



## POLITHERM 20 TX ORANGE 2,5YR 6/14 BR

**PRODUCT:** 10005419

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

**ATTENTION:** For the formation of the original texture of the product, it is mandatory that the curing oven is preheated to the curing temperature indicated in this bulletin.

### CHARACTERISTICS:

**Resin:** Epoxy / Polyester  
**Specific gravity:** 1,57 ± 0,10 g/cm<sup>3</sup>  
**Stability:** 12 month (max. 30°C)

### APPLICATION CHARACTERISTICS:

**Surface:** Ferrous and non-ferrous  
**Surface preparation:** Ferrous : Phosphatization  
 Non-ferrous: Chromatization or phosphatization\*  
**Cure conditions:** 10 minutes at 200°C  
**Thickness:** 70 - 90 µm  
**Application system:** Electrostatic gun

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

TEST	METHOD	SPECIFICATION
ADHESION	ASTM D 3359	Maximum GR0
GLOSS @ 60°	ASTM D 523	Visual standard
IMPACT (REVERSE)	ASTM 2794	Minimum 40 kg.cm
FLEXIBILITY (CONIC MANDREL)	ASTM D 790 / ISO 178	Minimum 5 mm

### CHEMICAL RESISTANCE \*\*\*

**Salt spray:** Minimum 500 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 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 tricationic 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.

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Review: 01

Date: 7/08/22