



PRODUCT DATA SHEET

KOSKOTE 3000 PE-SERIES

(POLYESTER-TGIC BASED POWDER COATING)

DESCRIPTION

KOSKOTE 3000 PE-Series polyester powder coating gives decorative finishes with exceptional outside durability and resistance to yellowing on prolonged exposure to heat. It is specially formulated on selected resins and pigments to gives many years service when properly applied.

PHYSICAL PROPERTIES

Appearance	: Free flowing fine powder
Colour	: Wide colour range.
Specific gravity	: 1.30 ~1.80 gm/cm ³ depend on colour.
Volume Solid	: 100%

SURFACE PREPARATION

Ensure that the surface is properly cleaned and free from oil, grease and other contaminants, Subsequent surface treatments might include blasting, if required, and iron phosphate or zinc phosphate depending on the long term corrosion performance desired.

APPLICATION INSTRUCTION

Suitable for application by proprietary manual or automatic corona charging guns. Make sure the spray equipment it hoses, gun parts and hoppers are clean and free from defuse powder all the contact points should be maintained to ensure metal-to-metal ground. Voltage should be kept between 20~100kV. Spray booth and collection system should maintained to ensure sufficient air velocities.

CURING SCHEDULE

Standard baking temperature : 10 minutes at 200°C (Peak metal temperature).

COATING THICKNESS

Recommended Thickness : 50~70 µm

KOSSAN PAINT (M) SDN.BHD

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THEORITICAL COVERAGE & PACKING SIZE

Coverage : 7.94 ~15.38 m²/kg (85 ~165 ft²) depend on thickness & S.G
Packing Size : 20 kg/box

STORAGE & SHELF LIFE

Store below 25°C in dry conditions. When stored under such conditions the shelf life is not exceeding 6 months from the date of manufacture.

PHYSICAL COATING PERFORMANCE

Gloss : > 85° (ASTM D523 60°)
Direct impact : Greater than 100 kg.cm (ASTM D2794)
Reverse impact : Greater than 100 kg.cm (ASTM D2794)
Adhesion : Gt = 0 (DIN 53151) 2mm.
Conical mendrel bend : Less than 6mm (ASTM D522)
Erichsen Cuppling : Greater than 6 mm (DIN 53156)
Pencil Hardness : 2 H (ASTM D3363)

ENVIRONMENTAL PROPERTIES

It is essential for long term durability to ensure that the substrate is given the correct pretreatment. Aluminium requires a chromate conversion coating and steel surfaces must be zinc phosphated. The powder should be applied as soon as possible after pretreatment. Specialist advise should be sought from pretreatment suppliers.

SALT SPRAY RESISTANCE

According to ASTM B117-73 on-

Zinc phosphated steel : 5 mm undercutting after 1000 hours exposure.

Chromated aluminium : No change after 2000 hours.

HUMIDITY RESISTANCE

According to DIN 50017: No breakdown after 1000 hours

SOLVENTS & CHEMICALS RESISTANCE

Good resistance to common acids, alkalis and solvents at room temperature. May be attacked by nitric acid, ketones and trichloroethylene. Refer to the information sheet " Chemical Resistance of Powder ".

FLORIDA EXPOSURE

24 months exposure gave a gloss retention of greater than 65% (unwashed) with negligible chalking.

HEALTY & SAFETY

Avoid skin and eyes contact by wearing suitable overalls, gloves, goggles, etc. Spillage on the skin should immediately be removed by thorough washing with water and soap. Eyes should be well flushed with water and medical attention sought immediately.

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DISCLAIMER

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