

Product

Field of application

- powder coating system for exterior applications like garden furnitures, steel constructions, construction or agriculture machines, fences

Properties

- label-free polyester resin base
- good weather resistance
- suitable for directly heated gas ovens
- very good mechanical properties
- good coverage, even on critical edges
- inclusive fumigation additive for galvanized substrates

Details

- colour shade: all RAL and also special colourshades are possible
- surface: smooth
- gloss: glossy 80 GU +-10 (60° angle)
- density: 1,4 - 1,9 g/ml (depending on colour shade)
- spreading rate: 8 - 12 m²/kg (at 60 µm layer thickness)

Storage

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

Processing

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

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

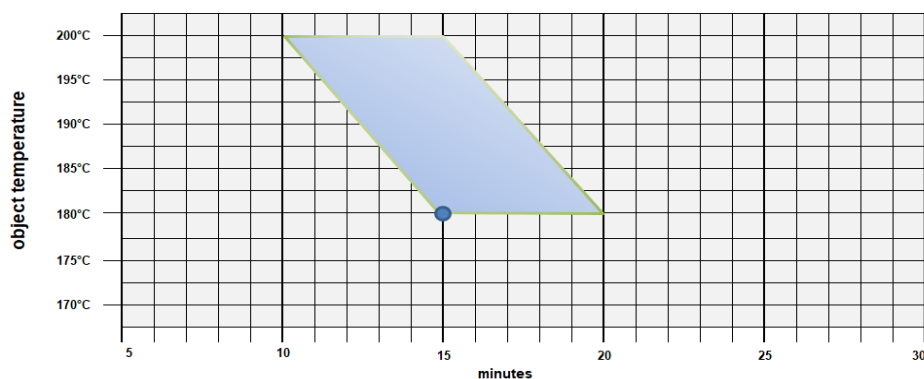
aluminium	chromating, chrome-free pre-treatment, pre-anodisation
steel	blasting, iron-phosphating, zinc-phosphating
galvanized steel	sweeping, chromating, chrome-free pre-treatment, zinc-phosphating

The coater has to check the suitability of pre-treatment referring to customer demand previously. According to requirements an additional primer could be necessary. In this case we advice our product **MEGAPRIMER® EP**.

Application: electrostatic and tribo

Layer thickness ISO 2360: 60 - 100 µm (depending on colour shade and application)

Curing cycle: 15 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
	• Buchholz hardness DIN EN ISO 2815	at least 80
	Corrosion resistance	• salt spray test (neutral) DIN EN ISO 9227
• humidity chamber test DIN EN ISO 6270-2		500 hours - no bubbles - no loss of liability
Weather resistance	• accelerated weathering DIN EN ISO 16474-3 (UV-B 313 nm)	min. 200 h with a residual gloss ≥ 50 %
	Not suitable for facade applications	
Certificates	• on request	

Notes		
Occupational safety/ health environmental protection	• please note information of corresponding safety data sheet	
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