

# **METALFORM**

**MASTERS OF METAL**

**ST 85 Inward and outward opening doors and  
windows tilt and turn brass OT67**

# METALFORM

## ST 85 Inward and Outward Opening Doors and Windows | Tilt and Turn | in Brass OT67

### Description:

Supply and installation of doors, windows, and facades featuring fixed and openable sashes, designed for inward and outward opening configurations. Built with thermal break profiles, specifically Secco Sistemi ST 85.

### Construction:

- Frame sections composed of two seamlessly joined metal shells, one external and one internal, filled with extruded polyamide infused with fiberglass and bonded with high-density polyurethane resin.
- Outer metal shell and Gothic glazing beads made from extruded copper alloy OT67. Inner shell crafted from cold-rolled profiled strips of Copper alloy OT67 (Cu67/Zn33) with a thickness of 15/10, meeting standard EN1652:1999.
- Folding unit designed to facilitate insertion of stainless steel alignment brackets, even with continuous surface welding.
- Assembly of frames involves welding the internal surfaces with the insertion of internal stainless steel reinforcement brackets and eventual brazing of visible parts.

### Design Details (Windows):

- Windows feature internal overlap and external coplanarity profiles.
- Visible sections include fixed side node of 47 mm, openable side node of 85 mm, central node for the two panels, asymmetrically measuring 107mm or symmetrically measuring 145mm, with a mandatory depth of 85 mm.
- Water, air, and wind sealing system for inward opening windows includes triple mortise gasket with two sealing levels, one of which is open-joint. Outward opening windows and doors feature double mortise gasket providing a closed joint seal.
- Mobile sill for floors included with doors.
- Corten steel screw-on water drains provided in the windows.

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## Glazing:

- Frames equipped with glass (type to be specified) fixed by means of Style glazing beads in Brass OT67, spaced from external surfaces by EPDM or silicone gaskets, and from internal surfaces by pressure-inserted EPDM gaskets.

## Hardware (Windows):

- Windows equipped with concealed, hot burnished stainless steel hinges, adjustable with three wings (Ø15 mm, 180kg capacity per panel).
- Alternatively, windows feature tilt and turn openings with perimeter hardware, available with either concealed hinges (130 kg load capacity) or visible hinges (Ø14 mm, 150 kg load capacity), equipped with an appropriate number of locking points depending on the sash size.

## Hardware (Doors):

- Doors equipped with locks featuring an appropriate number of locking points proportioned with the height of the sashes.
- Adjustable screw-on stainless steel hinges provided for load capacities up to 250 kg (Ø21.5 mm), and for load capacities up to 160 kg (Ø22.5 mm) in hot burnished stainless steel.

## Surface Finish:

- Surfaces oxidized and burnished with a mechanical cleaning process involving abrasive treatment, immersion in burnishing liquid, washing, and protection with Vaseline oil or wax.

## Handles:

- Handles available in various shapes, materials, and finishes, including Brass OT67.

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