

## ANODIZING QUALITY SPECIFICATIONS

Can Art meets the AAMA 611-20 Standards for Class I and Class II coatings.

All processes and testing operations are performed and verified in accordance to Can Art Quality Control Standards.

Our automated process monitors your product through the entire line. Tank sequence, temperature, voltage, current and time are all monitored ensuring a consistent high-quality finish.

### Properties

<b>Type</b>	Type II Sulphuric Acid Anodizing
<b>Class</b>	I and II
<b>Etching</b>	Premium Low Gloss Acid Etching
<b>Colouring</b>	Electrically Deposited Colouring (2 Step)
<b>Sealing</b>	Cold Seal with Hot Rinsing

### Can Art Testing

Test	Standard	Specification	
		Class I	Class II
<i>Visual Inspection</i>	AAMA 611-20-5.2	Free from surface imperfections from viewing at 3m and 90°*	
<i>Coating Thickness</i>	ASTM B-244	>0.0007"	>0.0004"
<i>ADT (Acid Dissolution Test)</i>	ASTM B-680	<2.60 mg/in <sup>2</sup>	
<i>Dye Stain Test</i>	ASTM B-136	No blue dye present	
<i>Coating Weight</i>	ASTM B-137	>27.0mg/in <sup>2</sup>	>15.5mg/in <sup>2</sup>
<i>Coating Density</i>	ASTM B-137	>38g/in <sup>3</sup>	
<i>Michael Clarke Abrasion Test</i>	AAMA 611-20-9.5	No chalk-like pick-up	
<i>Corrosion Resistance</i>	ASTM B-117, AAMA 611-20	<15 pits after 3000h	<15 pits after 1000h
<i>Colour and Gloss</i>	AAMA/ Can Art	Agreed upon with customer. Colour variation less than 3ΔE**	

\* **Full AAMA 611-20-5.2 statement:**

*"The anodic coating shall be uniform in appearance and visibly free from surface imperfections with the exception of minor flow lines or structural streaking that is typically inherent in the extrusion process. Coating shall be observed at a distance of 3m (10 ft) from the metal and inspected at an angle of 90 degrees to the surface in natural daylight. Color shall be compliant with mutually agreed upon color samples."*

\*\* **AAMA 611-20 – Note 6:**

*"Range Samples are not applicable to clear anodized finishes since colour is determined by the chemical make-up of the specific aluminum lot."*