

GUARANTEE

► BENDING RADIUS

- Mirawall is guaranteed for **1T** according to **EN 1396**
(Bending radius = thickness of aluminium)
- The rules have to be respected by the user, especially the choice of the Die- radius according to the sheet thickness

► OTHER BENDING (OT)

- After selection of all components, in particular the aluminium alloy, Mirawall could be suitable for OT bending
- Please contact Miralu in advance
- Previous tests for validation of bending conditions have to be made by the user

THICKNESS	V-DIE	V8	V10	V12	V14	V16	V18
1 mm	≥ 1.0 mm						
1.5 mm	≥ 1.5 mm						
2.0 mm	≥ 2.0 mm						

- Recommended ■ Not recommended
- Lower V-Die tests are possible subject to prior testing at your discretion.

► RESISTANCE TO FAST FORMING

impact test ISO 6272
10 Nm, For saturated colors 5 Nm

► RESISTANCE TO CORROSION

- EN 1396
- Good corrosion resistant
 - Classified **RC2** (classification after Acetic Salt Spray tests 1000h and Exposure in natural environment in Hook Van Holland, Netherlands)

► SCRATCH RESISTANCE ISO 1518-4

H

► PAINT ADHESION ISO 2409

Paint adhesion test on aluminium: **Class 0**
(no pick off)

► TRACEABILITY

- Traceability from the supplier's batch to the delivered batch.
- Traceability reinforced: marking every meter on the back side

► MILLS CONTROL CERTIFICATES ON REQUEST type EN 10204 3.1

REGULATORY CONFORMITY

Miralu guarantees:

- **REACH:** No substance listed in the XIV Reach appendix is present in our production and in our purchases
- **ROHs:** No listed substance is present in our production
No Lead, Mercury, Cadmium, hexavalent Chromium, polybromobiphenyls (PBB), polybromodiphenyléthers (PBDE).

RAW MATERIAL

► ALLOYS EN 573-3, EN 515, EN 482-2, EN 482-4

3000, 4000, 5000 ■ 100% recycled "green" alloy on request ■ Widths: **1000, 1250, 1500 and 1600 mm** (others on request) ■ Thicknesses: **6/10 to 20/10 mm**

► POWDER EN 1396

Polyester powder coated. Without COV, without lead, without Chromium

► PROTECTIVE FILM

Polyethylene **Transparent** (70µm) ■ Polyethylene **Black & white** (70µm) ■ Polyethylene Black & white (105µm) **suitable for Laser Cutting** (Co2 and Fiber) on request and after tests carried out by the customer.

FRONT SIDE

► TREATMENT

- Double degreasing, rinsing, conversion coating
- Based on Titanate
- Without Chromium
- Thickness thinner than a micron

► COATING

Polyester powder coated

► PAINT THICKNESS

- ISO 2360, according to COFRAC - EN 1396 table 3
- Average 60 µm

► ASPECT

- Uniformity of colour, gloss and Regular aspect
- Orange peel texture.
- Without checkerboard effects

► PLAIN COLOURS, METALLIC AND SPECKLED COLOURS

ISO 2813, EN 1396 table 4, according to COFRAC

- **High gloss** : 70 to 100 UB (+/- 5 UB)
- **Satin** : 30 to 70 UB (+/- 5 UB)
- **Matt** : 20 to 30 UB (+/- 5 UB)

► COLOUR CHARTS

- RAL 841GL, RAL 840HR, Pantone, NCS
- 400 colours available, others on request

► COLOURS

ISO 3668, according to COFRAC / EN 1396 annexe C

- MIRALU guarantees the continuity of gloss and colour between batches and deliveries

BACK SIDE

► TYPE

TOC - Thin Organic Coating

► SUBSTANCE

- Based on Titanate
- Without Chromium
- Without Volatile Organic Coating

► THICKNESS : 1 - 1.5 µm

► BENDING: Suitable for bending

► CHARACTERISTICS

- Extra corrosion resistance of the back side
- Low friction for a better handling of sheets
- Suitable for gluing (after tests carried by customer)

TECHNICAL CHARACTERISTICS

► FINISHED PRODUCTS

- Coils (with cardboard core: ø 498 mm, without cardboard core: ø 508 mm)
- Sheets

