

00: TECHNICAL OVERVIEW



01: INDOOR →

02: OUTDOOR →

03: PLATO →

04: TOTEM →

05: HIGHLIGHT →

We show you the way

alu SIGN
→

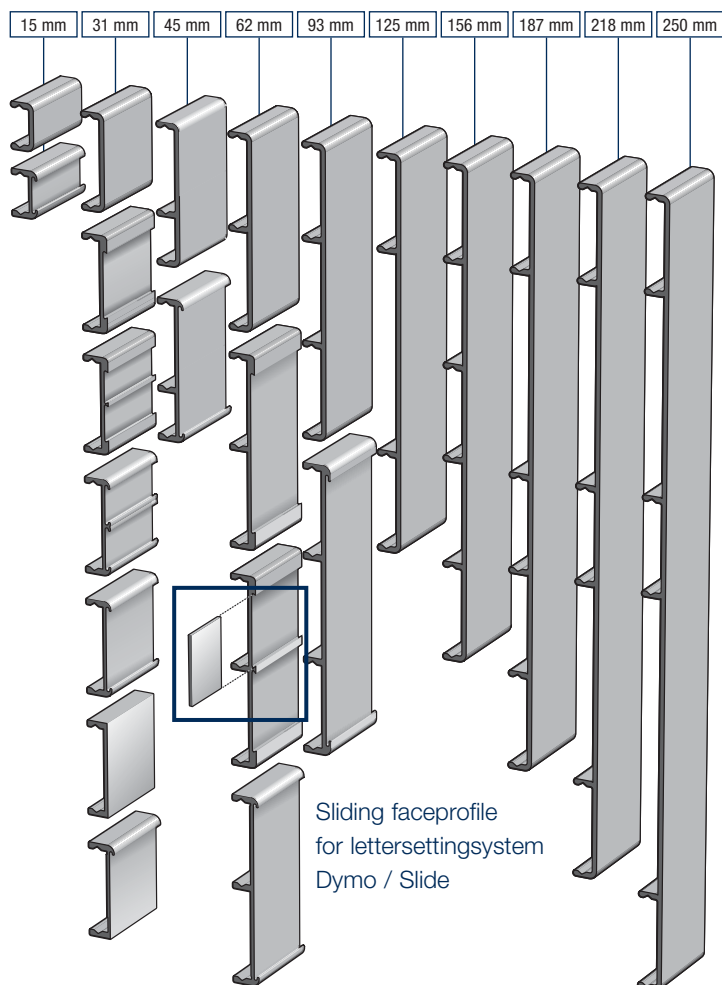
01:INDOOR	→	3
02:OUTDOOR	→	12
03:PLATO	→	17
04:TOTEM	→	30
05:HIGHLIGHT	→	34

01:INDOOR





OVERVIEW PROFILES



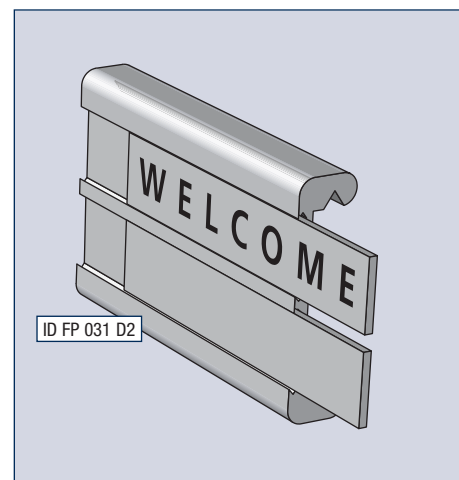
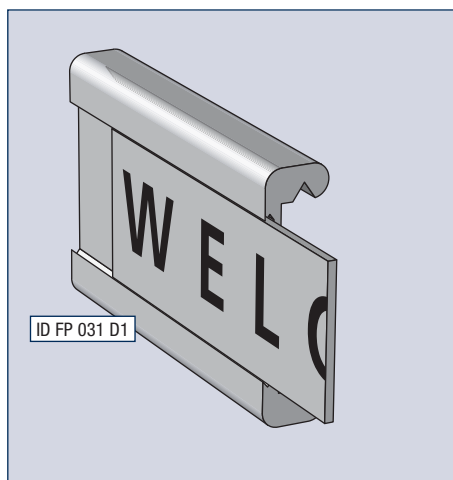
FACEPROFILES

CODE	TYPE	WIDTH PVC SHEET (mm)	THICKNESS (mm)
ID FP 015	Indoor face panel 15		
ID FP 015 S1	Indoor face panel 15 - 1-sliding	11,9	1
ID FP 031	Indoor face panel 31		
ID FP 031 S1	Indoor face panel 31 - 1-sliding	27	1
ID FP 031 S2	Indoor face panel 31 - 2-sliding	2x 13	1
ID FP 031 D1	Indoor face panel 31 - 1-sliding-dymo	19,2	0,8
ID FP 031 D2	Indoor face panel 31 - 2-sliding-dymo	2x 12,5	0,8
ID FP 031 S	Indoor face panel 31 slider		
ID FP 031 SU	Indoor face panel 31 support		
ID FP 045	Indoor face panel 45		
ID FP 045 S1	Indoor face panel 45 - 1-sliding	43	1
ID FP 062	Indoor face panel 62		
ID FP 062 S1	Indoor face panel 62 - 1-sliding	58	1
ID FP 062 D1	Indoor face panel 62 - 1-sliding-dymo	50	0,8
ID FP 062 D2	Indoor face panel 62 - 2-sliding-dymo	2x 24	0,8
ID FP 093	Indoor face panel 93		
ID FP 093 S1	Indoor face panel 93 - 1- sliding	89,5	1,5
ID FP 125	Indoor face panel 125		
ID FP 156	Indoor face panel 156		
ID FP 187	Indoor face panel 187		
ID FP 218	Indoor face panel 218		
ID FP 250	Indoor face panel 250		

SLIDING PROFILES

Our sliding profiles are just the thing for interchangeable texts, name-plates, etc.,... A small sheet of PVC, is slid into the aluminium profile.

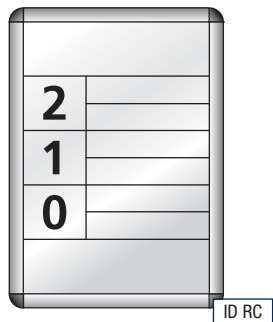
These profiles come in sizes of 15 mm (1 track), 31 mm (1 track), 31 mm (2 tracks), 45 mm (1 track), 62 mm 1 track and 62 mm 2 track and 93 mm 1 track.



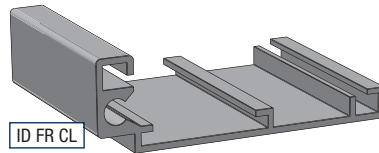
FRAME PROFILES

CODE	TYPE
ID FR CL	One-sided classic
ID FR TR	One-sided triangular
ID FR RO	One-sided radius
ID FR TB	Top/bottom radius profile
ID FR CLF	One-sided classic full
ID FR ROF	One-sided radius full

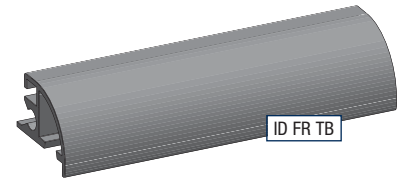
ONE SIDED RADIUS WITH TOP AND BOTTOM PROFILE



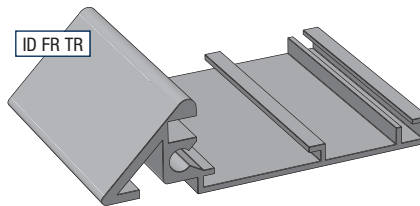
ONE SIDED CLASSIC



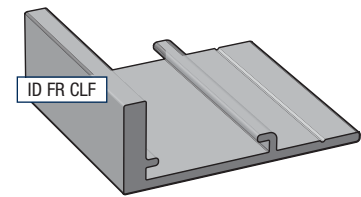
TOP / BOTTOM RADIUS PROFILE



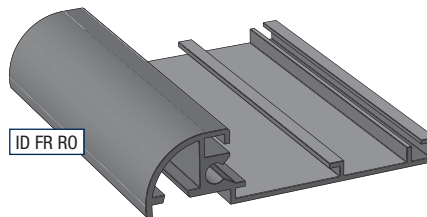
ONE SIDED TRIANGULAR



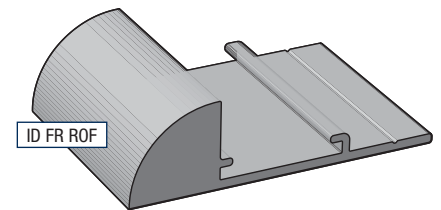
ONE SIDED CLASSIC FULL



ONE SIDED RADIUS

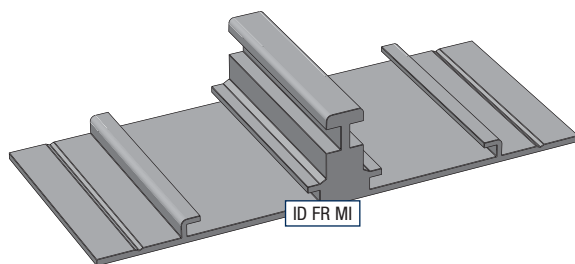


ONE SIDED RADIUS FULL



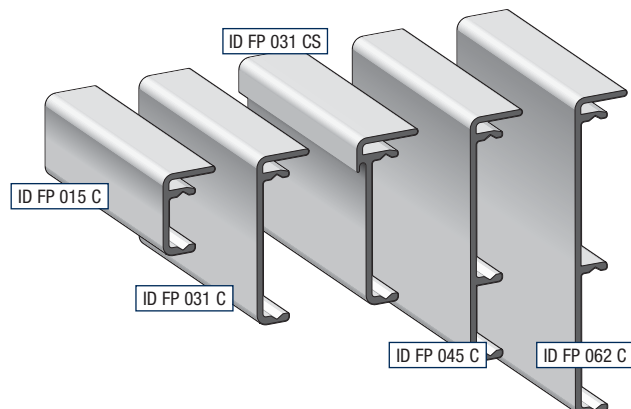
MIDDLE PROFILE

CODE	TYPE
ID FR MI	Middle profile



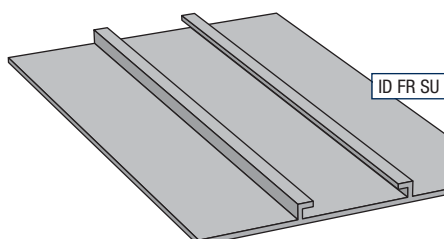
COVER PROFILES

CODE	TYPE
ID FP 015 C	Cover Profile 15 mm
ID FP 031 C	Cover Profile 31 mm
ID FP 031 CS	Cover Profile 31 mm - slide
ID FP 045 C	Cover Profile 45 mm
ID FP 062 C	Cover profile 62 mm



SUPPORT LIST

CODE	TYPE
ID FR SU	Support list



Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

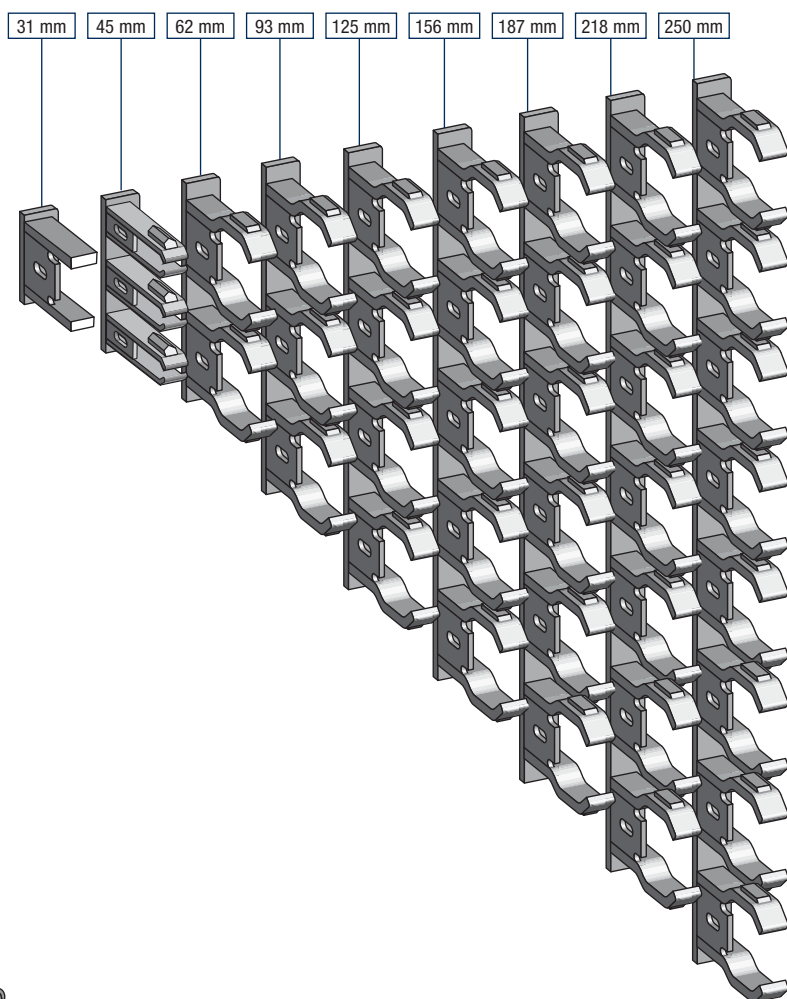
Indoor information at a glance



OVERVIEW ACCESSORIES

PLASTIC SINGLE ENDCAPS

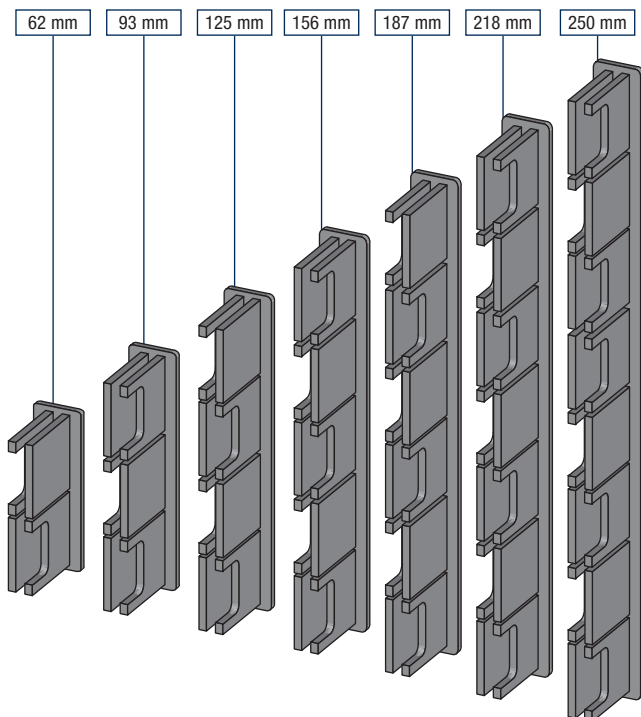
CODE	TYPE	SIZE
ID PSE 031	Single endcap	31 mm
ID PSE 045	Single endcap	45 mm
ID PSE 062	Single endcap	62 mm
ID PSE 093	Single endcap	93 mm
ID PSE 125	Single endcap	125 mm
ID PSE 156	Single endcap	156 mm
ID PSE 187	Single endcap	187 mm
ID PSE 218	Single endcap	218 mm
ID PSE 250	Single endcap	250 mm



