



Group	310 – Hybrid (Epoxy Polyester) Low Thickness
Curing	min: 180°C @ 20' to 30'   max: 200°C @ 10 to 15'
Surface	Smooth appearance
Brilliance	Available in gloss, satin or matt finish
Approvals	

**PRODUCT DESCRIPTION**

This thermosetting powder contains epoxy and polyester resins. The product forms a level hard film with good resistance to mechanical damage, most chemicals, such as detergents, fuels and oils. It has good resistance to yellowing caused by the chain stop during stoving. The product is designed for interior coating and has excellent protective and decorative effects.

**Storage Life :**

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

**CHARACTERISTICS**

**Spec. Gravity (kg/l):** 1,30 – 1,90  
**DFT (micron):** 45 - 65  
**Theoretical Coverage (m2/Kg @60µ):** 11

**Recommended film thickness:**

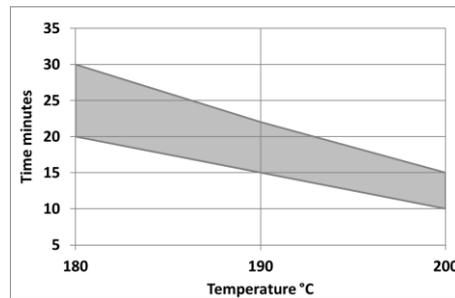
- Dry: 45 - 65 µm

**APPLICATION**

Suitable for automatic and manual electrostatic application. Please contact your Sherwin-Williams representative to discuss tribo-static application. Optimum performance is achieved with a dry film thickness of 60-80 microns.

**Curing Cycle**

Time	Substrate temperature
10 - 15 min	200°C
15 - 22 min	190°C
20 - 30 min	180°C



**SUBSTRATE PREPARATION**

The surface to be coated must be free from oils, grease or flash rust. If particular resistance to corrosion or humidity is required, it is suggested the following pretreatment of the surface:

**Aluminum:** chromate, phospho-chromate conversion (DIN 50939) or other Cr-free pretreatment

**Steel:** sand blasting or/and iron or zinc phosphatizing

**Galvanized steel:** chromate (DIN 50939), phosphate or Cr-free pretreatment

**PERFORMANCE DATA**

A test panel zinc phosphatised steel (UNI sheet), DFT 60 microns, stoving 10 minutes at 200°C satisfied the following requirements,

**Buchholz indentation test :**

more than 90  
 UNI EN ISO 2815

**Pendulum-rocker hardness :**

Persoz 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

**Reverse impact test (cm.kg):**

more than 5  
 ASTM D 2794; ISO 6272-2:2002

**Conical mandrel : Bend test**

Maximum 20 mm  
 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.