

SELAC EPOXYPOLYESTER
SERIES : G F versions XFC ULTRAFAST CURING
Glossy - Semiglossy - Metallic and tridimensional effects

DESCRIPTION

Thermosetting powder coatings based on epoxy resins crosslinked with carboxylated polyester resins and designed for the coating of goods for interior use . Their excellent aesthetical properties satisfy the most severe decorative standards . **Selac XFC hybrids** offer to our customers an advanced technology finalized to reduce the cost of painting , in which a more and more important factor is represented by the thermal energy necessary to polymerize the product . Very low curing temperatures or short curing times allow to keep energetic consumption low , resulting in a better productivity , thanks to the higher speed of the conveyor . For further details please request specific TDS .

GENERAL PROPERTIES

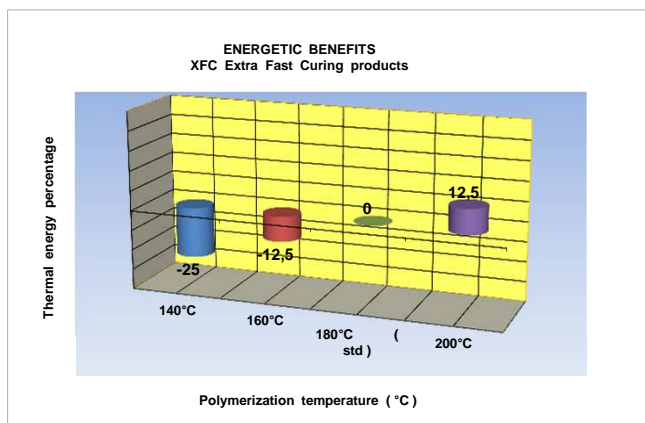
High reactivity
Excellent overall performances
Good mechanical properties
Excellent chemical resistance
Very good corrosion resistance

COLOURS AND EFFECTS

Possibility of a complete colour range
Gloss range from 15 up to 95 gloss
Smooth , orange peel , fine textured , hammer-finish , arabesque surface finish
Metallic effects possible in dry-blend or bonded versions
Wide possibility of taylor-made versions on demand

ENERGY BENEFITS OF XFC PRODUCTS

The draft expresses the percentage of energy saving possible on a painting line by the use of XFC products instead of standard powders (curing 20' @ 180°C) on the same weight of metal .



SERIES AND FINISHES

F G in XFC versions : Glossy and semiglossy

Note : several other products are present in arsonsisi range under the previous code " PH " ; please ask for dedicated TDS

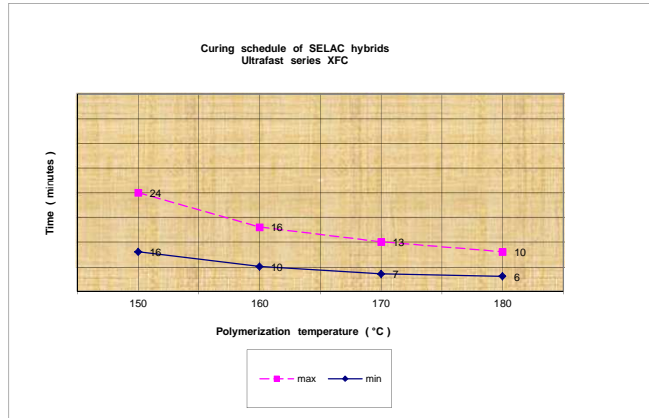
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CURING CONDITIONS

Drafts interpretation

To obtain functional , optical and aesthetic properties mentioned in TDS the curing schedule adopted for the products must be in any point of the draft area comprised between the curves of minimum and maximum .

Times always refer to object temperature (PMT) , being the heating time variable from item to item and from plant to plant .



Minimal conditions (PMT)

16' @ 150°C - 10' @ 160°C - 7' @ 170°C - 6' @ 180°C

SUPPORT PREPARATION

Painting must be done on clean support , free from oil , grease , oxidation , residuals of working , welding and rinsing processes , and any contaminating agent must be avoided
Iron and steel : iron or zinc salts phosphatization

Aluminium : cromatation or chrome-free pretreatment are recommended

Hot dipping galvanized steel : according with the item adopt mechanical treatment , phosphatization or chromatation process .