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PLASTIC DOUBLE ENDCAPS

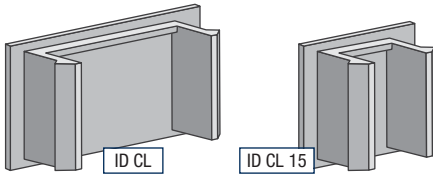
CODE	TYPE	SIZE
ID PDE 62	Double endcaps	62 mm
ID PDE 93	Double endcaps	93 mm
ID PDE 125	Double endcaps	125 mm
ID PDE 156	Double endcaps	156 mm
ID PDE 187	Double endcaps	187 mm
ID PDE 218	Double endcaps	218 mm
ID PDE 250	Double endcaps	250 mm



PLASTIC ACCESSORIES

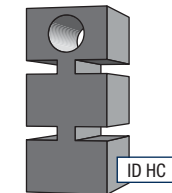
■ PLASTIC CLIPS

CODE	TYPE
ID CL	Clip - black
ID CL 15	Clip 15 mm - black



■ TOP & BOTTOM CAPS

CODE	TYPE
ID CL	One-sided classic left
ID CR	One-sided classic right
ID RL	Radius left
ID RR	Radius right
ID TL	Triangular left
ID TR	Triangular right

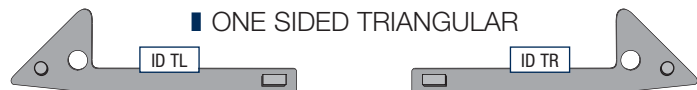
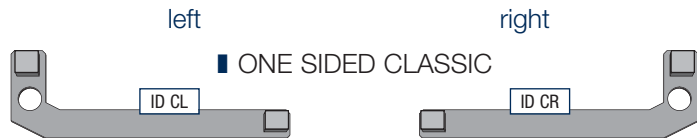
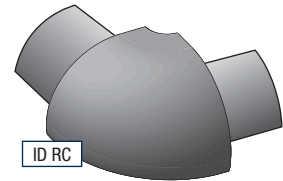


■ HANGING AND COMBINATION CLIPS

CODE	TYPE
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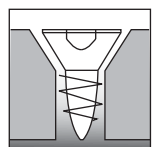
■ CORNER CLIP RADIUS

CODE	TYPE
ID RC	Corner radius



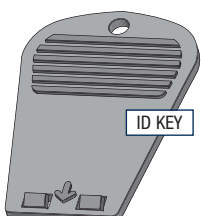
■ SCREWS

CODE	TYPE
ID TBS	Top and bottom screw type TORX



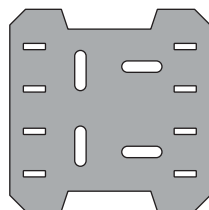
The screws are countersunk assembled

Key to replace assembled faceprofiles

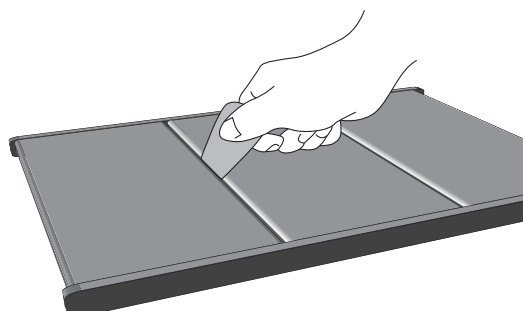


■ GROUNDPLATE

CODE	TYPE
ID GP	Groundplate* for 150 x 150 mm and 200 x 150 mm

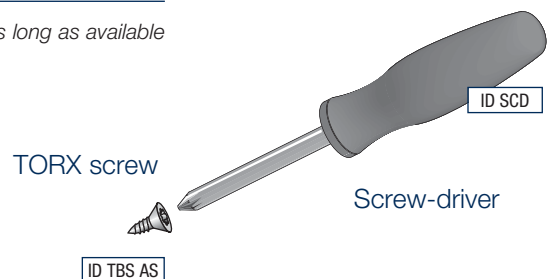


* As long as available



■ SCREW-DRIVER

CODE	TYPE
ID SCD	TORX screw driver



■ KEY

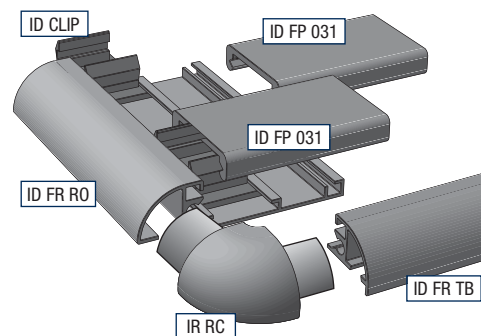
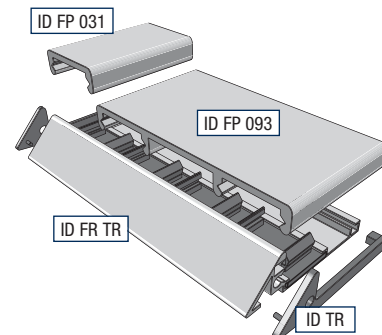
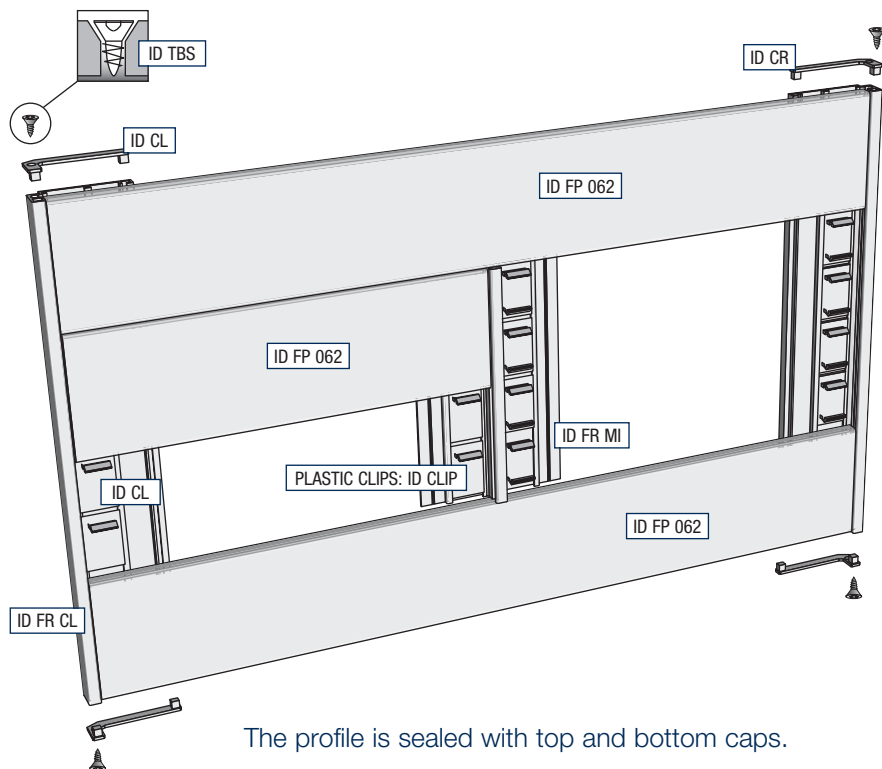
CODE	TYPE
ID KEY	Alusign key

Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.



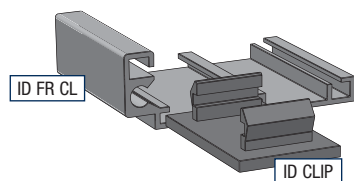
CONSTRUCTION EXAMPLES

INFORMATION AND OVERVIEW BOARDS

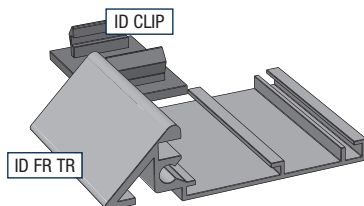


FRAME PROFILES

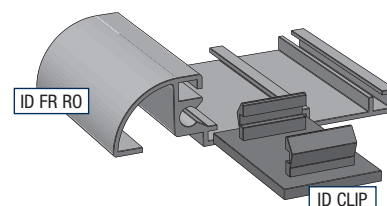
ONE SIDED CLASSIC



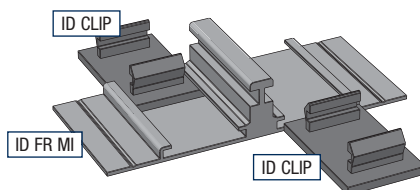
ONE SIDED TRIANGULAR



ONE SIDED RADIUS

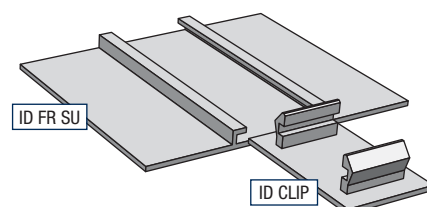


MIDDLE PROFILE



SUPPORT LIST

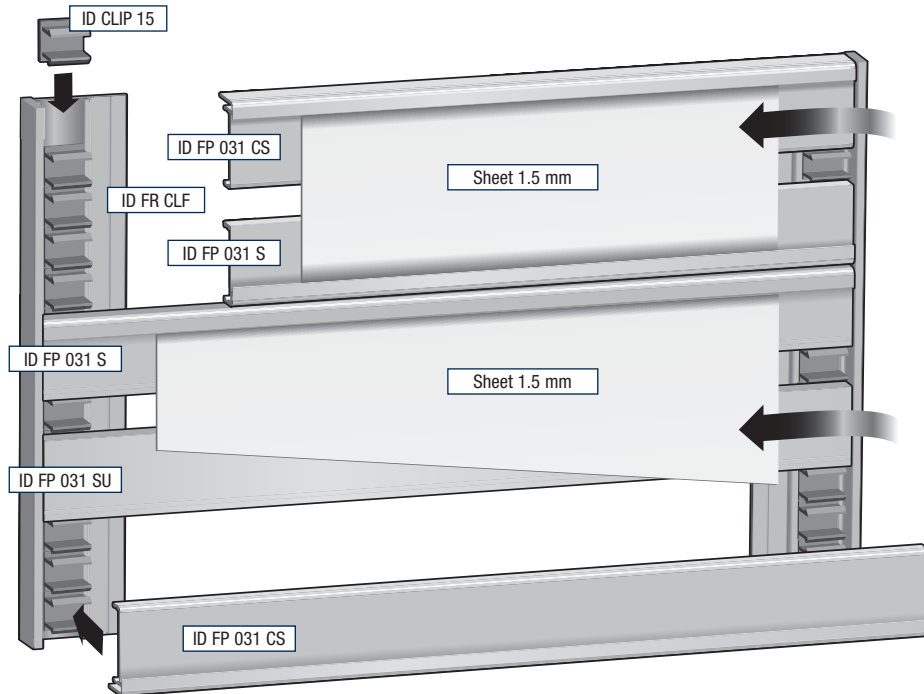
The supporting profile is used for supporting large panels, viz. for lengths of over 1 meter and for the erection of certain structures.



Plastic clips 31mm (ID CL) and 15 mm (ID CL 15) are slid into the profiles. These clips are for fastening the frame to the various text panels.

Clip 15 mm is used for the 15 and 45 mm faceprofiles.

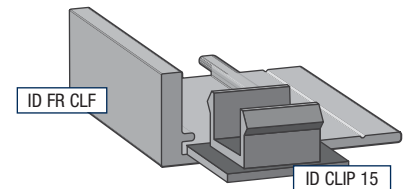
CONSTRUCTION WITH SLIDER PROFILES



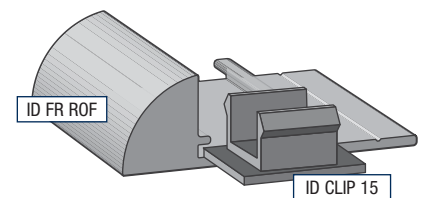
The slider profiles are used to make overview boards with a sheet of 1.5 mm. The support 31 mm gives stability for surfaces with a larger width.

FULL FRAME PROFILES

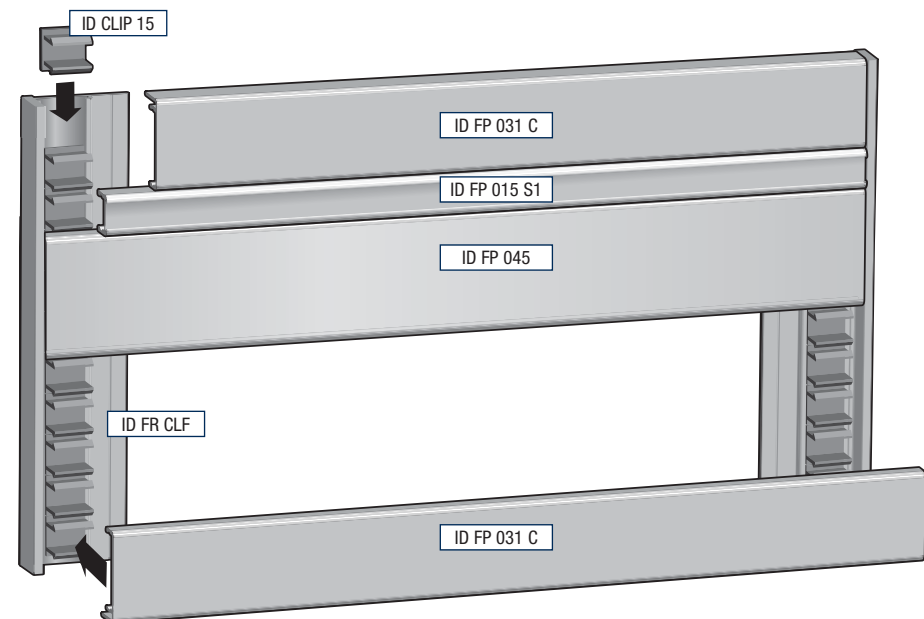
■ ONE SIDED CLASSIC FULL



■ ONE SIDED RADIUS FULL



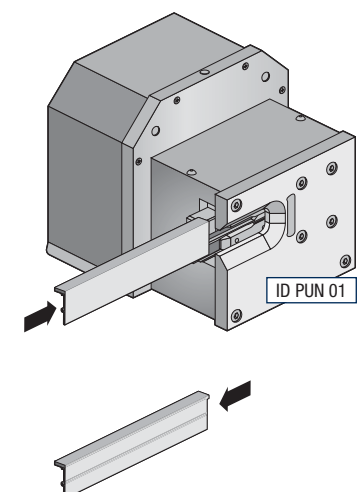
CONSTRUCTION WITH CLASSIC FULL PROFILE



No need to seal the profile with top and bottom caps.

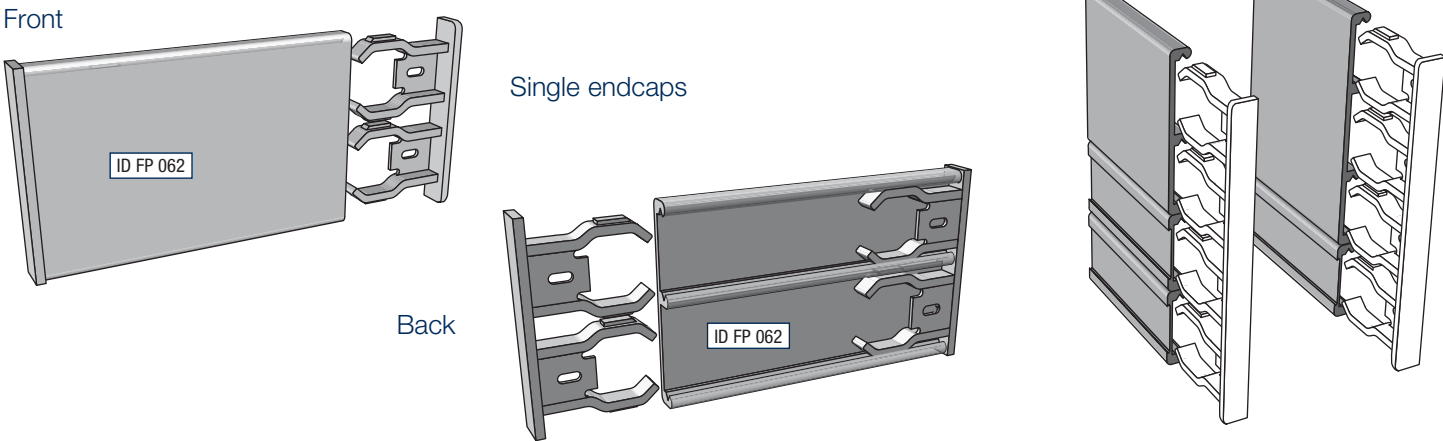
PUNCHING DIE

The punching die is used to cut the angles off the full classic and curved frame profiles. The cover profiles can be inserted into the frame profiles after this operation.

