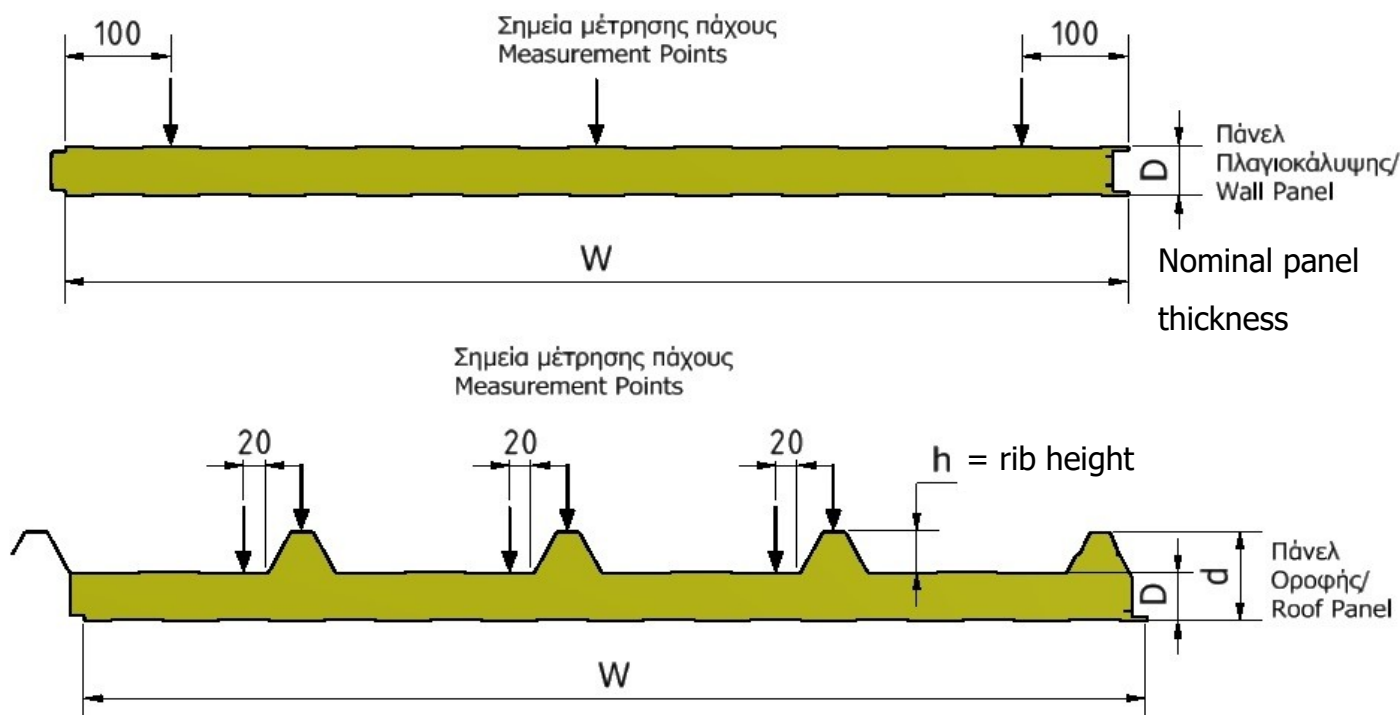


## Dimensional Tolerances of Insulated panels (According to EN 14509:2013)

**1. Thickness**  $D \leq 100 \text{ mm} \pm 2\text{mm}$

$D > 100 \text{ mm} \pm 2\%$

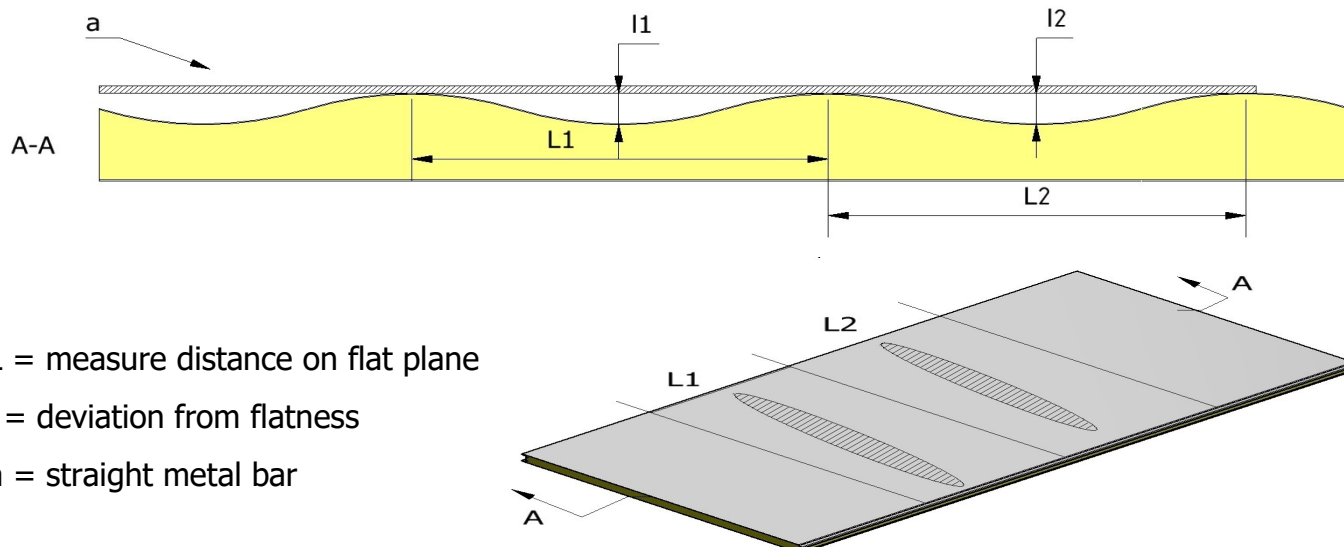


**2. Deviation from flatness**

For  $L_i = 200 \text{ mm}$   $l_i \leq 0,6\text{mm}$

For  $L_i = 400 \text{ mm}$   $l_i \leq 1,0\text{mm}$

