



Group	326 – Hybrid (Epoxy Polyester) Low Bake – Metalic with aluminium
Curing	min: 160°C @ 20' to 30' max: 180°C @ 10' to 15'
Surface	Smooth metallic appearance
Brilliance	N/A
Approvals	

PRODUCT DESCRIPTION

A hybrid thermosetting powder coating designed for low temperature cure (160°C).

The product forms a level hard film with good resistance to mechanical damage.

A robust metallic effect coating suitable for a wide variety of general industrial uses on aluminium, steel and galvanised steel.

The low curing temperature makes this product ideally suited to coating large fabrications.

It has good resistance to yellowing caused by the chain stop during stoving. suggested for interior coating.

To maintain the aesthetics in high traffic or aggressive environments, it is recommended to apply a clearcoat.

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 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
10-15 min	180°C
15-22 min	170°C
20 - 30 min	160°C

To maintain a consistent color/effect it is important for the coater to control the ratio of virgin to reclaim Powder. A minimum 70% virgin powder is recommended.

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

A steel test panel (UNI sheet) with a coating layer of 60 microns cured at 25 minutes at 160°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 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.