

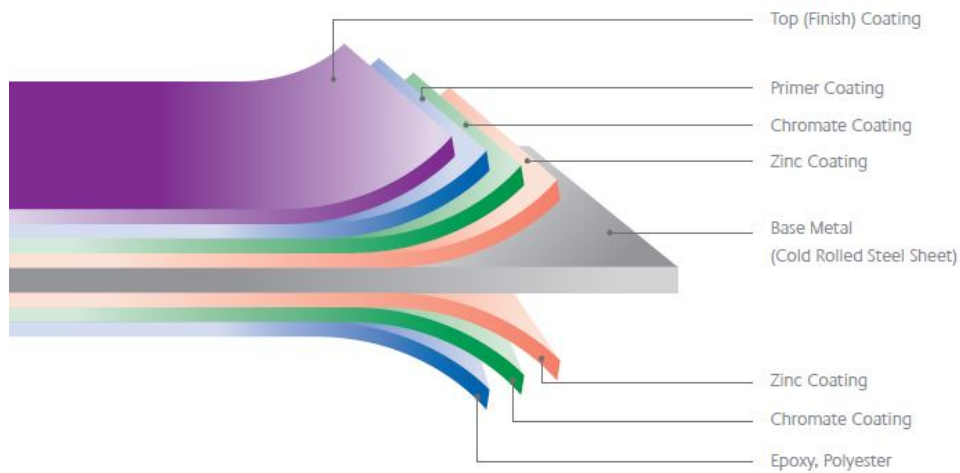
PRE PAINTED COILS

Pre Painted Coils Specification

Ralco offers a wide range of Pre painted steel and aluminum products in wide range of color choice.

Customer various demands can be satisfied through substrates the line is capable to paint on, capability on size range, coating textures.

Micro Structure of Coated Steel



PRIMER COAT:

Primer Type	PU /Epoxy	
Nominals Primer Coat Thickness(μ)	Top Coat	5
	Back Coat	2 to 5

FINISH COAT :

Paint Type	RMP / SMP /SDP / PVDF	
Nominals Paint Coating Thickness(μ)	Top Coat	18 to 22
	Back Coat	3 to 6*

*Optional up to 15 micron max.

Product Range:

Nominal Thickness (BMT,mm)	0.20 – 1.10
Nominal Width (mm)	610 - 1250
Unit Coil wt. (Max.MT)	10
Coil inner Daimeter (mm)	508

PRODUCT FORMS : In coils**Substrate Qualities – steel**

- CQ – Commercial Quality
- LFQ – Lock Forming Quality
- SQ – Structural Quality
- DQ – Drawing Quality
- EDQ – Extra Drawing Quality

Substrate – Aluminum**Alloy:** 3003 & 3005**Dimensions / Sizes**

Thickness range	Min	Max
GI , CR , Galvalum	0.25 mm	1.0 mm
Aluminum	0.45	1.0 mm

Width range	Min	Max
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Coil Weight	Min	Max
GI , CR , Galvalum	2000 kg	7000 kg
Aluminum	1000 kg	3000 kg

Coil Diameter	Min	Max
Inner	508 mm	600 mm
Outer – GI, CR , GL	700 mm	1600 mm
Outer - Aluminum	700 mm	1400 mm

COLOR PAINTING TYPES

Polyester
SMP (silicone modified polyester)
PVDF
Plastisol
HDF
Polyurethane
Epoxy
Acrylic paint

Paint Standards & Thickness

Normal , the exposed side of the substrate is coated with required paint system and selected color having coating thickness of 5 microns primer and finish coat 15 – 20 microns Total DFT 20 – 25 microns.

The reverse side is coated with 5 – 7 microns of epoxy or polyester back coat and the color is RAL7035

For other special coatings and color choice, please contact Ralco Sales dept.

Coil Weight	Min	Max
GI , Galvaume	2.0 to n	7.0 to n
Aluminum	1.0 to n	4.5 to n

Coil Dia meter	
Inner diameter	508 or 610 mm
Outer diameter	1600 mm Maximum





Slight color deviations are due to monitor calibration