



Pacificgold[®] Cobb Webb



POWDER & INDUSTRIAL COATINGS

Cobb Webb Powder Coating			
Product Code:		931 Line	
Description			
Cobb Webb finishes are a range of speciality powder coatings specifically formulated to give a highly attractive textured finish.			
Features		Benefits	
Attractive finish		Increased customer appeal	
Slight texture		Hide substrate imperfections	
Film integrity		Long intact life of coating	
Tough polyester		Hard wearing/serviceable finish	
No solvents or emissions		Less waste and pollution to the environment.	
Uses			
Cobb Webb decorative finishes may be used for a variety of applications. Examples include: office fittings and furniture, garden tools, computer equipment, electrical equipment, shelving, interior joinery components, and architectural finishes.			
Performance Guide			
Weather	Limited resistance to weathering. Refer requirements to your Dulux Powder Coatings Representative.	Salt Spray	Good. < 3mm adhesion loss at scribe after 250 hours salt spray on pre-treated steel, 1000 hours on pre-treated aluminium.
Heat	Excellent resistance to 90°C continuous service conditions	Humidity	Good resistance to 38°C/100% humidity for 1000 hours on pre-treated aluminium.
Flexibility	Pass 80 inch/lb	Abrasion	Very good resistance to abrasion
		Pencil Hardness	Min H
		Cross Hatch Adhesion	No removal
Chemical Resistance			
Ethyl Acetate	Softens/avoid contact	White Spirits	Resistant
Ethanol	Resistant	Xylene	Slight softening/limit contact
Methyl Ethyl Ketone	Softens/avoid contact		
Product Guide			
Colour	A range of made to order solid colours are available	Specific gravity	1.3 - 1.7 @ colour
Gloss Level	N/A	Shelf life	12 months when stored below 25°C/dry conditions
Note : The texture and gloss are developed by the chemical nature of the formulation, and there is very little possibility for changed gloss levels or variations on the pattern.			
Application Data			
Application Method	Electrostatic spray.		

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Clean Up		Dust or vacuum loose powder. Avoid use of compressed air.	
Cure Schedule		Metal Temperature (°C)	Time (minutes)
		210	8
		200	10
Cured Film Thickness		Recommended:	80 µm
		Range:	60 – 100 µm
Notes:	1. Thin films will show poor pattern development, whilst thick films may show no pattern at all.		
	2. Curing at temperatures below 200°C is not recommended due to potential problems in pattern formation.		
	3. There should be proper air flow in the curing oven to permit pattern development. If there is insufficient air flow, the pattern may either fail to develop or be uneven. Careful evaluation is required before considering the curing of the Cobb Webb finishes in an infra red curing system.		
Typical coverage rate:			
A coverage rate of 8 - 10 m ² /kg is commonly experienced. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.			
Application Guide			
Surface Preparation			
All surfaces should be degreased and pre-treated for optimal performance. 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/NZ4506)	
Zinc Coated Steels	Zinc or Iron Phosphate	(refer AS/NZ4506)	
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)	Box feeders are not recommended for the application of these powder coatings.		
2.	Apply by electrostatic spray.		
3.	Cure as per recommendations outlined above.		
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.		
Additional Notes for the Application of Cobb Webb			
<ul style="list-style-type: none">• The heat up rate of components in the curing oven will influence pattern development. Heat up rates should be as constant and rapid as possible to obtain reproducible patterns. Slow heat up rates may give poor pattern development.• Where components of differing mass are to be assembled some variation is to be expected due to variation in heat up rates and temperature profiles. It should also be noted that different types of electrostatic spray equipment may give different patterns due to the different charging techniques.• Due to the particular surface tension characteristics of these finishes, they tend to be more prone to contamination effects than conventional powders, and care must be taken to ensure that powder circulation systems, spray booths, recovery systems and surrounding areas are thoroughly cleaned prior to application.• Similarly specialty finishes may contaminate regular flow materials, ensure that powder circulation systems, spray booths, recovery systems and surrounding areas are thoroughly cleaned after application.• The nature and thickness of the substrate will affect the pattern formation. Substrates of > 1.5mm thickness should be checked carefully.			
Care and Maintenance			
As a general rule, cleaning of externally located powder coating surfaces must take place every six months. In areas where salts/pollutants are more prevalent such as seaside or 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. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Ethyl Alcohol, 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. 00000619) available through Sales and Customer Service Offices.

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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.
- 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 90°C.
- Maximum reclaim to be added is recommended at 15%

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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