

POLITHERM 54 HB R SM GRAPHITE W RAL 7024 BR**Code:** 19231137**PRODUCT DESCRIPTION**

Epoxy powder coating for high-build application with excellent adhesion, physical and chemical resistance, as well as good edge coverage. Excellent anticorrosive protection and low resistance to yellowing.

RECOMMENDED USE

Coating of metallic surfaces for use in corrosive or chemically aggressive environments, indoors or sheltered. Suitable for achieving layers above 100 micrometers in a single cold application.

PROPERTIES

The product should preferably be applied to abrasive blasted metal sheets, where it is easier to achieve the specified film thickness. Another factor that influences film thickness is the complexity of the part's geometry. As it is a technical application, the presence of surface imperfections such as pinholes and orange peel (or less distinct texture in textured coatings) may be found, without impairing the performance of the coating.

CERTIFICATIONS AND APPROVALS

Free from heavy metals and other substances provided for in RoHs Directive 2015/863 EU of 31/03/2015.

PACKAGING

Cardboard box with 55 lb in high-density polyethylene bag.

CHARACTERISTICS OF MANUFACTURED PRODUCT

Resin	Epoxy
Gloss	Bright
Finish	Smooth
Specific gravity ($\pm 0,10$)	1,53 g/cm ³
Theoretical Coverage	127.6 ft ² /lb at 1.0 mil
Mass loss during cure	Maximum 2%
Moisture content	Maximum 0.6%
Shelf life	12 months
Storage condition	It must be stored in closed containers, in cool, dry and covered places, at an ambient temperature not exceeding 86°F.

APPLICATION CHARACTERISTICS

Substrate	Ferrous metals Non-ferrous metals
Surface preparation	Ferrous : Phosphatization or nanoceramic Non-ferrous: Chromatization or nanoceramic
Surface cleaning	The performance of this product is related to the degree of surface preparation. The surface must be clean, dry and free of any contaminants. Completely remove oils, grease and fats.
Thickness	4.7 mils - 5.5 mils
Cure conditions	10 min à 392 °F (metal temperature).
Cure windows	15 min - 25 min at 356 °F 12 min - 20 min at 374 °F 10 min - 18 min at 392 °F 8 min - 15 min at 410 °F
Application system	Electrostatic spray gun corona

NOTE:

For non-ferrous metals phosphatizing, please contact our technical service.



CHARACTERISTICS OF APPLIED PRODUCT		
	Test	Specification/Standard
	Adhesion	5B (ASTM D 3359)
	Gloss 60°	65 - 75 (ASTM D523)
	Impact	Minimum 43 lb.in (ASTM D2794)
	Flexibility (conic mandrel)	Maximum 1/8 in (ASTM D790)
CHEMICAL RESISTANCE CHARACTERISTICS		
	Test	Specification/Standard
	Humidity	Minimum 3000h (ASTM D2247)
	Salt spray	Minimum 2000h (ASTM B117)
NOTE:	In the chemical resistance tests, the substrate used was cold-rolled steel sheet with tricationic phosphate. The mechanical resistance tests were performed on degreased common steel sheet under specific curing and coating conditions for the product. The values may vary depending on the substrate used.	
SAFETY PRECAUTIONS		
	Guidance is available in the product's Safety Data Sheet (SDS).	
NOTE	The information provided herein is based on our testing and experience and is intended to inform you about the product and its possible applications. The information provided in this bulletin is not intended to be complete, and the user assumes the risk of using the product for a purpose other than the specifications recommended in this bulletin without first obtaining our written confirmation of its suitability for the intended purpose. While we strive to ensure the accuracy of the information provided herein, we cannot control the quality or condition of the substrate, nor any other factors that affect the use and application of this paint. Therefore, unless we agree in writing to any condition that deviates from our recommendations, we accept no liability that may arise regarding the performance of this product. The information contained in this bulletin is subject to change without notice, based on our experience and policy of continuous development.	