



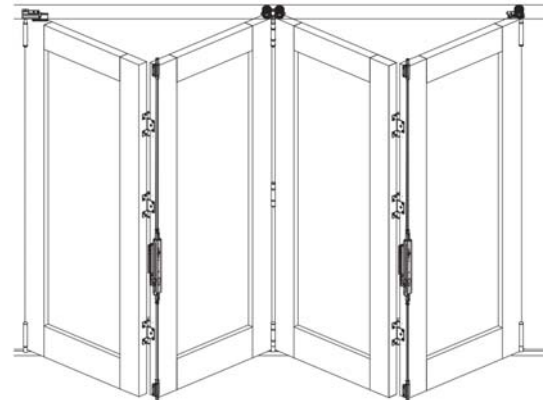
**PRESS METAL**

Press Metal Aluminium (Australia) Pty Limited  
www.pmaa.net.au

# 7000 SERIES



# BI-FOLDING



# WINDOWS AND DOORS

## "Single & Double Glazing"

SUPPORTED BY:



**ISSUE: AUGUST 2022**



**PRESS METAL**

Press Metal Aluminium (Australia) Pty Limited  
www.pmaa.net.au

## GROUP INTRODUCTION

Press Metal Berhad (PMB) is a Multinational Corporation with headquarters in Kuala Lumpur, Malaysia, as well as operations in the United Kingdom, Australia, Hong Kong and Dubai. The Company was incorporated in 1986 and subsequently listed on the Kuala Lumpur Stock Exchange in 1993. PMB Technology Berhad, its subsidiary company, also became a public company in 2003.

PMB specializes in Aluminium Extrusion manufacturing and is one of the Largest produces in Southeast Asia. PMB Facade Sdn Bhd (Malaysia) and PMB-Cyberwall Ltd (Hong Kong), both under PMB Technology Berhad are Leading Curtain Wall Contractors in this region with an Excellent Track Record. The projects involved include many famed buildings such as Chep Lak Kok Airport (Hong Kong), Plaza 66 (Shanghai, China), Golden Hall (Macao) and a1 Bidda (Doha, Qatar) and so on.

Through continuous growth in the past Twenty Years, PMB has emerged to be an internationally well recognized establishment. To fulfill its aggressive expansion plan, it has relocated its major production facility to China by setting up Press metal International Ltd in Foshan, China in 2005. The factory sits on a 760,000m<sup>2</sup> area of land which will house a complete aluminium extrusion facility with eventual production capacity of 200,00 tonnes per annum.

Press Metal Aluminium (Australia) Pty Ltd, is part of the Press metal Berhad (PMB) Group and is the Australian Distributer for all Aluminium Extrusions Manufactured by the group.

The Window and Sliding Door products shown in this catalogue are all Australian Designed and Australian Tested, to compliance with the Relevant Australian Standards.

### **PRESS METAL ALUMINIUM (AUSTRALIA) PTY LTD - SALES OFFICE CONTACTS**

#### **SYDNEY:**

1012-1016 Canley Vale Road,  
Wetherill Park, NSW, 2164,  
Australia

Tel: (02) 9756 5555

Fax: (02) 9756 5499

E-Mail: sales@pmaa.net.au

[www.pmaa.net.au](http://www.pmaa.net.au)

#### **BRISBANE:**

43 Motorway Circuit,  
Ormeau, QLD, 4208, Australia

Tel: (07) 5540 6100

Fax: (07) 5540 6144

E-Mail: sales @pmaa.net.au

#### **MELBOURNE:**

32 Southeast Boulevard,  
Pakenham, VIC, 3810

Tel: 03 9776 9976

email: sales@pmaa.net.au

## ALLOY 6063

### Description of Alloy

Alloy 6063 provides a good combination of extrudability and mechanical properties. Its excellent extrudability allows thin-walled hollow shapes, intricate solid and other shapes that are usually difficult to extrude with satisfactory finish, to be produced more easily. It responds well to polishing, chemical brightening, anodizing and dyeing.

### Characteristics

**Welding:** Alloy 6063 is readily welded by the MIG and TIG processes. The recommended filler alloy, particularly when welding exposed surfaces that will be anodized for decorative purpose, is 5356. Alloy 4043 may be used in other cases.

**Rivets:** Alloy 6053-T61

**Machining:** Readily machined in all temper given.

**Forming:** All tempers may be formed, the softer tempers accepting more severe forming.

**Corrosion:** Excellent resistance to the atmosphere, particularly for architectural applications.

### Tempers Available

Extrude Shapes T1, T4, T5 and T6

**Other Alloys & Tempers Are Available  
 Please Check with Sales Office**

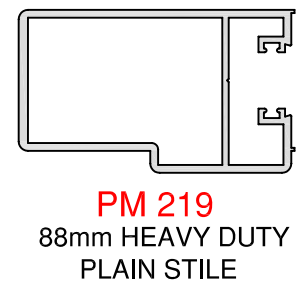
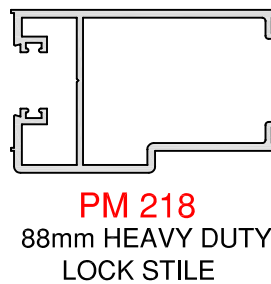
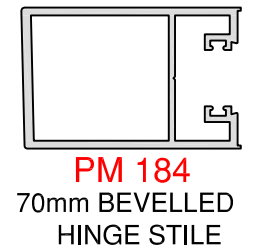
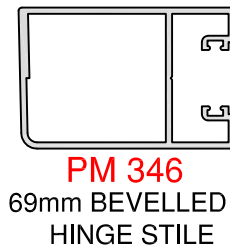
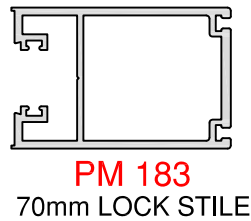
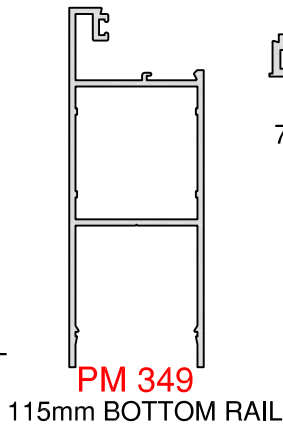
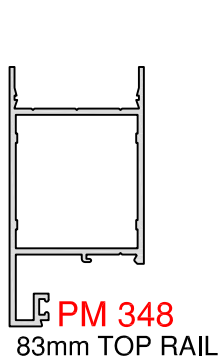
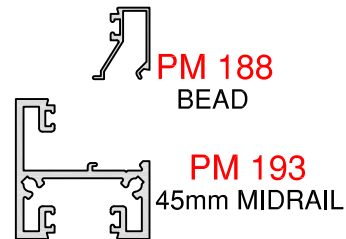
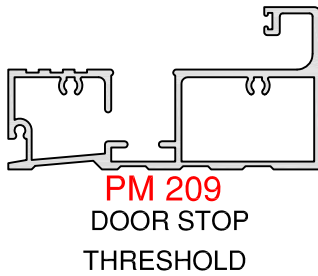
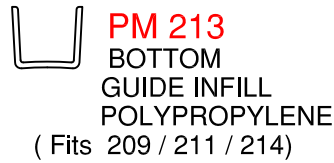
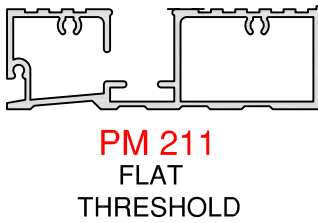
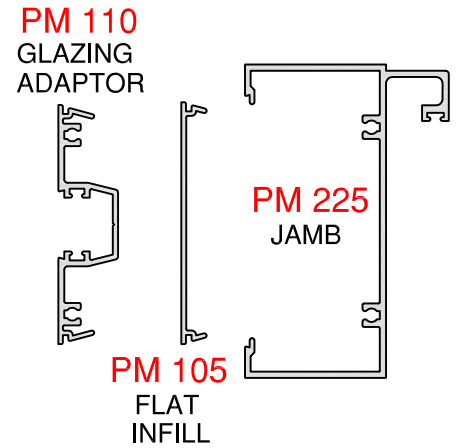
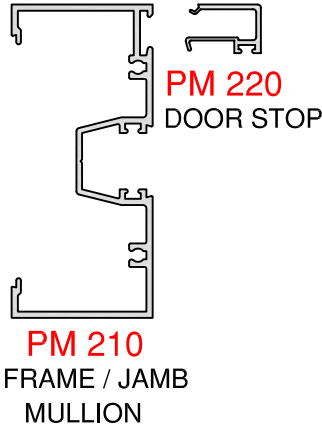
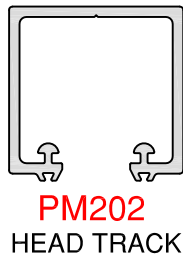
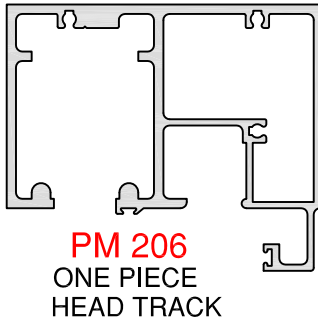
### Chemical Composition

Alloy 6063 is a heat-treatable aluminium-magnesium-silicone alloy.

%	si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Others	
									Each	Total
Min	0.20									
Max	0.60	0.35	0.10	0.10	0.90	0.10	0.10	0.10	0.05	0.15

### Mechanical Properties

Temper	Size (or) Thickness (3mm)		Tensile Strength (Mpa) min		Elongation %
	Over mm	Up To	UTS (Min)	Yield (Min)	
T1		12	115	60	12
	12	25	110	55	10
T4		12	130	70	12
	12	25	120	70	10
T5		12	150	110	8
	12	25	145	105	6
T6		12	205	170	8
	12	25	150	130	6

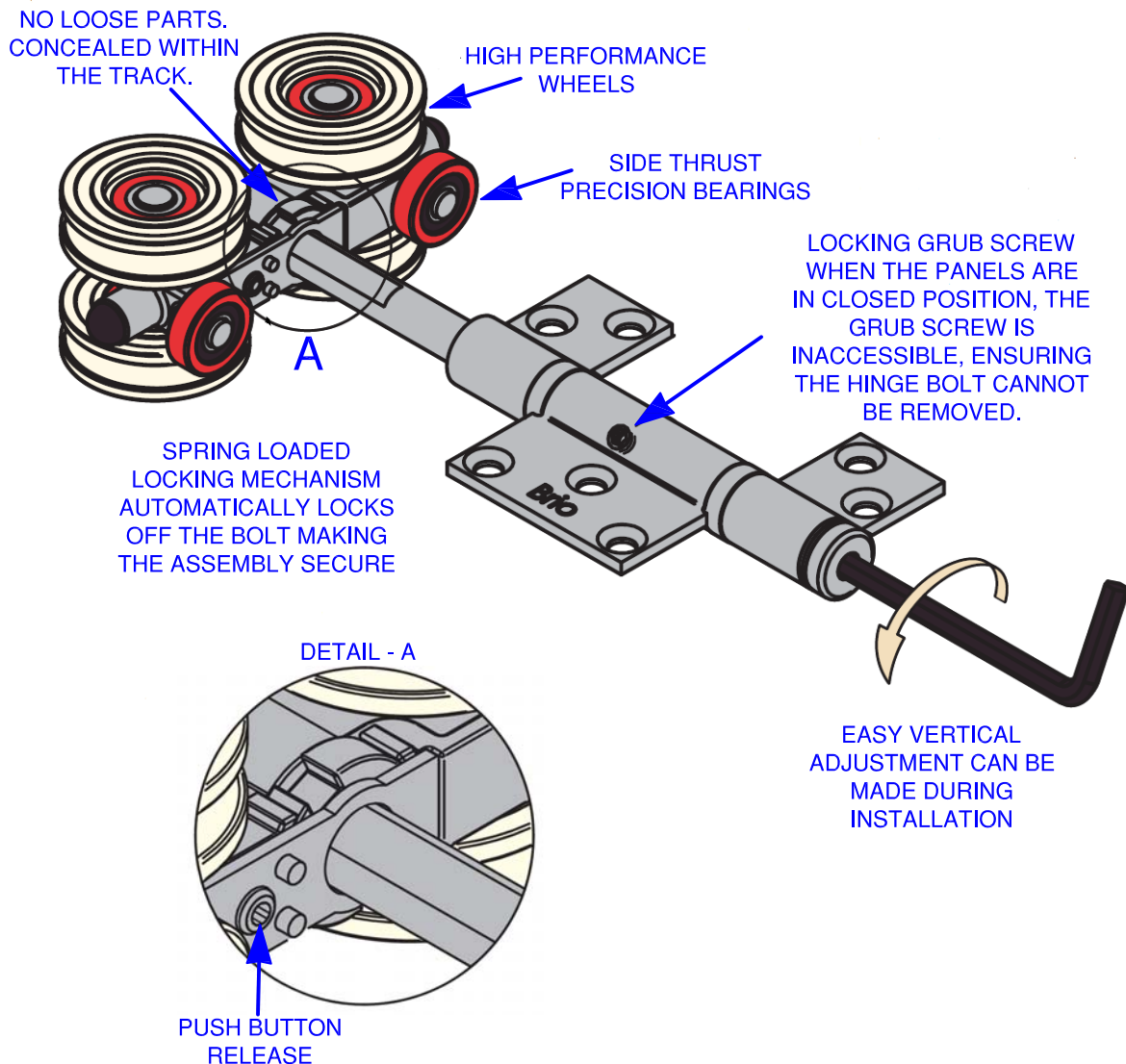


Press Metal Aluminium Australia have developed the 7000 Series Aluminium Bi-Folding Door to meet the needs of Modern Architectural Design in Commercial and Domestic Buildings. The Aluminium Extrusions have been designed to suit the fitting of BRIO Folding Door Hardware and feature the Latest BRIO innovation, making our 7000 Series Bi-Folding Door and Window Systems the best choice for your project.

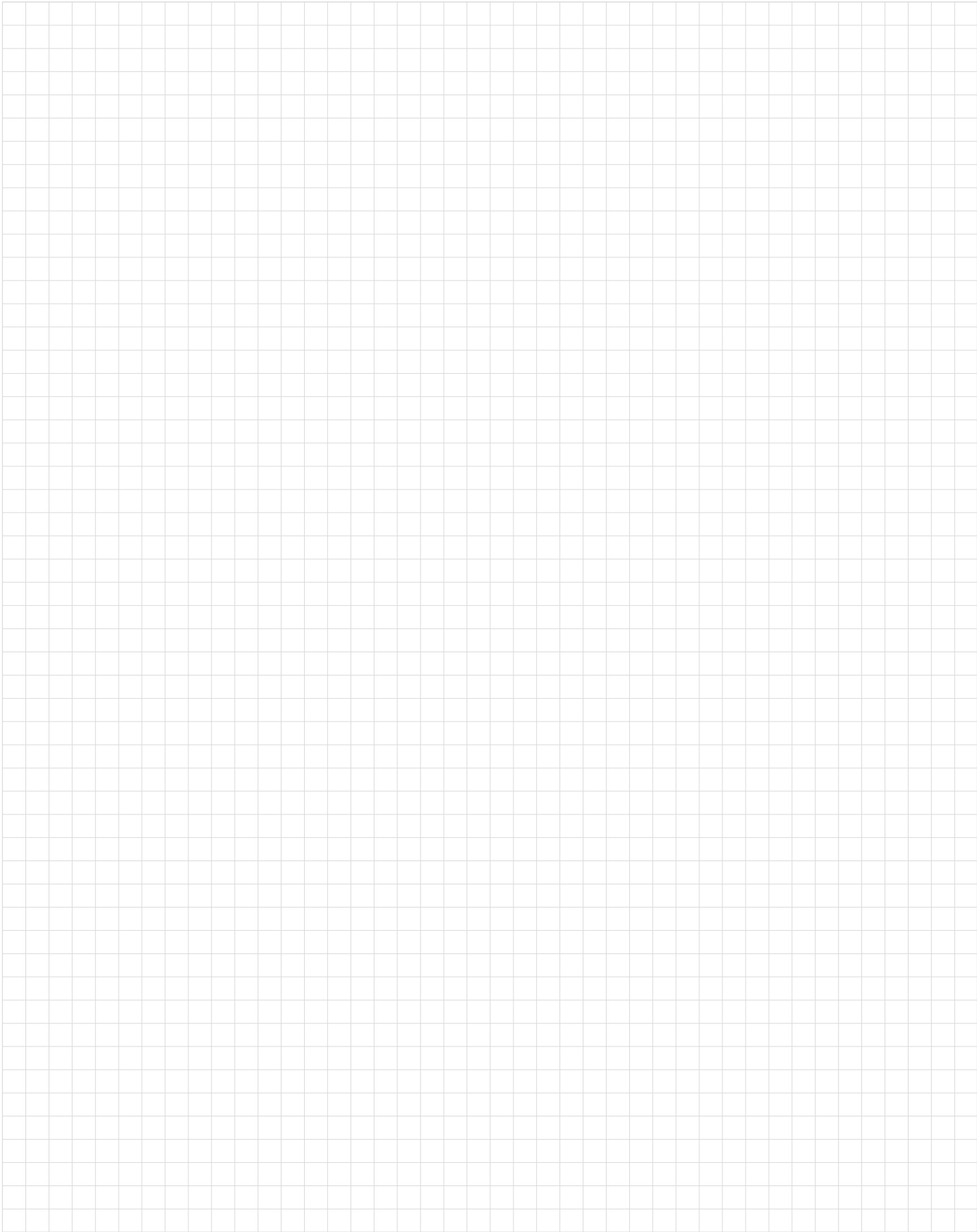
Ideal projects would be: Private Homes, Shopping Centers, Cafe and Restaurants, Domestic and Commercial Buildings, High End developments and Apartments.

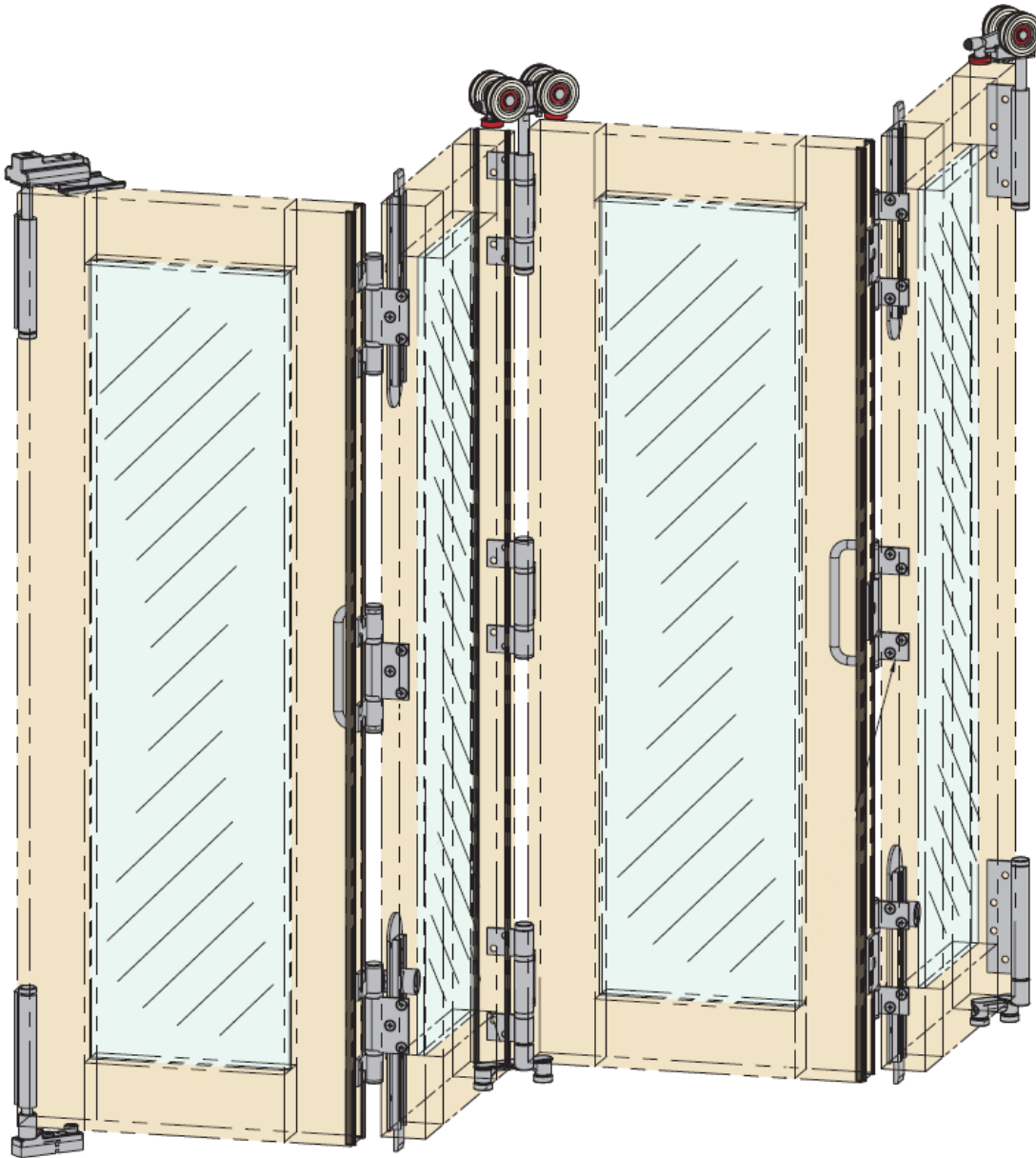
SOME NEW FEATURES OF **"BRIO"** HARDWARE

- **NEW LOCKING MECHANISM WITH NO LOOSE PARTS**  
 The new push button locking mechanism (Patent Pending) is a stand out element and is consistent across all hangers and pivots. It has no loose parts that can get misplaced during installation.
- **EASY ADJUSTMENT**  
 For faster installation, the locking mechanism provides easy vertical adjustment. just simply depress the push button and lower or raise the panel using the hex key provided.
- **NEW LOCKING MECHANISM**  
 As shown on the BRIO Weatherfold 4s 100 Intermediate Hanger
- **CONCEALED DESIGN**  
 The locking mechanism is concealed within the track to offer greater visual appeal.
- **FAILSAFE DESIGN**  
 Featuring automatic locking technology, the system self locks as soon as the push button is released, ensuring that the panel always remains set.
- **SECURITY**  
 The intermediate hanger hinge, bottom guides and pivot now feature non-removal pin technology for enhanced security. No exterior hardware can be tampered with or removed.



NOTES:





# SECTION: A

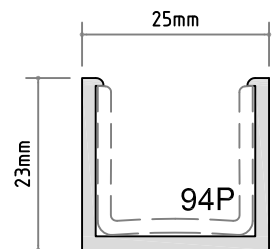
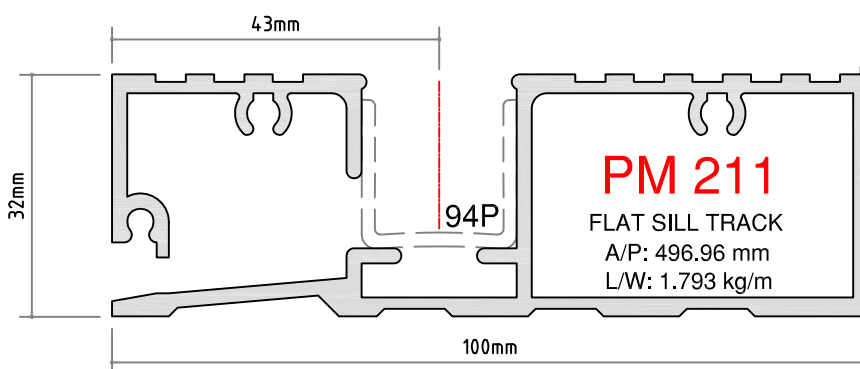
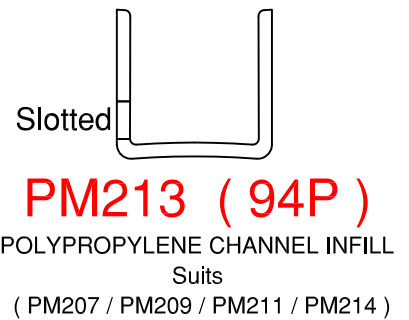
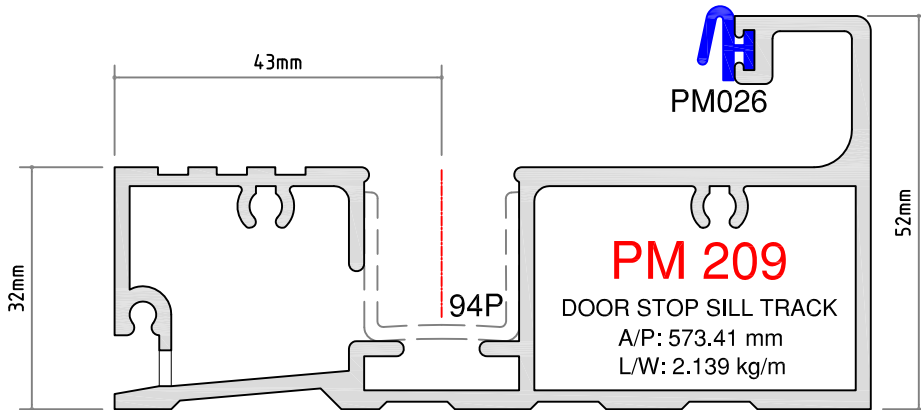
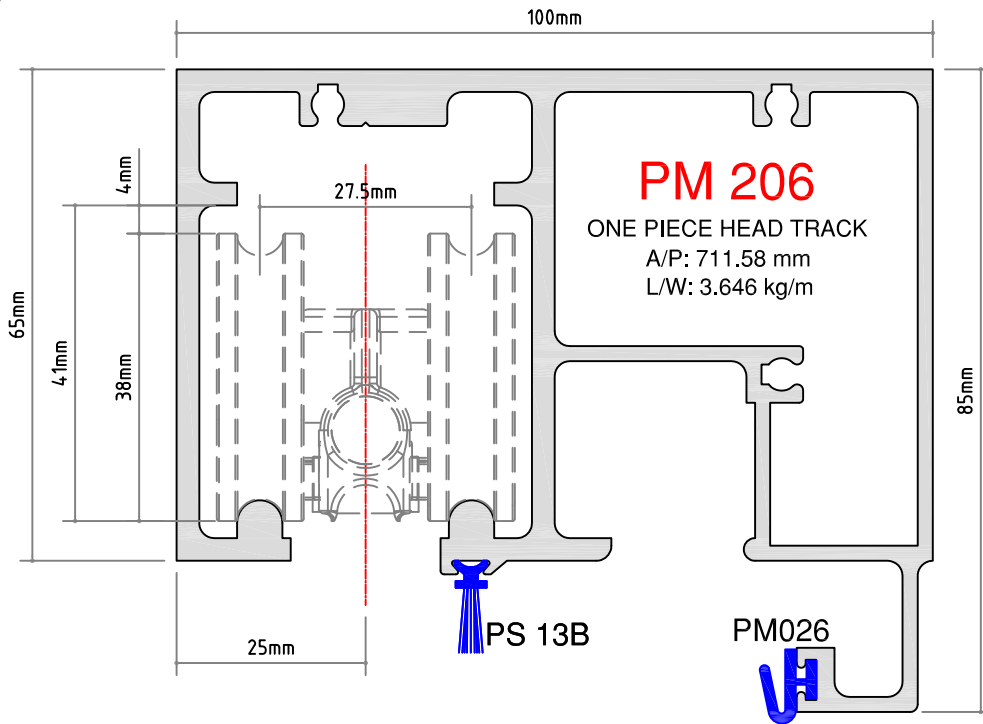
*Selection of Extrusions & Hardware*

