Jotun Facade 1201, 1203, 1206, 1207, 1208

PRODUCT DESCRIPTION

This lead-free TGIC powder coating is specifically designed to meet stringent requirements of the construction industry. It is formulated to meet the requirements of AAMA 2603, provides longevity to the projects and building components by ensuring gloss retention, colour stability and corrosion protection. This powder enables efficient application and provides uniform flow and attractive finish even after recycling.

Application areas

Primary areas of application are architectural aluminium extrusions and claddings. The overall excellent properties and attractive appearance of this product make it suitable for application to other ferrous and non-ferrous substrates.

When screen printing or sealants are used, it is advised to run separate trials to ensure compatibility and to meet the required performance criteria.

POWDER PROPERTIES

Property	Standard	Result
Specific gravity	Calculated	Max. 1.8 g/cm^3

Storage

Keep in a dry cool area. Maximum temperature 25 °C. Maximum relative humidity 60 %. If stored longer than 12 months a quality test must be performed.

APPLICATION

Pretreatment

The overall quality of the coating system is largely dependent on the type and quality of the pretreatment. For optimal results, it is recommended to follow the pre-treatment supplier's instructions.

The recommended types of pretreatment for the most frequently used substrates are:

Substrate	Pretreatment
Aluminium	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 30 µS/cm.

Suitable chrome-free pretreatment for aluminium is also recommended. Due to the variety of chrome-free pretreatments available today, only the approved systems from Qualicoat and GSB should be used. Detailed advice should be sought from the pretreatment supplier.

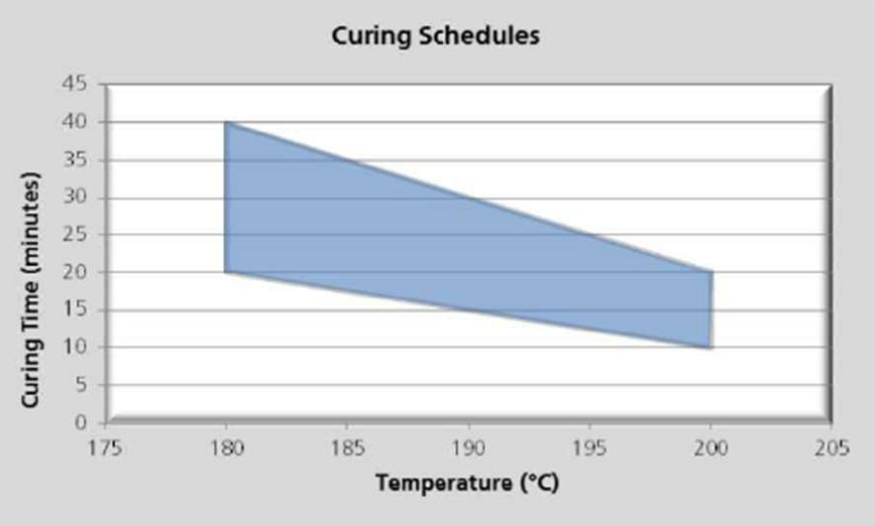
This Technical Data Sheet supersedes those previously issued.

The Technical Data Sheet (TDS) is recommended to be read in conjunction with the Safety Data Sheet (SDS) and the Application Guide (AG) for this product. For your nearest local Jotun office, please visit our website at www.jotun.com

Powder application

Recommended film thickness (µm): 60-80

Curing



Equipment

Suitable for Corona or Tribo charging equipment.

APPEARANCE

Colour

The product is available in a wide assortment of custom-made colours, including RAL and NCS.

Gloss

EN ISO 2813 (60°)

Series 1201 12 ± 5
Series 1203 30 ± 5
Series 1206 60 ± 7
Series 1207 77 ± 7
Series 1208 90 ± 10

Finish

Series 1201	Fine texture
Series 1203	Smooth
Series 1206	Smooth
Series 1207	Smooth
Series 1208	Smooth

If the significant surface is too small or unsuitable for the gloss to be measured with the glossmeter, the gloss should be compared visually with the reference sample (from the same viewing angle).

Gloss values of application production shall be within ±5 units of the coating manufacturer's specification.

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PERFORMANCE

The technical data provided below are typical for this product when applied as follows:

Substrate	Chromated aluminium panels
Substrate thickness (mm)	0.8
Film thickness (µm)	60-80

Typical values when tested.

Property	Standard	Result
Dry adhesion	AAMA 2603, Clause 8.4	A Level 4B classification per ASTM D3359 shall be achieved (Method B).
Impact resistance	AAMA 2603, Clause 8.5	No removal of film from substrate
Dry film hardness	AAMA 2603, Clause 8.3	Min. pencil H, without film rupture*
Acid resistance **10% Muriatic acid spot test**	AAMA 2603, Clause 8.6.1	After 15 minutes, no blistering and no visual change in appearance
Alkaline resistance **Mortar test** **100%RH at 100°F**	AAMA 2603, Clause 8.6.2	After 24 hours, no loss or film adhesion or visual change in appearance
Cyclic corrosion resistance	AAMA 2603, Clause 8.7.2	After 1000 hours, minimum rating of 7 on scribe or cut edge and a minimum blister rating of 8
Resistance to humid atmospheres	AAMA 2603, Clause 8.7.1	After 1500 hours – no formation of blisters to extent greater than "Few blisters Size No. 8"
Accelerated weathering	ISO 16474-3	Cycle: 4 hours at 50 ºC UV and 4 hours at 40 ºC condensation. No chalking, excellent gloss retention and colour stability after 250 hours testing.
Natural weathering test	AAMA 2603, Clause 8.8 12 months Florida exposure	Slight chalking, slight fading after 12 months exposure (angle of 45 deg facing south).
Detergent resistance	AAMA 2603, Clause 8.6.3	After 72 hours of exposure, no loss of film adhesion, no blistering and no significant visual change

** High gloss (≥90GU) may give lesser results; subjected to customers acceptance.*

Additional information

This product may be backed by a Product Performance Guarantee when applied on extruded architectural aluminium substrate. For further advice please contact your local Jotun office.

Sustainability

Powder coating is applied in air-and-powder mix in a strictly controlled factory process using electrostatic gun and a high temperature curing oven to create film. Virtually no VOCs are released in the process compared to traditional liquid paints. Unused or oversprayed powder can be recycled with minimal wastage, and disposal is easy and safe. In addition, all Jotun Powder Coatings' products does not contain intentionally added lead.

Disclaimer

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The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.