

**Product**

Field of application

- powder coating system for interior applications like steel furniture, shelves, radiators, household appliance, lamps, machine construction

Properties

- epoxy/polyester resin base
- very good mechanical properties
- good chemical resistance
- good scratch resistance
- colour stability at different curing conditions
- very good covering power
- good flow properties

Details

- colour shade: all RAL and also special colourshades are possible
- surface: smooth
- gloss: silk gloss 60 GU +/- 10 (60° Winkel)
- density: 1,3 - 1,8 g/ml (depending on colour shade)
- spreading rate: 9 - 13 m<sup>2</sup>/kg (at 60 µm layer thickness)

Storage

- 24 month at dry and cool storage up to max. +25°C

**Processing**

Substrates: pre-treated parts of aluminium, steel and galvanized steel

Preparation / Pre-treatment

- grease, oil, tinder and oxidation products have to be removed from surface before coating

aluminium	chromating, chrome-free pre-treatment, pre-anodisation
steel	blasting, iron-phosphating, zinc-phosphating
galvanized steel	sweeping, chromating, chrome-free pre-treatment, zinc-phosphating

The coater has to check the suitability of pre-treatment referring to customer demand previously.

Application

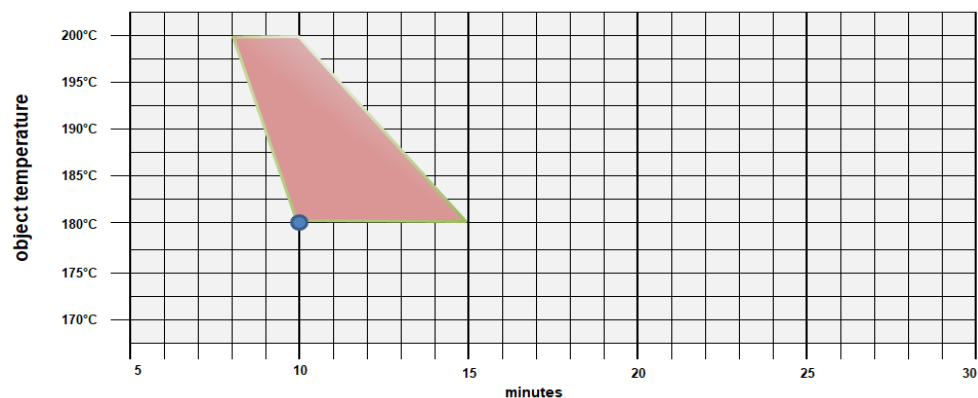
- electrostatic and tribo

Layer thickness ISO 2360

- 60 - 100 µm (depending on colour shade and application)

Object temperature

- 10 min - 180°C ( ● recommended)



Recoatibility

- product can be recoated by itself (if possible tribo)
- recommendation about appropriate liquid coats on request

### Test results

Proved substrate	• steel 0,8 mm, iron-phosphated, layer thickness 60 µm	
Physical/Mechanical	• cross cut test DIN EN ISO 2409	Gt 0
	• bending test DIN EN ISO 1519	5 mm no cracks
	• impact test ASTM D2794	>20 inchp. no cracks on both sides
	• Erichsen cupping test DIN EN ISO 1520	≥ 5 mm
Corrosion resistance	• salt spray test (neutral) DIN EN ISO 9227	500 hours - corrosion creepage ≤ 1 mm - no bubbles
	• humidity chamber test DIN EN ISO 6270-2	500 hours - no bubbles - no loss of liability
Weather resistance	• unsuitable for exterior applications	

Certificates • on request

### Notes

- Occupational safety/ health • please note information of corresponding safety data sheet
- environmental protection
- Colour shade deviation • colour shade deviation according to VdL-RL 10 (actual version)

This technical data sheet is based on our current state of knowledge. It is not a product specification.

The technical data sheet is for information only and without any responsibility. It does not release to test our products previously regarding suitability according to operation purpose. CENARIS reserves the right of changes without notification.

Therefore only the current version is valid. If in doubt, please contact us.

**The current technical data sheets and safety data sheets can be found at [www.cenaris.com/downloads](http://www.cenaris.com/downloads)**