

SPECIFICATIONS

Test	Criteria & Tolerance
Mechanical Properties of Aluminium Skin (Cover Sheets)	
Alloy	1100/ 3105, 3003/ 5005
Temper	H18/ H24, H22/ H42
Tensile Strength of Aluminium Skin (Rm)	≥ 130
0.2% Proof Stress (Rp 0.2)	≥ 90
Elongation A50	≥ 5%
Rigidity (EJ kNcm ² /m)	4mm = 2400
Modulus of Elasticity (N/mm ²)	70,000
Linear Thermal Expansion	2.4mm/m at 100°C Temperature
General Specifications of Almaxco Aluminum Composite Panel Sheets	
Pencil Hardness PVDF Coating	HB
Impact Resistance (Ball Drop) 50kg/cm	No split after reverse impact test with cross cutting
Humidity Resistance	3000 hours, No Change or Blister
Salt Spray Resistance	5% Salt for 3000 hours, No Change or Blister
Solvent Resistance	200 times MEK, No Change
Chemical Resistance	5% HCL or 5% NaOH for 24 Hours, No Change
Boiling Water Resistance	100°C (+/-2°C) for 2 hours
Cleaning Agent Resistance	Isopropyl Alcohol, Ethanol Absolute 46.7% No Change
Oil Resistance	No Trail
Abrasive Resistance	50 - 80 KTR, No Crack
Temperature Resistance	- 50°C to +80°C
Coating Specifications & Tolerance	
Minor Surface Coating Flaws	≤ 3/m ²
Color Variation Tolerance Solid Colors (PVDF, Polyester, FEVE)	Δ ≤ 2
Color Variation Tolerance Mettalic Colors (PVDF, Polyester, FEVE)	Δ ≤ 2
Color Variation Tolerance (Wooden/Granite PVDF Coating)	Δ ≤ 4
Gloss Range for PVDF	20% - 45%
Gloss Range for Polyester & FEVE	30% - 90%
Acceptable Gloss Reading Tolerance	+/- 10%
T-Bending for Polyester Paint	1T
T-Bending for PVDF, NANO, FEVE	2T
Coating Thickness for Polyester	≥17-20μm
Coating Thickness for PVDF/FEVE	≥25-28 μm
Coating Thickness for NANO	≥30-33 μm
Dimension Tolerances	
Thickness of Aluminium Skin	+/- 0.02mm
Thickness of Panel	+/- 0.2mm
Length (mm)	+/-3mm
Width (mm)	+/-2mm
Diagonal Difference (mm)	≤3/mm