



RHEINZINK PRODUCT LINES

Information on Material and Processing

Up-to-date information, reports and specialist publications, further technical information, measurement lists, standard details and tender texts can be found at www.rheinzink.de

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Introduction

A high-quality material, robustly alloyed and naturally beautiful. Durable and sustainable. Easy to process and highly versatile. For those who want all of these properties, RHEINZINK products are the perfect solution. In a manufacturing process developed by RHEINZINK and unique in the world, high-quality premium surfaces are produced which fulfill the high requirements of EN 988. This brochure examines important aspects relating to the material and gives information and recommendations on the topics of quality, product lines, transport/storage, processing, external influences, cleaning and maintenance. This information is based on many years of experience and is based on the latest technological developments.

Questions? The RHEINZINK Team is happy to help with all questions relating to RHEINZINK products.

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Woburn, MA - June 2020

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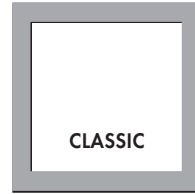


**ONE BRAND –
5 PRODUCT LINES**
**THE PERFECT
SOLUTION
FOR EVERY
REQUIREMENT**

● bright rolled

RHEINZINK-CLASSIC

*ORIGINAL.
EXPRESSIVE.
PATINATES OVER TIME.*



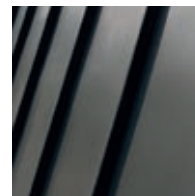
TITANIUM ZINC BRIGHT ROLLED:
PATINATES OVER THE YEARS. NATU-
RAL, VARIABLE SURFACE CHARACTER.

● blue-grey

● graphite-grey

RHEINZINK-prePATINA

*PRE-WEATHERED.
SELF-HEALING.
NATURAL.*



THE ONLY NATURALLY PRE-WEATH-
ERED SURFACE IN THE WORLD.
ZINC TYPICAL PATINA EX WORKS.
100% NATURAL, 100% RECYCLABLE.

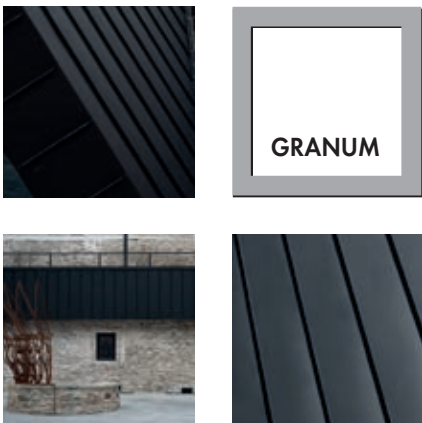
- skygrey
- basalte

- gold
- brown
- blue
- red
- green
- black

- pure-white
- perl-gold
- moss-green
- nut-brown
- blue
- tile-red
- black-grey

RHEINZINK-GRANUM

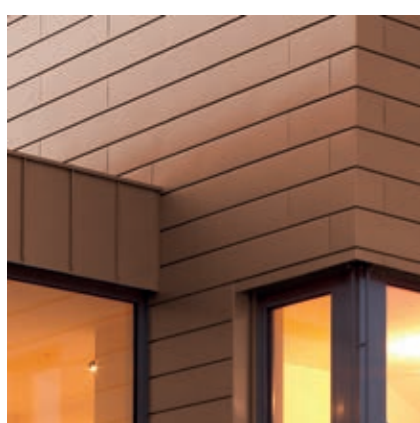
NOBLE.
MATTE FINISH.
MULTIFACETED.



SKYGREY AND BASALTE. PURE, GREY ELEGANCE. URBAN DESIGN. PHOSPHATED SURFACE WITH COUNTLESS DESIGN OPPORTUNITIES.

RHEINZINK-PRISMO

GLAZED.
DYNAMIC.
ADAPTABLE.



AESTHETIC, HARMONIOUS MATCH WITH ITS SURROUNDINGS. SUBTLE COLOR VARIETY FOR A UNIQUE LOOK. SEMI-TRANSPARENT.

RHEINZINK-artCOLOR

COLORFUL.
LIVELY.
CREATIVE.



CREATIVE DESIGN POSSIBILITIES. INDIVIDUAL, EXPRESSIVE COLOR COMPOSITIONS. COATED COLOR VARIETY.

QUALITY

1. Quality

1.1 Alloy

RHEINZINK is the brand name for titanium zinc according to DIN EN 988. The RHEINZINK alloy consists of electrolyte primary zinc according to DIN EN 1179 with a purity grade of 99.995% and precisely determined proportions of copper, titanium and aluminium. Alongside increasing creep strength, titanium also increases the recrystallization limit as compared to unalloyed zinc; copper increases ductility for every type of deformation. In addition to other factors, the alloy composition is not only of importance for the technological material properties of RHEINZINK, but also for the color of its patina (see Subsections 2.1 and 2.2.).

1.2 Manufacturing processes

RHEINZINK is the only manufacturer worldwide with a continuous wide-strip casting and rolling mill for producing construction zinc. With this milling process, which is technically extremely advanced and is being continually improved, the RHEINZINK alloy undergoes a continuous process (melting, casting, rolling, coiling) to become coils in specified thicknesses, which are then cut into strips, panels or bands along shearing lines.

The manufacturing process comprises the following steps:

Master alloy

To improve the quality and for energy reasons, a master alloy is produced in a crucible induction furnace at 760 °C (a molten mass of primary zinc, copper and titanium). The master alloy blocks produced contain the titanium and copper ratios of the subsequent milled alloy.

Melting

The master alloy blocks and primary zinc are melted in large melting furnaces (channel induction furnaces) at 500 – 550 °C and completely blended by induced current.

Casting

The finished alloy is cooled by a closed water circuit in the casting machine far enough below the melting point that a solid casting strip is formed.

Rolling

A cooling phase is incorporated between the casting machine and the rolling stands. The rolling process takes place with 5 pairs of rollers, the so-called rolling stands. At each of these rolling stands, the material is subjected to specific pressures reducing it by up to 50 % in thickness. At the same time, the material is cooled and lubricated with a special emulsion.

Coiling

Finally, the rolled RHEINZINK is coiled onto large rolls, or coils, weighing 20 tons. These are still at a temperature of approximately 100 °C and are stored for further cooling.

Stretching

The tensions in the RHEINZINK strips created by the rolling process are “pulled out” of the material during a stretching-bending-straightening process.

1.3 QUALITY ZINC

The strict testing standards of the TÜV Rheinland-developed QUALITY ZINC criteria catalogue, the quality requirements of which go well beyond the standard requirements, apply to the premium surfaces RHEINZINK-prePATINA blue-grey, RHEINZINK-prePATINA graphite-grey as well as RHEINZINK-CLASSIC and RHEINZINK-artCOLOR.

The quality criteria catalogue includes all of the material's characteristic values and the permissible tolerances with regard to the quality of semi-finished products (strips and sheets).

