

## AAMA Standards Comparison - Organic Coatings on Aluminum Extrusions and Panels

Attribute	AAMA 2603-13 (Pigmented Coatings)	AAMA 2604-13 (High Performance Coatings)	AAMA 2605-13 (Superior Coatings)
Minimum Initial Dry Film Thickness	> 20 microns (0.8 mil) for 80% of measurements, >17 microns (0.68 mil) or 85% of film thickness specified	> 30 microns (1.2 mil) for 80% of measurements, >25 microns (0.68 mil) or 85% of film thickness specified.	> 30 microns (1.2 mil) for 80% of measurements, > 25 microns (1.0 mil) or 85% of film thickness specified.
Specular Gloss (per ASTM D 523)	Within + 5 units of manufacturer's recommended values		
Outdoor Weathering Exposure Time	1 year, South Florida	5 years, South Florida	10 years, South Florida
Chalking Resistance (After Weather Exposure) (ASTM D 4214, Met. A)	Slight Change Allowed	5 years: Chalk < 8 rating	10 years: Chalk < 8 rating for colors, <6 rating for white
Color Retention(After Weather Exposure)	Slight Change Allowed	5 year fade: delta E <=5	10 year fade: delta E <= 5
Gloss Retention (After Weathering)	Slight Change Allowed	5 years >= 30% retention	10 years >= 50% retention
Erosion Resistance (After Weathering)	No Specification	5 years < 10% loss	10 years < 10% loss
Impact Resistance	No film removal from Substrate at initial test (not subject to weathering exposure)		
Humidity Resistance (per ASTM D 2247 or D 4585)-no visually apparent change and few" blisters < size 8 per ASTM D 968"	1500 hr at 100°F & 100% humidity	3000 hr at 100°F & 100% humidity	4000 hr at 100°F & 100% humidity
Chrome Pretreatment	No Specification	If used, >= 30 mg/ft2 by weight	If used, >= 40 mg/ft2 by weight
Abrasion Resistance (per ASTM D 968)	No Specification	Abrasion Coefficient >=20	Abrasion Coefficient >= 40
Salt Spray Corrosion Resistance (per ASTM B117)	1500 hr < 8 blisters, > 7 scribe	3000 hr < 8 blisters, > 7 scribe	N/A
Salt Spray Corrosion Resistance (per ASTM G85, Annex A5)	N/A	N/A	2000 hr < 8 blisters, > 7 scribe
Chemical Resistance	No loss of adhesion, blistering or visually apparent change after exposure to muriatic acid, mortar and detergent	No loss of adhesion, blistering or visually apparent change after exposure to muriatic acid, mortar, detergent, window cleaner and nitric acid	
Sealant Compatibility	Sealant must meet AAMA 800 and have no effect on coating		
Boiling Water Film Adhesion	No Specification	No loss of adhesion after 20 minutes in 212°F water	
Color Uniformity	No variation outside of limits established by color range sample approval		
Dry Film Hardness	"H" Minimum. No rupture when tested per ASTM D 3363.	"F" Minimum. No rupture when tested per ASTM D 3363.	
Dry & Wet Film Adhesion	Meet requirements of ASTM D 3359.		
T-Bend Test for Coating Flexibility	No Specification	Minimum of 2-T flexibility with no pick-off at the area of the bend.	

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