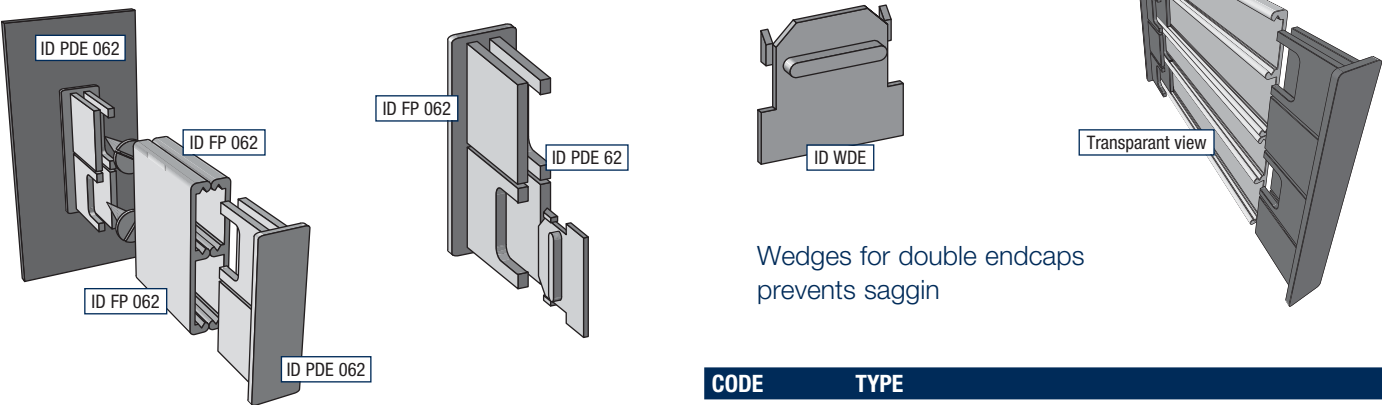




WALL MOUNTING

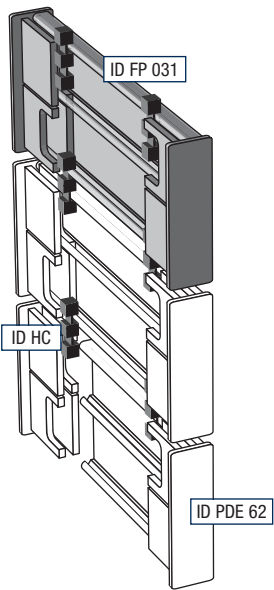


LATERAL WALL MOUNTING



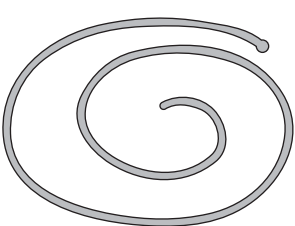
CODE	TYPE
ID WDE	Wedges for double endcaps

HANGING SYSTEM

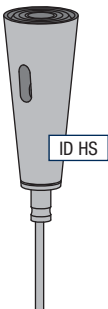


ACCESSORIES HANGING SYSTEM

CODE	TYPE / SIZE	FINISH / COLOUR
ID HS	Inox hanging system	inox
ID HC	Steel cable 100 m	inox

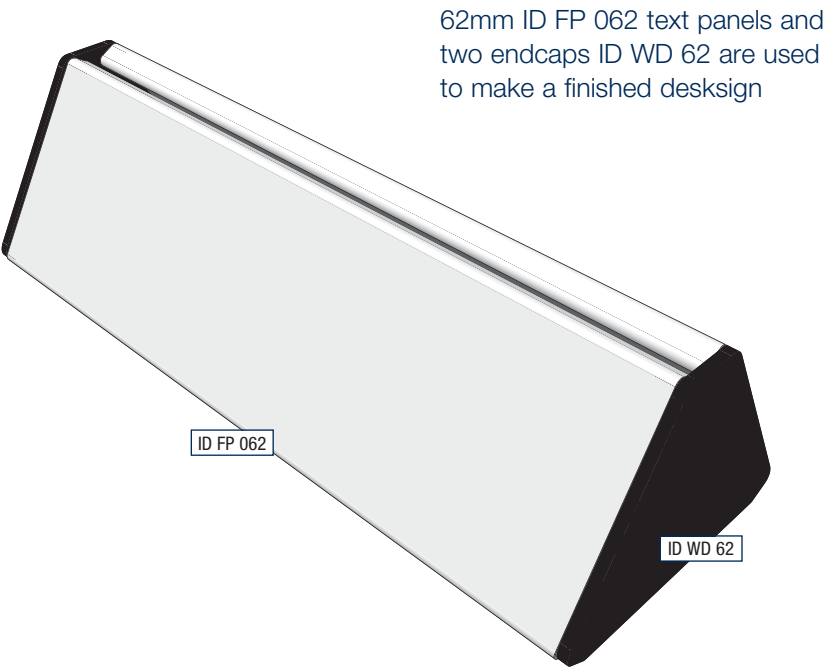


Steel cable ø 1 mm

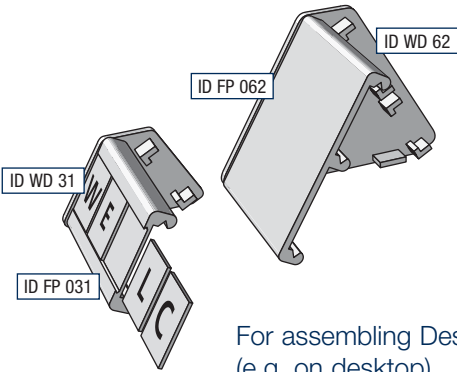


Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

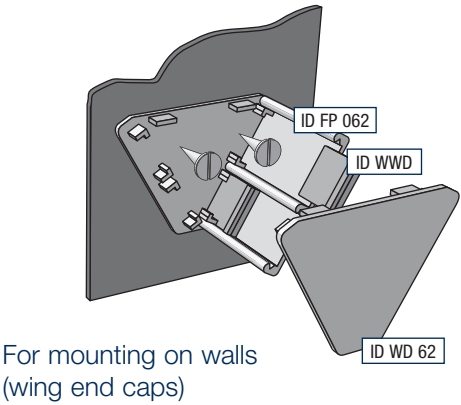
CONSTRUCTION EXAMPLE WING DESK



62mm ID FP 062 text panels and two endcaps ID WD 62 are used to make a finished desksign



For assembling Desksign (e.g. on desktop)



For mounting on walls (wing end caps)

OVERVIEW PLASTIC ENDCAPS FOR WING DESK

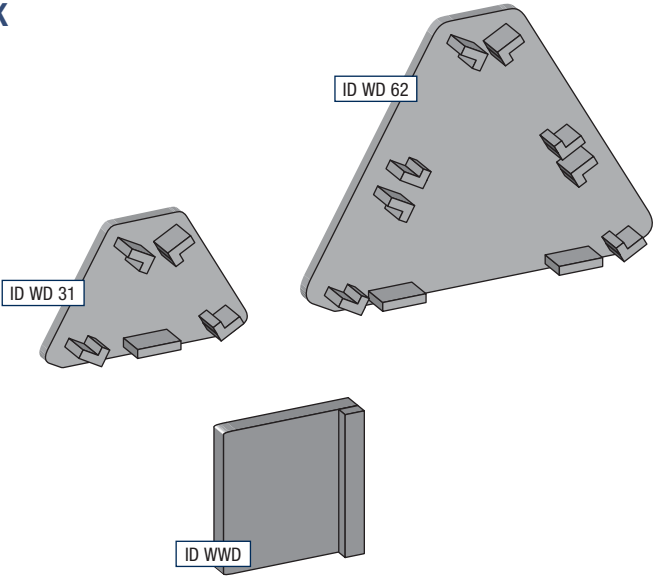
WING DESK ENDCAPS

CODE	TYPE	SIZE
ID WD 31	Wing desk endcaps	31 mm
ID WD 62	Wing desk endcaps	62 mm

WEDGES FOR WING DESK SIGNS

CODE	TYPE
ID WWD	Wedges for wing desk signs

Are used to lock the wingdesk end caps



Indoor information at a glance

02:OUTDOOR

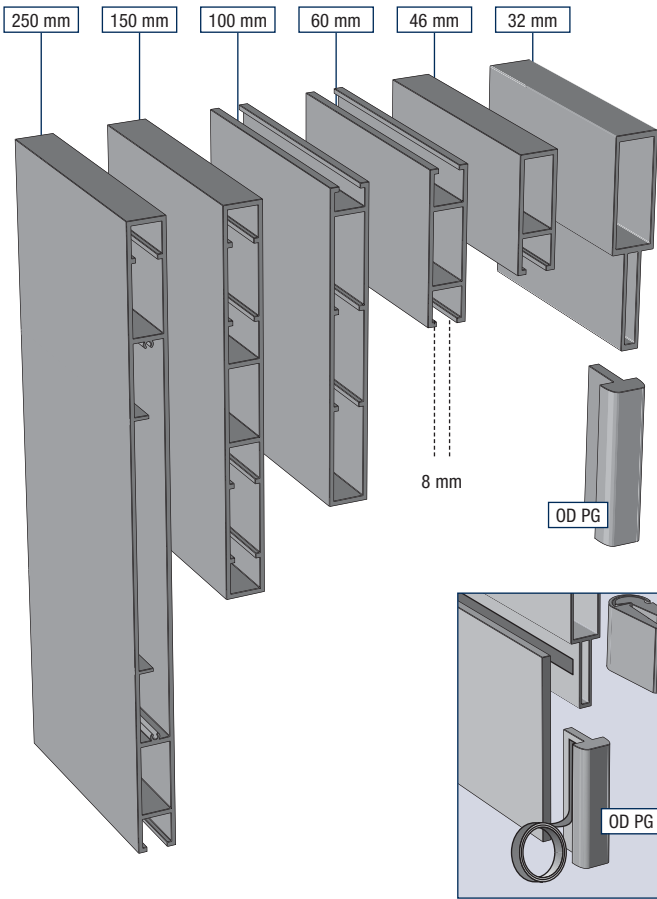
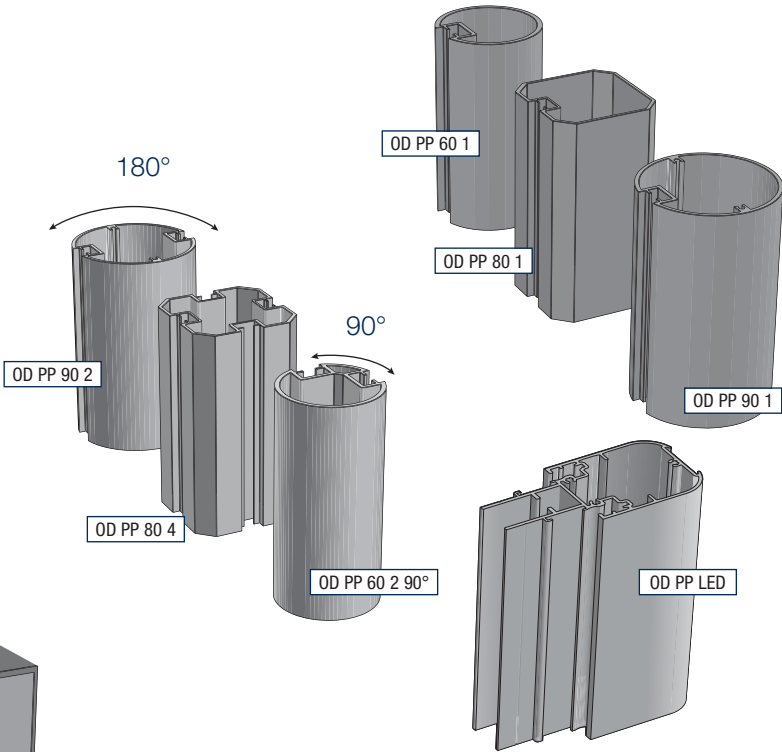


OVERVIEW PROFILES

POST PROFILES

CODE	TYPE	SIZE
OD PP 60 1	One-track	Ø 60 mm
OD PP 80 1	One-track	80 x 80 mm square
OD PP 90 1	One-track	Ø 90 mm
OD PP 60 2	Two-track	Ø 60 mm 90°
OD PP 80 4	Four-track	80 x 80 mm
OD PP 90 2	Two-track	Ø 90 mm 180°
OD PP LED	One-track	60 mm (oval)

The lenght of the uprights is 6.02 m.



LATERAL PROFILES

CODE	TYPE	SIZE
OD PG	Panel grip	-
OF FP 032	Face panel	32 mm
OF FP 046	Face panel	46 mm
OF FP 060	Face panel	60 mm
OF FP 100	Face panel	100 mm
OF FP 150	Face panel	150 mm
OF FP 250	Face panel	250 mm

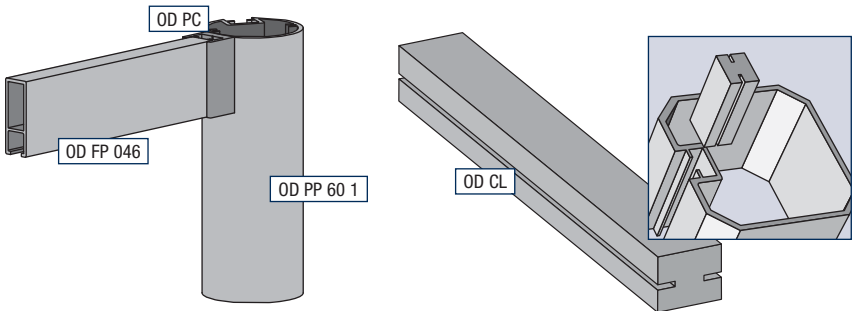
COVER LIST

CODE	TYPE
OD CL	Cover list

POST CONNECTOR

CODE	TYPE
OD PC	Post connector

Fixed on the 60 or 90 mm post, you are able to determine the mounting angle of the text panels.