Pages: A01 to A16

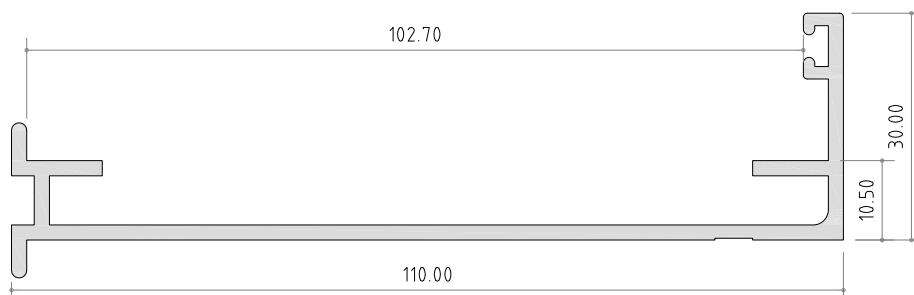
**7000 SERIES BI-FOLDING DOORS**

**A01**

SCALE 1:1

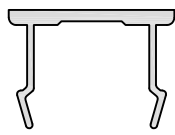
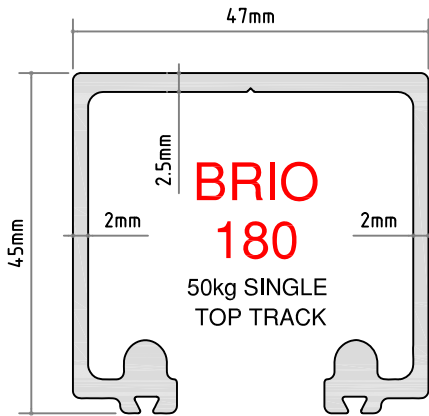
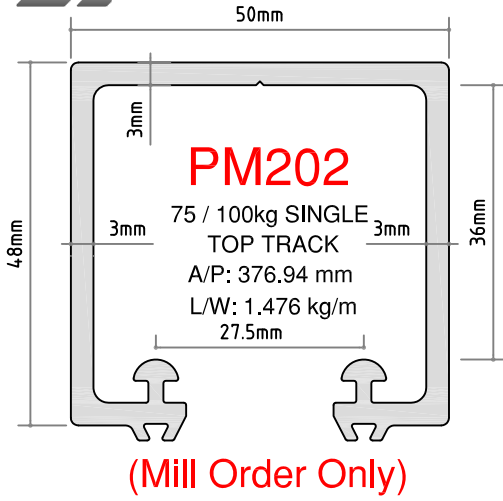


**PM214**  
CHANNEL  
A/P: 140.15 mm  
L/W: 0.331 kg/m



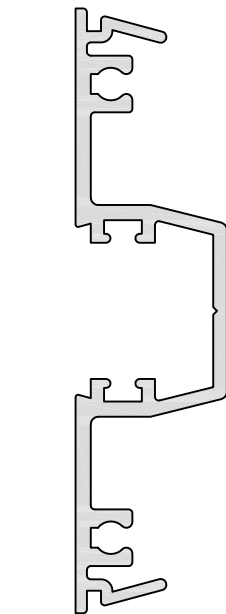
**PM 224**  
100mm BI-FOLD SUB SILL  
A/P: 370.99 mm  
L/W: 0.994 kg/m



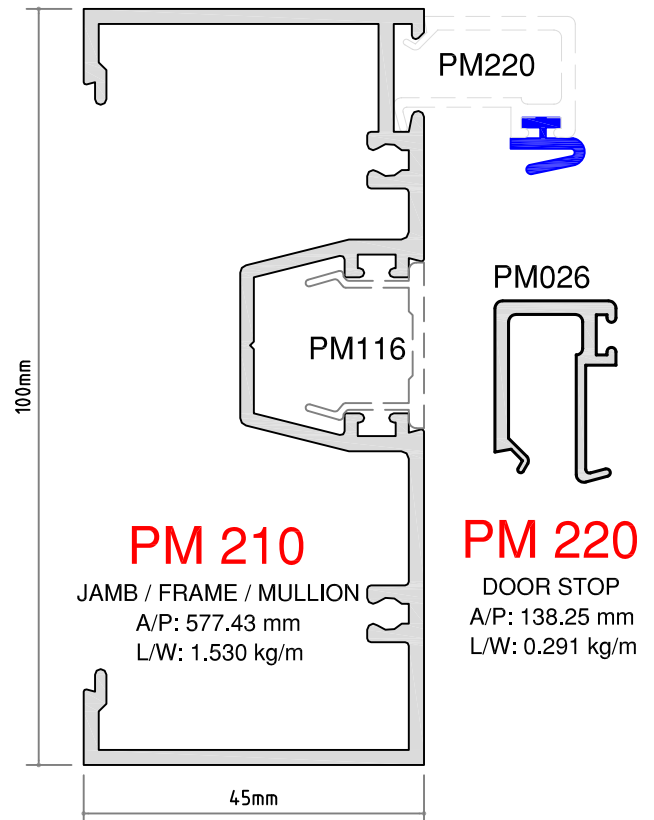
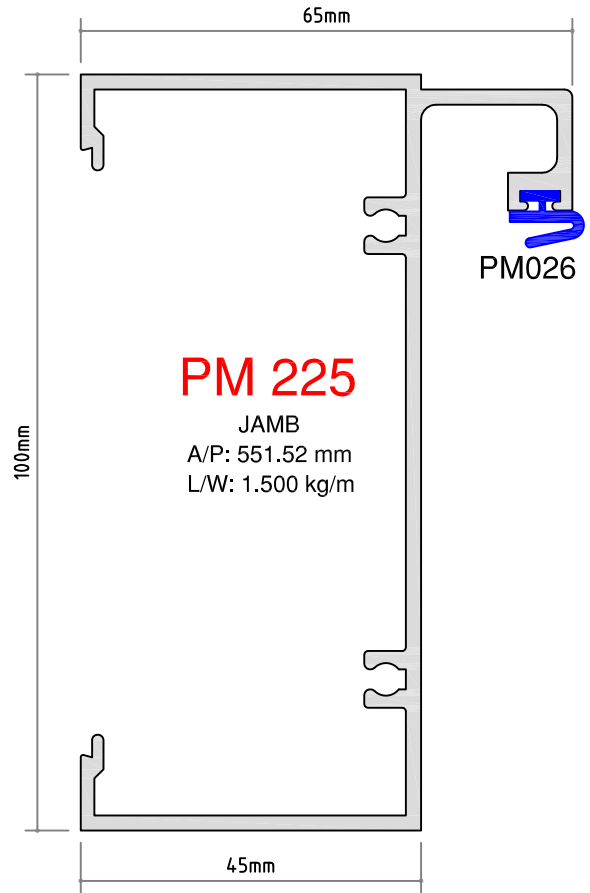


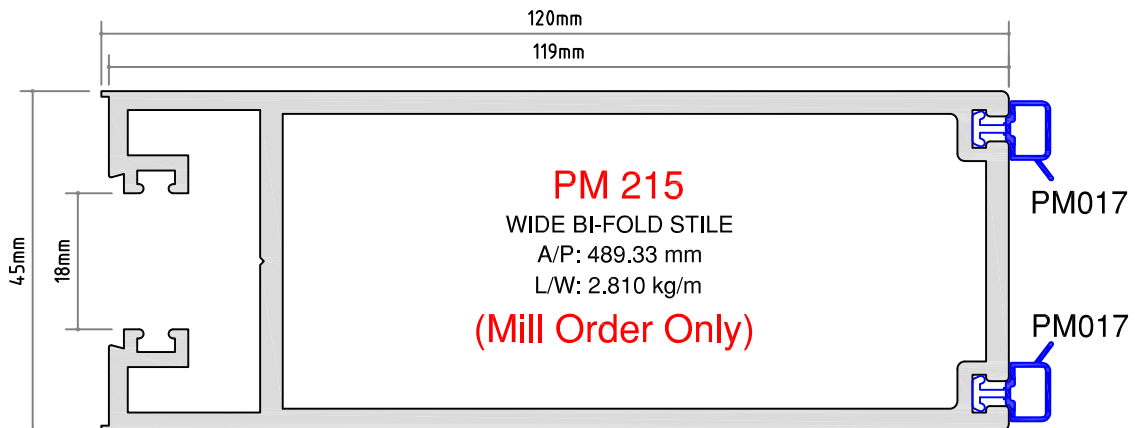
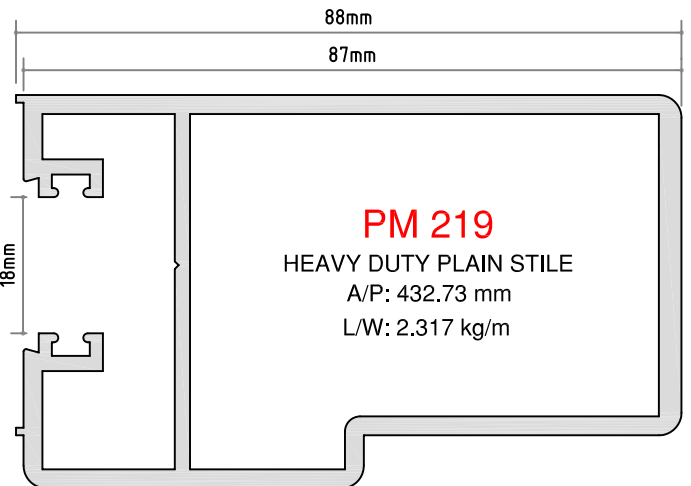
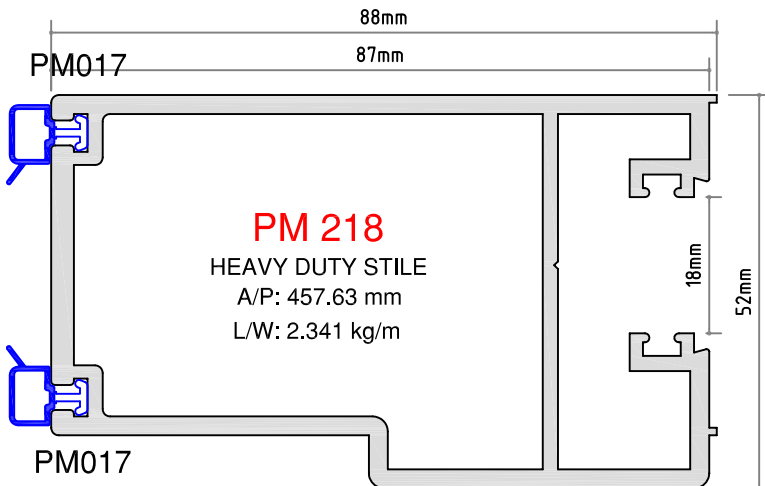
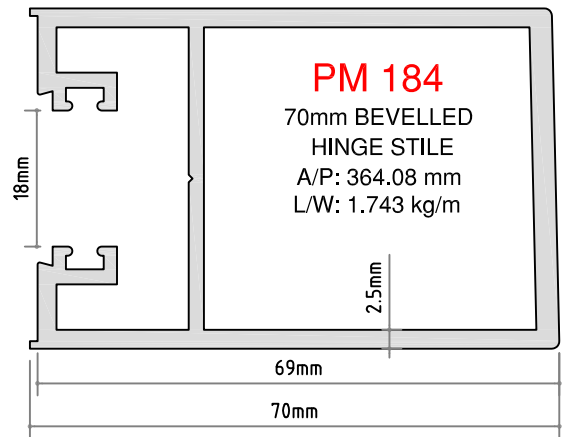
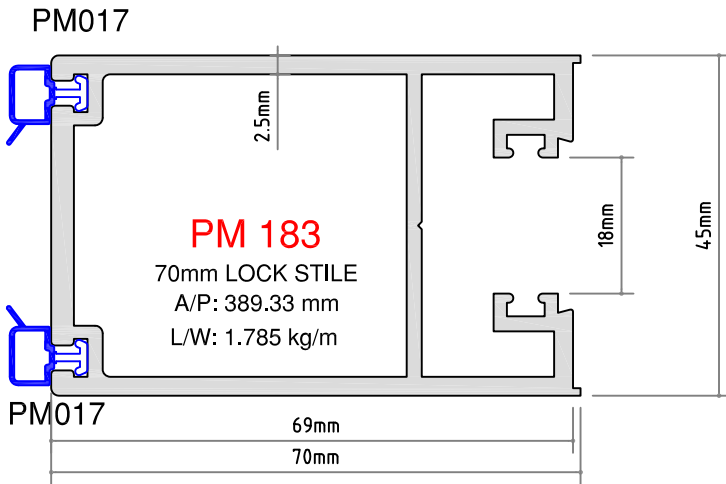
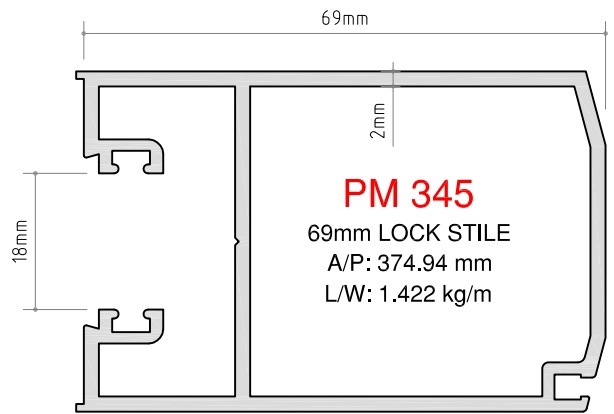
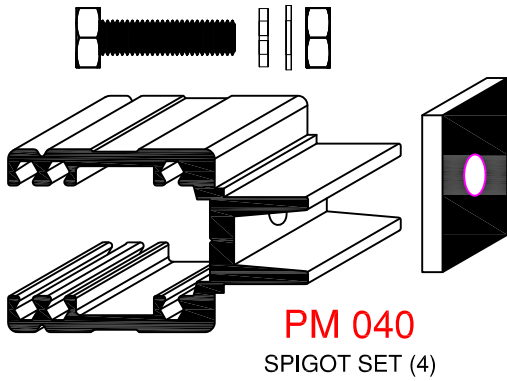
PMA6299  
**PM 116**  
POCKET FILLER  
A/P: 104.23 mm  
L/W: 0.177 kg/m

PMA6169  
**PM 105**  
100mm FLAT INFILL  
A/P: 202.91 mm  
L/W: 0.430 kg/m

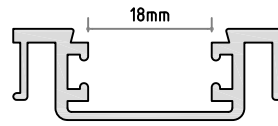
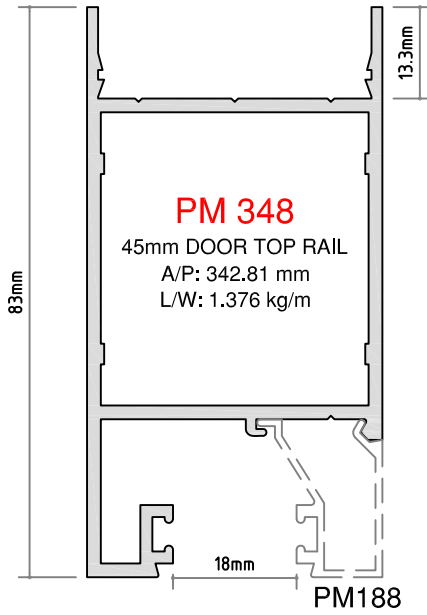


PMA5987  
**PM 110**  
GLAZING ADAPTOR  
A/P: 345.65 mm  
L/W: 0.865 kg/m

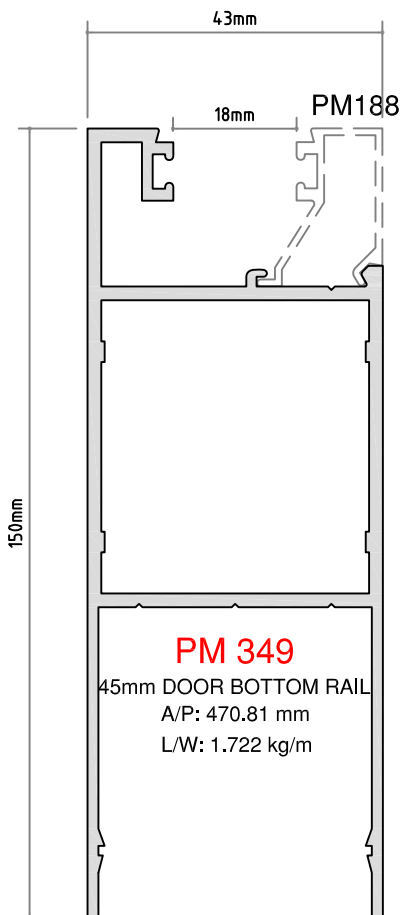




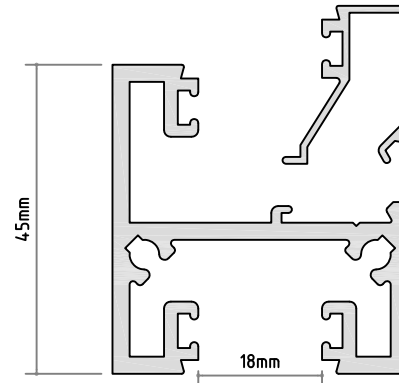
SCALE 1:1



**PM 350**  
 MID-RAIL ADAPTOR  
 (suits PM348 & PM349)  
 A/P: 193.17 mm  
 L/W: 0.385 kg/m

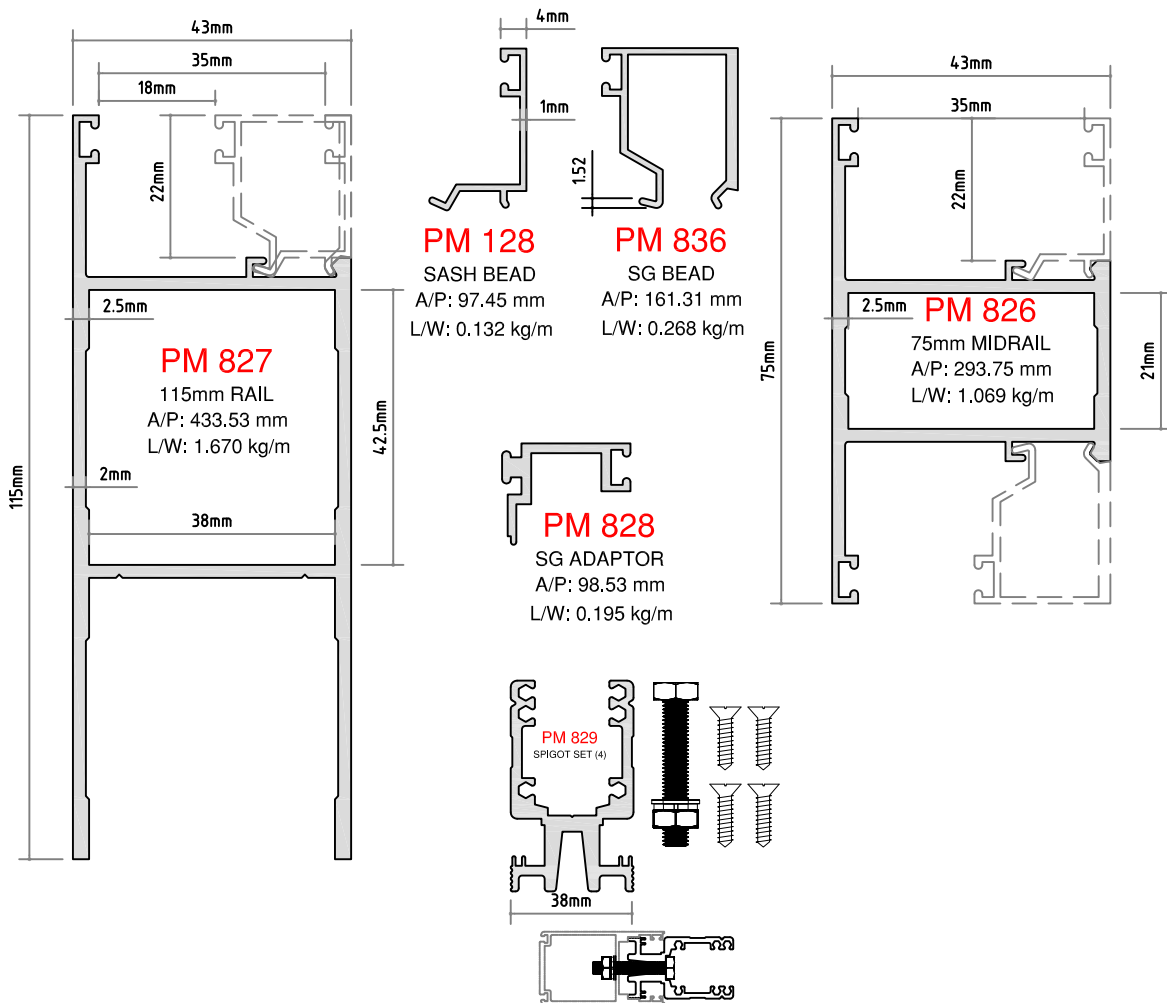
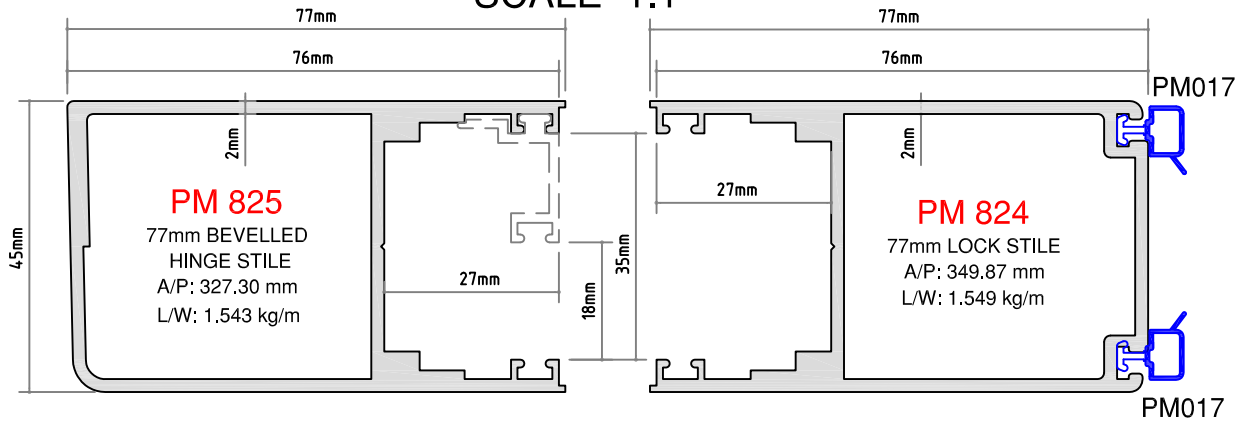


**PM 188**  
 DOOR RAIL BEAD  
 A/P: 135.16 mm  
 L/W: 0.203 kg/m

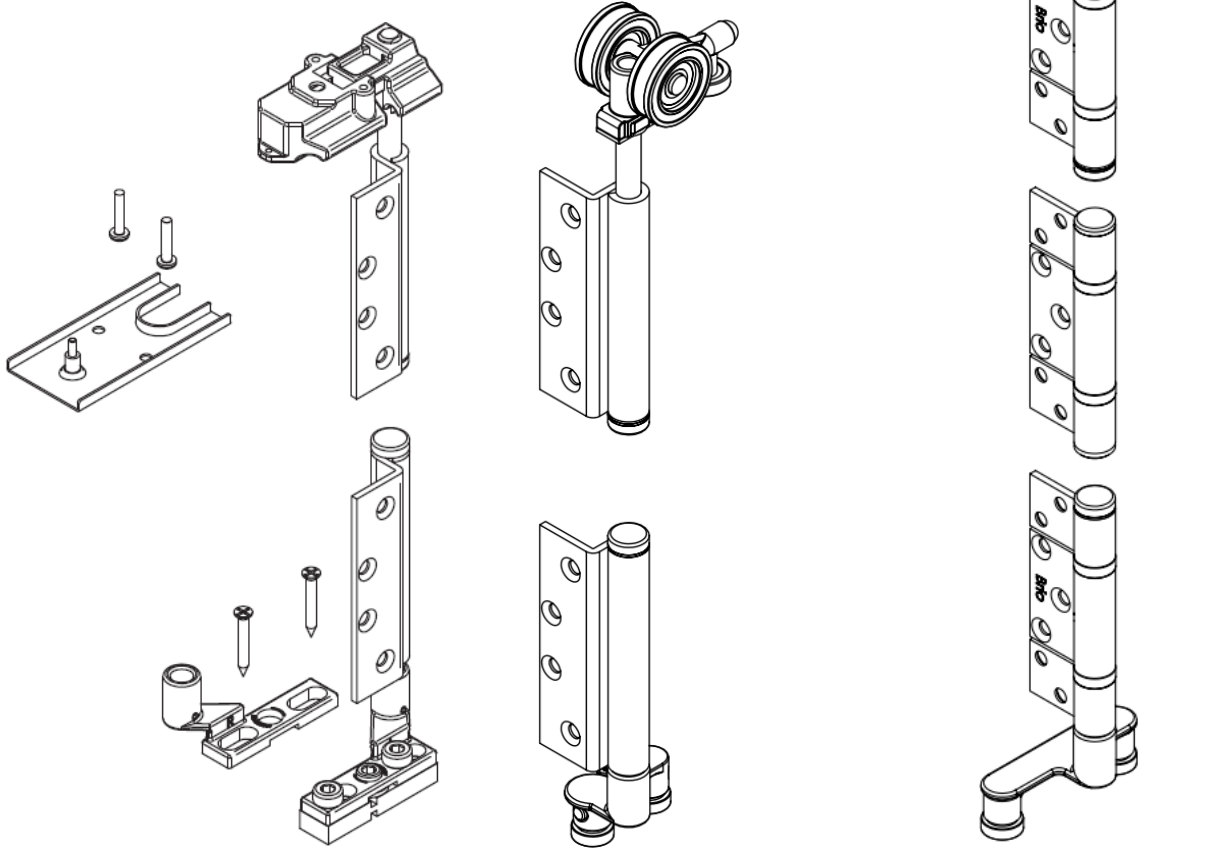
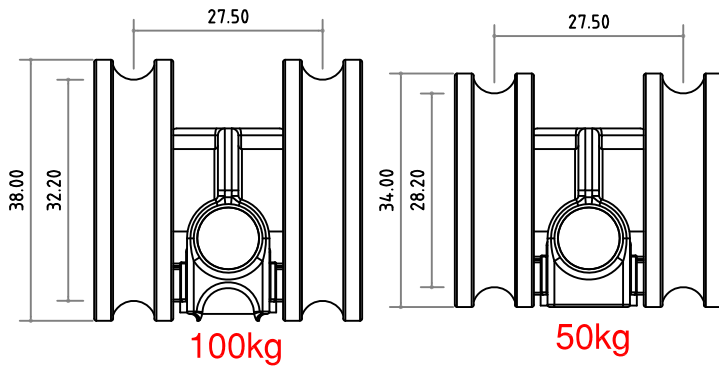


