



SYSTEM: POLYESTER PE54
INDUSTRIAL
COLOUR: GOLD
APPEARANCE: SMOOTH METALLIC SATIN

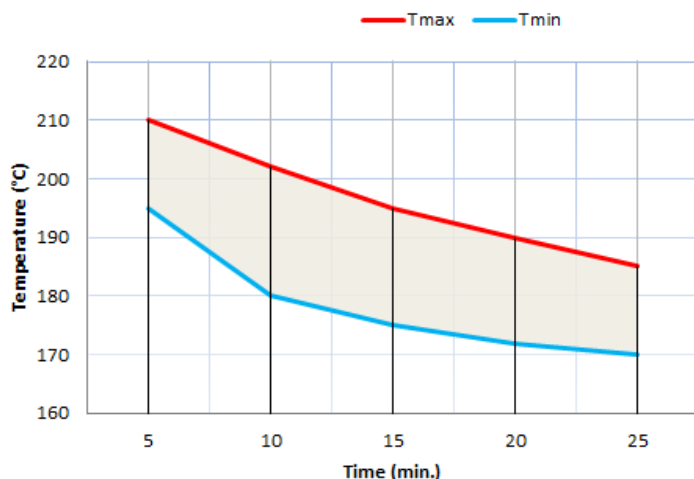


DESCRIPTION

DM312D8205 is a thermosetting polyester powder coating specifically designed for industrial purposes.



PROPERTIES OF THE POWDER



Relative density: $1.75 \pm 0.05 \text{ g/cm}^3$

Particle size:

Optimized for electrostatic application and in function of coating aspect

Storage:

Dry, max. 25 °C: at least 36 months from production date

Application / Layer thickness:

With Corona gun / 60 - 120 μm

Curing schedule (metal temperature):

10 min - 180 °C



PROPERTIES OF THE COATING

Substrate	Degreased cold-rolled steel (0.8 mm)	
Curing schedule	10 min - 180 °C	
Film Thickness	60 - 80 μm	
Adhesion	Gt = 0	(ISO 2409:2007)
Buchholz hardness	≥ 80	(ISO 2815:1973)
Clemen hardness	$\geq 3 \text{ kg}$	(ISO 1518:1992)
Erichsen test	$\geq 5 \text{ mm}$	(ISO 1520:1993)
Direct Impact	$\geq 20 \text{ kg.cm}$	(ISO 6272:1993)
Reverse Impact	$\geq 20 \text{ kg.cm}$	(ISO 6272:1993)
Cylindrical mandrel	$\leq 40 \text{ mm}$	(ISO 1519:1973)



ADDENDUM

To guarantee an optimal adhesion and corrosion protection, depending on the substrate; an optimal pre-treatment must be applied.

For more information, see our anti-corrosion performance matrix or contact Protech-Oxyplast.

DM312D8205 is not compatible with other standard polyester powder coatings, a good cleaning of the spraying equipment is needed.

For metallic coatings a minimum 90 µm is advised. The effect of metallic coatings is highly depending on the entire coating application. As a result, the effect obtained with f.ex. a corona- and tribo gun will be different. The application of a metallic powder from the same batch on different coating lines that is to be used for the same project is to be prevented as well. All RAL metallic colours (f.ex. RAL9006, RAL5025, ...) are approximate to the RAL standard and may differ in colour and effect from competitor products. Some metallic coatings are semi-transparent or not hiding to obtain their specific metallic effect. The final coating effect is depending on the applied coating thickness and the colour of the substrate or basecoat. Depending on the coating effect a transparent topcoat might be required to protect the metallic pigments from oxidation in case of contact with moisture or from damage and colour change due to friction

This information is given in good faith. A warranty, expressed or implied, cannot be supplied as results may vary depending on application conditions.