



**CAPITAL PAINTS**

**POWDER COATINGS**  
**TECHNICAL DATA SHEET**

**Product Series: CP03PE01**

**Product Grade: Matt**

**Product Description:** Pure-Polyester based powder coatings are thermosetting powders. These type of powders are specially designed to achieve good weather resistance, gloss retention and mechanical properties of the coating system, as they are more resistant to UV lights. Compared to Pure Epoxy and Epoxy-Polyester grades, PE Series are more resistant to yellowing.

**Application Areas:** Pure-Polyester grade powders are developed for excellent exterior durability coatings. These are best suited for architectural aluminium extrusions, automotive parts, lighting fixtures, fencing, electrical cabinets, bicycles, air conditioner covers etc.

**Pre-Treatment:** A performance of a coating system is mainly depends on pretreatment process. For maximum protection, it is essential to pretreat the substrate prior to powder coating. A substrate to be coated must be free from rust, grease/oil, dust and mill scale if any.

Substrate	Pretreatment method
Steel	Zinc Phosphate
Aluminium	Chromate/Chrome Free conversion coating
Zinc coated steel	Zinc phosphate/Chromate conversion

**Finish:** Pure-Polyester grade powders are available in smooth and texture pattern.

**Application Technique:** Pure-Polyester powders are suitable for both electrostatic and Tribo charging system. Make sure that a compressed air must be completely free from oil, dust and water.

**Storage Conditions:** Powder must be stored in a dry and cool conditions, preferably below 25°C. Exposure to high humidity should be avoided.

**Shelf Life:** One year from the date of manufacturing. Powder should be in a sealed carton under a standard storage conditions below 25°C and relative humidity not more than 60%.

**Safety Precautions:** Please consult the Material Safety Data Sheet.

**Test Conditions:** The results given below are for Pure-Polyester powder and test have been carried out under laboratory conditions and are for guidance and reference only and hence no guarantee. Pure-Polyester powder applied on 0.8 mm chromate/non chromate aluminium panels and baked at 200°C/10 Minutes (metal temperature). Thickness of coated panels: 60-90 microns. Values may vary with color, gloss and texture finish.



Sr. No.	Description	Standards	Data
1	Chemical Grade		Pure-Polyester
2	Appearance		Free flowing powder
3	Finish		Smooth finish
4	Gloss @ 60° Head	EN ISO 2813	30±5
5	DFT	EN ISO 2360	For smooth finishes, 60-90 microns
6	Curing Schedule		Minimum : 180°C/15 Minutes (Metal temperature) Maximum : 200°C/10 Minutes (Metal temperature)
7	Color		Wide range of colors are available including RAL.
8	Adhesion	EN ISO 2409 (2 mm)	Gt= 0. No loss of adhesion.
9	Impact resistance (Direct/Reverse)	EN ISO 6272-2	Passes 2.5 N-m without film cracking.
10	Cupping test	EN ISO 1520	Passes 5 mm without film cracking.
11	Flexibility test	EN ISO 1519	Passes 5 mm without film cracking.
12	Color retention		excellent
13	Buchholz hardness	EN ISO 2815	Indentation resistance according to Buchholz >80.
14	Salt spray resistance	ASTM B 117	No blistering and adhesion loss after 1000 hours.
15	Humidity resistance	DIN 50017	No blistering and adhesion loss after 1000 hours.
16	Pencil hardness		Passes HB-2H
17	Accelerated weather resistance	EN ISO 11341	No chalking, excellent gloss retention and color stability after 1000 hours.
18	Drilling, Milling and Sawing Test		No flaking of a coating.

**Note:** *As the products are very often used under conditions beyond suppliers' control, we cannot guarantee anything but the quality of the product itself. Capital Powder Coatings reserves the right, without notice, to alter or change the content of this Product Data Sheet.*

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Plot No.-38, Al Ghail Industrial Park,  
Ras Al Khaimah,  
United Arab Emirates

Tel.: +971 7 258 9223  
Fax: +971 7 258 9224  
email: info@capitalpaints.com