**PM 193**  
 45mm DOOR MID-RAIL  
 A/P: 379.44 mm  
 L/W: 1.190 kg/m

SCALE 1:1



**PIVOT SETS / GUIDE SETS / HANGERS**

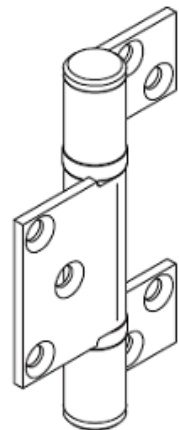
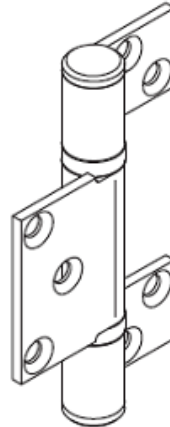
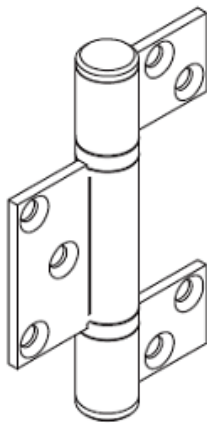
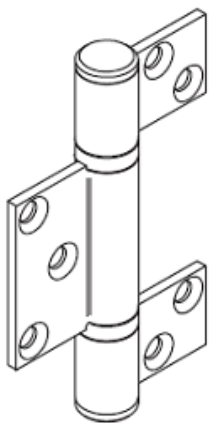
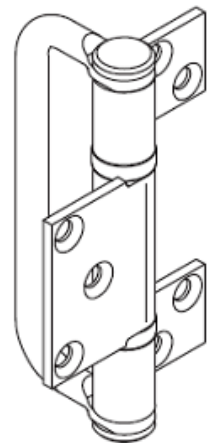
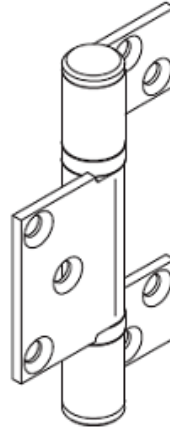
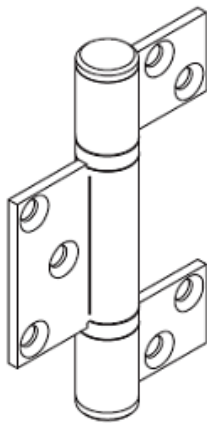
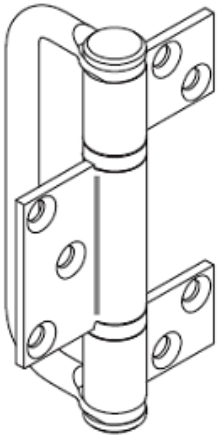
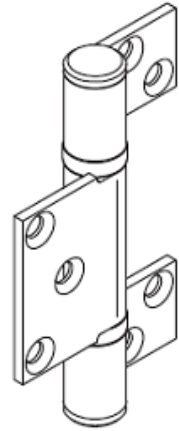
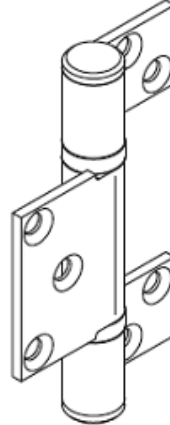
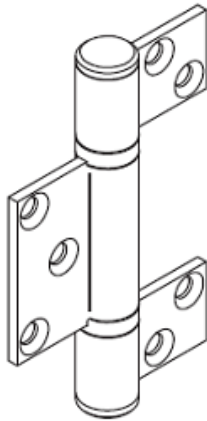
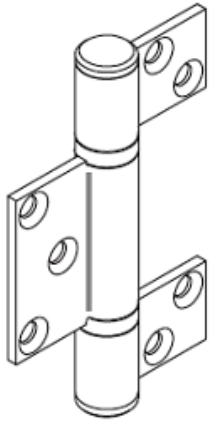


<b>Pivot Set</b>
<b>PM082</b> (BWS1 - 100HSS) 50 - 100Kg

<b>End Hanger Set</b>
<b>PM085</b> (BWS2 - 100SHSS) 100Kg
<b>PM083</b> (BWS2 - 50SHSS) 50Kg

<b>Intermediate Hanger Set</b>
<b>PM086</b> (BWS4 - 100SHSS) 100Kg
<b>PM084</b> (BWS4 - 50SHSS) 50Kg

**HINGE SETS**



<b>Hinge Hanger Set</b>
<b>PM087</b> (BW3 - 100H) 50 - 100Kg

<b>Hinge Set</b>
<b>PM088</b> (BW5 - 100H) 50 - 100Kg

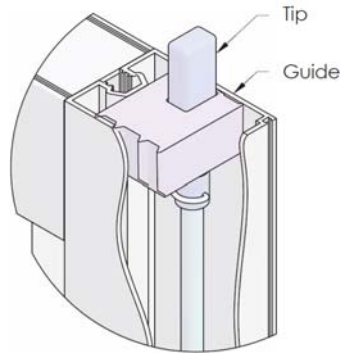
<b>Offset Hinge Set</b>
<b>PM089</b> (BW6 - 100H) 50 - 100Kg

<b>Offset Hinge Handle Set</b>
<b>PM090</b> (BW7 - 100H) 50 - 100Kg

## DOOR FURNITURE

### FINISHES

The discreet 286 Dual Point Lock is supplied in various colours and finishes for matching flexibility. The cast alloy handle is available in stin nickel and black paint while the stainless steel handle offers the choice of stin stainless or polished stainless.



Plastic Tip and Guide

NON LOCKING  
VERSION

LOCKING  
VERSION

LOW PROFILE  
KEY

180 DEGREE  
OPERATION

EURO  
CYLINDER

Aluminium  
Rod Pack  
286-25D

R - Pin

Spacer

Lock Body  
286A

Locking  
Handle  
286L-40SN

Aluminium  
Rod Pack  
286-25D



**PM069**

DORIC DN201  
FLUSH BOLT  
with 250mm  
PROFILE  
OFFSET ROD

PMAA CODE	BRIO CODE	DESCRIPTION
<b>PM091</b>	<b>286N-35PSS</b>	BRIO Dual Point Non Locking Plastic Tip 3.5m SS (KIT)
<b>PM092</b>	<b>286N-35PSN</b>	BRIO Dual Point Non Locking Plastic Tip 3.5m SN (KIT)
<b>PM093</b>	<b>286N-35PPBK</b>	BRIO Dual Point Non Locking Plastic Tip 3.5m PBK (KIT)
<b>PM094</b>	<b>286L-35PSS</b>	BRIO Dual Point Lockable Plastic Tip 3.5m SS (KIT)
<b>PM095</b>	<b>286L-35PSN</b>	BRIO Dual Point Lockable Plastic Tip 3.5m SN (KIT)
<b>PM096</b>	<b>286L-35PPBK</b>	BRIO Dual Point Lockable Plastic Tip 3.5m PBK (KIT)

### NON - KEYED FLUSH BOLTS

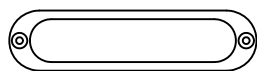
### KEYED FLUSH BOLTS



PMAA CODE	BRIO CODE	DESCRIPTION
<b>512SS 400</b>	<b>512SS - 400mm</b>	Non Locking Flush Bolt
<b>512SS 600</b>	<b>512SS - 600mm</b>	Non Locking Flush Bolt

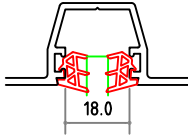


PMAA CODE	BRIO CODE	DESCRIPTION
<b>512ES S 400</b>	<b>512ESS - 400mm</b>	Lockable Flush Bolt
<b>512ES S 600</b>	<b>512ESS - 600mm</b>	Lockable Flush Bolt



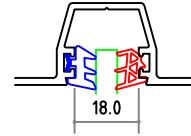
512FSS Flush Bolt Facia Plate  
Suits Both Keyed & Non Keyed Flush Bolts

## GLAZING WEDGES & SEALS



**ROLL IN WEDGE + ROLL IN WEDGE**









Glass Thickness	Roll-in Wedge	Roll-in Wedge
5.00mm	<b>PM 004</b>	<b>PM 004</b>
6.00mm	<b>PM 006</b>	<b>PM 006</b>
6.38mm	<b>PM 006</b>	<b>PM 006</b>
8.00mm	<b>PM 007</b>	<b>PM 007</b>
8.38mm	<b>PM 007</b>	<b>PM 007</b>
10.00mm	<b>PM 005</b>	<b>PM 005</b>
10.38mm	<b>PM 005</b>	<b>PM 005</b>
12.00mm	<b>PM 008</b>	<b>PM 008</b>
12.38mm	<b>PM 008</b>	<b>PM 008</b>

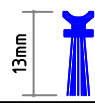






**CAPTIVE WEDGE + ROLL IN WEDGE**

Glass Thickness	Captive Wedge	Roll-in Wedge
6.00mm	<b>PM 001</b>	<b>PM 006</b>
6.38mm	<b>PM 001</b>	<b>PM 006</b>
8.00mm	<b>PM 002</b>	<b>PM 006</b>
8.38mm	<b>PM 002</b>	<b>PM 006</b>
10.00mm	<b>PM 002</b>	<b>PM 007</b>
10.38mm	<b>PM 002</b>	<b>PM 007</b>
12.00mm	<b>PM 002</b>	<b>PM 008</b>
12.38mm	<b>PM 002</b>	<b>PM 008</b>

### WEDGE TYPES (P.V.C MATERIAL)

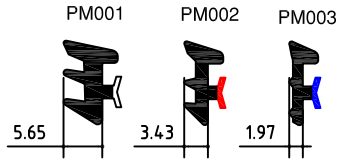
							
White Back	Red Back	Blue Back	Roll in	Roll in	Roll in	Roll in	Roll in
Captive Part No:	Captive Part No:	Captive Part No:	Part No:	Part No:	Part No:	Part No:	Part No:
<b>PM 001</b>	<b>PM 002</b>	<b>PM 003</b>	<b>PM 004</b>	<b>PM 005</b>	<b>PM 006</b>	<b>PM 007</b>	<b>PM 008</b>

SHAPE	PART NO:	FITS TO SECTIONS
	<b>PS 13B</b> Head Track Wool Pile Seal	PM202 - PM206
	<b>PM014</b> Wide Door Stile Bulb Seal	PM198
	<b>PM 017</b> Door Stile Seal	PM183 - PM218
	<b>PM 026</b> Door Stop Seal	PM206 - PM209 - PM220
	<b>PM 073</b> Sill Flap Seal	PM209 - PM211

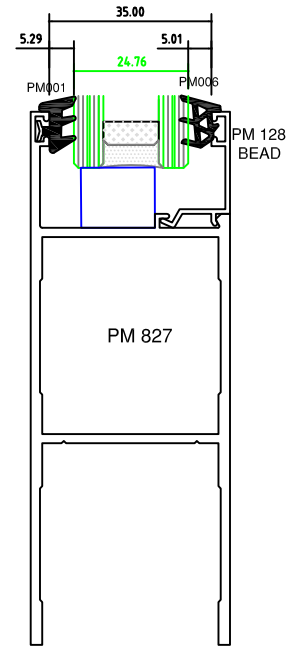
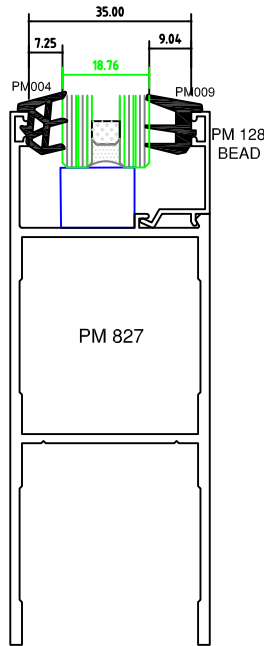
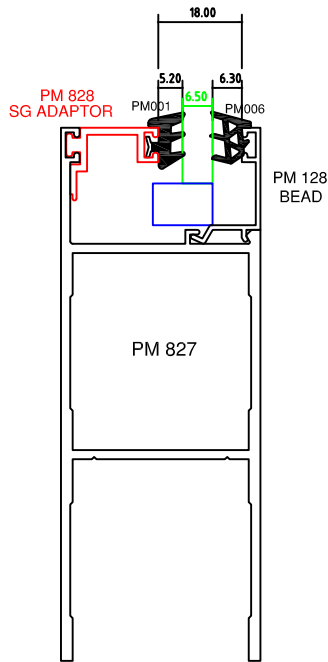
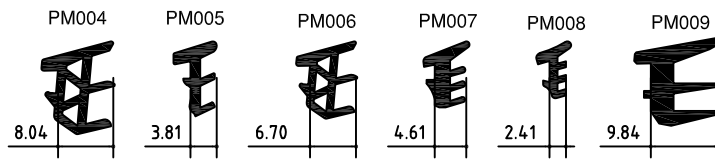




## CAPTIVE WEDGES

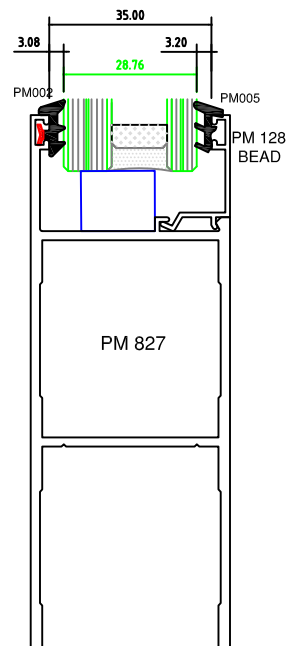
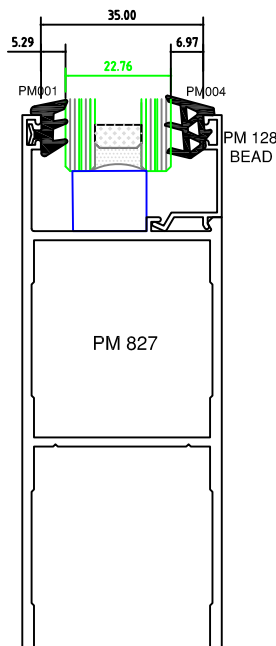


## ROLL-IN WEDGES



### ROLL IN WEDGE + ROLL IN WEDGE

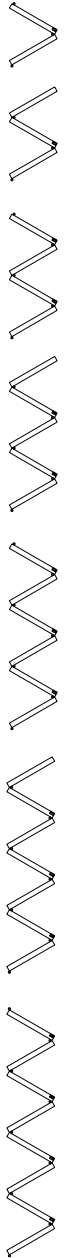
Glass Thickness	Roll-in Wedge	Roll-in Wedge
<b>18mm Pocket</b>		
6.00mm	PM 006	PM 006
6.5mm	PM 006	PM 006
8.00mm	PM 007	PM 007
8.38mm	PM 007	PM 007
10.00mm	PM 005	PM 005
10.5mm	PM 005	PM 005
12.00mm	PM 008	PM 008
12.5mm	PM 008	PM 008



### CAPTIVE WEDGE + ROLL IN WEDGE



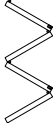
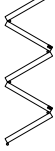
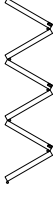
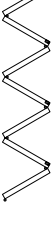
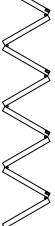
Glass Thickness	Captive Wedge	Roll-in Wedge
<b>18mm Pocket</b>		
6.00mm	PM 001	PM 006
6.5mm	PM 001	PM 006
8.00mm	PM 002	PM 006
8.38mm	PM 002	PM 006
10.00mm	PM 002	PM 007
10.5mm	PM 002	PM 007
12.00mm	PM 002	PM 008
12.5mm	PM 002	PM 008

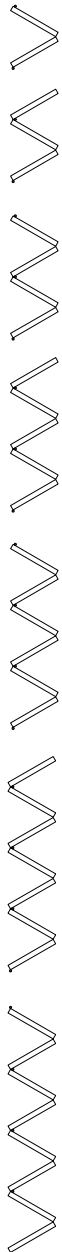
# BRIO HARDWARE SELECTION




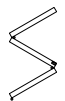
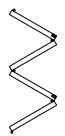

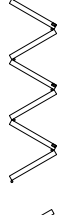
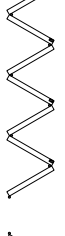
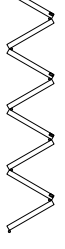
OUTWARD OPENING	50kg	Configuration (L - R)					Configuration (L - R)										
		PM087	PM090	PM082	PM083	PM084	PM091	PM092	PM093	PM094	PM095	PM096	PM040	PM097			
2 Leaf	0.2	1		1	1		1						2				
	2.0	1		1	1		1						2				
	0.3		1	1		1	1						3	1	1		
	1.2	1		2	1		1						3	1			
	2.1	1		2	1		1						3	1			
3 Leaf	3.0		1	1		1	1						3	1	1		
	0.4		2	1	1	1	2						4				
	1.3		1	2		1	2						4	1			
	2.2	2		2	1		2						4				
	3.1		1	2		1	2						4	1			
4 Leaf	4.0		2	1	1	1	2						4				
	0.5	1	1	1		2	2						5	1	1		
	1.4		2	2	1	1	2						5	1			
	2.3	1	1	2	1	1	2						5	1			
	3.2	1	1	2	1	1	2						5	1			
5 Leaf	4.1		2	2	1	1	2						5	1			
	5.0	1	1	1		2	2						5	1	1		
	0.6	1	2	1	1	2	3						6				
	1.5	1	1	2		2	3						6	1			
	2.4	1	2	2	2	1	3						6				
6 Leaf	3.3		2	2		2	3						6	1			
	4.2	1	2	2	2	1	3						6				
	5.1	1	1	2		2	3						6	1			
	6.0	1	2	1	1	2	3						6				
	0.7	2	1	1		3	3						7	1	1		
7 Leaf	1.6	1	2	2	1	2	3						7	1			
	2.5	2	1	2	1	2	3						7	1			
	3.4		3	2	1	2	3						7	1			
	4.3		3	2	1	2	3						7	1			
	5.2	2	1	2	1	2	3						7	1			
8 Leaf	6.1	1	2	2	1	2	3						7	1			
	7.0	2	1	1		3	3						7	1	1		
	0.8	2	2	1	1	3	4						8				
	1.7	2	1	2		3	4						8	1			
	2.6	2	2	2	2	2	4						8				
8 Leaf	3.5	1	2	2		3	4						8	1			
	4.4		4	2	2	2	4						8				
	5.3	1	2	2		3	4						8	1			
	6.2	2	2	2	2	2	4						8				
	7.1	2	1	2		3	4						8	1			
8.0	2	2	1	1	3	4						8					



	INWARD OPENING	50kg	Configuration (L - R)					Hardware Selection									
			PM088	PM089	PM082	PM083	PM084	PM091	PM092	PM093	PM094	PM095	PM096	PM040	PM097		
			BW5-100HSS Brio WF Hinge Set 100	BW6-100HSS Brio WF Offset Hinge Set 100	BWS1-100HSS Brio WF 4s Pivot Set 100	BWS2-50SHSS Brio WF 4s End Set 50s	BWS4-50SHSS Brio WF 4s Intermedite Set 50s	286N-35PSS BRIO Twin Point Non Locking SS	286N-35PSN Brio Twin Point Non Locking SN	286N-35PPBK BRIO Twin Point Non Locking PBK	286L-35PSS BRIO Twin Point Lockable SS	286L-35PSN BRIO Twin Point Lockable SN	286L-35PPBK BRIO Twin Point Lockable PBK	Door Assembly Package (Spiggot set of 4)	Mortice Lock - 25.4mm Backset	Extended Lip Strike Plate	
	2 Leaf	0.2	1		1	1									2		
		2.0	1		1	1									2		
	3 Leaf	0.3		1	1		1								3	1	1
		1.2	1		2	1									3	1	
		2.1	1		2	1									3	1	
		3.0		1	1			1							3	1	1
	4 Leaf	0.4		2	1	1	1								4		
		1.3		1	2		1								4	1	
		2.2	2		2	2									4		
		3.1		1	2		1								4	1	
		4.0		2	1	1	1								4		
	5 Leaf	0.5	1	1	1		2								5	1	1
		1.4		2	2	1	1								5	1	
		2.3	1	1	2	1	1								5	1	
		3.2	1	1	2	1	1								5	1	
		4.1		2	2	1	1								5	1	
		5.0	1	1	1		2								5	1	1
	6 Leaf	0.6	1	2	1	1	2								6		
		1.5	1	1	2		2								6	1	
		2.4	1	2	2	2	1								6		
		3.3		2	2		2								6	1	
		4.2	1	2	2	2	1								6		
		5.1	1	1	2		2								6	1	
		6.0	1	2	1	1	2								6		
	7 Leaf	0.7	2	1	1		3								7	1	1
		1.6	1	2	2	1	2								7	1	
		2.5	2	1	2	1	2								7	1	
		3.4		3	2	1	2								7	1	
		4.3		3	2	1	2								7	1	
		5.2	2	1	2	1	2								7	1	
		6.1	1	2	2	1	2								7	1	
		7.0	2	1	1		3								7	1	1
	8 Leaf	0.8	2	2	1	1	3								8		
		1.7	2	1	2		3								8	1	
		2.6	2	2	2	2	2								8		
		3.5	1	2	2		3								8	1	
		4.4		4	2	2	2								8		
		5.3	1	2	2		3								8	1	
		6.2	2	2	2	2	2								8		
		7.1	2	1	2		3								8	1	
8.0	2	2	1	1	3								8				



OUTWARD OPENING	100kg	Configuration (L - R)					Hardware Selection										
		PM087	PM090	PM082	PM085	PM086	PM091	PM092	PM093	PM094	PM095	PM096	PM040	PM097			
		BW3-100HSS Brio WF Hinge Handle Set 100	BW7-100HSS Brio Offset Hinge handle Set 100	BWS1-100HSS Brio WF 4s Pivot Set 100	BWS2-100HSS Brio WF 4s End Set 50S	BWS4-100HSS Brio WF 4s Intermedite Set 50s	286N-35PSS Brio Twin Point Non Locking SS	286N-35PSN Brio Twin Point Non Locking SN	286N-35PPBK Brio Twin Point Non Locking PBK	286L-35PSS Brio Twin Point Lockable SS	286L-35PSN Brio Twin Point Lockable SN	286L-35PPBK Brio Twin Point Lockable PBK	Door Assembly Package (Spigot set of 4)	Mortice Lock - 25.4mm Backset	Extended Lip Strike Plate		
2 Leaf	0.2	1		1	1		1								2		
	2.0	1		1	1		1								2		
3 Leaf	0.3		1	1		1	1								3	1	1
	1.2	1		2	1		1								3	1	
	2.1	1		2	1		1								3	1	
	3.0		1	1		1	1								3	1	1
4 Leaf	0.4		2	1	1	1	2								4		
	1.3		1	2		1	2								4	1	
	2.2	2		2	1		2								4		
	3.1		1	2		1	2								4	1	
	4.0		2	1	1	1	2							4			
5 Leaf	0.5	1	1	1		2	2								5	1	1
	1.4		2	2	1	1	2								5	1	
	2.3	1	1	2	1	1	2								5	1	
	3.2	1	1	2	1	1	2								5	1	
	4.1		2	2	1	1	2								5	1	
	5.0	1	1	1		2	2								5	1	1
6 Leaf	0.6	1	2	1	1	2	3								6		
	1.5	1	1	2		2	3								6	1	
	2.4	1	2	2	2	1	3								6		
	3.3		2	2		2	3								6	1	
	4.2	1	2	2	2	1	3								6		
	5.1	1	1	2		2	3								6	1	
	6.0	1	2	1	1	2	3								6		
7 Leaf	0.7	2	1	1		3	3								7	1	1
	1.6	1	2	2	1	2	3								7	1	
	2.5	2	1	2	1	2	3								7	1	
	3.4		3	2	1	2	3								7	1	
	4.3		3	2	1	2	3								7	1	
	5.2	2	1	2	1	2	3								7	1	
	6.1	1	2	2	1	2	3								7	1	
	7.0	2	1	1		3	3								7	1	1
8 Leaf	0.8	2	2	1	1	3	4								8		
	1.7	2	1	2		3	4								8	1	
	2.6	2	2	2	2	2	4								8		
	3.5	1	2	2		3	4								8	1	
	4.4		4	2	2	2	4								8		
	5.3	1	2	2		3	4								8	1	
	6.2	2	2	2	2	2	4								8		
	7.1	2	1	2		3	4								8	1	
	8.0	2	2	1	1	3	4								8		

	INWARD OPENING	100kg	BW5-100HSS Brio WF Hinge Set 100	BW6-100HSS Brio WF Offset Hinge Set 100	BWS1-100HSS Brio WF 4s Pivot Set 100	BWS2-100SHSS Brio WF 4s End Set 50s	BWS4-100SHSS Brio WF 4s Intermedite Set 50s	286N-35PSS Brio Twin Point Non Locking SS	286N-35PSN Brio Twin Point Non Locking SN	286N-35PPBK Brio Twin Point Non Locking PBK	286L-35PSS Brio Twin Point Lockable SS	286L-35PSN Brio Twin Point Lockable SN	286L-35PPBK Brio Twin Point Lockable PBK	Door Assembly Package (Spigot set of 4)	Mortice Lock - 25.4mm Backset	Extended Lip Strike Plate	
			Configuration (L - R)	PM088	PM089	PM082	PM085	PM086	PM091	PM092	PM093	PM094	PM095	PM096	PM040	PM097	
	2 Leaf	0.2	1		1	1		1							2		
		2.0	1		1	1		1							2		
	3 Leaf	0.3		1	1		1	1							3	1	1
		1.2	1			2	1		1						3	1	
		2.1	1			2	1		1						3	1	
		3.0		1	1	1		1	1						3	1	1
	4 Leaf	0.4		2	1	1	1	1							4		
		1.3		1	2		1		2						4	1	
		2.2	2			2	2		2						4		
		3.1		1	2		1		2						4	1	
	5 Leaf	0.5	1	1	1		2	2							5	1	1
		1.4		2	2	1	1		2						5	1	
		2.3	1	1	2	1	1		2						5	1	
		3.2	1	1	2	1	1		2						5	1	
		4.1		2	2	1	1		2						5	1	
	6 Leaf	0.6	1	2	1	1	2	3							6		
		1.5	1	1	2		2		3						6	1	
		2.4	1	2	2	2	1		3						6		
		3.3		2	2		2		3						6	1	
		4.2	1	2	2	2	1		3						6		
		5.1	1	1	2		2		3						6	1	
	7 Leaf	0.7	2	1	1		3	3							7	1	1
		1.6	1	2	2	1	2		3						7	1	
		2.5	2	1	2	1	2		3						7	1	
		3.4		3	2	1	2		3						7	1	
		4.3		3	2	1	2		3						7	1	
		5.2	2	1	2	1	2		3						7	1	
		6.1	1	2	2	1	2		3						7	1	
	8 Leaf	0.8	2	2	1	1	3	4							8		
		1.7	2	1	2		3		4						8	1	
		2.6	2	2	2	2	2		4						8		
		3.5	1	2	2		3		4						8	1	
		4.4		4	2	2	2		4						8		
		5.3	1	2	2		3		4						8	1	
		6.2	2	2	2	2	2		4						8		
		7.1	2	1	2		3		4						8	1	
8.0	2	2	1	1	3		4						8				



## Brio® Weatherfold 4s 50 & 100kg System Calculator

**Brio**  
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391 Park Rd, Regents Park  
P +61 (0) 8718 6718 F +61 (0) 8718 6719  
E sales@brio.com.au W www.brio.com.au

**Door Configuration**

What is the height and width of the   mm high  mm wide

Doors opening inward or outwards?

