

# Technical Data Sheet

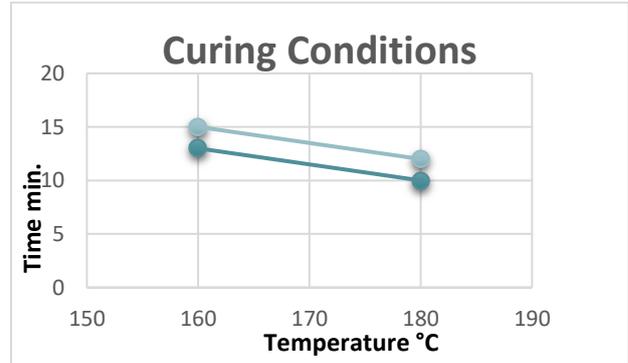
## BPCOAT TF SERIES (HAA POLYESTER)

**Product Name:** SMOOTH MAT POWDER COATING

**Product Code:** 03.3.....

**Product Description** BPCOAT TF Series is TGIC free polyester powder coating. It is designed for interior or exterior use. BPCOAT-TF 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

Powder Properties	Chemical Type	TGIC free polyester
Color	Surface	Smooth
Specific Gravity	Storage	Keep in dry cool area. Temperature is 25 °C
Shelf Life	Shelf Life	24 months
Curing Conditions	Curing Conditions	180 °C - 10 ' - 12'
(Object Temperature)	(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 5-35 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

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Salt Spray 500 h  
EN ISO 9227

No blistering

Yellowing  
After 1 hour curing

< 2 - 3

Accelerated Weathering - UVA- 340  
EN ISO 16474-3

1000 hours, excellent. Residual gloss  $\geq$  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  $\mu$ m.

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](http://www.bpc.com.tr)

Send technical inquiries to [bpc@bpc.com.tr](mailto:bpc@bpc.com.tr)