

# Paint Specification Glossy Standard Anodic

Properties	Norm	Results	Comments																
<b>Physical Properties</b>																			
1. Coating Thickness	EN 13523-1	18 ± 2 μ																	
2. Specular gloss topcoat, 60°	EN 13523-2	60-90 G																	
3. Pencil hardness	EN 13523-4	≥ F																	
4. Adhesion to cracking on rapid deformation	EN 13523-5	No cracks	7.5 N m/mm																
5. T-Bend	EN 13523-7	Processing within 2 months after delivery <table border="1"> <tr> <td>T-Bend</td> <td></td> <td>Ri rec.</td> <td>Ro rec.</td> </tr> <tr> <td>≥ 1.5</td> <td></td> <td>≥0.75mm</td> <td>≥1.25mm</td> </tr> </table> Processing later than 2 months after delivery <table border="1"> <tr> <td>T-Bend</td> <td>X</td> <td>Ri rec.</td> <td>Ro rec.</td> </tr> <tr> <td></td> <td>4,5</td> <td>≥1.4mm</td> <td>≥1.9mm</td> </tr> </table>	T-Bend		Ri rec.	Ro rec.	≥ 1.5		≥0.75mm	≥1.25mm	T-Bend	X	Ri rec.	Ro rec.		4,5	≥1.4mm	≥1.9mm	180° Ri rec: Recommended aluminium minimum inside bend radii (mm) Ro rec: Recommended minimum outside bend radii (mm) X: 3 x Normal T-bend value
T-Bend		Ri rec.	Ro rec.																
≥ 1.5		≥0.75mm	≥1.25mm																
T-Bend	X	Ri rec.	Ro rec.																
	4,5	≥1.4mm	≥1.9mm																
6. MEK / Solvent rubbing test	ECCA T11	≤ 100 double rubs																	
<b>Corrosion and Chemical Resistance</b>																			
7. Salt acid spray fog Resistance	EN 13523-8	Corrosion Index 2 according the EN 1396 table C4	After 1.000 hours testing																
8. Humidity Resistance	ASTM D-2247-68	No influence	After 1.000 hours testing																
9. QUV-B test	EN 13523-10 EN 13523-14	Slight colour change allowed ΔE ≤ 3 Gloss reduction ≤ 50 % of the original gloss Chalking ≤10 %	After 250h hours light cycle testing																

Anodic finishes are brushed aluminium protected by a transparent topcoat that protects the metal only and therefore small differences in chemical composition, lamination temperature, coil rolling, lubrication conditions and brushed operation of each coil, causes difference of tonality in the finished surface. Due to all these metal properties, each coil might have small tonality deviations.

# Paint Specification Matt Standard Anodic

Properties	Norm	Result	Comments																
<b>Physical Properties</b>																			
1. Coating Thickness	EN 13523-1	32 ± 2 μ																	
2. Specular gloss topcoat, 60°	EN 13523-2	10-60 G																	
3. Pencil hardness	EN 13523-4	≥ H																	
4. Adhesion to cracking on rapid deformation	EN 13523-5	No cracks	7.5 N m/mm																
5. T-Bend	EN 13523-7	Processing within 2 months after delivery <table border="1"> <tr> <td>T-Bend</td> <td></td> <td>Ri rec.</td> <td>Ro rec.</td> </tr> <tr> <td>≥ 1.5</td> <td></td> <td>≥0.75mm</td> <td>≥1.25mm</td> </tr> </table> Processing later than 2 months after delivery <table border="1"> <tr> <td>T-Bend</td> <td>X</td> <td>Ri rec.</td> <td>Ro rec.</td> </tr> <tr> <td></td> <td>4,5</td> <td>≥1.4mm</td> <td>≥1.9mm</td> </tr> </table>	T-Bend		Ri rec.	Ro rec.	≥ 1.5		≥0.75mm	≥1.25mm	T-Bend	X	Ri rec.	Ro rec.		4,5	≥1.4mm	≥1.9mm	180° Ri rec: Recommended aluminium minimum inside bend radii (mm) Ro rec: Recommended minimum outside bend radii (mm) X: 3 x Normal T-bend value
T-Bend		Ri rec.	Ro rec.																
≥ 1.5		≥0.75mm	≥1.25mm																
T-Bend	X	Ri rec.	Ro rec.																
	4,5	≥1.4mm	≥1.9mm																
6. MEK / Solvent rubbing test	ECCA T11	≤ 80 double rubs																	
<b>Corrosion and Chemical Resistance</b>																			
7. Salt acid spray fog Resistance	EN 13523-8	Corrosion index 2 according EN 1396, Table C.4	After 1.000 hours testing																
8. Humidity Resistance	ASTM D-2247-68	No influence	After 1.000 hours testing																
9. QUV-B test	EN 13523-10 EN 13523-14	Slight colour change allowed ΔE ≤ 3 Gloss reduction ≤ 30 % of the original gloss Chalking ≤10 %	After 250h hours light cycle testing																

Anodic finishes are brushed aluminium protected by a transparent topcoat that protects the metal only and therefore small differences in chemical composition, lamination temperature, coil rolling, lubrication conditions and brushed operation of each coil, causes difference of tonality in the finished surface. Due to all these metal properties, each coil might have small tonality deviations.

# Paint Specification Glossy Anodic 0.3 mm in Aluminium Thickness

Propierties	Norm	Results	Comments
<b>Physical Propierties</b>			
1. Coating Thickness	EN 13523-1	7.5 ± 0.5 μ	
2. Specular gloss topcoat, 60°	EN 13523-2	60-90 G	
3. MEK / Solvent rubbing test	ECCA T11	> 100 pasadas dobles	
<b>Corrosion and Chemical Resistance</b>			
4. Salt acid spray fog Resistance	EN 13523-8	N/A only for indoor use	After 1.000 hours testing
5. Humidity Resistance	ASTM D-2247-68	N/A only for indoor use	After 1.000 hours testing
6. QUV-B test	EN 13523-10	N/A only for indoor use	After 250h hours light cycle testing
	EN 13523-14		

Anodic finishes are brushed aluminium protected by a transparent topcoat that protects the metal only and therefore small differences in chemical composition, lamination temperature, coil rolling, lubrication conditions and brushed operation of each coil, causes difference of tonality in the finished surface. Due to all these metal properties, each coil might have small tonality deviations.

