



INVISI-MAXX

MAXX SECURITY. MAXX PROTECTION

INVISI-MAXX

High Performance Debris Screen

Technical Manual

April 2024 | ISSUE F

al spec[®]
EVERYTHING ALUMINIUM
& HARDWARE

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Contents

1. TECHNICAL MANUAL RELEASE NOTES	1.1
2. TECHNICAL SPECIFICATIONS	2.1
4. TEST SUMMARY	4.1
Impact - AS/NZS 1170.2, SECTION 2.5.7 & 5.3.2	4.1
5. EXTRUSIONS	5.1
6. HARDWARE & COMPONENTS	6.1
Seals	6.1
Fasteners	6.1
Accessories	6.2
Lock Hardware - Sliding Door	6.4
Lock Hardware - Cylinders	6.6
0.8mm Stainless Steel Mesh Sheet Sizes	6.7
1.2mm Stainless Steel Mesh Sheet Sizes	6.8
7. TYPICAL ELEVATION	7.1
8. TYPICAL DETAILS	8.1
Invisi-Maxx Sliding Door Head and Sill Details - IMX1	8.1
Invisi-Maxx Sliding Door Jamb and Mullion Details - IMX1	8.2
Invisi-Maxx Window Screen - IMXWF1	8.4
Invisi-Maxx Escape Screen - Open Out	8.5
Invisi-Maxx Escape Buildout Screen Head and Sill Details - Open Out	8.6
Invisi-Maxx Escape Buildout Screen Jamb Details - Open Out	8.7
9. CUTTING FORMULAS	9.1
Hinged / Sliding Door	9.1
Sliding Door with Frame	9.2
Window Screen	9.3
Window Screen with Frame	9.4
Invisi-Maxx Escape Outward Opening Screen - Top Hung	9.5
Invisi-Maxx Escape Outward Opening Screen - Side Hung	9.6
Invisi-Maxx Escape Buildout Outward Opening Screen - Top Hung	9.7
Invisi-Maxx Escape Buildout Outward Opening Screen - Side Hung	9.8
10. MANUFACTURING DETAILS	10.1
Stile and Rail Preparation	10.1
CSB2 120mm Cyclone Build-out Jamb Mitre Preparation	10.2
CSB2 120mm Cyclone Build-out Jamb Fixing Holes	10.3
IMXSD1 Perimeter Frame Preparation	10.4
IMXSD2 Sill Track Adaptor Fixing Holes	10.5
IMXSD3 Head Track Adaptor Fixing Holes	10.6

IMXSD5 Jamb Adaptor for Outward Door Fixing Holes	10.7
IMXSD5 Jamb Adaptor for Inward Door Fixing Holes	10.8
IMXSD6 HD Frame Mullion Fixing Holes	10.9
IMXSD7 HD Interlock Mullion Fixing Holes	10.10
IMX1 Sliding Door Mesh Fixing Location	10.11
Invisi-Maxx Escape Open Out Machining	10.12
Invisi-Maxx Escape Buildout Open Out Machining	10.13

11. ASSEMBLY DETAILS 11.1

Step 1 - Insulator Assembly	11.1
Step 2 - Door Frame Assembly	11.2
Step 3 - Mesh Assembly	11.3
Step 4 - Bottom Rail, Keeper and Wedge Assembly	11.4
Step 5 - Top Rail, Stiles, Keeper and Wedge Assembly	11.5
CSB2 Assembly	11.6

13. CARE & MAINTENANCE 13.1

2. Technical Specifications

ALUMINIUM

Aluminium frames should be manufactured using Alspec's INVISI-MAXX HIGH PERFORMANCE DEBRIS SCREEN framing system.

HARDWARE

All hardware as per Alspec Technical Manual.

FINISHES

- All powder coated material shall be produced to AS3715.
- All anodised material shall be produced to AS1231.

TESTING

- Product shall have a test report to show compliance to AS/NZS1170.2, Section 2.5.7 & 5.3.2.
- Invisi-Maxx with 0.8mm mesh thickness achieved the Impact Testing result of up to 36m/s.
- Invisi-Maxx with 1.2mm mesh thickness achieved the Impact Testing result of up to 44m/s.

All products are available from Alspec (A.B.N. 63 001 252 259) as detailed in the "Alspec" catalogue or on the Internet at www.alspec.com.au.

4. Test Summary

Impact - AS/NZS 1170.2, SECTION 2.5.7 & 5.3.2

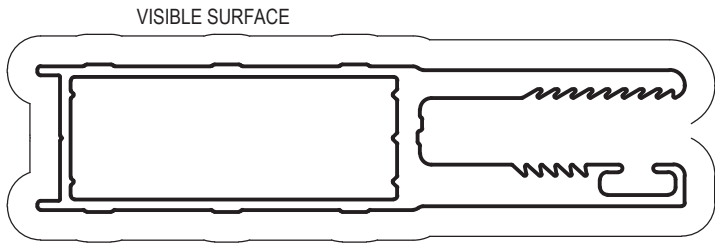
TEST REPORT	PRODUCT DESCRIPTION	MESH THICKNESS	SIZE	RESULT	DEFLECTION
AZT0091.14	Invisi-Maxx Fixed Screen	0.8mm	1.61m (H) x 1.32m (W)	31m/s	-
AZT0617.19	Invisi-Maxx Fixed Screen	1.2mm	1.55m (H) x 2.1m (W)	36m/s	-
AZT0183.14	Invisi-Maxx Fixed Screen with CSB2	1.2mm	1.08m (H) x 1.57m (W)	40m/s	-
AZT0184.14	Invisi-Maxx Fixed Screen	1.2mm	1.08m (H) x 1.57m (W)	44m/s	-
AZT0166.12	Invisi-Maxx Screen with CSB2	0.8mm	1.2m (H) x 1.69m (W)	36m/s	-
AZT0080.20	Invisi-Maxx Fixed Screen	1.2mm	1.56m (H) x 2.1m (W)	40m/s	-
AZT0650.19	Invisi-Maxx Bi-Sliding Door	1.2mm	2.1m (H) x 1.95m (W)	36m/s	-
AZT0092.14	Invisi-Maxx Escape Screen	0.8mm	1.61m (H) x 1.32m (W)	31m/s	-
AZT0093.14	Invisi-Maxx Escape Screen with CSB2	0.8mm	1.61m (H) x 1.32m (W)	33m/s	-
AZT0182.14	Invisi-Maxx Escape Screen	1.2mm	1.08m (H) x 1.57m (W)	40m/s	-
AZT0327.14	Invisi-Maxx Escape Screen	1.2mm	1.115m (H) x 1.605m (W)	44m/s	-
OT.DI22-05	Invisi-Maxx Awning Escape Out	1.2mm	1.5m (H) x 1.5m (W)	36m/s	-
OT.DI22-06	Invisi-Maxx Awning Escape Out	1.2mm	1.0m (H) x 1.1m (W)	36m/s	-
OT.DI22-08	Invisi-Maxx Fixed Screen	0.8mm	1.5m (H) x 1.0m (W)	27m/s	165m

4. Test Summary

Impact - AS/NZS 1170.2, SECTION 2.5.7 & 5.3.2

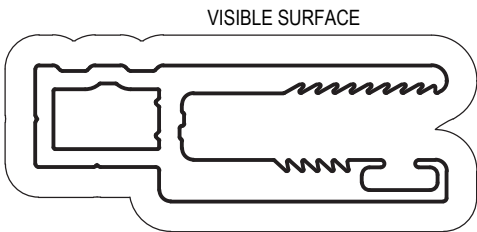
TEST REPORT	PRODUCT DESCRIPTION	MESH THICKNESS	SIZE	RESULT	DEFLECTION
OT.DI23-09	Invisi-Maxx Fixed Screen	1.0mm	1.5m (H) x 1.0m (W)	40m/s	-

5. Extrusions



IMX1
INVISI-MAXX
DOOR FRAME

Anod. Per. 328
Paint Per. 206



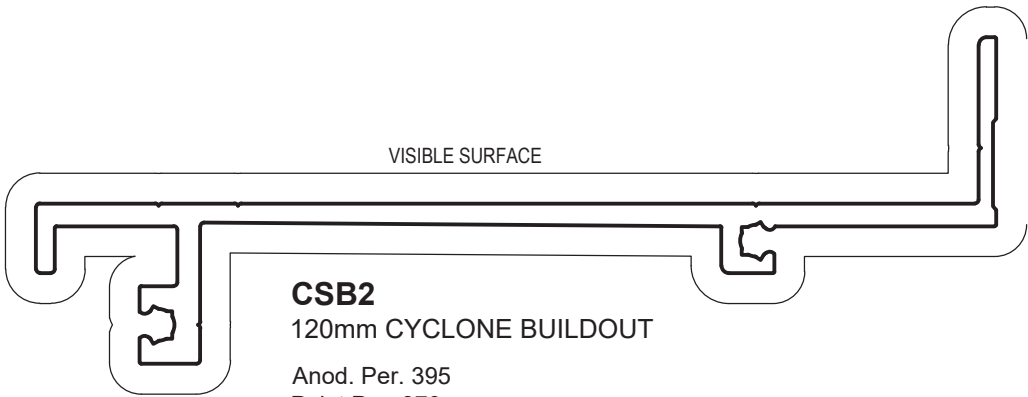
IMXWF1
INVISI-MAXX
WINDOW FRAME

Anod. Per. 251
Paint Per. 140



1020140
FLAT BAR 40 x 3mm

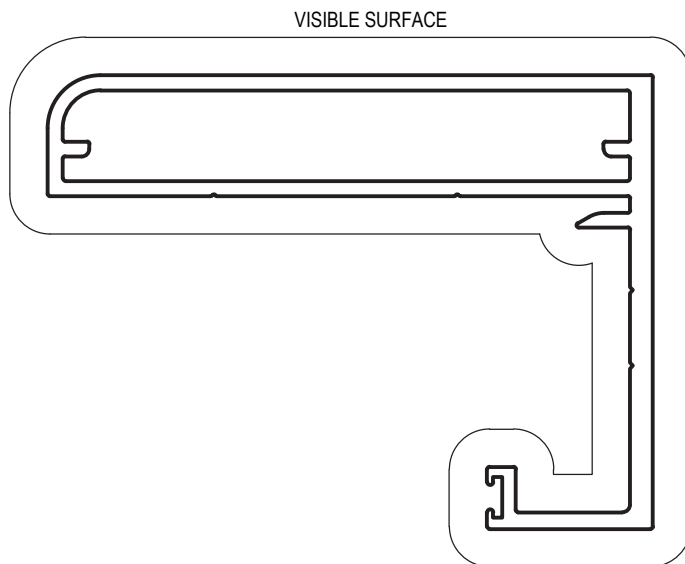
Anod. Per. 100
Paint Per. 100



CSB2
120mm CYCLONE BUILDOUT

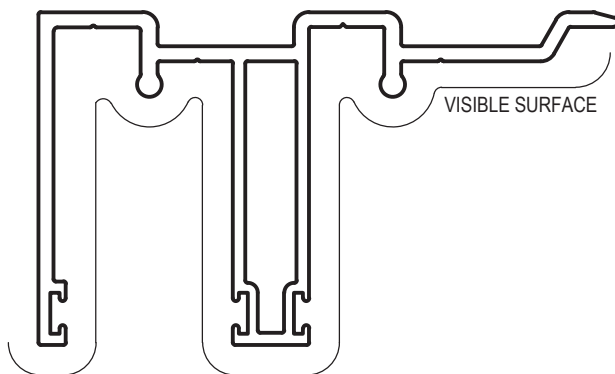
Anod. Per. 395
Paint Per. 370

5. Extrusions



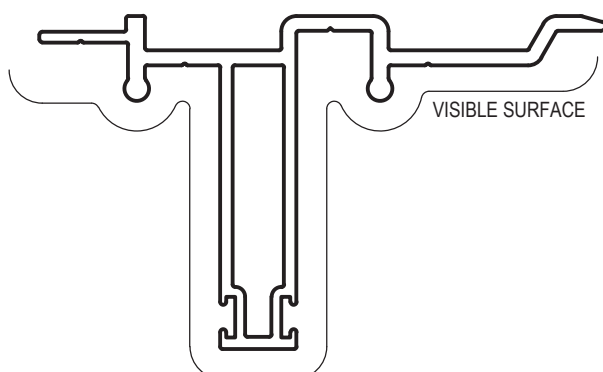
IMXSD1
INVISI-MAXX SLIDING DOOR
PERIMETER FRAME

Anod. Per. 347
Paint Per. 337



IMXSD2
INVISI-MAXX SLIDING DOOR SILL
TRACK ADAPTOR

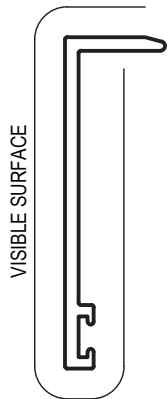
Anod. Per. 388
Paint Per. 183



IMXSD3
INVISI-MAXX SLIDING DOOR
HEAD TRACK ADAPTOR

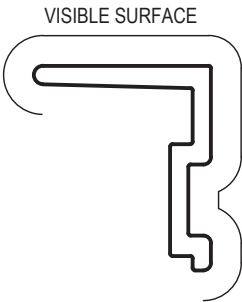
Anod. Per. 290
Paint Per. 146

5. Extrusions



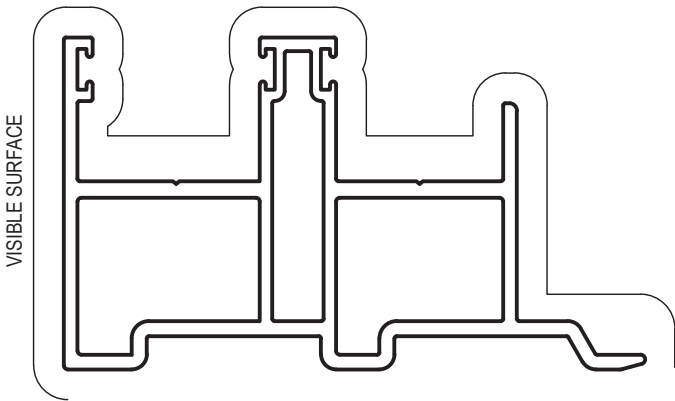
IMXSD4
INVISI-MAXX SLIDING DOOR
HEAD PELMET

Anod. Per. 124
Paint Per. 100



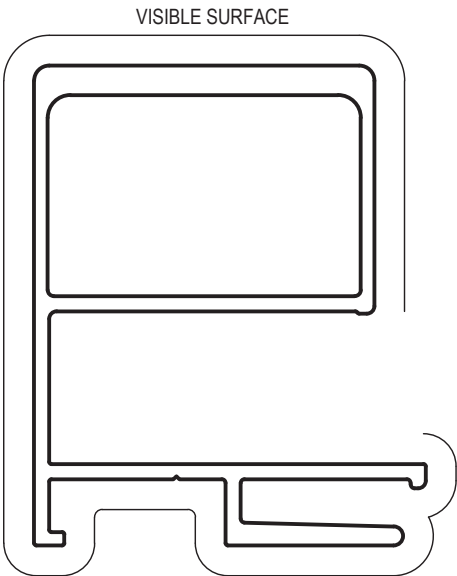
IMXSD6
INVISI-MAXX SLIDING DOOR HD
FRAME MULLION

