



Sample formulation for Two pack HAPs Free coatings

Varnish Preparation

LF-916-TBA varnish (NV=60%)		Dosage (wt%)
Lumiflon LF-916F		60
t-Butyl acetate		40
Total		100
Steering or Shaking for enough time, and then 200Mesh filtration		

Pigment Paste

Lumiflon LF-916-TBA	above described	40
Pigment (Titanium Dioxides)*		37
Solvent	t-Butyl acetate	24
Total		100
*High durable type		

Let Down (Main Package)

Pigment Paste	above described	50
Lumiflon LF-916-TBA	above described	48
Catalyst	10E-4 DBTDL (t-Butyl acetate)	2
Total		100

Paint formulation

Main Package	above described	100
Hardener	Desmodur N3300**	12
** Bayer		

Characteristics

Solid content	63.3(%)
Viscosity of varnish (@25degC)	c.a 40 mPas
Viscosity of Paint (@25degC)	c.a 240 mPas

Film Properties of Crosslinked Coatings

- (1) Curing Condition: Force drying @80deg.C for 1hour (for 1w in ambient)
- (2) Substrate: Aluminum Panels treated by Acid-chromating (0.8mm)

Film Thickness	30 - 40 micron meter
Specular Gloss	
ISO 2813	80 / 90 (20deg. / 60deg.)
Hardness (Pencil Test: scratch)	
ISO15184	F
Flexibility	
ASTM D4145	2-3T Bend
Flexibility (Cupping Test)	
ISO 1520	> 6mm
Impact resistance	
ASTM D2794 (Diameter = 12.7mm (0.5 in))	Direct; 0.5kg, > 1m Reverse; 0.5kg, >1m
Adhesion (Cross-cut Tape Test)	
ISO2409	0-1