

Technical Data Sheet

Alesta[®] HR HR0301-4051027

Product Description

The product is a heat resistant powder coating, based on silicone, epoxy and acrylic resins. It is developed to be used for applications where a temperature up to 300°C is used for a short time period (the cycle time is 1 hour). To achieve an optimum result it is recommended to contact an Axalta representative for guidelines on using Alesta HR in the best way.

Surface / Effect

Fine texture

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.

Recoating: Not possible

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Physical Properties

Specific Gravity 1,449 kg/dm³

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	50 - 70 µm		
Curing Conditions	13' @ 200°C (object temperature)		
TESTS	SPECIFICATIONS		RESULTS
	N°	DATES	
Gloss @ 60 °	EN ISO 2813	1999	5±2
After 1h @ 300°C	Adhesion (ISO 2409): ≤ Gt 2		

General curing condition

- Object t° / time
200°C 13 min

Application

- Do not mix this product with another powder.
- Substrate should be correctly cleaned before use.
- Application using either manual or automatic electrostatic guns.
- Suitable for TRIBO application
- 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.



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Storage Stability

12 months @ maximum 25° C

Safety

Consult the Safety Data Sheet prior to use

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