

TECHNICAL DATA SHEET

Article No.: 12053
 Leaflet No.: 1767
 Version: 7

POLYFLEX® PES-50 smooth resistant to yellowing Corona silk-matt

Description: Powder paint for interior use on the basis of polyester and epoxy resins with very good smooth and good opacity. Good overbake stability in terms of gloss and yellowing, universal use for indoors.

Applications: Metal ceilings, Metal furniture, shelves elements, machine casings, etc.

Colours: All colours

Surface: Smooth texture

Gloss: Visually silk-matt

Powder properties:

Particle size distribution (HELOS H1708)	smaller 29 µm: 40 – 47 % smaller 122 µm: 98 – 100%
Density	1.3 – 1.7 g/cm ³ can vary depending on the colour; can be specified for each individual colour

Material consumption: g/m² = density (g/cm³) x film thickness (µm)

Coating thickness:

Recommended	70 – 90 µm depending on the colour (in white rather more)
Maximum	150 µm

Application: The application can be made with the usual electrostatic powder coatings systems. To avoid any surface disturbances, we recommend not to mix this type of powder paint with any other powder. Do not burn with other powder coatings together in the same oven.

Packaging:

- 20/25 kg cardboard
- 500 kg Octobox
- 450/500 kg Big Bag

Other packaging variations are available on request.

Curing time:

Recommended	13 min at 180 °C object temperature
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Curing conditions:

Object temperature	Minutes hold time
210 °C	5 min. hold time
200 °C	6 min. hold time
190 °C	9 min. hold time
180 °C	13 min. hold time
170 °C	20 min. hold time

Substrates: Various metals, but primarily 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:

Aluminum	A suitable chemical pretreatment
Steel/Iron	Iron or zinc phosphating

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<p>Physical properties: Tested on: Steel sheet 0.8mm ST1405 double-pickled V1094</p> <p>Layer thickness: 70 – 90 µm</p>	<p>Cross cut test (DIN ISO 2409)</p> <p>Mandrel bending test (DIN ISO 1519)</p> <p>Impact resistance ASTM D 2794</p> <p>Erichsen cupping (DIN ISO 1520)</p> <p>Buchholz hardness (DIN ISO 2815)</p>	<p>GT 0</p> <p>1) ≤ 5 mm</p> <p>1) front ≥ 5.0 Nm (~44 inchpound) 1) reverse ≥ 5.0 Nm (~44 inchpound)</p> <p>1) ≥ 3 mm</p> <p>≥ 90</p>
<p>Resistance: Tested on: steel sheet iron phosphated</p>	<p>Condensation water test DIN ISO 6270</p> <p>Salt spray test DIN ISO 9227</p>	<p>500 h no bubble building Infiltration on the scratch track under 1 mm</p> <p>240 h no bubble building Infiltration on the scratch track under 1 mm</p>
<p>Post treatment of coated parts:</p>	<p>To print, to paste, to label, to laminate with film, over-coating and other post-treatments , some preliminary testing is recommended. For packaging only use appropriate plasticizers free materials. Condensation must be avoided.</p>	
<p>Repairs:</p>	<p>For repairs (conveyors hangers touch ups) the repair kit, art. No 12155 is available.</p>	
<p>Storage:</p>	<p>Storage instruction:</p> <p>Shelf life</p>	<p>In the original containers, store in a cool and dry environment by max. 25 °C. No direct sun exposure.</p> <p>18 months from the date of production under the mentioned conditions.</p>
<p>Safety recommendations.</p>	<p>Lower explosive limit</p>	<p>Please refer to the safety data sheet.</p> <p>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“.</p>
<p>Comments:</p>	<p>The information on this technical data sheet relative to the properties and application of the product concerned 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.</p>	