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TECHNICAL DATA SHEET

Article No.: 13473
Version: 3

POLYFLEX® PES-75-NT coarse structure fast-reacting Tribo/Corona silk gloss

Description:	Low bake powder for indoor use based on polyester and epoxy resins. Gives silk gloss surfaces with rought structure. Stabilized against overcuring and discolouration in directly gas fired ovens.		
Applications:	Metal furniture, shelving parts, machine housings, switching cabinets, lamp housings, kitchen appliances, etc.		
Colours:	Almost any colour with few limitations		
Surface:	Rough structure		
Gloss:	Visually silkgloss		
Powder properties:	**Particle size distribution** (HELOS H1708)	29 µm: 38 – 45 % 122 µm: 98 – 100 %	
	Density	1.4 – 1.8 g/cm³ 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**	80 – 100 depending on the colour tone	
	Maximum	150 µm	
Application:	The application can be made with all standard powder coating systems. This type of textured powder is very sensitive to foreign powder dust (colored stains) and can cause craters in smooth powder coatings. In order to achieve a uniform texture, the recommended coating thickness must be adhered to. If the coating thickness is too low, pores will form down to the substrate. Please read our processing instructions for textured powder coatings VR001D. To avoid surface defects, we recommend not mixing this type of powder coating with other powder coatings.		
Packaging:	- 20/25 kg cardboard box - 500 kg Octobox - 450/500 kg Big Bag Other packaging variations are available on request.		
Curing time:	**Recommended** 10 min. at 160°C object temperature		

Object temperature	Minutes hold time min	Minutes hold time max
200°C	3 min	5 min
190°C	4 min	7 min
180°C	5 min	9 min
170°C	7 min	13 min
160°C	10 min	18 min
150°C	13 min	25 min

Substrates:	Various metals or also as a top coat, e.g. on a KTL primer. The substrate to be coated must be free of oil, grease and oxidation products. We recommend the following pre-treatments under load:	
	Aluminium	A suitable wet-chemical pretreatment or sweeping
	Steel	Iron or zinc phosphating
Physical properties:	Tested on 1): Steel panel 0.8 mm ST1405 pickled twice V1094 Layer thickness: 80 – 100 µm	

KARL BUBENHOFER AG | Hirschenstrasse 26 | 9201 Gossau SG, Switzerland
T +41 71 387 41 41 | info@kabe-farben.ch | kabe-farben.ch

	Cross Cut test (DIN ISO 2409)	1) GT 0		
	Mandrel bending test (DIN ISO 1519)	1) ≤ 5 mm		
	Impact resistance (ASTM D 2794)	1) front	≥ 10 Nm	(~88 Inchpound)
		1) reverse	≥ 10 Nm	(~88 Inchpound)
	Erichsen cupping (DIN ISO 1520)	1) ≥ 8 mm		
Resistance:	Tested on: Steel panel iron phospated			
	Condensation water test (DIN ISO 6270)	500 h no blistering Infiltration on the scratch track under 1 mm		
	Salt spray test (DIN ISO 9227	240 h no blistering Infiltration on the scratch track under 1 mm		
Material Approvals:	-			
Repairs:	For repairs (conveyors hangers touch ups) the repair kit, art. No 10006124 is available.			
Post treatment of coated parts:	Appropriate preliminary tests are recommended for printing, gluing, labeling, film lamination, overcoating and other post treatments. Suitable plasticizer free materials are to be used for the packaging. Avoid condensation.			
Storage:	**Storage instruction:**	In the original containers, store in a cool and dry environment at 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 can be found in the safety data sheet and the CEPE brochures “safe powder coating guideline” and “results of the experimental toxicological studies on thermosetting powdercoatings”.			
Comments:	The information in 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.			
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