



BUILDING

PRODUCT OVERVIEW



STADUR
MADE IN GERMANY

About us



MADE IN GERMANY



Since 1982, STADUR has been developing countless applications based on the fundamental concept of the sandwich panel and is now one of Europe's largest and most innovative manufacturers of composite elements. We offer a wide range of high-quality products and customized solutions.

At our head office in 21714 Hammah, we offer a personalised and efficient service to meet the specific needs of each individual customer. Our dedicated team of 120 employees is here to assist you with any requests you might have.

Business Divisions



BUILDING

Sandwich panels for windows, doors and walls



BATHROOM

Shower units for sanitary facilities and wellness areas



ADVERTISING

Printable lightweight foam boards



TECHNICS

Sandwich panels for vehicles and industrial applications

Brief overview

- Founded: 1982 by Wolfgang Sylvester
- Production area: 20,000 m²
- Employees: >120
- Turnover in 2025: ~ 30 million (Exports account for >60%)
- Customers in over 80 Countries
- Modern production facilities

Subsidiaries

- Stadur Composite, Karstädt Plastic extrusion
- Stadur Dämmstoff, Stade Insulation materials trade
- Stadur Süd, Pliezhausen Sandwich panels

Contact

Phone: +49 41 44 / 234 0

E-mail: bau@stadur.com

Or use our contact form:

www.stadur.com/en/contact/

Your benefits

Sandwich panels



Lightweight

Easy to handle



UV-resistant

For outdoor use



Flexible design

Adapted to any structure and thickness



High stability

Dynamic resistance



Thermal insulation

Reliable and durable



Sound insulation

dB reduction

STADUR



Certified

STADUR is certified to DIN EN ISO 9001



Stadurlon – 100% PVC-free

100% recyclable

Made from 77% recycled materials



No Waste

Waste prevention and the minimisation of material losses are an integral part of our company policy

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General information

Cover sheets	Stadurlon, PVC, Laminate, Aluminium, GRP, Self-adhesive film	34
Core material	Various XPS, EPS and PUR foam cores, mineral wool	35
Groove geometry	Concerning: FB-1/SLN, FB-3/DN, FB-4/DN	36
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Sandwich panels with plastics





FB-1/SL

Sandwich panel with cover sheets of Stadurlon

Structure

	Stadurlon - 1.0 / 1.3 / 1.5 / 2.0 mm
	XPS - λ D 0.033
	Stadurlon - 1.0 / 1.3 / 1.5 / 2.0 mm

Formats

2000 x 1000 mm / 2150 x 950 mm
3050 x 1300 mm / 3000 x 1500 mm
3000 x 2000 mm / 4000 x 2000 mm

Other formats and standard sizes are available on request.

Notes

- Listed in the DGNB Navigator. Code: **XM14OL**
- AVIS TECHNIQUE n°06/16-2346
- Royal Edition with non-grooved foam
- Fall protection tested in accordance with DIN 18008-4:2013-07, NF-P 08-301 & P 08-302
- Various sizes in stock. Please contact us.

Properties



Very good thermal insulation



Easy processing



PVC-free



5 years UV warranty



Fall protection certified: see notes



Sound insulation



Suitable for painting



Various colours available



Impact-resistant



Specifications

Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
20 mm	1.3 / 1.5 mm	1.45	0.52	3.68
24 mm	1.3 / 1.5 mm	1.23	0.64	3.80
28 mm	1.3 / 1.5 mm	1.07	0.76	3.94
32 mm	1.3 / 1.5 mm	0.95	0.88	4.08
36 mm	1.3 / 1.5 mm	0.85	1.01	4.21
40 mm	1.3 / 1.5 mm	0.77	1.13	4.34
44 mm	1.3 / 1.5 mm	0.71	1.25	4.47
48 mm	1.3 / 1.5 mm	0.65	1.37	4.60

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ROYAL EDITION STADUR

MADE IN GERMANY



trimmed
all round



non-grooved
foam



short delivery
times



high-quality
finish

Stock formats:

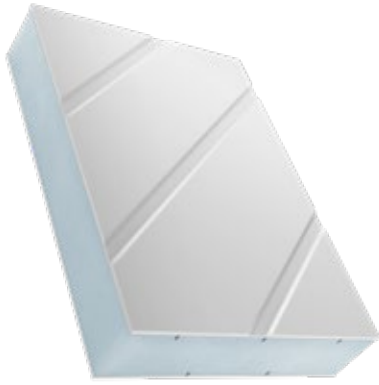
3000 x 1500 mm

3000 x 2000 mm

Stock thicknesses:

24, 28, 36, 40, 48 mm

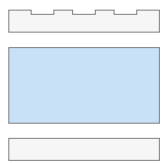




FB-1/SLN

Sandwich panel with cover sheets of Stadurlon grooved

Structure



Stadurlon - 2.0 mm

XPS - λ_D 0.033

Stadurlon - 2.0 mm

Properties



Very good thermal insulation



Easy processing



PVC-free



5 years UV warranty



Fall protection certified: see notes



Impact-resistant

Formats

2000 x 1000 mm

Other formats and standard sizes are available on request.

Notes



Suitable for painting

- Groove width 10 mm / Groove spacing 100 mm
- Softline grooving
- See 'Groove Geometry' data sheet
- Fall protection tested in accordance with DIN 18008-4:2013-07, NF-P 08-301 & P 08-302



Specifications

Total thickness	Cover sheets	U-value (λ_D 0.033)	R-value (λ_D 0.033)	Weight (kg/m ²)
20 mm	2.0 mm	1.45	0.52	3.68
24 mm	2.0 mm	1.23	0.64	3.80
28 mm	2.0 mm	1.07	0.76	3.94
32 mm	2.0 mm	0.95	0.88	4.08
36 mm	2.0 mm	0.85	1.01	4.21
40 mm	2.0 mm	0.77	1.13	4.34
44 mm	2.0 mm	0.71	1.25	4.47
48 mm	2.0 mm	0.65	1.37	4.60

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FB-1/PVC

Sandwich panel with cover sheets of PVC

Structure

	PVC 640 matt - 1.3 mm
	XPS - λ D 0.033
	PVC 640 matt - 1.3 mm

Formats

3000 x 1500 mm

Other formats and standard sizes are available on request.

Properties



Very good thermal insulation



Easy processing



UV-resistant



Impact-resistant



Fire protection **M2**
tested in accordance with
NF P 92-507 : 2004



Sound insulation

Notes

- AVIS TECHNIQUE n°06/16-2346



Specifications

Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
20 mm	1.3 mm	1.45	0.52	3.68
24 mm	1.3 mm	1.23	0.64	3.80
28 mm	1.3 mm	1.07	0.76	3.94
32 mm	1.3 mm	0.95	0.88	4.08
36 mm	1.3 mm	0.85	1.01	4.21
40 mm	1.3 mm	0.77	1.13	4.34
44 mm	1.3 mm	0.71	1.25	4.47
48 mm	1.3 mm	0.65	1.37	4.60

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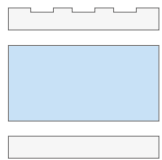
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Fax +49 (0) 41 44 / 234-100



FB-1/EXN

Sandwich panel with cover sheets of PVC with an extruded groove

Structure



PVC 640 matt - 2.2

XPS - λ D 0.033

PVC 640 matt - 1.3 / 2.2 mm

Properties



Very good thermal insulation



Easy processing



UV-resistant



Impact-resistant

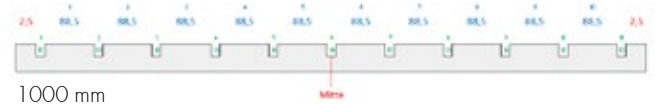
Formats

2100 x 1000 mm / 3000 x 1500 mm

Other formats and standard sizes are available on request.

Notes

- Groove width 10 mm / Groove spacing 88.5 mm
- 1000 mm width = 11 grooves
1500 mm width = 15 grooves
- Grooves can only be cut vertically.



