



ALLIEDBOND®

# ALLIEDBOND

## Installation

### Manual



**ESTOLGA 550**



# ALLIEDBOND®

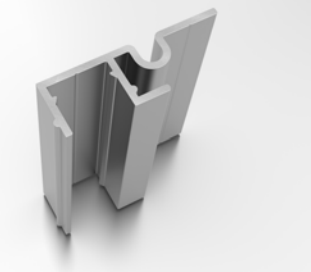
## List of ALLIEDBOND Attachment Parts

### ESTOLGA 550

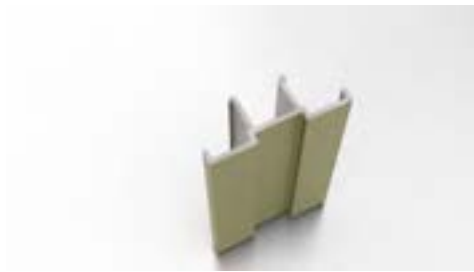


ESTOLGA 550 Base  
Attachment

**CL550B**



ESTOLGA 550 Perimeter  
Attachment **CL550B**



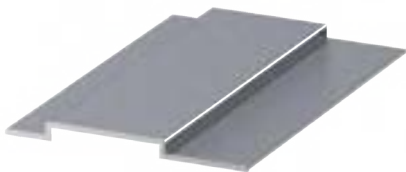
ESTOLGA 550 Base Cap

**CL550BF**



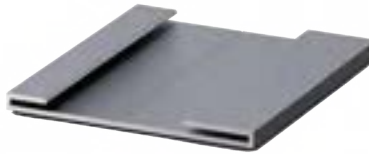
ESTOLGA 550 Perimeter Cap

**CL550IF**



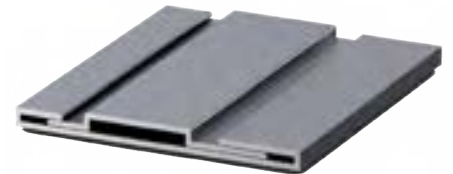
ESTOLGA 550 Stiffener  
Slide

**CL550-A**



ESTOLGA 550  
Stiffener Base

**CL550S-B**



ESTOLGA 550  
Stiffener  
Attachment **CL550S**



CL-550 3M VHB  
Tape **CL5503M**



CL-550 #6 1-1/2" Hex  
Head Screw **CL550HHF**



CL-550 #6 1-1/2" Pan  
Head Screw **CL550PHF**



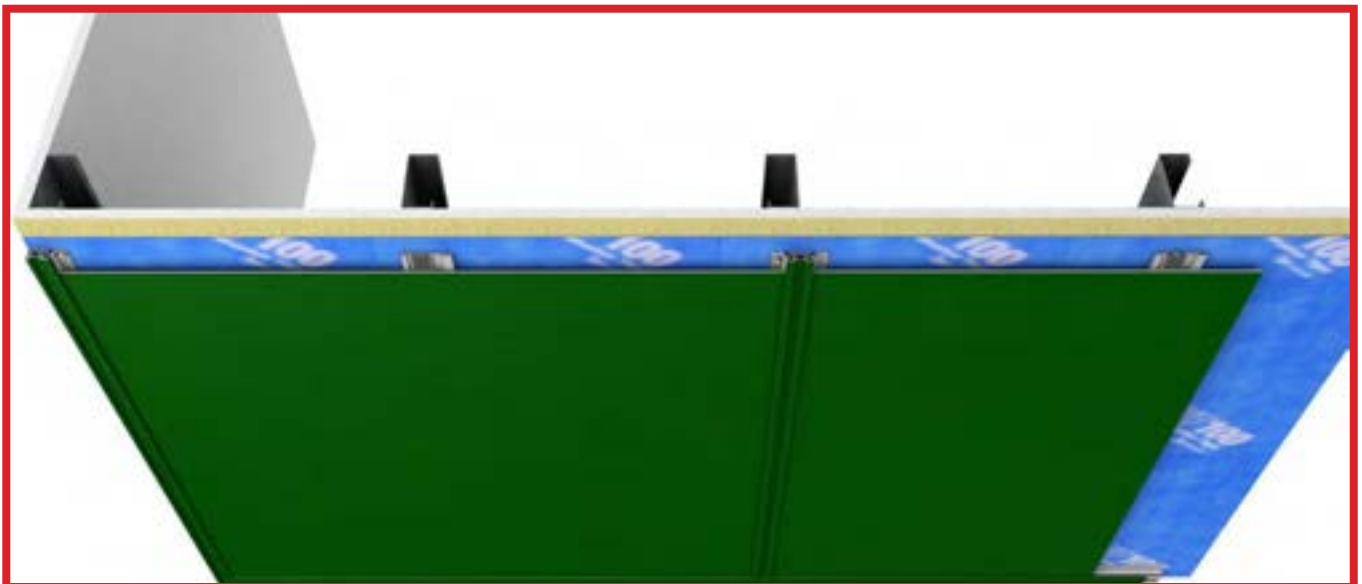
# ALLIEDBOND®

## ESTOLGA 550 Installation: Overview

ALLIEDBOND Wall Systems are installed modularly. An ESTOLGA 550 Perimeter Attachment is initially installed at the bottom of the wall, and a second perimeter Attachment is installed on the left (or right) edge of the wall. These two attachments form the initial axes of the panel grid and should be leveled and made plumb to the walls. An ACM panel is slid into the attachment slots (if the panel width or height is greater than 24" an ESTOLGA 550 Stiffener Attachment is required), and then a ESTOLGA 550 Base Attachment is inserted onto the unsecured edges of the panel. The process is repeated, adding panels to the right and above, until the edge of the wall is reached. An ESTOLGA 550 Perimeter Attachment is used at edges of the wall to finish the installation. After all panels and attachments are secured, ESTOLGA 550 Finishing Caps are installed.

No panel should have more than 24" of unsupported length, therefore if the panel width or height is greater than 24", an ESTOLGA 550 Stiffener Attachment (**CL550S**) is required.

