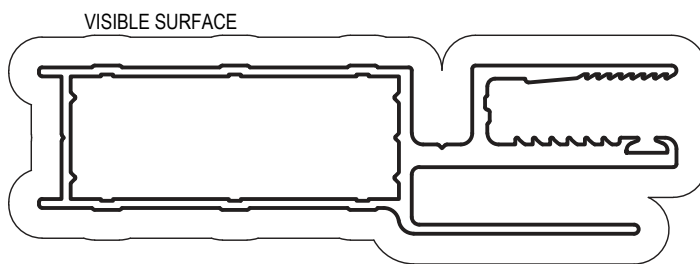
Anod. Per. 266  
Paint Per. 185



#### **IDFC**

##### INVISI DOOR FRAME (CENTRE)

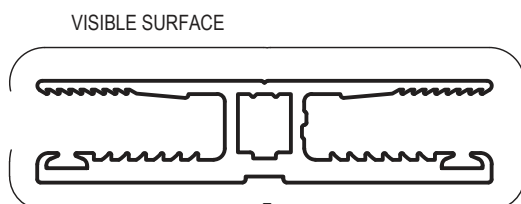
Anod. Per. 266  
Paint Per. 185



#### **ICPDF**

##### INVISI CAST PANEL DOOR FRAME

Anod. Per. 370  
Paint Per. 289



#### **IMR1**

##### INVISI MIDRAIL

Anod. Per. 296  
Paint Per. 135

## 5. Extrusions

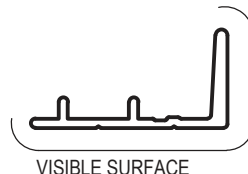
### Invisi-Gard Frame

VISIBLE SURFACE



**HD3**  
OFFSET INTERLOCK

Anod. Per. 100  
Paint Per. 100



**HD9**  
FRAME INTERLOCK

Anod. Per. 100  
Paint Per. 100



**HD10**  
EXTENDED 7mm OFFSET  
INTERLOCK

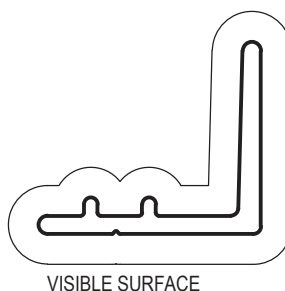
Anod. Per. 100  
Paint Per. 100

VISIBLE SURFACE



**HD21**  
HEAVY DUTY  
FLAT INTERLOCK

Anod. Per. 100  
Paint Per. 100



**HD23**  
HEAVY DUTY  
FRAME INTERLOCK

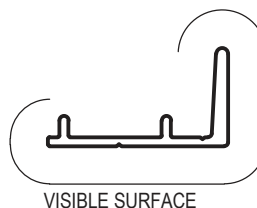
Anod. Per. 114  
Paint Per. 114

VISIBLE SURFACE



**HD22**  
HEAVY DUTY  
STEPPED INTERLOCK

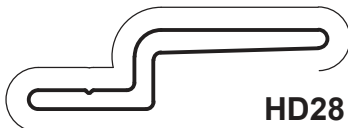
Anod. Per. 100  
Paint Per. 100



**HD29**  
ALTITUDE / CARINYA  
INTERLOCK

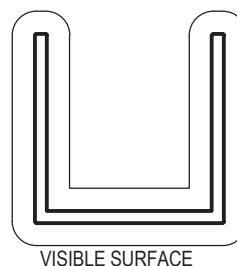
Anod. Per. 100  
Paint Per. 100

VISIBLE SURFACE



**HD28**  
HEAVY DUTY  
DEEP INTERLOCK

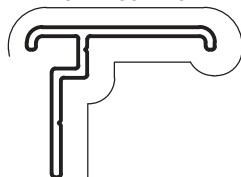
Anod. Per. 100  
Paint Per. 100



**HD6**  
CHANNEL  
25 x 25 x 1.6mm

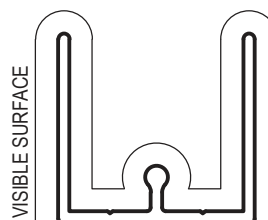
Anod. Per. 146  
Paint Per. 146

VISIBLE SURFACE



**TM18**  
OFFSET T MULLION

Anod. Per. 100  
Paint Per. 100

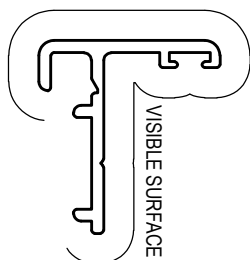


**ST8**  
BOTTOM SLIDING  
TRACK

Anod. Per. 160  
Paint Per. 138

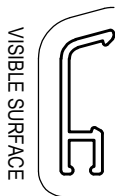
## 5. Extrusions

### Invisi-Gard Frame



**TM5**  
SECURITY  
MULLION

Anod. Per. 126  
Paint Per. 100



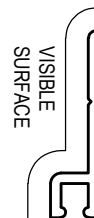
**MF75**  
WEATHERSEAL  
SNAP ON COVER

Anod. Per. 100  
Paint Per. 100



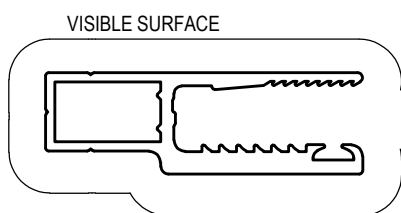
**BS1**  
BUGSTRIP  
SHORT LEG

Anod. Per. 100  
Paint Per. 100



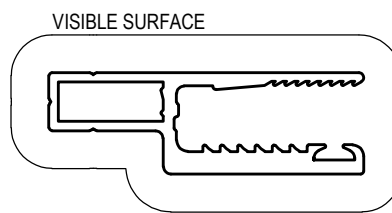
**BS2**  
BUGSTRIP  
LONG LEG

Anod. Per. 100  
Paint Per. 100



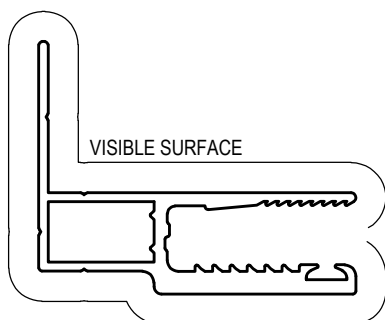
**IWF1**  
INVISI WINDOW FRAME 11mm

Anod Per. 184  
Paint Per. 103



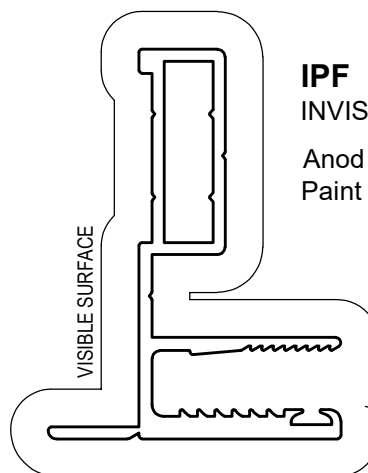
**IWF2**  
INVISI WINDOW FRAME 9mm

Anod Per. 184  
Paint Per. 102



**IWF3**  
INVISI WINDOW FRAME WITH LEG

Anod Per. 225  
Paint Per. 144

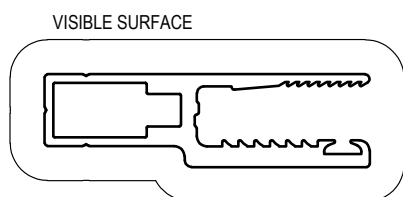


**IPF**  
INVISI PATIO FRAME

Anod Per. 274  
Paint Per. 274

## 5. Extrusions

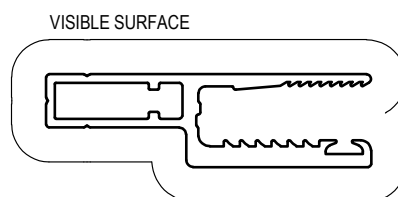
### Invisi-Gard Frame



#### **IWF1E**

EXTENDED INVISI 11mm  
WINDOW FRAME

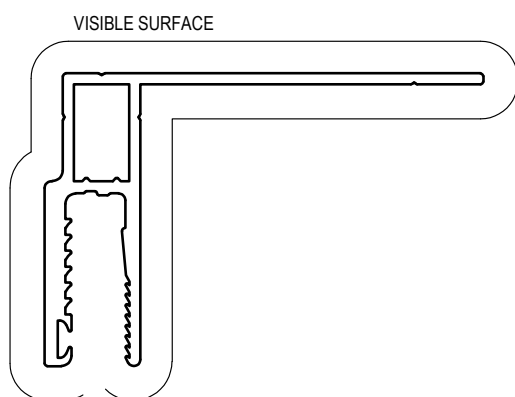
Anod Per. 194  
Paint Per. 108



#### **IWF2E**

EXTENDED INVISI 9mm  
WINDOW FRAME

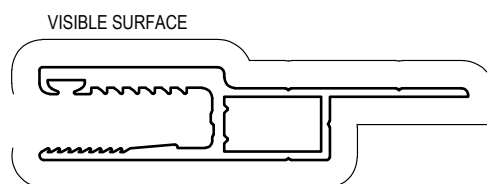
Anod Per. 195  
Paint Per. 108



#### **IWF3E**

INVISI-GARD  
50mm OFFSET

Anod Per. 285  
Paint Per. 199



#### **IWF1L**

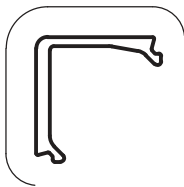
INVISI WINDOW FRAME  
11mm WITH LEG

Anod Per. 224  
Paint Per. 137

5. Extrusions

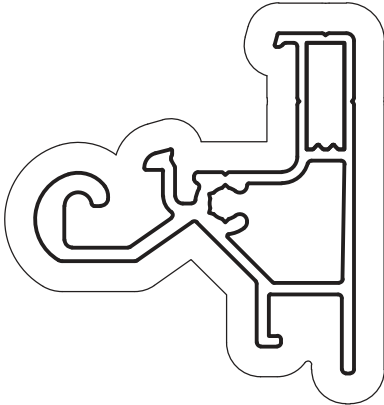
Invisi-Scape Frame

VISIBLE SURFACE



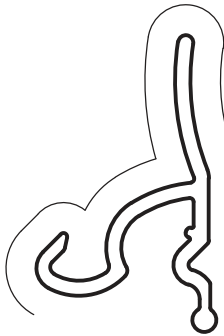
**IWF12**  
FRAME INFILL  
Anod Per. 100  
Paint Per. 100

VISIBLE SURFACE



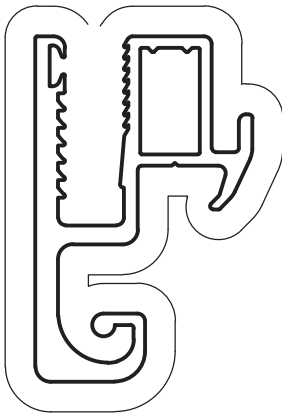
**IWF11**  
PERIMETER HINGE FRAME  
Anod Per. 240  
Paint Per. 240

VISIBLE SURFACE



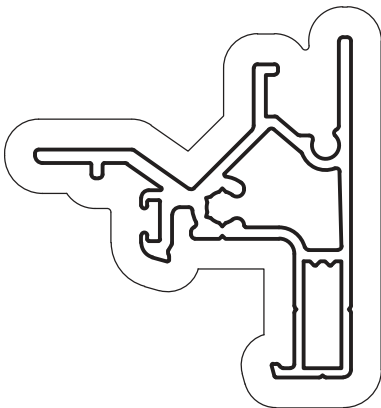
**IWF15**  
ESCAPE HANDLE  
Anod Per. 157  
Paint Per. 100

VISIBLE SURFACE



**IWF14**  
INVISI-GARD ESCAPE SASH  
Anod Per. 281  
Paint Per. 200

VISIBLE SURFACE

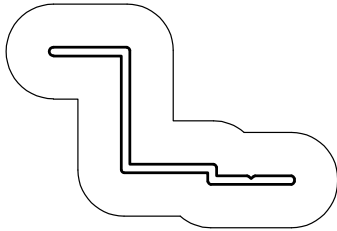


**IWF10**  
PERIMETER FRAME  
Anod Per. 232  
Paint Per. 232

## 5. Extrusions

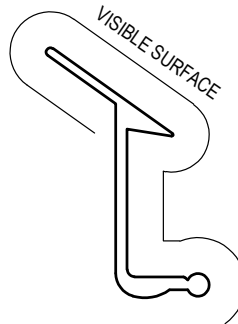
### Invisi-Scape Frame

VISIBLE SURFACE



**IH**  
INVISI HANDLE

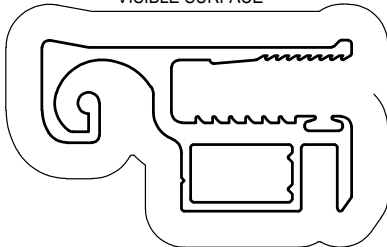
Anod Per. 105  
Paint Per. 105



**IOLH**  
IOLH INVISI I/O LOCK HDL

Anod Per. 113  
Paint Per. 100

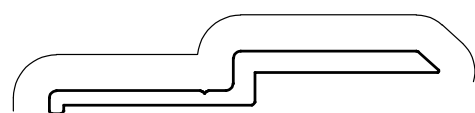
VISIBLE SURFACE



**IOS**  
IOS INVISI I/O SASH

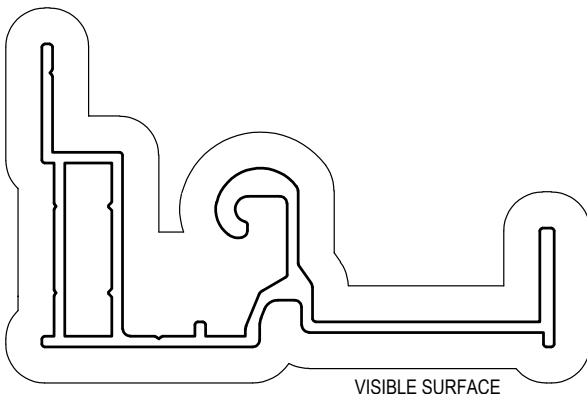
Anod Per. 260  
Paint Per. 124

VISIBLE SURFACE



**IDSAJA**  
INVISI I/O ANT JEM AD

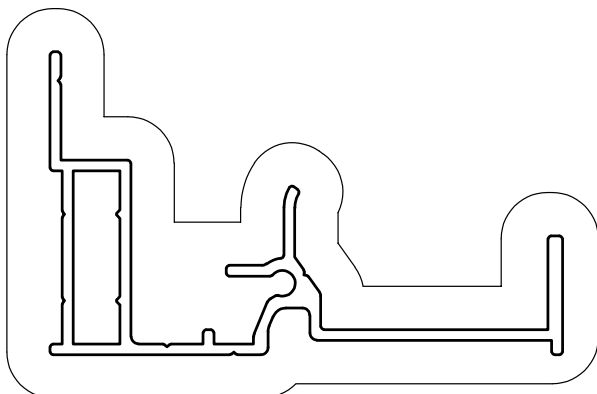
Anod Per. 122  
Paint Per. 100



**IOPHF**  
INVISI I/O HINGE FRAME

Anod Per. 336  
Paint Per. 336

VISIBLE SURFACE



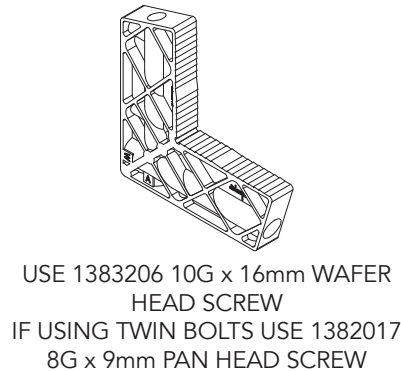
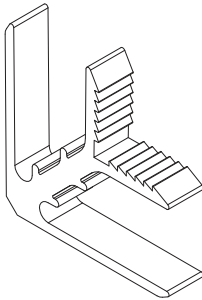
**IIOPLF**  
INVISI I/O PER LOCK FR

Anod Per. 325  
Paint Per. 325

VISIBLE SURFACE

## 6. Hardware & Components

### Accessories



#### P2 HEAVY DUTY SEC DOOR CORNER

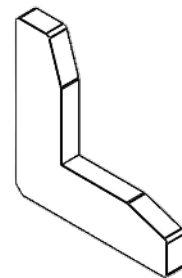
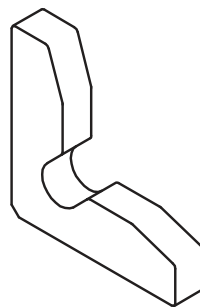
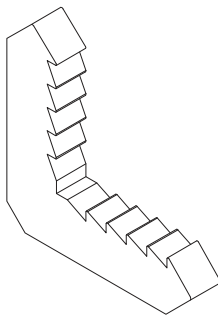
|        |            |
|--------|------------|
| PART   | 1311211    |
| FINISH | MILL (001) |
| QTY    | EACH       |

#### P3A NYLON CORNER STAKE WITH FLUSH BOLT HOLE x 1

|        |             |
|--------|-------------|
| PART   | 1311243     |
| FINISH | BLACK (034) |
| QTY    | EACH        |

#### IMS INVISI MIDRAIL STAKE - BAG OF 50

|        |              |
|--------|--------------|
| PART   | 1409100      |
| FINISH | MILL (001)   |
| QTY    | BAG (50/BAG) |



#### P5 SEC WINDOW CORNER

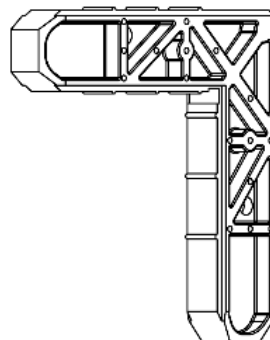
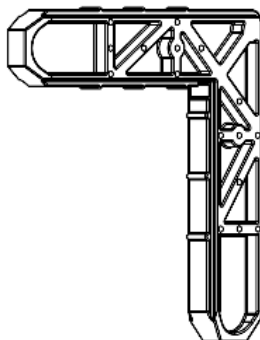
|        |                     |
|--------|---------------------|
| PART   | 1311226             |
| FINISH | NOT SPECIFIED (099) |
| QTY    | EACH                |

#### P5B STRAIGHT EDGE SEC WINDOW CORNER

|        |                     |
|--------|---------------------|
| PART   | 1311229             |
| FINISH | NOT SPECIFIED (099) |
| QTY    | EACH                |

#### P13 CORNERS (SUITS SW3)

|        |                     |
|--------|---------------------|
| PART   | 1311237             |
| FINISH | NOT SPECIFIED (099) |
| QTY    | EACH                |



#### ALSPEC FS3 CORNER FOR FS3 22 x 9mm FRAME

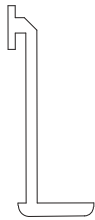
|        |             |
|--------|-------------|
| PART   | 1324024     |
| FINISH | BLACK (034) |
| QTY    | EACH        |

#### ALSPEC FS2 CORNER FOR FS2 22 x 11mm FRAME

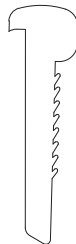
|        |             |
|--------|-------------|
| PART   | 1324000     |
| FINISH | BLACK (034) |
| QTY    | EACH        |

## 6. Hardware & Components

### Accessories



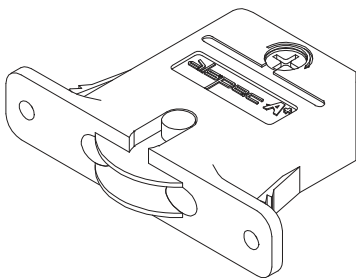
| II1 INVISI INSULATOR x 100m |             |
|-----------------------------|-------------|
| PART                        | 1409110     |
| FINISH                      | BLACK (034) |
| QTY                         | ROLL (100m) |



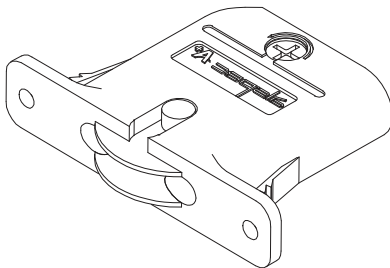
| IW1 INVISI WEDGE x 4m (25L PER PKT) |                  |
|-------------------------------------|------------------|
| PART                                | 1409105          |
| FINISH                              | BLACK (034)      |
| QTY                                 | PACK (25 L/PACK) |



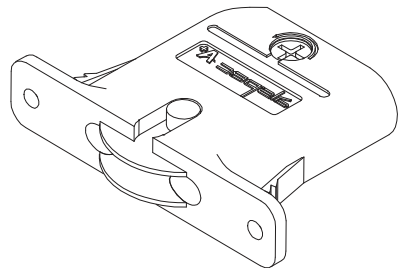
| IK1 INVISI KEEPER x 100m |             |
|--------------------------|-------------|
| PART                     | 1409115     |
| FINISH                   | BLACK (034) |
| QTY                      | ROLL (100m) |



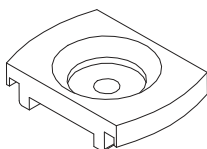
| ALSPEC DUO-FIT SEC DOOR ROLLER SS BEARING 20kg |             |
|------------------------------------------------|-------------|
| PART                                           | 1311900     |
| FINISH                                         | BLACK (034) |
| QTY                                            | EACH        |



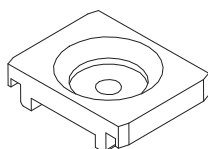
| ALSPEC OFFSET SECURITY DOOR ROLLER 25kg |             |
|-----------------------------------------|-------------|
| PART                                    | 1311904     |
| FINISH                                  | BLACK (034) |
| QTY                                     | EACH        |



| ALSPEC OFFSET SECURITY DOOR ROLLER SS 40kg |             |
|--------------------------------------------|-------------|
| PART                                       | 1311905     |
| FINISH                                     | BLACK (034) |
| QTY                                        | EACH        |



| 23.5mm ALSPEC SCREEN DOOR TOP GUIDE |             |
|-------------------------------------|-------------|
| PART                                | 1309906     |
| FINISH                              | BLACK (034) |
| QTY                                 | EACH        |



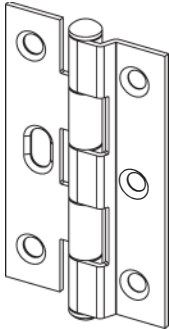
| 21.5mm ALSPEC SCREEN DOOR TOP GUIDE |            |
|-------------------------------------|------------|
| PART                                | 1309905    |
| FINISH                              | GREY (036) |
| QTY                                 | EACH       |



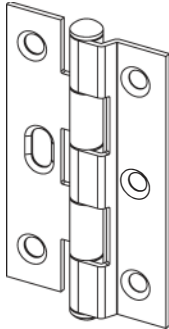
| ALSPEC SECURITY DOOR SOFT CLOSER SC3250PK |             |
|-------------------------------------------|-------------|
| PART                                      | 1311906     |
| FINISH                                    | BLACK (034) |
| QTY                                       | EACH        |

6. Hardware & Components

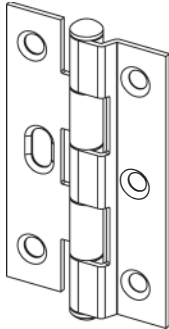
Accessories



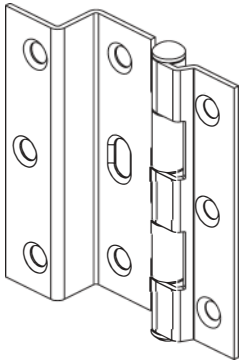
| ALSPEC STEPPED SECURITY DOOR HINGE |             |
|------------------------------------|-------------|
| PART                               | 1371817     |
| FINISH                             | BLACK (034) |
| QTY                                | EACH        |



| ALSPEC STEPPED SECURITY DOOR HINGE |                       |
|------------------------------------|-----------------------|
| PART                               | 1304180               |
| FINISH                             | STAINLESS STEEL (0G8) |
| QTY                                | EACH                  |



| ALSPEC STEPPED SECURITY DOOR HINGE |                               |
|------------------------------------|-------------------------------|
| PART                               | 1311051                       |
| FINISH                             | WHITE (010)<br>PRIMROSE (012) |
| QTY                                | PAIR                          |



| ALSPEC SCREEN DOOR STEP OVER HINGE |             |
|------------------------------------|-------------|
| PART                               | 1371818     |
| FINISH                             | BLACK (034) |
| QTY                                | EACH        |



Note: Other colours available on request



| INVENTCO 3S WATER DOOR CLOSER |             |
|-------------------------------|-------------|
| PART                          | 1311002     |
| FINISH                        | BLACK (034) |
| QTY                           | EACH        |

| ALSPEC AC100 SECURITY DOOR CLOSER |             |
|-----------------------------------|-------------|
| PART                              | 1379770     |
| FINISH                            | BLACK (034) |
| QTY                               | EACH        |



| ALSPEC SECURITY DOOR CLOSER HD (25kg) |             |
|---------------------------------------|-------------|
| PART                                  | 1311907     |
| FINISH                                | BLACK (034) |
| QTY                                   | EACH        |



| AUSTRAL STD SCREEN DOOR CLOSER |             |
|--------------------------------|-------------|
| PART                           | 1308001     |
| FINISH                         | BLACK (034) |
| QTY                            | EACH        |



| AUSTRAL DOUBLE FLUSH BOLT FOR SECURITY DOORS |             |
|----------------------------------------------|-------------|
| PART                                         | 1308004     |
| FINISH                                       | BLACK (034) |
| QTY                                          | EACH        |

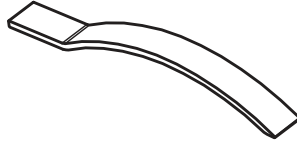
## 6. Hardware & Components

### Accessories



#### W203817 SECURITY DOOR FLUSH BOLT 20mm

|        |             |
|--------|-------------|
| PART   | 1301250     |
| FINISH | BLACK (034) |
| QTY    | EACH        |



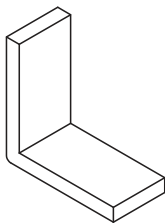
#### IOOSSB INVISI S/S BOWSPRINGS

|        |                       |
|--------|-----------------------|
| PART   | 1409036               |
| FINISH | STAINLESS STEEL (0G8) |
| QTY    | EACH                  |



#### CE5.5 CO-EXT BULB SEAL (5.5mm DIAMETER)

|        |             |             |
|--------|-------------|-------------|
| PART   | 1376345     | 1376456     |
| FINISH | BLACK (034) | BLACK (034) |
| QTY    | ROLL (250m) | METRE       |



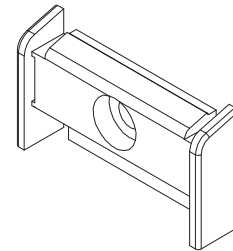
#### ICS INVISI CORNER STAKEx20/BAG

|        |                     |
|--------|---------------------|
| PART   | 1409120             |
| FINISH | NOT SPECIFIED (099) |
| QTY    | BAG                 |



#### FIRE ATTENUATION LABEL 118 x 50 x 1mm

|        |                    |
|--------|--------------------|
| PART   | 1300039            |
| FINISH | RED ANODISED (0LS) |
| QTY    | EACH               |



#### MFA75 END CAP COMPONENT

|        |             |
|--------|-------------|
| PART   | 1378995     |
| FINISH | BLACK (034) |
| QTY    | EACH        |



#### PS11 11mm FRINGE PILE x 100m

|        |             |
|--------|-------------|
| PART   | 1377408     |
| FINISH | BLACK (034) |
| QTY    | ROLL (100m) |

#### PS16 16mm FRINGE PILE x 100m

|        |             |
|--------|-------------|
| PART   | 1377415     |
| FINISH | BLACK (034) |
| QTY    | ROLL (100m) |

#### PS13 13mm FRINGE PILE x 100m

|        |             |
|--------|-------------|
| PART   | 1377414     |
| FINISH | BLACK (034) |
| QTY    | ROLL (100m) |

#### PS20 20mm FRINGE PILE x 100m

|        |             |
|--------|-------------|
| PART   | 1377423     |
| FINISH | BLACK (034) |
| QTY    | ROLL (100m) |

