



**MAZZONETTO Spa**  
Via A. Ceccon, 10 - 35010 Loreggia (PD)  
t. +39 049 9322611 - f. +39 049 9322650  
mazzonetto@mazzonettometalli.it  
www.mazzonettometalli.it



## MANUAL FOR STORAGE, HANDLING, USE AND MAINTENANCE OF METAL ROLLS: BASIC RULES

### PRODUCTS CONCERNED:



The prepainted material is a high-technology product, manufactured and tested in compliance with current quality standards. It is delivered to the user in packaging appropriate to its supply status.

The following recommendations are intended to help the user to get maximum benefit from the factory quality of the product and to ensure that the product reaches the end customer in good condition.

This manual has been compiled based also on the experience of suppliers and the ever-increasing number of users.

### Transport

As with untreated material, the pre-coated product is sensitive to the effects of moisture and condensation.

Consequently, transport must be effected in such conditions as to protect the material from steam and moisture on the one hand and from mechanical damage and abrasion on the other.

Upon delivery it is advisable to check the condition of the packaged material and note any damage from mechanical impact or water infiltration.

### Storage

The prepainted material must be protected from humidity, rain and the risk of creation of condensation.

Warehouse storage conditions should ideally be ventilated and moderate.

Care should be taken to prevent the product from being exposed or coming into contact with corrosive products, such as chemicals, solvents or toxic fumes. On site, the above conditions must also be maintained as much as possible. During storage, however, the material must be afforded maximum protection from steam and humidity.

When the material is stored outdoors, it is advisable to perform the following procedures:

- Store the sheets on an inclination so as to allow drainage;
- Leave a space of at least 15 cm between the base of the packaging and the ground, so as to ensure good ventilation;
- Ensure that the material is not completely enveloped by plastic coverings in order to maximise air circulation and thus help prevent the formation of condensation zones;
- In case of long-term storage, the material should be checked periodically. If humidity is found to be present, the packaging must be opened and the rolls separated and thoroughly dried.
- If the protective film is removed, you must pay due attention to manufacturer-specified time limits, the type of peelable and the recommendations regarding method and duration of storage.

### Handling

Prepainted material can be handled like any other laminate. Nevertheless, it is important to remember that the surface is that of a finished product, which is why it requires the same attention as given to a finished product ready for delivery to the end user.



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### On construction sites

When the material is handled by lifting systems, please pay particular attention to the protection of the sides and the bottom part. It is advisable to use nylon (or neoprene coated) strips or belts; but it is not advisable to use unprotected steel cables. In case of forklifts, please use specific attachments for the coil handling and lifting. During assembly, metal particles produced by blanking, cutting, drilling or printing should be removed with care to avoid the formation of incrustations on the painted surface. It should also be remembered that superficial damage caused during different operations can be largely avoided with the use of protective films. It is important, however, that such protective film be removed within 8 days of laying the product.

### In the workshop

The recommendations above are also applicable in the workshop. The prepainted laminate should be handled with the same care as given to finished products. Also, you should bear in mind the following points:

- equipment must be cleaned and surfaces in contact with the sheet must be smooth and free of irregularities;
- the containment cradles for the prepainted roll must be suitably robust and able to support heavy rolls without risk of damage to surfaces;
- the rolls of prepainted material should be protected against damage to surfaces and corners and under no circumstances must be rolled on the ground;
- if the rolls are stored on the ground after unpacking, they must be placed on felt so as to avoid damage from uneven ground or other factors, which may render the first coil unusable;
- overlapping the rolls is not recommended;
- at the time of cutting to open the rolls and packing, you should avoid any kind of pressure that could impair further coils. If such pressure cannot be avoided, you will have to position some fibreboard – or similar material – to protect the painted surface.

When unpacking is done manually, you must ensure that the surface is not scratched.

Once the strip is cut into sheets, you must ensure that they do not rub against each other. If the sheets are deposited on the ground in the workshop, they must be placed with the rear side down and then with the other side down. Pressure can be decreased by the insertion of reinforced paper between one sheet and another; this will also help avoid surface damage caused by burrs or sheared corners. It is advisable to wear clean, dry gloves.



## Workability

The laminate has excellent ductility and can be bent to make folds up to 180°. To avoid micro cracks and lesions appearing in the coating, it is essential to observe a few simple rules (applicable to any coated laminate):

- avoid marking the laminate with awls or any other tool that may mark or scratch the coating;
- create rounded and not sharp or crushed folds; create folds with inner curvature radius as indicated in the data sheet.

Indice ECCA*	Schema
0T	>100
0,5T	≈50
1T	≈33
1,5T	≈25
2T	≈20
2,5T	≈17

\* ECCA: European Coil Coating Association

Information on product specifications and in particular on the workability of laminates are available on the data sheets available on the website [www.mazzonettometalli](http://www.mazzonettometalli)

## Behaviour with other metals

During installation of roofing, facades and roof accessories, all precautions must be taken to avoid the direct contact of two metals with different chemical potential, especially if this difference is considerable. Contact typically is likely to occur when finishing works are carried out, especially the installation of gutters or downspouts made of metal other than that used in the manufacture of the cover plates.

## Removal of peelable film

Peelable film is sensitive to UV radiation and temperature; after long periods of exposure to sunlight and/or temperature variations, the glue hardens and the film becomes much more difficult to remove. For this reason it should be removed as soon as possible on site, ideally within eight days of laying.



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### Tips

Carefully cut the film in those parts that will become inaccessible after processing or installation. Remove beforehand those parts of the film that will be "trapped" during processing or in installation slots in metal pieces.

### Behaviour with temperature changes and direct flame

Laminate can be stored at very low temperatures without risk of damage because it is a material that is not subject to frost. Unlike other metals it can be bent even at low temperatures without the risk of micro cracks forming. It is recommended however that the material be processed at temperatures above 0° C so as not to damage the coating.

The laminate should under no circumstances be put in contact with direct flame; high temperatures can irreversibly damage the material.

### Maintenance

Roofing, cladding and roof accessories generally must be checked at regular intervals. It is therefore advisable to strike an inspection and maintenance agreement to ensure regular controls and component monitoring. The sooner any changes or damage is discovered, the more you can reduce costs for repairs or other maintenance measures, as well as the expenses incurred in resolving the causes of damages. The inspection consists of checks by specialised personnel to determine the current state of the material, particularly with regard to dirt deposits, plant growth, corrosion damage and cracking; checks are also made on the functionality of installed components.

If storage takes place in industrial environments, or where there are large quantities of fine particulates that can settle on the outer surface of the laminate, surface cleaning can be performed with water and a mild detergent.

Particular attention must be paid to the environment in which the product is installed. In environments with intense weather conditions combined with exposure to industrial and/or marine environments, exacerbated by the effects of forces such as abrasion, high temperature and humidity conditions, contact with sea water, etc., the customer must carry out checks and in-depth technical analysis before using the product.