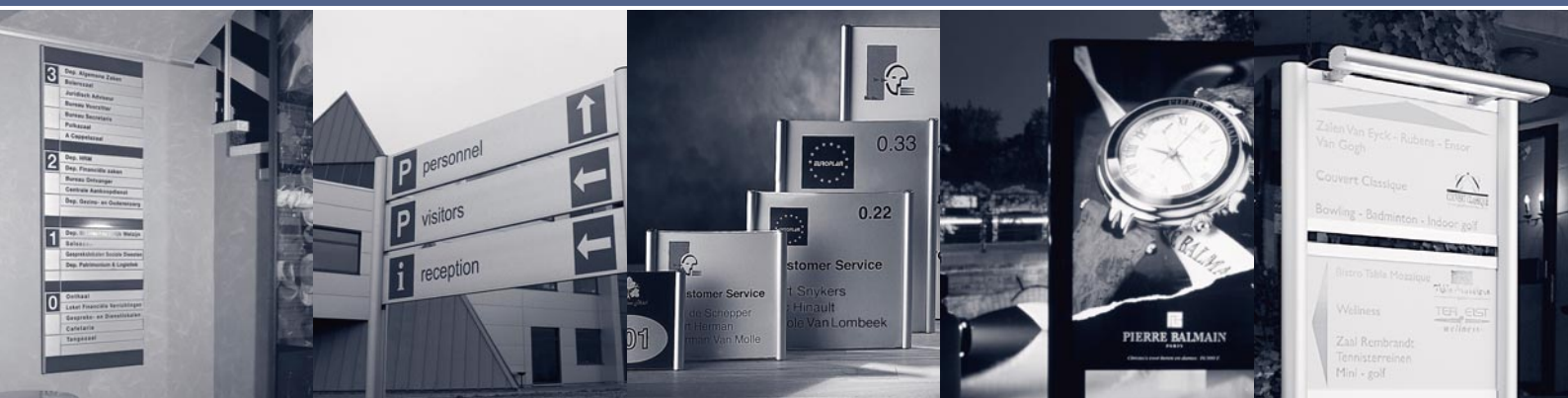


# 00: TECHNICAL OVERVIEW



01: INDOOR →

02: OUTDOOR →

03: PLATO →

04: TOTEM →

05: HIGHLIGHT →

*We show you the way*

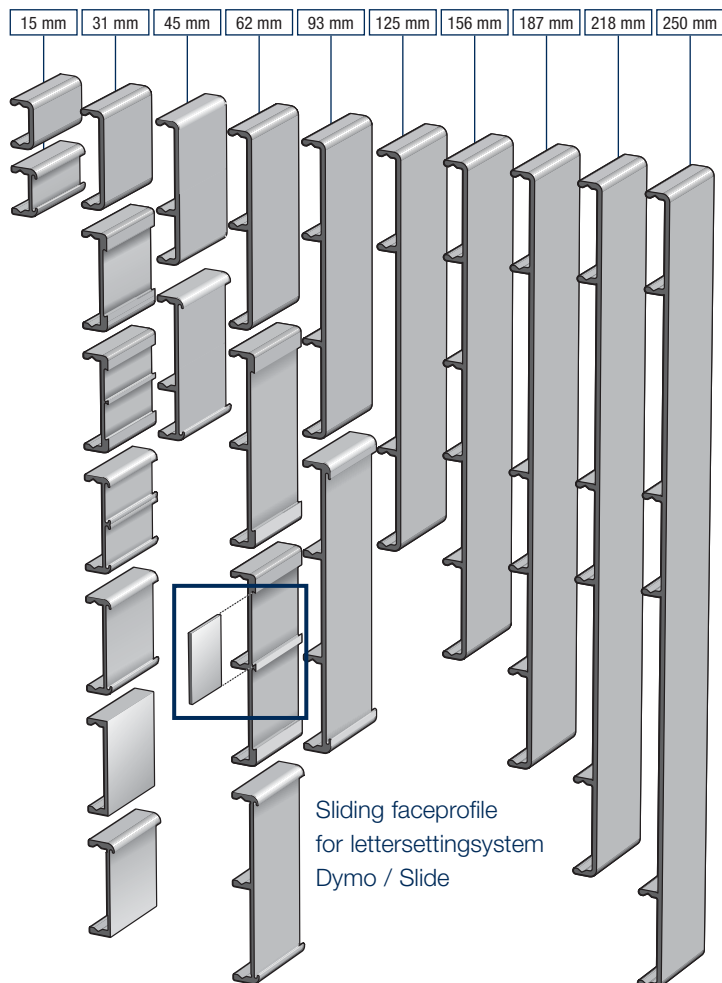
**alu** SIGN  
→

# 01:INDOOR





## OVERVIEW PROFILES



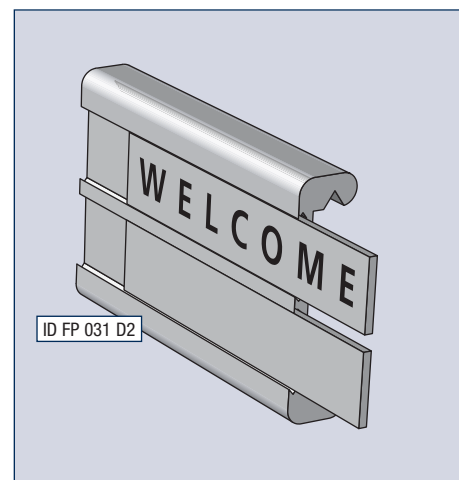
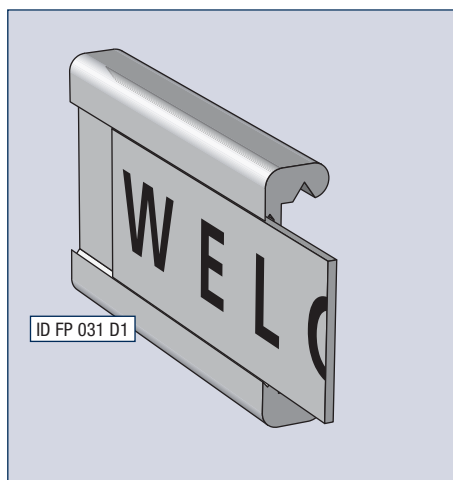
## FACEPROFILES

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.

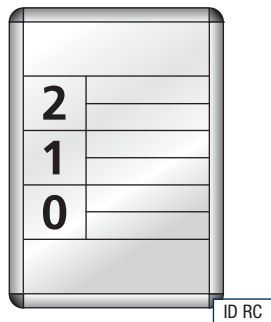
These profiles come in sizes of 15 mm (1 track), 31 mm (1 track), 31 mm (2 tracks), 45 mm (1 track), 62 mm 1 track and 62 mm 2 track and 93 mm 1 track.



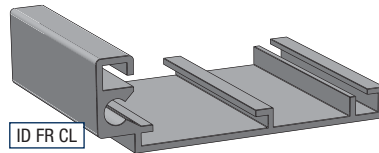
## FRAME PROFILES

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

