

## STANDARD SPECIFICATIONS

### 1. Alloy Specification :

S.no	Alloy series & temper	Top skin	Bottom skin
1	AA 1100 H16 /18	AA 1100 H16 /18	AA 1100 H16 / 18
2	AA 3003 H16	AA 3003 H16	AA 3003 H16
3	AA 3005 H 42	AA 3005 H42	AA 3005 H42
4	AA 3105 H 16 (ALUBOND GREEN)	AA 3105 H16	AA 3105 H16
5	AA 5005 H24 /42	AA 5005 H24 /42	AA 5005 H24/42

### 2. Gauge Specifications:

S.no	Standard skin gauges	Proposed combinations
1	0.50/0.50	0.50/0.50
2	0.40/0.40	0.40/0.40
3	0.30/0.30	0.30/0.30
4	0.21/0.21( for interior purpose only)	0.21/0.21( for interior purpose only)

### 3. Dimensional specifications

S.no	Standard width(mm)	Standard length (mm)	Standard thickness (mm)
1	a) 1000, b)1250, c)1500, d) 1550	a) 2440 b) 3200 c)6000	a) 4      b) 5      c) 6

### 4. Paint finishes

S.no	Paint finishes	Area of applications	durability
1	PVDF (Standard)	Exterior/Interior	Min 10 years
2	LUMIFLON	Exterior/Interior	Min 10years
3	HDPE	Exterior/Interior	Min 7 years
4	PE(Polyester)	Interior only	Min 5 years
5	ANODIZED	Interior	Min 5 years

## 5. Mechanical properties

5	<b>Section modulus(W)</b>	DIN 53293	cm <sup>3</sup> /m	1.62	1.7	1.75
6	<b>Rigidity (Poisson's ratio <math>\mu = 0,3</math>)</b>	DIN 53294	KN cm <sup>2</sup> /m	2300	2320	2400
7	<b>Alloy</b>	EN 573-3	.....	EN AW-1100	EN AW-3105	EN AW- 5005A (Al mg1)
8	<b>Temper</b>	EN 515	....	H16/H18	H14/H16	H22/H42
9	<b>Modulus of Elasticity</b>	EN 1999 1-1	N/mm2	68900	68900	70000
10	<b>Tensile Strength of Aluminium</b>	EN 485-2	N/mm2	R <sub>m</sub> ≥ 135	R <sub>m</sub> ≥ 140	R <sub>m</sub> ≥ 145
11	<b>0.2% Proof Stress</b>	EN 485-2	N/mm2	R <sub>po</sub> ≥ 85	R <sub>po</sub> ≥ 90	R <sub>po</sub> ≥ 95
12	<b>Elongation</b>	EN 485-2	%	A <sub>50</sub> ≥ 6	A <sub>50</sub> ≥ 5	A <sub>50</sub> ≥ 5
	<b>Linear Thermal Expansion</b>	EN 1999 1-1	mm/m @100°C	2.36	2.36	2.4

Peel off strength- minimum 130 Nmm/mm – ASTM D 1781

- For standard two coat the paint thickness Min 25 µm; if three coat the paint thickness is min 35 µm.

## 6. Core specifications:

S.no	Standard Core	Fire classification standard	Rate of classification
1.	Standard polyethylene core	DIN 4102-1	Class B2

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## 7. Aluminum composite panel tolerances

S.no	Parameters	Tolerance
1	Width	± 2mm
2	Length	± 4mm
3	Thickness	±0.2 mm up to 4 mm ; ±0.3 up to 6mm
4	Bow	Max 0.5% length or width
5	Squareness	5mm max
6	Spot	Maximum size ≤ 3mm
		Not more than 3 spot/m <sup>2</sup>

## 8. Wind resistance and panel dimensions

