

Fluoropolymer-based*) Coating Systems on ALUCOBOND®

General Properties	Test Method and Description				Results	Remarks
	ASTM	AAMA 620	DIN	ECCA		
Physical Properties						
Dry Film thickness	D1400-87	-	EN 13523-1	T 1	27 ±3 µm	two-coat-system**)
Gloss at 60°	D523-89	7.2	EN 13523-2	T 2	25 – 40***)	
Colour Matching	D 2244-89	7.1	EN 13523-3	T 3	0,3 - 0,9	corresponding to DIN 6175 Part 1
Pencil Hardness	D 3363-74	7.3	EN 13523-4	T 4	HB-F	
Coat Adhesion (cross-Cut Tape Test)	D 3359-90	7.4	53151	-		
- dry					Gt 0	„Gt 0“ means the best possible result, i.e. no loss of adhesion
- wet	24 h at 100°F (100° F = 37,78 °C)				Gt 0	
- boiling water	20 min at 210 - 212 °F (=98,9 - 100°C)				Gt 0	
Flexibility ☺						
- T-Bend		7.6	-	T 7	1 T	no cracking or tape removal of film
	D 4145-83				2 T	
- Reverse Impact	D 2794-90	7.5	EN 13523-5	T 5	40 in.-lb	
Abrasion Resistance	D 968-81	7.7	-	-	>50 liters per mil	
Corrosion and Chemical Resistance						
Solvent Resistance			EN 13523-11	T11	≥ 100	M.E.K., double rubs
Detergent Resistance	D 2248-89	7.8.4	-	-	no change	
Mortar Resistance	D 3260-82	7.8.2	-	-	no change	metallic: 3-coat system
Acid Resistance	D 1308-87	7.8.1	-	-	no change	metallic: 3-coat system
Alkali Resistance	D 1308-87	-	-	-	no change	metallic: 3-coat system
Humidity	D 2247-87	7.9.1	50017KK	similar T 9	no change	3000 h
Salt Spray	B 117-90	7.9.2	EN 13523-8	T 8	passed	3000 h
Acid Rain Test (SO ₂ -Resistance)	-	-	EN 13523- 23, 2l SO ₂	T 23	no corrosion, no blistering	5 rounds, one round is 24 h
Weathering Properties						
Florida Exposure 45° south	-	7.10.1	-	-		
- Colour Retention	D 2244-89	7.10.1.2	EN 13523-3	T 3	max. 5 units	the values are valid for 10 years Florida exposure
- Gloss Retention	D 523-89	7.10.1.4	EN 13523-2	T 2	min 50 %	
- Chalking	D 4214-89 Method A	7.10.1.3	EN 13523- 14	T 14	max. rating 8	
Accelerated Weathering	G 53-88 D 4587-91 Method B	-	53384 Method A	T 10		
- Colour Retention	D 2244-89	-	EN 13523-3	T 3	max. 5 units	the values are valid for 7000h accelerated weathering
- Gloss Retention	D 523-89	-	EN 13523-2	T 2	min. 50 %	
- Chalking	D 4214-89 Method A	-	EN 13523- 14	T 14	max. rating 8	

*) PVDF-based (Polyvinylidenfluorid) and FEVE-based (Fluoro Ethylene-Alkyl Vinyl Ether) coatings

***) three-coat systems: 37 ±3 µm

***) up to 85% for special effect colours and on request (please refer to colour chart)

ASTM = American Society For Testing and Materials

AAMA = American Architectural Manufacturers Association

DIN = German Standard, Deutsches Institut für Normung e.V. (DIN EN: based on European Standard)

ECCA = European Coil Coating Association