



## Dupol

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### Product Guide

<b>Colour</b>	A range of stock and made to order solid colours	<b>Specific gravity</b>	1.3 - 1.7 @ colour
<b>Gloss Level</b>	25 - 98% at 60°, as required	<b>Shelf life</b>	12 months when stored below 25°C/dry conditions

### Application Data

<b>Application Method</b>	Electrostatic spray.		
<b>Clean Up</b>	Dust or vacuum loose powder. Avoid use of compressed air.		
<b>Cure Schedule</b>	<b>Metal Temperature (°C)</b>	<b>Time (minutes)</b>	
	210	8	
	200	10	
	180	15	
<b>Cured Film Thickness</b>	Recommended:	80 µm	
	Range:	50 – 120 µm	

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 8 - 10m<sup>2</sup>/kg corresponds to 80µm 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 appropriate standards such as AS3715, BS6496, AAMA2603.2002

All surfaces should be degreased and pre-treated for optimal performance. Suitable pre-treatment includes:

Aluminium                      Yellow chromate or green chromate/phosphate                      (refer AS3715 and/or BS6496)

#### Application Procedure and Equipment

- 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.
4. Test for cure of the coating by contact with a drop of solvent (available from DGL Camel Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.

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### *Care and Maintenance*

As a general rule, cleaning of externally located powder coating surfaces must take place every six months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

#### 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.

**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 the powder coated surface. These solvents should not be used for cleaning purposes. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Turpentine, White Spirits, Ethyl Alcohol, Isopropanol.

### *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. 13542403) available through Sales and Customer Service Offices.

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### *Precautions and Limitations*

- As a result of possible wide application variations and stoving conditions, some products and colours may show variation between DGL Camel 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.
- Not recommended for use in highly corrosive environments such as severe marine or industrial locations.
- Not recommended for components which are exposed to constant temperatures exceeding 120°C.

