



# TECHNICAL MANUAL

Made in Italy

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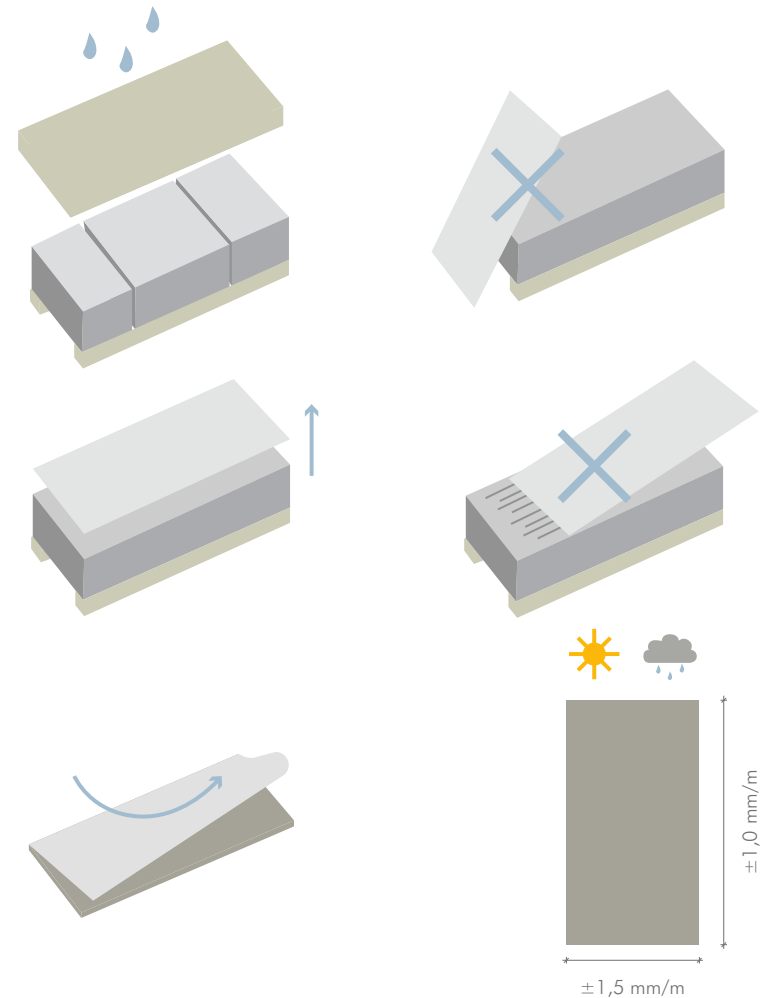
# TRANSPORT AND STORAGE

During transport and storage, the general processing recommendations for laminated boards has to be considered. Store sheltered outdoors on site and shield the protective film from solar radiation and other heat sources. In the meaning of transport regulations MilanoRiveste panels are not classified as hazardous materials, a labeling is not required.

Store horizontally on the pallet with a cover sheet. Ensure adequate ventilation. Standing water on plates or film must be avoided otherwise panels maybe bend.

Lift the sheets straight up. Do not slide the sheets against each other. Sheets have to be covered. MilanoRiveste panels change dimensions depending on humidity. A pre-conditioning of 72 hours on site is required. Shield the protective film from solar radiation and other heat sources. The protective film should be removed from both sides simultaneously before installation otherwise sheet maybe bend.

Typical values for dimensional movement in the longitudinal and transverse direction must be considered due to extreme change in relative humidity.



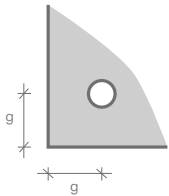
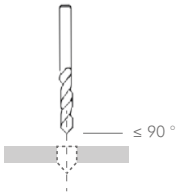
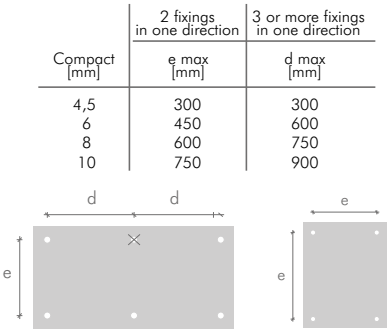
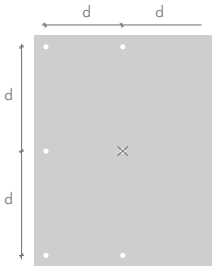
# DRILLING

You can drill MilanoRiveste panels with hand drill, CNC or pillar drill HSS (high speed steel) or carbide drill bit. Long spiral Type H drill point  $\leq 90^\circ$ . When drilling with hand drill use drill pad to avoid disruption (don't drill in emptiness). VHM (solid carbide) cladding panels drill with centring point for HPL suitable for freehand drilling without backing, no outbreak.

