

# Alesta® QP

## Anticorrosive Primer QP Primer

### QP90017278520 ALU QUALIPRIME ± RAL 7040

Alesta® Alu QualiPrime is an anticorrosion powder primer designed for aluminium substrates. The product is based on very high performance epoxy polyester resins that enhance the barrier effect and provide excellent flexibility and adhesion properties. Together with an appropriate surface treatment and an Alesta® polyester as a topcoat (Alesta® AP, SD), Alesta® Alu QualiPrime makes up a whole system that isolates the substrate from its environment in order to provide an excellent corrosion protection even under the most severe conditions.



#### Characteristics

- Gloss Smooth
- Solid
- Tribo/Corona

#### Usage Area

- Aluminium substrates, profiles and sheets



#### Approvals

Qualicoat P-1182



- Product approved by QUALICOAT
- QUALICOAT is a quality label for licensed customer
- This powder coating complies with the European Directives "Restriction of the use of certain hazardous substances" 2011/65/EU and 2015/863/EU (RoHS)

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 @ 170°C
- Substrate 0,8 mm Chrome-free Aluminium panels
- Film thickness 60 ± 10 µm  
EN ISO 2360

#### Physical Data

- Density 1,54 g/cm<sup>3</sup>  
calculated



## Product Performance / Film Properties

Gloss @ 60° EN ISO 2813	90 ± 5
Impact Resistance EN ISO 6272 / ASTM D2794	2,5 Nm / 22 inch-pound
Adhesion EN ISO 2409	GTO
Erichsen Cupping EN ISO 1520	5 mm
Cylindrical Mandrel Bending EN ISO 1519	5 mm

### Anticorrosion performance - Lab Acetic salt spray test carried out according to ISO 9227

- Substrate Aluminium 6060
- Film thickness QP90017278520: 60-80 µm & Topcoat Alesta® AP: 60-80 µm
- Curing condition QP90017278520: 10 min @ 170°C & Topcoat Alesta® AP: 12 min @ 180°C

		Chrome VI conversion	Chrome free conversion
1000 hours	Edges	perfect	perfect
	Blistering (ISO 4628)	0	0
	Adhesion (ISO 2409)	GTO	GTO
	Filiform corrosion	0 mm	0 mm
2000 hours	Edges		perfect
	Blistering (ISO 4628)		0
	Adhesion (ISO 2409)		GTO
	Filiform corrosion		0-2 mm (< 16 mm <sup>2</sup> )
3000 hours	Edges		perfect
	Blistering (ISO 4628)		0
	Adhesion (ISO 2409)		GTO
	Filiform corrosion		0-2 mm (< 16 mm <sup>2</sup> )

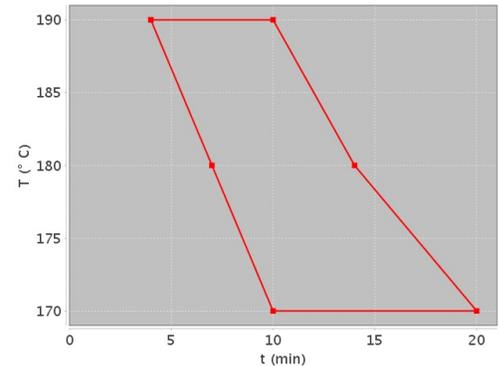
Protection and expected performance will vary according to the design of the part to be painted, the quality of the surface pretreatment and implementation and thickness of the coating system, as well as the maintenance programme of the coated surfaces.



## 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).

4-10 min @ 190°C  
7-14 min @ 180°C  
10-20 min @ 170°C



- For optimum intercoat adhesion, partial cure of the primer is recommended prior to application of the topcoat. This should be followed by full cure of the combined coating system. Minimum object temperature for partial cure: 2 min @ 140°C.
- Product is formulated for optimum intercoat adhesion under industrial curing conditions. However, for non-conventional curing programme, above 210°C, long time in the oven or direct fired gas oven, it is advisable to test to confirm suitability.



## Storage Stability

36 months/35°C  
Shelf life applies to materials stored in sealed plastic bags under dry and cool conditions.



## Substrate Preparation

- Chemical chrome and chrome-free treatments designed for aluminium are compatible with Alesta® Alu QualiPrime.
- Surface pretreatment has to be defined depending on type of substrate and required performance.
- The suitability of the surface preparation should be tested by the coater beforehand using appropriate test methods.
- Substrate must be correctly prepared and dried before using QP90017278520 and surface should be free of all contamination such as rust, oil and grease, old paints etc.



## Application

- Do not mix this product with other powder coatings.
- Can be applied with manual or automatic guns.
- Alesta® Alu QualiPrime is easily applicable, with high transfer efficiency.
- Spraying 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. Optimum coating performance will be obtained with a thickness of 60-100 µm.
- Easily overcoatable with specified Alesta® topcoats without sanding or any other preparation\* (within 12 hours).  
\*Cleaning is necessary if primer surface becomes contaminated (dust, oil etc.).
- All other conditions must be checked before use with an adhesion test.
- 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.
- 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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