

IE Powder Coating

Product Description

IE series of powder coatings are mainly made of weather-resistant polyester resin without TGIC, which are suitable for coating of metal substrates in general industrial fields.

Film Appearance & Package

Appearance effects: smooth surface (all kinds of gloss range), sanding, hammer effect

Color: According to requirement

Packing: 20Kgs. Carton boxes with double PE-bag.

For more information, please contact us.

Physical Data

Specific gravity: 1.2-1.7 (depending on the gloss and color)

Dry flow ability: 120-160

Particle size: 100% < 160μm, according to requirement

Substrate & Preparation

Substrate: Aluminum profile, steel or galvanized steel sheet and other metal substrates. (For more information, please contact us).

Preparation: The substrate shall be pre-treated according to GB/T9271 or ISO 1514. The cold-rolled steel plate tested for salt spray resistance shall be phosphate in addition to GB/T 9217. If the product is applied in high-anticorrosive environment of C4 or above (rated according to ISO12944), it can be used with Huajia anticorrosive special primer (please consult us).

Curing Condition (Object Temperature)

-> Can be used such as IR, gas, hot convection drying path, oven and other ways of curing.

-> If use the gas oven to bake, combustion by-products will change the color of the film.

Recommended curing condition: Object temperature/time 180-200°C/10-15min

Application

- Do not mix this product with others
- The substrate must be properly pre-treated before use
- Manual or automatic electrostatic spraying can be used
- The film thickness should be determined according to the geometry and requirement of the coated object, and the performance should be evaluated when the film thickness is less than 60μm

黄山华佳表面科技有限公司

中国, 安徽省, 黄山市, 徽州区, 永佳大道 109#

电话: 0086 559-3515170 传真: 0086 559-3511660

网站: www.hjchem.com

Huangshan Huajia Surface Technology Co., Ltd

No. 109 Yongjia Ave., Huizhou Dist, Huangshan City, Anhui, PRC

Tel: 0086 559-3515170 Fax: 0086 559-3511660

www.hjchem.com

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Product Performance & Film Properties

PROPERTIES	TEST METHOD	CRITERIA
Film Thickness	ISO 2360	60-80um
Adhesion	ISO 2409	Class 0
Hardness	ISO 15184	≥F
Cupping Test	ISO 1520	≥5mm
Bend Test	ISO 1519	≤3mm
Salt Spray	ISO 9227	Pass at 500 hours - no corrosion area more than 2mm from scribe
Impact Test	ISO 6272	≥2.5Nm
	GB/T 1732	50cm*Kg
Humidity	ISO 6270	Pass at 500 hours – no blistering, creep ≤2mm
Accelerated Weathering Test	ISO 11341	500h Q-Sun test, ≥ 70 % Gloss retention , $\Delta E \leq 5$

Note: 1-All chemical and physical properties are laboratory test results (unless otherwise stated), and are for reference only in application. The performance still needs to depend on the final use environment of the product.
2-The substrate for the above chemical and physical tests is chromate aluminum plates, and all test plates are sprayed with a film thickness of 60 to 80 μm .

Storage Stability

Store in a cool ($\leq 35^{\circ}\text{C}$)、dry warehouse, prevent direct sunlight, and should be isolated from fire source, away from heat source. Storage life is 12 months from the date of production. For products with gloss less than 70%, storage life is 6 months@ 30°C . For special products, please refer to specific product description.

Safety Precaution

All dusts are respiratory irritants. Therefore, inhalation of the dust or of the vapour resulting from the cure should be avoided. Take step to prevent skin contact, but should contact occur, wash skin with soap and water. In case of eye contact flush immediately with clean water and seek medical advice. Dust and powder should not be allowed to build up on surface or ledge. Dust clouds of any finely divided organic material can be ignited with an electric spark or open flame. All equipment should be electrically earthed to prevent build up of static.

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