Anod. Per. 109
Paint Per. 100



IMXSD5
INVISI-MAXX SLIDING DOOR
JAMB ADAPTOR

Anod. Per. 335
Paint Per. 207

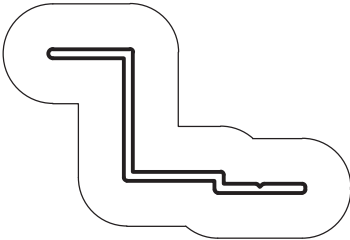


IMXSD7
INVISI-MAXX SLIDING DOOR HD
INTERLOCK MULLION

Anod. Per. 377
Paint Per. 213

5. Extrusions

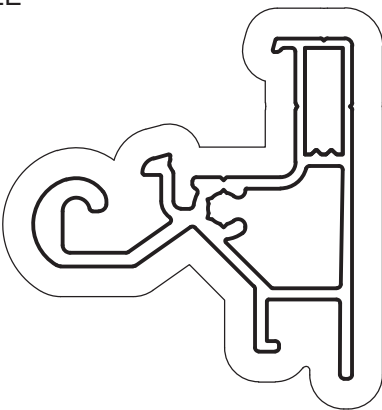
VISIBLE SURFACE



IH
INVISI HANDLE

Anod Per. 105
Paint Per. 105

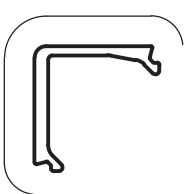
VISIBLE SURFACE



IWF11
PERIMETER HINGE FRAME

Anod Per. 240
Paint Per. 240

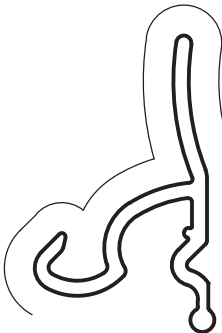
VISIBLE SURFACE



IWF12
FRAME INFILL

Anod Per. 100
Paint Per. 100

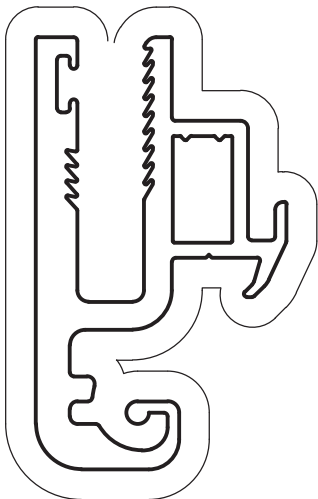
VISIBLE SURFACE



IWF15
ESCAPE HANDLE

Anod Per. 157
Paint Per. 100

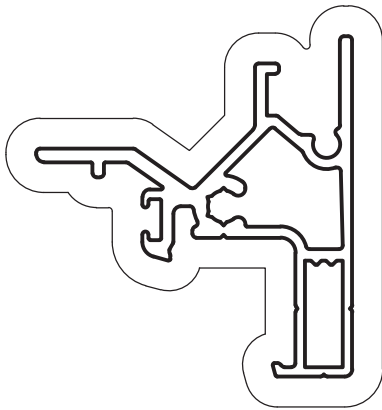
VISIBLE SURFACE



IWF13
INVISI-MAXX
ESCAPE SASH

Anod Per. 351
Paint Per. 239

VISIBLE SURFACE

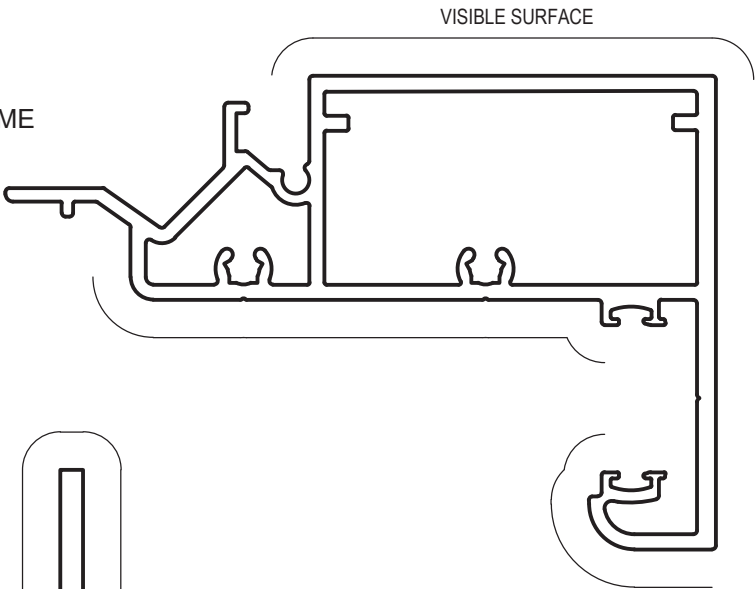


IWF10
PERIMETER FRAME

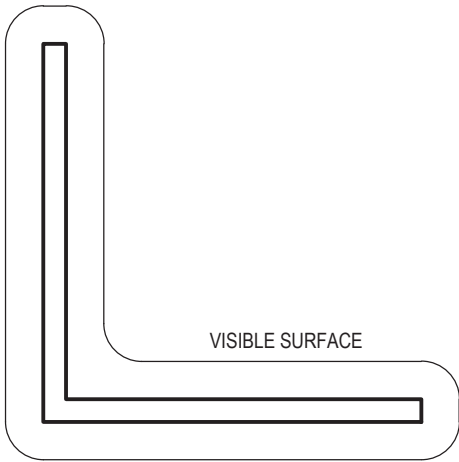
Anod Per. 232
Paint Per. 232

5. Extrusions

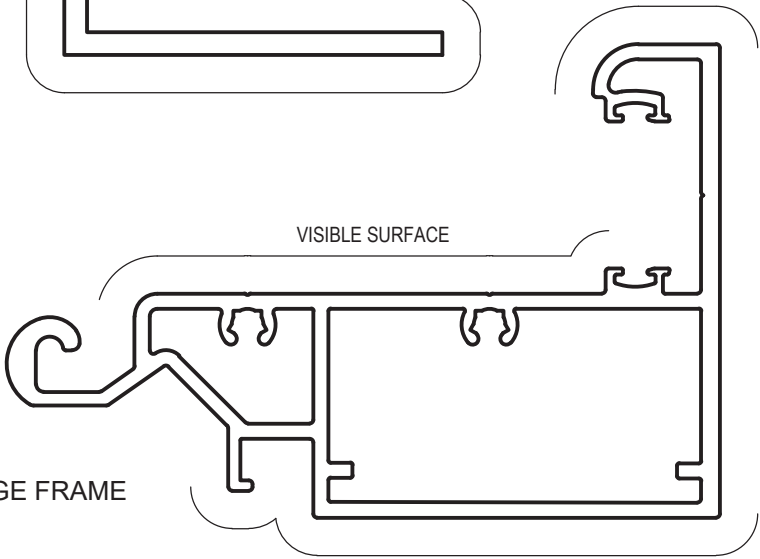
IWF16
INVISI-MAXX ESCAPE
90mm BUILDOUT FRAME
Anod. Per. 416
Paint Per. 145



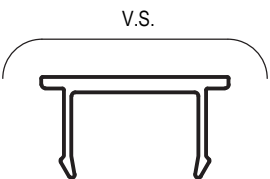
1032102
ANGLE 50 x 50 x 3mm
Anod. Per. 200
Paint Per. 200



IWF17
INVISI-MAXX ESCAPE
90mm BUILDOUT HINGE FRAME
Anod. Per. 432
Paint Per. 155



ME8
POCKET FILLER
Anod. Per. 100
Paint Per. 100



6. Hardware & Components

Seals

IMAGE	PART #	FINISH	DESCRIPTION
	1377201	BLACK (034) GREY (036)	PB48-300-3P WEATHERSEAL x 750m
	1377223	BLACK (034) GREY (036)	PB48-400-3P WEATHERSEAL x 600m

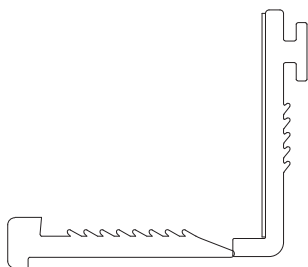
Fasteners

SCREWS			
PART #	HEAD	DESCRIPTION	LOCATION
1383110	SQUARE #2	SECURITY SCREW SQUARE DRIVE WITH PIN 25mm SS x 200 QTBS8G	DOOR CORNER STAKE
1382636	SQUARE #2	8g x 1/2 (13mm) 304SS SQ #2 PAN S/TAP SCREW x 1000	SLIDING DOOR FRAME / SLIDING DOOR MULLION
1382665	SQUARE #2	8g x 1/2 (13mm) 304SS SQ #2 CSK S/TAP SCREW x 1000	SLIDING DOOR PANEL
1382675	SQUARE #2	8g x 5/8 (16mm) 304SS SQ #1 PAN S/TAP SCREW x 1000	SLIDING DOOR FRAME
1382639	SQUARE #2	8g x 1 1/4 (32mm) 304SS SQ #2 PAN S/TAP SCREW x 1000	SLIDING DOOR JAMB ADAPTOR
1382046	PHILLIPS #2	8g x 1 (25mm) SS PHILLIPS PAN S/TAP SCREW x 500	WINDOW SCREEN FRAME / ESCAPE BUILDOUT FRAME
1382048	PHILLIPS #2	8g x 1 1/4 (32mm) SS PHILLIPS PAN S/TAP x 500	WINDOW SCREEN FRAME
1382050	PHILLIPS #2	8g x 1 1/2 (40mm) SS PHILLIPS PAN SELF TAPPING x 500	
1382054	PHILLIPS #2	10g x 1 (25mm) SS PHIL PAN S/TAP SCREW x 500	ESCAPE FRAME
1382058	PHILLIPS #2	10g x 2 (51mm) SS PHIL PAN S/TAP SCREW x 500	ESCAPE BUILDOUT FRAME

RIVETS		
PART #	DESCRIPTION	LOCATION
1380167	AS5-4 STAINLESS STEEL RIVETS x 1000 MILL	DOOR CORNER STAKE
1380161	AS4-3 STAINLESS STEEL RIVETS x 1000 MILL	WINDOW CORNER STAKE
1380163	AS4-2 STAINLESS STEEL RIVETS x 1000 MILL	ESCAPE CORNER STAKE

6. Hardware & Components

Accessories



IMXWDG INVISIMAXX WEDGE/ INSULATOR 20 x 4m

PART	1409525
FINISH	BLACK (034)
QTY	PACK



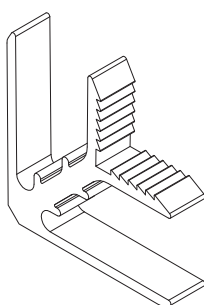
IMXKH KEEPER FOR HD MESH 1.2mm x 80m ROLL

PART	1409545
FINISH	BLACK (034)
QTY	ROLL



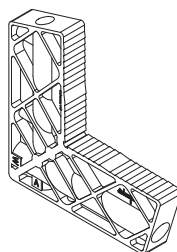
IMXKS KEEPER FOR STANDARD MESH 0.8mm x 80m ROLL

PART	1409540
FINISH	BLACK (034)
QTY	ROLL



P2 HEAVY DUTY SEC DOOR CORNER

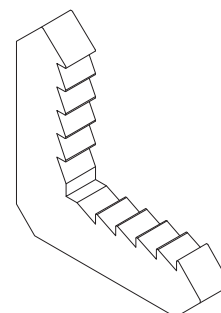
PART	1311211
FINISH	MILL (001)
QTY	EACH



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

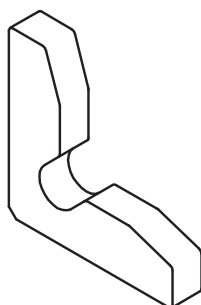
P3A NYLON CORNER STAKE WITH FLUSH BOLT HOLE x 1

PART	1311243
FINISH	BLACK (034)
QTY	EACH



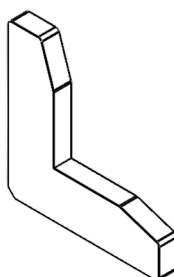
P5 SEC WINDOW CORNER

PART	1311226
FINISH	NOT SPECIFIED (099)
QTY	EACH



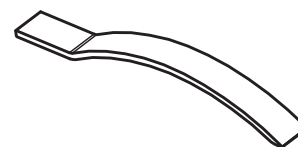
P5B STRAIGHT EDGE SEC WINDOW CORNER

PART	1311229
FINISH	NOT SPECIFIED (099)
QTY	EACH



P13 CORNERS (SUITS SW3)

PART	1311237
FINISH	NOT SPECIFIED (099)
QTY	EACH

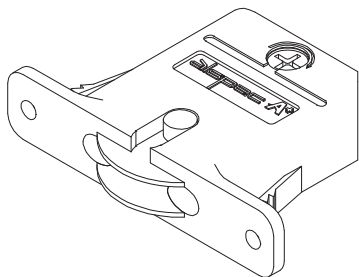


IOOSSB INVISI S/S BOWSPRINGS

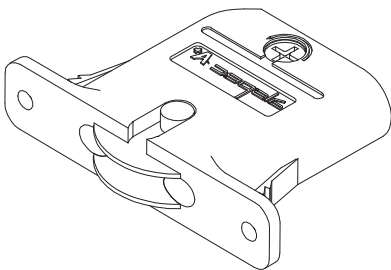
PART	1409036
FINISH	STAINLESS STEEL (0G8)
QTY	EACH

6. Hardware & Components

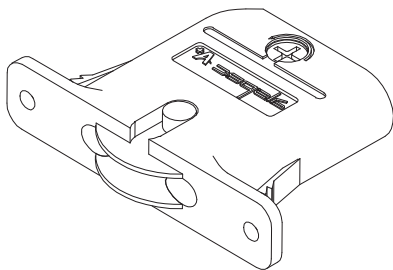
Accessories



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

6. Hardware & Components

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

* Monument Finish is not available at the moment

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

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

Refer to page 6.6 for cylinders

6. Hardware & Components

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 6.6 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



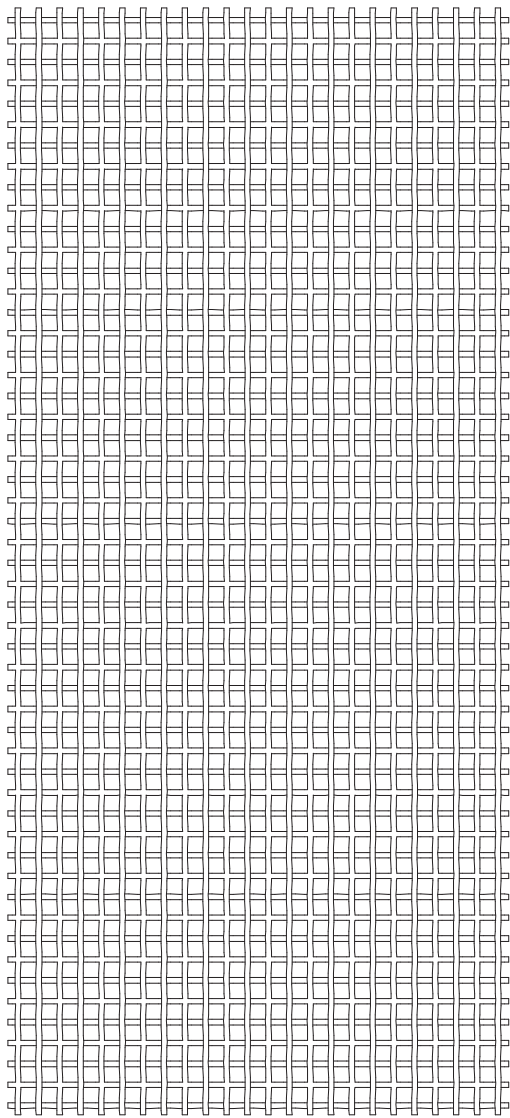
* For Asim Hinged Hook Bolt
Security Locks

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

PART	1308751
FINISH	NOT SPECIFIED (099)
QTY	EACH

6. Hardware & Components

0.8mm Stainless Steel Mesh Sheet Sizes

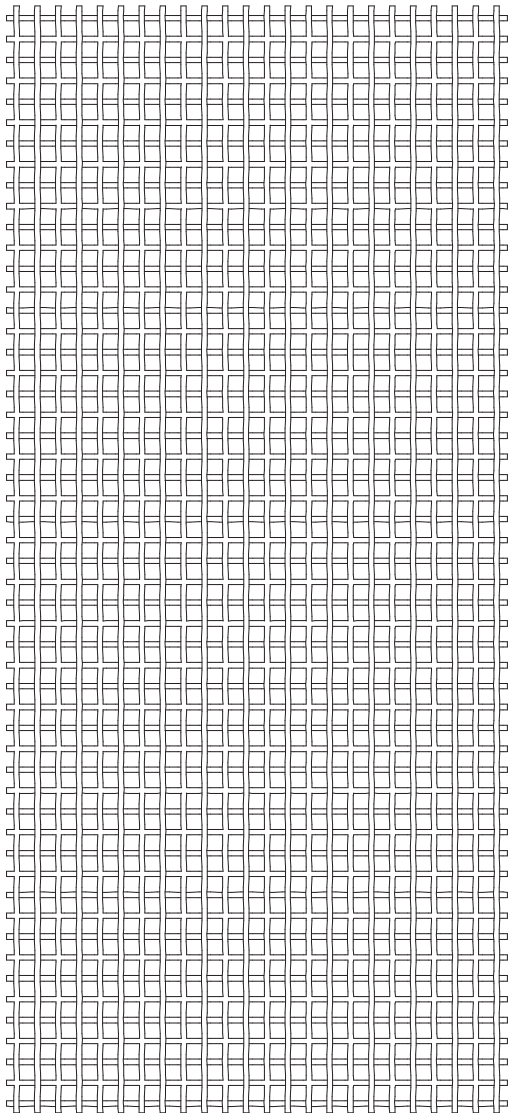


STAINLESS STEEL MESH (0.8mm) SATIN BLACK		
SIZE	PACK QTY.	PART NO.
750 x 2000	5	1409200
	50	1409201
750 x 2400	5	1409220
	50	1409221
750 x 3000	5	1409240
	50	1409241
900 x 2000	5	1409205
	50	1409206
900 x 2400	5	1409225
	50	1409226
900 x 3000	3	1409245
1200 x 2000	5	1409210
	50	1409211
1200 x 2400	3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

1.2mm Mesh must be used for Impact ratings above 36m/s

6. Hardware & Components

1.2mm Stainless Steel Mesh Sheet Sizes

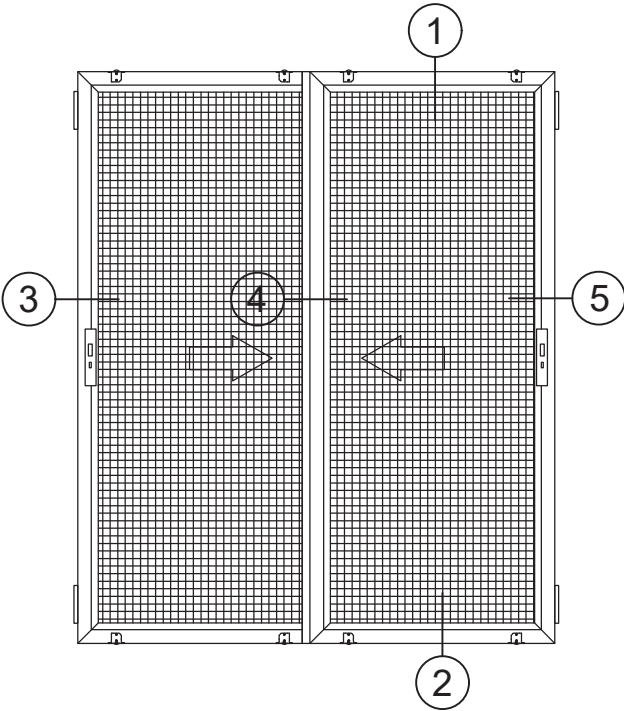


STAINLESS STEEL MESH (1.2mm) SATIN BLACK	
SIZE	PART NO.
750 x 2000	1409305
750 x 2400	1409310
750 x 3000	1409315
900 x 2000	1409320
900 x 2400	1409325
900 x 3000	1409330
1200 x 2000	1409335
1200 x 2400	1409340
1200 x 3000	1409345

