



Powder Coating

PY1005BR999C / RRS AC CLEARCOAT HG

Characteristics	<ul style="list-style-type: none"> ■ Powder coating for exterior use requiring high quality standards ■ Application, e.g. in the automotive sector ■ high glossy, smooth ■ Good mechanical resistance and surface hardness ■ Very smooth to apply ■ Very good light and weather resistance 												
System Coating	<ul style="list-style-type: none"> ■ System Liquid Coating <p>For various applications, there are coatings available, whose optical appearance regarding colour, gloss degree and surface is in optimum balance.</p>												
Technical / Physical Data	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">■ Binder-Base</td> <td>GMA acrylic</td> </tr> <tr> <td>■ Colour</td> <td>colourless (= RA999)</td> </tr> <tr> <td>■ Gloss value <small>visual</small></td> <td>high glossy</td> </tr> <tr> <td>■ Test layer thickness</td> <td>80 µm by colour RA999</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,15-1,2 g/cm³</td> </tr> <tr> <td>■ Material usage</td> <td>0,09 kg/m² with 80 µm mean test layer thickness</td> </tr> </table>	■ Binder-Base	GMA acrylic	■ Colour	colourless (= RA999)	■ Gloss value <small>visual</small>	high glossy	■ Test layer thickness	80 µm by colour RA999	■ Density <small>calculated</small>	1,15-1,2 g/cm ³	■ Material usage	0,09 kg/m ² with 80 µm mean test layer thickness
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Resistance Test	<ul style="list-style-type: none"> ■ on aluminium Q-Panel AQT ■ Condensate constant climate <small>DIN EN ISO 6270-2 (CH)</small> 240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8 ■ Salt spray test (CASS) <small>DIN EN ISO 9227</small> 240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8 ■ Chemical resistance Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome. 												
Processing and application Dependent on plant and buildings	<ul style="list-style-type: none"> ■ Processing / Loading Corona ■ Recommended coating thickness 60 - 130 µm ■ Pretreatment The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. If requirements are more demanding than this, we recommend appropriate levels of phosphatizing or chromating. 												

Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications. The sale of our products is in accordance with our terms of business and delivery.



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	<ul style="list-style-type: none"> ■ Touch-up coating: on enquiry ■ Health & Safety at Work guidelines The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet. 										
<p>Curing</p>	<ul style="list-style-type: none"> ■ Baking window Baking window tested in colour shade RA999 green cross-hatching = baking conditions with good final properties <p>The displayed baking conditions are based on results from laboratory tests and therefore merely serve as a guideline when configuring the processing company's coating systems. The processing company is responsible for ensuring that the coating is fully cured. The complete curing of the coating must be checked by means of additional analytical and resistance tests using representative original parts under production conditions. Please do not hesitate to contact us if you require consultation.</p> <div data-bbox="606 869 1500 1299"> <table border="1"> <caption>Baking Window Data</caption> <thead> <tr> <th>t [min]</th> <th>T [°C]</th> </tr> </thead> <tbody> <tr><td>8</td><td>185</td></tr> <tr><td>10</td><td>170</td></tr> <tr><td>16</td><td>160</td></tr> <tr><td>56</td><td>160</td></tr> </tbody> </table> </div>	t [min]	T [°C]	8	185	10	170	16	160	56	160
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<p>Resistance to storage</p>	<ul style="list-style-type: none"> ■ Approx. 12 month in original packagings at an ambient temperature of 5 to 23 °C. Powder coatings must be stored in a cool and dry place. <p>The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.</p>										
<p>Specific comments</p>	<ul style="list-style-type: none"> ■ Protective screening: 160 µm ■ Not compatible with other powder coatings (crater formation). ■ Test conditions All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information. The information provided here contains reference values and does not constitute a specification. <p>Packaging temperature</p>										



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Maximum recommended packaging temperature for finished, coated wheels with this product: 40°C.

Subsequent treatment

The coated surface must be dry and free of grease, silicone and dust before recoating, printing or bonding.

Pre-cleaning with a coating-compatible cleaning agent, such as a 50/50 isopropanol/water mixture, is applied during bonding.

This product does not correspond to the requirements of DBL 7381.50