

# Kingspan Installation Guide



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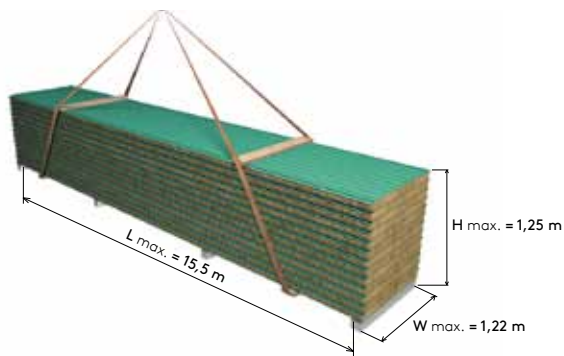
## 1. DELIVERY OF SANDWICH PANELS

### 1.1 PACKAGING

During the process of packaging, the Kingspan sandwich panels are stood in packets on non-carried styrofoam feet. Each panel packet is tightly wrapped in protective foil. The date of production can be found on the information card on the packet along with other supplementary information (DOP, etc.)

Main parameters of the panel packet:

- Height - H max. = 1.25 [m]
- Width - W max. = 1.22 [m]
- Length - L max. = 15.5 [m]
- Mass - max. 4500 [kg]



Picture 1. Main parameters of the panel packet

### 1.2 COLLECTING THE PANELS FROM THE MANUFACTURER

The minimum time for manufacturing the panels after which it is possible to collect them depends on the type of core of the sandwich panel.

- PIR cores: QuadCore®, IPN - 24 hours
- Mineral wool core K-Roc® - 12 hours

The driver takes part in loading the panels. He or she is obliged to abide by the Occupational Safety and Health regulations on the premises of the plant.

### 1.3 TRANSPORTATION

The Kingspan sandwich panels can only be transported by vehicles in good technical condition. Such a vehicle should have a covered loading box which makes it possible to load it from above (a "curtain" or "canvas" cover), from both sides and from the back. At the customer's request, transportation on a platform is acceptable for shorter distances.

The loading spaces must be clean and the surfaces of walls and floors cannot have any protruding sharp elements, such as nails etc. Any types of elements, including the design elements of the loading box, which may potentially damage the panels in transportation, must be suitably secured against the damage, e.g. with OSB panels or styrofoam.

The length of the transportation vehicle must be sufficient to cover the entire packet of sandwich panels placed in the loading box.

The panels with the following core: QuadCore® or IPN - it is acceptable for the packet to stick out of the loading box at a distance of less than 1.5 m.

For panels with the mineral wool core K-Roc it is not advisable for the panels to stick out of the loading box.

If the total length of the tractor with a semitrailer and panel packets after loading is more than 16.5 m or the total length of the articulated vehicle (car + trailer) with the panel packets is more than 18.75 m, the carrier must obtain special permission for carriage from Kingspan.

Vehicles with extendable boxes must contain additional elements, e.g. slidable beams to ensure that the loading box remains continuous at the place of styrofoam feet support.

In car transportation, it is permissible to pile up the packets.



Picture 2. Transportation of piled-up packets.

The carrier is obliged to check the fixing of the load/packets from time to time and, if required,

to tighten the fixing and improve the safety of the carried load. It is recommended to have the first check after 25-50 km and subsequent ones after another 150 km and so on.

The recommended width of the loading space is 2.5 m and the required height of the loading space in covered vehicles is at least 2.6 m.

The transportation vehicle which collects the panels must be equipped with transportation belts of a minimum of 50 mm in width, which will secure the packet of sandwich panels in the loading box. The number of the belts depends on the length of the panels. The recommended spacing of the belts is approx. 3.0 m.

The dressing packets transported along with the panel packets should be fixed individually with separate belts.

#### 1.4 UNLOADING

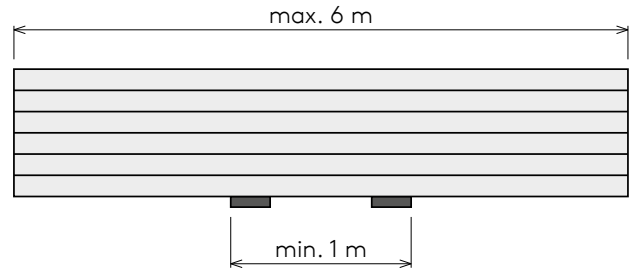
**Before unloading the packet of Kingspan sandwich panels, make a visual external check of the technical condition of the packaging. Any and all damage to the packaging should be noted on the waybills.**

Kingspan inserts an abridged instruction on how to unload and store the panels in each packet. Please read the instruction before unloading the panels in order to prepare the necessary tools and choose the right place where you will unload and store them.

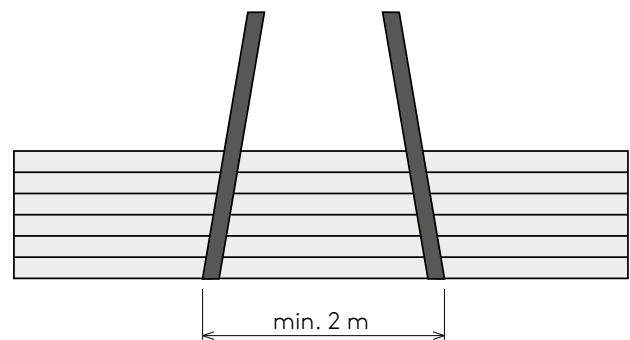
**The customer is responsible for providing all the tools, fittings and machines necessary to unload the panels.**

It is recommended that the staff who unload the panels have close to hand, a minimum of 3 sets of flat lifting slings with the ring length of approx. 6.0 m and the lifting capacity of 5.0 tonnes, a spreader beam, a building crane or forklift truck, as well as otter boards described below (Picture 6).

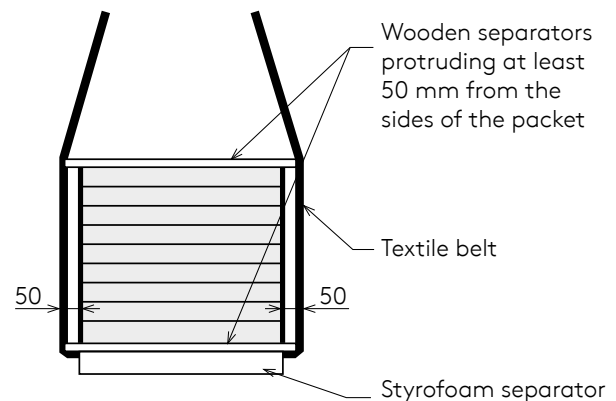
Packets with panels shorter than 6.0 m may be unloaded by forklift trucks (Picture 3) or a hoisting crane with textile belts (Picture 4) and otter boards with the belts positioned at a distance of 50 mm from the edge of the packet (Picture 5).



Picture 3. Unloading the panels with a forklift truck

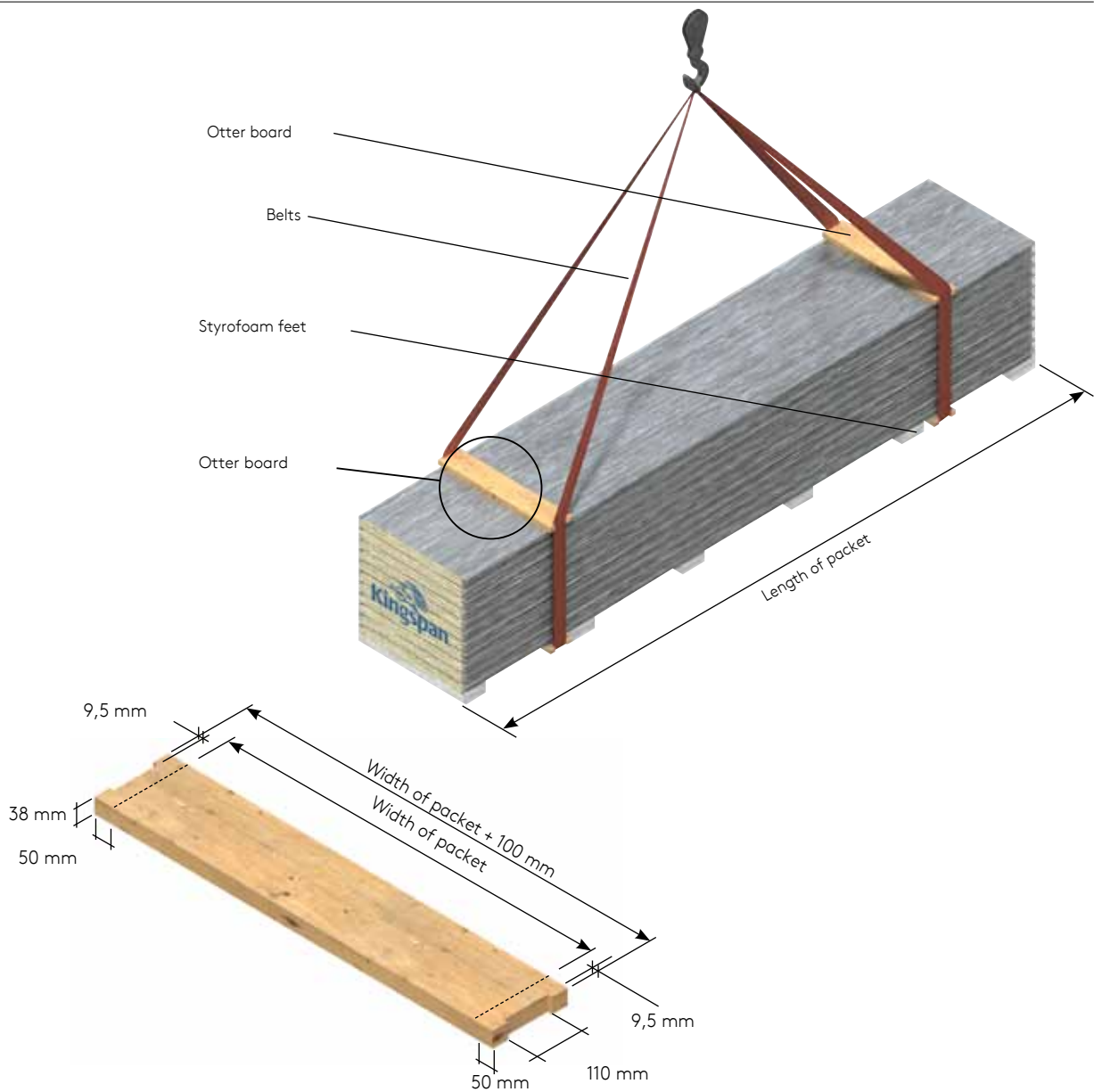


Picture 4. Unloading the panels with the use of a hoisting crane and textile belts.

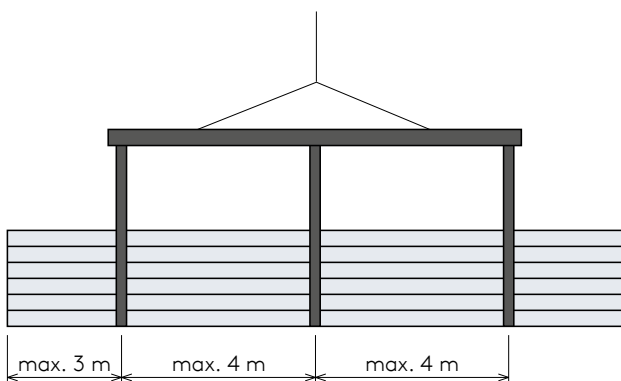


Picture 5. Unloading the panels with the use of otter boards

It is required to use a spreader beam and textile belts when the packets longer than 6.0 m are unloaded with a hoisting crane - Picture 7. The belts should be spaced with an otter board, both beneath and above the packet - Picture 5.



Picture 6. Sample measurements of otter board and means of using it.



Picture 7. Unloading the panels with a spreader beam and textile belts.

**Note! DO NOT USE ROPE OR CHAIN SLINGS TO UNLOAD THE PANELS!**

Each panel packet contains a label specifying the contents of the packet. The information provided at the label includes the type and thickness of the panels, the colour of the lacquer, the quantity of the pieces and the length of the panels in the packet. **Please check the accuracy of the materials each time they are supplied to you. Any and all shortages or inaccuracies should be immediately notified to the Construction Site Manager and the manufacturer - Kingspan.**

When you remove the panels from the packet by hand, always grab the edges of the panels so that you hold both sides of the lining, especially the lower side. If you only grab the upper side of the lining, you may accidentally remove it from its core.

After opening the packet, take out each panel ONE BY ONE.

If you take out a panel with a core made of the mineral wool K-Roc that is longer than 7.0 m, it is advisable to use a support frame and a hoisting crane. Otherwise, you may damage the panel while carrying it (dislocate the lining or snap the panel). A sample support frame is shown in Picture 8.

Protective foil used on the lining of the panels temporarily secures them during transportation and assembly. The protective foil on the lining should be removed no later than 30 days from the scheduled delivery date. Leaving the film on for a longer period of time may cause difficulties in its removal and damage to the paint coating. Violation of the above rules results in the loss of claims for quality defects (warranty and quality guarantee).



Picture 8. Unloading the panels with the use of a support frame

## 2. STORAGE

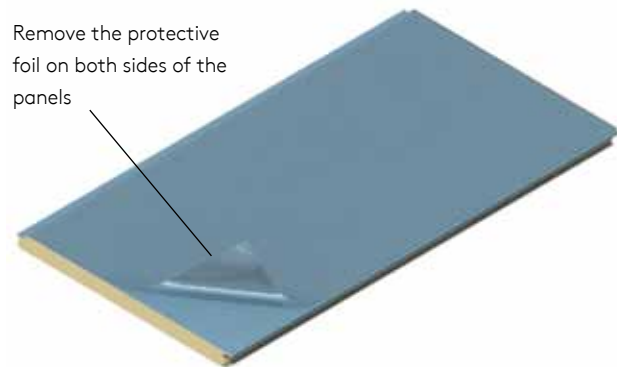
### 2.1 SHORT-TERM STORAGE

The place of storage should be prepared beforehand taking the following recommendations into account:

- the surface of the storage place should be hardened and levelled so that it does not cause the collapse, settlement or tilting of the packets which would consequently lead to the deformation or damage of the panels,
- remove any and all elements protruding from the ground (e.g. stones, twigs, steel rods, planks etc.) so that they do not damage the underside of the panel,
- the storage place should be properly dried in order to avoid rainwater gathering in pools under the stored panels,
- **the packets must not be piled up during storage,**
- a sufficiently large area should be provided so that there is no need to pile up the packets,
- it is not recommended to store the panels close to busy passageways to avoid accidental damage,
- they must not be stored in the passageways to avoid trampling over them,
- the storage space should be marked and taped off to ensure the safety of the stored materials,
- the storage space should be secured against the access of unauthorised persons - below is an example of how the panels should not be stored.

### 2.2 PREPARING THE PANELS FOR STORING

It is recommended to remove the protective foil from the panels which will be stored for a period of more than 30 days after delivery. Take the panels out of their packets and then remove the protective foil from the panels as it will lose its elasticity after the lapse of 30 days of the date of delivery, making its subsequent removal much more difficult. The glue used for the foil may lose its parameters and remain on the surface of the sheet during the removal of the protective foil. More information can be found in 3.6 Protective foil.



Picture 10. Removing protective foil.

Before piling up the panels again, carefully wipe the surface of the panels removing any motes of dust, filings or other undesired elements which could otherwise damage the lacquer coating.

The Kingspan sandwich panels should be stored on a slight incline (more than 3%) along the longer side of the panel so that any accidental rainwater may subsequently flow freely alongside them. The supports should be spaced out at a maximum of 1.5 m.

If the packets are stored in an open area for a longer period of time, they should be covered with a canvas to secure them against adverse weather conditions and UV rays - see Picture 11.

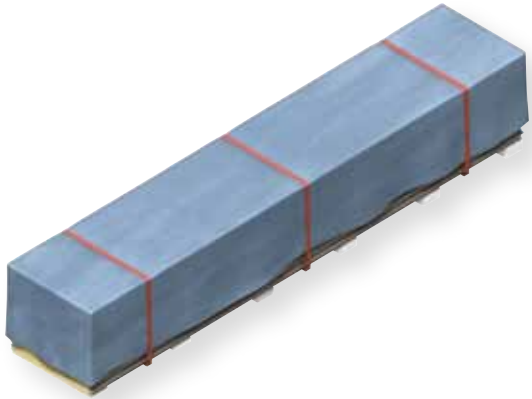


Picture 9. Panels stored incorrectly



**Note! Do not use plastic film to cover the panels during storage.**

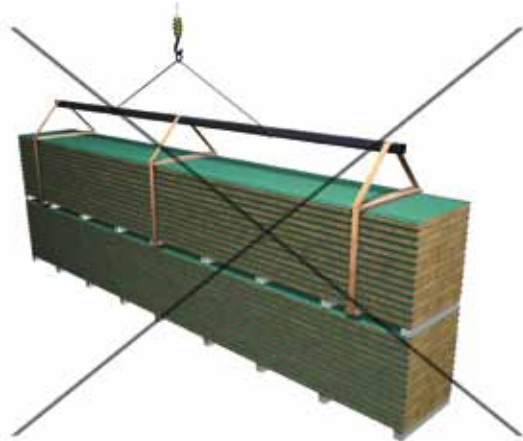
You should also remember to leave the front of the packet uncovered so that the vapour can be easily released from under the canvas.



