



POLITHERM 96 WFQ R ME-GRAY ARDO W RAL 9023 MA

PRODUCT: 15593925

QUALICOAT P-1717

DESCRIPTION / USES: Coating for architectural aluminum and galvanized steel, suitable for outdoor use. Politherm 96 WQF Series is Qualicoat certified in Class 1, gloss category 1. ABNT NBR 14125.

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:

Resin:	Poliéster
Specific gravity:	1,24 ± 0,10 g/cm ³
Shelf life:	12 month (max. 86°F)
Observations:	Free of heavy metals and other substances provided for in Directive 2015/863 EU of 03/31/2015 (RoHS).

APPLICATION CHARACTERISTICS:

Surface:	Aluminum, galvanized steel
Surface preparation:	Aluminum: Chromatization or chrome free chromatization Galvanized steel: Phosphatization (zinc or tricationic)
Cure conditions:	15 a 20 minutes at 374°F 10 a 15 minutes at 392°F
Thickness:	2,4 - 3,2 mils
Application system:	Electrostatic gun

AFTER CURE CHARACTERISTICS:***

TEST	METHOD	SPECIFICATION
ADHESION	ASTM D 3359	Maximum GR0
GLOSS @ 60°	ASTM D 523	Visual Standard
IMPACT TEST (15,9mm diameter indenter)	ASTM 2794	Minimum 43 Lb.in
CUPPING TEST	EN ISO 1520	Minimum 5 mm
INDENTATION	EN ISO 2815	Minimum 80
BEND TEST (5 mm diameter cilinder)	EN ISO 1519	No cracking or detachment
FLEXIBILITY (CONIC MANDREL)	ASTM D 790 / ISO 178	Maximum 3 mm

CHEMICAL RESISTANCE ***

Salt spray:	Minimum 1000 h (ASTM B117 – 03)
Humidity:	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 aluminium panels in accordance with the cure and thickness specifications. The results may vary, depending on the surface characteristics. For chemical resistance testing, panels were degreased and treated with tricationic phosphat.

IMPORTANT: 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.

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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