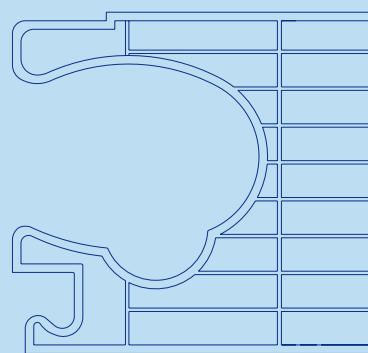


## Technical manual



50

TERMINAL 2



## ISOCLEAR 2550-10

**Translucent Building Elements made of  
Polycarbonate for seamless glazings**

System PC 2550-10 | PC 2550-10 AF 60 | PC 2550-10 AF 120



# General information

## on translucent building elements of Polycarbonate

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### The raw material

Polycarbonate (PC) is a crystal clear, high impact thermoplastic.

### Advantages

- Temperature resistance between -40 to +115°C, temporarily up to +130 °C
- High impact resistance nearly unchanging within these temperatures
- Good long term performance through UV protection

### UV co-extrusion

With this technique a high concentrated UV protection film is homogeneously melted onto the basis material while production process.

### This offers the following advantages:

- No adhesion problems of UV protection film
- Same temperature behaviour of base and UV material
- No impairment of high impact (like e.g. with coated or painted surfaces)
- Makes small cold bending radiuses possible.
- Better resistance against environmental influences and ageing.
- The thickness of the Coextrusion layer may influence the colouring.

### Outside Performance

Through the coextruded UV-protection film – which is always applied on the outer wall and if desired (surcharge) for some of the products is also available both-sided – our products offer best weather resistance and very good long term performance.

### Warranty

Rodeca offers 10 years warranty (according to written warranty) to its uv-coextruded products regarding to **yellowing index – ageing – hail**

### Light transmission

Customized on project demand RODECA can produce products with light transmission from almost 0% up to 80% light transmission (depending on material thickness and number of layers). Due to in-house compounding and raw material refinement special requests and colours can be realized. Please inquire the project demands which vary from our standards.

### G-Value (Solar gain value)

The G-values are related to light transmission and U-value. G-values can differ from product specification to product specification from 0.68 down to 0.25!

### Up-values and Uf-values (heat transmission coefficient - Up=U-value panel; Uf =U-value frame)

Throughout the multi-walled design of our translucent building elements translucent facades with thermally broken aluminium profiles can be designed according to the requirements on Heat Insulation Ordinance according to EnEV 2009.

### UV transmission

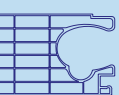
UV-radiation is stopped almost to 100% up to 380 Nm because of high UV-stabilization with coextruded UV-protection. The remaining transmission in the area of UV radiation is less than 1%. This property can be very important for UV sensitive goods.

### IR-radiation transmission

Our panels with HEATBLOC-surface let through day light and reflect and stop at the same time selectively the heating radiation. The effect is cooler rooms through lower solar gain values.

### Reflection of radar radiation

In the near of radar-units (e.g. at airports) it is important to have none or minimized influence through building elements. RODECA products do not have influence on reflection and do not affect radar-units.



# General information

## on translucent building elements of Polycarbonate

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### Service temperature

Service temperature is between minus 40 °C up to plus 115 °C (temporarily up to 130 °C). Please take into consideration service temperature especially with rain screen claddings respectively the use of dark foils for deposition of translucent building elements. Adequate distances and sufficient ventilation need to be considered in planning. That way danger of heat accumulation and associated deformations can be avoided.

### Thermal properties

The high deformation resistance from shortly up to 130 °C is one of the advantages which RODECA products with coextruded surface offer. RODECA products can be used in spaces where other thermoplastics cannot be used anymore. Interesting to know is that white surfaces on roof applications already can heat up to +100°C. (It is essential to respect thermal expansion/shrinking of polycarbonate and to avoid heat accumulation.)

### Colouring

The usual colours are:

- **CLEAR** with structure for panels for higher light transmission, light refraction. Additionally the surface is less sensitive to scratches.
- **OPAL** for optimized diffused light.
- **COLOR** Series - transparent or semitransparent COLOURS, similar to RAL from approx. 300 m<sup>2</sup> on request
- **BICOLOR** Series - two coloured finish, inner wall coloured, similar to RAL from approx. 150 m<sup>2</sup> on request
- **DUOCOLOR** - two coloured finish of translucent building elements custom made in transparent or semitransparent COLOURS similar to RAL from approx. 300 m<sup>2</sup> on request
- **DECOCOLOR** - two coloured finish, outer wall coloured, similar to RAL from approx. 150 m<sup>2</sup> on request

### Qualities

Depending on application area and demand RODECA produces different qualities.

- **LOGLIFE** quality for one sided UV protection. The terms can be extracted from our 10 years warranty declaration for LBE, MFP and U-Panels "longlife"
- **LOGLIFE PLUS** quality for one sided UV protection quality for special requirements. The terms can be extracted from our 10 years warranty declaration for LBE, MFP and U-Panels "longlife plus".

### Impact resistance/fracture behaviour

RODECA products made of PC are due to the raw material practically indestructible through beat, impact, stone throwing etc. Polycarbonate is 200 times more impact resistant than glass.

Polycarbonate building elements do not splinter and comply with German regulations on workplaces (Arbeitsstättenverordnung).

### Hail resistance

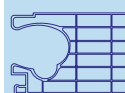
Currently doesn't exist a DIN standard, so our RODECA elements were tested at EMPA (Swiss testing laboratory) with a simulated hail test with a shot radius of 20 mm and no holes occurred. According to the current testing results we achieve the highest class (class 5) of the Swiss hail test with factory-new goods.

### Ball rebound safety

Even an ice hockey puck hurled against the element at 130 km/h could not cause damage. Unlimited ball rebound safety thus applies according to DIN 18032 T 3.

### Fire resistance

Polycarbonate has a very high ignition temperature of approx. 450 °C and in case of fire the smoke development is very little. RODECA products are classified according to the European standard DIN EN 13501 and are classified as hardly inflammable. Additionally the fire resistance of our products is classified according to various national standards. Please inquire the test certificates when needed.



# General information

## on translucent building elements of Polycarbonate

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### Melttable area according to DIN 18234

In many cases RODECA panels are used as melt-surface because their softening point is below 300°C.

### Sound insulation

Polycarbonate panels have despite their light weight a good sound insulation value up to 27 dB according to DIN EN ISO 140-3 in testing facility. With a double wall construction a value of up to 43 dB is achievable. This value refers to the value that the panel achieves on its own, due to constructive conditions this value may differ.

### Chemical resistance

PC elements possess a very high resistance to chemicals but can be affected through some chemical bounds. Chemical resistance of polycarbonate against other used chemicals has to be checked by customer on site. This is especially important for cooling substances, lubricants, surfactants, sealants, ammonia, etc. A policy on the compatibility of polycarbonate with chemicals can be found i.a. at <http://www.buerkle.de/en/knowhow/information/chemical-resistance.html>.

### Painting

In case that the polycarbonate panels for advertising reasons or similar will be painted or screen printed the compatibility of the painting system needs necessarily be tested from customer before use. The aluminium frame profiles can be powder coated according to the project needs. Additionally RODECA offers the possibility to deliver TPE gaskets in custom made colours.

### Vinyl wrap

For advertising purposes large scale letters can be glued onto the panels' surface. It is important that the foil and the glue doesn't contain substances which harm and affect polycarbonate. Please clarify before usage with the vinyl wrap supplier or the advertising company if the ingredients/glues of the foil intended to use are compatible with polycarbonate.

### Cleaning/Maintenance

For durable maintenance of technical and visual properties a regular care, maintenance and cleaning of the translucent building elements is mandatory. The cycle of care, maintenance and cleaning depends on the particular building site and the usage conditions. Cleaning of translucent building elements: Water with a small percentage of neutral cleaning agents. No use of glass cleaner, rubbing agents or sharp edged subjects. No alkaline or tensile agents to be used.

### Storage/Transport

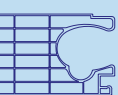
RODECA panels made of polycarbonate have to be protected before sun and wet conditions before installation and must be stored on a plain and even underground. In case of non-observance stock damages may occur. The stacking height of translucent building elements shouldn't exceed 200 cm.

### Packaging

The translucent building elements are delivered – depending on the finish – with one-sided or both-sided protective foil. The delivery is carried out – depending on length – from one to four pieces for hand unloading in a recyclable plastic wrapping or on pallet (for forklift unloading). Please unpack briefly before installation to avoid contamination in the hollow chambers. The protective film must be removed after processing and installation. If the Translucent Building Elements are provided with both-side protective film, the protective film on the interior side is applied as transport protection.

### Processing

The Polycarbonate Elements can be smoothly cut with common tools, e.g. pad saw (saw blade with fine indentation) Incidental shavings are to be removed with oil free and water free compressed air. Drill holes (preferably steel-, twist drill or wedge angle drill) need to be at least 40 mm away from elements side and always minimum 50% larger than the screw radius (because of expansion and shrinking due to temperature).



# General information

## on translucent building elements of Polycarbonate

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### Expansion/Shrinking

The expansion coefficient of polycarbonate is 0,065 mm per °C and per m and hence three times as high as the expansion coefficient of aluminium.

Rule of thumb: 3mm per m for 50 °C difference in temperature. Due to temperature differences the length and width of the panel change. The changes in length of the panel need to be considered constructional. RODECA has considered the length expansion in its system accessories. Thermally caused corrugations can not be excluded completely.

### Sealing

Sealings and sealing tapes need to be polycarbonate compatible and approved for usage from respective producer otherwise damages on the panels are possible.

Silicone: Must be absolutely neutral and solvent free, e. g. RODECA PC-Silicone 2001. The aluminium profiles need to be protected (according to state of the art technique) against galvanic corrosion and an adequate sealing of building has to be done.

### Condensation

Polycarbonate is a material that is permeable for vapour diffusion so that condensation may occur. This is not a quality defect. Depending from weather/climate this appearance is of temporary nature which is directly linked to temperature and humidity. Condensation doesn't effect the quality of the panels.

### Formation of algae

Algae can just occur in connection of dirt and humidity. Taping of the polycarbonate panels prevents appearance of dirt while stocking and transport.

### Sealing of panel ends

The ends of the panels must be closed before installation - directly after unpacking - with suitable sealing to avoid dust and dirt in the chambers.

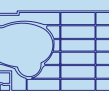
With a sealing that is permeable for vapour diffusion (or permeable to water) you run risk that dust, diesel exhaust particulates, gases or other fine particles can diffuse into the panel chambers. For projects with increased particulate matter emission respectively environmental pollution are additionally precautions to be taken. With a joint sealing and additional sealing methods the optical properties of the translucent building materials can be maintained. Every element needs to be sealed singularly. A general recommendation for sealing of panel ends can't be given due to the different installation situations. The complete lack of panel ends sealing cannot be recommended from our experience.

### Aluminium Frame Profiles

Aluminum frame profiles shall be treated in accordance with the unloading and storage regulations. Mill finish aluminium with oxidative staining is not accepted as reclamation reason. Due to production reasons, the end faces of thermally separated frame profiles are to be trimmed by the customer. Coated or anodised frame profiles can have bores or discolourations of the clamping points of the anodizing process at the lateral ends and are to be shortened if necessary on site. This is not accepted as reclamation reason. Coated profiles can have color deviations to other components in the same color. The chemical resistance of aluminum must be observed. Care and maintenance of aluminum profiles can preserve the optical properties and texture.

### Safety

The regional building regulations as well as the general safety regulations for non supporting wall and roof coverings are effective. For a penetration (according to workplace ordinance (German „Arbeitsstättenrichtlinie“) it is mandatory to use a board of 50 cm width.



# General information

## on translucent building elements of Polycarbonate

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### Tolerances

#### Panels

Length + 12 mm (up to 3 m) / +0.40% of panel length (above panel length of 3 m)

Thickness  $\pm$  0.5 mm

Width -2 mm / +6 mm

Weight - 5 %

Concavity length  $\pm$  5 mm per linear meter of panel length

Concavity width  $\pm$  5 mm per linear meter of panel width

Rectangularity < 5 mm per linear meter of panel length

All tolerances are based on room temperature of approx. 20 °C

Variations in colour saturation and shade between several production batches cannot be precluded (production-related). Variations are always possible and will not be accepted as reason for complaint.

### Disposal of waste/Environmental protection

RODECA takes leftovers from off-cuts etc. back. Packaging is fully recyclable.

### Joint permeability

Especially for large facades it is important not only to achieve a good U-value but also a product which is tested on joint permeability and complies with the required DIN values. RODECA panels fulfil this demand and passed project wise blower door tests for the whole construction.

### System accessories

For almost all installation situations RODECA supplies appropriate and well engineered accessories as well as ventilation flaps and windows in many different versions.

### Certification/Quality standard

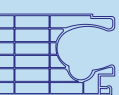
Rodeca panels are CE marked as specified by the European directive No. 305/2011 and according to the requirements of EN 16153. Beyond the performance of EN 16153 our products are certified according to several European and national standards.

If RODECA forwards building certification for translucent building elements these regulations must be complied with. Due to the not finalized harmonization of National and European norms please check whether the certifications are suitable for the particular application purpose.

### Miscellaneous

Data subject to technical change.

The aforesaid information and our application technological advice in words, written and through tries, are carried out to best of one's knowledge. This information is non-binding advice even in regards to property rights of third parties. Our advice does not release you from your responsibility to proof self dependently our current advices - especially our safety data sheets and technical information - and to test if our products in regards to applicability for the intended system and use. Application, use and handling of our products – produced from you based on our application technological advice - take place out of our control and therefore you are solely responsible. The sale of our products is carried out according to our current general terms and conditions. Please check before handling if our products are applicable for the intended purpose.



