



P-0570



Technical data sheet

Article-No.: **12829**
 Leaflet-No.: 2093
 Version: 05

POLYFLEX® PES-135-Q Pearl-Metallic fine structure Corona Silk matt

Fine structured powder paint with metallic effect for outdoor use on polyester base with exceptional resistance to light and very good weather resistance, excellent covering power with fine, not rough, silk matt structure. Stabilized against over burning and discoloration in direct gas-fired curing ovens. The curing can occur from 180° C.

Applications	Metal facades, Aluminum profiles, sun protection equipment, windows, doors, gates and frames, etc.	
Colours	According specific pearl-Metallic colour cards. Special colours upon request	
Surface	Fine structured	
Gloss	Visually silk matt	
Powder properties	Particle size distribution	smaller 29 µm: 38 – 45 % <small>(HELOS H1708)</small> smaller 122 µm: 98 – 100%
	Density	1.4 – 1.8 g/cm ³ can vary 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

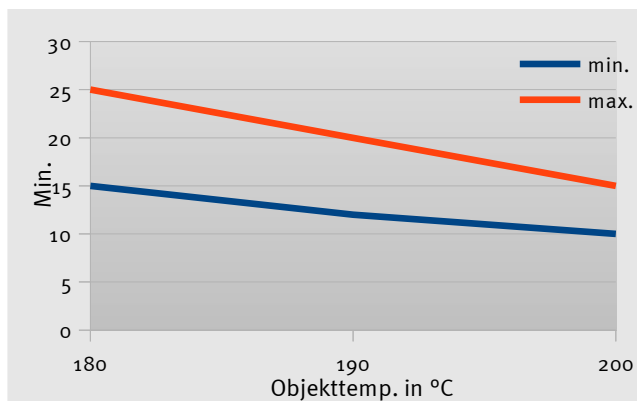
Application
 The application can be made with the usual electrostatic powder coating systems. The use of Tribo coating system is not recommended because of effect shifting. Please observe our application instructions for POLYFLEX Powder paint Metallic-Effect VR003D.
 For certain colours it is absolutely necessary to overcoat with a transparent powder. To avoid any surface disturbances, we recommend not to mix with any other powder paint.

Packaging

- 20/25 kg Box
- 500 kg Octobox
- 450/500 kg Big Bag

Other packaging variations are available on request

Baking diagram **Curing time recommendation: 15 min bei 180 °C object temperature**



Curing conditions:
 200°C 10 min. hold time
 190°C 12 min. hold time
 180°C 15 min. hold time

Underground

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:

Aluminum Chromating, chrome free pre-treatment or thin layer of anodizing coat

Steel/Iron Galvanization with subsequent chromating

Physical properties

tested on:

Aluminum 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 resistance front > 5 Nm (~44 inchpound)
ASTM D 2794 reverse > 2,5 Nm (~22 inchpound)

Erichsen cupping > 5 mm
(DIN ISO 1520)

Buchholz hardness > 90
(DIN ISO 2815)

Resistances

tested on:

Aluminum 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 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 hanger 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: 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 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 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. Further more, our general sales and delivery conditions apply.

The technical data sheet is revised periodically. If necessary, our sales department will confirm the validity of this document.



KARL BUBENHOFER AG, Hirschenstrasse 26, CH-9201 Gossau SG
Tel. +41 (0)71 387 41 41, Fax +41 (0)71 387 43 05, www.kabe-farben.ch