



Technical data sheet

Article No.: **13387**
 Leaflet No.: 2402
 Version: 01

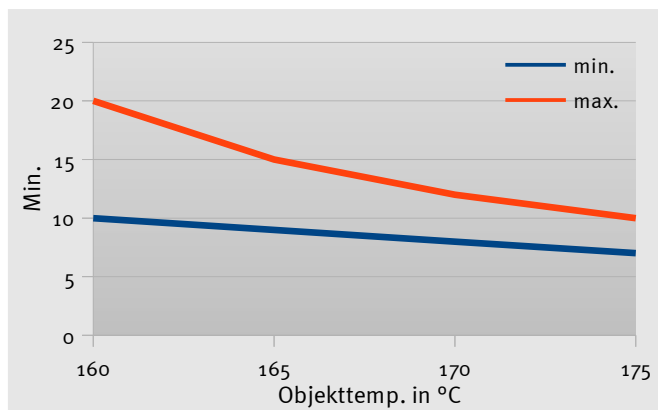
POLYFLEX® PES-55-NT-UDS-S smooth texture, fast reactive thin coat Corona Silk-gloss

Low temperature thin-coat powder for indoor use based on polyester and epoxy resins with very good smooth and very good covering. Universal use indoors.

Applications	Metal furniture, shelves elements, machine casings and many more	
Colours	All colours	
Surface	smooth texture	
Gloss	Silk-gloss, 50-60 gloss units (60°)	
Powder properties	Particle size distribution (HELOS H1708)	smaller 7 µm: 8 – 13% smaller 31 µm: 61 – 66%
	Density	1.4 – 1.8 g/cm ³ can vary depending on the colour, can be specified per colour on request
Material consumption	g/m ² =	Density (g/cm ³) x Film thickness (µm)
Coating thickness	Recommended	20 – 40 µm depending on the colour (in white 50 µm)
	Maximum	60 µm
Application	The application can be made with the usual electrostatic powder coating systems. To avoid any surface disturbance, we recommend not to mix this type of powder paint with any other powder.	
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: 10 min by 160 °C object temperature	

Curing conditions:

175°C	7 min. hold time
170°C	8 min. hold time
165°C	9 min. hold time
160°C	10 min. hold time



Supports

Various metals, but primarily as top coat on a KTL pre-treated surface. The support to be coated has to be free of oil, grease and oxydation products. Under exposure to corrosion, we recommend the following pre-treatments:

Aluminum	Apply a yellow, green or transparent chromating pre-treatment, an equivalent chrom free pre-treatment or an thin layer of anodizing coat.
Steel/Iron	Apply at least an iron or preferably a zinc-phosphate coating.

The pre-treatment can both be applied with dipping or spraying methods.

Physical properties

tested on:

steel sheet 0.8mm ST1405
pickled twice V1094

Film thickness
50 – 70 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 > 5 Nm (~44 inchpound)
Erichsen cupping (DIN ISO 1520)	> 5 mm
Buchholz hardness (DIN ISO 2815)	> 90

Resistances

tested on:

steel sheet iron phosphated

Condensation water test DIN ISO 6270	500 h no bubble building Infiltration on the scratch track under 1 mm
Salt spray test DIN ISO 9227	240 h no bubble building Infiltration on the scratch track under 1 mm

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 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. 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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