



# HMG Powder Coatings Limited

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## Epoxy Polyester Hammer & Antique

<b>Product Description</b>	Designed where the user requires a superior decorative finish for indoor applications. This structured finish is similar in appearance to the 518 Ripple Texture effect, but showing an attractive metallic vein through the coating. The range typically offers good toughness and chemical resistance and a tactile surface ideal for masking small flaws in the underlying substrate. Antique effects are similar to hammer effects, but have a more pronounced metallic vein that may be silver, gold, copper, etc. Typical applications include toys, furniture, electrical enclosures, etc.	
<b>Key Benefits</b>	Excellent aesthetics Good corrosion resistance Good chemical resistance Good hardness Excellent adhesion	
<b>Powder Properties</b>	Chemistry	A thermosetting epoxy-polyester resin system.
	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 80-120 microns ( $\mu\text{m}$ ), with a minimum thickness of 60 $\mu\text{m}$ . The appearance of structured finishes will be affected by film thickness and our recommendation is to ensure a tightly controlled DFT range.
	Sheen (ISO 2813)	Gloss or Semi-Gloss
	Specific Gravity	1.30 – 1.50 g/cm <sup>3</sup> depending on colour.
	Coverage	From 10-14 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	See box label for curing conditions. Typical object temperature conditions are: 10 minutes at 180 Celsius (object temperature)
<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 >5mm
	Impact	BS 3900: Part E7      >25kg cm (N)

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<b>Corrosion and Durability</b>	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.	

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<b>Colour Availability</b>	A range of shades are available. Any submitted colour standard can be manufactured to customer's requirements.		
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<b>Restriction of Hazardous Substances (RoHS/RoHS2)</b>	This product range 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).		
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<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.		
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