



Technical guide

Polyrey Facades

Exterior Compact for Cladding

Exterior design, interior comfort

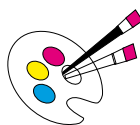
The Polyrey Facades Exterior Compact has been developed to withstand outdoor conditions and to suit the application of ventilated facades. Our technical guide outlines the various tests passed in order to guarantee the suitability of Polyrey Facades for exterior use.



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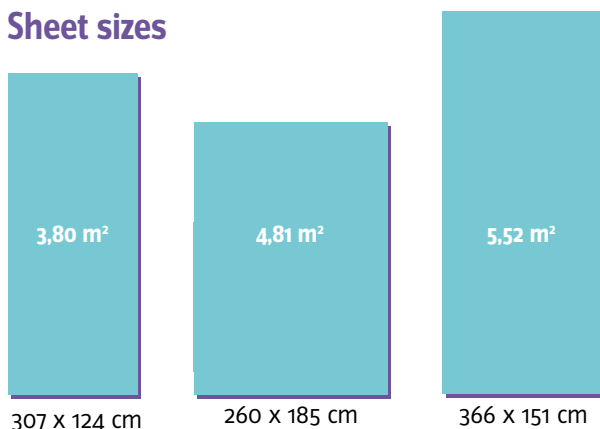
I. Polyrey Facades Exterior Grade Compact cladding: A quality guarantee

A Polyrey Facades : The range



Polyrey Facades is suitable for use as a ventilated facade with several sizes available in order to optimise utilisation, two thicknesses and decors that have been specifically selected for this application.

Sheet sizes



Thicknesses	8 and 10 mm
Decors	28 decors same decor both sides
Finish	Satin finish (FA)
Fire ratings	C-s1, do B-s1, do on request
Standards	EN 438-6 and 7 (EDF/EDS rough use) CE

Decor selection

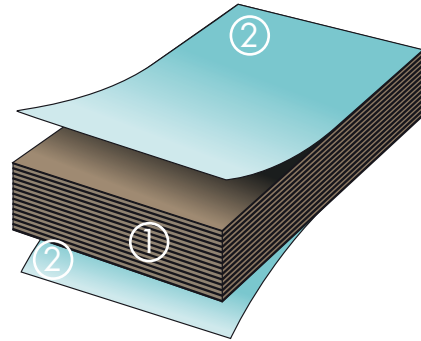
Plain colours		
Code	Decor	RAL or NCS matches
A069	Argile	S4010-Y30R
B110	Beige Poudré	2005-Y80R
B015	Blanc Menuires	9016 G
B111	Bleu Outremer	4060-R70B
C017	Coquille d'Œuf	1015 (D)
F006	Fer	7005 (L)
G015	Glaise	1811-Y01R
G021	Gris Ardoise	6502 B
G020	Gris Ciment	3101-Y26R
G044	Gris Dauphin	7047 (G)
N029	Noir de Jais	9011
P001	Pierre de Lune	7006 (D)
R006	Rouge Passion	2080-Y90R
R010	Rouge Tomette	6040-Y80R
V022	Vert Lichen	4020-G90Y

Woodgrains		
Code	Decor	RAL or NCS matches
B112	Bois Cuivré	6030-Y70R
C042	Chêne d'Armor	8010-Y90R
C005	Chêne du Perche	3040-Y20R
E036	Erable Naturel	1010-Y20R
E048	Etimoe Rouge	5040-Y60R
N007	Noyer Grisé	5005-Y20R
P020	Palissandre	6030-Y70R
P014	Pin Grisé	5005-Y50R
P036	Platane Rouge	4040-Y80R
Metals		
Code	Décor	Correspondances RAL ou NCS
A086	Acier Brossé	3500 N
A058	Acier Oxydé	6000 N
C034	Cuivre Oxydé	6020-Y70R
Z003	Zinc Oxydé	5010-B90G

B Composition of Polyrey Facades

Polyrey Facades has been specially developed for exterior applications. It is designed with a new high quality surface protection strongly resistant to extreme weather conditions.

- ① Phenolic core: The quantity of Kraft sheets that are impregnated with phenolic resin.
- ② Decorative paper sheets with surface protection for external use.



The characteristics of Polyrey Facades meet the highest level (EDS/ EDF) of the applicable standards for Exterior Compact EN 438 parts 6 and 7.



C Technical performances



1. Sustainability and resistance to external conditions

- Polyrey Facades is **sustainable, UV-resistant and weather resistant**. It also resists to **climatic shocks**. Its colours and decors are very well preserved throughout the years.

