

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 ²	2.7 kg/m ²	3.85 kg/m ²	5.43 kg/m ²	4.86 kg/m ²
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		FEVE	PVDF	HDPE	PE	13-15μm
TOPCOAT	TOPCOAT		2COAT/ LAYER	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

- PE
- HDPE
- PVDF
- FEVE

