

## **POLYESTER [Hammer Gold]**

**Product Code: PO 41-H-0001[Color – Gold]**

Polyester Hammer Tone Gold 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 Gold

### **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 m<sup>2</sup>/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]

This information contained in the data sheet is to the best of our knowledge correct and up to date. Under well-defined conditions. Its accuracy or suitability under the actual conditions of any independent use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller cannot accept any liability in connection with the use of the product relative to coverage, performance, injury, or damage, unless we specify in writing to do so. The information in this data sheet is subject to change without prior notice and it is the user responsibility to ensure it is current. For further information and advice please contact RITVER Technical Service Department.

Date Revised: 01<sup>st</sup> 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 thickness:**@80µm.

Test	Method	Range
Film Thickness	ISO2808	100 – 120 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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