

ENVIROCOAT POWDERS PVT. LTD.

HO : Plot No. 288, Sector 7, MIDC, Bhosari, Pune - 411026

WORKS : C-99, STICE, Musalgaon, Sinner, Nashik - 422112

CIN No. : U74994PN2018PTC175918

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PRODUCT DATA SHEET

PRODUCT NAME : PURE POLYESTER POWDER PAINT

Product Description	Thermo setting type of polyester resin based products mainly formulated for outdoor application bearing very good overbanking resistance. Items that demand good matt effect along with durability with matt finish can coated with this powder. Specially formulated to meet stringent specification laid down by Automobile Industry. Single coat application on properly pre-treated components will provide adequate protective values.
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Products Properties:	Chemical Nature	Pure Polyester
	Flow Finish :	Smooth, Uniform, Texture, structure, metallic
	Particle sizedistribution	More than 80 μ → 0 – 5 %
		More than 63 μ → 8 – 10 %
		Less than 32 μ → 40 – 55 %
	Specific Gravity	1.60 $\pm$ 0.20
	Storage	Keep in dry cool condition@ 25°C
	Shelf Life	6 months from the date of manufacturing @25°C & 50% Relative Humidity.

Technical Data

Mechanical Test		STANDARD	OBSERVATION
	Shade	Visual	Close match to STD
		Colour Computer	Delta E $\leq$ 1.0
	Gloss @ 60 °	ASTM D 523	Max. 50 - 60
	Film Thickness	ASTM 1186	50 – 60 μ
	Cross Cut Adhesion	ASTM 3359	GT = 0/100
	Impact Resistance	ASTM D 2794	80 Kg cm Direct
			80 Kg cm Reverse
	Flexibility	ASTM D522	6.25 mm

Chemical Tests	Salt Spray Resistance	ASTM B117	800 hrs
	QUV (500 Hrs) B 313 Lamp	ASTM B152	Retains 80% of Originalgloss after polishing with 3M wax solution
	Humidity Resistance	IS 101	800 Hrs.

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Pre-treatment	Mild steel or CRCA surfaces must be cleaned and free from oil grease dust followed by Iron or Zinc phosphate while Aluminum surface will require a suitable chromate conversion, chrome free pretreatment or flash anodizing before powder applications. Galvanized steel may require zinc or chromate conversion or sweep blasting.
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Application	Substrate	CRC Panels
	Application System	Electrostatic Spray Gun
	Voltage	60 – 90 KV
	Curing Schedule	200°C / 10-15 Mins EMT

PP Matt Products are to be applied only by Corona charged Guns. However for application through Tribo Guns & RoHS complied powders can also be made available on demand.

We recommend

- Voltage around 60 – 90 KV based on system
- Distance Gun – part will be 20 to 25 cm
- Slow first passes
- Flat jet spray nozzles or as demanded by the shape & size of the component.
- Gas or Diesel fired ovens must be fitted with Heat Exchanger having uniformity of insidetemperature.
- Direct feeding from the powder box is not recommended.
- Recycling up to 20% of reclaimed powder.

Disclaimer: The given data here are based on the best of our knowledge & subsequent data we receive from our customers. In view of many factors that may affect processors/applicators present system, these data do not relieve processors / applicators from carrying out their own investigations and teststo find out suitability for specific purposes. Neither do these data imply any guarantee nor the suitability of the products for a specific purpose until the same is being given in writing by us. These are general information only and may change without prior intimation.

For ENVIROCOAT POWDERS PVT LIMITED

R &D POWDER COATING

N.B. Computer generated file, No need to signature.