

Technical Data Sheet

Alesta[®] HR HR0300-4030727

Product Description

The product HR0300-4030727 is a heat resistant powder coating based on silicone resin. It is developed to be used for applications where a temperature up to 500°C is used for a short time period.

To obtain maximum properties the coating needs a heat treatment up to the application temperature after curing. We recommend 1 hour at 500°C.

Examples of applications where Alesta HR0300-4030727 is suitable are exhaust systems and stoves. We recommend you to contact an Axalta representative for guidelines on using Alesta HR in the best way.

Note: Cycle time/temperature
2h / 500°C

Surface / Effect

Texture, Matt

Approvals

This powder coating complies with the European Directives "Restriction of the use of certain hazardous substances" 2002/95/EC and 2011/65/EU (RoHS).

Colour

Black

Substrates

Recommended substrate is degreased aluminium or degreased and sandblasted steel.

Substrate Preparation

Steel and aluminium substrates must be free of all contaminants that cannot be removed by the cleaning process. Best results are obtained when a strong, hot potassium hydroxide-based alkaline cleaner is used, followed by several rinse stages. The last rinse should be deionized water.

Conversion coatings such as iron phosphate or zinc phosphate are not recommended because of the disintegration of the metal phosphate films at high temperatures.

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Physical Properties	
Specific Gravity	1,762 kg/dm3

Recoating: Not possible

The following performances have been obtained under the conditions described below and in laboratory. Actual product properties such as gloss, colour and finish may vary according to condition of application.

Product Performance / Film Properties			
CONDITIONS			
Steel panels:	0.8 mm		
Surface pretreatment	Sand blasted steel		
Film thickness	40 - 60 µm		
Curing Conditions	12' @ 230°C (object temperature)		
TESTS	SPECIFICATIONS		RESULTS
	N°	DATES	
Gloss @ 60 °	EN ISO 2813	1999	Texture, matt
After heat treatment 2 h @ 500°C	Recommended substrate is degreased aluminium or degreased and sandblasted steel where the following properties can be reached at a film thickness of 40-60 µm. At a higher film thickness level the heat resistance and flexibility will be reduced.		
	Adhesion (ISO 2409): Gt 2		

General curing condition
• Object t° / time
230°C 12min

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Application

- Do not mix this product with another powder.
- Substrate should be correctly cleaned before use.
- Application using either manual or automatic electrostatic guns.
- Film thickness: the required application settings will depend upon the geometry of the object being coated as well as the specified film thickness. It is the responsibility of the applicator to make the appropriate adjustments.

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.
- Recycling of the powder: possible up to 30 %.

Cleaning

Cleaning of the application equipment is done in a regular way by using a rubber scrape, vacuum cleaner and finely a wet rag. In filter box set-ups special caution is needed. To avoid contamination separate tubes and filter modules are recommended if feasible.

Storage Stability

12 months @ maximum 25° C

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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