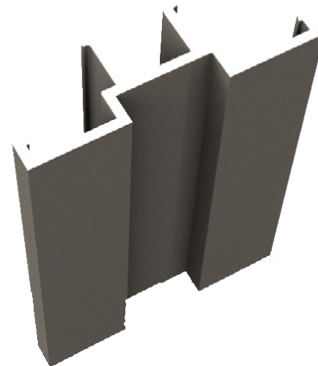
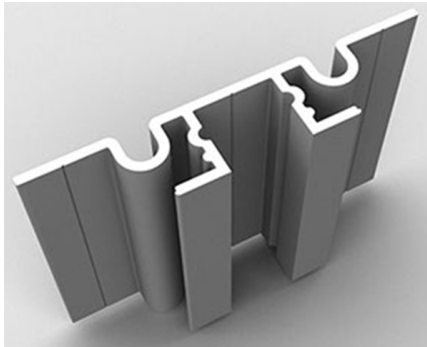


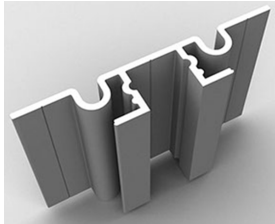
# Estolga® 550 OSCF

## Installation Manual



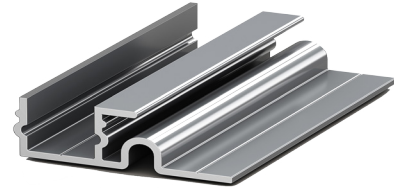
# Estolga® 550 OSCF

## List of Calor Attachment Parts



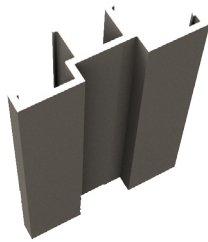
Calor Interior/Exterior Base Attachment

CL550B



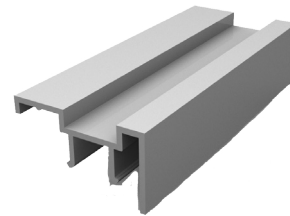
Calor Exterior Starter Attachment

CL550E



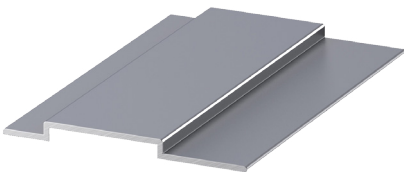
Calor Interior/Exterior Base Attachment Finishing Cap

CL550BF



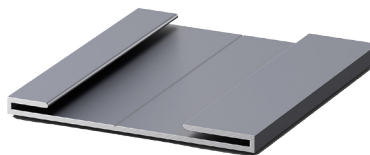
Calor Exterior Starter Attachment Finishing Cap