Specifications

Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
24 mm	2.2 / 1.3 mm	1.23	0.61	4.58
28 mm	2.2 / 1.3 mm	1.07	0.74	4.71
32 mm	2.2 / 1.3 mm	0.96	0.86	4.84
36 mm	2.2 / 1.3 mm	0.86	0.99	4.98
24 mm	2.2 / 2.2 mm	1.28	0.61	5.14
28 mm	2.2 / 2.2 mm	1.11	0.73	5.27
32 mm	2.2 / 2.2 mm	0.97	0.85	5.40
36 mm	2.2 / 2.2 mm	0.87	0.98	5.54

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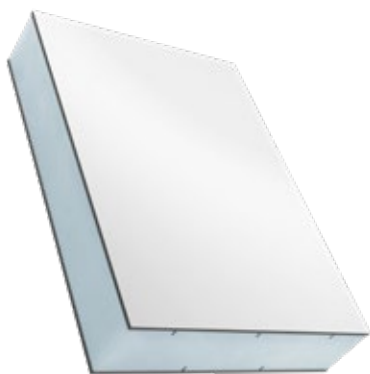
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Sandwich panels with laminate





FB-2

Sandwich panel with cover sheets of laminate

Structure



Properties



Very good thermal insulation



Easy processing



Impact-resistant

Formats

2200 x 1000 mm / 3050 x 1300 mm
4200 x 1610 mm

Other formats and standard sizes are available on request.

Notes

- AVIS TECHNIQUE n°06/16-2346



Specifications

Total thickness	Cover sheets	U-value (λD 0.033)	R-value (λD 0.033)	Weight (kg/m ²)
24 mm	2.0 mm	1.27	0.62	6.38
28 mm	2.0 mm	1.1	0.74	6.5
32 mm	2.0 mm	0.97	0.86	6.63
36 mm	2.0 mm	0.87	0.98	6.77
40 mm	2.0 mm	0.79	1.1	6.9
44 mm	2.0 mm	0.72	1.23	7.02
48 mm	2.0 mm	0.66	1.35	7.14



Sandwich panels with decorative film





FB-3/SL

Sandwich panel with decorative film and cover sheets of Stadurlon

Structure



Stadurlon - 1.5 mm with decorative film

XPS - λ D 0.033

Stadurlon - 1.5 mm with decorative film

Formats

2150 x 950 mm

3050 x 1300 mm

Other formats and standard sizes are available on request.

Notes

- AVIS TECHNIQUE n°06/16-2346
- An overview of the range of finishes is available on request
- Fall protection tested in accordance with DIN 18008-4:2013-07, NF-P 08-301 & P 08-302

Properties



Very good thermal insulation



Easy processing



Various colours available



UV-resistant



Sound insulation



Impact-resistant



Fall protection certified: see notes



Specifications

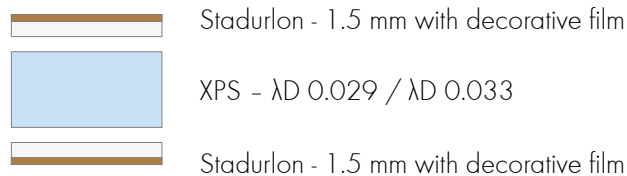
Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
24 mm	1.5 mm	1.23	0.64	4.33
28 mm	1.5 mm	1.07	0.76	4.46
32 mm	1.5 mm	0.95	0.88	4.6
36 mm	1.5 mm	0.85	1.01	4.72
40 mm	1.5 mm	0.77	1.13	4.85
44 mm	1.5 mm	0.71	1.25	4.98
48 mm	1.5 mm	0.65	1.37	5.11

FB-3

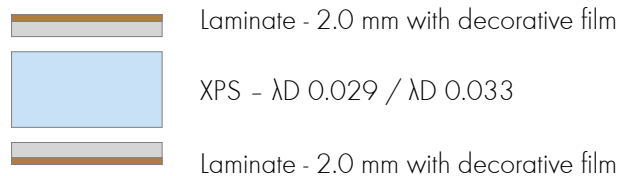
Cover sheets and decorative films

Stadur FB-3 sandwich panels with decorative film are available with the following cover sheets:

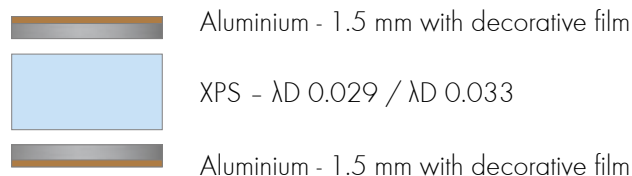
Stadurlon



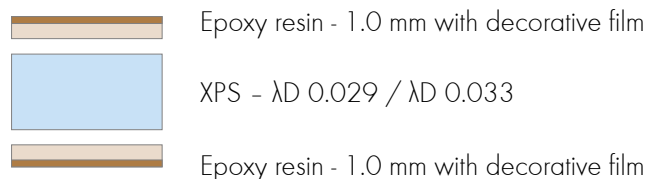
Laminate



Aluminium



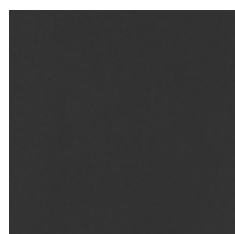
Epoxy resin



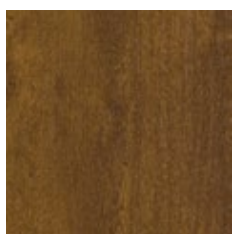
The top layers can be combined as desired; for example, a white Stadurlon backing.

Decorative films

The reproduction of colours and finishes is subject to the limitations of the printing process. If you require a more accurate representation of colours and finishes, we recommend requesting a sample.



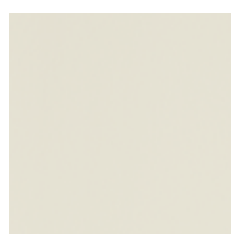
436-1014
Alux DB 703



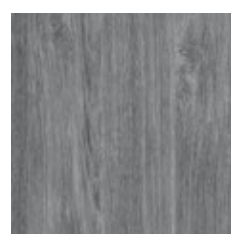
436-2076
Colonial Oak



436-7047
Quartz Grey SFTN



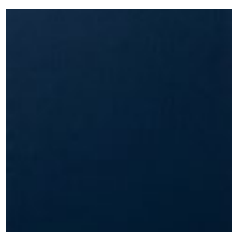
456-5054
Cream



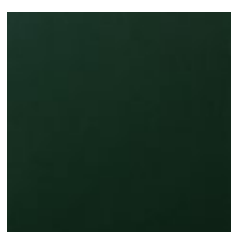
470-3003
Sheffield Oak
Concrete



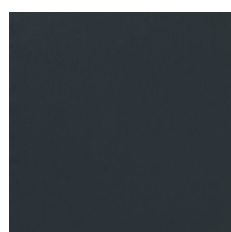
3081.005-167
Dark red



5150.005-167
Steel blue



6125.005-167
Dark green



7016.005-167
Anthracite grey



7251.005-167
Light grey

These are just a few examples of some of our most popular designs.

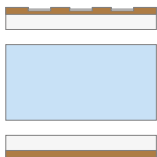
A complete, up-to-date list with design numbers is available on request: bau@stadur.com



FB-3/DN

Sandwich panel with decorative film grooved and cover sheets of laminate/aluminium

Structure



Laminate - 2.0 mm / Aluminium - 1.5 mm
with decorative film grooved

XPS - λ D 0.033

Laminate - 2.0 mm / Aluminium - 1.5 mm
with decorative film

Properties



Very good
thermal insulation



Easy
processing



Various colours
available



UV-resistant



Impact-resistant

Formats

Laminate: 2150 x 950 mm

Aluminium: 2000 x 1000 mm

Other formats and standard sizes are available on request.

