Powder Coat Specification

The following chart is a powder coating specification guide for mild steel and aluminium substrates. Feel free to call us today to discuss your project specific requirements.

escudo powder coating

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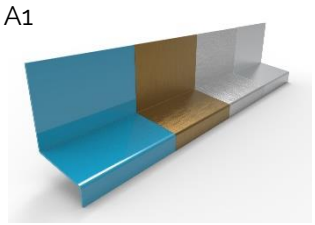
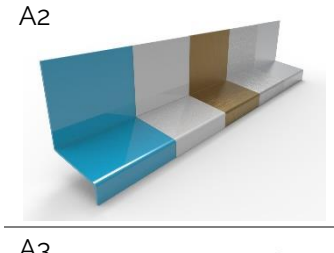
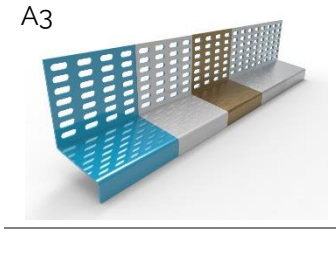
Mild Steel

Code	Metal & Coating	Use
S1 	Base Metal: **Steel** (PC) 1. Manual surface prep 2. One coat of powder baked at up to 200˚C	• Light/Medium Duty • Indoor/dry environments only
S2 	Base Metal: **Steel** (SB+PC) 1. Sand Blasting to remove rust and mill scale 2. One coat of powder baked at up to 200˚C	• Heavy Duty • Indoor/dry environments only
S3 	Base Metal: **Steel** (ZP+PC) 1. Acid bath to remove rust and mill scale 2. Zinc Electroplating (approx 15 microns) 3. One coat of powder baked at up to 200˚C	• Medium Duty • OK for outdoors or damp environments, subject to product design.
S4 	Base Metal: **Steel** (SB+ZS+PC) 1. Sand Blasting to remove rust and mill scale 2. Zincshield Powder Coat baked at 200˚C 3. Top colour coat of powder baked at up to 200˚C	• Heavy Duty. • OK for outdoors or damp environments, subject to product design.
S5 	Base Metal: **Steel** (SB+ZS+GP+PC) 1. Sand Blasting to remove rust and mill scale 2. Zincshield Powder Coat baked at 200˚C 3. Epoxy Primer Powder Coat baked at 200˚C 4. Top colour coat of powder baked at up to 200˚C	• Extra Heavy Duty. • Three coat system. • Good for harsh outdoor environments, subject to product design.
S6 	Base Metal: **Steel** (HDG+SB+GP+PC) 1. Acid bath to remove rust and mill scale 2. Hot Dip Galvanised (Approx 100 microns) 3. Whip blasted for powder coat adhesion 4. Epoxy Primer Powder Coat baked at 200˚C 5. Top colour coat of powder baked at up to 200˚C	• Extra Heavy Duty. • HDG Gives protection on inside of hollow sections. • Good for harsh outdoor environments, subject to product design.

Aluminium

Code	Metal & Coating	Use
A1 	Base Metal: **Aluminium** (PT+PC) 1. Acid etched in immersion bath 2. Chromate conversion coating 3. Top colour coat of powder baked at up to 200˚C	• Heavy Duty. • Good for exterior environments including flashings and architectural cladding.
A2 	Base Metal: **Aluminium** (PT+GP+PC) 1. Acid etched in immersion bath 2. Chromate conversion coating 3. Epoxy Primer Powder Coat baked at 200˚C 4. Top colour coat of powder baked at up to 200˚C	• Heavy Duty. • Good for exterior architectural installations. • Extra epoxy coat helps resist corrosion in coastal areas, subject to product design.
A3 	Base Metal: **Perforated Aluminium** (PT+GP+PC) 1. Acid etched in immersion bath 2. Chromate conversion coating 3. Epoxy Primer Powder Coat baked at 200˚C 4. Top colour coat of powder baked at up to 200˚C	• Heavy Duty. • Good for exterior architectural installations. • Extra coat helps prevent delamination around perforations.

Key

Suitable for Indoor/dry environments only.

OK for outdoors or damp environments, subject to product design and topcoat powder selection.

Sandblasted base metal for coating adhesion and impact resistance.

Extra corrosion resistance for coastal areas, subject to product design and maintenance. Dulux Duratec or similar for topcoat.

Edition 2 (Apr 2023)