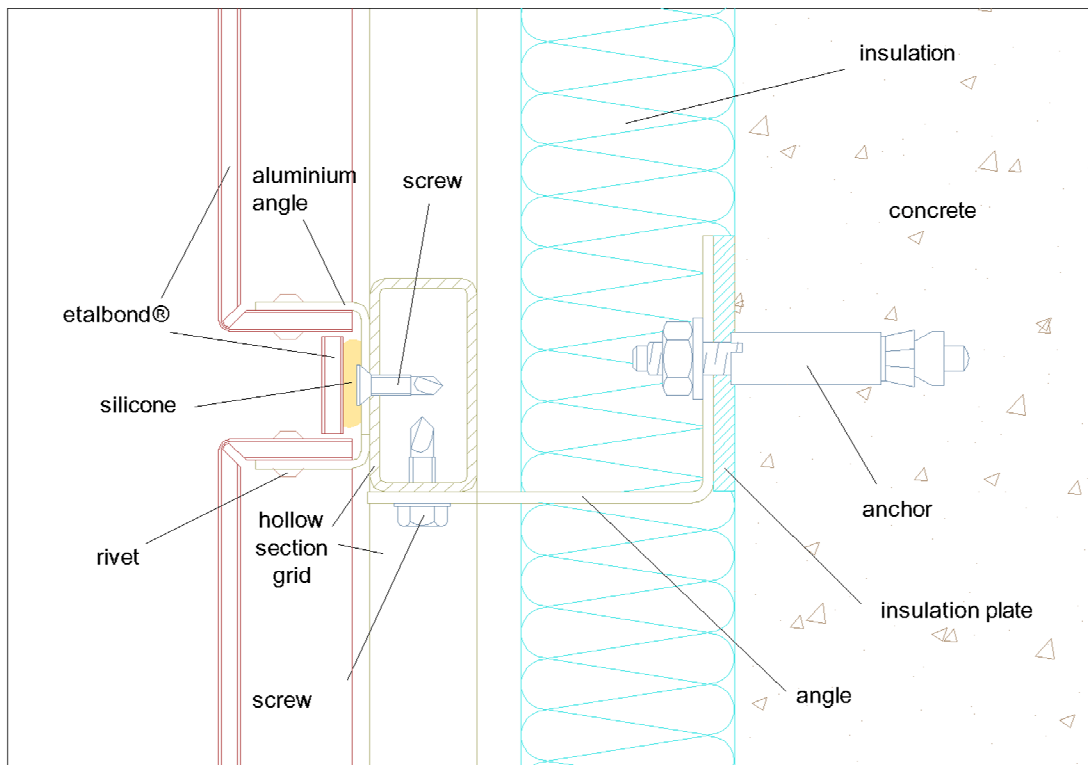
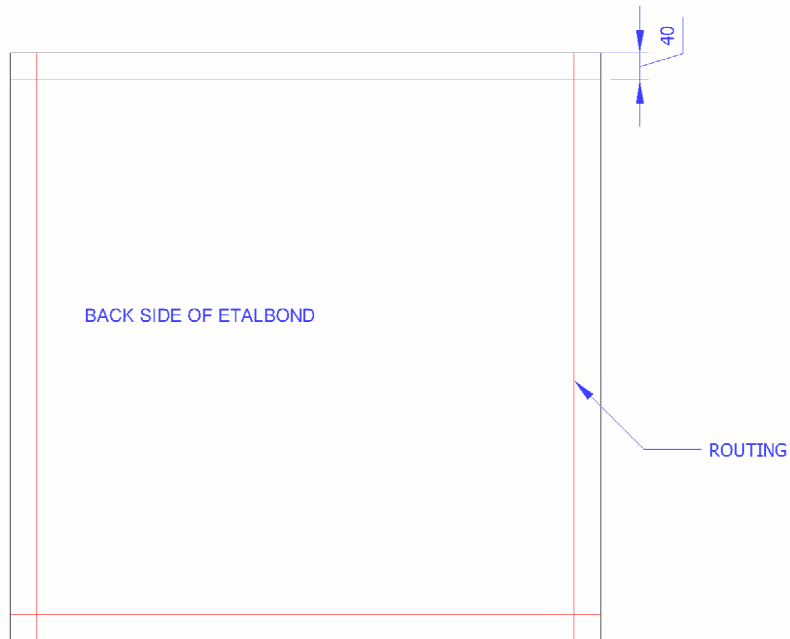


