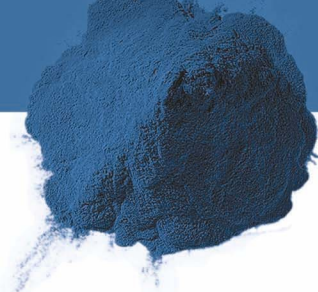




DBS 918 340



Technical data sheet

Article No.: **13667**
 Leaflet No.: 2570
 Version: 05

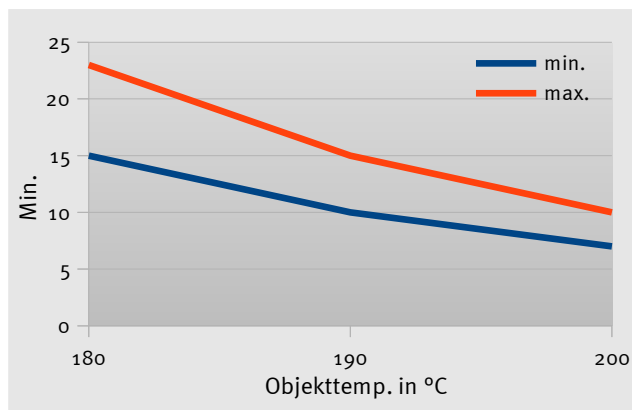
POLYFLEX® PES-20-Power smooth anti-graffiti Corona silk-matt 40

Silk-matt, chemical and solvent-resistant hybrid powder for indoor use based on polyester and epoxy resin with very good "Easy to Clean" properties, very nice smooth texture and high elasticity.

Applications	Preferred applications are in the plumbing, air conditioning, food, kitchen and hospital setting, machine and apparatus housings, metal furniture, kitchen appliances
Colours	Practically all colours possible (also white and very light colours).
Surface	smooth
Gloss	silk-matt, 30-50 gloss units (60°)
Powder properties	<p>Particle size distribution smaller 29 µm: 45 – 55% <small>(HELOS H1708)</small> smaller 122 µm: 98 – 100%</p> <p>Density 1.4 – 1.7 g/cm³ different depending on the colour can be specified per colour</p>
Material consumption	$g/m^2 = \text{Density (g/cm}^3) \times \text{film thickness (}\mu\text{m)}$
Coating thickness	<p>Recommended 70 – 90 µm depending on the colour</p> <p>Maximum 150 µm</p>
Application	<p>The application can be made with the usual powder coating systems.</p> <p>To avoid any surface disturbances and to maintain the properties of the powder paint, we recommend not to mix it with any other powder paint.</p>
Packaging	<ul style="list-style-type: none"> - 20/25 kg cardboard - 500 kg Octobox - 450/500 kg Big Bag <p>Other packaging variations are available on request.</p>

Baking diagram

Curing time recommendation: 15 min. by 180°C object temperature



Curing conditions:
 200°C 7 min. hold time
 190°C 10 min. hold time
 180°C 15 min. hold time

Substrates

Various metals but also as top-coat on a KTL pre-coating. The support to be coated has to be free of oil, grease and oxidation residues. Under exposure to corrosion we recommend the following pretreatments:

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

The pre-treatments can both be applied by dipping or spraying methods.

Physical properties

tested on:

Steel sheet 0.8mm ST1405
double pickled V1094

Film thickness
70 – 90 µm

Cross cut test GT 0
(DIN ISO 2409)

Mandrel bending test ≤ 5 mm
(DIN ISO 1519)

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

Erichsen cupping ≥ 5 mm
(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 1mm

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

Material authorization

DBS 918 340

Post treatment of coated parts

To print, to paste, to label, to laminate of film and any other post-treatment, some preliminary testing is recommended. For packaging only use appropriate unplasticized materials. Perspiration water should 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
max. 25°C No direct sun exposure

Shelf life 18 months from the date under the conditions mentioned

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 the experimental toxicology study on thermosetting powder coatings”.

Comments:

The information on this technical data sheet about 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 application, it is impossible for us to present them all in detail. Our technical consultants are at your disposal for any question you might have. Further more, 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



KARL BUBENHOFER AG, Hirschenstrasse 26, CH-9201 Gossau SG
Tel. +41 71 387 41 41, Fax +41 71 387 43 05, www.kabe-farben.ch