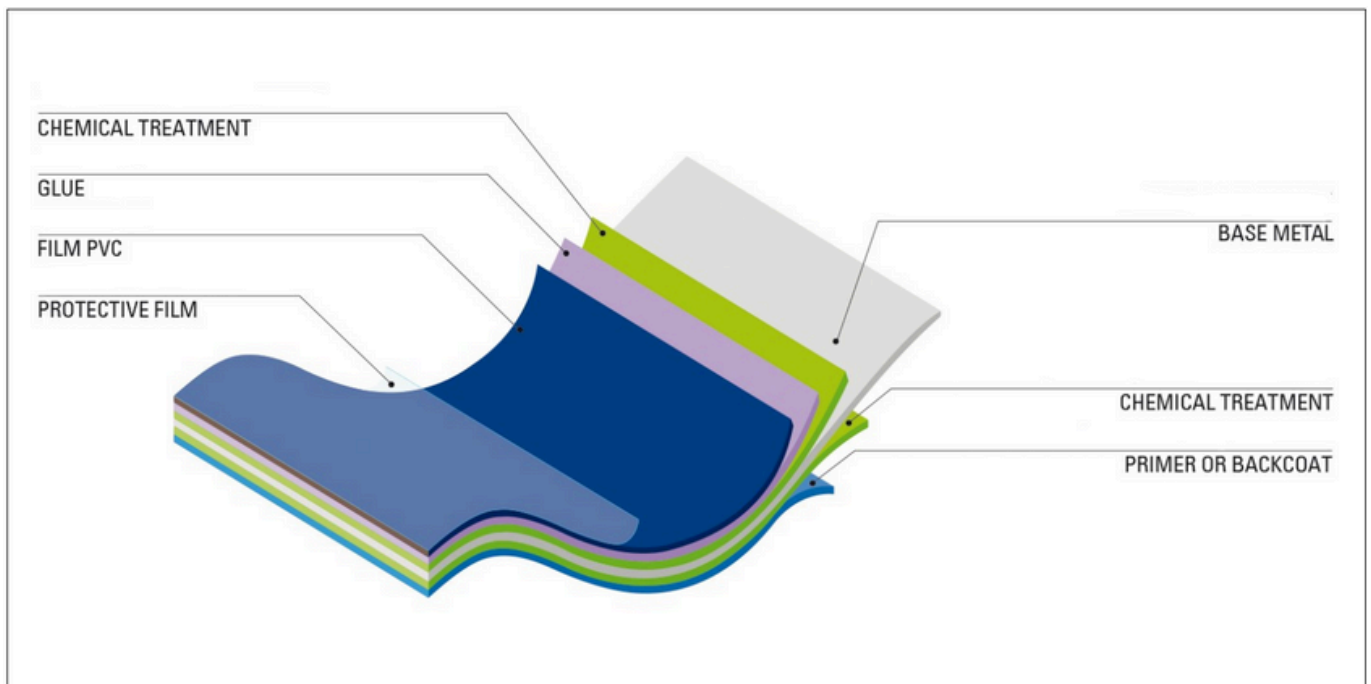




TECHNICAL FEATURES

CAP PVC

Indoor use



CAP PVC it is formed by a metal support pre-coated with PVC film, the film can be formulated for interiors, it can be plain or printed and with a smooth or embossed finish, and thanks to its characteristics it can be used in many sectors and for most various applications.

Furniture	for shelves, metal storage cabinets, dental clinic furniture, vending machines
Lifts and elevators	cabins and doors for lifts
Building	panels, partitions, security doors, suspended ceilings, light fittings
White goods and cooking appliances	dishwashers and washing machines, kitchen side panels and front doors of ovens.
Industrial refrigeration	cooker hoods, drawers and cabinets.
Cooling appliances	coldrooms, drink coolers and dispensers, water coolers, refrigerators for medical purposes
HVAC Industry	air handling units, water boilers, heating elements
SUBSTRATES	
HDG steel	
Cold-rolled steel	
Electrogalvanized steel	
Aluminium	
Stainless steel	

