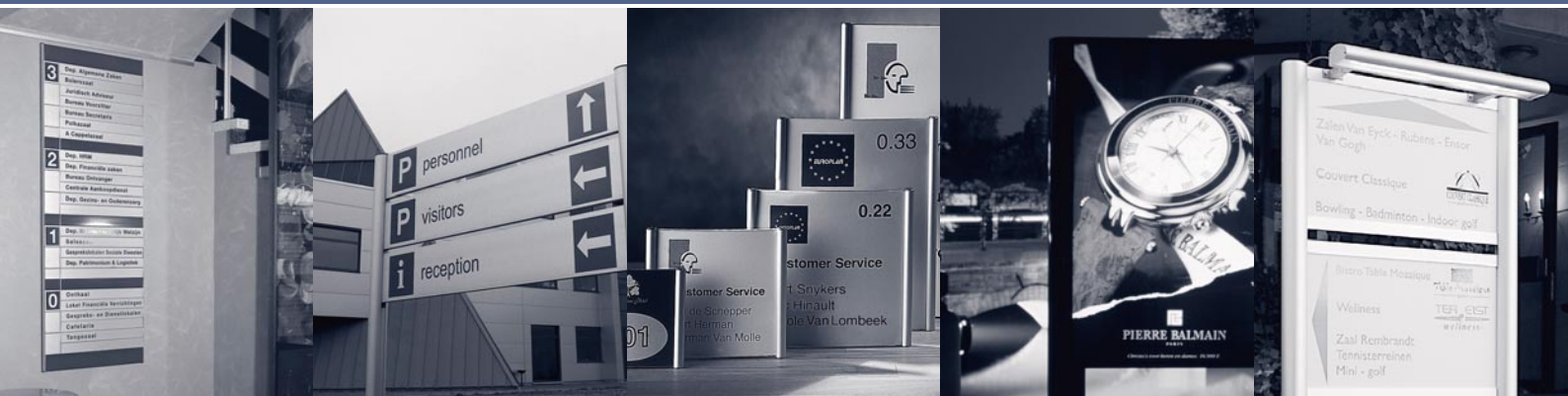


# 00: TECHNICAL OVERVIEW



01: INDOOR →

02: OUTDOOR →

03: PLATO →

04: TOTEM →

05: HIGHLIGHT →

*We show you the way*

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## 02:OUTDOOR

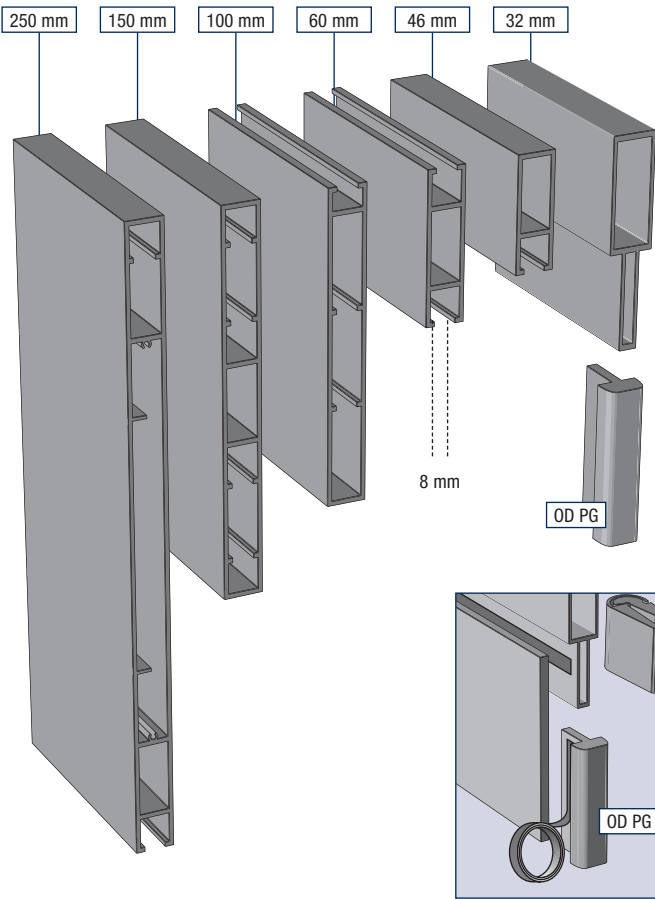
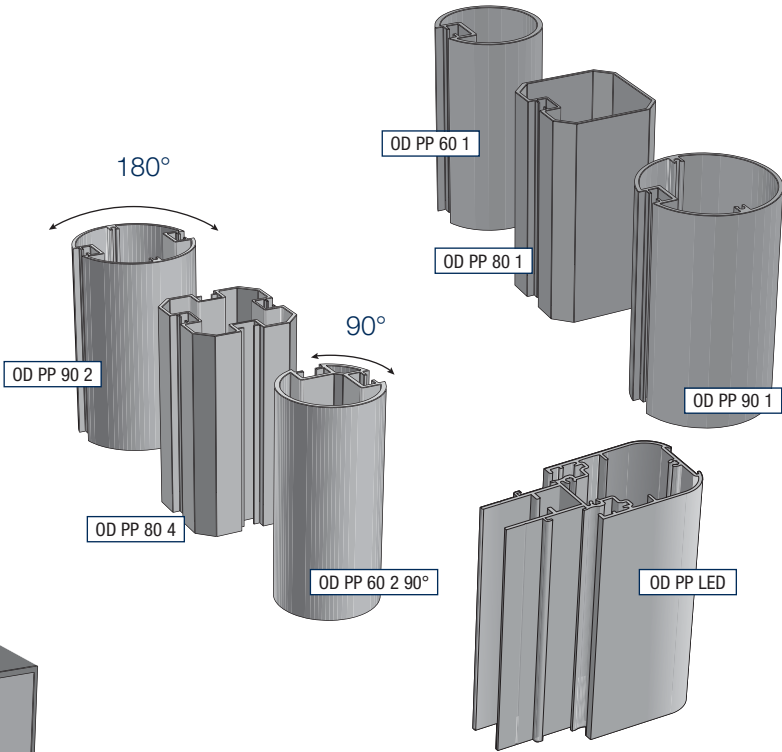


