



# Axalta™ Coating Systems

## Certification to CSA Z245.20-14 System 1A

**Nap-Gard Product: 7-2500 Series**

**Lot Number: 72508FG, 3712122**

**Date Issued: October 20, 2017**

**Issued By: Martin Salazar**

**Title: Sr Lab Technician**

The above described product meets the requirements in accordance with clauses 5.2.2 & 6.1.3 and is compatible with the requirements of clause 7.3.1 of CSA Z245.20 - 14. The results given on the following pages show that this product has met the requirements of CSA Z245.20 - 14 since all testing results are passing.

*This Certification is valid from:* October 20, 2017

*to:* October 20, 2018



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**Table 1: Epoxy Powder Properties For:**

7-2500 Series, lot no.72508FG, 371213, manufactured in Sept. 14, 2017 at Houston

Test	Date of Test	Test Method	Acceptance Criteria	Results
Cure	10/18/17	12.1	90 sec	45 sec
Gel Time	10/16/17	12.2	8 s. ± 20%	8 sec
Moisture	10/16/17	12.4.2 Procedure B	≤ 0.60 %	0.31 %
Particle Size	10/18/17	12.5	≤ 3.0% @ 150µm	0.2 %
			≤ 0.2% @ 250µm	0.1 %
Density	10/13/17	12.6.2.3 Procedure B Micrometrics He Pycnometer	1440 ± 50 g/L	1462 g/L
Thermal Characteristics DSC Q100	10/16/17	12.7 TA Instruments (DSC Q100)	Tg1 63 ± 5 °C	64.26 °C
			Tg2 109 ± 5 °C	114.10 °C
			ΔH 68 ± 10 J/g	69.15 J/g

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**Table 2:  
Qualification Test Requirements for Anti-Corrosion Coatings**

7-2500 Series lot no. 72508FG, 3712122 to system 1A

Test	Test Method	Acceptance Criteria	No. of Tests	Date of Test	Results
24 h, Cathodic Disbondment (3.5V, 65°C)	12.8	6.5 mm max	3	10/17/17	1.3, 1.4, 1.6 mm Measured from edge of holiday
28 d, 23°C Cathodic Disbondment	12.8	8.5 mm max	3	10/09/17	2.7, 2.7, 2.9 mm Measured from edge of holiday
28d,65 °C Cathodic Disbondment (change solution)	12.8	20 mm max	3	10/09/17	6.1, 6.2, 6.4 mm Measured from edge of holiday
Cross-section porosity	12.10	1 - 4 rating	3	10/16/17	1, 1, 1
Interface porosity	12.10	1 - 4 rating	3	10/16/17	3, 3, 3
3.0 ° Flexibility @ -30°C	12.11	No cracking	5	10/13/17	All 5 bars - no cracking
1.5 J impact	12.12	No holidays	3	10/13/17	All 3 bars - no cracking
2.5 ° Strained cathodic dis.	12.13	No cracking	3	10/10/17	All 3 bars - no cracking
Thermal Characteristics TA Instruments (DSC Q100)	12.7	$\Delta Tg \leq 5 \text{ °C} \uparrow$	3	10/16/17	-0.4, -0.1, -0.8 °C
		Tg3 109 ± 5 °C	3	10/16/17	113.3, 113.4, 113.4 °C
		Tg4 109 ± 5 °C	3	10/16/17	112.9, 113.3, 112.6 °C
		$\Delta H1 < 3.4 \text{ J/g}$	3	10/16/17	0.1, 0.1, 0.1 J/g
75°C, 24 h adhesion	12.14	Rating of 1 - 3	3	10/17/17	1, 1, 1
75°C, 28 d adhesion	12.14	Rating of 1 - 3	3	10/09/17	1, 1, 2
95°C, 28 d adhesion	12.14	Rating of 1 - 3	3		n/a

† Fulfills the requirement for 'Cure' in Z245.20 - 14; Table 2.

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