

Aludecor Compliance Statement

S.No.	Parameters	Unit	Standards	Aludecor AL 33D
Technical Property of Panel				
1	Tensile Strength	Mpa	ASTM E8	Minimum 30
2	0.2% Yield Strength	Mpa	ASTM E8	Minimum 24
3	Peel Strength	N/mm	ASTM D903	Minimum 4
4	Elongation	%	ASTM E8	Minimum 5
Technical Property of Skin				
5	Tensile Strength	N/mm ²	ASTM E8	Minimum 150
6	0.2% Yield Strength	N/mm ²	ASTM E8	Minimum 120
7	Elongation	%	ASTM E8	Minimum 2
Technical Property of Surface				
8	Gloss (60°)	%	ASTM D523-89	15-80
9	Hardness Pencil	min	ASTM D3363-92a	H
10	Adhesion: Dry Wet Boiling water	ASTM D3359, method 8 37.8°C, 24 hrs. 100°C, 20 min.	No pick off No pick off No pick off
11	Abrasive resistance	litres/mil	ASTM D968-93 (Falling sand)	40
12	Chemical Resistance: Muriatic acid, 10%HCl, 72hrs Sulphuric acid, 20%H ₂ SO ₄ , 18hrs Sodium hydroxide, 20%NaOH, 1hr Mortar, pat test, 24hrs Detergent, 3% solution, 38°C, 72hrs	ASTM D1308-87 ASTM D1308-87 ASTM D1308-87 AAMA2605 ASTM D2248-93	No change No change No change No change No change
13	Weather-o-meter test Colour retention: Gloss retention: Chalk resistance:	ASTM D2244-93 ASTM D523-89 ASTM D4214-89	Maximum 5 units after 4000 hrs. 70% after 4000 hrs. Maximum 8 units after 4000 hrs.
14	Salt spray resistance	Hrs	ASTM B117-90	Blister-10, scribe-8, after 4000 hrs., 35°C salt fog
Product Composition				
15	Panel thickness	mm	3
16	Panel size	mm	Width = 1220 mm ; Length = less than 7200 mm
17	Alloy	ASTM B209M	AA 3105
18	Skin Thickness	mm	0.3

19	Core material	LDPE (Virgin LDPE/First Grade Recycled LDPE)
20	Coating Type	AAMA 2605	PVDF based fluorocarbon coating
21	Coating Thickness (Front Coil)	AAMA 2605	Three Coat 30-35 microns
22	Coating Thickness (Back Coil)		AAMA 2605	4 μ to 7 μ Service Coat
23	Coating warranty	AAMA 2605	20 yrs
24	Adhesive Film	80 μ
Tolerance				
25	Tolerance in Width	mm	\pm 2.0 mm
26	Tolerance in Length	mm	\pm 4.0 mm
27	Tolerance in Thickness (Panel)	mm	\pm 0.2 mm
28	Tolerance in Thickness (Coil)	mm	\pm 0.03 mm
29	Squareness	mm	Maximum 5.0 mm
30	Bow	mm/m	Maximum 0.5% of width and / or length