

## POLITHERM 55 HB R LI GRAY PRIMER C5H 11835 SB

**PRODUCT:** 16371521

**DESCRIPTION / USES:** Coating of metal parts for internal use or as a primer in paint planes. Product is an epoxy that has raw materials that have anticorrosive properties and that provide characteristics to meet in one hand the degree of corrosivity C5 High of ISO-12944-6 (2018).

### CHARACTERISTICS:

<b>Resin:</b>	Epoxy
<b>Specific gravity:</b>	1,59 ± 0,10 g/cm <sup>3</sup>
<b>Stability:</b>	06 months (máx. 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 Non-ferrous: Chromatization or phosphatization*
<b>Cure conditions:</b>	5 minutes at 200 °C**
<b>Thickness:</b>	120 – 160 µm
<b>Primer system with finish:</b>	5 minutes at 160°C *** (see additional information)
<b>Application system:</b>	Electrostatic gun

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

TEST	METHOD	SPECIFICATION
ADHESION	ASTM D 3359	GR0
GLOSS @ 60°	ASTM D 523	70 - 100 UB
IMPACT (REVERSE)	ASTM 2794	Min. 40 kg X cm
FLEXIBILITY (CONIC MANDREL)	ASTM D 790 / ISO 178	Max. 3 mm

### CHEMICAL RESISTANCE \*\*\*

<b>Salt spray:</b>	Mínimo 1440 h (ISO-9227)
<b>Cyclic corrosion:</b>	Mínimo 1680 h (ISO 12944-6 – anexo B)
<b>Wet chamber:</b>	Min. 1000 h (35°C)

\* In case of phosphating of Non-Ferrous Metals, consult our Technical Department.

\*\* Monolayer system: Complete curing of the ink according to the indicated cycle.

\*\*\* Primer system with finish: When using the 16371521 as a primer, with subsequent application of finishing, it is recommended to pre-cure 5 minutes at 160°C, to obtain a complete support between layers. Pre-curing can be done at different times and temperatures, but never below 150°C or above 170°C. Divergent values compromise the final result. You should also not exceed the 48-hour period to apply the finish, at the risk of compromising the connection between layers. Healing is not recommended simultaneous of different parts of mass. The established time/temperature required to obtain the pre-curing of the pieces with greater metallic mass causes overnose in the thinner pieces causing support problems. Handling of parts should be avoided. If this procedure is necessary it should be done with gloves that do not release fibers.

\*\*\*\* Mechanical strength tests were performed on common degreased steel sheet under product-specific curing and coating conditions. The values may vary depending on the substrate used.

\*\*\*\*\* In the chemical resistance tests the substrate used was hot-rolled steel sheet with shot blast Sa 2 1/2.

**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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