Wear tests :

Polyrey Facades meet the highest level of the EDS / EDF wear test which corresponds to rough use. Test requirements :

- *UV resistance ISO 4892-3
Exposure to UVB, with dry heat and condensation cycles for 1500h long.*
- *Resistance to artificial wear conditions (to artificial bad weather)
Exposure to the solar spectrum –through a Xenon lamp- and to water spraying cycles for 3000 h long.*
- *Humidity resistance: Immersion of the compact in water of 65 °C for 48 h.*
- *Climatic shock resistance: Measurement of flex after 4 cycles over 5 days alternation between damp / warm / dry / cold conditions.*

- **Water repellent and inert**, Polyrey Facades fits any external environment.

It resists water, steam, mould, decay, frost and heat

- It is very **solid**, shock and wear resistant. As the material is very dense it is very strong as well.

Shock resistance tests :

The tests of mechanical strength carried out on the Exterior Compact measure the resistance to shock of a large diameter marble, as well as flex and tensile resistance ...

With the CSTB, other tests of mechanical strength have been carried out on the Polyrey Facades in a ventilated façade assembly: wind, shock and tensile resistance test (see Chapter V page 11).

All characteristics of Polyrey Facades are tested and controlled in order to meet the EN 438 standards, parts 6 and 7 (Specific to Exterior Grade Compact).

2. Excellent fire resistance

The Polyrey Facades offer concerns two products: Standard quality Euroclasse C (M2) or fireproof quality Euroclasse B (M1).

It does not melt or corrode and has low smoke emission.

Standardised type	Euroclass rating according EN 13501-1
Standard - EDS	C-s1,d0
Fire retardant - EDF	B-s1,d0

s : Smoke Density
d : Flaming droplets

The tests have been carried out with a framework, in the situ of a ventilated façade.

3. Ecological materials

- The life cycle analysis of Polyrey Facades Exterior Grade Compact has enabled the understanding and limitation of its environmental impact. The Environmental and Sanitary Declaration Sheets guarantee the environmental quality of this product that fits the HQU label standards.

Polyrey Facades is used to build ventilated facades that will optimize the THERMAL PERFORMANCE of buildings and reduce energy consumption.

- Polyrey Facades Compact does not contain pentachlorophenol, asbestos, halogens or heavy metals.
- Waste disposal: The high combustion heating values (18 to 20 MJ/kg) of Polyrey Facades Exterior Compact's waste, generates energy through incineration (at 700°C) in certified Waste-to-Energy plants.
- Polyrey Facades is produced in ISO 14001 certified factories.



II. Technical Data Sheet

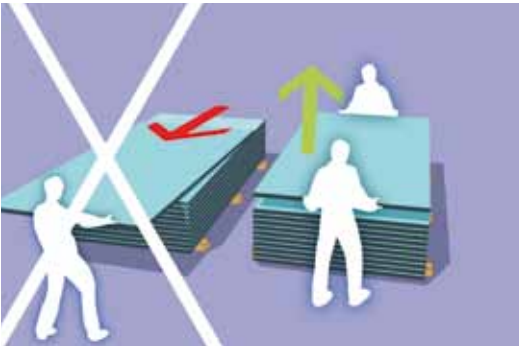
<h1>Polyrey Facades</h1> <p>Exterior Compact for Cladding</p>	Quality		Standard	FR
	Finishing		Satin FA	
	Thickness (mm)		8 - 10	
	Standardised type		EDS	EDF
	Standard	Scale Unit		
Wear resistance				
UV Resistance (1500h)				
Contrast	EN 438-2-28	Greyscale value	≥ 3	≥ 3
Aspect		Class (From 1 to 5)	≥ 4	≥ 4
Resistance to artificial wear conditions (3000h)				
Contrast	EN 438-2-29	Greyscale value	≥ 3	≥ 3
Aspect		Class (From 1 to 5)	≥ 4	≥ 4
Resistance to damp atmosphere (48h at 65°C)				
Mass increase	EN 438-2-15	%	≤ 5	≤ 5
Aspect		Class (From 1 to 5)	≥ 4	≥ 4
Resistance to climatic Shock				
Aspect	EN 438-2-19	Class (From 1 to 5)	≥ 4	≥ 4
Flex resistance factor (Ds)			≥ 0,95	≥ 0,95
Flex module (Dm)			≥ 0,95	≥ 0,95
Mechanical resistance				
Impact resistance with a large diameter marble (42,8mm and 324g)	EN 438-2-21	Height of fall in mm	≥ 1800	≥ 1800
Modules Elasticity	EN ISO 178:2003	M Pa	≥ 9000	≥ 9000
Elasticity Resistance	EN ISO 178:2003	M Pa	≥ 80	≥ 80
Tensile Strength	EN ISO 527-2:1996	M Pa	≥ 60	≥ 60
Dimensional characteristics				
Density	EN ISO 1183-1:2004	g/cm ³	≥ 1,35	≥ 1,35
Thickness tolerance				
Thicknesses 8 and 10 mm	EN 438-2-5	mm	± 0,50	± 0,50
Length and width tolerance	EN 438-2-6	mm	- 0 / + 10	- 0 / + 10
Edge straightness tolerance	EN 438-2-7	mm/m	≤ 1,5	≤ 1,5
Square tolerance	EN 438-2-8	mm/m	≤ 1,5	≤ 1,5
Flatness tolerance				
Thickness 8 mm	EN 438-2-9	mm/m	≤ 5,0	≤ 5,0
Thickness 10 mm		mm/m	≤ 3,0	≤ 3,0
Dimensional stability to high temperatures (70°C and 40°C with a 90-95% dampness)				
Longitudinal direction	EN 438-2-17	%	≤ 0,30	≤ 0,30
Transverse direction		%	≤ 0,60	≤ 0,60
Other characteristics				
Formaldehyde emission	EN 717-1/2	Class	E1	E1
Thermal conductivity	EN 12524	W/mK	0,3	0,3
Fire resistance				
Standard Euroclass	EN 13501-1		C-s1,d0	B-s1,d0