CL550EF



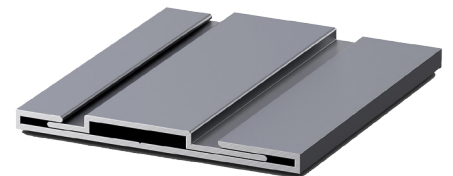
Calor Stiffener Slide

CL550S-A



Calor Stiffener Base

CL550S-B



Calor Stiffener Attachment

CL550S



Calor 3M VHB Tape

CL5503M



Calor #6 1-1/2" Hex Head Screw

CL550HHF

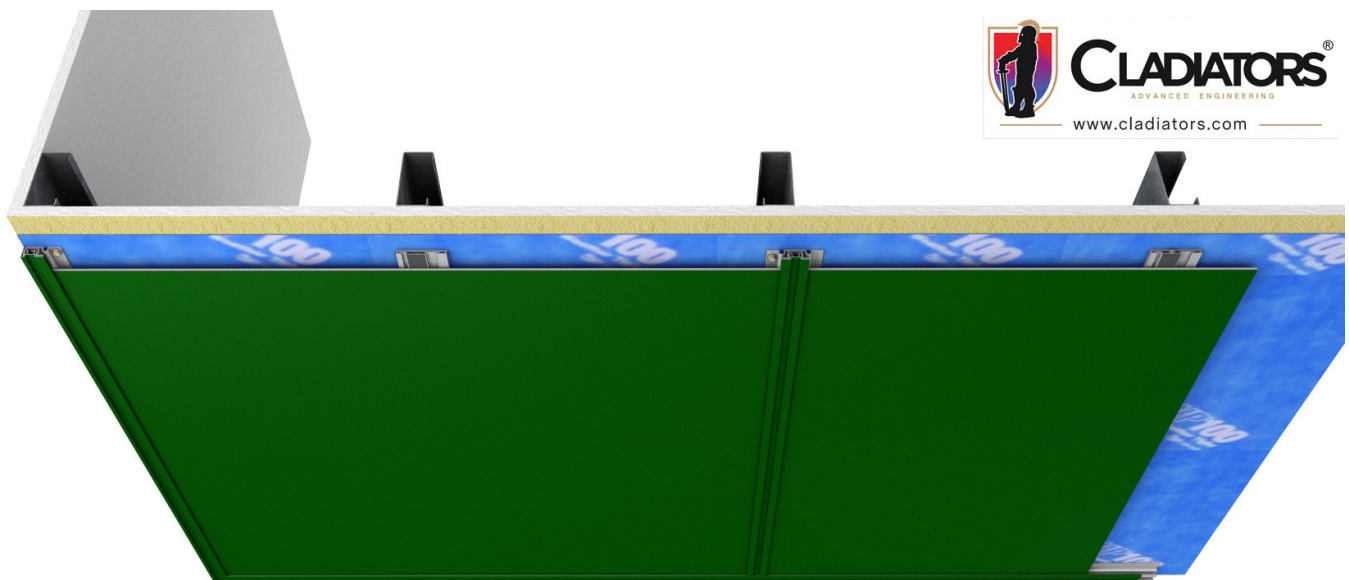
# Estolga® 550 OSCF

## Installation - Overview

Cladiators Calor Wall System is installed modularly. A Calor Starter Attachment is initially installed at the bottom of the wall, and a second Calor Starter 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 levelled and made plumb to the walls. An ACM panel is slid into the attachment slots (if the panel width or height is greater than 32" a Calor Stiffener Attachment is required), and then a Calor 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. A Calor Starter/End Attachment is used at edges of the wall to finish the installation. After all panels and attachments are secured, Finishing Caps are installed.

No panel should have more than 16" of unsupported length, therefore if the panel width or height is greater than 32", a Calor Stiffener Attachment (**CL550S**) is required.

Calor 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**".



