

Master Specification for Aluminium Profiles

- Scope of application:** This specification defines the basic requirements for all extruded aluminium profiles, purchased by profine
- Class of goods:** HAWA (traded goods) aluminium-profiles (701535000)
- Material:** EN AW – 6060 T66 according to DIN 755-2
- Place of label:** Front side
- Label:** Product-/article number, SAP number, content of packaging units, profine Logo
- Other applicable Standards:**
- DIN EN 755-1:1997-08 - Extruded rod/bar, tube and profiles
Part 1: Technical conditions for inspection and delivery
 - DIN EN 755-2:1997-08 - Extruded rod/bar, tube and profiles
Part 2: Mechanical properties
 - DIN EN 12020-1:2001-07 - Extruded precision profiles in alloys
EN AW-6060 and EN AW-6063
Part 1: Technical conditions for inspection and delivery
 - DIN EN 12020-2:2001-07 - Extruded precision profiles in alloys
EN AW-6060 and EN AW-6063
Part 2: Tolerances on dimension and form
 - DIN EN12206-1:2004-09 - Paints and varnishes – Coating of aluminium and aluminium alloys for architectural purposes
Part 1: Coatings prepared from coating powder
 - DIN 17611:2011-11 - Anodized products of aluminium and wrought aluminium alloys – Technical conditions of delivery
- Fastness to weathering:** GSB AL 631 (edition 05/2011) and Qualicoat EN ISO 11341 / ISO 2810 (edition 02/2010)
- Amount of samples:** For the approval of new tools and replacement tools (if geometry changed) we need 4 samples x 1,5 m mill finished and 4 samples x 1,5 m powder coated.
- Comments:**
- | thickness of coating | |
|----------------------|----------|
| powder coated | 60-80 µm |
| natural anodized | 15-20 µm |
- Further requirements:** profiles should be marked according to profine Norm pN 103, if possible