The Stiffener Attachment consists of two pieces: Base and Slide. The Base has two slots, one longer than the other. The Stiffener has two feet, one longer than the other. The Slide is inserted into the Base so that the longer of the Slide feet inserts into the longer of the Base slots. The slide is then free to move within the base. When the shorter Slider foot is slid fully into the shorter Base slot, the Stiffener Attachment is said to be "locked". When the longer Slide foot is fully into the longer Base slot, the Stiffener Attachment is said to be "unlocked".





# ALLIEDBOND®

## ESTOLGA 550 Installation: Overview, Continued

- ❖ A Perimeter Attachment (**CL550I**) is installed plumb to the wall and leveled horizontally. This attachment will be the bottom edge of the panel installation.
- ❖ A second Perimeter Attachment is installed plumb to the wall and leveled vertically. This attachment will be the left or right edge of the panel installation. These two Perimeter Attachments should join to form a 90 degree angle.
- ❖ Slide the ACM panel into the Perimeter Attachment slot until it is flush against the inside of the attachment slot. The panel is now held in place on the bottom and the left edges, but is not yet secured on the top and right edges.
- ❖ A Base Attachment (**CL550B**) is fit onto the Right edge of the existing panel until the ACM panel is flush against the attachment slot. Ensure that this attachment is level and plumb, and then secure the attachment to the wall with #6 1-1/2" Hex Head Fasteners (**CL550HHF**) inserted every 16" on center into the attachment foot.
- ❖ Repeat Step 4 except for the top edge of the panel. The panel is now secured on 3 sides.
- ❖ Repeat Steps 3-5 until the entire wall is covered in ACM panels that are secured on all 4 sides.
- ❖ Finish the span of panels by using a CL-550 Perimeter Attachment at the edges of the wall.
- ❖ Install Perimeter Caps (**CL550IF**) into the Perimeter Attachment joints and press firmly until the cap snaps into place. Install Base Caps (**CL550BF**) into the Base Attachment joints and press firmly until the cap snaps into place.