# Estolga® 550 OSCF

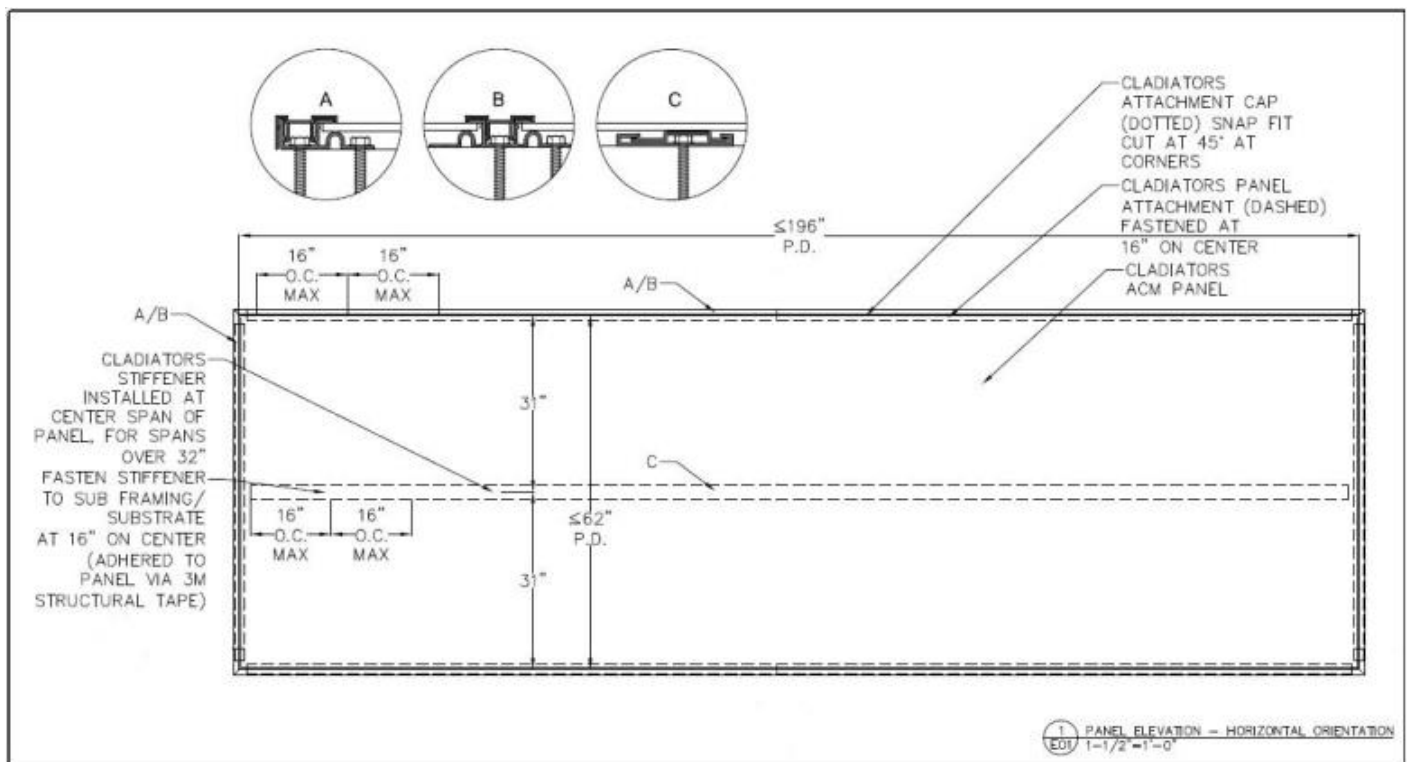
## Installation - Overview, Continued

1. A Calor Starter Attachment (**CL550E**) is installed plumb to the wall and levelled horizontally. This attachment will be the bottom edge of the panel installation.
2. A second Calor Starter Attachment is installed plumb to the wall and levelled vertically. This attachment will be the left or right edge of the panel installation. These two Calor Starter Attachments should join to form a 90 degree angle.
3. Slide the ACM panel into the Calor Starter 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.
4. A Calor 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 Calor #6 1-1/2" Hex Head Fasteners (**CL550HHF**) inserted every 16" on center into the attachment foot.
5. Repeat Step 4 except for the top edge of the panel. The panel is now secured on all 4 sides.
6. Repeat Steps 3-5 until the entire wall is covered in ACM panels that are secured on all 4 sides by Calor Attachments.
7. Finish the span of panels by using a Calor Starter Attachment at the edges of the wall.
8. Install Starter Attachment Caps (**CL550EF**) into the Starter Attachment joints and press firmly until the cap snaps into the Starter Attachments (**CL550B or CL550E**). Install Base Attachment Caps (**CL550BF**) into the Base Attachment joints and press firmly until the cap snaps into the Base Attachments. Optionally the Caps can be slid into the attachment joints.

# Estolga® 550 OSCF

9. Use stiffeners according to below indicated dimensions and panel lay out types. Cladiators Aluminum Composite Metal Sheet Standard Size is 62" x 196"

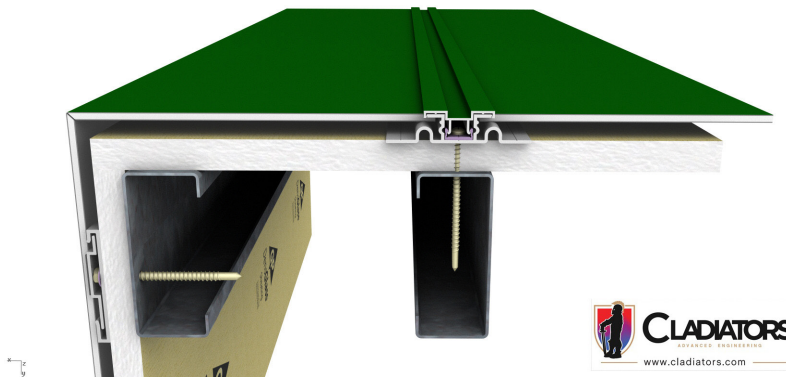
- **Horizontal Panel Layout:** Install Cladiators Stiffener horizontally at center span of panel, for spans over 32". Fasten stiffener to sub-framing / substrate at 16" on center (adhered to panel via 3M structural tape). See below Cladiators Maximum Panel Size for Horizontal Layout.





