

# Pacificgold PG201 Greywacke



Pacificgold PG201 Greywacke			
<b>Product Code:</b>		20197488-KG	
<b>Description</b>			
Pacificgold® PG201 Greywacke Polyester Powder Coating is a tough thermoset powder coating with decorative and durability characteristics that are suitable for internal use and external product applications which exhibit excellent overall performance			
<b>Features</b>		<b>Benefits</b>	
High transfer efficiency	Increased first pass transfer		
25 year service life warranty	Low maintenance		
Low cure	Cost savings on Energy or increased line speeds		
Good flow out	Smooth film appearance		
No solvents or emissions	Less waste and pollution to the environment		
Tough polyester	Hard wearing/serviceable finish		
<b>Uses</b>			
Pacificgold PG201 Greywacke was designed for use as an exterior durable base coat for signage and other external applications.			
<b>Performance Guide</b>			
<b>Weather</b>	Good resistance to weathering.	<b>Salt Spray</b>	Very good salt spray resistance over pretreated aluminium. (1000 hours - unaffected @ ASTM B117) 2-3mm adhesion loss at scribe after 250hrs salt spray on pretreated steel panels
<b>Heat</b>	Excellent resistance to 120°C continuous service conditions.	<b>Humidity</b>	Excellent resistance to 38°C/100% humidity for 1000 hours on pre-treated aluminium.
<b>Acid</b>	Resistant to spills of dilute acid. Avoid contact.	<b>Abrasion</b>	Very good resistance to abrasion
<b>Alkali</b>	Loss of gloss with 10% alkali. Avoid contact	<b>Pencil Hardness</b>	Min F - H
<b>Flexibility</b>	Pass 160 inch/lb	<b>Cross Hatch Adhesion</b>	No removal
<b>Chemical Resistance</b>			
<b>Mortar</b>	Check individual products, limit contact.	<b>White Spirits</b>	Resistant
<b>Ethanol</b>	Resistant	<b>Xylene</b>	Slight softening/limit contact
<b>Methyl Ethyl Ketone</b>	Softens/avoid contact	<b>Ethyl Acetate</b>	Softens/avoid contact
<b>Product Guide</b>			
<b>Colour</b>	A wide range of stock and made to order solid colours & pearlescents	<b>Specific gravity</b>	1.3 - 1.7 @ colour

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<b>Gloss Level</b>	25 - 98% at 60° as required	<b>Shelf life</b>	12 months when stored below 25°/dry conditions
<b>Toxicity</b>	Refer MSDS (No 39601)		

## Application Data

<b>Application Method</b>	Electrostatic spray.		
<b>Clean Up</b>	Dust or vacuum loose powder. Avoid use of compressed air.		
<b>Cure Schedule</b>	<b>Metal Temperature (°C)</b>	<b>Time (minutes)</b>	
	160	12	
<b>Cured Film Thickness</b>	Recommended:	80 µm	
	Range:	50 – 150 µm	

### Theoretical spreading rate at recommended film thickness

A coverage rate of 10 - 12m<sup>2</sup>/kg corresponds to 80 µm cured film thickness assuming no loss. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.

## Application Guide

### Surface Preparation

Surfaces should be prepared according to AAMA2603-98 (available from Standards Australia or Standards New Zealand offices) for Aluminium substrates or degreased and pretreated for exterior exposure of other substrates. Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes:

Aluminium	Yellow chromate or green chromate/phosphate	(refer AS3715-2002 and/or BS6496)
Ferrous Metals	Zinc or Iron Phosphate	(refer BS6497 and/or AS/NZS4506)
Zinc coated metals	Zinc or Iron Phosphate	(refer AS/NZS4506)

### Application Procedure and Equipment

1a)	For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble "simmering liquid". Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly.
1b )	For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.
2.	Apply by electrostatic spray.
3.	Cure as per recommendations outlined above.
	Care should be exercised when stoving at 220°C or above as some colours are prone to discolouration.
4.	Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.

## Care and Maintenance

Reference should be made to AAMA610.1:1979 standard for cleaning of surfaces.

In broad terms, cleaning of externally located powder coating surfaces must take place every three months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

### THREE STEPS TO CLEANING POWDER COATED SURFACES

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

**WARNING:** In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes and will render the warranty void if used. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Ethyl Alcohol or Isopropanol.

## Health and Safety

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The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information.

For detailed information, refer to product label and the current Chemical Data Sheet (No. 39601) available through Sales and Customer Service Offices.

Phone: Australia:-	13 24 99	New Zealand:-	09 441 8244.
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## Precautions and Limitations

- As a result of possible wide application variations and stoving conditions, some products and colours may show a variance between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
  - For optimum performance ensure recommended dry film thickness is obtained. Some light colours require increased film thickness average to achieve optimal consistency.
  - Not recommended for use in highly corrosive environments such as severe marine or industrial locations.
  - Not recommended for components which are exposed to constant temperatures exceeding 120°C.
- Dulux Powder Coatings is under no obligation to replace product or repair damages that may result from the use of this product in any way other than stated on the Product data sheet or Material safety data sheet.

## Transport and Storage

<b>Sizes:</b>	20 kg	<b>Flashpoint:</b>	N/A
<b>Weight:</b>	20 kg	<b>UN:</b>	N/A
<b>Dangerous Goods Class:</b>	N/A	<b>Package Group:</b>	N/A
<b>Shipment Name:</b>	Not dangerous goods. No special transport requirements.		

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