6. Hardware & Components

SL200 Compliant Lock Hardware - Hinged Door



|  | PART    | DESCRIPTION                                 | FINISH   | QTY  |
|-----------------------------------------------------------------------------------|---------|---------------------------------------------|----------|------|
|                                                                                   | 1332230 | TRISER HINGED HOOK PROJECTION BOLT SEC LOCK | BLACK    | EACH |
|                                                                                   | 1332231 | TRISER HINGED HOOK PROJECTION BOLT SEC LOCK | WHITE    | EACH |
|                                                                                   | 1332232 | TRISER HINGED HOOK PROJECTION BOLT SEC LOCK | MONUMENT | EACH |
|                                                                                   | 1332233 | TRISER HINGED HOOK PROJECTION BOLT SEC LOCK | PRIMROSE | EACH |

|  | PART    | DESCRIPTION                                       | FINISH   | QTY  |
|-------------------------------------------------------------------------------------|---------|---------------------------------------------------|----------|------|
|                                                                                     | 1332234 | TRISER HINGED DOOR MULTI POINT KIT (ROD OPERATED) | BLACK    | EACH |
|                                                                                     | 1332270 | TRISER HINGED DOOR MULTI POINT KIT (ROD OPERATED) | WHITE    | EACH |
|                                                                                     | 1332271 | TRISER HINGED DOOR MULTI POINT KIT (ROD OPERATED) | MONUMENT | EACH |
|                                                                                     | 1332273 | TRISER HINGED DOOR MULTI POINT KIT (ROD OPERATED) | PRIMROSE | EACH |

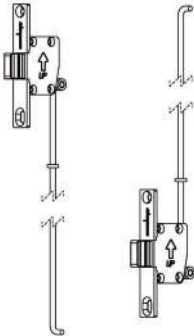
Refer to page 6.11 for cylinders

6. Hardware & Components

SL200 Compliant Lock Hardware - Hinged Door



|  | PART    | DESCRIPTION                          | FINISH        | QTY  |
|-----------------------------------------------------------------------------------|---------|--------------------------------------|---------------|------|
|                                                                                   | 1308142 | HETA HINGED PROJECTION BOLT SEC LOCK | BLACK         | EACH |
|                                                                                   | 1308143 | HETA HINGED PROJECTION BOLT SEC LOCK | WHITE         | EACH |
|                                                                                   | 1308144 | HETA HINGED PROJECTION BOLT SEC LOCK | PRIMROSE      | EACH |
|                                                                                   | 1308187 | HETA HINGED PROJECTION BOLT SEC LOCK | MONUMENT      | EACH |
|                                                                                   | 1332400 | HETA HINGED PROJECTION BOLT SEC LOCK | WOODLAND GREY | EACH |
|                                                                                   | 1332401 | HETA HINGED PROJECTION BOLT SEC LOCK | PAPERBARK     | EACH |
|                                                                                   | 1332402 | HETA HINGED PROJECTION BOLT SEC LOCK | SURFMIST      | EACH |
|                                                                                   | 1332403 | HETA HINGED PROJECTION BOLT SEC LOCK | WHITE BIRCH   | EACH |

|  |                                                 |         |       |       |        |      |
|-------------------------------------------------------------------------------------|-------------------------------------------------|---------|-------|-------|--------|------|
| PART                                                                                | DESCRIPTION                                     | SETTING | A     | B     | FINISH | QTY  |
| 1395004                                                                             | HETA HINGED DOOR MULTI POINT KIT (ROD OPERATED) | HIGH    | 682mm | 826mm | BLACK  | EACH |
|                                                                                     |                                                 | LOW     | 826mm | 682mm |        |      |

Refer to page 6.11 for cylinders

6. Hardware & Components



SL200 Compliant Lock Hardware - Sliding Door



|  | PART    | DESCRIPTION                       | FINISH   | QTY  |
|-----------------------------------------------------------------------------------|---------|-----------------------------------|----------|------|
|                                                                                   | 1332235 | TRISER SLIDING HOOK BOLT SEC LOCK | BLACK    | EACH |
|                                                                                   | 1332236 | TRISER SLIDING HOOK BOLT SEC LOCK | WHITE    | EACH |
|                                                                                   | 1332237 | TRISER SLIDING HOOK BOLT SEC LOCK | MONUMENT | EACH |
|                                                                                   | 1332238 | TRISER SLIDING HOOK BOLT SEC LOCK | PRIMROSE | EACH |

|  | PART    | DESCRIPTION                                        | FINISH   | QTY  |
|-------------------------------------------------------------------------------------|---------|----------------------------------------------------|----------|------|
|                                                                                     | 1332239 | TRISER SLIDING DOOR MULTI POINT KIT (ROD OPERATED) | BLACK    | EACH |
|                                                                                     | 1332273 | TRISER SLIDING DOOR MULTI POINT KIT (ROD OPERATED) | WHITE    | EACH |
|                                                                                     | 1332274 | TRISER SLIDING DOOR MULTI POINT KIT (ROD OPERATED) | MONUMENT | EACH |
|                                                                                     | 1332275 | TRISER SLIDING DOOR MULTI POINT KIT (ROD OPERATED) | PRIMROSE | EACH |

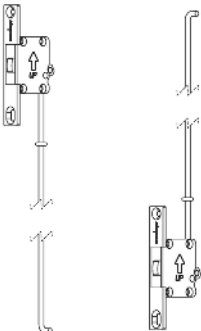
Refer to page 6.11 for cylinders

6. Hardware & Components

SL200 Compliant Lock Hardware - Sliding Door



|  | PART    | DESCRIPTION           | FINISH        | QTY  |
|-----------------------------------------------------------------------------------|---------|-----------------------|---------------|------|
|                                                                                   | 1308157 | HETA SLIDING SEC LOCK | BLACK         | EACH |
|                                                                                   | 1308158 | HETA SLIDING SEC LOCK | WHITE         | EACH |
|                                                                                   | 1308159 | HETA SLIDING SEC LOCK | PRIMROSE      | EACH |
|                                                                                   | 1308186 | HETA SLIDING SEC LOCK | MONUMENT      | EACH |
|                                                                                   | 1332404 | HETA SLIDING SEC LOCK | WOODLAND GREY | EACH |
|                                                                                   | 1332405 | HETA SLIDING SEC LOCK | PAPERBARK     | EACH |
|                                                                                   | 1332406 | HETA SLIDING SEC LOCK | SURFMIST      | EACH |
|                                                                                   | 1332407 | HETA SLIDING SEC LOCK | WHITE BIRCH   | EACH |

|  |                                                  |         |       |       |        |      |
|-------------------------------------------------------------------------------------|--------------------------------------------------|---------|-------|-------|--------|------|
| PART                                                                                | DESCRIPTION                                      | SETTING | A     | B     | FINISH | QTY  |
| 1395005                                                                             | HETA SLIDING DOOR MULTI POINT KIT (ROD OPERATED) | HIGH    | 546mm | 961mm | BLACK  | EACH |
|                                                                                     |                                                  | LOW     | 961mm | 546mm |        |      |

Refer to page 6.11 for cylinders

6. Hardware & Components

SL100 Compliant Lock Hardware



| 8654 HINGED SEC DOOR LOCK |             |
|---------------------------|-------------|
| PART                      | 1304455     |
| FINISH                    | BLACK (034) |
| QTY                       | EACH        |



| W807016 MK3 TASMAN ESCAPE LOCK |             |             |
|--------------------------------|-------------|-------------|
| PART                           | 1304476     | 1304477     |
| FINISH                         | WHITE (010) | BLACK (034) |
| QTY                            | EACH        |             |



| 8653 SLIDING SEC DOOR LOCK |                    |
|----------------------------|--------------------|
| PART                       | FINISH             |
| 1304480                    | PEARL WHITE (1NT)  |
| 1304481                    | SILVER PAINT (031) |
| QTY                        | EACH               |



| 8654 STD 3 POINT KIT |                          |
|----------------------|--------------------------|
| PART                 | 1304456                  |
| FINISH               | SATIN S/LESS STEEL (0A6) |
| QTY                  | EACH                     |



| 8654 PROJECTION BOLT 3 POINT KIT |                          |
|----------------------------------|--------------------------|
| PART                             | 1304454                  |
| FINISH                           | SATIN S/LESS STEEL (0A6) |
| QTY                              | EACH                     |



| W807317 MK3 ESCAPE 3 PT LOCK KIT |             |
|----------------------------------|-------------|
| PART                             | 1304478     |
| FINISH                           | BLACK (034) |
| QTY                              | KIT         |



| 8653 STD 3 POINT KIT |                          |
|----------------------|--------------------------|
| PART                 | 1304310                  |
| FINISH               | SATIN S/LESS STEEL (0A6) |
| QTY                  | EACH                     |



| ELEGANCE PUSH2GO HINGED SEC DOOR LOCK BLACK |             |
|---------------------------------------------|-------------|
| PART                                        | 1308101     |
| FINISH                                      | BLACK (034) |
| QTY                                         | EACH        |



| SP8653-64 DEEP JAMB STRIKE |                     |
|----------------------------|---------------------|
| PART                       | 1304312             |
| FINISH                     | NOT SPECIFIED (099) |
| QTY                        | EACH                |

Other rod lengths available, contact your Local Alspeg Representative for more information  
Refer to page 6.11 for cylinders

## 6. Hardware & Components

### Lock Hardware - Cylinders

| 62mm EURO CYLINDER                                                                | PART    | ITEM DESCRIPTION                                            |
|-----------------------------------------------------------------------------------|---------|-------------------------------------------------------------|
|  | 1360240 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KA PACK x10 |
|                                                                                   | 1360241 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A01     |
|                                                                                   | 1360242 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A02     |
|                                                                                   | 1360243 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A03     |
|                                                                                   | 1360244 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A04     |
|                                                                                   | 1360245 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A05     |
|                                                                                   | 1360246 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A06     |
|                                                                                   | 1360247 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A07     |
|                                                                                   | 1360248 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A08     |
|                                                                                   | 1360249 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A09     |
|                                                                                   | 1360250 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BC KEY A10     |

| 62mm EURO CYLINDER BLACK                                                           | PART    | ITEM DESCRIPTION                                             |
|------------------------------------------------------------------------------------|---------|--------------------------------------------------------------|
|  | 1360329 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KA PACK x10 |
|                                                                                    | 1360330 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A01     |
|                                                                                    | 1360331 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A02     |
|                                                                                    | 1360332 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A03     |
|                                                                                    | 1360333 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A04     |
|                                                                                    | 1360334 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A05     |
|                                                                                    | 1360335 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A06     |
|                                                                                    | 1360336 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A07     |
|                                                                                    | 1360337 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A08     |
|                                                                                    | 1360338 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A09     |
|                                                                                    | 1360339 | ALSPEC 62MM LAZY CAM CYLINDER 2 x 5 PIN EURO BLK KEY A10     |

\* Black Cylinder in Key No. A05 - A10 is not available until January 2024



\* For Asim Hinged Hook Bolt  
Security Locks

#### AUSTRAL CYL 2 x 5 PIN KA x 10 PROFILE AA8C4/KA10

|        |                     |
|--------|---------------------|
| PART   | 1308751             |
| FINISH | NOT SPECIFIED (099) |
| QTY    | EACH                |

## 6. Hardware & Components

### Fasteners

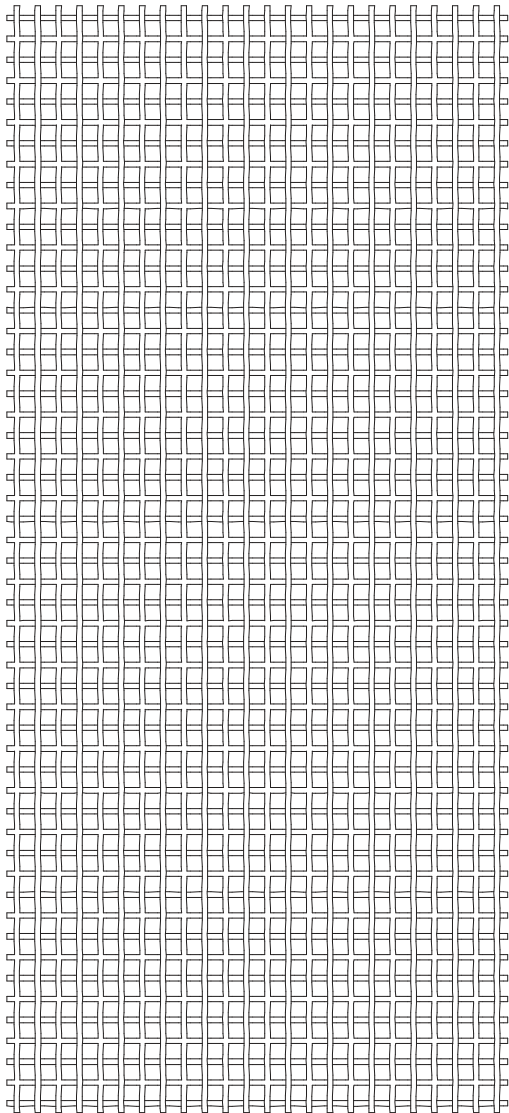
| SCREWS  |                                                        |                    |
|---------|--------------------------------------------------------|--------------------|
| PART #  | DESCRIPTION                                            | LOCATION           |
| 1382026 | 10g x 1/2 (13mm) SS PHILLIPS U/CUT SELF TAPPING x 1000 | DOOR CORNER STAKE  |
| 1382054 | 10g x 1 (25mm) SS PHIL PAN S/TAP SCREW x 500           | INVISI-SCAPE FRAME |

| ANTI-TAMPER SCREWS AND SCREW KEYS |                                                  |
|-----------------------------------|--------------------------------------------------|
| PART #                            | DESCRIPTION                                      |
| 1311551                           | SECURITY TAMPER PROOF SCREW 25mm GALV x 1        |
| 1311553                           | SECURITY TAMPER PROOF SCREW 25mm BRIGHT ZINC x 1 |
| 1311552                           | SECURITY TAMPER PROOF SCREW 40mm GALV x 1        |
| 1311554                           | SECURITY TAMPER PROOF SCREW 40mm BRIGHT ZINC x 1 |
| 1383160                           | TRI-LOBULAR SECURITY TAMPER PROOF SCREW KEY 25mm |
| 1383161                           | SECURITY TAMPER PROOF SCREW KEY 100mm            |

| RIVETS  |                                          |                                     | DRILL BIT |                                   |
|---------|------------------------------------------|-------------------------------------|-----------|-----------------------------------|
| PART #  | DESCRIPTION                              | LOCATION                            | PART #    | DESCRIPTION                       |
| 1380167 | AS5-4 STAINLESS STEEL RIVETS x 1000 MILL | DOOR CORNER STAKE, HINGES TO SCREEN | 1391263   | DRILL PANEL SHORTIE #20 x 10      |
|         |                                          |                                     | 1391269   | DRILL PANEL DOUBLE ENDED #20 x 10 |
| 1380161 | AS4-3 STAINLESS STEEL RIVETS x 1000 MILL | WINDOW CORNER STAKE                 | 1391261   | DRILL PANEL SHORTIE #30 x 10      |
|         |                                          |                                     | 1391267   | DRILL PANEL DOUBLE ENDED #30 x 10 |
| 1380163 | AS4-2 STAINLESS STEEL RIVETS x 1000 MILL | INVISI-SCAPE FRAME & SASHES         | 1391261   | DRILL PANEL SHORTIE #30 x 10      |
|         |                                          |                                     | 1391267   | DRILL PANEL DOUBLE ENDED #30 x 10 |

6. Hardware & Components

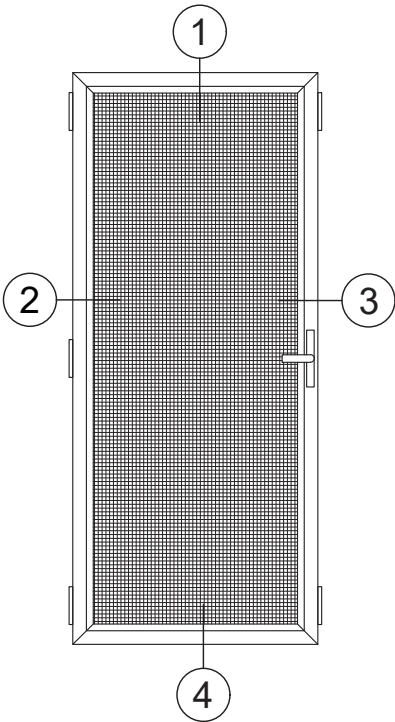
Mesh Sizes



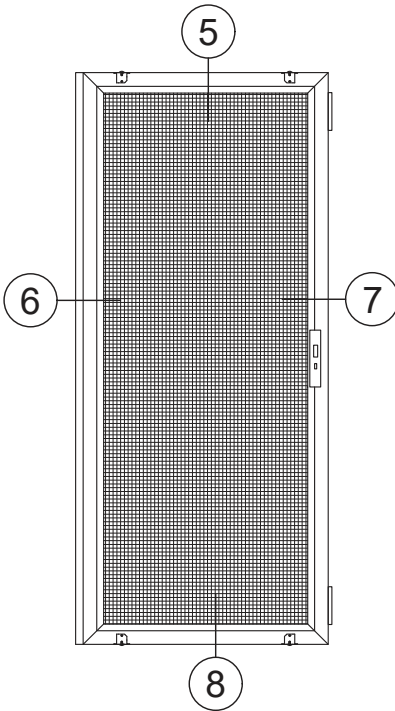
| 316 STAINLESS STEEL MESH (0.8mm)<br>SATIN BLACK |           |          |
|-------------------------------------------------|-----------|----------|
| SIZE                                            | PACK QTY. | PART NO. |
| 750 x 2000                                      | 5         | 1409200  |
|                                                 | 50        | 1409201  |
| 750 x 2400                                      | 5         | 1409220  |
|                                                 | 50        | 1409221  |
| 750 x 3000                                      | 5         | 1409240  |
|                                                 | 50        | 1409241  |
| 900 x 2000                                      | 5         | 1409205  |
|                                                 | 50        | 1409206  |
| 900 x 2400                                      | 5         | 1409225  |
|                                                 | 50        | 1409226  |
| 900 x 3000                                      | 3         | 1409245  |
| 1200 x 2000                                     | 5         | 1409210  |
|                                                 | 50        | 1409211  |
| 1200 x 2400                                     | 3         | 1409230  |
|                                                 | 50        | 1409231  |
| 1200 x 3000                                     | 3         | 1409250  |
| 1500 x 2000                                     | 2         | 1409260  |
| 1500 x 2400                                     | 2         | 1409262  |
| 1500 x 3000                                     | 2         | 1409264  |



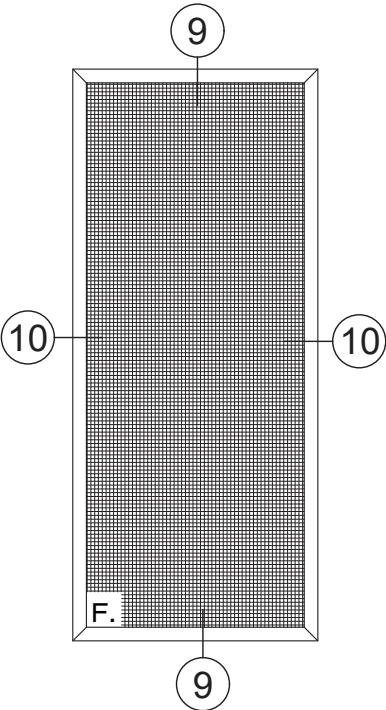
HINGED DOOR SCREEN



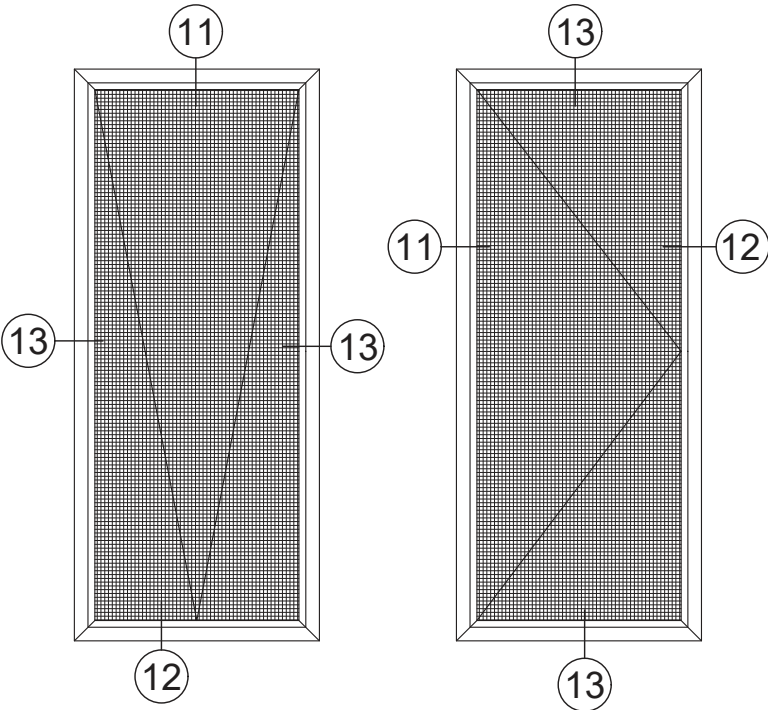
SLIDING DOOR SCREEN



WINDOW SCREEN

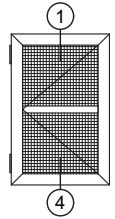


INVISI-SCAPE SCREENS





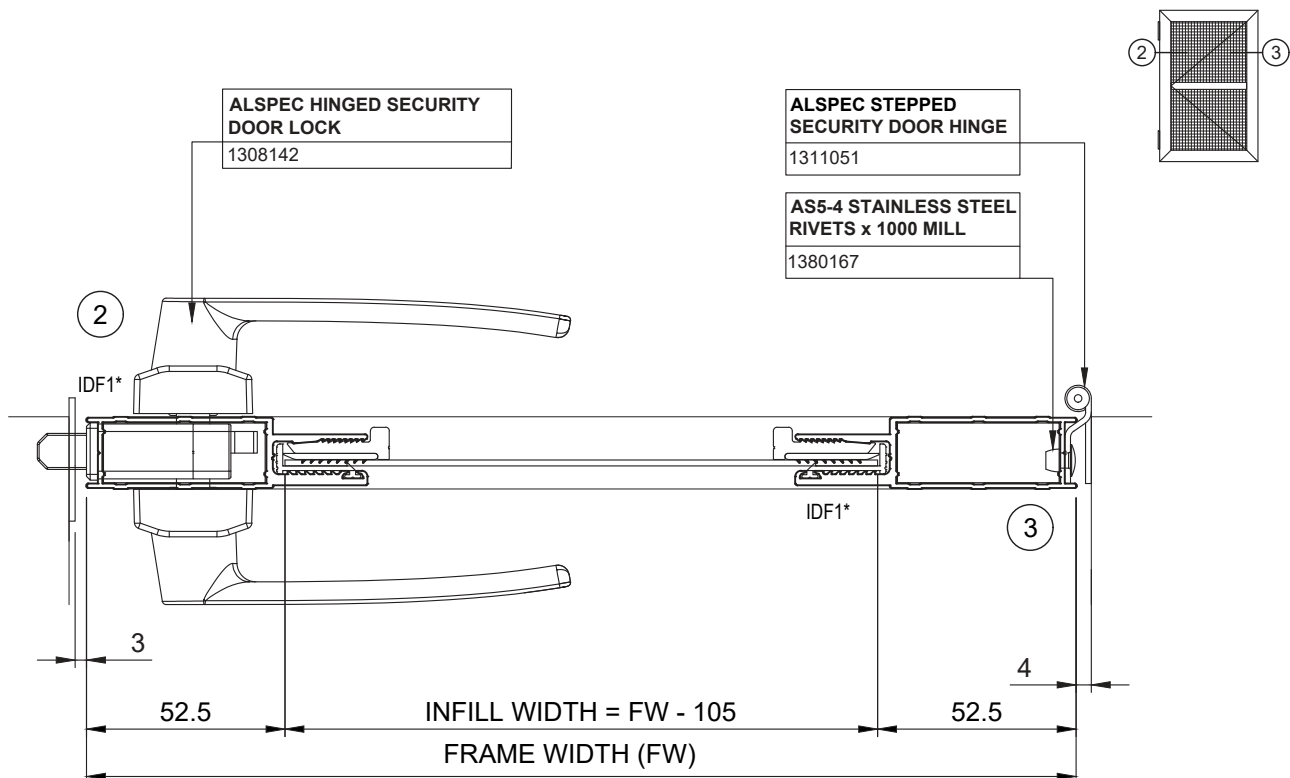
### Hinged Door - Side Detail



**alspec®**  
EVERYTHING ALUMINIUM & HARDWARE

## 8. Typical Details

### Hinged Door - Top Detail

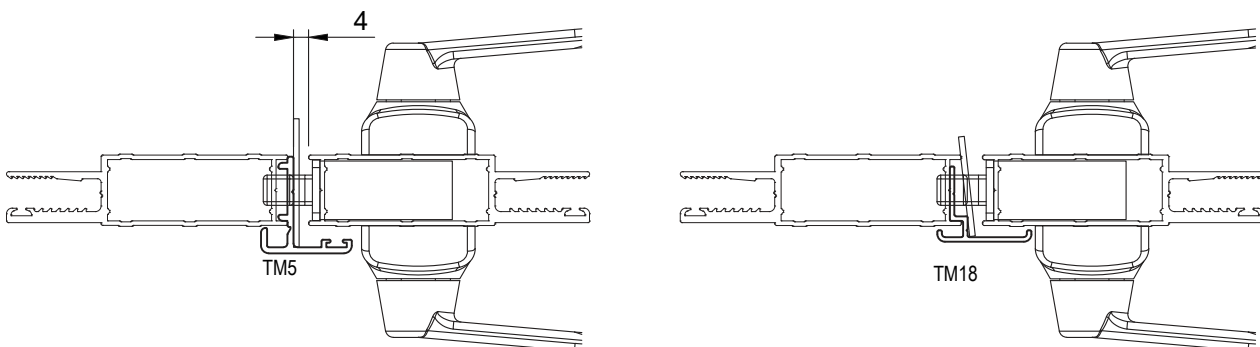


\*\* MAX DISTANCE BETWEEN THE DOOR AND THE FRAME AT THE LOCKING POINTS SHALL NOT BE GREATER THAN 3mm.

\*\*\* MAX DISTANCE BETWEEN THE DOOR AND THE FRAME AT THE HINGING POINTS SHALL NOT BE GREATER THAN 4mm.