# Estolga® 550 OSCF

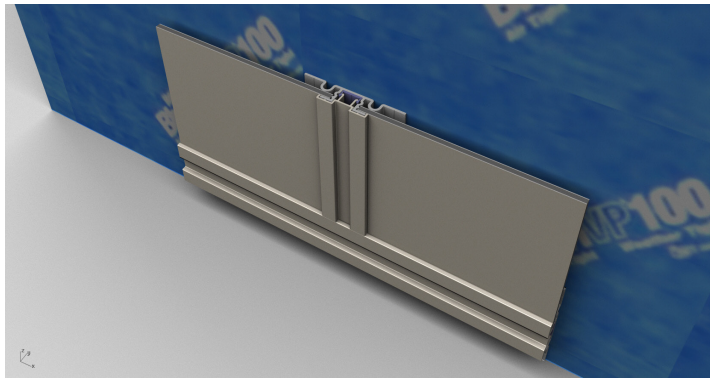
## Starter Attachment with Joint



1. The Calor Starter Attachment (**CL550E**) is installed plumb to the vertical wall and leveled.
2. The edge of the Starter Attachment Finishing Cap should be flush with the edge of the wall. This requires that the Starter Attachment be installed with an offset of 0.1 inches from the edge of the wall to leave room for the Cap edge.
3. Secure the Starter Attachment to the wall with Calor #6 1-1/2" Hex Head Fasteners (**CL-550HHF**) inserted every 16" into the attachment foot.
4. Install the ACM panel into the Starter Attachment slot. Ensure that the ACM panel is slid entirely into the attachment slot.
5. Insert the Starter Attachment Cap (**CL550EF**) into the Starter Attachment joint and press firmly until the cap snaps into the Starter Attachment. Alternatively, the Caps may be slid into the attachment joints.

# Estolga® 550 OSCF

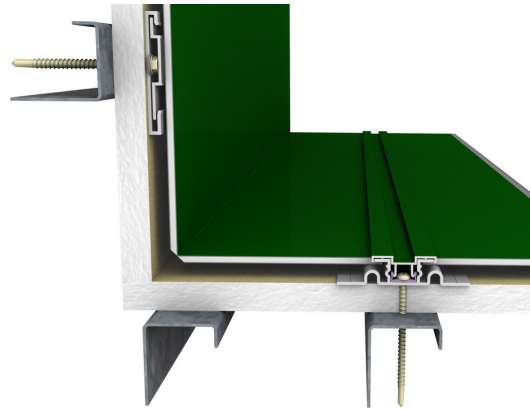
## Base Attachment



1. The Calor Base Attachment (**CL550B**) is installed plumb to the vertical wall and leveled.
2. Secure the Base Attachment to the wall with Calor #6 1-1/2” Hex Head Fasteners (**CL550H-HF**) inserted every 16” into the attachment foot.
3. Install the ACM panels into the Base Attachment slots. Ensure that the ACM panel is slid entirely into the attachment slot.
4. Insert the Base Attachment Cap into the Base Attachment joint and press firmly until the cap snaps into Base Attachment. Alternatively, the Caps may be slid into the attachment joints.

# Estolga® 550 OSCF

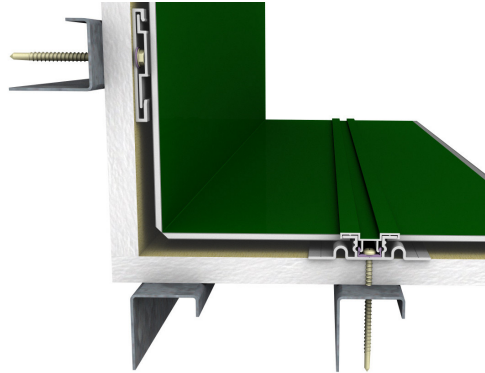
## Inside Corner using Stiffeners



1. 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.
2. Two Cladiators 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 Cladiators #6 1-1/2” Hex Head Fasteners (**CL550HHF**) every 16”.
3. The Cladiators Stiffener sliding connector (**CL550S-A**) is inserted into the Cladiators Stiffener base, and then the sliding connector is pushed into the “unlocked” position.
4. 3M tape strips (**CL5503M**) of at least 1” in length are installed onto the face of the Cladiators Stiffener sliding connector, and the tape’s protective film is removed.

