

STAC BOND®

ALUMINIUM COMPOSITE PANEL

GENERAL CATALOGUE



elemental
Architectural Cladding Specialists

www.elemental.ie

Tel: (01) 293 8951



Nº 553A/12



CERTIFIÉ CSTB CERTIFIED
111-113 / 111-114



Agrément Certificate
13/5022



AT-15-8778/2012

STAC BOND®

ALUMINIUM COMPOSITE PANEL



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STAC BOND®

STAC (Sistemas Tecnicos del Accesorio y Componentes, S.L.) has achieved with **STACBOND®**, a worldwide brand reference with respect to the installation of ventilated façades.

Since 2001, **STAC** has developed products that are focused on aluminium carpentry systems and curtain walling as well as polyamide profiles for thermal breaking and gaskets. From 2008, with its eagerness for growth and innovation, **STAC commenced the design and production of its own constructive systems** for the execution of architectonic façades by using **STACBOND®**, a very high quality panel that allows for a multitude of constructive possibilities thanks to its versatility and excellent physical and mechanical properties.

The Composite Panel **STACBOND®** is comprised of two aluminium sheets that are joined together with a nucleus of thermoplastic resins. It is sold in 3 varieties, **STACBOND®PE**, **STACBOND®FR** (Fire Retard) and **STACBOND®INTdesign**, along with an extensive range of finishes that adapt to the national and international market requirements.

The **STACBOND® STB-CH**, **STB-SZ** and **STB-RIVETED** panel systems are certified by way of the BBA 13/5022 [Technical Suitability Document] which consolidates the fact that STAC are in the forefront of the development of façade products. The purpose of this document is to guarantee the reliability and efficiency of our systems.

- 10,000 m² of covered installations.
- An annual manufacturing capacity of 1,000,000 m² of composite panel.
- 500,000 m² of fabrication capacity.
- An extensive colour range.
- Personalised attention from our own technical department.
- 8 latest generation CNC fabrication centres in order to offer service to our clients.
- On Site technical assistance.



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Discover all the possibilities of the **STACBOND®** Composite Panel

STACBOND® application possibilities

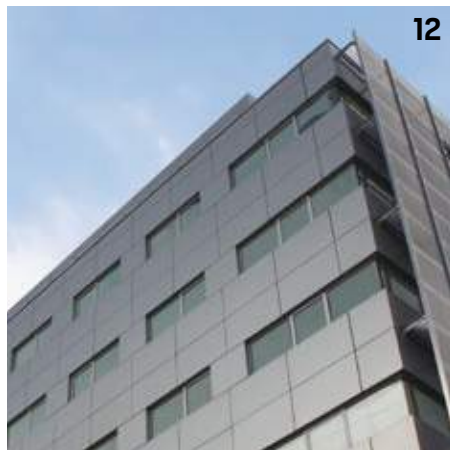
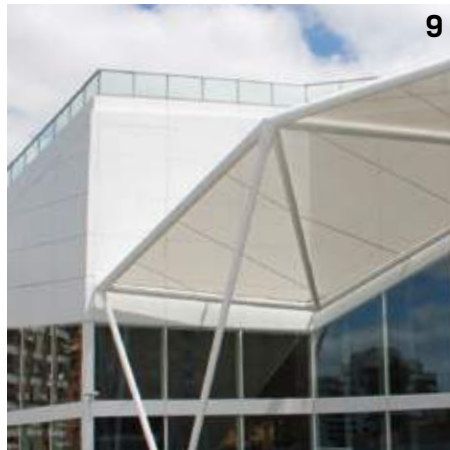
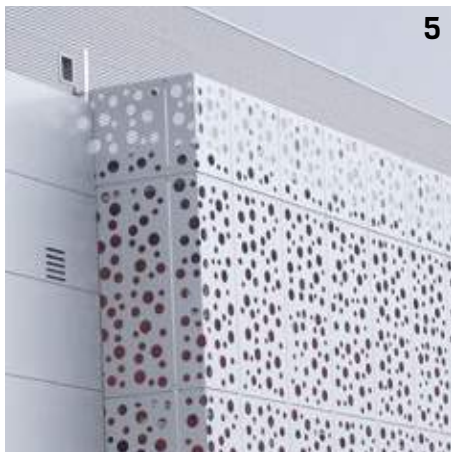
- Homes
- Hospitals and Health Centres
- Cultural and Social Buildings
- Sports Installations
- Shopping Centres
- Company Head offices and administration buildings
- Hotels
- Universities and research centres
- Infrastructures
- Refurbishments



INDIVIDUAL INSTALLATIONS

The **STACBOND®** Composite Panel can be found in the most important architectonic installations that have been recently installed both nationally and Internationally, some of which can be seen in continuation..

1	Álvaro Cunqueiro Metropolitan Hospital – STACBOND®FR	Pág. 6
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Álvaro Cunqueiro Metropolitan Hospital. Vigo (Spain)

ARCHITECT: Luis vidal + architects



Colonial Real Estate Offices. Barcelona (Spain)

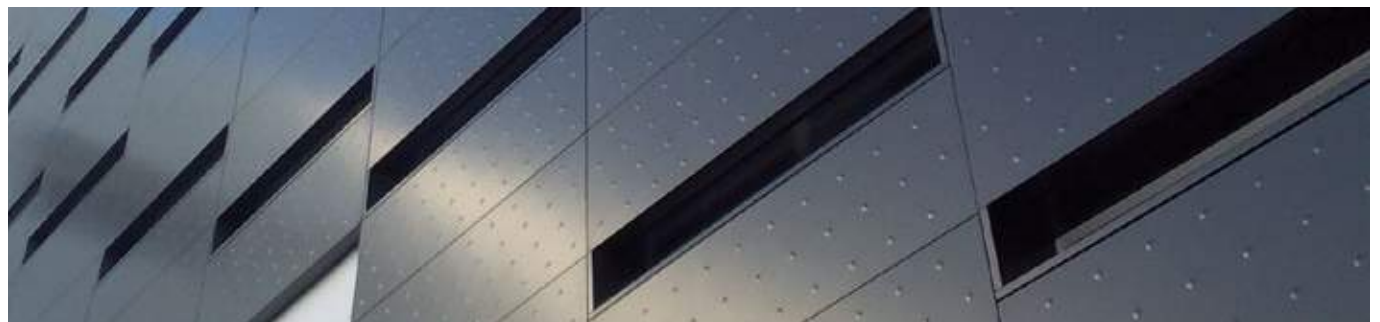
ARCHITECT: Octavio Mestre Architects



Marineda Shopping Centre. A Coruña (Spain)
ARCHITECT: mmo Architects



A Coruña University Hospital Complex. A Coruña (Spain)
ARCHITECT: Casa Consultors i Arquitectes. S.L.



Lourdes Hospital. Lisboa (Portugal)
ARCHITECT: Albert de Pineda y Saraiva +Asociados



Abella Shopping Centre. Lugo (Spain)
ARCHITECT: Manuel Villar



Petavatio Laser Centre. Valladolid (Spain)

ARCHITECT: Vicente-Núñez Architects



Galeón Shopping Centre. Tenerife (Spain)

ARCHITECT: Guido Meira Acuña



Adif Station. Logroño [Spain]
ARCHITECT: Ábalos + Sentkiewicz Architects



Santander Meteorological Centre. Santander [Spain]
ARCHITECT: Agustín Cámara Tercero



Oujda Angad Airport. Oujda (Morocco)

ARCHITECT: Abdou Lahlou



Mar de Vigo Congress Auditorium. Vigo (Spain)

ARCHITECT: César Portela

TECHNICAL DEPARTMENT

In **STACBOND®** you can count on an ample and qualified technical department who work widely in collaboration with its clients in developing constructive systems that adapt to each particular installation. It also has site technicians with a wide experience in the execution and installation of ventilated façades.

Should you wish to consult with us please do not hesitate contacting our technical department or the **STACBOND®** representative and we will attend to your requests willingly.

☎ T (+34) 981 817 036

☎ F (+34) 981 817 231

✉ stacbond@stac.es

Our web page facilitates our clients with all the necessary information for **STACBOND®** Composite Panel as well as the various STAC divisions such as **STACPOL®** Weather Tightness gaskets, **STAC®** Hardware and Accessories, **STACPLAST®** PVC Profiles and **STACMID®** Polyamide Profiles



High quality for your ideas

The **STACBOND®** panel has an external aluminium alloy 3005/ 3015 / 5005 sheet and is **coated with the highest quality PvdF Kynar® 500 70/30 paint** (polyvinyl fluoride) that offers the **highest resistance to corrosion and ageing.**

We work with two types of internal cores made up of thermoplastic resin (low density polyethelene) one of which is made with fire retardant that has a fire classification of B-S1 d0 according to UNE-EN-13501-1:2007. Both cores offer a **high degree of thermal and accoustic insulation.**

The manufacture of **STACBOND®** Composite Panel follows a controlled process by way of **rigorous internal tests and quality controls** in our laboratory as well as external controls by way of audits from the most prestigious construction institutes in the countries where we are certified and these most demanding national and international certifications are available to our clients which are detailed below:

- **ISO 9001** 9001 manufacture, fabrication and storage.
- **DIT** 553A/12 for Spain.
- **CSTB** 111-113 / 111-114 for France.
- **BBA** 13/5022 for the United Kingdom.
- **ITB** AT-15-8778/2012 for Poland.

The granting of these certificates follows the European GUIDE EOTA 034 Directive for ventilated façades and concludes that our constructive systems conform with the national regulations of each country.



Nº 553A/12



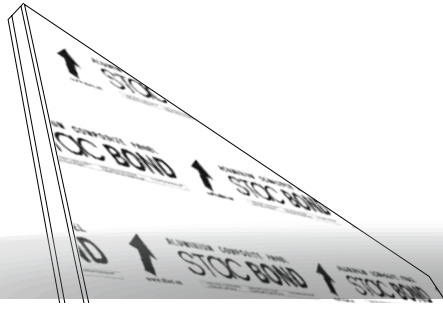
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Agrément Certificate
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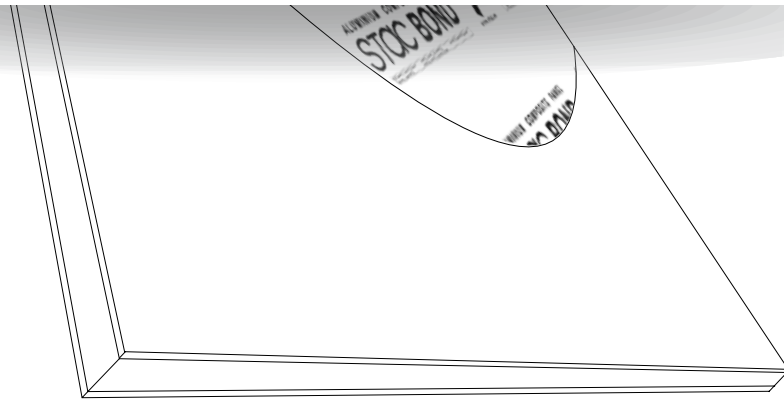


AT-15-8778/2012



ALUMINIUM **COMPOSITE PANEL**

STOC BOND®



PRODUCT RANGE



STAC BOND PE
 ALUMINIUM COMPOSITE PANEL

FR ALUMINIUM COMPOSITE PANEL
FIRE RETARD

int STAC BOND
DESIGN
 ALUMINIUM COMPOSITE PANEL

STAC BOND PE

ALUMINIUM COMPOSITE PANEL

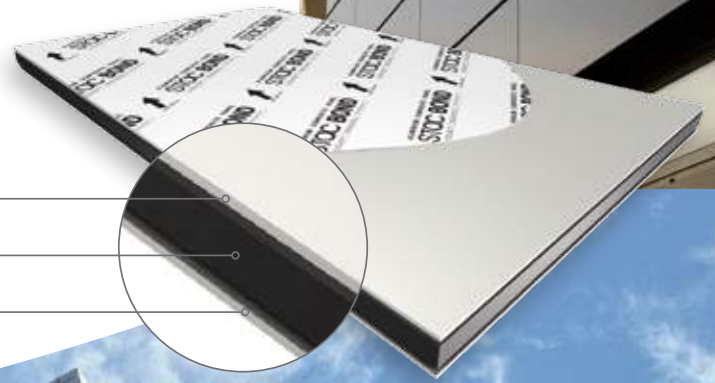
The **STACBOND®PE** with an internal core of thermoplastic resins (low density polyethelene) has excellent mechanical properties, a high degree of accoustic insulation, high impact resistance, increased rigidity and weight reduction and thanks to these characteristics it can be counted on for multiple application possibilities such as:

- Ventilated Façades
- Coverings and false ceilings
- Balconies and cantilevers
- External doors, front doors and canopies
- Urban street furniture equipment
- All types of external fittings
- Industrial applications (automation, railways, furniture, bodywork, etc.).

0.50 mm aluminium coated PVDF Kynar

Polyethelene core

0.50 mm aluminium Primer





TECHNICAL SPECIFICATIONS

STACBOND® PE

SHEET DIMENSIONS	WIDTHS (mm)	LENGTHS (mm)
Stock sizes	1250 - 1500	4000 - 5000
Made to measure manufacture (CONSULT)	1000 -1250 - 1500	(min.max.) 2000 / 6000

Thickness tolerance (mm) $\pm 0,2$	Width tolerance (mm) ± 2	Length tolerance (mm) $+ 15$	Diagonals tolerance (mm) ± 3
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PHYSICAL SPECIFICATION	UNITS	SIZE	CERTIFICATION
Aluminium thickness	mm	0,5	
Panel thickness	mm	4	
Panel weight	kg/m ²	5,5	
Aluminium alloy		3005 / 3105 / 5005	UNE EN 573-3

PE CORE SPECIFICATION	UNITS	SIZE	CERTIFICATION
Density	gr/cm ³	0,92	

TYPE OF PAINT	UNITS	SIZE	CERTIFICATION
PvdF KINAR 500 (70/30)	μ_m	20 - 40 μ_m *	
Brightness	MEASURED AT 60° ANGLE	30 +/- 5 *	EN 13523 - 2 ISO 2813
Hardness		Min F	EN 13523 - 4
Priming protection			YES

GENERAL CHARACTERISTICS	UNITS	SIZE	CERTIFICATION
Peeling	N/mm	$\geq 9,8$	ASTM D903 - 98 (2004)
Adherence		There is no loss of adherence	EN - DIN - 53151
Elasticity module (E)	N/mm ²	70000	EN 485 - 2
Elasticity limit (R _p 0.2)	N/mm ²	≥ 80	EN 485 - 2
Break loading (R _m)	N/mm ²	$125 \leq R_m \leq 240$	EN 485 - 2
Lengthening (A)	%	≥ 2	EN 485 - 2
Impact resistance		4 Joules / GTØ	EN 13523 - 5/6
Chemical resistance		5% HCL Without changes	ISO 2812 - MÉTHOD 3
Temperature utilization	°C	- 50° / 80° ^a	
Thermal expansion for differences of 100° C	mm/m (100° ^a)	2,25	UNE-EN ISO 10545:1997
Thermal transmission (U)	W/m ² K	3,38	UNE-EN ISO 12567-1
Accoustic insulation Rw (C;Ctr)	dB	26 [-1; -3]	ISO 140 - 3

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

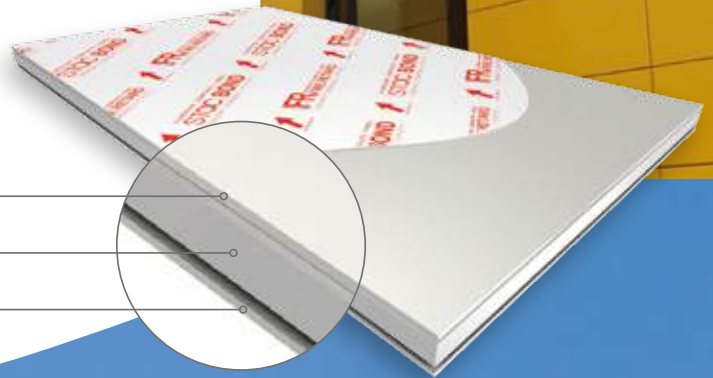
STACBOND **FR** ALUMINIUM COMPOSITE PANEL
FIRE RETARD

The **STACBOND®FR** has been developed to comply with the highest demands from the current norms for fire protection. Its internal core consisting of thermoplastic resins (low density polyethelene and fire retardant) has a fire classification of B-S1,d0 according to UNE-EN-13501-1:2007.

0.50 mm aluminium coated PVDF Kynar

Fire Retard Core

0.50 mm aluminium Primer





TECHNICAL SPECIFICATIONS

STACBOND®FR

SHEET DIMENSIONS	WIDTHS (mm)	LENGTHS (mm)
Stock sizes	1250 - 1500	4000 - 5000
Made to measure manufacture (CONSULT)	1000 -1250 - 1500	(min.max.) 2000 / 6000

Thickness tolerance (mm) $\pm 0,2$	Width tolerance (mm) ± 2	Length tolerance (mm) $+ 15$	Diagonals tolerance (mm) ± 3
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PHYSICAL SPECIFICATION	UNITS	SIZE	CERTIFICATION
Aluminium thickness	mm	0,5	
Panel thickness	mm	4	
Panel weight	kg/m ²	8,02	
Aluminium alloy		3005 / 3105 / 5005	UNE EN 573-3

FR CORE SPECIFICATION	UNITS	SIZE	CERTIFICATION
Density	gr/cm ³	1,6 - 1,8	
Fire Resistance		B - S1, d0	UNE-EN-13501-1:2007

TYPE OF PAINT	UNITS	SIZE	CERTIFICATION
PvdF KYNAR 500 (70/30)	μ_m	20 - 40 μ_m *	
Brightness	MEASURED AT 60° ANGLE	30 +/- 5 *	EN 13523 - 2
Hardness		Min F	EN 13523 - 4
Priming protection			YES

GENERAL CHARACTERISTICS	UNITS	SIZE	CERTIFICATION
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
Elasticity limit (R _p 0.2)	N/mm ²	≥ 80	EN 485 - 2
Break loading (R _m)	N/mm ²	$125 \leq R_m \leq 240$	EN 485 - 2
Lengthening (A)	%	≥ 2	EN 485 - 2
Impact resistance		4 Joules / GT0	EN 13523 - 5/6
Chemical resistance		5% HCL Without changes	
Temperature utilization	°C	- 50° / 80° ^a	
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
Accoustic insulation Rw [C;Ctr]	dB	29 [0; -2]	ISO 140 - 3

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

int STAC BOND DESIGN

ALUMINIUM COMPOSITE PANEL

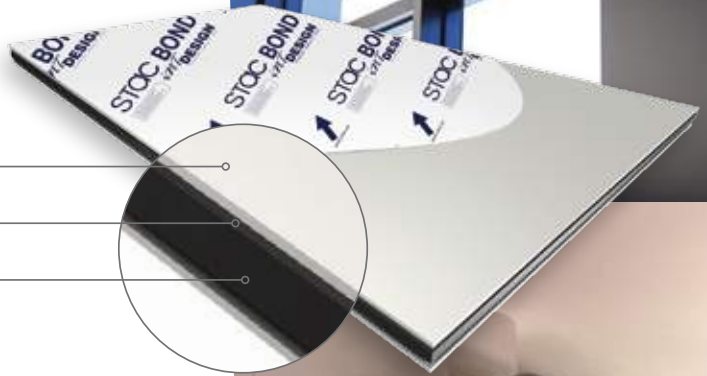
The **STACBOND®INTdesign** is used principally for the covering of internal spaces (new buildings as well as refurbishments) although there are a multitude of application possibilities such as:

- Decoration
- False ceilings
- Corporate image
- Digital printing
- Signage

0.30 mm aluminium & polyester paint

Polyethelene core

0.3 mm aluminium Primer





TECHNICAL SPECIFICATIONS

STACBOND®INTdesign

SHEET DIMENSIONS	WIDTHS (mm)	LENGTHS (mm)
Stock sizes	1500	3050 -5050
Made to measure manufacture (CONSULT)	1000 -1250	(min.max.) 2000 / 6000

Thickness tolerance (mm) $\pm 0,2$	Width tolerance (mm) ± 2	Length tolerance (mm) $+ 15$	Diagonals tolerance (mm) ± 3
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PHYSICAL SPECIFICATION	UNITS	SIZE	CERTIFICATION
Aluminium thickness	mm	0,3	EN 485-4
Panel thickness	mm	3	
Panel weight	kg/m ²	3.85	
Aluminium alloy		3005 / 3105	UNE EN 573-3

INTdesign CORE SPECIFICATION	UNITS	SIZE	CERTIFICATION
Density	gr/cm ³	0,92	

TYPE OF PAINT	UNITS	SIZE	CERTIFICATION
polyester	μ_m	20 - 40 μ_m *	
Priming protection			YES
Hardness		H	
Brightness	MEASURED AT 60° ANGLE	20-90	

GENERAL CHARACTERISTICS	UNITS	SIZE	CERTIFICATION
Peeling	N/mm	≥ 5	ASTM D903 - 98 (2004)
Elasticity module (E)	N/mm ²	70000	EN 485 - 2
Elasticity limit (R _p 0.2)	N/mm ²	≥ 150	EN 485 - 2
Break loading (R _m)	N/mm ²	$175 \leq R_m \leq 240$	EN 485 - 2
Temperature utilization	°C	- 50° / 80° ^a	
Thermal expansion for differences of 100° C	mm/m (100°)	2,3 (theoretical value)	

STANDARD COLOURS	SILVER METALLIC - WHITE RAL9016
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Possibility of manufacturing any colour with width sizes of 1.000, 1.250 y 1.500 mm.
Minimum order 1,000m2. Consult **STACBOND® T (+34) 981 817 036** stacbond@stac.es

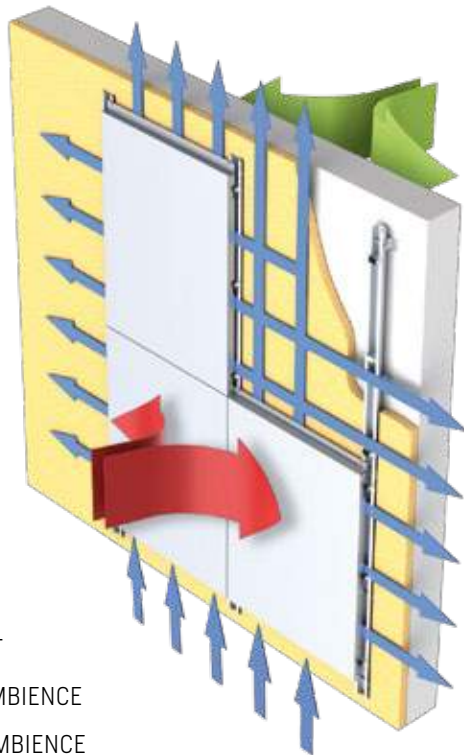
VENTILATED FAÇADE

The ventilated façade is an external finishing system that permits the fitting of the **STACBOND®** Composite Panel separated from the thermal insulation by using a loading structure.

This separation distance allows for an air current to flow between the panel and the façade with which an optimum thermal and acoustic insulation is achieved as well as efficient protection from atmospheric agents.

The panel is fixed to the façade using constructive elements that have been designed and fabricated by **STAC** for an easy, quick and efficient system fitting.

The main advantage of the ventilated façades is the energy saving which is possible thanks to the existing chamber between the brick and the composite panel that causes a reduction in thermal transmission and therefore an energy saving inside the building.



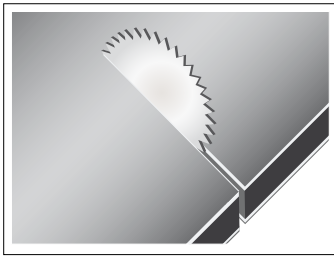
- AIR CURRENT
- INTERNAL AMBIENCE
- EXTERNAL AMBIENCE



Mar de Vigo
Congress Auditorium
STACBOND®FR
STB-403 Silver Metallic

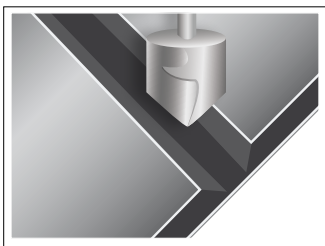
Creativity and energy
savings go hand in hand





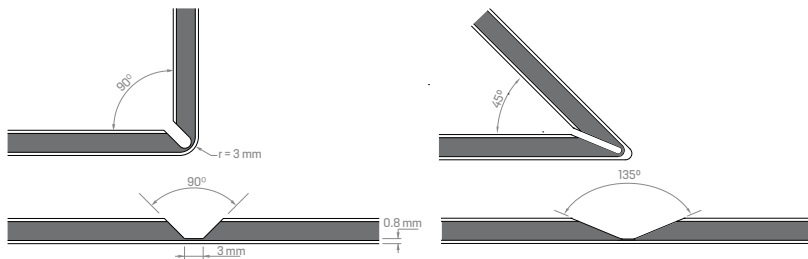
CUTTING

Can be done with CNC, mural or portable milling machine. Straight, curved or angle cuts can be achieved as long as the adequate tools are available.



MILLING

Can be done with CNC or a portable milling machine. The milling allows for the pieces to be folded afterwards. The 90° or 135° milling tools to be used depending on the required fold. In order to achieve the desired measurement the fold must be produced in the milling axis. An incorrect fold can alter the final measurement of the panel by up to 4 mm.



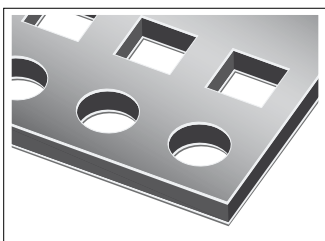
GROOVING

Grooving for 90° & 135° construction.



DRILLING

The panel will accept multiple types of perforations, and it is advisable to use the adequate tools in order to achieve an optimum quality finish. Please consult with **STACBOND®** regarding the various shapes and sizes.



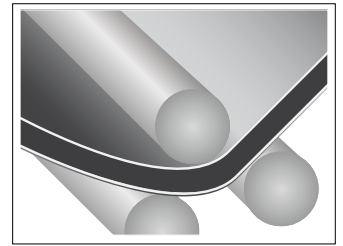
PUNCHING AND DIE CUTTING

The panel can be punched and die cut with conventional machinery. It is normal to find a slight sinking in the external aluminium panel. Please consult with **STACBOND®** regarding the various shapes and sizes.

BENDING WITH ROLLERS

In order to bend our products, the most appropriate method is to use the 3 roller pyramid style roller bending machines. In order to avoid any risks, attention must be paid to the minimum bend radii on the internal side.

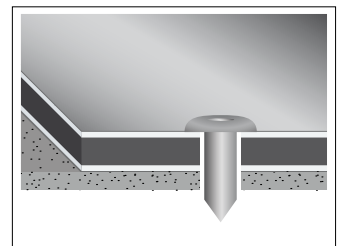
The minimum bend radius for **STACBOND®** in a bending machine is 150 mm for panels without creases and 500 mm for panels with 20 mm creases.



RIVETING AND SCREWING

It is essential to take in to account the lineal expansion of the panel. We recommend using normal metal screws made with stainless steel. The rivets to be used will be: Rivet ISO 15977 5,0x120 al/stainless A2 (SFS AP14-S-5012, and for atmospheres with a high prescence of chloride we recommend using stainless A4 rivets type SFS SSO-D15-50140 stainless/stainless A4, and recommended screws according to the façade manufacturer.

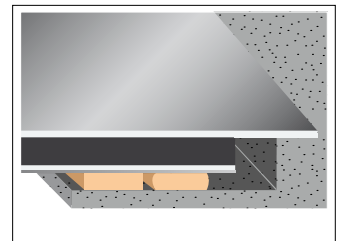
In order to do the riveting, a pressure control or dynamometer key riveter is needed with a pressure control limiter. All drilling needs a centerer.



GLUING

The panels can be glued using metal adhesives according to the adhesive manufacturers specifications.

Use a cleaner to remove the dirt and then apply a 'PRIMER' and then to follow with a strip of adhesive together with the double sided tape which is used to maintain the necessary adhesive thickness in order to absorb any possible expansions, as well as fixing the panel whilst the adhesive is drying.



ASSEMBLY SYSTEMS

STACBOND® has 5 assembly systems in order to offer to the current architecture new possibilities and solutions. These systems have been designed in great detail in order to adapt to the particular needs of each construction job.

The 5 assembly systems for the STACBOND® Composite Panel are the following:

- Hanging system (**STB-CH**)
- Male/Female system (**STB-SZ**)
- Riveted system (**STB-RIVETED**)
- Glued system (**STB-GLUED**)
- STB-T System (**STB-T RIVETED, STB-TSZ & STB-T GLUED**)

The **STB-CH, STB-SZ & STB-RIVETED** systems share sub-structure elements, separated in double T and the omega shaped mullion profile.

The **STB-GLUED** system uses L shaped spacers and a grooved tube in order to obtain increased structural resistance and an increase in gluing surface.

The **STB-T** systems use special L shaped separators and a T shaped mullion.

The composite panel assembly systems – **STACBOND® STB-CH, STB-SZ & STB RIVETED** have a technical suitability document ref. BBA 13/5022 which conforms with the TECHNICAL BUILDING CODE (CTE).

1. Structural security (DB-SE-AE)
2. In case of fire security (DB-SI)
3. Health, hygiene and environment (DB-SE-HS)
4. Usage security (DB-SUA)
5. Noise protection (DB-HR)
6. Energy saving (DB-HE)



STB-CH

HANGING SYSTEM

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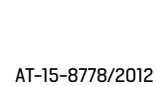


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STB-RIVETED

RIVETED SYSTEM

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STB-GLUED

GLUED SYSTEM

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STB-T-RIVETED

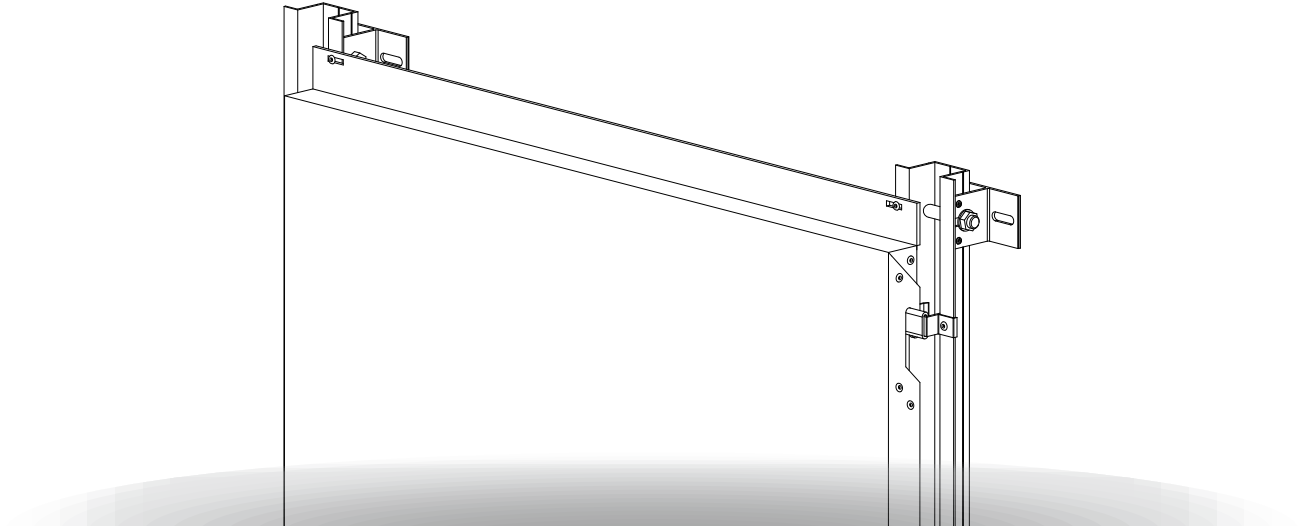
STB-T-SZ

STB-T-GLUED

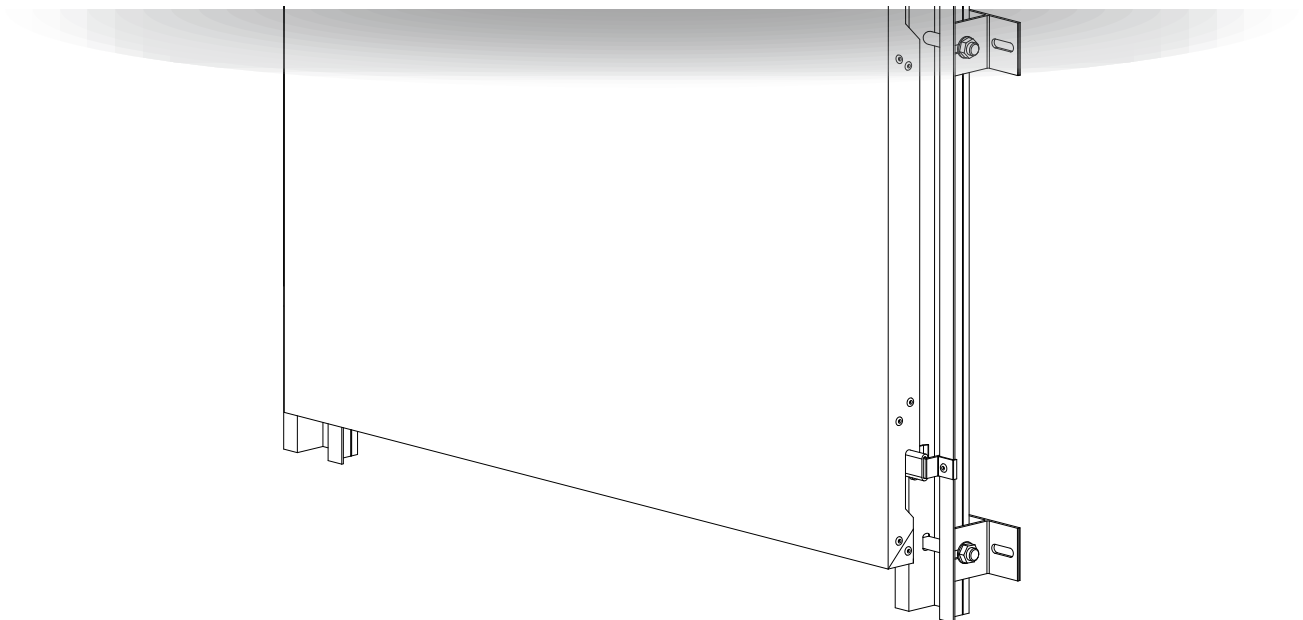
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STB-CH SYSTEM STAC BOND®



STB-CH ASSEMBLY SYSTEM

The STB-CH SYSTEM is a concealed fixing system which is versatile and is quickly assembled where the tray modules can be both horizontal and vertical. The STB-CH system complies with all of the requirements to carry out the most revolutionary architectonic claddings.