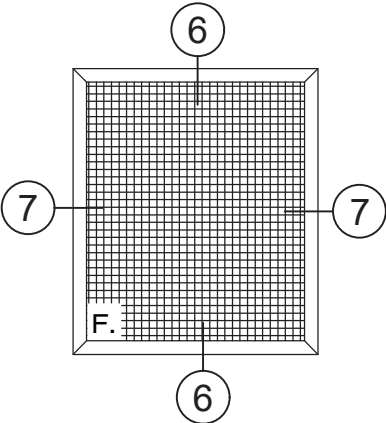
1.2mm Mesh must be used for Impact ratings above 36m/s

7. Typical Elevation

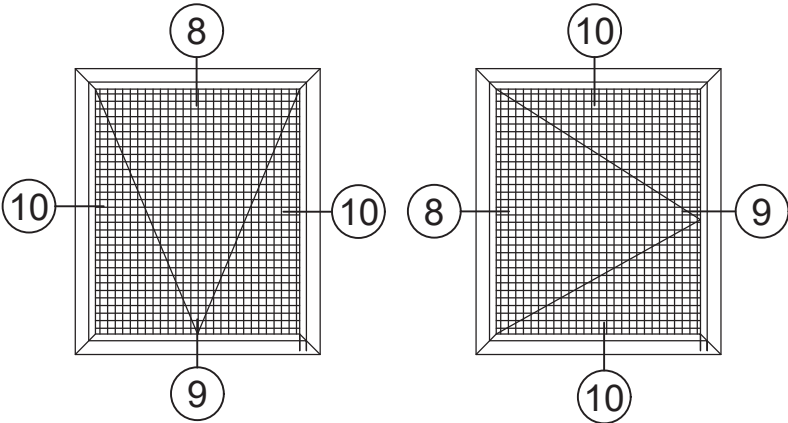
SLIDING DOOR SCREEN



WINDOW SCREEN

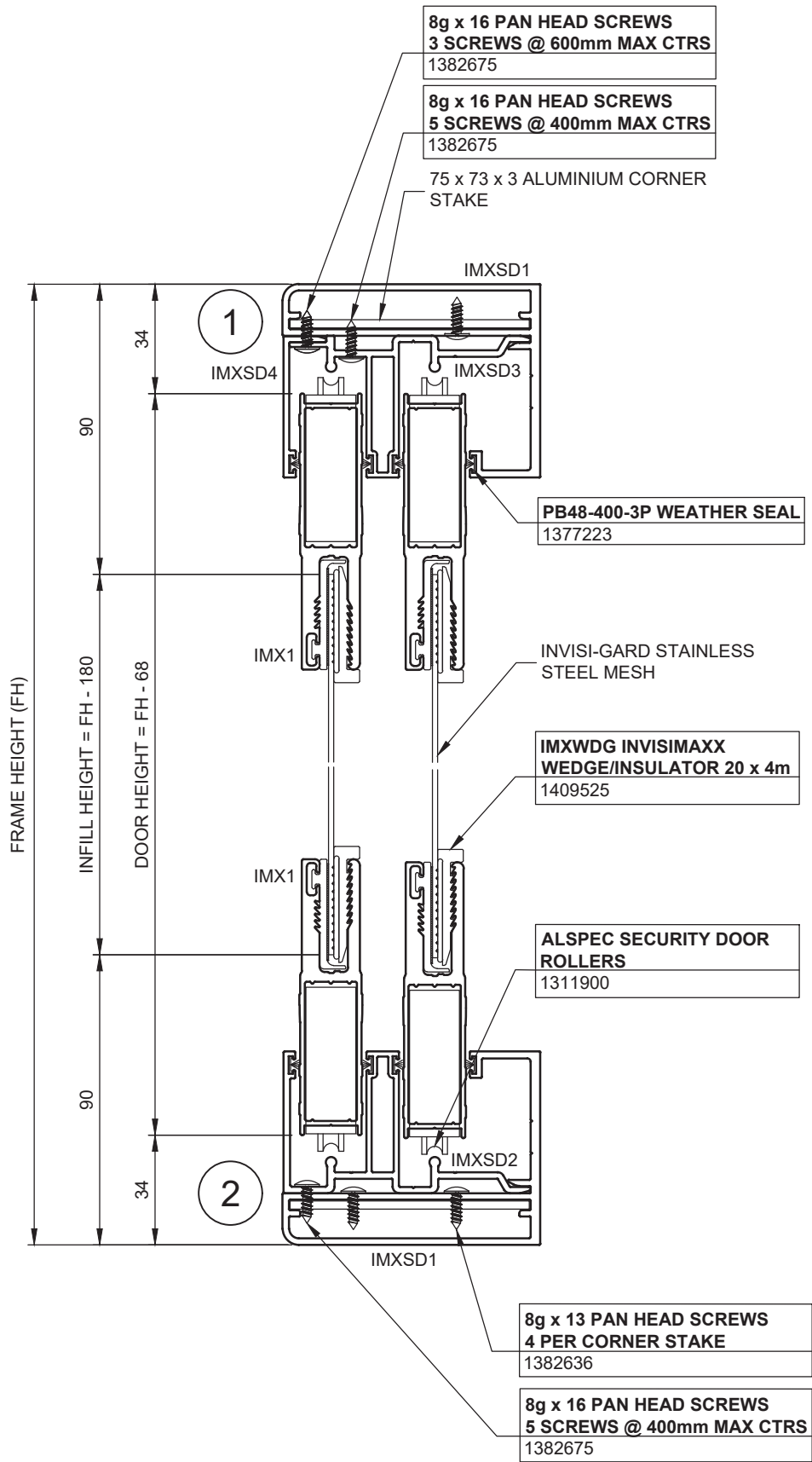


INVISI-MAXX ESCAPE SCREENS



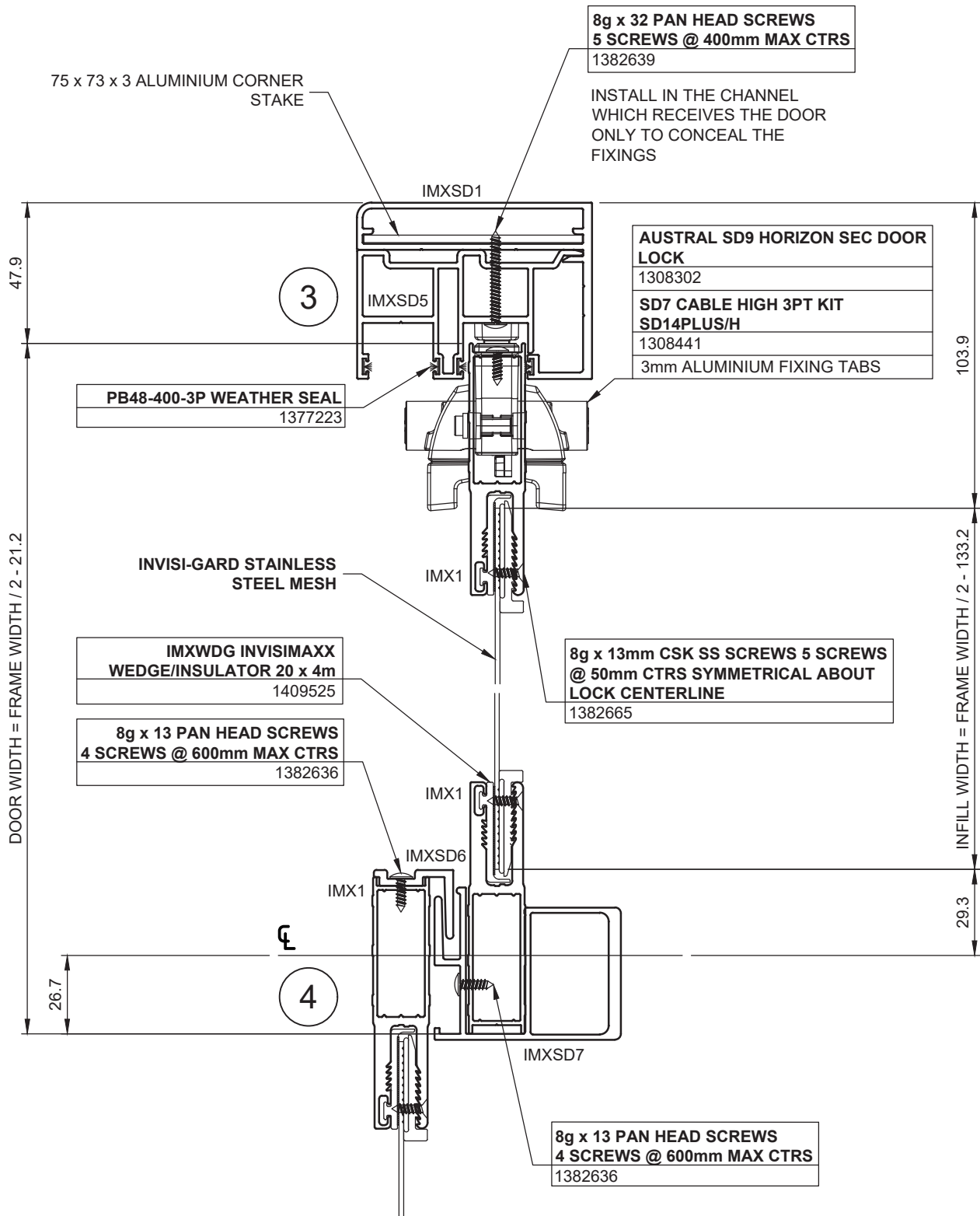
8. Typical Details

Invisi-Maxx Sliding Door Head and Sill Details - IMX1



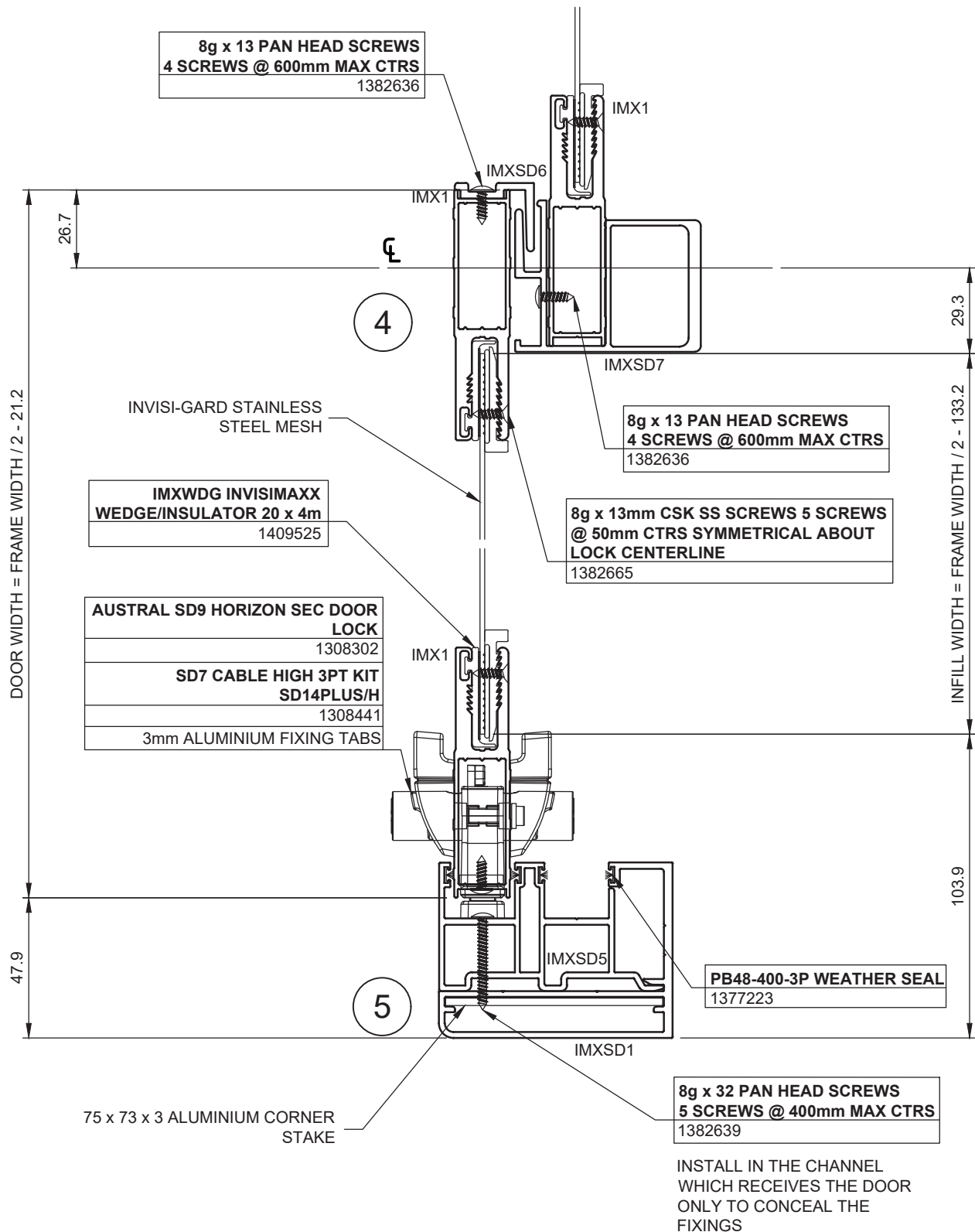
8. Typical Details

Invisi-Maxx Sliding Door Jamb and Mullion Details - IMX1



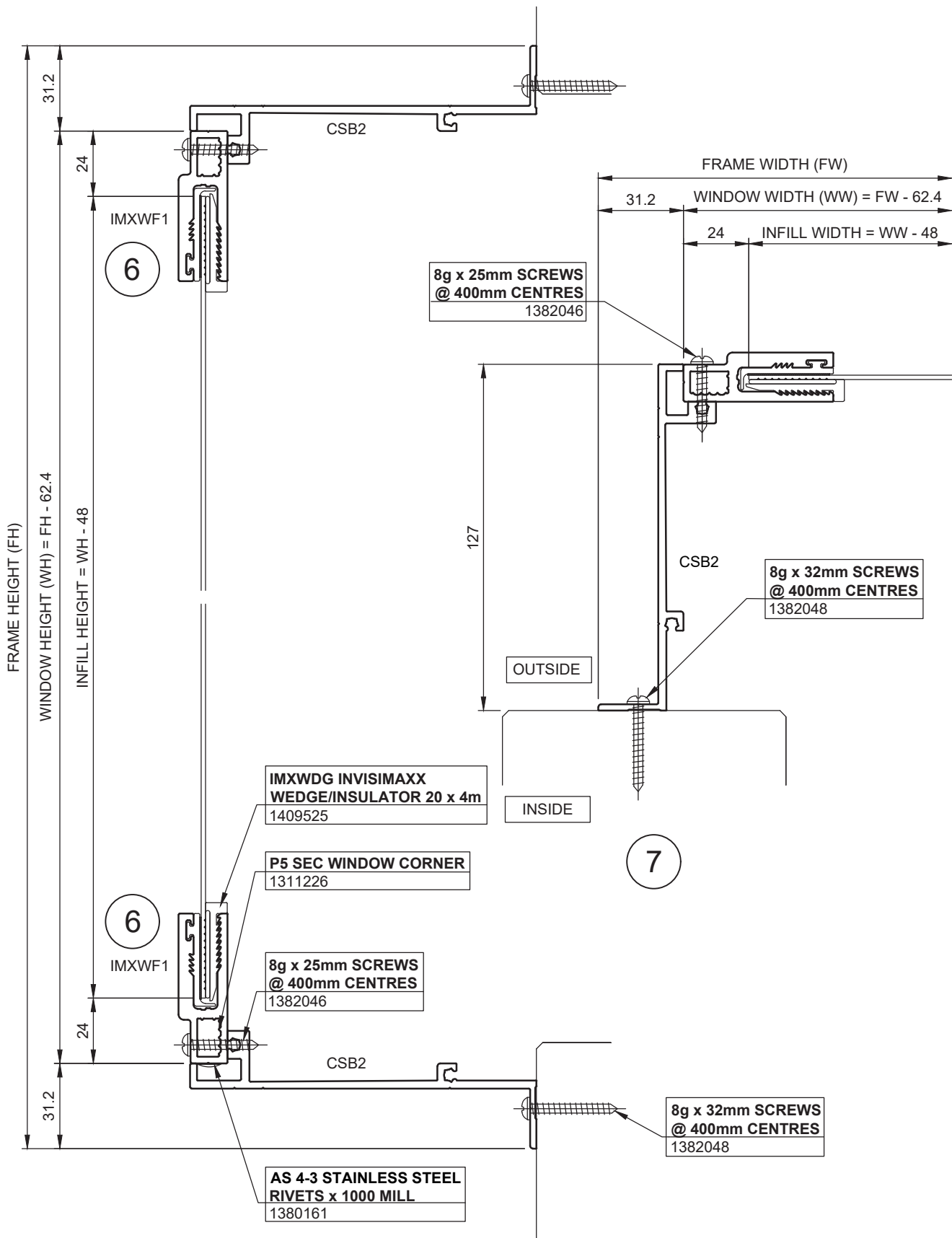
8. Typical Details

Invisi-Maxx Sliding Door Jamb and Mullion Details - IMX1



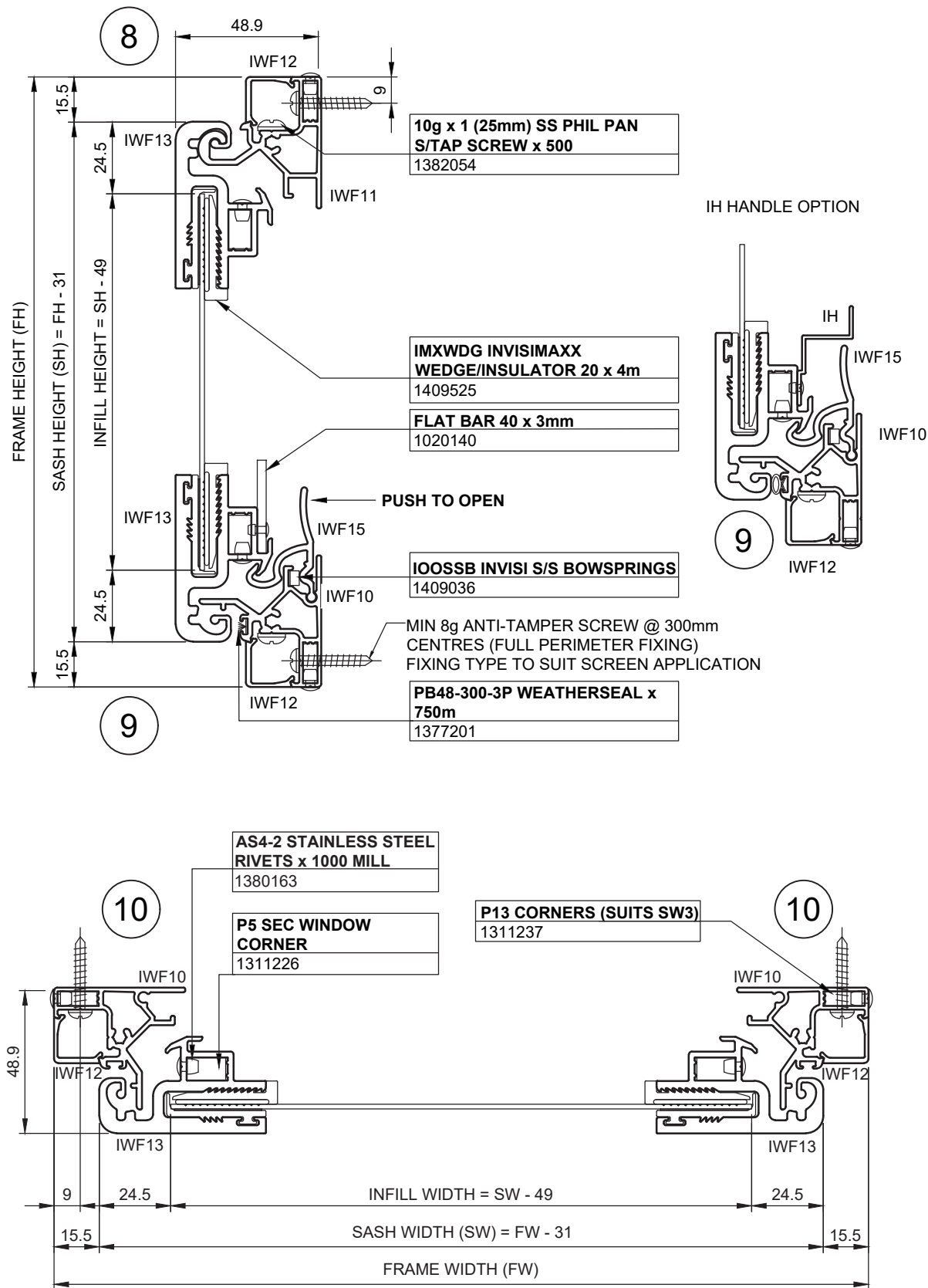
8. Typical Details

Invisi-Maxx Window Screen - IMXWF1



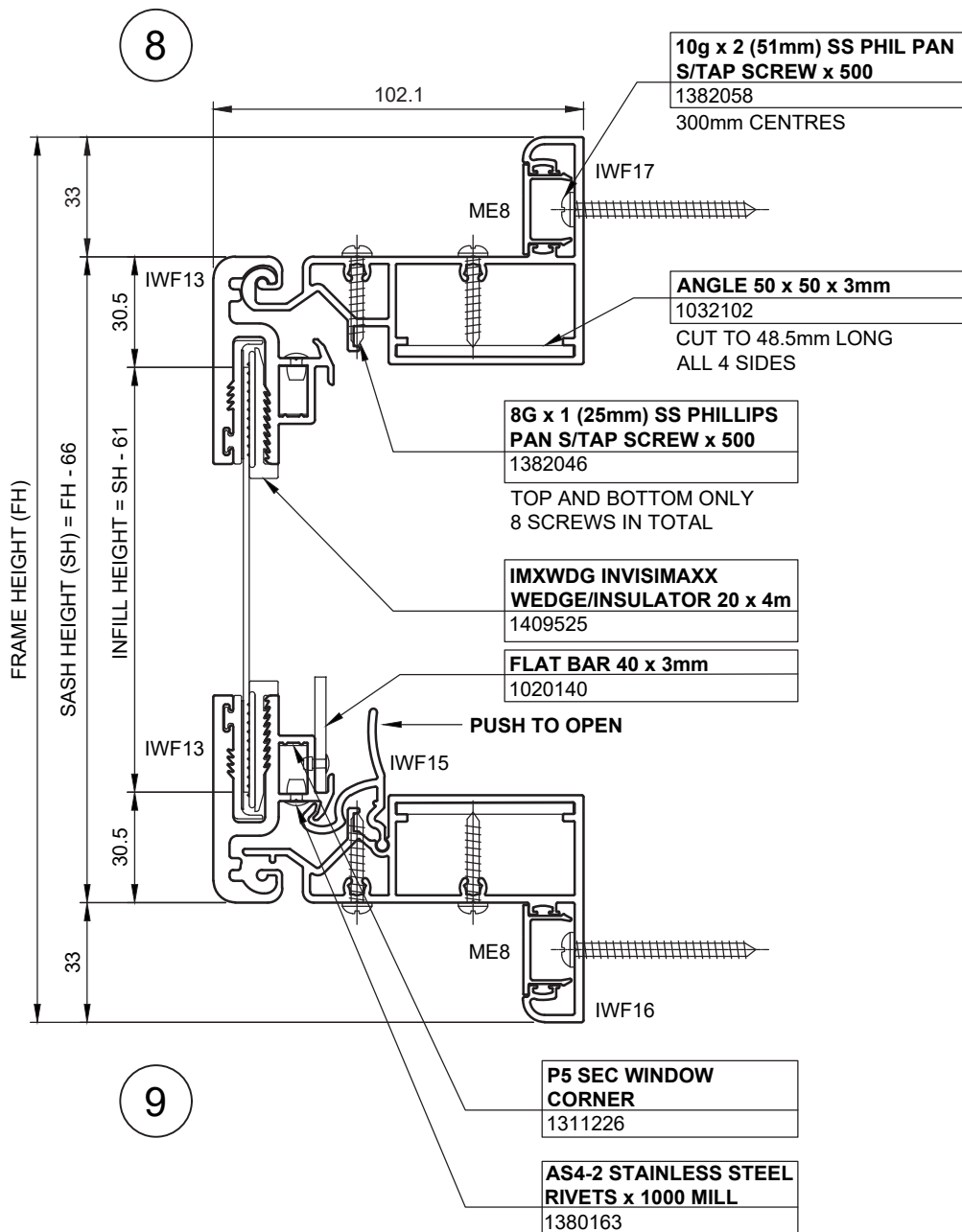
8. Typical Details

Invisi-Maxx Escape Screen - Open Out



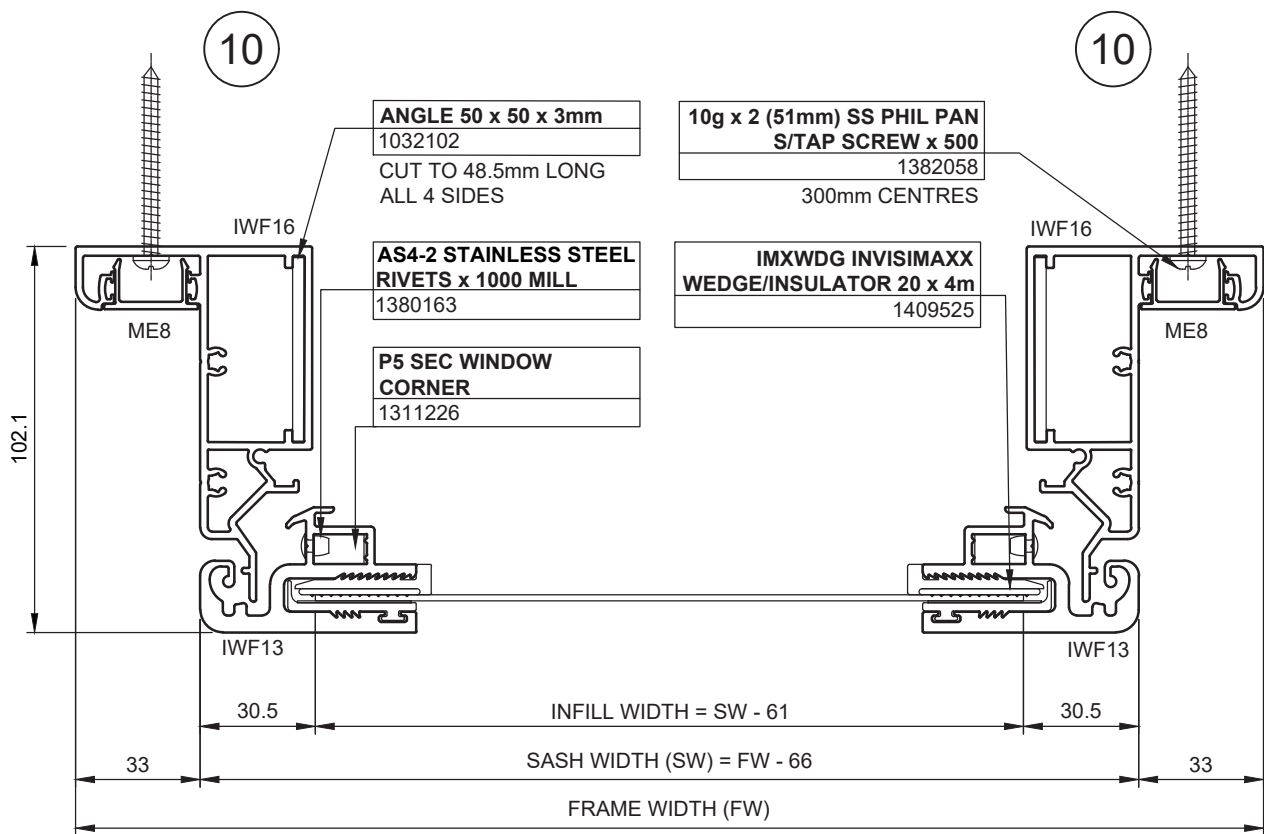
8. Typical Details

Invisi-Maxx Escape Buildout Screen Head and Sill Details - Open Out



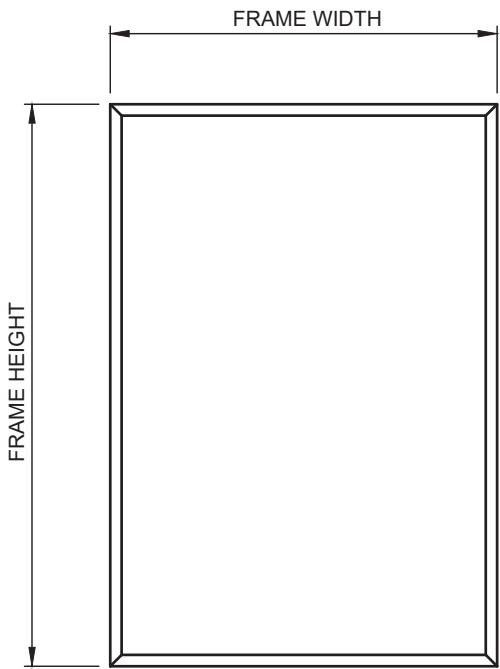
8. Typical Details

Invisi-Maxx Escape Buildout Screen Jamb Details - Open Out



9. Cutting Formulas

Hinged / Sliding Door

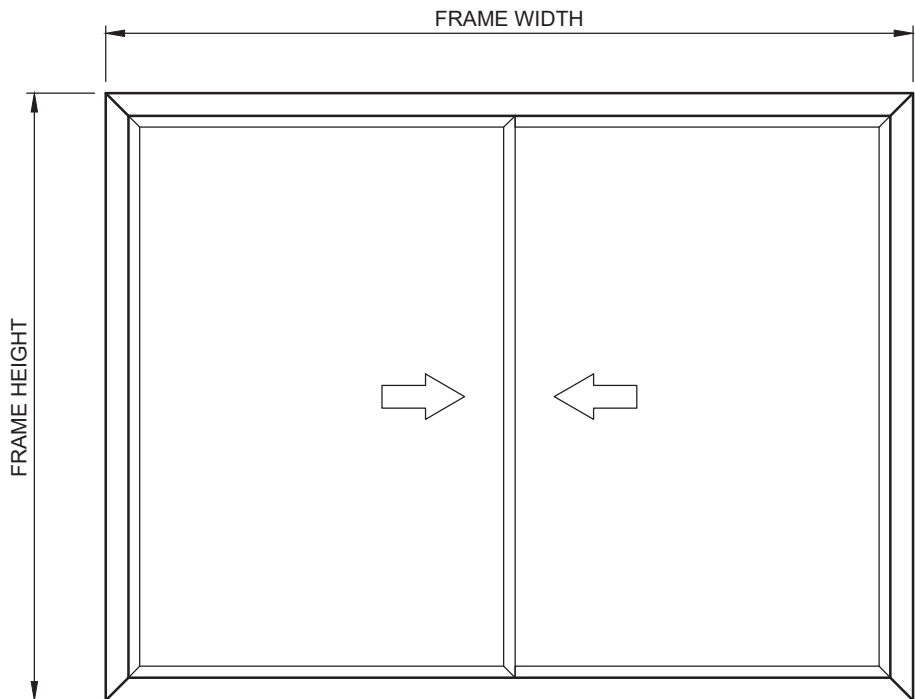


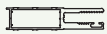
