Fluorescent Polyester Matt Powder Coatings

Date: 29/01/2019

Product Code: The information given in this data sheet is generic for Thermaset Fluorescent Polyester Matt Powder Coatings.

Product Description:
Thermaset Limited offer a range of coloured fluorescent polyester matt powder coatings designed for interior use. This range is specially formulated on selected polyester resins and pigments to give a tough decorative finish in bright fluorescent colours.

Colours Available:
Thermasets’ Fluorescent Polyester Matt Powder Coatings come in a range of colours or can be matched to customer supplied samples.

Substrate Preparation:
For maximum adhesion the substrate must be thoroughly cleaned of grease, rust etc. by shot blasting, solvent or chemical degreasing. For maximum protection it is essential to pretreat the substrate prior to the application of Thermaset Limited Fluorescent Polyester Matt Powder Coatings. Aluminium components should receive a full multi-stage chromate conversion coating or similar chrome-free pretreatment to clean and prepare the substrate. Detailed advice should be sought from the pretreatment supplier. Galvanized steel requires multi-stage pretreatment with either zinc phosphate or chromate conversion. Depending on the type of galvanizing, degassing or use of anti-bubbling additives may be required. Detailed advice should be sought from the pretreatment supplier. Ferrous substrates require iron or zinc phosphate pretreatment. Detailed advice should be sought from the pretreatment supplier.

Application:
To achieve best fluorescent effect a white powder coated base coat must be used. We recommend our product TLP-1576-G RAL 9016 but any white powder coating may be suitable, test before using. Thermaset Limited Fluorescent Polyester Matt Powder Coatings can be applied by manual or automatic electrostatic spray equipment, an even dry film thickness of 60 microns is recommended. When applying over a powder coat base set gun to “Recoat” if setting available or drop to about 30 kV. Trials may be needed to find best settings. Care should be taken not to contaminate the white base coat surface before over-coating. Should oil contamination by handling without gloves or over-curing of base coat have occurred, the base coat may need degreasing with a mild detergent and/or slight abrasion with 800 sandpaper. Remove dust by blowing with clean dry air.

Powder Properties:
<table>
<thead>
<tr>
<th>Type</th>
<th>Thermosetting polyester with a non-TGIC curing agent.</th>
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<tbody>
<tr>
<td>60° Gloss (EN ISO 2813)</td>
<td>Visual only</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.5-1.8 depending on colour</td>
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<tr>
<td>Particle size</td>
<td>Suitable for electrostatic spray</td>
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<tr>
<td>Stoving schedule</td>
<td>See box label for recommended curing conditions.</td>
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<td></td>
<td>Typical values are; 10 minutes @ 180°C peak metal temperature</td>
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<tr>
<td>Storage and shelf life</td>
<td>12 months when stored in cool (below 25°C) dry conditions. Open boxes must be resealed.</td>
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</table>
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Test Conditions:
Unless otherwise specified, all tests have been carried out under laboratory conditions on 0.8mm aluminium chromated panels and are given for guidance only. Actual product performance will depend on the circumstances under which the product is used. A powder coating dry film thickness of 60-70 microns was used.

Mechanical Tests:
- Flexibility (cylindrical mandrel) ISO 1519 Pass minimum 5mm
- Buchholz Hardness ISO 2815 Pass minimum 80
- Impact ISO 6272-2 Pass minimum 2.5Nm
- Erichsen cupping ISO 1520 Pass minimum 5mm
- Adhesion (2mm cross hatch) ISO 2409 Pass Gt 0
- Scratch Resistance ISO 1518-1 Pass 4 Kg

Chemical Tests:
- Constant Humidity ISO 6270 Pass 1000 hours.
- Boiling water 2 hours No defects or detachments.
- Salt Spray Resistance ASTM B117 Pass 1000 hours
- Sulphur Dioxide ISO 3231 After 24 cycles, infiltration<1mm from scratch.
- Mortar resistance EN 12206-1 Easy to remove, no staining.

Exterior Durability:
Not recommended for exterior applications since the fluorescent pigments used may be adversely affected by direct sunlight. After 12 months exposure there would be no film breakdown or loss of protection.

Chemical Resistance:
Generally good resistance to acids, alkalis and oil at normal temperatures.

Health and Safety Precautions:
This product is intended for use only by professional applicators in industrial environments. Consult the relevant Material Safety Data Sheet available from Thermaset.

Restrictions of Hazardous Substances (RoHS2):
Thermaset Limited Fluorescent Polyester Matt Powder Coatings range is suitable for use on items covered by Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012 (Directive 11/65/EU, ROHS 2). Products in the range contain none (or less than the maximum allowed amount) of the following restricted chemicals:- Lead, Mercury, Cadmium, Hexavalent Chromium or their compounds.
Poly-brominated biphenyl (PBB) or Poly-brominated diphenyl ether (PDBE) flame retardants.

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