Picture 11. Securing the packet with a canvas cover.

Under any conditions, do not let water accumulate in between the panels because it will damage the panels in the long run if the place is not properly ventilated.

The panel packets must not be piled up during storage (see Picture 12) because they may be imprinted or dented as a result.



Picture 12. Incorrect storage of packets.

If packets of panels are partly unpacked, remember, each time, to secure them against the sun, rain or strong wind.

Roof panels may be temporarily stored on a roof, also during the assembly, only when they are locked on the support frame system. It is a result of additional weight put on the structure. Each time, such weight should be consulted with the construction site manager or the investor's engineer.

The packets with the panels should be placed on support frames. For security reasons, it is not allowed to pile the panel packets on the roof structure. The panels stored on the roof should be secured against slipping down



### 3. ASSEMBLY

#### 3.1 WEATHER CONDITIONS

The correct assembly of the Kingspan sandwich panels is significantly impacted by weather conditions, such as wind speed, rain and visibility. The wind force should not exceed 4° on the Beaufort scale (9 m/s) because of the small weight of the panels in relation to their considerable size. If the speed of the wind exceeds 10 m/s, any works at height must be avoided. The panels should not be assembled during rain or snow and when it is very foggy. If it is getting dark and the visibility is deteriorating, and there is no artificial lighting provided on the site, the assembly of the panels should be aborted.

It is recommended to carry out assembly works in the temperature range from -5°C to +20°C. Carrying out assembly works, especially cutting panels and cutting window and door openings at temperatures below -5°C should not be performed due to the increased fragility of the core. The upper temperature limit is closely related to the insolation and heating of the panels from the sun's rays.

When the panels are installed in conditions of strong sunlight, there is a phenomenon of thermal expansion of the sheets heated in the sun, which results in the bending of the

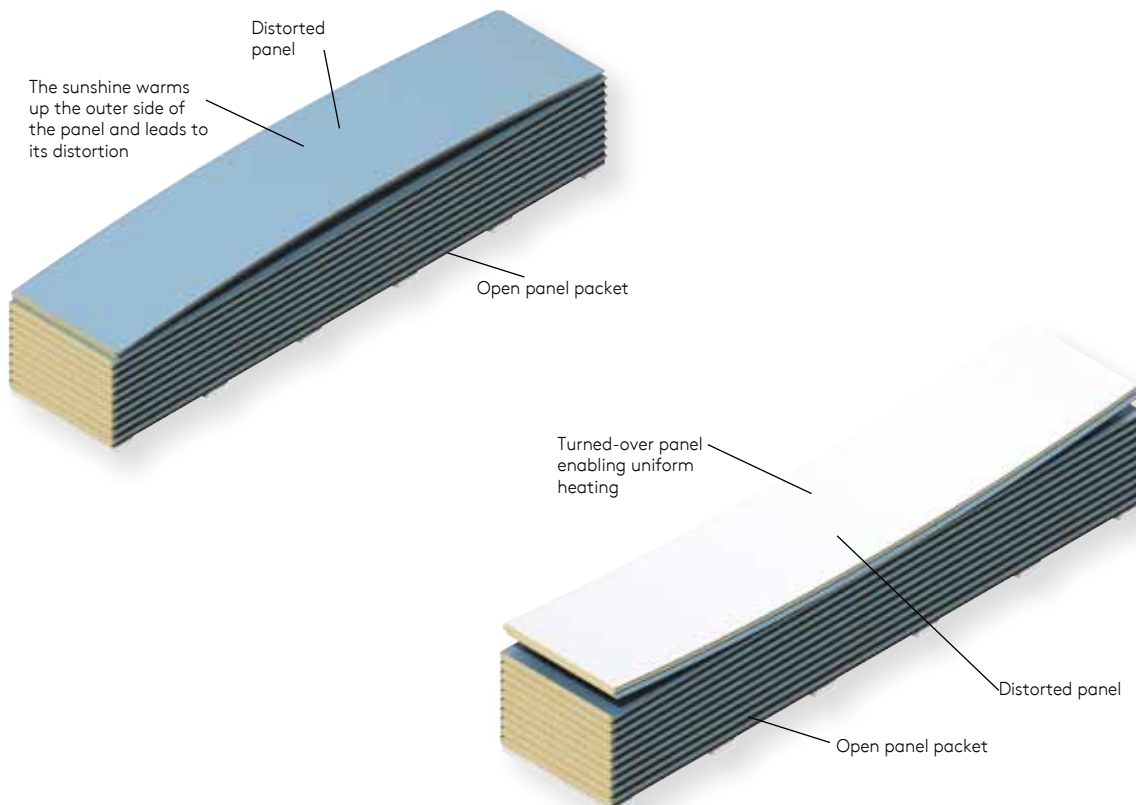
panels, usually towards the sun. This phenomenon is intensified in the case of sheets in dark colors. Very bright colors can be safely installed even at temperatures up to +30°C. On the other hand, sheets in dark colors can get very hot and cause the panels to bend even at a temperature of +10 ° C with high exposure to the sun.

In order to correctly install panels deformed as a result of thermal load, turn the panels to the "other" side and allow the second sheet to heat up, which will significantly reduce the panel's deflection

Information on the temperature and installation of panels in dark colors (3rd color group) can be found in point 4.1. Guidelines for the use of boards in cladding in dark colors.

If there is no factory-applied gasket in the panel lock, works with the use of sealing compounds should be performed at an ambient temperature above 4°C or in accordance with the recommendations of the manufacturer of sealing compounds.

Because of the possible impact of the wind, the panels should be fixed with all the connectors specified in the project before the end of the shift.



Picture 13. Bowing - thermal distortion of the panel.

### 3.2 OCCUPATIONAL SAFETY AND HEALTH

All the work performed during the assembly of the Kingspan sandwich panels must be carried out in accordance with the generally accepted Occupational Safety and Health regulations for assembly work and roof work, and under the supervision of authorised persons. In particular, you should abide by the regulations specified in:

- the Ordinance of the Minister of Infrastructure of 6 February 2003 on the occupational safety and health during the performance of construction work (Journal of Laws 2003 No. 47 item 401).
- the Announcement of the Minister of Family, Labour and Social Policy of 11 May 2018 on publication of the uniform text of the ordinance of the Minister of Labour and Social Policy on the occupational safety and health in manual transportation work and other work requiring physical effort (Journal of Laws 2018 item 1139).
- the Ordinance of the Minister of Labour and Social Policy of 26 September 1997 on general regulations of the occupational safety and health. (Journal of Laws 1997 No. 129 item 844) with subsequent amendments.

Additionally, during the assembly of the panels use the following security equipment for prevention against falling from a height:

- Protection barriers promoting safety during work around the building.
- Assembly-type ropes and security belts.
- Anti-fall nets



Picture 14. Security during assembly.



Picture 15. Assembly barrier.



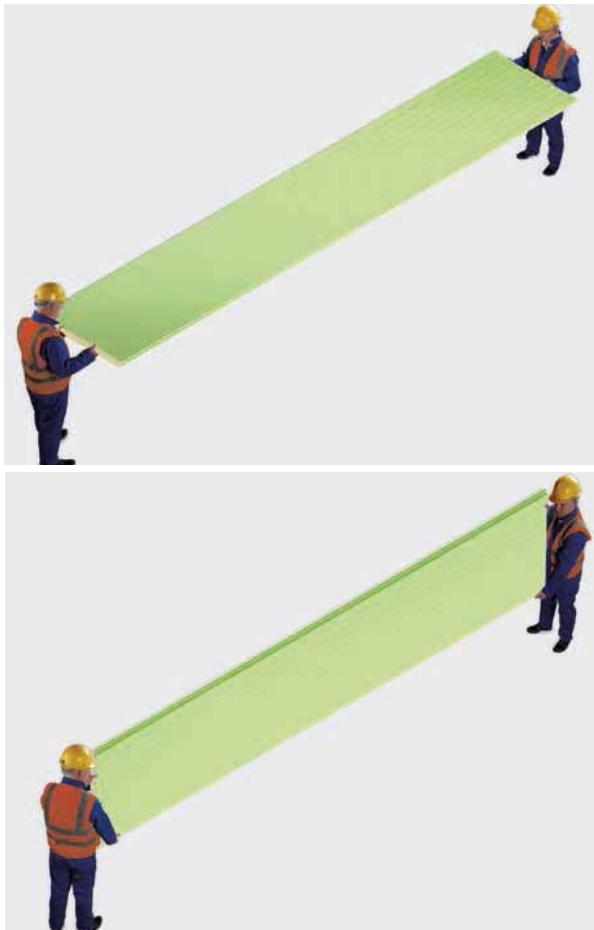
Picture 16. Assembler protected by security belts.



Picture 17. Anti-fall nets.

### 3.3 UNPACKING THE PANELS

- The most practical way to lay the roof panels is to use a hoisting crane.
- When laying the panels with the use of a hoisting crane, consider the decline of the roof. Otherwise, you may damage the edges of the panels.
- Lightweight panels may be taken out of the packet and laid on the wall or the roof by hand.
- Remember that the panels you take out should always be transported on their end.



Picture 18. Correct carriage of panels (below) and incorrect carriage of panels (above).

**Note!**

**It is forbidden to “hammer” elements such as bars and pipes into the heat-insulating core of the panel that would make it easier for you to carry it to the place of assembly.**

- Before you lay the panels on to the roof structure, remove the protective foil from the inner lining of the panels.

- While laying and assembling the panels, the assemblers stepping on the panels must have soft-sole footwear on so that they do not damage the coating of the panels.
- In order to protect the gaskets in the lengthwise contact of the panels, keep the movement of the panels on the roll axis to the minimum.

### 3.4 ASSEMBLY TOOLS

#### 3.4.1 ViaVac vacuuous elevators

The ViaVac vacuuous elevators are used to safely lift and carry, without causing damage, wall panels in a horizontal and vertical system, as well as wall panels with a variable angle of inclination. The choice of equipment from the VIAVAC offer depends on the type and length of the sandwich panel and the specificity of the assembly. In order to eliminate the risk of damaging the panel during carriage, always follow the instructions given by the properly trained technical department of the company that offers the VIAVAC machinery for hire.

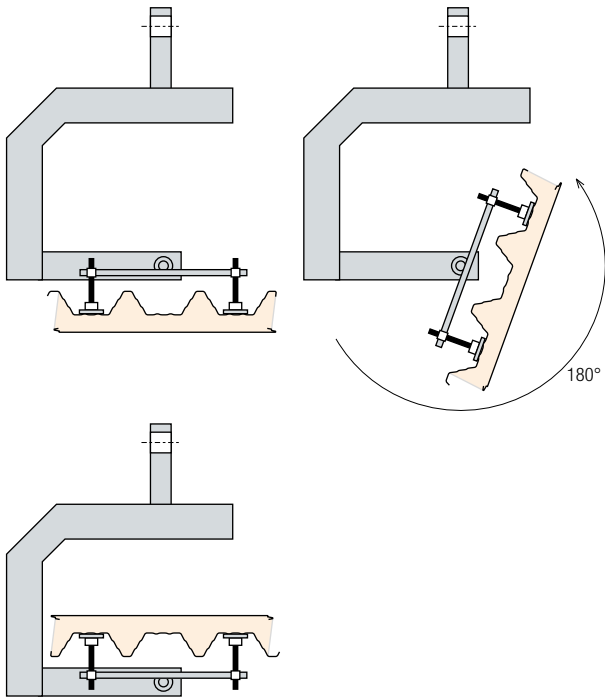
Hiring vacuum cups might be a perfect solution for the assemblers who want to make their work faster and safer.



Picture 19. Positioning the elevator on the top/first panel.



Picture 20. Lifting a correctly secured panel with vacuum cups and belts.



Picture 21. Turning over a sandwich panel for correct assembly.



Picture 22. A sandwich panel turned over on columns.



Picture 23. A sandwich panel correctly secured for further assembly.

**3.4.2 Self-locking assembly tool**

A special self-locking assembly tool makes the transportation of panels much easier. It is used to lift both the roof and the wall panels, horizontally and vertically. You will need at least two tools to lift the panels horizontally.



Picture 24. Self-locking assembly tool.



Picture 25. Self-locking assembly tool used for roof panels.



Picture 26. Stages of transportation of roof panels with the help of a self-locking assembly tool.

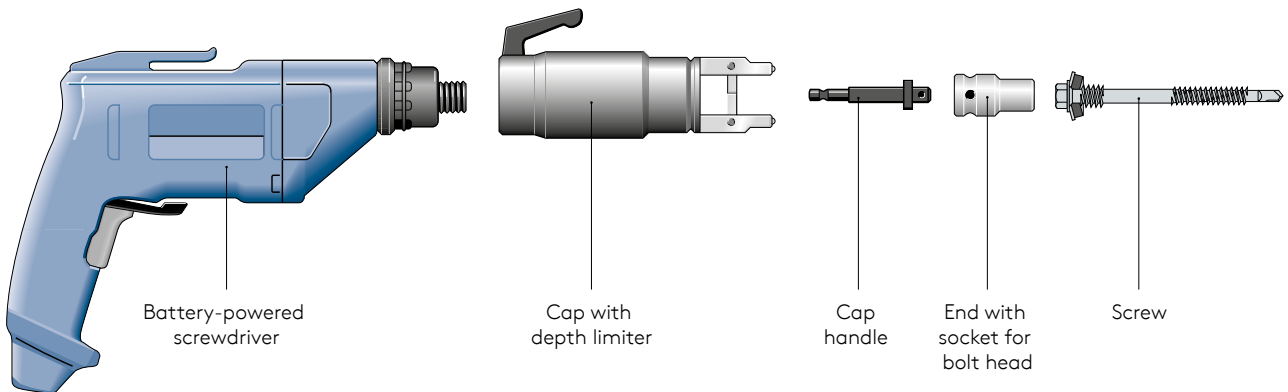
### 3.4.3 Screwdrivers

If you want to fix the connectors, it is advised to use specialist screwdrivers equipped with a proper head to drive long connectors and adjust the relative depth of the connector head.

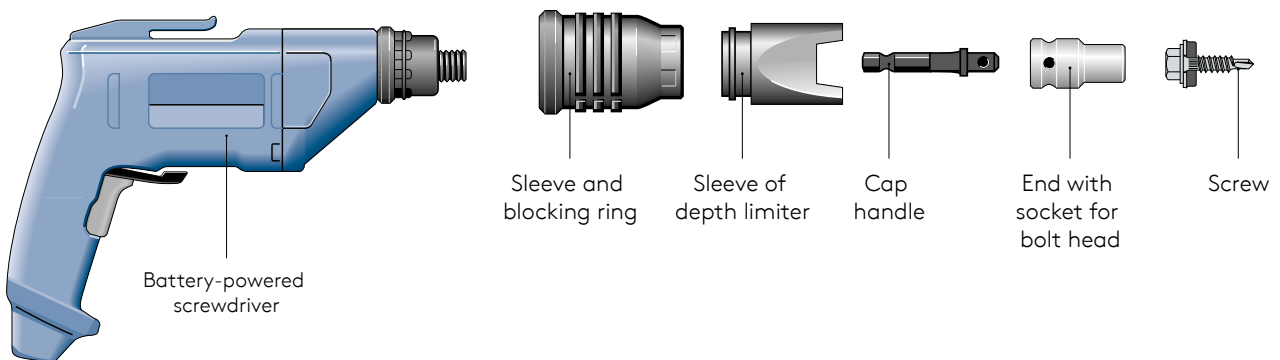
It is also acceptable to use a common screwdriver in which you can adjust the relative depth of connector setting, bearing the

following parameters:

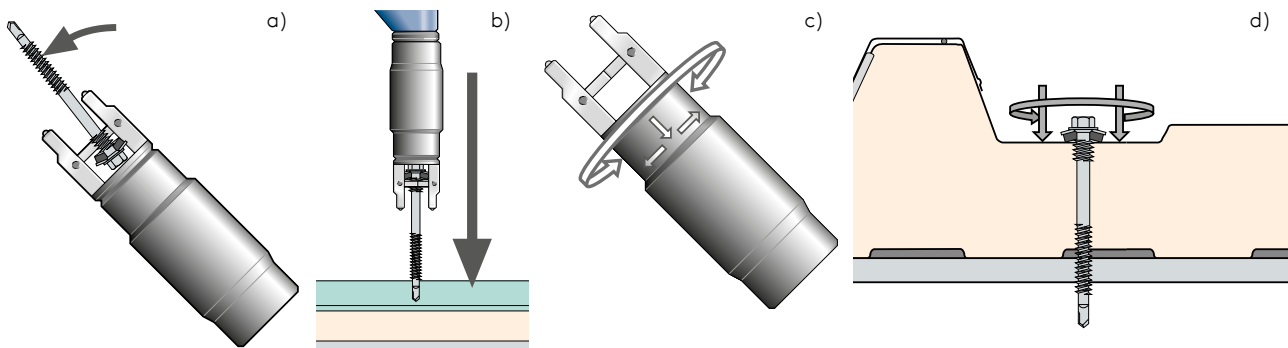
- power: 600 ÷ 750 W,
- working resolutions with this power: 1500 ÷ 2000 resolutions per minute,
- torque 600 ÷ 700 Nm.



