

PRODUCT: HDPE

FINISH: STB-4F1 High gloss black

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chromiun free chemical passivation
Front side coating	EN 13523	Type: HDPE
Topcoat thickness	EN 13523-1	20 (- 2; + 4) μm^* (HDPE)
Primer thickness	EN 13523-1	5 \pm 1 μm^* (PE)
Front side total coating thickness	EN 13523-1	25 (-3; + 5) μm^*
Back side total coating thickness		3 \pm 1 μm^* (Epoxy backcoat)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	90 \pm 10 GU
Bending	EN 13523-7	Max. 1.5 T
Impact	EN 13523-5	GT0
Pencil hardness	EN 13523-4	B - F
Solvent resistance to acetone	ASTM D 5402-93 (1999)	\geq 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) \leq 0,80 - Dark colors \leq 1 - High chroma, vivid colors and metallic colors \leq 2

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.