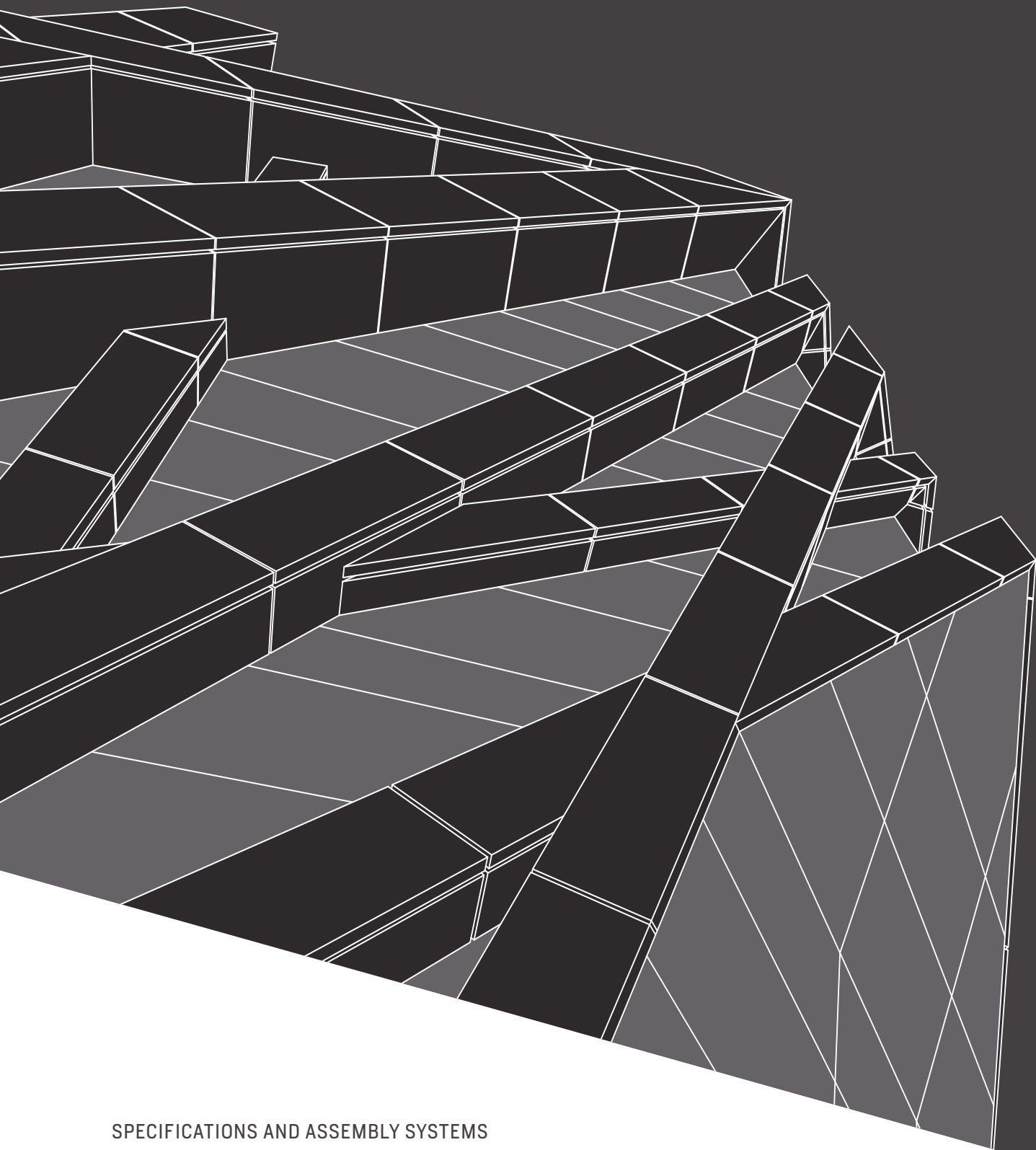


STAC BOND

ALUMINIUM COMPOSITE PANEL



SPECIFICATIONS AND ASSEMBLY SYSTEMS

TECHNICAL CATALOGUE

TECHNICAL CATALOGUE

SPECIFICATIONS AND ASSEMBLY SYSTEMS



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*ARCHITECTURE
WITHOUT LIMITS*

**PRODUCT
RANGE**

STACBOND® COMPOSITE PANEL

CHARACTERISTICS

STACBOND® composite panels are composed of two sheets of aluminium and an internal core of thermoplastics with a mineral content. The panels have excellent mechanical properties and provide rigidity. They have a low weight, flat surface, are long-lasting and easy to maintain.

They are especially designed for both new-build ventilated facades and for the renovation and restoration of facades. They are the ideal solution in all fields of architecture: homes, public buildings, offices, business and industry. That's not to mention their use in promoting a corporate image in, for example, supermarkets, car dealerships, banks and petrol stations. They also offer solutions for the design, transport and industrial sectors.

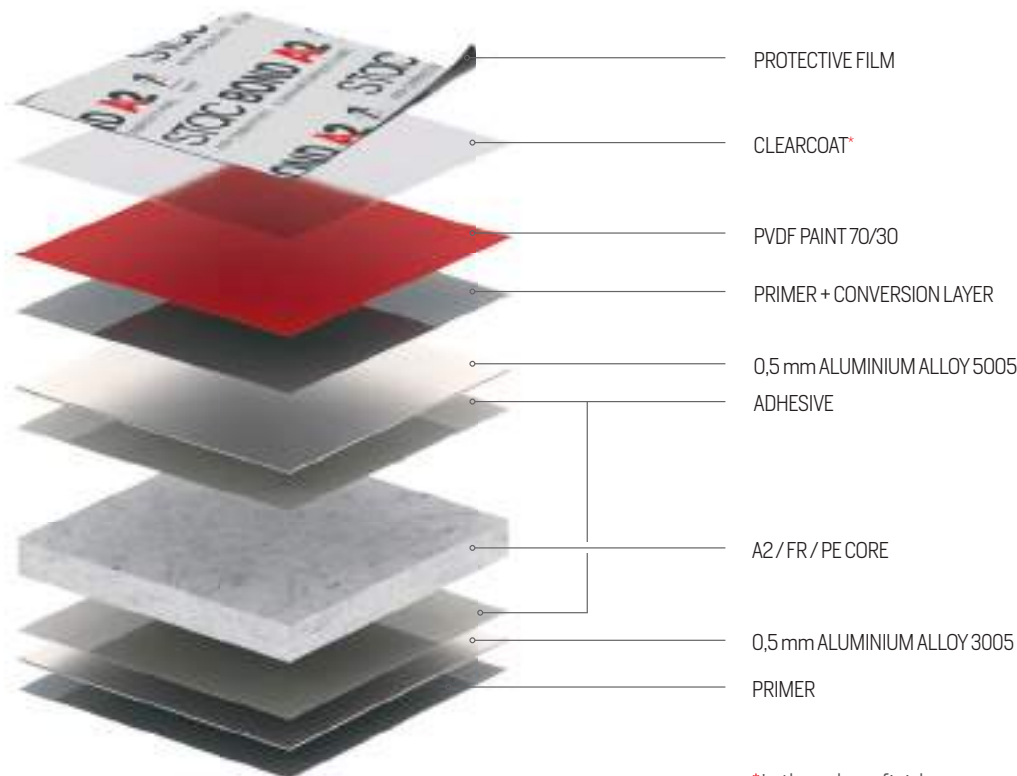
In its manufacturing standard this product consists of an outer sheet of aluminum alloy 5005 and an inner sheet of alloy 3005.

There are three different cores available depending on their mineral content, which can be non-combustible or fire retardant, and are classified (according to UNE 130501-1:2007) as A2-s1 d0 (**STACBOND® A2**), and B-s1, d0 (**STACBOND® FR**).

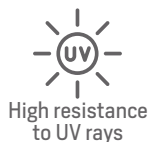
This is lacquered with the highest quality PVDF 70/30 (polyvinylidene fluoride) which provides excellent resistance to ageing and the highest protection against UV rays, as well as having excellent behaviour when machined or formed.

STACBOND® offers a full range of colours, shines, textures and natural finishes. Also, they can be supplied in any RAL / PANTONE / NCS colour – please enquire for details.

The **STACBOND®** composite panel is available in various standard dimensions of up to 2000 mm width. Other dimensions can be supplied under request.



* In three-layer finishes or on request

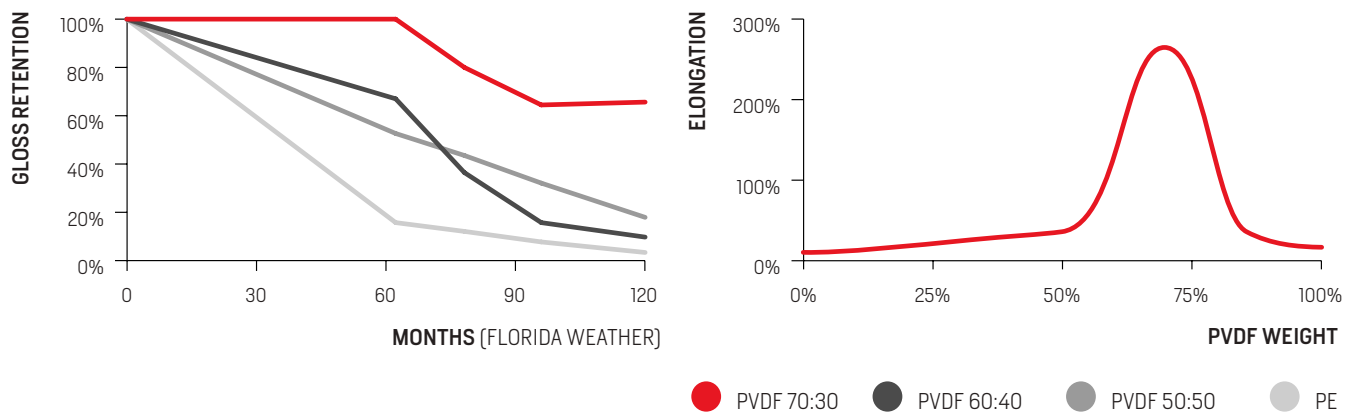


PVDF 70/30 PAINT

Highest quality paint, used in most **STACBOND®** regular finishes.

The 70/30 code indicates that the paint contains 70% polyvinylidene fluoride and 30% acrylic resin. This ratio is the optimal level to provide a high level of protection against UV rays and high ageing resistance. Mechanically, the paint has sufficient stretch to resist the forming of the panels without deterioration of the coating.

These finishes have a limited range of shine between 25 – 35 %, measured at an angle of 60°.



FEVE (LUMIFLON)

FEVE is a type of coating with a very similar structure to PVDF but it is harder and less flexible. It allows a wider shine range.

HDPE (High durability polyester)

HDPE paint is a slightly lower performance finish than PVDF, but allows high gloss range and some special finishes such as textured surfaces.

INNER FACE PROTECTION PRIMER

The epoxy / epoxy-polyester primer is applied at 5 – 10 microns and protects the interior face of the **STACBOND®** composite panel.



As part of our commitment to the environment, **STACBOND®** does not use chromium in any of the pre-treatment or painting processes.



CERTIFIED QUALITY

The manufacture of **STACBOND®** composite panels is performed under a controlled process with rigorous internal testing and quality control procedures in our laboratories, and externally via auditing by the most prestigious construction institutes in the various countries where we are certified. This means we offer our clients the peace of mind which comes from having the most demanding national and international certification.

The granting of these certifications follows the European directive in EAD 090062-00-0404 for exterior wall claddings and allows us to conclude that our construction systems are in accordance with the nation regulations of each country.

ENVIRONMENTAL COMMITMENT

As part of our continuous desire for innovation, the entire **STACBOND®** range and its processes employ optimized materials to always achieve simple, robust, aesthetic and functional products. This philosophy allows us to significantly reduce our environmental impact. We use 100% recyclable materials in the design of our products and we think about their life cycle right from the design phase. We also maintain a commitment with our suppliers to ensure that at least 95% of raw materials are also from recycled sources.

For these reasons, the **STACBOND® PE** and **STACBOND® FR** products have obtained EPD certification.

Furthermore, **STAC®** is **ISO 14001** certified thanks to the fact that our Environmental Management System (EMS), implemented in all our facilities, in line with the requirements of these regulations.



SPAIN



UNITED KINGDOM



ROMANIA



SWITZERLAND



INTERNATIONAL



FRANCE



POLAND



MEXICO



USA



INTERNATIONAL

SYSTEM CERTIFICATION

COUNTRY	RECOGNITION	BODY	SYSTEM						CORE		
			STB-T-CH	STB-T-SZ	STB-T-REM	STB-CH	STB-SZ	STB-REM	A2	FR	PE
EU	ETA 15-0655 – CE MARK	IETcc Madrid	✓	✓	✓	✓	✓	✓	✓	✓	✓
SPAIN	DIT 553p/19	IETcc Madrid	✓	✓	✓	✓	✓	✓	✓	✓	✓
POLAND	ITB-KOT-2017/0043 wydanie 2	ITB Warsaw	✓	✓	✓	✓	✓	✓	✓	✓	✓
FRANCE	Avis Technique 2.2/13-1548-V1 ⁽¹⁾ Avis Technique 2.2/13-1549-V2 ⁽²⁾	CSTB Paris				✓ ⁽²⁾		✓ ⁽¹⁾	✓	✓	✓
UNITED KINGDOM	BBA 13/5022	BBA Watford				✓	✓	✓	✓	✓	✓
ROMANIA	TPC	CTPC Bucharest	✓	✓	✓	✓	✓	✓	✓	✓	✓
GERMANY	DIBt	DIBt Berlin	✓	✓	✓	✓	✓	✓	✓	✓	✓
SWITZERLAND	VKF – AEAI	VKF Bern	✓	✓	✓	✓	✓	✓	✓	✓	✓
MEXICO	Valor AMEVEC	AMEVEC Mexico City	✓	✓	✓	✓	✓	✓	✓	✓	✓
			WET SYSTEM *		DRY SYSTEM *		RAINSCREEN SYSTEM *				
USA	ICC – ESR	ICC San Francisco	✓		✓		✓		✓	✓	✓
CANADA	INTERTEK	INTERTEK Texas	✓		✓		✓		✓	✓	

* Compatible certified systems not supplied by STAC®.

✓ IN PROGRESS ✓ CERTIFIED

ENVIRONMENTAL CERTIFICATES

COUNTRY	RECOGNITION	BODY	STAC BOND A2	STAC BOND FR	STAC BOND PE
INTERNATIONAL	EPD S-P-01289	Tecnalia R&I Guipúzcoa	✓	✓	✓

✓ IN PROGRESS ✓ CERTIFIED

FIRE-RESISTANCE RATING

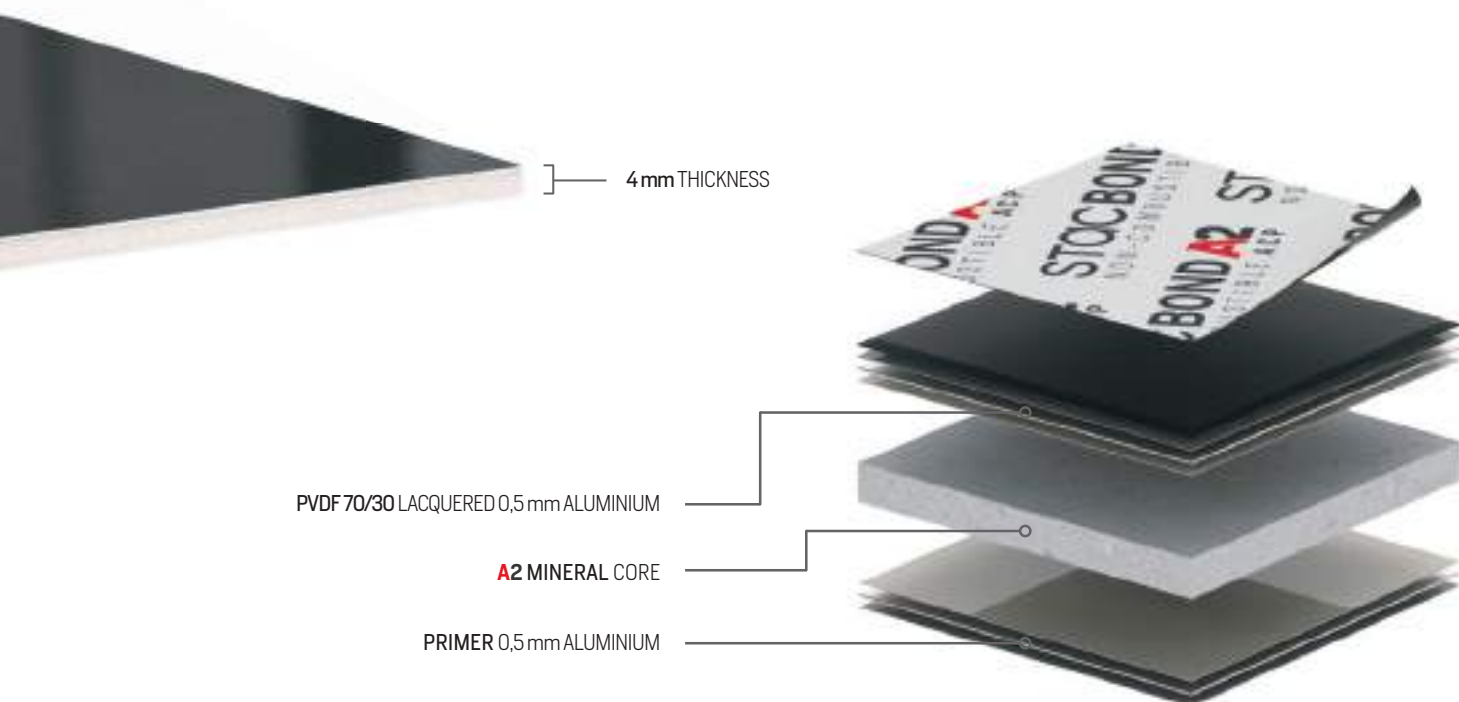
COUNTRY	REGULATION	STAC BOND A2	STAC BOND FR	STAC BOND PE
		CLASSIFICATION	CLASSIFICATION	CLASSIFICATION
EU	EN 13501-1	A2-s1, d0	B-s1, d0	·
	NF P 92-501:1995	·	·	M1
POLAND	PN-90/8-02867	·	NRO	·
USA	ASTM E84	A CLASS	A CLASS	A CLASS
	NFPA 285	PASS	PASS	·

STACBOND® A2 is a non-combustible composite panel composed of two sheets of aluminium and a mineral core developed to comply with the most stringent fire-resistance classification rules.

Thanks to the panels' exceptional mechanical properties (high rigidity, excellent flatness, impact resistance, durability and ease of maintenance) and A2-s1, d0 fire-resistance classification (in accordance with UNE EN 13501-1:2007), they are the ideal cladding solution for tall buildings and high-occupancy buildings.

Compliance with the strictest fire-resistance classification requirements, including:

- ✓ UNE EN 13501-1:2007 - **A2-s1, d0**
- ✓ NFPA 285 - **PASS**
- ✓ ASTM E84 - **A CLASS**



A2 CORE | 0,5 mm – 4 mm

SHEET DIMENSIONS		WIDTHS (mm)	LENGTHS (mm)
Made to measure manufacture (CONSULT)		1000 / 1250 / 1500 / 2000	(min.max.) 2500 / 6000
Thickness tolerance (mm) ± 0,2	Width tolerance (mm) ± 2	Length tolerance (mm) + 15	Diagonals tolerance (mm) ± 3
Tolerance of the Protective Film on the panel (mm) +0; -5			
PHYSICAL SPECIFICATION	UNIT	VALUE	NORM
Aluminium thickness	mm	0,5	
Panel thickness	mm	4	
Panel weight	kg/m ²	8,3	
Aluminium alloy		5005 / 3105 / 3005	UNE EN 573-3
A2 CORE SPECIFICATION	UNIT	VALUE	NORM
Density	g/cm ³	1,9 ± 0,15	
Fire reaction		A2 - S1, d0	UNE-EN-13501-1:2007
COATING TYPE	UNIT	VALUE	NORM
PvdF 70/30	μm	20 - 25*	EN 13523 - 1
Internal coating thickness Primer	μm	5 - 10*	EN 13523 - 1
External coating thickness	μm	25 - 35*	EN 13523 - 1
Gloss (measured at 60° angle)	GU	30 ± 5*	EN 13523 - 2 / ISO 2813
Hardness		Min F	EN 13523 - 4
GENERAL CHARACTERISTICS	UNIT	VALUE	NORM
Adherence		No loss of adherence	EN - DIN - 53151
Elasticity module (E)	N/mm ²	70000	EN 485 - 2
Proof stress (R _{p0.2})	N/mm ²	≥ 80	EN 485 - 2
Tensile strength (R _m)	N/mm ²	125 ≤ R _m ≤ 240	EN 485 - 2
Elongation (A)	%	≥ 4	EN 485 - 2
Impact resistance		4 Joules / GT0	EN 13523 - 5/6
Chemical Resistance		5% HCl unchanged	ISO 2812 - METHOD 3
Temperature utilization	°C	- 40 / +80	
Acoustic insulation Rw (C;Ctr)	dB	30 [-1; -3]	ISO 717 - 1

* Standard values, other values can be accepted if the finish requires it and does not affect the product quality.

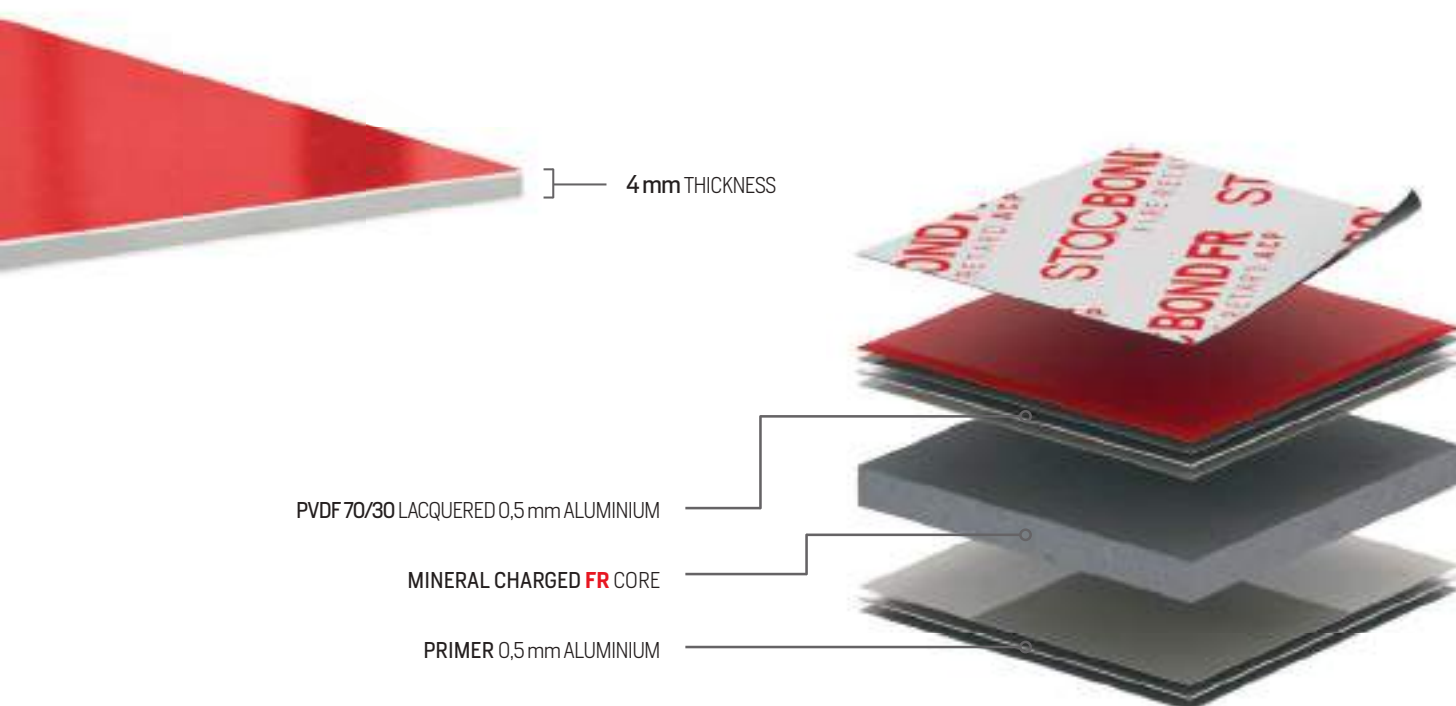
STACBOND[®] FR

FIRE RETARD ACP

STACBOND[®] FR panels are composed of two aluminium sheets with a fire retardant core made of thermoplastic resins with mineral load.

The panels have excellent mechanical properties including: high rigidity, excellent flatness and impact resistance. They comply with the majority of requirements for fire-resistance classification:

- ✓ UNE EN 13501-1:2007 – **B-s1, d0**
- ✓ PN-90/8-02867 – **NRO**
- ✓ NFPA 285 – **PASS**
- ✓ ASTM E84 – **A CLASS**



SHEET DIMENSIONS		WIDTHS (mm)	LENGTHS (mm)
Made to measure manufacture (CONSULT)		1000 / 1250 / 1500 / 2000	(min.max.) 2500 / 6000
Thickness tolerance (mm) $\pm 0,2$	Width tolerance (mm) ± 2	Length tolerance (mm) $+ 15$	Diagonals tolerance (mm) ± 3
Tolerance of the Protective Film on the panel (mm) $+0; -5$			
PHYSICAL SPECIFICATION	UNIT	VALUE	NORM
Aluminium thickness	mm	0,5	
Panel thickness	mm	4	
Panel weight	kg/m ²	8,02	
Aluminium alloy		5005 / 3105 / 3005	UNE EN 573-3
FR CORE SPECIFICATION	UNIT	VALUE	NORM
Density	g/cm ³	1,6 – 1,8	
Fire reaction		B – S1, d0	UNE-EN-13501-1:2007
COATING TYPE	UNIT	VALUE	NORM
PvdF 70/30	μ_m	20 – 25*	EN 13523 – 1
Internal coating thickness Primer	μ_m	5 – 10*	EN 13523 – 1
External coating thickness	μ_m	25 – 35*	EN 13523 – 1
Gloss (measured at 60° angle)	GU	30 \pm 5*	EN 13523 – 2 / ISO 2813
Hardness		Min F	EN 13523 – 4
GENERAL CHARACTERISTICS	UNIT	VALUE	NORM
Peeling	N/mm	≥ 7	ASTM D903 – 98 (2004)
Adherence		There is no loss of adherence	EN – DIN – 53151
Elasticity module (E)	N/mm ²	70000	EN 485 – 2
Proof stress ($R_{p0,2}$)	N/mm ²	≥ 80	EN 485 – 2
Tensile strength (R_m)	N/mm ²	125 $\leq R_m \leq$ 240	EN 485 – 2
Elongation (A)	%	≥ 4	EN 485 – 2
Impact resistance		4 Joules / GT0	EN 13523 – 5/6
Chemical resistance		5% HCl unchanged	ISO 2812 – METHOD 3
Temperature utilization	°C	- 40 / +80	
Thermal expansion for differences of 100° C	mm/m (100°)	2,36	UNE-EN ISO 10545:1997
Thermal transmission (U)	W/m ² K	5,62	UNE-EN ISO 12567-1
Acoustic insulation Rw (C;Ctr)	dB	29 [-1; -3]	ISO 717 – 1

* Standard values, other values can be accepted if the finish requires it and does not affect the product quality.

STACBOND PE

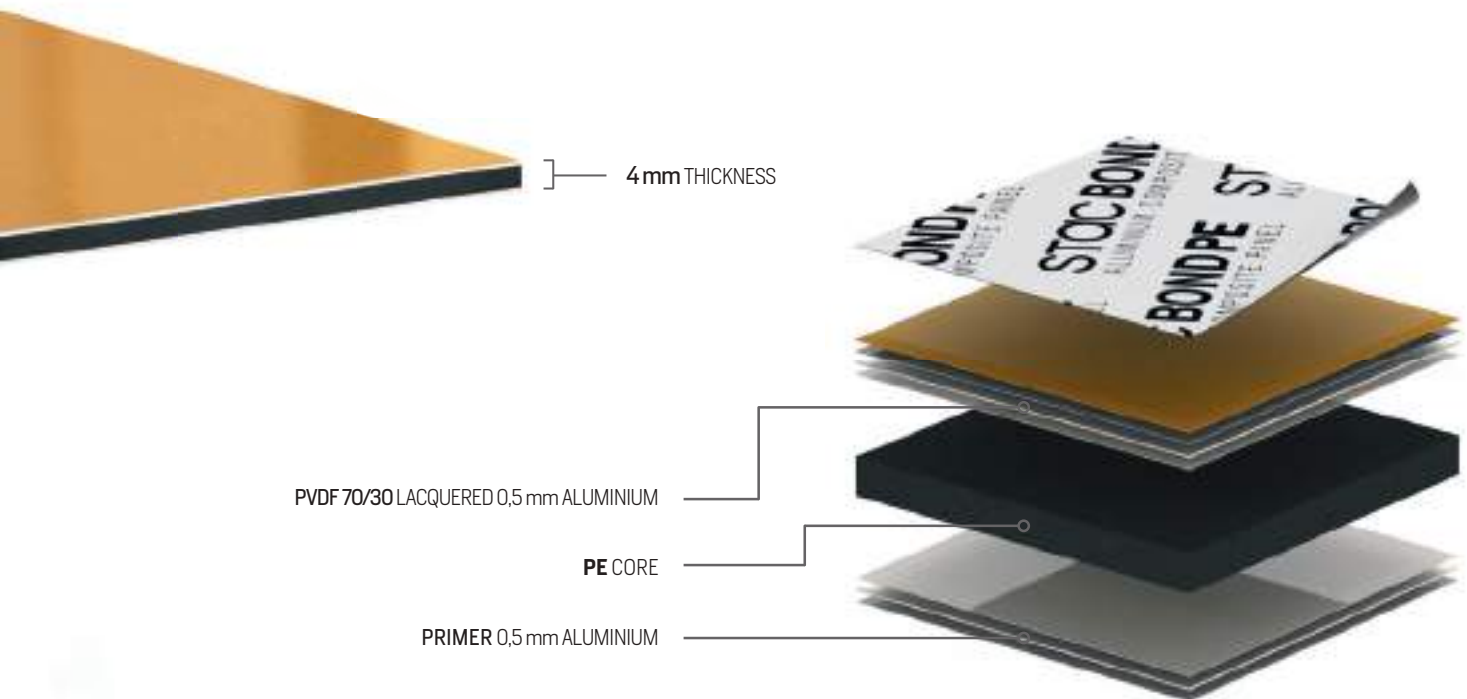
ALUMINUM COMPOSITE PANEL

STACBOND® PE panels consist of two aluminium sheets with a thermoplastic resin core (low-density polyethylene). Their outstanding properties include lightness, flatness, inalterability under humidity changes and the ease of forming.

They are especially suitable –among others– for ventilated facades, high durability corporate image, stands and exhibitors, and multiple applications for outdoor spaces.

They comply with the following fire classification requirements:

- ✓ NF P 92-501:1995 – **M1**
- ✓ ASTM E84 – **A CLASS**



PE CORE | 0,5 mm – 4 mm

SHEET DIMENSIONS		WIDTHS (mm)	LENGTHS (mm)
Made to measure manufacture (CONSULT)		1000 / 1250 / 1500 / 2000	(min. / max.) 2500 / 6000
Thickness tolerance (mm) ± 0,2	Width tolerance (mm) ± 2	Length tolerance (mm) + 15	Diagonals tolerance (mm) ± 3
Tolerance of the Protective Film on the panel (mm) +0; -5			
PHYSICAL SPECIFICATION	UNIT	VALUE	NORM
Aluminium thickness	mm	0,5	
Panel thickness	mm	4	
Panel weight	kg/m ²	5,5	
Aluminium alloy		5005 / 3105 / 3005	UNE EN 573-3
PE CORE SPECIFICATION	UNIT	VALUE	NORM
Density	g/cm ³	0,93	
COATING TYPE	UNIT	VALUE	NORM
PvdF 70/30	μm	20 - 25*	EN 13523 - 1
Internal coating thickness Primer	μm	5 - 10*	EN 13523 - 1
External coating thickness	μm	25 - 35*	EN 13523 - 1
Gloss (measured at 60° angle)	GU	30 ± 5*	EN 13523 - 2 / ISO 2813
Hardness		Min F	EN 13523 - 4
GENERAL CHARACTERISTICS	UNIT	VALUE	NORM
Peeling	N/mm	≥ 9,8	ASTM D903 - 98 (2004)
Adherence		There is no loss of adherence	EN - DIN - 53151
Elasticity module [E]	N/mm ²	70000	EN 485 - 2
Proof stress (R _{p 0,2})	N/mm ²	≥ 80	EN 485 - 2
Tensile strength (R _m)	N/mm ²	125 ≤ R _m ≤ 240	EN 485 - 2
Elongation (A)	%	≥ 4	EN 485 - 2
Impact resistance		4 Joules / GT0	EN 13523 - 5/6
Chemical resistance		5% HCl unchanged	ISO 2812 - METHOD 3
Temperature utilization	°C	- 40 / +80	
Thermal expansion for differences of 100° C	mm/m (100°)	2,25	UNE-EN ISO 10545:1997
Thermal transmission (U)	W/m ² K	3,38	UNE-EN ISO 12567-1
Acoustic insulation Rw (C;Ctr)	dB	28 (0; -3)	ISO 717 - 1

* Standard values, other values can be accepted if the finish requires it and does not affect the product quality.

PRODUCT MAINTENANCE

STACBOND® composite panels present an optimal behaviour against possible changes in appearance caused by prolonged exposure to normal climatic conditions.

Facades made of composite panels are exposed to many aggressive agents present in the environment, such as sulphurous compounds, acids and nitrogen compounds caused by acid rain, chemical salts, dirt, soot, etc. These substances mixed with water and combined with UV radiation from the sun can lead to deterioration of the surface finish and shorten life expectancy of the product. These effects are worse in areas where rainwater cannot wash away the impurities.

As long as care is taken to keep the coating in good condition through regular washing and to ensure that incompatible or highly contaminated materials do not come into contact with the surface, the coating will not crack or delaminate, but changes may occur to the uniform appearance, such as slight changes in colour and brightness.

Specifically, for particularly harsh or difficult environments, such as areas with high levels of UV, areas at risk of sandstorms, proximity to chemical factories, swimming pools, saline environments or areas not exposed to natural rain, more rapid deterioration may occur.

For these reasons, the cleaning of roofing and facades is an important part of the care and maintenance of the cladding.

Regular inspection and maintenance is recommended to maintain the optimal appearance and durability of the coated aluminium. Above all, areas not exposed to natural rain, such as overhangs, may need further cleaning to eliminate potentially corrosive deposits. Leaves, grass, mould and other objects should be removed and any obstructions should be cleaned to prevent overflow. Local defects that can cause premature deterioration of the coating or corrosion of the substrate should be examined and repaired.



CLEANING*

Dirt and stained areas can be cleaned with water and as oft brush. A moderate strength power washer can also be used. The surface should then be rinsed down.

For more stubborn stains a pH neutral soap should be used. The detergent must be thoroughly removed after a few minutes with water. To remove a stain, a soft cotton cloth (or similar) wetted with a non-aggressive solvent such as mineral alcohol may be used.

Washing the painted surface should be carried out from top to bottom so that any detergent is washed away completely. The use of strong or detergents or those which are inappropriate for coloured surfaces may damage the finish. If necessary, we recommend carrying out a test clean on a small, low-visibility area of the panel.

We recommend carrying out cleaning of the façade when climatic conditions allow (avoiding high temperatures or strong, direct sunlight).



Moderate pressure washer



Use of neutral detergents



Washing from top to bottom

PROTECTIVE FILM

The protective film used is a temporary surface protector and once the panel is installed in the facade it should be removed as soon as possible as climatic factors (hours of exposure, climate zone, geographic location or sharp changes in temperature) may affect the adhesive used on the protective film and make removal more difficult.

The protective film must be removed within a maximum period of 30 days after the panel has been installed on the facade. When the film is removed, it must be completely removed from the entire visible part of the facade. If it is partially removed, it could cause stains or marks to appear on the front face of the panel.

For the machining and later installation of the **STACBOND®** composite panel on the facade, it must be ensured that the orientation of the arrows indicated on the protective film must be the same on the entire surface, in order to avoid variations in the tone of the finish.

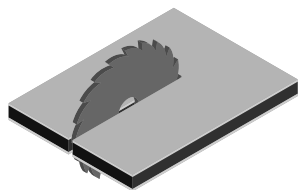


* Some special finishes require specific cleaning processes. In the vent of doubt, please consult **STACBOND®**.

*SHAPING YOUR
CREATIVITY*

PANEL TRANSFORMATION

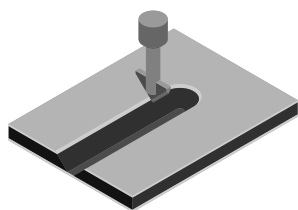
CUTTING



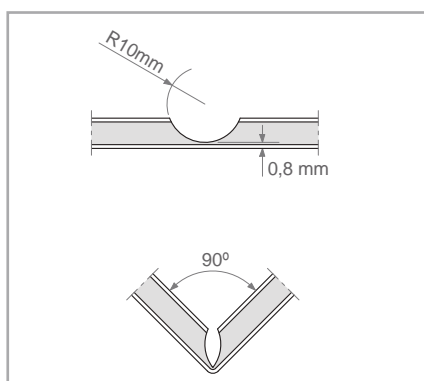
STACBOND® composite panel can be cut using CNC machinery or manually using a wall saw or portable milling machine. Straight, curved and angled cuts are possible, depending on the tools used.

Consult **STACBOND®** for the recommended parameters for the different types of cutting and the machinery used.