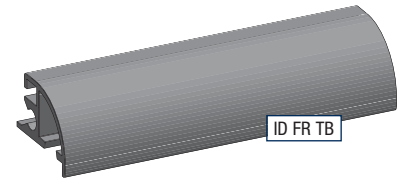
### ONE SIDED RADIUS WITH TOP AND BOTTOM PROFILE



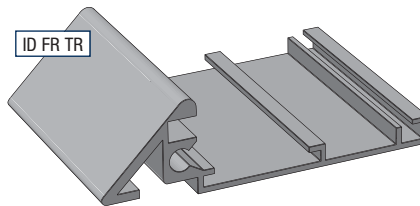
### ONE SIDED CLASSIC



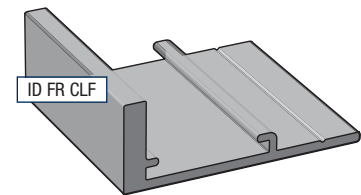
### TOP / BOTTOM RADIUS PROFILE



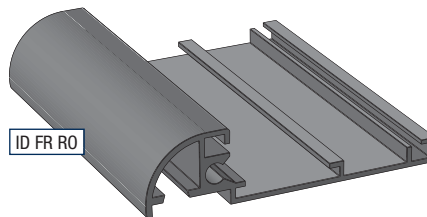
### ONE SIDED TRIANGULAR



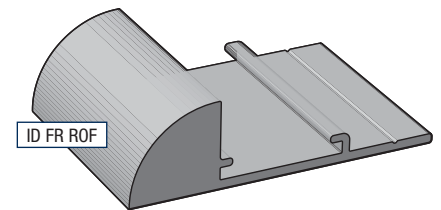
### ONE SIDED CLASSIC FULL



### ONE SIDED RADIUS

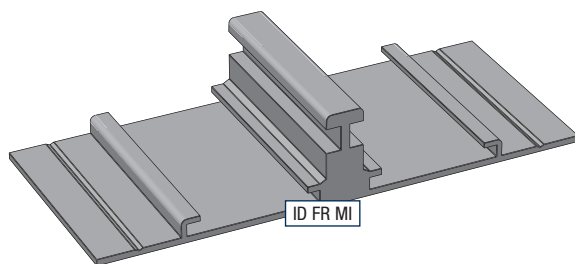


### ONE SIDED RADIUS FULL



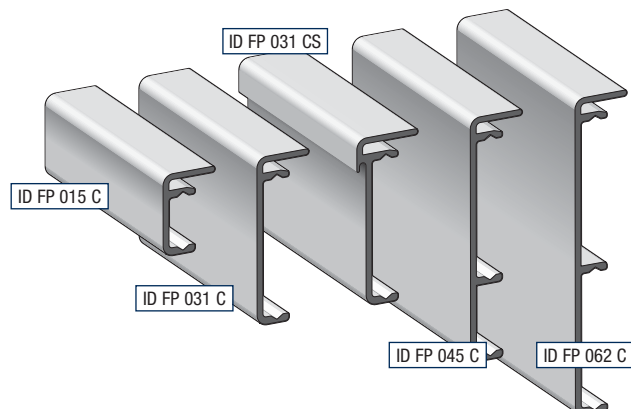
## MIDDLE PROFILE

CODE	TYPE
ID FR MI	Middle profile



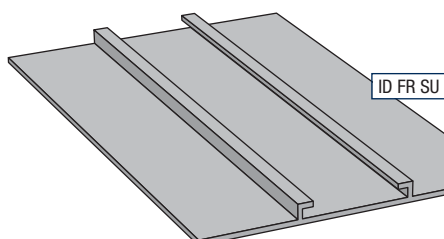
## COVER PROFILES

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.

