

TECHNICAL DATA SHEET

Article No.: 10003	POLYFLEX® PES-55-NT coarse structure Corona silk gloss		
Version: 5			
Description:	Low bake powder for indoor use based on polyester and epoxy resins. Gives silk gloss surfaces with coarse structure. Stabilized against overcuring and discolouration in directly gas fired ovens.		
Applications:	Metal furniture, shelves elements, switch cabinets, lockers, machine cases, lampcasing, kitchen appliances and many more		
Colours:	Almost any colour with few limitations		
Surface:	Rough structure		
Gloss:	Visually silk gloss		
Powder properties:	Particle size distribution (HELOS H1708)	29 µm: 38 – 45 % 122 µm: 98 – 100 %	
	Density	1.4 – 1.8 g/cm³ can vary depending on the colour; can be specified for each individual colour	
Material consumption:	g/m²	= density (g/cm³) x film thickness (µm)	
Coating thickness:	Recommended	80 – 100 depending on the colour tone (closer to 120 µm in the case of white)	
Application:	The application can be made with all standard powder coating systems. This type of textured powder is very sensitive to foreign powder dust (colored stains) and can cause craters in smooth powder coatings. In order to achieve a uniform texture, the recommended coating thickness must be adhered to. If the coating thickness is too low, pores will form down to the substrate. Please read our processing instructions for textured powder coatings VR001D. To avoid surface defects, we recommend not mixing this type of powder coating with other powder coatings.		
Packaging:	- 20/25 kg cardboard box - 500 kg Octobox - 450/500 kg Big Bag Other packaging variations are available on request.		
Curing time:	Recommended	10 min. at 160°C object temperature	
	Object temperature	Minutes hold time min	Minutes hold time max
	200°C	3 min	6 min
	180°C	5 min	10 min
	160°C	10 min	24 min
	140°C	27 min	45 min
Substrates:	Various metals or also as a top coat, e.g. on a KTL primer. The substrate to be coated must be free of oil, grease and oxidation products. We recommend the following pre-treatments under load:		
	Aluminium	A suitable wet-chemical pretreatment or sweeping	
	Steel	Iron or zinc phosphating	
Physical properties:	Tested on 1): Steel panel 0.8 mm ST1405 pickled twice V1094 Layer thickness: 80 – 100 µm		
	Cross Cut test (DIN ISO 2409)	1) GT 0	

	Mandrel bending test (DIN ISO 1519)	1) ≤ 5 mm	
	Impact resistance (ASTM D 2794)	1) front	≥ 10 Nm (~88 Inchpound)
		1) reverse	≥ 10 Nm (~88 Inchpound)
	Erichsen cupping (DIN ISO 1520)	1) ≥ 7 mm	
Resistance:	Tested on: Steel panel iron phosphated		
	Condensation water test (DIN ISO 6270)	500 h no blistering Infiltration on the scratch track under 1 mm	
	Salt spray test (DIN ISO 9227)	240 h no blistering Infiltration on the scratch track under 1 mm	
Material Approvals:	-		
Repairs:	For repairs (conveyors hangers touch ups) the repair kit, art. No 10006124 is available.		
Post treatment of coated parts:	Appropriate preliminary tests are recommended for printing, gluing, labeling, film lamination, overcoating and other post treatments. Suitable plasticizer free materials are to be used for the packaging. Avoid condensation.		
Storage:	Storage instruction:	In the original containers, store in a cool and dry environment at 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 can be found in the safety data sheet and the CEPE brochures “safe powder coating guideline” and “results of the experimental toxicological studies on thermosetting powdercoatings”.		
Comments:	The information in 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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