



Standard Cladify Technical Specifications (SCTS)



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1. Terms And Definitions

For the purpose of this document the terms and definitions given in SCTS (Standard Cladify Technical Specification) and the following apply.

1.1 Panel for cladding.

Panel cut to size which forms a wall and ceiling finishes for outside or inside use, fixed to a structure mechanically.

1.2 Dimensions of panels for cladding.

The length l, width b and thickness d are the dimensions of a panel for cladding. They are given in the stated sequence in inches (see Figure 1).

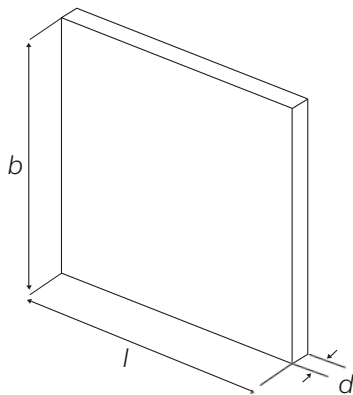


Figure 1

2. Requirements

2.1 Requirements for geometric characteristics

2.1.1 General.

All measurements shall be carried out in accordance with SCTS and all measured values of individual units shall fall within the required tolerances.

2.1.2 Requirements for thickness by more than given in Table 1.

Table 1 – Tolerances On The Nominal Thickness

Nominal Thickness In Inches	Tolerance
More than 1/2" up to and including 2"	± 1/8"
More than 2" up to and including 5"	± 1/4"
More than 5"	± 1/2"

The required thickness of panels shall result from a structural analysis or similar procedure which takes into account the technical and physical properties of the panel and the intended application.

2.1.3 Requirements for flatness.

The deviation from flatness of the surface shall not exceed 0.2% of the panel length and shall not exceed 1-1/2". For natural cleft faces, the tolerance on flatness shall be declared by manufacturer.

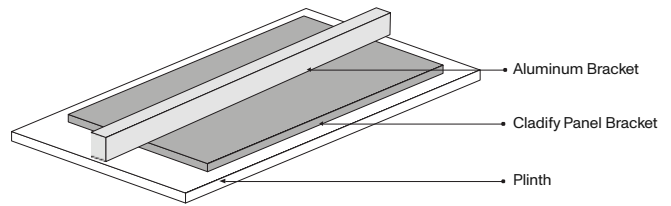


Figure 2

Table 2 - Requirements For Flatness

Thickness	Transversal		Longitudinal	
	Width	F	Length	F
1"	60"	≤ 1/4"	Length	≤ 1/4"

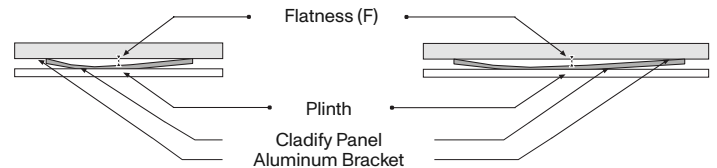


Figure 3

2.1.4 Requirements for length and width.

The length or width shall not deviate from the nominal size by more than given in.

Table 3 – Tolerances On Length And Width

Nominal Length and Width In Inches	< 24"	≥ 24"
Sawn edges thickness	± 1/16"	± 1/8"

2.1.5 Requirements for angles and special shapes

The permissible tolerance at any point shall be as stated in Table 3.

Each panel angle shall be in accordance with the agreed geometry. Pieces of special or irregular shape shall be checked for compliance with the required shape by use of a suitable template, the permissible tolerance at any point shall be as stated in Table 3.

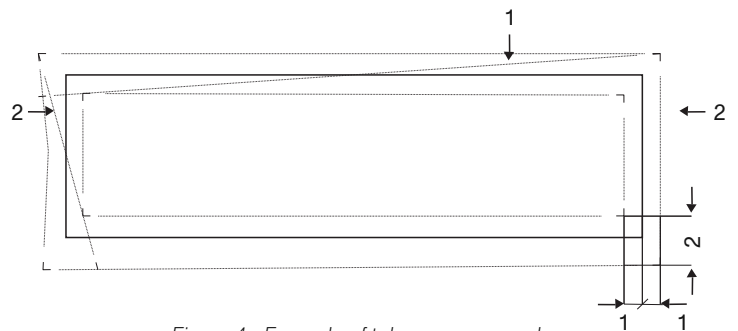


Figure 4 - Example of tolerances on angles.