Inspections are carried out four times a year without warning by a TÜV Rheinland inspector. The tests focus, in particular, on quality characteristics, which exceed those of regular standard specifications including, for example, the permissible lower thickness deviation of ± 0.02 mm, lower length and width tolerances of 2.0/-0 mm and an increased creep limit ($R_p 0.2$) and tensile strength (R_m). Another important quality criterion is the folding test. As in normal folding tests the bending edge is only assessed visually, they have the disadvantage that there is plenty of room for subjective assessments. In order to avoid this, QUALITY ZINC requires a special test. In a folding tensile test, the deformability is determined by clear characteristic values.

The sample is folded, then a tensile test is carried out with the folded sample, and finally the tensile strength of the folded sample is divided by the tensile strength of the material. The characteristic value D (ductility) must be below 0.7; in other words, the folded sample must exhibit > 70% of the strength of the basic material. This precludes subjective assessments.

1.4 Material properties

Physical and chemical properties

- Density (spec. weight):
7.2 g/cm³
- Melting point: approx. 420 °C
- Recrystallization limit: > 300 °C
- Coefficient of expansion:
in longitudinal rolling direction:
2.2 mm/m x 100 K
in transverse rolling direction:
1.7 mm/m x 100 K
- Elasticity modulus:
≥ 80,000 N/mm²
- Thermal conductivity: 110 W/m · K
- Electrical conductivity:
17 m/Ω mm²
- Non-magnetic
- Building material class A1
non-flammable

Mechanical-technical properties according to QUALITY ZINC criteria catalogue

Testing criteria	RHEINZINK-CLASSIC RHEINZINK-prePATINA blue-grey RHEINZINK-artCOLOR	RHEINZINK-prePATINA graphite-grey
0.2 % creep limit ($R_{p0,2}$)	min. 110 N/mm ²	min. 115 N/mm ²
Tensile strength (R_m)	min. 150 N/mm ²	min. 160 N/mm ²
Tensile stretch (A50)	min. 40 %	min. 45 %
Vickers hardness (HV3)	min. 45	min. 45
Folding test	No cracks on bending edge	No cracks on bending edge
Unfolding after folding test	No unfolding fracture	No unfolding fracture
Folding tensile test	D min. 0.7	D min. 0.7
Erichsen cupping	min. 8.0 mm	min. 8.0 mm
Permanent elongation in creep rupture test ($R_{p0,1}$)	max. 0.1 %	max. 0.1 %
Camber	max. 1.0 mm/m	max. 1.0 mm/m
Evenness	max. 1.5 mm wave height	max. 1.5 mm wave height

Mechanical-technical properties according to DIN EN 988

Testing criteria	RHEINZINK-GRANUM RHEINZINK-PRISMO
0.2 % creep limit ($R_{p0,2}$)	min. 110 N/mm ²
Tensile strength (R_m)	min. 150 N/mm ²
Tensile stretch (A50)	min. 40 %
Vickers hardness (HV3)	min. 45
Folding test	No cracks on bending edge
Unfolding after folding test	No unfolding fracture
Erichsen cupping	min. 8.0 mm
Permanent elongation in creep rupture test ($R_{p0,1}$)	max. 0.1 %
Camber	max. 1.0 mm/m
Evenness	max. 1.5 mm wave height

QUALITY

1.5 Identification

A

RHEINZINK-sheets and -coils:
recognisable by the consecutive colour-
ed stamping on the metal underside.

B


RHEINZINK-pallet identification:
recognisable by the packaging label
with detailed product data.

C

RHEINZINK-
Roof drainage accessories:
recognisable by the branding.

D

RHEINZINK
Roof drainage products:
recognisable by the branding.

RHEINZINK-prePATINA® – EN 988 Titanzink/Titanium Zinc/Zinc titane – RHEINZINK® – Datteln – MADE IN GERMANY –
TÜV QUALITY ZINC – Rückseite/back side/verso  – RHEINZINK-prePATINA® – 123456/78 0,70

RHEINZINK-GRANUM xxx Titanzink/Titanium Zinc/Zinc titane EN 988 –
RHEINZINK-GRANUM xxx Rückseite/back side/verso – [Coil-Nr. - Dicke]

A



B



C



D

1.6 Certifications

RHEINZINK is certified according to ISO 9001. The premium products RHEINZINK- prePATINA, RHEINZINK-CLASSIC and -artCOLOR are also subject to voluntary testing by TÜV Rheinland according to the strict QUALITY ZINC criteria catalogue. RHEINZINK is a natural, 100% recyclable material, which has always effortlessly fulfilled the strict ecological requirements of today. The latest production facilities, sophisticated logistics and favourable processing properties speak to this. Environmentally conscious action is documented through the introduction of the environmental management system ISO 14001. It is checked and certified according to TÜV Rheinland.

RHEINZINK also documents responsible action in regard to the environment through the introduction of an energy management system according to ISO 50001. The intention is to save energy and resources and to keep the environmental impacts of RHEINZINK products as low as possible.

RHEINZINK's dedication to the environment has been assessed and certified by independent institutes.



* Federal Environmental Agency recognised eco-label for construction products

2. Product lines

2.1 RHEINZINK-CLASSIC

The material RHEINZINK-CLASSIC is a natural material which develops a firmly adhering zinc carbonate patina during its lifetime exposed to the atmosphere. Initially, the zinc surface reacts with the oxygen in the air to form zinc oxide. The effect of water (rain and humidity) leads to the formation of zinc hydroxide, which reacts with carbon dioxide in the air to form a dense, firmly adhering and water-insoluble coating layer of zinc carbonate (patina). This protective layer is responsible for the high corrosion resistance of the zinc.

This process does not take place simultaneously everywhere. First, drop-let-shaped grey areas develop, which merge together as the protective layer continues to grow, creating the familiar uniform blue-grey patina. This process is very characteristic for bright-rolled surfaces and does not constitute grounds for complaint. Depending on the intensity of the external moisture, orientation and position of the building, as well as the inclination of the clad area, the process can take months or years. As a basic rule, the more intensively or the longer rainwater remains on the surface, the quicker the patina develops. This materi-

al property is often used by architects as a design tool to emphasise the building's natural ageing process.

While the basis of the protective layer is zinc carbonate, additional substances from the surroundings are also integrated into the protective layer. That is why the color of the patina can vary slightly from one place to another.

Additionally, the use of material with different production dates can lead to initial differences in patina formation. The color differences slowly converge over the course of the patina formation.



Leuphana University, Lüneburg



Patina formation

2.2 RHEINZINK-prePATINA

As an alternative to using bright-rolled material, the pre-weathered RHEINZINK surface variants are available. RHEINZINK-prePATINA blue-grey and graphite-grey are the only products on the market which have a truly natural surface. They are neither coated nor var-nished. The color effect is in fact created by the metal alloy itself. In comparison to RHEINZINK-prePATINA blue-grey, the RHEINZINK-prePATINA graphite-grey surface has a slightly higher copper content, meaning that the unique RHEINZINK pickling process results in a darker coloring. Both colors of the prePATINA surfaces thus result from the natural basis material and when they leave the factory, the materials already have a color very similar to that which results from the subsequent patina formation on the finished property. During the natural weathering process, any scratches (such as those which may result from installation) are evened out in the zinc typical way. By contrast, the natural patina of the other surface qualities is only formed after the phosphate layer or coating has been broken down.

