

KARUMEL EX8816-ZR ZINCRICH PRIMER POWDER COATING

KARUMEL EX8816-ZR is a powder coating primer containing zinc with excellent corrosion resistance and adhesion. It forms hard and tough film with excellent flexibility, hardness, resistance to chemicals.

1. POWDER PROPERTIES

Property	Test Description	Results
Finish and color	Standard Color	Dark grey
Specific Gravity	AIR PYCNOMETER METHOD	1.6 ± 0.5
Theoretical Coverage	60 μ m dry film thickness	5.7 ~ 6.7 m ² /kg
Shelf Life	Below 25°C with relative humidity 65% sealed state (77°F)	Max. 12 months

2. GENERAL APPLICATION

- As a protective coating for use on heavy-duty products, marine environments application, electric appliances, pipe, building materials, etc.
- Recommended coating is a primer for complete system.
- Not recommended for exterior

3. SURFACE PRE-TREATMENT

The surface must be clean and free from rust, dust, oil, grease and other contamination.

Types of pre-treatment are recommended as follows:

Type	Pre-treatment
Steel	Zinc Phosphate Blasting(the surface to Near-White(SSPC-SP10, Swedish Standard Sa2.5, NACE No.2), profile 38~100 μ m)

4. CURE SCHEDULE

The following theoretical curing schedules are recommended to achieve the best performance properties.

Temperature	Cure time	System
180°C(356°F)	2~5 minutes	As primer for complete system
180°C(356°F)	10 minutes	EX8816-ZR alone

*The cure time may have deviations influenced by various factors.

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5. FILM PROPERTIES

The data are typical for EX8816-ZR applied to Cold Rolled Steel panels(thickness 0.7mm) pretreated with zinc Phosphate, coated with a thickness of ca. 60 μ m, and cured at 180 $^{\circ}$ C (356 $^{\circ}$ F) for 10 minutes.

Property	Test Description	Result
Adhesion	Cross-cut 100/100, 1 mm tester	100/100
Gloss	Gloss meter(60 $^{\circ}$)	60 \pm 10%
Hardness	MITSUBISHI UNI Pencil	HB-H
Impact	Dupont Impact Tester(1/2"Φ)	500g*50 cm
Bending	6 mm Mandrel at 180 $^{\circ}$	No cracking
Erichsen	Erichsen tester	Above 6 mm
Salt spray resistance	Salt spray tester, 1000hrs	Under 3 mm

6. APPLICATION DETAILS

Property	Details
Storage	12 months at 25 $^{\circ}$ C cool and dry place (Cooler temperature and lower humidity are recommended)
Packing	20 kg
Remarks	Do not mix with any other type of powder to avoid the reduction of gloss and defect of physical properties. The mixing ratio of reclaim powder with virgin powder should be less than 30% and should be well sieved prior to being mixed. Failure to comply with the recommended curing conditions may affect the adhesion of the topcoat and cause degradation of the coating properties of the system

7. Notice

- The information is believed to be accurate without any obligation to KCC Corporation.
- Refer to Material Safety Data Sheet for complete hazard and safety information.
- All data are based on laboratory testing and practical experience.
- Contact KCC sales representative for further information.

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