İBA KİMYA SAN. ve TİC. A.Ş.
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IBASHINE

Technical Data Sheet

Description

IBASHINE powder coatings are decorative looking products obtained by physically mixing metallic pigments such as aluminum, copper or mica with powder coating. IBASHINE powder coatings are available in all chemistry, like epoxy-polyester, polyester TGIC and TGIC-free versions.

Characteristics

Aesthetic appearance with metallic effect
Improved application characteristics
Less waste and pollution to the environment

Applications

Metal furniture
Lighting equipment
Electronic equipment
Steel doors
White goods
Shelving systems
Architectural applications

Product Properties

Colour	A wide range of metallic colours
Surface	Gloss GL – Semigloss HR – Semimatt CS – Matt CM – Structure ST – Wrinkle WR
Specific gravity	1.3-1.8 gr/cm^3
Shelf Life	12 months (< 30°C and < 50% RH)

Codification

B	Do not resist to humidity and rubbing. A clear topcoat is required – suggest PE54DT000189GLX
X	Resist to humidity and smooth rubbing. A clear topcoat is not required at normal conditions. (A clear topcoat is required when exposing to harsh environments)
Q	Resist to humidity and rubbing. A clear topcoat is not required. It has excellent chemical, humidity and weather resistance designed specifically for architectural applications.

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Application Data

Application	IBASHINE powder coatings should be applied with lower voltage by increasing gun distance. Applied with corona guns which provide 40 – 60 kilovolts negative voltage.
Attention!	It is not recommended for application by friction charging equipment (tribo).
Curing	Check for TDS for the specific series.
Film Thickness	For smooth surfaces 60-80 µm, for wrinkle effects 80-120µm

Theoretical cons. 8-10 m^2/kg. Practical spreading rates will vary due to such factors as method and conditions of application, specific gravity, surface profile and texture.

Application Guide

Surface Preparation
All surfaces should be degreased and pre-treated for optimal performance.
Suitable pre-treatment 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
IBASHINE 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.
Test for cure of the coating by impact test.
Read "Application Data" for second layer applications.

Care and Maintenance

IBASHINE powder coatings 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. Use a soft cloth that does not scratch the surface. The detergent used for non-chemical resistant products should have a neutral pH. The surface should not be left with detergent for a long time and should be rinsed immediately with water.
The use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

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Health and Safety

The SDS 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.

Precautions and Limitations

As a result of possible wide application variations and stoving conditions, IBASHINE powder coatings 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.
IBASHINE powder coatings should be homogeneous before application. To ensure this, the entire box must be placed in the feding chamber and should be fluidized for about 10 minutes at minimum level which will provide gurgitation in the chamber.
The metallic effect of the cured powder coating will vary when the same powder coating is applied through different spray equipment.
The metallic effect may change when using recycled coating. If recycled coating is used, it should be added homogeneously.
We recommend "Q+" products to meet high chemical and weather stability requirements specifically for architectural applications.

Transport and Storage

Packaging	15-20 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.