



TECHNICAL DATA SHEET TGIC-FREE OUTDOOR POLYESTER POWDER

Licence no. 0683

Thermosetting powder paint with base of saturated polyester resins cross-linked with B-hydroxyalkylamide, free from inorganic pigments with heavy metals, for indoor and outdoor applications. For the tests, reference is made to the "TECHNICAL DIRECTIVES OF THE "QUALICOAT" QUALITY MARK OF PAINTED ALUMINUM (WITH LIQUID OR POWDERED PRODUCTS) USED IN ARCHITECTURE" 16° 2020 Edition

PHYSICAL PROPERTIES

Aspect	wrinkled
Brightness 60°	nd
Specific weight gr/ltr	1300-1700 (depending on the colour)
Grain size µm	< 100
Standard packaging kg	25
Application	corona-tribo (specify in order, some metallics need verification before application)
Storage	In a dry place and at a temperature lower than 35° C = 24 months *
* Any contact, even for a short time, with humidity determines the loss of any form of guarantee and suitability for use	

APPLICATION YIELD AND THICKNESS

Minimum application thickness 60 µm (as an average value of five measurements with no value < 48 µm).

Theoretical average yield = $1000 / (\text{specific weight} \times \text{thickness})$

Theoretical yield can be affected by: losses in the plant, inadequate plant parameter adjustments, surface of the support, shape of the support.

MECHANICAL PROPERTIES

Erichsen drawing	EN ISO 1520	8 mm	no defects
Bending with mandrel	EN ISO 1519	φ 3 mm	no defects
Impact test	ASTM D2794	> 2.5 mm	no defects
Buchholz durometer	EN ISO 2815	90-110	
Test of adherence	EN ISO 2409		Gt0



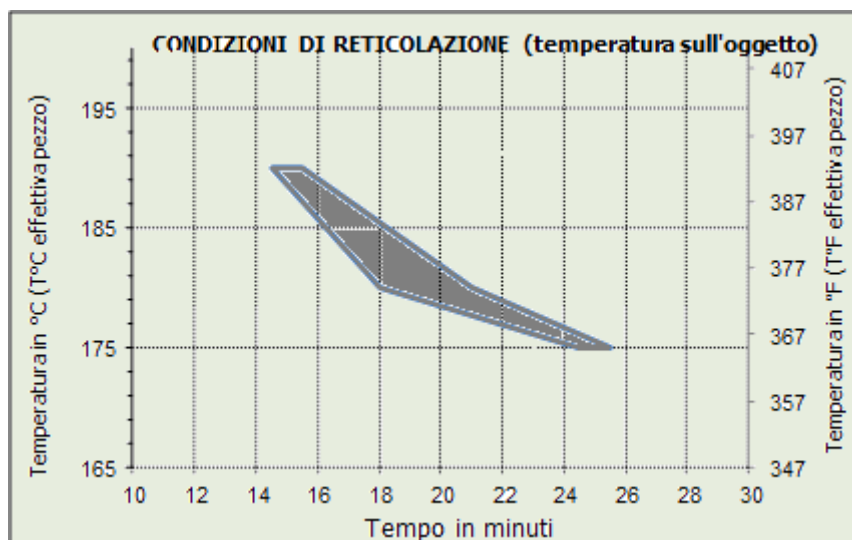
SUBSTRATE PREPARATION

Since these are products with the main use intended for outdoors, good cleaning of the support and adequate chemical conversion of the same are recommended. For galvanized aluminum and sheet metal supports, it is advisable to proceed with chroming. In the case of iron or steel, phosphating will have to be carried out, preferably with zinc salts.

For the best protection, do not paint at thicknesses less than 60 µm

CROSS-LINKING CONDITIONS (actual workpiece temperatures)

v: 175°C x 25' 180°C x 20' 190°C x 15'



CHEMICAL RESISTANCE

Good resistance to most acids, alkalis and oils at a temperature of 25° C.

RESISTANCE TO CORROSION AND OUTDOOR EXPOSURE

Humidistat test	DIN 50017	after 1000 hours	unchanged appearance
Prova Kesternich	EN ISO 3231	after 24 cycles	no change
Prova nebbia salina	EN ISO 9227	after 1000 hours	unchanged appearance