



115m

P-1269

## Technical data sheet

Article No.: **12604**  
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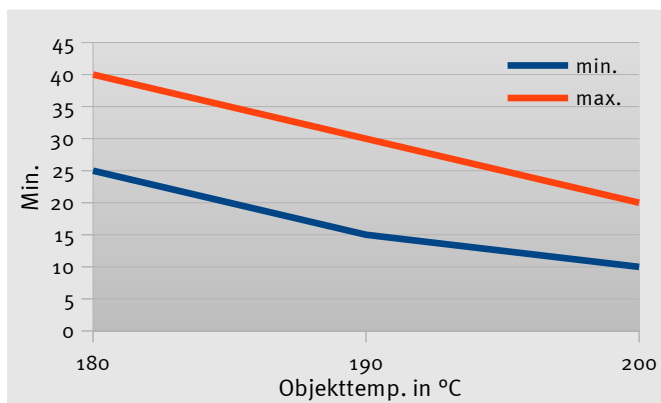
### POLYFLEX® PES-140-SD smooth highly weather resistant Corona Silk-matt 35

Silk matt powder coating for highly weather-resistant coatings for use in curtain walls based on polyester resin with excellent light and weather resistance, good smooth and excellent opacity. The weather resistance compared to standard facade powder is much higher. Cleaning cycles for facades can be extended. Stabilized against discoloration and burning gas-fired curing ovens in directly.

<b>Applications</b>	Metal facade, Aluminium profiles, sun protection systems, windows, doors, gates and many more	
<b>Colours</b>	Many colours with a few restrictions	
<b>Surface</b>	smooth	
<b>Gloss</b>	Silk-matt, 25-40 gloss units (60°)	
<b>Powder properties</b>	<b>Particle size distribution</b> (HELOS H1708)	smaller 29 µm: 40 – 47 % smaller 122 µm: 96 – 100%
	<b>Density</b>	1.4 – 1.7 g/cm <sup>3</sup> can vary depending on the colour can be specified per colour on request
<b>Material consumption</b>	g/m <sup>2</sup> =	Density (g/cm <sup>3</sup> ) x Film thickness (µm)
<b>Coating thickness</b>	Recommended	60 – 90 µm depending on the colour (white rather more 100 µm)
	Maximum	110 µm
<b>Application</b>	The application can be made with the usual electrostatic powder coating systems. To avoid any surfaces disturbances, we recommend not to mix this type of powder with any other powder paint.	
<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> Other packaging variations are available on request.	

#### Baking diagram

Curing time recommendation: 10 min at 200 °C object temperature



#### Curing conditions:

200°C 10 min. hold time  
 190°C 15 min. hold time  
 180°C 25 min. hold time

## Substrates

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** a suitable chemical pretreatment  
**Steel/Iron** iron or zinc phosphating

## Physical properties

tested on:

Aluminium plate 0,8 mm AlMg1  
H14 chromated

Film thickness  
60 – 90 µm

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

GT 0

**Mandrel bending test**  
(DIN ISO 1519)

≤ 5 mm\*

**Impact resistance**  
ASTM D 2794

front ≥ 2,5 Nm\* (~22 inchpound)  
reverse ≥ 2,5 Nm\* (~22 inchpound)

**Erichsen cupping**  
(DIN ISO 1520)

≥ 5 mm\*

**Buchholz hardness**  
(DIN ISO 2815)

≥ 80 (\*) cracks; no peeling with adhesive tape;  
with the naked eye

## Resistance

tested on:

Aluminium plate 0,8 mm AlMg1  
H14 chromated

**Condensation water test**  
DIN ISO 6270

1000 h no bubble building  
Infiltration on the scratch under 1 mm

**Salt spray test**  
DIN ISO 9227

1000 h no bubble building  
Infiltration on the scratch under 1 mm

## Material approval

**GSB Master** 115m  
**Qualicoat Class 2** P-1015

## 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

**Lower explosive limit** please refer to the safety data sheet

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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