III. Shipping and storage

The best conditions to ship and store Polyrey Facades are :

A Handling

- When handling, it is recommended to lift each board separately to minimise the risk of scratching the decorative faces against each other.
- Compressed air lifting machine can be used.

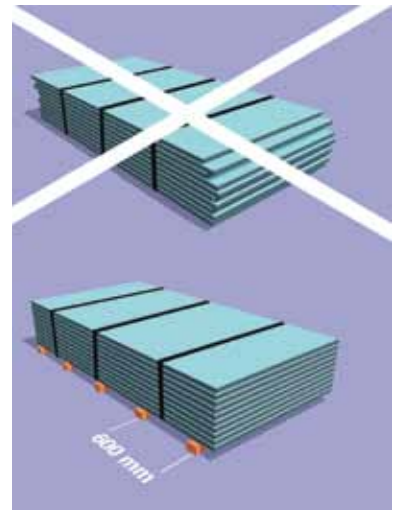


General rule :

During all handling, ensure that the sheets do not glide against one another. Avoid impact, scratching and the introduction of dirt particles that can have an abrasive effect.

B Palletisation and storage conditions

- Transport the sheets on pallets of sufficient size and rigidity.
- Bearers should be at maximum of 600 centres.
- The sheets must be stored in dry premises, under cover to avoid excesses of humidity and heat.
- When storing horizontally on pallets, place a protective sheet of sufficient size between the pallet and the bottom Compact sheet as well as on the top of the stack.
- Compact should always be stored flat in order to minimise any bending or bowing of the sheet.
- Never store boards with a protection sheet for more than 6 months.



IV. Machining

■ The following tools can be used to machine the Polyrey Facades Exterior Compact :

- saw, router, spindle moulder,
- drill,
- digital control machine (CNC).

■ For the machining of Polyrey Facades, carbide or diamond tipped tools are required.

Depending on the tools that are used, preliminary tests will be necessary in order to define the tool's characteristics, feed rates and rotation speeds to avoid any local overheating and to overcome defective machining.

It is recommended that protective film is not removed until after machining or until installed if possible.

If it is necessary to remove the film during the machining phase, than only do this along the edge of the board. Protection film must be removed simultaneously from both sides of the board.

Never leave protection film in place once the boards are installed.

A Cutting

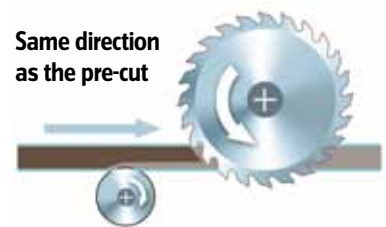
■ The feed speed depends on the thickness of the compact sheet and of the quality of the cutting work required. Slower feed speeds should be used than with thin laminate.

Chipping from the decorative face can be avoided by changing the exit angle of the blade. By raising the blade, the quality of the cut on the top side improves to the detriment of the bottom side and vice-versa.

■ Best results are obtained by using machines with tracer saws or by placing a base board under the compact to be machined.

■ Use of well sharpened unbuckled carbid or diamond blades is recommended with the narrowest line as possible.

There must be between 80 and 120 saw teeth.