For  $L_i > 700 \text{ mm}$   $l_i \leq 1,5\text{mm}$



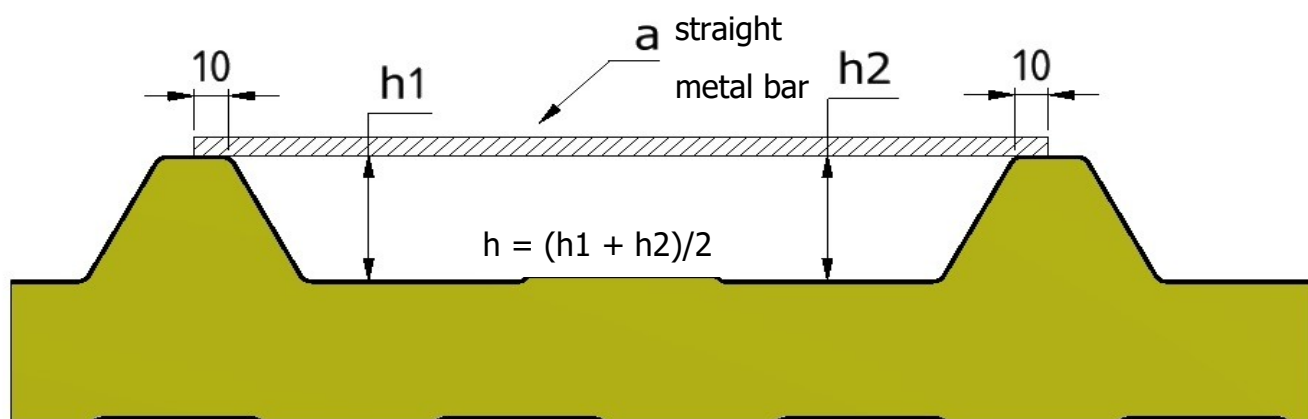
$L$  = measure distance on flat plane

$l$  = deviation from flatness

$a$  = straight metal bar

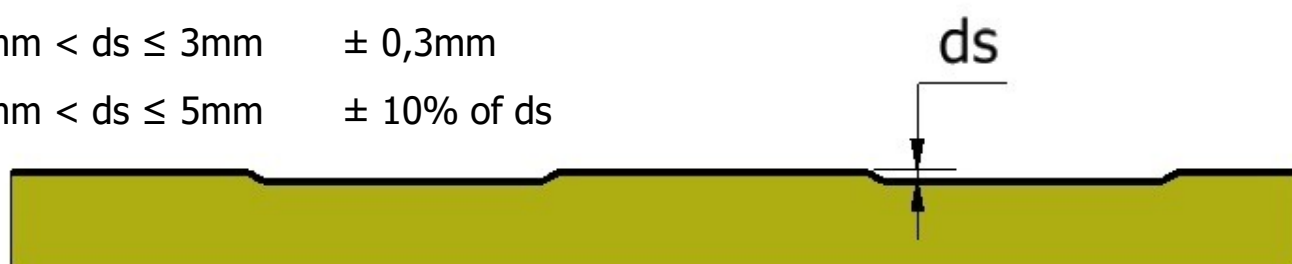
## Dimensional Tolerances of Insulated panels (According to EN 14509:2013)

- 3. Depth of metal profile**  $5\text{mm} < h \leq 50\text{mm}$ ,  $\pm 1\text{mm}$   
