

# Guidelines for the stoving and curing of powder coatings based on PF1003 / PF1004

### General

A correct stoving of the powder coating is a pre-requirement for a perfect powder coating layer.

For this the stoving condition as well as the temperature curve during the stoving process of the part which has to be coated has to be known and observed. The stoving condition and the temperature curve are specified by the producer of the powder coating.

The stoving condition is mentioned in the Technical Data Sheet.

### GSB- and Qualicoat

For the usage of our warehouse articles PF1003 and PF1004 in connection with GSB- and Qualicoat compliant coatings a very close range of stoving temperatures is required (see curing diagram – figure 1).

In order to fulfil the high requirements of the GSB-/Qualicoat regulations, this very close range of stoving temperatures is necessary so that a constant good quality of the final coating can be granted.

For the industrial usage (not in compliance with GSB-/Qualicoat-regulations) the requirements to the final product can vary greatly. In this case it is possible to apply a slightly bigger stoving range.

Investigations of PF1003- and PF1004 systems have shown, that the surface of the substrat, especially the pre-treatment / primer has a very great influence on the final quality of the powder coating.

A preliminary test based on the requirements is necessary, especially when the stoving conditions are in the marginal area of the specified range of stoving temperature.

Additional information is available in our safety and technical data sheets.

Figure 1

