

## POLITHERM 25 R SM GRAY PRIMER ACE 10629 SB

**PRODUCT:** 15141489

**DESCRIPTION / USES:** Epoxy powder coating for indoor use on metallic parts.

### CHARACTERISTICS:

|                          |                                                                                                       |
|--------------------------|-------------------------------------------------------------------------------------------------------|
| <b>Resin:</b>            | Epoxy                                                                                                 |
| <b>Specific gravity:</b> | 1,55 ± 0,10 g/cm <sup>3</sup>                                                                         |
| <b>Stability:</b>        | 6 months (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>             | Ferrous and non-ferrous                                                     |
| <b>Surface preparation:</b> | Ferrous: Phosphatization<br>Non-ferrous: Chromatization or phosphatization* |
| <b>Cure conditions:</b>     | 5 minutes at 200 °C**                                                       |
| <b>Thickness:</b>           | 50 – 70 µm                                                                  |
| <b>Application system:</b>  | Electrostatic gun                                                           |

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

| TEST                        | METHOD               | SPECIFICATION        |
|-----------------------------|----------------------|----------------------|
| ADHESION                    | ASTM D 3359          | : GR0                |
| GLOSS at 60°                | ASTM D 523           | : 50-70 UB           |
| IMPACT (REVERSE)            | ASTM 2794            | : Minimum 50 kg X cm |
| FLEXIBILITY (CONIC MANDREL) | ASTM D 790 / ISO 178 | : Maximum 3 mm       |

### CHEMICAL RESISTANCE \*\*\*

|                    |                                  |
|--------------------|----------------------------------|
| <b>Salt spray:</b> | : Minimum 500 h (ASTM B117 – 03) |
| <b>Humidity:</b>   | : 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.

This product is not suitable for parts intended to be glued using silicon glue.

**STORAGE:** Fresh, dry and covered place.