



## Painted Aluminum Spec Sheet

### Painted Aluminum Specification Data

- Material conforms to ASTM B 209
- Aluminum Alloy - 3105-H14/24 or 3003-H14
- Materials are pretreated, primed and coated with a polyester finish
- Standard Finish - Gloss, Matte available
- Standard Stock Gauges: .040, .063, .080
- Other Available Gauges: .024, .032, .050
- Standard Width: 48", 60"
- Standard Length: 96", 120"
- Protective Coating: Vinyl (PVC), Liner (Removable)
- Various colors available

### Application

Sign and graphics industry: vinyl receptive, screenprint, UV flatbed\*/Latex routable, bendable.

*\*Results may vary on certain printers*

POP, Channel Letters, Sign Cabinets, Wayfinding, Sign Blanks, Real Estate, Site Signs, Advertising

### Storage

Aluminum sheets to be stored flat in a clean, temperature controlled, moisture free environment.

### Applicable Test Standards

Test Method	Description
Viscosity ASTM D4212 (#4 Zahn Cup)	20 to 35 seconds
Weight per Gallon: ASTM D1475	9 to 12 lbs/gallon
Solids by Volume: ASTM D2697	40% to 53%
Solids by Weight: ASTM D2369	55% to 65%
Peak Metal Temperature	420°F to 450°F
MEK Double Rubs: NCCA II - (18)	100
VOC (Theoretical): ASTM D3960	3.5 to 4.5 lbs/gallon
Flash Point: ASTM D3278	125°F
System Dry Film Thickness: NCCA II - (13)	0.6 to 0.7 Mil. Total
Salt Spray 500 Hours: ASTM B117	Creep From Scribe $\leq$ 1/8 inch, Few No. 8 Blisters
Dry Heat 168 Hours, 140°F	No Opening
Humidity 100% RH 1,000 Hours: ASTM D2247	Few No. 8 Field Blisters
Water Immersion 168 Hours 100°F: ASTM D870	No Loss of Adhesion

### Properties & Characteristics

Gloss (60° Head): ASTM D523	20 to 80
Pencil Hardness: ASTM D3363	F to 2H
T-Bend: NCCA II - (19)	0T to IT
Cross Hatch Adhesion: NCCA II - (16)	No Loss of Adhesion
Reverse Impact: ASTM D2794	1 1/2 x Metal Thickness Inch-Pounds, No Loss of Adhesion