



POLITHERM 25 R SM ORANGE 25154 BR

PRODUCT: 18768385

DESCRIPTION / USES: Metallic parts coating for indoor use. Allows thickness ranging from 100 to 200 micrometers in only one layer without substrate pre-heating. The exclusion of two-layer application system saves time and energy, rising the output rates.

Note: Apply this product preferably over blasted substrates. This kind of pre-treatment helps the obtention of high thickness. Another aspect influencing the thickness is the shape of the parts, where geometries that are more complex presents more difficulty to obtain the specified layer.

As it is a coating for technical purposes, sometimes it is possible the presence of surface imperfections like pinholes or pour levelling (or smooth texture in textured coatings). These characteristics does not reduce the coating performance.

CHARACTERISTICS:

Resin:	Epoxy
Specific gravity:	1,45 ± 0,10 g/cm ³
Stability:	6 month (max. 30°C)
Observations:	Free of heavy metals and other substances provided for in Directive 2015/863 EU of 03/31/2015 (RoHS).

APPLICATION CHARACTERISTICS:

Surface:	Ferrous and non-ferrous
Surface preparation:	Ferrous : Phosphatization Non-ferrous: Chromatization or phosphatization*
Cure conditions:	10 minutes at 320°F
Thickness:	2,36 - 3,15 mils
Application system:	Electrostatic gun

AFTER CURE CHARACTERISTICS:***

TEST	METHOD	SPECIFICATION
ADHESION	ASTM D 3359	Maximum GR0
GLOSS @ 60°	ASTM D 523	80 - 100 UB
IMPACT (REVERSE)	ASTM 2794	Minimum 43 Lb.in
FLEXIBILITY (CONIC MANDREL)	ASTM D 790 / ISO 178	Minimum 3 mm

CHEMICAL RESISTANCE ***

Salt spray:	Minimum 500 h (ASTM B117 – 03)
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 results may vary, depending on the surface characteristics. For chemical resistance testing, panels were degreased and treated with tricationic phosphat.

IMPORTANT: This coating, when properly applied and cured is suitable for the use of adhesives and sealants. However, because of the different products on the market, it requires prior testing by the user in order to select the adhesive and / or sealant appropriate.

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

Review: 00

Date: 7/11/25