



**POLITHERM 49 WF TF R SM GRAY W RAL 7035 SM**

**Code:** 18952997

**PRODUCT DESCRIPTION**

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

**RECOMMENDED USE**

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

**PROPERTIES**

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.

**CERTIFICATIONS AND APPROVALS**

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

Complies with performance requirements for AAMA 2603.

**PACKAGING**

Cardboard box with 25 kg in high-density polyethylene bag.

**CHARACTERISTICS OF MANUFACTURED PRODUCT**

<b>Resin</b>	Polyester
<b>Gloss</b>	Semi matte
<b>Finish</b>	Smooth
<b>Specific gravity (± 0,10)</b>	1,46 g/cm³
<b>Theoretical Coverage</b>	11,42 m²/kg in medium thickness 60 µm
<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 30°C.

**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>	50 µm - 70 µm
<b>Cure conditions</b>	5 min à 200 °C (metal temperature).
<b>Cure windows</b>	20 min - 25 min at 170 °C 15 min - 20 min at 180 °C 10 min - 15 min at 190 °C 5 min - 10 min at 200 °C
<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	Maximum GR0 (ASTM D3359)
Gloss 60°	45 - 55 (ASTM D523)
Impact	Minimum 50 kg.cm (ASTM D2794)
Flexibility (conic mandrel)	Maximum 3,00 mm (ASTM D790)

**CHEMICAL RESISTANCE CHARACTERISTICS**

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