Picture 27. Screwdriver equipped with a head for driving long connectors with depth adjustment.



Picture 28. Screwdriver with head equipped with depth adjustment



Picture 29. Steps in assembling the connector for fixing sandwich panels

- a) setting the screw in the head,
- b) boring the fixing screw into the panel and the structure,
- c) if the gasket is not properly pressed, adjust the depth of the head so that it is similar to the one used for screws,
- d) tighten the screws that fix the panel with a properly set head.



### 3.4.4 Sawing machines, shears

For trimming sandwich panels, use the following tools:

- circular saws or chainsaws for cutting metal
- rotary saws with fine-toothed blades for cutting metal\*

\*You can use sawing machines if they are equipped with sufficiently accurate driving systems. Leftover filings should be immediately removed. Otherwise, they will stain the lacquer with rust



Picture 30. Sample circular saw for cutting sandwich panels.



Picture 31. Sample chainsaw for cutting sandwich panels.



Picture 32. Rotary saw with fine-toothed blade.

**Note! If you cut the panels or flashing, do not use angle grinders and other machines that may cause overheating in the cutting area. Otherwise, you may damage the anticorrosive coating. Use handheld shears to cut flashing.**



Picture 33. View of burnt panel cut with an angle grinder.



Picture 34. View of lacquer coating damaged by filings during cutting with an angle grinder



Picture 35. Damage to lacquer coating caused by leftover rusted filings

### 3.5 PREPARATION FOR ASSEMBLING

Before beginning to assemble Kingspan sandwich panels, do not forget to:

- Read the unloading instructions, Kingspan assembly instructions and technical design documentation, especially the details on how to assemble the panels.
- Check if the supporting structure was made in accordance with the technical documentation and ensure the acceptable assembly deviations were not exceeded. Kingspan advises that the sandwich panels be fixed to the supporting structure that is not farther than  $L/600$  (in which  $L$  = distance on axis between the successive elements of the support) from the plane.
- Check if the space between the purlins, poles and bolts, and the width of the plate (width of panel support) correspond with the design and the current guidelines listed on the static load charts and the Kingspan panel assembly details. The load charts and the assembly details can be found at [www.kingspan.com](http://www.kingspan.com).
- Check if the poles and bolts are aligned with the construction's wall structure. If you notice any errors or inaccuracies, please inform the Construction Site Manager.
- Check the steel class of the steel structure and the boring parameters of the screws you use or the concrete class and the requirements of the self-tapping screws used for concrete.
- Check how the pedestal and the other wet works were performed.
- Prepare all the necessary measures pertaining to the Occupational Safety and Health.
- Prepare all the tools and materials that you will need to fix the panels.
- Set and, if possible, mark off the place where the first panel will be fixed, horizontally and vertically.

If you prepare the structure well, it will be much easier for you to assemble the panels, ensure that the connectors fixing the panels work well and make the enclosure of the construction look neat and tidy.

**You must not perform any welding work or cut with angle grinders near the panels as it may permanently damage the lacquer coating.**

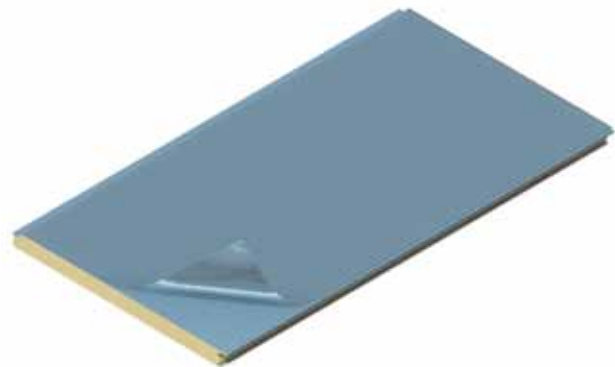
### 3.6 PROTECTIVE FOIL

#### 3.6.1 Protective foil on sandwich panels

The lining of the sandwich panels manufactured by Kingspan is secured against staining or damaging by protective foil. The foil is applied in production. The protective foil must be removed no later than 30 days after the scheduled delivery date.

**Leaving the foil on for a longer period of time may cause difficulties in its removal and damage to the paint coating. Violation of the above rules results in the loss of claims for quality defects (warranty and quality guarantee).**

Due to weather factors, the foil quickly loses its elasticity and bursts. As a result, it may be difficult to remove it from the sandwich panel lining. After the time mentioned above, the glue used for the foil may lose its parameters and remain on the surface of the sheet during the removal of the protective foil.



Picture 36. Sandwich panel secured by protective foil.



- Before assembly, remove the protective foil from the lengthwise edges of the panels to avoid squeezing it in the locks.
- Remove the foil in the spots where you will fix the screws to avoid squeezing it with the washer of the screws after you have tightened them.
- In roof panels, before you fix the panels to the structure, remove the protective foil on the inner side supported by the purlins.
- Remove the protective foil from the panels near flanges, skylights, smoke hatches etc. before assembly.
- You must not leave behind the foil that has been ripped or it may stain the lacquer by the water streaking down or variable exposure to sunshine.

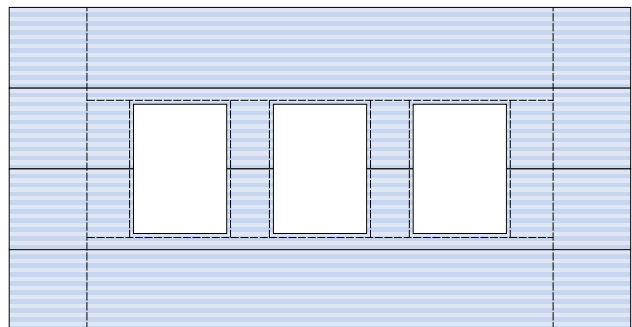
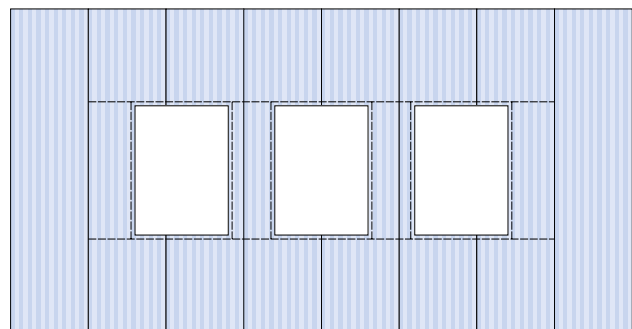
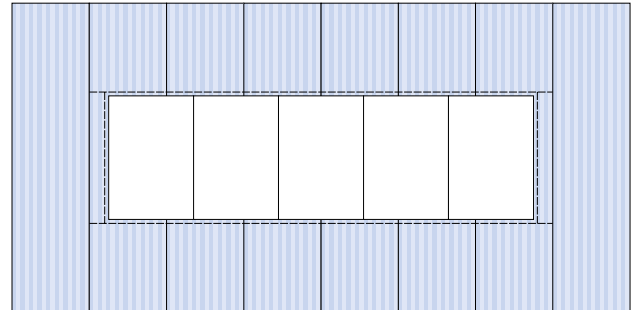
**The Kingspan wall panels, KS1150 RF, KS1150 TF, KS1150 TL, KS1150 NC and KS1150 NF produced with the inner and outer lining in the same colour and with the same profiling, carry protective foil on the inside with a blue band.**

### 3.6.2 Protective foil on flashing

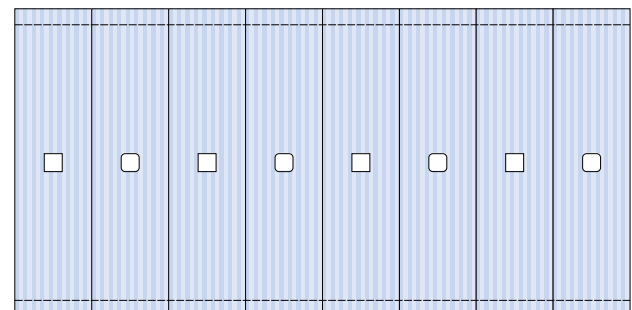
- Remove the protective foil from the flashing before you begin to assemble it.
- The protective foil from the flashings must be removed no later than 30 days after the delivery date.
- For the protective foil on flashing, use the same procedures as you apply for the foil on panels.

### 3.7 PANEL TRIMMING AND HOLES IN SANDWICH PANELS

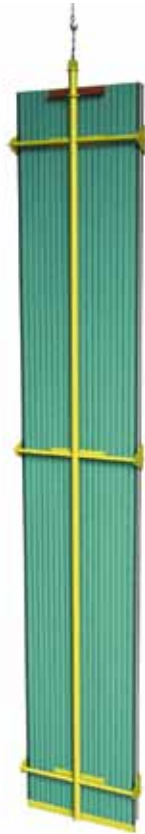
- The process of trimming should always be carried out using the proper materials (see 3.4.4 Assembly tools).
- Pre-cuts for the holes in roof and wall panels weaken the cross-section of the panel, so these places should be sufficiently tightened by an additional support structure (see Picture 37).
- Cuts and holes in roof and wall panels made before fixing the panels weaken the cross-section, so special care must be taken when you transport and assemble such panels.
- It is best to transport the weakened panels in another transportation frame (see Picture 39).



Picture 37. The wall woodwork holes in sandwich panels, dashed lines show the places where supplementary understructure should be applied.

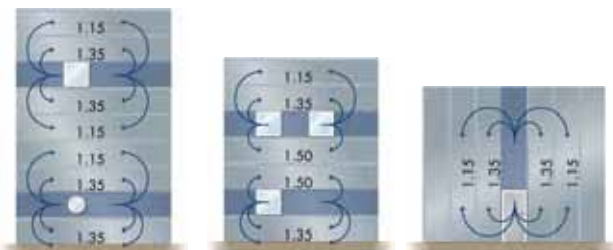


Picture 38. The wall woodwork holes in sandwich panels that do not require supplementary understructure.



Picture 39. Sample transportation frame for raising panels with holes.

- You may cut holes, the maximum diameter of which equals 20% of the width of the modular panel without an additional support structure (see Picture 38), but the panels must have a carriage cushion of at least 50%.
- You may only cut holes, the maximum diameter of which equals 50% of the width of the modular panel without an additional support structure, when the panels have a carriage cushion of at least 50% and the holes do not appear in the adjacent panels (see Picture 40).



Picture 40. The wall woodwork holes in sandwich panels that do not require supplementary understructure.

### 3.8 CONNECTORS FOR PANEL ASSEMBLY

If you want to fix Kingspan sandwich panels to the support structure, use appropriate self-drilling or self-tapping connectors with a minimum diameter of  $\phi$  5.5 mm made of corrosion-resistant steel (so-called stainless steel) or carbon-galvanised steel. The type of connector depends on the specific support structure and the panel thickness.

When you use self-tapping connectors, the diameter of the initial hole for a self-tapping screw depends on the thickness of the structural wall to which you fix the panel. You should stick to the diameter of the initial bore provided by the screw manufacturer.

Under the head of the fixing connector, you will find an EPDM gasket with a minimum diameter of  $\phi$  19 mm.

If you use screws for fixing roof panels, you may apply strengthening calottes.

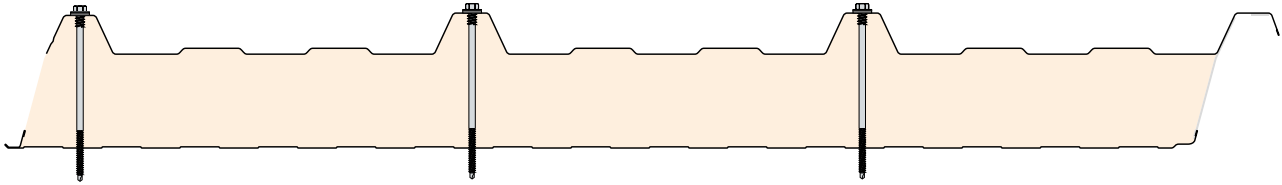
A single calotte is shown in the picture below (Picture 41). If you fix a panel with the help of a connector with a calotte, the minimum diameter of the connector's EPDM washer is 16 mm.

Kingspan recommends using calottes for assembling connectors on the humps of the panel.

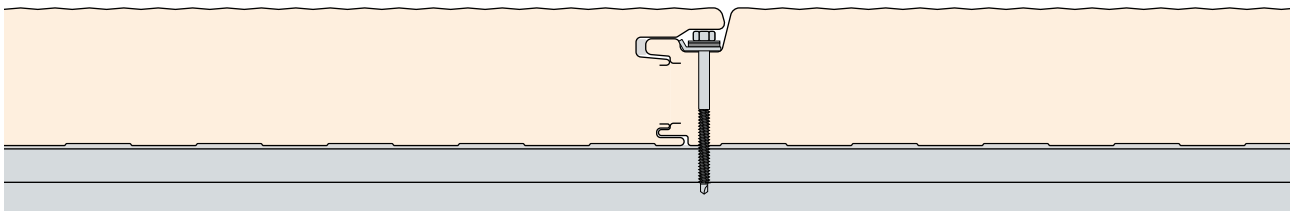


Picture 41. Connector with calotte - assembly in the hump of the roof panel.

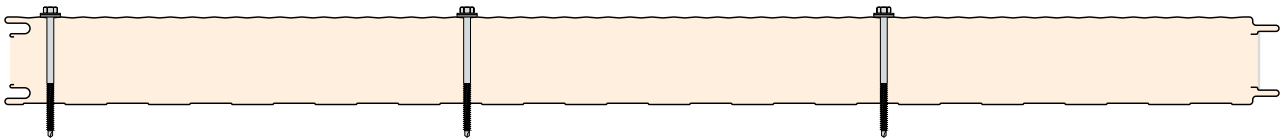
The connectors specified in the design are bolted, depending on the type of panel, in the lock socket or in the appropriate place on the outer lining of the panel. If you have roof panels with outer lining made of trapezoidal sheet, you should normally set the connectors on the edges of the trapezes, but you may also set the fixing screws in the trough of the trapezoidal sheet. Samples of the recommended spot for setting the connectors are shown in the pictures below.



Picture 42. Recommended spot for setting connectors for roof panels.

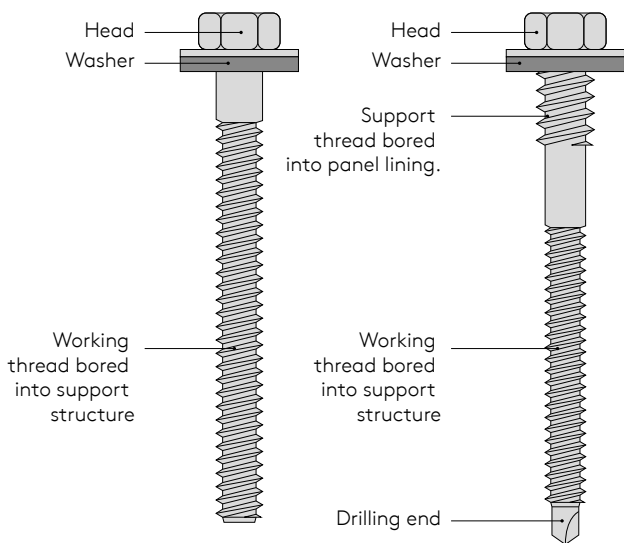


Picture 43. Recommended spot for setting connectors for wall panels with covert fixing.



Picture 44. Recommended spot for setting connectors for wall panels with overt fixing.

If you work with roof panels, you need to apply “first order” connectors with support threads. These connectors are supplemented with a thread under the head of the screw, whose purpose is to tighten the outer sheet to the washer with the EPDM gasket and therefore make the hole in which the connectors were set sufficiently leakproof. The construction of first order screws is shown in Picture 45.



Picture 45. Connector diagram

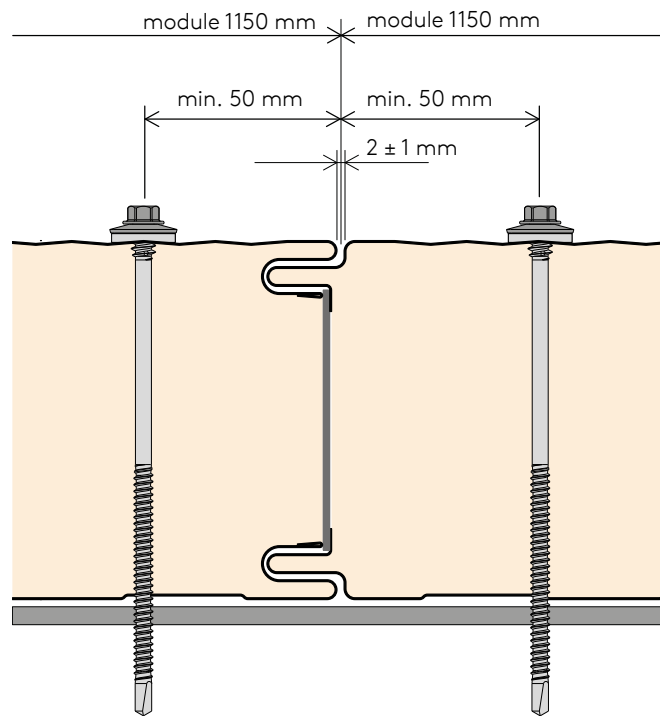
You are advised to use self-drilling connectors made of corrosion-resistant steel (so-called stainless steel) if you fix the panels on the premises, in which:

- Indoor atmosphere is characterised by relative permanent humidity of over 70%.
- The indoor atmosphere is chemically aggressive.
- Tiny thermal losses and tiny thermal conductivity for screws (e.g. refrigerators) are required.
- Glued laminate timber construction is used.