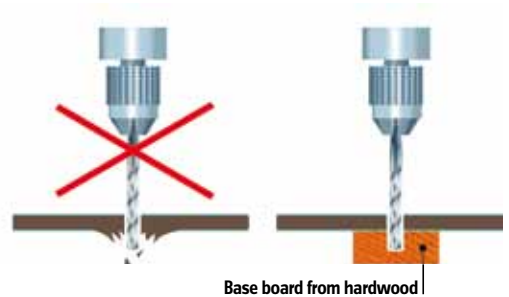


Opposite direction of the pre-cut



B Drilling

- Use drills with a 60 to 80° point angle, not 120°.
- Drilling of higher diameters must be done with universal drilling machines and with drills without a centre point.
- In order to prevent the front face from flaking where it comes out of the machine
 - The progression of the drill must be smooth.
 - It's recommended to work on a base board that can be drilled, such as a MDF or plywood.

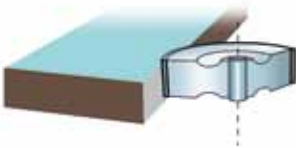


C Edge finishing

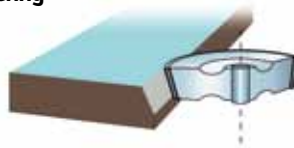
The edges will not require a special treatment but are machinable for particular finishes.

- Machine the edge of the compact by square cutting, chamfering and bevelling. We advice you to sand and polish to avoid injury.
- It is recommended to file down the sharp edges in order to prevent injuries.

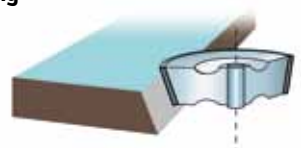
Square cutting



Chamfering



Bevelling



V. Installing the ventilated facades with visible fastener on wooden or metal framework

Polyrey Facades is the ideal cladding material for buildings requiring ventilated facades. It is resistant and sustainable, easy to machine and to install, offering many decorative possibilities.

The ventilated facade consists of an external insulation layer which creates a ventilated gap between the isolator and the compact.

- Ventilated facades combined with **exterior thermal insulation** have many advantages compared to interior insulation:

Overall, **thermal inertia** of the building is increased therefore cooling and heating processes are slowed down.

External thermal insulation is more efficient than interior insulation and meets the standards of **all current and future thermal regulations (RT 2012).**

This external insulation **reduces heating and the need for air-conditioning**, which reduces CO2 emissions.

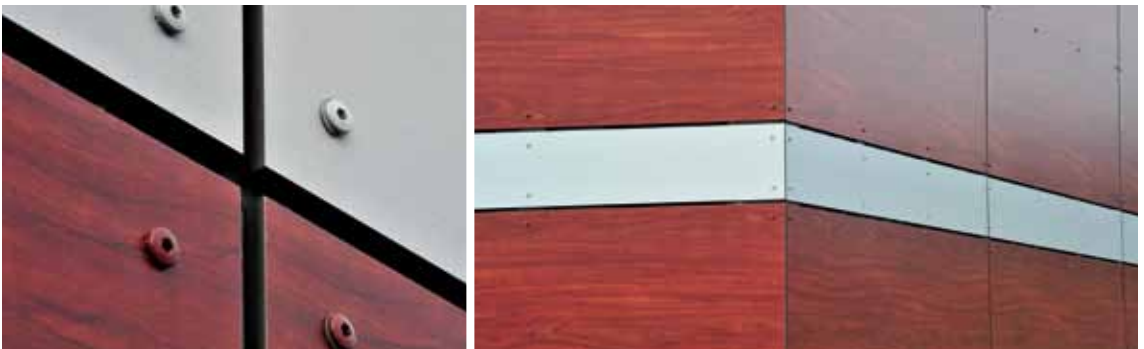
- The ventilated facade is a **sustainable and economical building method.**

Watertight, it efficiently **protects the carrier structure against rain and bad weather.** It guarantees a **healthy environment inside** as the ventilated air shaft quickly removes humidity or excessive heat from the building. The **living space** will not be impacted in comparison to the use of interior insulation (especially after refurbishment).

In the long term, it helps to preserve the fabric of the building, and thus its enhancing value.

