HMG Powder Coatings Limited

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Epoxy Polyester Ripple Texture

Product Description	Designed where the user requires a superior decorative finish for indoor applications. These structured finishes, often interchangeably described as “Ripple”, “Leatherette”, “Coarse Texture”, or “River Textures”, are attractive tactile coatings and are often used in office furniture, tool boxes, handrails, hand tools, shelving, electrical enclosures, etc. The range offers good resistance to chemicals and the uneven surface inherent in the product covers many small flaws that may be present on the substrate surface.		
Key Benefits	Excellent aesthetics Good corrosion resistance Good chemical resistance Good hardness Excellent adhesion Tactile surface		
Powder Properties	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 70-100 microns (µm), with a minimum thickness of 60 µm. The appearance of structured finishes will be affected by film thickness and our recommendation is to ensure a tightly controlled DFT range.	
	Sheen	Matt, Gloss or Semi-Gloss	
	Specific Gravity	1.50 – 1.70 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^{o}C), dry environment: 12 months.	
	Curing Schedule	The system is available as a standard bake or fast cure system on request. See box label for curing conditions. Typical object temperature conditions are: Standard Bake: 10 minutes at 180 Celsius (object temperature) Fast Cure: 10 minutes at 160 Celsius (object temperature)	
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)

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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	A range of shades are available. Any submitted colour standard can be manufactured to customer's requirements.		
Restriction of Hazardous Substances (RoHS/RoHS2)	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).		
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.		

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