All of the **sub-structure** is made with an **aluminium 6063 T5** profile and formed by double T ref. SCH-1 fixings which have different lengths in order to absorb any irregularities in the façade.

The separator is fixed to the vertical parameter using special mechanical wedges which are recommended in each case by the fixing suppliers.

The external ref. SCH-4 or internal ref. SCH-5 are fixed to the omega mullions that have been cut from an extruded aluminium alloy 6063 T5 profile. The hanging area is protected by using a special part known as an EPDM hanging gasket in order to avoid vibrations when resting against the **STACBOND®** Composite Panel trays

This sub-structure supports the **TACBOND®PE & FR** Composite Panels that have been fabricated in such a way that they rest against the previously mentioned hanging parts and are screwed at the top flange to the omega shaped mullion profiles.

The tray hanging cleats will be strengthened using reinforcement part ref. SCH-R that will be riveted to the tray's lateral flange on to the hanging cleats and therefore shaping the tray corners.

Internally the trays are strengthened using **intermediate stiffeners** which are composite panel parts that adhere to the internal tray face and are riveted in the perpendicular flanges.



Stac has developed a programme for a specific calculation of the substructure using the criteria in the Technical Suitability Document (BBA 13/5022) which was established at the British Board of Agrément for the execution of each project. This programme defines the maximum distances between vertical mullions and the number of fixings.

STB-CH ASSEMBLY ORDER

The following explains the assembly order of the STB-CH hanging system.

1. When fitting any type of ventilated façade, we must take in to account its **overhang**. The first step is to **fit the double T spacers ref. SCH-1**. These must be perfectly aligned vertically. The type of spacer to be used will depend on the façades' overhang.

2. The **omega profile (SCH-2)** will be **screwed to the double T** fixings so that they remain perfectly plum with the adjustments that the system allows.

The first and last fixing will be fitted at 250 mm from the omega mullion profile end.

3. The **external hanging parts (SCH-4)** or the **internal parts (SCH-5)** are fitted over the **omega**. These are height adjusted depending on where the hanging cleats are situated on each tray. They can never be over the maximum distance of 500 mm between each one.

4. The **STACBOND® Composite Panel**. The last step will be to fit the trays over the hanging pieces which are then screwed against the omega mullion flaps in the elongated holes that are situated in the top horizontal flange of the tray. The façade is to be executed in a rising direction.

1st. Double "T" SCH-1-59 fixings.



2nd. Omega SCH-2 profiles



3rd . SCH-4 external hangers



4th. STACBOND Composite Panel Tray



Special attention must be paid to the indicated direction with an arrow on the film protector in order to guarantee that no different tones are seen when the sun shines on to the façade.

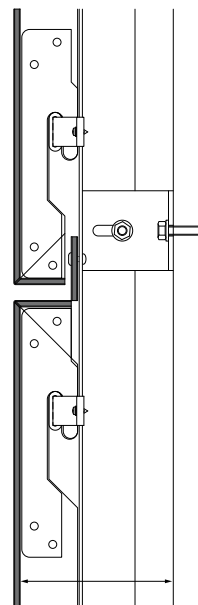
STB-CH ASSEMBLY ORDER

SHORT FLANGE PANEL



Standard tray

VERTICAL SECTION



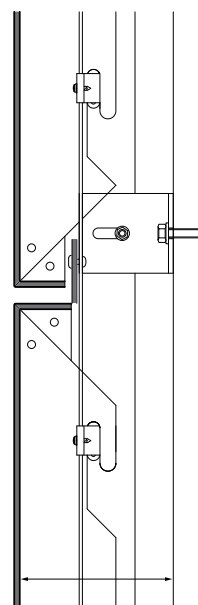
MAX. DIMENSION 310 mm
MIN. DIMENSION 100 mm
(With the different fixings)

LONG FLANGE PANEL



Special tray

VERTICAL SECTION

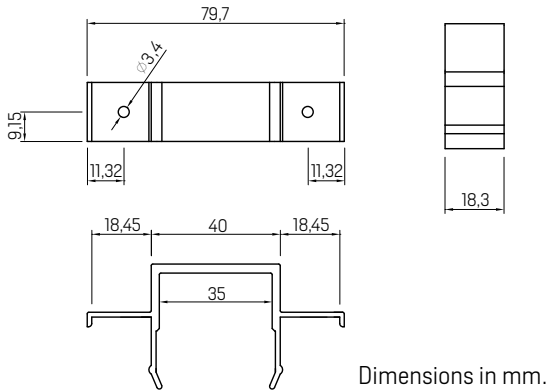


MAX. DIMENSION 310 mm
MIN. DIMENSION 100 mm
(With the different fixings)

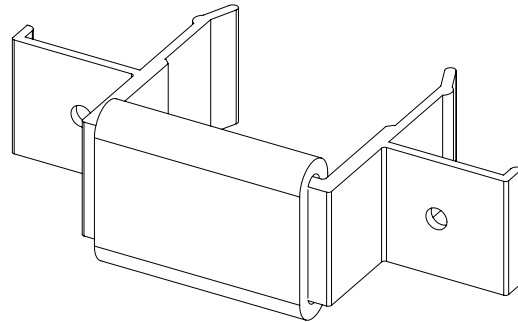
The short flange tray is the standard format for tray hanging. Additionally, **STACBOND®** has a format for the long flange available which channels the possible water ingress through the omega and helps to stiffen the tray.

AUXILIARY ELEMENTS FOR THE STB-CH SYSTEM

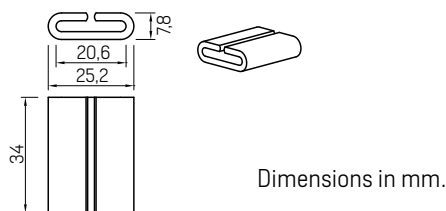
SCH-4 EXTERNAL HANGING



EXTERNAL HANGING



HANGING GASKET

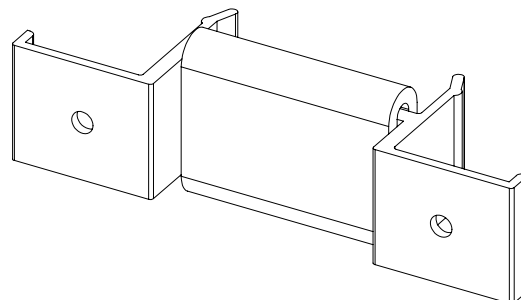


The hanging gasket part is there to avoid the vibration noises that are caused by wind loadings, road traffic, etc.

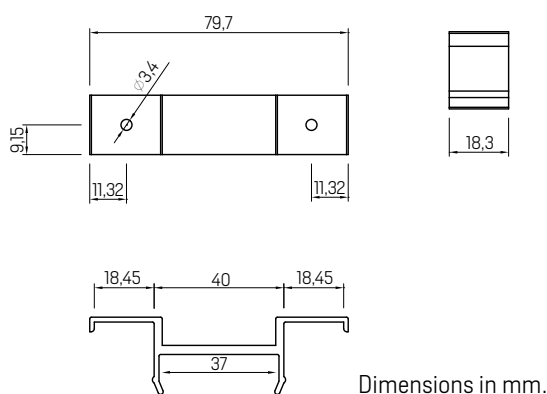
REFERENCE	DESCRIPTION	PRESENTATION
05.19.013	SCH-4 EXTERNAL HANGING	200 units/box.

The external hanging is used for the short flange composite panel.

INTERNAL HANGING



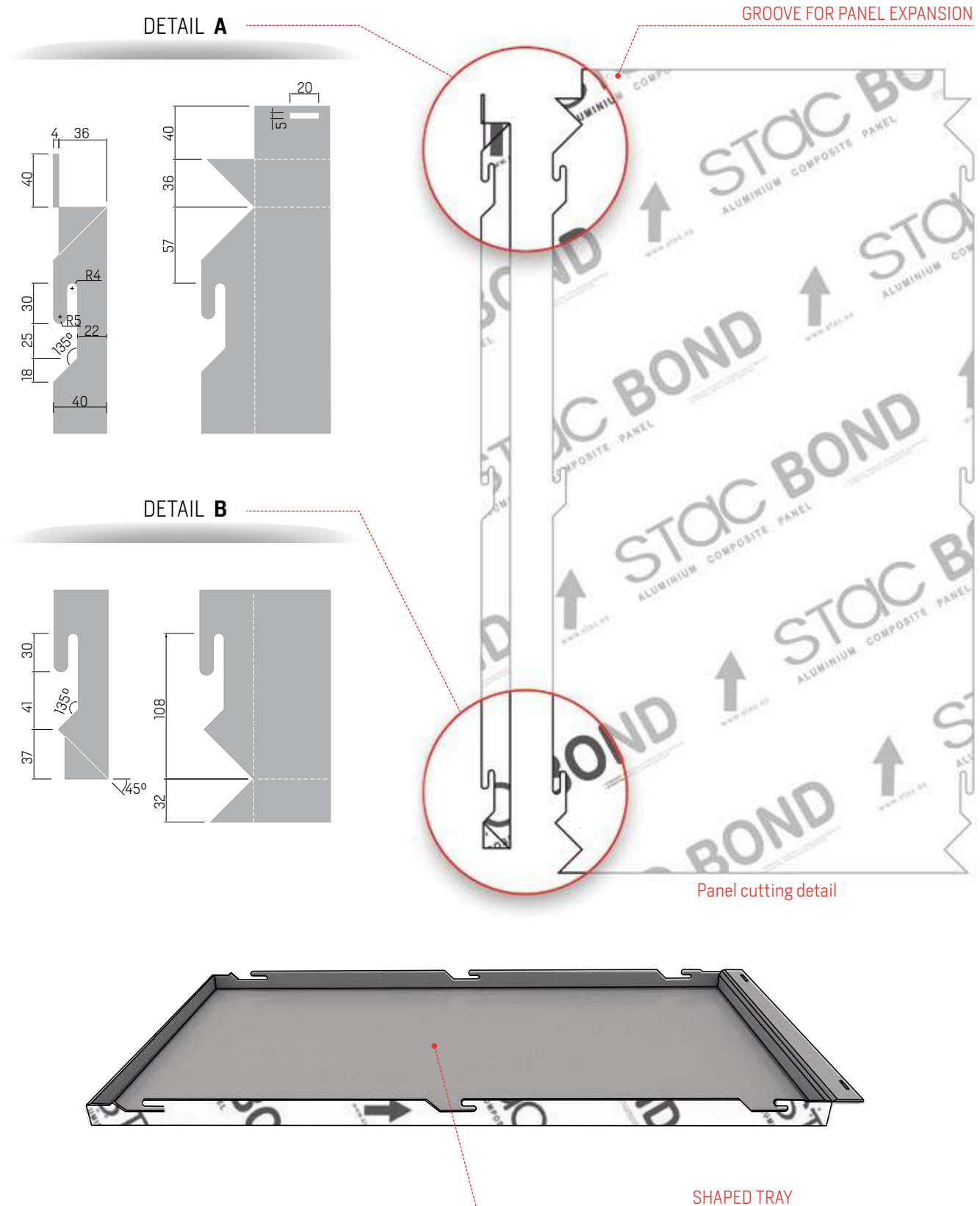
SCH-5 INTERNAL HANGING



REFERENCE	DESCRIPTION	PRESENTATION
05.19.008	SCH-5 EXTERNAL HANGING	50 units/box.

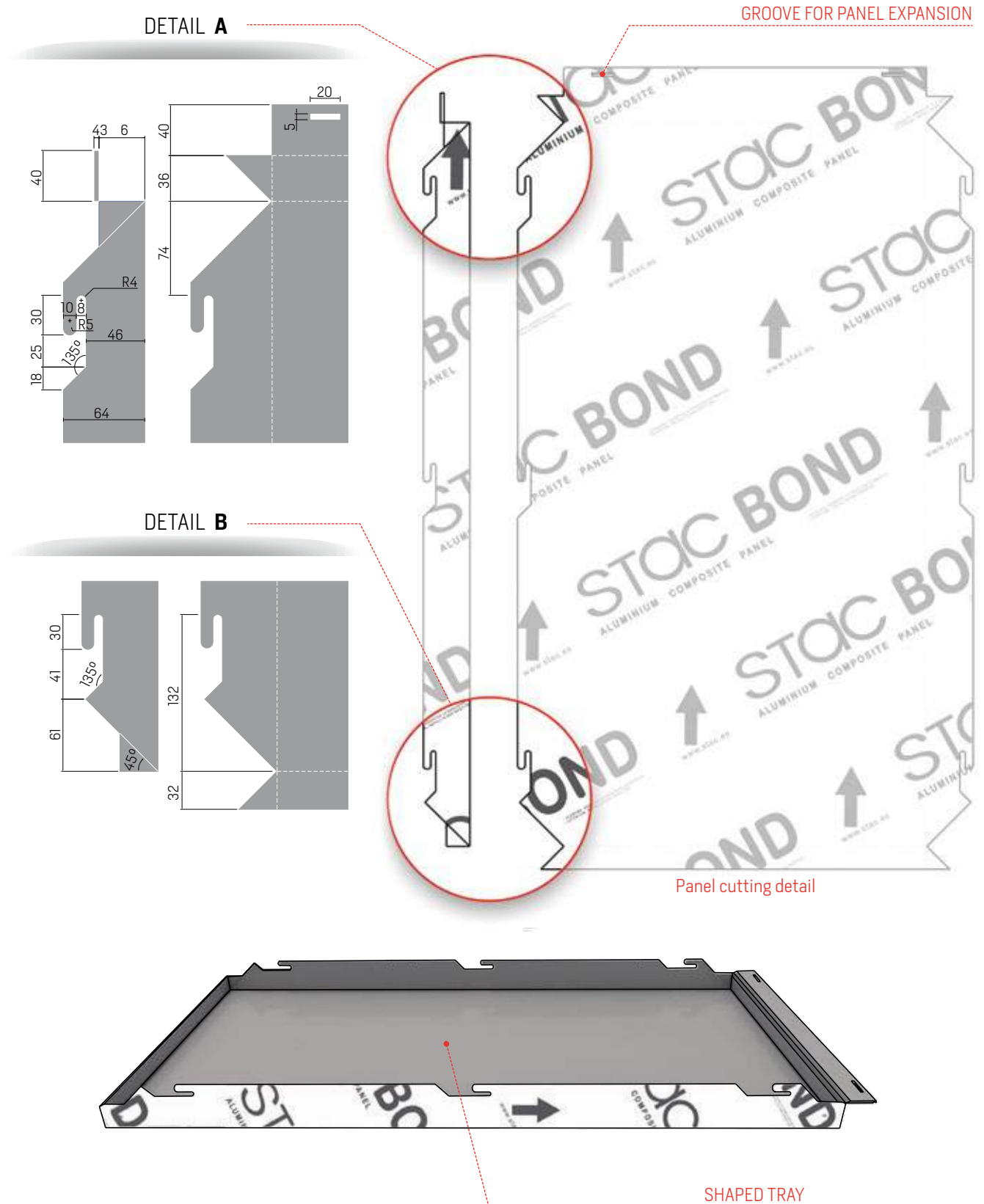
By using the internal hanging, the tray flange shape can be introduced further into the omega profile. With this, the channelling of possible water ingress through the vertical gaskets is improved as well as stiffening the tray.

SHORT FLANGE STANDARD TRAY SYSTEM **STB-CH**



Note: the STACBOND®PE, STACBOND®FR & STACBOND®INTdesign panel fabrications are supplied in the drawing. The shaping of the panels is carried out by the Client. There is no need for specific machinery.

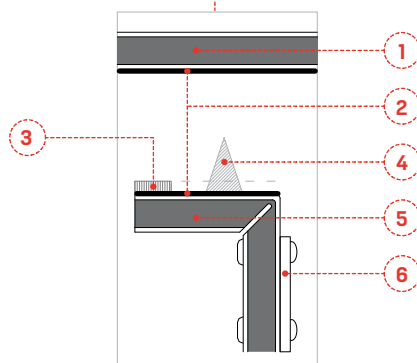
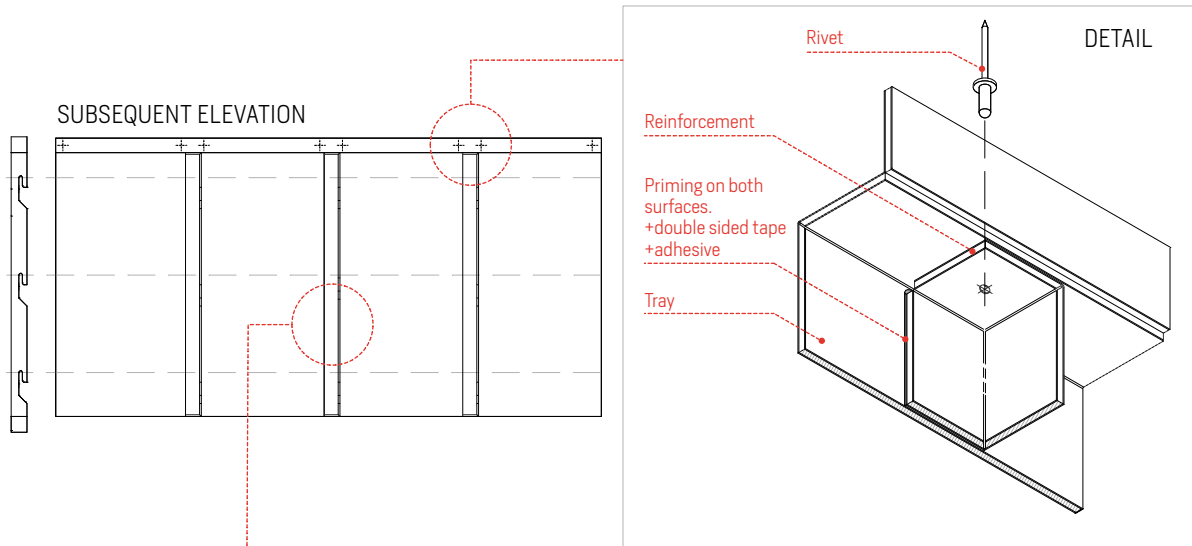
LONG FLANGE STANDARD TRAY SYSTEM **STB-CH**



Note: the **STACBOND®PE**, **STACBOND®FR** & **STACBOND®INTdesign** panel fabrications are supplied in the drawing. The shaping of the panels is carried out by the Client. There is no need for specific machinery.

THE STIFFENER SYSTEM **STB-CH**

The stiffener is an angular part shaped from the fabricated STACBOND® Composite Panel. It is used to reinforce the CH trays internally when they exceed certain dimensions. The stiffener is fixed by adhesive to the internal tray face and mechanically to the top and bottom flanges.



STIFFENER (SCH-RIG-2)

Nº	DESIGNATION	REFERENCE
1	Tray made from STACBOND Composite Panel	-
2	Priming	-
3	Auto adhesive double sided tape	-
4	Adhesive strip applied to the reinforcement	-
5	Stiffening profile originating from STACBOND panel	-
6	Concealed groove reinforcement	05.19.019

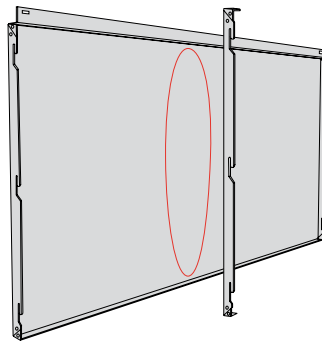


REFERENCE	DESCRIPTION
05.19.025	SCH-RIG-1 STIFFENER (0-750 mm)
05.19.026	SCH-RIG-2 STIFFENER (750-1500 mm)
05.19.027	SCH-RIG-3 STIFFENER (>1500 mm)

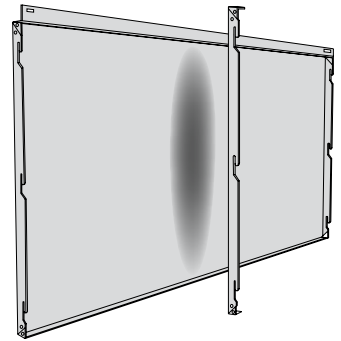
1. AREA PREPERATION

Cleaning. Dust and dirt is to be removed using mechanical processes but in no case should dissolvents be used.

This cleaning consists of a more or less deep sanding depending on the existing dirt. Afterwards, the dust must be blown away with compressed air. For the cleaning and de-greasing, use the SIKA CLEANER 205 or similar degreasing cleaner and leave to evaporate for at least 10 minutes.



1 CLEAN

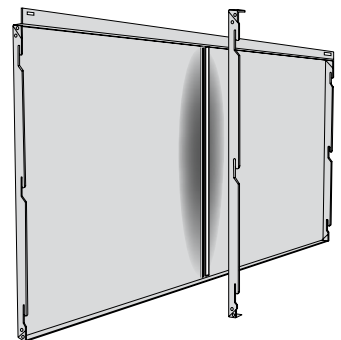


2. AREA PRIMING

Once the area is cleaned, the priming is done by using a specific product that strengthens the adherence of the elastic adhesive (SIKATACK PANEL PRIMER or similar).

3. DOUBLE SIDED ADHESIVE TAPE

Once the area has been primed and following the wait time for the priming (30, 60 min.) you can proceed to fit the double sided autoadhesive tape – SIKATACK PANEL 3 TAPE or similar that holds the piece whilst the adhesive polymerizes as well as ensuring the minium thickness to allow for the possible expansions of the **STACBOND®** Composite Panel.



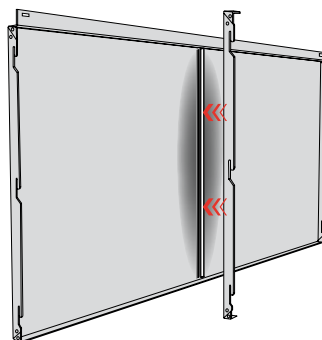
4 SIKATACK PANEL ADHESIVE

4. ADHESIVE APPLICATION

Fitting of the SIKATACK PANEL elastic adhesive or similar on to the tray by applying a strip to the double sided tape.

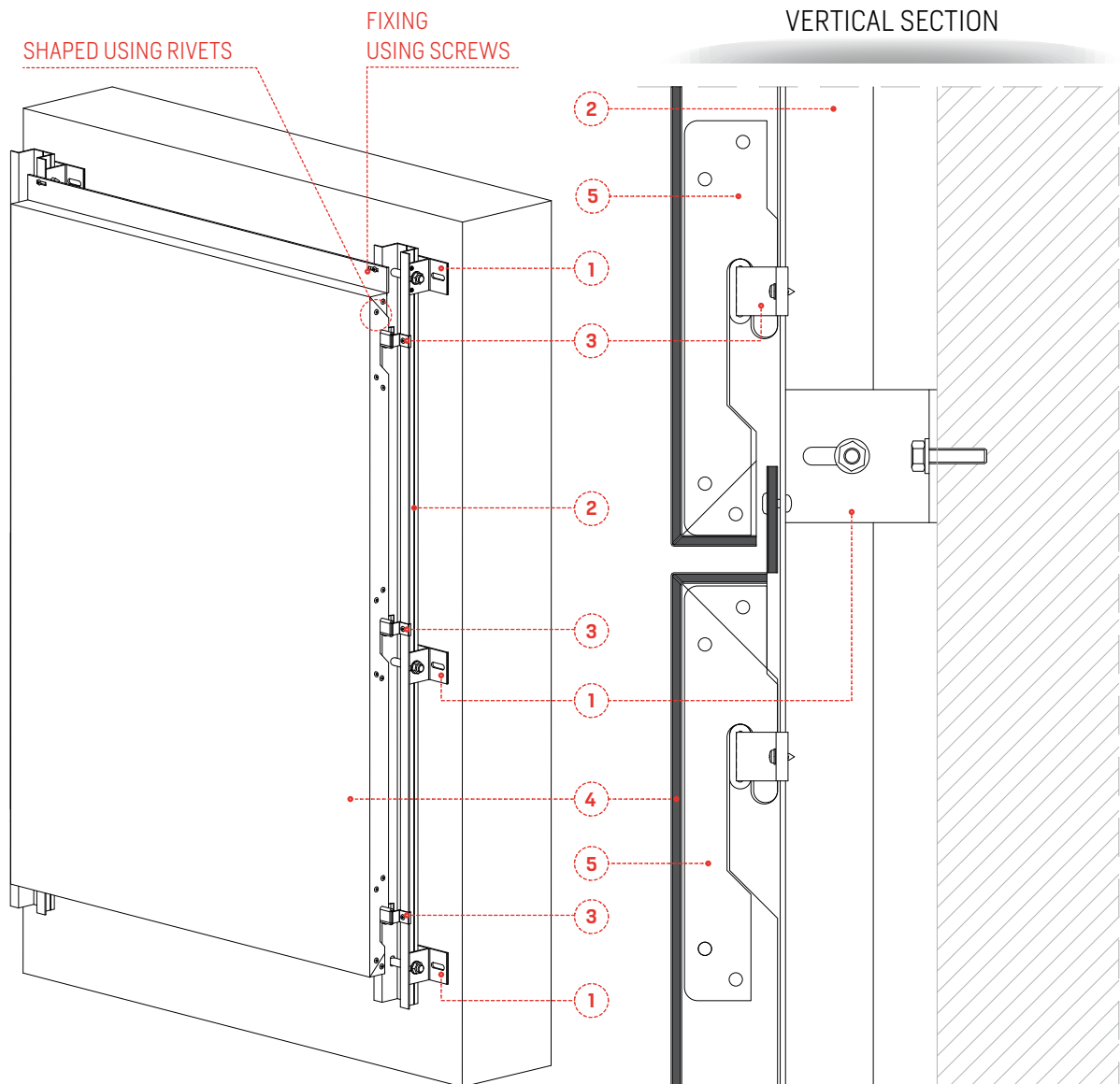
5. FITTING THE STIFFENER

The stiffener will be fitted in such a way that all of its surface remains impregnated with adhesive. Afterwards the top and bottom part will be riveted against the horizontal tray flanges.



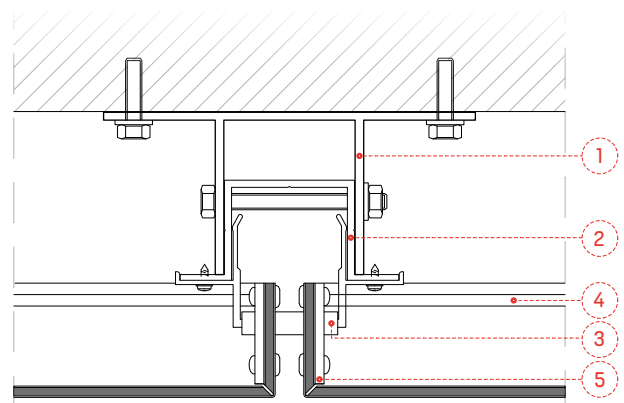
5 STICK THE STIFFENER

ASSEMBLY DIAGRAM SYSTEM **STB-CH**

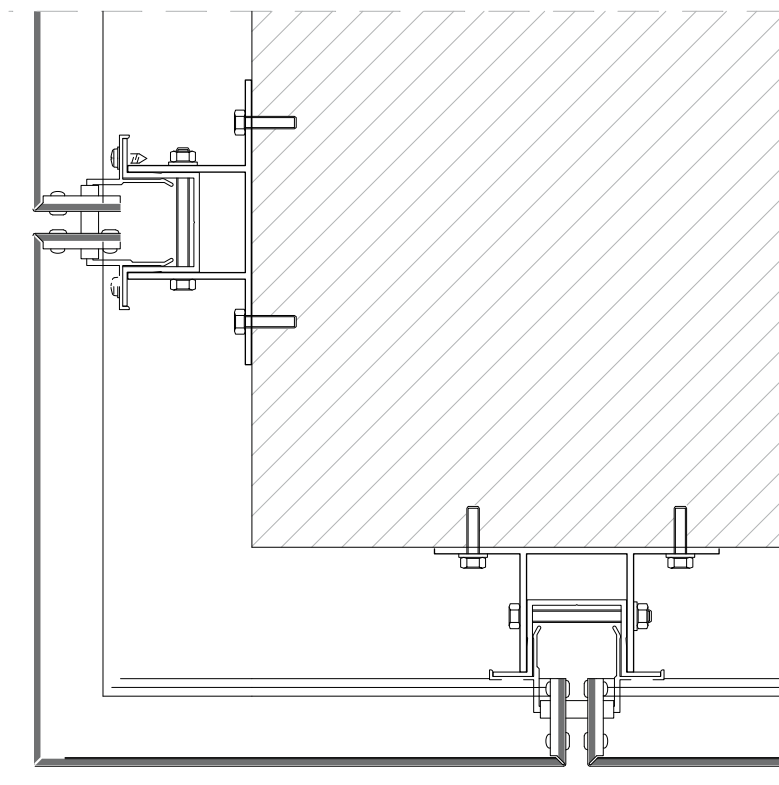


Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	External hanging part	05.19.013
4	Tray made from STACBOND Composite Panel	-
5	Concealed groove reinforcement	19.019

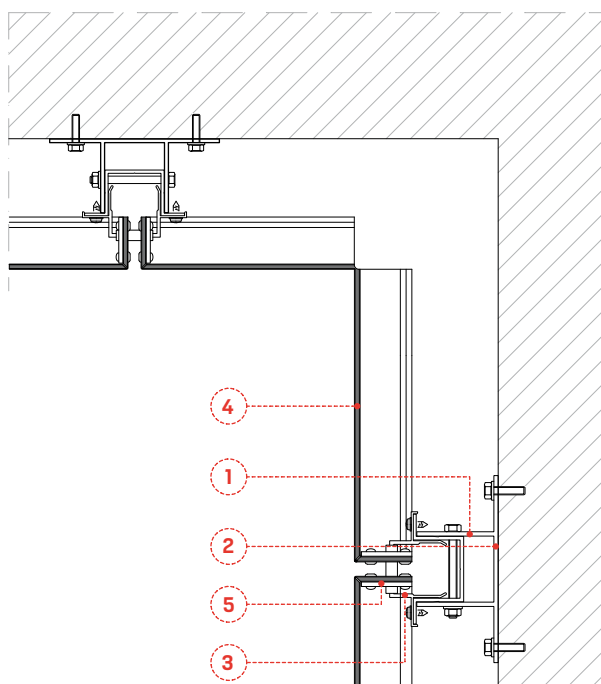
HORIZONTAL SECTION



CORNER ROUNDING OFF HORIZONTAL SECTION

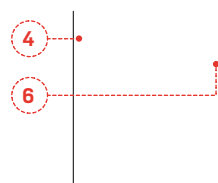


INSIDE CORNER ROUNDING OFF HORIZONTAL SECTION

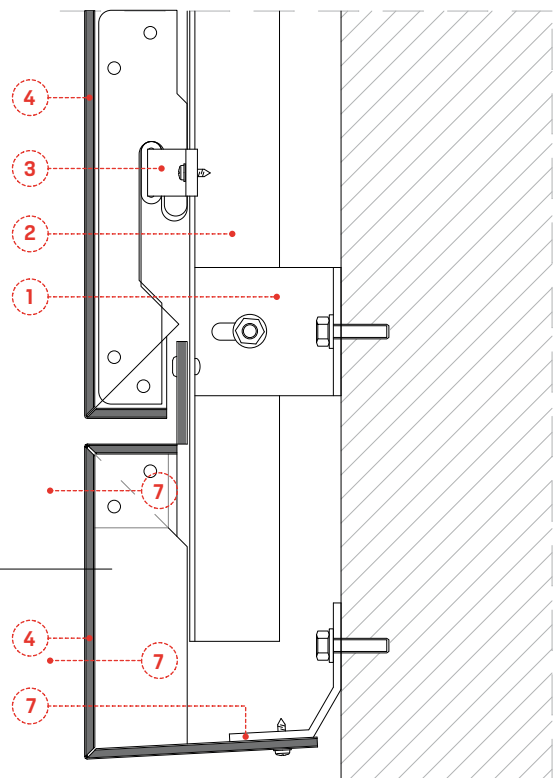


TECHNICAL DIAGRAMS **SYSTEM** STB-CH

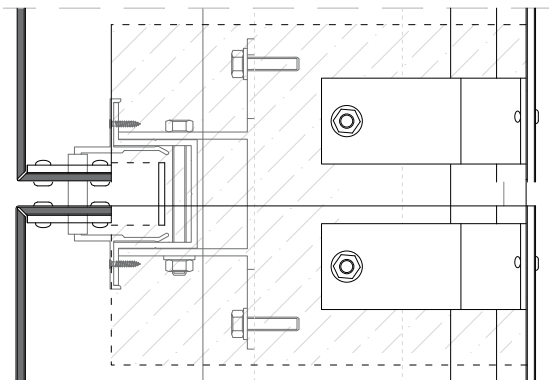
CORONATION ROUNDING OFF
VERTICAL SECTION



LOWER ROUNDING OFF
VERTICAL SECTION



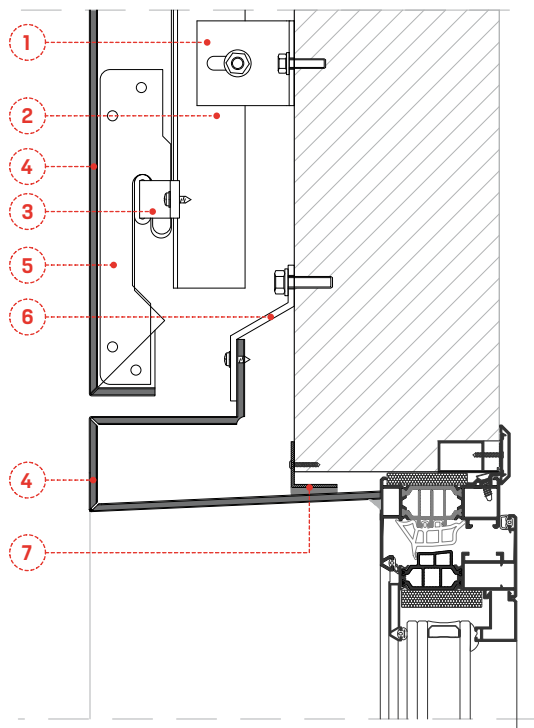
CORONATION ROUNDING OFF
HORIZONTAL SECTION



