

# ESPECIFICACIONES DE ACABADO FINISH SPECIFICATIONS

## REAL ANODIZED

Thickness <i>EN 12373-3</i>	8μ
Specular gloss topcoat <i>EN 12373-11</i>	Gloss measured by 60° Gardner: <b>Depending on specific colour</b>
Building Inspection Report	<b>Anodized finish is a natural aluminium oxidation and it will be have its own evolution over time.</b> <b>Micro-crazing is a propriety of this finish and it will be not visible at an inspection distance of 3 m.</b> <b>A beta effect is a property of Anodized finish.</b>
Aluminium Alloy	<b>EN-AW-5005A</b>
Micro-Crazing <sup>(*)</sup> :	It could appear such as thin white lines during aggressive bending and curving process of the panel. Crazing has no effect on corrosion of the panel. The crazing will be more visible in darker colours.
Bending Radius Recomendated T-Bend <i>EN 13523-7</i>	.1. If Anodized aluminium is folded, the anodic fillm of aluminium oxide will crack and micro-crazing will be formed. . 2. The surface must be protected by a protective film to avoid any marks of the folding machine jaws on the surface (black lines). .3. Bending radius <b>Folding at 90 °: 1.5T</b> <b>Folding at 180°: 2.5T</b> <i>More information in the Technical Recommendations of Real Anodized Sheet</i>
Corrosion resistance: Neutral salt spray test <i>ISO 9227</i>	1000 hours testing <b>No pitting corrosion attack.</b> <b>No preferential corrosion on bent, deformed or machined parts of the samples.</b> <b>No filiform corrosion.</b>
Arrow sense	To avoid difference of tonality, it is recommended <b>to follow the arrow sense printed in the protector film.</b>
Technical considerations for cut to edges	Special attention should be given on the cleaning of the cut line before processing, including: 1. Removal of aluminium particles. 2. Avoid too much pressure which can damage the anodic layer. <u>Cut edges</u> Unlike paint, anodising does not suffer from filiform corrosion and, therefore, there is no risk of the propagation of corrosion affecting the flat surfaces of the sheet after cut-to-edges. The cut surface of the aluminium will oxidise naturally and rapidly, thereby ensuring adequate surface protection of the cut surface. <i>More information in the Technical Recommendations of Real Anodized Sheet.</i>

(\*)Crazing is the micro-cracking of the anodic film. This crazing, which is perfectly uniform, is a property of the continuous anodised aluminium; it does not affect or weaken it.

The handling of continuous anodised products must be carried out by personnel with experience with this type of material. This product is very sensitive, any non-uniform tension or stress created in the metal can generate non-uniform crazing. Therefore, throughout the transformation process, each piece of equipment (leveler, cut, slitting machine, swaging etc.) must be set-up to take account of this sensitivity.

The packaging of the material must be undertaken without introducing any non-uniform tension in the metal.

Failure to observe the above precautions can cause:

- . Increased micro-crazing
- . Creation of non-uniform micro-crazing (which will result in in non-uniform appearance)
- . In some cases the destruction of the anodic film layer (blemishes, dust etc.)

More information in the Technical Recommendations of Alucoil Sheet, where it is include the handling process (cut, bending and curving), sense of the installation, maintenance and cleaning the Real Anodized panels.