



Group	611 – Polyester High Durable
Curing	min: 180°C @ 20' to 30' max: 200°C @ 10' to 13'
Surface	Smooth gloss appearance
Gloss	80 - 100 (60°)
Approvals	Qualicoat class 2 category 3 (licence P-0985) GSB Florida 3 Quality (licence 152h)

PRODUCT DESCRIPTION

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

PE/P/HD was created to protect and decorate aluminium and galvansied steel components used in fenestration projects in high UV/tropical climates.

PE/P/HD provides a high level of gloss and colour retention for Agricultural and Construction Equipment increasing the resale value of these vehicles.

Storage Life:

Store at temperatures lower than 30°C. Storage life in original package: 24 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

Reaction To Fire EN 13501-1

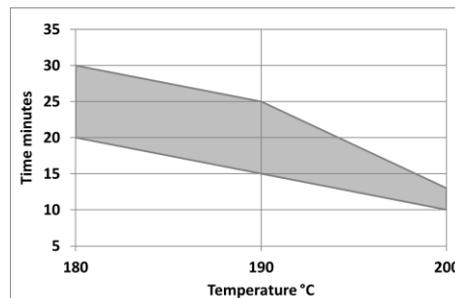
Classification: A2-s1,d0

APPLICATION

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

Curing Cycle

Time	Substrate temperature
10-13 min	200°C
15-25 min	190°C
20-30 min	180°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

CHEMICAL RESISTANCE

Immersion method for 48 hours at ambient temperature:

CHEMICAL	RESULT
hydrogen chloride 10 %	- film intact
nitric acid 30 %	matt, but washing off
saturated hydrogen sulphide	- film intact
hydrogen peroxide 40 volumes	- film intact
ammonium hydroxide 10 %	- film intact
ammonium hydroxide 33 %	- film intact
sodium hydroxide 5 %	- film intact
tartaric acid 5 %	- film intact
citric acid 5 %	- film intact
lactic acid 5 %	- film intact
ethanol	- film intact
N-butanol	- film intact
petroleum ether	- slightly softened

PERFORMANCE DATA

60um coating applied to an aluminium test panel (ALQ-36) cured 20 minutes at 180°C satisfied the following requirements,

Gloss 60° :

80.0 - 100.0

UNI EN ISO 2813:2014

Buchholz indentation test:

more than 90

UNI EN ISO 2815

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

Crosscut adhesion (2mm) (GT):

Class 0

UNI EN ISO 2409

Acetic salt fog test :

Meets requirements of Qualicoat and GSB International specifications

Resistance to humidity : 1000 hours

no blistering, indentation along the cross of maximum 1mm

Accelerated Weathering:

ISO 16474-2 Method A (daylight filters) –
Cycle 1 1000hrs, >90% retained gloss

Florida Weathering:

3 years 5° south facing
>50% Retained gloss

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.