

## IDENTIFICATION SYSTEMS FOR ALUMINIUM EXTRUSION DIE DRAWINGS

**Relating to the powder coating of architectural aluminium windows, door extrusions and home improvement profiles and the jiggling and coverage thereof.**

### Primary

**RED** continuous line

Email/Fax \_\_\_\_\_ Long Dashes

Primary visible surface exposed to outside or inside when window/door closed. Requiring a nominal 60 micron cover in powder and best possible surface finish with minimum inclusions. No jig marks or shading.

### Secondary

**GREEN** continuous line

Email/Fax ..... Dots

Secondary visible surfaces, i.e., in cavity of window/door and only visible when window/door is open.

Cover coat required i.e., nominal 40 microns powder coat. Finish to be fairly high visible standard but less critical than primary surfaces.

### Non-visible

**BLUE** continuous line

Email/Fax xxxxxxxxxxxx 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

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

Critical engagement areas, i.e., polyamide strip channels, wool pile 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.

Fully marked up drawings should be forwarded for appraisal at least two weeks before processing of material.

Prepared by Barley Chalu Ltd from the best knowledge available. No responsibility is accepted that the information given is sufficient or correct in all cases. Revision 5 Dated 13<sup>th</sup> May 2021. Raised by K Grubb. Approved by M C Panam.