



115h

P-0153

Technical data sheet

Article No: **11718**
 Leaflet No: 1732
 Version: 09

POLYFLEX® PES-135 smooth Tribo / Corona Silk-gloss 75

Silk-gloss powder paint for outdoor coatings on polyester resin base with excellent light and weathering resistance, good flow and very good covering power. Stabilized against over-burning and discoloration in direct gas-fired curing ovens.

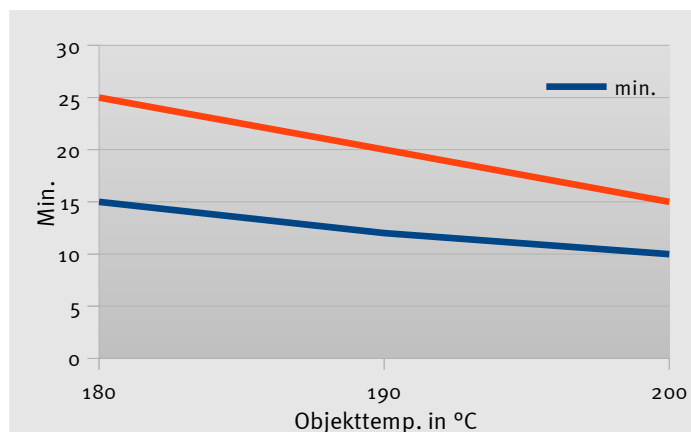
Applications	Metal facades, Aluminum profiles, sun protection systems, windows, doors, gates and frames and many more
Colours	Many all colours on request, with a few restrictions
Surface	smooth
Gloss	Silk-gloss, 65-85 gloss units (60°)
Powder properties	<p>Particle size distribution (HELOS H1708) smaller 29 µm: 40 – 47 % smaller 122 µm: 96 – 100%</p> <p>Density 1.4 – 1.8 g/cm³ different depending on the colour can be specified per colour</p>
Material consumption	g/m ² = Density (g/cm ³) x Film thickness (µm)
Coating thickness	<p>Recommended 60 – 80 µm depending on the colour</p> <p>Maximum 120 µm</p>
Application	<p>The application can be made with the usual electrostatic powder coating systems.</p> <p>To any surface disturbances, we recommend not to mix this type of powder paint with any other powder.</p>
Packaging	<ul style="list-style-type: none"> - 20/25 kg cardboard - 500 kg Octobox - 450/500 kg Big Bag <p>Other packaging variations are available on request</p>

Baking diagram

Curing time recommendation: 15 min by 180 °C object temperature

Curing conditions:

- 200°C 10 min. hold time
- 190°C 12 min. hold time
- 180°C 15 min. hold time



Supports

Different metals, however mainly on pre-treated aluminum or hot-dip galvanized or powder coated or anti-corrosion dip-coated steel. The support to be coated has to be free of oil, grease and oxidation products. Under exposure to corrosion, we recommend the following pre-treatment:

Aluminum	Chroma ting, chrome free pre-treatment or thin layer of anodizing coat
Steel/Iron	Galvanization with subsequent chroma ting

Physical properties

tested on:

Aluminum plate 0,8 mm AlMg₁
H14 chromated

Film thickness
60 – 80 µm

Cross cut test (DIN ISO 2409)	GT 0
Mandrel bending test (DIN ISO 1519)	< 5 mm
Impact resistance ASTM D 2794	front > 5 Nm (~44 inchpound) reverse > 2,5 Nm (~22 inchpound)
Erichsen cupping (DIN ISO 1520)	> 5 mm
Buchholz hardness (DIN ISO 2815)	> 90

Resistance

tested on:

Aluminum plate 0,8 mm AlMg₁
H14 chromated

Condensation water test DIN ISO 6270	1000 h no bubble building Infiltration on the scratch under 1 mm
Salt spray test DIN ISO 9227	1000 h no bubble building Infiltration on the scratch under 1 mm

Material approvals

GSB Standard	115h
Qualicoat Class 1	P-0153

Post-treatment of coated parts

To print, to paste, to label, to laminate with film, over-coating and other post-treatments , some preliminary testing is recommended. For packaging only use appropriate plasticizers free materials. Condensation must be avoided.

Repairs

For repairs (conveyors hangers touch ups) the repair kit, art. No 12155 is available.

Storage

Storage instruction: In the original containers, store in a cool and dry environment by max. 25 °C. No direct sun exposure.

Shelf life 18 months from the date of production under the mentioned conditions

Safety recommendations

Under explosion limit 40 g/m³

Further information are to find in the safety data sheet and the CEPE booklet „Safe powder coating“ and „Results of experimental toxicology study on thermosetting powder coatings“.

Comments:

The information on 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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