

# PROCESSING OF BOND PANELS

The back side is milled and the panel is folded in.  
When milling a panel, one of three ways can be chosen:



A common cutter with a typical blade



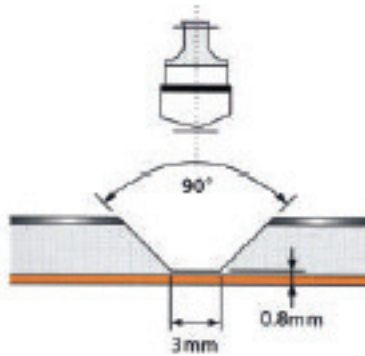
Disk milling machine to define the right angle



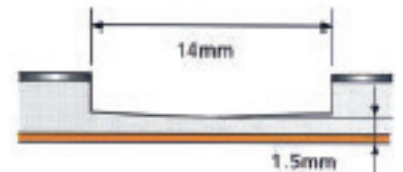
Atypical saw



Cold bending

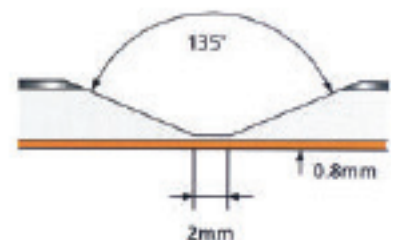
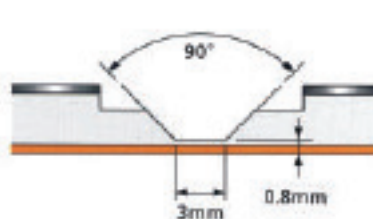
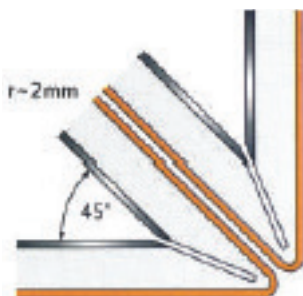
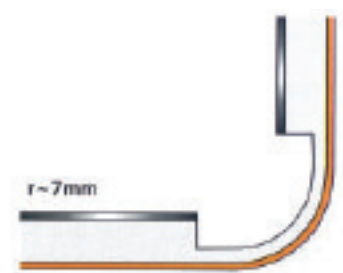
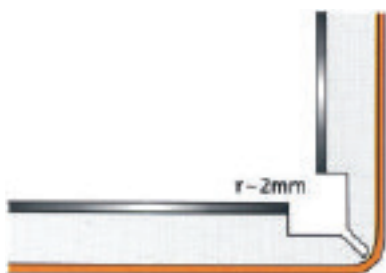


Sharp 90° angle (V-angle) to create a right angle



**Inappropriate**

Rectangular milling to create a 150° angle depends on the thickness of the panel



Sharp 135° (V-angle) for angles up to 135°

## Processing methods

The BOND panel is easy to process. Methods of treatment such as cutting, milling, grooving, folding, bending can be realized by simple tools for wood and metal.

### Riveting



Recessed rivet for easy connection from one side.

### Welding



Welding conditions:  
Welding temperature: 230-240° C  
Compressor pressure: 0.3-0.4 kg/cm<sup>3</sup>  
Process pressure: 1.0-1.5 kg  
Welding speed: 1000 m / min

### Cutting



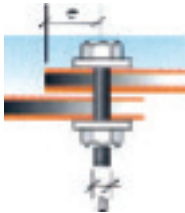
Simple wood cutting process. We recommend using a blade of hardened material.

### Bonding



You can achieve maximum adhesion when using special adhesives or single-component elastomeric polyurethanes.

### Screw in



When defining the distance of the bolt position (screw hole) from the edge of the board, it is necessary to take the form  $\geq 2D$  where D is the diameter of the hole. It is counted from the center of the hole to the edge of the board.

### Bending



When the BOND panel bends, the matrix must be positioned at the correct radius. The required DEBOND parameters are listed in the table.

BOND panel thickness (mm)	vertically	cross
3	65	55
4	75	55
6	90	80

### Cutting



The cutting machine is the most efficient for processing a large amount of BOND panel, sharp edges (burrs) may occur. The correct gap (gap) and slope are listed in the table.

