

### Specification Sheet

.027 x 11 3/4" – Gutter Coil  
.027 x 11 7/8" – Gutter Coil  
5K .027" Aluminum Gutter

Listed below are the specifications on the paint, metal preparation, and finished coating for aluminum gutter coil.

- The aluminum used is alloy 3105-H24 which meets the specifications set forth in the "Aluminum Standards and Data 1988" published by the Aluminum Association. The gauge of the aluminum for the gutter is .027, plus or minus .002.
- The surface of the aluminum sheet is thoroughly cleaned and dried to remove residual oils and impurities using a 140°F-160°F hot water solution of potassium hydroxide provided by Henkel Surface Technologies and then applying a chromate or titanium base conversion coating, 1402W or 1455SF by Henkel Surface Technologies.
- A thermo setting polyester enamel is roller coated and baked at high temperatures for the outside coating. The reverse side of the coil, or wash coat, is a thermo setting polyester enamel applied to help resist corrosion and promote formability.
- The color range of the applied finish is .8 mils, plus or minus .2 mils (1.0)
- Made in the USA
- The physical test used on our coated panels includes:

180 degree-2T bend flex test no tape off using Scotch Brand #610 tape (ASTM D-4145-83)

Reverse impact –2 lbs./mil no tape off in positive direction using Scotch Brand #610 tape (ASTM D-4146-83)

Pencil Hardness-F minimum using Eagle Turquoise Brand pencil (ASTM D-3363-92A)

M.E.K. resistance - 100 double rubs using cheesecloth-mesh size 28 x 24 (ASTM D-5402-92)

Dry Heat flexibility – no tape off on 2T bend after 2 minutes at 160 degrees F

