



Anodized Aluminum
© Colornodic

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Note: Colors may vary and are limited to commercial tolerances

Clear AC-2



Light Champagne AB-1



Dark Medium Bronze AB-5



Champagne AB-2



Dark Bronze AB-6



Light Bronze AB-3



Standard Dark Bronze AB-7



Light Medium Bronze AB-4



Black AB-8



Arcadia Inc. - Guide Specifications

ARCADIA INC DESIGNATION	TYPE	FINISH DESCRIPTION DESIGNATION	ALUMINUM ASSOCIATION DESIGNATION	AAMA SPECIFICATION
AC-3	COMMERCIAL CLEAR	CLEAR	AA-M12C22A21	
AC-2	CLASS II CLEAR	CLEAR	AA-M12C22A31	AAMA 611
AC-1	CLASS I CLEAR	CLEAR	AA-M12C22A41	AAMA 611
AB-1	COMMERCIAL BRONZE	LIGHT CHAMPAGNE	AA-M12C22A24	AAMA 611
AB-1	CLASS II BRONZE	LIGHT CHAMPAGNE	AA-M12C22A34	AAMA 611
AB-1	CLASS I BRONZE	LIGHT CHAMPAGNE	AA-M12C22A44	AAMA 611
AB-2	COMMERCIAL BRONZE	CHAMPAGNE	AA-M12C22A24	AAMA 611
AB-2	CLASS II BRONZE	CHAMPAGNE	AA-M12C22A34	AAMA 611
AB-2	CLASS I BRONZE	CHAMPAGNE	AA-M12C22A44	AAMA 611
AB-3	COMMERCIAL BRONZE	LIGHT BRONZE	AA-M12C22A24	AAMA 611
AB-3	CLASS II BRONZE	LIGHT BRONZE	AA-M12C22A34	AAMA 611
AB-3	CLASS I BRONZE	LIGHT BRONZE	AA-M12C22A44	AAMA 611
AB-4	COMMERCIAL BRONZE	LIGHT MEDIUM BRONZE	AA-M12C22A24	AAMA 611
AB-4	CLASS II BRONZE	LIGHT MEDIUM BRONZE	AA-M12C22A34	AAMA 611
AB-4	CLASS I BRONZE	LIGHT MEDIUM BRONZE	AA-M12C22A44	AAMA 611
AB-5	COMMERCIAL BRONZE	DARK MEDIUM BRONZE	AA-M12C22A24	AAMA 611
AB-5	CLASS II BRONZE	DARK MEDIUM BRONZE	AA-M12C22A34	AAMA 611
AB-5	CLASS I BRONZE	DARK MEDIUM BRONZE	AA-M12C22A44	AAMA 611
AB-6	COMMERCIAL BRONZE	DARK BRONZE	AA-M12C22A24	AAMA 611
AB-6	CLASS II BRONZE	DARK BRONZE	AA-M12C22A34	AAMA 611
AB-6	CLASS I BRONZE	DARK BRONZE	AA-M12C22A44	AAMA 611
AB-7	COMMERCIAL BRONZE	STANDARD DARK BRONZE	AA-M12C22A24	AAMA 611
AB-7	CLASS II BRONZE	STANDARD DARK BRONZE	AA-M12C22A34	AAMA 611
AB-7	CLASS I BRONZE	STANDARD DARK BRONZE	AA-M12C22A44	AAMA 611
AB-8	CLASS II BLACK	BLACK	AA-M12C22A34	AAMA 611
AB-8	CLASS I BLACK	BLACK	AA-M12C22A44	AAMA 611

NOTE: Class II Anodic finishes have a minimum thickness of .4 mils, Class I Anodic finishes have a minimum thickness of .7 mils

QUALITY CONTROL FOR ARCADIA INC.'S ANODIZED FINISHES (Applies to class II and I anodic finishes only)

The following parameters are tested in accordance with ASTM or ISO test methods:

- A. Anodic Coating Thickness: ASTM B244 or ISO 2360
- B. Anodic Coating Density (applies to exterior architectural applications) : ASTM B137
- C. Anodic Seal Integrity (ADT) : ASTM B680 or ISO 3210



ARCADIA INC.'S ANODIZED FINISH SPECIFICATIONS

Finish: All exposed surfaces of aluminum shall receive an architectural anodized finish (unless a commercial finish is specified) in conformance with Aluminum Association Standard #45. Processing shall be sulfuric acid anodizing with electrolytic deposition of inorganic pigmentation in the coating. The resulting coating shall be continuous, fully sealed and free of powdery surfaces, smut and blemishes.

Etching: Standard etch - medium matte, C22; unless otherwise specified.

Alloy: 6063-T6 is the standard alloy used for extruded architectural aluminum; 5005-H34 must be supplied for sheet and brake metal applications. Arcadia Inc. will not guarantee finish or color range for any other alloys processed. For all other alloys a "best effort" applies.

ARCADIA INC.'S TERMS AND CONDITIONS

Extrusions: Prices are computed per lineal foot and are based on producing finish on exposed areas only. It is our option to process sections back to back unless otherwise specified by the customer and priced accordingly. A minimum perimeter of 5.0 inches is used for price determination. Any perimeter less than 5.0 inches a minimum per foot charge applies, otherwise a solid or hollow inch factor is used.

Lengths processed are 8 through 28 feet, special pricing is used for lengths less than 8 feet and greater than 28 feet (maximum is 30 feet), ask for a quotation.

Racking -Standard end rack within 1" of each end or twist rack, our option. If end racking is used, any damage to the section within the 1" area is acceptable. Twist rack marks will be away from the ends and two or more contacts will be required. Not all sections will accept the pressure of end racking and not all section are adaptable to twist racking. Such sections should be reviewed for an acceptable racking method, special pricing may apply.

Packing - Repack bundles as received, bundles are to be bare, with layer separation, wood battens, steel straps and forklift protection. Bundle size to be 300 lbs. or more. Special packing requires separate pricing.

Sheet, Brake Metal, and Fabricated Parts Prices are computed per square foot or per item where applicable. The anodized finish is on exposed surfaces only. Arcadia Inc., is not liable for costs involved in replacement material resulting from loss or damage sustained from the anodizing process. Replacement material supplied by the customer will be processed at no additional cost.

Size- The maximum width Arcadia Inc. can process is 12", the depth 60" and the length 24'. Any part over 12' long may require additional racking due to its flimsiness. For sheet and brake metal a minimum thickness of 50 mils (0.05 inches) is required for processing.

Racking -Standard 1" rack marks on the ends of the material, some shapes may require additional rack marks due to the configuration of the part or due to the anodizing process itself. Arcadia Inc. is not responsible for lost or damaged material that requires special racking (which includes all rack marks other than the standard 1" end or twist rack marks). The color range is "best effort" only when special racking is required.

Packing - Material will be repacked as received if possible with paper or cardboard separation. Special packing is available upon request at additional cost.