

# Faceboard POR Rahmen-, Gurt- und Gesimsprofile

Frame and fascia profiles for facade design

## AREAS OF APPLICATION

Lightweight facade profiles installed as frame, fascia and cornice profiles for decorative facade designs. 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)
Accessories	<b>Alsifix FB</b> Required anchoring depth: $\geq 70$ mm Shank length: 120 - 300 mm
Density	approx. 500 kg/m <sup>3</sup>
Thermal Expansion	approx. $10,5 \cdot 10^{-6} \text{K}^{-1}$ based on DIN EN 14617-11

## APPLICATION INSTRUCTIONS

Preparation	Remove dust and any residue, which can reduce adhesion, from the decorative profiles; if necessary, adjust length. A miter or miter-box saw is recommended for cutting.
Substrate pre-treatment	All substrates must be sound, even, clean and free from adhesion-reducing residue. When installing external thermal insulation composite systems, use adhesive to attach the profiles to a suitable and dry base coat. 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 frame, fascia and cornice profiles that is being installed.

	<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) consistency.</p> <p>After a maturing time of at least 5 minutes, mix again.</p> <p>Do not mix more material than can be used within one hour.</p>
Application	<p>The Faceboard POR Rahmen-, Gurt- und Gesimsprofile 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. 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.</p> <p>An installation plan should be drawn up before starting work.</p> <p>Profilkleber 1K is applied to the entire substrate and the back of the facade profile (floating-buttering method) using a notched trowel (notch size 8 to 10 mm). The profiles are always fully bonded to the substrate. Place the profile carefully into position, then press firmly. Secure the profile to prevent slipping if necessary. The joint surrounding the facade profiles must be sealed with Profilkleber 1K. The adhesive joints consisting of Profilkleber 1K are smoothed over with a damp brush, making sure that the edges are sealed.</p> <p>The upper horizontal connection joint with the substrate must be finished as a concave fillet. Mitred joints and reverses must be fully bonded together.</p> <p>If profile adhesive has dropped onto the base coats, those areas must be cleaned with water immediately to avoid impairing the adhesion of mineral finishing coats. For facade profile projections &gt; 150 mm or a ratio between the profile height and projection &lt; 2, additional mechanical fixings must be inserted.</p> <p>Once the adhesive has hardened, the large-format customized profiles are anchored in the sound substrate with 2 - 3 Alsifix FB screw fixings/m (at least 100mm from the edge). A forstner bit or hinge location cutter (NW 20 mm) is used to pre-drill a hole at least 20 mm deep in the profile. The depth of the drilled hole must leave at least 50 mm of profile thickness. The profiles are aligned and screwed into the load-bearing substrate. Remove any drill dust. Insert the plug (and foam cap, if applicable) in the drilled hole and seal the hole with Faceboard POR Profilspachtel.</p> <p>Sand the Profilspachtel so that it is flush with the surface. The ratio between the profile height and projection is limited to <math>\geq 1</math>. We recommend Faceboard POR Montagekonsolen (assembly brackets) for facade profiles with a weight &gt; 4.5 kg/m and/or a projection &gt; 80 mm. The additional batten is fully bonded to the sound substrate with Profilkleber 1K before the facade profile is attached. Once the adhesive has dried sufficiently, the facade profile may also be mechanically fixed in position with at least 2 - 3 Alsifix FB screw fixings/m.</p> <p>Continuous facade profiles extending round the building or several facade profiles to be fixed in a row and with a thickness &gt; 20 mm must not be butted closely together. Facade profile with a thickness &gt; 20 mm are installed with an open vertical joint of approx. 10 mm. The open vertical joints are closed with Füllschaum B1 after an interval of at least 24 hours to allow the adhesive to dry.</p>

Once the Füllschaum B1 has set, scrape the joint to a depth of approx. 10 mm and fill with Fugenmasse MS for a flush finish.

In the case of continuous profiles extending round the building or facade profiles installed in a row, the ends of the row and the horizontal joints where the profile meets the wall must be sealed with Fugenmasse MS.

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. 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 Carbon, Alsicolor Cryltec, Alsicolor Sc, Alsicolor Silitec or Alsicolor Silitec Thermobalance, can be applied.

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. Horizontal profile surfaces with a projection > 20 mm must slope away from the facade by more than 5° or 8%. Depending on the profile geometry and thickness, rain deflectors should be incorporated.

Faceboard POR profiles 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 facade profiles must be protected from moisture 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 facade profiles should be treated with Imprägniergrund MI before the paint is applied.

#### Consumption of adhesive

approx. 3,0 - 4,0 kg/m<sup>2</sup>

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

Faceboard POR is essentially a mineral-based product. With regard to the surface finish, the instructions for mineral renders therefore apply.

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.

Installation:

- max. 40 kg per element, max. 40 kg/m<sup>2</sup> of contact area
- max. length per element 2250 mm
- max. width per element 520 mm
- max. length per element from 19 kg/m, 1120 mm

Please contact us for additional recommendations if you intending to use the

products for applications beyond than those described here.

The substrate must generally be more even if you are installing thinner or larger-sized profiles, as this prevents the profile from breaking and ensures a full bond. We recommend carrying out preliminary tests on site to ensure the reliable installation of the profiles.

As with traditional facade profiles, Faceboard POR facade profiles exposed to weathering and with projections > 150 mm must be provided with additional protection, e.g. sheet-metal flashings, in accordance with the code of practice for metal work in the roofing trade (Fachregeln für Metallarbeiten im Dachdeckerhandwerk). The lasting reliability of this type of weather protection must be ensured.

Alternatively, the horizontal surfaces may be coated with Waterflex or Waterflex Carbon, Kobau Elastic Mesh 10/10 and Disbon 404 (at least two coats).

The joints between profiles are generally visible. Any hairline cracks appearing in the paint above these vertical profile joints do not impair the function.

Faceboard POR lightweight facade profiles are designed for dead, wind and snow loads. Additional loads, e.g. imposed by stepping onto the facade profiles, are not permissible.

Depending on the area of application and the paint system used, a different classification for the reaction to fire may apply.

## STORAGE

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

## PACKAGING INFORMATION

Packaging unit                      Individual packaging

## OTHER INFORMATION

Information on safety	The information contained in the current safety information 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).

**alsecco GmbH**  
Kupferstraße 50  
D-36208 Wildeck  
Phone 03 69 22 / 88-0  
Fax 03 69 22 / 88-330  
Internet: [www.alsecco.de](http://www.alsecco.de)

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.

