

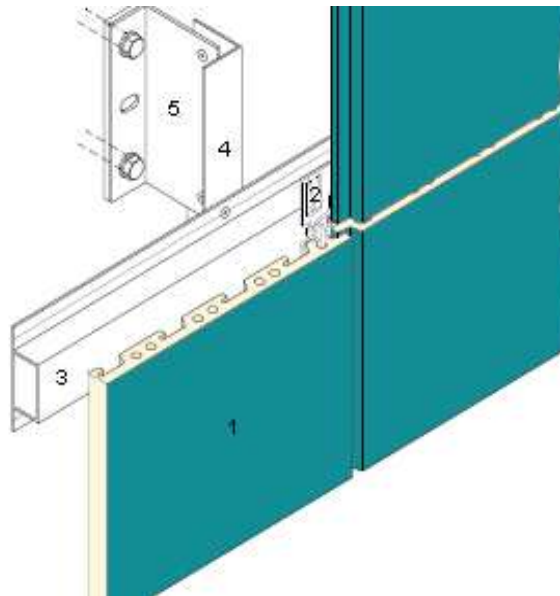
## Mounting instruction

KeraTwin<sup>®</sup> K20 clamp - vertical layer

### Substructure

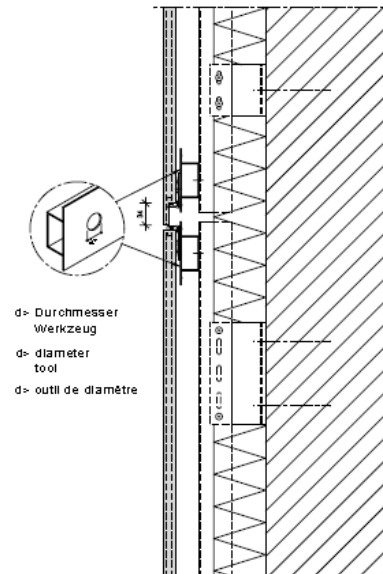
The mounting of the basic substructure must be carried out according to project-specific, static calculation.

- The profiles have to be mounted perpendicularly and in a flush way.
- The length of the vertical profiles must be divisible by the height of the panel size and should not exceed the height of one storey of the building.
- A profile butt joint of the vertical profiles behind a panel is not allowed.
- The horizontal joints can be covered by using the black joint tape (Art. No. 506).
- The clamps (Art. No. 680, 681, 682, 683, 684) have to be fixed with two rivets (Art. No. 675).
- To work up the rivets (Art. No. 675) an extended nozzle (25mm) at the rivet tool is needed.
- The joint with the clamps can be closed by using the joint profile (Art. No. 688) installed with the clip (Art. No. 689).
- For further information, see the standard technical details of the system K20, which we will make available to you on request.