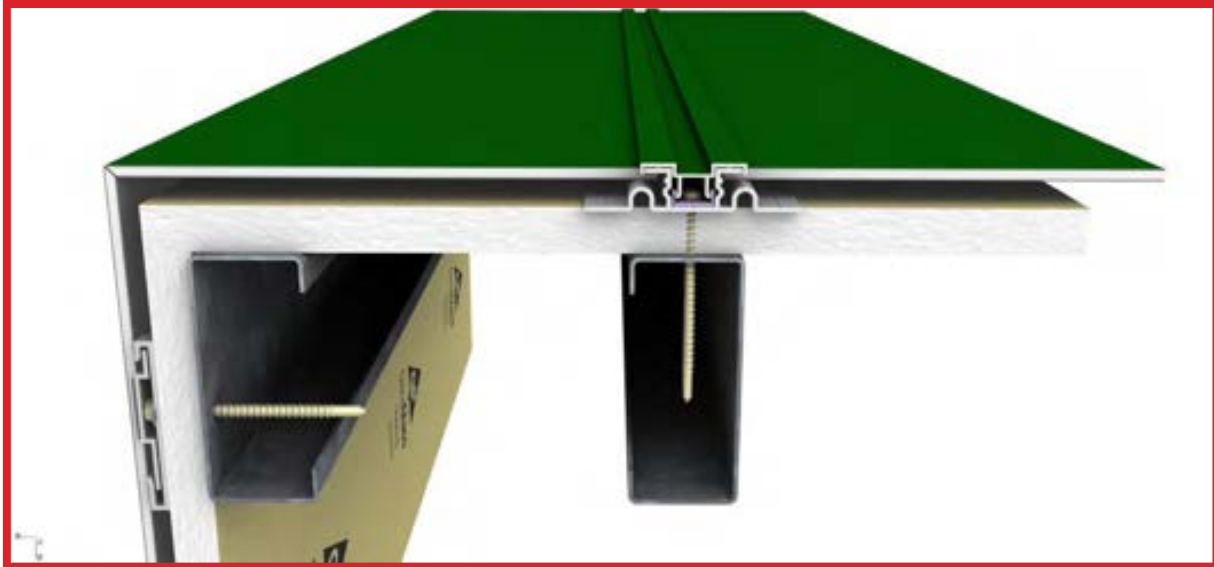


# ALLIEDBOND®



# ALLIEDBOND®

## ESTOLGA 550 Starter Attachment with Joint



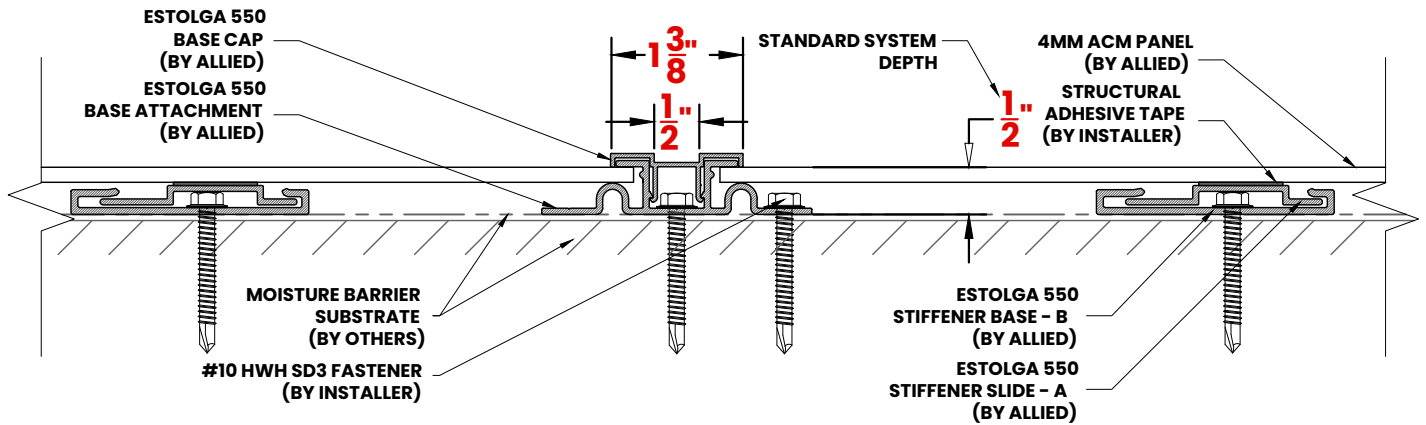
- ❖ The CL-550 Perimeter Attachment (**CL550I**) is installed plumb to the vertical wall and leveled.
- ❖ The edge of the Perimeter Cap (**CL550IF**) should be flush with the edge of the wall. This requires that the Perimeter Attachment be installed with an offset of 0.1 inches from the edge of the wall to leave room for the Cap edge.
- ❖ Secure the Perimeter Attachment to the wall with #6 1-1/2" Hex Head Fasteners (**CL-550HHF**) inserted every 16" into the attachment foot.
- ❖ Install the ACM panel into the Perimeter Attachment slot. Ensure that the ACM panel is slid entirely into the attachment slot.
- ❖ Insert the Perimeter Cap (**CL550IF**) into the Perimeter Attachment joint and press firmly until the cap snaps into place.



