

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
- with decorative metallic effect**
- 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 (visual)
- density: 1,3 - 1,8 g/ml (depending on colour shade)
- spreading rate: 9 - 13 m²/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

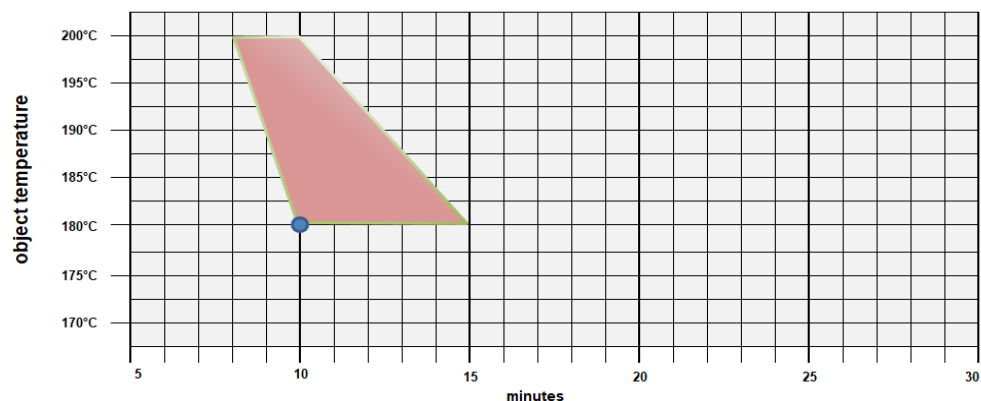
- electrostatic

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	≥ 4 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

General details

- Please note the data sheet concerning the processing of powder coatings with metallic effect published by " Verband der deutschen Lackindustrie". Please download it under the following web page.

https://www.wirsindfarbe.de/fileadmin/user_upload/Dokumente/2017-09-27-Merkblatt-Pulverlack-Metallic-Effekt.pdf

Additional details

- It should generally only be coated with electrostatic charge (corona).
- The coating of large areas should be done only with automatic systems.
- The coating of metallic powder coating is generally more demanding than the of general powder coating. Please check previously the optimal adjustment of the coating plant.
- Inside the coating cabin it should be used always the same spray pistols. This is especially important for parts which should to be combined later.
- The parameter of the construction (high voltage, conveying air, scavenging air, distance spray pistol/substrate) must not be changed during the coating process.
- It must paid attention to proper grounding of the parts.
- Only use fresh powder if possible.
- Complex geometries should always be pre-coated. When recoating there may be clouding, blowing effects and back spray effect.
- Recycling powder must be dosed continuously in a constant relationship.
- If possible only use pistols with flat jet nozzles.
- The pistols must be blowed out regularly.
- Be careful by using baffles as an attachment of pistols. Even by ventilated pistols disposal can occur.
- Coat the face plan side at last if you coat on both sides.
- For a uniform mixture of the powder coating fluidisable reservoir should be used. Due to this effect deviations are limited.
- Layer thicknesses should not be too high or low, 80 - 100 µm max. 120 µm.
- For a coating application powder should be used out of one batch if possible. The use of a new batch must be examined previously.

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