



## PRODUCT DATA SHEET

## KOSKOTE 4000 HY-SERIES

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## (Texture Polyester-Epoxy Powder Coating)

### DESCRIPTION

KOSKOTE 4000 HY Series specialty powder coating is a polyester-epoxy powder coating formulated to give a texture finish which is suitable for a wide range of indoor applications such as domestic appliances and office equipment.

### PHYSICAL PROPERTIES

Appearance	: Free flowing fine powder
Specific gravity	: 1.20 – 1.70 g/cm <sup>3</sup> (depending on colour)
Volume Solid	: 100%

### SURFACE PREPARATION

Ensure that the surface is properly cleaned and free from oil, grease and other contaminants, Subsequent surface treatments might include blasting, if required, and iron phosphate or zinc phosphate depending on the long term corrosion performance desired.

### APPLICATION INSTRUCTION

It is suitable for application by proprietary manual or automatic corona charging guns. Make sure the spray equipment it hoses, gun parts and hoppers are clean and free from defuse powder all the contact points should be maintained to ensure metal-to-metal ground. Voltage should be kept between 20~100kV. Spray booth and collection system should maintain to ensure sufficient air velocities.



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### CURING SCHEDULE

Standard baking temperature : 10 minutes at 180°C (Metal temperature).

### COATING THICKNESS

Recommended Thickness : 60~80 µm

### STORAGE & SHELF LIFE

It is recommended to store below 25°C in dry conditions. When stored under such conditions the shelf life is not exceeding 6 months from the date of manufacture.

### PHYSICAL COATING PERFORMANCE

Direct impact (ASTM D2794) : Greater than 45 kg.cm  
Reverse impact (ASTM D2794) : Greater than 45 kg.cm  
Adhesion (DIN 53151, 2mm) : Gt = 0  
Conical mandrel bend (ASTM D522) : Less than 8 mm  
Erichsen Cuppling (DIN 53156) : Greater than 6 mm  
Pencil Hardness (ASTM D3363) : 2H

### ENVIRONMENTAL PROPERTIES

It is essential for long term durability to ensure that the substrate is given the correct pretreatment. Aluminium requires a chromate conversion coating and steel surfaces must be zinc phosphated. The powder should be applied as soon as possible after pretreatment. Specialist advice should be sought from pretreatment suppliers.



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### SALT SPRAY RESISTANCE

According to ASTM B117-73 on-  
Zinc phosphated steel : 5 mm undercutting after 1000 hours exposure.  
Chromated aluminium : No change after 2000 hours.

### HUMIDITY RESISTANCE

According to DIN 50017: No breakdown after 1000 hours.

### SOLVENTS & CHEMICALS RESISTANCE

Good resistance to common acids, alkalis and solvents at room temperature. It may be attacked by nitric acid, ketones and trichloroethylene. Refer to the information sheet "Chemical Resistance of Powder".

### HEALTHY & SAFETY

Avoid skin and eyes contact by wearing suitable overalls, gloves, goggles, etc. Spillage on the skin should immediately be removed by thorough washing with water and soap. Eyes should be well flushed with water and medical attention sought immediately.

### DISCLAIMER

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