



INVISI-GARD

SECURITY SCREENS



INVISI-GARD

316 STAINLESS STEEL SECURITY

Technical Manual

February 2025 | ISSUE O

alspec[®]
EVERYTHING ALUMINIUM
& HARDWARE

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1. Technical Manual Release Notes

This page is intended to record all changes to the **INVISI-GARD 316 STAINLESS STEEL SECURITY** technical manual pages.

Changes or additions to this manual will be itemised with a brief description and date when the amendments were made.

[illegible]

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

Mesh	Marine Grade 316 Stainless Steel	Average Velocity Drop	44.21%
Wire Diameter	0.8mm	Average Drag Coefficient	0.6998 C _D
Mesh Count	11 x 11 strands per 25mm ²	Wire Tensile Strength	900 MPa (Nominal)
Aperture Size	1.6mm x 1.6mm	Open Area	44 %

Maximum Build Sizes

	HEIGHT (mm)	WIDTH (mm)	AREA (m ²)
SLIDING DOORS			
Without Midrails	2400	1200	2.8
With Midrails	3000	1500	4
HINGE DOORS			
Without Midrails	2400	1000	2.4
With Midrails	3000	1000	2.6
WINDOW SCREENS			
Fixed Screen	1500	1800	2.7
Escape Screen - Top Hung	1500	1800	2.7
Escape Screen - Side Hung	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	AZT0531.18	✓

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



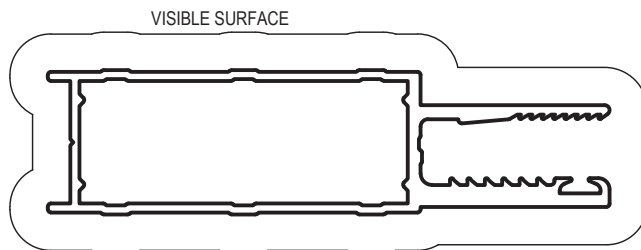
Window Energy Rating Scheme (WERS)

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

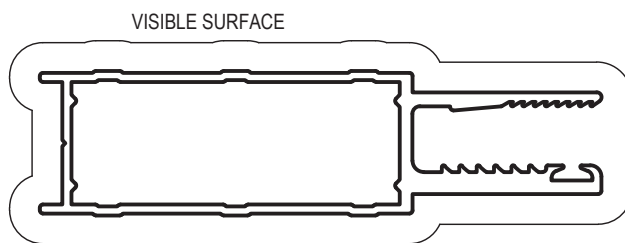
Invisi-Gard Frame



IDF1

INVISI DOOR FRAME

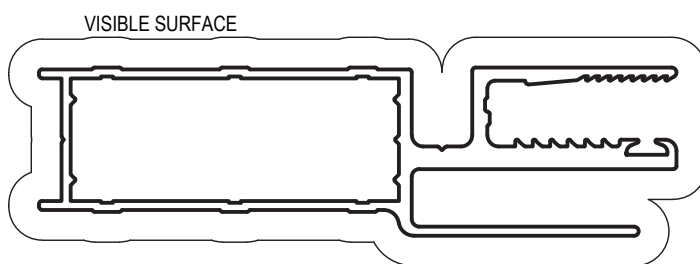
Anod. Per. 266
Paint Per. 185



IDFC

INVISI DOOR FRAME (CENTRE)

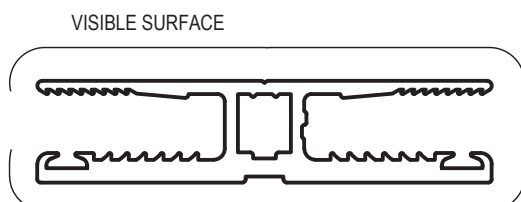
Anod. Per. 266
Paint Per. 185



ICPDF

INVISI CAST PANEL DOOR FRAME

Anod. Per. 370
Paint Per. 289



IMR1

INVISI MIDRAIL

Anod. Per. 296
Paint Per. 135

5. Extrusions

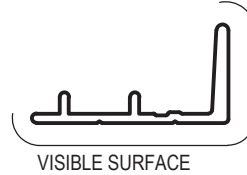
Invisi-Gard Frame

VISIBLE SURFACE



HD3
OFFSET INTERLOCK

Anod. Per. 100
Paint Per. 100



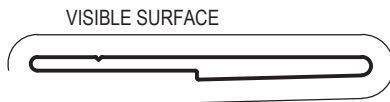
HD9
FRAME INTERLOCK

Anod. Per. 100
Paint Per. 100



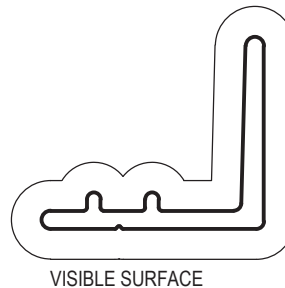
HD10
EXTENDED 7mm OFFSET
INTERLOCK

Anod. Per. 100
Paint Per. 100



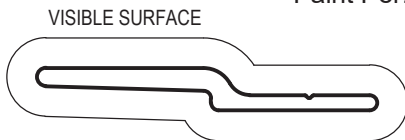
HD21
HEAVY DUTY
FLAT INTERLOCK

Anod. Per. 100
Paint Per. 100



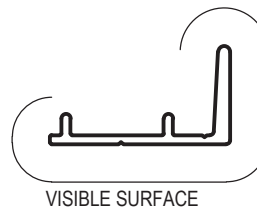
HD23
HEAVY DUTY
FRAME INTERLOCK

Anod. Per. 114
Paint Per. 114



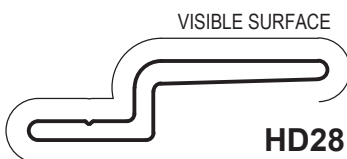
HD22
HEAVY DUTY
STEPPED INTERLOCK

Anod. Per. 100
Paint Per. 100



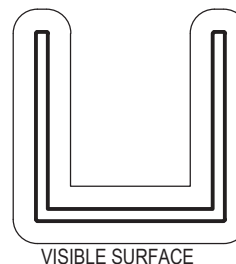
HD29
ALTITUDE / CARINYA
INTERLOCK

Anod. Per. 100
Paint Per. 100



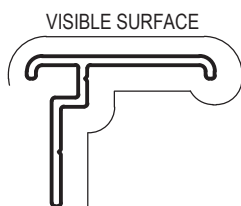
HD28
HEAVY DUTY
DEEP INTERLOCK

Anod. Per. 100
Paint Per. 100



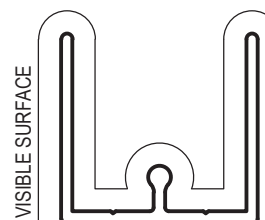
HD6
CHANNEL
25 x 25 x 1.6mm

Anod. Per. 146
Paint Per. 146



TM18
OFFSET T MULLION

Anod. Per. 100
Paint Per. 100

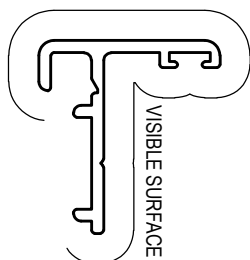


ST8
BOTTOM SLIDING
TRACK

Anod. Per. 160
Paint Per. 138

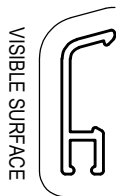
5. Extrusions

Invisi-Gard Frame



TM5
SECURITY
MULLION

Anod. Per. 126
Paint Per. 100



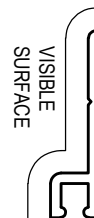
MF75
WEATHERSEAL
SNAP ON COVER

Anod. Per. 100
Paint Per. 100



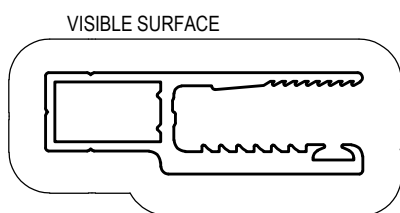
BS1
BUGSTRIP
SHORT LEG

Anod. Per. 100
Paint Per. 100



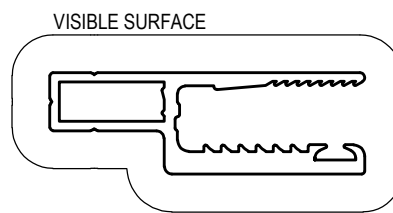
BS2
BUGSTRIP
LONG LEG

Anod. Per. 100
Paint Per. 100



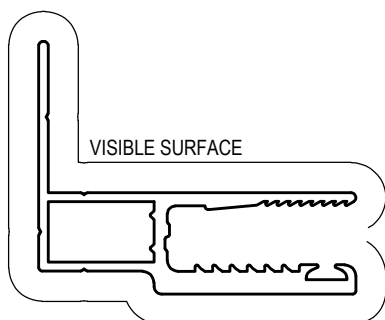
IWF1
INVISI WINDOW FRAME 11mm

Anod Per. 184
Paint Per. 103



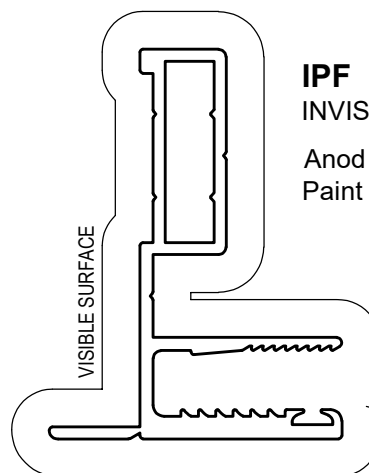
IWF2
INVISI WINDOW FRAME 9mm

Anod Per. 184
Paint Per. 102



IWF3
INVISI WINDOW FRAME WITH LEG

Anod Per. 225
Paint Per. 144

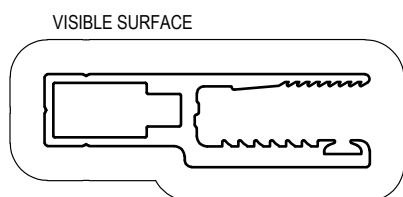


IPF
INVISI PATIO FRAME

Anod Per. 274
Paint Per. 274

5. Extrusions

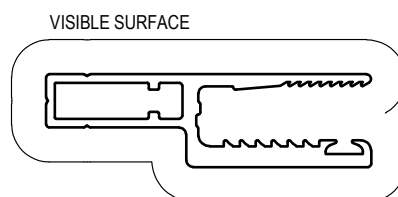
Invisi-Gard Frame



IWF1E

EXTENDED INVISI 11mm
WINDOW FRAME

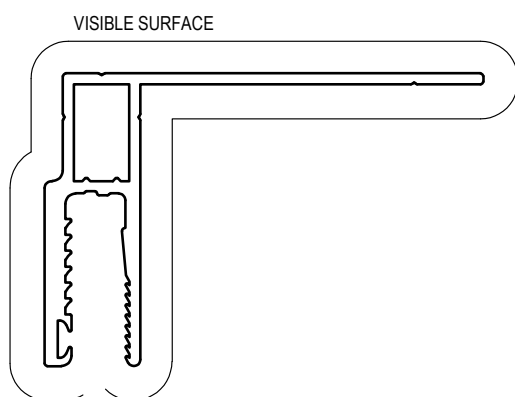
Anod Per. 194
Paint Per. 108



IWF2E

EXTENDED INVISI 9mm
WINDOW FRAME

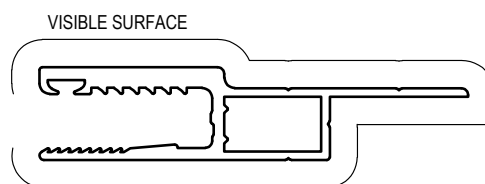
Anod Per. 195
Paint Per. 108



IWF3E

INVISI-GARD
50mm OFFSET

Anod Per. 285
Paint Per. 199



IWF1L

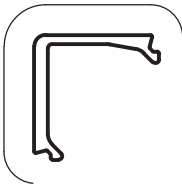
INVISI WINDOW FRAME
11mm WITH LEG

Anod Per. 224
Paint Per. 137

5. Extrusions

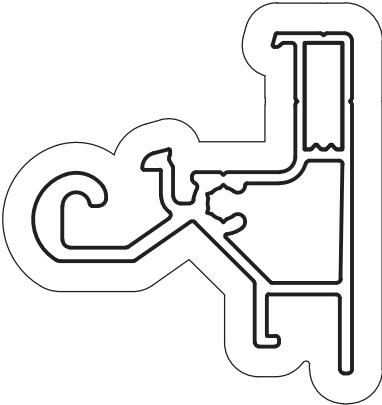
Invisi-Scape Frame

VISIBLE SURFACE



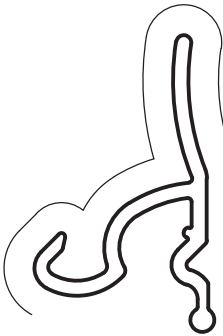
IWF12
FRAME INFILL
Anod Per. 100
Paint Per. 100

VISIBLE SURFACE



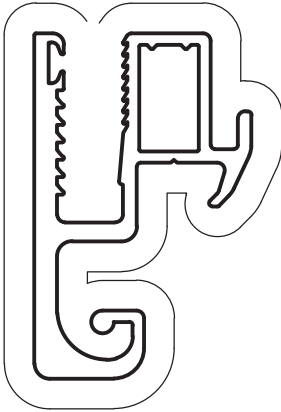
IWF11
PERIMETER HINGE FRAME
Anod Per. 240
Paint Per. 240

VISIBLE SURFACE



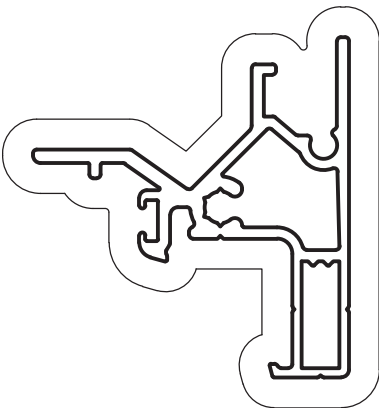
IWF15
ESCAPE HANDLE
Anod Per. 157
Paint Per. 100

VISIBLE SURFACE



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

VISIBLE SURFACE

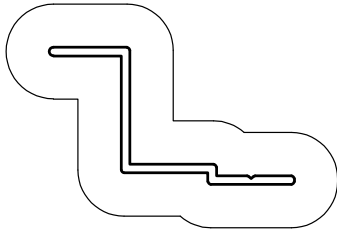


IWF10
PERIMETER FRAME
Anod Per. 232
Paint Per. 232

5. Extrusions

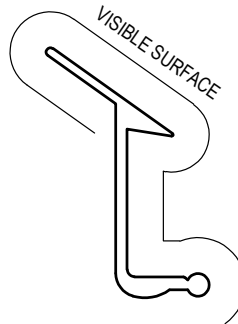
Invisi-Scape Frame

VISIBLE SURFACE



IH
INVISI HANDLE

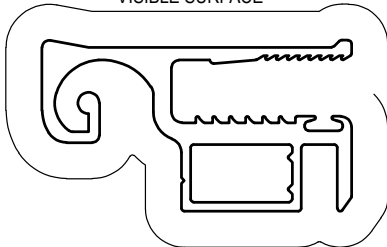
Anod Per. 105
Paint Per. 105



IOLH
IOLH INVISI I/O LOCK HDL

Anod Per. 113
Paint Per. 100

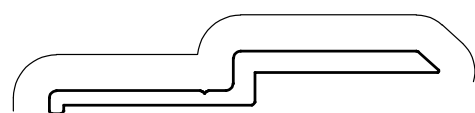
VISIBLE SURFACE



IOS
IOS INVISI I/O SASH

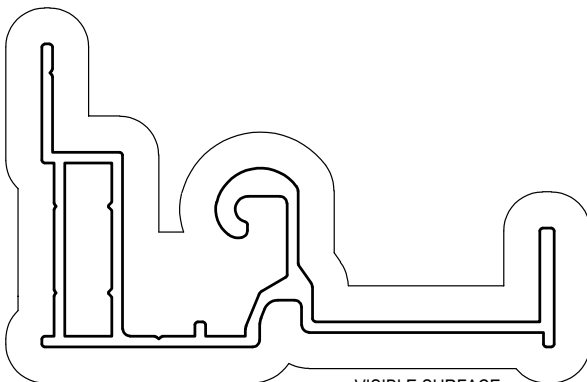
Anod Per. 260
Paint Per. 124

VISIBLE SURFACE



IDSAJA
INVISI I/O ANT JEM AD

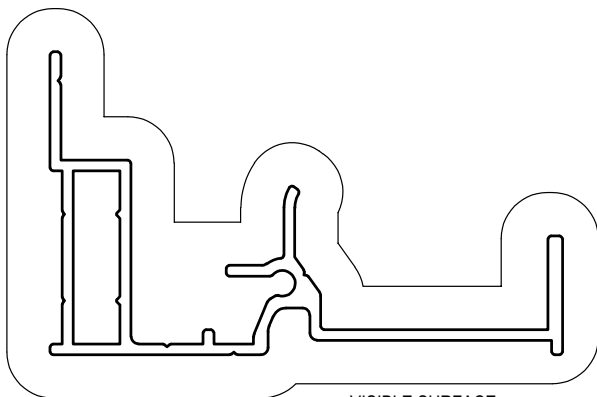
Anod Per. 122
Paint Per. 100



VISIBLE SURFACE

IOPHF
INVISI I/O HINGE FRAME

Anod Per. 336
Paint Per. 336



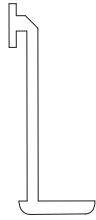
VISIBLE SURFACE

IIOPLF
INVISI I/O PER LOCK FR

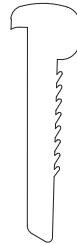
Anod Per. 325
Paint Per. 325

6. Hardware & Components

Accessories



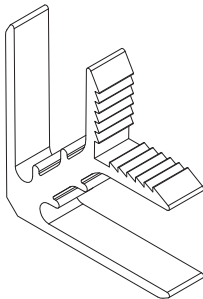
I11 INVISI INSULATOR x 100m	
PART	1409110
FINISH	BLACK (034)
QTY	ROLL (100m)



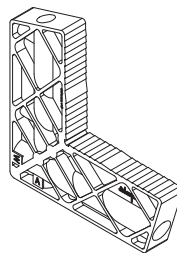
IW1 INVISI WEDGE x 4m (25L PER PKT)	
PART	1409105
FINISH	BLACK (034)
QTY	PACK (25 L/PACK)



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



P2 HEAVY DUTY SEC DOOR CORNER	
PART	1311211
FINISH	MILL (001)
QTY	EACH

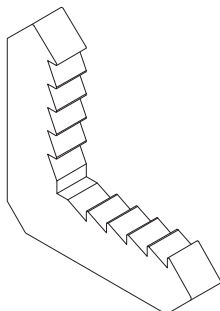


USE 1383206 10G x 16mm WAFER HEAD SCREW
IF USING TWIN BOLTS USE 1382017 8G x 9mm PAN HEAD SCREW

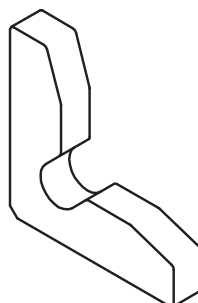
P3A NYLON CORNER STAKE WITH FLUSH BOLT HOLE x 1	
PART	1311243
FINISH	BLACK (034)
QTY	EACH



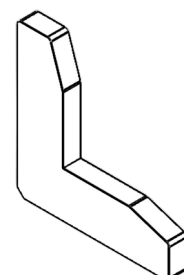
IMS INVISI MIDRAIL STAKE - BAG OF 50	
PART	1409100
FINISH	MILL (001)
QTY	BAG (50/BAG)



P5 SEC WINDOW CORNER	
PART	1311226
FINISH	NOT SPECIFIED (099)
QTY	EACH



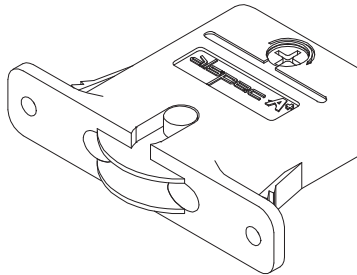
P5B STRAIGHT EDGE SEC WINDOW CORNER	
PART	1311229
FINISH	NOT SPECIFIED (099)
QTY	EACH



P13 CORNERS (SUITS SW3)	
PART	1311237
FINISH	NOT SPECIFIED (099)
QTY	EACH

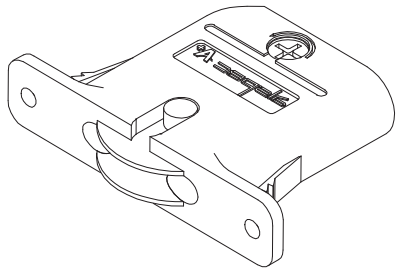
6. Hardware & Components

Accessories



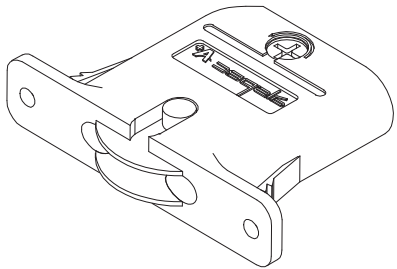
ALSPEC DUO-FIT SEC DOOR ROLLER SS BEARING 20kg

PART	1311900
FINISH	BLACK (034)
QTY	EACH



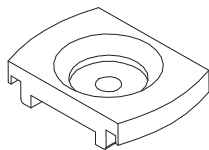
ALSPEC OFFSET SECURITY DOOR ROLLER 25kg

PART	1311904
FINISH	BLACK (034)
QTY	EACH



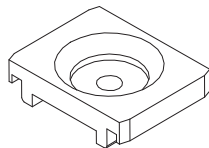
ALSPEC OFFSET SECURITY DOOR ROLLER SS 40kg

PART	1311905
FINISH	BLACK (034)
QTY	EACH



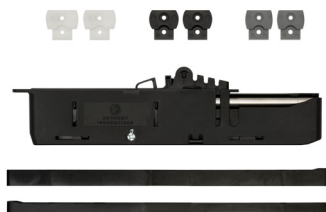
23.5mm ALSPEC SCREEN DOOR TOP GUIDE

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



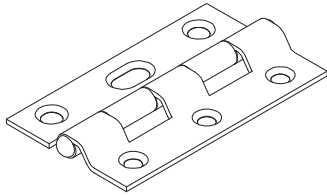
Note: Other colours available on request

INVENTCO 3S WATER DOOR CLOSER

PART	1311002
FINISH	BLACK (034)
QTY	EACH

6. Hardware & Components

Accessories



ALSPEC STEPPED SECURITY DOOR HINGE	
PART	1311051
FINISH	BLACK (034)
QTY	PAIR



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

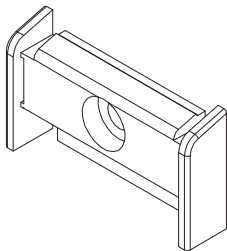
AUSTRAL STD SCREEN DOOR CLOSER	
PART	1308001
FINISH	BLACK (034)
QTY	EACH



W203817 SECURITY DOOR FLUSH BOLT 20mm	
PART	1301250
FINISH	BLACK (034)
QTY	EACH



AUSTRAL DOUBLE FLUSH BOLT FOR SECURITY DOORS	
PART	1308004
FINISH	BLACK (034)
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)

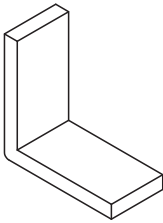
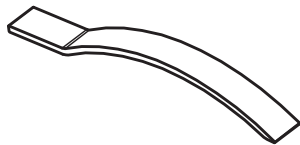
PS16 16mm FRINGE PILE x 100m	
PART	1377415
FINISH	BLACK (034)
QTY	ROLL (100m)

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

Accessories



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 PROTECTED WINDOW
REFER TO OCCUPANCY PERMIT
& FIRE ENGINEERING REPORT
FOR REPLACEMENT REQUIREMENTS
DO NOT REMOVE SCREEN

FIRE ATTENUATION LABEL 118 x 50 x 1mm	
PART	1300039
FINISH	RED ANODISED (0LS)
QTY	EACH

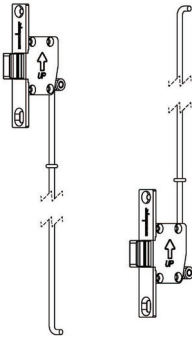
6. Hardware & Components



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

						
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

SL100 Compliant Lock Hardware - Hinged Door

	PART	DESCRIPTION	FINISH	QTY
	1332260	ASIM HINGED PROJECTION BOLT SEC LOCK	BLACK	EACH
	1332261	ASIM HINGED PROJECTION BOLT SEC LOCK	WHITE	EACH
	1332262	ASIM HINGED PROJECTION BOLT SEC LOCK	MONUMENT	EACH
	1332263	ASIM HINGED PROJECTION BOLT SEC LOCK	PRIMROSE	EACH
	1332264	ASIM HINGED PROJECTION BOLT SEC LOCK	WOODLAND GREY	EACH
	1332265	ASIM HINGED PROJECTION BOLT SEC LOCK	PAPERBARK	EACH
	1332266	ASIM HINGED PROJECTION BOLT SEC LOCK	SURFMIST	EACH
	1332267	ASIM HINGED PROJECTION BOLT SEC LOCK	WHITE BIRCH	EACH
	1332268	ASIM HINGED PROJECTION BOLT SEC LOCK	HAMM BROWN	EACH
	1332269	ASIM HINGED PROJECTION BOLT SEC LOCK	DUNE	EACH