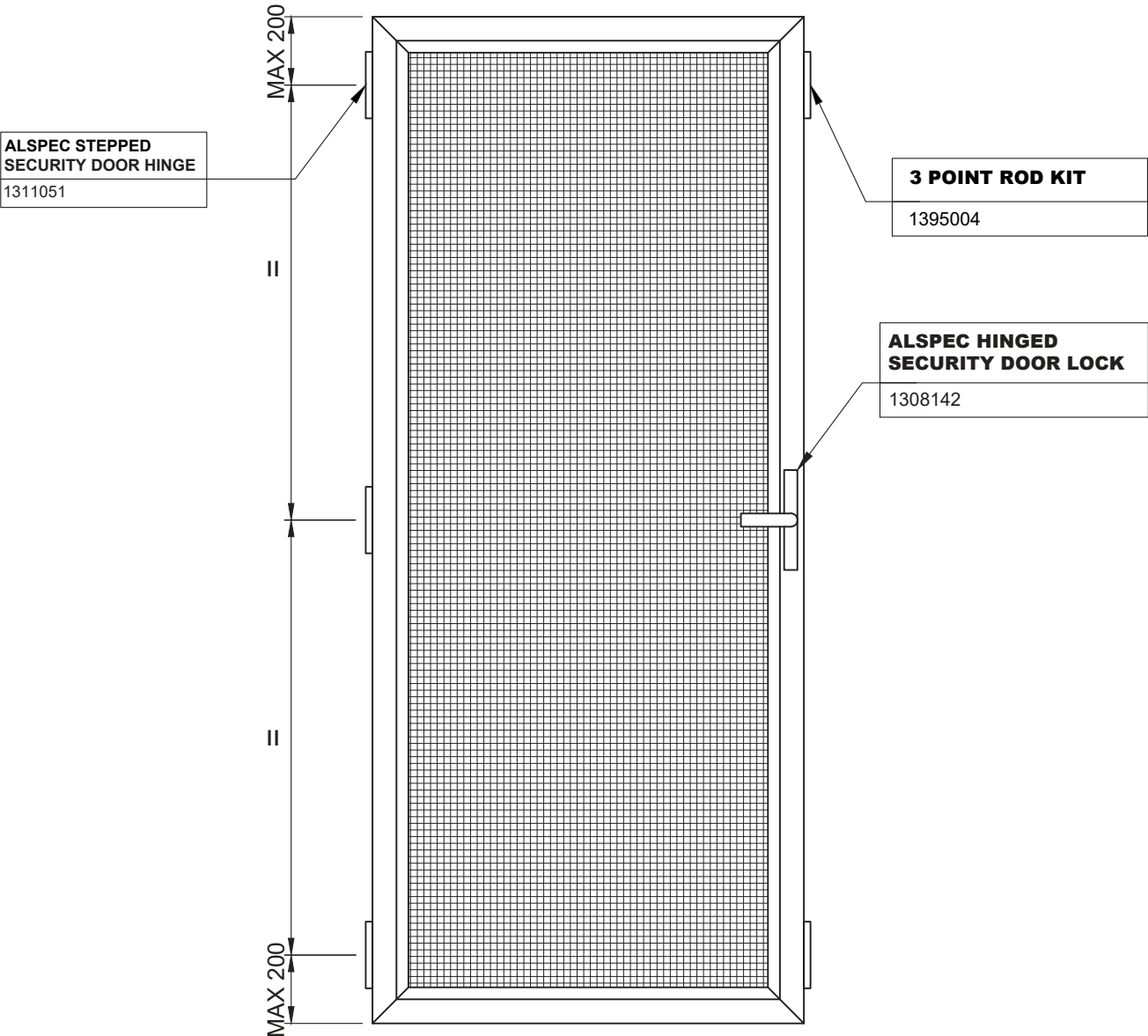
ALL OTHER POINTS, THE DISTANCE SHALL NOT BE GREATER THAN 5mm. SILL CLEARANCE ONLY MAY EXCEED 5mm TO COMPENSATE FOR IRREGULARITIES IN THE FLOOR OR DOORSTEP

### FRENCH/DOUBLE DOOR ADAPTORS



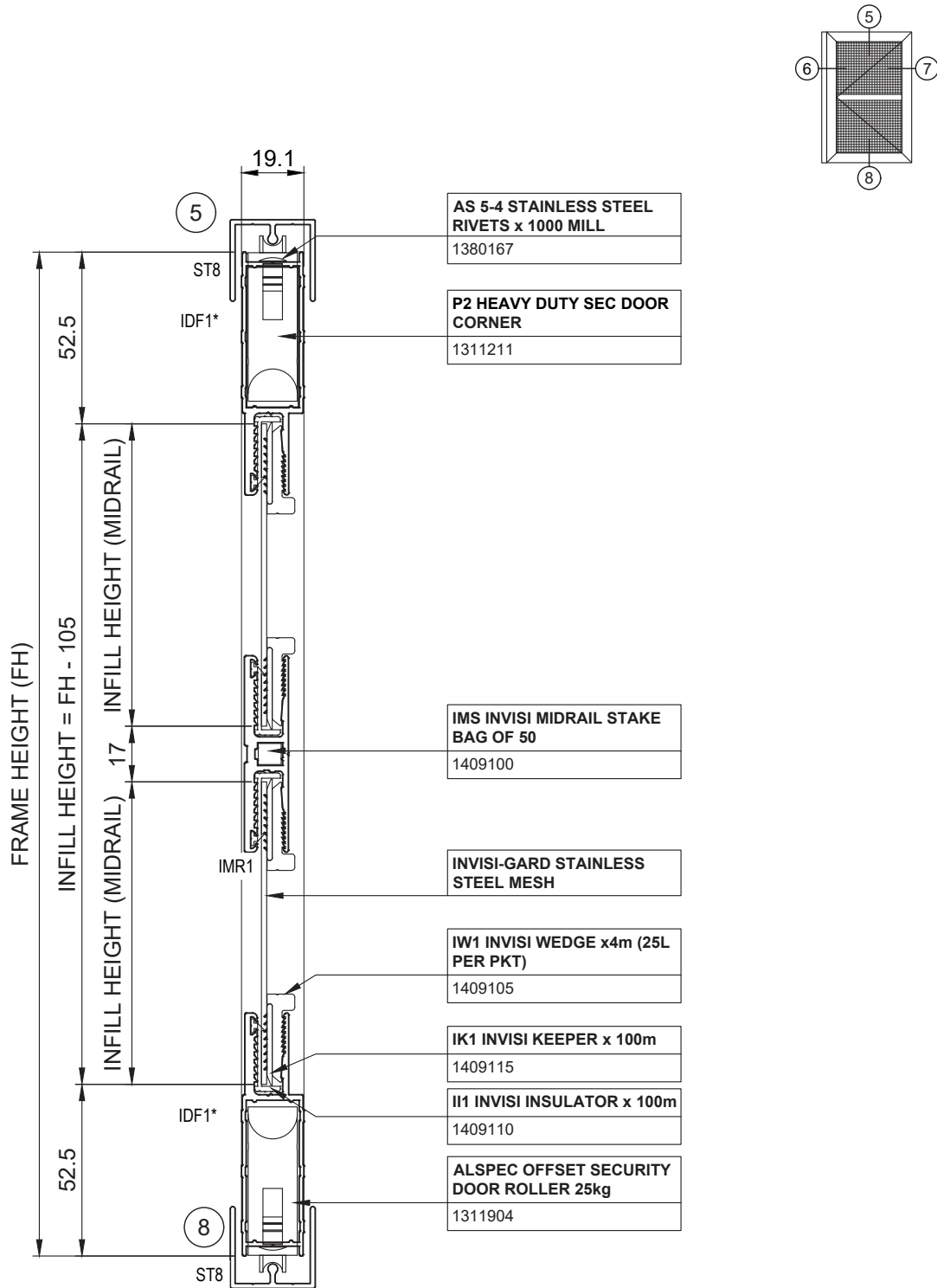
8. Typical Details

Hinged Door - Hardware Layout & Locking Points



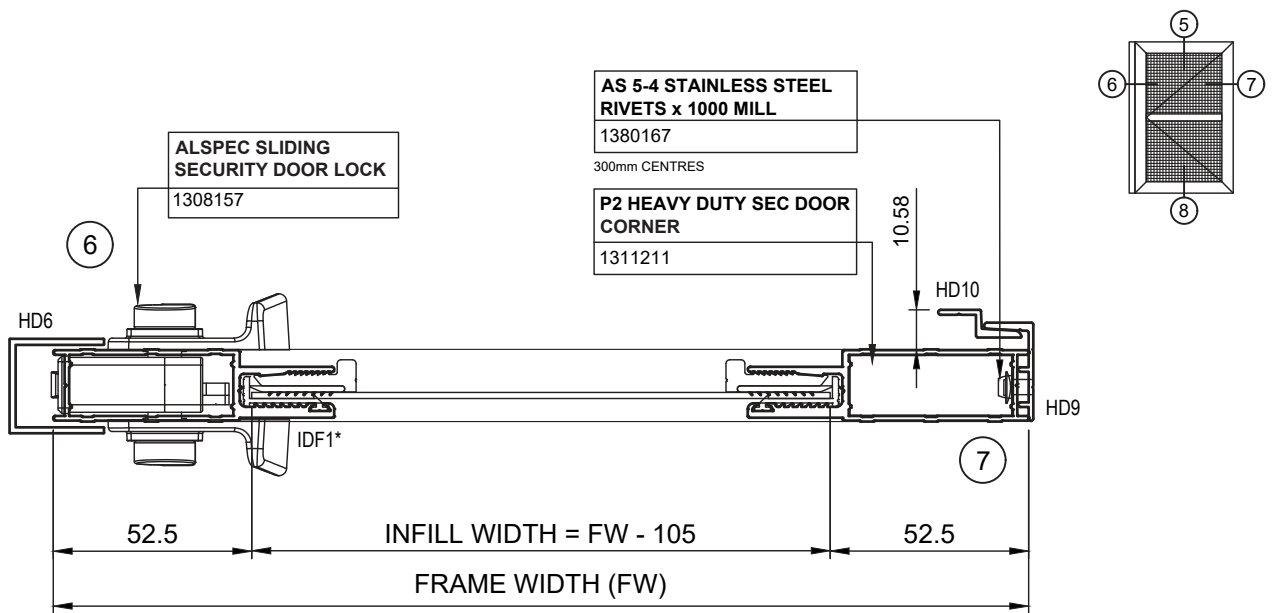
8. Typical Details

Sliding Door - Top Detail



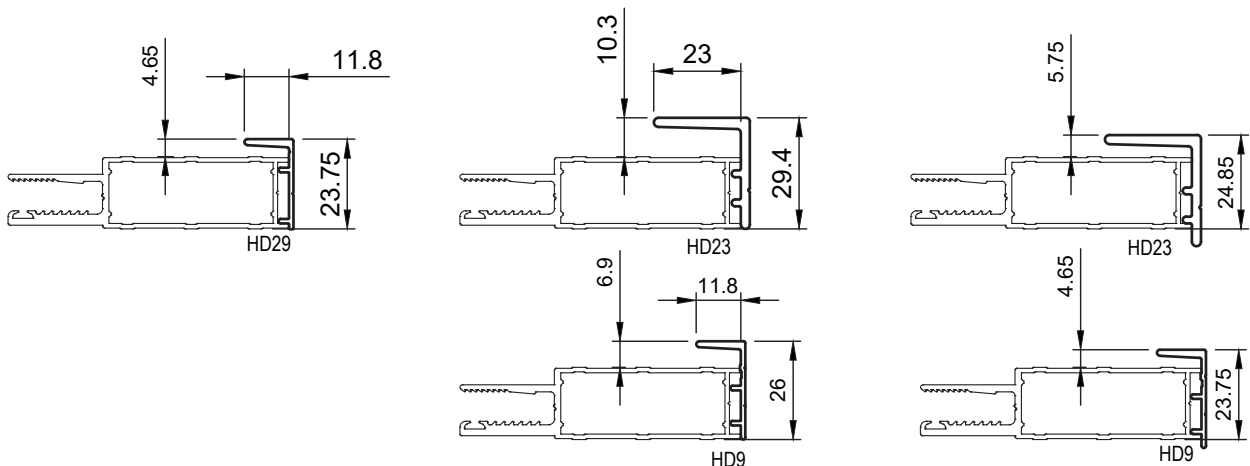
## 8. Typical Details

### Sliding Door - Side Detail

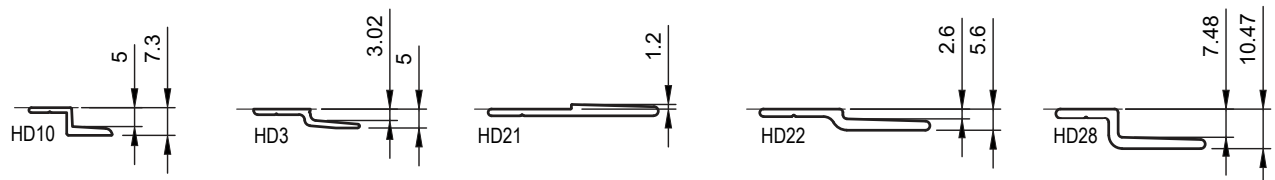


\* OTHER FRAME SECTIONS ALSO AVAILABLE, REFER TO INVISI-GARD WALL CHART OR CONTACT YOUR LOCAL ALSPEC DEALER FOR MORE INFORMATION

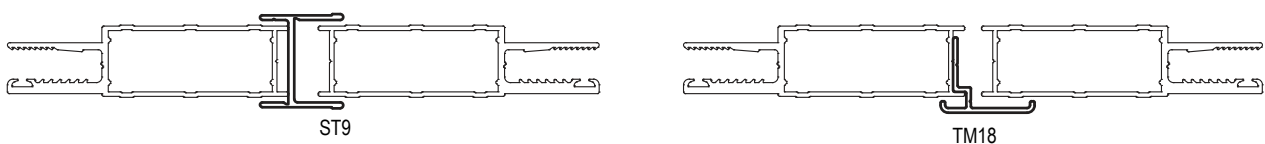
### FRAME INTERLOCK OPTIONS



### RETURN INTERLOCK OPTIONS

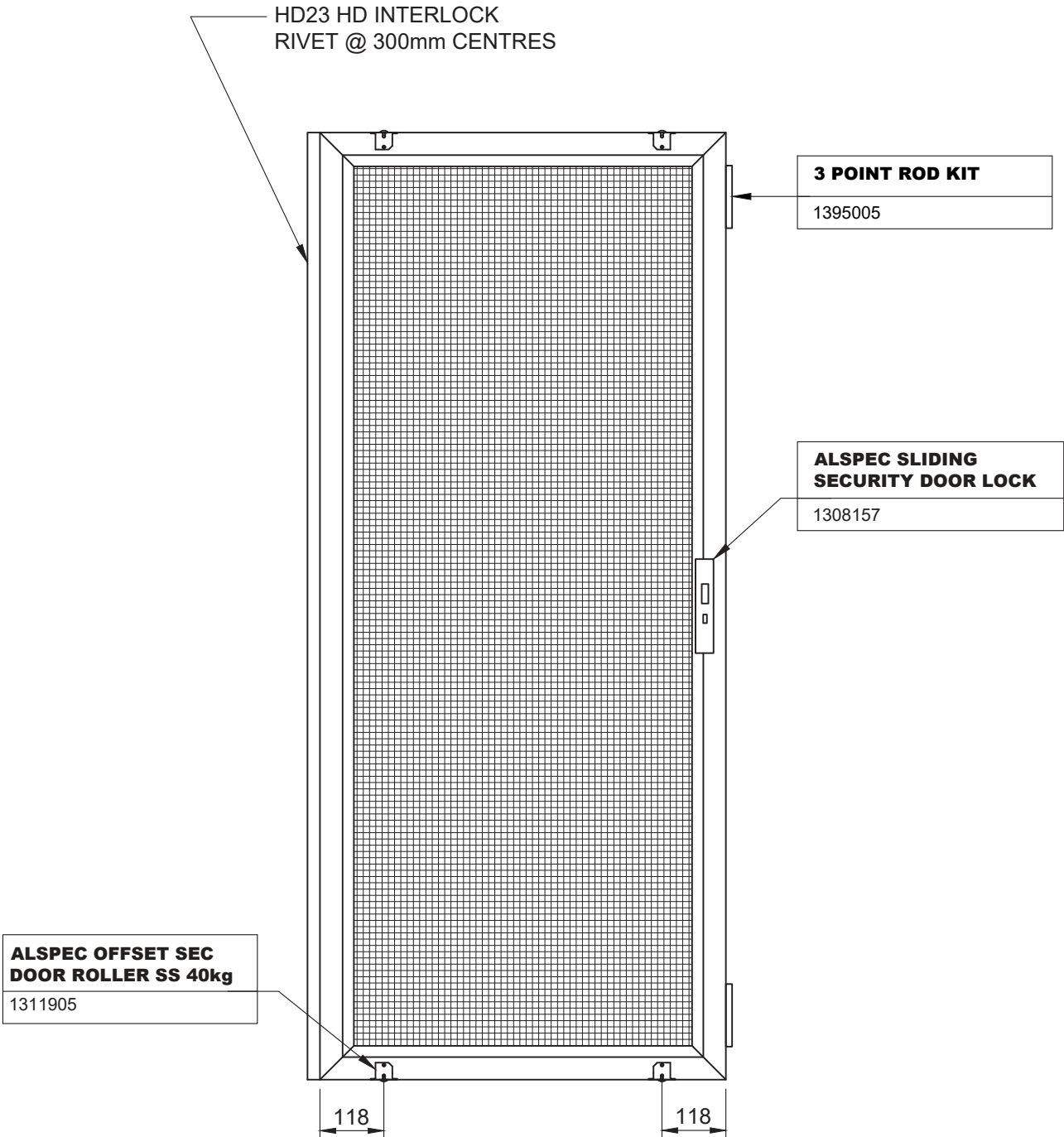


### MEETING ADAPTORS



## 8. Typical Details

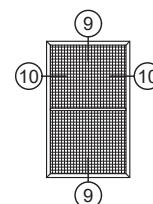
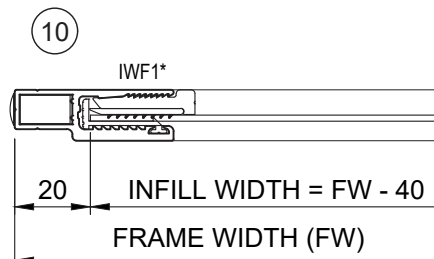
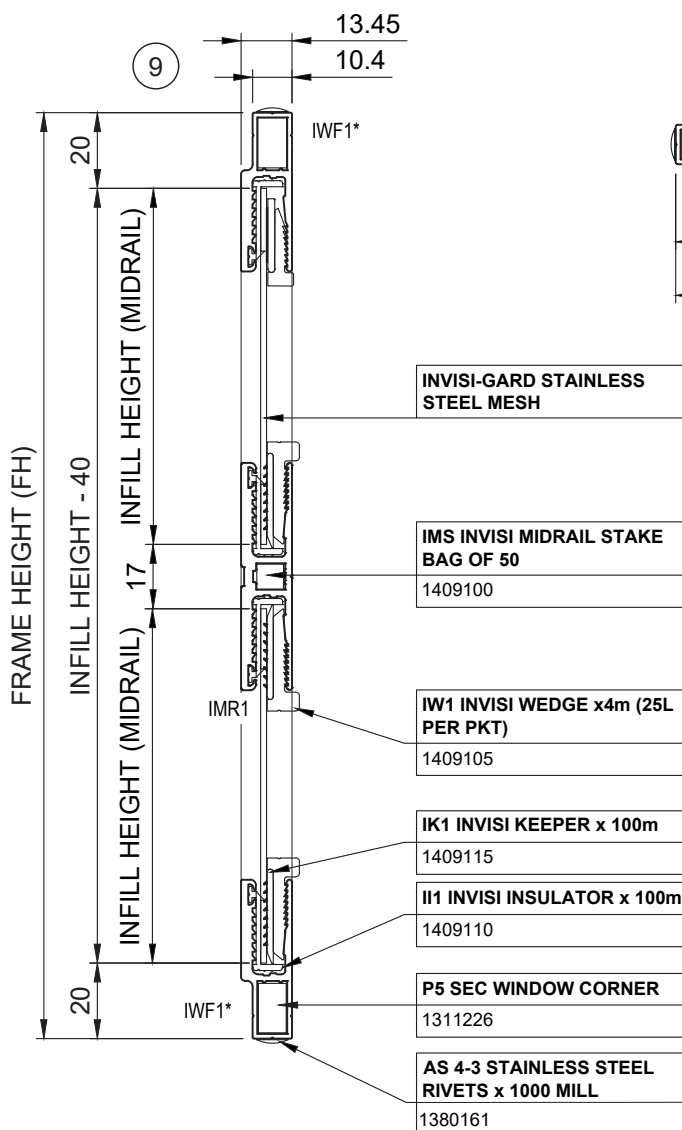
### Sliding Door - Hardware Layout & Locking Points



## 8. Typical Details

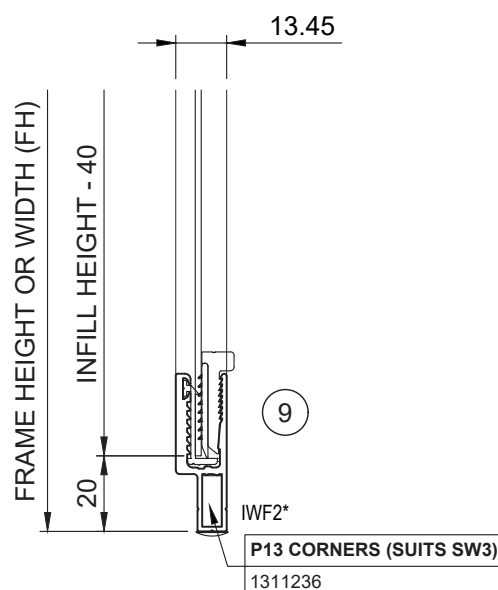
### Window Screen

#### IWF1 11mm FRAME

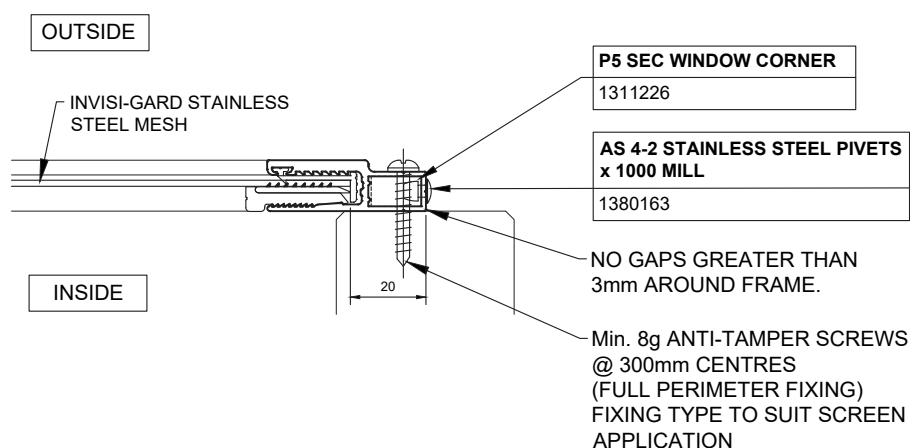


\* OTHER FRAME SECTIONS ALSO AVAILABLE, REFER TO INVISI-GARD WALL CHART OR CONTACT YOUR LOCAL ALSPEC DEALER FOR MORE INFORMATION

