

TEST DESCRIPTION	TEST RESULT - PRODUCT QUALITY		
STANDARD DIMENSIONS ( MM )	Width	1220 / 1250 / 1500 / 2000	
	Length	2440 / 2500 / 3050 / 4050	
	Thickness	3	
DIMENSION DEVIATION	Tolerance of Width : $\leq \pm 2\text{mm}$		
	Tolerance of Length : $\leq \pm 3\text{mm}$		
	Tolerance of Thickness : $\leq \pm 0.2\text{mm}$		
	Diagonal Deviation: $\leq 3\text{mm}$		
	Out of straight at sides: $\leq 1\text{mm/m}$		
	Warp : $\leq 3\text{mm/m}$		
APPEARANCE	Clean surface without swelling flaws, scratches and aberrations		
LUSTER DEVIATION	Face : 0.5/50.0		
	Back : 0.5/50.0		
COATING THICKNESS	Face: $\geq 18.0\mu\text{m}$		
	Back : $\geq 18.0\mu\text{m}$		
SURFACE DENSITY (KGS/M2)	3mm - 0.30mm	White & Colors	4.41
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	4.09
	3mm - 0.15mm	White	3.93
PENCIL HARDNESS	$\geq \text{HB}$		
COATING TOUGHNESS	Inner Panel $\leq 1.5\text{T}$		
ADHESIVE	No less than grade 1		
IMPACT STRENGTH	50Kg/cm Without peeling & cracking of paint		
RESISTANCE TO SOLVENT	Unchanged after cleaning 100 times with dimethylbenzene		
180° PEEL STRENGTH (N/mm)	3mm - 0.30mm	White & Colors	$\geq 8.0$
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	$\geq 7.0$
	3mm - 0.15mm	White	$\geq 6.0$
MODULUS OF ELASTICITY (N/mm2)	3mm - 0.30mm	White & Colors	$\geq 68,000$
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	$\geq 64,000$
	3mm - 0.15mm	White	$\geq 61,000$

RIGIDITY E x J (kNcm <sup>2</sup> /m)	3mm - 0.30mm	White & Colors	≥ 780
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	≥ 730
	3mm - 0.15mm	White	≥ 700
TEMPERATURE RESISTANCE	unchanged after -40°C to +80°C 20 cycles		
COEFFICIENT OF HEAT EXPANSION	≤ 3.00x10 <sup>-5</sup> °C <sup>-1</sup>		
DEFORMATION TEMPERATURE	≥ 110°C		
LINEAR THERMAL EXPANSION	≤ 3.1 mm/m at 100° expansion temperature difference		
HEAT TRANSITION COEFFICIENT	5.6 - 5.8 Wm <sup>2</sup> k		
0.2% PROOF STRESS	Rp0.2: 110-175 N/mm <sup>2</sup>		
SOUND ABSORPTION FACTOR	0.04 - 0.05 Alphas		
AIRBORNE SOUND INSULATION INDEX Rw	23 - 25 dB		
WATER ABSORPTION	≤ 0.01 %		

## SURFACE COATING SPECIFICATIONS

IRIBOND WHITE MATT & GLOSS (DIGITAL PRINTING GRADE)	Surface Coating	Printable Polyester Paint
	Colour Base	Pigment made in Taiwan
	Standard Colour	Pure White
	Tolerance of Colour	≤ ± 2.0 ° E
	Lacquering	Single layer of structural resistant baked lacquer providing printability and durability
	Surface Finishing	Matt & Gloss
	Tolerance of Glossiness	≤ ± 5.0 %
	Surface Outdoor Durability	5 years ( the change of color ≤ 4 NBS )
IRIBOND COLOURS	Surface Coating	Polyester Paint
	Colour Base	Pigment made in Japan
	Standard Colour	Red , Yellow , Green , Blue , Black , Creme , Grey
	Tolerance of Colour	≤ ± 2.0 ° E
	Lacquering	Single layer of structural resistant baked lacquer providing optimum rigidity and durability
	Surface Finishing	Matt & Gloss
	Tolerance of Glossiness	≤ ± 5.0 %
	Surface Outdoor Durability	5 years ( the change of color ≤ 4 NBS )

IRIBOND SILVER BRUSHED	Surface Coating	Polyester Paint
	Colour Base	Transparent , No Pigment
	Standard Colour	Natural Alu Silver
	Tolerance of Colour	$\leq \pm 2.0^{\circ} \text{ E}$
	Lacquering	Made by special brushing process on the Aluminium surface, then surface coated by a transparent resistant baked lacquer providing optimum rigidity and durability
	Surface Finishing	Brushed
	Tolerance of Glossiness	$\leq \pm 5.0 \%$
	Surface Outdoor Durability	3 years
IRIBOND SILVER MIRROR	Surface	Anodic Oxidation
	Colour Base	N/A
	Standard Colour	Silver
	Tolerance of Colour	$\leq \pm 2.0^{\circ} \text{ E}$
	Lacquering	Made by special anodizing process on the Aluminium surface providing optimum rigidity and durability
	Surface Finishing	High Gloss
	Tolerance of Glossiness	$\leq \pm 5.0 \%$
	Surface Indoor Durability	3 years
	Surface Outdoor Durability	N/A
SHELF LIFE	The products should be used within 12 months from production date.	