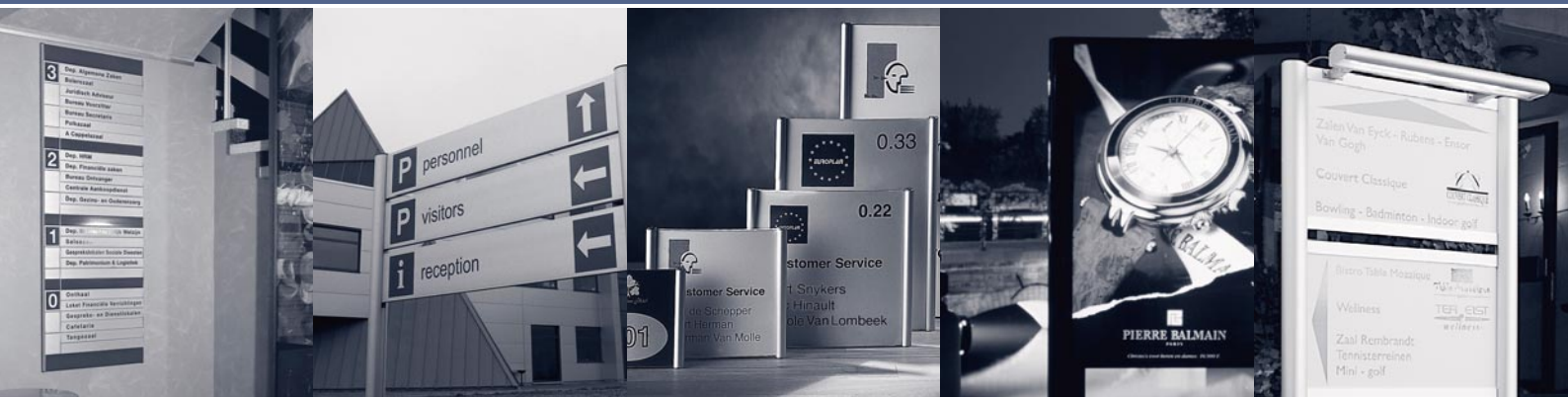


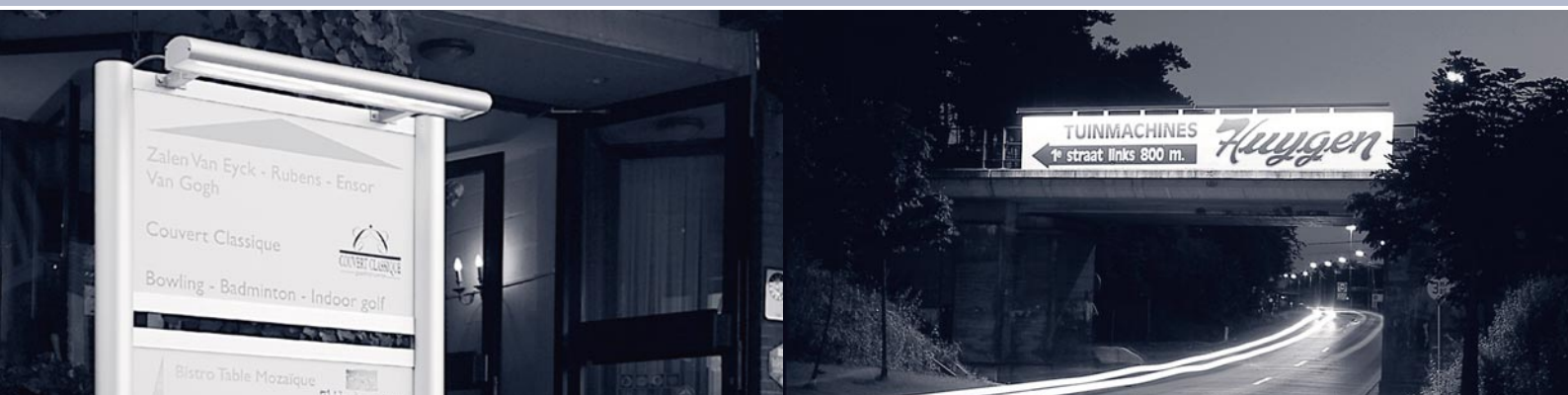
00: TECHNICAL OVERVIEW



01: INDOOR	→
02: OUTDOOR	→
03: PLATO	→
04: TOTEM	→
05: HIGHLIGHT	→

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05: HIGHLIGHT



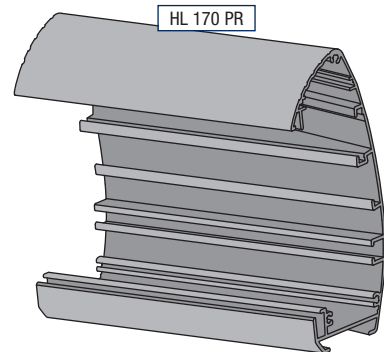
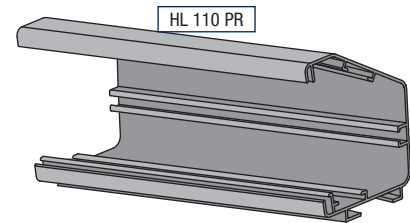
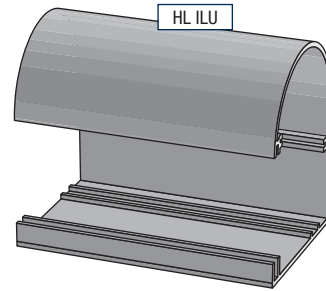
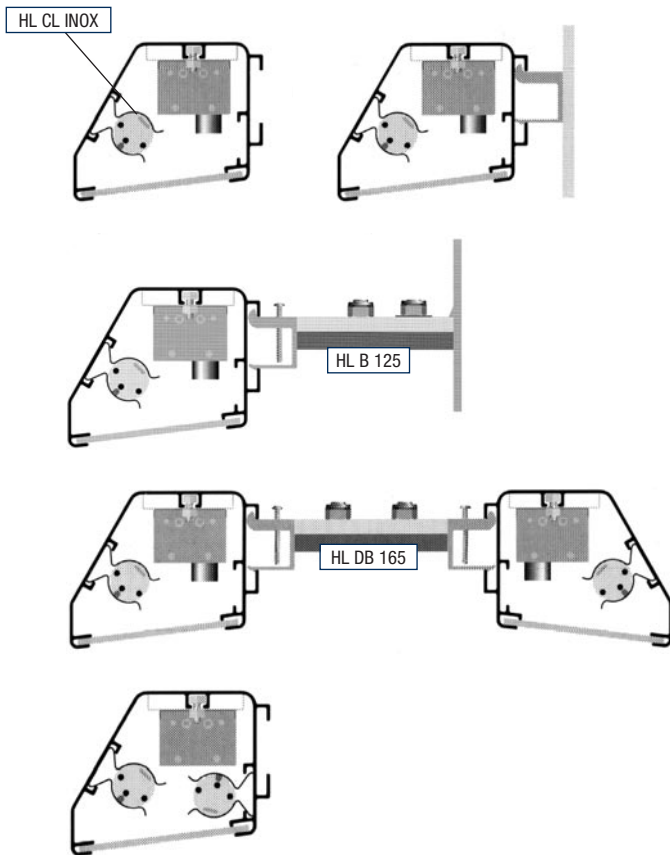
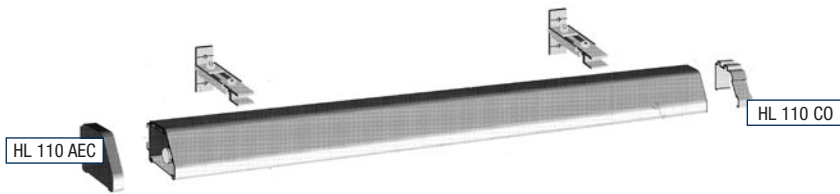
