



**POLITHERM 22 R MT GRAY UL W RAL 7035 BR**

**Code:** 17114939

**PRODUCT DESCRIPTION**

Hybrid powder coating with good adhesion and flexibility, high physical resistance and good chemical resistance.

**RECOMMENDED USE**

Coating of metal parts for general use.

**PROPERTIES**

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

The texture pattern is sensitive to temperature variations. It is recommended to bake in a preheated oven at the product baking 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>	Epoxy/Polyester
<b>Gloss</b>	Bright
<b>Finish</b>	Microtexture
<b>Specific gravity (± 0,10)</b>	1,62 g/cm <sup>3</sup>
<b>Theoretical Coverage</b>	120.5 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
Adhesion	5B (ASTM D 3359)
Gloss 60°	Visual standard
Impact	Minimum 43 lb.in (ASTM D2794)
Flexibility (conic mandrel)	Maximum 1/8 in (ASTM D790)
Cupping test	Minimum 1/4 in (EN ISO 1520)

**CHEMICAL RESISTANCE CHARACTERISTICS**

Test	Specification/Standard
Humidity	Minimum 1000h (ASTM D2247)
Salt spray	Minimum 750h (ASTM B117)

**NOTE:**

Tests for UL 1332 certification were performed on cold-rolled steel substrate sheets and hot-rolled steel with iron phosphate and nanoceramic treatments. The mechanical resistance tests were performed on degreased common steel sheet under specific curing and coating conditions for the product. The values may vary depending on the substrate used.

**SAFETY PRECAUTIONS**

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

**NOTE**

The POLITHERM 22 R is UL certified for both single-layer and two-layer paint systems. The two-layer system consists of POLITHERM 22 R UL and POLITHERM 29 R UL. When the product is used as a primer with subsequent application of a finishing layer, it is recommended to undergo a 5-minute curing process at 160 °C in order to ensure proper adhesion between layers. The mean cure can be performed under different time and temperature combinations, as long as it is kept within the range of 150 °C to 180 °C. Values outside this range may compromise the final performance of the system. Do not exceed a period of 48 hours between the application of the primer and the finishing layer, as this may adversely affect adhesion between layers. Simultaneous curing of parts with different metal masses is not recommended. The conditions required for the "half cure" of higher mass parts can lead to overcure in thinner parts, generating adhesion defects. Tampering with parts must be avoided. If necessary, this should be done using fiber-free gloves to prevent surface contamination. Applications must be validated by the client based on their actual process conditions, in order to ensure adequate performance of the coating system. 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.