

Product

Field of application

- powder coating system for exterior* applications like aluminium rims, bicycle frames, metal displays

Properties

- label-free polyester resin base
- **with decorative PREMIUM metallic effect (manufactured by MEGABOND® technology)**
- good weather resistance
- very good mechanical properties
- colour stability at different curing conditions
- good flow properties



Details

- colour shade: colorless
- surface: smooth
- gloss: glossy (visual)
- density: 1,21 g/ml
- spreading rate: 13 - 14 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

Pre-treatment

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

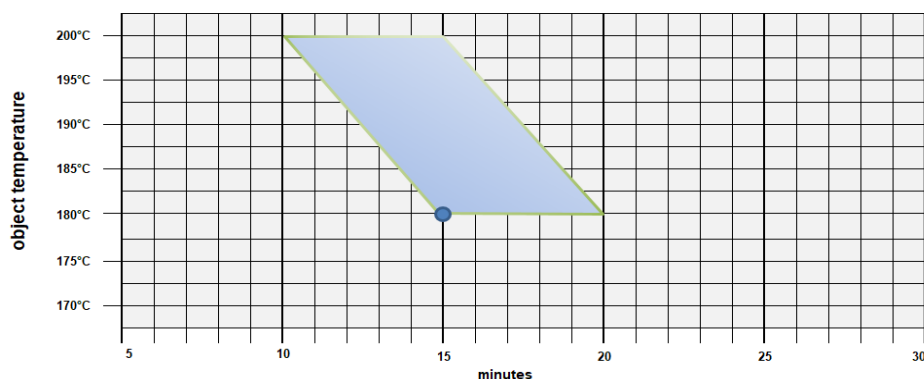
- electrostatic

Layer thickness ISO 2360

- 60 - 100 µm (depending on colour shade and application)

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 GSB / QUALICOAT, 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
	Certificates	• on request

Notes

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

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

* only with overcoating (colorless without a previous topcoat cannot be used outdoors)

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 sholuld 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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