

WWW.ISTA COVER.JR  
 MODERN ARCHITECTURE  
 MODERN MATERIAL

LUXURY  
 COVER

..... PROCESS .....

<ul style="list-style-type: none"> <li>- Sawing with vertical panel saw circular or jig saw</li> <li>- Cutting with guillotine shears cushion clamp</li> <li>- Digital Printing</li> <li>- Bending with folding machine/ bending press</li> <li>- Rolling bending with roll bending machines make sure to use ground rolls</li> <li>- Folding manually after cutting a V-groove using a panel saw with routing device, a CNC machining center or a panel routing machine</li> </ul>	<p>Cutting to Shape      Joining</p> <p style="text-align: center;">Shaping</p>	<ul style="list-style-type: none"> <li>- Sawing with vertical panel saw circular or jig saw</li> <li>- Cutting with guillotine shears cushion clamp</li> <li>- Photo Mounting</li> <li>- Bending with folding machine/ bending press</li> <li>- Rolling bending with roll bending machines make sure to use ground rolls</li> <li>- Folding manually after cutting a V-groove using a panel saw with routing device, a CNC machining center or a panel routing machine</li> </ul>
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EXAMPLE OF STRUT COVERING



Cover (1) Panel Saw (2) Jig Saw (3)



Routing for cover by means of a CNC machining center (1) Panel Saw (2)

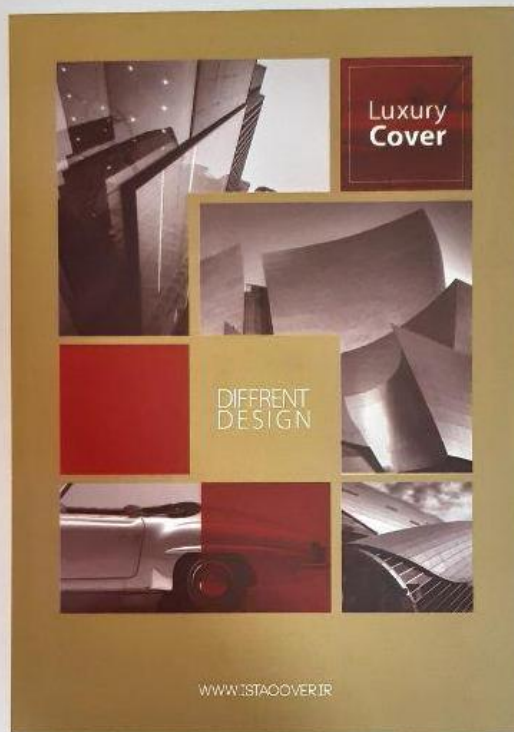


Cover (1) Panel Saw (2) Jig Saw (3)

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..... PVDF COATING FINISH .....

PVDF COATING OF have been highly evaluated through the following test's :

Hardness	ASTM D-3363-74 (NCAA II-12)
Flexibility: T-Bend	ASTM D-4145-83 (NCAA II-19)
Adhesion	ASTM D-4145-87 (NCAA II-5)
Abrasion: Falling Sand	ASTM D-968-81
Mortar Resistance	AAMA 606.2-91, TEST #7.7.2
Detergent Resistance	ASTM D-2248-73 (ECCA T5)
Acid Pollutants	ASTM D-1388-87
	AAMA 606.2-90, TEST #7.7.3.1
Alkali Resistance	ASTM D-1388-87
Salt Fog	ASTM B-117-85 (NCAA II-2)
Humidity	ASTM D-2247-87 D-714-87
Color Retention	ASTM D-2244-85, D-2244-88
Chalk Resistance	ASTM D-669-86, D4214-89
ASTM: American Society for Testing and Materials	NCAA: National Coil Coaters Association
AAMA: American Architectural Manufacturers Association	ECCA: European Coil Coating Association

..... PANEL PROPERTIES .....

PROPERTY	Unit	(4m)
GRAVITY	/	1.38
WEIGHT	Kg/m <sup>2</sup>	5.5
THERMAL TRANSMITTANCE	Kcal/m <sup>2</sup> hr. c	1.102
DEFLECTION TEMPERATURE	c	115
LINEAR EXPANSION	10 <sup>-6</sup> /c	24
TENSILE STRENGTH	Kg/mm <sup>2</sup>	8.5
ELONGATION	%	27
BENDING STRENGTH	Kg/cm <sup>2</sup>	1.344
BENDING MOMENT	Kg/cm <sup>2</sup>	537
ADHESIVE STRENGTH	Kg/in	18
BENDING ELASTIC MODULUS	Kg/mm <sup>2</sup>	3.746

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