INSTRUCTIONS FOR FIXING etalbond® ON A STEEL SUBSTRUCTURE

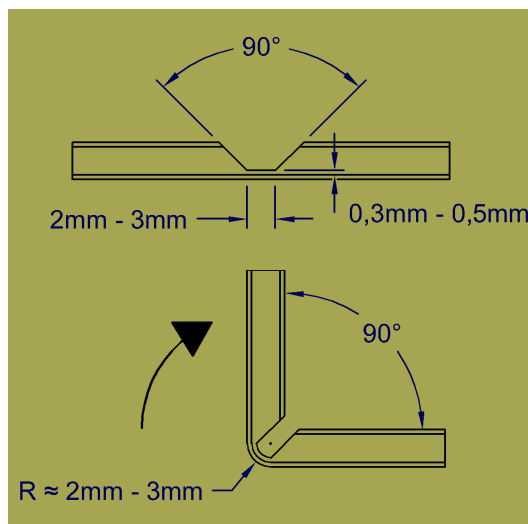


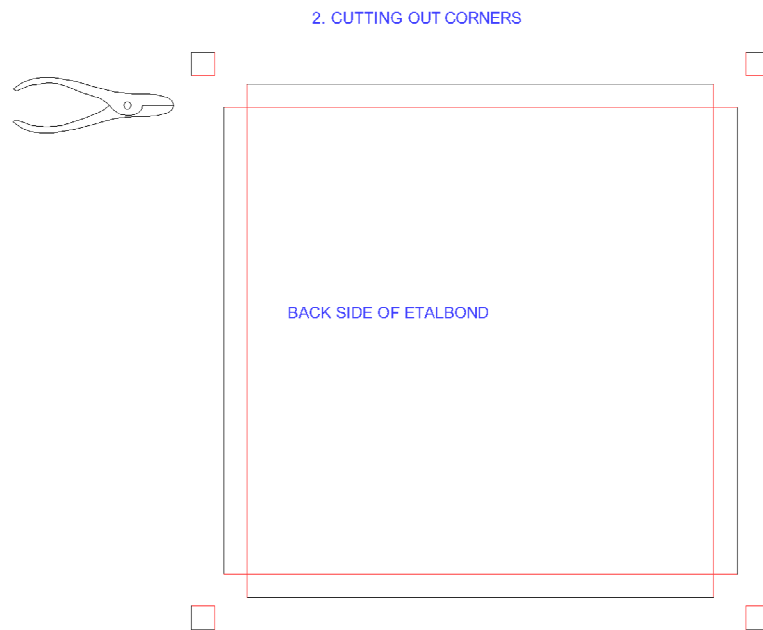
1. ROUTING (RED LINE)



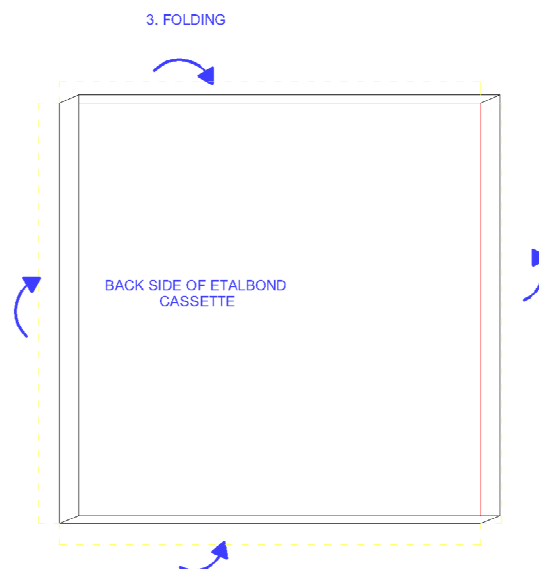
The first step for making an etalbond® cassette is cutting the panel in shape. In the example shown above, the aim is to make a cassette of dimensions 800mmx800mm and 40mm depth. The edges of the cassette will be folded 40mm. Therefore, the first step is to cut a piece that is 40mm + 40mm wider than the size we wish to create. In the example it will be  $(800+40+40)=880$ , so the piece we cut will be 880x880mm.

