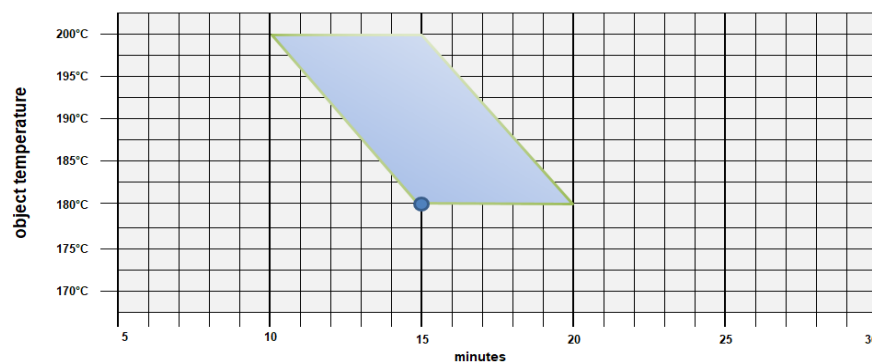


Product											
Field of application	<ul style="list-style-type: none"> powder coating system for exterior applications like street furniture, fences, metal facades, parking ticket machines, aluminium rims etc. 										
Properties	<ul style="list-style-type: none"> label-free polyurethane resin base special development with very good ANTI-GRAFFITI properties colour stability at different curing conditions excellent scratch resistance and surface hardness good chemical and solvent resistance good mechanical properties good weather stability 										
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>high gloss >90 GU (60° angle)</td> </tr> <tr> <td>• density</td> <td>1,1 - 1,5 g/ml (depending on colour shade)</td> </tr> <tr> <td>• spreading rate</td> <td>11 - 15 m²/kg (at 60 µm layer thickness)</td> </tr> </table>	• colour shade	all RAL and also special colourshades are possible	• surface	smooth	• gloss	high gloss >90 GU (60° angle)	• density	1,1 - 1,5 g/ml (depending on colour shade)	• spreading rate	11 - 15 m ² /kg (at 60 µm layer thickness)
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Storage	<ul style="list-style-type: none"> 12 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
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"> the product CANNOT be overpainted due to its anti-graffiti properties
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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 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	
Corrosion resistance	•	Erichsen cupping test DIN EN ISO 1520
		≥ 6 mm
	•	Buchholz hardness DIN EN ISO 2815
	at least 80	
Weather resistance	•	salt spray test (NSS + AASS) DIN EN ISO 9227
		1000 hours - corrosion creepage ≤ 1 mm - no bubbles
	•	humidity chamber test DIN EN ISO 6270-2
		1000 hours - corrosion creepage ≤ 1 mm - no bubbles
Anti-graffiti resistance	•	accelerated weathering DIN EN ISO 16474-3 (UV-B 313nm)
		min. 200 h with a residual gloss ≥ 50 %
Certificates	•	wax stick
		cleaning with a cloth
	•	shoe cream
		cleaning with a cloth
	•	felt pen (water-based)
	cleaning with a cloth	
	•	felt pen (solvent-based)
		cleaning with alcohol
	•	spray paint (solvent based) gem. ASTM D6578
		cleaning with alcohol
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