



# Axalta™ Coating Systems

## Certification to CSA Z245.20-14 System 2A

Nap-Gard Product - Anticorrosion Base Coat Layer:	Nap-Gard Product - Top coat Layer
Product: 7-2508FG/LG	7-2504
Lot Number: 3712122/3798887	3716629
Manufacturing site: Houston TX, USA	Houston TX USA
Date Manufactured: 09/2017	07/2017

*This certification is valid from:* 11/21/2017  
*to:* 11/21/2018

The above described Top Coat Layer product has been tested 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. Clause 6.1.3 requires that the anti-corrosion layer be qualified to Table 2 to be used for systems 2A, 2B, 2C, and 3. A certificate will be attached for the anti-corrosion layer to validate it's conformance to Tables 1 and 2. An additional Certificate may be attached to certify a system using a different anti-corrosion layer than list on this Certificate. The results on the following pages show that these products have met the stated CSA requirements since all testing have passed.

**Certified by:** San Nguyen

**Title:** R&D Technician

**Date Certified:** 11/30/2017





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**TABLE 5: Epoxy Powder Properties for Top Coat Layer**

Test	Date	Test Method	Acceptance Criteria	Results
Cure Time	11/27/17	12.1	90 sec	90 sec
Gel Time	11/27/17	12.2	15 sec ± 20%	13 sec
Moisture	11/27/17	12.4.2 Procedure B	≤ 0.5 %	0.3%
Particle Size	11/27/17	12.5	≤ 3.0% @ 150 μm	0.1%
			≤ 0.2% @ 250 μm	0.0%
Density	11/27/17	12.6.2.2 Procedure A	1380 ± 50 g/L	1411 g/L
Thermal Characteristics DSC Q100	11/27/17	12.7 TA Instruments (DSC Q100)	Tg1 60 ± 6 °C	61 °C
			Tg2 96 ± 5 °C	99 °C
			ΔH 50 ± 20 J/g	45 J/g

This table reflects the powder properties for 7-2504 , lot No. 3716629

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Pre-qualification of 7-2504 lot number 3716629, the Top Coat Layer, using 7-2508FG/LG lot number 3712122/3798887 as the Anti-corrosion Layer for testing.

**TABLE 6: Coating Pre-Qualification Tests for System 2A**

Test	Test Method	Acceptance Criteria	No. of Tests	Date of Test	Results
Cross-section Porosity	12.10	1 - 4 rating	6	11/28/17	2508LG/FG : 1,1,1,2,2,2
					72504 : 1,1,1,1,1,1
Interface Porosity*	12.10	1 - 4 rating	6	11/28/17	2,2,1,3,3,3
2.0° Flexibility @ -30°C	12.11	No cracking	10	11/27/17	10 bars pass, no cracking
3.0 J Impact	12.12	No holidays	6	11/29/17	6 bars pass, no holidays
1.5° Strained Cathodic Dis.; 28 days, 23°C	12.13	No cracking	6	11/21/17	6 bars pass, no cracking
Thermal Characteristics TA Instruments (DSC Q100)	12.7	(Cure)* $\Delta T_g < 5 \text{ }^\circ\text{C}$	6	11/27/17	1,1.6,-0.4,0.1,-0.2,0.5 $^\circ\text{C}$
		Tg 3 $99 \pm 5 \text{ }^\circ\text{C}$	6	11/27/17	99, 98, 99, 99, 99, 99 $^\circ\text{C}$
		Tg 4 $99 \pm 5 \text{ }^\circ\text{C}$	6	11/27/17	100,100,99,99,99,100 $^\circ\text{C}$
		$\Delta H1 < 2.5 \text{ J/g}$	6	11/27/17	0.2,0.2,0.0,0.1,0.1,0.0 J/g
Surface roughness	12.16	>50 $\mu\text{m}$ peak to trough		n/a	n/a $\mu\text{m}$

\* Test to be completed on the inner layer of the coating system.

For individual layers of a multi-layer coating system except anti-slip overcoat.

For all multi-layer coating systems, except anti-corrosion coating with anti-slip overcoat, use 1.5J.

Surface roughness for anti-slip overcoat systems only.

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