OVERVIEW ILLUMINATOR

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

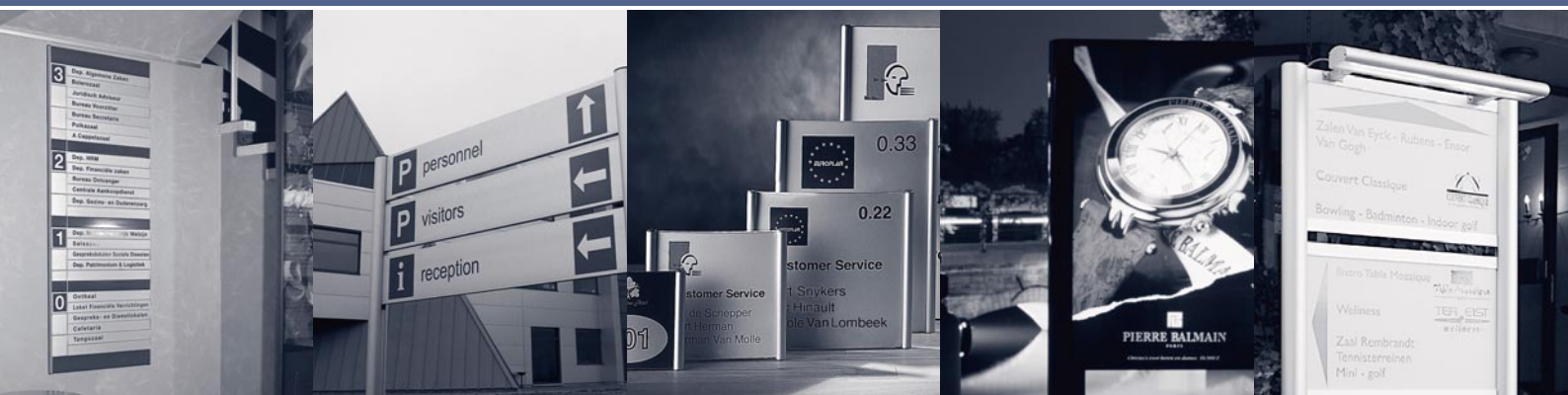
The plastic end caps for the "indoor system" are made of P.P.

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

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Alusign

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Your Alusign specialist:

Blank area for the Alusign specialist's name and contact information.