

POLYESTER [Hammer Copper]

Product Code: PO 41-H-0002[Color – Copper]

Polyester Hammer Tone Copper color powder coating is a thermosetting powder coating based on saturated polyester resins especially selected for exterior use. It has good flow and excellent resistance to atmospheric ageing environment. This powder coating product is applicable for electrostatic application.

Product meets most of the international requirements and specifications such as [Qualicoat]

USE

Ideal for outdoor furniture providing excellent resistance, applicable for all type of manufactures who are in need for similar type product such as: [fencing, air conditioning, lawn and garden equipment, mailboxes, construction equipment, light stand, etc...]

PROPERTIES

- Excellent flexibility
- Mechanical properties
- UV resistance
- Outstanding finishes
- V. Good corrosion resistance

SUBSTRATE

Cold rolled steel

COLOR

Hammer Tone Copper

APPEARANCE

Gloss – [77+/- 7]

SPECIFIC GRAVITY [ASTM5965-02] Kg/l

Approx. 1.500 – 1.600 Kg/L

SPREADING RATE [MILEAGE]

Approx. 10.4 – 11.1 m²/Kg [optimal film thickness @ 60µm]

PARTICLES SIZE DISTRIBUTION [ISO3310-1:2000] µm

Approx. 42 – 48 µm

CURING CONDITION

10' @ 200°C m.t in standard conditions – metal temp.

[The film obtained maintains its property if the polymerization conditions are respected]

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Date Revised: 01st Jan 2012

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SHELF LIFE & STORAGE @ 20°C

24 months when stored in dry and cool conditions @ 25°C, in original sealed containers.

PACK AVAILABLE

20 Kg cardboard boxes.
[Also available in Big Bags or containers upon request]

SURFACE PREPARATION

For Steel:

All surfaces must be dry, clean and free from contaminators. It is suggested a good substrate cleaning as required (sand blasting – degreasing – phosphatizing or chromed, etc...).

For Aluminum:

In order to obtain optimal anti-corrosion properties, it is advised to apply a chemical pretreatment prior to powder coating application.

APPLICATION DATA

Applied by electrostatic corona spraying using classic devices which can provide a negative tension of 60-80 kV. The powder is cured in a suitable convection or combustion, or induction, etc...

DRY FILM CHEMICAL & MECHANICAL RESISTANCE

All test have been effectuated on UNI 0.5mm thickness panel cured polymerization conditions standards.

Test film thicknes:@120µm.

Test	Method	Range
Film Thickness	ISO2808	100 – 150 µm.
Gloss (60°C)	ISO2813	75 – 85 gloss
Adhesion Crosshatch 2mm	BS EN ISO2409	90 – 100% GTO-0
Cupping Erichsen	ISO1520	7 – 10 mm [No cracking]
Direct Impact [2lbs-½ inch]	EN ISO 6272-1	80 – 100 cm [No cracking]
Indirect Impact [2lbs-½ inch]	EN ISO 6272-1	80 – 100 cm [No cracking]
Pencil Hardness	ISO15184	HB - F
Conical Mandrel	DIN EN ISO 6860	5-6 mm

Resistance to common synthetic resistance [72 hrs. in 3% solution]

- No blistering or loss of adhesion no significant change in appearance.

Salt spray resistance [ASTM B117-73] on Chromate Aluminum

- No blistering or loss of adhesion during [2000 hrs.]

Humidity Resistance [ASTM D2247] on Chromate Aluminum

- No blistering or loss of adhesion during [1000 hrs.]

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