



Aluminum Coil Anodizing Corporation
 501 E Lake Street • Streamwood IL 60107
 Phone: 630-837-4000 • Fax: 630-837-0814
 www.acacorp.com

Product Specification Document

ACAD-154AB-BF Rev 1

Product ID: 154AB-BF Bright Copper

Application: Architectural and Decorative

Material Specification:

Alloy: 1090

Temper: H19

Mechanical Properties (typical):

Tensile Strength:	180 N/mm ²	(26,000 psi)
Yield Strength:	165 N/mm ²	(24,000 psi)
Elongation:	4%	
Minimum Bend Radii:	1T	

For White Paint:	
1T bend:	n/a
1T bend – dry heat:	n/a
0T bend:	n/a

Optical / Anodized Properties:

Total Reflectance (TR%) ¹ :	% minimum			¹ (Technidyne TR-2 (ASTM 1651-94))	
Distinctness of Image (DI) ² :	75 minimum			² (Hunter Labs D47 Dorigon (ASTM E430-83))	
Specular Reflectance (RS) ² :	n/a			³ (DIN 67530)	
15° Diffuseness (15°) ² :	.05 maximum			⁴ (Byk Gardner Micro Gloss Meter)	
Dr. Lange 60° ³ :	w/g	n/a	a/g	n/a	⁵ (ASTM B137-89)
Gardner 60° Gloss ⁴ :	w/g	n/a	a/g	n/a	⁶ (Hunter Lab mini-Scan XE Plus)
Anodize Film Thickness ⁵ :	2.5 to 4.1 microns			(0.00010 to 0.00016 inch)	
Iridescence Rating:	Not Controlled				
Color ⁶ :	L*	58 yto 62	a* 11 to 15	b* 16 to 20	

Availability: Sheet and Coil

Gage:	0.30 to 1.0 mm	(0.012 to 0.040 inch)
Width:	12.7 to 1250 mm	(0.5 to 49.213 inch)
Length:	up to 3660 mm	(up to 144 inch)

Tolerances (standard): (Tighter tolerance may be possible. Contact your sales representative.)

Gage:	From:	0.25 to 0.40 mm	+/- 0.025 mm	(0.010 to 0.016 inch, +/- 0.001 inch)
		0.41 to 0.80 mm	+/- 0.040 mm	(0.017 to 0.032 inch, +/- 0.0015 inch)
		0.81 to 1.00 mm	+/- 0.050 mm	(0.033 to 0.040 inch, +/- 0.002 inch)
Slit Width:	From:	12.5 to 305 mm	+/- 0.125 mm	(0.5 to 12 inch, +/- 0.005 inch)
		306 to 610 mm	+/- 0.38 mm	(12.1 to 24 inch, +/- 0.015 inch)
		611 to 1250 mm	+/- 0.50 mm	(24.1 to 50 inch, +/- 0.020 inch)
Sheet:	Length:	Up to 1524 mm	+/- 1.0 mm	(Up to 60 inch, +/- 0.040 inch)
		1525 to 3050 mm	+/- 1.5 mm	(60 to 120 inch, +/- 0.060 inch)
		3051 to 3660 mm	+/- 2.0 mm	(120 to 144 inch, +/- 0.080 inch)
	Squareness: ¹	Up to 1200 mm	+/- 0.5 mm	(Up to 48 inch, +/- 0.020 inch)
		1201 to 2400 mm	+/- 1.0 mm	(49 to 95 inch, +/- 0.040 inch)
		2401 to 3660 mm	+/- 1.5 mm	(96 to 144 inch, +/- 0.060 inch)

¹ Difference in diagonals

Lateral Bow (in one meter):	Width Under 300 mm:	2.5 mm max.	(Width Under 12 inch: 0.100 inch)
	Width Over 300 mm:	1.25 mm max.	(Width Over 12 inch: 0.050 inch)

Flatness: Height between waves: 1% of wave length, 8mm (0.32 inch) maximum.

Burr: 10% of gage Not to exceed .08 mm (.003 inch)