

BASIC INFORMATION FOR CHROMATECH ULTRA

Dear customer,
one of the major advantages of Chromatech Ultra is the easiness of bend with every bending machine with no substantial investments. Nevertheless some simple suggestions are needed to optimize bending quality.



BENDING:

Overbend the corner by approximately 15° - 17°

Use a specific bending tool (ALU-PRO can supply it) or use a bending aluminium tool (punch) 2 mm less than the size of the spacer to be bent. For instance to bend a 15.5 mm spacer use a 13.5 mm punch (the punch should be in the centre with 1 mm of distance)

Slightly increase side pressure to obtain a correct width of the corner.

CUTTING:

Always use a specific blade. ALU-PRO can supply a specific blade for aluminium and Chromatech Ultra.

The same blade can be used for cutting aluminium and ultra profiles reducing the rate of about 20% compared to aluminium.

Slow down at the minimum level the speed of blade raising.

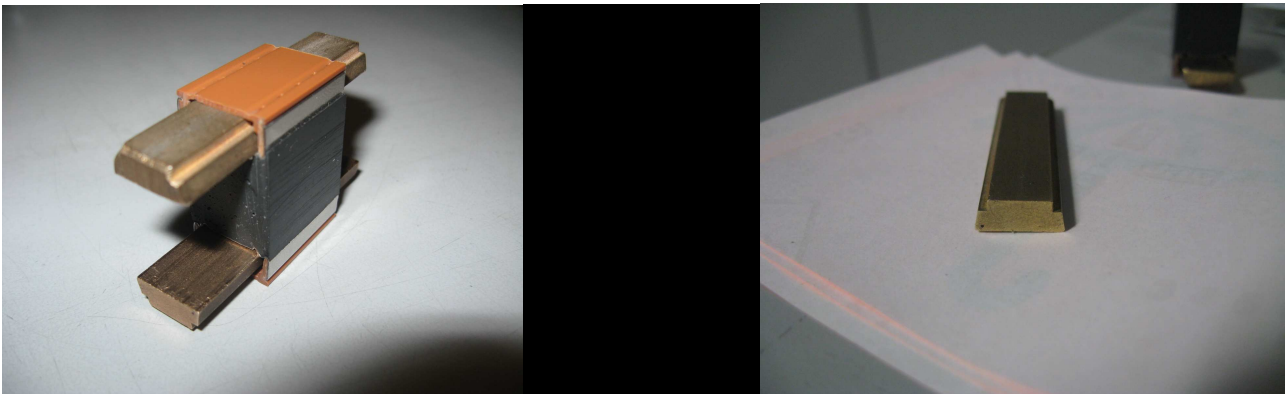
Increase the lubrication on the blade.

Always remember that the Chromatech Ultra is 7 mm high while aluminium spacers bar are 6,5 mm high. It is required to increase the height of the sliding guide of the spacer bar in order to avoid a bad automatic junction between the spacers.

If further instructions on bending will be needed please contact Alu-Pro technical service or your bending machine supplier.

ADHESION CHECK:

When preparing samples for adhesion test according to EN1279-6 F3.2.2 make sure the spacer backside is covered and into contact with the sealant. When pulling the samples support the spacer inside to avoid deformation. If the spacer deforms the adhesion test can fail!



STORAGE AND HANDLING

Storage and use

To secure the performance of the spacers, the stock conditions must be acceptable. Broken packaging, humidity and variation in temperature will have an effect on the spacer in general. Make sure the spacer is conditioned at room temperature before use.

Preferred conditions will be a room temperature over 15°C and humidity RH of minimum 45%

Cartons at the bottom of the stack must not be opened first and the spacer bars should be removed from top to bottom.

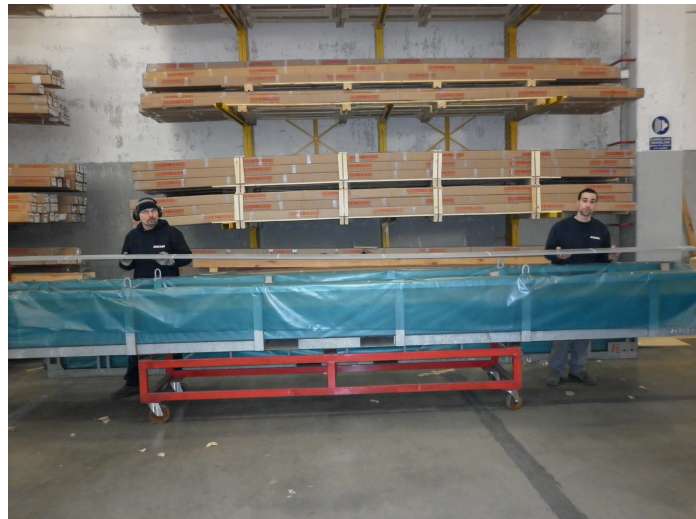
Avoid having an environment with a high concentration of dust. After taking out the spacer bar close the carton. In this way the spacer will be protected from dust and will be traceable after the carton has been opened



Handling

To avoid any dirty on the surface we recommend to use cotton gloves when handling Chromatech Ultra. To avoid any damage during spacer bars' transportation from stock to production, two people transporting bars is recommended.

Handling of complete bundles of 16 bars also reduces this risk. This also ensure minor deflection of the bars in the middle of the bundle.



Cleaning the plastic surface

If for some reason the plastic surface is defiled by dust from other materials it can be cleaned again by the use of water or air. Dust can easily be removed with antistatic loaded compressed air.

The Plastic is not resistant to solvents.