

# DIN EN 1396:2023-10 (E)

## Aluminium and aluminium alloys - Coil coated sheet and strip for general applications - Specifications

---

<b>Contents</b>		<b>Page</b>
European foreword .....		4
Introduction .....		5
1	Scope .....	6
2	Normative references .....	6
3	Terms and definitions .....	6
4	Technical conditions for inspection and delivery .....	8
4.1	Ordering information .....	8
4.2	Requirements .....	10
4.2.1	Production and manufacturing processes .....	10
4.2.2	Quality control .....	10
4.2.3	Freedom from defects .....	11
4.2.4	Chemical composition .....	11
4.2.5	Mechanical properties .....	11
4.2.6	Tolerances on shape and dimensions .....	11
4.2.7	Coating properties .....	11
4.3	Test procedures .....	11
4.3.1	Chemical composition .....	11
4.3.2	Tensile test .....	11
4.3.3	Coating tests .....	12
4.3.4	Retests .....	12
5	Mechanical properties .....	12
6	Organic coating properties .....	15
6.1	Tolerances on thickness .....	15
6.2	Tolerances on gloss .....	16
6.3	Tolerances on colour .....	17
7	Inspection documents .....	17
8	Marking .....	17
9	Packing .....	18
10	Arbitration tests .....	18
Annex A (normative) Rules for rounding .....		19
Annex B (informative) Examples of coating systems .....		20
Annex C (informative) Guidelines for organic coatings .....		22
C.1	General .....	22
C.2	Colour .....	22
C.3	Flexibility .....	22
C.4	Adhesion .....	23

<b>C.5</b>	<b>Pencil hardness .....</b>	<b>24</b>
<b>C.6</b>	<b>Durability of the organic coating .....</b>	<b>24</b>
<b>C.6.1</b>	<b>General .....</b>	<b>24</b>
<b>C.6.2</b>	<b>Corrosion resistance (outdoor exposure) .....</b>	<b>26</b>
<b>C.6.3</b>	<b>UV resistance .....</b>	<b>27</b>
<b>C.6.4</b>	<b>Humidity and water immersion resistance (accelerated tests) .....</b>	<b>29</b>
<b>C.6.5</b>	<b>Acetic acid salt spray fog resistance (accelerated corrosion test) .....</b>	<b>29</b>
<b>C.6.6</b>	<b>Filiform corrosion test, FFC (accelerated corrosion test) .....</b>	<b>30</b>
<b>Annex D (informative) Guidelines for storage and subsequent processing .....</b>		<b>31</b>
<b>D.1</b>	<b>Storage .....</b>	<b>31</b>
<b>D.2</b>	<b>General instructions for processing .....</b>	<b>31</b>
<b>D.3</b>	<b>Forming .....</b>	<b>31</b>
<b>D.4</b>	<b>Cutting .....</b>	<b>31</b>
<b>D.5</b>	<b>Joining .....</b>	<b>32</b>
<b>D.6</b>	<b>Cleaning .....</b>	<b>32</b>
<b>D.7</b>	<b>Temporary protective films .....</b>	<b>32</b>
<b>Bibliography .....</b>		<b>33</b>