#### IWF2 9mm FRAME



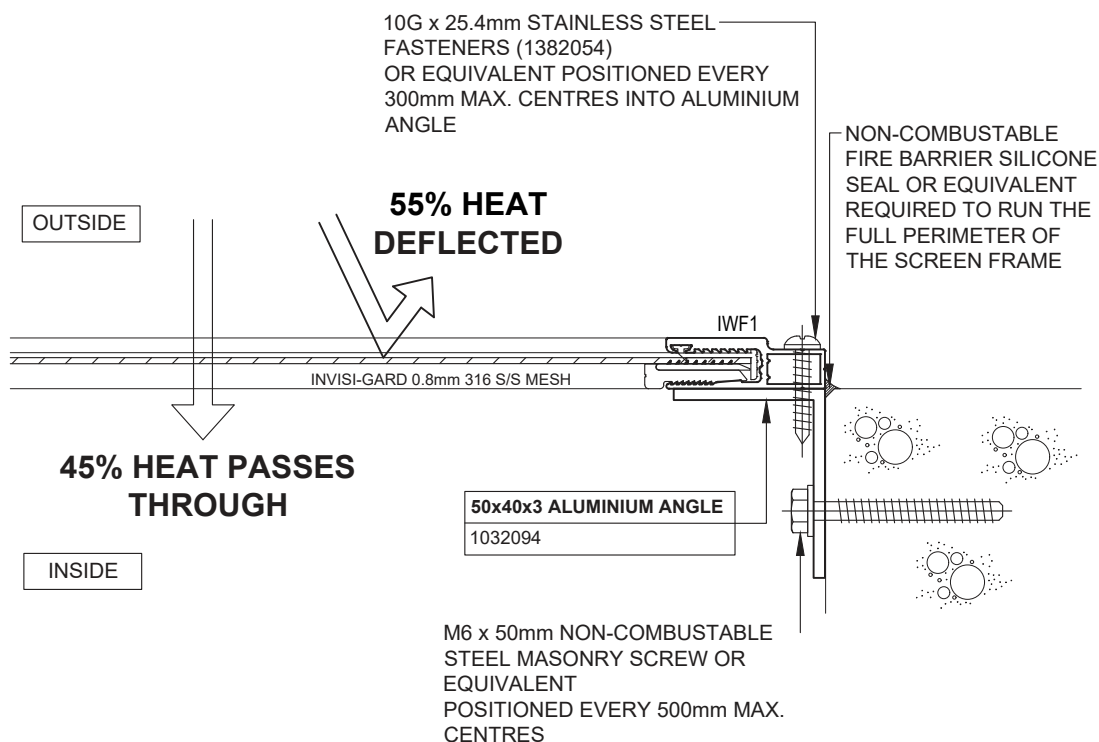
### TYPICAL SCREEN WINDOW INSTALLATION



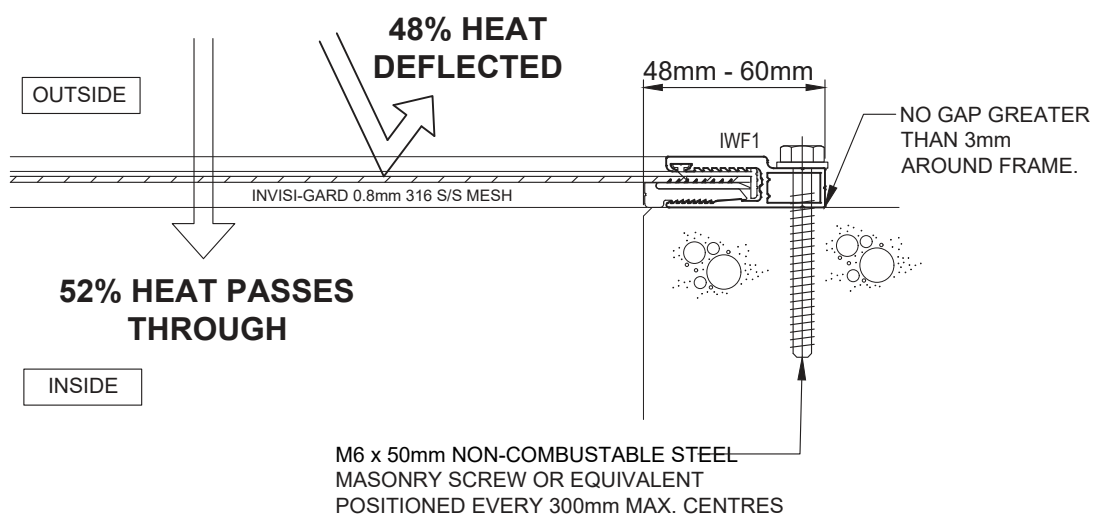
## 8. Typical Details

### Typical Fixed Fire Attenuation Screen Installation

TEST REPORT: 52577300a



TEST REPORT: 52577300b

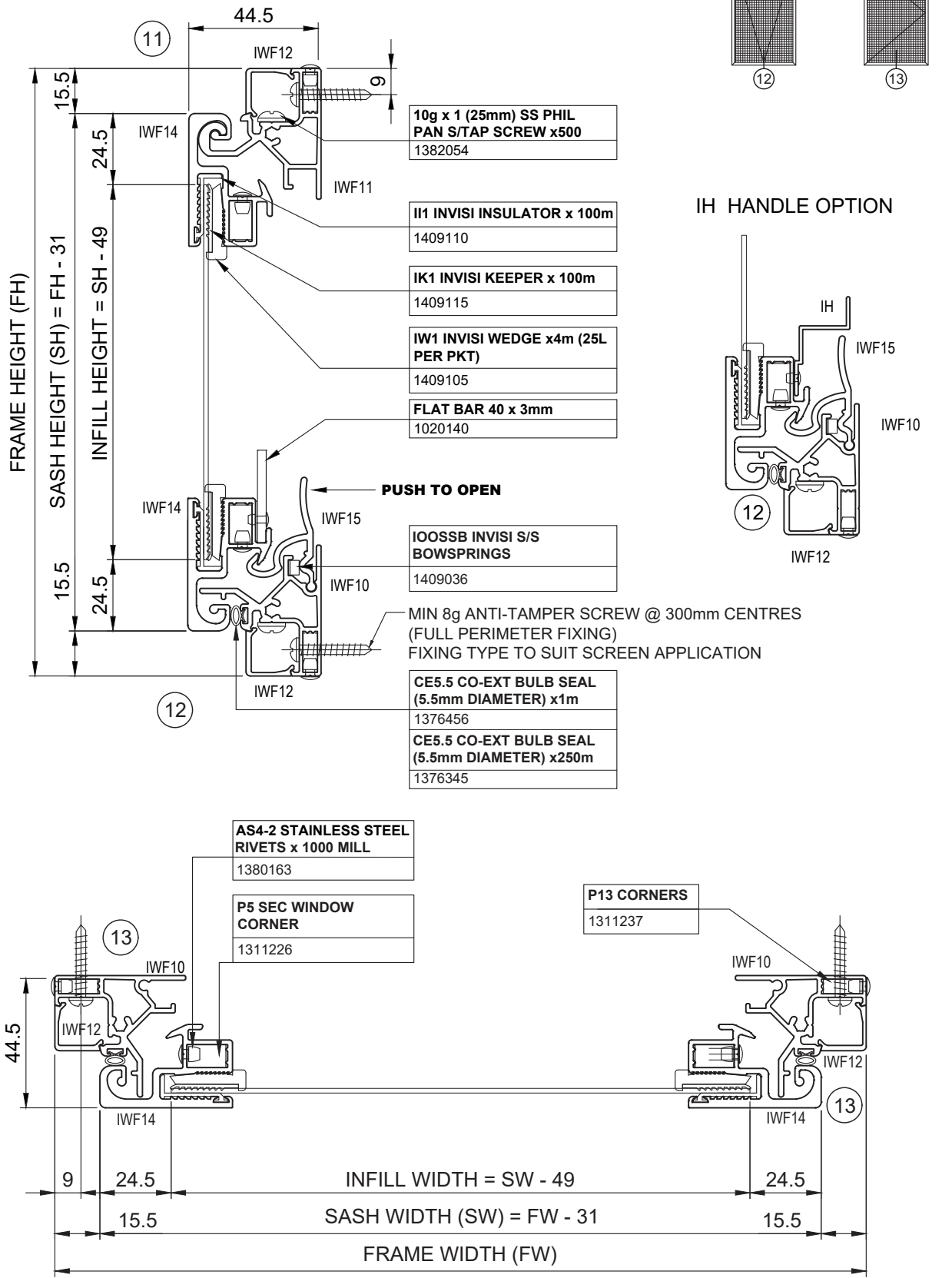




8. Typical Details

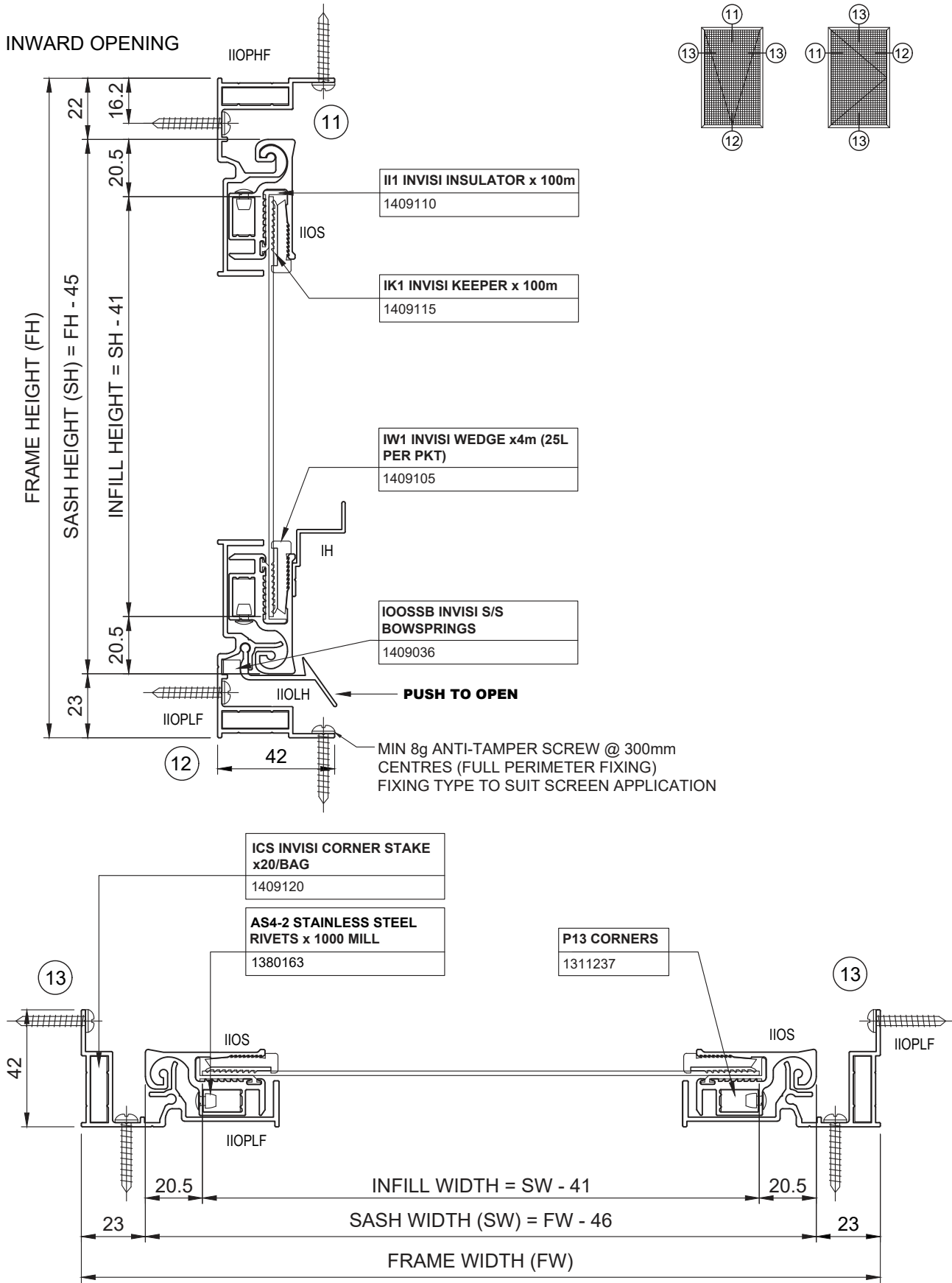
Escape Screen - Open Out

OUTWARD OPENING



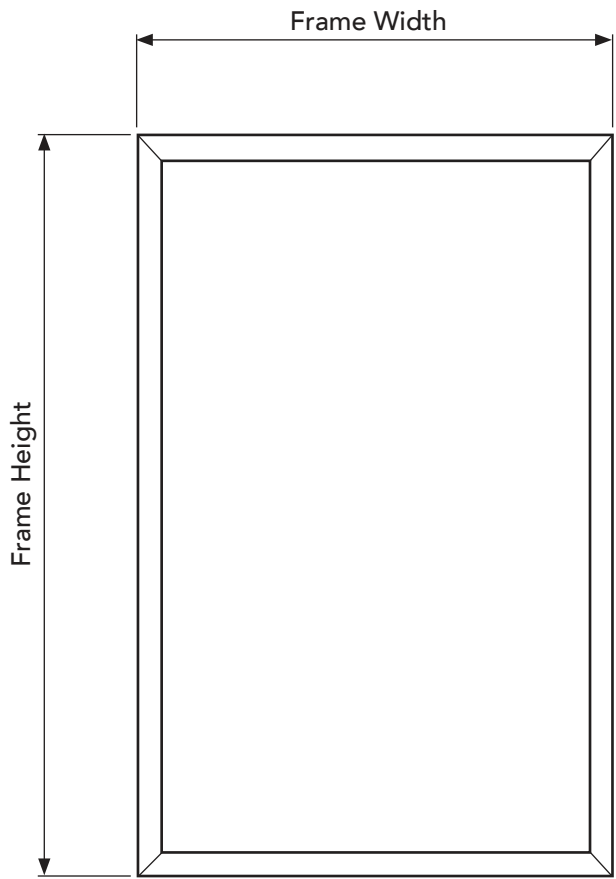
8. Typical Details

Escape Screen - Open In



9. Cutting Formulas

Hinged / Sliding Door



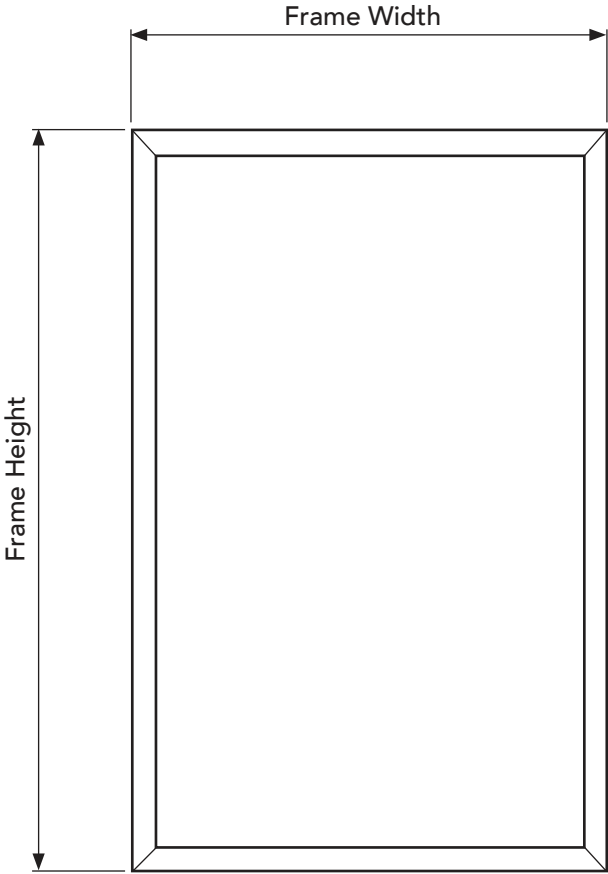
\* Mitre cut

| PROFILE                                                                               | SECTION NO. | DESCRIPTION | CUTTING FORMULA      | QTY |
|---------------------------------------------------------------------------------------|-------------|-------------|----------------------|-----|
| *  | IDF1        | Door Frame  | Frame Height         | 2   |
| *  | IDF1        | Door Frame  | Frame Width          | 2   |
| MESH                                                                                  | HEIGHT      |             | Frame Height - 105mm | 1   |
|                                                                                       | WIDTH       |             | Frame Width - 105mm  |     |

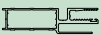
Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Hinged / Sliding Door - ICPDF



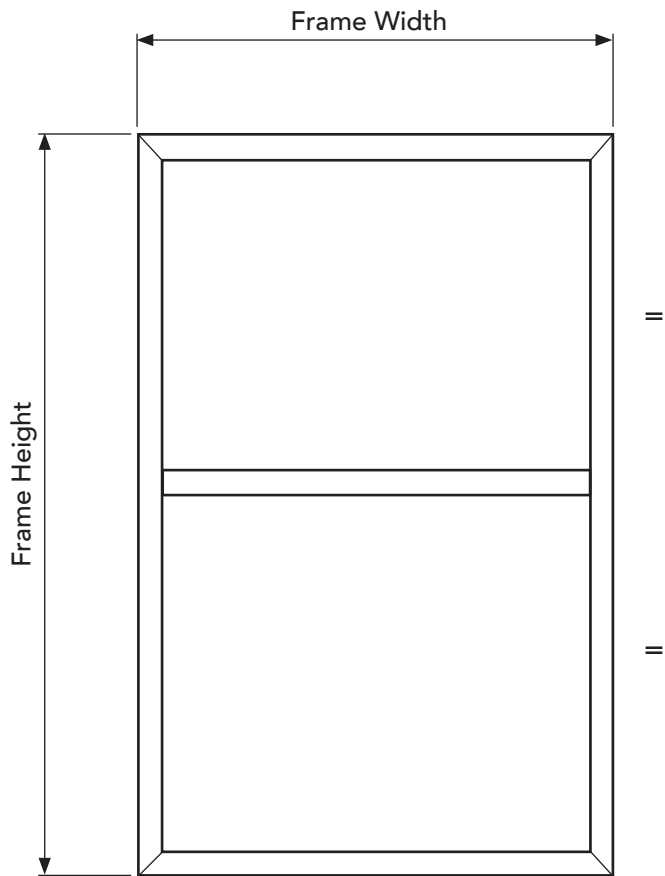
\* Mitre cut

|   | PROFILE                                                                             | SECTION NO. | DESCRIPTION | CUTTING FORMULA      | QTY |
|---|-------------------------------------------------------------------------------------|-------------|-------------|----------------------|-----|
| * |  | ICPDF       | Door Frame  | Frame Height         | 2   |
| * |  | ICPDF       | Door Frame  | Frame Width          | 2   |
|   | MESH                                                                                | HEIGHT      |             | Frame Height - 125mm | 1   |
|   |                                                                                     | WIDTH       |             | Frame Width - 125mm  |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Hinged / Sliding Door - Horizontal Mid Rail



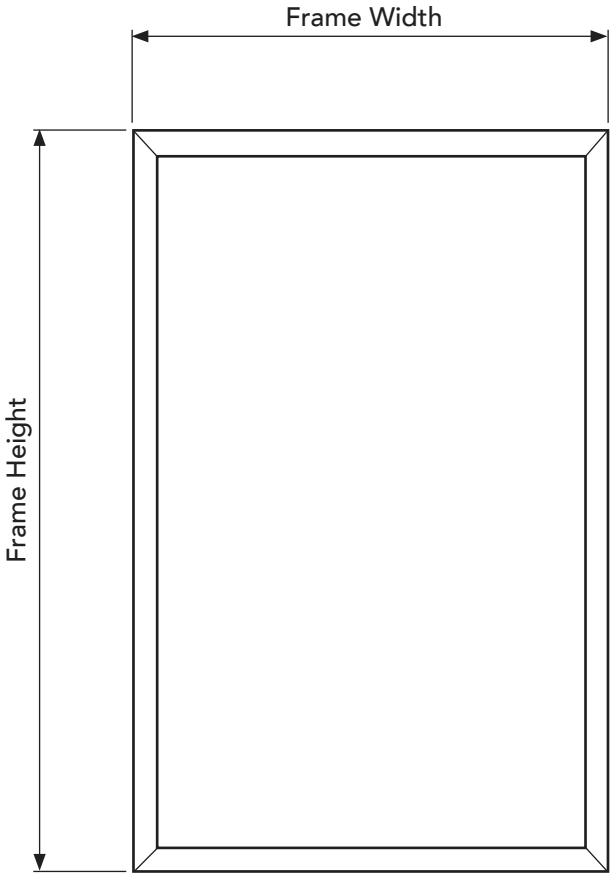
\* Mitre cut

|   | PROFILE                                                                             | SECTION NO.     | DESCRIPTION         | CUTTING FORMULA       | QTY |
|---|-------------------------------------------------------------------------------------|-----------------|---------------------|-----------------------|-----|
| * |  | IDF1            | Door Frame          | Frame Height          | 2   |
| * |  | IDF1            | Door Frame          | Frame Width           | 2   |
|   |  | IMR1            | Integrated Mid Rail | Frame Width - 149     | 1   |
|   | MESH                                                                                | HEIGHT / 2 - 61 |                     | Frame Height / 2 - 61 | 2   |
|   |                                                                                     | WIDTH           |                     | Frame Width - 105mm   |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes. Mesh formula is for central mid rail only. Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Fixed Screen



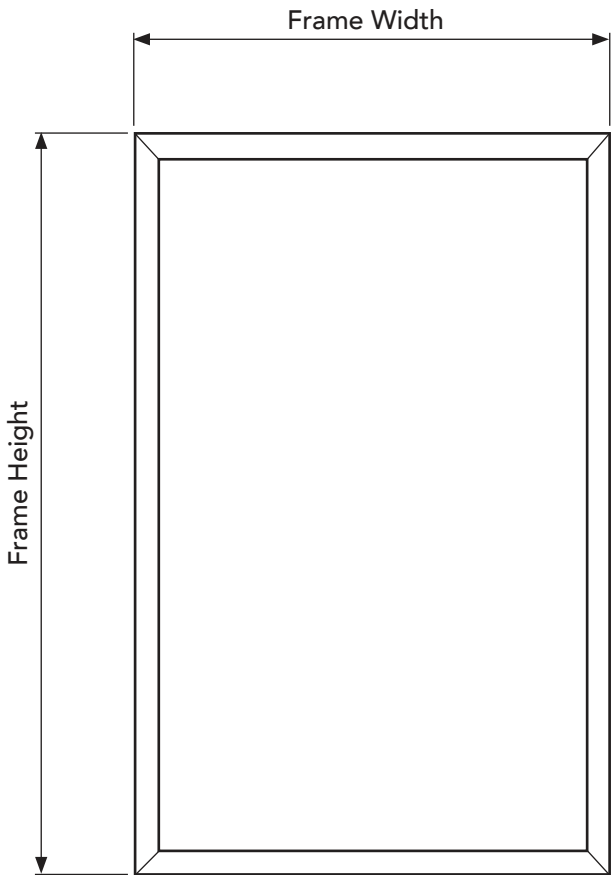
\* Mitre cut

|   | PROFILE                                                                             | SECTION NO. | DESCRIPTION  | CUTTING FORMULA     | QTY |
|---|-------------------------------------------------------------------------------------|-------------|--------------|---------------------|-----|
| * |  | IWF1        | Window Frame | Frame Height        | 2   |
| * |  | IWF1        | Window Frame | Frame Width         | 2   |
|   | MESH                                                                                | HEIGHT      |              | Frame Height - 40mm | 1   |
|   |                                                                                     | WIDTH       |              | Frame Width - 40mm  |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Fixed Screen - IWF1E and IWF2E



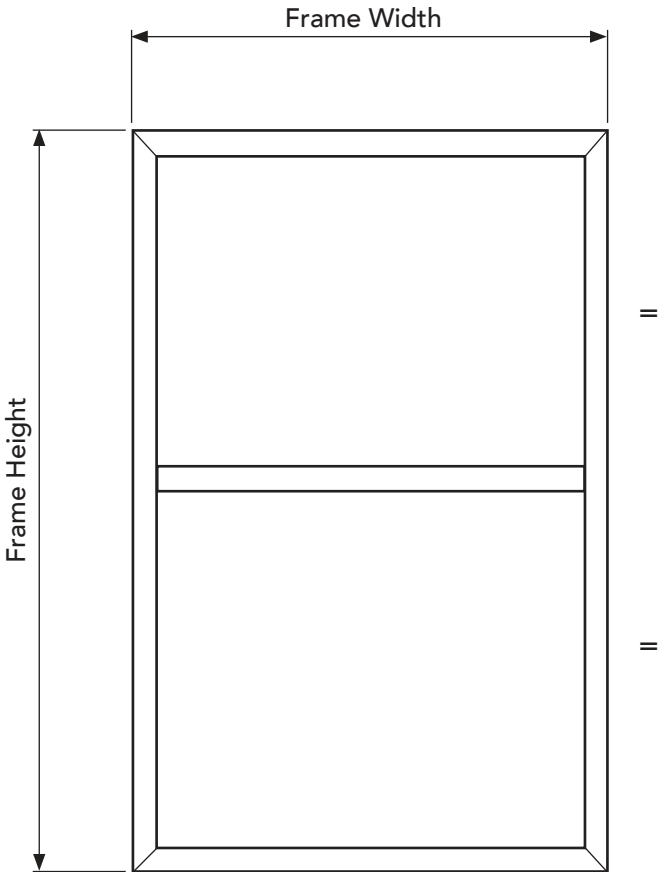
\* Mitre cut

|   | PROFILE                                                                             | SECTION NO.    | DESCRIPTION  | CUTTING FORMULA     | QTY |
|---|-------------------------------------------------------------------------------------|----------------|--------------|---------------------|-----|
| * |  | IWF1E or IWF2E | Window Frame | Frame Height        | 2   |
| * |  | IWF1E or IWF2E | Window Frame | Frame Width         | 2   |
|   | MESH                                                                                | HEIGHT         |              | Frame Height - 50mm | 1   |
|   |                                                                                     | WIDTH          |              | Frame Width - 50mm  |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Fixed Screen - Horizontal Mid Rail



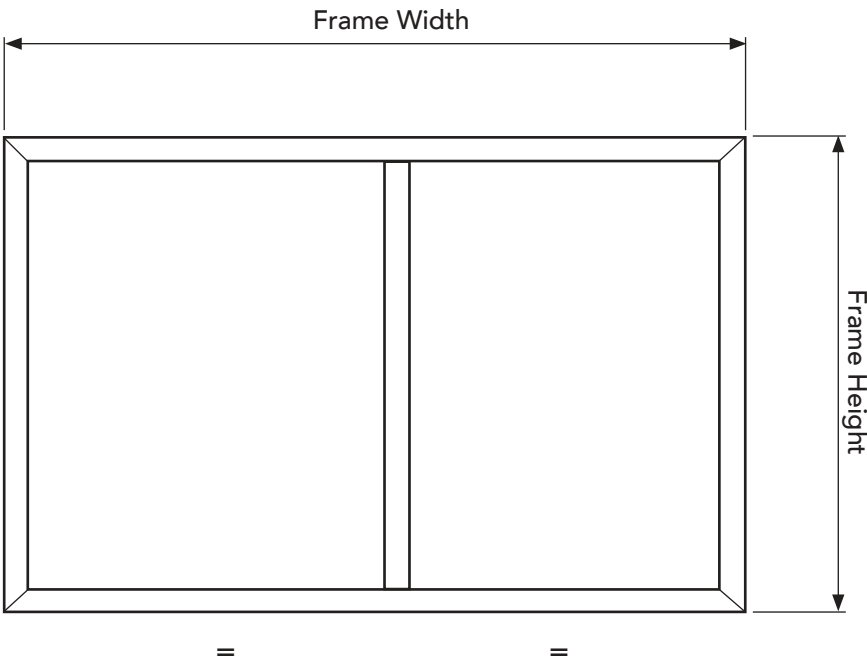
\* Mitre cut

|   | PROFILE                                                                             | SECTION NO. | DESCRIPTION          | CUTTING FORMULA       | QTY |
|---|-------------------------------------------------------------------------------------|-------------|----------------------|-----------------------|-----|
| * |  | IWF1        | Window Frame         | Frame Height          | 2   |
| * |  | IWF1        | Window Frame         | Frame Width           | 2   |
|   |  | IMR1        | Intergrated Mid Rail | Frame Width - 84      | 1   |
|   | MESH                                                                                | HEIGHT      |                      | Frame Height / 2 - 28 | 2   |
|   |                                                                                     | WIDTH       |                      | Frame Width - 40mm    |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes. Mesh formula is for central mid rail only. Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Fixed Screen - Vertical Mid Rail



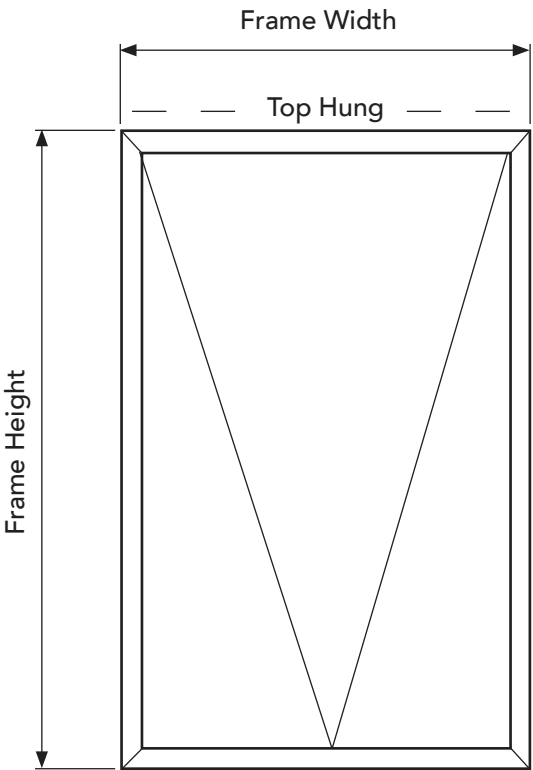
\* Mitre cut

|      | PROFILE                                                                             | SECTION NO. | DESCRIPTION          | CUTTING FORMULA        | QTY |
|------|-------------------------------------------------------------------------------------|-------------|----------------------|------------------------|-----|
| *    |  | IWF1        | Window Frame         | Frame Height           | 2   |
| *    |  | IWF1        | Window Frame         | Frame Width            | 2   |
|      |  | IMR1        | Intergrated Mid Rail | Frame Width - 84       | 1   |
| MESH | HEIGHT                                                                              |             |                      | Frame Height - 40mm    | 2   |
|      | WIDTH                                                                               |             |                      | Frame Width / 2 - 28mm |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes. Mesh formula is for central mid rail only. Do not cut undersize. Mesh must be cut square.

## 9. Cutting Formulas

### Invisi-Scape Outward Opening Screen - Top Hung



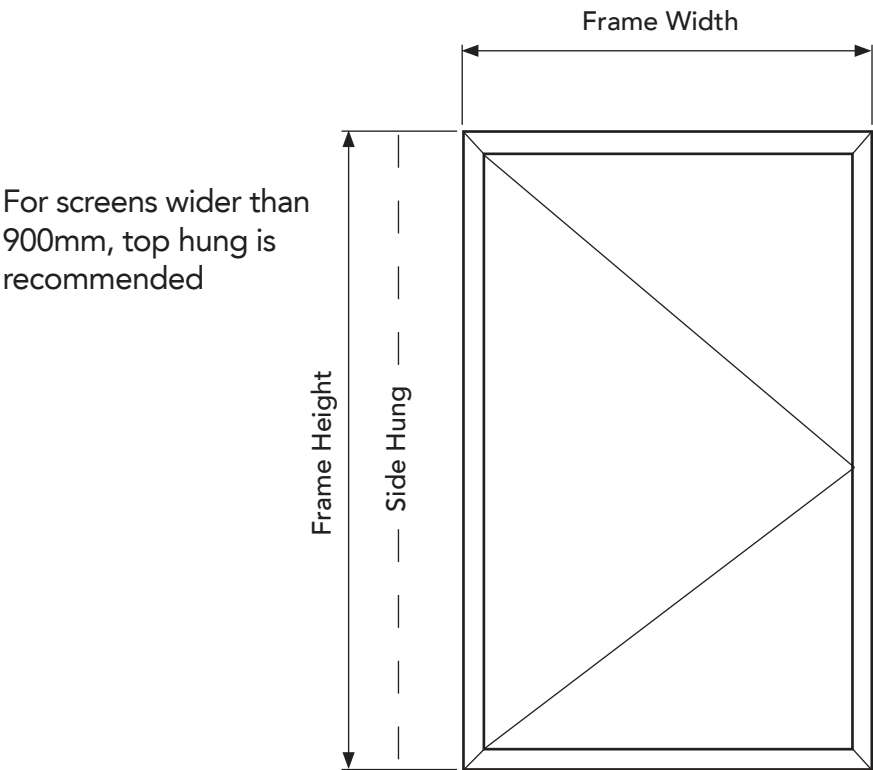
\* Mitre cut

| PROFILE                                                                               | SECTION NO. | DESCRIPTION     | CUTTING FORMULA   | QTY |
|---------------------------------------------------------------------------------------|-------------|-----------------|-------------------|-----|
| *  | IWF10       | Perimeter Frame | Frame Height      | 2   |
| *  | IWF10       | Perimeter Frame | Frame Width       | 1   |
| *  | IWF11       | Hinge Frame     | Frame Width       | 1   |
| *  | IWF12       | Frame Infill    | Frame Width       | 2   |
| *  | IWF12       | Frame Infill    | Frame Height      | 2   |
| *  | IWF15       | Lock Handle     | Frame Width - 86  | 1   |
| *  | IWF14       | Sash Frame      | Frame Height - 31 | 2   |
| *  | IWF14       | Sash Frame      | Frame Width - 31  | 2   |
|    | 40 x 3 FLAT | Sash Handle     | Frame Width - 96  | 1   |
| MESH                                                                                  | HEIGHT      |                 | Frame Height - 80 | 1   |
|                                                                                       | WIDTH       |                 | Frame Width - 80  |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square.

