



PH-PES ECO-IND SERIES

POLYESTER FOR ECONOMIC QUALITY

- outstanding mechanical properties
- perfect price-performance ratio
- good corrosion resistance

APPLICATION

Garden articles, mowers, camping articles, extinguishers, clothes horses and any metal object where high sun ray and weather resistances are not required.

The PH-Pes ECO-IND series are based on polyester with suitable TGIC-free hardeners, additives and pigments and stand for outstanding performance (especially weather resistance) at fair prices. They are versatile in use and meet many requirements for intermediate applications between Hybrid and Polyester with high performance.

PROPERTIES

Colour shade:	all RAL, (on request NCS, Pantone or other)
Finish:	smooth, fine texture, rough texture and special effects
Gloss:	from semimatt to glossy
Density:	from 1.25 to 1.80 g/cm ³ , depending on colour shade and quality
Yield:	depends on the applied film thickness, c.f. formula
Storage life:	average of 36 Months at temperatures lower than 30°C

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COATING PROPERTIES

Adhesion test:	Gt 0 DIN 53151
Impact test:	>25 cm/Kg ASTM D 2794
Erichsen cupping test:	>5 mm ISO 1520
Mandrel bend test:	5 mm ISO 1519
Pencil hardness test:	H-2H ASTM D 3363
Salt spray test:	1,000 hours 0.5 mm ASTM B 117-94
Humidity resistance:	1,000 hours unaffected ASTM 9870
Q.U.V-B test:	200/250 hours -50% gloss loss ISO 11507
Chemical resistance:	good regarding lyes and acids diluted and at room temp.

PROCESSING

Surface pretreatment:

Before coating, metal surfaces must be clean and free from greases, oils, rust and any other material that might cause adhesion loss of the product to surfaces.

Aluminium: chromatising or Cr-free cycles

Galvanised steel: chromatising

Steel: sand blasting or/and iron or zinc phosphatising

Application:

all common processes (Tribo, Corona)

Thickness:

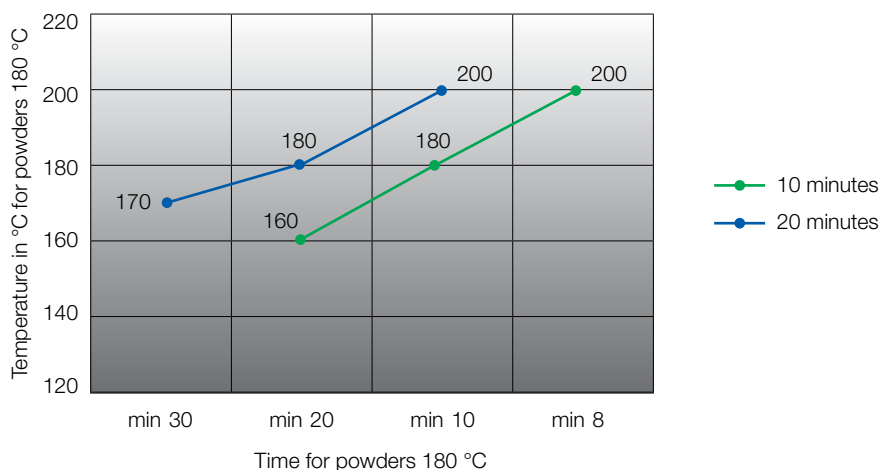
From 60 µm to 120 µm, depending on colour shade and finish type

Curing conditions:

10/20 minutes at 180 °C object temperature

CURING CONDITIONS

POLYESTER FOR ECONOMIC QUALITY – Curing conditions



Light colour shades can cause a shift. The maximum temperature is around 210 °C. All data refer to object temperature.

THEORETICAL SPREADING RATE

Multiply the average specific gravity by the requested thickness in microns. The obtained value is the consumption in grams per square meter. Formula: Specific gravity x thickness = yield (g/m²)

These data are based on empirical values for the completeness of which we do not assume any guarantee. Since we cannot influence in any way the processing of the product, the purchaser is responsible for ensuring that the product is suitable for the intended purpose before using the product. Any change in the processing procedure, environmental conditions, or the non-observance of instructions can influence the result negatively. Status 07/2015.