



## HMG Powder Coatings

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## Batch-to-Batch Colour Tolerances

The manufacture of powder coatings is an industrial process and subject to inherent deviations owing to industrially-manufactured raw materials and their preparation process. Additionally, applied coatings may differ in colour by variations in film thickness, viewing angle, smoothness of film, application equipment and lighting type.

HMG Powder Coatings Ltd take every precaution to ensure colour accuracy and consistency of finish to reduce batch to batch variations. The European Paint Association (CEPE) have issued guidance on permitted variation to the RAL-841GL standard, and on batch variation thereafter. HMG work within these tolerances, extrapolating the guidance to include non-RAL Classic colours too.

Metallic and effect shades are very complex with regard to colour and even more so susceptible to variations in application settings, and CEPE explicitly exclude them from their guidance. For these shades, a master panel and permitted variances should be agreed between HMG and the customer for products applied at the HMG lab; process-specific colour fluctuations at the coater cannot be considered in the assessment of the powder coating as supplied. CEPE have issued further guidance on the use of metallic effect powder coatings.

For further information, please refer to:

- BCF guide to colour tolerances
- CEPE recommendation on permitted colour variation
- CEPE guidance on the use of metallic effect powder coatings
- Metallic effects – HMG guidance on application

All of which are available for download from the Resources section of our website.