Corro-Coat PE-F Series 2195

Product Description

Corro-Coat PE-F Series 2195 is an exterior durable polyester TGIC-free powder coating especially formulated to satisfy the requirements for colour stability, gloss retention and corrosion protection. Corro-Coat PE-F Series 2195 provides a uniform flow and finish even after re-cycling.

Application Areas

Primary areas of application are architectural aluminum extrusions and claddings. The overall excellent properties and attractive appearance of Corro-Coat PE-F Series 2195 make it suitable for application to other ferrous and non-ferrous substrates.

When screen printing or sealants are used, it is advised to run separate trials to ensure compatibility and to meet the required performance criteria.

Pre-treatment

The overall quality of the coating system is largely dependent on the type and quality of the pre-treatment. The recommended types of pre-treatment for the most frequently used substrates are:

Aluminum	Chromate conversion
Steel	Zinc phosphate
Zinc coated steel	Zinc phosphate or chromate conversion
Final rinse (deionized)	The last running water from the object should be tested at 20°C. The readings obtained should measure below 30µS/cm.

Curing Schedules

20 minutes at 170°C object temperature
12 minutes at 180°C object temperature
8 minutes at 200°C object temperature

Colour Selection

Corro-Coat PE-F Series 2195 is available in a wide assortment of custom-made colours and metallic finishes, including RAL and NCS.

Powder Application

Corro-Coat PE-F Series 2195 is available for Corona or Tribo charging equipment.

Product Warranty

Corro-Coat PE-F Series 2195 is backed by a 10-year product warranty system for exterior application and a 25-year product warranty system for interior application when used on architectural aluminum substrates.

Storage Conditions

Keep in a dry cool area. Maximum temperature 25°C. Maximum relative humidity 60%. (Please refer to Section 7 of the *Recommended Process and Process Control Requirements for Architectural Aluminum Alloys' Coating* in Part 2 of the *Quality and Warranty* document).

Maintenance

Please refer to *Powder Coated Façades' Maintenance* in Part 3 of the *Quality and Warranty* document.

Approvals

Please consult your local Jotun Powder Coatings' production unit.

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Technical Data

The technical data provided below are typical for Corro-Coat PE-F Series 2195 applied to 0.8mm chromated aluminum panels (65 micron film thickness). Typical values when tested have not necessarily been recently revised.

Description	Norm	Series 2195
Gloss	EN ISO 2813 (60°)	45 ± 7
Adhesion	EN ISO 2409 (2mm)	Cross-cut rating Gt0 (100% adhesion).
Impact resistance	ASTM D 2794 (5/8" ball)	More than 23 inch-pounds or 2.5Nm without film cracking.
Cupping test	EN ISO 1520	Indentation depth in excess of 5mm without film cracking.
Flexibility	EN ISO 1519	Cylindrical Mandrel bending test, passes 5mm Mandrel diameter.
Film hardness	EN ISO 2815	Indentation resistance according to Buchholz: > 80.
Mortar resistance	ASTM C 207	After 24 hours at specified conditions, mortar is easily removed from the coating resulting neither in loss of adhesion nor in surface marring.
Drilling, milling and sawing test		No flaking of coating.
Salt spray resistance	ASTM B 117	No blistering and maximum 1mm corrosion creep from scratch after 1000 hours.
Resistance to humid atmospheres containing SO_2	EN ISO 3231 (0.2 l SO_2)	No blistering and maximum 1mm corrosion creep from scratch after 30 cycles.
Resistance to humid atmospheres	DIN 50017	No blistering and maximum 1mm corrosion creep from scratch after 1000 hours.
UV resistance	ASTM G 154 (UVB-313)	Cycle: 4 hours at 50°C UV and 4 hours at 40°C condensation. No chalking, excellent gloss retention and colour stability after 300 hours testing.
Accelerated weathering test	ASTM G 154 (UVA-340)	Cycle: 8 hours at 60°C UV and 4 hours at 45°C condensation. No chalking, excellent gloss retention and colour stability after 1000 hours testing.
Natural weathering test	ASTM G 7 (South Florida, 27°N)	No chalking, excellent gloss retention and colour stability after 12 months exposure (angle of 5° to South).

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