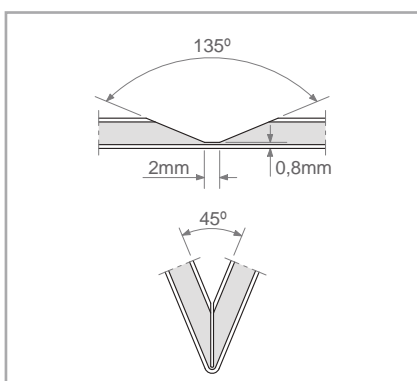
MILLING



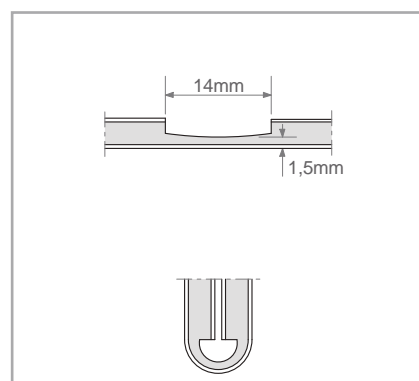
Performed using CNC, wall saw with milling disk or portable milling machine. The partial milling of the panels allows them to be bent into shape. The scoring is done using 90° or 135° milling bits depending on the bend required. To achieve the desired measurements, the fold must be made on the axis of the milling score line. The remaining thickness of the panel allows it to be bent into shape by hand using specific tools or using a composite panel specific press brake.



Spherical milling groove for 90° bends.



V-shaped milling groove for 135° bends.



Arc milling groove for complete 180° folds (not possible on **STACBOND® A2** panel).

RECOMMENDED MILLING PARAMETERS:

CORE	PROCESS	ROTATIONAL SPEED (r.p.m.)	DISPLACEMENT SPEED (mm/min)
STACBOND A2	CUTTING	22.000 – 24.000	8.000 – 10.000
	MILLING	24.000	10.000 – 12.000
STACBOND FR	CUTTING	24.000	12.000 – 14.000
	MILLING	24.000	15.000 – 18.000
STACBOND PE	CUTTING	24.000	12.000 – 14.000
	MILLING	24.000	15.000 – 18.000

Note: These values are for guidance only and are intended for use with **STACBOND®** recommended milling tools. For use with other tools or depending on the type of machine it is necessary to adjust them.

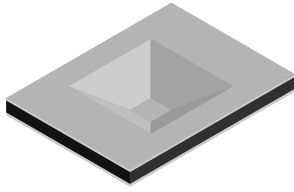
RECOMMENDED TOOLS **A2** CORE:

- **Cutting tool:** ø 6 mm milling cutter with diamond insertions (STB-FRESA6PCD)
- **Milling tool:** ø 10 mm spherical milling cutter with diamond insertions (STB-FRESA10PCD)

RECOMMENDED TOOLS **FR / PE** CORE:

- **Cutting tool:** ø 6 mm milling cutter with diamond insertions (STB-FD6X80X3.8)
- **Milling tool:** ø 10 mm spherical milling cutter with diamond coating (STB-FEMD-10x72)

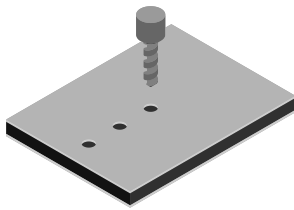
EMBOSSING AND ENGRAVING



STACBOND® composite panels can be embossed and engraved using CNC machines. There are limits on the depth achievable depending on the shape and size of the tool used.

Please consult STACBOND® about different possible methodologies.

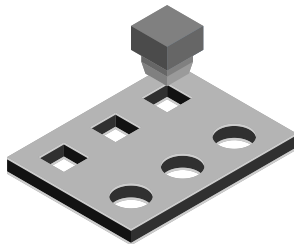
DRILLING



The composite panel supports multiple types of perforations. Drilling can be frequent during installation of the product on site, especially in riveted and screwed assembly systems. For this purpose, the use of a bidiametric drill bit is recommended for fasteners with an expansion margin.

Consult STACBOND® for further information.

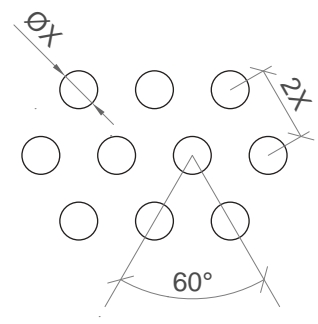
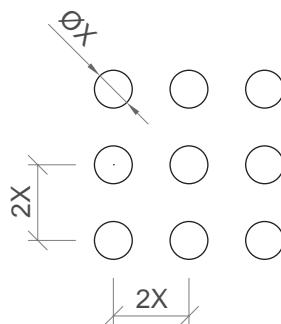
PUNCHING AND DIE-CUTTING*



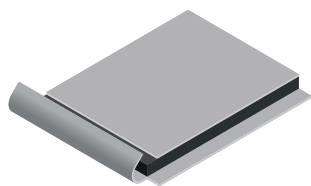
STACBOND® composite panels can be punched or die-cut using CNC machines. The recommended parameters to maintain the panels' properties and thus their guarantee are as follows:

- The smallest punch diameter should be 4 mm
- The distance between centres must be at least double the diameter
- The perforated surface area must be less than 35% of the total surface area of the panel

Consult STACBOND® about possible formats.



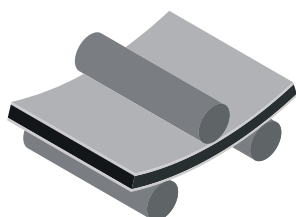
*STACBOND® A2 panel perforation is not recommended.



EDGE FOLDING OF BORDERS*

STACBOND® composite panels can be edge folded on their profile. We offer three types of border: Simple (hides border), double interior (hides the border and part of the reverse) and double exterior (hides border and has a tab sticking out which hides the joint with other sheets of the panel). The dimensions of the panel must be oversized to account for the requirements of each type of border.

	SIMPLE FOLDING	DOUBLE INTERIOR FOLDING	DOUBLE EXTERIOR FOLDING
UNFOLDED DIAGRAM			
FOLDED DIAGRAM			
FLAP INCREASE (mm)	3,5	7,5	14,0



BENDING WITH ROLLERS

To make curved panels the best system is using a bending machine with 3/4 rollers. To avoid risk of damage, attention must be paid to the minimum radius of the curve of the internal side.

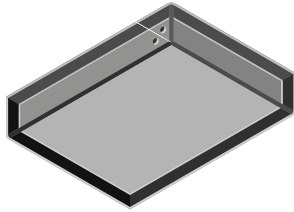
In the case of STACBOND® composite panels with flaps, the minimum recommended radius is 500 mm for a maximum flap length of 20 mm.

The minimum bending radius without flaps is determined by the following formula:

$$\emptyset \text{ UPPER ROLLER} \times 1,5 / 2 = \text{BENDING RADIUS}$$

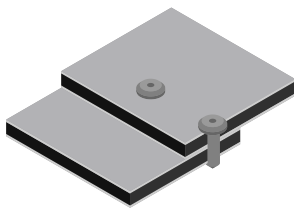
For example, in a machine where the diameter of the upper roller is 200 mm, we could bend a 4 mm thick composite panel sheet with a minimum radius of 150 mm.

Bending without flaps of lower radius can be achieved by using press brakes with specific tools. Consult STACBOND® for more information.



FORMING CASSETTES**

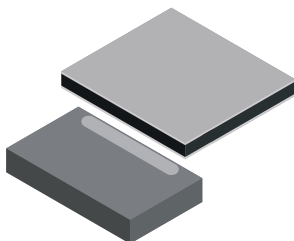
The cassettes in the **STACBOND®** systems are formed by bending the perimeter tabs. These tabs are made by partial milling of the panel with the correct dimensions for the system used. For fastening / anchoring the panels, various specific parts are used, such as strips made of aluminium or from the same material as the panel itself, which are attached using rivets. During the forming process we recommend that the panel be duly protected to avoid superficial damage. This process also can be used to form surfaces with three-dimensional relief.



RIVETING AND SCREWING

STACBOND® composite panels can be installed using rivets or screws, either to each other or to other materials. The thermal expansion of the panels must be taken into account. We recommend the use of aluminium / INOX rivets and INOX A2 screws.

We recommend the use of centring bits for correct drilling and fitting of rivets, as well as spacing nosepieces to limit the pressure exerted on the expansion points.



GLUEING

The panels can be glued using special adhesives and double-sided adhesive tape specified for composite panels, following the manufacturer's technical specifications.

Consult **STACBOND®** for further information.

*We recommend the edge folding of the **STACBOND® A2** panel in our own mounting systems (STB-REM, STB-T-REM, STB-PEG, STB-T-PEG) or other systems where the border is visible.

It is not recommended to fold the tabs of the **STACBOND® A2 panel more than twice.



*MORE SYSTEMS
MORE SOLUTIONS*

**ASSEMBLY
SYSTEMS**

STACBOND® offers 8 assembly systems to provide new possibilities and solutions for modern architecture. These systems have been meticulously designed to adapt to the specific requirements of each project.

These 8 systems for the installation of **STACBOND®** composite panels are split into two main groups depending on the substructure:

T SUBSTRUCTURE

- **STB-T-CH** (hanging system)
- **STB-T-SZ** (male-female coupling system)
- **STB-T-REM** (riveted system)
- **STB-T-PEG** (glued system)

OMEGA SUBSTRUCTURE

- **STB-CH** (hanging system)
- **STB-SZ** (male-female coupling system)
- **STB-REM** (riveted system)

The **STB-PEG** (glued system) employs a substructure consisting of independent angled spacers and ribbed tubes specifically prescribed for internal applications.

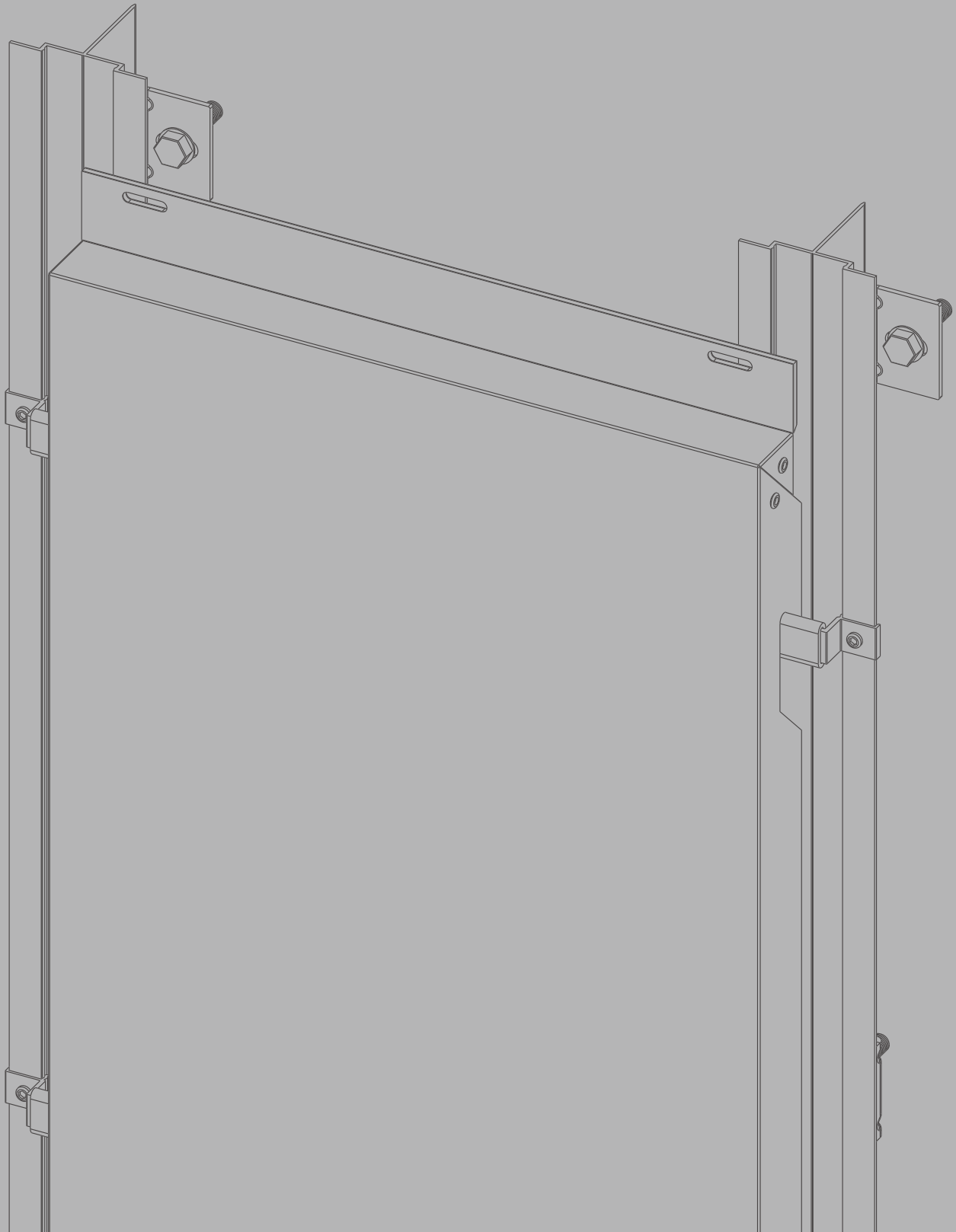
The **STB-CH**, **STB-SZ** and **STB-REM** systems employ the same substructure elements, DOUBLE T spacers and OMEGA profile.

The **STB-T-CH**, **STB-T-SZ**, **STB-T-REM** and **STB-T-PEG** systems employ special L spacers and T profile.

The **STB-T-CH**, **STB-T-SZ**, **STB-T-REM**, **STB-CH**, **STB-SZ** and **STB-REM** installation systems for **STACBOND®** composite panels have the European technical evaluation document ETE/ETA 15-0655 and CE marking according to EAD guide 090062-00-0404.

STB-T-CH

HANGING SYSTEM



STB-T-CH SYSTEM DESCRIPTION



STB-T-CH is a kit system based on hung cassettes made from **STACBOND® composite panels for installing ventilated facades**. The system has hidden fixings and is versatile and quick to install. The cassettes can be installed either vertically or horizontally. The **STB-CH** system complies with all the requirements to be employed in the most cutting edge architectural claddings.

The substructure employs **profiles T OMEGA** and **spacers L** in 6063 T5 aluminium alloy.

The spacers come in various lengths to house the required thickness of thermal insulation and compensate any irregularities in the facade. For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the spacers L and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the profiles T as uprights.

The **bracket sets STB-T-CH hanging** are placed on the profiles T. They are cut from extruded 6063 T% aluminium alloy profiles. A special EPDM piece is fitted in the hanging area to avoid vibrations.

The cassettes made of **STACBOND®** composite panel are attached to the substructure thanks to slots which are machined in the vertical edges of the cassettes and in their hidden stiffeners attached to the inner face, in a manner so that they rest on the bracket sets and are screwed or riveted through the upper tabs to the profiles T OMEGA.

STAC® has developed a program for the specific calculations of the substructure with the criteria from the Technical approval Document (DIT plus 553p/16) established by the Instituto de Ciencias de la Construcción Eduardo Torroja for each project executed, defining the maximum distances between uprights and the number of fixings.

The **STB-T-CH** system is included in the European technical evaluation document ETE/ETA 15-0655 and has the CE marking.



ETA-ETE: 15/0655



Nº 553P/19



ITB - KOT 2017/0043





SPACERS L

1. Spacers L to fix the profile to the facade. The spacers L join the profile T OMEGA to the vertical face or support wall and are used to overcome irregularities in the plumbness of the facade. They are either retaining or supporting. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.



PROFILES T OMEGA

2. The profiles T OMEGA are screwed to the spacers L. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings to the face must be placed at a maximum of 250 mm from the ends of the profile.



BRACKET SETS

3. The bracket sets are placed on the profiles. These are adjusted in height according to the location of the hanging slots of each cassette.



STACBOND COMPOSITE PANEL CASSETTE

4. STACBOND® composite panel cassette. The last step is placing the cassettes on the hangers and screwing or riveting them to the wings of the profiles T OMEGA in the slotted holes located on the upper horizontal tabs of the cassettes. The cladding is applied working from the bottom row up.

STB-T-CH SYSTEM

AUXILIARY ELEMENTS

BRACKET SET STB-T-CH HANGING

The bracket setSTB-T-CH hanging is used on T OMEGA profiles.

The gasket for the hanger is used to avoid vibration noise caused by wind load, road traffic, etc.

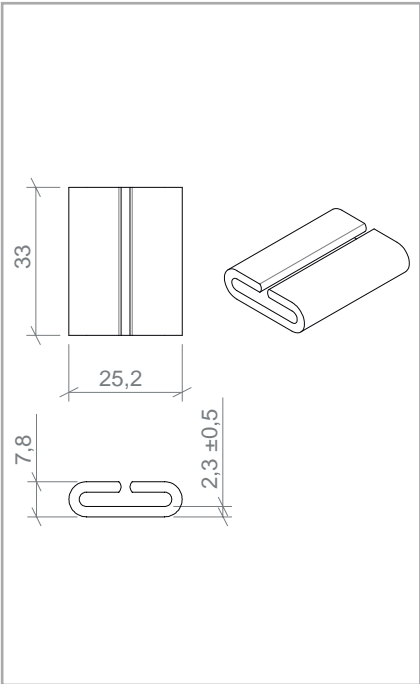
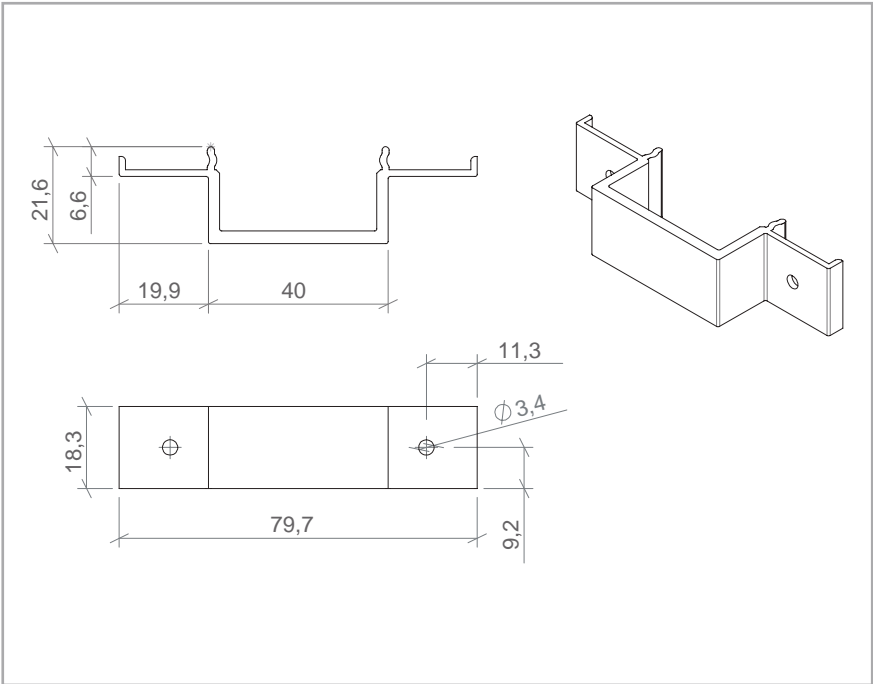
The support is initially attached to the profile via tabs which allow vertical movement to aid placement in the final location and is then fixed using self-tapping screws.



REFERENCE	DESCRIPTION	UNITS/BOX
05.19.062	BRACKET SET STB-T-CH HANGING	200

BRACKET STB-T-CH

BRACKET GASKET



Measurements in mm

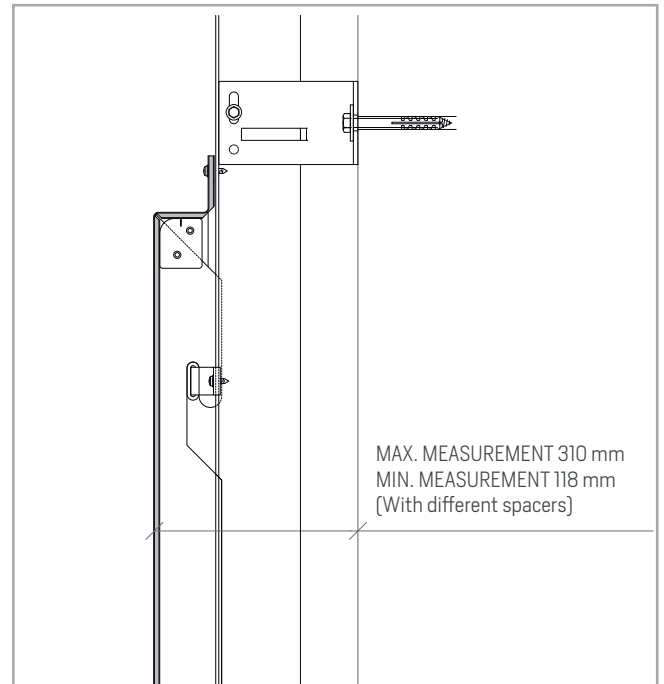
STB-T-CH SYSTEM

STANDARD CH CASSETTE WITH 45 mm FLAP

45 mm FLAP (DETAIL)



VERTICAL CROSS-SECTION



Note: The machined **STACBOND®** panels are supplied flat. The client is responsible for forming them into cassettes. No specialist machinery is required.

For the CH cassettes with 45 mm flaps, they can be formed using rectangular strips of 1050 ally (28 x 33 x 2 mm) or rectangular offcuts of the composite panels themselves.

Due to their greater length, the 45 mm flaps enter further into the T OMEGA profiles and more efficiently channel away water that hits the facade.

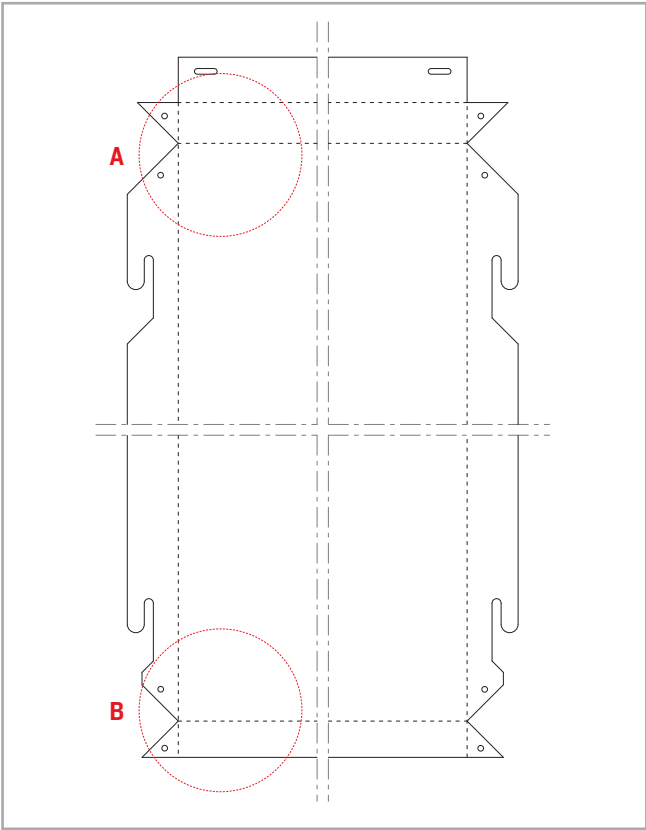
STB-T-CH SYSTEM

STANDARD CH CASSETTE WITH 45 mm FLAP

FORMED CASSETTE



FLAT CASSETTE



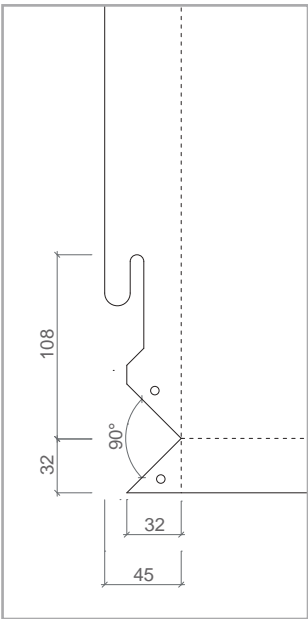
CASSETTES FORMING PLATE

The shaping plate is a small piece of 1050 H24 aluminium alloy which permits mechanical fixing via rivets to give the STB-CH and STB-T-CH system cassettes their shape.

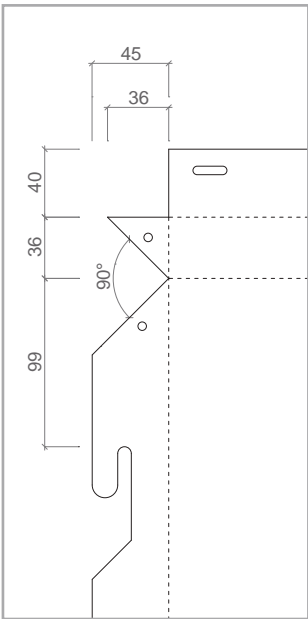
This plate is specified for CH cassettes with 45 mm flap and stiffeners.



DETAIL A



DETAIL B



Measurements in mm

REFERENCE	DESCRIPTION	UNITS/BOX
05.19.050	CASSETTES FORMING PLATE	3000

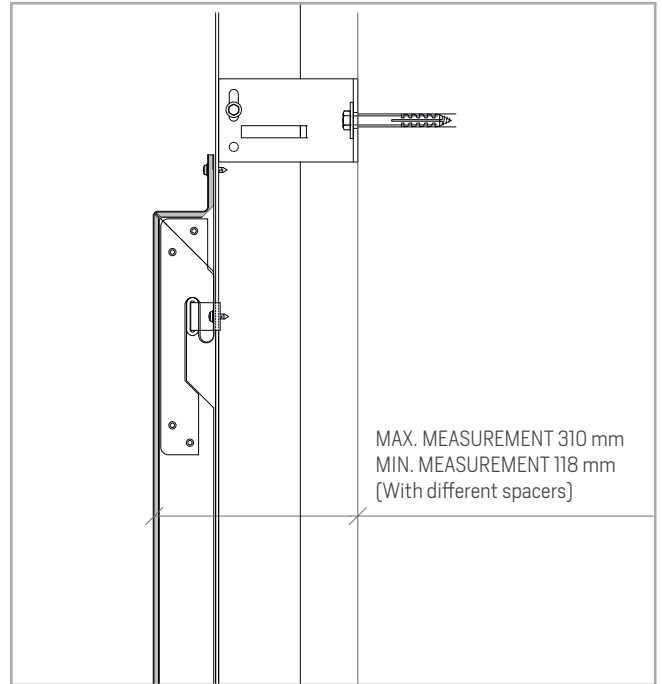
STB-T-CH SYSTEM

STANDARD CH CASSETTE WITH 40 mm FLAP

40 mm FLAP (DETAIL)



VERTICAL CROSS-SECTION



Note: The machined **STACBOND®** panels are supplied flat. The client is responsible for forming them into cassettes. No specialist machinery is required.

For the forming of CH cassettes with 40 mm flaps, hanging reinforcements are always used for every tab. These are specific 1050 aluminium alloy pieces of 2 mm and are riveted or screwed to the corresponding tabs and / or stiffeners.

The cassettes with 40 mm flap can allow greater optimization as they require less panel in the flaps than the cassettes with 45 mm flap.

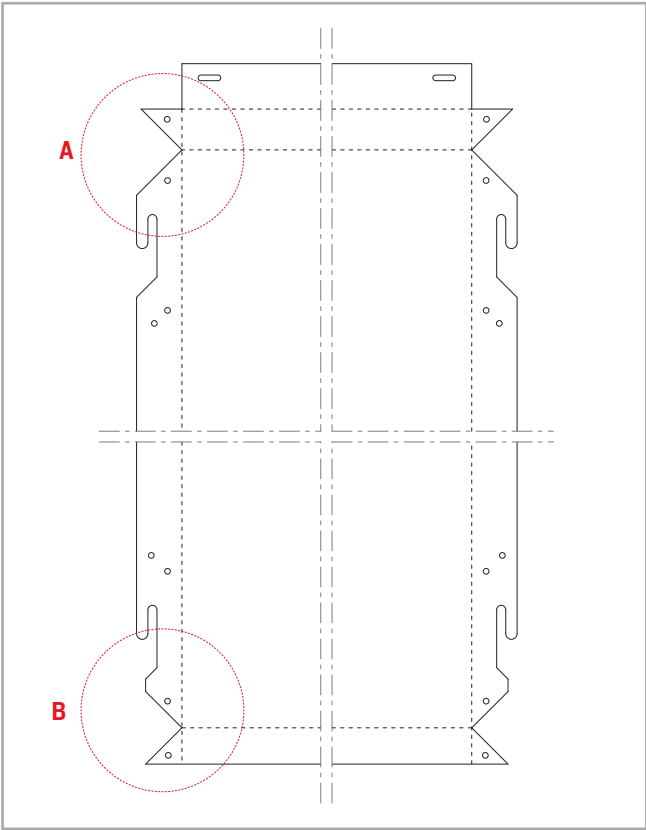
STB-T-CH SYSTEM

STANDARD CH CASSETTE WITH 40 mm FLAP

FORMED CASSETTE



FLAT CASSETTE

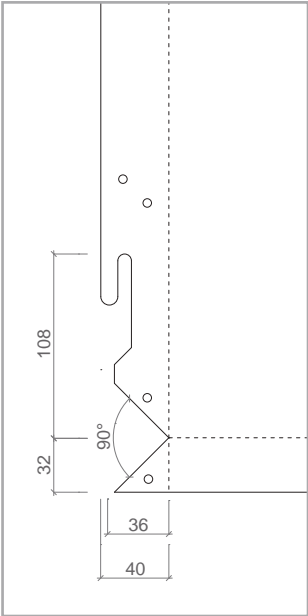


HANGING REINFORCEMENT

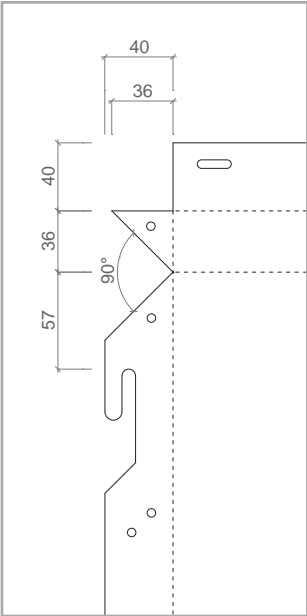
The hanging reinforcement is a piece made of 1050 H24 aluminium alloy which allows mechanical fixing via rivets to form the shape of the cassettes for the STB-CH and STB-T-CH systems, as well as strengthening each of the hanging slots of the CH cassettes with 40 mm flap.



DETAIL A



DETAIL B



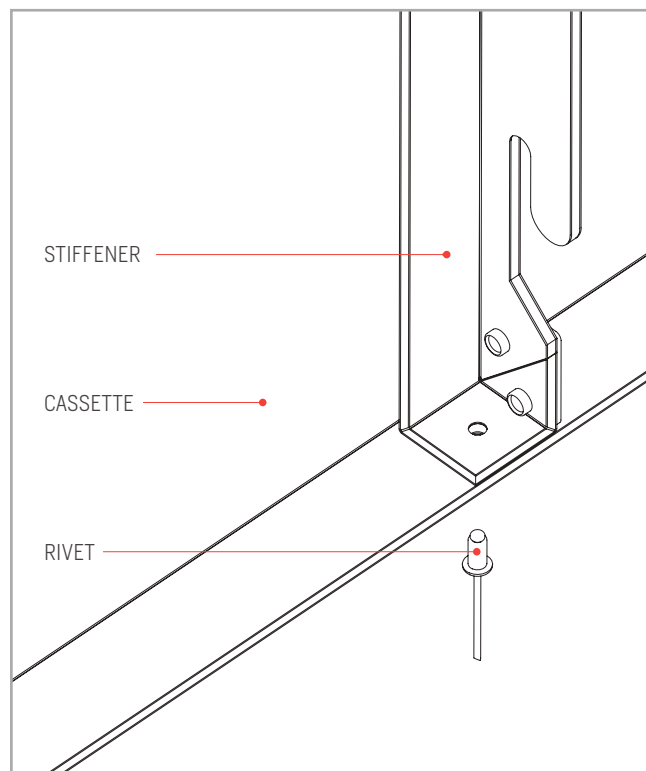
REFERENCE	DESCRIPTION	UNITS/BOX
05.19.019	HANGING REINFORCEMENT	500

Measurements in mm

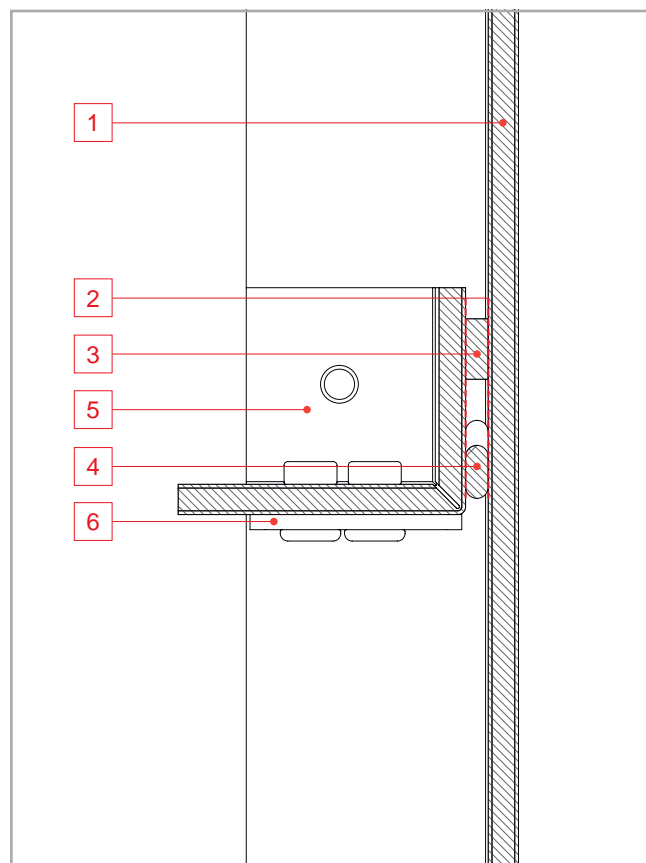
The stiffener is a angular piece formed from machined **STACBOND®** composite panel. It is used to internally reinforce CH cassettes when they exceed certain dimensions. The stiffener is fixed with double-sided tape and adhesive to the inner side of the tray and is riveted to the horizontal upper and lower flanges.



DETAIL OF MECHANICAL FIXING



DETAIL OF MECHANICAL FIXING



REFERENCE	DESCRIPTION
05.19.025	STIFFENER SCH-1 (< 750 mm)
05.19.026	STIFFENER SCH-2 (750 - 1500 mm)
05.19.027	STIFFENER SCH-3 (1500 - 2400 mm)
05.19.027.1	STIFFENER SCH-4 (2400 - 4000 mm)
05.19.027.2	STIFFENER SCH-5 (4000 - 5000 mm)
05.19.027.3	STIFFENER SCH-6 (> 5000 mm)

Nº	NAME
1	STACBOND® composite panel cassette
2	Primer
3	Double-sided adhesive tape
4	Adhesive applied to the cassette
5	Stiffener made of STACBOND® composite panel
6	Cassettes forming plate

STB-T-CH SYSTEM

ATTACHING STIFFENER

1. PREPARING THE AREA

Firstly dust and dirt is removed mechanically. Solvents must never be used. This cleaning consists of light or heavy sanding, depending on the extent of dirt present. The dust is then vacuumed or blown away. For cleaning and subsequent degreasing, SIKA-AVIATOR-205 or similar is used. It should be left to evaporate for 10 minutes minimum.

2. PRIMING THE AREA

Once the area is clean it is primed using a specific product which strengthens the adherence of the elastic adhesive (SIKATACK PANEL PRIMER or similar).

3. DOUBLE-SIDED ADHESIVE TAPE

After the required drying time of the primer (30 to 60 mins) the double-sided adhesive tape – SIKATACK PANEL-3 TAPE or similar – is applied. This holds the part whilst the adhesive polymerizes, as well as ensuring the required minimum depth of adhesive for any possible dilation of the STACBOND® composite panel.

4. APPLYING THE ADHESIVE

The elastic adhesive – SIKATACK PANEL or similar – is then applied to the panel, applying a continuous bead contiguous to the adhesive tape.

5. ATTACHING THE STIFFENER

The stiffener is then put in place ensuring that its full face surface is in contact with the adhesive.

6. FIXING WITH RIVETS

Lastly, the stiffener is drilled and riveted through the upper and lower ends to the horizontal tabs of the cassette.