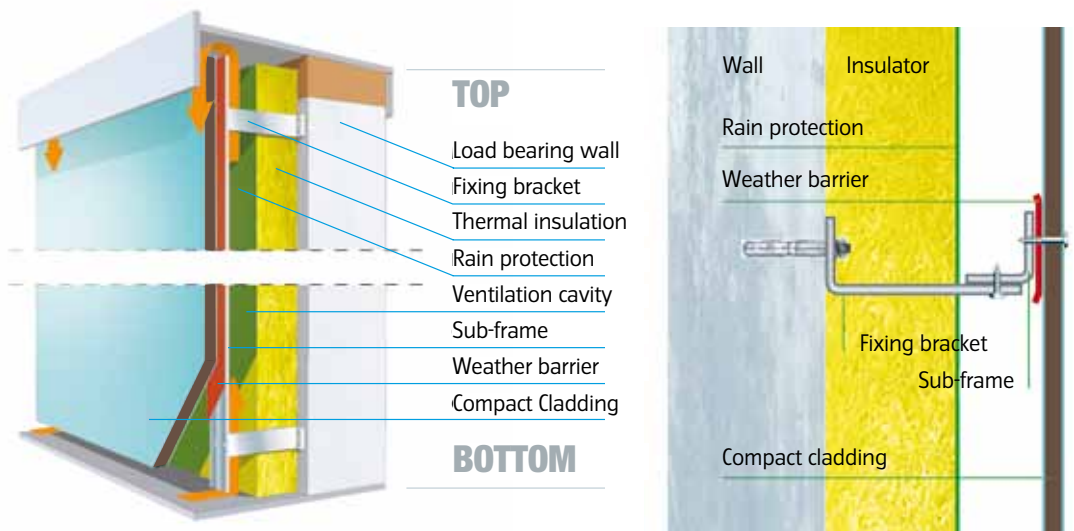
- The ventilated facade allows **managing cost control** for construction projects. The solutions are easy to calculate (frame and boards installation) and facilitate good management of the project schedule.

The exterior Polyrey Facades compact can be put up rapidly and easily with visible fixings, thus **minimise construction periods.**



The technical requirements for Polyrey Facades deal with the installation of ventilated facades with visible fixings, one onto a wooden frame, and the other onto a metal frame.

Full design criteria for the installation of compact cladding for ventilated facades, ensures the correct choice of board sizes for best optimisation. The boards can be put up horizontally or vertically. There is no specific way to cut or layout the boards, except in the case of directional woodgrains.



A Quality guarantee with regards to the requirements of ventilated facade

1. Resistance to wind effects

When designing a facade, the distribution of the charges admissible on the board must be taken into consideration by taking the wind resistance into account. The fixation of the boards on the frame under the effects of the wind will be defined by the following elements :

- the individual acceptable wind resistances under the attachment head in the board. They have been measured with tear resistance tests.
- the acceptable tear resistance of the board and framework system, measured through the wind resistance test.
- the wind arrow on the boards. It is limited to 1/100e of the range between the fixing points.

As part of the technical detail from the CSTB, tear and wind resistance tests have been carried out on the Polyrey Facades range in a ventilated facades assembly :

Table 1 - Tensile resistance : Individual acceptable resistances (in Newton) depending on the location of the attachments on the Polyrey Facades boards, centreline distance of the posts and thickness

Boards Position	Centreline distance in m	Position of the attachments		
		corner	edge	middle
8 mm	0,4	80	465	600 (900)
	0,6	50	380	600 (780)
	0,75	50	435	600 (650)
10 mm	0,4	135	600 (790)	600 (1620)
	0,6	120	600 (730)	600 (1375)
	0,75	60	600 (665)	600 (1220)

The values between brackets are the resistance values of the boards, but in any case, the maximum value to take into account is the value of the attachment screw, or 600N, for a stainless steel screw of \varnothing 4, 8 mm and 38 mm. length. (Results for wood framework - for metal framework, see technical notice)

Polyrey Facades Exterior Compact has very high tensile resistance, or resistance against sheering of the attachments by wind.

The **wind resistance test** results and the elements of table 1 are used to calculate depression resistances with normal wind conditions for different application types.

Drilling at 20 mm from the vertical edges and at 20 mm from the horizontal edges for rafters' centreline distances of 0,40m (table 2), 0,60m (table 3) and 0,75m (table 4). (Results for wood frame - for metal frame, see technical notice)

Table 2 - Flexural resistance (in Pascal). Centreline distances of the support posts = 0,40 m

Combination fixing V x H	Boards Thickness	Centreline distances of the attachments (m) along the support posts (V)					
		0,2	0,3	0,4	0,5	0,6	0,7
		Acceptable values in Pascal (Pa)					
2 x 2	8 mm	>3000	2180	1680	1370	1160	860
	10 mm	>3000	>3000	2780	2260	1900	1650
3 x 2 n x 2	8 mm	>3000	>3000	>3000	>3000	2920	2070
	10 mm	>3000	>3000	>3000	>3000	>3000	>3000
2 x 3 2 x n	8 mm	>3000	>3000	>3000	2360	1360	860
	10 mm	>3000	>3000	>3000	>3000	2670	1680
3 x 3 n x n	8 mm	>3000	>3000	2400	1920	1600	1370
	10 mm	>3000	>3000	2400	1920	1600	1370

n > 3

V: Attachments on the vertical (along the frameworks)

