



### Quality

Our computer-automated system controls and monitors your product through the entire anodizing process. It tracks all aspects of the process including tank sequencing, time, temperature, voltage, current, etc. Our computer controlled hoist system ensures all material with the same job and process specification is moved through the same solutions for the same amount of time.

Linetec conducts a rigorous, on line, quality assurance program for your product before it is allowed to leave our premises. We visually check for freedom from visual flaws and color differences among other on line inspections. Laboratory testing includes checks for coating weight, seal quality, anodic film thickness, and several other criteria. We carefully document all our tests and keep them on file for a minimum of five years.

Linetec's documented testing standards allow us to offer warranties up to 5 years, depending upon finish specified, with confidence that your product will perform as intended.

### Environmental Compliance

Linetec has the latest in acid recovery, effluent neutralizing and monitoring systems on our two anodizing lines to assure that we are totally compliant and environmentally friendly.

Besides being a leader in the finishing industry, we are also a leader in environmental protection and compliance, doing our part to maintain a clean and healthy environment for everyone.

See reverse side for finish specifications.



**FINISHER OF CHOICE!™**

# **LINETEC**

## **ANODIZE FINISHES**



**Clear Anodize 215R1 or 204R1**



**Champagne ANO-300**



**Light Bronze ANO-301**



**Medium Bronze ANO-302**



**Dark Bronze ANO-303**

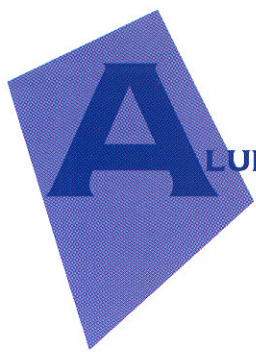


**Extra Dark Bronze ANO-304**



**Black ANO-305**





## ALUMINUM ASSOCIATION DESIGNATION SYSTEM FOR ALUMINUM FINISHES

The following examples show how the Aluminum Association Designation System for Aluminum Finishes is used (each designation is preceded by the letters AA to identify it as an Aluminum Association designation):

### Example 1 - Architectural Building Panel

If an architect wished to designate a matte anodized finish for a building such as that produced by giving aluminum a matte finish, followed by architectural Class I natural anodizing, he would designate it as follows:

AA - M10C22A41  
AA - Aluminum Association  
M10 - Unspecified  
C22 - Medium Matte Etched  
A41 - Anodic Coating-architectural, Class I

### Example 2 - Architectural Aluminum with Anodized Electrolytically Deposited Color

If an architect wished to specify a bronze anodized panel with a two-step color for architectural application, the designation would be:

AA - M10C22A44  
AA - Aluminum Association  
M10 - Unspecified as fabricated finish  
C22 - Chemically etched medium matte finish  
A44 - Anodic Coating-architectural, Class I Electrolytically Deposited Color

### Mechanical Finishes (M)

#### As Fabricated

M10 Unspecified  
M11 Specular as fabricated  
M12 Nonspecular as fabricated  
M1X Other (to be specified)

#### Buffed

M20 Unspecified  
M21 Smooth specular  
M22 Specular  
M2X Other (to be specified)

#### Directional Textured

M30 Unspecified  
M31 Fine satin  
M32 Medium satin  
M33 Coarse satin  
M34 Hand rubbed  
M35 Brushed  
M3X Other (to be specified)

#### Nondirectional Textured

M40 Unspecified  
M41 Extra fine matte  
M42 Fine matte  
M43 Medium matte  
M44 Coarse matte  
M45 Fine shot blast  
M46 Medium shot blast  
M47 Coarse shot blast  
M4X Other (to be specified)

### Chemical Finishes (C)

#### Nonetched Cleaned

C10 Unspecified  
C11 Degreased  
C12 Inhibited chemical cleaned  
C1X Other (to be specified)

#### Etched

\*C20 Unspecified  
\*C21 Fine matte  
\*C22 Medium matte  
\*C23 Coarse matte  
\*C2X Other (to be specified)

#### Brightened

C30 Unspecified  
C31 Highly specular  
C32 Diffuse bright  
C3X Other (to be specified)

#### Chemical Coatings

C40 Unspecified  
C41 Acid chromate-fluoride  
C42 Acid chromate-fluoride-phosphate

C43 Alkaline chromate  
C44 Non-chromate  
C45 Non-rinsed chromate  
C4X Other (to be specified)

### Anodic Coatings

#### General

A10 Unspecified  
A11 Preparation for other applied coatings  
A12 Chromic acid anodic coatings  
A13 Hard, wear and abrasion resistant coatings  
A1X Other (to be specified)

#### Protective and Decorative Coating less than 10um (.04 mil)

A21 Clear  
A22 Integral color  
A23 Impregnated color  
A24 Electrolytically deposited color  
A2X Other (to be specified)

#### Architectural Class I<sup>1</sup> 10-18 um (0.4-0.7 mil) coating

\*A31 Clear  
A32 Integral color  
A33 Impregnated color  
\*A34 Electrolytically deposited color  
A3X Other (to be specified)

#### Architectural Class I<sup>1</sup> 18 um (0.7 mil) and thicker anodic coatings

\*A41 Clear  
A42 Integral color  
A43 Impregnated color  
\*A44 Electrolytically deposited color  
A4X Other (to be specified)  
<sup>1</sup>Aluminum Association Standards for Anodized Architectural Aluminum

#### Resinous and Other Organic Coatings (R)<sup>2</sup>

R10 Unspecified  
R1X Other (to be specified)  
<sup>2</sup>These designations may be used until more complete series of designations are developed for these coatings.

\*Provided by Linetec Anodizing

## GUIDE SPECIFICATIONS

1. The anodic coating shall be continuous, fully sealed and free from powdery surfaces.

*Comment:* A uniform, continuous coating, fully sealed, is essential to good appearance and satisfactory performance.

2. There shall be no noticeable change in the color of the coating when subjected to a 200 hour UVIARC test.

*Comment:* Where severe exposure to sunlight will be encountered and where long finish life is desired, the UVIARC test is used to determine resistance to ultra violet radiation.

3. Maximum acid dissolution weight loss shall be no greater than 2.6 mg/in<sup>2</sup> when tested in accordance with ASTM B-680.

*Comment:* This test method covers a test for the quality of seal of porous anodic coatings on aluminum and its alloys. This is a rigorous test, but one which should be used if the coating is exposed to severe conditions.

4. All architectural work conforms to AAMA-611 Specification.

5. All commercial work conforms to MIL-A-8625 Military Specification for Type II (Class 1 and 2).

*Comment:* This specification covers the requirements for sulfuric acid anodizing, both dyed and non-dyed.

6. Linetec has the ability to conform to most major defense, aerospace, electronics, and automotive specifications.

Please submit your required specifications so Linetec can assure compliance.

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