



# SEAMLESS ALUMINIUM group

## Product Data Sheet : Swaged Round Downpipe

### Product Description:

Seamless Aluminum Group’s range of heavy duty Extruded Downpipes are designed and manufactured to provide the essential architectural features appropriate to traditionally and Modern designed buildings. Our Systems can be used as a direct replacement for Cast iron or PVC. It can also be used on both flush and projecting eaves.

As we manufacture all the Downpipes' and accessories in our state of the art manufacturing plant we can accommodate any special requirements you may have in relation to length, colour, special angles or brackets etc.

### Durability/Performance:

Aluminium Downpipe systems have a low maintenance life in excess of 40 years in rural and suburban conditions and in excess of 25 years in industrial and marine conditions. Aluminium is more resistant to damage than steel, rollform or PVC systems.

### Fire Rating:

Non Combustible to EN13501-1:2007 + A1:2009. Coefficient for thermal expansion 0.000023°C. Does not aid combustion. Melting point of approximately 660°C

### Standards:

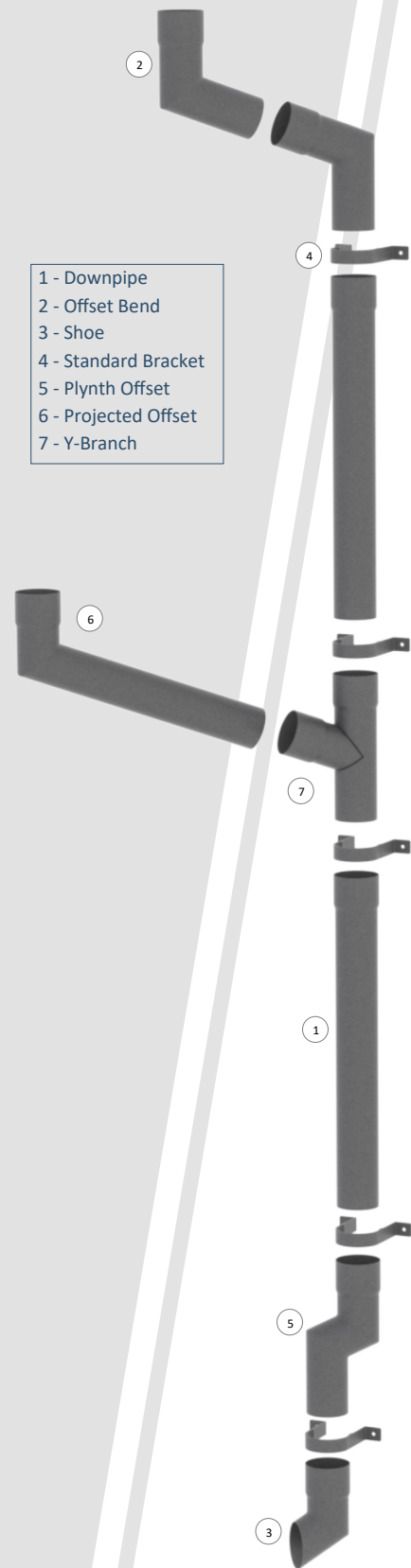
All Seamless Aluminium Groups systems are manufactured under the ISO 9001 - 2015 quality management standards.

Physical Properties	
Material	Manufactured from Extruded Aluminium to EN 755   573-3 Grade EN AW-6063 T4 Supplied by Registered Stockiest.
Finish	Mill Finish or Polyester Powder Coated to most classic RAL Colours. Produced to EN12206-1
Sizes Available	Ø63mm - 3m long - 1.65mm wall thickness Ø76mm - 3m long - 1.65mm wall thickness Ø102mm - 3m long - 1.80mm wall thickness Ø150mm - 3m long - 2.75mm wall thickness
Life expectancy	40 years or more

### Standard RAL Colour Options:



Our polyester powder coated range of RAL colours have a Matt finish and are available as standard colours unless alternative requested.





**Jointing:**

Downpipes have factory formed swages on each pipe length and component and are jointed at the swage they are also bonded together for additional strength. A low modulus sealant, such as Pro Cast Clear or Pro Sealer Clear, is applied to both sides creating a joint which will stand up to thermal movement.

**Handling & Storage:**

Downpipes, brackets and accessories, particularly with polyester powder coat finish should be handled with care and should preferably be stored under cover on racks to prevent scratching. All lengths are supplied in protective polythene wrapping, components suitably packed in boxes. If painted products are to be stored outside, cover with tarpaulin to guard against water ingress into the protective polythene. Mill finish items should be stored undercover to avoid uneven oxidation prior to being fitted.