 $50\text{mm} < h \leq 100\text{mm}$ ,  $\pm 2,5\text{mm}$

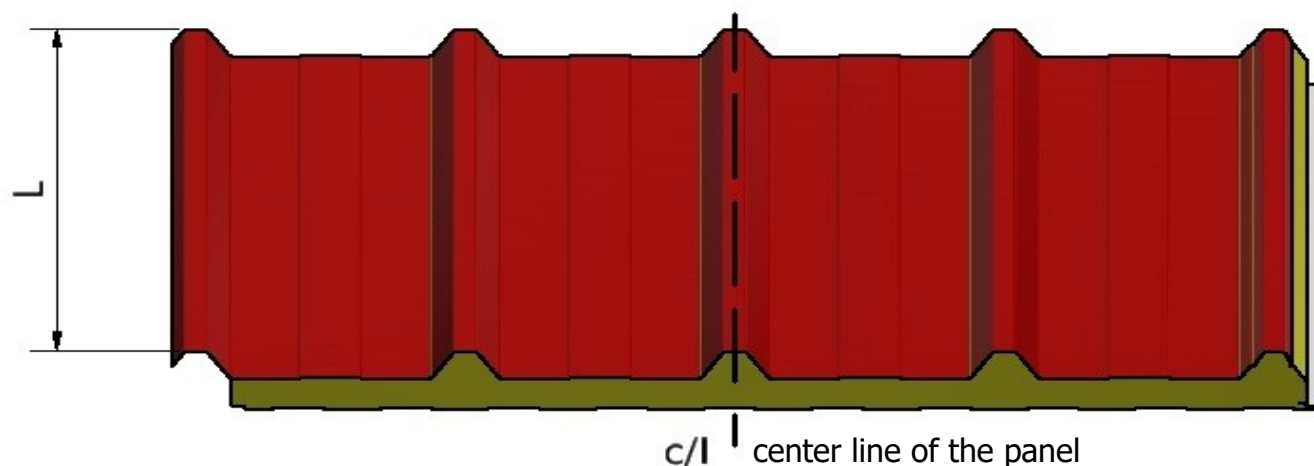


### 4. Depth of stiffeners on lightly profiled facings

- $ds \leq 1\text{mm}$   $\pm 30\%$  of  $ds$   
 $1\text{mm} < ds \leq 3\text{mm}$   $\pm 0,3\text{mm}$   
 $3\text{mm} < ds \leq 5\text{mm}$   $\pm 10\%$  of  $ds$

