



Qualicoat Approved Architectural Range

Certificate Nos: P-0656, P-0676, P-1084, P-1097 Product tested and approved for the quality mark

Introduction

Inver Powder Coatings' Class 1 'Qualicoat' approved range of Architectural Polyesters are recommended for use on aluminium exterior situations where the 'Qualicoat' specification applies. Inver Powder Coatings' attention to formulation and particle size control ensures optimum transfer efficiency, enabling applied costs to be better controlled.

Colour

Wide range of RAL colours available and specials manufactured to order

Gloss

Three levels available (all measured at an incident angle of 60°)

Category 1:	< 30 +/-5 units
	31 – 70 +/- 7 units
Category 2:	including "BR"
	Metallics
	71 – 100 +/- 10
Category 3:	units

(Permissible variation from the nominal value)

Film Properties

Meets the following criteria:

AdhesionISO2409:1992 (2mm)Gt 0IndentationISO2815:1973Min 80MandrelISO1519:1995 (5mm)No cracking or detachmentImpactASTM D2794: 1969 (2.5Nm)No cracking or detachmentKesternichISO3231:1993Max 1mm corrosion creep from scribesAcetic AcidISO9227:1990Max 16mm2 over 10cmSalt Spray(1000hrs)over 10cm length of scribeMachuQualicoat method B1 (j)Max corrosionAcceleratedISO1 1341-1994Loss of gloss max Uuminous intensitySolowmColour change as defined in Qualicoat tethol B1So% of original value.KeatheringIuminous intensity50% of original value.WeatheringFlorida 5° south facing 1 year (ISO2810:1974)Residual gloss for original value.Resistance2 hrs deionised water or 1 hr pressureNo defects or detachmentKondrarCookerNo defects or detachmentCondensedDIN50017:1982 No blisteringNo blistering chaip in all marcepSolvent30 secsRating 3-4 chipping chippingSawing,ISO1 520: 1995 5 mm min(typically 7-9Testminmin			
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	Test	min	min)

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

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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 60 microns

Minimum Curing Conditions (Minutes at object temperature)

	Full Gloss Cat 3 &	Matt Cat 1
	Semi Gloss Cat 2	
210°C	5 mins	8 mins
200°C	6 mins	10 mins
190°C	8 mins	13 mins
180°C	10 mins	Not
		recommended
170°C	13 mins	Not
		recommended

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Maximum Cure Conditions

	Full Gloss Cat 3 &	Matt Cat 1
	Semi Gloss Cat 2	
210°C	5-15 mins	8-15 mins
200°C	6-16 mins	10-20 mins
190°C	8-18 mins	13-23 mins
180°C	10-20 mins	Not
		recommended
170°C	13-23 mins	Not
		recommended

Storage

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. A chromate or chromate-free pretreatment approved by Qualicoat or GSB should be used prior to powder coating.

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	QG710121SG
Description	RAL 8019 GREY BROWN POLYESTER SEMI GLOSS
Gloss Level (60°)	65-75
Specific Gravity	1.36 +/-0.10
Stoving Schedule	10 MINS @ 180C Metal Temperature
Film Thickness	60-80 microns
SDS No:	

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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.

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