**Maintenance:**

In order to maintain proper working order, Downpipe's should be periodically cleaned and any built-up debris removed. Check all fixings are secure and take any remedial action to rectify if necessary. To maximise the life of the decorative paint finishes, all parts should be washed down at regular intervals and any damage repaired. Please see Cleaning and Maintenance document for detailed instructions.

**FIXING METHOD:**

Fixed from top down. External Fixing brackets at maximum 3.0m centres. 2 no fixings, (No.8x50mm twin threaded stainless screw) per bracket.

**Flow Rate:**

Flow rate performance is dependent on the chosen gutter system. Please see Product Data Sheet for the chosen gutter system as listed under the Flow Rate heading.

**Compatibility:**

Direct Aluminium contact with dissimilar metals or with materials containing lime or cement should be avoided. The polyester coating is an insulation but different metals should be separated by nonmetallic material to prevent electrolytic corrosion. The use of Aluminium in conjunction with copper roofs, cladding or flashings should be avoided. Contact Seamless Aluminium for advice where heavily polluted atmospheres or marine conditions are involved for advice on material choice.

**Environmental:**

Seamless Aluminium's manufacturing site in Donegal is focused on ensuring all environmental steps are taken when producing any product. Aluminium is a sustainable material, infinitely recyclable and responsibly sourced.

**Manufacturer:**

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**Fax:** +353 (0)71 985 1876  
**Email:** [Info@seamlessaluminium.ie](mailto:Info@seamlessaluminium.ie)  
**Website:** [www.seamlessaluminium.ie](http://www.seamlessaluminium.ie)  
**Address:** Seamless Aluminium Group LTD, Cavangarden, Ballyshannon, Co Donegal, F94 D767

**Technical Support:**

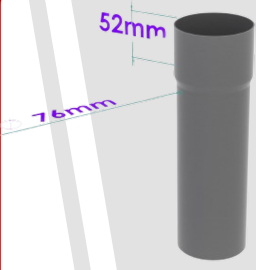
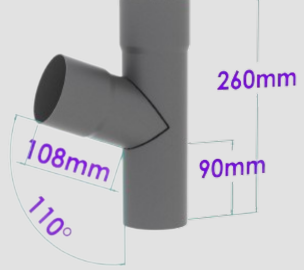
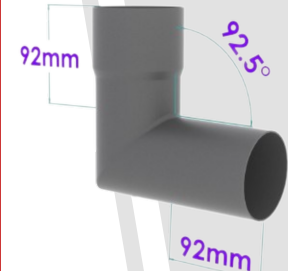
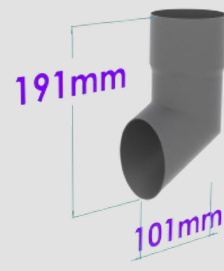
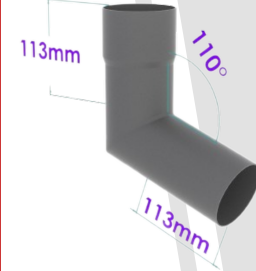
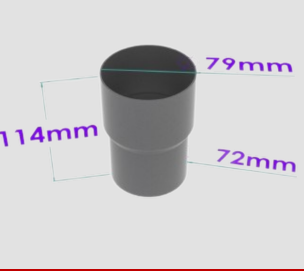
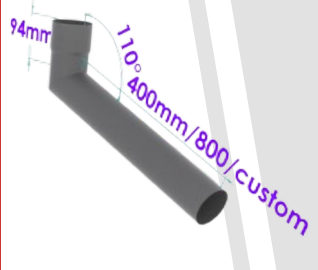
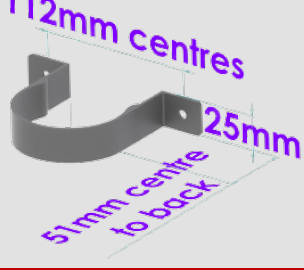
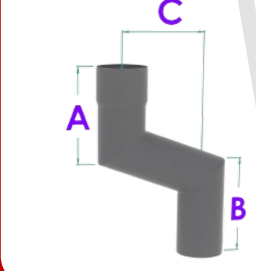
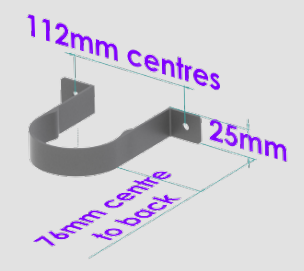
Technical advice is available from Seamless Aluminium via:

**Telephone:** +44 (0)121 765 4355  
**Email:** [Info@seamlessaluminium.co.uk](mailto:Info@seamlessaluminium.co.uk)  
**Website:** [www.seamlessaluminium.co.uk](http://www.seamlessaluminium.co.uk)  
**Address:** Seamless Aluminium International Ltd, Unit 6b, Solihull Building Trade Centre, Olton Wharf, Olton, West Midlands B92 7RN.

