



## REVEAL PANEL

System Technology for Facades



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12th edition

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## Foreword

This document describes the use of RHEINZINK-Reveal Panels. Although it forms the basis for proper planning and classical application solutions, it is no more than a guide for users. The detailed drawings included here describe solutions which are feasible at a practical level.

We should like to explicitly point out that in actual practice it may not be possible to create the type of cladding illustrated in this document – or not to their full extent. In this context every situation should be examined in detail by the planner in charge. It is necessary here to take account of the system-specific effects on the property and local/climatic conditions as well as the requirements in terms of building physics. Compliance with the application techniques and specifications described here does not release users from any responsibility in this regard.

This document is based on our practical experience and represents the latest findings from research and development, recognised standards and state-of-the-art technology. We reserve the right to make changes at any time in the course of further development.

If you have any queries or suggestions, please contact your customer advisor or get in touch with your local RHEINZINK sales office. All contact data can be found on our homepage

**[www.rheinzink.com/contact](http://www.rheinzink.com/contact)**.

For an overview of our sales offices see page 44 of this document.

Datteln, October 2019



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PRODUCT LINES



**ONE BRAND – 3 PRODUCT LINES**

**A perfect solution  
for every requirement**

To give you even more design freedom, we offer our material in three different product lines and in numerous finishes. You get the perfect solution for every requirement with the trusted RHEINZINK quality. All products exceed the high standards of EN 988 and the TÜV QUALITY ZINC criteria. The high level of manufacture is guaranteed by constant inspections and extensive laboratory tests. On this double page, we have summarised the characteristic features of our three product lines. On request, we will gladly send you samples of material.

**RHEINZINK-CLASSIC**

**The natural material  
in its most original form**

RHEINZINK-CLASSIC is the most original of all material options. The bright rolled version has proven itself for over 50 years of application. Depending on the weather conditions, over time a typical blue-grey patina is formed on the naturally shiny metallic surface. The patina gradually becomes more and more distinctive and develops a unique surface character.

**Surface quality:**

RHEINZINK-CLASSIC® bright rolled

**RHEINZINK-artCOLOR**

**Unlimited design in a variety of  
colours**

RHEINZINK-artCOLOR is the coloured version for roofing and facade cladding. A durable coating allows a wide range of colours and opens up a variety of design options for architects, planners, builders and trade customers. Classically elegant, contemporary avant-garde, contrasting or tone-on-tone. If you have a special colour requirement, we will be happy to produce RHEINZINK-artCOLOR in the shade of your choice.

**Surface qualities:**

- RHEINZINK-artCOLOR® black-grey
- RHEINZINK-artCOLOR® pure-white
- RHEINZINK-artCOLOR® pearl-gold
- RHEINZINK-artCOLOR® moss-green
- RHEINZINK-artCOLOR® nut-brown
- RHEINZINK-artCOLOR® blue
- RHEINZINK-artCOLOR® tile-red



prePATINA



prePATINA

#### THE WORLD'S ONLY NATURALLY PRE-WEATHERED SURFACES

Only RHEINZINK has a special process in which the blue-grey or graphite-grey colour of the natural patina is achieved naturally in production. As the inventors, we called this unique pickling process "pre-weathering". Virtually imperceptible to the human eye, atmospheric influences over time create a natural protective patina that reliably protects the product. In production, any use of artificial coatings, varnishes or phosphating is avoided completely. The prePATINA line products are the only ready-made natural surfaces in the entire global zinc construction market.

#### Surface qualities:

RHEINZINK-prePATINA® blue-grey  
RHEINZINK-prePATINA® graphite-grey

Natural weathering compensates for any installation-related scratches. Only the RHEINZINK-prePATINA and the RHEINZINK-CLASSIC lines offer this self-healing effect. They are environmentally friendly and absolutely maintenance-free.

**100% SELF-HEALING**  
**100% MAINTENANCE-FREE**  
**Only available from RHEINZINK**

MATERIAL

**1. Material RHEINZINK  
Titanium Zinc**

**1.1 Alloy and Quality**

RHEINZINK is titanium zinc according to DIN EN 988. The RHEINZINK alloy consists of electrolytically refined zinc according to DIN EN 1179 with a purity grade of 99.995% and precisely determined proportions of copper and titanium.

All RHEINZINK products are certified according to DIN EN ISO 9001:2008 and are subject to a voluntary inspection by TÜV Rheinland according to the strict QUALITY ZINC criteria catalogue (please request free of charge).

**Ecological Relevance**

RHEINZINK is a natural, 100% recyclable material that has always complied fully with today's strict ecological requirements. The latest production facilities, sophisticated logistics and favourable processing properties are available. Environmentally-conscious action is documented through the introduction of the environmental management system ISO 14001:2004. It is checked and certified according to TÜV Rheinland. We also document responsible action in regard to the environment through the introduction of an energy management system according to ISO 50001:2011. It is our intention to save as much energy as possible, to save resources and to keep the environmental impact of our products as low as possible.

**Aspects of ecological Assessment**

According to the holistic assessment from the Institute for Construction and Environment e.V., RHEINZINK is declared an environmentally friendly construction product according to ISO 14025, type

III (EPD) and EN 18504 „Sustainability of construction works. Environmental product declarations“. The examination of the environmental and health compatibility criteria also includes the entire life cycle of RHEINZINK products, from the raw material extraction to processing and use to recycling and disposal. It is based on a life cycle assessment according to ISO 14040 (LCA) (please request the certificate free of charge).

**Electromagnetic Radiation is safely shielded**

There is much public controversial debate about electromagnetic radiation. The International Society for Electromog Research (IGEF e.V.) has provided information here on RHEINZINK's shielding properties. The result: Over 99% of electromagnetic smog present is shielded. Biological measurements on people confirm the technical measurements and show a harmonising effect on heart, circulation and the nervous system. Body relaxation increases.

**Remaining Values**

With a service life that spans several generations, RHEINZINK is a material that sets new standards. The 30-year guarantee highlights the durability of the 100% recyclable material. This offers additional protection.

**1.2 Marking**

*RHEINZINK sheets and coils:*  
Recognisable by the consecutive coloured stamping on the metal underside.

*RHEINZINK-Roof Drainage Products:*  
Recognisable by the brand embossing.

*RHEINZINK-Roof Drainage Accessories:*  
Recognisable by the brand embossing.

*RHEINZINK-Palette Identification:*  
Recognisable by the packaging label with detailed product data.

**1.3 Material Properties**

- Density (spec. weight) 7.2 g/cm<sup>3</sup>
- Melting point approx. 420 °C
- Expansion coefficient:  
in a longitudinal rolling direction: 2.2 mm/m x 100 K  
in a transverse rolling direction: 1.7 mm/m x 100 K
- Typical joining techniques: seaming, soft soldering, bonding, screwing, riveting
- Non-magnetic
- Non-combustable
- Electromagnetic radiation shielding
- Recyclability 100%
- High recycling rate
- Assured material cycle
- Environmentally compatible (EPD)
- Natural material
- Low energy use
- Long service life
- Vital trace element
- Extensive resources

Metal thickness (mm)	Weight (kg/m <sup>2</sup> )
0.70	5.04
0.80	5.76
1.00	7.20

*RHEINZINK weight according to Metal thickness in kg/m<sup>2</sup> (Numbers are rounded)*



A



B



C



D

**1.4 Patina Formation**

On the natural RHEINZINK-prePATINA surface forms a bonded natural patina in the atmosphere. In so doing all the environmental influences from the air and rain water are integrated into the surface development. The material surface is maintenance free and as a natural product does not require care or cleaning. When using the natural RHEINZINK-prePATINA line surfaces in areas subject to a marine climate, white deposits may develop on the surface due to the salt in the atmosphere. These natural deposits integrate into the natural patina and because of the colour contrast, are more visible on the darker, RHEINZINK-prePATINA graphite-grey surface. This will not affect the function or expected service life of the material when used on facades, roofs or other cladded building components. The natural patina will appear lighter when used in locations where the air contains chlorides. When used in environments where sulphur levels are higher, (e.g. industrial pollution), the patina may appear somewhat darker than usual.

**1.4.1 RHEINZINK-CLASSIC bright rolled**

Application for all sheet metal work in seaming and soldering techniques. Natural patina forms at different times depending on the application or roof pitch. In areas protected from rain water e.g. beneath eaves or on roof edges sometimes only after a few years.

**1.4.2 RHEINZINK-prePATINA blue-grey and graphite-grey**

The pre-weathering process was developed by RHEINZINK 25 years ago especially for use in areas where a "finished" picture of the RHEINZINK surface is desired even at the hand-over of keys. This process allows the production of colour of a natural patina although the natural patina itself only forms after installation.

RHEINZINK is the only manufacturer world wide who uses this unique pre-weathering process. The use of a pickling process compared to a coating or phosphating process has two distinct advantages: Pickling gives the surface the appearance of a genuine patina, something that only occurs otherwise after a long time through natural influences. Pickling produces an even colour tone but is not comparable however with a RAL shade. A protective coating applied to the surface achieves temporary protection for storage, transport and processing. This protective film makes oil-free forming possible for processing in the profile roll forming machines.

The RHEINZINK quality prePATINA graphite-grey is the dark alternative and may, after a few years during the formation of patina and depending on the regional climate, develop a slight dark green sheen as with slate.

During the pickling process other natural surface properties are preserved - the surface remains solderable. The visible "Ageing with dignity" is not prevented by pre-weathering and has proved its worth in practice over many decades. The material largely reduces the typical reflections of the surface of thin sheets (oil canning).

**1.4.3 Information about Processing**

In order to avoid surface reactions from excessive sweating from the skin and other impurities caused by the building site, oil-free clean textile gloves should be worn.

Suitable products can be found at [www.rheinzink.de/werbemittelshop](http://www.rheinzink.de/werbemittelshop)



**1.4.4 Surface Uniformity**

We make every effort to supply profiles with surface uniformity. Production-related slight differences can occur, which are purely of appearance in nature and which, in the prePATINA line, usually even out during the formation of patina. In order to exclude specific product-related visual imperfections, particular requirements should be requested with respect to surface uniformity.



\* environmental label for building products recongnized by the German Federal Environmental Agency

MATERIAL

**1.4.5 Protection during Transportation and Installation**

To protect the surface during the transport, storage and installation our façade profiles and also our surface quality art-COLOR line are delivered with a protective plastic film. It also protects against negative influences during the construction phase.

The foliation is a self-adhesive protective plastic film that is applied at the factory and is exposed during installation to UV radiation and temperature variations. If this exposure continues for a long time, the properties of the film may change and cause adhesive residues on the metal surface. To avoid these changes, we recommend removing the film immediately after the installation process. The film should be removed at once from the surface as moisture could be hold back at loose film edges. This could cause visual imperfections (formation of zinc hydroxide).

**1.4.6 Information on Wave Formation Strip Material**

A characteristic surface phenomenon with strip material is the typical slight wavy structure of thin sheet metal.

These waves form because of the reaction of a natural material to the winding and unwinding process in the factory and the corresponding reworking (profiling etc.) during workshop preparation and installation.

The surface finish CLASSIC bright rolled emphasises the changing appearance because of light reflection. With increasing patination this perception reduces. If from the start e.g. for facades and roof surfaces, a high grade appearance is desired, we recommend, the surface finishes prePATINA blue-grey or prePATINA graphite-grey.

**Sheet Material**

An improved evenness is obtained by using sheet material, which RHEINZINK can manufacture and supply at lengths up to 6 m. The measurement of corrugations is subject to strict controls and must not exceed the value defined under DIN EN 988 (max. 2 mm per metre). The RHEINZINKworks standard prescribes for each metre of sheet length e.g. max. 1 wave 1 mm in height

**1.5 Response to external Influences**

**1.5.1 Influence of other Metals placed on Top**

Unproblematic:

- Aluminium, shiny or coated
- Lead
- Stainless steel
- Galvanised steel (rust streaking possible, e. g. caused by unprotected cut edges)

Problematic:

- Copper

**1.5.2 Influence of other Building Materials placed on Top**

Problematic:

- Unprotected bitumen roof sheeting without grit layer/gravel fill (acid oxidation)
- PVC roof sheeting (hydrochloric acid emissions)

**1.5.3 Influence of other substances incl. Mortar**

- Mineral-based materials such as chalk, cement or plaster plus moisture have a corrosive effect on metals.
- A suitable separating layer must be fitted between RHEINZINK building profiles and these building materials.
- Installation sequence: Plasterwork prior to RHEINZINK (if possible use material with plastic film)

**1.5.4 Effect of Oil Heating**

Discolouration on RHEINZINK surfaces can occur in the case of oil-driven heating systems because of the ingredients of the heating oil and additives. Such discolouration is more or less visible on all covering materials and has no influence on the durability of the roofing.

**Note:**

The builder must be informed about this situation. With gas-operated plants, discolouration is not expected.

**1.5.5 Base and Splash Water Areas, Rock Salt**

At base areas splash water can cause staining and disturb the patination process. Rock salt in connection with moisture has a corrosive effect on metals. Therefore facade claddings should be installed with a sufficient space to the ground, not less than 30 cm as a rule.

## 1.6 General Processing Principles

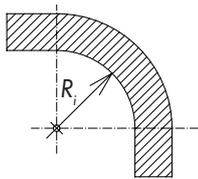
### 1.6.1 Marking

Mark using soft pens and not sharp pointed objects (scribing tool, pocket knife).

### 1.6.2 Forming/Radii of Curvature

Zinc and its alloys are anisotropic, which means they have different properties parallel and crosswise to the rolling direction.

The mechanical effect of this anisotropy is reduced to such a degree with RHEINZINK through the alloy and rolling process, that RHEINZINK independent of the rolling direction can be folded at 180° without incipient cracking.



Material thickness	Radius of curvature $R_i$ minimum
1.00 mm	1.75 mm
1.20 mm	2.10 mm
1.50 mm	2.63 mm

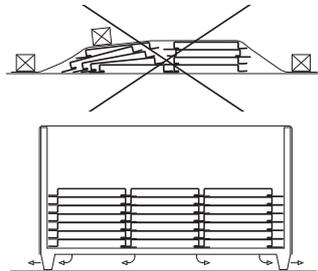
Recommended radii of curvature (inner radius) for RHEINZINK

### 1.6.3 Length Change caused by Temperature

With coverings, roofs, and facade cladding (panel length), sheet metal work and roof drainage (profile length), changes in length caused by temperature (expansion and contraction) must be taken into account in the design. In particular for penetrations, corners, joints and other transitions, the right design measures must be implemented; e.g. panels or profiles must be installed stress-free from the expansion technology perspective.

## 1.7 Storage and Transportation

RHEINZINK products must always be stored and transported in dry and ventilated conditions.



