



## P-PES IND SERIES

# POLYESTER FOR INDUSTRIAL QUALITY

- outstanding mechanical properties
- good weather resistance
- excellent versatility

The P-Pes are based on solid carboxyl polyester resins with suitable TGIC-free hardeners, additives and pigments with good light and weather resistances. Very versatile in uses, they are employed where a superior architectural quality is not needed.

## APPLICATION

Garden furniture, window iron frames, lighting articles, external aircondition, shelving, iron edge protection, industrial goods, etc.

## PROPERTIES

<b>Colour shade:</b>	all RAL, (on request NCS, Pantone or other)
<b>Finish:</b>	smooth, fine texture, rough texture, wrinkle, snake-effect and special effects in Dryblend and Bond version
<b>Gloss:</b>	from matt to glossy
<b>Density:</b>	from 1.25 to 1.80 g/cm <sup>3</sup> , depending on colour shade and quality
<b>Yield:</b>	depends on the applied film thickness, c.f. formula
<b>Storage life:</b>	at least 36 Months at temperatures lower than 30 °C

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## COATING PROPERTIES

<b>Adhesion test:</b>	Gt 0 DIN 53151
<b>Impact test:</b>	>25 cm/Kg ASTM D 2794
<b>Erichsen cupping test:</b>	>5 mm ISO 1520
<b>Mandrel bend test:</b>	5 mm ISO 1519
<b>Pencil hardness test:</b>	H-2H ASTM D 3363
<b>Salt spray test:</b>	1,000 hours 0.5 mm ASTM B 117-94
<b>Humidity resistance:</b>	1,000 hours unaffected ASTM 9870
<b>Q.U.V-B test:</b>	250/300 hours -50% gloss loss ISO 11507
<b>Chemical resistance:</b>	good regarding lyes and acids diluted and at room temp.

## PROCESSING

### Surface pretreatment:

Before coating, metal surfaces must be clean and free from greases, oils, rust and any other material that might cause adhesion loss of the product to surfaces.

Aluminium: chromatising or Cr-free cycles

Galvanised steel: chromatising

Steel: sand blasting or/and iron or zinc phosphatising

### Application:

all common processes (Tribo, Corona)

### Thickness:

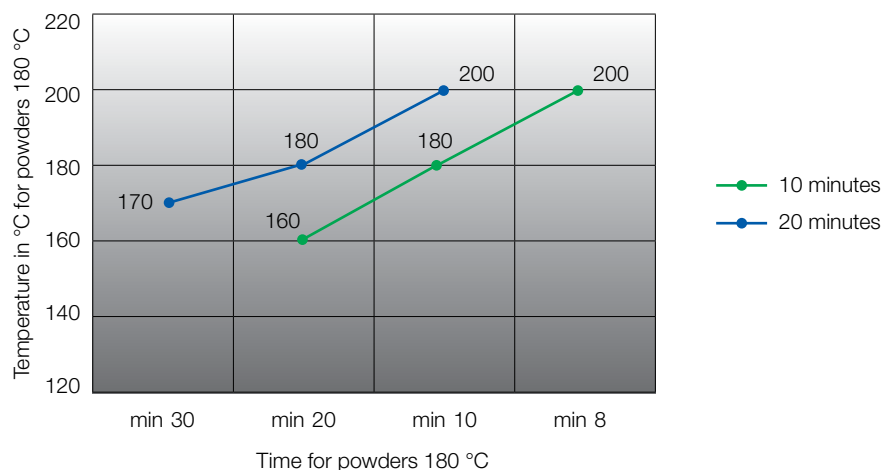
From 60 µm to 120 µm, depending on colour shade and finish type

### Curing conditions:

10/20 minutes at 180 °C object temperature (for wrinkle and snake effects are required temp. higher than std)

## CURING CONDITIONS

### POLYESTER FOR INDUSTRIAL QUALITY – Curing conditions



Light colour shades can cause a shift. The maximum temperature is around 210 °C. All data refer to object temperature.

## THEORETICAL SPREADING RATE

Multiply the average specific gravity by the requested thickness in microns. The obtained value is the consumption in grams per square meter. Formula: Specific gravity x thickness = yield (g/m<sup>2</sup>)

These data are based on empirical values for the completeness of which we do not assume any guarantee. Since we cannot influence in any way the processing of the product, the purchaser is responsible for ensuring that the product is suitable for the intended purpose before using the product. Any change in the processing procedure, environmental conditions, or the non-observance of instructions can influence the result negatively. Status 07/2015.