



## Condensed Paint and Metal Specifications

Listed below are the condensed specifications on the paint, metal preparation, and finished coating for aluminum gutter coil.

1. The mechanical properties on coated and mill finished coils shall conform to Aluminum Association Standards & Data & ASTM B 209: 3105 H24 must show no evidence of metal fracture when subject to a 1T (folded back on thickness of sheet on another) 180 degree bend in the longitudinal (direction of rolling) direction when viewed by the unaided eye.
2. Samples from each coated coil shall be capable of withstanding the bend test as follow:
  - a. ASTM D 4145-83 "Standard Test Method for Coating Flexibility of Pre-Painted Sheet"
  - b. NCCA Technical Bulletin 4.2.8 "Test Method for Evaluation of Adhesion and Flexibility by the T Bend Test"
  - c. Coated metal must show no evidence of paint fracture when subject to a 2T (two times metal thickness) 180 degree bend in the longitudinal (direction of rolling) direction when viewed by the unaided eye
3. The coated metal will be controlled to the approved master standard by approved color gloss meter. Determined at a gloss meter angle of 60 degrees to original standard must be controlled to (unless specified differently):
  - Low Gloss Top Coats - +/-3.0
  - Medium Gloss Top Coats - +/-5.0
  - High Gloss Top Coats - +/-10.0
4. The coated metal Topside coil finish - 0.65 - 0.90 mil. (unless specified differently). The coated metal Reverse Side coil finish - 0.15 - 0.40 mil. (unless specified differently).
5. The physical test used on our coated - panels includes:
  - a. 180° - 2T tape, Scotch Brand #610
  - b. Reverse Impact = (Positive) tape, Scotch Brand # 610, after impact 1.5 times metal thickness, 5/8" steel ball on Gardner Impact Test
  - c. Pencil hardness = F-2H minimum, Eagle Turquoise Brand
  - d. M.E.K. 100 Double rubs using Cheesecloth - mesh size 28 x 24.

More Detailed Information Available Upon Request