

Approval & Reception Procedure

DMC – Departamento de Materiais de Construção	
Materials for Aluminium Alloy Windows	Document No. ARP/DMC/11
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1. Reference Standard

Reference standard: BS 4873:2004

Aluminium profiles: BS EN 755-9:2001 or equivalent;

Aluminium ancillary components: BS EN 485-2:1995 or equivalent;

Anodized oxidation coating on aluminium: BS 1615, BS 3987 or equivalent;

Liquid organic coating on aluminium: BS 4842 or equivalent;

Powder organic coating on aluminium: BS 6496 or equivalent;

PVDF coating on aluminium: GB/T 5237.5-2000 or equivalent;

Other materials being used shall conform to the standard BS 4873:2004.

2. Approval procedures

Must be followed

Manufacturer's specifications of aluminium profiles.

Manufacturer's specifications of coating material.

3. Reception procedures

Submission of documents

Aluminium profiles: Before delivered to the site, test certificates of the related aluminium sections should be submitted, including chemical, mechanical and dimensional tolerance.

Anodized oxidation coating: Before delivered to the site, test certificates of the related aluminium sections should be submitted, including coating thickness, sealing quality and colour and colour difference.

Liquid organic coating on aluminium: Before delivered to the site, test certificates of the related aluminium sections should be submitted, including coating thickness, gloss, colour, adhesion, hardness.

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Powder coating: Before delivered to the site, test certificates of the related aluminium sections should be submitted, including coating thickness, gloss, colour and colour difference, scratch resistance, adhesion, impact test and cupping test.

PVDF coating: Before delivered to the site, test certificates of the related aluminium sections should be submitted, including coating thickness, gloss, colour and colour difference, hardness, adhesion, impact test and cupping test.

4. Inspection of lot

2 samples shall be selected from each delivery for the following tests and verifications

- Coating thickness;
- Sealing quality of anodized oxidation coating (if applicable).
- Length unit weight and thickness of sections.

5. Acceptance criteria

The test result shall comply with the reference standard. If one fails to comply with the requirements, two additional samples shall be tested. If one fail the lot (delivery) shall be considered not complied with the standard.