HMG Powder Coatings Limited

Dill Road, Castlereagh Industrial Estate, Belfast, BT6 9HU
Tel. +44 (028) 9079 4930 Fax. +44 (028) 9040 1187
www.hmgpowdercoatings.com
sales@hmgpowdercoatings.co.uk

Grey Alloy Wheel Primer

617-1S070P-4536

Product Description	A silver grey coloured epoxy-polyester powder coating primer specifically designed as a basecoat for alloy wheels prior to either liquid paint or powder coating finish coats.		
Key Benefits	Excellent levelling (smoothness) Very good chemical resistance Excellent adhesion to substrate Excellent overcoatability and intercoat adhesion Sandable coating Good out-gassing properties Does not contain ecologically toxic materials such as zinc		
Powder Properties	Chemistry	A thermosetting epoxy-polyester resin system.	
	Application	Corona electrostatic spray.	
	Coating Thickness	Depending on covering power and shade, general recommendation is 60-100 microns (µm), with a minimum thickness of 60 µm.	
	Gloss (ISO 2813)	70% ± 5 on a 60 degree head	
	Specific Gravity	1.65 ± 0.1 g/cm^3	
	Theoretical Coverage	Approximately 10 m^2/kg at 60 microns film thickness.	
	Storage & Shelf Life	When stored in a cool (<20^{o}C), dry environment: 12 months.	
	Curing Schedule	10 minutes at 180 Celsius (object temperature) *see recommendations for use.	
Pretreatment	To ensure maximum adhesion the substrate must be thoroughly clean and free from grease or any other contaminant. For maximum protection it is essential to pre-treat wheels before application of the powder coating. Aluminium alloys are typically treated using a chromat837_Polyester Issue 10. Issued 25.04.2016e conversion coating, however non-chromate treatments are available. Discuss the performance requirements with the treatment chemical supplier.		
Mechanical Tests	Unless otherwise specified, all tests were carried out under laboratory conditions on 0.8mm degreased and chromated aluminium panels. A powder coating DFT of 60-70 microns was used, followed by a second coat of Alloy Wheel High Gloss Black Polyester to 60-70 microns.		
	Hardness (primer)	ISO 2815 Buchholtz Indentation	>80
	Flexibility (primer)	ISO 1519 Cylindrical Mandrel	Pass >5mm
	Adhesion (primer)	ISO 2409 2mm Crosshatch	Pass Gt0
	Cupping (primer)	ISO 1520 Erichsen	Pass >5mm
	Impact (primer)	BS 3900: Part E7	>25kg cm (N)
	Intercoat Adhesion	Hoffman Scratch Test	>1500g

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Corrosion and Durability	Neutral Salt Fog	ASTM B117 (500 hours)	Corrosion creep <2mm from scratch Adhesion – Gt0
	Boiling Water	2 hours boiling water	No defects or detachments
	Humidity	BS 3900 Part F2	More than 1000 hours without effect
Colour Availability	A light silver grey, approximately RAL 7001.		
Application Tips	Care should be taken to ensure an adequate key for the second coat; over-curing the primer or handling the surface without gloves can compromise the inter-coat adhesion. • Degrease and profile the aluminium alloy using a light blast or a suitable etch primer • Apply Alloy Wheel Primer to a coating build of at least 60 microns • Cure the primer, but do not over-bake • Apply and cure the top coat as soon as possible after applying primer. Discuss application parameters with the spray equipment supplier; generally reducing kV and µA to as low as possible will help penetration to difficult recesses. Handle only with gloves over-coating. The second coat may be applied whilst the primer is still warm. Should over-curing have occurred or where handling has been unavoidable, the primer may need to be slightly abraded.		
Restriction of Hazardous Substances (RoHS/RoHS2)	This product conforms to the Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations (RoHS and RoHS2) Directive. It does not contain any compounds of lead, mercury, cadmium or hexavalent chromium; nor does it contain polybrominated biphenyls (PBBs) or polybrominated diphenyl ether (PBDE). Please refer to our statement on RoHS, available at www.hmgpowdercoatings.com		
Health & Safety	This product is intended for use only by professional applicators in industrial environments. Consult the relevant health and safety data sheet indicated in the box label before use.		

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