



DuPont Powder Coatings

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Data Sheet

Flamulit[®] HTC 154

A DuPont thermoplastic powder coating

Product

Flamulit[®] HTC 154 is a polyolefin based coating powder developed to give coatings characterised by good bending strength. This powder is applied by fluidised bed.

Typical applications

Coating of metal parts giving a bright and icy appearance. It can be used for coating electrical wires or switch gears, seat belt buckles, refrigerator shelves and baskets, ... For outdoor applications requiring long term weather resistance, the quality **Flamulit[®] HTC 154 UV** is available.

Typical coating conditions

Recommended pre-treatment :

Alkaline degreasing or degreasing with vapour phase chlorinated solvents. For increased mechanical adhesion, sand blasting is recommended.

Procedure for fluidised bed for steel:

- preheat 270-360 °C according to metal thickness
- immerse 3 to 6 seconds in fluidised bed
- auto-smoothing (can be cooled in ambient air or cold water)

For more informations, see DuPont guidelines for Metal Coating procedures.

Results

Bright and icy appearance.

Coating thickness :

- 300-600 µm (i.e. 300-600 g/m²)

Characteristics

General properties	Units	Methods	Values
MFI (190 °C/2.16kg)	g/10min	ASTM D 1238	38
Particle size	µm	Alpine	below 280
Brittle point	°C	ASTM D 746	-10
Softening temperature (Vicat)	°C	ASTM D 1525	77
Elongation at break	%	ASTM D 638	200
Coating properties			
Maximum working temperature	°C		55
UV stability	> 2000 hrs	UV-exposure without significant	damage if stabilized
Specific gravity of the coating	g/cm ³	ASTM D 792	0.91 to 0.94
Salt spray		ASTM B 117 unscribed	> 2000 hrs
Hardness Shore D		ASTM D 2240	48
Electric strength	kV/mm	CEI 243-1	60
Erichsen static stamping	mm	ISO 1520	8
Chemical resistance			
Environmental stress cracking	hrs	ASTM D 1693	medium
Dilute acids		very good (sulfuric acid until 50%)	
Dilute alkalis		good	
Solvents		poor	
Mineral salt solutions		good	

Edition of April 01, subject to modifications

For Safety, Health, storage and handling recommendations as well as the disclaimer information, see the DuPont Metal Coating general guideline.