Notes

- An overview of the range of finishes is available on request
- Groove width 10 mm / Groove spacing 100 mm
- See the 'Groove Geometry' data sheet

Specifications

Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
24 mm	2.0 mm HPL	1.27	0.62	6.57
28 mm	2.0 mm HPL	1.1	0.74	6.69
32 mm	2.0 mm HPL	0.97	0.86	6.82
24 mm	1.5 mm ALU	1.24	0.64	9.25
28 mm	1.5 mm ALU	1.08	0.74	9.34
32 mm	1.5 mm ALU	0.95	0.86	9.48



Sandwich panels with Aluminium





FB-4

Sandwich panel with cover sheets of Aluminium

Structure

	Aluminium - 0.8 / 1.0 / 1.5 / 2.0 mm
	XPS - λ D 0.033
	Aluminium - 0.8 / 1.0 / 1.5 / 2.0 mm

Formats

2000 x 1000 mm / 2500 x 1250 mm
3000 x 1500 mm

Other formats and standard sizes are available on request.

Properties



Very good thermal insulation



Easy processing



Fire protection **M1**
tested in accordance with
NF P 92-507 : 2004



Sound insulation



Suitable for painting



Various colours available

Notes

- AVIS TECHNIQUE n°06/16-2346
- Available in almost all standard RAL, Tiger and NSC colours
- Various degrees of gloss / fine textures available
- For sound insulation tests, see 'Phon'
- Fall protection tested in accordance with
DIN 18008-4:2013-07, NF-P 08-301 & P 08-302

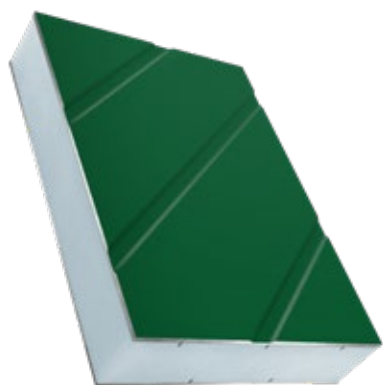


Fall protection
certified: see notes



Specifications

Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
20 mm	0.8 mm	1.4	0.55	4.91
24 mm	0.8 mm	1.2	0.67	5.04
28 mm	0.8 mm	1.04	0.79	5.18
32 mm	0.8 mm	0.93	0.91	5.31
36 mm	0.8 mm	0.83	1.03	5.44
40 mm	0.8 mm	0.79	1.09	5.57
44 mm	0.8 mm	0.69	1.27	5.71



FB-4/DN

Sandwich panel with cover sheets
of Aluminium grooved

Structure



Aluminium - 1.5 mm with Softline grooving

XPS - λD 0.033

Aluminium - 1.5 mm smooth

Properties



Very good
thermal insulation



Easy
processing



UV-resistant



Impact-resistant

Formats

Sizes on request.



Various colours
available

Notes

- Available in almost all standard RAL, Tiger and NSC colours
- Groove width 10 mm / Groove spacing 100 mm
- See the 'Groove Geometry' data sheet

Specifications

Total thickness	Cover sheets	U-value (λD 0.033)	R-value (λD 0.033)	Weight (kg/m ²)
24 mm	1.5 mm	1.19	0.67	9.25
28 mm	1.5 mm	1.04	0.79	9.34
32 mm	1.5 mm	0.93	0.91	9.48
36 mm	1.5 mm	0.86	1	9.61
40 mm	1.5 mm	0.77	1.12	9.74
44 mm	1.5 mm	0.71	1.24	9.86
48 mm	1.5 mm	0.65	1.36	9.99



Stadur Top

Sandwich panel with cover sheets of Aluminium with folded edges

Structure



Aluminium - 0.72 mm folded edge

XPS - λ D 0.033

Aluminium - 0.72 mm folded edge
Alternatively Stadurlon cover sheet is available

Formats

Width: 1200 mm

Length: 3000 mm / 3500 mm / 4000 mm / 4500 mm
5000 mm / 6000 mm / 7000 mm / 7500 mm

Other formats and standard sizes are available on request.

Properties



Very good thermal insulation



Easy processing



Fire protection



Structural sound insulation
Tested in accordance with
DIN EN ISO 140-18



Various colours available

Colours in stock:

RAL 7024 / 9010 / 8004, Zinc, red patterned

Notes

- The NP-6135 aluminium connecting profile is available in lengths of 7,500 mm and 4,500 mm
- With optional PHON sound-absorbing insert

Specifications

Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)	dB value*
16 mm	Top	1.60	0.45	4.88	-
32 mm	Top	0.90	0.94	5.41	64.3
52 mm	Top	0.58	1.55	6.07	67

See the Top Catalogue for additional variants and information



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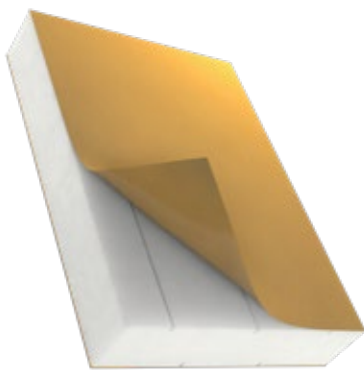
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Sandwich panels for special applications

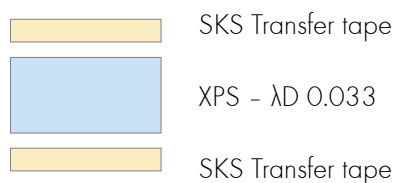




SKS

Sandwich panel with
self-adhesive film on both sides

Structure



Properties



Very good
thermal insulation



Easy
processing



Sound insulation
Tested at 36 mm with 32 dB

Formats

2000 x 1000 mm / 2200 x 1000 mm
3000 x 1000 mm / 3000 x 1500 mm

Other formats and standard sizes are available on request.

Notes

- Solvent-free, environmentally friendly transfer adhesive tape based on acrylic dispersion
- The adhesive has excellent initial tack and is resistant to ageing and UV light
- Please be sure to follow our separate processing recommendations
- Available with various cover sheets on one side, such as Stadurlon
- Various versions available from stock

Specifications

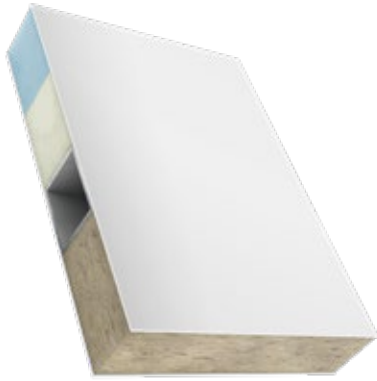
Total thickness	U-value (λD 0.033)	R-value (λD 0.033)	Weight (kg/m²)
18 mm	1.4	0.55	0.91
20 mm	1.29	0.61	0.98
21 mm	1.24	0.64	1.01
25 mm	1.08	0.76	1.15
30 mm	0.93	0.91	1.31
33 mm	0.85	1	1.41
40 mm	0.72	1.21	1.64
50 mm	0.59	1.52	1.97

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FB-GFK

Sandwich panel with cover sheets
of Glass-fibre-reinforced plastic

Structure

	GRP - 1.3 / 1.5 / 1.8 mm
	XPS - λ D 0.033 Optional inserts / reinforcements
	GRP - 1.3 / 1.5 / 1.8 mm

Properties



Very good
thermal insulation



Easy
processing



UV-resistant



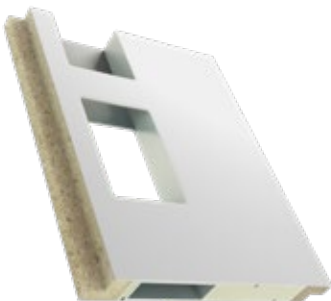
Impact-resistant

Formats

Any size up to 14,000 x 3,150 x 100

Length and width tolerances as a function of length
up to 3000 mm $\pm$ 2 mm, up to 5000 mm $\pm$ 4 mm,
up to 8000 mm $\pm$ 6 mm, up to 14000 mm $\pm$ 10 mm

Security inserts / reinforcements / CNC machining



STADUR custom solutions can be fitted with inserts and/or reinforcements for load-bearing purposes or bolting, for example.

