TB 105 — Finishing Contact Marks

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AAF

ARCHITECTURAL ANODISED FINISHES

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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 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 of 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***

Allow 50 mm at each extrusion end for contact marks, subject to confirmation with AAF for your profile before ordering or cutting. The fabricator would typically trim these ends before fabrication.

For sheet, pressings and flats, confirm the hole count, diameter, positions and edge distances with AAF before drilling. Requirements depend on the part's size, thickness and weight. Additional support may be required to secure the part during processing. Contact AAF if you need assistance. 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 finishing, contact AAF to agree any special racking, contact-mark or hanging-hole requirements in writing. Mark significant surfaces and permitted contact areas on the current part drawing. Include the agreed drawing and instructions with each order, including repeat orders.

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 suggestions meet your specific requirements. Reference should be made to the respective standards for the finish concerned as well as Architectural Anodised Finishes Pty Ltd (AAF) Terms and Conditions of Sale. Latest releases of Australian Standards are available for purchase via the following website; www.standards.org.au

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