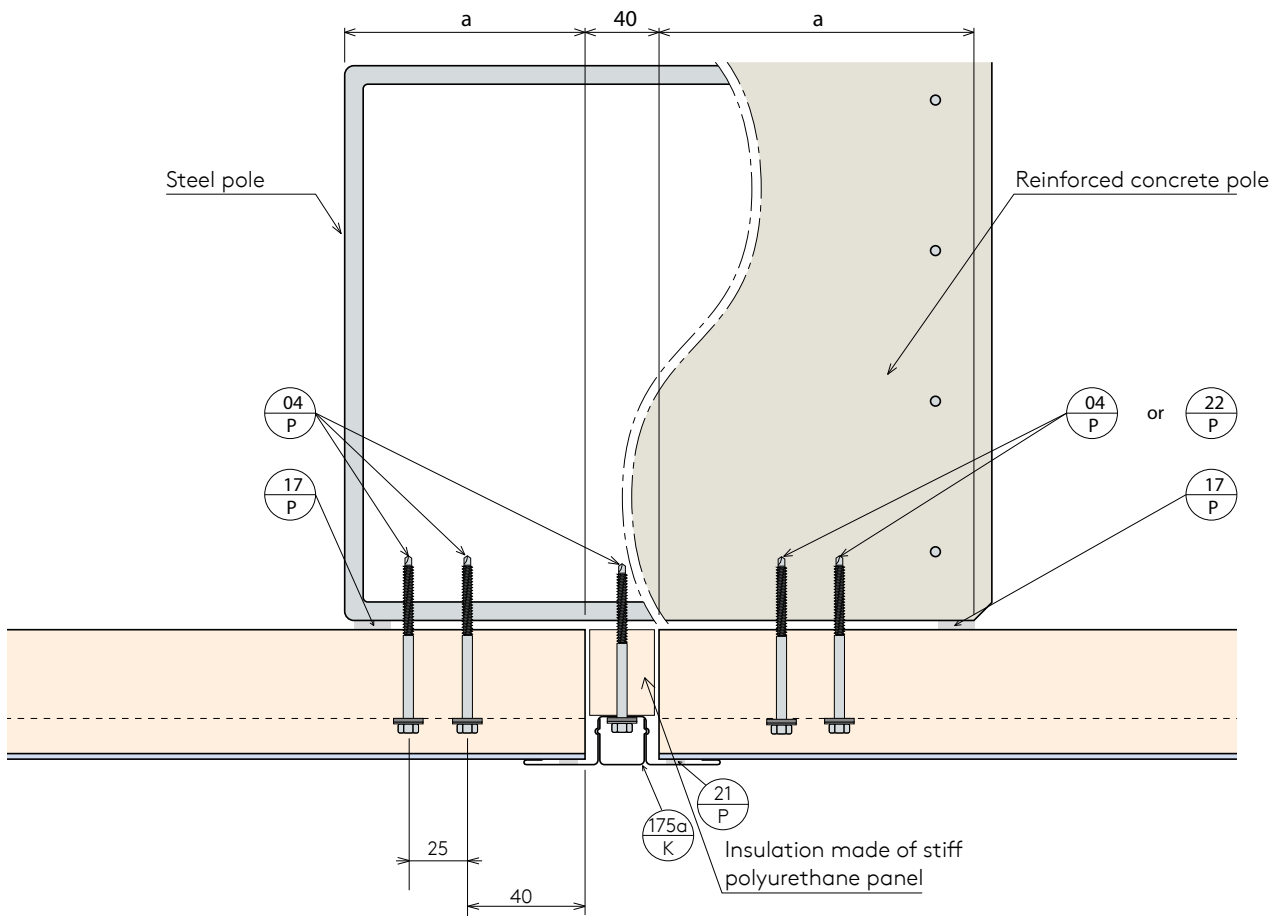
If you want to match the connectors, please consult the graphs showing how to select the right connector from the user manual for designers and assemblers or contact the Kingspan Technical Department.

If you want to properly fix the panel to the structure, keep the connector perpendicular when you set it. Consequently, it is recommended to use specialist screwdrivers equipped with a head for driving long connectors.

If you want to avoid distorting the lock or the cut edge of the panel, fix the screws at a distance of 50 mm from the joint of the lock or the edge of the cut panel. The following panels with covert fixing are exceptions: KS1000 AWP, KS1000 AT and KS1000 RH, in which the screws are only fixed in the assigned lock sockets (see Picture 43)

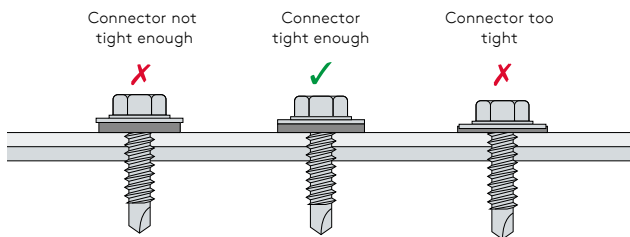


Picture 46. Recommended distance for setting the screws in the panel lock.



Picture 47. Recommended distance for setting the screws in the cut edge of the panel.

The torque with which you should turn the screws is not established, because the hardness of each structural element may be different and therefore the torque required to tighten the connectors properly may differ too. The proper assembly of screws is established by observing the flash on the screw gasket. You may upset and slightly bend the gasket but it must not lead to the full flash. Proper flash of the gasket is shown on Picture 48.



Picture 48. Incorrect and correct assembly of connector

If the connector is fixed correctly, it will cause the outer sheet of the sandwich panel to bend slightly. However, the bend in the connection area should not exceed 2 mm.

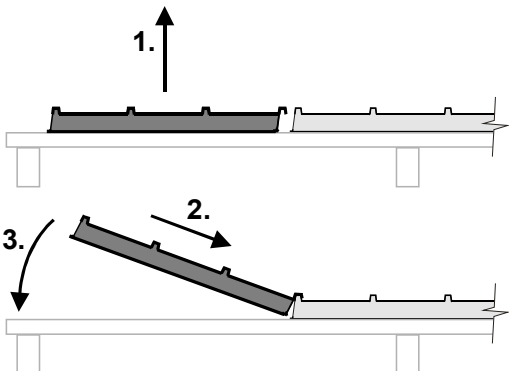
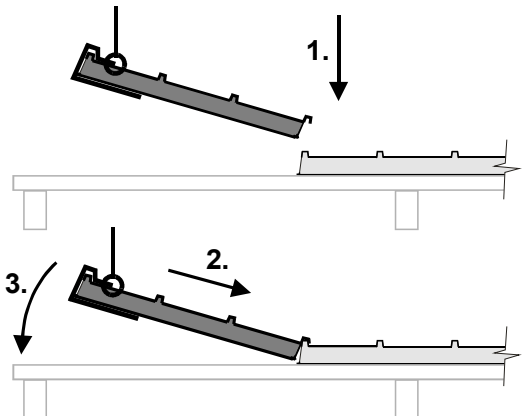
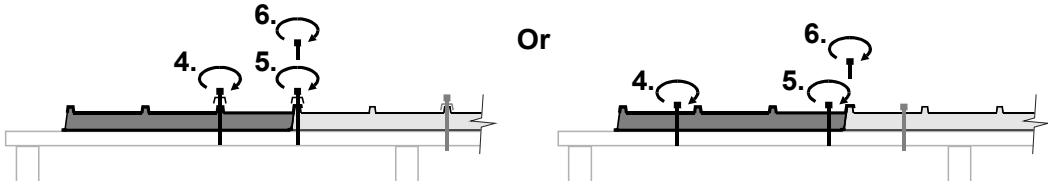
### 3.9 IMPORTANT INFORMATION FOR DESIGNERS AND ASSEMBLERS

- Proper planning of the respective structural elements (edges, continuous elements forming architectural accents in various colours, continuous stretches of window frames etc.) at the stage of architectural design can make the assembly and the degree of detail complexity much easier and therefore result in a lower risk of probable errors and failures.
- You are advised to assemble the panels in accordance with the order of the serial number of the packet. It will help you keep the colour continuum between the beginning and the end of manufacturing.
- You should always assemble the panels and the flashing in accordance with the direction of manufacturing. Rotating the element by 180° will automatically distort the colour continuum at the point of connection between the given element and the overturned element. The colour continuum will also appear at the point of connection with the panel that was fixed in accordance with the direction of manufacturing.
- When you work in a large area, as you progress, you need to frequently update the assessment of the colour continuum from a distance of 25 m or more. The farther you are from the object under assessment, the better you can notice even the slightest discrepancies in the colour continuum. If you assemble panels with metallic coloured lining, you should make the assessment as often as possible from as many different angles as possible. We also recommend that you remove the protective foil as soon as possible to make your assessment more accurate.
- Due to the complexity of technological processes, the manufacturers of organically coated sheets cannot guarantee that the colour continuum will be kept throughout all the successive orders. If the problems concerning the colour discrepancies are to be avoided and the colour uniformity of the sandwich panel lining is to be kept, the Buyer, before signing the contract of sale, should determine with Kingspan in written form, which part of the order/contract concerns deliveries for one construction. If the agreement is established, Kingspan undertakes to fulfil the order from one batch of stock material. Otherwise, Kingspan may not be liable for possible discrepancies in colour. If in doubt, do not hesitate to contact our Commercial Department.

3.10 ASSEMBLY OF ROOF PANELS

- Every third packet with panels contains an abridged version of assembly instructions. You must read the instructions carefully before you begin to assemble roof panels.

**KS1000 RW - Assembly Guideline**  
For more details click on [www.plyty-warstwowe.kingspan.pl](http://www.plyty-warstwowe.kingspan.pl) or check Technical Catalogue

<p><b>A. Manual assembly</b></p> 	<p><b>A. By crane</b></p> 
<p><b>B. Fixing</b>        Over each support: number of fasteners subject to individual calculation.   At 20-50cm</p>	
	

Picture 49. Abridged version of the instructions on how to assemble roof panels KS1000 RW added to the panel packets.

The roof panels contained in the packet are placed alternately with the humps up and down in order to maximise the use of the loading room in the lorry and minimise the cost of transportation. Therefore, when you take the successive panels out of the packet, you should turn over every other panel with the help of a vacuum machine (e.g. ViaVac RotaBoy) or by hand. You must turn over the panels carefully so as not to damage the empty trapeze of the panels - lengthwise hem.

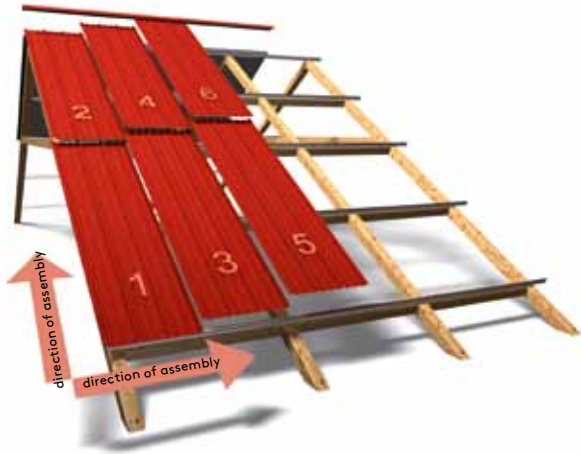
When you take the panels out of the packet, you should use a spreader beam if the panels are longer than 6 m.

You should arrange the panels in the right order to avoid the "wear" of the panels in the later stages of assembly and to match the panels more easily (see Picture 53)

KS1000 X-dek™ INSTALLATION METHOD	
Instannation Guide and detailed information available in Kingspan Technical Department	
KS1000 X-dek™ steel/steel (XD)	
<p>A. Preparing preliminary wholes in free crown.</p>	<h1 style="font-size: 2em; margin: 0;">det 5</h1>
<p>B. Installation manual or using rota-boy</p> <p>1. - butyl rubber sealant site applied (delivered by others)</p>	
<p>C. Main fixing and side lap stitching</p> <p>4. - main fixing 2 pcs every wave</p> <p>5. - stitching scerws between supports at 500 mm or 1000 mm centers (depending on requirements)</p>	
<p style="text-align: center; font-weight: bold; font-size: 1.2em;">det 5</p> <p>CAUTION: side lap stitching should be performed right after mainfixing of each panel</p>	
<p>D. Watertight layer applied on site</p> <p>6. - PVC, EPDM or bitumin membrane (delivered by others)</p>	

Picture 50. Abridged version of the instructions on how to assemble roof panels KS1000 X-dek™ found on the packet of the panel.

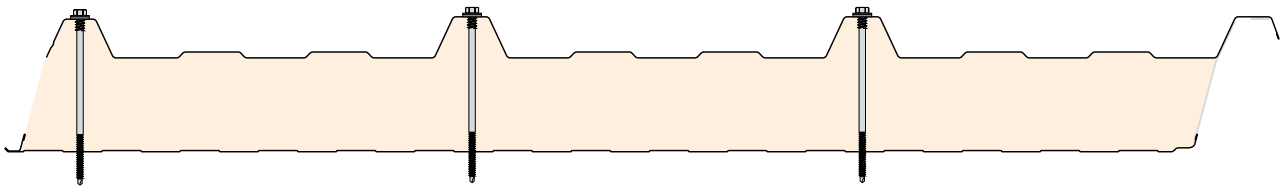




Picture 51. Direction and order of the assembly of roof panels.

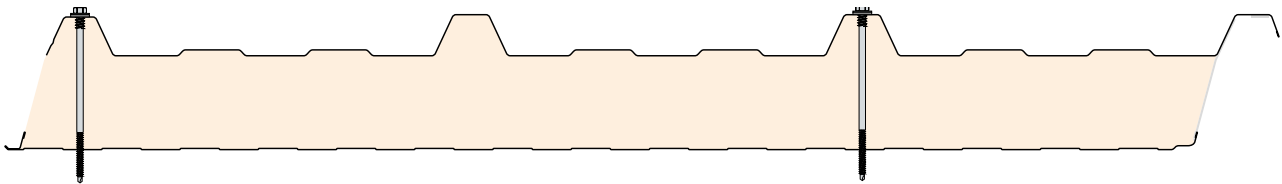
If you work on a roof support structure, you should fix the P17 gasket (sealing tape PE 20x5 mm) to level the effects of the panel work and ensure windproof insulation.

- Before you assemble the panels, remove the protective foil from the outer sheets of the panels or tear off the foil at the point of contact with the purlins.
- The panels are initially fixed with a single connector to the purlins below the roof ridge, then beside the eaves and to the remaining purlins. When it comes to the first of the purlins beside the roof ridge, the screws fixing the panel are fixed in the trough of the trapeze (see Picture 58).
- Before you leave the construction site, do not forget to assemble all the required connectors that fix the panel to the structure.
- The panels in the edge zones are fixed to the structure (the purlin) with three or more connectors in the upper part of the panel trapeze - on the hump of the trapeze. The precise number of connectors is calculated by the construction designer.



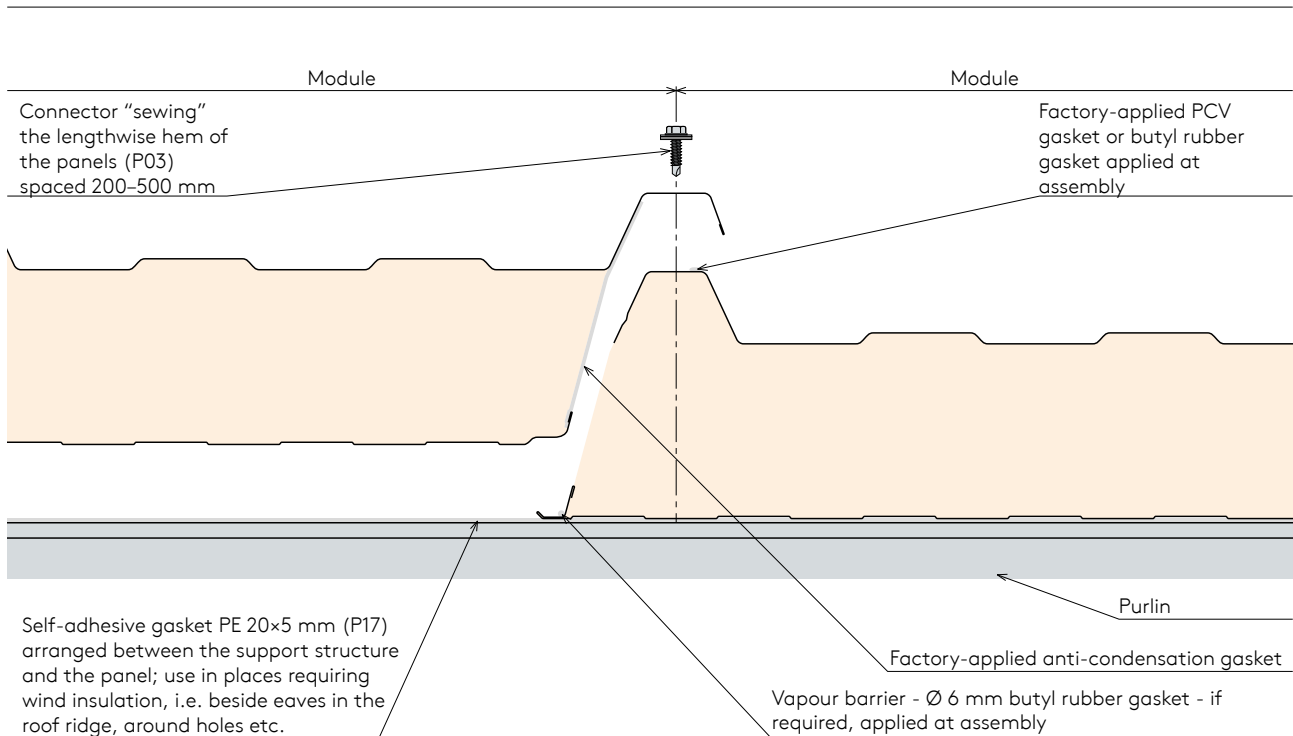
Picture 52. Arrangement of connectors in the KS1000 RW panel (edge zone).