We can also carry out cut-outs and milled recesses on our CNC machining centre up to dimensions of 14,000 x 3,150 x 100 mm. Edge finishing of the foam core in the form of a stepped rebate or tongue-and-groove joint is also possible.

Please note that inserts and reinforcements have different tolerance ranges to the foam core, meaning that marks on the surface cannot be ruled out.



Fapatec

Sandwich panel with cover sheets
of Single-pane/laminated safety glass

Structure



Safety glass - 4 / 6 / 8 / 10 mm

XPS - λ D 0.033

Stadurlon/PVC/Alu - 1.5 / 2.0 mm

Properties



Very good
thermal insulation



Various colours
available

Formats

Standard formats by arrangement

Notes

A wide range of heavy-metal-free enamel paints is available, in accordance with the RAL/NCS standard colour chart.

The total thickness can be freely selected in increments of one millimetre from 14 to 120 mm, depending on individual requirements.

The standard thickness tolerance is ± 0.7 mm.

Technical specifications depend on the materials used.



**Protection Line
for more demanding requirements**

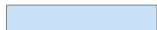




Protec

Sandwich panel with insert
for enhanced burglary protection

Structure

	Aluminium / Stadurlon 1.5 mm
	XPS - λ D 0.033
	Aluminium 1.5 / 2.0 / 3.0 mm
	XPS - λ D 0.029 / λ D 0.033
	Aluminium / Stadurlon 1.5 mm

Notes

- AVIS TECHNIQUE n°06/16-2346

Properties



Burglary protection
Tested in accordance with DIN EN 1630:2021-11



Impact-resistant



Sound insulation



Various colours
available



Specifications FB-1/SL

FB-1/SL Protec

Feature	1,5 mm insert	2,0 mm insert	3,0 mm insert
Total thickness	36 mm		
Standard sizes	2000 x 1000 mm / 3000 x 1500 mm 2000 x 950 mm (decor) / 3000 x 1300 mm (decor)		
Puncture resistance	x	x	RC2
Tear resistance	RC2	RC3	RC3
Weight in kg/m ²	9.60	11.00	13.80
U-value	0.89	0.90	0.92
Tested in accordance with	DIN EN 1630:2021-11, Annex F (adapted)		

Specifications FB-4

FB-4 Protec

Feature	1,5 mm insert	2,0 mm insert	3,0 mm insert
Total thickness	36 mm		
Standard sizes	2000 x 1000 mm / 3000 x 1500 mm 2000 x 1000 mm (decor) / 3000 x 1300 mm (decor)		
Puncture resistance	x	not tested	RC2
Tear resistance	RC2	not tested	RC3
Weight in kg/m ²	9.60	11.00	13.80
U-value	0.89	0.90	0.92
Tested in accordance with	DIN EN 1630:2021-11, Annex F (adapted)		

The systems we have tested provide reliable protection against attempts to pierce or reach through them. The specified RC classes are based on partial tests in accordance with **DIN EN 1630:2021-11, Annex F**, and clearly indicate the security level of our products.

However, a complete classification in accordance with DIN EN 1627 requires the entire system to be tested. Nevertheless, our partial tests provide valuable safety information, **independent of the overall system**.

Classes according to DIN

DIN standards

Manual tests – Attempted break-ins (DIN EN 1630:2021-11)

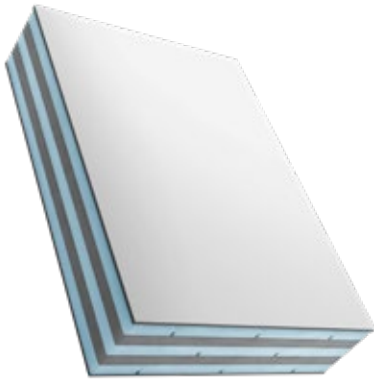
Class (DIN EN 1627:2011)	Old class (DIN EN V 1627:1999)	Glass class (DIN EN 356)	Tool set	Contact time	Total test time
RC1	WK1	-	Small, simple tools, physical strength	-	-
RC2	WK2	P4A	As above + screwdrivers, pliers, wooden and plastic wedges, saws	3 Min	15 Min
RC3	WK3	P5A	As above, plus additional screwdrivers, a crowbar, a small hammer, a hand-held drill and a split pin driver	5 Min	20 Min
RC4	WK4	P6B	As above, plus a heavy hammer, an axe, a chisel, metal shears, bolt cutters, chisels and a hand-held drill	10 Min	30 Min
RC5	WK5	P7B	As above + drill, jigsaw, reciprocating saw, angle grinder	15 Min	40 Min
RC6	WK6	P8B	As above + ground, steel wedge, grinding wheel, hammer	20 Min	50 Min

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Phon

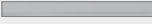
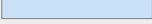
Sandwich panel with inserts
for enhanced sound insulation

Structures tested in accordance with ISO 717-1:2013; 10140-2:2010

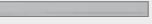
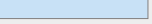
Cover sheet Stadurlon

also valid with a decorative finish

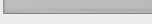
Phon 34

	Stadurlon 1.5 mm	36 mm	Thickness
	XPS 13.5 mm		
	Special insert 6.0 mm	34	dB
	XPS 13.5 mm		
	Stadurlon 1.5 mm	0.99	U-value

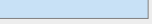
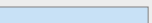
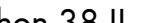
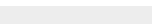
Phon 35

	Stadurlon 2.0 mm	36 mm	Thickness
	XPS 14.0 mm		
	Special insert 4.0 mm	35	dB
	XPS 14.0 mm		
	Stadurlon 2.0 mm	0.97	U-value

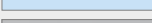
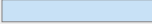
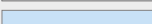
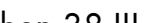
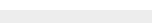
Phon 36 I

	Stadurlon 2.0 mm	36 mm	Thickness
	XPS 13.0 mm		
	Special insert 6.0 mm	36	dB
	XPS 13.0 mm		
	Stadurlon 2.0 mm	1.03	U-value

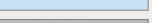
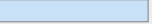
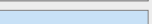
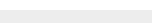
Phon 36 II

	Stadurlon 1.5 mm	36 mm	Thickness
	XPS 8.5 mm		
	Special insert 4.0 mm	36	dB
	XPS 8.0 mm		
	Special insert 4.0 mm		
	XPS 8.5 mm		
	Stadurlon 1.5 mm	1.05	U-value

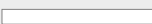
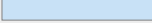
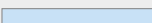
Phon 38 I

	Stadurlon 2.0 mm	36 mm	Thickness
	XPS 8.0 mm		
	Special insert 4.0 mm	38	dB
	XPS 8.0 mm		
	Special insert 4.0 mm		
	XPS 8.0 mm		
	Stadurlon 2.0 mm	1.09	U-value

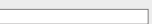
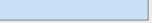
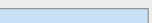
Phon 38 II

	Stadurlon 2.0 mm	48 mm	Thickness
	XPS 12.0 mm		
	Special insert 4.0 mm	38	dB
	XPS 12.0 mm		
	Special insert 4.0 mm		
	XPS 12.0 mm		
	Stadurlon 2.0 mm	0.78	U-value

Phon 38 III

	Stadurlon 2.0 mm	38 mm	Thickness
	XPS 8.0 mm		
	Special insert 6.0 mm	38	dB
	XPS 8.0 mm		
	Special insert 4.0 mm		
	XPS 8.0 mm		
	Stadurlon 2.0 mm	1.08	U-value

Phon 40

	Stadurlon 1.5 mm	39 mm	Thickness
	XPS 8.0 mm		
	Special insert 8.0 mm	40	dB
	XPS 8.0 mm		
	Special insert 4.0 mm		
	XPS 8.0 mm		
	Stadurlon 1.5 mm	0.80	U-value

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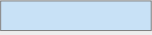
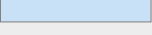
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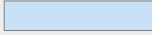
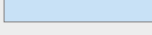
Structures tested in accordance with 717-1:2013; 10140-2:2010

