INVERPUL MP BT FTX

PUL MP BT FINE TEXTURED serie 329

Group	329 – Hybrid (Epoxy Polyester) Low Bake
Curing	min: 160°C @ 20' to 30' | max: 180°C @ 10' to 15'
Surface	Fine Textured appearance
Gloss	N/A
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.

Inverpul MP BT FTX is designed for internal applications.

The fine texture appearance hides surface defects so the product adding a quality finish to improve aesthetics.

The low bake feature makes the product suitable for use on high volume lines and for coating heavy gauge components.

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^2/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

SUBSTRATE PREPARATION

The surface to be coated must be free from oil, grease and flash rust.
A good quality pre-treatment process if recommend 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 a steel test panel (UNI sheet) cured 15 minutes at 170°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 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.