

The technical fiche of standard profile height 6,5 mm describes synthetically the main technical characteristics of the product deducible from the drawings and the technical specifications of the suppliers.

Specifications of raw materials (UNI EN 485-2)

ALLOY	STATE	THICKNESS	Rm	Rp	A5%	A50 %
3003	H 28	0.20 - 0.39	≥ 190	≥ 160	≥ 2	≥ 2
3005	H 18	0,25 - 0,28	210 ÷ 250	≥ 190	≥ 3	--
3005	H 24*	0,31 - 0,39	195 ÷ 240	≥ 155	≥ 9	--

Tolerance on the thickness 0,01 mm

* Material used in the production of bendable profile.

Legend:
Rm = unit breaking load in traction
Rp = yield load
A = elongation per cent

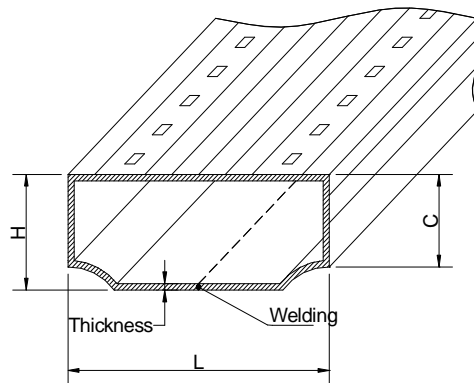
Composition of raw material (UNI EN 573-3)

ALLOY 3003										
Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	other cad.	other tot.	Al
0,6	0,70	0,05 ÷ 0,20	1,0 ÷ 1,5	--	--	0,10	--	0,05	0,15	rest

ALLOY 3005										
Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	other cad.	other tot.	Al
0,60	0,70	0,30	1,0 ÷ 1,5	0,20 ÷ 0,60	0,10	0,25	0,10	0,05	0,15	rest

Specifications of the finished product

Tolerance on the wideness	± 0,1 mm
Tolerance on the height	± 0,1 mm
Tolerance on the length	- 5 mm / + 10 mm
Check on the welding	Test with penetrating liquid (0 points/m) Check ultrasounds in line (Eddy Sensor)
Fogging test and volatile content	According to part "C" and "G" of the rules UNI (absent)
Residual greases	Test for the difference of weight after the degreasing (< 5 mg/m)
Permeability of holes	Test with flow meter (171 ± 26 l/m)
Painting (if made)	Paintings 100% polyester (thickness 20 -24 µm)
Oxidation (if made)	According to the type of colour thickness between 1- 5 µm



Profile	L ± 0,1 mm	H ± 0,1 mm	C ± 0,2 mm	Thickness ± 0,01 mm “L” Standard	Thickness ± 0,01 mm “Q” Std light	Thickness ± 0,01 mm “T” Extra light	Thickness ± 0,01 mm “P” Bendable	Thickness ± 0,01 mm “W” Bend. light
A055	5,50	6,50	4,60	0,25	0.22	0.20	0,35	--
A075	7,50	6,50	5,10	0,25	0.22	0.20	0,35	0.31
A085	8,50	6,50	5,10	0,25	0.22	0.20	0,35	0.31
A095	9,50	6,50	5,10	0,25	0.22	0.20	0,35	0.31
A115	11,50	6,50	5,10	0,25	0.22	0.20	0,35	0.31
A135	13,50	6,50	5,10	0,28	0.25	0.22	0,35	0.31
A145	14,50	6,50	5,10	0,28	0,25	0.22	0,35	0.31
A155	15,50	6,50	5,10	0,28	0,25	0.22	0,35	0.31
A175	17,50	6,50	5,10	0,28	--	--	0,35	0.31
A195	19,50	6,50	5,10	0,28	--	--	0,35	0.31
A215	21,50	6,50	5,10	--	--	--	0,39	--
A235	23,50	6,50	5,10	--	--	--	0,39	--

Dimensions and tolerances

Quality aspects

2.1 Quality management

ALU-PRO is certified according to UNI EN ISO 9001:2000

2.2 Test of the product

Processes and routines are established to secure the quality of the delivered material. During production the spacer are constantly monitored through a planning check. Data will be available for a period of 5 years.

2.3 Quality agreement

ALU-PRO fulfil the requirements of EN 1279-6 annex A. Specific quality agreement can be made to reduce inspection and test of incoming material according to EN 1279-6 part 5.2.6.

Customer focus

To secure the performance of the spacer, the stock conditions must be acceptable. Broken packaging, high humidity and variations in temperature will have an effect on the spacer surface. It is recommended to check out these specific points.