DuPont Powder Coatings

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**Data Sheet**

# *Flamulit® HTC 214*

A DuPont thermoplastic powder coating

## Product

**Flamulit® HTC 214** is a polyolefine based powder. Its excellent physical and chemical properties as well as its oxidation stabilisation give a product with especially long service life. **Flamulit® HTC 214** meets the requirements of the DIN 30670 standards.

## Typical application

**Flamulit® HTC 214** has been specially developed to meet the requirements for coating water pipes, underground steel pipes and pipe equipment plants**.** The UV resistance of **Flamulit® HTC 214** is enough good for pipes which do not need to be buried.

## Typical coating conditions

**Flamulit® HTC 214** can be applied not only by fluidised bed dipping, but also by film sprinkling or rotational coating.
Recommended pre-treatment :
Alkaline degreasing followed by phosphatation and passivation. For increased mechanical adhesion, we recommend that parts be sand blasted.
Procedure for fluidised bed :
- preheat 300-350°C according to metal thickness
- immerse 5 to 400 seconds in fluidised bed

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

## Results

Smooth and bright coatings that fulfil the DIN 30670 standards, with thickness up to 4 mm.

## Characteristics

| General properties | Units | Methods | | Values |
|---|---|---|---|---|
| MFI (190°C/2.16kg) | g/10min | DIN 53735 | | 2 |
| Particle size | µm | DIN 53734 | | below 500 |
| Brittle point | °C | DIN 53446 | | -80 |
| Softening temperature (Vicat) | °C | ISO 1525 | | 94 |
| Elongation at break | % | DIN 53455 | | > 300 |
| **Coating properties** | | | | |
| Maximum working temperature | °C | | | 60 |
| UV stability | > 2000 hrs UV-exposure without significant damage | | | |
| Specific gravity of the coating | g/cm3 | DIN 53479 | | 0.93 |
| Salt spray | | ASTM B 117 | scribed<br>unscribed | corrosion 8 mm from scribe<br>> 2000 hrs |
| Hardness Shore D | | DIN 53505 | | 48 |
| Adhesion | N/cm | DIN 30670 | | 80 |
| Electric strength | kV/mm | DIN53481 | | > 50 |
| Erichsen static stamping | mm | ISO 1520 | | 8 |
| **Chemical resistance** | | | | |
| Dilute acids | very good (except acetic acid) | | | |
| Dilute alkalis | very good | | | |
| Solvents | poor | | | |
| Mineral salt solutions | good | | | |

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