## OVERVIEW PROFILES

### 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

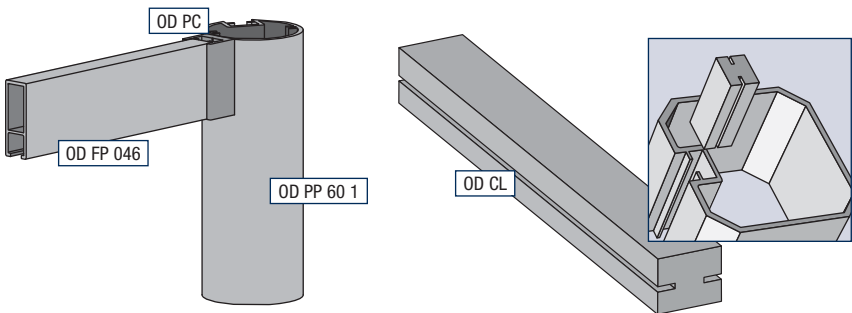
### COVER LIST

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.

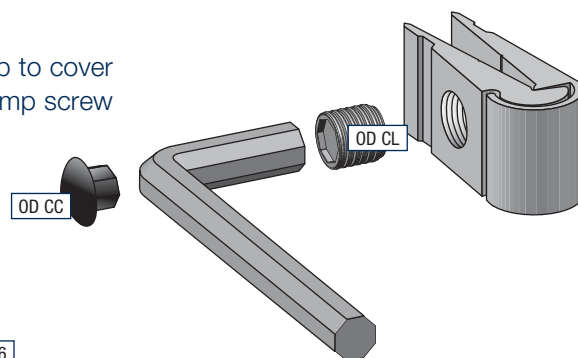
Covers all your outdoor needs



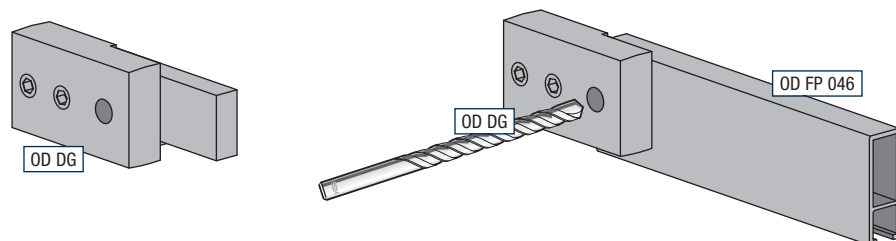
## OVERVIEW ACCESSORIES

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

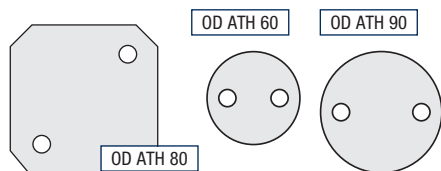


### DRILL GUIDE



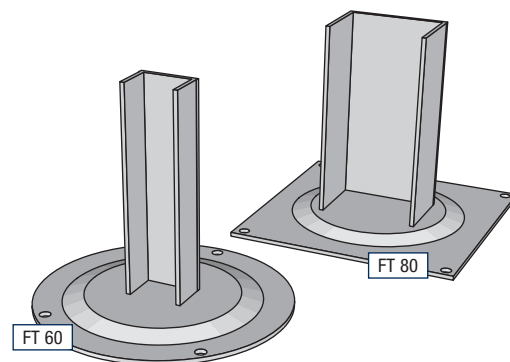
### TOP HAT CAPS ALU

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



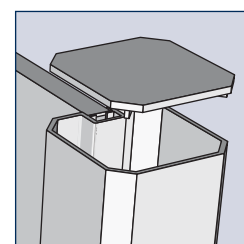
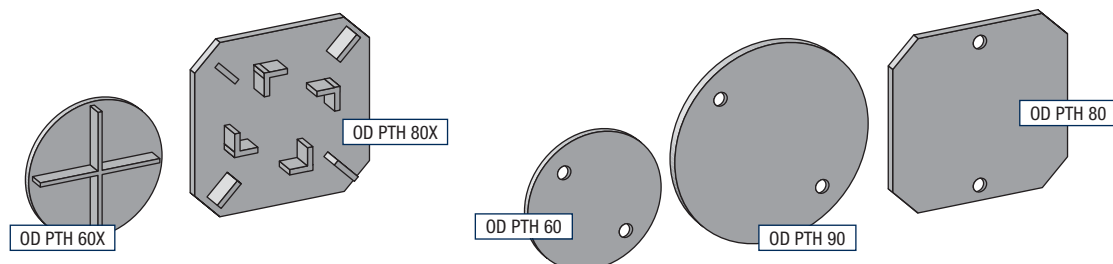
### FOOT

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



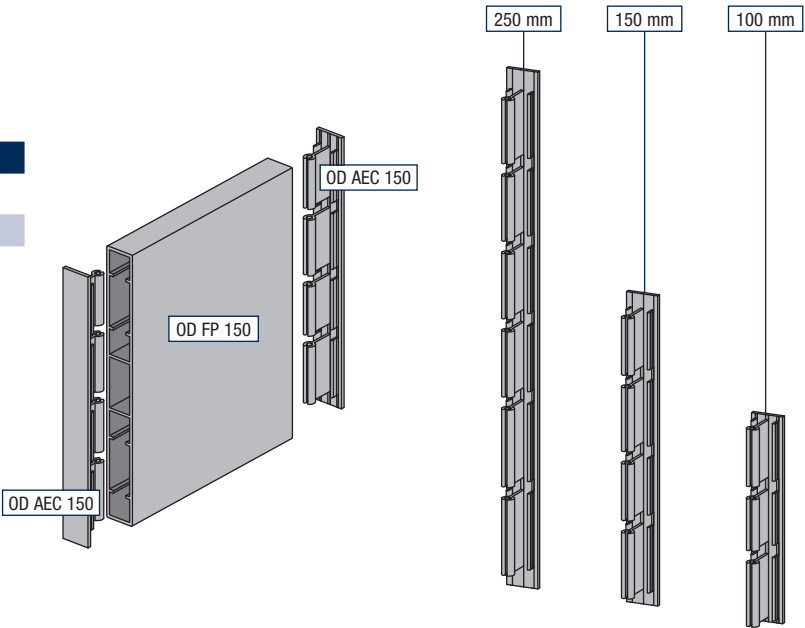
Profiles in mill finish, anodised and RAL.

Plastic accessories in black and grey. White finish, as long as available.

