



Group	227 – Polyester Low Bake Metallic Mic. (without Aluminium)
Curing	min: 160°C @ 20' to 40' max: 190°C @ 6 to 11'
Surface	Smooth, metallic appearance
Brilliance	N/A
Approvals	

PRODUCT DESCRIPTION

A low bake, metallic finish 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.

Suitable for a wide range of industrial applications, particularly suited to heavy fabrications due to the reduced curing temperature.

To maintain the aesthetics in high traffic or aggressive environments, it is recommended to apply a clearcoat.

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:

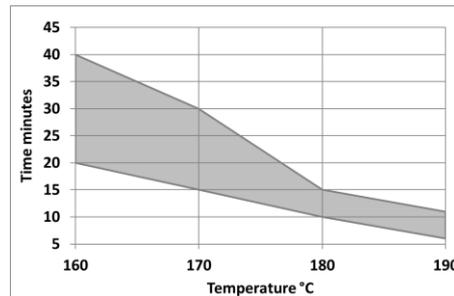
Dry: 60 - 80 µm

APPLICATION

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

Curing Cycle

Time	Substrate temperature
6 – 11 min	190°C
10 - 15 min	180°C
15 - 30 min	170°C
20 - 40 min	160°C



To maintain a consistent color/effect it is important for the coater to control the ratio of virgin to reclaim Powder. A minimum 70% virgin powder is recommended.

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				
		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 zinc phosphated steel test panel (UNI sheet) with 60 microns coating cured 20 minutes at 160°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 spray 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.