ALLIEDBOND®



**ALLIEDBOND®**



PATENTS: 9,874,026 10,011,997 10,316,525

**Fasteners**



**ESTOLGA® 550 OSCF**

On-Site Contractor Fabricated Attachment System

Sheet Name

**Typical Panel Joint Detail**

Sheet Number

**7**

Scale: NTS

**ESTOLGA SYSTEM: 550**

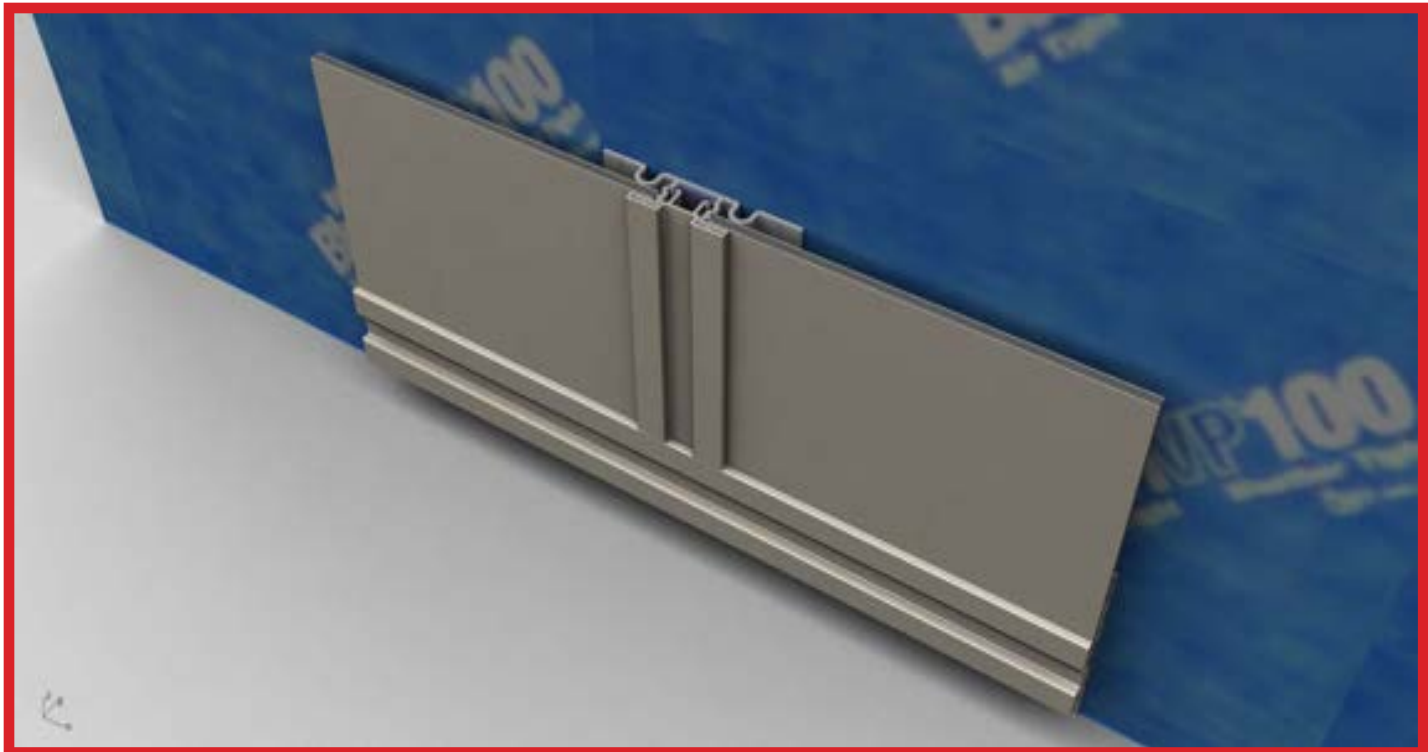
4m  6mm

Confidential Document: Property of Allied Specialty Group (ASG). Any transfer of this document without the express written permission of ASG is unlawful. This document include: Originals, duplicates, and electronic versions. All are exclusive. Information contained herein or related hereto is intended only for evaluation by technically skilled persons, with any use thereof to be at their independent discretion and risk. Such information is believed to be reliable, but ASG shall have no responsibility or liability for results obtained or damages resulting from such use. ASG grants no license under, and shall have no responsibility or liability for infringement of, any patent proprietary right. Sales of ASG products shall be independent and subject exclusively to warranties set forth in ASG acknowledgment. The foregoing may be waived or modified only in writing by an ASG officer. CLADIATOR™, THERMAClip™, ESTOLGA® and ALLIED SPECIALTY GROUP® are registered trademarks of Allied Specialty Group Inc. All rights reserved.



