

Letter of Certification

6" Half-Round Gutter .027 Gauge Aluminum

Spectra Metal Sales, Inc. is a member of the National Coil Coating Association and uses the NCCA's standards as guidelines for physical testing.

- Follow ASTM B209 standards for metal chemical composition and mechanical properties
- The Aluminum used is alloy 3105-H24 or 3105-H25 which meets the specifications set forth in the "Aluminum Standards and Data 2024" published by the Aluminum Association. The finished gauge of the Aluminum for this coil is .027, +/- .002. The 3105 alloy is building sheet grade consisting of approximately 97% recycled materials
- The Aluminum's inside and outside coating is a thermo polyester paint which is roll coated and baked per manufactures specifications.
- The paint specifications used for our aluminum gutter coil are as follows:

Top Dry Film Thickness:	.65 +/- .05 mils
Gloss (60°):	10 +/- 2 Units (varies by color)
Solvent Resistance:	100 Double rubs (M.E.K.)
Flexibility:	.027 (+/- .002) 2 T Bend minimum
Impact (N.T.O.):	1-1/2 Times metal thickness in Inch-Lbs (ASTM D 2794)
Pencil Hardness:	F - 2H
Humidity Resistance:	No blistering, loss of adhesion after 1,000 hours exposure to 100% relative humidity. (ASTM D 2247)
Salt Spray Resistance:	No field blistering and no more than 1/16" creep from a score line after neutral salt spray testing for 1,000 Hours (ASTM B 117)