9. Cutting Formulas

Invisi-Scape Outward Opening Screen - Side Hung



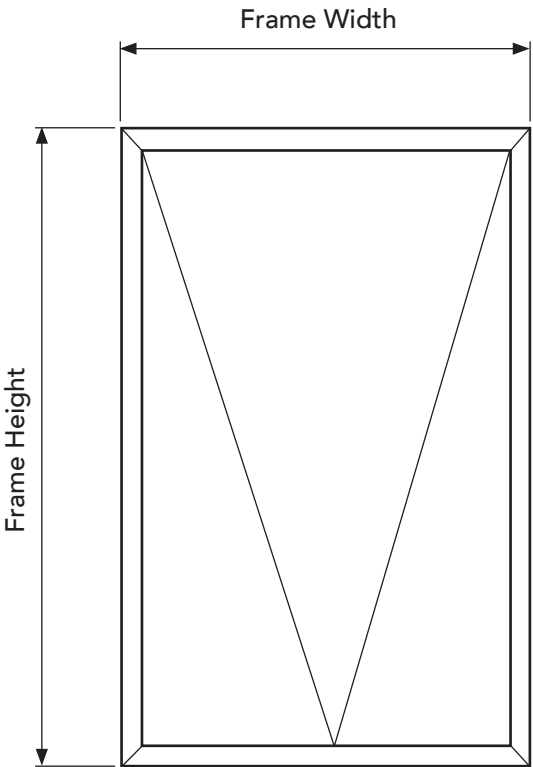
\* Mitre cut

|   | PROFILE                                                                             | SECTION NO. | DESCRIPTION     | CUTTING FORMULA   | QTY |
|---|-------------------------------------------------------------------------------------|-------------|-----------------|-------------------|-----|
| * |  | IWF10       | Perimeter Frame | Frame Height      | 1   |
| * |  | IWF10       | Perimeter Frame | Frame Width       | 2   |
| * |  | IWF11       | Hinge Frame     | Frame Height      | 1   |
| * |  | IWF12       | Frame Infill    | Frame Width       | 2   |
| * |  | IWF12       | Frame Infill    | Frame Height      | 2   |
|   |  | IWF15       | Lock Handle     | Frame Height - 86 | 1   |
| * |  | IWF14       | Sash Frame      | Frame Height - 31 | 2   |
| * |  | IWF14       | Sash Frame      | Frame Width - 31  | 2   |
|   |  | 40 x 3 FLAT | Sash Handle     | Frame Height - 96 | 1   |
|   | MESH                                                                                | HEIGHT      |                 | Frame Height - 80 | 1   |
|   |                                                                                     | WIDTH       |                 | Frame Width - 80  |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square.

## 9. Cutting Formulas

### Invisi-Scape Inward Opening Screen - Top Hung



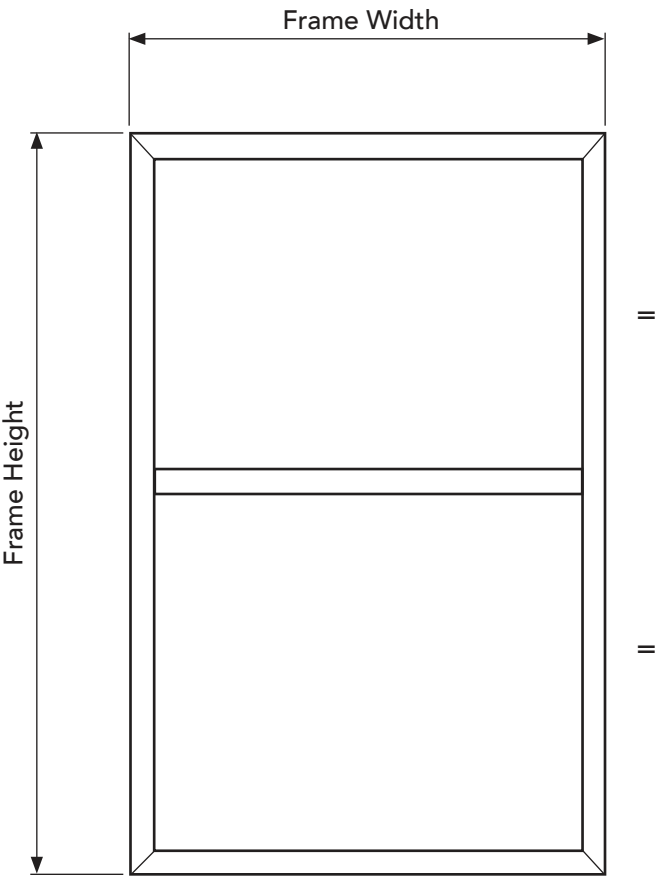
\* Mitre cut

|      | PROFILE                                                                             | SECTION NO. | DESCRIPTION     | CUTTING FORMULA   | QTY |
|------|-------------------------------------------------------------------------------------|-------------|-----------------|-------------------|-----|
| *    |  | IIOPLF      | Perimeter Frame | Frame Height      | 2   |
| *    |  | IIOPLF      | Perimeter Frame | Frame Width       | 1   |
| *    |  | IIOPHF      | Hinge Frame     | Frame Width       | 1   |
|      |  | IIOLH       | Lock Handle     | Frame Height - 66 | 1   |
| *    |  | IIOS        | Sash Frame      | Frame Height - 45 | 2   |
| *    |  | IIOS        | Sash Frame      | Frame Width - 46  | 2   |
|      |  | IH          | Sash Handle     | Frame Height - 66 | 1   |
| MESH | HEIGHT                                                                              |             |                 | Frame Height - 87 | 1   |
|      | WIDTH                                                                               |             |                 | Frame Width - 87  |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square. Formulas are for vertical hinge screens.

9. Cutting Formulas

Invisi-Scape Inward Opening Screen - Horizontal Mid Rail



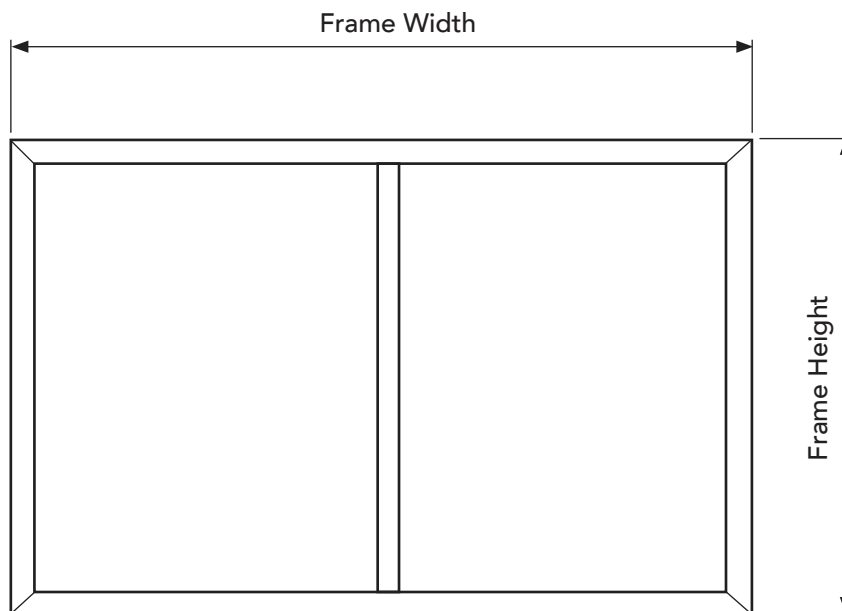
\* Mitre cut

|      | PROFILE                                                                             | SECTION NO. | DESCRIPTION     | CUTTING FORMULA        | QTY |
|------|-------------------------------------------------------------------------------------|-------------|-----------------|------------------------|-----|
| *    |  | IIOPLF      | Perimeter Frame | Frame Height           | 1   |
| *    |  | IIOPLF      | Perimeter Frame | Frame Width            | 2   |
| *    |  | IIOPHF      | Hinge Frame     | Frame Height           | 1   |
|      |  | IIOLH       | Lock Handle     | Frame Height - 66      | 1   |
| *    |  | IIOS        | Sash Frame      | Frame Height - 45      | 2   |
| *    |  | IIOS        | Sash Frame      | Frame Width - 46       | 2   |
|      |  | IH          | Sash Handle     | Frame Height - 66      | 1   |
|      |  | IMR1        | Mid Rail        | Frame Width - 132      | 1   |
| MESH | HEIGHT                                                                              |             |                 | Frame Height / 2 - 104 | 2   |
|      | WIDTH                                                                               |             |                 | Frame Width - 87       |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square. Formulas are for vertical hinge screens.

## 9. Cutting Formulas

### Invisi-Scape Inward Opening Screen - Vertical Mid Rail



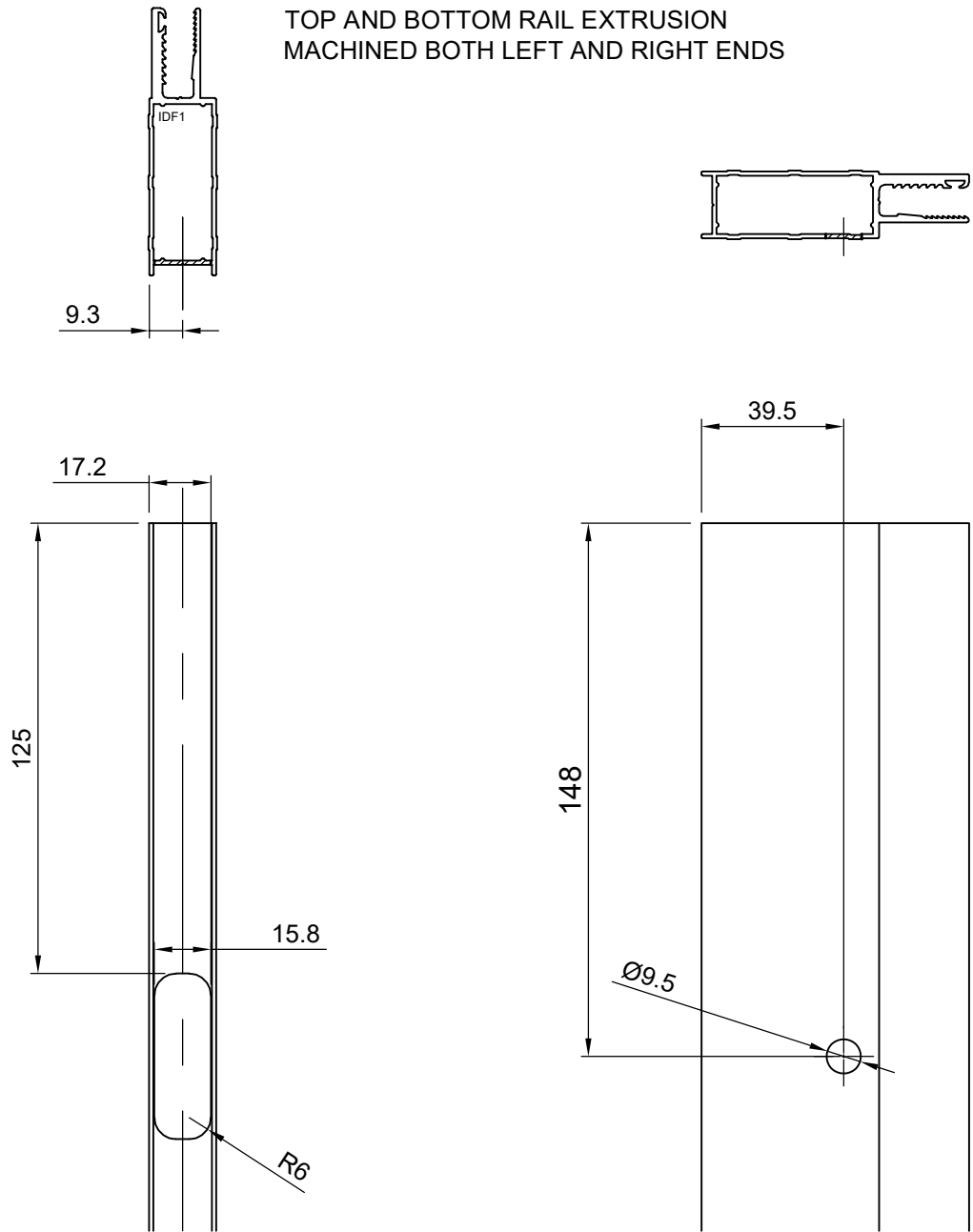
\* Mitre cut

|      | PROFILE                                                                             | SECTION NO. | DESCRIPTION     | CUTTING FORMULA        | QTY |
|------|-------------------------------------------------------------------------------------|-------------|-----------------|------------------------|-----|
| *    |  | IIOPLF      | Perimeter Frame | Frame Height           | 1   |
| *    |  | IIOPLF      | Perimeter Frame | Frame Width            | 2   |
| *    |  | IIOPHF      | Hinge Frame     | Frame Height           | 1   |
|      |  | IIOLH       | Lock Handle     | Frame Height - 66      | 1   |
| *    |  | IIOS        | Sash Frame      | Frame Height - 45      | 2   |
| *    |  | IIOS        | Sash Frame      | Frame Width - 46       | 2   |
|      |  | IH          | Sash Handle     | Frame Height - 66      | 1   |
|      |  | IMR1        | Mid Rail        | Frame Width - 132      | 1   |
| MESH | HEIGHT                                                                              |             |                 | Frame Height / 2 - 104 | 2   |
|      | WIDTH                                                                               |             |                 | Frame Width - 87       |     |

Note: A clearance of 4mm has been allowed for in the mesh cutting sheets sizes.  
Do not cut undersize. Mesh must be cut square. Formulas are for vertical hinge screens.

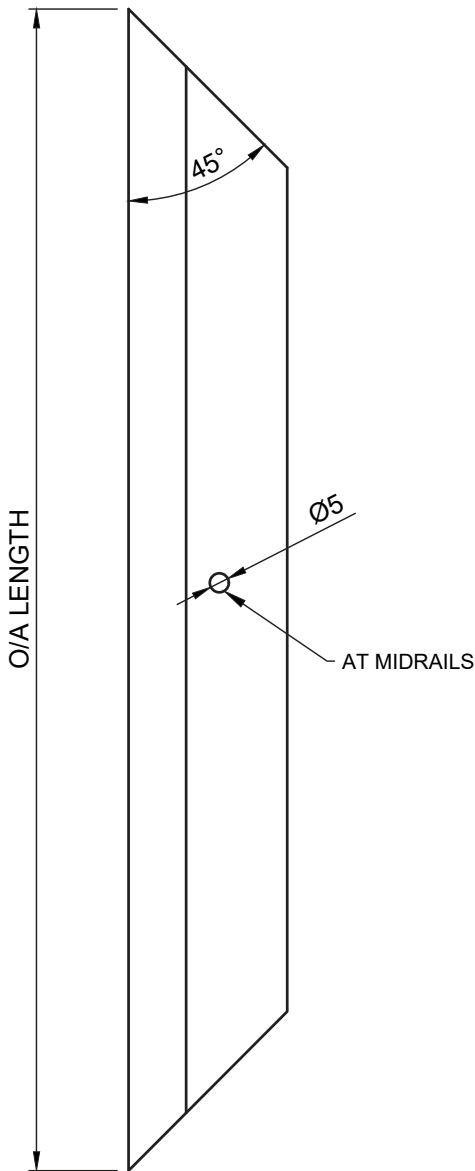
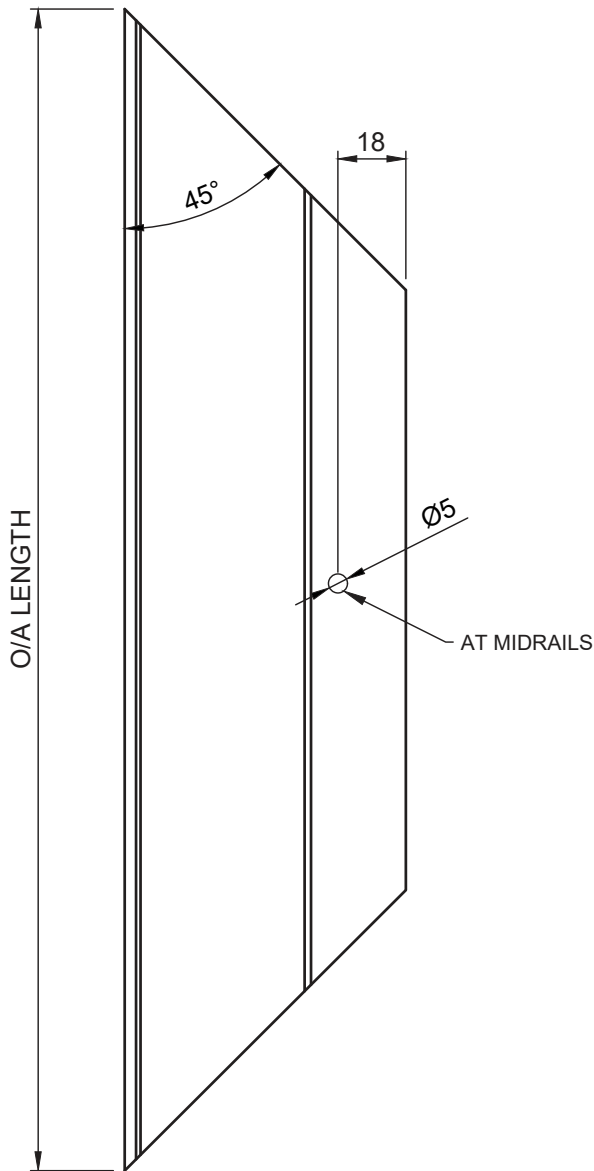
10. Manufacturing Details

Roller Machining Detail



## 10. Manufacturing Details

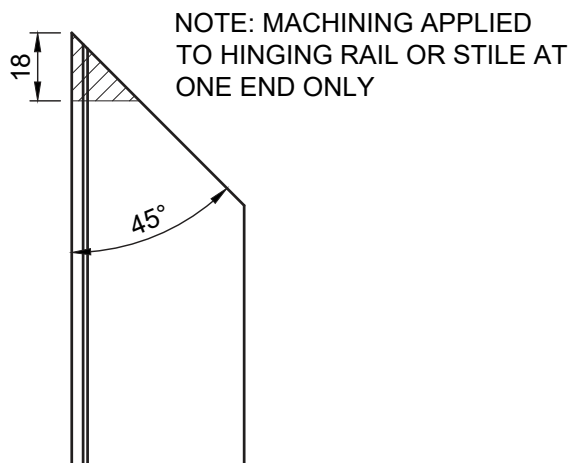
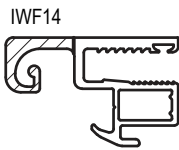
### Rail Preparation



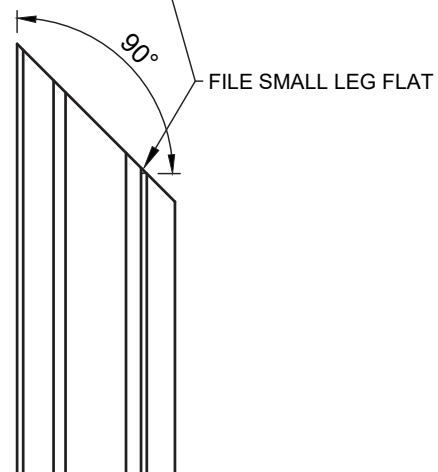
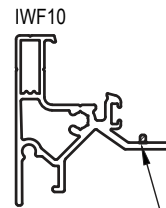
NOTE: ALL PERIMETER FRAMES & SASH SECTIONS ARE MITERED CUT

## 10. Manufacturing Details

### Invisi-Scape Open Out Details

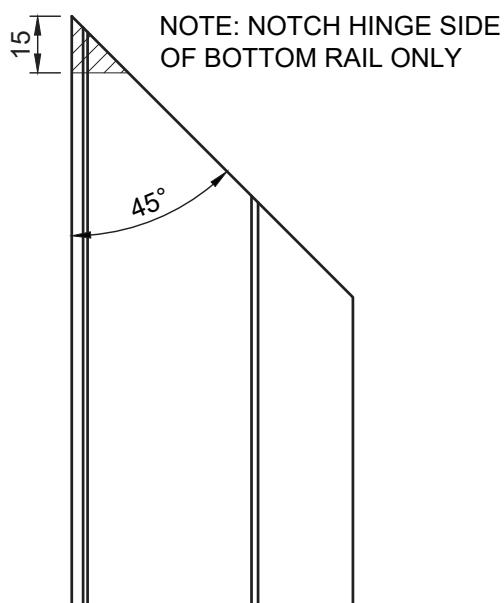
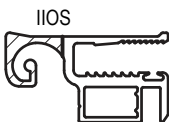


refer to page 11.9 for more details

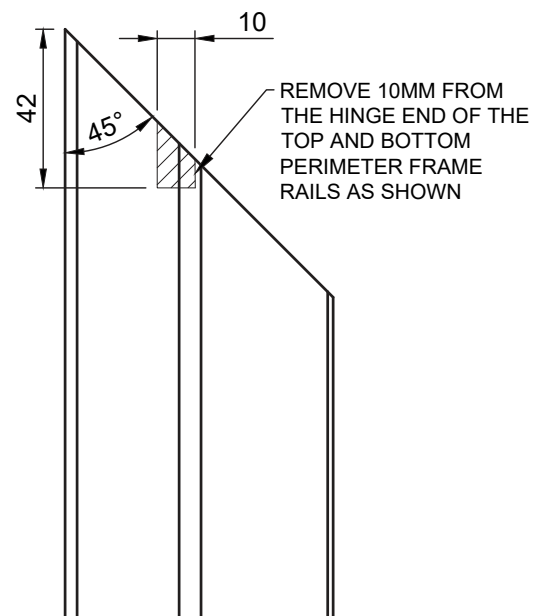
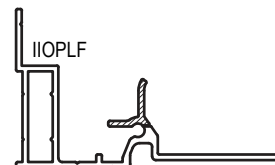


refer to page 11.11 for more details

### Invisi-Scape Open In Details



refer to page 11.17 for more details



refer to page 11.17 for more details

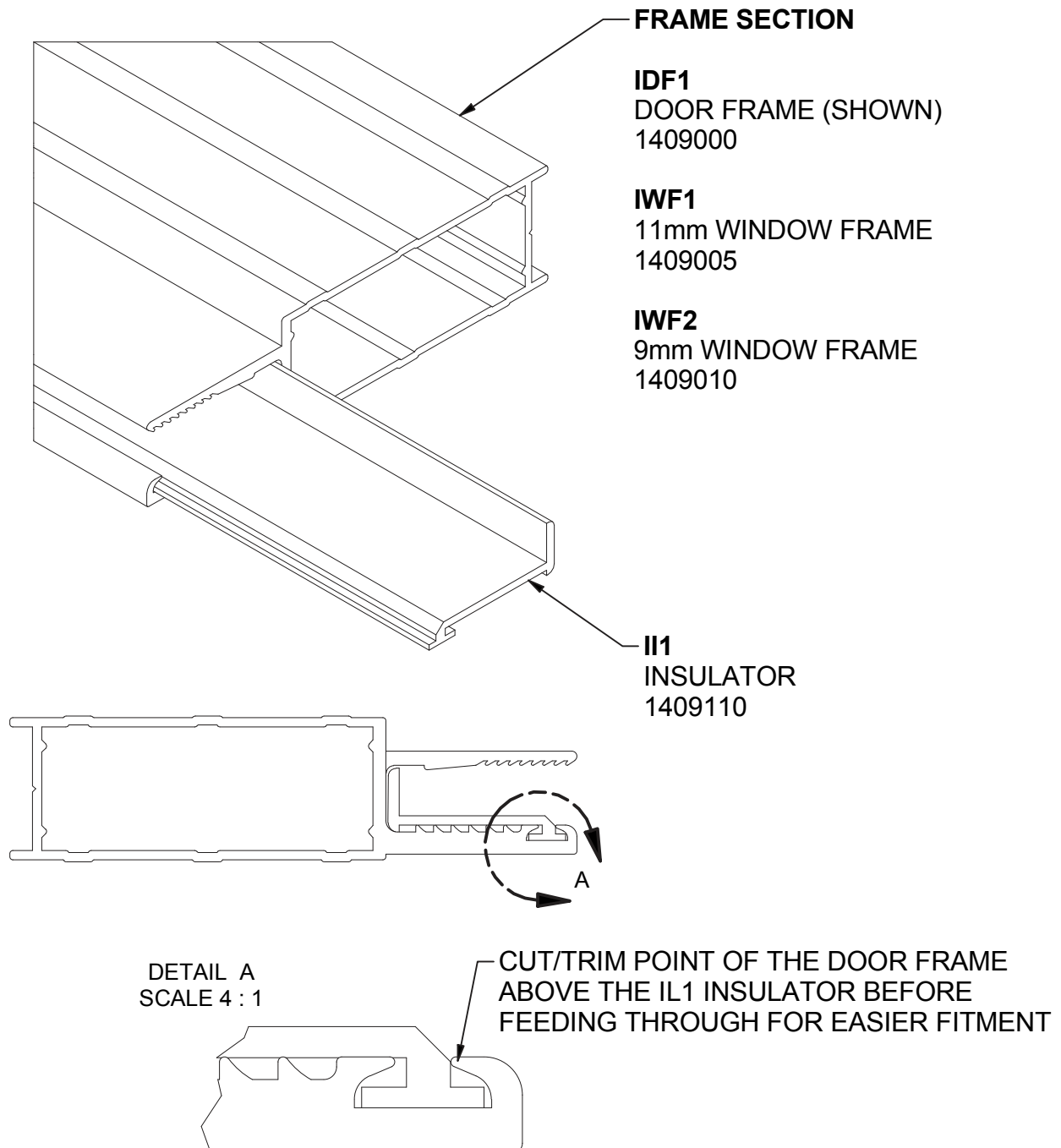


## 11. Assembly Details

### Invisi-Gard Assembly - Step One

INSERT THE FRAME INSULATOR INTO THE SECTION, PULL THROUGH USING BENT NOSE PLIERS AND CUT TO SUIT THE MITRE.

BE CAREFUL NOT TO DAMAGE THE INSULATOR.

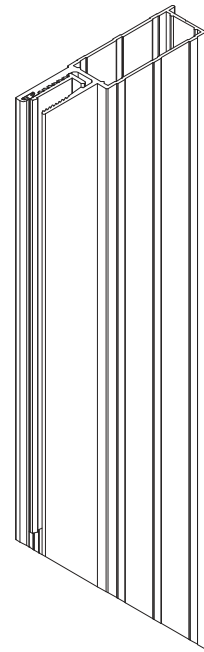
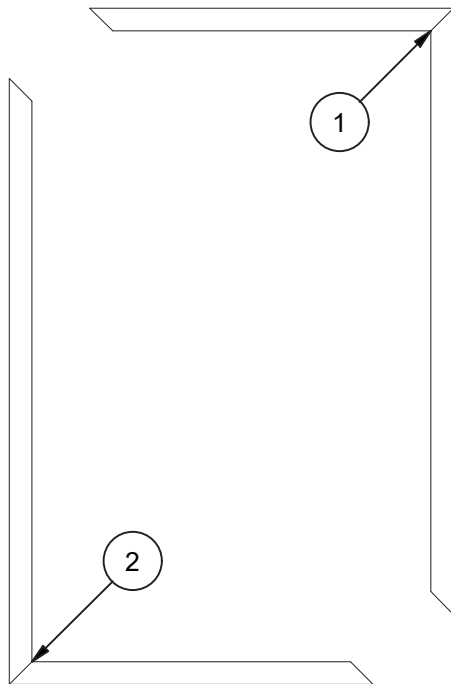


## 11. Assembly Details

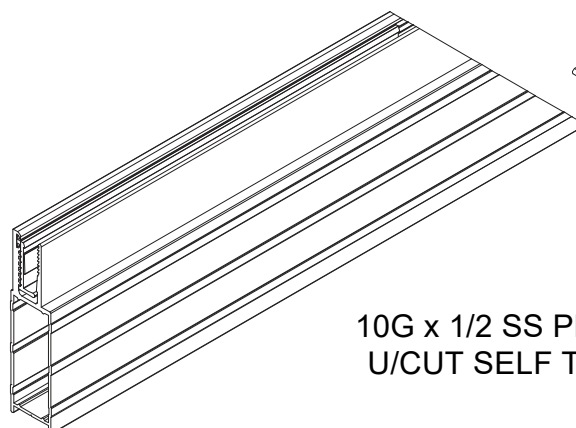
### Invisi-Gard Assembly - Step Two

ASSEMBLE 2 CORNERS OF THE  
FRAME USING THE P2 CORNER  
STAKES.

