



115n

P-0937



## Technical data sheet

Article no.: **13524**  
 Leaflet no.: 2468  
 Version: 03

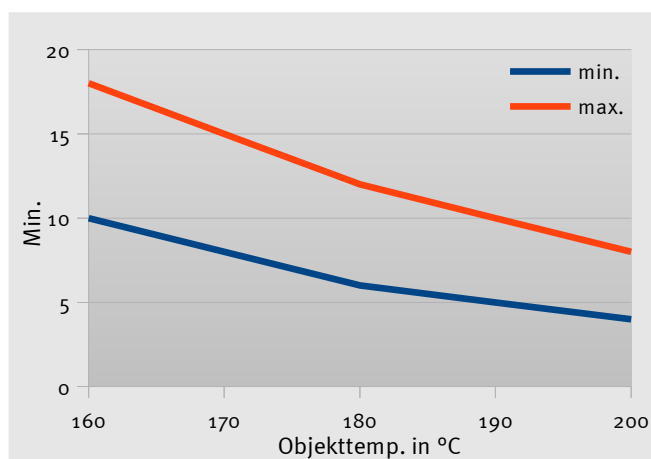
### POLYFLEX® PES-165-NT smooth Tribo / Corona Silk gloss 75

Fast reactive facade powder for external use on polyester base with excellent light and weather resistance, very good smooth and excellent opacity. Stabilized against discoloration and burning in direct-fired curing ovens trial.

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

**Baking diagram**

**Curing time recommendation: 10 min by 160 °C object temperature**



**Curing operation:**

200°C	4 min. hold time
190°C	5 min. hold time
180°C	6 min. hold time
170°C	8 min. hold time
160°C	10 min. hold time

## Support

Various metals, but primarily on pre-treated aluminum and galvanized or pre-coated steel with powder coating or KTL . 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** Chromate coating, chrom free pre-treatment or a thin layer of anodizing coat.

**Steel/Iron** Hot-dip galvanizing with subsequent chromating

The pre-treatments can both be applied by dipping or spraying methods.

## Physical properties

tested on:

Aluminium plate 0,8 mm AlMg1  
H14 chromated

Film thickness  
60 – 80 µm

**Cross cut test** GT 0  
(DIN ISO 2409)

**Mandrel bending test** < 5 mm  
(DIN ISO 1519)

**Impat resistance** front > 5 Nm (~44 inchpound)  
ASTM D 2794 reverse > 2.5 Nm (~22 inchpound)

**Erichsen test** > 5 mm  
(DIN ISO 1520)

**Buchholz hardness** > 90  
(DIN ISO 2815)

## Resistances

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 approvals

**GSB Standard** 115n

**Qualicoat Class 1** P-0937

## Post-treatment of coated parts

To print, label, foil laminating, over-coating and any other post-treatment, some preliminary testing is recommended. For packaging, only use appropriate plasticizer 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/m<sup>3</sup>

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.



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  
13524 version: 03