



# Aluminum Gutter Coil Specifications

## MATERIALS

- A. All ACM gutter coils 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. Gutter coil products shall be coated on the front side with ACM's baked on, high performance, Polykote® 3000 paint system that is specifically formulated for residential exterior applications. The backside of all gutter coils 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 front side and 0.20 mil on the backside.
- B. Physical Properties of Coated Surface:
  - a. Coated film hardness achieves F-2H pencil as tested per ASTM D3363
  - b. Solvent Resistance: 50 ~ 100+ MEK rubs as tested per ASTM D4752
  - c. Flexibility: Nominal 2-T180 NTO (subject to method of forming & metal thickness) as measured by ASTM D4145-83
  - d. Reverse Impact: 1.5X metal thickness NTO ASTM D2794

### Accelerated Weathering:

- a. 5% Salt Spray (1000 hours) no creep over 1/32" from scribe ASTM B 117
  - b. 100% Humidity: No significant visual change after 1,000 HR per ASTM D 2247-87
  - c. 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 gutter coil products are packaged with one to three rolls per skid with each coil approximately 300 – 400 lbs. Aluminum gutter coil is available in the widths and nominal thickness listed below\*:

<u>Thickness</u>	<u>Available Widths</u>
.027	11 3/4", 11 7/8", 14", 15"
.032	11 3/4", 11 7/8", 15", 18"

- D. ACM's aluminum gutter coil is 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 gutter coil is designed for residential and light commercial applications. Gutter coil can be field formed to provide seamless gutter systems. 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.

\*Some coils widths may be available in specific geographic distribution areas.

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