

Product

Field of application

- powder coating system for exterior applications like metal facades, winter gardens, garden furniture, steel structures, construction machinery, agricultural machinery, fences, etc.

Properties

- label-free polyester resin base
- facade quality with very good weather stability
- tested according to QUALICOAT
- 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: high gloss >90 GU (60° angle)
- density: 1,2 - 1,8 g/ml (depending on colour shade)
- spreading rate: 9 - 13 m²/kg (at 60 µm layer thickness)

Storage

- 36 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

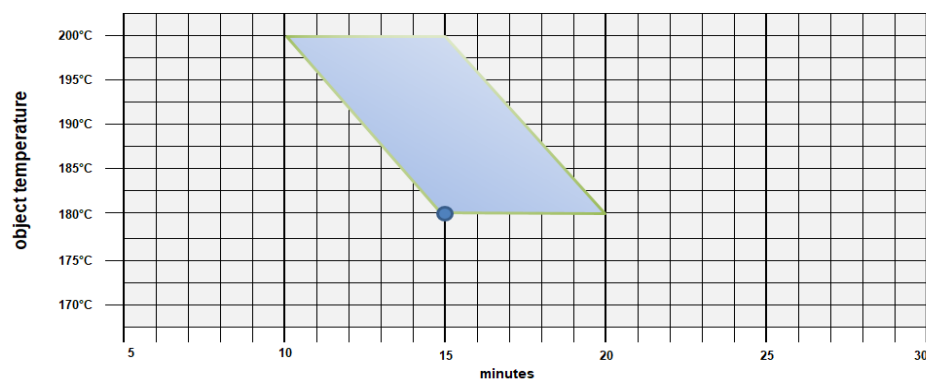
aluminium	chromating, chrome-free pre-treatment, pre-anodisation
steel	blasting, iron-phosphating, zinc-phosphating
galvanized steel	sweeping, chromating, chrome-free pre-treatment, zinc-phosphating

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	• aluminum 0,8 mm, pretreated according to QUALICOAT, layer thickness 60 µm
Physical/Mechanical	<ul style="list-style-type: none"> • cross cut test Gt 0 DIN EN ISO 2409 • bending test 5 mm no cracks DIN EN ISO 1519 • impact test >20 inchnp. no cracks on both sides ASTM D2794 • Erichsen cupping test ≥ 5 mm DIN EN ISO 1520 • Buchholz hardness at least 80 DIN EN ISO 2815
Corrosion resistance	<ul style="list-style-type: none"> • keesternich test (S02)30 cycles no change DIN EN ISO 3231 • salt spray test (NSS + AASS) 1000 hours - corrosion creepage ≤ 1 mm - no bubbles DIN EN ISO 9227 • humidity chamber test 1000 hours - corrosion creepage ≤ 1 mm - no bubbles DIN EN ISO 6270-2 • mortar test no residue after 24 h ASTM D3260 • boiling test no detachment after 2 h
Weather resistance	<ul style="list-style-type: none"> • accelerated weathering min. 300 h with a residual gloss ≥ 50 % DIN EN ISO 16474-3 (UV-B 313nm) • accelerated weathering min. 1000 h with a residual gloss ≥ 50 % DIN EN ISO 16474-2 (XENON) • Florida outdoor exposure 12 months storage (5 °south) with a residual gloss ≥ 50% DIN EN ISO 2810
Certificates	• QUALICOAT class 1 approval no. P-0366
Further test 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