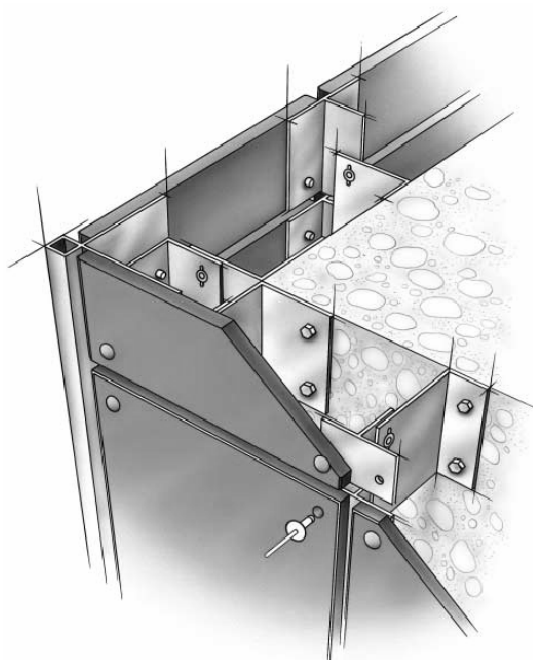


# TWINFIX

## Fixing Instructions for the Twinfix Trespa Rainscreen Cladding Rivet Fix System



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Trespa Meeon is a flat panel based on thermosetting resins, homogenously reinforced with wood fibres and manufactured under high pressure and temperature. Using special techniques, the panels have an integrated decorative surface with pigmented resins.

Trespa International B.V. is the only manufacturer that cures the surface of panel material for external applications using electron beams (Electron Beam Curing). That's what makes Trespa Meeon so highly weather resistant.

The resultant properties make the product particularly suitable for a wide range of exterior applications.

### Sheet thickness and weight

Thickness	Weight
6mm	8.4kg/m <sup>2</sup>
8mm	11.2kg/m <sup>2</sup>
10mm	14.0kg/m <sup>2</sup>
13mm	18.2kg/m <sup>2</sup>

### Sheet sizes

- 3650 x 1860 mm
- 3050 x 1530 mm
- 2550 x 1860 mm

### Colours

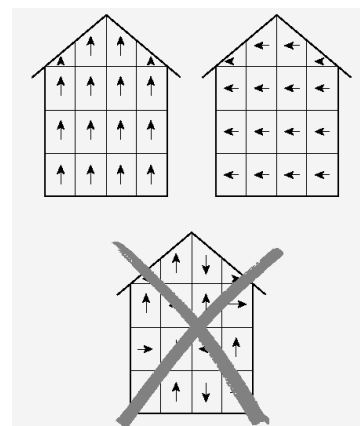
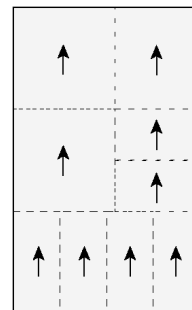
Sheets for façade applications are supplied in more than 50 standard colours.

### Properties

- Weather-resistant
- Colourfast
- Impact resistant
- Easy to clean (even graffiti)
- Scratch resistant
- Low maintenance
- Wide range of colours
- Easy to machine (can be undertaken on site)

## Fabrication and installation of Trespa Meeon Metallic

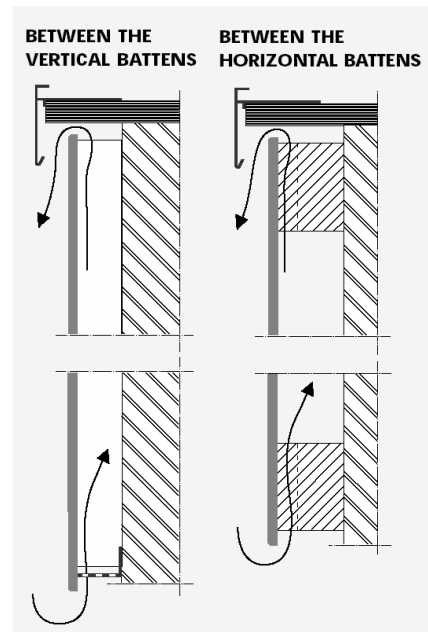
- Trespa Meeon Metallic panels feature a directional coloured surface. In order to achieve the same orientation of the panels please take notice of the following points:-
- When optimizing Trespa Meeon Metallic panels the direction should always be taken into account. Arrows on the back side of the full size panels have been applied by Trespa to indicate the direction the sheets have been produced.
- When cutting the sheets we advise you to temporarily mark the original production direction on the visible side of the individual panels. The fixing of the panels in the same direction will be easier and this way there will be no undesirable colour distinction. All other instructions for processing and fixing are as standard Trespa Meeon panels.
- Corner profile and sheet lengths have corresponding direction.
- The quantity of Trespa Meeon Metallic sheets required for a project should be ordered and supplied as a single instruction.



