

TECHNICAL DATA SHEET

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Version: 5

KABE React!ve PES-75 fine structure Corona silk matt

Description: Ultra low bake powder for indoor use based on polyester and epoxy resins. Gives silk matt surfaces with fine structure. Particularly suitable for coating MDF boards (1 and 2 layers) and other heat-sensitive substrates, but also for aluminum or steel. Specially developed for use in IR ovens. Stabilized against overcuring and discolouration in directly gas fired ovens.

Applications: Especially suitable for MDF and other heatsensitive substrates.

Colours: Almost any colour with few limitations

Surface: Fine structure

Gloss: Visually silk matt

Powder properties:

Particle size distribution (HELOS H1708)	29 µm:	50 – 55 %
	122 µm:	99 – 100 %
Density	1.4 – 1.7 g/cm ³ 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 – 120 depending on the colour tone
Maximum	140 µm

Application: The application can be made with all standard powder coating systems. The coating of heat-sensitive, non-metallic substrates requires the use of counter-cascades in order to achieve uniform and good coatings. 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	5 min. at 140°C object temperature		
Object temperature	Minutes hold time min	Minutes hold time max	
160°C	2 min	5 min	
150°C	3 min	7 min	
140°C	5 min	10 min	
130°C	10 min	18 min	

Substrates: Primarily MDF and other suitable, heat-sensitive substrates. Metallic substrates must be free of oil, grease and oxidation products. We recommend the following pre-treatments when exposed to corrosion:

Aluminium	A suitable wet-chemical pretreatment
Steel	Iron or zinc phosphating

Physical properties: Tested on 1): Steel panel 0.8 mm ST1405 pickled twice V1094
Layer thickness: 80 – 100 µm

Cross Cut test (DIN ISO 2409)	1) GT 0
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Mandrel bending test (DIN ISO 1519)	1) ≤ 8 mm
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	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) $\geq 5 \text{ mm}$
Resistance:	Tested on: Egger MBPL 16, 19, 25 mm. Layer thickness 80 - 100 μm	
	Testing of furniture surfaces	Part 1 - chem. Resistance: Cat. B Part 2 - Abrasion resistance: Cat. B - C Part 4 - scratch resistance: Cat. B - C Part 7 - dry heat: Cat. A Part 8 - damp heat: Cat. A
	Ledro-Test	$\geq 96 \text{ h}$ on PES-75 primer (total 180 μm) $\geq 48 \text{ h}$ single-layer (100 μm)
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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