

<b>Product Code</b>	40X Line
<b>Approval</b>	Architectural Aluminium Standards: Meets or exceeds AS3715, AAMA2605

### Description

Fluoroset™ Xtreme is a range of subtle and solid neutral colours, delivered with warranty grade advanced ultra durable fluoropolymer thermosetting powder.

Ideal for warranty grade applications over:

- Architectural aluminium including perforated and expanded aluminium.

Fluoroset™ Xtreme can also be used on the following metals but these are not warranted:

- Steel (mild), bright/semi bright steel, black steel and blue steel,
- Galvanised steel, stainless steel and Zinalume®.

Fluoroset™ Xtreme is supported by Alumi Shield™ warranties\* when applied by a DGL Accredited Powder Coater to the warranty specification on recommended project types and conditions.

\*Subject to the terms and conditions of the relevant product warranty. Please contact your local DGL representative for further details.

**IMPORTANT INFORMATION - CARE & MAINTENANCE POST INSTALLATION A SIMPLE AND REGULAR MAINTENANCE PROGRAM MUST BE IMPLEMENTED AND RECORDED IN LINE WITH THE DGL POWDERS CARE AND MAINTENANCE SCHEDULE TO:**

1. Comply with DGL warranty requirements,
2. Ensure the life of your asset is maximised

It is important that architects, specifiers, powder coaters, fabricators, manufactures and builders ensure they reinforce this message to the end asset owner.

For more information refer to the DGL Care and Maintenance brochure available at [dglpowders.com/tech-advice](http://dglpowders.com/tech-advice).

Zinalume is a registered trade mark of Bluescope Steel Limited.

### Features And Benefits

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| <ul style="list-style-type: none"> <li>• Ultra Durable fluoropolymer powder coating.</li> <li>• Alumi Shield™ 35 year aluminium durability warranty</li> <li>• Alumi Shield™ 30 year aluminium colour warranty.</li> <li>• Solid finish.</li> <li>• No solvents or emissions &amp; TGIC free.</li> <li>• Formulated to meet: AS 3715 and AAMA 2605.</li> </ul> | <ul style="list-style-type: none"> <li>• Guaranteed performance on appropriately pretreated aluminium.</li> <li>• Superior colour retention.</li> <li>• Ultra Durable hardwearing finish.</li> <li>• Ideal for use in most marine locations including less than 10m from the high tide line.</li> <li>• Recycle via appropriate application reclaim processes.</li> </ul> |
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### Uses

Fluoroset™ Xtreme has been developed for use in situations where class leading durability and colour retention is desired on a wide range of metal substrates including, most architectural aluminium applications such as window and door system, louvres, balustrades, sunshades, perforated screen, curtain walls, shop fronts, furniture and shelving.

It is ideal for;

Exterior projects,

- All commercial buildings,
- All residential buildings,
- Non-habitable.

Interior projects;

- All commercial buildings,
- All residential buildings,
- Non-habitable.

Subject to the terms and conditions of the relevant product warranty.

## Precautions And Limitations

Fluoroset™ Xtreme is only available in pearlescent colours which meet DGL International Powder Coatings pigmentation criteria. Some strong, bold colours may not necessarily meet these criteria and should be referred to DGL International Powder Coatings before specifying.

It is recommended that each project is coated with the same batch of powder, by the same applicator, in the same direction, ie, all vertically or all horizontally and if possible at the same time. This is especially important when large visible areas of a project are powder coated, for example, cladding and perforated and expanded aluminium sheets.

As a result of possible wide application variations and oven curing conditions, some products and colours may show variation between DGL 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 components which are exposed to constant temperatures exceeding 120°C. Powder coated surfaces are not designed to be touched or mechanically abraded above 50°C.

Not recommended for post fabrication processes such as post-forming, zipping for double or triple glazing or punching. Many post fabrication processes can impede achievement of a continuous layer of pre-treatment and the minimum film build of powder coating. Consult the relevant guideline or regulation such as the building code or window association for information on mitigating any potential damage that could be caused by post fabrication processes.

