

Paint Specification HOLO PVdF finish

Primer coat 5 µ thickness, 30 µ of colour PVdF coat 70% Kynar 500 and 10 µ of Clear Coat.

Properties	Norm	Results	Comments																
Physical Properties																			
1. Coating Thickness	EN 13523-1	(30 to 57) ± 2 µ	Colour specific																
2. Specular gloss topcoat, 60°	EN 13523-2	20 to 35 G																	
3. Pencil hardness	EN 13523-4	≥ F																	
4. Adhesion to cracking on rapid deformation	EN 13523-5	No cracks	7.5 Nm/mm																
5. Adhesion to cracking on rapid deformation after indentation	EN 13523-6	≤ GT1																	
6. T-Bend	EN 13523-7	<p>Processing within 2 months after delivery</p> <table border="1"> <tr> <td>T-Bend</td> <td></td> <td>Ri rec.</td> <td>Ro rec.</td> </tr> <tr> <td>≥ 1,5</td> <td></td> <td>≥0.75mm</td> <td>≥1.25mm</td> </tr> </table> <p>Processing later than 2 months after delivery</p> <table border="1"> <tr> <td>T-Bend</td> <td>X</td> <td>Ri rec.</td> <td>Ro rec.</td> </tr> <tr> <td>4,5</td> <td></td> <td>≥1.4mm</td> <td>≥1.9mm</td> </tr> </table>	T-Bend		Ri rec.	Ro rec.	≥ 1,5		≥0.75mm	≥1.25mm	T-Bend	X	Ri rec.	Ro rec.	4,5		≥1.4mm	≥1.9mm	<p>180°</p> <p>Ri rec: Recommended aluminium minimum inside bend radii (mm)</p> <p>Ro rec: Recommended minimum outside bend radii (mm)</p> <p>X: 3 x Normal T-bend value</p>
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7. MEK / Solvent rubbing test	EN 13523-11	≤ 100 double rubs																	
Corrosion and Chemical Resistance																			
8. Salt acid spray fog Resistance	EN 13523-8	Corrosion Index 2 according the EN 1396 table C4	After 1.000 hours testing																
9. Humidity Resistance	ASTM D-2247-68	No influence	After 1.000 hours testing																
10. QUV-B test	EN 13523-10 EN 13523-14	<p>Slight colour change allowed ΔE ≤ 1</p> <p>Gloss reduction ≤ 10 % of the original gloss</p> <p>Chalking ≤10 %</p>	After 500h hours light cycle testing																