	ROD TYPE		
	PART	DESCRIPTION	QTY
	1308012	ROD OPERATED MULTIPOINT KIT- H14R/H	EACH
	1308080	ROD OPERATED MULTIPOINT KIT- H14R/L	EACH
	1308863	ROD OPERATED MULTIPOINT KIT- H14R/P	EACH
	1308006	ADJUSTABLE ROD OPERATED MULTIPOINT KIT- H14R/A	EACH

	CABLE TYPE		
	PART	DESCRIPTION	QTY
	1308092	CABLE OPERATED MULTIPOINT KIT - EKIT/H	EACH
	1308099	CABLE OPERATED MULTIPOINT KIT - EKIT/H-ST150	EACH
	1308094	CABLE OPERATED MULTIPOINT KIT- EKIT/L	EACH
	1308091	CABLE OPERATED MULTIPOINT KIT- EKIT/P	EACH

Other rod lengths available,
contact your Local Alspec
Representative for more
information

Refer to page 6.11 for cylinders

6. Hardware & Components

SL100 Compliant Lock Hardware - Hinged Door



	PART	DESCRIPTION	FINISH	QTY
	1332280	ASIM HINGED HOOK BOLT SEC LOCK	BLACK	EACH
	1332281	ASIM HINGED HOOK BOLT SEC LOCK	WHITE	EACH
	1332282	ASIM HINGED HOOK BOLT SEC LOCK	MONUMENT	EACH
	1332283	ASIM HINGED HOOK BOLT SEC LOCK	PRIMROSE	EACH
	1332284	ASIM HINGED HOOK BOLT SEC LOCK	WOODLAND GREY	EACH
	1332285	ASIM HINGED HOOK BOLT SEC LOCK	PAPERBARK	EACH
	1332286	ASIM HINGED HOOK BOLT SEC LOCK	SURFMIST	EACH
	1332287	ASIM HINGED HOOK BOLT SEC LOCK	WHITE BIRCH	EACH
	1332288	ASIM HINGED HOOK BOLT SEC LOCK	HAMM BROWN	EACH
	1332289	ASIM HINGED HOOK BOLT SEC LOCK	DUNE	EACH

	CABLE TYPE		
	PART	DESCRIPTION	QTY
	1308097	CABLE OPERATED MULTIPOINT KIT (STRAIGHT BOLT) UKIT/H	EACH
	1308098	CABLE OPERATED MULTIPOINT KIT (STRAIGHT BOLT) UKIT/L	EACH
	1308121	CABLE OPERATED MULTIPOINT KIT (STRAIGHT BOLT) UKIT/P	EACH

	CABLE TYPE		
	PART	DESCRIPTION	QTY
	1308163	CABLE OPERATED MULTIPOINT KIT (PIVOTING BOLT) DH16/H	EACH
	1308162	CABLE OPERATED MULTIPOINT KIT (PIVOTING BOLT) DH16/L	EACH
	1308161	CABLE OPERATED MULTIPOINT KIT (PIVOTING BOLT) DH16/P	EACH

Other rod lengths available,
contact your Local Alspec
Representative for more
information

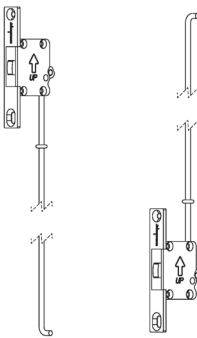
Refer to page 6.11 for cylinders

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

						
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 - Sliding Door



	PART	DESCRIPTION	FINISH	QTY
	1332290	ASIM SLIDING SEC LOCK	BLACK	EACH
	1332291	ASIM SLIDING SEC LOCK	WHITE	EACH
	1332292	ASIM SLIDING SEC LOCK	MONUMENT	EACH
	1332293	ASIM SLIDING SEC LOCK	PRIMROSE	EACH
	1332294	ASIM SLIDING SEC LOCK	WOODLAND GREY	EACH
	1332295	ASIM SLIDING SEC LOCK	PAPERBARK	EACH
	1332296	ASIM SLIDING SEC LOCK	SURFMIST	EACH
	1332297	ASIM SLIDING SEC LOCK	WHITE BIRCH	EACH
	1332298	ASIM SLIDING SEC LOCK	HAMM BROWN	EACH
	1332299	ASIM SLIDING SEC LOCK	DUNE	EACH

	ROD TYPE		
	PART	DESCRIPTION	QTY
	1308014	ROD OPERATED MULTIPOINT KIT - S14R/H	EACH
	1308015	ROD OPERATED MULTIPOINT KIT - S14R/L	EACH
	1308013	ROD OPERATED MULTIPOINT KIT - S14R/P	EACH
	1308028	ROD OPERATED MULTIPOINT KIT - S14R/A	EACH

	CABLE TYPE		
	PART	DESCRIPTION	QTY
	1308441	CABLE OPERATED MULTIPOINT KIT - SD14PLUS/H	EACH
	1308443	CABLE OPERATED MULTIPOINT KIT - SD14PLUS/L	EACH
	1308442	CABLE OPERATED MULTIPOINT KIT - SD14PLUS/P	EACH

Other rod lengths available,
contact your Local Alspec
Representative for more
information

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



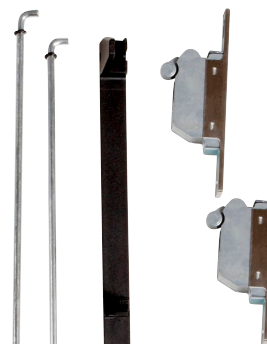
8654 STD 3 POINT KIT

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 Alspec Representative for more information
Refer to page 6.11 for cylinders

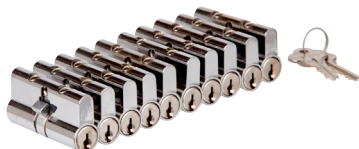
6. Hardware & Components

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

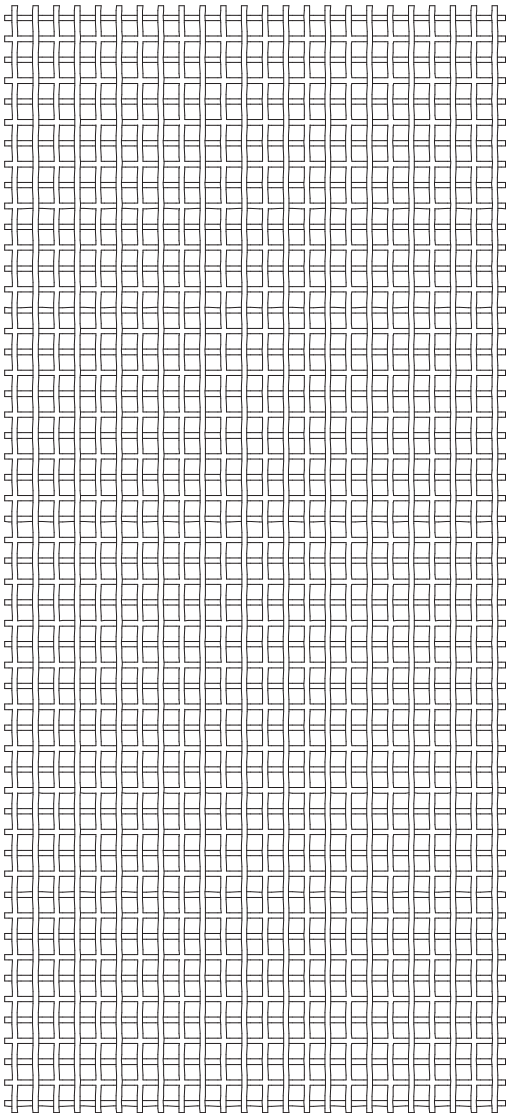
SCREWS		
PART #	DESCRIPTION	LOCATION
1382026	10g x 1/2 (13mm) SS PHILLIPS U/CUT SELF TAPPING x 1000	DOOR CORNER STAKE
1382054	10g x 1 (25mm) SS PHIL PAN S/TAP SCREW x 500	INVISI-SCAPE FRAME

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

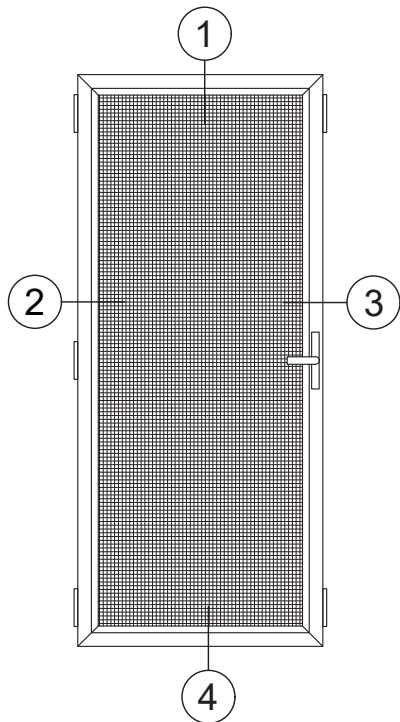
6. Hardware & Components

Mesh Sizes

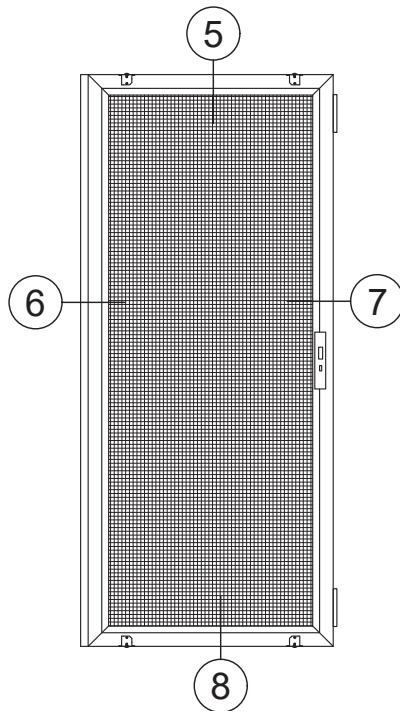


316 STAINLESS STEEL MESH (0.8mm) SATIN BLACK		
SIZE	PACK QTY.	PART NO.
750 x 2000	5	1409200
	50	1409201
750 x 2400	5	1409220
	50	1409221
750 x 3000	5	1409240
	50	1409241
900 x 2000	5	1409205
	50	1409206
900 x 2400	5	1409225
	50	1409226
900 x 3000	3	1409245
1200 x 2000	5	1409210
	50	1409211
1200 x 2400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

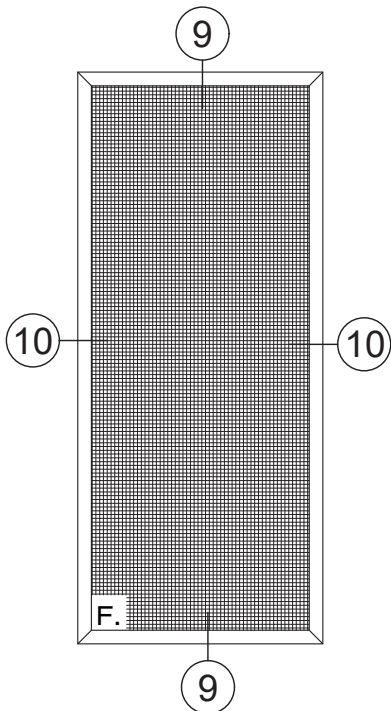
HINGED DOOR SCREEN



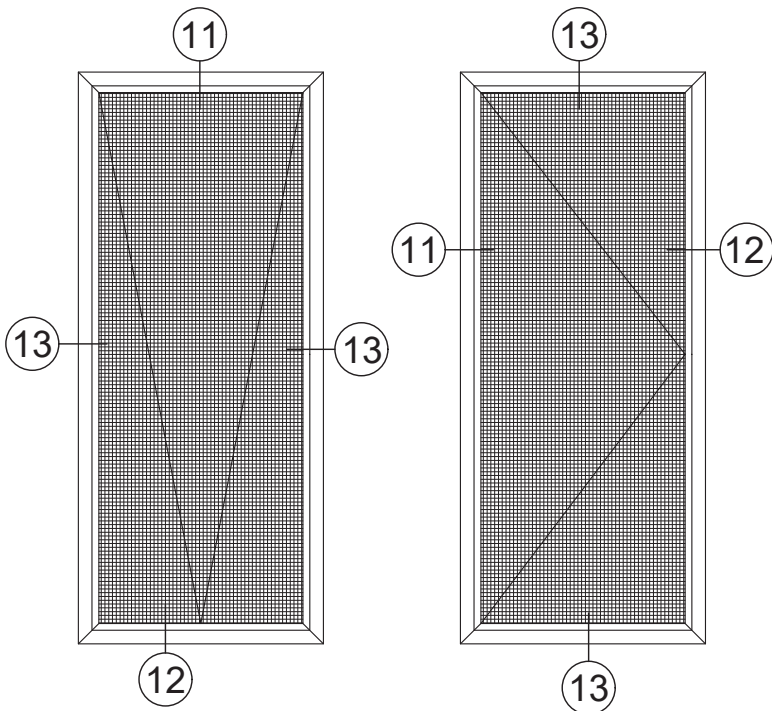
SLIDING DOOR SCREEN



WINDOW SCREEN

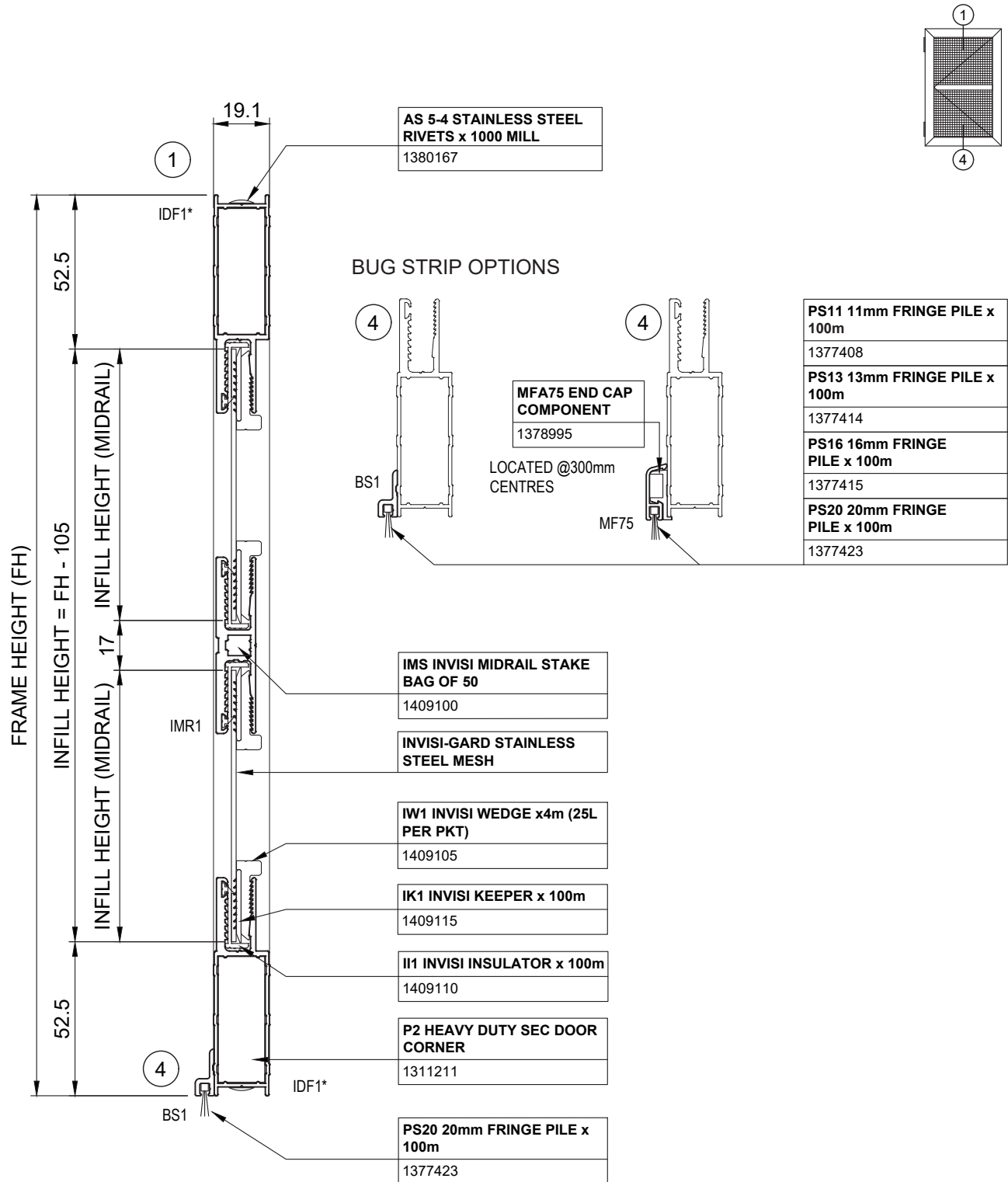


INVISI-SCAPE SCREENS



8. Typical Details

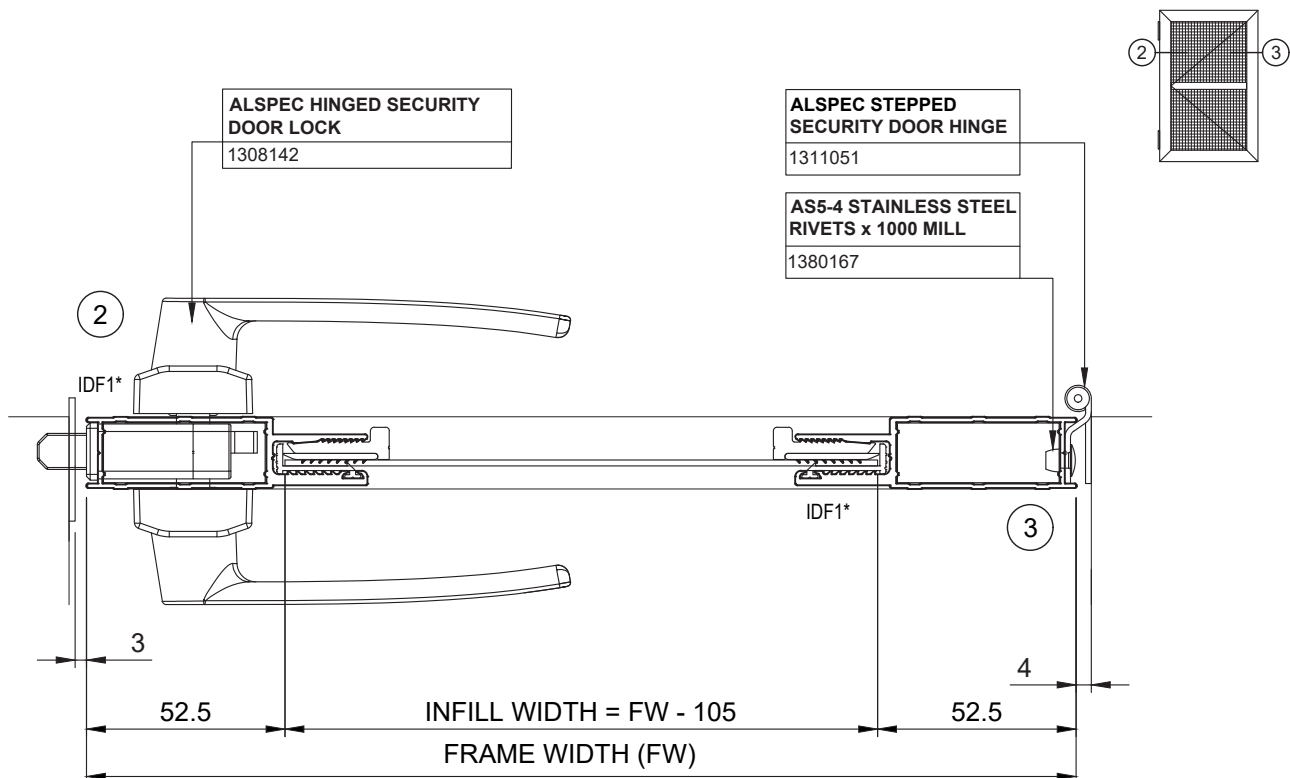
Hinged Door - Side Detail



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

8. Typical Details

Hinged Door - Top Detail

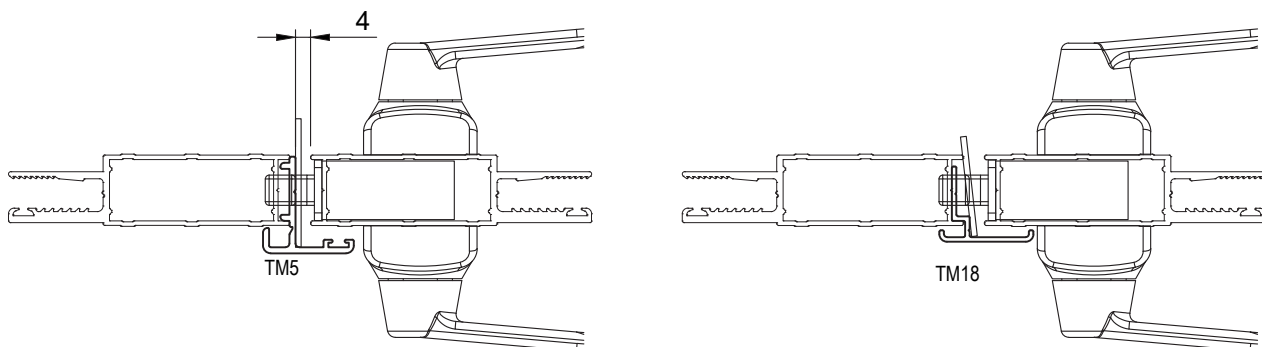


** MAX DISTANCE BETWEEN THE DOOR AND THE FRAME AT THE LOCKING POINTS SHALL NOT BE GREATER THAN 3mm.

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

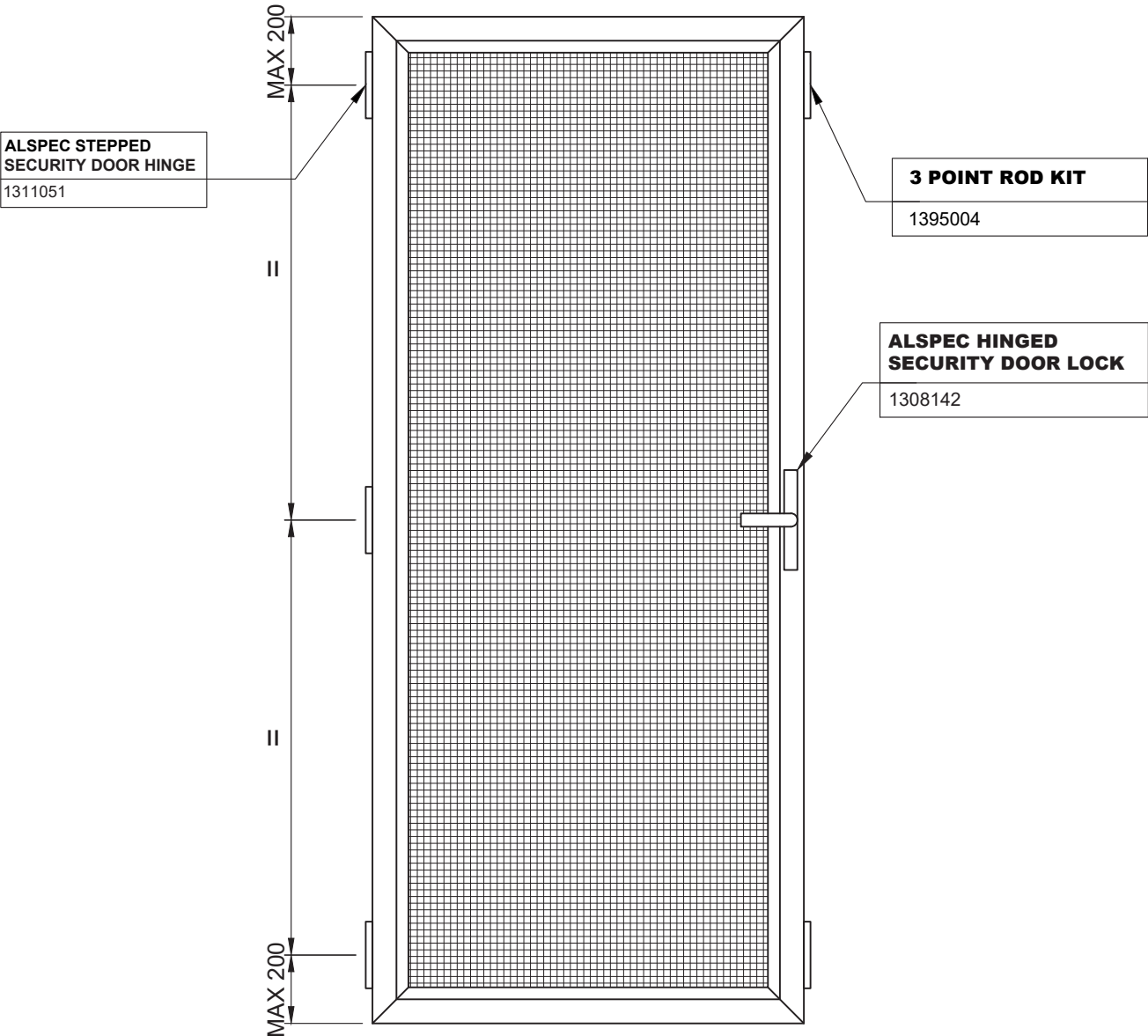
ALL OTHER POINTS, THE DISTANCE SHALL NOT BE GREATER THAN 5mm. SILL CLEARANCE ONLY MAY EXCEED 5mm TO COMPENSATE FOR IRREGULARITIES IN THE FLOOR OR DOORSTEP

