

PRODUCT: 3-LAYER FEVE

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chromium free chemical passivation
Front side coating	EN 13523	Type: FEVE
Topcoat thickness	EN 13523-1	
Front side total coating thickness	EN 13523-1	Depending on the color match
Primer thickness	EN 13523-1	
Back side total coating thickness		3 ± 1 µm* (Epoxy backcoat)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	80 ± 10
Bending	EN 13523-7	Max. 1.5 T
Impact	EN 13523-5	4B or ≤ GT1
Pencil hardness	EN 13523-4	HB - 2H
Solvent resistance to acetone	ASTM D 5402-93 (1999)	≥ 100 double rub

LONG TERM PROPERTIES, MAIN SIDE COATING	METHOD EQUIPMENT	REQUIREMENTS
ΔE	EN 13523-3	<p>ΔE value is specified depending on the color and coating type.</p> <p>According to approve sample generally:</p> <ul style="list-style-type: none"> - Light colors (solid colors) ≤ 1 - Dark colors ≤ 1 - High chroma, vivid colors and metallic colors ≤ 2,5

STACBOND® maintains the right to update and modify the contents of this data sheet at any time.

STACBOND® Quality Department



* Standard values, other values can be accepted if the finish so requires it and does not affect the product quality.