

Aluminum Gutter And Downspout Coil Specifications

MATERIALS

- A. Aleris Rolled Products gutter and downspout coil shall be made from Aleris aluminum sheet, a 3025/3105 alloy, H24 temper aluminum sheet with a minimum tensile strength of 24,000 psi.
- B. Aleris Rolled Products gutter coil shall be made available in two thicknesses: 0.027" and 0.032". The coil is available in widths that can be used to produce both 5-inch and 6-inch K-style gutter on all popular forming equipment:
 - 11.750"
 - 11.875"
 - 15.000"
- C. Aleris Rolled Products downspout coil shall be made available in three thicknesses: 0.016", 0.019" and 0.024". The coil is available in widths that can be used to produce both 2"x 3" and 3"x 4" downspout and type A and B elbows on all popular forming equipment:
 - 10.500" (available in 0.016"& 0.019")
 - 13.750" (available in 0.019"& 0.024")
- D. Prior to factory painting, the metal shall receive a special cleaning process to assure maximum paint adhesion. The exterior will be coated in a two-phase operation that includes a chrome-free corrosion inhibiting pretreatment and a baked-on polyester top coat.

COATINGS

Aleris Rolled Products gutter and downspout coil are coated with an oil-free linear polyester resin system in a wide variety of colors that are specially formulated for building products applications. Coatings are 10°, 30° or 80° gloss, depending upon the color. The coating system is designed for compatibility with environmentally friendly, chrome-free pretreatment systems. This baked on finish offers exceptional forming flexibility, cleanability, stain and mar resistance. The coating has been formulated specifically for superior performance with on-site seamless gutter forming equipment.