



# 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 16mm <sup>2</sup> over 10cm length of scribe
Accelerated Weathering	ISO1 1341-1994 Luminous intensity 550 W/m <sup>2</sup> (290-	Loss of gloss max 50% of original value.

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	800Nm)	
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

Store in dry, cool conditions, preferably below 25°C. Shelf life under these conditions will be approx 12 months.

Inver UK Ltd Goodlass Road  
Speke, Liverpool  
L24 9HJ, England  
Tel + 44 (0) 151 486 0486  
Fax: + 44 (0) 151 486 0484  
Email: [info@inveruk.com](mailto:info@inveruk.com)



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## 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	BR707787SG
Description	RAL 9001 POLYESTER SEMI-GLOSS
Gloss Level (60°)	65-70
Specific Gravity	1.57 +/-0.10
Stoving Schedule	10 MINS @ 180C Metal Temperature
Film Thickness	60-70 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.