1. CLEANING



2. PRIMING



3. ADHESIVE TAPE



4. SIKATACK PANEL ADHESIVE



5. ATTACHING THE STIFFENER



6. FIX WITH RIVETS

STB-T-CH SYSTEM

REPLACEMENT OF DAMAGED CASSETTES



1. Remove the damage cassette by cutting the upper flap.



2. Drill hole in tube of 30 x 30 x 1.4 mm with \varnothing 6 mm and place in the new cassette.



3. Place 4.2 x 13 DIN 7504 N stainless screws in "L" profile of 30 x 20 x 1.3 mm and attach this to the profile T OMEGA.



4. Place specified double-side tape and adhesive on the "L" profile 30 x 20 mm.

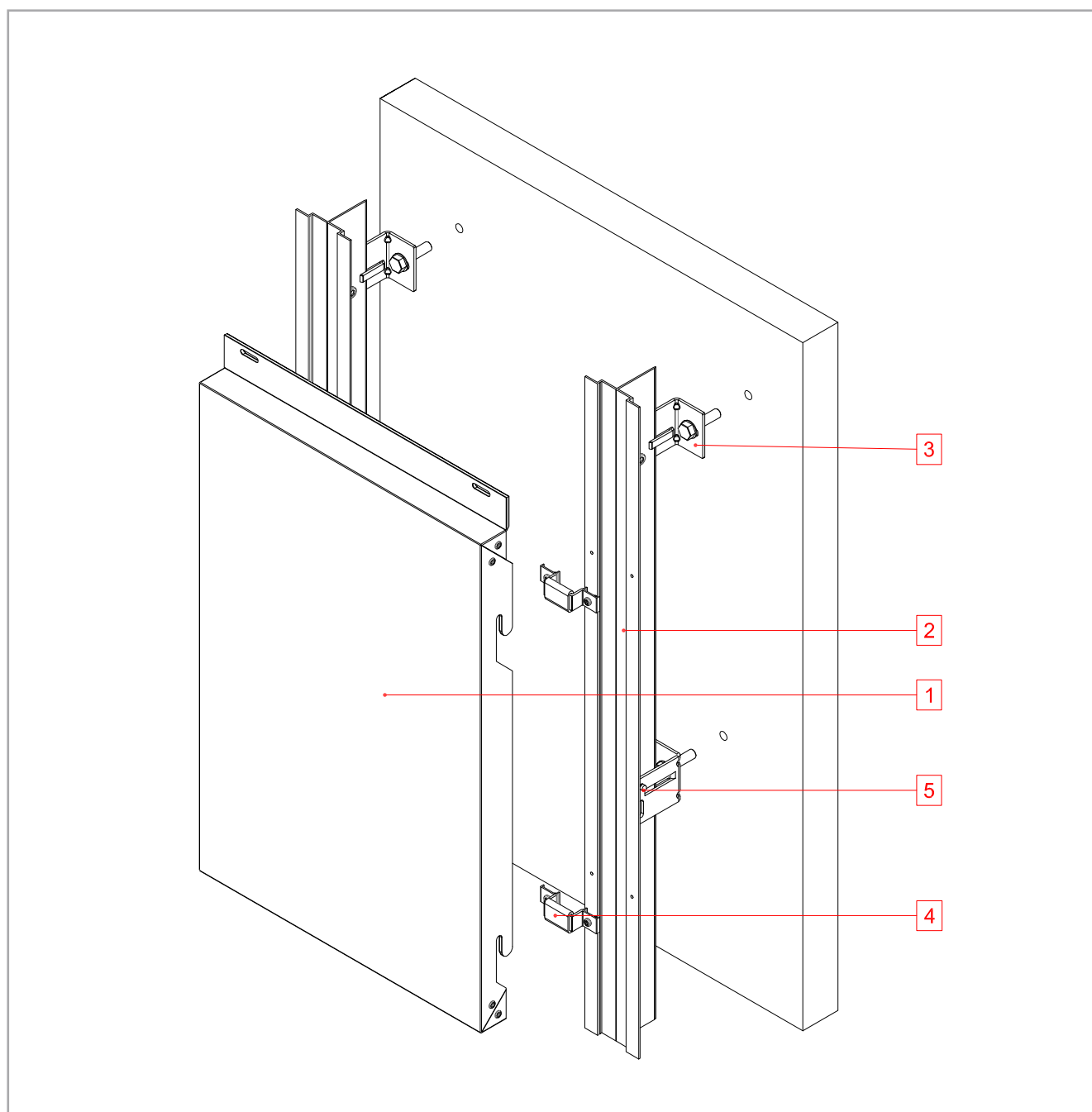


5. Fit the new **STACBOND®** composite panel cassette with special 9 mm hanging slot and hanging reinforcement pieces.



STB-T-CH SYSTEM

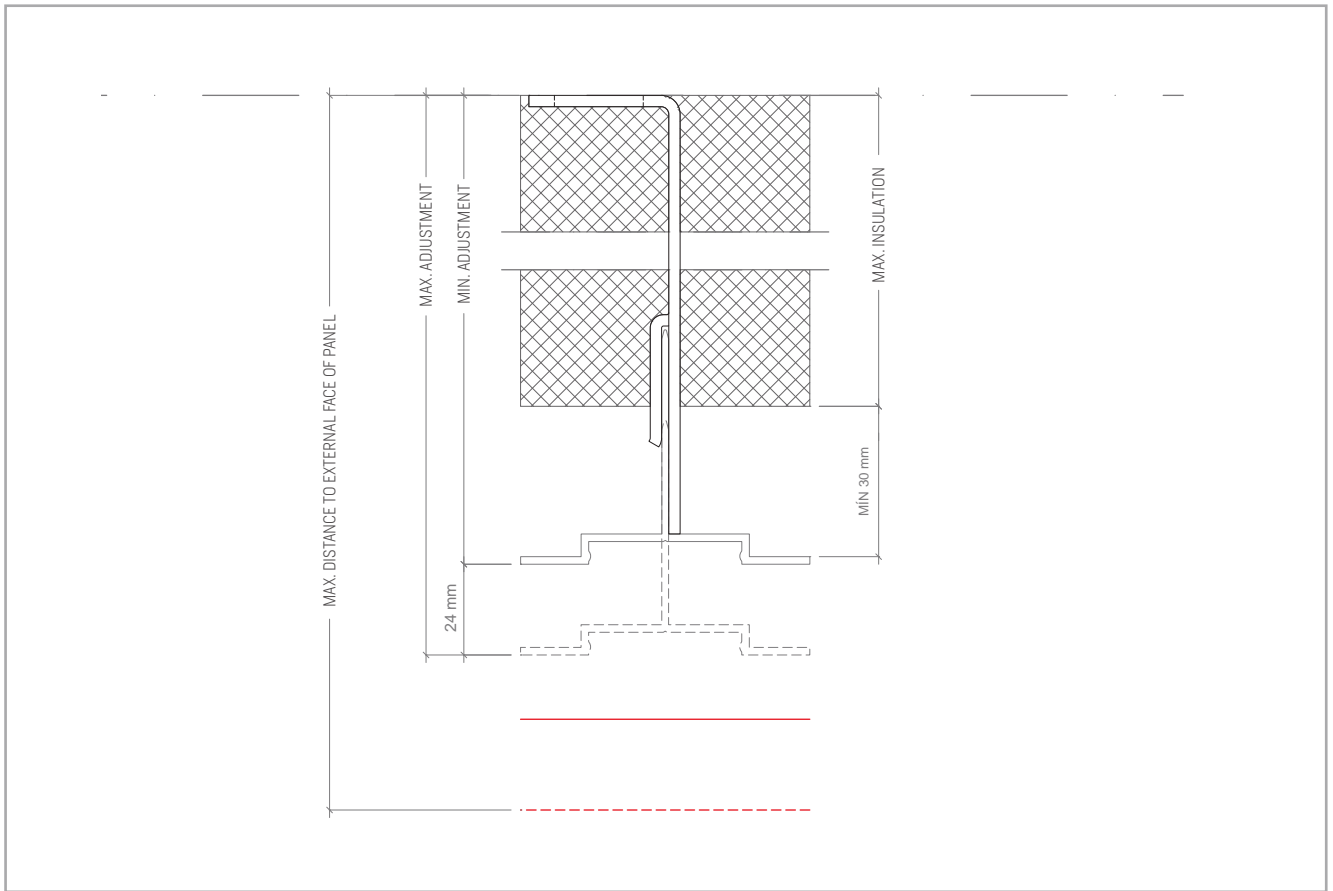
INSTALLATION DIAGRAM



N°	NAME
1	Cassette made from STACBOND® composite panel
2	Profile T OMEGA
3	Spacer L
4	Bracket set STB-T-CH hanging
5	Self-tapping screw

STB-T-CH SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER L * ST-1-55		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.041	SPACER L 68 ST-1-55	118	142	40
05.19.044	SPACER L 92 ST-1-55	142	166	80
05.19.051	SPACER L 116 ST-1-55	166	190	100
05.19.052	SPACER L 140 ST-1-55	190	214	120
05.19.053	SPACER L 164 ST-1-55	214	238	140
05.19.054	SPACER L 188 ST-1-55	238	262	160
05.19.055	SPACER L 212 ST-1-55	262	286	200
05.19.056	SPACER L 236 ST-1-55	286	310	220

SPACER L * ST-2-120		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.042	SPACER L 68 ST-2-120	118	142	40
05.19.045	SPACER L 92 ST-2-120	142	166	80

STB-T-CH SYSTEM

ACCESSORIES

PROFILES

REF.	PART	PAGE
05.19.061	PROFILE T OMEGA	106

SPACERS

REF.	PART	PAGE
05.19.041	SPACER L 68 ST-1-55	109
05.19.044	SPACER L 92 ST-1-55	
05.19.051	SPACER L 116 ST-1-55	
05.19.052	SPACER L 140 ST-1-55	
05.19.053	SPACER L 164 ST-1-55	
05.19.054	SPACER L 188 ST-1-55	
05.19.055	SPACER L 212 ST-1-55	
05.19.056	SPACER L 236 ST-1-55	
05.19.042	SPACER L 68 ST-2-120	
05.19.045	SPACER L 92 ST-2-120	

FASTENING ACCESSORIES

REF.	PART	PAGE
STB-R0300	BLIND RIVET POLYGRIP SFS ASO-D-48150 ALU/INOX 4,8X15	113


AUXILIARY ELEMENTS

REF.	PART	PAGE
05.19.062	BRACKET SET STB-T-CH HANGING	111
19.019	HANGING REINFORCEMENT	
05.19.050	CASSETTES FORMING PLATE	
05.19.025	STIFFENER SCH-1 (< 750 mm)	
05.19.026	STIFFENER SCH-2 (750 - 1500 mm)	
05.19.027	STIFFENER SCH-3 (> 1500 mm)	

INSULATION PLATES

REF.	PART	PAGE
05.19.070	3x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.066 / 05.19.068 / 05.19.072	115
05.19.066	INSULATING WEDGE FOR SPACERS L * ST-2-120 WITH REF.: 05.19.042 / 05.19.045	
05.19.068	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.053 / 05.19.054 / 05.19.055 / 05.19.056	
05.19.072	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.041 / 05.19.044 / 05.19.051 / 05.19.052	

INFORMATION AND SALES

 (+34) 981 817 036

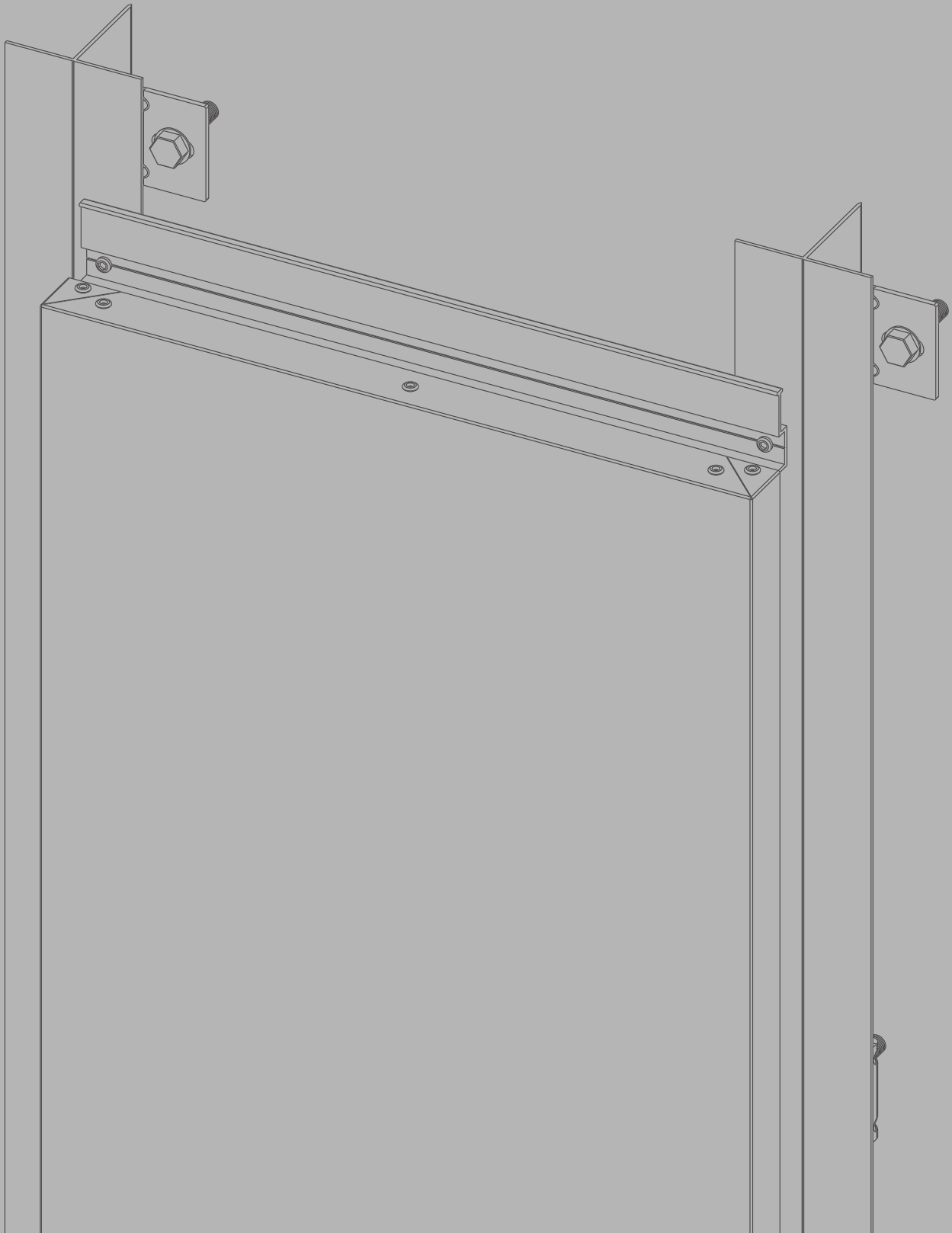
 (+34) 981 817 037

 stacbond@stac.es

 www.stac.es

STB-T-SZ

MALE-FEMALE SYSTEM



STB-T-SZ SYSTEM

DESCRIPTION



STB-T-SZ is a kit system based on cassettes made from **STACBOND® composite panels for installing ventilated facades**. It is a hidden male-female coupling system which is quick and easy to install. It was specially designed to develop facades with horizontal aspect of mainly solid wall with little surface area of openings or linear spaces.

The system comprises two 6063 T5 aluminium alloy profiles onto which the pre-formed cassettes are attached:

- Lower female profile, called **profile S**.
- Upper male profile, called **profile Z**.

The substructure employs **profiles T** and **spacers L** in 6063 T5 aluminium alloy.

The spacers come in various lengths to house the required thickness of thermal insulation and compensate any irregularities in the facade. For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the spacers L and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the T profiles as uprights.

The **STACBOND®** composite panel cassettes are mechanically attached to the uprights. The facade is constructed from the base up in a manner that the profile S of each upper cassette sits on the profile Z of the cassette below it. Mechanical anchoring is via screwing the profiles Z to the profile T.

To avoid vibration of the male-female cassettes and the profiles S and Z, protective EPDM gaskets are incorporated.

STAC® has developed a program for the specific calculations of the substructure with the criteria from the Technical approval Document (DIT plus 553p/16) established by the Instituto de Ciencias de la Construcción Eduardo Torroja for each project executed, defining the maximum distances between uprights and the number of fixings.

The **STB-T-SZ** system complies with all major international certifications.



ETA-ETE: 15/0655



Nº 553P/19



ITB - KOT 2017/0043





SPACERS L

1. Spacers L to fix the profile to the facade. The spacers L join the profile T to the vertical face or support wall and are used to overcome irregularities in the plumbness of the facade. They are either retaining or supporting. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.



PROFILES T

2. The profiles T are screwed to the spacers L. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings to the face must be placed at a maximum of 250 mm from the ends of the profile.



BASE PROFILE Z

3. Profile S and profile Z. These profiles longitudinally strengthen the cassette in both its upper and lower parts. The profile Z is fitted in the upper part and has a EPDM adhesive strip which surrounds the vertical wing of the profile to absorb possible spaces between the male and female parts to avoid noise caused by vibration. These profiles are attached to the cassettes using rivets.



STACBOND COMPOSITE PANEL CASSETTE

4. STACBOND® composite panel cassette. Once the cassette has been formed with the profile Z in the upper part and the profile S in the lower part, it is set up to the facade. Cladding is performed from the bottom row up in a manner so that each cassette rests on the one below and is mechanically fastened in the upper part by screwing the profile Z to the upright profile T.

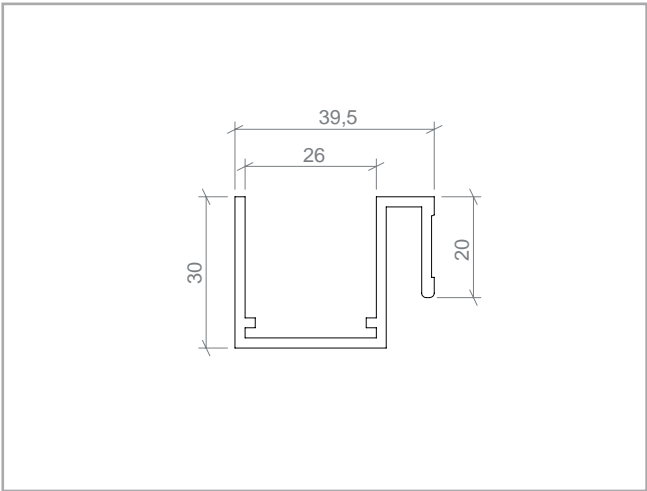
STB-T-SZ SYSTEM

AUXILIARY ELEMENTS

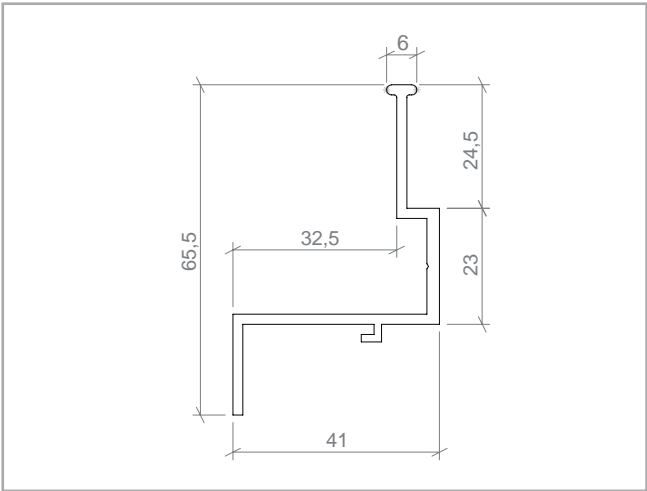
PROFILE S AND PROFILE Z



PROFILE S



PROFILE Z



Measurements in mm

REINFORCEMENT STB-T-SZ



The reinforcement STB-T-SZ is a segment of profile of 200 mm specific length, covers the internal distance between the SZ cassette and the substructure.
This part is attached to the substructure profile with screws.

EPDM GASKET PROFILE SZ



We provide a EPDM protection gasket to place between the two profiles and absorb any slack.

REFERENCE	DESCRIPTION	UNITS/BOX
05.19.001	PROFILE S	24
05.19.002	PROFILE Z	18
05.19.049	REINFORCEMENT STB-T-SZ	180
STB-JEPDM	EPDM GASKET PROFILE SZ (m.l.)	-

USING THE EPDM GASKET PROFILE SZ



The segments of EPDM gasket must be placed on the head of the profile Z and wrapped around to cover both sides. The recommended size of these strips is 60 mm.



The recommended maximum distance between segments is 500 mm. Using this accessory eliminates possible vibrations between the panels and allows them to be adjusted to ensure flatness of the facade.

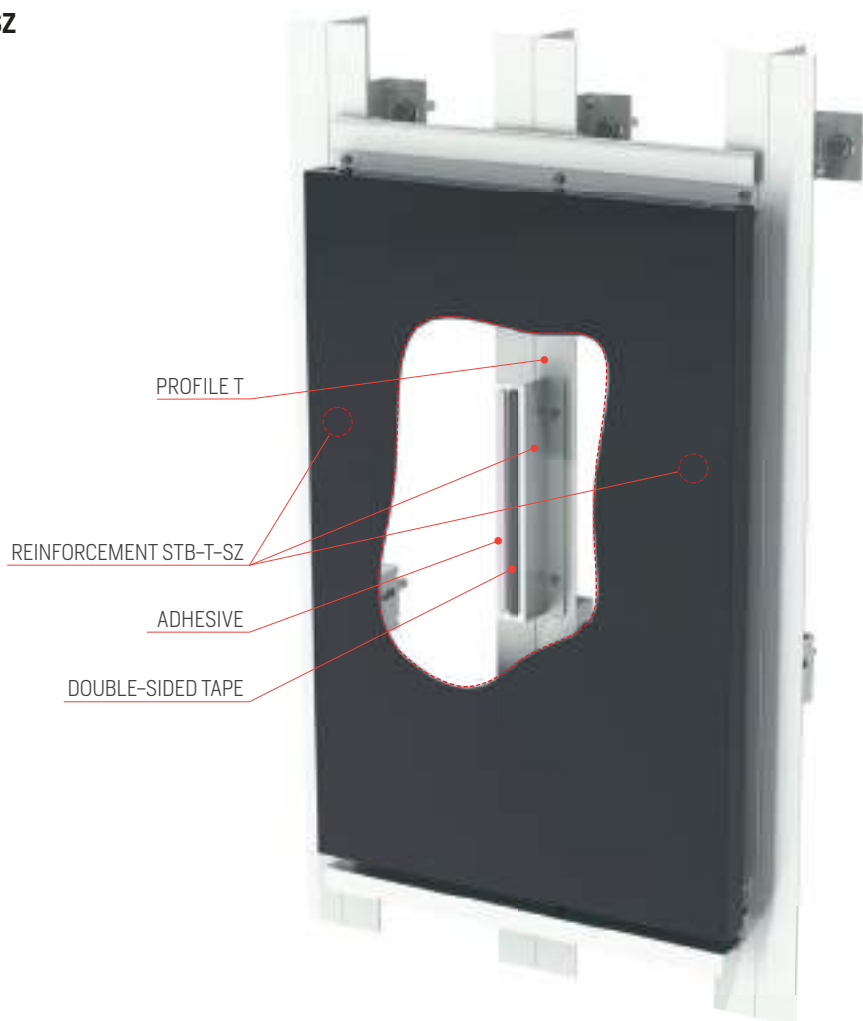
USING THE REINFORCEMENT STB-T-SZ

The use of the STB-T-SZ reinforcement depends on the height of the tray and the wind load of the project site. For more detailed information please consult **STAC®**.

It must be used on each of the upright profiles T that support the composite panel cassette.

The reinforcement is mechanically attached to the front face of the profile and special adhesive and double-sided adhesive tape is applied.

The cassette is then fitted and fixed using rivets in the upper profile Z.



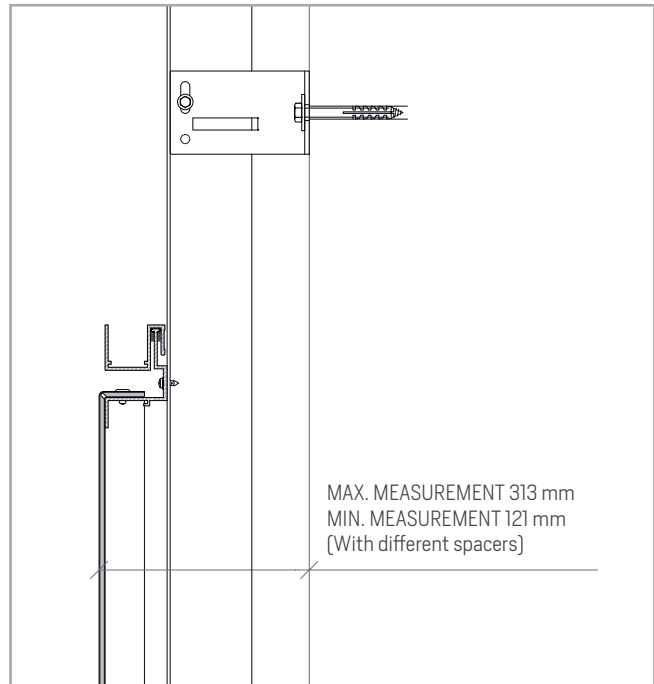
STB-T-SZ SYSTEM

INSTALLING SZ CASSETTE

UPPER FIXING



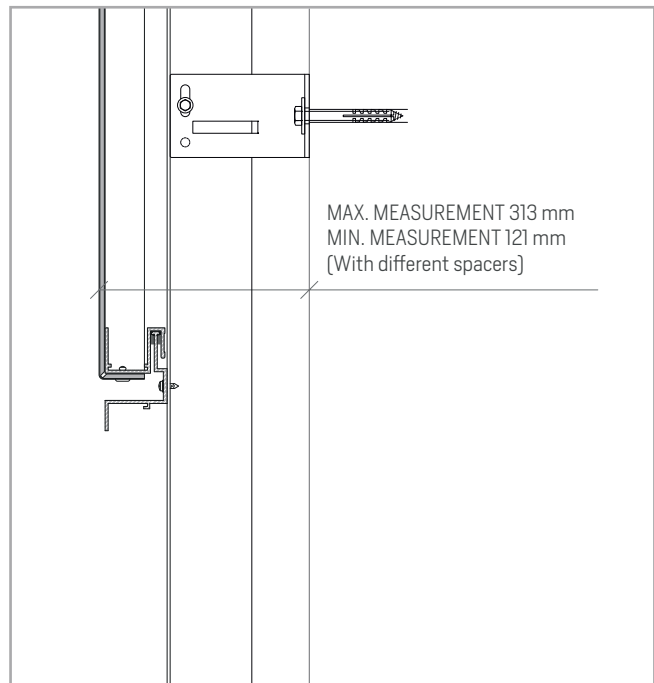
VERTICAL CROSS-SECTION



LOWER FIXING



VERTICAL CROSS-SECTION

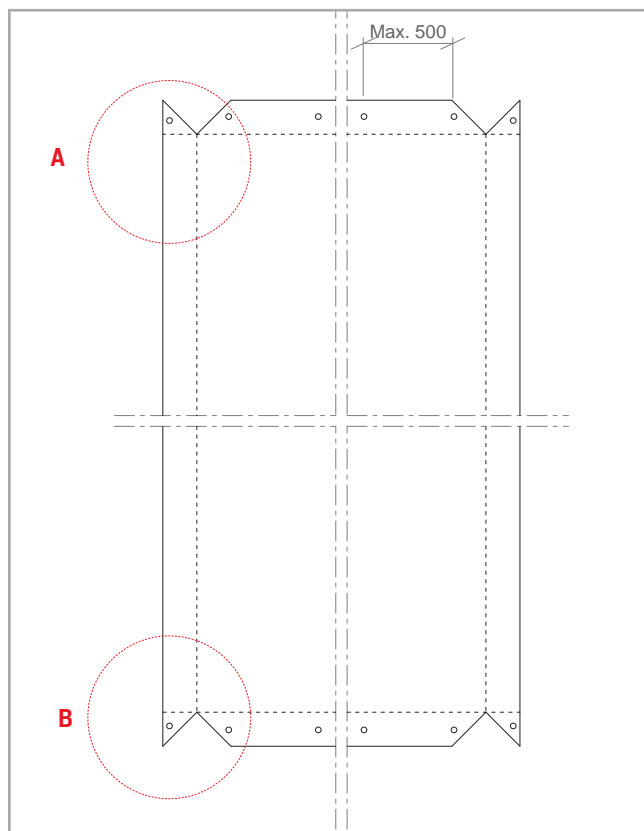


Note: The machined **STACBOND®** panels are supplied flat. The client is responsible for forming them into cassettes. No specialist machinery is required.

FORMED CASSETTE

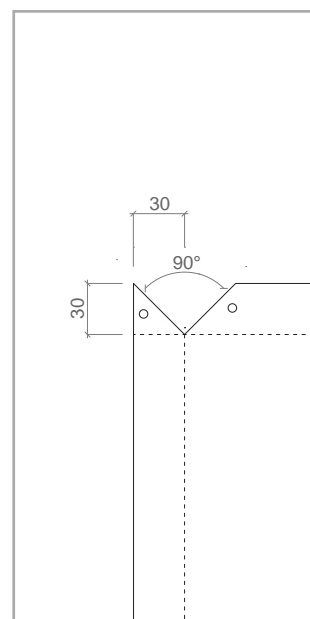
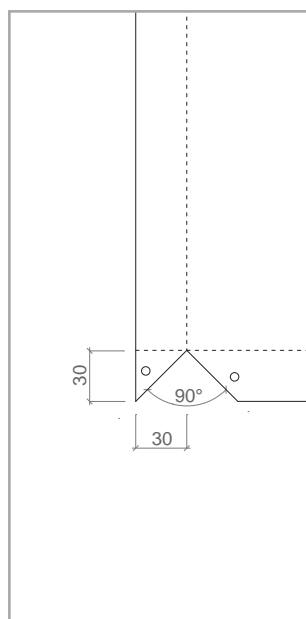


FLAT CASSETTE



DETAIL A

DETAIL B



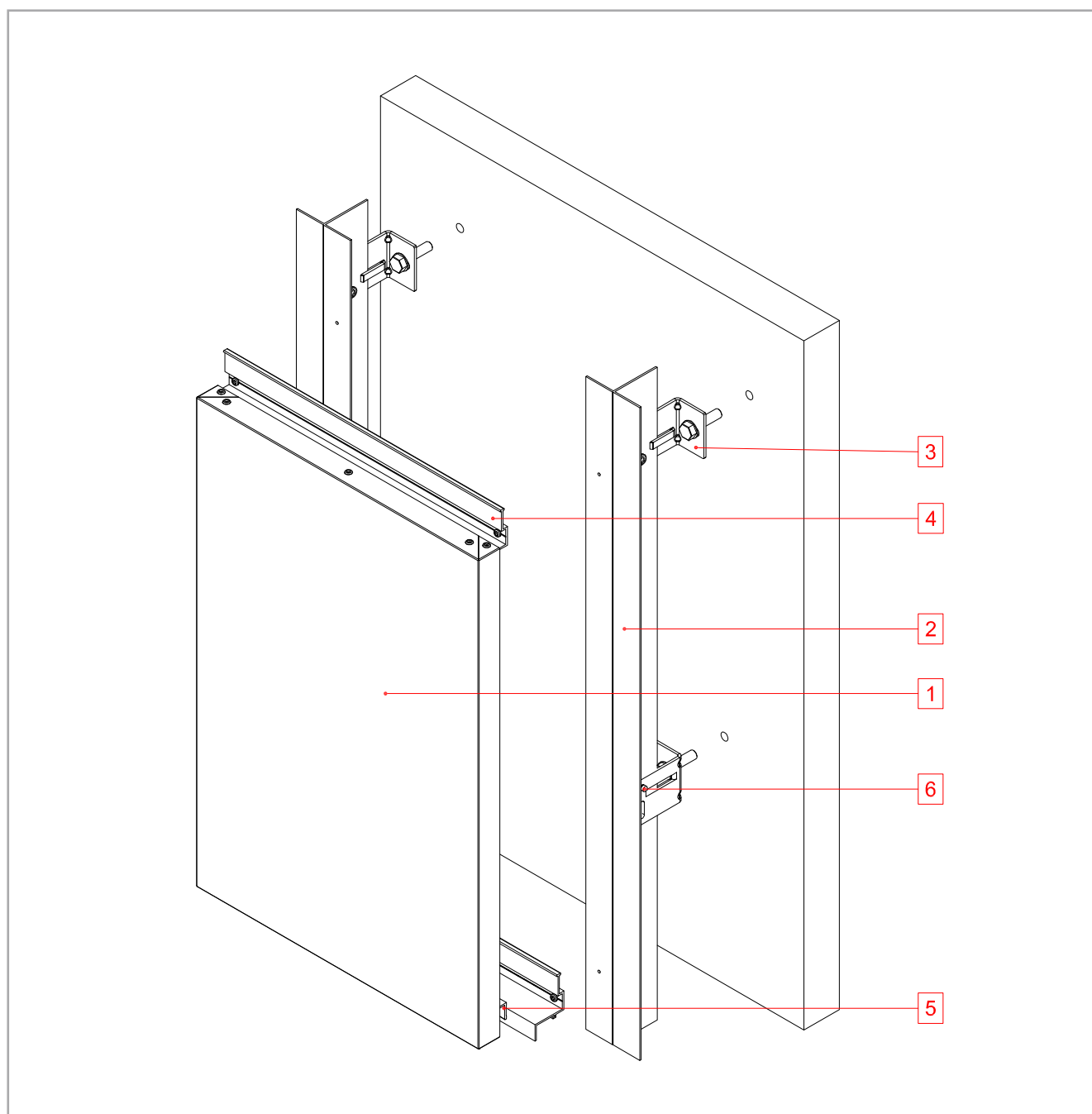
Measurements in mm

The standard cassettes in the STB-T-SZ system have 30 mm flaps. To form the cassettes, they are mechanically fastened via rivets directly to the longitudinal profiles S and Z.

The profile Z is attached in the lower part and the profile S in the upper part of the cassette. These profiles provide the cassettes with great longitudinal rigidity.

STB-T-SZ SYSTEM

INSTALLATION DIAGRAM

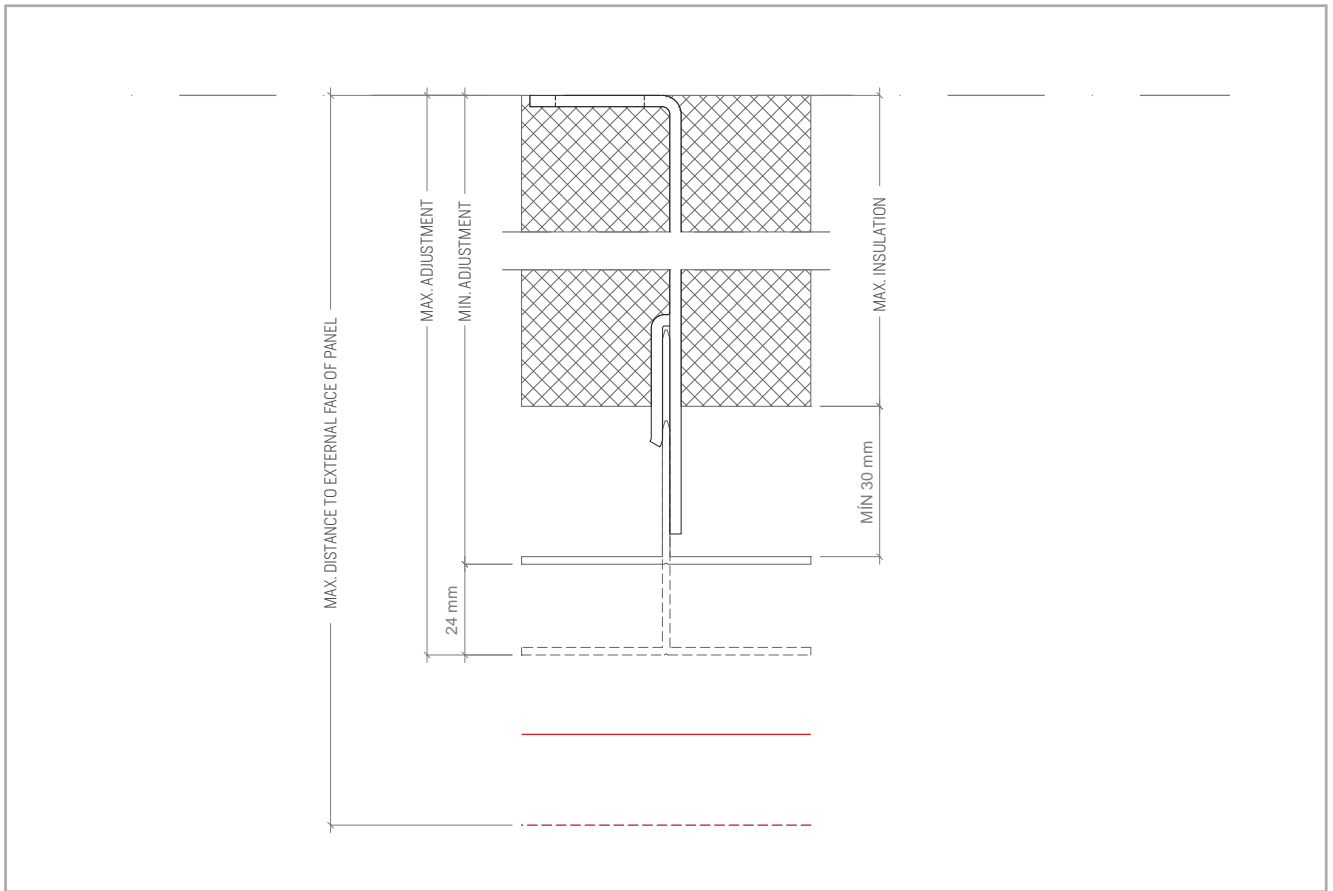


N°	NAME
----	------

- | | |
|---|--|
| 1 | Cassette made from STACBOND® composite panel |
| 2 | Profile T |
| 3 | Spacer L |
| 4 | Profile Z |
| 5 | Profile S |
| 6 | Self-tapping screw |

STB-T-SZ SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER L * ST-1-55		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.041	SPACER L 68 ST-1-55	121	145	40
05.19.044	SPACER L 92 ST-1-55	145	169	80
05.19.051	SPACER L 116 ST-1-55	169	193	100
05.19.052	SPACER L 140 ST-1-55	193	217	120
05.19.053	SPACER L 164 ST-1-55	217	241	140
05.19.054	SPACER L 188 ST-1-55	241	265	160
05.19.055	SPACER L 212 ST-1-55	265	289	200
05.19.056	SPACER L 236 ST-1-55	289	313	220

SPACER L * ST-2-120		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.042	SPACER L 68 ST-2-120	121	145	40
05.19.045	SPACER L 92 ST-2-120	145	169	80

STB-T-SZ SYSTEM

ACCESSORIES

PROFILES

REF.	PART	PAGE
05.19.043	PROFILE T	106
05.19.001	PROFILE S	107
05.19.002	PROFILE Z	
05.19.074	PROFILE Z 20	
05.19.063	PROFILE Z 24	

SPACERS

REF.	PART	PAGE
05.19.041	SPACER L 68 ST-1-55	109
05.19.044	SPACER L 92 ST-1-55	
05.19.051	SPACER L 116 ST-1-55	
05.19.052	SPACER L 140 ST-1-55	
05.19.053	SPACER L 164 ST-1-55	
05.19.054	SPACER L 188 ST-1-55	
05.19.055	SPACER L 212 ST-1-55	
05.19.056	SPACER L 236 ST-1-55	
05.19.042	SPACER L 68 ST-2-120	
05.19.045	SPACER L 92 ST-2-120	

AUXILIARY ELEMENTS

REF.	PART	PAGE
05.19.049	REINFORCEMENT STB-T-SZ	110
STB-JEPDM	EPDM GASKET PROFILE SZ (m.l.)	