Cover sheet PVC

Phon 29

	PVC 1.3 mm	24 mm	Thickness
	XPS 9.2 mm		
	Special insert 3.0 mm	29	dB
	XPS 9.2 mm		
	PVC 1.3 mm	1.30	U-value

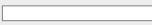
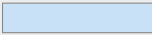
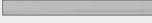
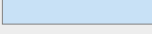
Phon 33

	PVC 1.3 mm	24 mm	Thickness
	XPS 8.7 mm		
	Special insert 4.0 mm	33	dB
	XPS 8.7 mm		
	PVC 1.3 mm	1.39	U-value

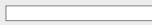
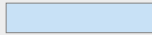
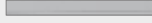
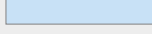
Cover sheet Aluminium

also valid with a decorative finish

Phon 33

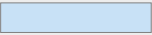
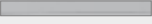
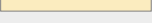
	Aluminium 0.8 mm	28 mm	Thickness
	XPS 11.2 mm		
	Special insert 4.0 mm	33	dB
	XPS 11.2 mm		
	Aluminium 0.8 mm	1.16	U-value

Phon 36

	Aluminium 1.5 mm	36 mm	Thickness
	XPS 13.5 mm		
	Special insert 6.0 mm	35	dB
	XPS 13.5 mm		
	Aluminium 1.5 mm	1.00	U-value

SKS

Phon 32

	SKS-Film	36 mm	Thickness
	XPS 15.0 mm		
	Special insert 6.0 mm	32	dB
	XPS 15.0 mm		
	SKS-Film	0.92	U-value

Tested components without special insert

also valid with a decorative finish

Product	Cover Sheet	Thickness	DB value	U-value
FB-1/SL	1.5 mm Stadurlon	24 mm	21	1.23
FB-1/SL	1.5 mm Stadurlon	28 mm	22	1.07
FB-1/SL	1.5 mm Stadurlon	36 mm	22	0.85
FB-1/SL	1.5 mm Stadurlon	48 mm	20	0.65
FB-1/SL Protec	2.0 mm Stadurlon	36 mm	31	0.92
FB-4	1.5 mm Aluminium	24 mm	29	1.24
FB-4	1.5 mm Aluminium	28 mm	29	1.08
FB-4	1.5 mm Aluminium	36 mm	29	0.86
FB-4	1.5 mm Aluminium	48 mm	27	0.62
FB-4	0.8 mm Aluminium	28 mm	25	1.02

Further configurations / options available on request

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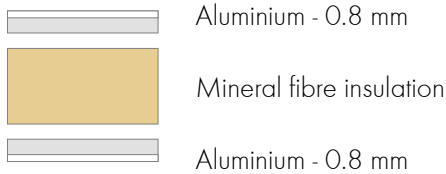
Phone +49 (0) 41 44 / 234-0
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Pyro/A2

Fire protection element with cover sheets of Aluminium

Structure



Properties



Very good thermal insulation



Easy processing



Various colours available



Sound insulation

Formats

3000 x 1500 mm

Other formats and standard sizes are available on request.



Suitable for painting

Notes

- LNE-tested: Certificate number P256039
- Available in almost all standard RAL, Tiger & NSC colours
- Various degrees of gloss / fine textures available



Fire protection **A2-S1,d0**

Tested in accordance with NF EN 13501-1:2018

A2: Non-flammable
s1: no/very little smoke
d0: no dripping/sparking

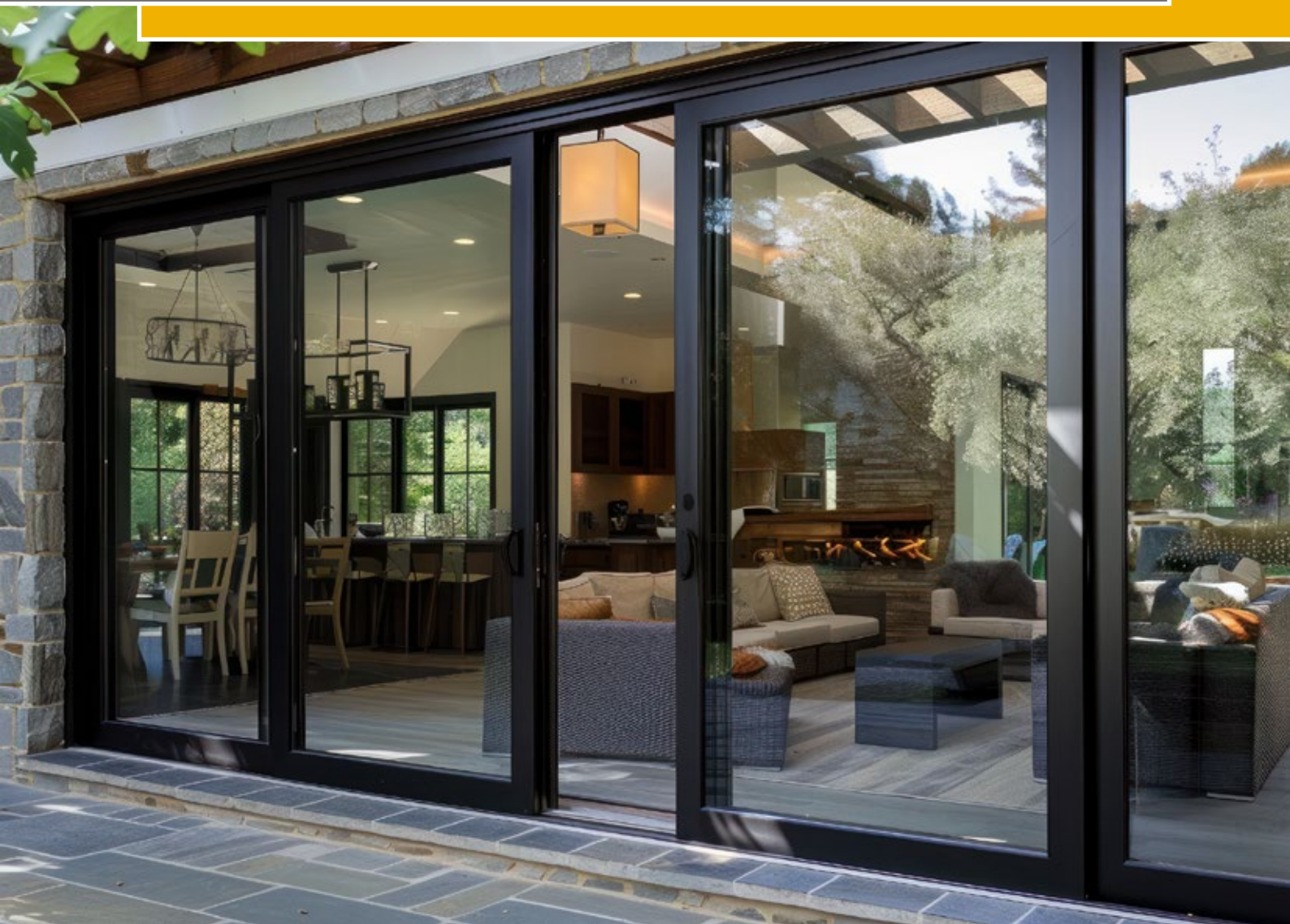
Specifications

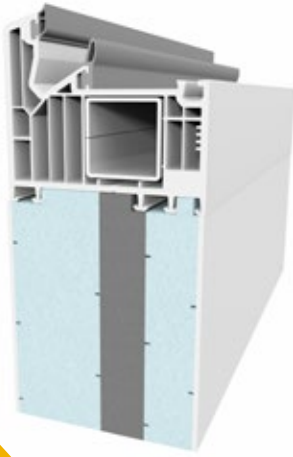
Total thickness	Cover sheets	U-value (λ D 0.033)	R-value (λ D 0.033)	Weight (kg/m ²)
24 mm *	0.8 mm	1.36	0.56	9.33
28 mm	0.8 mm	1.20	0.67	9.99
32 mm	0.8 mm	1.07	0.77	10.65
36 mm *	0.8 mm	0.96	0.87	10.98
40 mm	0.8 mm	0.87	0.97	11.97

* Thicknesses with a minimum order quantity



FrameTec & ProfileTec Frame Extensions





FrameTec

Sandwich panel with a StadurFoam core as window frame extension

Structure

FrameTec sandwich panels consist of a customised combination of:

- 2.0 mm Stadurlon cover sheet
- 12,0 / 19,0 mm StadurFoam screw-in core
- XPS - λ D 0,033
- optional special inserts

Counter-milling on one or both sides, suitable for all system profiles made of PVC, aluminium or timber.