Afterwards, we create a routing of 90° in a distance of 40mm from the edges of the panel, as shown in the picture above. The geometry of the routing has to be as per the following drawing:



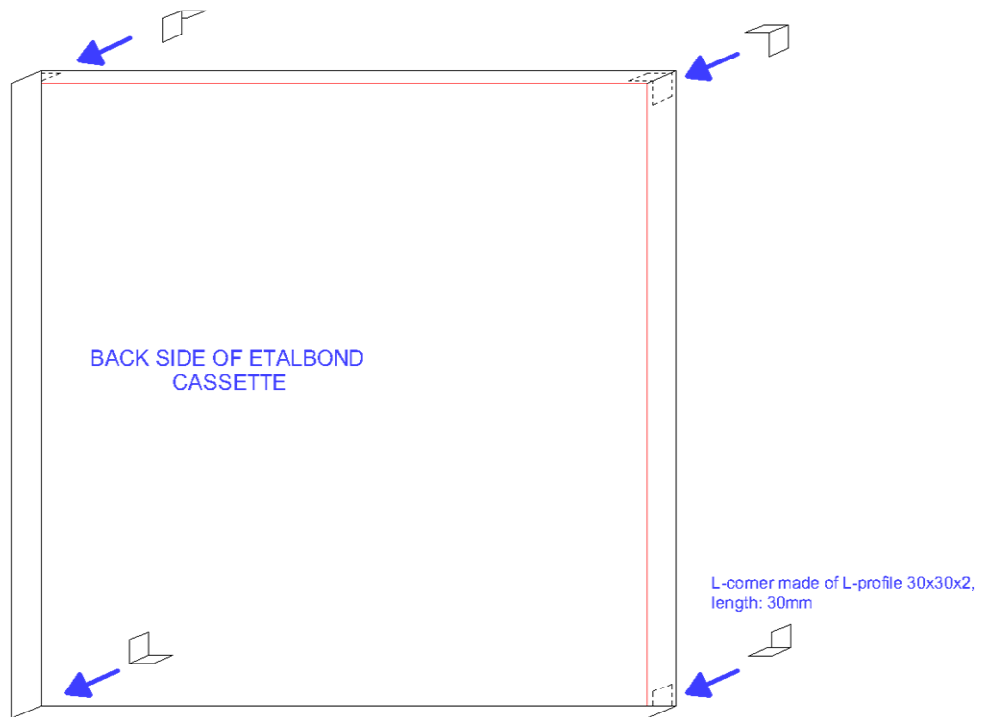


The corners that are created by the routing must be cut out, in order to allow us to fold the edges of etalbond®.



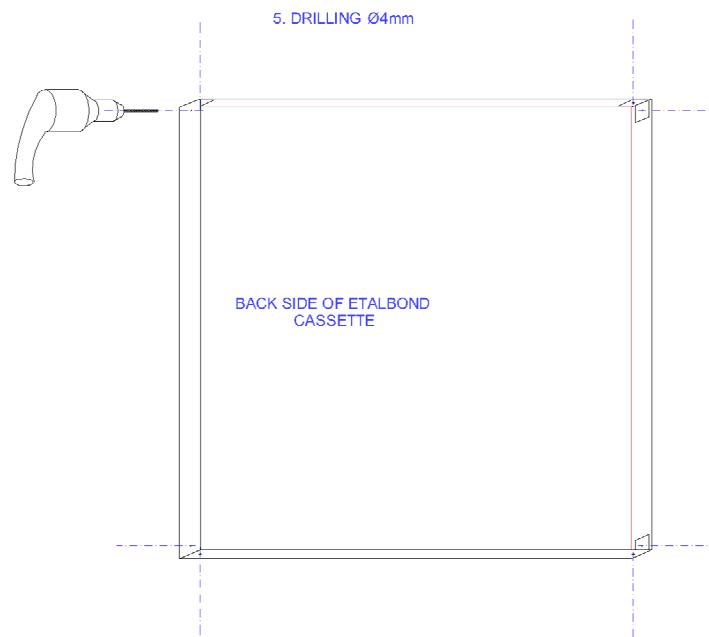
Now, the edges can be folded manually. The cassette of the example has now these dimensions:  
face: 800mmx800mm  
depth: 40mm