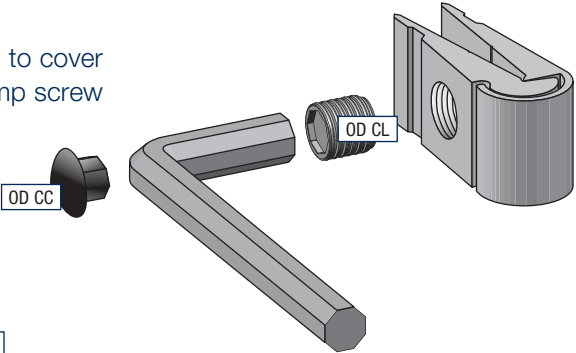
Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

Covers all your outdoor needs

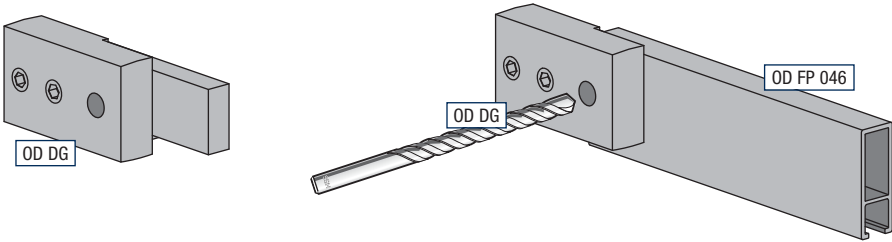
OVERVIEW ACCESSORIES

CODE	TYPE
OD CL	Clamp with inox screw M 10
OD CC	Plastic cap for clamp
OD DG	Drill guide

Plastic cap to cover the clamp screw



DRILL GUIDE

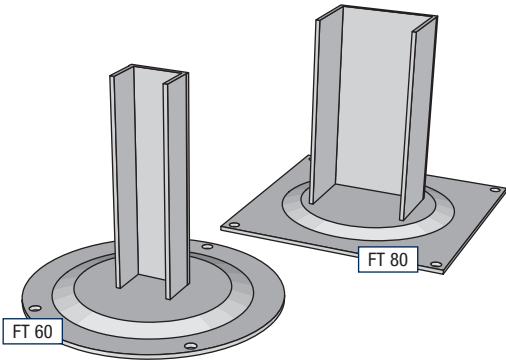
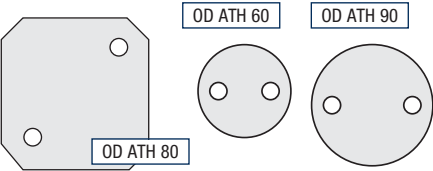


TOP HAT CAPS ALU

CODE	TYPE	SIZE
OD ATH 60	Top hat caps	Ø 60 mm
OD ATH 90	Top hat caps	Ø 90 mm
OD ATH 80	Top hat caps	80 x 80 mm

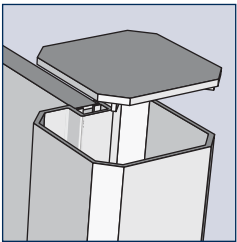
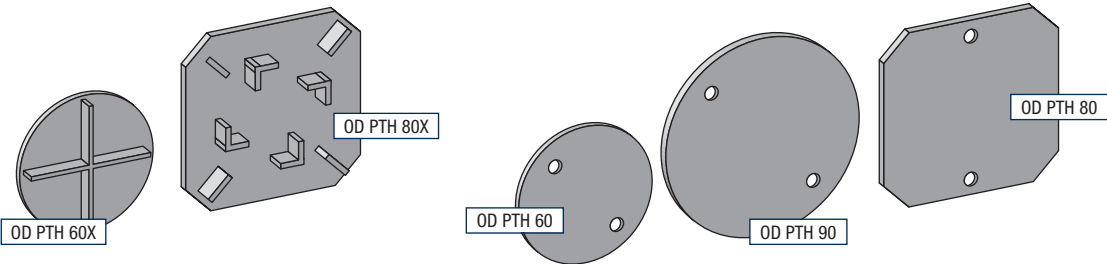
FOOT

CODE	TYPE
FT 60 1-TR	Foot for post 60 1-track
FT 60 2-TR	Foot for post 60 2-track
FT 80	Foot for post 80 1-track



PLASTIC ENDCAPS

CODE	TYPE
OD PTH 60X	Plastic top-hat for post 60 mm - for 1-track only - without screwholes
OD PTH 60	Plastic top-hat for post 60 mm - with screwholes
OD PTH 90	Plastic top-hat for post 90 mm - with screwholes
OD PTH 80X	Plastic top-hat for post 80 mm - for 1-track only - without screwholes
OD PTH 80	Plastic top-hat for post 80 mm - with screwholes

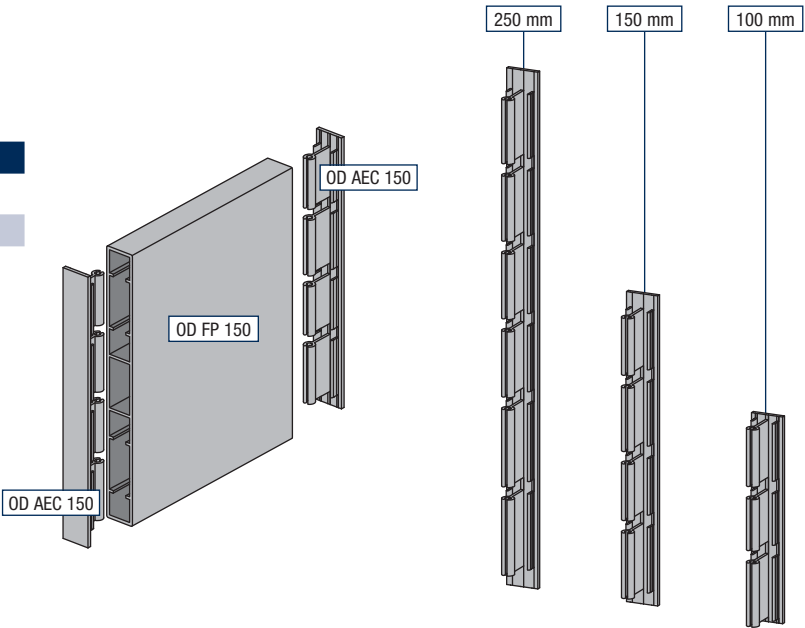


Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

OVERVIEW ACCESSORIES

ALU END CAPS

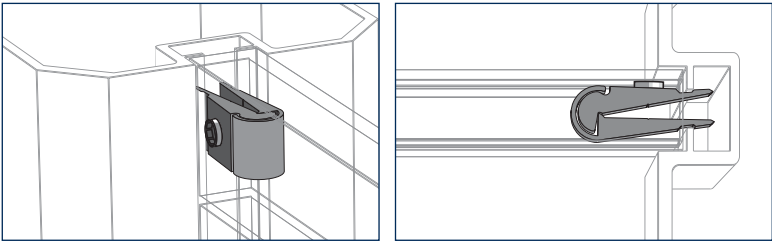
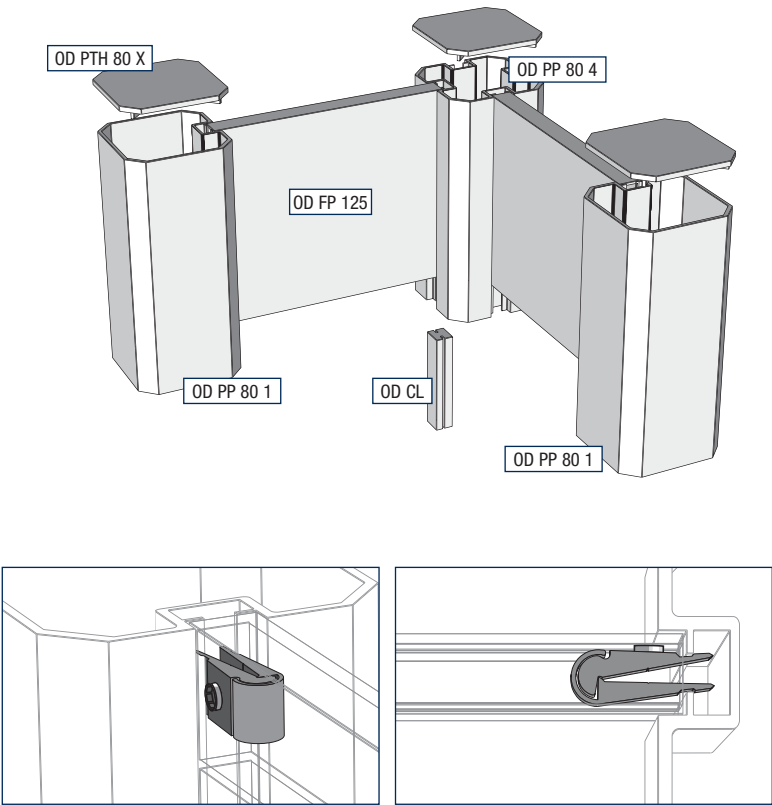
CODE	TYPE	SIZE
OD AEC 100	Alu end cap for face panel	100 mm
OD AEC 150	Alu end cap for face panel	150 mm
OD AEC 250	Alu end cap for face panel	250 mm



CONSTRUCTION EXAMPLES

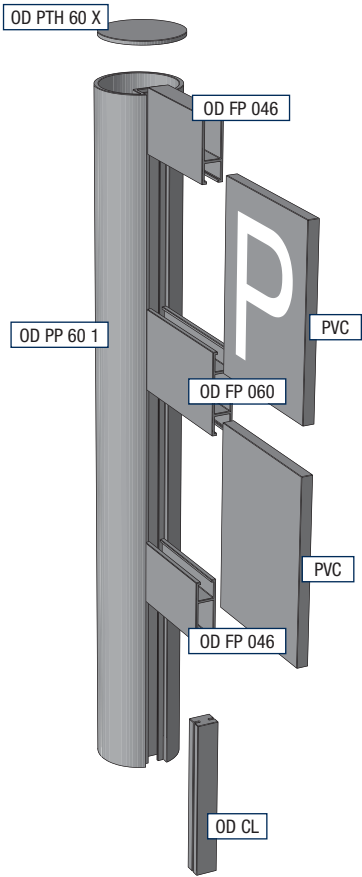
OUTDOOR SYSTEM

SQUARE 80 X 80 MM



Fitting of the clamp OD CL in a box profile and post, transparent view

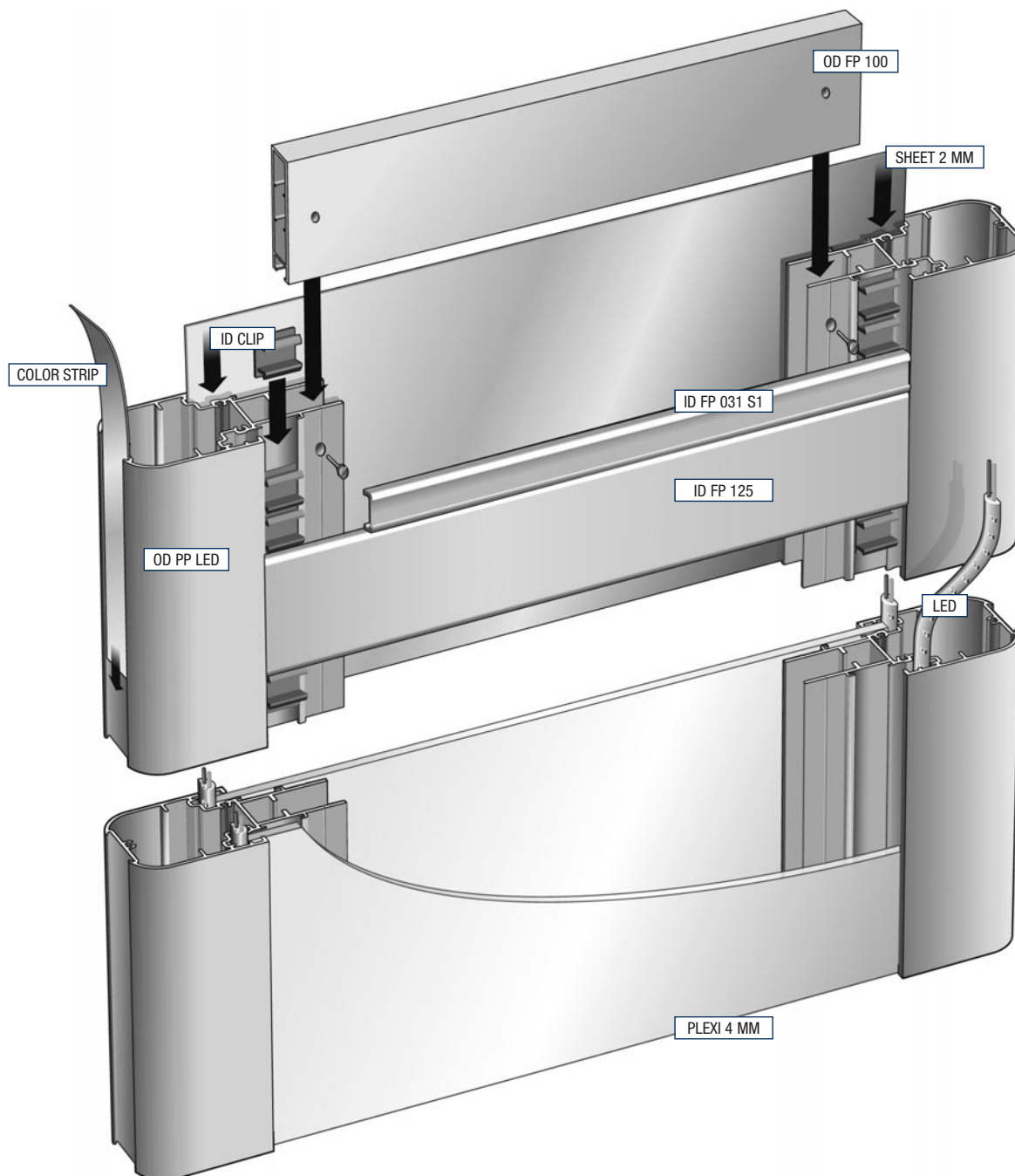
ROUND Ø 60 MM



Covers all your outdoor needs



■ CONSTRUCTION EXAMPLE POST PROFILE LED



Construction with Post Profile LED has different possible combinations:

- Indoor system
- Aluminium sheet & composit panels till 4 mm
- Plexi-glass till 4 mm with possibility to integrate LED lightning.

alu SIGN
OUTDOOR

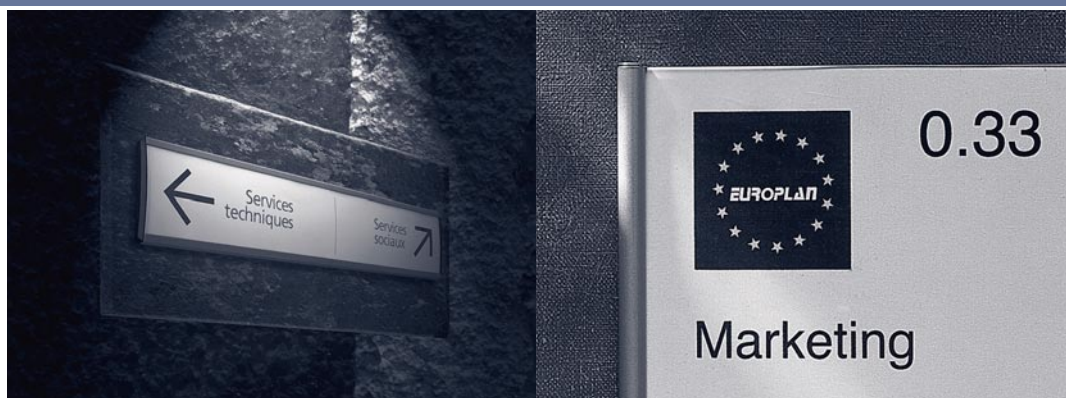
Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

Covers all your outdoor needs

03: PLATO

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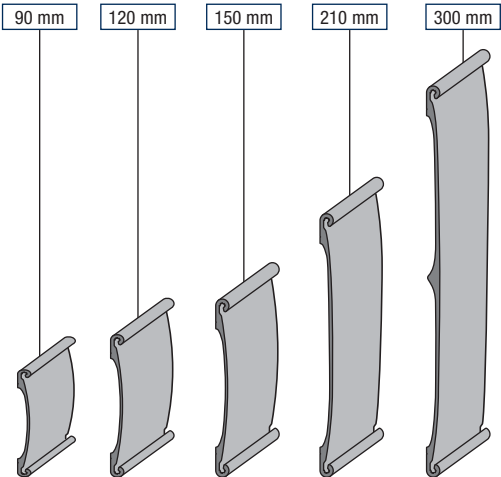
CONSTRUCTION EXAMPLE PLATO

