

Fluoraset FP

Page 1 of 4

Ultra Durable Fluoropolymer Powder Coating

Product Code: 964 Line

Specification met: Meets and/or exceeds requirements of AS3715, BS6496, AAMA2605-05.

Description

Fluoraset FP is a fluoropolymer powder coating designed specifically for architectural applications where colour and gloss retention are critical for prestigious architectural projects. **Fluoraset FP** is formulated with advanced fluoropolymer resin technology and high performance pigments to conform with the performance requirements of AAMA2605-05 (Newly released AAMA specification Superior Performing Organic Coatings). **Fluoraset FP** will give increased gloss and colour retention over high and super durable polyesters, and matches fluoropolymer liquid systems with the advantage of very good mar resistance.

Features

Benefits

20 year film integrity	Guaranteed performance on correctly pre-treated aluminium
15-20 year colour warranty	Superior colour retention
No primer required	Reduced application costs versus equivalent liquid coatings
Very good flow out	Smooth film appearance
Reduced solvents/emissions	Less waste and pollution to the environment
Tough powder coating	Hard wearing/serviceable finish

Uses

Fluoraset FP has been developed for use on extruded architectural aluminium, including window and door frames, and extruded panel work on commercial buildings.

Performance Guide

Weather	10 Years Florida (AAMA 2605-05) Chalking: No. 8 (colours), No. 6 (whites) Colour Change: $\Delta E < 5$ Gloss Retention: > 50%	Salt Spray	Excellent salt spray resistance over pre-treated aluminium. (4000 hours ASTM B117)
Heat	Excellent resistance to 90°C continuous service conditions.	Humidity	Excellent resistance to 38°C/100% humidity for 4000 hours on pre-treated aluminium.
Acid	Resistant to spills of dilute acid. Avoid contact.	Abrasion	Excellent resistance to abrasion. Abrasion Coefficient > 40 (ASTM D968)
Alkali	Resistant to spills of dilute alkali. Avoid contact.	Pencil Hardness	H - 2H
		Knoops Hardness	Min 18
Flexibility	Limited < 30 inch/lb	Cross Hatch Adhesion	No removal

Fluoraset FP

Page 2 of 4

Chemical Resistance

Mortar	Resistant	White Spirits	Resistant
Ethanol	Resistant	Xylene	Slight softening
Methyl Ethyl Ketone	Slight softening	Ethyl Acetate	Slight softening
Muriatic Acid	Resistant (Spot test)		

Product Guide

Colour	A range of made to order solid colours. Some strong/dark colours may not be possible.	Specific gravity	1.3 - 1.7 @ colour
Gloss Level	45 – 60% at 60°, as required	Shelf life	12 months when stored below 25°C/dry conditions. Cold storage recommended.

Application Data

Application Method	Electrostatic spray.		
Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.		
Cure Schedule	Metal Temperature (°C)	Time (minutes)	
	210	15	
	200	20	
	190	25	
Cured Film Thickness	Recommended:	50 μ m	
	Range:	40 – 80 μ m	

Note: Light colours may require a higher minimum film build for optimum coverage and colour consistency.

Theoretical spreading rate at recommended film thickness

A coverage rate of 12m²/kg corresponds to 50 μ m cured film thickness assuming no loss. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.

Application Guide

Surface Preparation

Surfaces should be prepared according to AAMA2605-05 (available from Standards Australia and Standards New Zealand offices). Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes:

Aluminium Chrome/Chromate (refer AS3715 and/or BS6496)

Application Procedure and Equipment

Applied by DGL Powder Coatings **Fluoraset FP** Registered Applicators with equipment and control systems to enable correct metal pre-treatment and control of the application and stoving as set out in the **Fluoraset FP** Applicators Manual.

- 1a) For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble “simmering liquid”. Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly.
- 1b) For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer’s recommendations.
2. Apply by electrostatic spray.



Fluoraset FP

3. Cure as per recommendations outlined above.
Care should be exercised when stoving at 220°C or above as some colours are prone to discolouration.
4. Test for cure of the coating with Methyl Ethyl Ketone (available from DGL Camel Powder Coatings) 50 double rubs. Slight surface softening may occur, and little to no colour transfer should occur. (Test Method available from DGL Camel Powder Coatings)

Care and Maintenance

Reference should be made to AAMA610.1:1979 standard for cleaning of surfaces. This is a condition of the warranty. In broad terms, cleaning of externally located powder coating surfaces must take place every three 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 and will render the warranty void if used. 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

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. 14172201) available through Sales and Customer Service Offices.

Phone: PRC 86 769 8755 8778



Fluoraset FP

Precautions and Limitations

- For use by **Fluoraset FP** Registered Applicators only, who can demonstrate ability to consistently meet and measure criteria according to AS3715, BS6496, AAMA2605-05, and **Fluoraset FP** Applicators Manual.
- **Fluoraset FP** is only available in solid colours which meet DGL Camel Powder Coatings pigmentation criteria. Strong, bold colours may not necessarily meet these criteria and should be referred to DGL Camel Powder Coatings before specifying.
- As a result of possible wide application variations and stoving conditions, some products and colours may show variation between DGL Camel 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.
- Not recommended for post forming or where punching is likely to cause depression and/or deformation of the metal profile.
- Whilst technically capable, it is not recommended for re-coating unless it is absolutely essential. This product is not designed for re-coating and special care must be taken to ensure good adhesion and uniform appearance.
- For optimum performance ensure recommended dry film thickness is obtained.
- Not recommended for use in highly corrosive environments such as severe marine or industrial locations.
- Not recommended for components which are exposed to constant temperatures exceeding 90°C.
- Do not exceed 220°C, metal temperature when stoving **Fluoraset FP**.
- This product can release an irritating white fume on baking, which is particularly noticeable if there is inadequate ventilation. Ensure adequate ventilation/extraction is available when baking this product to minimise fuming.

Transport and Storage

Sizes:	20 kg	Flashpoint:	N/A
Weight:	20 kg	UN:	N/A
Dangerous Goods Class:	N/A	Package Group:	N/A
Shipment Name:	Not dangerous goods.		
DGL Camel Powder Coating (Dong Guan) Ltd	Dulux Powder Coatings	DGL Powder Coatings	
Yan Tian District, Feng Gang	51 Winterton Road	31B Hillside Road	
Dong Guan, Guang Dong 523701	Clayton, Victoria, 3168	Glenfield, Auckland	
PRC	Australia	New Zealand	
Telephone: 86 769 8755 8778	61 3 9542 4500	64 9 441 8244	
Fax: 86 769 8756 9339	61 3 9542 4542	64 9 441 8242	

TM Fluoraset, The words DGL International and the Squares Device are trade marks

DISCLAIMER: Any advice, recommendation, information, assistance or service provided by DGL Powder Coatings in relation to goods manufactured by it or their use and application is given in good faith and is believed by DGL Powder Coatings to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by DGL Powder Coatings provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon DGL Powder Coatings by any condition or warranty implied by applicable legislation, regulation or other Government ordinance voiding or prohibiting such exclusion, limitation or modification