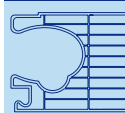
# Content

## Technical manual LBE 50mm

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Stand: 10/17

- Content
- Product range
- Technical information panel 1.1.1.1 to 1.1.1.4
- Technical information about fastening and load capacities 1.1.2.0 to 1.1.2.1
- Technical information frame systems 1.1.3.0
- Technical information non-thermally broken frame system 1.1.4.0 to 1.1.4.5
- Technical information thermally broken frame system 1.1.5.0 to 1.1.5.6
- Technical information windowsill systems 1.1.6.0 to 1.1.6.3



# Product range

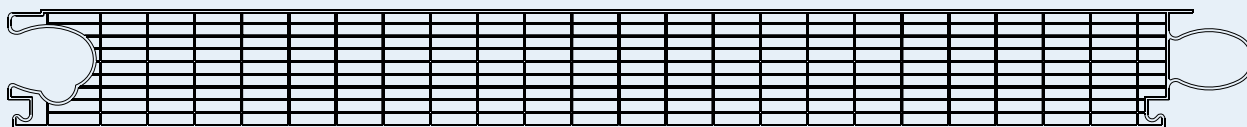
## Translucent Building Elements

Standard and Design Series

### Standard - crystal and opal

PC 2550-10 ISOCLEAR

Up-Value 0.80 - 0.92 W/m<sup>2</sup>K\*\*



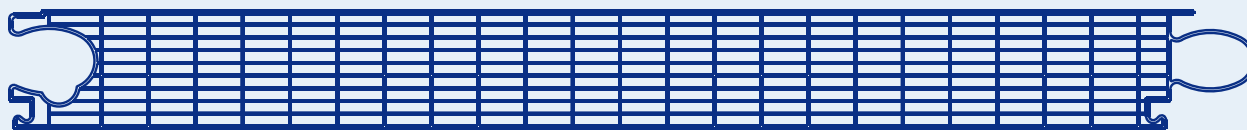
General German Building Approval Z-10.1-466

Building width 495 mm\*

### Design Series - Color

PC 2550-10 ISOCLEAR

Up-Value 0.80 - 0.92 W/m<sup>2</sup>K\*\*



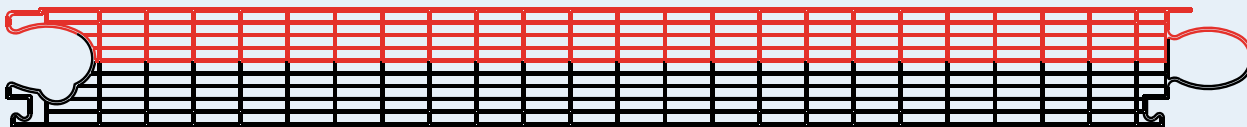
Minimum quantity of 300 m<sup>2</sup>  
General German Building Approval Z-10.1-466

Building width 495 mm\*

### Design Series - Duocolor

PC 2550-10 ISOCLEAR

Up-Value 0.80 - 0.92 W/m<sup>2</sup>K\*\*



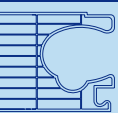
Minimum quantity of 300 m<sup>2</sup>  
General German Building Approval Z-10.1-466

Building width 495 mm\*

Rodeca panels are CE marked as specified by the European directive No. 305/2011 and according to the requirements of EN 16153. Beyond the performance of EN 16153 our products are certified according to several European and national standards. Such as other national fire certifications, proof of joint tightness, certified resistance against ball and puck impact as well as hail resistance etc. corresponding to testing reports. As necessary please contact us for further certifications.

\* Please note our general information regarding production tolerances

\*\* The Up-values depend on the installation situation, for further details please check our technical manuals and the structural-physical values. It is mandatory to consider the technical datasheets to this.



# 1.1.1.1

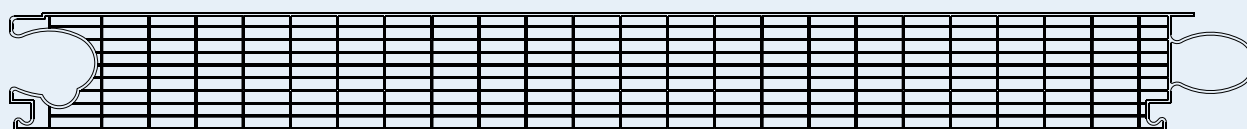
## Translucent Building Elements

Product properties - Physical properties

Stand: 10/17

### Up-Value from 0.80 W/m<sup>2</sup>K to 0.92 W/m<sup>2</sup>K

Depending on horizontal or vertical installation situation as interior or exterior application according to DIN EN ISO 6946:2008 / DIN EN ISO 10077-2:2008



#### Flammability classification:

PC 2550-10 ISOCLEAR

fire class B-s1, d0 according to EN 13501

Building width:

495 mm -2/+ 6 mm

Thickness:

50 mm +/- 0.5 mm

Weight:

approx. 5.0 kg/m<sup>2</sup>

Number of layers:

10 layers / 9 chambers

Modulus of elasticity:

2,400 N/mm<sup>2</sup>

Coefficient of linear expansion:

0.065 mm/m/°C

UV admission:

< 1 %, wavelength until 380 nm stopped almost a 100 %

Production tolerances:

s. General information

#### Versions:

Standard:

Colours: crystal, opal, petrol and pacific blue

Color:



Available in any solid colour similar to RAL.

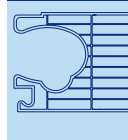
The Color version can be delivered with a minimum quantity of 300 m<sup>2</sup> without separate surcharges for colour change.

Duocolor:

Two coloured version of the panels combinable with HEATBLOC

The DUOCOLOR version can be delivered with a minimum quantity of 300 m<sup>2</sup> without separate surcharges for colour change.

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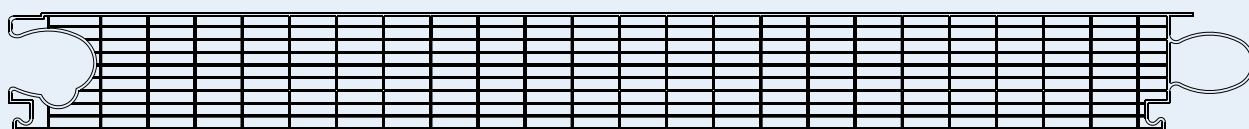
## 1.1.1.2

### Translucent Building Elements

Product properties - Physical properties

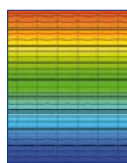
#### Up-Value from 0.80 W/m<sup>2</sup>K to 0.92 W/m<sup>2</sup>K

Depending on horizontal or vertical installation situation as interior or exterior application  
According to DIN EN ISO 6946:2008 / DIN EN ISO 10077-2:2008



#### Up-Values:

Isotherm- and temperature pattern  
from -10 °C outside and 20 °C inside  
at vertical assembly



Isotherms:

Red: 13°C  
Blue: 10°C  
Black: 0°C

#### Installation situation interior:

Up-Value 0.80 W/m<sup>2</sup>K vertical  
Up-Value 0.84 W/m<sup>2</sup>K horizontal

#### Installation situation exterior:

Up-Value 0.90 W/m<sup>2</sup>K vertical  
Up-Value 0.92 W/m<sup>2</sup>K horizontal

The German building approval foresees the calculation of facade and roof areas according to the requirements of DIN 10077-2 (U<sub>cw</sub>). If additional or divergent national requirements be asked to calculate the thermal protection, these must be respected.

Sound insulation:

Test report on request

#### Transmission:

Standard:

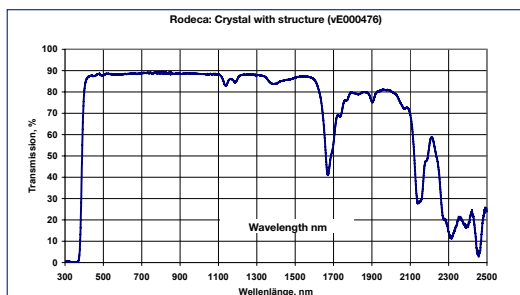
Colour: crystal approx. 44 %  
Colour: opal approx. 36 %

Color:

Depending on colour e. g.  
Colour: petrol (~ RAL 6027) approx. 36 %

Duocolor:

Depending on colour combination and  
level of opalization  
For example colour combination:



Crystal / opal approx. 41 %  
Heatbloc S / crystal approx. 25 %  
Heatbloc S / opal 067 approx. 20 %

(The Measurement of the transmission values was carried out with application of a natural day light lamp of 20,000 Lux in connection with a lux meter Lightmeter MS 1000-300 – measuring range 200 to 50,000 LUX) exemplarily on a 1 mm thick PC.)

## 1.1.1.3

### Translucent Building Elements

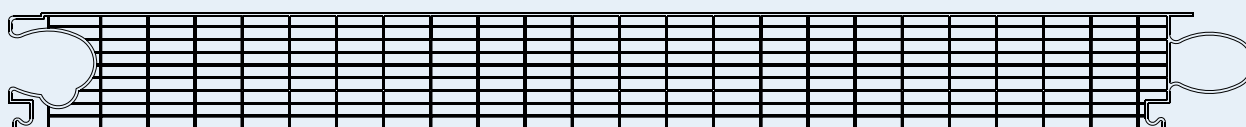
Product properties - Physical properties

Stand: 10/17

#### Up-Value from 0.80 W/m<sup>2</sup>K to 0.92 W/m<sup>2</sup>K

Depending on horizontal or vertical installation situation as interior or exterior application

According to DIN EN ISO 6946:2008 / DIN EN ISO 10077-2:2008



#### Solar gain values g

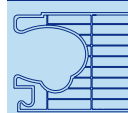
Standard:	Colour: crystal	approx. 50 %
	Colour: opal	approx. 41 %
Color:	Depending on colour e.g. colour: petrol (≈ RAL 6027) approx. 45 %	
Duocolor:	Depending on colour combination and level of opalization	
	For example colour combination	
	Crystal / opal	approx. 46 %
	Heatbloc S / crystal	approx. 25 %
	Heatbloc S / opal 067	approx. 26 %

The General German building approval Z-10.1-466 is available. All following specification about the structural safety are based upon the component testings which were made in the context of the approval procedure. Flammability classifications don't have any influence of the structural safety aspects.

The RODECA translucent building elements in use with thermally broken or non-thermally broken frame systems have the following system names:

PC 2550-10	For single field constructions
PC 2550-10 AF 60	For two or multi field constructions with aluminium flat frame fastener in length 60 mm
PC 2550-10 AF 120	For two or multi field constructions with aluminium flat frame fastener in length 120 mm

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## 1.1.1.4

### Translucent Building Elements

Product version Duocolor

#### Duocolor means:

Approx. 1/2 of the panel seen from outside view in Colour 1

Approx. 1/2 of the panel seen from outside view in Colour 2

The separation of the colours is not guaranteed exactly in the middle of the panel but may vary slightly in between the single production charges, due to that differences in transmission can be possible.

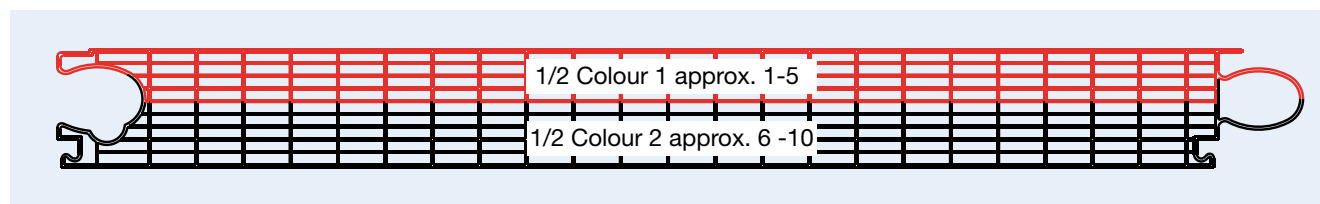
For the indication of the colours always the outside view from the panel is taken as basis!

#### Example:

The version Duocolor crystal/RAL 5002 means:

Approx. Layers 1-5 in colour crystal

Approx. Layers 6-10 in colour RAL 5002



Please note that in your inquiry that the version Duocolor always has the correct sequence of the colour description from outside view to inside view.

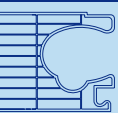
In order to avoid mistakes you can attach this data sheet with the description of your desired colour combination to your order.

