



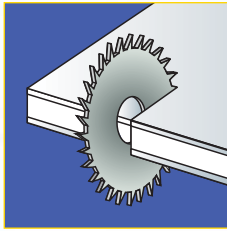
Specifications

| | Standard | Unit | Value |
|---|-----------------------|-------------------|-----------|
| Thickness | | mm | 3 |
| Alloy | | EN AW | 1100 |
| Status | | | H18 |
| Length tolerance | DIN 16927/ISO 11833-1 | mm | -0/+2 |
| Breadth tolerance | DIN 16927/ISO 11833-1 | mm | -0/+2 |
| Thickness tolerance | DIN 16927/ISO 11833-1 | mm | ±0,1 |
| Diagonal deviation | | mm | 3 |
| Weight | | kg/m ² | 4.20 |
| PE | | g/cm ³ | 0.92 |
| Coefficient linear thermal (from -50°C to +80°C) | | mm/mK | 0.024 |
| Fire Behaviour | DIN 4102 | | B2 |
| Thickness of the Topcoat and Backcoat | | µm | 20±2 |
| Material Topcoat and Backcoat | | | Polyester |
| Degree of gloss (Measurement angle 60°) | | | 20-40±10 |

Transport and Storage

- The sheets should be handled and treated with care when transporting and unloading
- Pallets should be checked on delivery for damage incurred during transport and for dampness, (to avoid stains, any damp sheets should be dried immediately)
- The recipient should have any damage found on delivery confirmed by the freight agent and report such findings to the supplier immediately
- Pallets should be stored in such a way that they are protected from rain, snow, and splashing water, all manner of penetrating dampness and condensation should be avoided (e.g. when moving cold sheets into a warmer environment)
- Pallets should be stacked horizontally one on top of the other (i.e. no vertical storage)
- Heavier sheets should be stored at the bottom of a stack and lighter sheets at the top
- No more than maximum six pallets should be stacked on top of one another
- When lifting single sheets off the pallet at least two men should hold the sheets at all four corners
- Sheets should not be pulled on top of one another, sheets should be carried vertically
- To avoid stains workers should wear gloves

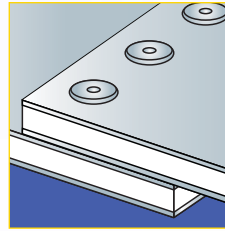




Cutting to shape

Sawing

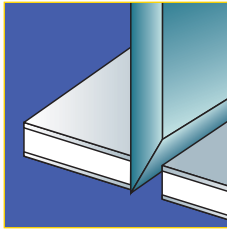
with a vertical panel saw, circular saw, jig-saw, or band saw



Riveting

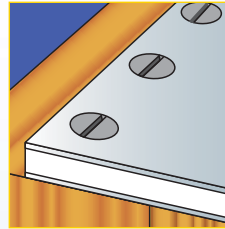
with conventional equipment and rivets or blind rivets, for outdoor application, allow for hole play (thermal expansion of the sheet)

work with a rivet gauge



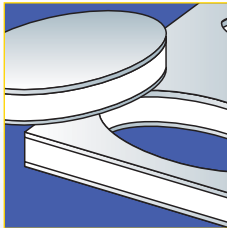
Cutting

with guillotine shears, (this lightly tugs on the top outer sheet), cushion the hold-down device



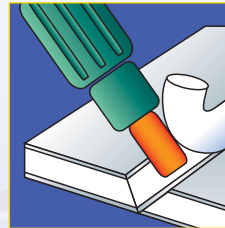
Screwing

with any standard non-rusting timber screws, self-tapping screws, or metal screws, for exterior use, with facing screws suitable for thermal expansion



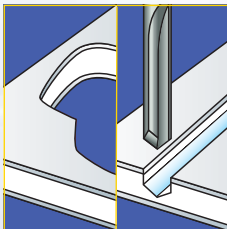
Punching

with a strip-steel cutter on a stamping die (suitable for 2 to 3 mm sheets), (this lightly tugs on the top outer sheet), with a plate punching machine, manually or hydraulically operated (for all sheet thicknesses)



Welding

welding the polyethylene core material - with a hot-air welding gun and polyethylene seam

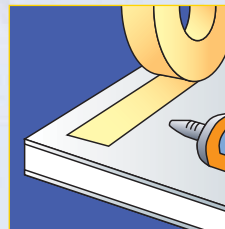


Cutting off

with a jig-saw or scroll saw, with a water-jet cutter

Milling

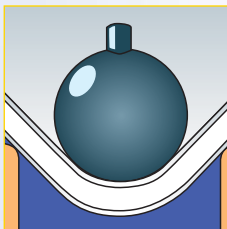
can be easily worked using conventional machines and CNC machining centres



Adhesive bonding

with any standard metal adhesive suitable for aluminum (no adhesion to the end-on plastic edges),

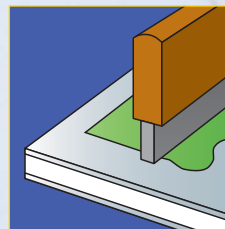
with any standard double-sided adhesive tape



Bending and shaping

Bending

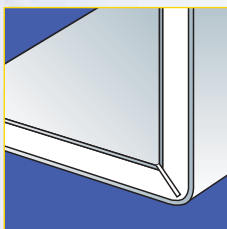
with a bending machine or bending press, minimum inside bending radius $r = 15 \times d$ (where d = sheet thickness): (the return movement is greater than with solid plate)



Surface treatment

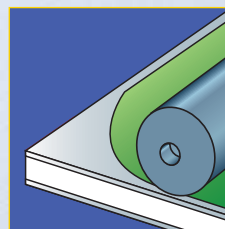
Screen printing

with any standard screen printing ink, (the surface of the sheets must be clean and free of dust and grease)



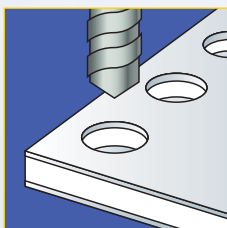
Edging (edge milling)

by hand, having first cut an appropriately angled V-shaped groove for the inside of the proposed fold using a panel saw with a milling attachment or by means of a hand-held router at 90°



Lamination/photograph mounting

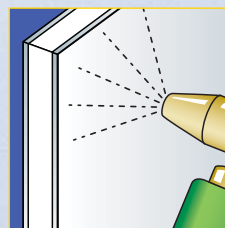
lamination with self-adhesive film, photograph mounting either dry by means of adhesive film or wet by means of dispersion adhesive



Joining

Drilling connecting holes

by using a bit suitable both for aluminum and for plastic sheets, (for relatively large holes use a bit with brad point)



Painting

by overpainting the polyester coated surfaces using any suitable paint type