



METALLIC STANDARD POLYESTERS

Technical Data Sheet

DESCRIPTION

Alwan PR29/METALLIC polyester is a thermosetting powder coating based on saturated polyester resins especially selected for good resistance to atmospheric ageing, U.V. light and saponification. These basic characteristics provide coating films showing excellent outdoor durability and outstanding decorative properties.

The crosslinking agent is also U.V. resistant and allows rapid cure of the powder by polyaddition mechanism without any release of reaction products.

Alwan PR29/METALLIC is particularly suitable for the decorative and protective coating of Aluminium, steel or galvanized building materials used for architectural purposes.

Qualicoat Approved System P-No: P-0708 Class 1 Category 2 Qualicoat Approved System P-No: P-0763 Class 1 Category 1 Outdoor Durable Meets or exceeds A.A.M.A. 2603

SPECIFICATION

POWDER PROPERTIES

Chemical type Polyester

1.2 – 1.75 depending on color and effect Specific gravity

Particle size distribution Applicable for electrostatic spray at 60 – 90 kV

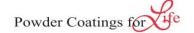
Physical Appearance Metallic

Gloss Matt - Glossy

Shelf Life 24 months at 27°C maximum storage temperature

10 minutes at 200°C (metal temperature) Curing schedule

12 minutes at 190°C (metal temperature)





MECHANICAL PROPERTIES

Adhesion ISO 2409 (2mm crosshatch) Gt=0

Bend test ISO 1519 (cylindrical mandrel) : Pass 5mm

Cupping test ISO 1520 Pass >5mm

Impact test ISO 6272-1 Pass 2.5 Nm (direct and reverse)

Buchholz test ISO 2815 >80

ENVIRONMENTAL AND CHEMICAL RESISTANCE

Resistance to SO2 **EN ISO 3231** No infiltration exceeding 1mm on both sides of

the scratch after 30 cycles (0.21 I SO2).

Acetic acid salt spray ISO9227 Maximum 16mm² infiltration over a scratch

length of 10cm. after 1000 hours testing.

Constant humidity ISO 6270-2 No blistering, creep <1mm after 1000 hrs.

Mortar resistance EN 12206-1 No effect after 24 hrs.

>50% gloss retention after 1000 hrs. Accelerated Weathering ISO 16474-2

Chemical Resistance Generally good resistance to acids, alkalis, and oils

at room temperature.

No chalking, excellent gloss retention and colour Exterior durability ISO 2810

stability after 1 year Florida Exposure.

TEST CONDITIONS

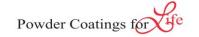
Determined on degreased chromated Aluminium to DIN 50939.

Metal substrate Al Mg1 (0.8 - 1.0 mm)

Coating thickness (ISO 2360) 60 - 90 microns DFT

Curing schedule 10 minutes at 200°C

Flow out Smooth





For other substrates, and in order to obtain optimal corrosion protection, it is essential to apply the following pretreatment prior to powder coating:

For steel : Iron or zinc phosphate

For galvanized steel : Chromate treatment

Suitable chrome-free pretreatment for Aluminium is also recommended. Due to variety of chrome-free pretreatments available today, only the approved system from Qualicoat should be used. Detailed advice should be sought from the supplier.

CORROSION RESISTANCE

Alwan PR29/METALLIC has been tested in a Salt spray Cabinet according to ASTM B 117 - 73, on various substrates .

Iron Phosphate 1000 hours : 8-10 mm undercutting

Zinc Phosphate 1000 hours : 3-6 mm undercutting

Chromated Galvanized Steel 500 hours : 10-15 mm undercutting

Chromated Aluminum 2000 hours : no change

STORAGE STABILITY

Due to its high Tg (Glass Transition Temperature) and its specific chemical composition, Alwan PR29/METALLIC powder when stored under cool dry conditions will not show any change in free-flowing properties after two years.

The information given in this Data Sheet is given in good faith and with every belief in its accuracy but cannot be considered as a formal warranty. In accordance with ALWAN's policy of product development, this specification is subject to change without notice.