## General instructions

- **Certificate:**  
BBA, Agrément Certificate no. 91/2628.
- **Guarantee:**  
On request for a period of 10 years.
- **Ventilation:**  
The ventilation provisions below apply:
  - A ventilated air cavity at least 20mm wide;
  - Ventilation opening at the top and bottom of the façade cladding, windows and fascias.

Façade cladding height	Ventilation surface
To 1m	≥ 20cm <sup>2</sup> /m <sup>2</sup> for fascias
Above 1m	≥ 50cm <sup>2</sup> /m <sup>2</sup> for fascias
- **Joints:**  
The joint width is minimum 10mm + thickness of possible joint profiles.
- **Fixings:**  
Centralise screws and do not overtighten as this will obstruct the movement of the panel.  
(NB: machines with a depth stop are available for this purpose).



## Processing

### Cutting

- **Hand circular saw:**

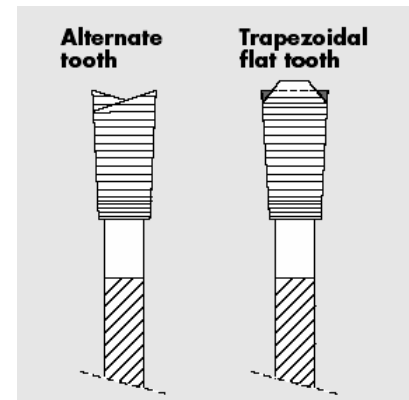
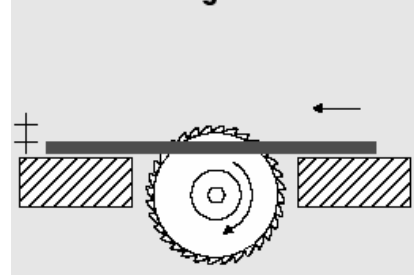
Diameter	Teeth	Speed	Blade thickness	Saw-blade height
150mm	36	4,000	2,5mm	15mm
200mm	46	4,000	3,0mm	20mm

- **Stationary circular saw:**

Diameter	Teeth	Speed	Blade thickness	Saw-blade height
300mm	72	6,000	3,4mm	30mm
350mm	84	5,000	4,0mm	35mm
400mm	96	4,000	4,8mm	40mm

- **Feed:**  
7 – 22m/min
- **Tooth:**  
Hard metal wood-working tools, carbide-tipped alternate tooth or trapezoidal flat tooth.
- **Jig saw:**  
Carbide-tipped saw; interior corners of cut-outs should be drilled with 6mm hole diameter.
- **Entering tooth:**  
At the decorative side of the panel.
- **Cut edges:**  
The best results are obtained with stationary tools; any sharp edges can be removed with sandpaper.
- **Rake angle:**  
A rake angle of 45° gives the best cutting performance.

### Saw-blade height



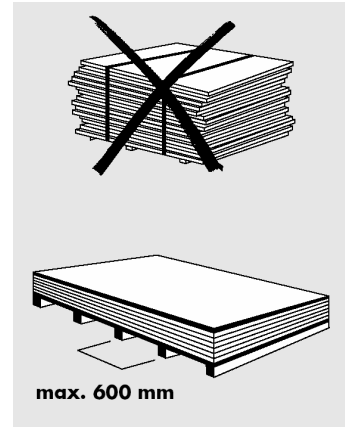
### Drilling

- Carbide-tipped HSS-drill, top angle 60-80°.  
Panels should be drilled with support sheets.

Diameter	Speed	Feed
5mm	3,000	60-120mm/min
8mm	2,000	40-80mm/min
10mm	1,500	30-60mm/min

## Transportation and storage

- During transportation, use stable flat pallets at least the same dimension as the sheets.
- When moving a sheet, lift it to prevent scratches on the panel surface.
- The sheets should be stored in an enclosed area, protected against moisture and heat, in a normal ambient temperature and humidity.
- For horizontal storage on pallets, the sheets should be supported over the entire surface with a protective layer between the pallet and the sheet and also on the uppermost sheet.
- For vertical storage the sheets, should be upright on their sides and be supported over the full height.
- Stickers should be removed before installation.



## Visible fixing with blind rivets

Fixing panels of min. 6mm thickness on a metal sub-frame is possible with blind rivets. The sub-frame should preferably consist of vertical aluminium profiles which are fixed to the structure with special wall brackets.

- **Fixings:**
  - Rivets: diameter 5mm; hole diameter in panel 10mm;
  - One hole of 5.1mm in centre of panel; 2 fixed points may be made next to each other with a hole of 6mm.
- **Maximum fixing centres:**  
Distances (mm) for a building height up to 12m:
 

Panel thickness	2 fixings in one direction	More than 2 fixings in one direction
6	450	550
8	600	750
10	750	900
- **Panel edge clearances:**  
Minimum 20mm, maximum 10 times panel thickness
- **Panel size:**  
Maximum 3050mm.
- **Tools:**  
The rivet head should be 0.3mm free from the panel surface by using a sliding point attachment.

