

## POLITHERM 96 R ME- GRAY W RAL 9006 MA

**PRODUCT:** 15851828

### QUALICOAT P-1717

**DESCRIPTION / USES:** Polyester powder coating.  
Surfaces exposed to outdoor environment.  
Coating for architectural aluminum and galvanized steel, suitable for outdoor use. Politherm 96 WQF Series is Qualicoat certified in Class 1, gloss category 1.

**ATTENTION:** **Resistance:** Metallic coatings are sensible to scratches and can present decreased effect when in contact with humidity and regular cleaning products. The metallic effect undergoes major changes in case of intense handling, contact with chemicals (including some more aggressive cleaning products) and friction between parts or abrasive objects.  
**Protection:** It's recommended applying a uniform layer of clear coat to protect this film against wear. It should be noted that this procedure reduces the metallic effect and this reduction is variable depending on the original level of metallic effect. It is recommended pre-testing the use of the clear and this clear must be applied after a partial cure of the metallic coating.  
**Application:** Metallic powder coatings should follow strict controls in the application process in order to reduce tonal variations. This occurs when there is variation in any one of the following: gun voltage, thickness, airflow, and way of application, substrate and sharp of the part. One should also avoid the following: recoating, re-use of recovered coating, presence of different mass parts in the same curing batch. The curing conditions (temperature/time/parts distribution) may also cause differences in metallic effect.  
The gloss and the color of this coating are also sensitive to curing conditions. Changes from standard can be avoided by running the correct cure cycle (temperature, time and parts distribution).  
In short, each applicator should find the best parameters for a more homogeneous result.

### CHARACTERISTICS:

<b>Resin:</b>	Polyester
<b>Specific gravity:</b>	1,26 ± 0,10 g/cm <sup>3</sup>
<b>Stability:</b>	12 month (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>	Aluminum, galvanized steel
<b>Surface preparation:</b>	Aluminum: Chromatzation or chrome free chromatzation Galvanized steel: Phosphatzation (zinc or tricaticonic)
<b>Cure conditions:</b>	15 at 30 minutes at 190 °C* 10 at 15 minutes at 200 °C*
<b>Thickness:</b>	60 – 80 µm
<b>Application system:</b>	Electrostatic gun

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

TEST	METHOD	SPECIFICATION
ADHESION	WPS-3905, EN ISO 2409,	: Grade 0
GLOSS @ 60°	WPS-3854, EN ISO 2813	: Visual std.
IMPACT TEST (15,9mm diameter indenter)	WPS-4130, ASTM D 2794	: Min 50 kg.cm (4,90 Nm)
CUPPING TEST	WPS-3804, EN ISO 1520	: Min. 3 mm
INDENTATION	WPS-4899, EN ISO 2815	: Min. 80
BEND TEST (5 mm diameter cilinder)	WPS-4823, EN ISO 1519	: No cracking or detachment
FLEXIBILITY (conic mandrel)	WPS-4856	: Max 3 mm

### CHEMICAL RESISTANCE \*\*\*

<b>Salt spray:</b>	Min. 1000 h (EN ISO 9227)
<b>Humidity:</b>	Min. 1000 h (EN ISO 6270)

## TECHNICAL INFORMATIONS – POWDER COATINGS

\* After stabilization on correct temperature (metal temperature).

\*\* Chemical resistance tests were performed using chromatized aluminum panels. Mechanical strength tests were performed on degreased aluminum panels. Values may vary depending on the substrate and pre-treatment.

**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.

