

TECHNICAL SHEET

CUSTOMER:

Order Confirmation:

TS: E-1353 00

Rev07 06.05.11

PRODUCT:

1 Product definition

1.1 Aluminium alloy	EN-AW 5005 in accordance with EN 573/3
1.2 Metal thickness (mm)	1,00
1.3 Temper	H42 in accordance with EN 515
1.4 Colour top side	AC 23G2 in accordance with internal standard
1.5 Colour backing coat	AC 6325 in accordance with internal standard
1.6 Paint top side	Highly durable modified Polyurethane
1.7 Paint backing coat	PE - Alchydric
1.8 Width and Length (mm)	in accordance with order specifications
1.9 Metal Finish	MF
1.10 Surface Type	Standard

**RAL
7024**

2 Metal specification

2.1 Mechanical properties after coating in accordance with EN 1396 (transverse to rolling direction) @Room Temperature

Rm:	MPa	125 ÷ 165
Rp0,2:	MPa	80 min.
A50mm:	%	5 min

2.2 Tolerances on dimensions

Thickness: in accordance with EN 485/4
Width and Length: in accordance with EN 485/4

3 Pre-treatment

Degreasing and chromium free treatment on top and reverse side

4 Organic coating specification

		Top side	Backing coat
4.1 Paint system		23G2/48	6325/40
4.2 Coating thickness	EN 13523 - 1 μm	24 (min. 21)	approx. 4
4.3 Pencil hardness	EN 13523 - 4 KOH-I-NOR	H	
4.4 Specular gloss to 60°	EN 13523 - 2 units	40 ± 5	
4.5 Adhesion 90°/180°	%	100	
4.6 Adhesion on cross hatch+impact	%	100	100
4.7 Resistance to rapid deformation	EN 13523 - 5 joule	32	
4.8 Resist. to craking on the bending	EN 13523 - 7 n°T	0,5	
4.9 Top side colour difference	DeltaE	0,90 in accordance with internal Standard Nr. 2.290 rev. 000	

5 Protective strippable film

5.1 Novelis code	D
5.2 Material	LDPE
5.3 Thickness	Approx. 80 μm
5.4 Colour	B & W with arrows

Note: this technical sheet is referring to the above mentioned order confirmation. Without reference to the order confirmation number, this technical sheet has to be considered for information only and could be submitted to revision.