Color tolerances

RHEINZINK-CLASSIC and the pre-weathered surfaces RHEINZINK-prePATINA blue-grey and graphite-grey are natural materials which begin to form a natural patina when exposed to the atmosphere. A special pickling used on the prePATINA range creates the look of a true patina in the factory from the RHEINZINK alloy, which would only set in after a longer period of time under natural influences. The pickling produces a uniform color, though one which cannot be compared with a RAL color.

Due to the higher copper content in RHEINZINK-prePATINA graphite-grey, the copper is also able to react with the atmosphere, meaning that a natural greenish tint develops on the surface. During the course of patina formation, the surface may become brighter.

For production reasons, color differences may occur but are purely visual and, as a rule for RHEINZINK-prePATINA, these differences are evened out during patina formation on the finished property. Therefore color differences can also occur within a coil. Color differences do not constitute grounds for complaint.

Care must be taken to ensure that the same surface material is ordered for the property or that connected surfaces are ideally completed simultaneously with the same surface material.

Special coatings

RHEINZINK-prePATINA surfaces can be provided with a transparent coating on the top (prePATINA TOP). The coating helps to delay the typical formation of salt deposits in marine climate, see chapter 5.1.

As an additional protection against negative influences from building physics induced climatic conditions RHEINZINK-prePATINA can be provided with a coating on the underside (prePATINA proROOFING).

The RHEINZINK information on color tolerances applies. Additionally, color changes to the underlying pre-weathered layer may occur in spite of the transparent coating.



RHEINZINK-prePATINA surfaces

2.3 RHEINZINK-GRANUM

The skygrey and basalte surfaces of the GRANUM product line complement the existing RHEINZINK product range. The luxury matt appearance is obtained by phosphating the material surface. The phosphate coating is durable, weather-resistant and sustainable. It brings out the basic material's typical texture. The bright or dark surface color of the phosphate layer does not occur due to a chemical reaction creating the color from the alloy as with the prePATINA surfaces, but is due to the appropriate chemical pre-treatment. This means that scratches or surface damage to the GRANUM basalte surface only subsequently form a typical zinc blue-grey patina, and do not blend in with the darker surface color.

For this product line, the natural patina formation only begins with the gradual weathering of the phosphate layer. It is slowly "infiltrated" by natural reactions, and over time a top layer of natural patina and phosphate layer is formed. During this process, the dark surface of RHEINZINK-GRANUM basalte may become brighter.

Color tolerances

Color differences may occur for production reasons and do not constitute grounds for complaint.

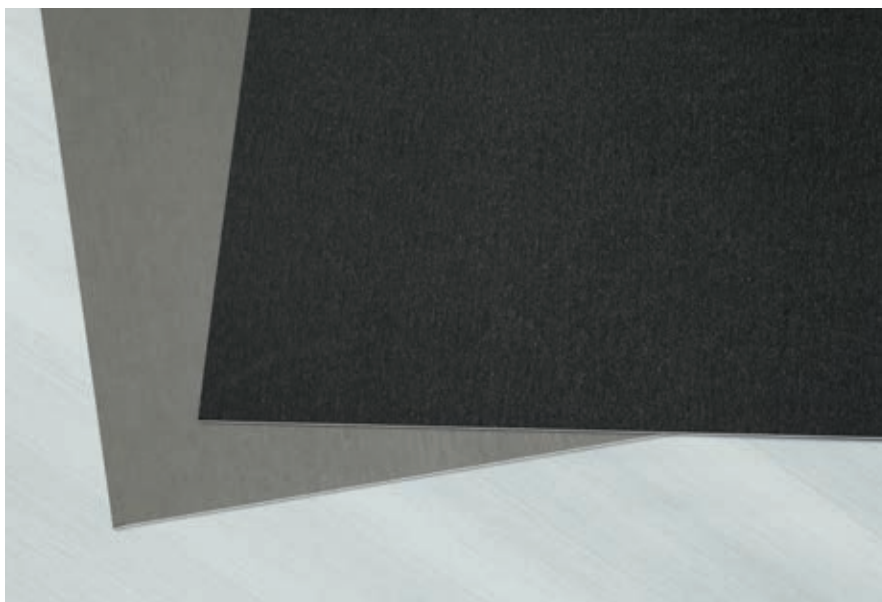
Care must be taken to ensure that the same surface material is ordered for the property or that connected surfaces are ideally completed simultaneously with the same surface material.

Special coatings

RHEINZINK-GRANUM surfaces can be provided with a transparent coating on the top (GRANUM TOP). The coating helps to delay the typical formation of salt deposits in marine climate, see chapter 5.1.

As an additional protection against negative influences from building physics induced climatic conditions RHEINZINK-GRANUM can be provided with a coating on the underside (GRANUM proROOFING).

The RHEINZINK information on color tolerances applies. Additionally, color changes to the underlying phosphated layer may occur in spite of the transparent coating.



RHEINZINK-GRANUM surfaces

PRODUCT LINES

2.4 RHEINZINK-artCOLOR

RHEINZINK-artCOLOR is the colourful variant for roofing and façade cladding, which does not form a patina.

The basic material of the artCOLOR range surpasses the requirements of EN 988. A high-quality, durable PVDF coating allows a wide choice of colors, providing architects, planners, craftsmen and clients with diverse design possibilities.

If desired, we are happy to produce RHEINZINK-artCOLOR in the color of your choice according to the RAL cata-logue.

The RHEINZINK-artCOLOR standard colors:



Black-grey



Pure-white



Perl-gold



Moss-green



Nut-brown



Blue



Tile-red

Coating properties	
Upper side coating	PVDF, total layer thickness > 30µm including primer
Reverse side coating	Polyester, total layer thickness > 15µm including primer, color RAL 9018 (papyrus white)
Gloss level according to DIN 67530	30 (60°)
Corrosion resistance according to DIN EN 10169	RC 4
Coating hardness according to DIN EN 13523-4	Pencil hardness HB-F
Resistance to abrasion according to ASTM D 968	Sandblast 70l
Impact test (reverse impact) according to DIN EN 13523-5	~ Sheet thickness 0.5 – 1.2mm → 3 to 9 joules
T-bend tear-free according to DIN EN 13523-7	max. 1 T
T-bend hairline crack free according to DIN EN 13523-7	max. 1.5 T
Cross-cut test according to EN ISO 2409	GT0 (no detachment)
Adhesion after indentation according to EN 13523-6	GT0 (no detachment)
Solvent resistance according to DIN EN 13523-11	min. 100 double frictions
Salt spray fog test according to ISO 9227	1000 h

2.5 2.5 RHEINZINK-PRISMO

RHEINZINK-PRISMO is the organic-looking color-coated product line from RHEINZINK. The basis material is the phosphate surface GRANUM skygrey, onto which a semi-transparent PVDF varnish is applied. This results in a colored effect which also brings out the underlying zinc structure. With seven standard colors, PRISMO offers diverse design possibilities.

