DIN EN 10169:2011-02 (E)

Continuously organic coated (coil coated) steel flat products - Technical delivery conditions

Contents

Page

Foreword 3

1 Scope 4

2 Normative references 4

3 Terms and definitions 6

4 Designation 11

5 Information to be supplied by the purchaser 12
5.1 Mandatory information 12
5.2 Options 13

6 Requirements 13
6.1 General 13
6.1.1 Steel substrates 13
6.1.2 Organic coatings 14
6.1.3 Manufacturing process 15
6.2 General coating properties 15
6.2.1 General 15
6.2.2 Coating thickness and tolerances 16
6.2.3 Appearance 17
6.2.4 Adhesive strength after cupping or bending 18
6.2.5 Coating hardness 18
6.2.6 Other coating and performance properties 18
6.3 Special coating properties 18
6.3.1 General 18
6.3.2 Product flexibility 18
6.3.3 Durability 19
6.4 Freedom of defects 22

7 Inspection 22
7.1 Types of inspection and inspection documents 22
7.2 Test units 22
7.3 Type and number of tests 22
7.4 Sampling 23
7.5 Test methods 23
7.5.1 General 23
7.5.2 Coating thickness 23
7.5.3 Colour and colour difference 23
7.5.4 Gloss 24
7.5.5 Adhesive strength/flexibility 24
7.5.6 Inspection on defects 24
7.5.7 Coating hardness 24
7.5.8 Testing on durability 25
7.6 Retests 27

8 Marking 27

9 Packing and dispatch 27

10 Storage 27

Annex A (informative) Types of ambience 28

Annex B (informative) Coating materials 31

Annex C (informative) Types of atmosphere (see also EN ISO 12944-2) 32

Annex D (informative) Outdoor exposure sites 33

Annex E (informative) Storage 35

Bibliography 36