



Technical data sheet

Article No.: **14512**
 Leaflet No.: 3137
 Version: 00

POLYFLEX® PES-140-SD QUALIBOND Pearl-Metallic smooth highly weather resistant Corona silk-gloss

Silk gloss polyester powder with a special pearl-metallic effect for use on facades with excellent light and weather resistance, good flow and very good coverage. The weather resistance compared to standard facade powder is much higher. Stabilized against burning and discoloration in direct gas-fired baking ovens.

Applications Metal façades, aluminum profiles, sun protection systems, windows, doors, gates and many more.

Colours According to special Pearl Metallic colour cards. Special colours on request.

Surface smooth

Gloss visually silk gloss

Powder properties **Particle size distribution** smaller 29 µm: 40 – 47%
 HELOS H1708 smaller 122 µm: 96 – 100%

Density 1.4 – 1.7 g/cm³ different depending on the colour can be specified per colour

Material consumption g/m² = Density (g/cm³) x film thickness (µm)

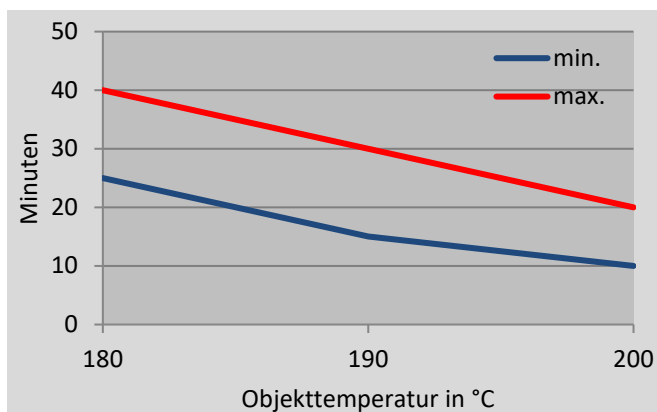
Coating thickness Recommended 60 – 90 µm depending on the colour
 Maximum 120 µm

Application The application can be made with all common electrostatic powder coating equipment. Please read our technical recommendation for POLYFLEX powder coating with metallic effect VR003D. To avoid any surface disturbances, we recommend not mixing this type of powder paint with any other powder.

- Packaging**
- 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 200 °C object temperature**



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

Support

Different metals, however mainly on pre-treated aluminium 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:

Aluminium a suitable chemical pre-treatment
Steel/Iron iron or zinc phosphating

Physical properties

tested on:

aluminium plate 0.8mm AlMg1
H14 chromated

Film thickness
60 – 80 µm

Cross cut test GT 0
DIN ISO 2409

Mandrel bending test ≤ 5 mm*
DIN ISO 1519

Impact resistance front ≥ 2.5 Nm* (~22 inchpound)
ASTM D 2794 reverse ≥ 2.5 Nm* (~22 inchpound)

Erichsen cupping ≥ 5 mm*
DIN ISO 1520

(*cracks; no peeling with adhesive tape,
with naked eye

Resistance

tested on:

aluminium plate 0.8mm AlMg1
H14 chromated

Condensation water test 1000 h no bubble building
DIN ISO 6270 Infiltration on the scratch track under 1mm

Salt spray test 1000 h no bubble building
DIN ISO 9227 Infiltration on the scratch track under 1mm

Material approval

GSB Master 115l

Qualicoat Class 2 P-1032

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. Perspiration water should 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 explosion 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 about 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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