



# JINHU COLOR POWDER COATING CO.LTD

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## TECHNICAL DATA SHEET

### LOW CURE EPOXY POWDER COATING

( FH-LE )

#### INTRODUCTION

FH-LE is low cure thermosetting powder coating based on epoxy resin with outstanding chemical, mechanical and corrosion resistance properties. These characteristics, together with its FDA compliance, make it suitable as a non-toxic, protective coating in many indoor applications ,including tap ware, bathroom fittings, water-tanks, drum linings etc.

#### GLOSS AND COLOR RANGE

- Gloss levels range:>70%
- Full color range is available.

#### APPLICATION SCHEDULE

- Applied by electrostatic spraying gun that can provide negative tension of 60-80 kV.
- Curing schedule :10 minutes at 160°C (metal temperature )
- Optimal film thickness : 60 -90 um

#### POWDER PROPERTIES

- Specific gravity : 1.28 - 1.75 (depend on colors)
- Particle size distribution(Laser Particle size analyser) :Less than 5% above 100 um  
50 – 65% above 32 um :  
Average particle size : 35 - 48um

#### COATING PROPERTIES

- Film thickness (ISO 2178) : 60 - 90 μm
- Gloss (ISO 2813, 60°) : >70%
- Adhesion (ISO 2409) : GT= 0
- Pencil hardness(ASTM D3363 ) : HB – 2H
- Direct and reverse impact (ASTM D2794) : > 50kg.cm
- Salt spray Resistance (ASTM B117 ,1000hrs ) : No blistering or loss of adhesion
- Chemical Resistance:Resistant to some common inorganic acids, bases and salts, organic acids and solvents.



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## SUBSTRATES AND PRE-TREATMENT

In order to obtain optimal anti-corrosion properties, it is recommended to apply a chemical pretreatment prior to powder coating application.

- 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.