FRENCH/DOUBLE DOOR ADAPTORS



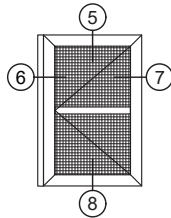
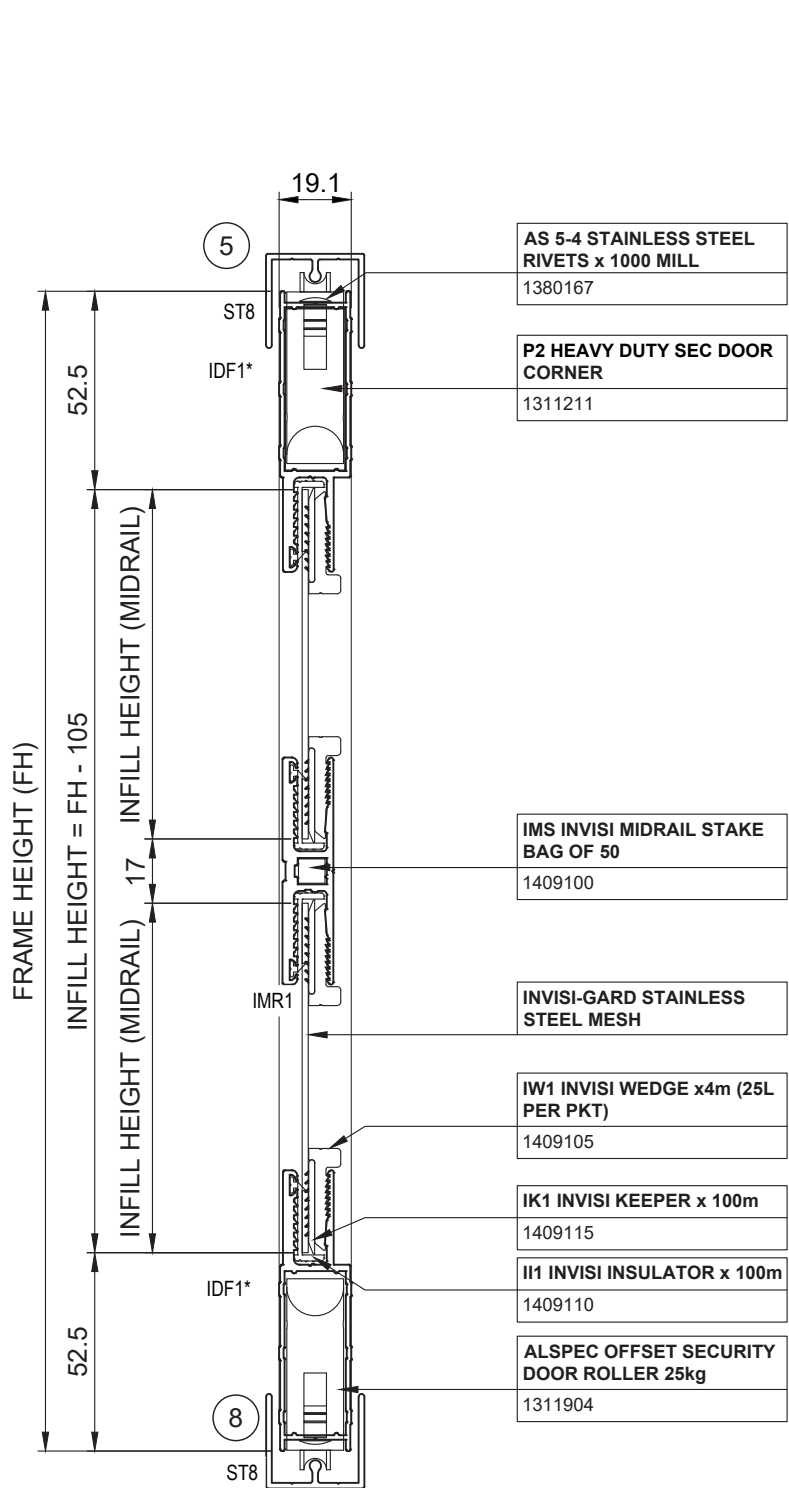
8. Typical Details

Hinged Door - Hardware Layout & Locking Points



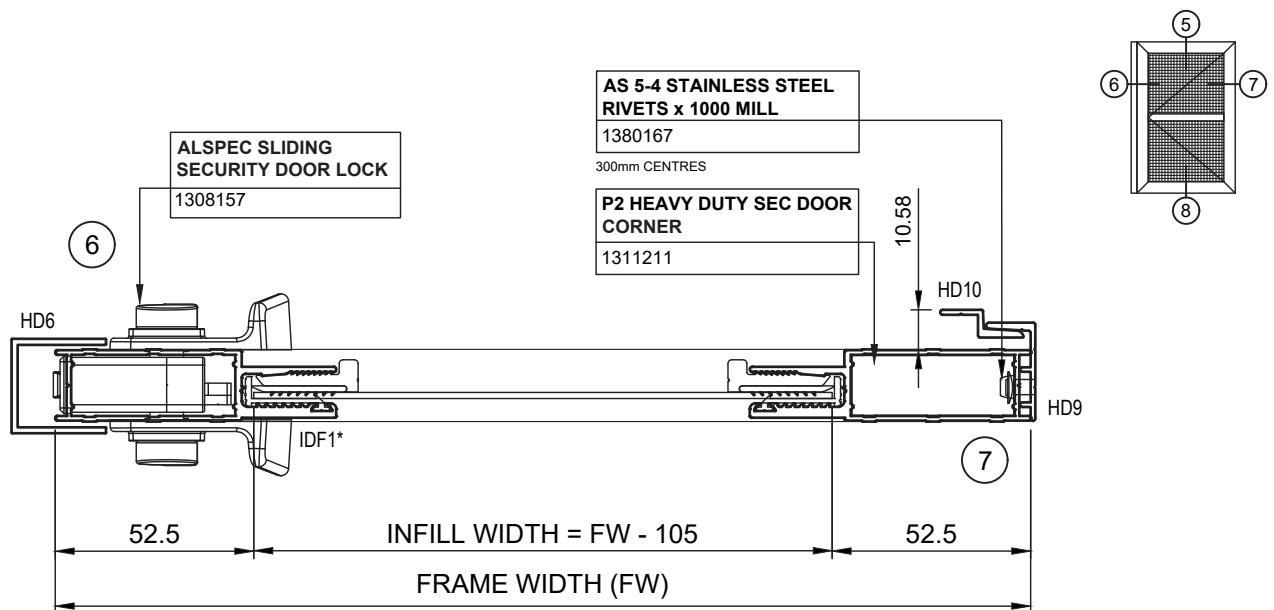
8. Typical Details

Sliding Door - Top Detail



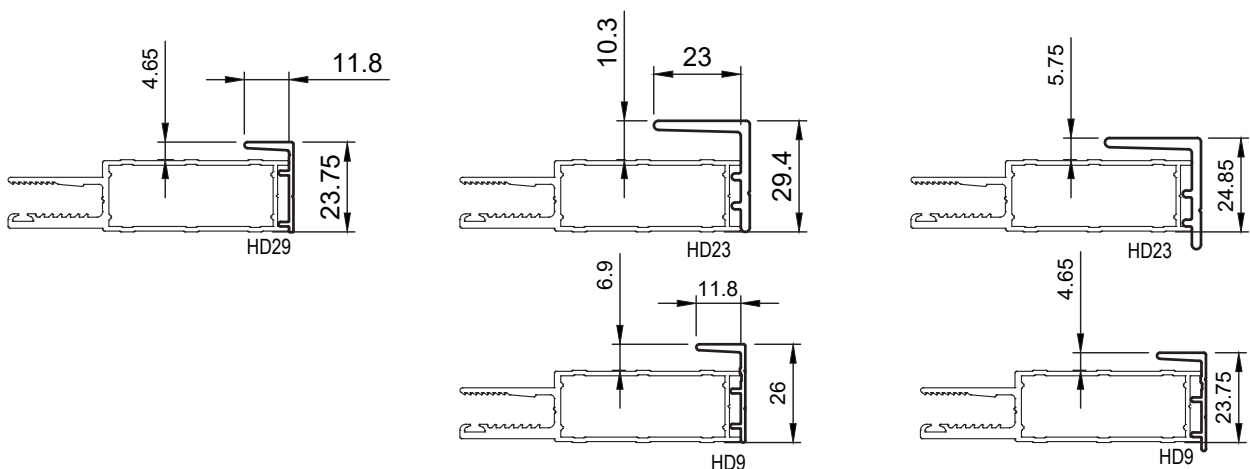
8. Typical Details

Sliding Door - Side Detail

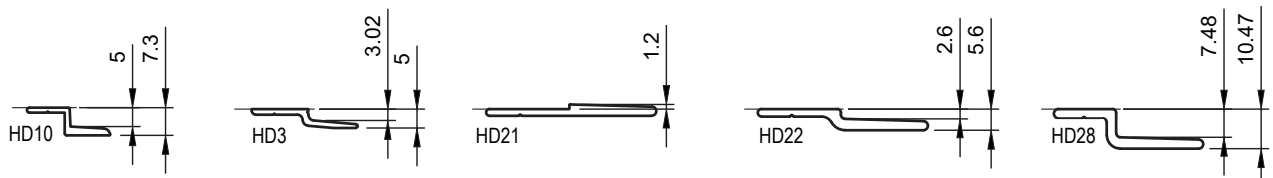


* OTHER FRAME SECTIONS ALSO AVAILABLE, REFER TO INVISI-GARD WALL CHART OR CONTACT YOUR LOCAL ALSPEC DEALER FOR MORE INFORMATION

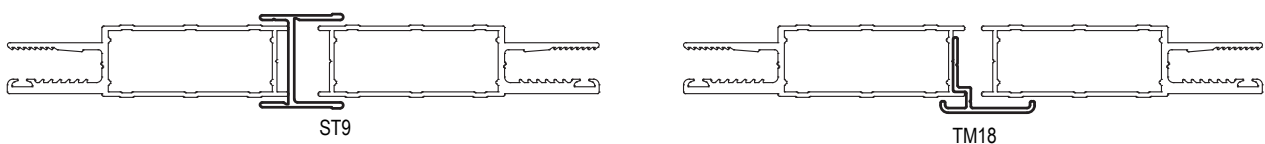
FRAME INTERLOCK OPTIONS



RETURN INTERLOCK OPTIONS

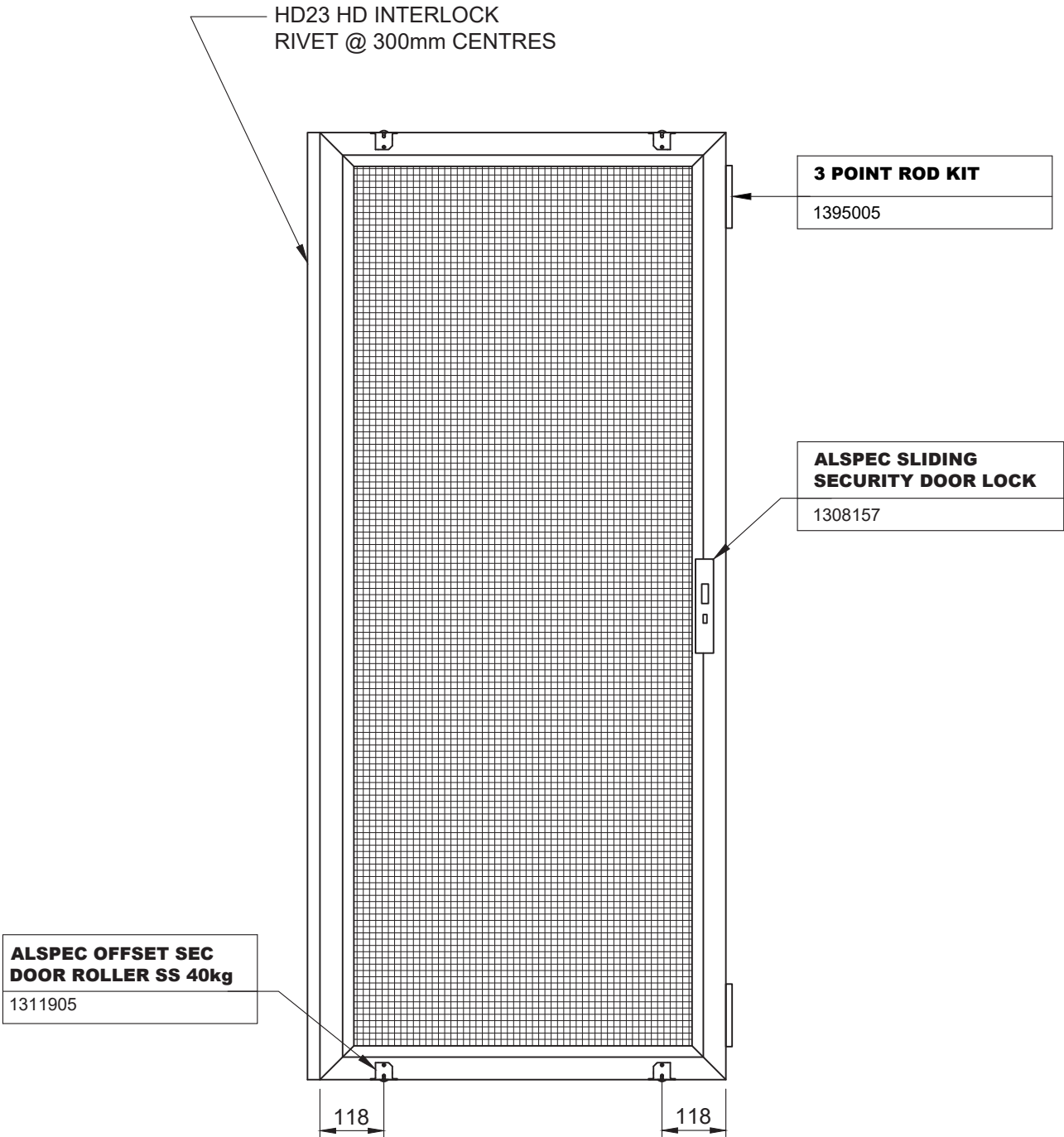


MEETING ADAPTORS



8. Typical Details

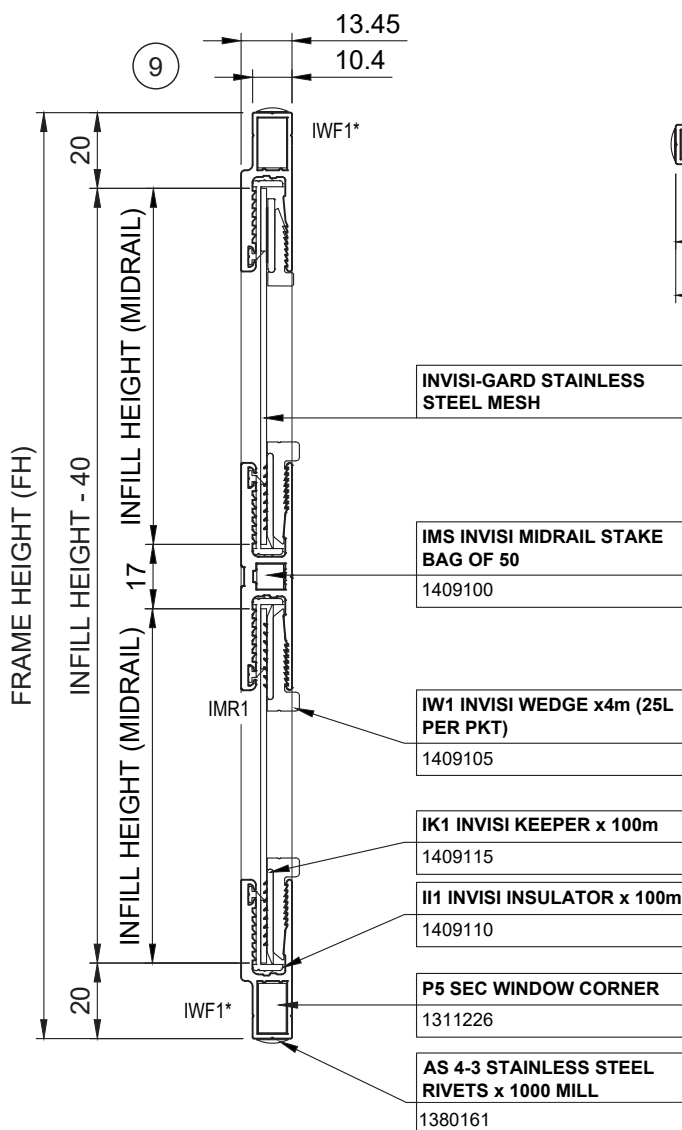
Sliding Door - Hardware Layout & Locking Points



8. Typical Details

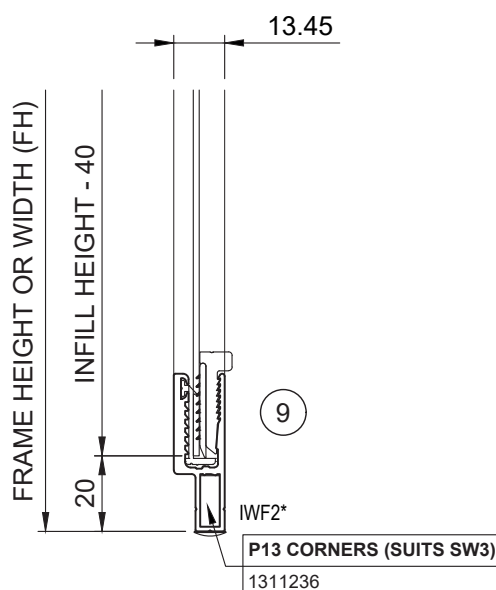
Window Screen

IWF1 11mm FRAME

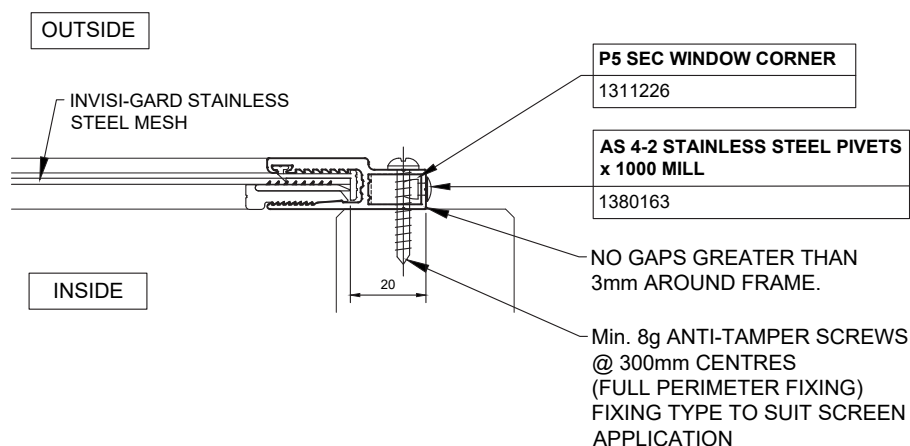


* OTHER FRAME SECTIONS ALSO AVAILABLE, REFER TO INVISI-GARD WALL CHART OR CONTACT YOUR LOCAL ALSPEC DEALER FOR MORE INFORMATION

