

Halcon Doors

Roller Doors

Security, Commercial & Insulated Shutters

Product Specification			Specification-number	
Customer:			Rev. Number:	0
Product:	Rollershutters (Primer Topcoat System)		Date:	
			Sign:	
	SPECIFICATION	STANDARD	REQUIREMENT	
1	METAL		EN AW 3005 H46	
1.1	Mechanical properties after coating	EN 1396		
1.2	Nominal metal thickness Tolerance on metal thickness	EN 485-4	0.28-0.48mm +/-0.02mm	
1.4	Tolerance on lateral bow	EN 485-4	< 3mm measured over 2000mm length	
1.5	Tolerance on width	EN 485-4	<100mm +0,3/-0 101-300mm +0,4/-0 301-500mm +0,6/-0 1250mm +1,5/-0	
2	MAIN SIDE (PTS)			
2.1	Coating thickness	EN 13523-1	25 +/- 3 microns	
2.1.1	Primer Topcoat (Polyurethan with polyamide)		Polyester: 5 +/- 1 micron PUR- PA: 20 +/- 2 microns	
2.2	Colour	EN 13523- 3 EN 1396	According to approved sample Ref. Part C.2	
2.2.1	Gloss	EN 13523-2	30 +/- 5 E	
2.3	Bending	EN 13523-7	T 0	
2.4	Impact	EN 13523-5/6	30 +/- 5 E	
3	REVERSE SIDE		GTO	
3.1	Protective blue transparent coating	EN 13523-1	4 +/-1 1 microns suitable for PU- foaming	
4	PACKING SPESIFICATIONS			
4.1	Packing of coil		C32, eye to sky, wooden separators	
4.2	OD		Maximum tba mm. Min tba mm	
4.3	Pallet weight		Maximum tba kg.	
4.4	ID		400mm	
4.5	Fibre core		No	
4.6	Main coating		Facing out	
4.7	Coiling direction	EN 1396	Clockwise	
5	GENERAL INSTRUCTIONS			
	Work certificates	EN 10204 -3,1B	To be sent pr. e-mail	