

Type of coating PA - POLYESTER POWDER COATINGS

Color RAL 6005

Symbol PA412/0/0913/01C

Surface Smooth

Gloss Semi-gloss

Characteristics

- Outdoor, economic application
- Good degassing properties
- Possible small deviation of color, gloss or appearance of the coating of standards
- Good weather resistance
- Good UV-light resistance
- Good chalking resistance

Applications Furniture and garden tools, shelves elements, etc.

Powder properties

Particle size (Malvern)	Fine powder suitable for electrostatic spray (corona) and tribocharging (tribo)
Specific gravity (g/cm³)	1,35
Theoretical coverage (m²/kg)	9 by the film thickness 80 µm i 100 % use of powder coating
Storage stability	24 months from the date of production, in the original, unopened package, keep away from heat sources, at temperatures at 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	80 - 100 µm max.120	
	ISO 2808		
	Gloss (60°)	65 ±10 gloss units	
	ISO 2813 ¹		
	VISUAL ²		
	Cross cut	0	
	ISO 2409		
	Mandrel bending	>5 mm	
ISO 1519			
Erichsen cupping	>5 mm		
ISO 1520			
Impact resistance	front	>50 cm*1kg	
ISO 6272-1	rewers	<50 cm*1kg	
Buchholz hardness	>80		
ISO 2815 ³			
Pencil hardness	3 H		
ISO 15184 ³			

(1) applies to smooth and no metallic coatings film

(2) applies to structural and metallic coatings film

(3) not applicable structural coatings film

Surface pretreatment	<ul style="list-style-type: none">- 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	<ul style="list-style-type: none">- Electrostatic gun - corona (recommended voltage is 60 kV) or tribo gun, with the exception of metallic effects - should be applied only technology corona.- Application parameters depend on the geometric shapes of the detail and the film thickness to be reached. Responsibility for the correct application parameters rests on the coating applicators.- Despite careful production methods, may be small deviation color and effect deviation between the different manufacturing batches (it typical for powder coatings).- It is recommended to do the entire order on the same equipment, with the same application parameters.- If it is possible to apply the powder coating from one production batch.- Take care of proper grounding of application equipment and coated elements (color/effect will be repeatable).- Control the air speed during application of powder coatings.- Keep an appropriate distance: the gun - coated elements.- Keep a uniform thickness of coating.- Not be mixed with other powder coatings.
Curing conditions	<ul style="list-style-type: none">- Curing time recommendation in a convection oven: 200°C/10 min. or 180°C/15 min. (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	<ul style="list-style-type: none">- The powder coatings are in compliance with 2011/65/EC and 2015/863/EC (so called ROHS) .- Heavy metal and TGIC free.
Comments	<ul style="list-style-type: none">- 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.- In the case of cleaning powder coated surfaces it is necessary strict compliance with the Technical recommendations 01: Cleaning of powder coated surfaces.
Safety Data Sheet	PA - POLYESTER POWDER COATINGS
Edition / date	2.2 / 2018-11-27

The above values may vary depending on the type of surface pretreatment, color, gloss, texture, etc.
All informations included in this card are based on our experience and actual knowlegde and do not release the user from carrying out their own tests. If in doubt please contact us for details.
Having no influence on the use and application conditions, we can take responsibility only for the quality of any the product and ensure that it fits to our standards.
This Technical Data Sheet is revised periodically. EKO-COLOR reserves the right to change specifications without notice.
If necessary, our sales department will confirm the validity of this document.