

## Series P.31 Postforming polyester Colore®

The information provided in this data sheet are generic for Colore® P.31 series. For further detail concerning specific products belonging to P.31 series, please contact us.

### Description

**Colore® P.31** thermosetting powder coating formulated with polyester resin and light-resisting pigments. Film obtained after product's polymerization respects T-bend test according to NF EN 13523/7-2014

### Area of applicability

**P.31** series, due to its chemical nature, specifically designed for painting sheet metal and substrates which are then subjected to bending (post-forming).

Attention: in order to get best possible result is strictly necessary to follow indications provided by this technical data sheet

### Color / Aspect

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

Products developed in **P.31** could be:

- Smooth – glossy 71-95 gloss\*(T0)
- Smooth – semi glossy 51-70 gloss\*(T0)
- Smooth – semimatt 31-50 gloss\*(T1)

N.B.: even in metallic finishing (please contact our technical department for more informations.)

*Gloss level taken at 60° angle of incidence*

### Legislation

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 12 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: 1.55-1.70 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

### Features P.31 series after polymerization

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	Test conditions		
Steel panel	0,8 mm		
Surface pretreatment	Zinc salt phosphating		
Film thickness	Range 80+/-10μ		
Curing conditions	190°x20'/200°X15' (T° object)		
TESTS	SPECIFICATIONS	UNIT OF MESAUREMENT	RESULTS
Gloss (60°)	UNI EN ISO 2813	gloss	Up to the effect
Thickness	UNI EN ISO 2360	μ	range 70-90
Color gap (Δe) compared to initial standard		CIEILab	according to Qualicoat specifications
Buchholz hardness	UNI EN ISO 2815		≥ 80 according to gloss level
Erichsen cupping test	UNI EN ISO 1520	mm	<4 mm no cracks
T-BEND TEST	NF EN 13523/7-2014	T0-T1-T2	T0-T1 according to gloss level
Impact test (concave)	UNI EN ISO 6272-2	cm/kg	40-50 cm/kg no cracks
Impact test (convex)	UNI EN ISO 6272-2	cm/kg	40-50 cm/kg no cracks
Bend test (Cylindered mandrel)	UNI EN ISO 6860	mm	7 mm No cracks
Cross-cut adhesion test	UNI EN ISO 2409	GT	0: no detachment

Issued on 13.10.2022 Revision nr.2  
This technical data sheet replaces all previous versions



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### Surface preparation

Surface must be carefully cleaned and degreased, if not postforming ability will be compromised

### Application

- Spraying can be done with automatic or manual Corona or Tribo electric system. With Tribo electric system, compatibility with any metallic powder coating must be tested in plant, before its industrial use.
- Never mix powder from different production batches.
- The use of the same production batch is recommended on painting details that will be subsequently assembled.

### Polymerization conditions

*(object temperature)*

- 190°x20'
- 200°x15'

### 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.

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**Colore S.r.l. | Via della Meccanica 16/b, 36016 Thiene (VI) Italia  
T+39 0445 380 800 - info@colore.im – www.colore.im**