1. Nominal size.

2. The slab sides shall fall within the two dotted lines indicating the tolerance of length and width according to table 3.

Max. angle tolerance is ± 0.5%.

2.1.6 Requirements for holes.

The size of holes (porosities) should not be bigger than 1/16".

2.1.7 Requirements for surface finish

2.1.8.1 General.

Surface finishes shall be carried out uniformly to the edges of the cladding panel.

The surface finishing of some types of stones may typically involve the use of patching, fillers or other similar products for natural holes, faults or cracks; this is to be considered as part of the normal processing. In such cases the type of treatment, as well as the type and nature of additional materials, shall be declared.

2.1.8.2 Requirements for surfaces after surface finishing

Surfaces shall have a regular appearance as a function of the finishing process and shall be worked to meet the specified finish (e.g. making reference to samples) on all exposed surfaces.

Cladify panels with stone facing are subject to variation in color, shading, veining, and patching. Stone is a natural material and as it is characteristics, variations are inevitable.

NOTE 1: Surfaces obtained by grinding are, for example:

- Rough ground surfaces obtained, e.g. by means of a grinding disk of grain size F60 (Acid wash);
- Medium ground surfaces obtained, e.g. by means of a grinding disk of grain size F120;
- Fine ground surfaces obtained, e.g. by means of a grinding disk of grain size F220;
- Matt finished surfaces obtained, e.g. by means of a grinding disk with grain size F400;
- Highly polished surfaces obtained, e.g. by means of a polishing disk or felt F600.

NOTE 2: Surfaces obtained by means of percussion tools are as per sample:

2.2 General

This characteristic shall always be declared.

The colour, veining, texture, etc. of the Material shall be identified visually, typically by a reference sample of the same stone suitable for providing a general description of visual appearance. The reference sample shall be provided by the supplier.

2.3 Reference sample, visual inspection and acceptance criteria.

A reference sample shall be an adequate number of pieces of natural stone of sufficient size to indicate the general appearance of the finished work. The dimensions of individual pieces shall be at least 0,01 square meters (typical values are between 0,01 and 0,25 square meters in face area but may be more) and shall indicate the range of appearance regarding the colouring, the vein pattern, the physical structure and the surface finish. In particular the reference sample shall show specific characteristics of the stone, such as holes for travertine, worm holes for marble, glass seams, spots, crystalline veins and rusty spots.

The reference sample does not imply strict uniformity between the sample itself and the actual supply; natural variations may always occur.

If the processing of the stone involves the use of patching, fillers or other similar products for natural holes, faults or cracks, then the reference sample shall similarly display the impact of the same on the finished surface.

All the characteristics as shown by the reference sample shall be considered typical of the stone and not as flaws, therefore they shall not become a reason

for rejection, unless their concentration becomes excessive and the typical character of the stone is lost.

Any comparison between production sample and reference sample shall be carried out by placing the reference sample against the production samples and viewing them at a distance of about two meters under normal daylight conditions and recording any visible differences in the characteristics of the stones (Figure 5).