At the same time, the durable PVDF coating protects the material. However, penetrating scratches do not subsequently form a colored patina, but a zinc-typical blue-grey look.

The coating itself does not form a patina, but may also change its appearance and become brighter due to environmental influences.

The RHEINZINK PRISMO standard colors:



Blue



Brown



Gold



Green



Black



Red

Color tolerances

Color differences may occur for production reasons and do not constitute grounds for complaint. Care must be taken to ensure that the same surface material is ordered for the property or that connected surfaces are ideally completed simultaneously with the same surface material.

3. Transportation and storage

3.1 General

In general, care must be taken that RHEINZINK is transported and stored under dry, ventilated conditions. This means that open transportation, particularly in unsettled weather, should be avoided. If these rules cannot be followed, the formation of zinc hydroxide can be expected (see Subsection 5.2).

- Small coils of up to 100 kg must be stored upright to avoid deformation.
- During rearrangement of larger coils, which are delivered horizontally, the accompanying wooden sleepers must continue to be used for stabilisation and weight distribution.
- If desired, coils with a weight of at least 1 t can be delivered with a cardboard tube. The cardboard tube serves to reinforce the coil and prevent deformation in the event of longer-term storage.
- Material with protective plastic film should not be stored for more than 12 months. In the event of longer-term storage, there may be difficulties removing the film.
- The film protects against mechanical damage, but not against moisture impact. The information on transport and storage described in this chapter applies.



Storage of small coils



Storage of coils with wooden sleepers

Avoid at all costs!

- Covering coils, panels or profiles without ventilation
- Change in dew point
- Storage on a damp floor
- Transportation/storage on damp pallets
- Stacking the material too tightly during transportation or storage (to avoid abrasions)





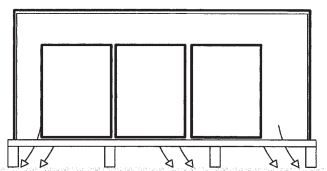
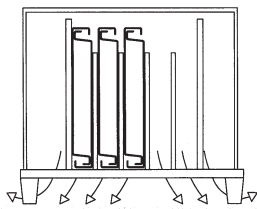
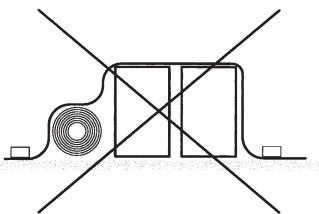
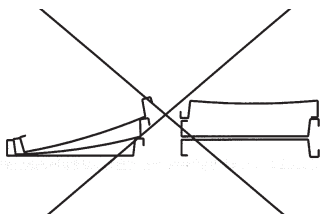
Incorrect storage on-site

3.2 Storage on-site

For optimal storage on-site, storage in a dry, well-ventilated room or container is advised.

If no room or container is available, the following should be observed:

- The material should be protected from rain and moisture with appropriate covers. However, sufficient ventilation should also be ensured.
- Tarpaulins should not be placed directly onto the material, as moisture may get between the profiles and, in the absence of air, may lead to visual damage through the formation of zinc hydroxide (see Subsection 5.2).
- The material must not be stored directly on the ground, but must have sufficient clearance for condensation to evaporate



Transportation and storage of panels

Transportation and storage of coils

Additionally, the material should be protected against typical "building-related soiling", such as cement and plaster dust, dust from stone cutting and stone dust etc. – both during storage and during relocation. Building dust combines with air humidity and constitutes lasting contamination of the metal surfaces.

PROCESSING INSTRUCTIONS

4. Processing instructions

4.1 Recommendations for workflow on-site

In order to protect RHEINZINK from potential negative impacts from other trades during the building phase, such as plastering, it is recommended to plan the order of work amongst the parties involved so that sheet metal work is carried out afterwards, if possible.

If the trades cannot be separated in this way, the RHEINZINK material must be protected by a cover. This should be applied in such a way that ventilation of the covered components is ensured. If this is not possible for practical reasons, the following points should be observed:

- Do not directly cover damp RHEINZINK material
- Use dry covering material
- Fully adhere coverings, without air bubbles or wrinkles (danger of condensation formation)
- Only apply coverings in partial areas and immediately after work, at the latest at the end of the working day

If these notes are not followed, the formation of zinc hydroxide can be expected, which may lead to a visual defect on the surface (see Subsection 5.2). Affected surfaces should be cleaned immediately with RHEINZINK-Sweeper.

The storage of components or prepared metal sheets on site must always be planned such that they are protected and dry, ensuring that soiling or mechanical damage of the stored components can be avoided (see Section 3).

4.2 Avoidance of color differences Care must be taken to ensure that the same surface material is ordered for the property or that connected surfaces are ideally completed simultaneously with the same surface material.

In the event that long delays are unavoidable due to unplanned interruptions to construction, it should always be ensured that all common visible faces involving same surface material are completed as simultaneously as possible.

If this is not feasible due to logistical circumstances, it is to be expected in the case of long interruptions that small color differences may initially occur due to the difference in reaction period. This type of color difference is not evidence of a material defect, but rather highlights the material's natural properties and does not constitute grounds for complaint. The color differences will even out as the patina forms.

4.3 Working temperature

At metal temperatures of $< 10^{\circ}\text{C}$, the additional measure of warming the working area, e.g. with a hot air gun, is necessary when abruptly reshaping the material (seaming, bending). This represents an additional cost, which must be separately compensated for.

At temperatures below zero, flawless processing can no longer be guaranteed.

It is therefore recommended to take account of work delays caused by the weather and the additional costs when planning.

Please note the additional information in Subsection 4.12.

4.4 Processing traces

Scratches can arise during forming with profiling machines, during transport, loading and unloading on site etc. They cannot be completely avoided during manual processing of metals. These areas weather over time. An even surface will develop once more (product lines RHEINZINK-CLASSIC and RHEINZINK-prePATINA). These scratch marks do not affect the durability of the RHEINZINK materials.

To avoid processing traces, the use of foiled material is recommended.

4.5 Avoidance of fingerprints

Gloves should be worn in order to avoid fingerprints. Fingerprints which occur on the metal surface due to sweat on the skin may not be completely covered by natural weathering over time, dependent on intensity, and may be visually conspicuous for a long period of time.

4.6 Bending and roll forming

Zinc and its alloys are anisotropic, which means they have different properties parallel and perpendicular to the rolling direction. The mechanical effect of this anisotropy is reduced by the RHEINZINK alloy and rolling process such that the material can be folded 180° irrespective of the rolling direction.

A minimum bend radius of 1.75 mm should be applied. Where the metal thickness (t) exceeds 1.0 mm, the following applies to the minimum bend radius: $1.75 \times t$ [mm].

For the surface qualities with special coating RHEINZINK-prePATINA TOP and -GRANUM TOP, a minimum bend radius of $3.0 \times t$ [mm] applies..

The processing with standard roll formers is possible with no restrictions. Any soiling and deposits on the roll sets should be removed to avoid damage to the surface or coatings. The correct settings for the roll sets should continue to be ensured. The forward feed of the band material must take place without tension or slack, in order to avoid the formation of bulges during the roll forming process.

