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TECHNICAL DATA SHEET

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Version: 3

KABE React!ve PES-75-Primer 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 as a primer MDF boards (1 and 2 layers) and other heat-sensitive substrates. Specially developed for use in IR ovens. Stabilized against overcuring and discolouration in directly gas fired ovens.		
Applications:	Especially suitable for priming MDF and other heatsensitive substrates		
Colours:	MDFgrey, RAL 9016 und RAL 9005, other colours on request		
Surface:	Fine structure		
Gloss:	Visually silkmatt		
Powder properties:	**Particle size distribution** (HELOS H1708)	29 µm: 40 – 47 % 122 µm: 99 – 100 %	
	Density	1.4 – 1.7 g/cm³ 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 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	
	Mandrel bending test (DIN ISO 1519)	1) ≤ 8 mm	

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	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: Egger MBPL 16, 19, 25 mm, combination with PES-75 top coat silk matt (approx. 80 µm), total layer thickness approx. 180 µm			
	Ledro-Test	≥ 96 h		
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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