Storage and Transportation (Schema)

### Note:

**Container storage is the best method for optimum storage at the building site. If necessary request a dry and well-ventilated room from the building management. Do not place covers directly over the material as this can cause moisture or rain water to penetrate between the profiles and in the absence of ventilation lead to deterioration in appearance because of the formation of zinc hydroxide.**

## 1.8 Structural Physics

- Weather protection
- Moisture regulation
- Thermal economy
- Rear ventilation
- Sound proofing/fire protection

The rear-ventilated facade is a multi-layered system, which, when designed properly, guarantees permanent functional capability. By functional capability, we mean that all requirements pertaining to structural physics are met. This is described in detail below.

By separating the rain screen facade from the thermal insulation and supporting structure, the building is protected from the weather.

The supporting outer walls and the insulation remain dry and thus fully functional. Even when driving rain penetrates open joints, it is quickly dried out as a result of the air circulation in the ventilation space.

The bracket-mounted rear-ventilated facade protects the components from severe temperature influence. Heat loss in the winter and too much heat gain in the summer are prevented.

Thermal bridges can be reduced considerably.

## 1.9 Windproof Building Envelope

This does not apply to the rear-ventilated facade, as this component itself cannot be windproof.

The building must be windproof before the rear-ventilated facade is installed. A solid brick or concrete wall will ensure that the building is windproof. Penetrations (e.g. windows, ventilation pipes, etc.) must be sealed from the building component to the supporting structure. In the case of a skeleton construction, the wall surface must also be sealed.

If the building envelope is improperly sealed (wind suction, wind pressure), there is a high degree of ventilation/energy loss, which, along with drafts, creates unpleasant room temperature. Dew or condensation can be expected on the leeward side of the building.

Air circulation in the room should be provided through air conditioning or by opening the windows.

### MATERIAL

#### 1.10 Weather Protection

Rear-ventilated facade cladding protects the supporting structure, the water-proofed thermal facade insulation, and the substructure, from the weather.

Bracket-mounted rear-ventilated facade provide a high degree of protection from driving rain.

Because of the physical structure, it is impossible for the rain or capillary water transfer to reach the insulating layers. Furthermore, moisture can always be drawn out through the ventilation space. This allows the insulating layers to dry out quickly, without impeding thermal insulation.

#### 1.11 Moisture

Rear-ventilated facade cladding provides protection from driving rain and moisture. Moisture penetration as a result of diffusion does not occur in the rear-ventilated facade.

When the supporting structure is wind-proof, the diffusion current density is too small to cause the dew point temperature to drop.

#### 1.12 Thermal Economy

In order to understand the thermal economy of the rear-ventilated facade, we must first consider the various heat flow rates, as well as the air exchange between the rear-ventilation space and the outside air, separately, in terms of structural physics.

##### 1.12.1 Thermal Insulation

In the winter, heat flow from the inside to the outside is referred to as a heat transfer co-efficient (U-value).

The smaller the value, the smaller the quantity of heat escaping to the outside. The U-value is determined by the heat conductivity of the thermal insulation and insulation thickness.

The high-grade thermal insulation is a contribution to environmental protection and pays for itself in a relatively short period of time through low heating costs.

##### 1.12.2 Summer thermal Insulation

Summer thermal insulation should provide comfort: The amount of heat flowing from the outside to the inside should remain as small as possible. Proper thermal insulation, as well as a certain mass in the construction itself, will help to achieve this objective.

The advantage of a bracket-mounted, rear-ventilated facade, is that a large portion of the heat which streams onto the cladding is diverted through convective air exchange.

##### 1.12.3 Thermal Bridges

Thermal bridges are elements of the building envelope, that have high thermal conductivity (have high U-values) and are continuous from the warm side to the cold side of the thermal insulation. Apart from general design-dependent thermal bridges of a building, e.g. protruding balconies, the installation of the substructure must be taken into account in the case of a rear-ventilated facade. Thermal bridges can be reduced significantly by installing an insulating strip between the supporting structure and the substructure (thermal break).

Proper installation of the insulation reduces the formation of thermal bridges.

#### 1.13 Fire Protection

Metal facades with a metal substructure and appropriate fasteners meet the highest requirements for non-combustibility (Building Material Class A1, DIN 4102). In the case of bracket-mounted, rear-ventilated facades, it may be necessary to install firestops.

#### 1.14 Rear-Ventilation

The free ventilation cavity between the facade cladding and the layer behind it must be at least 20 mm. Tolerances and plumbness of the building must be taken into account. In some places, this rear-ventilation space may be reduced locally up to 5 mm – e.g. by means of the substructure or the unevenness of the walls.

##### 1.14.1 Air Intake and Exhaust Openings

The rear-ventilation space requires intake and exhaust vent openings. These openings must be designed so that their functionality is guaranteed for the lifetime of the building. It cannot be hindered through dirt or other external influences. The openings are located at the lowest and highest point of the facade cladding, as well as in windowsill and window lintel areas, and penetrations. In the case of higher, multi-storey buildings, additional intake and exhaust vent openings should be provided (e.g. at each floor).

#### 1.15 Soundproofing

To prove that a facade design is sound-proof, the entire wall structure, as well as each building component (windows, etc.) must be defined. The use of proper static fasteners will prevent any potential noise development as a result of the cladding.

**2. RHEINZINK Profile Group  
Reveal Panel SF 25**

The reveal panel opens up a wealth of design possibilities for the designer, because it can be installed vertically and diagonally. Variable spacing of the reveal joints (0-30 mm) underscores segmentation when the reveal panel is used. The reveal panel is available in widths of 200-333 mm.

**Technical Approval**

The RHEINZINK-Reveal Panel System is subject to EN 14782 and is approved for use with substructure spacing  $\leq 1.00$  m (other support spacing possible on request). In Germany the facade system is additionally governed by the Con-

struction Products List B, Part 1 (edition 2015/2), section 1.0 relating to construction products subject to harmonised standards according to the Construction Products Directive, section 1.4.10.1 Self-supporting roof covering and wall cladding elements for interior and exterior application made of sheet metal.

**Static Load Tables**

Load tables are based on DIN 18807 for profile section properties.

Deflection:

1/180 for facade components

Safety factor:

$g = 1.50$

(this is taken into account in the tables)

**Units for Loads and Forces**

The load tables indicate permissible forces and loads in  $kN/m^2$ .

Deflection values in relation to span width are given for single span, double span or multi-span conditions.

The following indicators are used for display purposes:

- Single span
- Double span
- Multi-span

Span width in m		0.50	0.60	0.80	0.90	1.00	1.20	1.40	1.50	1.60	1.70
Permissible wind load in $kN/m^2$	■			3.50	3.14	2.83	2.36	2.00	1.89	1.78	1.67
	■ ■	2.20	1.85	1.42	1.28	1.14	0.95	0.86	0.82	0.77	0.73
	■ ■ ■	2.50	2.14	1.56	1.41	1.30	1.09	0.95	0.91	0.87	0.83

SF 25 - 200,  $s = 1.00$  mm

Span width in m		0.50	0.60	0.80	0.90	1.00	1.20	1.40	1.50	1.60	1.70
Permissible wind load in $kN/m^2$	■			2.83	2.50	2.27	1.89	1.62	1.49	1.40	1.32
	■ ■	1.78	1.48	1.14	0.99	0.93	0.82	0.70	0.65	0.59	0.53
	■ ■ ■	2.04	1.70	1.30	1.16	1.03	0.91	0.81	0.76	0.71	0.66

SF 25 - 250,  $s = 1.00$  mm

Span width in m		0.50	0.60	0.80	0.90	1.00	1.20	1.40	1.50	1.60	1.70
Permissible wind load in $kN/m^2$	■	3,37	2.82	2.12	1.89	1.71	1.41	1.18	1.07	0.97	0.89
	■ ■	1.36	1.13	0.89	0.82	0.74	0.59				
	■ ■ ■	1.48	1.30	0.98	0.91	0.85	0.72	0.58	0.52		

SF 25 - 333,  $s = 1.00$  mm

Table 4: Load table for reveal panel

Basis for design: uniformly distributed load, including the weight of the profile itself

Safety factor: 1.50

Tensile yield strength:  $100 N/mm^2$

Width of support profile:  $\geq 50$  mm

DIN 18807/experimental testing at the University of Karlsruhe, Germany

PROFILE GEOMETRY

**2.1 Profile Geometry**

Metal gauge

s = 1.00 mm / 1.20 mm

Cover widths SF 25 s = 1.00 mm	Weight
200 mm	11.20 kg/m <sup>2</sup>
225 mm	10.70 kg/m <sup>2</sup>
250 mm	10.40 kg/m <sup>2</sup>
300 mm	9.84 kg/m <sup>2</sup>
333 mm	9.60 kg/m <sup>2</sup>

Cover widths of 200-333 mm

All sizes in between, in mm intervals, are possible. For widths of over 250 mm, we recommend using a material thickness of 1,20 mm.

**Possible Applications**

- Facades
- Soffits
- Parapets

**Fastening**

Using rivets or screws, the panels are fastened directly onto the substructure, through the protruding leg of the groove (see detail above).

Linear expansion is restricted by limiting the length of the facade panel, and accommodated via the deflection of the substructure.

**Dimensions**

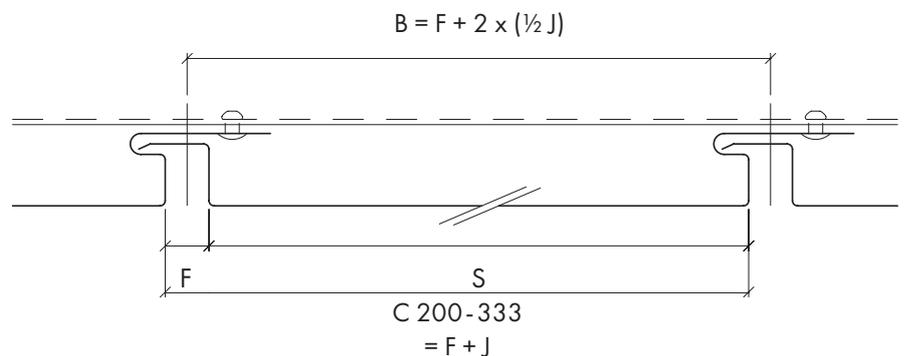
- Drawings: Dimensions in mm
- Panel designation: SF 25-287 (example)
- Standard length: ≤ 4000 mm
- B: bay width
- C: cover width
- J: joint width
- F: face width

**Tolerances**

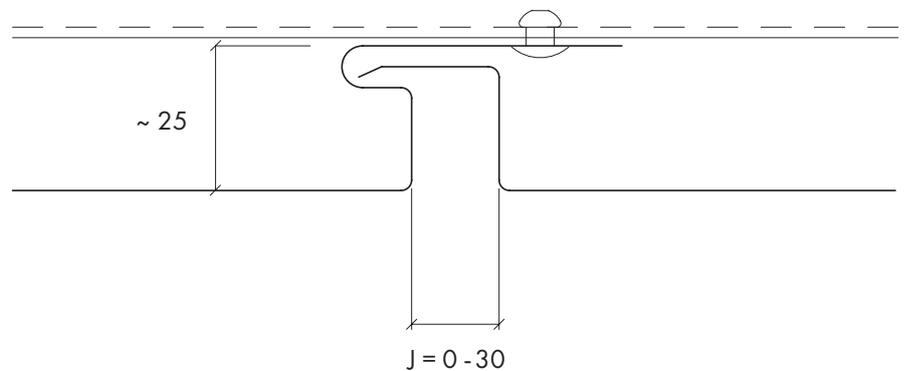
As per RHEINZINK works standard

**Note re Installation:**

- Reinforcing the panels at both ends with backfolds is recommended
- A 0-33 mm wide reveal joint (J) is possible
- The cover width (C) of the panel is manufactured with a minus tolerance of < 1 mm.



System section



Joint configuration

**2.1.1 RHEINZINK-Reveal Panel,  
vertical Installation**



*Telecom Giubiasco, Giubiasco, Switzerland*



*RHEINZINK panel, SF 25 with 20 mm  
reveal joint*



*Theater am Marientor (previously: Les Misérables), Duisburg, Germany*



*RHEINZINK panel, SF 25 with 15 mm  
reveal joint*

JOINT FORMATION

2.2 Joint Formation

2.2.1 Vertical Panels

2.2.1.1 Horizontal Joint

**A: Slave Profile**

A virtually seamless transition from one panel to the other strongly accentuates the verticality of the facade. This type of joint formation does not affect the rear-ventilation space.

**Fastening**

Using rivets or adhesives, fastening is one-sided directly onto the substructure or onto the lower panel.

**B: Flashing Profile installed within horizontal Joint**

Panel with backfolds closes the vertical joint and frames the panel with a surrounding reveal joint.

**C: Cornice Profile**

The horizontal joint can be accentuated by using profiles of varying widths. It is important not to interrupt or close off the rear-ventilation space.

2.2.1.2 Vertical Joint

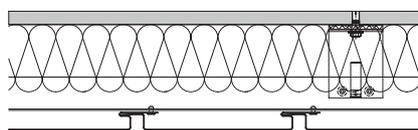
**D: Butt Joint**

This joint is formed by using a certain type of panel. It can be developed in varying widths from 0-30 mm and affects vertical segmentation.

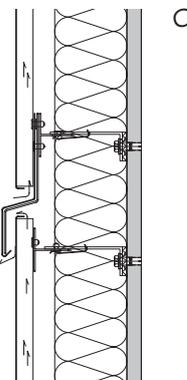
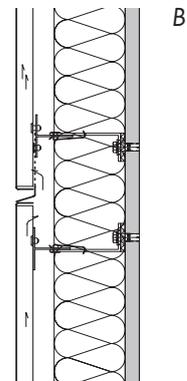
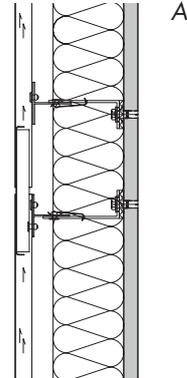
**Note:**

- Theoretically, all of the joint formations illustrated here can be used on all vertically installed RHEINZINK panels.
- Facade sections should be separated by means of expansion joints - a max. of 4000 mm (Example A, B, C).
- When determining panel lengths (Example C), air intake and exhaust openings must be taken into account.

View



Profile



A

B

C

D

### 2.3 Accommodating thermal Expansion of Facade Cladding

- Thermal expansion of facade profiles is accommodated by means of expansion joints.
- Statically connected fields cannot exceed 4000 mm in length. Exceptions must be discussed and approved by Application Engineering Department\*.
- In the area of expansion joints the fixing to the substructure must be executed accordingly.
- The substructure must be designed to be independent for each facade field around the expansion joint.