FASTENING ACCESSORIES

REF.	PART	PAGE
STB-R0300	BLIND RIVET POLYGRIP SFS ASO-D-48150 ALU/INOX 4,8X15	113

INSULATING WEDGES

REF.	PART	PAGE
05.19.070	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.066 / 05.19.068 / 05.19.072	115
05.19.066	INSULATING WEDGE FOR SPACERS L * ST-2-120 WITH REF.: 05.19.042 / 05.19.045	
05.19.068	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.053 / 05.19.054 / 05.19.055 / 05.19.056	
05.19.072	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.041 / 05.19.044 / 05.19.051 / 05.19.052	

INFORMATION AND SALES

 (+34) 981 817 036

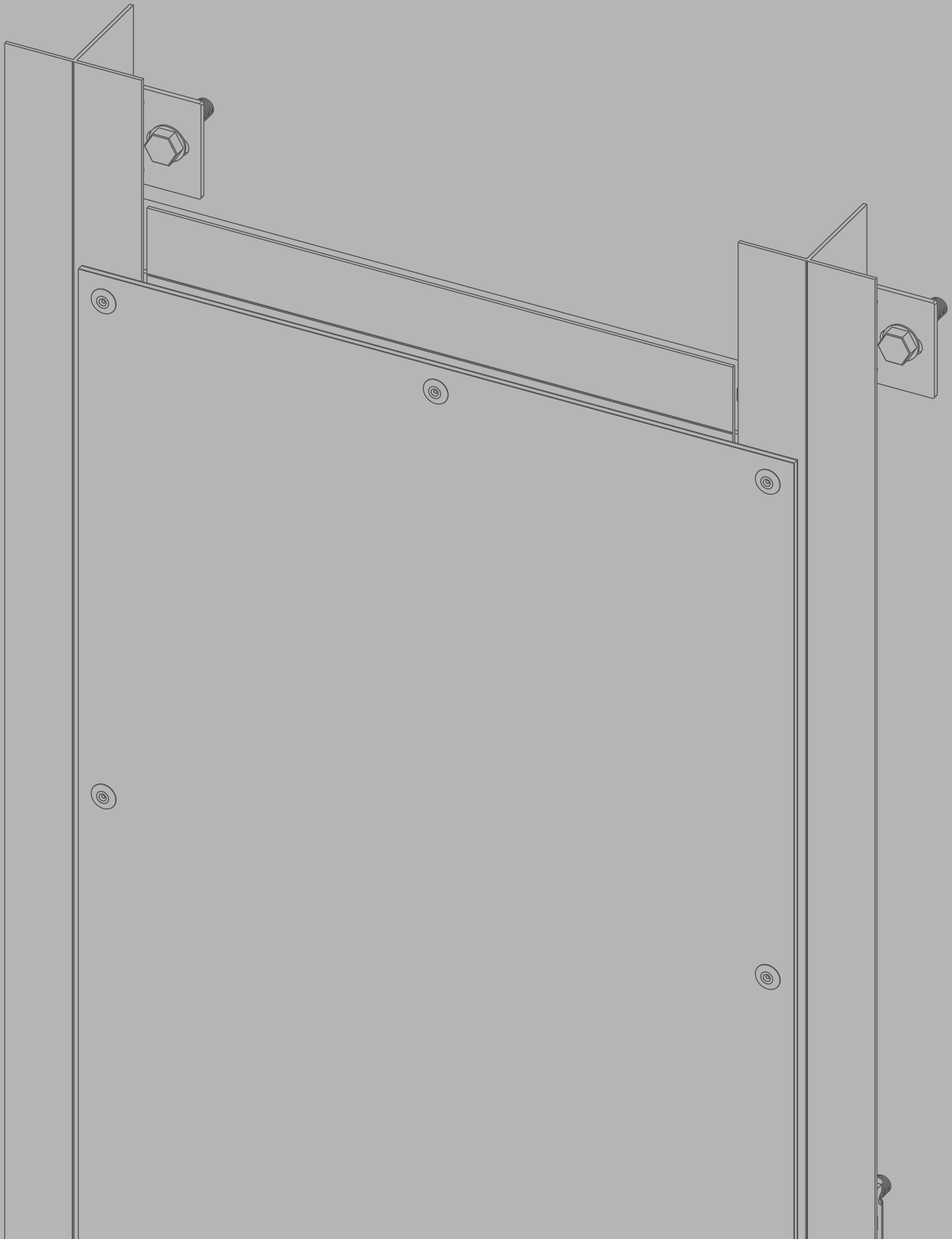
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STB-T-REM

RIVETED SYSTEM



STB-T-REM SYSTEM

DESCRIPTION



STB-T-REM is a kit system based on flat panels made from **STACBOND® composite panels for installing ventilated facades**. It is a system with visible fixings which is quick to install and which allows both horizontal and vertical assembly. It is a very versatile system which perfectly suits any architectural layout and offers the possibility to easily cover curving sections. The **STB-T-REM** system therefore complies with all the requirements to be employed in the most demanding architectural claddings.

The substructure employs **profiles T** and **spacers L** in 6063 T5 aluminium alloy.

The spacers come in various lengths to house the required thickness of thermal insulation and compensate any irregularities in the facade. For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the spacers L and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the profiles T as uprights.

The **STB-T-REM** system can be mounted on a unidirectional or bidirectional substructure. With a unidirectional substructure, the horizontal joint remains open. In the case of the bidirectional substructure, horizontal struts are attached to the uprights using **spacers angular** made of 6063 T5, or to the vertical face using spacers L.

This substructure with vertical and / or horizontal T profiles support the **STACBOND®** composite panel sheets which are riveted at their edges.

STAC® has developed a program for the specific calculations of the substructure with the criteria from the Technical approval Document (DIT plus 553p/16) established by the Instituto de Ciencias de la Construcción Eduardo Torroja for each project executed, defining the maximum distances between uprights and the number of fixings.

The **STB-T-REM** system complies with all major international certifications.



ETA-ETE: 15/0655



Nº 553P/189

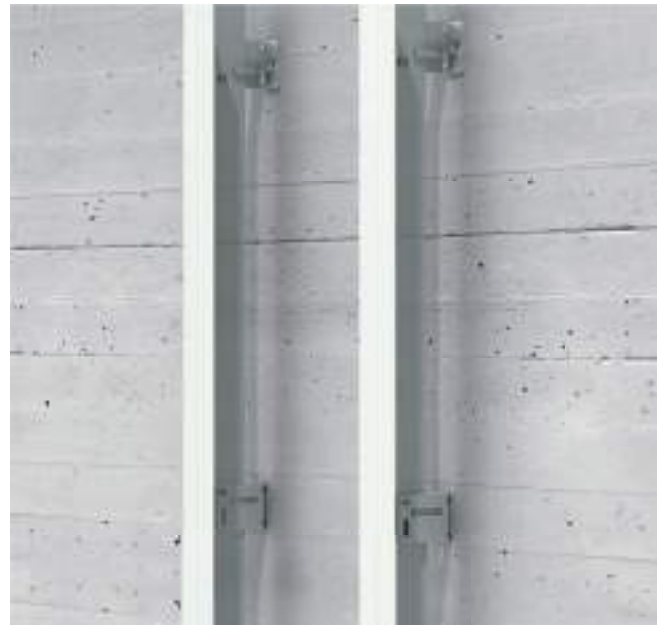


ITB - KOT 2017/0043





SPACERS L



PROFILES T

1. Spacers L to fix the profile to the facade. The spacers L join the profile T to the vertical face or support wall and are used to overcome irregularities in the plumbness of the facade. They are either retaining or supporting. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.

2. The profiles T are screwed to the spacers L. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings to the face must be placed at a maximum of 250 mm from the ends of the profile.



HORIZONTAL PROFILES T



ATTACHING STACBOND COMPOSITE PANEL

3. Horizontal cross-struts (optional). These profiles are mechanically fixed to the vertical substructure using the **spacers angular**, or to the base wall using spacers L. The possibility of creating a bidirectional substructure allows the system to adapt to the requirements of the facade.

4. Attaching STACBOND® composite panel. Once the substructure is in place, the **STACBOND®** panels are attached to it using rivets. Attention should be paid to the condition and type of rivet to ensure correct dilation of the panels.

STB-T-REM SYSTEM

AUXILIARY ELEMENTS

SPACER ANGULAR

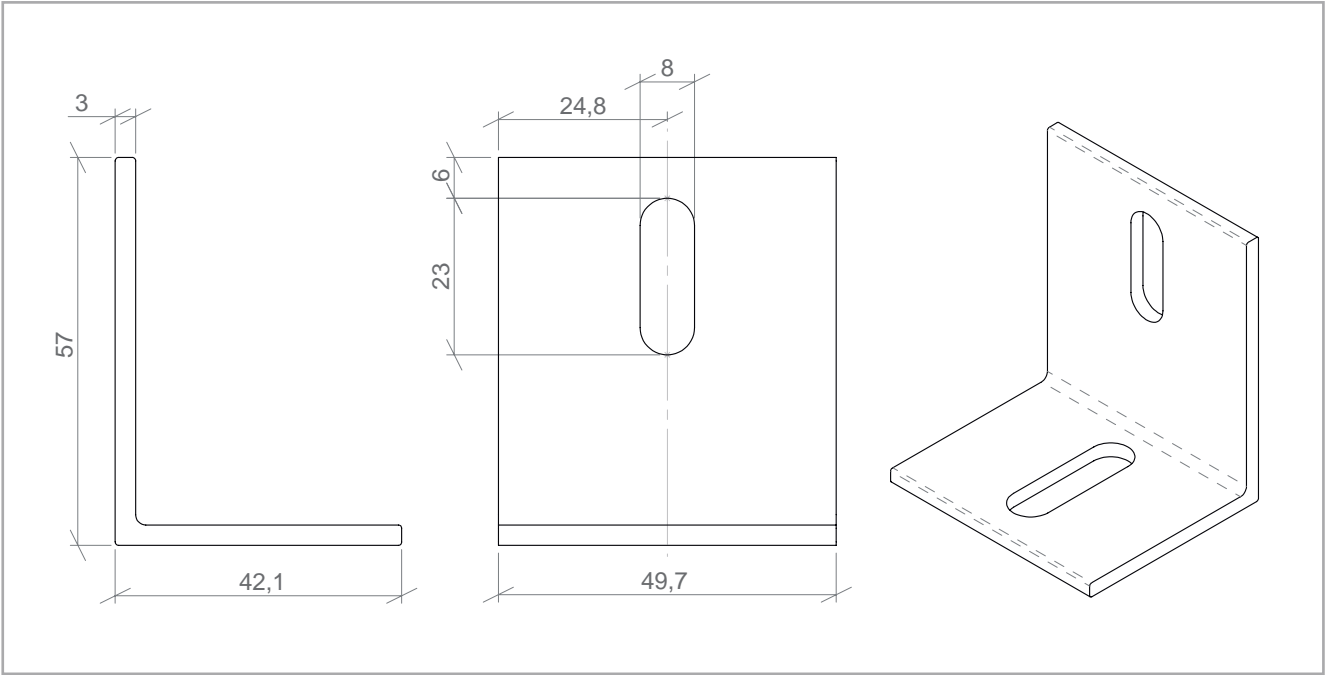
Part made of extruded 6063 T5 aluminium alloy profile (3 mm) with holes for fixing to the upright and cross-strut profiles T.

This accessory allows profiles T to be attached horizontally to the vertical substructure, reducing the number of fixings to the base wall.

Fixing of these spacers is done using \varnothing 4.8 mm blind rivets or \varnothing 4.8 mm self-tapping screws. These coupling parts are compatible with possible dilation of the substructure.



REFERENCE	DESCRIPTION	UNITS/BOX
19.021	SPACER ANGULAR	100



Measurements in mm

STB-T-REM SYSTEM

TYPE AND DISTRIBUTION OF PERFORATIONS

DILATION OF THE PANEL

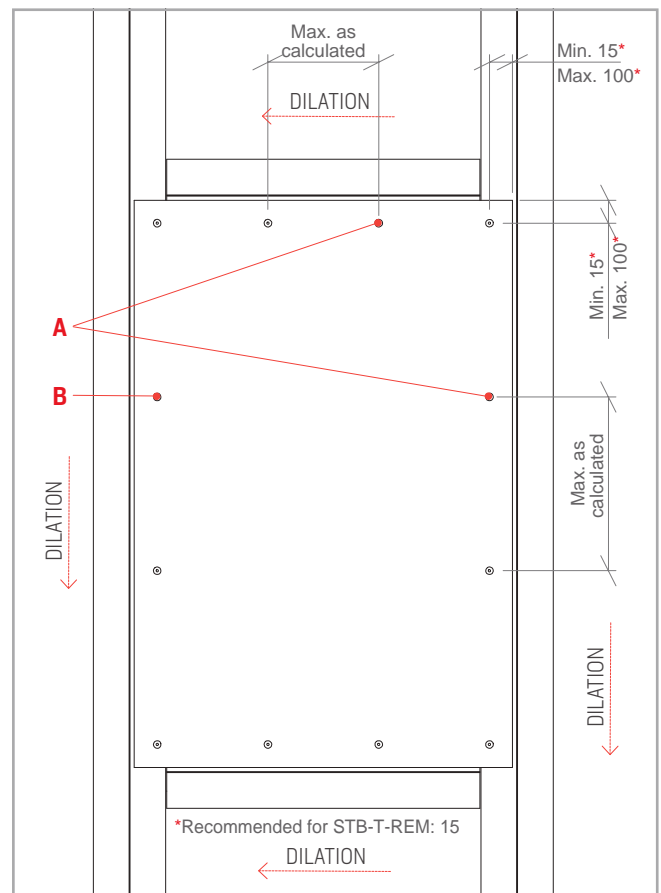
The diagram shows the layout and max. distance of the holes in the **STACBOND®** composite panel.

The panels are set in place by drilling and inserting the corresponding rivet, respecting the difference between the diameter of the drill and the shank of the rivet and also the distances between rivets and the edge of the panel.

To allow movement of the panel and to avoid problems from dilation, it is important to centre the drill holes on the substructure. This allows equal dilation in all directions and does not limit movement. We recommend the use of **centring gauges** to ensure correct hole placement and fixing of rivets.

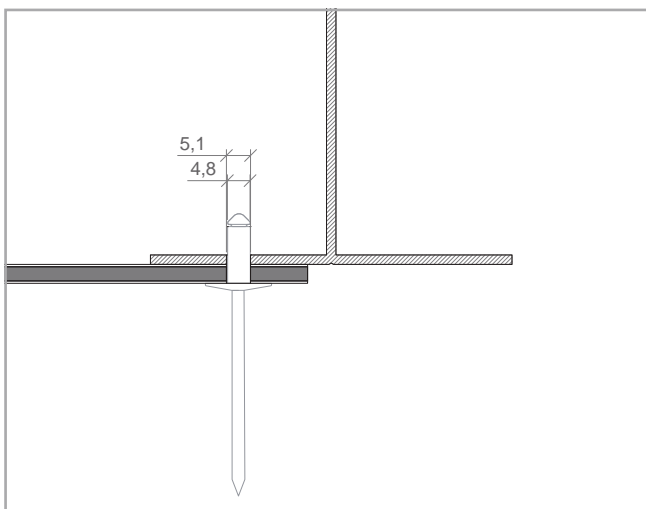
Furthermore, to allow movement in the floating fixing points, it is important to control the rivet clinch strength. We recommend the use of a **spacing nosepiece** which leaves a 0.2 mm gap between the sheet and the fixing, avoiding immobilising fixing points which should be floating.

Rivets and screws specified by **STAC®** should be used.



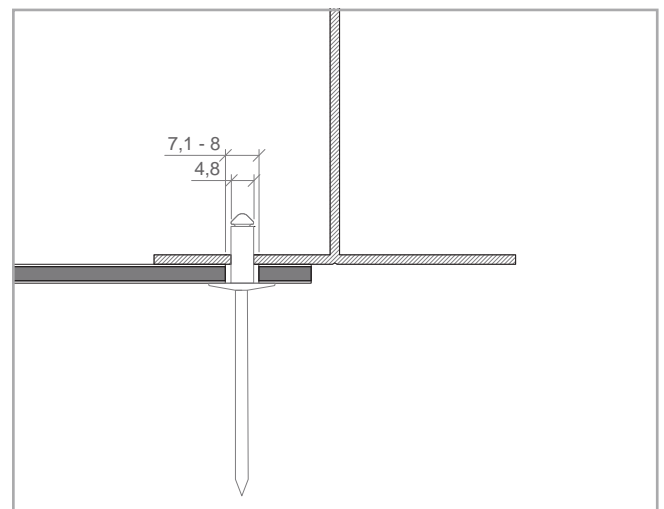
Note: other rivets and screws may be used providing that their mechanical characteristics are equal or greater than those specified by **STAC®**.

A. FIXED ANCHORING POINTS



The 5.1 mm hole drilled in the **STACBOND®** composite panel defines the origin of the panel's dilation.

B. MOBILE ANCHORING POINTS

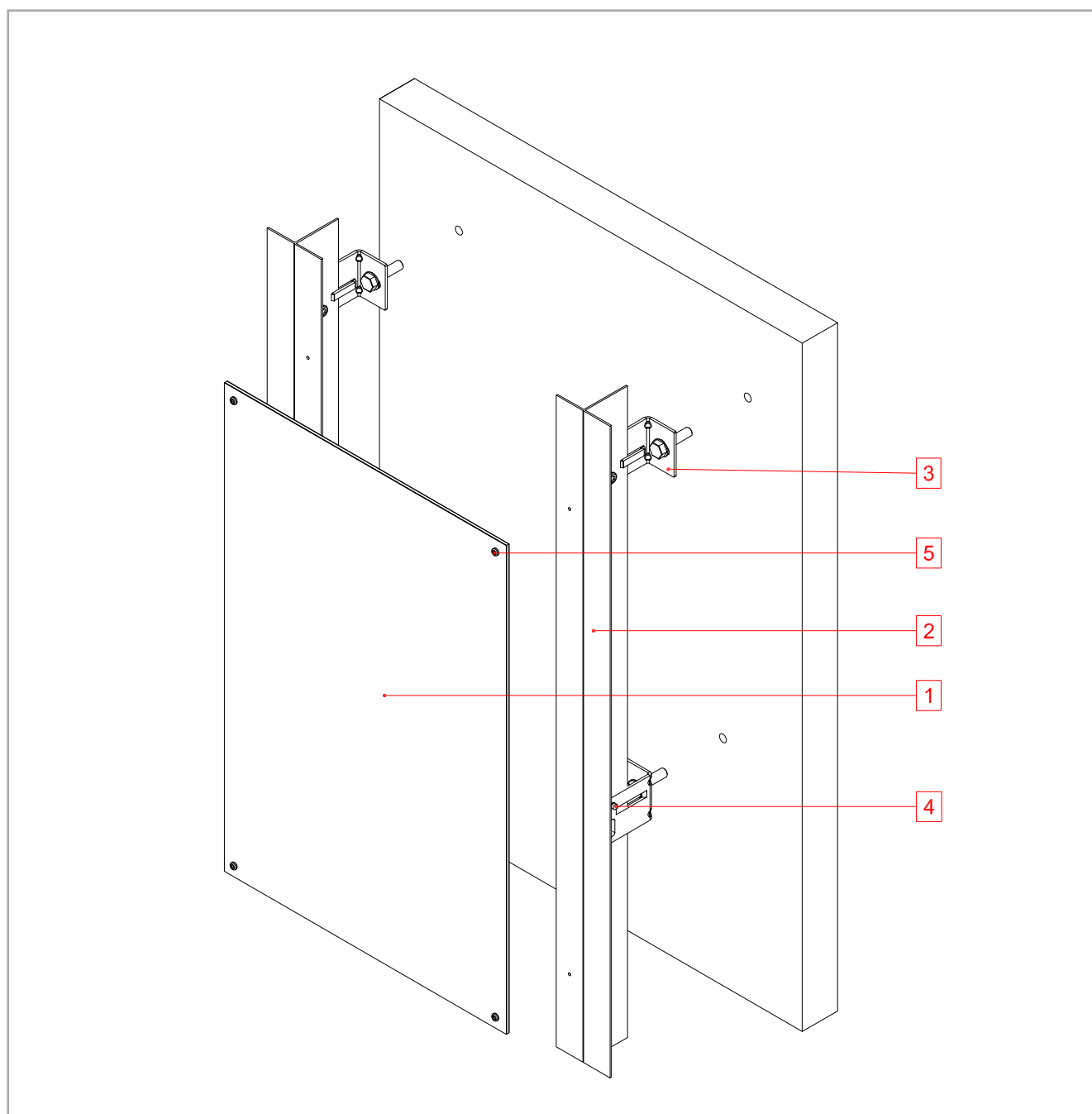


The larger diameter hole drilled in the **STACBOND®** composite panel allows dilation to be absorbed.

Measurements in mm

STB-T-REM SYSTEM

INSTALLATION DIAGRAM

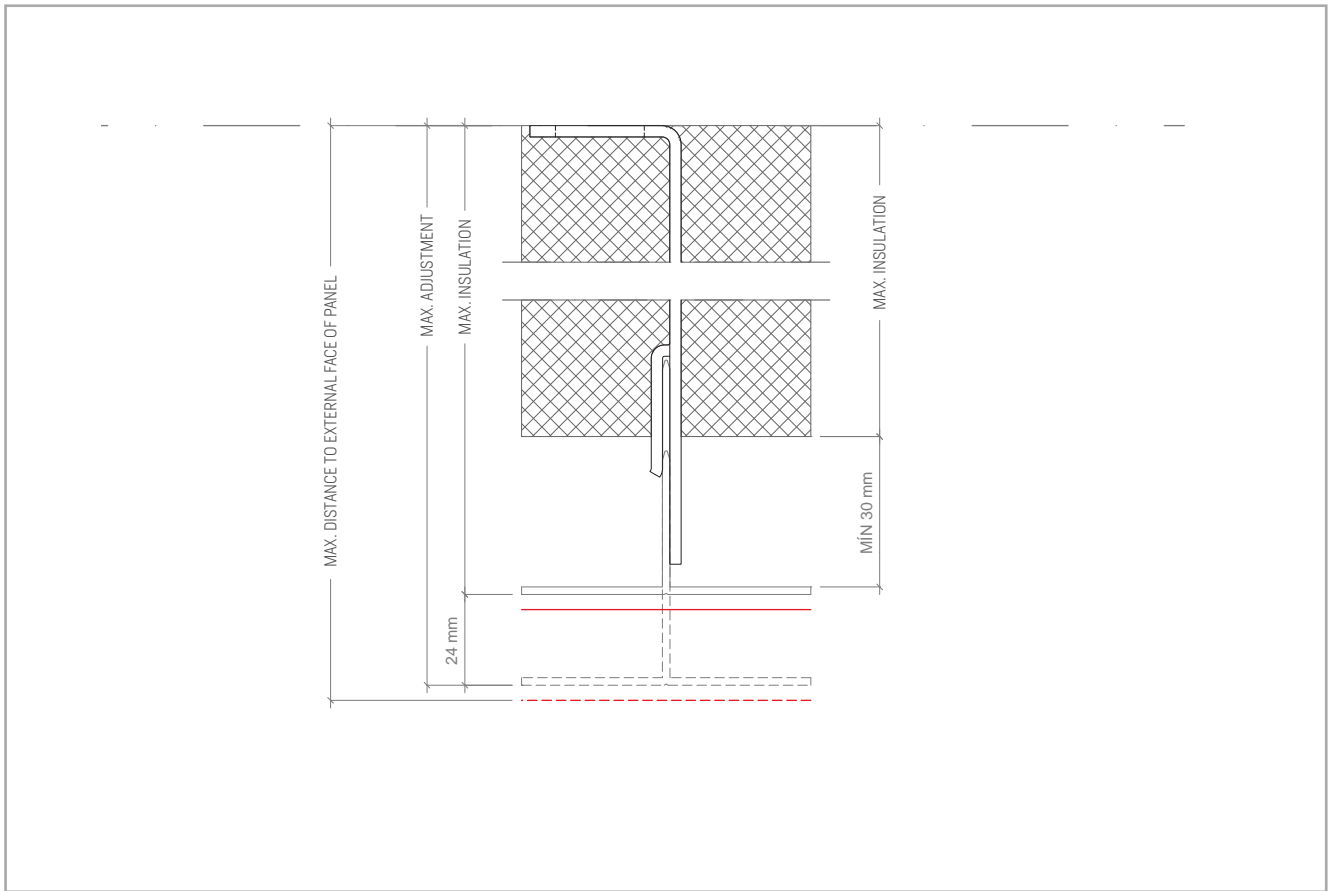


N°	NAME
----	------

- | | |
|---|---------------------------|
| 1 | STACBOND® composite panel |
| 2 | Profile T |
| 3 | Spacer L |
| 4 | Self-tapping screw |
| 5 | Blind rivet |

STB-T-REM SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER L * ST-1-55		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.041	SPACER L 68 ST-1-55	80	104	40
05.19.044	SPACER L 92 ST-1-55	104	128	80
05.19.051	SPACER L 116 ST-1-55	128	152	100
05.19.052	SPACER L 140 ST-1-55	152	176	120
05.19.053	SPACER L 164 ST-1-55	176	200	140
05.19.054	SPACER L 188 ST-1-55	200	224	160
05.19.055	SPACER L 212 ST-1-55	224	248	200
05.19.056	SPACER L 236 ST-1-55	248	272	220

SPACER L * ST-2-120		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.042	SPACER L 68 ST-2-120	80	104	40
05.19.045	SPACER L 92 ST-2-120	104	128	80

STB-T-REM SYSTEM

ACCESSORIES

PROFILES

REF.	PART	PAGE
05.19.043	PROFILE T	106

FASTENING ACCESSORIES

REF.	PART	PAGE
STB-FIJA-201	RIVETER NOSEPIECE (RIVETS SSO-D15)	112
STB-FIJA-202	RIVETER NOSEPIECE (RIVETS AP)	
STB-FIJA-203	DUAL DIA. DRILL BIT (HSS-7,0/5,1x74)	
STB-FIJA-204	DEPTH LOCATOR 16x18	
STB-FIJA-205	CENTRING GAUGE (DG-146x20-7.0)	
STB-FIJA-206	REPLACEMENT NOSE PIECE FOR CENTRING GAUGE ø 6.9 mm	113
STB-FIJA-207	SPECIAL BIT FOR THE CENTRING GAUGE (HS-5.1x62/26)	
STB-FIJA-208	DRIVER BIT T20WW-25-HEX1/4"	
STB-FIJA-209	MANUAL CENTRING GAUGE FOR SCREWS SLA3	
STB-FIJA-210	SOCKET IRIUS G-00106.07	
STB-T0100	SECURITY SCREW 4.8x19 INOX HEAD TORX SLA3/6-S-D12-4.8x19	113
STB-R0100	BLIND RIVET ISO 15977 D5x12 CAB. 14 mm ALU/INOX AP14-S-5,.0x12	
STB-R0200	FACADE RIVET HEAD 15 mm INOX/INOX A4 5x14 SSO-D15-50140	

SPACERS

REF.	PART	PAGE
19.041	SPACER L 68 ST-1-55	109
05.19.044	SPACER L 92 ST-1-55	
05.19.051	SPACER L 116 ST-1-55	
05.19.052	SPACER L 140 ST-1-55	
05.19.053	SPACER L 164 ST-1-55	
05.19.054	SPACER L 188 ST-1-55	
05.19.055	SPACER L 212 ST-1-55	
05.19.056	SPACER L 236 ST-1-55	
05.19.042	SPACER L 68 ST-2-120	
05.19.045	SPACER L 92 ST-2-120	

AUXILIARY ELEMENTS

REF.	PART	PAGE
19.021	SPACER ANGULAR	110

INSULATING WEDGES

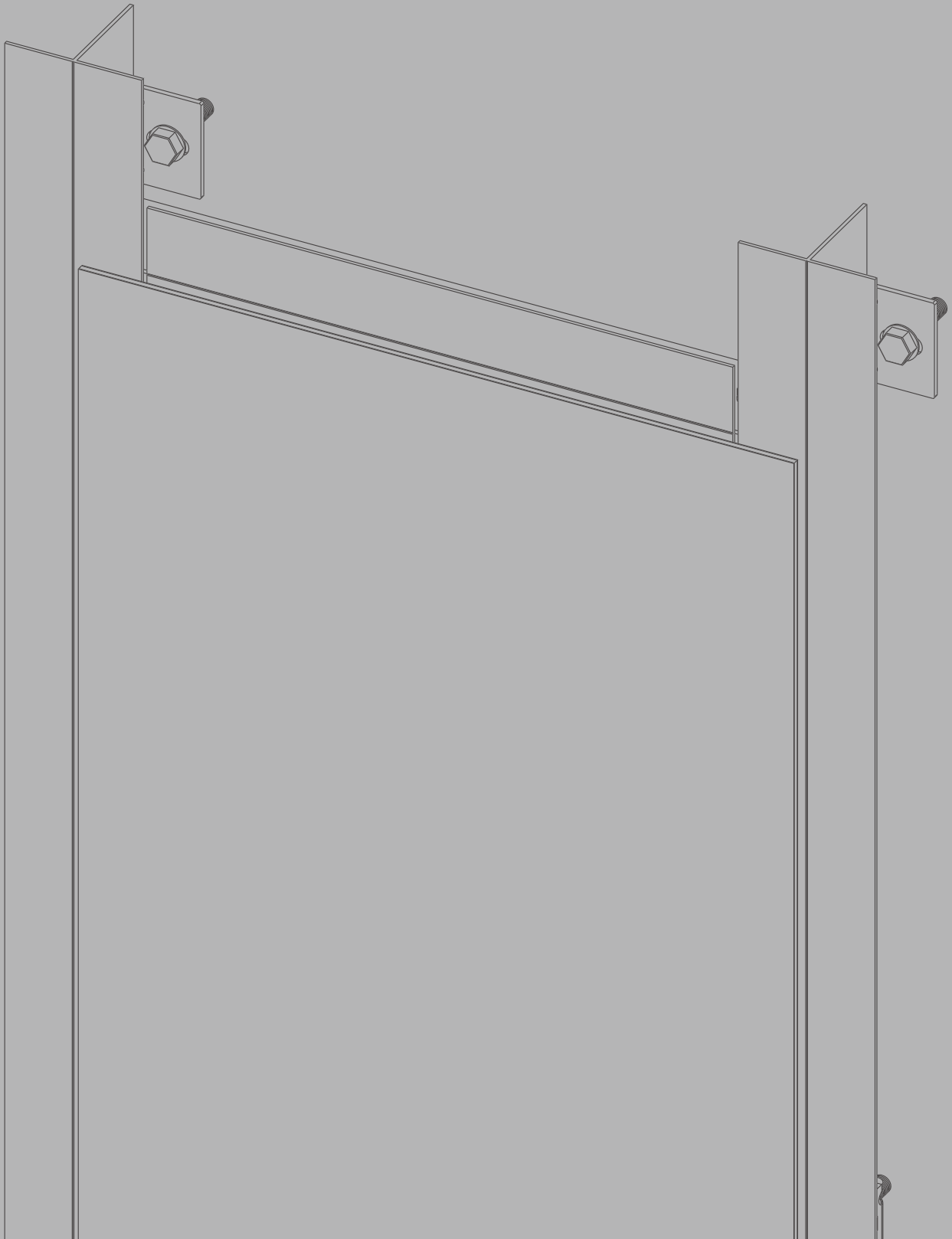
REF.	PART	PAGE
05.19.070	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.066 / 05.19.068 / 05.19.072	115
05.19.066	INSULATING WEDGE FOR SPACERS L * ST-2-120 WITH REF.: 05.19.042 / 05.19.045	
05.19.068	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.053 / 05.19.054 / 05.19.055 / 05.19.056	
05.19.072	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.041 / 05.19.044 / 05.19.051 / 05.19.052	

INFORMATION AND SALES

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STB-T-PEG

GLUED SYSTEM



STB-T-PEG SYSTEM

DESCRIPTION



STB-T-PEG is a kit system based on flat panels made from **STACBOND® composite panel for installing ventilated facades**. It is a system with hidden fixings which is quick and economic to install and which allows both horizontal and vertical assembly.

As this is a glued system with chemical anchoring, it is resistant to aging and weathering; it absorbs vibration and allows numerous possibilities in facade design.

The substructure employs **profiles T** and **spacers L** in 6063 T5 aluminium alloy.

For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the spacers L and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the T profiles as uprights.

The **STB-T-PEG** system can be mounted on a unidirectional or bidirectional substructure. With a unidirectional substructure, the horizontal joint remains open. In the case of the bidirectional substructure, horizontal struts are attached to the uprights using **spacers angular** made of 6063 T5, or to the vertical face using spacers L.

STACBOND® composite panels are attached to the substructure consisting of vertical and (where used) horizontal profiles using a specific adhesive and double-sided adhesive tape, in accordance with the manufacturer's instructions.

STAC® has developed a program for the specific calculations of the substructure for each project executed, defining the maximum distances between uprights.



SPACERS L



PROFILES T

1. Spacers L to fix the profile to the facade. The spacers L join the profile T to the vertical face or support wall and are used to overcome irregularities in the plumbness of the facade. They are either retaining or supporting. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.

2. The profiles T are screwed to the spacers L. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings to the face must be placed at a maximum of 250 mm from the ends of the profile.



HORIZONTAL PROFILES T

3. Horizontal cross-struts (optional). These profiles are mechanically fixed to the vertical substructure using the **spacers angular**, or to the base wall using spacers L. The possibility of creating a bidirectional substructure allows the system to adapt to the requirements of the facade.



GLUING THE STACBOND COMPOSITE PANEL

4. Attaching STACBOND® composite panel. Once the substructure is in place, the **STACBOND®** panels are attached to it using double-sided adhesive tape and adhesive, following the manufacturer's instructions.

STB-T-PEG SYSTEM

AUXILIARY ELEMENTS

SPACER ANGULAR

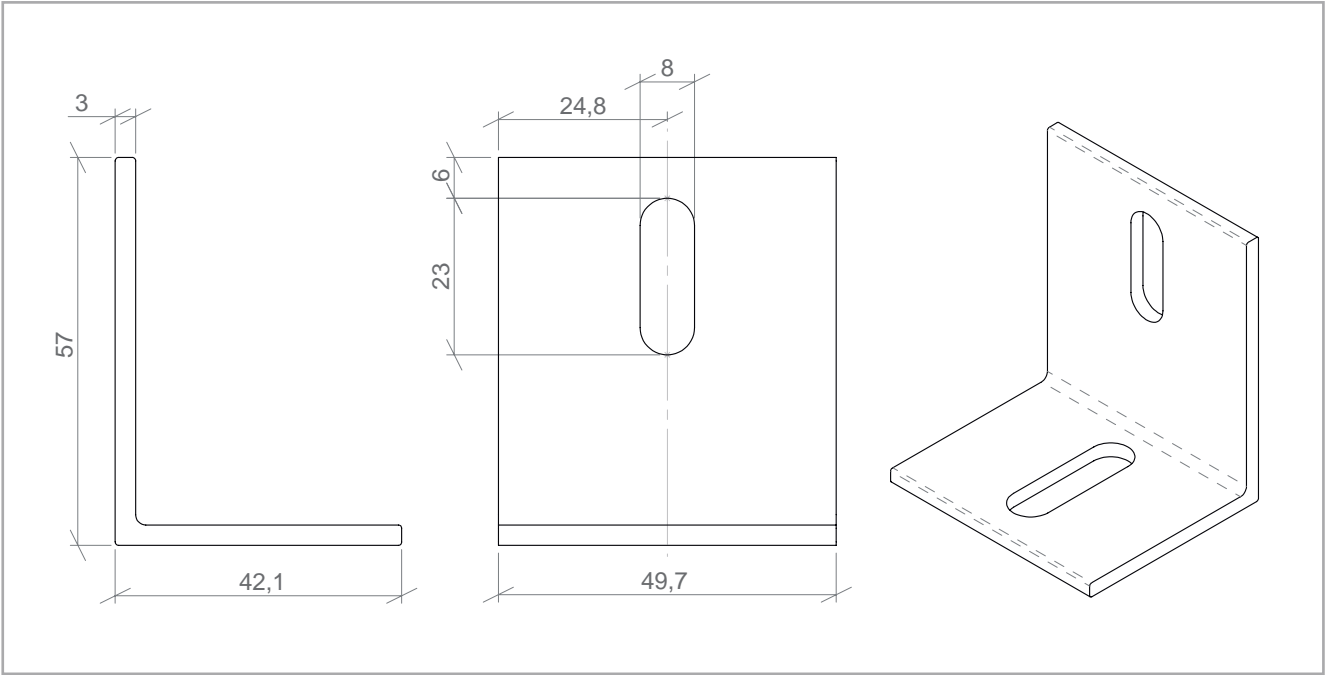
Part made of extruded 6063 T5 aluminium alloy profile (3 mm) with holes for fixing to the upright and cross-strut profiles T.

This accessory allows profiles T to be attached horizontally to the vertical substructure, reducing the number of fixings to the base wall.

Fixing of these spacers is done using \varnothing 4.8 mm blind rivets or \varnothing 4.8 mm self-tapping screws. These coupling parts are compatible with possible dilation of the substructure.



REFERENCE	DESCRIPTION	UNITS/BOX
19.021	SPACER ANGULAR	100



Measurements in mm



1. Cleaning the substructure. The substructure must be clean, dry, homogenous, and free of oil, grease, dust and loose particles. Any paint, grout or other substances must be removed.

