

## PRIMECOAT SERIES 29

**thermosetting powder coating architectural application**  
**polyester**  
**smooth gloss | semi gloss | matte | semi matte**  
**rough gloss structure | fine texture**

### Typical application

#### Protective and decorative coatings on metal items:

- Metal facades
- Steel construction
- Traffic signals.

### Product details

- Packages: carton with antistatic PE bag liner, 20kg, 5kg or Big Bag for approx. 500kg, net
- Storage Stability: min 24 month from manufacture (see printed date on product label)
- Storage temperature: <25°C
- Moisture: <80%
- Specific Gravity (ISO 8130-2): smooth 1.50–1.65 g/cm<sup>3</sup>  
rough structure/fine texture 1.50-1.75 g/cm<sup>3</sup> depending on pigmentation
- Moisture content (ISO 8130-7): <0.4%
- Fluidization (ISO 8130-5): good
- Particle size distribution (ISO 8130-13):
  - fine fraction up to 10 µm in size: <10%
  - base fraction up to 32 µm in size: 25–45%

### Gloss level

- Smooth gloss: 75–100\*
- Semi gloss: 60–75\*
- Smooth matte: 10–40\*
- Semi matte: 40–60\*
- Rough gloss structure: visual comparison
- Fine texture: visual comparison

\* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings). The gloss index can be set by agreement with the consumer. Gloss of coating parameters other than indicated in the table can be agreed with the customer.

### Test results

Checked under laboratory conditions on a chromated 0.8 mm thick aluminium test panel. Actual product performance may vary due to product specific properties such as gloss, color, effect and finish as well as application related and environmental influences.

Test method	Test	Smooth				Fine texture	Rough gloss structure
		Gloss	Semi gloss	Matte	Semi matte		
ISO 2360	film thickness recommended	60-80µm	60-80µm	60-80µm	60-80µm	70-90µm	80-100µm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤3mm	≤5mm	≤5mm	≤6mm	≤10mm	≤10mm
ISO 2815	impression hardness	≥87	≥87	≥87	≥87	-	-
ISO 3668	coating color, deviation	≤1	≤1	≤1	≤1	≤1	≤1
ASTM D 2794	ball impact test cracking of coating	No cracks	No cracks	No cracks	Minor cracks	Cracks	Cracks
ISO 6270-1	determination of resistance to humidity 1000h	≤1mm	≤1mm	≤1mm	≤1mm	≤1mm	≤1mm
ISO 9227	salt spray test 1000h	≤1mm	≤1mm	≤1mm	≤1mm	≤1mm	≤1mm

## Processing

Corona, Tribostatic\*

\* Available upon inquire.

## Color shades

Mainly RAL shades; also special domestic shades on request\*.

\* Color of coating parameters other than indicated in the table can be agreed with the customer.

## Pretreatments

Before the painting, the item should be adequately pretreated in accordance with surface type, final use and required performances. The following table can be used as starting point for the pretreatment choice. The surface shall be clean, dry and appear with a rough and dull profile.

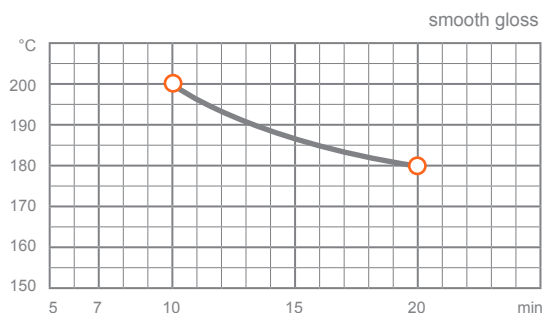
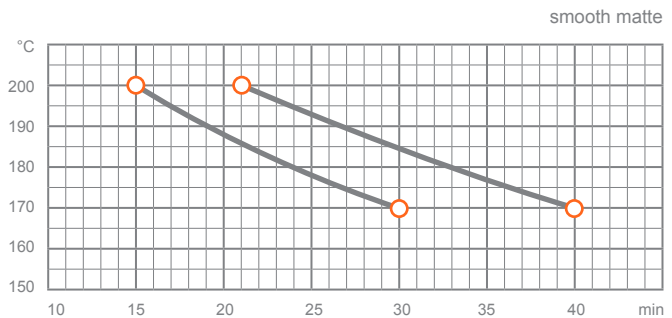
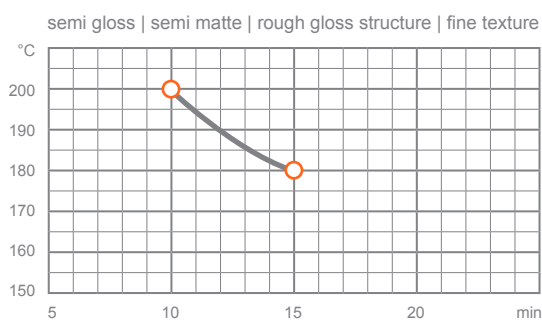
Substrat	Indoor use	Outdoor use	Architecture
Aluminium	soil removal, chromate, chrome-free	chromate, chrome-free	chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting	iron phosphate, zinc phosphate, sand-blasting	-
Zinc coated steel	acid attack, iron phosphate, chromate	acid attack, zinc phosphate, chromate	-

Oxides (rust) cleaning and de-greasing shall be carried out when the simplified process is used! The simplified pre-treatment does not ensure necessary protective properties and decreases the service life of the coating. Hot-dip galvanized steel requires additional mechanical processing (incision).

## Cure parameters

Temperature and time combinations resulting in the optimal cross-linking of the coating.

Typical curing



Please observe cure parameters closely since mechanical properties will develop before full cross-linking!

To obtain optimal stoving conditions you are recommended to carry out practical trials, adapted to the object in question and the stoving oven each time. Temperature conditions of curing for each powder are listed on the label. Our technical service department will be glad to advise you.

The curing mode schedule can be set by agreement with the consumer.

## Note

The data is provided for information purposes and is not exhaustive. The customer using the product otherwise than indicated in the data sheet takes responsibility for the results obtained. As the manufacturer, we provide more precise product description, conditions of usage and all the application process accompanying factors. Due to the fact that direct control on our part cannot be effected in regards to the following of the aforementioned conditions, unless an additional written agreement is made, we offer no guarantees and hold no responsibility for the products usage and the results obtained.

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