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P-1131

Technical data sheet

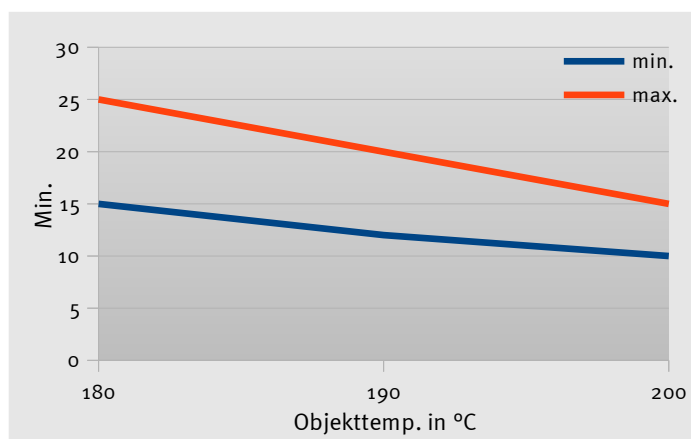
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POLYFLEX® PES-135

Smooth coating Tribo / Corona silk matt 35

Facades powder for outdoor use on polyester base with exceptional resistance to light and very good weather resistance, very good flow and covering power. Stabilized against over burning and discoloration in direct gas-fired curing ovens.

Applications	Metal facades, Aluminum profiles, sun protection equipment, windows , doors, gates and frames, etc.	
Colours	Practically all colours with very few limitations	
Surface	Smooth	
Gloss	Silk matt, Gloss level 25-40 (60°)	
Power properties	Particle size distribution <small>(HELOS H1708)</small>	smaller 29 µm: 40 – 47 % smaller 122 µm: 99 – 100%
	Density	1.4 – 1.8 g/cm ³ different depending on the colour, can be specified per colour
Material consumption	g/m ² =	Density (g/cm ³) x film thickness (µm)
Coating thickness	Recommended	70 – 90 µm depending on the colour
	Maximum	120 µm
Application	The application can be made with the usual powder coating systems, Tribo or Corona. To avoid any surface disturbances, we recommend not to mix it with any other powder paint.	
Packaging	<ul style="list-style-type: none"> - 20/25 kg cardboard - 500 kg Octobox - 450/500 kg Big Bag Other packaging variations are available on request	
Baking diagram	Curing time recommendation : 15 min at 180 °C object temperature	



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

Substrates	Different metals, however mainly on pretreated aluminum or galvanized 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-treatments:	
	Aluminium	Chromating, chrome free pretreatment
	Steel/Iron	Galvanization with a subsequent chromating
Physical properties	Cross cut test	GT 0 (DIN ISO 2409)
tested on:	Mandrel bending test :	≤ 5 mm (DIN ISO 1519)
Aluminium plate 0,8 mm AlMg1 H14 chromated	Impact resistance	front ≥ 5.0 Nm (~44 inchpound) reverse ≥ 2.5 Nm (~22 inchpound) ASTM D 2794
Film thickness 70 – 90 µm	Erichsen cupping	≥ 5 mm (DIN ISO 1520)
	Buchholz hardness	≥ 90 (DIN ISO 2815)
Resistances	Condensation water test	1000 h no bubble building DIN ISO 6270 Infiltration on the scratch track under 1 mm
tested on:	Salt spray test	1000 h no bubble building DIN ISO 9227 Infiltration on the scratch track under 1 mm
Aluminium plate 0,8 mm AlMg1 H14 chromated		
Material approval	GSB Standard	115j
	Qualicoat Class 1	P-1131
Post treatment of coated parts	To print, to paste, to label, to laminating of film and any other post-treatment, some preliminary testing is recommended. For packaging only use appropriate plasticizers-free materials. Perspiration water should be avoided.	
Repairs	For repairs (conveyors hangers touch ups) the repair kit, Art. 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	24 months from the date of production under the mentioned conditions
Safety recommendations	Lower explosive limit	please refer to the safety data sheet

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

Comments: The information on this technical data sheet about the properties and application of the product in question are made on hand of our knowledge, development and practical experience. Because of the multiple possible application, it is impossible for us to present them all in detail. Our technical consultants are at your disposal for any question you might have. Further more, 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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