

GENERAL FEATURES

Thermoset powder coatings epoxypolyester resins based.
 It forms hard and smooth film with good resistance to chemicals, fuels, and lubricants. Good mechanical performance.

APPLICATION

This product is specifically formulated as a light metal wheels primer.

ADVISED CYCLES

The substrate need to be well cleaned from oil, grease and superficial oxydation.
 To obtain the best anti corrosion or humidity resistance a substrate pre-treatment is suggested as :

for aluminium	chromatation of phosphochromatation as DIN50939
for steel	sand blasting and/or iron or zink phosphatation
for galvanised steel	chromatation

HANDLING AND STORAGE

Store at temperatures from 5°C and lower than 30°C with max 60%RH; higher temperatures and humidity may damage the product by causing undesired alterations or blobs.
 Storage life in original package: 24 months.

TECHNICAL DATA

Code	Int. Method	Range	Ref. Method
P/CL092	Calc.specific gravity(kg/l):	1.457 - 1.516	
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):	660 - 686	
P/CL210	Water content (%):	0.0 - 0.0	
P/YC060	Particle size dist. <32µ(%):	47 - 48	
P/YC120	Particle size dist. <63µ(%):	86 - 88	
P/CS010	Dry film thickness(microns):	70 - 90	UNI ISO 2178
P/CC050	Gloss 60° :	75.0 - 85.0	UNI EN ISO 2813:2001

WAYS OF APPLICATION

Inverpul Primer MP can be sprayed with corona guns (60/80 KV) or tribo, in automatic or manual plants.
 Application from 50 to 70 microns are suggested at a curing cycle of 180°C for 15'.
 To cure the Inverpul Primer MP 80 GL is possible to use the following combinations of time and temperatures:

7-12 Min.	200°C (object temperature)
10-20 Min.	190°C (object temperature)
15-30 Min.	180°C (object temperature)

Please use the suggested curing conditions.

TECHNOLOGICAL FEATURES AND RESISTANCE TESTS

substrate used	aluminium panel
film thickness	60 microns
curing	15 minutes at 180°C

All the test was carried out on chromated aluminium substrate.

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):	25 - 35	ASTM D 2794; ISO 6272-2:2002
P/CM050	Direct impact test (cm.Kg):	25 - 35	ASTM D 2794; ISO 6272-2:2002
P/CM100	Crosscut adhesion (2mm)(GT):	less than 1	UNI EN ISO 2409

NOTES

Be careful if a gas oven with direct flame is used to cure the primer, an adhesion test from the top coat to the primer must be performed, as nitrogen oxides could affect negatively the result.

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.