POLITHERM 25 R SM GRAY N 6,5 BR

PRODUCT: 10005677

DESCRIPTION / USES: Epoxy powder coating for indoor use on metallic parts. Meets the specifications of the standard Petrobrás N-2841-Rev B, when used as epoxy primer according to item 6.5 of the said standard

CHARACTERISTICS:

Resin:	Epoxy
Specific gravity:	1,62 ± 0,10 g/cm^3
Stability:	06 months (máx. 30ºC)
Observations:	Free of heavy metals and other substances provided for in Directive 2015/863 EU of 03/31/2015 (RoHS)

APPLICATION CHARACTERISTICS:

Surface:	Ferrous and non-ferrous
Surface preparation:	Ferrous: Phosphatization Non-ferrous: Chromatization or phosphatization
Cure conditions (Temperature in Metal)	
Single layer system**	5 minutes at 200 ºC
Primer system as finish***	5 minutes a 160ºC (See additional information)
Thickness:	90 – 100 µm
Application system:	Electrostatic gun

AFTER CURE CHARACTERISTICS****:

TEST	METHOD	SPECIFICATION
ADHESION	ASTM D 3359	: GR0
GLOSS at 60°	ASTM D 523	: Minimum 85 UB
IMPACT (REVERSE)	ASTM 2794	: Minimum 50 kg.cm
FLEXIBILITY (CONIC MANDREL)	ASTM D 790 / ISO 178	: Maximum 3 mm
PENCIL HARDNESS	ASTM D 3363	: Minimum HB

CHEMICAL RESISTANCE *****

Salt spray:	: Minimum 2000 h (ASTM B117 – 03)
Humidity:	: Minimum 1500 h (35ºC)

*Norma Petrobrás N 2841 Rev B: In case of attendance to the standard observe the conditions of item 4.2.1 of the same.

** **Single layer system:** Complete curing of the powder coating according to the indicated cycle.

*** **Primer system as finish:** When the 10005677 is used as primer, with subsequent application of finishing, it is recommended to pre-cure from 5 minutes to 160 º C, to obtain complete adhesion between layers. The pre-cure can be done in different times and temperatures but never below 150 º C or above 170 º C. Divergent values compromise the final result. It should also not exceed the period of 48 hours to apply the finish, at the risk of compromising adhesion between layers. Simultaneous curing of different pasta parts is not recommended.

*****The tests of mechanical resistance were carried out on common steel plate degreased in curing conditions and specific layer for the product. The values may vary according to the substrate used.

In the chemical resistance tests, the substrate used was a steel plate treated with tricationic phosphate and the 10005677 ink was applied as a primer in 90-100 µm followed by polyester paint (Politherm superdurable series), applied as finishing, in a layer of 80- 100 µm as specified by the standard Petrobrás N-2841-Rev B - type III coating.

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.