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POWDER COATING

V-PET#4000

1. Resin Type

Polyester / Poly-urethane

Thermosetting Powder Coating

2. Properties

- Excellent physical properties
- High weather durability
- Smooth finish
- High corrosion resistance

3. Typical Applications

Fence, Traffic sign, Switchbox, Vending machine, Tractor,
Another metal goods

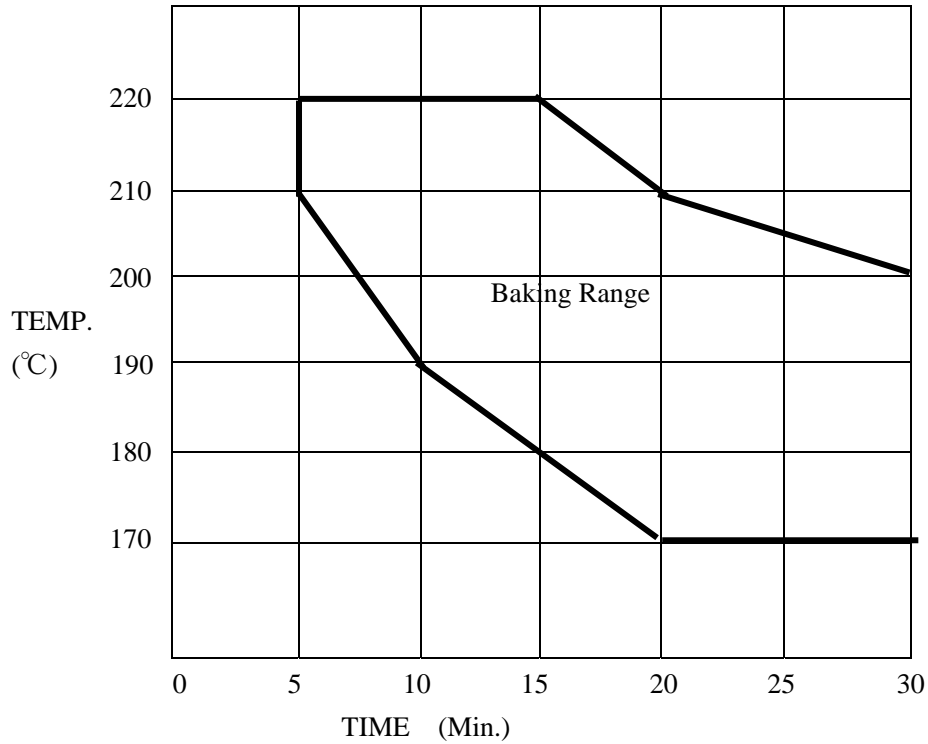
4. Contents

Resin and Hardener	• • • • •	64
Pigments	• • • • •	35
Additives	• • • • •	1

Total 100 (%)

※This table is standard formulation. (White Colored)

5. Permitted Baking Schedule



6. Powder Properties and Coating Standard

Items	Performance	Notes
Storage Stability	6month at 35°C	
Specific Gravity	1.4~1.7	Density meter
Particle Size (mean-in microns)	30~40 μ m	Laser diffraction method Particle Size Analyzer
Baking Schedule	180°C×20min	
Film Thickness	50~80 μ m	For standard Application

7. Film Properties

V-PET#4000 WHITE

Items	Test method	Result
HARDNESS	Pencil hardness(JIS K 5600 5-4)	F-H
ADHESION	1mm squares(Remaining squares/100) (JIS K 5600 5-6)	100/100
Erichsen indentation	Erichsen tester(JIS K 5600 5-2)	6mm<
Impact resistance	Du Pont(1/2"×500g)(JIS K 5600 5-3)	50cm
Accelerated Weathering	Gloss retention after 300 hours of sunshine-weather-o-meter test	Gloss retention 60% or more
Salt Spraying Test	Salt solution spray 35°C 5%NaCl 500hours (JIS K 5600 7-1)	3mm or less
Humidity Test	50°C 98%RH 500hours (JIS K 5600 7-2)	No effect
Acid Resistance	5% H ₂ SO ₄ -aq 20°C 72hours	No effect
Base Resistance	5% NaCO ₃ -aq 20°C 72hours	No effect

Bonderite 3020 (Treatment with Zinc Phosphate) panels were used for all tests and Electro statically sprayed at 60~80micro meter thickness.

8. Handling & Safety Precautions

- The area adjacent to the coating operation should be property ventilated.
- Cure ovens must be exhausted to the outside atmosphere.
- All dusts are respiratory irritants, inhalation of the dust should be avoided.
- If skin contact occurs, wash thoroughly with soap and water.
- Should eye contact occur, flush with water immediately and procure medical attention.
- To avoid static electricity build-up, property ground all equipment.
- Provide dust collection equipment with adequate explosion venting: dust clouds of any finely divided organic material can be ignited by open flame or electrical sparks.