



**PRE-PAINTED  
GALVANISED  
Coils & Sheets**

## Coil Form

Coil ID (mm)	508
Thickness (TCT in mm)	0.25 - 1.50
Width (mm)	600 - 1250
Coil Weight (t)	2 - 10 (if guard film: 1 - 2.5 t)

## Product Specification

Substrate	Galvanised Steel
Zinc Coating (gsm)	90 - 275
Hardness (HRB)	55 - 95
Guard film - optional (microns)	30 - 40 $\mu$ (Customised also)
Standards	JIS G 3312, ASTM A 755, EN 10169-1, IS 14246 - 1995

## Paint Specification

Paint System	Primers	Epoxy, PU polyester/universal
	Top coat	Regular Modified Polyester (RMP)/SMP/PVDF/SDP
	Backer coat	Epoxy, polyester & PU
Characteristics	Primer top coat (micron) Subject to Substrate & Coating Type	7 $\mu$ (max.)
	Top coat RMP (micron) (Coating Based)	20 - 25 $\mu$ (max.)
	Primer + Backer coat (micron)	12 - 15 $\mu$ (max.)
	Colour	As per RAL code/customer's requirement
	Gloss	Matt 35% (+/-5%)/semi-gloss 60% (+/-5%) high gloss $\geq$ 70%

## Performance Testing

Pencil Hardness	H (min.)
Impact test (in Joules) (thickness based Soft Material)	As per JIS G 3312
Salt spray test (Specific to Coating Type)	750 - 1000 hrs.
Adhesion test (cross-hatch)	100%
Erichsen cupping test	Upto 7 mm
Humidity test	1000 hrs.
T - Bend test (T = substrate thickness of Soft Material)	2 T (no tape loss)
Solvent rub test (MEK – double rub)	>50 rubs
Chemical Resistance 5% NaOH, 5% HSSO <sub>4</sub>	No blistering, discolouration and softening of paint film
Max. operating temperature	Upto 120°C

