



ASTOR METAL FINISHES

BROWN BRONZE = AGED BRASS



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Alchemy Names: Various

Description: Brown Bronze = Aged Brass

Astor's Brown Bronze range includes numerous patina shades & "patterns" to brass or brass-plated metal. For those profiles and applications where brass is not strong enough, light enough, available in the profiles or sizes required, Astor are able to heavy brass plate stainless, mild steel, copper or aluminium. With varying processes, the brass can then be aged to more than 100 variations.



Technically speaking;

Bronze is a metal alloy of copper & tin (& other metals) & slightly pinker tones than that of brass. Bronze is seen in older hardware, marine hardware and custom castings however is not readily available for projects. **Brass** is a metal alloy of copper & tin (& other metals) which is more readily available in various profiles & yellower than bronze metal. Once brass & bronze are aged, they become very similar shades and behave the same over time.

Patina to brass or bronze (or brass-plating);

This is achieved by a combination of polishing & submersion into a baths and rinses. We use a chemical solution to accelerate the aging of the brass metal. Due to the nature of a patina, brass metal itself and the process the finish is not designed to nor is it likely to be a consistent finish.

Base metals;

By heavy brass-plating, the same finish can be achieved on all base metals however some are better suited to the specific application. Some projects may have a mixture of brass (trafficable & benchtops) stainless (large panels and welded frames) aluminium (profiles, air grilles) and mild steel (handrails) and all will look & behave the same. For external use, we recommend stainless or brass (if practical) *although also possible to electroplate aluminium for external use (pending details).* [Request our Base Metal Guide.](#)



HOW TO SPECIFY AGED BRASS (BROWN BRONZE)

Option 1: Send a sample to match (with details of intended use)

Option 2: Send an image to match (with details of intended use)

Option 3: Specify one of below

| | | | |
|--------|--------------------|-----------------------------------|---------|
| LIGHT | "Apodis" | Light Brown Bronze + Clear Gloss | (LBBGL) |
| | "Tucana" | Light Brown Bronze + Clear Satin | (LBBML) |
| | "Tucana Natural" | Light Brown Bronze Oiled | (LBBNL) |
| MEDIUM | "Delphinus" | Medium brown Bronze + Clear Gloss | (MBBGL) |
| | "Arcturus" | Medium Brown Bronze + Clear Satin | (MBBML) |
| | "Arcturus Natural" | Medium Brown Bronze Oiled | (MBBNL) |
| DARK | "Alpheratz" | Dark Brown Bronze + Clear Gloss | (DBBGL) |
| | "Centauri" | Dark Brown Bronze + Clear Satin | (DBBML) |
| | "Centauri Natural" | Dark Brown Bronze Oiled | (DBBNL) |

Option 4: Detailed specification/ variation

1> Select patina shade #0.5 - #6



2> Select "pattern"

Original = Non directional, smooth finish – samples we supply

Hairline = Brushed Before patina

Antique = Brushed After Patina

Buffed = Rubbed

Orbitale = Orbital Burnish

Burnished = patchy, distressed

Vintage = highlighted corners, edges, highpoints

3> Select topcoat

Clear matt

Clear Satin

Clear Semi-gloss

Clear Gloss

Unlacquered = oiled or waxed

Specification: AS/NZ 1192_2004

| STAINLESS | ALUMINIUM Interior | ALUMINIUM (Exterior/ Wet Area) |
|---|--|--|
| Nickel-plating: 15-25 microns thickness Heavy Brass plating: 10-15 microns Aging process: chemical patina of brass Oil: rubbed by hand to offer mild sealant | Nickel-plating: 15-25 microns Heavy Brass plating: 10-15 microns Aging process: chemical patina of brass Oil: rubbed by hand to offer mild sealant, | Duplex Nickel-plating: 2 separate layer of nickel, semi-bright + bright nickel, 60-70microns thickness Heavy Brass plating: 10-15 microns Aging process: chemical patina of brass Oil: rubbed by hand to offer mild sealant |



Managing Project Expectations

Due to the nature of patina and bespoke metal finishes, you may request Astor to hold a referenced control sample at time of specification. All samples are clearly labelled to advise of likely variations (over the items specifically and also over various production runs. We encourage all fabricators and suppliers to send shop drawings for Astor's comment to assist with achieving efficiency, cost effectiveness and a high quality finish.

Patina behaviour specified without lacquer:

A patina offers a "skin" to the brass which also helps stabilise the brass. If left unlacquered, patina's will change naturally in use. Oils and waxes offer mild protection while still allowing the brass and patina to age naturally. They of course cannot be warranted.

When handled; the patina will likely lighten as it is removed, and often shows an increase in sheen. This is the result of the oils in our hands which remove dust & pollutants, allowing the natural brightness of brass to show. Where not handled the patina will darken. Where salt is allowed to settle on the surface, the patina will Verdi gris. Different brass alloys will result in slightly difference shades (redder & greener). To avoid variations in different brasses, the answer is to brass-plate.

Astor Methodology

Aged patina may differ over various production runs and also depending on how previous samples have been handled. Thus for larger projects or where seeking a very specific patina, we recommend a sign off sample at the beginning of the order - on the actual metal, profile, components. Base metal, configuration, & type of profile and can also have an influence on the result. Once approved the remaining order will be finished. Lead times are generally within 2-3 weeks (pending scope & complexity).

Astor quality control

This is done at each stage of the various processes with the first step being assessment of the metal we are sent. For adjacent panels, we understand that projects do not want a "patchwork" result when installed. Label the back of each panel with a clearly marked up elevation for our factory staff to work to.

Handling, freight & install

All finishes are to be handled with care. Unlacquered finishes are oiled to assist with packing, freight and installation. We provide rubber gloves and handling instructions at time of despatch. We recommend to leave the oil on (especially while any other trades are on site). This oil will absorb and evaporate naturally and provides ongoing protection of the patina. If required, the oil can be removed with thinner (without affecting the patina) although ideally wait as long as possible to do this as this will allow the patina to become more robust & less reactive.

Additional information is located on our website, or request from our team;

[ASTOR PLATING CAPACITIES](#)
[DESIGN TIPS TO SUIT PLATING](#)

[QUOTE REQUEST](#)
[BASE METAL SELECTION](#)

[APPLICATIONS](#)
[TO LACQUER OR NOT TO LACQUER](#)

[FABRICATION TIPS FOR PLATING](#)



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