

## POLITHERM 46 WF R PE- GRAY SKY 10562 UM

**PRODUCT:** 14718131

**DESCRIPTION / USES:** Resistance: metallics powder coatings are sensitive to risks and show varying wear depending on the use situation of the parts. The metallic appearance can undergo some changes in situations such as intense handling, contact with chemicals (including some cleaning products), friction between parts or with more abrasive objects.  
 Protection: To protect the film against this wear we recommend the application of a uniform layer of glossy polyester varnish. It should be noted that this procedure reduces the metallic effect to a varying degree, depending on the level of metallization of the paint. For non-glossy finishes it is recommended to test the use of varnishes with lower gloss. Application of a varnish has to be made after a half-cure of a metallic powder coating.  
 Application: Metallic powder coatings should follow strict controls in the application process to reduce variations in color tone. Such variations occur when there is a variation of the gun tension, the applied layer thickness, the air flow, the application method and also the form and type of substrate. You should also avoid repainting, using recovered powder and the presence of different dough parts in the same oven. Baking conditions (time, temperature, distribution of parts) can also cause differences in the metallic effect.  
 In short, each applicator must find the best parameters for a more homogeneous result.

### CHARACTERISTICS:

<b>Resin:</b>	Polyester
<b>Specific gravity:</b>	1,55 ± 0,10 g/cm <sup>3</sup>
<b>Stability:</b>	12 month (max. 30°C)
<b>Observations:</b>	Free of heavy metals according to the RoHS Directive 2011/65/UE of 08/06/2011

### APPLICATION CHARACTERISTICS:

<b>Surface:</b>	Ferrous and non-ferrous
<b>Surface preparation:</b>	Ferrous : Phosphatization Non-ferrous: Chromatization or phosphatization*
<b>Cure conditions:</b>	10 minutes at 200 °C**
<b>Thickness:</b>	60 – 80 µm
<b>Application system:</b>	Electrostatic gun

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

TEST	METHOD	SPECIFICATION
ADHESION	ASTM D 3359	: GR0
GLOSS @ 60°	ASTM D 523	: 10 ± 3 UB
FLEXIBILITY (CONIC MANDREL)	ASTM D 790 / ISO 178	: Max 3 mm
IMPACT (REVERSE) (allows microcracks)	ASTM D 2794	: Min 50 kg X cm

Note: Due to the fact that the product contains high metallization, it may present microcracks after the impact test. However, it should not show signs of peeling when using the tack tape.

### CHEMICAL RESISTANCE \*\*\*

<b>Salt spray:</b>	: Min. 500 h (ASTM B117 – 03)
<b>Humidity:</b>	: Min. 1000 h (35°C)

## TECHNICAL INFORMATIONS – POWDER COATINGS

\* 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 results may vary, depending on the surface characteristics. For chemical resistance testing, panels were degreased and treated with tricationic phosphat.

**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.