Please use this data sheet as well as basis for your project orders:

#### Ordering information:

Approx. layers 1 - 5 from outside view in Colour 1      Colour 1 \_\_\_\_\_

Approx. layers 6 -10 from outside view in Colour 2      Colour 2 \_\_\_\_\_



## 1.1.2.0

### Translucent Building Elements

System PC 2550-10 AF 60 | System PC 2550-10 AF 120

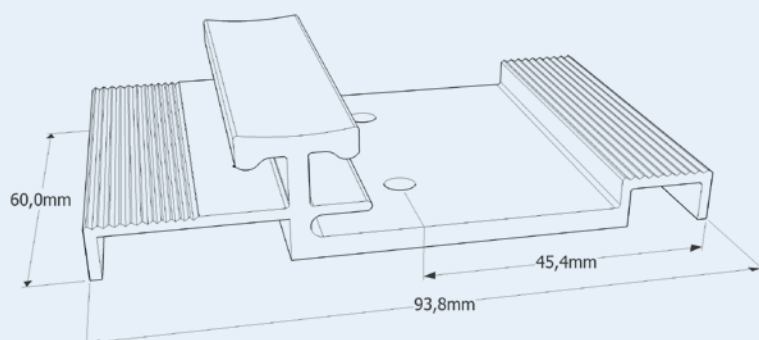
Fastener

Stand: 10/17

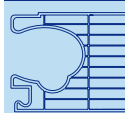
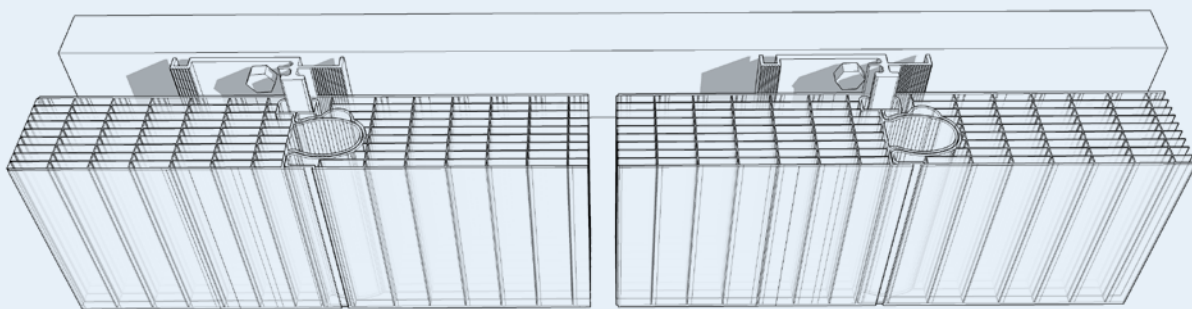
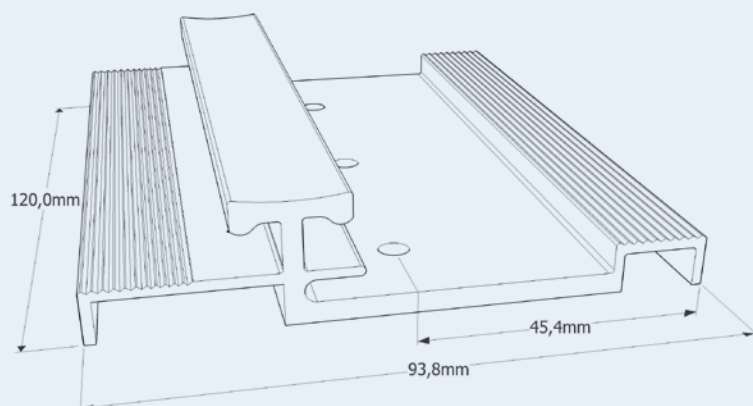
#### General

The RODECA flat fasteners are made of extruded aluminium profiles, afterwards cut, pierced and trovalised. The proof of applicability and the statical values are in the General German Building Approval Z-10.1-466 documented. We recommend to fix the flat aluminium fasteners with stainless steel screws without sealing discs. The fixing materials need to be chosen in type and finish adequately to substructure. The height of substructure should be not smaller than the height of the fastener.

Article no.: 49405060



Article no.: 494050120



## 1.1.2.1

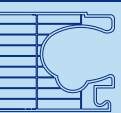
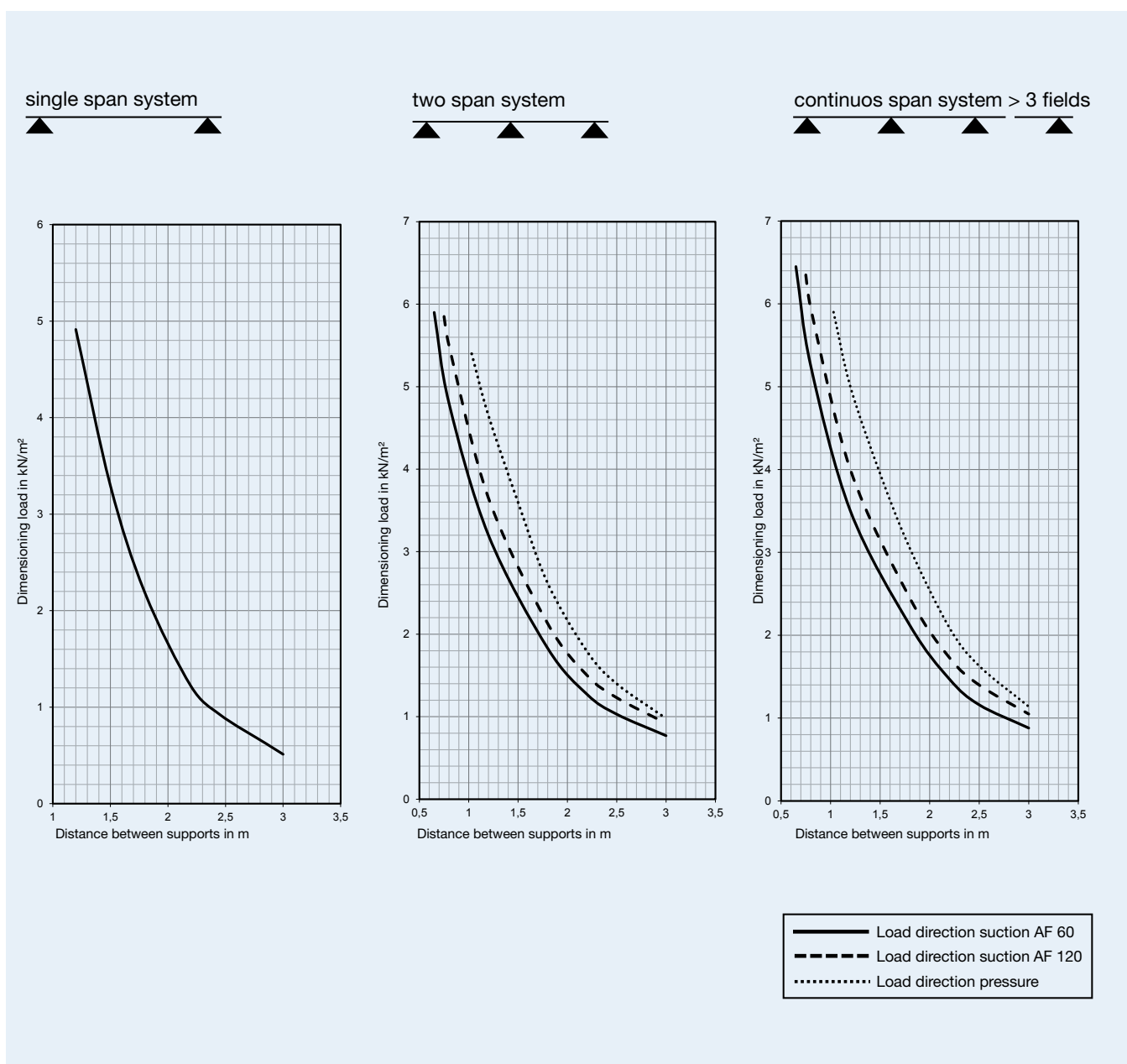
### Translucent Building Elements

Span width | System PC 2550-10

The below diagrams show the span widths recommendations referring to dimensioning loads, where wind is considered as dominating variable action. The values are based on the General German Building approval Z-10.1-466 and are only valid in conjunction with the RODECA systems accessories.

Please note that for the structural design of the valid spans additionally to the influencing loads the correspondent national partial safety factors  $\gamma_f$  must be added.

The structural analysis of the span widths must be proven project-related based on the German Building approval Z-10.1-466.



# 1.1.3.0

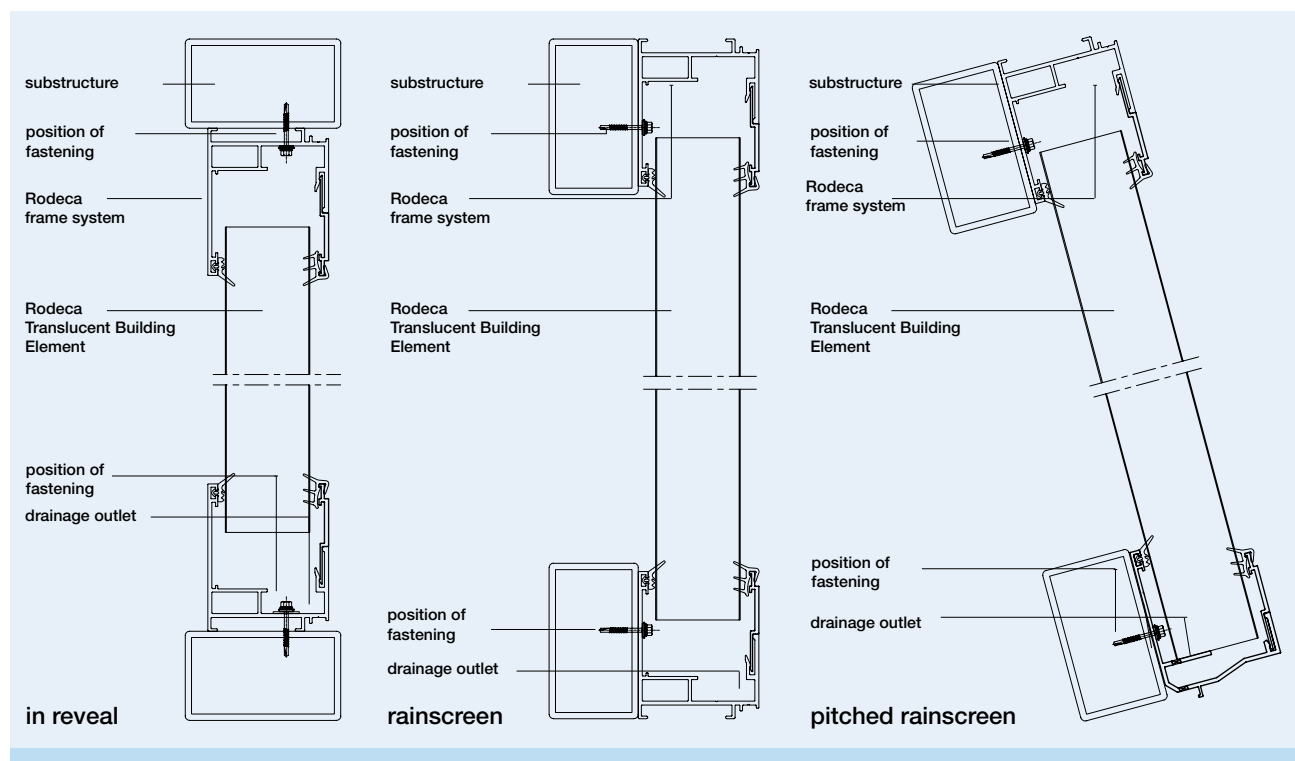
## Translucent Building Elements

Frame system thermally and non-thermally broken

General Information

Stand: 10/17

### Mounting situation



### General

The examples shown above illustrate the use of Rodeca frame profiles for mounting in reveal, as rainscreen or as a pitched rainscreen construction.

In all cases the sealing between frame sections, frame profile and substructure should be adapted to local conditions. The proof of aluminium profiles, their fixings and the fixing of Rodeca fasteners must be kept in an individual case. Installation of the aluminium profiles with **stainless steel screws** and sealing disc. Dimensions and size according to substructure and extract values of fixing materials. Rodeca assembly instructions must be observed.

Rodeca frame systems are made of extruded Aluminium profiles consisting of aluminium EN AW-6060, status T 66 according to DIN EN 755-2. The ribs are made of fiber glass reinforced polyamide PA 66 with fiber glass part of 25%. The gaskets are made of TPE.

### Please note:

The coefficient of linear expansion for Aluminium profiles = 0.023 mm/m°C. Polycarbonate panels = 0.065 mm/m°C.

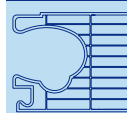
### Initial lengths/-units

Aluminium profiles	6.00 m
Front plate	2.0 und 3.0 m
TPE gaskets, grey or black or special colour on request	50 m rolls
Profile connector	10 cm PU* 4pcs.

### Versions

Aluminium - mill finish
Aluminium - anodized E6/EV1
Aluminium - powder coated according to RAL

\*PU = Packing unit



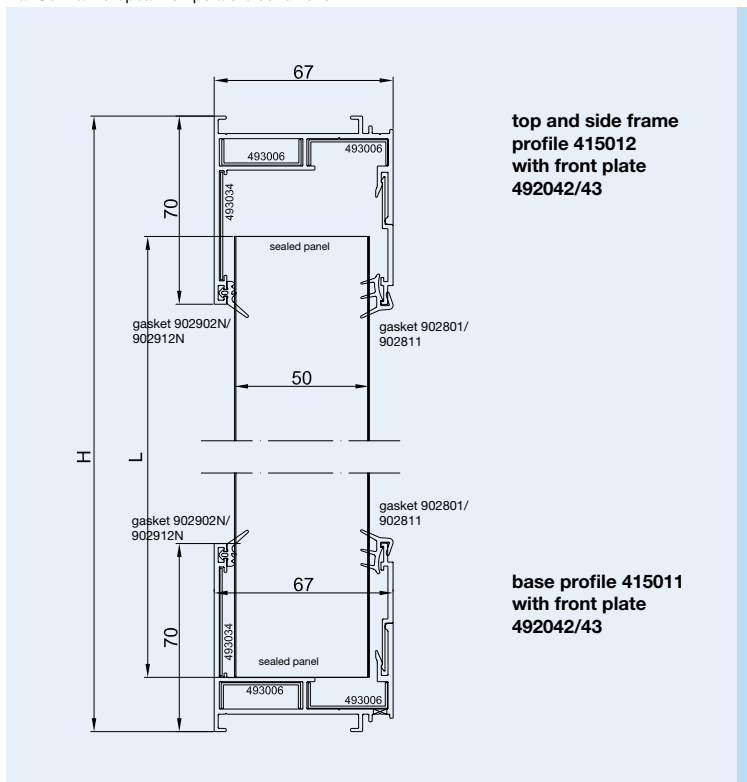
## 1.1.4.0

### Translucent Building Elements

Frame system non-thermally broken  
Top and base framing

#### Facade 90° up to 4.5m panel length\*

\* at Central European temperature conditions



**Top profile 415012**  
**Base profile 415011**

#### Article numbers

**415012** = Top and side frame profile  
493034 = Profile connector for 415012  
493006 = Profile connector 2x for 415012

