

**POLITHERM 54 HB R LI PRETO N1 BR**  
**POWDER COATING 54 R SM BLACK N1 BR**

**PRODUCT:** 11647458

**DESCRIPTION / USES:** Epoxy powder coating for indoor use on metallic parts.

**CHARACTERISTICS:**

**Resin:** Epoxy  
**Specific gravity:** 1,51 ± 0,10 g/cm<sup>3</sup>  
**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:** 10 minutes at 200 °C\*\*  
**Thickness:** 100 – 120 µm  
**Thickness for tests:** 50 – 70 µm  
**Application system:** Electrostatic gun

**AFTER CURE CHARACTERISTICS\*\*\*:**

TEST	METHOD	SPECIFICATION
ADHESION	TIM 222	: GR0
GLOSS at 60°	TIM 404	: Minimum 90 UB
IMPACT (REVERSE)	TIM 375	: Minimum 50 kg X cm
FLEXIBILITY (CONIC MANDREL)	TIM 342	: Maximum 3 mm

**CHEMICAL RESISTANCE \*\*\***

**Salt spray:** : Minimum 500 h (ASTM B117 – 73)  
**Humidity:** : Minimum 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.

This product is not suitable for parts intended to be glued using silicon glue.

**STORAGE:** Fresh, dry and covered place.

**WEG COATINGS**  
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