- The intermediate panels are fixed to the structure (the purlin) with two connectors. The number of connectors should be consulted with the construction designer



Picture 53. Arrangement of connectors in the KS1000 RW panel (normal zone)

- If you fix roof panels, always use screws that are compatible with the material of the support structure, in accordance with the guidelines specified in the construction design.
- You should use an additional self-drilling connector (P03) on the lengthwise hem for the panels spaced every 200-500 mm or in accordance with the construction's technical design to sew the roof panels along the lengthwise hem (see Picture 56).



Picture 54. Sewing the hem of the KS1000 RW panel with an additional P03 connector on the lengthwise hem of two panels

- If you want to set the P03 connectors, you are advised to use a common screw-driver (with adjustable pressure force). Due to variable load in the normal zone and the edge zone, the final number of connectors is decided on by the construction designer of the building project
- The Ø 6 mm butyl rubber gasket on the inside of the lock is fixed, for example, in buildings with high humidity in accordance with the guidelines provided below.

Intended use of building	Relative humidity and indoor temperature			Standard humidity Insulating joints of side panels
	15°C	20°C	25°C	
Storerooms, warehouses	<50%	<35%	<25%	
Offices, shops and most of the retail outlets	50-65%	35-50%	25-35%	
Buildings for few users	65-80%	50-60%	25-45%	
Buildings for numerous users (e.g. sports halls, kitchens)	80-95%	60-70%	45-55%	
Higher humidity in buildings (special purpose buildings, e.g. swimming pools, laundries, breweries)	>95%	>70%	>55%	

Picture 55. Recommended range of insulation use for internal lock in roof panels

- Minimum slope of roof made of Kingspan KS1000 RW sandwich panels with QuadCore®, IPN is:  
 >4° (7%) for roofs with continuous panels without lengthwise connection and without skylights.  
 >6° (10%) for roofs with panels with lengthwise connection or skylights.
- Minimum slope of roof made of Kingspan KS1000 FF sandwich panels with K-Roc® mineral wool core is:  
 >5° (8.5%) for roofs with continuous panels without lengthwise connection and without skylights.  
 >8° (14%) for roofs with panels with lengthwise connection or skylights.
- Minimum slope of roof made of Kingspan KS1000 X-dek™ sandwich panels with QuadCore®, IPN is:  
 >1° (2%) for roofs covered with waterproofing PCV, TPO, TPF.  
 >2° (3%) for roofs covered with bituminous waterproofing.

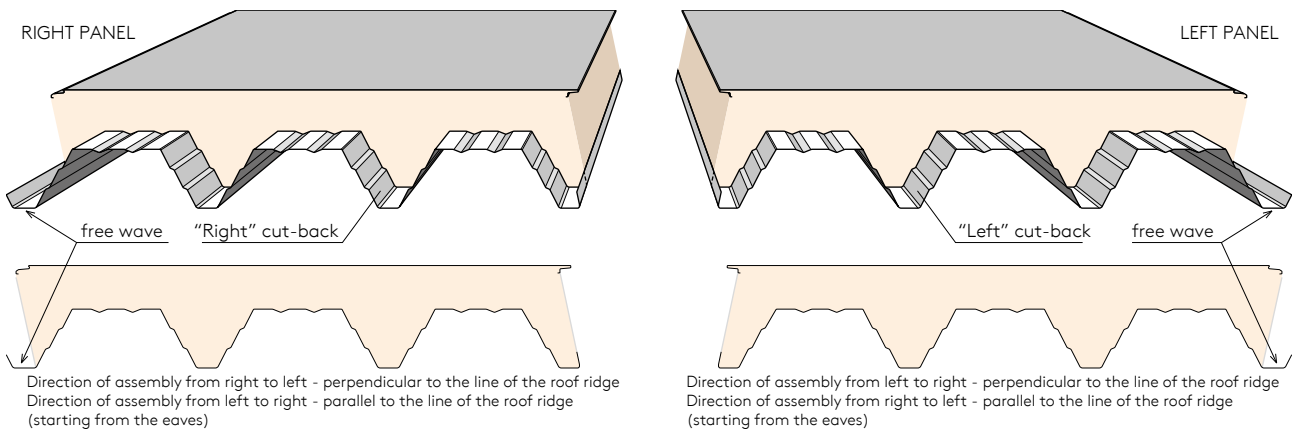
Roof panels with the foam QuadCore® or IPN always have undercutting, i.e. a trapezoidal sheet longer than the core of the panel and “protruding” beyond the outline of the panel at

one end. The undercutting enables tight crosswise connection and correct assembly of the system gutter in the eaves. The undercutting may have the length of 50 mm to 630 mm, graduated every 10 mm. Standard undercutting for the KS1000 RW panels is 50 mm for eave panels and 250 mm at the crosswise connection of the panels. In the case of the KS1000 X-dek™ panels, the standard undercutting is 50 mm.

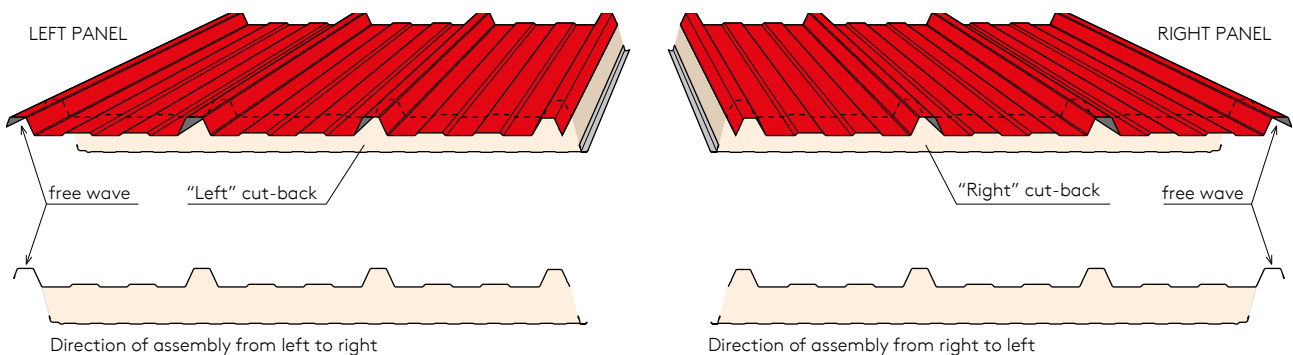
The appearance of the undercutting determines the direction of assembling the roof surface. There are two types of undercutting: left and right; the differences between them are shown in the pictures below.

**Minimum widths of roof supports.**

Each time, check if the width of the support corresponds with the one specified in the design. When you choose the width of the support, consider the notes contained in the charts describing the load capacities of the panels or in the software for an individual calculation of the load capacities in sandwich panels, e.g. SandStat.

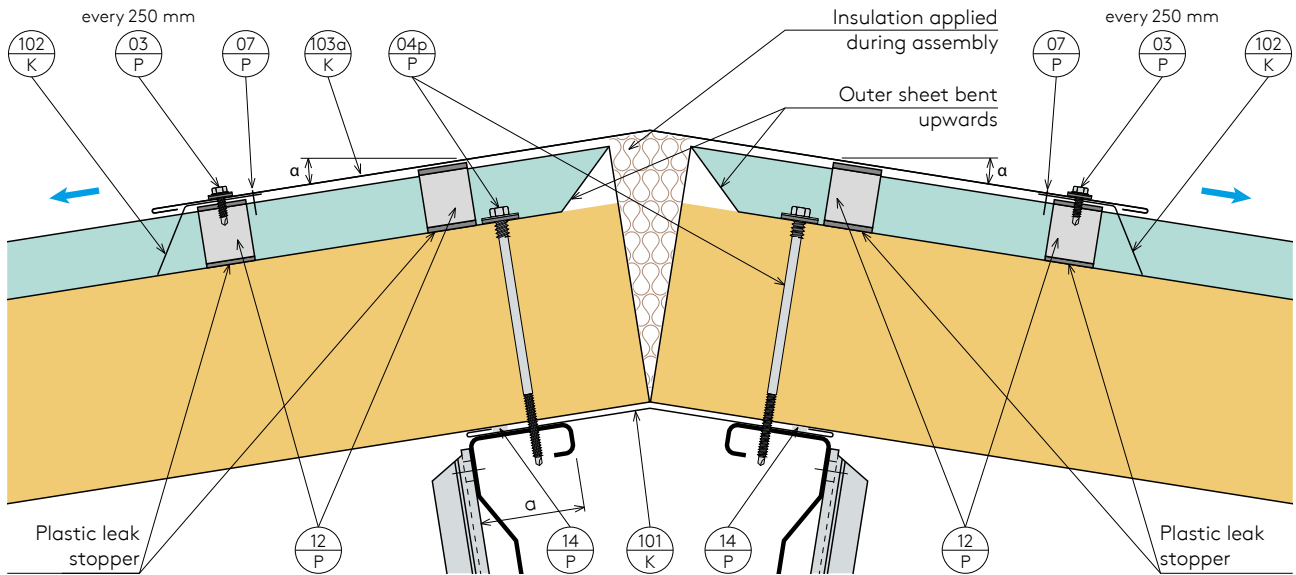


Picture 56 Left undercutting and right undercutting on the KS1000 X-dek™ panels (details in the X-dek™ panel assembly instruction manual)



Picture 57. Left and right undercutting on KS1000 RW panels.

### 3.10.1 Roof ridge



Picture 58. Roof ridge - detail

After you assemble the Kingspan roof panels, you should:

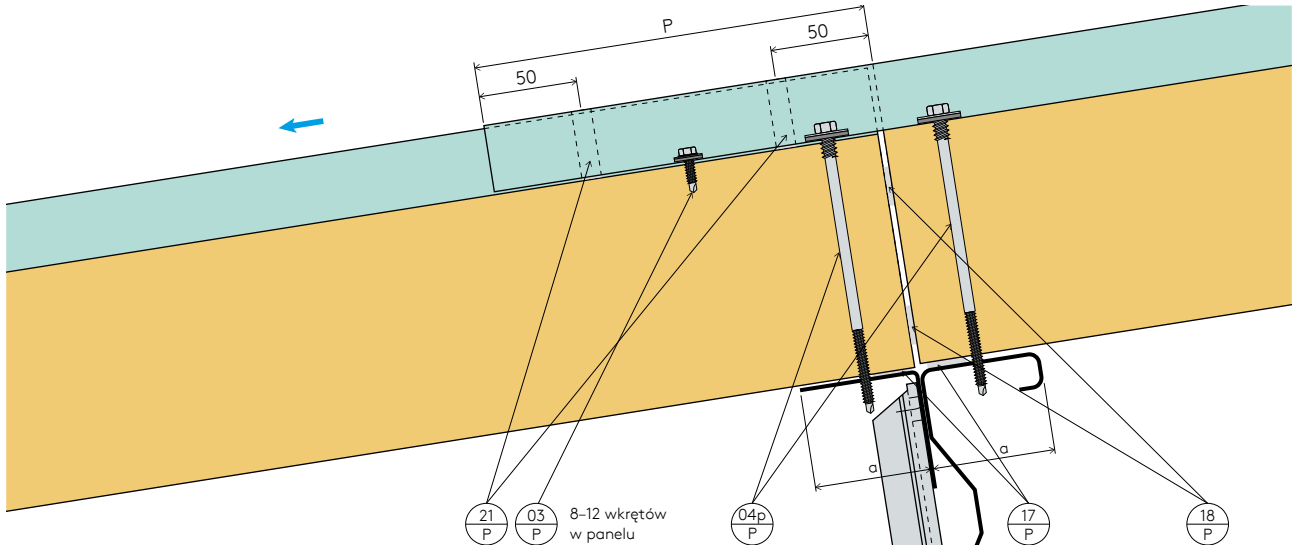
- Bend upwards the ends of the outer trapezoidal sheet.
- Tape the P14 gaskets (sealing tape PE 9x3 mm) and rivet the dressing of the inner roof ridge K101 between the roof ridge purlins if it was not fixed before the panels were laid.
- Fill the empty space between the panels with stiff foam or polyurethane assembly foam. After the foam has hardened, trim the unnecessary flash. If it needs to be fire-resistant, the empty space should be filled with soft mineral wool or fireproof assembly foam (in accordance with design requirements and fire-fighting regulations).
- If you have roof panels with the K-Roc® mineral wool core, you should fill the panel contact at the core thickness with

mineral wool.

- Tape the P12 polyethylene comb gasket in the shape of trapeze of the RW or FF panels with the help of the roof work leak stopper on both sides of the roof ridge. The number of gaskets depends on the roof slope:  
 $\leq 10\%$  - 4 pcs/mb  
 $> 10\%$  - 2 pcs/mb
- Assemble the comb dressing K102 to the panel humps with P08 rivets. It will protect the P12 gaskets against adverse weather conditions and birds.

Use P03 connectors or P08 leakproof rivets to fix the outer dressing of the roof ridge K103a to the panel edges.

### 3.10.2 Crosswise connection of panels



Picture 59. Crosswise connection of roof panels - detail.

The length of undercutting on the lengthwise hem of the panels is 250 mm.

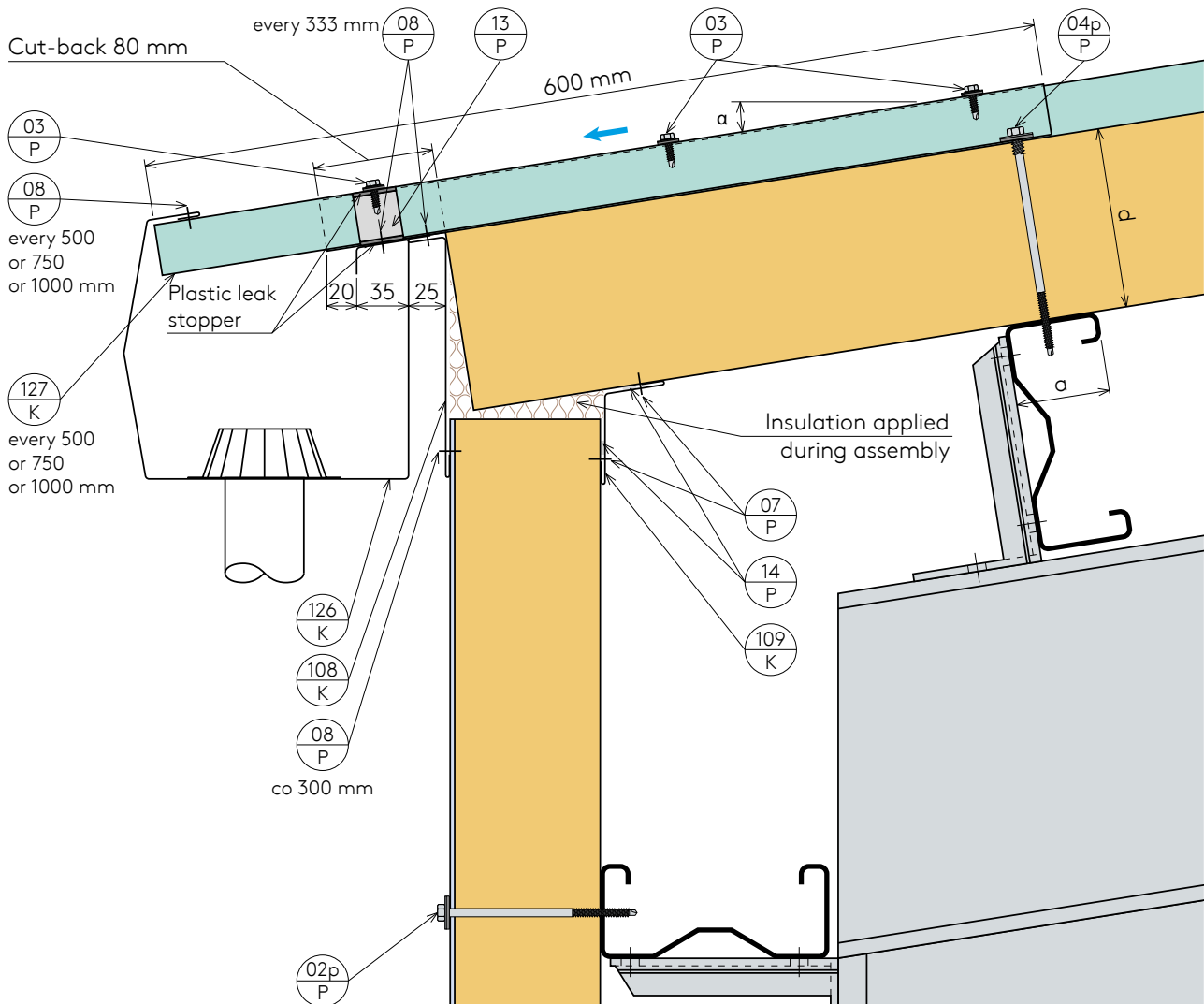
Crosswise connection appears if “lengthening” of the panel is required. In order to make the above connection properly, you should:

- Check if the width of the purlins, where both panels are going to be supported, is sufficient and if both panels will have the required width of support, in accordance with the charts showing load capacity.
- If the support is too small, consult the designer and add a structural element to widen the plate.
- Remove the protective foil to prepare the panels for assembly.
- Tape the P17 gaskets (sealing tape PE 20x5 mm) on the purlins.
- Provisionally, fix the eave panel to the point of crosswise connection, where the P04 main screws should be fixed to the purlin before the connection.
- Fix the P18 gaskets (expansion tape PU 20x4 mm, after expanding 20x20 mm) to the front of the panel.
- Assemble at least two rows of the P21 gasket (butyl rubber tape 10x3 mm) across the panel with the distances shown in the picture.
- Assemble another panel between the connection point and the roof ridge.
- Bolt both panels at the connection point with the help of the P04 main screws and sew the hem with the P03 sheet screws alternately.