4. PLACEMENT OF L-CORNERS

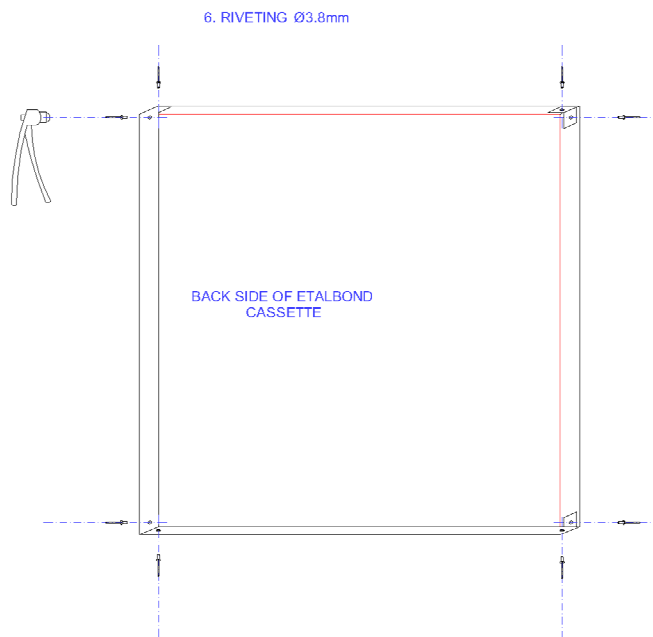


In order to stiffen the cassette, it is important to fix aluminium L-profiles inside the corners of the cassette. For the example shown above, a 30x30x2 aluminium L-profile is used. By cutting small pieces of this profile (in 30mm length) we create small angles that can be placed in the 4 corners as shown in the drawing above. Before placing the corners it would be better to put silicone in the corner in order to waterproof the cut edges of the cassette.

## Instructions for fixing etalbond® on a steel substructure

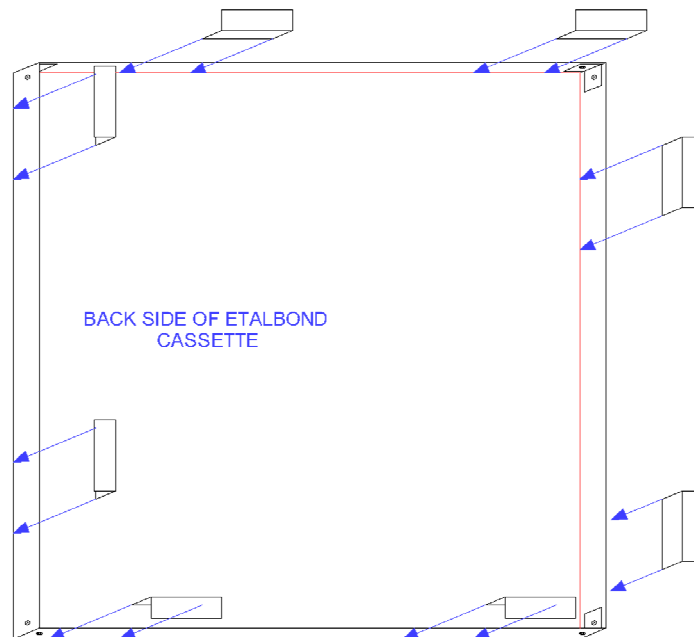


Holding the L-corners in place we use a drill of diameter 5mm (or 4mm) to create holes through both etalbond® and the L-corners according to the blue dotted lines shown in the drawing above.