# ALLIEDBOND®

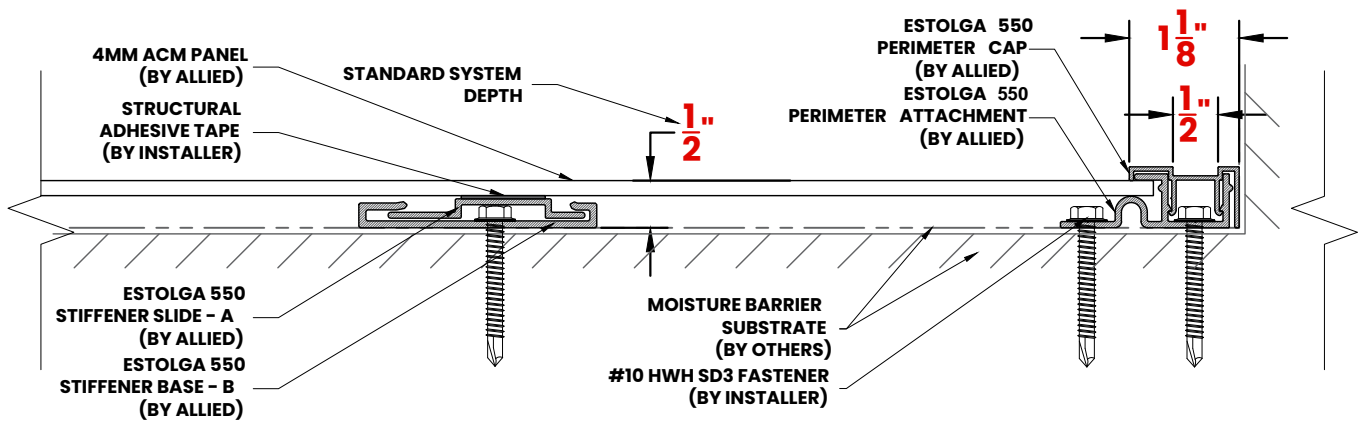
## ESTOLGA 550 Base Attachment



- ❖ The CL-550 Base Attachment (**CL550B**) is installed plumb to the vertical wall and leveled.
- ❖ Secure the Base Attachment to the wall with #6 1-1/2" Hex Head Fasteners (**CL550H-HF**) inserted every 16" into the attachment foot.
- ❖ Install the ACM panels into the Base Attachment slots. Ensure that the ACM panel is slid entirely into the attachment slot.
- ❖ Insert the Base Cap snaps (**CL550BF**) into the Base Attachment joint and press firmly until the cap snaps into place.



**ALLIEDBOND®**



PATENTS: 9,874,026 10,011,997 10,316,525

**Fasteners**



**ESTOLGA® 550 OSCF**

On-Site Contractor Fabricated Attachment System

Sheet Name

**Typical Termination Detail**

Sheet Number

**8**

Scale: NTS

**ESTOLGA SYSTEM: 550**

4mm  6mm

Confidential Document: Property of Allied Specialty Group (ASG). Any transfer of this document without the express written permission of ASG is unlawful. This document include: Originals, duplicates, and electronic versions. All are exclusive. Information contained herein or related hereto is intended only for evaluation by technically skilled persons, with any use thereof to be at their independent discretion and risk. Such information is believed to be reliable, but ASG shall have no responsibility or liability for results obtained or damages resulting from such use. ASG grants no license under, and shall have no responsibility or liability for infringement of, any patent proprietary right. Sales of ASG products shall be independent and subject exclusively to warranties set forth in ASG acknowledgment. The foregoing may be waived or modified only in writing by an ASG officer. CLADIATOR™, THERMAClip™, ESTOLGA® and ALLIED SPECIALTY GROUP® are registered trademarks of Allied Specialty Group Inc. All rights reserved.