# Estolga® 550 OSCF

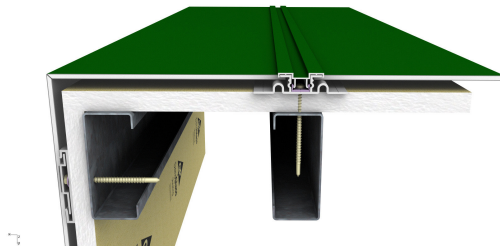
## Inside Corner using Stiffeners, Continued



5. 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.
6. 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 Slider 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.

# Estolga® 550 OSCF

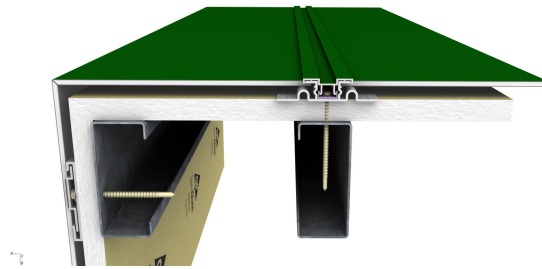
## Outside Corner using Stiffeners



1. 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.
2. Two Cladiators 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 Cladiators #6 1-1/2” Hex Head Fasteners (**CL550HHF**) every 16”.
3. The Cladiators Stiffener sliding connector (**CL550S-A**) is inserted into the Cladiators Stiffener base, and then the sliding connector is pushed into the “unlocked” position.
4. 3M tape strips (**CL5503M**) of at least 1” in length are installed onto the face of the Cladiators Stiffener sliding connector, and the tape’s protective film is removed.

