

# TECHNICAL DATA SHEET

## COATING SYSTEM

**STAC BOND®**  
ALUMINIUM COMPOSITE PANEL

### PRODUCT: PVdF VALID FOR TOPCOAT

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chromium free chemical passivation
Front side coating	EN 13523	PVdF 70/30**
Topcoat thickness	EN 13523-1	20 [-2; +4] $\mu\text{m}^*$ (PVdF)
Primer thickness	EN 13523-1	5 $\pm$ 1 $\mu\text{m}^*$ (PE)
Front side total coating thickness	EN 13523-1	25 [-3; +5] $\mu\text{m}^*$
Back side total coating thickness		3 $\pm$ 1 $\mu\text{m}^*$ (Epoxy backcoat)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	30 $\pm$ 5 GU (for higher gloss one extra transparent layer is necessary on top)
Bending	EN 13523-7	Max. 1.0 T (depending on the substrate)
Impact	EN 13523-5	GTO
Pencil hardness	EN 13523-4	Minimum: F
Solvent resistance to ketone	ASTM D 5402-93 (1999)	$\geq$ 100 double rub

LONG TERM PROPERTIES, MAIN SIDE COATING	METHOD EQUIPMENT	REQUIREMENTS
Water immersion resistance	EN 13523-9	1000 h. OK Blistering > 6F
Florida exposure		Gloss retention > 85% of original after 2 years
$\Delta E$	EN 13523-3	$\Delta E$ value is specified depending on the color and coating type. According to approve sample generally: - Light colors (solid colors) $\leq$ 0,80 - Dark colors $\leq$ 1 - High chroma, vivid colors and metallic colors $\leq$ 2

STACBOND® maintains the right to update and modify the contents of this data sheet at any time.

STACBOND® Quality Department



\* Standard values, other values can be accepted if the finish so requires it and does not affect the product quality.  
\*\* 70% PVDF 70/30