The technical fiche of standard profile height 6,5 mm describes synthetically the main technical characteristics of the product deducible from the drawings and the technical specifications of the suppliers.

Specifications of raw materials (UNI EN 485-2)

ALLOY	STATE	THICKNESS	Rm	Rp	A5%	A50 %
3003	H 28	0,20 ÷ 0,45	≥ 190	≥ 160		≥ 2
3005	H18	0,25 ÷ 0,28	210 ÷ 250	≥ 190	≥ 3	
3005	H24*	0,31 ÷ 0,39	170 ÷ 225	≥ 130	≥ 12	
3005	H22*	0,35	145 ÷195	≥ 110	≥ 8	
3005	H26*	0,31	195 ÷ 240	≥ 160	≥ 9	
3105	H29	0,31 ÷ 0,35	≥ 210	≥ 190		≥ 3

Tolerance on the thickness ± 0,01 mm

* Material used in the production of bendable profile.

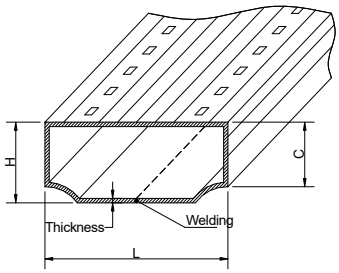
Legend:
Rm = unit breaking load in traction
Rp = yield load
A = elongation per cent

Composition of raw material (UNI EN 573-3)

ALLOY 3003										
Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	other cad.	other tot.	Al
0,6	0,70	0,05 ÷ 0,20	1,0 ÷ 1,5	--	--	0,10	--	0,05	0,15	rest
ALLOY 3005										
Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	other cad.	other tot.	Al
0,60	0,70	0,30	1,0 ÷ 1,5	0,20 ÷ 0,60	0,10	0,25	0,10	0,05	0,15	rest
ALLOY 3105										
Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	altri cad.	altri tot.	Al
0.60	0,70	0,3	0,3 ÷ 0,8	0,2 ÷ 0,8	0,2	0,4	0.,1	0,05	0,15	resto

Specifications of the finished product

Tolerance on the wideness	± 0,1 mm
Tolerance on the height	± 0,1 mm
Tolerance on the length	- 5 mm / + 10 mm
Check on the welding	Test with penetrating liquid (0 points/m) Check ultrasounds in line (Eddy Sensor)
Fogging test and volatile content	According to part “C” of the rules UNI 1279-4 (0%)
Residual greases	Test for the difference of weight after the degreasing (< 5 mg/m)
Permeability of holes	Test with flow meter (171 ± 26 l/m)
Painting (if made)	Paintings 100% polyester (thickness 20 -24 µm) Painting on the side is 2.5 mm ± 1 mm
Oxidation (if made)	According to the type of colour thickness between 1- 5 µm



Profile	L ± 0,1 mm	H ± 0,1 mm	C ± 0,2 mm	Thickness ± 0,01 mm Standard	Thickness ± 0,01 mm Std light	Thickness +0,01 mm - 0,02 mm -Bendable	Thickness +0,01 mm - 0,02 mm -Bend. thicker	Thickness +0,01 mm - 0,02 mm -Bend. light
A040	4.00	6.50	4.50	0.28	--	--	--	--
A055	5,50	6,50	4,60	0,28	0.25	0,35	0.39	0,31
A065	6,50	6,50	5,10	0,28	0.25	0,35	0.39	0,31
A075	7,50	6,50	5,10	0,28	0.25	0,35	0.39	0.31
A085	8,50	6,50	5,10	0,28	0.25	0,35	0.39	0.31
A095	9,50	6,50	5,10	0,28	0.25	0,35	0.39	0.31
A105	10.50	6.50	5.10	0.28	0.25	0.35	0.39	0.31
A115	11,50	6,50	5,10	0,28	0.25	0,35	0.39	0.31
A125	12.50	6.50	5.10	0.31	0.28	0.35	0.39	0.31
A135	13,50	6,50	5,10	0,31	0.28	0,35	0.39	0.31
A145	14,50	6,50	5,10	0,31	0,28	0,35	0.39	0.31
A155	15,50	6,50	5,10	0,31	0,28	0,35	0.39	0.31
A165	16,50	6,50	5,10	0,31	0,28	0,35	0.39	0.31
A175	17,50	6,50	5,10	0,31	0,28	0,35	0.39	0.31
A195	19,50	6,50	5,10	0,31	0,28	0,35	0.39	0.31
A215	21,50	6,50	5,10	0,39	--	0,39	0.45	--
A235	23,50	6,50	5,10	0,39	--	0,39	0.45	--
A255	25,40	6,50	5,10	0.45	--	0,45	--	--
A265	26.50	6,50	5,10	0.45	--	0,45	--	--

For painted spacers, outside dimensions are oversized of a level variable between 12 and 20 µ
For anodized spacers, outside dimensions are oversized of a level variable between 3 and 5 µ

Dimensions and tolerances

Quality aspects

2.1 Quality management

ALU-PRO is certified according to UNI EN ISO 9001:2015

2.2 Test of the product

Processes and routines are established to secure the quality of the delivered material. During production the spacer are constantly monitored through a planning check. Data will be available for a period of 5 years.

Customer focus and warranty

To secure the performance of the spacer, the stock conditions must be acceptable. Broken packaging, high humidity and variations in temperature will have an effect on the spacer surface. It is recommended to check out these specific points. On all aluminium spacer bars, ALU-PRO offers a 10 year product warranty. The warranty covers free exchange of spacers in case of a defect. The spacers must have been stored, installed and used according to present norms and technical standards.