



	TEST STANDARD	TOLERANCE	RESULT
<b>PHYSICAL PROPERTIES</b>			
Panel Thickness	...	(±) 0.2 mm	2 mm to 3 mm
Weight of the Panel	...	± 0.5 kg/m <sup>2</sup>	2.7 kg/m <sup>2</sup>
Standard Width	...	(±) 2 mm	1220 mm
Length	...	(±) 2 mm	2440 mm
Skin Thickness	...	(±) 0.03 mm	0.10 mm to 0.20 mm
<b>FILM PROPERTIES AND PERFORMANCE</b>			
Surface Quality/ Visual Inspection		Visually Accepted	PASSED
Pencil Hardness	ASTM D 3363	≥ H	2H
Film Adhesion Test by Crosshatch	ASTM D3359	No removal of film	No removal of film nor blistering
Film Adhesion Test by Boiling Water	AAMA 2605	No removal of film	No removal of film nor blistering
Solvent Resistance Test (MEK Test)	ASTM D 4752	Bearable @ 100X Rubbing	PASSED 100 DR
Impact Resistance Test 50 kg-cm	ASTM D 2794	No removal of film	No removal of film

**THIS PRODUCT IS FOR KITCHEN & INTERIOR USE ONLY**



PHYSICAL PROPERTIES					
	TEST STANDARD	TOLERANCE	RESULT		
			3MM (0.20MM COIL)	4MM (0.3MM COIL)	4MM (0.2MM COIL)
Panel Thickness	...	(±) 0.2 mm	3.0 mm	4.0 mm	4.0 mm
Weight of the Panel	...	(±) 0.5 mm	3.85 kg/m <sup>2</sup>	5.43 kg/m <sup>2</sup>	4.86 kg/m <sup>2</sup>
Standard Width	...	(±) 2 mm	1220, 1500 mm		
Length	...	(±) 2 mm	2440 mm up to 6000 mm		
Skin Thickness	...	(±) 0.02 mm	0.20 mm	0.30 mm	0.20 mm
MECHANICAL PROPERTIES					
	TEST STANDARD	REQUIREMENT	RESULT		
			3MM (0.20MM COIL)	4MM (0.3MM COIL)	4MM (0.2MM COIL)
Peel off Strength @ 180°	ASTM D 903	≥ 10 Kg/25mm	≥ 10 Kg/25mm		
COATING PROPERTIES AND PERFORMANCE					
	TEST STANDARD	REQUIREMENT	RESULT		
			3MM (0.20MM COIL)	4MM (0.3MM COIL)	4MM (0.2MM COIL)
Paint Quality	....	...	POLYESTER (PE)		
Color Difference Test	ASTM D 2244	ΔE ≤2.0 (reference to master sample)	ΔE ≤2.0 (reference to master sample)		
Coating Thickness	ASTM D 1400	2-Coat: 25 ± 3 μm	2-Coat: 25 ± 3 μm		
Specular Gloss @60	ASTM D 523-89	±5% (reference to master sample)	±5%		
Pencil Hardness Test	ASTM D 3363	≥ H	≥ H		
Solvent Resistance Test (MEK Test)	ASTM D 4752	...	No removal of paint @ 50 DBR		
Coating Flexibility T - Bend Test	ASTM D 4145	≥ 2T without cracks	2T without cracks		
Impact Resistance Test 50 kg-cm	ASTM D 2794	...	No crack and Paint Peel-off		



**COATING PROPERTIES AND PERFORMANCE**

SCHEMATIC DIAGRAM

COATING SYSTEM								DFT
				FEVE	PVDF	HDPE	PE	
CLEARCOAT	CLEARCOAT	3COAT/ LAYER	2COAT/ LAYER	FEVE	PVDF	HDPE	PE	13-15µm
TOPCOAT	TOPCOAT			PVDF	PVDF	HDPE	PE	18-20µm
PRIMER	PRIMER			PRIMER				5-7µm
	PRETREATMENT			CHROME				<1µm
SUBSTRATE	SUBSTRATE			ALUMINUM				METAL

COATING GLOSS LIMITATION & COMPARISON WITH VARIOUS COATINGS

GLOSS RANGE (ASTM D 523) STANDARD @ 60°	
FEVE	60 - 90 GU
PVDF	15 - 40 GU
HDPE	15 - 90 GU
PE	20 - 90 GU

- PE
- HDPE
- PVDF
- FEVE

