

**PRODUCT: 3-LAYER FEVE**  
**FINISH: STB-S10 Golden pearl**

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chrome-free chemical passivation
Front side coating	EN 13523	Type: FEVE 3L
Topcoat thickness	EN 13523-1	13 ± 2 µm*
Basecoat thickness	EN 13523-1	22 ± 2 µm*
Primer thickness	EN 13523-1	5 ± 1 µm*
Front side total coating thickness	EN 13523-1	40 µm*
Back side total coating thickness		5 ± 1 µm* (chrome-free polyester)
Colour		According to aproved sample
Gloss (measured at 60° angle)	EN 13523-2	> 80%
T-bend adhesion - no removal	EN 13523-7	0 - 0,5 T without loose of adhesion
T-bend flexibility - no cracking	EN 13523-7	≤ 1 T
Impact resistance - no cracking	EN 13523-5	< 4J
Pencil hardness	EN 13523-4	Min. HB
Solvent resistance to acetone	EN 13523-11	≥ 100 double rubs

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**STACBOND®** Quality Department



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