For centralised drilling of panel and aluminium substructure use step drill with stop ring for rivet fixing, spring drill device or centralise drill device. Minimum and maximum distance between panel edge and hole.

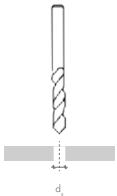
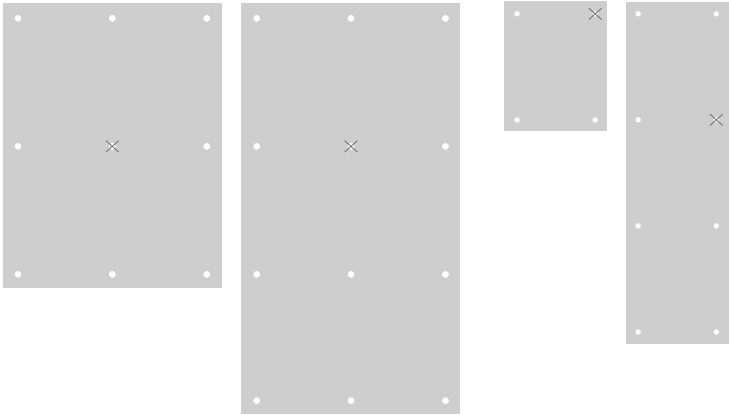
The maximum distance between fastening points depends on the thickness of MilanoRiveste panel. Fixing point should be the nearest (upper) fastening point to the middle of the sheet.

- $\varnothing 5,3$  mm for facade screws 5,5 T20 on wood substructure
- $\varnothing 5,1$  mm for rivet fixing 5/xxK14 on aluminium substructure



| Compact [mm] | g [mm] min max |
|--------------|----------------|
|              | 20-45          |
|              | 20-60          |
|              | 20-80          |
|              | 20-100         |

Sliding points guarantee that the different stretching between substructure and MilanoRiveste will be compensated. Use fixing elements and drill diameters according to list below or similar. It is not enough to drill correct diameter for sliding points only, you also need correct fixing of rivets and/or screws. Diameter of sliding point depends on head and shaft diameter of rivet or screw.



|              | sliding point | $\varnothing d_s$ [mm] |
|--------------|---------------|------------------------|
| Substructure | wood          | 7,5                    |
|              | aluminium     | 8,5                    |

# FIXING SYSTEM

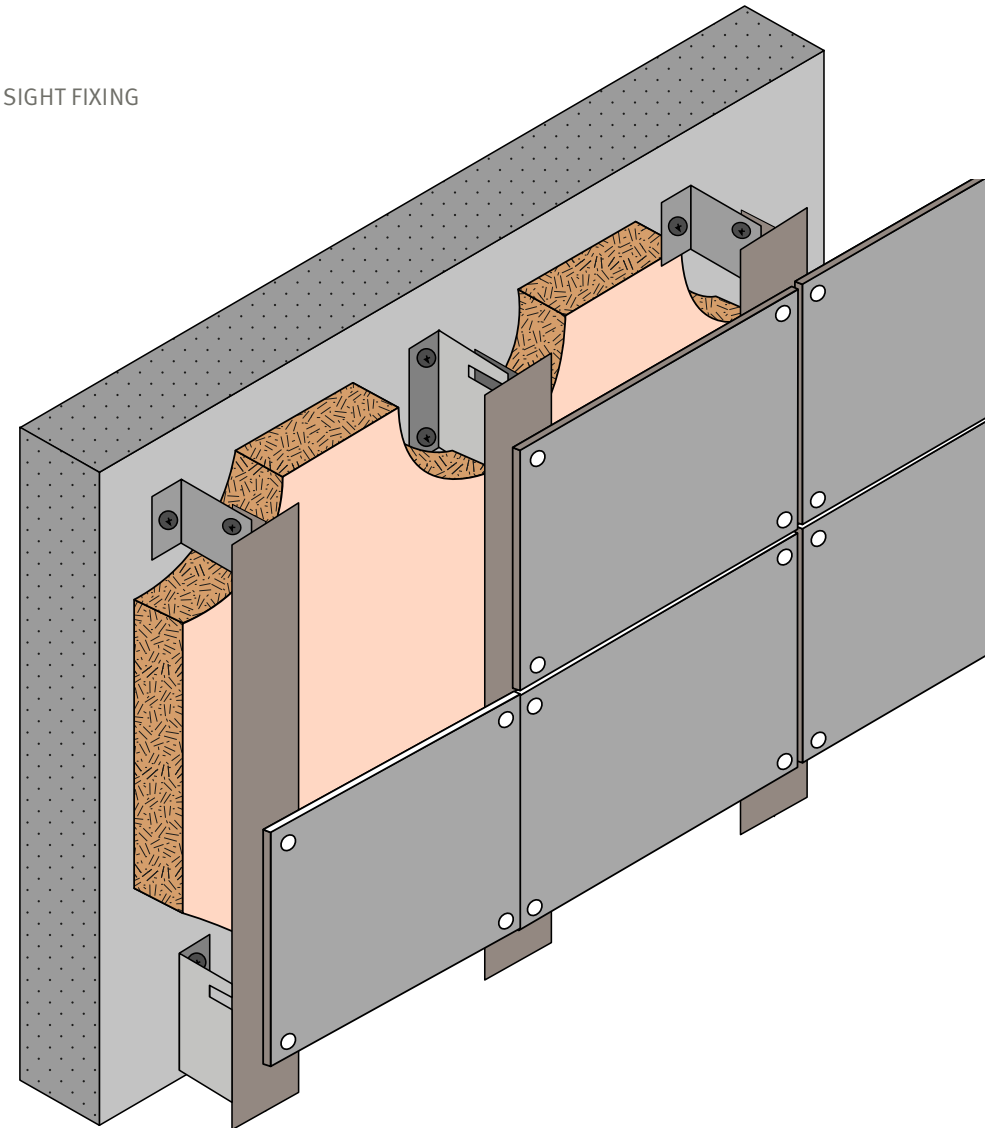
When assembling the ventilated facade, a space must be left between the structural facade (or insulation layer) and the panels. Furthermore, the panels must be never mounted in direct contact with the underlying surface, but an expansion gap must be provided, which allows the panel to contract and expand in relation to humidity.

