

Powder coating P-PL-2323

Use	For obtaining protective and decorative coatings with varying degree of gloss and texture on metal products of various industries, as well as customer goods.
Composition	Homogeneous mixture of carboxylated polyester resins and hard epoxy resins with pigments, fillers and special-purpose additives.
Application area	For coloring various metal products relating metal products of various industries, as well as customer goods 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.	
Not solid contents weight	Not more than 1%	
Grading	- residue on sieve 0100,%, not more	5.0
Density	1.2-1.9 g/cm ³ depending from the color	
Color	Should match the control color of MAV Ltd., the colors of RAL catalog, samples-references agreed with the customer.	
Appearance	Same texture surface without mechanical impurities.	
Mechanical properties	- Hardness of the coating upon tension , mm, not more than	5*
	- Adhesion of the coating, points, not more than	1

Surface properties

* - the recommended thickness 80 mkm.

Thickness

Depending from the type of texture– 80 – 200 mkm

Theoretical Consumption

200 – 220 g/m² (by the film thickness 150 mkm). Consumption can fluctuate depending on the equipment, surface quality, personal qualification etc.

Transportation and storage:

Powder coatings 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.