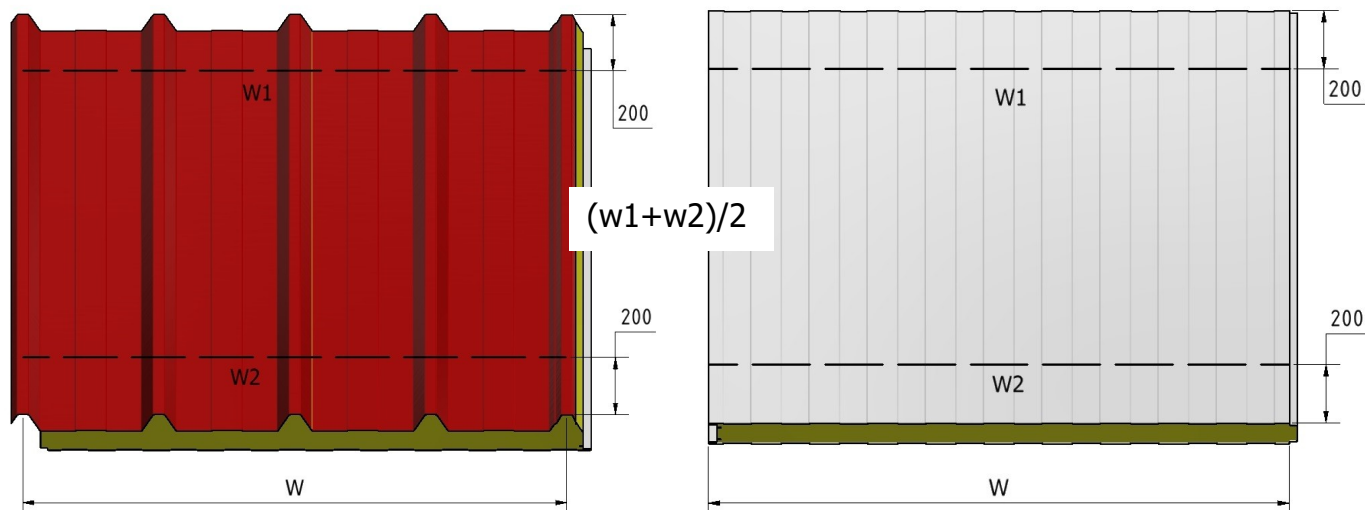


- 5. Length**  $L \leq 3000\text{mm}$   $\pm 5\text{mm}$   
 $L > 3000\text{mm}$   $\pm 10\text{mm}$

