



**COLORIN® DARK BRONZE ARCHITECTURAL CLASS I IS A FINISH DEVELOPED FOR EXTERIOR APPLICATIONS WHERE UV FADE RESISTANCE IS CRITICAL TO THE DESIGNER.**

The ColorIn® Dark Bronze Architectural Class I finish utilizes a specialized anodizing process using a two-step electrolytic coloring system. The combination of an Architectural Class I film thickness with the inorganic coloring chemistry provides exceptional corrosion resistance and will maintain color consistency under harsh weathering conditions.

**INDUSTRY DESIGNATIONS**

**Aluminum Association**  
AA-M12-C22-A34  
**Mil A-8625F Classification**  
Type II Sulfuric Anodize

**INDUSTRY STANDARDS**

**AAMA 611-12**  
Voluntary specification for anodized architectural aluminum  
**Mil A-8625F Anodizing Standard**  
Anodic coatings for aluminum and aluminum alloys

**ALUMINUM PROPERTIES**

Alloy ..... 5005  
Temper ..... Half Hard  
Finish ..... Mill Finish

**MECHANICAL PROPERTIES**

UTS ..... 20-26 ksi [138-179 MPa]  
YTS ..... 15 min [103 MPa]  
Elongation ..... 4% - 5% min

**CHEMICAL PROPERTIES**

Si ..... 0.30 %  
Fe ..... 0.7 %  
Cu ..... 0.20 %  
Mn ..... 0.20 %  
Mg ..... 0.50 - 1.1 %  
Cr ..... 0.10 %  
Zn ..... 0.25 %  
Other ..... 0.15 %  
Al ..... Remainder

**ANODIZE FILM THICKNESS**

**Architectural Class I:**

**ANODIZE FINISH PROPERTIES**

Optical ..... N/A  
Gloss ..... Coarse Matte  
Color ..... Dark Bronze  
Color Target ..... < Delta E of 5.0  
UV Stable ..... Yes  
Environment ..... Exterior  
Quality Grade ..... 2  
Other ..... None

*Panel-to-Panel match quality can be custom ordered.*

**WIDTH AVAILABILITY**

48.0" (1219 mm)

*Other widths can be custom ordered.*

**GAUGE AVAILABILITY**

0.032" (0.8 mm)  
0.040" (1.0 mm)  
0.050" (1.3 mm)  
0.063" (1.6 mm)  
0.080" (2.0 mm)

**ANODIZED FINISH TEST DATA**

CHARACTERISTIC	TEST METHOD	STANDARD	TEST RESULTS
Oxide Layer, Weight	ASTM B137 - Coating Dissolution	AAMA 611-12, 4.18 mg/cm <sup>2</sup> (27.0 mg/in <sup>2</sup> )	> 4.2mg/cm <sup>2</sup> (27 mg/in <sup>2</sup> )
Color Uniformity	ASTM B2244 - Calculation Δ in Delta E	AAMA 611-12, Color must meet agreed upon specification	Lorin Color D043, Δ in Delta E ≤ 2.7
Gloss Uniformity	ASTM D523 - 60° Gloss Reflectance	AAMA 611-12, Gloss must meet agreed upon specification	Lorin Gloss E1D, Nominal Target 30
Abrasion Resistance	ASTM D4060 - Taber abrasive wheel	Based on a anodic film thickness, 18 μm (0.700 mils)	10,000 cycles; 40.6 mg / wgt loss; 4.1wear index
Film Hardness	ASTM D3363 - Pencil Hardness	Based on a anodic film thickness, 10 μm (0.400 mils)	9H Hardness
Corrosion Resistance	ASTM B117 - Neutral Salt Spray	AAMA 611-12, 3,000 hours ≤ 15 pits < 1mm, 381 cm <sup>2</sup> (150in <sup>2</sup> )	Pass, No visible pits
Weathering	SAE J1960 - ATLAS Accelerated testing using an Xenon Arc light source	AAMA 611-12, 10 year Florida Exposure with max Δ Delta E of 5.0	<i>In Test Chamber</i>
Craze Resistance	AAMA 611-12 - Thermal Crazing of the oxide layer	AAMA 611-12, oxide layer shall not craze less than 82°C (120°F)	No visible evidence of Thermal Crazing
Seal Quality	ASTM B680 - Acid Dissolution	AAMA 611-12, max weight loss shall be 40mg/dm <sup>2</sup> (2.6mg/in <sup>2</sup> )	< 20mg/dm <sup>2</sup> (1.3mg/in <sup>2</sup> )
Solar Reflectance Index	ASTM E1980 - Calculation of Solar Reflectance and Thermal Emissivity	Testing based on 6 μm (0.250 mil) film thickness	SRI 6.0

**SECONDARY SERVICES**

- Shearing, Width Capabilities:**  
7" (178mm) - 62" (1575 mm)
- Shearing, Length Capabilities:**  
Up to 192" (4876 mm)
- Shearing, Loading Gauge:**  
Up to 0.080" (2.0 mm)
- Slitting, Width Capabilities:**  
0.75" (19 mm) min
- Slitting, Loading Gauge:**  
Up to 0.100" (2.5 mm)
- Other Secondary Services:**  
Protective peel-able films  
International packaging  
Perforating and embossing

**MAINTENANCE AND CLEANING**

The anodized aluminum finish can be washed with mild soap and water followed by a clean water rinse. For more information on cleaning anodized aluminum, please refer to the Aluminum Association Publication 92, Care of Aluminum or AAMA 609 & 610-09, Cleaning and maintenance guide for architecturally finished aluminum.

**SUSTAINABILITY AND LEED**

- Recycled Content, 5005 alloy:**  
100% recyclable  
Recycled Content, 6.6%  
Reclaimed-Virgin Material, 93.4%  
2012.04.30 Mill16
- Volatile Organic Compounds:**  
The aluminum oxide layer does not contain any VOC's

**AVAILABILITY**

The standard lead time for stocked gauges and widths is two weeks for anodizing and one week for any secondary services such as slitting, shearing and applying transparent protective films or paper.

Please check availability of Non-Stocked materials by contacting our sales staff using our toll free number 800.654.1159 or email your request to [info@lorin.com](mailto:info@lorin.com). Some raw materials may have extended lead times.

**TECHNICAL SUPPORT**

A staff of factory trained personnel are available to offer technical assistance. Please call our toll free number 800.654.1159 or email your question to [info@lorin.com](mailto:info@lorin.com).

**PRODUCT SUPPORT PARTNERS**

Lorin Industries works very closely with many manufacturers' in multiple markets who specialize in anodized aluminum fabrication. Our support staff can assist you if you are looking for finished components. Please call our toll free number 800.654.1159 or email your request for product and application support to [info@lorin.com](mailto:info@lorin.com).

**WARRANTY**

A limited warranty is available upon request. The warranty is issued on a per project basis and can be applied for on line by completing an application for warranty at [Lorin.com](http://Lorin.com).

