

**GENERAL FEATURES**

This thermosetting powder contains polyester resins.

**APPLICATION**

This product has been specially formulated for Retailers.  
 Due to its special content the product is suggested also for exterior coating.

**ADVISED CYCLES**

The surface to be coated must be cleaned from oils, grease or flash rust.  
 If particular resistance to corrosion or humidity is required, it is suggested the following pretreatment of the surface:

for steel	sand blasting or/and iron or zinc phosphatising
for galvanised steel and aluminium	chromatising

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Mixed cycles:  
 If it is needed, it is possible to carry out mixed cycles by using liquid primers in combination with the Polyester Powder.  
 Therefore we advise:  
 - electrophoretic primer after phosphatising or  
 - spray water-borne primer after sand blasting and successive stoving.

As for the spray water-borne primer, it must be noted, that it was specially formulated in order to resolve the problem of adhesion to the support or/and among different layers, especially if durability and outdoor resistance are required.

**HANDLING AND STORAGE**

Store at temperatures lower than 30°C; higher temperatures may damage the powder by causing undesired alterations or blobs.  
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 Storage life in original package: 18 months.

**TECHNICAL DATA**

Code	Int. Method	Range	Ref. Method
P/CL092	Calc.specific gravity(kg/l):	1.152 - 1.199	
P/CL120	Non volatile content(w/w)(%) 3h at 105 °C	100.0 - 100.0	UNI EN ISO 3251
P/CL125	Non volatile content(v/v)(%)	100.0 - 100.0	

Code	Int. Method	Range	Ref. Method
P/CL143	1µm Theor.spread.rate (m2/kg):	834 - 868	
P/CL210	Water content (%):	0.0 - 0.0	
P/YC060	Particle size dist. <32µm (%):	36 - 46	
P/YC120	Particle size dist. <63µm (%):	74 - 91	
P/CS010	Dry film thickness(microns):	60 - 80	UNI ISO 2178
P/CC050	Gloss 60° :	3.0 - 7.0	UNI EN ISO 2813:2014

**WAYS OF APPLICATION**

Apply with automatic or manual guns with negative terminal (60/80KV).  
 For stoving the Polyester products with gloss below 10 it is possible to use the following combinations of time and temperature:

10-20 minutes	200°C (temperature of the support)
20-30 minutes	190°C (temperature of the support)

For stoving the Polyester products with gloss over 10, or for stoving the Polyester fine textured products, it is possible to use the following combinations of time and temperature:

7-10 minutes	200°C (temperature of the support)
10-20 minutes	190°C (temperature of the support)
20-40 minutes	180°C (temperature of the support)

For stoving use the given indications.  
 Apply with guns with negative terminal (60/80KV) or triboelectric guns automatically or manually.  
 It is advised to apply in layers with the thickness of 60-80 µ.  
 For stoving the Polyester matt products with gloss below 10 it is possible to use the following combinations of time and temperature:

10-20 minutes	200°C (temperature of the support)
20-30 minutes	190°C (temperature of the support)

**TECHNOLOGICAL FEATURES AND RESISTANCE TESTS**

The support used	UNI sheet
Thickness	60 microns
Stoving	20 minutes at 190°C
Appearance and levelling	good

Chemical resistance test by immersing for 48 hours at indoor temperature into:

hydrogen chloride 10 %	film is intact
nitric acid 30 %	matt, but washing off
hydrogen sulphide	intact
hydrogen peroxide 40 volumes	intact
ammonium hydroxide 10 %	intact
ammonium hydroxide 33 %	intact
sodium hydroxide 5 %	intact
tartaric acid 5 %	intact
citric acid 5 %	intact
lactic acid 5 %	intact
ethanol	intact
N-butanol	intact
petroleum ether	slightly softened

result from a misuse of the product or for damages that have arisen after the product's distribution.

The chemical resistance test was carried out on zinc phosphatised steel.

Code	Int. Method	Range	Ref. Method
P/CM010	Buchholz indentation test :	more than 300	UNI EN ISO 2815
P/CM181	Pendulum-rocker hardness : Persoz pendulum	more than 3	UNI EN ISO 1522
P/CM040	Erichsen cupping test (mm):	more than 5	UNI EN ISO 1520
P/CM050	Direct impact test (cm.Kg):	more than 10	ASTM D 2794; ISO 6272-2:2002
P/CM051	Reverse impact test(cm.kg):	more than 10	ASTM D 2794; ISO 6272-2:2002
P/CM170	Conical mandrel : Bend test	less than	UNI EN ISO 6860
P/CM100	Crosscut adhesion (2mm)(GT):	00	UNI EN ISO 2409
P/CM190	Salt fog test :	500 hours later - no change	UNI ISO 9227
P/CM230	Resistance to humidity : (Humidity test)	less than	UNI EN ISO 6270-2:2005

## NOTE TO USER

The information contained in this document while based on evidence and reliable methods can not be considered exhaustive.

This information are current to the date of issuance of this data sheet, therefore is under user's responsibility to verify that the data provided on this sheet are current to the date of the product.

The user, under its own responsibility, shall respect all the existing provisions on hygiene and safety and shall verify every time the features and the specific and appropriate way to use the product, cause the respect of the provisions is not under producer's direct control.

The manufacturer does not guarantee nor assume any liability or responsibility for whatsoever harm that might