



Group	338 – Hybrid (Epoxy Polyester) Fast Low Bake Rough Texture
Curing	min: 140°C @ 25' to 40' max: 180°C @ 4' to 10'
Surface	Rough texture
Gloss	N/A
Approvals	

PRODUCT DESCRIPTION

Epoxy-polyester ultra low bake thermosetting powder coating which forms a hard film with good resistance to mechanical damage and chemicals, such as detergents, fuels and oils. It has good resistance to yellowing caused by the chain stop during stoving.

It is designed as an interior coating and is suitable for a wide range of applications including racking and shelving, metal office furniture, radiators, white goods.

The fast cure makes it ideally suited to coat heavy items, heat sensitive components or fast track speeds.

Storage Life:

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

CHARACTERISTICS

Spec. Gravity (kg/l): 1,40 – 1,88
DFT (micron): 90 - 110
Theoretical Coverage @60um: 6 m²/kg

Recommended film thickness:

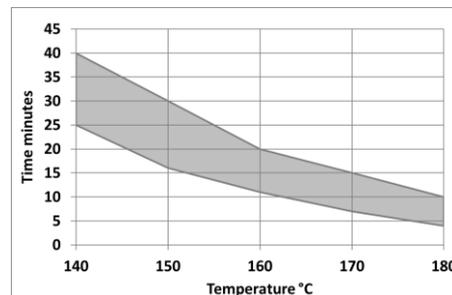
Dry: 90 - 110 µm

APPLICATION

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

Curing Cycles

Time	Substrate temperature
4-10 min	180°C
7-15 min	170°C
11-20 min	160°C
16-30 min	150°C
25-40 min	140°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

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

PERFORMANCE DATA

The hardness test was carried out on zinc phosphatised steel. Steel test panels with 90um of coating cured 25 minutes at 140°C satisfied the following requirements:

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 10mm
 UNI EN ISO 6860

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.