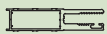
PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IMX1	Door Frame	Frame Height *	2
	IMX1	Door Frame	Frame Width *	2
MESH	HEIGHT		Frame Height - 112	1
	WIDTH		Frame Width - 112	

* Mitre cut both ends 45°

9. Cutting Formulas

Sliding Door with Frame

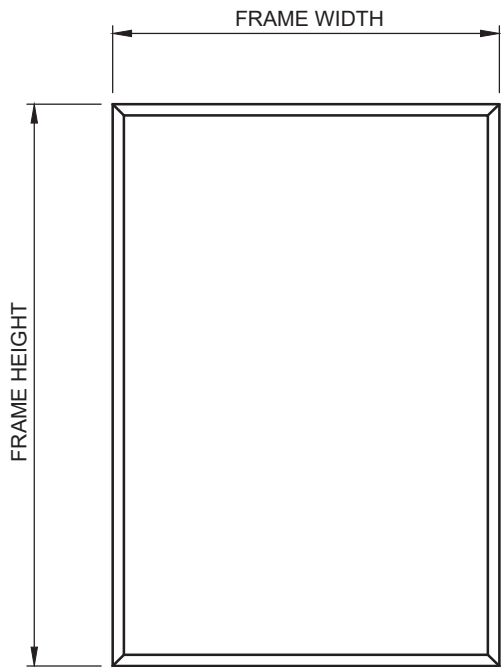


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IMX1	Door Frame	Frame Height - 68 *	4
	IMX1	Door Frame	Frame Width / 2 - 21 *	4
	IMXSD1	Perimeter Frame	Frame Height *	2
	IMXSD1	Perimeter Frame	Frame Width *	2
	IMXSD2	Sill Track Adaptor	Frame Width - 120	1
	IMXSD3	Head Track Adaptor	Frame Width - 120	1
	IMXSD4	Head Pelmet	Frame Width - 120	1
	IMXSD5	Jamb Adaptor	Frame Height - 32	2
	IMXSD6	HD Frame Mullion	Frame Height - 124	1
	IMXSD7	HD Interlock Mullion	Frame Height - 124	1
MESH	HEIGHT		Frame Height - 180	2
	WIDTH		Frame Width / 2 - 133	

* Mitre cut both ends 45°

9. Cutting Formulas

Window Screen

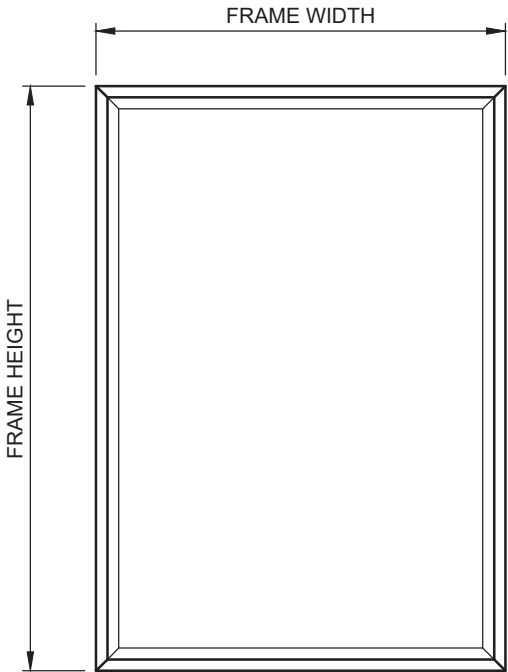


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IMXWF1	Window Frame	Frame Height *	2
	IMXWF1	Window Frame	Frame Width *	2
MESH	HEIGHT		Frame Height - 48	1
	WIDTH		Frame Width - 48	

