

**GENERAL FEATURES**

This thermosetting powder contains polyester resins cured with fit curing agents specially selected for their excellent resistance to UV radiation and outdoor weathering.

The powder forms a decorative film with enhanced outdoor resistance.

The Inverpul Polyester/M were created for coating aluminium components used in architecture and for coating galvanised steel and have all the necessary requirements for approval of the GSB specification (licence 152f).

The Inverpul Polyester/M Cat. 1 have also all the necessary requirements for approval of the Qualicoat class 1 category 1 (licence P-0587) specification.

**APPLICATION**

Due to its special content the product is particularly suggested for exterior coating.

**ADVISED CYCLES**

The surface to be coated must be cleaned from oils, grease or flash rust.

If particular resistance to corrosion or humidity is required, it is suggested the following pretreatment of the surface:

for aluminium	chromate conversion according to DIN 50939
for steel	sand blasting or/and iron or zinc phosphatising
for galvanised steel	chromatising

**HANDLING AND STORAGE**

Store at temperatures lower than 30°C; higher temperatures may damage the powder by causing undesired alterations or blobs.

Storage life in original package: 12 months.

**TECHNICAL DATA**

Code	Int. Method	Range	Ref. Method
P/CL092	Calc.specific gravity(kg/l):	1.25 - 1.800	
P/YC060	Particle size dist. >32µ(%):	48 - 54	
P/YC120	Particle size dist. >63µ(%):	87 - 93	
P/CL143	1µm Theor.spread.rate (m2/kg):	550 - 780	

**WAYS OF APPLICATION**

Apply with guns with negative terminal (60/80KV) or triboelectric guns automatically or manually.

It is advised to apply the product in layers with the thickness of 60-80 microns and to stove at 190°C for 20 minutes (temperature of the support).

For stoving of the Polyester/M products it is possible to use the following curing windows:

10-15 minutes	200°C (temperature of the support)
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15-25 minutes	190°C (temperature of the support)
20-35 minutes	180°C (temperature of the support)

For stoving use the given indications.

**TECHNOLOGICAL FEATURES AND RESISTANCE TESTS**

The support used	aluminium sheet
Thickness	60 microns
Stoving	20 minutes at 190°C
Appearance and levelling	very good

Chemical resistance test by immersing for 48 hours at indoor temperature into:

Hydrochloric acid 10 %	film is intact
nitric acid 30 %	matt, but washing off
saturated hydrogen sulphide	intact
hydrogen peroxide 40 volumes	intact
ammonium hydroxide 10 %	intact
ammonium hydroxide 33 %	intact
sodium hydroxide 5 %	intact
tartaric acid 5 %	intact
sodium hydroxide 5 %	intact
citric acid 5 %	intact
lactic acid 5 %	intact
ethanol	intact
N-butanol	intact
petroleum ether	slightly softened

The chemical resistance test was carried out on chromatised aluminium.

Code	Int. Method	Range	Ref. Method
P/CC050	Gloss 60° :	25.0 - 35.0	UNI EN ISO 2813:2001
P/CM010	Buchholz indentation test :	more than 90	UNI EN ISO 2815
P/CM040	Erichsen cupping test (mm):	more than 5	UNI EN ISO 1520
P/CM050	Direct impact test (cm.Kg):	more than 25	UNI 8901
P/CM051	Opposite impact test(cm.kg):	more than 25	UNI 8901
P/CM080	Cylindrical mandrel size 4 does not break :		UNI EN ISO 1519
P/CM100	Crosscut adhesion (2mm)(GT):	00	UNI EN ISO 2409
P/CM230	Resistance to humidity : (Humidity test)	1000 hours later - no blistering, indentation along the cross of maxi-	UNI 8744

Our technical data sheets represent the results of the lab tests; they do not have binding value.

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		mum 1 mm	

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