### 3.10.3 Eaves

You should assemble the eaves from the Kingspan roof panels in the following way:

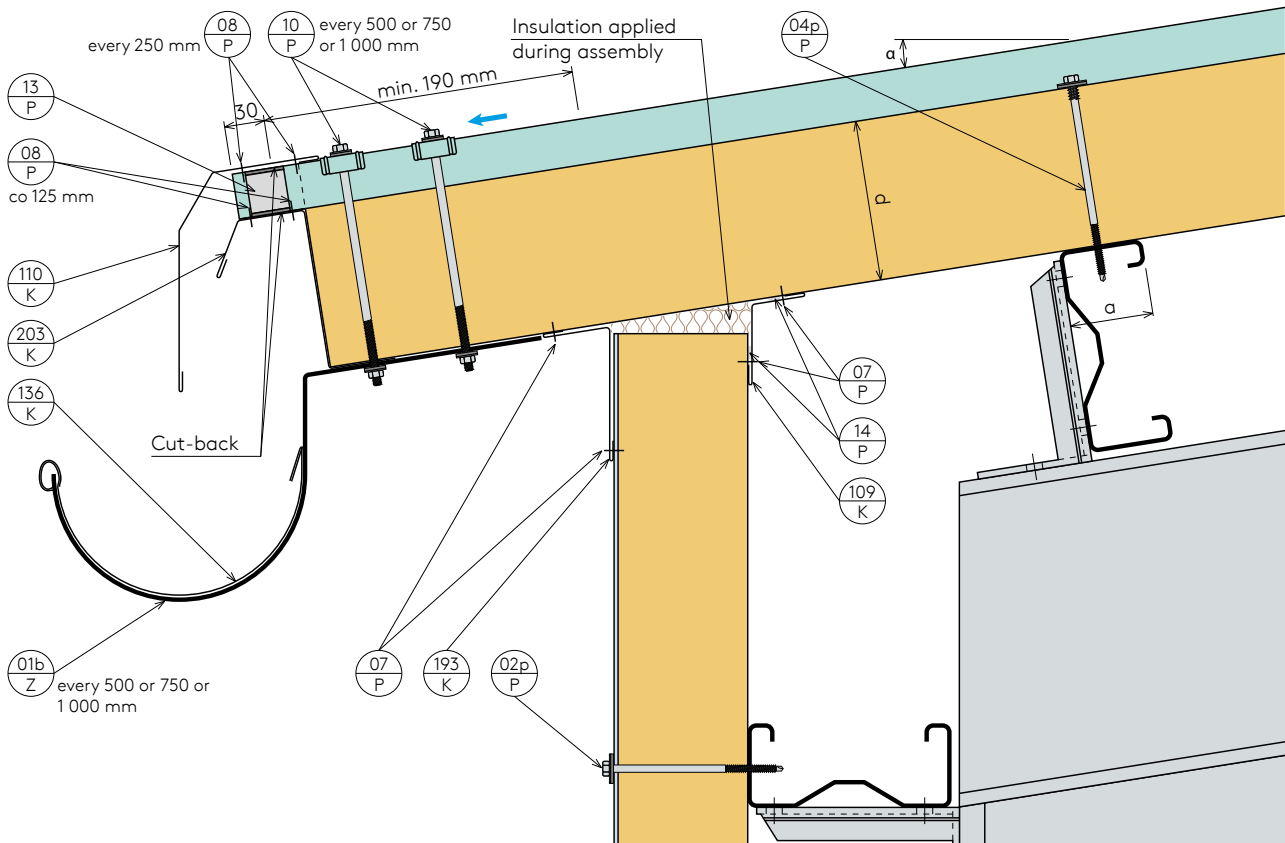
Variant I: Kingspan polygonal steel gutter:



Picture 60. Kingspan polygonal gutter on the roof - detail

- To ensure that water is removed from the roof surface effectively and the eaves panels are assembled correctly, read the appropriate instructions: „Kingspan Polygonal eave gutters - assembly instruction manual“
- Before you begin to assemble the gutters, you should assemble the K108 dressing (Outer concave angle) to mask the connection between the roof and the wall. After the gutter has been installed, the access to the point of
  - K108 dressing assembly will be very limited and can make assembly impossible. You should use P08 leakproof rivets or P03 screws to fix the dressing to the panels.
  - You should carry out the further stages of assembly in accordance with the gutter assembly instructions.

Variant II Kingspan semi-circular steel gutter:



Picture 61 Kingspan semi-circular gutter on the roof - detail

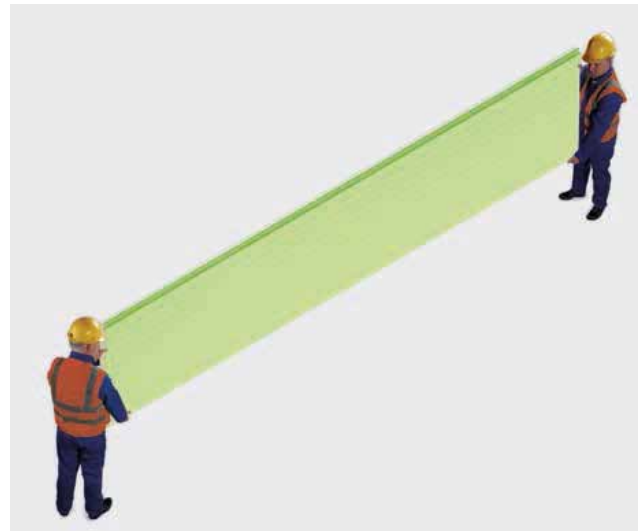
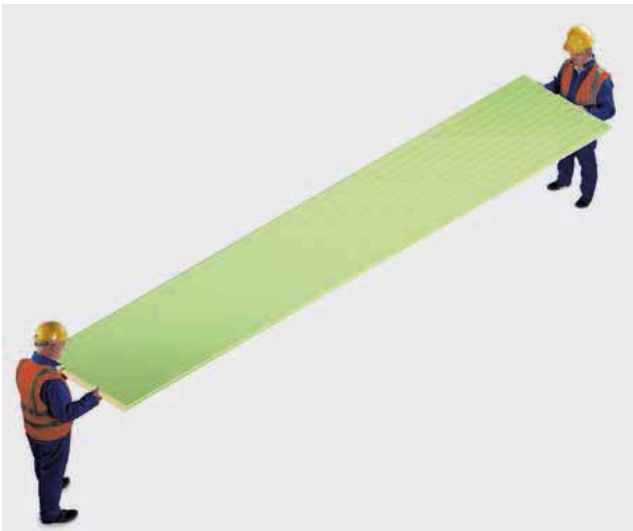
To ensure that water is removed from the roof surface effectively, the panels in the eaves should be finished off with the K203 gutter drip cap and the K110 eave dressing before the assembly of the gutter.

- Tape the P13 gasket (inside filler of the trapezoidal profile for RW, FF panels) into the humps from below to fill up the trapezes.
- Use P08 leakproof rivets to assemble the K203 gutter drip cap. At the same time, hem the dressing at least 5 cm in length and seal the hem with roof work compound, e.g. Butyrub.
- Rivet the K110 dressing with the help of P08 rivets from above to the panel trapezes so that the water can freely flow between the K203 and K110 dressing.
- Fix gutter hooks to the panel to ensure that the gutter drops in the proper manner.
- Put the K136 steel gutters into gutter hooks.



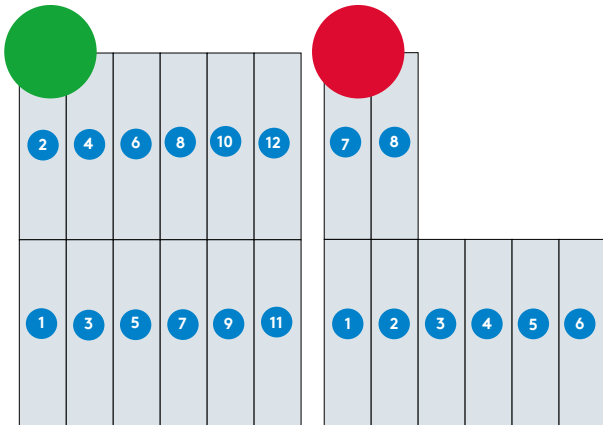
### 3.11 ASSEMBLY OF WALL PANELS

- The most practical way to assemble Kingspan wall panels is to use a hoisting crane and vacuum grabs (e.g. ViaVac) or self-locking handles.
- To unload the panels, prepare the right length of the lifting sling and a spreader beam (if the panel is longer than 6 m) corresponding with the length of the panel.
- The upper panel in the packet should be pushed out to make it possible to fix a tool for lifting the panels.
- Lightweight panels can be taken out of the packet and laid on the wall by hand, but remember that they should be transported to the place of assembly in the "on end" position.



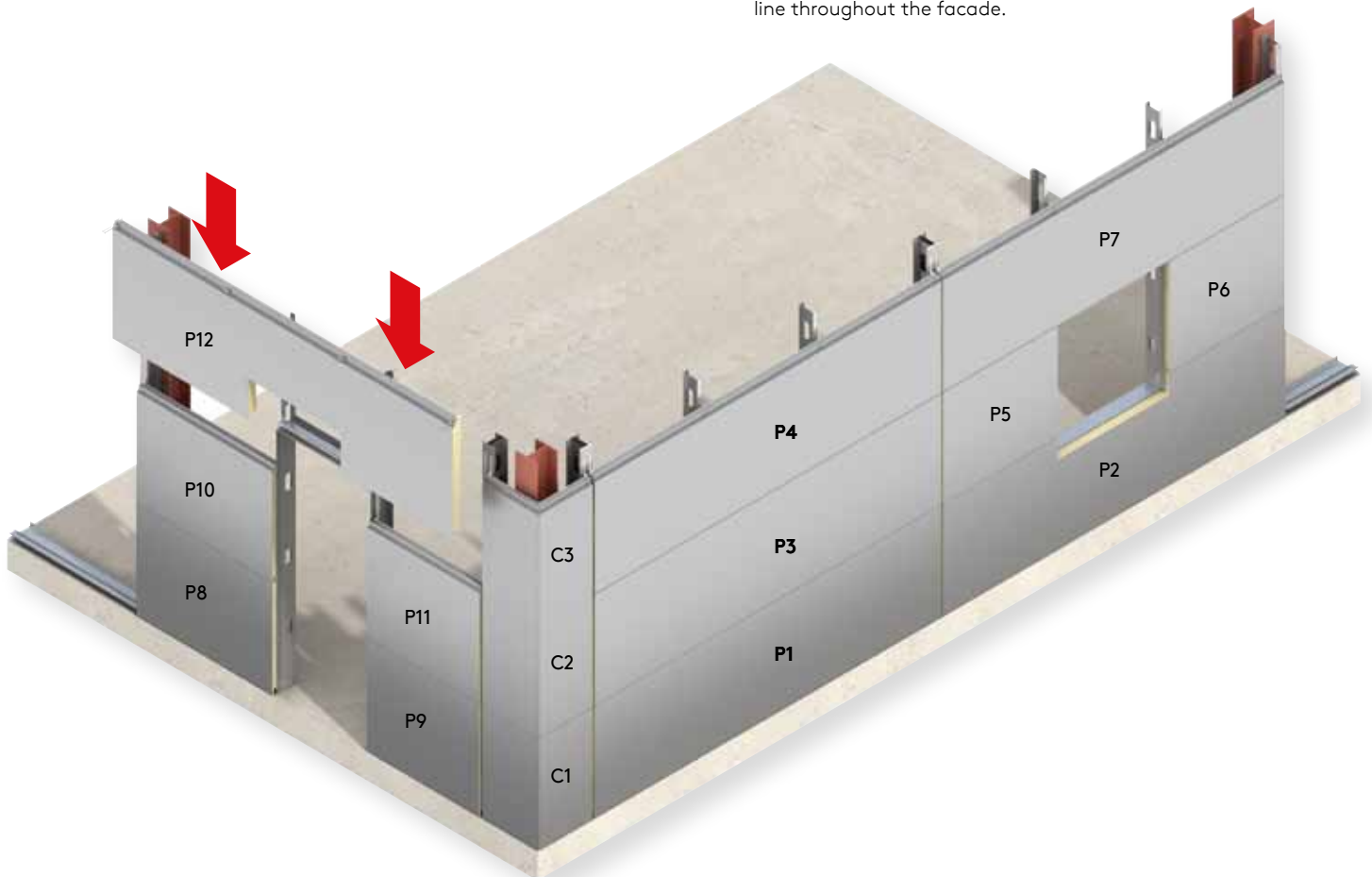
Picture 62. Incorrect carriage of panels (left) and correct carriage of panels (right).

- Before assembling the panels, remove the protective foil from the inner lining and lay thermal insulation on the ground sill beam.
- Place the pedestal dressing on the thermal insulation and, provisionally, fix it to the ground sill beam. The shape and width of the dressing depends on the thickness of the panel, the width of the ground sill and the type of the ground sill detail.
- If the panels are laid vertically, set the extreme panel to the perfect vertical with the help of the level line and only then fix the panel together with the drip cap.
- If you use a horizontal layout of the panels in relation to the ground sill beam, fix a levelled starting profile and a drip cap. Next set the panel on the starting profile and level it.
- Precise setting of the first panel will help avoid the so-called "stepping" factor on the successively assembled panels.
- It is recommended to have the proper order of the assembly to avoid the undesired aesthetic effects, such as different sizes of joints or, in the horizontal arrangement, the failure to match the horizontal joint.



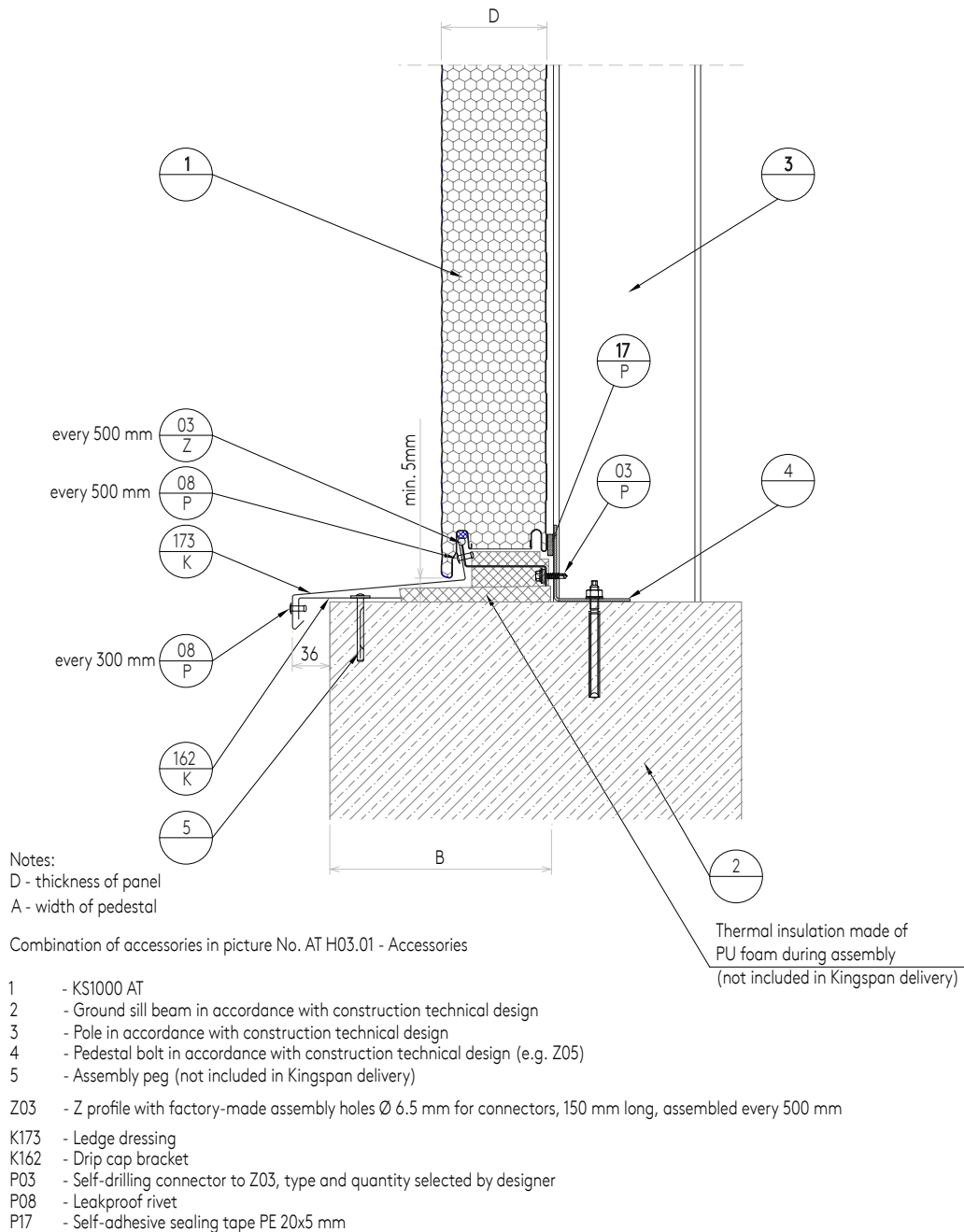
Picture 63. Correct (left) and incorrect (right) order of assembling the wall panel in vertical arrangement.