Imprints from bending machines and presses are unavoidable and do not constitute grounds for complaint. This also applies to so-called idle marks, which can arise during the roll forming process.

4.7 Soft soldering

The soft soldering process is a fast and easy method to produce a water-tight, firmly bonded and lasting connection. The temperature for soft soldering is about 250 °C and is therefore ideally suited for soldering the RHEINZINK material! The RHEINZINK parts to be joined remain in the solid state, but are bonded on the surface with the solder. The strength of the soldered seam (due to the connection of the solder with the material) is achieved through an alloy formation on the contact surfaces. When done properly, this is exactly as strong as the material.

Preparation of the soldered seam

The RHEINZINK surfaces to be soldered must be absolutely clean. If pieces of the RHEINZINK-CLASSIC bright-rolled surface variant are to be attached to each other, the following information should be observed: RHEINZINK-CLASSIC bright rolled can form a slight oxide layer on the surface, despite being stored correctly. In this case, the surface must be cleaned mechanically with stainless steel wool or chemically by repeated application of the flux.

Soldered seam overlap

The overlap area should be 10 to 15 mm. Soldered-through seams, i.e. overlap width = attached soldered seam width, yield the greatest strength. Larger overlap widths mean that soldering through is more difficult, such that a reduction in strength occurs in the soldered seam.

Flux

Our recommended flux is "ZD-pro" from the Felder company. With the RHEINZINK-prePATINA graphite-grey as well as with the GRANUM and PRISMO product lines and all coated surfaces, the protective or paint layer must be removed via abrasion before application of the flux. The flux is then applied conventionally.

Tin solder

The task of the tin solder is the full dispersion on the material and the forming of a permanent bond with the material. That is why the solder and material must be perfectly matched.

Our recommendation is therefore the lead-free RHEINZINK Tin solder, SnZn 801 according to DIN EN ISO 9453 Alternatively: Tin solder low antimony, DIN EN 29453, S-Pb 60 Sn 40, manufacturer's label L-Pb Sn 40 (Sb)

Soldering bit

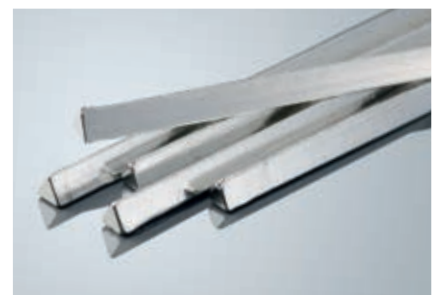
It is recommended to use a hammer bit with a weight of 500 g (min. 350 g). These weights allow for an optimal heat retention without overheating. The wide application surface (fin) ensures a rapid and even heat transfer to the soldering point. Please note that the heat must be added to the entire overlap area, because the solder only flows to where the corresponding heat is given. Pointed bits should only be used for areas that are inaccessible with the hammer bit.

In order to avoid later ruptures of the soldered seam, the thermal linear expansion of metal components must be taken into account. When the elements are assembled, the individual lengths add up to a total length. Movement in the event of temperature differences must, however, still be assured.

After soldering, it is imperative to remove all residues with a damp cloth.

Note:

Further information on soft solder joining technique can be found in the RHEINZINK brochure "Joining techniques – soft soldering and bonding".



Lead-free RHEINZINK-tin solder

PROCESSING INSTRUCTIONS

4.8 Bonding

Full-surface bonding

Cold-applied bitumen adhesives, such as ENKOLIT from the Enke company, have proven themselves for the flat fixing of wall, cornice or windowsill coverings.

Suitable sub-surfaces for bonding with bitumen adhesives are all mineral surfaces, such as masonry, natural stone, cement screed, concrete, slate etc., as well as wood and wooden materials. Unsuitable surfaces are those sensitive to solvents, for example bitumen surfaces, most soft elastic plastics or polystyrene. The bonding technique requires an even, firm base, which must be dust-free, clean and dry.

The adhesive is applied with a notched trowel. Full-surface bonding avoids the transmission of sound, particularly in the region of windowsills (no resonance vibrations of the fixed components). Components which are to be mounted in angled or vertical areas using bitumen adhesives must also be mechanically fixated. The adhesive manufacturer's instructions must also be observed.

Note:

Further information on full-surface bonding can be found in the RHEINZINK brochure "Design and Application – copings and connections".

Strip bonding

For many years, the bonding of metals has been a proven connection technology in various industrial production areas. It requires an adhesive adapted to the base material and a defined processing. Particular attention must be given to the preparation of the parts to be bonded. A clean and dust-free environment is to be ensured, especially on construction sites.

Strip bonding is usually carried out with polyurethane adhesives with one or two components. Areas of application include joints of wall coverings or façade elements.

For strip bonding, the adhesive is ideally applied as a triangular bead, which is then compressed during joining to the intended height, usually half the original height.

Suitable sub-surfaces for bonding with polyurethane are all types of metal, mineral surfaces such as masonry and concrete, wood and wooden materials. When bonding plastics and coated components, the suitability of the adhesive should be checked. Unsuitable surfaces include bitumen surfaces and polystyrene.

To ensure secure bonding, sufficient surface adhesion is necessary and should be guaranteed by appropriate pre-treatment. All layers and coatings which reduce adhesion must be removed. In particular, greasy or oily films must be removed from metals using an appropriate cleaning agent. It may be necessary to roughen the surface. To improve adhesion, a primer or undercoat may be required, depending on the adhesive and surface. Before bonding, the primer must be sufficiently cured.

When bonding, the manufacturer's instructions must be observed.

A special gutter adhesive has been developed for the RHEINZINK roof drainage systems, and has been being used in some European countries for many years.

Note:

Further information on bonding RHEINZINK gutters can be found in the RHEINZINK brochure "Joining techniques – soft soldering and bonding".

4.9 Evenness

Coil material

A characteristic surface appearance for coil material is the slight wave structure typical of thin sheet material. These waves form as the reaction of a natural material to the rolling/unrolling process in the factory and the corresponding reshaping processes (profiling etc.) during workshop production or installation.

This wave development (oil canning), typical for rolling, come to the fore after installation due to reflection of light.

DIN EN 988 allows for deviations in evenness of up to 2mm for rolled titanium zinc coils/sheets, before further processing. For all surface variants, the waves are visually not discernible when the viewing direction of the surface is changed (change of the angle of incidence and thus the angle of reflection).

Additionally, these slight waves, specific to thin sheet material, become significantly less visually apparent once patina formation begins on the bright-rolled surface or the temporary protective surface film (particularly for transport, storage and installation) begins to weather, as no strong reflections occur from the pre-weathered surfaces. The period of time required for further patina formation on the property depends on the weather conditions (in particular, humidity) and local conditions. It is therefore not possible to specify a binding date.

Thin sheet cladding does not have a completely even surface. If there are increased requirements for the visual appearance, it is recommended to increase the metal thickness, reduce the panel width and possibly use sheet material.

