



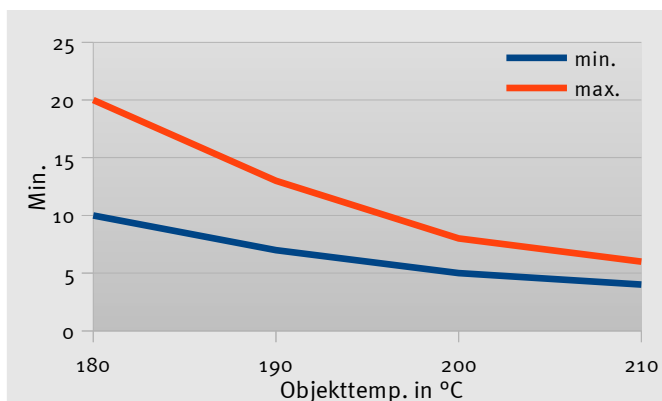
Technical data sheet

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POLYFLEX® PES-125-GU Pearl-Metallic smooth texture for gasifying substrates Corona Silk-gloss

Pearl Metallic powder coatings for outdoor applications on polyester base with good light and weather resistance, very good flow and excellent covering. The product has excellent outgassing properties. Stabilized against discoloration and burning gas-fired curing ovens in directly.

Applications	Galvanized steel of all kinds such as railings, grilles, sun protection systems, doors, gates, frames, car parts, machinery and equipment.
Colours	Colours on request
Surface	smooth texture
Gloss	Silk-gloss
Powder properties	<p>Particle size distribution smaller 29 µm: 40 – 47 % <small>(HELOS H1708)</small> smaller 122 µm: 98 – 100%</p> <p>Density 1.4 – 1.7 g/cm³ can vary depending on the colour; can be specified individually per colour on request</p>
Material consumption	$g/m^2 = \text{Density (g/cm}^3) \times \text{Film thickness (}\mu\text{m)}$
Coating thickness	<p>Recommended 70 – 90 µm depending on the colour</p> <p>Maximum 120 µm</p>
Application	<p>The application can be made with the usual electrostatic powder coating systems.</p> <p>Please read our technical recommendation for POLYFLEX powder coatings with metallic effect VR003D.</p> <p>To avoid any surface disturbances, we recommend not to mix this type of powder paint with any other powder .</p>
Packaging	<ul style="list-style-type: none"> - 20/25 kg cardboard - 500 kg Octobox - 450/500 kg Big Bag <p>Other packaging types are available on request.</p>
Baking diagram	<p>Curing time recommendation: 10 min by 180 °C object temperature</p>



Curing conditions:

210°C	4 min. hold time
200°C	5 min. hold time
190°C	7 min. hold time
180°C	10 min. hold time

Support

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:

- 1) Aluminium plate 0,8 mm AlMg1 H14 chromated
- 2) Steel sheet strip - galvanized and chromated as per GSB for hot-dip galvanization

Film thickness

- 1) 70 – 90 µm
- 2) 50 – 80 µm

Cross cut test

(DIN ISO 2409)

1) GT 0

2) GT 0

Mandrel bending test

(DIN ISO 1519)

1) < 5 mm

2) < 12 mm

Impact resistance

ASTM D 2794

front 1) > 5 Nm

2) > 5 Nm (~44 inchpound)

reverse 1) > 5 Nm

2) > 2.5 Nm* (~44 / 22 inchpound)

Erichsen cupping

(DIN ISO 1520)

1) > 5 mm

2) > 3 mm

Buchholz hardness

(DIN ISO 2815)

> 80 (for 1 and 2)

(*) 40-50 µm coating thickness at 20-25 °C
1 hour after coating

Resistance

tested on:

Aluminium plate 0,8 mm AlMg1 H14 chromated

Condensation water test

DIN ISO 6270

1000 h no bubble building

Infiltration of the scratch track under 1 mm

Salt spray test

DIN ISO 9227

1000 h no bubble building

Infiltration of 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 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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