



# series 6.647.0XXX-YYY

GI COLOR srl Factory: Via Tagliamento, 4 - 36050 Belvedere di Tezze S/B (VI) – ITALIA tel.+39.0424.560208 fax +39.0424.564601

POLYESTER POWDER FOR OUTDOOR TGIC-FREE  
LICENSE NR. 0628

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 "TECHNICAL GUIDELINES OF THE MARK OF QUALITY 'QUALICOAT' PAINTED ALUMINUM" issue No. 16° EDITION 2020

## **PHYSICAL PROPERTIES**

Appearance	smooth matt
Gloss range 60° (EN ISO 2813:90)	15+/-10
Specific gravity gr/ltr	1400-1600 (depending of the colour)
Prarticle size distribution µm (MASTERSIZER 2000)	all bellow < 100 micron
Packaging kg	25
Application	corona-tribo (specify in the order, some metallic need to be checked prior to the application)
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 (as the average of five measurements and no value <48 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. The product should be applied to lose. Being a non-bonded metallic (dry blend), the end result may be different from the surface to be coated and application parameters, the recovery should not be used but painted to lose.

**MECHANICAL PROPERTIES**

Erichsen slow penetration	EN ISO 1520	8 mm	no coating detaching,
Conical mandrel bending	EN ISO 1519	∅ 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	

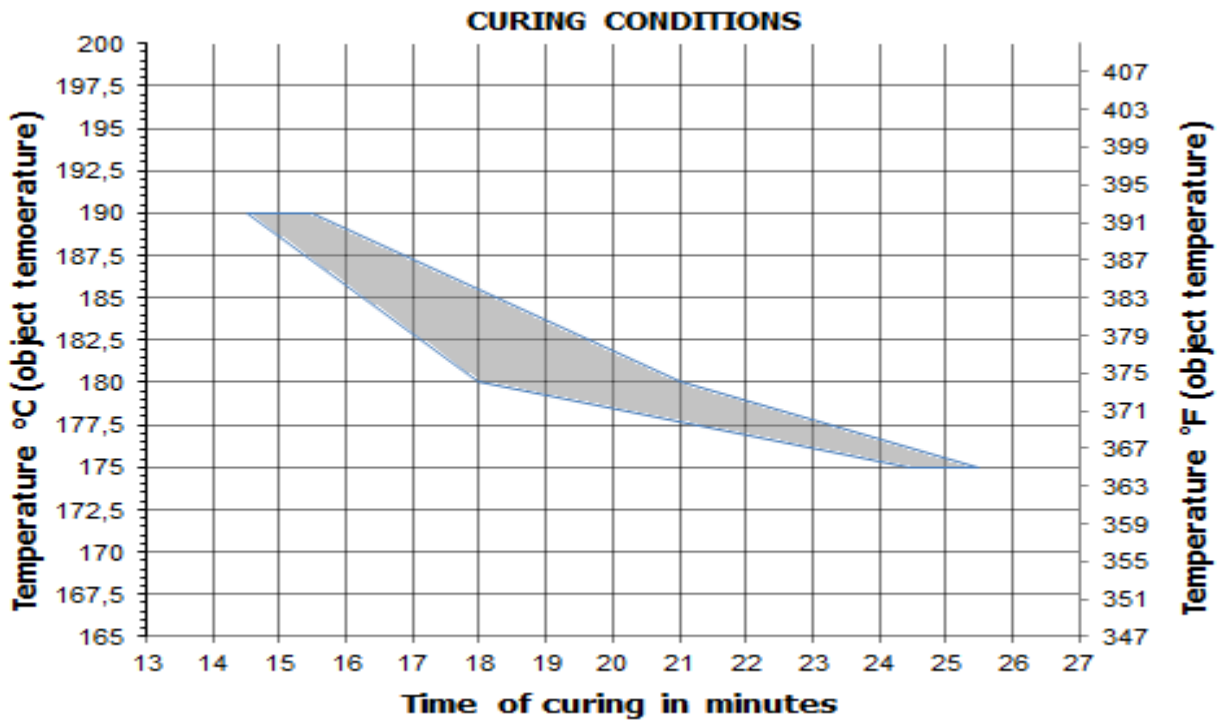
**PREPARING THE SURFACE**

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

---

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.