* Mitre cut both ends 45°

9. Cutting Formulas

Window Screen with Frame

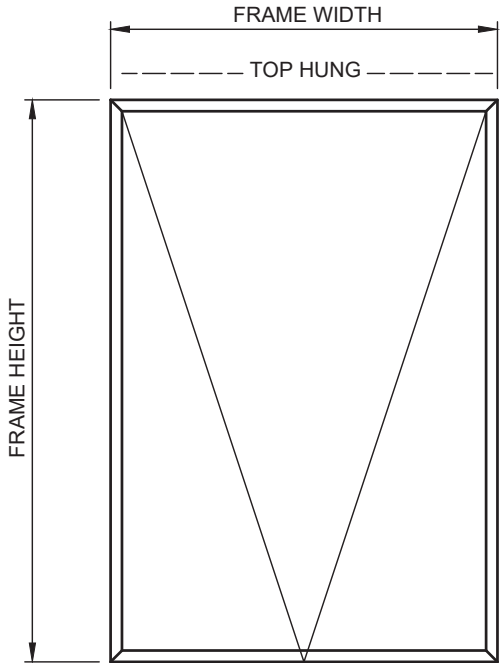


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IMXWF1	Window Frame	Frame Height - 62 *	2
	IMXWF1	Window Frame	Frame Width - 62 *	2
	CSB2	120mm Cyclone Buildout	Frame Height *	2
	CSB2	120mm Cyclone Buildout	Frame Width *	2
MESH	HEIGHT		Frame Height - 110	1
	WIDTH		Frame Width - 110	

* Mitre cut both ends 45°

9. Cutting Formulas

Invisi-Maxx Escape Outward Opening Screen - Top Hung

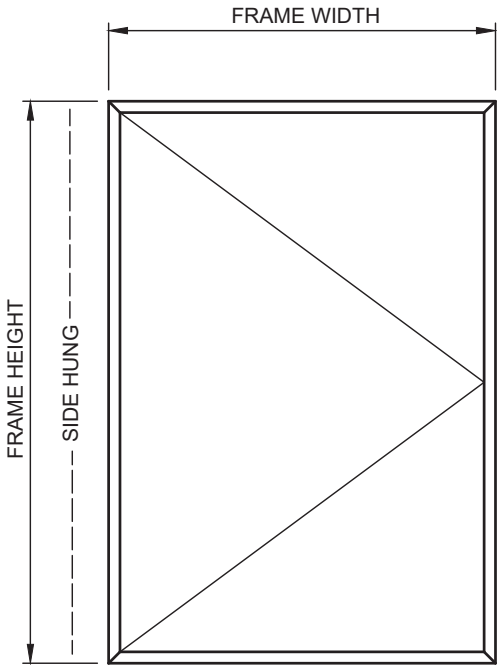


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IWF10	Perimeter Frame	Frame Height *	2
	IWF10	Perimeter Frame	Frame Width *	1
	IWF11	Hinge Frame	Frame Width *	1
	IWF12	Frame Infill	Frame Width *	2
	IWF12	Frame Infill	Frame Height *	2
	IWF15	Lock Handle	Frame Width - 86	1
	IWF13	Sash Frame	Frame Height - 31 *	2
	IWF13	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	

* Mitre cut both ends 45°

9. Cutting Formulas

Invisi-Maxx Escape Outward Opening Screen - Side Hung

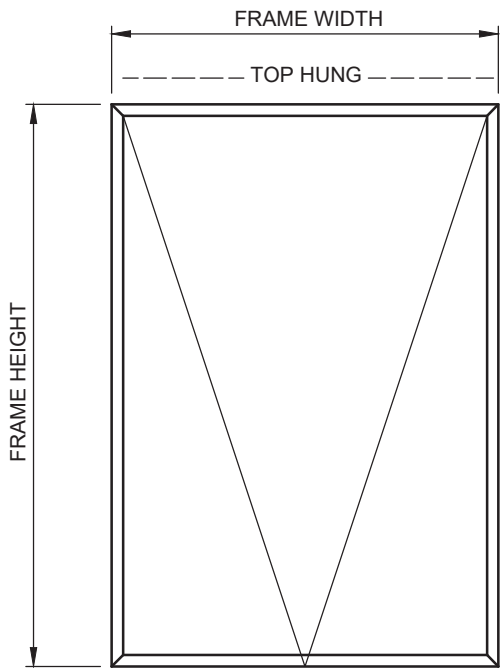


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IWF10	Perimeter Frame	Frame Height *	1
	IWF10	Perimeter Frame	Frame Width *	2
	IWF11	Hinge Frame	Frame Height *	1
	IWF12	Frame Infill	Frame Width *	2
	IWF12	Frame Infill	Frame Height *	2
	IWF15	Lock Handle	Frame Height - 86	1
	IWF13	Sash Frame	Frame Height - 31 *	2
	IWF13	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	

* Mitre cut both ends 45°

9. Cutting Formulas

Invisi-Maxx Escape Buildout Outward Opening Screen - Top Hung

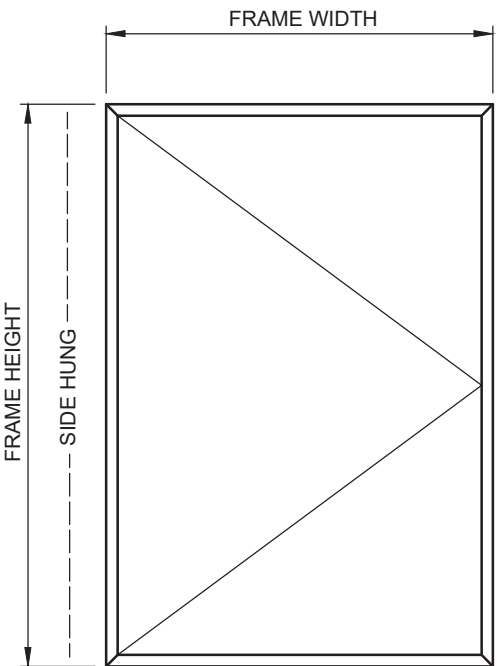


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IWF16	Buildout Frame	Frame Height *	2
	IWF16	Buildout Frame	Frame Width *	1
	IWF17	Hinge Frame	Frame Width *	1
	ME8	Pocket Filler	Frame Height - 16 *	2
	ME8	Pocket Filler	Frame Width - 16 *	2
	IWF15	Lock Handle	Frame Width - 122	1
	IWF13	Sash Frame	Frame Height - 66 *	2
	IWF13	Sash Frame	Frame Width - 66 *	2
	40 x 3 FLAT	Sash Handle	Frame Width - 132	1
MESH	HEIGHT		Frame Height - 127	1
	WIDTH		Frame Width - 127	

* Mitre cut both ends 45°

9. Cutting Formulas

Invisi-Maxx Escape Buildout Outward Opening Screen - Side Hung

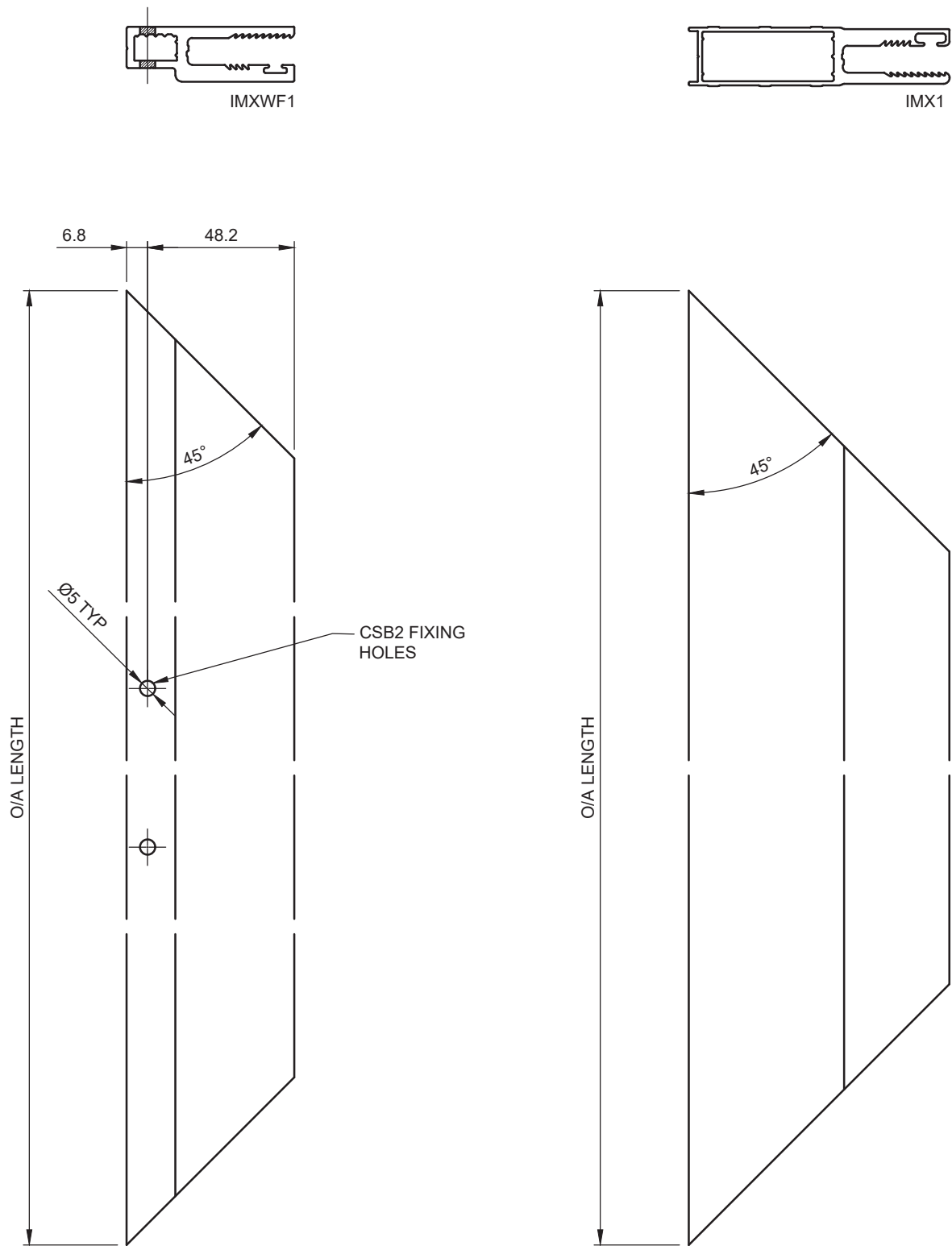


PROFILE	SECTION NO.	DESCRIPTION	CUTTING FORMULA	QTY
	IWF16	Buildout Frame	Frame Height *	1
	IWF16	Buildout Frame	Frame Width *	2
	IWF17	Hinge Frame	Frame Height *	1
	ME8	Pocket Filler	Frame Height - 16 *	2
	ME8	Pocket Filler	Frame Width - 16 *	2
	IWF15	Lock Handle	Frame Height - 122	1
	IWF13	Sash Frame	Frame Height - 66 *	2
	IWF13	Sash Frame	Frame Width - 66 *	2
	40 x 3 FLAT	Sash Handle	Frame Height - 132	1
MESH	HEIGHT		Frame Height - 127	1
	WIDTH		Frame Width - 127	

