

COATING DATA SHEET & PROPERTIES

Hunter Douglas Limited pioneered the coil coating process in Australia back in 1950. Since then techniques and technology have been developed continuously ensuring that the HD COLOR-COTE[®] Coating Process remains abreast with internationally accepted standards.

Coil coating carried out by Hunter Douglas Limited is designed to meet all appropriate test requirements of *AS/NZS 2728 – 2007 Prefinished/prepainted sheet metal products for interior/exterior building applications – Performance requirements*.

The HD COLOR-COTE[®] Coating Process involves three stages of coating, including oven baked curing:

Pre-treatment:

Hot alkaline cleaning of the base material followed by roll-on application of a Chromate Conversion Coating. This coating inhibits corrosion and improves paint adhesion.

Primer:

Specially formulated flexible polyester primer designed for flexibility and good corrosion resistance applied at a nominal thickness of 5 microns.

Finish Coat:

The finish coat is based on polyester-melamine formaldehyde resin system designed for good exterior durability and flexibility. All the pigments used to impart colour are designed to have good exterior durability. The topcoat is applied at a nominal thickness of 20 microns.

The reverse side of the coil is coated with a similar polyester-melamine Backing coat at a nominal film thickness of 15 microns.

Application:

HD COLOR-COTE[®] Coating Process is applied in continuous coil form using urethane application rollers to control the accuracy of the paint film thickness.

The pre-treatments, primers and finish coats are oven baked at each stage after application through curing ovens at the required curing temperatures ensuring maximum performance.

Typical Properties of Coating

Properties	Specifications
Colour	Comparable to Std.
Dry Film Build:	
Top-	22 – 25 microns
Reverse-	16 – 18 microns
Gloss @ 60°	25 - 90
T-Bend Test	2T No tape off
Reverse Impact	Pass 7J
Pencil Hardness	F Minimum
Solvent Resistance	50 Double rubs minimum
Stripper Resistance	30 minutes minimum
Salt Spray Resistance	Passes 2000 hours
Humidity Resistance	Passes 2000 hours
QUV Resistance	Passes 2000 hours

Note: All testing carried out as prescribed under Australian/New Zealand Standard AS/NZS 1580 *Paints and related materials – methods of test.*
