



Worth doing, worth Dulux.



POWDER & INDUSTRIAL COATINGS

Pacificgold Armorspray[®] EP

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| Dulux Powder Coatings Specialised Environmental Protection Powder Coating | | | |
| Product Code: | 910 Line | | |
| Specifications Met: | DIN 68861 (Furniture Surfaces) | | |
| Description | | | |
| Armorspray EP is a powder coating offering exceptional properties in resistance to a broad range of chemical, abrasion damage and allowing rapid removal of graffiti. Pentel and aerosol paint graffiti can, in general, be removed by a recommended solvent wipe of 1-2 rubs. The range is suitable both for exterior and interior exposure environments and is often used where aggressive environments are encountered outdoors. | | | |
| Features | | Benefits | |
| Excellent solvent resistance | Graffiti resistant | | |
| Excellent chemical resistance | Hard wearing in unfriendly environments | | |
| Film integrity | Long intact life of coating | | |
| Tough film | Hard wearing/serviceable finish | | |
| No solvents or emissions | Less waste and pollution to the environment | | |
| Uses | | | |
| Armorspray EP powder coatings have a multitude of uses over varied substrates from steel to aluminium. Examples of their application platform signage and train componentry, bus shelters, security lockers, telephone boxes, road and general signage, roller shutter doors, transformers, and furniture for industry and schools. Potential applications include areas in public buildings and recreation grounds such as :- toilet and shower cubicles, wall partitioning, food court benches, outdoor furniture, fixtures and fittings. Note : All metal substrates must be 'pre fabricated' - No post forming is recommended with Armorspray EP coatings | | | |
| Performance Guide | | | |
| Weather | Good resistance to weather | Salt Spray | 2-3mm adhesion loss at scribe after 250hrs ASTM B117 salt spray (Duridine 49 pretreated steel panels) |
| Heat | Excellent resistance to 220 ⁰ C continuous service conditions | Humidity | Excellent resistance to 35 ⁰ C/100% humidity for 1000 hours on pretreated aluminium. |
| Flexibility | Pass 80 inch/lb | Abrasion | Very good resistance to abrasion. 50 rubs with 'Jif' - no gloss reduction |
| Pencil Hardness | Min 4 - 6H | Cross Hatch Adhesion | No removal |
| Water Soak | No failure after 1000hrs (32 ⁰ C) | | |
| Chemical Resistance | | | |
| Ethyl Acetate | Resistant | White Spirits | Resistant |

Armorspray® EP

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| Ethanol | Resistant | Xylol | Resistant |
| Methyl Ethyl Ketone | Resistant | Dulon AAA Thinners | Resistant |
| 10% HCL Acid | Unaffected (100hrs) | Specific gravity | 1.3 - 1.7 @ colour |
| Gloss Level | 25 - 98% at 60° as required | Shelf life | 12 months when stored below 30°/dry conditions |

Product Guide

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| Colour | No restriction | Specific gravity | 1.3-1.7 @ colour |
| Gloss Level | 70 - 90% at 60°, as required | Shelf life | 12 months when stored below 25°/dry conditions |
| Toxicity | Refer MSDS (No. 35424 & 37140). | | |

Application Data

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|---------------------------------------|---|----------------------|--------------------------|
| Application Method | Electrostatic corona | | |
| Clean Up | Dust or vacuum loose powder. Avoid use of compressed air! | | |
| Film build | | Cure Schedule | |
| Cured Film Thickness (microns) | Min | Max | Recom |
| | 1. | 50 | 150 80 |
| | | | Metal Temperature |
| | | | 220 |
| | | | 200 |
| | | | 180 |
| | | | Time |
| | | | 15 minutes |
| | | | 20 minutes |
| | | | 25 minutes |

Note: Light colours may require a higher minimum film build for optimum coverage and colour consistency.

Theoretical spreading rate at recommended film thickness

A coverage rate of 7-9sq.meters per Kg corresponds to 80 µm cured film thickness assuming no loss. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.

Application Guide

Surface Preparation

Surfaces should be prepared according to AAMA2603-98 (available from Standards Australia or Standards New Zealand offices). Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes:

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| Aluminium | Yellow chromate or green chromate/phosphate | (refer AS3715-2002 and/or BS6496) |
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Application Procedure and Equipment

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| 1a) | For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble "simmering liquid". Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly. |
| 1b) | For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations. |
| 2. | Apply by electrostatic spray. |
| 3. | Cure as per recommendations outlined above. |
| | Care should be exercised when stoving at 220°C or above as some colours are prone to discolouration. |
| 4. | Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur. |

Care and Maintenance

Reference should be made to AAMA610.1:1979 standard for cleaning of surfaces. In broad terms, cleaning of externally located powder coating surfaces must take place every three months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

Graffiti removal:- Solvents recommended for graffiti removal are:-Dulon AAA thinners & MIBK
Apply the solvent with a soft rag, allow the solvent to moisten the graffiti marks, allow approximately thirty seconds before wiping the surface clean.

THREE STEPS TO CLEANING POWDER COATED SURFACES

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

Armorspray® EP

WARNING: In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of some powder coated surfaces. These solvents should not be used for cleaning purposes without first checking with your Dulux Representative.

Health and Safety

The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information.

For detailed information, refer to product label and the current Chemical Data Sheet (No. 35424 & 37140) available through Sales and Customer Service Offices.

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| Phone: Australia:- | 13 24 99 | New Zealand:- | 09 441 8244. |
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Precautions and Limitations

- Strong, bold colours may not necessarily meet these criteria and so should be referred to Dulux Powder Coatings before specifying.
- As a result of possible wide application variations and stoving conditions, some products and colours may show a variance between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
- For optimum performance ensure recommended dry film thickness is obtained. Some light colours require increased film thickness average to achieve optimal consistency.
Dulux Powder Coatings is under no obligation to replace product or repair damages that may result from the use of this product in any way other than stated on the Product data sheet or Material safety data sheet.
- As a result of possible wide application variations and stoving conditions, some products and colours may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.

Transport and Storage

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|-------------------------------|---|-----------------------|-----|
| Sizes: | 20 kg | Flashpoint: | N/A |
| Weight: | 20 kg | UN: | N/A |
| Dangerous Goods Class: | N/A | Package Group: | N/A |
| Shipment Name: | Not dangerous goods. No special transport requirements. | | |

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