Sheet material

Increased evenness can be achieved by using sheet material, which RHEINZINK can manufacture and deliver in lengths of up to 6m. The size of the waves is subject to strict control and may not exceed the defined value according to DIN EN 988 (max. 2mm per m).

4.10 Marking

As a rule, soft pencils should be used, no sharp or pointed objects.

4.11 Protective plastic film

Note that the properties of protective plastic films can change due to environmental influences (sun/UV radiation, frost, temperature changes and humidity). For this reason, it is recommended to remove the foil immediately after installation.

4.12 Special information on the processing of the product lines RHEINKZINK-artCOLOR, -PRISMO, -prePATINA TOP and -GRANUM TOP.

For particularly high expectations of visual quality, the following measures can be taken to further minimise processing traces.

- Folds should be closed by hand with a seam locker. A soft rag can be wrapped around the tool to serve for additional protection.
- Tools such as e.g. clinching pliers, box folding pliers, etc. can be masked with a self-adhesive fleece.
- Nylon hammers and nylon fold pieces should be used.

Metal temperature

For metal temperatures $< 10\text{ °C}$, the material should be heated up in parallel to the rollforming process. For "intersection points" or other critical detail points, it can also make sense for temperatures $\geq 10\text{ °C}$ to warm the material up in the workspace. Warming should take place cautiously and not over an open flame. The material temperature must not exceed 80 °C .

PROCESSING INSTRUCTIONS

5. External influences

5.1 Use in regions with maritime climates

When RHEINZINK materials are used in regions with maritime climates, white deposits may form on the material due to the saline or chloride-containing air. These salt deposits may occur kilometres inland and may affect roofs and façades. These natural deposits are integrated into the material's patina and are more clearly visible on the surface of darker materials due to the color contrast. Overall, the natural patina in these regions with saline or chloride-containing air appears brighter. The function and lifetime of the material used for façades, roofs and other parts of the building are not affected when the RHEINZINK installation guide-lines are followed.

The occurrence of salt deposits in regions with maritime climates is to be expected regardless of the material and surface chosen. This also applies to the coated product lines and surface variants. It is not possible to precisely identify regions with maritime climates which affect the material, due to variables such as local temperature, precipitation and wind conditions. For this reason, the extent or appearance of changes to the material's appearance cannot be predicted and varies from location to location.

In the event of precipitation, surfaces which are not exposed to regular rainfall or which are protected from rain (e.g. soffits or the underside of gutters) are usually more strongly impacted by the salty air and the white deposits, which are more visible on these surfaces. In addition, salt deposits may form on seams and drip edges. Again, this does not reduce functionality.

It is recommended to clean the surface of the material with clean water (not seawater) at least twice a year or more if necessary in maritime climate zones, depending on local conditions.



Examples of salt deposits on façades, seams and drip edges



Examples of salt deposits on soffits and undersides of gutters

5.2 Formation of zinc hydroxide (white rust) on RHEINZINK-CLASSIC, -prePATINA and -GRANUM

As described in Subsection 2.1, RHEINZINK develops a protective zinc carbonate patina when exposed to the air.

When there is an inadequate supply of carbon dioxide from the air, for example in cases of poor storage, transportation or unsatisfactory covering, the patina development remains in the zinc hydroxide stage, which in the presence of sufficient moisture will grow in volume and appear as a whitish coating. It should be pointed out that, as a rule, the formation of zinc hydroxide on the upper surface of the material is a purely visual defect and does not affect the material's durability.

In the case of horizontally installed wall copings or similar applications, an insufficient slope can result in the formation of puddles, in which the material is exposed to moisture without an air supply. The result is the formation of zinc hydroxide. However, as this exposure is only temporary and the formation of zinc hydroxide is continually interrupted, the statement above that these are purely visual defects still applies.



Zinc hydroxide formation due to insufficient slope

For copings, there is a risk of formation of zinc hydroxide if they are covered with foil, e.g. for protection during plastering or painting work. In the event of rain or a change in temperature, moisture may penetrate under the foil. This appearance of zinc hydroxide on cladding can be avoided if the foil is removed at the end of the workday. Furthermore, appropriate planning of assembly sequences contributes to avoiding the formation of zinc hydroxide on RHEINZINK.

Hot water corrosion

If the underside of the metal is exposed to moisture in combination with high temperatures over a long period of time, due to physical property or installation errors, hot water corrosion may occur. Zinc carbonate cannot form on the underside because of the lack of carbon dioxide from the air. No exchange of air is possible. This type of hot water corrosion eventually leads to a pointwise deep corrosion (pitting).

5.3 Influence of metals laid above

Electrolytic corrosion can arise when different metals are assembled together if the metal (component) with the higher electrical potential is higher up in the flow direction of the water.

Harmless

- Aluminium, blank or coated
- Lead
- Stainless steel
- Galvanised steel (rust traces are however possible, from unprotected cut edges etc.)

Problematic

- Copper

5.4 Influence of roof sheeting laid above

When using the following products, a protective coat is required, e.g. Enke Multi Protect:

- Exposed bituminous roof sheeting without gravel surface/shingle (oxidation acid corrosion)
- PVC roof sheeting (acidic emissions)
- ECB roof sheeting (acidic emissions)

When using other products, it is recommended to request from the manufacturer the expected pH values of the resulting degradation products due to UV radiation. pH values between 5.5 and 11 are harmless for RHEINZINK material with regards to corrosion damage.

PROCESSING INSTRUCTIONS

5.5 Influence of wooden cladding laid above

Interactions with the natural material of wood are essentially the result of its pH value. The pH value of a substance is an important chemical parameter defining how acidic or alkaline the substance is.

In principle, pH values between 5.5 and 11 are harmless for RHEINZINK material with regards to corrosion damage.

RHEINZINK is not aware of any cases of significant corrosion occurring due to surface water on wooden-clad façade surfaces which led to a demonstrable reduction of the durability of a RHEINZINK-clad surface. Nevertheless, surface water on some types of wood, such as oak or red cedar, can lead to extreme surface color changes. However, these are a purely visual defect.

Certain fire retardant or impregnating treatments of the wood can, however, have a corrosive effect on metals. The manufacturer information must be observed.

In order to avoid potential visual defects due to drips – resulting from dirt accumulation and/or the pH value arising – the collection of gathered surface water from wooden-clad areas by a gutter should ideally be taken into account during the detailed planning stage.

If, according to the manufacturer's information, corrosive effects are to be expected for treated wood, a protective coating is recommended.

5.6 Influence of oil heating

As for all light-colored roofing materials, discolourations may become visible which are caused by the deposit of exhaust gas constituents from oil burning. Heating oil still contains minor, non-combustible ash content such as sulphur and sometimes ferrous additives. The resulting deposits on the surface do not affect the durability of RHEINZINK material.

5.7 Influences during the construction phase

Splatters of paint or mortar, cement, plaster dust

Splatters usually occur during the transportation or use of paint or mortar or subsequent tasks on areas which are not correctly covered. As long as the splatters and deposits are still fresh or liquid, the marks can usually be largely removed by clear tap water with the addition of washing up liquid/neutral cleaner using a soft cloth. It is always recommended to remove this kind of splatter immediately if possible.

