

Fluoroset[®] FP

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	
20 year film integrity	Guaranteed performance on correctly pre-treated aluminium		
20 Year gloss retention warranty	Long intact life of coating		
20 year colour warranty	Very good colour retention		
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

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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	15	
	200	20	
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)
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Application Procedure and Equipment

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

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.

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

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.		

	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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