BOND panel thickness (mm)	gap	angle
3	0,04	1°
4	0,04	1°30"
6	0,2	2°30"

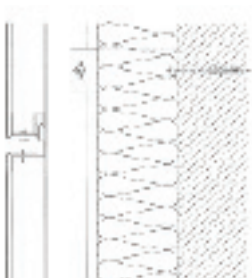
## Example of using basic AL profiles from the Dencop Lighting in practice

Code: 39659660  
Aluminium structural profile „OMEGA” rod = 6 m /6596/

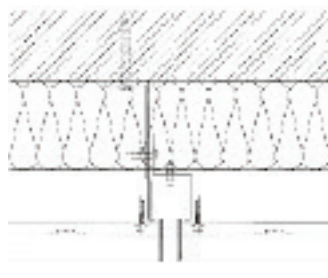
Code: 39659760  
Aluminium structural profile „Z” rod = 6 m /6597/

Code: 39659860  
Aluminium structural profile „S” rod = 6 m /6598/

### Vertical cut



### Horizontal cut



Details of Al-profile connection „Z” and „S”

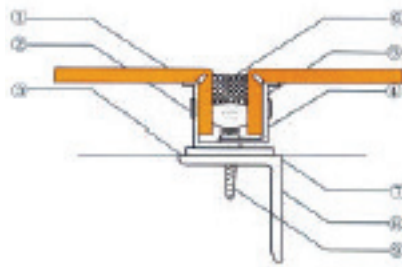
Sample of implementation of aluminum profile „Omega”, „Z” and „S” Lidl Hradec Kralove

# Installation scheme

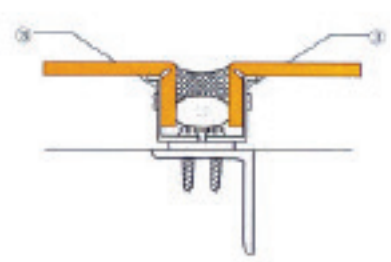
1. BOND panel
2. Rivets
3. Metal part L from AL
4. Metal part L from AL
5. Sealing material
6. Spacer (sealing)
7. Spacer
8. Angle bar
9. Screw

## Panel mounting method - Variant A

Fixed joint with L part (1)



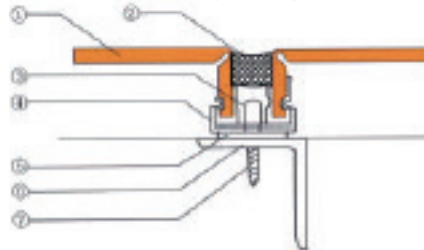
Fixed joint with L part (2)



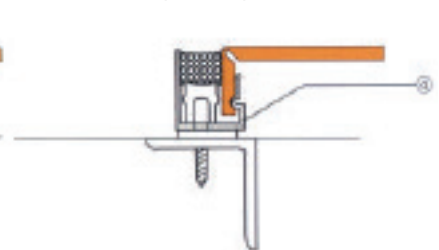
1. BOND panel
2. Sealing material
3. Plastic pad
4. Special profile
5. Spacer (sealing)
6. Angle bar
7. Screw

## Panel mounting method - Variant B

Fixed connection  
Using a special profile (1)



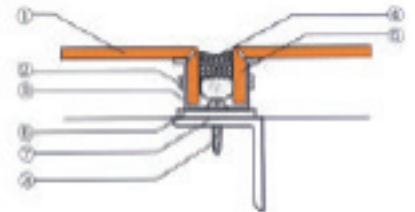
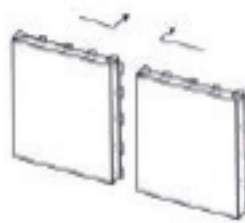
Fixed connection  
Using a special profile (2)



Accessories mentioned above are used for low buildings.

