

TINTA PO POLITHERM 22 R LI CINZA 13125 SF
POWDER COATING 22 R SM GREY 13125 SM

PRODUCT: 12396591

DESCRIPTION / USES: Metallic parts coating for indoor use.

CHARACTERISTICS:

Resin: Epoxy / polyester
Specific gravity: 1,55 ± 0,10 g/cm³
Stability: 6 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: 5 minutes at 180 °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	WPS-3905	GR0
GLOSS	WPS-3854	43 ± 5 UB
IMPACT (REVERSE)	WPS-4130	Min. 160 kg X cm
FLEXIBILITY (CONIC MANDREL)	WPS-4856	Max. 0 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.

COPY FOR INFORMATION

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