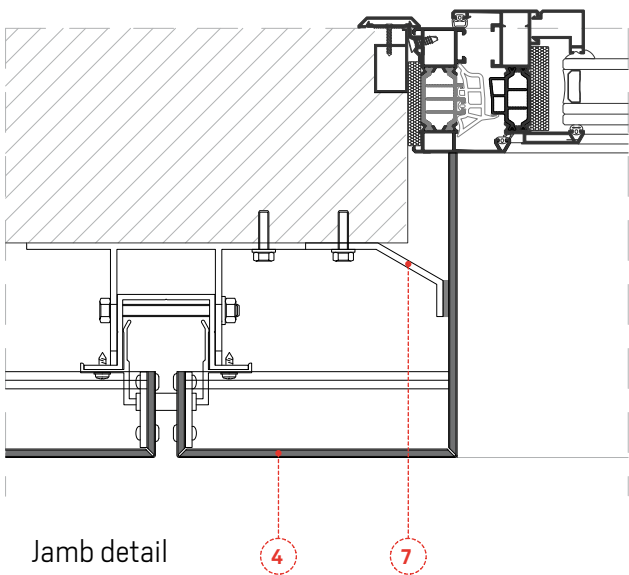
Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	External hanging part	05.19.013
4	Bandeja procedente de panel composite STACBOND	-
5	Concealed groove reinforcement	19.019
6	Aluminium rounding off for water evacuation	Not supplied by STAC
7	Aluminium rounding off for fixing	Not supplied by STAC

TECHNICAL DIAGRAMS **SYSTEM** STB-CH

WINDOW ROUNDING OFF
VERTICAL SECTION

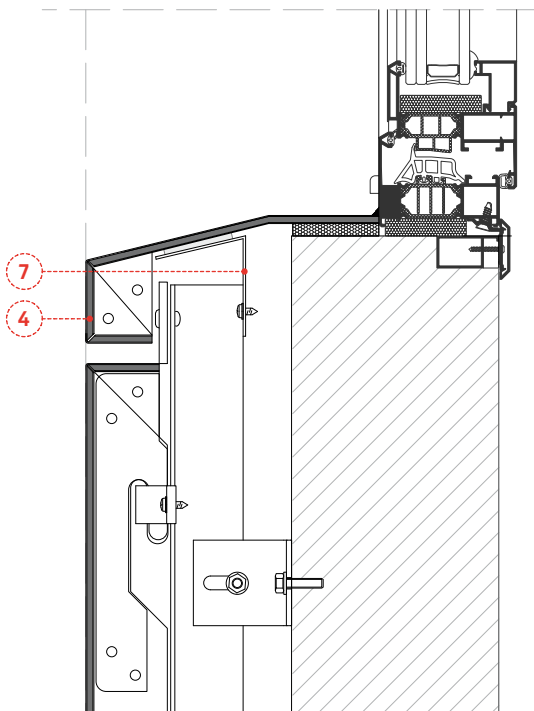


WINDOW ROUNDING OFF
HORIZONTAL SECTION



Jamb detail

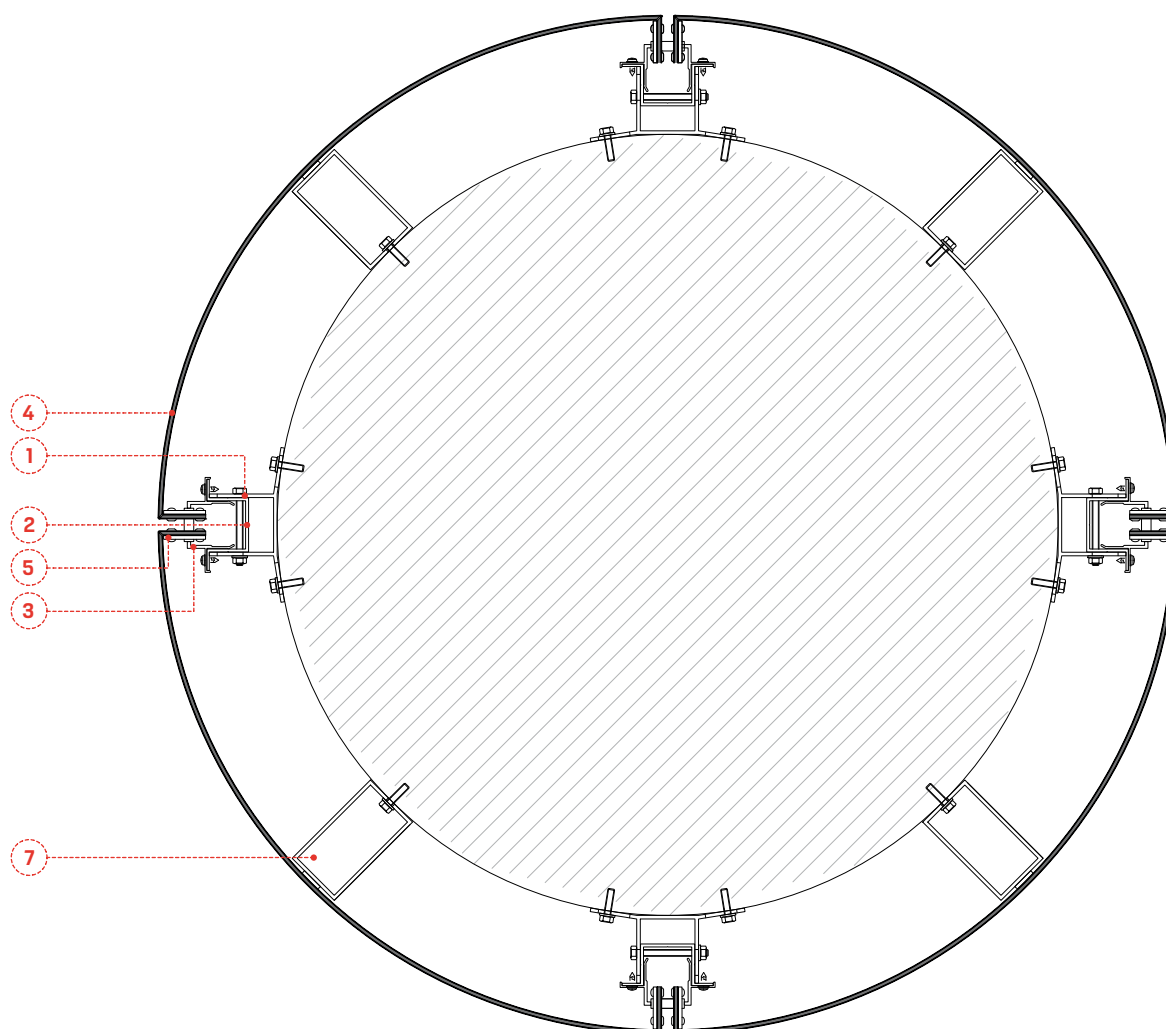
Lintel detail



Water flow detail

Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	External hanging part	05.19.013
4	Tray made from STACBOND Composite Panel	-
5	Concealed groove reinforcement	19.019
6	Aluminium rounding off for water evacuation	Not supplied by STAC
7	Aluminium rounding off for fixing	Not supplied by STAC

CIRCULAR ROUNDING OFF VERTICAL SECTION

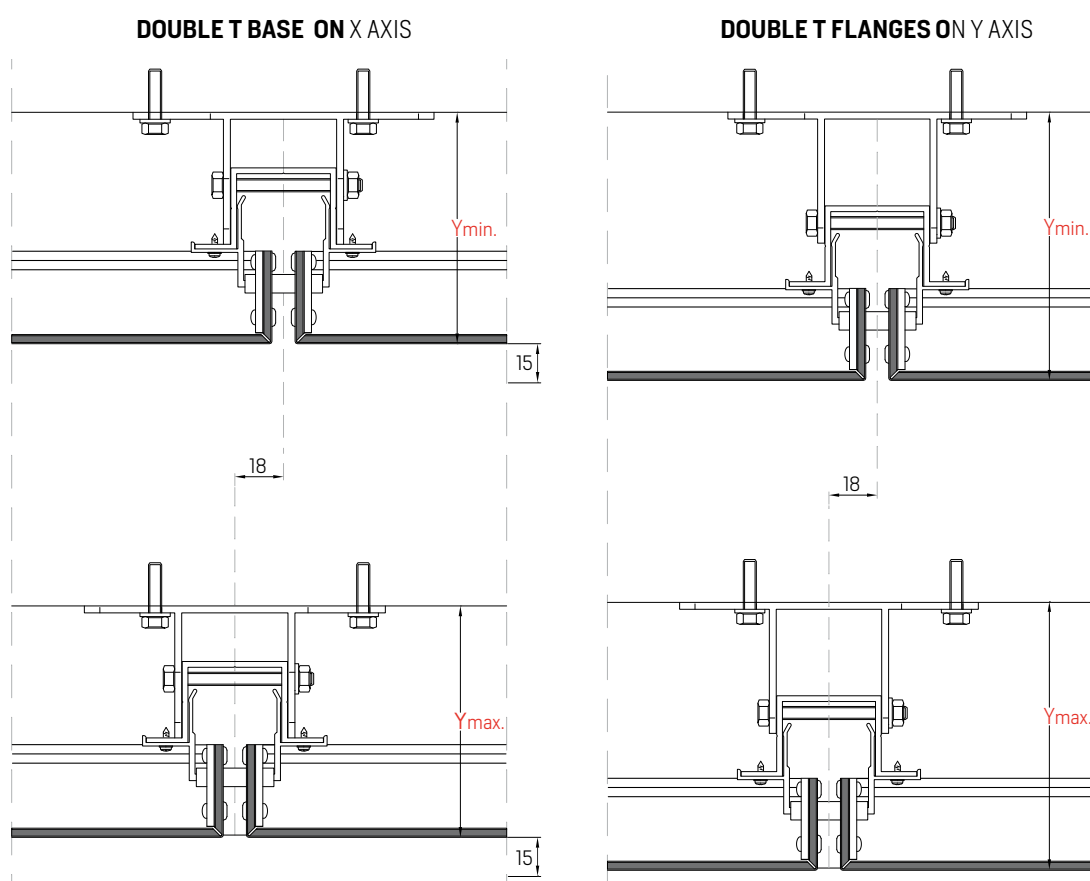


Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	External hanging part	05.19.013
4	Tray made from STACBOND composite panel	-
5	Concealed groove reinforcement	19.019
6	Aluminium rounding off for water evacuation	Not supplied by STAC
7	Aluminium rounding off for fixing	Not supplied by STAC

Minium radii:
 Without folds: 150 mm
 With 20 mm folds in the
 curved edges: 500 mm
 (only one fold per edge).

TECHNICAL DIAGRAMS SYSTEM **STB-CH**

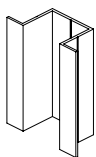
SCREW ADJUSTMENT ON THE BASE OF THE DOUBLE T



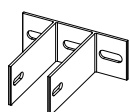
REFERENCE	DESCRIPTION	ADJUSTMENT MIN. (Y) STACBOND panel seen face	ADJUSTMENT MAX. (Y) STACBOND panel seen face
05.19.004	FIXING SCH-1-59	100	115
05.19.005	FIXING SCH-1-74	115	130
05.19.006	FIXING SCH-1-89	130	145
05.19.007	FIXING SCH-1-104	145	160
05.19.030	FIXING SCH-1-119	160	175
05.19.031	FIXING SCH-1-134	175	190
05.19.032	FIXING SCH-1-149	190	205
05.19.033	FIXING SCH-1-164	205	220
05.19.034	FIXING SCH-1-179	220	235
05.19.035	FIXING SCH-1-194	235	250
05.19.036	FIXING SCH-1-209	250	265
05.19.037	FIXING SCH-1-224	265	280
05.19.038	FIXING SCH-1-239	280	295
05.19.039	FIXING SCH-1-254	295	310

Adjustments in the axis and by fixing in mm.

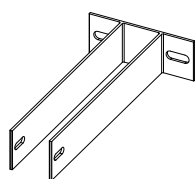
ACCESSORIES SYSTEM STB-CH



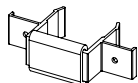
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.003	SCH-2 OMEGA PROFILE	6063 T5	-



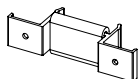
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.004	SCH-1-59 FIXING (e=3mm)	6063 T5	90
05.19.005	SCH-1-74 FIXING (e=3mm)	6063 T5	85
05.19.006	SCH-1-89 FIXING (e=3mm)	6063 T5	70
05.19.007	SCH-1-104 FIXING (e=3mm)	6063 T5	50



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.030	SCH-1-119 FIXING	6005 T6	-
05.19.031	SCH-1-134 FIXING	6005 T6	-
05.19.032	SCH-1-149 FIXING	6005 T6	-
05.19.033	SCH-1-164 FIXING	6005 T6	-
05.19.034	SCH-1-179 FIXING	6005 T6	-
05.19.035	SCH-1-194 FIXING	6005 T6	-
05.19.036	SCH-1-209 FIXING	6005 T6	-
05.19.037	SCH-1-224 FIXING	6005 T6	-
05.19.038	SCH-1-239 FIXING	6005 T6	-
05.19.039	SCH-1-254 FIXING	6005 T6	-

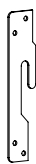


REFERENCE	PART	ALLOY	UNITS/BOX
05.19.013	SCH-4 EXTERNAL HANGING	6063 T5	200

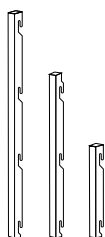


REFERENCE	PART	ALLOY	UNITS/BOX
05.19.008	SCH-5 INTERNAL HANGING	6063 T5	50

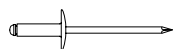
ACCESSORIES SYSTEM **STB-CH**



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



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.025	SCH-RIG-1 STIFFENER (0-750 mm)	-	-
05.19.026	SCH-RIG-2 STIFFENER (750-1500 mm)	-	-
05.19.027	SCH-RIG-3 STIFFENER (>1500 mm)	-	-

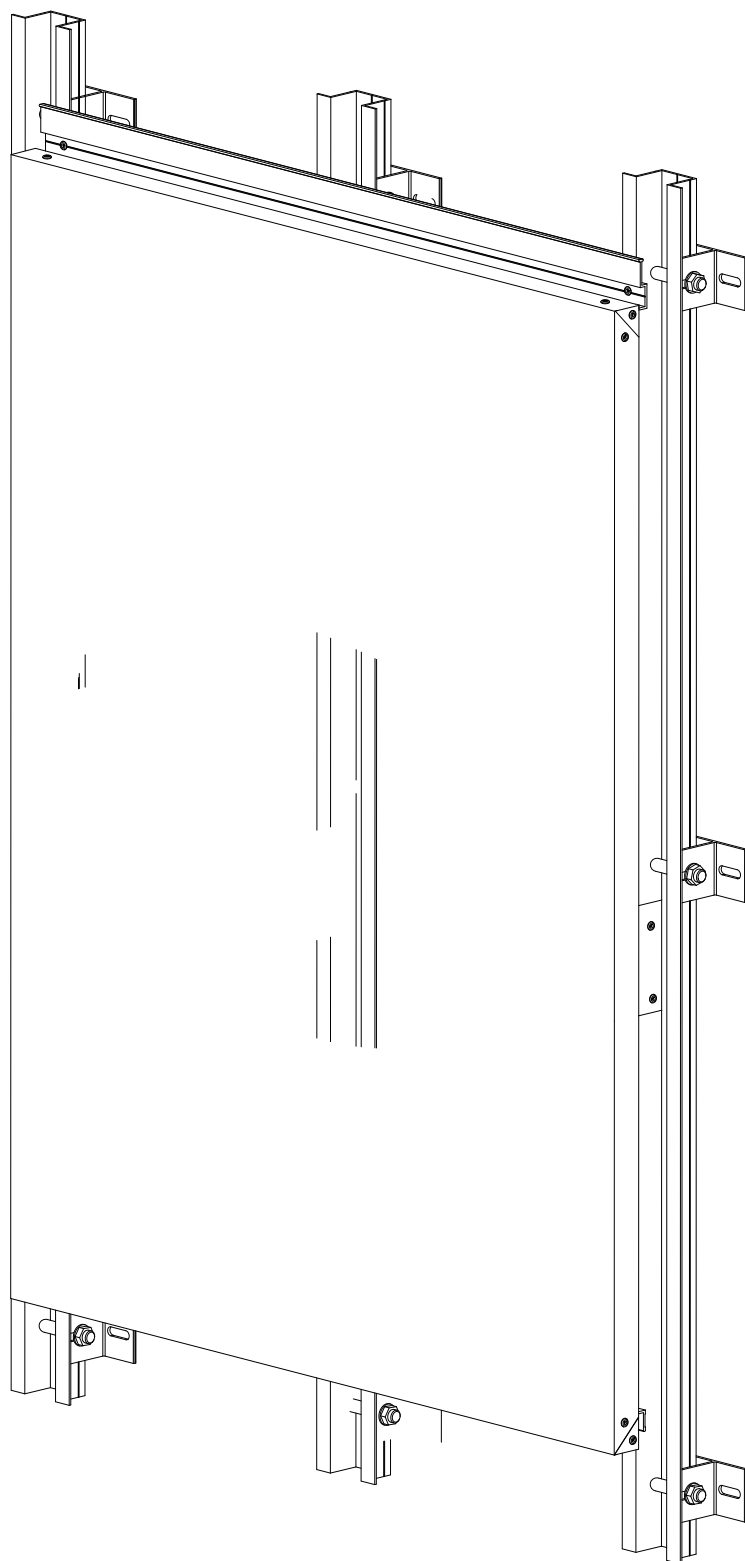


REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Polygrip SFS ASO-D-48150 Alu/stainless 4.8x15 blind rivet		
STB-R0300	Polygrip SFS ASO-D-48150 NOT PAINTED	100	100
	Polygrip SFS ASO-D-48150 PAINTED – RAL CHART	250	100

APPLICATION: For shaping **STACBOND®** STB-CH y STB-SZ composite panel.

INFORMATION & SALES

T (+34) 981 817 036
 F (+34) 981 817 231
 stacbond@stac.es



ASSEMBLY SYSTEM **STB-SZ**

The **STB-SZ system** for assembling **STACBOND®** Composite Panels on ventilated façades is comprised of “**S & Z**” 6063-T5 aluminium alloy profiles.

It is a male/female system that is designed to save time in assembling the façade. This system comprises of two profiles over which the ready shaped trays are fixed:

- **Female profile:** also known as **SC-S profile**.
- **Male profile:** also known as **SC-Z profile**.

The **STB-SZ** is a concealed fixing system which is versatile and is assembled quickly and was studied especially in order to develop ventilated façades for the **STACBOND®** Composite Panel with horizontal adjustment.

All of the **substructure** is made using **6063 T5 aluminium** profiles.

The substructure is made up of fixings in a double T shape ref. SCH-1 with different lengths in order to absorb all of the façade's irregularities.

The spacer is fixed to the vertical parameter using special mechanical wedges that are recommended in each case by the fixing suppliers. These double T spacers receive the omega shaped vertical mullions ref. SCH-2.

The **STACBOND®** Composite Panel trays are fixed to the vertical mullions using profile ref. SC-Z which is made from **aluminium alloy 6063 T5** extruded profiles.

In order to avoid vibrations in the **STACBOND®** panels, the male/female of the SC-S & SC-Z profiles have the neoprene protection gasket ref. STB-JEPDM.



Stac has developed a programme for specific calculation of the substructure using the criteria in the Technical Suitability Document (BBA 13/5022) which was established at the British Board of Agrément for the execution of each project. This programme defines the maximum distances between vertical mullions and number of fixings.

ASSEMBLY SYSTEM **STB-SZ**

In continuation the order of assembly of the male-female STB-SZ system is explained:

1. Double T spacers for fixing the profile to the façade. The Double “T” fixings join the omega mullion to the vertical parameter or the wall support and are responsible for resolving the overhang problems of the façade. They can be retaining or supporting.

1st. Fixings with double “T” SCH-1-59



2. Fitting the Omega. Profile omega (SCH-2) is by screwing to the double T fixings which must be perfectly plum with the the adjustments the system allows. Given that the mullions are not continuous, special attention must be paid to the levelling of the sections during the fixing on site. The first and last fixing must be fitted at a maximum of 250 mm from the omega mullion profile ends.

2nd. Omega SCH-2 profiles



3. “S” & “Z” profiles. These profiles reinforce lengthwise the tray both at the top as at the bottom. The “Z” profile is fitted to the top part and has to have an adhesive neoprene tape fitted in such a way that it surrounds the profile vertical flange in order to absorb possible play between the male and the female which avoids noises produced from vibrations. These profiles are fixed to the trays with rivets.

3rd. SC-S y “Z” SC-Z profiles



4. STACBOND® Composite Panel tray. Once the “Z” profile has been riveted to the tray to the top part and the “S” profile to the lower part it is taken to the façade. The work is done in an ascending direction so that each tray can rest over the previous one and is mechanically fixed at the top part by screwing the “Z” profile to the omega mullion.

4th. STACBOND® composite panel tray



Special attention must be paid to the direction indicated with an arrow on the film protector in order to guarantee that different tones are not produced when the sun shines on to the façade.

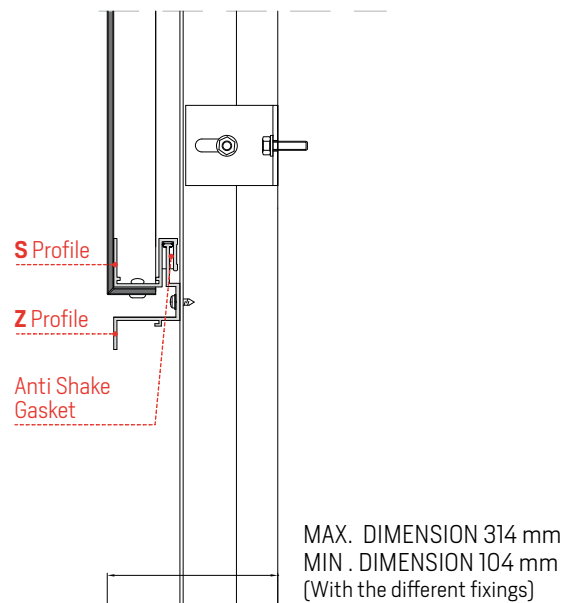
ASSEMBLY SYSTEM **STB-SZ**

TOP FIXING



Standard tray

VERTICAL SECTION

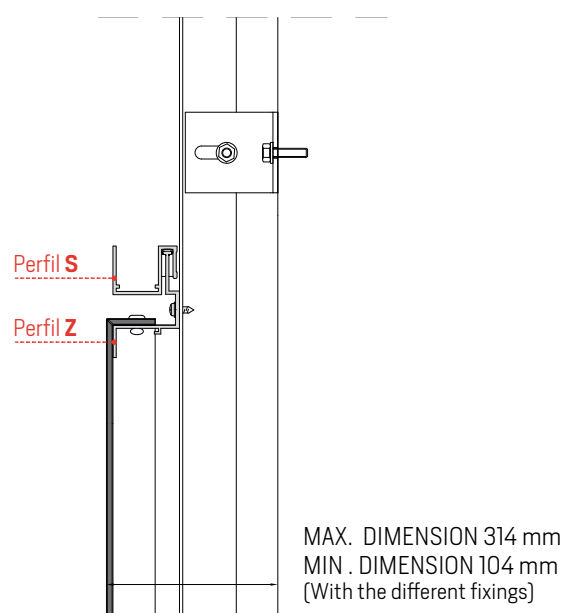


BOTTOM FIXING



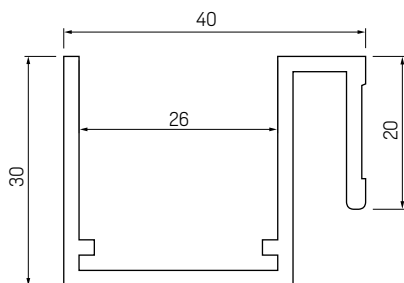
Standard tray

VERTICAL SECTION

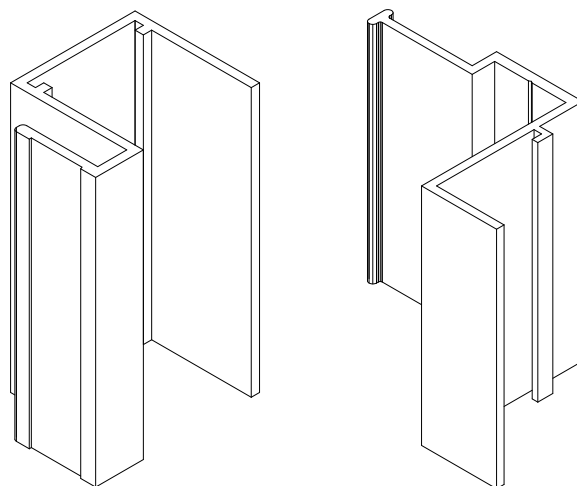


AUXILIARY ELEMENTS FOR THE **STB-SZ** SYSTEM

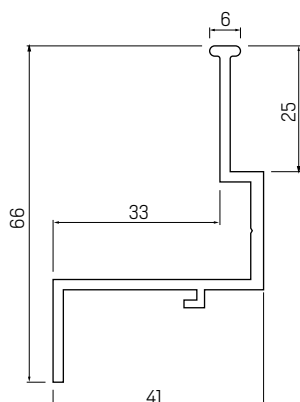
SC - S "S" PROFILE



"S" PROFILE & "Z" PROFILE



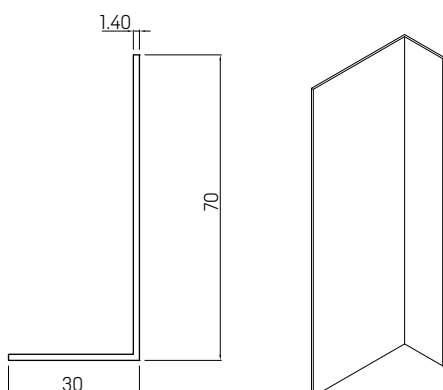
SC - Z "Z" PROFILE



REFERENCE	DESCRIPTION	PRESENTATION
05.19.001	SC-S "S" PROFILE	6 mt. length
05.19.002	SC-Z "Z" PROFILE	6 mt. length
05.99.231	SZ REINFORCEMENT	-
STB-JEPDM	S/Z PROFILE EPDM GASKET	-

We have the neoprene protection gasket available for fitting both profiles and absorbing possible play.

SZ REINFORCEMENT

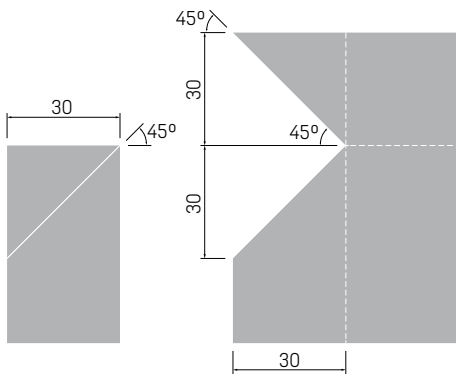


NEOPRENE GASKET

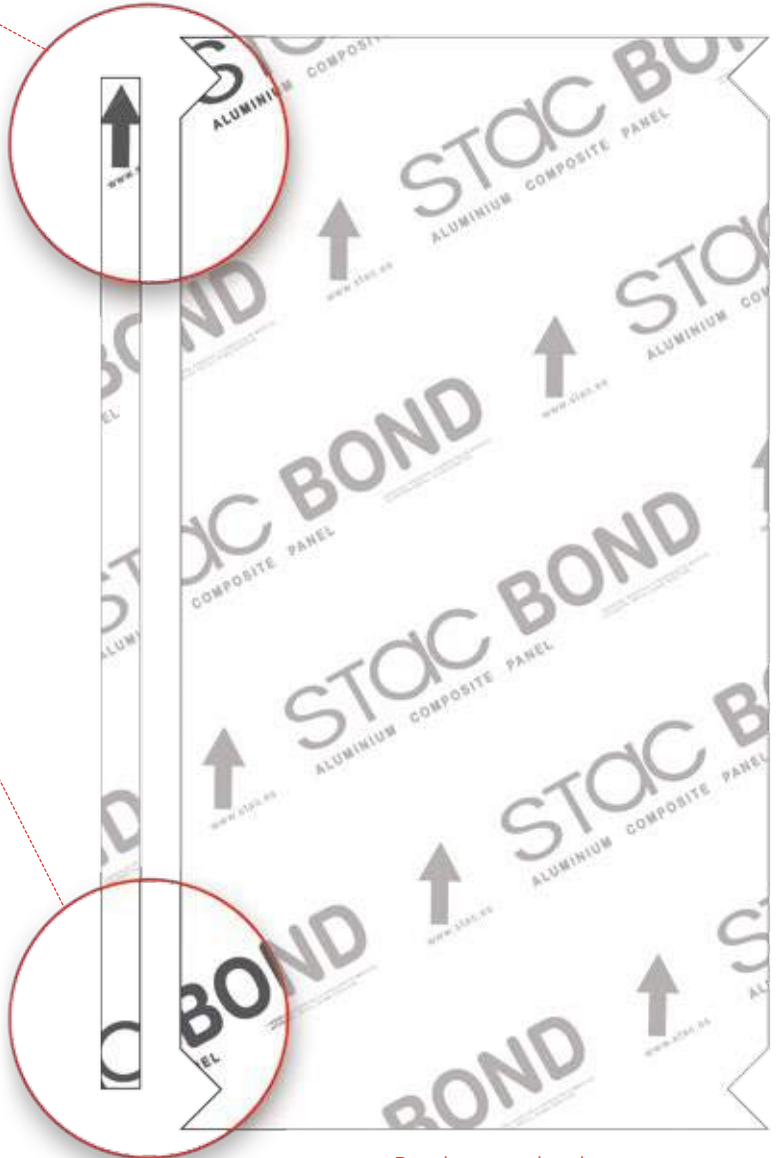
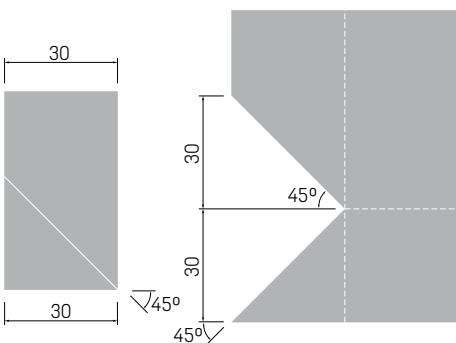


STANDARD TRAY SYSTEM **STB-CH**

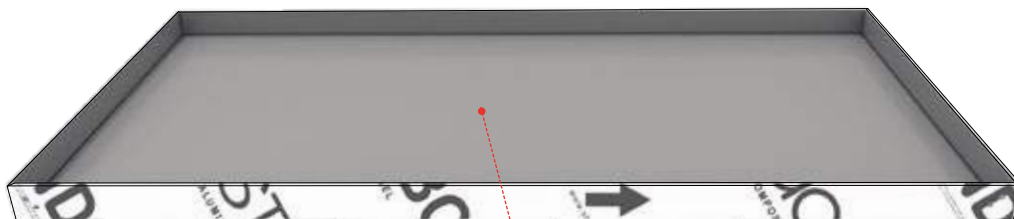
DETAIL A



DETAIL B



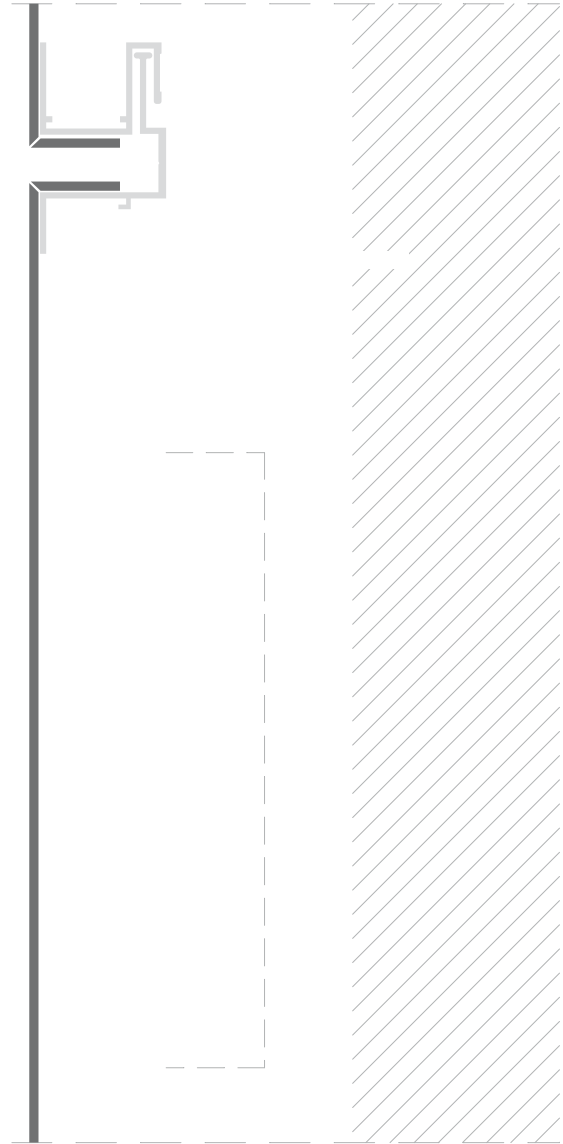
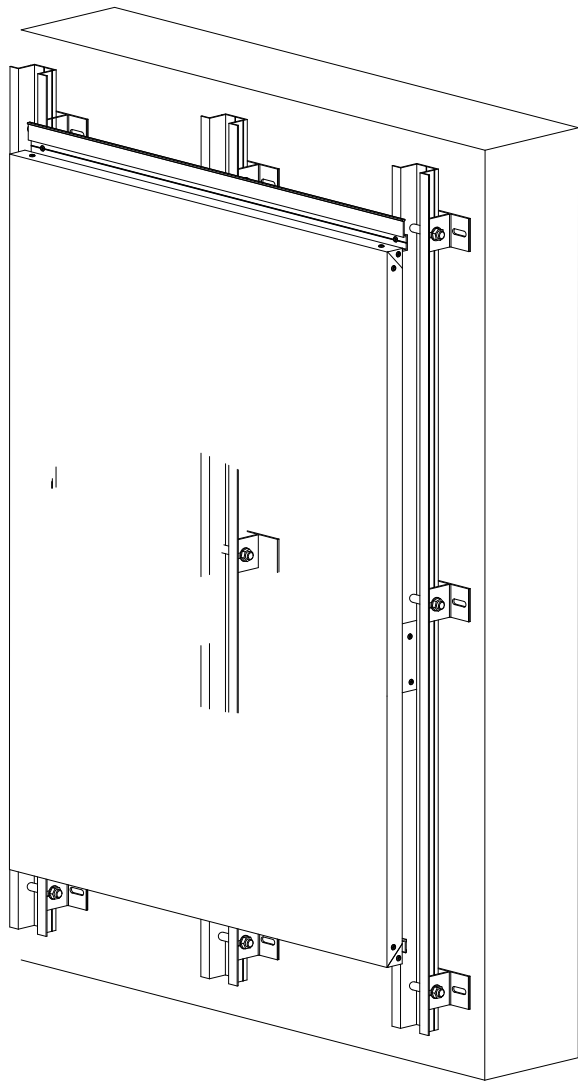
Panel cutting detail



SHAPED TRAY

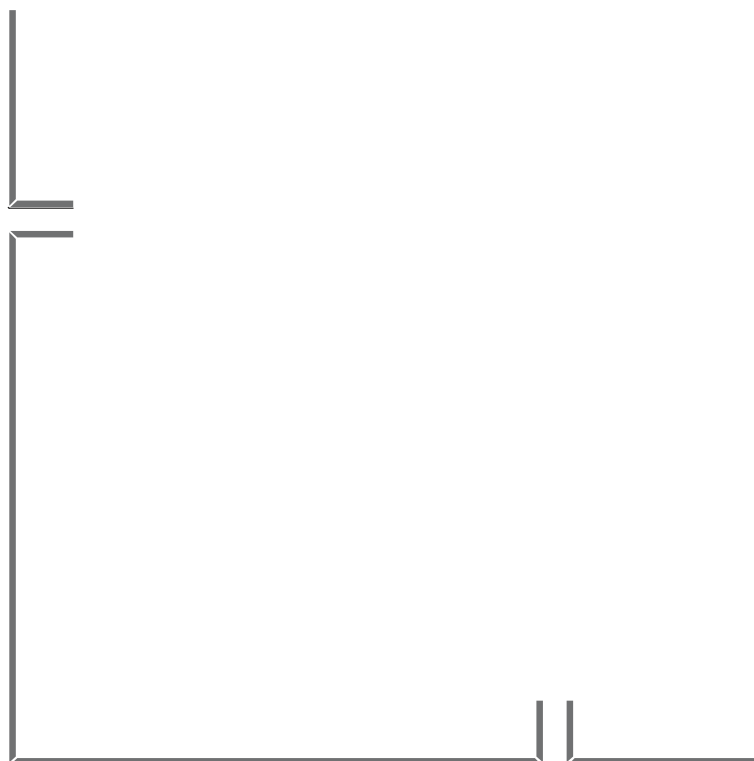
Note: the **STACBOND®PE**, **STACBOND®FR** & **STACBOND®INTdesign** panel fabrications are supplied in the drawing. The shaping of the panels is carried out by the Client. There is no need for specific machinery.