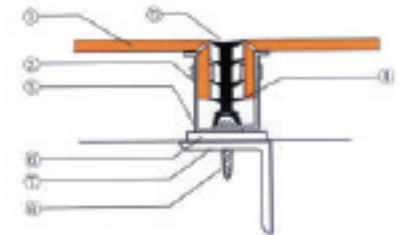
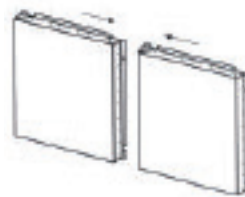
1. BOND panel
2. Rivets
3. Metal part L from AL
4. Sealing material
5. Spacer (sealing)
6. Spacer (sealing)
7. Angle bar
8. Screw

## Panel mounting method - Variant C



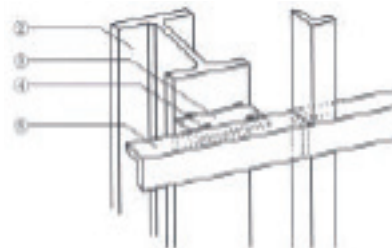
1. BOND panel
2. Rivets
3. Metal part L from AL
4. Metal part L from AL
5. Sealing ring
6. Spacer (sealing)
7. Angle bar
8. Screw

## Panel mounting method - Variant D

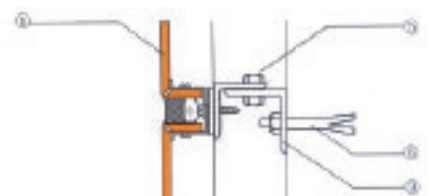
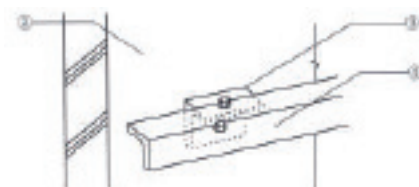


## Sample of inverted structure

1. BOND panel
2. Carrier pillar
3. Angle pillar
4. Weld
5. Angle bar

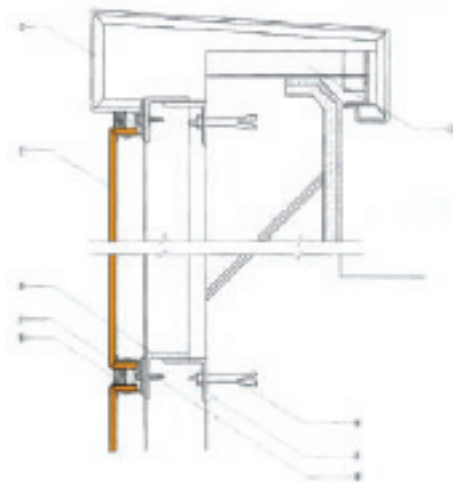


1. BOND panel
2. Carrier pillar on the wall
3. Angle pillar
4. Metal part L from AL
5. Screw
6. Recessed part



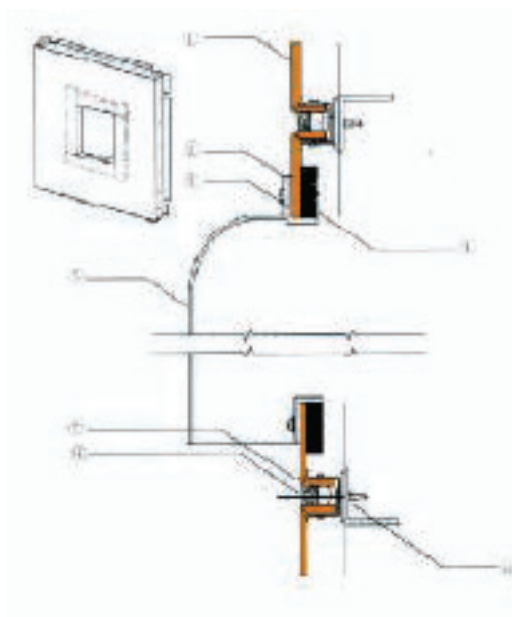
### Example of ending instalation (top part)

1. BOND panel
2. Top of the building
3. Angle pillar
4. Angle pillar
5. Angle lath
6. Sealing material
7. Insulating material
8. Screw
9. Anchor screw



