



HMG Powder Coatings Limited

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Polyester Dead Matt

Product Description	A powder coating that exhibits an extreme flat matt surface. The microstructure of the surface gives a satin feel. The coating is designed for use on decorative components such as furniture, lighting, domestic appliances, office furniture and any other component where a high design standard is demanded.		
Key benefits	Weather-resistant coating Deep matt Superb smoothness Low picture framing Good chemical resistance No toxic ingredients		
Powder Properties	Chemistry	A thermosetting resin system based on an acrylic/carboxylated polyester copolymer 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 60-100 microns (μm), with a minimum thickness of 60 μm .	
	Gloss (ISO 2813)	Dead Matt <5 GU	
	Specific Gravity	1.40 – 1.60 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 200 Celsius (object temperature) The object temperature must reach 200°C to achieve the dead matt effect. Lower temperatures result in a glossier surface.	
Pretreatment	To ensure maximum adhesion the substrate must be thoroughly clean, free from grease, oil, rust, mill scale or any other contaminant. For applications where high corrosion or chemical resistance is required the substrate should be chemically treated prior to powder coating, typically:		
	Steel	Chemical pre-treatment such as zinc phosphating or blasting with a suitable medium and priming with HMG NZP primer.	
	Galvanised Steel (HDG)	Suitable chemical pre-treatment or blasting with a non-ferrous medium and priming with HMG Eposeal primer.	
	Aluminium	Chrome-free GSB- or Qualicoat-approved chemical treatment	
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	Sulphur Dioxide	Kesternich Test ISO 3231	After 24 cycles, infiltration <1mm from scratch
	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.	
Weathering	Accelerated	UV-B 313 Test, ISO 11507	After 300 hours, residual gloss >50%
Colour Availability	All colours from BS 5252, BS 4800, BS 381C, RAL Classic, RAL Design, Pantone and NCS ranges. Any submitted colour standard can be manufactured to customer's requirements		
Restriction of Hazardous Substances (RoHS/RoHS2)	This product conforms to the Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations (RoHS, RoHS2 and RoHS3) 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.		
Application Notes	<p>Although the product does have good finger-marking resistance, for objects with a heavy traffic such as railings, the product should be tested before use. No physical or chemical abrasive should be used in cleaning.</p> <p>The gloss level of the range is very low – 2-4 Gloss Units typically. Lab tests have shown that decreasing the residence time in the oven, or curing at a lower temperature can dramatically increase the gloss level.</p> <p>Owing to the low gloss range, even minor increases in measured gloss will be clearly apparent; we recommend that the user take adequate precautions to ensure the temperature range and residence time in the oven be kept at a very tight tolerance.</p>		



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