* Mitre cut both ends 45°

10. Manufacturing Details

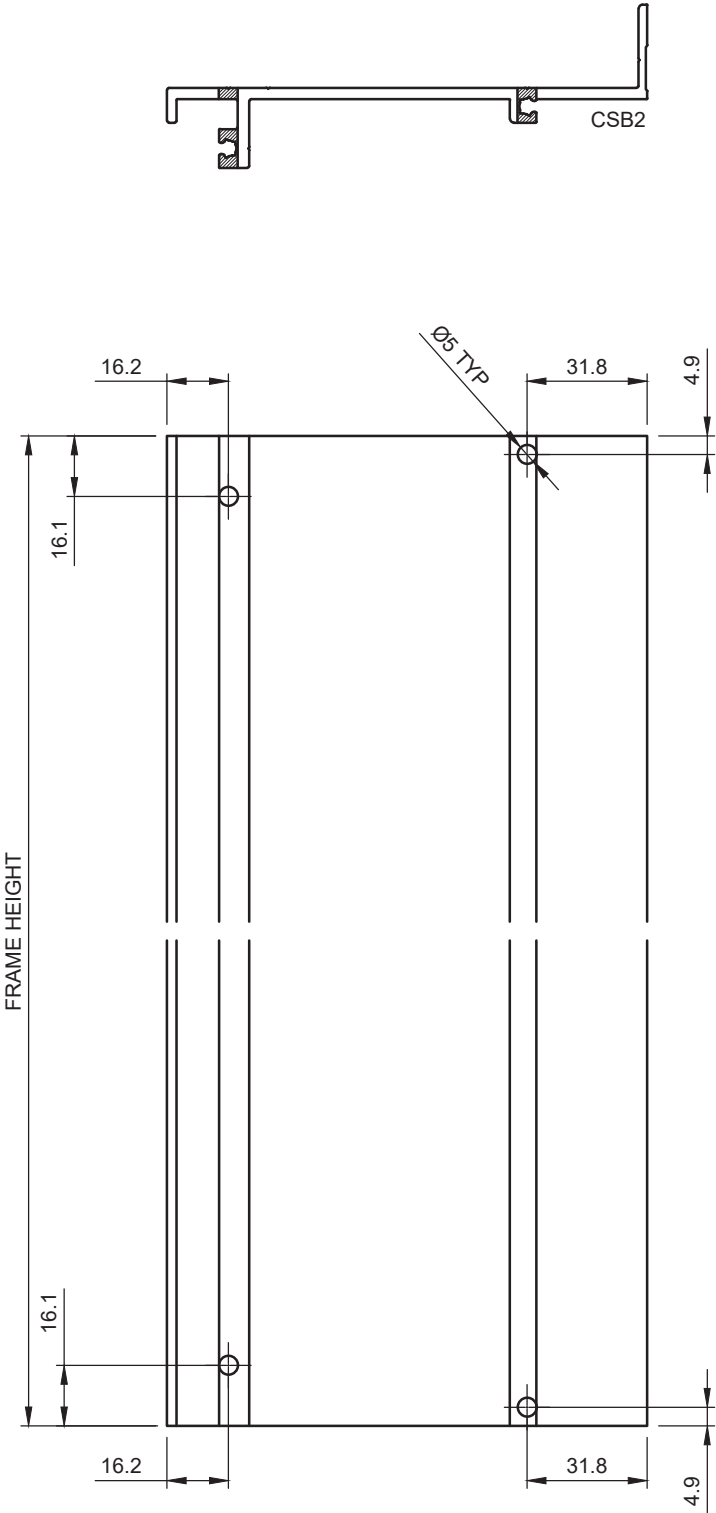
Stile and Rail Preparation



NOTE: ALL PERIMETER FRAMES AND SASH SECTIONS ARE MITRE CUT

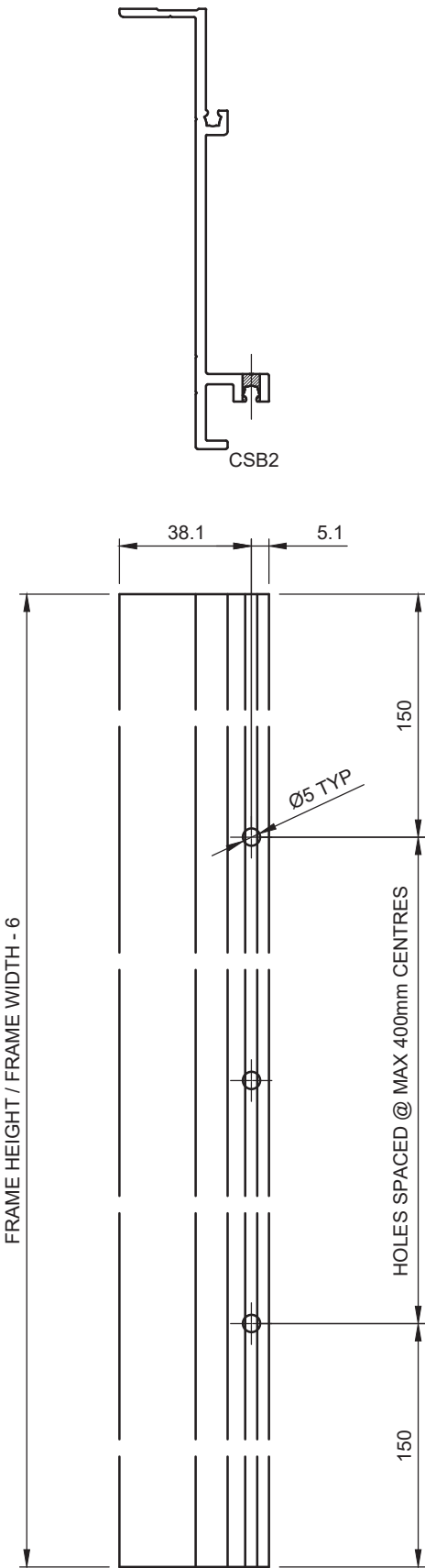
10. Manufacturing Details

CSB2 120mm Cyclone Build-out Jamb Mitre Preparation



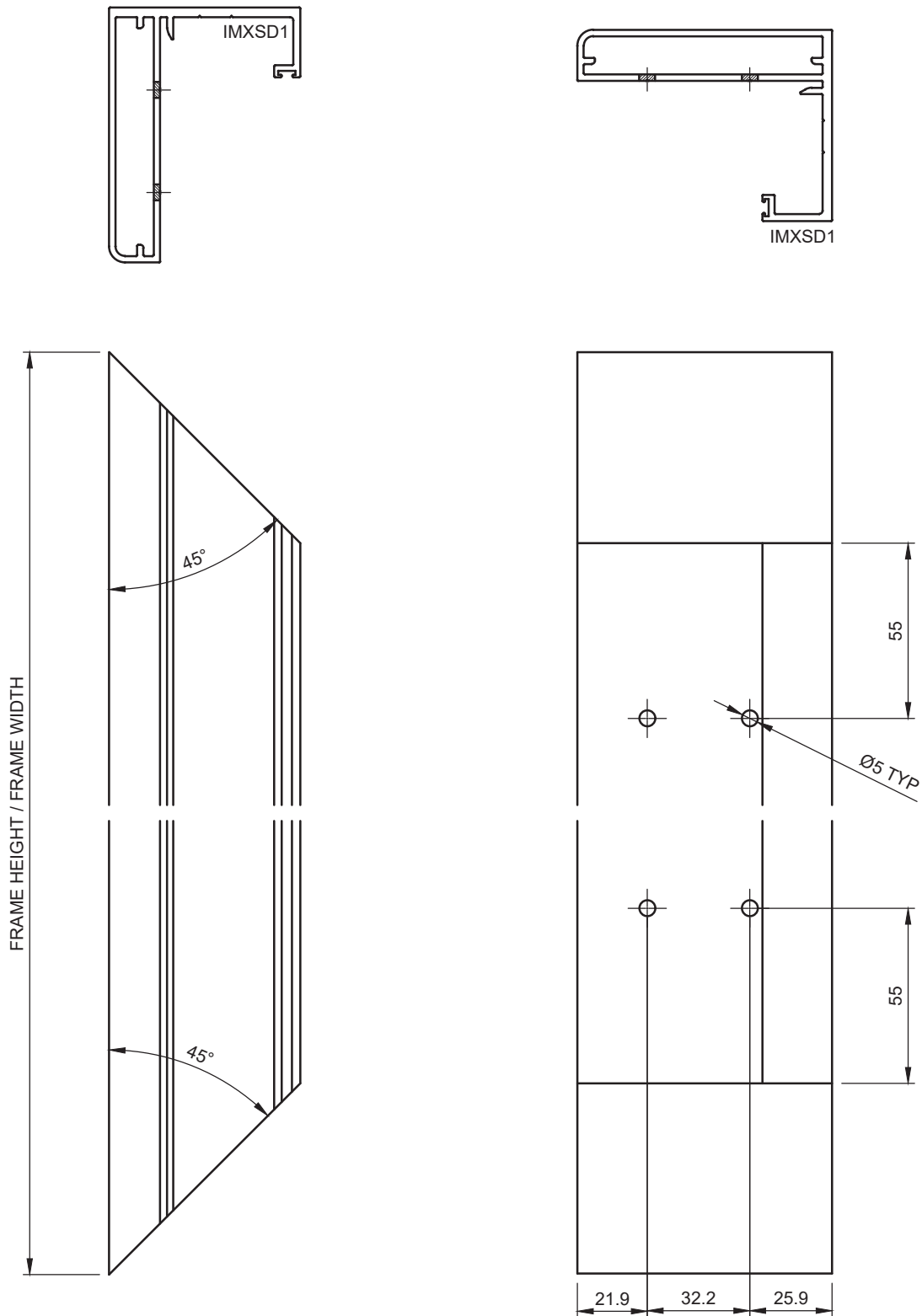
10. Manufacturing Details

CSB2 120mm Cyclone Build-out Jamb Fixing Holes



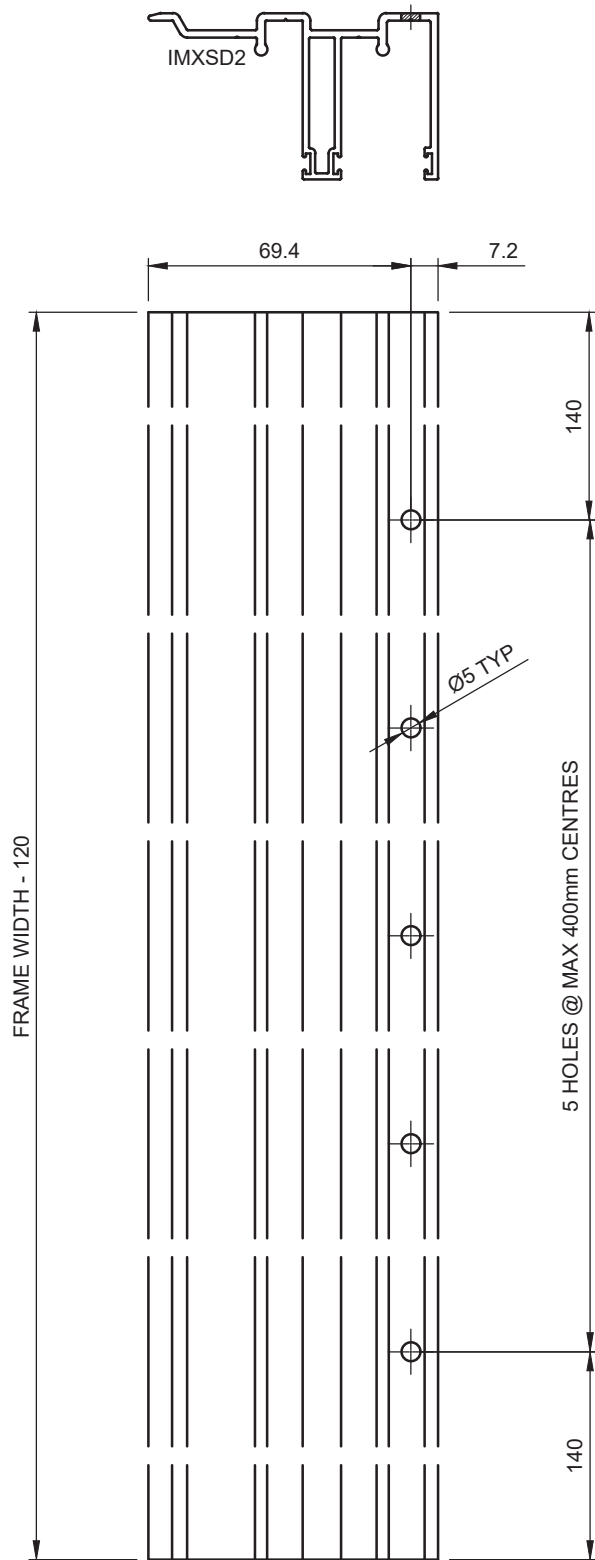
10. Manufacturing Details

IMXSD1 Perimeter Frame Preparation



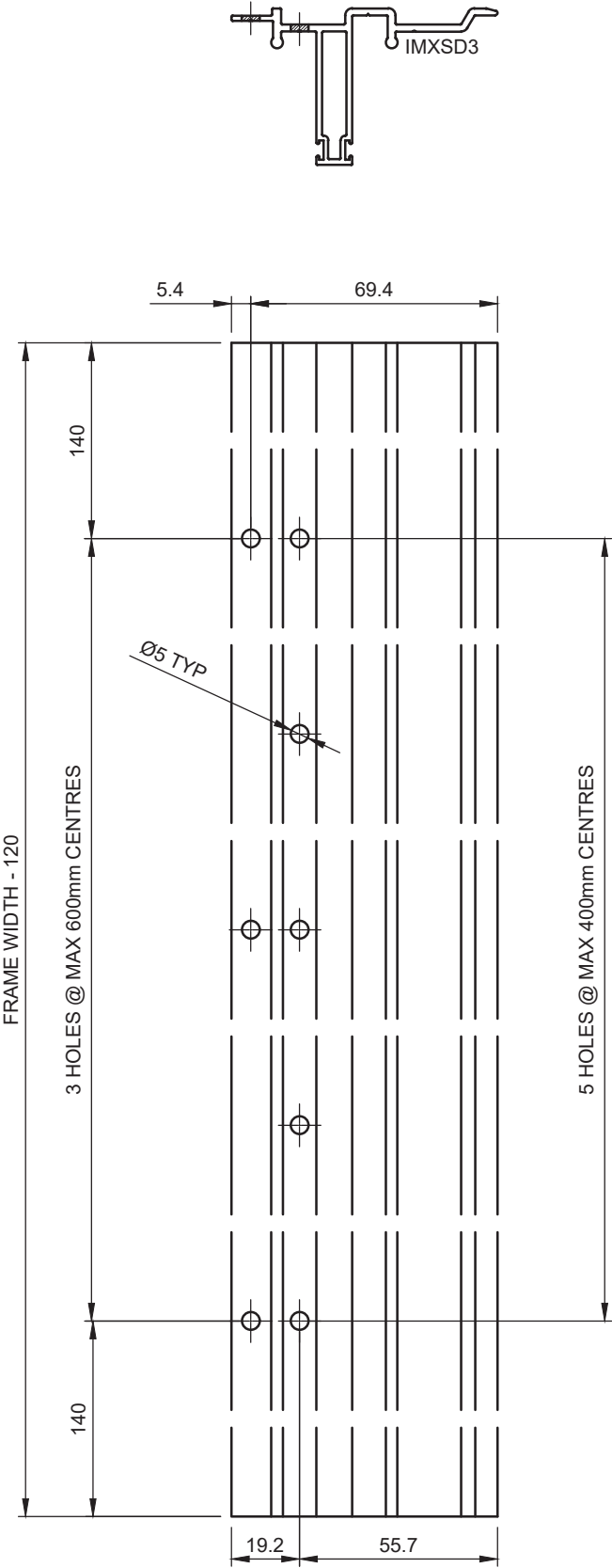
10. Manufacturing Details

IMXSD2 Sill Track Adaptor Fixing Holes



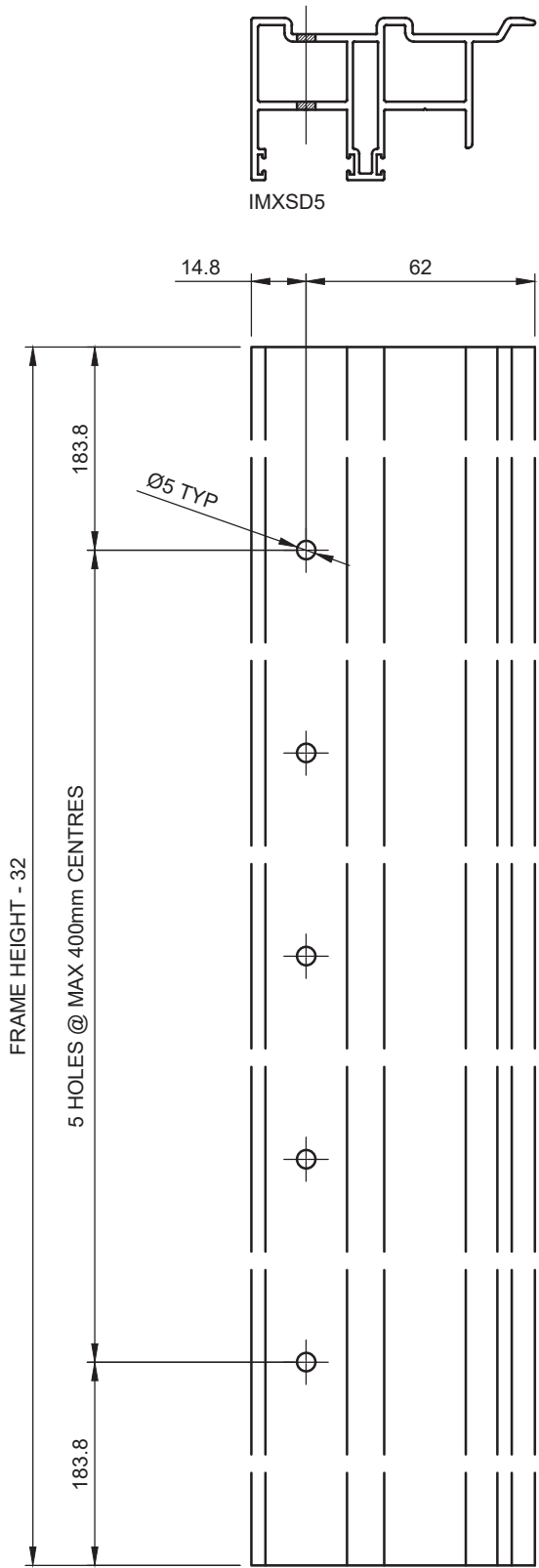
10. Manufacturing Details

IMXSD3 Head Track Adaptor Fixing Holes



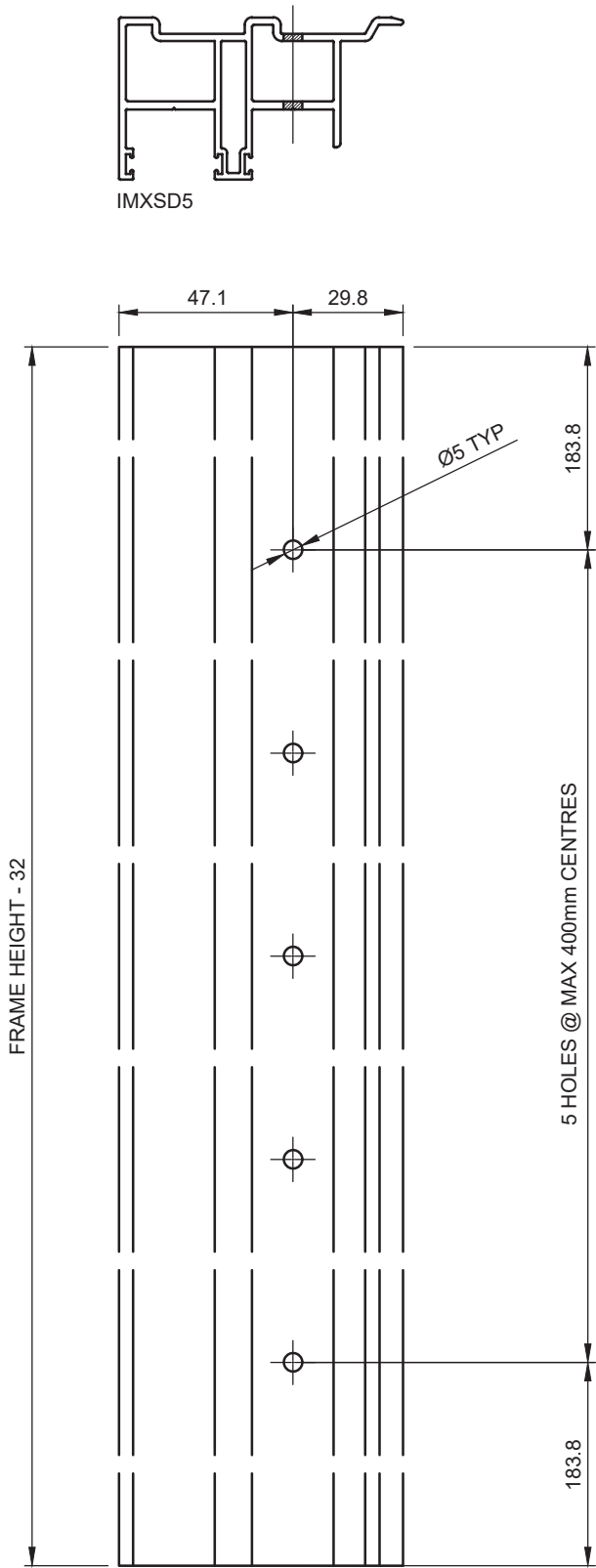
10. Manufacturing Details

IMXSD5 Jamb Adaptor for Outward Door Fixing Holes

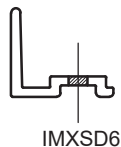


10. Manufacturing Details

IMXSD5 Jamb Adaptor for Inward Door Fixing Holes