IWF2 9mm FRAME



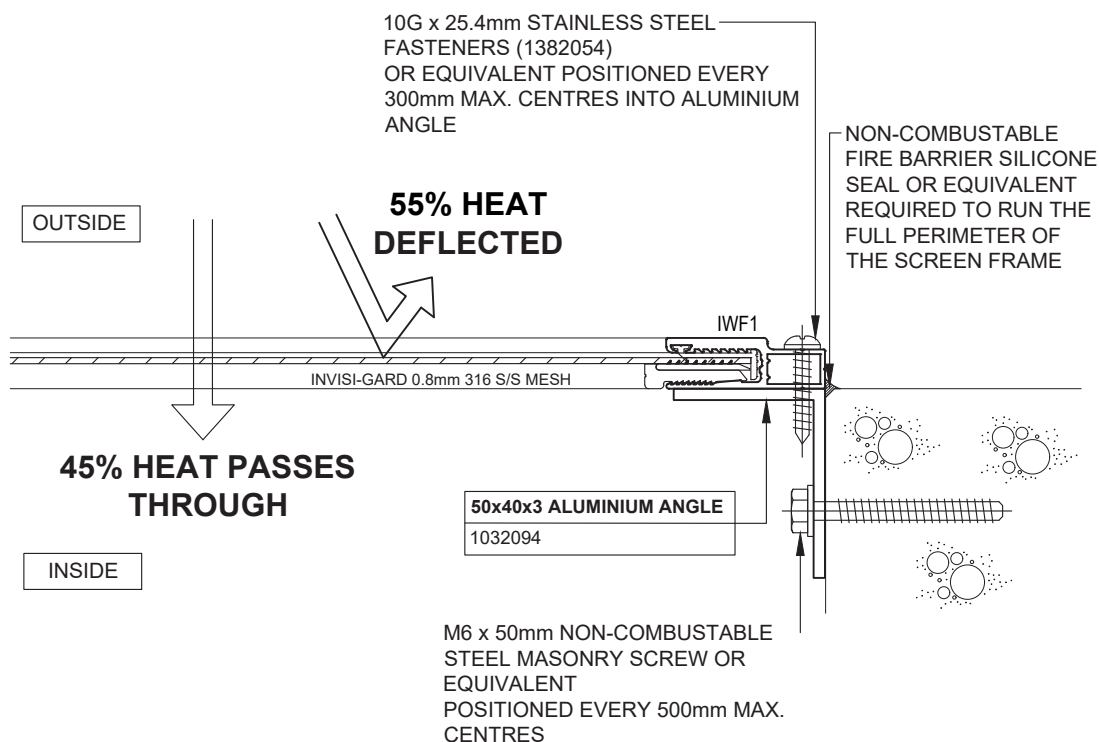
TYPICAL SCREEN WINDOW INSTALLATION



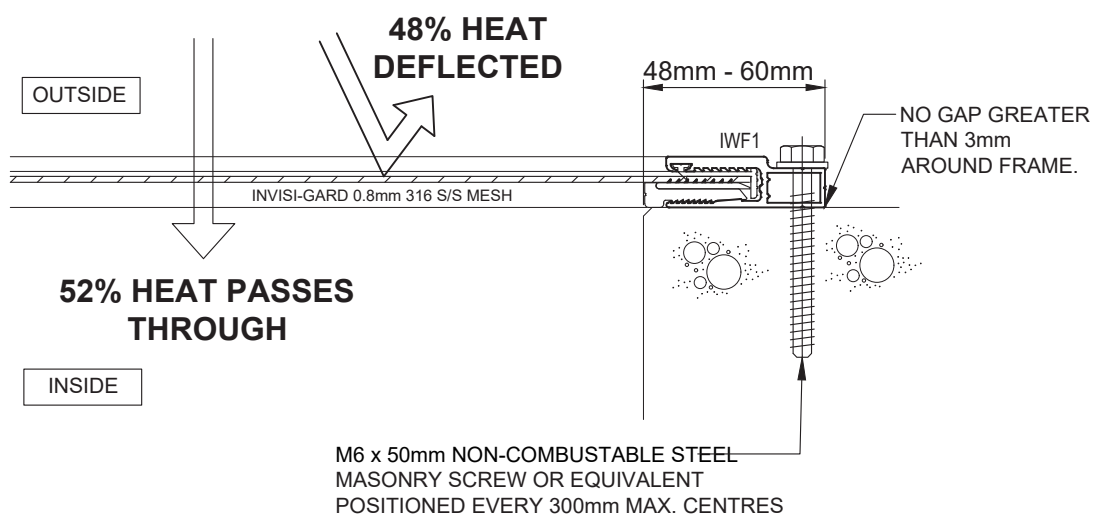
8. Typical Details

Typical Fixed Fire Attenuation Screen Installation

TEST REPORT: 52577300a



TEST REPORT: 52577300b

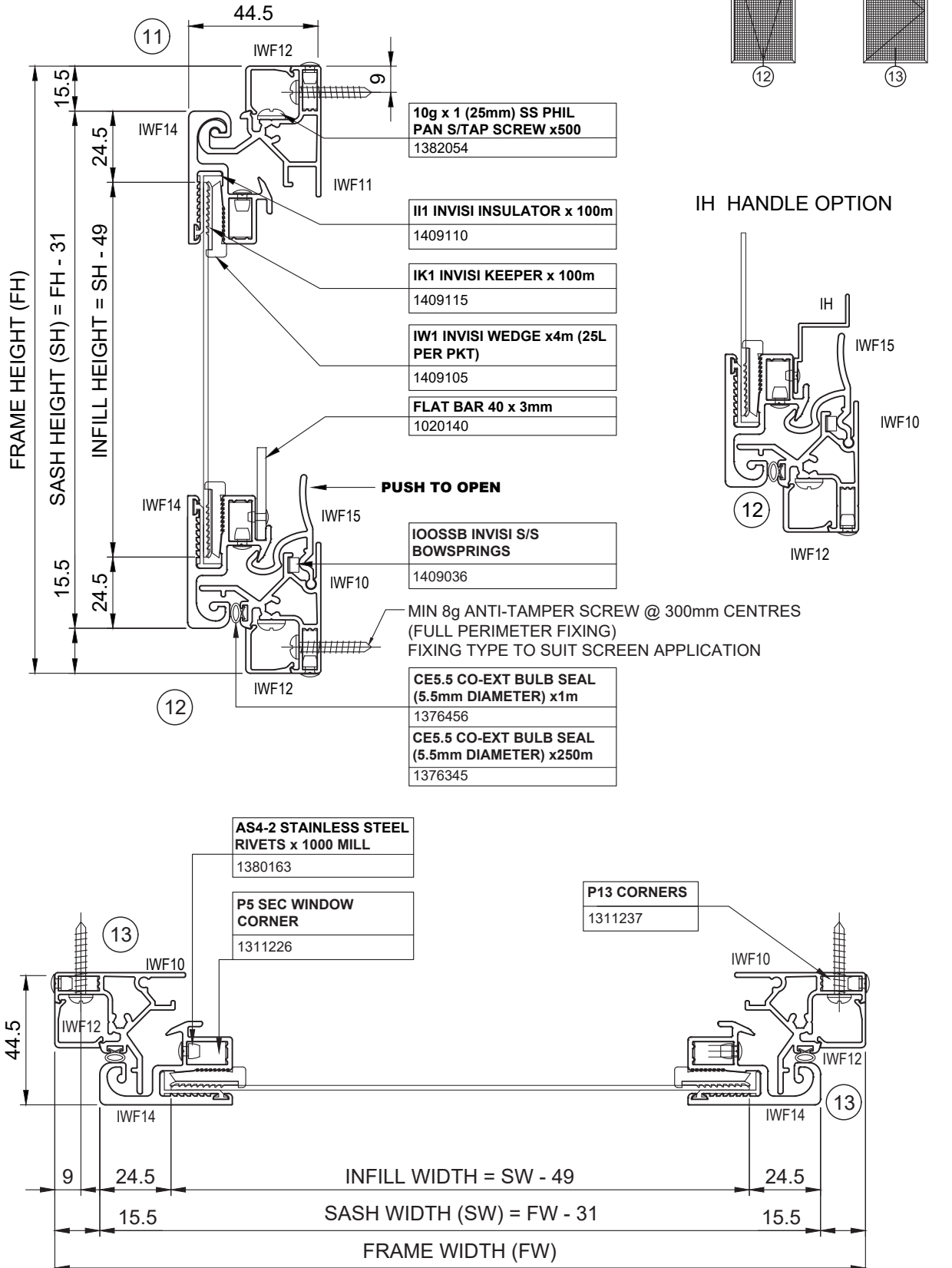




8. Typical Details

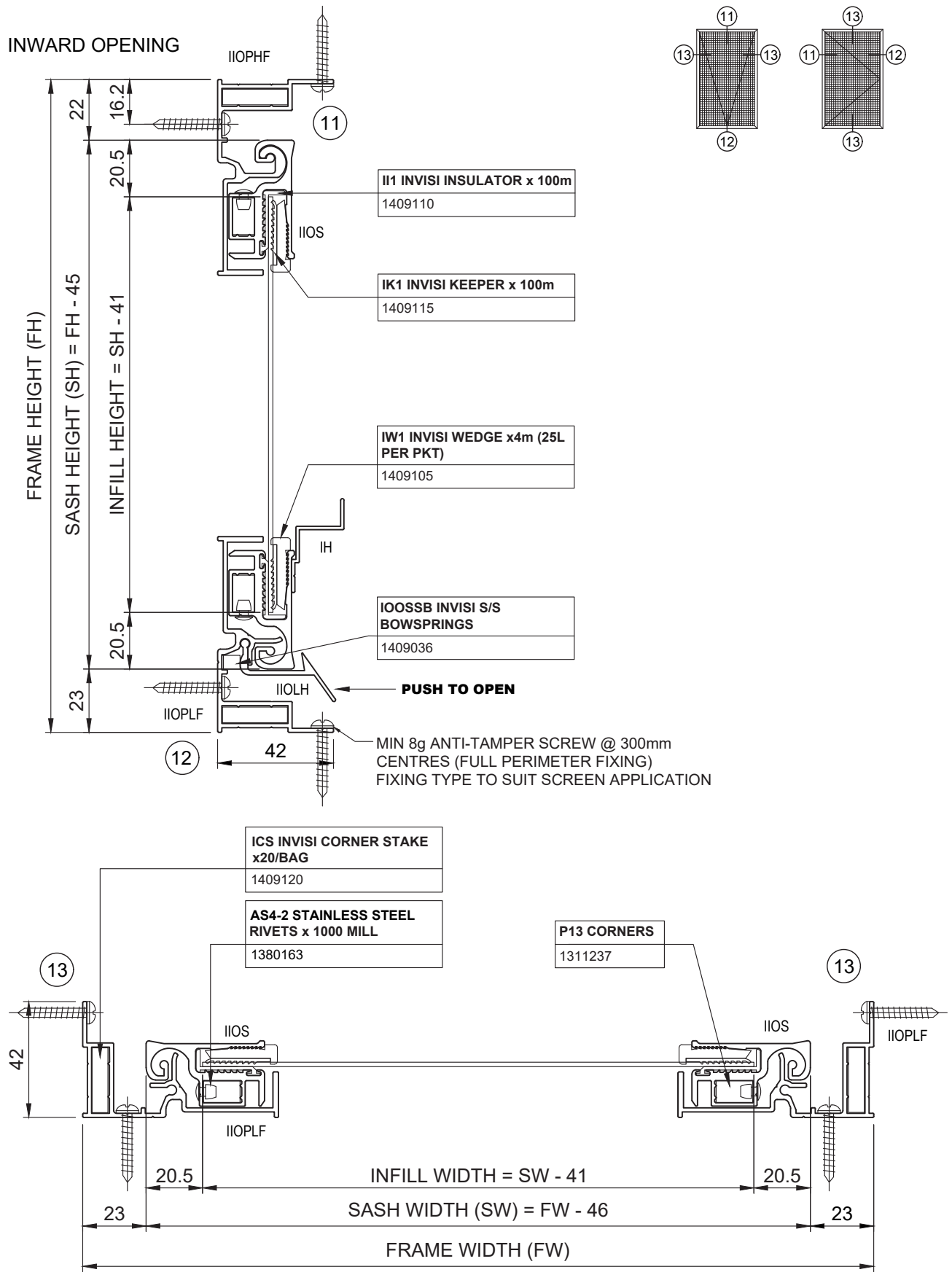
Escape Screen - Open Out

OUTWARD OPENING



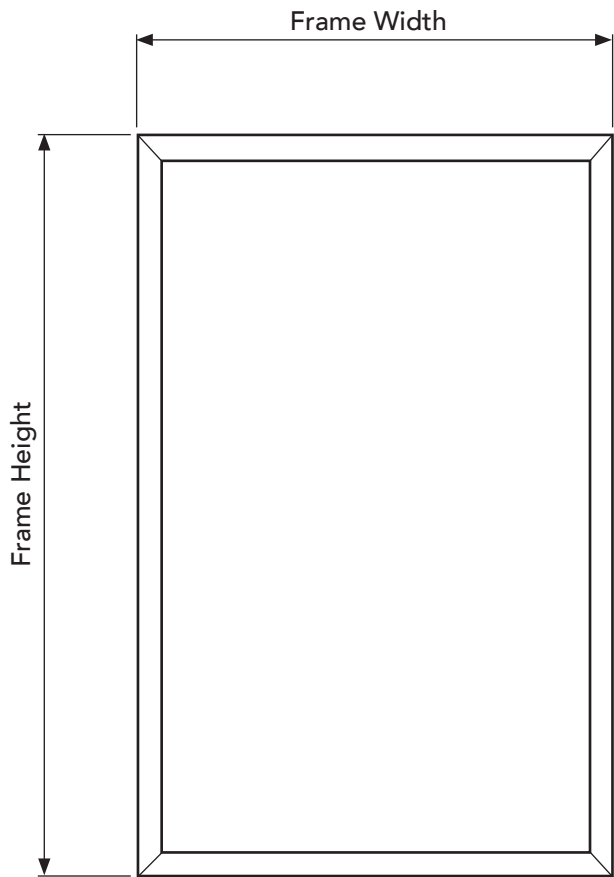
8. Typical Details

Escape Screen - Open In



9. Cutting Formulas

Hinged / Sliding Door



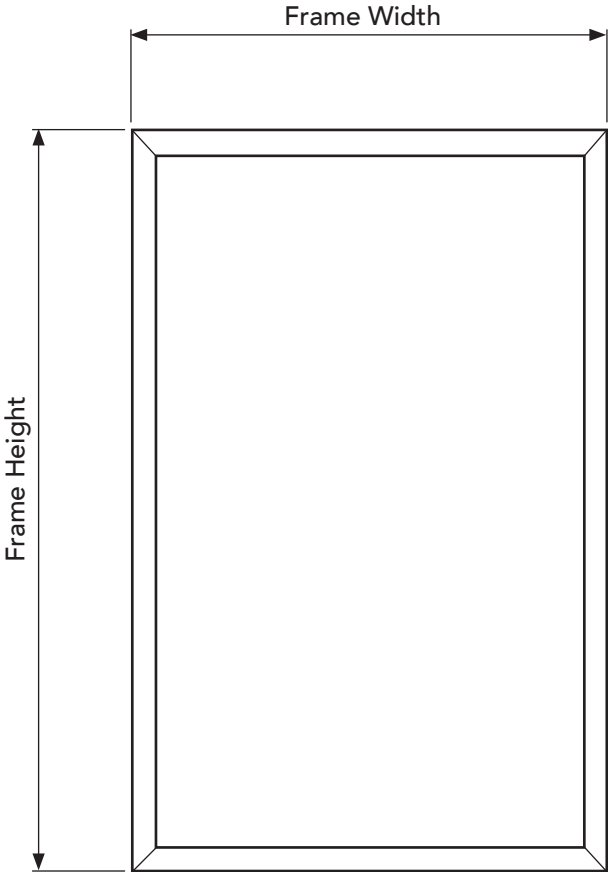
* Mitre cut

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



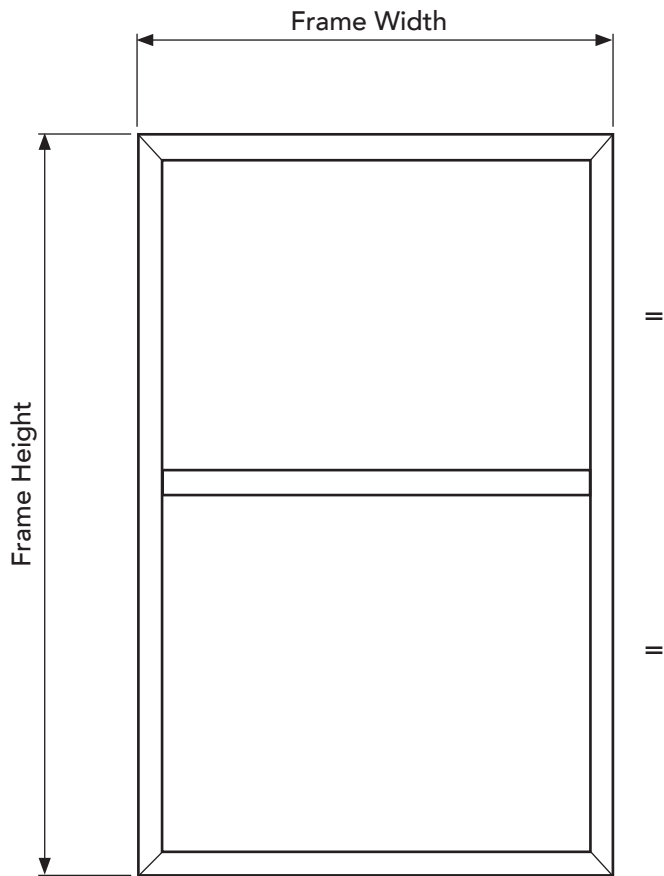
* Mitre cut

	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



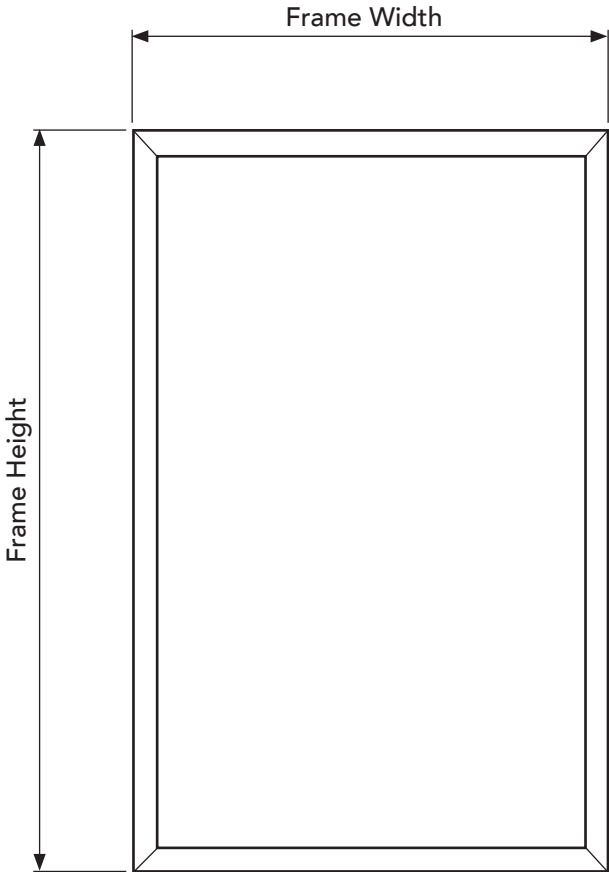
* Mitre cut

	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



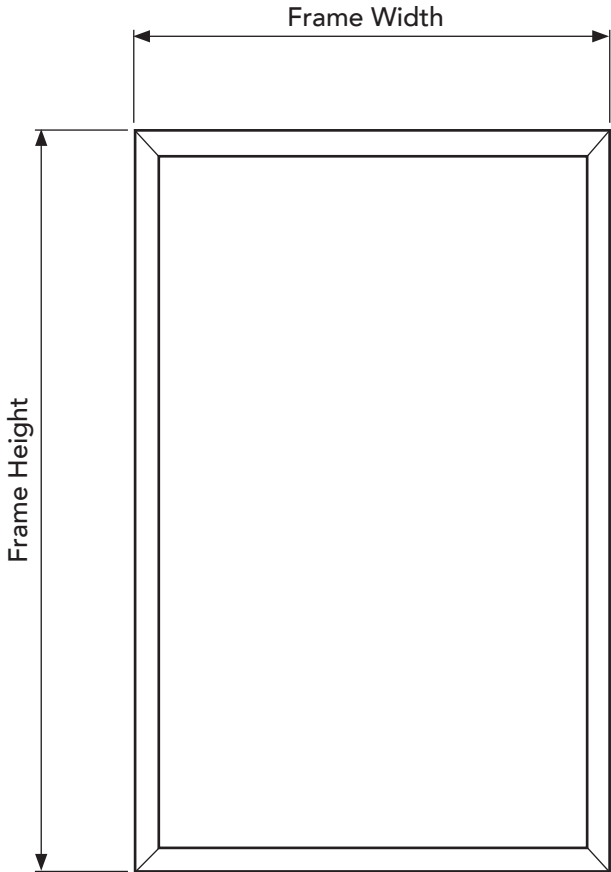
* Mitre cut

	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



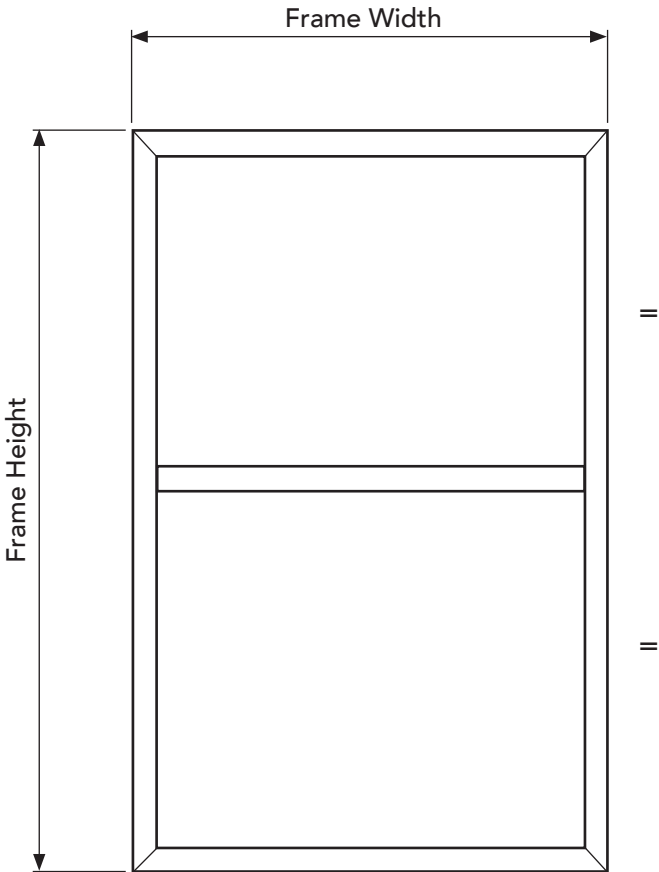
* Mitre cut

	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



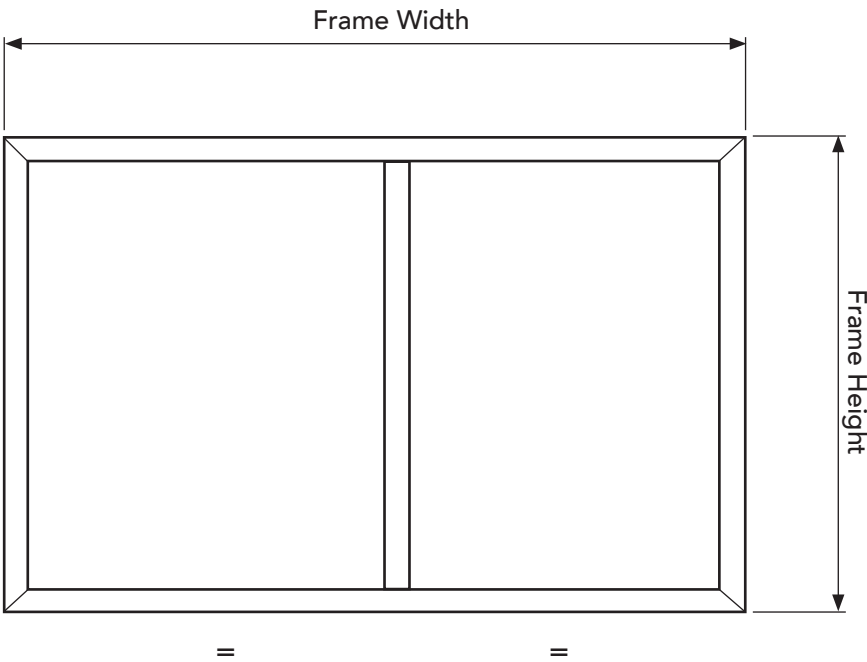
* Mitre cut

	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



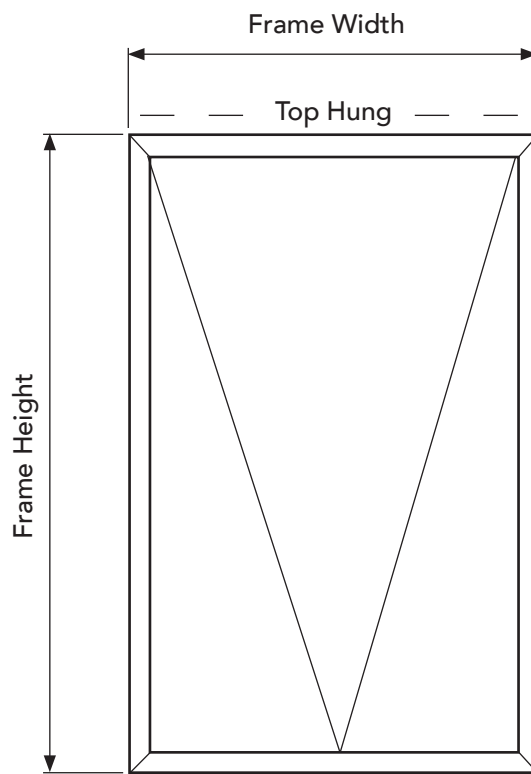
* Mitre cut

	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



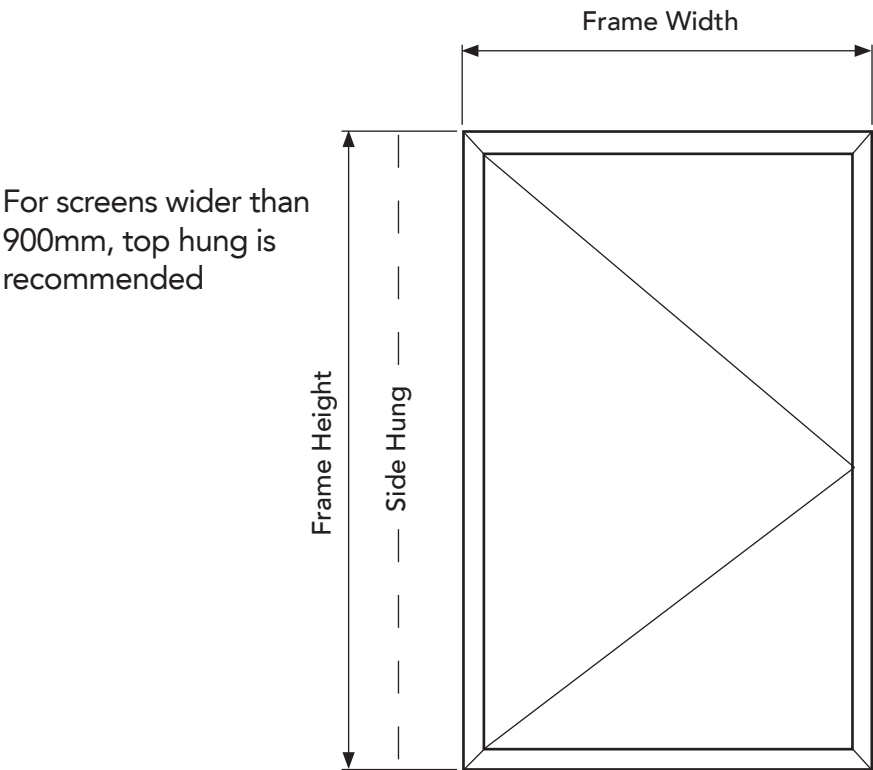
* Mitre cut

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



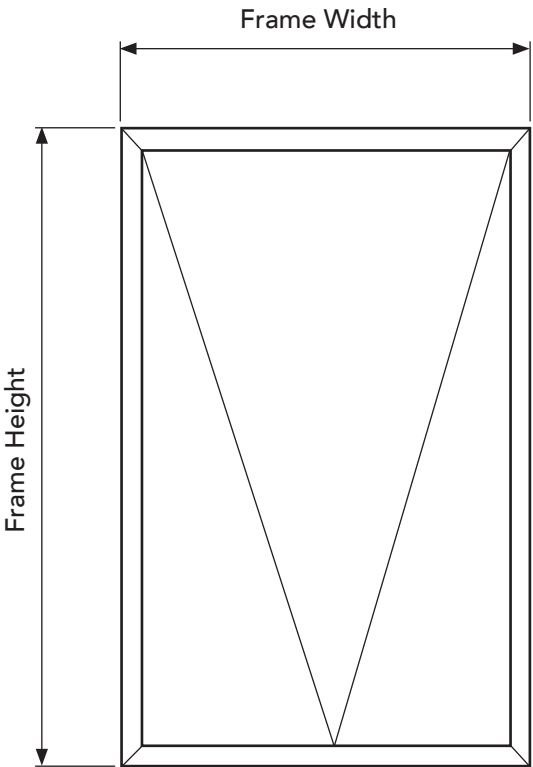
* Mitre cut

	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



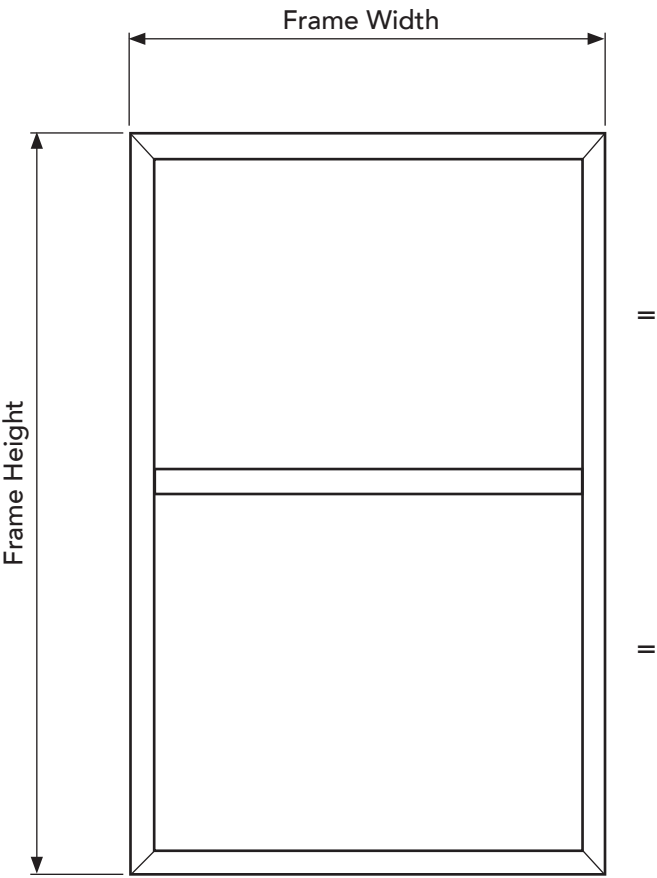
* Mitre cut

	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



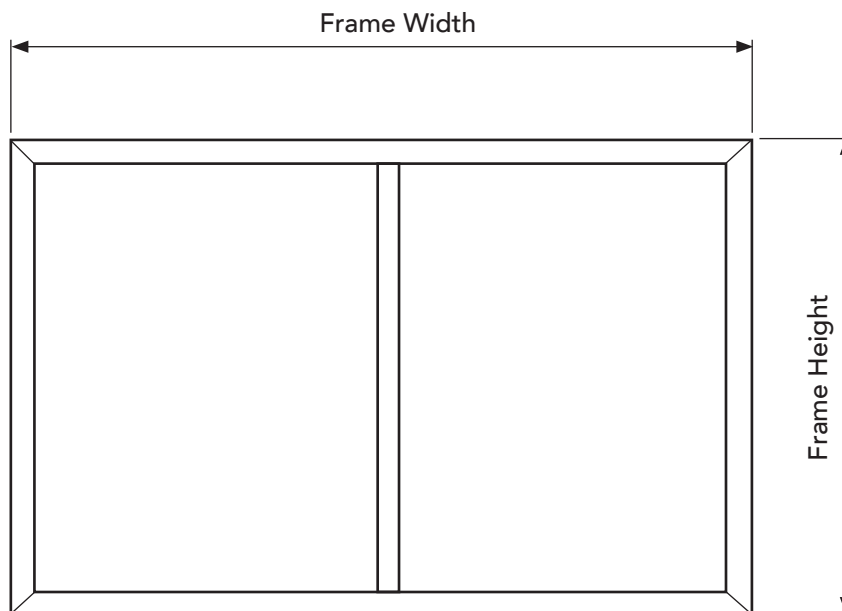