ASSEMBLY DIAGRAM SYSTEM **STB-SZ**

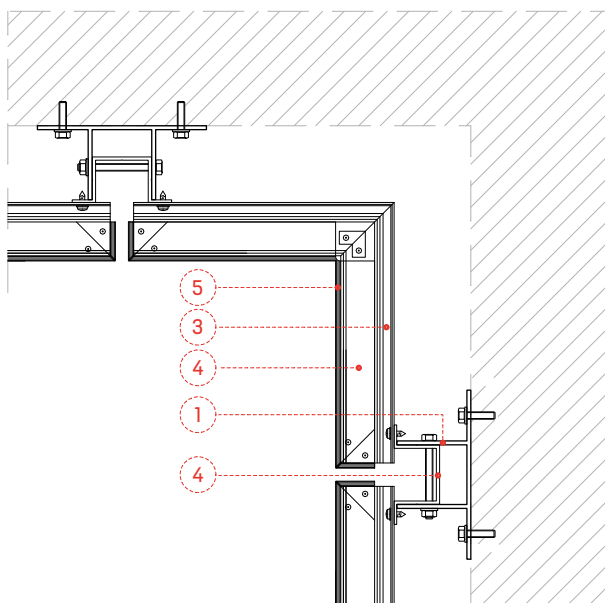


TECHNICAL DIAGRAMS SYSTEM **STB-SZ**

CORNER ROUNDING OFF HORIZONTAL SECTION



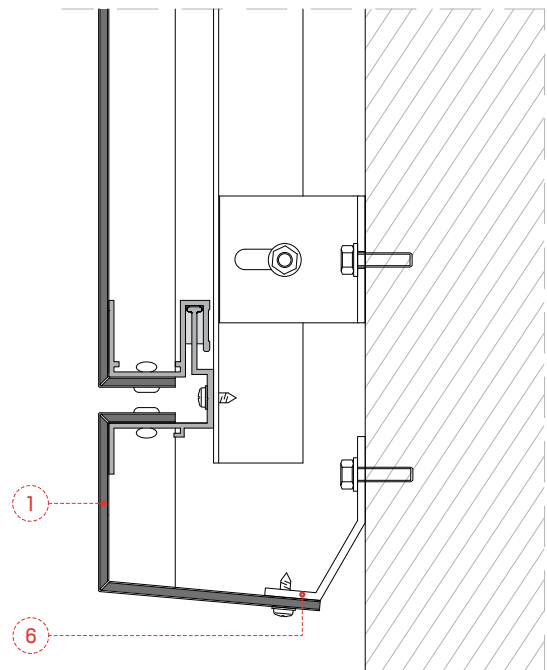
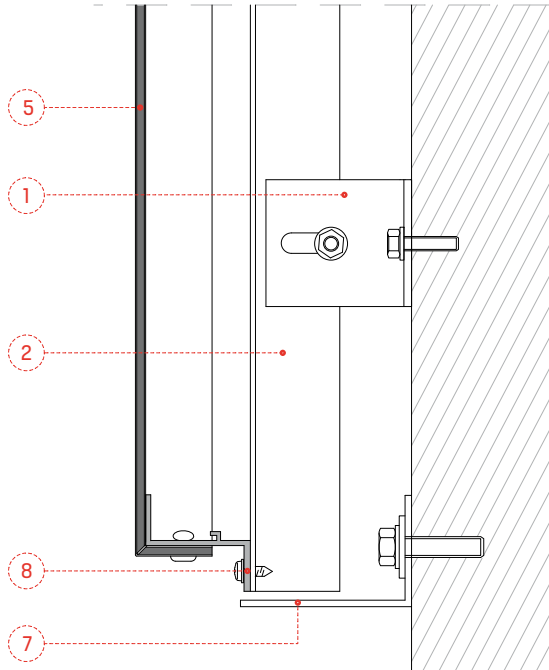
INSIDE CORNER ROUNDING OFF HORIZONTAL SECTION



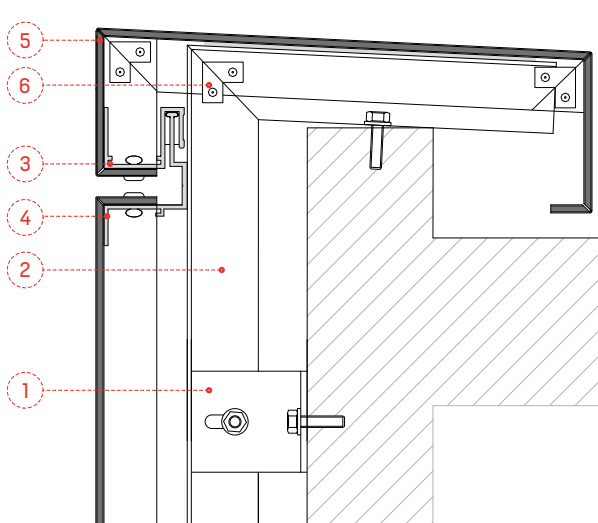
Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	S profile	05.19.001
4	Z profile	05.19.002
5	STACBOND composite panel tray	-
6	Aluminium rounding off for fixing	Not supplied by STAC

TECHNICAL DIAGRAMS SYSTEM **STB-SZ**

LOWER ROUNDING OFF VERTICAL SECTION



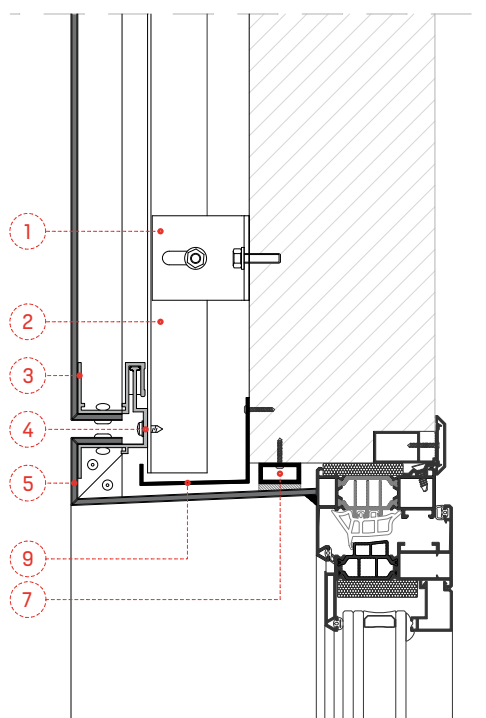
CORONATION ROUNDING OFF VERTICAL SECTION



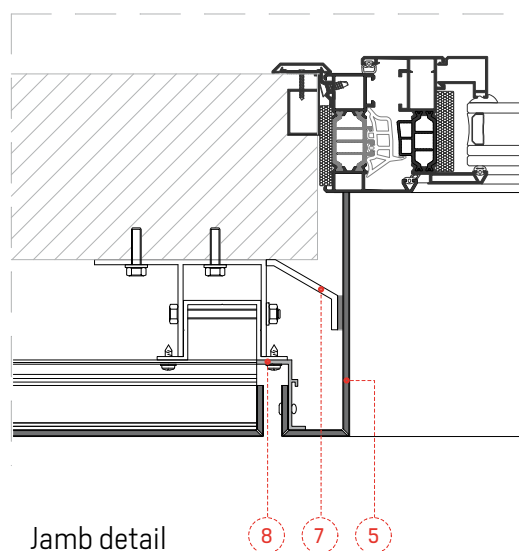
Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	S profile	05.19.001
4	Z profile	05.19.002
5	STACBOND composite panel tray	-
6	Aluminium rounding off for fixing	Not supplied by STAC
7	Auxilliary profile	Not supplied by STAC
8	Adapted Z profile	-
9	Evacuation apron	Not supplied by STAC

TECHNICAL DIAGRAMS SYSTEM **STB-SZ**

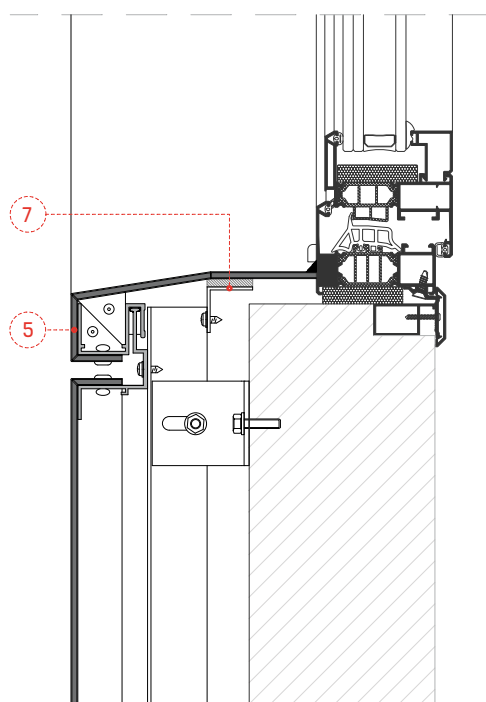
WINDOW ROUNDING OFF
VERTICAL SECTION



WINDOW ROUNDING OFF
HORIZONTAL SECTION



Lintel detail

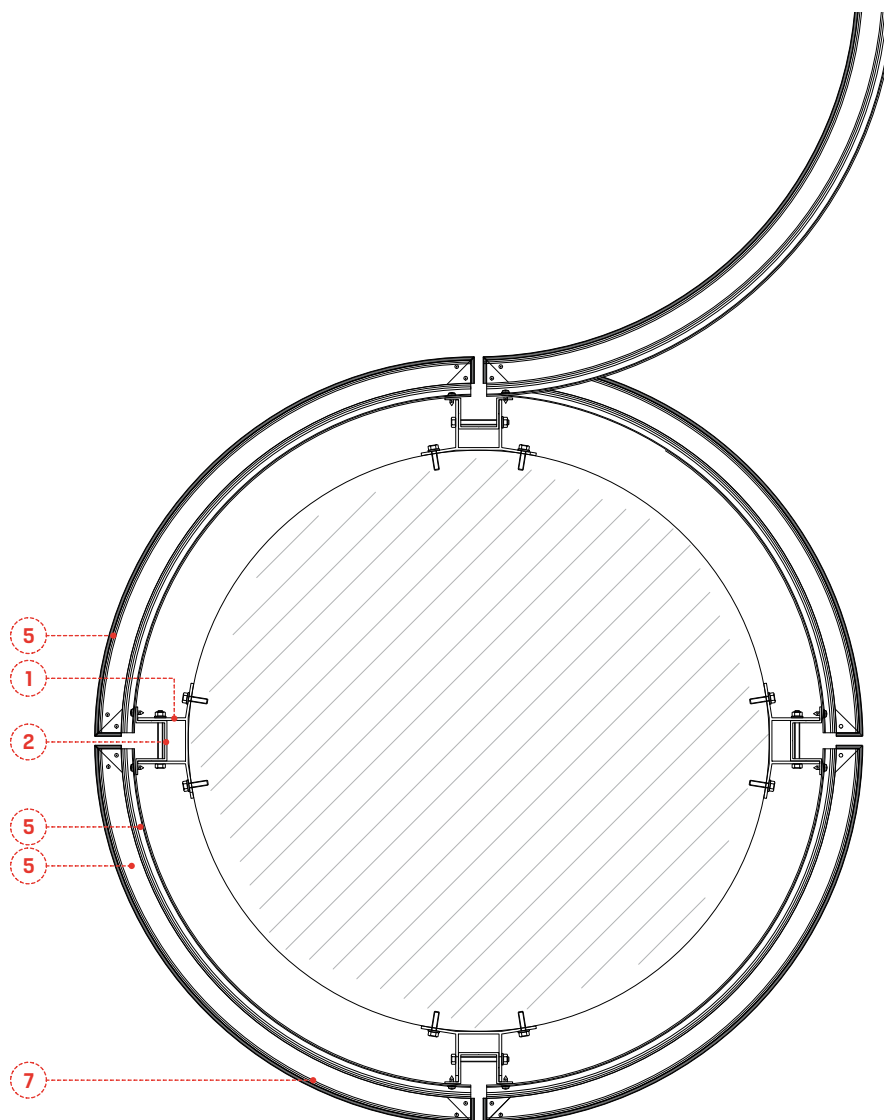


Water flow detail

Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	S profile	05.19.001
4	Z profile	05.19.002
5	STACBOND composite panel tray	-
6	Aluminium rounding off for fixing	Not supplied by STAC
7	Auxilliary profile	Not supplied by STAC
8	Adapted Z profile	-
9	Evacuation apron	Not supplied by STAC

TECHNICAL DIAGRAMS SYSTEM **STB-SZ**

CIRCULAR ROUNDING OFF HORIZONTAL SECTION



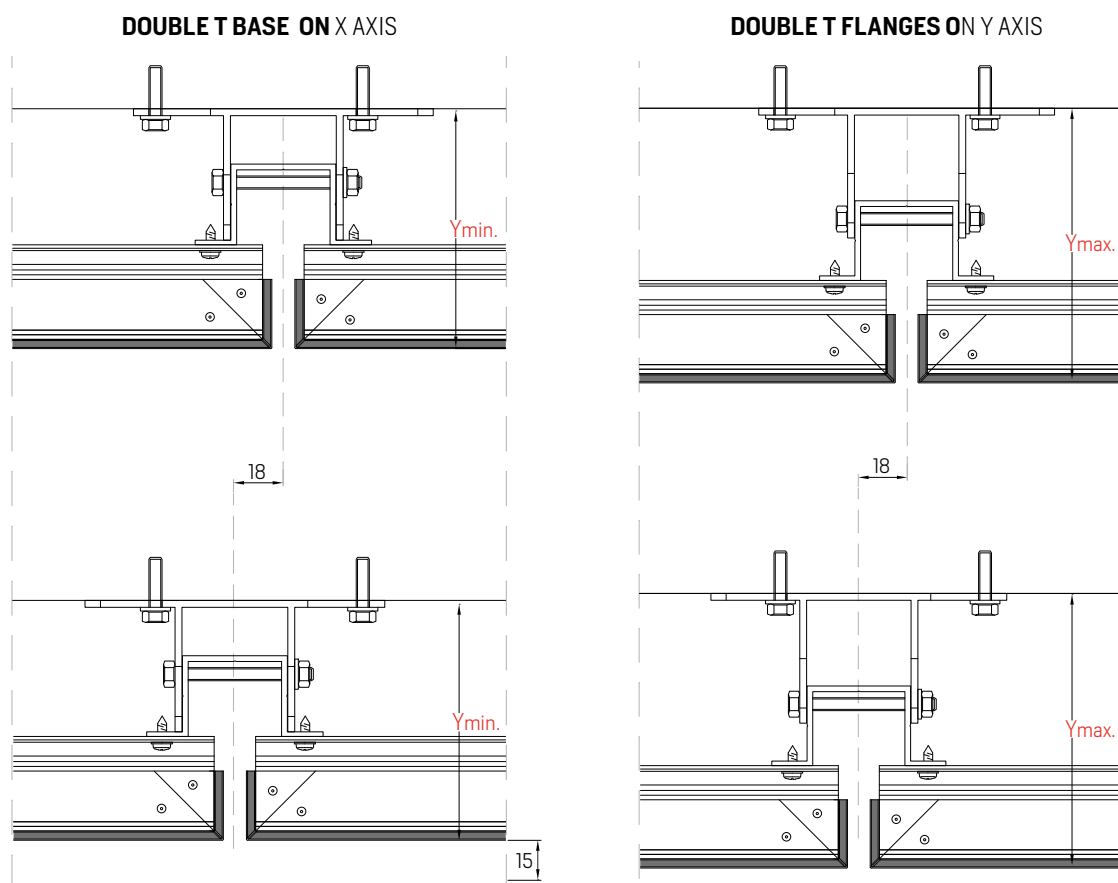
Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	S profile	05.19.001
4	Z profile	05.19.002
5	Tray made from STACBOND composite panel	-
6	Aluminium rounding off for fixing	Not supplied by STAC
7	Auxilliary profile	Not supplied by STAC
8	Adapted Z profile	-
9	Evacuation apron	Not supplied by STAC

Minium radii:

Without folds: 150 mm
With 20 mm folds in the curved edges: 500 mm (only one fold per edge).

TECHNICAL DIAGRAMS SYSTEM **STB-SZ**

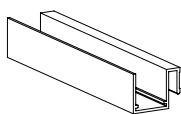
SCREW ADJUSTMENT ON THE BASE OF THE DOUBLE T



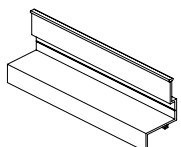
REFERENCE	DESCRIPTION	ADJUSTMENT MIN. (Y) STACBOND panel seen face	ADJUSTMENT MAX. (Y) STACBOND panel seen face
05.19.004	FIXING SCH-1-59	104	119
05.19.005	FIXING SCH-1-74	119	134
05.19.006	FIXING SCH-1-89	134	149
05.19.007	FIXING SCH-1-104	149	164
05.19.030	FIXING SCH-1-119	164	179
05.19.031	FIXING SCH-1-134	179	194
05.19.032	FIXING SCH-1-149	194	209
05.19.033	FIXING SCH-1-164	209	224
05.19.034	FIXING SCH-1-179	224	239
05.19.035	FIXING SCH-1-194	239	254
05.19.036	FIXING SCH-1-209	254	269
05.19.037	FIXING SCH-1-224	269	284
05.19.038	FIXING SCH-1-239	284	299
05.19.039	FIXING SCH-1-254	299	314

Adjustments in the axis and by fixing in mm.

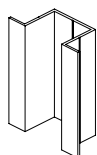
ACCESSORIES SYSTEM **STB-SZ**



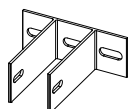
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.001	SC-S "S" PROFILE	6063 T5	-



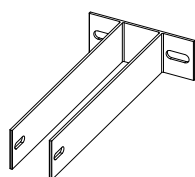
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.002	SC-Z "Z" PROFILE	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.003	SCH-2 OMEGA PROFILE	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.004	SCH-1-59 FIXING (e=3mm)	6063 T5	90
05.19.005	SCH-1-74 FIXING (e=3mm)	6063 T5	85
05.19.006	SCH-1-89 FIXING (e=3mm)	6063 T5	70
05.19.007	SCH-1-104 FIXING (e=3mm)	6063 T5	50

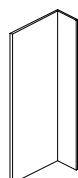


REFERENCE	PART	ALLOY	UNITS/BOX
05.19.030	SCH-1-119 FIXING	6005 T6	-
05.19.031	SCH-1-134 FIXING	6005 T6	-
05.19.032	SCH-1-149 FIXING	6005 T6	-
05.19.033	SCH-1-164 FIXING	6005 T6	-
05.19.034	SCH-1-179 FIXING	6005 T6	-
05.19.035	SCH-1-194 FIXING	6005 T6	-
05.19.036	SCH-1-209 FIXING	6005 T6	-
05.19.037	SCH-1-224 FIXING	6005 T6	-
05.19.038	SCH-1-239 FIXING	6005 T6	-
05.19.039	SCH-1-254 FIXING	6005 T6	-

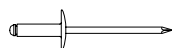
ACCESSORIES SYSTEM **STB-SZ**



REFERENCE	PART	ALLOY	UNITS/BOX
STB-JEPDM	S/Z PROFILE EPDM GASKET	-	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.99.231	SZ REINFORCEMENT	6063 T5	500



REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Polygrip SFS ASO-D-48150 Alu/stainless 4.8x15 blind rivet		
STB-R0300	Polygrip SFS ASO-D-48150 NOT PAINTED	100	100
	Polygrip SFS ASO-D-48150 PAINTED – RAL CHART	250	100

APPLICATION: For shaping **STACBOND®** STB-CH y STB-SZ composite panel.



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INFORMATION & SALES

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✉ stacbond@stac.es



ASSEMBLY SYSTEM **STB-RIVETED**

The **STB-RIVETED** assembly system is a very versatile system as it adapts perfectly to whatever architectonic typology. It is about a seen fixing system and rapid assembly that **admits as many horizontal pieces as vertical**.

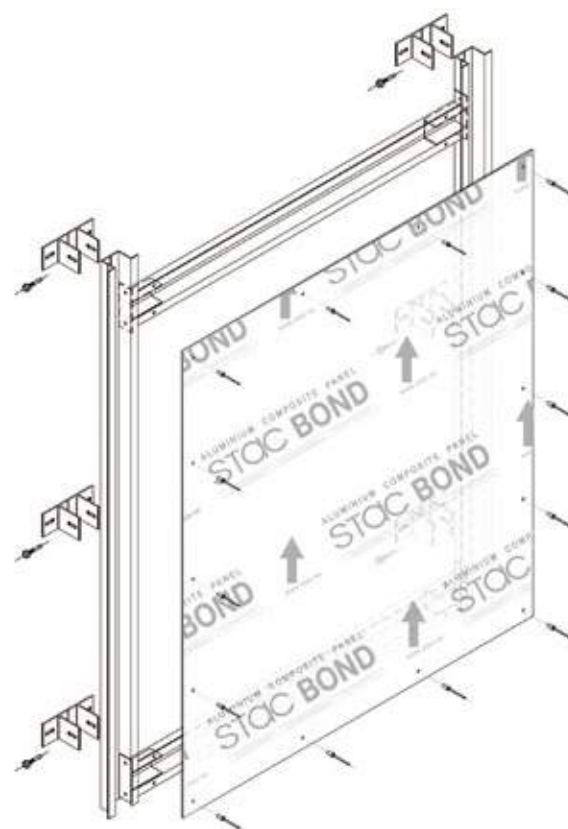
Furthermore, by using panels that have not been shaped, it offers the **possibility of executing curved areas**. For all of this, the **STB-RIVETED** system complies with all of the requisites in order to execute the most demanding architectonic claddings.

All of the **sub-structure** is made with **6063 T5 aluminium alloy** profiles. The substructure is made with double “T” shape fixings ref. SCH-1 with different lengths in order to absorb all of the façade’s irregularities.

The spacer will be fixed to the vertical parameter using special mechanical wedges that are in each case, recommended by the fixing suppliers. These double T spacers receive the omega shaped vertical mullions ref. SCH-2.

On the vertical mullions, the horizontal mullions are fixed using a **mullion joiner** ref. SCR-3 which is an **aluminium alloy 6063 T5** part. This perimetral substructure consisting of omega shaped vertical and horizontal mullions support the **STACBOND®** composite panel plates that are riveted around their perimeter.

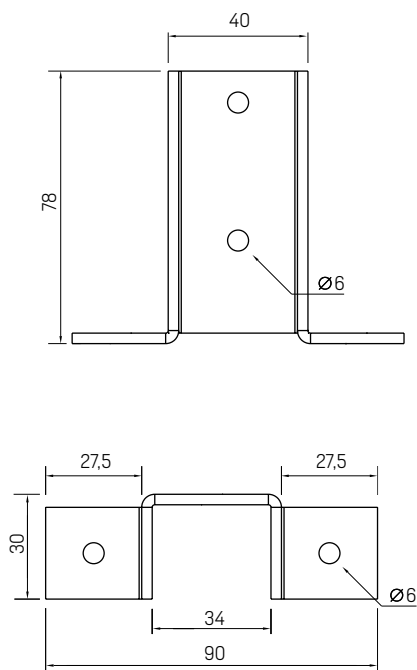
Stac has developed a programme for a specific calculation of the substructure using the criteria in the Technical Suitability Document (BBA 13/5022) which was established at the British Board of Agrément for the execution of each project. This programme defines the maximum distances between vertical mullions of an omega shape and number of fixings.



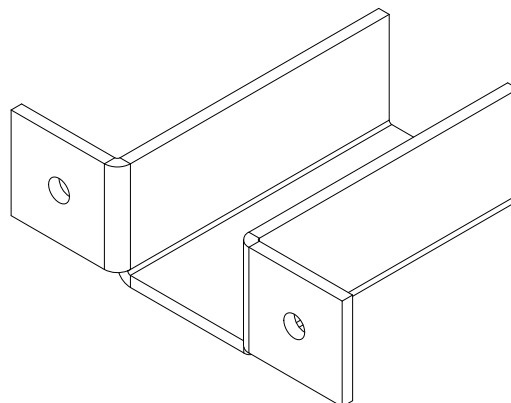
The **STB-RIVETED** system can be assembled with a one directional or bidirectional substructure and with the one directional gasket it remains open. Both options comply with the Technical Suitability Document (DIT).

AUXILIARY ELEMENTS FOR THE STB-RIVETED SYSTEM

SCR - 3 MULLION JOINING



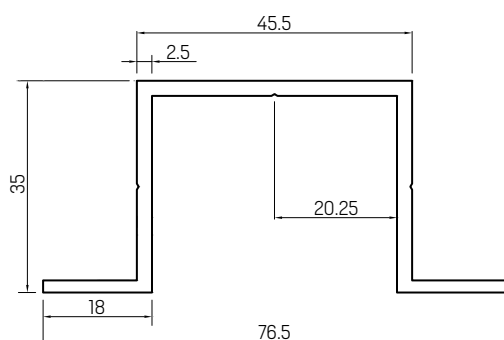
MULLION JOINING



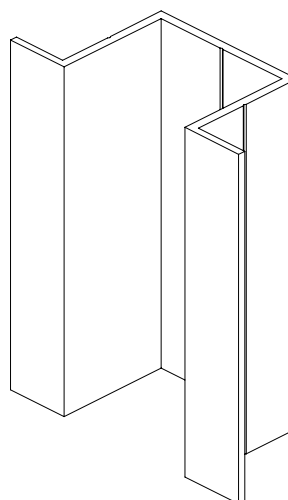
REFERENCE	DESCRIPTION	PRESENTATION
05.19.020	SCR-3 MULLION JOINING	200 units/box.

A part for joining the vertical omega with the horizontal.

