



**POLITHERM 86 WFS R ME ORANGE W RAL 2013 MA**

**Code:** 19429970

**PRODUCT DESCRIPTION**

Superdurable polyester powder coating with good chemical resistance and excellent adhesion, flexibility and yellowing resistance. It has excellent weathering resistance with greater gloss and color retention than other polyester-based coatings.

**RECOMMENDED USE**

Coating of metal surfaces for use outdoors where extra durability against the weather effects is required.

**PROPERTIES**

Metallic coatings are sensitive to scratches and exhibit variable wear, depending on the usage of the parts. The metallic appearance may change in situations such as heavy handling, contact with chemicals (including some cleaning products), friction between parts or with abrasive objects. To protect the film from wear, we recommend the application of a uniform layer of glossy polyester powder varnish. Note that this procedure diminishes the metallic effect to a varying degree, depending on the level of metallization of the paint. For non-glossy finishes, it is recommended to previously test the use of varnishes with lower gloss. It is recommended to test the use of varnishes beforehand, and the varnish should be applied after the metallic paint has partially cured.

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.

**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**

<b>Resin</b>	Polyester
<b>Gloss</b>	Matte
<b>Finish</b>	Metallic
<b>Specific gravity (± 0,10)</b>	1,52 g/cm³
<b>Theoretical Coverage</b>	128.5 ft²/lb at 1.0 mil
<b>Mass loss during cure</b>	Maximum 2%
<b>Moisture content</b>	Maximum 0.6%
<b>Shelf life</b>	12 months
<b>Storage condition</b>	It must be stored in closed containers, in cool, dry and covered places, at an ambient temperature not exceeding 86°F.

**APPLICATION CHARACTERISTICS**

<b>Substrate</b>	Ferrous metals Non-ferrous metals
<b>Surface preparation</b>	Ferrous : Phosphatization or nanoceramic Non-ferrous: Chromatization or nanoceramic
<b>Surface cleaning</b>	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.
<b>Thickness</b>	3.1 mils - 3.9 mils
<b>Cure conditions</b>	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**

<b>Test</b>	<b>Specification/Standard</b>
<b>Adhesion</b>	5B (ASTM D 3359)
<b>Gloss 60°</b>	4 - 9 (ASTM D523)
<b>Impact</b>	Minimum 43 lb.in (ASTM D2794)
<b>Flexibility (conic mandrel)</b>	Maximum 1/8 in (ASTM D790)

**CHEMICAL RESISTANCE CHARACTERISTICS**

<b>Test</b>	<b>Specification/Standard</b>
<b>Humidity</b>	Minimum 2000h (ASTM D2247)
<b>Salt spray</b>	Minimum 1200h (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.