



SPECIFICATION FOR COATED COILS

| Sr.No. | Product Characteristic | Unit | Specification | Measuring/ Test Equipment | Test Standard |
|--------------------------------|--|---------|---|---------------------------|----------------|
| 1 | Aluminium Coils | | Alloy 1100 / H24 | --- | --- |
| 2 | Coil thickness | mm | 0.18 ± 0.005 | Digital micrometer | --- |
| 3 | Coil Width | mm | 1250 /1500 - +1/-0 | Measuring Tape | --- |
| <u>PAINT PROPERTIES</u> | | | | | |
| 1 | Paint Type | --- | Polyester / PU Suitable for printing | --- | --- |
| 2 | Coating Thickness | µm | Min. 20 ± 2 | DFT Meter | ASTM D 7091 |
| 3 | Color Difference | Visual | Should match to standard sample | --- | ASTM D1729 |
| 4 | Color Difference (ΔE) by spectrophotometer | CIE lab | Max. 0.5 | Spectrophotometer | ASTM D 2244 |
| 5 | Gloss at 60 ° | % | 35 - 40 | Gloss -o-meter | ASTM D1729 |
| 6 | Solvent Resistance (MEK) | DR | Min. 100 DR | MEK | ASTM D5402 |
| 7 | Impact Resistance | Kg/cm | To Pass min. 30 kg-cm (Reverse impact) | Impact Tester | ASTM D2794 |
| 8 | Erichsen Cupping | mm | Min. 5.0 mm, no tape off | Erichsen Cupping Tester | ASTM ECCA T6 |
| 9 | Bend Test (T Bend) | --- | To pass min. 1T No tape off (2T No crack) | T Bent Tester. | ASTM D 4145 |
| 10 | Pencil Hardness | --- | Min. F | Pencil Hardness Tester | ASTM D 3363 |
| 11 | Cross Hatch Test | --- | To pass 100 / 100 , (1 X 1 mm) by tape test. | Cross Hatch Tester | ASTM D3359 |
| 12 | Coated surface quality | Visual | 1. Edge to Edge coating (Uncoated edges are not acceptable, refer photos). 2. No edge burr, no edge wavy. 3. Single coil (No coil joints inside). 4. Plain coil winding (No stagger). 5. Surface finish - free from coating defect like blisters, vibration bands, color /gloss patches, dents, holes, scratches, edge damages. 6. Coil weight > 2.0 T . 7. Coil Packing - Seaworthy eye to wall. 8. Bobbin core I.D. 508 ± 2 mm | | |
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