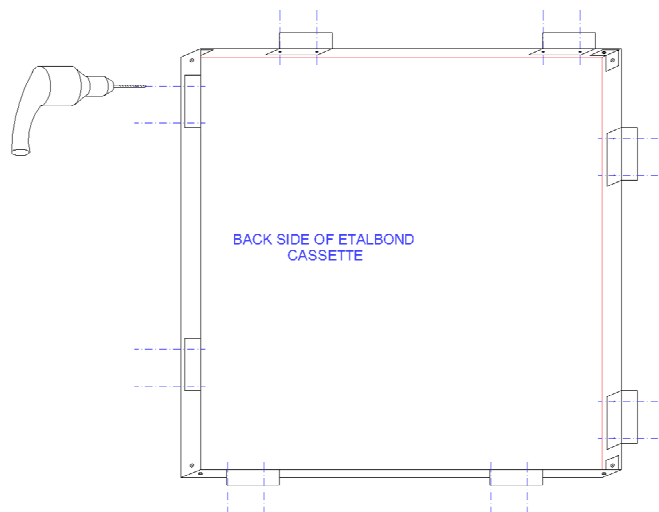
In the holes we drilled we fix rivets of 4.8mm (or 3.8mm) diameter.

7. PLACEMENT OF L-CORNERS

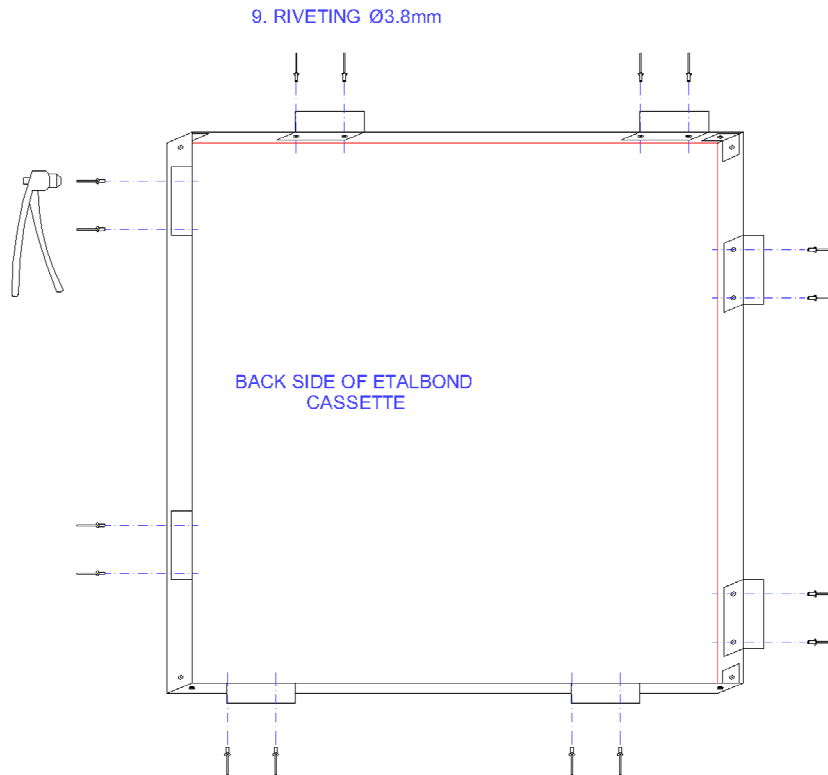


Using the aluminium L-profile of 30x30, we cut again pieces of 100mm length and place them with one "leg" inside the cassette.

