



Aluminum Pre-Made Gutter Specifications

MATERIALS

- A. All ACM aluminum pre-made gutters shall be made of a 3105 / 3025 - type aluminum coil sheet H24, or equivalent, as referenced in Aluminum Standards and Data, Table 7.1. The metal shall be treated on both sides with a non-chromate chemical conversion coating to ensure proper paint adhesion and resistance to corrosion. ACM pre-made gutters shall be coated on the exterior side with ACM's baked on, high performance, Polykote® 3000 paint system that is specifically formulated for residential exterior applications. The interior side of pre-made gutters shall be coated with a full coat of Polyester backer finish unless specified otherwise. The nominal film thickness of coatings shall be a 0.70 mil on the exterior side and 0.20 mil on the interior side with a total nominal thickness of .027 mil.
- B. Physical Properties of Coated Surface:
- Coated film hardness achieves F-2H pencil as tested per ASTM D3363
 - Solvent Resistance: 50 ~ 100+ MEK rubs as tested per ASTM D4752
 - Flexibility: Nominal 2-T180 NTO (subject to method of forming & metal thickness) as measured by ASTM D4145-83
 - Reverse Impact: 1.5X metal thickness NTO ASTM D2794

Accelerated Weathering:

- 5% Salt Spray (1000 hours) no creep over 1/32" from scribe ASTM B 117
- 100% Humidity: No significant visual change after 1,000 HR per ASTM D 2247-87
- QUV test as achieved by ASTM D4587 no visible loss of film integrity and no chalking greater than #8 after 500 HR, as measured by ASTM D 4214-89

- C. ACM's (0.027") aluminum pre-made gutters are available in a wide variety of colors to match ACM/Norandex metal products, as well as most major manufacturers'. Please refer to color literature for color availability.

APPLICATIONS

ACM aluminum pre-made gutters are designed for residential and light commercial applications. Gutter system shall be attached per contractor's direction and state and local building codes.

CONSIDERATIONS

Corrosion is likely to happen with direct contact of aluminum products to certain dissimilar materials or water run-off from same such materials. Care should be taken to avoid contact of aluminum with any corrosive materials during the installation process, including, but not limited to: concrete, stucco, pretreated lumber, corrosive chemicals, fiber cement products, masonry cement, roofing made with metallic granules of dissimilar metals (copper, zinc, steel, etc.), salt, and dissimilar metals.

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