



E29 EPOXY POWDER COATING

TECHNICAL DATA SHEET

INTRODUCTION

OXYPLAST E29 is an epoxy-based thermosetting powder coating formulated to give a finish with very good flow-out and gloss levels ranging from satin to very high gloss. It is used indoors as a general decorative coating.

GLOSS AND COLOUR RANGE

Gloss levels range from satin to very high gloss: 60-100% at 60°. A full colour range is available; however whites and very light shades are more sensitive to overbake yellowing.

APPLICATIONS

Include industrial machinery, indoor furniture, etc.

APPLICATION SCHEDULE

May be applied by electrostatic spraying using classic devices which can provide a negative tension of 60 - 80kV.
The powder is cured in a suitable convection or infra-red oven.
Curing:
Medium cure 10 mins at 180°C
Optimal film thickness: 60 - 80µm.

SUBSTRATES AND PRE-TREATMENT

May be applied to the following substrates after the appropriate cleaning and conversion coating:

Ferrous metals (cold-rolled steel, cast iron, etc.)	:	Iron or zinc phosphatation
Zinc surfaces (galvanised steel, zinc alloy)	:	Chromatation or zinc phosphatation
Aluminium alloys	:	Chromatation

STORAGE

At temperatures not exceeding 30°C and under dry conditions, E29 powders may be stored for up to 6 months without affecting their free-flowing properties. The coating thus obtained will still have optimal characteristics.

PROPERTIES OF THE POWDER

Melting range (Kofler)	:	66 - 90°C
Specific gravity (DIN 55990/3)	:	1.40 – 1.75 (depending on colour)
Particle size distribution, % above 100µm	:	0%
% above 32 µm	:	50 – 60%

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PROPERTIES OF THE COATING

Physical and Mechanical	The following are properties typical of E29 determined on 0.8mm gauge degreased galvanised steel:	
	Film Thickness	: 60 - 80µm
	Gloss (ASTM D523,60°)	: 60 - 100%
	Flow-out	: Very good
	Adhesion (din 53151 – 2mm spacing)	: GT = 0
	Pencil hardness (ASTM D3363-Staedtler Lumograph)	: H – 2H
	Buchholz hardness (DIN 53153)	: 91 – 111
	Sclerometre hardness	: 400 – 800gms
	Conical mandrel (ASTM D522)	: < 4mm
	Direct impact (ASTM D2794 – 0.625 in. Diameter ball)	: > 80kg.cm
	Reverse impact (ASTM D2794 – 0.625 in. Diameter ball)	: > 80kg.cm
	Erichsen cupping (DIN 53156)	: > 8mm
	Heat resistance, 30 mins at 200°C	: Yellowing
	Salt-Spray Resistance	According to ASTM B117-73 on,
Chromated aluminium, 2000 hours		: No blistering or loss of adhesion
Zinc phosphated steel, 1000 hours		: 3mm undercutting
Iron phosphated steel, 1000 hours		: 6mm undercutting
Chemical Resistance	E29 is resistant to many of the common inorganic acids, bases and salts, organic acids and certain organic solvents.	

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