

TECHNICAL DATA SHEET

Article No.: 14276	POLYFLEX® PAC-135 Pearl-Metallic smooth Corona matt		
Version: 5			
Description:	Pearl metallic powder for outdoor use based on polyester resins. Gives matt surfaces with good flow and very good light and weather resistance. Especially suitable for creating special surface effects (e.g. Corten steel appearance). Stabilized against overcuring and discolouration in directly gas fired ovens.		
Applications:	Metal façades, Aluminium profiles, windows, doors, gates and many more and also for indoor application.		
Colours:	According do PearlMetallic clour card. Many colours on request.		
Surface:	Smooth		
Gloss:	Visually matt		
Powder properties:	Particle size distribution (HELOS H1708)	29 µm: 40 – 47 % 122 µm: 99 – 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	70 – 90 depending on the colour tone	
	Maximum	110 µm	
Application:	The application can be made with all standard powder coating systems. Please observe our processing instructions for POLYFLEX powder coatings with metallic effect VR003D. Overcoating cannot be guaranteed if the thermal load is too long. The stoving process must therefore be given the utmost attention. To avoid surface defects and to maintain the properties, we recommend not mixing this type of powder coating with other powder coatings. When changing to a different quality, clean carefully.		
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	15 min. at 180°C object temperature	
	Object temperature	Minutes hold time min	Minutes hold time max
	210°C	7 min	11 min
	200°C	8 min	13 min
	190°C	10 min	16 min
	180°C	15 min	24 min
Substrates:	Various metals, especially as a top coat for creating effects on primers. The substrate to be coated must be free of oil, grease and oxidation products. We recommend the following pre-treatment if the surface is subject to corrosion:		
	Aluminium	A suitable wet-chemical pretreatment	
	Steel	Iron or zinc phosphating	
	The pretreatments can be can be applied both by immersion and by spraying. applied.		
Physical properties:	Tested on 1): Aluminium panel 0.8 mm AlMg1 H14 chromated Layer thickness: 60 – 80 µm		

Cross Cut test (DIN ISO 2409)	1) GT 0
Mandrel bending test (DIN ISO 1519)	1) $\leq 5^*$ mm
Impact resistance (ASTM D 2794)	1) front $\geq 2.5 \text{ Nm}^*$ (~22 Inchpound)
	1) reverse $\geq 2.5 \text{ Nm}^*$ (~22 Inchpound)
Erichsen cupping (DIN ISO 1520)	1) $\geq 5^*$ mm
Buchholz Hardness (DIN ISO 2815)	≥ 80

(*) cracks; no detachment with adhesive tape, with unarmred eye

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:	6 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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