OVERVIEW ACCESSORIES

ALU END CAPS

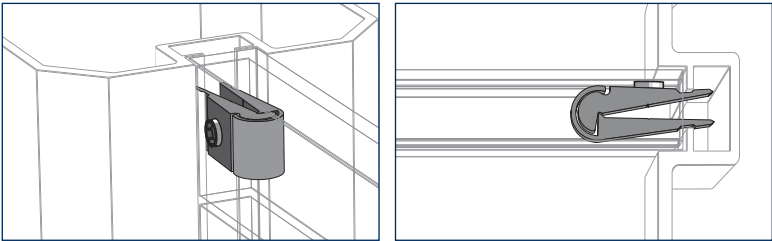
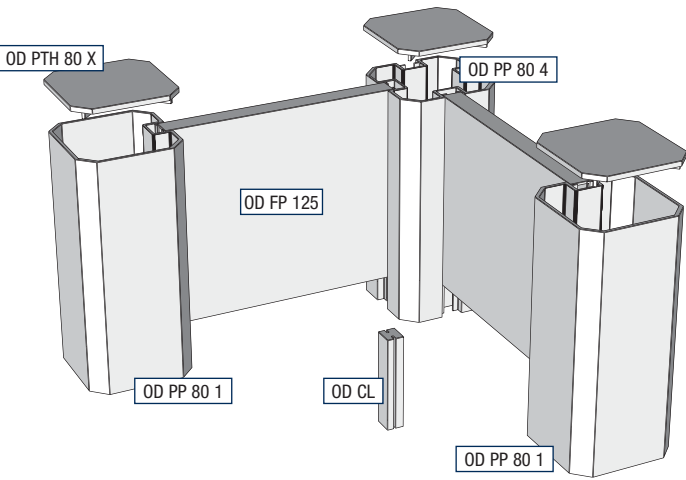
CODE	TYPE	SIZE
OD AEC 100	Alu end cap for face panel	100 mm
OD AEC 150	Alu end cap for face panel	150 mm
OD AEC 250	Alu end cap for face panel	250 mm



