

EPOXY POLYESTER [GREY]

Product code: EP-73- 7004
[Colour - RAL 7004]

Epoxy Polyester Grey RAL 7004 powder coatings for electrostatic application.

USES

Ideal for home appliance and for manufacturing that no need to resist to outdoor exposure. In general the epoxy polyester is used in the application of manufacturing that need good compromise of mechanical resistance and chemistry resistance, the usage is suggested in the home appliance application and for all the manufacturing that need this type of compromise (washing machine, dishwasher, radiator, refrigerator, freezer,internal automotive part,electric panels,etc...)

PROPERTIES

Excellent Mechanical properties
Excellent flow and aspect
Good chemical resistance
Very good Finishes

APPLICATION

Electrostatic Corona

SUBSTRATE

Cold rolled steel

COLOR

GREY, RAL 7004

APPEARANCE

SemiGlossy Smooth

SPECIFIC GRAVITY [MTDSLC149] Kg/l

1.650 - 1.750 Kg/L

SPREADING RATE [Mileage] a 60 µm

9.5 - 10.1 m²/Kg

PARTICLE SIZE DISTRIBUTION [MTDSLC151] µm

42 - 48 µm

CURING CONDITION

15' @ 180 °C m.t in standard conditions - metal temp.

[The film obtained maintains its property if the polymerization conditions are respected]

SHELF LIFE & STORAGE @20°C

24months in the original boxes

PACKAGING

20 Kg cardboard boxes.

[Also available in Big Bags or containers upon request]

SURFACE PREPARATION

For Steel:

All surfaces must be dry, clean and free from contaminants. It is suggested a good substrate cleaning as required (sand blasting - degreasing - phosphatizing or chromating, etc...).

For Aluminum:

In order to obtain optimal anti-corrosion properties, it is advised to apply a chemical pretreatment prior to powder coating application.

APPLICATION DATA

Applied by electrostatic corona spraying using classic devices which can provide a negative tension of 60-80 kV. The powder is cured in a suitable convection or combustion, or induction, etc...

DRY FILM CHEMICAL & MECHANICAL RESISTANCE

All test have been effectuated on UNI 0.5mm thickness panel cured polymerization conditions standards

Test film thickness :@80µm.

Test	Method	Range
Film Thickness	IMOA001	60 - 80 µm.
Gloss (60°)	IMOA002	50 - 70 gloss.
Adhesion	IMOA003	90 - 100% GTO
Cupping Erichsen	IMOA004	8 - 10 mm.
Direct Impact [2lbs-½ inch]	IMOA004	80 - 100 cm. [No cracking]
Indirect Impact [2lbs-½ inch]	IMOA005	80 - 100 cm. [No cracking]
Pencil Hardness	IMOA001	B - F

Resistance to common synthetic resistance [72hrs. in 3% solution]

- No blistering or loss of adhesion no significant change in appearance

Salt spray resistance [ASTM B117-73] on Chromate Aluminum

- No blistering or loss of adhesion during [2000hrs.]

Humidity Resistance [ASTM D2247] on Chromate Aluminum

- No blistering or loss of adhesion during [1000hrs.]