



series 6-666-XXXXGJT

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POLYESTER GLITTER POWDER FOR OUTDOOR TGIC-FREE
LICENSE NR. 0683

Thermosetting powder coating based on saturated polyester resins crosslinked with beta-hydroxyalkylamides, free of inorganic pigments with heavy metals, for indoor and outdoor use.

For the tests we refer to "SPECIFICATIONS FOR A QUALITY LABEL FOR LIQUID AND POWDER ORGANIC COATINGS ON ALUMINIUM FOR ARCHITECTURAL APPLICATIONS" 15th Ed.2017

PHYSICAL PROPERTIES

| | |
|---|-------------------------------------|
| Appearance | wrinkled matt |
| Gloss 60° (EN ISO 2813:90) | nd |
| Specific gravity gr/lt | 1300-1700 (depending of the colour) |
| Particle size distribution µm (MASTERSIZER 2000) | all bellow < 125 micron |
| Packaging kg | 25 |
| Application | corona |

Storage Into dry place at a temperature below 35° C = 24 month

- Making contact even for a short time, with moisture determines the decay of any form of warranty and fitness for use

YIELD OF PPLICATION AND THICKNESS

Minimum application thickness 60 µm

Theoretical average spreading rate = $1000 / (\text{specific gravity} * \text{thickness})$

The theoretical yield can be affected by leaks in the system, parameter system, the surface of the support, the form of the support. In case of usage of recovered powder it must be done in a controlled and repetitive way

MECHANICAL PROPERTIES

| | | | |
|---------------------------|-------------|---------|-----------------------|
| Erichsen slow penetration | EN ISO 1520 | 8 mm | no coating detaching, |
| Conical mandrel bending | EN ISO 1519 | Φ 3 mm | no coating detaching |
| Impact test | ASTM D2794 | >2,5 nm | no coating detaching |
| Buchholz Hardness | EN ISO 2815 | 90-110 | |
| Cross cut adhesion | EN ISO 2409 | Gt0 | |

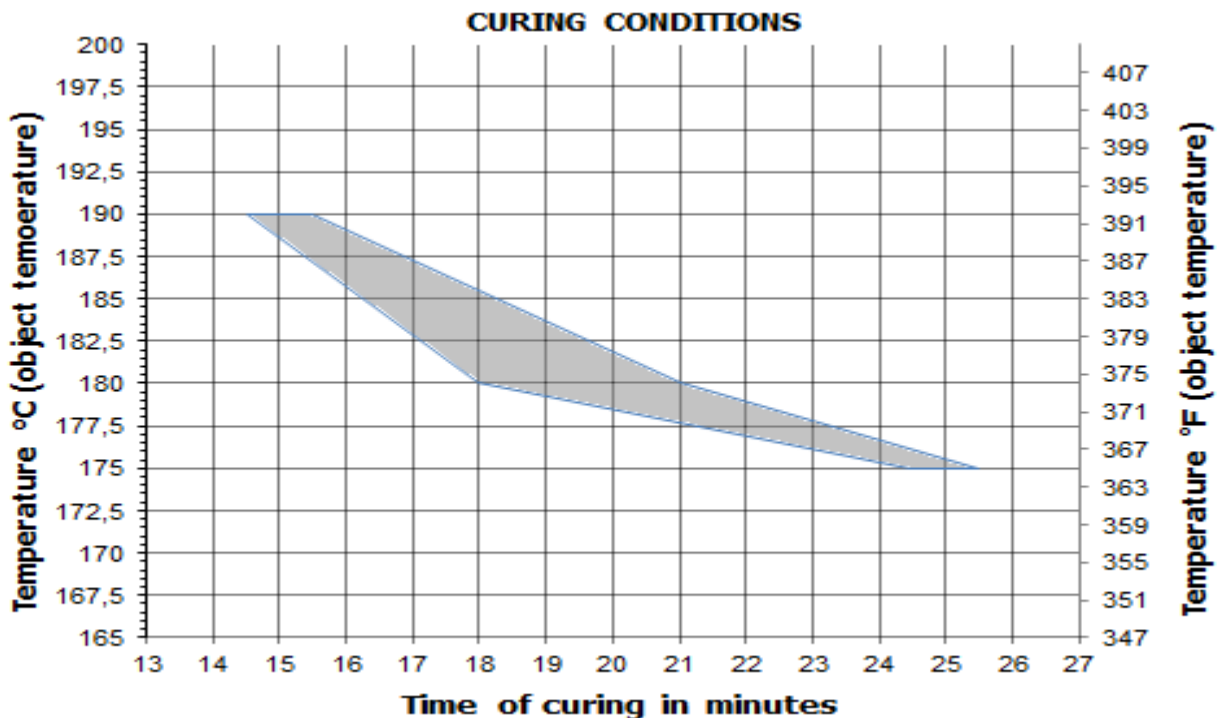
PREPARING THE SURFACE

As these products are intended for use with the main outside, it is recommended a good cleaning of the support and an adequate chemical conversion of the same. For aluminum supports and galvanized sheet metal, it is appropriate to proceed to a chromate treatment. In the case of iron or steel you will have to proceed to a phosphating, preferably with zinc salts.

For the best protection do not paint in layers less than 60 µm.

Curing conditions (object temperature)

Recommended values: 175 °C x 25' 180 °C x 20' 190 °C x 15'



CHEMICAL RESISTANCE

Good resistance to most acids, alkalis and oils at temperature of 25 °C

CORROSION RESISTANCE AND EXPOSURE OUTSIDE

Wet adhesion DIN 50017 after 1000 hours appearance unchanged

Kesternich test EN ISO 3231 after 24 cycles no change

Salt spray test EN ISO 9227 after 1000 hours appearance unchanged

RECLAIM – GLITTER EFFECTS

To achieve uniform color and effect, the dosing of fresh powder is to be maintained throughout the entire process, but should not be less than 70% . At the same time the reclaim powder should only be continuously reintroduced and sieved into the powder circulation. The exclusive use of reclaim powder is not permitted.

THE INFORMATION PROVIDED IS BASED ON CURRENT OUR KNOWLEDGE AND EXPERIENCE. HOWEVER , THE END USER IS RESPONSIBLE FOR PROPER APPLICATION OF THE PRODUCTS AND MUST CONSIDER ALL THE FACTORS AND OPERATING CONDITIONS THAT MAY IN ANY WAY AFFECT THE END RESULT. DUST IS A PROFESSIONAL USE ONLY.