GENERAL FEATURES

This thermosetting powder contains polyester resins cured with fit curing agents specially selected for their superior resistance to UV radiation and outdoor weathering.
This products is part of the category named HIGH DURABLE.
The Inverpul and Inverbond /HD FTX were created for coating aluminium components used in architecture, for coating galvanised steel and for coating primers especially formulated for the ACE (Agricultural and Construction Equipment) sector and have all the necessary requirements for the approval of the Qualicoat class 2 category 1 (licence P-0987) specification.
The Inverpul and Inverbond /HD FTX have also all the necessary requirements for approval of the GSB Master Quality (license 152j) specification.
The metallic effect pigment of the Inverbond /HD FTX is fixed on the powder by means of a bonding process, thanks to which is possible to achieve the best results in terms of application and reproducibility for the metallic effect powders. The problems of separation in the powdercloud during the application process, typical of dry blend products, are so eliminate, with positive effects on the colour constancy.

APPLICATION

Due to its special content the product is particularly suggested for exterior coating, also in tropical environment.

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 aluminium	chromate conversion according to DIN 50939
for steel	sand blasting or/and iron or zinc phosphatising
for galvanised steel	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: 12 months.

TECHNICAL DATA

Code	Int. Method	Range	Ref. Method
P/CL092	Calc.specific gravity(kg/l):	1.365 - 1.421	
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):	704 - 733	
P/CL210	Water content (%):	0.0 - 0.0	
P/CS010	Dry film thick-ness(microns):	60 - 80	UNI ISO 2178
P/CC050	Gloss 60° :	5.0 - 15.0	UNI EN ISO 2813:2001

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 (temperature of the support).
For stoving of the Polyester/HD FTX products it is possible to use the following combinations of time and temperature:

10 minutes	200°C (temperature of the support)
15 minutes	190°C (temperature of the support)
20 minutes	180°C (temperature of the support)

For stoving use the given indications.

TECHNOLOGICAL FEATURES AND RESISTANCE TESTS

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

Code	Int. Method	Range	Ref. Method
P/CM010	Buchholz indentation test :	more than 90	UNI EN ISO 2815
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	Opposite impact test(cm.kg):	more than 25	ASTM D 2794; ISO 6272-2:2002
P/CM100	Crosscut adhesion (2mm)(GT):	00	UNI EN ISO 2409
P/CM230	Resistance to humidity : (Humidity test)	1000 hours later - no blistering, indentation along the cross of maximum 1 mm	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 result from a misuse of the product or for damages that have arisen after the product's distribution.