



Technical Information

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 Leaflet No.: 2438
 Version: 02

POLYFLEX® PES-75-NT Rough, fast-reacting structure Tribo / Corona silk gloss

Low-temperature powder with a rough, silk gloss structure for indoor use based on polyester and epoxy resins; high level of opacity for universal use indoors. Curing can take place from as low as 150 °C.

Applications	Metal furniture, shelving parts, machine housings, switching cabinets, lamp housings, kitchen appliances, etc.
Color tones	All color tones.
Surface	Rough structure.
Gloss	Visually silk-glossy.

Powder properties	Particle size distribution (HELOS H1708)	smaller than 29 µm: 38 – 45 % smaller than 122 µm: 98 – 100%
	Density	1.4 – 1.8 g/cm ³ depending on color tone; can be specified for each color tone if required.

Material consumption	g/m ² =	density (g/cm ³) x coating thickness (µm)
Coating thickness	Recommendation:	80 – 100 µm according to color tone.
	Maximum:	150 µm

Application
 The coating can be applied with all typical powder coating systems, Tribo or Corona.
 In order to prevent surface blemishes, we recommend that you do not mix this powder coating type with other powder coatings.

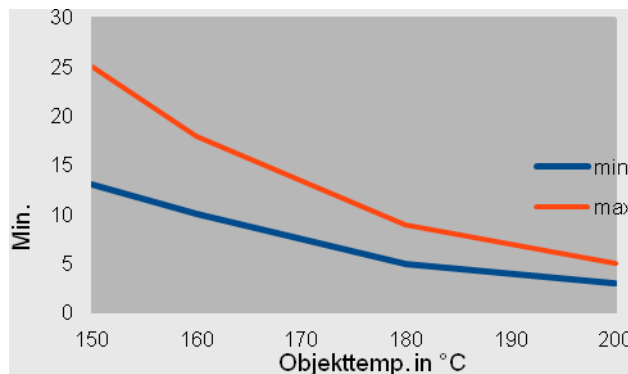
Packaging

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

Other packaging types are available on request.

Baking diagram

Curing recommendation: 10 minutes at 160 °C object temperature



Baking conditions:
 200°C 3 min. hold time
 180°C 5 min. hold time
 160°C 10 min. hold time
 150°C 13 min. hold time

Substrates

Various metals or as a finishing coat – for example, over a KTL primer. The substrate to be coated must be free of oil, grease and oxidation products. Under punishing conditions we recommend the following pretreatment:

Aluminum: A suitable (transparent) chromatinization or a similarly thorough chrome-free pretreatment or thin-layer anodization is to be performed.

Steel/iron: At least iron and preferably zinc phosphating is to be carried out. Pretreatment can be applied using dip or spray methods.

Physical properties

Tested on:

Steel sheet 0.8mm ST1405
double-pickled V1094

Layer thickness:
80 – 100 µm

Cross cut test GT 0
(DIN ISO 2409)

Mandrel bending test < 5 mm
(DIN ISO 1519)

Impact resistance testing front > 10 Nm (~88 inch pounds)
ASTM D 2794 reverse > 10 Nm (~88 inch pounds)

Erichsen cupping > 8 mm
(DIN ISO 1520)

Resistance

Tested on:

Iron-phosphated steel sheets

Condensation water test 500 h – no blisters formed
DIN ISO 6270 Infiltration at cross-cut less than 1 mm

Salt spray test 240 h – no blisters formed
DIN ISO 9227 Infiltration at cross-cut less than 1 mm

After-treatment of coated parts

Appropriate preliminary trials are recommended for printing, sticking, labeling, foil lamination, overcoating and other after-treatment methods. Suitable plasticizer-free materials must be used for the packaging. Condensation water must be avoided.

Touch-up

Our Rep. Set, art. no. 12155, is available for retouching work.

Storage

Storage conditions To be stored in original canister, in cool and dry conditions at max. 25 °C and not exposed to direct sunlight.

Duration of storage Up to 18 months as of production date under the conditions stated.

Safety advice

Lower explosion limit 40 g/m³

For additional information see the safety data sheet and the CEPE brochures "Sicheres Pulverlackieren" (Safe powder coating) and "Ergebnisse der experimentellen Toxikologiestudie über wärmehärtbare Pulverlacke" (Results of experimental toxicology study on heat-curable powder coatings).

Note:

We have provided the details relating to the properties and use of the specified products set out in this information sheet according to the knowledge available to us and our development work and practical experience. Due to the wide range of possible applications, it has not been possible to include all individual characteristics. In cases of doubt, our application experts are available to provide technical advice. The general terms and conditions of sale otherwise apply.

This leaflet is revised at intervals. If you are unsure about particular details, our sales department will be glad to advise you about the applicability of this documentation.



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