



BULLCREM LACK

POWDER COATINGS



STABILIMENTO E SEDE LEGALE

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# Technical Data Sheet -version 2/2025-

**QLI410140001 PES AVORIO OP 1014**

*Approved product by Qualicoat Class 1 P- 1605*



Thermosetting powder coating with specifically selected resins, additives and pigments providing outstanding general properties; suitable for outdoor decorative applications requiring a high resistance to light and weather conditions.

## Fields of application

Architectural, Garden furniture, lighting systems, road signposts and other metal items for outdoor use.

## Product characteristics

Surface appearance: Smooth

Colour: Ivory

Substrate: Aluminium

Theoretical Density: 1.45 - 1.60 g/cm<sup>3</sup>

Shine (60°): 25 +/- 5 Gloss

ISO 2813

Fluidity SAMES: >140

Polymerization condition: 180°C X 15 – 30min

(actual on the piece) 190°C X 12 – 25min

200°C X 10 – 20min

**Theoretical yield:** multiply the average of the specific gravity by the requested thickness in microns. The obtained value is the consumption in grams per square meter

## Particle size distribution

The average particle size (d50) of powder coatings determined using the LASER method is normally between 35 and 45 microns. Special particle size distributions are available upon request, depending on the needs.

Bullcrem Lack Srl

P.IVA, C.F. e Reg. Imprese 03951000243 – Iscrizione R.E.A. di Treviso n. 373595 – Capitale sociale € 600.000,000 Int. Vers.

Società soggetta all'attività di direzione e coordinamento della Managlio Srl

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### Chemical-physical characteristics

All tests were performed in the laboratory under controlled standard conditions, on AA 5005-H24 alloy panels for mechanical tests with a thickness of 0.8 or 1 mm; while for corrosion tests on AA 6060 alloy panels with thicknesses of 60 - 80 µm

### Mechanical tests

Deep drawing – ISO 1520: PASS 5mm

Adhesion – ISO 2409(2mm crosshatch): Gt0

Bending – ISO 1519: PASS 5mm

Impact resistance – ISO 6272: PASS 2.5Nm

Buchholz Hardness – ISO 2815: >80

Accelerated aging ISO 16474-2 (1000H) – gloss retention > 50%

ISO 11507:1997 QUV B 313 (300H) - gloss retention > 50%

### Chemical/corrosion resistance

Salt spray-acetic acid ISO 9227 1000 hours: no bubbles higher than the value 2 (S2) of the ISO 4628-2 standard. Maximum film lifting 16mm<sup>2</sup> every 10cm of incision.

Humidistat ISO 6270-2 1000 hours: no bubbles higher than the value 2 (S2) of the ISO 4628-2 standard.

Corrosion in humid atmosphere containing sulphur dioxide ISO 22479 Method B: no penetration more than 1mm from both edges of the incision, no change in colour or presence of bubbles higher than the value 2 (S2) of the ISO 4628-2 standard

Resistance to mortar EN 12206-1: no change in appearance/colour after 24 hours.

Good resistance to acids, alkalis and oils at room temperature.

Natural Aging (Florida Exposure) – ISO 2810: color and gloss must meet the requirements of QUALITAL.

**Fire resistance classification: A2, s1, d0 film thickness =<120 µm according to EN13501-1:2018**  
**Reaction to fire for products, PCS (Higher Calorific Value) 17 – 27MJ/Kg according to EN ISO 1716:2018**

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The characteristics of the product, such shine, colour and finishing may vary based on the application and polymerization conditions.

Please feel free to contact us, should you use it in direct flame polymerization furnaces.

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### Preparation of the surface

Thoroughly remove grease, processing residues and rust from the item.

A suitable chemical conversion is recommended to achieve a good level of protection against corrosion before coating.



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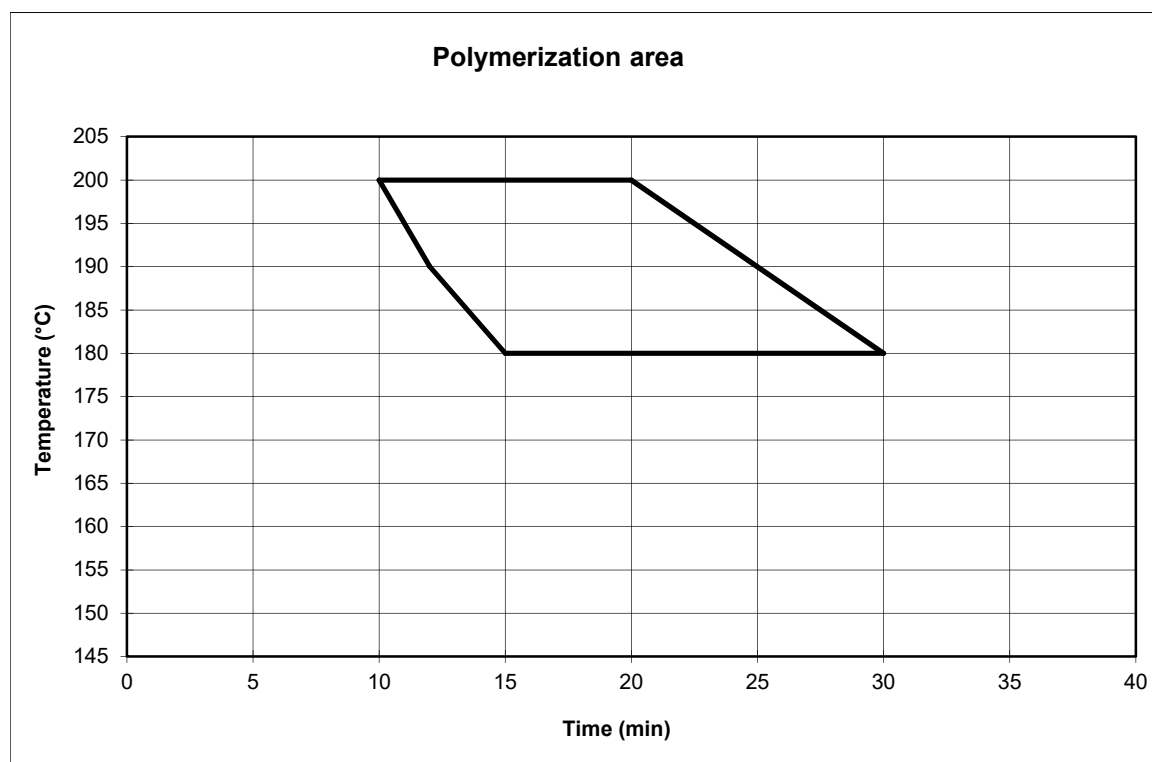
## Application

Do not mix this product with other powders in order to avoid possible incompatibility problems.  
We recommend a film thickness between 80 and 90 microns.

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## Storage

The product stored in a dry environment at a temperature below 30°C remains stable for at least 24 months, while below 35°C for at least 12 months.



The information hereby provided is the result of our experience and shall be subject to review. Data provided fall within the normal scope of the product characteristics and refer to specific materials only. Bullcrem Lack may not foresee all the variations to the final use, hence they can not provide any guarantee and shall accept no responsibility connected to the use of the aforementioned information.

The information contained in the present sheet is subject, without notice, to modifications for the continuous improvement of the product. For special information please feel free to contact our laboratory technicians.

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