TECHINICAL DATA SHEET
COATING SYSTEM

VER. 001/21

PRODUCT: 4-LAYER HDPE

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chrome-free chemical passivation
Front side coating	EN 13523	Type: HDPE 4L
Clearcoat thickness	EN 13523-1	15 ± 1 µm*
Inkcoat thickness	EN 13523-1	1 - 7 µm*
Topcoat thickness	EN 13523-1	20 ± 2 µm*
Primer thickness	EN 13523-1	5 - 7 µm*
Front side total coating thickness	EN 13523-1	45 µm*
Back side total coating thickness		5 ± 1 µm* (chrome-free polyester)
Colour		According to approved sample
Gloss (measured at 60º angle)	EN 13523-2	2 - 5% gloss
T-bend adhesion - no removal	EN 13523-7	≤ 1,5 T
T-bend flexibility - no cracking	EN 13523-7	≤ 1,5 T
Impact resistance - no cracking	EN 13523-5	< 4J
Pencil hardness	EN 13523-4	F - 2H
Solvent resistance to acetone	EN 13523-11	≥ 100 double rubs

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.