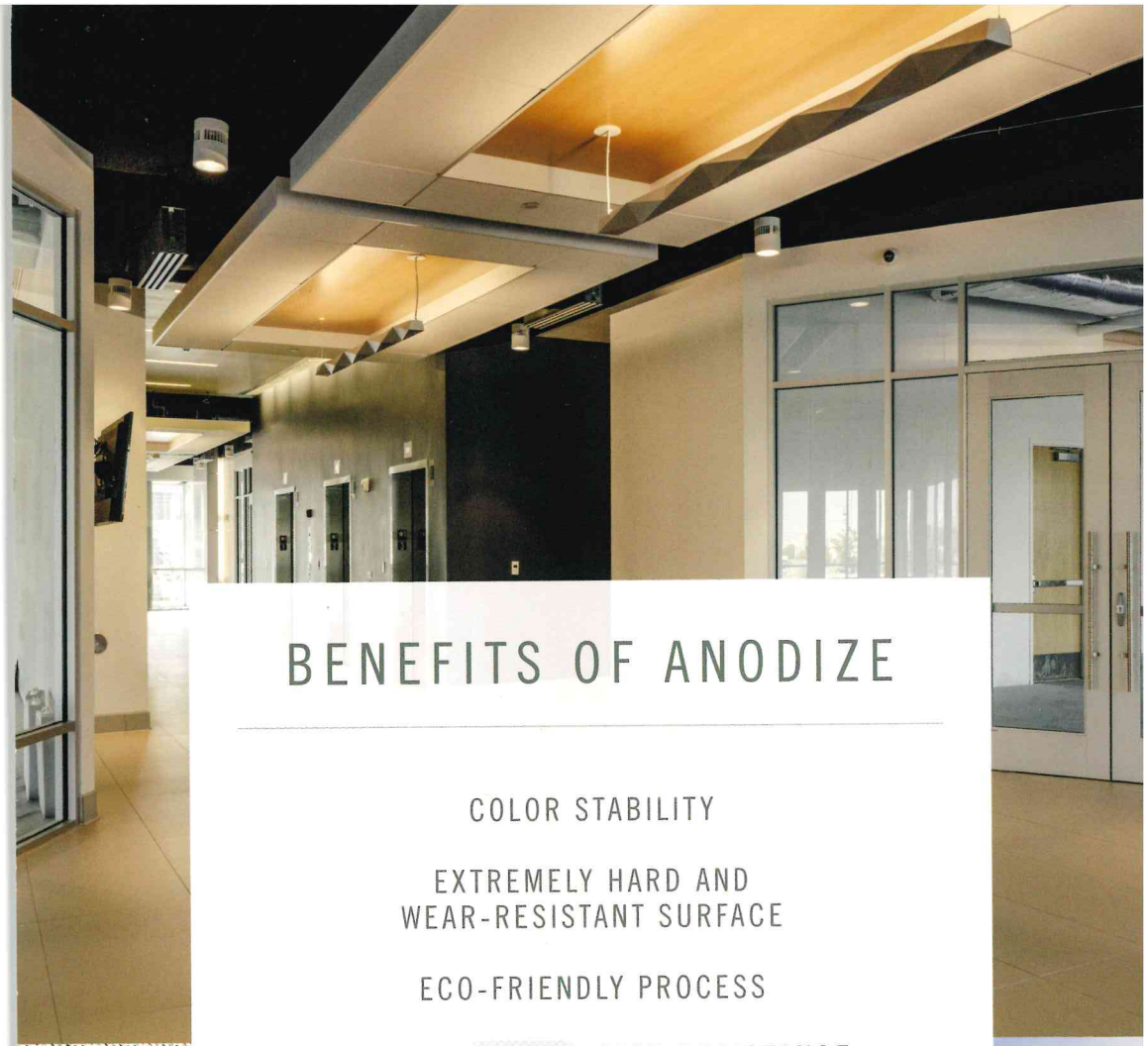
ANODIZE FINISHES

BEAUTY MADE TO LAST

LINETEC



BENEFITS OF ANODIZE

COLOR STABILITY

EXTREMELY HARD AND
WEAR-RESISTANT SURFACE

ECO-FRIENDLY PROCESS

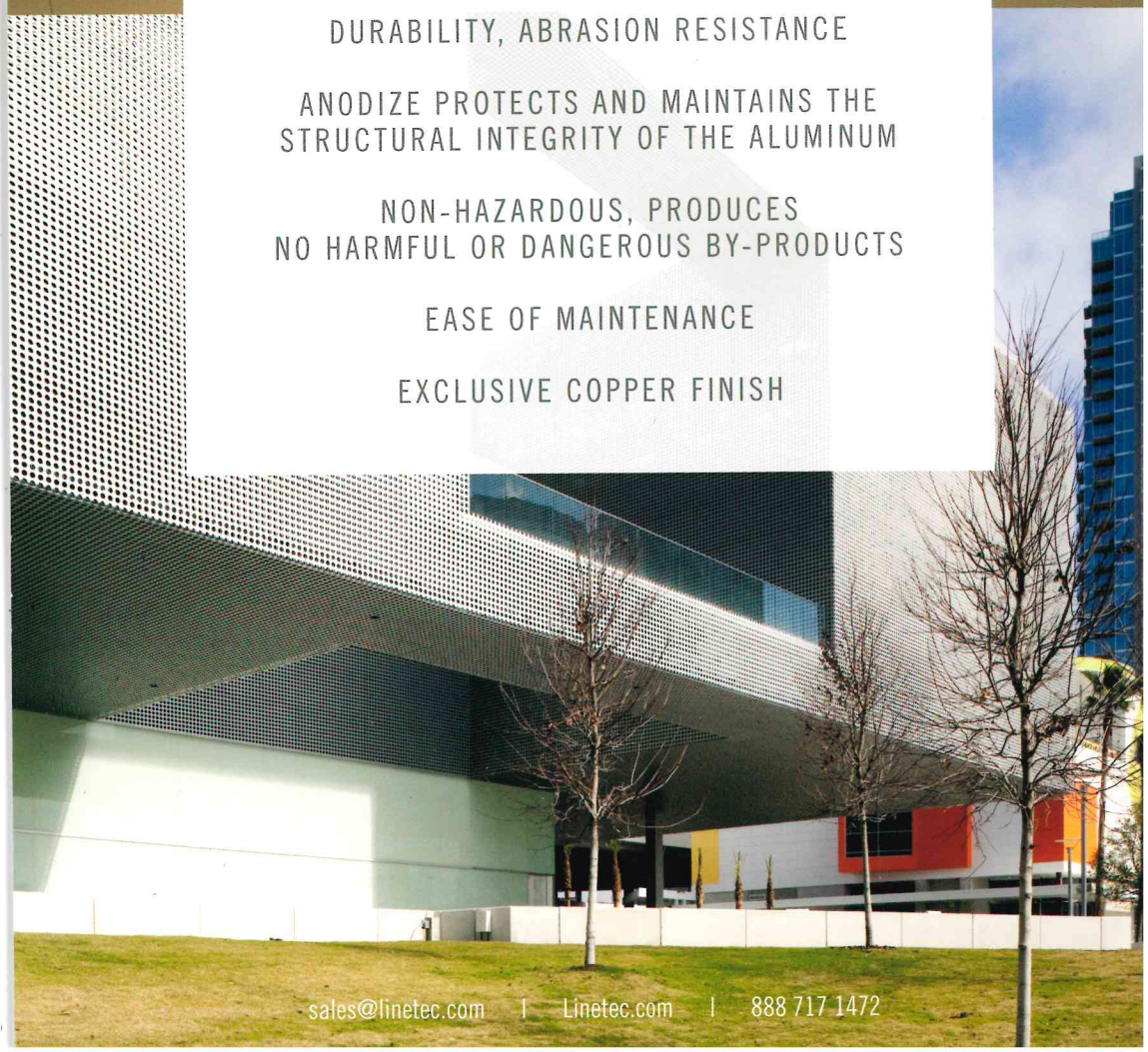
DURABILITY, ABRASION RESISTANCE

ANODIZE PROTECTS AND MAINTAINS THE
STRUCTURAL INTEGRITY OF THE ALUMINUM

NON-HAZARDOUS, PRODUCES
NO HARMFUL OR DANGEROUS BY-PRODUCTS

EASE OF MAINTENANCE

EXCLUSIVE COPPER FINISH



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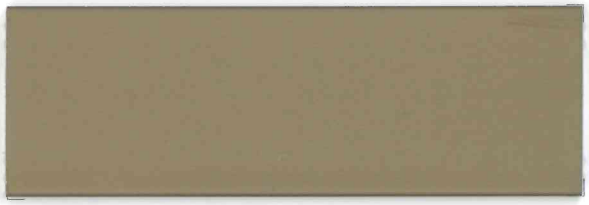
ARCHITECTURAL ANODIZE FINISHES

