İBA KİMYA SAN. ve TİC. A.Ş.
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IBADECOR

Technical Data Sheet

Description

IBADECOR (..W) powder coatings are exterior durable polyester or polyurethane based powder coatings designed as a base coat for sublimation decoration techniques.

Characteristics

Excellent flow out
Perfect pattern appearance
Less waste and pollution to the environment

Applications

Window and door systems
Kitchen cabinets
Architectural applications

Product Properties

Seriles:	PU44, PE54, PE50, PE20, PE21, PE22
Flow out	Excellent
Surface	Gloss GL, Semigloss HR, Semimatt CS, Matt CM, Structure ST, Silk Pattern SP
Yoğunluk	1.3 – 1.8 gr/cm^3 (koyu renklerde düşük, açık renklerde yüksek)
Raf Ömrü	12 months (< 30°C and < %50 RH)

Application Data

Application	Check for TDS for the specific series.
Curing	Check for TDS for the specific series.
Film Thickness	80-100µ (recommended)*
Theoretical cons.	6-9 m^2/kg. Practical spreading rates will vary due to such factors as method and conditions of application, specific gravity, surface profile and texture.

**Apply homogeneously at 80 µm minimum (do not forget IBADECOR coatings are semi-transparent)*
After providing full cure according to serie, metal temperature, wooden patterns and marble finishes are created by applying a top coat through a sublimation decoration technique.
Be sure that there is no air between the base coating and wooden pattern paper film during vacuum process
Take out the profiles when the metal temperature is reduced between 5 - 10°C.

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Coating Properties

Check for TDS for the specific series.

Application Guide

Surface Preparation
All surfaces should be degreased and pretreated for optimal performance.
Suitable pretreatment includes:

Aluminium	Yellow chromate or green chromate/phosphate
Ferrous metals	Zinc phosphate or Iron phosphate
Zinc Coated Metals	Zinc phosphate or chromate

Application Procedure and Equipment
IBADECOR powder coatings charging properties are optimized when powder is free-flowing and moisture-free. Aged or compacted powder may require preconditioning for several minutes to fluidise evenly.
If storage room temperature is lower than the application area, powder coatings, which are hygroscopic, should be acclimated in unopened containers prior to adding into the spray hopper. For optimum performance, It should be applied and stored at air-conditioning area. Storage temperatures should be kept below 30 °C.
Powder should not be stored in hoppers for long periods of time. If moisture condensation occurs, fluidize powder to dry-out or replace moisture-laden powder with virgin powder.
Powder coatings are finely ground particulates. Respirators or dust masks should be used by workers exposed to powder in order to avoid dust inhalation.
Compressed air to the gun must be oil and moisture free.
Silicone should not be used in application area.
For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.
Contact points should be maintained to ensure metal-to-metal ground.
Apply by electrostatic spray. Relative humidity should be 50-60% for corona system, lower than 40% for tribo system.
Cure as per recommendations outlined above.
Reclaim-to-virgin ratios should be carefully monitored to maintain spray consistency.
Sieving powder before adding to hopper eliminates potential clumping or foreign matter.
After provide full cure, wooden patterns and marble finishes are created by applying a top coat through a sublimation decoration technique. For more detailed, please contact your system manufacturer's.

Care and Maintenance

IBADECOR should be regularly washed with warm water and mild liquid detergent, followed by a fresh water rinse to maintain the attractive appearance of the powder cured film. The use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

Health and Safety

The SDS of existing serie is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed. It is recommended to contact to Sales and Customer Service Offices for further information.

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Precautions and Limitations

As a result of possible wide application variations and stoving conditions, IBADECOR may show variation, between İBA Kimya 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.
For optimum performance ensures recommended dry film thickness is obtained.
Not recommended for use in highly corrosive environments.
The heat up rate of components in the curing oven may influence gloss difference.
If the base coat does not cure well, wooden pattern paper film sticks to the coating after curing.
During sublimation process in the oven, be sure to take out the profiles at the same metal temperature each time, otherwise wooden pattern may vary each time. We recommend using thermocouples with automatic system.
If the profile stays too long or at very high temperature (>205 °C) during sublimation process in the oven, wooden pattern paper film sticks to the coating after curing.

Transport and Storage

Packaging	15-20-25 kgs. Heavy polyethylene bag in a corrugated carton
Shipment	Not dangerous goods. No special transport requirements.
Storage Conditions	Storage temperatures should be kept below 30 C° and 50% relative humidity. Powder should be stored in closed containers.

DISCLAIMER: All the information provided in this data sheet depends on our knowledge and experience up to date and may be subject to revision as new technology and experience evolve. Since the conditions of application may vary depending on the substrate, physical conditions and other variables, users should conduct necessary tests to determine the conformity of the product for its intended use. We do not accept liability since the application, use and processing of the products take place beyond our control and supervision. Moreover, our liability for breach of warranty is exclusively limited to replacement of the product or refund of its price and we are not liable for incidental, indirect or consequential damages under any circumstances.