



## American Architectural Windows

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# AAMA PAINT SPECIFICATIONS

### AAMA 2604 STANDARD ON ALL ALUMINUM PRODUCTS

Specification	2603	2604	2605
<b>South Florida Weathering</b>			
<b>Color retention</b>	1 year: "slight" fade	5 yrs: Fade = 5 Delta E	10 yrs: Fade = 5 Delta E
<b>Chalk resistance</b>	1 year: "slight" chalk	5 yrs: Chalk = 8	10 yrs: Chalk = 8
<b>Gloss retention</b>	No specification	5 yrs: 30% retention	10 yrs: 50% retention
<b>Erosion resistance</b>	No specification	5 yrs: 10% loss	10 yrs: 10% loss
<b>Dry film thickness</b>	0.8 mils minimum	1.2 mils minimum	1.2 mils minimum
<b>Pretreatment System</b>	Chrome or Chrome Free *	Chrome or Chrome Free *	Chrome or Chrome Free *
<b>Accelerated Testing</b>			
<b>Salt Spray</b>	1,500 hours	3,000 hours	4,000 hours
<b>Humidity</b>	1,500 hours	3,000 hours	4,000 hours

## APPLICATOR

The level of quality and appearance of organic spray applied finished is dependent on the applicator. When specifying your finish, the introduction of one or more of the following statements within the specification article 2.06 FINISHES will assist in achieving a higher level of quality;

*Specify on projects where the organic coating covers a finished material area of greater than 1,000 square feet:*

- Applicator will run (and maintain on file) test panels that process with the project for the sole purpose of conducting and verifying tests that demonstrate AAMA 2604 or AAMA 2605 compliance. Such panels shall be retained on file for at least one year from finish application and be available for submission prior to project completion with test results clearly defined.
- Applicator will maintain on file quality control reports which substantiate mil readings, gloss, and color match. Bake temperature tapes shall be included.

*General items to consider for a project specification:*

- Applicator will achieve color match that is within 2-Delta-E of master chip on all runs/releases and match will be verified only by use of a Spectrophotometer. All material will be monitored as finishing is completed by the applicator to assure color match.
- Applicator will use Bake Strips/Temperature Tapes during the finish application process on each release/run of material to assure quality standards are met relative to proper bake temperature.
- Applicator will have in-House Color Match Computers to assure releases, rework or other phrased requirements have proper color match and consistency.
- Applicator will be fully EPA compliant.
- Applicator will have their own fully certified Field Service crews to supply field repair should such be required.