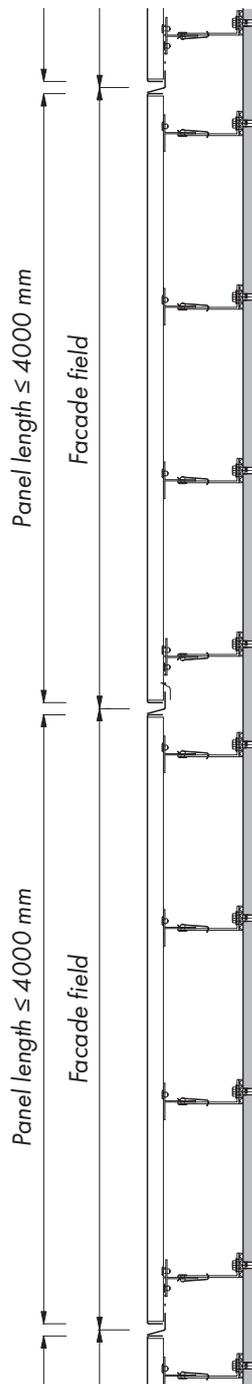
Two examples of facade implementation illustrate the connections schematically:

#### Example A

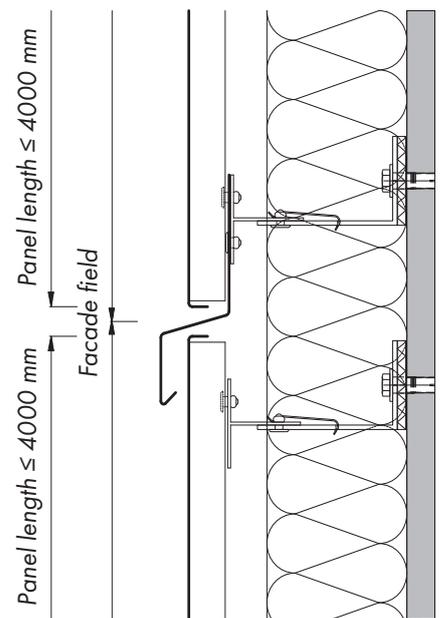
Large cladding components each form a field, which is fastened separately from the next field, by means of expansion joints.

#### Example B

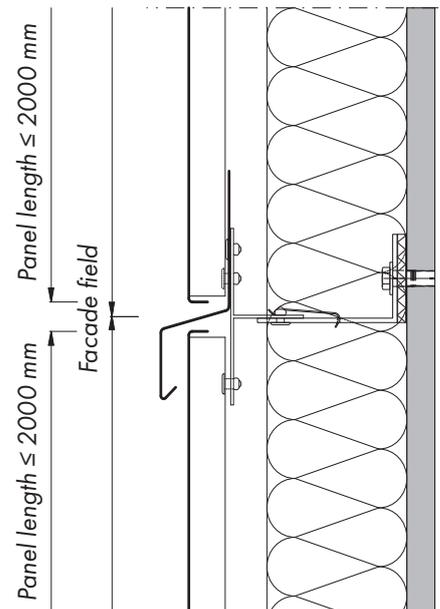
Small facade components are combined to create one facade field. Linear expansions can be accommodated after every third component, however, the total length of 4000 mm should not be exceeded.



Example A: Facade field joint (separation by means of expansion joints)



Example B: Facade joint serving as expansion joint



Example B: Facade joint serving as design feature only

\* see addresses and contacts on page 44

SUBSTRUCTURE

**2.4 Substructure**

RHEINZINK facade systems are normally installed on substructures consisting of single, double, or multiple non-ferrous metal systems. Apart from efficiency and the structural advantages provided by these systems, they also guarantee control and monitoring of fastening patterns and compliance with fire protection regulations. Moreover, the double and multiple systems enable building tolerances to be adjusted without difficulty.

The architectural appearance of the profiles determines the design of the substructure. Before the substructure is constructed, those concerned must determine the appropriate design, otherwise – inevitably – the design would determine the architecture.

**Note:**

Use of wood as a substructure for large facade surfaces in system technology is not recommended because of its behaviour when damp and difficulty in adjusting tolerances.

However, a dried wooden substructure is definitely suitable for small surface applications such as dormers, fascias and gable walls.

The location and orientation of the fixed and sliding points for metal substructures must be determined based on the type of cladding, the surface and length of the panels.

With single substructure systems, the disadvantages certainly outweigh the advantages, such as:

- inability to accommodate building tolerances
- large thermal bridges

All technical problems are solvable when double/multiple systems are used:

- local thermal bridges only
- rear-ventilation throughout is guaranteed

However, the expensive and elaborate design coupled with the fact that two or more installation procedures must be implemented must be taken into consideration.

Double or two-part systems constitute the “happy medium”:

Advantages

- cost-effective
- easy accommodation of building tolerances
- local thermal bridges only

Disadvantages:

- two installation procedures
- depending on the detailing requirements additional costs can occur



*Single substructure*



*Double or two-part substructure*



*Multi-part substructure*

FASTENING

**2.5 Fasteners**

Fasteners are parts that connect the cladding to the substructure mechanically. The edge distance of connections and fasteners in the substructure must be at

least 10 mm. Only corrosion-resistant fasteners, which guarantee long-term function capability, may be used.

**2.5.1 EJOT® Drilling Screws**

**Area of Application**

Drilling screws to join

- RHEINZINK panels onto
- steel substructures 1,5-4,0 mm
- aluminum substructures 1,5-4,0 mm

**JT 3 - FR - 6 - 5,5 x 25 - E11**



Marking	Ø x mm	Length mm	Drill capacity t <sub>I</sub> + t <sub>II</sub> mm	Clamping thickness mm
JT3 - FR - 6	5.5 x	25	min. 0,63 + 1,5 max. 2,0 + 4,0	0 - 7.0



**2.5.2 EJOT®**

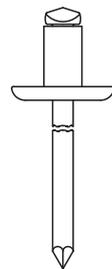
**Blind Rivet with large Collar**

Aluminum (Al) rivet sleeve  
Rivet mandrel made of high-grade steel  
Secure connection

**Area of Application**

- Use blind rivets to fasten
- RHEINZINK panels
- steel or aluminum profile sheets onto
- steel substructures
- aluminum substructures

**Blind rivet K14 - Al/E - 5,0 x 8,0**



Marking	Ø x mm	Length mm	Clamping thickn. mm	Drill hole Ø mm
Blind rivet K14 - Al/E -	5.0 x	8.0	2.5 - 4.5	5.1
	5.0 x	10.0	4.5 - 6.0	5.1
	5.0 x	12.0	6.0 - 8.0	5.1
	5.0 x	18.0	12.0 - 14.0	5.1

**2.5.3 EJOT® Blind Rivet**

Aluminum (Al) rivet sleeve  
Rivet mandrel made of high-grade steel  
Secure connection

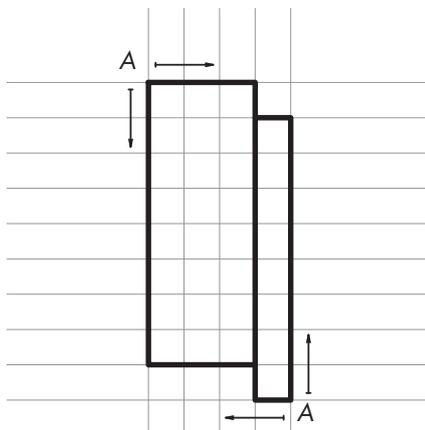
**Area of Application**

Blind rivets are used to fasten secondary components, e.g. slave profiles.

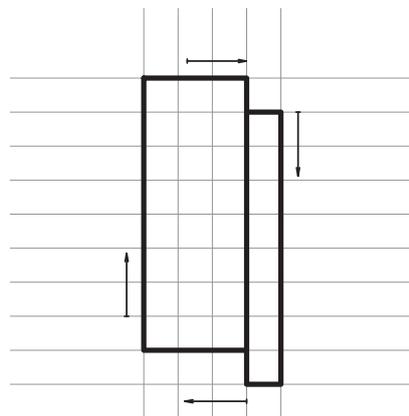
**Blind rivet Al/E - 4,8 x 10**



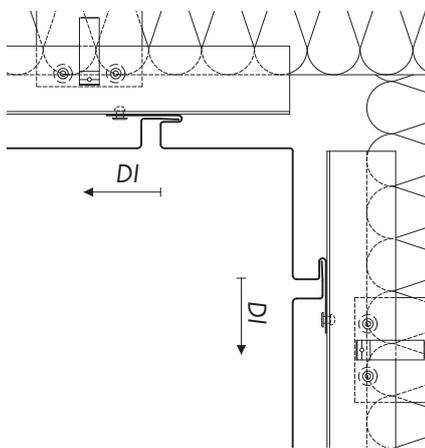
Marking	Ø x mm	Length mm	Clamping thickn. mm	Drill hole Ø mm
Blind rivet Al/E -	4.8 x	10.0	0.5 - 6.5	4.9
	4.8 x	15.0	4.5 - 11.0	4.9
	4.8 x	25.0	11.0 - 19.5	4.9



A: start of installation

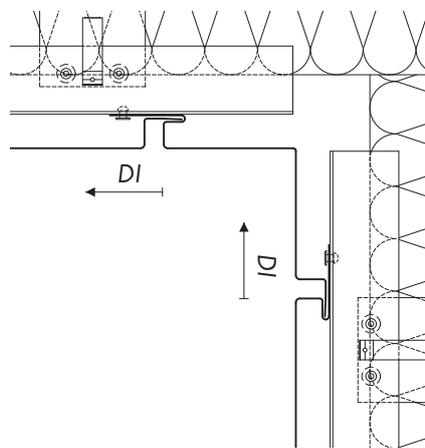


Installation can begin anywhere



**Example A:**

The corner panel is installed first. Building tolerances are accommodated either by installing an adaptor panel in the centre of the facade, or, next to the outside corner panel.



**Example B:**

The corner panel is part of the continuous installation sequence. Any tolerances that need to be adjusted at this point can be accommodated by the corner panel.

**2.6 Installation and Building Tolerances**

Adapter panels are required to accommodate building and installation tolerances.

The location of these panels in the facade is determined by the installation process and sequence.

Trim work, e.g. window and door frames, corner panels, joint profiles, etc., should be installed first. The panels are manufactured at the RHEINZINK system centre to precise dimensions.

Dimensional adjustments can be made on site by making minimum changes to the joint width. The performance of the system is not affected by this.

The panels are installed starting at Installation Point A. Adaptor panels are generally inserted before the next section.

Depending on the size of tolerance to be accommodated, one or two adaptor panels will be installed.

**Note:**

Tolerance adjustment using adaptor panels  $\leq 15$  mm difference is hardly noticeable.

DI: direction of installation

DETAIL CONCEPT

**2.7 Detail Concept**

Detail design creates the lasting impression of the facade. Plan details or sections are required for most of the corners, reveals, as well as connections and terminations. These must be coordinated during detail design development. Two significant design variations will illustrate this.

**Visible Width of the Building Profile or Section**

The spectrum ranges from sharp-edged profiles to profiles that are several centimeters wide. Precise planning allows for the widths of all termination and frame profiles to be the same, or, to vary these in desired proportions.

**Projection of Profiles**

Depending on the detail design, the profiles either protrude from, or lie flush with the facade surface.

This overview illustrates three possible principles:

**Profile Group 1**

A relatively wide joint profile (visible width ca. 60 mm) is selected as the building profile, which is terminated flush with the facade surface.

Various facade systems, such as cassettes or panels, can be used to form the corner of the building.

**Profile Group 2**

A sharpe-edged profile will be installed flush with the curtain wall, so that the window frame design is not accentuated.

**Profile Group 3**

The jamb profile selected for this window surround can replicate the joint profile (see profile group 1) and is used as a flashing in conjunction with the window sill and lintel.



*Profile group 1*



*Profile group 2*



*Profile group 3*

**2.8 Details**

**2.8.1 General Instructions**

**Third Party Trades**

Connections of facade claddings to third party trades are necessary and unavoidable in most cases to ensure impermeability. Because of the warranty obligations on the part of the craftsman, sub-contracting connections and fasteners to third party trades (e.g. windows), must always be approved by the project manager of the trade in question.

Please keep the location of the scaffold anchors in mind during planning/design.

**Wall Structure**

The layered construction is equal to a rear-ventilated metal facade. A solid brick/concrete wall or stud wall with sheathing serves as the supporting structure.

**Substructure**

See Chapter 2.4

**Load Effect**

In the case of two-dimensional cladding profiles (all panel types) that are only fastened on one side, flanged backfolds are required to provide additional reinforcement for all profiles in exposed building locations.

**Installation Instructions**

We will not go into installation details here, because, when it comes right down to it, these are strongly influenced by other trades when it comes to windows, structural steel construction, etc.

The installation processes must always be determined individually for each project, considering interfaces and the sequence of installation.

Notable deviations from the rule will be pointed out for various details.

**Drip Edges**

Standards and regulations must be taken into consideration in the detail design, e.g. drip edges above rendered facades (dirt as a result of pollution).

**Diagonal Installation**

RHEINZINK-Reveal Panels can also be used for diagonal facade installation.

To a large extent, technical implementation of the design is commensurate with horizontal installation. Foldbacks must be fabricated on site.

**2.8.2 Pictographs**

Horizontal profiles (see page 26)

H1: outside corner

H2: inside corner

H3: window jamb

Vertical profiles (see pages 26/27)

V1: base

V2: windowsill

V3: window lintel

V4: roof edge

V5: expansion joint

**Variations**

In some cases, variations for the same detail are depicted (e.g. window lintel with/without shade).

These are identified and include additional explanatory texts or drawings.

**Applicability**

The details and designs depicted here are suggestions, which have been implemented on various projects. Responsibility must be taken for decisions made on detail suggestions, taking into account applicable standards and regulations, as well as the stylistic intentions of the planner for the project.

Building Height	Overlap	Distance to drip edge
≤ 8 m	≥ 50 mm	≥ 20 mm
> 8 m ≤ 20 m	≥ 80 mm	≥ 20 mm
> 20 m	≥ 100 mm	≥ 20 mm

*Table 6: Distance and overlap dimensions for flashings (e.g. windowsills, wall copings, verge profile, etc.)*

PLANNING GRID

**2.9 Planning Grid**  
**The Grid Principle in Facade Construction**

A metal facade consists of components manufactured industrially with a high degree of precision. These components determine appearance through precise horizontal and vertical segmentation. Penetrations and terminations that are not matched/coordinated with the axis grid can have a disturbing effect. The following instructions serve to assist proper planning of facade segmentation:

**Principles**

As a rule, a differentiation should be made between new construction and renovations when discussing grid problems. In the case of new construction, the facade grid can be coordinated or matched to the design; penetrations such as windows, ventilation piping, etc. are always secondary.

In the case of renovations, the penetrations (e.g. windows) cannot be displaced or removed, so the grid must be coordinated with the penetrations.

When deviating from the grid, the following principles apply:

- At terminations, one should begin or end with an entire module (X or Y)
- Dimensional differences of max. 15 mm (deviations from module X or Y, in the case of two-dimensional profiles), are not noticeable.
- Dimensional tolerances, which cannot be corrected (X or Y dimensional change) must be compensated either in the windowsill or roof edge area.
- Adjustments or displacements of height coordinates can only be implemented in the roof edge or base area.

The principles used to segment a facade are illustrated using the example of a vertical grid for horizontal cladding. This principle also applies to vertical facade cladding.

