

# TECHNICAL DATA SHEET COATING SYSTEM

**STAC BOND®**  
ALUMINIUM COMPOSITE PANEL

## PRODUCT: HDPU CLEAR

DESCRIPTION	METHOD EQUIPMENT	REQUIREMENTS TYPICAL VALUES
Pretreatment		Alkaline cleaning + chromiun free chemical passivation
Front side coating	EN 13523	Type: HDPU
Topcoat thickness	EN 13523-1	15 ± 2 µm* (HDPU)
Primer thickness	EN 13523-1	5 ± 1 µm* (PE)
Front side total coating thickness	EN 13523-1	20 [-3; +3] µm*
Back side total coating thickness		7 ± 1 µm* (Epoxy backcoat)
Colour		According to approved sample
Gloss (measured at 60° angle)	EN 13523-2	> 80 GU
T-Bend cracking	EN 13523-7	Min. 1 T
T-Bend adhesion	EN 13523-7	0 - 0,5 T
Pencil hardness	EN 13523-4	B - F
Solvent resistance to acetone	EN 13523-11	≥ 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.