



UV-Cured Powder Coating: Plastic

Technical Properties

Property	Test Method	Result
Gloss	ASTM D 523	3-90 GU @60°
Adhesion	ASTM D 3359, Method B	4B Minimum
Pencil Hardness	ASTM D 3363	H - 4H
Abrasion Resistance	ASTM D 4060 CS-17 wheel, 500 g, 1000 cycles	10-35 mg material loss

11/21/2019

PRODUCT OVERVIEW

UVMax® UV-cured powder coating from Keyland Polymer is durable and functional for a variety of products and applications.

UVMax® UV-cured powder for Plastic is an excellent coating for applications in the transportation, light weighting, building materials, industrial products, and other markets.

Keyland can develop a wide range of powders to match to any RAL, Pantone, or supplied color standard.

PRODUCT BENEFITS

- Zero VOCs
- Instant cure
- Highly durable and chemically resistant
- Wide range of applications
- Large pallet of colors, glosses, and textures

Further physical testing is reported/ performed as requested by the customer. Keyland Polymer has the capability to formulate coatings to meet stringent specifications specific to customer needs.

Film properties were determined by averaging test results from a variety of common polymer substrates at 1.8-2.5 mils (46-64 µm) powder film thickness.

Note: Due to the nature of many plastic materials' surface properties, surface preparation may be necessary to insure good physical properties. Contact Keyland Polymer for further information.

Application Data

Parameters	Recommendations
Application	Powder is typically sprayed using corona electrostatic spray guns. Most plastic materials require use of a conductive aid to allow for electrostatic transfer. Contact Keyland Polymer for more information.
Melt	Melt times will range from 0.5-3 minutes depending on polymer base, part size/ dimensions, oven set temperatures, and type of oven.
UV Cure	It is recommended that UV powder coatings be cured using gallium-doped lamps with a UVV dosage of 2000-4000 mJ/cm ² and UVV intensity of 1000-2000 mW/cm ² . A coating temperature of 105-140°C (221-284°F) is recommended at the time of cure.
UV LED Cure	Unpigmented and pigmented powder coatings will cure using a UV LED lamp under the correct parameters. Contact Keyland Polymer for product and process information.
Storage and Shelf Life	Dry and cool conditions below 18°C (65°F) for 6 months are recommended for storage stability. Contact Keyland Polymer to confirm the appropriate storage conditions for your product.

Disclaimer: The recommendations and suggestions herein are made without guarantee or representation of results. Actual product performance will depend on the conditions in which the product is used. We recommend adequate testing in your laboratory or plant to determine if this product meets all your finish requirements.

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