

# Instructions for use

Protective film for coating process:  
Constraints, storage conditions and usage.

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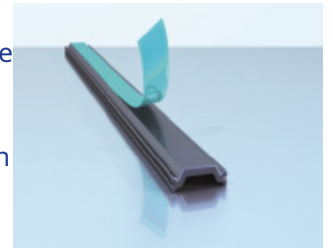
## Protective film for coating process: Constraints, storage conditions and usage.

### 1. Product purpose

Due to the low electrical conductivity of polyamide, adhesion of the powder is lower than observed on the aluminum, causing obvious Visual differences in the finish of the coated aluminum and polyamide.

Protective film for coating processes is a semi-transparent removable adhesive tape, formed by a layer of polyester and silicone adhesive, used for the protection of certain areas of the profile of polyamide (visible areas) during the process of coating.

The aim of the film is to protect the surface of the polyamide in the coating process. Once the tape is removed the polyamide strip rests black (not coated) and without any residue.



### 2. Constraints regarding the geometry of application.

The geometry of the polyamide conditions and limits the use of the protective film.

Protective film has proved its effectiveness from a film width and flat surface upper than 6 mm.

For the application in geometries with angular or curved surfaces to cover, although it can be used, it is necessary to increase the width of the film and the contact surface up to the 8 mm. It is also needed to check the effectiveness of the film and its adhesion pre-testing it by our company and by the customer.

### 3. Conditions of usage and storage

The adhesion of the film is negatively affected by moisture and environmental temperature, the humidity of the substrate (polyamide), and dust. This makes its recommended usage period is four weeks after receipt of the product.

It is recommended to keep profiles of polyamide with film stored in:

- Areas not exposed to the weather.
- Areas away from sources of humidity.
- Areas away from heat sources.
- Areas away from dust in suspension.

Occasionally and due to environmental factors that have been subject, the film can be found slightly off in small areas. It is advisable an inspection prior to the coating process and, if needed, press andpaste these located points again.. This procedure ensures total protection of the desired surface.

### 4. Removal of the film after usage

Coating protection film should be removed after coating process. In order to prevent remnants of the adhesive on the surface of polyamide it must not be carried out when aluminum-polyamide profile is still hot.

### 5. Limitations of usage in other production processes

The protective film is only suitable for coating processes in aluminum profiles with thermal break. The optimal operating range is between 180 and 200°C. It is recommended not to exceed the exposure period of 20 minutes.

Behavior of protective film in any other process or different thread has not been evaluated and therefore there is no guarantee of proper behavior.

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## 6. Main Features

<b>Purpose</b>	Protect the visible polyamide surface during the process of powder coating and be subsequently removed to obtain a product coat free and remnants of the adhesive free.
<b>Colour</b>	Semitransparent
<b>Material</b>	Layer of polyester and silicone adhesive
<b>Width and Minimum Surfaces</b>	6 mm in flat surfaces, and 8mm in the rest of geometries. Pre-testing and approval phases can be necessary.
<b>Suitable Processes</b>	Powder coating process for aluminum profiles with thermal break
<b>Work Temperature Range</b>	180-200°C (20 min)
<b>Usage Time Recommended</b>	4 weeks after reception of the material. An inspection (and re-adhesion of film in located areas if necessary) is recommended before usage.
<b>Storage</b>	Indoor in protected zones free from dust and moisture.
<b>Removal of the film</b>	Only when the profiles are cool.

In case of specific questions, we will gladly offer you our personalized attention.