# INVERPUL PE/P BT FTX

PUL PE/P Low Bake FineTextured serie 229

| | |
|---|---|
| Group | 229 – Polyester Low Bake |
| Curing | min: 160°C @ 20' to 40' \| max: 190°C @ 6 to 11' |
| Surface | Fine Textured appearance |
| Gloss | N/A |
| Approvals | |

## PRODUCT DESCRIPTION

A low bake TGIC-free thermosetting polyester powder coating featuring excellent resistance to UV radiation and outdoor weathering.

The product forms a protective and decorative film with enhanced outdoor resistance.

The fine texture finish imparts elegant aesthetics to the coated part.

The product is particularly suited to exterior applications and is suitable for use in a wide range of applications, including metal office furniture, lockers, fenesrtation products, conservatories, garden furniture, street 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 $m^2$/kg

**Recommended film thickness:**

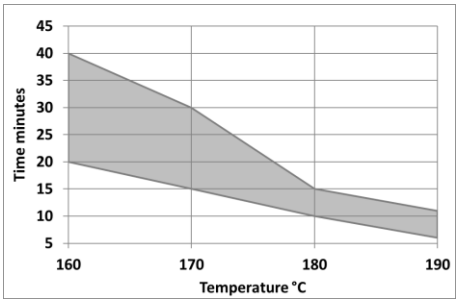
- Dry: 60 - 80 µm

## APPLICATION

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

**Curing Cycle**

| Time | Substrate temperature |
|---|---|
| 6 – 11 min | 190°C |
| 10 - 15 min | 180°C |
| 15 - 30 min | 170°C |
| 20 - 40 min | 160°C |




## CHEMICAL RESISTANCE

Immersion method for 48 hours at ambient temperature into:

| CHEMICAL | RESULTS |
|---|---|
| Hydrogen chloride 10% | intact |
| 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 |
| Citric acid 5% | intact |
| Lactic acid 5% | intact |
| Ethanol | intact |
| N-butanol | intact |
| 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.

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 | | | |
|---|---|---|---|---|---|
| Pretreatment | | 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 | | | ✓ | ✓ |

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## PERFORMANCE DATA

A zinc phosphated steel test panel (UNI sheet), DFT 60 microns,Stoving 20 minutes at 160°C
satisfied the following requirements,

**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

**Conical mandrel : Bend test**
Maximum 10 mm
UNI EN ISO 6860

**Crosscut adhesion (2mm) (GT)**:
Class 0
UNI EN ISO 2409

**Salt spray test** :
1000 hours
Scribe creep 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.