Alesta® EP
Epoxy Polyester Industrial EP Leatherette Texture
EP05004005923 BLACK COARSE TEXTURE J000672

Epoxy Polyester Industrial product specifically formulated for decorative applications. It is intended for use in a wide range of interior applications.

Characteristics
- Semi Gloss Leatherette
- Solid
- Corona

Usage Area
- Domestic and industrial appliances
- Indoor application e.g. shelving, office furniture, partitioning, white goods
- Protection and decoration of interior parts

Approvals

Marine	CE 2690 (MED), CE 8517 (MCA)
UL 1332	MH45216 (Fr)

- 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)	10 min @ 180℃
Substrate	0,8 mm Steel Panels
Film thickness EN ISO 2360	70 ± 10 µm

Physical Data

Density calculated	1,65 g/cm³

Technical Data Sheet

Product Performance / Film Properties

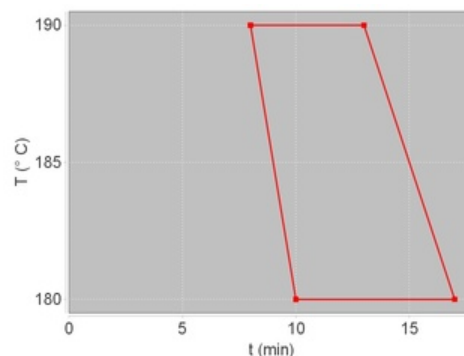|	
Gloss @ 60° EN ISO 2813	SEMI GLOSS
Adhesion EN ISO 2409	GT0
Impact Resistance EN ISO 6272	1 kg / 20 cm

Curing Conditions (object temperature)

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 @ 190℃
10-17 min @ 180℃

Storage Stability

36 months/35℃
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® EP. Surface preparation should be chosen according to type of substrate and required performance.
- On steel and hot-dip galvanized steel, corrosion resistance may be further enhanced by the use of our Alesta® ZeroZinc protective primers (please contact us for further information).
- The suitability of the surface preparation should be tested by the coater beforehand using appropriate test methods.

Technical Data Sheet

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. Certain colours should be applied at higher film thickness to ensure full coverage and therefore colour homogeneity. Below this limit, colour variation may occur due to differences in film thickness.
- Great care is taken during our manufacturing process but small variations in colour and/or appearance are unavoidable with effect colours. Therefore we recommend that a single batch of powder coating should be used to coat parts that will be subsequently assembled together. Differences are more likely with effect powder coatings such as metallic, pearlescent, speckled, textured and combinations thereof. Differences will be more easily visible on large coated parts such as cladding panels, flat sheets etc.
- Recycling of the powder: possible up to 30 % for solid colours. For special finishes (for example metallic, pearlescent, speckled), please refer to our website and the 'Metallics are us – Tips for Users' guide.

Comments

- Certain chemicals or domestic cleaning products may cause damage to the appearance of the coating. We recommend testing a small inconspicuous area first to confirm suitability.
- 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.
- Please contact us for specific questions.

Safety

Consult the Safety Data Sheet prior to use