



Group	421 – Epoxy Low Bake Gloss
Curing	min: 160°C @ 20' to 30' max: 180°C @ 10' to 15'
Surface	Smooth glossy
Brilliance	85 - 95 (60°)
Approvals	

PRODUCT DESCRIPTION

Epoxy based thermosetting powder coating designed to cure at low temperature (160°C). The product forms a smooth hard film with good resistance to mechanical damage and excellent chemical resistance to acids, alkalis, detergents, fuels and oils.

It is designed as an interior coating and is suitable for a wide range of applications including racking and shelving, laboratory furniture, metal office furniture.

Storage Life:

Store at temperatures lower than 30°C. Storage life in original package: 18 months.

CHARACTERISTICS

Spec. Gravity (kg/l): 1,25 – 1,65
DFT (micron): 60 - 80
Theoretical Coverage @60um: 11 m²/kg

Recommended film thickness:

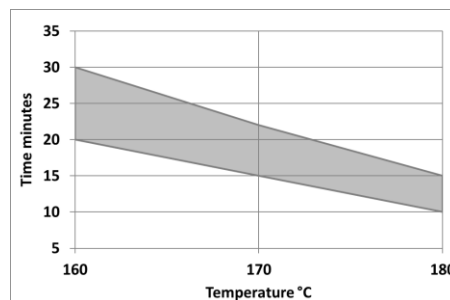
Dry: 60 - 80 µm

APPLICATION

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

Curing cycles

Time	Substrate temperature
10 - 15 min	180°C
15 - 22 min	170°C
20 - 30 min	160°C



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.

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

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

Pretreatment	Substrate				
	Aluminum	Steel	Galvanized Steel	Metallized Steel	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

The hardness test was carried out on zinc phosphatised steel.

A test panel steel (UNI sheet), DFT 60 microns, stoving 25 minutes at 160°C satisfied the following requirements:

Buchholz indentation test :

more than 90
UNI EN ISO 2815

Pendulum-rocker hardness :

Persez pendulum
more than 300
UNI EN ISO 1522

Erichsen cupping test (mm):

more than 3
UNI EN ISO 1520

Direct impact test (cm.Kg):

more than 20
ASTM D 2794; ISO 6272-2:2002

Conical mandrel : Bend test

Maximum 20mm
UNI EN ISO 6860

Crosscut adhesion (2mm) (GT):

Class 0
UNI EN ISO 2409

Salt fog test :

1000 hours
later - indentation
along the cross of 3-6 mm
UNI ISO 9227

Resistance to humidity:

(Humidity test) 500 hours
no change
UNI EN ISO 6270-2:2005

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.