* Mitre cut

	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



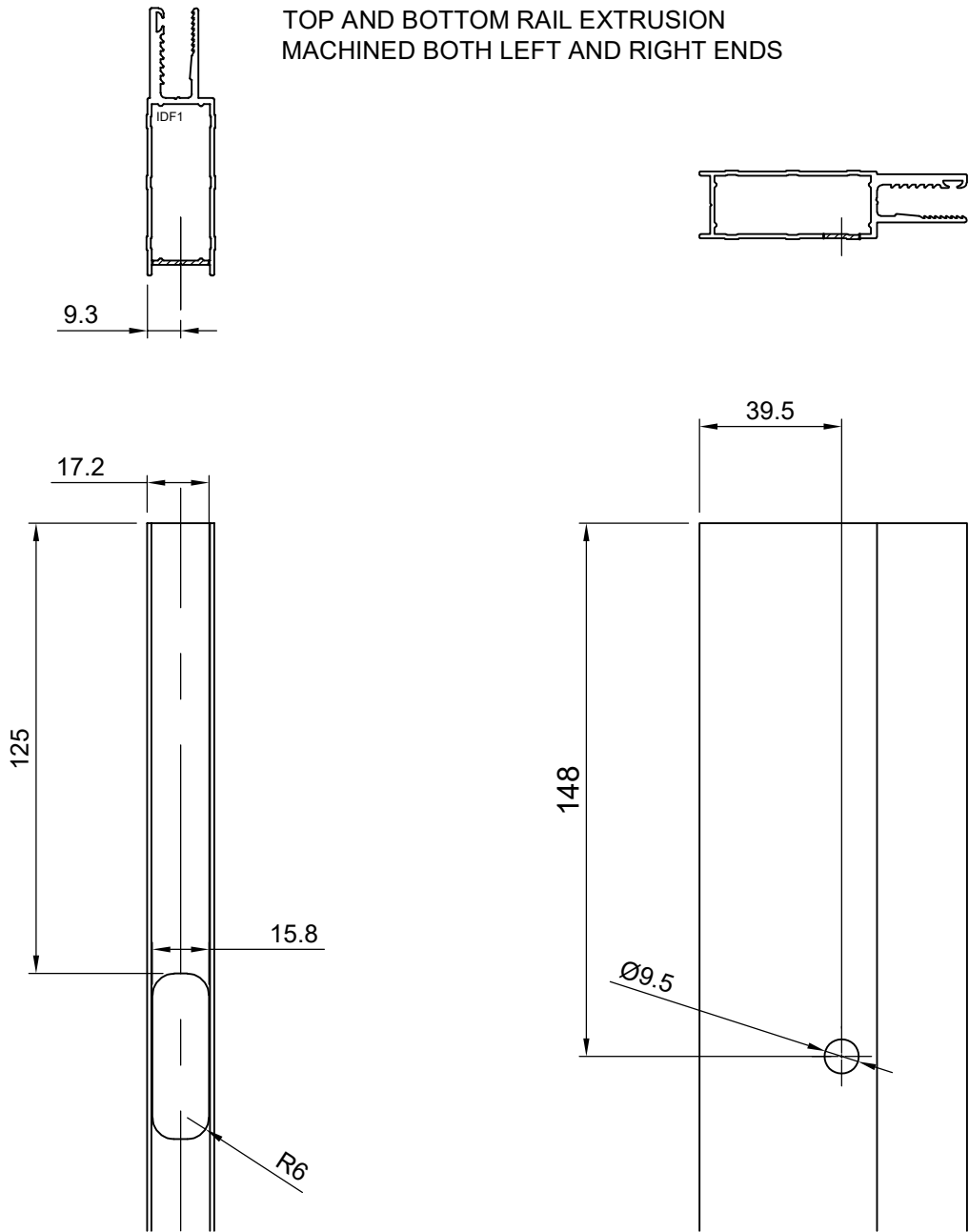
* Mitre cut

	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.

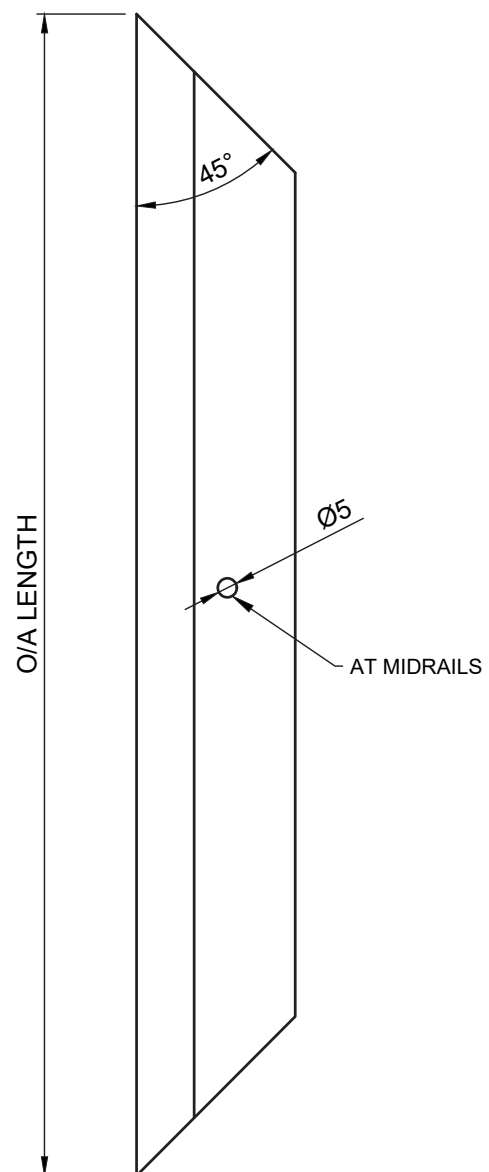
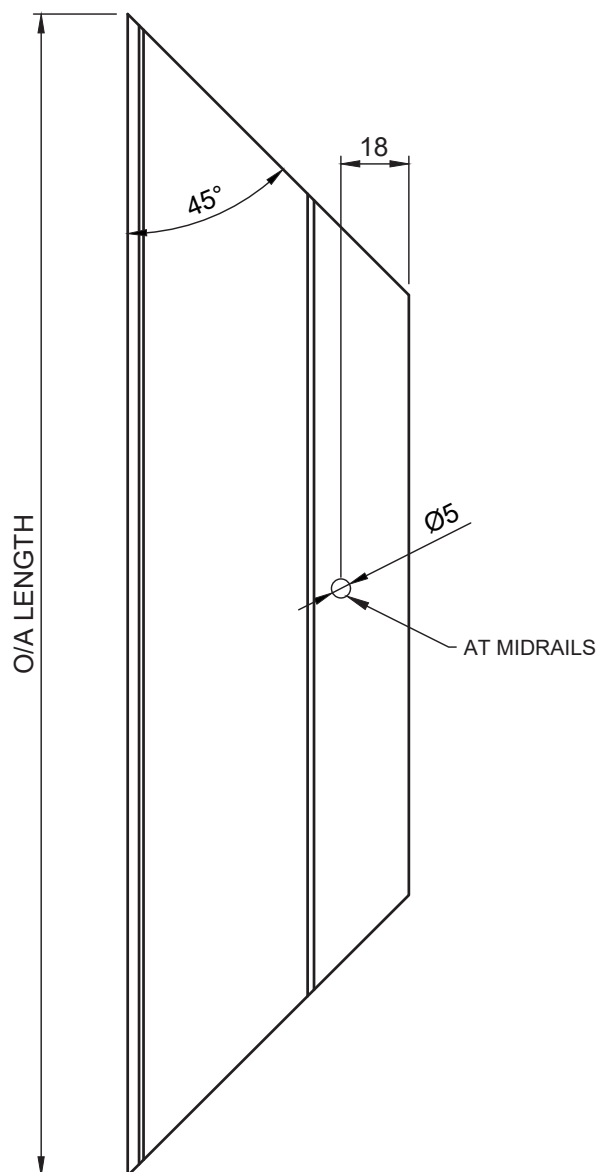
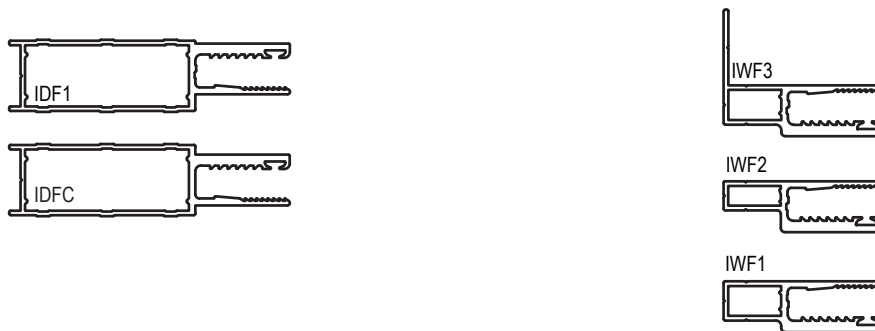
10. Manufacturing Details

Roller Machining Detail



10. Manufacturing Details

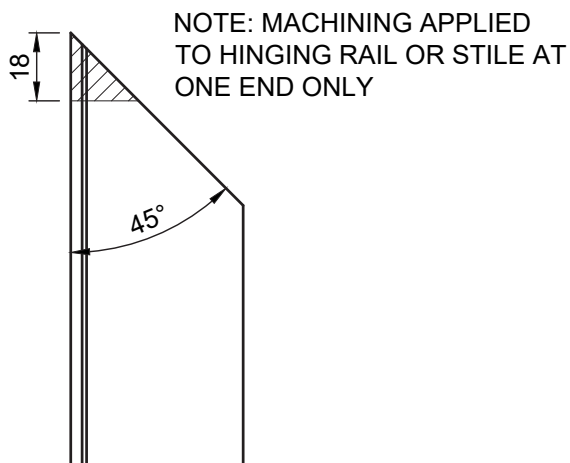
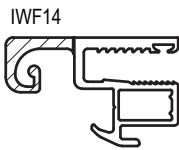
Rail Preparation



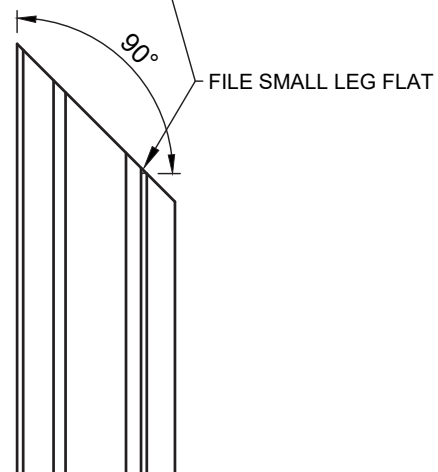
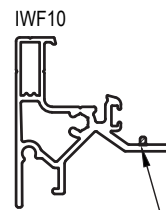
NOTE: ALL PERIMETER FRAMES & SASH SECTIONS ARE MITERED CUT

10. Manufacturing Details

Invisi-Scape Open Out Details

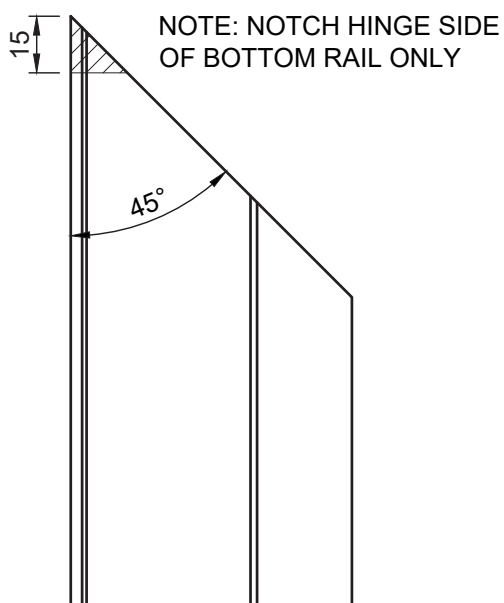
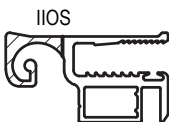


refer to page 11.9 for more details

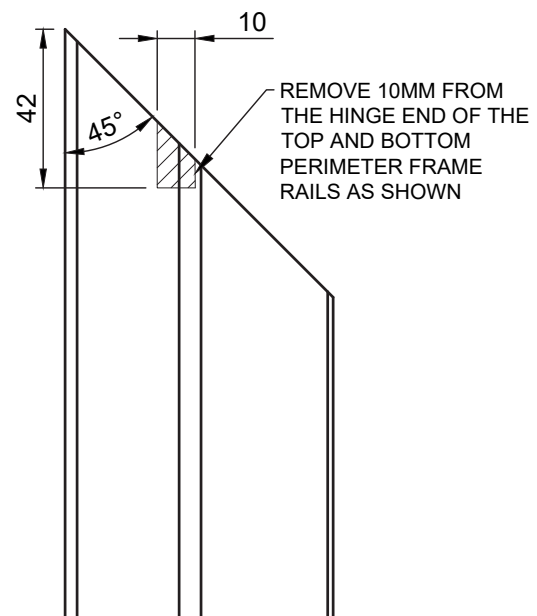
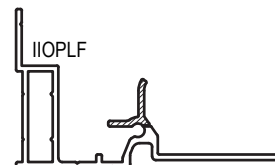


refer to page 11.11 for more details

Invisi-Scape Open In Details



refer to page 11.17 for more details



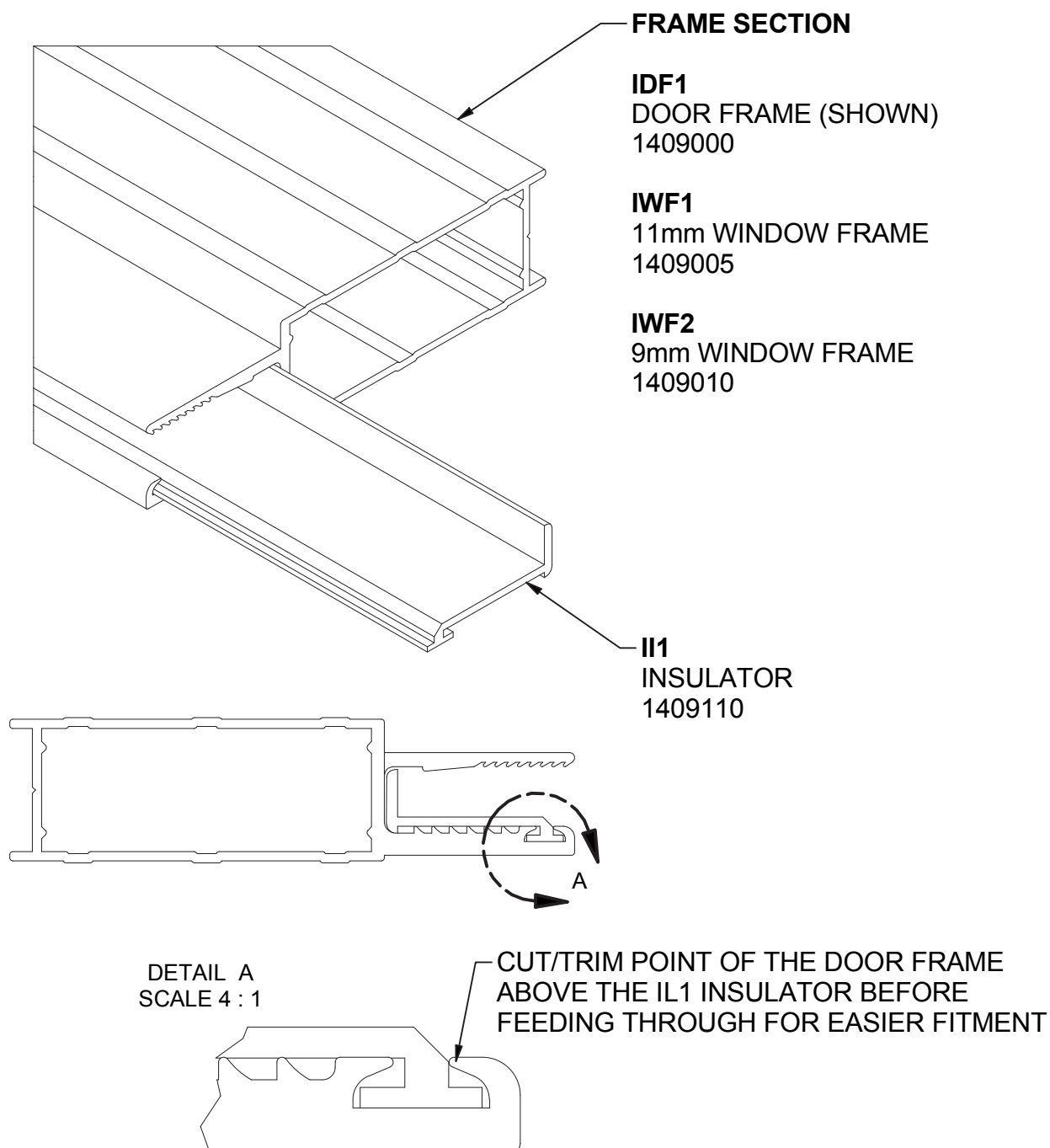
refer to page 11.17 for more details

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.

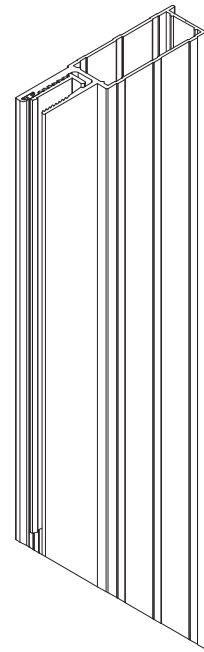
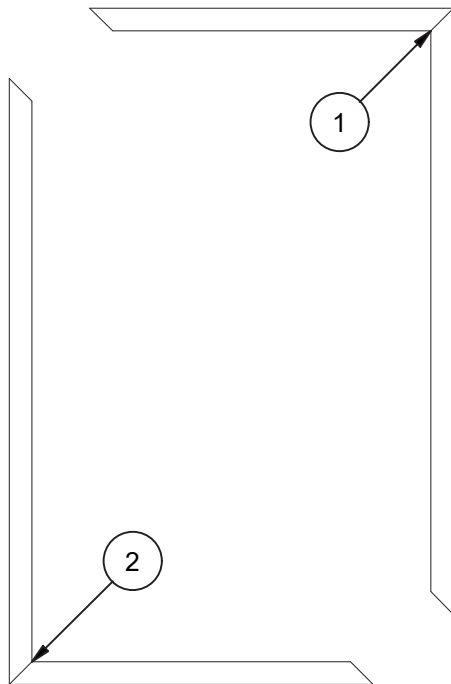


11. Assembly Details

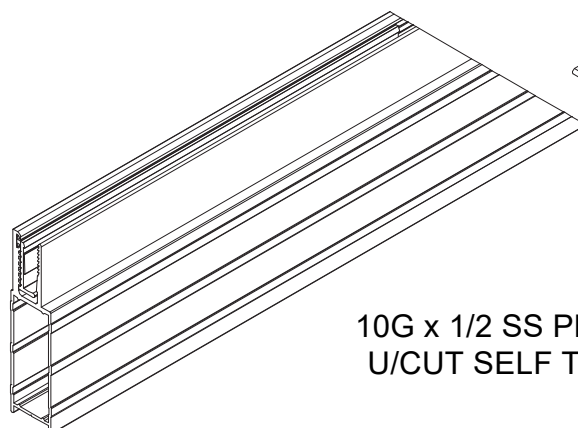
Invisi-Gard Assembly - Step Two

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



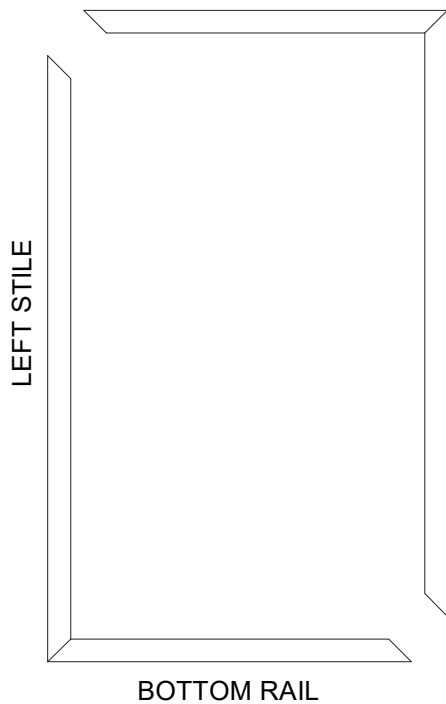
10G x 1/2 SS PHILLIPS
U/CUT SELF TAPPING
1382026

OR

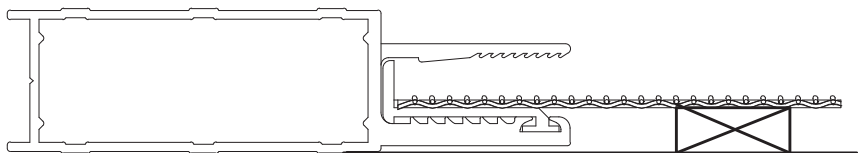
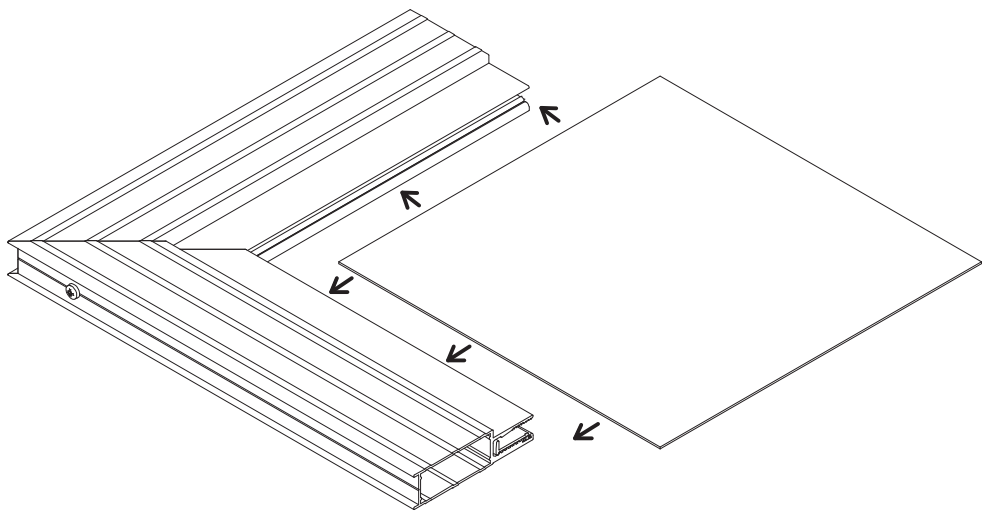
5-4 S/STEEL RIVETS
1380167

11. Assembly Details

Invisi-Gard Assembly - Step Three



COMPLETE THE ASSEMBLY OF
THE FRAME AROUND THE MESH.