- B: bay width
- C: cover width
- J: joint width
- F: face width

**Module Y**

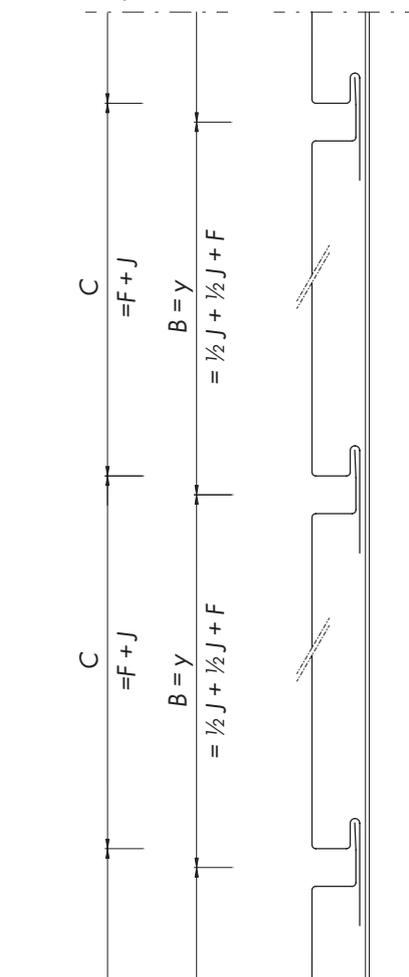
Y corresponds to the smallest segment of the facade, which is repeated again and again, e.g. panel width. The Y grid module determines the precise location of penetrations and terminations. In the case of reveal panels, the Y dimension is discretionary and is produced in cover widths of 200 mm to 333 mm, based on the project.

The bay width (Y) is formed using the visible surface of the panel and two half joints.

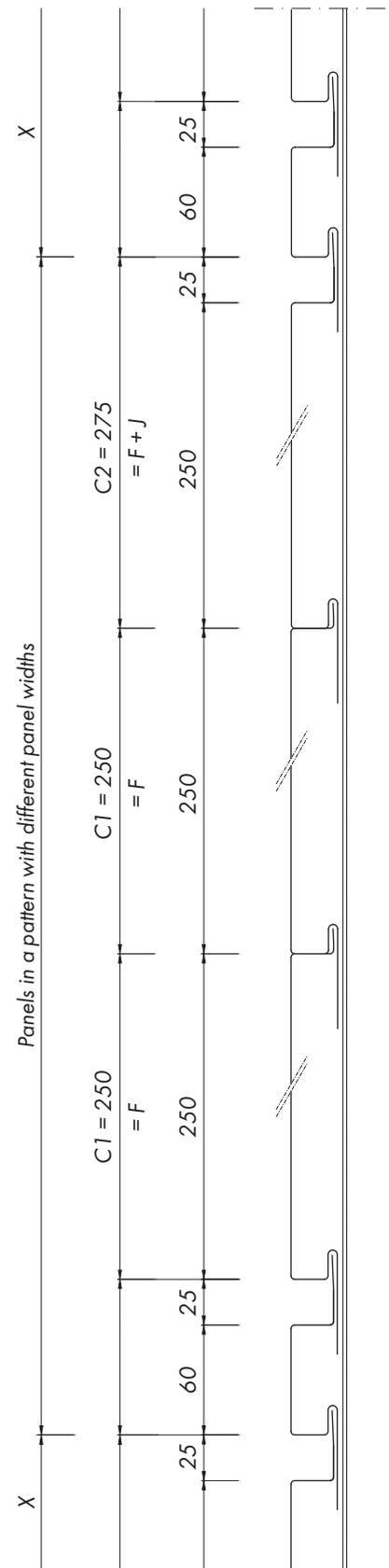
The cover width is established from the visible surface and the width of the joint. The width of the reveal can vary from 0 to 30 mm and is determined by appropriate length of the "tongue".

**Dimension X**

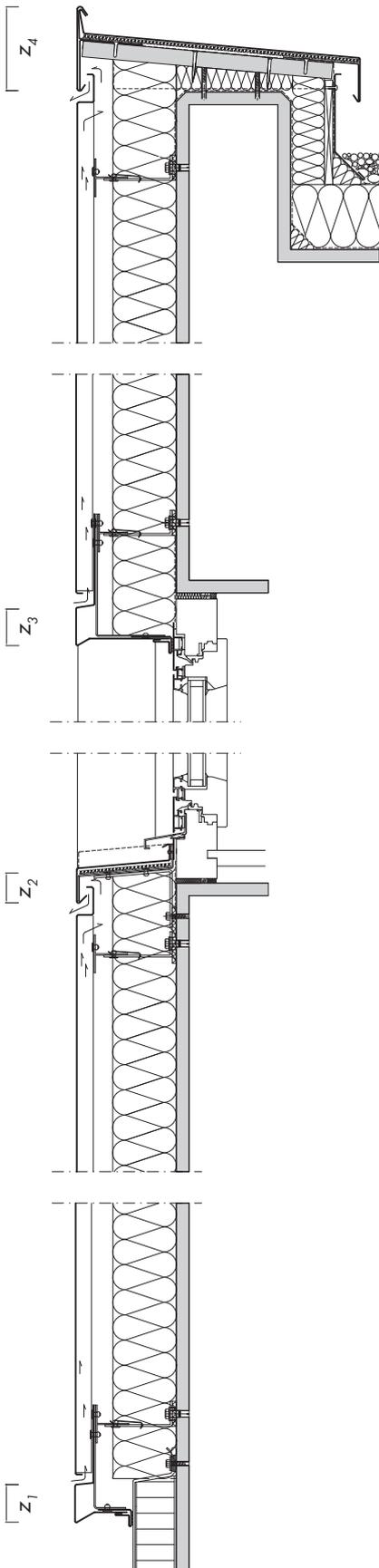
All of the sections marked with X are an integral multiple of selected module Y and, as a rule, correspond to the cover width of a profile.



Repeated panel module



Combination of panels creating a module



**Position Z<sub>4</sub>: Roof Edge**

**Grid for new Construction, respectively, Renovation**

If the height coordinates of the roof edge do not fit into the prescribed grid selected, the following corrective options can be selected:

- change the roof edge profile/ incline
- raise or lower the parapet wall or the roof edge board.
- Changing the X or Y module

**Position Z<sub>3</sub>: Window Lintel**

**Position Z<sub>2</sub>: Windowsill**

**Grid Development for new Construction**

- Determine the openings of the building shell
- Determine the window frame profile
- Determine window location
- Determine profile geometry of window connections
- Develop design details within the grid

**Grid Development for Renovations**

- Determine window frame profile, for new/old window
- Determine window location, for new/old window
- Determine profile geometry of window connections
- Develop design details within the grid

If the location of the window or of the detail does not fit into the grid, the following corrective options can be selected:

- Change the profile geometry of the window lintel profile or the windowsill
- Adjust window height
- change the incline of the windowsill
- Change the X or Y module

**Position Z<sub>1</sub>: Base**

**Grid Development for new Construction, respectively, Renovation**

- Define potential deviations to the right or left
- Define profile geometry of base detail in accordance with corner profiles

If the location of the base does not fit into the grid, the following corrective options can be selected:

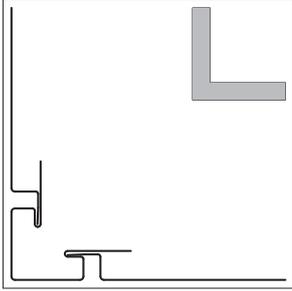
- Shift the facade connection to the right and/or left
- Change the profile geometry of the base profile
- Lower or raise the plinth masonry, if it exists or has been designed

