



IMPACTPRO® SATIN

Installation Guide

Preparation - profiles - bonding - jointing - thermoforming - heat welding - handover

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BEFORE INSTALLATION

Pre-installation checks

- Confirm colour, finish and production batch before cutting. Keep a continuous elevation visually consistent.
- Install sheets in the same orientation throughout each area.
- Store sheets flat and condition in the installation room for approximately 24 hours.
- Maintain a minimum recommended installation temperature of 14°C.
- Confirm substrates are flat, sound, clean, dry and free from dust, grease and contamination.
- Confirm substrate moisture is no greater than 16% WME before fixing.
- Plan datum lines, corners, openings, joint positions and profile locations before cutting.

Recommended tools

Setting / measuring	Cutting / finishing	Bonding / site
Laser level; spirit level; tape measure; chalk line	Jigsaw; hacksaw; knife; tenon saw; round / square files; hole cutter	Mixing paddle; 6mm notched trowel; rubber mallet; clean workbench

PROFILES AND EDGE DETAILS

IMPACTPRO® profile components



External Angle

External-angle finishing profile.



1-Part Joiner

Single-part divider / joiner profile.



2-Part Joiner

Two-part joiner / transition profile.



1-Part Capping

Single-part edge / capping profile.



2-Part Capping

Two-part edge / capping profile.



Internal Angle

Internal-angle finishing profile.



Small External Corner

Compact external-corner profile.



Small Internal Corner

Compact internal-corner profile.

Setting out

- Set profile positions before sheet cutting and adhesive application.
- Use unjointed profile lengths between angles or ends of runs wherever practicable.
- Keep trim use to the minimum required by the project detail for a clean hygienic finish.

SHEET PREPARATION AND BONDING

1. Mark and dry-fit

- Inspect each sheet before marking. Mark datum and cut lines on the protective-film side.
- Cut to size using suitable tooling and PPE.
- Peel protective film back approximately 50mm from edges where required for insertion into profiles.
- Dry-fit and confirm approximately 3mm expansion clearance at inflexible supports.

2. Adhesive application

- Use IMPACTPUR® two-part polyurethane cladding adhesive.
- Mix and apply in accordance with the adhesive Technical Data Sheet and Safety Data Sheets.
- Apply adhesive to the sheet back with a 6mm notched trowel, working outwards from the centre.

3. Fixing sequence

- Present the sheet carefully to the substrate and work from the centre outwards to achieve full contact.
- Check datum, joint gap and alignment before adhesive initial set.
- Remove adhesive contamination immediately in accordance with the adhesive instructions.

JOINTING, CORNERS AND EXPANSION

Heat-welded joints

- Allow approximately 1.5mm gap between sheets for compatible weld rod.
- Keep the joint and weld rod clean and free from contamination.
- Set welding temperature and speed to the equipment, ambient conditions and material. Complete a test weld before production work.
- Allow the weld to cool before trimming. Trim flush without cutting into the sheet face.

Thermoformed corners

- Internal and external corners may be formed from the sheet using a thermoformer for a continuous hygienic detail.
- External-to-external marking dimension: add approximately 6mm.
- Internal-to-internal marking dimension: subtract approximately 6mm.
- Internal-to-external / external-to-internal: use the measured substrate dimension.

Expansion

- Allow approximately 3mm at inflexible supports such as door frames, ceilings, skirting and other fixed abutments.
- Seal exposed local edges with compatible hygienic silicone where required.

HANDOVER, CLEANING AND QUALITY CHECKS

Completion checklist

- All joints straight, consistent and fully finished.
- All exposed edges, profiles and corners secure and sealed as detailed.
- Protective film removed only after installation is complete.
- No adhesive, silicone or weld residue on finished faces.
- Door frames, penetrations and service interfaces sealed to the project detail.
- Allow adhesive and sealant to cure before final cleaning.

Initial and routine cleaning

- Use a soft cloth with a mild soap or detergent for routine cleaning.
- Cleaning solution should not exceed 60°C.
- For stubborn stains use a compatible alkaline cleaner with a soft cloth.
- Do not use abrasive pads or aggressive cleaners that could affect the satin finish.
- Where pressure cleaning is permitted, keep the nozzle at least 600mm from the sheet surface.