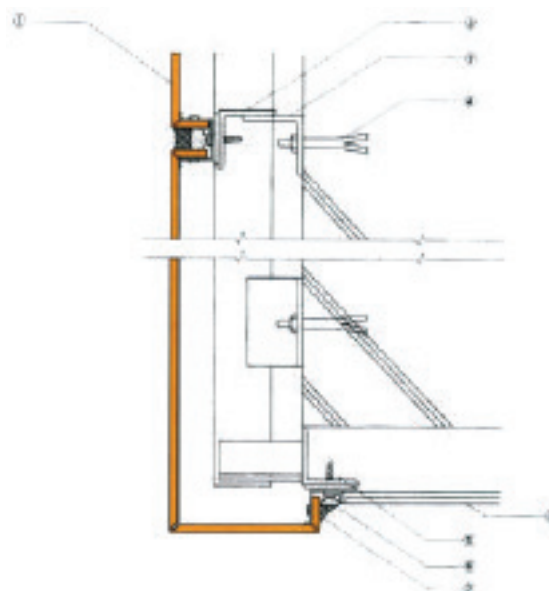
### Example of hole instalation

1. BOND panel
2. Sealing material
3. Adhesive tape
4. Veneer (newsboard)
5. Sealing material resistant to climatic influences
6. Sealing material
7. Insulating material
8. Screw



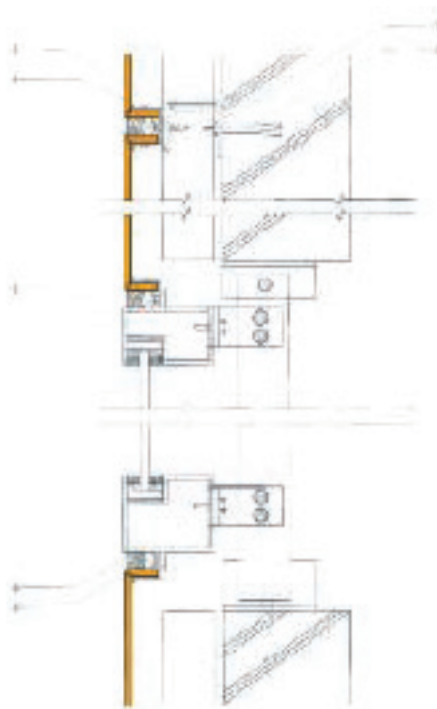
### Example of basic instalation

1. BOND panel
2. Angle lath
3. Angle pillar
4. Sealing material
5. Insulating material



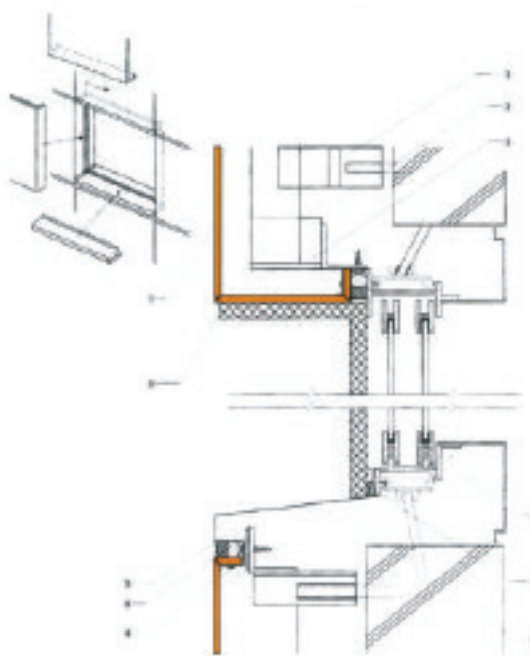
### Example of window frame instalation

1. BOND panel
2. Anchor screw
3. Angle pillar
4. Angle lath
5. Sealing material
6. Insulating material
7. Outside window frame