# REVEAL PANELS, DESIGN AND APPLICATION

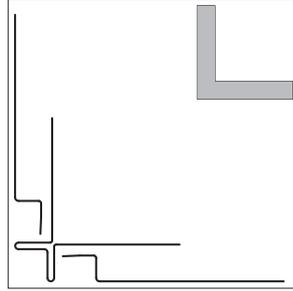
## DESIGN OVERVIEW VERTICAL APPLICATION

### 2.10 Reveal Panel Design, vertical Application

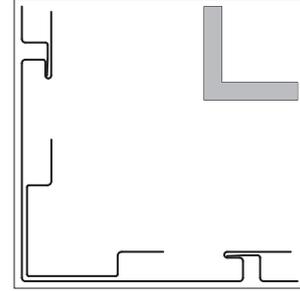
Detail H1: Outside corner, page 28



H1.1

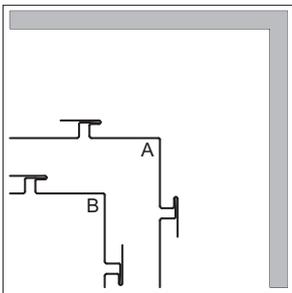


H1.2

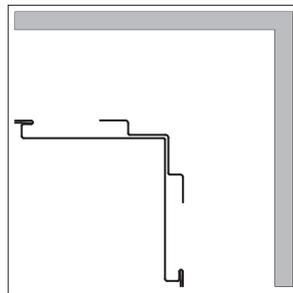


H1.3

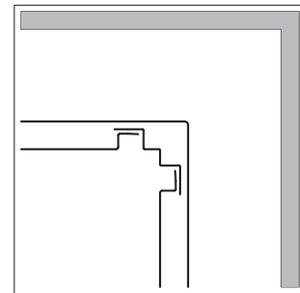
Detail H2: Inside corner, page 30



H2.1

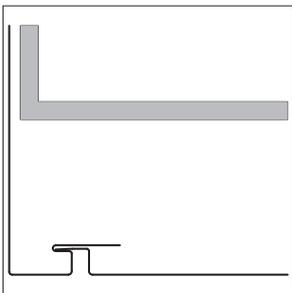


H2.2

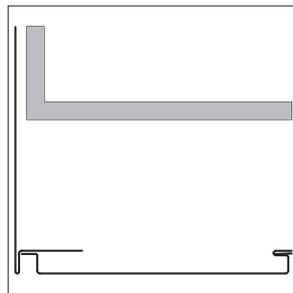


H2.3

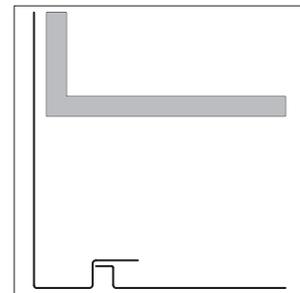
Detail H3: Window jamb, page 32



H3.1

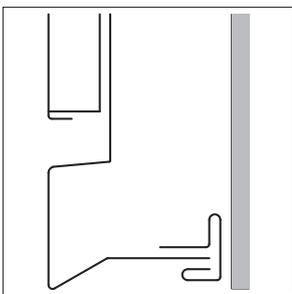


H3.2

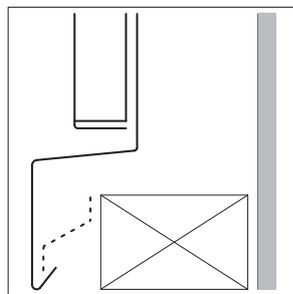


H3.3

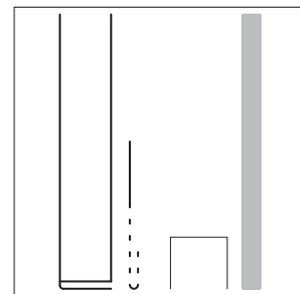
Detail V1: Base, page 34



V1.1

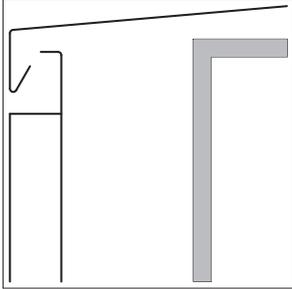


V1.2

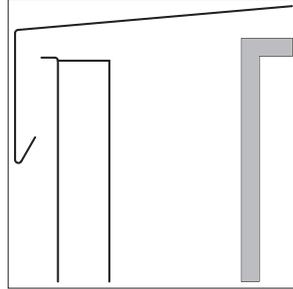


V1.3

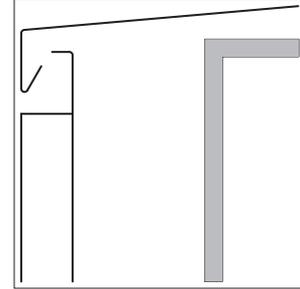
Detail V2: Windowsill, page 36



V2.1

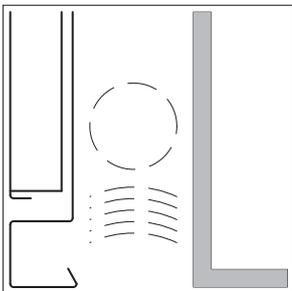


V2.2

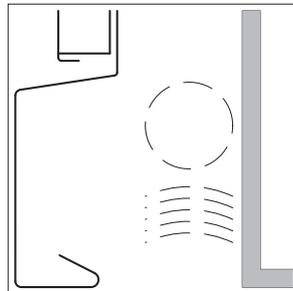


V2.3

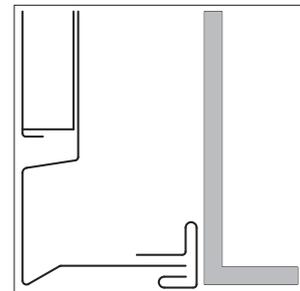
Detail V3: Window lintel, page 38



V3.1

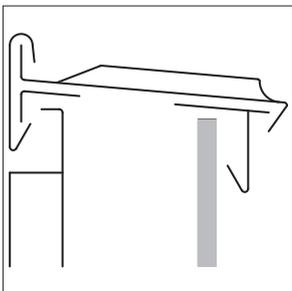


V3.2

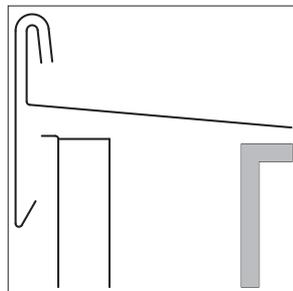


V3.3

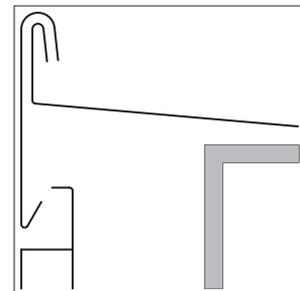
Detail V4: Two-part roof edge, page 40



V4.1

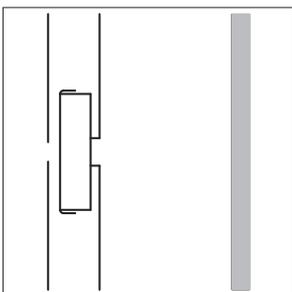


V4.2

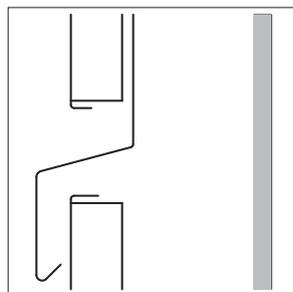


V4.3

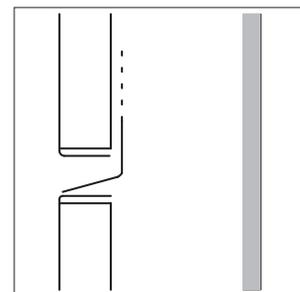
Detail V5: Expansion joint, page 42



V5.1



V5.2

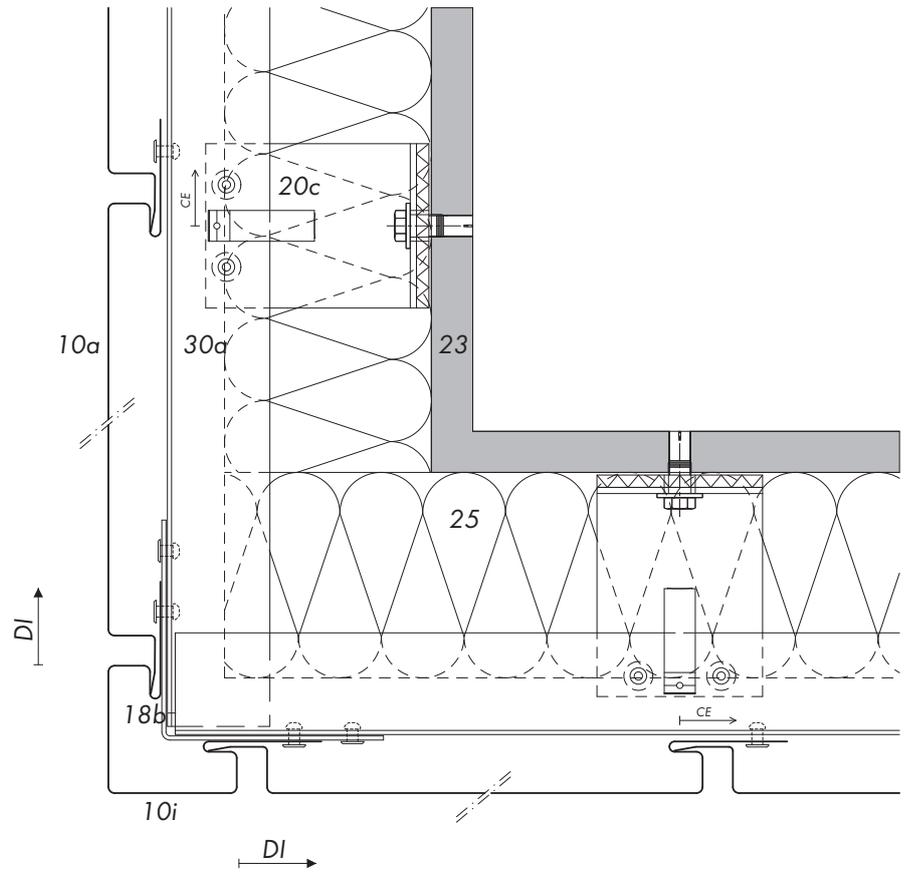


V5.3

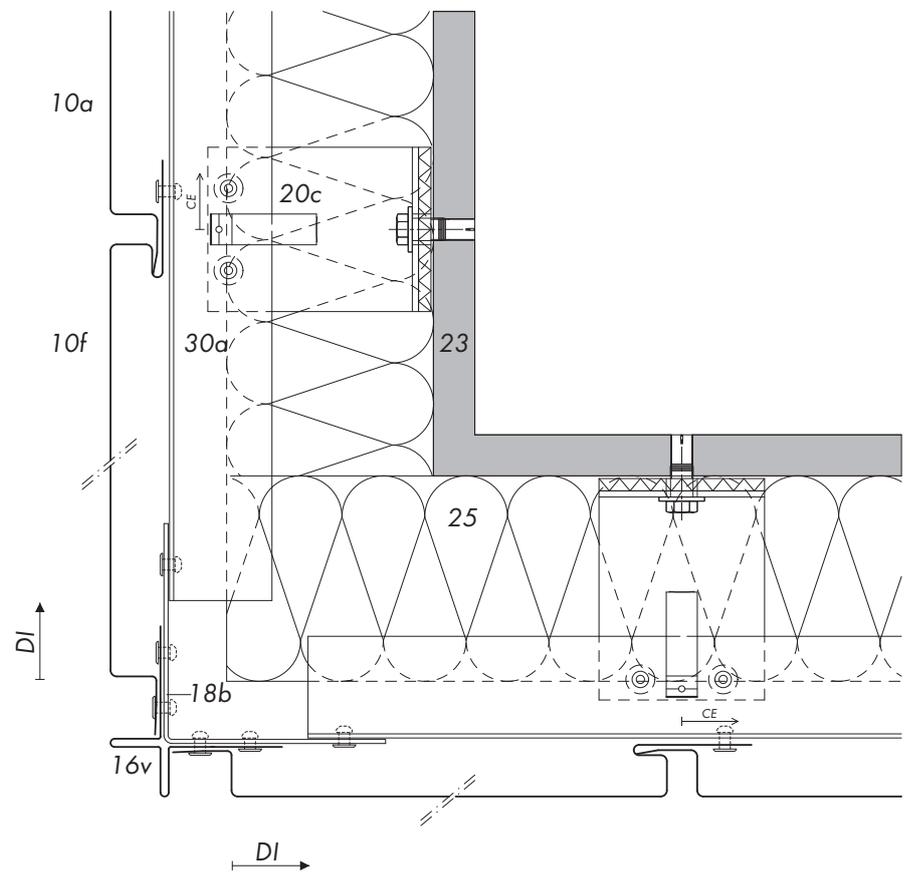
REVEAL PANELS, DESIGN AND APPLICATION

DESIGN – VERTICAL APPLICATION  
DETAIL H1: OUTSIDE CORNER

H1.1

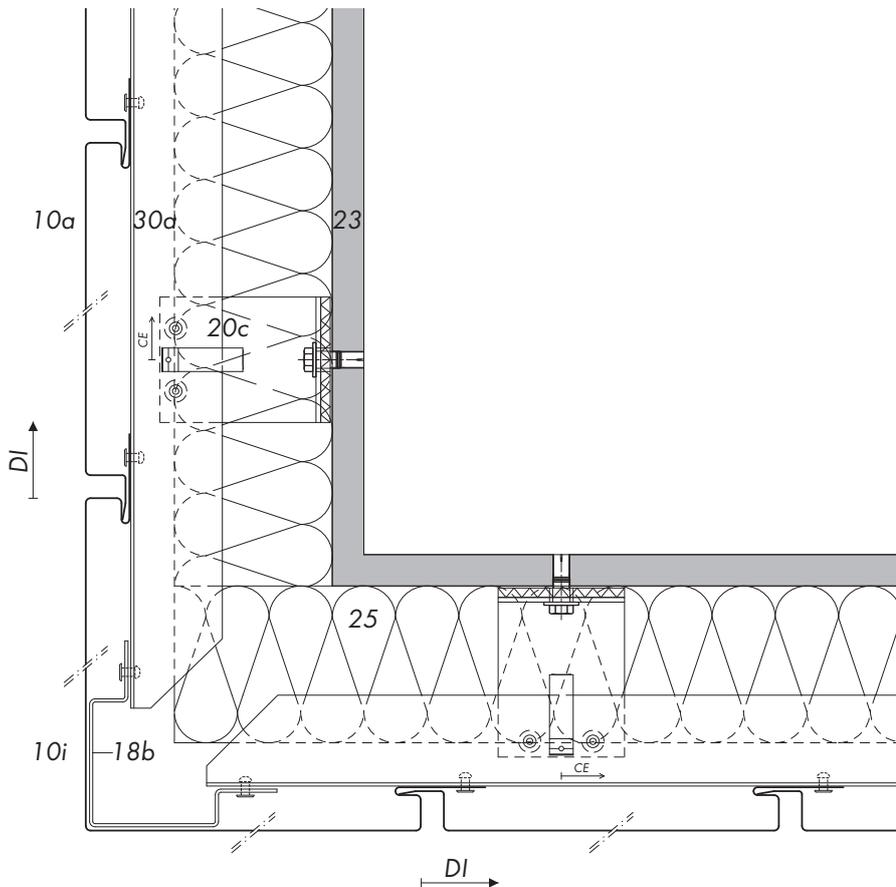


H1.2



DESIGN – VERTICAL APPLICATION  
DETAIL H1: OUTSIDE CORNER

H1.3



**2.10.1 Detail H1: Outside Corner**

- 10 RHEINZINK-Reveal Panel SF 25
  - a Standard panel
  - f Fitting panel
  - i Corner panel, groove-groove
- 16 RHEINZINK-Building Profile
  - v Corner profile
- 18 Support Profile
  - b Aluminium
- 20 Substructure
  - c Bracket system, with thermal break\*
- 23 Supporting Structure
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

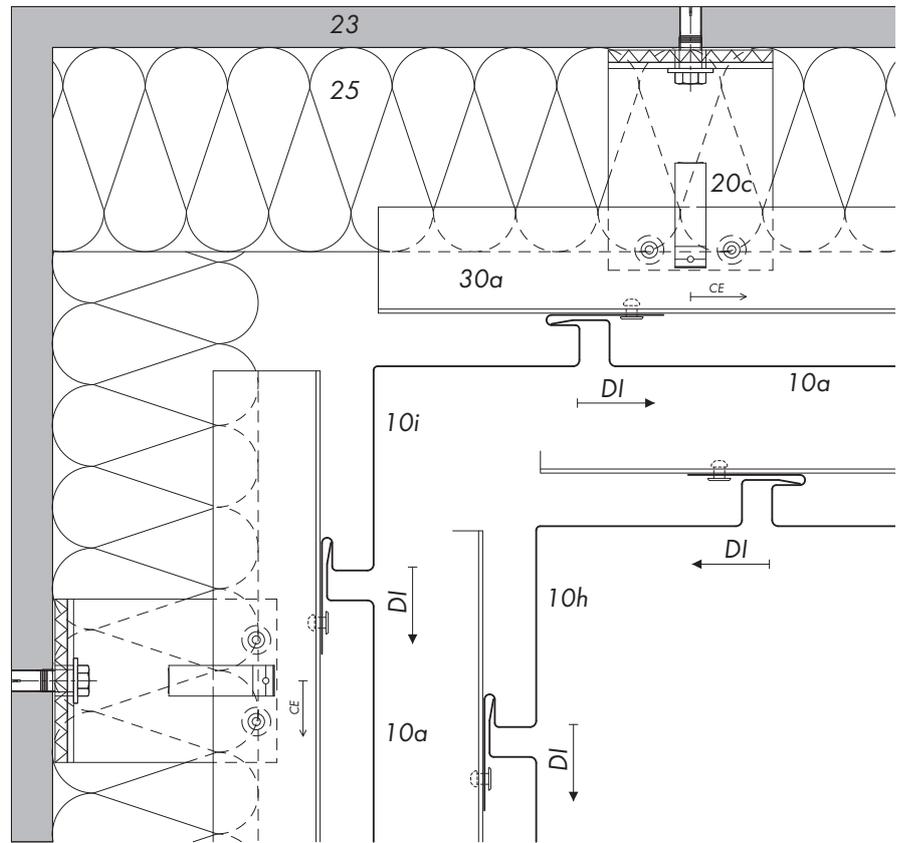
DI Direction of installation  
CE Controlled expansion of substructure

\* Manufacturers' guidelines must be complied with

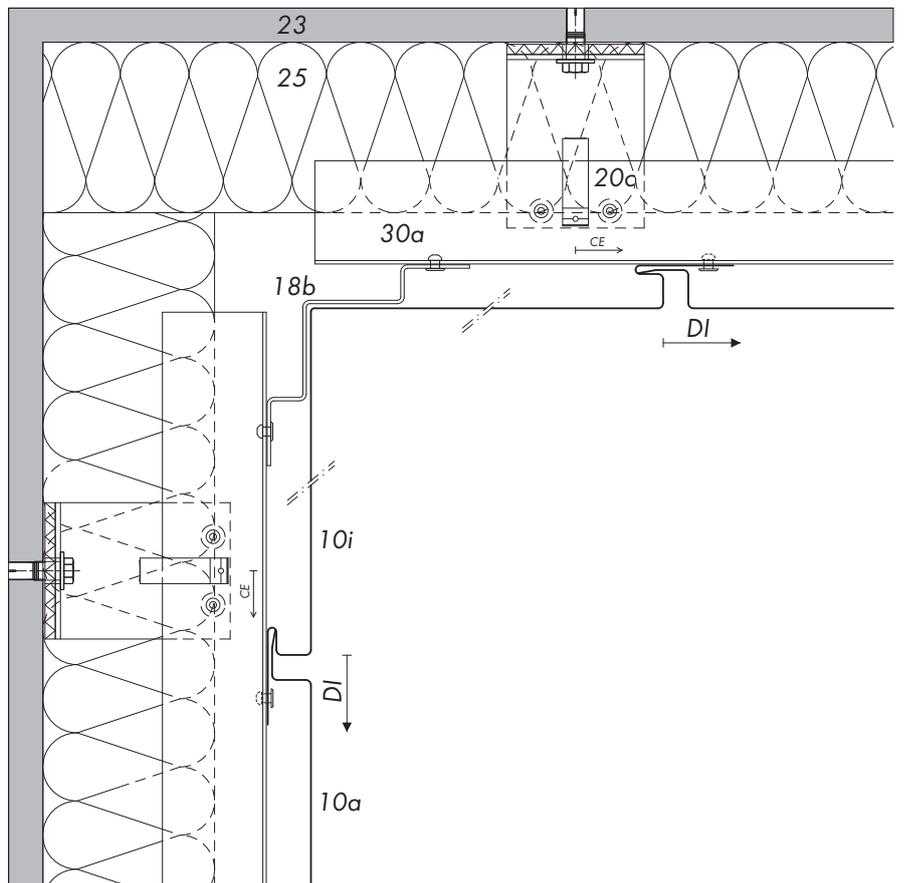
REVEAL PANELS, DESIGN AND APPLICATION

DESIGN – VERTICAL APPLICATION  
DETAIL H2: INSIDE CORNER

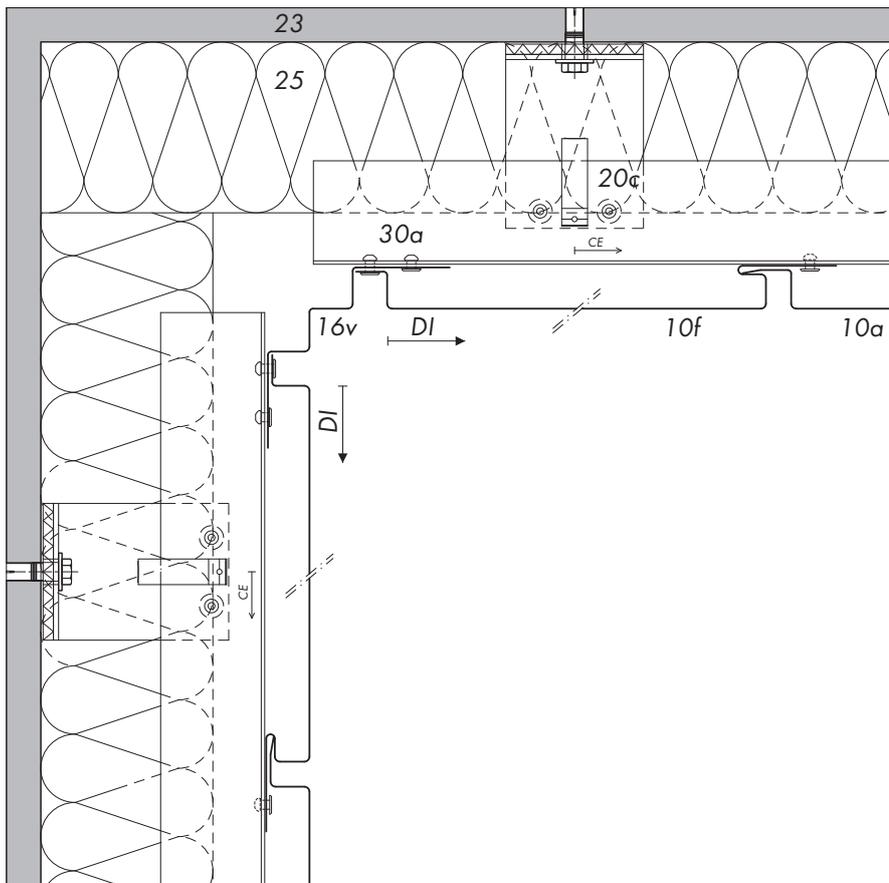
H2.1



H2.2



DESIGN – VERTICAL APPLICATION  
DETAIL H2: INSIDE CORNER



H2.3

**2.10.2 Detail H2: Inside Corner**

- 10 RHEINZINK-Reveal Panel SF 25
  - a Standard panel
  - f Fitting panel
  - h Corner panel, groove-tongue
  - i Corner panel, groove-groove
- 16 RHEINZINK-Building Profile
  - v Corner profile
- 18 Support Profile
  - b Aluminium
- 20 Substructure
  - c Bracket system, with thermal break\*
- 23 Supporting Structure
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

