

Product

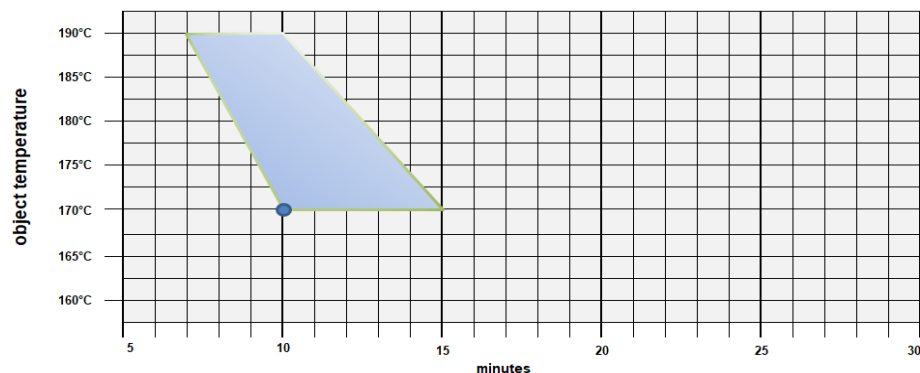
Field of application	<ul style="list-style-type: none"> powder coating system for exterior applications like metal facades, winter gardens, garden furniture, steel structures, construction machinery, agricultural machinery, fences, etc. 										
Properties	<ul style="list-style-type: none"> label-free polyester resin base low temperature powder coating (NT) 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 										
Details	<table border="0"> <tr> <td>• colour shade</td> <td>all RAL and also special colourshades are possible</td> </tr> <tr> <td>• surface</td> <td>smooth</td> </tr> <tr> <td>• gloss</td> <td>matt 25 GU +-10 (60° angle)</td> </tr> <tr> <td>• density</td> <td>1,2 - 1,8 g/ml (depending on colour shade)</td> </tr> <tr> <td>• spreading rate</td> <td>9 - 13 m²/kg (at 60 µm layer thickness)</td> </tr> </table>	• colour shade	all RAL and also special colourshades are possible	• surface	smooth	• gloss	matt 25 GU +-10 (60° angle)	• density	1,2 - 1,8 g/ml (depending on colour shade)	• spreading rate	9 - 13 m ² /kg (at 60 µm layer thickness)
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Storage	<ul style="list-style-type: none"> 18 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	<table border="0"> <tr> <td>aluminium</td> <td>chromating, chrome-free pre-treatment, pre-anodisation</td> </tr> <tr> <td>steel</td> <td>blasting, iron-phosphating, zinc-phosphating</td> </tr> <tr> <td>galvanized steel</td> <td>sweeping, chromating, chrome-free pre-treatment, zinc-phosphating</td> </tr> </table>	aluminium	chromating, chrome-free pre-treatment, pre-anodisation	steel	blasting, iron-phosphating, zinc-phosphating	galvanized steel	sweeping, chromating, chrome-free pre-treatment, zinc-phosphating
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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"> 10 min - 170°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 QUALICOAT, layer thickness 60 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		
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