

Alesta® ST

Polyester Industrial ST Soft Touch

ST00000900020 CLEARCOAT SOFT TOUCH

The Alesta® Soft Touch range is a polyurethane based powder coating containing high performance hydroxyl polyester. It offers excellent decorative appearance and soft feel effect together with good mechanical properties and chemical resistance. This product is intended for industrial indoor and outdoor use.



Characteristics

- Extra Matt Smooth
- Clearcoat
- Corona

Usage Area

- Protection and decoration of interior parts
- Indoor application e.g. shelving, office furniture, partitioning, white goods
- Urban furniture



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).

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) | 12 min @ 200°C |
| • Substrate | 0,8 mm Steel Panels |
| • Film thickness | 70 ± 10 µm |
| EN ISO 2360 | |

Physical Data

- | | |
|------------|------------|
| • Density | 1,18 g/cm³ |
| calculated | |



Special Application Advice

- If applied over E-Coat please first consult Axalta for advice.
- When Alesta® Clearcoat is used to overcoat a basecoat, it is important that adequate testing is performed to confirm compatibility and aspect. Prototypes, including substrate and surface preparation, should be coated using the intended curing temperature and time, and then tested to confirm sufficient adhesion between the two layers and aspect such as gloss, color and finish. Appropriate methods should be used such as a cross-cut test after 2 hours conditioning of the coated object and visual assessment.
- When Alesta® Clearcoat is used on components that will be subjected to outdoor weathering, it is essential that only polyester basecoats are used. Clearcoats are transparent to UV light, and if basecoats containing epoxy are used, chalking and subsequent delamination may occur.



Product Performance / Film Properties

Gloss @ 60° EN ISO 2813	7 ± 3
Impact Resistance EN ISO 6272	1 kg / 50 cm
Adhesion EN ISO 2409	GT0
Pencil hardness EN ISO 1518	2H
Clemen Hardness EN ISO 1528	6 N
Taber abrasion NFT 30-015	<100 mg loss of coating weight
Chemical Resistance	No visible effect with common cosmetics (e.g. nail vrnish), cleaners (e.g. bleach), inks
Solvent Resistance Methyl Ethyl Ketone	No visual change after 50 double rubs



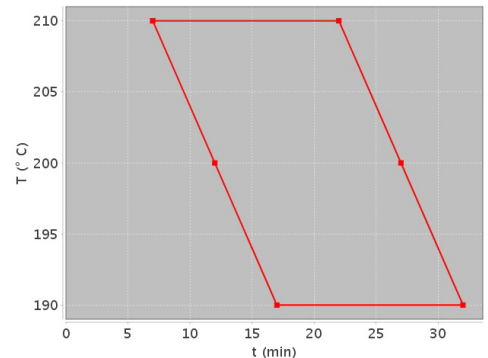
Curing Conditions (object temperature)

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).

17-32 min @ 190°C

12-27 min @ 200°C

7-22 min @ 210°C



Storage Stability

12 months/35°C

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



Substrate Preparation

- Surface preparation should be chosen according to type of substrate and required performance and then 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.
- 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.
- Recycling of the powder: possible up to 30 %.



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.
- 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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