

TECHNICAL DATA SHEET

Article No.: 14252	POLYFLEX® PES-150 3D effect fine Corona silk matt			
Version: 5				
Description:	Powder for outdoor use based on polyester resins. Gives silk matt surfaces with fine wrinkle structure and good light and weather resistance. Stabilized against overcuring and discolouration in directly gas fired ovens.			
Applications:	Facade parts, vehicle parts, bicycles, general outdoor application			
Colours:	Colours on request, effect varies slightly depending on color			
Surface:	3D-effect fine structure			
Gloss:	Visually silkmatt			
Powder properties:	Particle size distribution (HELOS H1708)	29 µm:	35 – 50 %	
		122 µm:	98 – 100 %	
	Density	1.4 – 1.8 g/cm ³ can vary depending on the colour; can be specified for each individual colour		
Material consumption:	g/m ²	= density (g/cm ³) x film thickness (µm)		
Coating thickness:	Recommended	90 – 120 depending on the colour tone		
Application:	The application can be made with all standard powder coating systems. Due to the structure, great attention must be paid to the application and especially the curing process (high heating rate). To avoid surface defects, we recommend not mixing this type of powder coating with other powder coatings.			
Packaging:	<ul style="list-style-type: none"> - 20/25 kg cardboard box - 500 kg Octobox - 450/500 kg Big Bag Other packaging variations are available on request.			
Curing time:	Recommended	12 min. at 190°C object temperature		
	Object temperature	Minutes hold time min	Minutes hold time max	
	210°C	6 min	12 min	
	200°C	8 min	17 min	
	190°C	12 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		
	Steel	Iron or zinc phosphating		
Physical properties:	Tested on 1): Aluminium panel 0.8 mm AlMg1 H14 chromated Layer thickness: 90 – 100 µm			
	Cross Cut test (DIN ISO 2409)	1) GT 0		
	Mandrel bending test (DIN ISO 1519)	1) ≤ 4 mm		
	Impact resistance (ASTM D 2794)	1) front	≥ 2.5 Nm	(~22 Inchpound)
		1) reverse	≥ 2.5 Nm	(~22 Inchpound)

	Erichsen cupping (DIN ISO 1520)	1) ≥ 5 mm
Resistance:	Tested on: Aluminium panel 0.8 mm AlMg1 H14 chromated	
	Condensation water test (DIN ISO 6270)	1000 h no blistering Infiltration on the scratch track under 1 mm
	Salt spray test (DIN ISO 9227)	1000 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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