

TECHNICAL DATA SHEET

Article No.: 12517 Version: 6	POLYFLEX® PES-125 transparent smooth Corona silk gloss 55		
Description:	Powder for outdoor use based on polyester resins. Gives transparent silk gloss surfaces with very good flow and good light and weather resistance. Stabilized against overcuring and discolouration in directly gas fired ovens.		
Applications:	As a protective colourless coat on already painted / coated surfaces, but also on glass, ceramic, aluminium, steel and various nonferrous metals (Pretests)		
Colours:	mostly colourless		
Surface:	Smooth		
Gloss:	Visually gloss 45 – 60 Gloss units (60°) on white primed panel		
Powder properties:	Particle size distribution (HELOS H1708)	29 µm: 40 – 47 % 122 µm: 96 – 100 %	
	Density	1.2 – g/cm ³ for colourless	
Material consumption:	g/m ²	= density (g/cm ³) x film thickness (µm)	
Coating thickness:	Recommended	70 – 90	
	Maximum	90 µm	
Application:	The application can be made with all standard powder coating systems. For exterior use, only apply to already painted/coated surfaces, not directly to metal! 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	15 min. at 180°C object temperature	
	Object temperature	Minutes hold time min	Minutes hold time max
	210°C	5 min	8 min
	200°C	7 min	11 min
	190°C	10 min	15 min
	180°C	15 min	22 min
	170°C	25 min	35 min
Substrates:	When overcoating already painted surfaces, it is essential to check adhesion in advance. For application directly to metal, the substrate must be free of oil, grease and oxidation products. We recommend the following pre-treatment if the surface is subject to corrosion:		
	Aluminium	A suitable wet-chemical pretreatment or sweeping	
	Steel	Iron or zinc phosphating	
	Not suitable for coating rims and valves.		
Physical properties:	Tested on 1): Aluminium panel 0.8 mm AlMg1 H14 chromated Layer thickness: 70 – 90 µm		

Cross Cut test (DIN ISO 2409)	1) GT 0
Mandrel bending test (DIN ISO 1519)	1) ≤ 4 mm
Impact resistance (ASTM D 2794)	1) front ≥ 5 Nm (~44 Inchpound) 1) reverse ≥ 5 Nm (~44 Inchpound)
Erichsen cupping (DIN ISO 1520)	1) ≥ 6 mm
Resistance:	Tested on: Aluminium panel 0.8 mm AlMg1 H14 chromated
Condensation water test (DIN ISO 6270)	1000 h no blistering Infiltration on the scratch track under 1 mm
Salt spray test (DIN ISO 9227)	1000 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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