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|------------|---|
| Group | 511 – Polyurethane Gloss |
| Curing | min: 190°C @ 14' to 20' max: 200°C @ 10' to 15' |
| Surface | Smooth |
| Brilliance | 85 - 95 (60°) |
| Approvals | |

PRODUCT DESCRIPTION

This Polyurethane based thermosetting powder coating forms a decorative film with enhanced outdoor resistance. The product forms a level hard film with good resistance to mechanical damage, and enhanced chemical resistance to detergents, fuels and oils.

The excellent levelling property of this product imparts a smooth, highly appealing finish to coated articles.

Can be used on all common metallic substrates, steel, aluminium and galvanised steel, and is suitable for exterior applications.

Storage Life:

Store at temperatures lower than 30°C. Storage life in original package: 18 months.

CHARACTERISTICS

Spec. Gravity (kg/l): 1,25 – 1,80

DFT (micron): 60 - 80

Theoretical Coverage @60um:
11.5m²/kg

Recommended film thickness:
Dry: 60 -80 microns

APPLICATION

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

Curing Cycle

| Time | Substrate temperature |
|-------------|-----------------------|
| 10 - 15 min | 200°C |
| 12 - 18 min | 195°C |
| 14 - 20 min | 190°C |

SUBSTRATE PREPARATION

The surface to be coated must be free from oil, grease and flash rust. A good quality pre-treatment process is recommended for optimum performance.

Aluminum: chromate, phospho-chromate conversion (DIN 50939) or other Cr-free pretreatment

Steel: sand blasting or/and iron or zinc phosphatizing

Galvanized steel: chromate (DIN 50939), phosphate or Cr-free pretreatment

CHEMICAL RESISTANCE

The chemical resistance test was carried out on zinc phosphatised steel.

By immersing for 48 hours at ambient temperature into:

hydrogen chloride 10 % - film intact

nitric acid 30 % matt, but washing off

saturated hydrogen sulphide - film intact

hydrogen peroxide 40 volumes - film intact

ammonium hydroxide 10 % - film intact

ammonium hydroxide 33 % - film intact

sodium hydroxide 5 % - film intact

tartaric acid 5 % - film intact

citric acid 5 % - film intact

lactic acid 5 % - film intact

ethanol - film intact

N-butanol - film intact

petroleum ether - slightly softened

PERFORMANCE DATA

A pre-treated steel test panel (UNI sheet), cured for 10 minutes at 200°C with DFT 60 microns, satisfied the following requirements,

Gloss 60° :

85.0 - 95.0

UNI EN ISO 2813:2014

Buchholz indentation test:

more than 90

UNI EN ISO 2815

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

Crosscut adhesion (2mm) (GT):

Class 0

UNI EN ISO 2409

Salt fog test :

1000 hours later – indentation along the cross of maximum 3 – 6 mm

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.