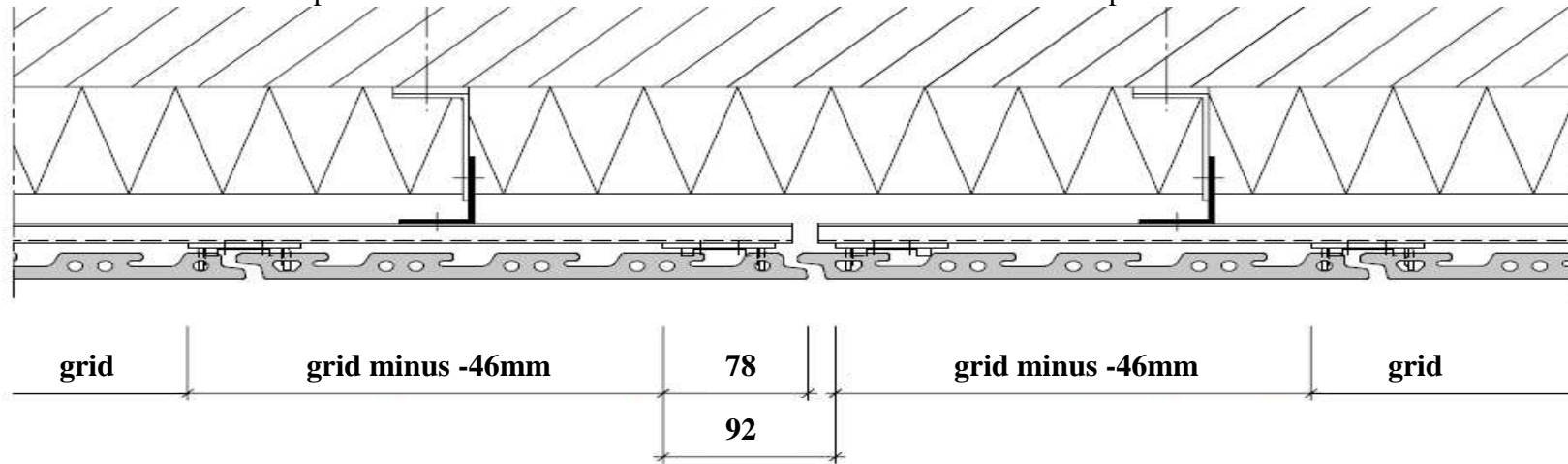


#### Important:

**A profile butt joint of the vertical bearing profiles behind a panel is not allowed! See standard technical detail drawings.**



Fix the first row of clamps as shown underneath. Use 2 rivets Art. Nr. 675 for each clamp.



Start with edge-clamps Art. Nr. 682 – 681 ... 681 – 683



affix the joint tape Art. Nr. 506



put the panels into the preassembled clamps.  
at the edging use the edge-clamp Art. Nr. 684 ...  
for further fixings use the twin-clamps Art. Nr. 680



Twin-clamp K20 #680



edge-clamp K20 #681



edge-clamp K20 left #682



edge-clamp K20 right #683

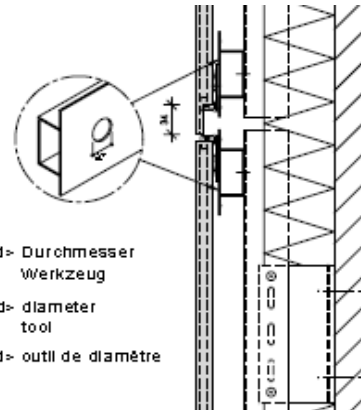
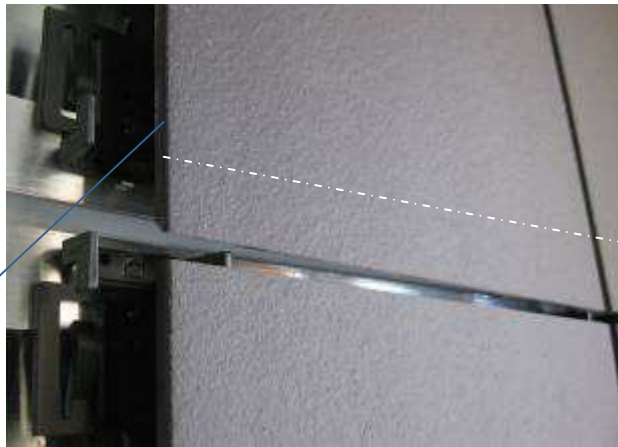


single clamp K20 #684



bend the clamp on thread at first to your body and  
than back, repeat until breakage