H: Attachments on the horizontal (follows the framework's centreline distance)

Table 3 - Flexural resistance (in Pascal). Centreline distances of the support posts = 0,60 m

Combination fixing V x H	Boards Thickness	Centreline distances of the attachments (m) along the support posts (V)					
		0,2	0,3	0,4	0,5	0,6	0,7
		Acceptable values in Pascal (Pa)					
2 x 2	8 mm	1300	910	710	570	480	420
	10 mm	2670	2260	1750	1420	1200	1040
3 x 2 n x 2	8 mm	> 3000	3000	2320	1890	1600	1380
	10 mm	>3000	>3000	>3000	2960	2500	2160
2 x 3 2 x n	8 mm	1360	1360	1360	1360	1360	860
	10 mm	2670	2670	2670	2670	2500	1680
3 x 3 n x n	8 mm	>3000	2130	1600	1280	1060	900
	10 mm	>3000	2130	1600	1280	1060	900

n > 3

V: Attachments on the vertical (along the frameworks)

H: Attachments on the horizontal (follows the framework's centreline distance)

Table 4 - Flexural resistance (in Pascal). Centreline distances of the support posts = 0,75 m

Combination fixing V x H	Boards Thickness	Centreline distances of the attachments (m) along the support posts (V)					
		0,2	0,3	0,4	0,5	0,6	0,7
		Acceptable values in Pascal (Pa)					
2 x 2	8 mm	700	700	610	500	420	360
	10 mm	1300	920	710	580	490	420
3 x 2 n x 2	8 mm	1680	1680	1680	1680	1460	1260
	10 mm	>3000	>3000	3000	2370	2000	1730
2 x 3 2 x n	8 mm	700	700	700	700	700	700
	10 mm	1360	1360	1360	1360	1360	1360
3 x 3 n x n	8 mm	1680	1680	1280	1020	850	730
	10 mm	2560	1700	1280	1020	850	730

n > 3

V: Attachments on the vertical (along the frameworks)

H: Attachments on the horizontal (follows the framework's centreline distance)

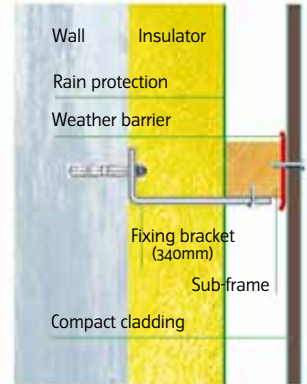
2. Shock resistance

Two tests have been carried out on Polyrey Facades Exterior Grade Compact used in a ventilated facade, in order to guarantee its shock resistance :

- Shocks from soft objects (sand bag).
- Shocks from hard objects (marble).

For these tests particularly long squares have been used to simulate the implement of a very thick insulation layer, which can be necessary within the context of RT 2012.

The Polyrey Facades is very resistant to different kinds of mechanical shocks.



B General building principles

Following processes are necessary for installing the boards :

- Positioning of framework, insulation, rain resistant film, vertical protection strips (or watertightness strips).
- Fixing the Polyrey Facades boards on the framework with fixed and sliding points.
- Ventilation opening of the air shaft
- Checking the fixings, angles and special points.

1. Positioning of framework, insulation, rain resistant film

The positioning of the frameworks must be operated according to prescriptions of CSTB Specification 3316 and its modifications 3422 and 3585-V2.

2. Fixing the boards: fixed and sliding points

The boards can be submitted to dimensional variations due to heat and humidity. These variations are, at maximum, 2 mm per linear metre in the longitudinal direction and 5,5 mm/m in the transversal direction.

When fixing the boards, these dimensional variations should be taken into account. It's recommended to install the board with a fixed point and several sliding points. The fixed point is located in the centre of the board, its role is to guarantee the board's correct positioning and to divide the dimensional variations. The sliding points allow a certain liberty of movement to the board.

2a - Drilling of the boards

The drilling diameter of the holes for the fixed points must be equivalent to the screw or the rivet's diameter. The drilling diameter of the sliding points must be larger than the screw or rivet's diameter :

- **Fixing with screws on wooden framework :**

The drilling diameter of the sliding points must be 3 mm larger than the screw's: 8 mm for a 5mm diameter screw.

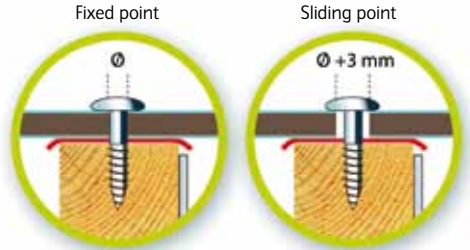
- **Fixing with rivets and automatic driller on a metal framework :**

The rivet's drilling diameter for sliding points must be twice as large as the rivet's.

