

**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

Details

- colour shade all RAL and also special colourshades are possible
- surface structure
- gloss glossy (visual)
- density 1,3 - 1,8 g/ml (depending on colour shade)
- spreading rate 7 - 11 m<sup>2</sup>/kg (at 80 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

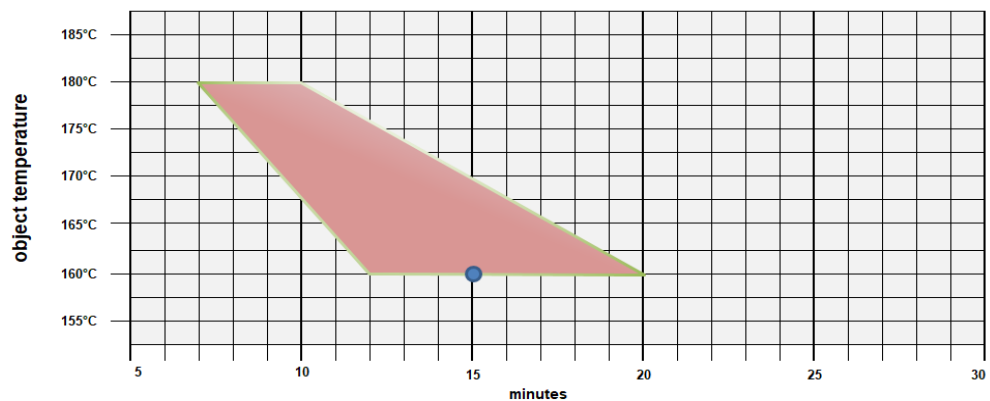
- electrostatic and tribo

Layer thickness ISO 2360

- 80 - 120 µm (depending on colour shade and application)

Object temperature

- 15 min - 160°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	≥ 6 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)

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