

# Alesta® E

## Anticorrosive Primer EE Primer

### EE70027713322 PRIMER RAL 7047 GREY

Anticorrosive Zinc free primer offering excellent corrosion protection on steel and aluminium substrates.



#### Characteristics

- Gloss Smooth
- Solid
- Corona
- Antigassing

#### Usage Area

- Protection and decoration of interior parts
- Gas or liquid tanks, pipelines, structural steelwork, trucks, trailers & car parts



#### Approvals

GSB: Two-layer build on steel: 908 a

Corrosion class C5-I "very high" in a two-layer build according to DIN EN ISO 12944-6



- This powder coating complies with the European Directives "Restriction of the use of certain hazardous substances" 2011/65/EU and 2015/863/EU (RoHS)
- Classification A2 (non flammable) of reaction to fire in accordance with NF EN 13501-1+A1 : 2013

The following data has been obtained under laboratory conditions as described below. Actual product properties such as gloss, colour and finish may vary depending on application conditions.



#### Test Conditions

- |  |                     |
|--|---------------------|
| • Curing Conditions (object temperature) | 13 min @ 180°C      |
| • Substrate                              | 0,8 mm Steel Panels |
| • Film thickness                         | 70 ± 10 µm          |
| EN ISO 2360                              |                     |

#### Physical Data

- |            |            |
|------------|------------|
| • Density  | 1,52 g/cm³ |
| calculated |            |



## Product Performance / Film Properties

Gloss @ 60° EN ISO 2813	80 ± 5
Impact Resistance EN ISO 6272 / ASTM D2794	20 inch-pound
Adhesion EN ISO 2409	GTO
Erichsen Cupping EN ISO 1520	8 mm
Cylindrical Mandrel Bending EN ISO 1519	5 mm
Salt Spray Test EN ISO 7253	Above 2000 h depending on substrate and surface treatment

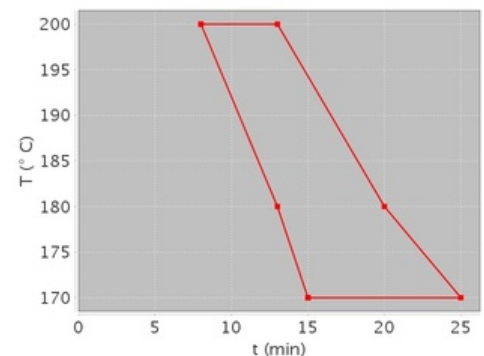


## Curing Conditions (object temperature)

EE70027713322 - Use as primer in a two-layer system

Can be cured using a variety of methods, e.g. IR, convection, combi ovens. In direct gas ovens, combustion by-products may cause significant colour changes (for specific advice, please contact us).

8-13 min @ 200°C  
13-20 min @ 180°C  
15-25 min @ 170°C



## Storage Stability

24 months/35°C

Shelf life applies to materials stored in sealed plastic bags under dry and cool conditions.



## Substrate Preparation

- On aluminium, steel and hot-dip galvanized steel: both chemical pre-treatment and mechanical surface preparation are compatible with Alesta® E. Surface preparation should be chosen according to type of substrate and required performance.
- The suitability of the surface preparation should be tested by the coater beforehand using appropriate test methods.



## Application

- Do not mix this product with other powder coatings.
- Substrate should be correctly cleaned before use.
- Can be applied with manual or automatic guns.
- Film thickness: application settings will depend upon the geometry of the object being coated as well as the required film thickness. It is the responsibility of the applicator to make the appropriate adjustments.
- Recycling of the powder: possible up to 30 %.



## Comments

- Certain chemicals or domestic cleaning products can cause damage to the appearance of the coating. Please test a small inconspicuous area first to confirm suitability.
- Please contact us for specific questions.
- In instances where the coating will be subjected to additional processes (such as printing, labelling, overcoating, postforming, gluing, application of sealant or any other post-treatment), adequate testing should be performed to confirm suitability. Prototypes should be prepared under conditions that are representative of the final production process.
- Coated parts should be packed after they are fully cooled using suitable materials that are free of plasticizers. Packaged parts should be stored under cover to avoid the formation of condensation (for example under plastic wrapping film) which could result in permanent marks on the surface of the coating.



## Safety

Consult the Safety Data Sheet prior to use

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.

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