

# ENVIROCOAT POWDERS PVT. LTD.

HO : Plot No. 288, Sector 7, MIDC, Bhosari, Pune - 411026

WORKS : C-99, STICE, Musalgaon, Sinner, Nashik - 422112

CIN No. : U74994PN2018PTC175918

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## PRODUCT DATA SHEET

### PRODUCT NAME : PURE EPOXY POWDER PAINT

<b>Product Description</b>	National Paints EP Series is a thermosetting powder coating based on epoxy resins that provides excellent decorative properties and chemical/mechanical performance. It is available in various colors and finishes for interior use on appliances, furniture, and other items requiring chemical resistance. It exhibits properties such as high gloss, flexibility, impact resistance, and adhesion as well as corrosion protection when tested according to various standards.
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<b>Products Properties:</b>	<b>Chemical Nature</b>	Epoxy
	<b>Flow Finish :</b>	Smooth, semi glossy, glossy, Texture, Structure and Metallic
	<b>Particle sizedistribution</b>	More than 80 $\mu$ → 0 – 5 %
		More than 63 $\mu$ → 8 – 10 %
		Less than 32 $\mu$ → 40 – 55 %
	<b>Specific Gravity</b>	1.60 $\pm$ 0.20
	<b>Storage</b>	Keep in dry cool condition@ 25°C
	<b>Shelf Life</b>	6 months from the date of manufacturing @25°C & 50% Relative Humidity.

## Technical Data

<b>Mechanical Test</b>		<b>STANDARD</b>	<b>OBSERVATION</b>
	<b>Shade</b>	Visual	Close match to STD
		Colour Computer	Delta E $\leq$ 1.0
	<b>Gloss @ 60 °</b>	ASTM D 523	GLOSSY = 80+ units SEMIGLOSSY = 40-70 units MATT = 5-20 UNITS
	<b>Film Thickness</b>	ASTM 1186	50 – 80 $\mu$
	<b>Cross Cut Adhesion</b>	ASTM 3359	GT = 0/100
	<b>Impact Resistance</b>	ASTM D 2794	80 Kg cm Direct
			80 Kg cm Reverse
	<b>Flexibility</b>	ASTM D522	6.25 mm

<b>Chemical Tests</b>	<b>Salt Spray Resistance</b>	ASTM B117	800 hrs
	<b>QUV ( 500 Hrs) B 313 Lamp</b>	ASTM B152	Retains 80% of Originalgloss after polishing with 3M wax solution
	<b>Humidity Resistance</b>	IS 101	1000 Hrs.

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## Pre-treatment

Mild steel or CRCA surfaces must be cleaned and free from oil grease dust followed by Iron or Zinc phosphate while Aluminum surface will require a suitable chromate conversion, chrome free pretreatment or flash anodizing before powder applications. Galvanized steel may require zinc or chromate conversion or sweep blasting.

## Application

### Substrate

CRC Panels

### Application System

Electrostatic Spray Gun

### Voltage

60 – 90 KV

### Curing Schedule

200°C / 10-15 Mins EMT

Epoxy Products are to be applied only by Corona charged Guns. However for application through Tribo Guns & RoHS complied powders can also be made available on demand.

We recommend

- Voltage around 60 – 90 KV based on system
- Distance Gun – part will be 20 to 25 cm
- Slow first passes
- Flat jet spray nozzles or as demanded by the shape & size of the component.
- Gas or Diesel fired ovens must be fitted with Heat Exchanger having uniformity of insidetemperature.
- Direct feeding from the powder box is not recommended.
- Recycling up to 20% of reclaimed powder.

*Disclaimer: The given data here are based on the best of our knowledge & subsequent data we receive from our customers. In view of many factors that may affect processors/applicators present system, these data do not relieve processors / applicators from carrying out their own investigations and teststo find out suitability for specific purposes. Neither do these data imply any guarantee nor the suitability of the products for a specific purpose until the same is being given in writing by us. These are general information only and may change without prior intimation.*

**For ENVIROCOAT POWDERS PVT LIMITED**

**R &D POWDER COATING**

*N.B. Computer generated file, No need to signature.*