Precautions:

- Clean the surface with a damp paper towel, moving in one single direction, as if sanding. Solvents must never be used.
- For cleaning and degreasing, SIK-AVIATOR-205 or similar is used. It should be left to evaporate for 10 minutes minimum.

2. Priming the area. Priming should be done with a product which strengthens the adherence of the adhesive to the substructure – SIKATAACK PANEL PRIMER or similar.

Precautions:

- Once hardened, the primers can only be removed via mechanical means.
- The primer leaves a heterogeneous film. Only those surfaces which are to be glued should be treated.
- The evaporation times of the cleaning products must be adhered to (30 – 60 mins).

3. Applying the double-sided adhesive tape. The double-sided adhesive tape – SIKATAACK PANEL-3 or similar – is used to initially attach the panels until the main adhesive polymerizes and also ensures the minimum adhesive thickness of 3 mm. This absorbs and possible vibration or dilation produced in the **STACBOND®** composite panel facade. The long-term strength is only achieved with the adhesive.

4. Elastic adhesive. Apply a continuous vertical bead of elastic adhesive – SIKATAACK PANEL or similar – using a triangular nozzle (8 mm wide x 10 mm long), at least 5 mm away from the adhesive tape. To ensure correct application, the gun should be positioned perpendicular to the support.

Precautions:

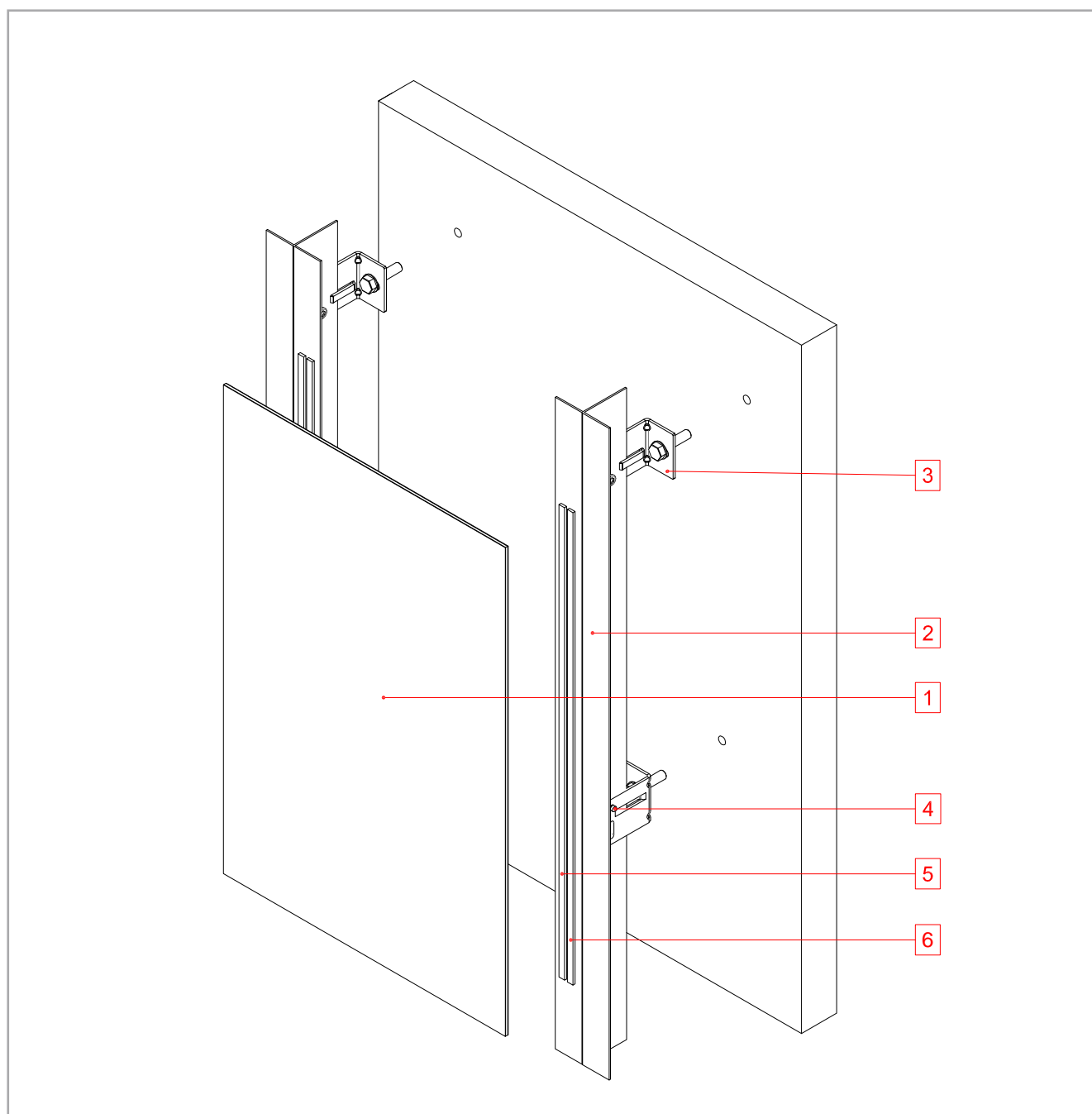
- The application of adhesive bead on the cross-struts of the substructure does not offer any structural function.

5. Placing the panel. Remove the protective film from the double-sided adhesive tape. Carefully place the panel in position precisely and press firmly until the panel contacts the double-sided adhesive tape.

Always follow the panel manufacturer's instructions for their storage. Avoid exposure to heat and direct sunlight prior to gluing the panels.

STB-T-PEG SYSTEM

INSTALLATION DIAGRAM

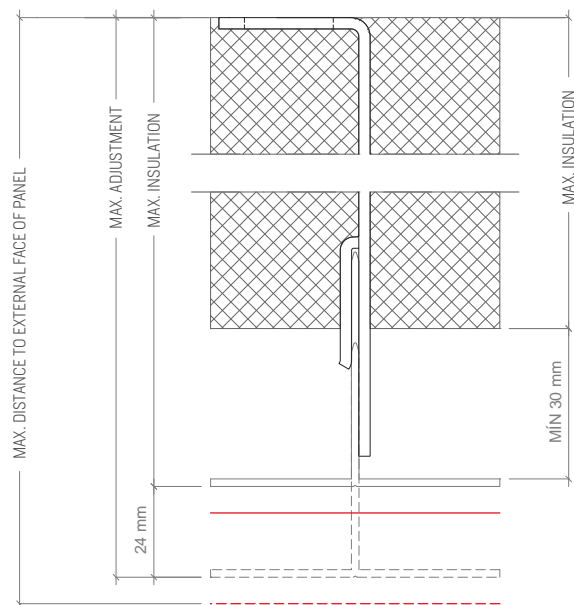


N° NAME

- | | |
|---|----------------------------|
| 1 | STACBOND® composite panel |
| 2 | Profile T |
| 3 | Spacer L |
| 4 | Self-tapping screw |
| 5 | Specific adhesive |
| 5 | Double-sided adhesive tape |

STB-T-PEG SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER L * ST-1-55

REF.	PART	DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
		MIN.	MAX	
05.19.041	SPACER L 68 ST-1-55	83	107	40
05.19.044	SPACER L 92 ST-1-55	107	131	80
05.19.051	SPACER L 116 ST-1-55	131	155	100
05.19.052	SPACER L 140 ST-1-55	155	179	120
05.19.053	SPACER L 164 ST-1-55	179	203	140
05.19.054	SPACER L 188 ST-1-55	203	227	160
05.19.055	SPACER L 212 ST-1-55	227	251	200
05.19.056	SPACER L 236 ST-1-55	251	275	220

SPACER L * ST-2-120

REF.	PART	DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
		MIN.	MAX	
05.19.042	SPACER L 68 ST-2-120	83	107	40
05.19.045	SPACER L 92 ST-2-120	107	131	80

STB-T-PEG SYSTEM

ACCESSORIES

PROFILES

REF.	PART	PAGE
05.19.043	PROFILE T	106

SPACERS

REF.	PART	PAGE
05.19.041	SPACER L 68 ST-1-55	109
05.19.044	SPACER L 92 ST-1-55	
05.19.051	SPACER L 116 ST-1-55	
05.19.052	SPACER L 140 ST-1-55	
05.19.053	SPACER L 164 ST-1-55	
05.19.054	SPACER L 188 ST-1-55	
05.19.055	SPACER L 212 ST-1-55	
05.19.056	SPACER L 236 ST-1-55	
05.19.042	SSPACER L 68 ST-2-120	
05.19.045	SPACER L 92 ST-2-120	


AUXILIARY ELEMENTS


REF.	PART	PAGE
19.021	SPACER ANGULAR	110

INSULATING WEDGES

REF.	PART	PAGE
05.19.070	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.066 / 05.19.068 / 05.19.072	115
05.19.066	INSULATING WEDGE FOR SPACERS L * ST-2-120 WITH REF.: 05.19.042 / 05.19.045	
05.19.068	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.053 / 05.19.054 / 05.19.055 / 05.19.056	
05.19.072	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.041 / 05.19.044 / 05.19.051 / 05.19.052	

INFORMATION AND SALES

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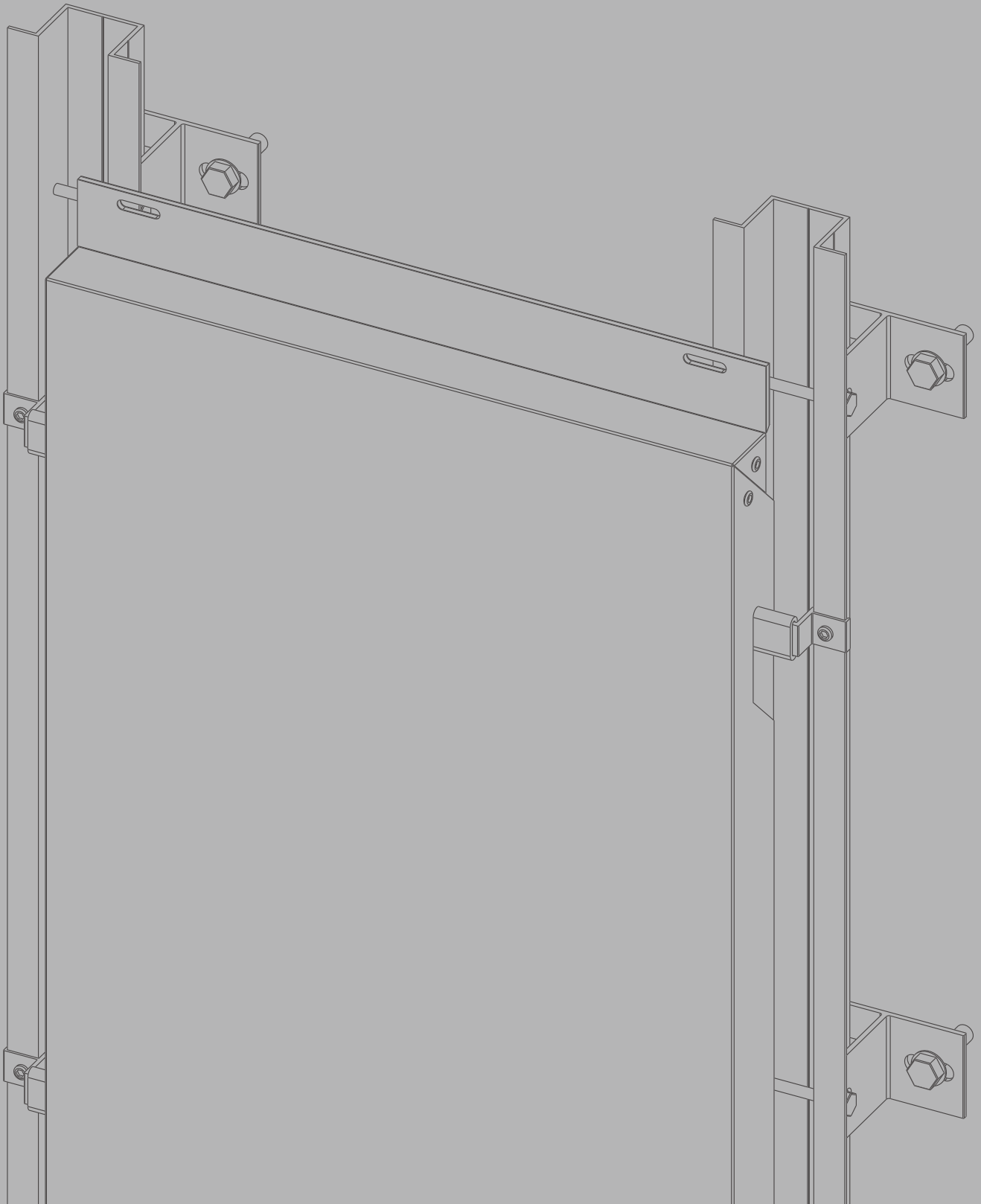
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STB-CH

HANGING SYSTEM



STB-CH SYSTEM DESCRIPTION



STB-CH is a kit system based on hung cassettes made from **STACBOND®** composite panels for installing ventilated facades. The system has hidden fixings and is versatile and quick to install. The cassettes can be installed either vertically or horizontally. The **STB-CH** system complies with all the requirements to be employed in the most cutting edge architectural claddings.

The substructure employs **profiles OMEGA** and **spacers DOUBLE T** in 6063 T5 aluminium alloy.

The spacers come in various lengths to house the required thickness of thermal insulation and compensate any irregularities in the facade. For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the **spacers DOUBLE T** and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the **profiles OMEGA** as uprights.

The **bracket sets STB-CH hanging** are placed on the uprights. They are cut from extruded 6063 T% aluminium alloy profiles. A special EPDM piece is fitted in the hanging area to avoid vibrations.

The cassettes made of **STACBOND®** composite panel are attached to the substructure thanks to slots which are machined in the vertical edges of the cassettes and in their hidden stiffeners attached to the inner face, in a manner so that they rest on the support hangers and are screwed or riveted through the upper tabs to the **profiles OMEGA**.

STAC® has developed a program for the specific calculations of the substructure with the criteria from the Technical approval Document (DIT plus 553p/16) established by the Instituto de Ciencias de la Construcción Eduardo Torroja for each project executed. This program defines the maximum distances between uprights and the number of fixings.

The **STB-CH** system complies with all major international certifications.



ETA-ETE: 15/0655



Nº 553P/19



ITB - KOT 2017/0043



13/5022



2.2/13-1548_V2





SPACERS DOUBLE T

1. The first step is **attaching the spacers DOUBLE T** to the facade. These must be in perfect vertical alignment. The spacers to be used depends on the thermal insulation and the layout / irregularities of the facade. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.



PROFILES OMEGA

2. The **profiles OMEGA** are **screwed to the spacers DOUBLE T**. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings must be placed at a maximum of 250 mm from the ends of the profile OMEGA.



BRACKET SETS

3. The **bracket sets** are **placed on the profiles**. These are adjusted in height according to the location of the hanging slots of each cassette.



STACBOND COMPOSITE PANEL CASSETTE

4. STACBOND® composite panel cassette. The last step is placing the cassettes on the hangers and screwing or riveting them to the wings of the profiles OMEGA in the slotted holes located on the upper horizontal tabs of the cassettes. The cladding is applied working from the bottom row up.

STB-CH SYSTEM

AUXILIARY ELEMENTS

BRACKET SET STB-CH HANGING

The bracket setSTB-CH hanging is used on OMEGA profiles.

The gasket for the hanger is used to avoid vibration noise caused by wind load, road traffic, etc.

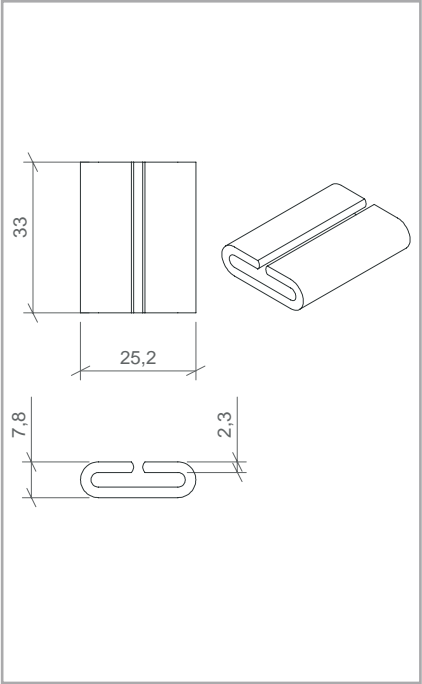
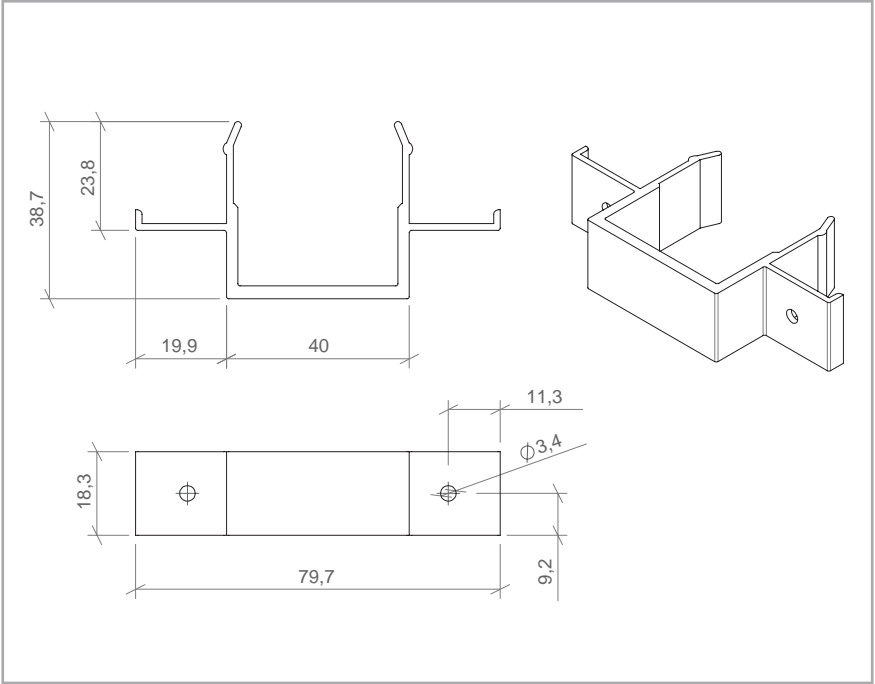
The support is initially attached to the profile via tabs which allow vertical movement to aid placement in the final location and is then fixed using self-tapping screws



REFERENCE	DESCRIPTION	UNITS/BOX
05.19.013	BRACKET SET STB-CH HANGING	200

BRACKET STB-CH

BRACKET GASKET



Measurements in mm

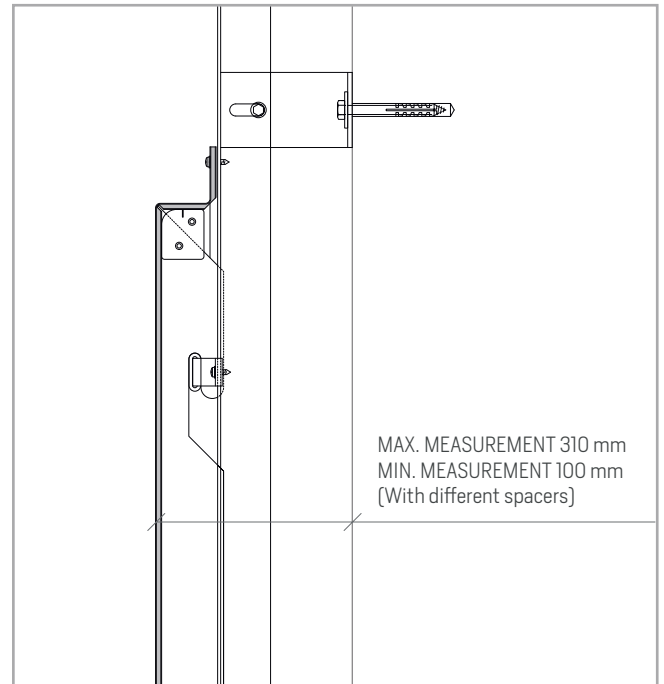
STB-CH SYSTEM

STANDARD CH CASSETTE WITH 45 mm FLAP

45 mm FLAP (DETAIL)



VERTICAL CROSS-SECTION



Note: The machined **STACBOND®** panels are supplied flat. The client is responsible for forming them into cassettes. No specialist machinery is required.

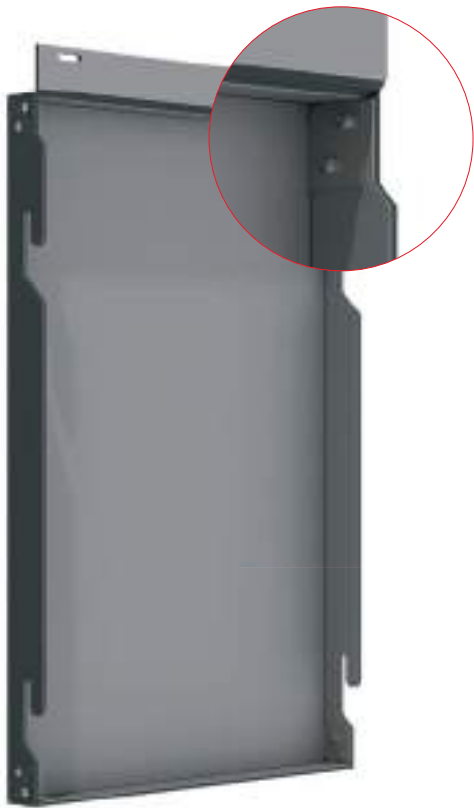
For the CH cassettes with 45 mm flaps, they can be formed using rectangular strips of 1050 ally (28 x 33 x 2 mm) or rectangular offcuts of the composite panels themselves.

Due to their greater length, the 45 mm flaps enter further into the OMEGA profiles and more efficiently channel away water that hits the facade.

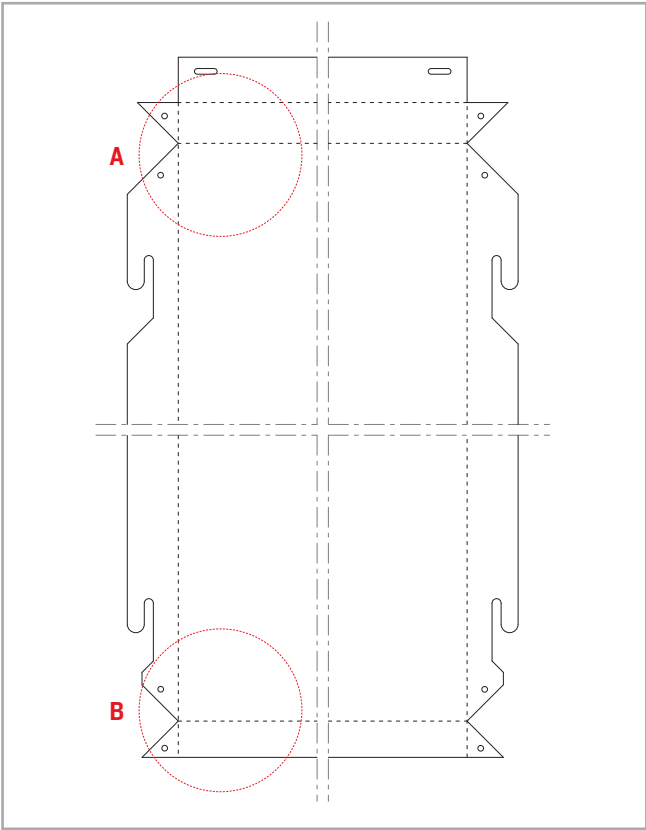
STB-CH SYSTEM

STANDARD CH CASSETTE WITH 45 mm FLAP

FORMED CASSETTE



FLAT CASSETTE



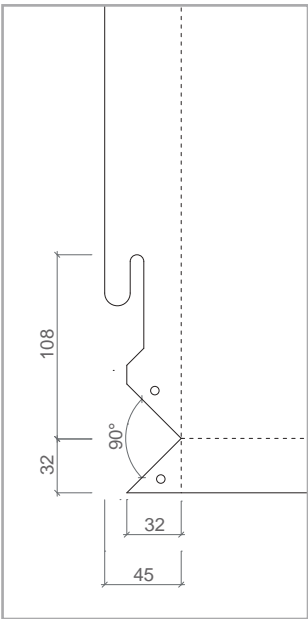
CASSETTES FORMING PLATE

The shaping plate is a small piece of 1050 H24 aluminium alloy which permits mechanical fixing via rivets to give the STB-CH and STB-T-CH system cassettes their shape.

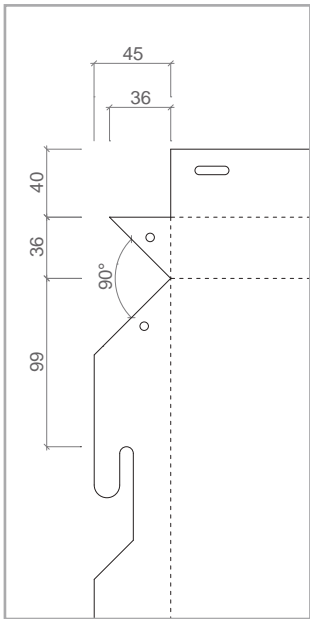
This plate is specified for CH cassettes with 45 mm flap and stiffeners.



DETAIL A



DETAIL B



REFERENCE	DESCRIPTION	UNITS/BOX
05.19.050	CASSETTES FORMING PLATE	3000

Measurements in mm

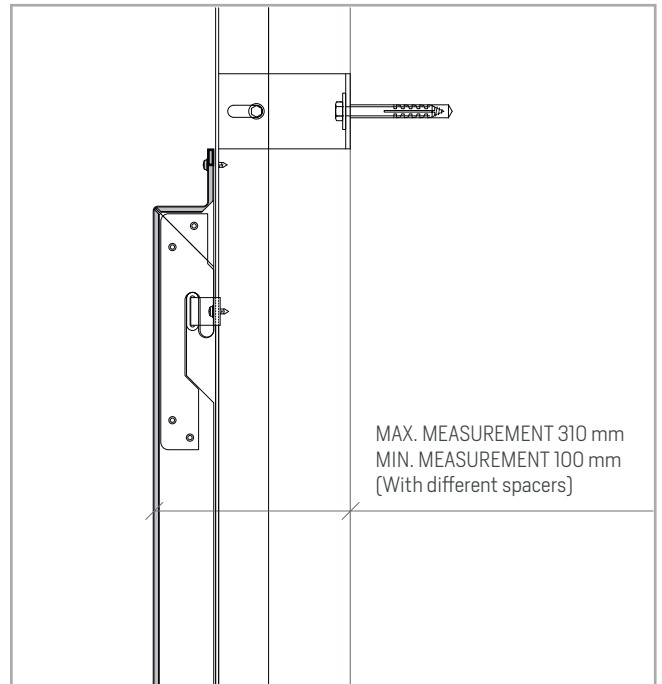
STB-CH SYSTEM

STANDARD CH CASSETTE WITH 40 mm FLAP

40 mm FLAP (DETAIL)



VERTICAL CROSS-SECTION



Note: The machined **STACBOND®** panels are supplied flat. The client is responsible for forming them into cassettes. No specialist machinery is required.

For the forming of CH cassettes with 40 mm flaps, hanging reinforcements are always used for every tab. These are specific 1050 aluminium alloy pieces of 2 mm and are riveted or screwed to the corresponding tabs and / or stiffeners.

The cassettes with 40 mm flap can allow greater optimization as they require less panel in the flaps than the cassettes with 45 mm flap.

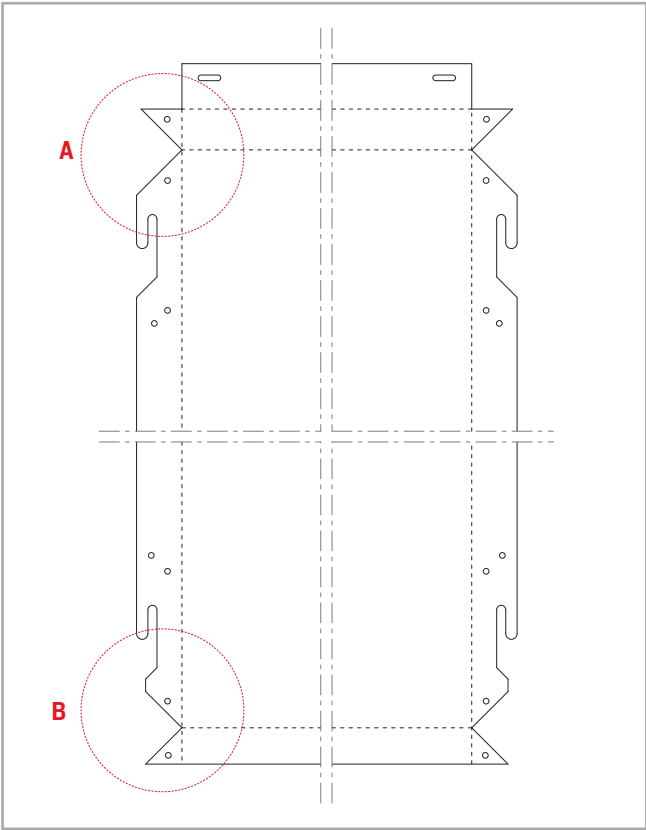
STB-CH SYSTEM

STANDARD CH CASSETTE WITH 40 mm FLAP

FORMED CASSETTE



FLAT CASSETTE

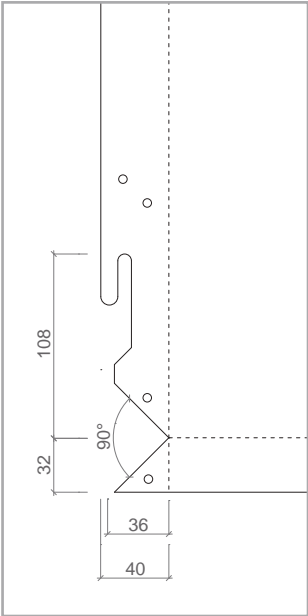


HANGING REINFORCEMENT

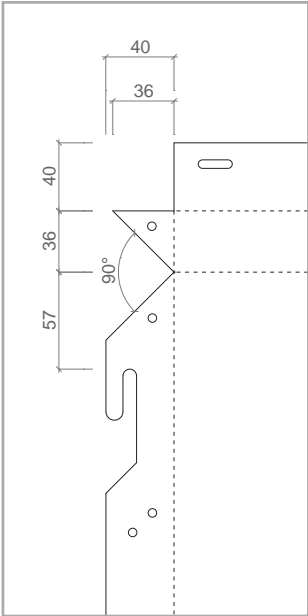
The hanging reinforcement is a piece made of 1050 H24 aluminium alloy which allows mechanical fixing via rivets to form the shape of the cassettes for the STB-CH and STB-T-CH systems, as well as strengthening each of the hanging slots of the CH cassettes with 40 mm flap.



DETAIL A



DETAIL B



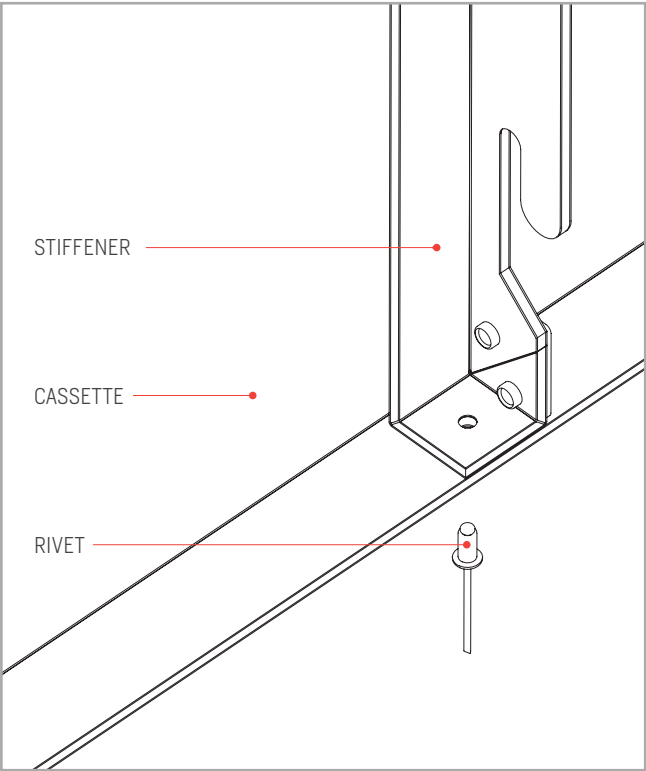
REFERENCE	DESCRIPTION	UNITS/BOX
05.19.013	HANGING REINFORCEMENT	500

Measurements in mm

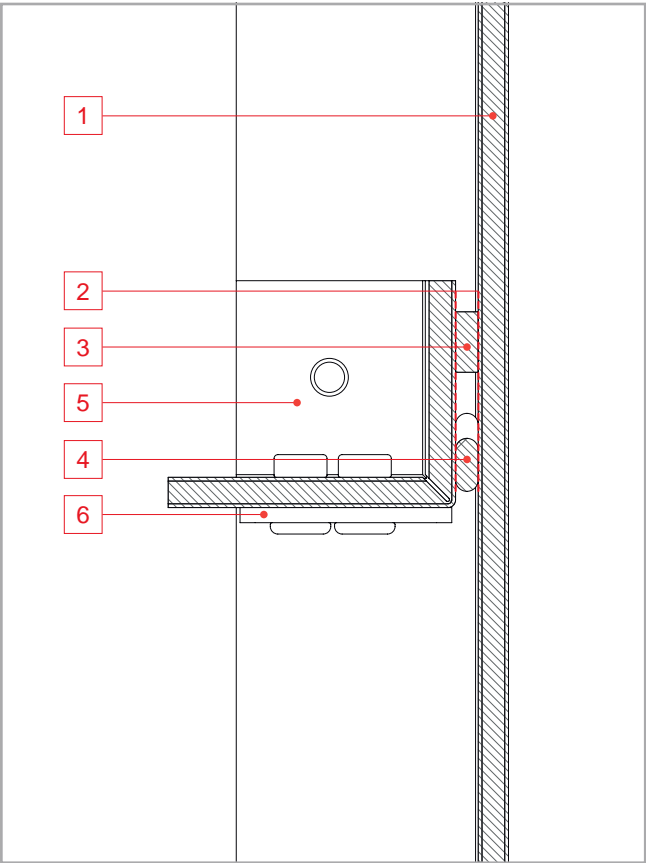
The stiffener is a angular piece formed from machined **STACBOND®** composite panel. It is used to internally reinforce CH cassettes when they exceed certain dimensions. The stiffener is fixed with double-sided tape and adhesive to the inner side of the tray and is riveted to the horizontal upper and lower flanges.



DETAIL OF MECHANICAL FIXING



DETAIL OF MECHANICAL FIXING



REFERENCE	DESCRIPTION
05.19.025	STIFFENER SCH-1 (< 750 mm)
05.19.026	STIFFENER SCH-2 (750 - 1500 mm)
05.19.027	STIFFENER SCH-3 (1500 - 2400 mm)
05.19.027.1	STIFFENER SCH-4 (2400 - 4000 mm)
05.19.027.2	STIFFENER SCH-5 (4000 - 5000 mm)
05.19.027.3	STIFFENER SCH-6 (> 5000 mm)

Nº	NAME
1	STACBOND® composite panel cassette
2	Primer
3	Double-sided adhesive tape
4	Adhesive applied to the cassette
5	Stiffener made of STACBOND® composite panel
6	Cassettes forming plate

STB-CH SYSTEM

ATTACHING STIFFENER

1. PREPARING THE AREA

Firstly dust and dirt is removed mechanically. Solvents must never be used. This cleaning consists of light or heavy sanding, depending on the extent of dirt present. The dust is then vacuumed or blown away. For cleaning and subsequent degreasing, SIKA-AVIATOR-205 or similar is used. It should be left to evaporate for 10 minutes minimum.

2. PRIMING THE AREA

Once the area is clean it is primed using a specific product which strengthens the adherence of the elastic adhesive (SIKATACK PANEL PRIMER or similar).

3. DOUBLE-SIDED ADHESIVE TAPE

After the required drying time of the primer (30 to 60 mins) the double-sided adhesive tape – SIKATACK PANEL-3 TAPE or similar – is applied. This holds the part whilst the adhesive polymerizes, as well as ensuring the required minimum depth of adhesive for any possible dilation of the STACBOND® composite panel.

4. APPLYING THE ADHESIVE

The elastic adhesive – SIKATACK PANEL or similar – is then applied to the panel, applying a continuous bead contiguous to the adhesive tape.

5. ATTACHING THE STIFFENER

The stiffener is then put in place ensuring that its full face surface is in contact with the adhesive.

6. FIXING WITH RIVETS

Lastly, the stiffener is drilled and riveted through the upper and lower ends to the horizontal tabs of the cassette.



