



## TECHNICAL DATA SHEET

| TEST DESCRIPTION                      | TEST RESULT - PRODUCT QUALITY                           |   |            |
|---------------------------------------|---|---|------------|
| STANDARD DIMENSIONS                   | Width   | 1220 / 1250 / 1500 / 2000                                       |            |
|                                       | Length  | 2440 / 2500 / 3050 / 4050                                       |            |
|                                       | Thickness   | 3   |            |
| DIMENSION DEVIATION                   | Tolerance of Width: $\leq \pm 2$ mm                     |   |            |
|                                       | Tolerance of Length: $\leq \pm 3$ mm                    |   |            |
|                                       | Tolerance of Thickness: $\leq \pm 0.2$ mm               |   |            |
|                                       | Diagonal Deviation: $\leq 3$ mm                         |   |            |
|                                       | Out of straight at sides: $\leq 1$ mm/ m                |   |            |
|                                       | Warp: $\leq 3$ 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: $\geq 18.0$ $\mu$ m                               |   |            |
|                                       | Back: $\geq 18.0$ $\mu$ m                               |   |            |
| SURFACE DENSITY (KGS/M <sup>2</sup> ) | White & Colours   |   |            |
|                                       | 3 mm - 0.30 mm  | Silver Brushed  | 4.41       |
|                                       | Silver Mirror   |   |            |
|                                       | 3 mm - 0.20 mm  | White   | 4.09       |
|                                       | 3 mm - 0.15 mm  | White   | 3.93       |
| PENCIL HARDNESS                       | $\geq$ HB   |   |            |
| COATING TOUGHNESS                     | Inner Panel $\leq 1.5$ T                                |   |            |
| ADHESIVE                              | No less than grade 1                                    |   |            |
| IMPACT STRENGTH                       | 50 Kg/ cm Without peeling & cracking of paint           |   |            |
| RESISTANCE TO SOLVENT                 | Unchanged after cleaning 100 times with dimethylbenzene |   |            |
| 180° PEEL STRENGTH (N/ mm)            | White & Colours   |   |            |
|                                       | 3 mm - 0.30 mm  | Silver Brushed  | $\geq 8.0$ |
|                                       | Silver Mirror   |   |            |

|  |  |                 |          |
|--|--|-----------------|----------|
|  | 3 mm - 0.20 mm                                       | White           | ≥ 7.0    |
|  | 3 mm - 0.15 mm                                       | White           | ≥ 6.0    |
| MODULUS OF ELASTICITY (N/mm <sup>2</sup> ) |  | White & Colours |          |
|  | 3 mm - 0.30 mm                                       | Silver Brushed  | ≥ 68,000 |
|  |  | Silver Mirror   |          |
|  | 3 mm - 0.20 mm                                       | White           | ≥ 64,000 |
|  | 3 mm - 0.15 mm                                       | White           | ≥ 61,000 |
| RIGIDITY E x J (kNcm <sup>2</sup> /m)      |  | White & Colours |          |
|  | 3 mm - 0.30 mm                                       | Silver Brushed  | ≥ 780    |
|  |  | Silver Mirror   |          |
|  | 3 mm - 0.20 mm                                       | White           | ≥ 730    |
|  | 3 mm - 0.15 mm                                       | White           | ≥ 700    |
| TEMPERATURE RESISTANCE                     | unchanged after -40°C to +80°C 20 cycles             |                 |          |
| COEFFICIENT OF HEAT EXPANSION              | ≤ 3.00 x 10 <sup>-5</sup> °C-1                       |                 |          |
| DEFORMATION TEMPERATURE                    | ≥ 110 °C   |                 |          |
| LINEAR THERMAL EXPANSION                   | ≤ 3.1 mm/ m at 100° expansion temperature difference |                 |          |
| HEAT TRANSITION COEFFICIENT                | 5.6 - 5.8 Wm2k                                       |                 |          |
| 0.2% PROOF STRESS                          | Rp: 0.2: 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<br>(DIGITAL PRINTING GRADE) | Surface Coating            | Printable Polyester Paint  |
|  | Colour Base                | Pigment made in Taiwan   |
|  | Standard Colour            | Pure White   |
|  | Tolerance of Colour        | ≤ ± 2.0 Δ 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 colour ≤ 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 Δ E  |
|  | Lacquering                 | Single layer of structural resistant baked lacquer providing optimum rigidity and durability |
|  | Surface Finishing          | Matt & Gloss   |

Tolerance of Glossiness  $\leq \pm 5.0 \%$   
Surface Outdoor Durability 5 years (the change of colour  $\leq 4$  NBS)

IRIBOND SILVER BRUSHED

|                            |   |
|----------------------------|---|
| Surface Coating            | Polyester Paint   |
| Colour Base                | Transparent, No Pigment   |
| Standard Colour            | Natural Alu Silver  |
| Tolerance of Colour        | $\leq \pm 2.0 \Delta E$   |
| 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        | $\leq \pm 2.0 \Delta E$  |
| 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