8. DRILLING Ø4mm

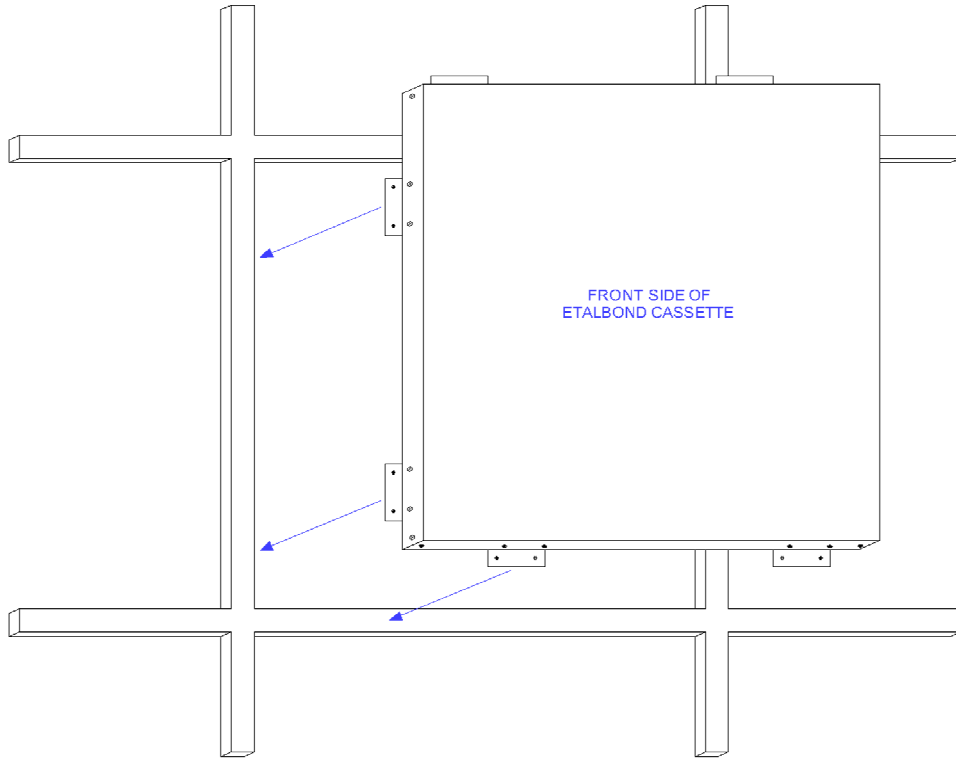


Holding the corners in place, we drill 2 or 3 holes of 5mm diameter.



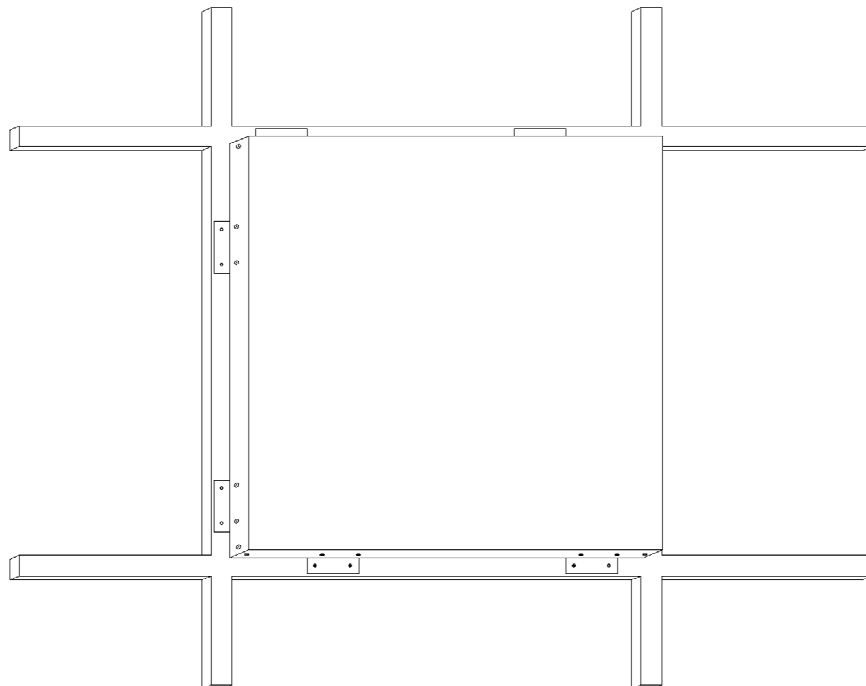
We use 2 or 3 rivets of 4.8mm diameter per to fix each L-profile in place.

10. POSITIONING ON THE SUBSTRUCTURE



On the building we create a grid of galvanized hollow steel sections. A typical steel section that can be used is 40x20mm with thickness 1,5mm – 2mm. Then we place the cassette as shown in the drawing above.

11. FIXING WITH SCREWS ON THE SUBSTRUCTURE





Now, we can use (stainless steel or galvanised) self-drilling screws of 3.9 or 4.2 diameter to fix the cassette on the steel substructure. We use 2 or 3 screws per aluminium L-corner.



In order to hide the screws and the substructure we can put now silicone along the gaps between the cassettes and then stick long stripes of etalbond (20mm to 30mm wide) along the gaps.

