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TECHNICAL DATA SHEET

DURPOL E 6L4870013T000 (EX 6048A7001) PRIMER GREY SM M TS HMF X R7001

Composition

Powder based od epoxy resins hardened in stoichiometrically relation with appropriate hardeners and suitable exclusively for indoor pieces

Recommended uses

Powder indicated for a wide range of artefacts having excellent aesthetic finishing level and good resistance to chemical agents such as: machine tools whether in direct touch with lubricant oils and emulsions, metallic furniture, and so on.They can be used as primer for two hands cycles powder-powder and powder-liquid. In order to obtain an excellent protection, it is necessary to spray an average thickness of 70- 80 micron.

Substrate pre-treatment

Powders adhere to most metal surfaces provided these are dry, clean and degreased. A chemical pre-treatment of the surface is required in order to improve the resistance against the corrosion, based on the kind of metallic support.

Application

This powder is suitable for use with electrostatic spraying equipments whose voltage is between 40 and 90 KV. Where acronym "TS" is present, our products are working also with triboelectical guns.
A difference of thickness of applied coating can generate modification of the appearance of hardened coating.In case of products having special effects, the use of overspray is not advised except for bonded products.

Polymerization conditions

180°C x 15 min. (piece temperature)

Characteristics after polymerization (application on steel panel)

Erichsen Drawing:	>= 5 mm	ISO 1520
Mandrel Bend Test:	>= 4 mm	ISO 1519
Impact Resistance:	>= 2,5 Nm	ASTM D2794
Buchholz Hardness:	>= 80	ISO 2815
Cross Cut Test:	Gt0	ISO 2409
Gloss 60°:	L=80-100 gloss; SL=60-80 gloss; SO=30-60 gloss; O=10-30 gloss; OO=0-10 gloss	ISO 2813

Chemical resistance

The product has good resistance to most 10% acids and to ethylalcohol at room temperature (25°C).
For specific requests we invite you to contact our technical assistance.

Corrosion resistance (application on iron-phosphate bonder)

Humidity Chamber:	After 500 hours no change.	ISO 6270
Kesternich:	After 10 cycles no loss of adhesion.	ISO 3231
Salt Spray:	After 1500 hours < 1 mm penetration.	ISO 9227

Accelerated ageing (QUV-B) (313 nm) with QUV/SE cycle 4 hours, condensation at 40°C/4 h irradiation 50°C (0,75 W/m²/nm. Application on aluminium panel)

Test:

Storage

A storage life of at least 6 months from date of loading can be expected provided the boxes remain sealed and stored in a cool dry area below 30°C.

Notes:

* The above data are the results of careful researches and our long experience, nevertheless considering the large number of factors concurring to determine the values in the present technical data sheet, the utilizer will have the duty to effect the best conditions so as to get the best result.
* This product is destined only to professional applicators working in an industrial installation. The manipulation of the product from the utilizer must be conform to laws concerning the use of powder coatings and to information described in our technical data sheet sent together with the product itself.

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