00: TECHNICAL OVERVIEW

We show you the way

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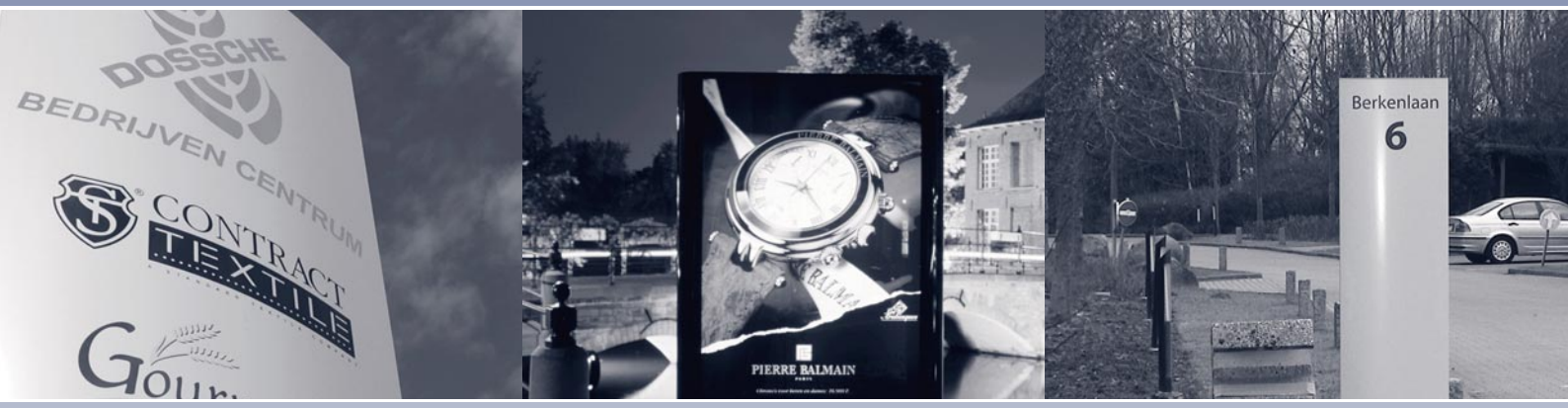
04: TOTEM



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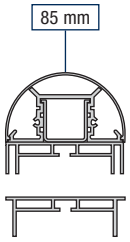
GLOBE

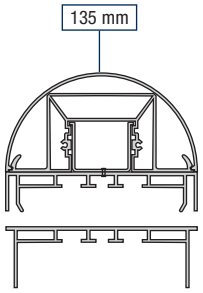
Versions

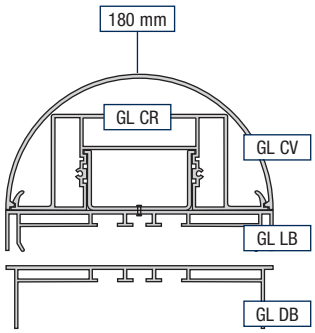
You can choose between the Lightbox sections and the Di-box sections. Both types are available in widths of 85, 135 and 180 mm.

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.





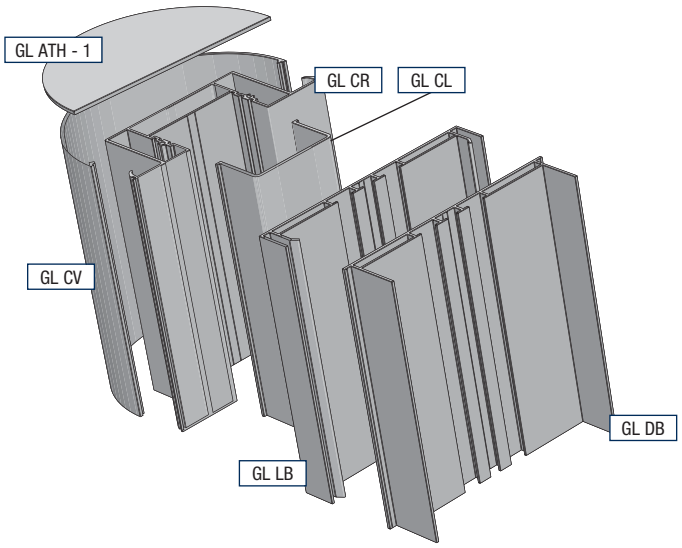


CODE	TYPE	MAXIMUM THICKNESS SHEET	MAXIMUM THICKNESS PLEXI
GL CV 085	Globe post profile 85 cover		
GL CR 085	Globe post profile 85 core		
GL CL 085	Globe post profile 85 clip		
GL LB 085	Globe light-box profile 85		5 mm
GL DB 085	Globe di-box profile 85	3 mm	
GL ATH 085-1	Globe alu top hat 85-1		
GL CV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