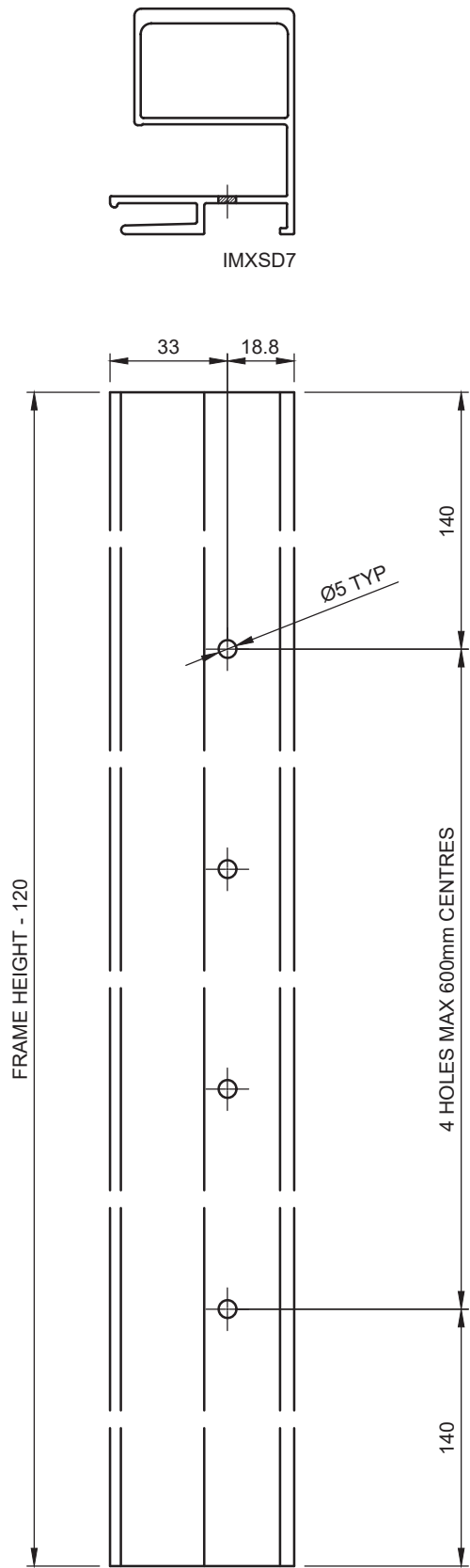


IMXSD6 HD Frame Mullion Fixing Holes



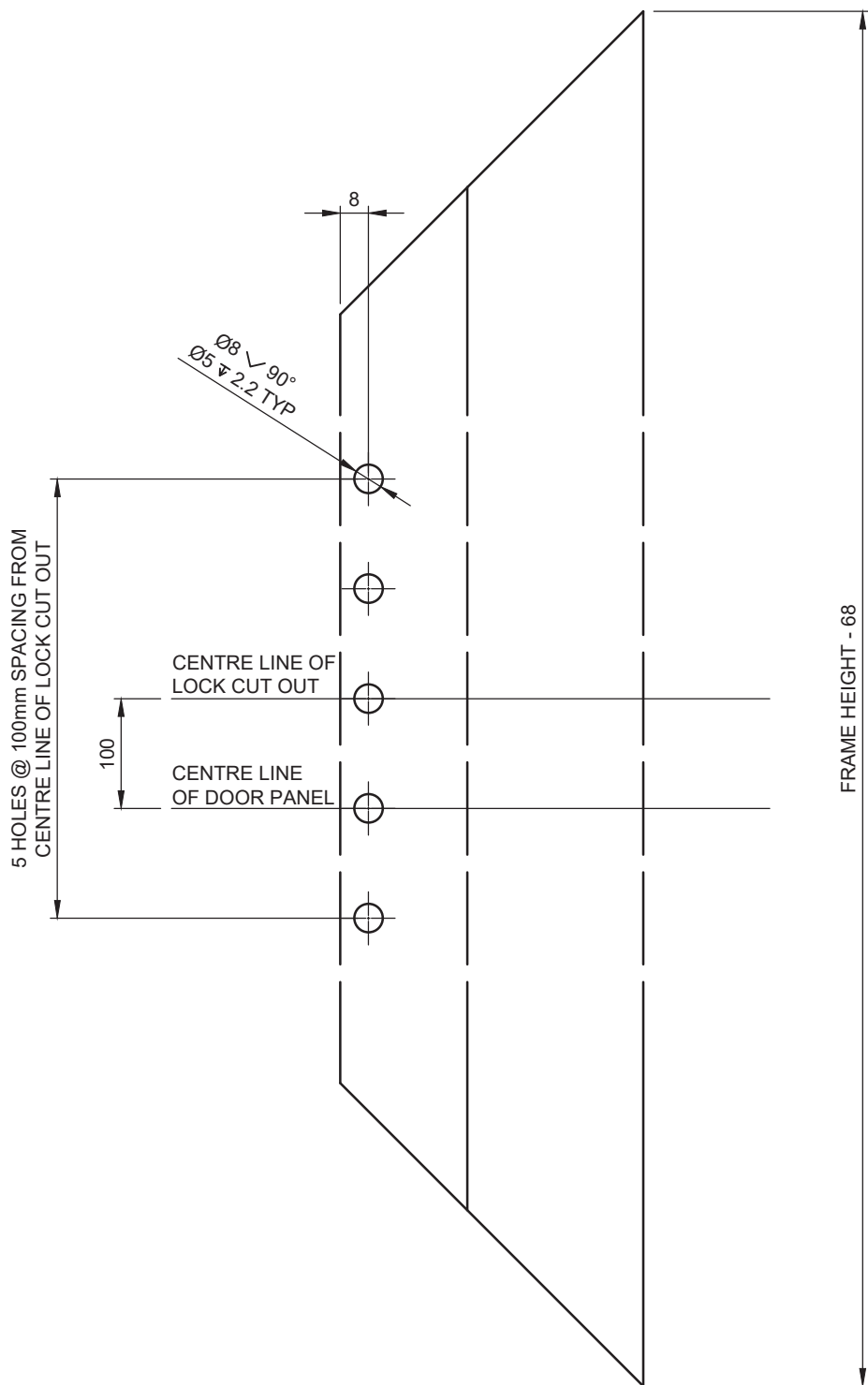
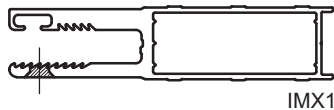
10. Manufacturing Details

IMXSD7 HD Interlock Mullion Fixing Holes



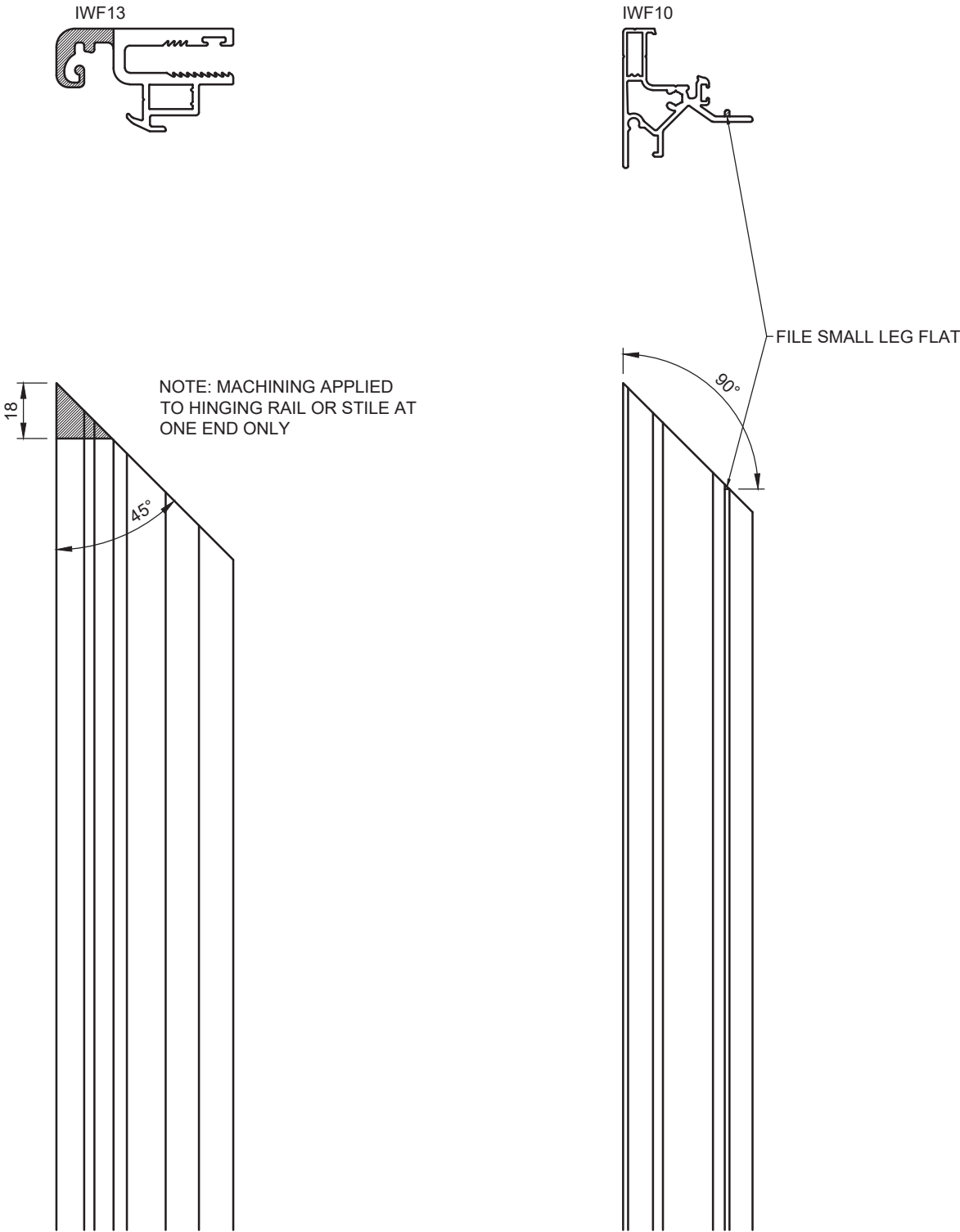
10. Manufacturing Details

IMX1 Sliding Door Mesh Fixing Location



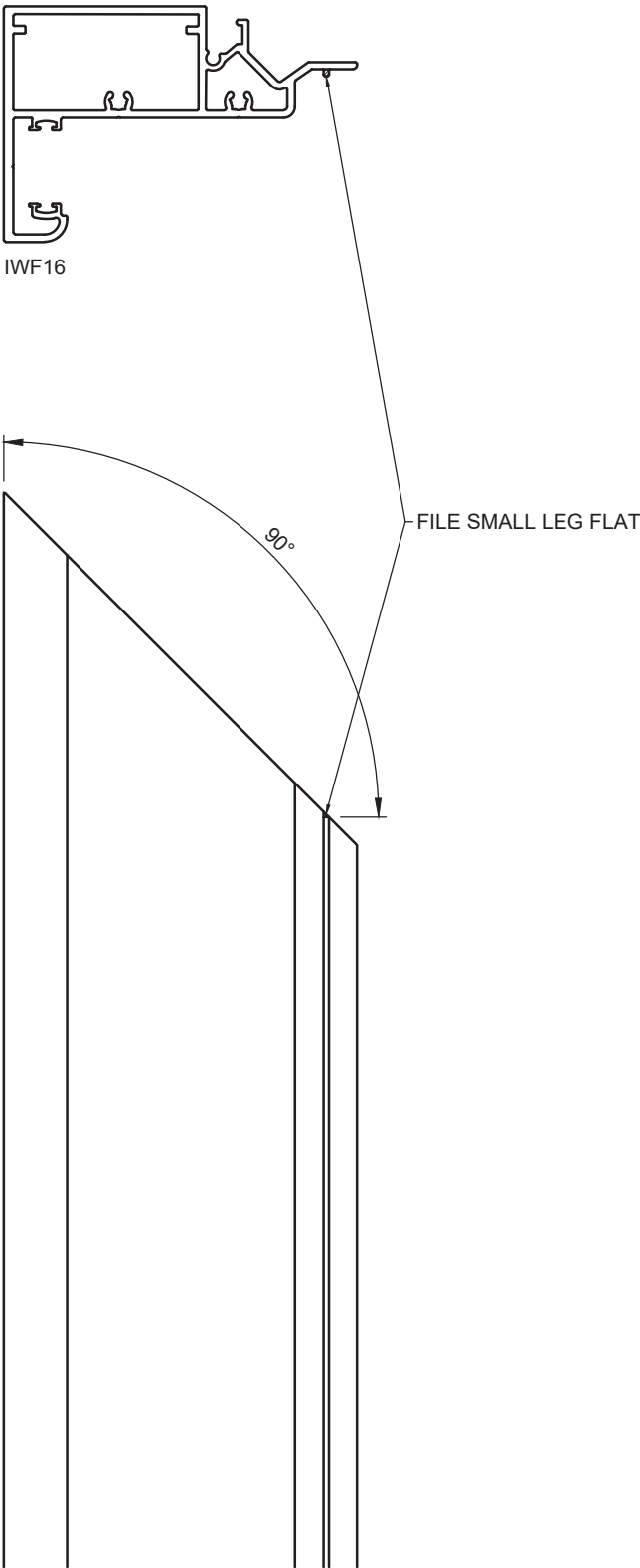
10. Manufacturing Details

Invisi-Maxx Escape Open Out Machining



10. Manufacturing Details

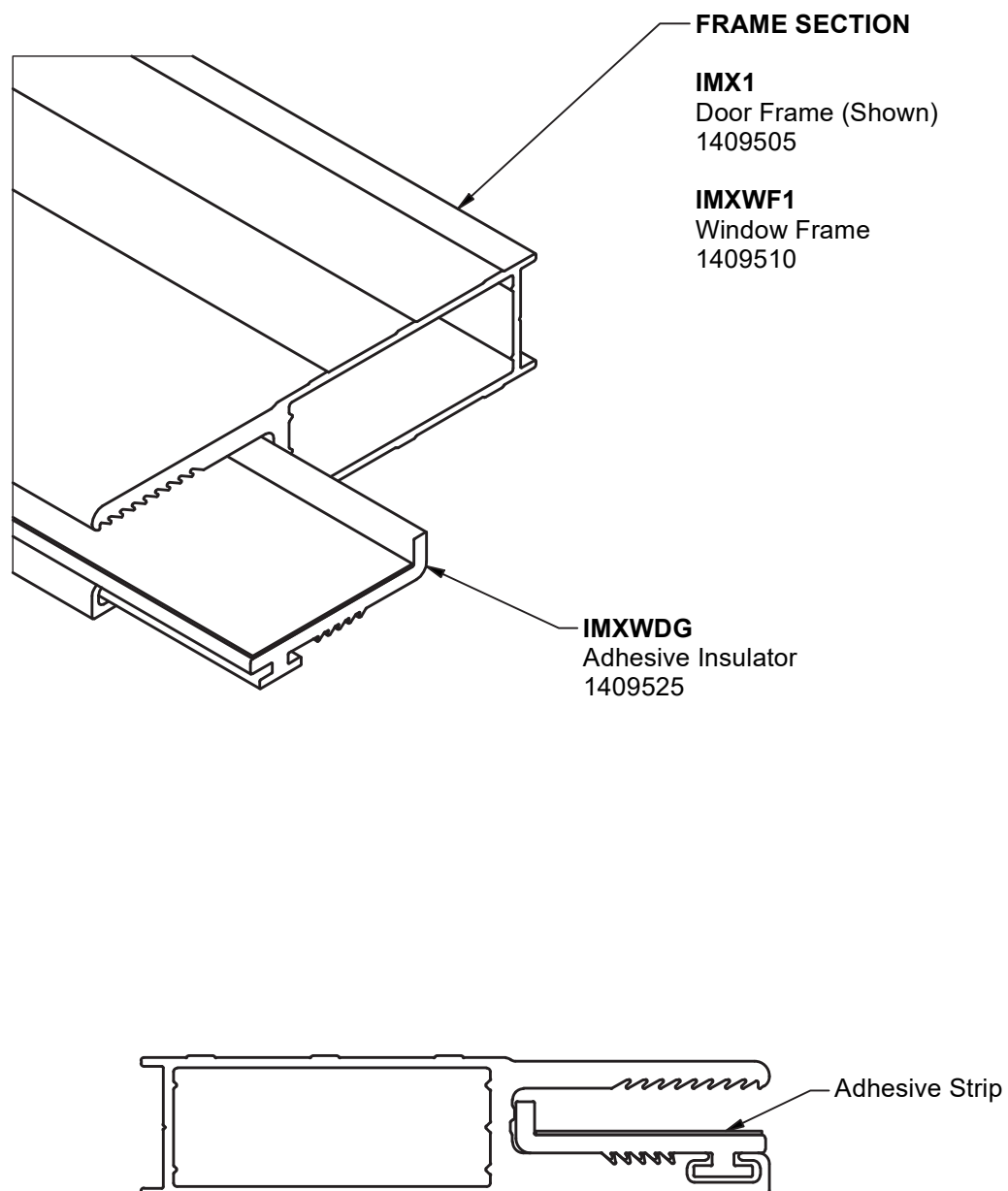
Invisi-Maxx Escape Buildout Open Out Machining



11. Assembly Details

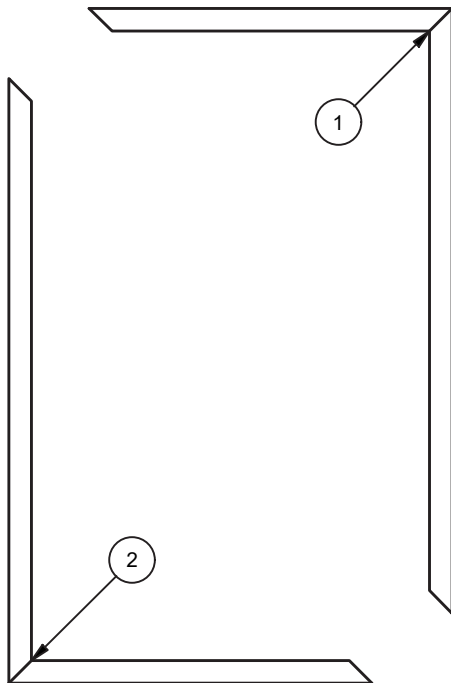
Step 1 - Insulator Assembly

Remove the plastic film from the adhesive strip, then slide the insulator into the section.



11. Assembly Details

Step 2 - Door Frame Assembly

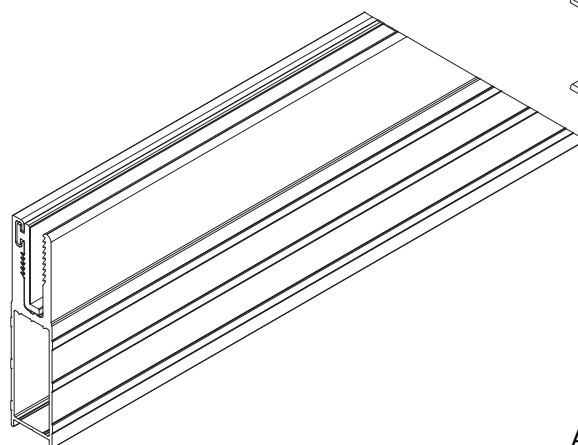


Assemble two corners of the frame using the designated corner stakes as per below.

Assemble the frame internal side up (insulator down).