Number of panels folding to the left?

Number of panels folding to the right?

Number of floating panels?

Number of systems of this type?

Panel Weight? (kg)

Timber or Aluminium doors?

**Options**

Type of floor channel?

Type of track?

Hanger bearing?

Number of pairs of magnetic catches?

Which type of jamb centre support?

What is the meeting door configuration?

Flush Bolt types?

Square or round top flushbolt?

Are router bits required?

Drilling jig?

Retractable pleated insect screen?

**Selected Door Configuration**



HARDWARE LEGEND		
SYMBOL	REF.	DESCRIPTION
	1	Adjustable pivot set
	2	End hanger set with guide
	3	Hinge set with hinge handle
	4	Intermediate hanger set with guide
	5	Hinge set
	6	Offset hinge set
	7	Offset hinge set with hinge handle
	8	Meeting door set
	FB	Flush bolt No. 456
	ML	Mortice lock No. 6200
	FP	Flush pull No. 401
	FB&FP	Flush bolt & flush pull

The reference number is an abbreviation of the full set number.

[See Bill of Materials](#)

[See Door Calc.](#)



**Brio**  
C5, Regents Park Estate  
391 Park Rd, Regents Park  
P +61 (0) 8718 6718 F +61 (0) 8718 6719  
E sales@brio.com.au W www.brio.com.au

COMPANY:

PROJECT REFERENCE:

CONTACT NAME:

CONTACT PH / EMAIL:

ORDER NO:

NOTES:

1 Unit(s)  
2400mm Opening height  
3500mm Opening width  
2 Left  
2 Right  
0 Floating

### Bill of Quantities

Code	Description	System Qty
<b>Track and Channel</b>		
180-A40	Track aluminium anodised - 4000mm	1
94PPA-40	Polypropylene Black + Channel Mill 4000mm	1
<b>Hangers and Guides</b>		
BWS1-100HSS	Brio WF 4s Pivot Set 100 Non Morticed SS	2
BWS2-50SHSS	Brio WF 4s End Set 50 S Non-Morticed SS	2
<b>Hinges &amp; Accessories</b>		
BW3-100HSS	Brio WF Hinge Handle Set 100 Non-Morticed SS	2
<b>Flush Bolts Top</b>		
512SS-400	Flush Bolt - Standard - 400mm - Satin Stainless	2
<b>Flush Bolts Bottom</b>		
512ESS-400	Flush Bolt - Lockable - 400mm - Satin Stainless	2
<b>Seals</b>		
AQ21B-15	Frame Seal 15M Bag	1
PS13B-6	Track Seal 6M Bag	1

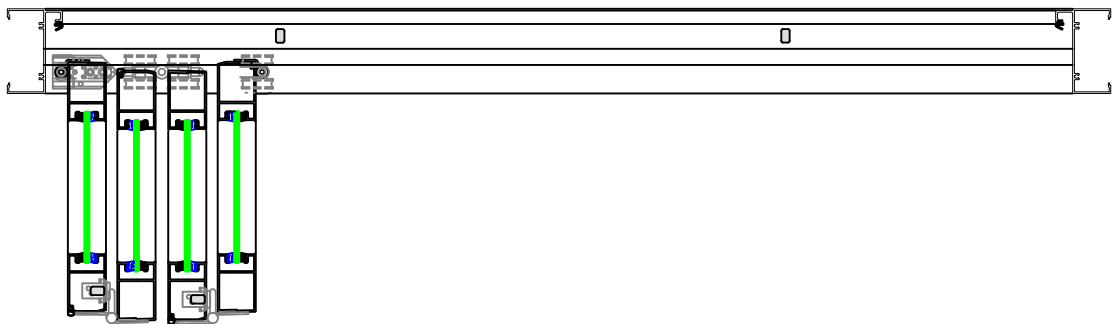
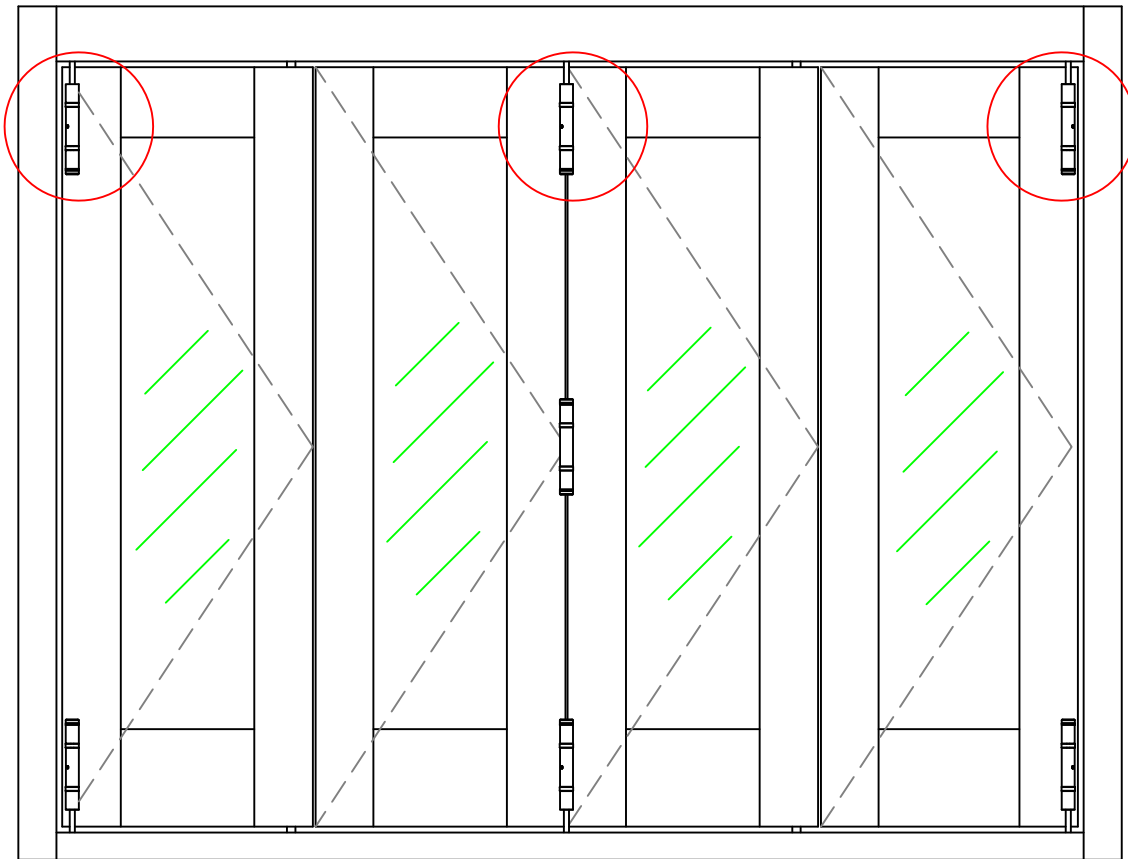
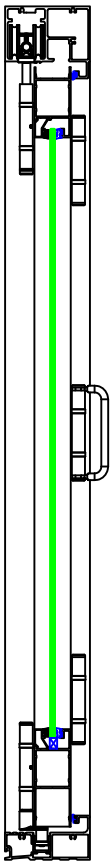
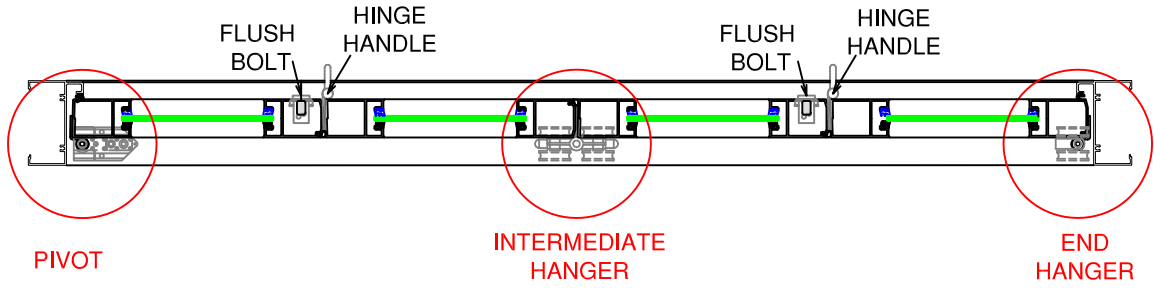
### Accessories

# **SECTION:        B**

## ***Frame Assembly Details***

**Pages:            B01 to B14**

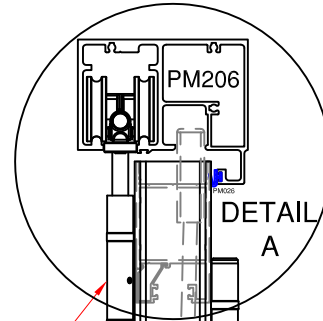
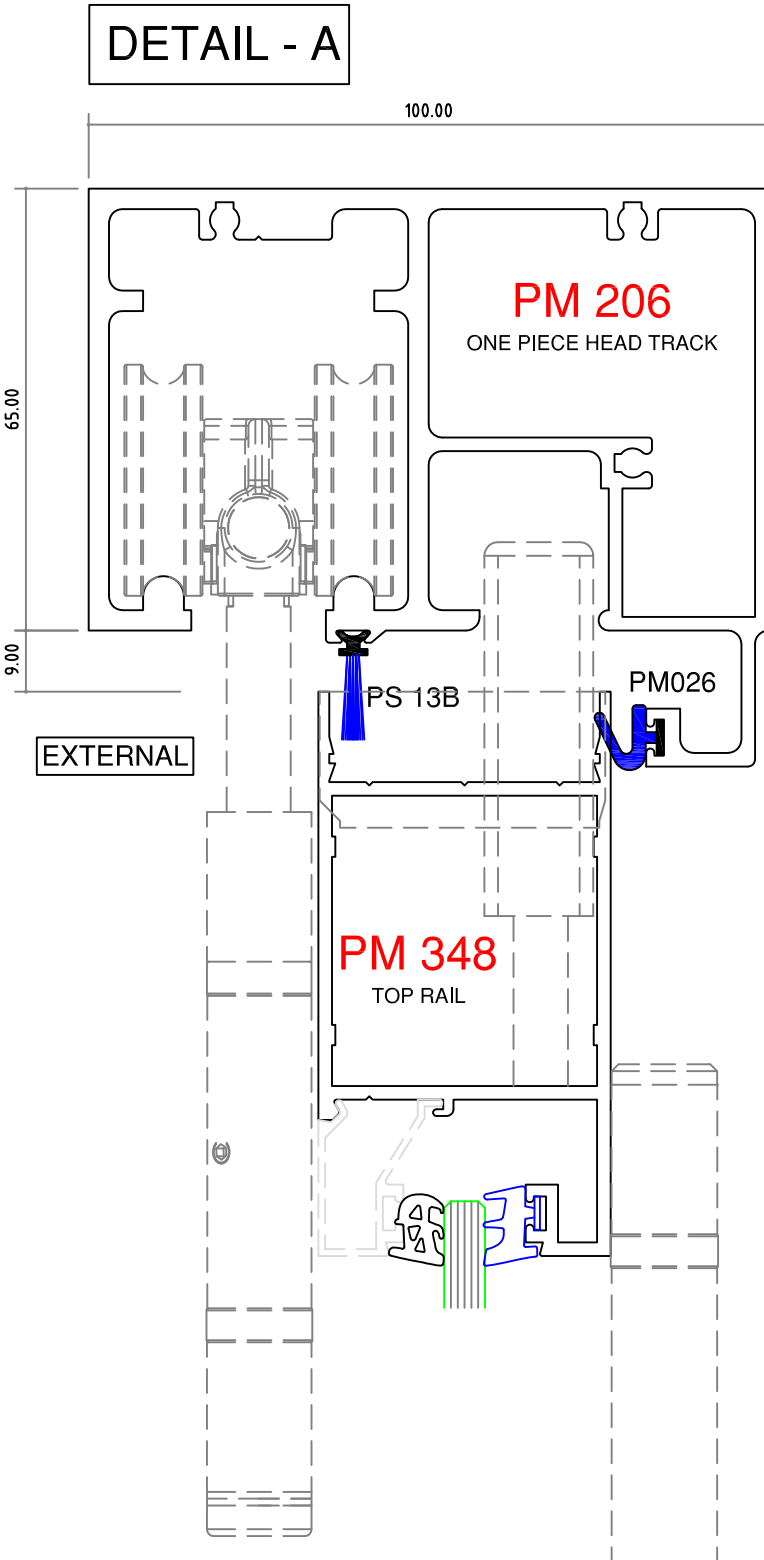
# TYPICAL CONFIGURATION 4 PANEL OPENING OUTWARD RIGHT TO LEFT



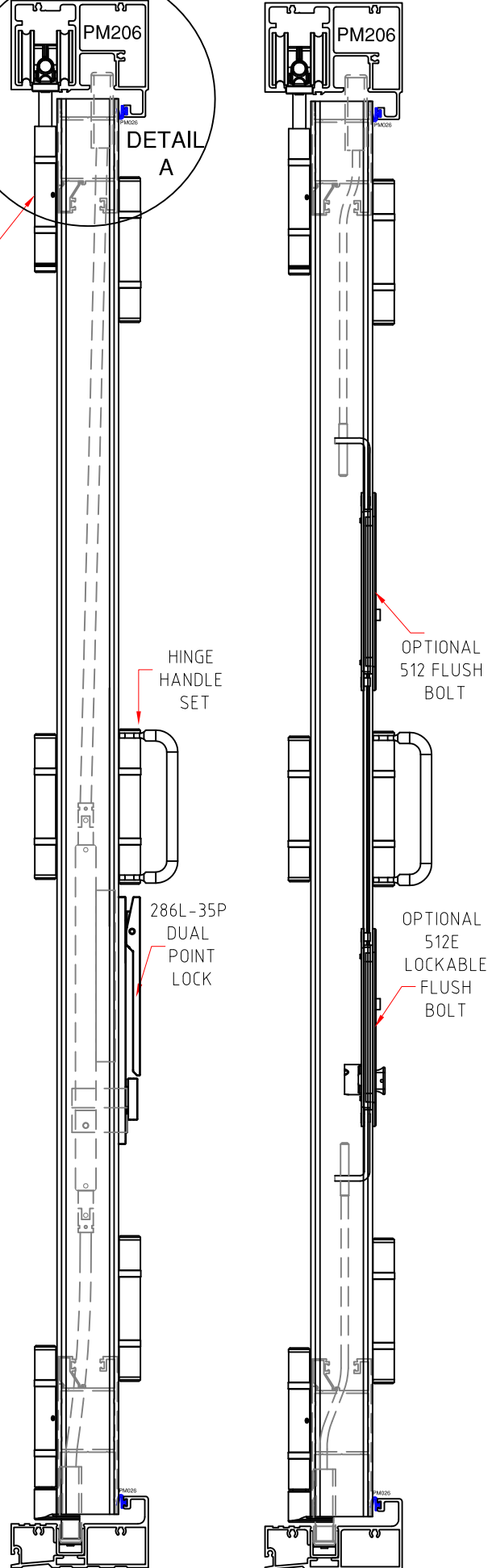


# PM206 - HEAD TRACK DETAIL "A"

Not to Scale

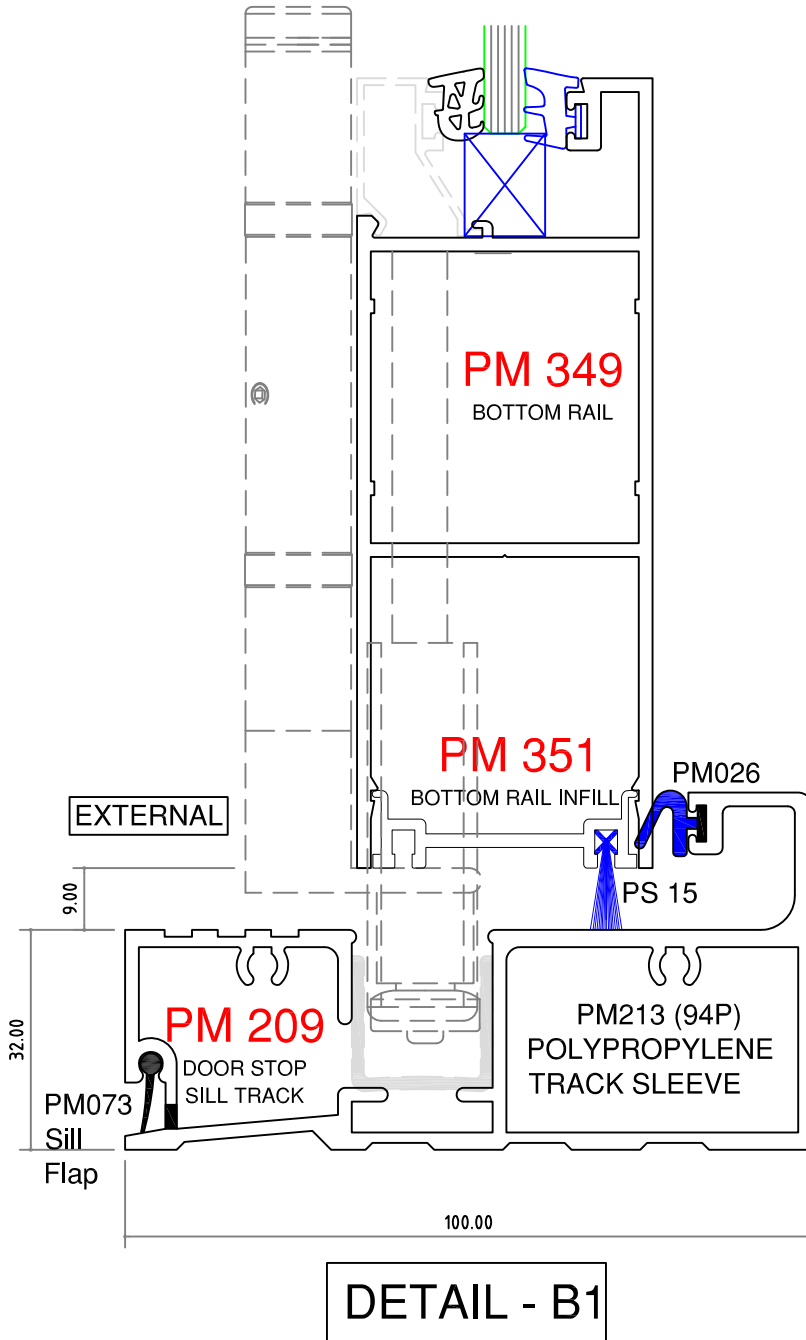


INTERMEDIATE HANGER

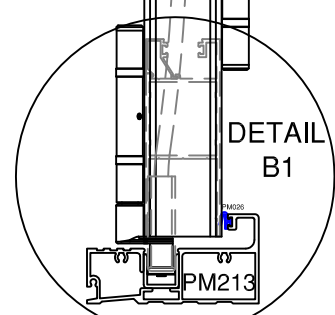
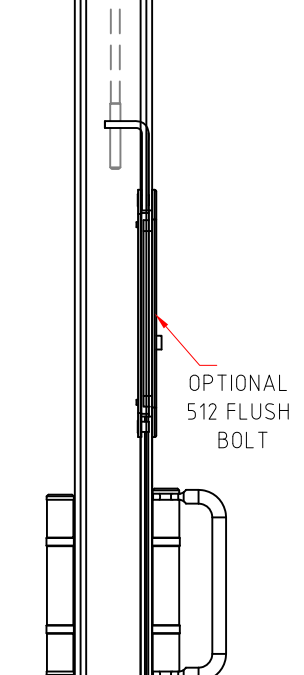
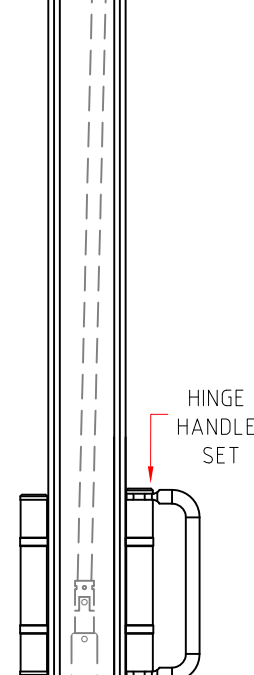
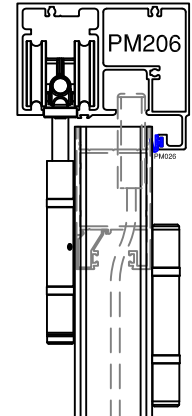
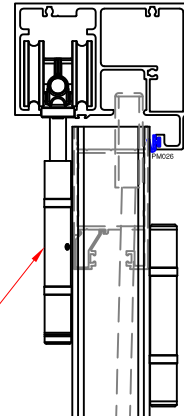


# PM213 - SILL TRACK DETAIL "B1"

Not to Scale

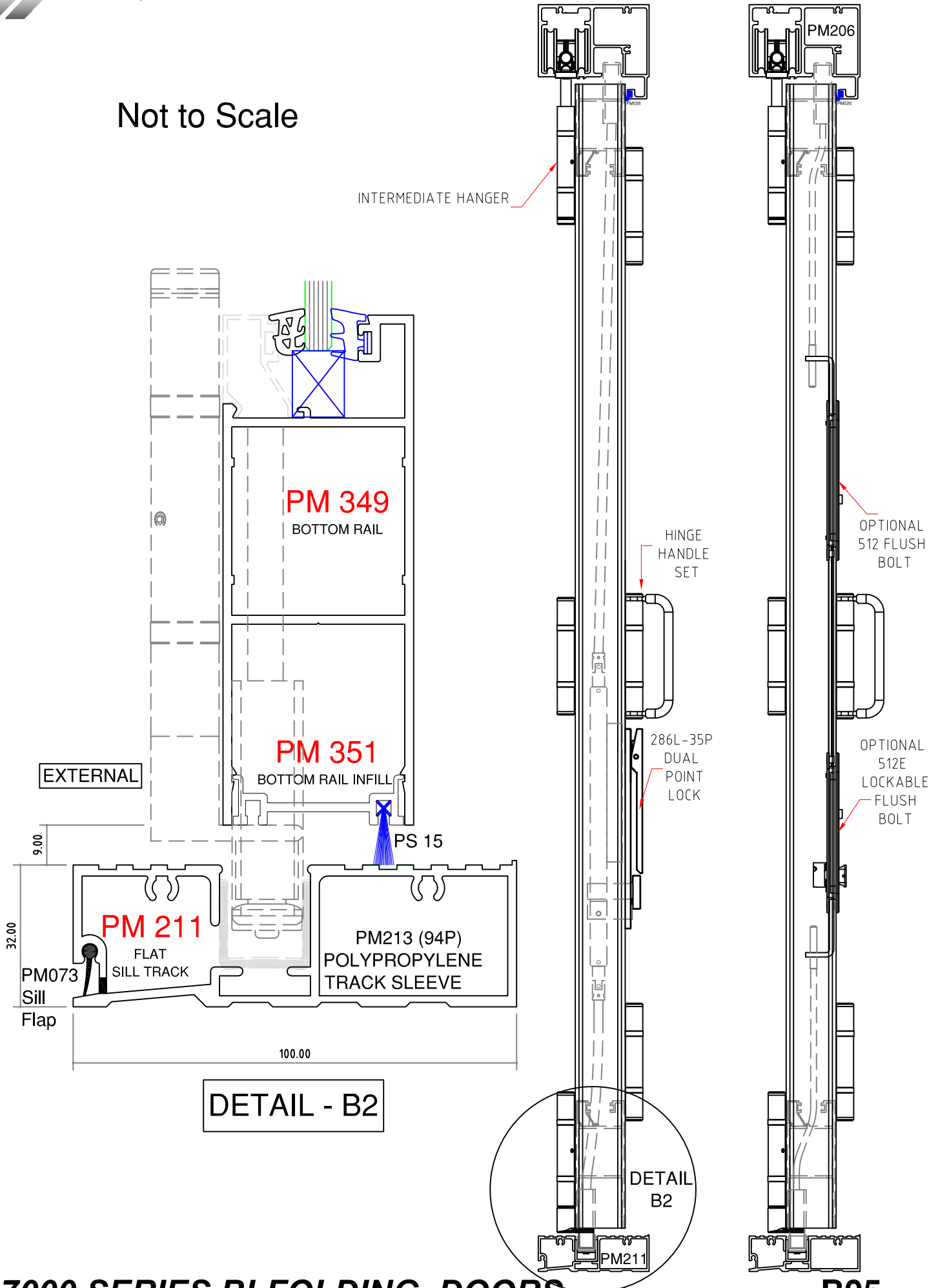


INTERMEDIATE HANGER



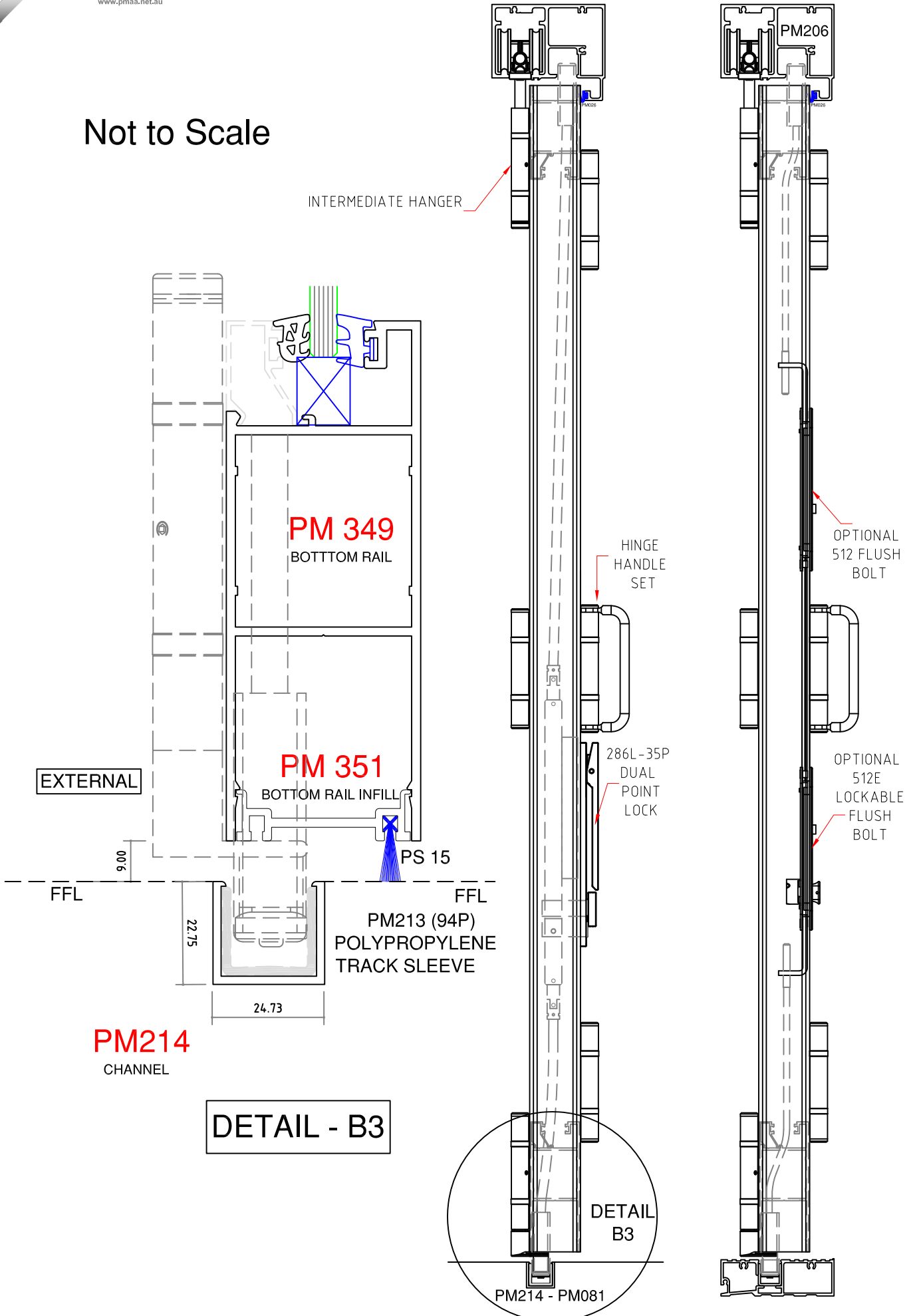
# PM216 - SILL TRACK DETAIL "B2"