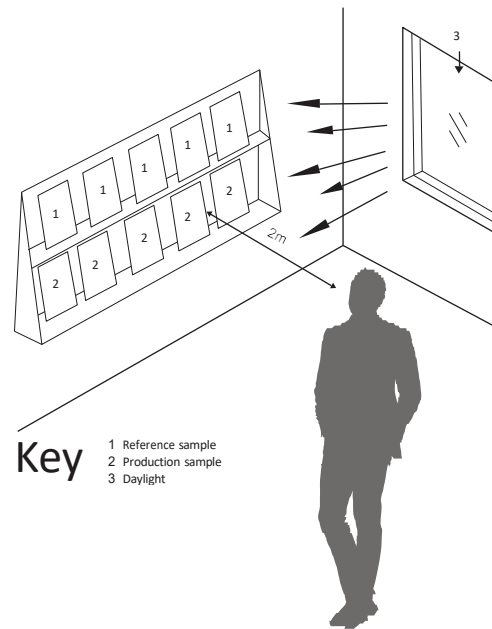


Figure 5

2.4 Damage to walls caused by movement of panel and footing and other causes.

• Table 4 – Description Of Typical Damage & Required Repair

Description	Crack Width Limit	Crack Category
Hairline Cracks	< 0.1mm	0
Fine cracks that do not need repair.	1/16"	1
Cracks noticeable but easily filled.	<1/4"	2
Cracks can be repaired and possibly a small amount of wall will need to be replaced.	1/4 - 3/4" (or a number of cracks 0.12 or more in one group)	3
Extensive repair work involving breaking-out and replacing sections but also depends of walls.	3/4 - " but also depends on number of cracks.	4

2.5 Inspection surfaces from a normal viewing position.

Generally, variations in the surface colour, texture and finish of walls, ceilings, floors and roofs, and variation to be viewed where possible from a normal viewing position. A normal viewing position is looking at a distance minimum 2 meters with the surface or material being illuminated by 'non-critical light' means the light that strikes the surface is diffused and is not glancing or parallel to that surface.

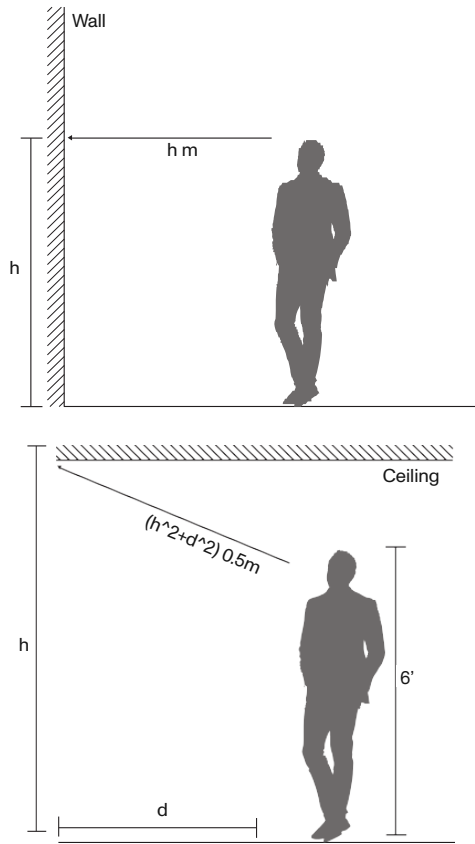


Figure 6

2.6 The measurement of SCTS tolerances

Vertical Surfaces

Deviations of vertical surface from a true vertical plane are to be measured from a plumb line through a plan position or reference point nominated in the contract documents or inferred if none is nominated. The maximum deviation of a vertical surface from that plumb line will not exceed more than 1/2" from a plane surface (Bow) in any 2 m length. Refer to below diagrams. Where diagrams are provided for the clarification of details, the diagram shows only detail relevant to the issue and is not intended to be used as general details for construction.