MEASUREMENTS			
Substrate thickness	From 0.30 to 2.0mm		
Substrate aluminium th.	From 0.50 to 2.0mm		
Max. coil size	1500 mm		
Min. coil size	700 mm		
Coil ID	500 mm		
Max. strip width	1500 mm		
Min. strip width	19 mm		
Max. sheets size	1500 x 6000 mm		
# minimum thickness x sheet cutting process 0,45 mm			
COATING OF UPPER FACE		BACKSIDE COATING	
Polyvinylchloride film (PVC)			
Self-sticking peeling protective film (to be removed not later than 6 months after the mill's manufacturing date. In absence of the protective film, the customer takes responsibility for any pressure mark and / or surface defect. The suitability of the protective film for its production process / finished product must be confirmed by the customer through specific tests		3-5 micron thick primer, suitable for foaming/gluing with PUR or glues (all foaming/gluing tests have to be performed by the customer and are on his behalf)	
		On request: Coloured backing-coat 10-12 micron (+/- 2	

GENERAL FEATURES		Test standards	Solid colour and printed Test results
CG.1	Thickness film	UNI EN 13523-1	
	Surface finish Semirigid film		120-300 µm
	Surface finish Rigid film		100-200 µm
	Thickness tolerance		± 7 %
CG.2	Colour	UNI EN 13523-3	BLUE / RED / GREEN / ORANGE / YELLOW : DE MAX 1,5
		Solid colours	BEIGE / BLACK/ BROWN/ GRAY /WHITE : DE MAX 1 SILVER : Only visual control, possible variation of shade and embossing among different batches.
		Printed	Colour Consistency not measurable by instruments,only visual control.
CG.3	Gloss level	UNI EN 13523-2	Gloss
	Semirigid film	M/SM/P/PR/PV/V	Min 5 max 40
	Rigid film	SA/SMA/SFA/TA/PVA	Min 5 max 40
CG.4	Maximum temperature range for end use	-20 °C + 60 °C	No significant change

Values refer to the codes given by the mill. In case of other types of films, we must check type by type.

** In order to avoid possible shade differences it is advisable to use materials coming from the same manufacturing batch.

MECHANICAL FEATURES		Test standards	Test results
CM.1	Adhesion after drawing 6 mm	UNI EN 13523-6	Good
CM.2	Adhesion after cupping (all products)	UNI EN 13523-7	≥ 1T
CM.3	Resistance to rapid deformation (impact test)	UNI EN 13523-5	16 J no visible cracks using a magnifying lens 10x

*** PVC films in dark or vivid colours can show a whitening on the bend, depending on radius and machines. The client himself must evaluate this phenomenon on his own final production.

CHEMICAL-PHYSICAL FEATURES		Test standards	Test results
CCF.1	Corrosion resistance	UNI EN 13523-8	
	Hot-dip galvanised steel		360 h creepage max 2 mm no blisters
	Electro-galvanised steel		190 h creepage max 2 mm no blisters
	Cold-rolled steel		190 h creepage max 2 mm no blisters
	Stainless Steel A304 2B °		1000 h without penetration
	Stainless Steel A430 2B °		360 h creepage max 2 mm no blisters
	Aluminium °°		1000 h without penetration
CCF.2	Resistance at 100% relative humidity		UNI EN13523-26
CCF.3	Resistance to solvents		Not Sufficient
CCF.4	Stain resistance	UNI EN13523-18	
	Semi rigid film		Build-up off marks/stains in contact with fresh tomato and coffee
	Rigid film		

° The test results refer to non-treated surfaces. In case of scotch bright and hair-line products, the tests are in function of the degree of the surface roughness

°° The test results refer to the quality of the aluminium defined by the mill. In case of material supplied by the customer, tests must be agreed upon.