**415011** = Base profile  
493034 = Profile connector for 415011  
493006 = Profile connector 2x for 415011

**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

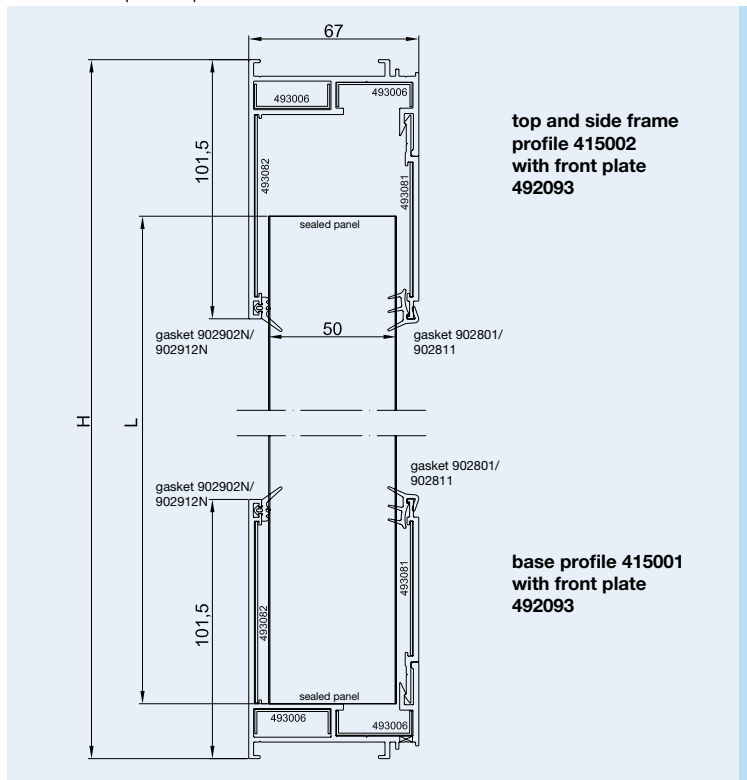
**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
L in mm = Height H in mm  
less 65 mm at H > 1,500 mm  
less 70 mm at H < 1,500 mm

#### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Top profile 415002**  
**Base profile 415001**

#### Article numbers

**415002** = Top and side frame profile  
493082 = Profile connector for 415002  
493006 = Profile connector 2x for 415002

**415001** = Base profile  
493082 = Profile connector for 415001  
493006 = Profile connector 2x for 415001

**492093** = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
L in mm = Height H in mm - **75 mm**

## 1.1.4.1

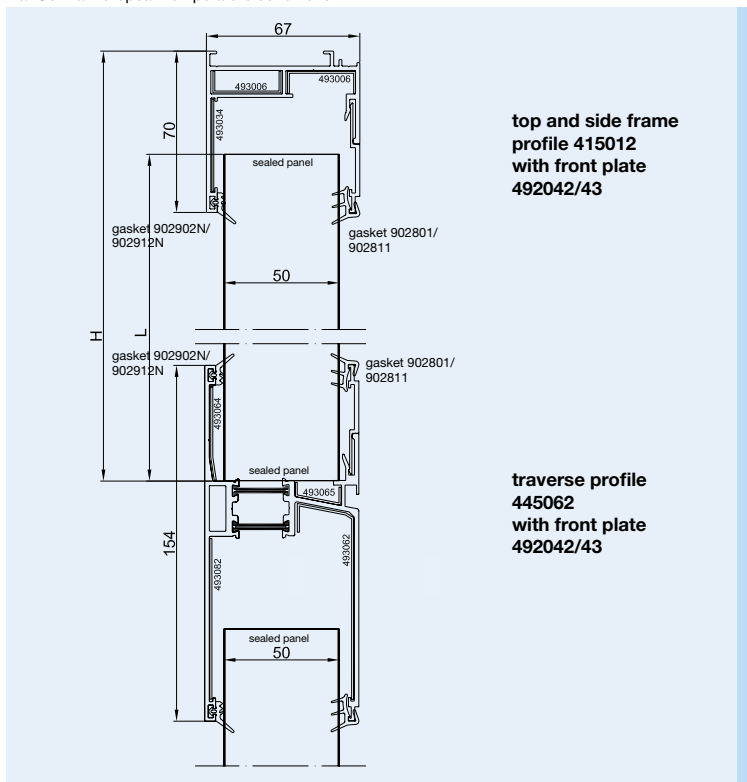
### Translucent Building Elements

Frame system non-thermally broken  
Top and base framing

Stand: 10/17

#### Facade 90° up to 4.5m panel length\*

\* at Central European temperature conditions



**Top profile 415012**  
**Traverse profile 445062**

#### Article numbers

**415012** = Top and side frame profile  
493034 = Profile connector for 415012  
493006 = Profile connector 2x for 415012

**445062** = Traverse profile  
493062 = Profile connector for 445062  
493082 = Profile connector for 445062  
493064 = Profile connector for 445062  
493065 = Profile connector for 445062

**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

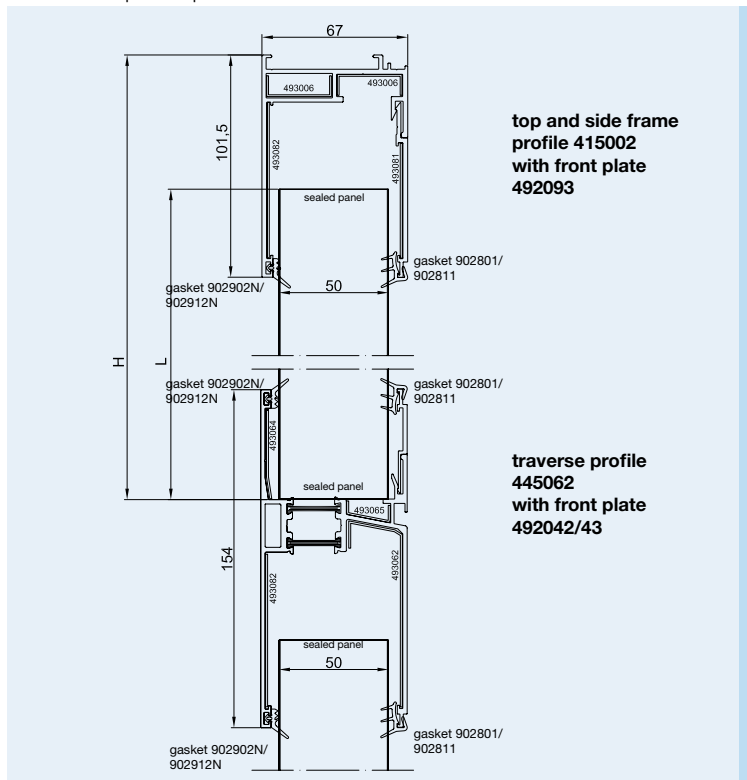
**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
 $L \text{ in mm} = \text{Height } H \text{ in mm} - 45 \text{ mm}$

#### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Top profile 415002**  
**Traverse profile 445062**

#### Article numbers

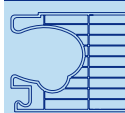
**415002** = Top and side frame profile  
493082 = Profile connector for 415002  
493006 = Profile connector 2x for 415002  
**492093** = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

**445062** = Traverse profile  
493062 = Profile connector for 445062  
493082 = Profile connector for 445062  
493064 = Profile connector for 445062  
493065 = Profile connector for 445062  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
 $L \text{ in mm} = \text{Height } H \text{ in mm} - 55 \text{ mm}$



## 1.1.4.2

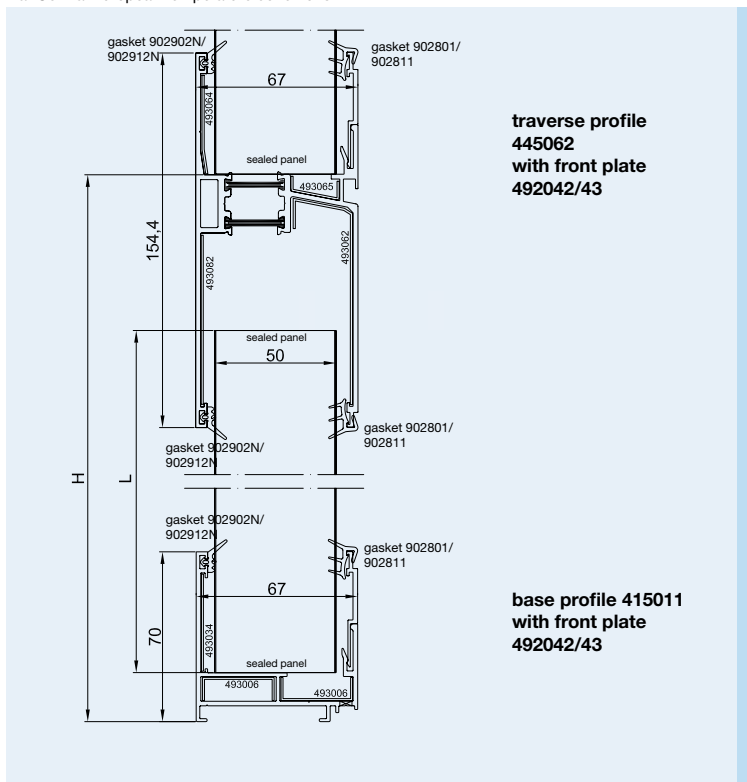
### Translucent Building Elements

Frame system non-thermally broken

Top and base framing

#### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Traverse profile** 445062  
**Base profile** 415011

#### Article numbers

**445062** = Traverse profile

493062 = Profile connector for 445062

493082 = Profile connector for 445062

493064 = Profile connector for 445062

493065 = Profile connector for 445062

**415011** = Base profile

493034 = Profile connector for 415011

493006 = Profile connector for 2x for 415011

**492042** = Front plate in L = 2.0 m

**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey

**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey

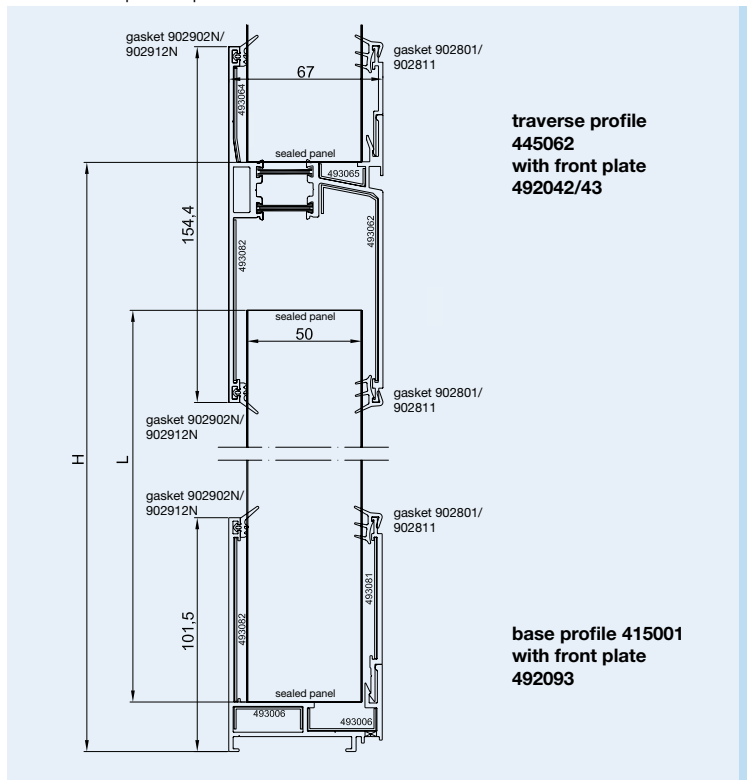
**902912N** = Inner lip gasket TPE black

Calculation of panel length:

L in mm = Height H in mm - 75 mm

#### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Traverse profile** 445062  
**Base profile** 415001

#### Article numbers

**445062** = Traverse profile

493062 = Profile connector for 445062

493082 = Profile connector for 445062

493064 = Profile connector for 445062

493065 = Profile connector for 445062

**492042** = Front plate in L = 2.0 m

**492043** = Front plate in L = 3.0 m

**415001** = Base profile

493082 = Profile connector for 415001

493006 = Profile connector 2x for 415001

**492093** = Front plate in L = 3.0 m

493081 = Profile connector for 492093

**902801** = Outer plug gasket TPE grey

**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey

**902912N** = Inner lip gasket TPE black

Calculation of panel length:

L in mm = Height H in mm - 75 mm

## 1.1.4.3

### Translucent Building Elements

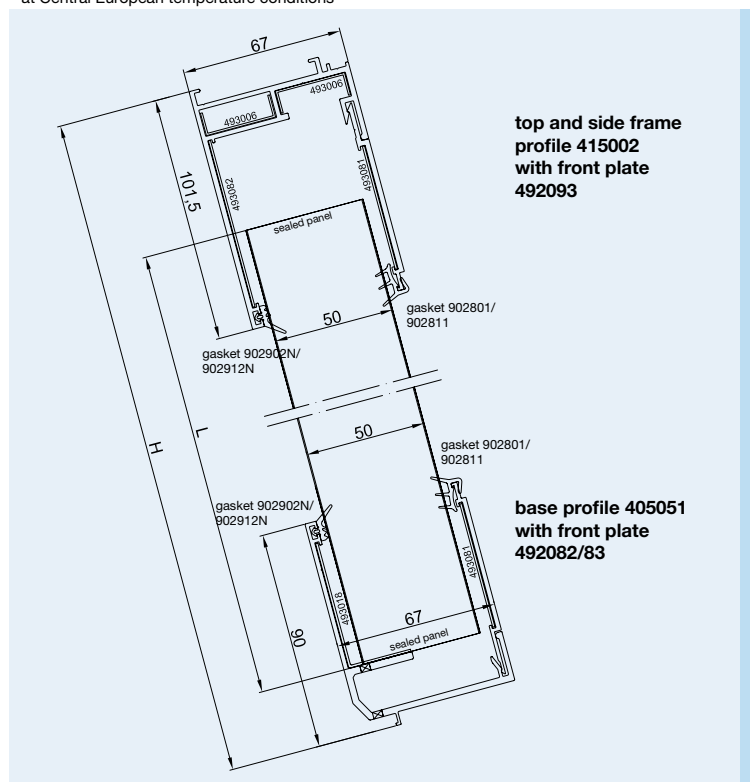
Frame system non-thermally broken

Top and base framing

Stand: 10/17

Pitched installation >15° up to 12m panel length\*

\* at Central European temperature conditions



**Top profile 415002**  
**Base profile 405051**

#### Article numbers

**415002** = Top and side frame profile  
493082 = Profile connector for 415002  
493006 = Profile connector 2x for 415002