Formats

Thickness: up to 210 mm

Lengths: up to 7,000 mm

Pieces cut to specific dimensions are available in fixed sizes.

Notes

- Listed in the DGNB Navigator. Code: **EL9AZC**
- Cover sheet also available with a decorative finish
- Please refer to our 'FrameTec & ProfileTec' catalogue for full details of this product.

Properties



Very good thermal insulation



Easy processing



Fall protection



5 years UV warranty



Impact-resistant



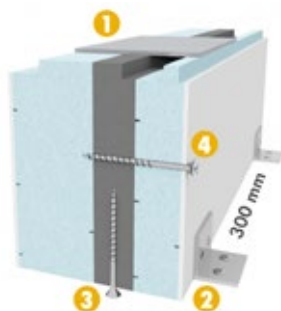
Sound insulation



Various colours available



Specifications



Thickness: mm	Structure: mm	Weight: kg/m ²	U Value: W/m ² K
70	2.0 / 66 / 2.0	17.52	0.488
80	2.0 / 76 / 2.0	17.87	0.417
90	2.0 / 86 / 2.0	18.22	0.365

1. Compressive strength*
2. Bending strength*
3. Extraction force vertical*
4. Extraction force horizontal*

> 1000 kg/m
> 3.1 Mpa
> 3400 N
> 2200 N

Screw: $\varnothing$ 6.0 mm
Screw-in depth: approx. 50 mm
Other thicknesses and finishes available on request
*Laboratory value

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ProfileTec

Sandwich panel with a StadurFoam core as door threshold subbase

Structure

ProfileTec sandwich panels consist of a customised combination of:

- 2.0 mm Stadurlon cover sheet
- 12,0 / 19,0 mm StadurFoam screw-in core
- XPS - λ D 0,033
- optional special inserts

Counter-milling on one or both sides, suitable for all system profiles made of PVC, aluminium or timber.

Formats

Thickness: up to 210 mm

Lengths: up to 7,000 mm

Pieces cut to specific dimensions are available in fixed sizes.

Notes

- Listed in the DGNB Navigator. Code: **EL9AZC**
- Cover sheet also available with a decorative finish
- Please refer to our 'FrameTec & ProfileTec' catalogue for full details of this product.

Properties



Very good thermal insulation



Easy processing



Fall protection



5 years UV warranty



Impact-resistant



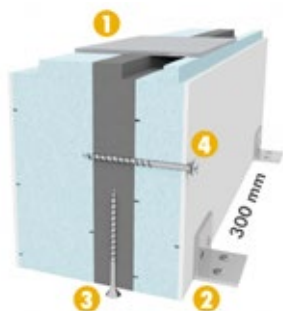
Sound insulation



Various colours available



Specifications



Thickness: mm	Structure: mm	Weight: kg/m ²	U Value: W/m ² K
54	2.0 / 33 / 19	14.50	0.639
67	2.0 / 46 / 19	15.00	0.497

1. Compressive strength* > 1000 kg/lfm
2. Bending strength* > 2.0 Mpa
3. Extraction force vertical* > 3400 N
4. Extraction force horizontal* > 2200 N

Screw: Ø 6.0 mm
Screw-in depth: approx. 50 mm
Other thicknesses and finishes available on request
*Laboratory value

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Cover Sheets

Stadurlon

It is the Stadurlon outer layer that makes STADUR's sandwich panels so special. This high-performance plastic was developed in collaboration with BASF in Ludwigshafen as an alternative to PVC. It is manufactured by Stadur Composite GmbH & Co. KG in Karstädt. This is where Stadurlon is extruded. The thin sheets are then delivered to the production facility in Hammah, where they are bonded together to form the familiar sandwich panels.

- Weather- and moisture-resistant
- Impact-resistant in accordance with DIN EN ISO 179
- Fire behaviour in accordance with DIN 4102, B2
- Bulk density in accordance with ISO 1183: 1.12 g/cm³
- Thermal conductivity = 0.56 W/mK (DIN 52612)
- Bulk density in accordance with SO 1183 (DIN 53479): 1.43 g/cm³

PVC

- Weather- and moisture-resistant
- Impact-resistant
- Flame-retardant in accordance with DIN 4102, class B1
- Bulk density according to SO 1183 (DIN 53479): 1.43 g/cm³
- Thermal conductivity = 0,16 W/mK (DIN 52612)

Laminate

- High impact resistance
- UV-resistant
- Thermal conductivity = 0.25 W/mK
- Bulk density according to ISO 1183: 1.35 g/cm³

Aluminium

- Aluminium Al MG 1, powder-coated, powder-spray-coated or wet-painted
- Thermal conductivity = 200 W/mK
- Bulk density = 2.70 g/cm³
- Fire resistance class A1 = non-combustible

GRP

Glass-fibre-reinforced plastic

- Low weight combined with high mechanical strength
- Resistance to chemicals, corrosion and UV radiation
- Two standard grades: High Gloss with an attractive finish and High Impact with enhanced impact resistance

SKS film

- Solvent-free, environmentally friendly transfer adhesive tape based on acrylate dispersion; release paper, yellow, 90 g/m²
- Excellent initial tack = min. 21 N/25 mm, contact time: 1 hour
- Resistant to ageing and UV light
- Temperature resistance from -40 °C to +90 °C
- Standard adhesive weights: 70 g/m², 100 g/m²

Core Materials

XPS

- Minimal water absorption
- High compressive strength
- Rot-proof and resistant to ageing
- Bulk density of approx. 33 kg/m³
- Fire resistance class E in accordance with DIN EN 13501-1
- Free from PFCs, HCFCs and HBCD
- Thermal conductivity = 0.33 W/mK

PUR

- Bulk density: 30–100 kg/m³
- Water absorption of ≤ 3%
- Achieves excellent insulation performance even at low thicknesses
- Recyclable
- Good dimensional stability within a temperature range of -70 °C to +130 °C

