

PRIMECOAT SERIES 89

thermosetting powder coating for indoor use
 epoxy-polyester
 smooth gloss | semi gloss | semi matte | matte
 fine texture
 rough gloss texture | rough matte texture

Typical application

Protective and decorative coatings on metal items inside premises:

- Equipment, including medical equipment
- Shelves and racks
- Furniture, including that for schools, hospitals
- Machinery parts.
- Children's toys

Product details

- Packages: carton with antistatic PE bag liner, 20kg, 5kg or Big Bag for approx. 500 kg, net
- Storage Stability: 24 month from manufacture (see printed date on product label)
- Storage temperature: <25°C
- Specific Gravity (ISO 8130-2): smooth 1.50–1.65 g/cm³
 rough/fine texture 1.50-1.75 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): <0.4%
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: <10%
 - base fraction up to 32 µm in size: 25-45%

Gloss level

- Smooth gloss: 75–100*
- Smooth semi gloss: 60–75*
- Smooth matte: 10–40*
- Smooth semi matte: 40–60*
- Fine texture: visual comparison
- Rough glossy texture: visual comparison
- Rough matte texture: visual comparison

* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings).

Test results

Checked under laboratory conditions on a chromated 0.8 mm thick aluminium test panel.

| Test method | Test | Smooth | | | | Fine texture | Rough texture | |
|-------------|--|-----------|--------------|----------|--------------|--------------|---------------|-----------|
| | | Gloss | Semi gloss | Matte | Semi matte | | Gloss | Matte |
| ISO 2360 | film thickness recommended | 60-80 µm | 60-80 µm | 60-80 µm | 60-80 µm | 70-90 µm | 80-100 µm | 80-100 µm |
| ISO 2409 | cross cut test/adhesion 1 mm cutting distance | GT 0 | GT 0 | GT 0 | GT 0 | GT 0 | GT 0 | GT 0 |
| ISO 1519 | mandrel bending test cracking of coating | ≤5mm | ≤5mm | ≤10mm | ≤10mm | ≤10mm | ≤10mm | ≤32mm |
| ISO 2815 | impression hardness | ≥87 | ≥87 | ≥87 | ≥87 | - | - | - |
| ISO 3668 | coating color, deviation | ≤1 | ≤1 | ≤1 | ≤1 | ≤1 | ≤1 | ≤1 |
| ASTM D 2794 | ball impact test cracking of coating | No cracks | Minor cracks | Cracks | Minor cracks | Cracks | Cracks | Cracks |
| ISO 6270-1 | determination of resistance to humidity 500 h | ≤1mm | ≤1mm | ≤1mm | ≤1mm | ≤1mm | ≤1mm | ≤1mm |
| ISO 9227 | salt spray test 500 h | ≤1mm | ≤1mm | ≤1mm | ≤1mm | ≤1mm | ≤1mm | ≤1mm |

Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also special domestic shades on request*.

* Color of coating parameters other than indicated in the table can be agreed with the customer.

Pretreatments

Before the painting, the item should be adequately pretreated in accordance with surface type, final use and required performances.

The following table can be used as starting point for the pretreatment choice. The surface shall be clean, dry and appear with a rough and dull profile.

| Substrat | Indoor use |
|-------------------|---|
| Aluminium | soil removal, chromate, chrome-free |
| Steel | soil removal, iron phosphate, zinc phosphate, sand-blasting |
| Zinc coated steel | acid attack, iron phosphate, chromate |

Oxides (rust) cleaning and de-greasing shall be carried out when the simplified process is used!

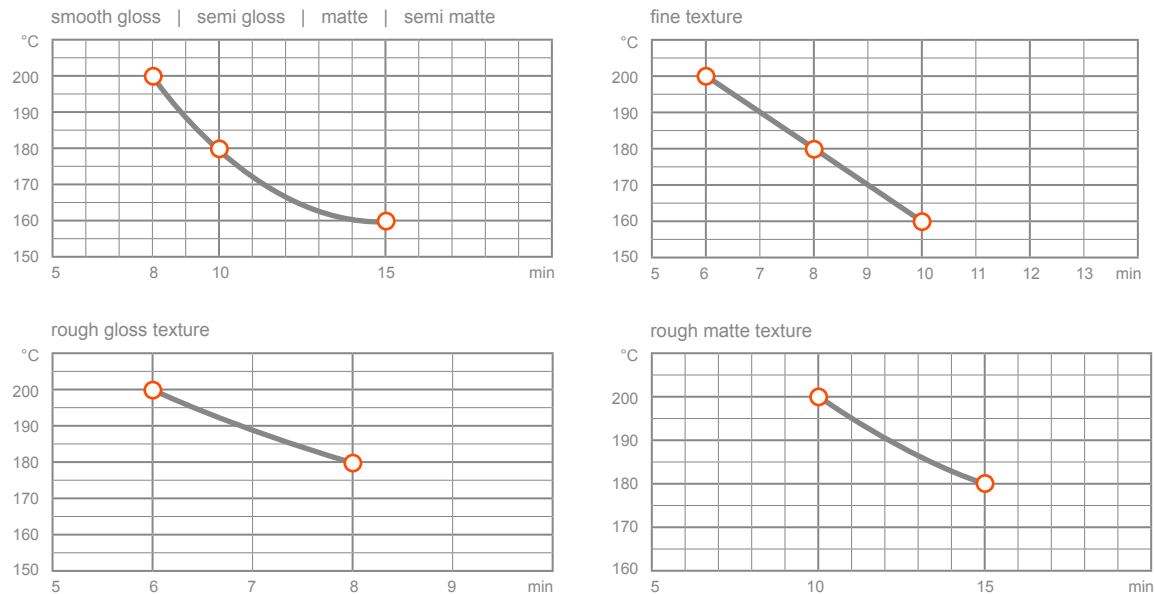
The simplified pre- treatment does not ensure necessary protective properties and decreases the service life of the coating.

Hot-dip galvanized steel requires additional mechanical processing (incision).

Cure parameters

Temperature and time combinations resulting in the optimal cross-linking of the coating.

Typical curing



Please observe cure parameters closely since mechanical properties will develop before full cross-linking!

To obtain optimal stoving conditions you are recommended to carry out practical trials each time, adapted to the carry out practical trials each time, adapted to the object in question and the stoving oven. Temperature conditions of curing for each powder listed on the label.

Our technical service department will be glad to advise you.

Note

The data is provided for information purposes and is not exhaustive. The customer using the product otherwise than indicated in the data sheet takes responsibility for the results obtained. As the manufacturer, we provide more precise product description, conditions of usage and all the application process accompanying factors. Due to the fact that direct control on our part cannot be effected in regards to the following of the aforementioned conditions, unless an additional written agreement is made, we offer no guarantees and hold no responsibility for the products usage and the results obtained.

Address:

Primatek Coatings OÜ
Kadastiku 29A
21004 Narva, Estonia

Contact:

Phone +372 655 1010
primatek-coatings.com

Bank details:

Swedbank AS:
EE87 2200 2210 5686 9100