DI Direction of installation  
CE Controlled expansion of substructure

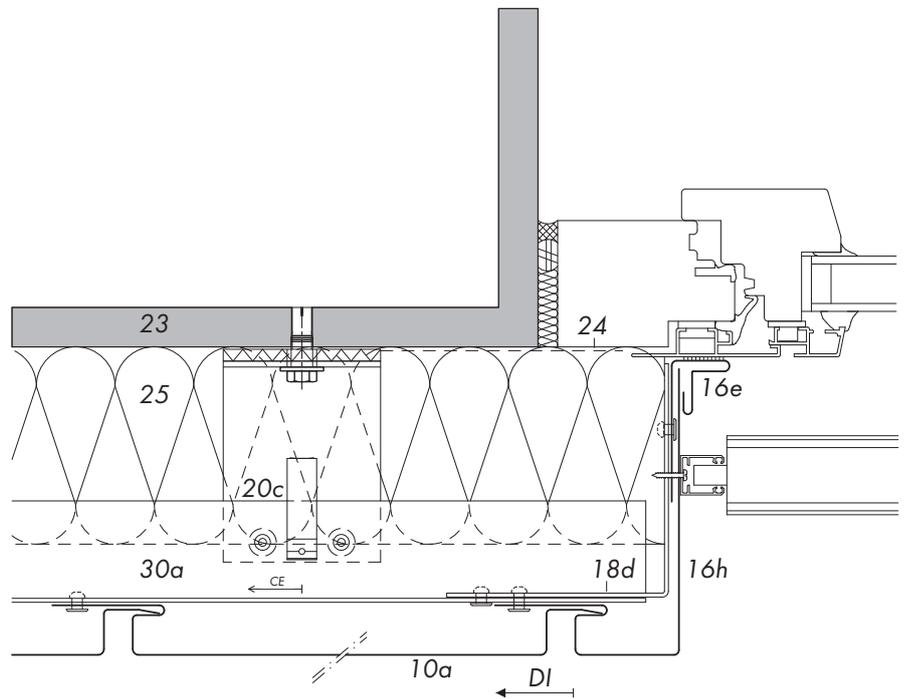
\* Manufacturers' guidelines must be complied with

REVEAL PANELS, DESIGN AND APPLICATION

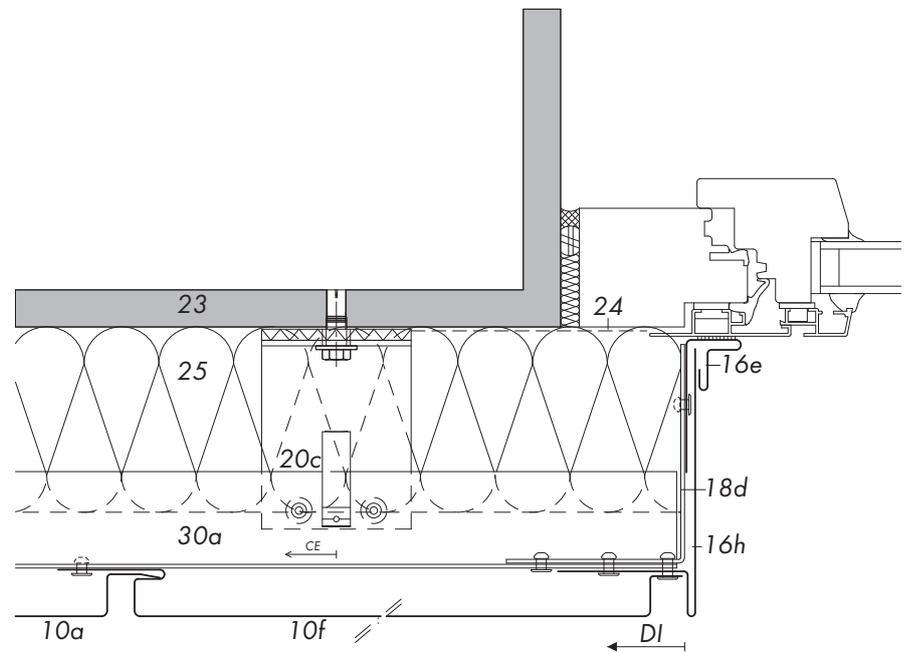
DESIGN – VERTICAL APPLICATION

DETAIL H3: WINDOW JAMB

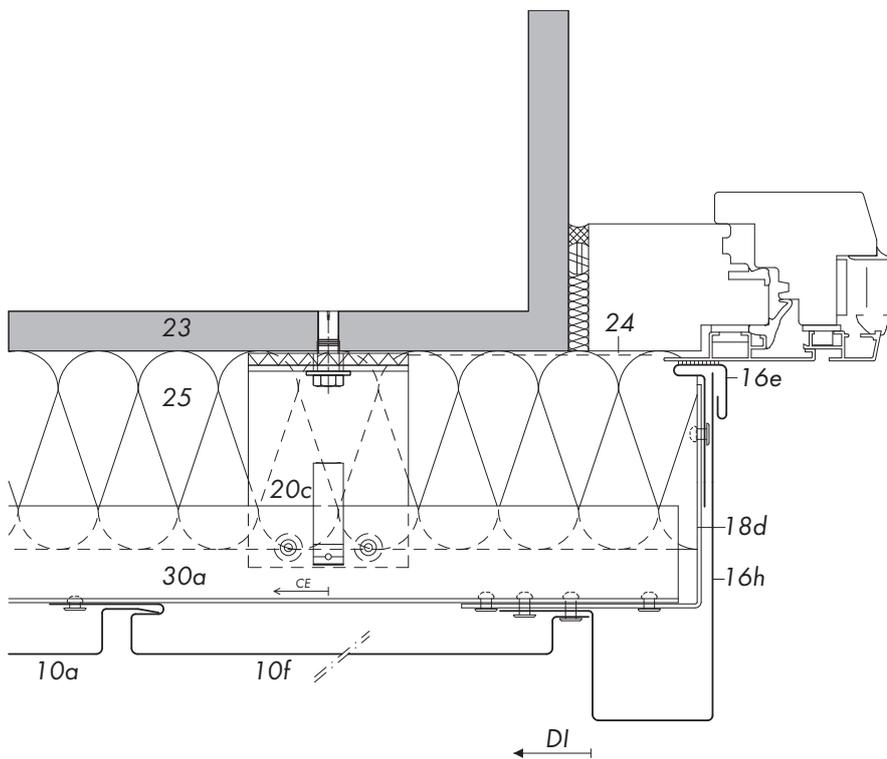
H3.1



H3.2



H3.3



**2.10.3 Detail H3: Window jamb**

- 10 RHEINZINK-Reveal Panel SF 25
  - a Standard panel
  - f Fitting panel
- 16 RHEINZINK-Building Profile
  - e Receiver strip, with sealant tape
  - h Jamb profile
- 18 Support Profile
  - d Aluminium\*
- 20 Substructure
  - c Bracket system, with thermal break\*\*
- 23 Supporting Structure
- 24 Window Foil
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

DI Direction of installation  
CE Controlled expansion of substructure

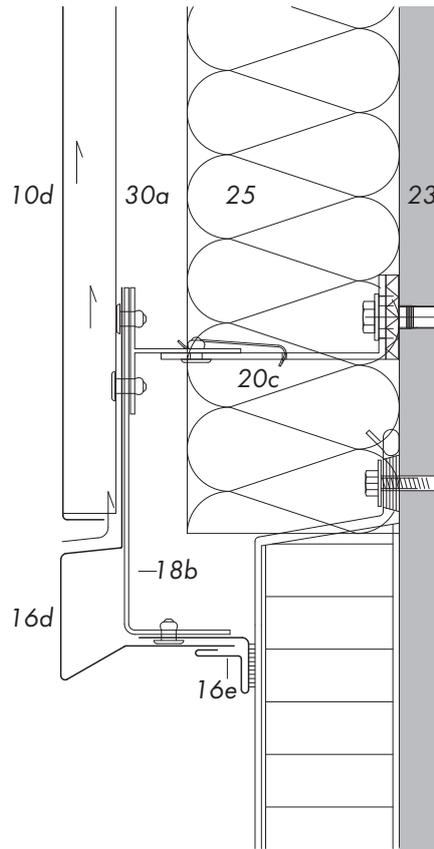
\* If fire breaks are required use galvanised steel  $\geq 1$  mm  
\*\* Manufacturers' guidelines must be complied with

REVEAL PANELS, DESIGN AND APPLICATION

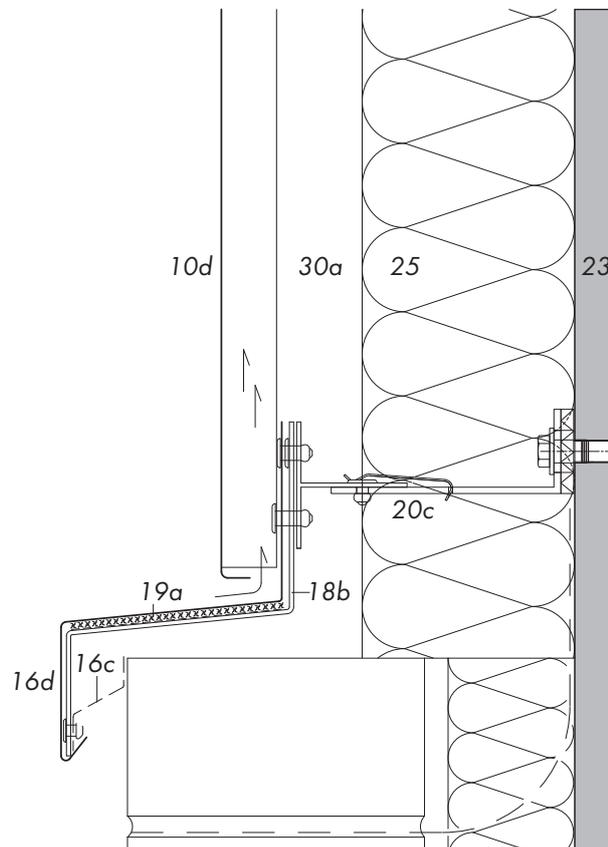
DESIGN – VERTICAL APPLICATION

DETAIL H4: EXPANSION JOINT

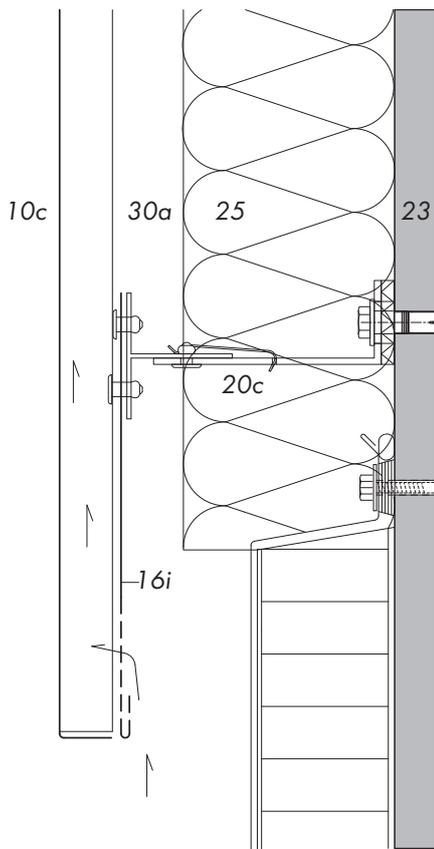
V1.1



V1.2



V1.3



**2.10.4 Detail V1: Base**

- 10 RHEINZINK-Reveal Panel SF 25
  - c Standard panel, with stopend
  - d Standard panel, with stopend short
- 16 RHEINZINK-Building Profile
  - c Perforated strip
  - d Base profile
  - e Receiver strip, with sealant tape
  - i Termination profile, partly perforated
- 18 Support Profile
  - b Aluminium
- 19 Separating Layer
  - a Structured underlay VAPOZINC
  - Alternative: glued to support profile over entire surface
- 20 Substructure
  - c Bracket system, with thermal break\*
- 23 Supporting Structure
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

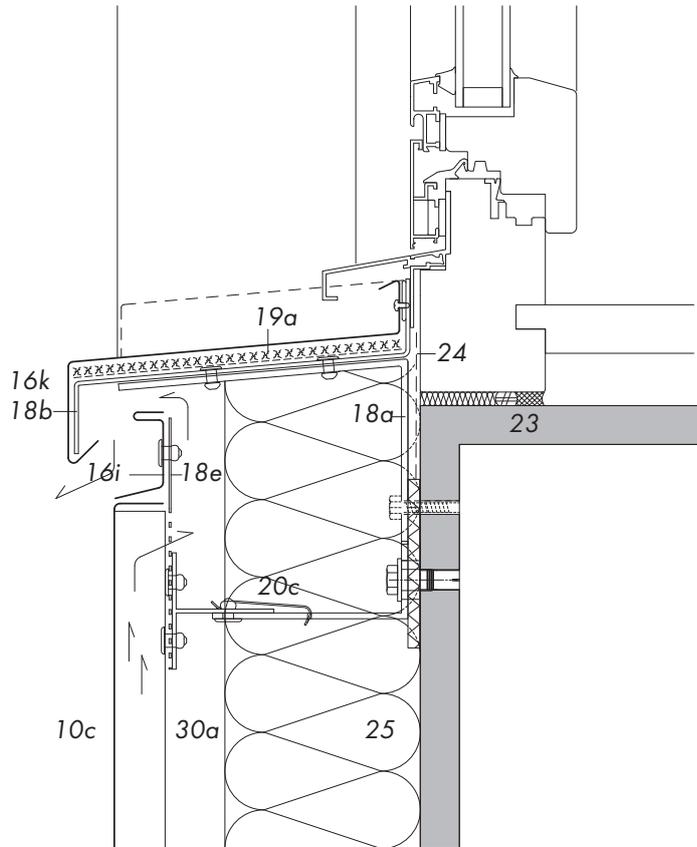
\* Manufacturers' guidelines must be complied with

