

Product

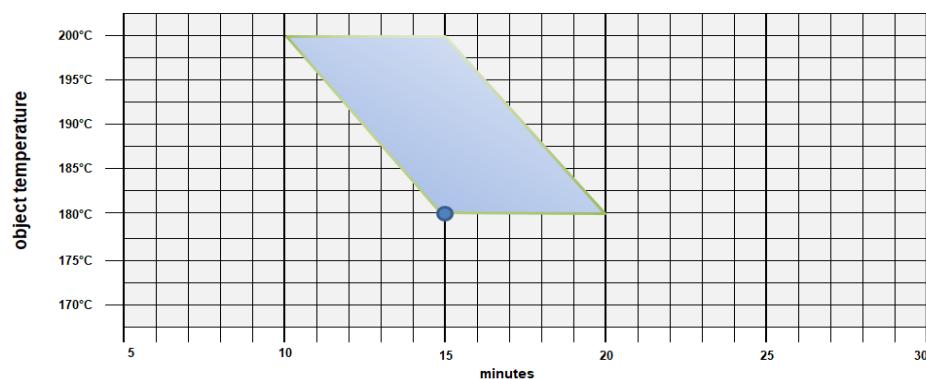
Field of application	<ul style="list-style-type: none"> powder coating system for exterior applications like metal facades, winter gardens, garden furniture, steel structures, construction machinery, agricultural machinery, fences, etc.
Properties	<ul style="list-style-type: none"> label-free polyester resin base facade quality with very good weather stability tested according to GSB and QUALICOAT suitable for directly heated gas ovens very good mechanical properties good coverage, even on critical edges inclusive fumigation additive for galvanized substrates
Details	<ul style="list-style-type: none"> colour shade all RAL and also special colourshades are possible surface smooth gloss glossy 80 GU +-10 (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	<ul style="list-style-type: none"> 36 months at dry and cool storage up to max. +25°C

Processing

Substrates	pre-treated parts of aluminium, steel and galvanized steel	
Preparation	<ul style="list-style-type: none"> grease, oil, tinder and oxidation products have to be removed from surface before coating 	
Pre-treatment	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> electrostatic and tribo
Layer thickness ISO 2360	<ul style="list-style-type: none"> 60 - 100 µm (depending on colour shade and application)
Curing cycle	<ul style="list-style-type: none"> 15 min - 180°C (● recommended)



Recoatibility	<ul style="list-style-type: none"> product can be recoated by itself (if possible tribo) recommendation about appropriate liquid coats on request
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Test results		
Proved substrate	• aluminum 0,8 mm, pretreated according to GSB / QUALICOAT, layer thickness 60 µm	
Physical/Mechanical	• 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	• 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	• 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	• GSB standard	approval no. 282 a
	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