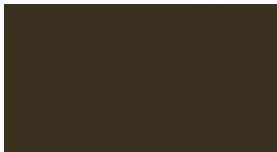
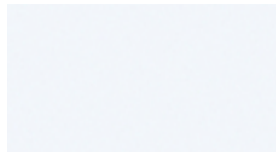


## Architectural Colors for Aluminum Products

FINAL COLOR SELECTION SHOULD BE MADE FROM ACTUAL COLOR CHIPS



Bronze



White



Beige



Black



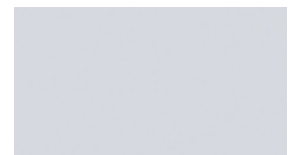
Ivory



Seawolf Beige



Simulated Anodized  
Champagne



Simulated Anodized  
Silver



Medium Gray



Charcoal Gray



Green



Aged Copper



Fairfax Brown



Red



River Rouge Red



Colonial Blue

**NOTE:** These colors are merely a few available from Crystal architectural products. Please contact your sales representative for more detailed information. These samples are as close as possible to actual color offered, within the limitations of color chip reproduction. Upcharge and Extended lead time apply based on quantity. Please ask your representative for more details.

### ► WHY POWDER COATING IS CRYSTAL'S CHOICE OF FINISH?

**Powder coating** is an advanced method of applying a decorative and protective finish to a wide range of materials and products that are used by both industries and consumers.

Powder coating is the fastest-growing finishing technology in North America, representing over 10% of all industrial finishing applications.

Powder coating gives consumers, businesses, and industry one of the most economical longest-lasting, and most color-durable quality finishes available.

**Powder coating** is also highly protective of our environment. While liquid finishes contain solvents which have pollutants known as volatile organic compounds (VOC's), powder coating contains no solvents. Thus, there is no longer a need for finishers to buy costly pollution control equipment. In addition, most powder coating over-spray that does not adhere to the part can be retrieved and reused, virtually eliminating the waste commonly found in liquid finishing processes.

Queens, NY (HQ)  
 St. Louis, MO  
 Scranton, PA

P: 800.472.9988 F: 718.460.4594  
 P: 636.305.7880 F: 636.305.7881  
 P: 570.276.8000 F: 570.563.5313

Cleveland, OH  
 Chicago, IL  
 Riverside, CA

P: 440.871.8694 F: 440.871.8690  
 P: 773.376.6688 F: 773.376.6868  
 P: 951.779.9300 F: 951-779-6300

## AAMA Paint Specifications

**AAMA 2604 STANDARD ON ALL CRYSTAL ALUMINUM PRODUCTS**

	AAMA 2603 (SAME AS AAMA 603)	AAMA 2604 (SAME AS AAMA 605)	AAMA 2605 (NEW SPEC)
<b>SOUTH FLORIDA WEATHERING:</b>			
COLOR RETENTION	1 yr. "Slight" Fade	5 yr. -Fade <= 5 Delta E	10 yr. -Fade <= 5 Delta E
CHALK RESISTANCE	1 yr. "Slight" Chalk	5 yr. - Chalk 8	10 yr. - Chalk 8
GLOSS RETENTION	No Specification	5 yr. -30% Retention	10 yr. - 50% Retention
EROSION RETENTION	No Specification	5 yr. - 10% Loss	10 yr. - 10% Loss
DRY FILM THICKNESS	2-3 Mils Minimum	2-3 Mils Minimum	2-3 Mils Minimum
PRETREATMENT SYSTEM	Chrome or Chrome-Free	Chrome or Chrome-Free	Chrome Pretreatment Supplier
<b>ACCELERATED TESTING:</b>			
SALT SPRAY	1,500 Hours	3,000 Hours	4,000 Hours
HUMIDITY	1,500 Hours	3,000 Hours	4,000 Hours

### APPLICATOR

The level of quality and appearance of organic spray applied finishes 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 in file), test panels that process with the project for the sole purpose of conducting and verifying test that demonstrate 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 this 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.