

Armourspray® AP

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Powder Coating for Appliances and White Goods

Product Code: 986 Line

Description

Armourspray® AP is a tough thermosetting powder coating suitable for interior applications, that exhibits excellent flow and gloss combined with good adhesion to a variety of substrates.

Armourspray® AP shows easy application properties and gives a film very resistant to wear and damage.

Features

Benefits

Excellent flow	Excellent for appliances and white goods
Film integrity	Long intact life of coating
Very good surface hardness	Hard wearing / serviceable finish
No solvent or emissions	Less waste and pollution to the environment
Good chemical resistance	Resists oil and general chemical spills

Uses

Armourspray® AP is designed for use in the appliance industry and can be used over a variety of substrates including steel and aluminium.

Examples include: Washing machines, fridges, general white goods

Performance Guide

Weather	Armourspray® AP is not recommended for exterior use. It contains a component which will chalk on exterior exposure.	Salt Spray	Very good salt spray resistance. < 3mm adhesion loss at scribe after 250 hours salt spray on steel.
Heat	Excellent resistance to 120°C continuous service conditions.	Humidity	Excellent resistance to 38°C/100% humidity for 250 hours on steel.
Acid	Resistant to spills of dilute acid. Avoid contact.	Abrasion	Excellent resistance to abrasion.
Alkali	Resistant to spills of dilute alkali. Avoid contact.	Pencil Hardness	Min H
Flexibility	Pass 80 inch/lb	Cross Hatch Adhesion	No removal

Chemical Resistance

Very good resistance to oils and general chemicals.

Ethyl Acetate	Softens after prolonged contact	White Spirits	Resistant
Ethanol	Resistant	Xylene	Slight softening/limit contact
Methyl Ethyl Ketone	Softens after prolonged contact		

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Product Guide

Colour	A range of made to order solid colours available	Specific gravity	1.3 - 1.7 @ colour
Gloss Level	50-98% at 60°, as required	Shelf life	12 months when stored below 30°C/dry conditions

Application Data

Application Method	Electrostatic spray.		
Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.		
Cure Schedule	Metal Temperature (°C)	Time (minutes)	
	200	10	
	190	12	
	180	15	
Cured Film Thickness	Recommended:	80 µm	
	Range:	50 – 120 µm	

Note: Curing below metal temperatures of 160°C, or above metal temperatures of 200°C are not recommended.

Theoretical spreading rate at recommended film thickness

A covering rate of 8 - 10m²/kg is commonly experienced. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.

Application Guide

Surface Preparation

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

Aluminium	Yellow chromate or green chromate/phosphate	(refer AS3715-2002 and/or BS6496)
Ferrous metals	Zinc phosphate or Iron phosphate	(refer BS6497)
Zinc Coated Metals	Zinc phosphate or chromate	(refer BS6497)

(e.g. galvanising)

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 Corsol PGMA (available from Orica 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

To maintain the attractive appearance of the Armourspray® AP film, it should be regularly washed with warm water and mild liquid detergent, followed by a fresh water rinse.

The use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

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 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 Orica 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 corrosion 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 exterior applications.

Transport and Storage

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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