

IDENTIFICATION SYSTEMS FOR ALUMINIUM EXTRUSION DIE DRAWINGS

Relating to the powder coating of architectural aluminium window, door extrusions, and home improvement profiles and the jigging and coverage thereof.

Primary

RED continuous line ('Tempo' felt tip)

Fax/Email _____ Long Dashes

Primary visible surfaces exposed to outside or inside when window/door is closed. Requiring a nominal 60 micron cover in powder and best possible surface finish with minimum inclusions. No jig marks or shading along the extrusion on this face, but 25mm each end jig allowance required on all profiles.

§ Secondary

GREEN continuous line ('Tempo' felt tip)

Fax/Email Dots

Secondary visible surfaces, ie; In cavity of window/door and only visible when window/door in open position. Cover coat required, ie; Nominal 40 microns powder coat. Finish to be fairly high visible standard but less critical than primary surfaces.

Non-visible

BLUE continuous line ('Tempo' felt tip)

Fax/Email XXXXXXXXXXXXXXXX Crosses

Non-visible surfaces need not be coated or partially coated if convenient. Jig marks and shading acceptable here.

§ Critical engagement areas

YELLOW continuous line ('Tempo' felt tip)

Fax/Email /////////////// Hatched

Critical engagement areas, i.e.; polyamide strip channels, woolpile grooves, bead engagements and clipping areas for uPVC composite or clad extrusions. In these areas minimum paint coverage required.

NB: Powder coatings are generally applied by electrostatic methods and in some instances because of the 'Faraday Cage' it may be impossible to achieve the required paint coverage in certain channels and recesses, also jig shading in some internal corners.

May we suggest that fully marked up drawings are forwarded for appraisal at point of enquiry (Extruders and customers drawings may show a slight variance of the above format, in that case we will confirm back and request approval of our interpretation).

Prepared by Barley Chalu Limited from the best knowledge available. No responsibility is accepted that the information given is sufficient or correct in all cases.

Revision 5, Dated 23.05.2018

Barley Chalu Limited