

## IBASHINE

# Technical Data Sheet

### Description

**IBASHINE** powder coatings are decorative looking products obtained by physically mixing metallic pigments such as aluminum, copper or mica with powder coating. **IBASHINE** powder coatings are available in all chemistry, like epoxy-polyester, polyester TGIC and TGIC-free versions.

### Characteristics

Aesthetic appearance with metallic effect  
Improved application characteristics  
Less waste and pollution to the environment

### Applications

Metal furniture  
Lighting equipment  
Electronic equipment  
Steel doors  
White goods  
Shelving systems  
Architectural applications

### Product Properties

<b>Colour</b>	A wide range of metallic colours
<b>Surface</b>	Gloss GL – Semigloss HR – Semimatt CS – Matt CM – Structure ST – Wrinkle WR
<b>Specific gravity</b>	1.3-1.8 gr/cm <sup>3</sup>
<b>Shelf Life</b>	12 months (< 30°C and < 50% RH)

### Codification

<b>B</b>	Do not resist to humidity and rubbing. A clear topcoat is required – suggest PE54DT000189GLX
<b>X</b>	Resist to humidity and smooth rubbing. A clear topcoat is not required at normal conditions. (A clear topcoat is required when exposing to harsh environments)
<b>Q</b>	Resist to humidity and rubbing. A clear topcoat is not required. It has excellent chemical, humidity and weather resistance designed specifically for architectural applications.

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## Application Data

<b>Application</b>	IBASHINE powder coatings should be applied with lower voltage by increasing gun distance. Applied with corona guns which provide 40 – 60 kilovolts negative voltage.
<b>Attention!</b>	It is not recommended for application by friction charging equipment (tribo).
<b>Curing</b>	Check for TDS for the specific series.
<b>Film Thickness</b>	For smooth surfaces 60-80 µm, for wrinkle effects 80-120µm
<b>Theoretical cons.</b>	8-10 m <sup>2</sup> /kg. Practical spreading rates will vary due to such factors as method and conditions of application, specific gravity, surface profile and texture.

## Application Guide

### Surface Preparation

All surfaces should be degreased and pre-treated for optimal performance.

Suitable pre-treatment includes:

Aluminium	Yellow chromate or green chromate/phosphate
Ferrous metals	Zinc phosphate or Iron phosphate
Zinc Coated Metals	Zinc phosphate or chromate

### Application Procedure and Equipment

IBASHINE powder coatings charging properties are optimized when powder is free-flowing and moisture-free. Aged or compacted powder may require preconditioning for several minutes to fluidise evenly.

If storage room temperature is lower than the application area, powder coatings, which are hygroscopic, should be acclimated in unopened containers prior to adding into the spray hopper. For optimum performance, It should be applied and stored at air-conditioning area. Storage temperatures should be kept below 30 °C.

Powder should not be stored in hoppers for long periods of time. If moisture condensation occurs, fluidize powder to dry-out or replace moisture-laden powder with virgin powder.

Powder coatings are finely ground particulates. Respirators or dust masks should be used by workers exposed to powder in order to avoid dust inhalation.

Compressed air to the gun must be oil and moisture free.

Silicone should not be used in application area.

For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.

Contact points should be maintained to ensure metal-to-metal ground.

Apply by electrostatic spray. Relative humidity should be 50-60% for corona system, lower than 40% for tribo system.

Cure as per recommendations outlined above.

Reclaim-to-virgin ratios should be carefully monitored to maintain spray consistency.

Sieving powder before adding to hopper eliminates potential clumping or foreign matter.

Test for cure of the coating by impact test.

Read "Application Data" for second layer applications.

## Care and Maintenance

IBASHINE powder coatings should be regularly washed with warm water and mild liquid detergent, followed by a fresh water rinse to maintain the attractive appearance of the powder cured film. Use a soft cloth that does not scratch the surface. The detergent used for non-chemical resistant products should have a neutral pH. The surface should not be left with detergent for a long time and should be rinsed immediately with water.

The use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

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## Health and Safety

The SDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed. It is recommended to contact to Sales and Customer Service Offices for further information.

## Precautions and Limitations

As a result of possible wide application variations and stoving conditions, **IBASHINE** powder coatings may show variation, between İBA Kimya 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 ensures recommended dry film thickness is obtained.

**IBASHINE** powder coatings should be homogeneous before application. To ensure this, the entire box must be placed in the feeding chamber and should be fluidized for about 10 minutes at minimum level which will provide gurgitation in the chamber.

The metallic effect of the cured powder coating will vary when the same powder coating is applied through different spray equipment.

The metallic effect may change when using recycled coating. If recycled coating is used, it should be added homogeneously.

We recommend "Q+" products to meet high chemical and weather stability requirements specifically for architectural applications.

## Transport and Storage

<b>Packaging</b>	15-20 kgs. Heavy polyethylene bag in a corrugated carton
<b>Shipment</b>	Not dangerous goods. No special transport requirements.
<b>Storage Conditions</b>	Storage temperatures should be kept below 30 C° and 50% relative humidity. Powder should be stored in closed containers.

*DISCLAIMER: All the information given in this Data Sheet is the result of our research work experience. It is given in good faith and with every belief in its accuracy but cannot be considered as a formal warranty. In accordance with İBA KİMYA, policy of product development, this specification is subject to change without notice.*