

Specification Table

of Steel Composite Sheet

TEST DESCRIPTION	TEST RESULT - PRODUCT QUALITY		
DIMENSION DEVIATION	Length Difference: $\leq \pm 3\text{mm}$		
	Width Difference: $\leq \pm 2\text{mm}$		
	Thickness Difference: $\leq \pm 0.2\text{mm}$ (For 2MM Panel $\leq + 0.2\text{mm}$ only)		
	Diagonal Deviation: $\leq 3\text{mm}$		
	Out of straight at sides: $\leq 1\text{mm/m}$		
	Warp : $\leq 3\text{mm/m}$		
APPEARANCE	Clean surface without swelling flaws, scratches and aberrations		
LUSTER DEVIATION	Face : 0.5/50.0		
	Back : 0.5/50.0		
SURFACE DENSITY (KGS/M ²)	Iribond Steel	3mm - 0.30mm	7.71
PENCIL HARDNESS	$\geq \text{HB}$		
COATING TOUGHNESS	Inner Panel $\leq 3\text{T}$		
ADHESIVE	No less than grade 1		
IMPACT STRENGTH	50Kg/cm Without peeling & cracking of paint		
RESISTANCE TO SOLVENT	Unchanged after cleaning 100 times with dimethylbenzene		
180° PEEL STRENGTH (N/mm)	≥ 9.0		
MODULUS OF ELASTICITY (N/mm ²)	$\geq 78,000$		
SHEAR STRENGTH (Mpa)	≥ 68		
RIGIDITY E x J (kNcm ² /m)	≥ 2300		
TEMPERATURE RESISTANCE	unchanged after -40°C to +80°C 20 cycles		
COEFFICIENT OF HEAT EXPANSION	$\leq 2.00 \times 10^{-5} \text{ } ^\circ\text{C}^{-1}$		
DEFORMATION TEMPERATURE	$\geq 105^\circ\text{C}$		
LINEAR THERMAL EXPANSION	$\leq 2.7 \text{ mm/m}$ at 100° expansion temperature difference		
HEAT TRANSITION COEFFICIENT	5.6 - 5.8 Wm ² k		
0.2% PROOF STRESS	Rp0.2: 110-175 N/mm ²		
SOUND ABSORPTION FACTOR	0.04 - 0.05 Alphas		
AIRBORNE SOUND INSULATION INDEX R _w	23 - 25 dB		
WATER ABSORPTION	$\leq 0.01\%$		

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SURFACE COATING SPECIFICATIONS		
IRIBOND STEEL	Surface Coating	Polyester Paint
	Colour Base	Pigment made in Taiwan
	Coating Thickness	≥ 22.0µm
	Standard Colour	Pure White
	Tolerance of Colour	≤ ± 2.0 ΔE
	Lacquering	2 layers of structural resistant baked lacquer providing optimum rigidity and durability
	Surface Finishing & Glossiness Level	Both sided Matt: 65%
	Tolerance of Glossiness	≤ ± 5.0 %
	Surface Outdoor Durability	5 years (the change of color ≤ 4 NBS)
SHELF LIFE	The product should be used within 12 months from date of production.	
Before starting printing production we recommend a printing test and generation of a specific ICC profile on the individual printing machine.		