

Powder varnish P-PL-1322

Use For getting protective and decorative coatings in a two-layer system (powder coatings plus varnish) on metal surfaces.

Composition Homogeneous mixture of solid carboxylated polyester resins and hardener and special-purpose additives.

Application area For coloring various metal products operated indoors and outdoors.

Pre-treatment Surface should be carried out depending on metal and subsequent operating conditions. The surfaces should not have burrs, burn-through, a metal discontinuities as cracks, etc. The radius of curvature of the sharp edges should be not less than 0.3 mm. Preparation before paint application should be done in accordance with GOST 9.402. Degreasing degree - 1, the surface cleaning degree from remove scale and rust - 2. It is allowed to prepare surfaces in ways are not provided in GOST 9.402. The pre-treatment process should include adhesion and a sufficient degree of purification from substances preventing staining and accelerate corrosion processes. The chemical pretreatment of the metal is recommended for the best protective properties/

Application method electrostatic or tribostatic

Curing 15 min/ 180 °C – object temperature
10 min/ 200 °C - object temperature

Properties	Powder form	Fine powder without lumps or impurities.
	Color	Colorless
Surface properties	Not solid contents weight	Not more than 1%
	Grading	- residue on sieve 0100,%, not more 5.0
	Appearance	Same texture surface without mechanical impurities.
Mechanical properties	Coating impact strength, cm, not less than	50*
	- Elasticity of the coating upon flexuring , mm, not more than	3*
	- Hardness of the coating upon tension , mm, not more than	5*
	- Adhesion of the coating, points, not more than	1

* - the recommended thickness - 60 - 80 mkm

Thickness Recommended – 60 – 80 mkm.

Theoretical Consumption 80 – 120 g/m² (by the film thickness 60-80 mkm). Consumption can fluctuate depending on the equipment, surface quality, personal qualification etc.

Transportation and storage: Powder coatings and varnishes are transported in closed packing under the temperature from -40°C to +27°C. Shelf life — 18 month from the production date. Powder coatings store in a closed container at a temperature not more than 27 °C and at a relative humidity of 75%, at least 1 m from heating. The warranty period is 18 months from the manufacture date. Closed box of powder coatings must undergo acclimatization before opening within 48 hours in the operating room.

Accident prevention Application has to be done indoor with installed ventilation providing clean air in the working area. Personal should have special equipment, clothes and personal protection organs equipment. Powder coatings can be explosive. During the work do not admit source of ignition, sparking, overheating of the powder, cloud formation and powder dust accumulation. Do not smoke.

The product is intended only for the professional use by the consumer with sufficient knowledge in powder coatings application and labor safety. This technical data sheet is not comprehensive and is based on laboratory research and our experience. Product usage and results are determined in a greater degree by the consumer conditions, as well as compliance with the manufacturer's recommendations. In the absence of control over all conditions observance from our side, we are not responsible for the end results, but we are responsible for the material quality according to the quality system acting in MAV Ltd.