INVERBOND PE/P AL

BOND PE/P WITH ALUMINIUM serie 214

Group	214 – Polyester Bonded Metallic With Aluminium
Curing	min: 180°C @ 20' to 40' | max: 200°C @ 10' to 20'
Surface	Smooth, metallic effect
Gloss	N/A
Approvals	

PRODUCT DESCRIPTION

A metallic effect TGIC-free thermosetting polyester powder coating featuring excellent resistance to UV radiation and outdoor weathering.
The powder forms a protective and decorative film with enhanced outdoor resistance.

The PE/P Al range is designed to protect aluminium, steel and galvanised steel components in a variety of end uses. It's good exterior durability lends it to be used in both internal and external applications.

The metallic effect pigment is incorporated into the product by means of a bonding process for optimum application and reproducibility.

In high traffic areas a clearcoat can be applied to prolong the aesthetics of the coating.

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

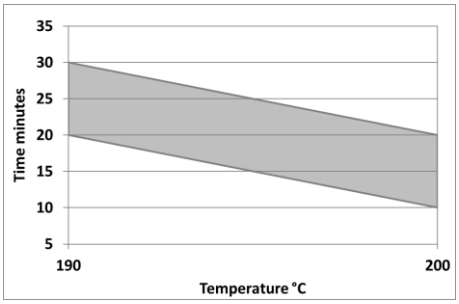
APPLICATION

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

Curing Cycle

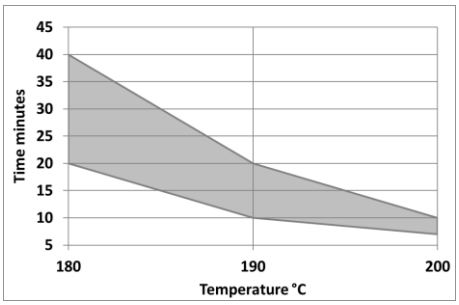
For stoving the Polyester metallic products with **gloss below 10:**

Time	Substrate temperature
10 – 20 min	200°C
20 – 30 min	190°C



For stoving the Polyester matt products **with gloss over 10**:

Time	Substrate temperature
7 – 10 min	200°C
10 – 20 min	190°C
20 – 40 min	180°C



SUBSTRATE PREPARATION

The surface treatment should be chosen according to the type of substrate and the required performance.

The surface to be coated must be free from oxidation, oil, grease or any other form of contamination.

A good quality pretreatment process is recommended for optimum performance.

Final user should select the proper pretreatment based on corrosion resistance performance.

Where required, the corrosion resistance can be enhanced using a primer system.

		Substrate			
Pretreatment		Aluminum	Steel	Galvanized Steel	Metallized Steel
Chemical	Cr-free (Zr, Ti, Oxilanes or alternatives)	✓		✓	
	Pre-anodising	✓			
	Chromate	✓		✓	
	Phospho-chromate	✓			
	Iron phosphate		✓		
	Zinc phosphate		✓	✓	
	Nano-ceramic		✓		
Mechanical	Sand blasting		✓		
	Soft blasting			✓	✓
	Sweeping			✓	✓

INVERBOND PE/P AL

BOND PE/P WITH ALUMINIUM serie 214

PERFORMANCE DATA

A pre-treated steel test panel (UNI sheet) with 60um of coating and cured 20 minutes at 180°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 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

Conical mandrel : Bend test
Maximum 10 mm
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.