

POLITHERM 20 R SM ORANGE 2001 25202 BR**PRODUCT:** 14009765**DESCRIPTION / USES:** Metallic parts coating for indoor use.**CHARACTERISTICS:**

Resin:	Epoxy / polyester
Specific gravity:	1,65 ± 0,10 g/cm ³
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 180 °C**
Thickness:	50 – 70 µm
Application system:	Electrostatic gun

AFTER CURE CHARACTERISTICS*:**

TEST	METHOD	SPECIFICATION
ADHESION	WPS-3905	GR0
GLOSS	WPS-3854	Min. 85 UB
IMPACT (REVERSE)	WPS-4130	Min. 50 kg X cm
FLEXIBILITY (CONIC MANDREL)	WPS-4856	Max. 3 mm

CHEMICAL RESISTANCE ***

Salt spray:	Min. 500 h (ASTM B117 – 03)
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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