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|-----------|--|
| Group | 611 – Polyester High Durable |
| Curing | min: 180°C @ 20' to 30' max: 200°C @ 10' to 13' |
| Surface | Smooth gloss appearance |
| Gloss | 80 - 100 (60°) |
| Approvals | Qualicoat class 2 category 3 (licence P-0985) GSB Florida 3 Quality (licence 152h) |

PRODUCT DESCRIPTION

PE/P/HD is a glossy, superdurable thermosetting polyester powder coating delivering superior resistance to UV radiation and outdoor weathering.

PE/P/HD was created to protect and decorate aluminium and galvansied steel components used in fenestration projects in high UV/tropical climates.

PE/P/HD provides a high level of gloss and colour retention for Agricultural and Construction Equipment increasing the resale value of these vehicles.

Storage Life:

Store at temperatures lower than 30°C.
Storage life in original package: 24 months.

CHARACTERISTICS

Spec. Gravity (kg/l): 1,25 – 1,70
DFT (micron): 60 - 80
Theoretical Coverage @60um: 11 m²/kg

Recommended film thickness:
Dry: 60 - 80 µm

Reaction To Fire EN 13501-1

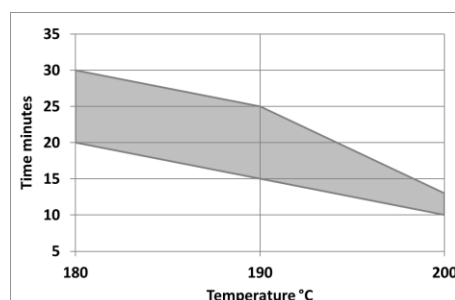
Classification: A2-s1, d0

APPLICATION

Suitable for automatic and manual electrostatic application
Please contact your Sherwin-Williams representative to discuss tribo-static application

Curing Cycle

| Time | Substrate temperature |
|-----------|-----------------------|
| 10-13 min | 200°C |
| 15-25 min | 190°C |
| 20-30 min | 180°C |



CHEMICAL RESISTANCE

Immersion testing for 48 hours at ambient temperature:

| Chemical | Effect |
|-------------------------|-----------------------|
| hydrochloric acid 10 % | No change |
| Nitric acid 30 % | matt, but washing off |
| Sulphuric acid 10% | No change |
| hydrogen peroxide 40 vv | No change |
| ammonium hydroxide 10% | No change |
| ammonium hydroxide 33 % | No change |
| sodium hydroxide 5% | No change |
| tartaric acid 5% | No change |
| citric acid 5% | No change |
| lactic acid 5% | No change |
| ethanol | No change |
| N-butanol | No change |
| petroleum ether | slightly softened |

SUBSTRATE PREPARATION

The surface treatment should be chosen according to the type of substrate and the required performance.

The surface to be coated must be free from oxidation, oil, grease or any other form of contamination.

A good quality pretreatment process is recommended for optimum performance, certified products can be found via Qualicoat, GSB or Qualisteelcoat.

Final user should select the proper pretreatment based on corrosion resistance performance.

Where required, the corrosion resistance can be enhanced using a primer system.

| | | Substrate | | | | |
|------------|--|-----------|-------|------------------|------------------|--|
| | | Aluminum | Steel | Galvanized Steel | Metallized Steel | |
| Chemical | Cr-free (Zr, Ti, Oxilanes or alternatives) | ✓ | | ✓ | | |
| | Pre-anodising | ✓ | | | | |
| | Chromate | ✓ | | ✓ | | |
| | Phospho-chromate | ✓ | | | | |
| | Iron phosphate | | ✓ | | | |
| | Zinc phosphate | | ✓ | ✓ | | |
| | Nano-ceramic | | ✓ | | | |
| Mechanical | Sand blasting | | ✓ | | | |
| | Soft blasting | | | ✓ | ✓ | |
| | Sweeping | | | ✓ | ✓ | |

PERFORMANCE DATA

60 µm coating applied to an aluminium test panel (ALQ-36) cured 20 minutes at 180°C satisfied the following requirements,

Gloss 60° :

80.0 - 100.0

UNI EN ISO 2813:2014

Buchholz indentation test:

more than 90

UNI EN ISO 2815

Erichsen cupping test (mm):

more than 5

UNI EN ISO 1520

Direct impact test (cm.Kg):

more than 25

ASTM D 2794; ISO 6272-2:2002

Reverse impact test(cm.kg):

more than 25

ASTM D 2794; ISO 6272-2:2002

Crosscut adhesion (2mm) (GT):

Class 0

UNI EN ISO 2409

Acetic salt fog test :

Meets requirements of Qualicoat and GSB International specifications

Resistance to humidity : 1000 hours

no blistering, indentation along the cross of maximum 1mm

Accelerated Weathering:

ISO 16474-2 Method A (daylight filters) –
Cycle 1 1000hrs, >90% retained gloss

Florida Weathering:

3 years 5° south facing
>50% Retained gloss

CAUTION

FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label and Safety Data Sheet (SDS) prior to using this product.

A Safety Data Sheet is available from your local Sherwin-Williams facility or distributor

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the user obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in user handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.