



HMG Powder Coatings Limited

Dill Road, Castlereagh Industrial Estate, Belfast, BT6 9HU
Tel. +44 (028) 9079 4930 Fax. +44 (028) 9040 1187
www.hmgpowdercoatings.com
sales@hmgpowdercoatings.co.uk

Soft Feel Dead Matt

Product Description	A velvet matt powder coating that exhibits a soft, warm to the touch property. The coating is designed for use on decorative components such as bottles, domestic appliances, office furniture and any other component where a tactile property is desirable.		
Powder Properties	Chemistry	A thermosetting resin system based on a carboxylated polyester resin and a multifunctional curing agent.	
	Application	Corona electrostatic spray. The system can be modified for Tribo application as required.	
	Coating Thickness (DFT)	Depending on covering power and shade, general recommendation is 60-100 microns (μm), with a minimum thickness of 60 μm .	
	Gloss (ISO 2813)	Dead Matt <5 GU	
	Specific Gravity	1.40 – 1.60 g/cm^3 depending on colour.	
	Coverage	From 10-14 m^2/kg at 60 microns film thickness.	
	Storage & Shelf Life	When stored in a cool (<20°C), dry environment: 12 months.	
	Curing Schedule	10 minutes at 200 Celsius (object temperature) Full cure is required to achieve the matt velvet effect. Under-cure results in a glossier surface.	
Pretreatment	To ensure maximum adhesion the substrate must be thoroughly clean, free from grease, oil, rust, mill scale or any other contaminant. Cleaning may be carried out either by shot blasting, solvent or chemical degreasing. For applications where high corrosion or chemical resistance is required the substrate should be chemically treated prior to powder coating, typically:		
	Ferrous substrates	iron or zinc phosphate	
	Zinc coated steel	zinc phosphate or chromate conversion	
	Aluminium	chromate conversion	
Mechanical Tests	Unless otherwise specified, all tests were carried out under laboratory conditions on 0.8mm degreased and zinc phosphated steel panels. A powder coating DFT of 60-70 microns was used.		
	Hardness	ISO 2815 Buchholtz Indentation	>80
	Flexibility	ISO 1519 Cylindrical Mandrel	Pass >5mm
	Adhesion	ISO 2409 2mm Crosshatch	Pass Gt0
	Cupping	ISO 1520 Erichsen	Pass >5mm
	Impact	BS 3900: Part E7	>25kg cm (N)

HMG Powder Coatings Ltd (HMG) decline any liability with respect to the use made by anyone of the information contained herein. The information contained herein represents HMG's best knowledge thereon without constituting any express or implied guarantee or warranty of any kind (including, but not limited to, regarding the accuracy, the completeness or relevance of the data set out herein). HMG is the sole owner or authorised user of the intellectual property rights relating to the information communicated. The information relating to the use of the products is given for information purposes only. No guarantee or warranty is provided that the product is adapted for any specific use. The user or purchaser should perform its own tests to determine the suitability for a particular purpose. The final choice of use of a product remains the sole responsibility of the user.

Soft Feel Dead Matt

Corrosion and Durability	Neutral Salt Fog	ASTM B117 (250 hours)	Pass – Corrosion creep <2mm from scratch
	Mortar Resistance	ASTM C207	Easy to remove. No staining
	Boiling Water	2 hours boiling water	No defects or detachments
	Humidity	BS 3900 Part F2	More than 1000 hours without effect
	Chemical Resistance	Resistant to most acids, alkalis and oils.	
Colour Availability	All colours from BS 5252, BS 4800, BS 381C, RAL Classic, RAL Design, Pantone and NCS ranges. Any submitted colour standard can be manufactured to customer's requirements		
Restriction of Hazardous Substances (RoHS/RoHS2)	This product conforms to the Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations (RoHS and RoHS2) Directive. It does not contain any compounds of lead, mercury, cadmium or hexavalent chromium; nor does it contain polybrominated biphenyls (PBBs) or polybrominated diphenyl ether (PBDE).		
Health & Safety	This product is intended for use only by professional applicators in industrial environments. Consult the relevant health and safety data sheet indicated in the box label before use.		
Application Notes	<p>Although the product does have good finger-marking resistance, for objects with a heavy traffic such as railings, the product should be tested before use. In dark colours especially there may be polishing marks after rubbing.</p> <p>The gloss level of the range is very low – 2-4 Gloss Units typically. Lab tests have shown that decreasing the residence time in the oven, or curing at a lower temperature can dramatically increase the gloss level. Higher gloss products will not exhibit the velvet feel.</p> <p>Owing to the low gloss range, even minor increases in measured gloss will be clearly apparent; we recommend that the user take adequate precautions to ensure the temperature range and residence time in the oven be kept at a very tight tolerance.</p>		



HMG Powder Coatings Ltd (HMG) decline any liability with respect to the use made by anyone of the information contained herein. The information contained herein represents HMG's best knowledge thereon without constituting any express or implied guarantee or warranty of any kind (including, but not limited to, regarding the accuracy, the completeness or relevance of the data set out herein). HMG is the sole owner or authorised user of the intellectual property rights relating to the information communicated. The information relating to the use of the products is given for information purposes only. No guarantee or warranty is provided that the product is adapted for any specific use. The user or purchaser should perform its own tests to determine the suitability for a particular purpose. The final choice of use of a product remains the sole responsibility of the user.