► SHEET LENGTHS

From 600 mm to 10 000 mm

GUARANTEE

► BENDING RADIUS

- MiraBuild is guaranteed for **1.5T** according to **EN 1396**
(Bending radius = thickness of aluminium)
- The rules have to be respected by the user, especially the choice of the Die- radius according to the sheet thickness

THICKNESS	V-DIE	V10	V12	V14	V16
1 mm	≥ 1.0 mm				
1.5 mm	≥ 1.5 mm				
2.0 mm	≥ 2.0 mm				

- ☐ Recommended ☒ Not recommended
- Lower V-Die tests are possible subject to prior testing at your discretion.

► RESISTANCE TO FAST FORMING

impact test ISO 6272

10 Nm, For saturated colors 5 Nm

► RESISTANCE TO CORROSION

EN 1396

- Good corrosion resistant
- Classified **RC2** (classification after Acetic Salt Spray tests 1000h and Exposure in natural environment in Hook Van Holland, Netherlands)

► SCRATCH RESISTANCE ISO 1518-4

H for pearly finish and 3H for textured finish

► PAINT ADHESION ISO 2409

Paint adhesion test on aluminium: **Class 0** (no pick off)

► TRACEABILITY

- Traceability from the supplier's batch to the delivered batch.
- Traceability reinforced: marking every meter on the back side

► MILLS CONTROL CERTIFICATES ON REQUEST type EN 10204 3.1

REGULATORY CONFORMITY

Miralu guarantees:

- **REACH:** No substance listed in the XIV Reach appendix is present in our production and in our purchases
- **ROHS:** No listed substance is present in our production
No Lead, Mercury, Cadmium, hexavalent Chromium, polybromobiphenyles (PBB), polybromodiphenyléthers (PBDE).

RAW MATERIAL

► ALLOYS

EN 573-3, EN 515, EN 482-2, EN 482-4

4000, 5000 ■ 100% recycled "green" alloy on request ■ Widths: **1000, 1250, 1500 & 1600** mm (others on request) ■ Thicknesses: **6/10 to 20/10** mm

► POWDER EN 1396

Polyester powder coated

Without COV, without lead, without Chromium

► PROTECTIVE FILM

Polyethylene for pearly finishes

Transparent (70µm) ■ **Black & white** (70µm) ■ Black & white (105µm) **suitable for Laser Cutting** (Co2 and Fiber) on request and after tests carried out by the customer.

Polyethylene for textured finishes

Transparent (80µm) ■ **Black & white** (100µm) ■ Black & white (105µm) **suitable for Laser Cutting** (Co2 and Fiber) on request and after tests carried out by the customer.

FRONT SIDE

► TREATMENT

- Double degreasing, rinsing, conversion coating
- Based on Titanate
- Without Chromium
- Thickness thinner than a micron

► COATING

Polyester powder coated

► PAINT THICKNESS

ISO 2360, according to COFRAC - EN 1396 table 3

- Average 60 µm

► FINISHES

- Pearly
- Textured
- Wrinkled
- Copper-colored
- Iridescent

► ASPECT

- Uniformity of colour, gloss and Regular aspect
- Without checkerboard effects
- For pearly finish: orange peel texture.

► TEXTURED FINISHES

- 5 to 10 UB (+/- 3 UB)

► PEARLY FINISHES

ISO 2813, EN 1396 table 4, according to COFRAC

- **High gloss** : 70 to 100 UB (+/- 5 UB)
- **Satin** : 30 to 70 UB (+/- 5 UB)
- **Matt** : 20 to 30 UB (+/- 5 UB)

► COLOURS

ISO 3668, according to COFRAC / EN 1396 annexe C

- MIRALU guarantees the continuity of gloss and colour between batches and deliveries

BACK SIDE

► TYPE

TOC - Thin Organic Coating

► SUBSTANCE

- Based on Titanate
- Without Chromium
- Without Volatile Organic Coating

► THICKNESS : 1 - 1.5 µm

► BENDING: Suitable for bending

► CHARACTERISTICS

- Extra corrosion resistance of the back side
- Low friction for a better handling of sheets
- Suitable for gluing (after tests carried by customer)