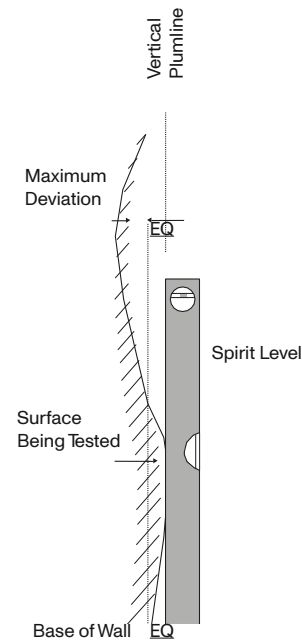
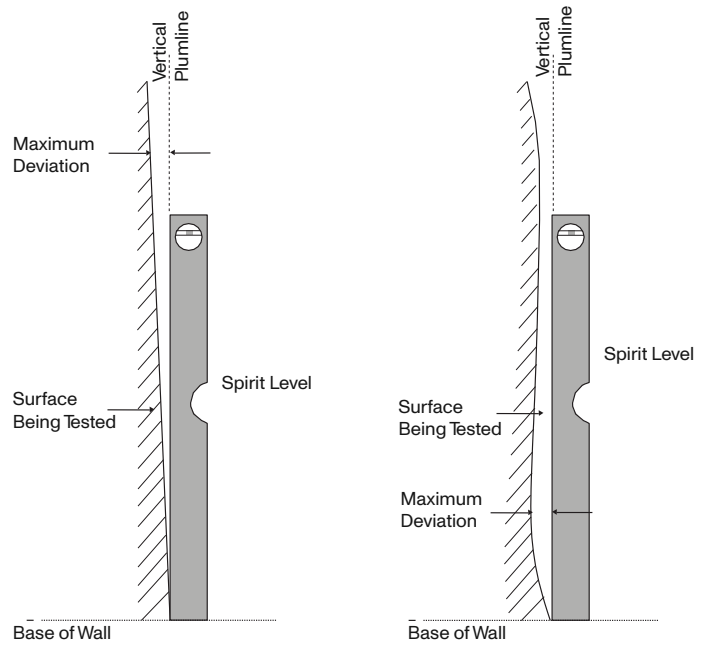