Seamless Aluminium Group pursues a policy of constant product development and information contained within this datasheet is therefore subject to change without notice. The customer is responsible for ensuring that each product is fit for its intended purpose and that the conditions for use are suitable. All quoted data is nominal and subject to production tolerances.



**Downpipe Parts and Accessories:**

	<u>Swaged Downpipe</u>		<u>Y-Branch</u>
	<u>Offset Bend</u> <u>92.5°</u>		<u>Shoe</u>
	<u>Offset Bend</u> <u>110°</u>		<u>Loose Connector</u>
	<u>Projected Offset Bend</u> <u>110°</u>		<u>Standard Bracket</u>
	<u>Plynth Offset</u>		<u>35mm Stand-off bracket</u>

(76mm Downpipe Accessories shown)



Introduction:

These recommendations cover procedures for cleaning and maintenance of powder coated Aluminium rainwater, eaves, window cills and capping systems. Powder Coatings are organic coatings which need to be cleaned and maintained regularly to ensure that the decorative and protective properties of the coating are retained. Powder Coated Aluminium materials, gutter and rainwater pipe systems are not a FIT and FORGET product and regular cleaning and maintenance (depending on environment) will be required to ensure product/ system lifespan and correct functionality.

Method:

Downpipe’s should be regularly cleaned of debris, leaves and grit to maintain the designed finish and to prevent or debris build up which will in turn damage finishes. Check all joints are watertight, fixings are secure and take any remedial action to rectify if necessary. Usual maintenance of powder coated applied products can be done with an appropriate cleaning product, followed by clear water rinsing and wiping using a soft cloth. All surfaces should be cleaned using a soft cloth or sponge, using nothing harsher than natural bristle brushes. There is no need to overclean or apply excessive pressure or rubbing. We recommend frequent mild cleaning rather than infrequent heavy cleaning. If the project is subject to any hazardous unusual environmental factors, or is close to salt water, an estuary or marine environments then Seamless Aluminium Ltd must be consulted on an individual project basis. If the coating is very heavily soiled (i.e. due to lack of maintenance), then the recommendation is to consult a specialized cleaning company.

Recording:

Failure to follow cleaning and maintenance guidelines will render all Warranties null and void therefore a written record must be kept in respect of all inspections, maintenance, cleaning and repair work detailing the following Information Name and details of inspection , cleaning body, date of works (cleaning, maintenance and or repair), detail of works undertaken and Inspection report findings.

Cleaning Products:

Before cleaning the cleaning agent’s datasheet must be consulted. Usual maintenance can be done using water with mild detergent (pH 5 to 8) rinsing down afterwards with fresh water If the atmospheric pollution has resulted in heavy soiling of the coating, some stains or marks may require stronger domestic products such as products based of alcohol, petroleum spirits, white spirit, or bleach (diluted to 5%). In this case, it is necessary to rinse the coating immediately after the cleaning product has been used. In no circumstance should any abrasive cleaner or polish, or any cleaner containing ketones or esters be used.

Frequency:

The frequency of cleaning depends in part on the geographical and environmental location of the building, the elements it is exposed to and the standard of appearance that is required . Also the requirements to remove deposits, which could, during prolonged contact with either the powder film or the metal substrate, (if exposed) cause damage. As a general rule the coated surface should be cleared at least once a year in a normal environment. However in areas where pollutants are more prevalent, coastal areas or industrial areas a more frequent cleaning programme must be carried out. The Industry standards for the cleaning of Powder Coated Aluminium products dependant on their located environments are as follows:

Environment	Frequency of Cleaning
<b>Normal</b> Urban industrial. Moderate SO <sub>2</sub> levels in coastal area with low salinity	<b>12 months</b>
<b>Severe</b> Industrial areas and coastal areas with moderate salinity and SO <sub>2</sub> levels >30 mg/m <sup>3</sup>	<b>6 months</b>
<b>Hazardous</b> Industrial areas with humid and aggressive atmospheres, with SO <sub>2</sub> .> 30mg/m <sup>3</sup> Coastal and offshore areas less than one km from coast with high UV, high humidity and salt > 12 mg per litre rain water)	<b>3 months</b>