

Product

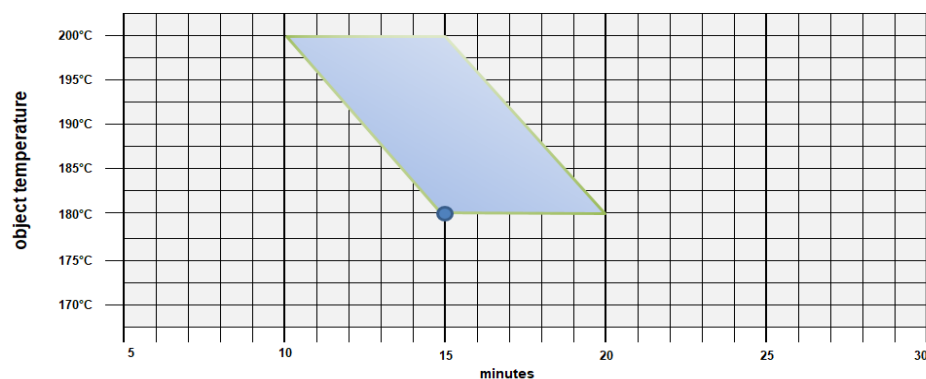
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|----------------------|---|
| Field of application | <ul style="list-style-type: none"> powder coating system for exterior applications like switch cabinets, garden furniture, steel structures, construction machinery, agricultural machinery, fences, etc. |
| Properties | <ul style="list-style-type: none"> label-free polyester resin base facade quality with very good weather stability 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: fine structure gloss: glossy (visual) density: 1,2 - 1,8 g/ml (depending on colour shade) spreading rate: 8 - 12 m²/kg (at 70 µm layer thickness) |
| Storage | <ul style="list-style-type: none"> 24 months at dry and cool storage up to max. +25°C |

Processing

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| 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 steel galvanized steel | <ul style="list-style-type: none"> chromating, chrome-free pre-treatment, pre-anodisation blasting, iron-phosphating, zinc-phosphating 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**.

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| Application | <ul style="list-style-type: none"> electrostatic and tribo |
| Layer thickness ISO 2360 | <ul style="list-style-type: none"> 70 - 110 µm (depending on colour shade and application) |
| Curing cycle | <ul style="list-style-type: none"> 15 min - 180°C (● recommended) |



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| 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 70 µm |
| Physical/Mechanical | • | cross cut test DIN EN ISO 2409 |
| | • | bending test DIN EN ISO 1519 |
| | • | impact test ASTM D2794 |
| | • | Erichsen cupping test DIN EN ISO 1520 |
| | • | Buchholz hardness DIN EN ISO 2815 |
| Corrosion resistance | • | keesternich test (S02)30 cycles DIN EN ISO 3231 |
| | • | salt spray test (NSS + AASS) DIN EN ISO 9227 |
| | • | humidity chamber test DIN EN ISO 6270-2 |
| | • | mortar test ASTM D3260 |
| | • | boiling test |
| Weather resistance | • | accelerated weathering DIN EN ISO 16474-3 (UV-B 313nm) |
| | • | accelerated weathering DIN EN ISO 16474-2 (XENON) |
| | • | Florida outdoor exposure DIN EN ISO 2810 |
| Certificates | • | GSB standard |
| | • | QUALICOAT class 1 |
| Further test certificates | • | on request |

| Notes | | |
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| 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