- 1. Aluminium frame
- 2. Text sheet
- 3. Plastic 1 till 1.5 mm
- 4. Tab

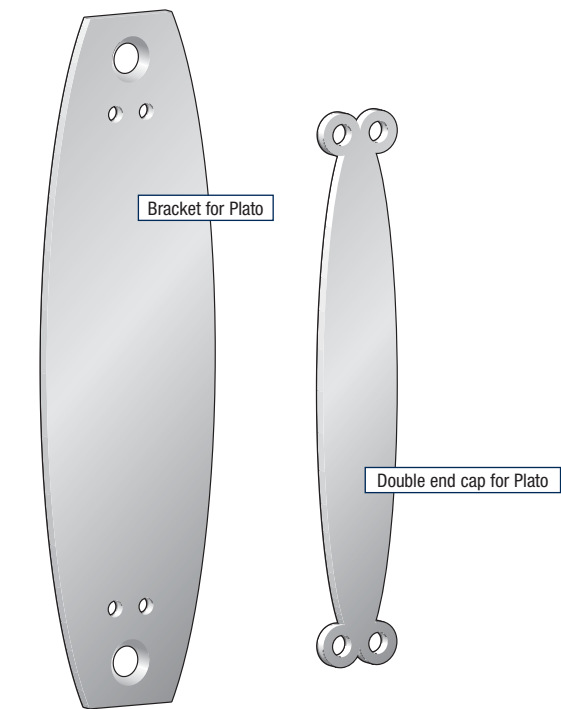
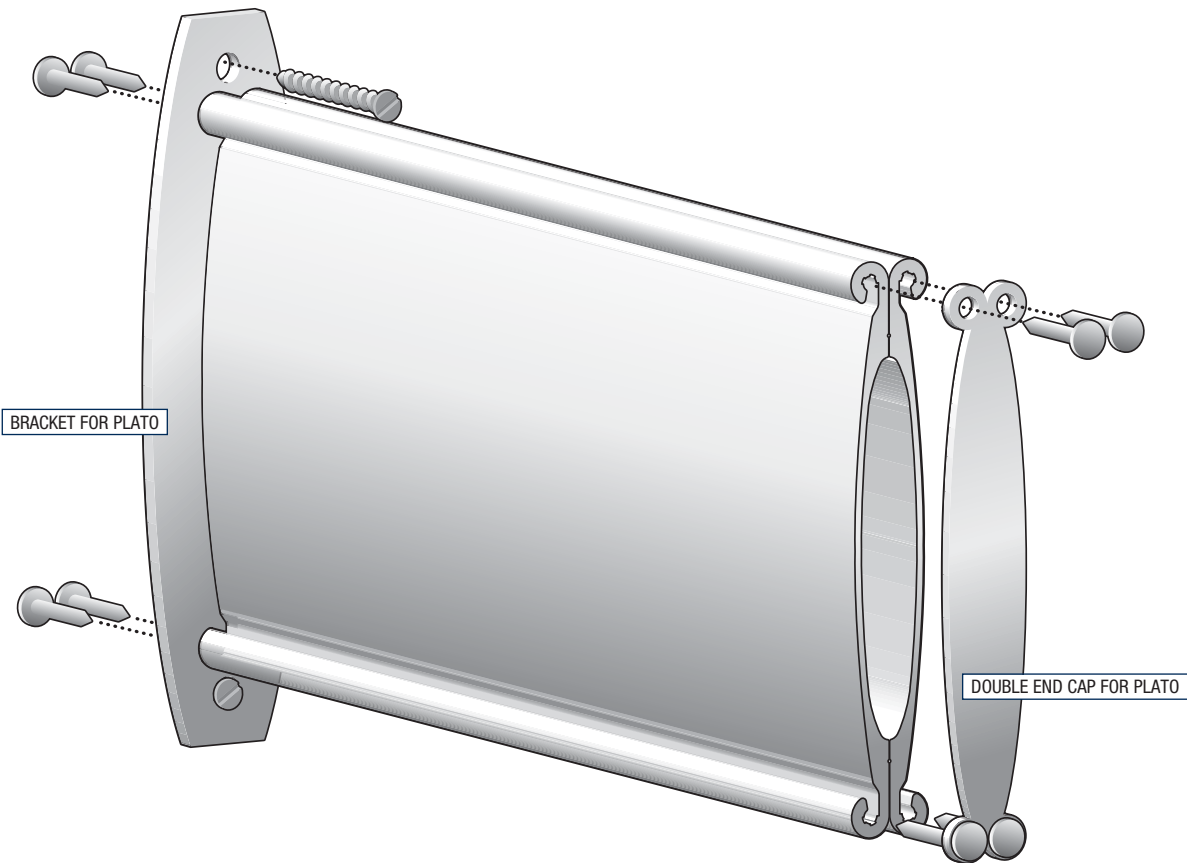


PLATO

CODE	TYPE	SIZE	STRIP ANTI REFLEX
PL tab	Plato inox tab	-	
PL 90	Plato	90 mm	89 x 1 mm
PL 120	Plato	120 mm	119 x 1 mm
PL 150	Plato	150 mm	149 x 1 mm
PL 210	Plato	210 mm	209 x 1,5 mm
PL 300	Plato	300 mm	297 x 1,5 mm



CONSTRUCTION EXAMPLE PROJECTING SIGN



BRACKETS

CODE	TYPE	SIZE
PL BR 090	Bracket for Plato	90 mm
PL BR 120	Bracket for Plato	120 mm
PL BR 150	Bracket for Plato	150 mm
PL BR 210	Bracket for Plato	210 mm
PL BR 300	Bracket for Plato	300 mm

END CAPS

CODE	TYPE	SIZE
PL DEC 090	Double end cap for Plato	90 mm
PL DEC 120	Double end cap for Plato	120 mm
PL DEC 150	Double end cap for Plato	150 mm
PL DEC 210	Double end cap for Plato	210 mm
PL DEC 300	Double end cap for Plato	300 mm

Profiles in mill finish, anodised and RAL.

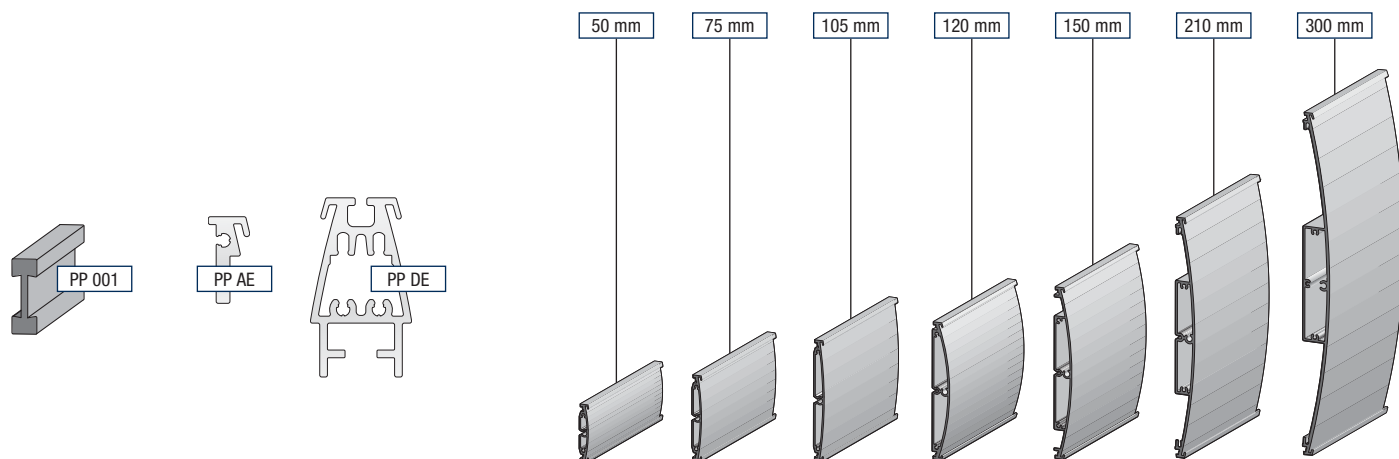
Ensures everyone can find you



■ CONSTRUCTION EXAMPLE PLATO+

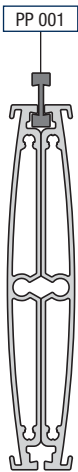


1. Aluminium frame
2. Text sheet
3. Plastic 0.8 till 1 mm
4. Endcap - available in black and grey

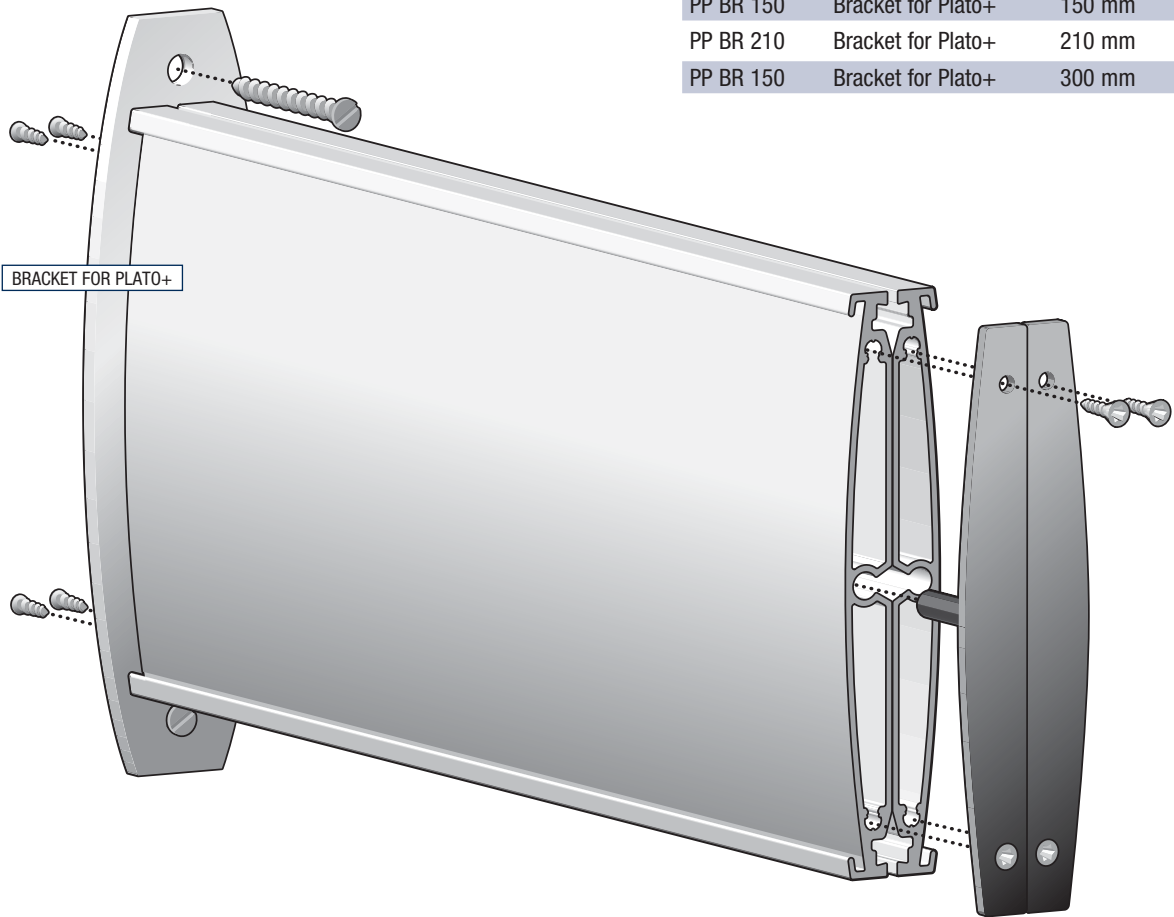


■ PLATO+

CODE	TYPE	SIZE	STRIP ANTI REFLEX
PP 50	Plato+	50 mm	52.5 x 0.8 mm
PP 75	Plato+	75 mm	74 x 0.8 mm
PP 105	Plato+	105 mm	104 x 0.8 mm
PP 120	Plato+	120 mm	121 x 1 mm
PP 150	Plato+	150 mm	148 x 1 mm
PP 210	Plato+	210 mm	209 x 1 mm
PP 300	Plato+	300 mm	297 x 1 mm
PP 001	Plato+ fixing profile		
PP AE	Plato + all edges	400 till 600 mm	
PP DE	Plato + double edges	150 till 600 mm	



CONSTRUCTION EXAMPLE PROJECTING SIGN



■ BRACKETS

CODE	TYPE	SIZE
PP BR 075	Bracket for Plato+	90 mm
PP BR 105	Bracket for Plato+	105 mm
PP BR 120	Bracket for Plato+	120 mm
PP BR 150	Bracket for Plato+	150 mm
PP BR 210	Bracket for Plato+	210 mm
PP BR 300	Bracket for Plato+	300 mm

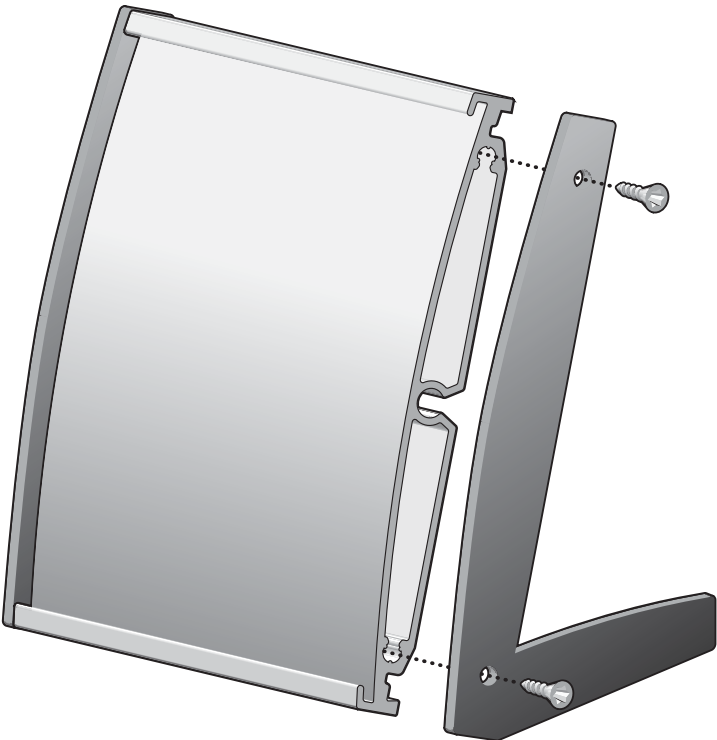


CONSTRUCTION EXAMPLE WING DESK

■ WING DESK

CODE	TYPE	SIZE
PP AWD 050	PP alu wing desk	50 mm
PP AWD 075	PP alu wing desk	75 mm
PP AWD 105	PP alu wing desk	105 mm

Available in black and silver anodised.



