

APCOSHIELD EX400 series

Epoxy coatings

The datasheet is standard for the range APCOSHIELD EX400 series products and specific products within the range can vary. Datasheet for individual products are available.

PRODUCT DESCRIPTION

APCOSHIELD EX400 series products are thermosetting powder coatings based on Epoxy Polyester resins which are available in smooth glossy, semi glossy, matt, structure, texture and metallic finishes in wide range of colours & shades and can be applied to ferrous and non-ferrous substrates.

APCOSHIELD EX400 series products can be custom designed to meet customer specifications.

Suitable for indoor applications.

PRODUCT SPECIFICATION

Chemistry	Epoxy
Physical Appearance	Free flow powder
Specific Gravity	1.4 - 1.7
Application DFT	60-80 micron for smooth, texture & metallic finishes 70-100 micron for structure finish
Curing Schedule	180°C object temp. for 10 min.

FILM PERFORMANCE

	Product series (Product code)	EX 400G (2401)	EX 405SG	EX 408SG (2822)	EX 410SG	EX 420SG	EX 430M (1492)	EX 440S	EX 440T	EX 460ME
Test description	Test method	Specification								
Finish	Visual	Smooth	Smooth	Smooth	Smooth	Smooth	Smooth	Structure	Texture	Metallic
Gloss at 60° head	ASTM D 523	>90	75-85	65-75	40-60	20-30	<20	20-30	5-10	--
Impact resistance	ASTM D 2794	120 KG.CM	100 KG.CM	100 KG.CM	80 KG.CM	80 KG.CM	40 KG.CM	40 KG.CM	80 KG.CM	80 KG.CM
Scratch hardness	ASTM D 2197	2 KG								
Pencil Hardness	ASTM D 3363	2 H								
Adhesion	ASTM D 3359	GT-0 (100% adhesion)								
Cylindrical Mandrel	ASTM D 522B	5 mm								
Erichsen Cupping	DIN 53156	5 mm								
Salt Spray Resistance	ASTM B 117	1000 Hrs.								
Humidity Resistance	ASTM D 2247	1000 Hrs.								

Test conditions: All tests are carried under laboratory conditions on 0.8mm standard Tri-cationic Phosphated CRCA test panels with coating weight of 2-3 gm/sq.mt followed by powder coating at DFT 60-70µ for smooth & texture finish and at DFT 70-100µ for structure finish and cured at 180°C object temp. for 10 min.

APPLICATION RECOMMENDATION

Pre-treatment	All substrates are to be cleaned & should be free from grease, oil & dust A suitable chromate conversion coating is recommended for Aluminum substrate. Passivated Zinc phosphate coating is recommended for steel substrate. for better results Sand Blasting / Grit blasting to at least SA 2.5 followed by passivated tri-cationic phosphating process with coating weight of 2-3 gm/sq.mt is recommended
Application voltage	60 – 90 KV
Earthing	Proper & good
Compress air	Free from moisture, oil, dust & other impurities through flat jet spray nozzle
Thorough cleaning of the application & recovery system required between each change in powder to avoid contaminations & defects	

SHELF LIFE AND STORAGE

Shelf life of six months from the date of manufacturing, if stored in closed store in dry & cool atmosphere below 30°C & 60% RH throughout the period.

The cartons should be stacked 1+4 high. Avoid exposure to direct sunlight, heat and high humidity. Partly used material must be tightly closed after each removal and stored carefully inside the carton to avoid contamination & absorption of moisture.

SAFETY INFORMATION

Please refer Material Safety Data Sheet prior to using the product

The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current regulations. Use of the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from Asian Paints PPG Pvt. Ltd. as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfil the demands set out in the local rules and legislation. Always read the MSDS and the Technical Data Sheet for this product. We do not control the quality or the condition of the substrate or the many factors affecting the use and application of the product.

Unless agreed in writing, Asian Paints PPG Pvt. Ltd. do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. The information contained in this data sheet is subject to modification from time to time in the light of experience and continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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