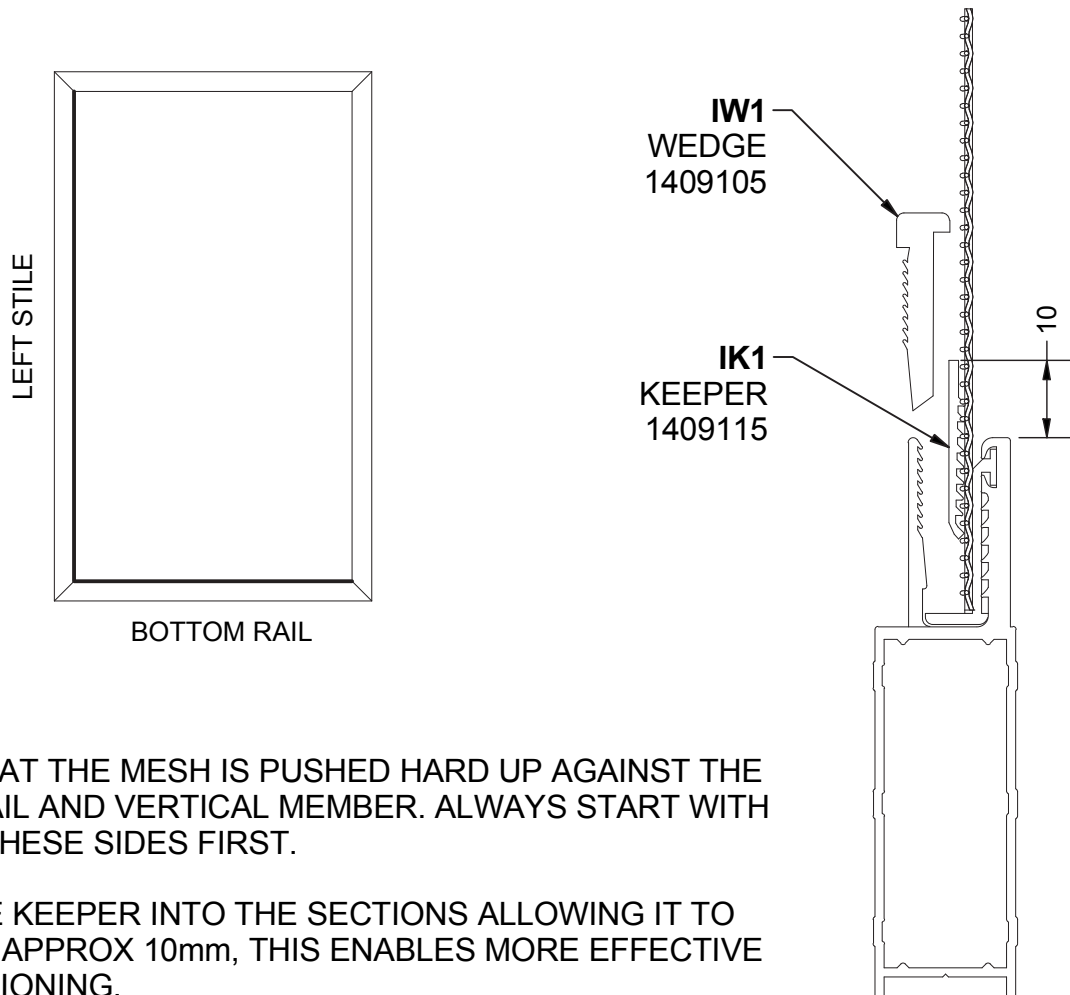


IMPROVE MESH TAUTNESS BY USING
PACKERS TO SUPPORT THE MESH FROM
SAGGING.THE PACKER THICKNESS DEPENDS
ON THE SECTION BEING USED, REFER TABLE.

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

11. Assembly Details

Invisi-Gard Assembly - Step Four



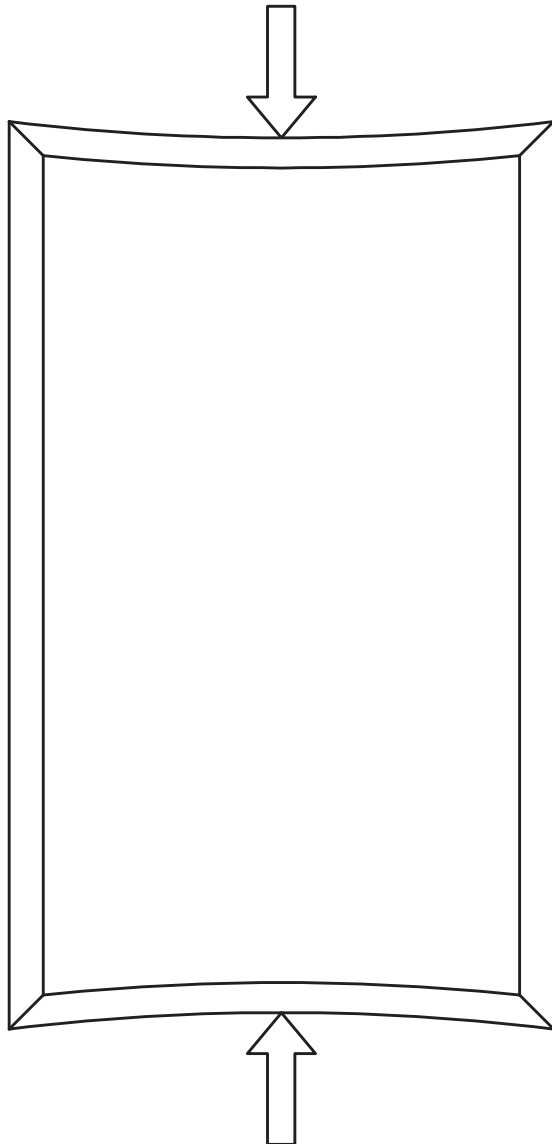
ENSURE THAT THE MESH IS PUSHED HARD UP AGAINST THE BOTTOM RAIL AND VERTICAL MEMBER. ALWAYS START WITH WEDGING THESE SIDES FIRST.

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



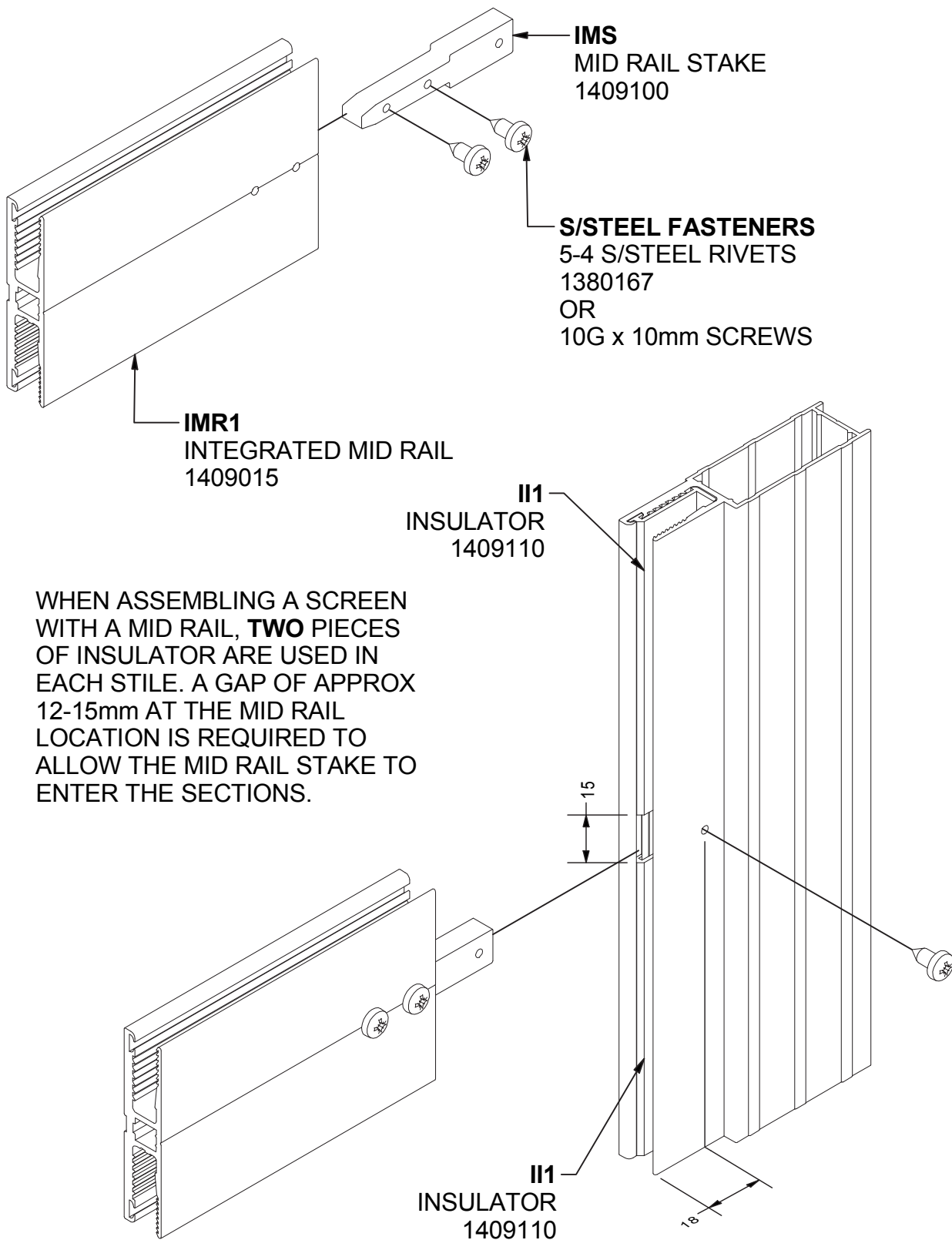
IMPORTANT NOTE:

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

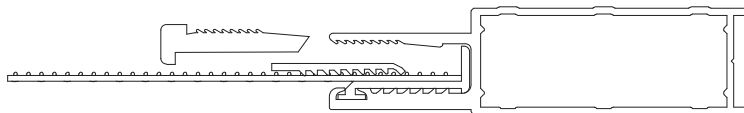
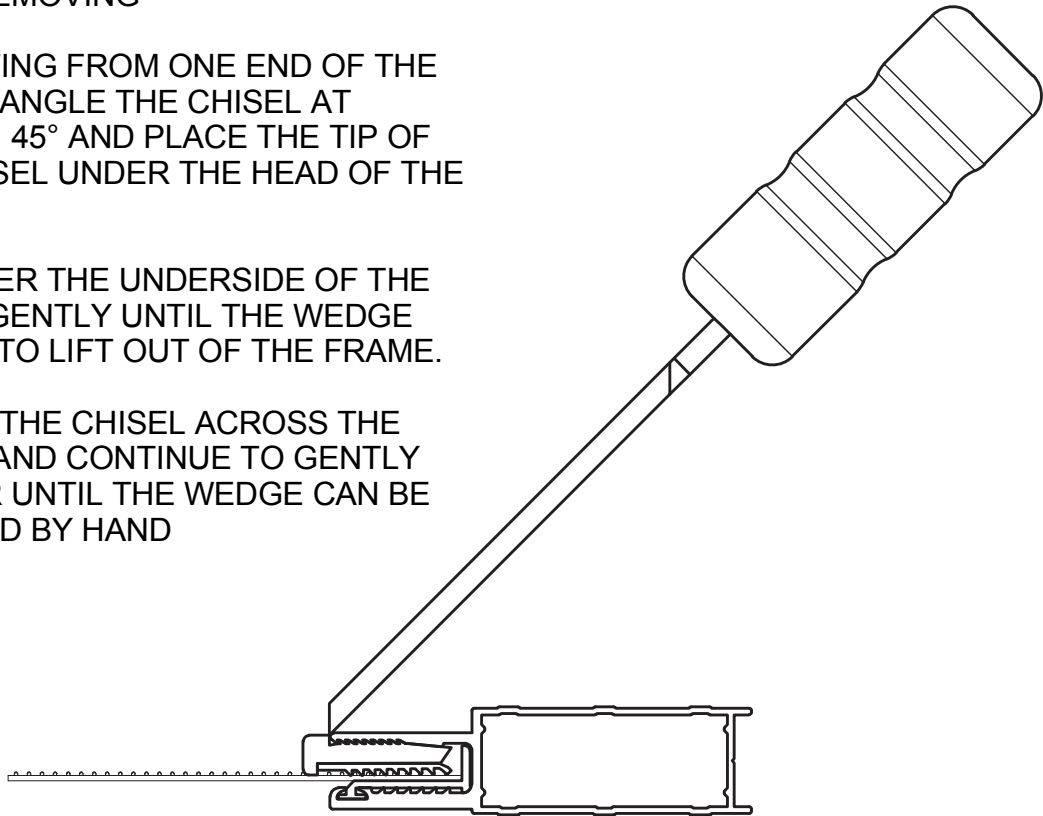
Invisi-Gard Disassembly

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

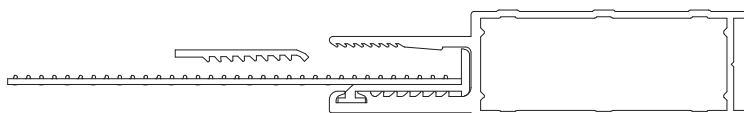
1. STARTING FROM ONE END OF THE WEDGE, ANGLE THE CHISEL AT APPROX. 45° AND PLACE THE TIP OF THE CHISEL UNDER THE HEAD OF THE WEDGE

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

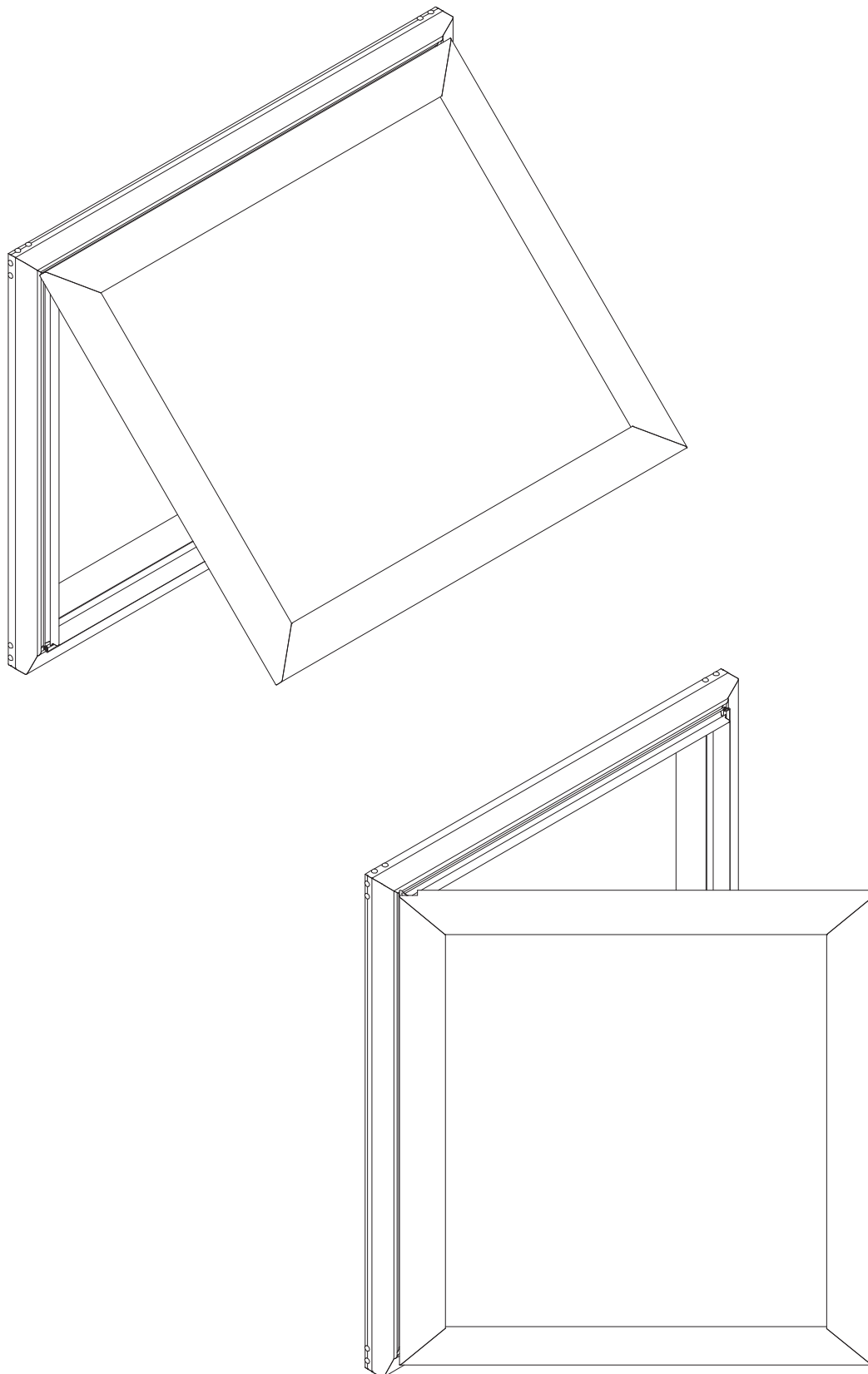


AFTER WEDGE HAS BEEN REMOVED, USE BENT NOSE PLIERS TO REMOVE THE KEEPER STRIP



11. Assembly Details

Invisi-Scape Outward Open

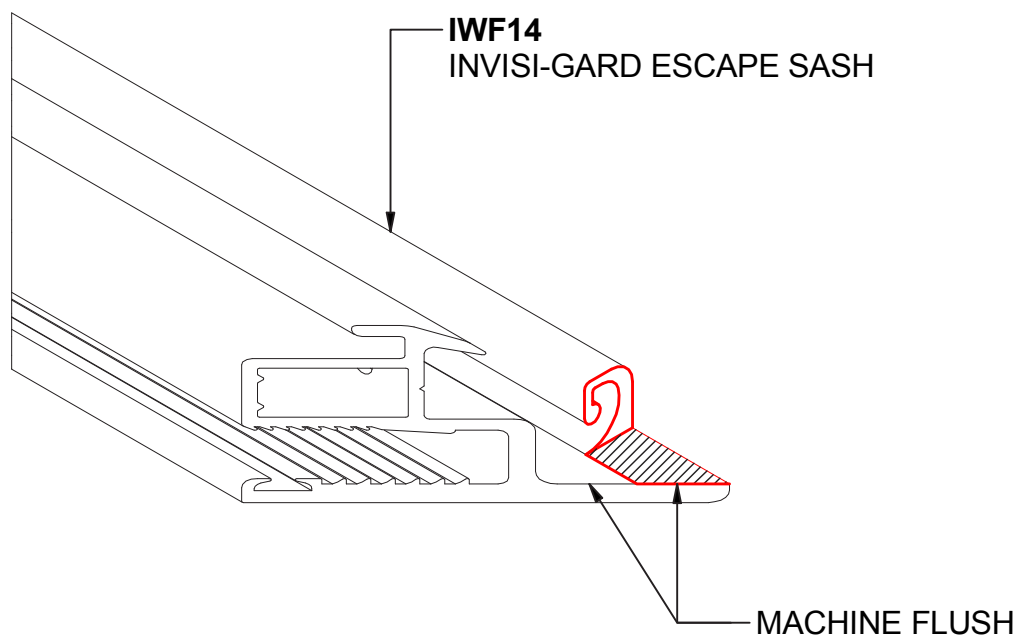
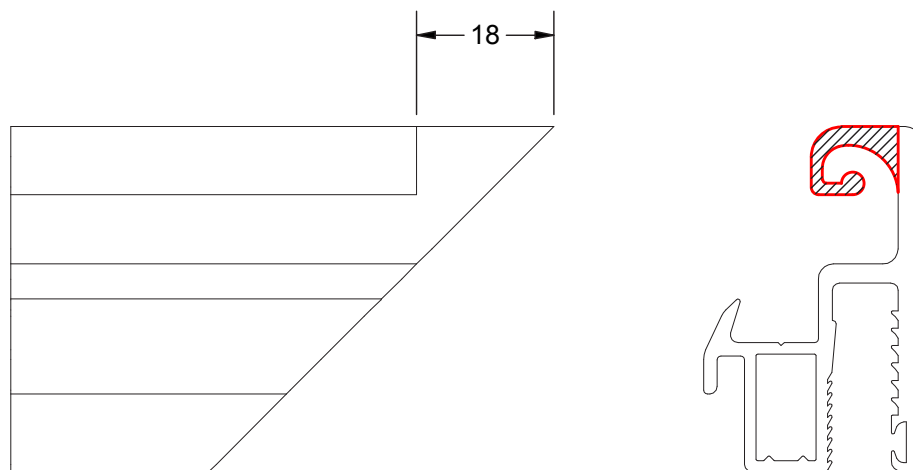


11. Assembly Details

Invisi-Scape Outward Open Assembly - Step One

SASH FRAME PREPARATION

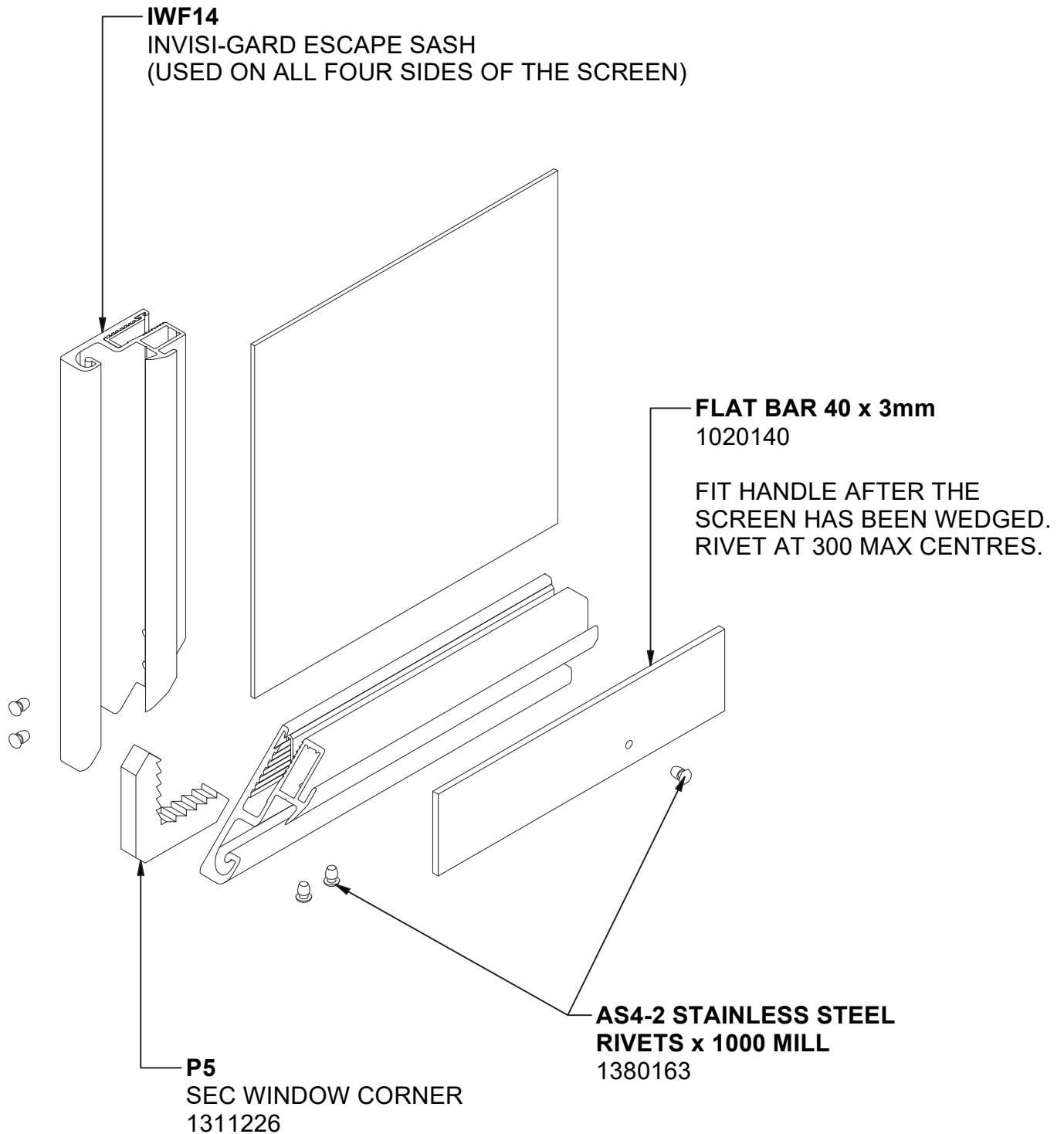
MACHINE 18mm OFF THE HOOK HINGE AS SHOWN BELOW.
THIS MACHINING OPERATION IS ONLY APPLIED TO THE HINGING
SIDE AT ONE END ONLY.



