

Alesta® IP

Polyester Industrial IE Gloss

IE90011016323 JCB YELLOW

Polyester Industrial is a range of powder coatings intended for the decoration and protection of metal components for both outdoor and indoor use. It offers excellent weathering and corrosion resistances, good mechanical properties. IE90011016323 is designated specially for the ACE segment.



Characteristics

- Gloss Smooth
- Solid
- Corona/Tribo
- Low Bake

Usage Area

- Industrial outdoor application e.g. agricultural
- Machinery, trucks, trailers & car parts



Approvals

UL: 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) : 15 min @ 160°C
 - Substrate : 0,8 mm Steel Panels
 - Film thickness : 70 ± 10 µm
- EN ISO 2360

Physical Data

- Density : 1,4 g/cm³
calculated



Product Performance / Film Properties

JCB Standard 4200/0000 version 19 - Class A

Gloss @ 60° 90 ± 5
EN ISO 2813

Impact Resistance 40 inch-pound
EN ISO 6272 / ASTM D2794

Adhesion GT0
EN ISO 2409

Cyclic corrosion test Creep <2mm each side of scribe after 60 cycles
PV 1210

Pencil Hardness 2H
EN ISO 15184

Accelerated weathering Colour change, DE ≤ 2 after 1000 hrs
ISO 11341, method 1, test cycle A

Neutral salt spray test Creep <1mm each side of scribe after 1000 hrs
ISO 9227: 2006

Sulfur dioxide exposure No visible deterioration after 10 cycles
ISO 3231

Fluid an chemical tests ISO 2812-1

- De-ionised water: panel 3/4 immersed in de-ionised water at 15-21°C for 400 hours.
- Diesel: panel 3/4 immersed in diesel fuel to BS EN 590 Class A at a temperature of 16 to 21°C for 24 hours.
- Hydraulic Fluid: panel 3/4 immersed in JCB hydraulic fluid HP 32 4002/1000 (to JCB STD00080) at a temperature of 95 to 100°C for 2 hours.
- Antifreeze: panel 3/4 immersed in a neat solution of JCB High performance coolant (STD00088) at a temperature of 16 to 21°C for 24 hours.
- DEF fluid: panel 3/4 immersed in Diesel Exhaust Fluid solution (DEF, AdBlue®, AUS32 - see STD00271 for specification) at 15-21°C for 250 hours.

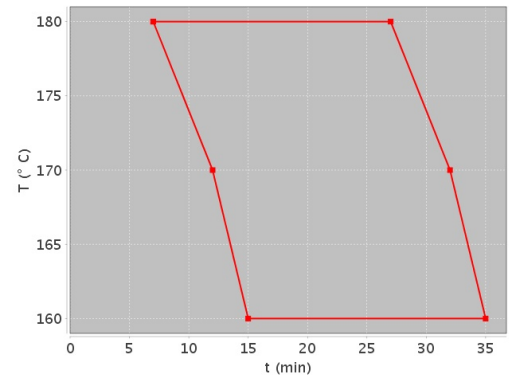
No degradation of the film, no softening of the film - pencil hardness and adhesion test in conformance with this standard, after 24 hours



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).

15-35 min @ 160°C
12-32 min @ 170°C
7-27 min @ 180°C



Storage Stability

36 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® IP. 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.



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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