ASSEMBLE THE FRAME REAR SIDE  
UP (OR INSULATOR DOWN)



**P2**  
DOOR CORNER STAKE  
1311211



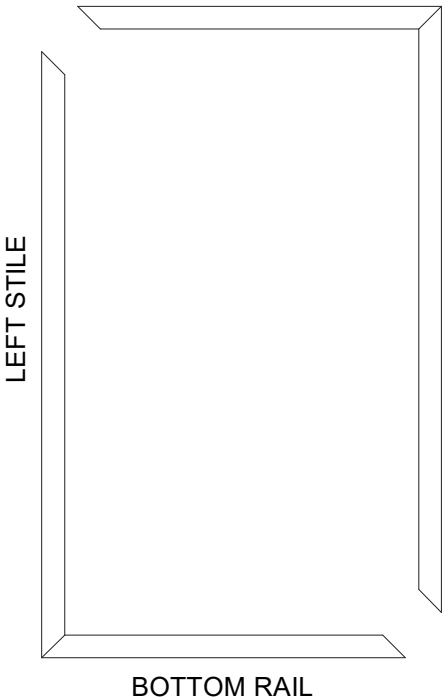
10G x 1/2 SS PHILLIPS  
U/CUT SELF TAPPING  
1382026

OR

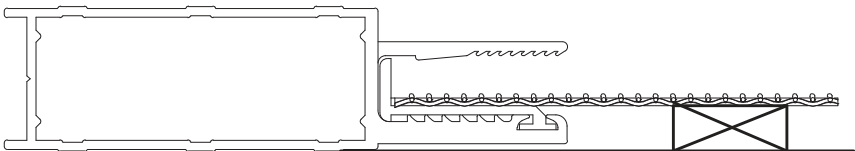
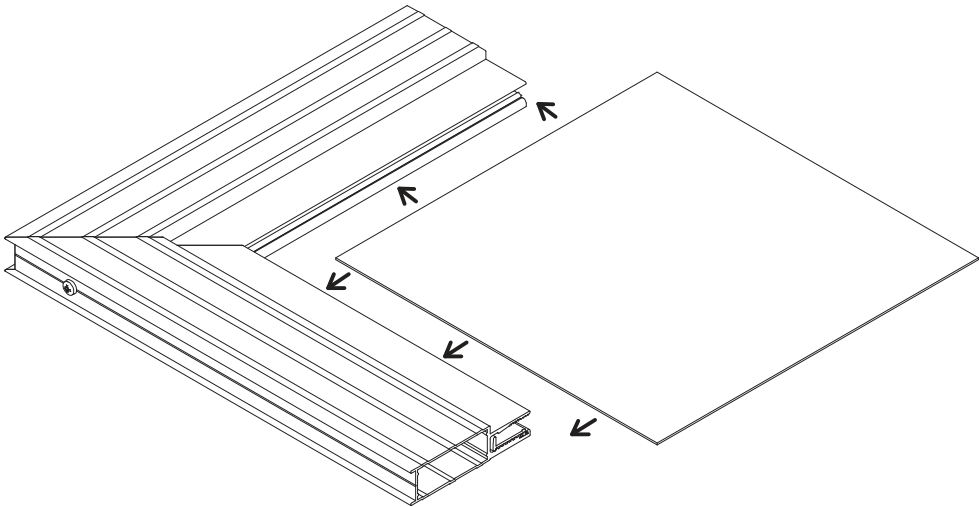
5-4 S/STEEL RIVETS  
1380167

11. Assembly Details

Invisi-Gard Assembly - Step Three



COMPLETE THE ASSEMBLY OF  
THE FRAME AROUND THE MESH.

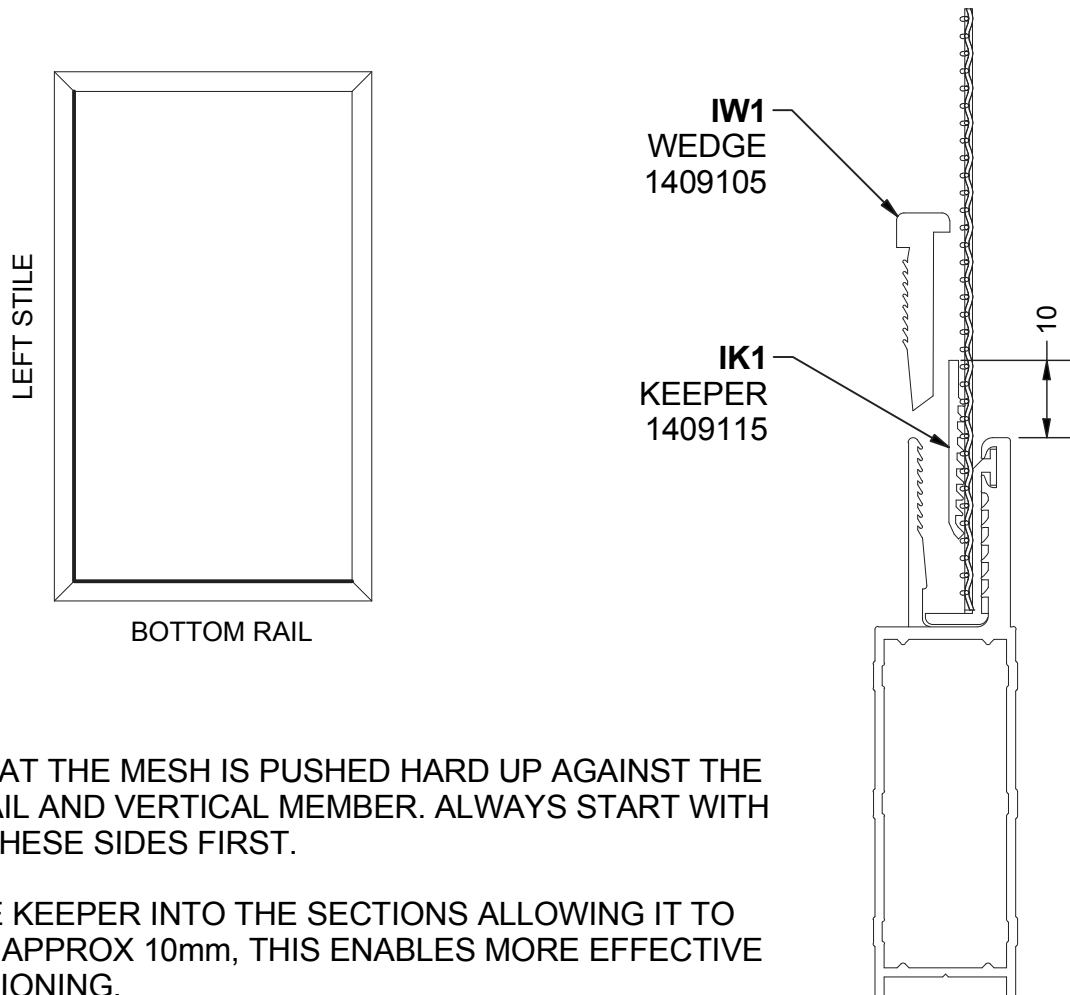


IMPROVE MESH TAUTNESS BY USING  
PACKERS TO SUPPORT THE MESH FROM  
SAGGING. THE PACKER THICKNESS DEPENDS  
ON THE SECTION BEING USED, REFER TABLE.

| PROFILE | PACKING SIZE |
|---------|--------------|
| IDF1    | 6mm          |
| IDFC    | 8mm          |
| ICPDF   | 14mm         |
| IWF1    | 5mm          |
| IWF2    | 5mm          |
| IWF14   | 5mm          |

## 11. Assembly Details

### Invisi-Gard Assembly - Step Four



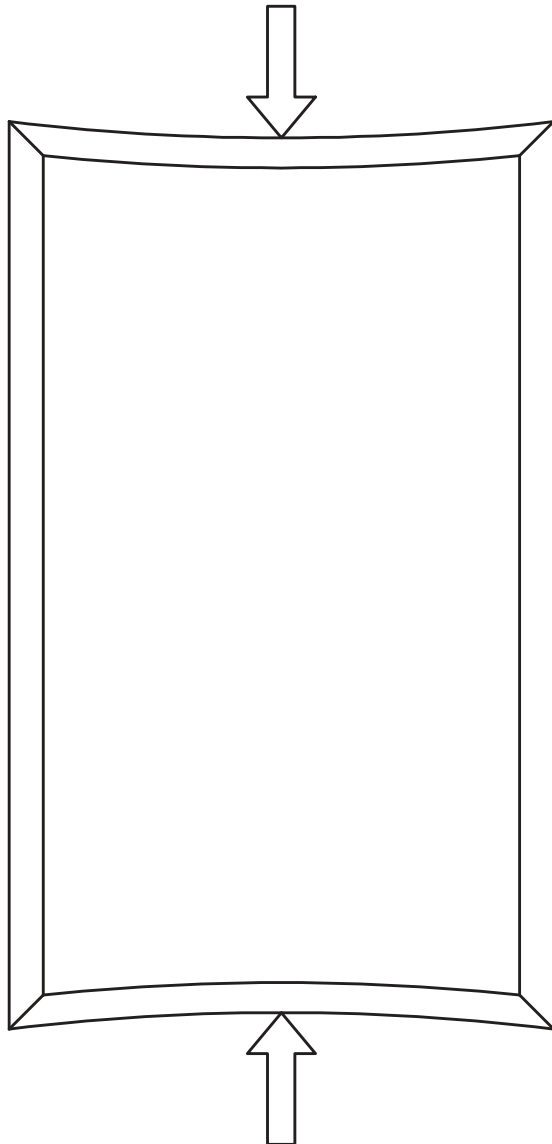
ENSURE THAT THE MESH IS PUSHED HARD UP AGAINST THE BOTTOM RAIL AND VERTICAL MEMBER. ALWAYS START WITH WEDGING THESE SIDES FIRST.

INSERT THE KEEPER INTO THE SECTIONS ALLOWING IT TO PROTRUDE APPROX 10mm, THIS ENABLES MORE EFFECTIVE MESH TENSIONING.

PUSH IN THE WEDGES BY HAND (ENOUGH TO SUPPORT THE MESH), AND USE A NYLON BLOCK TO DRIVE IN THE WEDGE. TAKE CARE TO NOT DAMAGE THE MESH

## 11. Assembly Details

### Invisi-Gard Assembly - Door Tensioning Method



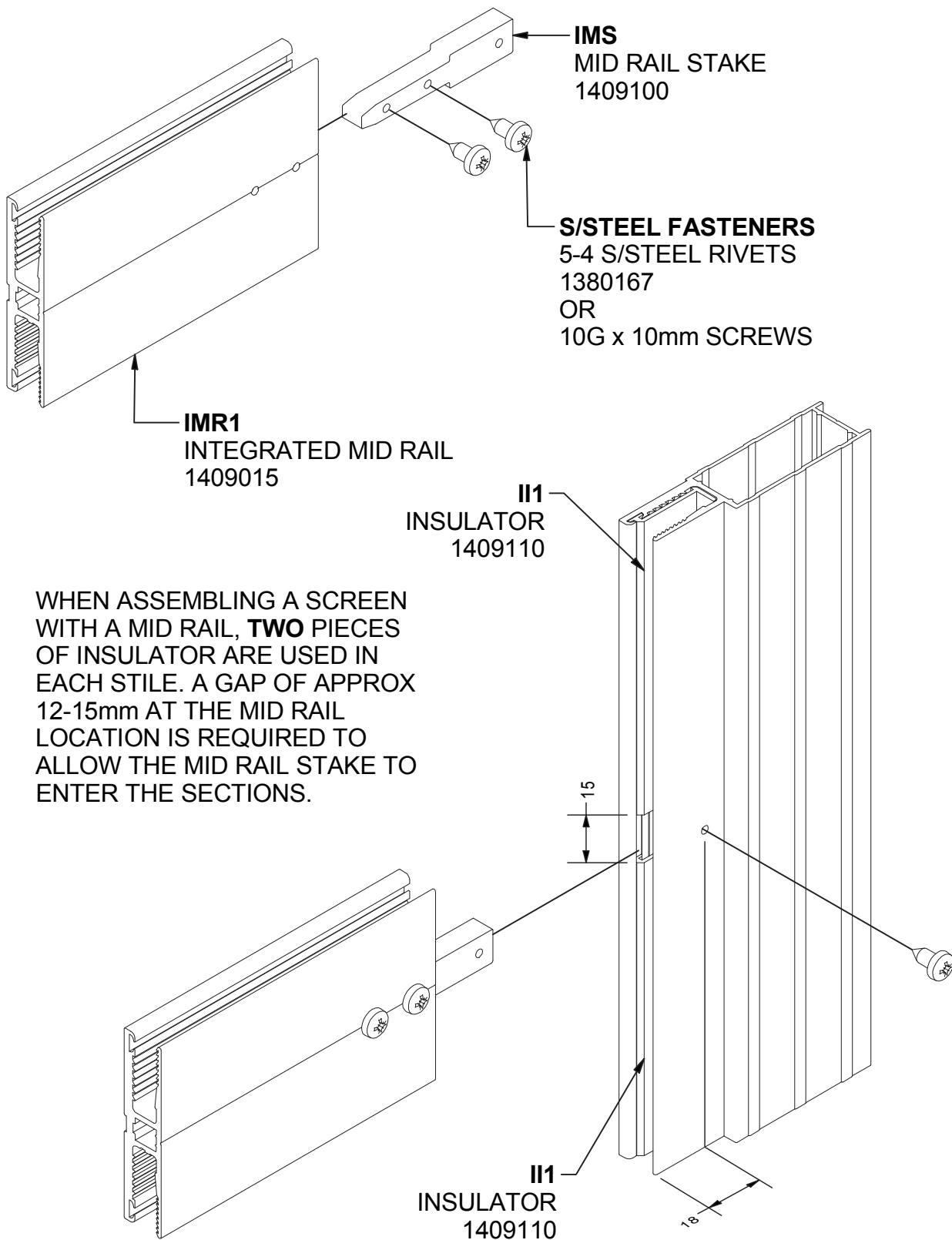
#### **IMPORTANT NOTE:**

FOR BEST RESULTS, THE TOP AND BOTTOM RAIL OF ALL DOOR FRAMES SHOULD BE BOWED APPROX. 5mm PER SIDE USING A CLAMPING SYSTEM PRIOR TO WEDGING IN THE MESH, THIS WILL CREATE PRE-TENSION ON THE FRAME WHICH WILL PULL THE MESH TAUT UPON RELEASE OF THE CLAMP .

USE LARGE ADJUSTABLE SASH CLAMP OR SIMILAR

## 11. Assembly Details

### Invisi-Gard Assembly - Mid Rail Assembly



## 11. Assembly Details

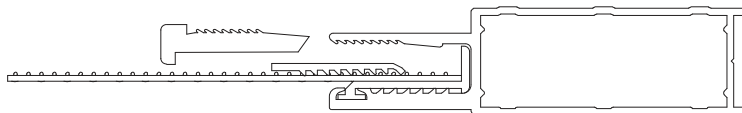
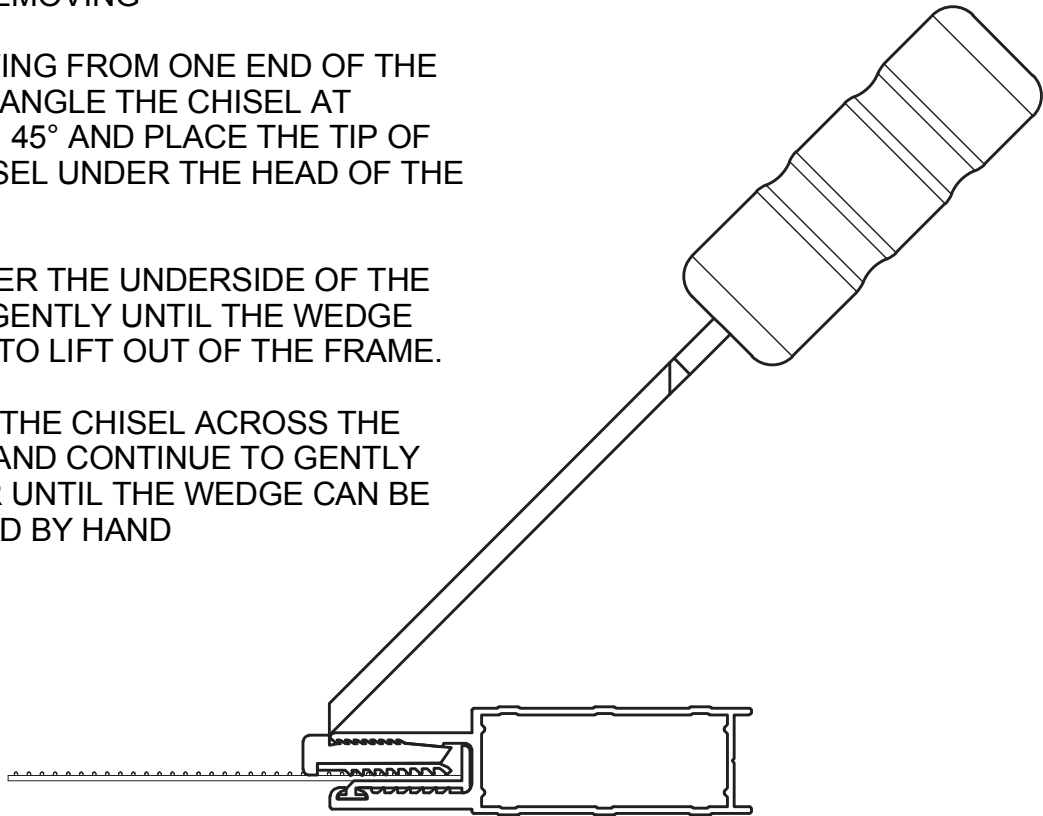
### Invisi-Gard Disassembly

**NOTE:** USE A BLUNTED WIDE FACE CHISEL WHEN REMOVING THE WEDGE TO AVOID BREAKING THE WEDGE HEAD WHEN REMOVING

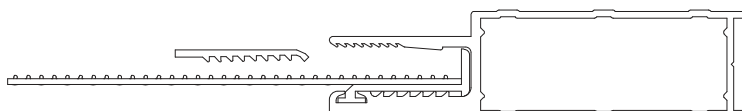
1. STARTING FROM ONE END OF THE WEDGE, ANGLE THE CHISEL AT APPROX. 45° AND PLACE THE TIP OF THE CHISEL UNDER THE HEAD OF THE WEDGE

2. HAMMER THE UNDERSIDE OF THE CHISEL GENTLY UNTIL THE WEDGE STARTS TO LIFT OUT OF THE FRAME.

3. MOVE THE CHISEL ACROSS THE WEDGE AND CONTINUE TO GENTLY HAMMER UNTIL THE WEDGE CAN BE REMOVED BY HAND

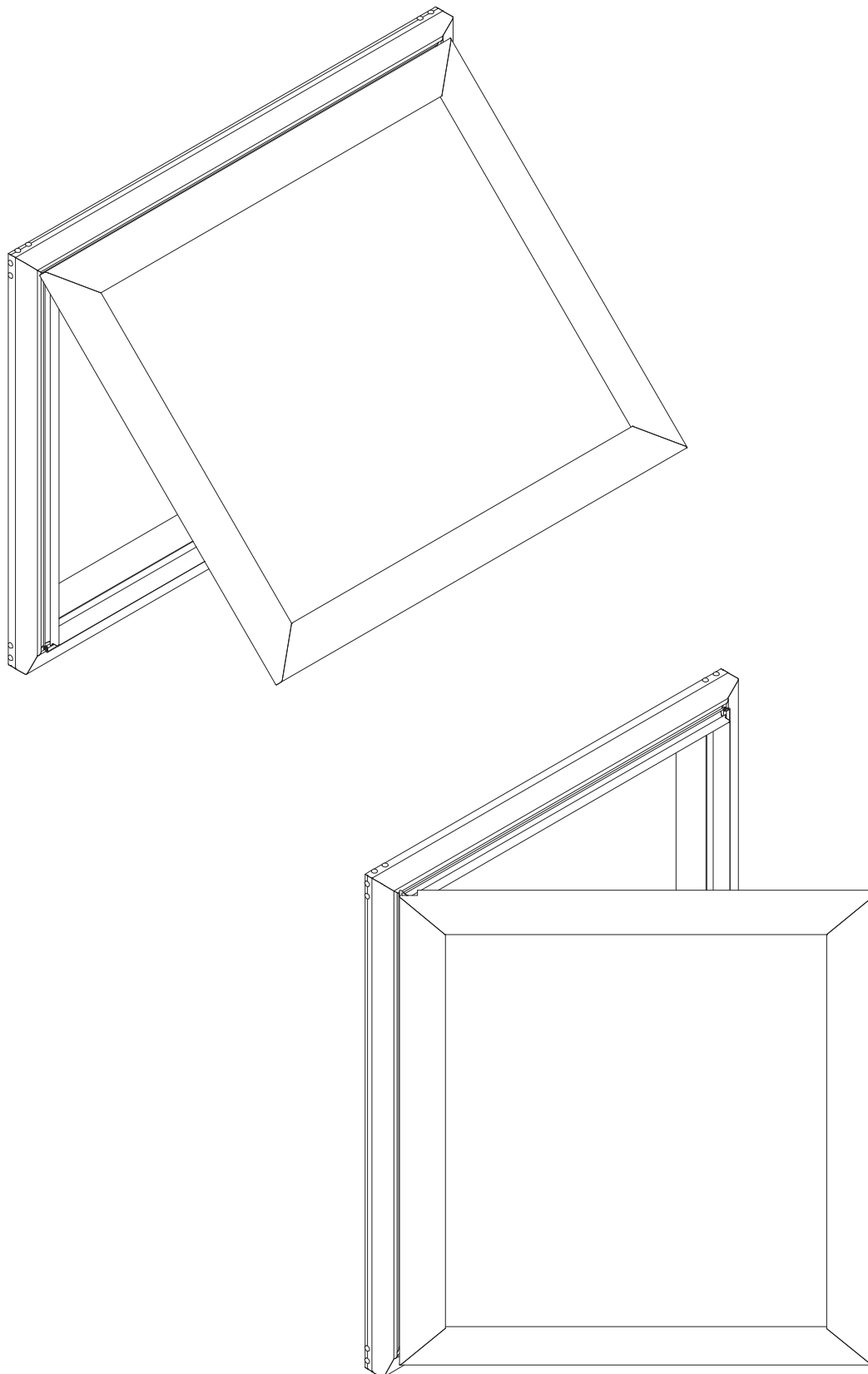


AFTER WEDGE HAS BEEN REMOVED, USE BENT NOSE PLIERS TO REMOVE THE KEEPER STRIP



## 11. Assembly Details

### Invisi-Scape Outward Open

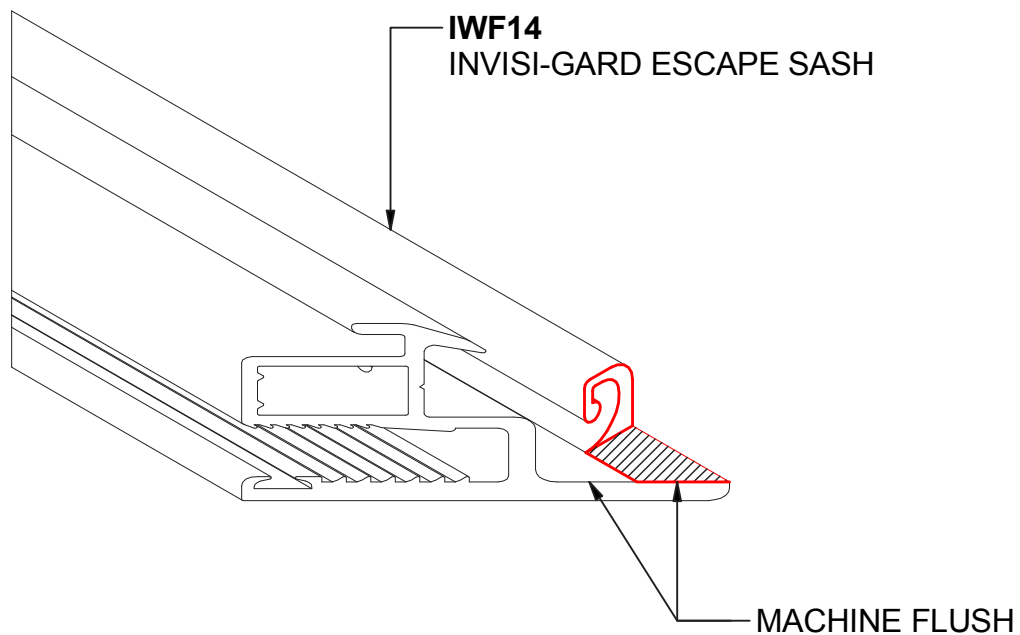
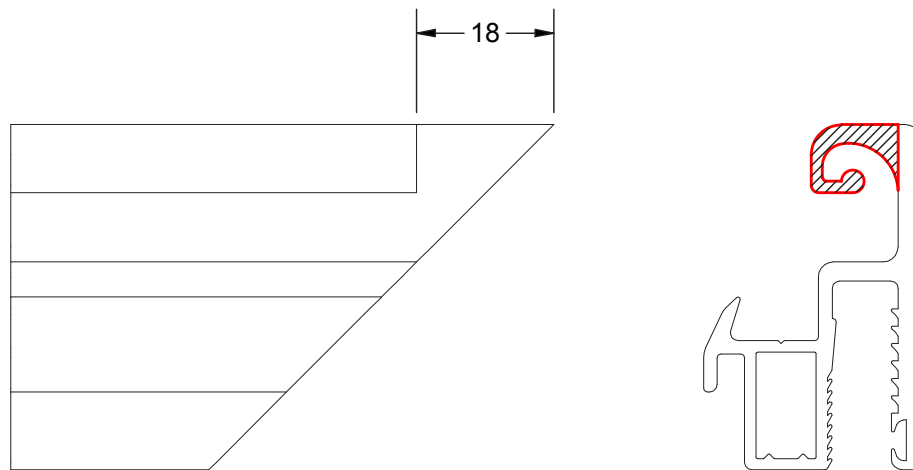


## 11. Assembly Details

### Invisi-Scape Outward Open Assembly - Step One

#### SASH FRAME PREPARATION

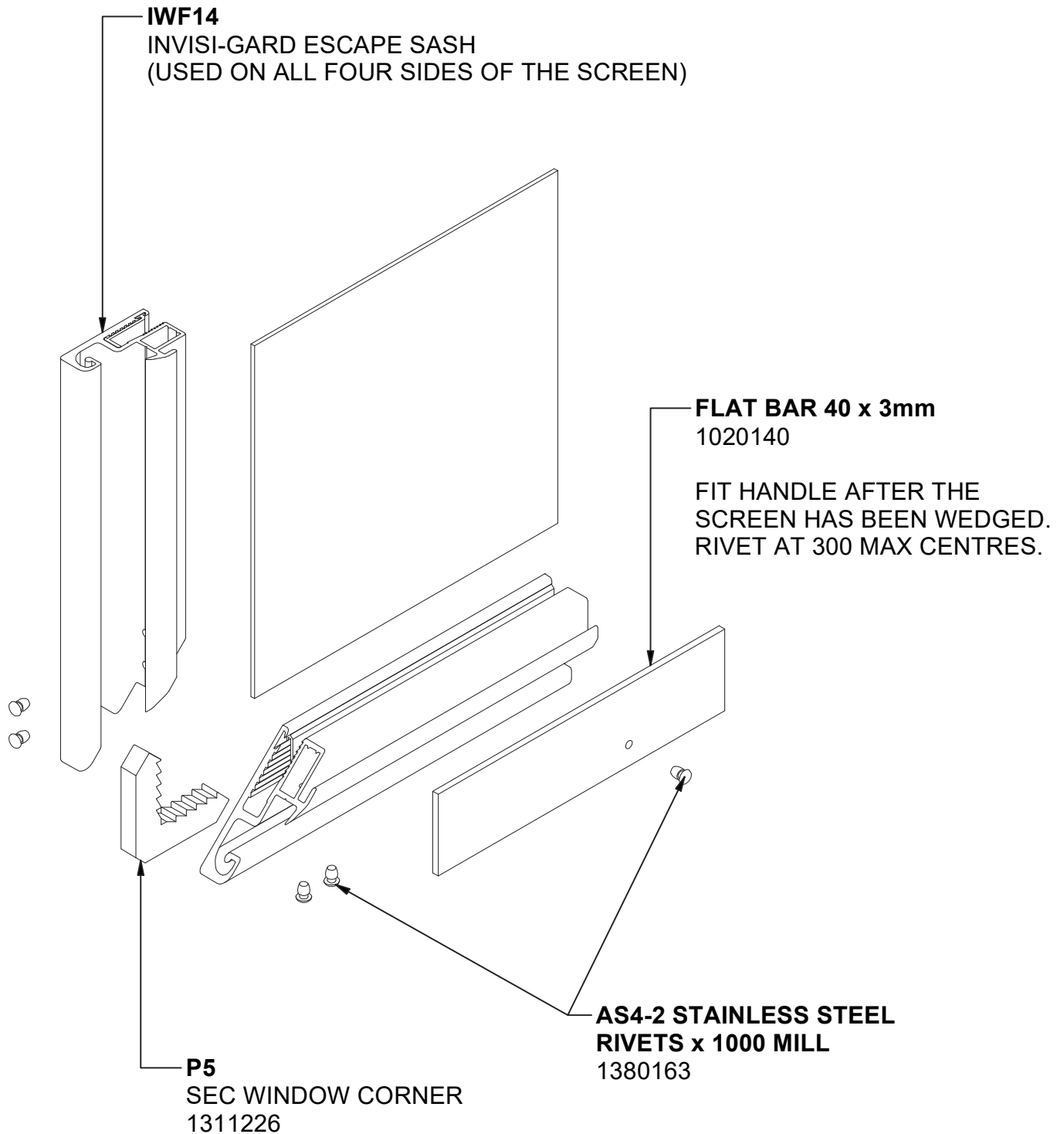
MACHINE 18mm OFF THE HOOK HINGE AS SHOWN BELOW.  
THIS MACHINING OPERATION IS ONLY APPLIED TO THE HINGING  
SIDE AT ONE END ONLY.