CONSTRUCTION EXAMPLE ALL EDGES

■ ALUMINIUM ENDCAPS

CODE	TYPE	SIZE
PP AAE 400	PP all edges alu endcap	400 mm
PP AAE 420 (A2)	PP all edges alu endcap	420 mm
PP AAE 500	PP all edges alu endcap	500 mm
PP AAE 600	PP all edges alu endcap	600 mm

Available in black and silver



Wall mounting with a width till 600 mm

CONSTRUCTION EXAMPLE
WITH DOUBLE EDGES



Width till 600 mm
Existing plastics endcaps
till 300 mm can be used

■ ALUMINIUM ENDCAPS

CODE	TYPE	SIZE
PP ADE 150	PP double edges alu endcap	150 mm
PP ADE 210	PP double edges alu endcap	210 mm
PP ADE 300	PP double edges alu endcap	300 mm
PP ADE 400	PP double edges alu endcap	400 mm
PP ADE 420 (A2)	PP double edges alu endcap	420 mm
PP ADE 500	PP double edges alu endcap	500 mm
PP ADE 600	PP double edges alu endcap	600 mm

Available in black and silver

Ensures everyone can find you



TOTEM CONSTRUCTION EXAMPLE WITH PLATO + DOUBLE EDGES

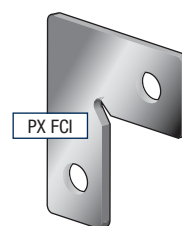
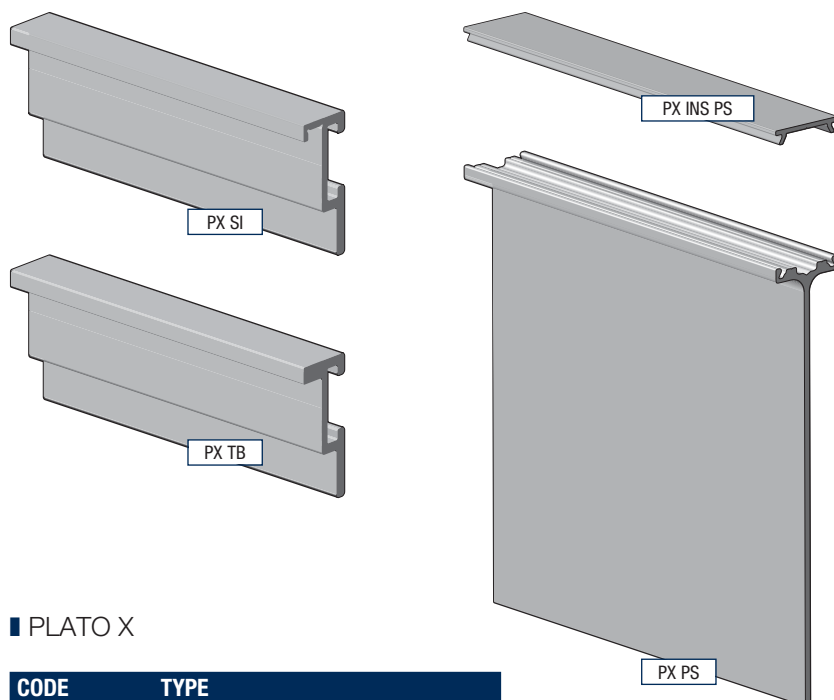


■ PLATO X

■ DIMENSIONS ON STOCK IN ANODISED SILVER

CODE	INSERTS	THICKNESS PLEXI
PX 075105 AS	75 x 105 mm	1,5 mm
PX 105105 AS	105 x 105 mm	1,5 mm
PX 148105 AS	148,5 x 105 mm	1,5 mm
PX 148148 AS	148,5 x 148,5 mm	1,5 mm
PX 210148 AS	210 x 148,5 mm	2 mm
PX 297210 AS	297 x 210 mm	2 mm
PX 297148 AS	297 x 148,5 mm	2 mm
PX 300150 AS	300 x 150 mm	2 mm
PX 420297 AS	420 x 297 mm	2 mm
PX 594420 AS	594 x 420 mm	2 mm
PX 600150 AS	600 x 150 mm	2 mm
PX 600105 AS	600 x 105 mm	2 mm
PX 800105 AS	800 x 105 mm	2 mm
PX 841594 AS	841 x 594 mm	2 mm

Other dimensions or lacquered possible on request



■ ACCESSORIES

CODE	TYPE
PX FCI	Plato X fixing inox corner

■ PLATO X

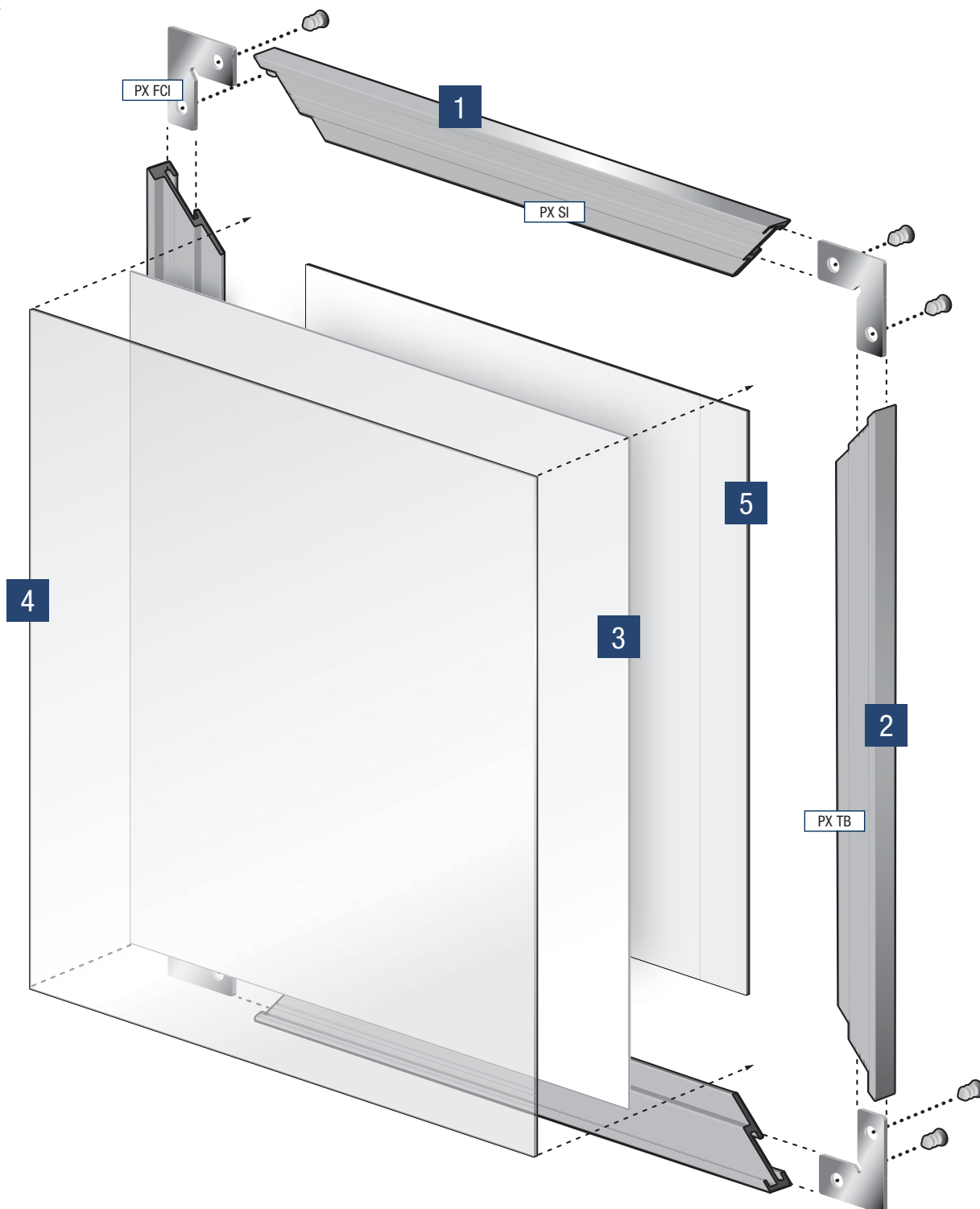
CODE	TYPE
PX SI	Plato X side profile
PX TB	Plato X top and bottom profile
PX PS	Plato X projecting profile
PX INS PS	Plato X insert projecting profile

Profiles in mill finish and anodised silver

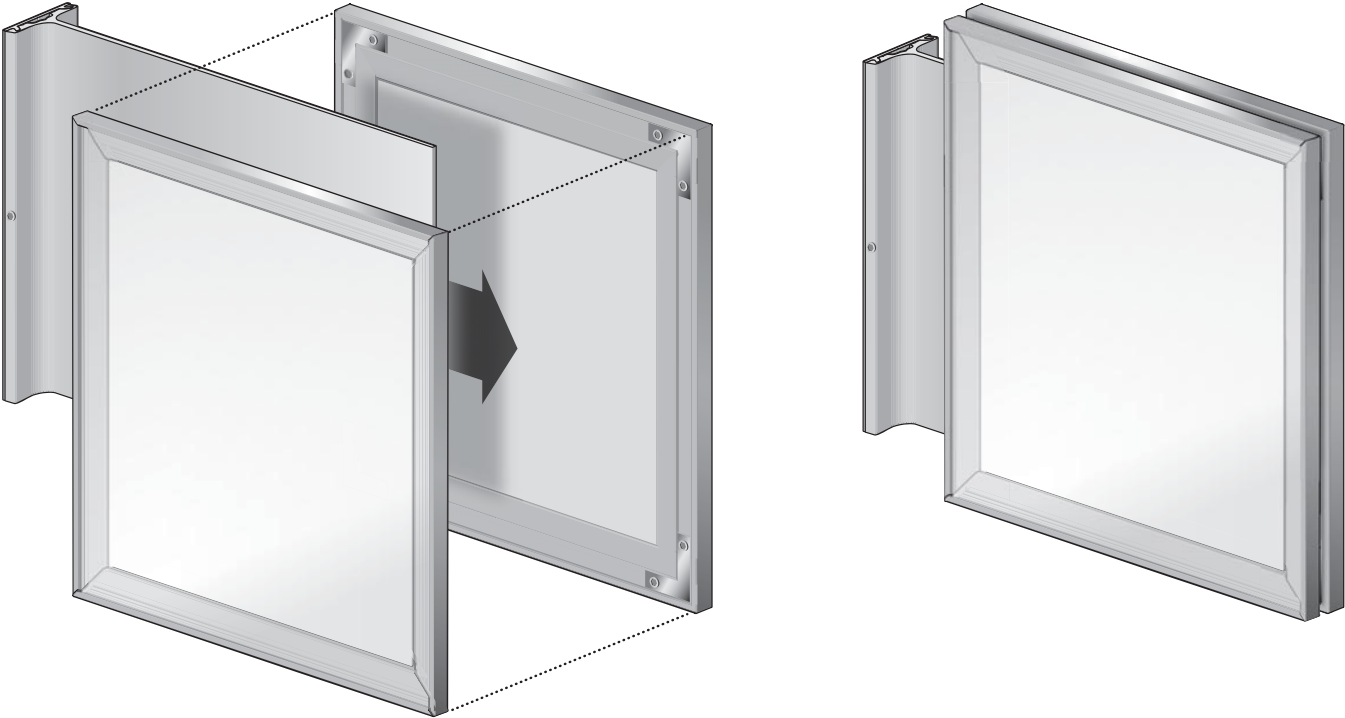


CONSTRUCTION EXAMPLE PLATO X

1. Plato X - side profile
2. Plato X - top and bottom profile
3. Text frame
4. Plastic: 1.5 till 2 mm
5. Dibond sheet



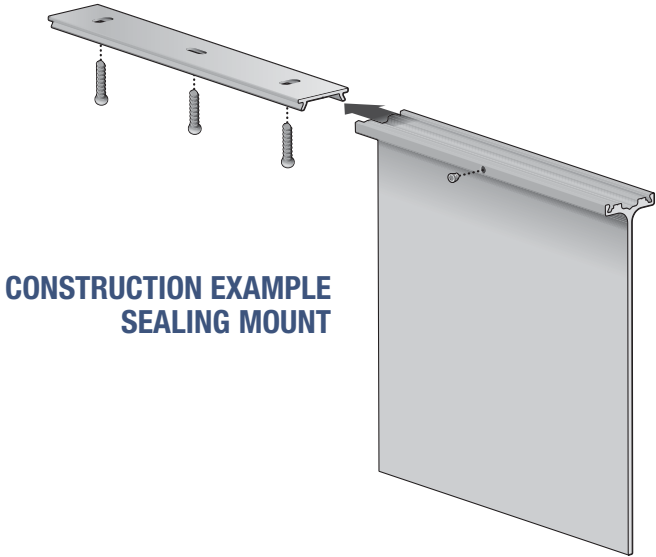
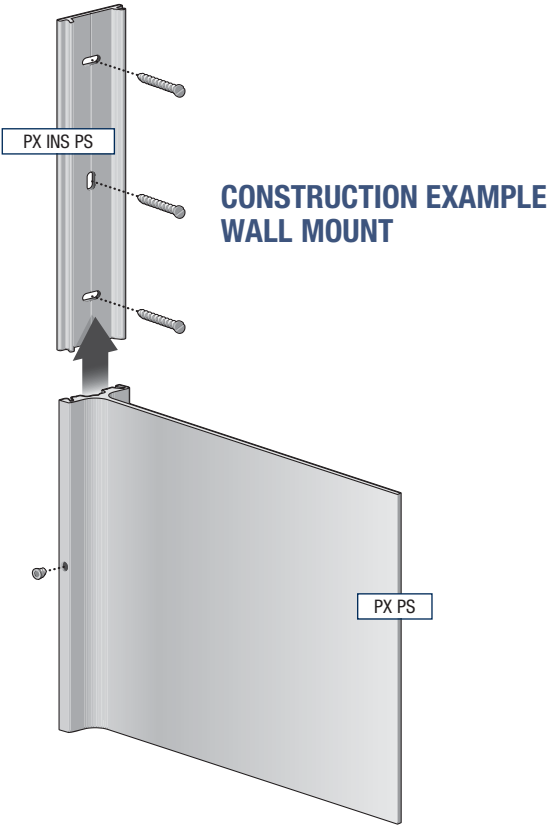
CONSTRUCTION EXAMPLE PROJECTING SIGNS



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PROJECTING SIGNS - DIMENSIONS ON STOCK