# ALLIEDBOND®

## Inside Corner using Stiffeners



- ❖ Mark a straight line on the back of the ACM Panel and then route the line with a V-groove router bit, ensuring that about 0.012" of the core material is left un-routed, and also that the finished side of the ACM panel is not routed. The ACM panel can now be bent along the route line to the angle of the building wall. If the ACM panel used for the corner extends longer than 12" on each side, an aluminum L brace should be secured with caulking to the back of the panel, covering the route.
- ❖ Two CL-550 Stiffener Base Attachments (CL550S-B) are installed plumb to the vertical wall and vertically level on either side of the corner. The Stiffener Base should be installed within 6" of each side of the corner. The Stiffener Base is secured to the wall using #6 1-1/2" Hex Head Fasteners (CL550HHF) every 16".
- ❖ The CL-550 Stiffener Slide (CL550S-A) is inserted into the CL-550 Stiffener base, and then the sliding connector is pushed into the "unlocked" position.
- ❖ 3M tape strips (CL5503M) of at least 1" in length are installed onto the face of the CL-550 Stiffener sliding connector, and the tape's protective film is removed.



# ALLIEDBOND®

## Inside Corner using Stiffeners, Continued



- ❖ The pre-bent ACM panel is affixed to the system so that the panel's bend is aligned with the wall corner. Slight pressure is applied to bond the 3M tape to the back side of the ACM panel.
- ❖ Starting with one edge of the ACM panel, pull the panel in the direction away from the corner. The ACM panel is affixed to the Stiffener Slider and so the Stiffener Slider will adjust within the Stiffener Base until the Stiffener Slide is "locked". This same step is repeated on the opposing wall. The ACM will flex along the route line to accommodate for the Stiffener locking into place.