Cutting and drilling must be done with very sharp saws, drills, etc., as blunt tools will likely result in chipping. Cutting lubricants must be cleaned off as per the DGL Care & Maintenance instructions. For more information refer to the DGL Care and Maintenance brochure available at [dglpowders.com/techadvice](http://dglpowders.com/techadvice).

### IMPORTANT DESIGN CONSIDERATIONS:

It is recommended that any item that is coated should be designed and fabricated using AS 2312.1 and the relevant building code as guides.

The following design elements should be avoided - narrow crevices, poor air circulation, depressions, sharp edges and corners, large flat ledges (not window ledges), intermittent welding, undrained flat surfaces, unsealed hollow sections, flat surfaces in loose contact where moisture may be drawn in between them by capillary action and contact between dissimilar metals, e.g., with screws, rivets, etc.

Take care if non-metallic substrates are required to be or cannot avoid being powder coated, e.g., thermal break strips in double or triple glazing. On these non-metallic surfaces powder coatings may not adequately adhere and the final visual appearance may not be acceptable.

When aluminium items are exposed to interior and exterior environments it is essential that should only one side of a section of metal be coated, it must be in a sealed environment, i.e, not exposed to moisture, air and excessive heat. Should the seal fail, and a claim is made for an Alumi Shield™ warranty project this will be void as the integrity of the seal is not the responsibility of DGL.

## Performance Guide

<b>Exterior Durability</b>	Superior resistance to weathering, providing extended protection for aluminium.	<b>Salt</b>	Excellent salt spray resistance over pre-treated aluminium for 4,000 hours according to ASTM B117.
<b>Heat Resistance</b>	Excellent resistance to 120°C continuous service conditions. Surfaces are not designed to be touched or mechanically abraded above 50°C.	<b>Water</b>	Excellent resistance to 38°C/100% humidity for 4,000 hours on pre-treated aluminium.
<b>Solvent</b>	Resistant to methylated spirits and isopropyl alcohol. Avoid contact with, for example white spirits, mineral turpentine and kerosene, etc.	<b>Abrasion</b>	Excellent resistance to abrasion. Abrasion Coefficient > 40 (ASTM D968 falling sand test method)
<b>Acid</b>	Resistant to the 15 minute spot test for Muriatic Acid, and 30 minute Nitric Acid test as per AAMA 2605.	<b>Alkali</b>	Resistant to spills of dilute alkali at room temperature. Avoid contact.

Typical Properties			
<b>Gloss Level</b>	Matt 35-44 at 60° Satin 45-75 at 60°	<b>Coverage</b>	12m <sup>2</sup> /kg corresponds to 50um cured film thickness when fully reclaiming over sprayed powder in accordance with Dulux recommendations.
<b>Shelf Life</b>	2 years from date of manufacture if stored at < 25 °C.	<b>V.O.C Level</b>	Not formulated with Volatile Organic Compound (VOCs).
<b>Colour</b>	A limited range of stocked colour. If you cannot find the colour you require DGL offer a Custom colour service. Visit <a href="http://dglpowders.com">dglpowders.com</a>		
<b>Meets GBCA VOC Requirement?</b>	Yes (Powder Coatings Only). This Premium Powder Coating: <ul style="list-style-type: none"> <li>▪ Contains no harmful volatile organic solvents</li> <li>▪ Is free of heavy metal pigments such as lead, cadmium, arsenic &amp; mercury</li> <li>▪ Is produced with stringent Safety, Health &amp; Environmental policies and standards</li> <li>▪ Is manufactured in facilities where significant energy and resources employed in production, are measured with aggressive reduction targets in place</li> <li>▪ Is produced with minimal waste</li> </ul> Consequently, this Premium Powder Coating is a prime consideration for projects where air quality standards have been set such as 4, 5 & 6 Green Star Rating Projects.		
<b>Film Build (microns)</b>	Recommended 50µm, range 40-80µm.	<b>Clean Up</b>	Dust or vacuum loose powder. Avoid use of compressed air.
<b>Application Method</b>	Electrostatic Spray	<b>Specific Gravity</b>	1.3 - 1.7 depending on colour.
<b>Flexibility</b>	< 3.4 Nm (< 30 in/lb) by direct impact with a 3mm substrate deformation.	<b>Pencil Hardness</b>	H to 2H - no rupture of film per ASTM D3363.
<b>Cross Hatch Adhesion</b>	No removal (ref AAMA 2605 test method).	<b>Chemical Resistance</b>	<b>Mortar</b> PASS (24 hours Pat test ref. EN 12206-1). <b>Methylated Spirits</b> Good resistance. <b>Isopropyl alcohol</b> Good resistance. <b>Acid</b> Resistant to dilute acid at ambient temperatures. Avoid contact. <b>Alkali</b> Resistant to dilute alkali at ambient temperatures. Avoid contact. <b>Stronger solvents</b> Avoid contact with, for example white spirits, mineral turpentine and kerosene etc.
<b>Cure Schedule</b>	<b>Metal Temperature (°C)</b> 210 200 195	<b>Time (minutes)</b> >20 Mins >25 Mins >30 Mins	<b>Comments</b> Metal temperature. Metal temperature. Metal temperature.

Application Guide	
<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>▪ PREPARATION FOR ALUMINIUM SUBSTRATES:</li> </ul> <p>Etch;</p> <ul style="list-style-type: none"> <li>• The etch process is an important stage of pre-treatment and close consultation with your pre-treatment supplier is strongly recommended to ensure optimum adhesion &amp; corrosion resistance is obtained.</li> <li>• Etch rates must be a minimum of 1gm/m<sup>2</sup>.</li> </ul> <p>Chrome Conversion Coatings;</p> <ul style="list-style-type: none"> <li>• Chrome conversion weights must be a minimum of 431mg/m<sup>2</sup>.</li> </ul> <p>Chrome-free conversion coatings;</p> <ul style="list-style-type: none"> <li>• Chrome-free - refer to your pre-treatment supplier as currently no standards address chrome-free.</li> </ul> <p>Final deionised water rinse;</p> <ul style="list-style-type: none"> <li>• The conductivity of the final rinse water draining from the aluminium articles must be less than 30 micro Siemens/cm<sup>2</sup> at 20°C.</li> </ul> <p>Post rinse dry off temperature - consult your pre-treatment supplier but generally;</p> <ul style="list-style-type: none"> <li>• &lt; 75° C for chrome pre-treatment,</li> <li>• &lt; 120° C for chrome-free pre-treatment.</li> </ul> <p>Pre-treated aluminium must be handled very carefully with clean lint-free gloves and powder coated within the time specified by the pre-treatment supplier - this is generally within 16 to 48 hours.</p> <p>Dulux Accredited Powder Coaters must comply with the metal pre-treatment guidelines set out in the Accredited Alumi Shield™ Manual.</p> <p>PREPARATION FOR STEEL SUBSTRATES.</p> <ol style="list-style-type: none"> <li>1. Wash and degrease all surfaces to be coated in accordance with AS1627.1 with a free-rinsing, neutral/alkaline detergent, in strict accordance with the manufacturer's written instructions and all safety warnings.</li> <li>2. Wash with fresh potable water and ensure that all soluble salts are removed. Testing if required can be done in accordance with AS3894.6 for the determination of residual contaminants.</li> <li>3. Grind all sharp edges with a power tool to a minimum radius of 2mm.</li> <li>4. Hand or power tool clean welds to AS1627.2 to remove roughness. Remove filings, preferably by vacuum.</li> <li>5. Abrasive blast clean all steel surfaces to be powder coated in accordance with AS 1627.4 to the visual cleanliness standard of SA 2.5. Use a medium that will generate a surface profile of 35 to 65 microns. In situations where it is not possible to prepare your item on all surfaces as described above, for long term protection against corrosion it is strongly recommended whenever possible, that an alternative substrate such as aluminium be considered.</li> <li>6. The steel must be coated within 4 hours of blasting and stored in an area which is clean and dry.</li> </ol>
<p><b>Application Procedure And Equipment</b></p>	<ul style="list-style-type: none"> <li>▪ APPLICATION.</li> </ul> <p>Powder must be &lt; 2 years from date of manufacture and stored at &lt; 25 °C in dry conditions.</p> <p>Application is generally by electrostatic spray.</p> <p>Light colours may require a higher minimum film build for optimum coverage and colour consistency.</p> <p>Theoretical Coverage rate at recommended film thickness;</p> <p>A coverage rate of 12m<sup>2</sup>/kg corresponds to 50µm cured film thickness assuming minimal loss i.e., over sprayed powder is reclaimed or recycled, sieved and mixed with virgin (fresh) powder under controlled conditions – a general rule of thumb is &lt; 20% of reclaim powder continuously added to the fresh (virgin) powder to maintain a consistent finish. Extra care should be taken with reclaiming blended products. Practical coverage rates will vary due to such factors as method of application, surface profile and texture.</p> <p>Apply with equipment and control systems to enable correct metal pre-treatment and control of the application and oven conditions.</p> <p>DGL Accredited Powder Coaters must comply with recommendations as set out in the Accredited Applicator Manuals.</p> <ol style="list-style-type: none"> <li>1a). For fluidised bed, ensure uniform fluidisation of powder. Powder found to be compacted may require fluidising for a few minutes prior to coating - powder should resemble a rolling motion.</li> <li>1b). Box feeders can be used when spraying bonded pearls and metallic powders, though it is not best practice. Box feeders are NOT recommended for spraying blended pearls and metallic powders.</li> <li>2. Apply by electrostatic spray.</li> <li>3. Cure as per recommendations outlined above. Air temperatures exceeding 220°C may result in irreversible colour &amp; gloss variation in light and bold colours and excessive temperatures may result in irreversible damage to the powder coating film.</li> <li>4. Test for cure of the coating by conducting a 30 MEK double rub within 30 seconds test. The surface should be wiped dry and left for 60 seconds and then checked for softening. Only slight softening and minimal colour transfer to test cloth should occur.</li> </ol> <p>SPECIFICATIONS:</p> <p>Specifications for all approved substrates are available that detail full coatings systems required including where primers are required. These include,</p> <p>On aluminium;</p> <p>Powder Primers may be necessary on appropriately pre-treated perforated and expanded aluminium for a Alumi Shield™ warranty as detailed below,</p> <ol style="list-style-type: none"> <li>a. Interior general;</li> </ol> <p>Interior conditions (E-Prime™ base coat not mandatory), moderate interior (E-Prime™ base coat mandatory).</p> <ol style="list-style-type: none"> <li>b. Exterior mild (E-Prime™ base coat not mandatory), severe (E-Prime™ basecoat mandatory).</li> </ol> <p>For more information about all specifications for aluminium visit <a href="http://dglpowders.com">dglpowders.com</a>.</p>

## Care And Maintenance

### PACKAGING PRE INSTALLATION

Attention to packing is essential for powder coaters and fabricators to ensure that all powder coated sections are received in good condition. When packing powder coated assets, it is recommended that:

- Sections must be adequately cooled prior to packing; the metal temperature must not exceed 40°C on packing.
- Appropriate protective wrapping is recommended prior to packing to avoid damage during transport.
- If protective tapes are used, ensure that the tape will remain removable following transport, fabrication and installation and not irreversibly mark or damage the coating. Tapes should be used in accordance with the manufacturer's instructions and only remain in contact for the minimum amount of time.
- Packed metal should be kept away from sunlight or moisture to avoid coating defects.

### CARE & MAINTENANCE POST INSTALLATION

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## Health And Safety

<b>MSDS Number</b>	Fluorose™ Xtreme 40X Line (Non-Hazardous) - DLXDGLN003450	<b>Safety Precautions</b>	The SDS 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 Safety Data Sheet available at <a href="http://dglpowders.com/datasheets-safety-data-sheets/">dglpowders.com/datasheets-safety-data-sheets/</a>
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In the case of emergency, please call 1800 033 111

## Transport And Storage

<b>Package Weight</b>	20 KG	<b>Shipment Name</b>	Not dangerous goods. No special transport requirements.
<b>Flash Point</b>	N/A	<b>UN Number</b>	N/A
<b>Dangerous Goods Class</b>	N/A	<b>Package Group</b>	N/A

## Images



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