

Fine Texture Powder Coat Type F 5904

polyester quality for interior and exterior use

Basis

polyester resin

Colours

all colours according to RAL
further colours available upon
request

Gloss grade

matt to silk-glossy

Properties

- very good weather resistance
- high gloss and colour stability
- very good adhesion on all common metallic substrates
- high surface hardness at good mechanical parameters
- covers up uneven surfaces and substrate faults
- after full curing / cross-linking, the paint film is physiologically safe

Field of application

Interior and exterior coatings meeting the highest qualitative and optical demands, e.g. lamps, automatic machines, boxes, cash boxes, printer for extract of account, car accessories, roof porter, switch cabinets etc.

Technical data**Density**

1,45 to 1,70 g/ml ¹⁾
(according to DIN ISO 8130-2)

Theor. coverage

approx. 10,5 m²/kg ¹⁾
(with 80 µm)

Grain distribution

< 11 %	< 10 µm
35 - 50 %	< 32 µm
> 85 %	< 90 µm

(laser measuring instrument)

Cross-hatch

Gt 0 C (according to DIN EN ISO 2409)

Erichsen cupping test

≥ 4 mm (according to DIN EN ISO 1520)

Salt spray test

> 250 h ²⁾
(according to DIN 50021-SS)

Condensation water test

> 250 h ²⁾ (according to DIN EN ISO 6270-2)

Accelerated weathering**QUV-A**

> 1.000 h (according to DIN EN ISO 11507)

Impact test

reverse: ≥ 20 ip
direct: ≥ 40 ip
(according to ASTM D 2794-69)

Labelling

see current safety data sheet

¹⁾ depending on colour

²⁾ In combination with suitable primers (see coating suggestion), the values for salt spray and condensation water tests increase to > 1.000 h.

Coating recommendation

Substrates ¹⁾	Prime coat ²⁾	Top coat ³⁾
Aluminium preferably yellow- or green-chromated (according to DIN 50939) or chromium-free no-rinse pretreatment	Zinc Prime Powder Coat Type E 8330.-.7107 (grey) approx. 60 µm	
Steel preferably iron or zinc-phosphated	Prime Powder Coat Type E 8330.-.7103 (grey) approx. 60 µm	Fine Texture Powder Coat Type F 5904 60 to 70 µm
Cast iron	Prime Powder Coat Type M 8340.-.7123 (grey) approx. 60 µm	
Galvanized steel etc.	1C Zinc-Rich Paint 5416.-.7100 (grey) 20 to 30 µm	

¹⁾ Generally, the substrate shall be free from grease, oil, separating and drawing agents as well as corrosion products and other impurities, and pretreated according to the corrosion protection requirements.

²⁾ In order to obtain an optimum adhesion in the case of a double-layer coating system in the powder area, the powder primer may only be precured. An object temperature of 110 - 130°C is recommended for this at a holding time of 8 to 10 minutes. If the prime coat is fully cured, adhesion problems may occur.

³⁾ Or single layer, provided that substrate has been pretreated accordingly.

Process

Compatibility

Different batches or powder coat qualities cannot always be mixed / are not always compatible to one another. Surface defects such as gloss reduction, specks, crater, orange peel effect, etc., may result from incompatibility. To be sure, appropriate tests shall be carried out before application.

Application temperature

15 to 25 °C

Air humidity

< 75 % r. h.

Application

Generally, make sure the substrate is grounded properly. The fluidizing, conveying and dosing air must be free from oil and condensation water. In order to obtain a uniform coating quality, a constant fresh / recovered powder ratio should be maintained. The recovery powder portion in the circulation system should normally be less than 35 %. When processing metallic powder coats, special processing instructions must be followed. Also refer to "Processing Instructions for Brillux Metallic - Powder Coats".

Corona application

voltage:
70 to 100 kV
(in the case of first coat)
40 to 50 KV
(in the case of overcoating)

Tribo application

possible

Curing conditions

duration: object temperature:
10 min. at 180 to 200 °C

Packaging

20 kg single cardboard box
500 kg cardboard box containing 25 polyethylene bags á 20 kg
Further container sizes available upon request.

Storage

1 year after receipt.
Store in closed container, dry
and at room temperature.
Protect against heat and direct
sun impact.

Remark

This Technical Data Sheet is
based on intense development
work and many years of practical
experience. The contents
do not constitute any contractual
relationship. The user/buyer is
not released from its obligation
to test our products for suitability
for the intended application. In
addition to that, our General
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apply.

As soon as a new edition of this
Technical Data Sheet is issued,
the previous specifications will
become invalid.

If you need the current version,
please consult your Brillux
contact.

Version 1

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