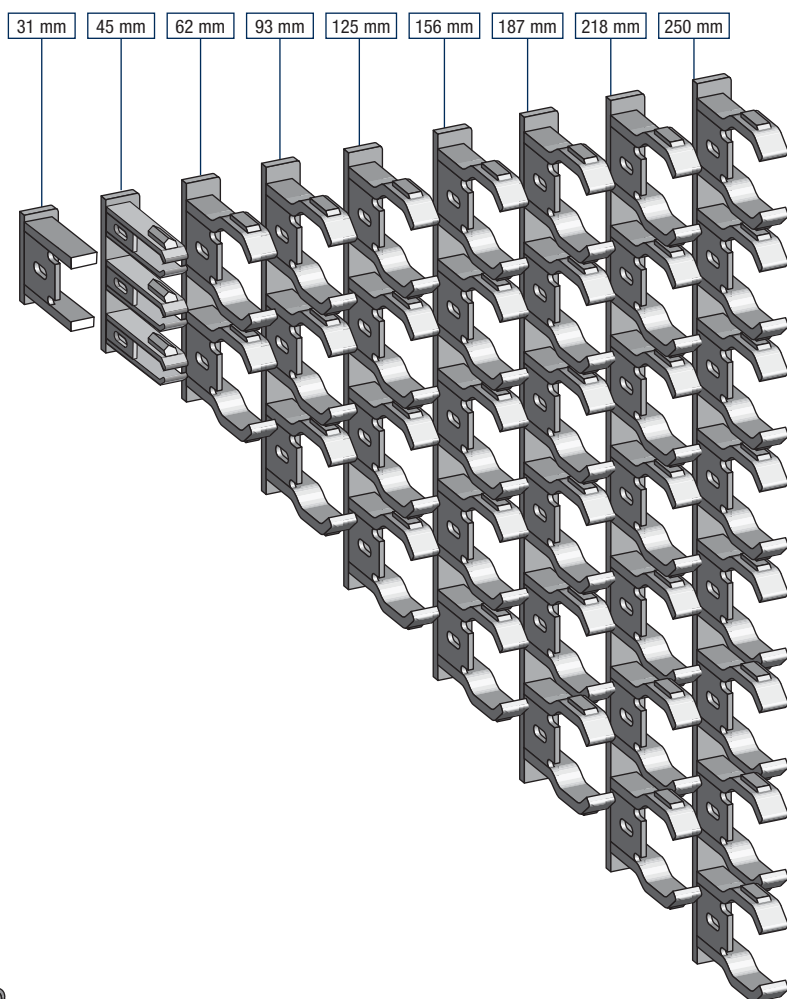
Indoor information at a glance



## OVERVIEW ACCESSORIES

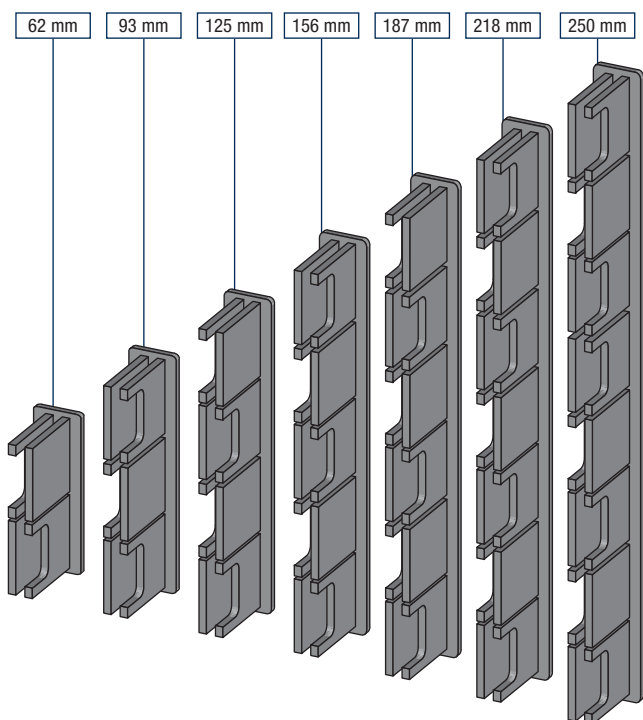
### PLASTIC SINGLE ENDCAPS

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



### PLASTIC DOUBLE ENDCAPS

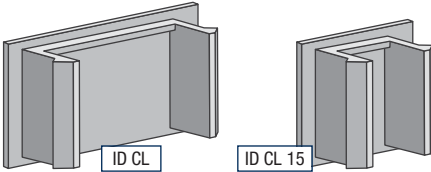
CODE	TYPE	SIZE
ID PDE 62	Double endcaps	62 mm
ID PDE 93	Double endcaps	93 mm
ID PDE 125	Double endcaps	125 mm
ID PDE 156	Double endcaps	156 mm
ID PDE 187	Double endcaps	187 mm
ID PDE 218	Double endcaps	218 mm
ID PDE 250	Double endcaps	250 mm



