

## ALUBOND U.S.A REAL ANODIZED

### ANODIZED TREATMENT SPECIFICATION SHEET:

#### Enhanced anodized surface properties :

- **Anodic layer thickness:**
  - o Measured following Eddy Current method (ISO 2360)
  - o guaranteed value of minimum 7-8  $\mu\text{m}$ , at any point on the surface
- **Sealing of the anodic layer**
  - o Weight loss test following EN ISO 3210:2010 (method 1) o Results < 20mg/dm<sup>2</sup>
- **Continuity of the anodic layer**
  - o Continuity test following EN ISO 2085:2010
  - o Results : no points per cm<sup>2</sup>
- **Visual surface appearance:**
  - o Uniform and metallic appearance
  - o No defects visible at an inspection distance of 3 m
  - o Crazeing due to thermal gluing, not visible at 3 m distance
- **Gloss :**
  - o Measured at 60°// following EN ISO 7668:2010 expressed in Gloss Units (GU)
  - o Gloss tolerances can be agreed depending on the used substrate

#### The surface is resistant to<sup>1</sup>:

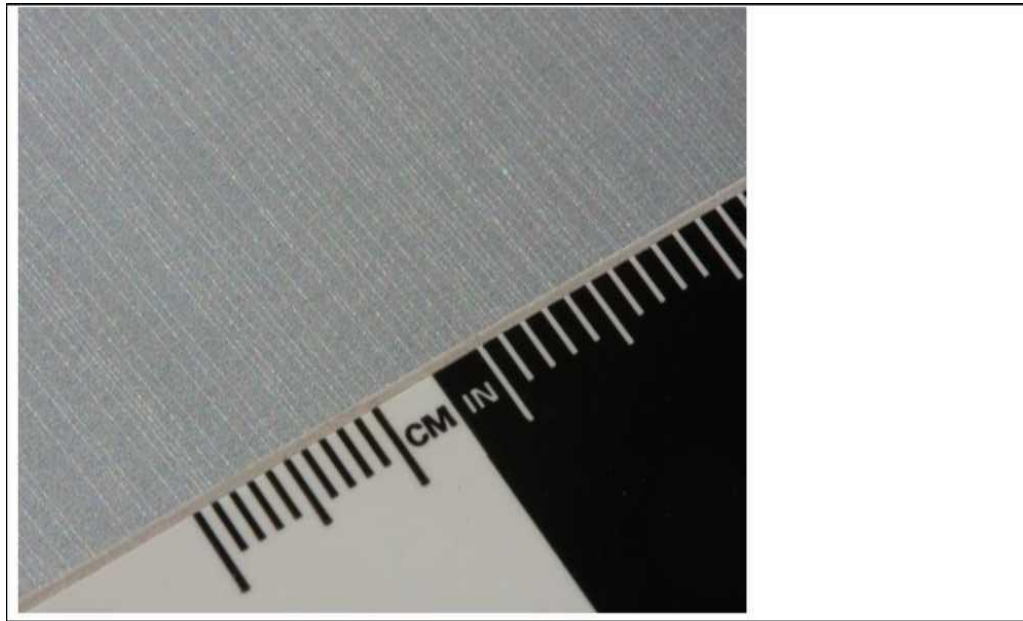
- filiform corrosion & weathering
- Fading due to light & UV influences
- Chalking
- Finger printing

#### Aluminum substrate properties:

- Mechanical properties following DIN EN 485-2
- Dimensional tolerances following DIN EN 485-4
- Alloy EN-AW 5005, but other alloys possible on request
- Temper: typically H14 or H24 but other tempers available on request
- Anodizing Quality

#### Crazing:

- No influence on corrosion resistance (checked in lab and practice)
- Crazeing very sensitive to handling after continuous treatment, like leveling, CTL, slitting => know-how to handle anodized material.
- Limited visual impact and no detrimental impact on the final appearance



- Typical phenomena on pre-anodized aluminum
- Crazing = micro-cracking of the anodic layer
- Perpendicular to the rolling direction
- Homogeneous - not visible at 3m distance

#### Definitions:

- Clear anodizing: the anodic layer is transparent, not colored. The observed surface color is that of the aluminum substrate. Also known as "natural" anodizing.
- Architectural anodizing: anodizing process specifically designed for architectural applications.
- Enhanced anodizing: the classical anodizing process has been modified in order to meet the above mentioned properties.
- Coil anodizing: anodizing of aluminum coils in a continuous treatment process

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