

**PRODUCT: WRINKLED PE**

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chromium free chemical passivation
Front side coating	EN 13523	Type: PE
Topcoat thickness	EN 13523-1	20 ± 2 µm*
Primer thickness	EN 13523-1	5 ± 1 µm* (PE)
Front side total coating thickness	EN 13523-1	25 ± 3 µm*
Back side total coating thickness		3 ± 1 µm* (Epoxy backcoat)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	4 - 5%
T-bend cracking	EN 13523-7	1 - 1,5 T
T-bend adhesion	EN 13523-7	0 - 0,5 T
Pencil hardness	EN 13523-4	Min F
Solvent resistance to acetone	ASTM D 5402-93 (1999)	≥ 100 double rub

STACBOND® maintains the right to update and modify the contents of this data sheet at any time.

STACBOND® Quality Department



\* Standard values, other values can be accepted if the finish so requires it and does not affect the product quality.