## PLASTIC ACCESSORIES

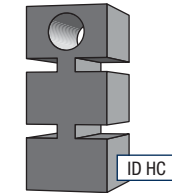
### ■ PLASTIC CLIPS

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

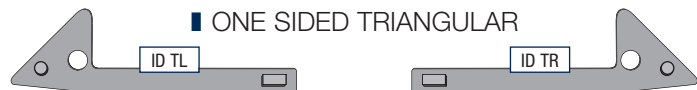
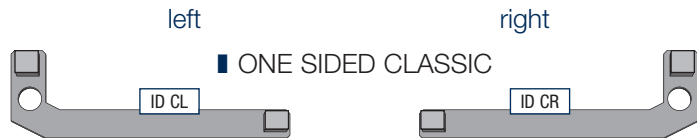
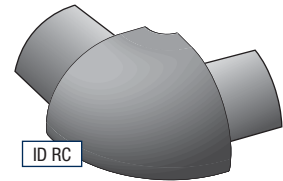


### ■ HANGING AND COMBINATION CLIPS

CODE	TYPE
------	------

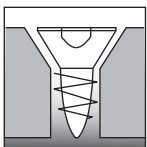
### ■ CORNER CLIP RADIUS

CODE	TYPE
ID RC	Corner radius



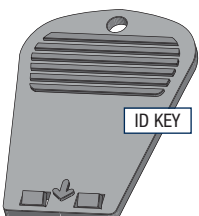
### ■ SCREWS

CODE	TYPE
ID TBS	Top and bottom screw type TORX



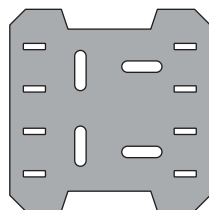
The screws are countersunk assembled

Key to replace assembled faceprofiles

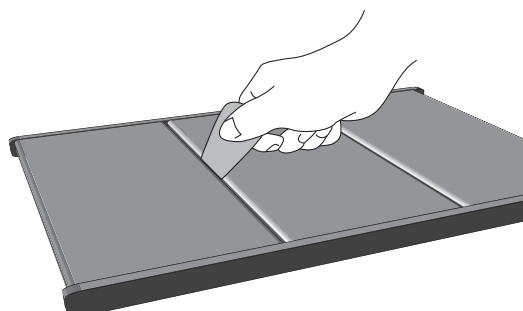


### ■ GROUNDPLATE

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

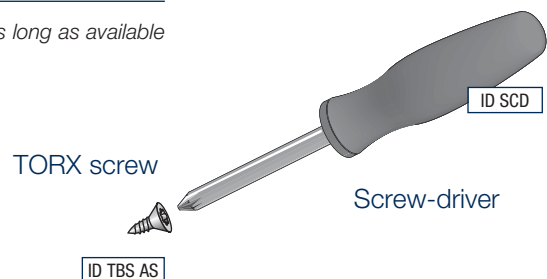


\* As long as available



### ■ SCREW-DRIVER

CODE	TYPE
ID SCD	TORX screw driver



### ■ KEY

CODE	TYPE
ID KEY	Alusign key

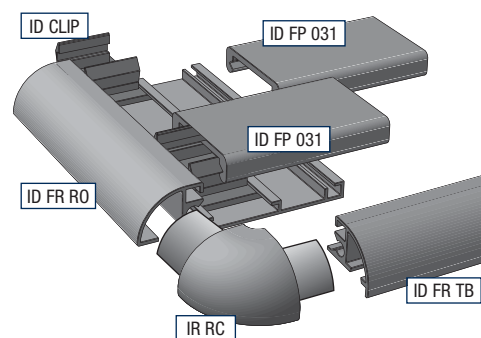
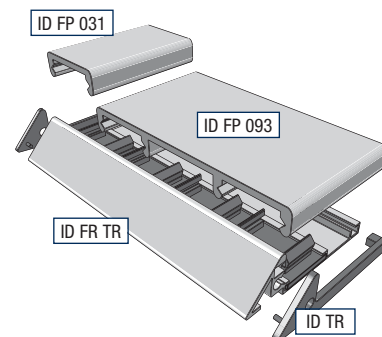
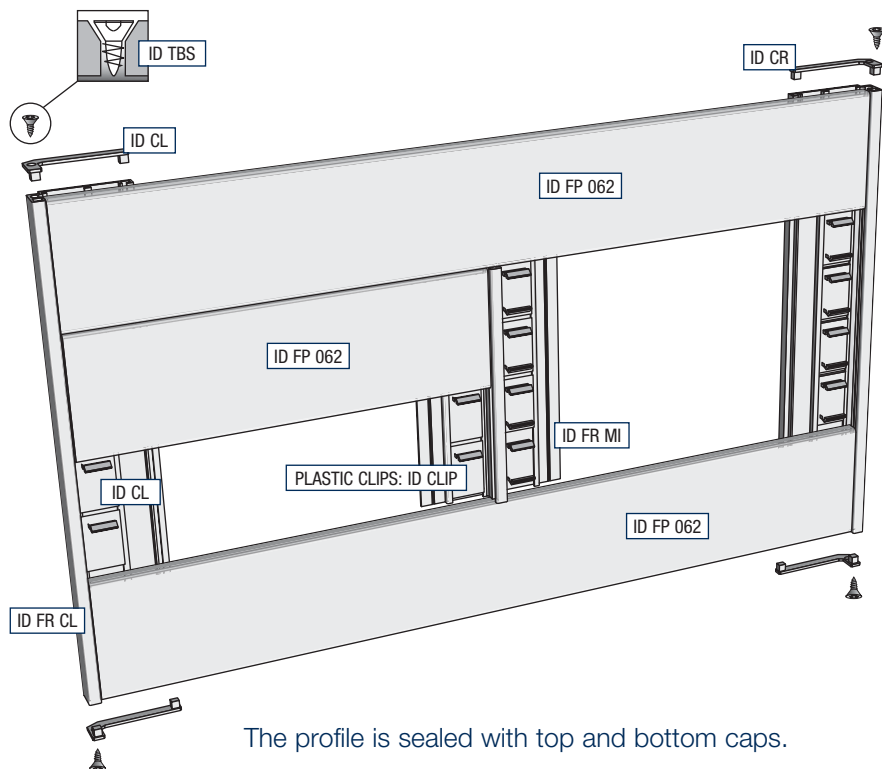
Profiles in mill finish, anodised and RAL.  
Plastic accessories in black and grey. White finish, as long as available.