REVEAL PANELS, DESIGN AND APPLICATION

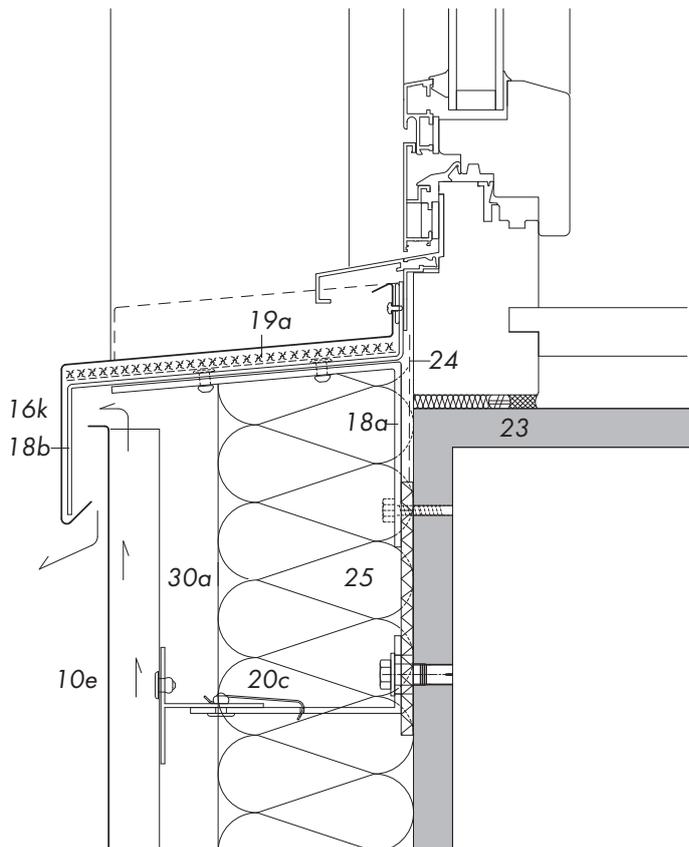
DESIGN – VERTICAL APPLICATION

DETAIL V1: BASE

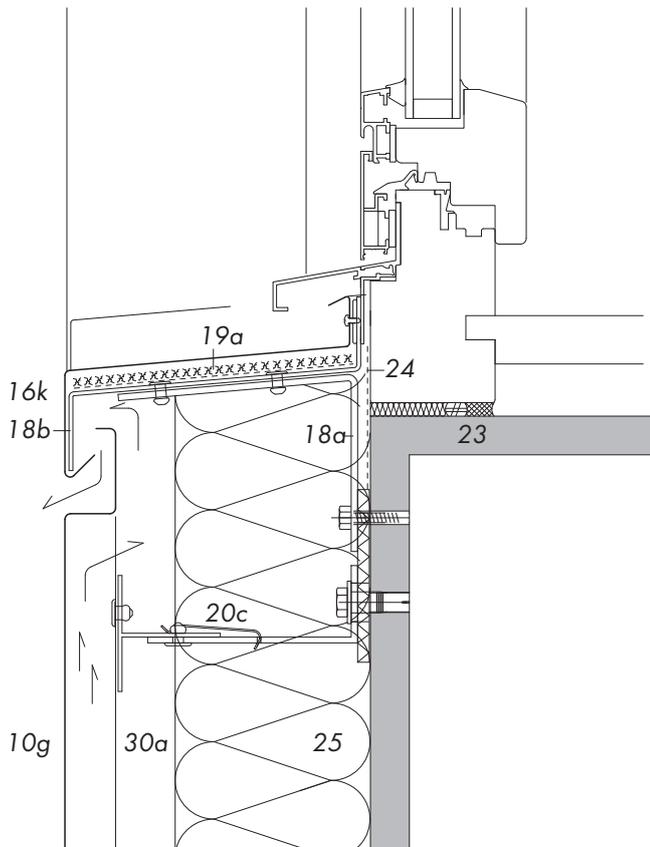
V2.1



V2.2



V2.3



**2.10.5 Detail V2: Windowsill**

- 10 RHEINZINK-Reveal Panel SF 25
  - c Standard panel, with stopend
  - e Standard panel, with stopend short, outward-facing
  - g Fitting panel, with bent up water drip
- 16 RHEINZINK-Building Profile
  - i Connection/termination profile
  - k Window sill coping
- 18 Support Profile
  - a Galvanised steel, support angle with thermal break
  - b Aluminium
  - e Aluminium, partly perforated
- 19 Separating Layer
  - a Structured underlay VAPOZINC
  - Alternative: glued to support profile over entire surface
- 20 Substructure
  - c Bracket system, with thermal break\*
- 23 Supporting Structure
- 24 Window Foil
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

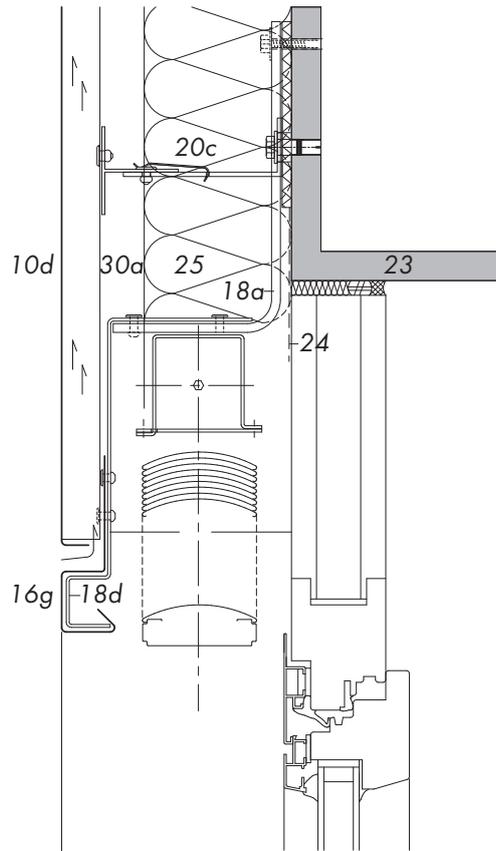
\* Manufacturers' guidelines must be complied with

REVEAL PANELS, DESIGN AND APPLICATION

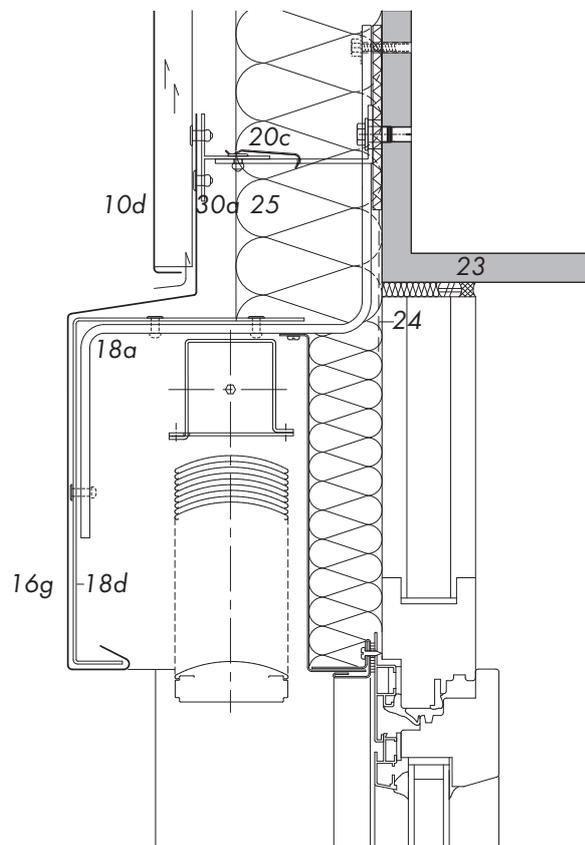
DESIGN – VERTICAL APPLICATION

DETAIL V2: WINDOWSILL

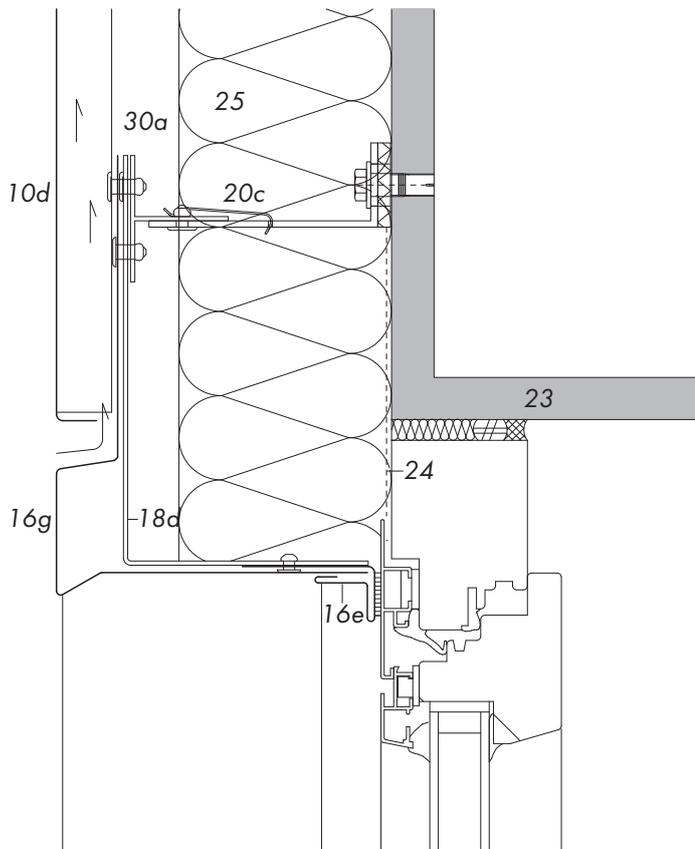
V3.1



V3.2



V3.3



**2.10.6 Detail V3: Window lintel**

- 10 RHEINZINK-Reveal Panel SF 25
  - d Standard panel, with stopend short
- 16 RHEINZINK-Building Profile
  - e Receiver strip, with sealant tape
  - g Lintel profile
- 18 Support Profile
  - a Galvanised steel, support profile with thermal break
  - d Aluminium \*
- 20 Substructure
  - c Bracket system, with thermal break \*\*
- 23 Supporting Structure
- 24 Window Foil
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

\* If fire breaks are required use galvanized steel  $\geq 1.0$  mm.

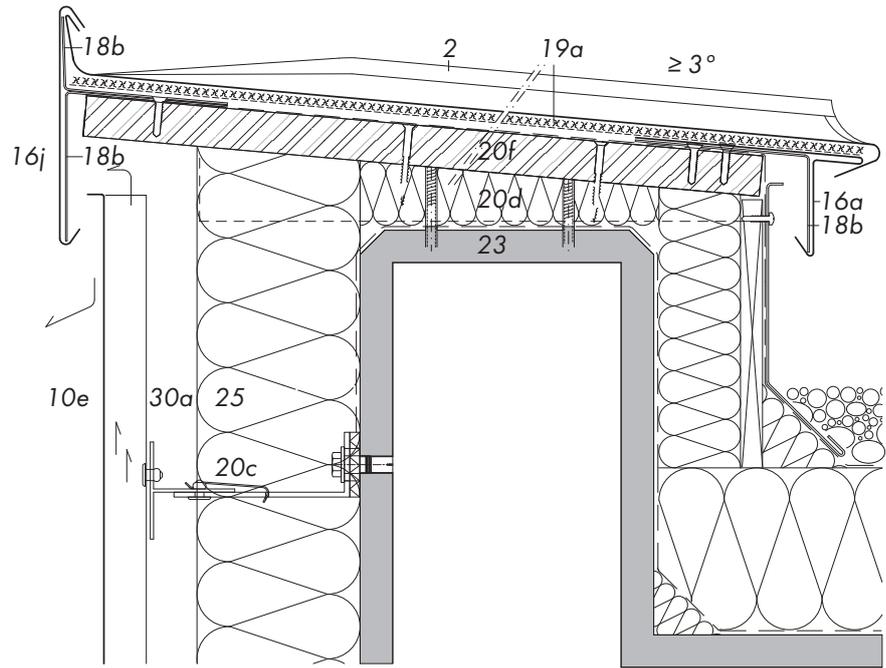
\*\* Manufacturers' guidelines must be complied with

