

## TECHNICAL DATA SHEET

APL / TDS / 008 / Rev.04 | Date 16.10.2025

# ALUCOSIGN®

Physical Properties							
	Test Standard	Tolerance		Result			
				2MM TO 3MM	3MM (0.20MM COIL)	4MM (0.3MM COIL)	4MM (0.2MM COIL)
Panel Thickness	...	(±) 0.2 mm		2mm to 3mm	3.0 mm	4.0 mm	4.0 mm
Weight of the Panel	...	(±) 0.5 kg/m <sup>2</sup>		2.7 kg/m <sup>2</sup>	3.85 kg/m <sup>2</sup>	5.43 kg/m <sup>2</sup>	4.86 kg/m <sup>2</sup>
Standard Width	...	(±) 2 mm		1220 mm	1220, 1500 mm		
Length	...	(±) 2 mm		2440 mm	2440 mm up to 6000 mm		
Skin Thickness	...	(±) 0.02 mm	(±) 0.03 mm	0.10 mm to 0.20 mm	0.20 mm	0.30 mm	0.20 mm
Mechanical Properties							
	Test Standard	Requirement		Result			
				3MM (0.20MM COIL)	4MM (0.3MM COIL)	4MM (0.2MM COIL)	
Peel off Strength @ 180°	ASTM D 903	10 Kg/25mm		10 Kg/25mm			
Coating Properties And Performance							
	Test Standard	Requirement		Result			
				3MM (0.20MM COIL)	4MM (0.3MM COIL)	4MM (0.2MM COIL)	
Paint Quality	....	...		POLYESTER (PE)			
Color Difference Test	ASTM D 2244	E 2.0 (reference to master sample)		E 2.0 (reference to master sample)			
Coating Thickness	ASTM D 1400	2-Coat: 25 ± 3 µm		2-Coat: 25 ± 3 µm			
Specular Gloss @60	ASTM D 523-89	±5% (reference to master sample)		±5%			
Pencil Hardness Test	ASTM D 3363	≥H		≥H			
Solvent Resistance Test (MEK Test)	ASTM D 4752	...		No removal of paint @ 50 DBR			
Coating Flexibility T - Bend Test	ASTM D 4145	2T without cracks		2T without cracks			
Impact Resistance Test 50 kg-cm	ASTM D 2794	...		No crack and Paint Peel-off			
Film Properties And Performance							
	Test Standard	Requirement		Result (2MM TO 3MM)			
Surface Quality/ Visual Inspection		Visually Accepted		PASSED			
Pencil Hardness	ASTM D 3363	≥H		2H			
Film Adhesion Test by Crosshatch	ASTM D3359	No removal of film		No removal of film nor blistering			
Film Adhesion Test by Boiling Water	AAMA 2605	No removal of film		No removal of film nor blistering			
Solvent Resistance Test (MEK Test)	ASTM D 4752	Bearable @ 100X Rubbing		PASSED 100 DR			
Impact Resistance Test 50 kg-cm	ASTM D 2794	No removal of film		No removal of film			

This Product Is For Signage & Display Applications Only. Not Certified For Facade Use - Follow Local Regulations.

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**Coating Properties And Performance**

Schematic Diagram								
Coating System							DFT	
				FEVE	PVDF	HDPE	PE	
CLEARCOAT	CLEARCOAT	3COAT/ LAYER	2COAT/ LAYER	FEVE	PVDF	HDPE	PE	13-15µm
TOPCOAT	TOPCOAT			PVDF	PVDF	HDPE	PE	18-20µm
PRIMER	PRIMER			PRIMER				5-7µm
SUBSTRATE	PRETREATMENT			CHROME				<1µm
	SUBSTRATE	ALUMINUM				METAL		

**Coating Gloss Limitation & Comparison With Various Coatings**

GLOSS RANGE (ASTM D 523) STANDARD @ 60°	
FEVE	60 - 90 GU
PVDF	15 - 40 GU
HDPE	15 - 90 GU
PE	20 - 90 GU