TECHNICAL CHARACTERISTICS

► FINISHED PRODUCTS

- Coils (with cardboard core: ø 498 mm, without cardboard core: ø 508 mm)
- Sheets

► SHEET LENGTHS

From 600 mm to 10 000 mm

GUARANTEE

► BENDING RADIUS

- MiraForté is guaranteed for **1.5T** according to **EN 1396**

(Bending radius = thickness of aluminium)

- The rules have to be respected by the user, especially the choice of the Die - radius according to the sheet thickness

THICKNESS	V-DIE	V25	V35
2.5 mm	≥ 2.5 mm		
3.0 mm	≥ 3.0 mm		

■ Recommended

■ Not recommended

- Lower V-Die tests are possible subject to prior testing at your discretion.

► RESISTANCE TO FAST FORMING

Impact test ISO 6272

10 Nm, For saturated colors 5 Nm

► RESISTANCE TO CORROSION

EN 1396

- Good corrosion resistant
- Classified **RC2** (classification after Acetic Salt Spray tests 1000h and Exposure in natural environment in Hook Van Holland, Netherlands)

► SCRATCH RESISTANCE ISO 1518-4

H

► PAINT ADHESION ISO 2409

Paint adhesion test on aluminium: **Class 0** (no pick off)

► TRACEABILITY

- Traceability from the supplier's batch to the delivered batch.
- Traceability reinforced: marking every meter on the back side

► MILLS CONTROL CERTIFICATES ON REQUEST type EN 10204 3.1

REGULATORY CONFORMITY

Miralu guarantees:

- REACH:** No substance listed in the XIV Reach appendix is present in our production and in our purchases
- ROHs:** No listed substance is present in our production
No Lead, Mercury, Cadmium, hexavalent Chromium, polybromobiphenyls (PBB), polybromodiphenyléthers (PBDE).

RAW MATERIAL

► ALLOYS EN 573-3, EN 515, EN 482-2, EN 482-4

3000, 4000, 5000 ■ 100% recycled "green" alloy on request ■ Widths: **1000, 1250, 1500 and 1600** mm (others on request) ■ Thicknesses: **25/10 & 30/10** mm

► POWDER EN 1396

Polyester powder coated. Without COV, without lead, without Chromium

► PROTECTIVE FILM

Polyethylene **Transparent** (70µm) ■ Polyethylene **Black & white** (70µm) ■ Polyethylene Black & white (105µm) **suitable for Laser Cutting** (Co2 and Fiber) on request and after tests carried out by the customer.

FRONT SIDE

► TREATMENT

- Double degreasing, rinsing, conversion coating
- Based on Titanate
- Without Chromium
- Thickness thinner than a micron

► COATING

Polyester powder coated

► PAINT THICKNESS

ISO 2360, according to COFRAC - EN 1396 table 3

- Average 60 µm

► ASPECT

- Uniformity of colour, gloss and Regular aspect
- Orange peel texture
- Without checkerboard effects

► PLAIN COLOURS, METALLIC AND SPECKLED COLOURS

ISO 2813, EN 1396 table 4, according to COFRAC

- High gloss** : 70 to 100 UB (+/- 5 UB)
- Satin** : 30 to 70 UB (+/- 5 UB)
- Matt** : 20 to 30 UB (+/- 5 UB)

► COLOUR CHARTS

- RAL 841GL, RAL 840HR, Pantone, NCS
- 400 colours available, others on request

► COLOURS

ISO 3668, according to COFRAC / EN 1396 annexe C

- MIRALU guarantees the continuity of gloss and colour between batches and deliveries

BACK SIDE

► TYPE

TOC - Thin Organic Coating

► SUBSTANCE

- Based on Titanate
- Without Chromium
- Without Volatile Organic Coating

► THICKNESS : 1 - 1.5 µm

► BENDING: Suitable for bending

► CHARACTERISTICS

- Extra corrosion resistance of the back side
- Low friction for a better handling of sheets
- Suitable for gluing (after tests carried by customer)

TECHNICAL CHARACTERISTICS

► FINISHED PRODUCTS

- Coils (with cardboard core: ø 498 mm, without cardboard core: ø 508 mm)
- Sheets