CONSTRUCTION EXAMPLES

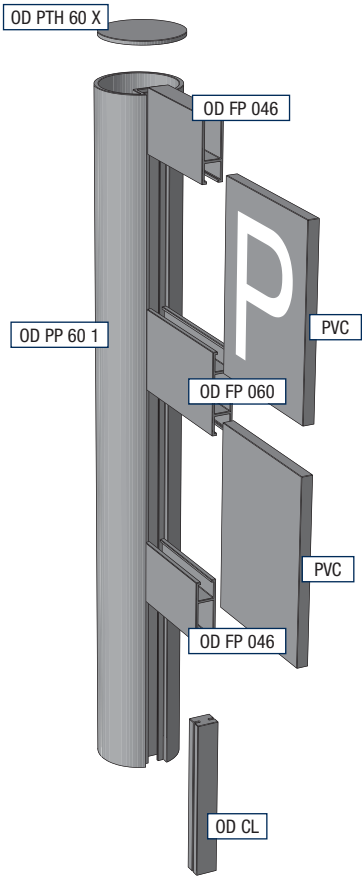
OUTDOOR SYSTEM

SQUARE 80 X 80 MM



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

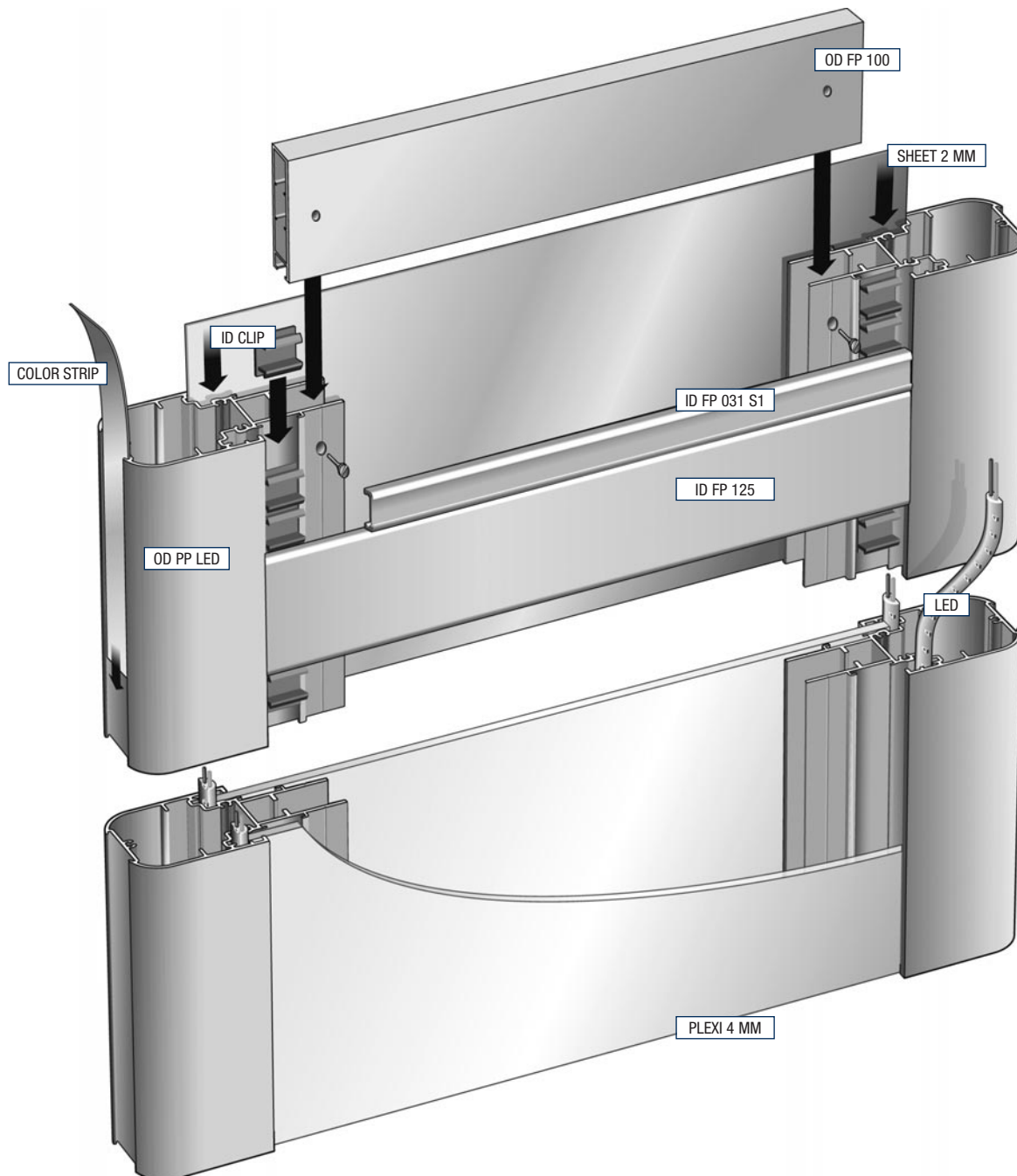
ROUND Ø 60 MM



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.

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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*