EPS

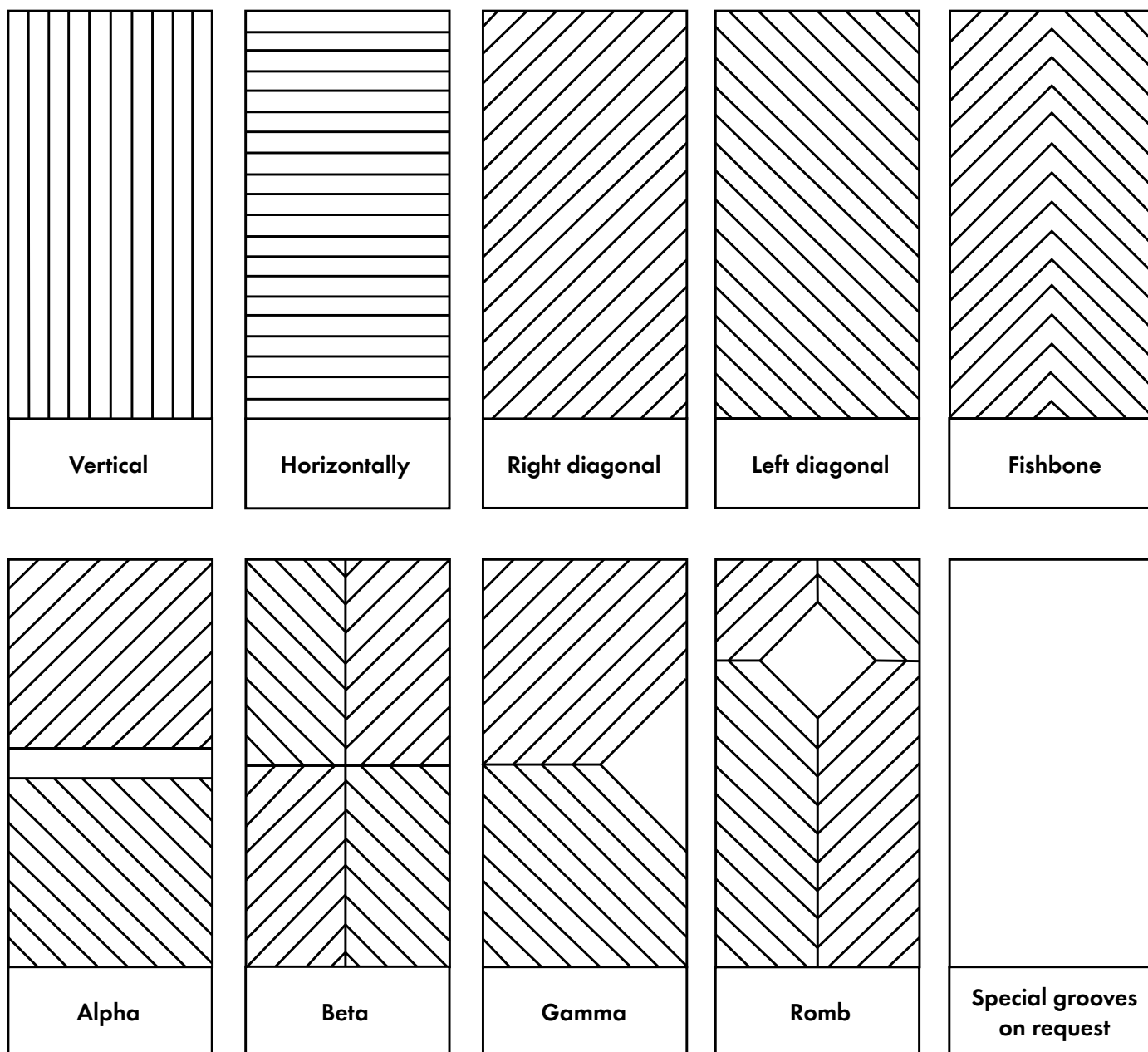
- High-end insulation with integrated infrared absorbers and reflectors to reduce heat transfer to the outside and inside
- Colour: grey
- Thermal conductivity = 0.032 W/mK
- Compressive strength at 10% compression ≥ 150 kPa
- Water absorption ≤ 0.2 kg/m²

Mineral wool

- Increased compressive strength
- Non-combustible A1 (DIN EN 13501-1)
- Thermal conductivity = 0.040 W/mK
- Compressive stress CS (10) ≥ 90 kPa
- Point load PL (5) ≥ 800 N

**Other materials / finishes
available on request**

Groove geometry for FB-1/SLN, FB-3/DN, FB-4/DN



Please note:

For further information, please refer to our leaflet: Installation Instructions.
We reserve the right to make technical changes.

Processing instructions for Sandwich Panels



General

- The core foams are not designed to provide anchorage for screws.
- Rivets may only be used full width and with a counter washer (danger of rivets causing dents/sinking in).
- Never rivet one side only (danger of delaminating), especially when corresponding loads are expected to be placed on the boards.
- Boards cannot be used on vacuum-forming and deep drawing / moulding machinery.
- Boards cannot be folded / bevelled.
- Surfaces can be welded under certain conditions (please consult our Application Technologies Department).
- Boards up to a thickness of approx. 10 mm can be stamped under certain conditions. We draw your attention expressly to the fact that rounding may occur on separation. The foam can be deformed and destroyed at the punching site.
- When installing in wooden profiles, the retaining strips must be screwed down and may not be nailed.
- Rigid installation of the boards must be avoided. A space of 6 – 10 mm from the frame must be kept all round the perimeter. Boards must be installed floating, in an appropriately dimensioned rubber seal or similar such, in order to accommodate expansion.
- The foam has to be protected against UV radiation.
- To prevent frost damage, moisture must not penetrate the grooves in the foam.
- Composite elements must not bear the bracing of a construction. Statics has to be achieved according to the processing instructions of the profile system's manufacturer.
- Claim under guarantee exists in regard to the surface and the bonding (according to manufacturer's information) only but not in regard to warping of the panel.
- Thickness tolerances of the production materials may be partially visible (e.g. at the joint site of the foam core) and do not give grounds for claims under guarantee.
- The range of operating temperature may differ depending on facing and core material. Please contact us for detailed information.



Drilling

Use spiral drill bits with plastic-cutting angles

- Clearance angle approx. 8°-10°
- Cutting angle approx. 3°-5°
- Tip angle approx. 80°-110°
- With large-diameter holes, use a centre drill.
- Observe the corresponding DIN/EN and VDI guidelines.



Milling

- In view of idle time, use diamond-tipped or carbide-tipped tools.
- RPM and feed speed lie between 3.000-24.000 rpm and 1-30 m/minute respectively, depending on the material and choice of tools.



Surface Protection Foils with Stadurlon or PVC

In consultation with our surface protection film suppliers, we have drawn up the following recommendations for storing and handling the film to prevent increased adhesion:

- In general, none of the surface protection foils are UV-stable. Due to the shrinkage behaviour of the protection foil a circumferential negative tolerance of the foil up to 10 mm may occur.
- The ideal storage and processing temperature lies between +10°C and +40°C. At temperatures below 10°C the adhesive strength of the surface protection foil diminishes linearly with the temperature. At temperatures above 40°C the adhesive strength of the surface protection foil increases linearly until transfer of the adhesive to the panel occurs.
- Particularly during storage, and/or with panels installed coated with surface protection foil, which are subjected to UV-rays (Sun), the surface temperature can easily exceed 40°C resulting in the transfer of the adhesive as well as in an embrittlement of the foil.
- Ideally, panels coated with a surface protection foil should be stored inside (also avoiding UV-rays near doors and windows). If this is not possible the panels must be covered with a white and opaque cover hood.
- When installed panels (inside and outside) are subjected to UV-rays the surface protection foil must be removed immediately.
- The protective foil of Panels coated with surface protection foil that are not subjected to UV-rays must be removed within 6 months of production (see label, only pallets are marked).



Bonding

- The raw surface must be clean, dry and oil-free.
- Full-surface bonding is possible.
- Ensure that the raw surface is suitable for bonding.
- Always follow the instructions of the adhesive manufacturer.
- Use only solvent-free contact adhesives for foams.
- Allow sufficient evaporation time for single-component adhesives before bonding.
- Always mix two-component adhesives exactly according to the manufacturer's instructions.
- Carry out appropriate trials on samples before use.
- Adhesives may not be used for structural purposes.
- Check silicones for compatibility.
- When using silicone, the raw surface must be primed with bonding primer etc, according to the manufacturer's instructions.
- Edges are only suitable for bonding to a limited extent.
- When edge-bonding, foams do not provide high adhesive or shear strength.
- Bonding of SKS: see special processing recommendation
- For bonding front edges, we recommend the flexible universal adhesive Illbruck SP050



Storage, Transport, Packing

- Generally, all boards must be stored dry laid flat on pallets.
- When boards are delivered on pallets, a layer of approx.
- 10-20 mm thick extruded foam panels is placed on top. This is not only as protection against scratches etc. but also serves as a thermal barrier against the ambient climate. This plays a significant role in preventing the facing panels of the uppermost boards exhibiting different climatic properties to those stacked lower down. Furthermore this prevents a warping of the panels.
- The pallets are covered with a light PE foil. Caution: cannot be stored outdoors!
- The pallets must be covered with a UV-resistant foil after opening.
- After opening a pallet of composite elements, the top board must additionally be weighted down appropriately over the entire surface area.
- The boards must always be carried vertically (to prevent sagging).