**492093** = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

**405051** = Base profile  
493018 = Profile connector for 405051

**492082** = Front plate in L = 2.0 m  
**492083** = Front plate in L = 3.0 m  
493081 = Profile connector for 492082/83

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

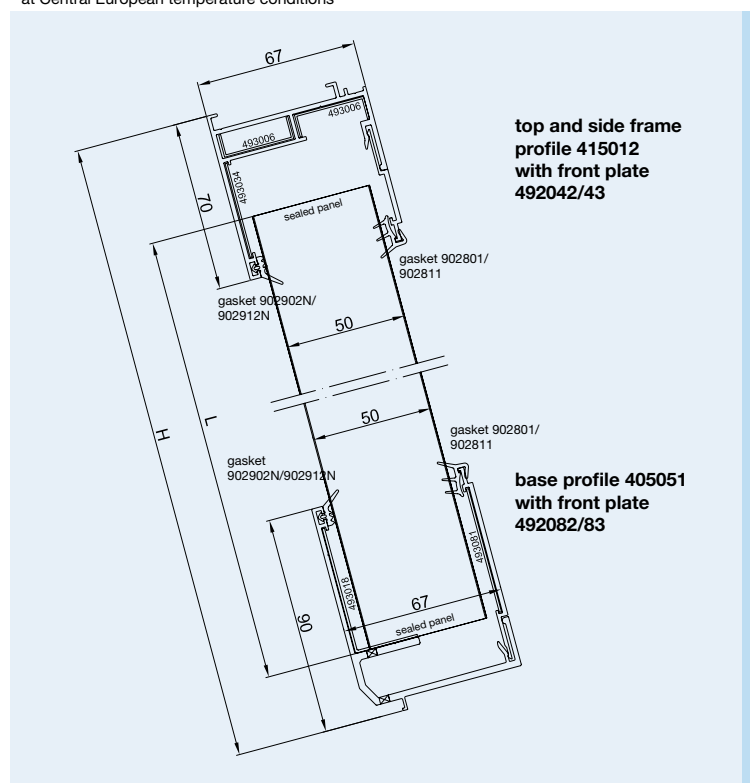
**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:

L in mm = Height H in mm - 80 mm

Pitched installation >15° up to 4.5m panel length\*

\* at Central European temperature conditions



**Top profile 415012**  
**Base profile 405051**

#### Article numbers

**415012** = Top and side frame profile  
493034 = Profile connector for 415012  
493006 = Profile connector 2x for 415012

**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**405051** = Base profile  
493018 = Profile connector for 405051

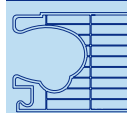
**492082** = Front plate in L = 2.0 m  
**492083** = Front plate in L = 3.0 m  
493081 = Profile connector for 492082/83

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:

L in mm = Height H in mm - 60 mm

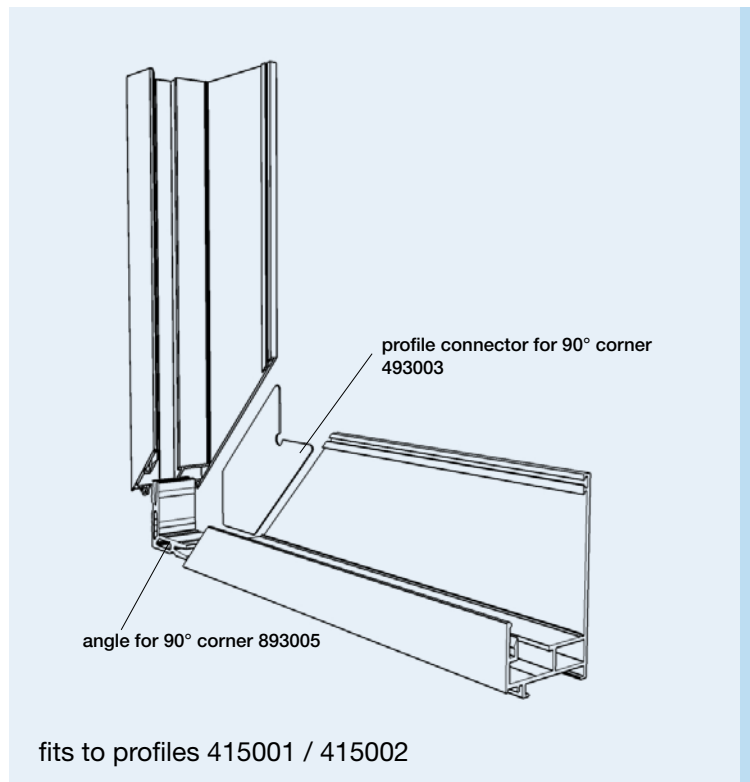


## 1.1.4.4

### Translucent Building Elements

Frame system non-thermally broken  
Corner connection

#### 90° corner connection 415005



#### General

90° corner connections of the profiles 415002 and 415012 are available as prefabricated components.

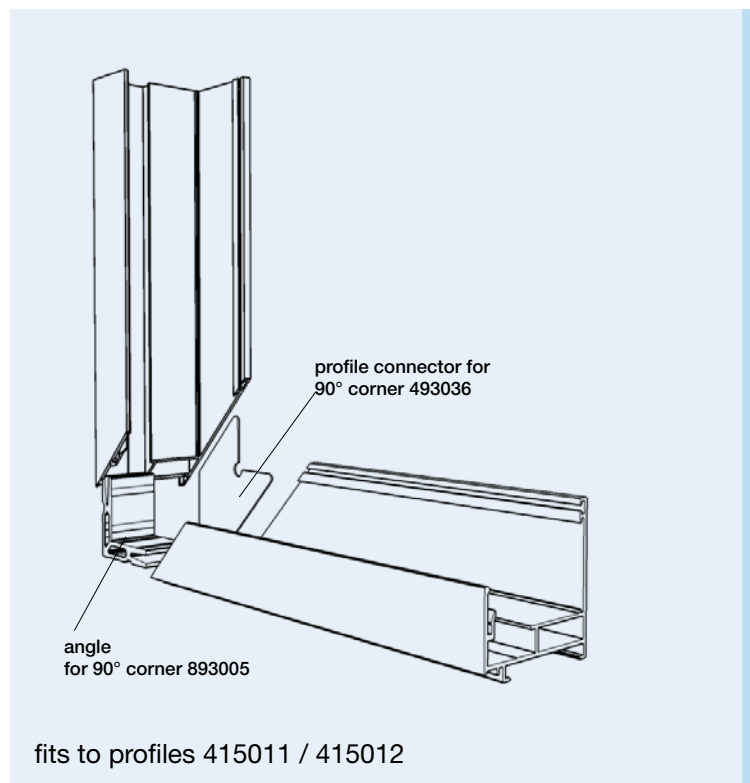
The corner connections are made of 0.55m long frame profiles, incl. front plates. The connections are sealed with profile connectors and sealant and thus save installation time and effort.

#### Initial lengths/-units

Prefabricated corner profile incl. front plates and profile connectors	
Length 0.55 m	1 pc. PU*
Profile connector 493003	4 pcs. PU*
Angle for 90° corner 893005	4 pcs. PU*
TPE gaskets, grey or black or special colour on request	50 m rolls

\*PU = Packing unit

#### 90° corner connection 415015



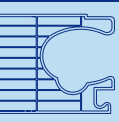
#### Article numbers

**415005** = 90° corner connection prefabricated  
incl. profile connectors and front plate,  
fits to profile 415001 & 415002  
**493003** = profile connector for a 90° corner  
of profile 415001/02  
**893005** = angle for a 90° corner of profile  
415001/02

**415015** = 90° corner connection prefabricated  
incl. profile connectors and front plate,  
fits to profile 415011 & 415012  
**493036** = profile connector for a 90° corner  
of profile 415011/12  
**893005** = angle for a 90° corner of profile  
415011/12

#### Versions

Aluminium - mill finish  
Aluminium - anodized E6/EV1  
Aluminium - powder coated according to RAL



## 1.1.4.5

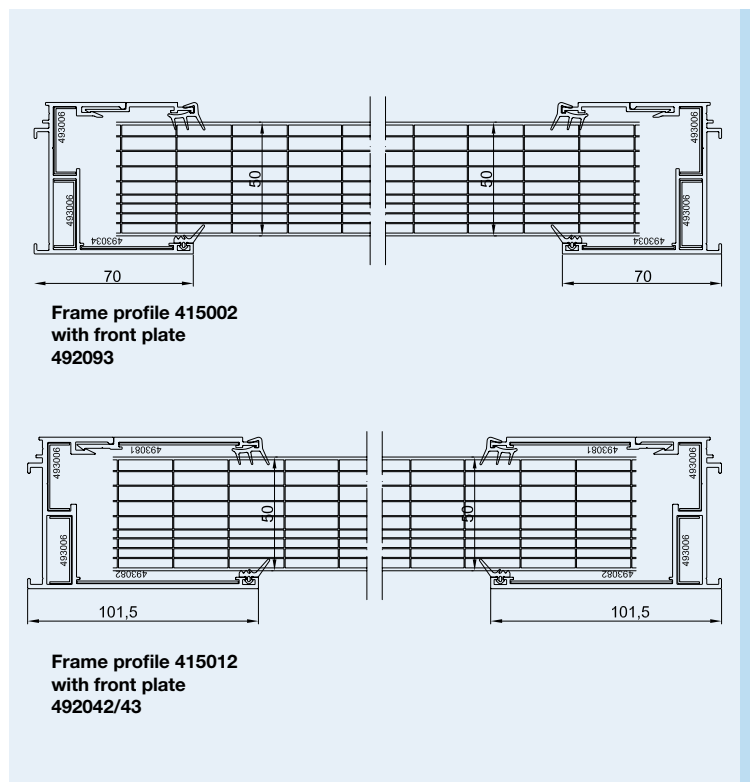
### Translucent Building Elements

Frame system non-thermally broken

Lateral framing

Stand: 10/17

#### Side connections



#### Side connection with frame profiles

##### Article numbers

**415002** = Top and side frame profile  
**493082** = Profile connector for 415002  
**493006** = Profile connector 2x for 415002

**492093** = Front plate in L = 3.0 m  
**493081** = Profile connector for 492093

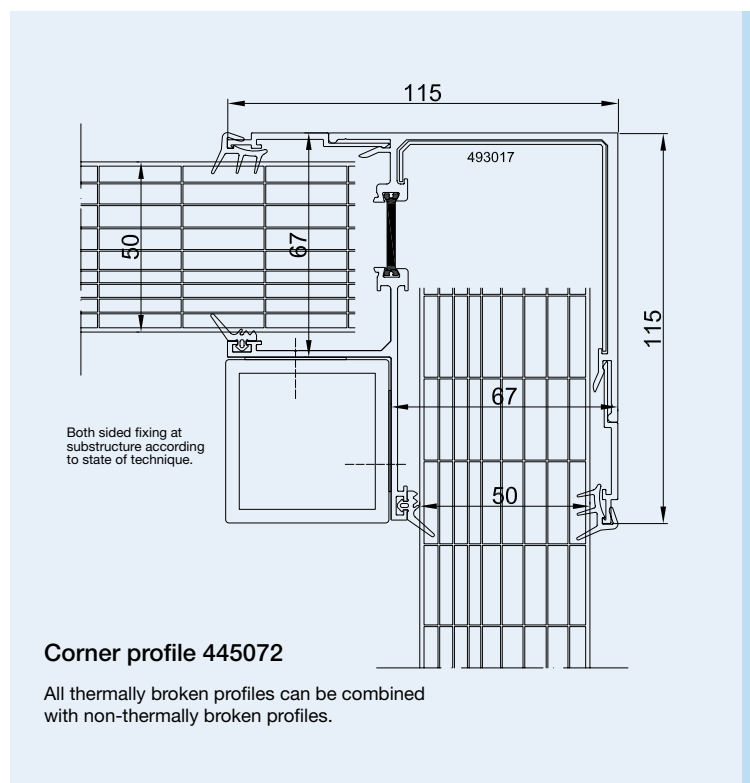
**415012** = Top and side frame profile  
**493034** = Profile connector for 415012  
**493006** = Profile connector 2x for 415012

**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

#### Side connection 90° corner



#### Side connection 90° corner with frame profile 445072

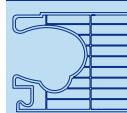
##### Article numbers

**445072** = Corner profile  
**493017** = Profile connector for 445072

**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black



## 1.1.5.0

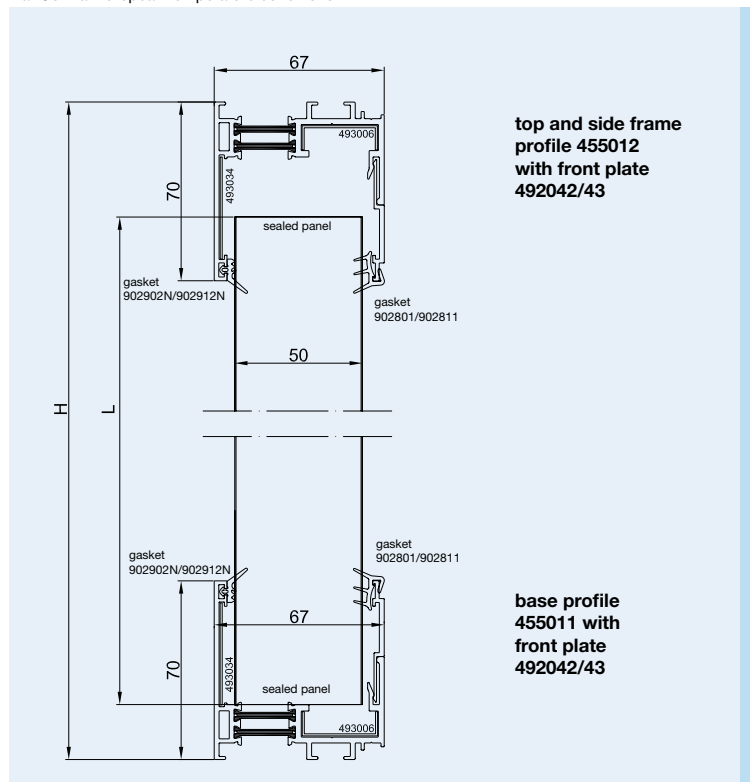
### Translucent Building Elements

Frame system thermally broken

Top and base framing

Facade 90° up to 4.5m panel length\*

\* at Central European temperature conditions



**Top profile** 455012  
**Base profile** 455011

#### Article numbers

455012 = Top and side frame profile  
493006 = Profile connector for 455012  
493034 = Profile connector for 455012

