



# 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

## Alloy Wheel Black Polyester

837-0R905C-3825

<b>Product Description</b>	An exterior durable system offering excellent corrosion resistance, gloss retention and mechanical properties. The extremely high gloss level and definition of image gives this black powder coating a mirror-like surface finish. Additionally, its ability to retain its mirror-like finish even at high film builds make it ideal for intricate alloy wheels, either as a finish in its own right, or as a base coat. When used as a base coat for liquid paint chromes, it will lend a deep flop to the chrome finish.		
<b>Key Benefits</b>	Piano Black finish High Build without losing DOI No lacquer required when used as a top coat finish Use as a base coat for liquid paint chromes		
<b>Powder Properties</b>	Chemistry	Thermosetting carboxylated polyester cured with a multifunctional curing agent.	
	Application	Corona electrostatic spray.	
	Coating Thickness (DFT)	General recommendation is 60-100 microns ( $\mu\text{m}$ ), with a minimum thickness of 60 $\mu\text{m}$ .	
	Gloss (ISO 2813)	Gloss	>96 GU
	Specific Gravity	1.25 g/cm <sup>3</sup>	
	Theoretical Coverage	From 13 m <sup>2</sup> /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	
<b>Pretreatment</b>	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	
<b>Mechanical Tests</b>	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 >4mm
	Impact	BS 3900: Part E7	>20kg cm (N)
<b>Corrosion and Durability</b>	Sulphur Dioxide	Kesternich Test ISO 3231	After 24 cycles, infiltration <1mm from scratch
	Neutral Salt Fog	ASTM B117 (500 hours)	Corrosion creep <2mm from scratch Adhesion – Gt0
	Mortar Resistance	ASTM C207	Easy to remove. No staining
	Boiling Water	2 hours boiling water	No defects or detachments
	Humidity	BS3900: Part F2	Pass. 1000 hours without any effect.

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.

# Alloy Wheel Black Polyester

Exterior Durability	After 12 months, minimal loss of gloss or colour change. No film breakdown or reduction in protective properties
<b>Chemical Resistance</b>	This product shows excellent resistance to water, brine, hydrochloric acid, dilute sulphuric, acetic and phosphoric acids, dilute alkalis, peroxides and bleach, alcohols and urea.
<b>Colour Availability</b>	A deep Jet Black, close match to RAL 9005 and BS 00 E 53.
<b>Restriction of Hazardous Substances (RoHS/RoHS2)</b>	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).
<b>Health &amp; Safety</b>	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.



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.