Not to Scale



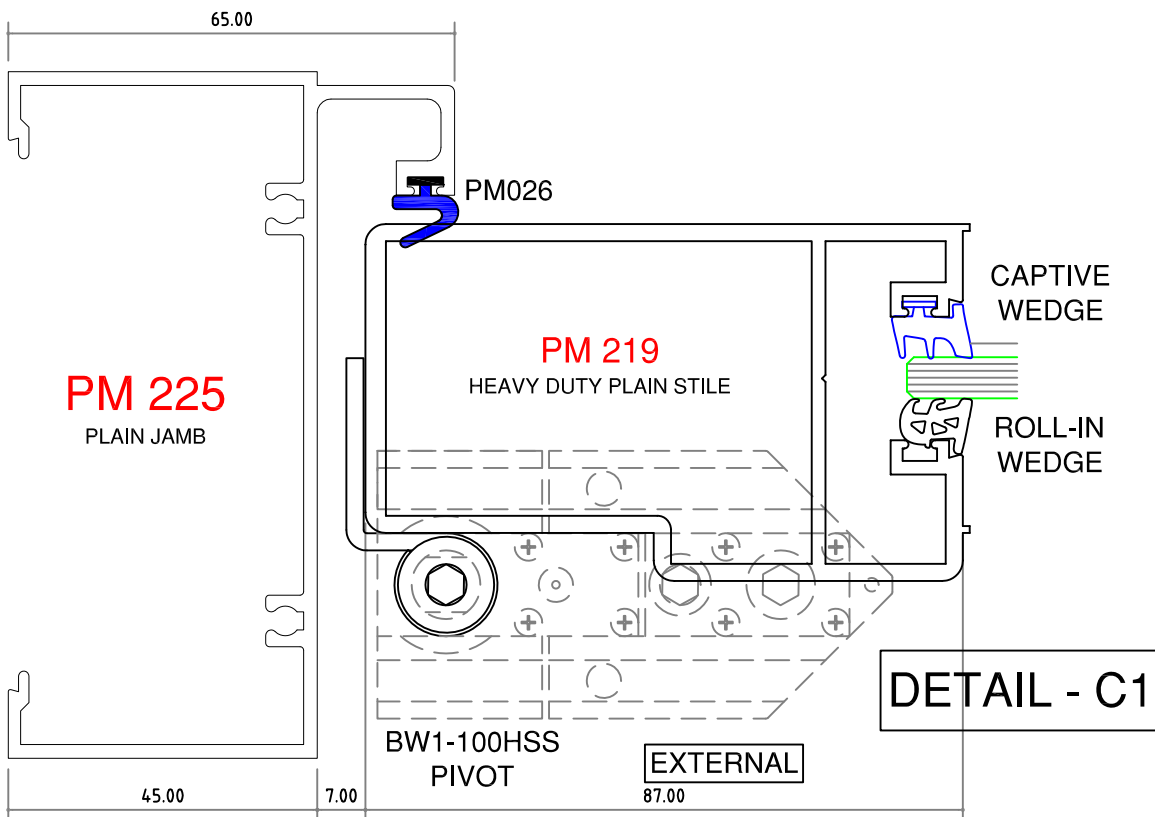
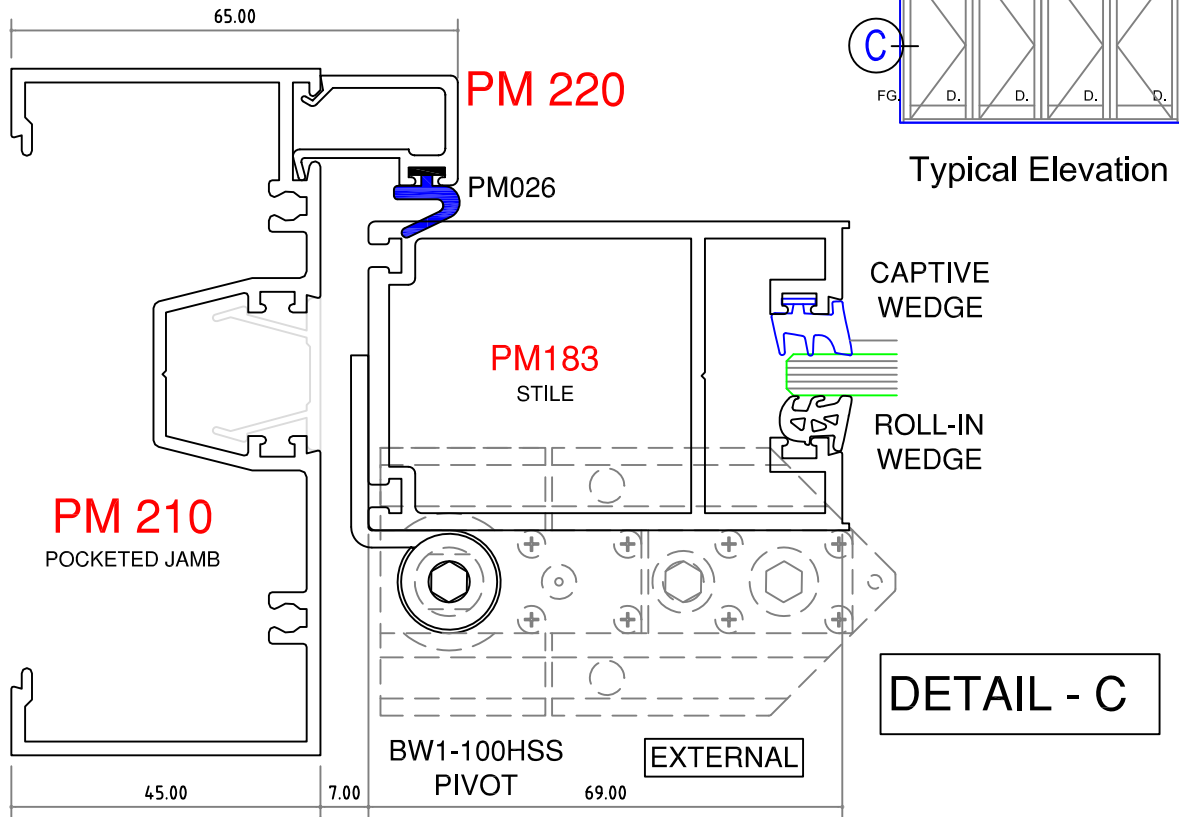
# PM214 - SILL TRACK DETAIL "B3"

Not to Scale



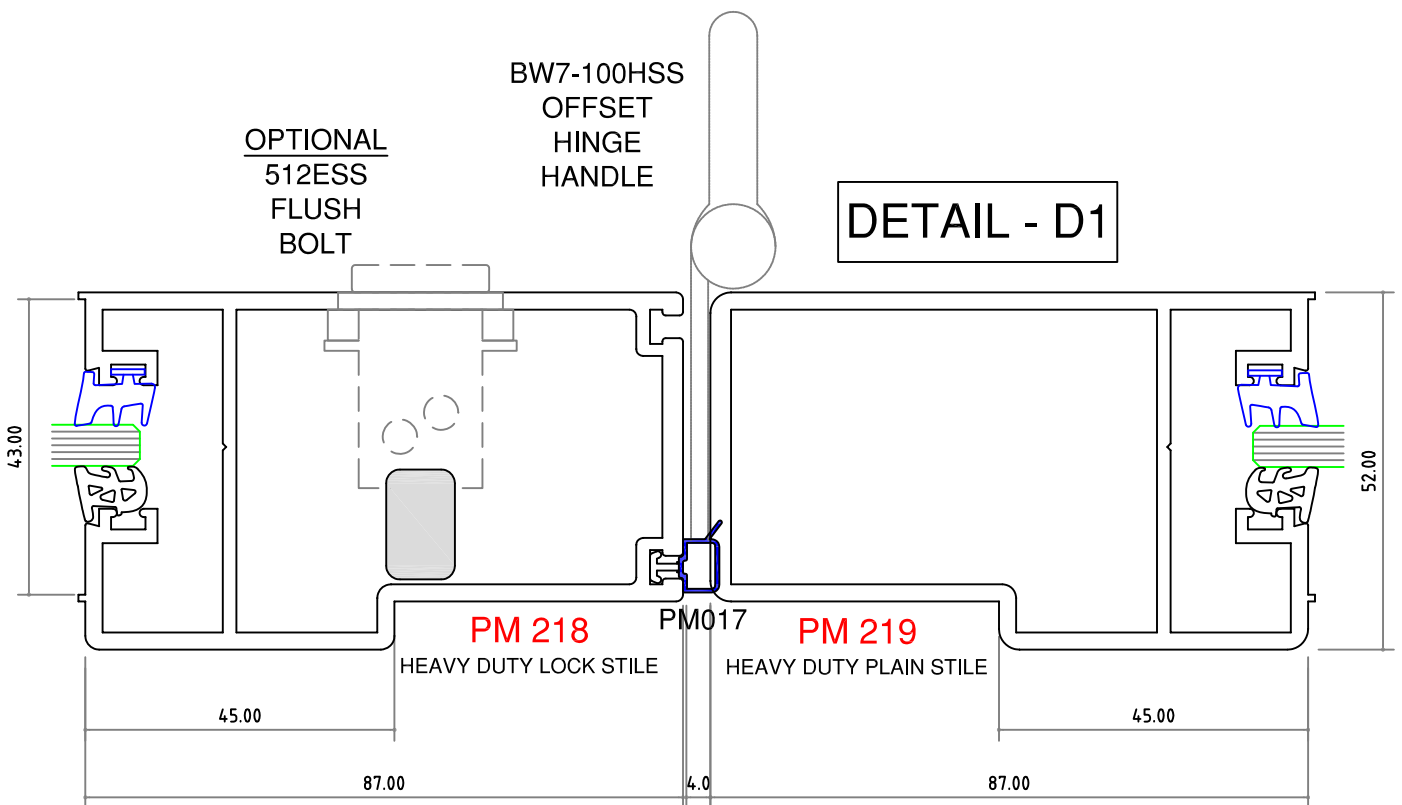
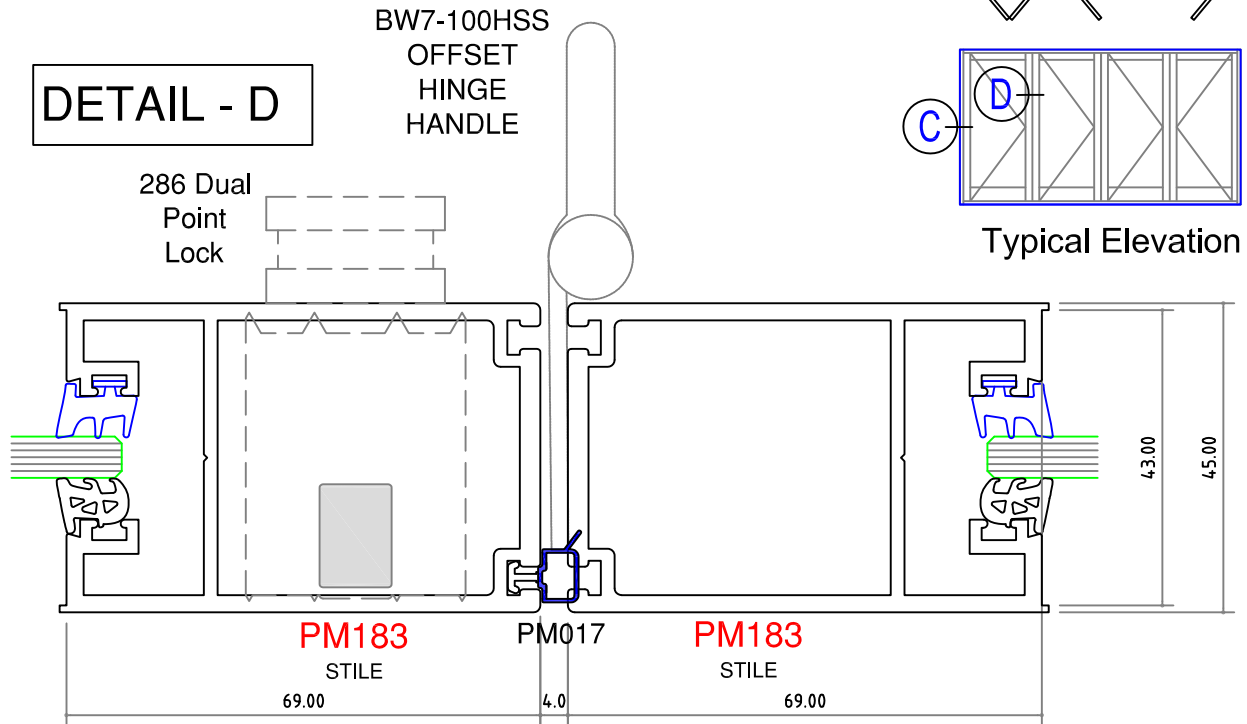
# PM210 - PM225 JAMB / PIVOT DETAIL "C"

Not to Scale



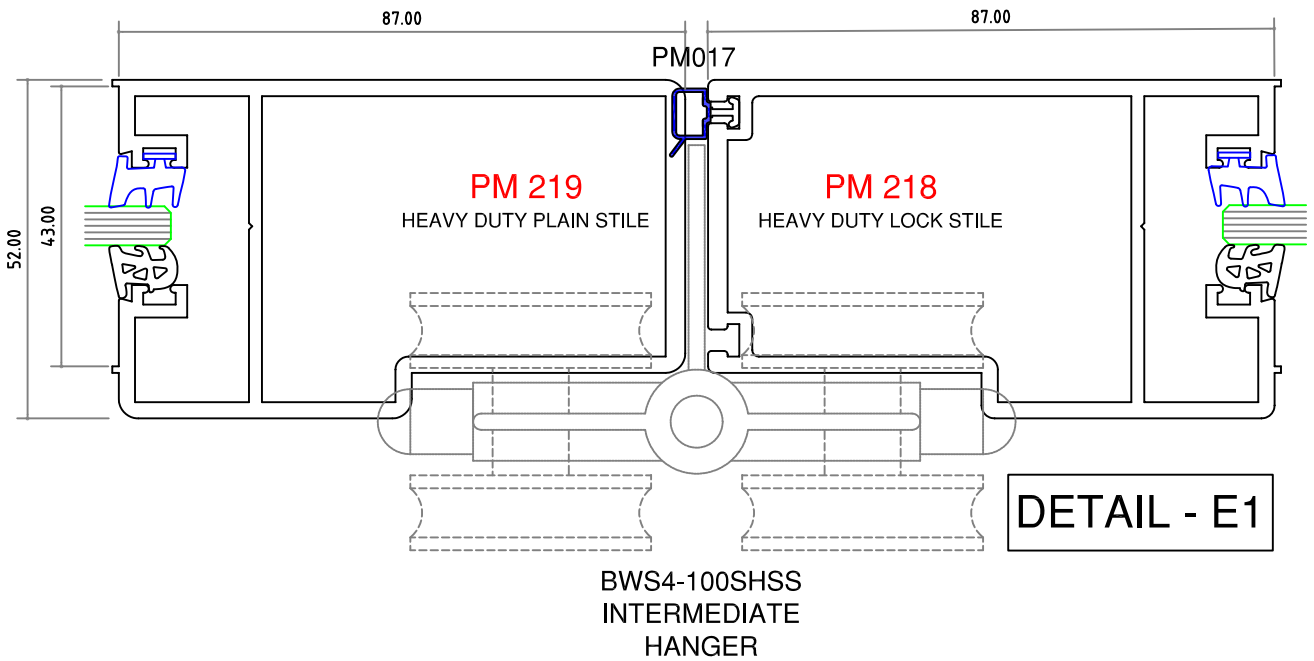
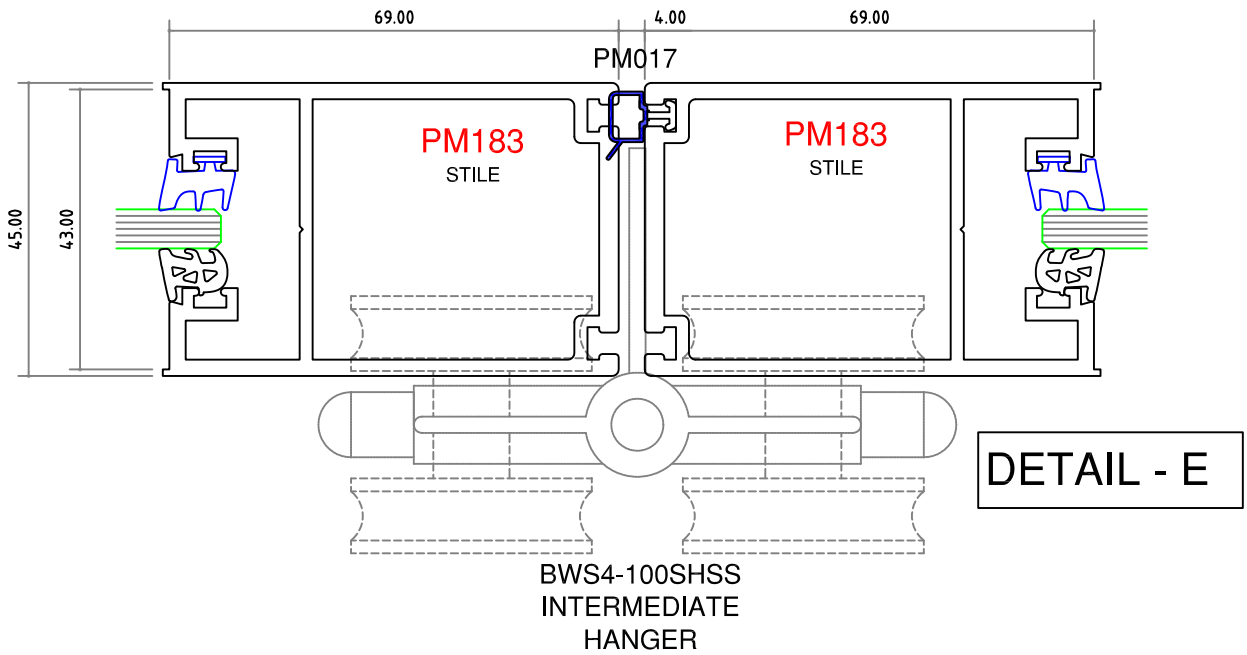
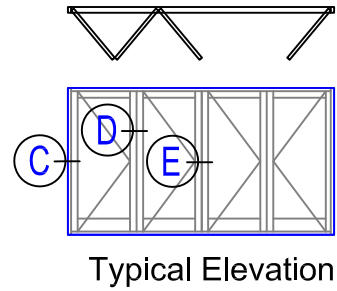
# HINGE STILE DETAILS "D"

