

# Reynolux<sup>®</sup> coil-coated aluminium

## Guidelines for handling, storage and fabrication

### General

- **GUIDELINES:** The general instructions for the handling and storage of our Reynolux<sup>®</sup> coil-coated aluminium coils and sheets are presented in this manual. However you should respect the national working regulation of your country.
  - **DO NOT REMOVE** the protective film before installation is completed as specified below. Protective film should be peeled-off within 6 months after installation (refer to the Protective film section)
  - **INSPECTION:** Any coils or sheets that show visible damage (dents, impact damage, deep scratches through the protective film, etc.) should be rejected unless the damaged section is outside of the required usable area.
1. Overall parcel inspection before unloading: Any defect detected should be notified to the carrier by writing on the official delivery document with a copy to Arconic Architectural Products SAS (AAP) within 24 hours.
  2. Inspection of the merchandise after unloading, when implementing: Any defect detected should be notified to the sales representative by providing precise traceability data (coil number, pallet number, etc.)
- **SAFETY:** For all handling, transformation and installation steps ensure that appropriate protective equipment is worn: eye protection, hearing protection and gloves. As a general precaution, safety boots are also recommended.



### Handling

- In order not to damage the sheet or the coil, please handle them with care by supporting them at several points lengthwise according to the length and weight. Handle several sheets at a time so as to avoid scratching the finish. Do not slide the coated surfaces against each other. Insert cardboard between the sheets and the pallet.
  - **Sheets:** Always transport Reynolux<sup>®</sup> coil-coated aluminium horizontally on a solid pallet that supports the entire length and a suitable flat trolley. Ensure that the sheets are carefully strapped and protected with top and bottom coversheets to prevent damage.
- **Coils:**
    - 1. Unloading on a vertical axis or a horizontal axis:** Use a forklift or a pallet jack, which is adapted to the weight of the coil.
    - 2. Handling on a vertical axis:** Use a suction pad or a coil tipper, which is adapted to the weight and the diameter of the coil.
    - 3. Handling on a horizontal axis:** Use a forklift or a crane with a grip on the inside diameter of the coil. But in all cases, the tools (fork, clamp...) must be protected in order to avoid damage to the material.

### Storage

- Store the material in a dry, temperate place on a flat horizontal support whose dimensions are greater than or equal to the sheets or coil.
  - Store the sheets or coil in the workshop and make sure that the material is at about 18°C (64°F) at least 24 hours before the transformation work begins in order to deal with dimensional changes due to weather and climate and to optimise the transformation work (gluing, profiling, bending, processes, etc).
- Always make sure that the weight of the material does not affect the sheets below.

## Fabrication

- **Thermal expansion & dimensions:** Expansion and shrinkage behaviour must be considered when calculating dimensions of your product.
- **Sheet inspection:** Inspect sheets of Reynolux® coil-coated aluminium for obvious signs of damage during transport or handling. Do not fabricate damaged sheets unless the damaged section can be eliminated.
- **Batch:** Always use Reynolux® coil-coated aluminium from the same batch for one project, this will avoid any minor colour variations.
- **Product traceability:** Should be kept all through the transformation process in order to facilitate future information research.
- **Direction of coil-coating:** Metallic coatings have a reflective or pearlescent finish, which is oriented in the longitudinal direction during the coil-coating process. This gives the sheet “active colour” behaviour, dependent on the angle from which it is viewed. The same goes for

pattern coatings (wood, granite...). Directional arrows are printed onto the protective film and should be used to maintain the correct orientation and avoid shading differences between adjacent sheets. This orientation should be taken into account when making sheet optimisation calculations. Note the direction of the coating on any cut pieces left without arrows.

- Do not bring the Reynolux® pre-painted aluminium sheets and coils into direct contact with metals such as copper, brass, bronze or iron. Insert protection elements.
- Respecting all the above guidelines will minimise the chance of stress whitening.
- All transformation (bending, roll forming, deepdrawing, etc.) must be done in accordance with the specific bending radius (defined before the first delivery and according to the norm EN 1396)

## Protective film

The protective films used by AAP are intended to temporarily protect the surfaces against dirt, scratches and tool marks during the complete utilisation cycle: handling, storage, transport, transformations and mounting. However, they are not intended to protect against corrosion, humidity or chemical products. After removal our protective films do not affect the sheet's surface and thus do not lower the quality of the digital and screen printing.

- **Durability:** deadline for the removal of the protective film

Removal	Inside (away from UV)	Outside (UV)
UV resistant	12 months	6 months
Not UV resistant	6 months	0 months

- **Removal:** The ambient temperature has an influence when the protective film is removed: The higher the temperature is, the easier it will to peel it off. Remove the protective film immediately after the installation of the sheets.

- **Important:** Avoid stagnant water as it can create a risk of transfer of glue when the film is removed. Do NOT stick PVC tape, polyurethane and modified silicone sealant onto the protective film. Plasticizers contained in these materials penetrate the film and may cause gloss change on the coating. Do NOT use permanent markers on the protective film.

- **Choice of protective film:** We'll suggest a protective film based on our experience. However for specific applications or transformation it is necessary to try out the product before permanent use. This trial has to take into account several criteria, such as: the type of material on which it will be used, the state of its surface, mechanical and thermal overloads within work as well as the real durability and ageing conditions that are required. For instance, the type of protective film and glue can vary according to the type of paint used or the type of cutting (laser or water jet cutting for example).

## Disclaimer

As our customer, you are solely responsible for selecting the proper materials (Arconic Architectural Products SAS's (AAP) products) based on your customer's demand, the intended utilization, the technical characteristics of the product integration in the project, the compatibility with other utilized material, and if applicable, how these products are incorporated into other products. Laws and building and safety codes governing the design and use of AAP's products vary widely. AAP does not control how AAP products are fabricated, transformed or otherwise configured or used, nor how AAP's products are combined with other materials. AAP assumes no responsibility for any of the foregoing. It is the responsibility of the owner, the architect, the general contractor, the fabricator/installer and the transformer, consistent with their roles, to determine the appropriate materials for a project in strict conformity to all applicable national, regional and local building codes and regulations. AAP is dependent upon Customer to provide true, accurate and complete information relating to product purchases. Any laboratory testing information provided by AAP applies only to the particular product or assembly tested and does not necessarily represent how products will actually perform in use. Reports and test data corresponding to a particular tested product sample or assembly are not a guarantee that the same product or assembly would always achieve the same test result. Please ensure the product is used in a system that complies with applicable fire safety regulation.