

Product Data Sheet

Corro-Coat PU Series 6312

Product Description

Corro-Coat PU Series 6312 is an exterior durable caprolactam-free IPDI-cured polyester powder coating designed as a base coat for sublimation decoration techniques. It exhibits an excellent even uniform flow and an attractive finish and appearance, even after recycling.

Corro-Coat PU Series 6312 features excellent chemical properties and imparts superior weather resistance as well as chalking resistance to UV light.

Application Areas

Primary areas of application are aluminium extrusions and sheets. The overall excellent properties and attractive appearance of Corro-Coat PU Series 6312 make it suitable for application to other ferrous and non ferrous substrates.

Wooden patterns and marble finishes are created by applying a top coat through a sublimation decoration technique. The finishes are very attractive on kitchen cabinets and fixtures, window frames and doors. When screen printing or sealants are used, it is advised to run separate trials to ensure compatibility and to meet the required performance criteria.

Pre-treatment

The overall quality of the coating system is largely dependent on the type and quality of the pre-treatment. The recommended types of pre-treatment for the most frequently used substrates are:

Aluminum	Chromate conversion
Steel	Zinc phosphate
Zinc coated steel	Zinc phosphate or chromate conversion
Final rinse (deionized)	The last running water from the object should be tested at 20°C. The readings obtained should measure below 30µS/cm.

Curing Schedules

20 minutes at 190°C object temperature
15 minutes at 200°C object temperature
10 minutes at 210°C object temperature

Colour Selection

Corro-Coat PU Series 6312 is available in a wide assortment of custom-made colours, including RAL and NCS.

Finish

Corro-Coat PU Series 6312 is available in silky smooth matt finish, ranging from 15% to 25% (angle 60° measured according to EN ISO 2813).

Powder Application

Corro-Coat PU Series 6312 is suitable for Corona or Tribo charging equipment.

Storage Conditions

Keep in a dry cool area. Maximum temperature 25°C. Maximum relative humidity 60%. (Please refer to Section 7 of the "Recommended Process and Process Control Requirements for Architectural Aluminum Alloys' Coating" in Part 2 of the "Quality and Warranty" document).

Maintenance

Please refer to "Powder Coated Façades' Maintenance" in Part 3 of the "Quality and Warranty" document.

Approvals

Please consult your local Jotun Powder Coatings' production unit.



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Technical Data

The technical data provided below are typical for Corro-Coat PU Series 6312 applied to 0.8mm chromated aluminium panels (typical 65 micron film thickness). Typical values when tested have not necessarily been recently revised.

Description	Norm	Series 6312
Adhesion	EN ISO 2409 (2mm)	Cross-cut rating Gt0 (100% adhesion).
Impact resistance	ASTM D 2794 (5/8" ball)	Most grades exceed 20 inch-pounds without film cracking.
Cupping test	EN ISO 1520	Most grades exceed 5mm without film cracking.
Flexibility	EN ISO 1519	Cylindrical Mandrel bend test, 5mm without film cracking.
Film hardness	EN ISO 2815	Indentation resistance according to Buchholz: > 80.
Salt spray resistance	ASTM B 117	Excellent. Measured with respect to corrosion, blistering and adhesion loss after 1000 hours.
Resistance to humid atmospheres	DIN 50017	Excellent. Measured with respect to blistering and adhesion loss after 1000 hours.
UV resistance	ASTM G 154 (UVB-313)	Excellent. Measured with respect to color and gloss retention.

Note: The information on this Product Data Sheet is given to the best of the manufacturer's knowledge, based on laboratory testing and practical experience. However, as the product is often used under conditions beyond the manufacturer's control, only the quality of the product itself can be guaranteed. Jotun Powder Coatings reserves the right without notice to alter or change the content of this Product Data Sheet.

Jotun Powder Coatings. April 2005.

THIS PRODUCT DATA SHEET SUPERSEDES ALL PREVIOUSLY ISSUED VERSIONS.