

Faceboard POR Bossensteine

Ashlar elements for facade design

AREAS OF APPLICATION

Lightweight ashlar elements for decorative facade design. Suitable for installation on solid substrates and alsecco facade systems based on EPS and mineral-wool insulation materials.

PRODUCT PROPERTIES

- Mineral granule-based design element
- Suitable Alsicolor facade paints may be applied for a colour finish.
- Excellent visual and technical quality
- Easy bonding with adhesive Profilkleber 1K
- Virtually unlimited scope of design due to standard shapes and order-based special types

TECHNICAL DATA

Fire behavior	A2-s1, d0 according to DIN EN 13501-1 (up to and including 100 mm profile thickness)
Density	approx. 500 kg/m ²
Thermal Expansion	approx. $10,5 \cdot 10^{-6} \text{K}^{-1}$ based on DIN EN 14617-11

APPLICATION INSTRUCTIONS

Preparation	<p>Remove dust and any residue, which can reduce adhesion, from the decorative profiles; if necessary, adjust length.</p> <p>A miter or miter-box saw is recommended for cutting.</p>
Substrate pre-treatment	<p>All substrates must be sound, even, clean and free from adhesion-reducing residue.</p> <p>When installing external thermal insulation composite systems, use adhesive to attach the profiles to a suitable and dry base coat.</p> <p>The planeness of the surface of the set base coat must not deviate by more than 2 mm across the maximum edge length of the ashlar that is being installed.</p> <p>Check the soundness of concrete and untreated render, and remove any residual release agent and loose particles.</p> <p>Apply a suitable primer to absorbent substrates.</p>
Mixing adhesive	<p>25 kg Profilkleber 1K in approx. 4,5 - 5,0 l of water.</p> <p>Mix with electric mixer until obtaining a workable, smooth (lump-free)</p>

consistency.

After a maturing time of at least 5 minutes, mix again.

Do not mix more material than can be used within one hour.

Application

Faceboard POR Bossensteine are bonded to the sound, even substrate with Profilkleber 1K. If any profiles have to be cut to size, a circular cross-cut saw or mitre-box saw must be used to produce a clean cut. Dust must be removed from the cut edges prior to installation.

An installation plan should be drawn up before starting work. When drawing up the installation plan, the joints between the facade profiles must be arranged so that no stress is created when structural components such as windows or windowsills are incorporated. Faceboard POR Bossensteine must not be notched in the area around openings.

The upper wall junction joint must be sealed completely with Profilkleber 1K during installation.

Profilkleber 1K is applied all over to the substrate and the rear of the ashlar elements (floating-buttering method) using a notched trowel (notch size 8 to 10 mm). The profiles are always fully bonded to the substrate. Profilkleber 1K is also applied to the cut surfaces of the facade profile. Place the facade profile carefully into position, then press firmly. Secure the profile to prevent it slipping if necessary. The joint surrounding the ashlar must be sealed with Profilkleber 1K. Go over the adhesive joints consisting of Profilkleber 1K with a damp brush, making sure that the edges are sealed and smooth. Mitred joints and reverses must be fully bonded together. For edge profiling of ashlars more than 15 mm thick, fill the joints with Profilkleber 1K or Fugenmasse MS, then smooth out any excess Profilkleber 1K or cut off Fugenmasse MS after it has hardened. The joint width is 2 - 3 mm. The max. field size of facade sections where Faceboard POR Bossensteine are installed is 9 x 9 m. Field joints must be installed for field lengths greater than 9 m. This involves aligning and fixing the facade profiles 10 - 20 mm apart, making sure that the joints are straight. Then make an incision in the base-coat render underneath. Insert a non-absorbent PE cord (PE-Rundschnur) in the field joint you have created and seal with Fugenmasse MS so that this is flush with the surface.

Make sure that the edges are straight. The edges may need to be chamfered before this is done.

Use PE-Rundschnur and apply Fugenmasse MS to connect profiles to other types of structural elements, e.g. windows. The width of the joint must comply with the specifications of DIN 18540 to offset any stresses that occur. The horizontal connection joints with the substrate must be finished as a concave channel. Once the joints and adhesive used for fixing the facade profiles in position have dried out sufficiently, a suitable facade paint at least twice, e.g. Alsicolor Cryltec, or Alsicolor Silitec can be applied. The edges of the facade profiles to be coated on site must be snapped over an offcut or sanding block in preparation for this process. Fine hairline cracks or shrinkage cracks in the areas of the vertical joints between facade profiles do not affect the functionality and therefore do not constitute grounds for complaint.

Small damages to the profiles can be repaired with Faceboard POR Profilspachtel. Faceboard POR Bossensteine require special measures to protect them from moisture in the splash zone. A minimum gap of 10 mm must be observed

between the end or underside of the profile and ground level. Faceboard POR Bossensteine must be protected from water up to at least 50 mm above ground level by applying Waterflex or Waterflex Carbon. In the splash zone up to 300 mm above ground level or adjacent horizontal parts of the building, the Faceboard POR Bossensteine should be treated with Imprägniergrund MI before paint is applied.

Consumption of adhesive	approx. 3,0 - 4,0 kg/m ² Determine the precise material requirements by means of a trial coating on the object.
Weather conditions	Temperatures below + 5 °C may not arise during application and drying.
Drying time adhesive	approx. 24 hours. Depending on temperature, relative humidity and substrate conditions even longer.
Cleaning of tools	In a fresh state with water.
Information	<p>Faceboard POR is essentially a mineral-based product. With regard to the surface finish, the instructions for mineral renders therefore apply.</p> <p>Please contact us for further information if you are intending to use the products for applications other than those described here. The feasibility of installing customized units must be considered in advance. The customer is required to check and approve the drawings prepared for customized profiles before the order is accepted.</p> <p>The substrate must generally be more even if you are installing thinner or larger-sized ashlar, as this prevents breakage and ensures a full bond. We recommend carrying out preliminary tests on site to ensure the reliable installation of the profiles.</p> <p>The joints between profiles are generally visible. Any hairline cracks appearing in the paint above these vertical profile joints do not impair the function.</p> <p>We are unable to accept dimensional drawings sent in by fax.</p> <p>Depending on the area of application and the paint system used, a different classification for the reaction to fire may apply.</p>

STORAGE

Store flat to prevent warping.
Dry, cool, protected against moisture.

PACKAGING INFORMATION

Formats	<p>Available thicknesses (D), lengths (L) and widths (B)</p> <p>D = 20 mm; 25 mm; 30 mm; 35 mm ... 50 mm</p> <p>L = 150 mm – 1000 mm</p> <p>B = 30 mm – 520 mm</p> <p>Maximum standard dimensions for full-bond installation 520 x 520 x 50 mm (0.27 m²) or 1000 x 270 x 50 mm (0.27 m²)</p>
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Packaging unit Individual packaging

OTHER INFORMATION

Information on safety	The information provided in the current safety data sheet applies.
Transportation	Do not throw, transport on a level surface, use layers of cardboard or similar as packing material for numerous profiles, to prevent damage to the coating, special protection for the edges.
Waste code	Dispose residues as per EWC 170904 (mixed construction and demolition waste).

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The above information is based on many years of experience and tests and is provided by us to the best of our knowledge. Such information applies in addition to our application guidelines. However, we cannot accept any responsibility for the correctness of our recommendations on account of wide variety of substrates and of on-site conditions and applications which are outside our control. Any recommendations provided by our employees and deviating from these documents must be given in writing. We reserve right to make any changes on account of technical progress or building regulations. Your technical advisor will be pleased to provide the relevant product data sheets.

