Technical Data Sheet

BPCOAT TF SERIES (HAA POLYESTER)
Product Name: SMOOTH GLOSSY POWDER COATING
Product Code: 10.3……..

Product Description

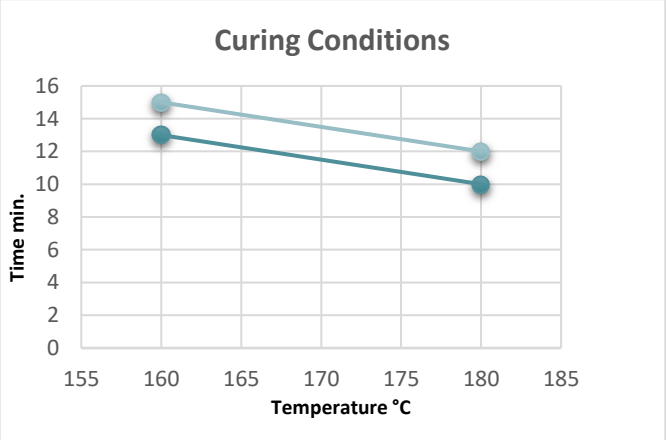
BPCOAT TF Architectural series is a TGIC-free polyester powder coating. BPCOAT TF Architectural series meets the requirements of the construction industry with its excellent outdoor durability and mechanical properties. BPCOAT-TF Architectural Series offer similar mechanical properties to polyester with TGIC system but have some distinct advantages and disadvantages. Advantages are higher transfer efficiency, excellent storage stability, better flow of surface. The only disadvantage of this system is film thickness but this problem is solved considerably by improved formulations. The most important feature of this group is not contain heavy metals and toxic substances harmful to the human health

Approvals

This product approved by QUALICOAT.
Class 1 P -1988

Powder Properties

Chemical Type	TGIC free polyester
Color	Various
Surface	Smooth
Specific Gravity	1,2 -1,9 g/cm^3
Storage	Keep in dry cool area.Temperature is 25 °C
Shelf Life	24 months
Curing Conditions	180 °C - 10 ' - 12’
(Object Temperature)	160 °C - 13 ' – 15 ‘



Test Conditions	The results are based on mechanical and chemical tests which have been carried out under laboratory conditions.

Substrate	Aluminum (0,5- 0,8 mm)
Pretreatment	Chrome free pretreatment
Curing Conditions (Object temperature)	180 °C - 10 '
Film Thickness	60 - 80 µm
Theoretical Coverage	It varies depending on formula and film thickness

Mechanical And Chemicals Test

Gloss @ 60° EN ISO 2813	80-95 gloss
Impact Resistance EN ISO 6272 / ASTM D2794	2,5 Nm / 22 inch-pound
Adhesion EN ISO 2409	GT=0
Flowing EN ISO 8130-5	100 - 250
Buchholz Hardness EN ISO 2815	>67
Cupping EN ISO 1520	>6 mm
Cylindrical Mandrel Bending EN ISO 1519	<5 mm

Salt Spray 1000 h EN ISO 9227	No blistering
Yellowing After 1 hour curing	< 2 - 3
Weathering - Florida EN ISO 2810	1 year, excellent.Residual gloss ≥ 50%, Colour change ΔE: According to Qualicoat requirements,
Accelerated weathering - Xenon lamp EN ISO 16474-2	1000 hours excellent. Residual gloss ≥ 50%, Colour change ΔE: According to Qualicoat requirements,
Accelerated Weathering - UVA- 340 EN ISO 16474-3	1000 hours, excellent. Residual gloss ≥ 50%

Pre Treatment

Powder coating is primarily used in steel, galvanized steel, aluminum copper and zinc alloy metal surfaces. To prevent oxidation of the surface is usually oily and greasy which cause several problems for coating. So metal surface should be cleaned by a variety of chemical methods prior to coating methods in order to get the highest performance. Oil, soil, metal oxides, rubber and plastics must be thoroughly removed.
In order to improve corrosion resistance, iron phosphate or zinc phosphate is strongly used for steel surfaces. Surface preparation should be chosen according to type of substrate and required performance.The suitability of the surface preparation should be tested by the coater before using appropriate test methods.

Powder Application

BPCOAT powders can be applied by tribo or corona charging at 30 to 100 kV.
Film thickness should be minimum 60 µm.
Do not mix this product the with other powder coatings.

Application Area

Aluminium profile, garden and park furniture, steel door, exterior lighting equipment, traffic signs, Automotive accessories and Agricultural machinery.

For Reference Only!

All specifications in this technical data sheet are based on our current knowledge. The possibility of product development, this specification is subject to change without notice. We recommend users to test the product in their work side before repetitive use by using this data just as a guide.

More details on our web site at www.bpc.com.tr

Send technical inquiries to **bpc@bpc.com.tr**