

TECHNICAL DATA SHEET

Dark Bronze Matt ColorIn® Architectural Class I

Finish Description: Dark Bronze Matt ColorIn® Architectural Class I is a finish developed for exterior applications where UV fade resistance is critical to the designer. The Dark Bronze Matt ColorIn® Architectural Class I finish utilizes a specialized anodizing process using a two-step electrolytic coloring system. The combination of an Architectural Class I film thickness with the inorganic coloring chemistry provides exceptional corrosion resistance and will maintain color consistency under harsh weathering conditions.

Reference Part Number (s)

0910-750-001

Industry Designations

Aluminum Association

AA-M12-C23-A44

Mil A-8625F Classification

Type II Sulfuric Anodize

Industry Standards

AAMA 611-12

Voluntary specification for anodized architectural aluminum

ISO 9001: 2008

Quality management system

Mil A-8625F Anodizing Standard

Anodic coatings for aluminum and aluminum alloys

Aluminum Properties

Alloy: 5005

Temper: H34

Finish: Mill Finish

Mechanical Properties

UTS: 20-26 ksi [138-179 MPa]

YTS: 15 min [103 MPa]

Elongation: 4% - 5% min

T Bend: Recommended 1t - 2t, min

Chemical Properties

Si: 0.30 %

Fe: 0.7 %

Cu: 0.20 %

Mn: 0.20 %

Mg: 0.50—1.1 %

Cr: 0.10 %

Zn: 0.25 %

Other: 0.15 %

Al: Remainder

Stock Gauge Availability ¹

0.032" (0.8 mm)

0.040" (1.0 mm)

0.050" (1.3 mm)

0.063" (1.6 mm)

0.080" (2.0 mm)

Stock Width Availability ²

48.0" (1219 mm)

Anodize Film Thickness

Architectural Class II:

0.700 mils [17.8 μm] minimum

Anodize Finish Properties ³

Optical: Not Applicable

Gloss: Coarse Matte

Color : D043, Dark Bronze

Color Target: < Delta E of 5.0

UV Stable: Yes

Environment: Exterior

Seal: S1, Duplex Seal I

Quality Grade: 2

Other: ColorIn®

Footnotes: 1 - Other gauges can be custom ordered. 2 - Other widths can be custom ordered. 3 - Panel-to-Panel match quality can be custom ordered.



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Aluminum Secondary Services

- Shearing, Width Capabilities:**
7" (178mm) - 62" (1575 mm)
- Shearing, Length Capabilities:**
Up to 192" (4876 mm)
- Shearing, Loading Gauge:**
Up to 0.080" (2.0 mm)
- Slitting, Width Capabilities:**
0.75" (19 mm) min
- Slitting, Loading Gauge:**
Up to 0.100" (2.5 mm)
- Other Secondary Services:**
Protective peel-able films
International packaging
Perforating and embossing

Maintenance and Cleaning

The anodized aluminum finish can be washed with mild soap and water followed by a clean water rinse. For more information on cleaning anodized aluminum, please refer to the Aluminum Association Publication 92, Care of Aluminum or AAMA 609 & 610-09, Cleaning and maintenance guide for architecturally finished aluminum.

Sustainability and LEED

- Recycled Content, 5005 alloy:**
100% recyclable
Recycled Content, 6.6%
Reclaimed-Virgin Material, 93.4%
2012.04.30 Mill6
- Volatile Organic Compounds:**
The aluminum oxide layer does not contain any VOC's

Availability

The standard lead time for stocked gauges and widths is two weeks for anodizing and one week for any secondary services such as slitting, shearing and applying transparent protective films or paper.

Please check availability of Non-Stocked materials by contacting our sales staff using our toll free number 800.654.1159 or email your request to info@lorin.com. Some raw materials may have extended lead times.

Technical Support

A staff of factory trained personnel are available to offer technical assistance. Please call our toll free number 800.654.1159 or email your question to info@lorin.com.

Product Support Partners

Lorin Industries works very closely with many manufacturers' in multiple markets who specialize in anodized aluminum fabrication. Our support staff can assist you if you are looking for finished components. Please call our toll free number 800.654.1159 or email your request for product and application support to info@lorin.com.

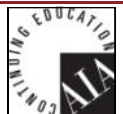
Warranty

A limited 20 year warranty is available upon request. The warranty is issued on a per project basis and can be applied for on line by completing an application for warranty at www.Lorin.com

Anodized Finish Test Data

| Characteristic | Test Method | Standard | Test Results |
|-------------------------|---|---|---|
| Oxide Layer, Thickness | ASTM B244 - Eddy current method | AAMA 611-12, 18 µm (0.700 mils) min | Nominal Target, 19.1 µm (0.750 mils) |
| Oxide Layer, Weight | ASTM B137 - Coating Dissolution | AAMA 611-12, 4.18 mg/cm ² (27.0 mg/in ²) | > 4.2 mg/cm ² (27 mg/in ²) |
| Color Uniformity | ASTM B2244 - Calculation Δ in Delta E | AAMA 611-12, Color must meet agreed upon specification | Lorin Color D043, Δ in Delta E ≤ 2.7 |
| Gloss Uniformity | ASTM D523 - 60° Gloss Reflectance | AAMA 611-12, Gloss must meet agreed upon specification | Lorin Gloss E1D, Nominal Target 30 |
| Abrasion Resistance | ASTM D4060 - Taber abrasive wheel | Based on a anodic film thickness, 18 µm (0.700 mils) | 10,000 cycles; 40.6 mg / wgt loss; 4.1 wear index |
| Film Hardness | ASTM D3363 - Pencil Hardness | Based on a anodic film thickness, 10 µm (0.400 mils) | 9H Hardness |
| Corrosion Resistance | ASTM B117 - Neutral Salt Spray | AAMA 611-12, 3,000 hours ≤ 15 pits < 1mm, 381 cm ² (150in ²) | Pass, No visible pits |
| Weathering | SAE J1960 - ATLAS Accelerated testing using an Xenon Arc light source | AAMA 611-12, 10 year Florida Exposure with max Δ Delta E of 5.0 | In Test Chamber |
| Craze Resistance | AAMA 611-12 - Thermal Crazing of the oxide layer | AAMA 611-12, oxide layer shall not craze less than 82°C (120°F) | No visible evidence of Thermal Crazing |
| Seal Quality | ASTM B680 - Acid Dissolution | AAMA 611-12, max weight loss shall be 40mg/dm ² (2.6mg/in ²) | < 20mg/dm ² (1.3mg/in ²) |
| Solar Reflectance Index | ASTM E1980 - Calculation of Solar Reflectance and Thermal Emissivity | Testing based on 6 µm (0.250 mil) film thickness | SRI 6.0 |

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