

Technical data sheet

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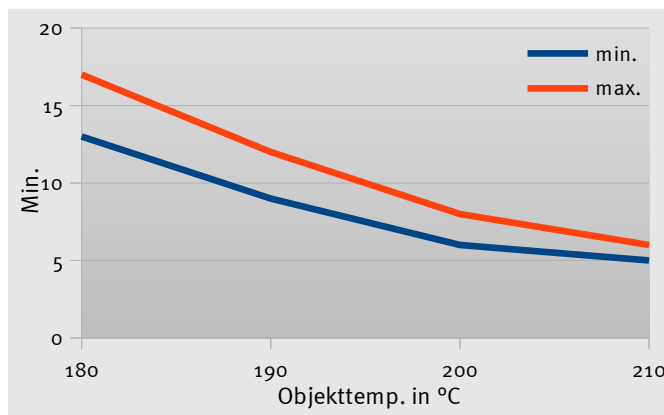
POLYFLEX® PES-50 rough structure Corona matt

Powder paint with rough structure for interior use on the basis of polyester and epoxy resins with excellent covering power and good resistance to chemicals. Curing can take place above 180 ° C.

Applications	Metal furniture, shelves elements, machine casing and many more	
Colours	Many colours, white and very bright shades are not recommended	
Surface	Structure rough	
Gloss	Visual matt	
Powder properties	Particle size distribution	smaller 29 µm: 38 – 45% <small>(HELOS H1708)</small> smaller 122 µm: 98 – 100%
	Density	1.3 – 1.7 g/cm ³ can vary depending on the colour, can be specified per colour individually on request
Material consumption	g/m ² =	Density (g/cm ³) x Film thickness (µm)
Coating thickness	Recommended	80 – 100 µm depending on the colour
	Maximum	150 µm
Application	The application can be made with the usual electrostatic powder coating systems. The powder tends to yellowing, the baking process is therefore devote most attention. Please read our application instruction for structured powder VRoo1D. To avoid any surfaces disturbances, we recommend not to mix this type of powder with any other powder paint.	
Packaging	<ul style="list-style-type: none"> - 20/25 kg cardboard - 500 kg Octobox - 450/500 kg Big Bag Other packaging variations are available on request.	

Baking diagram

Curing time recommendation: 13 min. by 180 ° C object temperature



Curing conditions:

210°C	4 min. hold time
200°C	6 min. hold time
190°C	8 min. hold time
180°C	13 min. hold time

Substrates

Various metals or as top coat on a KTL pre-treated surface. The support to be coated has to be free of oil, grease and oxidation products. Under exposure to corrosion, we recommend the following pre-treatments:

Aluminium a suitable chemical pretreatment
Steel/Iron Iron or zinc phosphating

The pre-treatment can both be applied with dipping or spraying methods.

Physical properties

tested on:

steel sheet 0.8mm ST1405
double pickled V1094

Film thickness
80 – 100 µm

Cross cut test GT 0
(DIN ISO 2409)

Mandrel bending test ≤ 8 mm
(DIN ISO 1519)

Impact resistance front ≥ 5 Nm (~44 inchpound)
ASTM D 2794 reverse ≥ 2.5 Nm (~22 inchpound)

Erichsen cupping ≥ 2mm
(DIN ISO 1520)

Resistance

tested on:

iron phosphate steel sheet

Condensation water test 500 h no bubble building
DIN ISO 6270 Infiltration on the scratch track under 1 mm

Salt spray test 240 h no bubble building
DIN ISO 9227 Infiltration on the scratch track under 1 mm

Post treatment of coated parts

To print, label, foil laminating, over coating and any other post-treatment, some preliminary testing is recommended. For packaging, only use appropriate plasticizers free materials. Condensation must be avoided.

Repairs

For repairs (conveyors hangers touch ups) the repair kit, Art. No 12155 is available

Storage

Storage instruction In the original containers, store in a cool and dry environment by max. 25° C. No direct sun exposure.

Shelf life 18 months from the date of production under the mentioned conditions.

Safety recommendations

Lower explosive limit please refer to the safety data sheet

Further information are to find in the safety data sheet and the CEPE booklet „Safe powder coating“ and „Results of experimental toxicology study on thermosetting powder coatings“.

Comments

The information on this technical data sheet relative to the properties and application of the product in question are made on hand of our knowledge, development and practical experience. Because of the multiple possible applications, it is impossible for us to present them all in detail. Our technical consultants are at your disposal for any question you might have. Furthermore, our general sales and delivery conditions apply.

This technical data sheet is revised periodically. If necessary, our sales department will confirm the validity of this document.



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