



## POLITHERM 46 WF R PE- GOLDEN YANMAR YM3 30697 BR

**PRODUCT:** 17789994

**DESCRIPTION / USES:** Metallic parts coating for outdoor use.

**ATTENTION:** Resistance: metallics powder coatings are sensitive to risks and show varying wear depending on the use situation of the parts. The metallic appearance can undergo some changes in situations such as intense handling, contact with chemicals (including some cleaning products), friction between parts or with more abrasive objects.

**Protection:** To protect the film against this wear we recommend the application of a uniform layer of glossy polyester varnish. It should be noted that this procedure reduces the metallic effect to a varying degree, depending on the level of metallization of the paint. For non-glossy finishes it is recommended to test the use of varnishes with lower gloss. Application of a varnish has to be made after a half-cure of a metallic powder coating.

**Application:** Metallic powder coatings should follow strict controls in the application process to reduce variations in color tone. Such variations occur when there is a variation of the gun tension, the applied layer thickness, the air flow, the application method and also the form and type of substrate. You should also avoid repainting, using recovered powder and the presence of different dough parts in the same oven. Baking conditions (time, temperature, distribution of parts) can also cause differences in the metallic effect.

In short, each applicator must find the best parameters for a more homogeneous result.

### CHARACTERISTICS:

|                          |                                                                                                       |
|--------------------------|-------------------------------------------------------------------------------------------------------|
| <b>Resin:</b>            | Polyester                                                                                             |
| <b>Specific gravity:</b> | 1,28 ± 0,10 g/cm <sup>3</sup>                                                                         |
| <b>Stability:</b>        | 12 month (max. 30°C)                                                                                  |
| <b>Observations:</b>     | Free of heavy metals and other substances provided for in Directive 2015/863 EU of 03/31/2015 (RoHS). |

### APPLICATION CHARACTERISTICS:

|                                                                                 |                                                                              |
|---------------------------------------------------------------------------------|------------------------------------------------------------------------------|
| <b>Surface:</b>                                                                 | Ferrous and non-ferrous                                                      |
| <b>Surface preparation:</b>                                                     | Ferrous : Phosphatization<br>Non-ferrous: Chromatization or phosphatization* |
| <b>Cure conditions:</b>                                                         | 10 minutes at 200°C                                                          |
| <b>Thickness:</b>                                                               | 60 - 80 µm                                                                   |
| <b>Application system:</b>                                                      | Electrostatic gun                                                            |
| <b>NOTE:</b> See application recommendations at the beginning of this bulletin. |                                                                              |

### AFTER CURE CHARACTERISTICS:\*\*\*

| TEST                        | METHOD               | SPECIFICATION    |
|-----------------------------|----------------------|------------------|
| ADHESION                    | ASTM D 3359          | Maximum GR0      |
| GLOSS @ 60°                 | ASTM D 523           | Visual standard  |
| IMPACT (REVERSE)            | ASTM 2794            | Minimum 50 kg.cm |
| FLEXIBILITY (CONIC MANDREL) | ASTM D 790 / ISO 178 | Minimum 3 mm     |

### CHEMICAL RESISTANCE \*\*\*

|                    |                                |
|--------------------|--------------------------------|
| <b>Salt spray:</b> | Minimum 500 h (ASTM B117 – 03) |
| <b>Humidity:</b>   | 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 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.

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Review: 00

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