THICKNESS

Minimal recommended thickness is 60 microns , but in any case the coating layer must completely cover any surface roughness , especially in case of sandblasted supports .

For fine textured products the minimal suggested thickness is 80 micron .

For orange peel products the minimal suggested thickness is 100 micron .

APPLICATION METHODS AND RECYCLE

The application is possible with manual or automatic electrostatic devices , both corona and tribo .

Overspray can be recycled in the fresh powder and re-used , but the use of integral recycle is not recommended at all ; do not exceed 25% and maintain a constant feeding of fresh powder .

On metallic products an indicative ratio is 10% , but an unproper management of the recycle may result in remarkable variations of the effect , therefore it must be evaluated in each single case ; please contact arsonsisi s.p.a. and refer to the technical informative note about application of metallic .

TECHNICAL FEATURES

Specific gravity : 1,3 to 1,9 g/cc , according colour and formula

Theoretical yield at 60 micron : 13 to 9 sqm/kg
according colour and formula

Brilliance range at 60° : 15 to 95

Average particle size (laser Malvern) : 32 - 45 micron

X99 particle size (laser Malvern) : 95 - 150 micron

******* NOTE : taylor-made particle size distributions are possible on demand**

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MECHANICAL PROPERTIES

Test conditions : trials are made on normalized UNI 5961 panels 0,6 mm thick , degreased with solvent , coated with 70 - 80 micron of powder completely cured .
Mentioned results are obtained under controlled lab conditions ; therefore these values are merely indicative and must be confirmed in the actual use conditions under the responsibility of each single user .

Minimal polymerization conditions (PMT)
16' @ 150°C - 10' @ 160°C - 7' @ 170°C - 6' @ 180°C
Thickness : 70 - 80 micron .
Direct impact : min. 20 Nm (ISO 6272)
Erichsen embossing (ISO 1520) : min. 4 mm
Cylindrical mandrel (ISO 1519/73) : pass 3/16" = 5 mm
Adhesion (ISO 2409) : GT 0/1
Buchholz hardness (ISO 2815) : min. 85
Pencil hardness (ASTM D3363) : H - 2H

CORROSION AND DURABILITY

Test conditions : trials are made on normalized UNI 5961 panels 0,6 mm thick , treated by microcrystalline zinc salts phosphatization , or on AA 5005-H24 chromatated aluminium panels , coated with 70 - 80 micron of powder completely cured .
Mentioned results are obtained under controlled lab conditions ; therefore these values are merely indicative and must be confirmed in the actual use conditions under the responsibility of each single user .

Salt spray test (ISO 3768 / ASTM B117)

Support UNI 5961 steel treated by zinc phosphate
After 500 hours rust penetration at the cross-hatch : max. 4 mm

Saline-acetic spray test (ISO 9227)

Support UNI 5961 steel treated by zinc phosphate
After 500 hours rust penetration at the cross-hatch : max. 16 mm

Humidostatic test (ISO 6270)

Support UNI 5961 steel treated by zinc phosphate
After 1000 hours no film variation

Chemical resistances at room temperature (25+/-3°C)

Generally good versus diluted acids and diluted alkalis
Sufficient versus aromatics , moderate versus ketons and alogenated
The behaviour versus very aggressive or concentrated agents or under different conditions must be verified by the user

IMPORTANT NOTE

Metallic or tridimensional effect products may not grant same performances due to the metallic pigments or to the particular structure

STORAGE AND STABILITY

Products must be stored in the original sealed packagings , in a cool and dry place and at a temperature not exceeding 30°C .
In these conditions products **SELAC B XFC** are usually stable for a period of 6 months but particular formulations may have different storing life .
Always consult the specific TDS of each single product or contact arsonsisi s.p.a.

RECOMMENDATIONS

These informations are given on the base of our best experience as well as the one of specialized laboratories and they are continuously updated , nevertheless the user has the complete responsibility to apply and to experiment the products according its own specific necessities .
This document has the intention to describe and summarize the main properties of arsonsisi products , but in no case it can be considered as a warranty for them .
Further informations about application of metallic effects , maintenance of goods coated with homologated polyesters or availability of special versions are mentioned in specific technical integrative notes .