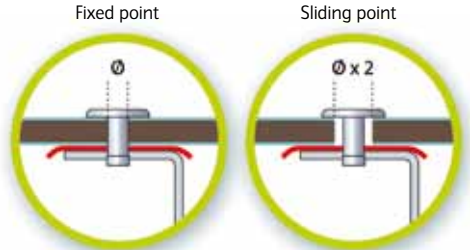
With an automatic driller (of 4,8 mm diameter), sliding point diameters are 8 mm.

Generally speaking, the drilling preservation zone of the board must be of at least 20 mm of the vertical and horizontal edges. It is recommended to use multistep drills to centre the screws correctly.

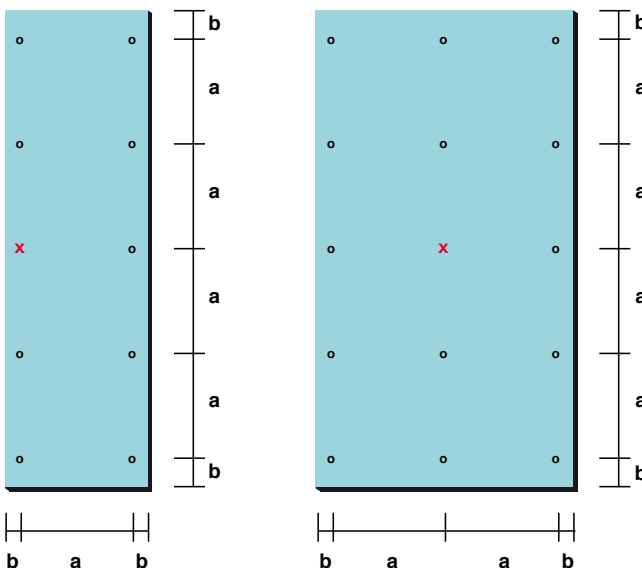
Wooden framework



Metal framework (rivet)



2b - Position and centreline distance of the fixing points on the board



The position and centreline distance of the fasteners are determined according to flexural resistance values (tables 2, 3 and 4 of the previous chapter)

- o = Sliding point
- x = Fixed point
- a = Distance between attachments
- b = Distance between attachments and the edges of the board: minimum 20 mm

2c - Fixing the board to the framework

The positioning of the screws and rivets are carried out from a fixed point in order to prevent the stressing of the board. Fixing the board should always start from its centre and then move to the edges. You must not jam the attachments nor tighten them to the framework; The boards need to expand freely. Screws must be put in with a screw gun with torque limiters or depth stop. Rivets are put in with a clamping wedge.

The fastener head must cover the drilling hole.

3. Ventilation opening of the air cavity

The air gap between the wood panelling and the building must be ventilated.

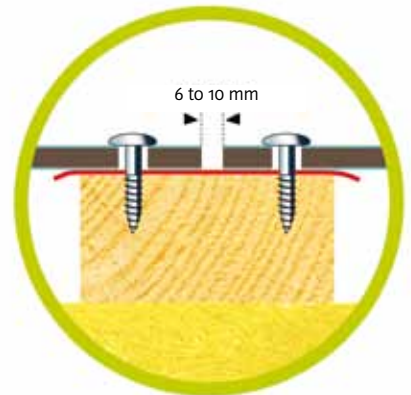
Openings through at the top and the bottom of the panelling allow the ventilation of the cavity. These ventilation openings should have a section proportional to the facade's height.

Below, at the foot of the panelling, the opening must be protected from rodents with frames with perforated solid cores. At the top, the opening is protected with a rain protection covering.

4. Checking the fixings, angles and special points

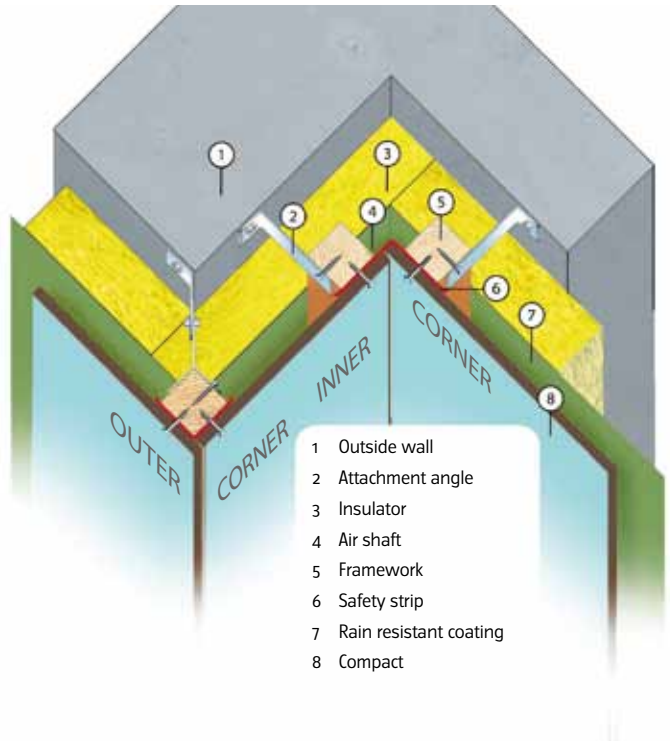
Fixings : Because of the dimensional variations the boards must be put up in a way that leaves vertical and horizontal connexions with a minimum width of 6 mm. It is recommended to stay under widths of 10 mm.

