COLIBER® POWDER COATINGS

TECHNICAL DATA SHEET

Type of coating	**EE - EPOXY ZINC PRIMER-ZP**
Color	SZARY
Symbol	EE712/0/2488/01ZP
Surface	Smooth
Gloss	Semi-gloss

Characteristics

- Inner specialistic use, primer
- Contains metallic zinc
- Excellent anti-corrosion properties
- Very good resistance to chemicals
- Very good adhesion to metallic surfaces
- Very good inter-layer adhesion
- Very good mechanical resistance

Applications

Steel elements exposed to aggressive corrosive environment, used as a primer layer, can be used as an independent layer in situations when it is not exposed to atmospheric conditions.

Powder properties	**Particle size (Malvern)**	Fine powder suitable for electrostatic spray (corona).
	Density (g/cm³) ISO 8130-2	2,094
	Theoretical coverage (m²/kg)	~10 by the film thickness 50 µm and 100 % use of powder coating.
	Storage stability	12 months from the date of production, in the orginal, unopened package, keep away from heat sources, in the temperature of 5 – 25°C, protect from moisture. No direct sun exposure. The product should be stay at ambient temperature (paint shop) 12h before use.
Coating film tested in lab conditions on: steel panel	**Thickness** ISO 2808	recommended 50-70µm
	Gloss (60°) ISO 2813[1] VISUAL[2]	65 ±5 GU
	Cross cut ISO 2409	0
	Mandrel bending ISO 1519	<5 mm
	Erichsen cupping ISO 1520	>5 mm
	Impact resistance ISO 6272-1	front >50 kg/cm reverse >50 kg/cm
	Buchholz hardness ISO 2815[3]	>90
	Pencil hardness ISO 15184[3]	2H
iron phosphated steel panel	**Salt spray test** ISO 9227	min. 720 h no bubble

(1) applies to smooth and no metallic coatings film
(2) applies to structural and metallic coatings film
(3) not applicable structural coatings film

Eko-Color Sp. z o.o.
St. Sucharskiego 2, 77-100 Bytów, Poland
Tel. +48 59 822 22 22, e-mail: info@eko-color.pl

Version: 1.0 Date of version: 24.11.2020

COLIBER®
POWDER COATINGS

TECHNICAL DATA SHEET

Surface pretreatment	- The overall quality of the coating film depends on the type and quality of the pretreatment. - Surfaces must be dry, degreased and free from rust and other contaminants. - In order to improve coating adhesion to the surface and improve resistance it is recommended: aluminium - chromating, chrome-free pretreatment or anodic pretreatment. steel and galvanized steel - individual choice of surface pretreatment (e.g. phosphating). - However, in order to achieve optimum results, you must follow the instructions and recommendations of the pretreatment material manufacturer.
Application	- Electrostatic gun - corona (recommended voltage - 60 kV) or tribo gun. - Application parameters depend on the geometric shapes of the detail and the film thickness to be reached. - Responsibility for the correct application parameters lies on the coating applicators. - Despite careful production methods, slight deviation of color and effect between the different manufacturing batches may occur (typical for powder coatings). - Various application parameters may cause color/effect changes. - Proper grounding of application equipment and coated elements helps to keep repeatability of the obtained color/effect. - It is recommended to do the entire order on the same equipment, with the same application parameters and using powder coating from one production batch. - Not be mixed with other powder coatings. - Control the air speed during application of powder coatings. - Keep the appropriate distance: the gun - coated elements. - Keep a uniform thickness of coating.
Curing conditions	- Curing time recommendation in a convection oven: **200°C/10min.** **180°C/15min.** (object temperature) - Must be strictly observed parameters of stoving the coating film to ensure that the full mechanical and chemical properties. - Suitability of the product for stoving in gas ovens and radiant ovens should be verified - may be a significant difference in color - perform a comparative test with the standard color (please contact us for details).
Approvals	- The powder coatings are in compliance with 2011/65/EC and 2015/863/EC (so called ROHS). - Heavy metal free.
Technical recommendations	- In the case of cleaning powder coated surfaces it is necessary strict compliance with the Technical recommendations 01: Cleaning of powder coated surfaces.
Comments	- To print, to glue, to label, to laminate with foil, over-coating or any other post-treatment, some preliminary testing is recommended. - Powder-coated details should be packaged after being completely cooled down to ambient temperature, into appropriate packaging materials previously tested by the user. - Packaged details should be stored under cover to avoid condensation, which may result in traces on the finished coating.
Safety Data Sheet	EPOXY ZINC PRIMER EE/ZP SERIE S04
Edition / date	1.3 / 2023-05-24