

Group	321 – Hybrid (Epoxy Polyester) Low Bake Gloss
Curing	min: 160°C @ 20' to 30' max: 180°C @ 10' to 15'
Surface	High gloss smooth appearance
Brilliance	85 - 95 (60°)
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.

It is designed for interior applications.

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

Time	Substrate temperature
10-15 min	180°C
15-20 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 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 or nano-ceramic pretreatments

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

PERFORMANCE DATA

A test panel zinc phosphatised steel (UNI sheet), DFT 60 microns, stoving 25 minutes at 140°C satisfied the following requirements,

Gloss 60° :

85 - 95.0

UNI EN ISO 2813:2014

Buchholz indentation test:

more than 90

UNI EN ISO 2815

Pendulum-rocker hardness :

Persozpendulum

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

later - indentation

along the cross of 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.