



Group	223 – Polyester Low Bake Matt
Curing	min: 160°C @ 15' to 25' max: 180°C @ 10' to 12'
Surface	Smooth matt appearance
Gloss	25 - 35 @ 60°
Approvals	

PRODUCT DESCRIPTION

A matt, low bake TGIC-free thermosetting polyester powder coating featuring excellent resistance to UV radiation and outdoor weathering.

The product forms a protective and decorative film with enhanced outdoor resistance.

The product is particularly suited to exterior applications and can be used in a wide range of applications on all types of metal components.

The matt finish prevents glare when used on large surface areas.

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:

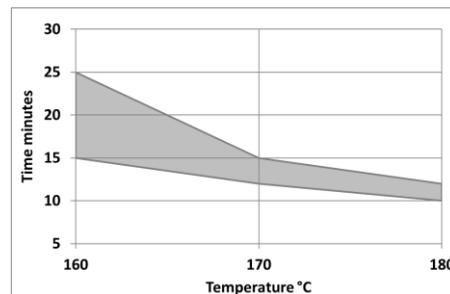
- Dry: 60 - 80 µm

APPLICATION

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

Cure Cycle

Time	Substrate temperature
10 - 12 min	180°C
12 - 15 min	170°C
15 – 25 min	160°C



CHEMICAL RESISTANCE

The chemical resistance test was carried out on zinc phosphatised steel. Immersion method for 48 hours at ambient temperature into:

CHEMICAL

Hydrogen chloride 10% intact
 Nitric acid 30% matt, but washing off
 Saturated hydrogen sulphide intact
 Hydrogen peroxide 40 volumes intact
 Ammonium hydroxide 10% intact
 Ammonium hydroxide 33% intact
 Sodium hydroxide 5% intact
 Tartaric acid 5% intact
 Citric acid 5% intact
 Lactic acid 5% intact
 Ethanol intact
 N-butanol intact
 Petroleum ether slightly softened

RESULT

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.

Pretreatment	Substrate				
	Aluminum	Steel	Galvanized Steel	Metallized Steel	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			✓	✓

PERFORMANCE DATA

A 60um coating applied to a pre-treated aluminium test panel cured 15 minutes at 160°C satisfied the following requirements:

Gloss 60° :

25 - 35

UNI EN ISO 2813:2014

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 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 20 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.