EVI VERNICI
PAINTS & COATINGS SOLUTIONS

POWDER COATING DIVISION

Technical Data Sheet

Polyester - Red

Product code: PO/24-3005
Color: RAL 3005

Composition and Application Field

Polyester Red powder coating is a thermosetting powder coating based on saturated polyester resins especially selected for exterior use. Its good flow out and excellent resistance to atmospheric ageing environment. This pwoder coating product is applicable for electrostatic application.
Product meets most of the international requirements and specifications such as [Qualicoat]
Ideal for outdoor furniture providing excellent resistance, applicable for all type of manufactures who are in need for similar type of manufacturers who are in need for similar type product such as: [fencing, air conditioning, lawn and garden equipment, mailboxes, construction equipment, light stand, etc...]

Properties

- Excellent flexibility
- Mechanical properties
- UV resistance
- Outstanding finishes
- V. Good corrosion resistance

Substrates

Cold rolled steel

Colors

Red Ral 3005

Appearance

Matt (provides smooth surface)

Specific Gravity (MTDSLC149) Kg/l

Approx. 1.500 – 1.600 Kg/L

Spreading Rate (Milage)

Approx. 10.4 – 11.1m2/Kg [optimal film thickness @ 60µm]

Particles Size Distribution (MTDSLC151) µm

Approx. 42 – 48 µm

Curing Condition

20' @ 190°C m.t in standard conditions – metal temp.
[The film obtained maintains its property if the polymerization conditions are respected]

Storage

24 months when stored in dry and cool conditions @ 20°C, in original sealed containers.

Packing

20 Kg cardboard boxes.
[Also available in Big Bags or containers upon request]

Surface Preparation

For Steel: All surfaces must be dry, clean & free from contaminators. It is suggested a good substrate cleaning as required (sand blasting, degreasing, phosphatizing or chromatizing, 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 suitable convection, 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	30 – 40 gloss
Adhesion	IMOA003	90 – 100% GTO
Cupping Erichsen	IMOA004	8 – 10 mm
Direct Impact	IMOA004	80 – 100 cm
[2lbs-½ inch]		No Cracking
Indirect Impact	IMOA005	80 – 100 cm
[2lbs-½ inch]		No Cracking
Pencil Hardness	IMOA001	HB - F

Resistance to common synthetic resistance (72 hrs. 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 (2000 hrs.)
Humidity Resistance (ASTM D2247) on Chromate Aluminum: No blistering or loss of adhesion during (1000 hrs.)

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