



DALI' SERIES

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POLYESTER POWDER FOR INDOOR USE TGIC-FREE

Thermosetting powder coating based on polyester resins crosslinked with saturated β – idrossialchilamide, free from inorganic pigments with heavy metals. Due to the properties of the pigments used to achieve the effect the fluorescent UV stability is reduced, this reduction varies from color to color the product therefore is not recommended for outdoor use and is suitable for electrostatic application CORONA. Is recommended application on a white background PE411 (special product formulated for better adhesion) to highlight the fluorescent effect.

PHISICAL PROPERTY

Gloss 60 °	Smooth, polished 85 +/-15
Specific Gravity gr/lt	1150-1500 (depending on color)
particle size	<100 μ m
Standard packaging	25 kg
Application	tribo-corona
Storage	In a dry place at a temperature below 35 °C = 24 months *

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

YIELD OF APPLICATION AND THICKNESS

Minimum application thickness with no value <48 μ m). 60 μ m (as the average of five measurements)

Theoretical average spreading rate = 1000 / (specific gravity * thickness)

The theoretical yield can be affected by losses in the system, the parameter settings of system is not adequate, the surface of the support, the form of the support.

MECHANICAL PROPERTY

Erichsen	EN ISO 1520	8 mm no defect
Mandrel bends	EN ISO 1519	\varnothing 3 mm no defect
Impact test	ASTM D2794	> 2.5 nm no defect

Buchholz Hardness
Adhesion

EN ISO 2815
EN ISO 2409

90-110
GT0

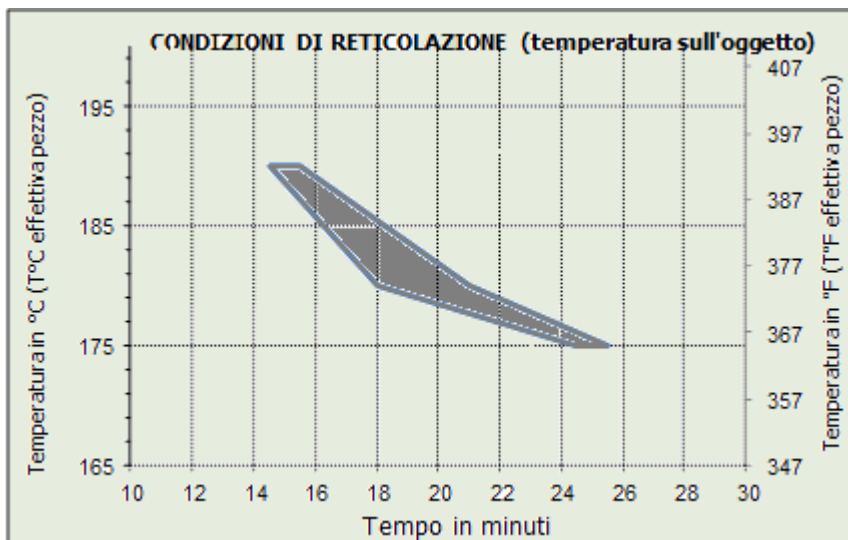
PREPARING THE SURFACE

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 μ m.

CURING CONDITIONS

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 a temperature of 25 ° C.

CORROSION RESISTANCE

Humidistat
Salt spray test

DIN 50017
EN ISO 9227

after 500 hours appearance unchanged
unchanged after 500 hours

THE INFORMATION PROVIDED IS BASED ON CURRENT KNOWLEDGE AND EXPERIENCE THE END USER AND RESPONSIBLE FOR THE 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.