P2
Door Corner Stake (shown)
1311211

P5
Window Corner Stake
1311226



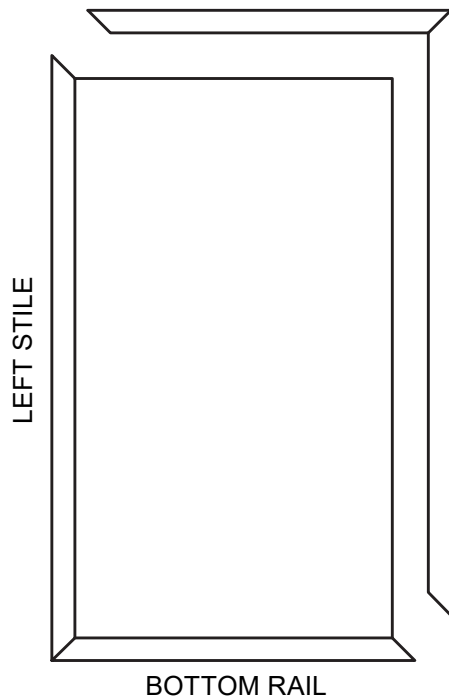
10g x 25mm S/Steel
Security Screws
1383110

or

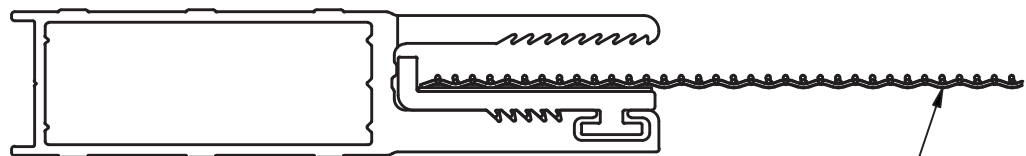
AS5-4 S/Steel Rivets
1380167

11. Assembly Details

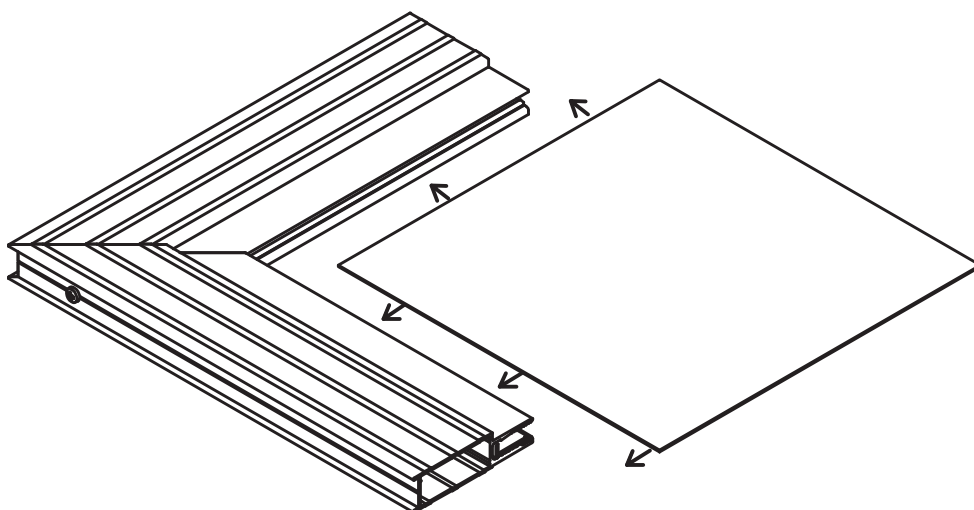
Step 3 - Mesh Assembly



Complete the assembly of the frame around the mesh.



Support the mesh using 10mm packers. This will help make locating the mesh into the retention pocket easier and reduce mesh sag.



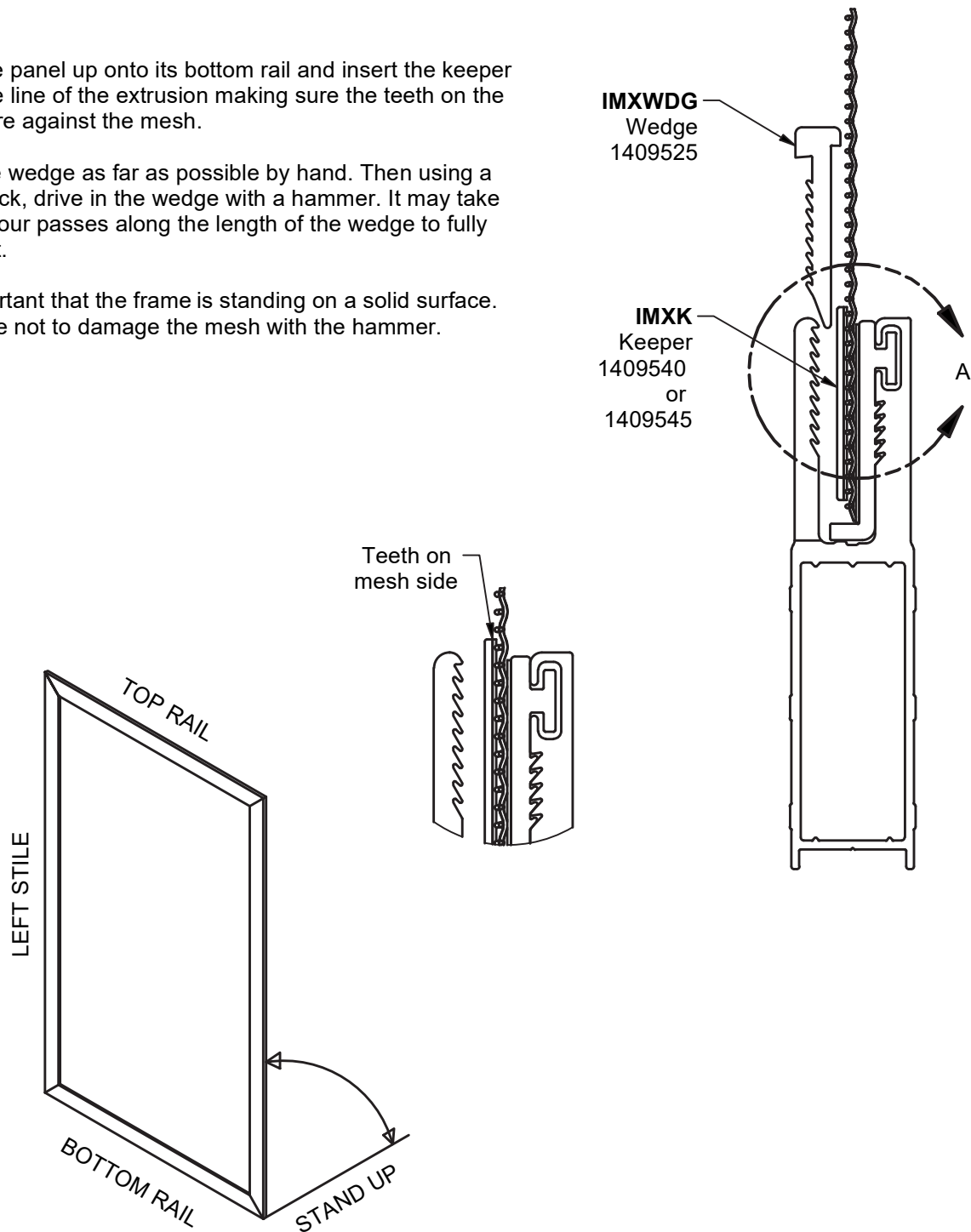
11. Assembly Details

Step 4 - Bottom Rail, Keeper and Wedge Assembly

Stand the panel up onto its bottom rail and insert the keeper below the line of the extrusion making sure the teeth on the keeper are against the mesh.

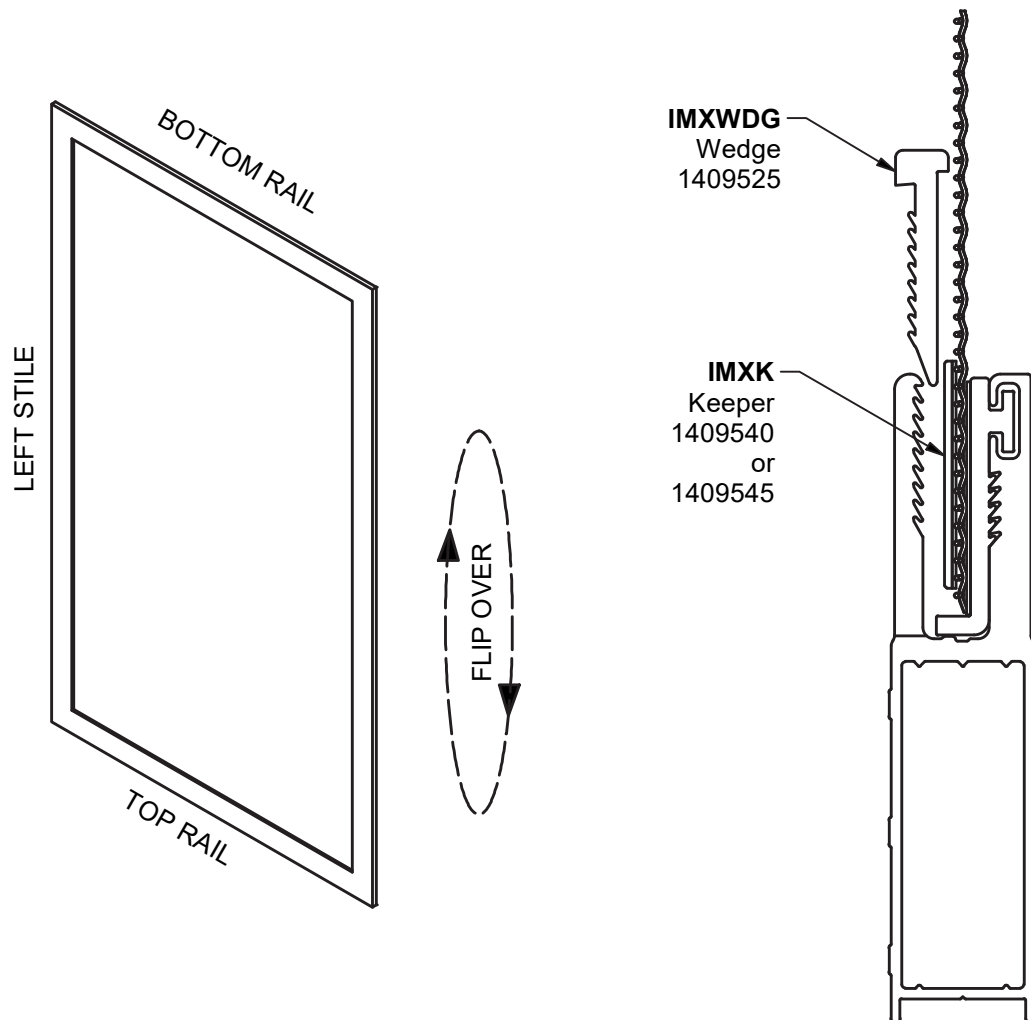
Insert the wedge as far as possible by hand. Then using a nylon block, drive in the wedge with a hammer. It may take three to four passes along the length of the wedge to fully engage it.

It is important that the frame is standing on a solid surface. Take care not to damage the mesh with the hammer.



11. Assembly Details

Step 5 - Top Rail, Stiles, Keeper and Wedge Assembly

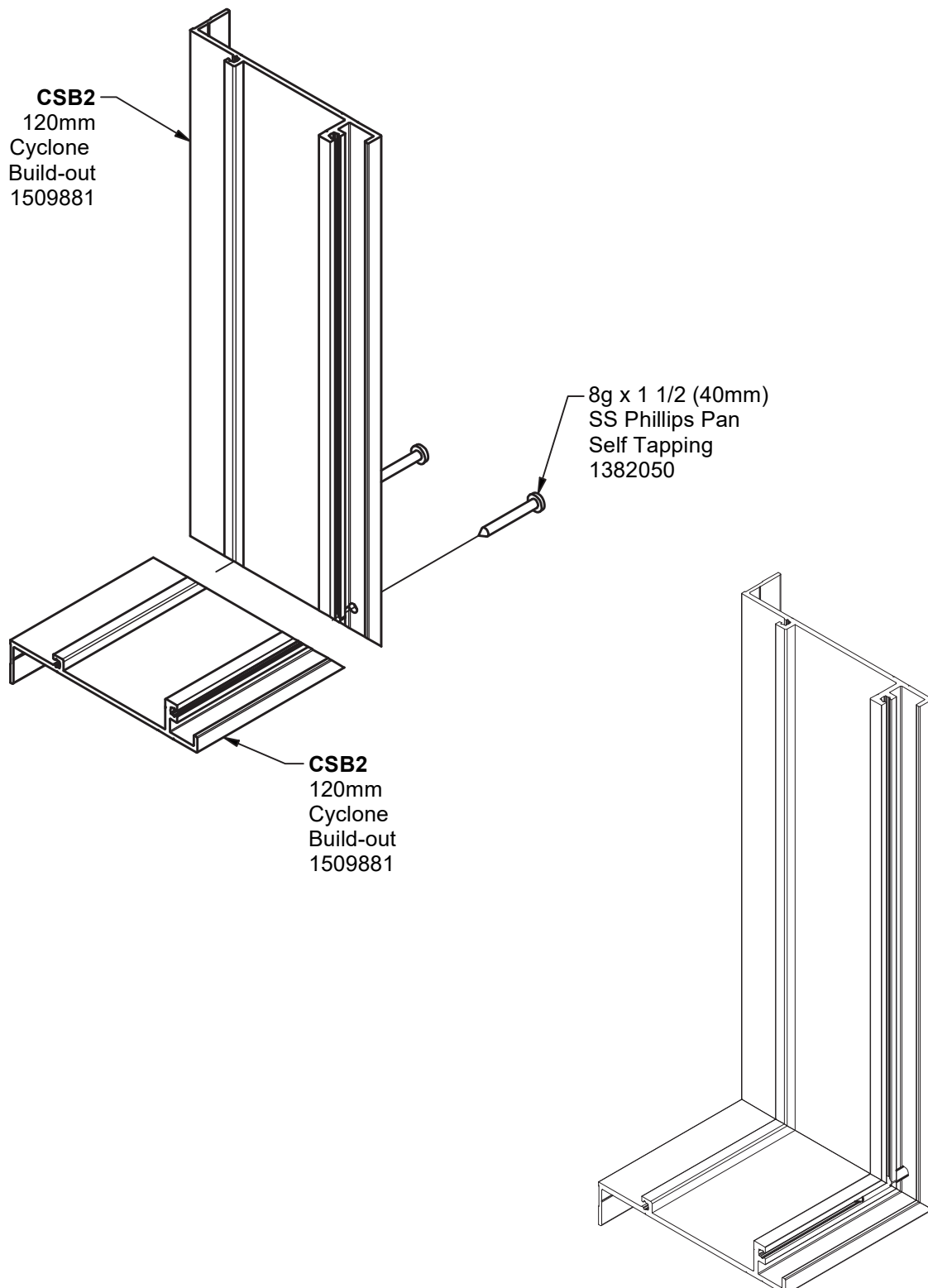


Flip the panel over onto its top rail and repeat step 4.

Best results are achieved when opposing ends are wedged first. Complete the panel by wedging the final two sides.

11. Assembly Details

CSB2 Assembly



13. Care & Maintenance

FRAMING

Your new **INVISI-MAXX High Performance Debris 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-Maxx** frame will retain it's good looks and resist the elements for years to come.

The **INVISI-MAXX High Performance Debris 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-MAXX High Performance Debris 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-MAXX High Performance Debris 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.

HEAD OFFICE | 3 Alspec Place, Eastern Creek NSW 2766
Phone: 02 9834 9500 | Fax: 02 9834 9532 | info@alspec.com.au

ALSPEC SHOWROOMS

AluSpace by Alspec - Sydney | 110 New South Head Road, Edgecliff NSW 2027
Phone: 1300 ALUSPACE (1300 258 772) | design@alspec.com.au

AluSpace by Alspec - Adelaide | 1 Pope Court, Beverley SA 5009
Phone: 08 8150 6960 | adelaidealospace@alspec.com.au

Brisbane Design Centre | 66 Merivale Street, South Brisbane QLD 4101
Phone: 07 3089 4900 | brisbane@alspec.com.au

MELBOURNE BRANCH
26–40 Pound Road West
Dandenong South VIC 3175
Phone: 03 8787 6333
Fax: 03 8787 6399
melbourne@alspec.com.au

ADELAIDE BRANCH
1 Pope Court
Beverley SA 5009
Phone: 08 8150 6960
Fax: 08 8150 6999
adelaide@alspec.com.au

PERTH BRANCH
30 Holder Way
Malaga WA 6090
Phone: 08 9209 9100
Fax: 08 9209 9199
perth@alspec.com.au

BRISBANE BRANCH
8–22 Jutland Street
Loganlea QLD 4131
Phone: 07 3089 4900
Fax: 07 3089 4999
brisbane@alspec.com.au

NEWCASTLE BRANCH
95 Griffiths Road
Lambton NSW 2299
Phone: 02 4952 9111
Fax: 02 4952 9728
newcastle@alspec.com.au

CAIRNS BRANCH
34–38 Hargreaves Street
Edmonton QLD 4869
Phone: 07 4037 6666
Fax: 07 4037 6699
cairns@alspec.com.au

CANBERRA BRANCH
28 Sheppard Street
Hume ACT 2620
Phone: 02 5134 3300
canberra@alspec.com.au

DARWIN BRANCH
25 Bishop Street
Woolner NT 0820
Phone: 08 8941 7300
darwin@alspec.com.au

SUNSHINE COAST BRANCH
4-8 Empire Crescent
Chevallum QLD 4555
Phone: 07 5437 6123
Fax: 07 5437 6124
chevallum@alspec.com.au

BRENDALE BRANCH
24 Doherty Street
Brendale QLD 4500
Phone: 07 3205 9911
Fax: 07 3205 9915
brendale@alspec.com.au

TOWNSVILLE BRANCH
21 Carroll Street
Mount Louisa QLD 4814
Phone: 07 3089 4965
Fax: 1300 131 747
townsville@alspec.com.au

BUNDABERG BRANCH
17 Production Street
Svensson Heights QLD 4670
Phone: 07 4111 2000
Fax: 07 4111 2099
bundaberg@alspec.com.au

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