SCH - 2 OMEGA PROFILE

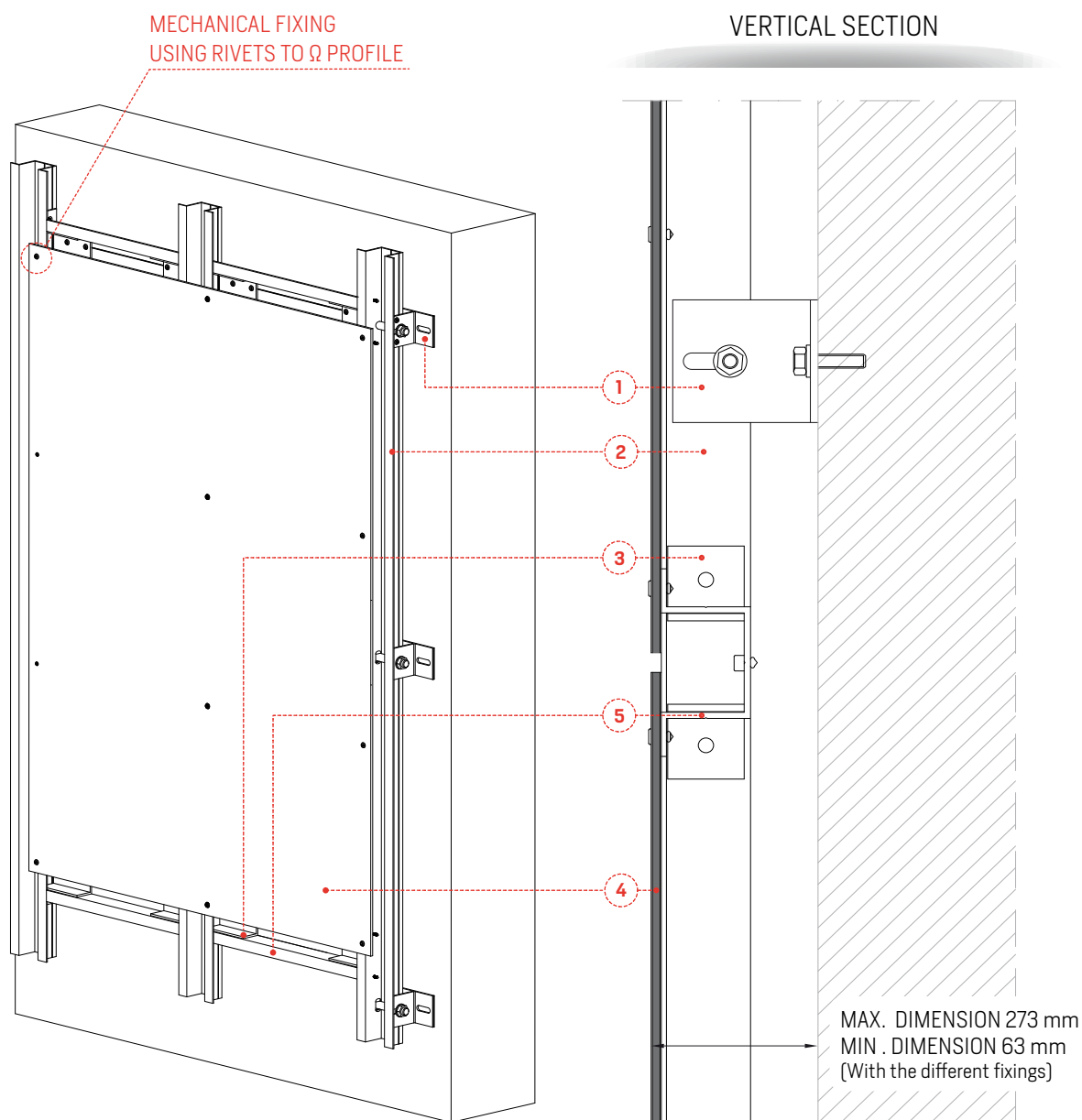


OMEGA PROFILE



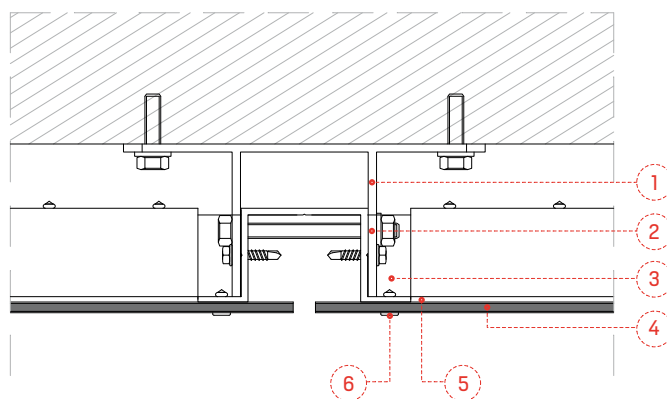
REFERENCE	DESCRIPTION	PRESENTATION
05.19.003	SCH-2 PROFILE	6 mt. length

ASSEMBLY DIAGRAM SYSTEM **STB-RIVETED**



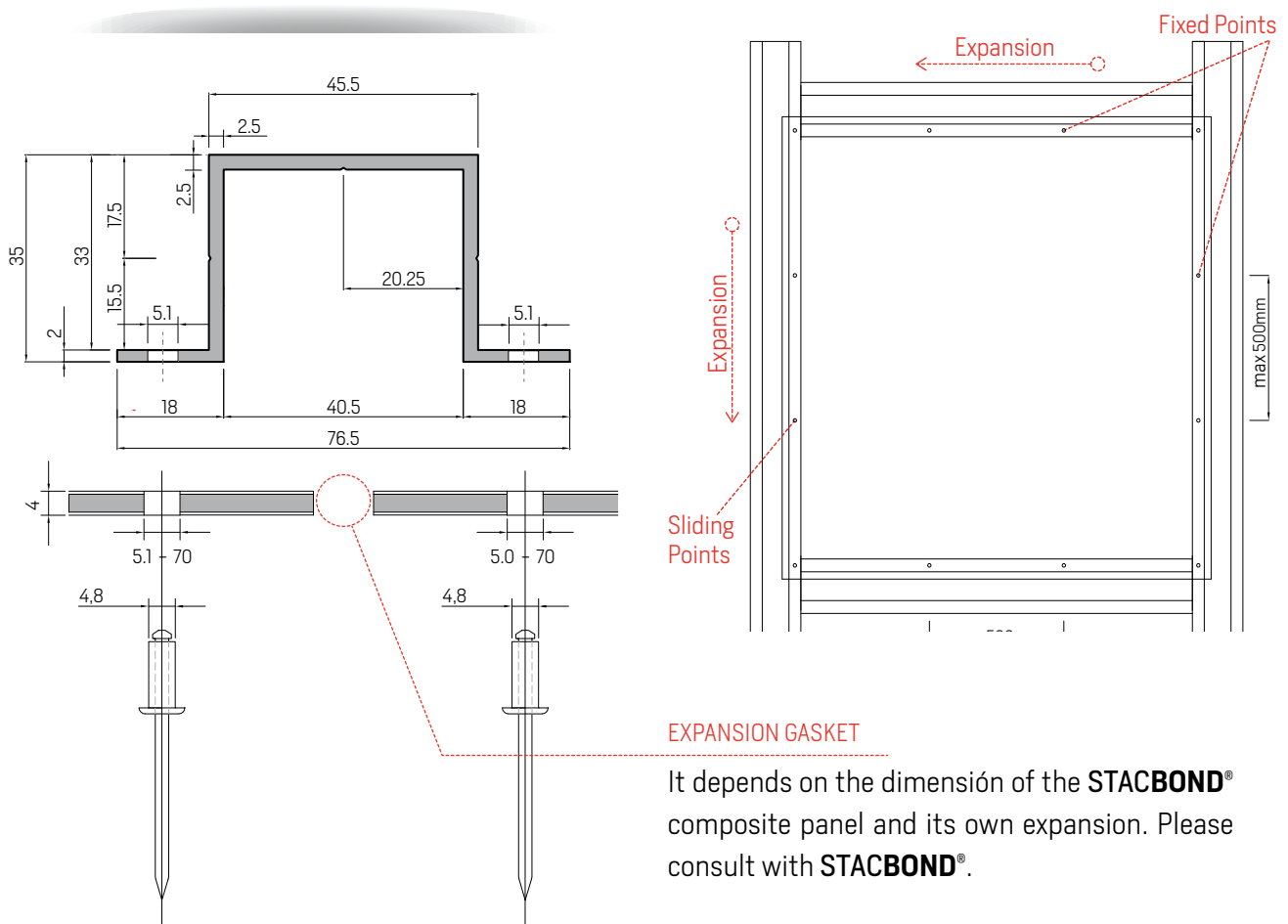
HORIZONTAL SECTION

Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	Joining profile between omegas	05.19.020
4	STACBOND composite panel	
5	Omega transom profile	05.19.003
6	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head. 14 mm	STB-R0100



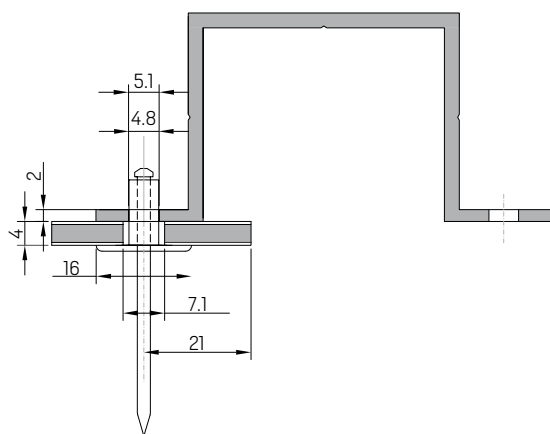
TYPES OF PERFORATIONS AND RIVET SYSTEM **STB-RIVETED**

SECTION



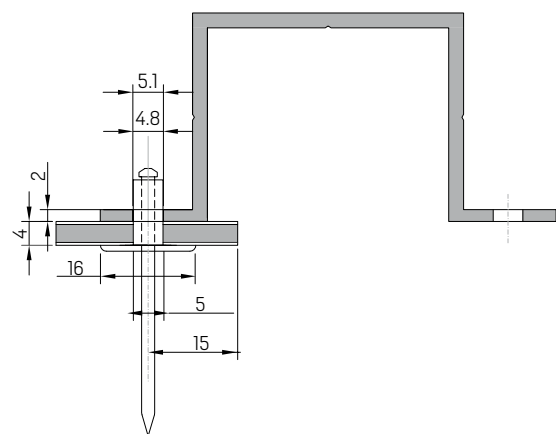
It depends on the dimension of the **STACBOND®** composite panel and its own expansion. Please consult with **STACBOND®**.

SLIDING POINTS SECTION



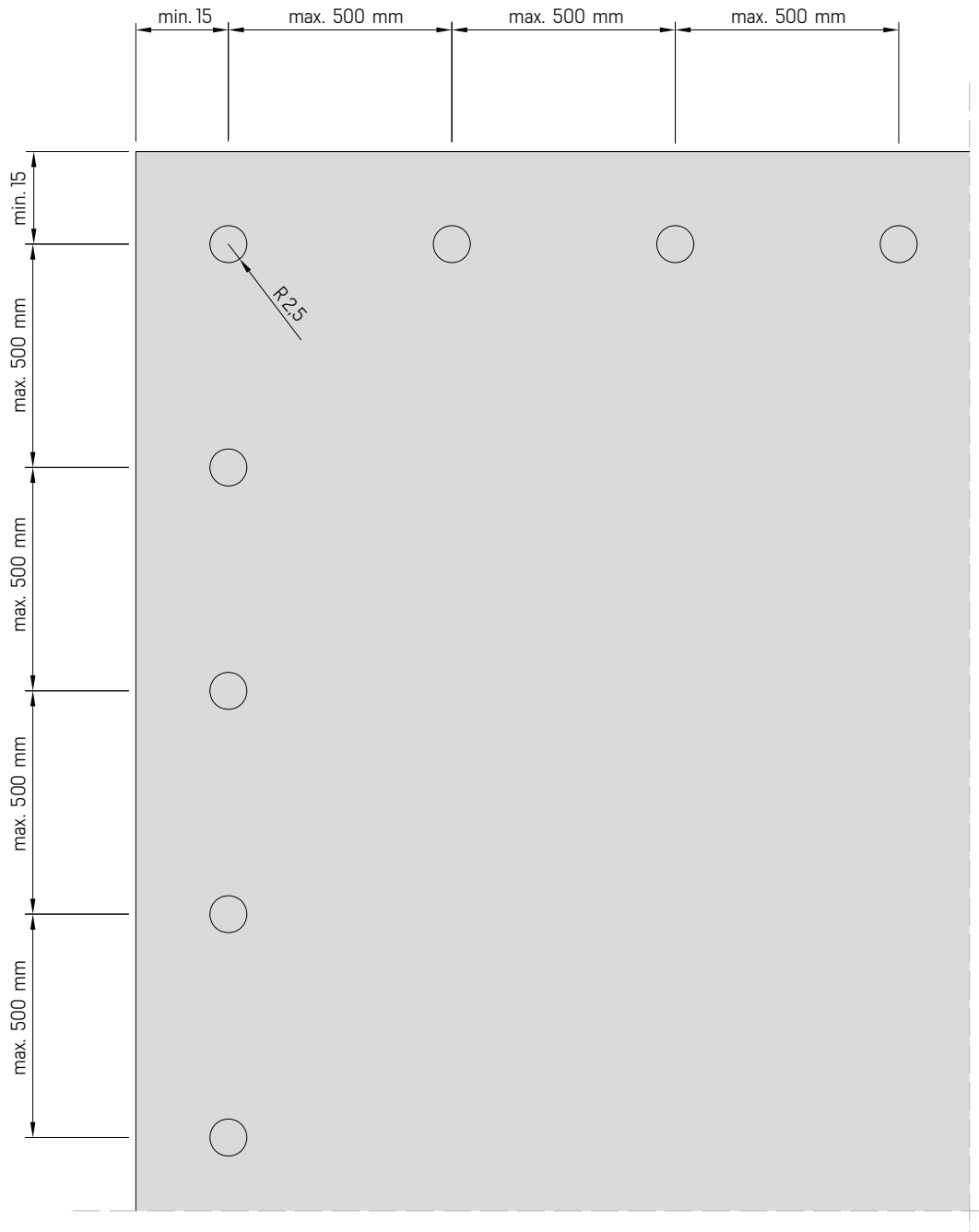
The figure demonstrates the sliding point, a drill hole in the **STACBOND®** Composite Panel which has a larger diameter so that it can absorb expansion.

FIXED POINT SECTION



The figure demonstrates the fixed point and from where the panel expansion is produced.

PERFORATION LAYOUT SYSTEM **STB-RIVETED**

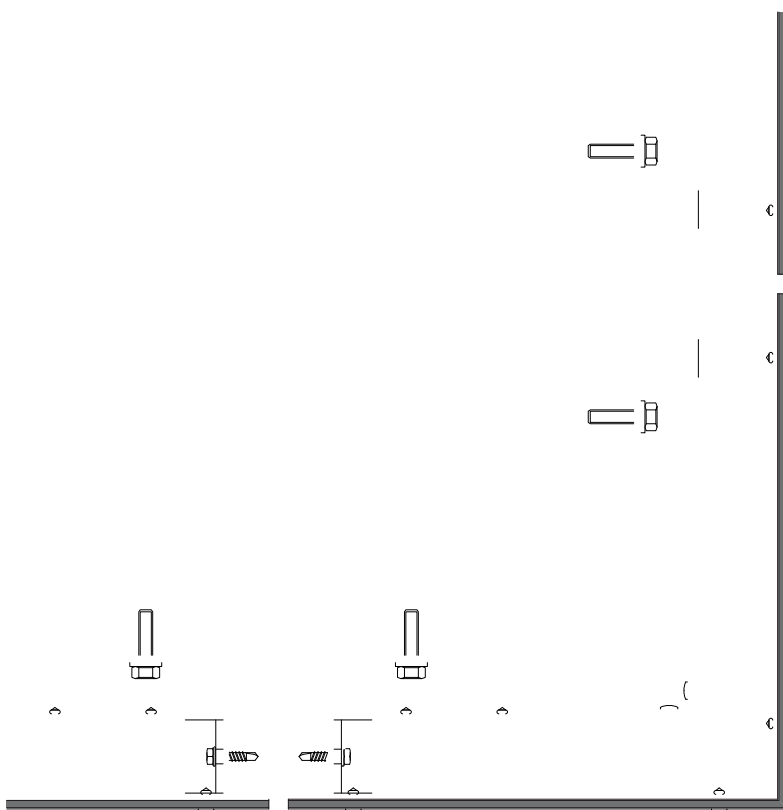


In the drawing the perforation diameters are demonstrated and the maximum distance to where these have to be situated.

The panels are installed on site by being perforated and fitting the corresponding rivet but respecting the play between the screw diameter and the rivet pin as well as the distances between rivets and the panel edges.

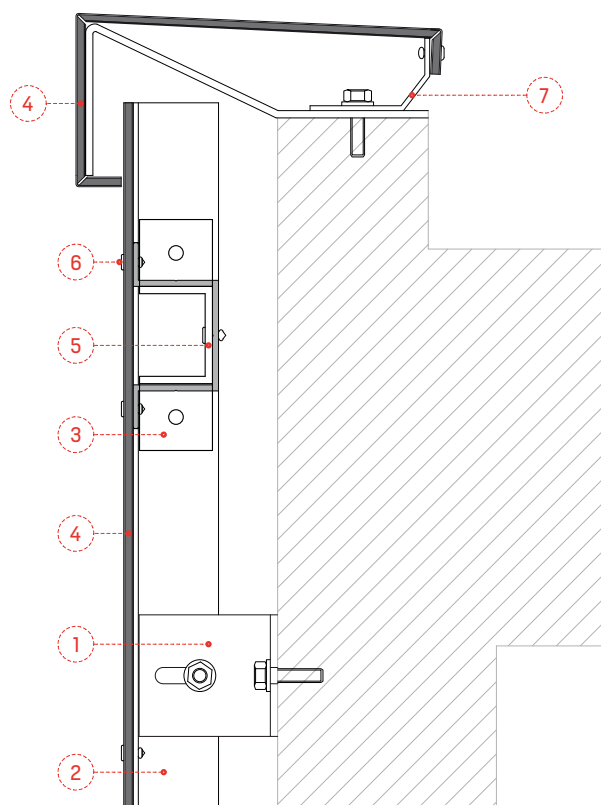
We recommend using a guide in order to position the rivets.

Special attention must be paid to the direction indicated with an arrow on the film protector in order to guarantee that different tones are not produced when the sun shines on to the façade.

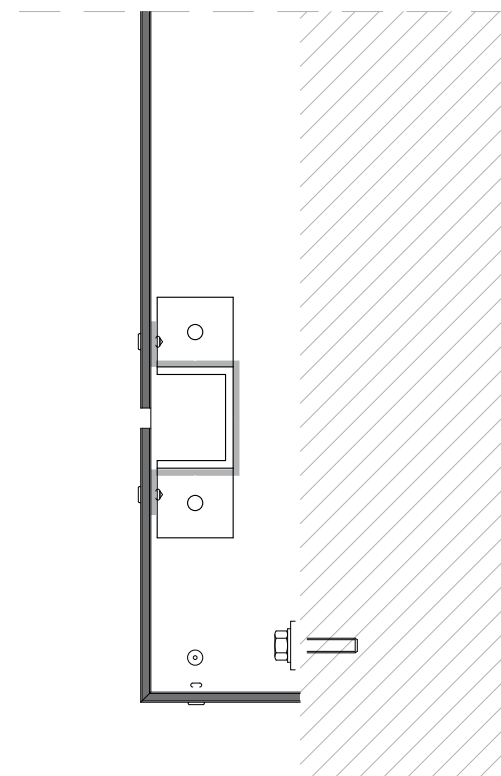


TECHNICAL DIAGRAMS SYSTEM **STB-RIVETED**

CORONATION ROUNDING OFF



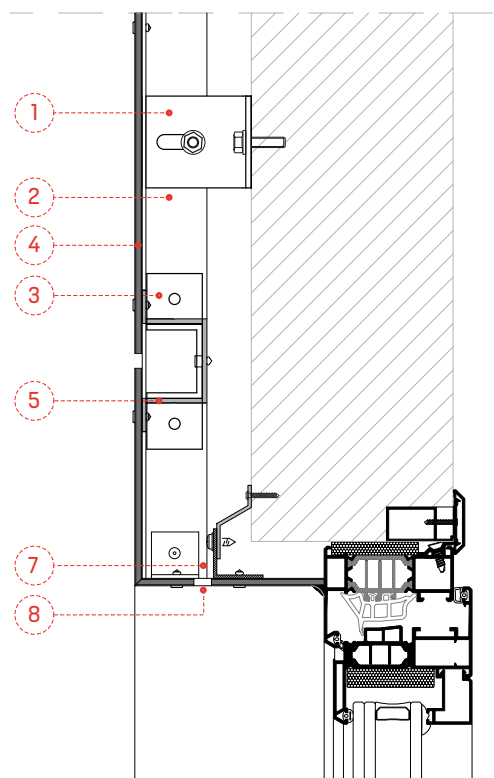
LOWER ROUNDING OFF
VERTICAL SECTION



Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	Joining profile between omegas	05.19.020
4	STACBOND composite panel	-
5	Omega transom profile	05.19.003
6	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head. 14 mm	STB-R0100
7	Auxilliary profile	Not supplied by STAC
8	Ventilation perforations	

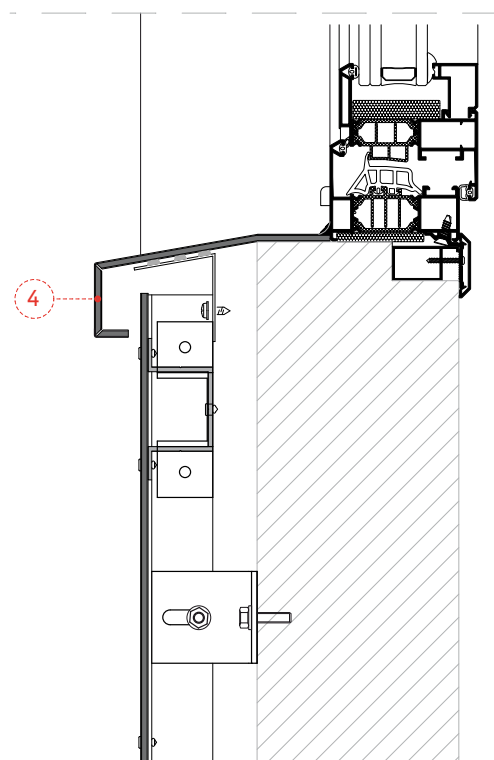
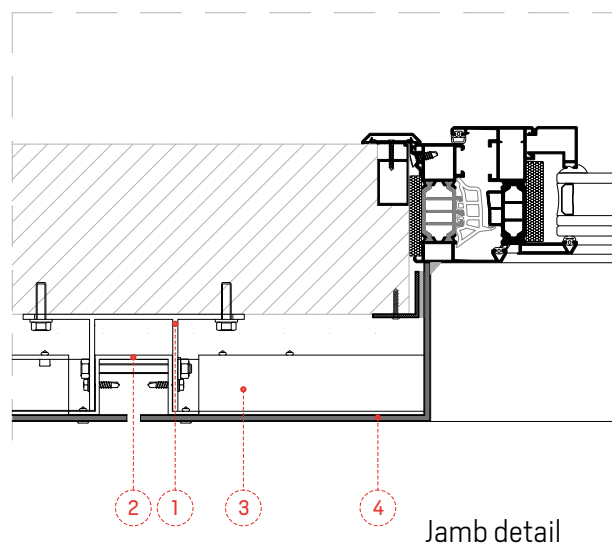
TECHNICAL DIAGRAMS SYSTEM **STB-RIVETED**

WINDOW ROUNDING OFF
VERTICAL SECTION



Lintel detail

WINDOW ROUNDING OFF
HORIZONTAL SECTION

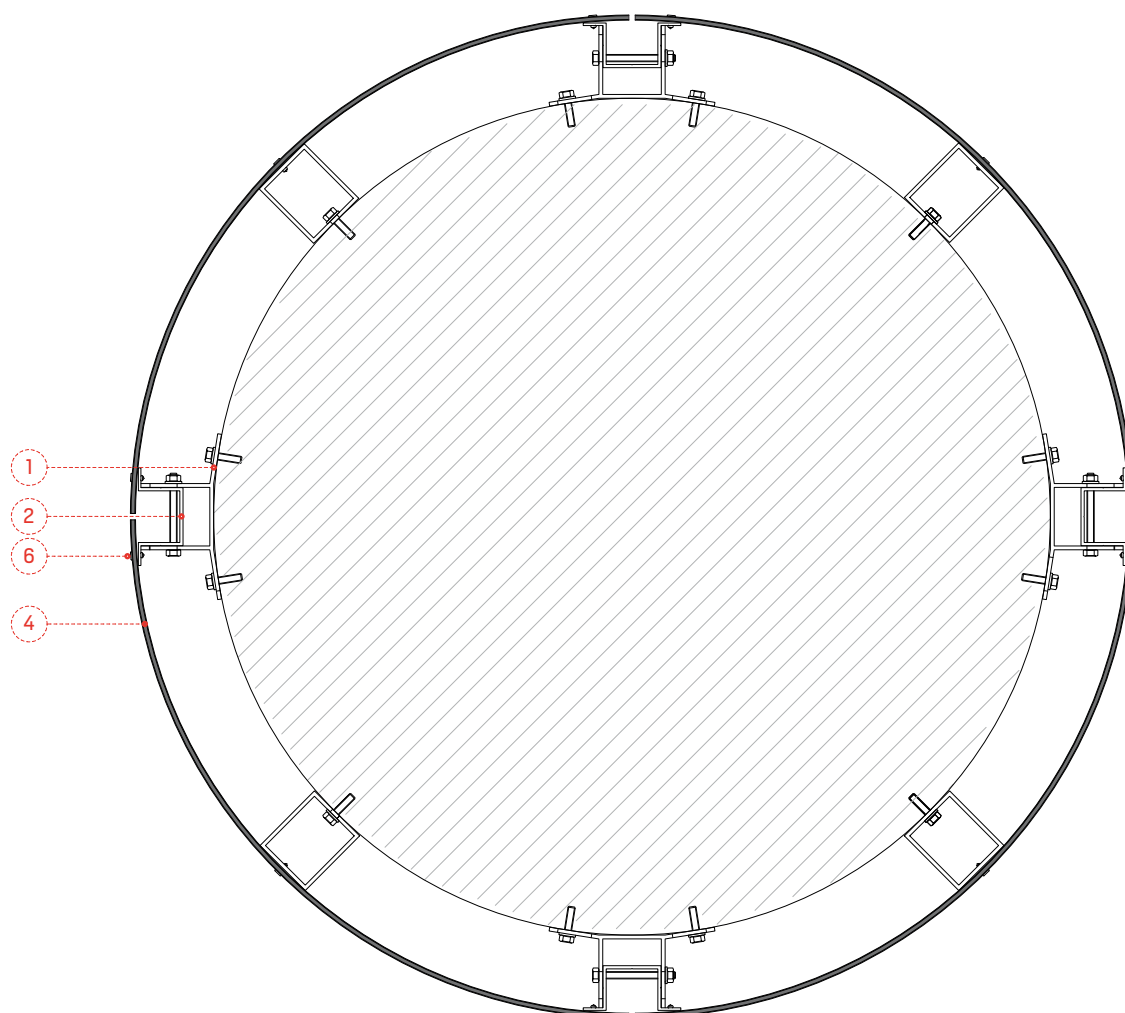


Water flow detail

Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	Joining profile between omegas	05.19.020
4	STACBOND composite panel	-
5	Omega transom profile	05.19.003
6	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head. 14 mm	
7	Auxilliary profile	Not supplied by STAC
8	Ventilation perforations	

TECHNICAL DIAGRAMS SYSTEM **STB-RIVETED**

CIRCULAR ROUNDING OFF HORIZONTAL SECTION



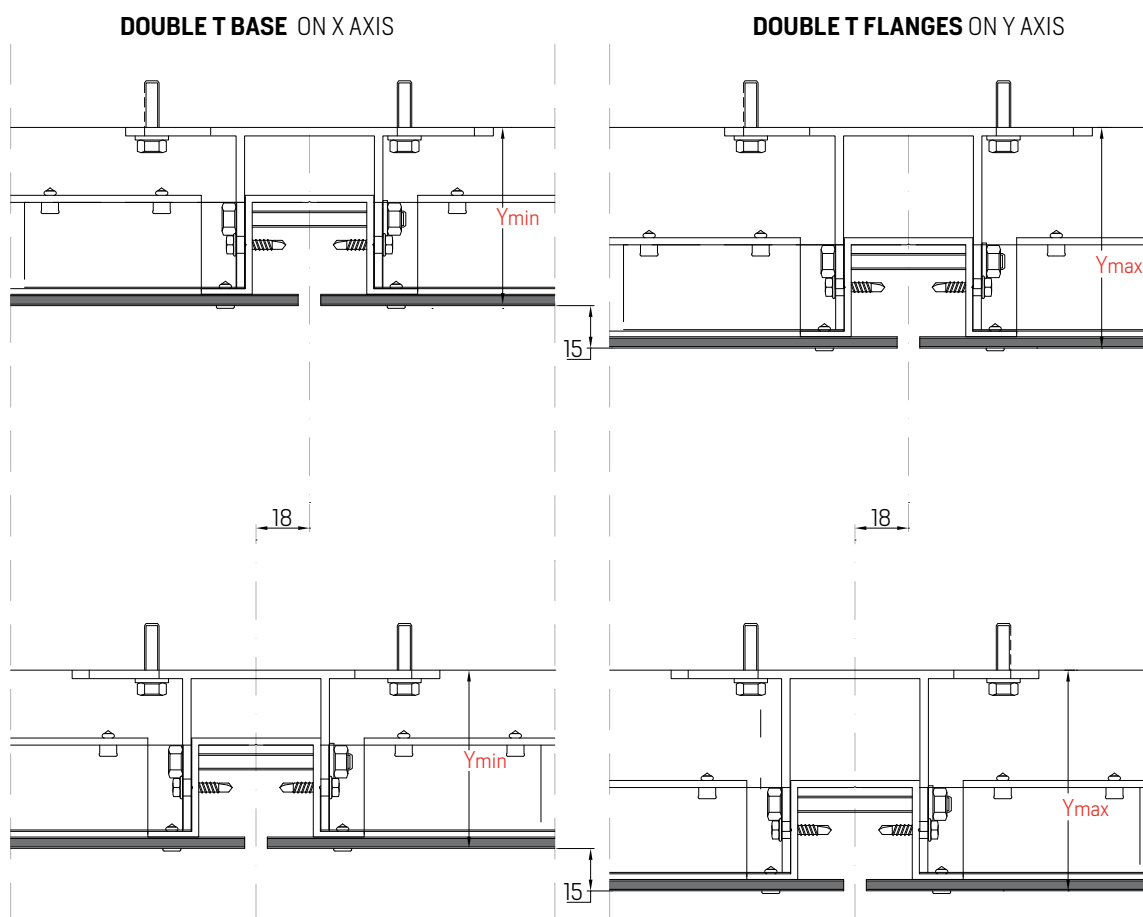
Nº	DESIGNATION	REFERENCE
1	Double T profile bracket	05.19.004
2	Omega mullion profile	05.19.003
3	Joining profile between omegas	05.19.020
4	STACBOND composite panel	-
5	Omega transom profile	05.19.003
6	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head. 14 mm	STB-R0100

Minium radii:

Without folds: 150 mm
With 20 mm folds in the curved edges: 500 mm
(only one fold per edge).

TECHNICAL DIAGRAMS SYSTEM **STB-RIVETED**

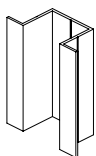
SCREW ADJUSTMENT ON THE BASE OF THE DOUBLE T



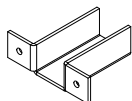
REFERENCE	DESCRIPTION	ADJUSTMENT MIN. (Y) STACBOND panel seen face	ADJUSTMENT MAX. (Y) STACBOND panel seen face
05.19.004	FIXING SCH-1-59	63	78
05.19.005	FIXING SCH-1-74	78	93
05.19.006	FIXING SCH-1-89	93	108
05.19.007	FIXING SCH-1-104	108	123
05.19.030	FIXING SCH-1-119	123	138
05.19.031	FIXING SCH-1-134	138	153
05.19.032	FIXING SCH-1-149	153	168
05.19.033	FIXING SCH-1-164	168	183
05.19.034	FIXING SCH-1-179	183	198
05.19.035	FIXING SCH-1-194	198	213
05.19.036	FIXING SCH-1-209	213	228
05.19.037	FIXING SCH-1-224	228	243
05.19.038	FIXING SCH-1-239	243	258
05.19.039	FIXING SCH-1-254	258	273

Adjustments in the axis and by fixing in mm. .

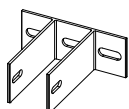
ACCESSORIES SYSTEM **STB-RIVETED**



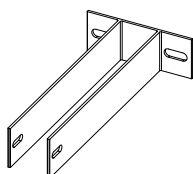
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.003	SCH-2 OMEGA PROFILE	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.020	SCR-3 MULLION JOINING	1050H24	200



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.004	SCH-1-59 FIXING (e=3mm)	6063 T5	90
05.19.005	SCH-1-74 FIXING (e=3mm)	6063 T5	85
05.19.006	SCH-1-89 FIXING (e=3mm)	6063 T5	70
05.19.007	SCH-1-104 FIXING (e=3mm)	6063 T5	50



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.030	SCH-1-119 FIXING	6005 T6	-
05.19.031	SCH-1-134 FIXING	6005 T6	-
05.19.032	SCH-1-149 FIXING	6005 T6	-
05.19.033	SCH-1-164 FIXING	6005 T6	-
05.19.034	SCH-1-179 FIXING	6005 T6	-
05.19.035	SCH-1-194 FIXING	6005 T6	-
05.19.036	SCH-1-209 FIXING	6005 T6	-
05.19.037	SCH-1-224 FIXING	6005 T6	-
05.19.038	SCH-1-239 FIXING	6005 T6	-
05.19.039	SCH-1-254 FIXING	6005 T6	-

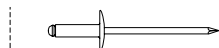
ACCESSORIES SYSTEM **STB-RIVETED**

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head 14 mm		
STB-RO100	SFS AP14-S-5,0x12 - NOT PAINTED	100	100
	SFS AP14-S-5,0x12 - PAINTED - RAL CHART	250	100



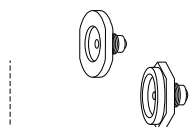
APPLICATION: for the fixing of **STACBOND®** façade panels over a metallic STB-RIVETED substructure

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Façade rivet - 15 mm head. Inox/Inox A4 5x14		
STB-RO200	SSO-D15-50140 - NOT PAINTED	100	100
	SSO-D15-50140 - PAINTED - RAL CHART	250	100

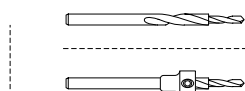


APPLICATION: for the fixing of **STACBOND®** façade panels over a metallic substructure for high exposure atmospheres to the presence of chlorides.

REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-201	Riveter nozzles for SSO-D15 rivets	Tightening limiter function for moving points	1
STB-FIJA-202	Riveter nozzles for AP rivets	Tightening limiter function for moving points	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-203	Double drill bit (HSS-7,0/5,1x74)	Drill panel at 7 mm & substructure at 5,1 mm	1
STB-FIJA-204	Depth limit (Depth Locator 16x18)	Works with a double drill bit so as not to drill a 7 mm hole in the substructure	1



REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-205	Centerer (DG-146x20-7,0)	When the panels are drilled at 7 mm and we have to drill a 5.1 mm hole centred over the substructure	1
STB-FIJA-206	6.9 mm diameter centerer replacement point	It is the part A of the centerer so that there is no need to buy a complete one if it is damaged	1
STB-FIJA-207	Special drill bit for the centerer(HSS-5,1x62/26)	A drill bit with a shorter helicoidal so that it does not enter in to the centerer and jams	10



REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Screw head 4,8x19 stainless A2 torx head		
STB-TO100	SLA3/6-S-D12-4,8x19 NOT PAINTED	500	100
	SLA3/6-S-D12-4,8x19 - PAINTED RAL CHART	250	100



ACCESSORIES SYSTEM **STB-RIVETED**

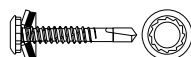
REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	ACCESSORIES FOR SCREWING STB-REM SCREWS		
STB-FIJA-208	POINT T20WW-25-HEX1/4"	1	1
STB-FIJA-209	Manual centerer for SLA3 screws	1	1



Once in, it cannot be removed

APPLICATION: for fixing the **STACBOND®** façade panels on to a STB-RIVETED metallic substructure

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Security screw 5,5x32 stainless A2 Irius security head		
STB-T0200	SX3/15-L12-S16/1-5,5x32 NOT PAINTED	500	100
	SX3/15-L12-S16/1-5,5x32 PAINTED RAL CHART	250	100



REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
STB-FIJA-210	Irius socket wrench G-00106.07	1	1



Assembled with a security socket. It can be removed with the socket

APPLICATION: For fixing the **STACBOND®** façade panels on to the STB-RIVETED metallic substructure.