► SHEET LENGTHS

From 600 mm to 10 000 mm

GUARANTEE

► BENDING RADIUS

- MiraSea is guaranteed for **1T** according to **EN 1396**
(Bending radius = thickness of aluminium)
- The rules have to be respected by the user, especially the choice of the Die-radius according to the sheet thickness

THICKNESS	V-DIE	V8	V10	V12	V14	V16	V18
1 mm	≥ 1.0 mm	■	■	■	■	■	■
1.5 mm	≥ 1.5 mm	■	■	■	■	■	■
2.0 mm	≥ 2.0 mm	■	■	■	■	■	■

■ Possible sous conditions ■ Possible

- Lower V-Die tests are possible subject to prior testing at your discretion.

► RESISTANCE TO FAST FORMING

impact test ISO 6272

10 Nm, For saturated colors 5 Nm

► RESISTANCE TO CORROSION

EN 1396

- Extra corrosion resistant
- Classified **RC3** (classification after Acetic Salt Spray tests 1000h and Exposure in natural environment in Hook Van Holland, Netherlands)

► SCRATCH RESISTANCE ISO 1518-4

H

► PAINT ADHESION ISO 2409

Paint adhesion test on aluminium: **Class 0** (no pick off)

► TRACEABILITY

- Traceability from the supplier's batch to the delivered batch.
- Traceability reinforced: marking every meter on the back side

► MILLS CONTROL CERTIFICATES ON REQUEST

type EN 10204 3.1

REGULATORY CONFORMITY

Miralu guarantees:

- **REACH:** No substance listed in the XIV Reach appendix is present in our production and in our purchases
- **ROHS:** No listed substance is present in our production
No Lead, Mercury, Cadmium, hexavalent Chromium, polybromobiphenyles (PBB), polybromodiphenyléthers (PBDE).

RAW MATERIAL

► ALLOYS EN 573-3, EN 515, EN 482-2, EN 482-4

5000 or equivalent ■ Widths: **1000, 1250, 1500 & 1600** mm (others on request) ■ Thicknesses: **6/10 to 20/10** mm

► POWDER EN 1396

Polyester powder coated. Without COV, without lead, without Chromium

► PROTECTIVE FILM

Polyethylene **Transparent** (70µm) ■ Polyethylene **Black & white** (70µm) ■ Polyethylene Black & white (105µm) **suitable for Laser Cutting** (Co2 and Fiber) on request and after tests carried out by the customer.

FRONT SIDE

► TREATMENT

- Double degreasing, etching on demand, protective primer
- Without Chromium
- Thickness thinner than 4 µm

► COATING

Polyester powder coated

► PAINT THICKNESS

ISO 2360, according to COFRAC - EN 1396 table 3

- Average 60 µm

► ASPECT

- Uniformity of colour, gloss and Regular aspect
- Orange peel texture.
- Without checkerboard effects

► PLAIN COLOURS, METALLIC AND SPECKLED COLOURS

ISO 2813, EN 1396 table 4, according to COFRAC

- **High gloss** : 70 to 100 UB (+/- 5 UB)
- **Satin** : 30 to 70 UB (+/- 5 UB)
- **Matt** : 20 to 30 UB (+/- 5 UB)

► COLOUR CHARTS

- RAL 841GL, RAL 840HR, Pantone, NCS
- 400 colours available, others on request.

► COLOURS

ISO 3668, according to COFRAC / EN 1396 annexe C

- MIRALU guarantees the continuity of gloss and colour between batches and deliveries

BACK SIDE

► TYPE

Back Coat

► SUBSTANCE

- Without Chromium
- Without Volatile Organic Coating

► THICKNESS : 5 - 7 µm

► BENDING: Suitable for bending

► CHARACTERISTICS

- Extra corrosion resistance of the back side
- Suitable for gluing (after tests carried by customer)

TECHNICAL CHARACTERISTICS

► FINISHED PRODUCTS

- Coils (with cardboard core: ø 498 mm, without cardboard core: ø 508 mm)
- Sheets

► SHEET LENGTHS

From 600 mm to 10 000 mm