CERTIFICATIONS		Test norms	Test results
CER.1	Reaction to fire classification for building products	EN 13501	Classification A2 (*) depending on the type of pvc
CER.2	Certificazione di Equipaggiamenti marittimi secondo direttiva europea MED Marine Equipment Certification according to European MED Directive	Direttiva europea 2014/90/EU e successivi emendamenti European Directive 2014/90/EU	Certificati MED B e MED D (*) in funzione della tipologia di pvc Certificate MED B and MED D (*) depending on the type of pvc

CLEANING INSTRUCTIONS FOR CAP PVC			
P.1	General rules	P.2	Removal of small stains
	In order to clean the surface please use only water and neutral soap. It's advisable to use a soft cloth, rinsing and drying up the surface with care. Please avoid using cleaning agents containing abrasive particles.		Surface stains can be removed using mineral turpentine or denatured alcohol. It's impossible to remove the stains which have been absorbed by the PVC film. REMARK: one must avoid solvents such acetone, toluene, and so on because they are very aggressive on the PVC films.

WAREHOUSING AND PROCESSING CAP PVC

D.1	Coils or pallets of precoated materials should be stored under a roof and in places not subject to big changes of temperature in order to avoid the possibility of condensation.	L.1	Precoated materials should be preferably utilized (within six months from reception) and using appropriate machines to avoid abrasions, scratch, cuts, marks on the film surface and/or cracks of the same or even of the zinc layer.
D.2	Materials protected with peeling film for temporary protection must be placed far away from heat/humidity sources and not exposed to direct solar rays. The protective peeling film should anyway be removed within and not later than 6 months from the mill's manufacturing date.	L.2	During roll forming or bending it is necessary that the tools should contemplate not only the thickness of the material itself but also the possible tolerances so as to avoid re laminations.
D.3	During transport the material must be protected from moisture and condensation. It must be loaded on vehicles in such a way as to ensure protection from collisions, abrasions and overturning.	L.3	As far as flatness of strips and coils is concerned, please do refer to what mentioned in UNI EN 10143.
		L.4	The ideal temperature at which materials must be formed or bent or punched should be around 18° C.

Production range :

Cold rolled steel Electrogalvanized steel HDG steel		Thickness (mm)										
		0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.2	1.5	2.0
Width (mm)	700/800	●	●	●	●	●	●	●	●	●	●	●
	800/900	●	●	●	●	●	●	●	●	●	●	●
	900/1000	●	●	●	●	●	●	●	●	●	●	●
	1000/1100	●	●	●	●	●	●	●	●	●	●	●
	1100/1200	●	●	●	●	●	●	●	●	●	●	●
	1200/1300	●	●	●	●	●	●	●	●	●	●	
	1300/1400		●	●	●	●	●	●	●	●		
	1400/1500		●	●	●	●	●	●	●	●		

Stainless steel		Thickness (mm)										
		0.3	0,4	0.5	0.6	0.7	0.8	0.9	1.0	1.2	1.5	2.0
Width (mm)	700/800		●	●	●	●	●	●	●	●	●	
	800/900		●	●	●	●	●	●	●	●	●	
	900/1000		●	●	●	●	●	●	●	●	●	
	1000/1100		●	●	●	●	●	●	●	●	●	
	1100/1200		●	●	●	●	●	●	●	●	●	
	1200/1300		●	●	●	●	●	●	●	●		
	1300/1400			●	●	●	●	●	●			
	1400/1500			●	●	●	●					
Aluminium		Thickness (mm)										
		0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.2	1.5	2.0
Width (mm)	700/800			●	●	●	●	●	●	●	●	●
	800/900			●	●	●	●	●	●	●	●	●
	900/1000			●	●	●	●	●	●	●	●	●
	1000/1100			●	●	●	●	●	●	●	●	●
	1100/1200			●	●	●	●	●	●	●	●	●
	1200/1300			●	●	●	●	●	●	●		
	1300/1400				●	●	●	●	●	●		
	1400/1500				●	●	●	●	●	●		

If the processing carried out does not comply with the parameters indicated, the customer assumes responsibility for the processing carried out.

Acceptance

Date :

Company stamp :

Name and signature of the authorised person :