

Product Datasheet



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Functional Powder Coatings

Resicoat[®] R4-FB

for Fluidized Bed Application on Preheated Surfaces

Code: HJC03R

Product Description	Resicoat [®] R4 is a high quality thermosetting epoxy powder coating for the corrosion protection of valves and fittings, manufactured from cast iron or steel. The powder coating is available to be applied in one layer on a preheated surface by electrostatic spray application or fluidized bed application. Typical film thickness achieved is in the range of 250 – 500 µm. The resultant thermoset epoxy has a high mechanical resistance with excellent electrical insulation properties. Drinking water approvals are available to confirm the coatings suitability, as a hygienic and environmental friendly coating. The outstanding adhesion of Resicoat [®] R4 epoxy powders to the metal substrate provides long term protection of the coated component. It ensures a reliable conservation to the function and value of the parts for the common water and gas distribution network. The applicator of Resicoat [®] R4 benefits from a modern and environmentally friendly process.		
Powder Properties	Binder System	Typical value	Method
	Density	Epoxy	
	Gel time at 200° C	1.3 – 1.4 g/cm ³	ISO 8130-2
	Storage stability	30 – 40 sec.	ISO 8130-6
	MSDS	4 months from delivery date at ≤ 23° C	
		PC 508	
Application Data	Preheating temperature	190 – 210° C object temperature	
	Post cure conditions	self curing on 8 mm steel at above temp.	
	Particle size distribution	< 63 µm = 45 – 60 %	ISO 8130-1
		< 200 µm = 99 – 100 %	
Material Properties	Colour	blue, approx. RAL 5015	
	Recommended film thickness	250 – 350 µm	
	Flow	smooth	
	Gloss at 60° angle	70 – 90 units	DIN 67530
	Cross cut	Gt 0	DIN EN ISO 2409
	Impact resistance	> 5 Joule	DIN 30677-2
	Dielectric strength	≥ 30 kV/mm	DIN 30677-2
	Elongation	> 5 %	DIN 30677-2
	Hardness	≥ 90	DIN EN ISO 2815
	Cathodic disbonding	< 10 mm	DIN 30677-2
	Hot water immersion, 90° C, 4 weeks	no visible change	
	Adhesion after 7 days, 90° C water	> 16 MPa	acc. DIN EN ISO 4624, GSK
Approvals	Drinking water approvals: DE: Beschichtungslinie, C-138801-06-Ko/St, Arbeitsblatt W270 W-148264e-07-SI, UBA FR: DGS/VS 4 No99/217, AFNOR XP P41-250-1-3, No. de dossier: 07 MAT LY 027, LSEHL NL: Guideline BRL-K759, K 11557, KIWA UK: BS 6920, Approval No. 0612503, WRAS BE: Pipa/Hydrocheck 011, R4 blue, Belgaqua CZ: Act No. 409/2005 Coll, Reference 52/2006, Brno Health Institute AT: ÖNORM B 5014 Teil 1, Dok-Nr.: D-138568, AGES IT: D.M. del 6/04/04n. 174, Rapporto di prova N. 2420, SSICA Gas approval: DE: Test of resistance to gas according G 260, 06/069/5123/3, DVGW		
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Authorized by:	GK		
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Disclaimer: This Product Data Sheet is based on the present state of our knowledge and on current laws. The data referring to Powder Properties, Application Data and Physical Tests is based on lab based samples. Factors such as quality or condition of the substrate may have an effect on the use and application of the product. It remains the responsibility of the user to test thoroughly if the product is applicable for the intended use. The use of the product beyond our recommendation releases us from our responsibility, unless we have recommended the specific use in writing. It is always the responsibility of the user to take all necessary steps to fulfil the demands set out in the local rules and legislation. We are not liable for any application-technological advice. The Product Data Sheet shall be updated from time to time. Please ensure you have the latest version before using the product. All products and Product Data Sheets are subject to our standard terms and conditions of sale (GCS). You can receive the latest copy of GCS via internet or our post address. Brand names mentioned in this Product Data Sheet are trademarks of or are licensed to the AkzoNobel group.

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