Technical Data Sheet

- BOND PE/PA SENZA ALLUMINIO serie 285

GENERAL FEATURES

This thermosetting powder contains polyester resins cured with fit curing agents.
The product forms a level hard film with good resistance to mechanical damage, detergents and yellowing. Chemical resistance of the product results good.
The metallic effect pigment is fixed on the powder by means of a bonding process, thanks to which is possible to achieve the best results in terms of application and reproducibility for the metallic effect powders. The problems of separation in the powdercloud during the application process, typical of dry blend products, are so eliminate, with positive effects on the colour constancy.

APPLICATION

Due to its chemical nature it is particularly suitable for the coating and protection of appliances that require good resistance to overbaking and yellowing with good stability of gloss.
These coatings are suggested for the coating of articles for the kitchen, oven doors, splash guard for kitchens and radiators.
Good thermal stability in case of exposure of the manufactured articles painted with this product at temperatures up to 200 ° C, in particular not observed change in terms of colour and appearance, good adhesion and mechanical properties.
To avoid variation of the metallic effect due to repeated surface rubbing and metallic pigment release on the surfaces in contact with the coating, it is suggested a double coat with transparent PE/PA.

ADVISED CYCLES

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

for steel	sand blasting or/and iron or zinc phosphatising
for galvanised steel and aluminium	chromatising

HANDLING AND STORAGE

Store at temperatures lower than 30°C; higher temperatures may damage the powder by causing undesired alterations or blobs.
Keep the product away from umidity.
Storage life in original package: 18 months.

TECHNICAL DATA

Code	Int. Method	Range	Ref. Method
P/CL092	Calc.specific gravity(kg/l):	1.25 - 1.650	
P/YC060	Particle size dist. <32µm (%):	36 - 46	
P/YC120	Particle size dist. <63µm (%):	74 - 91	
P/CL143	1µm Theor.spread.rate (m2/kg):	540 - 780	

WAYS OF APPLICATION

Apply with guns with negative terminal (60/80KV) or triboelectric guns automatically or manually.
It is advised to apply in layers with the thickness of 60-80 µ and to stove at 190°C for 20 minutes (temperature of the support).
For stoving the PE/PA products it is possible to use the following combinations of time and temperature:

12-15 minutes	200°C (temperature of the support)
20-25 minutes	190°C (temperature of the support)

For stoving use the given indications.

TECHNOLOGICAL FEATURES AND RESISTANCE TESTS

The support used	UNI sheet

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Thickness	60 microns
Stoving	20 minutes at 190°C

The chemical resistance test was carried out on zinc phosphatised steel.

Code	Int. Method	Range	Ref. Method
P/CM040	Erichsen cupping test (mm):	more than 5	UNI EN ISO 1520
P/CM050	Direct impact test (cm.Kg):	more than 25	ASTM D 2794; ISO 6272-2:2002
P/CM051	Reverse impact test(cm.kg):	more than 25	ASTM D 2794; ISO 6272-2:2002
P/CM170	Conical mandrel : Bend test	maximum 10 mm	UNI EN ISO 6860
P/CM100	Crosscut adhesion (2mm)(GT):	00	UNI EN ISO 2409
P/CM190	Salt fog test :	1000 hours later - indentation along the cross of 3-6 mm	UNI ISO 9227

NOTE TO USER

The information contained in this document while based on evidence and reliable methods can not be considered exhaustive.
This information are current to the date of issuance of this data sheet, therefore is under user's responsibility to verify that the data provided on this sheet are current to the date of the product.
The user, under its own responsibility, shall respect all the existing provisions on hygiene and safety and shall verify every time the features and the specific and appropriate way to use the product, cause the respect of the provisions is not under producer's direct control.
The manufacturer does not guarantee nor assume any liability or responsibility for whatsoever harm that might result from a misuse of the product or for damages that have arisen after the product's distribution.

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