

Product Datasheet



AkzoNobel

Tomorrow's Answers Today

Functional Powder Coatings

Resicoat® PI

Nylon – Internal Pipe Coating

Code: HLF90QF

Product Description

Resicoat® PI HLF90QF (Corvel® 78-7001) Black is an electrostatic spray grade nylon powder coating with excellent abrasion / wear resistance, good chemical and solvent resistance, good exterior durability, low coefficient of friction, and excellent machinability. Durable and easy to clean, Resicoat® PI HLF90QF is recommended for industrial pipe and fittings among numerous other applications.

Powder Properties

	Typical value	Method
Binder system	Nylon	
Specific gravity	1.04 – 1.14 g/cm ³	calculated
Coverage (ft ² /lb/mil)	176 sq.ft @ 1 mils	calculated
Particle size	200M: 0.0 – 15.0 % 325M: 40.0 – 60.0 %	ASTM D 3451 (% retained)
Storage stability	12 months at < 80 °F (27 °C)	

Application Properties

Preheating temperature	500 °F (260 °C) metal temperature
Post curing	5 minutes at 500 °F (260 °C)
Metal preparation	All oil and grease, mill scale and rust must be removed. A blast profile of 1.5 – 2.5 mils (38 – 50 µm) followed by application of Resicoat® 596004 (7P-0200) nylon primer is required for optimum performance. Water quench is recommended to maximize gloss and physical properties. A surfactant can be added to the water to prevent spotting.

Material Properties

Color	black	
60 degree gloss	60 – 80	ASTM D 523
Recommended film thickness	8.0 – 15.0 mils (200–375 µm)	
Melting point	356 – 374 °F (180-190 °C)	ASTM D 789
Hardness, Shore D	70 – 80	ASTM D 2240
Dielectric strength	800 – 1200 volts/mil	ASTM D 149
Taber abrasion	10 – 18 mg loss	ASTM D 4060

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GK

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Disclaimer: This Product Data Sheet is based on the present state of our knowledge and on current laws. The data referring to Powder Properties, Application Data and Physical Tests is based on lab based samples. Factors such as quality or condition of the substrate may have an effect on the use and application of the product. It remains the responsibility of the user to test thoroughly if the product is applicable for the intended use. The use of the product beyond our recommendation releases us from our responsibility, unless we have recommended the specific use in writing. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. We are not liable for any application-technological advice. The Product Data Sheet shall be updated from time to time. Please ensure you have the latest version before using the product. All products and Product Data Sheets are subject to our standard terms and conditions of sale (GCS). You can receive the latest copy of GCS via internet or our post address. Brand names mentioned in this Product Data Sheet are trademarks of or are licensed to the AkzoNobel group.