The structure is an important part of the ventilated facade. Next are some examples of fixing systems suitable for ventilated facades with Compact Exterior HPL.

## AT SIGHT FIXING

At sight fixing - Economic system, very resistant, suitable for buildings higher than 5 meters. It principally allows the aligned joint. The panels are fixed with rivets or screws that can be colored and customized with the chromatic shades of the panels themselves.

AT SIGHT FIXING

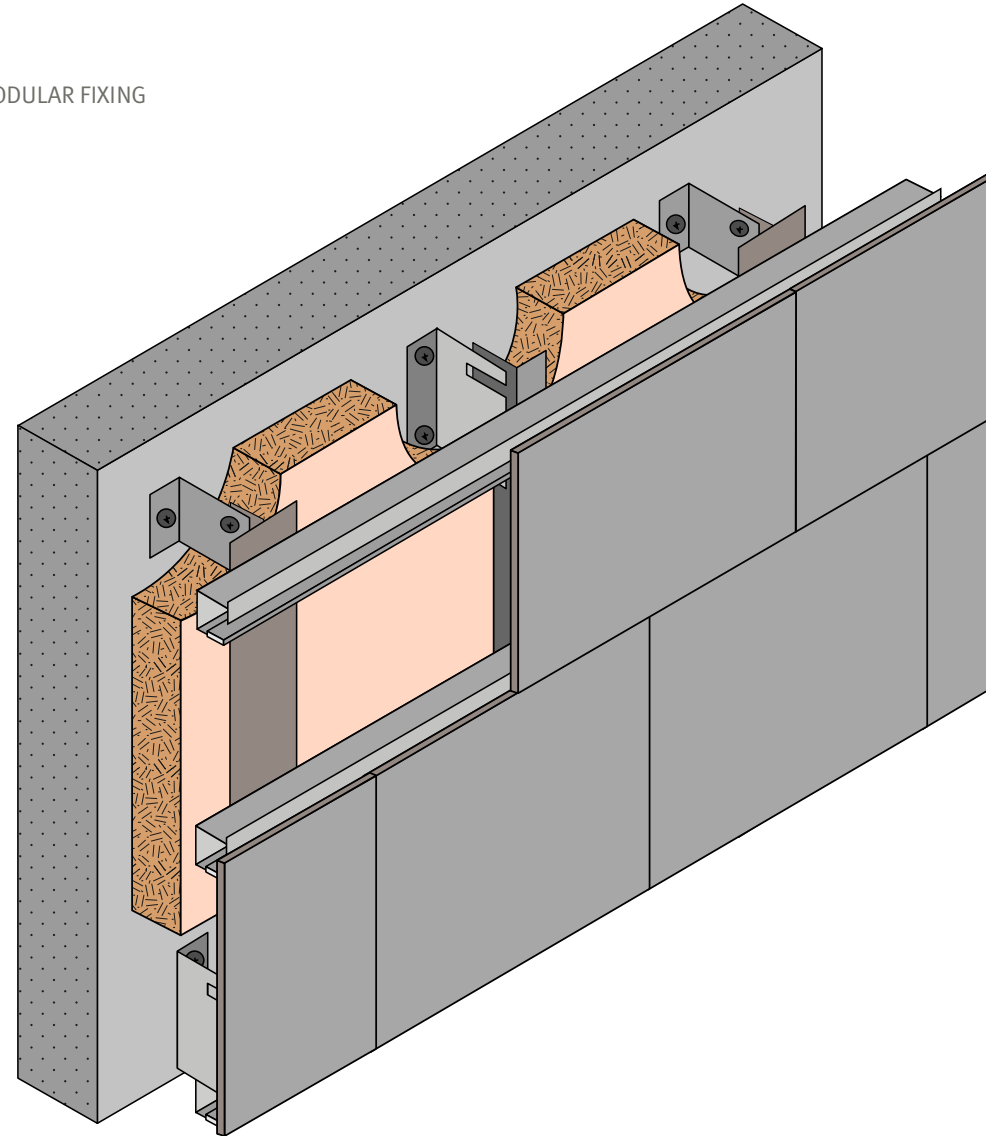


