



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-998YD-YA Rev 1

Product ID: 998YD/YA UltraBond

Application: For adhesive/lamination applications requiring excellent bonding substrate

Material Specification:			
Alloy:	5205		
Temper:	H14		
Mechanical Properties (typical):			
Tensile Strength:	155 N/mm ²	(22,500 psi)	For White Paint: 1T bend: n/a 1T bend – dry heat: n/a 0T bend: n/a
Yield Strength:	148 N/mm ²	(21,500 psi)	
Elongation:	2.5%		
Minimum Bend Radii:	1T		

Optical / Anodized Properties:			
Total Reflectance (TR%) ¹ :	% minimum		
Distinctness of Image (DI) ² :	n/a		
Specular Reflectance (RS) ² :	n/a		
15° Diffuseness (15°) ² :	n/a		
Dr. Lange 60° ³ :	w/g	n/a	a/g n/a
Gardner 60° Gloss ⁴ :	w/g	330-370	a/g n/a
Anodize Film Thickness ⁵ :	0.1 to 0.25 microns (0.000004 to 0.00001 inch)		
Iridescence Rating:	Not Controlled		
Color ⁶ :	L*	a*	b*

¹(Technidyne TR-2 (ASTM 1651-94))
²(Hunter Labs D47 Dorigon (ASTM E430-83))
³(DIN 67530)
⁴(Byk Gardner Micro Gloss Meter)
⁵(ASTM B137-89)
⁶(Hunter Lab mini-Scan XE Plus)

Availability:	Sheet and Coil		
Gage:	0.3 to 1.27 mm	(0.012 to 0.050 inch)	
Width:	12.7 to 1250 mm	(0.50 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 0.050 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)		