

Customer Information Sheet

Pre-finished Aluminium Products

Introduction

Many aluminium products that are used in the building industry have a finish applied that both protects the original "mill finish" and enhances the finished look. This data sheet provides information on colour choice, care and maintenance, precautions and limitations and transportation of CS Cavity Sliders product that may be powder coated or anodised.

Affected CS Products

CavitySliders with aluminium jambs
WardrobeSliders with aluminium jambs
TrackSystems

Pre-HungJambs - aluminium jambs
DoorLeaves: NewYorker, AluTec, AluMax, MirrorLite
CaviLock handles (CL200, CL400)

Powder coating

What is powder coating?

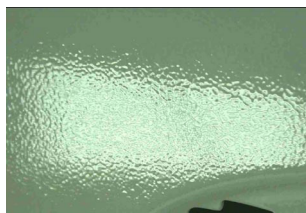
Powder coating is a type of finish that is applied as a free-flowing, dry powder. The coating is typically applied electrostatically and is then cured under heat to allow it to flow and form a "skin." Once cured, the powder creates a hard, durable finish.

Colour choice and finish

Powder coating enables you to choose from a wide range of colours. CS Cavity Sliders recommends the Dulux Powder Coat colour range. When deciding on a colour option, the name and associated code number must be provided. If a colour is supplied outside of this chart a colour sample, name and code must be provided to a CS Cavity Sliders representative to obtain a matching colour option and price.

Things to be aware of:

- Light colours will tend to retain their appearance better than dark or bright colours.
- Surface finishes will vary according to the shape of aluminium the powder is applied to.
- Aluminium sheet and extrusions may have an orange peel look to the surface finish. This is considered acceptable as a part of industry standards.
- Metallic colours also require a second protective clear coat.
- Finished product may have minor surface scratches and abrasions which are accepted as a part of the application process.



↑ A close up example of 'orange peel look'

When judging colour consistency and integrity of finish, the accepted industry standard is inspection from a distance of two metres.

Graffiti removal

Anti graffiti powder coatings require specific cleaning procedures that must be adhered to. Solvents recommended for graffiti removal are Dulon AAA thinners.

Apply the solvent with a soft clean rag. Allow the solvent to moisten the graffiti marks for approximately 30 seconds (but no longer than 60 seconds) before wiping the surface clean.

Then, using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove any remaining thinners. Rinse after cleaning with fresh water to remove any remaining detergent.

Please note: where solvents have been used to remove graffiti, you may notice a dull finish to the affected area.

Advantages of powder coating

- ▮ Wide choice of colours available.
- ▮ Powder coating is a tough, durable finish.
- ▮ Minor scratches may be repaired. Aerosol and dab stick applicators for unintentional chips are available from your supplier in most stock colors. It is recommended that the use of these products be restricted to minor areas.

Disadvantages of powder coating

- ▮ Over the long term, powder coat colours will slowly degrade.

Anodising

What is anodising?

Anodising is an electrochemical process that creates a protective layer on the surface of aluminium profiles. The metallic finish that is created does not peel, chip or flake and achieves good protection against heat, moisture, sunlight and atmospheric corrosion.

Colour choice and finish

Natural Anodised (also known as Matt Natural or Silver) is the most common colour, although black and bronze are also available.

CS Cavity Sliders will not anodise our **flush aluminium door** range due to imperfections in the aluminium sheet being magnified by the anodising process.

Things to be aware of:

- Variability of colour
- Visible aluminium grain
- Extrusion die lines

These are all common features that are a part of the anodising process and are not defects in the surface finish. The standard layer thickness is 12 microns but in exposed coastal or industrial environments thickness options of 20 and 24 microns are advised.

When judging colour consistency and integrity of finish, the accepted industry standard is inspection from a distance of two metres.

General Information

Joins in flush aluminium doors

Some flush skinned aluminium doors will require a join where stock sheets will not cover the entire door frame. The standard detail for this join is to bring the sheets to within 1 x rivet stem distance apart (1.5mm) to create a neat negative detail that gives a consistent finish. This join will typically run vertically up the door in the centre.

Any door requested over 6000mm x 2180mm will require a join due to the maximum size of sheet that we can supply. A CAD drawing will be supplied for any door over this size for customer sign off as a part of order acceptance.

Transportation

CS Cavity Sliders provides a damage warning on all easily damaged product. This states that:

- We have a Photo Reference of the door prior to it leaving our production facility.
- Product must be handled very carefully during transit
- It is the responsibility of the customer to unwrap and check the condition of the door once received.

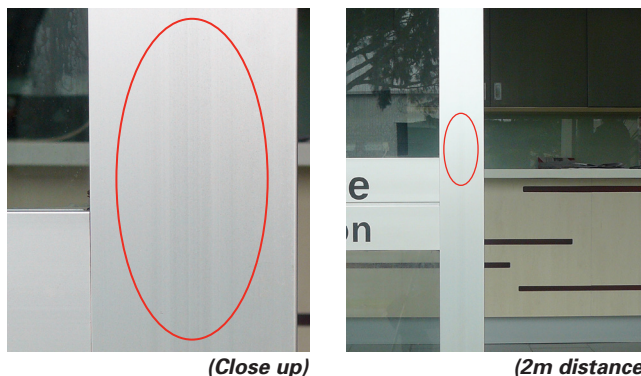
Once a product arrives at the customer destination, it is then their responsibility to check that the product is inspected and the delivery docket is signed before the transport company driver leaves the site. CS Cavity Sliders will accept no responsibility for damage to a product once it has been delivered and the delivery docket signed.

Advantages of anodising

- ▮ Anodising enhances aluminium's appearance.
- ▮ Metallic finish does not peel, chip or flake.
- ▮ Provides good protection against heat, moisture, sunlight and atmospheric corrosion.
- ▮ Recommended for use in coastal areas (at 24 microns).

Disadvantages of anodising

- ▮ Limited colour range
- ▮ Although anodised finishes are very tough, once scratched they are virtually impossible to repair.



↑ Photos of die lines that may be visible with an anodised finish, taken from close-up and two metres away.

Maintenance

Pre-finished items should be cleaned regularly (at least once every 6 months in interior applications and more often in industrial or exterior environments) with a dilute solution of mild, neutral liquid detergent, e.g., dish washing detergent, warm water (40°C), and a soft, lint free cloth or brush.

Do not use abrasive cleaning tools such as steel wool, hard brushes, abrasive scourers, etc., as these may damage the coating surface and change the colour or gloss levels of the finish. Rinse suds off thoroughly with fresh water and dry with a clean cloth.

It is vital that any other chemicals such as petrol, strong alkalines or acids are NOT used on any pre-finished surface.

Pre-finished items that are maintained regularly should retain their good looks. They will not crack, chip or peel as with conventional finishes.

Installation Care

During installation construction, the pre finished surface should be protected from damage by subcontractors and site works during construction.

Once installed and finished, maintaining the initial appearance is a simple matter. The dirt and grime which builds up on surfaces over time contains moisture and salts which can adversely affect pre-finished surfaces and must be removed.