



Pacifigold® PG 288

POWDER & INDUSTRIAL COATINGS

Dulux Powder & Industrial Coatings TGIC Free Polyester Powder Coating			
Product Code:		288 Line	
Description			
Pacificgold® PG288 Polyester Powder Coatings are a range of tough thermoset powder coatings with decorative and durability characteristics that are suitable for internal use and external product applications, colour and finish dependanttt excellent overall performance			
Features		Benefits	
High transfer efficiency		Increased first pass transfer	
15 - 25 year service life estimate – dependant upon environment.		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	
Uses			
Pacificgold® PG288 Polyesters have a multitude of uses over varied substrates from steel to aluminium. Examples of their application include bicycles, garden tools, lawn mowers, industrial transformers and heavy equipment and automotive components. This product has not been designed for Architectural use, advice should be sought before specifying PG288 for Architectural Joinery, Cladding or fittings.			
Performance Guide			
Weather	Good resistance to weathering, colour and finish dependant.. Note some colours are not exterior durable – please consult the Pacificgold Colour card.	Salt Spray	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
Heat	Excellent resistance to 120°C continuous service conditions.	Humidity	Excellent resistance to 38°C/100% humidity for 1000 hours on pre-treated aluminium.
Acid	Resistant to spills of dilute acid. Avoid contact.	Abrasion	Very good resistance to abrasion
Alkali	Loss of gloss with 10% alkali. Avoid contact	Pencil Hardness	Min F - H
Flexibility	Pass 160 inch/lb	Cross Hatch Adhesion	No removal
Chemical Resistance			
Mortar	Check individual products, limit contact.	White Spirits	Slight softening/avoid contact
Ethanol	Resistant	Xylene	Slight softening/avoid contact

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Methyl Ethyl Ketone	Softens/avoid contact	Ethyl Acetate	Softens/avoid contact
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Product Guide

Colour	A wide range of stock and made to order solid colours & pearlescents	Specific gravity	1.3 - 1.7 @ colour
Gloss Level	25 - 98% at 60° as required	Shelf life	12 months when stored below 25°/dry conditions
Toxicity	Refer MSDS DLXNZLEN001357 or DLXNZLEN002722		

Application Data

Application Method	Electrostatic spray.		
Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.		
Cure Schedule	Metal Temperature (°C)	Time (minutes)	
	200	7	
	180	8	
	175	10	
Cured Film Thickness	Recommended:	80 µm	
	Range:	50 – 150 µm	

Note: Light colours may require a higher minimum film build for optimum coverage and colour consistency.

Theoretical spreading rate at recommended film thickness

A coverage rate of 10 - 12m²/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)
Ferrous Metals	Zinc or Iron Phosphate	(refer 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 AAMA609 & 610 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.

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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

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. 10355) available through Sales and Customer Service Offices.

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

- Strong, bold colours may not necessarily meet these criteria and so should be referred to Dulux Powder Coatings before specifying.
 - 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

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

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