1. CLEANING



2. PRIMING



3. ADHESIVE TAPE



4. SIKATACK PANEL ADHESIVE



5. ATTACHING THE STIFFENER



6. FIX WITH RIVETS

STB-CH SYSTEM

REPLACEMENT OF DAMAGED CASSETTES



1. Remove the damage cassette by cutting the upper flap.



2. Drill hole in tube of 30 x 30 x 1.4 mm with \varnothing 6 mm and place in the new cassette.



3. Place 4.2 x 13 DIN 7504 N stainless screws in "L" profile of 30 x 20 x 1.3 mm and attach this to the profile OMEGA.



4. Place specified double-side tape and adhesive on the "L" profile 30 x 20 mm.

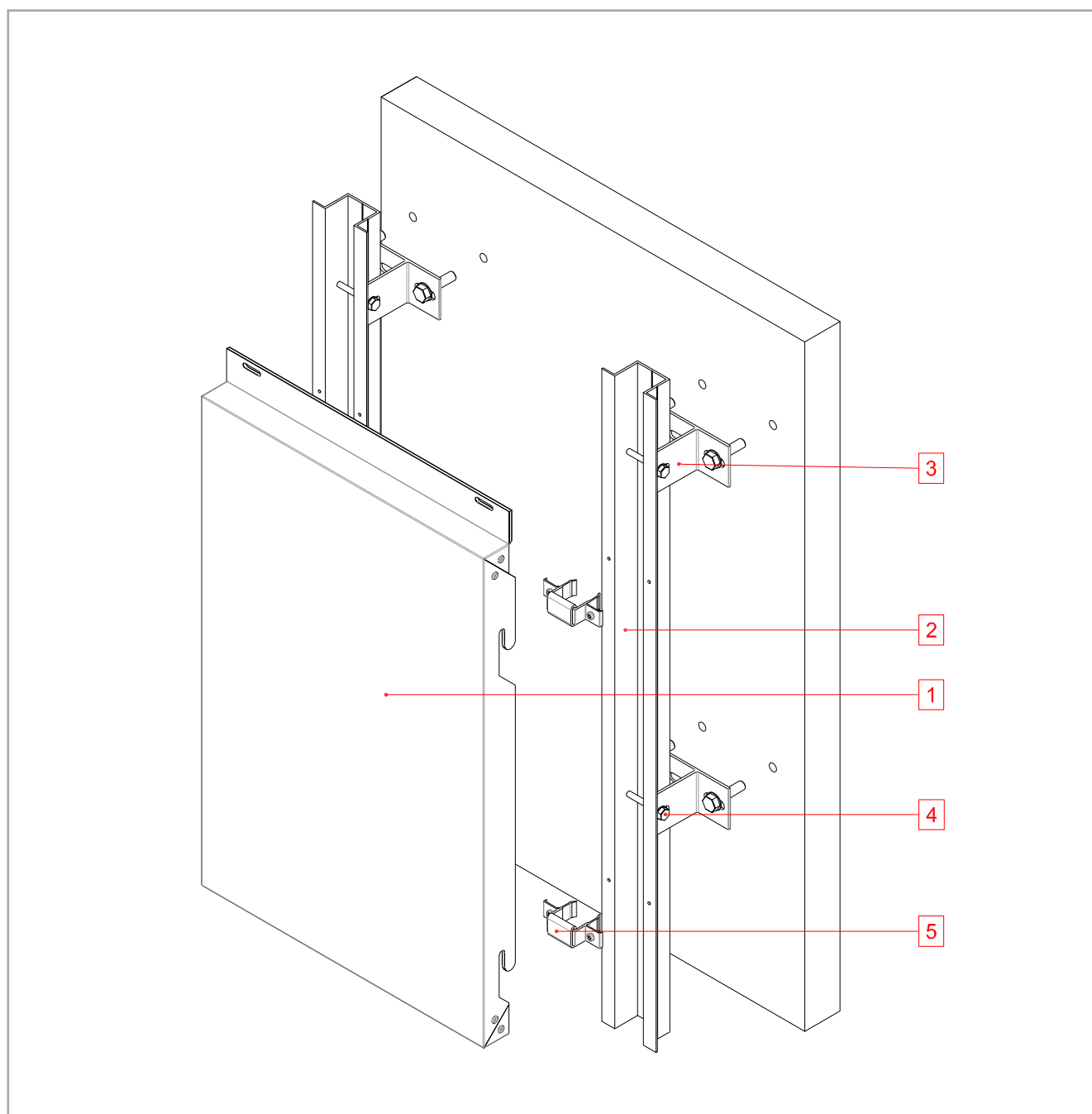


5. Fit the new **STACBOND®** composite panel cassette with special 9 mm hanging slot and hanging reinforcement pieces.



STB-CH SYSTEM

INSTALLATION DIAGRAM

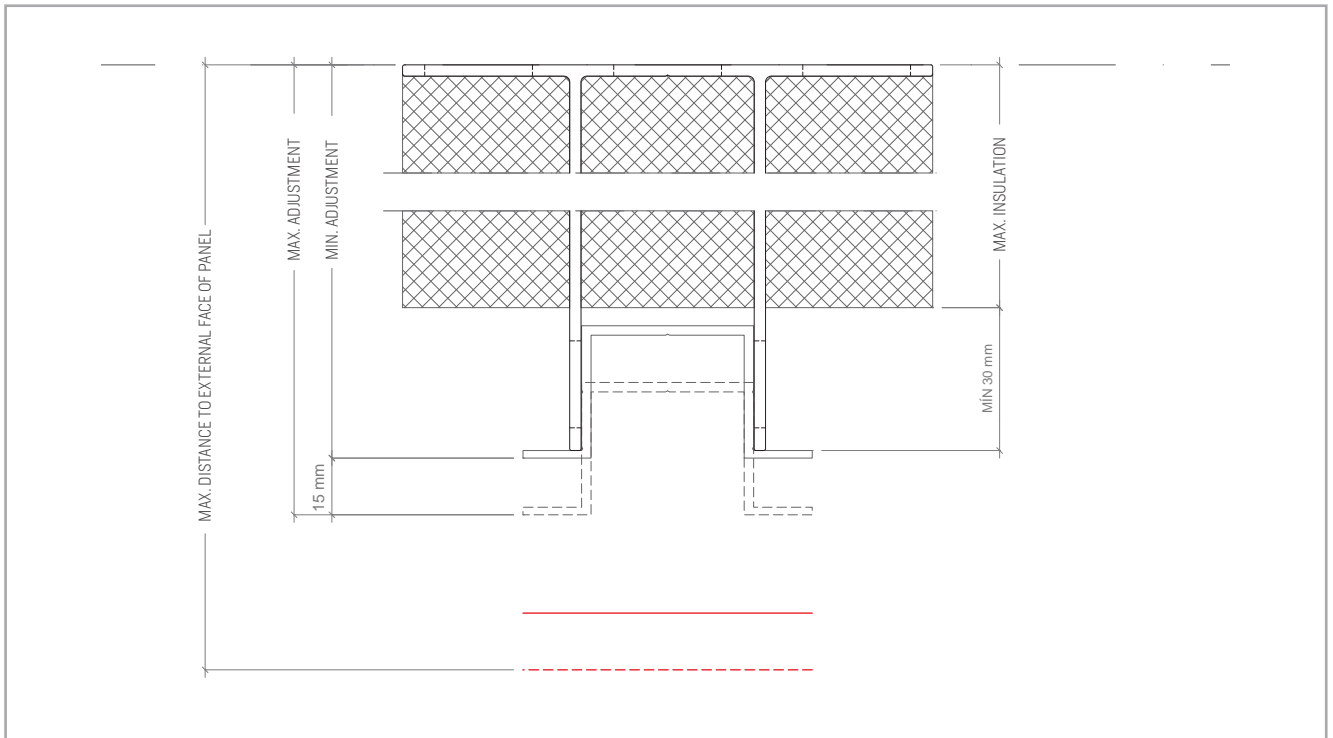


N° NAME

- | | |
|---|--|
| 1 | Cassette made from STACBOND® composite panel |
| 2 | Profile OMEGA |
| 3 | Spacer DOUBLE T |
| 4 | Through screw M 6 x 60/70 |
| 5 | Bracket set STB-T-CH hanging |

STB-CH SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER DOUBLE T *

REF.	PART	DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
		MIN.	MAX	
05.19.004	SPACER DOUBLE T 59	100	115	30
05.19.005	SPACER DOUBLE T 74	115	130	50
05.19.006	SPACER DOUBLE T 89	130	145	60
05.19.007	SPACER DOUBLE T 104	145	160	80
05.19.030	SPACER DOUBLE T 119	160	175	100
05.19.031	SPACER DOUBLE T 134	175	190	110
05.19.032	SPACER DOUBLE T 149	190	205	120
05.19.033	SPACER DOUBLE T 164	205	220	140
05.19.034	SPACER DOUBLE T 179	220	235	160
05.19.035	SPACER DOUBLE T 194	235	250	170
05.19.036	SPACER DOUBLE T 209	250	265	180
05.19.037	SPACER DOUBLE T 224	265	280	200
05.19.038	SPACER DOUBLE T 239	280	295	220
05.19.039	SPACER DOUBLE T 254	295	310	230

SPACER U *

REF.	PART	DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
		MIN.	MAX	
05.19.046	SPACER U 59	100	115	30
05.19.047	SPACER U 74	115	130	50

PROFILES

REF.	PART	PAGE
05.19.003	PROFILE OMEGA	106

AUXILIARY ELEMENTS

REF.	PART	PAGE
05.19.062	BRACKET SET STB-T-CH HANGING	111
19.019	HANGING REINFORCEMENT	
05.19.050	CASSETTES FORMING PLATE	
05.19.025	STIFFENER SCH-1 (< 750 mm)	
05.19.026	STIFFENER SCH-2 (750 - 1500 mm)	
05.19.027	STIFFENER SCH-3 (> 1500 mm)	

INSULATING WEDGES

REF.	PART	PAGE
05.19.071	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.067 / 05.19.069 / 05.19.073	114
05.19.005	INSULATING WEDGE FOR SPACERS U* WITH REF.: 05.19.046 / 05.19.047	
05.19.069	INSULATING WEDGE FOR SPACERS DOUBLE T* WITH REF.: 05.19.030 / 05.19.031 / 05.19.032 / 05.19.033 / 05.19.034 / 05.19.035 / 05.19.036 / 05.19.037 / 05.19.038 / 05.19.039	
05.19.073	INSULATING WEDGE FOR SPACERS DOUBLE T* WITH REF.: 05.19.004 / 05.19.005 / 05.19.006 / 05.19.007	

SPACERS

REF.	PART	PAGE
05.19.004	SPACER DOUBLE T 59	108
05.19.005	SPACER DOUBLE T 74	
05.19.006	SPACER DOUBLE T 89	
05.19.007	SPACER DOUBLE T 104	
05.19.030	SPACER DOUBLE T 119	
05.19.031	SPACER DOUBLE T 134	
05.19.032	SPACER DOUBLE T 149	
05.19.033	SPACER DOUBLE T 164	
05.19.034	SPACER DOUBLE T 179	
05.19.035	SPACER DOUBLE T 194	
05.19.036	SPACER DOUBLE T 209	109
05.19.037	SPACER DOUBLE T 224	
05.19.038	SPACER DOUBLE T 239	
05.19.039	SPACER DOUBLE T 254	
05.19.046	SPACER U 59	109
05.19.047	SPACER U 74	

FASTENING ACCESSORIES

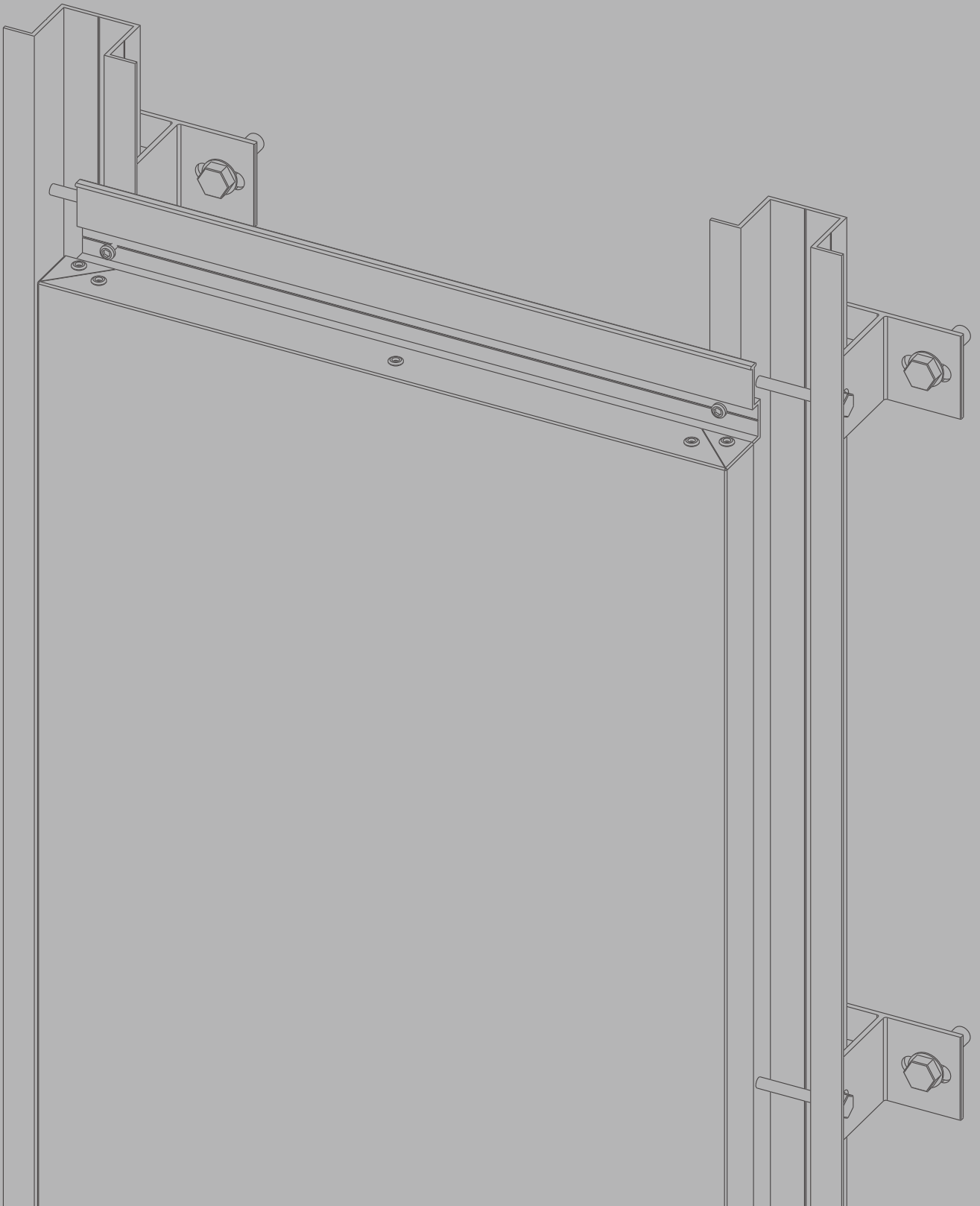
REF.	PART	PAGE
STB-R0300	BLIND RIVET POLYGRIP SFS ASO-D-48150 ALU/INOX 4,8X15	113

INFORMATION AND SALES

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 📠 (+34) 981 817 037
 ✉ stacbond@stac.es
 🌐 www.stac.es

STB-SZ

MALE-FEMALE SYSTEM



STB-SZ SYSTEM DESCRIPTION



STB-T-SZ is a kit system based on cassettes made from **STACBOND® composite panels for installing ventilated facades**. It is a hidden male-female coupling system which is quick and easy to install. It was specially designed to develop facades with horizontal aspect of mainly solid wall with little surface area of openings or linear spaces.

The system comprises two 6063 T5 aluminium alloy profiles onto which the pre-formed cassettes are attached:

- Lower female profile, called **profile S**.
- Upper male profile, called **profile Z**.

The substructure employs **profiles OMEGA** and **spacers DOUBLE T** in 6063 T5 aluminium alloy.

The spacers come in various lengths to house the required thickness of thermal insulation and compensate any irregularities in the facade. For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the spacers double T and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the profiles OMEGA as uprights.

The **STACBOND®** composite panel cassettes are mechanically attached to the uprights. The facade is constructed from the base up in a manner that the profile S of each upper cassette sits on the profile Z of the cassette below it. Mechanical anchoring is via screwing the profiles Z to the profile OMEGA.

To avoid vibration of the male-female cassettes and the profiles S and Z, protective EPDM gaskets are incorporated.

STAC® has developed a program for the specific calculations of the substructure with the criteria from the Technical approval Document (DIT plus 553p/16) established by the Instituto de Ciencias de la Construcción Eduardo Torroja for each project executed, defining the maximum distances between uprights and the number of fixings.

The **STB-SZ** system complies with all major international certifications.



ETA-ETE: 15/0655



Nº 553P/19



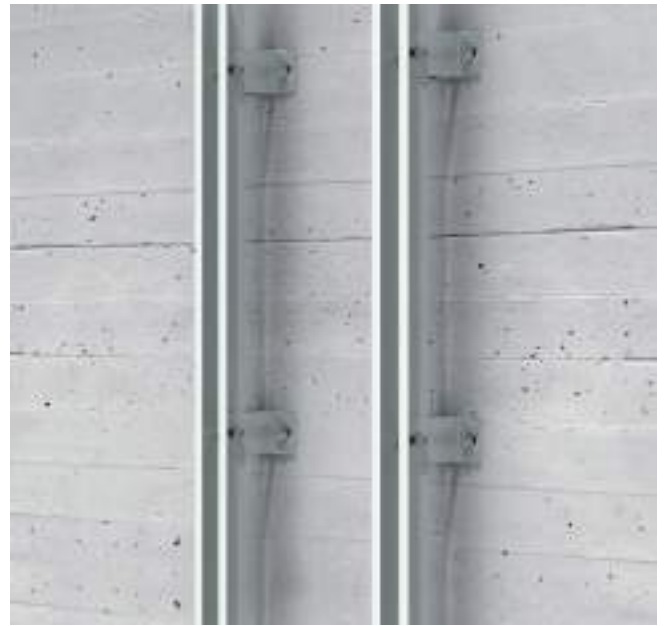
ITB - KOT 2017/0043





SPACERS DOUBLE T

1. The first step is **attaching the spacers DOUBLE T** to the facade. These must be in perfect vertical alignment. The spacers to be used depends on the thermal insulation and the layout / irregularities of the facade. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.



PROFILES OMEGA

2. The profiles **OMEGA** are **screwed to the spacers DOUBLE T**. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings must be placed at a maximum of 250 mm from the ends of the profile **OMEGA**.



BASE PROFILE Z

3. Profile S and profile Z. These profiles longitudinally strengthen the cassette in both its upper and lower parts. The profile Z is fitted in the upper part and has a EPDM adhesive strip which surrounds the vertical wing of the profile to absorb possible spaces between the male and female parts to avoid noise caused by vibration. These profiles are attached to the cassettes using rivets.



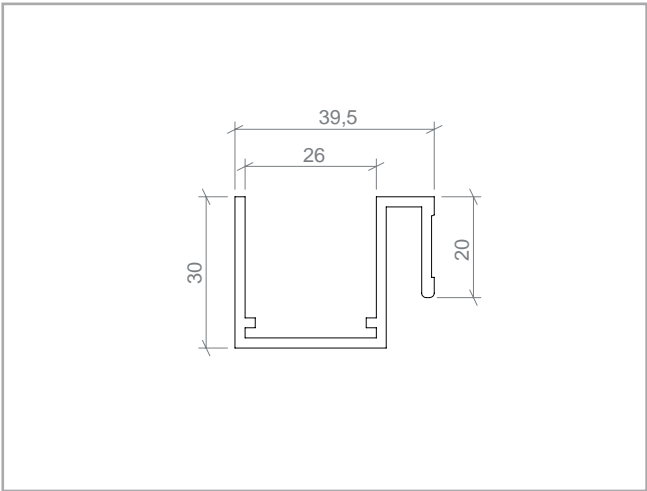
STACBOND COMPOSITE PANEL CASSETTES

4. STACBOND® composite panel cassette. Once the cassette has been formed with the profile Z in the upper part and the profile S in the lower part, it is set up to the facade. Cladding is performed from the bottom row up in a manner so that each cassette rests on the one below and is mechanically fastened in the upper part by screwing the profile Z to the upright profile **OMEGA**.

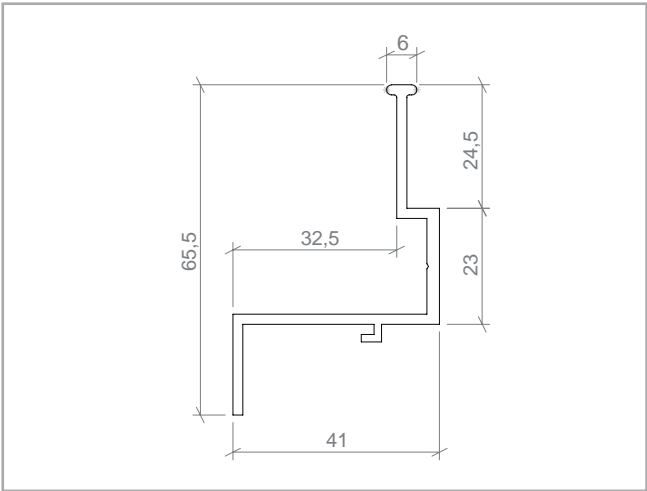
PROFILE S AND PROFILE Z



PROFILE S



PROFILE Z



Measurements in mm

EPDM GASKET PROFILE SZ



We provide a EPDM protection gasket to place between the two profiles and absorb any slack.

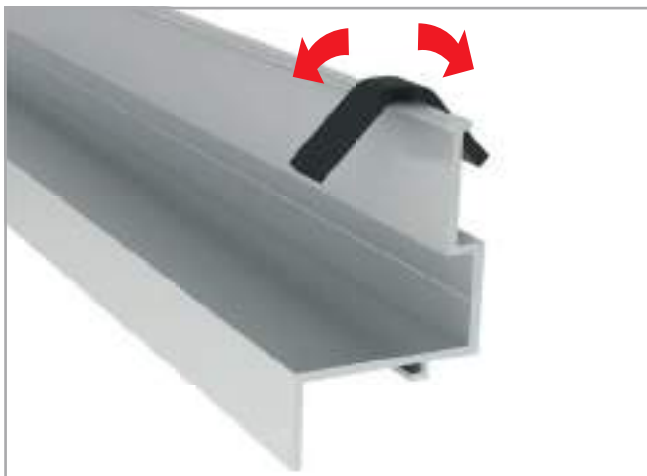
REINFORCEMENT STB-SZ

The reinforcement STB-SZ is a segment of profile of 200 mm specific length, covers the internal distance between the SZ cassette and the substructure.
This part is attached to the substructure profile with screws.



REFERENCE	DESCRIPTION	UNITS/BOX
05.19.001	PROFILE S	24
05.19.002	PROFILE Z	18
05.99.231	REINFORCEMENT STB-SZ	174
STB-JEPDM	EPDM GASKET PROFILE SZ (m.l.)	-

USING THE EPDM GASKET PROFILE SZ



The segments of EPDM gasket must be placed on the head of the profile Z and wrapped around to cover both sides. The recommended size of these strips is 60 mm.



The recommended maximum distance between segments is 500 mm. Using this accessory eliminates possible vibrations between the panels and allows them to be adjusted to ensure flatness of the facade.

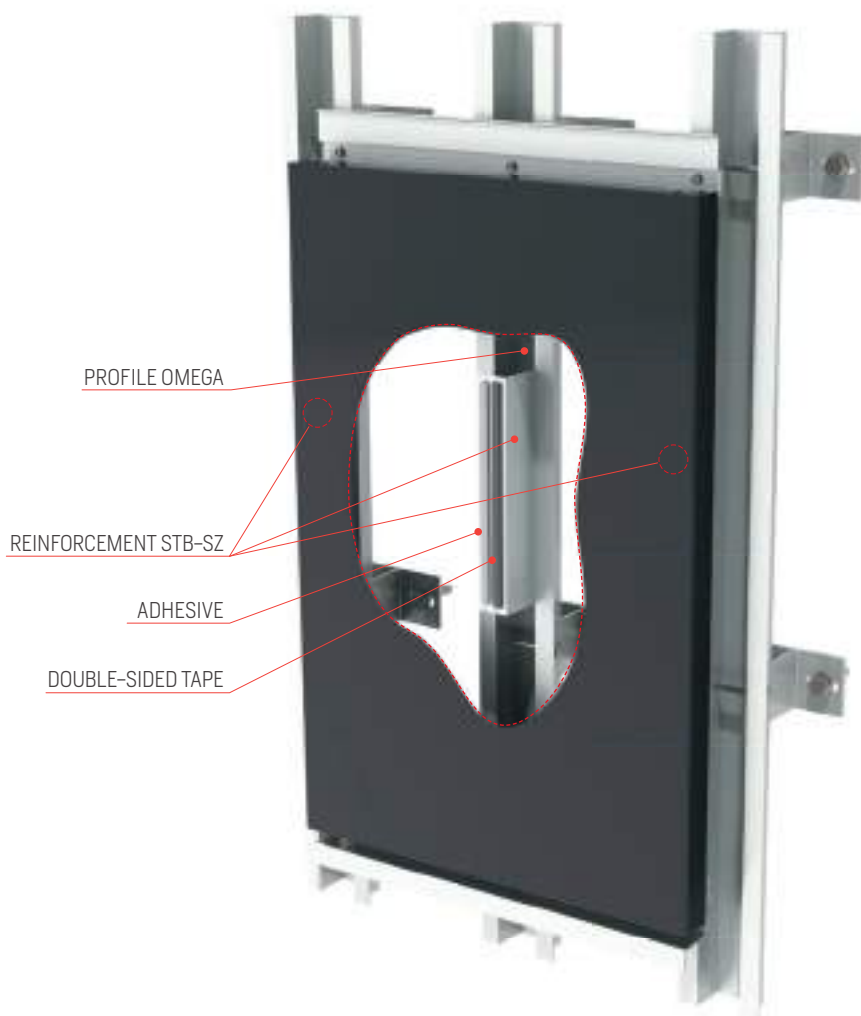
USING THE REINFORCEMENT STB-SZ

The use of the STB-SZ reinforcement depends on the height of the tray and the wind load of the project site. For more detailed information please consult **STAC®**.

It must be used on each of the upright profiles OMEGA that support the composite panel cassette.

The reinforcement is mechanically attached to the front face of the profile and special adhesive and double-sided adhesive tape is applied.

The cassette is then fitted and fixed using rivets in the upper profile Z.



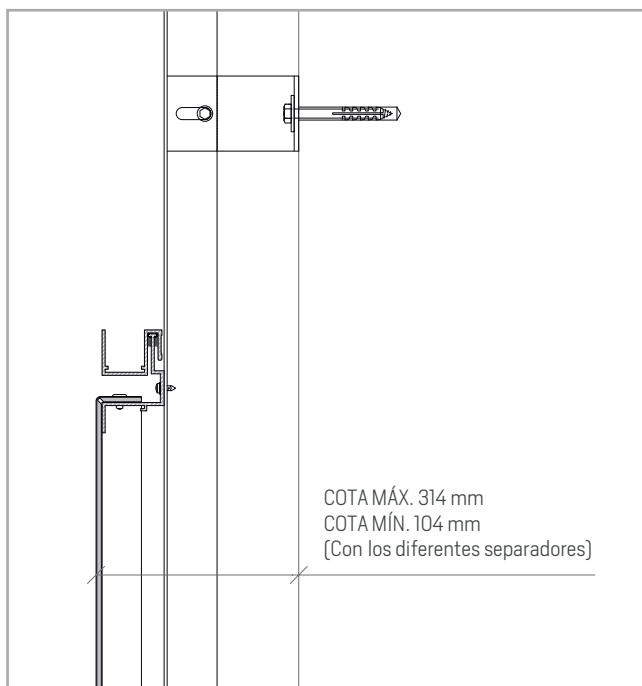
STB-SZ SYSTEM

INSTALLING SZ CASSETTE

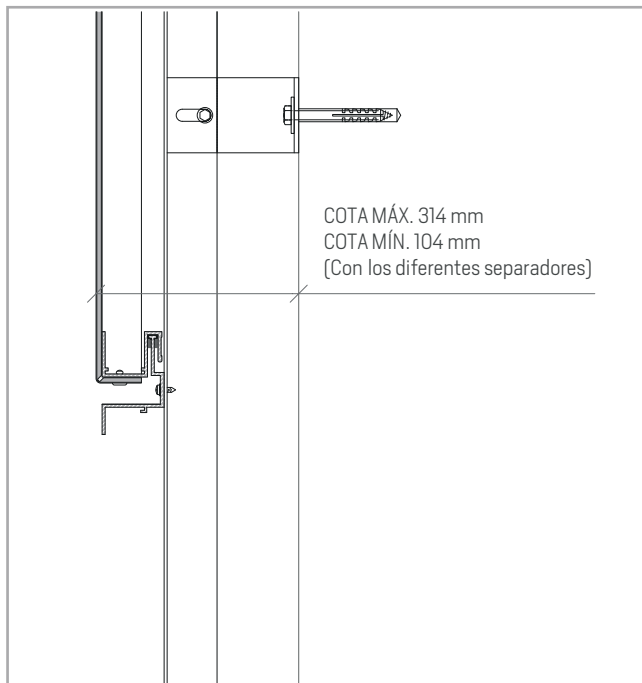
UPPER FIXING



VERTICAL CROSS-SECTION



VERTICAL CROSS-SECTION

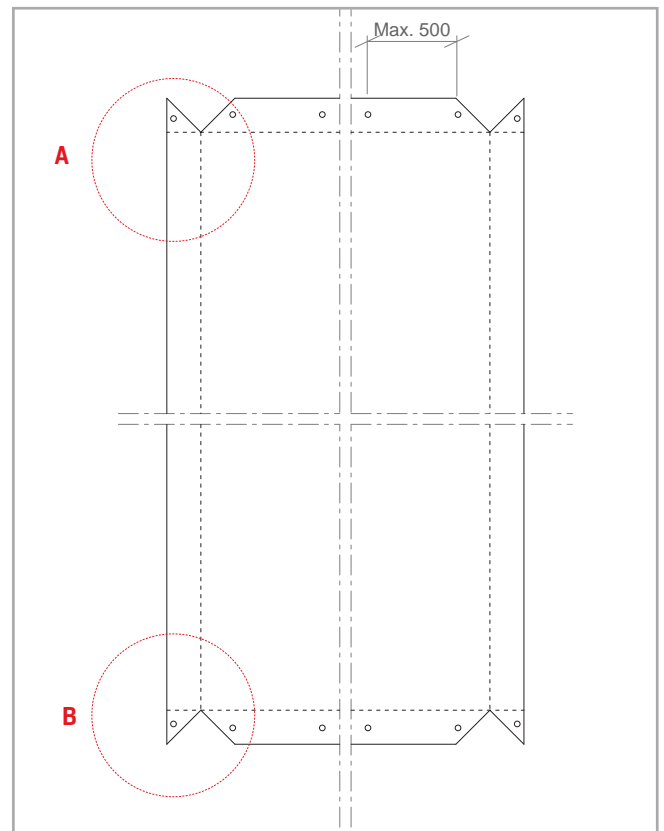


Note: The machined **STACBOND®** panels are supplied flat. The client is responsible for forming them into cassettes. No specialist machinery is required.

FORMED CASSETTE

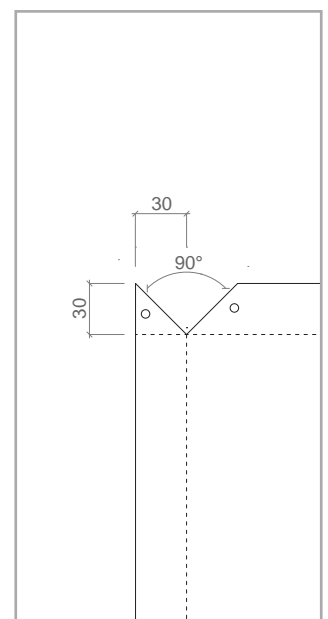
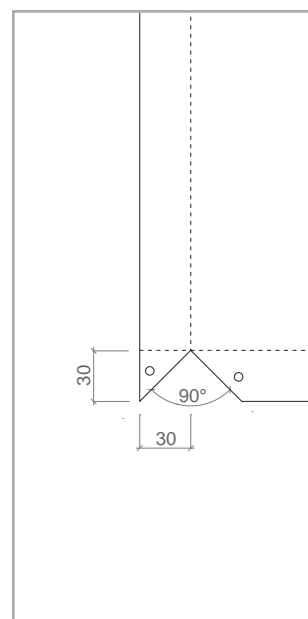


FLAT CASSETTE



DETAIL A

DETAIL B

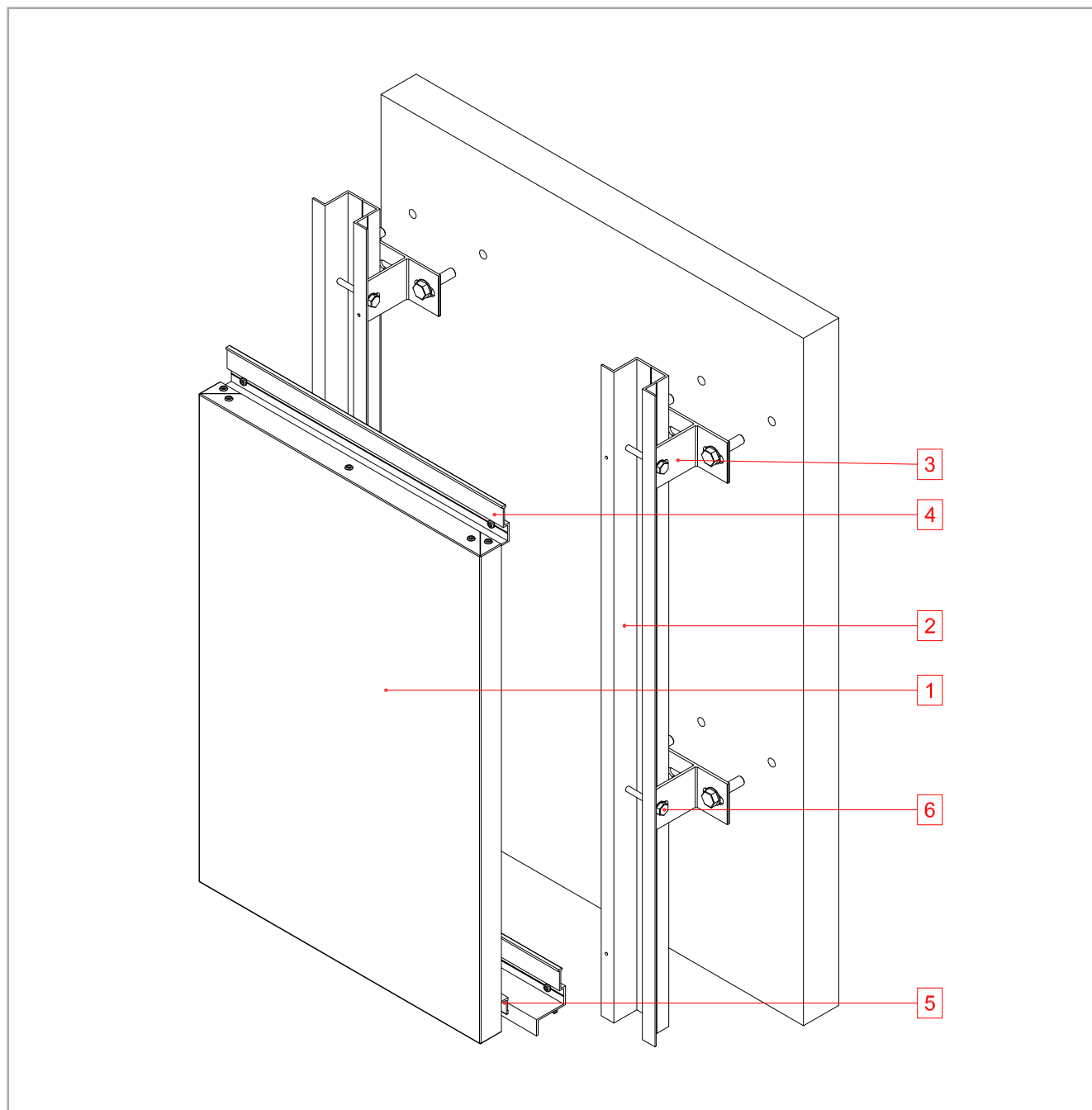


Measurements in mm

The standard cassettes in the STB-T-SZ system have 30 mm flaps. To form the cassettes, they are mechanically fastened via rivets directly to the longitudinal profiles S and Z.

The profile Z is attached in the lower part and the profile S in the upper part of the cassette. These profiles provide the cassettes with great longitudinal rigidity.