## 11. Assembly Details

### Invisi-Scape Outward Opening Assembly - Step Two

ASSEMBLE THE SASH FRAME AS PER A STANDARD INVISI-GARD SCREEN.



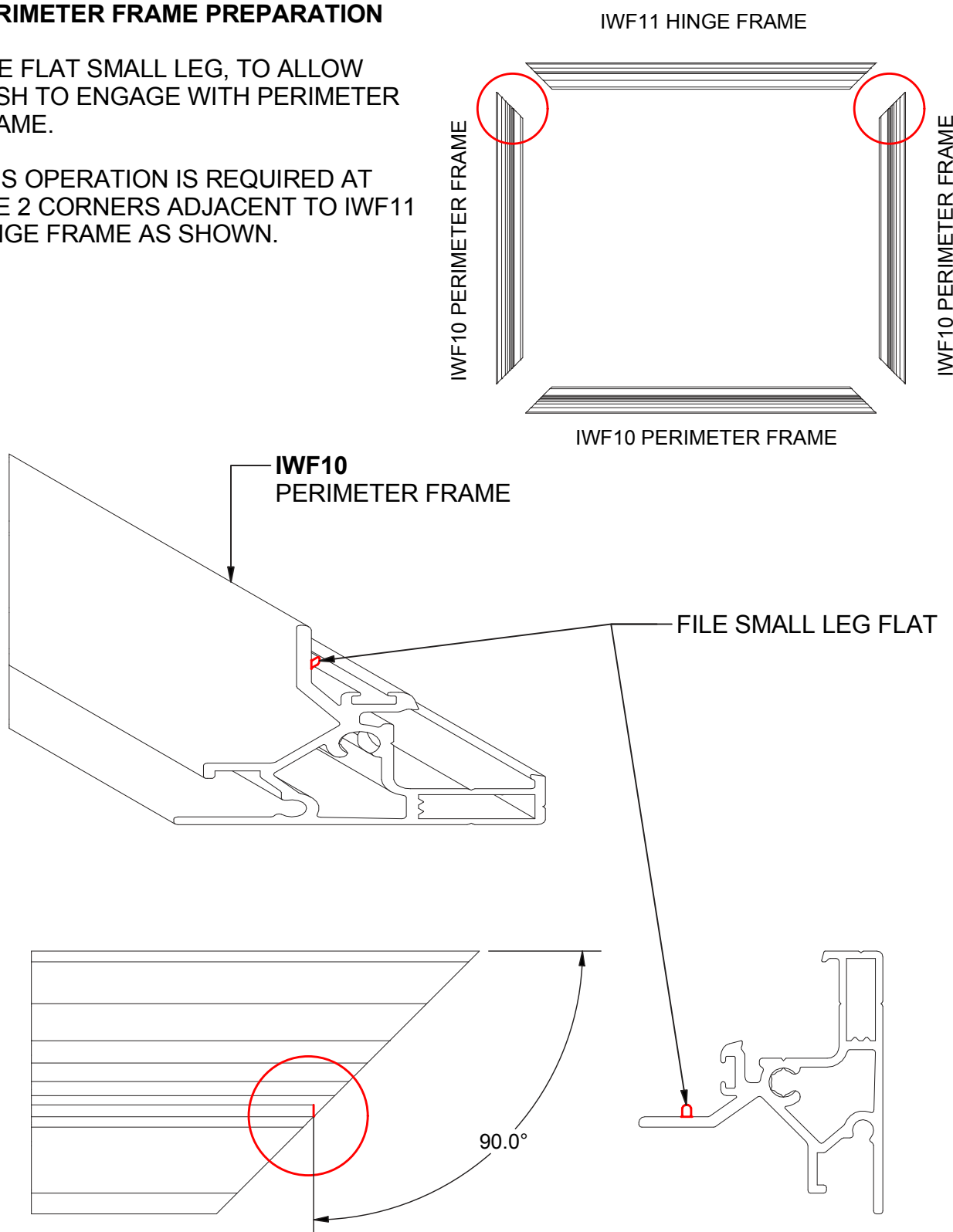
## 11. Assembly Details

### Invisi-Scape Outward Open Assembly - Step Three

#### PERIMETER FRAME PREPARATION

FILE FLAT SMALL LEG, TO ALLOW SASH TO ENGAGE WITH PERIMETER FRAME.

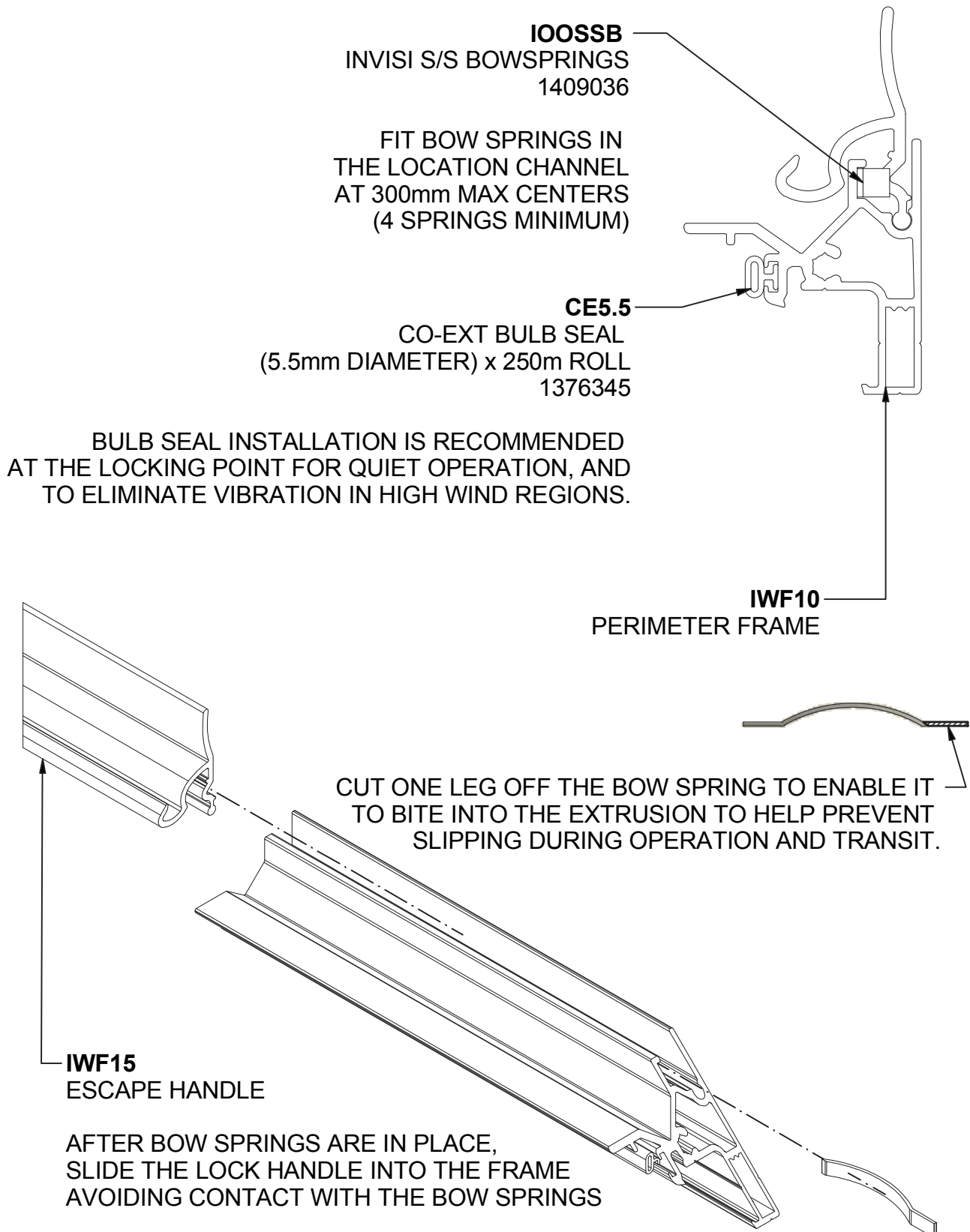
THIS OPERATION IS REQUIRED AT THE 2 CORNERS ADJACENT TO IWF11 HINGE FRAME AS SHOWN.



## 11. Assembly Details

### Invisi-Scape Outward Opening Assembly - Step Four

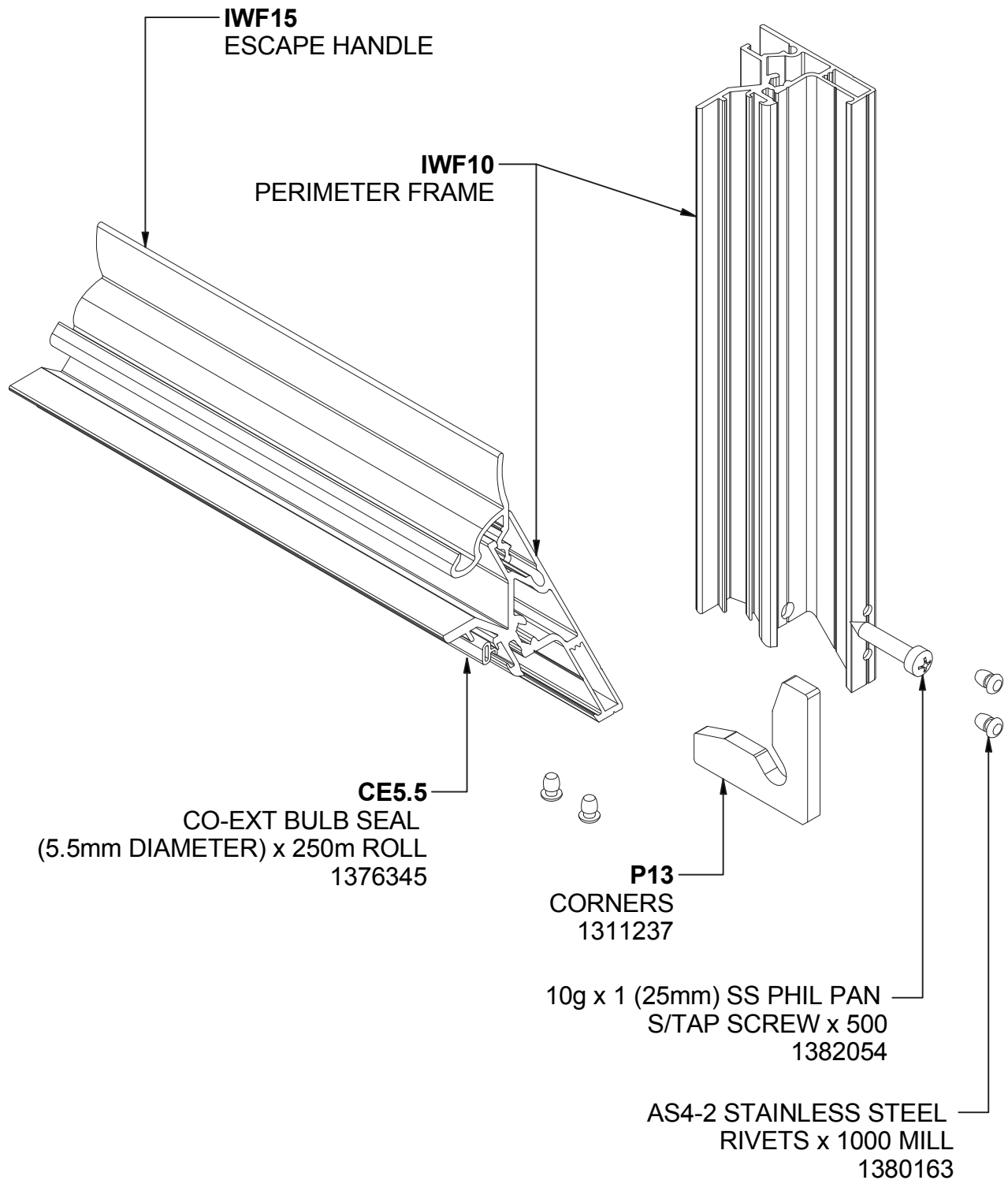
#### SPRING LOADED LOCK ASSEMBLY



## 11. Assembly Details

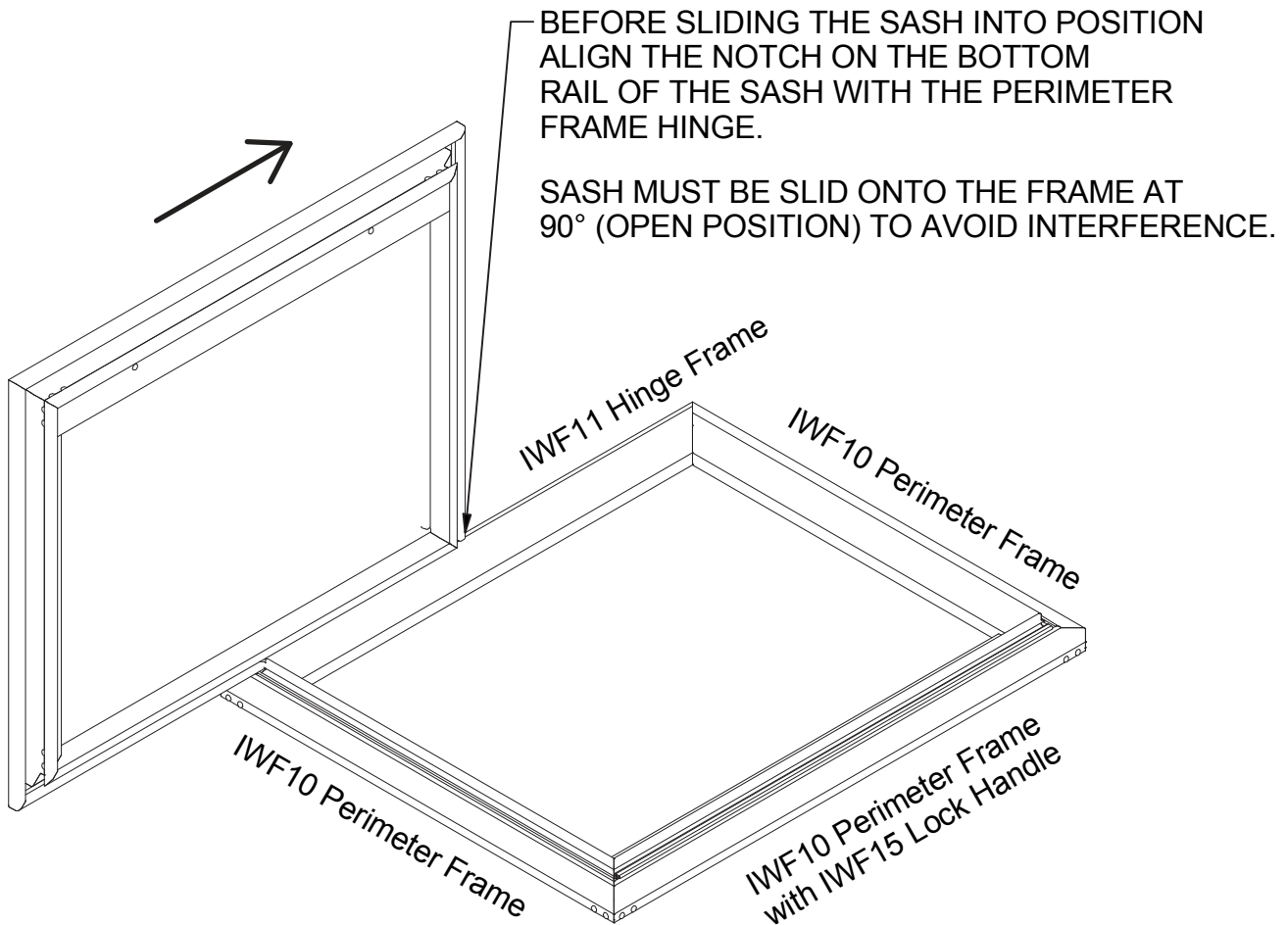
### Invisi-Scape Outward Open Assembly - Step Five

#### PERIMETER FRAME ASSEMBLY (LOCK CORNER SHOWN)



## 11. Assembly Details

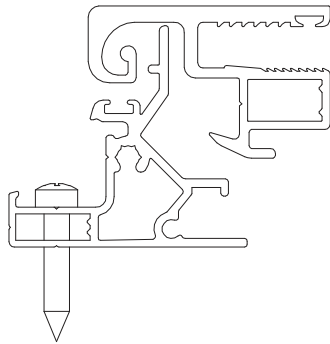
### Invisi-Scape Outward Opening Assembly - Step Six



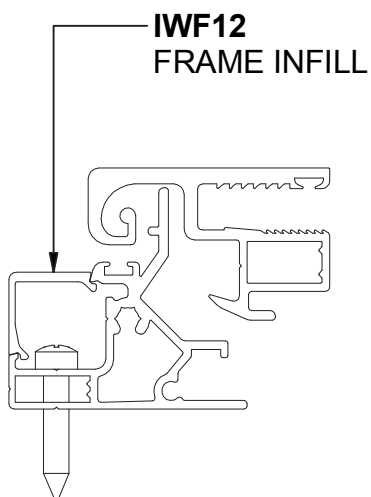
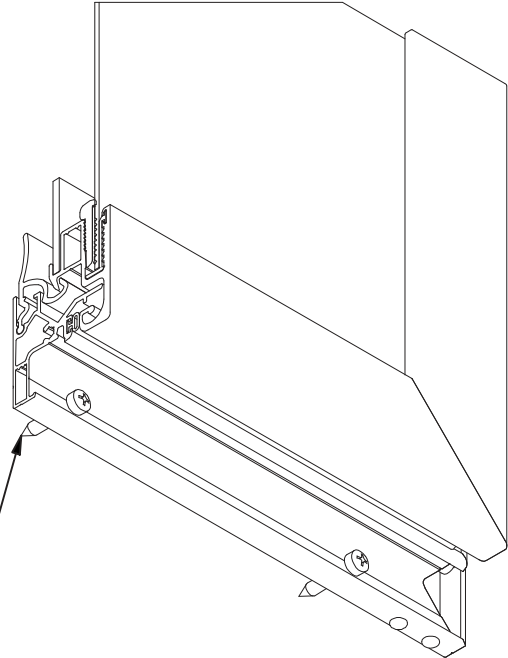
## 11. Assembly Details

### Invisi-Scape Outward Open Assembly - Step Seven

#### FINAL ASSEMBLY

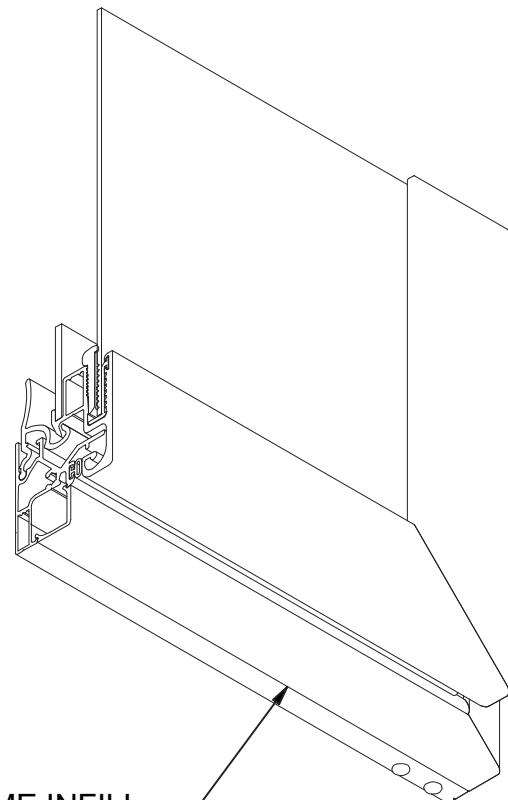


USING MIN. 8G ANTI-TAMPER SCREWS,  
FRAME MUST BE SECURELY FIXED  
TO THE STRUCTURE AT 300mm  
MAX CENTRES. DO NOT OVER TIGHTEN.



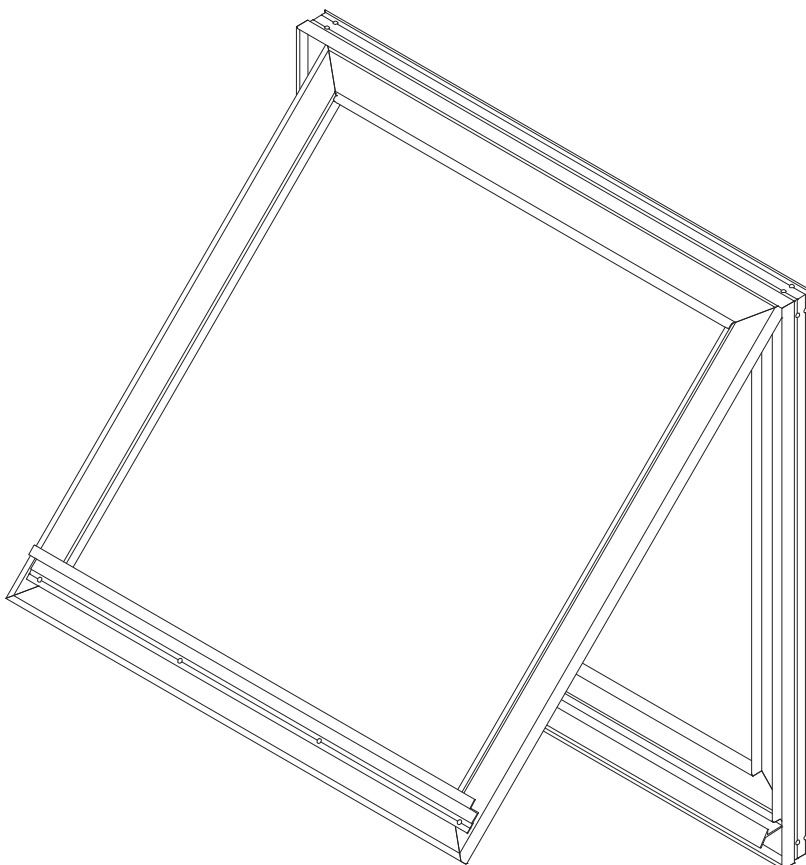
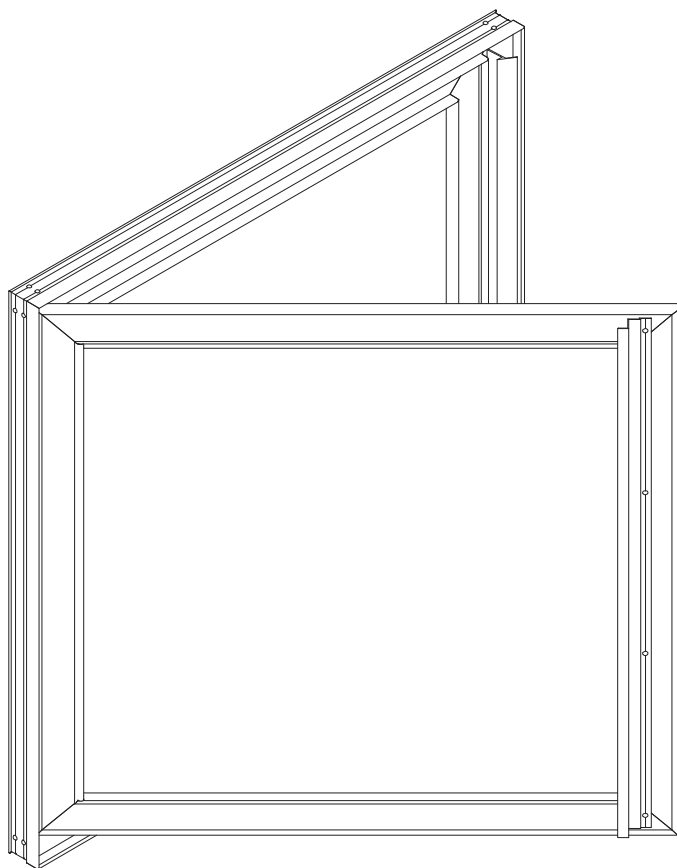
**IWF12  
FRAME INFILL**

CLIP ON THE FRAME INFILL  
TO CONCEAL THE FIXINGS.



## 11. Assembly Details

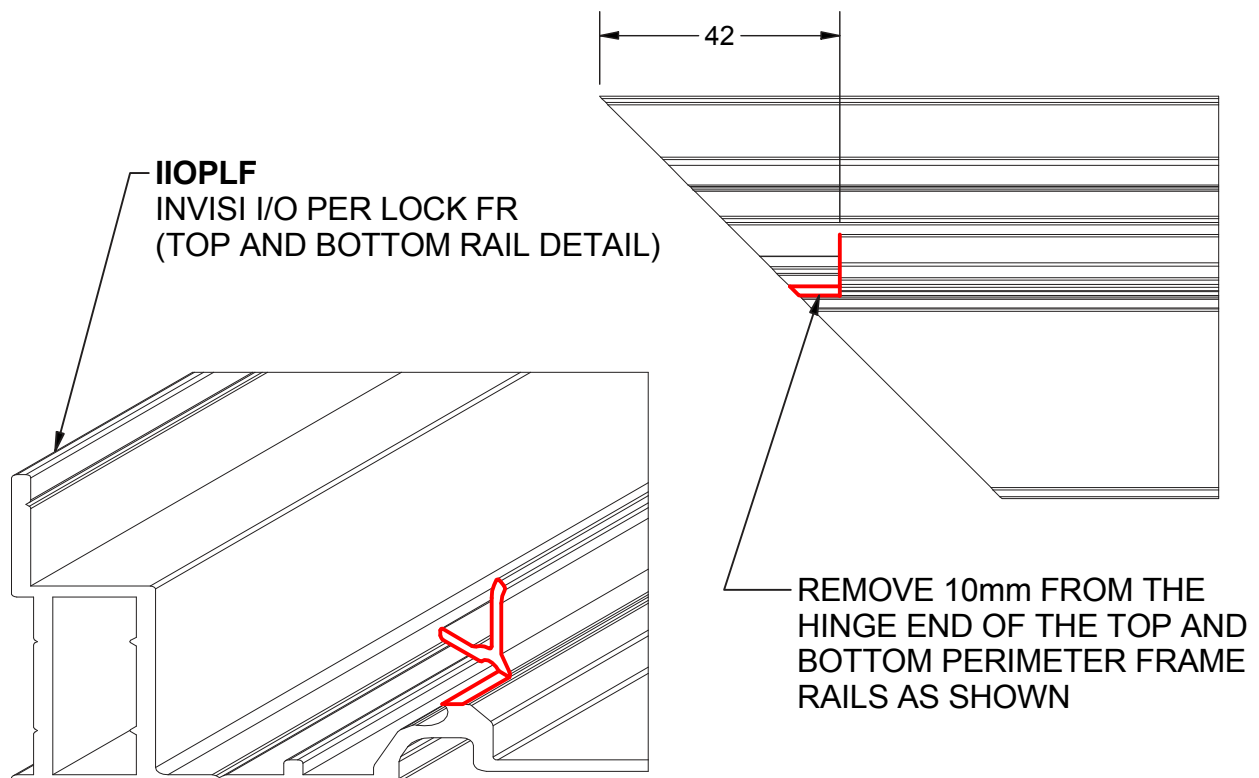
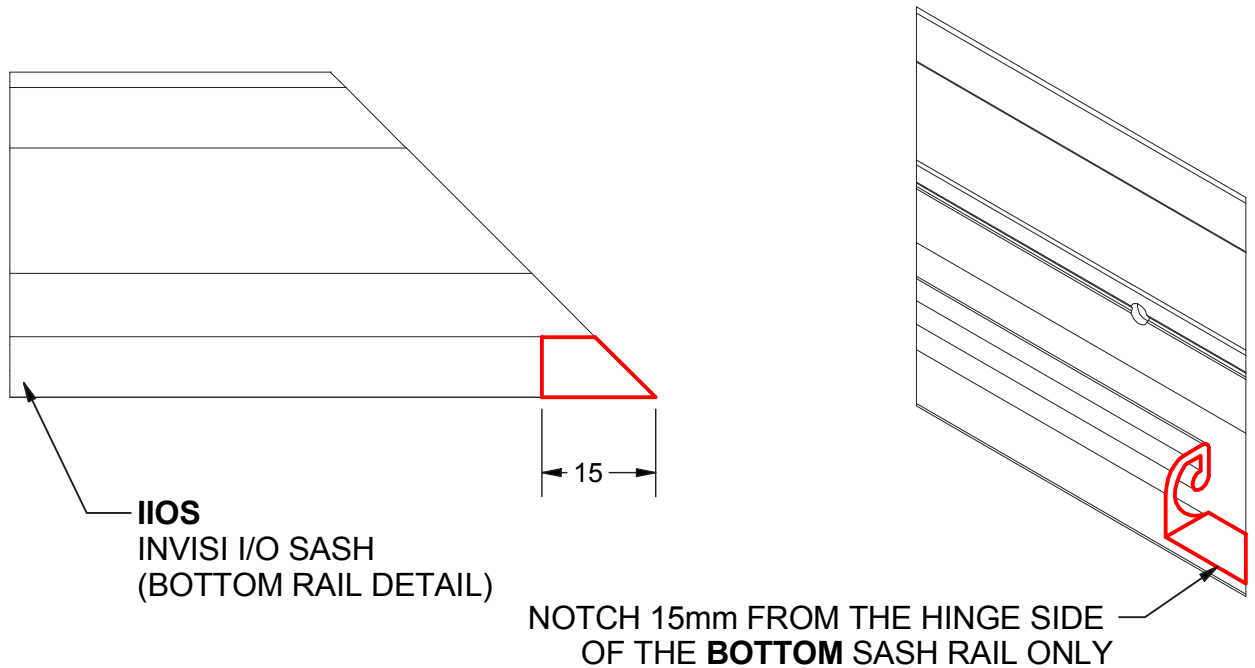
### Invisi-Scape Inward Opening



## 11. Assembly Details

### Invisi-Scape Inward Opening - Step One

PREPARE THE SASH BOTTOM RAIL AND THE PERIMETER FRAME RAILS  
ACCORDING TO THE NOTCHING DETAILS BELOW.