The following applies equally to all types of mortar and concrete:

1. They can become a corrosion problem caused by chlorides, which may have been added to the mixing water in the form of calcium or magnesium chlorides as part of the bonding agents or anti-freeze. Such problems may actively persist beyond the bonding or drying phase.
2. When they accidentally touch RHEINZINK, e.g. in the form of fallen mortar residues, they can cause a superficial change due to their moisture content alone, which is not of corrosive significance, but can constitute a visual defect.

Brick cleaning

Generally speaking, it can be assumed that brick cleaning agents damage the cladding due to their usually extremely low pH value, causing corrosion. Roof or façade surfaces underneath should therefore be protected.

Rust traces

Red rust stains can arise when steel components above RHEINZINK surfaces rust, or through drilling chips/swarf from processing of the steel which were not removed. In general, rust stains can only be removed via abrasion. However, this would lead to these areas appearing bright-rolled once more in the case of "pre-weathered" surfaces or those which already have a patina. Furthermore, it can be assumed that these rust stains would occur again if the cause cannot be eliminated.

Such cases are, as a rule, purely visual defects, which are not relevant to the durability of RHEINZINK materials.

Use of surfaces during installation

Walking on surfaces with dirty shoes, which could transfer building dust such as cement, plaster, lime, which have a corrosive effect when combined with moisture, onto the installed surface, should be avoided. In general, walking on completed surfaces should be avoided as far as possible to avoid scratches.

Adhesive residues

Adhesive residues from adhesive tape or protective plastic films which were left on the surface too long usually do not affect the surface. However, they can be complex to remove.

Information on cleaning RHEINZINK surfaces can be found in the Cleaning recommendations in Section 6.

5.8 Base and spray area, road salt

In the base area, soiling and changes to the patina formation may occur due to spray. In combination with moisture, road salt has a corrosive effect on metal. For this reason, façade cladding should in general be at a sufficient distance from the ground – usually $\geq 30\text{cm}$.

5.9 Influence of other materials

- Wood fibre plates installed above can lead to drips on eaves flashing or roof drainage products, which are however not usually corrosive.
- Only neutrally reacting silicon sealing compounds should be used.
- Extreme exposure can be expected if roof drainage systems must be replaced under a layer of old roof tiles (which may even be covered with moss). In these cases, corrosion marks may appear at the preferred drip points at the outlet of troughed tiles (e.g. pantiles), as the tiles have stored pollutants from the atmosphere as they aged. Particularly when they are dissolved by small flows of water (fog, dew, drizzle), these may be slightly acidic. Under such circumstances, new gutters often (depending on weather conditions during installation) do not have a chance to form a protective layer in the areas where they are predominantly subjected to these stresses. For this reason, a protective coat is recommended here, e.g. Enke Multi Protect.

- Die-cast accessories may cause stains
- In isolated cases, there may be wash outs with a corrosive effect from new roof tiles or shingles. The manufacturer should be asked about this as a precaution.
- When cleaning, e.g. window cleaning, it must be ensured that only pH-neutral cleaning products are used, in order to avoid stains on RHEINZINK material.

CLEANING RECOMMENDATIONS

6. Cleaning recommendations

6.1 General comments

Changes to the natural surface usually do not affect the material or reduce durability, but are purely a visual defect. However, contamination on material surfaces cannot always be avoided and may, for example during installation, be caused by external or environmental influences. RHEINZINK cannot guarantee that these recommendations will achieve an appearance as new..

Cleaning success depends on the level of contamination and the circumstances, including how long the contamination has already been present on the material. During cleaning, it is necessary to distinguish between the various product lines and surfaces. In general, the surfaces should not be cleaned with "hard objects" and/or acidic cleaning products, as the surface may be damaged. An abrasive treatment would lead to the surface appearing bright-rolled once more. In the case of the patina-forming surfaces only, these areas increasingly blend in visually during the weathering process.

In order to achieve long-lasting cleaning success, it is important to proceed extremely carefully. It is recommended to test the cleaning on a small surface. During the weathering process and the formation of the protective layer, the areas cleaned will increasingly blend in visually. When these cleaning recommendations are followed, visual defects of the material surface can usually be minimised.

Basic cleaning for all surfaces

- Clean the material quickly after the contamination has been identified with plenty of clear tap water, with the addition of a little washing up liquid/neutral cleaner (no abrasive cleaners), using a soft cloth or sponge and rubbing with a moderate amount of pressure in the direction of rolling.
- If necessary, repeat the process several times.
- In this case, too, dry with soft, lint-free cloths or paper microfibre cloths.
- It is imperative to change the cleaning cloth frequently.

6.2 Recommendations for cleaning RHEINZINK-CLASSIC bright-rolled and RHEINZINK-prePATINA

Type of contamination	Surface	Step 1	Step 2	Step 3
Dust Slight contamination Slight zinc hydroxide stains	CLASSIC bright rolled, prePATINA blue-grey and graphite-grey	Basic cleaning		
Fingerprints Plaster, mortar and paint residues Building and lime dust, pollen, bird droppings, chimney combustion residuesB- Brown discolouration, rust stains	CLASSIC bright rolled	Basic cleaning	Possible abrasive pre-treatment with stain-less steel wire wool	RHEINZINK-Sweeper
	prePATINA blue-grey and graphite-grey	Basic cleaning	RHEINZINK-Sweeper	
Formation of white rust/ Formation of zinc hydroxide Road salt residue	CLASSIC bright rolled	Basic cleaning	Possible abrasive pre-treatment with stain-less steel wire wool	RHEINZINK-Sweeper
	prePATINA blue-grey and graphite-grey	Basic cleaning	WEICON® Metal-Fluid	RHEINZINK-Sweeper
Adhesive residues	CLASSIC bright rolled, prePATINA blue-grey and graphite-grey	Basic cleaning	Citronex or Sika®-Remover-208	RHEINZINK-Sweeper
Salt deposits in maritime climate	It is recommended to clean the surface of the material with clean water (not seawater) at least twice a year in maritime climate zones, depending on local conditions.			
Heavy contamination Changes to surface	In these cases, cleaning the natural surface is not possible and matching the original condition is not to be expected. The changes are purely visual, in general a reduction in durability is not to be expected.			

Recommended products

- **RHEINZINK-Sweeper** is suitable for cleaning metals in the roof and façade areas.
It does not leave greasy or sticky residue and is a temporary protective layer for the surface / available in RHEINZINK specialist shops (www.rheinzink.de)
- **WEICON Metal-Fluid** / available in specialist shops (www.weicon.de)
- **Citronex** / available in specialist shops (www.metallit.com)
- **Sika® Remover-208** / available in specialist shops (www.sika.com)

When using cleaning and care products, please observe the manufacturer's processing information and health and safety regulations.

