

Fluoroset[®] FP

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| A Super durable warranted Fluoropolymer Powder Coating | | | |
| Product Code: | | 964 Line | |
| Specification met: | | Meets and/or exceeds requirements of AAMA2605 | |
| Description | | | |
| <p>Fluoroset[®] FP is a range of Fluoropolymer powder coatings designed specifically for architectural applications where colour and gloss retention are critical for prestigious architectural projects. Fluoroset[®] FP is formulated with advanced Fluoropolymer (Lumiflon[®]) resin technology and utilising high performance pigments to conform with the performance requirements of AAMA2605-98 (New AAMA specification released for Superior Performing Organic Coatings) . Fluoroset[®] FP will give increased gloss and colour retention over high durability polyesters and matches Fluoropolymer liquid systems whilst deriving increased mar resistance by virtue of its thermosetting chemistry.</p> | | | |
| Features | | Benefits | |
| 30 year film integrity | | Warranted performance on correctly pre-treated aluminium when applied by a Dulux Registered Applicator | |
| 25 Year gloss retention warranty | | Long intact life of coating on correctly pre-treated aluminium when applied by a Dulux Registered Applicator | |
| 25 year colour warranty | | Very good colour retention on correctly pre-treated aluminium when applied by a Dulux Registered Applicator | |
| A 1 coat system | | Reduced application costs vs equivalent liquid coatings | |
| Registered applicators | | Quality assurance systems in place | |
| High transfer efficiency | | Increased first pass transfer | |
| Low cure | | Cost savings on Energy or increased line speeds | |
| Good flow out | | Smooth film appearance | |
| No solvents or emissions | | Less waste and pollution to the environment | |
| Tough polyester | | Hard wearing/serviceable finish | |
| Uses | | | |
| <p>Fluoroset[®] FP Powder Coating has been developed for use on extruded architectural aluminium, including window and door frames and panel cladding on commercial and prestigious buildings.</p> | | | |
| Performance Guide | | | |
| Weather | AAMA 2605-98. (10 years) Chalking No. 8 for colours, No. 6 for whites Colour Change $\Delta E < 5$ Gloss retention $> 50\%$. | Salt Spray | Excellent salt spray resistance over pretreated aluminium. Pass 4000 hrs |
| Heat | Excellent resistance to 90°C continuous service conditions. | Humidity | Excellent resistance to 35°C/100% humidity for 4000 hours on pre-treated aluminium. |
| Acid | Muriatic Acid - unaffected Nitric Acid - Pass $\Delta E < 5$. | Abrasion | Pass abrasion co-efficient > 40 |
| Alkali | Resistant to spills of dilute alkali. Avoid contact. | Pencil Hardness | Min H – 2F |
| Flexibility | Pass - no tape removal of film | Cross Hatch Adhesion | Dry – Pass, Wet - Pass Boiling Water - Pass |

Fluoraset® FP

| Chemical Resistance | | | |
|----------------------------|--------------------------------------|----------------------|--------------------------------|
| Mortar | Resistant Resistant (24 hr Pat Test) | White Spirits | Resistant |
| Ethanol | Resistant | Xylene | Slight softening/limit contact |
| Methyl Ethyl Ketone | Softens/avoid contact | Ethyl Acetate | Softens/avoid contact |

| Product Guide | | | |
|----------------------|--|-------------------------|---|
| Colour | A limited range of made to order solid and pearl colours | Specific gravity | 1.3 - 1.7 @ colour |
| Gloss Level | 25 - 98% at 60° as required | Shelf life | 6 months when stored below 25°C @ 50 - 60% r / humidity |
| Toxicity | Refer CDS (No 14142201) | | |

| 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 | >18 | |
| | 200 | >25 | |
| Cured Film Thickness | Recommended: | 40 µm | |
| | Range: | 30 – 80 µm | |

Theoretical spreading rate at recommended film thickness

A coverage rate of 12 - 14m²/kg is commonly experienced. 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 AS1627.6-2003 Section 3 to achieve a conversion coating corresponding to Class 1. Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes: | | | |
| Aluminium | Chrome/Chromate | (refer AS1627.6-2003) | |

| Application Procedure and Equipment | |
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| Applied by Dulux Powder Coatings Fluoraset® FP I 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. |
| 3. | Cure as per recommendations outlined above. |
| | Care should be exercised when stoving at 210°C or above as some colours are prone to discolouration. |
| 4. | Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur. |

| Care and Maintenance | |
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| 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 six 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. |

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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, 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. 3969) available through Sales and Customer Service Offices.

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| Phone: Australia:- | 13 24 99 | New Zealand:- | 09 441 8244. |
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Precautions and Limitations

- Strong, bold colours may not necessarily meet these criteria and so should be referred to Dulux Powder Coatings before specifying.
- As a result of possible wide application variations and stoving conditions, some products and colours may show a variance between Dulux 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 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.
- Dulux Powder Coatings is under no obligation to replace product or repair damages that may result from the use of this product in any way other than stated on the Product data sheet or Material safety data sheet.

Transport and Storage

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| 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. No special transport requirements. | | |

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| | Dulux Powder & Industrial Coatings | Dulux Powder & Industrial Coatings | |
| | 1-15 Pound Road West | 31B Hillside Road | |
| | Dandenong South, Victoria, 3175 | Glenfield, Auckland 0627 | |
| | Australia | New Zealand | |
| | ACN 004 117 828 | | |
| | | | |
| Telephone: | 61 3 8787 4500 | 64 9 441 8244 | |
| Fax: | 61 3 8787 4542 | 64 9 441 8242 | |

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