

**Material Specification**
Anodized Class I Clear Finish

Job No.: 91269

Project Name: ACLS Millbrae

Project Designation: MTL-V

1.0 SPECIFICATION

AAMA 611-14

- 1.1. Class: I
- 1.2. Designation: A41
- 1.3. Description: Clear
- 1.4. Process: 215

2.0 METHOD

15 percent sulfuric acid electrolyte, 12 amps per square foot, 68°F to 74°F for 60 minutes or equivalent

3.0 SAMPLE AND TESTING REQUIREMENTS

- 3.1. Fabricator/finisher shall provide adequate sampling and testing to insure that the product meets the performance requirements of AAMA 611.
- 3.2. Tests should be performed on coupons processed with production loads/parts.
- 3.3. Test records should be kept on file and include product date and respective test results.

4.C: MATERIAL ACCEPTANCE CRITERIA

In accordance with AAMA 611-14

4.1	Film Thickness (ASTM B 244 or B 487)	0.787 mils (20 μ) minimum
4.2	Coating Weight (ASTM B 137)	27.0 mg/in ² (4.18 mg/cm ²)
4.3	Coating Density (ASTM B 137)	38 g/in ³ (2.31 g/cm ³)
4.4	Color Uniformity (AATCC Test Method 173)	$\leq 5\Delta E$
4.5	Gloss Uniformity (ASTM D 523)	Range ≤ 15 units with 60° gloss meter
4.6	Abrasion Resistance (Michael Clark)	Not Degraded by Glass Paper
4.7	Salt Spray Resistance (ASTM B 117)	3,000 hours
4.8	Weathering	Max of 10 years, Fade Maximum 5 Delta E
4.9	Seal Test (ASTM B 680 or ISO 3210)	Max Weight Loss ≤ 2.6 mg/in ² (40 mg/dm ²)
4.10	Craze Resistance	No crazing below metal temperature of 82°C
4.11	Warranty	20 year

Aama Standard 2613

Jeffrey Franz



Aama Standard 2613:

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