

## TECHNICAL DATA SHEET

### WRINKLE FINISH POWDER COATING

( Florid Series )

#### INTRODUCTION

Florid Series is wrinkle finish powder coatings with highly decorative ripple-pattern finishes available in any of powder chemistry types e.g. epoxy, polyester , epoxy polyester and polyurethane . In certain applications this finish is chosen due to its ability to hide substrate defects.

#### APPLICATION SCHEDULE

- Applied by electrostatic spraying gun that can provide negative tension of 60-80 kV.
- Curing schedule : 180-200°C /10-15 minutes depending on the powder chemistry.
- Optimal film thickness : 80 -110 um

The size of wrinkle pattern obtained depends on the coating thickness. Excessively thin or thick films will not give a satisfactory finish.

#### GLOSS AND COLOR RANGE

- Gloss levels range from matt to high gloss depending on the chemistry type .
- Full color range is available.
- The overbake yellowing resistance of a particular color depends on the chemistry .

#### SUBSTRATES AND PRE-TREATMENT

Applied to the following substrates after the appropriate cleaning and conversion coating.

- Ferrous metals(cold rolled steel, cast iron etc.): Iron or zinc phosphatation
- Zinc surfaces(galvanized steel, zinc alloy) : Chromatation or zinc phosphatation
- Aluminum alloys : Chromatation

#### STORAGE

- Should be stored under dry conditions with good ventilation at a temperature not exceeding 30 C.
- Storage period recommended should not exceed 6 months,in case exceeding 6 months without affecting their free flowing properties, the powder will still have optimal characteristics.
- Should be protected from excessive heat,humidity,water and contamination with foreign materials such as powder, dust, dirt, etc.
- Any leftover powder should be kept in an appropriate area that is cool and dry. Do not expose to the air too long as the powder properties may deteriorate with the moisture.