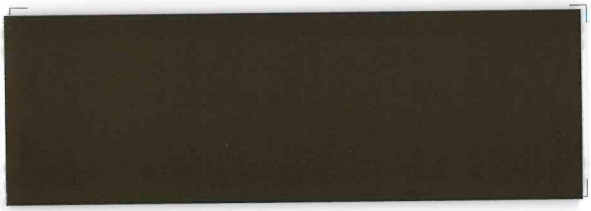
Natural Coating / UV Resistant / Low Maintenance

Clear ANO-215 AE or ANO-204 AE



Champagne ANO-300 AE

Light Bronze ANO-301 AE



Medium Bronze ANO-302 AE

Dark Bronze ANO-303 AE

Extra-Dark Bronze ANO-304 AE

Black ANO-305 AE

The color of your metal may vary slightly from these samples.

Linetec anodize finishes meet the AAMA-611 specification. All Linetec anodize finishes are Class I, with the exception of ANO-204 Clear, which is a Class II anodize.

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ANODIZING

Anodizing is the process of electrochemically accelerating and controlling the oxidation of an aluminum substrate, creating an extremely hard, durable and aesthetically pleasing coating on the aluminum. Architectural anodize finishes are limited to certain colors; however their hardness and scratch-resistance far surpass that of paint coatings.

QUALITY

Our automated system controls and monitors your product through the entire anodizing process. It tracks all aspects of the process including tank sequencing, voltage, current, time and temperature, ensuring the most consistent anodize finish available.

CARE & CLEANING

Anodized material has an extremely hard surface that is colorfast and mar resistant. An anodized finish should be cleaned using mild soap solutions to retain its original beauty. The cleaning solution should be applied with a soft cloth, sponge or brush. Avoid the use of acidic or alkaline cleaners. To avoid damage to the finish, anodized aluminum should be placed into walls after mortar has cured. Any uncured masonry product that is not immediately removed from the anodized aluminum will destroy the finish, sometimes beyond repair.

MATERIAL SIZE GUIDELINES

STANDARD

Length	28' 6" (342")
Height	6' 6" (78")
Width	13"
Weight per load	1800 lbs

CUSTOM / OVERSIZE

Length	30' 6" (366")
Height	6' 6" (78")
Width	3' (36")
Weight per load	1800 lbs

AAMA ANODIZE SPECIFICATIONS

	AAMA 611	
South Florida Weathering	CLASS I	CLASS II
End Use	Exterior	Interior or exterior with regular maintenance
Film Thickness	0.7 mils	0.4 mils
Salt Spray Resistance	3000 hours	1000 hours
Color Retention	10 yrs - fade = 5 Delta E	10 yrs - fade = 5 Delta E
Gloss Uniformity	15 unit Variation	15 unit Variation
Hardness	Excellent	Very Good
Gloss Options	4-30	4-30
Effect of Poor Quality Substrate	Significant	Significant
Warranty	5 to 10 years	N/A

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FINISHER OF CHOICE!™

Eco-Friendly Anodizing

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Linetec anodize finishes meet the AAMA-611 specification.

Wikk Clear ANO–215R1 or ANO–204R1 AE

Wikk Light Bronze (Champagne) ANO-300 AE

Non-Stock Light Bronze ANO-301 AE

Non-Stock Medium Bronze ANO-302 AE

Non-Stock Dark Bronze ANO-303 AE

Wikk Extra Dark Bronze ANO-304 AE

Wikk Black ANO-305 AE

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ALUMINUM ASSOCIATION DESIGNATION SYSTEM FOR ALUMINUM FINISHES

The following examples show how the Aluminum Association Designation System for Aluminum Finishes is used (each designation is preceded by the letters AA to identify it as an Aluminum Association designation):

Example 1 - Architectural Building Panel

If an architect wished to designate a matte anodized finish for a building such as that produced by giving aluminum a matte finish, followed by architectural Class I natural anodizing, he would designate it as follows:

AA - M10C22A41
AA - Aluminum Association
M10 - Unspecified
C22 - Medium Matte Etched
A41 - Anodic Coating-architectural, Class I

Example 2 - Architectural Aluminum with Anodized Electrolytically Deposited Color

If an architect wished to specify a bronze anodized panel with a two-step color for architectural application, the designation would be:

AA - M10C22A44
AA - Aluminum Association
M10 - Unspecified as fabricated finish
C22 - Chemically etched medium matte finish
A44 - Anodic Coating-architectural, Class I
Electrolytically Deposited Color

