

## POLITHERM 20 R SM GRAPHITE 10342 MA

**PRODUCT:** 13577768

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

**CHARACTERISTICS:**

**Resin:** Epoxy / polyester  
**Specific gravity:** 1,81 ± 0,10 g/cm<sup>3</sup>  
**Stability:** 12 month (máx. 30°C)  
**Observations:** Free of heavy metals according to RoHS Directive 2002/95/CE of 01/27/2003

**APPLICATION CHARACTERISTICS:**

**Surface:** Ferrous and non-ferrous  
**Surface preparation:** Ferrous: Phosphatization  
 Non-ferrous: Chromatization or phosphatization\*  
**Cure conditions:** 10 minutes at 200 °C\*\*  
**Thickness:** 60 – 80 µm  
**Application system:** Electrostatic gun  
**Note:** We recommend the following cure and application procedures to reduce color and metallic changes.  
 - Avoid recovered powder.  
 - Avoid application on previously coated parts.  
 - Avoid time and temperature variations during baking. It can happen when set parameters of the oven are changed, or when parts with different mass are cured in the same baking.

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

TEST	METHOD	SPECIFICATION
ADHESION	WPS-3905	GR0
GLOSS	WPS-3854	30 ± 3 UB
IMPACT (REVERSE)	WPS-4130	Min. 50 kg X cm
FLEXIBILITY (CONIC MANDREL)	WPS-4856	Max. 3 mm

**CHEMICAL RESISTANCE \*\*\***

**Salt spray:** Min. 500 h (ASTM B117 – 73)  
**Humidity:** Min. 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 tricaticonic 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.

**COPY FOR INFORMATION**

**WEG TINTAS LTDA - CNPJ 12.006.058/0001-21**  
 Matriz: Rodovia BR 280, Km 50 - Fone: (+55) (47) 3276-4000 - Fax: (+55) (47) 3276-5500 - CEP 89270-000 - Guaramirim – SC  
**Filial: INDÚSTRIA DE TINTAS E VERNIZES PAUMAR LTDA – CNPJ 60.621.141/0001-53**  
 Rua Dr. Ulisses Guimarães, 800 - Fone: +55 (11) 4547-6100 – CEP 09372-050 - Mauá – SP  
 EMERGÊNCIA: (+55) (11) 5012-5311 - E-mail: [tintas@weg.net](mailto:tintas@weg.net) - [www.weg.net](http://www.weg.net)