Not to Scale

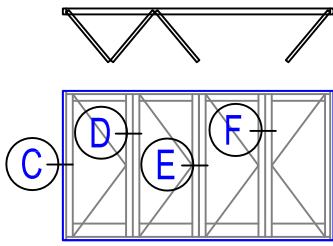


# HANGER STILE DETAILS "E"

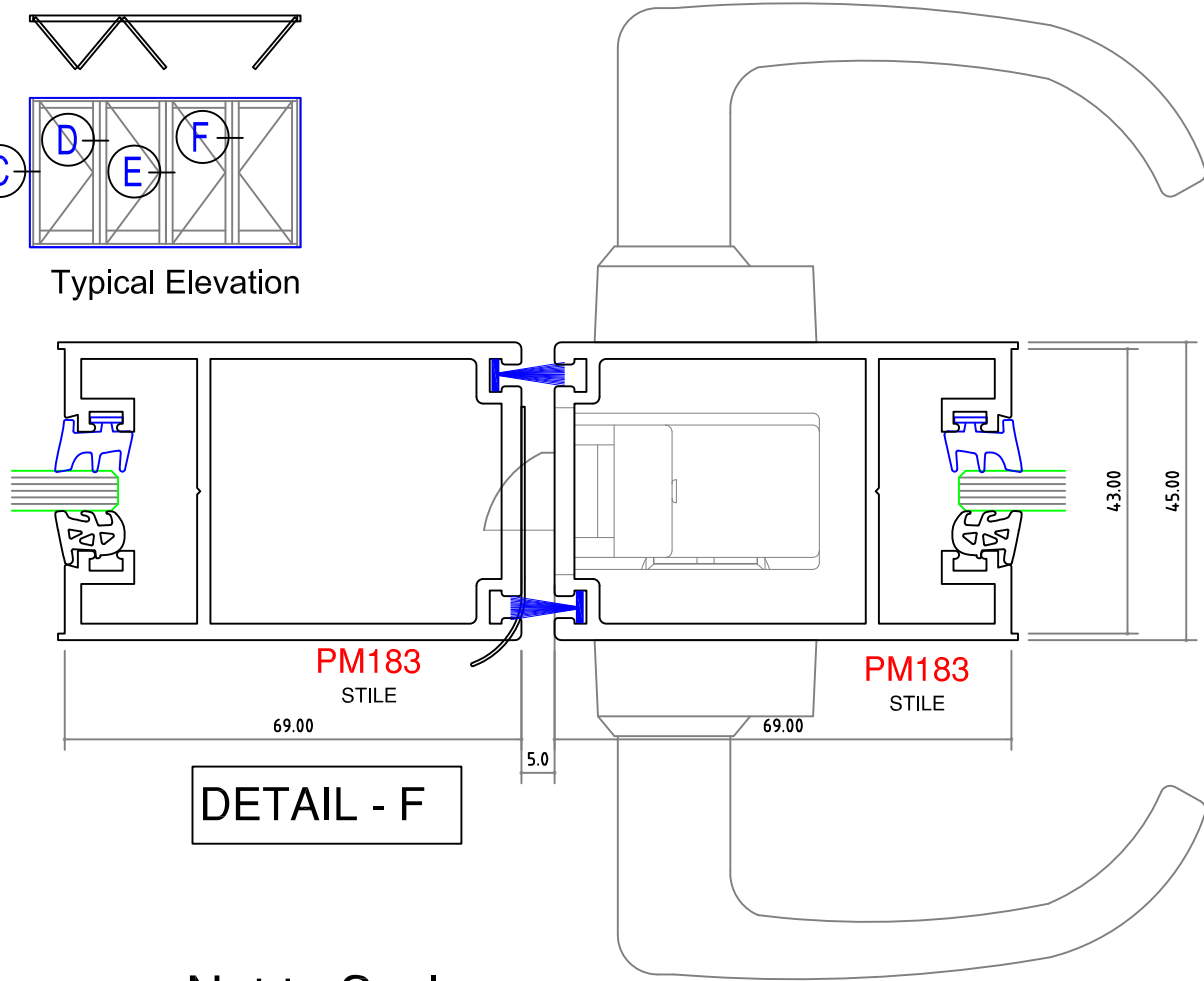
Not to Scale



# LOCK STILE DETAILS "F"



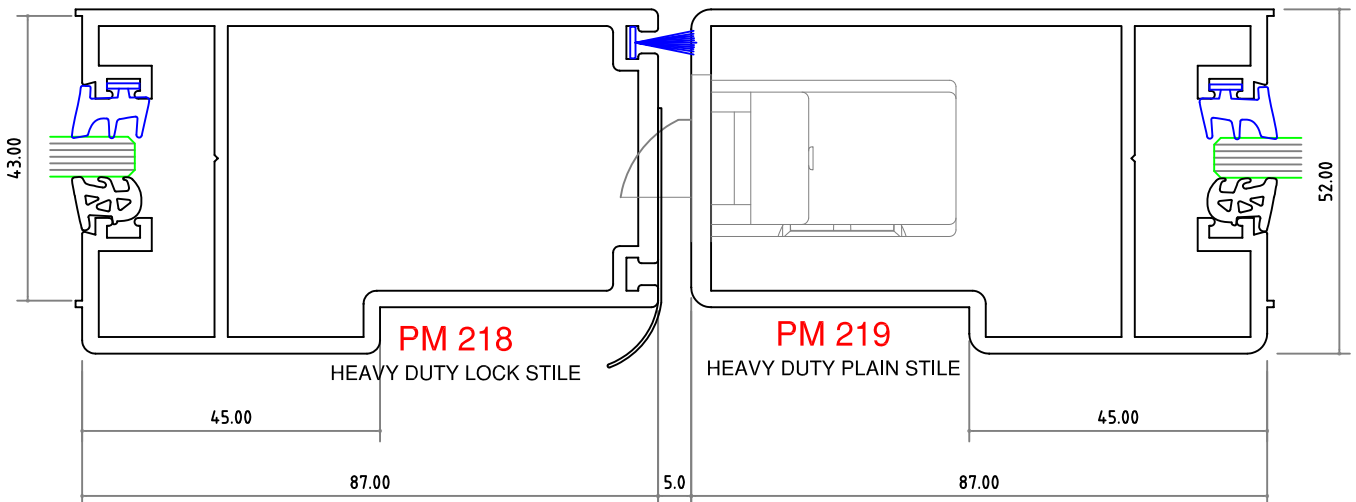
Typical Elevation



DETAIL - F

Not to Scale

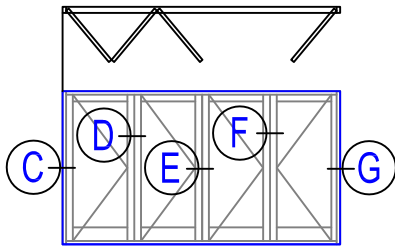
DETAIL - F1





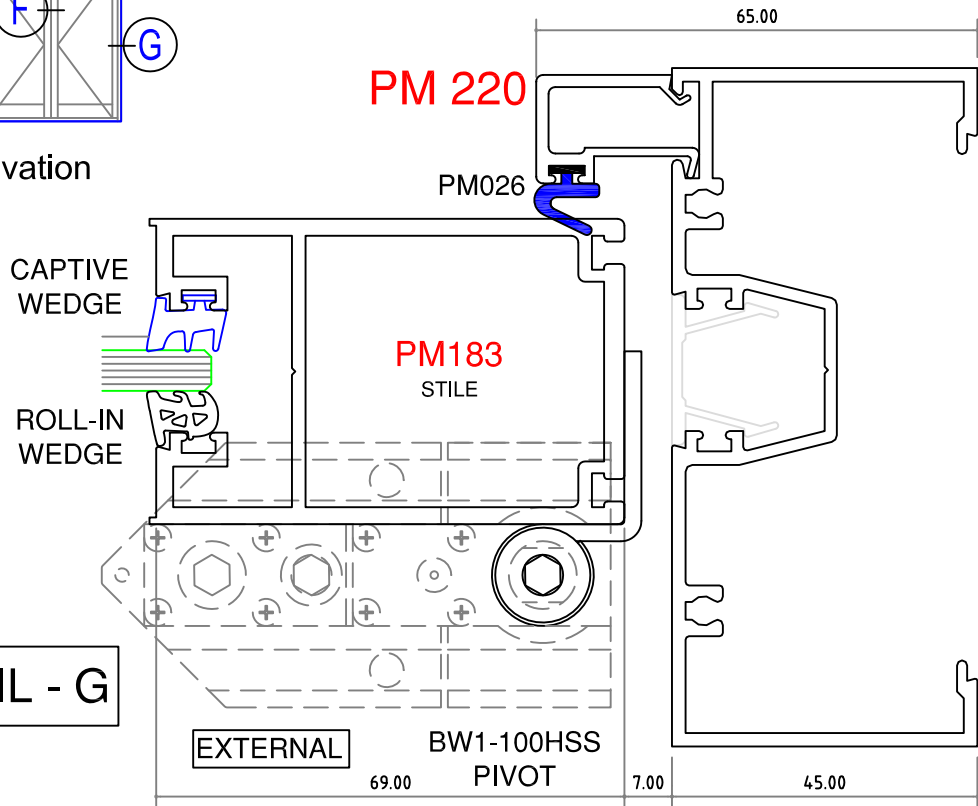
# PIVOT STILE DETAILS "G"

Not to Scale

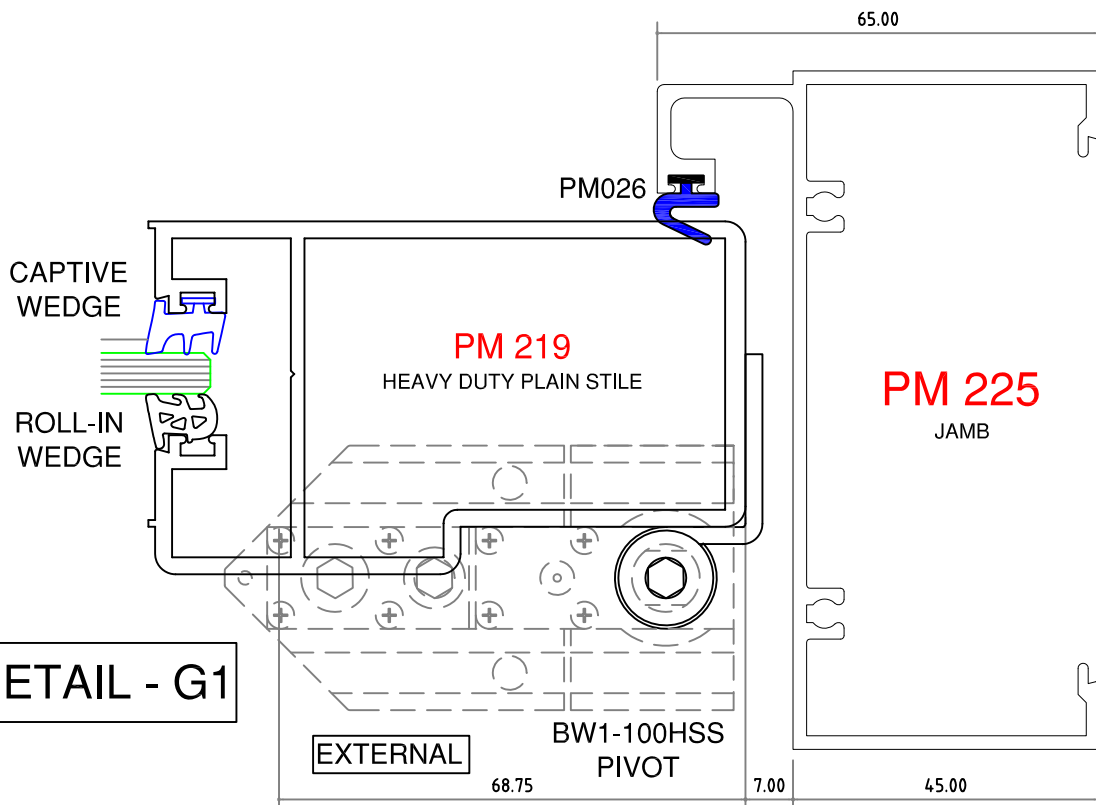


Typical Elevation

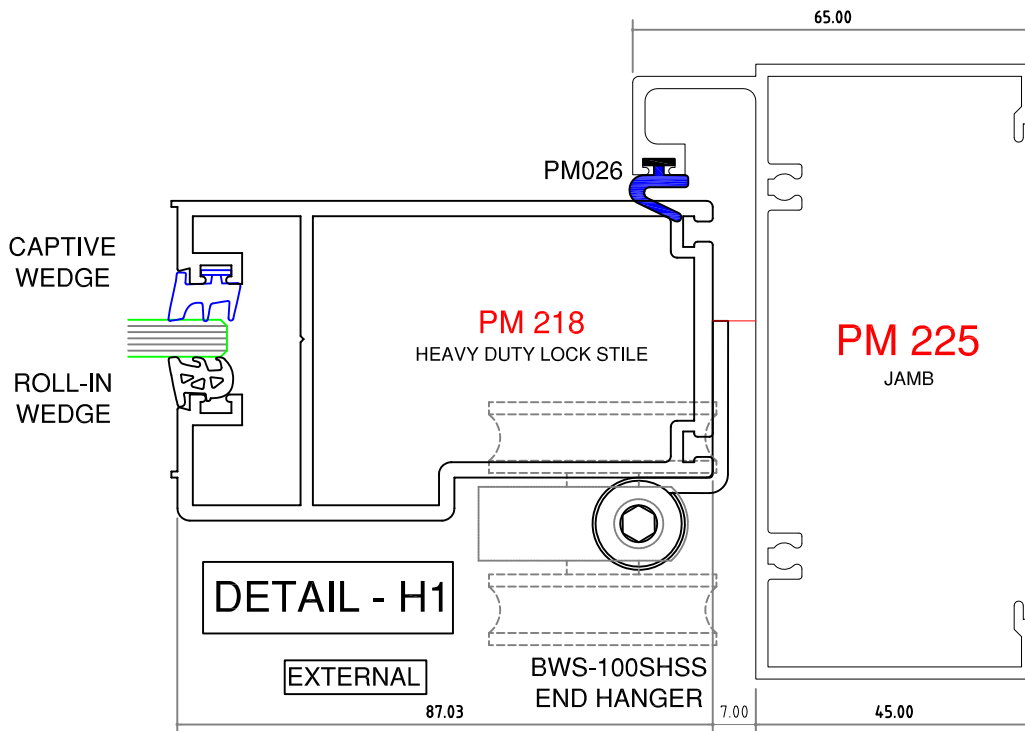
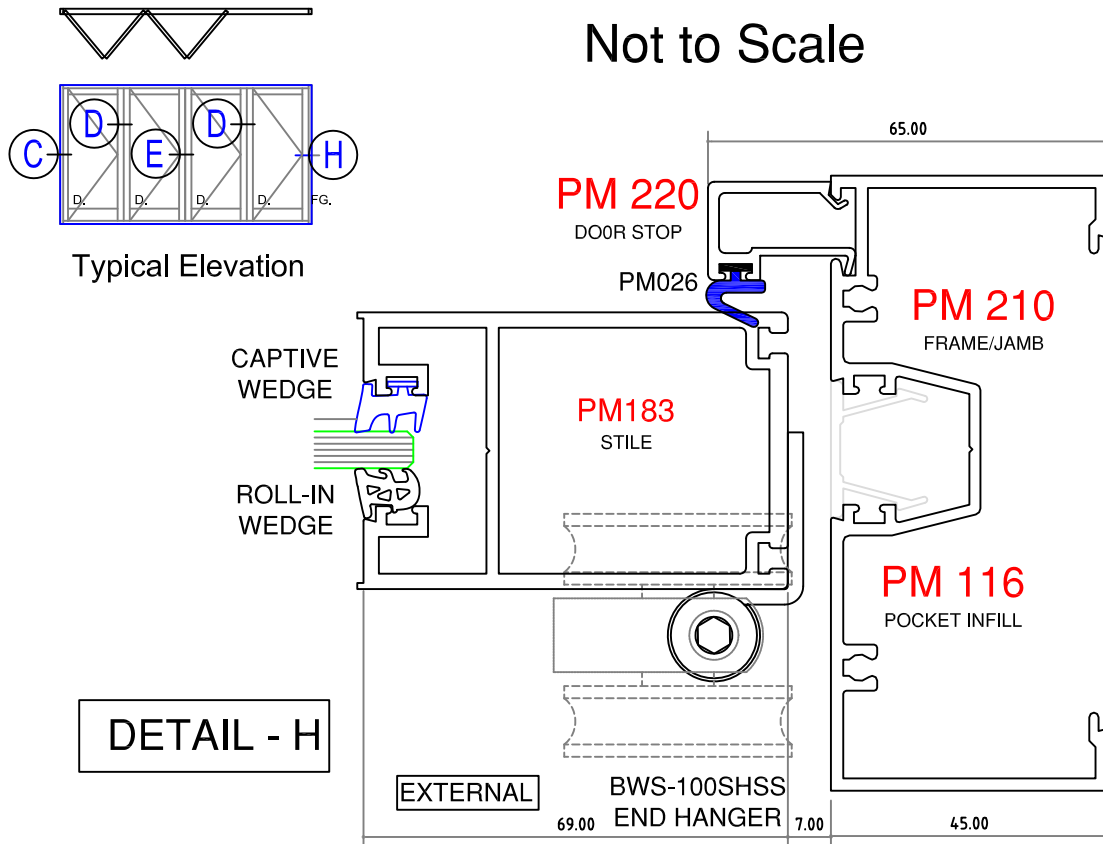
**DETAIL - G**



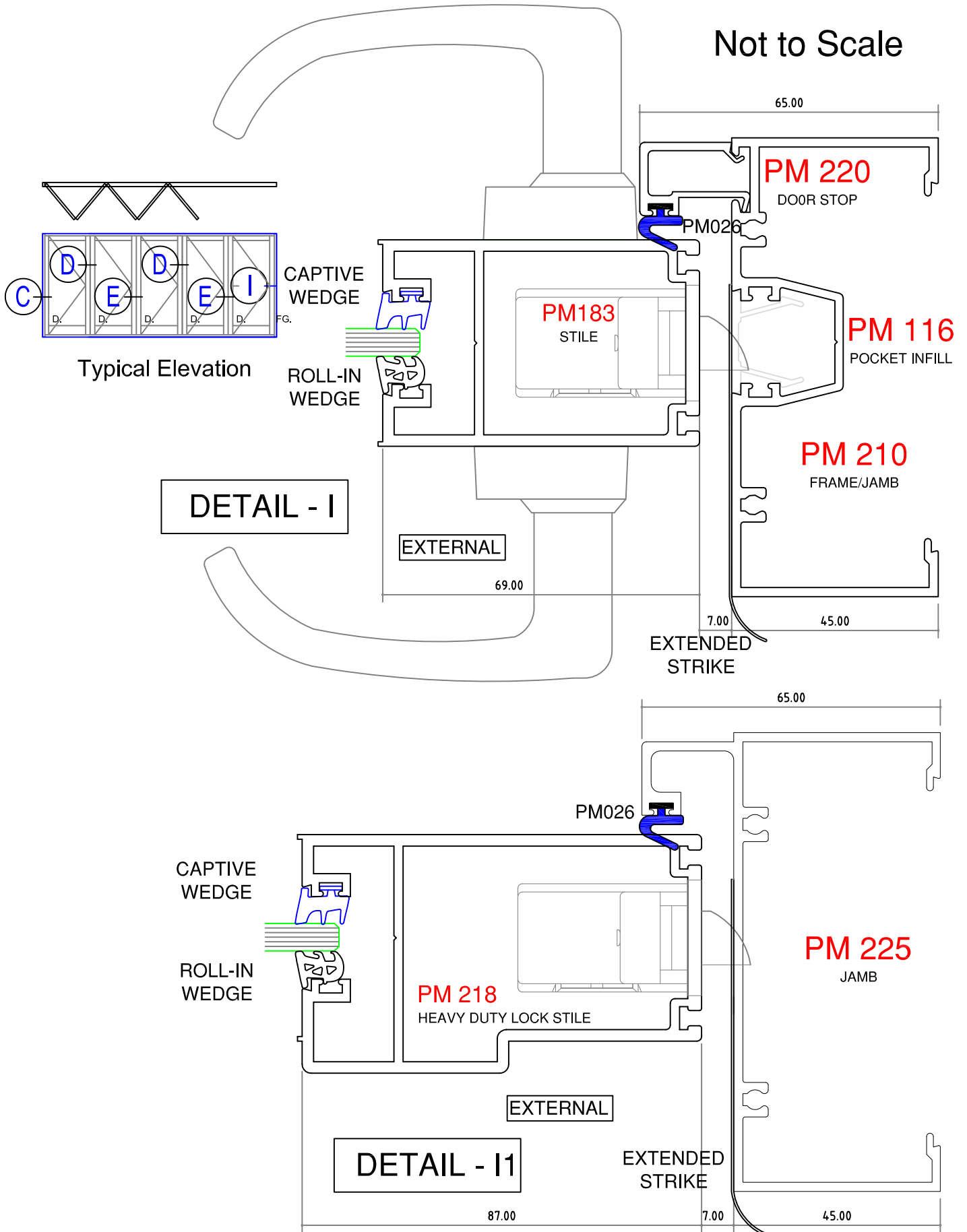
**DETAIL - G1**



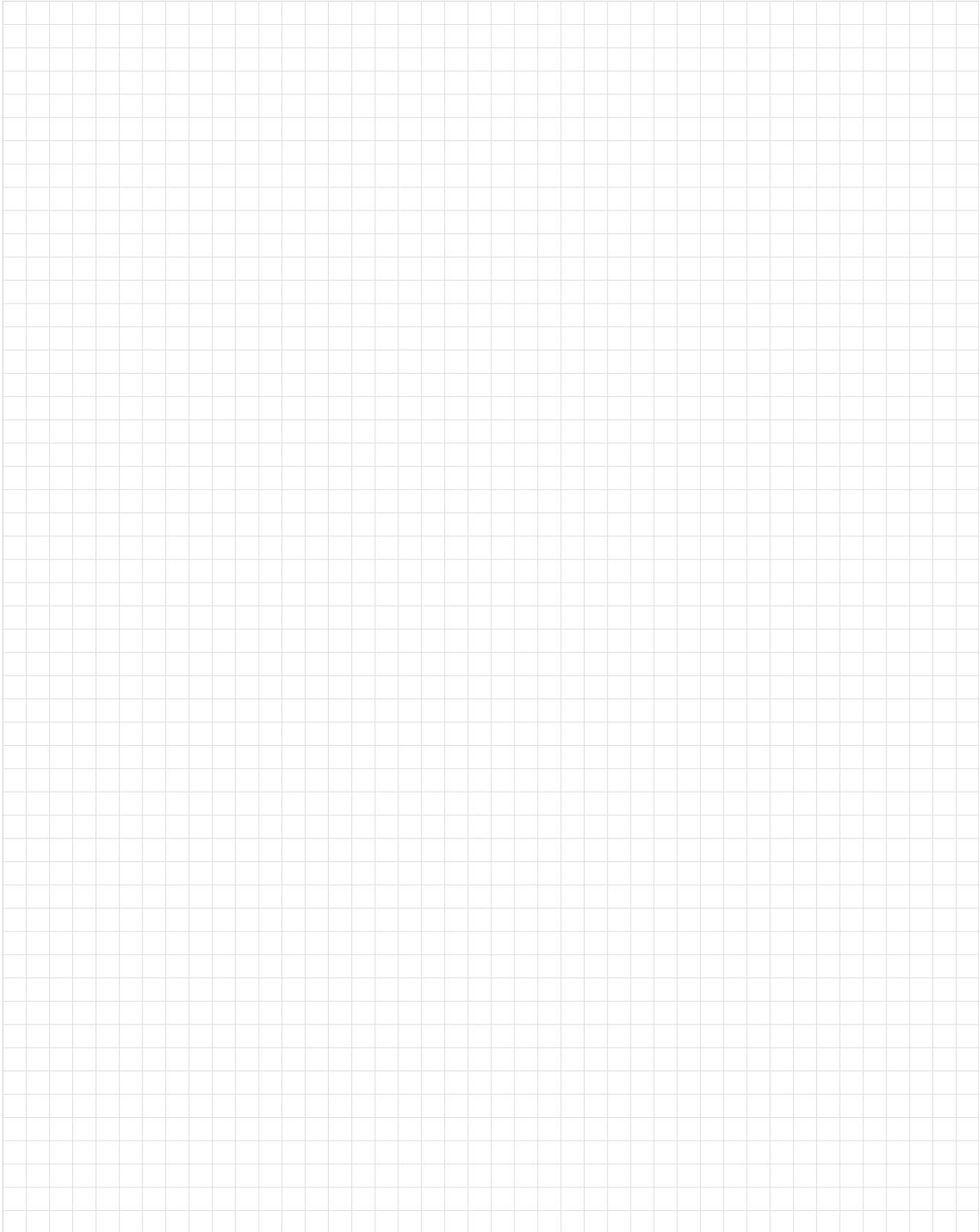
# END HANGER STILE DETAILS "H"



# LOCK STILE DETAILS "I"



**NOTES:**

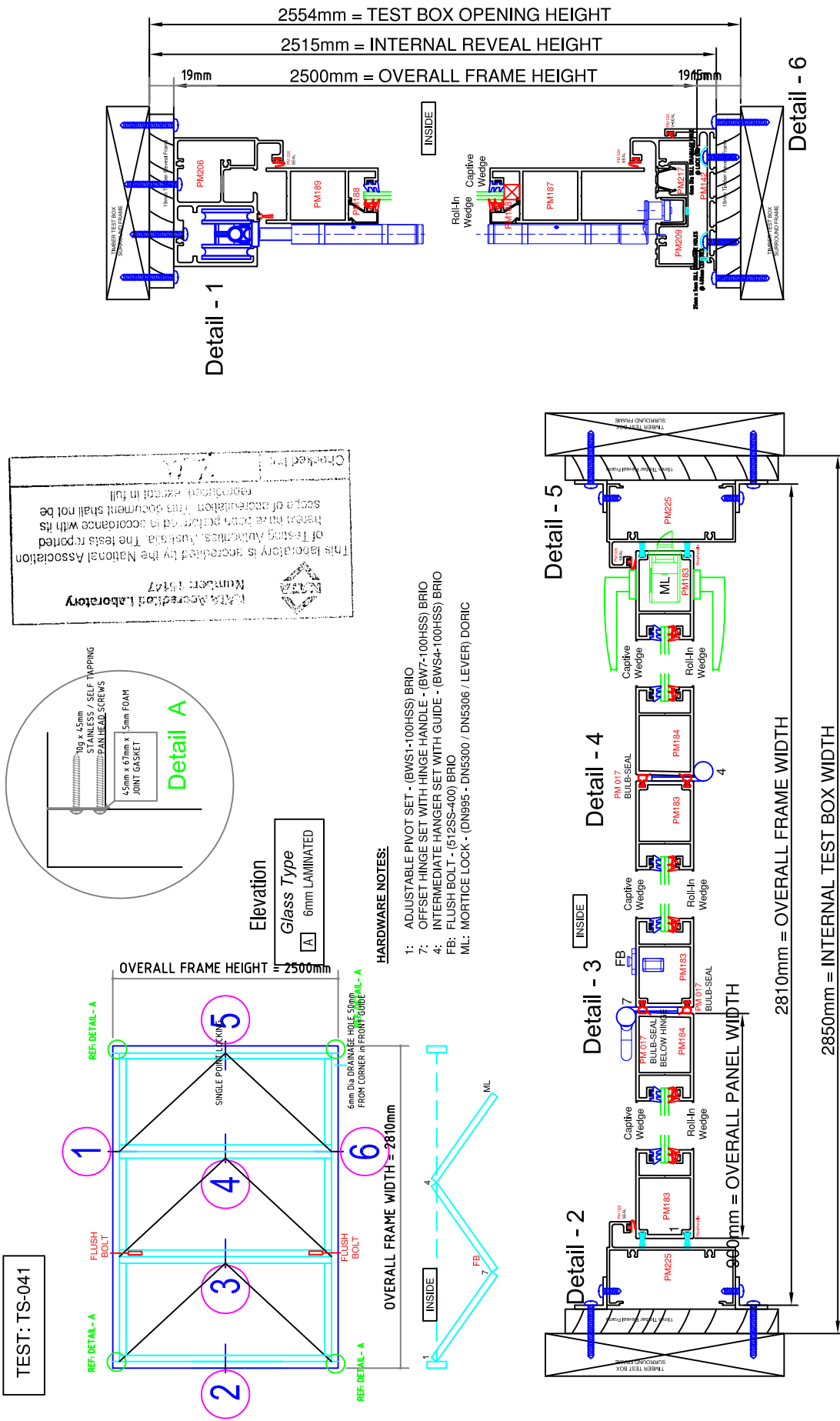


# **SECTION: C**

- ***Test Reports***
- ***Strength Charts***

**Pages: C01 to C06**

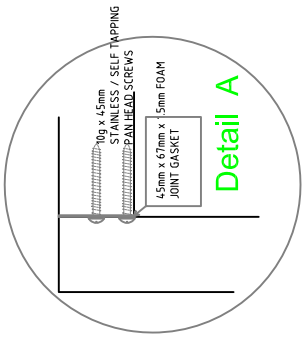




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Number: 1947

Checked by: [Signature]



<b>WINDOW TYPE:</b> 7000 SERIES - Bi-Folding Door 3 Panels L/H Opening Outwards GLAZING: 6mm Clear Laminated	<b>DATE :</b> 06-10-2016	<b>PAGE No.:</b> TS 041
	<b>TEST DOOR</b>	
<b>SCALE :</b> N.T.S. on A4		

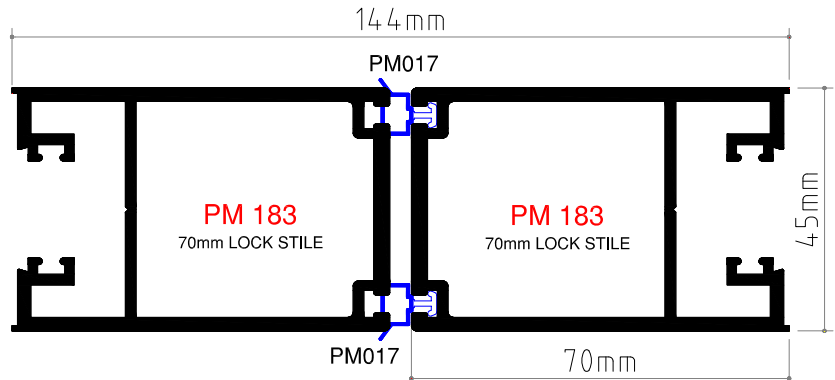
<b>7000 SERIES</b>	<b>TESTING AS 2047.1</b>	AS 1288
	<b>SERVICE ABILITY LOAD</b>	1/250
	<b>WATER PENETRATION</b>	150 Pa
	<b>POSITIVE TEST PRESSURE</b>	800 Pa
	<b>NEGATIVE TEST PRESSURE</b>	800 Pa
<b>ULTIMATE STRENGTH</b>	2000 Pa	
<b>AIR INFILTRATION</b>	75 Pa	