- We use the tongue and groove connection to speed up the assembly of the successive panels.
- In order to ensure the right leakproofness of the panels' lengthwise contact, tighten the elements together without damaging the panel edges. It can be done by hand, with the help of a wooden cap on the lock through pressing or tight fitting. It is acceptable to use belts or clams with bolts.
- After laying the panels, it is important to tighten the gaskets (min. 30%) or force the panel cores to stick together as tightly as possible.
- If the wall panels with the K-Roc mineral wool core panels do not have a factory-made gasket in the lock, it is acceptable, before fixing the panels to the structure and after consulting Kingspan, to apply sealing butyl rubber compound in the lock of a panel from the outside and the inside.
- Keep the horizontal and vertical contacts of the panels in line throughout the facade.



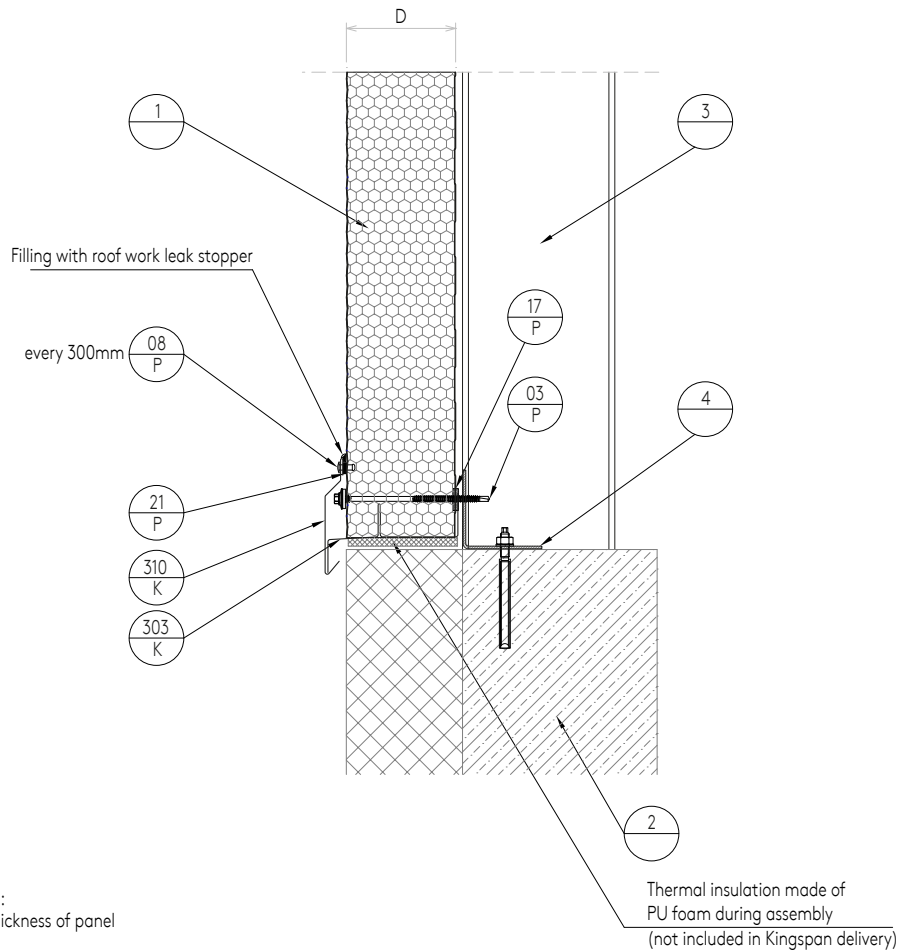
Picture 64 Correct order of assembling the wall panel in horizontal arrangement.

## 3.11.1 Ground sill



Picture 65. Detail, ground sill - protruding pedestal

The ground sill may have several different solutions depending on whether the ground sill pedestal protrudes beyond the light of the panels or is tiled or even recessed. Furthermore, the dressing of the ground sill differs depending on whether the panels are arranged vertically or horizontally.



Notes:  
D - thickness of panel

Combination of accessories in picture No. AT H03.04 - Accessories

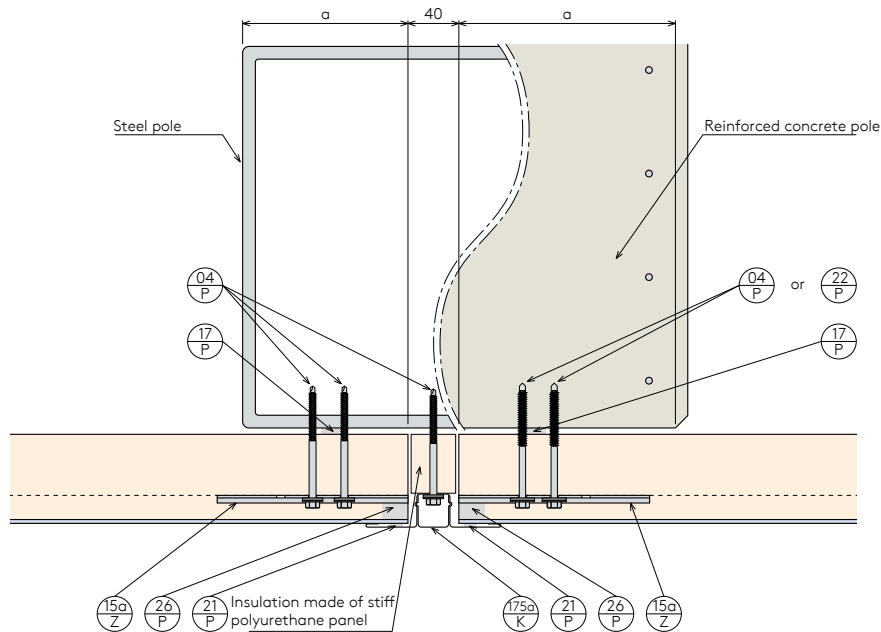
- 1 - KS1000 AT
- 2 - Ground sill beam in accordance with construction technical design
- 3 - Pole in accordance with construction technical design
- 4 - Pedestal bolt in accordance with construction technical design (e.g. Z05)
- K302 - Dressing masking the screw
- K303 - Ledge dressing of cut panel
- P03 - Self-drilling connector for sandwich panels, type and quantity selected by designer
- P08 - Leakproof rivet
- P17 - Self-adhesive sealing tape PE 20x5 mm
- P21 - Self-adhesive butyl rubber sealing tape 10x3 mm

Picture 66. Detail, ground sill - recessed pedestal

Current details of the ground sill solution are available on the website as .dwg details.

For each solution, check the straight line of the ground sill beam. Special care must also be taken with regard to the order of assembling the gaskets, thermal insulation and flashing as correct assembly in the reverse order might not be possible.

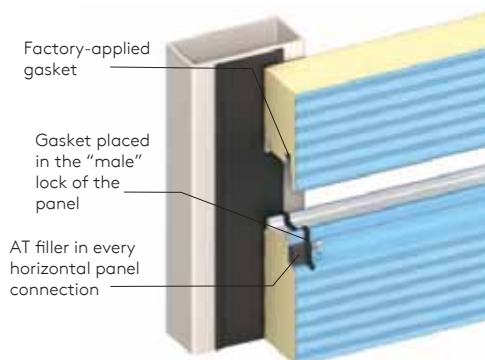
### 3.11.2 Pole contact (for horizontally laid panels).



Picture 67. Panel contact on pole - detail

If you use panels assembled horizontally, the panel contact on the pole should be insulated and shielded against adverse weather conditions.

- The vertical gap between the fronts of the panels should be at least 20 mm and if you use the K175 Top-hat dressing - minimum 40 mm.
- The gap should be filled with thermal insulation in the form of mineral wool for premises that require fire resistance or with stiff foam or assembly foam precisely cut out after hardening to fix the other elements.
- You should assemble the P21 gaskets (butyl rubber sealing tape 10x3 mm), which are located between the panel and the flashing. Instead of the P21 gasket, you may use one row of permanent plastic roof work compound, e.g. butyl

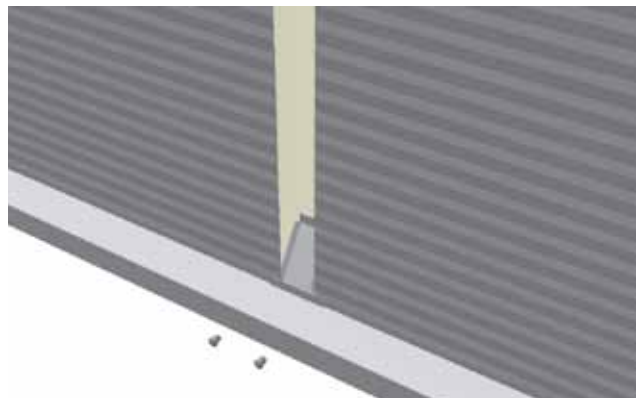
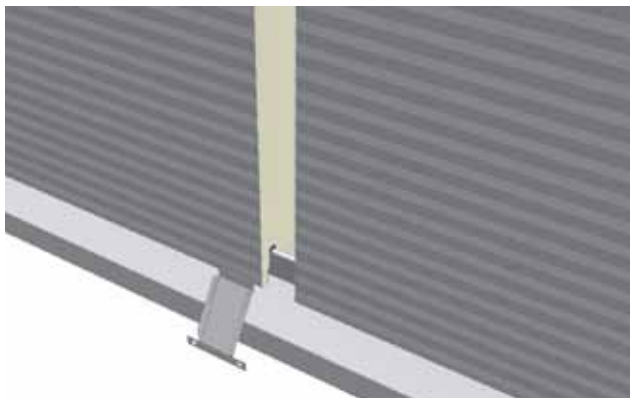


Picture 68. Sealing the lock at the panel end

- If you use the K175 Top-hat dressing on premises with a huge risk of heavy rain and blustery wind, you must seal the lock of the panels along 40 mm from the panel front with the help of a foam gasket and roof work leak stopper (e.g. butyl) so that the water may not be pushed by the wind under the wings of the dressing.
- Install the K255 dressing, i.e. a channel directing the water away from the Top-hat dressing. If required, bend the edges of K255 so that it perfectly fits into the space between the panels.



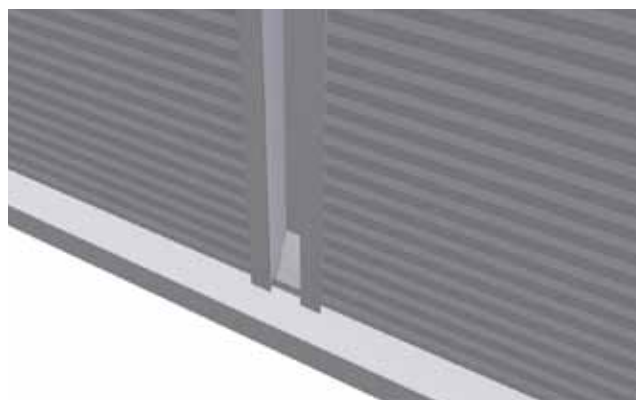
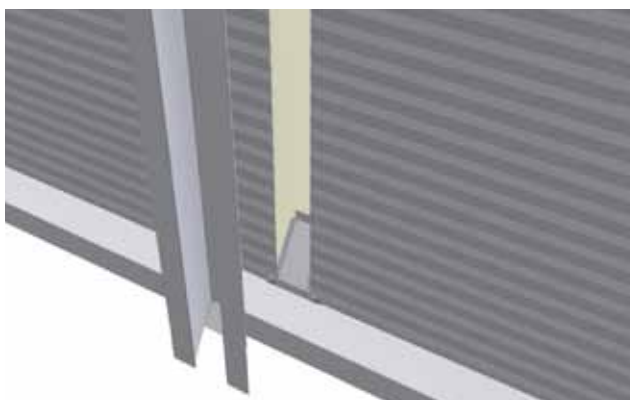
Picture 69. Drainage channel for K175 Top-hat dressing (bottom) and sample installation point (top)



Picture 70. Stages of assembling the drainage channel for K175 Top-hat dressing - assembly of K255 dressing.

- You should assemble the base of the K175 Top-hat dressing in the shape of "Omega" for the support structure with the help of bolts used for fixing the panels.

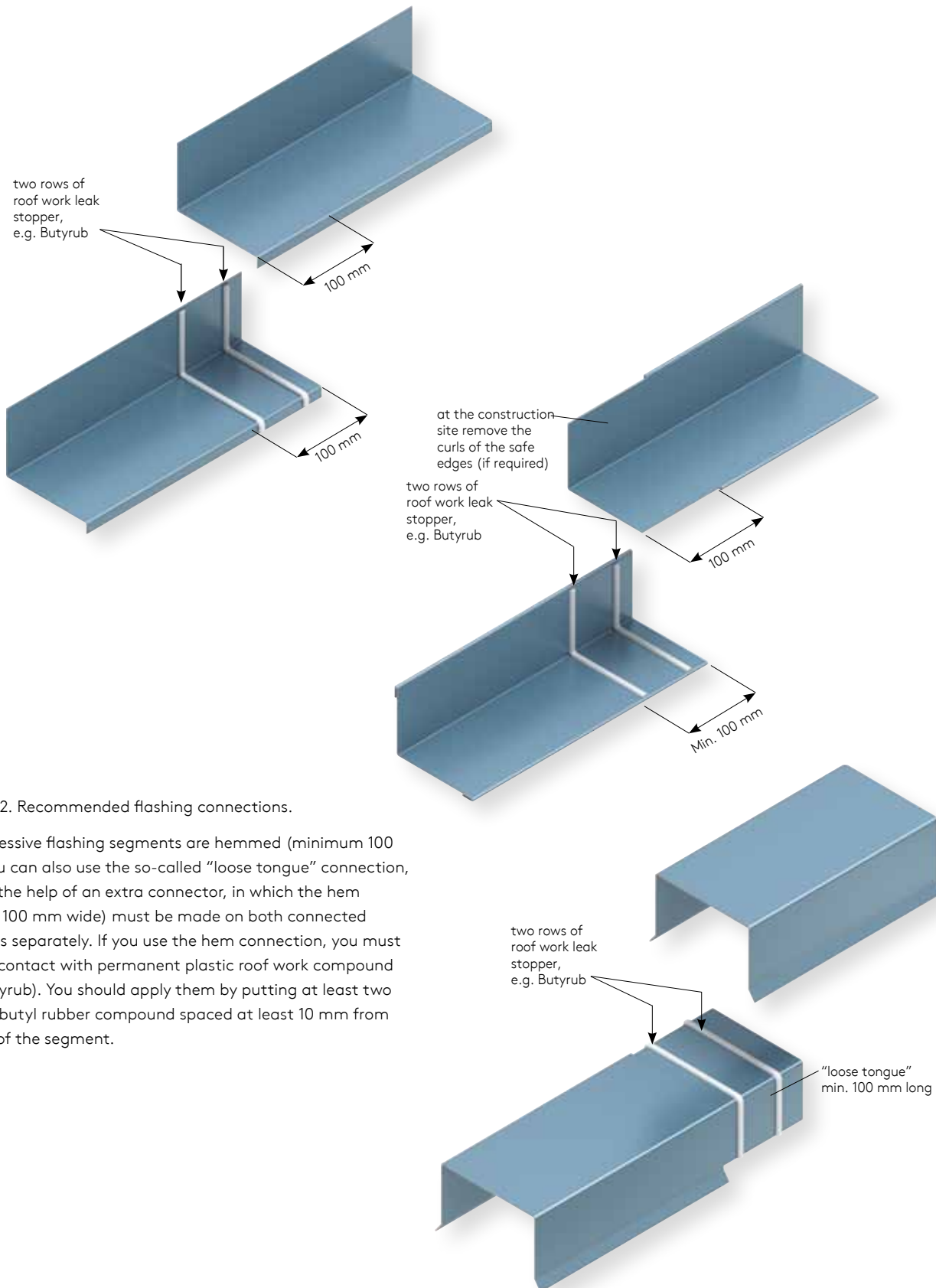
**Note! The Omega must be cut and slid home to make it compatible with K255 channel.**



Picture 71. Stages of assembling the drainage channel for K175 Top-hat dressing - assembly of K175 dressing

- Mask the screws by using the C-shaped clip. The "omega" profile base should be bent so that it corresponds with the drip caps in the lintels of the holes and beside the ground sill to make the water flow out freely.