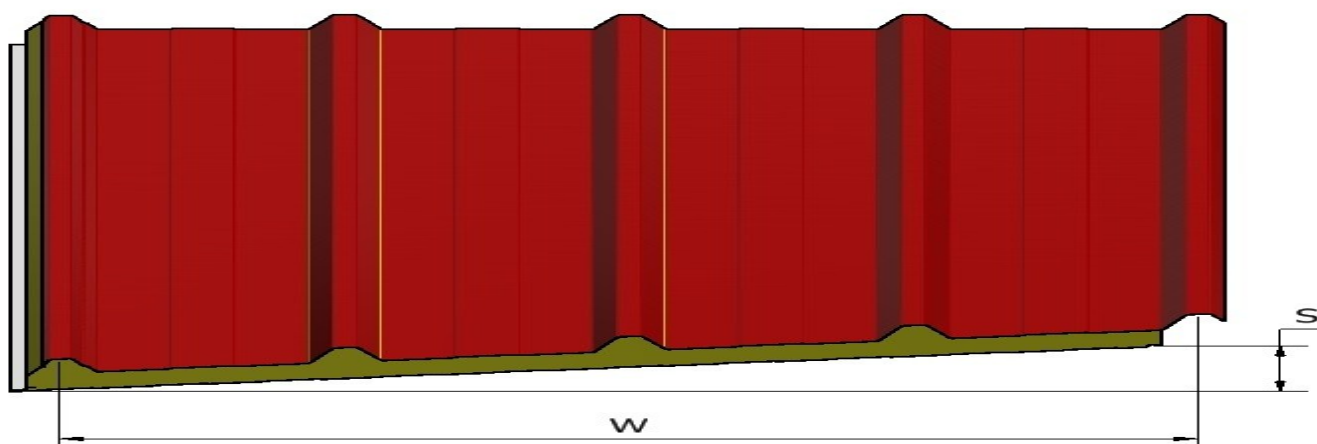


## Dimensional Tolerances of Insulated panels (According to EN 14509:2013)

### 6. Cover width $W \pm 2\text{mm}$



### 7. Deviation from squareness $S \leq 0,6\%$ of the $W$



### 8. Deviation from straightness

$\delta = 1\text{mm/m}$  & max total deviation 5mm



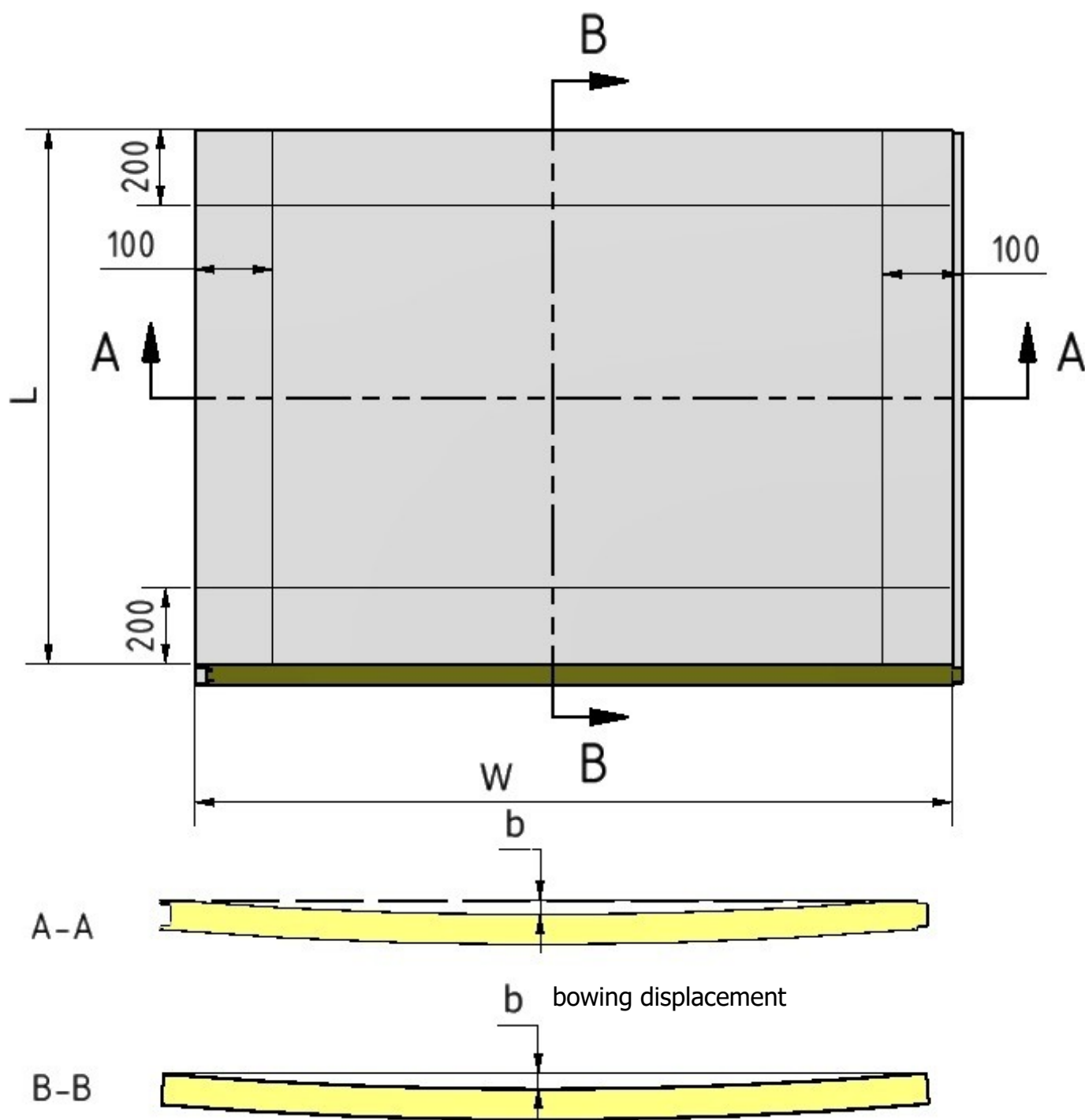
## Dimensional Tolerances of Insulated panels (According to EN 14509:2013)

