

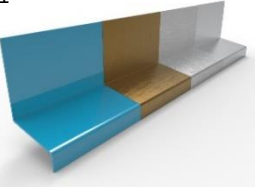





Powder Coat Specification

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.





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	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> Medium Duty Subject to product design being suitable for Zinc Plating OK for outdoors or damp environments, subject to product design. 
S4 	Base Metal: Pre-Galv Steel (PG+ZP+PC) 1. Manual surface prep 2. Zincshield Powder to welds/bare steel, baked at 200°C 3. Top colour coat of powder baked at up to 200°C	<ul style="list-style-type: none"> Medium Duty OK for outdoors or damp environments, subject to product design. 
S5 	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	<ul style="list-style-type: none"> Heavy Duty. OK for outdoors or damp environments, subject to product design. 
S6 	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	<ul style="list-style-type: none"> Extra Heavy Duty. Three coat system. Good for harsh outdoor environments, subject to product design. 
S7 	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	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> 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	<ul style="list-style-type: none"> 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.