



## Technical data sheet

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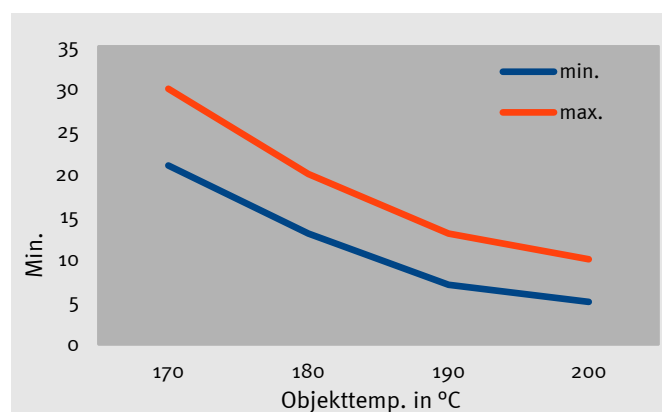
### POLYFLEX® PES-20-Power smooth anti-graffiti, Corona, silk gloss

Chemical and solvent resistant hybrid powder for indoor use. Polyester and epoxy base product with good light stability. The results are coatings with high elasticity, very good "Easy to clean"-properties with a silk-gloss fine smooth texture.

<b>Applications</b>	Preferred applications are in the plumbing, air conditioning, food, kitchen, and hospital settings, machine and apparatus housings, metal furniture, kitchen appliances	
<b>Colours</b>	Practically all colours available (also white and very light shades).	
<b>Surface</b>	smooth	
<b>Gloss</b>	visual silky gloss	
<b>Powder properties</b>	<b>Particle size distribution</b> smaller 29 µm: 55 – 60 % <small>(HELOS H1708)</small> smaller 122 µm: 98 – 100 % <b>Density</b> 1.4 – 1.7 g/cm³ different depending on the colour can be specified per colour	
<b>Material consumption</b>	g/m² =	Density (g/cm³) x film thickness (µm)
<b>Coating thickness</b>	Recommended	70 – 90 µm depending on the colour
	Maximum	150 µm
<b>Application</b>	The application can be made with the usual powder coating systems. 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. Please not curing together in the same oven with any other powder paint.	
<b>Packaging</b>	<ul style="list-style-type: none"> <li>- 20/25 kg cardboard</li> <li>- 500 kg Octobox</li> <li>- 450/500 kg Big Bag</li> </ul> Other packaging variations are available on request.	

#### Baking diagram

**Curing 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

Different metals also as top-coat for example on cathodic anti-corrosion dip-coating. The support to be coated has to be free of oil, grease and oxidation products. Under strain we recommend following pretreatments:

**Aluminium** a suitable chemical pretreatment

**Steel/Iron** Iron or zinc phosphating

The pretreatment can be applied by dip-coating or spray method.

## 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 ≥ 10 Nm (~88 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 under 1 mm

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

## 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 the document



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