



## Powder Coating

## Polyester RAL Colours

Product Code	Per product
Colour	RAL
Gloss Level	From 20% matt through to 95% measured at 60o
Specific Gravity	1.4-1.8 dependent upon colour, gloss and other properties
Stoving Schedule	High bake, 200°C metal temperature for 10 minutes Standard bake, 180°C metal temperature for 10 minutes Low bake, 160°C metal temperature for 10 minutes
Film Thickness	60-80 microns
Heat Stability	Excellent colour stability on continuous exposure up to 130oc or intermittent exposure up to 140oc
Coverage	11-14 square metres per kilo at 50-70 microns for most applications.

### Introduction

The RAL stock range is a polyester powder coating recommended for use in both interior and exterior applications. Meets the full requirements of BS6496/7. Our attention to particle size control and formulation ensures optimum transfer efficiency.

### Storage and Handling

Store in dry, cool conditions, preferably below 25°C. Shelf life under these conditions will be approx 12 months. For full information on handling this product type, refer to individual Safety Data Sheet and the 'Code of Safe Practice' issued by the British Coatings Federation.

### 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

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

## Curing Conditions

High bake, 200°C metal temperature for 10 minutes

Standard bake, 180°C metal temperature for 10 minutes

Low bake, 160°C metal temperature for 10 minutes

## Film Properties

Adhesion	ISO2409:1992 (2mm)	Gt 0
Indentation	ISO2815:1973	Min 80
Mandrel bend test	ISO1519:1995 (5mm)	5 mm
Impact resistance	ASM D2794	No cracking or detachment
Kesternich	ISO3231:1993	No change
Acetic Acid Salt Spray	ISO9227:1990 (1000hrs)	Max 16mm <sup>2</sup> over 10cm length of scribe
Accelerated Weathering	ISO1 1341-1994	Loss of gloss max 50% of original value
Weathering	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	No defects or detachment
Condensed water	DIN50017:1982	No blistering
Sawing, Milling, Drilling		No cracking or chipping
Cupping Test	ISO1 520: 1995	5mm

## 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 (available on request).