Mechanical Finishes (M)

As Fabricated

M10 Unspecified
M11 Specular as fabricated
M12 Nonspecular as fabricated
M1X Other (to be specified)

Buffed

M20 Unspecified
M21 Smooth specular
M22 Specular
M2X Other (to be specified)

Directional Textured

M30 Unspecified
M31 Fine satin
M32 Medium satin
M33 Coarse satin
M34 Hand rubbed
M35 Brushed
M3X Other (to be specified)

Nondirectional Textured

M40 Unspecified
M41 Extra fine matte
M42 Fine matte
M43 Medium matte
M44 Coarse matte
M45 Fine shot blast
M46 Medium shot blast
M47 Coarse shot blast
M4X Other (to be specified)

Chemical Finishes (C)

Nonetched Cleaned

C10 Unspecified
C11 Degreased
C12 Inhibited chemical cleaned
C1X Other (to be specified)

Etched

*C20 Unspecified
*C21 Fine matte
*C22 Medium matte
*C23 Coarse matte
C2X Other (to be specified)

Brightened

C30 Unspecified
C31 Highly specular
C32 Diffuse bright
C3X Other (to be specified)

Chemical Coatings

C40 Unspecified
C41 Acid chromate-fluoride
C42 Acid chromate-fluoride-phosphate
C43 Alkaline chromate
C44 Non-chromate
C45 Non-rinsed chromate
C4X Other (to be specified)

Anodic Coatings

General

A10 Unspecified
A11 Preparation for other applied coatings
A12 Chromic acid anodic coatings
A13 Hard, wear and abrasion resistant coatings
A1X Other (to be specified)

Protective and Decorative

Coating less than 10um (.04 mil)

A21 Clear
A22 Integral color
A23 Impregnated color
A24 Electrolytically deposited color
A2X Other (to be specified)

Architectural Class II[1]

10-18 um (0.4-0.7 mil) coating

*A31 Clear
A32 Integral color
A33 Impregnated color
A34 Electrolytically deposited color
A3X Other (to be specified)

Architectural Class I[1]

18 um (0.7 mil) and thicker anodic coatings

*A41 Clear
A42 Integral color
A43 Impregnated color
A44 Electrolytically deposited color
A4X Other (to be specified)

[1]Aluminum Association Standards for Anodized Architectural Aluminum

Resinous and Other Organic Coatings (R)[2]

R10 Unspecified
R1X Other (to be specified)

[2]These designations may be used until more complete series of designations are developed for these coatings.

*Provided by Linetec Anodizing

GUIDE SPECIFICATIONS

1. Exposed surfaces of all aluminum windows, framing, and trim shall receive an anodized color finish conforming to the Aluminum Association Designation, Architectural Class I, AA-M10C22A44.

   Comment: Architectural Class I should always be specified for high rise curtain wall construction and for monumental construction, high rise or low rise, where excellent appearance with little maintenance is desired for the life of the building. The AA-M10C22A44 indicated extrusions with a mill finish (M10) which receive a medium matte etch (C22) and are colored by the electrolytic deposition of stable metal compounds (A44).

2. The anodic coating shall be continuous, fully sealed and free from powdery surfaces.

   Comment: A uniform, continuous coating, fully sealed, is essential to good appearance and satisfactory performance.

3. Coating thickness shall be a minimum of 0.7 mil when tested in accordance with ASTM B 244.

   Comment: A minimum of 0.7 mil thickness is required to meet the Architectural Class 1 designation and to provide the desired resistance to weathering and corrosion.

4. Coating weight shall be a minimum of 27.0 mg/in^2 with an apparent density of 38.0 g/in^3 when tested in accordance with ASTM B 137-89.

   Comment: This minimum weight, which is a measure of the density is necessary to assure that the coating has the desired hardness, abrasion resistance and durability.

5. There shall be no noticeable change in the color of the coating when subjected to a 200 hour UVIARC test.

   Comment: Where severe exposure to sunlight will be encountered and where long finish life is desired, the UVIARC test may be used to determine resistance to ultra violet radiation. This test is much more severe than the salty spray and weatherometer tests on the coloring agents in the coating.

6. Maximum acid dissolution weight loss shall be 2.6 mg/in^2 when tested in accordance with International Standard (ISO) 3210 to ensure a high quality seal.

   Comment: This test determines the ability of the sealed coating to resist acid attack. It is a rigorous test, but one which should be used if the coating is to be exposed to severe conditions.

Linetec specifications meet AAMA - 611.

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