

Dulux Powder Coatings Alphatec®

AU_DP01826

Product Code	961 & 984
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Description
Alphatec® is a tough thermosetting polyester powder coating with decorative and durability characteristics, suitable for interior and non architectural exterior product applications combined with excellent overall performance.

Features And Benefits	
<ul style="list-style-type: none"> • Colour Chart colours • Tough, one coat finish • Interior/exterior applications • Low cure/high transfer efficiency • No solvents or emissions • TGIC free 	<ul style="list-style-type: none"> • Readily available colour range • Hard wearing/serviceable finish • Less waste and pollution to the environment • Suitable for most environments • Reduced application costs • Reduced risk to health

Uses
Alphatec® polyesters have a multitude of uses over various substrates including steel and aluminium.
- Examples include: bicycles, garden tools, lawn mowers, and automotive components.


Precautions And Limitations
<p>Some strong, bold colours may not meet performance criteria for weathering (colour change), refer to Dulux Powder Coatings before specifying.</p> <p>As a result of possible wide application variations and stoving conditions, some products and colours may show variation 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.</p> <p>For optimum performance ensure recommended dry film thickness is obtained.</p> <p>Not recommended for use in highly corrosive environments such as severe marine or industrial locations.</p> <p>Not recommended for components which are exposed to constant temperatures exceeding 120°C.</p> <p>When using sealants or screen printing the surface preparation is paramount to achieve good adhesion (see your Dulux technical representative for recommendations).</p> <p>Alphatec® Plus is not recommended for use on Thermal Break materials.</p>

Performance Guide			
Exterior Durability	Good resistance to weathering. Suitable for outdoor applications.	Salt	Good. < 3mm adhesion loss at scribe after 250 hrs pretreated steel, 1000 hrs pre-treated aluminium.
Heat Resistance	Good resistance to 120°C continuous service conditions.	Water	Excellent resistance to 38°C/100% humidity for 1000 hours on pre-treated aluminium.
Solvent	Resistant to alcohol and white spirits. Softens with ketones. Refer Dulux for further details.	Abrasion	Very good resistance to abrasion.
Acid	Resistant to spills of dilute acid. Avoid contact.	Alkali	Resistant to spills of dilute alkali. Avoid contact.

Typical Properties			
Gloss Level	15 80%	Coverage	Coverage rate of 8 - 10m ² /kg corresponds to 80 microns
Shelf Life	12 months when stored below 30°C/dry conditions	V.O.C Level	N/A
Colour	A wide range of stock and made to order solid colours.		
Meets GBCA VOC Requirement?	Yes. Dulux Powder Coatings: <ul style="list-style-type: none"> Contain no harmful volatile organic solvents Free of heavy metal pigments such as lead, cadmium, arsenic & mercury Proven low temperature curing technology Produced with stringent Safety, Health & Environmental policies and standards Developed with consideration of life cycle analysis, to guide our suppliers and the materials we use Manufactured in facilities where significant energy and resources employed in production, are measured with aggressive reduction targets in place Produced and used with minimal waste Consequently, Dulux® Powder Coatings are a prime consideration for projects where air quality standards have been set, such as 4, 5 & 6 Green Star Rating Projects.		
Sanding Properties	Sandable	Film Build (microns)	Minimum 50 microns, Maximum 110 microns
Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.	Application Method	Electrostatic Spray
Specific Gravity	1.49 - 1.54 @colour	Flexibility	Excellent < or 160 in/lb
Pencil Hardness	Min H	Knoop Hardness	Average 15
Cross Hatch Adhesion	No removal	Chemical Resistance	Mortar Resistant White Spirits Resistant Ethanol Resistant Xylene Slight softening/limit contact Methyl Ethyl Ketone Softens/avoid contact Ethyl Acetate Softens/avoid contact
Cure Schedule	Metal Temperature (°C) 210 200 180	Time (minutes) 4 Mins 5 Mins 8 Mins	Comments

Application Guide	
Surface Preparation	<ul style="list-style-type: none"> Surfaces should be prepared according to appropriate standards such as AS/NZS4506, AS3715-2002, BS6496, BS6497 (available from Standards Australia or Standards New Zealand offices). All surfaces should be degreased and pre-treated for optimal performance. Suitable pre-treatment includes: <ul style="list-style-type: none"> Aluminium - Yellow chromate or green chromate/phosphate (refer AS3715-2002 and/or BS6496) Ferrous metals Abrasive blast (SA 2.5)/Zincshield™ powder primer (refer Zincshield™ Data Sheet) or Zinc phosphate or Iron phosphate (refer BS6497) Zinc Coated Steels (eg. galvanising) - Zinc phosphate or chromate (refer BS6497) Stainless Steel - Suitable metal blast. Recommended maximum blast profile of 25 microns
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Spray Application Guide

Thinner 	Not Applicable
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Care And Maintenance

As a general rule, cleaning of externally located powder coating surfaces must take place every six 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. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Turpentine, White Spirits, Ethyl Alcohol, Isopropanol.

Health And Safety

MSDS Number	13960120, 0	Health Effects	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.13960120) available through Sales and Customer Service Offices. Phone: Australia:- 13 24 99
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In the case of emergency, please call 1800 033 111

Transport And Storage

Package Weight	20 Kg	Shipment Name	Not dangerous goods. No special transport requirements.
Flash Point	N/A	UN Number	N/A
Dangerous Goods Class	N/A		

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