# Estolga® 550 OSCF

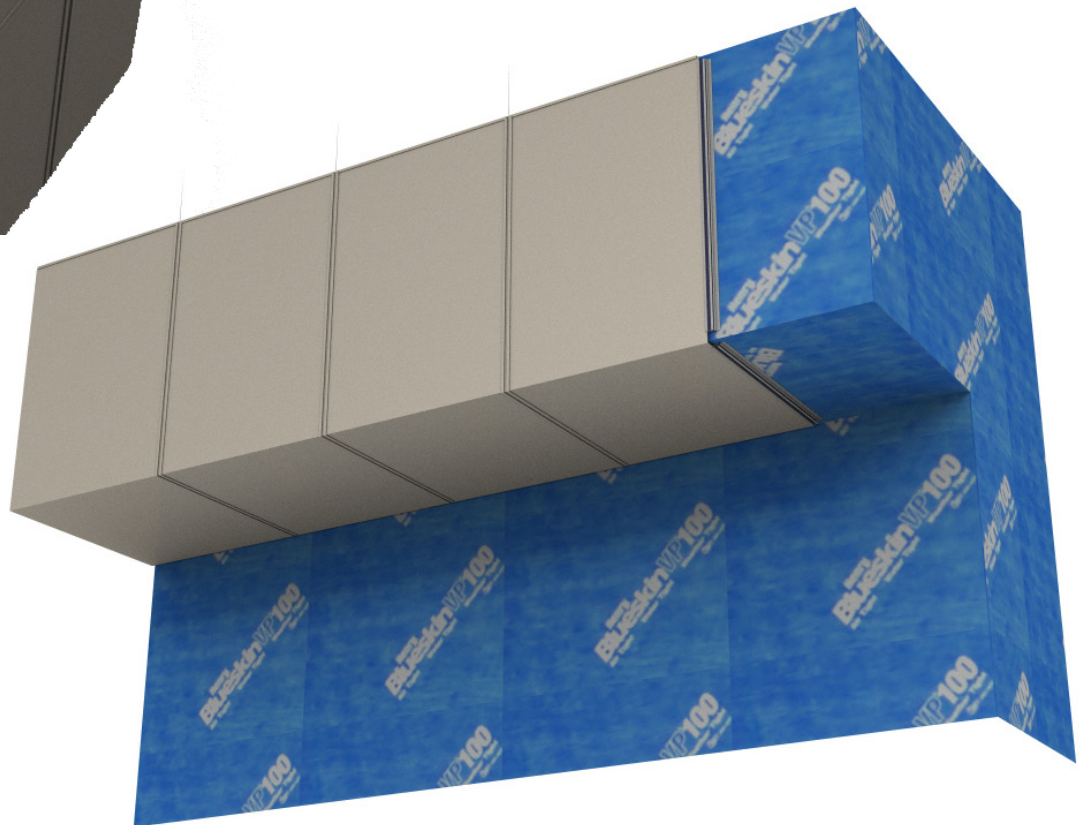
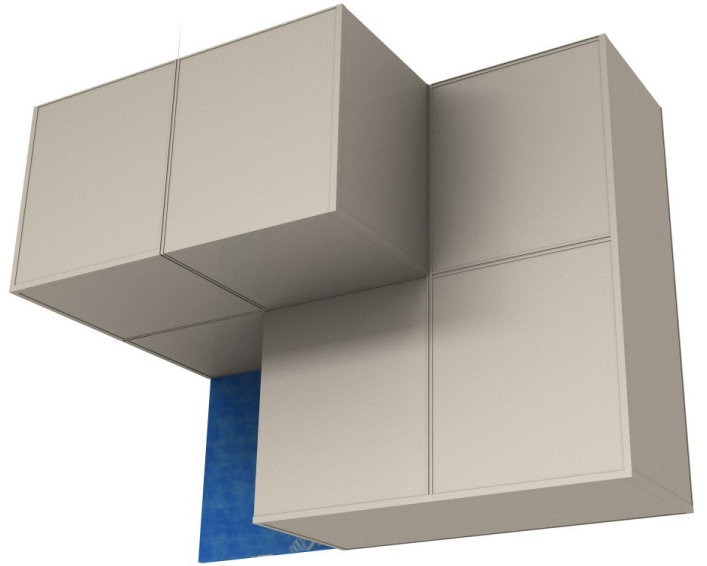
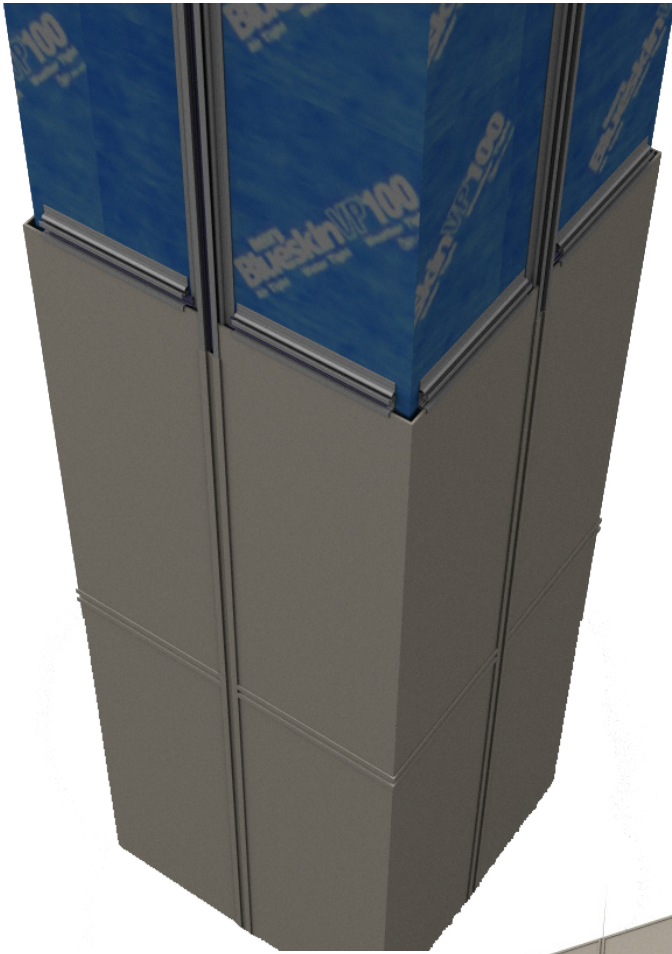
## Outside Corner using Stiffeners, Continued



5. 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.
6. 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 ACM will adjust within the Stiffener Base until the Stiffener Slider 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.

# Estolga® 550 OSCF

## Typical Installations



# Estolga® 550 OSCF

## Typical Installations

