

Technical Data Sheet

POWDER POLYESTER COATING

Type of base material:

Aluminium Alloys: 1xxx, 3xxx and 5xxx

Norms:

EN 573-3

EN 10204

Temper:

H0/111, H42, H44, H46, H48

EN 515

Dimension:

Width: up to 1600 mm
Length: up to 6000 mm
Flatness: 1/2 EN- Standard

Thickness of aluminium (without paint)

Thickness: 0,7 mm to 3 mm Coil
0,7 mm to 5 mm Sheet

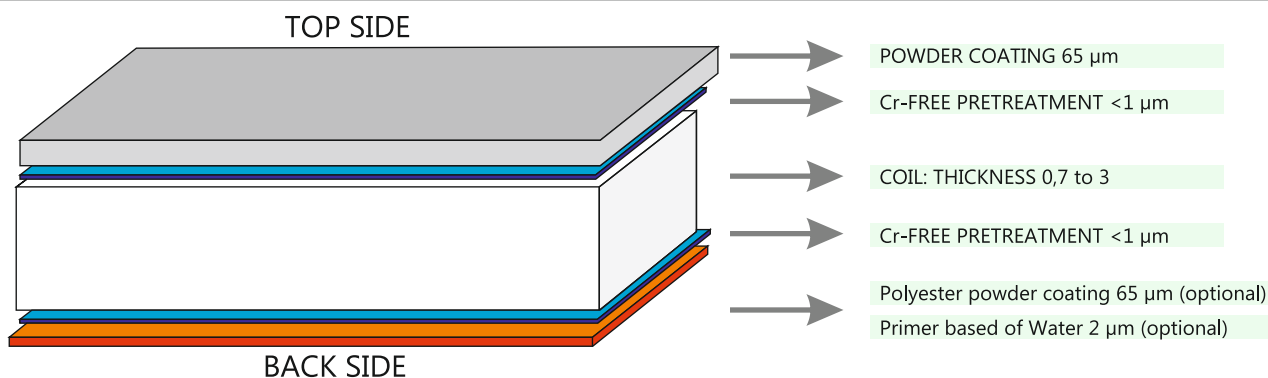
EN 485-4

Chemical pretreatment of material before paint:

Pretreatment: Alkaline + Acid cleaners before Cr-free conversion coating + Titanium

Characteristic of coating

Application	Type of paint	Layers coating	PVC protective film thickness
1 side	Powder coated	Polyester: 65 µm (minimun) ISO 2360 - EN 1396	30 to 100 µm
2 sides (Back Side)	Powder coated	Polyester: 65 µm (minimun) ISO 2360 - EN 1396	30 to 100 µm
	Pretreatment	Alk + Ac + Ti (without VOC)	30 to 100 µm
	Primer coated	Primer based of Water: 2 µm	



Protection Film = PE of 70/80µm, black/white, transparent or blue color and Laser cut (Co2 and Fiber)

***Properties

TEST	SPECIFICATION
PAINT TYPE EN 1396	Polyester Powder Coated (without COV, lead and chromium)
GLOSS - ISO 2813	Gloss 71-100±10 units / Satin 31-70±7 units / Matt 0-30±5 units
ADHESION EN ISO 2409	Class 0 (no pick off)
ERICHSEN EN ISO 1520	>5 mm.
IMPACT EN ISO 6272	Gloss 50 Kg. cm., Matt 30 Kg. cm.
ISO 1519 Bend Test	5 mm.
ISO 17132 T-Bending	OT**
CORROSION RESISTANCE: ISO 9227 / DIN 50021	1000 Hours
Fire resistance (EN 13501-1)	Classified A2 S1-do

*This data does not guarantee that this products is suited to your own particular use.

For extended warranty, please request it *Standards application of ECCA norms

Guarantee over 5 years**

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