REVEAL PANELS, DESIGN AND APPLICATION

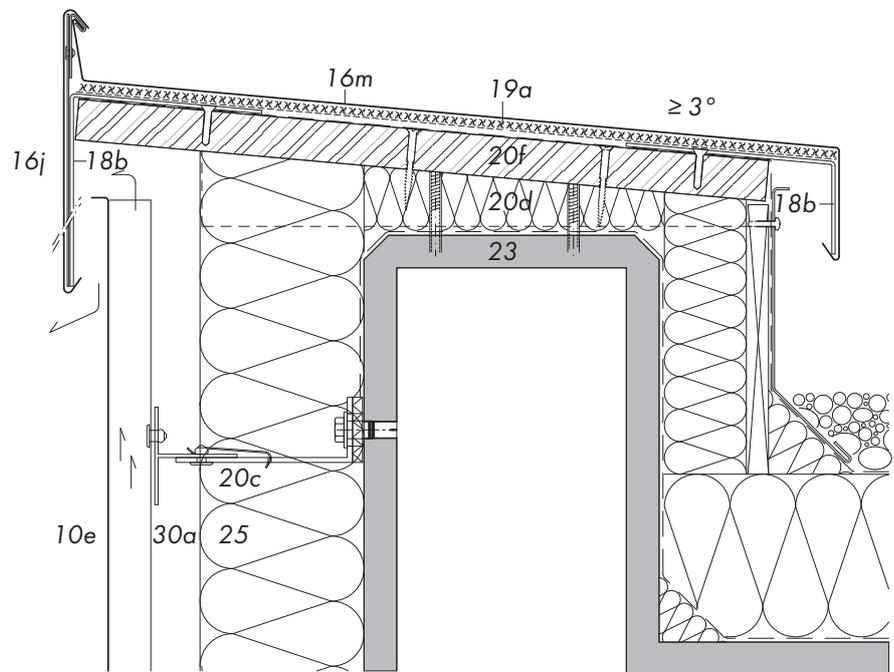
DESIGN – VERTICAL APPLICATION

DETAIL V3: WINDOW LINTEL

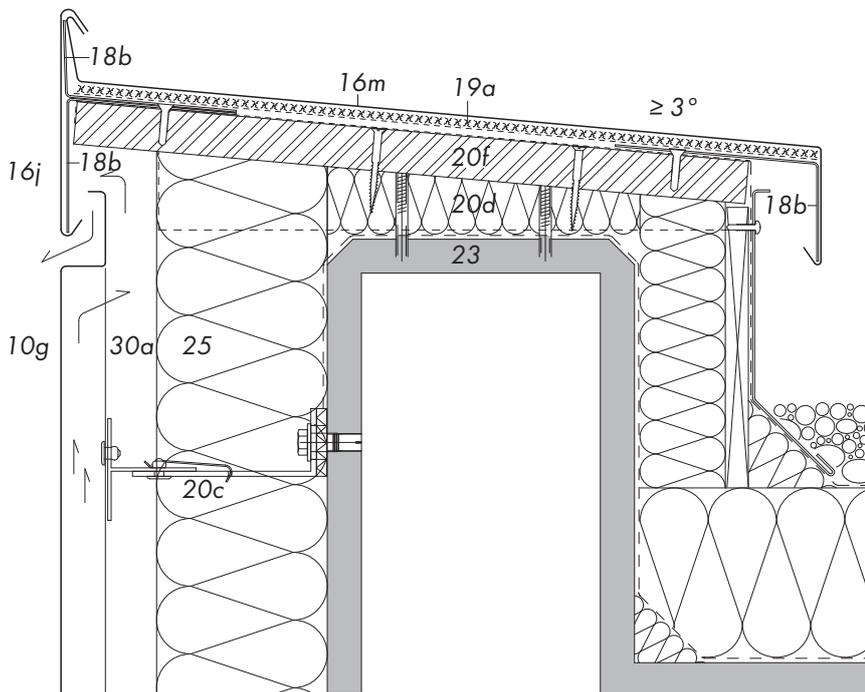
V4.1



V4.2



V4.3



**2.10.7 Detail V4: Two-Part Roof Edge**

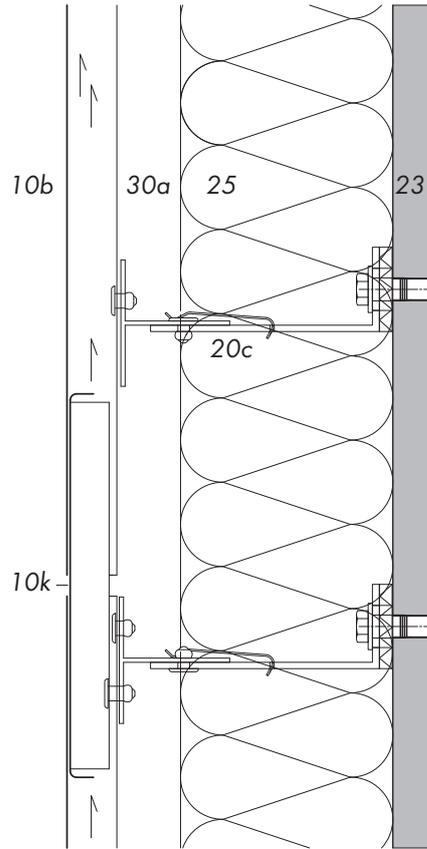
- 2 RHEINZINK-Double Standing Seam
- 10 RHEINZINK-Reveal Panel SF 25
  - e Standard panel, with stopend short, outward-facing
  - g Fitting panel, with bent up water drip
- 16 RHEINZINK-Building Profile
  - a Eaves flashing
  - j Fascia profile
  - m Wall coping
- 18 Support Profile
  - b Aluminium
- 19 Separating Layer
  - a Structured underlay VAPOZINC
  - Alternative: glued to support profile over entire surface
- 20 Substructure
  - c Bracket system, with thermal break\*
  - d Wood, wedge board
  - f OSB/veneer plywood sheathing, thickness min. 22 mm
- 23 Supporting Structure
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

\* Manufacturers' guidelines must be complied with

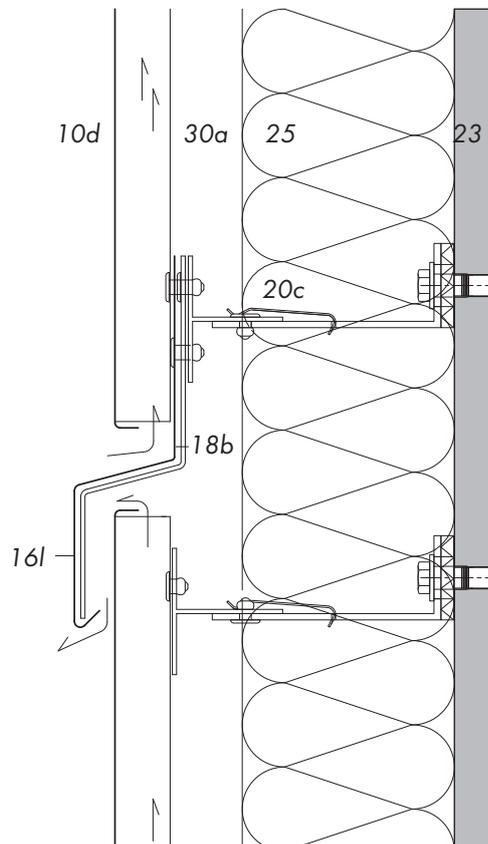
REVEAL PANELS, DESIGN AND APPLICATION

DESIGN – VERTICAL APPLICATION  
DETAIL V4: TWO-PART ROOF EDGE

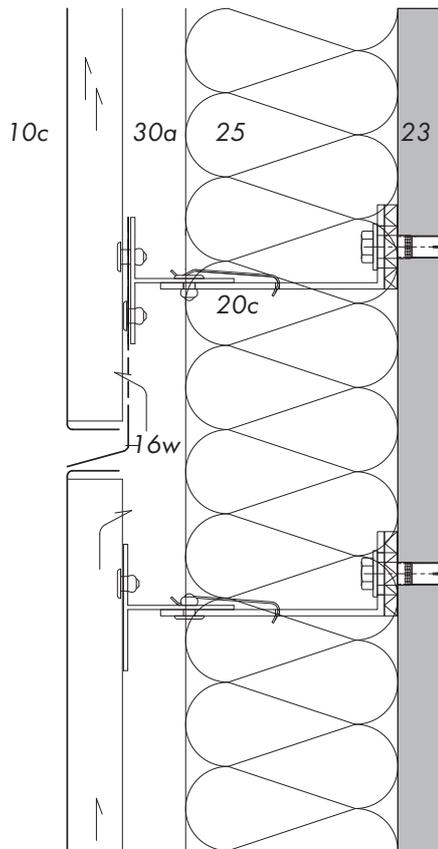
V5.1



V5.2



V5.3



**2.10.8 Detail V5: Expansion Joint**

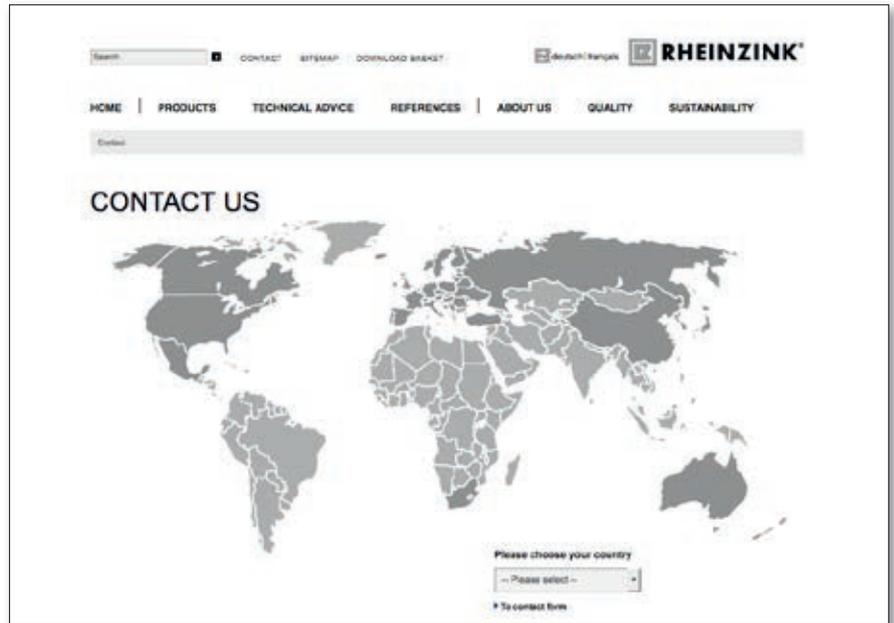
- 10 RHEINZINK-Reveal Panel SF 25
  - b Standard panel, without stopend
  - c Standard panel, with stopend
  - d Standard panel, with stopend short
  - k Slave profile, with stopends
- 16 RHEINZINK-Building Profile
  - l Cornice coping
  - w Shadow gap profile, partly perforated
- 18 Support Profile
  - b Aluminium
- 20 Substructure
  - c Bracket system, with thermal break\*
- 23 Supporting Structure
- 25 Thermal Insulation
- 30 Ventilated Air Space
  - a Depth of air space  $\geq 20$  mm

\* Manufacturers' guidelines must be complied with

CONTACT

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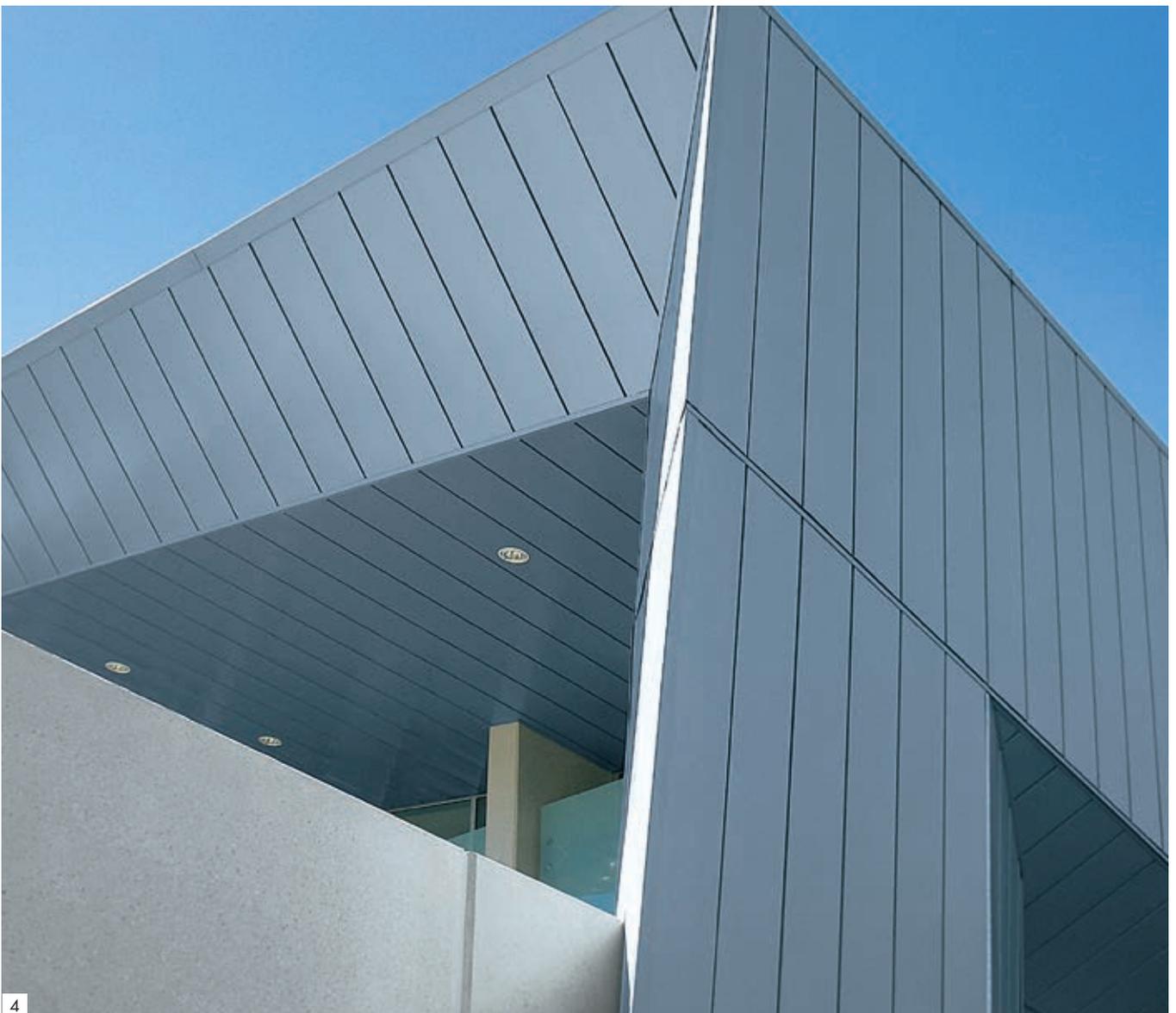
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REVEAL PANELS, DESIGN AND APPLICATION

REFERENCE PROJECTS





For other project references,  
please see  
[www.rheinzink.com](http://www.rheinzink.com)



**Titel: Universität Nottingham, Business School, Nottingham, Great Britain**

Architect: Michael Hopkins & Partners, London, Großbritannien

RHEINZINK work implemented by:

Carlton Building Services Ltd., Bolton, Großbritannien

**1. Airport, Bydgoszcz, Polen**

Architects: Pracownia Architektoniczna Arus sp. z o.o.,

Bydgoszcz, Poland

RHEINZINK work implemented by:

F.H.U. Budownictwa Krest, Niepołomice, Poland

**2./3. Columbarium, De Nieuwe Ooster Begraafplaats, Amsterdam, Netherlands**

Architect: Karres en Brands landschapsarchitecten, Hilversum, Netherlands

RHEINZINK work implemented by:

Loodgietersbedrijf C.J. Ockeloen v.o.f., Amsterdam, Netherlands

**4. Mt. Druitt Court House, Sydney, Australia**

Architect: Perumal Pedavoli Pty Ltd., Ultimo, Australia

RHEINZINK work implemented by:

Perumal Pedavoli Pty Ltd., Hornsby, Australia

**5. CargoLifter Werft, Briesen-Brand, Germany**

Architect: SIAT Architektur + Technik, Munich, Germany

SIAT Bauplanung und Ingenieurleistungen GmbH & Co. OHG

RHEINZINK work implemented by:

Thale Metallbedachung Bauklempnerei, Lingen/Ems, Germany

**6. Artemis Square, Brüssel, Belgium**

Architect: De Borman + Gerard, Brussels, Belgium

RHEINZINK work implemented by:

Platteau Dakwerken, Deurne, Belgium









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