

METALFORM

MASTERS OF METAL

**BV 75 Inward and Outward Opening Doors and
Windows | Tilt and Turn | Corten Steel**

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Supply and installation of doors, windows, and facades, in fixed and openable sashes, for inward and outward opening doors and windows, built with thermal break profiles Secco Sistemi BV 75.

Frame Construction:

- The frame sections are made by seamlessly joining two metal shells (one whole and one external) with extruded polyamide filled with fibreglass and joined to the parts by high density polyurethane resin. The metal shells are obtained by cold-rolling profiling strips of Cor-Ten steel (Fe510X) with a thickness of 15/10, following the eN1049 standard.

Assembly:

- The folding unit must be kept open so that the stainless steel alignment brackets can be inserted, even in the case of continuous surface welding. The assembly of the frames is carried out by continuous welding of the contact surfaces followed by grinding and restoration of the surface finish.

Visible Sections:

- The system provides for the internal and external overlapping of the profiles with the following minimally visible sections:

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- Fixed side node: 27 mm
- Side sash node: 47 mm
- Central node for the two wings: 62 mm
- Mandatory depth: 77 mm.

Frame Options:

- All nodes are identical, starting from 62 mm, making the fixed parts indistinguishable from the openable parts, enabling the windows to be coplanar to each other.
- Distinct nodes for fixed and openable parts, minimizing their dimensions as much as possible, with the option of inserting (or not inserting) coplanar glass between them.

Design Features:

- The external part of the sash profile is beveled at an angle like the glazing bead, giving depth to the external elevation of the window/door and placing the glass in axis with the sash section.

Sealing System:

- Water, air, and wind sealing system for inward opening windows with triple mortise gasket (two sealing levels, one of which is open-joint), for outward opening windows and for doors with double mortise gasket (one level of closed joint gasket). Mobile sill for floors for doors.

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Water Drainage:

- A sufficient number of Corten steel screw-on water drains are provided in the windows.

Glass Fixing:

- Frames are complete with glass, fixed with glazing beads (select one of the following options) | Beveled | Squared | Square Rounded | Triangular | Thin | in corten steel, spaced from the external surfaces by means of EPDM or silicone gaskets, and from the internal surfaces by means of pressure-inserted EPDM gaskets.

Hardware:

- Windows, when there is no tilting sash, and doors, are equipped with hinges to be screwed on, Corten adjustable and available with two wings (Ø12 mm for capacities up to 50 kg per sash) or with three wings (Ø15 mm for capacities up to 100 kg per sash).

Optional Features:

- Tilt&Turn/sash window opening with concealed hinges (130 kg load-bearing capacity) and outer hardware with an appropriate number of locking points depending on the sash size. Internal bolt locking system with a lower and upper end, and a sufficient number of additional locking points depending on the size of the opening doors.

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Surface Finish:

- Oxidized Surfaces finished with acid etching, oxidation, passivation, and waxing processes.

Handles:

- The handles complete the set and are available in different shapes, materials, and finishes, including corten steel.

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