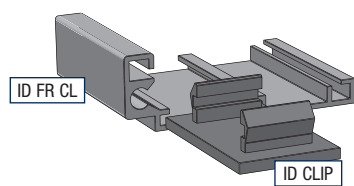
## CONSTRUCTION EXAMPLES

### INFORMATION AND OVERVIEW BOARDS

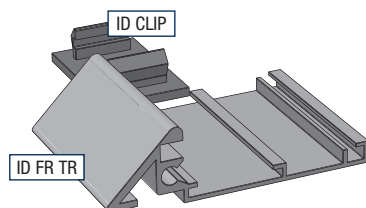


### FRAME PROFILES

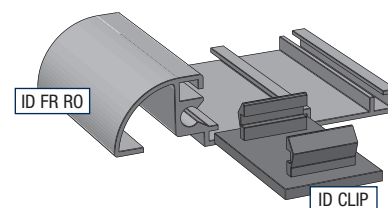
#### ONE SIDED CLASSIC



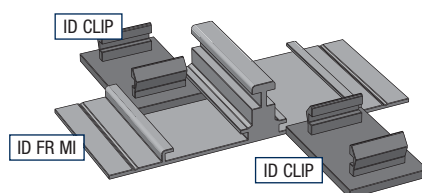
#### ONE SIDED TRIANGULAR



#### ONE SIDED RADIUS

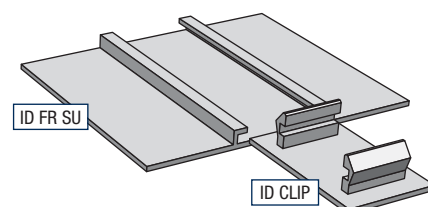


### MIDDLE PROFILE



### SUPPORT LIST

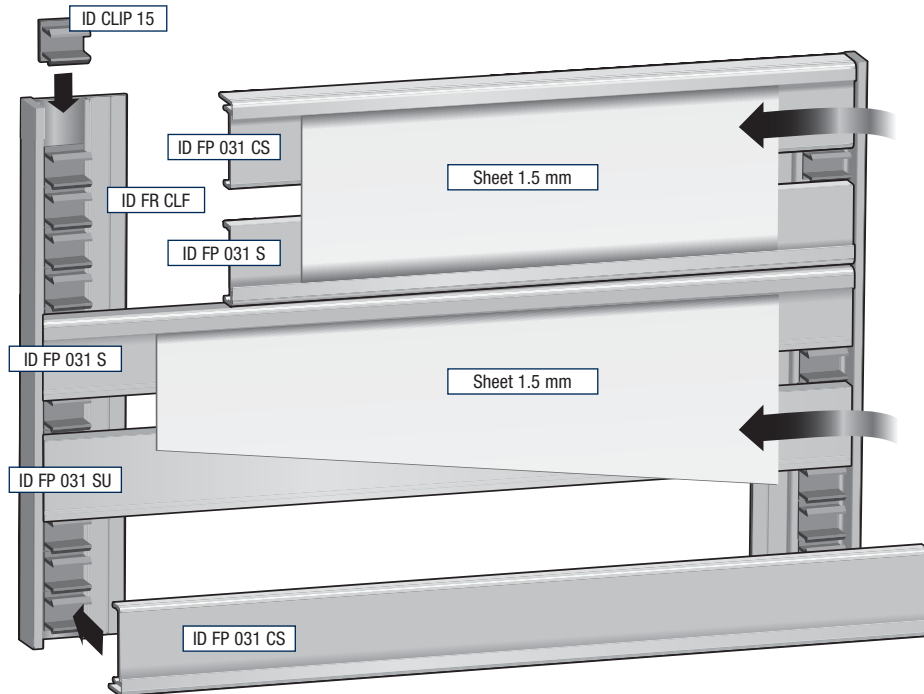
The supporting profile is used for supporting large panels, viz. for lengths of over 1 meter and for the erection of certain structures.



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.