## 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

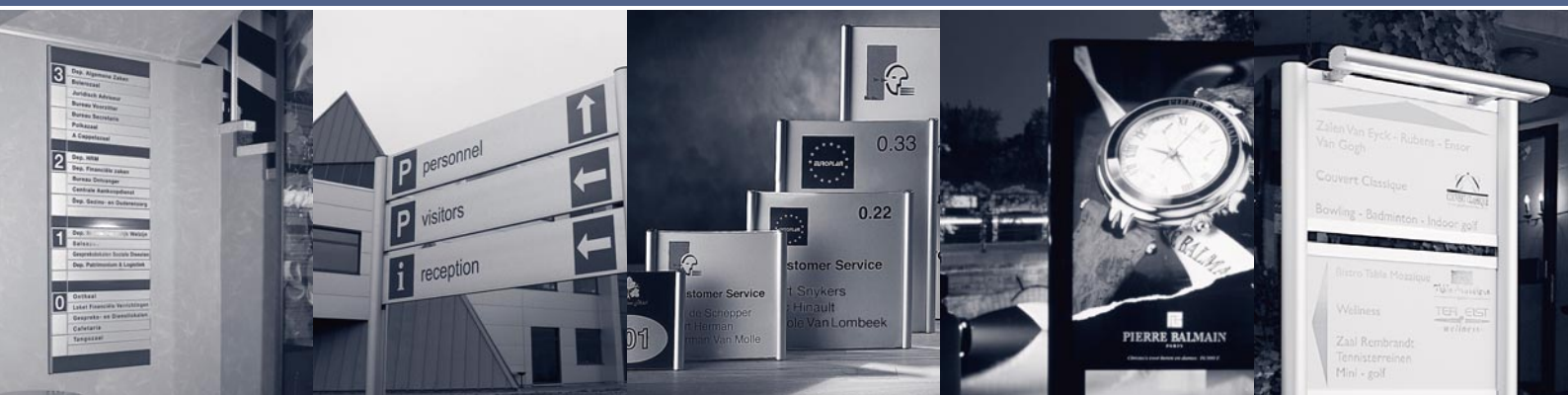
The plastic end caps for the "indoor system" are made of P.P.

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



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**Alusign**

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Your Alusign specialist: