

PRODUCT NAME**Polyester Architectural Powder (827)**

ISSUE DATE 17/10/2006

PRODUCT CODE 827 Series

**PRODUCT DESCRIPTION**

HMG Polyester 827 powder coatings are an architectural system offering excellent flow and decorative aspect especially designed where high corrosion resistance, optimum mechanical properties and excellent gloss retention are required.

These products meet requirements of: BS EN 12206; BS 6497: 1984; Qualicoat Class 1 (Approval numbers are indicated on box label as follows: Gloss P-465, Semi-Gloss P-327, Matt P-464).

This product is suitable for Tribo spray systems.

**PRODUCT PROPERTIES**

A thermosetting powder coating based on a carboxylated polyester resin and a multifunctional curing agent.

Gloss:

Gloss 90%+

Semi-gloss 60% ±5

Matt 30% ±5

Any gloss level as specified.

**TECHNICAL PROPERTIES**

All tests carried out on degreased and zinc phosphated steel at a coating thickness of 60 microns. Mechanical properties, especially impact resistance, will improve with high cure conditions.

Pencil Hardness

1H - 3H

Flexibility-Bend Test

BS 3900: Part E1: 1970

Pass – 3/16 inch diameter Mandrel

Adhesion

Cross hatch BS 3900: Part E6: 1974

Classification 0

Erichsen-Cupping Test

BS 3900: Part E4: 1976, 5 - 10 mm according to colour and type

Impact Test:

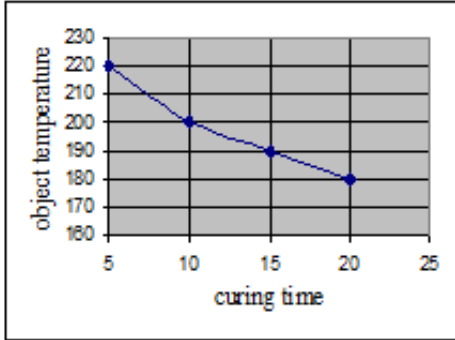
BS 3900: Part E7: 1974

Between 10 – 40kg/cm depending on colour and type



CURING INFORMATION

Normal Cure: 10mins @ 200 (matt)



10 minutes at 180°C gloss (always check box)



CORROSION RESISTANCE

Salt Spray:

ASTM B117, More than 500 hours with creepage of corrosion less than 2mm from scribe mark.

Humidity:

BS 3900: Part F2: 1973, More than 1000 hours without any effect.



CHEMICAL RESISTANCE

Salt Spray

ASTM B117

More than 500 hours with creepage of corrosion less than 2mm from scribe mark.

Humidity

BS 3900: Part F2: 1973

More than 1000 hours without any effect



COLOUR RANGE

RAL colour range, BS 4800 colour range, BS 381C colour range or any submitted colour standard



GENERAL INFORMATION

SPECIFIC GRAVITY	1.20 – 1.90 g/cm ³ depending on colour and type
COVERAGE	From 10 – 14 m ² /kg at 60 microns film thickness
STORAGE	Store between 5°C - 25°C. When not in use, cans must be kept sealed
SHELF LIFE	When stored in cool (<25°C), dry conditions – 12 months



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants.

HMG produce a full range of Preparatory Cleaners suitable for most cleaning and degreasing processes.

Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

Please refer to Knowledge Base for details on Surface Preparation.

**HEALTH AND SAFETY**

Consult the health and safety data sheet indicated on the label.

This range does NOT contain triglycidyl isocyanurate (TGIC)

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.