STB-SZ SYSTEM INSTALLATION DIAGRAM

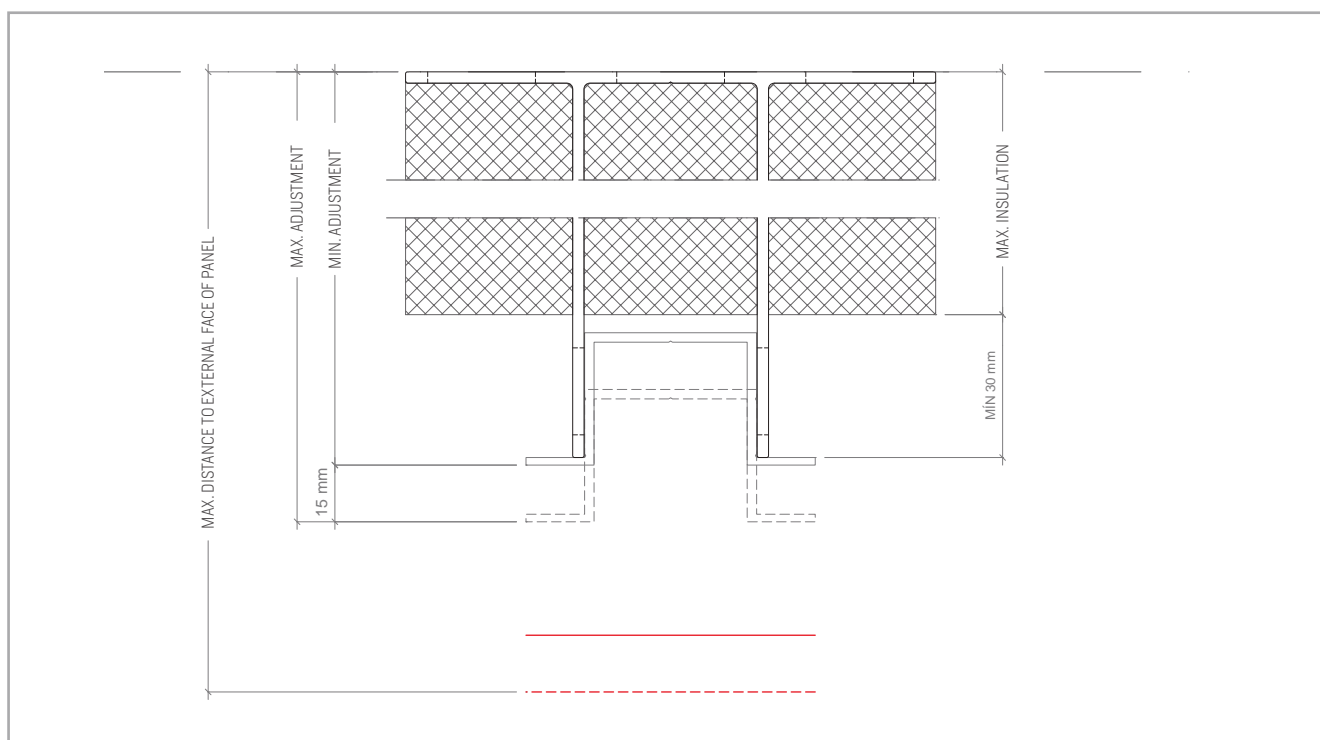


N°	NAME
----	------

- | | |
|---|--|
| 1 | Cassette made from STACBOND® composite panel |
| 2 | Profile OMEGA |
| 3 | Spacer DOUBLE T |
| 4 | Profile Z |
| 5 | Profile S |
| 6 | Through screw M 6 x 60/70 |

STB-SZ SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER DOUBLE T *		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.004	SPACER DOUBLE T 59	104	119	30
05.19.005	SPACER DOUBLE T 74	119	134	50
05.19.006	SPACER DOUBLE T 89	134	149	60
05.19.007	SPACER DOUBLE T 104	149	164	80
05.19.030	SPACER DOUBLE T 119	164	179	100
05.19.031	SPACER DOUBLE T 134	179	194	110
05.19.032	SPACER DOUBLE T 149	194	209	120
05.19.033	SPACER DOUBLE T 164	209	224	140
05.19.034	SPACER DOUBLE T 179	224	239	160
05.19.035	SPACER DOUBLE T 194	239	254	170
05.19.036	SPACER DOUBLE T 209	254	269	180
05.19.037	SPACER DOUBLE T 224	269	284	200
05.19.038	SPACER DOUBLE T 239	284	299	220
05.19.039	SPACER DOUBLE T 254	299	314	230

SPACER U *		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.046	SPACER U 59	104	119	30
05.19.047	SPACER U 74	119	134	50

PROFILES

REF.	PART	PAGE
05.19.003	PROFILE OMEGA	106
05.19.001	PROFILE S	107
05.19.002	PROFILE Z	
05.19.074	PROFILE Z 20	
05.19.063	PROFILE Z 24	

AUXILIARY ELEMENTS

REF.	PART	PAGE
05.99.231	REINFORCEMENT STB-SZ	110
STB-JEPDM	EPDM GASKET PROFILE SZ (m.l.)	

INSULATING WEDGES

REF.	PART	PAGE
05.19.071	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.067 / 05.19.069 / 05.19.073	114
05.19.005	INSULATING WEDGE FOR SPACERS U* WITH REF.: 05.19.046 / 05.19.047	
05.19.069	INSULATING WEDGE FOR SPACERS DOUBLE T* WITH REF.: 05.19.030 / 05.19.031 / 05.19.032 / 05.19.033 / 05.19.034 / 05.19.035 / 05.19.036 / 05.19.037 / 05.19.038 / 05.19.039	
05.19.073	INSULATING WEDGE FOR SPACERS DOUBLE T* WITH REF.: 05.19.004 / 05.19.005 / 05.19.006 / 05.19.007	


SPACERS

REF.	PART	PAGE
05.19.004	SPACER DOUBLE T 59	108
05.19.005	SPACER DOUBLE T 74	
05.19.006	SPACER DOUBLE T 89	
05.19.007	SPACER DOUBLE T 104	
05.19.030	SPACER DOUBLE T 119	
05.19.031	SPACER DOUBLE T 134	
05.19.032	SPACER DOUBLE T 149	
05.19.033	SPACER DOUBLE T 164	
05.19.034	SPACER DOUBLE T 179	
05.19.035	SPACER DOUBLE T 194	
05.19.036	SPACER DOUBLE T 209	109
05.19.037	SPACER DOUBLE T 224	
05.19.038	SPACER DOUBLE T 239	
05.19.039	SPACER DOUBLE T 254	
05.19.046	SPACER U 59	109
05.19.047	SPACER U 74	

FASTENING ACCESSORIES

REF.	PART	PAGE
STB-R0300	BLIND RIVET POLYGRIP SFS ASO-D-48150 ALU/INOX 4,8X15	113

INFORMATION AND SALES

 (+34) 981 817 036

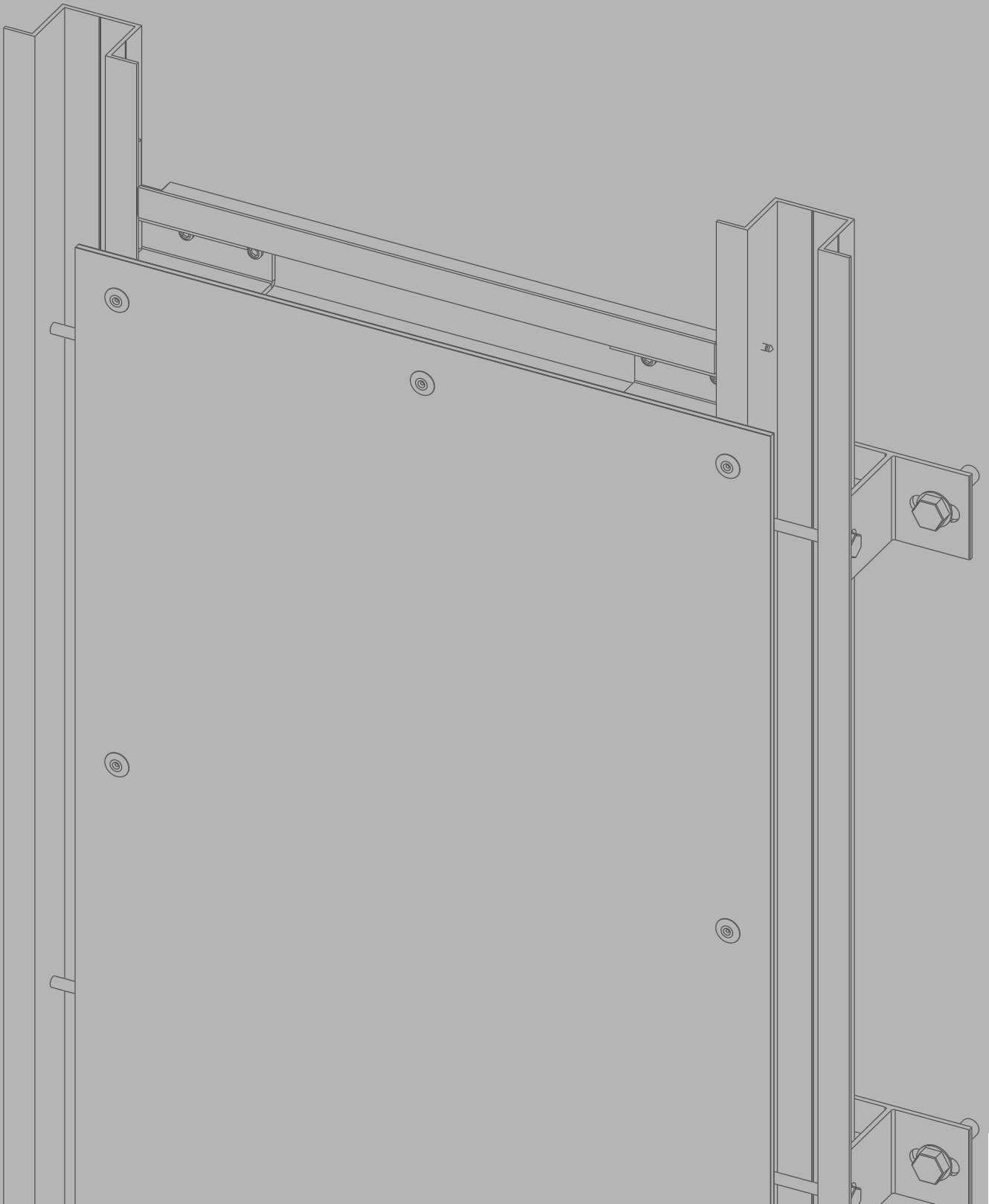
 (+34) 981 817 037

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STB-REM

RIVETED SYSTEM



STB-REM SYSTEM

DESCRIPTION



STB-REM is a kit system based on flat panels made from **STACBOND® composite panels for installing ventilated facades**. It is a system with visible fixings which is quick to install and which allows both horizontal and vertical assembly. It is a very versatile system which perfectly suits any architectural layout and offers the possibility to easily cover curving sections. The **STB-REM** system therefore complies with all the requirements to be employed in the most demanding architectural claddings.

The substructure employs **profiles OMEGA** and **spacers DOUBLE T** in 6063 T5 aluminium alloy.

The spacers come in various lengths to house the required thickness of thermal insulation and compensate any irregularities in the facade. For the thermal break, **STAC®** has developed specific **INSULATING WEDGES** to place between the spacers DOUBLE T and the vertical face.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the profiles OMEGA as uprights.

The **STB-REM** system can be mounted on a unidirectional or bidirectional substructure. With a unidirectional substructure, the horizontal joint remains open. In the case of the bidirectional substructure, horizontal struts are attached to the uprights using mounting joints made of 1050-H aluminium alloy, or to the vertical face using spacers DOUBLE T.

This substructure with vertical and / or horizontal profiles OMEGA support the **STACBOND®** composite panel sheets which are riveted at their edges.

STAC® has developed a program for the specific calculations of the substructure with the criteria from the Technical approval Document (DIT plus 553p/16) established by the Instituto de Ciencias de la Construcción Eduardo Torroja for each project executed, defining the maximum distances between the profile OMEGA uprights and the number of fixings.

The **STB-REM** system complies with all major international certifications.



ETA-ETE: 15/0655



Nº 553P/19



ITB - KOT 2017/0043

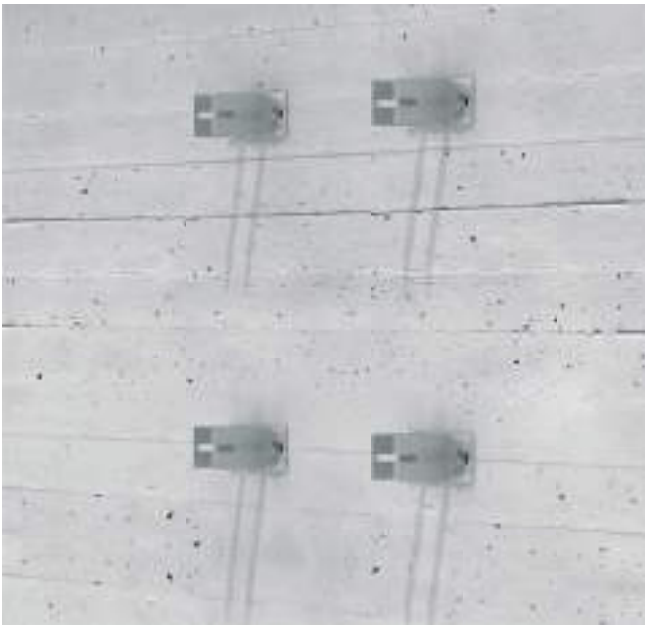


13/5022

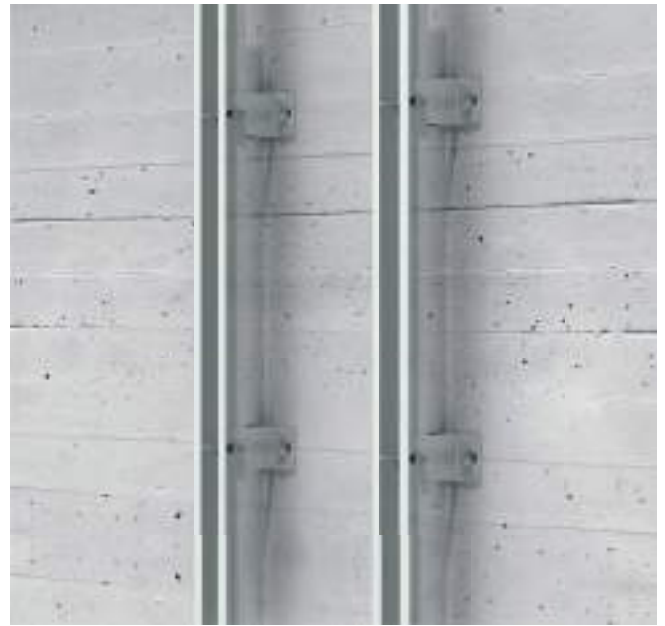


2.2/13-1548_V1





SPACERS DOUBLE T



PROFILES OMEGA

1. The first step is **attaching the spacers DOUBLE T** to the facade. These must be in perfect vertical alignment. The spacers to be used depends on the thermal insulation and the layout / irregularities of the facade. **Insulating wedges** can optionally be installed to act as thermal bridge breaks.

2. The **profiles OMEGA** are **screwed to the spacers DOUBLE T**. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings must be placed at a maximum of 250 mm from the ends of the profile OMEGA.



HORIZONTAL PROFILES OMEGA



ATTACHING STACBOND COMPOSITE PANEL

3. **Horizontal cross-struts (optional).** These profiles are mechanically fixed to the vertical substructure using **mullion joinings STB-REM**. The possibility of creating a bidirectional substructure allows the system to adapt to the requirements of the facade.

4. **Attaching STACBOND® composite panel.** Once the substructure is in place, the **STACBOND®** panels are attached to it using rivets. Attention should be paid to the condition and type of rivet to ensure correct dilation of the panels.

STB-REM SYSTEM

AUXILIARY ELEMENTS

MULLION JOINING STB-REM

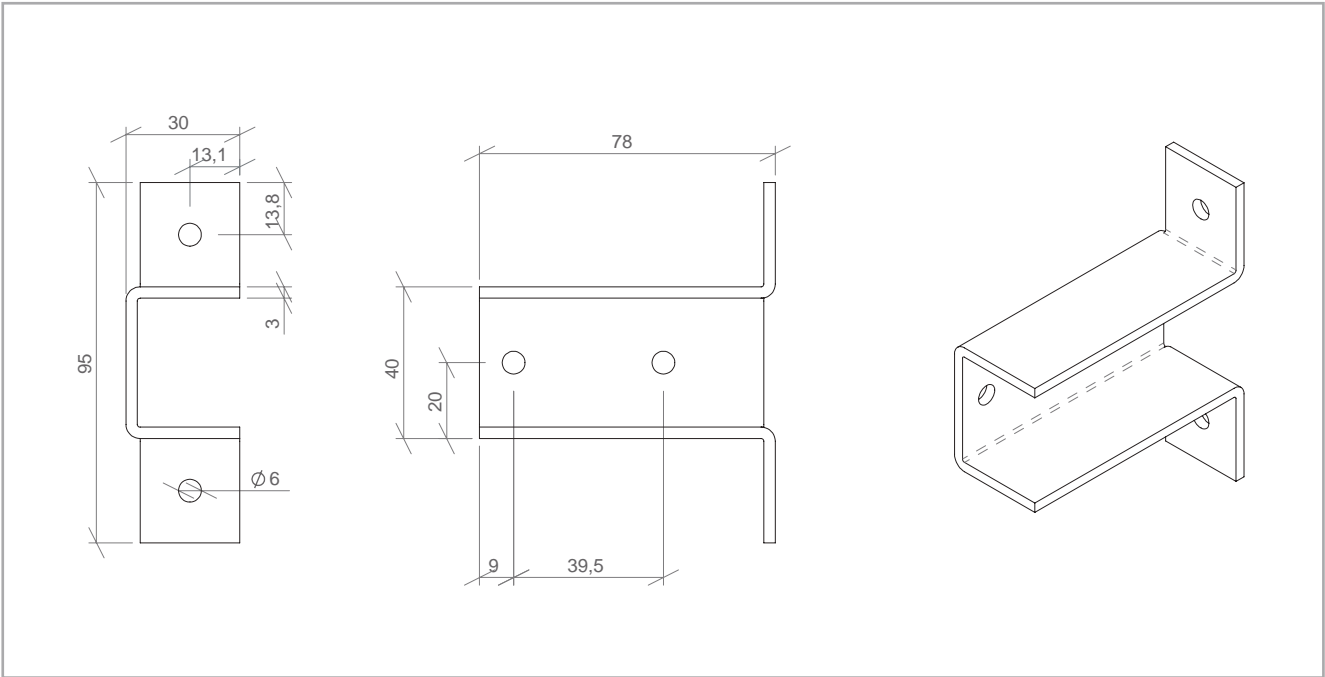
Part made of folded 1050-H aluminium alloy sheet (3 mm) with holes for fixing to the upright and cross-strut profiles OMEGA.

This accessory allows profiles OMEGA to be attached horizontally to the substructure, reducing the number of fixings to the base wall.

Fixing of these spacers is done using \varnothing 4.8 mm blind rivets or \varnothing 4.8 mm self-tapping screws. These coupling parts are compatible with possible dilation of the substructure.



REFERENCE	DESCRIPTION	UNITS/BOX
05.19.020	MULLION JOINING STB-REM	150



Measurements in mm

STB-REM SYSTEM

TYPE AND DISTRIBUTION OF PERFORATIONS

DILATION OF THE PANEL

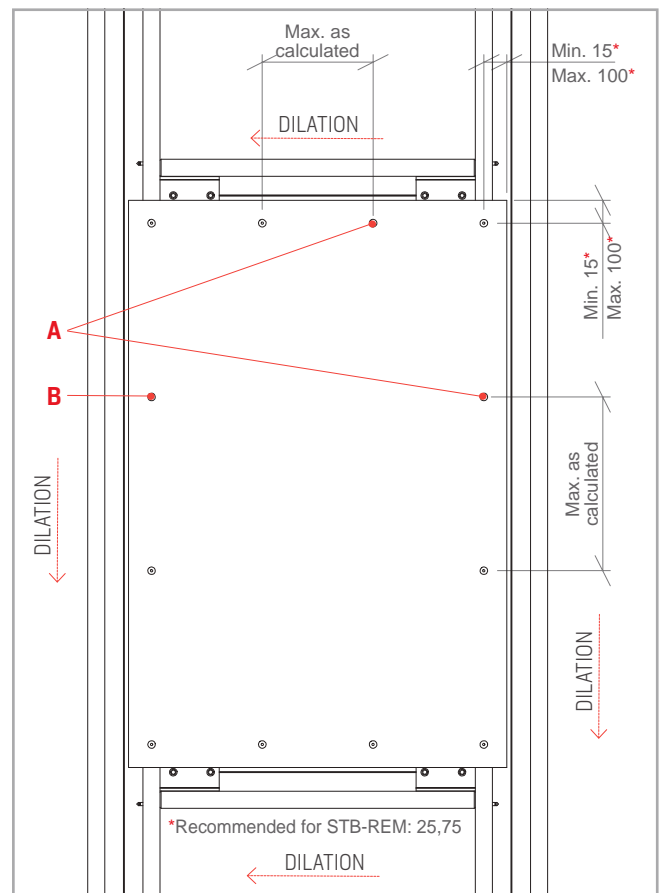
The diagram shows the layout and max. distance of the holes in the **STACBOND®** composite panel.

The panels are set in place by drilling and inserting the corresponding rivet, respecting the difference between the diameter of the drill and the shank of the rivet and also the distances between rivets and the edge of the panel.

To allow movement of the panel and to avoid problems from dilation, it is important to centre the drill holes on the substructure. This allows equal dilation in all directions and does not limit movement. We recommend the use of **centring gauges** to ensure correct hole placement and fixing of rivets.

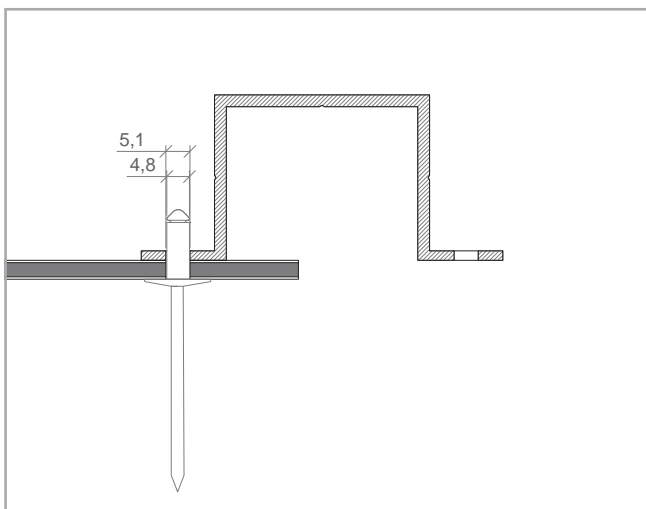
Furthermore, to allow movement in the floating fixing points, it is important to control the rivet clinch strength. We recommend the use of a **spacing nosepiece** which leaves a 0.2 mm gap between the sheet and the fixing, avoiding immobilising fixing points which should be floating.

Rivets and screws specified by **STAC®** should be used.

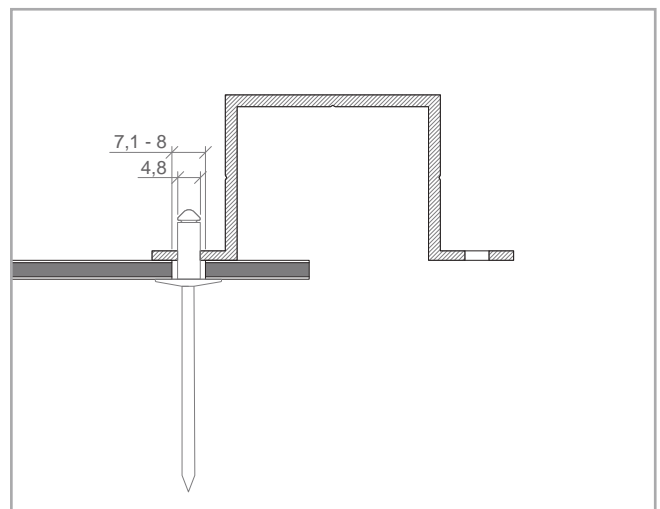


Note: other rivets and screws may be used providing that their mechanical characteristics are equal or greater than those specified by **STAC®**.

A. FIXED ANCHORING POINTS



B. MOBILE ANCHORING POINTS

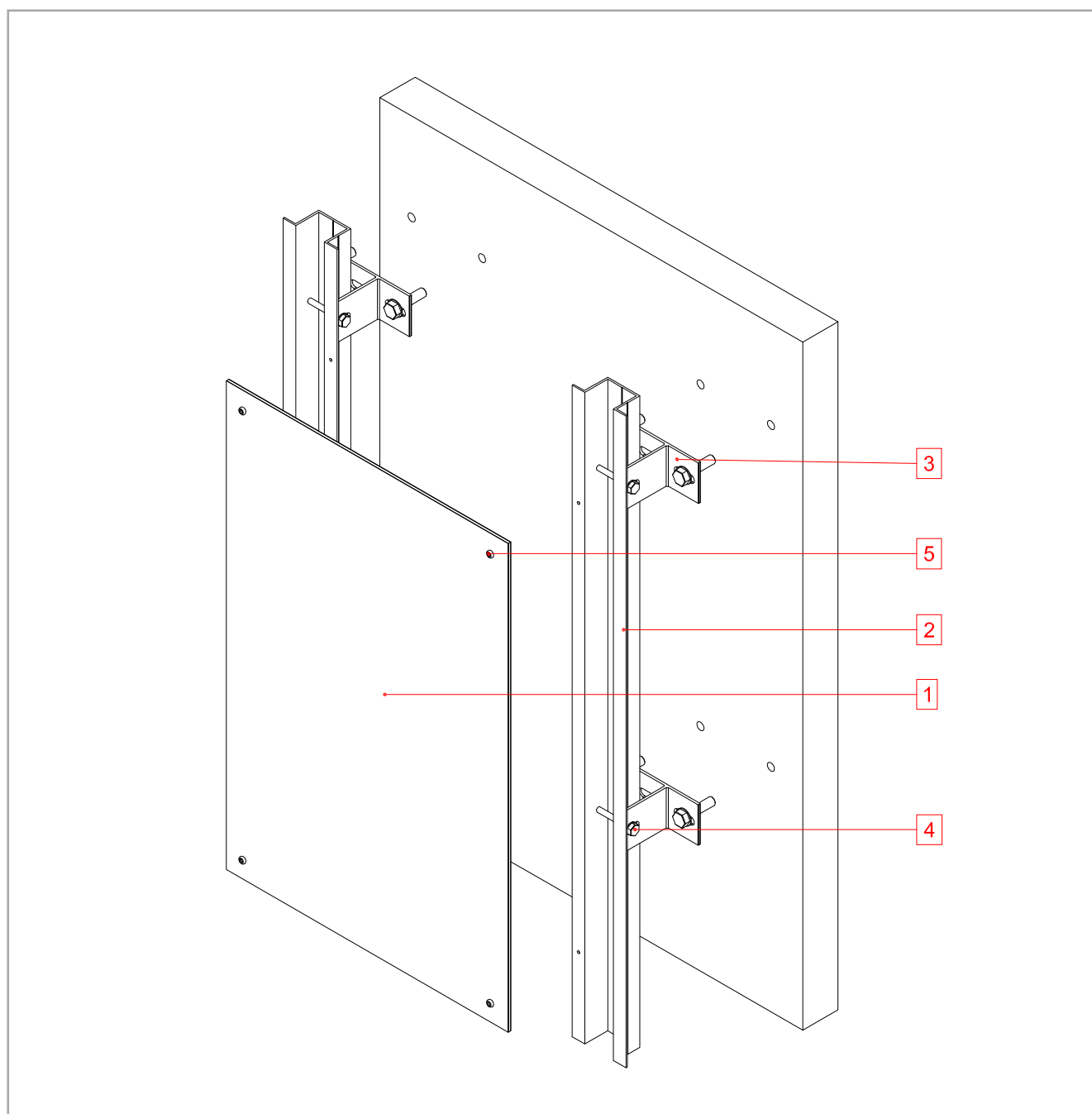


Measurements in mm

The larger diameter hole drilled in the **STACBOND®** composite panel allows dilation to be absorbed.

STB-REM SYSTEM

INSTALLATION DIAGRAM

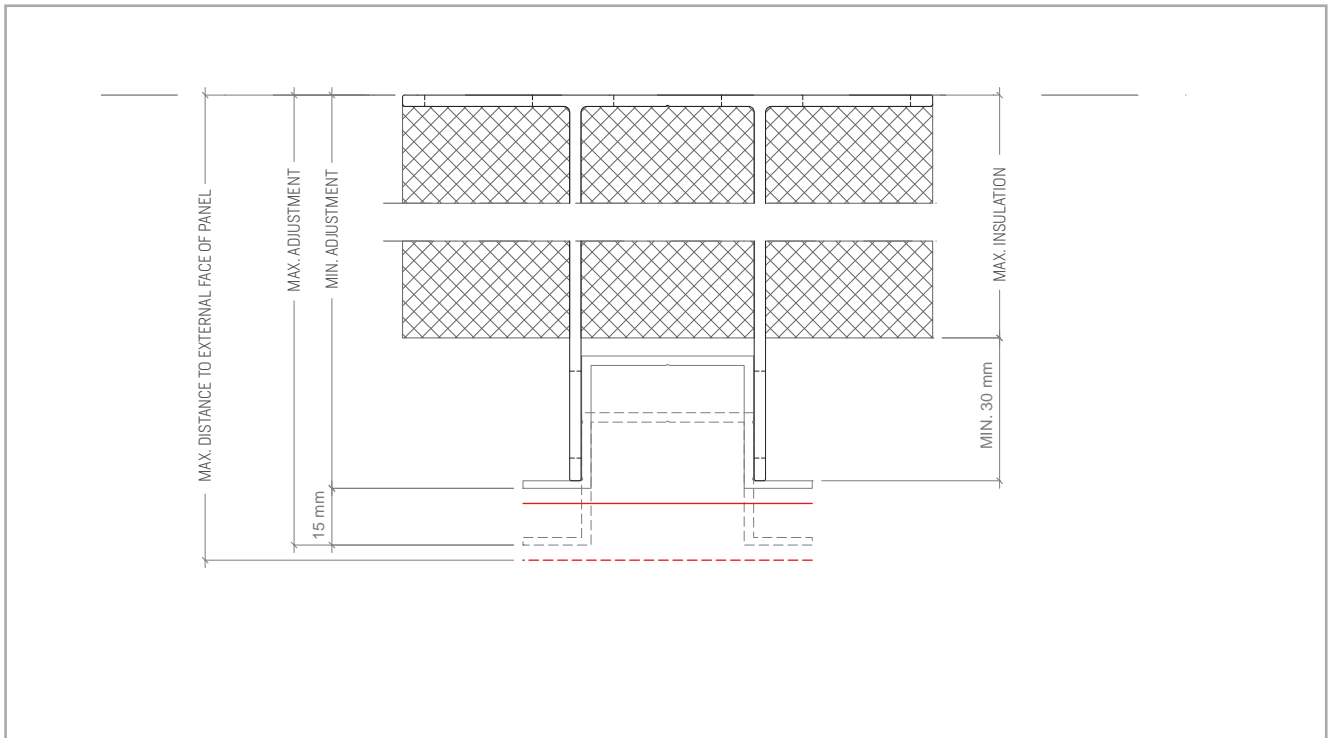


N°	NAME
----	------

- | | |
|---|---------------------------|
| 1 | STACBOND® composite panel |
| 2 | Profile OMEGA |
| 3 | Spacer DOUBLE T |
| 4 | Through screw M 6 x 60/70 |
| 5 | Blind rivet |

STB-REM SYSTEM

SPACER / THERMAL INSULATION RELATIONSHIP



SPACER DOUBLE T *		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.004	SPACER DOUBLE T 59	63	78	30
05.19.005	SPACER DOUBLE T 74	78	93	50
05.19.006	SPACER DOUBLE T 891	93	108	60
05.19.007	SPACER DOUBLE T 104	108	123	80
05.19.030	SPACER DOUBLE T 119	123	138	100
05.19.031	SPACER DOUBLE T 134	138	153	110
05.19.032	SPACER DOUBLE T 149	153	168	120
05.19.033	SPACER DOUBLE T 164	168	183	140
05.19.034	SPACER DOUBLE T 179	183	198	160
05.19.035	SPACER DOUBLE T 194	198	213	170
05.19.036	SPACER DOUBLE T 209	213	228	180
05.19.037	SPACER DOUBLE T 224	228	243	200
05.19.038	SPACER DOUBLE T 239	243	258	220
05.19.039	SPACER DOUBLE T 254	258	273	230

SPACER U *		DISTANCE (mm) FROM BASE OF FIXING TO VISIBLE FACE OF PANEL		RECOMMENDED INSULATION (mm) WITH 30 mm AIR CAVITY
REF.	PART	MIN.	MAX	
05.19.046	SPACER U 59	63	78	30
05.19.047	SPACER U 74	78	93	50

STB-REM SYSTEM

ACCESORIES

PROFILES

REF.	PART	PAGE
05.19.003	PROFILE OMEGA	106

FASTENING ACCESSORIES

REF.	PART	PAGE
STB-FIJA-201	RIVETER NOSEPIECE (RIVETS SSO-D15)	112
STB-FIJA-202	RIVETER NOSEPIECE (RIVETS AP)	
STB-FIJA-203	DUAL DIA. DRILL BIT (HSS-7,0/5,1x74)	
STB-FIJA-204	DEPTH LOCATOR 16x18	
STB-FIJA-205	CENTRING GAUGE (DG-146x20-7.0)	
STB-FIJA-206	REPLACEMENT NOSE PIECE FOR CENTRING GAUGE ø 6.9 mm	113
STB-FIJA-207	SPECIAL BIT FOR THE CENTRING GAUGE (HS-5.1x62/26)	
STB-FIJA-208	DRIVER BIT T20WW-25-HEX1/4"	
STB-FIJA-209	MANUAL CENTRING GAUGE FOR SCREWS SLA3	
STB-FIJA-210	SOCKET IRIUS G-00106.07	
STB-T0100	SECURITY SCREW 4.8x19 INOX HEAD TORX SLA3/6-S-D12-4.8x19	113
STB-R0100	BLIND RIVET ISO 15977 D5x12 CAB. 14 mm ALU/INOX AP14-S-5,.0x12	
STB-R0200	FACADE RIVET HEAD 15 mm INOX/INOX A4 5x14 SSO-D15-50140	

AUXILIARY ELEMENTS

REF.	PART	PAGE
05.19.020	MULLION JOINING STB-REM	110

SPACERS

REF.	PART	PAGE
05.19.004	SPACER DOUBLE T 59	108
05.19.005	SPACER DOUBLE T 74	
05.19.006	SPACER DOUBLE T 89	
05.19.007	SPACER DOUBLE T 104	
05.19.030	SPACER DOUBLE T 119	
05.19.031	SPACER DOUBLE T 134	
05.19.032	SPACER DOUBLE T 149	
05.19.033	SPACER DOUBLE T 164	
05.19.034	SPACER DOUBLE T 179	
05.19.035	SPACER DOUBLE T 194	
05.19.036	SPACER DOUBLE T 209	109
05.19.037	SPACER DOUBLE T 224	
05.19.038	SPACER DOUBLE T 239	
05.19.039	SPACER DOUBLE T 254	
05.19.030	SPACER U 46	
05.19.031	SPACER U 47	

INSULATING WEDGES

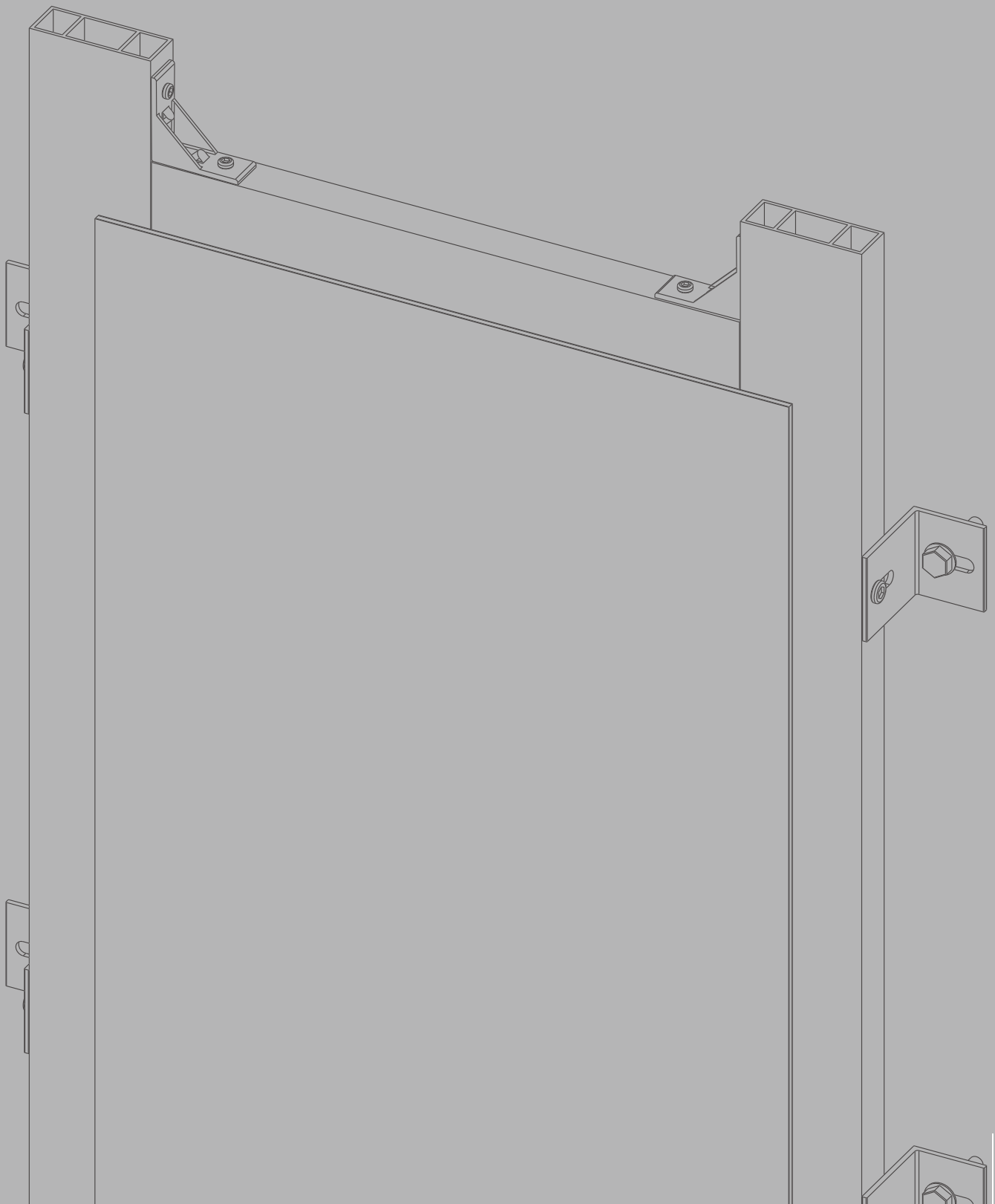
REF.	PART	PAGE
05.19.071	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.067 / 05.19.069 / 05.19.073	114
05.19.005	INSULATING WEDGE FOR SPACERS U * WITH REF.: 05.19.046 / 05.19.047	
05.19.069	INSULATING WEDGE FOR SPACERS DOUBLE T * WITH REF.: 05.19.030 / 05.19.031 / 05.19.032 / 05.19.033 / 05.19.034 / 05.19.035 / 05.19.036 / 05.19.037 / 05.19.038 / 05.19.039	
05.19.073	INSULATING WEDGE FOR SPACERS DOUBLE T * WITH REF.: 05.19.004 / 05.19.005 / 05.19.006 / 05.19.007	

INFORMATION AND SALES

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STB-PEG

GLUED SYSTEM



STB-PEG SYSTEM

DESCRIPTION



STB-PEG is a kit system based on flat panels made from **STACBOND®** composite panels for installing ventilated facades. It is a system with hidden fixings which is quick and economic to install and which allows both horizontal and vertical assembly.

