



POLITHERM 29 TF R SM GRAY W RAL 7040 MA

Code:		19107110
PRODUCT DESCRIPTION		
		TGIC-free polyester powder coating with good adhesion, flexibility and chemical resistance. It has high physical resistance and good weathering resistance.
RECOMMENDED USE		
		Coating of metal parts for industrial purposes in outdoor environments.
PROPERTIES		
		Enhanced with additives to reduce baking time and/or temperature.
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	Polyester	
Gloss	Matte	
Finish	Smooth	
Specific gravity (± 0,10)	1,69 g/cm³	
Theoretical Coverage	115.5 ft²/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	2.4 mils - 3.1 mils	
Cure conditions	10 min à 356 °F (metal temperature).	
Cure windows	15 min - 25 min at 338 °F 10 min - 20 min at 356 °F 7 min - 15 min at 374 °F 5 min - 12 min at 392 °F	
Application system	Electrostatic spray gun corona	
NOTE:		
		For non-ferrous metals phosphatizing, please contact our technical service.



Adhesion	5B (ASTM D 3359)
Gloss 60°	25 - 30 (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 1500h (ASTM D2247)
Salt spray	Minimum 700h (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.