

Specification for anodisation of aluminium curtain wall / windows & doors / façade cladding

Material of profiles:

aluminium alloy (NEN-EN 573-3-09): EN-AW 6060 (AlMgSi0.5)

aluminium alloy (NEN-EN 573-3-09): EN-AW 6063 (AlMgSi0.7)

The profiles should be obtained from 1 supplier wherever possible, in order to minimise differences in alloys. Different alloys need to be submitted to the anodising company for approval and guarantee.

Material of sheeting and expanded metal:

Aluminium alloy (NEN-EN 573-3-09): EN-AW 5005 (AlMg1), AA=AQ (Anodising Quality)

Aluminium alloy (NEN-EN 573-3-09): EN-AW 1050 (Al99.5), AA=AQ (anodising Quality)

The sheeting should be produced from 1 production batch (coil) wherever possible, in order to minimise differences in alloy. The alloy and brand that are selected need to be submitted to the anodising company for approval and guarantee.

Surface treatment:

- Anodised according to QUALANOD at a QUALANOD certified company.
- Dyeing processes suitable for outside applications according to ISO 2135:2010, lightfastness of 8 or higher. Only electrolytic dyeing or impregnation dyeing with metal salts (no pigments). The limits for colour anodisation need to be set based on the material that is to be used and must be submitted to the architect or client for approval.
- Electrical contacts that will remain visible after installation need to be fitted on the non-visible side, or in consultation with the architect or client. Saw cuts that will remain visible after installation need to be discussed with the architect or client. (PS Contact points and saw cuts or drilling holes do not affect the quality of the adjacent anodising layer).
- Sheeting must be used in such a way that the rolling direction of the plate is uniform. (PS The use of sheeting with a non-uniform rolling direction will result in a difference in reflection and therefore an optical colour difference, as the anodising layer is transparent.)
- If the sheeting is welded, then the welding wire must be made of an alloy containing less than 5% Si, so that the weld will match the colour of the aluminium that is used. AlMg5 or USAS 5356 is preferable.
- Guarantee period; to be guaranteed by the anodising company.
- Anodisation according to processing code: Pretreatment:; Layer thickness; colour; (Example: E6 A20 AluGold01 = matt staining, 20 mu, light gold)

Pretreatment (please select):

E1:	ground, matt staining
E2:	brushed, lines clearly visible
E4:	ground, brushed, satinised lines
E5:	ground, polished
E6:	matt staining (standard)

Layer thickness (please select):

15 mu	for indoor work,
20 mu	for outdoor work,
25 mu	for outdoor work, loaded

Colour (please select):

Code:	Colour:	Alternative code according to EURAS
AluNature:	Natural	C0
AluGold00:	New Silver	
AluGold01:	Champagne – light gold	
AluGold02:	Gold	
AluGold03:	Dark gold	
AluCopper01:	Orange – light copper	
AluCopper02:	Medium light copper	
AluCopper03:	Medium dark copper	
AluCopper04:	Dark copper	
AluRed01:	Pink – light red	
AluRed02:	Medium light red	
AluRed03:	Medium dark red	
AluRed04:	Dark cardinal red	
AluBrass01:	Light brown brass	
AluBrass02:	Medium light brown brass	
AluBrass03:	Medium dark brown brass	
AluBrass04:	Dark brown brass	
AluBronze01:	Titanium - light bronze	C31
AluBronze02:	Medium - light bronze	C32
AluBronze03:	Medium - dark bronze	C33
AluBronze04:	Dark bronze	C34
AluBlack:	Black	C35
AluGrey:	Anthracite dark grey	
AluBlue:	Dark blue	
AluGreen:	Dark green	
AluOldCopper01:	Light brown	
AluOldCopper02:	Chocolate brown	
AluOldCopper03:	Dark chocolate brown	