



POWDERCOATED TO ORDER

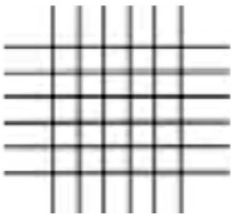
To deliver a high-quality product, we choose to powdercoat each unit individually. The benefits to the homeowner are; no scratches/scuffs from storage/transportation of off-site site finishing, cut ends are powdercoated with no bare metal exposed, and all parts are batched by unit rather than by extrusion part (so the colors exactly match in the end product).

CROSSHATCH ADHESION TESTING

With each unit, we powdercoat a sample chip and perform the Crosshatch Adhesion Test (ASTM D3359-17 M-B). The tested sample chip is included in the customer packet for each order. Acceptable results are from Class 5B or Class 4B.

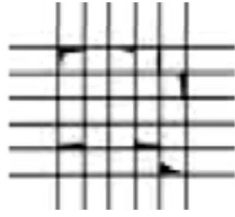
CLASS 5B

The edges of the cuts are smooth. No squares are missing



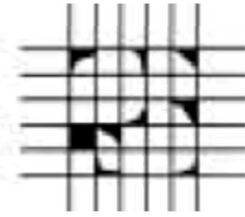
CLASS 4B

Small flakes at intersections. Less than 5% affected



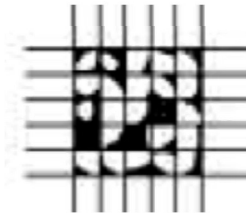
CLASS 3B

Some flaking along edges or intersections. Less than 15% affected.

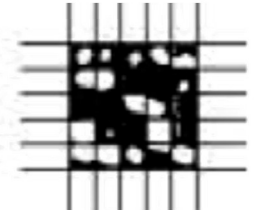


CLASS 2B

Some squares wholly flaked or in large ribbons. Less than 35% affected.



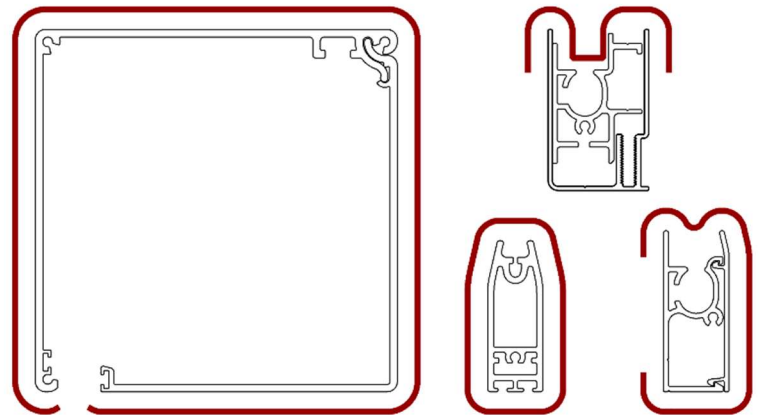
CLASS 1B



SURFACE FINISH

We follow the European Standard **BS EN 12206-1:2004** in determining unacceptable cosmetic surface defects. "Significant Surfaces" are marked on the drawing to the right in **red**.

1. The powder coating on the significant surface shall not have any scratches through to the base metal.
2. When the powdercoating on the significant surface is viewed at an oblique angle of about 60 degrees, none of the following defects shall be visible from a distance of 3 meters: Excessive roughness (orange peel), runs, blisters, craters, pinholes, inclusions, dull spots, pits or scratches
3. The powdercoating surface shall be of even color and with good hiding power.



HANGING HOLES AND MARKS

Non-standard extrusions, like buildout material, will have hanging holes. These holes are required for the powdercoating process. Where possible, they will be drilled roughly 6" in from either end of the extrusion. Within reason, the entire exterior surface of buildout will be considered a significant surface.

Standard extrusions are hung during the powdercoating process with custom fasteners but may occasionally have "touch marks" that are not visible after installation and which do not interfere with the operation of the product.

Overspray may be present on inside surfaces - it will not be thick enough to interfere with the function of the product.