

**PRODUCT: PVdF VALID FOR TOPCOAT**

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chromium free chemical passivation
Front side coating	EN 13523	PVdF 70/30**
Topcoat thickness	EN 13523-1	20 (- 2; + 4) m* (PVdF)
Primer thickness	EN 13523-1	5 ± 1 µm* (PE)
Front side total coating thickness	EN 13523-1	25 (- 3; + 5) µm*
Back side total coating thickness		3 ± 1 µm* (Epoxy backcoat)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	30 ± 5 GU (for higher gloss one extra transparent layer is necessary on top)
Bending	EN 13523-7	Max. 1.0 T (depending on the substrate)
Impact	EN 13523-5	GT0
Pencil hardness	EN 13523-4	Minimum: F
Solvent resistance to ketone	ASTM D 5402-93 (1999)	≥ 100 double rub

LONG TERM PROPERTIES, MAIN SIDE COATING	METHOD EQUIPMENT	REQUIREMENTS
Water immersion resistance	EN 13523-9	1000 h. OK Blistering > 6F
Florida exposure		Gloss retention > 85% of original after 2 years
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"> <li>- Light colors (solid colors) ≤ 0,80</li> <li>- Dark colors ≤ 1</li> <li>- High chroma, vivid colors and metallic colors ≤ 2</li> </ul>

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.

\*\* 70% PVDF 70/30