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POWDER COATING

V-PET#5000

1. Resin Type

Epoxy/Polyester

Thermosetting Powder Coating

2. Properties

- Smooth finish
- Very slight yellowing
- high corrosion resistance

3. Coating Specification

- Substrate : Steel, Galvanized steel etc.
- Pretreatment : Zinc-phosphate
- Application : Electrostatic spraying
- Baking condition : 180°C × 20min. (Material Temp.)

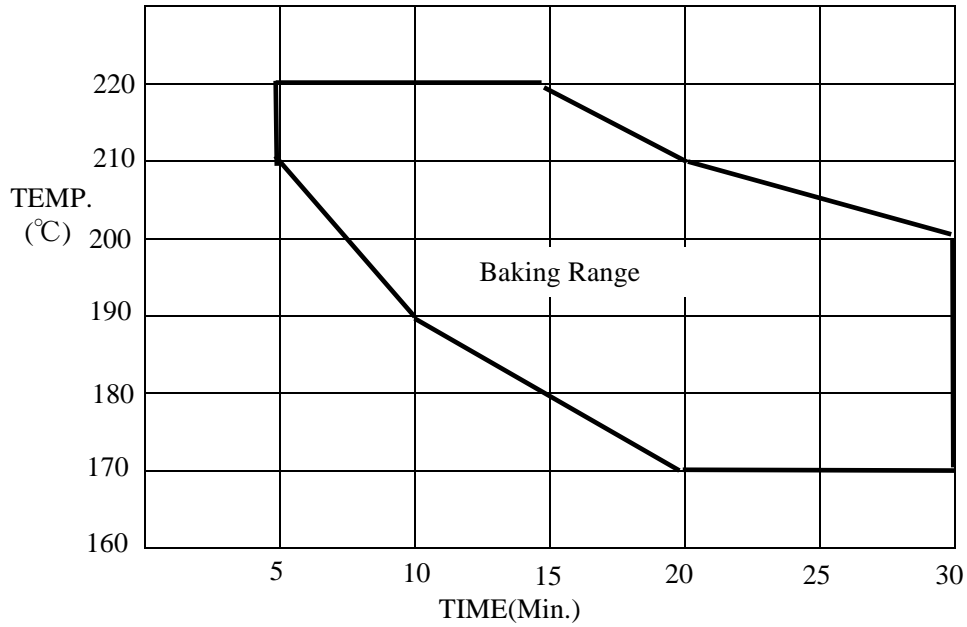
4. Composition

Resin (Epoxy/Polyester)	• • •	6 4
Pigments	• • • • •	3 5
Additives	• • • • •	1

Total 1 0 0 (%)

※This table is standard formulation. (White Colored)

5. Permitted Baking Schedule



6. Powder Properties and Coating Standard

Items	Performance	Notes
Storage Stability	6 months@35°C	
Specific Gravity	1.5~1.7	Density meter
Particle Size (mean-in microns)	30~40 μ m	Laser diffraction method Particle Size Analyzer
Baking Schedule	180°C \times 20min	
Film Thickness	50~80 μ m	For standard Application

7. Film Properties

V-PET#5000 WHITE

Items	Test method	Result
HARDNESS	Pencil hardness (JIS K 5600-5-4)	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)	30cm
Accelerated Weathering	Gloss retention after 300 hours of sunshine-weather-o-meter test	Gloss retention 30%
Salt Spraying Test	5%NaCl Salt solution spray 35°C 500hours (JIS K 5600-7-1)	2mm or less
Humidity Test	JIS K 5600-7-2 50°C 98%RH 500hours	No effect
Acid Resistance	5% H ₂ SO ₄ -aq 20°C 24hours	No effect
Alkali Resistance	5% NaOH-aq 20°C 24hours	No effect

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

8. Handring & 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.