



**POLITHERM 29 TF R SM GRAY UL W RAL 7012 SB**

**Code:** 19468877

**PRODUCT DESCRIPTION**

TGIC-free polyester powder coating with good adhesion, flexibility and chemical resistance. It has high physical resistance and good weathering resistance.

**RECOMMENDED USE**

Coating of metal parts for industrial purposes in outdoor environments. Recommended for thicker parts or reduced baking cycles.

**PROPERTIES**

Enhanced with additives to reduce baking time and/or temperature.

**CERTIFICATIONS AND APPROVALS**

Free from heavy metals and other substances provided for in RoHs Directive 2015/863 EU of 31/03/2015.

Powder coating certified according to UL license MH63984.

**PACKAGING**

Cardboard box with 55 lb in high-density polyethylene bag.

**CHARACTERISTICS OF MANUFACTURED PRODUCT**

<b>Resin</b>	Polyester
<b>Gloss</b>	Semi bright
<b>Finish</b>	Smooth
<b>Specific gravity (± 0,10)</b>	1,49 g/cm <sup>3</sup>
<b>Theoretical Coverage</b>	131.0 ft <sup>2</sup> /lb at 1.0 mil
<b>Mass loss during cure</b>	Maximum 2%
<b>Moisture content</b>	Maximum 0.6%
<b>Shelf life</b>	12 months
<b>Storage condition</b>	It must be stored in closed containers, in cool, dry and covered places, at an ambient temperature not exceeding 86°F.

**APPLICATION CHARACTERISTICS**

<b>Substrate</b>	Ferrous metals Non-ferrous metals
<b>Surface preparation</b>	Ferrous : Phosphatization or nanoceramic Non-ferrous: Chromatization or nanoceramic
<b>Surface cleaning</b>	The performance of this product is related to the degree of surface preparation. The surface must be clean, dry and free of any contaminants. Completely remove oils, grease and fats.
<b>Thickness</b>	2.4 mils - 3.1 mils
<b>Cure conditions</b>	10 min à 356 °F (metal temperature).
<b>Cure windows</b>	15 min - 25 min at 338 °F 10 min - 20 min at 356 °F 7 min - 15 min at 374 °F 5 min - 12 min at 392 °F
<b>Application system</b>	Electrostatic spray gun corona

**NOTE:**

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

**CHARACTERISTICS OF APPLIED PRODUCT**

Test	Specification/Standard
------	------------------------



<b>Adhesion</b>	5B (ASTM D 3359)
<b>Gloss 60°</b>	65 - 75 (ASTM D523)
<b>Impact</b>	Minimum 43 lb.in (ASTM D2794)
<b>Flexibility (conic mandrel)</b>	Maximum 1/8 in (ASTM D790)

**CHEMICAL RESISTANCE CHARACTERISTICS**

<b>Test</b>	<b>Specification/Standard</b>
<b>Humidity</b>	Minimum 1500h (ASTM D2247)
<b>Salt spray</b>	Minimum 700h (ASTM B117)

**NOTE:**

In the chemical resistance tests, the substrate used was cold-rolled steel sheet with tricationic phosphate. The mechanical resistance tests were performed on degreased common. The tests for UL certification were carried out on sheets of cold-rolled steel and hot-rolled steel substrate, with iron phosphate treatments and nanoceramics. Both single-layer and two-layer paint systems were evaluated using the products Politherm 22 R UL and Politherm 29 R UL. In the two-layer system, Politherm 22 R UL was used as a coating, followed by a finishing layer with Politherm 29 R UL. The test conditions included tests of moisture resistance in controlled atmosphere containing carbon dioxide (CO<sub>2</sub>), sulfur dioxide (SO<sub>2</sub>) and air as per UL specification with a minimum requirement of 1200 hours. Salt fog tests were performed according to ASTM B117 standard, with a minimum requirement of 600 hours.

**SAFETY PRECAUTIONS**

Guidance is available in the product's Safety Data Sheet (SDS).

**NOTE**

The information provided herein is based on our testing and experience and is intended to inform you about the product and its possible applications. The information provided in this bulletin is not intended to be complete, and the user assumes the risk of using the product for a purpose other than the specifications recommended in this bulletin without first obtaining our written confirmation of its suitability for the intended purpose. While we strive to ensure the accuracy of the information provided herein, we cannot control the quality or condition of the substrate, nor any other factors that affect the use and application of this paint. Therefore, unless we agree in writing to any condition that deviates from our recommendations, we accept no liability that may arise regarding the performance of this product. The information contained in this bulletin is subject to change without notice, based on our experience and policy of continuous development.