Figure 7

2.7 Tolerance in Cladify Panel installation

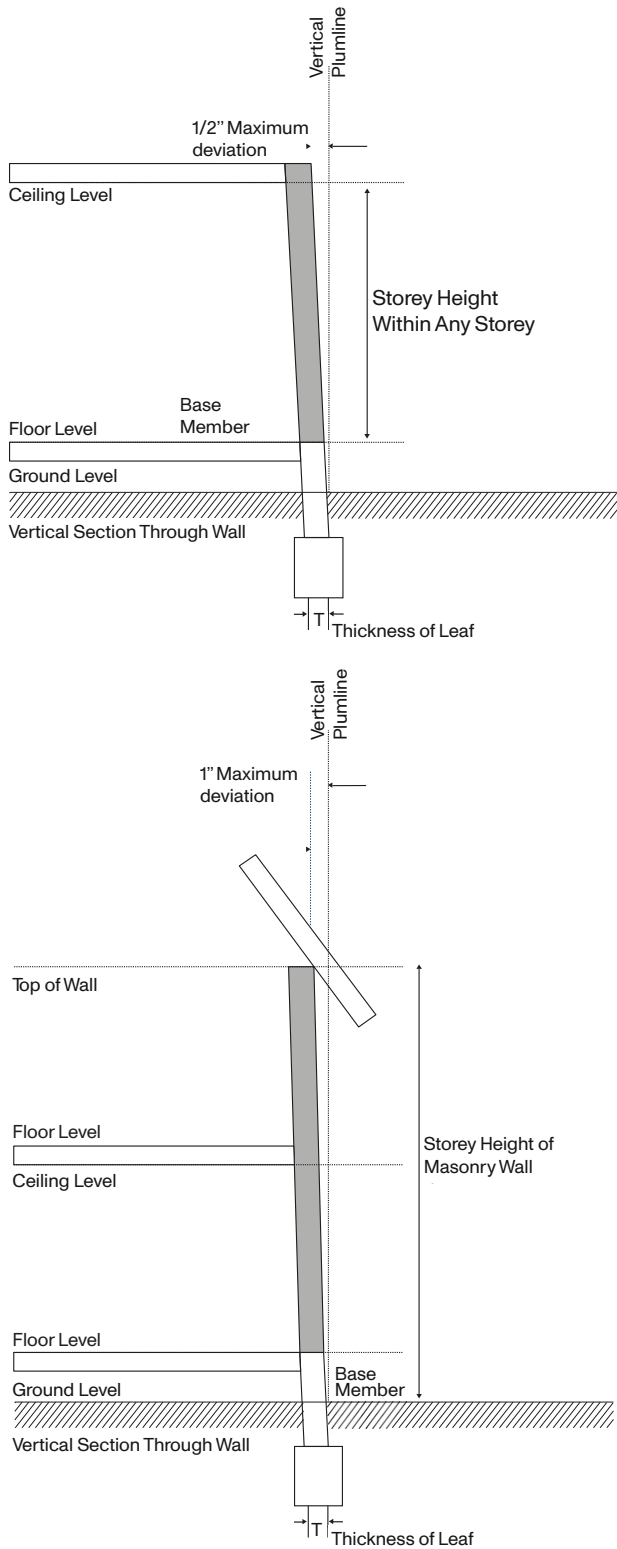


Figure 8

2.8 Tolerances in installation of Cladify panels.

For width of panel 1500 mm: $\pm 1/4"$ - 0,1%

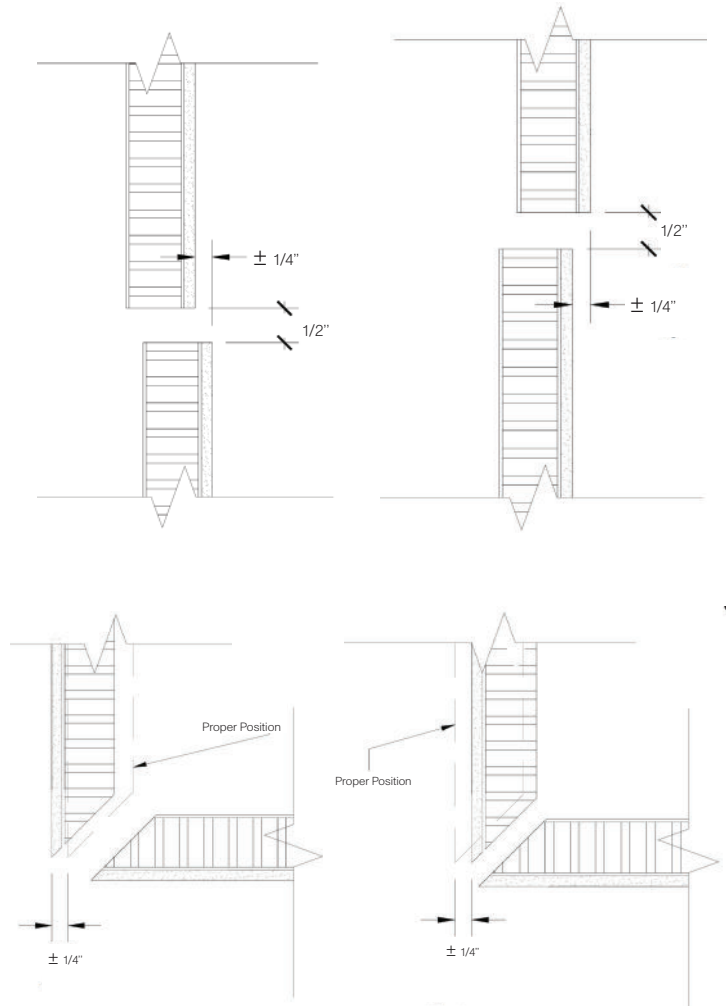


Figure 9

2.9 Tolerances in installation of Cladify panels- Joint Tolerances.

Acceptable panel to panel: all ceiling and floor joint gaps.

Table 5 – Description Of The Joint Condition

	Min Joint Size	Max Joint Size
Panel to Panel	1/8"	1/2"
Panel to Wall	0"	1"- 3/4"
Panel to Ceiling	0"	1"- 3/4"
Panel to Floor	0"	1"- 3/4"

Note: Site conditions and wall conditions may affect the acceptable tolerances. The Min and Max acceptable tolerances are calculated based on the highest point on the outages.