455011 = Base profile with drainage  
493006 = Profile connector for 455012  
493034 = Profile connector for 455011

492042 = Front plate in L = 2.0 m  
492043 = Front plate in L = 3.0 m

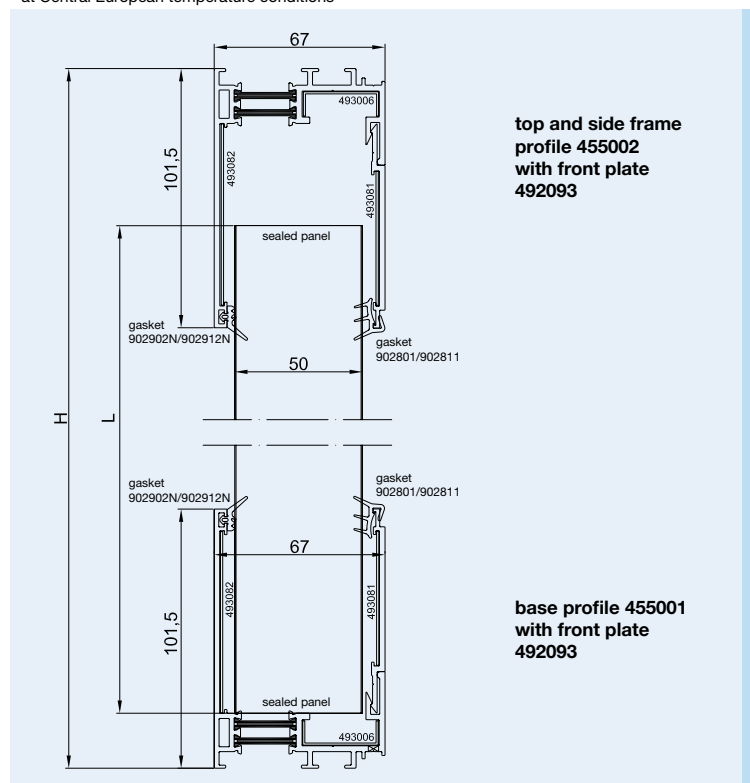
902801 = Outer plug gasket TPE grey  
902811 = Outer plug gasket TPE black

902902N = Inner lip gasket TPE grey  
902912N = Inner lip gasket TPE black

Calculation of panel length:  
L in mm = Height H in mm - 68 mm

Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Top profile** 455002  
**Base profile** 455001

#### Article numbers

455002 = Top and side frame profile  
493082 = Profile connector for 455002  
493006 = Profile connector for 455002

455001 = Base profile with drainage  
493082 = Profile connector for 455001  
493006 = Profile connector for 455001

492093 = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

902801 = Outer plug gasket TPE grey  
902811 = Outer plug gasket TPE black

902902N = Inner lip gasket TPE grey  
902912N = Inner lip gasket TPE black

Calculation of panel length:  
L in mm = Height H in mm - 75 mm

# 1.1.5.1

## Translucent Building Elements

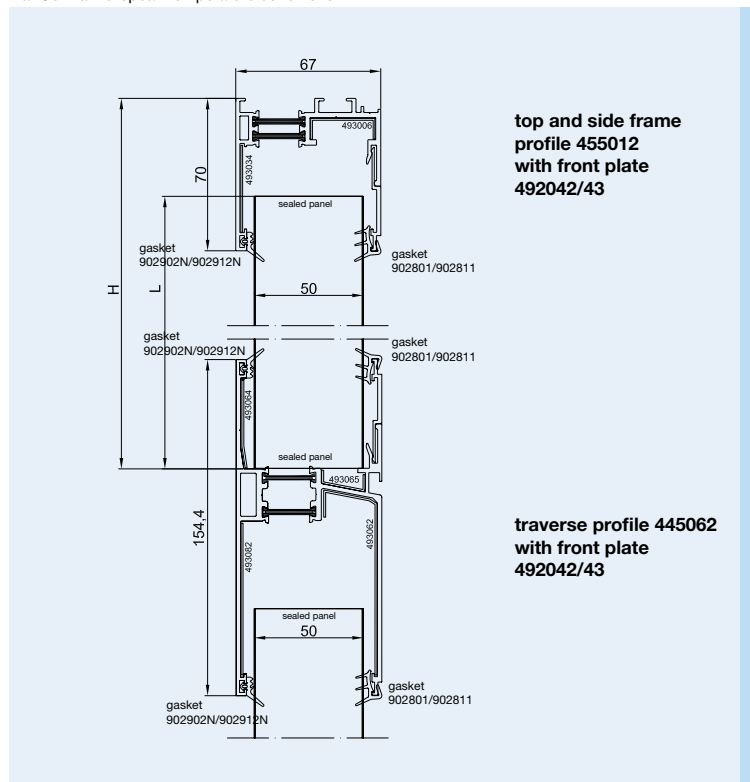
Frame system thermally broken

Top and base framing

Stand: 10/17

### Facade 90° up to 4.5m panel length\*

\* at Central European temperature conditions



**Top profile 455012**  
**Traverse profile 445062**

#### Article numbers

**455012** = Top and side frame profile  
493006 = Profile connector for 455012  
493034 = Profile connector for 455012  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**445062** = Traverse profile  
493062 = Profile connector for 445062  
493082 = Profile connector for 445062  
493064 = Profile connector for 445062  
493065 = Profile connector for 445062  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

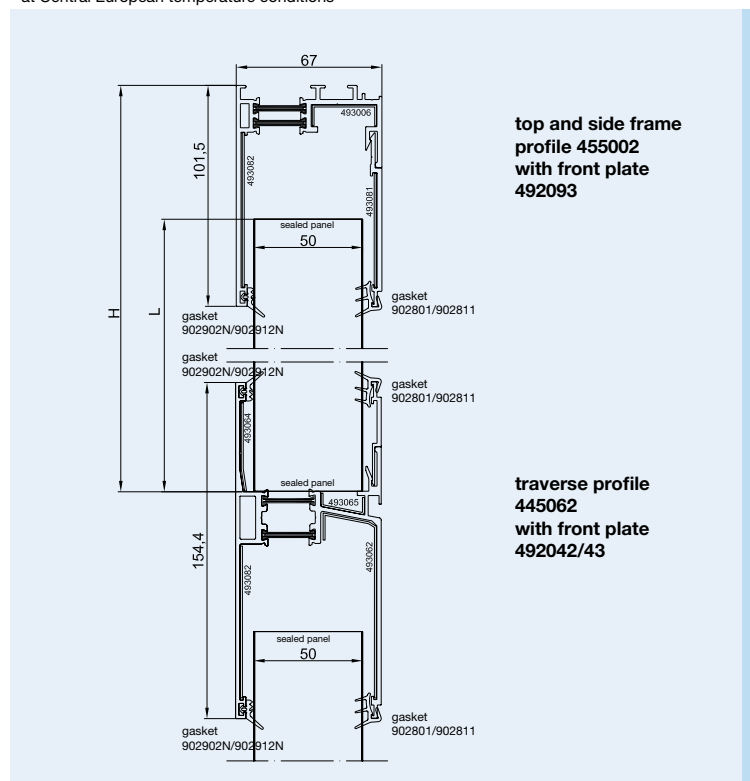
**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:

L in mm = Height H in mm - **45 mm**

### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Top profile 455002**  
**Traverse profile 445062**

#### Article numbers

**455002** = Top and side frame profile  
493082 = Profile connector for 455002  
493006 = Profile connector for 455002  
**492093** = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

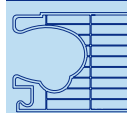
**445062** = Traverse profile  
493062 = Profile connector for 445062  
493082 = Profile connector for 445062  
493064 = Profile connector for 445062  
493065 = Profile connector for 445062  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:

L in mm = Height H in mm - **55 mm**



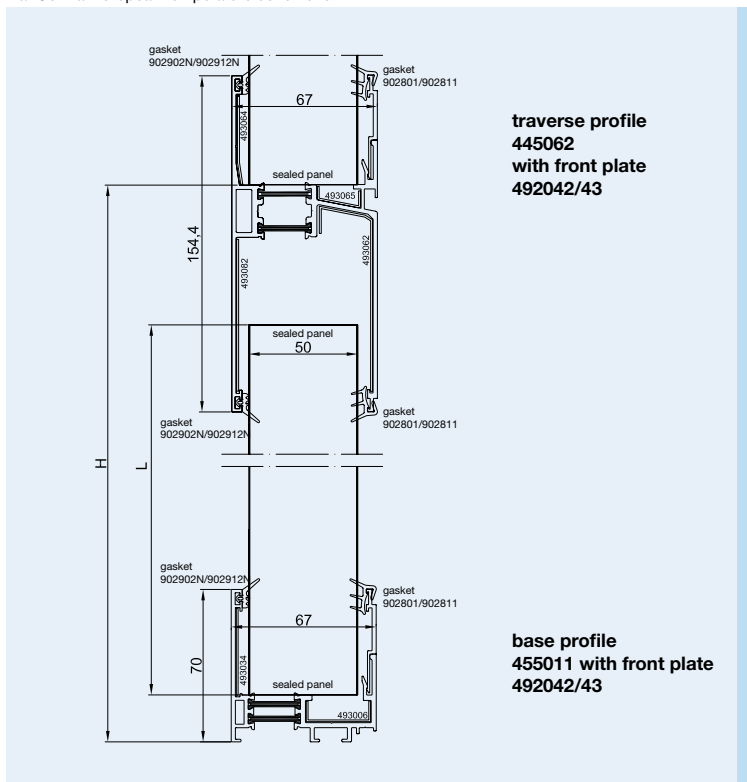
## 1.1.5.2

### Translucent Building Elements

Frame system thermally broken  
Top and base framing

#### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Traverse profile** 445062  
**Base profile** 455011

#### Article numbers

**445062** = Traverse profile  
493062 = Profile connector for 445062  
493082 = Profile connector for 445062  
493064 = Profile connector for 445062  
493065 = Profile connector for 445062  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**455011** = Base profile with drainage  
493006 = Profile connector for 455011  
493034 = Profile connector for 455011  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

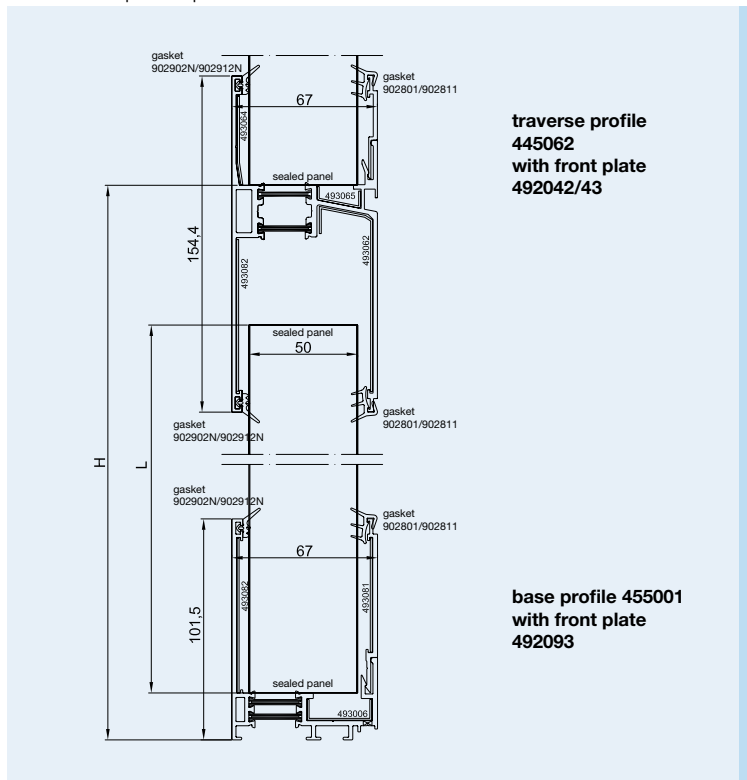
**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
 $L \text{ in mm} = \text{Height } H \text{ in mm} - 80 \text{ mm}$

#### Facade 90° up to 12m panel length\*

\* at Central European temperature conditions



**Traverse profile** 445062  
**Base profile** 455001

#### Article numbers

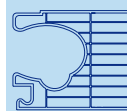
**445062** = Traverse profile  
493062 = Profile connector for 445062  
493082 = Profile connector for 445062  
493064 = Profile connector for 445062  
493065 = Profile connector for 445062  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**455001** = Base profile with drainage  
493082 = Profile connector for 455001  
493006 = Profile connector for 455001  
**492093** = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
 $L \text{ in mm} = \text{Height } H \text{ in mm} - 80 \text{ mm}$