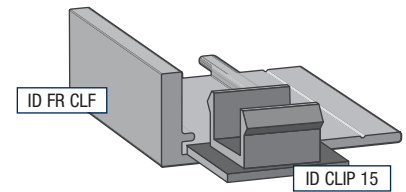
## CONSTRUCTION WITH SLIDER PROFILES



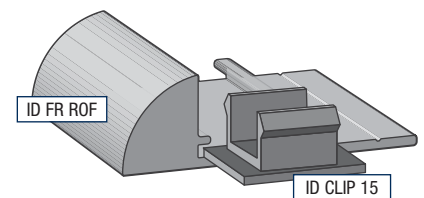
The slider profiles are used to make overview boards with a sheet of 1.5 mm. The support 31 mm gives stability for surfaces with a larger width.

## FULL FRAME PROFILES

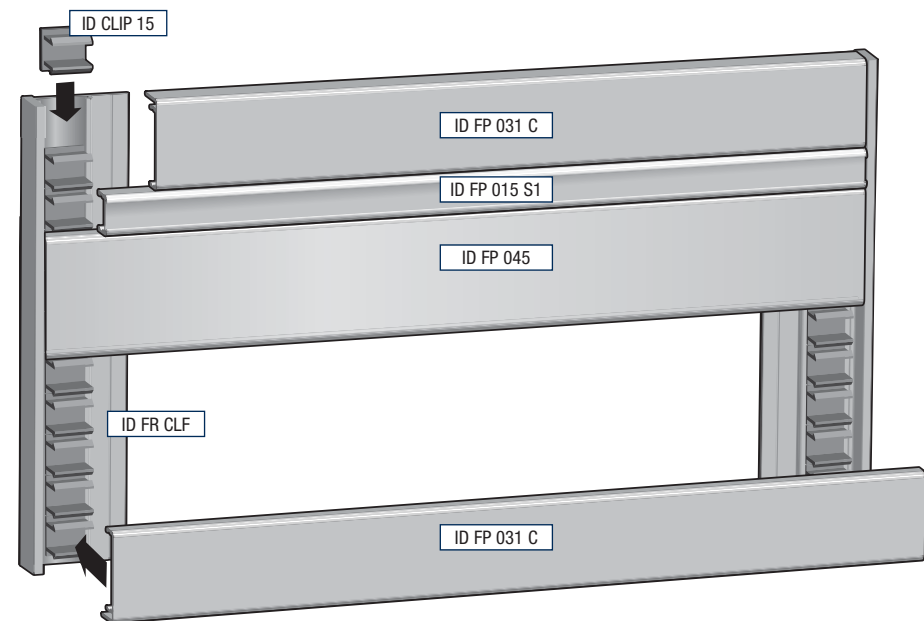
### ■ ONE SIDED CLASSIC FULL



### ■ ONE SIDED RADIUS FULL



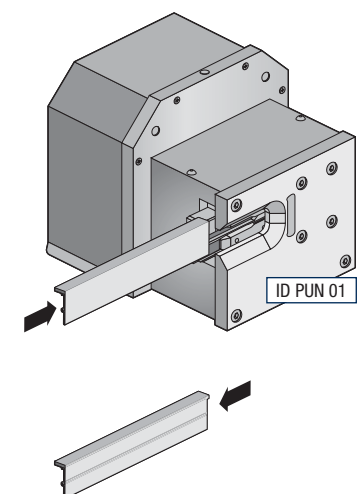
## CONSTRUCTION WITH CLASSIC FULL PROFILE



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

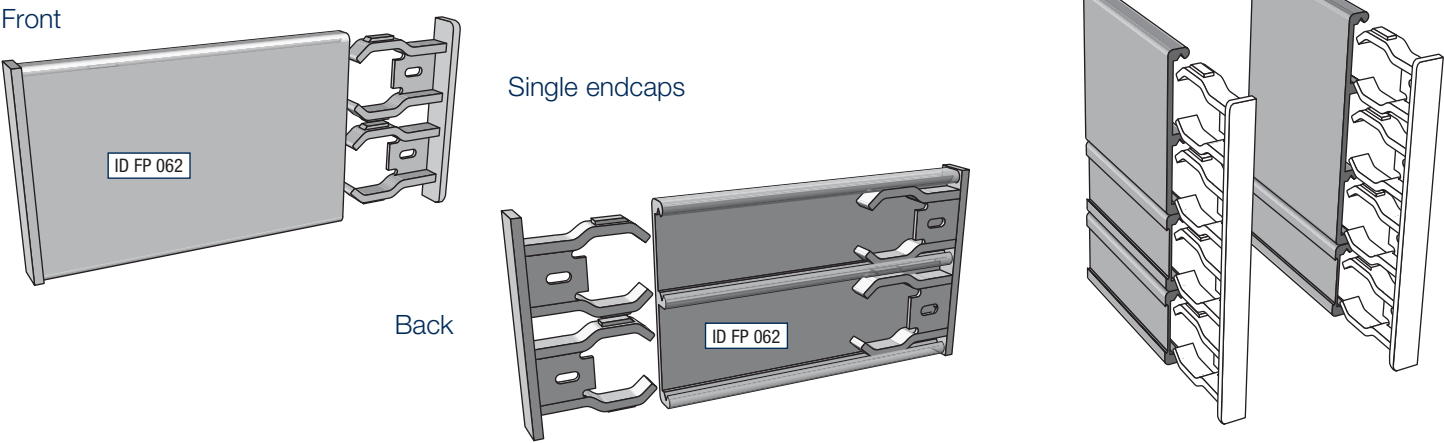
## PUNCHING DIE

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.

