



**POLITHERM 19 TF R SM ORANGE W RAL 2008 BR**

**Code:** 17863570

**PRODUCT DESCRIPTION**

TGIC-free polyester powder coating with good adhesion, flexibility, and physical and chemical resistance. Offers moderate weathering resistance.

**RECOMMENDED USE**

Coating of metal parts for industrial purposes in outdoor environments.

**PROPERTIES**

There may be, among batches, some variations in the color shade around the pattern exhibited.

**CERTIFICATIONS AND APPROVALS**

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

**PACKAGING**

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

**CHARACTERISTICS OF MANUFACTURED PRODUCT**

<b>Resin</b>	Polyester
<b>Gloss</b>	Bright
<b>Finish</b>	Smooth
<b>Specific gravity (± 0,10)</b>	1,68 g/cm <sup>3</sup>
<b>Theoretical Coverage</b>	116.2 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 Non-ferrous: Chromatization or phosphatization
<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>	2.8 mils - 3.5 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
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<b>Adhesion</b>	Maximum GR0 (ASTM D3359)
<b>Gloss</b>	80 UB - 100 UB (ASTM D523)
<b>Impact</b>	Minimum 35 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 500h (ASTM D2247)
<b>Salt spray</b>	Minimum 300h (ASTM B117)

**NOTE:**

In the chemical resistance tests, the substrate used was steel sheet treated with tricationic phosphate. Mechanical resistance tests were performed on degreased plain steel sheet under the curing conditions and coating specific to the product. 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.