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Technical Data Sheet

Product	P9-059-9005-018 POLIEST OPACO LISCIO ONYX BLACK K62
Series: P9 Group: P9000000	**INDUSTRIAL POLYESTER THERMOSETTING POWDER COATING FOR INDUSTRIAL USE**

SPECIFIC PRODUCT PROPERTIES

CURE TEMPERATURE :	190	°C	Object temperature
CURE TIME :	20	Min	-
GLOSS AT 60 °:	0 - 4	% Units %	ISO 2813
THEORIC OUTPUT :	12.31	m²/kg	Thickness 60 µm
APPLICATION :	CORONA	-	-

	Temperature (°C)	Min time (min)	Max time (min)
Polimerization area (Object temperature)	180	30	40
	190	20	30
	200	15	22

GENERAL PROPERTIES OF THE SERIES

Fundamental Product characteristics

Powder coatings of this **Series** are based on raw materials characterized by high resistance to atmospheric agents and UV radiations.

Substrate preparation

Before the painting, the item should be adequately pre-treated in accordance with surface type, final use and required performances. The following table can be used as starting point for the pre-treatment choice.

Substrate	Indoor Use	Otdoor Use	Architecture
Aluminium	Soil removal, Chromate, Chrome-Free	Chromate, Chrome-Free	-
Steel	Soil removal, Iron Phosphate, Zinc Phosphate, Sand-blasting	Iron Phosphate, Zinc Phosphate, Sand-blasting	-
Zinc coated steel*	Acid attack, Iron Phosphate, Zinc Phosphate, Chromate	Acid attack, Zinc Phosphate, Chromate	-

*If the powder has to be applied on galvanized steel, please contact the representative.

Particle size distribution

Powder coatings of this **Series** are characterized by an average particle size included between 30 and 40 microns. According to the customer's specific needs, specific particle size distributions can be supplied.

Typical applications

Powder coatings of this **Series** can be used for painting different items for use both indoor and outdoor.

Storage stability

The self-life of this Powder coatings Series, if stored in a dry place and at temperatures below 30°C, will be at least 36 months from production date. For product older than 36 months, it is recommended to check the characteristics before use.

General properties of the series (1)	Regulation	Test result
Impact Test (2)	ASTM D2794	2,5 Nm
Adhesion (2)	ISO 2409	GT0
Deep-drawing	ISO 1520	5 mm
Bending test (2)	ISO 1519	5 mm
Salt spray (3)	ISO 9227	500 hours without film separation
Accelerated ageing	EN ISO 11341	600 hours with remaining gloss superior to 50%
Humidity test (3)	ISO 6270	500 hours without film separation or blistering
Acetone	100 double passages with cotton wad	Scarce resistance
Ethyl alcohol	100 double passages with cotton wad	Excellent resistance
Methylethylketone	100 double passages with cotton wad	Scarce resistance
Perchloroethane	100 double passages with cotton wad	Scarce resistance
Toluene	100 double passages with cotton wad	Limited resistance
Trichloroethane	100 double passages with cotton wad	Scarce resistance
Xylene	100 double passages with cotton wad	Limited resistance
Acetic acid (10%)	Film immersion for 30 days	Excellent resistance
Citric acid (10%)	Film immersion for 30 days	Excellent resistance
Hydrochloric acid (10%)	Film immersion for 30 days	Excellent resistance
Phosphoric acid (10%)	Film immersion for 30 days	Excellent resistance
Lactic acid (10%)	Film immersion for 30 days	Excellent resistance
Sulphuric acid (10%)	Film immersion for 15 days	Excellent resistance
Ammonium hydroxide (10%)	Film immersion for 30 days	Scarce resistance
Sodium hydroxide (10%)	Film immersion for 30 days	Scarce resistance

(1) All tests were performed on smooth glossy white powder without fillers sensitive to acids. For physical-chemical tests on specific codes please contact the Technical Direction of ST Powder Coatings.

(2) Tests carried out on Unichim steel panels with coating thickness of about 60 microns.

(3) Tests carried out on Bonder 26S/60/0C panels with coating thickness of about 60 microns.

Note 1
The information given in this Technical Data Sheet, based upon laboratory tests, is currently correct to the best of our knowledge. Since product application and conditions vary and are often beyond our control, we can guarantee only the product quality itself. In the light of continuous product improvement, ST Powder Coatings reserves the right to modify without notice the content of this technical sheet.

Note 2
The acronym RFG, if present in the description, indicates a product formulated with special additives that minimize the problems related to direct polymerization in gas ovens.

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