

Technical Data Sheet

Alesta® HR HR00044059021



Product Description

Alesta® HR is a heat resistant powder coating, based on epoxy and silicon resins.

It offers an excellent resistance to high temperature (until 550°C) without deterioration of the film.

Approvals

This powder coating complies with the European Directives "Restriction of the use of certain hazardous substances" 2002/95/EC and 2011/65/EU (RoHS).

Substrates

Granulated steel

End use: Exhaust, Pipes, Barbecues

For specific applications please contact us.

Packaging : 15 or 20kg in plastic bag and cardboard box

Substrate Preparation

On steel: mechanical preparation is required: shot blasted steel (slight and homogeneous roughness).

Physical Properties

Specific Gravity	1.65
Particle Size distribution	25-29
Particle size, powder < 122 µm	> 95 %
Fluidity	120 – 160

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The following performances have been obtained under the conditions described below and in laboratory. Actual product properties such as gloss, colour and finish may vary according to condition of application.

Product Performance / Film Properties			
CONDITIONS			
Steel panels:	0.8 mm		
Surface pretreatment	Shot blasted steel		
Film thickness	45 µm +/- 10		
Curing Conditions	7' à 230°C (T° objet)		
TESTS		SPECIFICATIONS	GLOSS
	N°	DATES	
Gloss @ 60°	EN ISO 2813	1999	4 – 8 unités
Impact resistance	EN ISO 6272	2004	≥ 1 kg / 50 cm

Baking Window

General curing conditions :

- **Object t° / time**
7 min @ 230°C
10 min @ 210°C
17 min @ 200°C

Application

- Do not mix this product with another powder.
- Substrate should be correctly cleaned before use.
- Spraying can be done using either manual or automatic electrostatic CORONA guns.
- Many of our products can be applied using the TRIBO electric process. (please contact us for specific product advice)
- Film thickness: the required application settings will depend upon the geometry of the object being coated as well as the specified film thickness. It is the responsibility of the applicator to make the appropriate adjustments.

Comments

- Certain chemicals or domestic cleaning products can cause damage to the appearance of the coating. Please test a small inconspicuous area first to confirm suitability.
- Recycling of the powder: possible up to 30 % with the exception of some metallic and pearlescent products.
- Please contact us for specific questions.

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Storage Stability

6 months @ max 30°C

Safety

Consult the Safety Data Sheet prior to use product

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