

## Technical data sheet Luxe powder

### Powder polyester coated aluminium

<b>Basic alloys</b> (chemical composition uni en 573-3 1996 norm)	<b>Physical estate</b> (in accordance with UNI EN 485-2 norm)
Family 1000 – 3000 – 5000	H42 – H44 – H46 – H47 – H48 – H111

#### Allowance tolerance

**width**

35-200 mm	201-350 mm	351-600 mm	601-900 mm	901-1500 mm
+/-0.2	+/-0.3	+/-0.5	+/-1.0	+/-1.5

**Thickness (without paint)**

Punctual	Average*
0.700-3.000 mm	0.700 – 3.000 mm
+/- 8%	+/-6%

\*:average tickness =  $(D^2-d^2) \times \pi / (4000 \times L)$

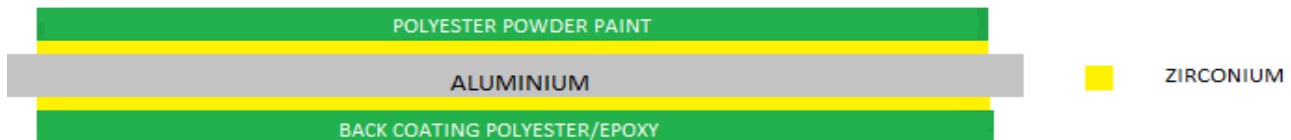
D= outside diameter mm; d= inside diameter mm; L= length mt.

#### Chemical pre-treatment

Before being painted, the aluminium undergoes two chemical degreasing processes and the zirconium treatment

#### Paint features

Painted side	Type of resin	Film basis weight	Film thickness	Gloss
Upper side	Polyester powder paint	-	Min 50 µm	30-90°
Underside	Back coating polyester/epoxy Or only zirconium	≈ 5 g/m <sup>2</sup> -	≈ 4 µm -	10-90° -



#### Technical characteristics of the painted surface

Adherance	AICC n°1 (erichsen +strap with adesive tape) AICC n°7 (checks method)	
Resistance to Metilethilchetone	100 double shots	
"T bend" test	Until to 1,2mm : 0,5t >1,2mm ≤ 1,5mm : 1t >1,5mm ≤ 2,0mm : 1,5t >2,0mm ≤ 3,0mm : 2t	
Shot at 50 cm	ok	
Gloss test	Unit	Tolerance
	30-40	+/-5
	40-79	+/-7
Colour measure	Pastel and white colour	ΔE ≤ 1.0
	Metallic colour	ΔE ≤ 1.75
Saline spray	Depending on basic alloys used (astm D714-85)	
Saline acetic spray	Depending on basic alloys used	
U.V. test	Good (500 h)	
Reaction to fire	A1 (EN 13501-1-2018)	

**Painted according to UNI EN 1396**

**Protective film features:** protective film 50/70 micron UV resistant