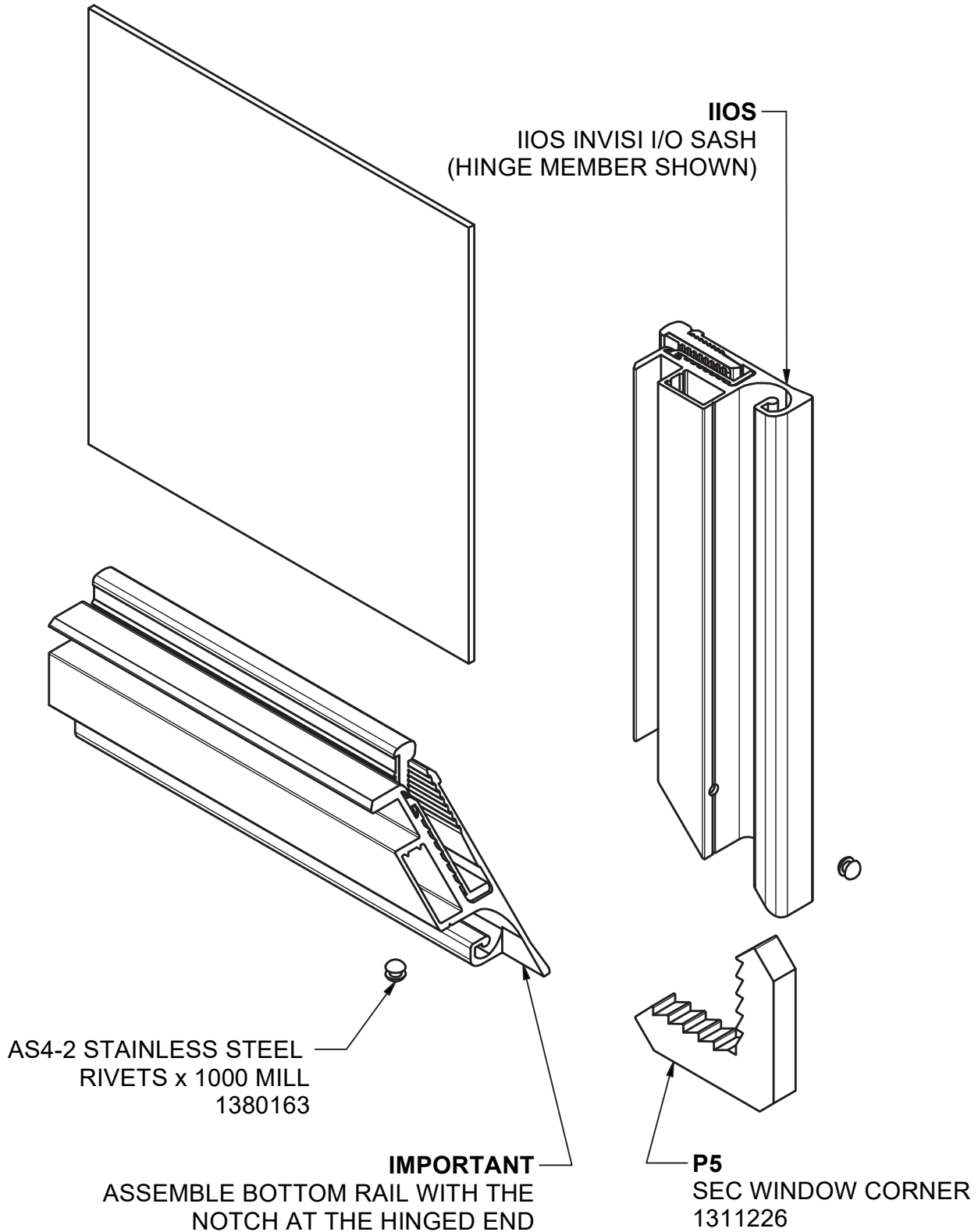


## 11. Assembly Details

### Invisi-Scape Inward Opening - Step Two

#### SASH FRAME ASSEMBLY

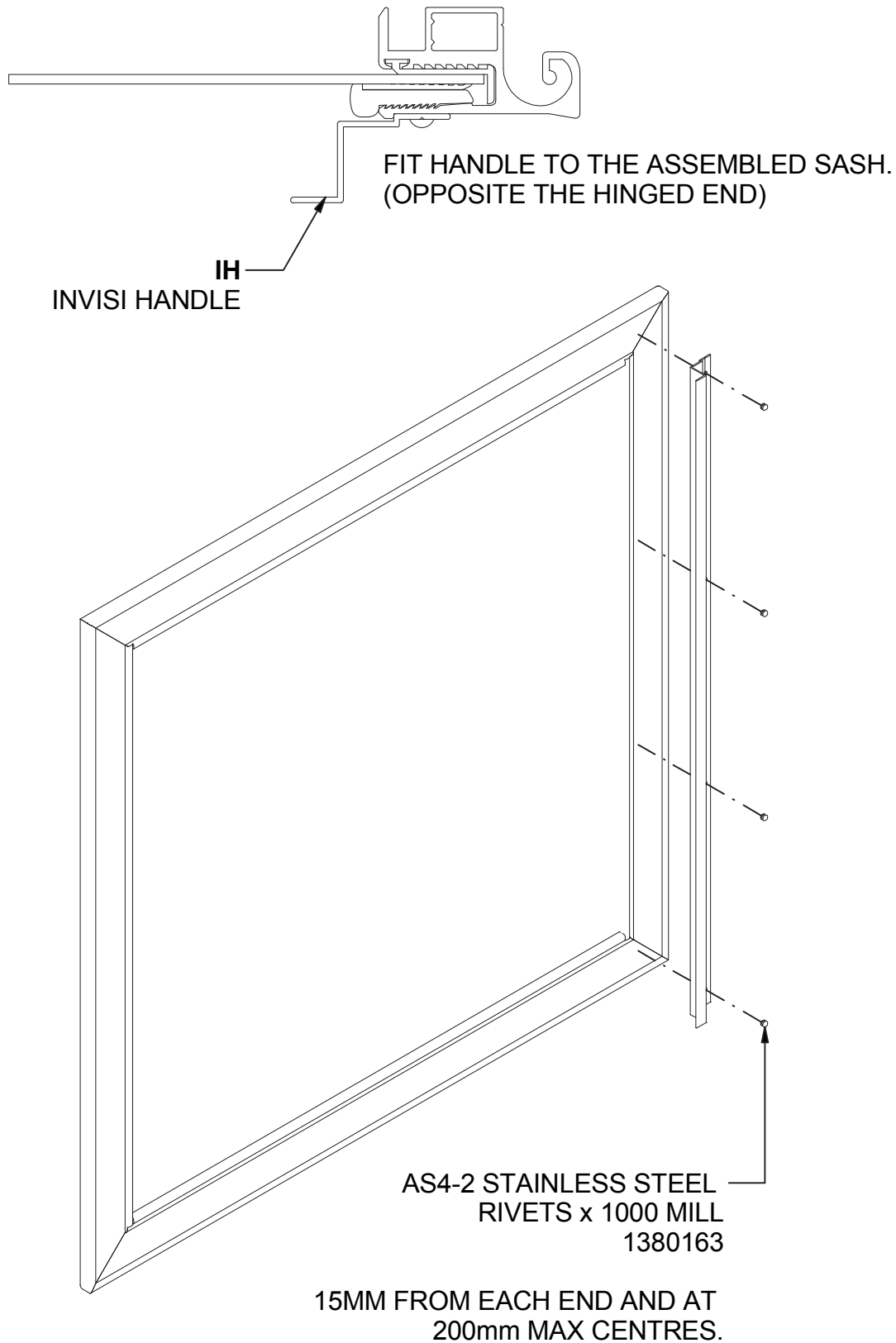
ASSEMBLE THE SASH FRAME AS PER A STANDARD INVISI-GARD WINDOW.



## 11. Assembly Details

### Invisi-Scape Inward Opening - Step Three

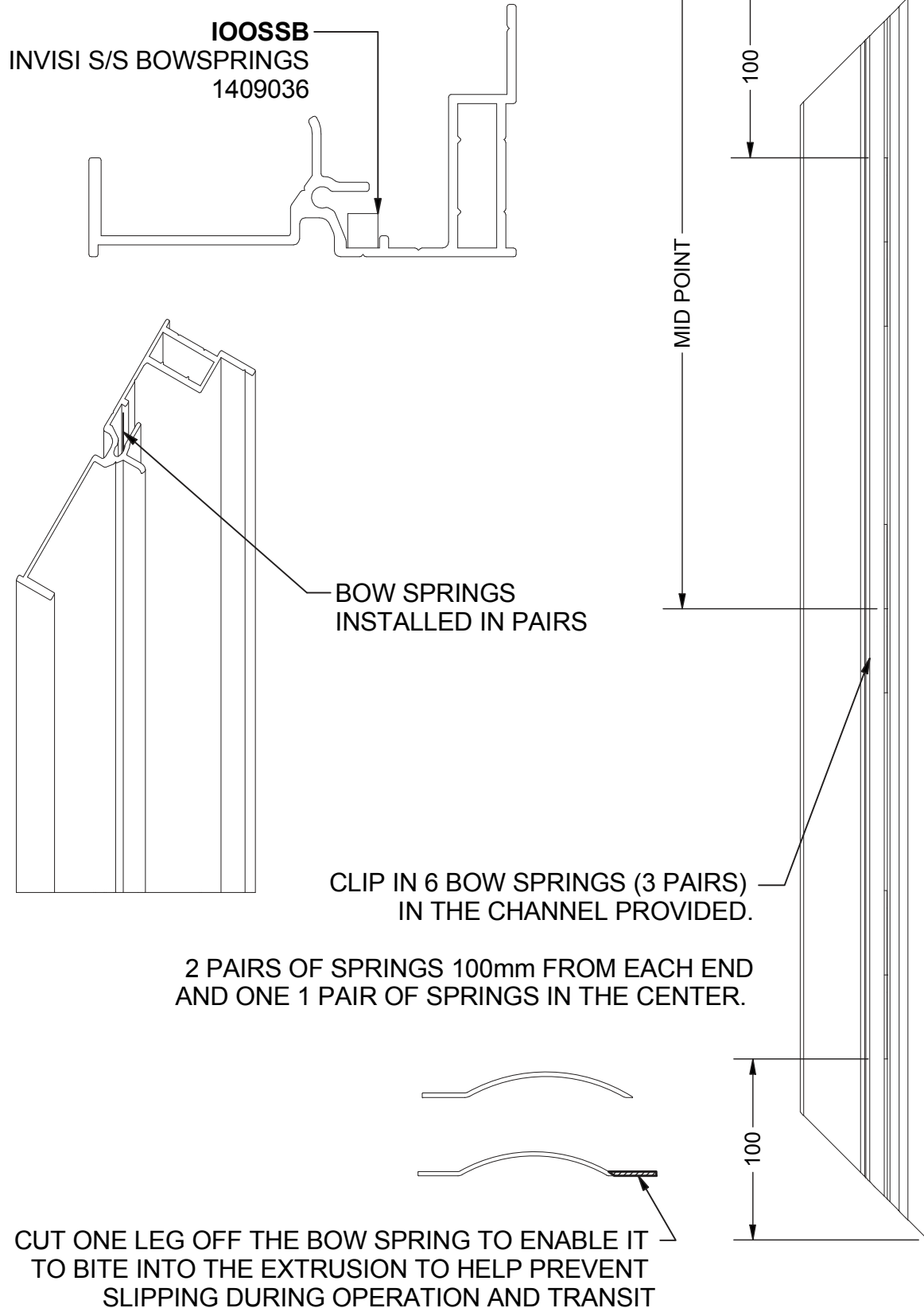
#### SASH FRAME ASSEMBLY



## 11. Assembly Details

### Invisi-Scape Inward Opening - Step Four

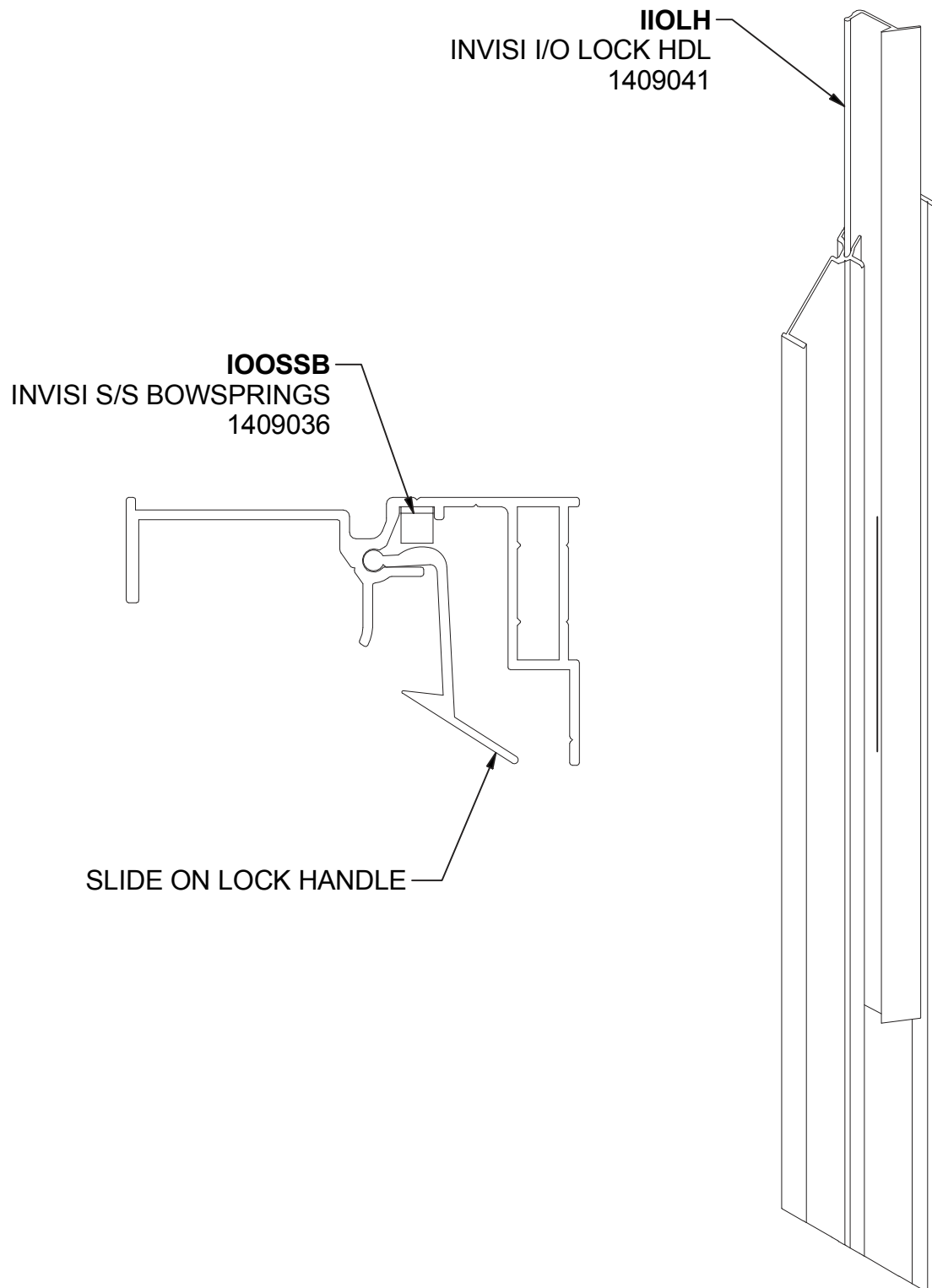
#### PERIMETER FRAME ASSEMBLY



## 11. Assembly Details

### Invisi-Scape Inward Opening - Step Five

#### PERIMETER FRAME ASSEMBLY



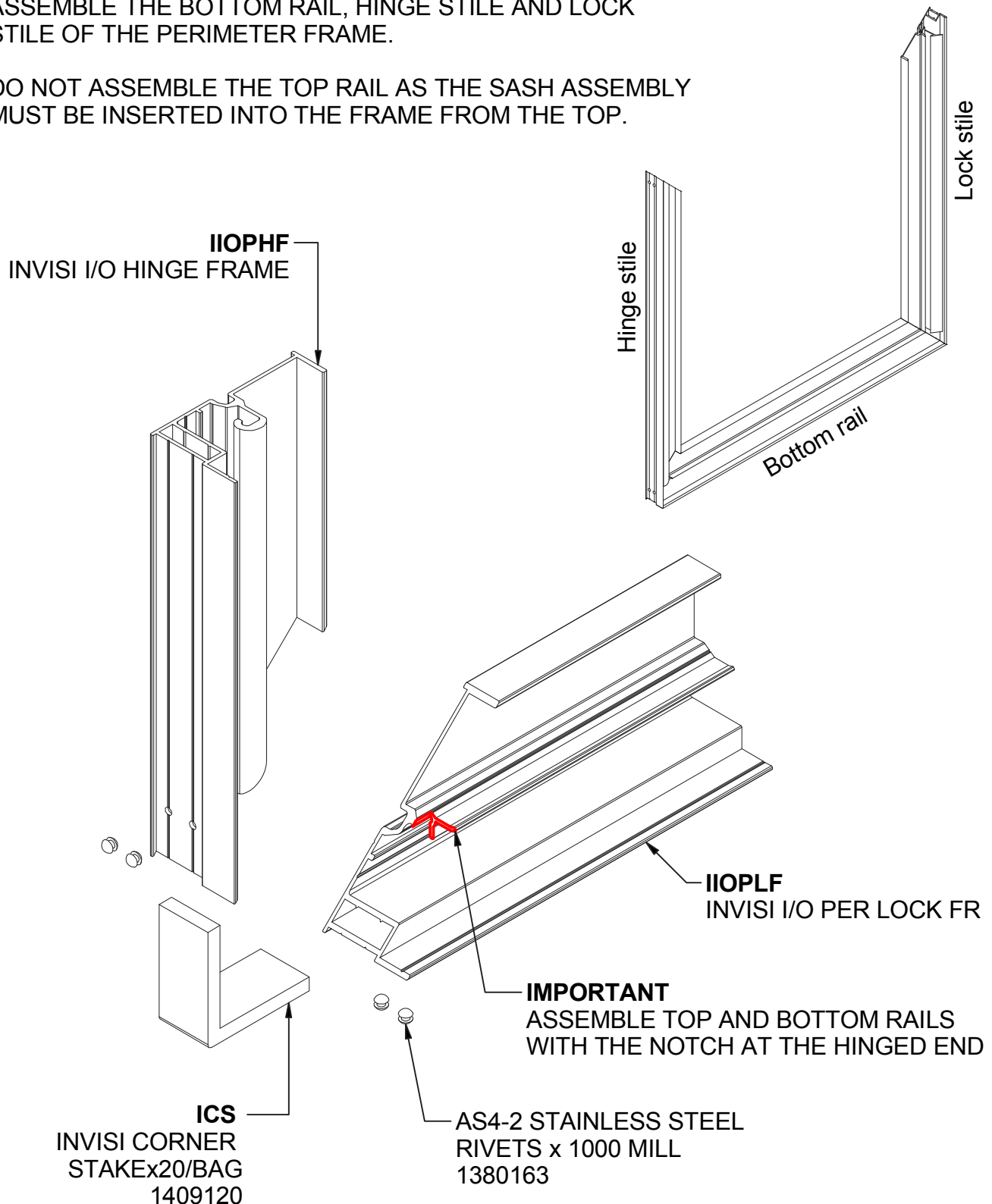
## 11. Assembly Details

### Invisi-Scape Inward Opening - Step Six

#### PERIMETER FRAME ASSEMBLY

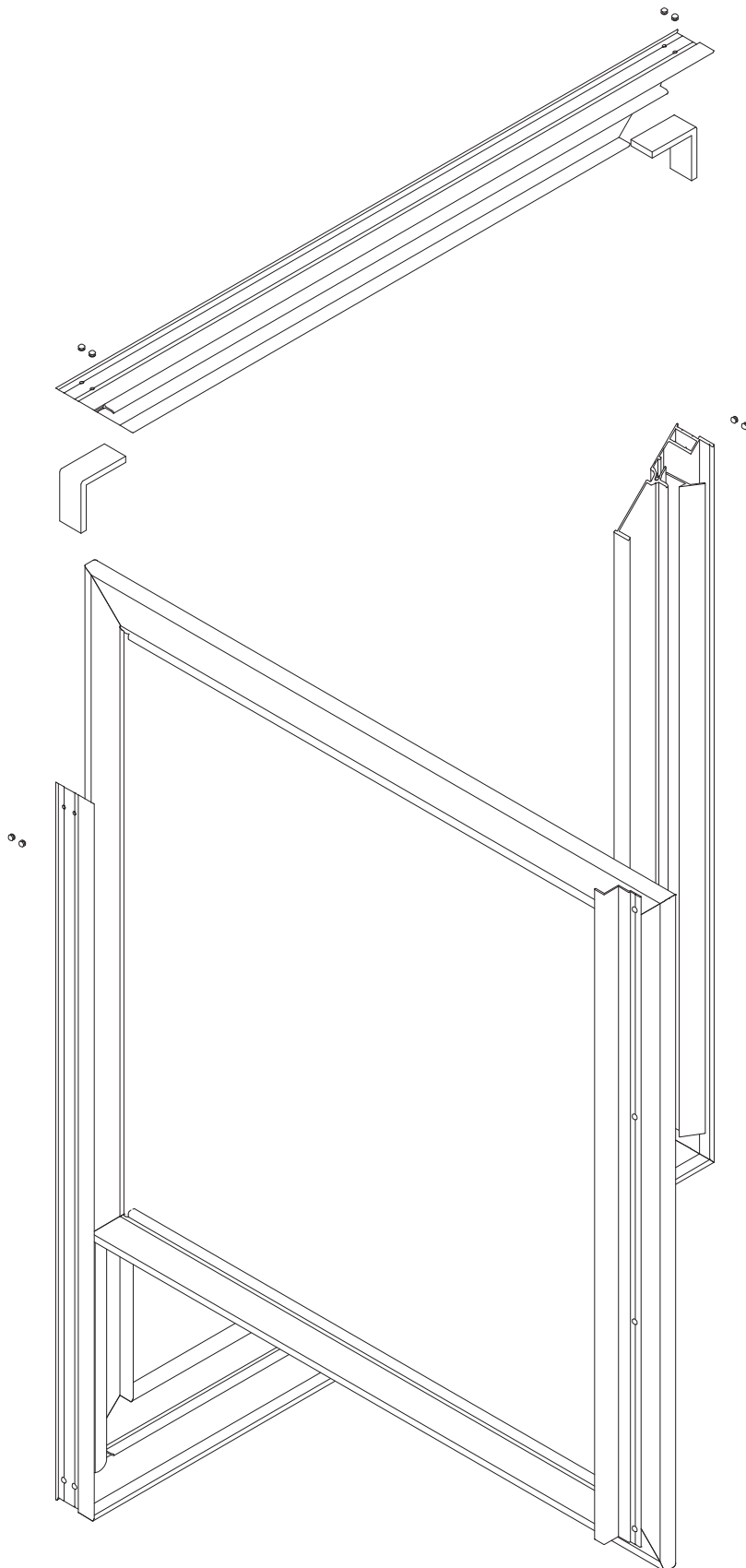
ASSEMBLE THE BOTTOM RAIL, HINGE STILE AND LOCK STILE OF THE PERIMETER FRAME.

DO NOT ASSEMBLE THE TOP RAIL AS THE SASH ASSEMBLY MUST BE INSERTED INTO THE FRAME FROM THE TOP.



## 11. Assembly Details

### Invisi-Scape Inward Opening - Step Seven



BEFORE SLIDING THE SASH INTO POSITION ALIGN THE NOTCH ON THE BOTTOM RAIL OF THE SASH WITH THE PERIMETER FRAME HINGE.

SASH MUST BE SLID ONTO THE FRAME AT 90° (OPEN POSITION) TO AVOID INTERFERENCE.

ONCE THE TOP RAIL HAS BEEN ASSEMBLED TO THE FRAME, CHECK THE OPERATION OF THE LOCK.



## 13. Care & Maintenance

### FRAMING

Your new **INVISI-GARD Security Screen** frames have been manufactured using the highest quality materials available to the Architectural industry. Constructed from Architectural grade aluminium, these products are highly corrosion resistant and exceptionally strong. With a moderate amount of maintenance, the **INVISI-GARD Security Screen** frame will retain it's good looks and resist the elements for years to come.

The **INVISI-GARD Security Screen** frames are the product of extensive research and development and designed to resist corrosion and rusting, but as with all external elements on the building require some maintenance to keep them looking good and performing well. Depending on how harsh the environment elements are, the maintenance period will vary. Refer to recommended maintenance table below.

Your **INVISI-GARD Security Screen** frames should only ever need to be washed down with a soft bristled brush using warm water and mild detergent. Rinse well with fresh water and remove any detergent residue. Strong detergents and abrasive cleaners should never be used to clean the **INVISI-GARD Security Screen** frames as they may scratch or damage the surface finish.

### MAINTENANCE PERIOD TABLE

| ENVIRONMENT     | RECOMMENDED MAXIMUM MAINTENANCE INTERVAL |
|-----------------|------------------------------------------|
| Mild            | Six Months                               |
| Moderate        | Three Months                             |
| Tropical/Severe | One Month                                |

Environmental Definitions:

**Mild** – Being rural, away from the coast and remote from industry and urban activity.

**Moderate** – Being mainly urban, inland and away from heavy industry.

**Tropical** – Being coastal/marine, subject to salt deposition and within 15km of the Eastern coast or 10km of the Western coast of Australia.

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