# FIXING SYSTEM

## MODULAR FIXING

System suitable for tall buildings, with visible seam.  
It is made with sliding panels inserted in aluminum rails.

## MODULAR FIXING

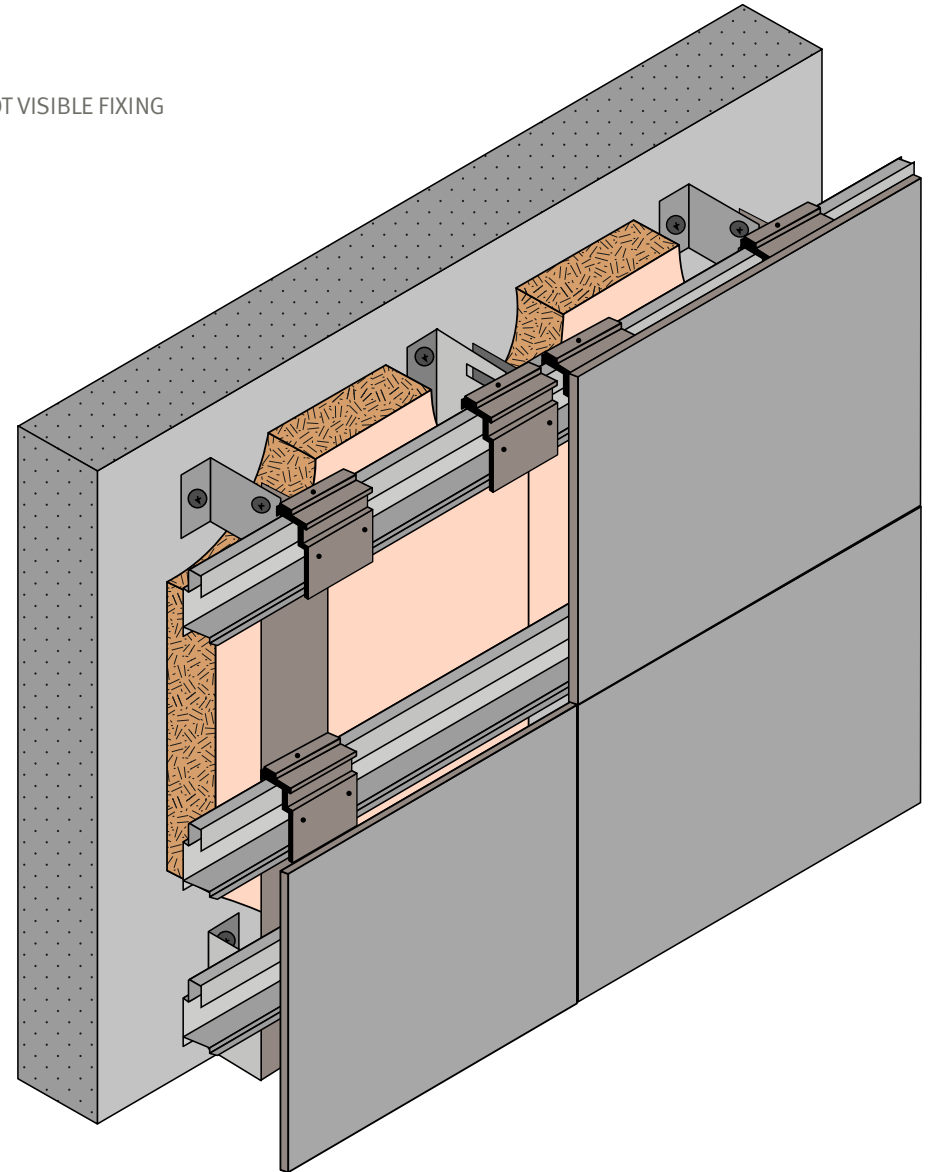


# FIXING SYSTEM

## NOT VISIBLE FIXING

System suitable for not very tall buildings. It allows the staggered joint. The panels are fixed on the back to a structure of aluminum beams. The fixing elements are not visible from the outer facade.

## NOT VISIBLE FIXING





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