2.10 Tolerances in installation of Cladify panels - Panel joints

For panel alignment: Ins and outs - Max $\pm 1/4"$

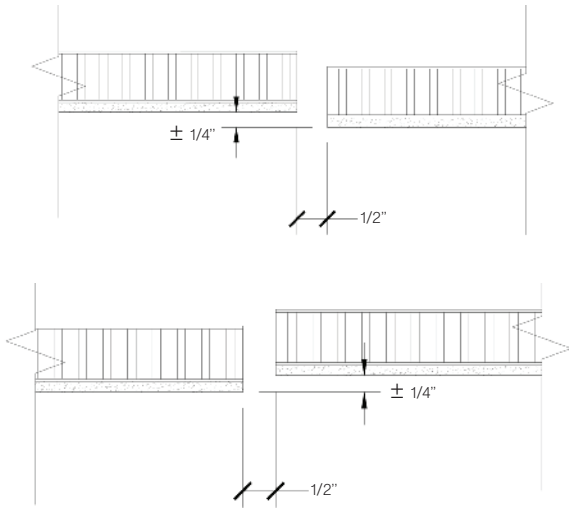
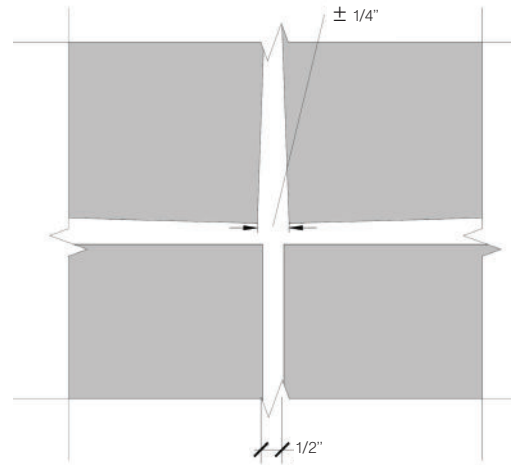


Figure 10

2.12 Tolerances in installation of Cladify panels- Joint consistency

For the joint between the panel at 1500 mm and more: $\pm 1/4"$



2.11 Tolerances in installation of Cladify panels- Horizontal and Vertical joints.

For panel alignment: Horizontal joint to Vertical joint - Max $\pm 1/4"$

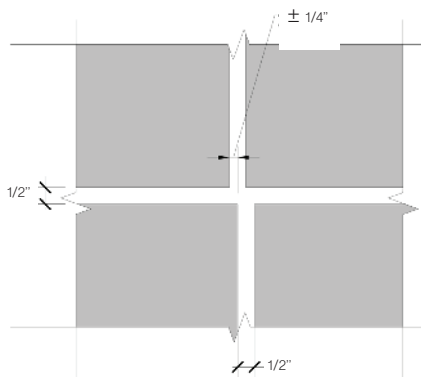
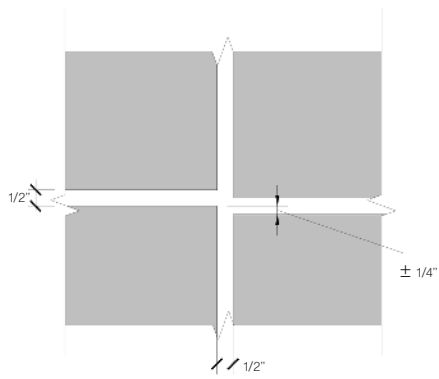


