



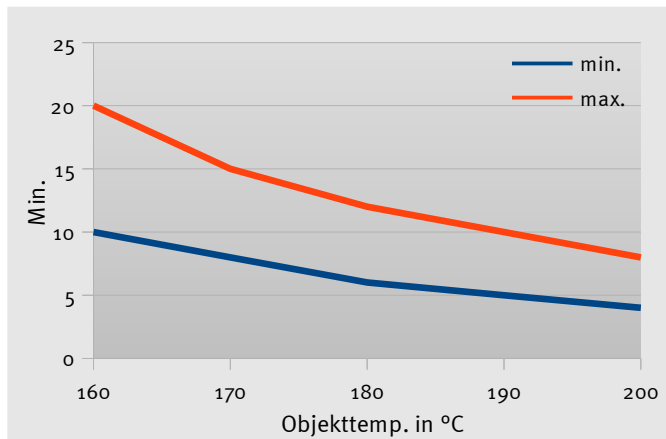
Technical data sheet

Article No.: **13519**
 Leaflet No.: 2460
 Version: 02

POLYFLEX® PES-166-NT smooth texture, fast reactive industrial quality Corona silk-gloss 75

Fast reactive, silk-gloss polyester powder for outdoor applications in the industrial area with good light and weather resistance, very nice smooth and very good covering power. Thanks to the high reactivity can be curing from 160 °C. Stabilized against discoloration and burning gas-fired curing ovens in directly.

Applications	Noise barriers, enclosures, sun protection systems, garden furniture, gardening tools, Air conditioners and fans, chassis and parts, doors, gates and many more	
Colours	many colours with a few restrictions	
Surface	smooth texture	
Gloss	Silk-gloss, 75-85 gloss units (60°)	
Powder properties	Particle size distribution (HELOS H1708) smaller 29 µm: 40 – 47 % smaller 122 µm: 99 – 100% 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	60 – 90 µm depending on the colour
	Maximum	120 µm
Application	It can be applied with the usual electrostatic powder coating systems. To avoid any surface disturbances, we recommend not to mix this type of powder with any other powder paint.	
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 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 – 90 µm

Cross cut test GT 0
(DIN ISO 2409)

Mandrel bending test < 6 mm
(DIN ISO 1519)

Impact resistance front > 2,5 Nm (~22 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

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/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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