11. Assembly Details

Invisi-Scape Outward Opening Assembly - Step Two

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



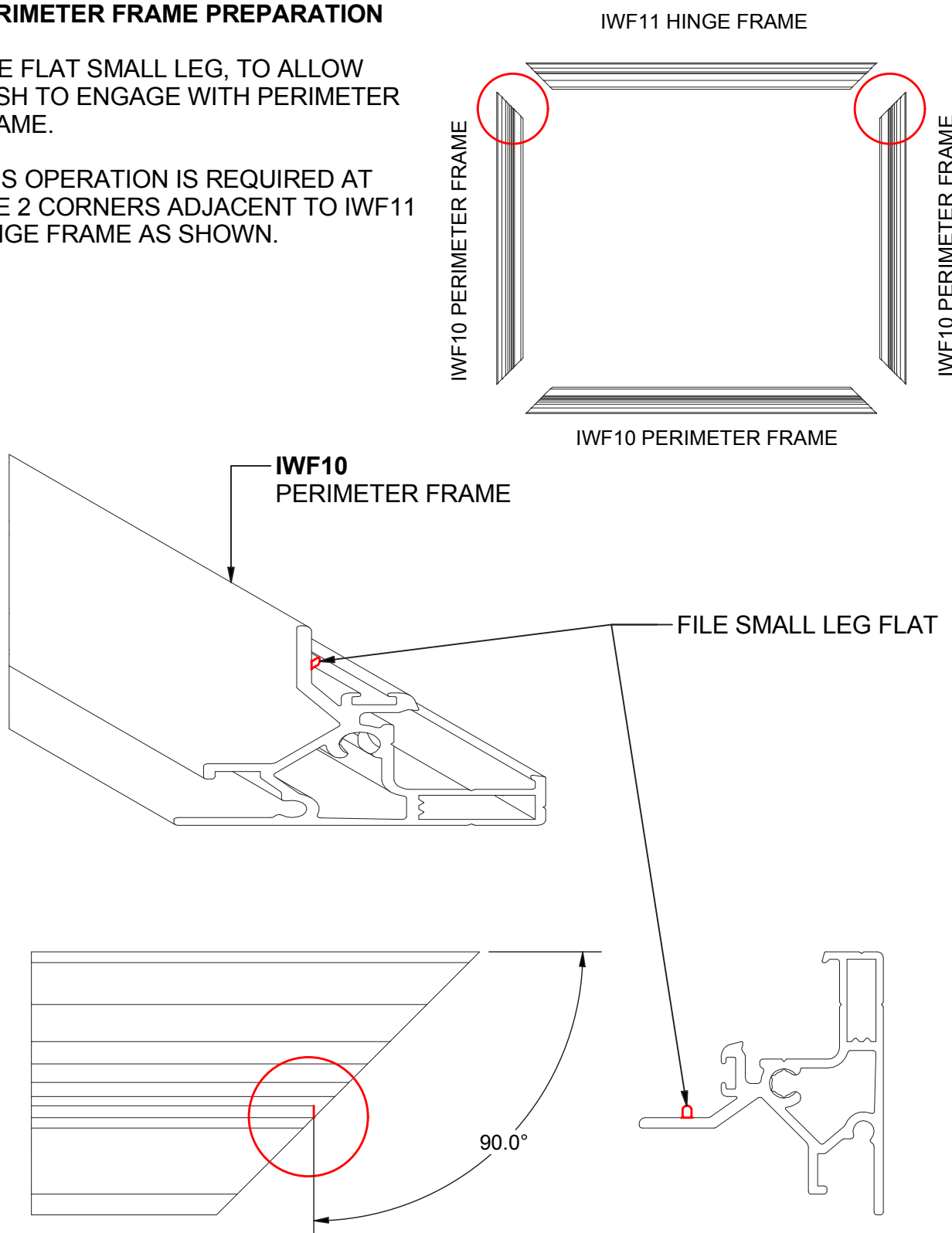
11. Assembly Details

Invisi-Scape Outward Open Assembly - Step Three

PERIMETER FRAME PREPARATION

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

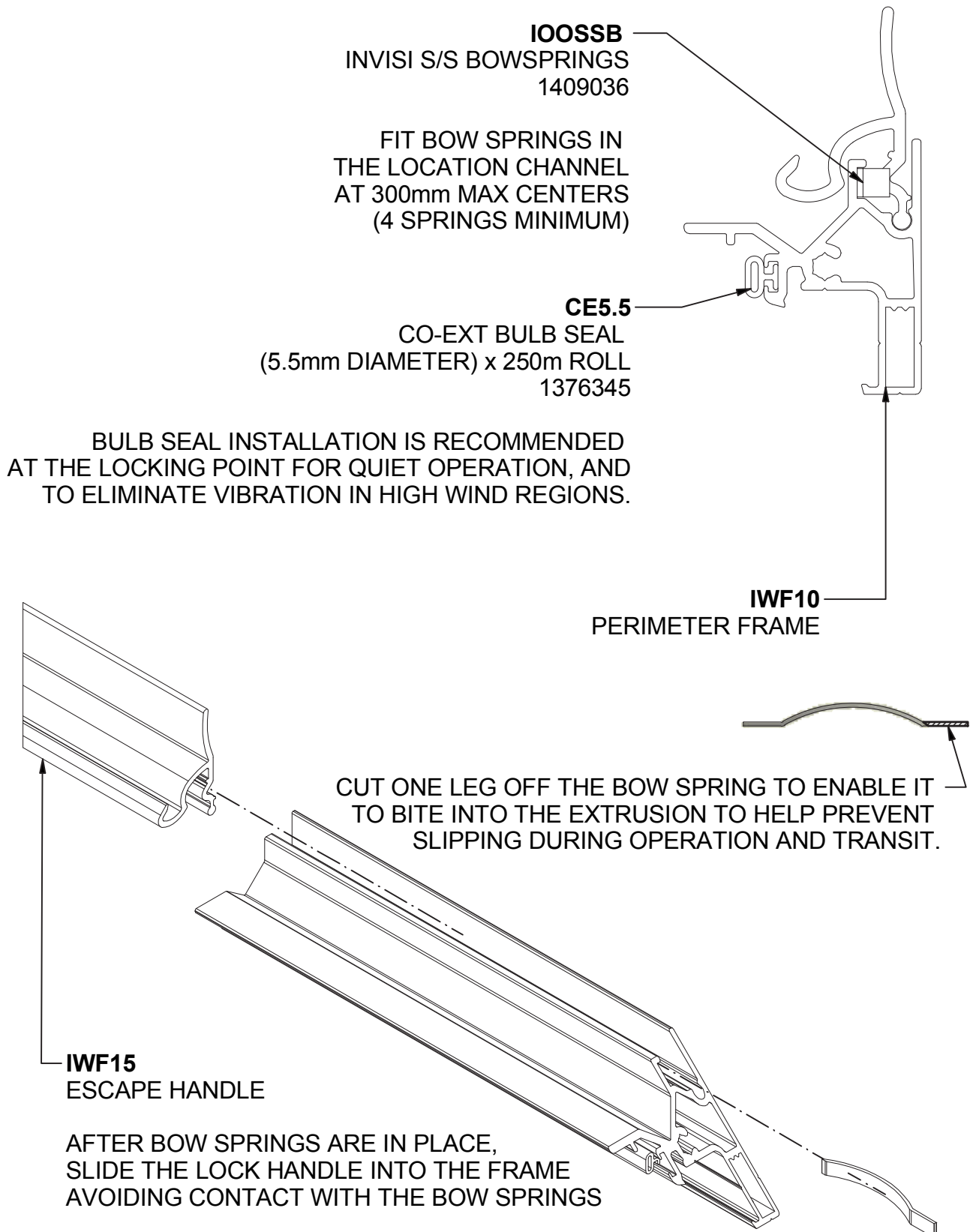
THIS OPERATION IS REQUIRED AT THE 2 CORNERS ADJACENT TO IWF11 HINGE FRAME AS SHOWN.



11. Assembly Details

Invisi-Scape Outward Opening Assembly - Step Four

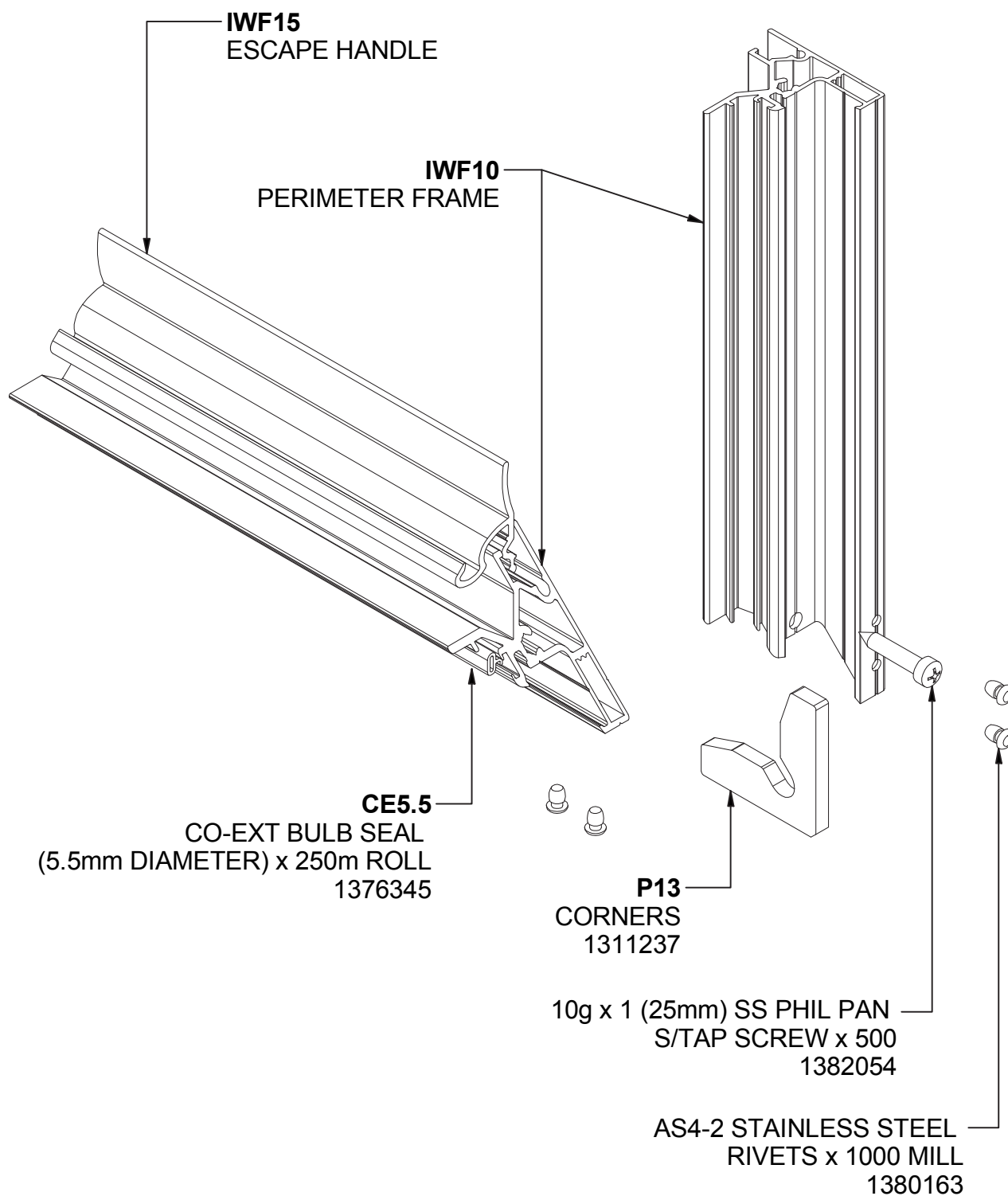
SPRING LOADED LOCK ASSEMBLY



11. Assembly Details

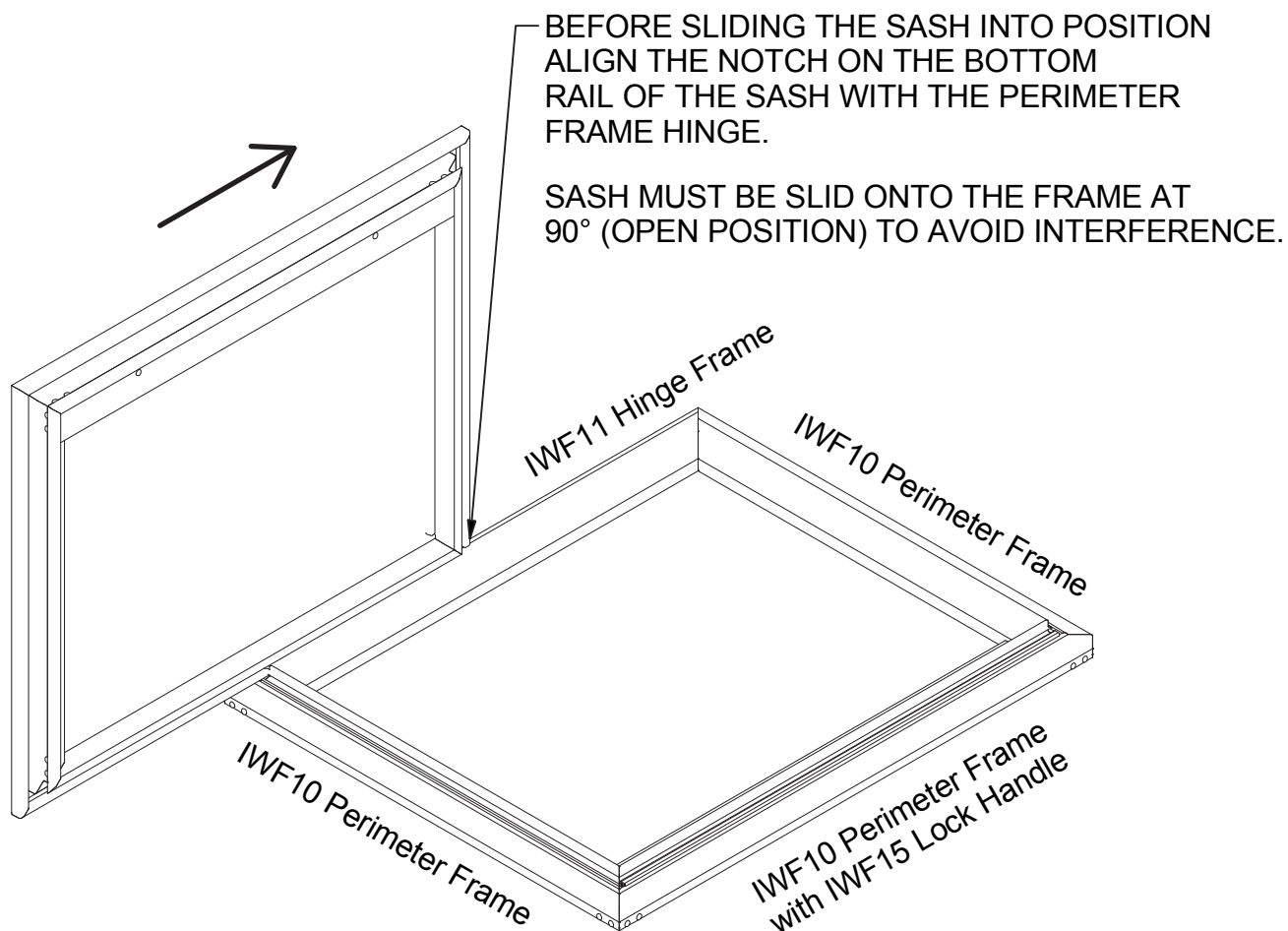
Invisi-Scape Outward Open Assembly - Step Five

PERIMETER FRAME ASSEMBLY (LOCK CORNER SHOWN)



11. Assembly Details

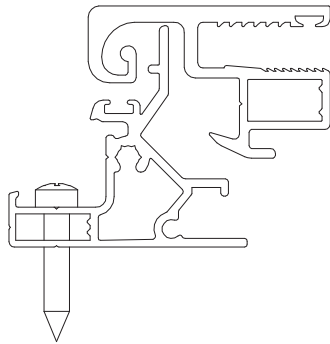
Invisi-Scape Outward Opening Assembly - Step Six



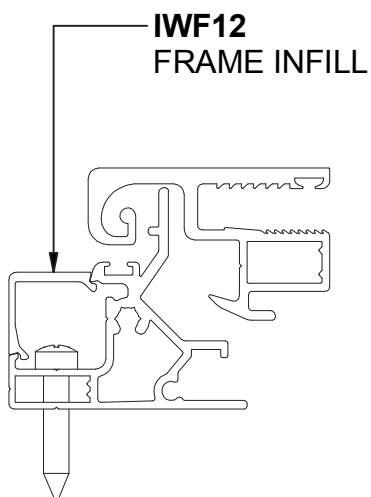
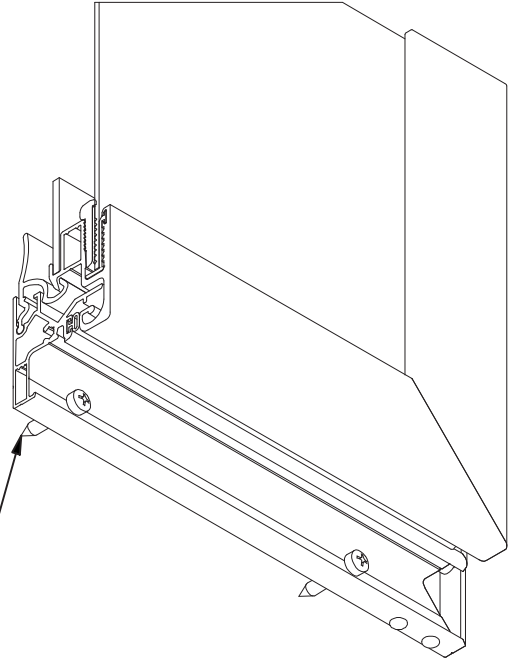
11. Assembly Details

Invisi-Scape Outward Open Assembly - Step Seven

FINAL ASSEMBLY

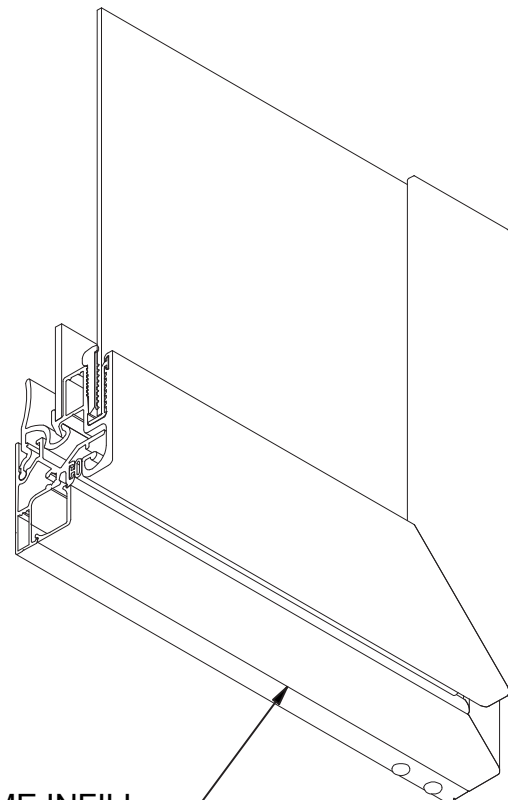


USING MIN. 8G ANTI-TAMPER SCREWS,
FRAME MUST BE SECURELY FIXED
TO THE STRUCTURE AT 300mm
MAX CENTRES. DO NOT OVER TIGHTEN.



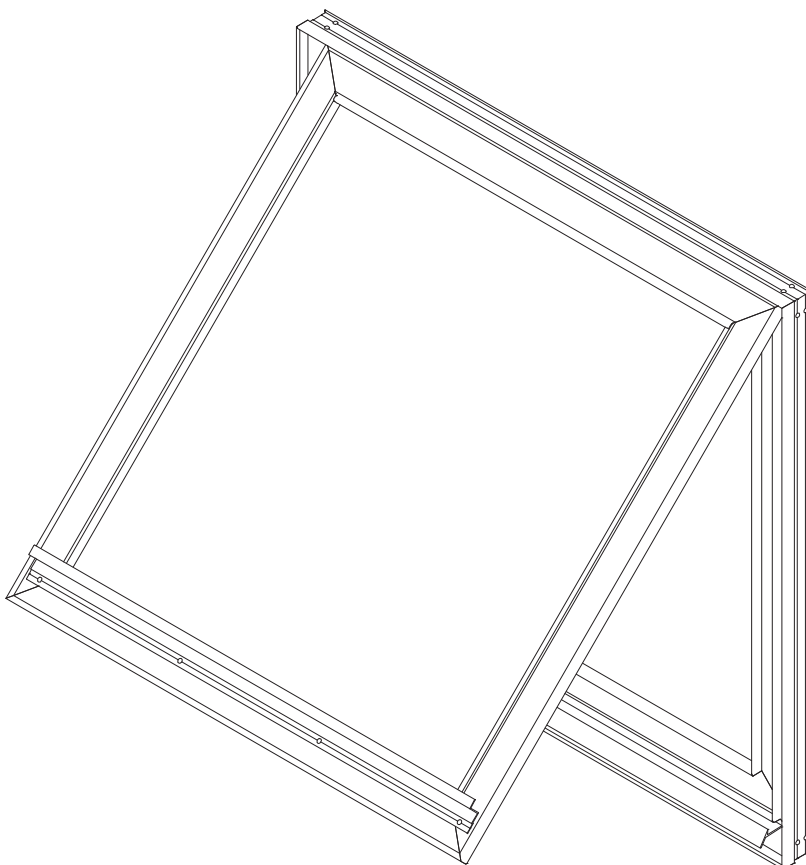
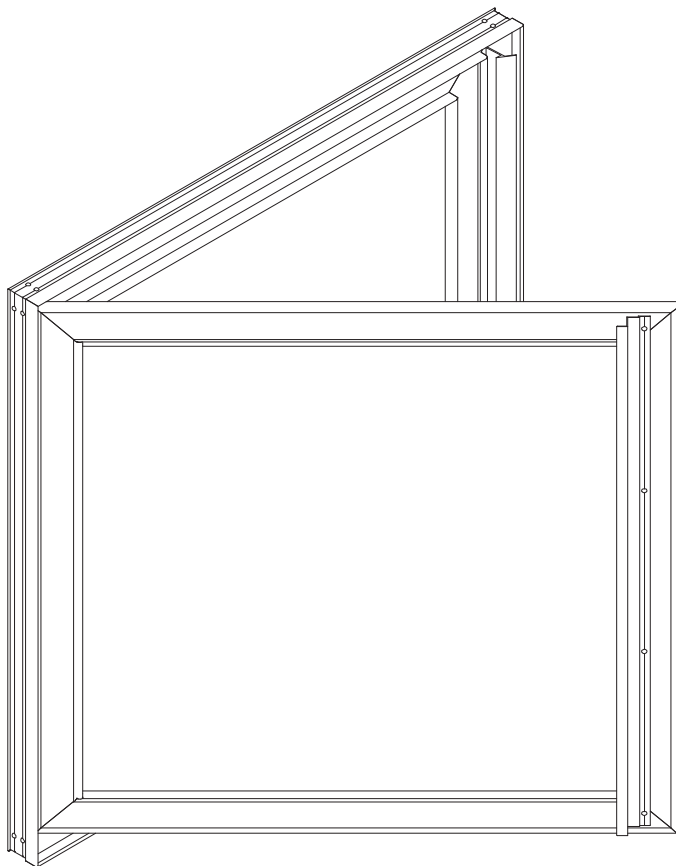
IWF12
FRAME INFILL

CLIP ON THE FRAME INFILL
TO CONCEAL THE FIXINGS.