Figure 11

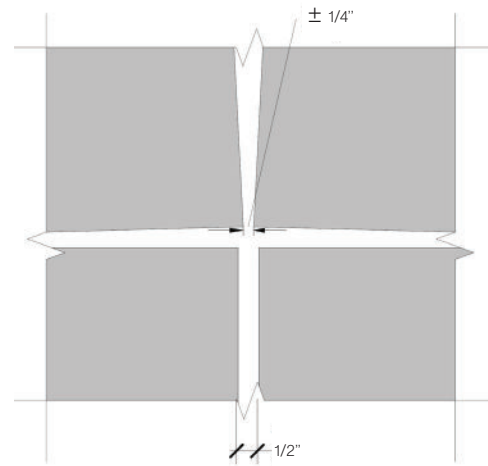
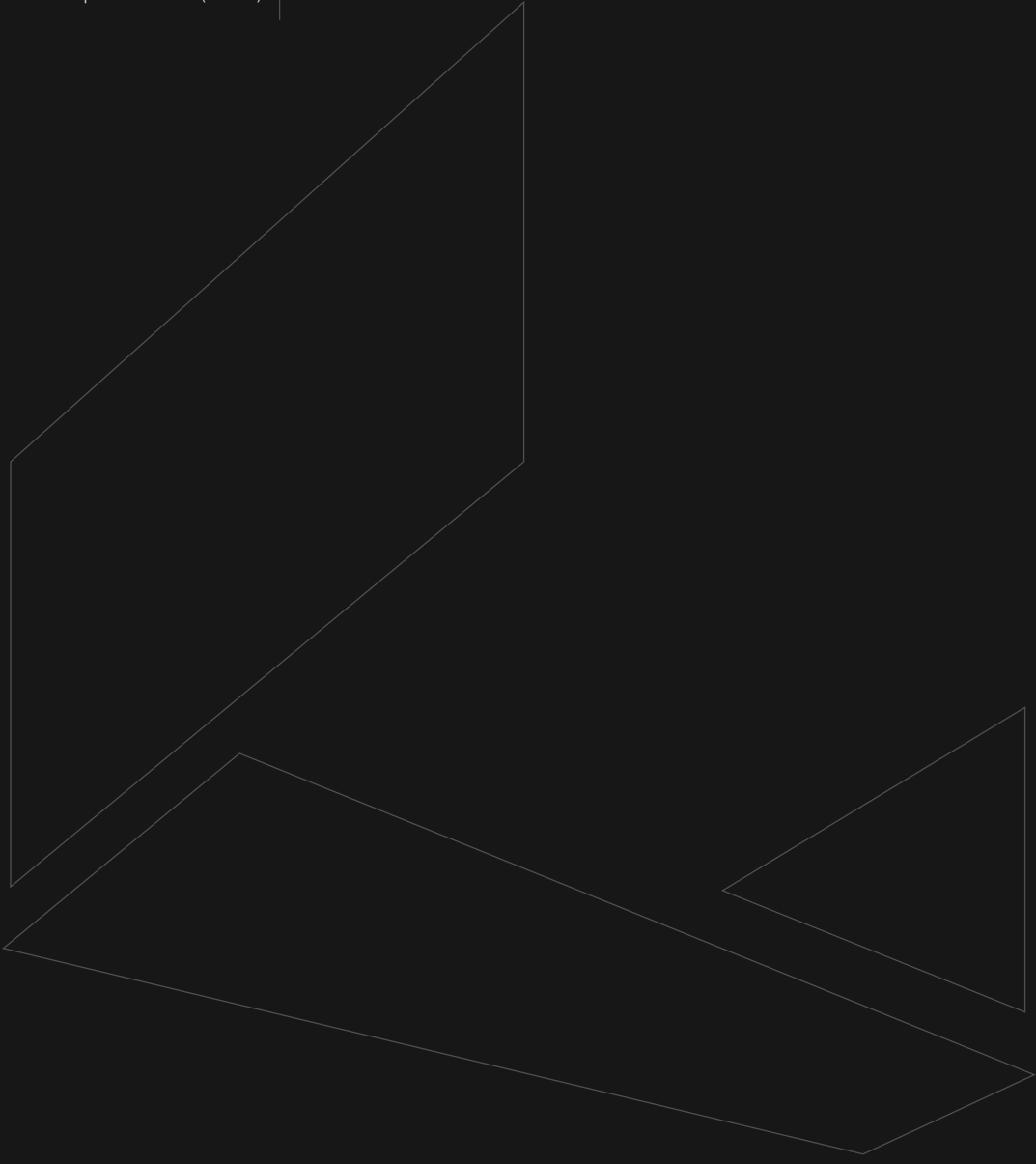


Figure 12



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