TECHNICAL SPECIFICATIONS

STAC BOND PE
ALUMINUM COMPOSITE PANEL

VER. 002/19

HDPE PAINT | **PE** CORE | 0,3mm – 3mm

SHEET DIMENSIONS	**WIDTHS (mm)**	**LENGTHS (mm)**
Made to measure manufacture (CONSULT)	1000 / 1250 / 1500 / 2000	(min. / max.) 2500 / 6000

Thickness tolerance (mm) ± 0,2	**Width tolerance (mm) ± 2**	**Length tolerance (mm) + 15**	**Diagonals tolerance (mm) ± 3**

Tolerance of the Protective Film on the panel (mm) +0; -5

PHYSICAL SPECIFICATION	**UNIT**	**VALUE**	**NORM**
Aluminium thickness	mm	0,3	
Panel thickness	mm	3	
Panel weight	kg/m^2	3,85	
Aluminium alloy		5005 / 3105	UNE EN 573-3
PE CORE SPECIFICATION	**UNIT**	**VALUE**	**NORM**
Density	g/cm^3	0,93	

COATING TYPE	**UNIT**	**VALUE**	**NORM**
External coating thickness (Primer + HDPE)	μ_m	23 – 32*	EN 13523 – 1
HDPE	μ_m	20 ± 2*	
Primer	μ_m	5 – 10*	
Internal coating thickness (Primer)	μ_m	5 – 10*	
Gloss (measured at 60º angle)	GU	30 ± 5*	EN 13523 – 2 / ISO 2813
Hardness (pencil hardness)		HB – F	EN 13523 – 4
GENERAL CHARACTERISTICS	**UNIT**	**VALUE**	**NORM**
Peeling	N/mm	≥ 9,8	ASTM D903 – 98 (2004)
Adherence		There is no loss of adherence	EN – DIN – 53151
Elasticity module (E)	N/mm^2	70000	EN 485 – 2
Proof stress ($R_{p\ 0,2}$)	N/mm^2	≥ 80	
Tensile strength (R_m)	N/mm^2	$125 \leq R_m \leq 240$	
Elongation (A_{50})	%	≥ 4	
Impact resistance		4 Joules / GTØ	EN 13523 – 5/6
Chemical resistance		5% HCl unchanged	ISO 2812 – METHOD 3
Temperature utilization	ºC	– 40 / +80	
Thermal expansion for differences of 100º C	mm/m (100º)	2,25	UNE-EN ISO 10545:1997
Thermal transmission (U)	W/m^2K	3,38	UNE-EN ISO 12567-1
Accoustic insulation Rw (C;Ctr)	dB	–	ISO 717 – 1

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

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