

## Series P.14MED polyester Colore®

The Information provided in this data sheet are generic for Colore® P.14MED series. For further detail concerning specific products belonging to P.14MED series, please contact us.

### Description

**Colore® P.14MED** thermosetting powder coating formulated with polyester resin and light-resisting pigments. It has a medium reactivity, is essential from heavy metals and TGIC, Film obtained after product's polymerization owns very good mechanical properties, excellent flow, more than fair characteristics of resistance to chemical agents (detergents, propellants, lubricants ...).

### Area of applicability

The products formulated in the P.14MED Colore® series can be used for the coating of products intended for external use. They are widely used in the naval sector both for internal and external furnishings and for fixtures and architectural elements intended for installation on ships etc.

### Color / Aspect

Please check stock list for eventual availability. Minimum order for custom production, starting from 25 kgs.

Products developed in P.14MED could be:

- Smooth – matt 10 – 30 gloss\*
- Smooth – metallic/multicolor

*Gloss level taken at 60° angle of incidence*

### Legislation

Nr. **MED B MED036820CS**

This powder coating respects European Directives "Restriction of the use of certain hazardous substances" 2002/95/CE and 2011/65/EU (RoHS).



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### Storage stability and packaging

if kept in dry environment, in sun shelter and at temperature of maximum less than 30° powder coating stays stable for 24 months. In presence of different conditions then the ones written above, it is possible to accuse inconveniences such as lumps and important decreasing in powder coating fluency.

Goods are supplied in 25 or 20 kgs plastic bags and cardboard boxes.



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### Physical features

- Specific gravity: 1.20-1.60 g/cm<sup>3</sup> according to the product
- Theoretical spreading rate: m<sup>2</sup>/kg = 1000/specific weight for thickness
- Particle size at 63 µ: range 20-26
- Minimum resin content: 60,00%

### Features P.14MED series after polymerization

	Test conditions		
Steel panel	0,8 mm		
Surface pretreatment	Zinc salt phosphating		
Film thickness	According to the effect		
Curing conditions	180°x15' (T° object)		
TESTS	SPECIFICATIONS	UNIT OF MESAUREMENT	RESULTS
Gloss (60°)	UNI EN ISO 2813	gloss	10-30
Thickness	UNI EN ISO 2360	µ	range 60-90
Color gap (Δe) compared to initial standard		CIE Lab	according to Qualicoat specifications
Buchholz hardness	UNI EN ISO 2815		≥ 80 according to gloss level
Erichsen cupping test	UNI EN ISO 1520	mm	<5 mm no cracks
Impact test (concave)	UNI EN ISO 6272-2	cm/kg	25 cm/kg no cracks
Impact test (convex)	UNI EN ISO 6272-2	cm/kg	25 cm/kg no cracks
Bend test (Cylindere mandrel)	UNI EN ISO 6860	mm	5 mm No cracks
Cross-cut adhesion test	UNI EN ISO 2409	GT	0: no detachment
Salt spray test (1000 hrs)	MTD-03	mm	according to Qualicoat specifications
Solar box exposure (1000 hrs)	UNI EN ISO 11341	gloss	≤50% drop in gloss

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### Surface preparation

Surface must be carefully cleaned and degreased, according to the corrosion protection level requested. On steel, to get better results and to improve corrosion resistance features, it is possible and suggested, the use in combination with our Colore® epoxy primers.

### Application

- Spraying can be done with automatic or manual Corona.
- Never mix powder from different production batches.
- The use of the same production batch is recommended for painting parts that will be subsequently assembled.
- The product must be applied on metal substrates with a thickness of  $\geq 0,56$  mm. The thickness of the applied film must be between 60-90  $\mu\text{m}$ .

### Polymerization conditions

*(object temperature)*

- 180°x15'
- 190°x12'

### Safety

Please check safety data sheet of specific product (MSDS)

**Disclaimer:** all provided and given information are correct and the result of our best experiences and knowledges, but they do not comport any responsibilities or warranty in case of non-proper use. In accordance with COLORE® policy of products development, information given in this technical data sheet are susceptible, without notice, of changing in respect of company view product's continuous improvement.

