Technical Data Sheet: BR
Date: Nov-21

# InverRAL Polyester

## Introduction

The InverRAL stock range is a polyester powder coating recommended for use in both interior and exterior applications. InverRAL meets the full requirements of BS6496/7. Inver UK's attention to particle size control and formulation ensures optimum transfer efficiency.

## Colour

Wide range of RAL colours available.

## Gloss

Two gloss levels available (@60°) Gloss 80+, Semi-Matt 30+/-5

## Film Properties

Meets the following criteria:

| | | |
|---|---|---|
| Adhesion | ISO2409:1992 (2mm) | Gt 0 |
| Indentation | ISO2815:1973 | Min 80 |
| Mandrel bend | ISO1519:1995 (5mm) | No cracking or detachment |
| Impact | ASTM D2794: 1969 (2.5Nm) | No cracking or detachment |
| Kesternich | ISO3231:1993 (0.21.S02-24 cycles) | Max 1mm corrosion creep from scribes |
| Acetic Acid Salt Spray | ISO9227:1990 (1000hrs) | Max 16mm2 over 10cm length of scribe |
| Accelerated Weathering | ISO1 1341-1994 Luminous intensity 550 W/m2 (290-800Nm) | Loss of gloss max 50% of original value. |
| Weathering | Florida 5° south facing 1 year (ISO2810:1974) | Residual gloss >50% of original (min) |
| Resistance to Mortar | ASTM B3260 (24hrs) | No residue after removal |
| Resistance to boiling water | 2 hrs deionised water or 1 hr pressure cooker | No defects or detachment |
| Condensed water | DIN50017:1982 (1000 hrs) Max 1mm under film creep | No blistering |
| Sawing, Milling, Drilling | | No cracking or chipping |
| Cupping Test | ISO1 520: 1995 5 mm min | (typically 7-9 min) |

Substrate used for these tests was aluminium alloy AA5005-H24 with a thickness of 0.8mm pre-treated according to DIN 50939: 1988

InverRAL also complies with requirements for Class 0 as defined in Approved Document B, "fire Safety" to the Building Regulations 2000.

## Specific Gravity

1.4 – 1.8 depending on colour, gloss etc

## Coverage

9 – 12 sq. m/kg @ 50 microns (100% utilisation assumed) depending on colour and gloss

## Film Thickness

Minimum 50-80 microns

## Curing Conditions

Gloss and semi gloss 180°C/10 mins object temperature. Matt 200°C/10 mins object temperature.

## Storage

**Valspar Powder Coatings**
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Store in dry, cool conditions, preferably below 30°C. Shelf life under these conditions will be approx 24 months.

## Pre- treatment

Conversion coating is essential in all cases. The metal must be thoroughly degreased with alkaline or acid cleaner. The conversion coating shall be applied by treatment with a solution of chromate or chromate/phosphate ions as active ingredients.

## Application Guidelines

Inver UKs' 'Qualicoat' approved powder coatings are suitable for use with all known electrostatic powder spraying equipment designed for thermosetting powder application.

## Individual Product Information

| | |
|---|---|
| Reference Number | BR803742G |
| Description | RAL 7015 SLATE GREY POLYESTER G |
| Gloss Level (60°) | 85-100 |
| Specific Gravity | 1.58 +/-0.10 |
| Stoving Schedule | 10 MINS @ 180C Metal Temperature |
| Film Thickness | 60-80 microns |
| SDS No: | |

## Health & Safety

We recommend all users of powder coatings to refer to the Code of Safe Practice: Application of Powder Coatings by Electrostatic Spraying (published by the British Coatings Federation of Great Britain Ltd) and our appropriate Health & Safety Data Sheet.

The InverRAL stock range of colours are matched to true 841-GL RAL standards for 80% gloss and 840-HR RAL standards for 35% matt. The colours depicted in the colour card and the range have been prepared as replications of these colours. However, as with all printing and manufacturing the colour chips may vary slightly in colour and gloss from actual coatings due to the effects of heat light and the manufacturing process.

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General Industrial Coatings

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