- Individual boards must be lifted off the pile and not pulled off over the edges.
- During transportation, it should generally be ensured that boards are stored laid flat (exception: vertical pallets). Glass panels are an exception; they should be transported stood upright as far as possible.
- With glass and all other panels it must also be ensured that direct sunlight is avoided during storage. In case of non-observance every reclamation will be disclaimed.
- All products must be checked for visible transport damage immediately on receipt of delivery. This must then be recorded on the delivery note. Concealed transport damage discovered subsequently must be reported to Stadur in writing, at latest within six days of delivery (digital photos are helpful). Claims made after installation of the products will not be accepted.
- In particular laminated panels must be appropriately climatically conditioned prior to processing.
- Remove the protective surface foil immediately after installation!
- Always wear protective gloves, as the board edges can be very sharp.



Sawing, Cutting

- Use wood or metal-working machines, eg wall-mounted saws, bench and hand-held circular saws, band and electric jig saws.
- Carbide-tipped saw blades
- Do not use cooling fluids
- Board dimensioning saws (check pressure of clamps: max 1-1.5 bar)
- Jigsaws (medium teeth and slow feed)
- Generally speaking, trapezoidal-tooth saw blades are best suited, but if a perfect edge is required, hollow-tooth saw blades should be used. The idle time of hollow-tooth saw blades is however lower than with trapezoid-toothed saw blades.

- Manufacturer: Leitz e.g. for a Striebig wall mounted saw 300 x 3.2 x 30 Z96 pos T2/F2 IDENT No. 059951 e.g. for a Homag pressure beam saw 370 x 3.8 x 60 Z96 pos. T2/F2 IDENT No. 059867
- RPMs and feed speeds: They lie between 3.000-6.500 rpm and 5-30 m/minute respectively, depending on the material and the diameter of the saw blade.

In general it should be noted that, due to the cutting speed, the diameter of the saw blade and the RPM chosen have to be coordinated.



Painting

The following processing instructions regarding paintability apply exclusively to sandwich panels with a **Stadurlon** cover sheet:

Pre-treatment

1. Clean the surface thoroughly with Selemix Thinner 1-480 and a clean cotton cloth.
2. Sand the entire surface using a random-orbit sander and P 320-grit sandpaper
3. Carefully remove any sanding dust.
4. Clean the surface again with Selemix Thinner 1-480.
5. Then remove dust from the entire surface using a dust-binding cloth.

When applying the primer, a flow-cup spray gun, e.g. SATA RP 1000 or 5000, with a nozzle size of 1.4 mm is recommended. The topcoat is also applied using a flow-cup spray gun with a nozzle size of 1.6–1.8 mm.

Primer

Selemix 2 K Plastic Primer 7-502

Mixing ratio

- 4 parts Selemix 2 K Plastic Primer 7-502 in colour X
- 1 part Selemix Acrylic Hardener 9-08
- 20 % Selemix Thinner 1-402

Application

- 1 light base coat
- Flash-off time 4–5 minutes
- 1 full-coverage spray coat

Allow the primer to dry completely.

Topcoat

Once the primer has dried completely, either of the following topcoats may be used:

Option 1

- Selemix Direct PRO 7-15X Einschichtdecklack (acrylic-based)

Option 2

- Selemix PUR Direct 7-53X Einschichtdecklack (polyurethane-based)

Both products are available in various gloss levels and in approximately 24,000 colour shades. Application must be carried out in accordance with the relevant Selemix technical data sheets.

Important note

The adhesion tests, which yielded a GT 0 result (cross-hatch adhesion test), were carried out exclusively using the above-described coating system and the specified pre-treatment. Deviations in substrate preparation, products used, mixing ratios or application parameters may adversely affect the adhesion and long-term durability of the coating system. Therefore, compliance with the described working procedure is strongly recommended.

A full technical application report is available on request.

Additional information

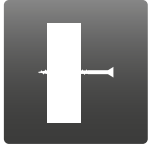
FrameTec & ProfileTec



Coupling

Normally couplings of profile extensions in the structure connection area have no effect on the statics, so that forces acting perpendicular to the window plane can be transmitted only to a limited extent. This results in higher deformations in the frame area under load which may lead to an impairment of the suitability for use. Experience shows that where plastic windows are concerned no sufficient transfer of loads is obtained via the coupling in case of extensions above 60 mm.

Multiple couplings reduce the transfer of loads into the structure considerably. If extensions with a frontage height of more than 60 mm are used fastening to the brickwork by means of claws, steel straps or screws will not be sufficient. In this case brackets must be used to fasten the extension profiles. Base profiles should generally be lined, and full-face support over the entire length be ensured. When coupling single elements via the key bonding is required to preclude potential damage from moisture due to gaps.



Connection

The element should be screwed to the window or threshold profile every 300 mm. Screwing with the SFS self-tapping screw SPC4 can be performed without problems even

without pre-drilling due to our screw core. Other commercially available coupling screws can also be used.



Processing

- Substrate consists of concrete or brickwork.
For frame constructions static evidence must be provided, and they must be checked for thermal/hygric motion.
- Screws must be mounted through the grey StadurFoam core.

- The ideal temperature for storage and further processing, particularly for FrameTec corner brackets, is between +10°C and +40°C. At temperatures below 10°C, the adhesive strength of the surface protection film decreases linearly with temperature. At temperatures above 40°C, the adhesive strength of the surface protection film increases linearly with temperature right up to the point of adhesive transfer to the panel.



Care and cleaning

FrameTec and ProfileTec need only little care. To protect the high-quality plastic surfaces from unavoidable environmental influences regular cleaning with water or mild soapy water

should be performed. Please note that other, aggressive agents, e.g. abrasive cleaners, may damage the surface.



Sealing

Joints must be permanently sealed.
The silicone cord or coupling seal must be fitted in the external joint.

The vapour diffusion resistance must be greater on the interior side than on the exterior side.

Determination of air, wind and water system properties in accordance with DIN ED 1026; DIN ED 1027; DIN EN 12211

Air permeability: Class 4*

Mean air permeability: Class 4*

Resistance to driving rain: Class 9A*

*tested by MPA BAU Hannover

Intended use

There is a wealth of specialist literature on building waterproofing.

In Germany, the following standards apply in particular: 'DIN EN 18533 – Waterproofing of structures in contact with the ground' and, for terminology, DIN 18195. Further regulations:

- RAL guidelines for installation and TR 20
- ift publication 'Correct installation of floor-to-ceiling windows and doors'
- ibat 'Connection of floor-to-ceiling elements'
- Technical regulations for waterproofing (in accordance with the Flat Roof Guideline)
- Technical regulations for the trades: roofers, glaziers, window fitters & joiners
- Depending on the current situation, further regulations must be observed

For Austria, the following are particularly important:

- ÖNORM B 5320 Installation of windows and doors in walls
- ÖNORM B 3691 Planning and execution of roof waterproofing
- ÖNORM B 3692 Design and execution of building waterproofing
- Guideline for the connection of windows, sun protection and façades

In Switzerland, SIA 271 and the technical note on waterproofing connections for windows and doors apply. Further regulations:

- Technical note from Gebäudehülle Schweiz
- Depending on the current situation, further regulations must be observed



Sealing

- Particular care must be taken when waterproofing with bitumen.
Exposure to heat for too long can significantly affect the adhesive bond.
Joints, in particular, must not be exposed to direct heat.

Always flame the bitumen membrane and press it against the StadurFoam top layer – not the other way round!

In line with StadurFoam's operating temperature range (approx. 60°C), we recommend:

- EPDM waterproofing membrane*
- Liquid polymer waterproofing*

*Given the wide variety of materials available on the market, the appropriate sealant must be identified through your own tests.

Example

The effect of excessive flame exposure



Example

Waterproofing with a certified liquid system



The colours and surfaces shown are dependent on the printing process. For precise colour and surface matching we recommend to request an original sample. Subject to technical changes. All business transactions are based on our General Terms and Conditions which can be viewed at www.stadur.com.

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