

Hammertone & Antique Finish

The information given in this datasheet is generic for the range **Rapid Hammertones & Antique** Specific products within the range can vary from the generic. For these products individual product datasheets are available

Product Description: **Rapid Epoxy Polyester** is a series of hybrid powder coatings Specifically formulated for use on mild Steel & Aluminum components. Providing surpasses the performance of all leading powders. It gives hammertones & Antique finish combined with maximum film integrity to ensure long term cosmetic and functional protection.

Powder Properties:	Chemical type	Epoxy-polyester
	Particle size	Suitable for electrostatic spray
	Gloss	Visually
	Specific gravity	1.2 – 1.9 g/cm ³ depending on colour
	Storage	Dry cool conditions below 30°C peak temperature
	Shelf life	12 months below 30°C peak temperature
		6 months below 35°C peak temperature
Stoving schedule		10-12 minutes at 180°C (Object temperature)

Test Conditions: The results shown below are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only. Actual product performance will depend upon the circumstances under which the product is used.

Substrate	M.S (0.5-0.8mm)
Pre-treatment	Phosphating
Film Thickness	60-80microns
Stoving	10 minutes at 180°C (object temperature)

Mechanical Tests:	Dry Adhesion	ISO2409	Pass Gt 0
	Enrichen Cupping	ISO1520 and	Pass
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	Dry Film Hardness	ISO2815 (Buchholz)	Pass > 80
	Impact	ASTM D2794 and	Pass
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Flexibility	ISO1519 and	Pass	

Chemical and Durability Tests:	Salt Spray	ISO7253	Pass at 1000 hours - no corrosion more than 1.6mm From scribe.
	Isopropyl Alcohol		15 Cycle pass
	Constant Humidity	ISO6270	Pass at 1000 hours – no Corrosion area > 1mm from scribe

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Chemical Resistance	Generally good resistance to acids, alkalis and oils at Normal temperatures
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Colour Stability at Elevated temperatures	Average
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Pretreatment:	For maximum protection it is essential to pre-treat components prior to the Application of Powder . Components should receive a full multi- stage pre-treatment to clean and condition the substrate. Detailed advice should be sought from the pre-treatment supplier.
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Application:	Rapid powders can be applied by manual or automatic electrostatic spray equipment. For solid shades, unused powder can be reclaimed using suitable equipment and recycled through the coating system. For mixed colours and certain special effect finishes, advice must be sought from the manufacturer, as to the suitability or otherwise of the product for recycling. Certain special effect finishes may not be suitable for recycling. For all mixed colour/special effect systems, advice must be sought as to the correct mixing ratio for virgin/reclaim powder.
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Safety Precautions:	Please consult the Material Safety Datasheet (MSDS)
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