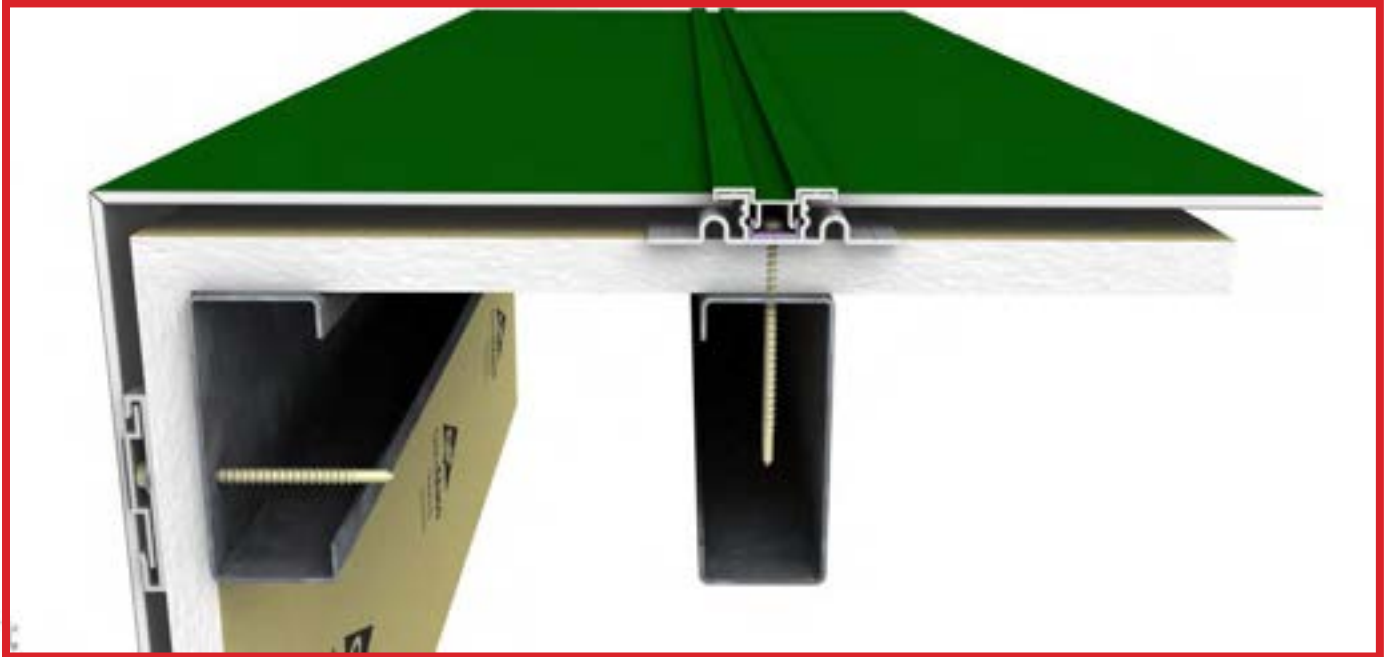


# ALLIEDBOND®



# ALLIEDBOND®

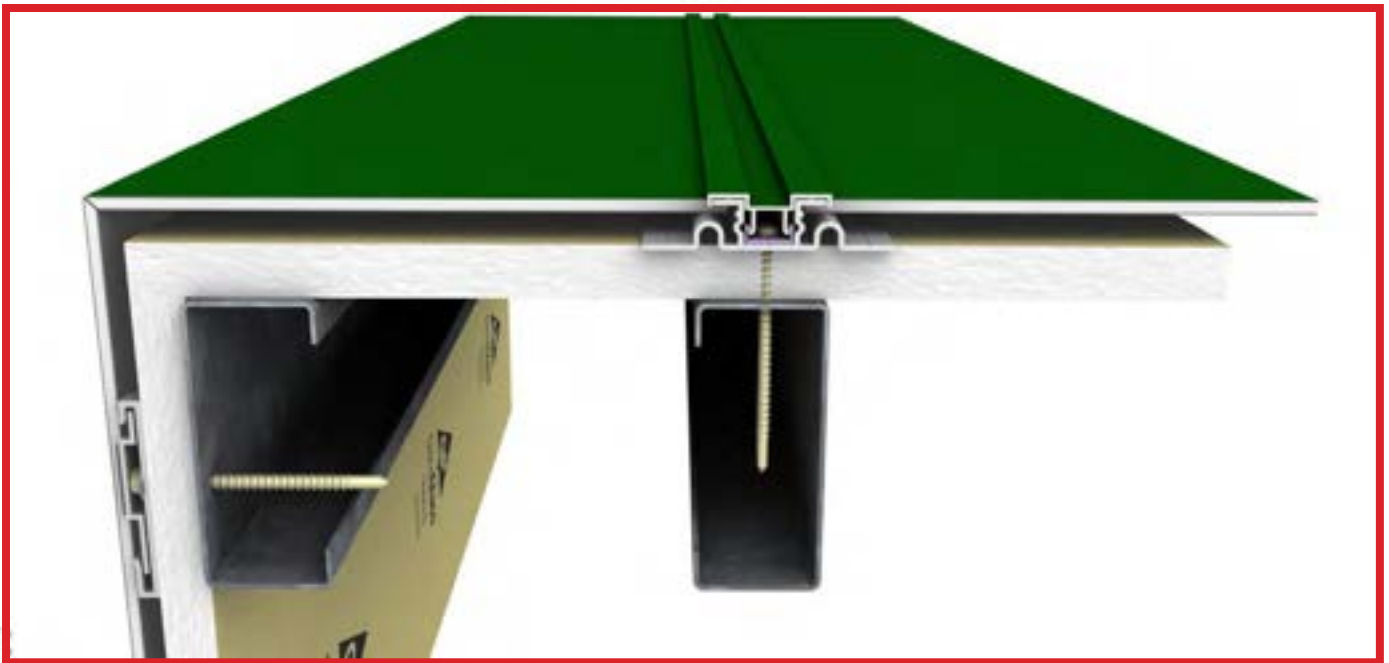
## Outside Corner using Stiffeners



- ❖ Mark a straight line on the back of the ACM Panel and then route the line with a V-groove router bit, ensuring that about 0.012" of the core material is left un-routed, and also that the finished side of the ACM panel is not routed. The ACM panel can now be bent along the route line to the angle of the building wall. If the ACM panel used for the corner extends longer than 12" on each side, an aluminum L brace should be secured with caulking to the back of the panel, covering the route.
- ❖ Two Stiffener Base attachments (**CL550S-B**) are installed plumb to the vertical wall and vertically level. The Stiffener Bases should be installed within 6" of each side of the corner. The Stiffener Base is secured to the wall using CL-55 #6 1-1/2" Hex Head Fasteners (**CL550HHF**) every 16".
- ❖ The Stiffener slide (**CL550S-A**) is inserted into the Stiffener Base (**CL550S-B**), and then the sliding connector is pushed into the "unlocked" position.
- ❖ 3M tape strips (**CL5503M**) of at least 1" in length are installed onto the face of the Stiffener Slide and the tape's protective film is removed.



## Outside Corner using Stiffeners, Continued



- ❖ The pre-bent ACM panel is affixed to the system so that the panel's bend is aligned with the wall corner. Slight pressure is applied to bond the 3M tape to the back side of the ACM panel.
- ❖ Starting with one edge of the ACM panel, pull the panel in the direction away from the corner. The ACM panel is affixed to the Stiffener Slide and so the ACM will adjust within the Stiffener Base until the Stiffener Slide is "locked". This same step is repeated on the opposing wall. The ACM will flex along the route line to accommodate for the Stiffener locking into place.

