

# TECHNICAL DATA SHEET

## COATING SYSTEM

**STAC BOND®**  
ALUMINIUM COMPOSITE PANEL

### PRODUCT: 4-LAYER PVdF

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chrome-free chemical passivation
Front side coating	EN 13523	Type: PVdF 4L
Topcoat thickness	EN 13523-1	15 ± 1 µm*
Inkcoat thickness	EN 13523-1	3 ± 1 µm*
Basecoat thickness	EN 13523-1	20 ± 2 µm*
Primer thickness	EN 13523-1	5 ± 1 µm*
Front side total coating thickness	EN 13523-1	53 µm*
Back side total coating thickness		5 ± 1 µm* (chrome-free polyester)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	35 ± 5 GU
T-bend adhesion - no removal	EN 13523-7	≤ 1T
T-bend flexibility - no cracking	EN 13523-7	≤ 1T
Impact resistance - no cracking	EN 13523-5	< 4J
Pencil hardness	EN 13523-4	Min. HB
Solvent resistance to acetone	EN 13523-11	≥ 100 double rubs

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.