

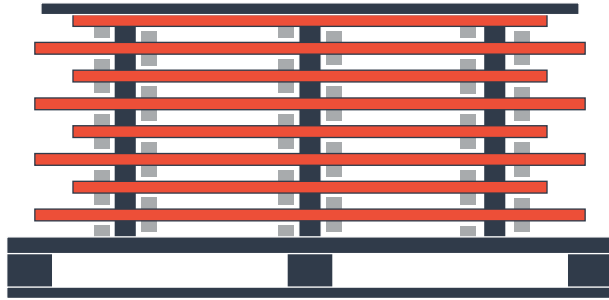
RECOMMENDATIONS FOR WORKING

TRANSPORT AND HANDLING

Handle Samrat Exterior panels with care in order not to damage the edges and surfaces of the high-quality material. In spite of the excellent surface hardness and the installation protection film, the stack weight of Samrat Exterior Cladding Panels is possible cause of damage. Therefore, any form of dirt or dust between the panels must definitely be avoided.

Samrat Exterior cladding panels must be secured against slippage during transport. when loading or unloading, the panels must be lifted. Do not push or pull them over the edge. Transport protection films must always be removed from both sides at the same time. The transport protection film must not be exposed to heat or direct sunshine.

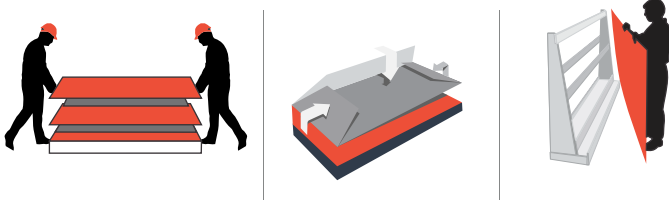


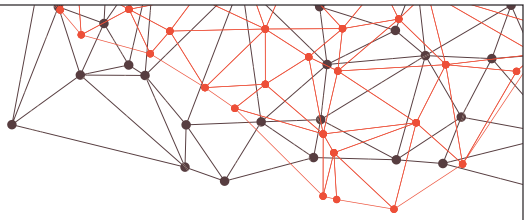


STORAGE AND AIR CONDITIONING

all panels must be stacked horizontally on flat, stable support and supporting panels. the goods must lie completely flat. Cover plates must always be left on the stack. The top cover should be weighted down. After removal of panels, PE films must again be closed over the stack. The same applies, in principle, for cut-panel stacks, Incorrect storage can lead to permanent deformation of the panels.

Samrat Exterior cladding panels are to be stored in closed rooms under normal climatic conditions, Climate differences on the two surface of panel are to be avoided. with pre-installed fastening elements, therefore, care is to be taken that the climatic effect is uniform on all sides. Use intermediate layers of wood or plastic.





MACHINING

Samrat Exterior cladding panels can be easily machined, like hardwood, laminated chipboard or bonded chipboard, with carbide-tipped woodworking tools. Saw with stable circular saws or hand-held circular saws for installation cutting. All well-known producers of hand-held machines (Festa, Bosch, Metobo and many more) offer guide rails. We recommend usage of carbide-tipped saw blades with (group) trapezoidal teeth FZ/TR-(Leitz) to give good cutting results. To achieve good cutting quality, feed EXtERIOR as smoothly as possible.

- Cutting rate: 50-60m/sec depending on tool diameter and rpm, e.g. 4000 rpm, 250 mm, 64 teeth
- Depth of cut per tooth: 0.02 - 0.04 mm
- Feed: 6 - 10 m/min depending on thickness
- Sharp saws and optimum setting of the saw blade projection are necessary in order to achieve clean cut edge
- For fitting work and chamfering on the construction site, electrical hand planes with a chamfering or a mitring groove have proven themselves.
- Use HSS twist for manual drilling. Drill tip 90°
- When using carbide-tipped drills use pillar drilling machines-carbide metal tends to break off when drilling by hand.
- Do not allow the drill to break through the backside of the panel, or if necessary, drill against an appropriate base applying enough pressure to ensure a clean exit hole.