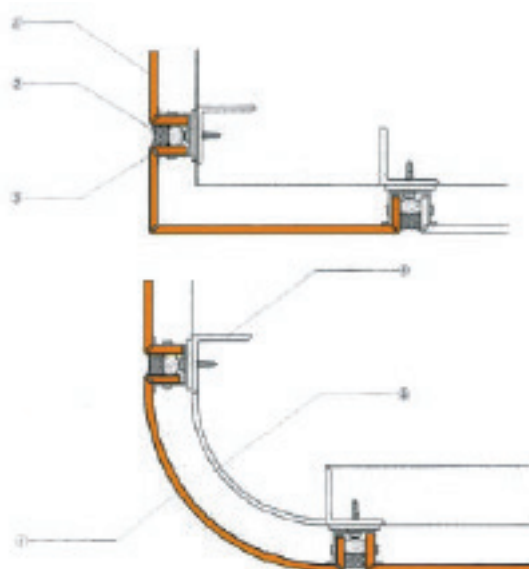
### Example of window frame instalation of a repaired building

1. BOND panel
2. Anchor screw
3. Angle pillar
4. Angle lath
5. Sealing material
6. Insulating material
7. Silentblock
8. Screw
9. Window frame
10. Original supporting wall



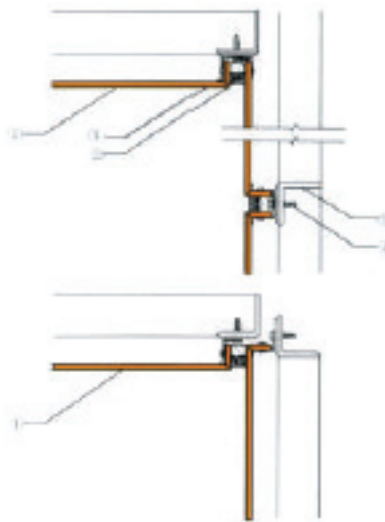
### Example of external window corner instalation

1. BOND panel
2. Sealing material
3. Insulating material
4. Angle lath
5. Steel reinforcement



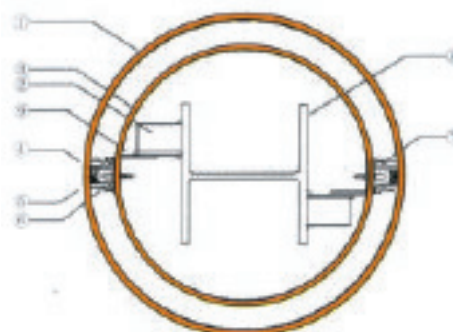
### Example of window corner instalation

1. BOND panel
2. Sealing material
3. Insulating material
4. Angle lath
5. Screw



### Example of pole casing

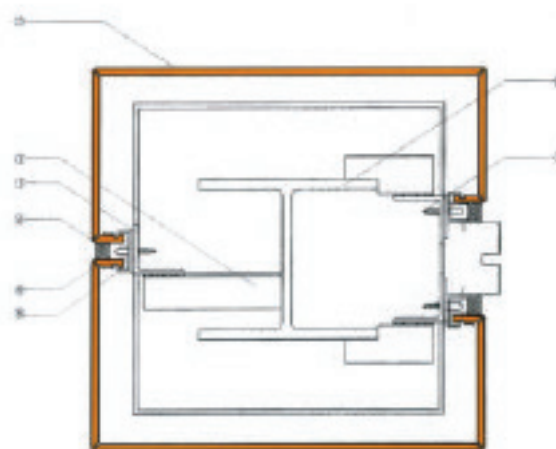
1. BOND panel
2. Angle reinforcement
3. Steel reinforcement
4. Sealing material
5. Plastic insulating lath
6. Special profile
7. Screw
8. Carrier pillar



Accessories mentioned above are used for low buildings.

### Example of pillar casing

1. BOND panel
2. Angle reinforcement
3. Angle lath
4. Sealing material
5. Plastic insulating lath
6. Special profile
7. Screw
8. Carrier reinforcement



Accessories mentioned above are used for low buildings.

### Example of eaves instalation

1. BOND panel
2. Angle reinforcement
3. Angle lath
4. Anchor screw
5. Sealing material
6. Insulating material
7. Screw
8. Ceiling