CLEANING RECOMMENDATIONS

6.3 Recommendations for cleaning RHEINZINK-GRANUM

Type of contamination	Step 1	Step 2
Adhesive residues	Basic cleaning	Pronto, or Pledge (SC Johnson Wax) Furniture Polish (Johnson) **
Building dust and dry dirt	Basic cleaning	
Bird droppings, road salt, fingerprints, cement	Basic cleaning	Cleaning alcohol* and repeat step 1
Greasy and oily residues	Basic cleaning	Cleaning alcohol* and repeat step 1
Graffiti and paint on GRANUM-skygrey	Basic cleaning	Graffiti-Remover 1500 from 3M **
Graffiti and paint on GRANUM-basalte	Basic cleaning	It is not possible to remove the paint residue without damaging the surface.
Salt deposits in maritime climate	It is recommended to clean the surface of the material with clean water (not seawater) at least twice a year in maritime climate zones, depending on local conditions.	

* Apply the cleaning alcohol with a cotton cloth.

** Spray the material, allow to sink in for a few minutes, and then carefully wipe off with a cotton cloth. The basic cleaning should then be repeated.

Caution!

Do not carry out cleaning in direct sunlight! In no event should acetone, cellulose thinner or similar solvents or products with an abrasive effect be used to clean the material.

Recommended products

- **Pronto furniture polish (Johnson)** / commercially available
- **Cleaning alcohol** / commercially available
- **Graffiti-Remover 1500 from 3M** / Suppliers via www.3mdeutschland.de

When using cleaning and care products, please observe the manufacturer's processing information and health and safety regulations.

6.4 Recommendations for cleaning RHEINZINK-artCOLOR

Type of contamination	Step 1	Step 2
Light contaminations, fingerprints plaster, mortar, paint residues Building and lime dust, pollen Bird droppings Chimney combustion residues, brown discolouration Rust traces Road salt	Basic cleaning	
Adhesive residues	Basic cleaning	Citronex or Sika®-Remover-208
Heavy contaminations Greasy or oily residues	Basic cleaning	Cleaning alcohol Ethanol Isopropyl
Salt deposits in maritime climate	It is recommended to clean the surface of the material with clean water (not seawater) at least twice a year in maritime climate zones, depending on local conditions.	

Caution!

Do not carry out cleaning in direct sunlight! In no event should acetone, cellulose thinner or similar solvents or products with an abrasive effect be used to clean the material.

Further information and recommendations can be obtained from the GRM (Association for the Cleaning of Metal Façades).

Recommended products

- **Citronex** / available in specialist shops (www.metallit.com)
- **Sika® Remover-208** / available in specialist shops (www.sika.com)
- **Cleaning alcohol, ethanol, isopropyl** / available in chemists

When using cleaning and care products, please observe the manufacturer's processing information and health and safety regulations.

CLEANING RECOMMENDATIONS

6.5 Recommendations for cleaning RHEINZINK-PRISMO

Type of contamination	Step 1	Step 2
Adhesive residues	Basic cleaning	Pronto, or Pledge (SC Johnson Wax) Furniture Polish (Johnson) * **
Building dust and dry dirt	Basic cleaning	
Bird droppings, road salt, fingerprints, cement	Basic cleaning	Cleaning alcohol* and repeat step 1
Greasy and oily residues	Basic cleaning	Cleaning alcohol* and repeat step 1
Graffiti and paint	Basic cleaning	Graffiti-Remover 1500 from 3M * **
Salt deposits in maritime climate	It is recommended to clean the surface of the material with clean water (not seawater) at least twice a year in maritime climate zones, depending on local conditions.	

* Apply the cleaning alcohol with a cotton cloth.

** Spray the material, allow to sink in for a few minutes, and then carefully wipe off with a cotton cloth. The basic cleaning should then be repeated.

Caution!

Do not carry out cleaning in direct sunlight! In no event should acetone, cellulose thinner or similar solvents or products with an abrasive effect be used to clean the material.

Recommended products

- **Pronto furniture polish (Johnson)** / commercially available
- **Cleaning alcohol** / commercially available
- **Graffiti-Remover 1500 from 3M** / Suppliers via www.3mdeutschland.de

When using cleaning and care products, please observe the manufacturer's processing information and health and safety regulations.

7. Maintenance

7.1 General information

RHEINZINK-CLASSIC, RHEINZINK-prePATINA and RHEINZINK-GRANUM are in general low maintenance respectively maintenance-free.

The zinc carbonate patina which forms over time consistently protects the material from corrosive atmospheric pollution. Regular maintenance measures to preserve the material's functionality and durability are not required.

Solely when salt deposits form in areas with maritime climates or road salt reaches the surface in winter it is recommended to clean surfaces regularly.

For the coated product lines RHEINZINK-artCOLOR and RHEINZINK-PRISMO, regular cleaning is required to preserve functionality. In particular, corrosive substances should be removed immediately. Please observe the information in Subsections 5.1 and 5.8 in this regard.

Regardless of the material, gutters must be cleaned regularly, so that blockages do not arise and the rainwater is free to flow away at all times. It is recommended to enter into a maintenance contract with a specialised tradesperson.

The RHEINZINK-Leaf Guard helps reduce maintenance effort. This perforated plate profile, deliverable in 2m lengths, is inserted into half-round gutters of different dimensions and protects securely and durably without any fixing. The leaves remain on the perforated plate, dry there and are mostly blown away by the wind. Coarser dirt does not get into the gutter and is easy to remove. Even with a heavy build-up of leaves and heavy rain, the product's geometry, which is protected by technology, ensures a permanent flow of water, thereby safeguarding the functioning of the roof drainage system year-round.

Special information on patina formation

The patina formation described in Section 2 is dependent on various factors which influence the appearance of the property. Differing impact of rain can, e.g. in the case of varying roof pitches in a property or on the differently oriented façade surfaces, lead to temporary color differences, as the patina forms at different speeds. Over the long-term, the surfaces converge in color.

The situation is different for surfaces which are protected from the rain, e.g. below roof overhangs. Here, permanent color differences may remain.

In the area of soffit cladding, changes to the patina formation may occur in some cases. This can be independent of the size and/or orientation (compass direction) of the soffit. There may be formation of zinc hydroxide. Particularly in maritime climates, salt deposits are to be expected.

MAINTENANCE

7.2 Soiling

The non-coated surface qualities in particular react with their surroundings in a manner typical of the material.

Discolourations, among other things due to greasy deposits or deposits of pollen, may occur. Stains can also be caused by road salt, urine, leaves or by objects such as ashtrays or plant pots being placed on horizontal surfaces.

Bird droppings

Soiling with bird droppings is in general a purely visual defect, which is not relevant for the material's durability.

Removal of the soiling without visually affecting the material should be carried out with water and a soft cotton cloth as soon as possible. If the droppings are allowed to remain on the surface for a longer period, stains may form.



Leaves

In general, leaves or the tannic acid formed by moisture do not affect RHEINZINK materials. However, it cannot be ruled out that visual defects on the metal surface remain after removal of the leaves, both for RHEINZINK-CLASSIC bright-rolled and for RHEINZINK-prePATINA and RHEINZINK-GRANUM.



Please observe the cleaning recommendations for the various surface qualities in Section 6.



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