Jotun Facade 2712

PRODUCT DESCRIPTION

This product is an exterior durable caprolactam-free powder coating designed as a base coat for sublimation or heat transfer decoration technique to meet stringent requirements of the construction industry. It provides longevity to the projects and building components by ensuring gloss retention, colour stability and corrosion protection. This product exhibits an excellent even uniform flow and an attractive finish and appearance, even after recycling. This product has weathering performance in line with AAMA 2604.

Application areas

Primary areas of application are architectural aluminium extrusions and claddings. The overall excellent properties and attractive appearance of this product make it suitable for application to other ferrous and non-ferrous substrates.

Wooden patterns are created by applying an approved film (preferably Qualideco approved) designed for architectural aluminium extrusions through a sublimation or heat transfer technique. The results are aesthetically impressive creating a limitless imitation of wood with excellent weathering resistance.

When screen printing or sealants are used, it is advised to run separate trials to ensure compatibility and to meet the required performance criteria.

POWDER PROPERTIES

Property	Standard	Result
Specific gravity	Calculated	Max. 1.4 g/cm^3

Storage

Keep in a dry cool area. Maximum temperature 25 °C. Maximum relative humidity 60 %. If stored longer than 12 months a quality test must be performed.

APPLICATION

Pretreatment

The overall quality of the coating system is largely dependent on the type and quality of the pretreatment.

The recommended types of pretreatment for the most frequently used substrates are:

Substrate	Pretreatment
Aluminium	Chromate conversion
Steel	Zinc phosphate
Zinc coated steel	Zinc phosphate or chromate conversion
Final rinse (deionized)	The last running water from the object should be tested at 20 °C. The readings obtained should measure below 30 µS/cm.

Suitable chrome-free pretreatment for aluminium is also recommended. Due to the variety of chrome-free pretreatments available today, only the approved systems from Qualicoat and GSB should be used. Detailed advice should be sought from the pretreatment supplier.

Powder application

Curing schedule	Object temperature	Time
1	190 °C	20 minutes
2	200 °C	15 minutes
3	210 °C	10 minutes

Recommended film thickness (µm): 80-100

Equipment

Suitable for Corona or Tribo charging equipment.

APPEARANCE

Colour The product is available in a wide assortment of browns and beige colours but can also be made available in custom-made colours.

Gloss EN ISO 2813 (60°) 15-25

Finish Silky smooth matt finish

If the significant surface is too small or unsuitable for the gloss to be measured with the glossmeter, the gloss should be compared visually with the reference sample (from the same viewing angle).

PERFORMANCE

The technical data provided below are typical for this product when applied as follows:
Substrate Chrome-free treated aluminium panels
Substrate thickness (mm) 0.8
Film thickness (µm) 80-100
Typical values when tested.

Property	Standard	Result
Adhesion	EN ISO 2409	Cross-cut rating Gt0 (100 % adhesion)
Impact resistance	EN ISO 6272 /ASTM D2794 (impactor diameter 15.9 mm)	More than 23 inch-pounds
Cupping test	EN ISO 1520	Indentation depth in excess of 5 mm without film cracking
Flexibility	EN ISO 1519	Cylindrical mandrel bend test, 5 mm without film cracking.
Film hardness	EN ISO 2815	Indentation resistance according to Buchholz: >80
Humidity resistance containing SO_2.	ISO 22479 Method B (0.2 I SO_2) ISO 4628-2	No infiltration exceeding 1 mm on both sides of the scratch after 24 cycles.
Humidity resistance	EN ISO 6270-2 ISO 4628-2	No infiltration exceeding 1 mm on both sides of the scratch after 1000 hours
Acetic acid salt spray resistance	ISO 9227 ISO 4628-2	After 1000 hours testing – maximum 16 mm² infiltration over a scratch length of 10 cm.

Accelerated weathering	ISO 16474-3	Cycle: 4 hours at 50 ºC UV and 4 hours at 40 ºC condensation. No chalking, excellent gloss retention and colour stability after 300 hours testing.
Xenon Arc Accelerated Weathering	ISO 16474-2 Method A	Cycle: 102 minutes dry at 38 °C and 18 minutes water spray under UV. No chalking, excellent gloss retention and colour stability after 1000 hours testing.
Natural weathering test	ISO 2810 (South Florida, 27 ºN)	No chalking, excellent gloss retention and colour stability after 12 months exposure (angle of 5º to South).

Additional information

This product may be backed by a Product Performance Guarantee when applied on extruded architectural aluminium substrate. For further advice please contact your local Jotun office.

Sustainability

Powder coating is applied in air-and-powder mix in a strictly controlled factory process using electrostatic gun and a high temperature curing oven to create film. Virtually no VOCs are released in the process compared to traditional liquid paints. Unused or oversprayed powder can be recycled with minimal wastage. In addition, all Jotun Powder Coatings' products does not contain intentionally added lead.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.