

## General information about sandwich panels

### 1. Tolerances

Sandwich panels are also subject to a certain tolerance, these tolerances can be found in the document standard for sandwich panels. Moreover, the production process in combination with the mechanical influences and the properties of the used materials make it impossible to produce sandwich panels deviation free. Optical deviations have no technical reduction of the sandwich panels and are included in the tolerance determination.

### 2. Shipping, transport and storage

Moving the sandwich panels works best with suction cups. It has to be taken care of that the vacuum (the suction cup) is of the correct size and that multiple suction cups are used. The lifted sandwich panel must be prevented from bending.

The transport of sandwich panels by means of lifting bands is also possible, but ensured must be that the distance between the lifting bands is max. 3000 mm and that the lifting bands are no further than 1500 mm from the ends of the sandwich panels. The (ends) edges of the panels must be specially protected.

At the storage of sandwich panels, the panels are supported by foam strips or other suitable spacers with a distance of less than 1000 mm from each other and at the front and back of the sandwich panels at a distance of less than 500 mm. If several panels are stacked, these strips always have to be placed exactly above each other. A general indication of how many sandwich panels can be stacked on top of each other cannot be given because sandwich panels come in many different designs and sizes. In case of doubt, no more than 5 sandwich panels (with the exception of floor panels or sandwich panels with heavy constructions, in this case fewer than 5) may be stacked on top of each other. Heavy and large sandwich panels must be stacked at the bottom of the stack.

Please make sure that sandwich panels are stored flat, dry and are protected against external influences (sunlight, dust, hail, moisture, etc.). The most optimal storage is to store the sandwich panels in a closed warehouse at a normal temperature in a working environment and at an humidity between 40 and 60%.

The storage of sandwich panels longer than 6 months is not recommended.

### 3. Processing of sandwich panels

The further processing and therefore modification of the sandwich panels by the buyer takes place on its own initiative and responsibility as long as Pecocar has not guaranteed a guaranteed ownership. Sandwich panels are used in a wide range of applications, therefore Pecocar can only provide general information about the processing of sandwich panels.

- Before the sandwich panels are further processed, they have to be acclimatized. The processing has to take place at a temperature between 15 and 25 degrees Celsius, and a humidity of between 40 and 60%.
- Inserting screws, rivets and other fasteners can cause damage to the sandwich panels
- Tensile forces have to be checked
- Sandwich panels have to be processed "floatingly" due to the possibility of thermal expansion or shrinking
- The manufacturer's instructions have to be respected when using glue or other adhesives. Even if guidelines are clear, it is still recommended that necessary checks or tests are performed
- Compatibility with the glue must be ensured when using solvents or silicones
- When drilling, milling and sawing the sandwich panels basic guidelines are available that have to be worked on, e.g. according to DIN / EN and VDI
- Tools have to be suitable for processing the various materials. Here it is also recommended to test the usability of such tools before they are being used to achieve optimum results. Wrong tools, or the wrong handling of them, can lead to damaged sandwich panels. The suitability of suitable tools have to be agreed with the manufacturer.
- For all tests, we recommend using samples and documentation as proof.
- Due to the adhesives usually used, our sandwich panels are only suitable for use at temperatures up to 80°C on the top layer. Suitability up to 90°C on the top layer must be expressly agreed with us by the customer. If the sandwich panels are exposed to higher temperatures than 80°C (or the agreed 90°C) on the top layer, our warranty and liability for defects of the sandwich panels caused by heat, in particular laminate detachment or blistering, is excluded. If such defects occur and there is evidence of use at temperatures above 80°C (or the agreed 90°C) on the top layer, it shall be presumed that the defects have been caused by the effect of heat. The customer is at liberty to prove evidence of another cause.

#### **4. Coating**

In general, sandwich panels are suitable to be coated. If desired, Pecocar can also provide a suitable coating advice.

Lacquering and foiling in colours with RAL light reference value < 40 are unsuitable for sandwich panels used outdoors due to strong heat development and must not be used. If the customer nevertheless carries out such painting or foiling, our warranty and liability for defects in the sandwich panels caused by heat, in particular laminate detachment or blistering, is excluded. Should such defects occur in the case of lacquering or foiling with RAL light reference value < 40, it shall be assumed that they have been caused by the effect of heat. The customer is at liberty to prove another cause.

The grinding of sandwich panels offered and performed by Pecocar serves as the preparation for the coating. Before the coating, the customer or painter may extra need to grind, fill, fill up and repeatedly fill the panel.

#### **5. General information**

When handling sandwich panels, for safety reasons there always has to be worked with suitable protective clothing. Pecocar's warranty may be affected by not adhering these instructions. Our valid terms and conditions can be found on our website [www.pecocar.nl](http://www.pecocar.nl).

Albergen, 10-07-2025