

## Dulux Powder Coatings Fluoraset®

AU\_DP01896

<b>Product Code</b>	964 Line
<b>Approval</b>	Meets and/or exceeds requirements of AAMA2605-11.

### Description

Fluoraset® is a 100% fluoropolymer resin powder coating designed specifically for architectural applications where colour and gloss retention are critical. Fluoraset® is formulated with advanced fluoropolymer resin technology and high performance pigments to conform with the performance requirements of AAMA2605-11 (specification for Superior Performing Organic Coatings). It is supported by a 30 year durability warranty\* when applied by a Dulux Registered Applicator. Fluoraset® will give increased gloss and colour retention over high and super durable polyesters, and matches fluoropolymer liquid systems with the advantage of very good mar resistance, when compared with liquid fluoropolymer systems.

\*Subject to the terms and conditions of the relevant product warranty. Please contact your local Dulux representative for further details.

### Features And Benefits

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|---|---|
| <ul style="list-style-type: none"> <li>• 30 year durability warranty*</li> <li>• No primer required</li> <li>• Very good flow out</li> <li>• Reduced solvents/emissions</li> <li>• Tough powder coating</li> <li>• Guaranteed performance on correctly pre-treated aluminium</li> </ul> | <ul style="list-style-type: none"> <li>• Superior colour retention</li> <li>• Reduced application costs vs. equivalent liquid coatings</li> <li>• Smooth film appearance</li> <li>• Less waste and pollution to the environment</li> <li>• Hard wearing/serviceable finish</li> </ul> |
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### Uses

Fluoraset® has been developed for use in situations where class leading colour retention is desired.

### Precautions And Limitations

Fluoraset® is only available in solid and pearl colours which meet Dulux Powder Coatings pigmentation criteria. Strong, bold colours may not necessarily meet these criteria and should be referred to Dulux Powder Coatings before specifying.

- As a result of possible wide application variations and stoving conditions, some products and colours may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
- Not recommended for post forming or where punching is likely to cause depression and/or deformation of the metal profile.
- Whilst technically capable, it is not recommended for recoating unless it is absolutely essential. This product is not designed for recoating and special care must be taken to ensure good adhesion and uniform appearance.
- For optimum performance ensure recommended dry film thickness is obtained.
- For use in highly corrosive environments such as severe marine or industrial locations, aluminium sections should be coated in cut and prepunched configuration. Frequent washing is imperative in severe environments.
- Not recommended for components which are exposed to constant temperatures exceeding 90°C.
- Do not exceed 210°C, metal temperature when stoving Fluoraset®.
- This product can release an irritating white fume on baking, which is particularly noticeable if there is inadequate ventilation. Ensure adequate ventilation/extraction is available when baking this product to minimise fuming.


### Performance Guide

<b>Exterior Durability</b>	10 Yrs Florida (AAMA2605-11). Chalking: No. 8 (colours), No. 6 (whites). Colour Change Delta E<5. Gloss > 50% retention.	<b>Salt</b>	Excellent salt spray resistance over pre-treated aluminium. (4000 hours ASTM B117)
<b>Heat Resistance</b>	Excellent resistance to 90°C continuous service conditions.	<b>Water</b>	Excellent resistance to 38°C/100% humidity for 4000 hours on pre-treated aluminium.
<b>Solvent</b>	Resists alcohol and white spirits	<b>Abrasion</b>	Excellent resistance to abrasion. Abrasion Coefficient > 40 (ASTM D968)
<b>Acid</b>	Resistant to spills of dilute acid. Avoid contact.	<b>Alkali</b>	Resistant to spills of dilute alkali. Avoid contact.

