



BULLCREM LACK

POWDER COATINGS



STABILIMENTO E SEDE LEGALE

Via del Lavoro, 20 - 31039 Riese Pio X (TV) - Italy

Tel: +39 0423 755 547 - [www.bullcrem-lack.com](http://www.bullcrem-lack.com)

## Technical Sheet

N. 1 / 2023

### QRG490030001 PES BIANCO RAG 9003

*Approved product by Qualicoat Class 1 P- 1557*



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: Red

Substrate: Aluminium

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

Shine (60°): n.a.

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.



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

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### Chemical-physical characteristics

All tests were carried out in a laboratory under controlled standard conditions, using panels made from an AA 5005-H24 alloy for mechanical tests; while corrosion tests were carried out on AA 6060 alloy panels.

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### 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%

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### Chemical/corrosion resistance

Acetic-salt spray ISO 9227: no corrosion, no film detachment < 16mm<sup>2</sup> corrosion/10cm, 1000 hours.

Humidistat ISO 6270 and immersion trials in distilled water ISO 2409: no blistering and loss of shine, 1000 hours.

Corrosion in an atmosphere containing sulphur dioxide ISO 3231: After 24 cycles, no blisters gloss loss or discoloration.

Good resistance to acids, alkalis and oils at normal temperatures.

Mortar Resistance EN 12206-1: no effect after 24 hours

Exterior durability - ISO 2810 (1 year): >50% gloss retention, colour retention accords with Qualicoat

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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.

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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### Application

Do not mix this product with other powders in order to avoid possible incompatibility problems. For metallic effect powders, we suggest to work on a spray-to-waste basis as their metallization is obtained by means of a dry-blend process of components with different chromatic aspects and specific weights.

As a result of different coating processes and, if any, of overspray recycling methods, the final metallic effect might present substantial differences in colour and aspect from the initial standard. For all metallic effect powders the corona application is recommended.

Metallic effect coatings are generally not scratch resistant. We recommend to handle such objects with care.

We recommend a film thickness between 60 and 90 microns. For yellow, orange and red coatings a film thickness between 100 and 120 microns is recommended.

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### Storage

The product stored in a dry place at a temperature below 30°C stays stable for at least 36 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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