The framework's front must be covered with a protection strip or watertightness strip larger than the framework. A rain resistant film must also be used on the insulation.



Corner connections must also count with the board's expansion space. It's possible to use profiles or metallic parts, as well as for outer as inner corners. To avoid tensions during the assembly, the corner element must be as small as possible.

The boards in the corner must be fixed to the framework at the corners' levels to avoid any move if shocked.



Some assembly examples :

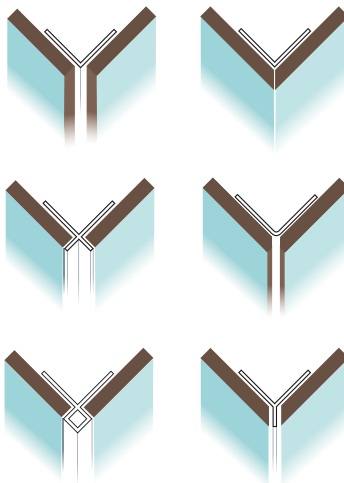
Without profile



Interior profile

Straight cut

Mitre joint cut



Exterior corner piece



Special points for openings : doors, windows and joists can be treated with profiles.

Your usual supplier proposes profiles and corner pieces in matching colours for every Polyrey Facades decor. (Etanco, SFS or similar)



C Cleaning and repair



Polyrey Facades boards are easy to clean because their surface isn't porous, therefore stains and dirt cannot penetrate the material.

- Superficial dirt can be cleaned with water (cold or warm).
- More persistent stains or graffiti can be cleaned with adapted detergents. It is recommended to test detergents before using them.

A damaged board can be replaced by unscrewing the fasteners and putting up a new board.

D Fixing Options

Fasteners for Compact			
On wooden framework Screw		On metal framework Self drilling screw or rivet	
			

Fasteners for the squares			
On wooden framework Screw		On metal framework Self drilling screw or rivet	
			

Etanco, SFS (or similar) screws and bolts can be colour matched to all Polyrey Facades decors in accordance with RAL/NCS references

- **Frameworks** : It is recommended to use :
Wooden framework: Wood type E4 or E5 class of 80 mm width and 80 mm thickness
Metal framework: Z or U shaped: Either galvanized corrosion resistant steel or aluminium.
- **Elements for watertightness** : Must comply with the CSTB 33/06 specifications.
- **Squares** : Galvanized corrosion resistant steel. They must be positioned quincuncially along the framework.

Experimental results

All tests of the boards' performances when submitted to predictable charges have been carried out by, or under supervision of, different institutions such as CSTB and FCBA.

These tests as well as others carried out by POLYREY's laboratory concern :

- sustainability estimation,
- shock resistance,
- depression resistance.

The references of the protocol on the fire resistance test taken into account for the announcement of the inflammability ratings of the panelling boards of 8 and 10 mm thicknesses are :

Euroclasses EDF ranking report : n° 10/RC40 du FCBA en date du 23/06/2010

Euroclasses EDS ranking report : n° 10/RC41 du FCBA en date du 23/06/2010

Euroclasses EDF test report : n° 404/10/158-1 du FCBA en date du 22/06/2010

Euroclasses EDS test report : n° 404/10/158-2 du FCBA en date du 22/06/2010

Technical assistance

Please ask us any technical question by email on the following address: facades@polyrey.com

POLYREY is the manufacturer of the Compact material therefore if installation is required, this is carried out by specialist cladding companies. However, do not hesitate to contact Polyrey for further technical support.

Garantee

Polyrey only guarantees the quality of the Polyrey Facades Exterior Grade Compact. Providing the recommendations outlined in the technical guide, Polyrey can not guarantee the material in the case of faults during the machining or installation phases.

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Samples ordered before 3pm are dispatched the same day.

Polyrey makes every effort to assure you the receipt of your samples within 48 hours