

SAWING INSTRUCTIONS NEW DIRECTIVE

To prevent buckling in façade sandwich panels in particular, some types of blind façade panels must be sawn according to a specific sawing method. The following guideline applies to this:

- For the SAB WB with a core thickness of 120 or 140 mm, we recommend using this sawing method at temperatures below 10°C.
- For the SAB WB with a core thickness of 100 mm, this method should be used at temperatures below 5°C.

Note:

Follow the step-by-step plan on the next page carefully. In addition, make sure that the panel is supported flat and stable on multiple pallets or eps blocks when cutting.



SAB-profiel bv - A Tata Steel Enterprise

Produktieweg 2, NL-3401 MG IJsselstein

Postbus 97, NL-3400 AB IJsselstein

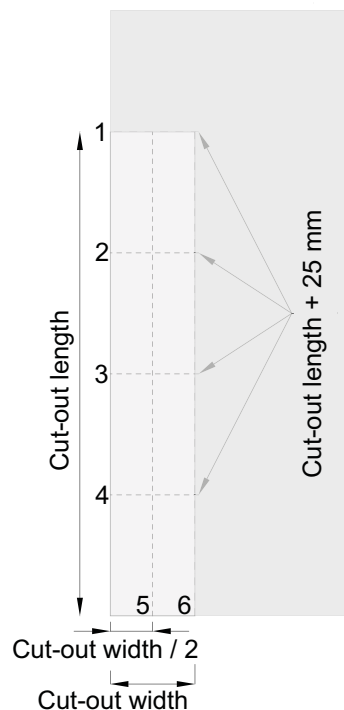
T +31 (0)30 68 79 700

E info@sabprofiel.nl

www.sabprofiel.nl

REMOVING CORNERS IN A PANEL – STEP-BY-STEP PLAN

1. Determine the dimensions of the compartment to be cut out of the panel.
2. Divide the length (Cut-out length) over the desired number of cuts in width. A saw cut must be made at regular intervals (e.g. every meter) (numbered 1 to 4).
3. Make the cuts: Cut each cut 25 mm beyond the specified width (Cut-out width). See the image for clarification.
4. Cut in the longitudinal direction (cut number 5), at the centre of the width (Cut-out width/2), as shown in the figure.
5. Make cut 6 in the position that corresponds to the desired size of the compartment (cut-out width, see figure).



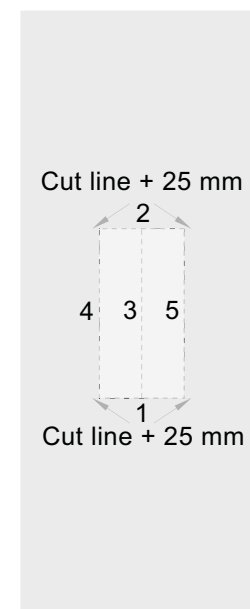
Important: Cuts 5 and 6 must not run past cut 1!

Sawing instructions – Important

Panels should only be cut with a circular saw. In the corners, where the steel has already been sawn through but the foam has not, a hand saw may be used to carefully loosen the foam.

REMOVING A COMPARTMENT IN THE MIDDLE OF A PANEL – STEP-BY-STEP PLAN

1. Determine the dimensions of the compartment to be cut out of the panel.
2. Cut lines 1 and 2 both 25 mm longer than the desired size of the box. See the image for clarification.
3. Calculate half of the compartment width (Cut/2) and perform cut 3 at this position (see illustration).
4. Cut lines 4 and 5 to clear the compartment completely.



Important: Saw cuts 3, 4 and 5 must not extend beyond cuts 1 and 2!

SAB-profiel bv - A Tata Steel Enterprise

Produktieweg 2, NL-3401 MG IJsselstein

Postbus 97, NL-3400 AB IJsselstein

T +31 (0)30 68 79 700

E info@sabprofiel.nl

www.sabprofiel.nl