

NOBLE POWDER COATINGS

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| PRODUCT DESCRIPTION | <p><u>Noble Paints PE Series</u> is Standard powder coating based on selected polyester resins and hardeners. It is mainly developed to fulfil exterior durability requirements with attractive decorative finishes combined with optimum protective properties. <u>PE series</u> offers good gloss retention and resistance to color change properties.</p> <p><u>PE Series</u> is available in a variety of colors as per RAL Card, custom made shades in glossy, semi-gloss, and matt finishes. Other patterns like sandy finish, course textures, and metallic finishes are also available.</p> | | | | | | | | |
| APPLICATION AREAS | <p><u>PE Series</u> is mainly recommended for Exterior architectural applications. Typical application area is Aluminum Industry, Air Conditioner Cabinets, Garden Furniture, Playground Item, Automobile Accessories, Light Fixtures and Firefighting equipment etc.</p> | | | | | | | | |
| POWDER APPLICATION | <p><u>Noble Paints PE Series</u> can be applied by corona Electrostatic Powder Spray - 40 to 100 KV. Over spray powder can be reclaimed using suitable equipments and recycled through the coating systems.</p> | | | | | | | | |
| PRE-TREATMENT: | <p>Substrate should be free of grease, oil, dirt, and finger prints. Remove all contamination and apply surface treatments to get optimum adhesion and coating performance properties. The recommended types of pre-treatments for the most frequently used substrates are:</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">For Steel</td> <td style="width: 50%;">Zinc Phosphate</td> </tr> <tr> <td>For Galvanized Steel</td> <td>Chromate treatment</td> </tr> <tr> <td>For Aluminium</td> <td>Chromate treatment (DIN 50939)</td> </tr> </table> | | | For Steel | Zinc Phosphate | For Galvanized Steel | Chromate treatment | For Aluminium | Chromate treatment (DIN 50939) |
| For Steel | Zinc Phosphate | | | | | | | | |
| For Galvanized Steel | Chromate treatment | | | | | | | | |
| For Aluminium | Chromate treatment (DIN 50939) | | | | | | | | |
| POWDER PROPERTIES | Chemical Type | Pure Polyester - PE Series | | | | | | | |
| | Gloss @ 60° (ISO-2813) | (Glossy) | 90 ± 10 | | | | | | |
| | | (Semi-glossy) | 77 ± 7 | | | | | | |
| | | (Matt Finish) | 30 ± 5 | | | | | | |
| | | (Sandy Finish) | 10 ± 5 | | | | | | |
| | Particle Size | 60% above 32 micron sieve | | | | | | | |
| | Specific Gravity | 1.2 - 1.6 (Depending upon the color & Finish). | | | | | | | |
| | Theoretical Coverage | 8 - 13sq. meters/kg (as per Dry Film Thickness, Specific Gravity & Transfer efficiency) | | | | | | | |
| | Curing Schedule | 200 °C / 10Min & 180 °C / 15Min (metal temp.) | | | | | | | |
| | Flow Out | Very Good | | | | | | | |



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| COATING PROPERTIES | Cupping Test | (ISO-1520) | 5mm Pass (No surface cracking) |
| | Impact Test Direct | (ISO-6272) | 50 kg/cm (No surface cracking) |
| | Impact Test Indirect | (ISO-6272) | 50 kg/cm (No surface cracking) |
| | Flexibility | (ASTM D 552) | 180deg (No surface cracking) |
| | Dry Adhesion | (ISO-2409) | GT - '0' |
| | Pencil Hardness | (ASTM D 3363) | H-2H passes (No pencil marks) |
| | Flexibility | (ISO-1519) | 5 mm passes (No film cracking) |
| STORAGE CONDITIONS | Store Powder in a Dry cool condition. Do not exceed 33°C. Keep powder in packed condition if not in use to avoid contamination and moisture. Do not mix with any other Powder. | | |

NOTE : The information in this Data Sheet is the outcome of NP research work and experience. The information contained herein is believed to be accurate but cannot be taken as a formal warranty.