As this is a glued system with chemical anchoring, it is resistant to aging and weathering; it absorbs vibration and allows numerous possibilities in facade design.

The substructure is made from lengths of **MULLIONS STB-PEG** (70 x 24.5 mm) and 6063 T5 aluminium alloy **spacers ANGULAR**.

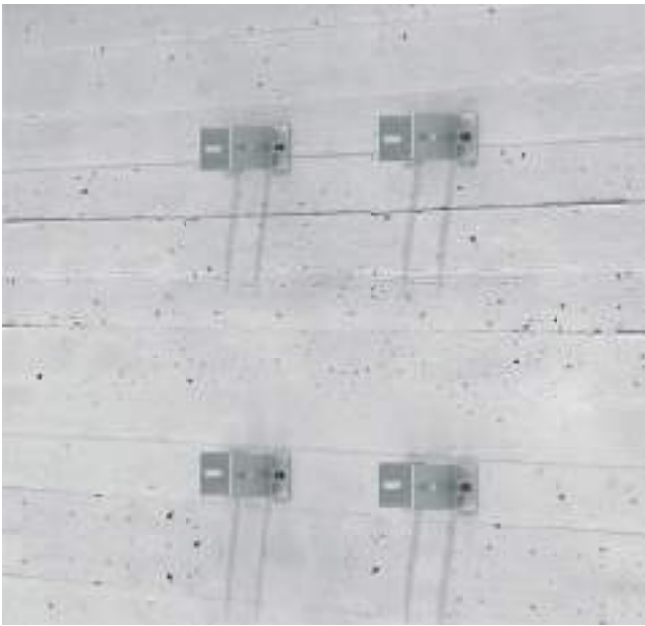
These spacers are placed opposite each other to bidimensionally absorb any irregularities in the facade.

The spacers are anchored to the wall using special mechanical fixings, recommended in each case by the fixings suppliers, and receive the **MULLIONS STB-PEG** as uprights.

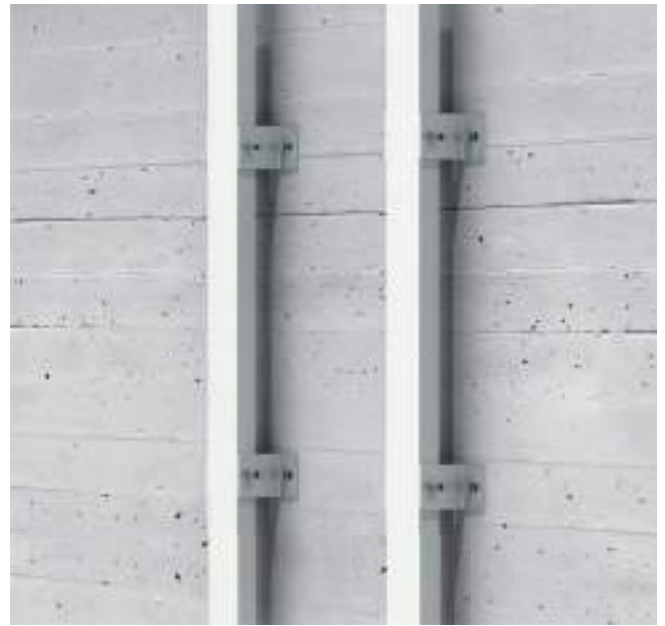
The **STB-PEG** system can be mounted on a unidirectional or bidirectional substructure. With a unidirectional substructure, the horizontal joint remains open. In the case of the bidirectional substructure, horizontal struts are attached to the uprights using **MULLION JOININGS STB-PEG** made of ZAMAK 5, or to the vertical face using spacers **ANGULAR**.

The **STACBOND®** composite panels are attached to the substructure using a specific adhesive and double-sided adhesive tape, in accordance with the manufacturer's instructions.

STAC® has developed a program for the specific calculations of the substructure for each project executed, defining the maximum distances between uprights.



SPACERS ANGULAR



MULLIONS STB-PEG

1. Spacers angular. The spacers angular join the uprights to the vertical face or supporting wall. They are either retaining or supporting. These are placed opposite each other and fixed to the vertical face using special mechanical anchors.

2. Placement of uprights. The mullions STB-PEG are screwed between the spacers angular. They must be perfectly plumb with the adjustment that the system allows. The first and last fixings must be placed at a maximum of 250 mm from the ends of the mullion.



HORIZONTAL MULLIONS



GLUING THE STACBOND COMPOSITE PANEL

3. Horizontal cross-struts (optional). These profiles are mechanically fixed to the vertical substructure using **mullion joinings STB-PEG**. The possibility of creating a bidirectional substructure allows the system to adapt to the requirements of the facade.

4. Attaching STACBOND® composite panel. Once the substructure is in place, the **STACBOND®** panels are attached to it using double-sided adhesive tape and adhesive, following the manufacturer's instructions.

STB-PEG SYSTEM

AUXILIARY ELEMENTS

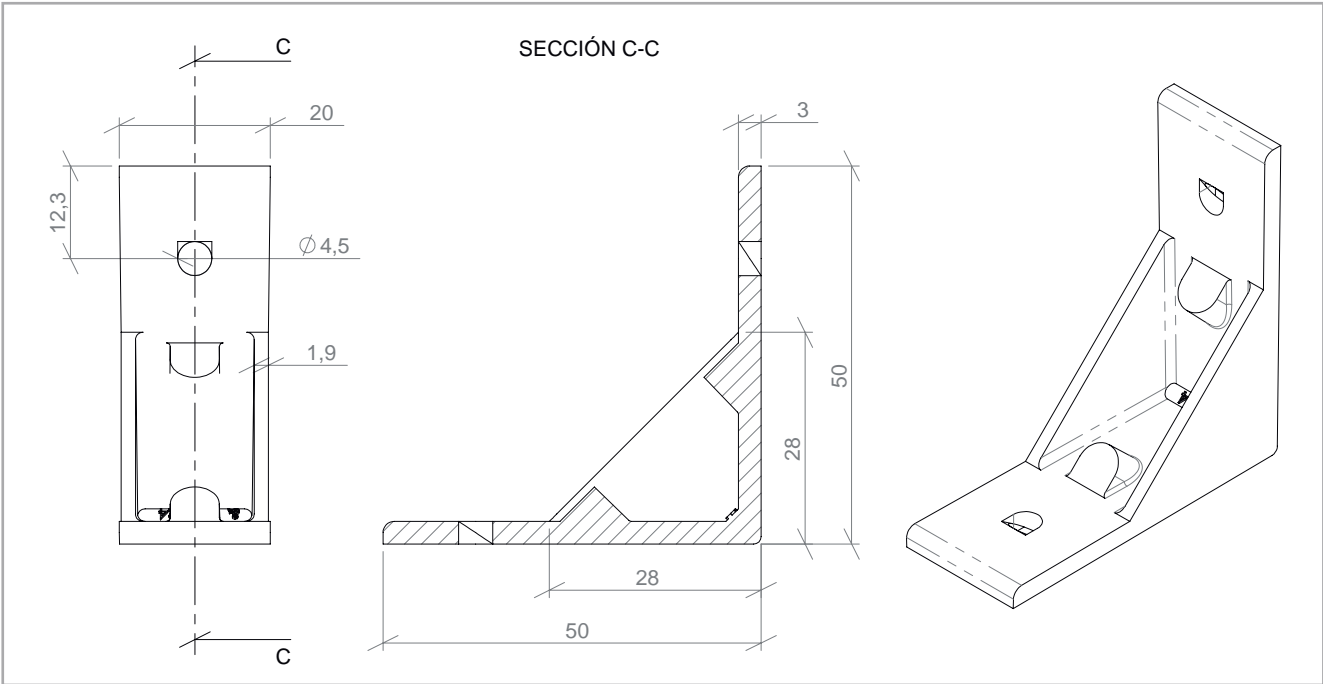
MULLION JOINING STB-PEG

The mullion joints STB-PEG are made of moulded ZAMAK 5 and allow the construction of bidirectional substructures via mechanical fixing between mullions STB-PEG uprights.

Fixing of these mullion joints is done using $\varnothing 4.8$ mm blind rivets or $\varnothing 4.8$ mm self-tapping screws. These coupling parts are compatible with possible dilation of the substructure.



REFERENCE	DESCRIPTION	UNITS/BOX
05.19.024	MULLION JOINING STB-PEG	100



Measurements in mm



1. Cleaning the substructure. The substructure must be clean, dry, homogenous, and free of oil, grease, dust and loose particles. Any paint, grout or other substances must be removed.

Precautions:

- Clean the surface with a damp paper towel, moving in one single direction, as if sanding. Solvents must never be used.
- For cleaning and degreasing, SIK-AVIATOR-205 or similar is used. It should be left to evaporate for 10 minutes minimum.

2. Priming the area. Priming should be done with a product which strengthens the adherence of the adhesive to the substructure – SIKATAACK PANEL PRIMER or similar.

Precautions:

- Once hardened, the primers can only be removed via mechanical means.
- The primer leaves a heterogeneous film. Only those surfaces which are to be glued should be treated.
- The evaporation times of the cleaning products must be adhered to (30 – 60 mins).

3. Applying the double-sided adhesive tape. The double-sided adhesive tape – SIKATAACK PANEL-3 or similar – is used to initially attach the panels until the main adhesive polymerizes and also ensures the minimum adhesive thickness of 3 mm. This absorbs and possible vibration or dilation produced in the **STACBOND®** composite panel facade. The long-term strength is only achieved with the adhesive.

4. Elastic adhesive. Apply a continuous vertical bead of elastic adhesive – SIKATAACK PANEL or similar – using a triangular nozzle (8 mm wide x 10 mm long), at least 5 mm away from the adhesive tape. To ensure correct application, the gun should be positioned perpendicular to the support.

Precautions:

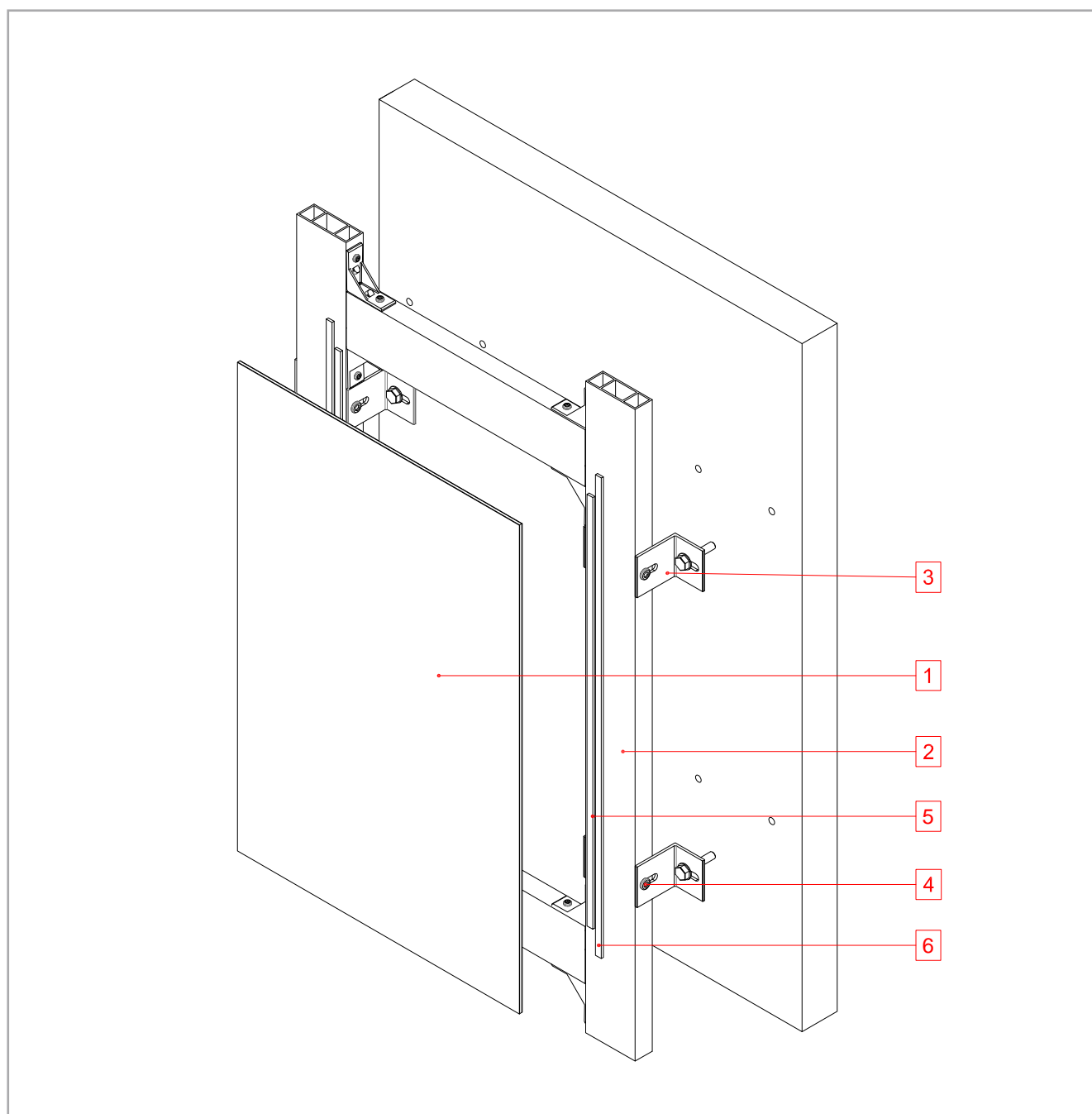
- The application of adhesive bead on the cross-struts of the substructure does not offer any structural function.

5. Placing the panel. Remove the protective film from the double-sided adhesive tape. Carefully place the panel in position precisely and press firmly until the panel contacts the double-sided adhesive tape.

Always follow the panel manufacturer's instructions for their storage. Avoid exposure to heat and direct sunlight prior to gluing the panels.

STB-PEG SYSTEM

INSTALLATION DIAGRAM



Nº NAME

- | | |
|---|----------------------------|
| 1 | STACBOND® composite panel |
| 2 | Mullion STB-PEG |
| 3 | Spacer angular |
| 4 | Self-tapping screw |
| 5 | Specific adhesive |
| 6 | Double-sided adhesive tape |

PROFILES

REF.	PART	PAGE
19.022	MULLION STB-PEG	106

AUXILIARY ELEMENTS


REF.	PART	PAGE
05.19.024	MULLION JOINING STB-PEG	110

SPACERS

REF.	PART	PAGE
19.021	SPACER ANGULAR	109

INFORMATION AND SALES

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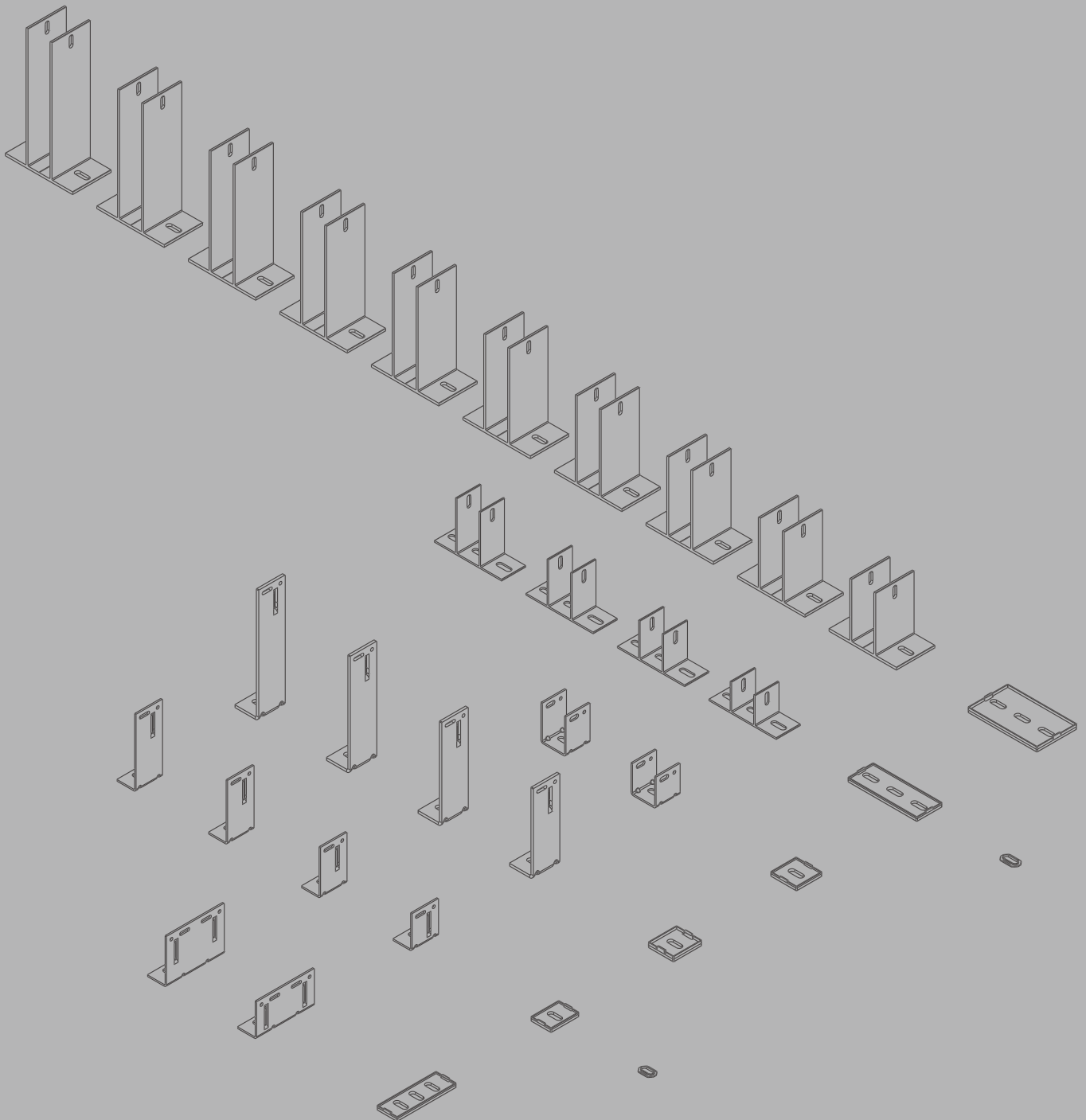
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ACCESSORIES

FOR ASSEMBLY SYSTEMS



STACBOND® ACCESSORIES

PROFILES



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.003	PROFILE OMEGA	6063 T5	12



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.040	PROFILE OMEGA F (2,5 mm)	6063 T5	12



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.043	PROFILE T	6063 T5	12



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.061	PROFILE T OMEGA	6063 T5	12



REFERENCE	PART	ALLOY	UNITS/BOX
19.022	MULLION STB-PEG	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
04.99.231	PROFILE REINFORCEMENT STB-SZ	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
01.34.550	PROFILE REINFORCEMENT STB-T-SZ	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.001	PROFILE S	6063 T5	24



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.002	PROFILE Z	6063 T5	18



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.074	PROFILE Z 20	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.063	PROFILE Z 24	6063 T5	-

Nota: the profiles are supplied with a length of 6500 mm. For other formats, please contac STAC®.

STACBOND® ACCESSORIES

SPACERS



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.004	SPACER DOUBLE T 59	6063 T5	96
05.19.005	SPACER DOUBLE T 74	6063 T5	80
05.19.006	SPACER DOUBLE T 89	6063 T5	80
05.19.007	SPACER DOUBLE T 104	6063 T5	72



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.030	SPACER DOUBLE T 119	6005 T6	50
05.19.031	SPACER DOUBLE T 134	6005 T6	24
05.19.032	SPACER DOUBLE T 149	6005 T6	40
05.19.033	SPACER DOUBLE T 164	6005 T6	40
05.19.034	SPACER DOUBLE T 179	6005 T6	36
05.19.035	SPACER DOUBLE T 194	6005 T6	24
05.19.036	SPACER DOUBLE T 209	6005 T6	24
05.19.037	SPACER DOUBLE T 224	6005 T6	30
05.19.038	SPACER DOUBLE T 239	6005 T6	25
05.19.039	SPACER DOUBLE T 254	6005 T6	24



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.004F	SPACER DOUBLE T 59 F	6063 T5	-
05.19.005F	SPACER DOUBLE T 74 F	6063 T5	-
05.19.006F	SPACER DOUBLE T 89 F	6063 T5	-
05.19.007F	SPACER DOUBLE T 104 F	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.030F	SPACER DOUBLE T 119 F	6005 T6	-
05.19.031F	SPACER DOUBLE T 134 F	6005 T6	-
05.19.032F	SPACER DOUBLE T 149 F	6005 T6	-
05.19.033F	SPACER DOUBLE T 164 F	6005 T6	-
05.19.034F	SPACER DOUBLE T 179 F	6005 T6	-
05.19.035F	SPACER DOUBLE T 194 F	6005 T6	-
05.19.036F	SPACER DOUBLE T 209 F	6005 T6	-
05.19.037F	SPACER DOUBLE T 224 F	6005 T6	-
05.19.038F	SPACER DOUBLE T 239 F	6005 T6	-
05.19.039F	SPACER DOUBLE T 254 F	6005 T6	-



REFERENCE	PART	ALLOY	UNITS/BOX
19.021	SPACER ANGULAR	6063 T5	100



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.046	SPACER U 59	5005 H24	125
05.19.047	SPACER U 74	5005 H24	100



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.042	SPACER L 68 ST-2-120	5005 H24	250
05.19.045	SPACER L 92 ST-2-120	5005 H24	180



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.041	SPACER L 68 ST-1-55	5005 H24	500
05.19.044	SPACER L 92 ST-1-55	5005 H24	200
05.19.051	SPACER L 116 ST-1-55	5005 H24	180
05.19.052	SPACER L 140 ST-1-55	5005 H24	276
05.19.053	SPACER L 164 ST-1-55	5005 H24	130
05.19.054	SPACER L 188 ST-1-55	5005 H24	135
05.19.055	SPACER L 212 ST-1-55	5005 H24	120
05.19.056	SPACER L 236 ST-1-55	5005 H24	100

STACBOND® ACCESSORIES

AUXILIARY ELEMENTS



REFERENCE	PART	ALLOY	UNITS/BOX
05.99.231	REINFORCEMENT STB-SZ	6063 T5	174



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.049	REINFORCEMENT STB-T-SZ	6063 T5	180



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.020	MULLION JOINING STB-REM	5005 H24	150



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.024	MULLION JOINING STB-PEG	ZAMAK 5	100



REFERENCE	PART	ALLOY	UNITS/BOX
19.021	SPACER ANGULAR	6063 T5	100



REFERENCE	PART	ALLOY	UNITS/BOX
STB-JEPDM	EPDM GASKET PROFILE SZ (m.l.)	-	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.013	BRACKET SET STB-CH HANGING	6063 T5	200



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.062	BRACKET SET STB-T-CH HANGING	6063 T5	200



REFERENCE	PART	ALLOY	UNITS/BOX
19.019	HANGING REINFORCEMENT	1050 H24	500



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.050	CASSETTES FORMING PLATE	1050 H24	3000



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.025	STIFFENER SCH-1 (< 750 mm)	-	-
05.19.026	STIFFENER SCH-2 (750 - 1500 mm)	-	-
05.19.027	STIFFENER SCH-3 (> 1500 mm)	-	-
05.19.027.1	STIFFENER SCH-4 (2400 - 4000 mm)	-	-
05.19.027.2	STIFFENER SCH-5 (4000 - 5000 mm)	-	-
05.19.027.3	STIFFENER SCH-6 (> 5000 mm)	-	-

STACBOND® ACCESSORIES

FASTENING ACCESSORIES



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-201	RIVETER NOZZLES (RIVETS SSO-D15)	Limits cinch strength for mobile anchoring points	1
STB-FIJA-202	RIVETER NOZZLES (RIVETS AP)	Limits cinch strength for mobile anchoring points	1



REFERENCE	PART	OBSERVATIONS	MIN./UNITS
STB-FIJA-203	DUAL DIA. DRILL BIT (HSS-7,0/5,1x74)	Drills panel to 7 mm and the substructure to 5.1 mm	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-204	DEPTH LIMIT (DEPTH LOCATOR 16x18)	Works with the dual diameter bit to stop the 7 mm shank drilling into the substructure	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-205	CENTRING GAUGE (DG-146x20-7.0)	To make the 5.1 mm hole in the substructure through the 7 mm hole in the panel	1
STB-FIJA-206	REPLACEMENT NOSE PIECE FOR CENTRING GAUGE ø 6.9 mm	Replacement nose piece in the event of damage.	1
STB-FIJA-207	SPECIAL DRILL BIT FOR THE CENTRING GAUGE (HS-5.1x62/26)	Special drill bit for the gauge with shorter helical shaft.	1



REFERENCE	PART	MIN. UNITS	UNITS/BOX
STB-FIJA-208	DRIVER BIT T20WW-25-HEX1/4"	1	1



REFERENCE	PART	MIN. UNITS	UNITS/BOX
STB-FIJA-209	MANUAL CENTRING GAUGE FOR SCREWS SLA3	1	1



REFERENCE	PART	MIN. UNITS.	UNITS/BOX
STB-FIJA-210	SOCKET IRIUS G-00106.07	1	1



REFERENCE	PART	FINISH	MIN. UNITS	UNITS/BOX
STB-T0100	SECURITY SCREW 4.8x19 INOX HEAD TORX	UNPAINTED	100	100
	SLA3/6-S-D12-4.8x19	PAINTED - RAL CHART	250	100



REFERENCE	PART	FINISH	MIN. UNITS	UNITS/BOX
STB-R0100	BLIND RIVET ISO 15977 D5x12 CAB. 14 mm	UNPAINTED	100	100
	ALU/INOX AP14-S-5,0x12	PAINTED - RAL CHART	250	100

APPLICATION: To attach **STACBOND®** panels to STB-REM / STB-T-REM substructures.



REFERENCE	PART	FINISH	MIN. UNITS	UNITS/BOX
STB-R0200	FACADE RIVET HEAD 15 mm INOX/INOX A4 5x14	UNPAINTED	100	100
	SSO-D15-50140	PAINTED - RAL CHART	250	100

APPLICATION: To attach **STACBOND®** panels to STB-REM / STB-T-REM substructures for environments with high chloride exposure.



REFERENCE	PART	FINISH	MIN. UNITS	UNITS/BOX
STB-R0300	BLIND RIVET POLYGRIP SFS ASO-D-48150	UNPAINTED	100	100
	ALU/INOX 4.8X15	PAINTED - RAL CHART	250	100

APPLICATION: To form CH and SZ cassettes from **STACBOND®** composite panels

STACBOND® ACCESSORIES

INSULATING WEDGES FOR SPACERS OMEGA / U



REFERENCE	PART	UNITS/BOX
05.19.071	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.067 / 05.19.069 / 05.19.073	2500



REFERENCE	PART	UNITS/BOX
05.19.067	INSULATING WEDGE FOR SPACERS U* WITH REF.: 05.19.046 / 05.19.047	700



REFERENCE	PART	UNITS/BOX
05.19.069	INSULATING WEDGE FOR SPACERS DOUBLE T* WITH REF.: 05.19.030 / 05.19.031 / 05.19.032 / 05.19.033 / 05.19.034 / 05.19.035 / 05.19.036 / 05.19.037 / 05.19.038 / 05.19.039	400



REFERENCE	PART	UNITS/BOX
05.19.073	INSULATING WEDGE FOR SPACERS DOUBLE T* WITH REF.: 05.19.004 / 05.19.005 / 05.19.006 / 05.19.007	400



STACBOND® ACCESSORIES

INSULATING WEDGES FOR SPACERS L



REFERENCE	PART	UNITS/BOX
05.19.070	3 x GROOVE WASHER FOR INSULATING WEDGES WITH REF.: 05.19.066 / 05.19.068 / 05.19.072	2500



REFERENCE	PART	UNITS/BOX
05.19.066	INSULATING WEDGE FOR SPACERS L * ST-2-120 WITH REF.: 05.19.042 / 05.19.045	400



REFERENCE	PART	UNITS/BOX
05.19.068	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.053 / 05.19.054 / 05.19.055 / 05.19.056	700




REFERENCE	PART	UNITS/BOX
05.19.072	INSULATING WEDGE FOR SPACERS L * ST-1-55 WITH REF.: 05.19.041 / 05.19.044 / 05.19.051 / 05.19.052	800



INFORMATION AND SALES

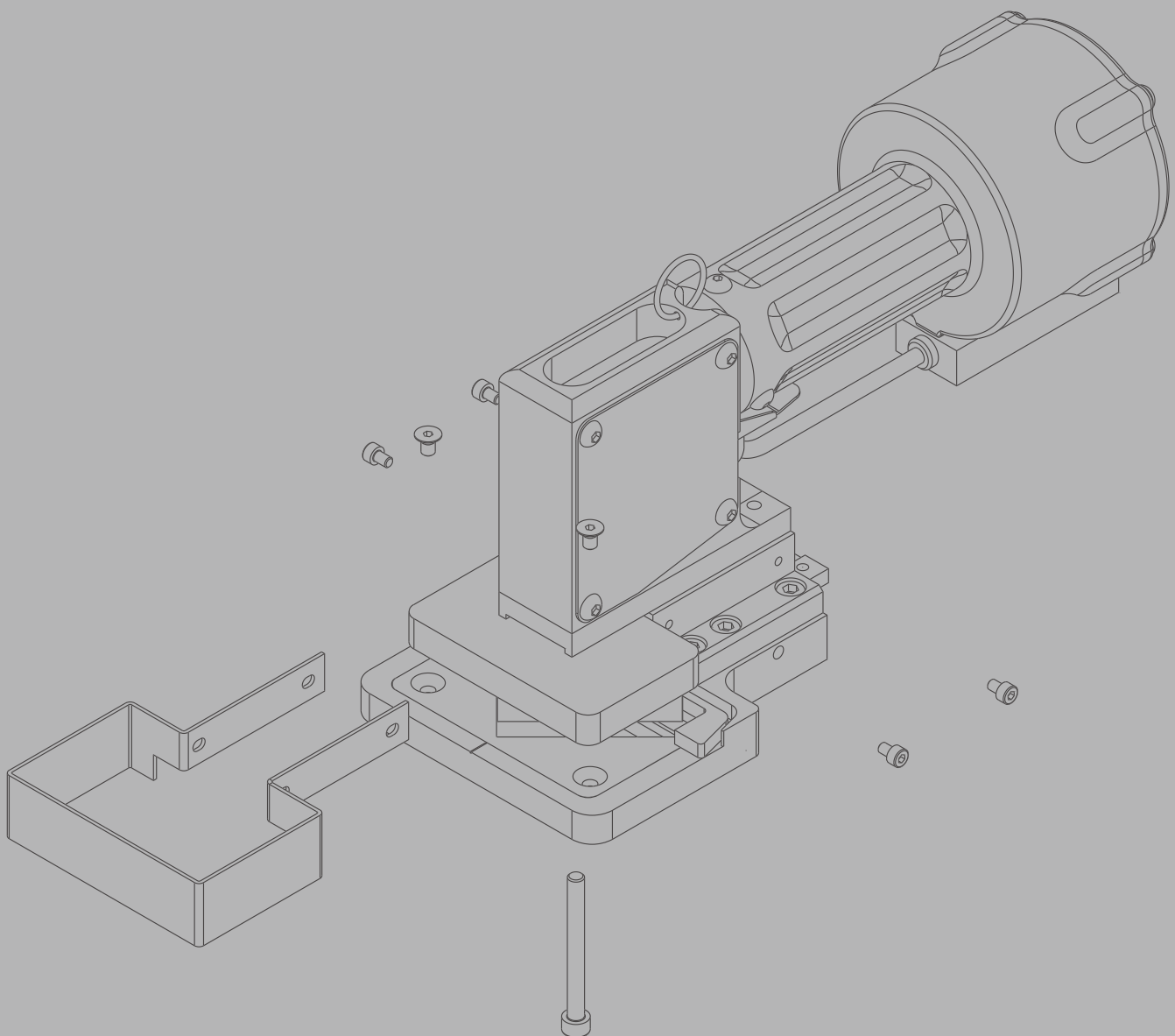
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PROCESSING TOOLS



STACBOND® PROCESSING TOOLS

MANUAL DIE-CUTTING MACHINE



HANGING BOOT TOOLING DETAIL



V TOOLING DETAIL



STACBOND® DIE-CUTTING MACHINE MANUAL

Easy-to-use and very versatile hand tool for use in the workshop as well as for mobile use in the assembly of facades, trade fairs, etc.

This machine is the ideal complement to work together with a manual milling machine or a wall saw.

Its interchangeable tools, specifically developed for the CH and SZ cassette formats of the **STACBOND®** assembly systems, enable the hanging boots and corners to be die-cut for correct shaping.



REFERENCE	DESCRIPTION	OBSERVATIONS	MIN. UNITS
STB-MC-0010	STACBOND® MANUAL DIE-CUTTING MACHINE WITH HANGING BOOT DIE-CUTTING TOOLING	Pre-assembled hanging boot tool allows adjustment for 40 and 45 mm flaps.	1
STB-MC-0011	STACBOND® MANUAL DIE-CUTTING MACHINE WITH V DIE-CUTTING TOOLING	The pre-assembled V-shaped tooling is used to make the cassette forming corners.	1
STB-MC-0013	STACBOND® MANUAL DIE-CUTTING MACHINE WITH HANGING BOOT DIE-CUTTING AND V DIE-CUTTING TOOLING	Available interchangeable tools (follow the instructions for use).	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FMD4X80X3.8	HM HSS MILLING CUTTER Ø4x80,5x3,8 Z=2 Ø12 BODY 4 mm PANEL CUTTING	Ø 4 mm hard metal milling cutter for panel cutting with 4 mm thickness (marking)	1
STB-FMD5X80X2.8	HM HSS MILLING CUTTER Ø5x80x2,8 Z=2 Ø12 BODY 3 mm PANEL CUTTING	Ø 5 mm hard metal milling cutter for panel cutting with 3 mm thickness (dilation)	1
STB-FMD5X80X3.8	HM HSS MILLING CUTTER Ø5x80x3,8 Z=2 Ø12 BODY 4 mm PANEL CUTTING	Ø 5 mm hard metal milling cutter for panel cutting with 4mm thickness (dilation)	1
STB-FMD6X80X2.8	HM HSS MILLING CUTTER Ø6x80x2,8 Z=2 Ø12 BODY 3 mm PANEL CUTTING	Ø 6 mm hard metal milling cutter for panel cutting with 3 mm thickness (dilation)	1
STB-FMD6X80X3.8	HM HSS MILLING CUTTER Ø6x80x3,8 Z=2 Ø12 BODY 4 mm PANEL CUTTING	Ø 6 mm hard metal milling cutter for panel cutting with 4 mm thickness (dilation)	1
STB-FMD6X80X3.8	HM HSS MILLING CUTTER Ø6x80x3,8 Z=2 Ø12 BODY 4 mm PANEL CUTTING	Ø 6 mm hard metal milling cutter for panel cutting with 6 mm thickness (dilation)	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FD6X80X2.8	DIAMOND HSS MILLING CUTTER COHERSA SPECIAL H4 PCD Ø6x80x2,8 Z=2 Ø12 HM BODY	Ø 6 mm diamond milling cutter for panel cutting with 3 mm thickness	1
STB-FD6X80X3.8	DIAMOND HSS MILLING CUTTER COHERSA SPECIAL H4 PCD Ø6x80x3,8 Z=2 Ø12 HM BODY	Ø 6 mm diamond milling cutter for panel cutting with 4 mm thickness	1
STB-FD6X80X5.8	DIAMOND HSS MILLING CUTTER COHERSA SPECIAL H4 PCD Ø6x80x5,8 Z=2 Ø12 HM BODY	Ø 6 mm diamond milling cutter for panel cutting with 6 mm thickness	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FRESAD6PCD	DIAMOND HSS MILLING CUTTER SECO PCD Ø6x75x3,8 Ø12 HM BODY	Ø 6 mm diamond milling cutter for panel cutting with 4 mm thickness with A2 core	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FMD-C45	HM HSS MILLING CUTTER Ø3x81 90° SPECIAL REF. 1 Z=2 Ø12 BODY	Hard metal milling cutter for 45° cutting	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FRESA90	HM HSS MILLING CUTTER Ø3x81 ESPECIAL REF. 1 Z=2 Ø16 BODY	Hard metal milling cutter for 90° v-groovi ng	1

STACBOND® PROCESSING TOOLS

MILLING CUTTERS FOR CNC MACHINES



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FEMD-10x72	HM HSS SPHERICAL MILLING CUTTER WITH DIAMOND COATING Ø10x72 Z=2 Ø10 BODY (COD:JS532100D1B.0Z2-NXT)	Ø 10 mm milling cutter with diamond coating for spherical grooving of panel with PE/FR core	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FRESAD10PCD	DIAMOND HSS SPHERICAL MILLING CUTTER SECO PCD Ø10x73 Ø10 HM BODY	Ø 10 mm diamond milling cutter for spherical grooving of panel with A2 core	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FEMD-20X100	HM HSS SPHERICAL MILLING CUTTER Ø20x100 UHM 30° Z=2 Ø20 BODY	Ø20mm hard metal milling cutter for spherical grooving	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FRESA135	HM HSS MILLING CUTTER Ø3xØ32x80x38,8 R0,2 Z=2 Ø16 BODY	Hard metal milling cutter for 45° cutting	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FPCD-135	DIAMOND HSS MILLING CUTTER Ø35x175 Z=2 Ø16 BODY	Diamondmilling cutter for 135° v-grooving of panel with A2 core	1

INFORMATION AND SALES

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STACBOND® would be pleased to help with any enquiry.

For further information, please visit our website or get in touch and we'll study a solution that meets your requirements.

We provide technical assistance in Spanish, English, French, German and Italian.



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