Technical Data Sheet

ICORENE® N7510

Polyolefin
Custom Powders

Product Description

ICORENE® N7510 is an adhesive polyolefin based coating powder that has been designed for encapsulating wire goods.

This grade will provide superior adhesion to the metal without any need of primer.
ICORENE® N7510 is used for fluidized bed coating applications.

General

Features	• Abrasion Resistant • Good Adhesion	• Good Flow • Good Processing Stability	
Uses	• Automotive Applications • Coating Applications	• Decorative Railing • Industrial Applications	• Piping • Wire & Cable Applications
Forms	• Powder		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	0.920 to 0.940 g/cm³	0.920 to 0.940 g/cm³	ASTM D1505
Apparent (Bulk) Density	0.30 to 0.35 g/cm³	0.30 to 0.35 g/cm³	ASTM D1895A
Appearance	smooth/glossy	smooth/glossy	Visual
Particle Size	< 11.8 mil	< 300 µm	Internal Method
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Elongation (Break)	> 100 %	> 100 %	ASTM D638
Abrasion - (Tabor)	tba mg	tba mg	ASTM D4060
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Gardner Impact			ISO 6272
73°F (23°C), 0.118 in (3.00 mm)	> 88.5 in·lb	> 10.0 J	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Durometer Hardness (Shore D)	52	52	ASTM D2240
Aging	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Continuous Upper Temperature Resistance	140 °F	60 °C	Internal Method
Optical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Gloss (11.8 mil (300 µm))	60 to 90	60 to 90	ISO 2813
Cured Properties	**Nominal Value (English)**	**Nominal Value (SI)**	
Coverage - at 300µm thickness	2360 in²/lb	3.35 m²/kg	

Additional Information	Nominal Value (English)	Nominal Value (SI)	Test Method
Adhesion [1]	290 to 580 psi	2.00 to 4.00 MPa	
Salt Spray - resistance unscratched [2]	1000 hours	1000 hours	
UV Resistance - (no significant loss of colour or gloss)	2000 hours	2000 hours	ISO 4892-2

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COATING METHOD RECOMMENDATIONS

Pretreatment:
For excellent quality finish it is essential to properly prepare your parts before coating. Metal can be either gritblasted or chemically pretreated, using suitable process in line with expected coating performance. Required information can be found on our process guideline document or through your local sales and technical contact.

Dip coating:
Preheat the metal to 250-350°C. Dip for 3-5 seconds then depending on the metal thickness a post dip heat treatment may be needed.

Automatic coating machine:
Preheat in oven at 280-350°C for 2-4 minutes. Dip for 3-5 seconds then finish in the post heat oven at 150-200°C for 2-4 minutes before final cooling in air or water.

Caution regarding heat and plastic exposure:
We recommend minimum heat history possible to achieve the desired coating finish. Excessive heat will shorten the coating lifetime and could cause discoloration. Over-thick coatings or metal parts with uneven metal thicknesses may affect the final coating properties.

CHEMICAL RESISTANCE:

- dilute acids 50°C - Fair
- dilute alkali 50°C - Fair
- salt (except peroxides) 50°C - Fair
- solvent at 23°C - Avoid contact

Notes

[1] ASTM D4541

[2] ISO 9227

Notes

These are typical property values not to be construed as specification limits.