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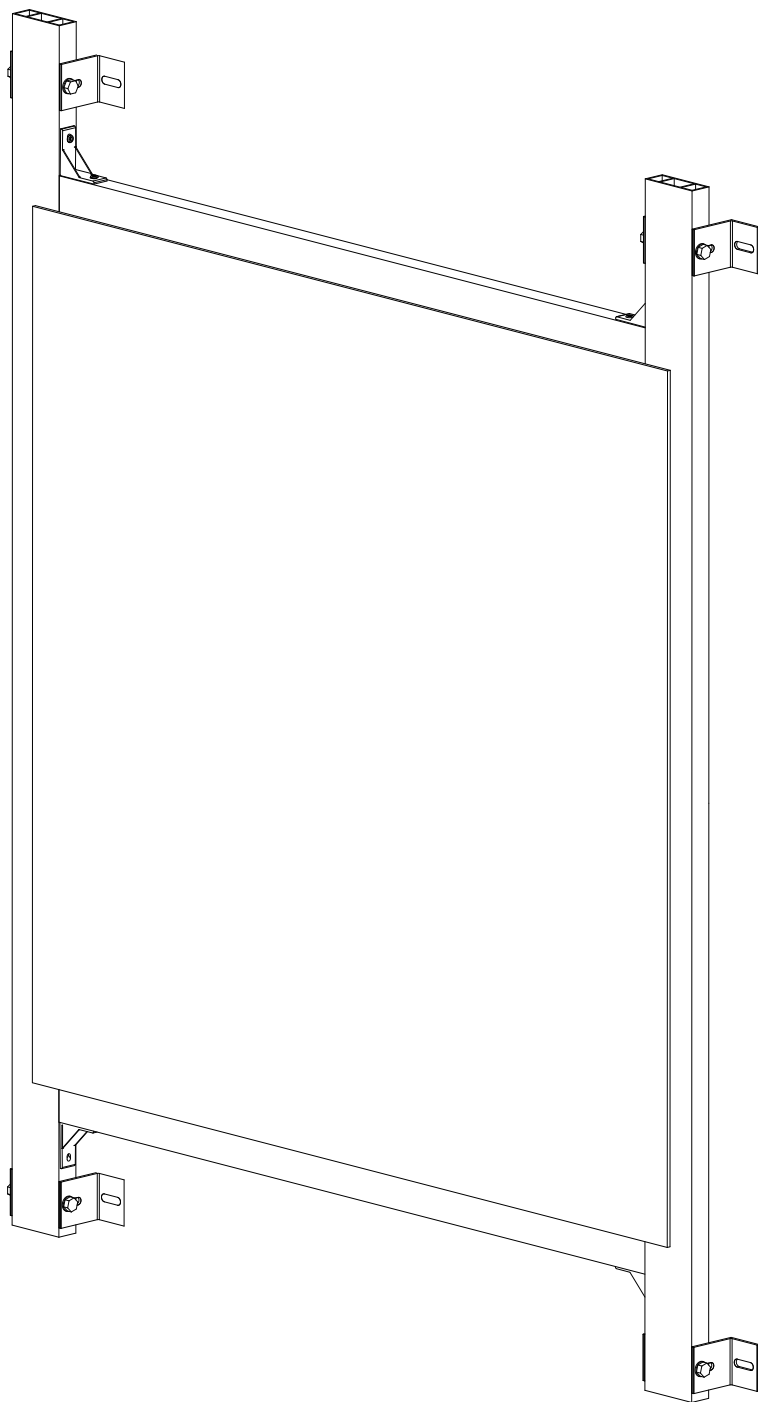
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ASSEMBLY SYSTEM **STB-GLUED**

STB-GLUED, a **STACBOND®** Composite Panel system where the plate is adhered using a chemical fixing to a substructure made up of vertical and horizontal mullions with a ribbed 70 x 24.50 mm tube and joined together using an angle called a “Glued Mullion Joiner”.

A lightweight system, with concealed fixing and is quick and economic to assemble. It allows for modulations of **STACBOND®** Composite Panel both horizontally as well as vertically. As it is a glued system with chemical fixings, it is resistant to aging and the elements, absorbs vibrations and offers multiple possibilities for façade design

All of the substructure will be made using **6063 T5 aluminium** profiles. The fixings or spacers in an “L” shape will be situated against each other in order to bidimensionally absorb the façade’s irregularities. Spacer ref. SC1 is fixed to the vertical parameter using special mechanical wedges that are recommended in each case by the fixing suppliers.

These spacers receive the grooved tubular mullions and transoms (extruded **aluminium profile alloy 6063 T5** ref. SCP-2). These grooved tubular profiles make up a perimetral frame that holds the panels made from **STACBOND®** Composite Panels with great rigidity and using an adhesive fixing.

Steps to follow for assembly:

1. Clean the substructure.

The substructure must be clean, dry, homogeneous, free of oils, grease, dust and loose or badly adhered particles. Paint, whitewash and other coatings must be removed.

Precautions:

- Clean the surface with damp paper, moving in only one direction as if sanding. Dissolvents should never be used.
- For prior cleaning and de-greasing, use SIKACLEANER 205 de-greaser and cleaner or similar and allow for it to evaporate for at least 10 minutes.

2. Area priming.

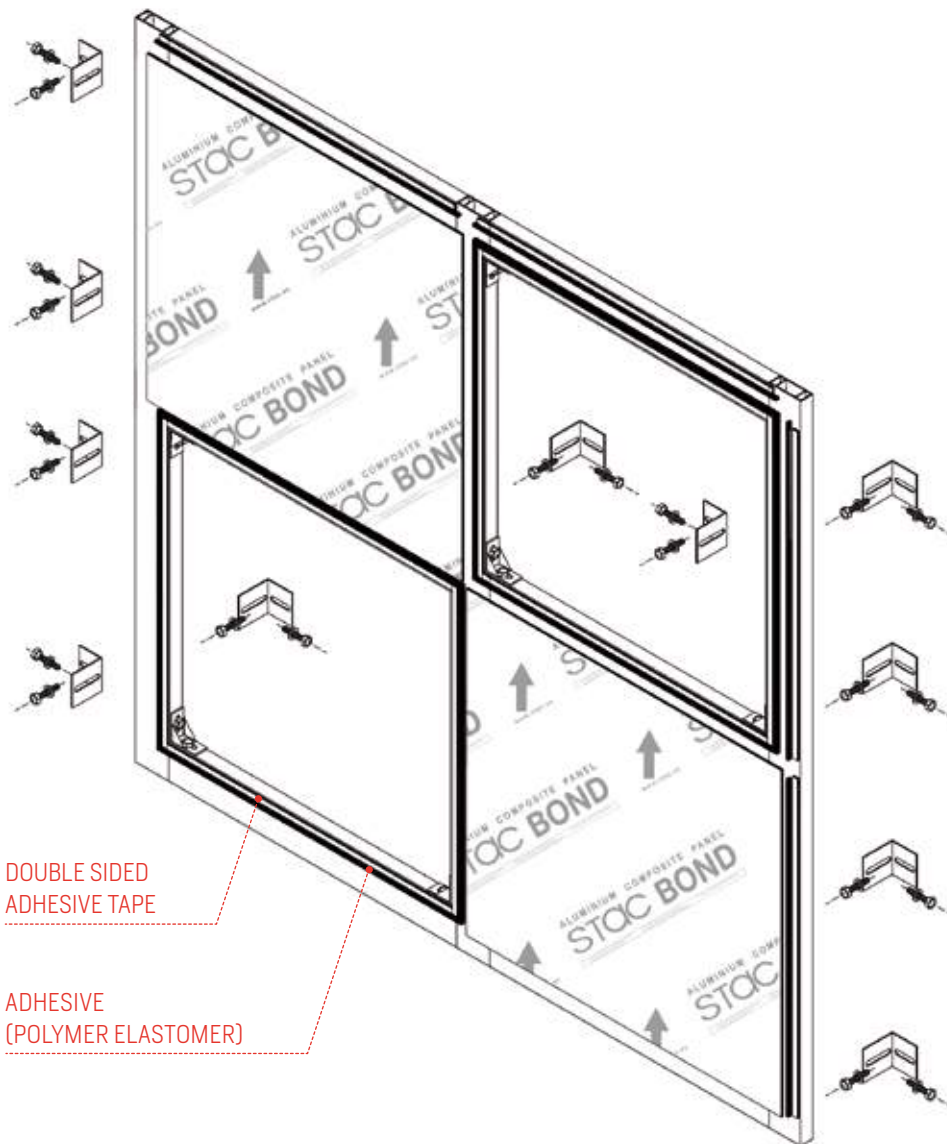
The priming is made with a product that reinforces the adherence of the adhesive paste to the substructure using SIKATACK PANEL PRIMER or similar.

Precautions:

- Once hardened, the primings can only be removed mechanically.
- The priming leaves a heterogeneous film. The surfaces should only be treated if they are going to be glued.
- It is essential to respect the cleaner evaporation times in all circumstances (30, 60 mins.)

3. Application of the double sided adhesive tape. The SIKATACK PANEL 3 double sided tape or similar is to be used for the initial fixing of the panels until the adhesive has polymerized and has reached a minimum 3 mm adhesive thickness so that it can absorb the possible expansions and vibrations in the **STACBOND®** Composite Panel façade. The long term resistance is achieved only with the adhesive.

ASSEMBLY SYSTEM **STB-GLUED**



4. Elastic adhesive.

Apply a SIKATAACK PANEL elastic adhesive strip or similar using the triangular nozzle (8 mm wide & 10 mm long) at least at 5 mm from the tape. The application must be done using a manual or pneumatic pistol. So that the application is correct, the application pistol should be placed perpendicular to the support.

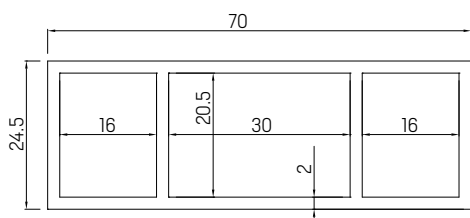
5. Panel fitting.

Remove the film protector from the double sided adhesive tape. Carefully fit the panel in its exact position and press firmly until the panel makes contact with the double sided tape.

Always comply with the panel manufacturers instructions regarding their storage. Avoid exposure to heat and direct sunlight prior to gluing the panels.

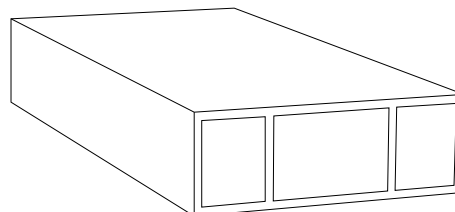
AUXILIARY ELEMENTS FOR THE STB-GLUED SYSTEM

SCP-2 GLUED MULLION



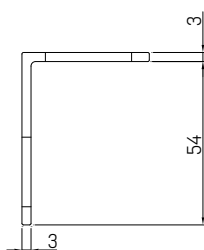
70 x 24.50 mm grooved tube for assembly of the STB-GLUED system.

GLUED MULLION



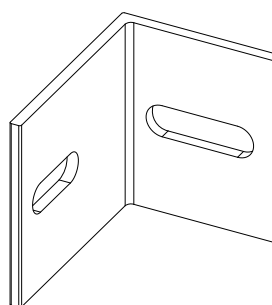
REFERENCE	DESCRIPTION	PRESENTATION
05.19.022	SCP-2 GLUED MULLION	-

SC-1-59 ANGULAR FIXING



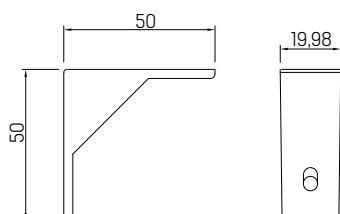
Angular fixing for fastening the mullion profile to the vertical parameter.

ANGULAR FIXING



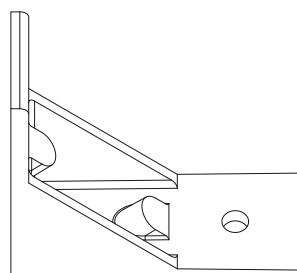
REFERENCE	DESCRIPTION	PRESENTATION
05.19.021	SC-1-59 ANGULAR FIXING	100

SCP-3 GLUED MULLION JOINING

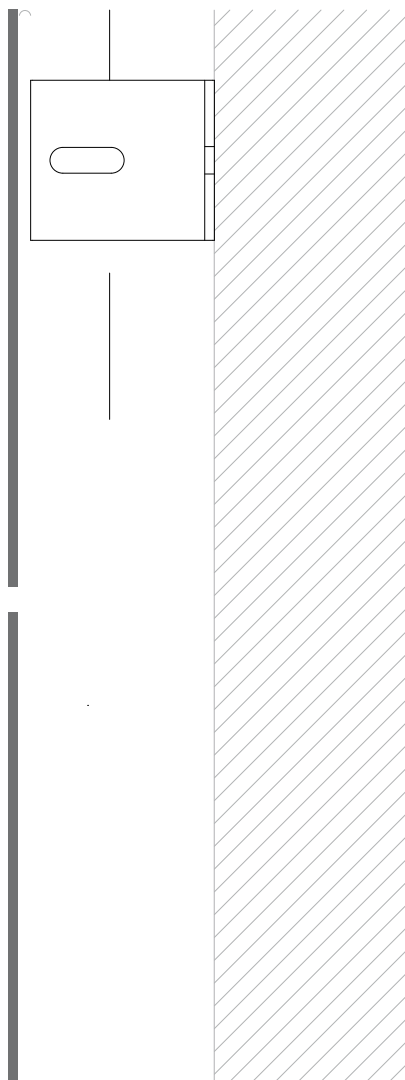
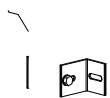
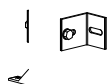
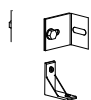


Joining mullion for joining the horizontal grooved tube to the vertical.

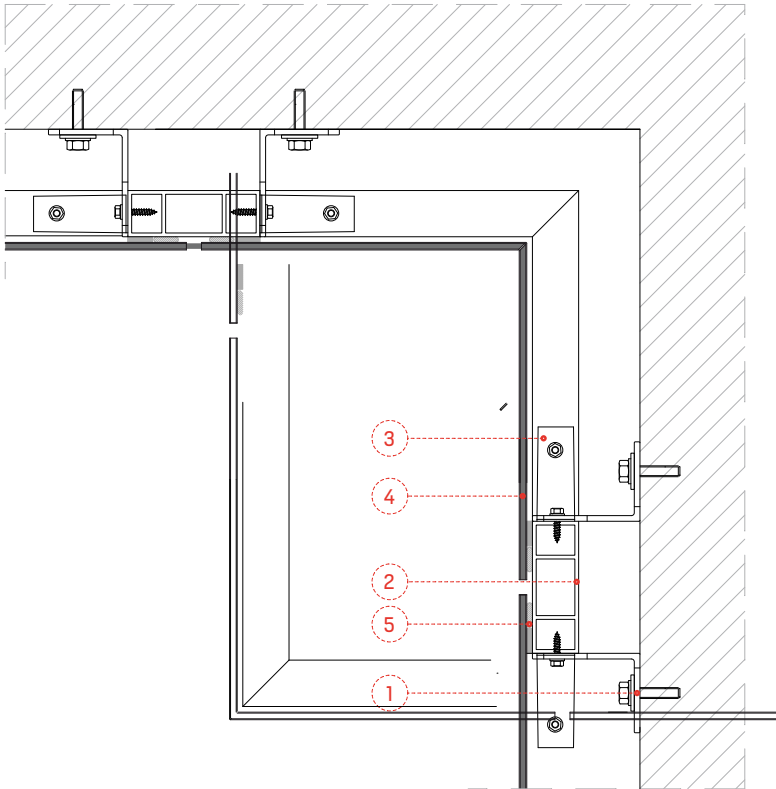
GLUED MULLION JOINING



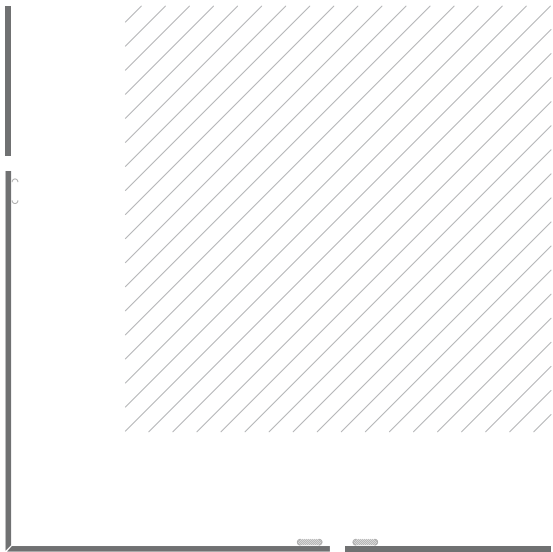
REFERENCE	DESCRIPTION	PRESENTATION
05.19.024	SCP-3 GLUED MULLION JOINING	100



INSIDE CORNER ROUNDING OFF
HORIZONTAL SECTION



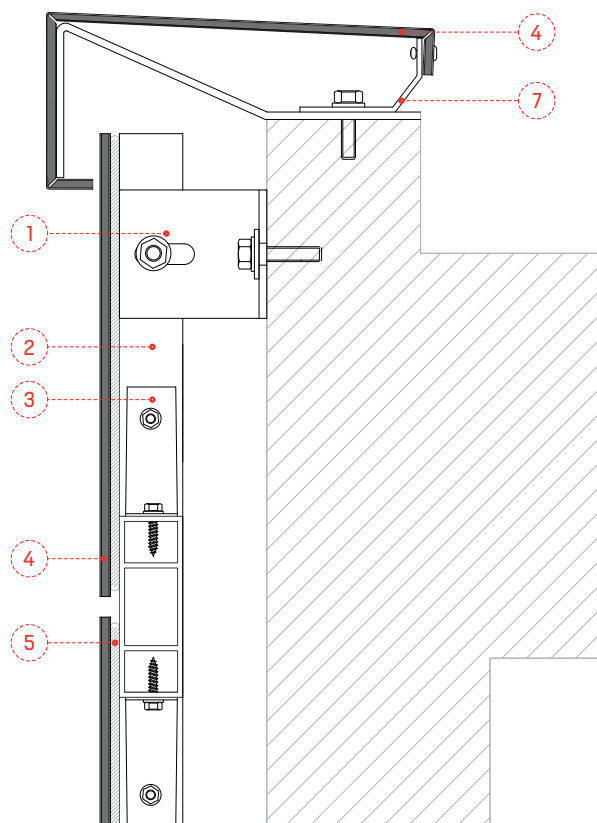
CORNER ROUNDING OFF
HORIZONTAL SECTION



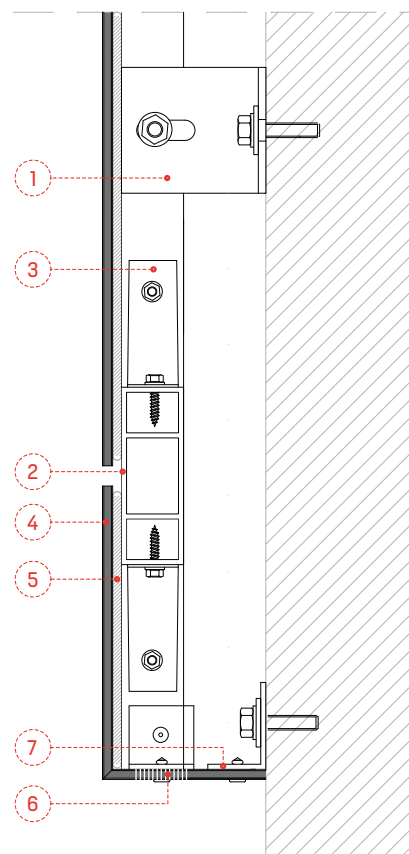
Nº	DESIGNATION	REFERENCE
1	Angular	05.19.021
2	Glued mullion	05.19.022
3	Glued mullions joint	05.19.024
4	STACBOND composite panel	
5	Specific adhesive	Not supplied by STAC

TECHNICAL DIAGRAMS SYSTEM **STB-GLUED**

CORONATION ROUNDING OFF



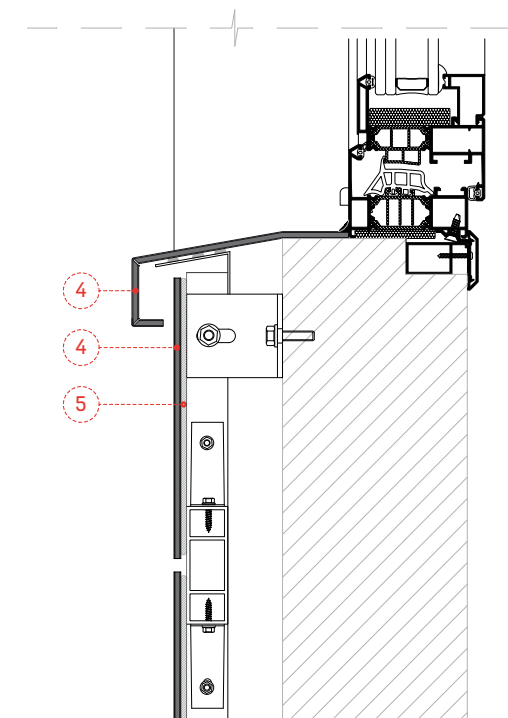
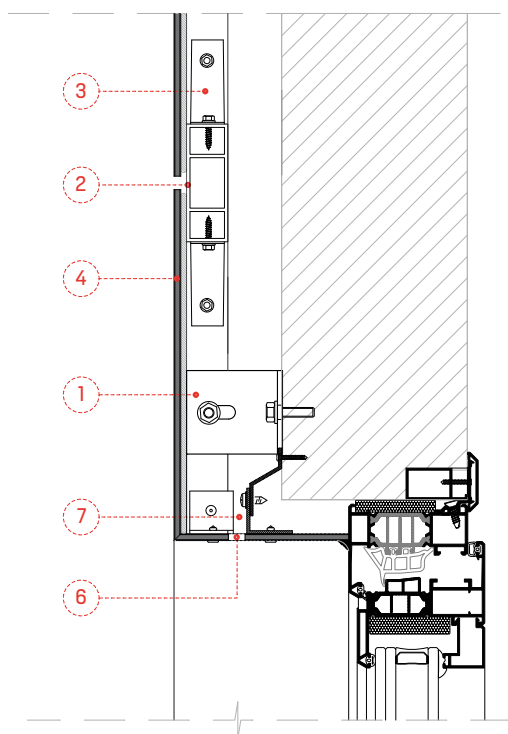
LOWER ROUNDING OFF VERTICAL SECTION



Nº	DESIGNATION	REFERENCE
1	Angular	05.19.021
2	Glued mullion	05.19.022
3	Glued mullions joint	05.19.024
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC
6	Ventilation perforations	
7	Auxilliary profile	Not supplied by STAC

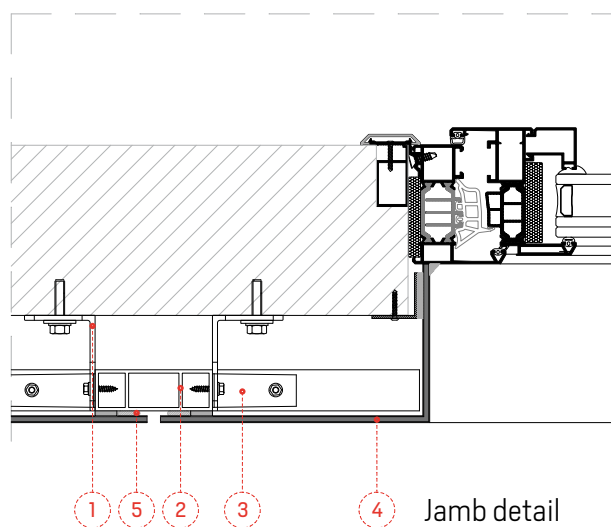
TECHNICAL DIAGRAMS SYSTEM **STB-GLUED**

WINDOW ROUNDING OFF
VERTICAL SECTION



Lintel detail

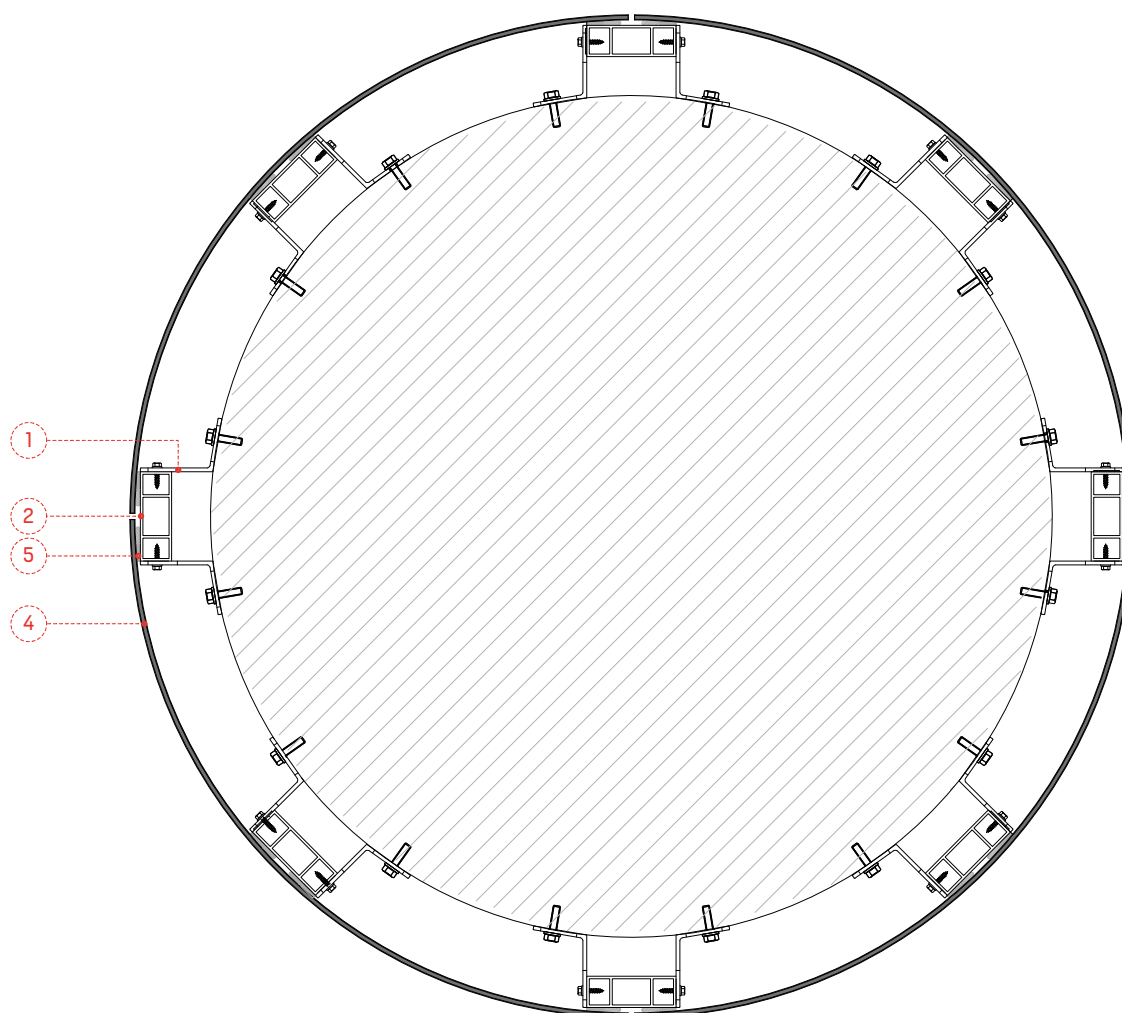
WINDOW ROUNDING OFF
HORIZONTAL SECTION



Nº	DESIGNATION	REFERENCE
1	Angular	05.19.021
2	Glued mullion	05.19.022
3	Glued mullions joint	05.19.024
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC
6	Ventilation perforations	
7	Auxilliary profile	Not supplied by STAC

Water flow detail

CIRCULAR ROUNDING OFF HORIZONTAL SECTION



Nº	DESIGNATION	REFERENCE
1	Angular	05.19.021
2	Glued mullion	05.19.022
3	Glued mullions joint	05.19.024
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC
6	Ventilation perforations	
7	Auxilliary profile	Not supplied by STAC

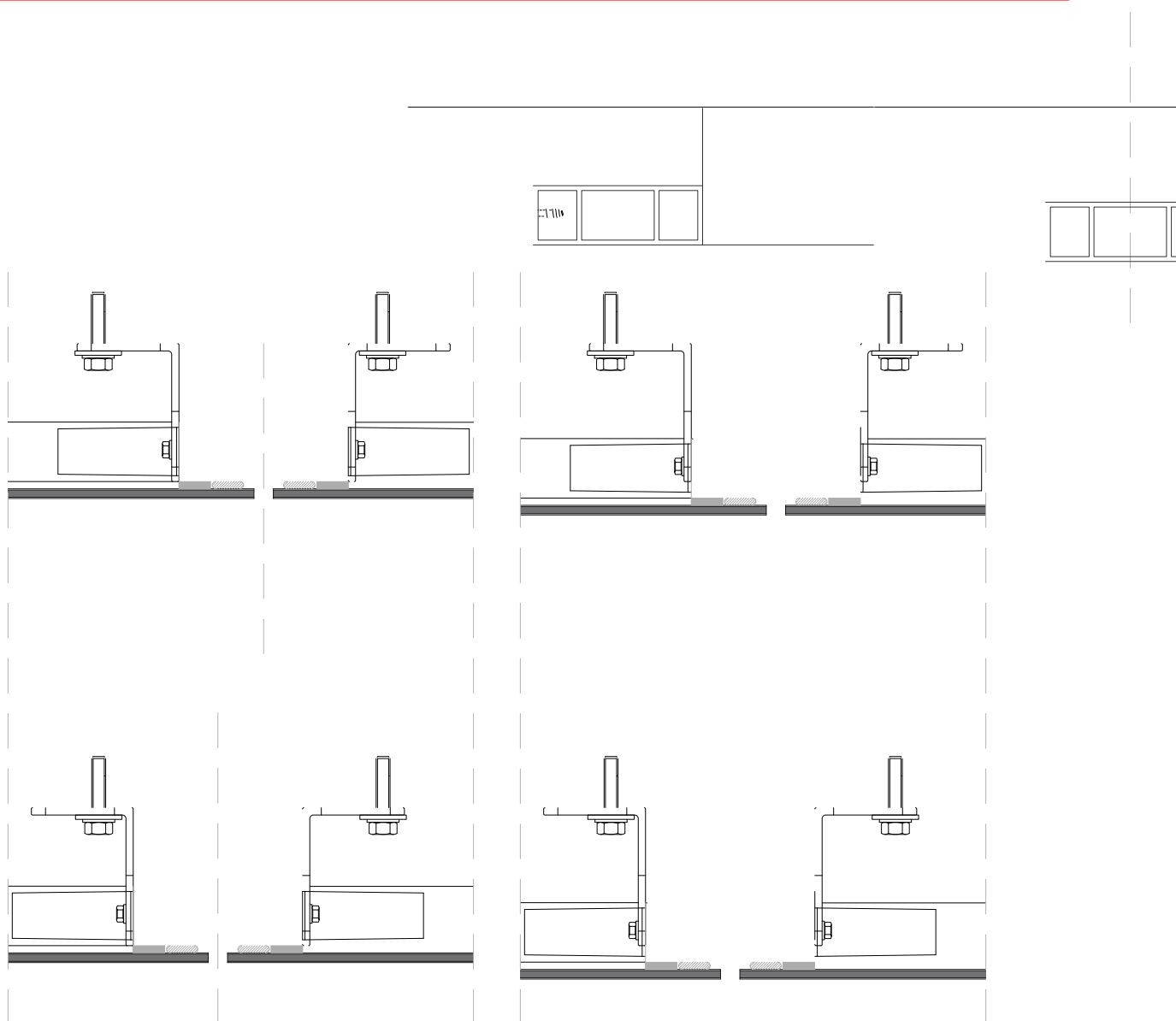
Minium radii:

Without folds: 150 mm

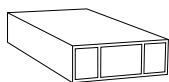
With 20 mm folds

in the curved edges: 500 mm
(only one fold per edge).

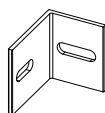
TECHNICAL DIAGRAMS SYSTEM **STB-GLUED**



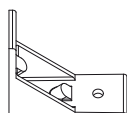
ACCESSORIES SYSTEM **STB-GLUED**



REFERENCE	PART	ALLOY	UNITS/BOX
19.022	SCP-2 GLUED MULLION	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
19.021	SC1-59 ANGULAR FIXING	6063 T5	100



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.024	SCP-3 GLUED MULLION JOINING	ZAMAK 5	100



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ASSEMBLY SYSTEM **STB-T**

The **STB-T SYSTEM** was conceived to attend to our Clients needs and the continuous interaction of **STACBOND®** with the construction job.

The continual prescence of our technical department with regard to consultations with our clients at ground level, generates the search of new assembly systems that satisfy the real needs of the job.

The **STB-T SYSTEM** is optimum for assembling the SZ trays, riveted panels and glued panels.

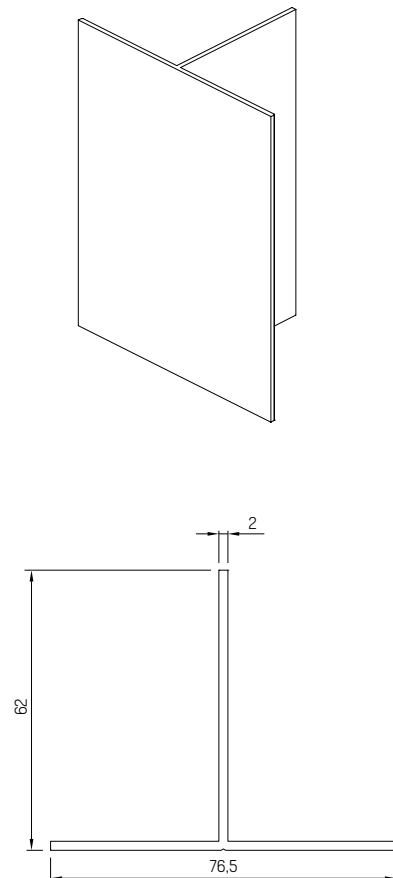
The system is comprised of façade spacers made from foldable aluminium sheet ref. ST-1 & ST-2 and T shaped extruded 6063 T5 aluminium mullions ref. ST-3.

Each façade spacer generates an adjustment of 24 mm. The spacers are fixed to the vertical parameter and recieve the T shaped vertical mullions. To join the the T mullions the ST-2 spacer is used which allows for mullion expansión and leaving a 10 mm distance between the T mullions and the ST-1 spacer is used for the rest of the positions.

The ST-1 & ST-2 spacers have some flanges so that the T can be fitted and retained without screws until the mullion plumb lines can be regulated so that afterwards they can be screwd to the spacer in its final position.

To join the spacer to the omega, screw references 5.5X22 stainless A2 screws with assembled epdm Ø.16 (SFS SN5/12 DIN 7504 K) washers. In the support spacers, the fixed point of the spacer is to be used and in the retaining spacers the expansion buttonhole is to be used.

