



series 6.647

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POLYESTER POWDER FOR OUTDOOR TGIC-FREE
LICENSE NR. P-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

QUALICOAT Specifications 2021 - MASTER VERSION - V01.docx valid from 01.01.2021

PHYSICAL PROPERTIES

Appearance	smooth matt
Gloss range 60° (EN ISO 2813:90)	25+/-10
Specific gravity gr/lt	1300-1700 (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.

MECHANICAL PROPERTIES

Erichsen slow penetration	EN ISO 1520	8 mm	no coating detaching,
Conical mandrel bending	EN ISO 1519	∅ 5 mm	no coating detaching
Impact test	ASTM D2794	>2,5 nm	no coating detaching
Buchholz Hardness	EN ISO 2815	> 80	
Cross cut adhesion	EN ISO 2409	Gt0	

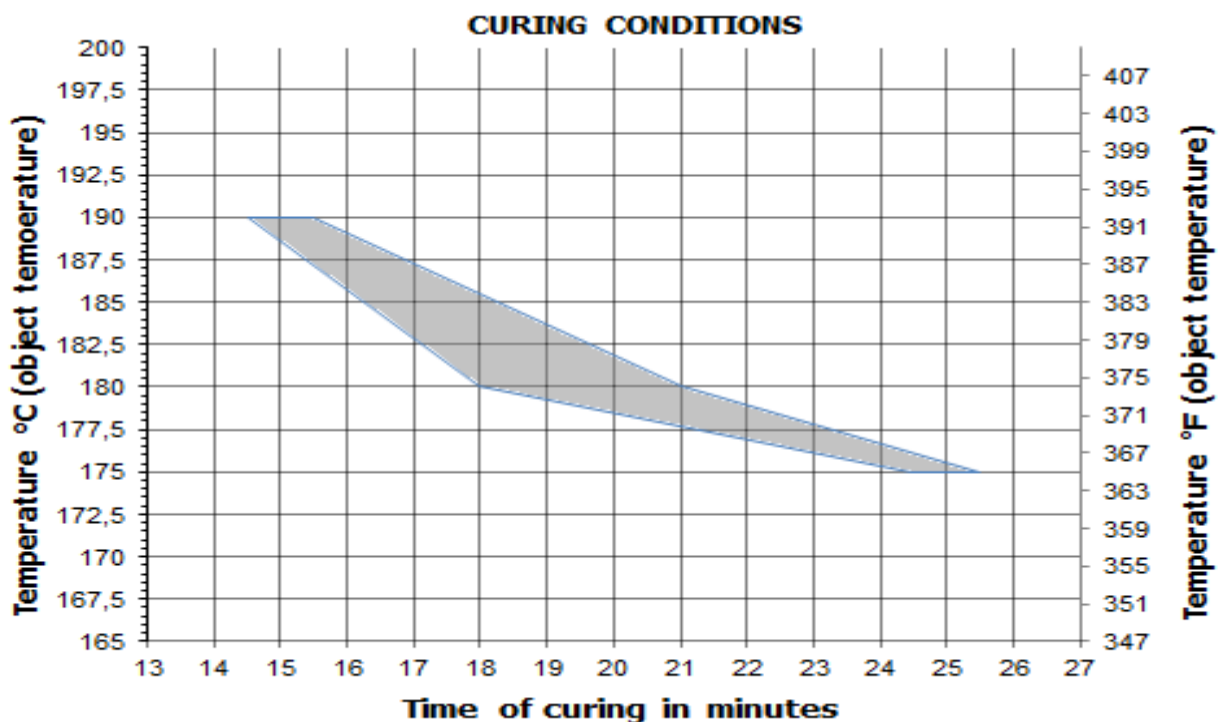
PREPARING THE SURFACE

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.