



Aluminum Coil Anodizing Corporation
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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 | | |

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|---|--|---------|---|
| Optical / Anodized Properties: | | | |
| Total Reflectance (TR%) ¹ : | % minimum | | ¹ (Technidyne TR-2 (ASTM 1651-94)) |
| Distinctness of Image (DI) ² : | n/a | | ² (Hunter Labs D47 Dorigon (ASTM E430-83)) |
| Specular Reflectance (RS) ² : | n/a | | ³ (DIN 67530) |
| 15° Diffuseness (15°) ² : | n/a | | ⁴ (Byk Gardner Micro Gloss Meter) |
| 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* |

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|----------------------|-----------------|-----------------------|--|
| 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) | |

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| 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) | |