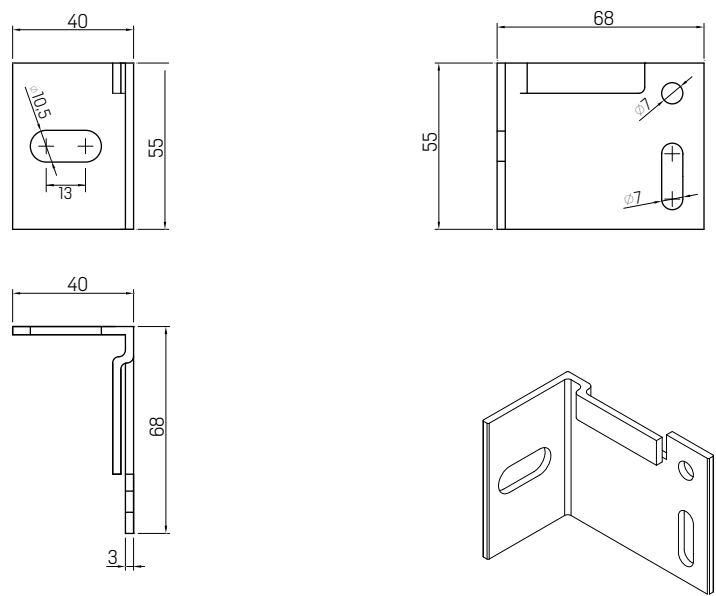
T PROFILE



REFERENCE	DESCRIPTION	PRESENTATION
05.19.043	ST-3 T MULLION PROFILE	-

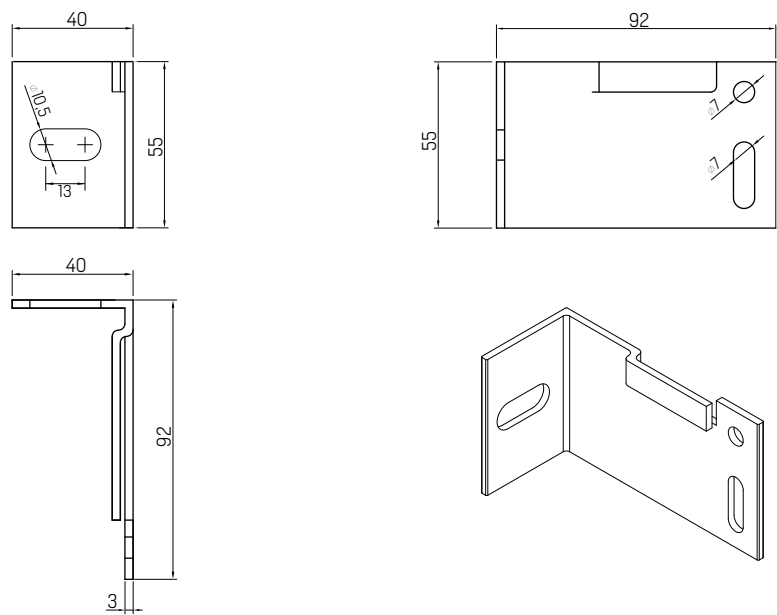
SUBSTRUCTURE ELEMENTS **STB-T** SYSTEM

ST-1 -68 L SPACER



REFERENCE	DESCRIPTION	PRESENTATION
05.19.041	ST-1-68 L SPACER	-

ST-1 -92 L SPACER

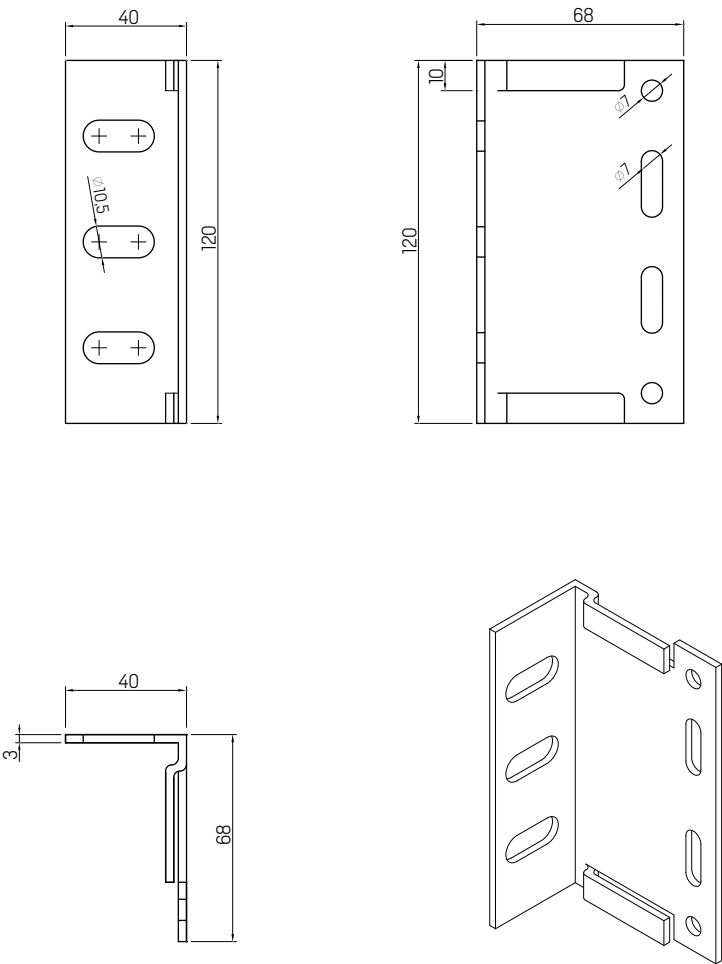


REFERENCE	DESCRIPTION	PRESENTATION
05.19.044	ST-1-92 L SPACER	-



SUBSTRUCTURE ELEMENTS **STB-T** SYSTEM

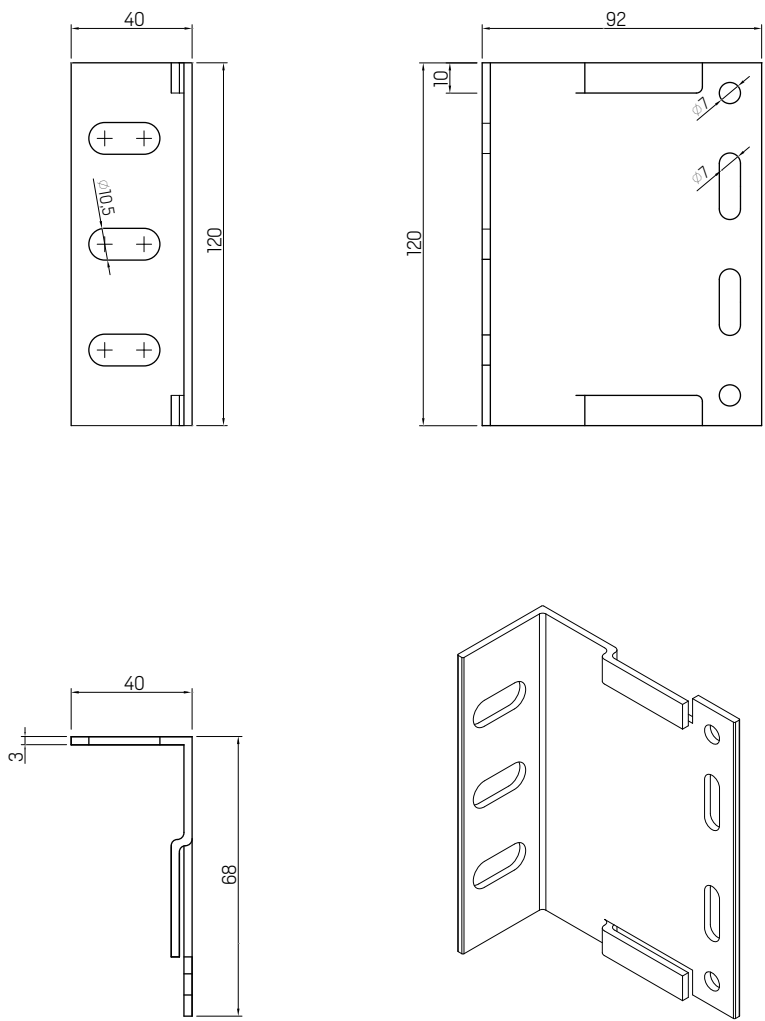
ST-2-68 L SPACER



REFERENCE	DESCRIPTION	PRESENTATION
05.19.042	ST-1-68 L SPACER	-

SUBSTRUCTURE ELEMENTS **STB-T** SYSTEM

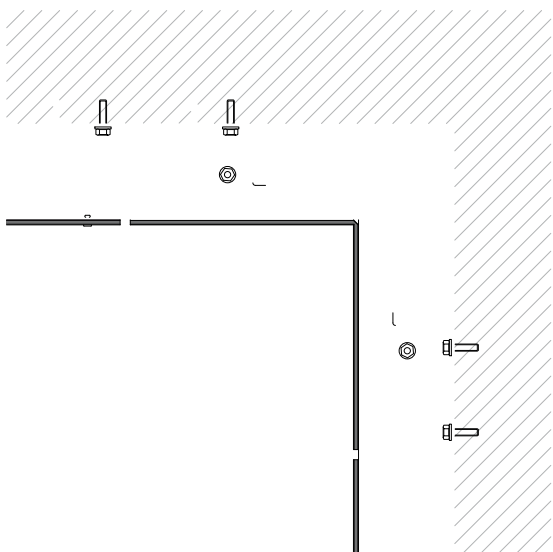
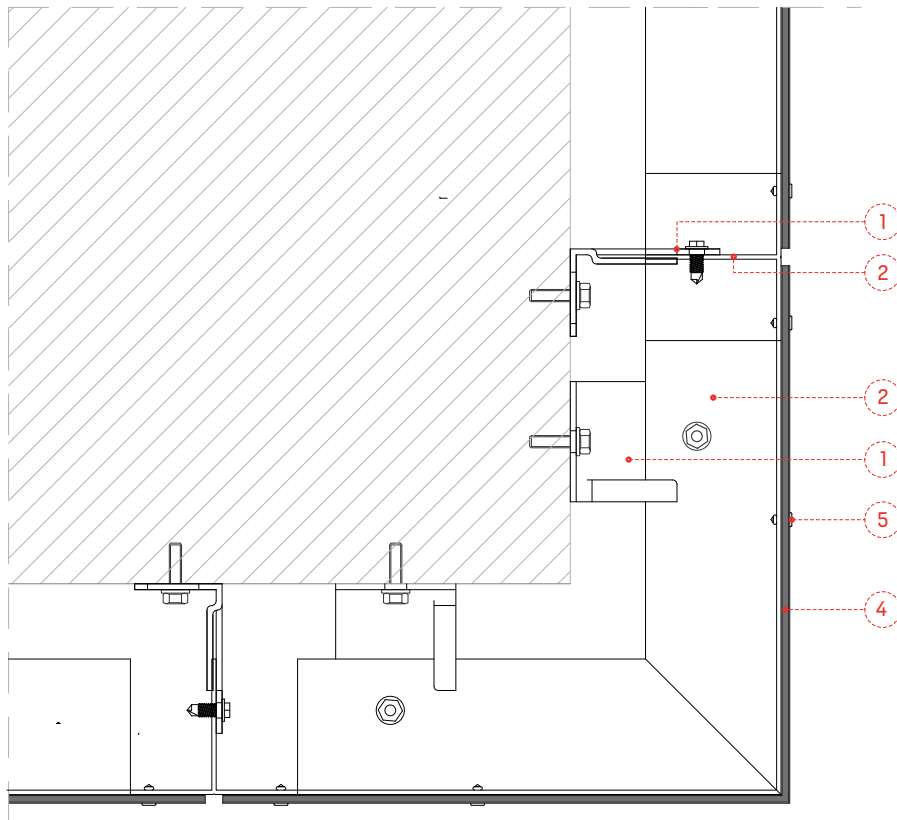
ST-2-92 L SPACER



REFERENCE	DESCRIPTION	PRESENTATION
05.19.045	ST-1-68 L SPACER	-

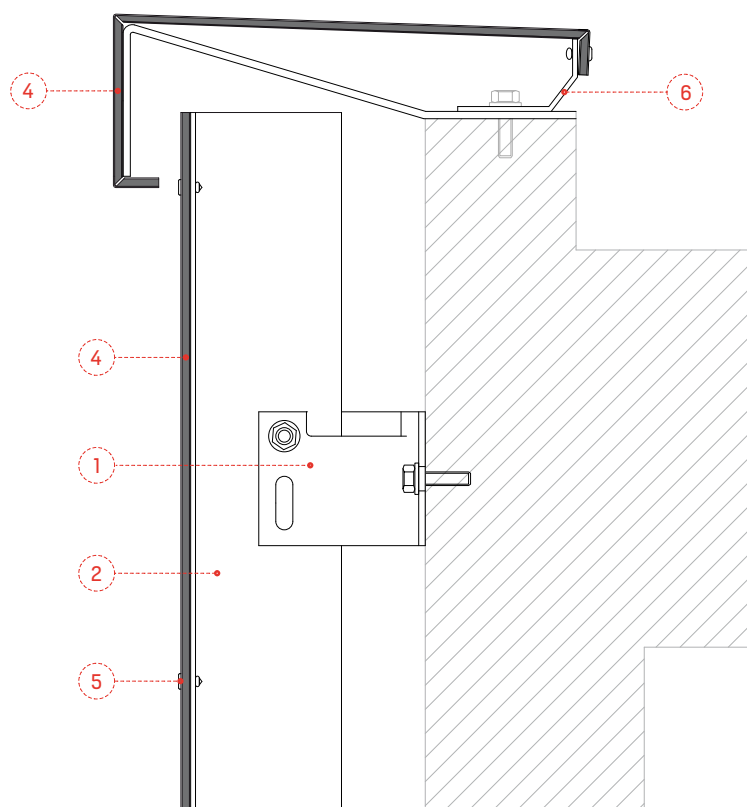


TECHNICAL DIAGRAMS SYSTEM **STB-T RIVETED**

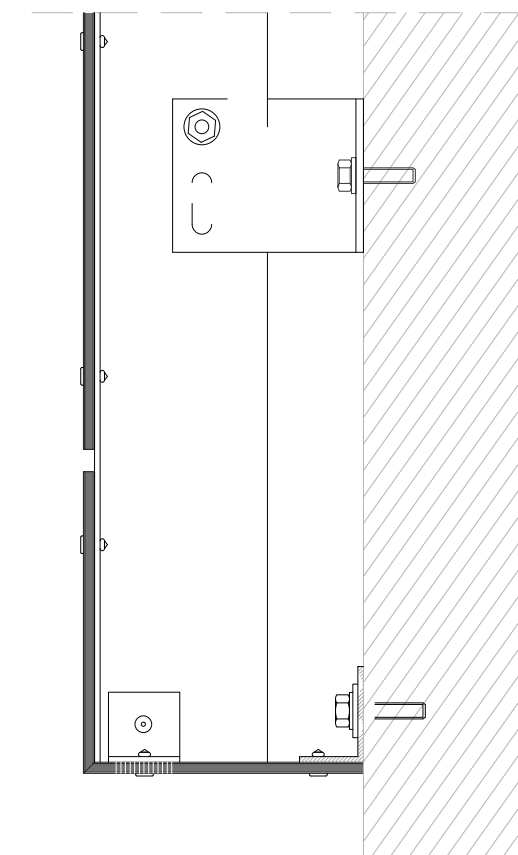


TECHNICAL DIAGRAMS SYSTEM **STB-T RIVETED**

CORONATION ROUNDING OFF



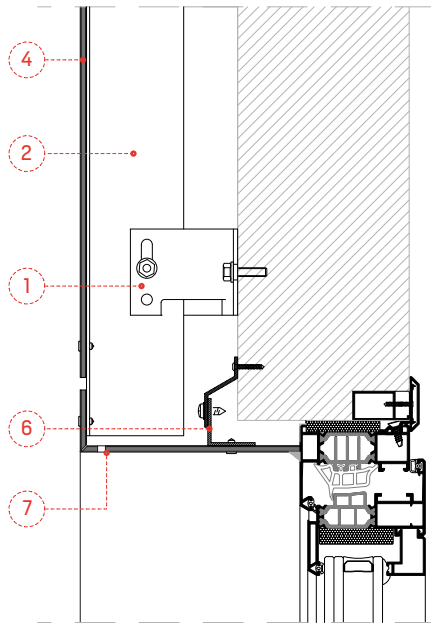
LOWER ROUNDING OFF
VERTICAL SECTION



Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	ST-2 L Spacer	05.19.042
4	STACBOND composite panel	-
5	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head 14 mm	STB-R0100
6	Auxilliary profile	Not supplied by STAC
7	Ventilation perforations	

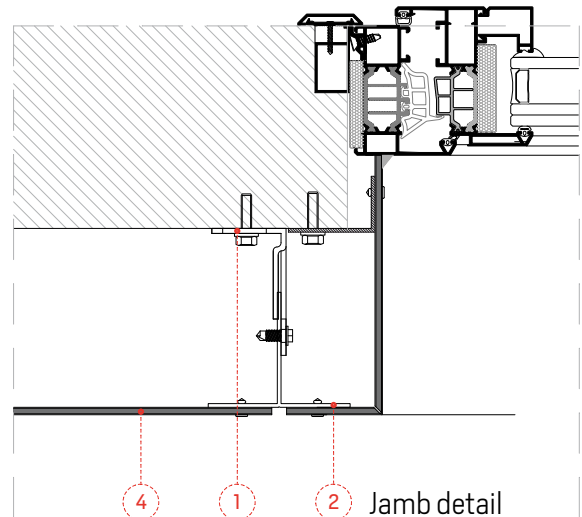
TECHNICAL DIAGRAMS SYSTEM **STB-T RIVETED**

WINDOW ROUNDING OFF
VERTICAL SECTION

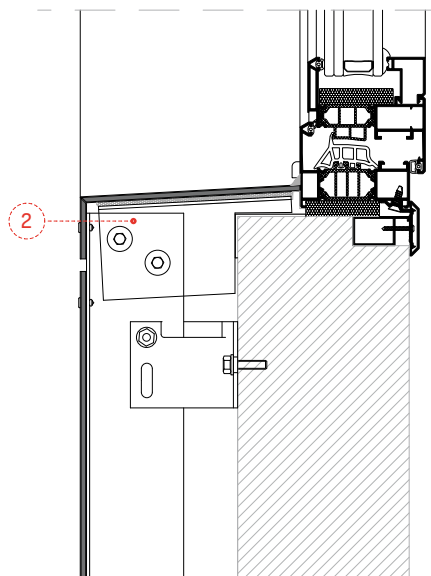


Lintel detail

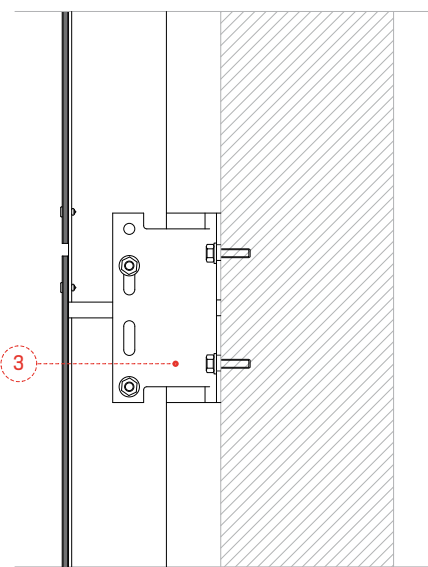
WINDOW ROUNDING OFF
HORIZONTAL SECTION



VERTICAL SECTION



Water flow detail



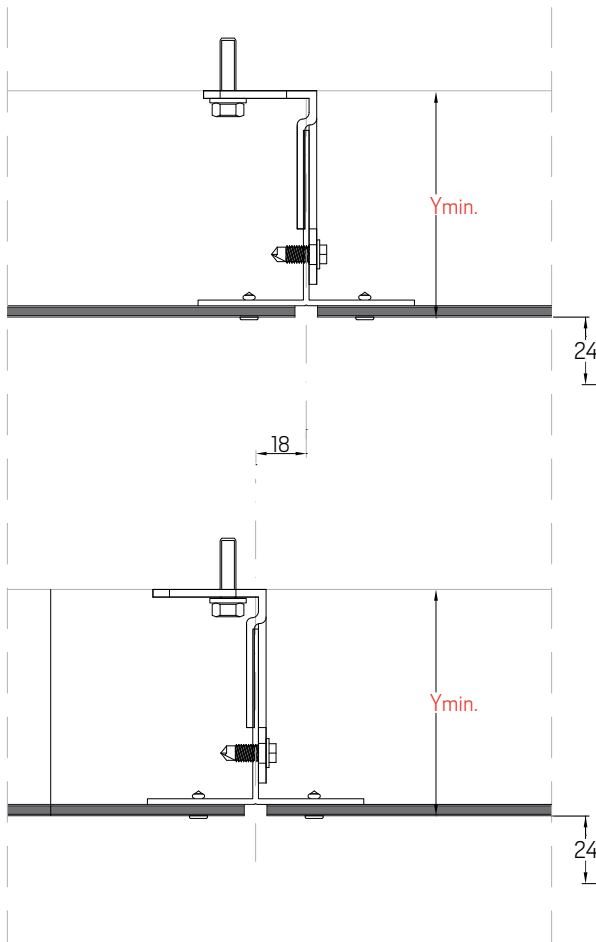
Mullions joint

Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	ST-2 L Spacer	05.19.042
4	STACBOND composite panel	-
5	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head 14 mm	STB-R0100
6	Auxilliary profile	Not supplied by STAC
7	Ventilation perforations	

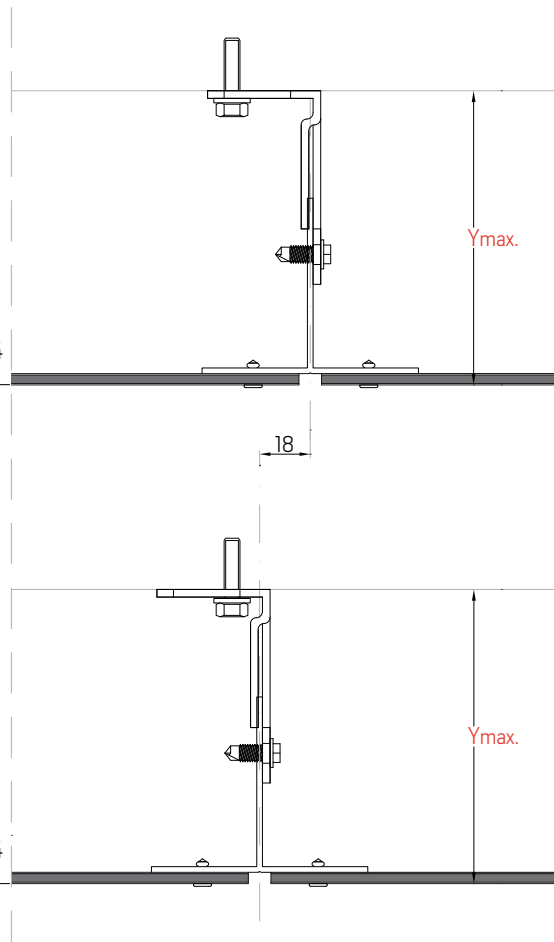
TECHNICAL DIAGRAMS SYSTEM **STB-T RIVETED**

SCREW ADJUSTMENT AT THE BOTTOM OF THE FIXING

L SPACER BASE ON X AXIS



L SPACER FLANGER ON Y AXIS

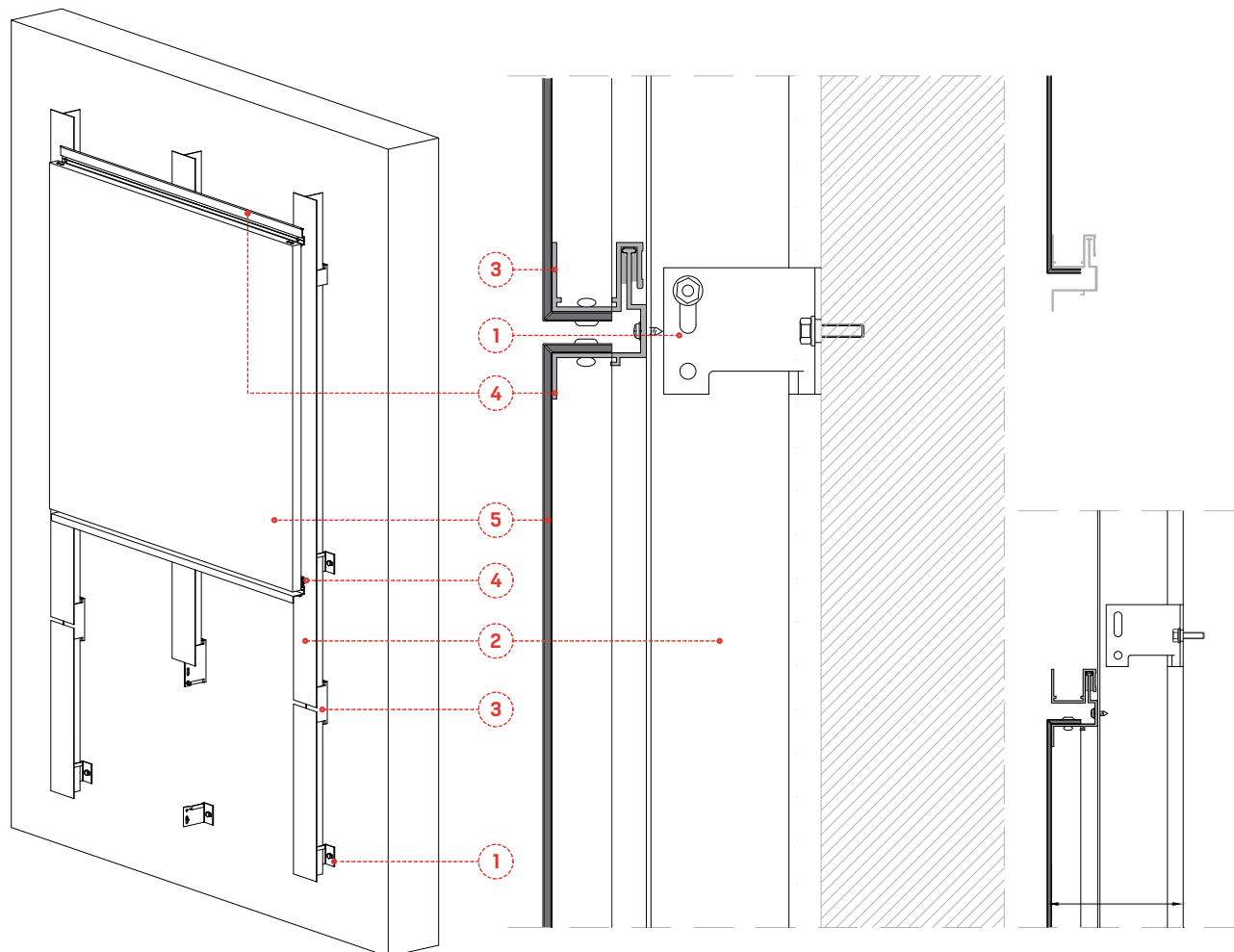


REFERENCE	DESCRIPTION	ADJUSTMENT MIN. (Y) STACBOND panel seen face	ADJUSTMENT MAX. (Y) STACBOND panel seen face
ST-1-68	ST-1-68 FIXING	80	104
ST-2-92	ST-1-92 FIXING	104	128
ST-2-68	ST-2-68 FIXING	80	104
ST-2-92	ST-2-92 FIXING	104	128

Adjustments in the axis and by fixing in mm.

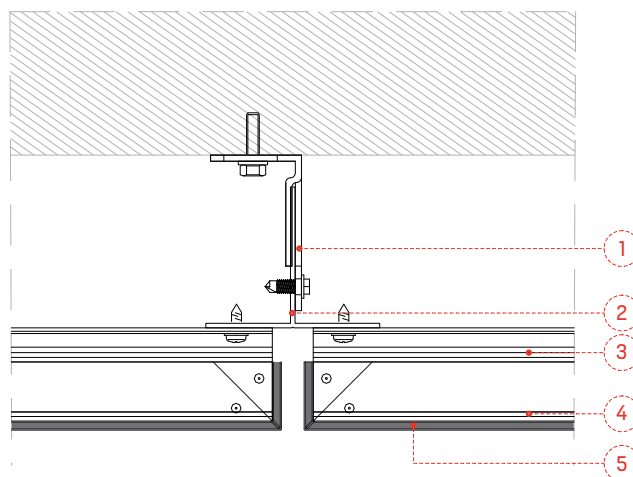
ASSEMBLY DIAGRAM SYSTEM **STB-T SZ**

VERTICAL SECTION



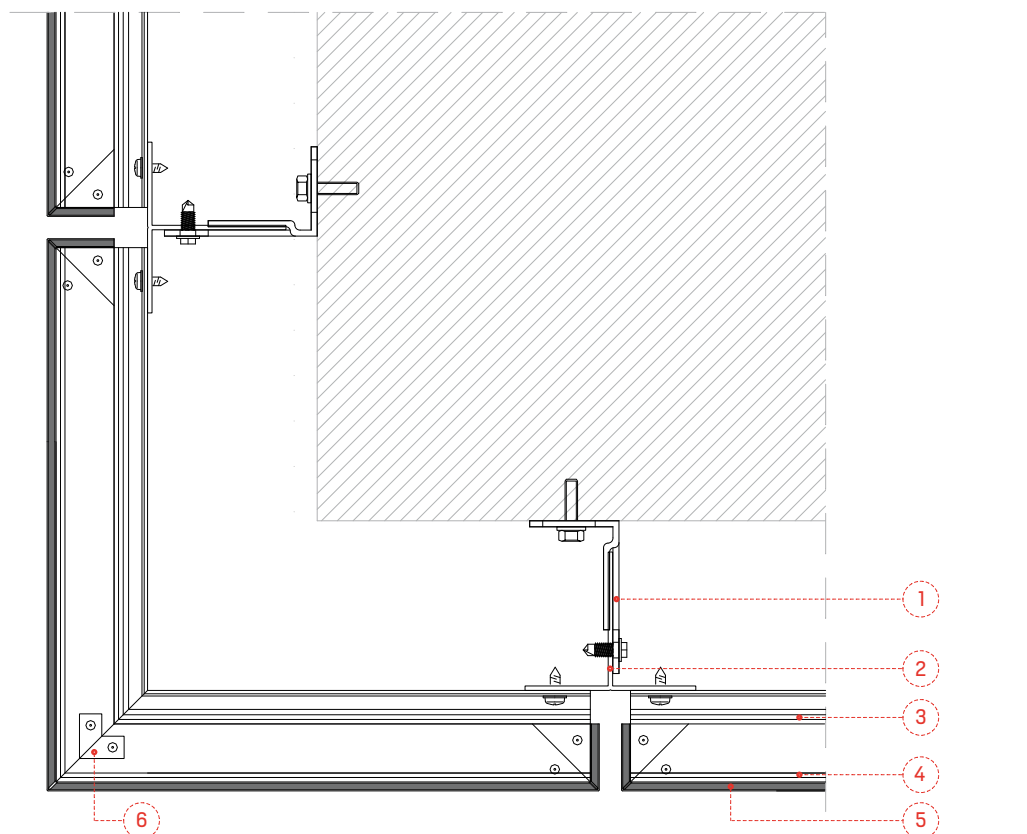
HORIZONTAL SECTION

Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	S profile	05.19.001
4	Z profile	05.19.002
5	STACBOND composite panel	-

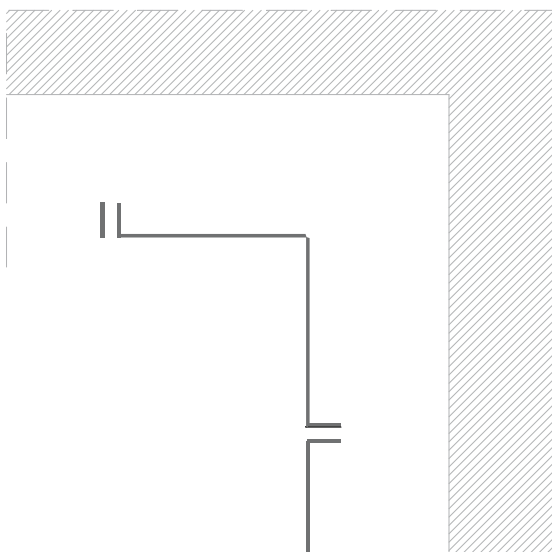


ASSEMBLY DIAGRAM SYSTEM **STB-T SZ**

CORNER ROUNDING OFF HORIZONTAL SECTION



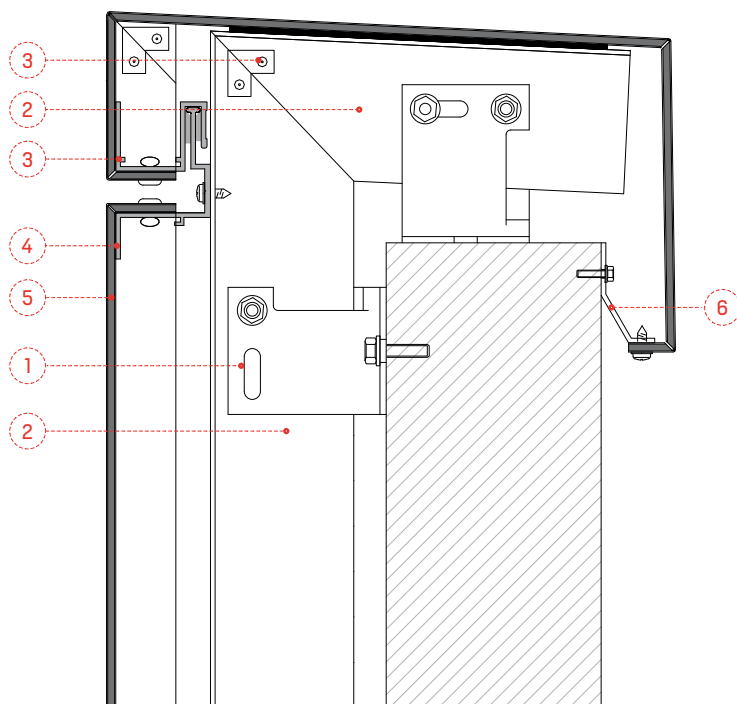
INSIDE CORNER ROUNDING OFF HORIZONTAL SECTION



