



Test Parameter	AAMA 2603	AAMA 2604	AAMA 2605 and ASCA 96
Pretreatment Requirements			
Metal preparation and pretreatment	Multi-Stage cleaning and pretreatment	Multi-Stage cleaning and pretreatment	Multi-Stage cleaning and pretreatment
Pretreatment Type	Chemical conversion coating	Chrome or non-chrome chemical conversion coating	amorphous chromium phosphate or amorphous chromate treatment
Pretreatment coating weight	None specified	chrome=30 mg/ft ² minimum; non-chrome per supplier's specification	chrome=40 mg/ft ² minimum
Paint Film Requirements			
Dry Film Thickness	0.8 mils minimum	1.2 mils (for multicoat, 1.0 mil topcoat minimum & 0.3 +/- 0.1 mil primer)	1.2 mils (for multicoat, 1.0 mil topcoat minimum & 0.3 +/- 0.1 mil primer) (None specified under ASCA 96)
Sealant Compatibility	meets AAMA 800	meets AAMA 800	meets AAMA 800
Color Uniformity	within established color range	within established color range	within established color range
Specular Gloss	+/- 5 units of specification (high=80+, medium=20-79, low£19)	+/- 5 units of specification (high=80+, medium=20-79, low£19)	+/- 5 units of specification (high=80+, medium=20-79, low£19)
Dry film hardness	H minimum	F minimum	F minimum
Adhesion Requirements			
Dry Adhesion	0% failure (no loss)	0% failure (no loss)	0% failure (no loss)
Wet Adhesion	0% failure (no loss)	0% failure (no loss)	0% failure (no loss)
Boiling Water Adhesion	None specified	0% failure (no loss)	0% failure (no loss)
Impact	No removal of film	No removal of film	No removal of film from substrate



Resistance	from substrate	from substrate	
Abrasion Resistance	None specified	abrasion coefficient value = 20 minimum	abrasion coefficient value = 40 minimum

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Chemical Resistance Requirements			
Muriatic Resistance	15-minute exposure: no blistering or visual change	15-minute exposure: no blistering or visual change	15-minute exposure: no blistering or visual change
Mortar Resistance	24-hour exposure: no loss of film adhesion or visual change	24-hour exposure: no loss of film adhesion or visual change	24-hour exposure: no loss of film adhesion or visual change
Nitric Acid Resistance	None specified	30-minute exposure: 5 Delta E (Hunter) maximum color change	30-minute exposure: 5 Delta E (Hunter) maximum color change
Detergent Resistance	72-hour exposure: no loss of adhesion, no blistering, no significant visual change	72-hour exposure: no loss of adhesion, no blistering, no significant visual change	72-hour exposure: no loss of adhesion, no blistering, no significant visual change
Window Cleaner Resistance	None specified	24-hour exposure: no blistering or appearance change	24-hour exposure: no blistering or appearance change (none specified under ASCA 96)
Corrosion Resistance Requirements			
Humidity Resistance	1,500 hours: no more than "few" blisters size 8, figure no. 4, ASTM D 714	3,000 hours: no more than "few" blisters size 8, figure no. 4, ASTM D 714	4,000 hours: no more than "few" blisters size 8, figure no. 4, ASTM D 714
Salt Spray Resistance	1,500 hours of salt solution: minimum rating of 7 on scribe or cut edges; minimum blister rating of 8 in the field (ASTM D 1654)	3,000 hours of salt solution: minimum rating of 7 on scribe or cut edges; minimum blister rating of 8 in the field (ASTM D 1654)	4,000 hours of salt solution: minimum rating of 7 on scribe or cut edges; minimum blister rating of 8 in the field (ASTM D 1654)



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Weathering Resistance Requirements			
Accelerated Exposure	1,000 hours in Atlas Type ``XW" weatherometer: no adhesion loss; slight chalking or color change	None specified	None specified
Outdoor Exposure	1 year South Florida, 45m south: no adhesion loss; slight chalking or fading	5 years South Florida, 45m south: 5 Delta E (Hunter) maximum color change; chalking < 8 (ASTM D 4214); gloss retention > 30%; erosion resistance < 10% film loss	10 years South Florida, 45m south: 5 Delta E (Hunter) maximum color change; chalking < 8 (ASTM D 4214), gloss retention > 50%; erosion resistance < 10% film loss