



From fax: 404 350-0581

Southern Aluminum Finishing Company, Inc.

Dear Valued Customer:

Thank you for using Southern Aluminum Finishing for your anodizing requirements. In an effort to serve you better, we have compiled a checklist for fabricating rails prior to anodizing or painting. Some of the following conditions require premium pricing:

√ **The most important thing is that rails and assemblies must have drainage holes to prevent solution from getting trapped. These holes must be a minimum of 3/8" in diameter.** Drill holes at each horizontal and vertical connection to allow draining and submerging into tanks. Top holes are required for admission of air, and bottom holes are required for drainage. Anodizing and paint pretreatment chemicals can leak through even the tightest welded joints. (See sketch attached)

√ Always be sure use anodizing quality aluminum. Anodizing requires 6063T5 or T6 for extrusion and 5005 for sheet.

√ Welds will vary in color from the rail extrusion when anodized. For best results, use 5356 alloy welding rod to fabricate welded handrails. Avoid 4043 because it turns black when anodized.

√ Rails and assemblies should never include non-aluminum materials.

√ Anodizing and painting surface quality is dependent on the metal we start with. Anodizing does not cover up scratches or water. Painting hides a little better, but does not always work either. Sometimes our customers try to smooth rails by sanding. This is often a disaster with anodizing because it is impossible to manually apply uniform pressure while sanding. What might look uniform after sanding or buffing will usually look blotchy and horrible after anodizing. It is best to use utmost care when fabricating. Make sure everyone who comes in contact with the metal wears gloves.

√ Rails that are radiused with turn-backs greater than 18 inches, or pieces greater than 100 pounds each are subject to premium pricing.

√ Any section higher than 5 feet, wider than 20 inches, longer than 28 feet, or shorter in length than 5 feet will require special handling or may not fit in our tanks. Please call.

√ Any two flat surfaces sandwiched together may present a problem due to seepage of pretreatment chemicals.

√ Any type of frame, grille, tread-plate, or louver or small parts (anything shorter than 36 inches) require special handling.

√ Tubes with an outside perimeter of greater than or equal to 20 inches are also subject to premium pricing.

Please contact our Customer Consultants at 800-241-7429 anytime you have a question.

Very Truly Yours,

Southern Aluminum Finishing Company, Inc.

