



PRODUCT DATA SHEET

KOSKOTE 4020 PE-SERIES

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(Hammerstone Finish Outdoor Durable Polyester Powder Coating)

DESCRIPTION

KOSKOTE 4020 PE-Series specialty powder coating is a Polyester-TGIC powder coating formulated to give a hammerstone finish with exceptional outdoor durability. It is specially formulated on selected resins and pigments to give many years of service in various applications.

PHYSICAL PROPERTIES

Appearance	: Free flowing fine powder
Specific gravity	: 1.40 – 1.70 g/cm ³ (depending on color)
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 hoses, gun parts and hoppers are clean and free from dust 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 200°C (Metal temperature).

COATING THICKNESS

Recommended Thickness : 60~120 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 – 3H

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.



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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

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factor affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product data without notice.