



Technical data sheet

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 Version: 05

POLYFLEX® PES-135-Q fine structure Tribo / Corona silk matt

Fine structure powder coating for outdoor use on polyester base with very good light- and weather-resistance and excellent opacity with a medium fine, not rough, silk matt structure. Stabilized against discoloration and burning gas-fired curing ovens in directly. Curing can be done already from 180 ° C.

Applications	Aluminium profile, sun protection systems, Garden furniture, shutters, noise walls, windows, doors, gates and frames and much more	
Colours	Many colours with some restrictions	
Surface	fine structure	
Gloss	Silk-matt	
Powder properties	Particle size distribution	smaller 29 µm: 38 – 45 % smaller 122 µm: 98 – 100% <small>(HELOS H1708)</small>
	Density	1.4 – 1.8 g/cm ³ can vary depending on the colour; can be specified individually per colour on request
Material consumption	g/m ² =	Density (g/cm ³) x film thickness (µm)
Coating thickness	Recommended	70 – 90 µm depending on the colour

Application

The application can be made with the usual electrostatic powder coating systems. To obtain a uniform structure of the image layer-thick the recommendation must be maintained if possible. A low film thicknesses to yield pores to the substrate. Please read our application instruction for structured powder VR001D.

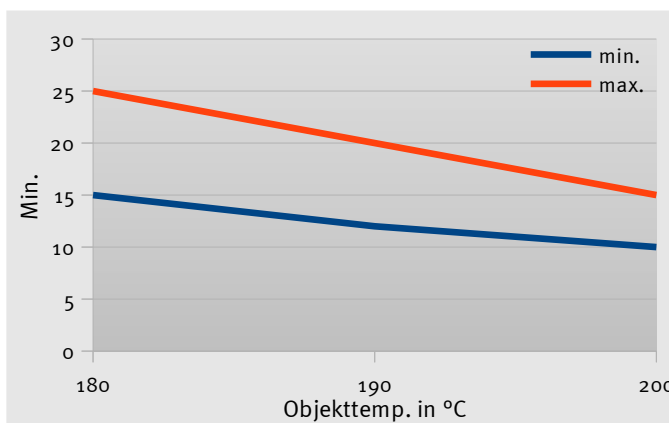
To avoid disturbances, we recommend not to mix this type of powder paint with any other powder.

Packaging

- 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. 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:

Aluminium plate 0,8 mm AlMg1 H14 chromated

Film thickness
70 – 90 µm

Cross cut test GT 0
(DIN ISO 2409)

Mandrel bending test < 5 mm
(DIN ISO 1519)

Impact test front > 5 Nm (~44 inchpound)
ASTM D 2794 reverse > 2.5 Nm (~22 inchpound)

Erichsen cupping > 5 mm
(DIN ISO 1520)

Resistance

tested on:

Aluminium plate 0,8 mm AlMg1 H14 chromated

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

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

Material approval

Qualicoat Class 1 P-0570

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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