Typical Properties																	
<b>Gloss Level</b>	30 60%	<b>Shelf Life</b>	At least 2 years from date of manufacture if stored at < 25 °C.														
<b>Colour</b>	A range of solid & pearl colours. Some strong colours may																
<b>Meets GBCA VOC Requirement?</b>	Yes. Dulux Powder Coatings: <ul style="list-style-type: none"> <li>▪ Contain no harmful volatile organic solvents</li> <li>▪ Free of heavy metal pigments such as lead, cadmium, arsenic &amp; mercury</li> <li>▪ Proven low temperature curing technology</li> <li>▪ Produced with stringent Safety, Health &amp; Environmental policies and standards</li> <li>▪ Developed with consideration of life cycle analysis, to guide our suppliers and the materials we use</li> <li>▪ Manufactured in facilities where significant energy and resources employed in production, are measured with aggressive reduction targets in place</li> <li>▪ Produced and used with minimal waste</li> </ul> Consequently, Dulux ® Powder Coatings are a prime consideration for projects where air quality standards have been set, such as 4, 5 & 6 Green Star Rating Projects.																
<b>Film Build (microns)</b>	Recommended 50um	<b>Clean Up</b>	Dust or vacuum loose powder. Avoid use of compressed air.														
<b>Application Method</b>	Electrostatic Spray	<b>Specific Gravity</b>	1.62 - 1.63 @colour														
<b>Flexibility</b>	Limited < 30 inch/lb	<b>Pencil Hardness</b>	H to 2H														
<b>Knoop Hardness</b>	Min 18	<b>Cross Hatch Adhesion</b>	No removal														
<b>Chemical Resistance</b>	<table border="0"> <tr><td><b>Mortar</b></td><td>Resistant</td></tr> <tr><td><b>White Spirits</b></td><td>Resistant</td></tr> <tr><td><b>Ethanol</b></td><td>Resistant</td></tr> <tr><td><b>Xylene</b></td><td>Slight Softening</td></tr> <tr><td><b>Methyl Ethyl Ketone</b></td><td>Slight Softening</td></tr> <tr><td><b>Ethyl Acetate</b></td><td>Slight Softening</td></tr> <tr><td><b>Muriatic Acid</b></td><td>Resistant (Spot test)</td></tr> </table>			<b>Mortar</b>	Resistant	<b>White Spirits</b>	Resistant	<b>Ethanol</b>	Resistant	<b>Xylene</b>	Slight Softening	<b>Methyl Ethyl Ketone</b>	Slight Softening	<b>Ethyl Acetate</b>	Slight Softening	<b>Muriatic Acid</b>	Resistant (Spot test)
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<b>Cure Schedule</b>	<b>Metal Temperature (°C)</b>	<b>Time (minutes)</b>	<b>Comments</b>														
	210	15 Mins															
	200	20 Mins															
	190	25 Mins															

Application Guide	
<b>Surface Preparation</b>	<ul style="list-style-type: none"> <li>▪ Surfaces should be prepared according to AS1627.6-2003 Section 3 to achieve a conversion coating corresponding to Class 1. Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes: Aluminium Chrome/Chromate (refer AS1627.6-2003)</li> </ul>
<b>Application Procedure And Equipment</b>	<ul style="list-style-type: none"> <li>▪ Applied by applicators with equipment and control systems to enable correct metal pre-treatment 1a) For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble "simmering liquid". Aged or compacted powder may require preconditioning for several minutes to fluidise evenly.</li> <li>1b) For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations. Box feeders are not suitable for the application of pearlescent and metallic finishes.</li> <li>2. Apply by electrostatic spray.</li> <li>3. Cure as per recommendations outlined above.</li> </ul> Metal temperatures in excess of 210°C should be avoided due to the possibility of colour change or thermal degradation of the polymer. Electrostatic spray. Note: Light colours may require a higher minimum film build for optimum coverage and colour consistency.

### Spray Application Guide

<b>Thinner</b> 	Not Applicable
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### Care And Maintenance

Reference should be made to AAMA610.1:1979 standard for cleaning of surfaces. This is a condition of the warranty. In broad terms, cleaning of externally located powder coating surfaces must take place every three months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

#### THREE STEPS TO CLEANING POWDER COATED SURFACES

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

**WARNING:** In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes and will render the warranty void if used. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Turpentine, Ethyl Alcohol, Isopropanol

### Health And Safety

<b>MSDS Number</b>	14172201, 0	<b>Health Effects</b>	The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information. For detailed information, refer to product label and the current Chemical Data Sheet (No. 14172201) available through our Sales and Customer Service Office. Phone: 13 24 99
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**In the case of emergency, please call 1800 033 111**

### Transport And Storage

<b>Package Weight</b>	20 Kg	<b>Shipment Name</b>	Not dangerous goods.No special transport requirements.
<b>Flash Point</b>	N/A	<b>UN Number</b>	N/A
<b>Dangerous Goods Class</b>	N/A	<b>Package Group</b>	N/A

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