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TECHNICAL DATA SHEET

PURAL PES 7D2500003TM01 (EX 5510A6548) BLACK COPPER TEXT/MET OX HG TS TF HMF X

Composition

Special effect powder based on polyester carboxylated saturated resins and hardeners alternative to TGIC and formulated with pigments and additives suitable to reach good resistance characteristics to UV rays and weathering agents. Nevertheless, this product is additivated with metallic oxidable pigments and if in direct contact with weathering agents, it may lose its metal effect; if in case of outdoor exposition, it is necessary to protect the powder with a second hand of polyester or polyurethane transparent powder.

Recommended uses

Powder indicated for coating of outdoor artifacts where good resistance characteristics to chalking and UV rays are requested. Therefore it can be used for coating of garden furniture, lighting elements and bodies for agricultural and industrial machinery. It is unfit for architecture. The presence of metallic pigments may not guarantee the maintenance of the metallic effect during aging tests and when in contact with oxidizing chemical agents. In order to obtain an excellent protection, it is necessary to spray an average thickness of 80 - 100 microns.

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 20 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°:	Non applicabile.	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 1000 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:	Not applicable.

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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