CODE	SIZE
PX 150150 PS	150 x 150 mm
PX 300150 PS	300 x 150 mm

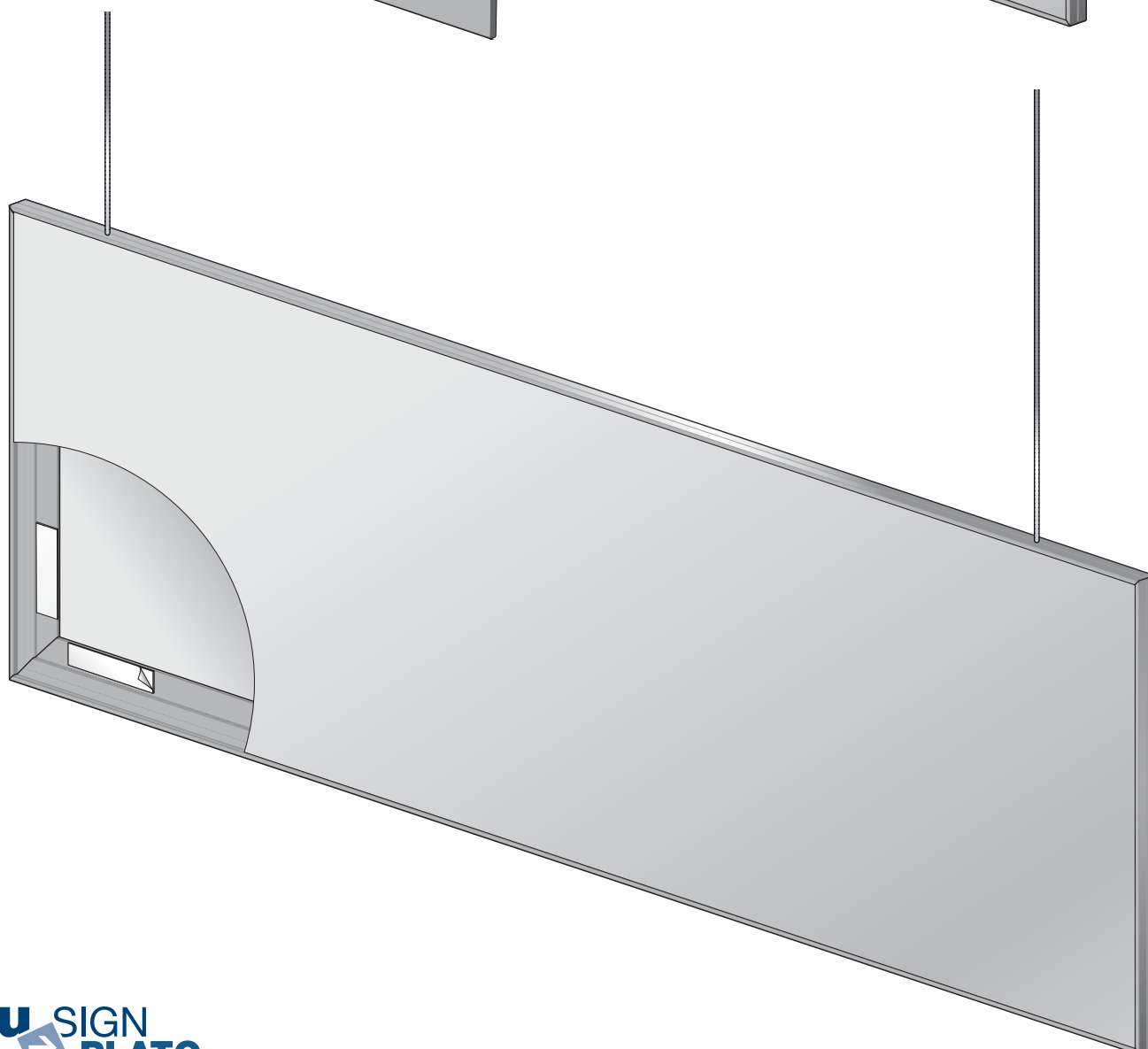
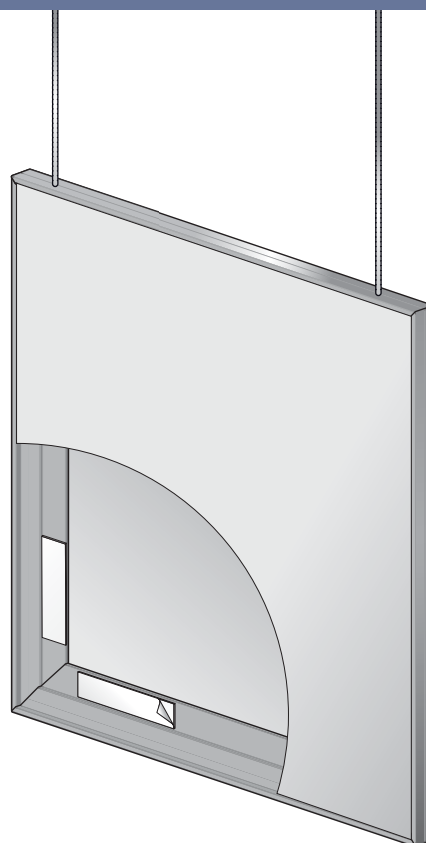
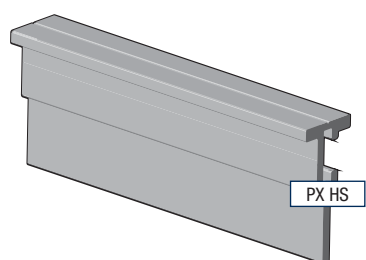




■ PLATO X HANGING SYSTEM

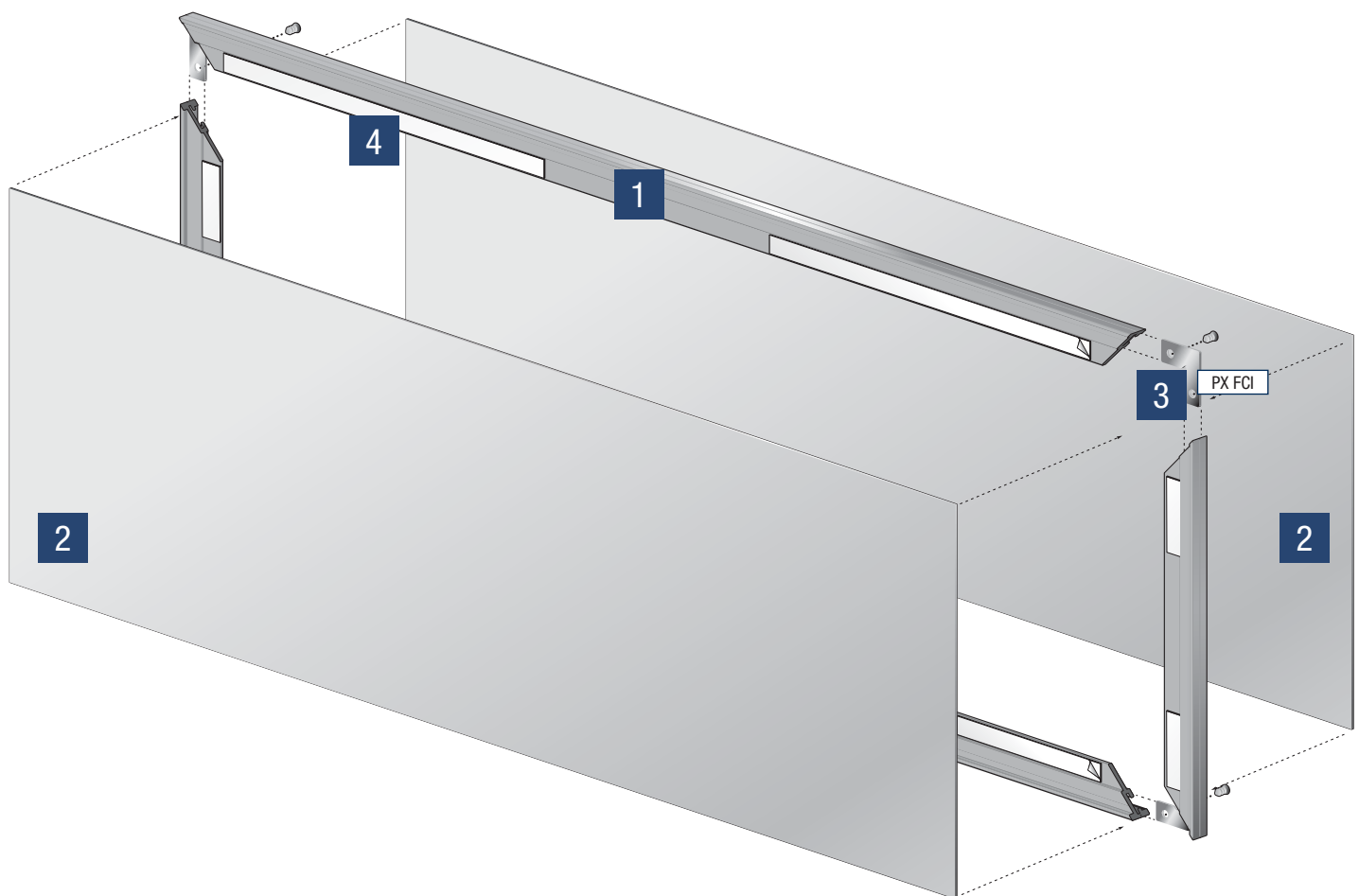
CODE	INSERTS
PX 148148 HS	148,5 x 148,5 mm
PX 297148 HS	297 x 148,5 mm
PX 594105 HS	594 x 105 mm
PX 594148 HS	594 x 148,5 mm
PX 600105 HS	600 x 105 mm

Dimensions on stock – other dimensions possible on request

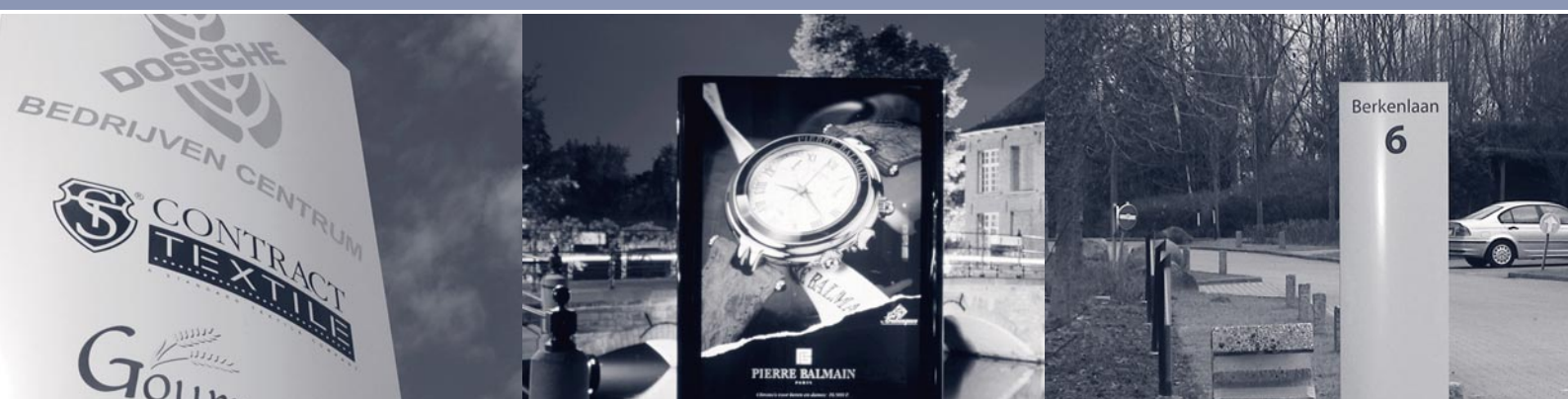


CONSTRUCTION EXAMPLE PLATO X HANGING SYSTEM

1. Plato X - hanging sign
2. Text frame in dibond or aluminium sheet of 2 or 3 mm thickness
3. PX fixing inox corner
4. Double tape



04:TOTEM



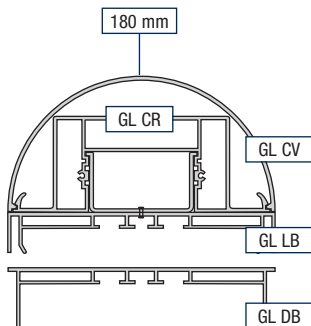
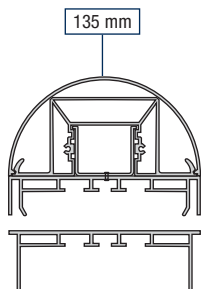
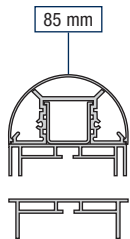
GLOBE

Versions

You can choose between the Lightbox sections and the Di-box sections. Both types are available in widths of 85, 135 and 180 mm.

As the name suggests, the Lightbox sections are used to make lightboxes, either single or double-sided, for displaying slides, posters etc.

The Di-box system is intended more for making up complete columns with composite aluminium plates, which can have colours and text added to them. The two systems are also suitable for mounting in combination with each other.



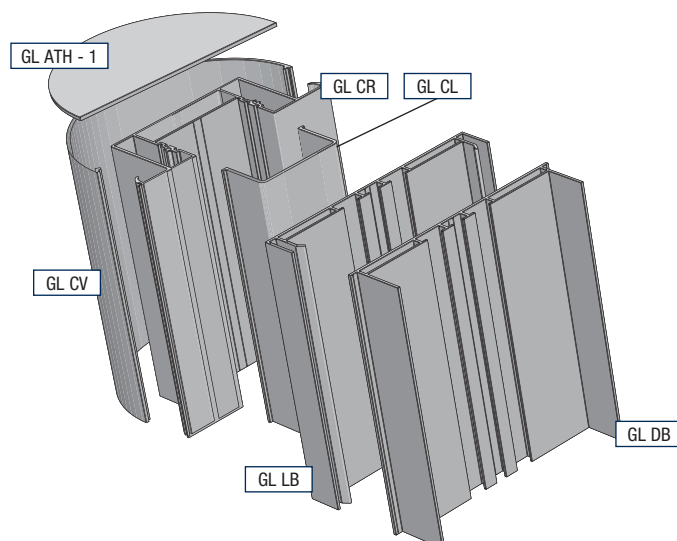
CODE	TYPE	MAXIMUM THICKNESS SHEET	MAXIMUM THICKNESS PLEXI
GL CV 085	Globe post profile 85 cover		
GL CR 085	Globe post profile 85 core		
GL CL 085	Globe post profile 85 clip		
GL LB 085	Globe light-box profile 85		5 mm
GL DB 085	Globe di-box profile 85	3 mm	
GL ATH 085-1	Globe alu top hat 85-1		
GL CV 135	Globe post profile 135 cover		
GL CR 135	Globe post profile 135 core		
GL CL 135	Globe post profile 135 clip		
GL LB 135	Globe light-box profile 135		5 mm
GL DB 135	Globe di-box profile 135	4 mm	
GL ATH 135-1	Globe alu top hat 135-1		
GL CV 180	Globe post profile 180 cover		
GL CR 180	Globe post profile 180 core		
GL CL 180	Globe post profile 180 clip		
GL LB 180	Globe light-box profile 180		5 mm
GL DB 180	Globe di-box profile 180	5 mm	
GL ATH 180-1	Globe alu top hat 180-1		

For higher thickness with lightbox: use the lightbox - fix 135 and 180 mm

Other top hat caps are available.

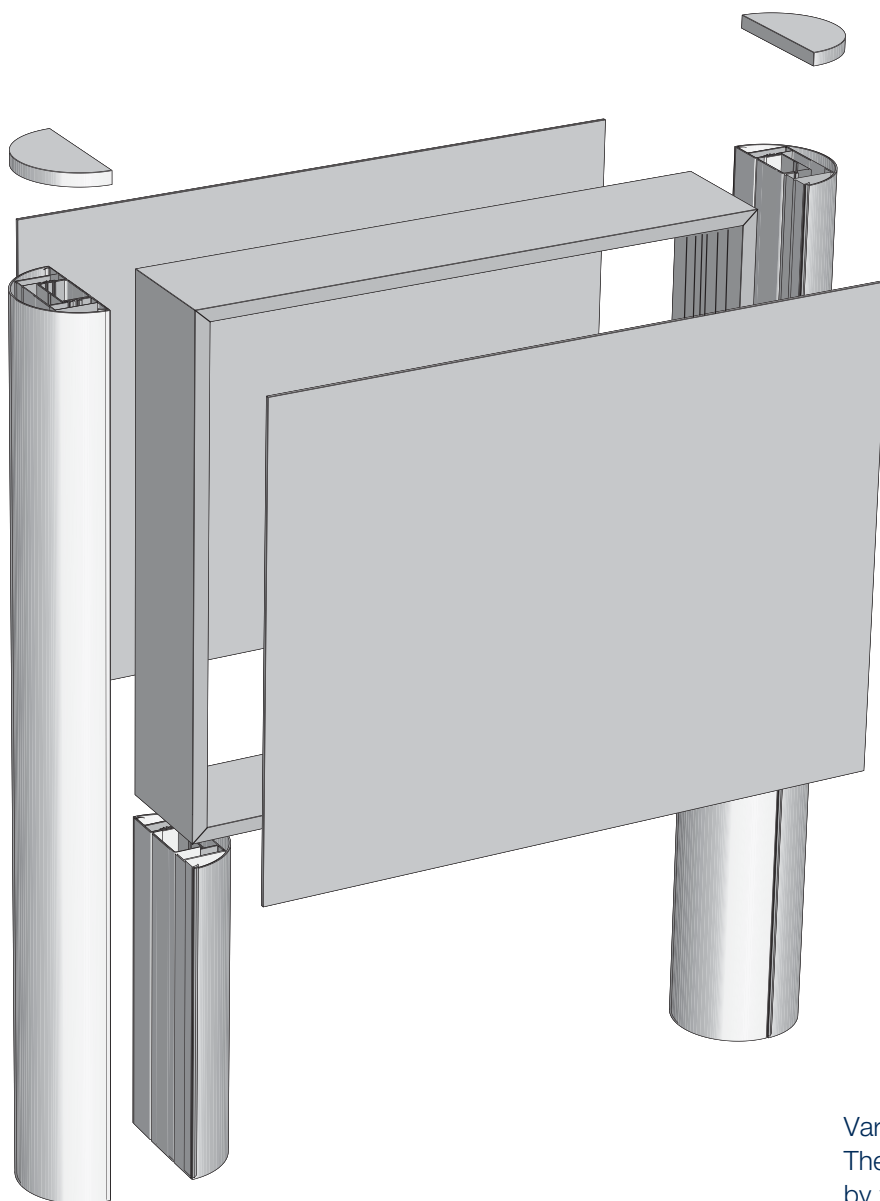
On the technical side

Simple and quick to assemble. Easy to maintain. The support sections can be sunk into the ground or mounted on metal foot plates anchored by bolts. As can be seen from the drawing, there are lots of possibilities for both types of section. Note also the special wall mounting, where the light box is mounted perpendicular to the wall without supporting poles.

