

# Instructions for use

**Technoform Coating Prime**

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### 1. Product purpose

Due to the low electrical conductivity of polyamide, the adhesion of the coating powder is lower than that observed on aluminium, resulting in visual differences in the finish of aluminium and polyamide.

Technoform Coating Prime is a particle deposition of different aluminium-based powders, which acts as a surface preparation treatment for coating, like a solid primer. The aim of Coating Prime is to improve the surface characteristics of the polyamide in the coating process, thus achieving an optimal coating.

TECHNOFORM ensures that Coating Prime maintains the thermal conductivity of the polyamide without affecting the coating process.

### 2. Constraints regarding the geometry of application

The geometry of the polyamide limits and influences the use of Coating Prime. It can be applied to the outer perimeter of the strip, excluding the inside regions of the fins. Coating Prime has been proven to be effective on a surface width of more than 6 mm. The effectiveness of Coating Prime also needs to be tested by our company and the customer.

### 3. Conditions of usage and storage

Do not store Coating Prime products outdoor, under the influence of moisture, environmental temperature, and dust.

It is recommended to keep profiles with Coating Prime stored in:

- Areas not exposed to the weather.
- Areas away from sources of humidity.
- Areas away from heat sources.
- Areas away from dust in suspension

### 4. Limitations of usage in other production processes

Coating Prime product is suitable for single use in polyester based electrostatic powder coating processes on aluminium profiles with thermal break. The optimum curing temperature range is between 180 and 200°C. It is recommended not to exceed an exposure time of 20 minutes.

For a good coating of the strip, it is recommended to spray the paint frontally onto the main or exposed side of the aluminium profile with thermal break. During the pre-treatment process, the coverage of Coating Prime is reduced, without losing its properties, following Qualicoat standard in terms of etching (2g/m<sup>2</sup>). For the drying process, a temperature between 80 and 100°C is recommended.

The first time it is intended to use Coating Prime, in order to maximize the performance of the solution, a visit to the customer facilities by Technoform specialists is required to quantify the characteristics of the coating process.

Behaviour of Coating Prime in any other process or under other conditions has not been evaluated and therefore there is no guarantee of proper behaviour.

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### 5. Specific security considerations

The use of gloves is recommended. Prevent formations of dust. Keep the working area clean.

### 6. Main Features

Purpose	Optimise the electrostatic application of polyester-based powder coatings on polyamide profiles. It improves powder deposition and mitigates blistering..
Colour	Grey or light grey surface. A variation in shade may be observed which does not influence the correct functioning of the treatment. Banding may also be observed.
Material	PA 66 GF25, dry impact resistant and LLPA 66 GF25, dry impact resistant, with powder based on aluminium sprayed in solid-state
Width and minimum surface	6 mm. Pre-tests and approval phases may be necessary.
Suitable processed	Coating and anodizing processes for windows, doors and facades.
Work temperature range	180-200 °C (20 min) for curing. 80-100°C for drying
Handling	Handle with gloves.
Storage	Indoors in protected areas, free from dust and moisture. The material must be kept away from any source of ignition, moisture or incompatible substances

**In case of specific questions, we gladly offer our individual support.**