### 3.12 Assembly instructions for flashing



Picture 72. Recommended flashing connections.

The successive flashing segments are hemmed (minimum 100 mm). You can also use the so-called "loose tongue" connection, i.e. with the help of an extra connector, in which the hem (at least 100 mm wide) must be made on both connected segments separately. If you use the hem connection, you must seal the contact with permanent plastic roof work compound (e.g. Butyrub). You should apply them by putting at least two strips of butyl rubber compound spaced at least 10 mm from the end of the segment.

#### 4. DIFFERENT COLOUR GROUPS

The different colour groups shown below are based on thermal loads affecting the sandwich panel casing. During exposure to sunshine, the outer steel lining gets hot faster when the colours are dark.

Large temperature differences ( $\Delta t$ ) between the outer lining and the inner lining create thermal tensions that affect the performance of the sandwich panel attached to the structure. These tensions always cause the panel to bend into the shape of an arch towards the heated sheet, but they also make the surface ripple or, in extreme cases, badly damage the panel on the intermediate support. In the PN-EN 14509 norm: 2013, which describes the requirements for sandwich panels, the colours were divided into 3 groups: very light, light, dark. The temperature value of the outer lining is determined depending on the category of a given colour and is the following:

- +55 °C for very light colours, (group 1)
- +65 °C for light colours (group 2)
- +80 °C for dark colours (group 3)

Below are some of the colours from different colour groups:

##### Group I - very light colours:

R1013, R1015, R1016, R1018, R1026, R2007, R6019, R7035, R9001, R9002, R9003, R9010, R9016;

##### Group II - light colours

R1000, R1001, R1002, R1003, R1004, R1005, R1006, R1007, R1011, R1012, R1014, R1017, R1019, R1020, R1021, R1023, R1024, R1027, R1028, R1032, R1033, R1034, R2000, R2001, R2003, R2004, R2005, R2008, R2009, R2010, R2011, R2012, R3012, R3014, R3015, R3017, R3018, R3022, R3024, R3026, R4003, R4005, R4009, R5012, R5014, R5015, R5018, R5024, R6011, R6013, R6017, R6018, R6021, R6027, R6033, R6034, R7000, R7001, R7002, R7003, R7004, R7023, R7030, R7032, R7033, R7034, R7036, R7037, R7038, R7040, R7042, R7044, R7045, R7046, R7047, R8001, R8003, R8023, R9006, R9007, R9018, R9022;

##### Group III - dark colours:

R2002, R3000, R3001, R3002, R3003, R3004, R3005, R3007, R3009, R3011, R3013, R3016, R3020, R3027, R3031, R4001, R4002, R4004, R4006, R4007, R4008, R4010, R5000, R5001, R5002, R5003, R5004, R5005, R5007, R5008, R5009, R5010, R5011, R5013, R5017, R5019, R5020, R5021, R5022, R5023, R6000, R6001, R6002, R6003, R6005, R6006, R6007, R6008, R6010, R6012, R6014, R6015, R6016, R6020, R6022, R6024, R6025, R6026, R6028, R6029, R7005, R7006, R7008, R7009, R7011, R7012, R7013, R7015, R7016, R7021, R7022, R7024, R7026, R7031, R7039, R7043, R8000, R8002, R8004, R8007, R8008, R8011, R8012, R8014, R8015, R8016, R8017, R8019, R8022, R8024, R8025, R8028, R9004, R9005; R9011, R9017;

#### 4.1 GUIDELINES FOR USING PANELS IN DARK LINING

Due to much larger thermal loads in comparison with light colours, the outer lining of dark panels (colour group III) may be distorted and deformed.

While making the design, the construction designer must also consider this fact and, in order to avoid damage to the panels, use a solution that will simultaneously fulfil 3 conditions:

- Select the right means of assembly and static system in accordance with the charts showing acceptable load capacities,
- Limit the maximum length of panels,
- Consider the temperature in which the sandwich panels will be assembled.

##### 4.1.1 Static diagram and means of assembling

With regard to both the wall panels and the roof panels, the assembly system must be verified with the software used for calculating sandwich panels (SandStat) or with load capacity charts, i.e. the correct assembly (static) system must fulfil the SGU and SGN criteria. SandStat allows the input of any static system along with the loads affecting the sandwich panels (permanent, changeable, thermal, wind, snow for roofs and service).

Regardless of the choice of panels according to SandStat or load charts, it is recommended to assemble the dark wall sandwich panels in single-span systems only. The use of multi-span systems may result in the appearance, on the intermediate support, of gentle ripples caused by larger thermal loads. Although such ripples are formally accepted as manufacturing norm, they may be aesthetically unacceptable to the investor, who may complain about them.

##### 4.1.2 Assembly temperature

It is recommended to carry out assembly works in the temperature range from -5°C to +20°C. Carrying out assembly works, especially cutting panels and cutting window and door openings at temperatures below -5°C should not be performed due to the increased fragility of the core. The upper temperature limit is closely related to the insolation and heating of the panels from the sun's rays.

When the panels are installed in conditions of strong sunlight, there is a phenomenon of thermal expansion of the sheets heated in the sun, which results in the bending of the panels, usually towards the sun. This phenomenon is intensified in the case of sheets in dark colors. Very bright colors can be safely installed even at temperatures up to +30°C. On the other hand, sheets in dark colors can get very hot and cause the panels to bend even at a temperature of +10 °C with high exposure to the sun.



In order to correctly install panels deformed as a result of thermal load, turn the panels to the "other" side and allow the second sheet to heat up, which will significantly reduce the panel's deflection

Information on the temperature and installation of panels in dark colors (3rd color group) can be found in point 4.1. Guidelines for the use of boards in cladding in dark colors.

If there is no factory-applied gasket in the panel lock, works with the use of sealing compounds should be carried out at an ambient temperature above 4°C or in accordance with the recommendations of the manufacturer of sealing compounds.

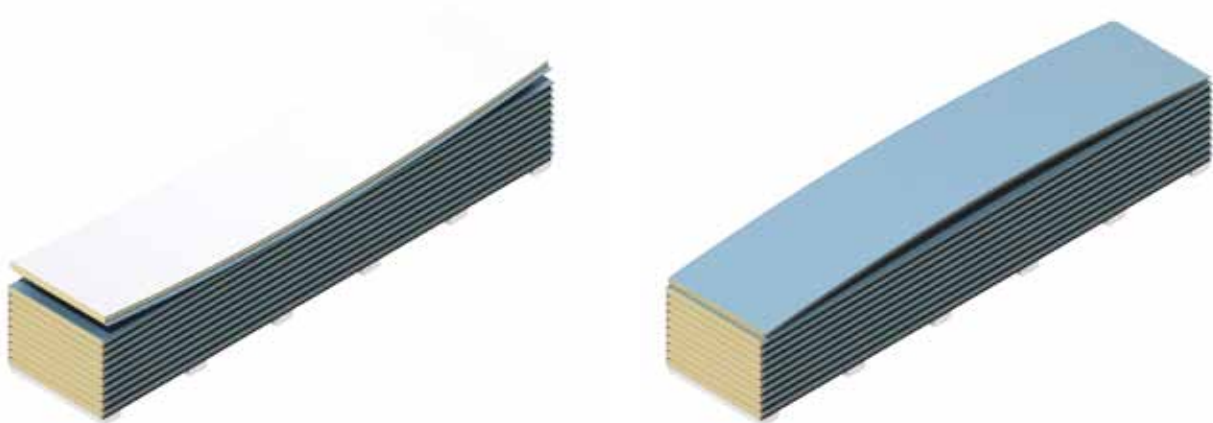
#### 4.2 GUIDANCE ON USING PANELS WITH LINING WITHOUT OVERPRESS ("SMOOTH LINING")

The panels in the lining without overpress may only be assembled in a single-span system, after first checking with SandStat if such a solution is possible.

Using the panels with lining without overpress in other assembly systems may lead to undesired visual effects, e.g. rippling of the lining. These may be temporary, i.e. they may only appear in specific conditions, e.g. when the facade is exposed to powerful sunshine. No such elements adversely affect the panel's capacity to withstand heavy load, but they may not be appreciated by the investor who may claim that the visual aspect of the facade has been compromised.

**Kingspan Sandwich Panels do not bear responsibility for the damage to the panels resulting from the fact that the designer had not considered the above-mentioned guidelines.**

**If the customer expects aesthetically attractive smooth panels, we recommend the panels offered by Kingspan Facades.**



Picture 73. Bowing - thermal distortion of the panel.

## 5. GUIDANCE ON TEMPORARY MAINTENANCE INSPECTION OF CASING MADE OF KINGSPAN SANDWICH PANELS

In order to ensure the correct longevity and prolong the durability of the casing made of the Kingspan sandwich panels, we recommend a minimum yearly quality inspection of the outer and inner panel lining. It will allow you to check the quality status of the panels and eliminate potential threats to their durability.

It is recommended to start such inspections as soon as you complete the construction, once a year in April or May, with the assistance of Kingspan representatives in order to check the conditions of use and confirm the guarantee given by Kingspan.

During the guarantee period, each inspection should be carried out in the presence of a Kingspan representative and should be officially confirmed to avoid the risk of the guarantee being void.

During each inspection, take care to check the state of the structural elements as provided below:

Element	Necessary action
<b>Drainage system - gutters:</b> Potential blockages may cause overflowing and seepage inside the building.	Remove the stains and clear out the points of congestion.
<b>Rubble:</b> The rubble (rubbish) that has not been removed from the construction site, which lies adjacent to the panels (especially on the roof), may cause permanent local humidity and create spots of potential corrosion.	Remove the rubble and clear out points of contact.
<b>Bundles of dust and dirt on the casing where they cannot be washed away by rainwater:</b> Focal spots of dirt diminish the aesthetic attributes of the premises and, if they linger, may damage the paint coating.	Clean and wash the soiled areas in accordance with the guidelines from 5.1.1 Casing washing.
<b>Clusters of flora:</b> In exceptional circumstances, there may appear clusters of flora in darkened places and spots shaded from the rain.	Clear out the overgrown spots and clean in accordance with the guidelines from 5.1.2 Removing fungi, moss and mould.
<b>Minor mechanical damage:</b> When there is minor mechanical damage that disturbs the paint coating, corrosion spots may appear on the steel sheets.	Assess the size of damage caused by the appearance of: 1. Tiny scratches - cover the spots with repair paint in accordance with 5.2 Correction painting 2. Surface damage - repaint the damaged surface in accordance with 5.3 Surface painting 3. Serious damage to lining sheets - replacement of plating or whole panels
<b>Filings left after drilling and panel cutting:</b> May cause minor corrosion of edges.	Gently wipe the filings off the edges.
<b>State of connectors in use:</b> Badly installed connectors may cause minor leakage or create corrosion spots on the connectors.	Replace damaged or corroding connectors and replenish masking caps (if required).
<b>Corrosion on the edges of cutting:</b> May appear on cut edges beside hems and assembly contacts, where the cut sheet is in contact with the paint coating.	Securing the edges in accordance with 5.4 Securing cut surfaces.

## 5.1 TIPS FOR CASING MAINTENANCE

### 5.1.1 Casing washing

If you clean the Kingspan panels, you should abide by the following security measures:

- Apply soft water, i.e. distilled or ionised under low pressure.
- If the dirt is permanent, it is recommended to use commonly accessible washing detergents (products for washing car sheets), preparing 10% concentration solutions, or read the instructions provided by the manufacturer.
- It is not advisable to use active foam, because if you do not rinse it thoroughly, light streaks and stains will be left afterwards.
- High concentration of washing products may cause damage to the lacquer coating.
- Wash from bottom to top.
- After washing each panel, rinse the freshly washed panel and all the panels lying underneath twice (once from the bottom and once from the top).
- After washing one vertical section, towel dry it to avoid water stains.
- Carefully rinse with water all the spots that have been washed with detergents.
- Do not use organic solvents or abrasive substances (polishes, powders).
- If the stains have been caused by leak stoppers (silicones, rubber butyls etc.) or bituminous compound, you may use mineral solvents or read the instructions provided by the compound manufacturer after a preliminary attempt in a place where potential damage to the lacquer will not be visible (e.g. underneath masking dressing). Always rinse these places with water carefully.
- It will cause more harm than good if you clean and wash the places carelessly or too often. It is recommended to hire companies specialising in cleaning building facades, because they have access to water softening installations, as well as all the necessary tools and washing products.

### 5.1.2 Removing fungi, moss and mould.

There are natural environments that are conducive to the growth of flora, especially shaded areas in a wet climate, densely forested or marshy. The presence of moss, fungi or mould in such places is inevitable, even on materials that are not conducive to the growth of plants.

If you come across the dirt and stains mentioned above, use a washing product in accordance with the following recipe. Prepare the mixture in a weight proportion using widely available ingredients offered by chemical product suppliers. Before you mix the first three ingredients, read the instructions concerning security precautions recommended by the producers of these ingredients.

1.	High-quality domestic detergent —	0,5 part of the mixture
2.	Trisodium phosphate —	3,0 part of the mixture
3.	5% solution of sodium hypochlorite —	25,0 part of the mixture
4.	Dilution-water —	71,5 part of the mixture
		-----
		100,0 part of the mixture

Before using the solution, it is recommended to wash the infected spot in accordance with washing recommendations and then apply the solution on to the surface with the use of low-pressure spray or a paintbrush. Leave the surface where you have applied the solution for a period of 1 to 22 hours and then rinse the washed surfaces with cold running water before the passage of 24 hours.

## 5.2 TIPS FOR CASING MAINTENANCE

### **Kingspan does not repair sandwich panels or lacquer coating.**

If you notice tiny scratches on the lacquer surface, the depth of which does not reach the steel sheet

(the depth of fissure reaches the ground coat), you do not need to apply any correction painting unless you want to do it for aesthetic purposes. If the fissures do reach the steel sheet, the normal practice is to paint these spots over with an appropriate colour and composition paint. If you deal with polyester coating (PES lacquer), use a commonly available polyester lacquer used in the car industry or a paint applied on galvanised coating as your repair paint. The paints you use must be able to dry in open air. You should not use stoving lacquers. We do not recommend using cellulose paints.

If you deal with PVDF and Plastisol coating, we recommend contacting a selected manufacturer of repair paints to acquire the correct paint. Addresses of these manufacturers may be obtained from Kingspan Sp. z o.o. on demand.

Kingspan neither selects nor supplies repair paints.

It is important not to apply the repair paint beyond the edges of the specific fissure. This is why you should use a soft paintbrush with a "sharp" end for such a procedure. It is not recommended to use paints in aerosol or pressure-sprayed paints. After applying a correction paint, you may notice a clear difference in shade or quality of the coating. Therefore, you should avoid using repair paints on larger surfaces for aesthetic reasons.

### 5.3 SURFACE PAINTING.

If you need to repaint a detail of the panel or casing, you will be applying surface painting. Therefore, you are required to prepare the original coating for repainting by matting and degreasing, which is equal to damaging the initial coating. Unfortunately, it will result in losing your Kingspan guarantee on the original lacquer coating. This type of painting should be carried out by an authorised and specialised company with the use of appropriate lacquers and in appropriate conditions (temperature, wind, humidity, no dust etc.). Because of this, the customer will be able to obtain a guarantee on the repair work carried out in this way.

### 5.4 SECURING CUT EDGES

The presence of tiny corrosion spots on the cut edges of the sheets is nothing out of the ordinary and does not constitute imminent danger to the durability of the plating unless the corrosion has spread beyond the edge of the sheet. The steel sheets used as lining are protected against corrosion by the so-called "DUPLEX" system, which means that they are protected by zinc coating

(275 g Zn/m<sup>2</sup>), which creates a surface electrochemical screen against corrosion (so-called "cathode protection"), and the lacquer coating. If the sheets are affected by a C3 corrosion class environment, the cut edge undergoes electrochemical reactions due to the presence of a zinc layer. It only corrodes until a layer of oxides encrusts over the steel, after which the process grinds to a halt - this is why there may be a natural corrosion of the edge and possible discolouration of the sheet edge.

However, this phenomenon is only temporary and it quickly subsides.

If the sheets are affected by a C5 corrosion class environment, it is recommended to cover the cut edges with enhanced corrosion-resistant polyurethane lacquers (e.g. Tikkurila Temadur HB 50 or equal).

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