

Group	631 – Polyester High Durable Low Bake (Heavy Equipment)
Curing	min: 160°C @ 15' to 35' max: 180°C @ 10' to 25'
Surface	Smooth, gloss appearance
Brilliance	70 - 100 (60°)
Approvals	

PRODUCT DESCRIPTION

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

PE/P/HD BT was created to protect and decorate steel and galvansied steel components in the heavy machinery market. Being low bake (BT) it is particularly suited for fast line speeds or to coat heavy gauge components.

PE/P/HD BT provides a high level of gloss and colour retention for Agricultural and Construction Equipment.

Storage Life :

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

CHARACTERISTICS

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

Recommended film thickness:

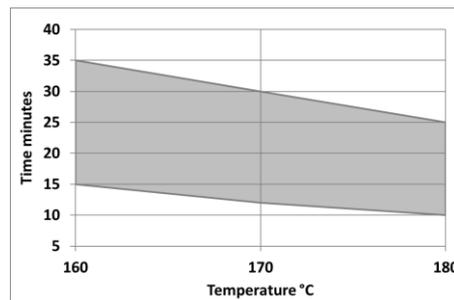
Dry: 60 - 80 µm

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 -25 min	180°C
12 - 30 min	170°C
15 - 35 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, 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.

Pretreatment		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

A test panel with Bonderite 1000, DFT 60 microns, stoving 20 minutes at 160°C satisfied the following requirements,

Gloss 60° :

70 - 100

UNI EN ISO 2813:2014

Buchholz indentation test:

more than 90

UNI EN ISO 2815

Pendulum-rocker hardness :

Persozendulum

more than 300

UNI EN ISO 1522

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

Crosscut adhesion (2mm) (GT):

Class 0

UNI EN ISO 2409

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.