GENERAL FEATURES
This thermosetting powder contains polyester resins cured with fit curing agents.

APPLICATION
Due to its special content the product is particularly suggested 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

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

TECHNICAL DATA

Code	Int. Method	Range	Ref. Method
P/CL092	Calc.specific gravity(kg/l):	1.427 - 1.485	
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	
P/CL143	1µm Theor.spread.rate (m2/kg):	673 - 701	
P/CL210	Water content (%):	0.0 - 0.0	
P/YC060	Particle size dist. <32µm (%):	36 - 46	
P/YC120	Particle size dist. <63µm (%):	74 - 91	

WAYS OF APPLICATION
Apply with guns with negative terminal (60/80KV) or triboelectric guns automatically or manually.
It is advised to apply the product in layers with the thickness of 60-80 microns and to stove at 180°C for 20 minutes.
For stoving of the Polyester texture products it is possible to use the following combinations of time and temperature:

7-11 minutes	200°C (temperature of the support)
10-20 minutes	190°C (temperature of the support)
15-27 minutes	180°C (temperature of the support)
20-40 minutes	170°C (temperature of the support)

For stoving use the given indications.

TECHNOLOGICAL FEATURES AND RESISTANCE TESTS

The support used	UNI sheet
Thickness	60 microns
Stoving	20 minutes at 180°C

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

hydrochloric acid 10 %	film is intact
nitric acid 30 %	matt, but washing off
saturated 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

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

Code	Int. Method	Range	Ref. Method
P/CM040	Erichsen cupping test (mm):	more than 5	UNI EN ISO 1520
P/CM050	Direct impact test (cm.Kg):	more than 25	ASTM D 2794; ISO 6272-2:2002
P/CM051	Reverse impact test(cm.kg):	more than 25	ASTM D 2794; ISO 6272-2:2002
P/CM170	Conical mandrel : Bend test	maximum 10 mm	UNI EN ISO 6860
P/CM100	Crosscut adhesion (2mm)(GT):	00	UNI EN ISO 2409
P/CM190	Salt fog test :	1000 hours later - indentation along the cross of 3-6 mm	UNI ISO 9227
P/CM230	Resistance to humidity : (Humidity test)	500 hours later - no change	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 con-

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