### 9. Bowing

2,0mm for each meter length but  $b(\text{total}) \leq 20\text{mm}$

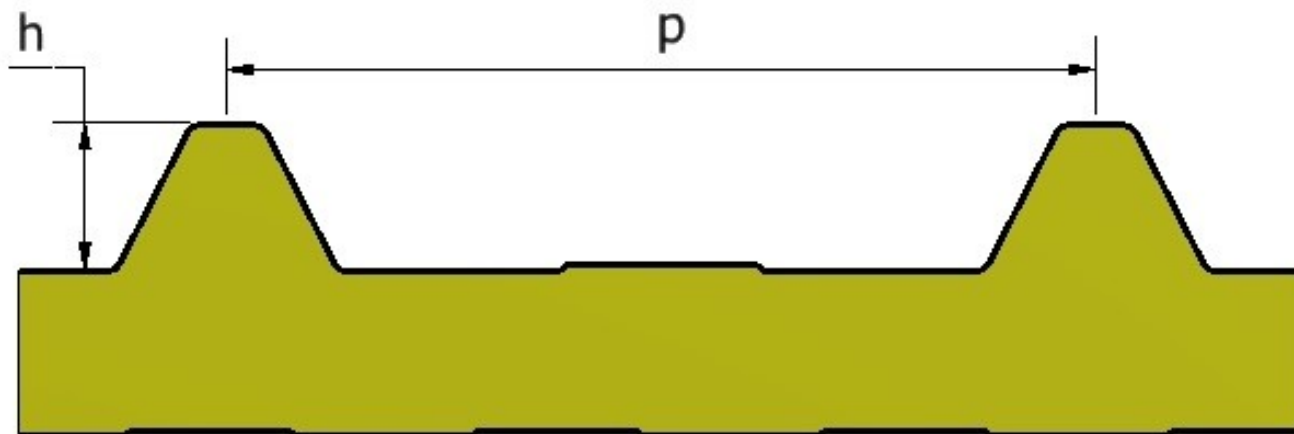
8,5mm for each meter width for flat or lightly profiled,  $h \leq 10$

10 mm for each meter width for other depths profile,  $h > 10$  (roof panel)

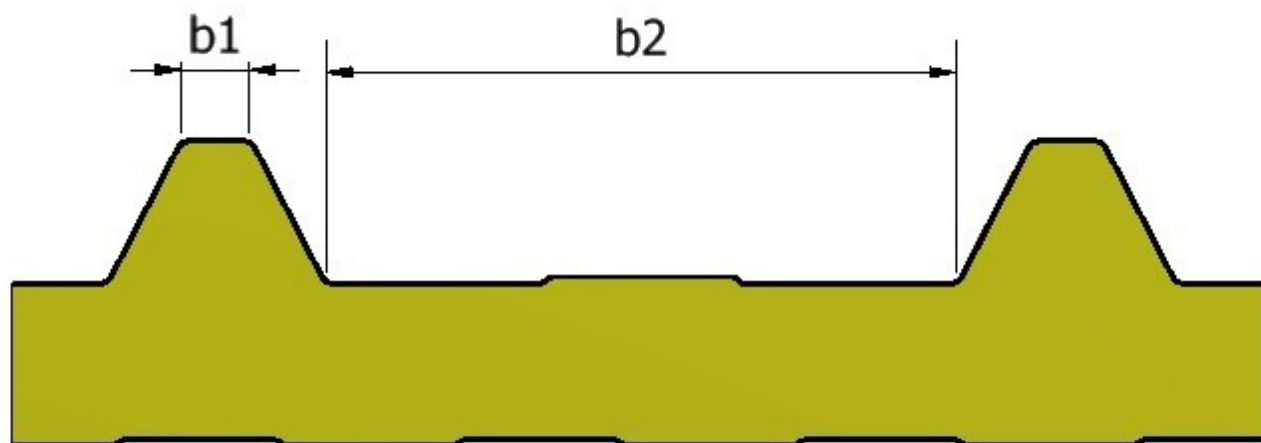


## Dimensional Tolerances of Insulated panels (According to EN 14509:2013)

- 10. Pitch of profile**     $h \leq 50\text{mm}$              $\pm 2\text{mm}$   
                                  $h > 50\text{mm}$              $\pm 3\text{mm}$



- 11. Width of rib and valley**      Rib width             $\pm 1\text{mm}$   
   Valley width         $\pm 2\text{mm}$



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