

TECHNICAL
BULLETIN

AAF

AUSTRALIAN ALUMINIUM FINISHING

aafonline.com.au

FINISHING CONTACT MARKS & HANGING HOLES

Contact or “Jig” & “Rack” marks are the result of holding the metal part in place so they can be carried through the finishing process.

The essential function of “Jigging/Racking” the part is that it secures the part & prevents it from falling due to agitation & other physical pressures sustained in the various Powder Coat or Anodising stages. Secondly, electrochemical processes such as anodising also need reliable contact to allow the required amount of electrical current to safely pass from the rack to each part.

There are a multitude of factors which affect the ideal number, size & location of contact marks. However, ultimately, it’s a matter of experience & judgment with due consideration to the following;

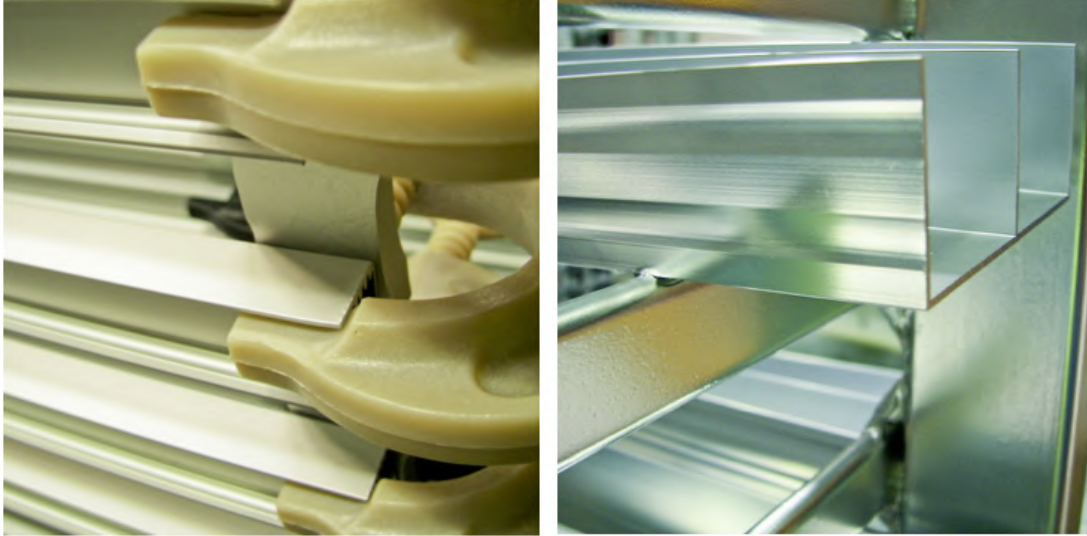
- Very firm part to rack contact, for sufficient contact surface area & avoid contact “burns”
- Size, length & weight of the metal part
- The structural rigidity of the part & risk to falling, bowing & liquid entrapment
- Part orientation to best provide finishing to the visible faces
- The profile/part design & risk of gas/liquid entrapment
- Sensitivity of work surfaces to damage from clamping

Generally, industry practice has been that a 50mm allowance be made from each end for extrusion contact marks. Typically, thereafter, the fabricator would cut-off the ends of the extrusion, before fabrication.

With sheet product (sheets, pressings, flats...etc.), it is advisable that you provide your product with pre-drilled holes to allow us to hang from. A minimum of two holes at each top corner is required if it is a 1200mm wide sheet. If narrower than 600mm wide, then an additional two holes in the bottom corners is also required. If you are unsure of the best place to position the hanging holes, please contact us and we are only happy to assist. Sheet product supplied without hanging holes may incur a surcharge if we are to provide the hanging holes in order to process your order.

In considering the list above & consistent with good practice, AAF endeavours to keep the size & number of contact marks to an absolute minimum, and would position them;

- On non-visible surfaces (marked on your part drawing) wherever possible
- Otherwise, On visible surfaces, as close as possible to the ends of the part
- On occasion, with parts that are less structurally rigid, middle jig support may also be required



SPECIFIC CONTACT MARK REQUIREMENTS?

Do you have a specific requirement concerning contact marks outside of the industry practice mentioned above?

Before having your parts finished, it's imperative you contact your AAF representative to discuss further. They will only be too happy to suggest ideas that may be mutually suitable. Once agreed, we can have these instructions encoded in our on-line drawing system, so that each time you place an order, you can be confident that any special instructions are there to be followed.

If not specified on a drawing & agreed, the racking method & contact areas are chosen at our discretion, obviously consistent with good practice as mentioned above.

NOTE

Details contained herewith do not constitute specific advice, merely they are provided as a matter of courtesy and as general information only. You should seek your specialist's advice, to ensure that any information or suggestion meet your specific requirements. Reference should be made to the respective standards for the finish concerned as well as Australian Aluminium Finishing Pty Ltd (AAF) Terms and Conditions of Sale. Latest releases of Australian Standards are available for purchase via the following website; www.standards.com.au

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