## 1.1.5.4

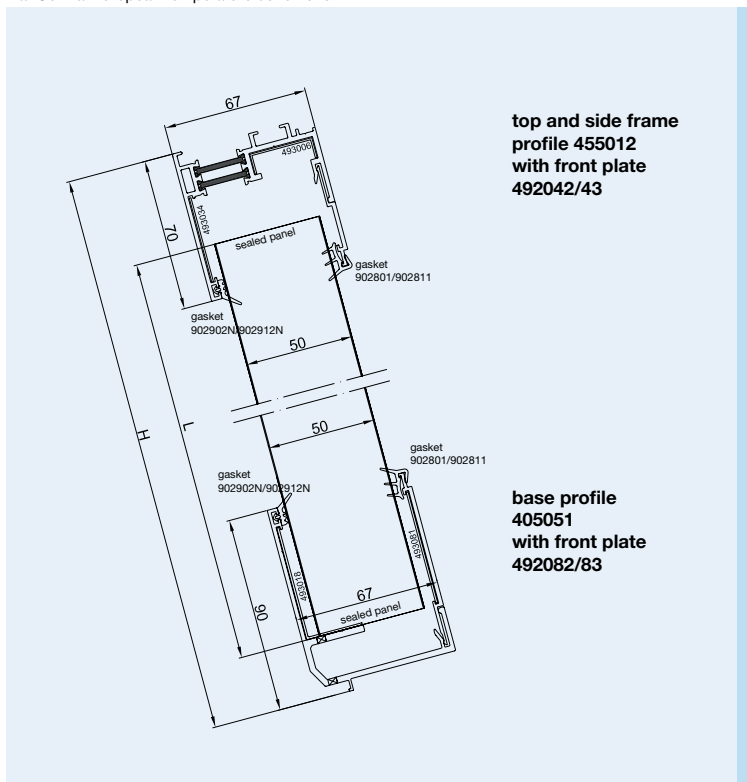
### Translucent Building Elements

Frame system thermally broken

Top and base framing

Pitched installation  $>15^\circ$  up to 4.5m panel length\*

\* at Central European temperature conditions



**Top profile 455012**  
**Base profile 405051**

#### Article numbers

**455012** = Top and side frame profile  
493006 = Profile connector for 455012  
493034 = Profile connector for 455012  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**405051** = Base profile  
493018 = Profile connector for 405051

**492082** = Front plate in L = 2.0 m  
**492083** = Front plate in L = 3.0 m  
493081 = Profile connector for 492082/83

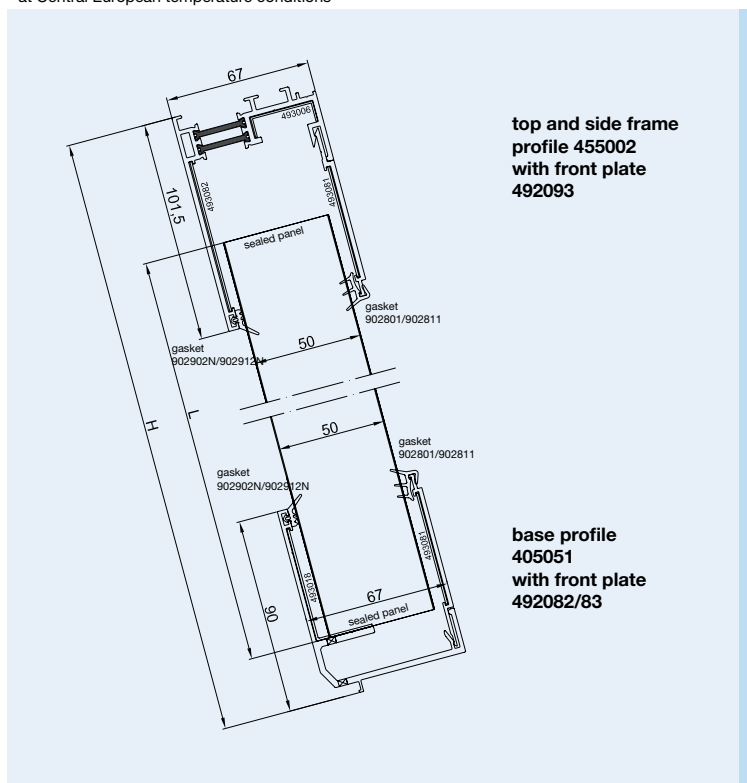
**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
L in mm = Height H in mm - **65 mm**

Pitched installation  $>15^\circ$  up to 12m panel length\*

\* at Central European temperature conditions



**Top profile 455002**  
**Base profile 405051**

#### Article numbers

**455002** = Top and side frame profile  
493082 = Profile connector for 455002  
493006 = Profile connector for 455002

**492093** = Front plate in L = 3.0 m  
493081 = Profile connector for 492093

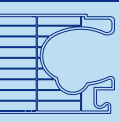
**405051** = Base profile  
493018 = Profile connector for 405051

**492082** = Front plate in L = 2.0 m  
**492083** = Front plate in L = 3.0 m  
493081 = Profile connector for 492082/83

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

Calculation of panel length:  
L in mm = Height H in mm - **85 mm**



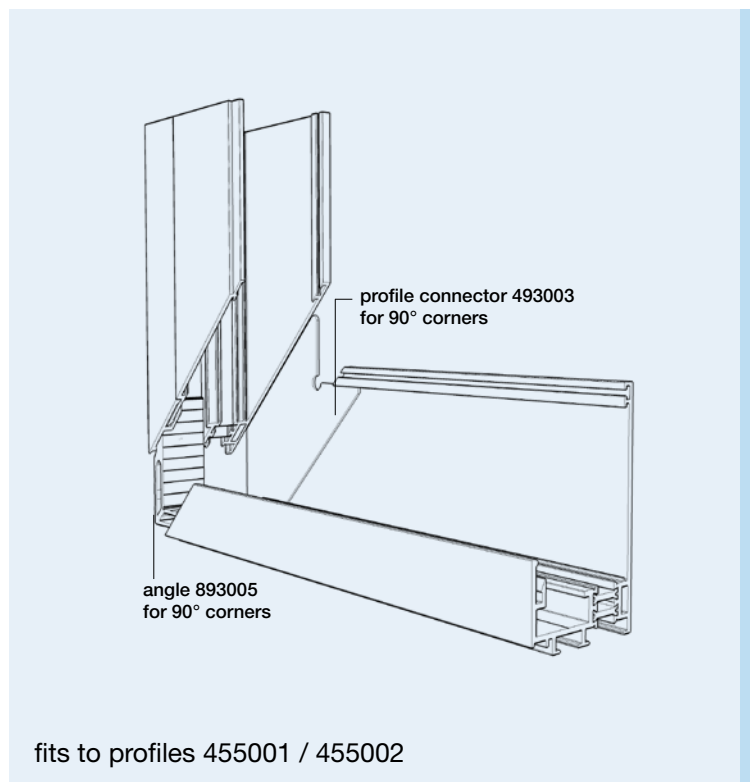
# 1.1.5.5

## Translucent Building Elements

Frame system thermally broken  
Corner connection

Stand: 10/17

### 90° corner connection 455005



#### General

90° corner connections of the profiles 455002 and 455012 are available as prefabricated components.

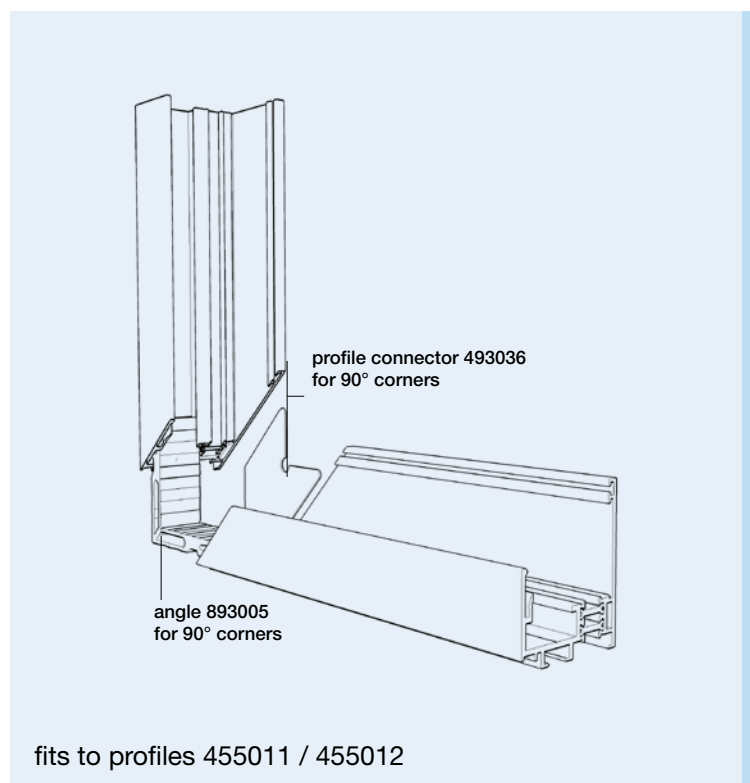
The corner connections are made of 0.55m long frame profiles, incl. front plates. The connections are sealed with profile connectors and sealant and thus save installation time and effort.

#### Initial lengths/-units

Prefabricated corner profile incl. front plates and profile connectors	
Length 0.55 m	1 pc. PU*
Profile connector 493003	4 pcs. PU*
Angle for 90° corner 893005	4 pcs. PU*
TPE gaskets, grey or black or special colour on request	50 m rolls

\*PU = Packing unit

### 90° corner connection 455015



#### Article numbers

**455005** = 90° corner connection prefabricated  
incl. profile connectors and front plate,  
fits to profile 455001 & 455002

493003 = profile connector for a 90° corner  
of profile 455001/02

893005 = angle for a 90° corner of profile  
455001/02

**455015** = 90° corner connection prefabricated  
incl. profile connectors and front plate,  
fits to profile 455011 & 455012

493036 = profile connector for a 90° corner  
of profile 455011/12

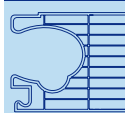
893005 = angle for a 90° corner of profile  
455011/12

#### Versions

Aluminium - mill finish

Aluminium - anodized E6/EV1

Aluminium - powder coated according to RAL



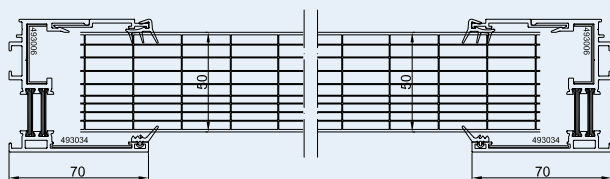
## 1.1.5.6

### Translucent Building Elements

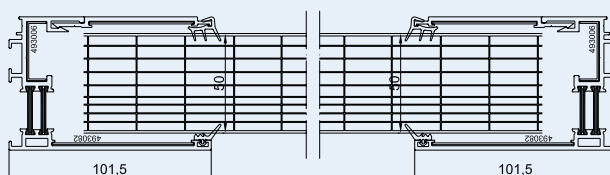
Frame system thermally broken

Lateral framing

#### Side connection



frame profile 455012  
with front plate 492042/43



frame profile 455002  
with front plate 492093

#### Side connection with frame profiles

##### Article numbers

**455012** = Top and side frame profile  
**493006** = Profile connector for 455012  
**493034** = Profile connector for 455012  
**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

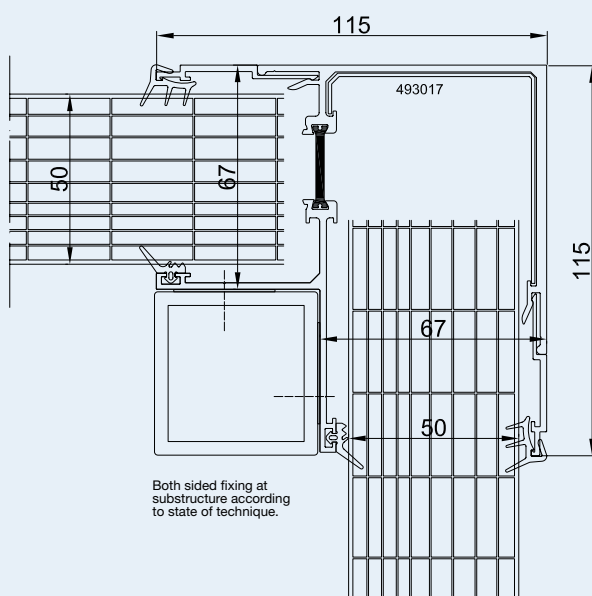
**455002** = Top and side frame profile  
**493082** = Profile connector for 455002  
**493006** = Profile connector for 455002

**492093** = Front plate in L = 3.0 m  
**493081** = Profile connector for 492093

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

#### Side connection 90° corner



Corner profile 445072

All thermally broken profiles can be combined  
with non-thermally broken profiles.

