



Group	322 – Hybrid (Epoxy Polyester) Low Bake Semi-Gloss
Curing	min: 160°C @ 20' to 30'   max: 180°C @ 10' to 15'
Surface	Smooth satin appearance
Gloss	35.0 - 85.0 (60°)
Approvals	

### PRODUCT DESCRIPTION

This thermosetting powder with epoxy and polyester resins is designed to cure at low temperature (160°C).

The product forms a level hard film with good resistance to mechanical damage and chemicals, typically detergents, fuels and oils.

It has good resistance to yellowing caused by the chain stop during stoving.

The product has excellent protective and decorative effects.

It is designed for internal applications and is particularly suited to fast track speeds or for coating heavy mass parts.

Typical uses include coating metal office furniture, lockers, racking, shelving, partitioning.

#### **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<sup>2</sup>/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
10-15 min	180°C
15-20 min	170°C
20-30 min	160°C

### SUBSTRATE PREPARATION

The surface to be coated must be free from oil, grease and flash rust.  
A good quality pre-treatment process is recommended for optimum performance.

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

**Steel:** sand blasting or/and iron or zinc phosphatizing or nano-ceramic pretreatments

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

**PERFORMANCE DATA**

A 60um coating applied to steel test panel (UNI sheet) cured 25 minutes at 160°C satisfied the following requirements,

**Gloss 60° :**

35 - 85

UNI EN ISO 2813:2014

**Buchholz indentation test:**

more than 90

UNI EN ISO 2815

**Pendulum-rocker hardness :**

Persozpendulum

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 20mm

**Crosscut adhesion (2mm) (GT):**

Class 0

UNI EN ISO 2409

**Salt fog 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.