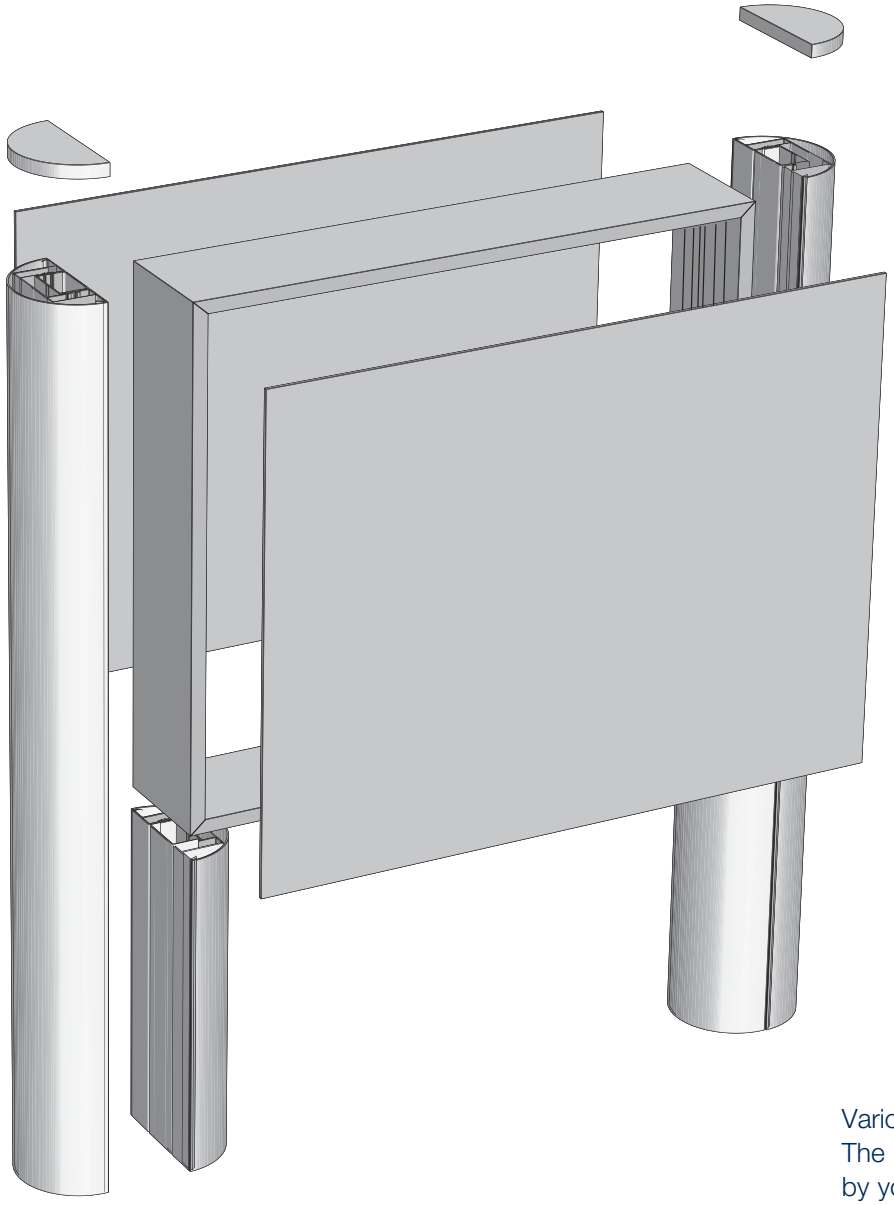
On the technical side

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.

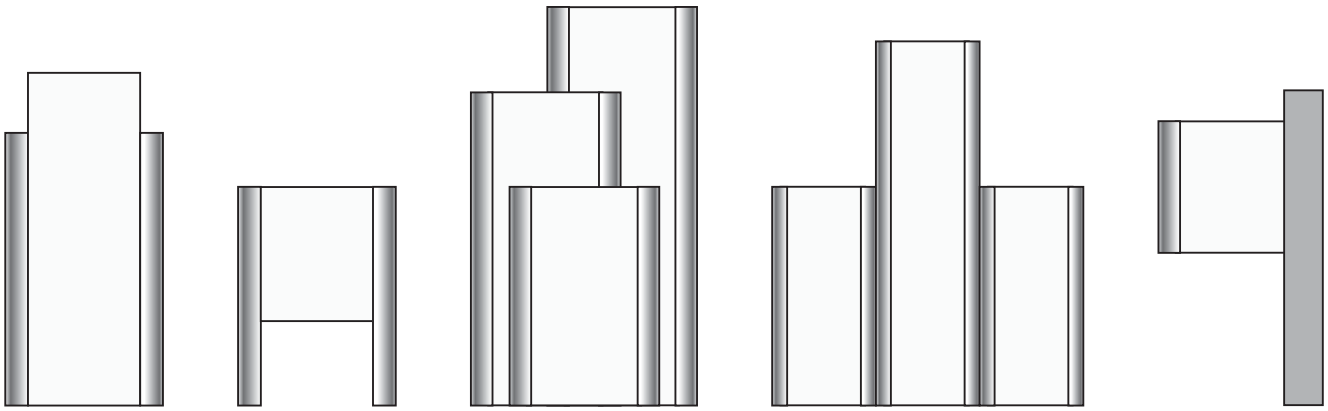


Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

CONSTRUCTION EXAMPLE GLOBE



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

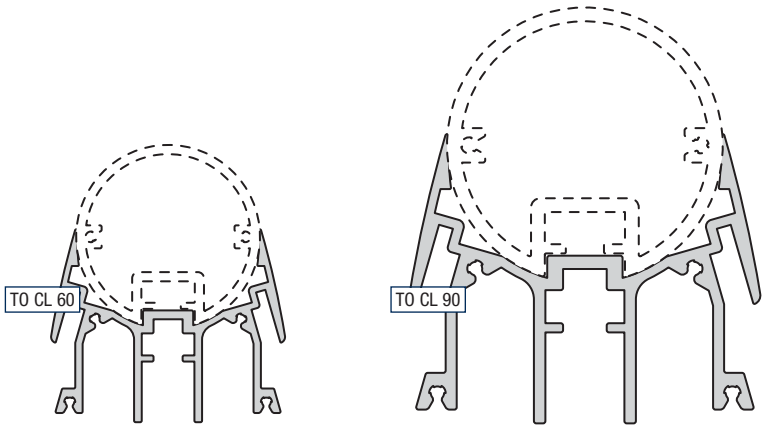


Profiles in mill finish, anodised and RAL.
Plastic accessories in black and grey. White finish, as long as available.

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

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

Puts you on the map

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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