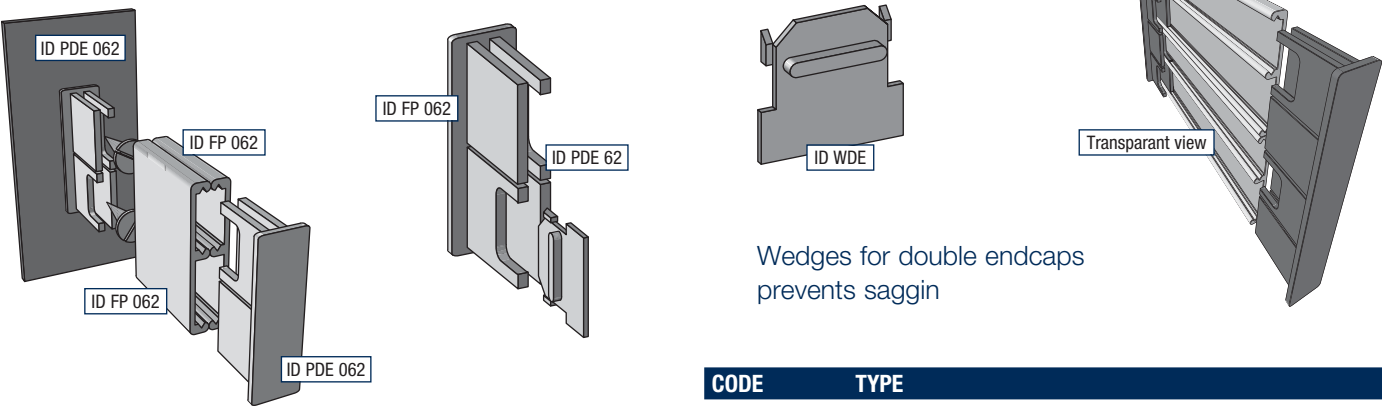




WALL MOUNTING

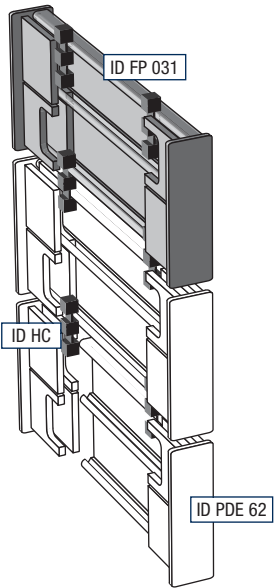


LATERAL WALL MOUNTING



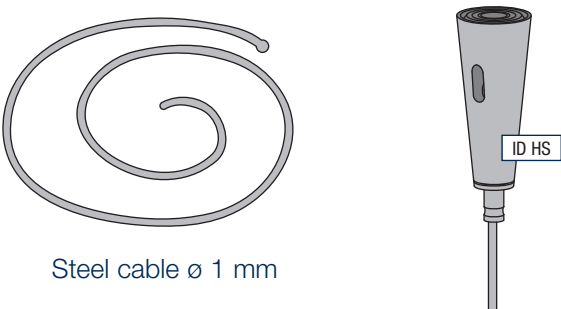
CODE	TYPE
ID WDE	Wedges for double endcaps

