

P.18 series polyester Colore®

The Information provided in this data sheet are generic for Colore® P.18 series. For further detail concerning specific products belonging to P.18 series, please contact us.

Description

Colore® P.18 thermosetting powder coating formulated with polyester resin, specifically developed for polymerizing at lower curing conditions, and light-resisting pigments. Film obtained after product's polymerization owns good resistance features concerning both atmospheric agents and chemical agents (detergents, propellants, lubricants ...).

Area of applicability

P.18 series, due to its chemical nature, is suggested for painting and protecting metallic substrates for outdoor use. Wide application field could be found in building sector, industrial automotive and standard accessories for common outdoor using.

Color / Aspect

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

Products developed in P.18 could be:

- Smooth – glossy 71-95 gloss*
- Smooth – semi glossy 51-70 gloss*
- Smooth – metallic
- Fine structure – matt
- Fine structure – semimatt
- Fine structure – metallic matt and semimatt
- Rough structure – glossy 71-95 gloss*
- Rough structure – semi glossy
- Rough structure – metallic

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).

Storage stability and packaging

if kept in dry environment, in sun shelter and at temperature of maximum less than 30° powder coating stay 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: | 1.20-1.70 g/cm ³ according to the product |
| • Theoretical spreading rate: | m ² /kg = 1000/specific weight for thickness |
| • Particle size at 63 µ: | range 18-32 |

| Features P.18 series after polymerization | | | |
|--|-------------------------|---------------------|---|
| | | Test conditions | |
| Steel panel | 0,8 mm | | |
| Surface pretreatment | Zinc salt phosphating | | |
| Film thickness | According to the effect | | |
| Curing conditions | 160°x20' (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 70-120 |
| Colour gap (Δe) compared to initial standard | | CIE1Lab | according to Qualicoat specifications |
| Buchholz hardness | UNI EN ISO 2815 | | No cracks |
| Erichsen cupping test | UNI EN ISO 1520 | mm | <4 mm no cracks |
| Impact test (concave) | UNI EN ISO 6272-2 | cm/kg | 40-60 cm/kg no cracks |
| Impact test (convex) | UNI EN ISO 6272-2 | cm/kg | 4.-60 cm/kg no cracks |
| Bend test (Cylinderead mandrel) | UNI EN ISO 6860 | mm | 8 mm No cracks |
| Cross-cut adhesion test | UNI EN ISO 2409 | GT | 0: no detachment |
| Salt spray test (1000 hrs) | MTD-03 | mm | corrosion length max 4 mm corrosion area max 16mm ² /10cm |
| Solar box exposure: 400 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 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.

Polymerization conditions

(object temperature)

- 170x15'
- 160°x20'

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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