



eTEC ACM 1D is a versatile range of aluminium composite panels, the high-quality matt white painted surface on one side, has excellent ink adhesion and colour reproduction qualities; enabling the production of truly eye-catching signage, retail displays, interior decorations, advertising and so much more.

ACP DIMENSIONS

TEST ITEM	STANDARD
Total Thickness	3mm
Aluminium Skin Thickness	0.15mm
Standard Sizes	1220x2440, 1500x3050

DIMENSIONAL TOLERANCES

Panel Thickness	±0.2mm
Aluminium Thickness	±0.02mm
Width	-0mm/+2mm
Length	-0mm/+4mm
Diagonal	±5mm

SURFACE PROPERTIES

Paint	PE(Polyester)
Paint Thickness	17 ±1 μ m
Pencil Hardness	≥2H
Toughness of Coating	≤3T
Impact Strength	30kg*cm (No crack in Paint)
Adhesion Force	100/100 No peel
Boiling Water Resistance	Boiled for 2 hours without change
Solvent Resistance	Cleaned 200 times with Dimethylbenzene without change
Cleaning Resistance	>1000 times without change
Peel Strength 180°	≥3N/mn

PRODUCT PROPERTIES

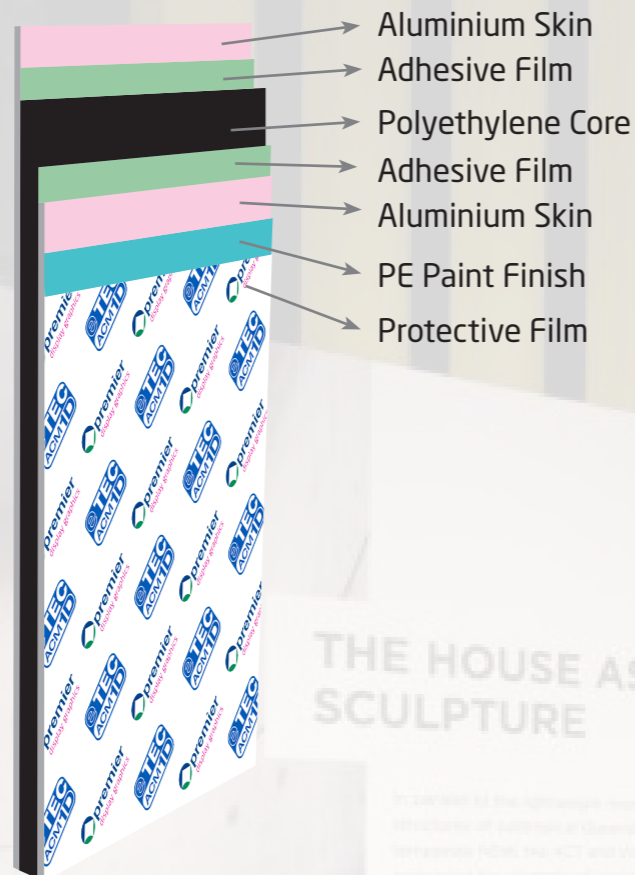
Weight (kg/m ²)	3.82kg/m ²
Core Composition	Polyethylene

The above information is given for general guidance only and is subject to change without notice.



Product Structure

ETEC ACM 1D is composed of two aluminium sheets and a polyethylene core that are laminated in a continuous process at high temperatures.



Drilling

ETEC ACM 1D can be easily drilled.

For optimum results please ensure that drill bits that have been specifically designed for use on aluminium and plastic are used.

For larger holes, a drill bit with a location point is required.

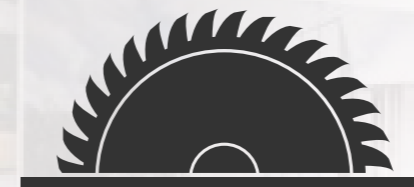
- Cutting Angle: 100° - 140° (Helix Angle: 30° - 50°)
- Cutting Speed: 50 - 300 m/min
- Feed Speed: 0.02 - 0.5mm/Revolution
- Hole Size: Screw Width +2mm



Sawing & Cutting

It is easy to cut ETEC ACM 1D, follow the guidelines below for optimum results.

- Circular Saw: Trapezoidal / Flat Tooth Blade
Flat Teeth Chamfered at 45°
Carbide Tipped
- Saw Blade Diameter: 250-300mm
- Number of Teeth: 72 minimum
- Tooth Thickness: 3.2mm
- Clearance Angle: 15°
- Rake Angle: 10° Positive



Routing

ETEC ACM 1D can be cut using conventional routers on CNC milling machines.

Sharp tools must be used in order to avoid damaging the edge of the material.

- Cutting Speed: 3000-5000m/min
- Feed Speed: 25-30m/min