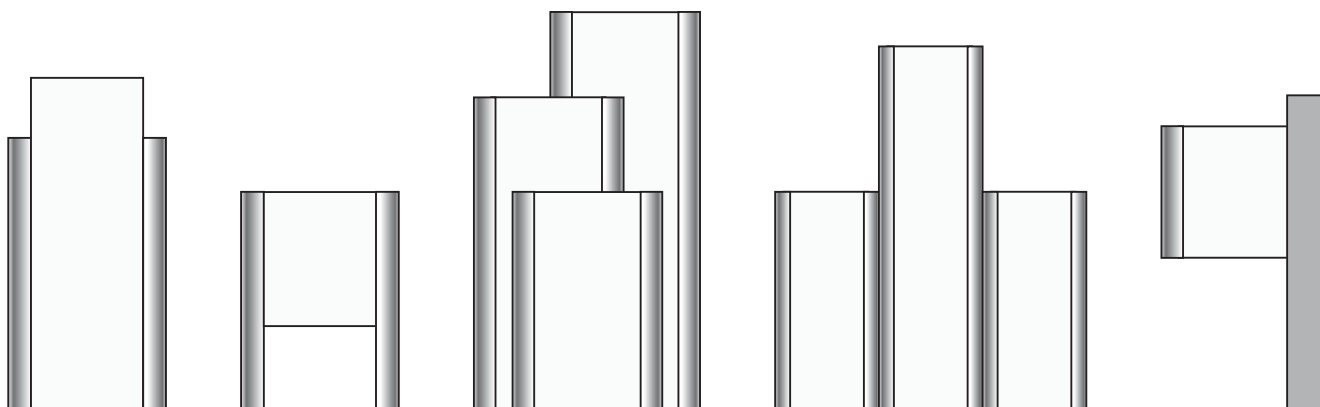




■ CONSTRUCTION EXAMPLE GLOBE



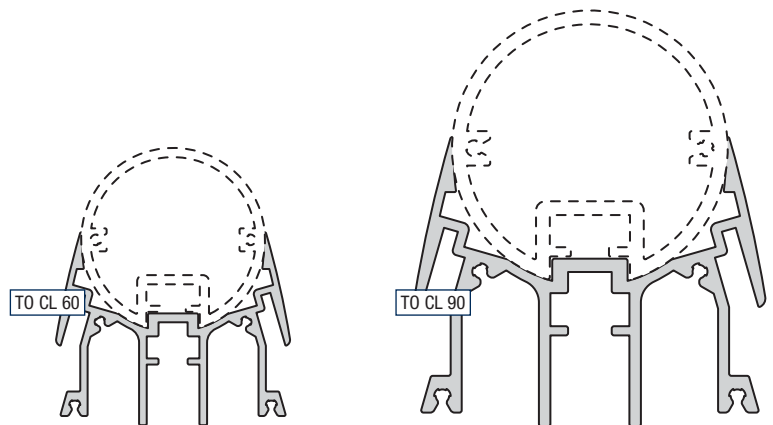
Various versions are possible.
The possibilities are only limited
by your imagination.



OVERVIEW TOTEM CLAM

CODE	TYPE
TO CL 60	Totem Clam post circular 60
TO CL 90	Totem Clam post circular 90

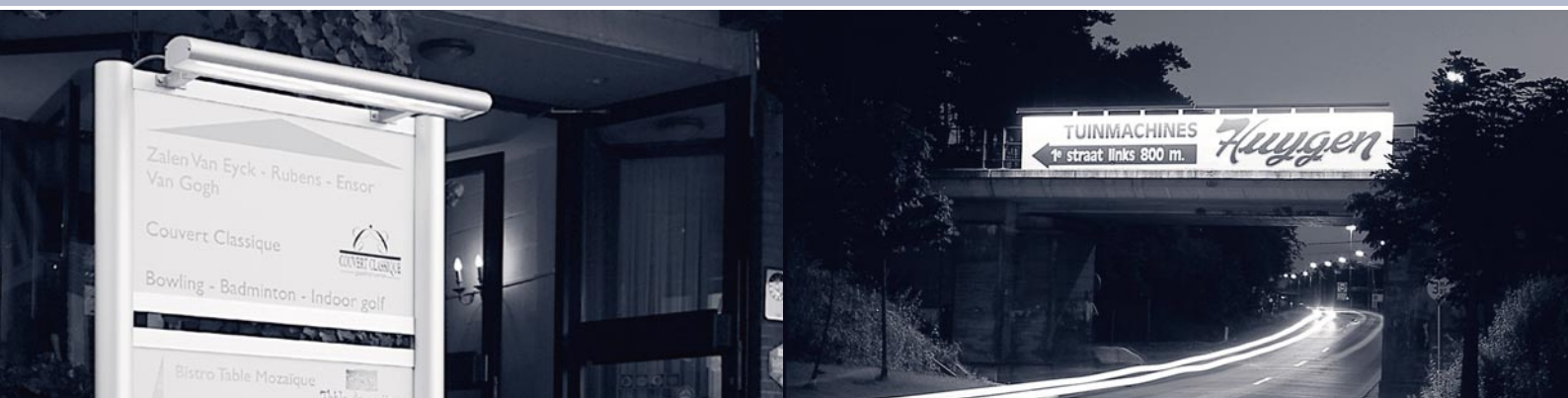
Totem construction is connected by OD FP 100.
A sheet (max. thickness 4 mm) connects the two Totem clams.



CONSTRUCTION EXAMPLE TOTEM CLAM



05:HIGHLIGHT



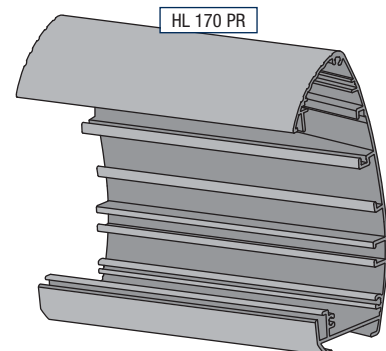
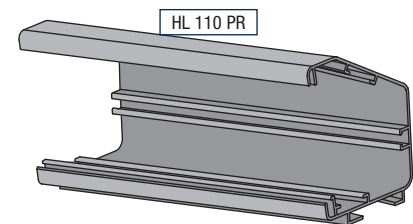
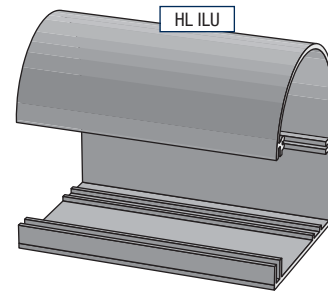
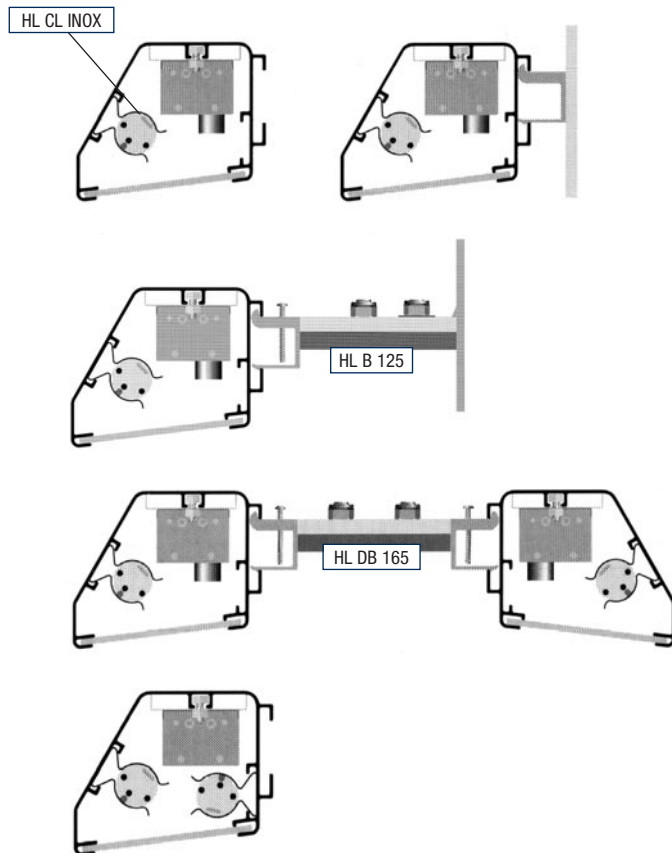
OVERVIEW ILLUMINATOR

CODE	TYPE
HL ILU PR	Highlight Illuminator profile
HL 110 PR	Highlight 110 profile
HL 170 PR	Highlight 170 profile

ALUMINIUM TOP HATS (box of 10 pcs.)

CODE	SIZE
HL ILU AEC	Highlight alu endcap illuminator
HL 110 AEC	Highlight alu endcap 110
HL 170 AEC	Highlight alu endcap 170

* Is available in mill finish, anodised and RAL 9016



BRACKETS AND ACCESSORIES

CODE	TYPE
HL CL INOX	Highlight tube clips
HL 110 CO	Highlight 110 connector
HL B 125	Highlight bracket 125 mm
HL B 200	Highlight bracket 200 mm
HL B 300	Highlight bracket 300 mm
HL B 400	Highlight bracket 400 mm
HL DB 165	Highlight double bracket 165 mm

Profiles for brackets are also available in 5000 mm length.

TECHNICAL DATA

1. LENGTH OF THE PROFILES

All the profiles are supplied in lengths of 5.02 metres, except for the outdoor uprights, totem and highlight profiles - they come in lengths of 6.02 metres.

2. THE ALUMINIUM ALLOY

American standard: AA 6060

British standard: HE 9

German standard: ALM GSI 0.5

European standard: EN AW 6060

3. SHOP-PRIMING OF THE ALUMINIUM

Stoving work: the pre-treatment can only be done properly with aluminium of the right grade and the stoved aluminium will have no visible surface flaws (e.g. extrusion lines).

The pre-treatment is done by dip-coating and this in accordance with DIN 50939.

It comprises the following stages:

- degreasing
- removal of any impurities
- the application of a conversion coat

The spraying with paint and the stoving should be done as soon as possible after pre-treatment so as to avoid fouling the workpiece with dust or dirt.

The profiles are hung up and sprayed automatically, in an electrostatic spraying process. Any small areas that might have been missed are touched up, where necessary, by manual spraying. This is followed by having the polyester powder cured in a chamber furnace at 200 °C, for 12 minutes.

The polyester which is used for this is a thermosetting coating with a base of saturated polyester resins. The surface treatment is ideal for use in the building industry due to its good weather resistance, resistance to ageing and its resistance to UV light.

Thickness of primer: 60 microns.

The panels are guaranteed colourfast. The colours, in the production process, are kept permanent.

4. QUALITY OF THE ALUMINIUM PROFILES

Alusign aluminium profiles meet the quality standard, ISO 2000.

5. ANODIZING OF THE PROFILES

Alusign profiles achieve the QUALANOD - EWAA/ EURAS quality seal for architectural anodization.

The procedure for a 15 micron, colourless, anodization coat, with a satin finish:

DEGREASING:

The profiles are immersed in hot water for 20 minutes (tensides 35 g/l) at 65 °C. The bath is agitated with air.

PICKLING:

The profiles are satinized by mat dipping in caustic soda at 1 % conc. at 55 °C by the "Epal" method, for 18 minutes.

ANODIZATION:

The anodization is done in sulphuric acid (150 g/l) + oxalic acid (15 g/l) at a temperature of 22 °C.

The current density is 1.5 A/dm². The voltage is 20 V.

The bath is agitated with air.

The anodization time is more than 55 minutes.

The coating after each charge is checked using a Fischer coating thickness meter.

CONDENSATION

Condensation takes place in stainless steel vats filled with demineralized water at a temperature of 98 °C.

The pH of the water lies between 5.5 and 6.5. Silicates (10 mg/l) and the electric conductance (1,500 µS, viz. microsiemens) of the water are measured daily.

The condensation time must not be shorter than 3 minutes per micron.

The quality of the condensation is measured every 2 hours by means of a drop test and every other day by means of a test for weight loss.

RINSING:

Between the active baths the profiles are rinsed in several baths, the last of which contains demineralized water.

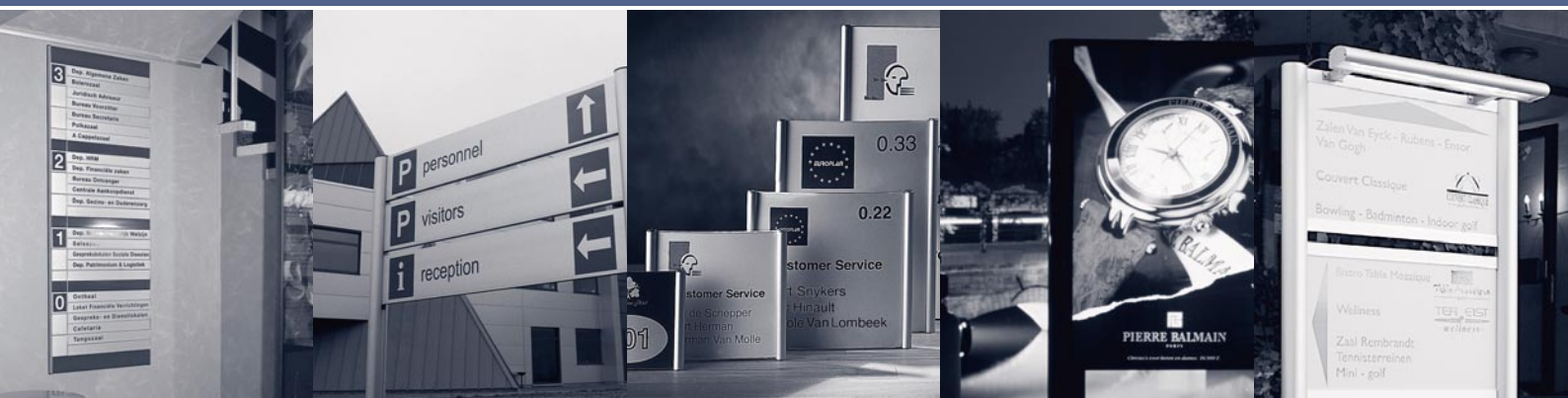
6. PLASTIC END CAPS

The plastic end caps for the "indoor system" are made of P.P.

The plastic end caps for the "outdoor system" are made of P.A.6.0.

Let show you the way

Alu show you the way



alu → **SIGN**

Alusign

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