HANGING SYSTEM



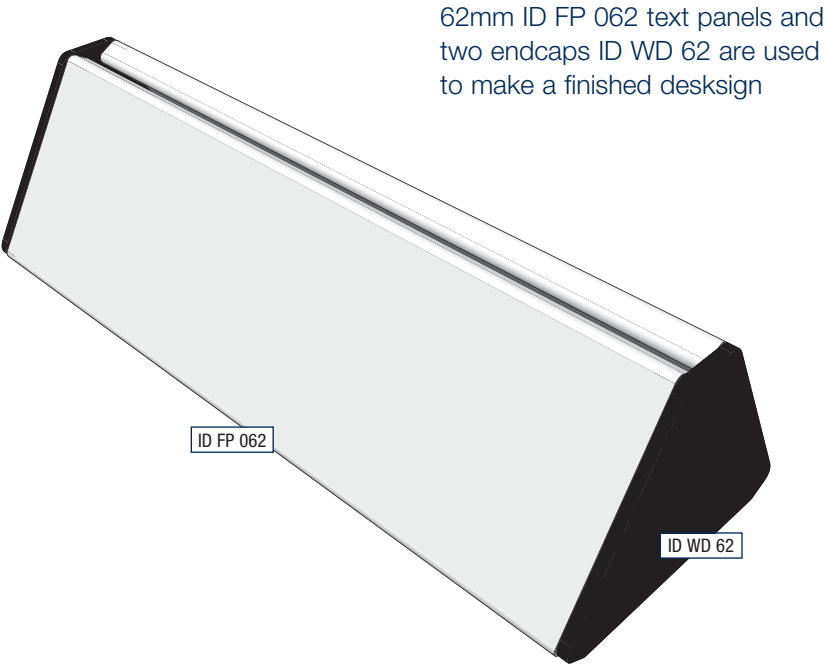
ACCESSORIES HANGING SYSTEM

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

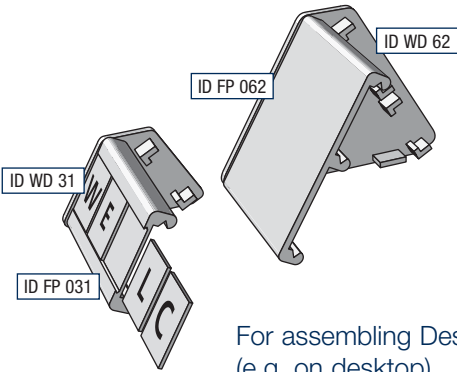


Profiles in mill finish, anodised and RAL.  
Plastic accessories in black and grey. White finish, as long as available.

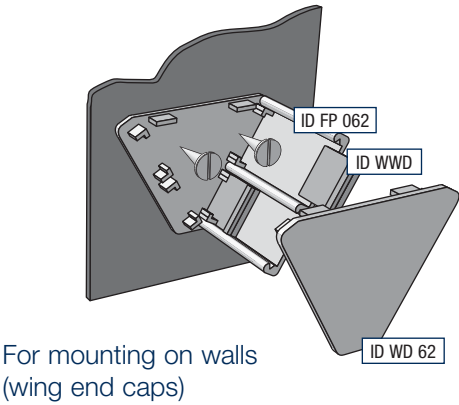
CONSTRUCTION EXAMPLE WING DESK



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

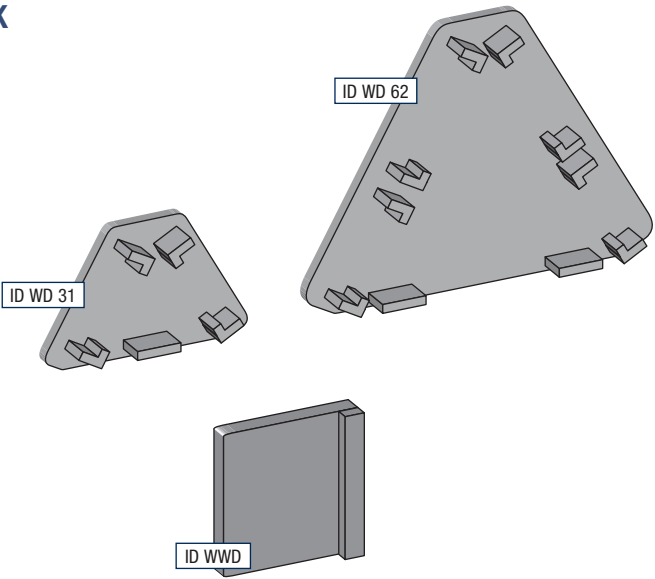
■ WING DESK ENDCAPS

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

## 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/dm<sup>2</sup>. 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.

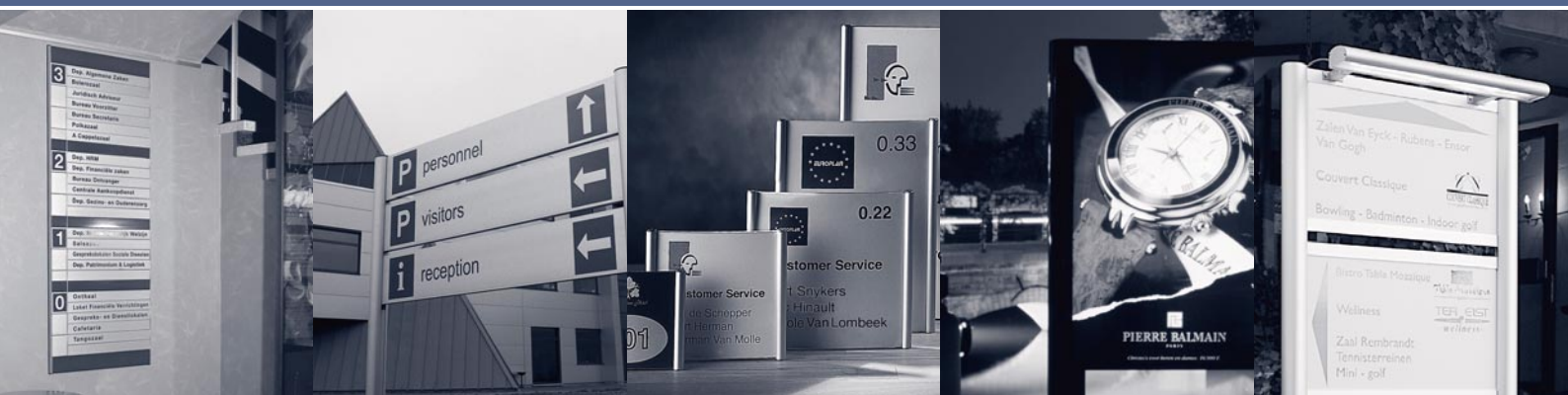
### 6. PLASTIC END CAPS

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*

Let show you the way



**alu** → **SIGN**

**Alusign**

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Your Alusign specialist: