

## PRIMECOAT SERIES 77

thermosetting powder coating for outdoor use  
 polyester  
 smooth gloss | smooth matte  
 fine texture | anodized effect | antique  
 chrome metallic

### Typical application

#### Protective and decorative coatings on metal items:

- Construction metal structures
- Agricultural machinery
- Transport elements
- Auto parts
- Garden and sports equipment.

### Product details

- Packages: carton with antistatic PE bag liner, 20 kg, 5 kg or Big Bag for approx. 500 kg, net
- Storage Stability: 24 month from manufacture (see printed date on product label)
- Storage temperature: <25°C
- Specific Gravity (ISO 8130-2): smooth 1.50–1.75 g/cm<sup>3</sup> depending on pigmentation
- Moisture content (ISO 8130-7): <0.4%
- Particle size distribution (ISO 8130-13):
  - fine fraction up to 10 µm in size: <10%
  - base fraction up to 32 µm in size: 25–45%

### Gloss level

N/D\* (visual comparison)

\* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings).

### Test results

Checked under laboratory conditions on a chromated 0.8 mm thick aluminium test panel.

Test method	Test	Glossy	Matte	Fine	Anodized	Antique	Chrome
ISO 2360	film thickness recommended	60-80 µm	60-80 µm	70-90 µm	60-80 µm	100-150 µm	60-80 µm
ISO 2409	cross cut test/adhesion 1 mm cutting distance	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤10mm	≤10mm	≤10mm	≤10mm	≤32mm	≤10mm
ISO 3668	coating color, deviation	≤1	≤1	≤1	≤1	≤1	≤1
ASTM D 2794	ball impact test cracking of coating	No cracks	Minor cracks	Cracks	No cracks	Cracks	No cracks

### Processing

Corona, Tribostatic\*

\* Available upon inquire.

## Color shades

Mainly RAL shades; also special domestic shades on request\*.

\* Color of coating parameters other than indicated in the table can be agreed with the customer.

## Pretreatments

Before the painting, the item should be adequately pretreated in accordance with surface type, final use and required performances.

The following table can be used as starting point for the pretreatment choice. The surface shall be clean, dry and appear with a rough and dull profile.

Substrat	Indoor use	Outdoor use	Architecture
Aluminium	soil removal, chromate, chrome-free	chromate, chrome-free	chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting	iron phosphate, zinc phosphate, sand-blasting	-
Zinc coated steel	acid attack, iron phosphate, chromate	acid attack, zinc phosphate, chromate	-

Oxides (rust) cleaning and de-greasing shall be carried out when the simplified process is used!

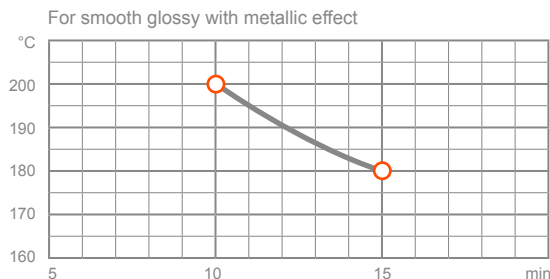
The simplified pre-treatment does not ensure necessary protective properties and decreases the service life of the coating.

Hot-dip galvanized steel requires additional mechanical processing (incision).

## Cure parameters

Temperature and time combinations resulting in the optimal cross-linking of the coating.

Typical curing



Please observe cure parameters closely since mechanical properties will develop before full cross-linking!

To obtain optimal stoving conditions you are recommended to carry out practical trials each time, adapted to the carry out practical trials each time, adapted to the object in question and the stoving oven.

Temperature conditions of curing for each powder listed on the label.

**Our technical service department will be glad to advise you.**

## Note

The data is provided for information purposes and is not exhaustive. The customer using the product otherwise than indicated in the data sheet takes responsibility for the results obtained. As the manufacturer, we provide more precise product description, conditions of usage and all the application process accompanying factors. Due to the fact that direct control on our part cannot be effected in regards to the following of the aforementioned conditions, unless an additional written agreement is made, we offer no guarantees and hold no responsibility for the products usage and the results obtained.

### Address:

Primatek Coatings OÜ  
Kadastiku 29A  
21004 Narva, Estonia

### Contact:

Phone +372 655 1010  
primatek-coatings.com

### Bank details:

Swedbank AS:  
EE87 2200 2210 5686 9100