<b>AZUMA DESIGN LAB REPORT NUMBER:</b> AZT0330.16
--

## 7000 SERIES - BI-FOLD DOOR

<b>70mm LOCK STILE</b>
<b>PM183</b>
$I_{yy} = 204.99 \times 10^3 \text{ mm}^4$
$x \text{ max} = 22.5$
Moment of Inertia = $409.98 \times 10^3 \text{ mm}^4$
Max Depth of Section from N Axis = 22.5mm
E - Modulus = 69 Gpa
Ultimate Stress = 110 Mpa
Z Section Modules = 18.2
Panel Width Increments: 100mm
Door Height Increments: 100mm



		SERVICABILITY 1/250	ULTIMATE U	LIMITATIONS: Servicability to 5000Pa & Ultimate to 8000Pa						
W = Panel Width (mm) (W)										
Door Height (mm) (H)	Servicability	700	800	900	1000	1100	1200	1300	1400	1500
2100	250	1381	1244	1080	1002	941	891	825	793	768
	U	5394	4776	4303	3933	3638	3400	3207	3049	2921
2200	250	1190	1070	928	860	805	761	725	675	651
	U	4898	4332	3899	3558	3286	3065	2884	2736	2614
2300	250	1033	928	847	743	694	655	623	579	558
	U	4468	3948	3549	3235	2983	2778	2610	2470	2355
2400	250	903	810	738	646	603	568	540	516	481
	U	4093	3614	3245	2955	2721	2531	2374	2243	2134
2500	250	793	711	647	597	528	496	470	449	431
	U	3763	3320	2979	2710	2493	2316	2169	2046	1944
2600	250	701	627	570	526	464	436	413	393	377
	U	3472	3062	2745	2495	2293	2128	1990	1876	1779
2700	250	622	556	505	465	410	385	364	346	332
	U	3214	2832	2538	2305	2117	1962	1834	1726	1635
2800	250	555	496	450	414	384	342	323	307	293
	U	2984	2628	2354	2136	1960	1816	1695	1594	1508
2900	250	497	444	402	370	343	305	287	273	261
	U	2778	2445	2189	1985	1821	1685	1572	1477	1396
3000	250	447	399	361	332	308	288	257	244	233
	U	2592	2281	2041	1850	1696	1568	1462	1372	1296
3100	250	403	359	326	299	277	259	231	219	209
	U	2425	2133	1908	1729	1583	1464	1363	1279	1207
3200	250	365	325	294	270	250	234	208	197	188
	U	2273	1999	1787	1619	1482	1369	1275	1195	1126
3300	250	332	295	267	245	226	211	199	178	170
	U	2136	1877	1678	1519	1390	1284	1194	1119	1054
3400	250	302	269	243	223	206	192	181	162	154
	U	2010	1766	1578	1428	1307	1206	1122	1050	989
3500	250	296	246	222	203	188	175	164	155	140
	U	1895	1665	1487	1346	1230	1135	1055	988	930
3600	250	271	225	203	186	172	160	150	142	128
	U	1790	1572	1404	1270	1161	1071	995	931	875
3700	250	249	206	186	170	157	146	137	130	117
	U	1693	1487	1328	1201	1097	1012	940	879	826
3800	250	229	190	171	157	145	135	126	119	113
	U	1604	1409	1257	1137	1038	957	889	831	781
3900	250	211	175	158	144	133	124	116	109	104
	U	1522	1337	1193	1078	984	907	842	787	739
4000	250	195	173	146	133	123	114	107	101	96
	U	1446	1270	1133	1023	935	861	799	746	701

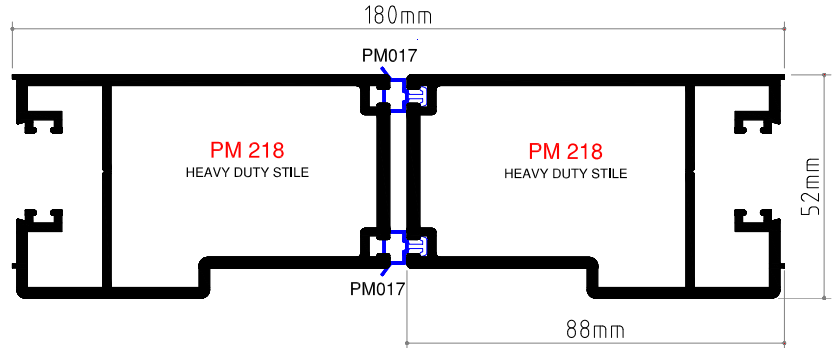
### MULLION SELECTION TABLE

C04



## 7000 SERIES - BI-FOLD DOOR

<b>87mm HD LOCK STILE</b>
<b>PM218</b>
$I_{yy} = 305.71 \times 10^3 \text{ mm}^4$
$x \text{ max} = 27.1$
Moment of Inertia = $611.42 \times 10^3 \text{ mm}^4$
Max Depth of Section from N Axis = 27.1mm
E - Modulus = 69 Gpa
Ultimate Stress = 110 Mpa
Z Section Modules = 22.6
Panel Width Increments: 100mm
Door Height Increments: 100mm



		SERVICABILITY 1/250	ULTIMATE U		LIMITATIONS: Servicability to 5000Pa & Ultimate to 8000Pa					
W = Panel Width (mm) (W)										
Door Height (mm) (H)	Servicability	700	800	900	1000	1100	1200	1300	1400	1500
2100	250	2060	1855	1611	1495	1403	1329	1230	1183	1145
	U	6679	5914	5329	4870	4505	4210	3970	3775	3616
2200	250	1775	1596	1384	1282	1201	1135	1081	1006	972
	U	6065	5364	4827	4406	4068	3795	3571	3387	3236
2300	250	1541	1384	1263	1108	1036	977	929	863	832
	U	5532	4889	4394	4006	3694	3440	3231	3059	2915
2400	250	1346	1207	1101	964	900	848	805	769	717
	U	5068	4474	4018	3659	3370	3134	2939	2777	2642
2500	250	1183	1060	965	890	787	740	702	670	643
	U	4660	4111	3689	3356	3087	2867	2686	2534	2407
2600	250	1045	935	851	784	692	650	615	587	562
	U	4300	3791	3399	3089	2839	2635	2465	2322	2202
2700	250	928	829	754	694	612	574	543	517	495
	U	3980	3507	3142	2854	2621	2430	2270	2137	2024
2800	250	828	739	671	617	573	510	481	458	437
	U	3695	3254	2914	2645	2427	2248	2099	1973	1867
2900	250	741	662	600	551	512	454	429	407	389
	U	3439	3028	2710	2458	2254	2086	1946	1828	1728
3000	250	666	594	539	495	459	429	384	364	347
	U	3210	2824	2527	2291	2100	1942	1810	1699	1604
3100	250	601	536	485	445	413	386	345	327	311
	U	3002	2641	2362	2140	1960	1812	1688	1583	1494
3200	250	545	485	439	402	373	348	311	294	280
	U	2815	2475	2213	2004	1835	1695	1578	1479	1395
3300	250	495	440	398	365	338	315	297	266	253
	U	2644	2324	2077	1881	1721	1589	1479	1385	1305
3400	250	451	401	363	332	307	286	269	241	230
	U	2489	2187	1954	1768	1618	1493	1389	1300	1224
3500	250	441	366	331	303	280	261	245	232	209
	U	2347	2062	1841	1666	1524	1406	1307	1223	1151
3600	250	404	335	303	277	256	238	224	211	190
	U	2216	1947	1738	1572	1437	1326	1232	1152	1084
3700	250	371	308	278	254	235	218	205	194	174
	U	2097	1842	1644	1486	1358	1252	1163	1088	1023
3800	250	342	283	256	233	216	201	188	178	168
	U	1987	1744	1557	1407	1286	1185	1101	1029	967
3900	250	315	261	236	215	199	185	173	163	155
	U	1885	1655	1477	1335	1219	1123	1043	974	915
4000	250	291	259	218	199	183	170	160	151	143
	U	1791	1572	1402	1267	1157	1066	989	924	868

### MULLION SELECTION TABLE

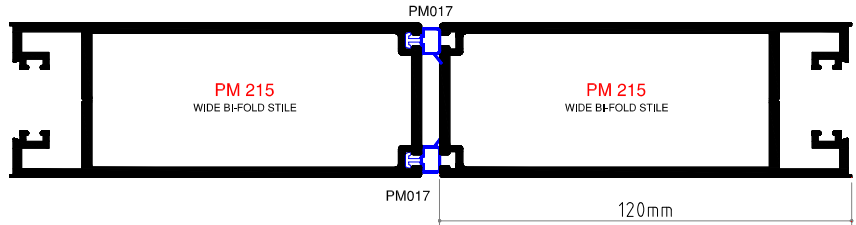
**C05**

### 7000 SERIES BI-FOLDING DOORS

**C05**

## 7000 SERIES - BI-FOLD DOOR

<b>120mm WIDE LOCK STILE</b>	
<b>PM215</b>	
$I_{yy} = 320.94 \times 10^3 \text{ mm}^4$	
$x \text{ max} = 22.5$	
Moment of Inertia = $641.88 \times 10^3 \text{ mm}^4$	
Max Depth of Section from N Axis = 22.5mm	
E - Modulus = 69 Gpa	
Ultimate Stress = 110 Mpa	
Z Section Modules = 28.5	
Panel Width Increments:	100mm
Door Height Increments:	100mm



		SERVICABILITY 1/250	ULTIMATE U		LIMITATIONS: Servicability to 5000Pa & Ultimate to 8000Pa					
W = Panel Width (mm) (W)										
Door Height (mm) (H)	Servicability	700	800	900	1000	1100	1200	1300	1400	1500
2100	250	2162	1948	1691	1569	1473	1395	1292	1242	1202
	U	8000	7478	6738	6158	5696	5323	5020	4773	4573
2200	250	1864	1676	1453	1346	1260	1192	1135	1056	1020
	U	7669	6783	6104	5571	5144	4798	4515	4283	4092
2300	250	1618	1453	1326	1163	1087	1026	976	906	873
	U	6996	6181	5557	5065	4670	4349	4086	3867	3686
2400	250	1413	1267	1156	1012	945	890	845	808	753
	U	6408	5658	5081	4626	4261	3962	3716	3511	3341
2500	250	1242	1112	1013	934	826	777	737	703	675
	U	5892	5198	4665	4243	3903	3626	3396	3204	3043
2600	250	1097	982	893	823	726	682	646	616	590
	U	5437	4793	4298	3906	3590	3331	3116	2936	2785
2700	250	974	871	791	728	642	603	570	542	519
	U	5032	4434	3974	3609	3314	3072	2871	2702	2559
2800	250	869	776	704	648	602	535	505	480	459
	U	4672	4115	3685	3344	3069	2842	2654	2495	2361
2900	250	778	694	630	579	537	477	450	427	408
	U	4349	3828	3427	3108	2850	2638	2461	2312	2185
3000	250	700	624	566	519	482	451	403	382	365
	U	4059	3571	3195	2897	2655	2455	2289	2148	2029
3100	250	631	563	510	467	433	405	362	343	327
	U	3796	3340	2987	2706	2479	2291	2135	2002	1889
3200	250	572	509	461	422	391	366	326	309	294
	U	3559	3130	2798	2534	2320	2143	1996	1871	1764
3300	250	519	462	418	383	355	331	311	279	266
	U	3343	2939	2627	2378	2176	2010	1870	1752	1651
3400	250	473	421	381	348	322	301	283	253	241
	U	3147	2766	2471	2236	2046	1888	1756	1644	1548
3500	250	463	384	347	318	294	274	257	243	219
	U	2967	2607	2328	2107	1926	1777	1652	1546	1455
3600	250	424	352	318	291	269	250	235	222	200
	U	2803	2462	2198	1988	1818	1676	1558	1457	1371
3700	250	390	323	292	267	246	229	215	203	183
	U	2651	2329	2079	1880	1718	1584	1471	1375	1293
3800	250	359	297	268	245	226	211	198	186	177
	U	2512	2206	1969	1780	1626	1499	1392	1301	1223
3900	250	331	274	247	226	208	194	182	171	163
	U	2384	2093	1867	1688	1541	1420	1318	1232	1157
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	U	2265	1988	1773	1602	1463	1348	1251	1168	1097

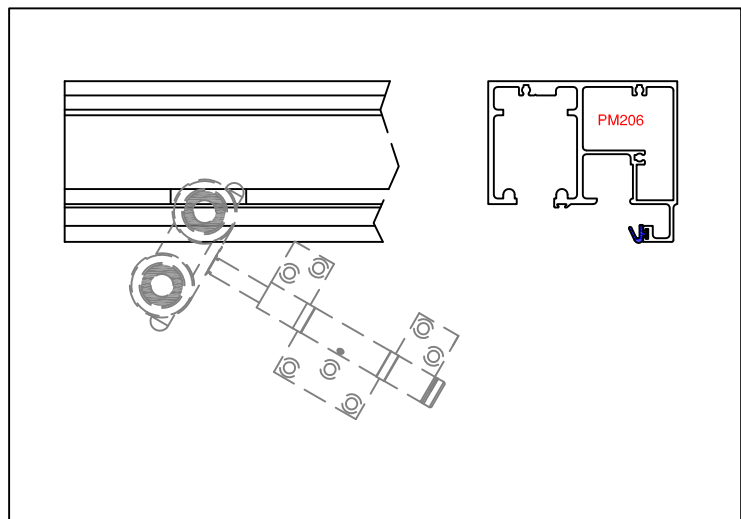
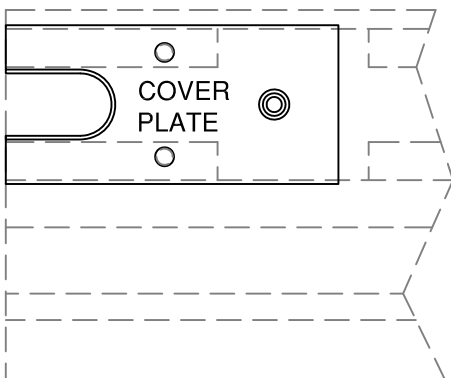
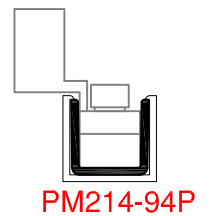
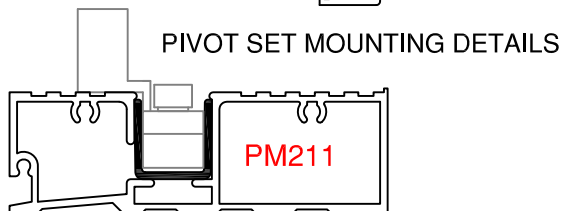
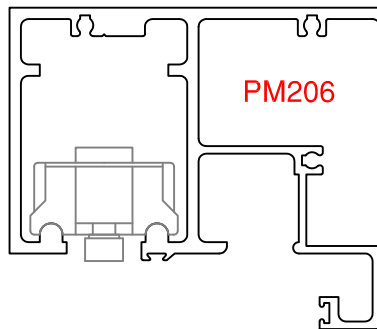
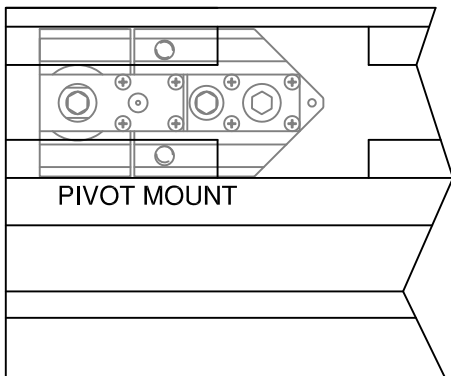
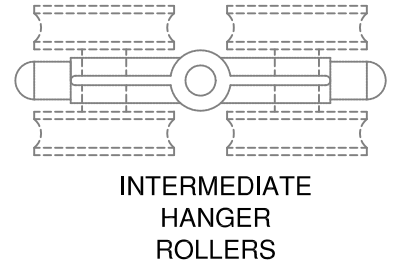
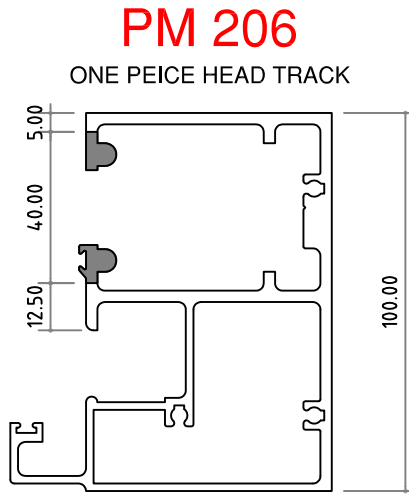
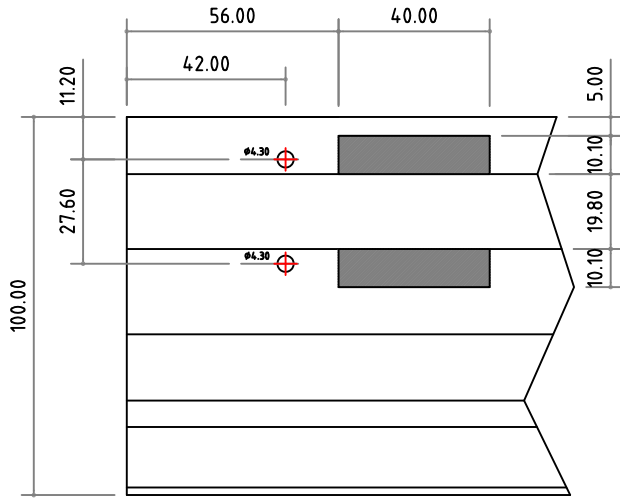
### MULLION SELECTION TABLE

# **SECTION: D**

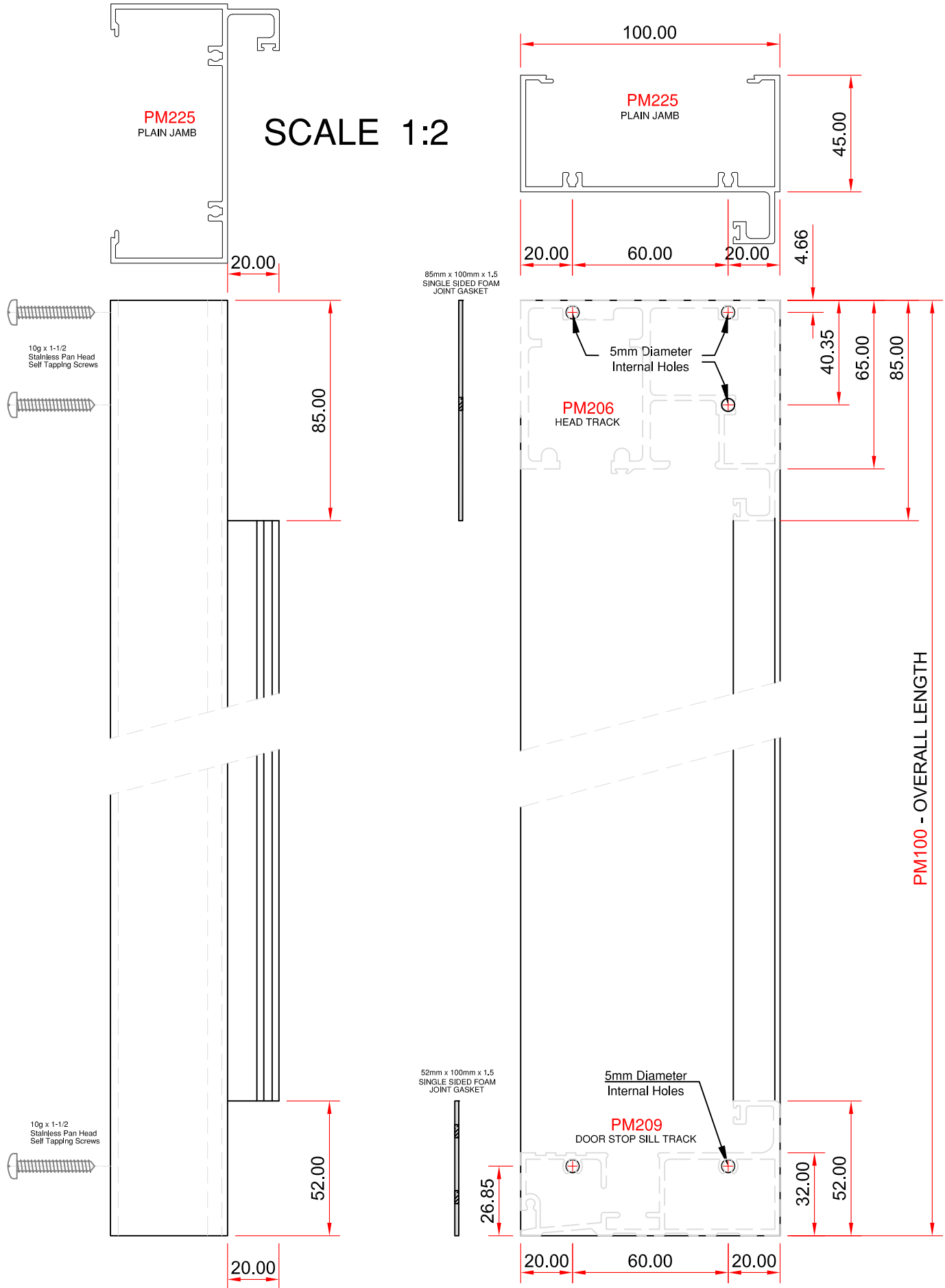
- ***Machining and Fabrication Details***

**Pages: D01 to D09**

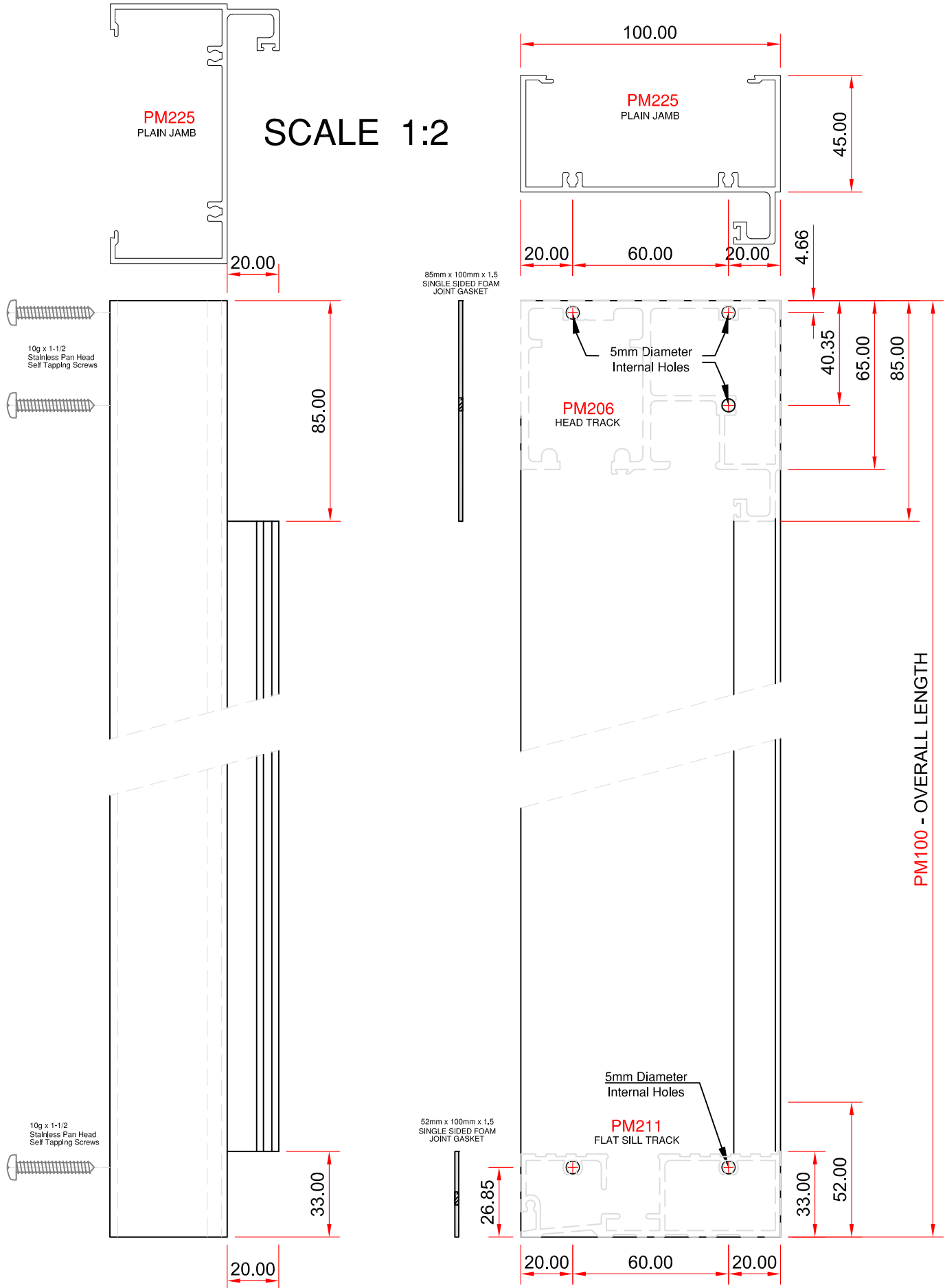
SCALE 1:2



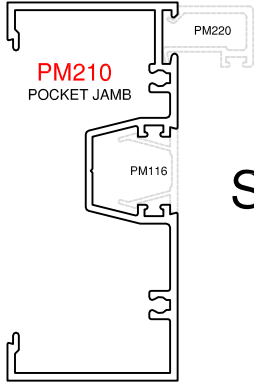
# PM225 JAMB MACHINING DETAILS TO SUIT PM208 HEAD & PM213 SILL TRACKS



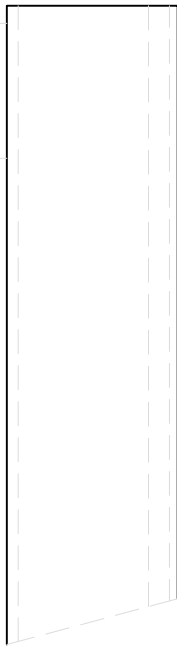
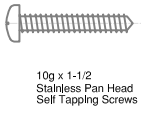
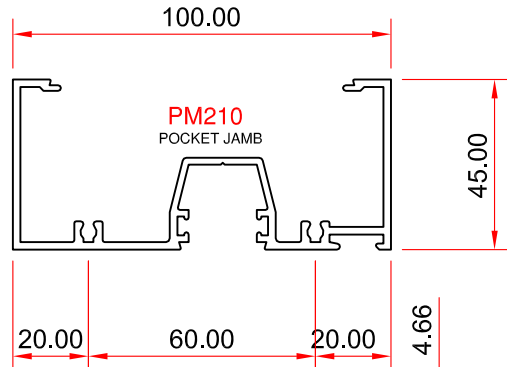
# PM225 JAMB MACHINING DETAILS TO SUIT PM208 HEAD & PM216 SILL TRACKS