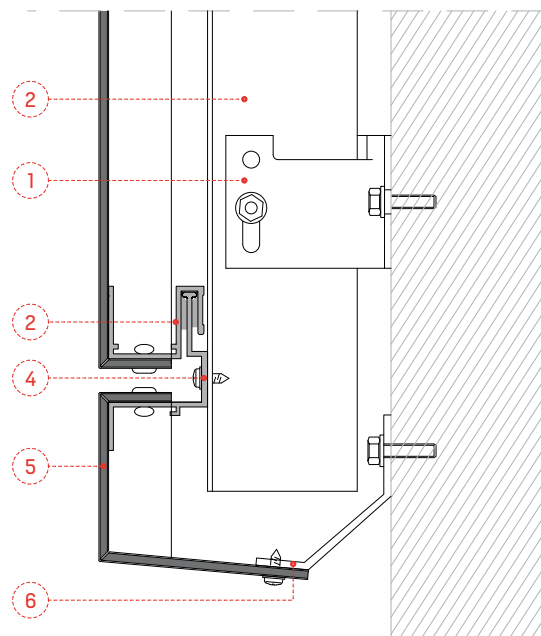
Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	S profile	05.19.001
4	Z profile	05.19.002
5	STACBOND composite panel	-

ASSEMBLY DIAGRAM SYSTEM **STB-T SZ**

CORONATION ROUNDING OFF



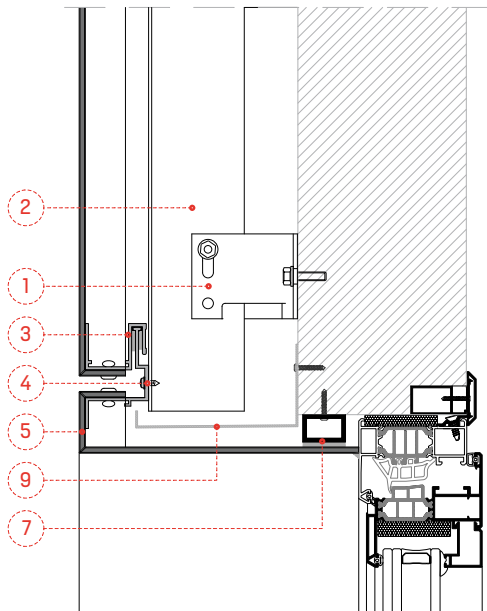
LOWER ROUNDING OFF
VERTICAL SECTION



Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	S profile	05.19.001
4	Z profile	05.19.002
5	STACBOND composite panel	-
6	Aluminium rounding off for fixing	Not supplied by STAC
7	Ventilation perforations	
8	Adapted Z profile	05.19.002
9	Evacuation apron	Not supplied by STAC
10	ST-2 spacer	05.19.042

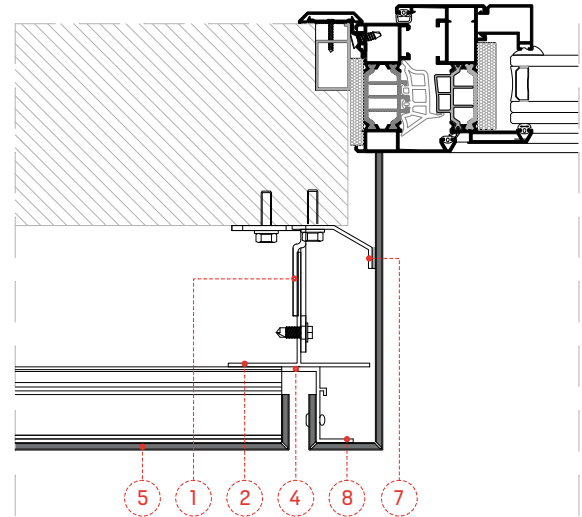
ASSEMBLY DIAGRAM SYSTEM **STB-T SZ**

WINDOW ROUNDING OFF
VERTICAL SECTION



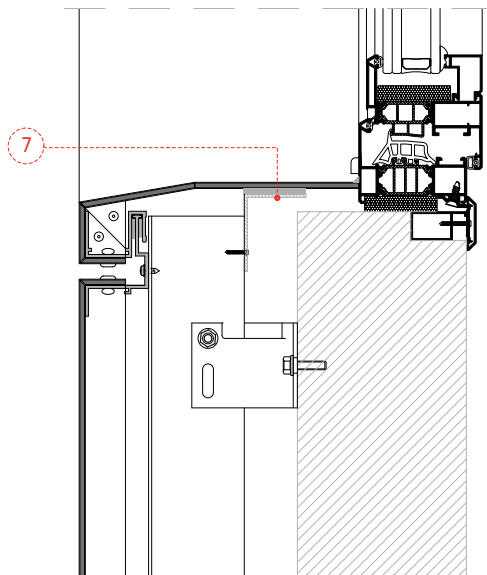
Lintel detail

WINDOW ROUNDING OFF
HORIZONTAL SECTION

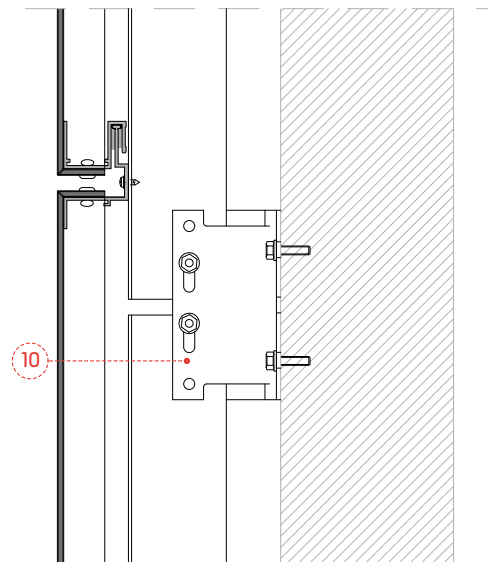


Jamb detail

VERTICAL SECTION



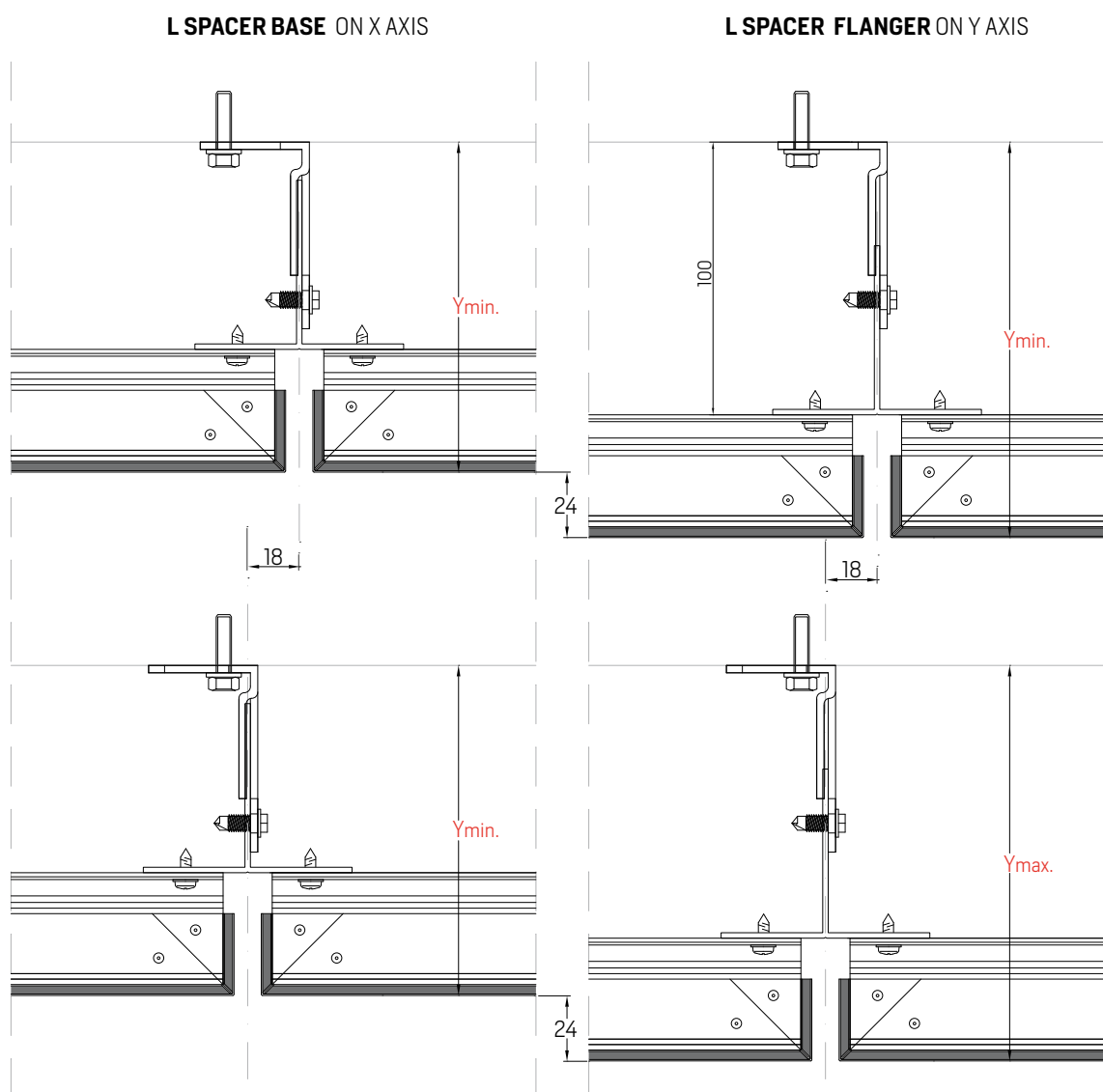
Water flow detail



Mullions joint

ASSEMBLY DIAGRAM SYSTEM **STB-T SZ**

SCREW ADJUSTMENT AT THE BOTTOM OF THE FIXING

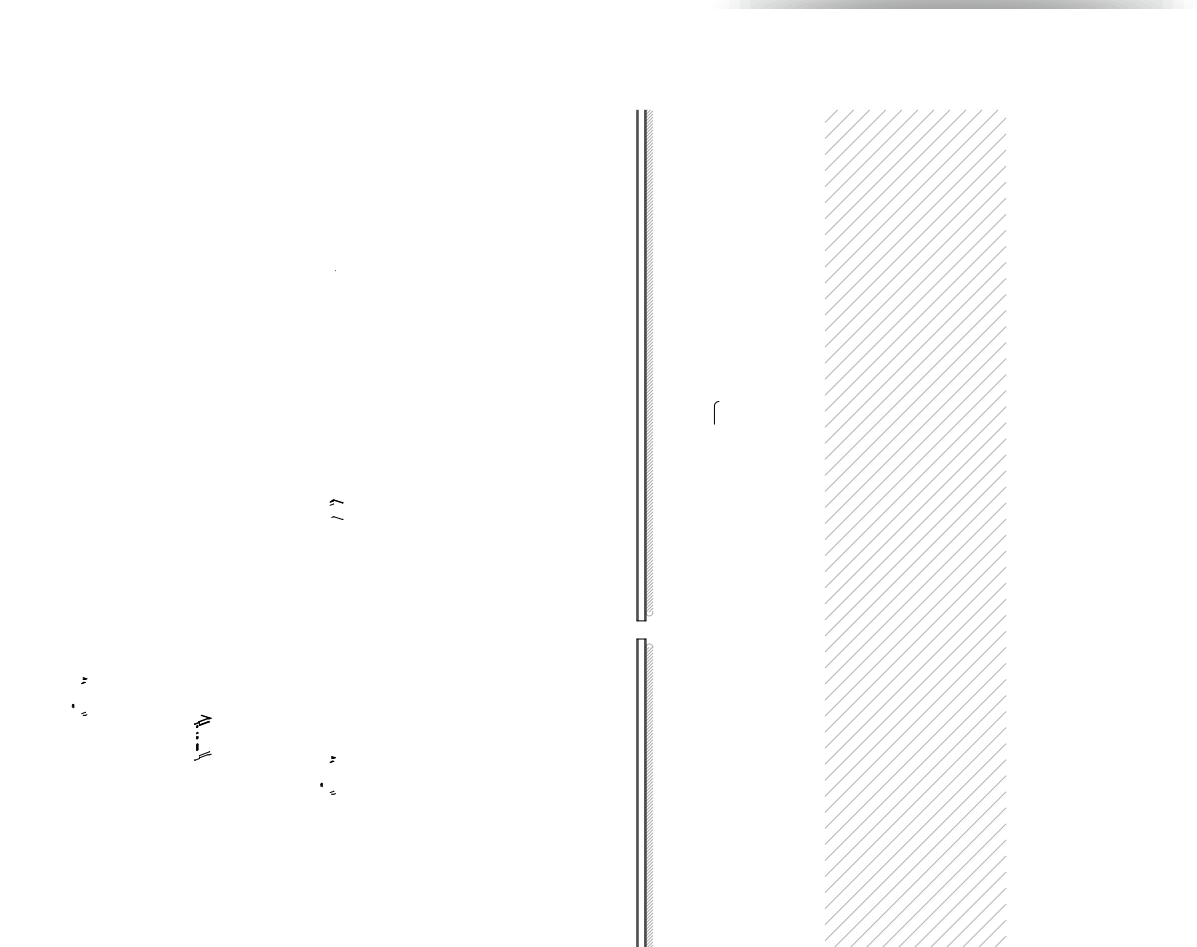


REFERENCE	DESCRIPTION	ADJUSTMENT MIN. (Y) STACBOND panel seen face	ADJUSTMENT MAX. (Y) STACBOND panel seen face
ST-1-68	ST-1-68 FIXING	121	145
ST-2-92	ST-1-92 FIXING	145	169
ST-2-68	ST-2-68 FIXING	121	145
ST-2-92	ST-2-92 FIXING	145	169

Adjustments in the axis and by fixing in mm.

ASSEMBLY DIAGRAM SYSTEM **STB-T GLUED**

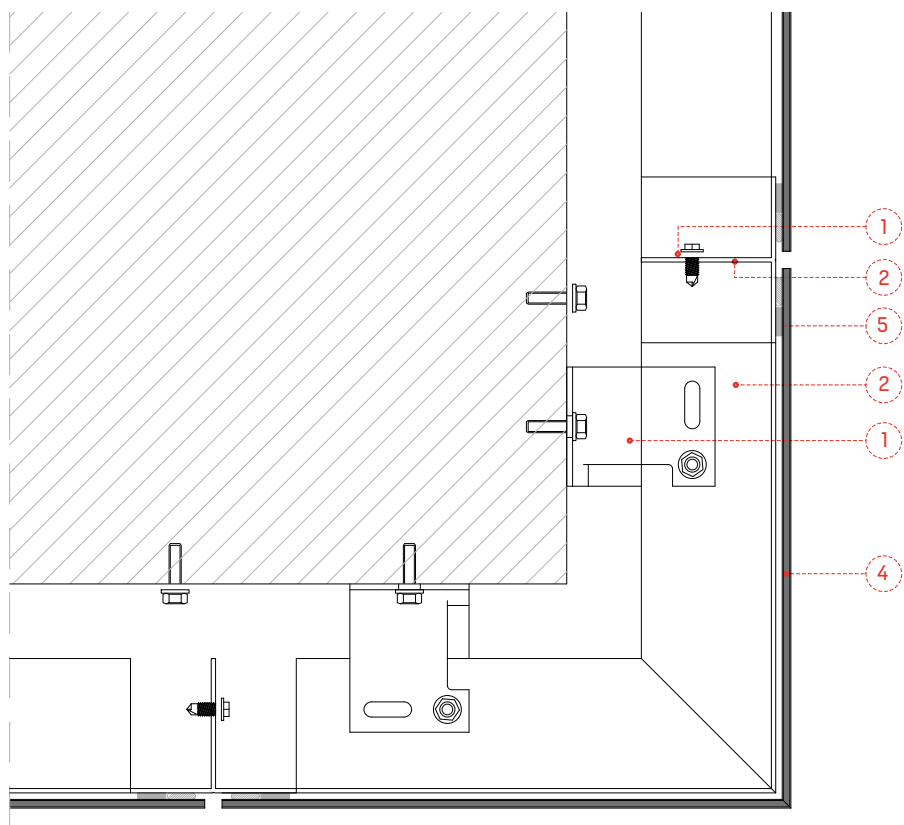
VERTICAL SECTION



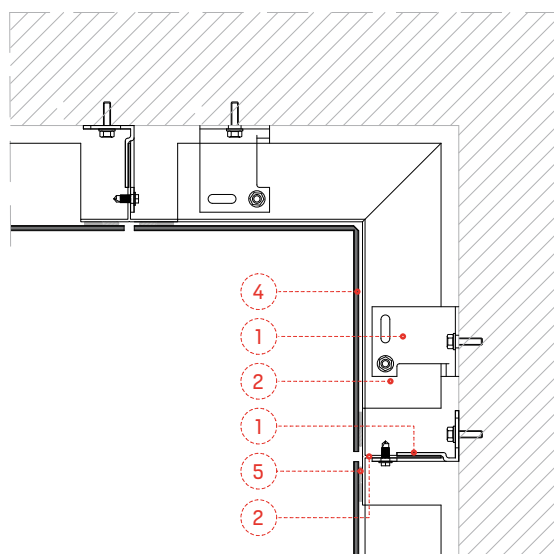
Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	ST-2 L Spacer	05.19.042
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC

ASSEMBLY DIAGRAM SYSTEM **STB-T GLUED**

CORNER ROUNDING OFF HORIZONTAL SECTION



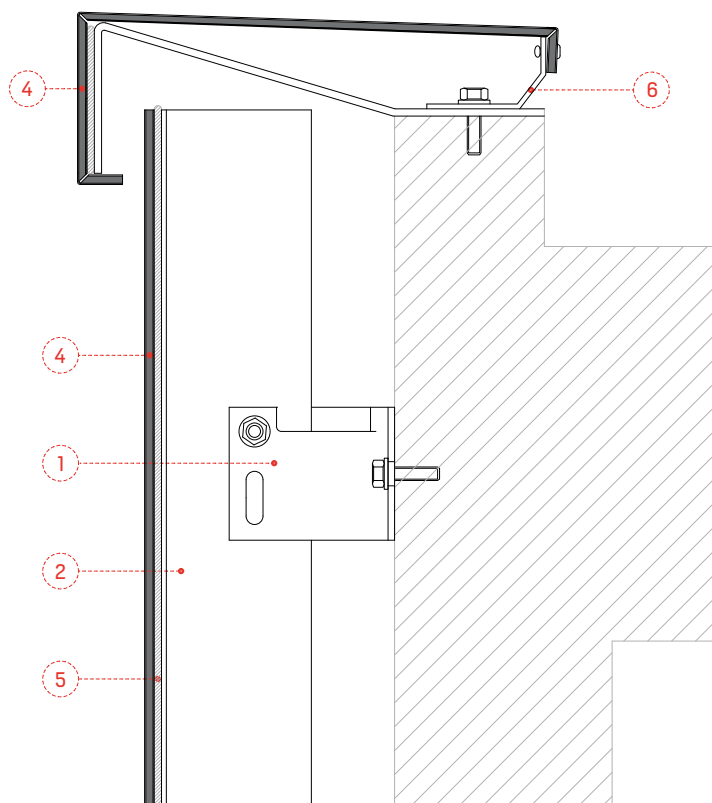
INSIDE CORNER ROUNDING OFF HORIZONTAL SECTION



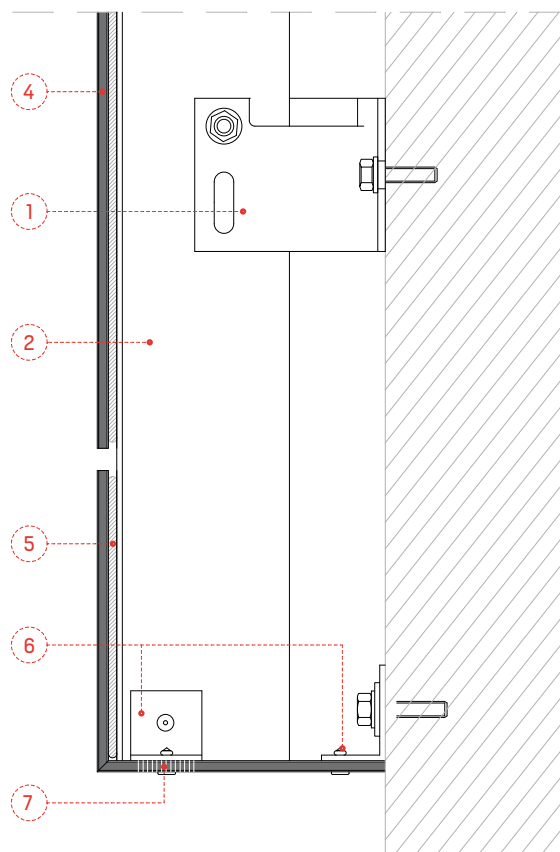
N°	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	ST-2 L Spacer	05.19.042
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC

ASSEMBLY DIAGRAM SYSTEM **STB-T GLUED**

CORONATION ROUNDING OFF



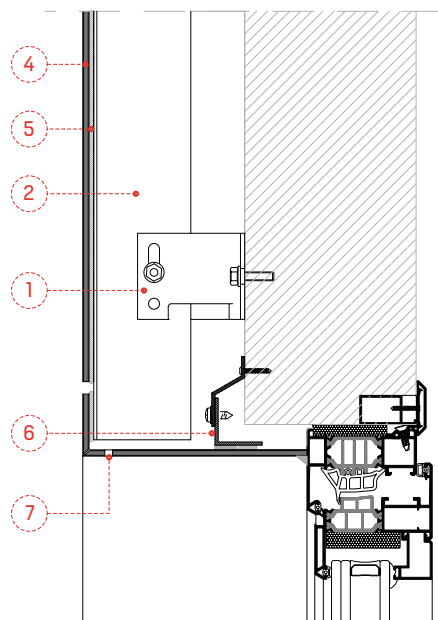
LOWER ROUNDING OFF
VERTICAL SECTION



Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	ST-2 L Spacer	05.19.042
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC
6	Auxilliary profile	Not supplied by STAC
7	Ventilation perforations	

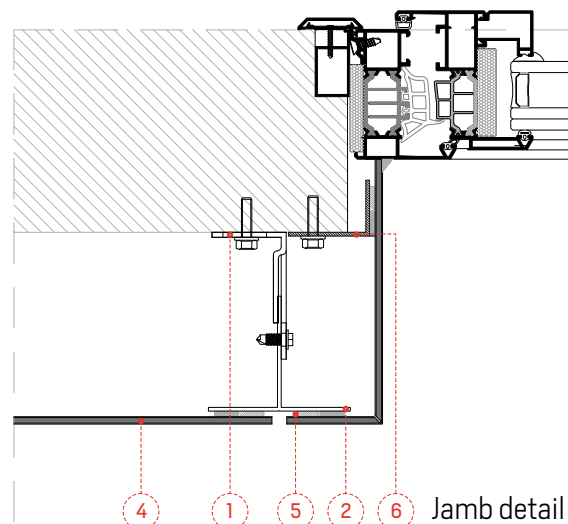
ASSEMBLY DIAGRAM SYSTEM **STB-T GLUED**

WINDOW ROUNDING OFF
VERTICAL SECTION

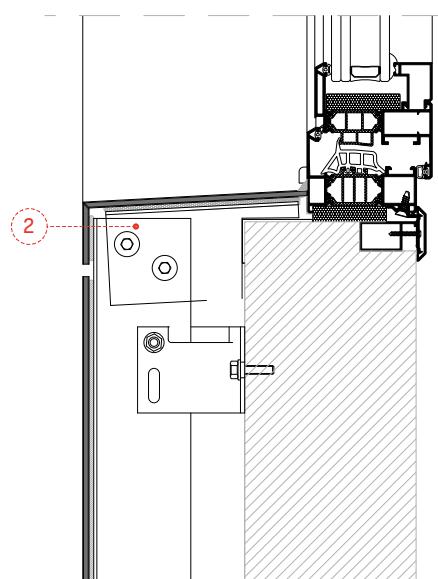


Lintel detail

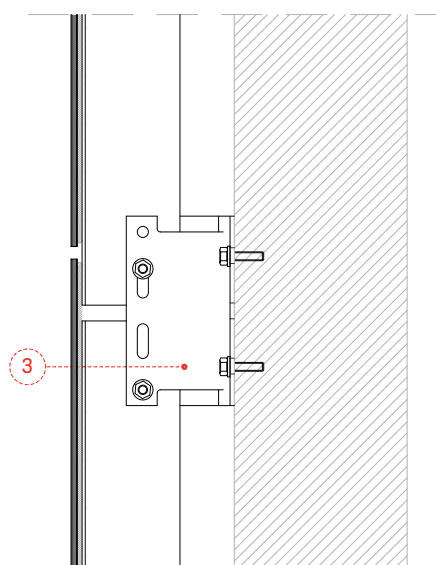
WINDOW ROUNDING OFF
HORIZONTAL SECTION



VERTICAL SECTION



Water flow detail



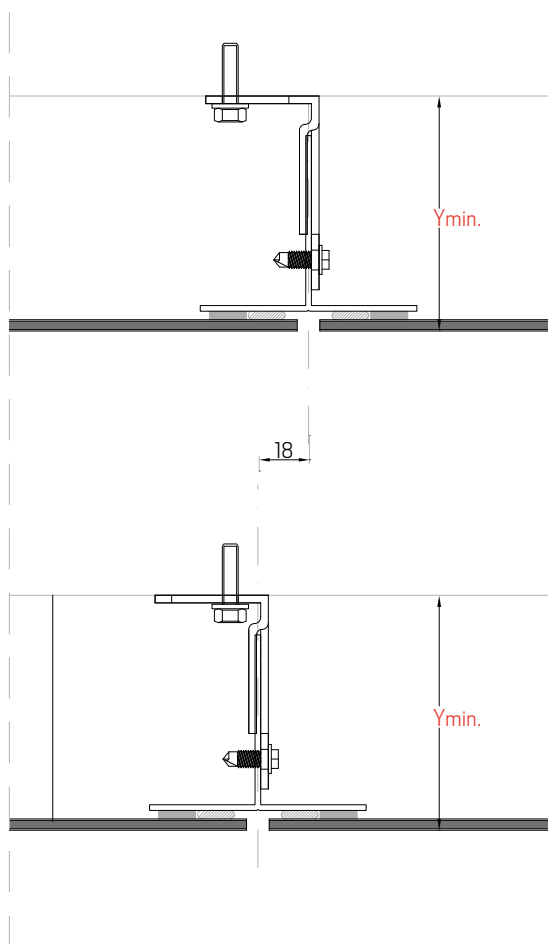
Mullions joint

Nº	DESIGNATION	REFERENCE
1	ST-1 L Spacer	05.19.041
2	T Mullion profile	05.19.043
3	ST-2 L Spacer	05.19.042
4	STACBOND composite panel	-
5	Specific adhesive	Not supplied by STAC
6	Auxilliary profile	Not supplied by STAC
7	Ventilation perforations	

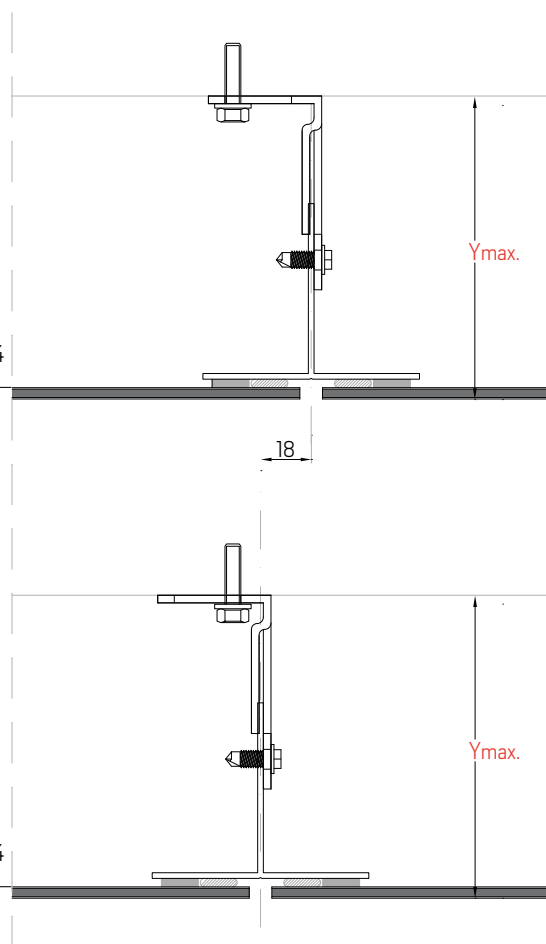
ASSEMBLY DIAGRAM SYSTEM **STB-T GLUED**

SCREW ADJUSTMENT AT THE BOTTOM OF THE FIXING

L SPACER BASE ON X AXIS



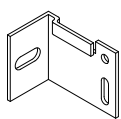
L SPACER FLANGER ON Y AXIS



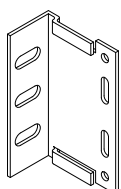
REFERENCE	DESCRIPTION	ADJUSTMENT MIN. (Y) STACBOND panel seen face	ADJUSTMENT MAX. (Y) STACBOND panel seen face
ST-1-68	ST-1-68 FIXING	83	107
ST-2-92	ST-1-92 FIXING	109	131
ST-2-68	ST-2-68 FIXING	83	107
ST-2-92	ST-2-92 FIXING	107	131

Adjustments in the axis and by fixing in mm.

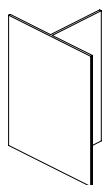
ACCESSORIES SYSTEM **STB-T**



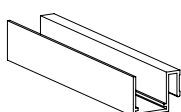
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.041	ST-1-68 L SPACER		
05.19.044	ST-1- 92 L SPACER		



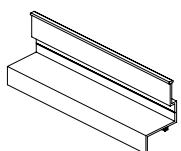
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.042	ST-2-68 L SPACER		
05.19.045	ST-2- 92 L SPACER		



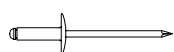
REFERENCE	PART	ALLOY	UNITS/BOX
05.19.042	ST-3 T MULLION PROFILE	6063 T5	



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.001	SC-S "S" PROFILE	6063 T5	-



REFERENCE	PART	ALLOY	UNITS/BOX
05.19.002	SC-Z "Z" PROFILE	6063 T5	-



REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Blind rivet iso 15977 D.5x12 Al/stainless SFS AP14-S-5,0x12 Head 14 mm		
STB-R0100	SFS AP14-S-5,0x12 - SIN LACAR	100	100
	SFS AP14-S-5,0x12 - LACADO CARTA RAL	250	100

APPLICATION: for the fixing of **STACBOND®** façade panels over a metallic STB-T RIVETED substructure

ACCESSORIES SYSTEM **STB-T**

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Façade rivet - 15 mm head. Inox/Inox A4 5x14		
STB-R0200	SSO-D15-50140 - NOT PAINTED	100	100
	SSO-D15-50140 - PAINTED - RAL CHART	250	100

APPLICATION: for the fixing of **STACBOND®** façade panels over a metallic substructure for high exposure atmospheres to the presence of chlorides.

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Polygrip SFS ASO-D-48150 Alu/stainless 4.8x15 blind rivet		
STB-R0300	Polygrip SFS ASO-D-48150 NOT PAINTED	100	100
	Polygrip SFS ASO-D-48150 PAINTED - RAL CHART	250	100

APPLICATION: For shaping **STACBOND®** STB-T-SZ composite panel.

REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-201	Riveter nozzles for SSO-D15 rivets	Tightening limiter function for moving points	1
STB-FIJA-202	Riveter nozzles for AP rivets	Tightening limiter function for moving points	1

REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-203	Double drill bit (HSS-7,0/5,1x74)	Drill panel at 7 mm & substructure at 5,1 mm	1
STB-FIJA-204	Depth limit (Depth Locator 16x18)	Works with a double drill bit so as not to drill a 7 mm hole in the substructure	1

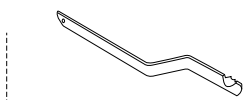
REFERENCE	PART	OBSERVATIONS	MIN. UNITS
STB-FIJA-205	Centerer (DG-146x20-7,0)	When the panels are drilled at 7 mm and we have to drill a 5.1 mm hole centred over the substructure	1
STB-FIJA-206	6.9 mm diameter centerer replacement point	It is the part A of the centerer so that there is no need to buy a complete one if it is damaged	1
STB-FIJA-207	Special drill bit for the centerer(HSS-5,1x62/26)	A drill bit with a shorter helicoidal so that it does not enter in to the centerer and jams	10

ACCESSORIES SYSTEM **STB-T**

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Screw head 4,8x19 stainless A2 torx head		
STB-T0100	SLA3/6-S-D12-4,8x19 NOT PAINTED	500	100
	SLA3/6-S-D12-4,8x19 – PAINTED RAL CHART	250	100



REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	ACCESSORIES FOR SCREWING STB-REM SCREWS		
STB-FIJA-208	POINT T20WW-25-HEX1/4"	1	1
STB-FIJA-209	Manual centerer for SLA3 screws	1	1



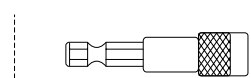
Once in, it cannot be removed.

APPLICATION: for fixing the **STACBOND®** façade panels on to a STB-RIVETED metallic substructure

REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
	Security screw 5,5x32 stainless A2 Irius security head		
STB-T0200	SX3/15-L12-S16/1-5,5x32 NOT PAINTED	500	100
	SX3/15-L12-S16/1-5,5x32 PAINTED RAL CHART	250	100



REFERENCE	PART	MIN. QUANTITY	UNITS/BOX
STB-FIJA-210	Lrius socket wrench G-00106.07	1	1



Assembled with a security socket. It can be removed with the socket

APPLICATION: For fixing the **STACBOND®** façade panels on to the STB-RIVETED metallic substructure.



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STACBOND® has a qualified technical department that is at your entire disposal for any consultation you may have.

If you have not found what you are looking for, please contact us at stacbond@stac.es **Tel.** [\(+34\) 981 817 036](tel:+34981817036). We will look for a solution that adapts to your requirements.

An online version of this brochure is available in pdf format to download and consult and can be found in the download section on our website.

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