



Jotun Powder Coatings

Corro-Coat PE-F Series 2191

Product Description

Corro-Coat PE-F Series 2191 is an exterior durable matt soft textured finish polyester TGIC-free powder coating especially formulated to satisfy the requirements for colour stability, gloss retention and corrosion protection. Corro-Coat PE-F Series 2191 provides a uniform flow and finish even after re-cycling.

Application Areas

Primary areas of application are architectural aluminum extrusions and claddings. The overall excellent properties and attractive appearance of Corro-Coat PE-F Series 2191 make it suitable for application to other ferrous and non-ferrous substrates.

When screen printing or sealants are used, it is advised to run separate trials to ensure compatibility and to meet the required performance criteria.

Pre-treatment

The overall quality of the coating system is largely dependent on the type and quality of the pre-treatment. The recommended types of pre-treatment for the most frequently used substrates are:

| | |
|-------------------------|---|
| Aluminum | Chromate conversion |
| Steel | Zinc phosphate |
| Zinc coated steel | Zinc phosphate or chromate conversion |
| Final rinse (deionized) | The last running water from the object should be tested at 20°C. The readings obtained should measure below 30µS/cm. |

Curing Schedules

20 minutes at 170°C object temperature
12 minutes at 180°C object temperature
8 minutes at 200°C object temperature

Colour Selection

Corro-Coat PE-F Series 2191 is available in a wide assortment of custom-made colours and metallic finishes, including RAL and NCS.

Powder Application

Corro-Coat PE-F Series 2191 is available for Corona or Tribo charging equipment

Product Warranty

Corro-Coat PE-F Series 2191 is backed by a 10-year product warranty system for exterior application and a 25-year product warranty system for interior application when used on architectural aluminum substrates.

Storage Conditions

Keep in a dry cool area. Maximum temperature 25°C. Maximum relative humidity 60%. (Please refer to Section 7 of the "Recommended Process and Process Control Requirements for Architectural Aluminum Alloys' Coating" in Part 2 of the "Quality and Warranty" document).

Maintenance

Please refer to "Powder Coated Façades' Maintenance" in Part 3 of the "Quality and Warranty" document.

Approvals

Please consult your local Jotun Powder Coatings' production unit.



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Technical Data

The technical data provided below are typical for Corro-Coat PE-F Series 2191 applied to 0.8mm chromated aluminum panels (65 micron film thickness). Typical values when tested have not necessarily been recently revised.

| Description | Norm | Series 2191 |
|--|--------------------------------------|---|
| Gloss | EN ISO 2813 (60°) | 12 ± 5 |
| Adhesion | EN ISO 2409 (2mm) | Cross-cut rating Gt0 (100% adhesion). |
| Impact resistance | ASTM D 2794 (5/8" ball) | More than 23 inch-pounds or 2.5 Nm without film cracking. |
| Cupping test | EN ISO 1520 | Indentation depth in excess of 5mm without film cracking |
| Flexibility | EN ISO 1519 | Cylindrical Mandrel bending test, passes 5mm Mandrel diameter. |
| Film hardness | EN ISO 2815 | Indentation resistance according to Buchholz: >80. |
| Mortar resistance | ASTM C 207 | After 24 hours at specified conditions, mortar is easily removed from the coating resulting neither in loss of adhesion nor in surface marring. |
| Drilling, milling and sawing test | | No flaking of coating. |
| Salt spray resistance | ASTM B 117 | No blistering and maximum 1mm corrosion creep from scratch after 1000 hours. |
| Resistance to humid atmospheres containing SO ₂ | EN ISO 3231 (0.2 I SO ₂) | No blistering and maximum 1mm corrosion creep from scratch after 30 cycles. |
| Resistance to humid atmospheres | EN ISO 6270-2 | No blistering and maximum 1mm corrosion creep from scratch after 1000 hours. |
| UV resistance | ASTM G 154 (UVB-313) | Cycle: 4 hours at 50°C UV and 4 hours at 40°C condensation. No chalking, excellent gloss retention and colour stability after 300 hours testing. |
| Accelerated weathering test | ASTM G 154 (UVA-340) | Cycle: 8 hours at 60°C UV and 4 hours at 45°C condensation. No chalking, excellent gloss retention and colour stability after 1000 hours testing. |
| Natural weathering test | ASTM G 7 (South Florida, 27°N) | No chalking, excellent gloss retention and colour stability after 12 months exposure (angle of 5° to South). |

Note: The information on this Product Data Sheet is given to the best of the manufacturer's knowledge, based on laboratory testing and practical experience. However, as the product is often used under conditions beyond the manufacturer's control, only the quality of the product itself can be guaranteed. Jotun Powder Coatings reserves the right without notice to alter or change the content of this Product Data Sheet.

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THIS PRODUCT DATA SHEET SUPERSEDES ALL PREVIOUSLY ISSUED VERSIONS.

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