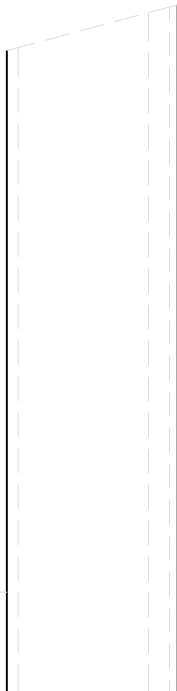
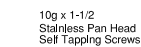
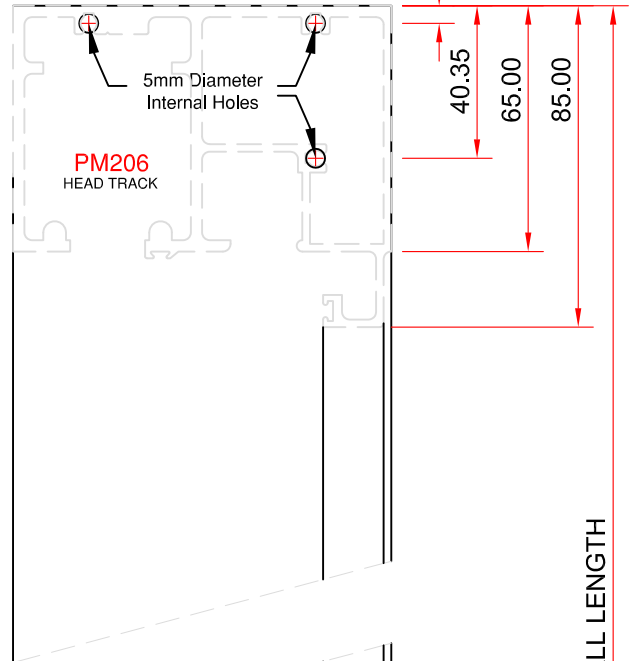
# PM210 JAMB MACHINING DETAILS TO SUIT PM208 HEAD & PM213 SILL TRACKS



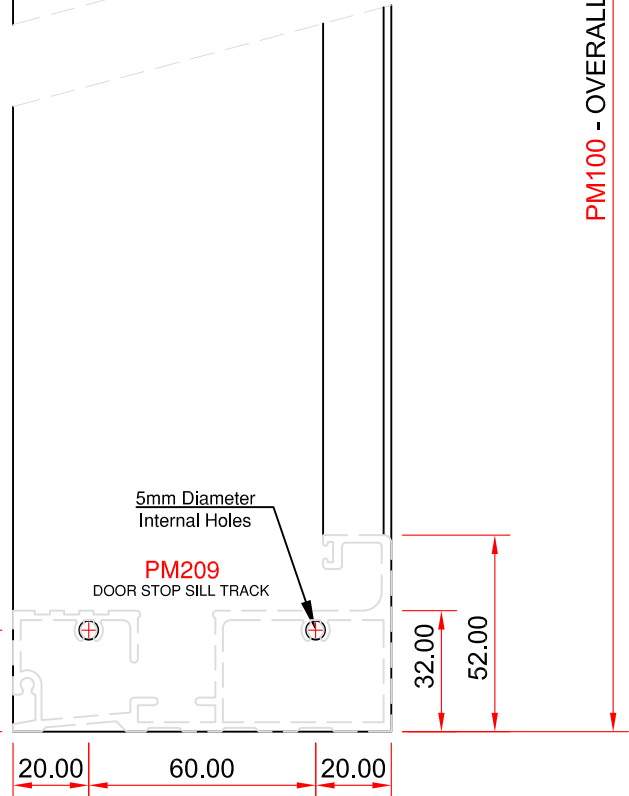
SCALE 1:2



85mm x 100mm x 1.5  
SINGLE SIDED FOAM  
JOINT GASKET

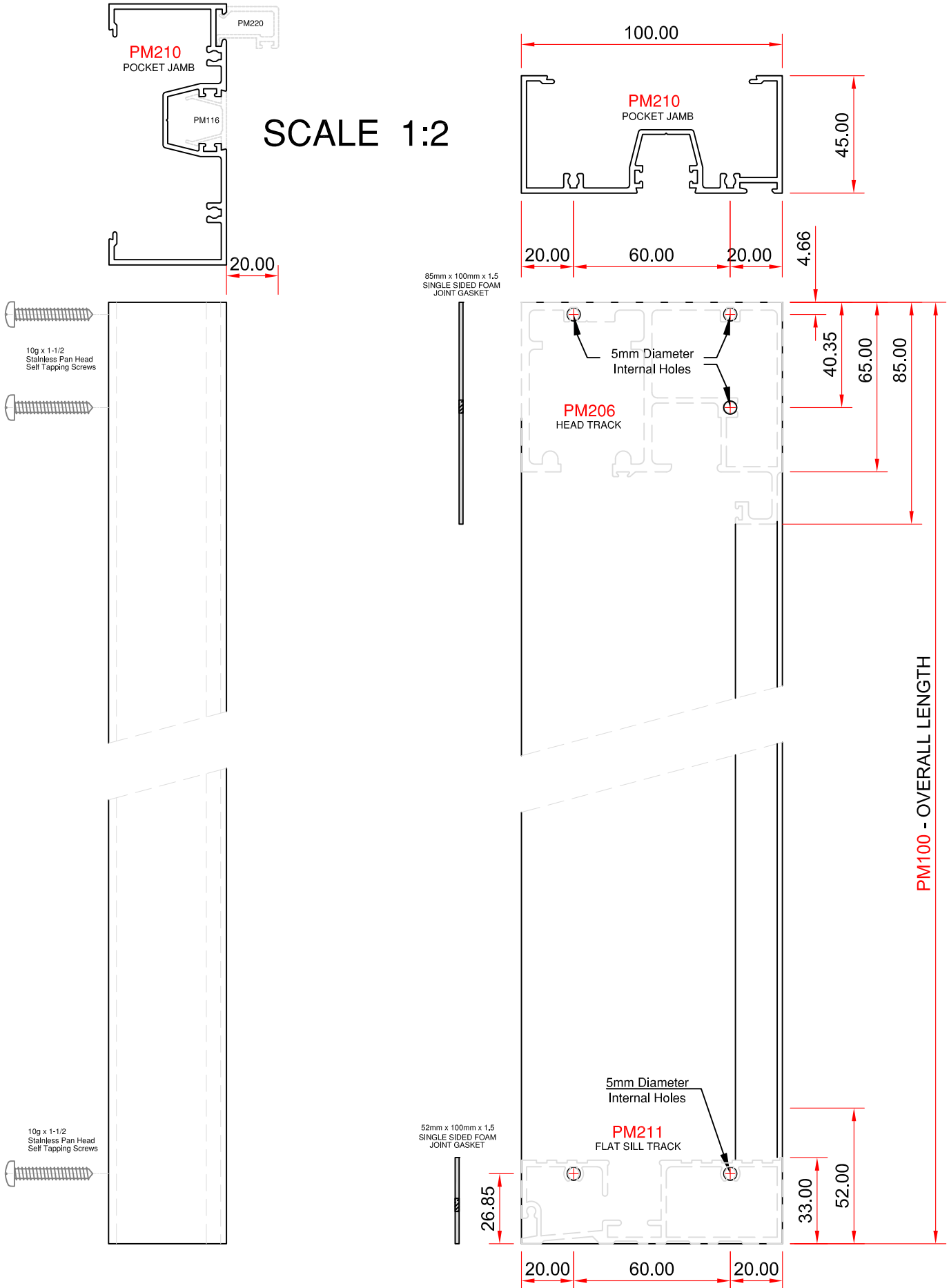


52mm x 100mm x 1.5  
SINGLE SIDED FOAM  
JOINT GASKET



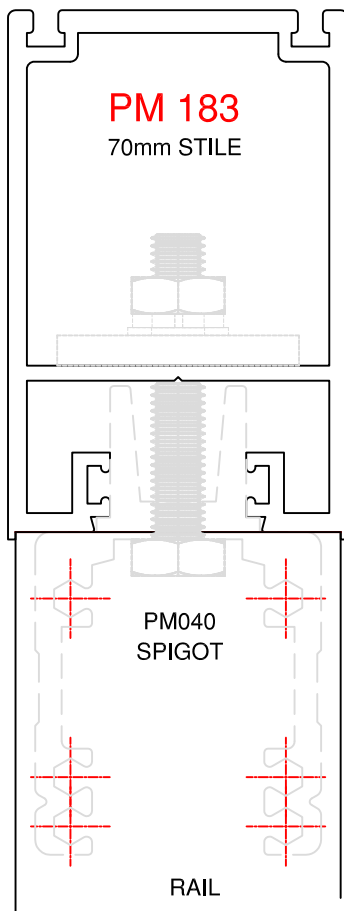
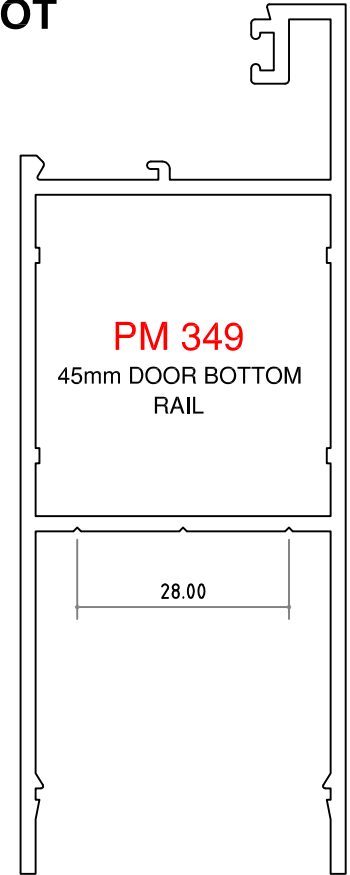
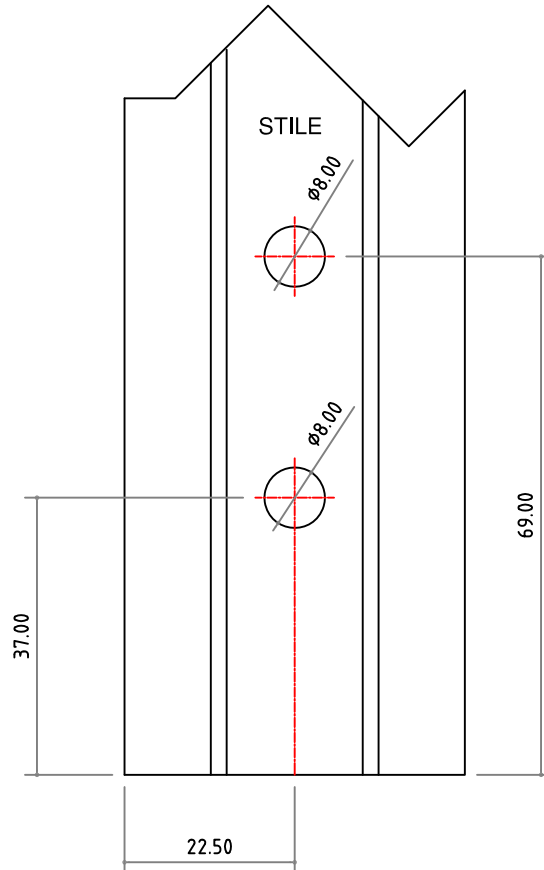
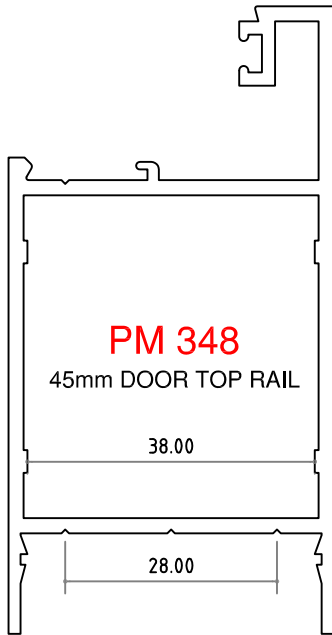
PM100 - OVERALL LENGTH

# PM210 JAMB MACHINING DETAILS TO SUIT PM208 HEAD & PM213 SILL TRACKS

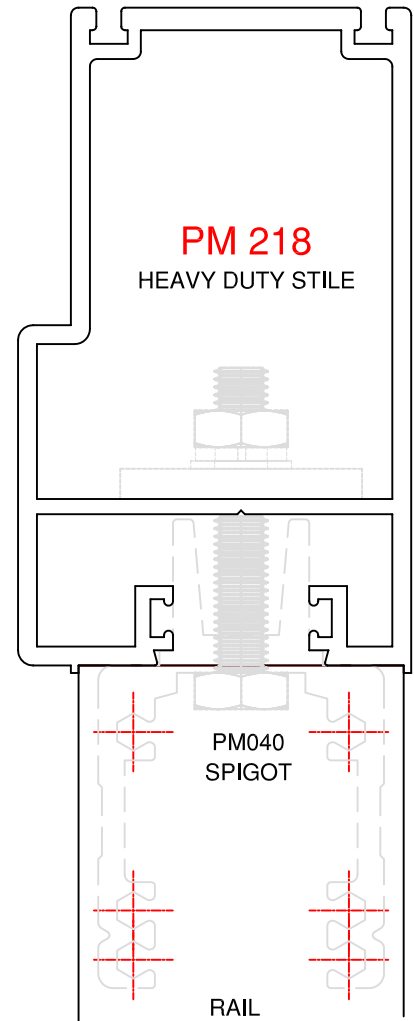
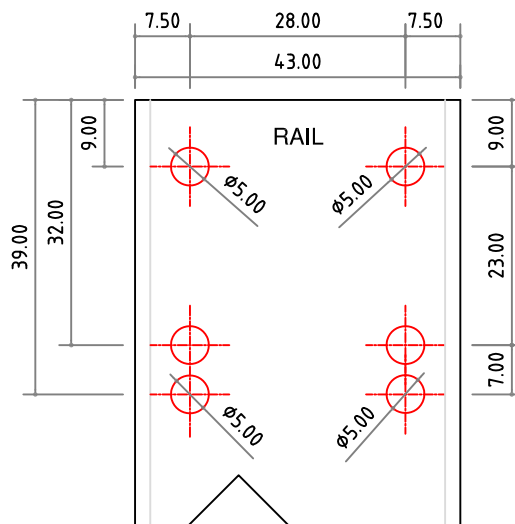




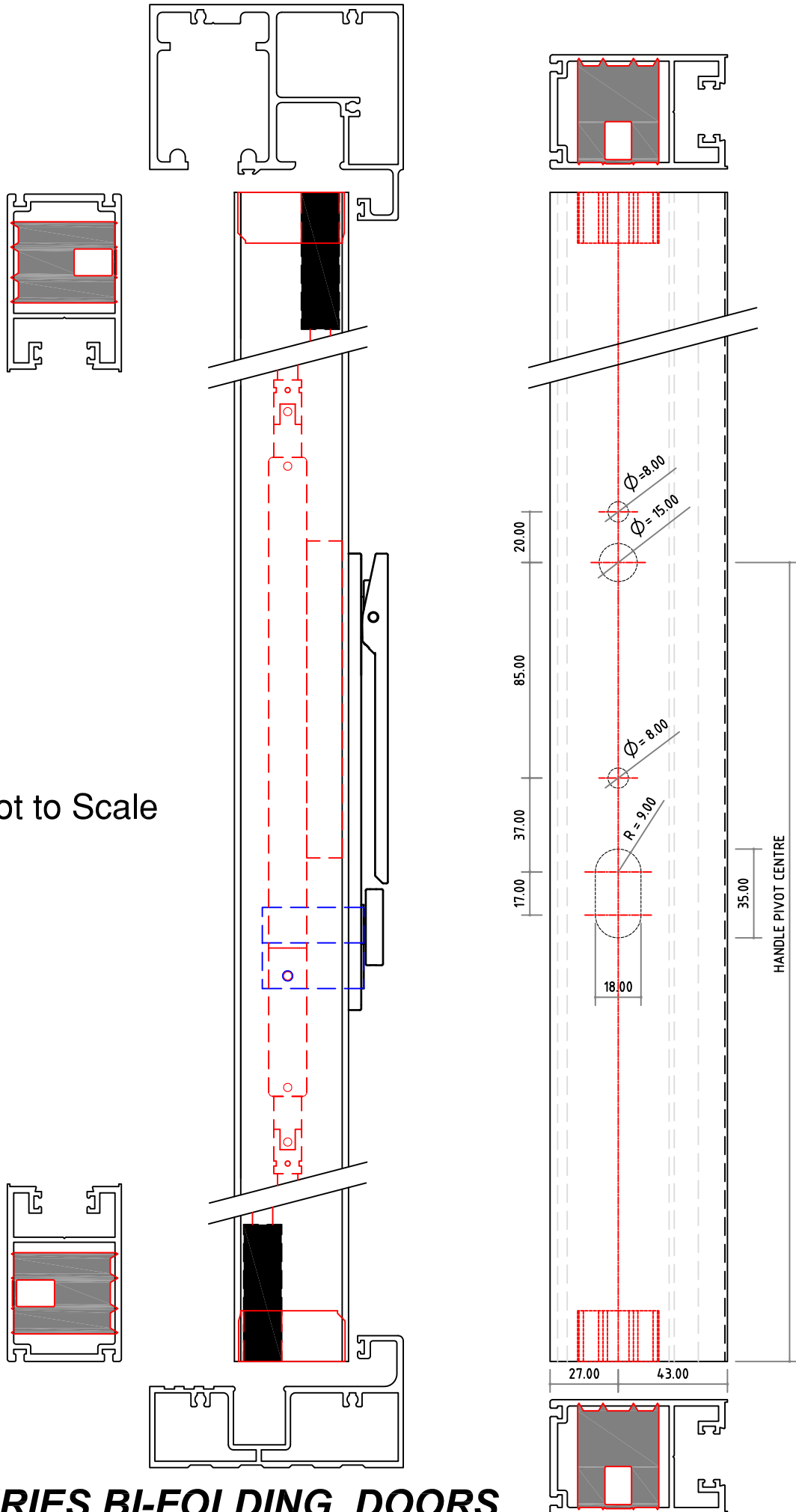
# STILE & RAIL MACHINING DETAILS TO SUIT PM040 SPIGOT



SCALE 1:1

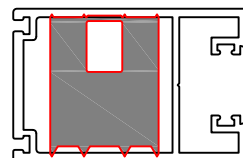
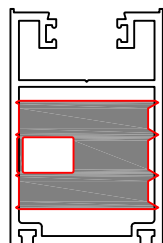
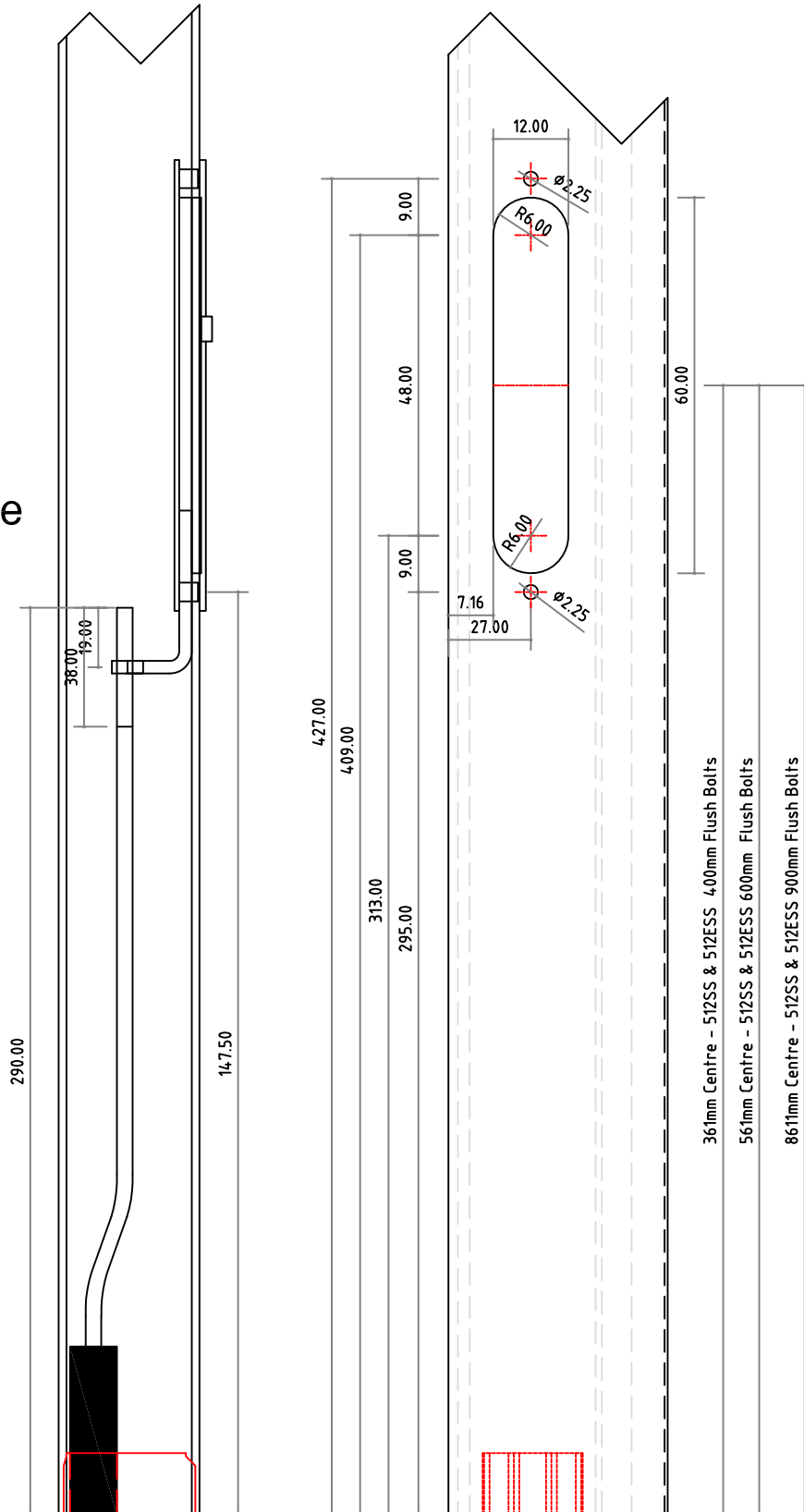


# BRIO 286 DUAL POINT LOCK MACHINING DETAILS



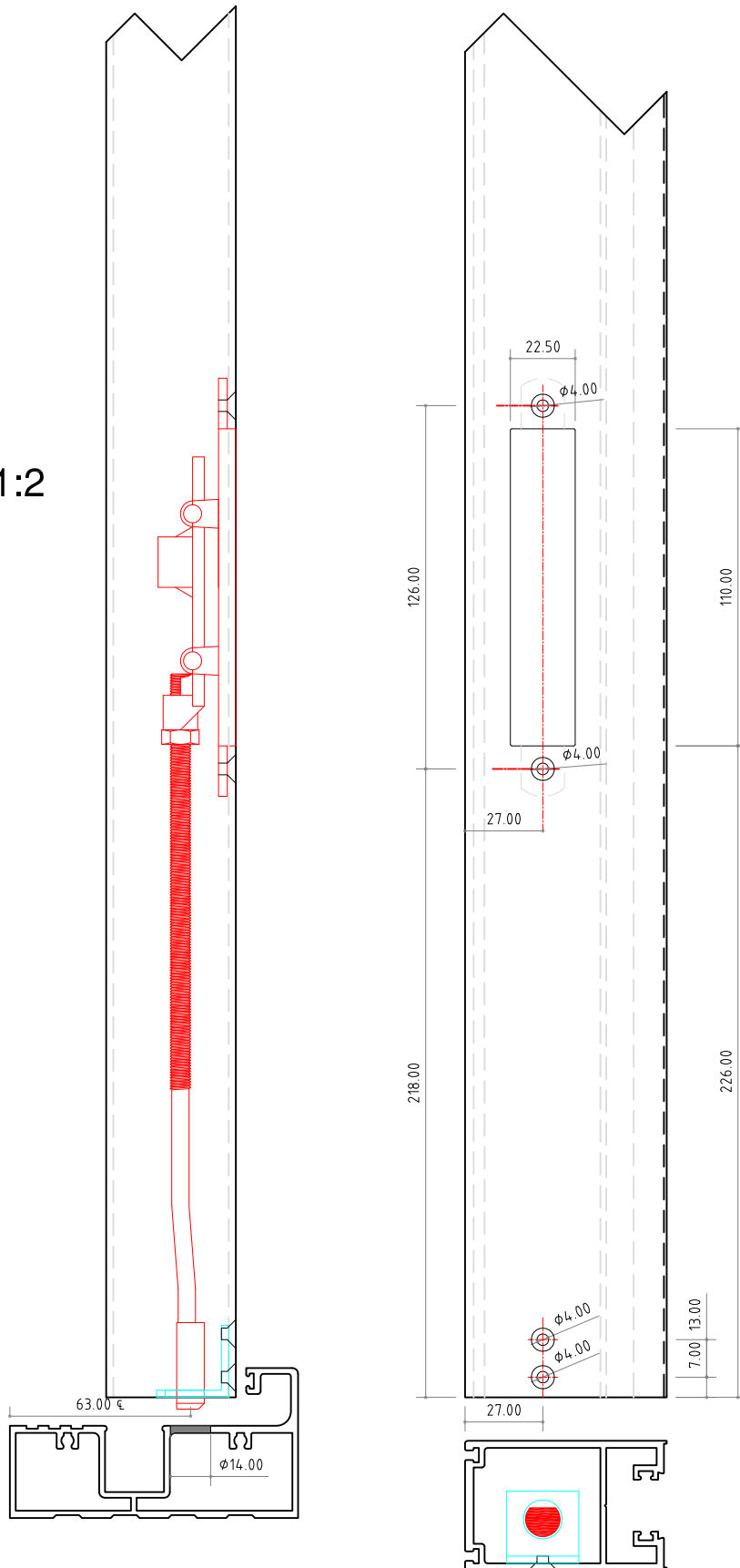
# BRIO 512 FLUSH BOLT MACHINING DETAILS

Not to Scale



# PM069 - DN201 FLUSH BOLT DN218 ANGLE BRACKET AND PROFILE OFFSET ROD. MACHINING DETAILS

SCALE 1:2





**PRESS METAL**

Press Metal Aluminium (Australia) Pty Limited  
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NOTES: