



HMG Powder Coatings Limited

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Reclamation Range

Part of the 617 range

Product Description	A collection of powder coating manufactured from materials reclaimed from HMG's manufacturing process. The products offer a cost-effective and, as their raw materials are diverted from landfill, environmentally-friendly solution. The coatings apply as per a normal powder coating and offer all the protective benefits of a standard powder coating. Typical applications include shelving, racking, protective coatings, tool cases, office furniture, etc.	
Key Benefits	Excellent opacity Good corrosion resistance Good resistance to detergents Eco-friendly Excellent adhesion	
Powder Properties	Chemistry	A thermosetting epoxy-polyester resin system.
	Application	Corona electrostatic spray.
	Coating Thickness (DFT)	General recommendation is 60-100 microns (μm), with a minimum thickness of 60 μm .
	Gloss (ISO 2813)	75 \pm 10 GU
	Specific Gravity	1.40 - 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°C), dry environment: 12 months.
	Curing Schedule	10 minutes at 180 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 >10mm
	Adhesion	ISO 2409 2mm Crosshatch Pass Gt0
	Cupping	ISO 1520 Erichsen Pass >5mm
	Impact	BS 3900: Part E7 >20kg cm (N)

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Gumbo Grey

Corrosion and Durability	Neutral Salt Fog	ASTM B117 (250 hours)	Pass – Corrosion creep <2mm from scratch
	Boiling Water	1 hour boiling water	No defects or detachments
	Humidity	BS 3900 Part F2	More than 500 hours without effect
	Chemical Resistance	Resistant to most acids, alkalis and oils.	
Colour	A number of colours are available. Owing to the nature of the manufacturing process, the batch-to-batch tolerances are larger than HMG's norm. The products are not recommended for users requiring a high batch-to-batch consistency.		
	Gumbo Grey	617-1S070P-134	Smooth finish. Light grey, approximately BS 00 A 05
	Gumbo Black	617-1S095P-1062	Smooth finish. Black, approximately RAL 9005 / BS 00 E 53
	Gumbo Silver	616-1S100P-4542	Smooth finish. Silver metallic effect
	Dakota Black	519-1S095P-206	Fine textured finish. Black, approximately RAL 9005 / BS 00 E 53
	Dakota White	519-1S095P-4869	Fine textured finish. White
	Dornan Grey	519-2S070P-4430	Fine textured finish. Light grey, approximately BS 00 A 05
	Dornan Silver	616-2S100P-4762	Fine textured finish. Silver metallic effect
Restriction of Hazardous Substances (RoHS/RoHS2)	These products conform to the Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations (RoHS and RoHS2) Directive. They do not contain any compounds of lead, mercury, cadmium or hexavalent chromium; nor do they contain polybrominated biphenyls (PBBs) or polybrominated diphenyl ether (PBDE).		
Health & Safety	These products are intended for use only by professional applicators in industrial environments. Consult the health and safety data sheet SDS1005 before use.		



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