#### Side connection 90° corner with profile 445072

##### Article numbers

**445072** = Corner profile  
**493017** = Profile connector for 445072

**492042** = Front plate in L = 2.0 m  
**492043** = Front plate in L = 3.0 m

**902801** = Outer plug gasket TPE grey  
**902811** = Outer plug gasket TPE black

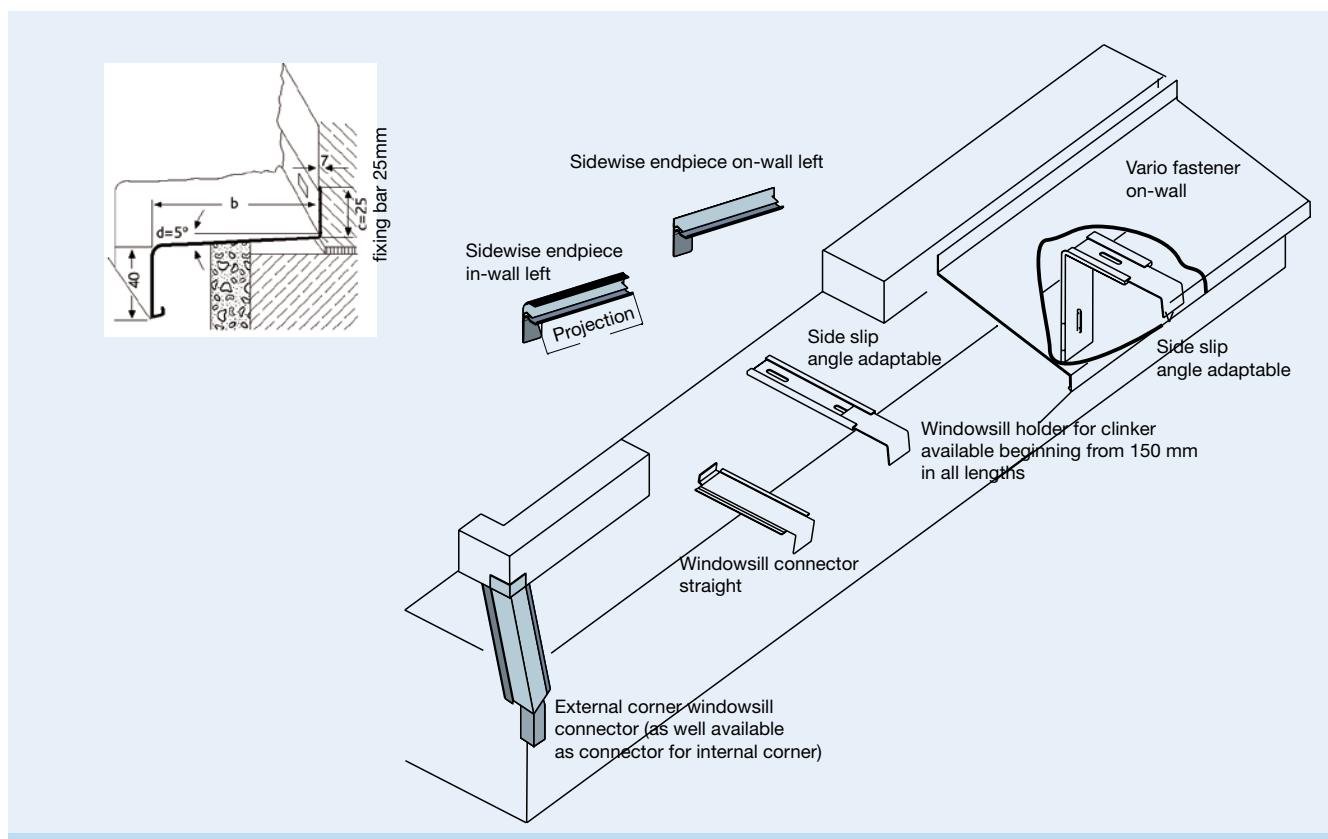
**902902N** = Inner lip gasket TPE grey  
**902912N** = Inner lip gasket TPE black

# 1.1.6.0

## Translucent Building elements

### Windowsills and accessories

Stand: 10/17



#### Installation manual - Windowsill products

##### Please note before installing:

- Thermal expansion of the profiles:  
Windowsills over 3,000 mm long must be divided in the middle and extended through a connection joint. The windowsills must be sufficiently fastened to the frame and be tight against rain water. The possibility for the windowsill to expand must be made sure depending on length.
- For sound insulation during heavy rains we recommend to provide windowsills with a sound absorptive stripe. The sound absorptive area should be around 1/3 of the windowsill area.
- For on-site fixing of windowsill on the profile (non-RODECA profile) of the windows the self-sealing gasket (black or white) is to be used.
- Aluminium windowsills should project about 40 mm over the finished facade. The profile width should be measured accordingly. This applies only for installations with side endings. Without side endings the projection of windowsills should not be lower than 20mm.
- From a projection/profile depth of 150 mm holders (Vario fastener or clinker fastener) are necessarily to be used on the structure (every 800 to 1,000 mm).

##### Note for installation:

Before installation of the side elements stick the sound absorptive stripes approx. 50 mm behind the beginning of the drip edge on the bottom side of the windowsill profile.

Please don't forget to leave free approx. 30 mm on the front sides of the windowsill in order to be able to install the side elements.

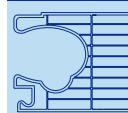
On the predrilled (perforated) side of the windowsill insert the gasket, check the straight and precise seating of the rubber profile and remove the cover strip from the adhesive surface. (This does not apply to assemblies with RODECA profiles)

Before screwing the windowsills, if using Rodeca profiles, the base profile and chosen adapter are installed to the supporting substructure. The side elements are to be clipped on in advance. After clipping on the side elements and fastening the windowsill, seal the connection points all around. Please leave at least 5 mm on each side of the windowsill for the thermal expansion.

If implementing full thermal protection it is important to make sure that the vario fastener is fixed before placing the insulation to the masonry. This also applies if using the holder for clinker installation.

The windowsill with the protective foil side at the top is to be fixed at the edge of the window using windowsill screws\*. The foil may not be covered while assembling the connector elements. Make sure to provide the final windowsill slope of at least 5° after the assembly. When plastering the side elements please check the presence of expansion joint and keep in mind the thermal expansion of aluminium. Coarse mortar and plaster remnants must be removed immediately from the protective foil. After completion of the facade work in the windowsill area, the protective foil has to be removed as quickly as possible.

\* Size of the screw head – 3.9 mm

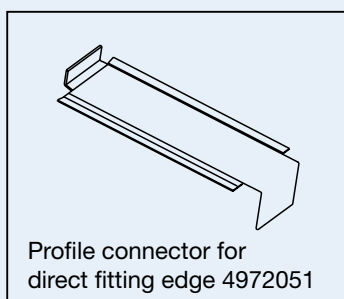
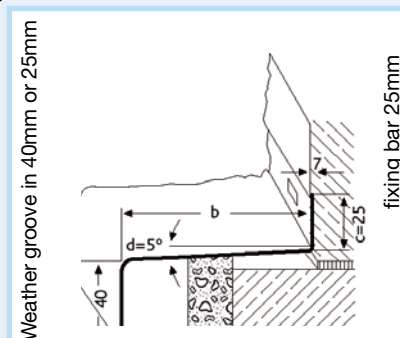
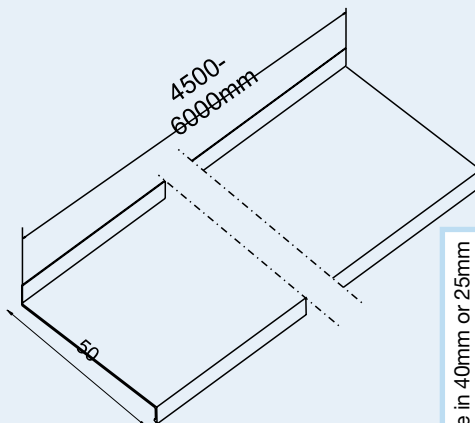
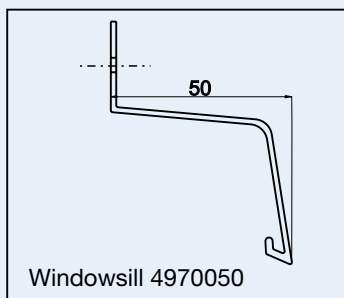


## 1.1.6.1

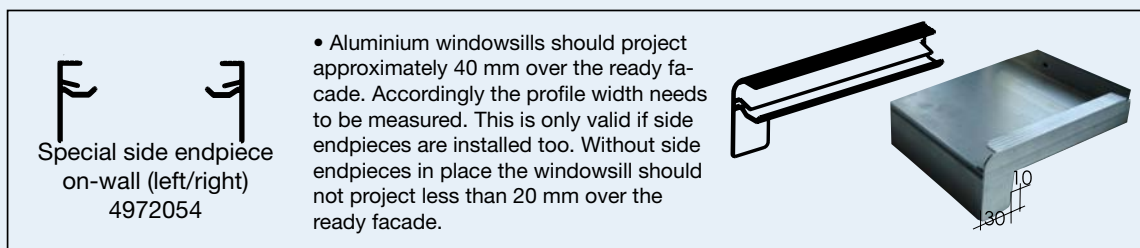
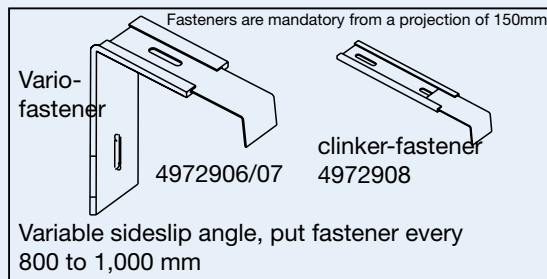
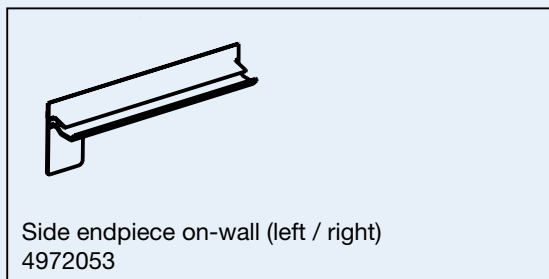
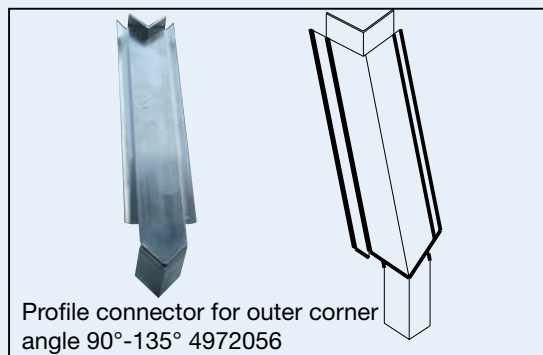
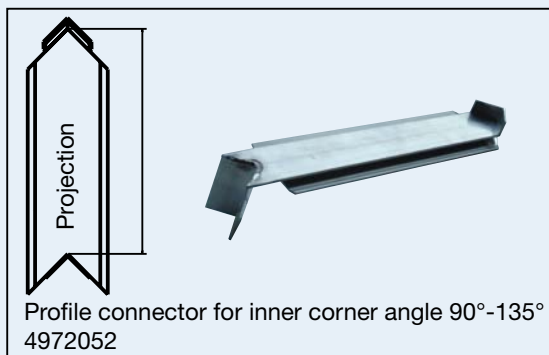
### Translucent Building elements

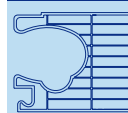
#### Windowsills and accessories

Example for construction group:



Example: article numbers for a 50 mm windowsill projection:





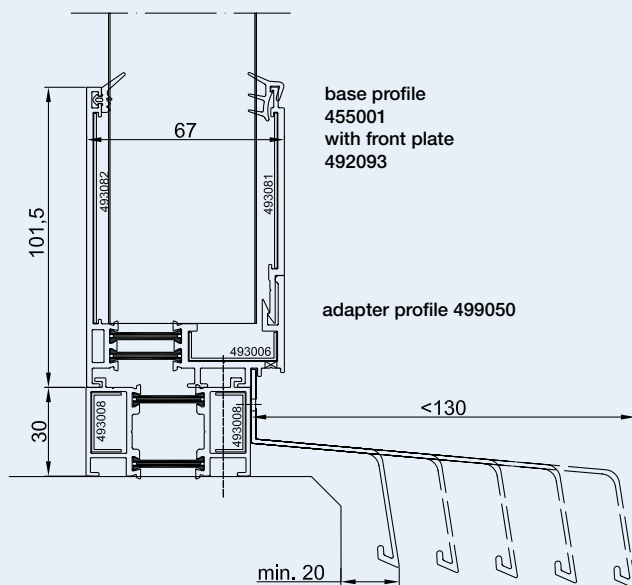
## 1.1.6.3

### Translucent Building elements

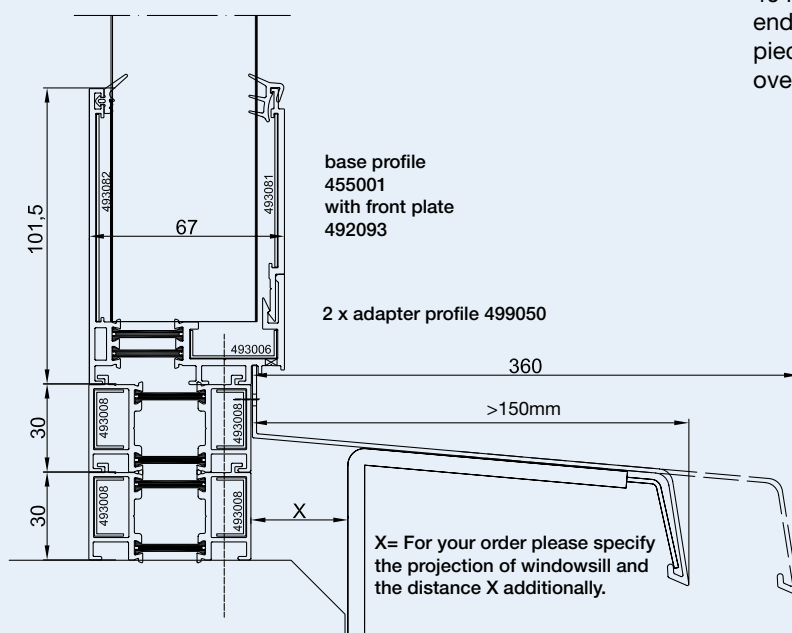
Windowsills and accessories

Framing system thermally broken

Aluminium windowsills for thermally broken frame profiles with adapter profiles



Base profile 455001 (also 455011) with adapter profile 499050 for windowsill projections from 50 mm to 130 mm.



Base profile 455001 (also 455011) with 2 x adapter profile 499050 for windowsill projections from 150 mm to 360 mm.

#### General

Compatible to thermally broken frame profiles we offer a suitable adapter profile for connection of windowsills with varying projections.

#### Initial lengths/-units

Aluminium profile	6.00 m
Profile connector	10 cm

#### Article numbers

**4971070** = windowsill 70 mm projection  
**4971110** = windowsill 110 mm projection  
**4971150** = windowsill 150 mm projection

windowsills with 70mm / 110 mm / 150 mm projection available from stock

**499050** = thermally broken adapter profile for profile 455001  
**493008** = Profile connector for 499050

**For use with adapter profile 499050 the allowance for calculation of panel length must be increased by 30 mm per adapter profile.**

Aluminium windowsills should project approx. 40 mm over facade. This applies only if side end pieces are installed. Without side end pieces the windowsill must project 20 mm over facade.

