



Technical Data Sheet

Alesta® E

EE80005001723

Vanguard Blue

Product Description

The Alesta® E range is an epoxy powder coating containing high performance epoxy resin. It offers excellent chemical resistance together with good mechanical properties and outstanding protection against corrosion.

Substrates

Any ferrous metals

End use: Particularly suitable for storage tanks for the water industry.

The poor UV resistance of epoxy resins means that use should be restricted to parts that are not directly exposed to sunlight.

Approvals

This powder coating complies with the European Directives "Restriction of the use of certain hazardous substances" 2011/65/EU and 2015/863/EU (RoHS).

Colours / Appearance / Properties

Blue / - / Gloss

Corona

Substrate Preparation

Either:

1. Degreasing followed by a chemical conversion to reach the required level of protection against corrosion

- Substrate to be clean and free of grease and oil. Any imperfections to be repaired.
- Substrate pretreatment Zinc phosphate or Zirconium phosphate pretreatment.

Or:

2. Gritblast to SA2.5 with a profile of 100-175microns.

- Ensure that all grit is removed before applying powder

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Powder application

- Application by electrostatic spray to cold or preheated substrate.
- Thickness Minimum film thickness of 125 microns on all surfaces, i.e. both sides of the plates.
- Coating to be holiday tested to ensure the coating is holiday free (i.e. free of pinholes)

Physical Properties

Specific Gravity	1,34
Particle Size distribution	50-65µm mean

The following performances have been obtained under the conditions described below and in laboratory. Actual product properties such as gloss, colour and finish may vary according to application conditions.

Product Performance / Film Properties

CONDITIONS	
Steel panels:	0,8 mm
Surface pretreatment	phosphated or media blasted steel
Film thickness	90 ± 10 µm (normal use range will be from 180 to 300 microns)
Curing Conditions	7 min @ 200°C (object temperature)
TESTS	SPECIFICATIONS
	N°
Gloss @ 60°	EN ISO 2813 90 ± 10
Adhesion	EN ISO 2409 GT0
Conical mandrel	EN ISO 6860 3 mm
Impact resistance	ASTM D2794 80 inch-pound

Baking Window

General curing conditions :

- Object t° / time
7 min @ 200°C

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Storage Stability

12 months @ 35°C max

Shelf life applies to materials stored in sealed plastic bags under dry and cool conditions

Application

- Do not mix this product with other powders.
- Substrate should be correctly cleaned before use.
- Spraying can be done using either manual or automatic electrostatic guns to cold or preheated substrate
- Film thickness: the required application settings will depend upon the geometry of the object being coated as well as the specified film thickness. It is the responsibility of the applicator to make the appropriate adjustments. Certain colours should be applied at higher film thickness to ensure full coverage and therefore colour homogeneity. Below this limit, colour variation may occur due to thickness variation.
- Thickness Minimum film thickness of 125 microns on all surfaces, i.e. both sides of the plates.
- Coating must be holiday tested to ensure the coating is holiday free (i.e. free of pinholes)

Comments

- Resistant to acids and alkalis (pH range 2 to 11). Also resistant to chlorinated water and various organic chemicals, details available on request.
- Recommended for use in corrosivity categories C1- C4 (as defined in ISO12944-2) if overcoated with Alesta IP or Alesta AP polyester.
- Certain chemicals or cleaning products can cause damage to the appearance of the coating. Please test a small inconspicuous area first to confirm suitability.
- Recycling of the powder: possible up to 30 % with exception of some metallic and pearlescent products
- Please contact us for specific questions.

Safety

Consult the Safety Data Sheet prior to use

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