

Novinox XCA02 in Polyester Melamine primer – Coil Coating

Guiding formulation/REF 102026ML1
DYNAPOL LH820 / CYMEL 303

ION EXCHANGED
SILICAS

Dry film thickness: **6µm**
Application over **HDG** using a threaded bar
Salt spray resistance **1000hrs** with a PE-Melamine top coat **20µm**
according to the ASTM B-117

RAW-MATERIALS	% WEIGHT	DESCRIPTION	SUPPLIERS
<i>Mix in the following order</i>			
CYMEL 303	5.4	HMMM	ALLNEX
DYNAPOL LH 820	40.1	Polyester resin	EVONIK
SOLVESSO 150	13.6	Aromatic hydrocarbon Solvent	EXXON CHEMICAL
DOWANOL PMA	19.5	Glycol ester, solvent	DOW
COATOSIL MP200	0.5	Silane, adhesion promoter	MOMENTIVE
<i>mix until homogeneous preparation</i>			
NOVINOX XCA02	7.0	Anticorrosive pigment	SNCZ
TiO ₂ RTC90	6.5	Titanium dioxide rutile	VENATOR
TALC HAR T84	6.5	Filler	IMERYS
AEROSIL R972	0.4	Fumed silica	EVONIK
<i>grind 40 min. till 5.5 on a Hegman gauge</i>			
NACURE 2500	0.5	Catalyst	KING INDUSTRIES
TOTAL WEIGHT	100		

Properties:

PVC % :	23.8
Solids % :	48.2
Volumic solids % :	34.9
Pigment/Binder ratio (vol.)	0.31



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15/04/2020
GF_137 v0.02



Novinox XCA02 in PE Melamine primer – Coil Coating

Guiding formulation/REF 015108ML1
DESMOPHEN 1665 / CYMEL 303

Dry film thickness: **7µm + 20 µm**
Application over **HDG** using a threaded bar
Salt spray resistance **750hrs** according to the ASTM B-117

RAW-MATERIALS	% WEIGHT	DESCRIPTION	SUPPLIERS
<i>Mix in the following order</i>			
CYMEL 303	5.4	HMMM	ALLNEX
DESMOPHEN 1665	47.6	Polyester resin	COVESTRO
SOLVESSO 150	10.7	Solvent	EXXON CHEMICAL
DOWANOL PMA	15.4	Glycol ester, solvent	DOW
<i>mix until homogeneous preparation</i>			
NOVINOX XCA02	7.0	Anticorrosive pigment	SNCZ
TiO ₂ RTC90	6.5	Titanium dioxide rutile	VENATOR
TALC HAR T84	6.5	Filler	IMERYS
AEROSIL R972	0.4	Fumed silica	EVONIK
<i>grind 40 min. till 5.5 on a Hegman gauge</i>			
NACURE 2500	0.5	Catalyst	KING INDUSTRIES
TOTAL WEIGHT	100		

Properties :

PVC % :	19.42
Solids % :	56.76
Volumic solids % :	44.13
Pigment/Binder ratio (vol.)	0.24



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15/04/2020
GF_115 v1.01



Novinox XCA02 in PU primer – Coil Coating

Guiding formulation/REF 021099ML2
DESMOPHEN 1665 / DESMODUR BL3175

ION EXCHANGED
SILICA

Dry film thickness: **7µm + 20 µm**
Application over **HDG** using a threaded bar
Salt spray resistance **750hrs** according to the ASTM B-117

RAW-MATERIALS	% WEIGHT	DESCRIPTION	SUPPLIERS
<i>Mix in the following order</i>			
DESMOPHEN 1665	38.7	Polyester resin	COVESTRO
SOLVESSO 150	11.8	Solvent	EXXON CHEMICAL
DOWANOL PMA	11.9	Glycol ester, solvent	DOW
<i>mix until homogeneous preparation</i>			
NOVINOX XCA02	7.0	Anticorrosive pigment	SNCZ
TiO ₂ RTC90	7.4	Titanium dioxide rutile	VENATOR
TALC HART84	7.4	Filler	IMERYS
AEROSIL R972	1.0	Fumed silica	EVONIK
<i>grind till 8 on a Hegman gauge</i>			
DESMODUR BL 3175	14.3	Blocked polyisocyanate	COVESTRO
DBTL	0.5	Catalyst	
TOTAL WEIGHT	100		

Properties:

PVC % :	21.84
Solids % :	58.84
Volumic solids % :	44.86
Pigment/Binder ratio (vol.)	0.28



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