

## APCOSHIELD PY900 WOODGRAIN series

### Wood look finish Polyester coatings



The datasheet is standard for the Wood look finish APCOSHIELD PY900 WOODGRAIN series product range & specific products within the range can vary. Datasheet for individual products are available.

### PRODUCT DESCRIPTION

APCOSHIELD PY900 WOODGRAIN series products are thermosetting powder coating based on special Polyester resins and are available in smooth glossy, semi glossy, matt and texture finish in wide range of colours. APCOSHIELD PY900 WOODGRAIN series products are designed as a base coat for sublimation decoration techniques. The process involves transfer of sublimed ink on APCOSHIELD PY900 WOODGRAIN series powder coatings under controlled conditions of heat and pressure.

The coating exhibits excellent adhesion to both and aluminum resulting in superior mechanical properties.

APCOSHIELD PY900D WOODGRAIN series products can be custom designed to meet customer specifications.

### PRODUCT SPECIFICATION

Chemistry	Polyester
Physical Appearance	Free flow powder
Specific Gravity	1.4 - 1.7
Application DFT	60-80 micron
Curing Schedule	200°C object temp. for 10 min.

### FILM PERFORMANCE

	Product series (Product code)	PY 900G	PY 905G	PY 908G	PY 910G	PY 915G	PY 920G	PY 930M (2914)	PY 940T (2924)	PY 960ME
Test description	Test method	Specification								
Finish	Visual	Smooth	Smooth	Smooth	Smooth	Smooth	Smooth	Smooth	Texture	Metallic
Gloss at 60° head	ASTM D 523	>90	75-85	65-75	40-60	35-45	20-30	<20	10-20	--
Impact resistance	ASTM D 2794	40 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 1mm Chromated Aluminum (AA 6063 & AA 6060) test panels with powder coating at DFT 60-80 microns cured at 200°C object temp. for 10 min.

## APPLICATION RECOMMENDATION

Substrate	Aluminum
Pre-treatment ISO 10546	All substrates are to be cleaned & should be free from grease, oil & dust A multistage chromate conversion coating 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.	
The coated components further process for transfer of sublimed ink under controlled conditions of heat and pressure.	

## 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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