11. Assembly Details

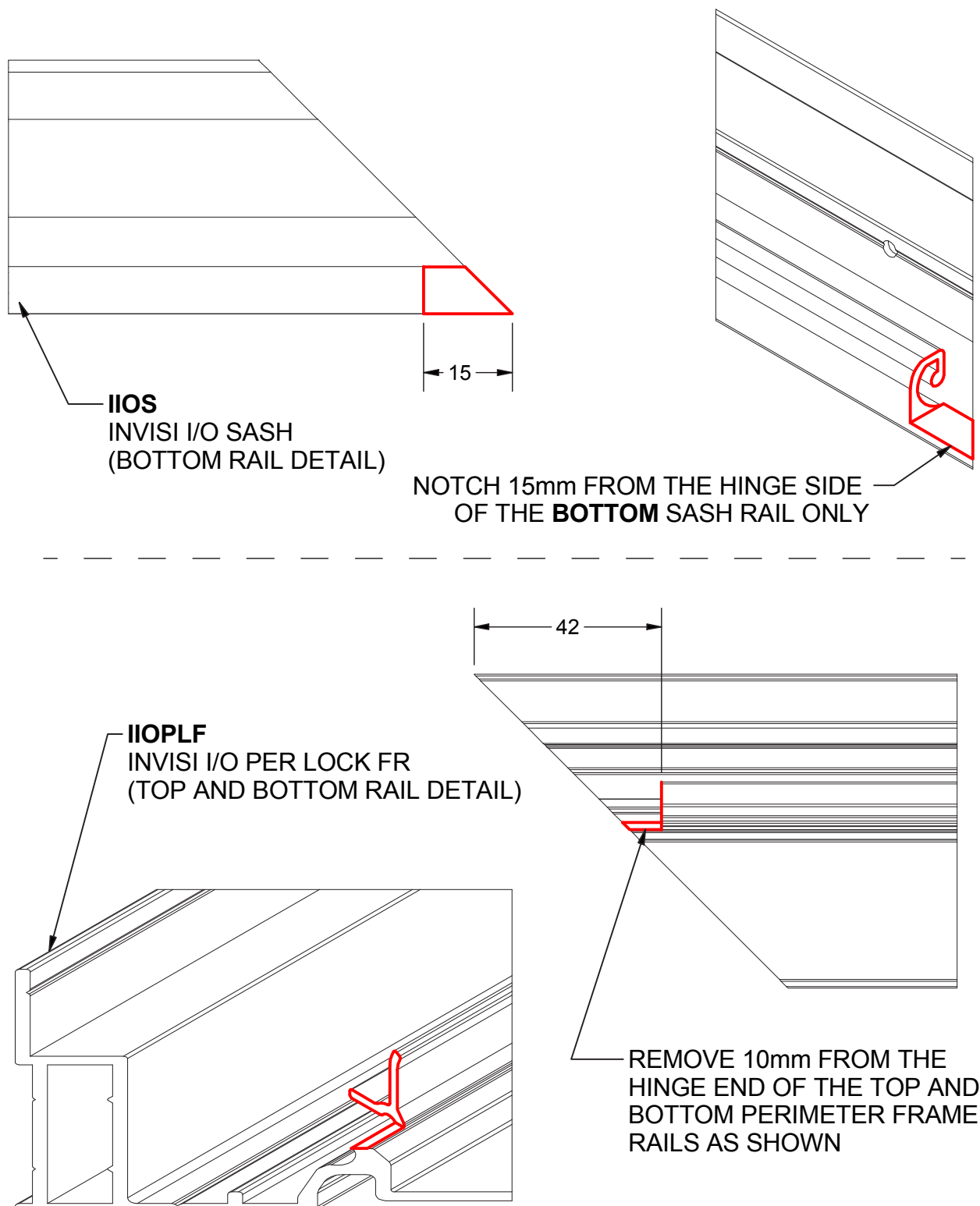
Invisi-Scape Inward Opening



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.

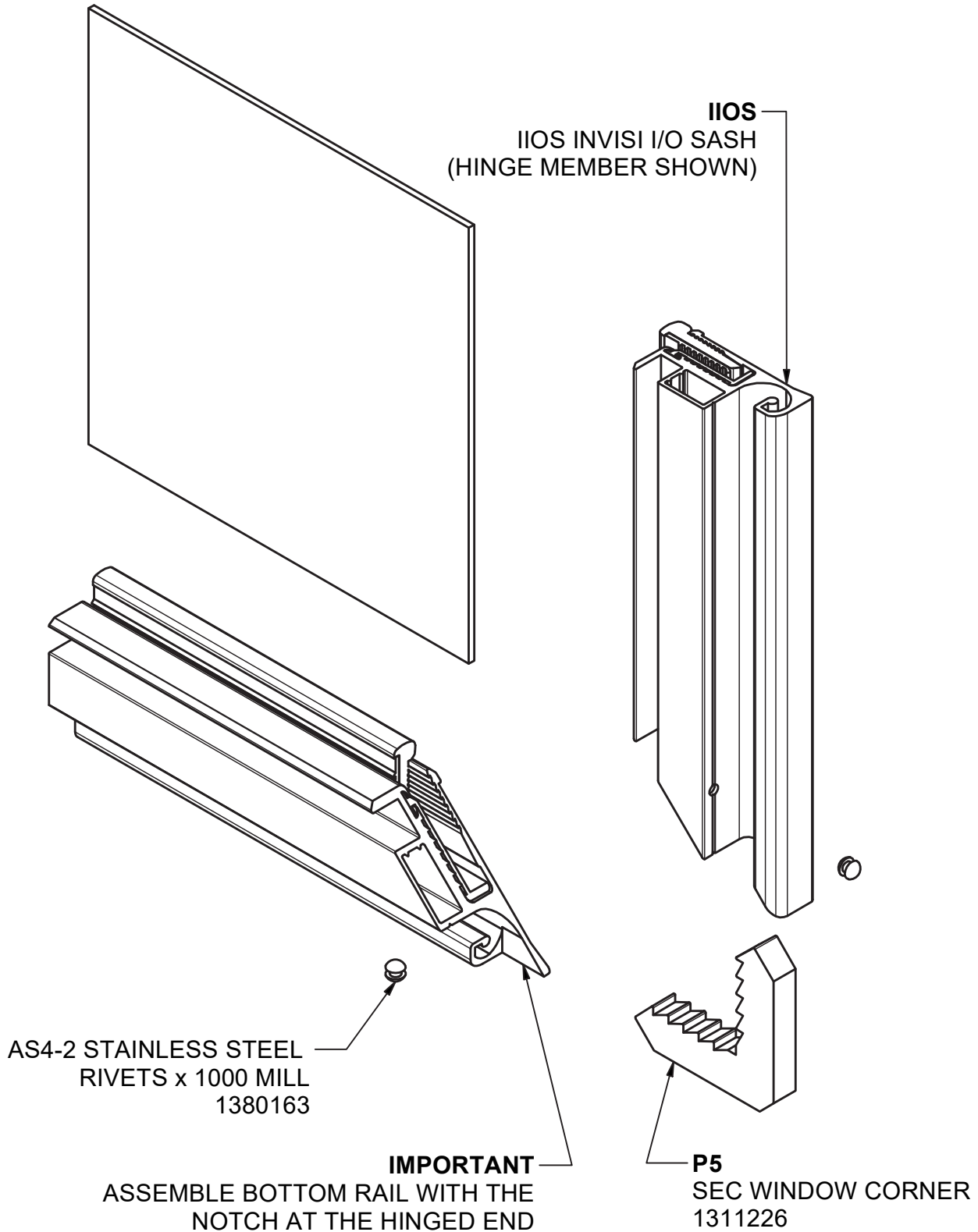


11. Assembly Details

Invisi-Scape Inward Opening - Step Two

SASH FRAME ASSEMBLY

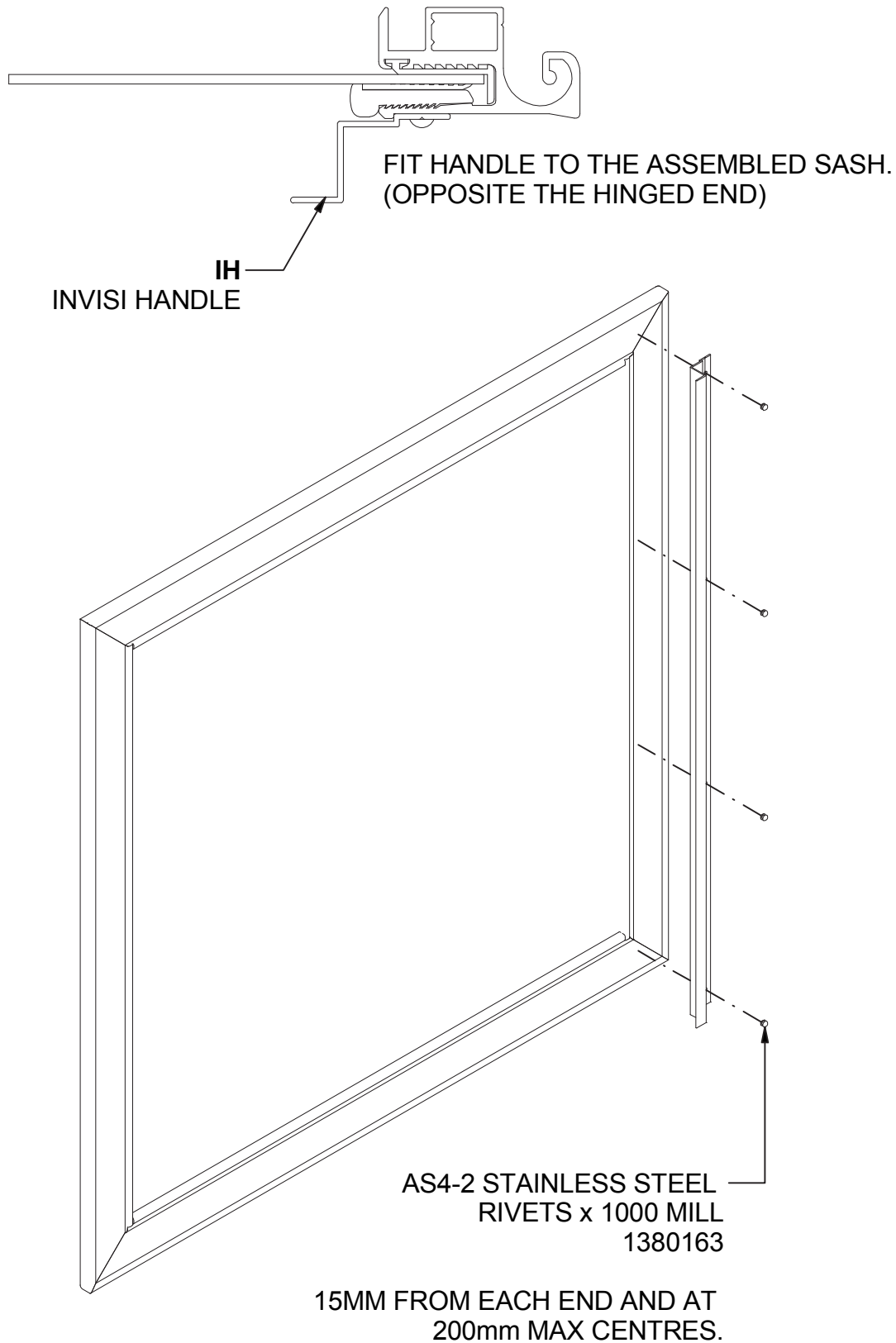
ASSEMBLE THE SASH FRAME AS PER A STANDARD INVISI-GARD WINDOW.



11. Assembly Details

Invisi-Scape Inward Opening - Step Three

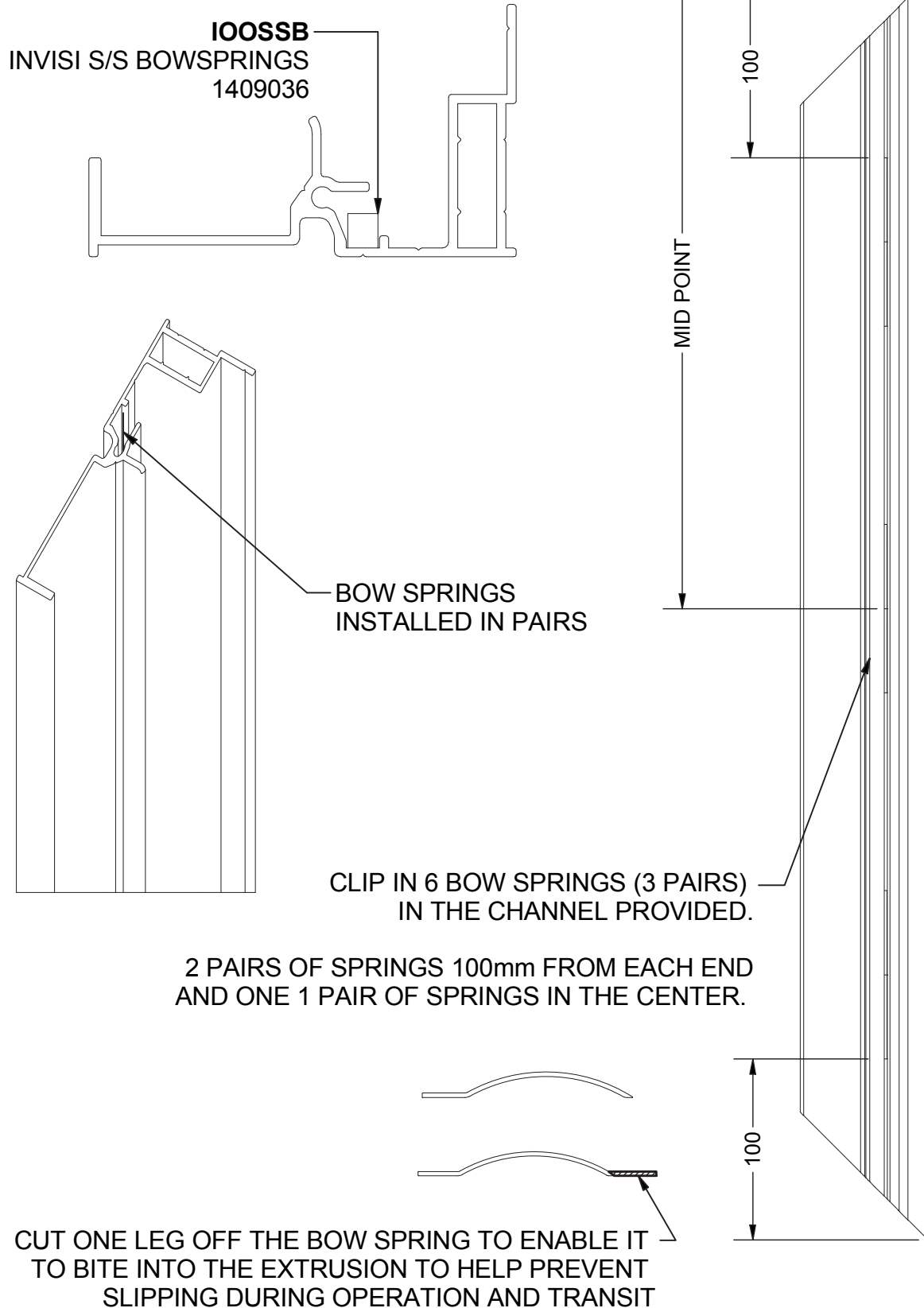
SASH FRAME ASSEMBLY



11. Assembly Details

Invisi-Scape Inward Opening - Step Four

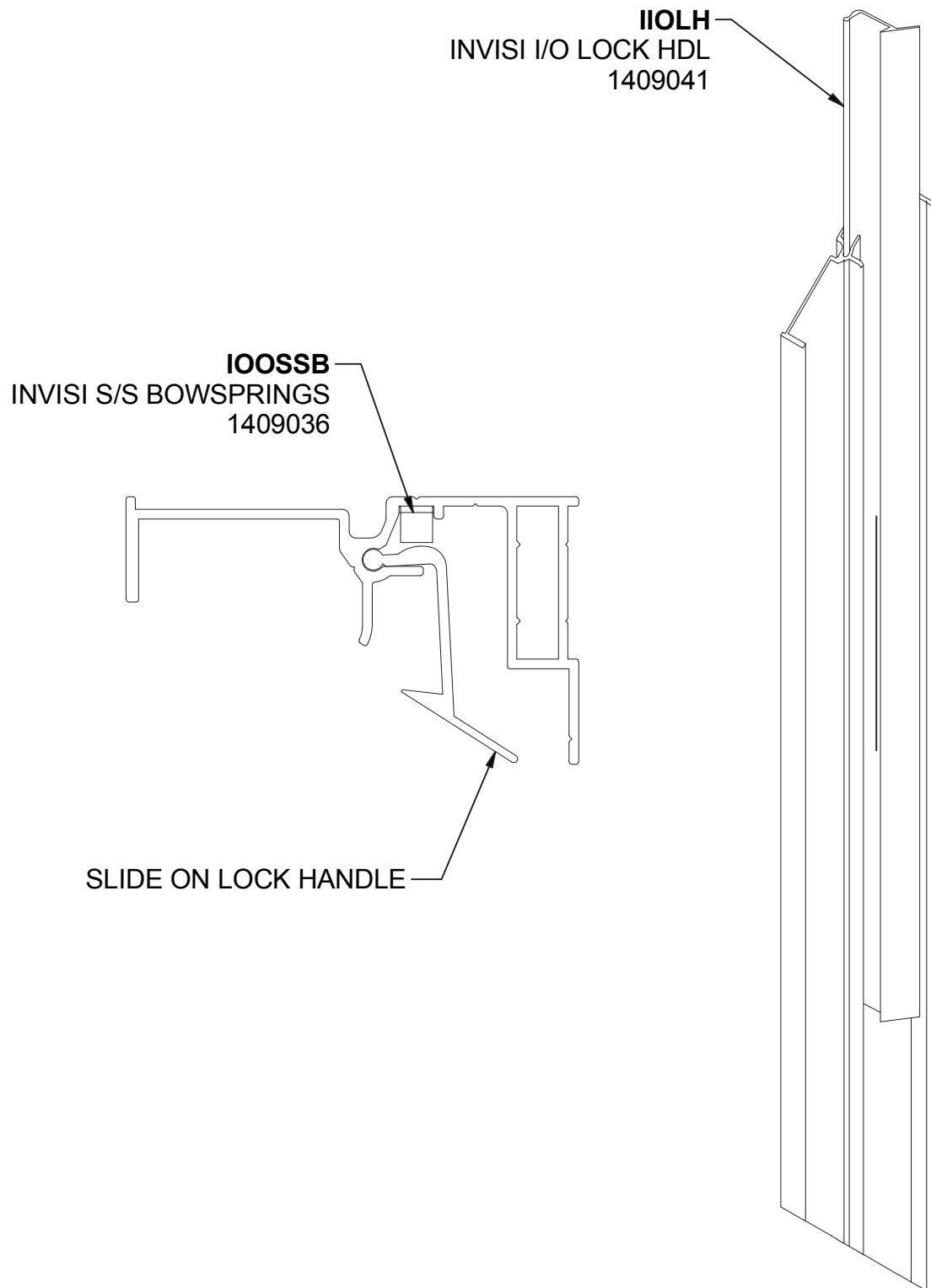
PERIMETER FRAME ASSEMBLY



11. Assembly Details

Invisi-Scape Inward Opening - Step Five

PERIMETER FRAME ASSEMBLY



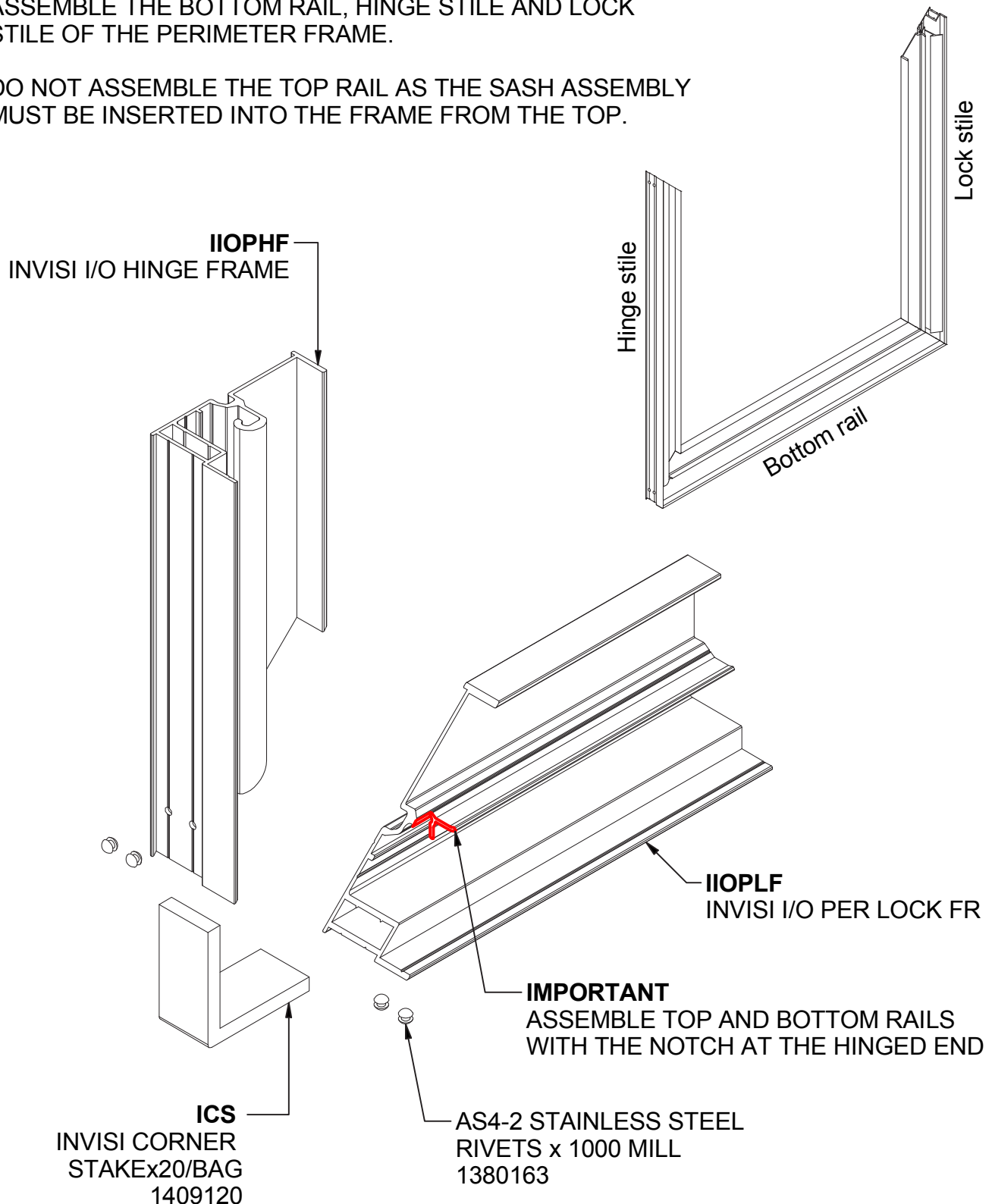
11. Assembly Details

Invisi-Scape Inward Opening - Step Six

PERIMETER FRAME ASSEMBLY

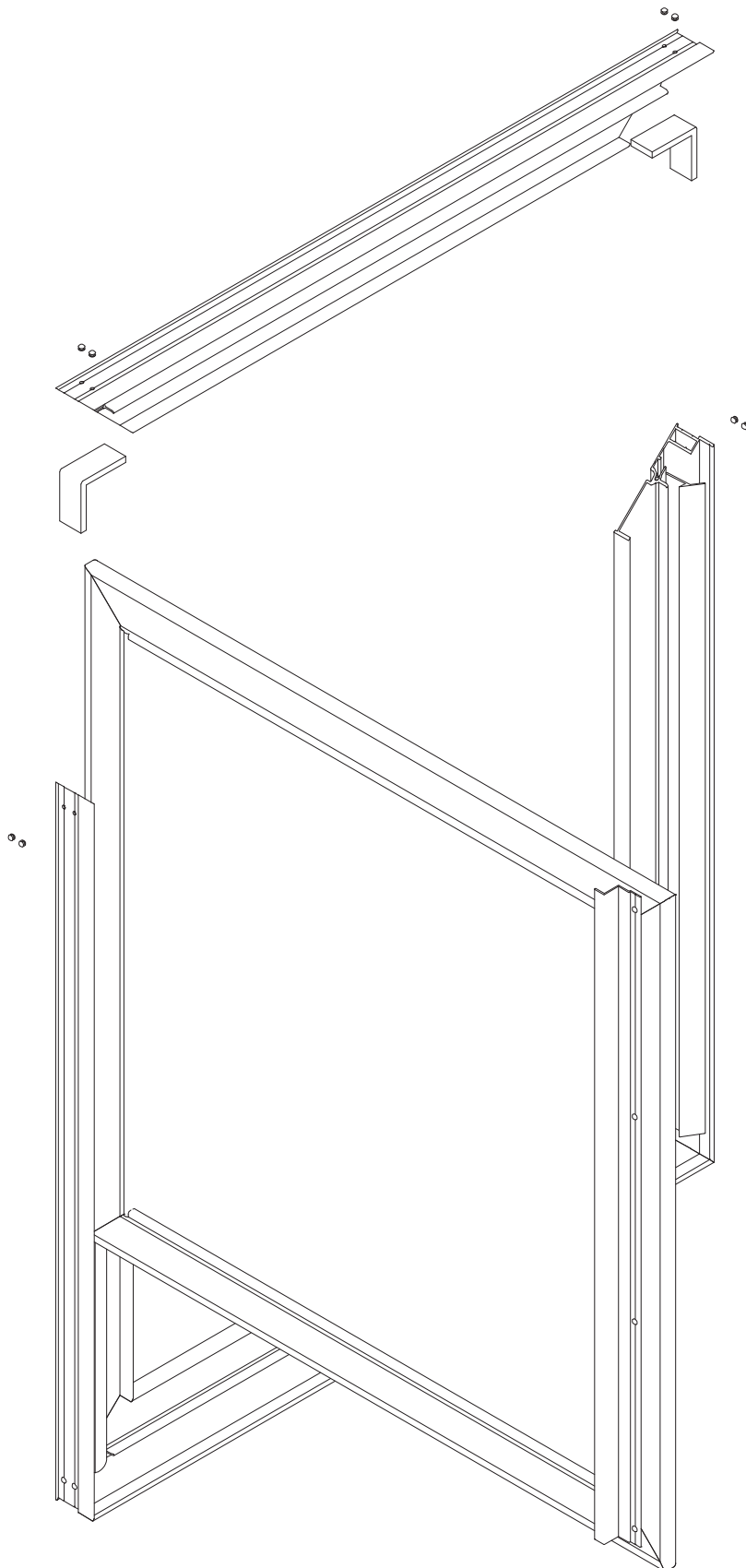
ASSEMBLE THE BOTTOM RAIL, HINGE STILE AND LOCK STILE OF THE PERIMETER FRAME.

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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