

SALTLAKE-XXX

Special surface powder coatings



Information:

1. [TECHNICAL INFORMATION](#)
2. [LOW-CURE VERSION](#)
3. [PRODUCTS AVAILABLE IN STOCK](#)
4. [TESTS CARRIED OUT](#)
5. [MARKETING MATERIAL](#)

SALLAKE

Special surface powder coatings

1. TECHNICAL INFORMATION

• TECHNICAL DATA

Chemical nature	Modified polyurethane
Finish	Special textured
Class of resistance	Class 1
Yield in surface/mass	13,1 m ² /Kg
Specific weight	1,27 ± 0,03 g/cm ³

• APPLICATION AND CURING CYCLE

Available for corona charging.

Curing time and temperature:

- 30 minutes at 190°C (metal temperature).
- 25 minutes at 195°C (metal temperature).
- 20 minutes at 200°C (metal temperature).

Recommended thickness: 120 micron.

• MECHANICAL PROPERTIES

Test	Standard Reference	Result
Buchholz	ISO 2815	ok
Cross-cut	ISO 2409	no loss of adhesion; ok
Impact 2,5 N*m	ISO 6272	ok
Bending	ISO 1519	no loss of adhesion; ok
Salt spray	ISO 9227	corrosion <4 mm; ok

SALT LAKE

Special surface powder coatings

2. LOW-CURE VERSION

For this series of powders a low-curing version is available, which allows to obtain completely the Saltlake effect at *lower temperatures and/or in a shorter time*.

The code for this variants is **Saltlake-1XXX** ("1" at the beginning of the three-digit code that identifies the color)

Curing conditios for Saltlake-1XXX:

- 30 minutes at 175°C (metal temperature).
- 25 minutes at 185°C (metal temperature).
- 20 minutes at 190°C (metal temperature).

This variant allows the following advantages:

- Energy saving;
- Possible use with every kind of oven, since the same curing conditions of standard polyester powders are required;
- Possible application on objects made of *zama* and other materials that at 200°C (curing temperature of standard Saltlake powders) could give surface defects.



Applicazioni di polveri saltlake: cassette della posta decorate rispettivamente con Saltlake-005, Saltlake -023 e Saltlake -001

SALLAKE

Special surface powder coatings

3. PRODUCTS AVAILABLE IN STOCK

• PRODUCT CODE

SALLAKE-001	SALLAKE-002	SALLAKE-003	SALLAKE-004
SALLAKE-005	SALLAKE-006	SALLAKE-007	SALLAKE-008
SALLAKE-009	SALLAKE-010	SALLAKE-011	SALLAKE-012
SALLAKE-013	SALLAKE-014	SALLAKE-015	SALLAKE-016
SALLAKE-017	SALLAKE-018	SALLAKE-019	SALLAKE-020
SALLAKE-021	SALLAKE-022	SALLAKE-023	SALLAKE-024
SALLAKE-026			

• PACKAGING



Cardboard packaging; net weight 20 Kg – Lower weight miniboxes are available

SALTLAKE

Special surface powder coatings

4. TESTS CARRIED OUT

Tests have been performed to determine under which conditions the Saltlake effect is regularly obtained.

• TEMPERATURE GRADIENT

The temperature gradient is a relevant factor for the powder coating in terms of the resulting aspect. Several gradients have been tested on this series of powders to determine which is the limit of increase to obtain a correct Saltlake effect.

The temperature was controlled with thermal probe (metal temperature).

Gradient limit: **1,76 °C/s - 105,6 °C/min.**

Higher increases, i.e. high temperatures reached faster than this, may result in an inhomogeneous effect.



Saltlake-001 cured with a gradient of 105,6 °C/min.

The surface is slightly less “wrinkled”, but the effect is homogeneous and has formed correctly

Very low gradients have been tested as well (down to 0,07°C/s – 3,97°C/min), but no problem has been observed in terms of the final aspect.

.

• TEMPERATURE FOR THE FORMATION OF THE SALTLAKE EFFECT

The Saltlake effect has been observed *during* its formation: temperatures and times required have been registered.

Temperature of formation: **175°-185°C (347°F -365°F).**

Time required: **60 seconds.**

The temperature was checked with thermal probe (metal temperature); the cross-linking has been carried out with a standard gradient of temperature.

The formation of the effect could be inhomogeneous or just partial if 185°C temperature is not exceeded.

SALT LAKE

Special surface powder coatings

- **THICKNESS**

To obtain the correct formation of the saltlake effect on the surface to be coated it is necessary a thickness of powder equal to about 120 μm . After curing, the thickness measured will result equal or *higher* than 120 μm , due to the characteristic wrinkled surface that has formed.

Because of the special textured surface, it is recommended to determine the thickness on the average value of *at least 8 measurements* on the reference area.



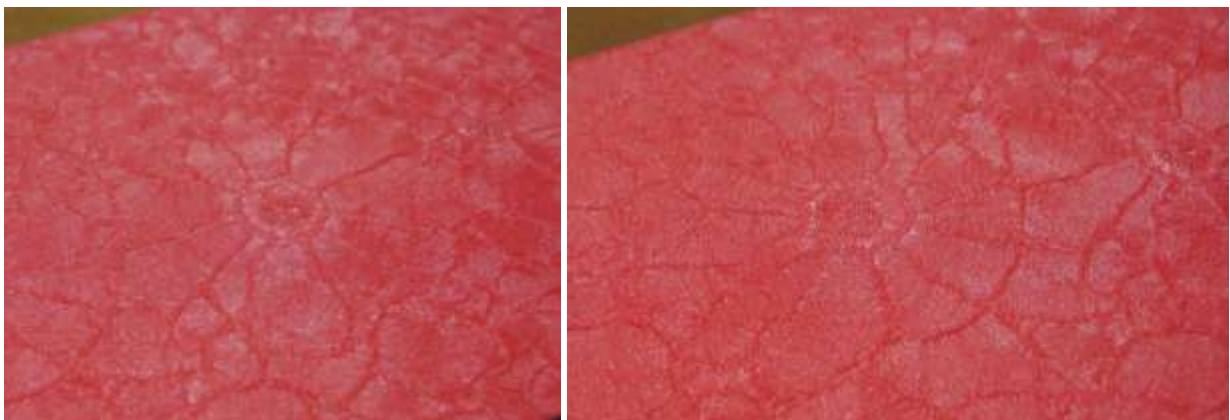
Thickness measured: **130 μm**
Correct formation of the saltlake effect.

Thickness measured: **100 μm**
Incomplete formation of the saltlake effect.

Thickness measured: **70 μm**
No saltlake effect.

- **DEFECTS**

If the surface to be coated is not well clean, or if the object has not been completely degassed (for materials that require this kind of treatment), after curing we may observe defects like those shown in the picture below, that look like small craters, with a “star” pattern around it. They form where the stains were.



SALT LAKE

Special surface powder coatings

5. MARKETING MATERIAL



A3 catalogue with aluminum samples

With each 20 kg product order will be delivered a copy **FOR FREE** of the **A3 catalogue with aluminum samples**.

On demand, it is possible to **customize the marketing material**.

GICOLOR SRL

Sede legale: Viale del Lavoro, 5 - 37040 Arcole (VR)

Sede operativa: Via Tagliamento, 4 - 36056 Belvedere di Tezze sul Brenta (VI)

Tel. +39 0424 560208 - Fax +39 0424 564601

