

TDS24 – POLYESTER POWDER COATED LEAD PROFILES

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1. PRODUCT DESCRIPTION

Polyester powder coated leads are produced by applying a specially designed coloured coating selected for its high durability. They have been developed for use on glass furniture panels and to give an alternative modern appearance to a number of traditional lead strip applications.

Polyester Powder Coated products are available in Copper, White and Titanium.

Note: Every effort is made to ensure good colour reproduction, but due to colour processing limitations, colour/shades may vary slightly from batch to batch.

2. PRODUCT RANGE

The Oval sizes shown (✓) in the table are normally available ex. stock.

NOMINAL WIDTH (MM)	18	18	9	6	4.5
PROFILE TYPE	Oval	Ribbed	Oval	Oval	Oval
Metres per reel	50	50	50 25	50 25	50 25
COPPER			✓	✓	✓
WHITE	✓	✓	✓	✓	✓
TITANIUM			✓	✓	✓
BOX QUANTITY	2	2	5 8	6 8	7 8

3. TECHNICAL SPECIFICATIONS

LEAD (Pb): 99.% Minimum Refined Lead.

COATING SPECIFICATION: THICKNESS RANGE: 10-20 Microns

Flexibility: BS.3900 part E1¼" Mandrel-Excellent

Corrosion Resistance: Hot salt water spray A.S.T.M. B117 1000 hrs excellent.

Artificial Weathering: BS3900 part F3 2000 hrs. – Minimal change.

Florida Exposure: 45° angle 12 months – Minimal change

Chemical Resistance: Excellent to most chemicals including acids and alkalis but softened by ketones and chlorinated solvents such as trichloroethylene – abrasive-cleaning agents should be avoided. Certain liquid building products (e.g. mortar additives) are highly aggressive, and should not be allowed to come into contact with powder coated lead.

ADHESIVE SPECIFICATION: 100% cross linked acrylic

4. PERFORMANCE

BS5713 / BSEN1279

Polyester powder coated Lead Profiles are used in the production of double glazed (IG) units under BS5713 and also recently introduced in the UK, BSEN1279.

The requirements of BSEN1279 Part 6 are met in the following ways:

Annex C (normative): Fogging Tests:

Unit manufactured using polyester powder coated Lead Profile can conform to this test method.

Annex J (informative): Adhesion Test:

Regular testing under the operating procedures outlined in ISO9000:2000 are carried out at RegaLead Ltd.

A Certificate of Conformity to Annex J can be issued for the Peel and Shear requirements of this specification, by request, to our Quality Manager.

WEATHERING

Polyester powder coated lead profiles should not be used within 2 km of the coast, as the salt air is extremely corrosive.

Note: *In areas that may be subject to moisture, the outer edges of the lead may release deposits of basic lead carbonate. This is a normal reaction of lead with moisture. Should these deposits become unsightly they can be removed by cleaning (normal window maintenance). With time this reaction will cease.*

5. APPLICATION AND STORAGE

APPLICATION

The correct application of Lead profiles is important to obtain optimum performance.

1. The glass surface should be thoroughly cleaned with a proprietary glass cleaner such as UV-Tek, then wiped to remove any moisture or residue.
2. The lead profile should be smoothed between finger and thumb before removing backing tape. Do not stretch the lead.
3. Initial application will be aided by applying finger/thumb pressure to the lead while following the design.
4. Secure onto the glass using a boning peg, applying a firm even pressure. First run the concave edge of the peg along the full length of the top surface. Then, using the pointed end holding the peg at an approximate angle of 45°, run the peg along both outer edges of the lead in a smooth firm action – in effect crimping the lead to the glass. Repeat on each strip and treat all joints in the same manner, ensuring good surface contact and that no gaps are left between lead/adhesive and glass. This lead should only be applied to flat glass.

NOTE: *Angling the peg slightly when using the concave end will avoid damaging the top surface of wide or ribbed lead. The pointed end should be used to bone down the grooves in ribbed lead.*

IMPORTANT: The coating applied to polyester powder coated lead has had the effect of “toughening” the product, making it less malleable than standard lead profile. Therefore it is essential the above instructions are followed and that extra care and attention is taken during application to ensure good surface contact is obtained between lead/adhesive and glass. The use of rubber rollers is not recommended.

5. Clean the panel as step 1 and leave it to stand for 1 hour before machine washing to allow adhesive bond to develop.
6. Polyester powder coated lead profile has excellent flexibility, however its use is not recommended around tight circles or curves. Butt jointing should be avoided and ends should be tucked under a solid strip of lead. Ideally the finished panel should not have any loose ends.

STORAGE

Correct storage conditions are important to reduce deterioration. Storage life in a temperate climate should be no less than 2 years providing it is stored in original sealed cartons. It should not be stored in areas that may be subject to excessive heat, moisture corrosive or solvent fumes.

6. HEALTH & SAFETY

Lead is a stable metal but the correct handling of the product is important to avoid inhalation or ingestion of dust or fumes. Under normal application conditions the most important precaution relates to personal hygiene, ie washing hands after application. Further important specific details are given in HS01 Health & Safety – Lead Profiles

Information and recommendations are given in good faith and based on practical tests. No warranty or guarantee is given as to the fitness of any Goods for any particular purpose and the buyer shall have satisfied himself as to the fitness of the Goods for the purpose for which they are so required. Product covered by Standard Conditions of Sale.