

POLITHERM 10 ME ALUMÍNIO 31240 BR
POWDER PAINT 10 ME ALUMINIUM 3 1240 GLOSSY

PRODUCT: 10004733
DESCRIPTION / USES: Metallic parts coating for indoor use.

IMPORTANT: Metallic coatings are sensitive to risks and can show some wear, depending of the circumstances of use. The metallic finish could change, in case of intense handling, contact with chemical products (including domestic cleaning products), attrition between parts or with abrasive objects and exposure for long periods in highly humidity environments.
 To protect the film against wear, we recommend the application of a clear as top coat. The application must be done after a partial cure of the metallic finish. Recommended clears: 10005709 for glossy finish and 10006020 for matte.

CHARACTERISTICS:

Resin: Epoxy/polyester
Specific gravity: 1,72 ± 0,10 g/cm³
Stability: 12 month (máx. 30°C)
Observations Free of heavy metals according to RoHS Directive 2002/95/CE of 01/27/2003

APPLICATION CHARACTERISTICS :

Surface: Ferrous and non-ferrous
Surface preparation: Ferrous : Phosphatization
 Non-ferrous: Chromatization or phosphatization*
Cure conditions: 10 minutes at 200 °C**
Thickness: 50 – 70 µm
Application system: Electrostatic gun

Note: We recommend the following cure and application procedures to reduce color and metallic changes.
 - Avoid recovered powder.
 - Avoid application on previously coated parts.
 - Avoid time and temperature variations during baking. It can happen when set parameters of the oven are changed, or when parts with different mass are cured in the same baking.

AFTER CURE CHARACTERISTICS *:**

TEST	METHOD	SPECIFICATION
ADHESION	TIM 222	: GR0
GLOSS	TIM 404	: Visual Std
IMPACT (REVERSE)	TIM 375	: Min. 50 kg X cm
FLEXIBILITY (CONIC MANDREL)	TIM 342	: Max. 3 mm

CHEMICAL RESISTANCE ***

Salt spray: : Min. 500 h (ASTM B117 – 73)
Humidity: : Min. 1000 h (35°C)

* For non-ferrous metals phosphatizing, please contact our technical service.

** After stabilization on correct temperature (metal temperature).

*** The tests were conducted on degreased steel panels in accordance with the cure and thickness specifications. The figures may be change, depending on the surface characteristics. For chemical resistance tests the panels were degreased and treated with tricationic phosphat.

IMPORTANT: If is not possible the use of the product according to the directions given above we ask you to contact our technical service.

STORAGE: Fresh, dry and covered place.

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