



115j

P-1131

Technical data sheet

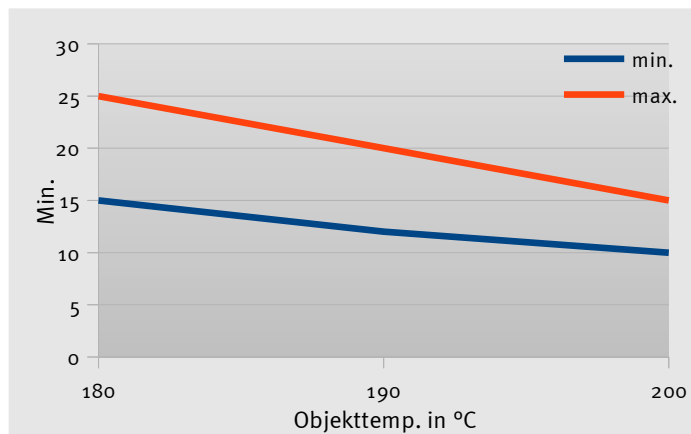
Article No.: **11993**
 Sheet No.: 1735 E
 Version: 10

POLYFLEX® PES-135

Smooth coating Tribo / Corona Silk gloss 35

Facades powder for outdoor use on polyester base with exceptional resistance to light and very good weather resistance, very good flow and covering power. Stabilized against over burning and discoloration in direct gas-fired curing ovens.

Applications	Metal facades, Aluminum profiles, sun protection equipment, windows , doors, gates and frames, etc.
Colours	Practically all colours with very few limitations
Surface	Smooth
Gloss	Visually silk gloss, Gloss level 30-40 (60°)
Power properties	<p>Particle size distribution smaller 29 µm: 40 – 47 % <small>(HELOS H1708)</small> smaller 122 µm: 99 – 100%</p> <p>Density 1.4 – 1.8 g/cm³ different depending on the colour, can be specified per colour</p>
Material consumption	g/m ² = Density (g/cm ³) x film thickness (µm)
Coating thickness	<p>Recommended 70 – 90 µm depending on the colour</p> <p>Maximum 120 µm</p>
Application	The application can be made with the usual powder coating systems, Tribo or Corona. To avoid any surface disturbances, we recommend not to mix it with any other powder paint.
Packaging	<ul style="list-style-type: none"> - 20/25 kg cardboard - 500 kg Octobox - 450/500 kg Big Bag Other packaging variations are available on request
Baking diagram	Curing time recommendation : 15 min at 180 °C object temperature



Baking operation
 200°C 10 min. hold time
 190°C 12 min. hold time
 180°C 15 min. hold time

Underground

Different metals, however mainly on pretreated aluminum or galvanized powder coated or anti-corrosion dip-coated steel. The support to be coated has to be free of oil, grease and oxidation products. Under exposure to corrosion we recommend the following pre-treatments:

Aluminium Chromating, chrome free pretreatment or thin layer of anodizing coat
Steel/Iron Galvanization with a subsequent chromating

Physical properties

tested on:

Aluminium plate 0,8 mm AlMg1
H14 chromated

Film thickness
70 – 90 µm

Cross cut test GT 0
(DIN ISO 2409)

Mandrel bending test: < 5 mm
(DIN ISO 1519)

Impact resistance front > 5 Nm (~44 inchpound)
ASTM D 2794 reverse > 2,5 Nm (~22 inchpound)

Erichsen cupping > 5 mm
(DIN ISO 1520)

Buchholz hardness > 90
(DIN ISO 2815)

Resistances

tested on:

Aluminium plate 0,8 mm AlMg1
H14 chromated

Condensation water test 1000 h no bubble building
DIN ISO 6270 Infiltration on the scratch track under 1 mm

Salt spray test 1000 h no bubble building
DIN ISO 9227 Infiltration on the scratch track under 1 mm

Material approval

GSB Standard 115j

Qualicoat Class 1 P-1131

Post treatment of coated parts

To print, to paste, to label, to laminating of film and any other post-treatment, some preliminary testing is recommended. For packaging only use appropriate plasticizers-free materials. Perspiration water should be avoided.

Repairs

For repairs (conveyors hangers touch ups) the repair kit, Art. 12155 is available.

Storage

Storage instruction: In the original containers, store in a cool and dry environment by max.25° C. No direct sun exposure.

Shelf life 18 months from the date of production under the mentioned conditions

Safety recommendations

Under explosion limit 40 g/m³

Further information are to find in the safety data sheet and the CEPE booklet „Safe powder coating“ and „Results of the experimental toxicology study on thermosetting powder coatings“.

Comments:

The information on this technical data sheet about the properties and application of the product in question are made on hand of our knowledge, development and practical experience. Because of the multiple possible application, it is impossible for us to present them all in detail. Our technical consultants are at your disposal for any question you might have. Further more, our general sales and delivery conditions apply. This technical data sheet is revised periodically. If necessary, our sales department will confirm the validity of this document



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