

TEST DESCRIPTION	TEST RESULT - PRODUCT QUALITY		
STANDARD DIMENSIONS (MM)	Width	1220 / 1250 / 1500 / 2000	
	Length	2440 / 2500 / 3050 / 4050	
	Thickness	3	
DIMENSION DEVIATION	Tolerance of Width : ≤ ± 2mm		
	Tolerance of Length : ≤ ± 3mm		
	Tolerance of Thickness : ≤ ± 0.2mm		
	Diagonal Deviation: ≤ 3mm		
	Out of straight at sides: ≤ 1mm/m		
	Warp : ≤ 3mm/m		
APPEARANCE	Clean surface without swelling flaws, scratches and aberrations		
LUSTER DEVIATION	Face : 0.5/50.0		
	Back : 0.5/50.0		
COATING THICKNESS	Face : ≥ 18.0µm		
	Back : ≥ 18.0µm		
SURFACE DENSITY (KGS/M2)	3mm - 0.30mm	White & Colors	4.41
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	4.09
	3mm - 0.15mm	White	3.93
PENCIL HARDNESS	≥ HB		
COATING TOUGHNESS	Inner Panel ≤ 1.5T		
ADHESIVE	No less than grade 1		
IMPACT STRENGTH	50Kg/cm Without peeling & cracking of paint		
RESISTANCE TO SOLVENT	Unchanged after cleaning 100 times with dimethylbenzene		
180° PEEL STRENGTH (N/mm)	3mm - 0.30mm	White & Colors	≥ 8.0
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	≥ 7.0
	3mm - 0.15mm	White	≥ 6.0
MODULUS OF ELASTICITY (N/mm2)	3mm - 0.30mm	White & Colors	≥ 68,000
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	≥ 64,000
	3mm - 0.15mm	White	≥ 61,000

RIGIDITY E x J (kNcm ² /m)	3mm - 0.30mm	White & Colors	≥ 780
		Silver Brushed	
		Silver Mirror	
	3mm - 0.20mm	White	≥ 730
	3mm - 0.15mm	White	≥ 700
TEMPERATURE RESISTANCE	unchanged after -40°C to +80°C 20 cycles		
COEFFICIENT OF HEAT EXPANSION	≤ 3.00x10 ⁻⁵ °C ⁻¹		
DEFORMATION TEMPERATURE	≥ 110°C		
LINEAR THERMAL EXPANSION	≤ 3.1 mm/m at 100° expansion temperature difference		
HEAT TRANSITION COEFFICIENT	5.6 - 5.8 Wm ² k		
0.2% PROOF STRESS	Rp0.2: 110-175 N/mm ²		
SOUND ABSORPTION FACTOR	0.04 - 0.05 Alphas		
AIRBORNE SOUND INSULATION INDEX Rw	23 - 25 dB		
WATER ABSORPTION	≤ 0.01 %		

SURFACE COATING SPECIFICATIONS		
IRIBOND WHITE MATT & GLOSS (DIGITAL PRINTING GRADE)	Surface Coating	Printable Polyester Paint
	Colour Base	Pigment made in Taiwan
	Standard Colour	Pure White
	Tolerance of Colour	≤ ± 2.0 △E
	Lacquering	Single layer of structural resistant baked lacquer providing printability and durability
	Surface Finishing	Matt & Gloss
	Tolerance of Glossiness	≤ ± 5.0 %
	Surface Outdoor Durability	5 years (the change of color ≤ 4 NBS)
IRIBOND COLOURS	Surface Coating	Polyester Paint
	Colour Base	Pigment made in Japan
	Standard Colour	Red , Yellow , Green , Blue , Black , Creme , Grey
	Tolerance of Colour	≤ ± 2.0 △E
	Lacquering	Single layer of structural resistant baked lacquer providing optimum rigidity and durability
	Surface Finishing	Matt & Gloss
	Tolerance of Glossiness	≤ ± 5.0 %
	Surface Outdoor Durability	5 years (the change of color ≤ 4 NBS)

IRIBOND SILVER BRUSHED	Surface Coating	Polyester Paint
	Colour Base	Transparent , No Pigment
	Standard Colour	Natural Alu Silver
	Tolerance of Colour	$\leq \pm 2.0 \Delta E$
	Lacquering	Made by special brushing process on the Aluminium surface, then surface coated by a transparent resistant baked lacquer providing optimum rigidity and durability
	Surface Finishing	Brushed
	Tolerance of Glossiness	$\leq \pm 5.0 \%$
	Surface Outdoor Durability	3 years
IRIBOND SILVER MIRROR	Surface	Anodic Oxidation
	Colour Base	N/A
	Standard Colour	Silver
	Tolerance of Colour	$\leq \pm 2.0 \Delta E$
	Lacquering	Made by special anodizing process on the Aluminium surface providing optimum rigidity and durability
	Surface Finishing	High Gloss
	Tolerance of Glossiness	$\leq \pm 5.0 \%$
	Surface Indoor Durability	3 years
	Surface Outdoor Durability	N/A
SHELF LIFE	The products should be used within 12 months from production date.	

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