

**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):             | 1.577 - 1.641 |                 |
| 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):           | 609 - 634     |                 |
| P/CL210 | Water content (%):                        | 0.0 - 0.0     |                 |
| P/YC060 | Particle size dist. <32µ(%):              | 36 - 46       |                 |
| P/YC120 | Particle size dist. <63µ(%):              | 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 fine 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 %             | mat, 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   | UNI 8901        |
| P/CM051 | Opposite impact test(cm.kg):             | more than 25   | UNI 8901        |
| 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 8744        |

**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.