# Jotun Facade 1387, 1388

## PRODUCT DESCRIPTION

This lead-free TGIC powder coating is specifically designed to meet stringent requirements of the construction industry. Due to its fast cure properties the product improves manufacturing output without compromising on durability and appearance. It provides longevity to the projects and building components by ensuring gloss retention, colour stability and corrosion protection. This product provides uniform flow and attractive finish even after recycling. This product is certified according to Qualicoat Class 1 and has weathering performance in line with AAMA 2603.

### 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. 1.6 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 performance of the coating system is largely dependent on the nature of the substrate and the type and quality of the pretreatment. For optimal results, it is recommended to follow the pretreatment supplier's instructions and recommendations.

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.



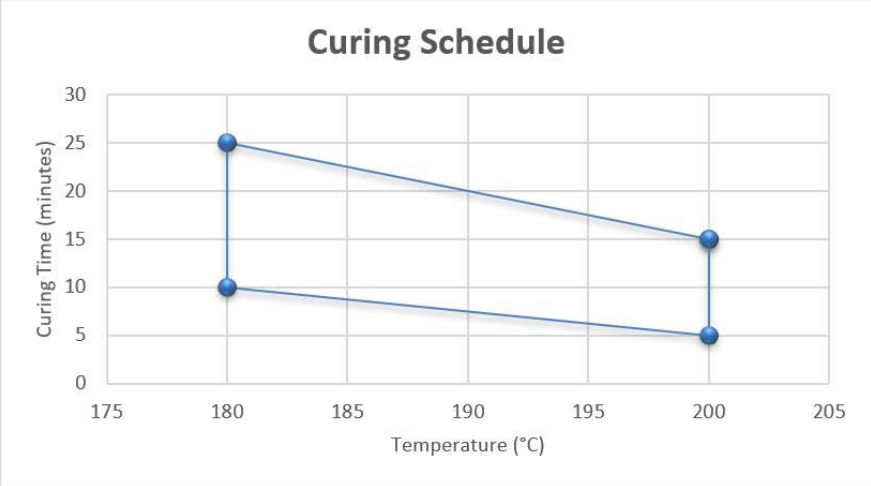
This Technical Data Sheet supersedes those previously issued.

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** White and light colours.

**Gloss** EN ISO 2813 (60°)

| | |
|---|---|
| 1387 | 77±7 |
| 1388 | 90±10 |

**Finish** 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).

# PERFORMANCE

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

| | |
|---|---|
| Substrate | Chrome-free treated aluminium panels |
| Substrate thickness (mm) | 0.8 |
| Film thickness (µm) | 60-80 |

Typical values when tested.

| Property | Standard | Result |
|---|---|---|
| **Adhesion** | EN ISO 2409 | Cross-cut rating Gt0 (100 % adhesion) |
| **Impact resistance** | EN ISO 6272 /ASTM D2794 (impactor diameter 15.9 mm) | More than 23 inch-pounds or 2.5 Nm without film cracking |
| **Cupping test** | EN ISO 1520 | Indentation depth in excess of 5 mm without film cracking |
| **Flexibility** | EN ISO 1519 | Cylindrical mandrel bending test, passes 5 mm mandrel diameter |



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| | | |
|---|---|---|
| **Film hardness** | EN ISO 2815 | Indentation resistance according to Buchholz: >80 |
| **Mortar resistance** | EN 12206-1 | The mortar must be easy to remove without leaving any residues. |
| **Drilling, milling and sawing test** | | No flaking of coating. |
| **Humidity resistance containing $SO_2$.** | ISO 22479 Method B (0.2 I $SO_2$)<br>ISO 4628-2 | No infiltration exceeding 1 mm on both sides of the scratch after 24 cycles. |
| **Humidity resistance** | EN ISO 6270-2<br>ISO 4628-2 | No infiltration exceeding 1 mm on both sides of the scratch after 1000 hours |
| **Acetic acid salt spray resistance** | ISO 9227<br>ISO 4628-2 | After 1000 hours testing – maximum 16 $mm^2$ infiltration over a scratch length of 10 cm. |
| **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 300 hours testing. |
| **Xenon Arc Accelerated Weathering** | ISO 16474-2 Method A | Cycle: 102 minutes dry at 38 °C and 18 minutes water spray under UV. No chalking, excellent gloss retention and colour stability after 1000 hours testing. |
| **Natural weathering test** | ISO 2810 (South Florida, 27 ºN) | No chalking, excellent gloss retention and colour stability after 12 months exposure (angle of 5º to South). |
| **Flame spread index** | ASTM E84 | Class 1 or A |
| **Smoke Development Index** | ASTM E84 | Class 1 or A |

## Approvals

This product is certified according to Qualicoat Class 1 and has weathering performance in line with AAMA 2603.
Qualicoat: Facade 1387/88 - P1733 (AE)

## 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. In addition, all Jotun Powder Coatings' products does not contain intentionally added lead.

## Disclaimer

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.



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