

APCOSHIELD DURO

PC23

POWDER COATINGS

Product Data Sheet



PRODUCT DESCRIPTION

APCOSHIELD DURO series thermosetting Super Durable Polyester powder coatings provide a combination of good mechanical, corrosion resistance and weather resistance properties and can be custom formulated with finishes from high gloss to Matt and texture to meet demanding requirement of Architectural Aluminum extrusion, Window frames & facades. The product conforms to AAMA 2604-05 standard.

APCOSHIELD DURO range products are suitable for indoor and outdoor applications of Architectural Coatings.

The Product Data Sheet is standard for the APCOSHIELD DURO range products and specific shades within the range can vary. Datasheets for individual products are available.

PHYSICAL PROPERTIES

Appearance	Free flow powder
Specific Gravity	1.4 - 1.7
Shelf life	Six months from the date of manufacturing in dry cool condition below 30°C & 60% RH

FILM PERFORMANCE

Test description	Test reference	Specification
Finish	Visual	As per Asian Paints PPG standard
Gloss at 60° head	ASTM D 523	Smooth Matt 0-30 GU Smooth Semi-gloss 30-80 GU Smooth Glossy >80 GU
Adhesion	ASTM D 3359	GT-0 (Passes 5B)
Impact resistance	ASTM D 2794	40 kg-cm
Scratch hardness	ASTM D 2197	2 KG
Pencil Hardness	ASTM D 3363	2H
Cylindrical Mandrel	ASTM D 522B	5mm
Erichsen Cupping	DIN 53156	5mm
Salt Spray Resistance	ASTM B 117	3000 Hrs. pass 3mm Scribe Creep
Humidity Resistance	ASTM D 2247	3000 Hrs. No blisters
Detergent Resistance	ASTM D 2248	No visual change in appearance
Muriatic acid resistance	AAMA 2604-05	No visual change in appearance
Mortar resistance (24 Hr.)	ASTM C 507	Mortar is easily removed with no loss of adhesion
Natural Weathering	ISO 2810	Excellent for 5 year Florida exposure

Test conditions: All tests are carried under laboratory conditions on 1mm Chromated Aluminum (AA 6063 & AA 6060) test panels with powder coating at DFT 60-80 microns cured at 200°C object temp. for 10 min.

APPLICATION RECOMMENDATION

Substrate	Aluminum grade AA 6063 or AA 6060
Pre-treatment ISO 10546	All substrates are to be cleaned & should be free from grease, oil & dust A multistage chromate conversion coating is recommended.
Application type	Corona Electrostatic spray
Application voltage	60-90 KV and can be customized basis the application line
Earthing	Proper & good
Compress air	Free from moisture, oil, dust & other impurities through flat jet spray nozzle
Application DFT	60-80 microns for smooth, texture & metallic finishes
Curing Schedule	200°C object temp. for 10 min.

Thorough cleaning of the application & recovery system required between each change in powder to avoid contaminations & defects. Refer to test certificate of individual product for recommended application DFT and curing schedule.

SHELF LIFE AND STORAGE

Shelf life of six months from the date of manufacturing in dry cool condition below 30°C & 60% RH. The cartons should be stacked 1+4 high. Avoid exposure to direct sunlight, heat and high humidity. Partly used material must be tightly closed after each removal and stored carefully inside the carton to avoid contamination & absorption of moisture.

All material be used in FIFO order (first in first out). Materials that exceed the shelf life should be revalidated prior to use.

SAFETY INFORMATION

Please refer Material Safety Data Sheet prior to using the product

The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current regulations. Use of the product for any purpose other than that specifically recommended in the product data sheet without first obtaining written confirmation from Asian Paints PPG Pvt. Ltd. as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfil the demands set out in the local rules and legislation. Always read the MSDS and the Technical Data Sheet for this product. We do not control the quality or the condition of the substrate or the many factors affecting the use and application of the product.

Unless agreed in writing, Asian Paints PPG Pvt. Ltd. do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. The information contained in this data sheet is subject to modification from time to time in the light of experience and continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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