**Vert. butt-joint**

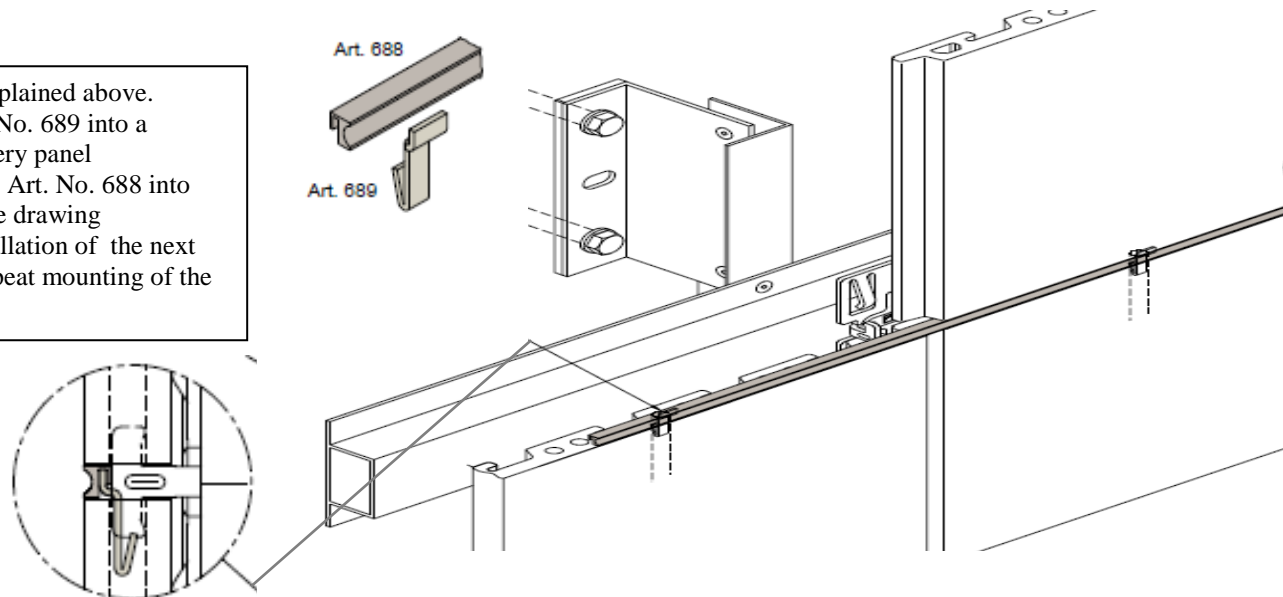


undercut 34mm  
here is shown the panel reverse side and the installation principle

Use panels with undercut (34mm) – fixed with edge-clamps K20  
Please determine the undercut left or right on the panel during the design work. The disposal of the panel edges (top or bottom line) effects the look of the design.  
*e. g. the picture shows the bottom line of the panel - left.*

**Joint profile**

- fix the panels as explained above.
- insert the clip Art. No. 689 into a free channel of every panel
- put the joint profile Art. No. 688 into clip as shown in the drawing
- go ahead with installation of the next row panels and repeat mounting of the joint profile



**Replacement of a panel**

Cut the joint profile #688 at the vert. joints (length: 2 panel width)



press out and pull out the cut joint profile section



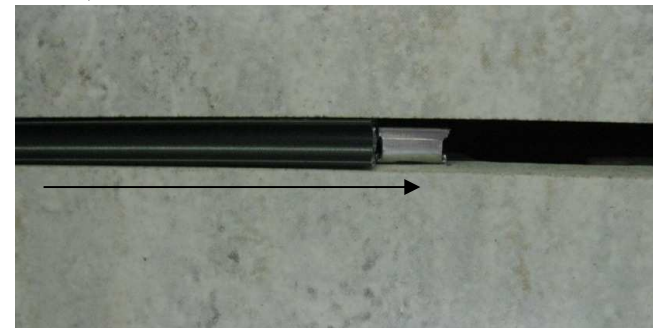
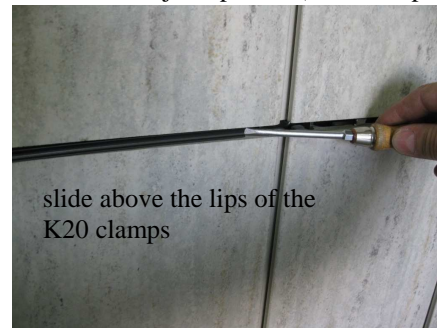
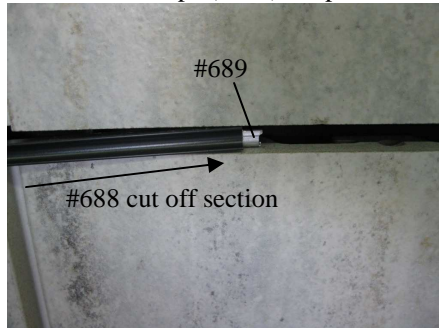
cut off clamp lips, left and right the panel and take out the panel



use edge-clamp right #683 and edge-clamp left #682 and fix it with rivets #675



slide into the clips (#689) the prior cut off section of the joint profile (#688 L=2panel width)



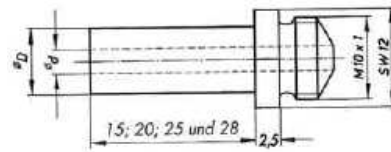
### Tools and rivets



drill bit  $\varnothing$  3,3 mm



extended nozzle (25mm)  
please find from tool supplier



(e. g. for Gesipa AccuBird Art. No. 1457372)



#675 stainless steel rivet  $\varnothing$  3,2 x 9,5  
with extended bolt